

Dryer troubleshooting guide *for Eastman copolyesters*

Problem	Possible cause	Corrective action
High dew point (wet air)	Desiccant worn out or saturated	Dry cycle machine or replace desiccant
	Incorrect desiccant type	Replace desiccant with type and size recommended by dryer manufacturer
	Regeneration heaters burned out	Replace heaters
	Regeneration filter plugged	Clean or replace filter
	Regeneration blower reversed	Reverse electrical connections
	Air leaks	Check and repair auto loader seal and/or hoses to hopper
	Beds not changing at the proper time	Reset or repair controller
	Return air too hot	Add or repair aftercooler
Low airflow	Dirty air filter	Clean or replace filter
	Fan motor reversed	Reverse electrical connections
	Hoses reversed between inlet and outlet	Connect dryer outlet to inlet at the bottom of the hopper
	No hose clamps; hose disconnected	Connect and clamp hoses
	Hose smashed or cut	Repair or replace hose
Short residence time	Hopper too small	Use larger hopper
	Hopper not full	Keep hopper full
	Tunneling or "rat holes"	Remove clumped material or install proper spreader cones
Temperature high or low (or varying more than -3°C [-5°F])	Incorrect temperature setting	Set correct temperature
	Temperature controller malfunction	Calibrate or replace temperature controller
	Dryer not designed to maintain correct range	Repair or replace dryer
	Thermocouple loose or malfunction	Repair or replace thermocouple
	Heater malfunction	Repair or replace heater



**Eastman Chemical Company
Corporate Headquarters**

P.O. Box 431
Kingsport, TN 37662-5280 U.S.A.

U.S.A. and Canada, 800-EASTMAN (800-327-8626)
Other Locations, +(1) 423-229-2000

www.eastman.com/locations

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