OPERATING GUIDELINES FOR SOLID TUMBLE BLENDERS

CHARGING THE BLENDER

- Insure the safety gate is closed and secure.
- Position vessel with the access cover in the up position by utilizing the jog button on the control panel and remove Access cover.
- Open the safety gate and charge vessel to the proper fill level.
- Replace access cover making sure all cover clamps are in place and secure.

BLENDING

- Insure the safety gate is closed and secure.
- Set blender timer per SOP.
- Before starting blender, check rotating area is clear of any obstructions.
- Depress start button.

DISCHARGING THE BLENDER

- When blend cycle ends, utilize the jog button to position vessel discharging.
- Position drum under butterfly valve and empty blender.

INSTRUCTIONS TO PROGRAM RED LION TIMER

- Depress “P1”.
- Use the appropriate buttons under each digit to set the time.
- Depress the “E” button to enter the selected time.
- Depress the “R” button to reset the timer to your selection.

TO CHANGE THE TIME SETTING, REPEAT THE ABOVE STEPS.

INSTALLATION CHECK SHEET

ALIGNING AND LEVELING

UNIT CLEAR OF ALL OBSTRUCTIONS (TURNING RADIUS)	Yes ⬭	No ⬭	N/A ⬭
VESSEL ALIGNED, LEVELED, AND ANCHORED PER INSTALLATION MANUAL	Yes ⬭	No ⬭	N/A ⬭
VACUUM SYSTEM LEVELED AND ANCHORED	Yes ⬭	No ⬭	N/A ⬭
HEATING SYSTEM LEVELED AND ANCHORED	Yes ⬭	No ⬭	N/A ⬭
SOLVENT RECOVERY SYSTEM LEVELED AND ANCHORED	Yes ⬭	No ⬭	N/A ⬭
CONTROL PANEL AND LOCAL CONTROL STATIONS MOUNTED	Yes ⬭	No ⬭	N/A ⬭
ALL SAFETY GATES IN PLACE AND WIRED	Yes ⬭	No ⬭	N/A ⬭

ELECTRICAL CONNECTIONS

MAIN ELECTRIC SOURCE CONNECTED TO MAIN CONTROL PANEL	Yes ⬭	No ⬭	N/A ⬭
MAIN POWER CUTOFF MOUNTED (LOCAL)	Yes ⬭	No ⬭	N/A ⬭
MAIN ELECTRIC SOURCE CONNECTED TO HEATING SYSTEM CONTROL PANEL	Yes ⬭	No ⬭	N/A ⬭
VACUUM PUMP WIRED TO THE MAIN CONTROL PANEL, OR TO VACUUM PUMP CONTROL PANEL	Yes ⬭	No ⬭	N/A ⬭
COOLING SYSTEM WIRED TO CONTROL PANEL, OR TO COOLING SYSTEM CONTROL PANEL	Yes ⬭	No ⬭	N/A ⬭
RECOVERY SYSTEM WIRED TO CONTROL PANEL OR TO RECOVERY SYSTEM PANEL	Yes ⬭	No ⬭	N/A ⬭
SEAL WATER SOLENOID (FOR LIQUID RING VACUUM PUMP) WIRED TO PUMP MOTOR TERMINAL IN MAIN CONTROL PANEL	Yes ⬭	No ⬭	N/A ⬭
AGITATOR MOTOR WIRED TO TERMINAL IN MAIN CONTROL PANEL	Yes ⬭	No ⬭	N/A ⬭
MECHANICAL SEAL SOLENOID VALVE (FOR AGITATOR) WIRED	Yes ⬭	No ⬭	N/A ⬭

HEATING SYSTEM

WATER INLET AND OUTLET PIPING CONNECTED BETWEEN HEATING SYSTEM AND THE DRYER VESSEL	**Yes**⬭	**No** ⬭	**N/A**⬭
ON THE ROTARY UNION THE SMALLER PIPE ON THE END WILL BE THE SUPPLY AND THE LARGER PIPE ON THE SIDE WILL BE THE RETURN LINE	**Yes**⬭	**No** ⬭	**N/A**⬭
CONNECTION ON ROTARY UNION FLEX CONNECTIONS	**Yes**⬭	**No** ⬭	**N/A**⬭
HEATING SYSTEM AND VESSEL LOOP FILLED WITH HEAT TRANSFER MEDIA	**Yes**⬭	**No** ⬭	**N/A**⬭
BLEED PLUG ON VESSEL AT HIGHEST POINT TILL FLOW	**Yes**⬭	**No** ⬭	**N/A**⬭
EXPANSION TANK LEVEL CHECKED	**Yes**⬭	**No** ⬭	**N/A**⬭
HEATING SYSTEM, NO LEAKS	**Yes**⬭	**No** ⬭	**N/A**⬭
TEMPERATURE CHECKED WITH CONTROLLER RANGE SETTINGS OK, CIRCULATION OK	**Yes**⬭	**No** ⬭	**N/A**⬭
HEATING SYSTEM CYCLED AT SET POINTS	**Yes**⬭	**No** ⬭	**N/A**⬭
VESSEL HEATED AT AN EVEN RATE (NO COLD SPOTS)	**Yes**⬭	**No** ⬭	**N/A**⬭
PRESSURE GAUGES READ PROPERLY	**Yes**⬭	**No** ⬭	**N/A**⬭
RELIEF VALVE OK	**Yes**⬭	**No** ⬭	**N/A**⬭

VACUUM SYSTEM

PIPING BETWEEN VACUUM SYSTEM AND VESSEL CONNECTED	**Yes**⬭	**No** ⬭	**N/A**⬭
FLEX CONNECTION AT VACUUM TUBE	**Yes**⬭	**No** ⬭	**N/A**⬭
CHILLED WATER LINES CONNECTED TO CONDENSER JACKET	**Yes**⬭	**No** ⬭	**N/A**⬭
FOR OIL SEALED BALLAST PUMPS: FILLED WITH OIL	**Yes**⬭	**No** ⬭	**N/A**⬭
FOR LIQUID RING PUMPS WATER INLET/OUTLET LINES CONNECTED	**Yes**⬭	**No** ⬭	**N/A**⬭
FOR SEALANT SYSTEMS TO LIQUID RING PUMP LOOP FILLED WITH WATER OK	**Yes**⬭	**No** ⬭	**N/A**⬭

MECHANICAL CHECKS

BOLTS CHECKED FOR TIGHTNESS (ALL)	Yes ⬭	No ⬭	N/A ⬭
VACUUM CLAMP FREE TO MOVE	Yes ⬭	No ⬭	N/A ⬭
AIR SUPPLY SET AT 90 POUNDS	Yes ⬭	No ⬭	N/A ⬭
V-BELTS CHECKED FOR TIGHTNESS	Yes ⬭	No ⬭	N/A ⬭
CHECKED FOR AIR LEAKS	Yes ⬭	No ⬭	N/A ⬭
GEAR LASH SET FOR: _____	Yes ⬭	No ⬭	N/A ⬭
EXPANSION BEARING CHECKED FOR LOCATION (MUST BE AT INBOARD SIDE OF BEARING HOUSING) CAP REMOVED FOR CHECK	Yes ⬭	No ⬭	N/A ⬭
FLEX CONNECTION S ARE FREE TO MOVE	Yes ⬭	No ⬭	N/A ⬭
GROUNDING STRAPS INSTALLED PROPERLY	Yes ⬭	No ⬭	N/A ⬭
DUST ARM INSTALLED AND PIPED PROPERLY	Yes ⬭	No ⬭	N/A ⬭
SEAL ASSEMBLIES CHECKED FOR TIGHTNESS	Yes ⬭	No ⬭	N/A ⬭

TRAY OPERATION

TRAY INSTALLED	Yes ⬭	No ⬭	N/A ⬭
TRAY LIFTS SMOOTH AND EVEN	Yes ⬭	No ⬭	N/A ⬭
DRUM CENTRALIZER SET AND TIGHT	Yes ⬭	No ⬭	N/A ⬭
TRAY PRESSURE SET	Yes ⬭	No ⬭	N/A ⬭

TESTING

VESSEL ROTATION IN CORRECT DIRECTION	Yes ⬭	No ⬭	N/A ⬭
AGITATOR ROTATION IN CORRECT DIRECTION	Yes ⬭	No ⬭	N/A ⬭
HEATING SYSTEM PUMP ROTATING IN CORRECT DIRECTION	Yes ⬭	No ⬭	N/A ⬭
VACUUM PUMP ROTATING IN CORRECT DIRECTION	Yes ⬭	No ⬭	N/A ⬭
LIQUID RECOVERY PUMP ROTATION IN CORRECT DIRECTION	Yes ⬭	No ⬭	N/A ⬭
AGITATOR SEAL COOLING WATER FLOW TO OPEN DRAIN	Yes ⬭	No ⬭	N/A ⬭

DISCHARGE VALVE OPENS AND CLOSES PROPERLY	**Yes**◯	**No** ◯	**N/A**◯
DUST ARM MOVES SMOOTH AND SLOW	**Yes**◯	**No** ◯	**N/A**◯
AGITATOR SHAFT ROTATED FOR FIVE MIN. AND CHECK FOR OVERHEATING; SEAL SHOULD BE WARM, NOT HOT	**Yes**◯	**No** ◯	**N/A**◯
VARI SPEED MOTORS CHECKED FOR UPPER AND LOWER LIMITS (WITH MOTOR RUNNING)	**Yes**◯	**No** ◯	**N/A**◯
THESE CHECKS ARE IN ADDITION TO CHECKS FOUND IN THE INSTALLATION PROCEDURE	**Yes**◯	**No** ◯	**N/A**◯

VACUUM TESTING

STEP1

VACUUM PUMP BLANKED OFF AND CHECKED FOR MAXIMUM PRESSURE DROP; MAXIMUM DROP	**Yes**◯	**No** ◯	**N/A**◯

STEP2

RECOVERY SYSTEM BLANKED OFF FROM DRYER AND CHECKED FOR MAXIMUM PRESSURE DROP. CHECKED FOR LEAK RATE NO MORE THAN ONE HALF INCH PER HOUR LEAK RATE	**Yes**◯	**No** ◯	**N/A**◯

STEP3

DRYER AND VACUUM SYSTEM CHECKED FOR MAXIMUM PRESSURE DROP VACUUM WAS ENTIRE SYSTEM BLANKED OFF FROM VACUUM PUMP AND CHECKED FOR VACUUM LEAK NO MORE THAN ONE HALF INCH PER HOUR	**Yes**◯	**No** ◯	**N/A**◯

TEST1: LEAK RATE WAS: _____
TEST2: LEAK RATE WAS: _____

VACUUM LEAKAGE RECHECKED (IF NECESSARY)

The above checklist should be completely executed (except the items not supplied by GEMCO)

The following signatures are required to validate your warranty.

Serial Number: _____ DATE: _____

_____ _____

Authorized signature of purchaser authorized signature of GEMCO representative