



**AN SPX BRAND**

**Installation, Operation and  
Maintenance Manual**

**HXK SERIES  
REFRIGERATED AIR DRYERS**

**Models  
HX75/100/150**

Bulletin M519E Rev.C ( 04/09)  
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**This instruction manual must be read by everyone  
Who installs or works with this equipment**

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## INTRODUCTION

The dryers use mechanical refrigeration to dry compressed air. See Table 4 for rated capacity and other dryer specifications.

To ensure continuous good performance and safe operation, everyone who installs, uses or maintains the dryer must read and carefully follow the instructions in this manual.

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## SAFETY

The dryers are designed and built with safety as a prime consideration; industry-accepted safety factors have been used in the design. Each dryer is checked at the factory for safety and operation. All necessary adjustments are made before shipment.

Follow the maintenance schedules outlined in this manual for good performance and safe operation. Maintenance should be done only by qualified personnel with proper tools.

Carefully read the following safety rules before proceeding with installation, operation or maintenance. The rules are essential to ensure safe dryer operation. Failure to follow these rules void the warranty or result in dryer damage or personal injury.

1. Do not install or try to repair a dryer that has been damaged in shipment.  
See Receiving and Inspection for instructions.
2. Compressed air and electricity have the potential to cause personal injury or equipment damage. Before doing any work in the dryer, be sure the electrical supply has been locked and tagged and the internal pressure of the dryer has been vented to the atmosphere.
3. Do not operate the dryer at pressures or temperatures above the maximum conditions shown on the data plate.
4. Always supply electrical power that complies with the voltage shown on the data plate.
5. Do not readjust the dryer without factory authorization.
6. Work on the refrigeration system must be done only by a competent refrigeration mechanic.
7. Use only manufacturer's genuine replacement parts. The manufacturer bears no responsibility for hazards caused by the use of unauthorized parts.

## Safety Instructions

Safety instructions in this manual are boldfaced for emphasis. The signal words **DANGER**, **WARNING** and **CAUTION** are used to indicate hazard seriousness levels as follows:

**DANGER** ----- Immediate hazard which WILL result in severe injury or death.

**WARNING** ----- Hazard or unsafe practice which COULD result in severe injury or death.

**CAUTION** ----- Hazard or unsafe practice which COULD result in minor injury or in product or property damage.

## Data Plate

The dryer data plate contains identification information. If the data plate is missing or damaged, contact your local distributor and request a replacement.

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## RECEIVING AND INSPECTION

Inspect the dryer closely when it is received. Record any indication of damage on the delivery receipt, especially if the dryer will not be immediately uncrated. Obtain the delivery person's signed agreement to recorded damages to facilitate future insurance claims.

Since the dryer is shipped F.O.B. Factory, the manufacturer's responsibility for the shipment ceases when the carrier signs the bill of lading.

If goods are received short or in damaged condition, notify the carrier and insist on a notation of the loss or damage across the face of the freight bill. Otherwise no claim can be enforced against the carrier.

If concealed loss or damage is discovered, notify your carrier at once and request an inspection. This is absolutely necessary. Unless you do this, the carrier will not consider any claim for loss or damage. The carrier will make an inspection and may grant a concealed damage notation. If you give the carrier a clear receipt for the goods that have been damaged or lost in transit, you do so at your own risk and expense.

The manufacturer is willing to assist you in collecting claims for loss or damage. Willingness does not make the manufacturer responsible for collecting claims or replacing material. Claim filing and processing is your responsibility.

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## INSTALLATION

### **Ambient Air Temperature**

Locate the dryer indoors where the ambient air temperature will be between 4 °C and 50 °C. Intermittent operation at ambient temperatures up to 50 °C will not damage the dryer but may result in a higher dew point or dryer shutdown due to high refrigerant discharge pressure (see Field Service Guide).

Do not operate air-cooled dryers at ambient air temperatures below 4 °C. Such operation may result in low suction pressure, causing freeze-up.

### **Location and Clearance**

Mount the dryer on a level base and bolt down if the base vibrates. If the dryer is air cooled, install it in a clean, well-ventilated area to reduce fouling of the condenser coils with dirt and dust. Allow 6 inches clearance on the sides and the front of the dryer for cooling airflow on air-cooled dryers and for service access on air-cooled dryers.

### **System Arrangement**

Liquid water adversely affects dryer performance. To prevent “slugging” the dryer with liquid water, locate the dryer downstream of an aftercooler and a mechanical separator. Install drain valves to discharge condensate that collects in these areas.

If the airflow is relatively constant and will not cause short term overloading of the dryer, it is recommended that the dryer be located downstream of the receiver tank. If the nature of the application is such that the air demand regularly exceeds the dryer flow rating, it is recommended that the dryer be located upstream of the receiver.

For safety and convenience, install inlet and outlet shutoff valves and depressurization valves at the locations indicated. These valves allow the dryer to be isolated and depressurized for servicing. Bypass piping may be installed around the dryer for uninterrupted airflow when the dryer is serviced. If the compressed air operation cannot tolerate undried air for short periods, install a second dryer in the bypass line.

Compressed air systems commonly require filters to remove compressor oils, particulates, condensed liquids and other contaminants. When an oil-removal filter is used, install the

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filter downstream of the dryer. At this location, the life of the replaceable filter element is prolonged since some of the entrained oil is removed by the dryer and drained through the separator.

### **Piping and Connections**

Piping must be furnished by the user unless otherwise specified. Connections and fittings must be rated for the maximum operating pressure given on the dryer data plate and must be in accordance with applicable codes. Support all piping ; do not allow the weight of any piping to stress the dryer or filters. Inlet and outlet shutoff valves and a valved bypass are recommended. Piping should be at least the size of the inlet and outlet connections to minimize pressure drop in the air system. See Table 5 for dryer inlet and outlet connections.

### **Drains**

Condensate must be drained from the dryer to prevent its reentrainment. The dryers are equipped with automatic drain valves and internal drain hoses up to the drain connections on the dryer cabinets. The user must install a discharge line from the drain connection and run it to a waste disposal collection system that meets applicable regulations. Pipe or copper tubing ½ inch or larger is recommended for condensate discharge lines. Install the drain lines so that condensate can be seen as it drains.

### **Electrical Connections**

Field wiring must comply with local and national fire, safety and electrical codes. Installation must be in accordance with the National Electrical Code. Confirm that your line voltage is the same as the voltage listed on the dryer data plate. Refer to Approval Dwg for electrical schematics.

#### **CAUTION**

**Operation of dryers with improper line voltage constitutes abuse and could affect the dryer warranty.**

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## HOW IT WORKS

### **Airflow (see Figure 2)**

The dryers use refrigeration cooling to condense entrained moisture out of the air stream. Warm saturated air enters the air-to-air heat exchanger where it is cooled by outgoing cold air. The inlet air is further cooled in the refrigeration chiller. The cold, dry air is reheated by incoming warm air as it passes back through the air-to-air heat exchanger. Using the outgoing air to pre-cool the inlet air condenses up to 65 percent of the moisture out of the inlet air before it reaches the chiller. Pre-cooling the inlet air reduces the heat load on the refrigerant compressor, permitting the use of a smaller refrigerant compressor.

### **Refrigeration System**

The refrigeration system is designed and fabricated in accordance with recognized commercial/industrial practices. It consists of a compressor and the controls, safety interlocks and associated equipment necessary for safe performance.

All models use expansion devices and hot gas bypass valves(HGBV) to modulate the refrigerant flow.

The HGBV delivers hot refrigerant gas to the refrigerant compressor in response to changes in the refrigerant pressure. This prevents icing in the chiller and short cycling in the refrigerant compressor during extended periods of system operation at low load.

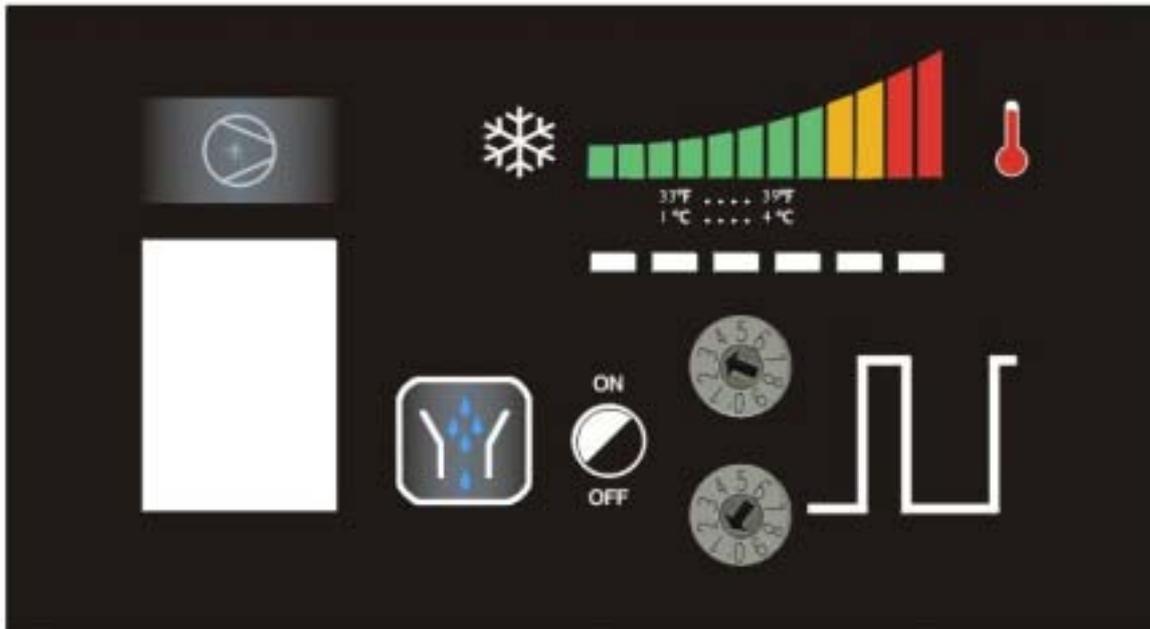
The HGBV is adjusted at the factory; operation is fully automatic.

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## INSTRUMENTATION

### Dryer System Monitor (DSM)

This series are equipped with LED type dew point indicator.



**Figure 1**  
**DRYER SYSTEM MONITOR**

DSM has LED type dew point indicators and electronic drain valve operation time adjusting. When the dryer is normal running, the green LED will light on. The red indicator light indicating a need for dryer operating condition checking. If all LEDs light on, the sensor for dew point monitor is malfunction. The automatic drain valve controls allow the period of drain opening to be set from 0.5 sec to 9 sec and drain valve closed time to be set from 0.5 min to 9 min. When the "PUSH TO TEST" button is pushed, the drain port clicks open with a cleaning audible sound.

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## **AUTOMATIC DRAIN VALVE**

The dryers are equipped with an electronic drain valve that automatically discharges condensate from the dryer. Drain valve operation is controlled by a drain valve timer. The drain opening can be set from 0.5 sec to 9 sec. The drain cycle can be set from 0.5 min to 9 min.

### **Electronic Drain Valve Adjustment**

To minimize air losses, the drain valve control time should be adjusted to open the drain port just long enough to discharge accumulated condensate. Set the drain valve operating time so that only air discharges at the end of the open period. Recommended initial settings are a 1 to 2-second drain opening and 30 seconds drain closed time (cycle). If liquid discharges as the port is closing, set the timer for a shorter cycle or a longer opening.

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## **START-UP**

Follow the procedure below to start your dryer. Failure to follow the prescribed start-up procedure will invalidate the warranty. If problems arise during start-up, call your distributor.

1. Turn the dryer ON/OFF switch to OFF.
2. Turn on the main electrical power to the dryer.

### **To start dryer :**

1. Turn the power switch to ON. The refrigerant compressor will turn on.
  2. Confirm that condensate is discharging from the drain valve.
  3. Check drain valve timing. See Electronic Drain Valve section for drain valve adjustment procedure.
  4. Check that the main electrical supply voltage matches the voltage specified on the dryer data plate.
  5. Check proper connection and support of compressed air lines to the dryer; check bypass valve system, if installed.
  6. Ensure adequate ventilation for air-cooled dryers.
  7. Confirm that the inlet air temperature, pressure and airflow to the to the dryer meet the specified requirements (see Table 4 & 5)
-

8. confirm that the condensate lines from the drain valve discharge into a collection tank or an environmentally-approved disposal system.
9. If the refrigerant Suction Pressure Gauge is out of range, refer to the Field Service Guide for information or contact your local distributor.

The dryer is designed to run continuously. Let the dryer run even when the demand for compressed air is interrupted; the dryer will not freeze up.

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## SHUTDOWN

When the dryer must be shut down for maintenance or other reasons, use the following procedures.

If electrical repairs must be made :

1. Turn off the power switch.
2. Disconnect the main power supply.
3. Lock out and tag the power supply in accordance with OSHA requirements.

### **DANGER**

**Portions of the control circuit remain energized when the power switch is in the OFF position. Disconnect supply power to the dryer before performing maintenance on the electrical system.**

**Dismantling or working on any component of the compressed air system under pressure may cause equipment failure and serious personal injury.**

**Before dismantling any part of the dryer or compressed air system, completely vent the internal pressure to the atmosphere.**

If mechanical repairs must be made, vent the internal pressure of the dryer to atmospheric pressure. After the refrigerant compressor become cool, restart the dryer according to the start-up instructions.

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## MAINTENANCE

The dryers require little maintenance for satisfactory operation. Good performance can be expected if the following routine maintenance steps are taken.

### **DANGER**

**Dismantling or working on any component of the compressed air system under pressure may cause equipment failure and serious personal injury. Before dismantling any part of the dryer or compressed air system, completely vent the internal pressure to the atmosphere.**

### **General**

For continued good performance of your refrigerated dryer, all refrigeration system maintenance should be performed by a competent refrigeration mechanic. Before corrective maintenance is done during the warranty period, call your local distributor and proceed according to instructions.

### **Daily**

Check the operation of the electronic drain valve at least once during each 8-hour shift. See the Field Service Guide for remedies to drain valve malfunctions. See the ELECTRONIC DRAIN VALVE section for drain valve adjustment.

### **Weekly**

**Inspect air filter weekly and clean it if necessary. Dirty air filter cause loss of efficiency and may result in damage to product.**

**Air Filter –Clean accumulated dust and dirt from air filter weekly if air flow across the Condenser is impeded.**

**A. Open right side door.**

**B. Remove air filter by sliding upwards.**

**C. Wash with soap and water and allow to dry before reinstalling.**

**Note : Do not use solvents to clean air filter.**

**D. Reinstalling air filter and right side door.**

### **Monthly**

For air-cooled condensers, it is recommended to inspect the condenser coils monthly. If necessary, remove dirt or other particles with compressed air from an OSHA-approved air nozzle that limits its discharge pressure to 2.1 kgf/cm<sup>2</sup>.

## Returns to Manufacturer

If the dryer or a component of the dryer must be returned to the manufacturer, first call your local distributor for a return authorization number and shipping address. Your distributor will inform you whether the dryer or only a component must be returned. Mark the package with the return authorization number and ship freight prepaid as directed by your local distributor.

## Electronic Drain Valve Disassembly and Servicing

The valve body is mounted on the frame bottom; a hose connects the valve body to the heat exchanger vessel.

### CAUTION

**Do not disassemble drain valve timer or attempt to repair electrical parts.  
Replace timer if defective.**

The drain valve discharges condensate through a full-port drain opening. The valve body may need to be cleaned under conditions of gross particulate contamination.

To disassemble the drain valve body for cleaning and other maintenance :

1. Turn power switch off.
2. Disconnect main power supply to dryer.
3. Lock out and tag power supply in accordance with OSHA requirements.

### WARNING

**If power supply is not disconnected before disassembly, serious personal injury and valve damage may result.**

4. Remove hoses that connect the drain valve to the drain valve strainer.
5. Remove screw and washer from front of the drain valve.
6. Remove the power supply connector and gasket (with the timer assembly if attached) from the solenoid coil housing. Do not damage or lose the gasket.
  1. Remove coil fixing nut and spring washer from top of solenoid coil housing.
  2. Lift solenoid coil housing off solenoid core in valve body.
  3. Unscrew solenoid core from valve body.

Once the drain valve is disassembled, the following maintenance can be performed.

1. Inspect internal parts of valve body; clean or replace as required.
2. Remove debris from valve body.
3. Wipe solenoid core components with a clean cloth or blow out debris with compressed air from an OSHA-approved air nozzle that limits its discharge pressure to 2.1 kgf/cm<sup>2</sup>.
4. Check that the inside part assembly is clear and solenoid coil moves freely in housing
5. If timer is attached to valve body, check electrical continuity across timer assembly.

To reassemble the drain valve, reverse the sequence of the preceding steps. After the drain valve is reassembled, connect the main power supply to the dryer.

When the dryer is returned to service, check the drain valve for air or condensate leaks; tighten connections as required to correct leaks. Check the drain cycle; adjust the timer according to the procedure in the drain valve adjustment section.

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## FIELD SERVICE GUIDE

Problems most frequently encountered with refrigerated dryers are water downstream of the dryer and excessive pressure drop. Most causes can be identified and remedied by following this guide.

### **DANGER**

**Closed refrigeration systems are potentially dangerous. Work on the refrigeration system must be done only by a competent licensed refrigeration mechanic.**

**Do not release fluorocarbon refrigerants to the atmosphere. Do not discharge liquid refrigerants into floor drains. Refrigerant vapors may accumulate in low places. Inhalation of high concentrations may be fatal.**

**Do not smoke while working on the refrigeration system or when a refrigerant leak is suspected. Burning materials may decompose refrigerants, forming toxic gas or acids that may cause serious injury and property damage.**

The refrigerant valves are adjusted at the factory with the refrigerant system operating and no airflow through the dryer. While the dryer is operating, the suction pressure may fluctuate slowly with changes in the refrigeration load. To determine the suction pressure, see the Refrigerant Suction Pressure Gauge mounted on the front panel.

### FIELD SERVICE GUIDE (COLOR INDICATOR)

PROBLEM	SYMPTOM	POSSIBLE CAUSE	REMEDY
Water downstream of dryer	No discharge from separator drain trap.	Failure of separator.	Dismantle and clean, repair or replace separator.
	Dryer inlet air temperature too high.	Aftercooler malfunction	Check aftercooler discharge temperature and reduce to dryer design condition (120° max)
	Refrigerant compressor stopped.	Leak in ref. system.	Consult your local distributor.
		Compressor overheated	Turn dryer off. Wait 30 minutes; turn dryer on. (Motor thermostat self-starting.)
High pressure drop	Low outlet pressure.	Compressor burned out	Consult your local distributor.
		Dryer undersized (may also cause water downstream of dryer)	Check airflow and dryer capacity. Reduce airflow or resize and replace dryer.
	Lowest process air temperature below 32°	Blocked separator	Dismantle and clean or replace separator.
Color indicator out of green zone	Indicator in red zone	Dryer icing up (check at separator).	Consult your local distributor.
		Inlet air temperature too high	Reduce aftercooler discharge temperature to design conditions (see Table 1).
		Excessive airflow	Check airflow and system capacity. Reduce airflow or resize and replace system.
		Condenser fouled or Clogged	Clean or replace pre filter.
		High ambient temp.	Ventilate area.
	Improper adjustment of Expansion valve.	Remove cap from the exp. valve and turn the screw until the indicator is in the green zone.	
Indicator in blow zone	Improper adjustment of Expansion valve	Adjust the exp. valve until the indicator is in the green zone.	
No condensate from electronic drain valve (EDV)	Valve venting. But no condensate from valve	Accumulation of dirt in valve strainer.	Dismantle valve strainer. Strainer clean or replace.
			Replace valve.
	Valve continuously venting.	Clogged valve orifice.	Check and replace connector
		Short in electrical component.	Check and correct power supply and connections.
	Valve not cycling.	No electrical power.	Replace solenoid coil.
		Solenoid coil malfunction.	Check and correct power supply and connections.
		No electrical power.	Check solenoid coil and wiring cable and replace fuse.
No response when test button is pushed.	No electrical power.	Replace sensor assembly	
	Burn out fuse	Dismantle valve strainer. Strainer clean or replace.	

### FIELD SERVICE GUIDE (DSM)

PROBLEM	SYMPTOM	POSSIBLE CAUSE	REMEDY
Water downstream of dryer.	No discharge from automatic drain valves (ADV).	ADV failure or accumulation of dirt in drain valve strainer.	Dismantle drain valve: clean, repair or replace. See maintenance section.
	Inlet air temperature is too high.	Aftercooler malfunction.	Check aftercooler discharge temperature. Reduce temperature to 49 max.; reduce airflow if temperature is above 38 . (See Table 5).
	Liquid water entering dryer.	Aftercooler drain valve malfunction.	Dismantle aftercooler drain valve ; clean, repair or replace.
	Excessive airflow (may also cause high pressure drop).	Dryer improperly sized.	Check airflow and dryer capacity(see Table 4). Reduce airflow or resize and replace dryer.
	Compressor cuts out on internal overload.	Inadequate ventilation of refrigerant compressor.	Ensure adequate ventilation of the condensing unit(see Clearance). Motor will restart automatically when compressor is cool.
			Locate leak, repair and recharge. Motor will restart automatically when compressor is cool.
	Compressor windings read open or shorted.	Compressor burned out.	Have a refrigeration mechanic check and replace.
	The red LED light on	Improper adjustment of HGBV.	Remove cap from the HGBV and screw out HGBV 1/2 turn to lower suction pressure
		Inlet air temperature too high.	Reduce aftercooler discharge temperature to design conditions(see Table 5).
		Excessive airflow.	Check airflow and system capacity. Reduce airflow or resize and replace system.
		Condenser fouled or clogged.	Clean or replace condenser.
		Fan motor inoperative.	Replace fan motor.
		High ambient temperature.	Ventilate area. See Table 5
	High pressure drop across dryer.	Inlet air temperature is too low.	Low ambient temperature.
Excessive airflow(may also cause water downstream of dryer).		Dryer improperly sized.	Check airflow and dryer capacity. Reduce airflow or resize and replace dryer.
Dryer icing up.			Adjust operating conditions to meet sizing conditions.
	Adjust HGBV to raise suction pressure		

PROBLEM	SYMPTOM	POSSIBLE CAUSE	REMEDY
No condensate from automatic drain valve (ADV)	Valve venting. But no condensate from valve.	Accumulation of dirt in valve strainer.	Dismantle valve strainer. Strainer clean or replace.
	Valve continuously venting.	Clogged valve orifice.	Replace valve.
		Short in electrical component.	Check and replace connector or DSM assembly.
	Valve not cycling.	No electrical power.	Check and correct power supply and connections.
		DSM malfunction.	Replace DSM assembly.
		Solenoid coil malfunction.	Replace solenoid coil.
No response when test button is pushed.	No electrical power.	Check and correct power supply and connections.	
	Burn out fuse	Check solenoid coil and wiring cable and replace fuse.	
Dew Point indicator malfunction	All LED indicator light on	Sensor malfunction	Replace sensor assembly

**Table 1**

**SUCTION PRESSURE**

REFRIGERANT	WITHOUT AIRFLOW	WITH AIRFLOW
R-404a	5 ± 0.5kgf/cm2g	6 ± 1 kgf/cm2g

Do not adjust refrigerant valves without factory authorization. Adjustments must be made only with no airflow into the dryer.

**CAUTION**

**Do not introduce mineral oils into the refrigeration system of the dryers.  
Servicing equipment should contain NO TRACE OF MINERAL OILS.**

**Table 2**

**REFRIGERANT PRESSURE SWITCH SETTINGS**

Fan Cycle Control	
Fan Pressure Switch Setting	
R-404a	
ON	OFF
24 ± 1 kgf/cm2g	18 ± 1 kgf/cm2g

Refrigerant Compressor Control		
High Pressure Switch Setting		
Sensor Location	R-404a	
	Cut-out	Cut-in
Compressor discharge	28 ± 1 kgf/cm2g	<b>Manual Reset</b>

**Table 3****DIMENSIONS AND CONNECTION SIZES**

MODEL	DIMENSIONS ( mm )		
	H	W	D
HX75	510	680	700
HX100/150	525	453	722

**Table 4****DRYER SPECIFICATIONS**

MODEL NO.	POWER SUPPLY (V / PH/Hz)	INPUT POWER (kW)	REFRIGERANT TYPE <sup>b</sup>
HX75	220/ 1/60	1.6	R-404a
HX100		1.6	
HX150		1.7	

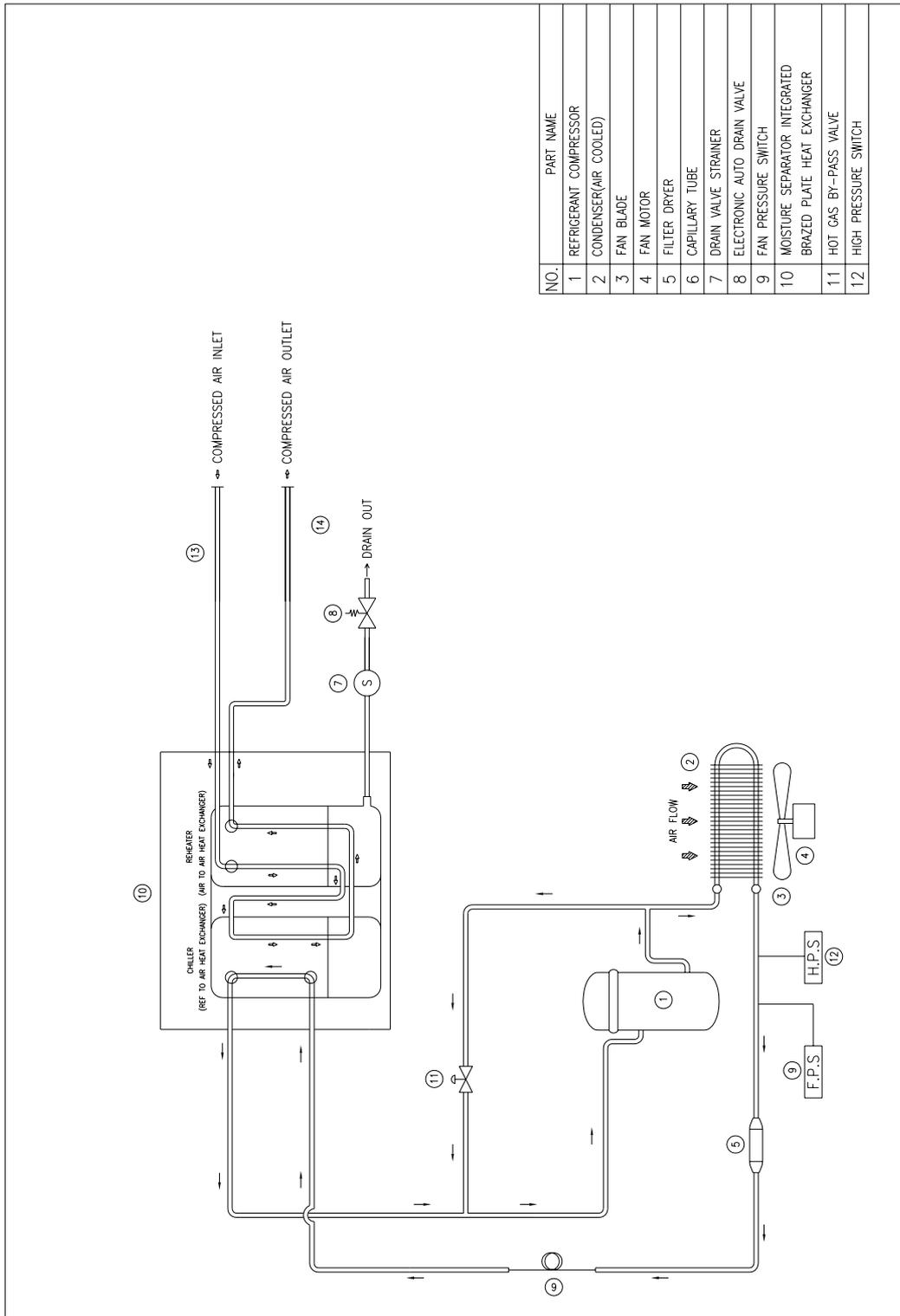
<sup>a</sup> Rating conditions are 45 °C inlet temperature, 7.0kgf/cm<sup>2</sup>g inlet pressure, 100% inlet relative humidity, 45 °C ambient temperature @ 60Hz.

<sup>b</sup> Refer to dryer data plate for refrigerant charge.

**Table 5****DRYER OPERATING CONDITIONS**

MODEL NO.	Maximum Inlet Air Pressure	Minimum Inlet Air Pressure	Maximum Inlet Air Temperature	Minimum Inlet Air Temperature	Maximum Ambient Air Temperature	Minimum Ambient Air Temperature
HX75/100/150	16.3kgf/cm <sup>2</sup> g	0.7kgf/cm <sup>2</sup> g	49	4	45	4

Note : Continuous operation in the above maximum and minimum operating conditions is not allowable.



NO.	PART NAME
1	REFRIGERANT COMPRESSOR
2	CONDENSER(AIR COOLED)
3	FAN BLADE
4	FAN MOTOR
5	FILTER DRYER
6	CAPILLARY TUBE
7	DRAIN VALVE STRAINER
8	ELECTRONIC AUTO DRAIN VALVE
9	FAN PRESSURE SWITCH
10	MOISTURE SEPARATOR INTEGRATED BRAZED PLATE HEAT EXCHANGER
11	HOT GAS BY-PASS VALVE
12	HIGH PRESSURE SWITCH

Figure 2  
AIR AND REFRIGERANT FLOW SCHEMATIC

## REPLACEMENT PARTS

ITEM	DESCRIPTION	HX75	HX100	HX150
1	Refrigerant compressor	C000593		
2	Condenser(air-cooled)	C000533	C004472	C004473
3	Fan Blades	C000084		C000663
4	Hot Gas Bypass Valve(HGBV)	C000451		C000085
5	Fan Motor	C006281		C000663
6	Filter/Dryer	C000490	C000220	
7	DRYER SYSTEM MONITOR	C005042		
8	COLOR INDICATOR	C003294		
9	Electronic Drain Valve(EDV)	C006470		
10	Fan Pressure Switch	C005315		
11	High Pressure Switch	C000692		
12	On/Off Switch with Running Lamp	C003520		
13	Pre Filter Element	Replacement Time : 6 months (To be Confirmed at field site)		
14	After Filter Element	Replacement Time : 6 months (To be Confirmed at field site)		

Some specifications in this manual may change without notice for improvement.



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**HEADQUARTERS / FACTORY**

SPX FLOW TECHNOLOGY KOREA CO., LTD.

#940-1, YERIM-RI, JEONGGWAN-MYEON,

GIJANG-GUN, 619-961 BUSAN, SOUTH KOREA

Tel : +82-51-728-5360 Fax :+82-51-728-5359

[www.spxflowkorea.com](http://www.spxflowkorea.com)

**SEOUL OFFICE**

601, 6F, C-DONG, WOOLIM LION'S VALLEY, 371-28, GASAN-DONG

GEUMCHEON-GU SEOUL KOREA

Tel : +82-2-2026-3620 Fax : +82-2-2026-3623