

TECHNICAL BULLETIN – DDR13

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 drum gap (between the drums) or nip, for any foreign objects.
3. Turn on 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 main condensate return valve and drain water. When empty, close main condensate valve.
6. Open condensate bypass valves. These are located on the other side of the traps.
7. Make sure trap valves are open.
8. Open 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 exhaust blower.
12. Make sure steam blown down valve(s), 'Y' strainer valve(s) and the steam pressure regulator(s) are closed.
13. Open the main steam valve slowly.
14. Blow down 'Y' strainer to clean-out screen. Note: Open with caution, because of steam pressure. After blow down, close.
15. Open 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 slurry supply hand valves or shut off feed pump.
2. Run out the puddle until the sheet becomes unacceptable or drums are clean.
3. Raise the knife blades and open the end dams.
4. Stop the side screw conveyors, if the dryer is equipped with screws that are driven by separate motors.
5. Turn off the main steam pressure valve and open the trap valves and condensate valves that dump to the floor.
6. Stop pendulum feed if dryer is equipped with one.
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 exhaust blower running during clean up.
9. Perform dryer clean up and sanitation.
10. Continue to rotate drums until they have had a chance to cool.
11. Stop drums.
12. Turn off air supply to header.
13. Turn off main electrical disconnect.

Please contact Drum Drying Resources for further information on converting existing double drum dryers to the applicator roll drying system.

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.

Check our Technical Bulletin section often in order to learn more about how our products and services can help you become more productive.