

TECHNICAL BULLETIN – DDR14

SUBJECT: DOUBLE DRUM DRYER START UP AND SHUT DOWN PROCEDURE

The following are the start up and shut down procedures for a double drum dryer:

Start Up

1. Blow down the main steam line of all water.
2. Check the drum gap (separation between the drums) or nip, for any foreign objects.
3. Turn on the main air-to-air header. Make sure all specified air pressures are set for each component (i.e. knife blades, end boards, etc.).
4. Check knife blades, end dams and screw conveyor product diverter shields, to make sure they are NOT touching the drums.
5. Open the main condensate return valve, and drain water. When empty, close the main condensate return valve.
6. Open the condensate bypass valves. These are located on the other side of the traps.
7. Make sure the trap valves are open.
8. Open the air purge valves that are located on the end of the drums.
9. Remove any lock-out device, in order to power-up the main panel.
10. Start drums at 15 Hertz, unless otherwise specified.
11. Start the exhaust blower.
12. Make sure that the steam blow down valve(s), the 'Y' strainer valve(s) and the steam pressure regulator(s) are closed.
13. Open the main steam valve, slowly.
14. Blow down the 'Y' strainer, to clean-out the screen. Note: Open with caution, because of steam pressure. After the blow down, close.
15. Open the steam air regulator to bleed in steam, so that it maintains 10 PSI of steam on the drum dryer pressure gage for one (1) hour, then increase the steam pressure 10 PSI every 15 minutes.
16. When the steam pressure is at 15 to 20 PSI on the drum gage, close the drum air purge valves, condensate by-pass valves and trap valves; following, open the main condensate return valve. Open the trap valves no more than one turn. This bleeds steam in with the condensate.
17. The drum dryer warm-up procedure should take no less than 2.5 hours.
18. When drums are to a specified steam pressure, production can start.

Shut Down

1. Turn off the slurry supply hand valves and/or shut off the feed pump.
2. Run out the puddle until the sheet becomes unacceptable, or the drums are clean.
3. Raise the knife blades and retract the end dams.
4. Stop pendulum feed if dryer is equipped with one.
5. Stop the side screw conveyors, if the dryer is equipped with screws that are driven by separate motors.
6. Turn off the main steam pressure valve and open the trap valves and condensate valves that dump to the floor.
7. Flush the dryer hood and drums with **NO LESS THAN 180° WATER.**

CAUTION: DO NOT APPLY COLD WATER TO THE DRUMS WHEN HOT!!!

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8. Leave the exhaust blower running during clean-up. Turn off after clean-up.
9. Perform dryer clean up and sanitation.
10. Continue to rotate the drums until they have had a chance to cool.
11. Stop the drums.
12. Turn off the air supply to the header.
13. Turn off the main electrical disconnect.

Drum Drying Resources supplies new, rebuilt, and retrofitted Double Drum Dryers to the drying industry. Each dryer is configured to specific designs, specifications, and systems to produce your product at maximum quality, sanitation, and productivity levels.

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