

TM3214 EXNO Heat & Vacuum Cool Drying Rate Chart

Procedure to set unload rotor speed:

1. Using your grain input moisture and desired plenum temperature, use Chart 1 to calculate the approximate unload rate. Start dryer unload.
2. Use Chart 2 to calculate the approximate time it will take to turn the dryer over one complete time.
3. After the time from Chart 2 has expired, adjust unload rotor speed accordingly. If grain moisture is too wet, decrease unload speed by 3% for every 1% moisture is off, if too dry, do the opposite. Allow at least 1/3 the turnover time in Chart 2 between changes.
4. When the actual grain moisture is within 0.5% of your target (or desired) grain moisture, calibrate the discharge moisture sensor by following instructions on touchscreen (TOOLS→CALIBRATE SENSORS).
5. Once moisture sensor has been calibrated and you are within 0.5% of your desired output moisture on the touchscreen, you can switch the unload from Manual to Automatic. Note the Grain Column Temperature, often automatic control works best based off grain temp.

Chart 1 shows suggested unload rotor speed settings based on plenum temperature and amount of moisture to be removed. The values in the chart are a good **starting point** when first selecting the unload speed. Final running speed may differ from charts as user may adjust speed as dryer runs.

Example: to dry 20% Corn to 15% with a plenum temperature of 170°, initial unload rate should be set to: 47 %

Chart 1 TM3214 EXNO Unload Rate (%) for Corn at Listed Moistures*

		Plenum Temperature								
		140 °F	150 °F	160 °F	170 °F	180 °F	190 °F	200 °F	210 °F	220 °F
Moisture Removal	16-15%	70	80	90	100	100	100	100	100	100
	17-15%	54	62	70	77	85	93	100	100	100
	18-15%	45	51	58	64	70	77	83	90	96
	19-15%	38	44	49	55	60	66	71	76	82
	20-15%	33	38	43	47	52	57	61	66	71
	21-15%	29	33	37	41	45	50	54	58	62
	22-15%	25	29	33	36	40	43	47	51	54
	23-15%	22	25	29	32	35	38	41	45	48
	24-15%	20	22	25	28	31	34	36	39	42
	25-15%	17	20	22	24	27	29	32	34	37
	26-15%	15	17	19	21	23	26	28	30	32
	27-15%	13	15	17	18	20	22	24	26	28
	28-15%	11	13	14	16	17	19	21	22	24
29-15%	9	11	12	13	15	16	17	19	20	
30-15%	8	9	10	11	12	13	14	16	17	

Chart 2 TM3214 EXNO Dryer Specifications

Unload Rate (%)	Freq. (Hz)	Bu/hr*	Minutes to Turn Over
10	6	500	437
20	12	1000	218
30	18	1500	146
40	24	2000	109
50	30	2500	87
60	36	3000	73
70	42	3500	62
80	48	4000	55
90	54	4500	49
100	60	5000	44

Heat Holding Capacity:	2723
Overall Holding Capacity:	3640
Maximum Unload Rate:	5000

*The charts above show approximate unload rates and capacities, and in no way are guaranteed. They can vary due to flow gate settings, varieties of grain, weather conditions, and amount of fines.

NOTE: If the dryer has multiple plenum and several different plenum set points are being used, an equivalent plenum temp must be calculated.

$$Eq. \text{ Plenum Temp} = PT1 * \frac{\# \text{ of Tiers P1}}{\text{Total \# of Tiers}} + PT2 * \frac{\# \text{ of Tiers P2}}{\text{Total \# of Tiers}} \dots \text{ect.}$$

Example: On a TM1610 dryer with the top plenum set to 210°F and the bottom plenum set to 180°F the equivalent temp is calculated as follows:

$$210^{\circ}F * \frac{4 \text{ Tiers Top Plenum}}{10 \text{ Tiers Total}} + 180^{\circ}F * \frac{6 \text{ Tiers Lower Plenum}}{10 \text{ Tiers Total}} = 84 + 108 = 192^{\circ}F \text{ equivalent temp}$$