



# 7350 Series End Drive Conveyors

## Installation, Maintenance and Parts Manual



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## Introduction

### CAUTION

**Some illustrations may show guards removed. DO NOT operate equipment without guards.**


Upon receipt of shipment:

- Compare shipment with packing slip. Contact factory regarding discrepancies.
- Inspect packages for shipping damage. Contact carrier regarding damage. Accessories may be shipped loose.
- See accessory instructions for installation.

The Dorner Limited Warranty applies.

Dorner 7350 Series conveyors have patents pending.

Dorner reserves the right to make changes at any time without notice or obligation.

Dorner has convenient, pre-configured kits of Key Service Parts for all conveyor products. These time saving kits are easy to order, designed for fast installation, and guarantee you will have what you need when you need it. Key Parts and Kits are marked in the Service Parts section of this manual with the Performance Parts Kits logo .

## Warnings – General Safety

### **DANGER**



#### **SEVERE HAZARD!**

**KEEP OFF CONVEYORS.** Climbing, sitting, walking or riding on conveyor will result in death or serious injury.

### **DANGER**



#### **EXPLOSION HAZARD!**

- **DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.** The electric gearmotor generates heat and could ignite combustible vapors.
- Failure to comply will result in death or serious injury.

### **WARNING**



#### **CRUSH HAZARD!**

- **DO NOT** place hands or fingers inside the conveyor while it is running.
- **DO NOT** wear loose garments while operating the conveyor. Loose garments can become caught up in the conveyor.
- Failure to comply could result in serious injury.

### **WARNING**



#### **CRUSH HAZARD!**

- **SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.**
- Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing serious injury.

### **WARNING**



#### **SEVERE HAZARD!**

**LOCK OUT POWER** before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

### **WARNING**



#### **BURN HAZARD!**

**DO NOT TOUCH** the motor while operating, or shortly after being turned off. Motors may be **HOT** and can cause serious burn injuries.

### **WARNING**



#### **PUNCTURE HAZARD!**

Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.

### **WARNING**



#### **SEVERE HAZARD!**

- Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.
- When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, **CHECK FOR POTENTIAL PINCH POINTS** and other mechanical hazards before system start-up.
- Failure to comply could result in serious injury.

# Product Description

Refer to (Figure 1) for typical conveyor components.

Typical Components	
1	Conveyor
2	Gearmotor
3	Belt (Cleated Belt Shown)
4	Support Stands
5	Drive End
6	Idler End

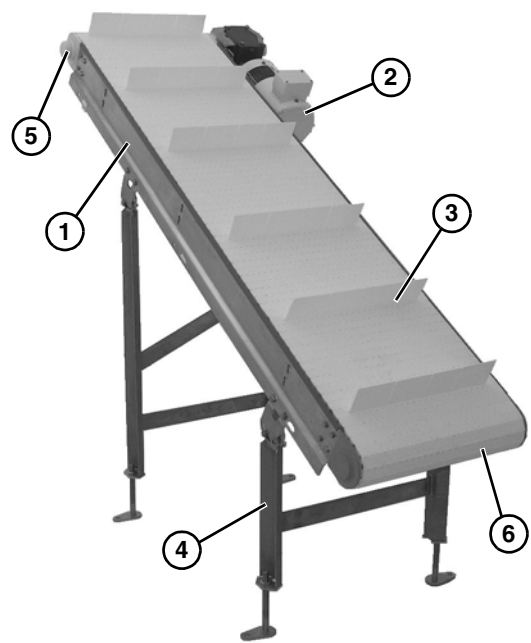
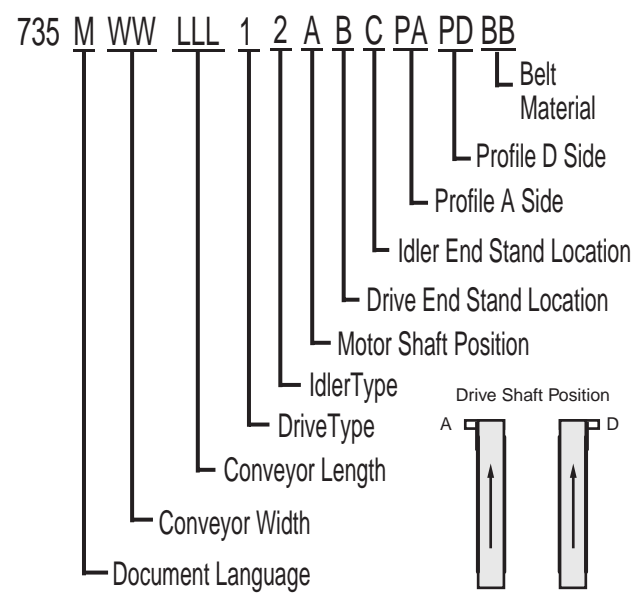


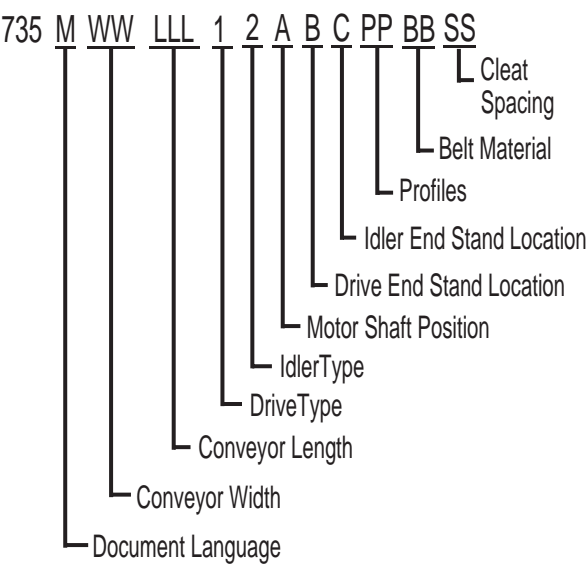
Figure 1

# Specifications

## Flat Belt 7350 Series Conveyor

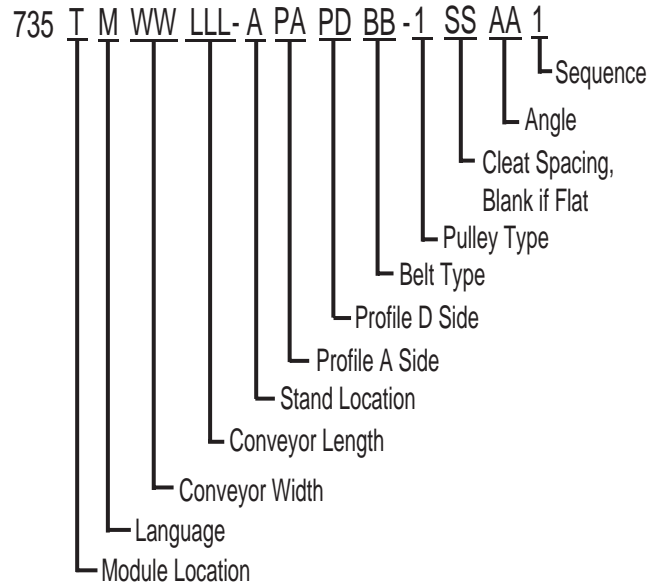


## Cleated Belt 7350 Series Conveyor

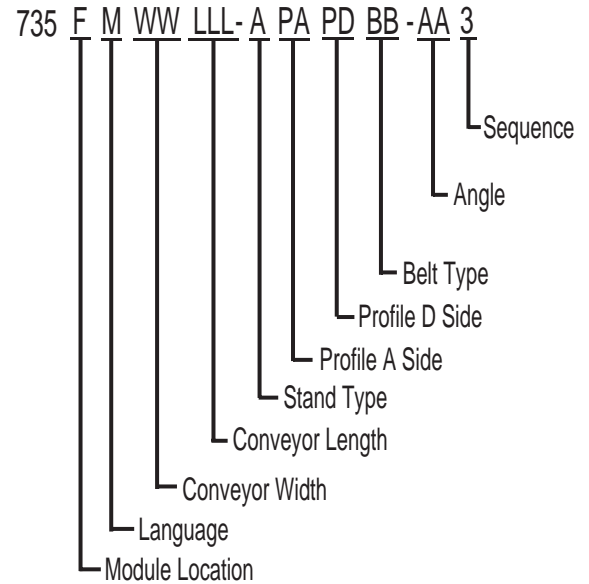


## 7350 Series Z-Frame Conveyor Modules

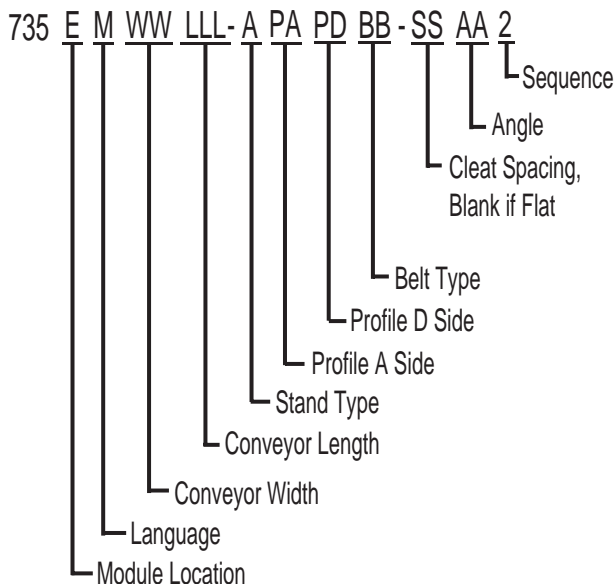
### 7350 Series Infeed Section to Knuckle



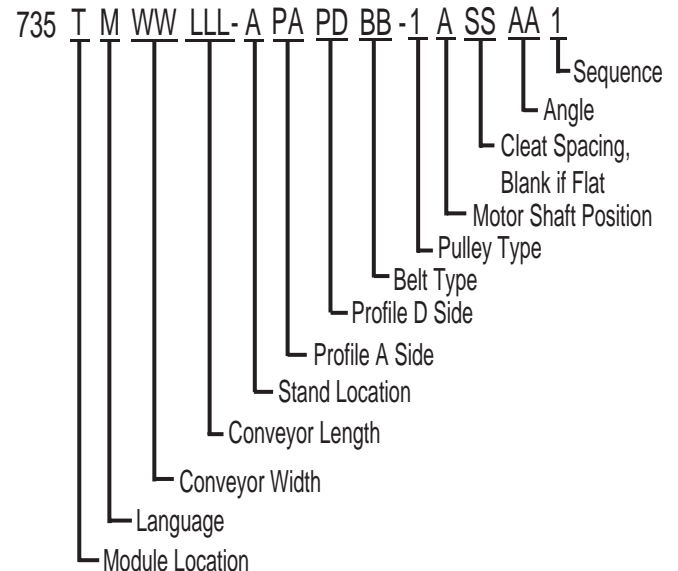
### 7350 Series Mid Section between Knuckle and Curve



### 7350 Series Mid Section between two Knuckles



### 7350 Series Discharge Section from Knuckle



# Specifications

## Conveyor Supports

### Maximum Distances:

1 = Support Stand on Idler End = 30" (762 mm)

2 = Between Support Stands = 8 ft (2438 mm)\*\*

3 = Support Stand on Drive End = 24" (610 mm)

\*\* For conveyors longer than 10 ft (3048 mm),  
install stand mount kit at frame joint.

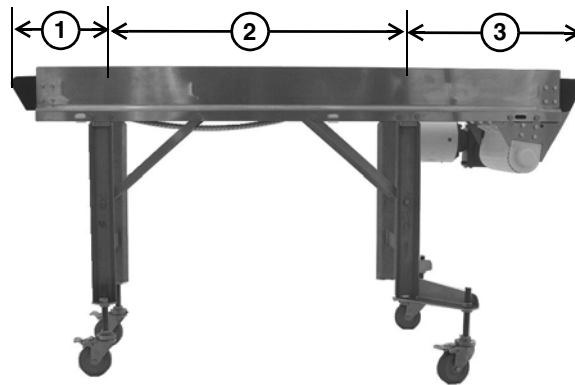


Figure 2

## Specifications

Conveyor Width Reference ( <u>WW</u> )	04 – 36 in 02 increments
Conveyor Belt Width	4" (102 mm) - 36" (914 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft <sup>2</sup> (97 kg/ m <sup>2</sup> ) with a maximum of 750 lbs. (340 kg)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	260 ft/minute (79 m/minute)

Conveyor Length Reference ( <u>LLL</u> )	036 – 999 in 001 increments
Conveyor Length	36" (914 mm) - 999" (25.4 m) in 1" (25 mm) increments

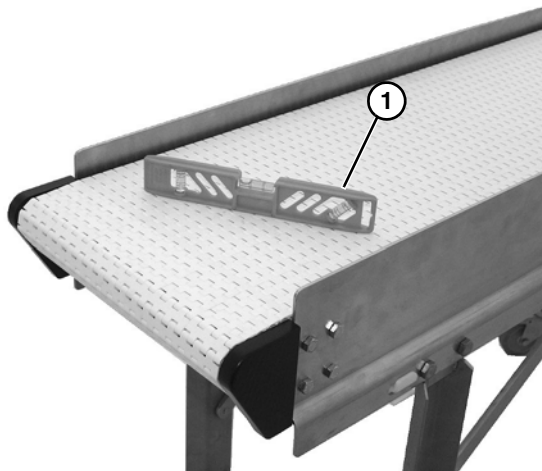
### IMPORTANT

*Maximum conveyor loads are based on:*

- *Non-accumulating product*
- *Product moving toward gearmotor*
- *Conveyor being mounted horizontally*
- *Conveyor being located in a dry environment*
- *Conveyor equipped with standard belt only*

## ⚠ CAUTION

Conveyor **MUST** be mounted straight, flat and level within confines of conveyor. Use a level (Figure 3, item 1) during setup.



**Figure 3**

## Required Tools

- Level
- Torque wrench
- 5/32" hex wrench (for bearings)
- 13 mm wrench (for tail assemblies)
- 14 mm wrench (for motor mounts)
- 17 mm wrench (for stands)

## Recommended Installation Sequence

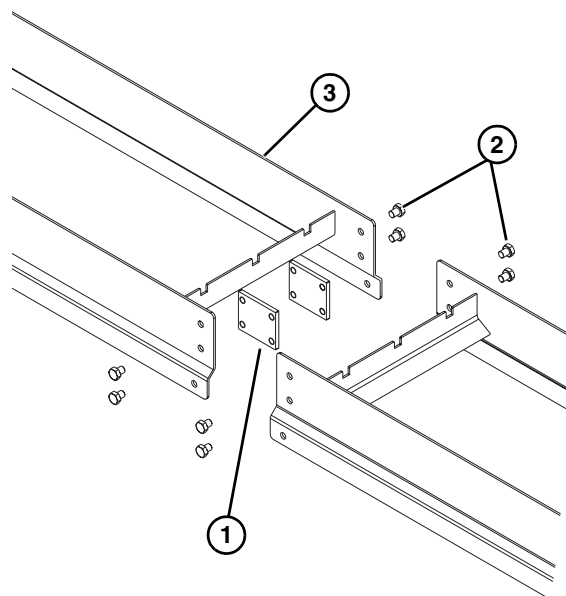
1. Assemble the conveyor (if required). Refer to "Conveyors Longer than 10 ft (3048 mm)" on page 7.
2. Attach the stands. Refer to "Stand Installation" on page 9.
3. Install the belt. Refer to "Belt Installation" on page 9.
4. Install the gearmotor. Refer to "Drive Package Installation" on page 12.

## Conveyors Longer than 10 ft (3048 mm)

### Connecting Components

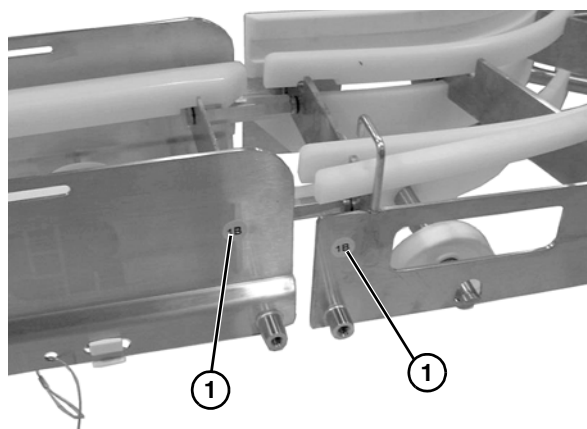
Typical Connecting Components (Figure 4).

- |   |   |
|---|---|
| 1 | Connector Plate (x2)                    |
| 2 | Hex Head Cap Screw M10-1.50 x 12mm (x4) |
| 3 | Conveyor Frames                         |



**Figure 4**

1. Locate and arrange conveyor sections by section labels (Figure 5, item 1).



**Figure 5**

2. Join both conveyor sections, and install plate frame connectors (Figure 4, item 1), and secure with M10x12 hex head cap screws (Figure 4, item 2) on both sides.

# Installation

## Z-Frame Conveyors

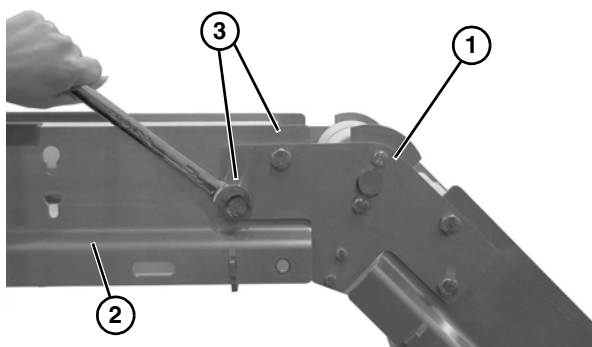
### NOTE

*Be sure all frame sections are properly supported during Z-Frame assembly.*

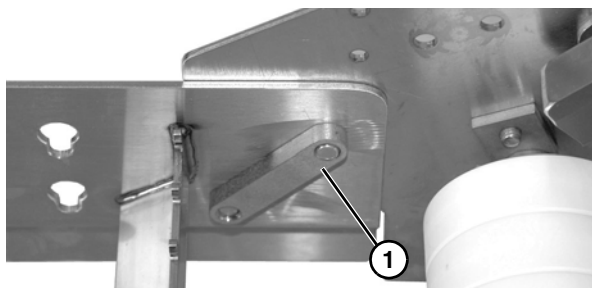
### Knuckles

#### Upper Knuckle

1. Attach upper knuckle (**Figure 6, item 1**) to frame (**Figure 6, item 2**) by using two cap screws (**Figure 6, item 3**) and connector plate (**Figure 7, item 1**) on each side of conveyor.

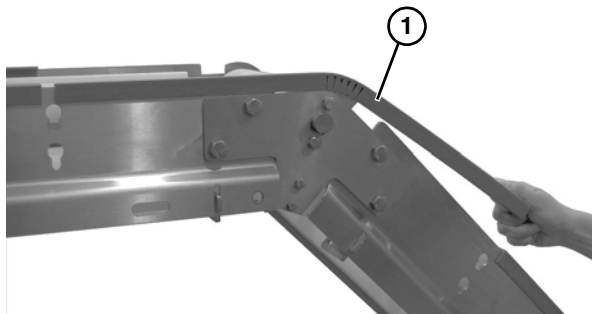


**Figure 6**



**Figure 7**

2. Attach bar cap (**Figure 8, item 1**) to frame and knuckle.

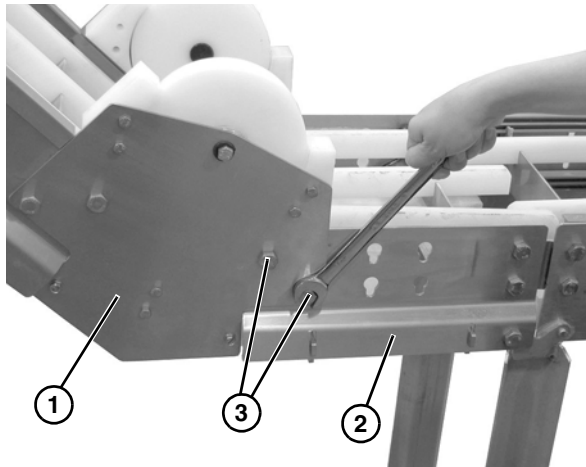


**Figure 8**

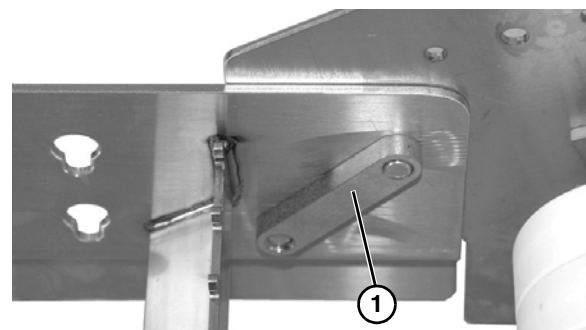
3. Tighten all cap screws to 60 in-lb (7 Nm).

#### Lower Knuckle

1. Attach lower knuckle (**Figure 9, item 1**) to frame (**Figure 9, item 2**) by using two cap screws (**Figure 9, item 3**) and connector plate (**Figure 10, item 1**) on each side of conveyor.



**Figure 9**



**Figure 10**

2. Tighten all cap screws to 60 in-lb (7 Nm).



## All Conveyors

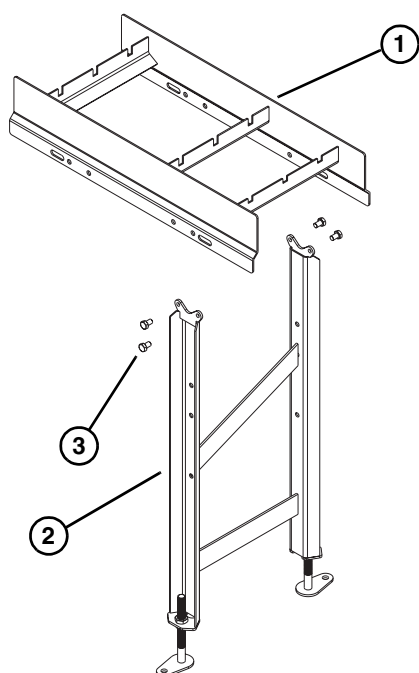
### Stand Installation

#### NOTE

*For detailed assembly instructions, please see support stand manual 851-683.*

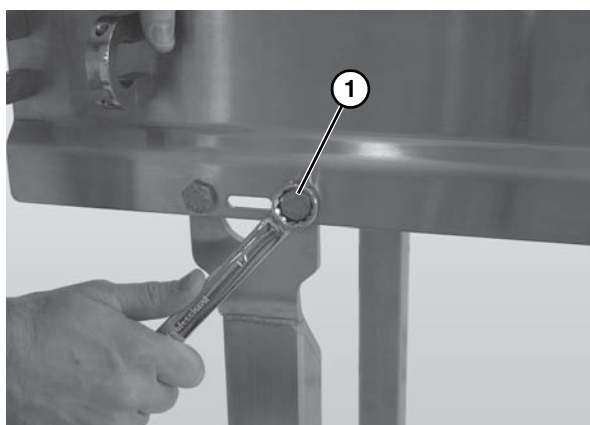
Typical stand components (**Figure 11**)

- |   |  |
|---|--|
| 1 | Conveyor Frame                             |
| 2 | Stand                                      |
| 3 | M10 - 1.5 x 16 mm hex head cap screws (x4) |



**Figure 11**

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame (**Figure 12, item 1**).

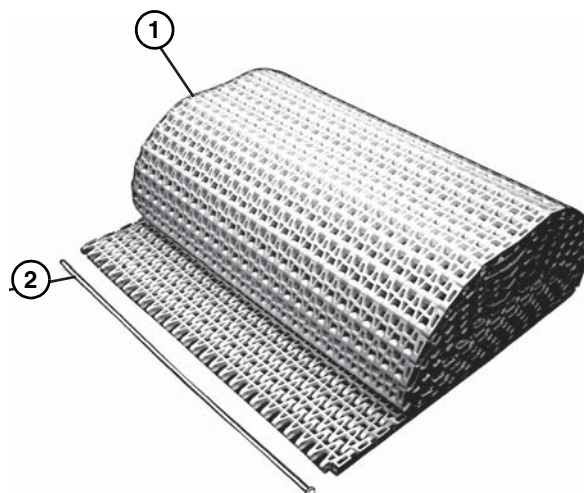


**Figure 12**

## Belt Installation

Typical Belt Components (**Figure 13**)

- |   |            |
|---|------------|
| 1 | Chain Belt |
| 2 | Belt Rod   |



**Figure 13**

1. Position the belt on the conveyor frame (**Figure 14**).



**Figure 14**

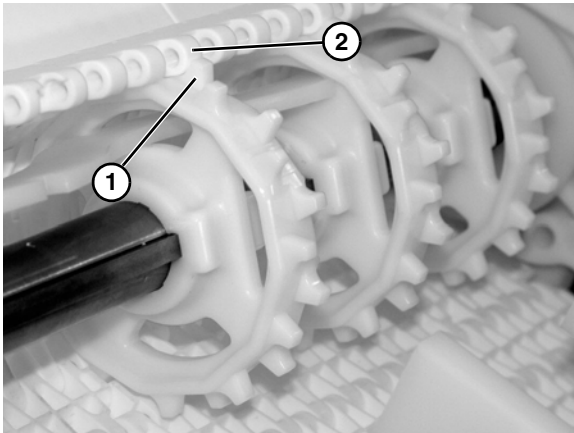
2. Wrap belt around idler tail.

---

# Installation

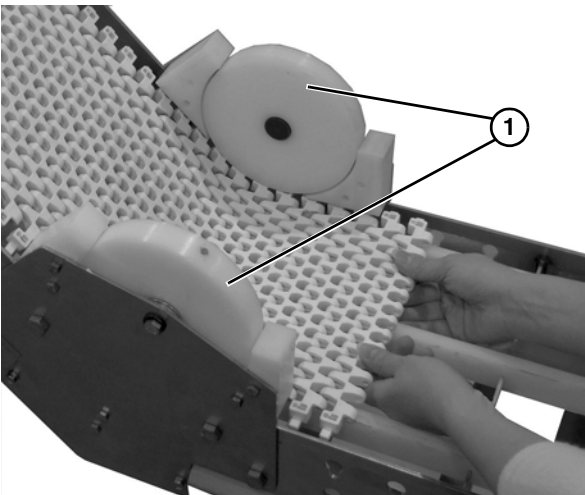
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3. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth (**Figure 15, item 1**) mating with rounded section (**Figure 15, item 2**) of belt.



**Figure 15**

4. For Z-Frame conveyors, guide the belt under the hold down guides (**Figure 16, item 1**) in the lower knuckle.



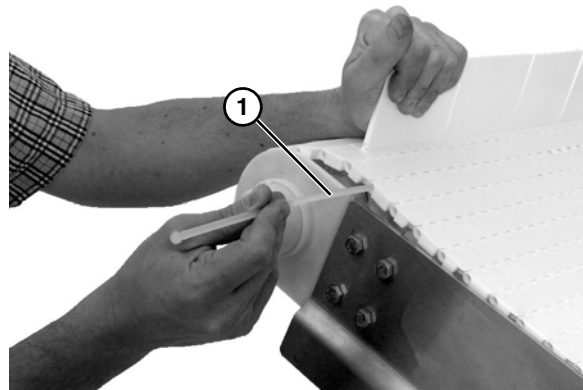
**Figure 16**

5. Bring the ends of the belt together (**Figure 17**).



**Figure 17**

6. Insert the belt rod (**Figure 18, item 1**).



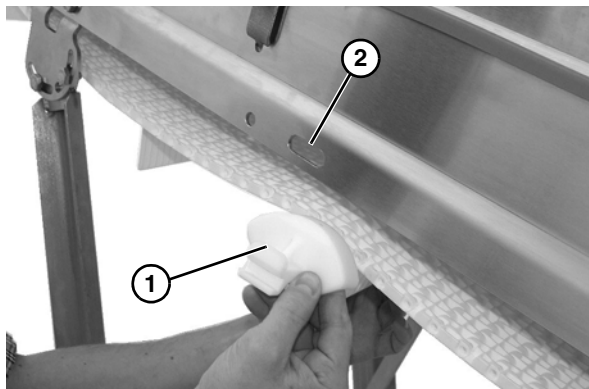
**Figure 18**

7. Push the belt rod in as far as possible.
8. Lightly tap the head of the rod with a hammer until it snaps into position.

## Belt Returns

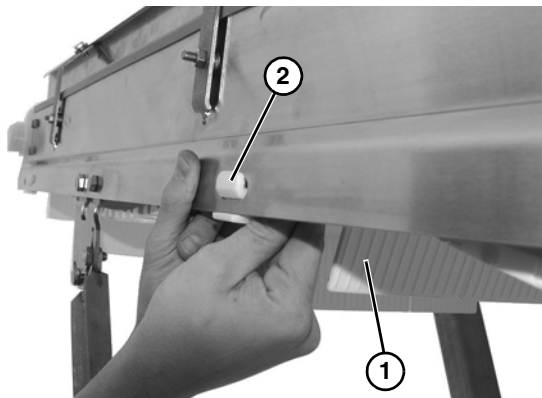
### Returns for conveyors up to 24" wide

1. Install belt return (**Figure 19, item 1**) into slotted frame hole (**Figure 19, item 2**).



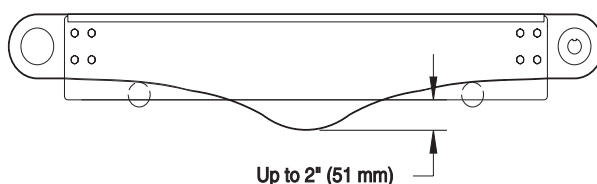
**Figure 19**

2. Install belt (Figure 20, item 1) around lower frame section and above lower wear strip (Figure 20, item 2).



**Figure 20**

1. Check belt sag by measuring from the bottom of conveyor frame (Figure 21). Belt sag should not exceed 2" (51 mm).



**Figure 21**

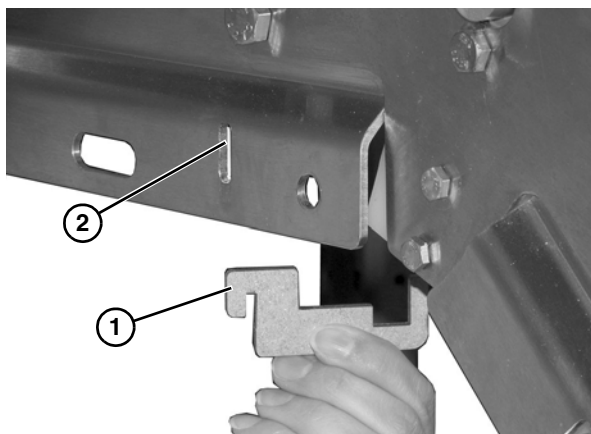


## CAUTION

Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame.

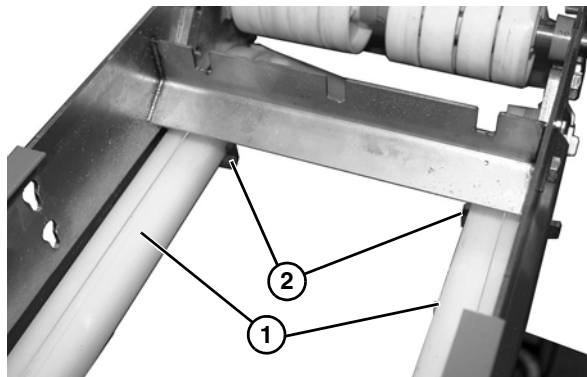
### Returns for conveyors 26" - 36" wide

1. Install belt return mounting bracket (Figure 22, item 1) into slotted frame hole (Figure 22, item 2).



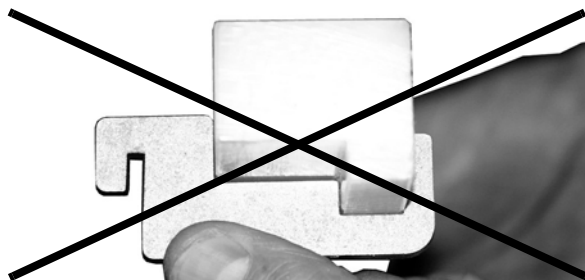
**Figure 22**

2. Install belt return (Figure 23, item 1) onto mounting bracket (Figure 23, item 2).

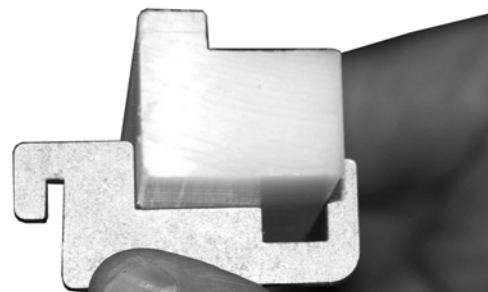


**Figure 23**

3. Verify that belt returns are mounted correctly by following graphic below (Figure 24) shows incorrect mounting and (Figure 25) shows correct mounting.



**Figure 24**

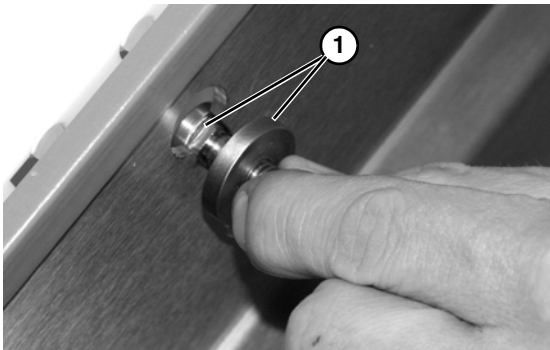


**Figure 25**

# Installation

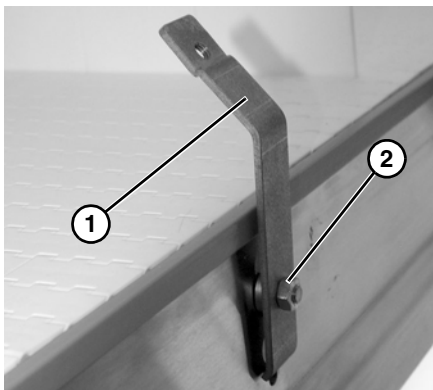
## Guide Installation

1. Insert carriage bolts with spacers (**Figure 26, item 1**) into slotted holes in conveyor side.



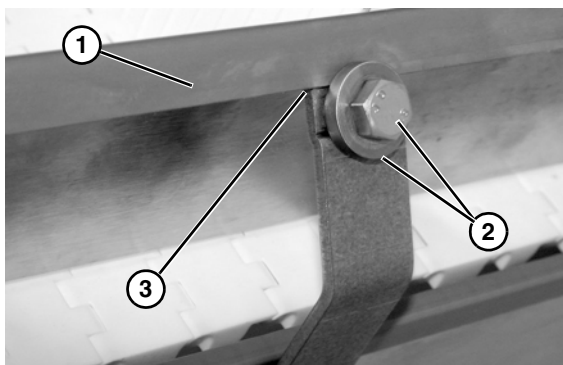
**Figure 26**

2. Attach the guide mounting brackets (**Figure 27, item 1**) to the conveyor with hex nuts (**Figure 27, item 2**). Hand tighten only at this time.



**Figure 27**

3. Attach guide (**Figure 28, item 1**) to the mounting brackets with hex bolts and spacers (**Figure 28, item 2**). Hand tighten only at this time.



**Figure 28**

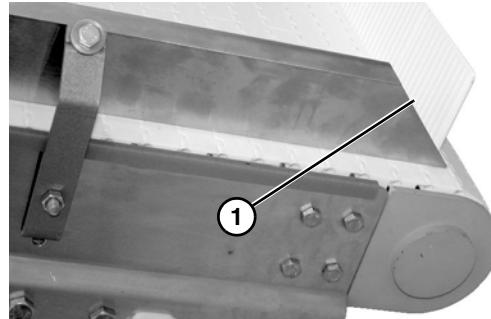
4. Ensure that nose of bracket slips under the lip of guide (**Figure 28, item 3**).

### NOTE

*Adjust guides to provide clearance between guides and belt.*

### NOTE

*When installing guides, be sure that the angled end of guide is installed on the idler end of conveyor (**Figure 29, item 1**).*



**Figure 29**

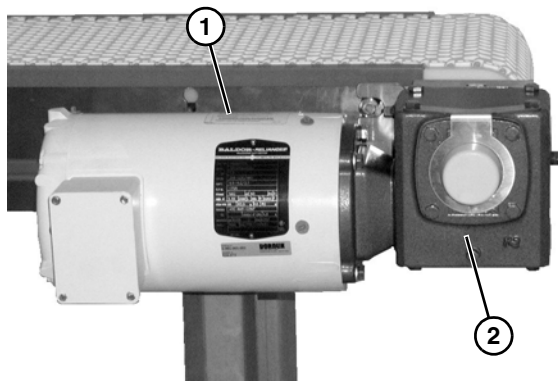
5. Tighten all mounting hardware.

## Drive Package Installation

For detailed assembly instructions, refer to the appropriate Drive Packages Manual:

- 851-679 Side Mount 90° Drive Package
- 851-681 Bottom Mount 90° Drive Package
- 851-682 Bottom Mount Parallel Shaft Drive Package

1. Attach the motor (**Figure 30, item 1**) to the gear reducer (**Figure 30, item 2**).



**Figure 30**

---

# Preventive Maintenance and Adjustment

---

## Required Tools

- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- Punch and hammer (to remove belt rod)

## Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 22 for recommendations.
- Replace any worn or damaged parts.

## Cleaning

### NOTE

*Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.*



### CAUTION

Dorner recommends cleaning all the "food zones" prior to placing conveyor into service. Ensure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.



### WARNING



### SEVERE HAZARD!

**LOCK OUT POWER** before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

## Maintaining the Conveyor Belt

### Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

Damage to belt links or rods, surface cuts and / or wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories

Skipping indicates:

- Excessive load on belt
- Worn spindle or impacted dirt on drive spindle

## Lubrication

No lubrication is required. Replace bearings if worn.

# Preventive Maintenance and Adjustment

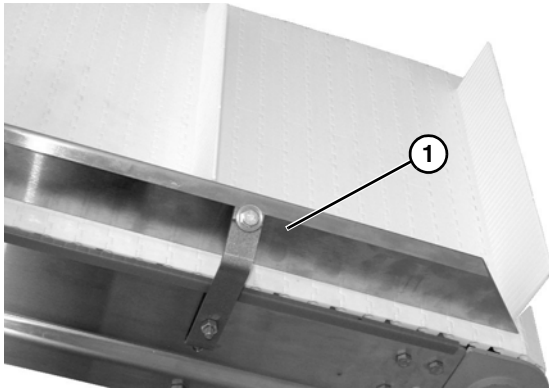
## Conveyor Belt Replacement

### **⚠ WARNING**



**SEVERE HAZARD!**  
**LOCK OUT POWER** before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

1. Remove guides (**Figure 31**, item 1) when required.



**Figure 31**

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head (**Figure 32**).



**Figure 32**

3. Slide the old belt off the conveyor frame.
4. Replace the old belt with a new one. Refer to "Belt Installation" on page 9.

### **⚠ CAUTION**

**DO NOT** reuse belt rods that are damaged or show signs of wear.

## Conveyor Belt Tensioning

### **⚠ WARNING**

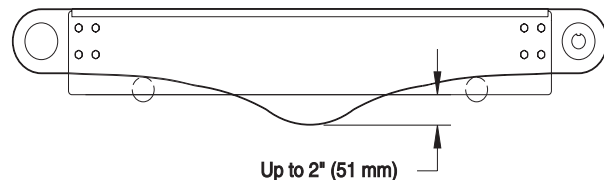


**SEVERE HAZARD!**  
**LOCK OUT POWER** before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

### **NOTE**

*Belt should not be stretched during installation. A proper length of belt can be installed by interlocking the ends by hand without excess links.*

1. Remove one or more belt links to take up tension.



**Figure 33**

### **⚠ CAUTION**

**Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame (Figure 33).**



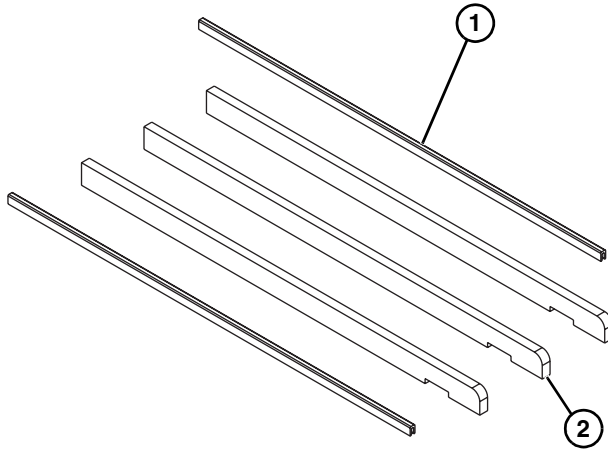
# Preventive Maintenance and Adjustment

## Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips (**Figure 34**)

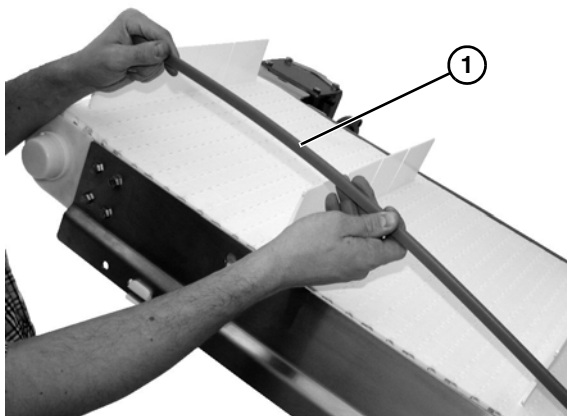
- |   |                        |
|---|------------------------|
| 1 | Bar Cap                |
| 2 | Wear Strips, Bed Frame |



**Figure 34**

## Bar Cap Replacement

1. Remove worn bar cap (**Figure 35, item 1**) by lifting off of conveyor side rail.

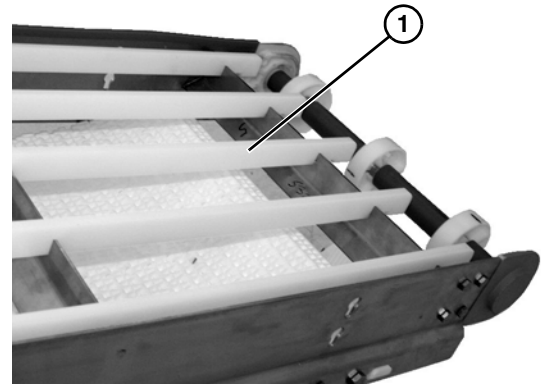


**Figure 35**

2. Replace with new bar cap.

## Wear Strip Removal

1. Remove conveyor belt. See “Conveyor Belt Replacement” on page 14.
2. Remove worn wear strips (**Figure 36, item 1**) from frame notches.



**Figure 36**

3. Replace with new wear strips.

## Drive Sprocket and Spindle Replacement

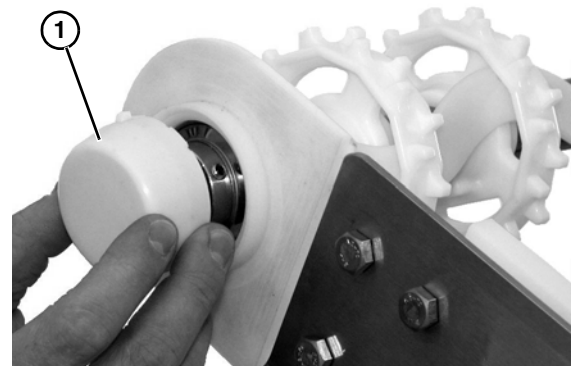
### **WARNING**



#### **SEVERE HAZARD!**

**Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.**

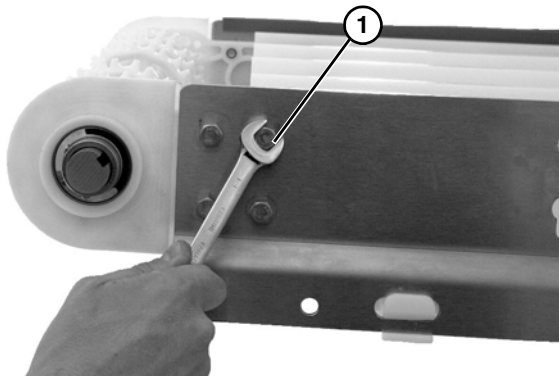
1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Open conveyor belt. See “Conveyor Belt Replacement” on page 14.
3. Remove bearing cover (**Figure 37, item 1**).



**Figure 37**

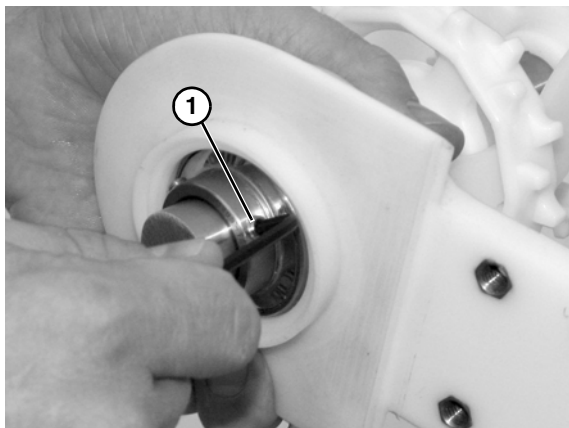
# Preventive Maintenance and Adjustment

4. Remove the four head plate bolts (**Figure 38, item 1**) on both sides of the conveyor.



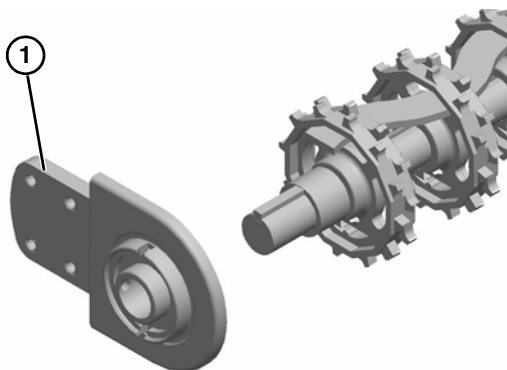
**Figure 38**

5. Remove tail assembly.
6. Loosen set screws (**Figure 39, item 1**).



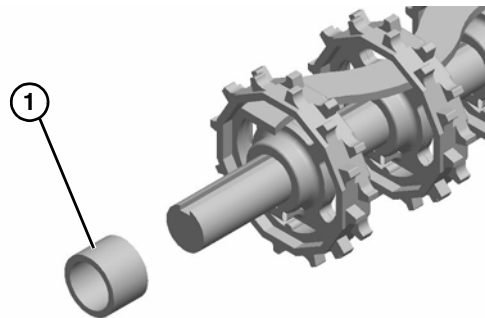
**Figure 39**

7. Slide the head plate with bearing (**Figure 40, item 1**) off the shaft.



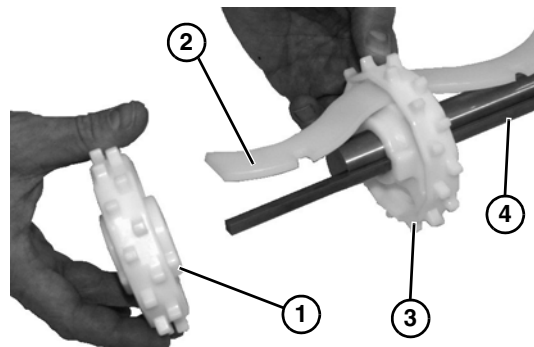
**Figure 40**

8. Slide off drive sprocket spacer (**Figure 41, item 1**).



**Figure 41**

9. Slide entire sprocket assembly slightly outward, and remove the first sprocket (**Figure 42, item 1**) off the drive spindle and alignment bar (**Figure 42, item 2**).



**Figure 42**

10. Remove remaining sprockets (**Figure 42, item 3**) off the alignment bar as you slide entire assembly off the drive spindle (**Figure 42, item 4**).

## NOTE

To reassemble please note the placement of the sprockets on the alignment key.



# Preventive Maintenance and Adjustment

## Idler Puck and Spindle Replacement

### **WARNING**



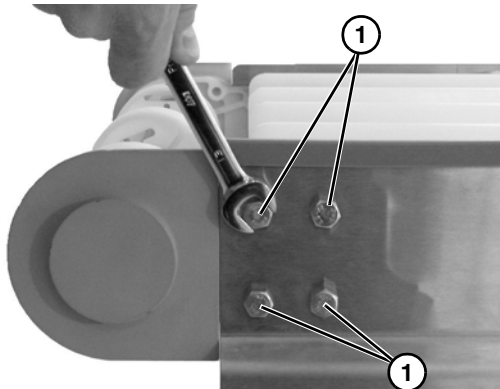
#### **SEVERE HAZARD!**

Exposed moving parts can cause severe injury. **LOCK OUT POWER** before removing guards or performing maintenance.

### **NOTE**

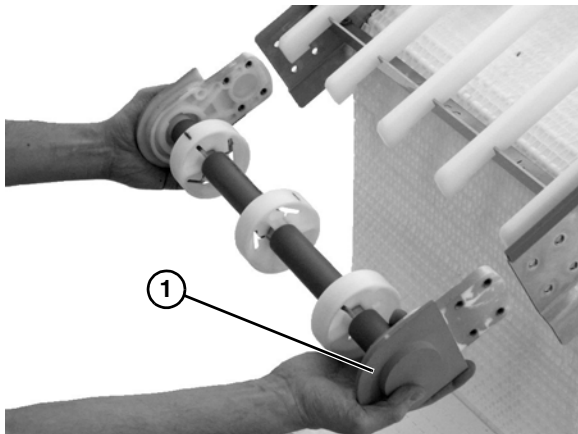
*Idler tails are equipped with plain bushing pucks, replace when worn.*

1. Open conveyor belt. See “Conveyor Belt Replacement” on page 14.
2. Remove four head plate bolts (Figure 43, item 1). Repeat on opposite side.



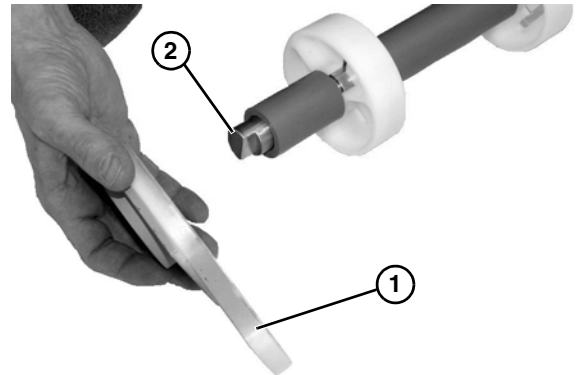
**Figure 43**

3. Remove idler tail assembly (Figure 44, item 1).



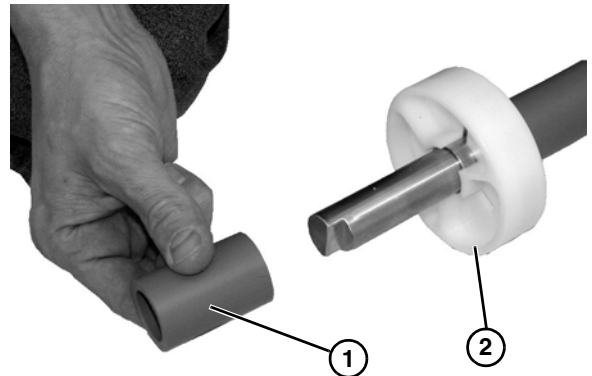
**Figure 44**

4. Slide off idler head plate (Figure 45, item 1) from shaft (Figure 45, item 2).



**Figure 45**

5. Slide off the round puck spacer (Figure 46, item 1).



**Figure 46**

6. Slide off puck and replace (Figure 46, item 2).
7. Repeat as needed.

# Preventive Maintenance and Adjustment

## Nose Bar Idler Spindle Replacement

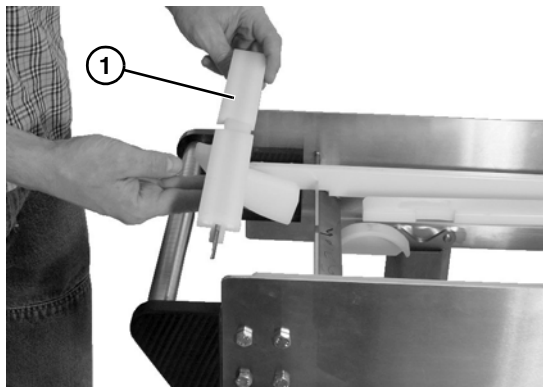
### **WARNING**



#### **SEVERE HAZARD!**

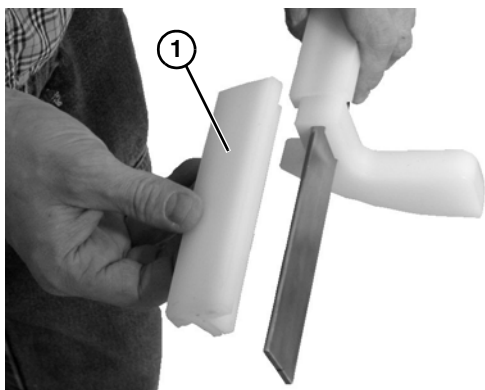
**Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.**

1. Open conveyor belt. See “Conveyor Belt Replacement” on page 14.
2. Remove the nose bar idler bar with wear strips and idler shoe attached (**Figure 47, item 1**).



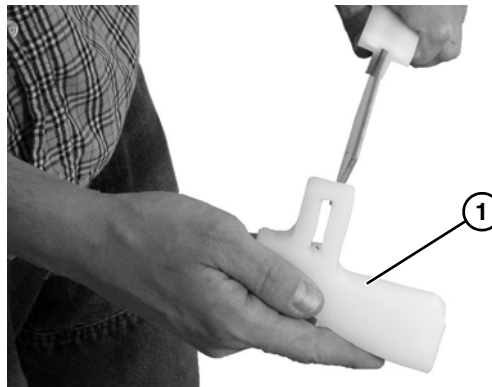
**Figure 47**

3. Remove and replace wear strips if worn (**Figure 48, item 1**).



**Figure 48**

4. Remove and replace nose bar idler shoe if worn (**Figure 49, item 1**).



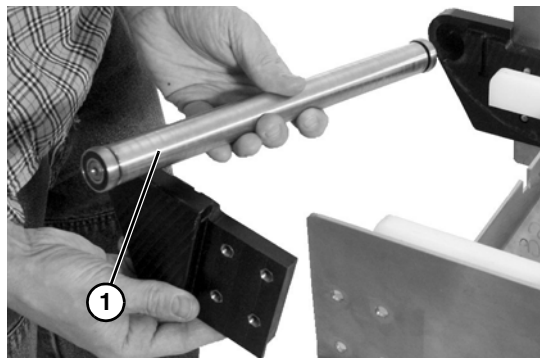
**Figure 49**

5. Remove four head plate bolts (**Figure 50, item 1**).



**Figure 50**



6. Slide off idler roller bearing assembly (**Figure 51, item 1**).




**Figure 51**

# Preventive Maintenance and Adjustment

## Bearing Replacement

 <b>WARNING</b>

Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.

## Drive Bearing Removal and Replacement

 <b>WARNING</b>

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. See “Drive Sprocket and Spindle Replacement” on page 15. Follow steps 1 through 7.
2. Twist the bearing out (**Figure 52, item 1**).

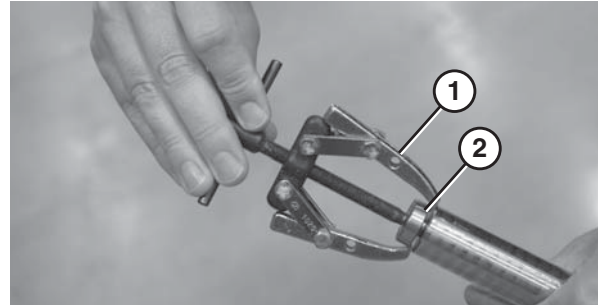


**Figure 52**

3. Replace bearing.

## Idler Bearing Removal and Replacement

1. See “Nose Bar Idler Spindle Replacement” on page 18. Follow steps 1 through 6.
2. Using a bearing removal tool (**Figure 53, item 1**) remove the bearing (**Figure 53, item 2**).



**Figure 53**

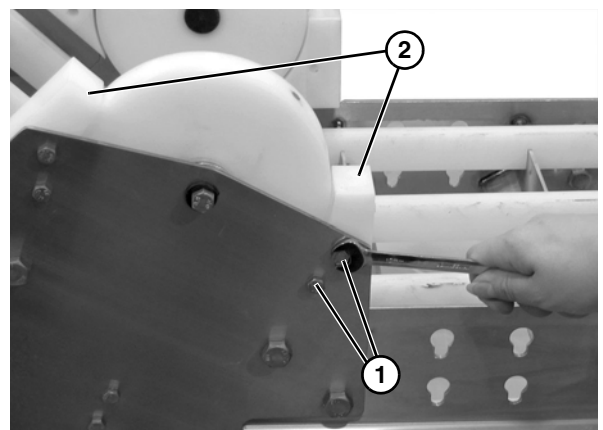
3. Press on new bearing.

 <b>CAUTION</b>
Press on inner race only, pressing on outer race could damage bearing.

## Maintenance of Knuckles

### Lower Knuckle

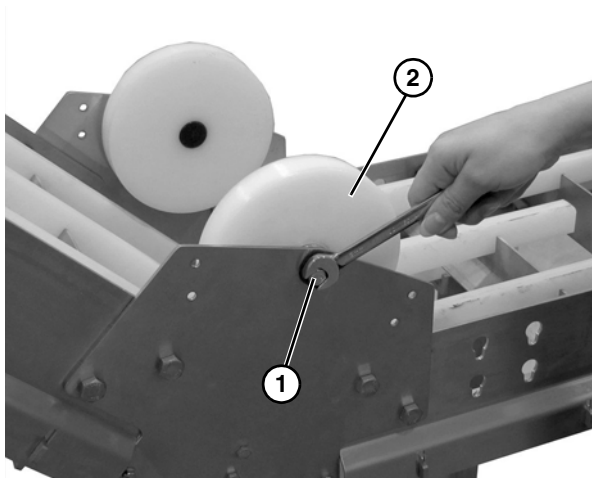
1. Remove belt. See “Conveyor Belt Replacement” on page 14.
2. Remove two cap screws (**Figure 54, item 1**) on each side of the knuckle and remove the hold down roller guards (**Figure 54, item 2**). Repeat on opposite side of the conveyor.



**Figure 54**

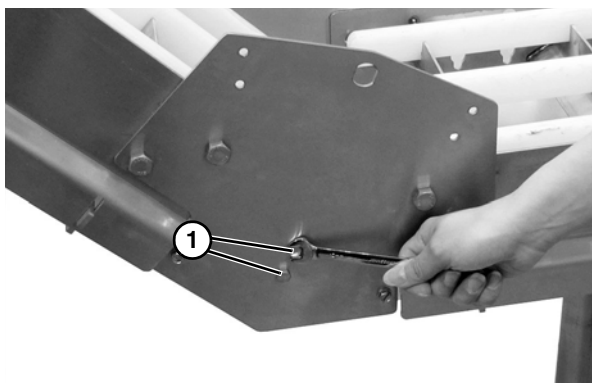
# Preventive Maintenance and Adjustment

3. Remove the cap screw (**Figure 55, item 1**) and the hold down roller (**Figure 55, item 2**). Repeat on opposite side of the conveyor.

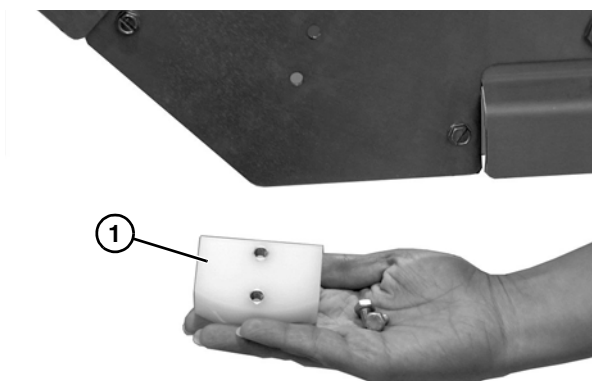


**Figure 55**

4. Remove two cap screws (**Figure 56, item 1**) and the inner belt return guide (**Figure 57, item 1**). Repeat on opposite side of the conveyor.



**Figure 56**

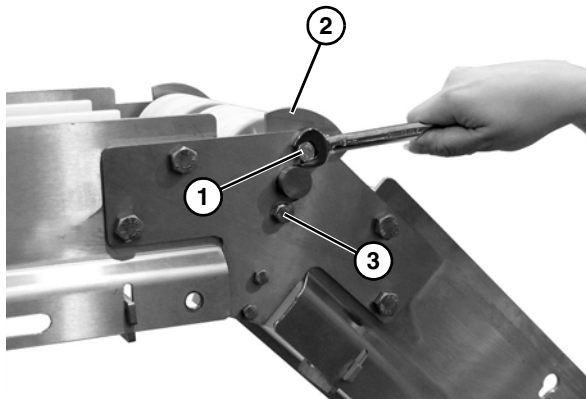


**Figure 57**

5. Replace parts as necessary.
6. Install parts reverse of removal.

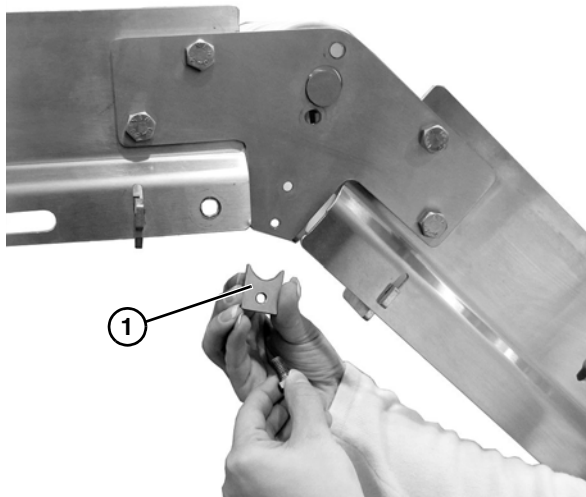
## Upper Knuckle

1. Remove belt. See “Conveyor Belt Replacement” on page 14.
2. Remove cap screw (**Figure 58, item 1**) and edge guide plate (**Figure 58, item 2**) from each side of the conveyor.



**Figure 58**

3. Remove the cap screw (**Figure 58, item 3**) and shaft clamp (**Figure 59, item 1**) from each side of the conveyor.



**Figure 59**

# Preventive Maintenance and Adjustment

- Slide shaft (**Figure 60, item 1**) inwards to remove from knuckle frame (**Figure 61, item 1**).
- Remove two cap screws (**Figure 63, item 1**) and inner belt return guide (**Figure 64, item 1**). Repeat on opposite side of the conveyor.

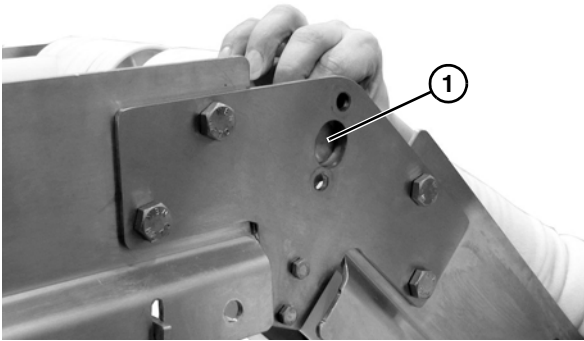


Figure 60

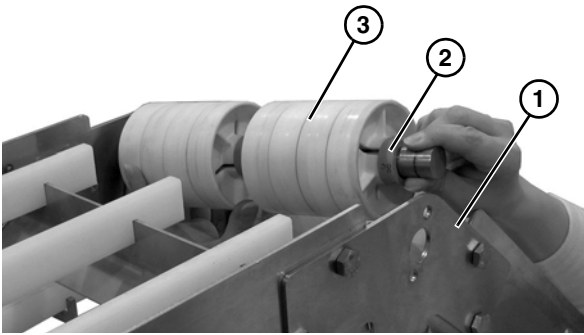


Figure 61

## NOTE

Spacer (**Figure 61, item 2**) and pucks (**Figure 61, item 3**) are loose and can slide off the shaft.

- Remove spacer (**Figure 62, item 1**), rollers (**Figure 62, item 2**) and tube spacers (**Figure 62, item 3**) from shaft.

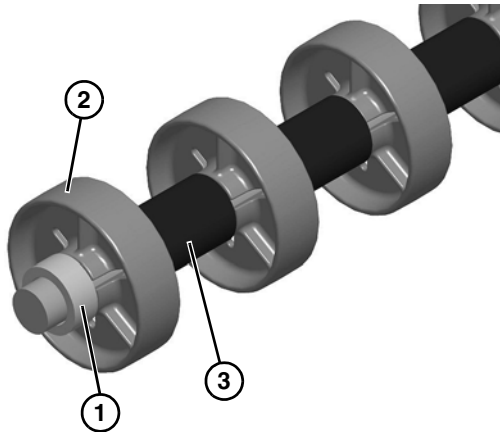


Figure 62

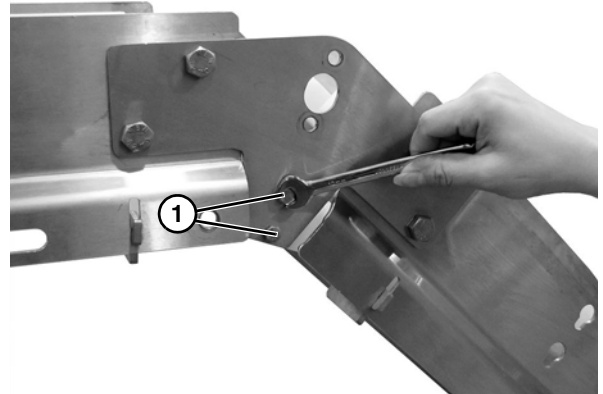


Figure 63

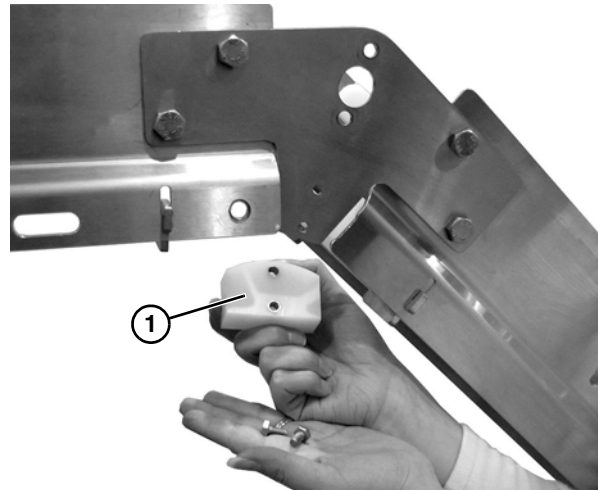



Figure 64

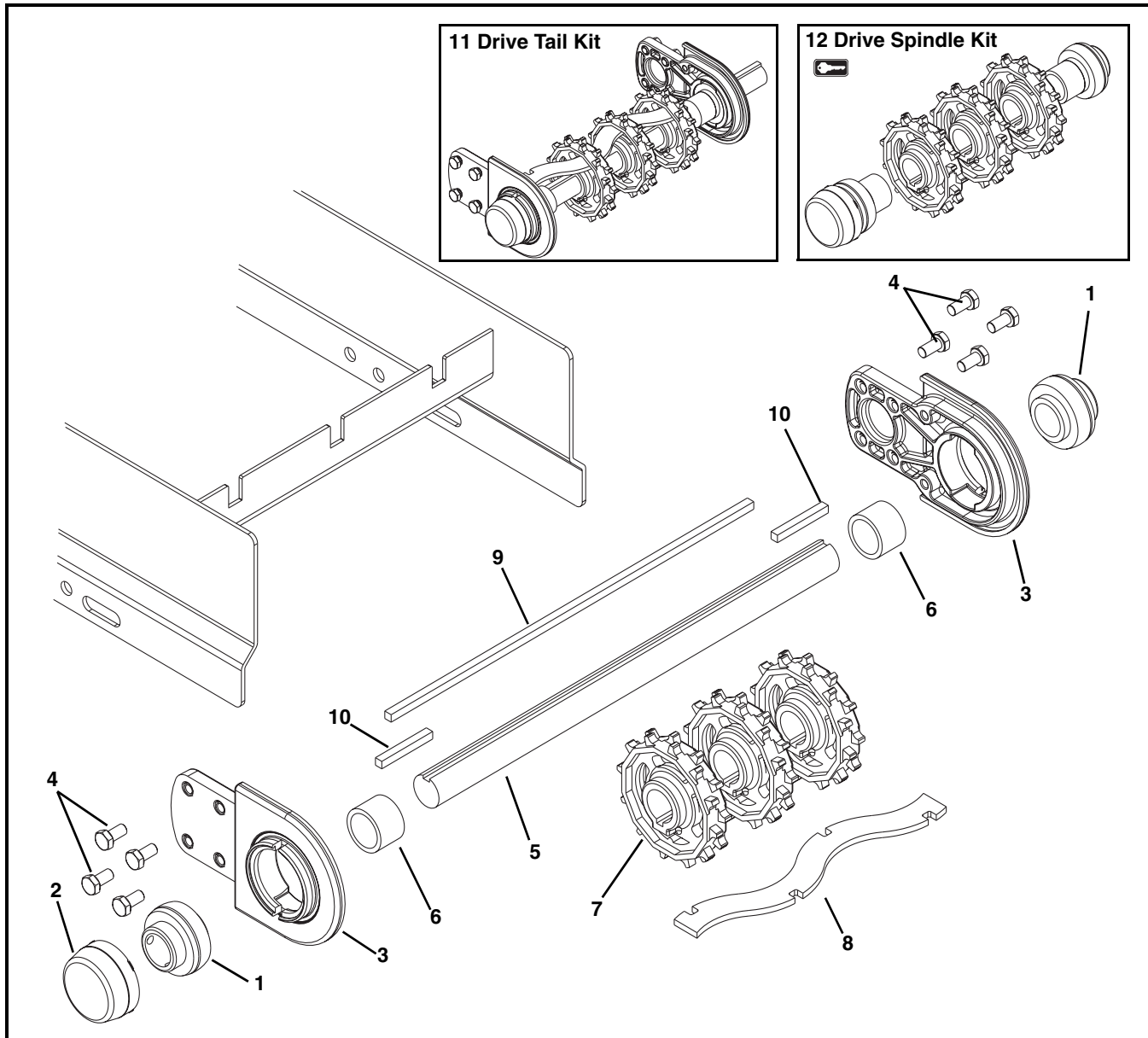
- Replace parts as necessary.
- Install parts reverse of removal.

# Service Parts

## NOTE

For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory. Key Service Parts and Kits are identified by the Performance Parts Kits logo . Dorner recommends keeping these parts on hand.

## Drive End Components





# Service Parts

Item	Part Number	Description
1	735BK	Bearing Kit (Qty. 2)
2*	807-1454	Bearing Cap
3	532011	Headplate
4	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
5	See Drive Spindle Chart	Spindle
6	532251-LLLL	Sprocket Spacer
7	807-1754	Sprocket
8	532124-WW	Sprocket Alignment Bar
9	532121-LLLL	Square Key
10	912-110SS	Square Key

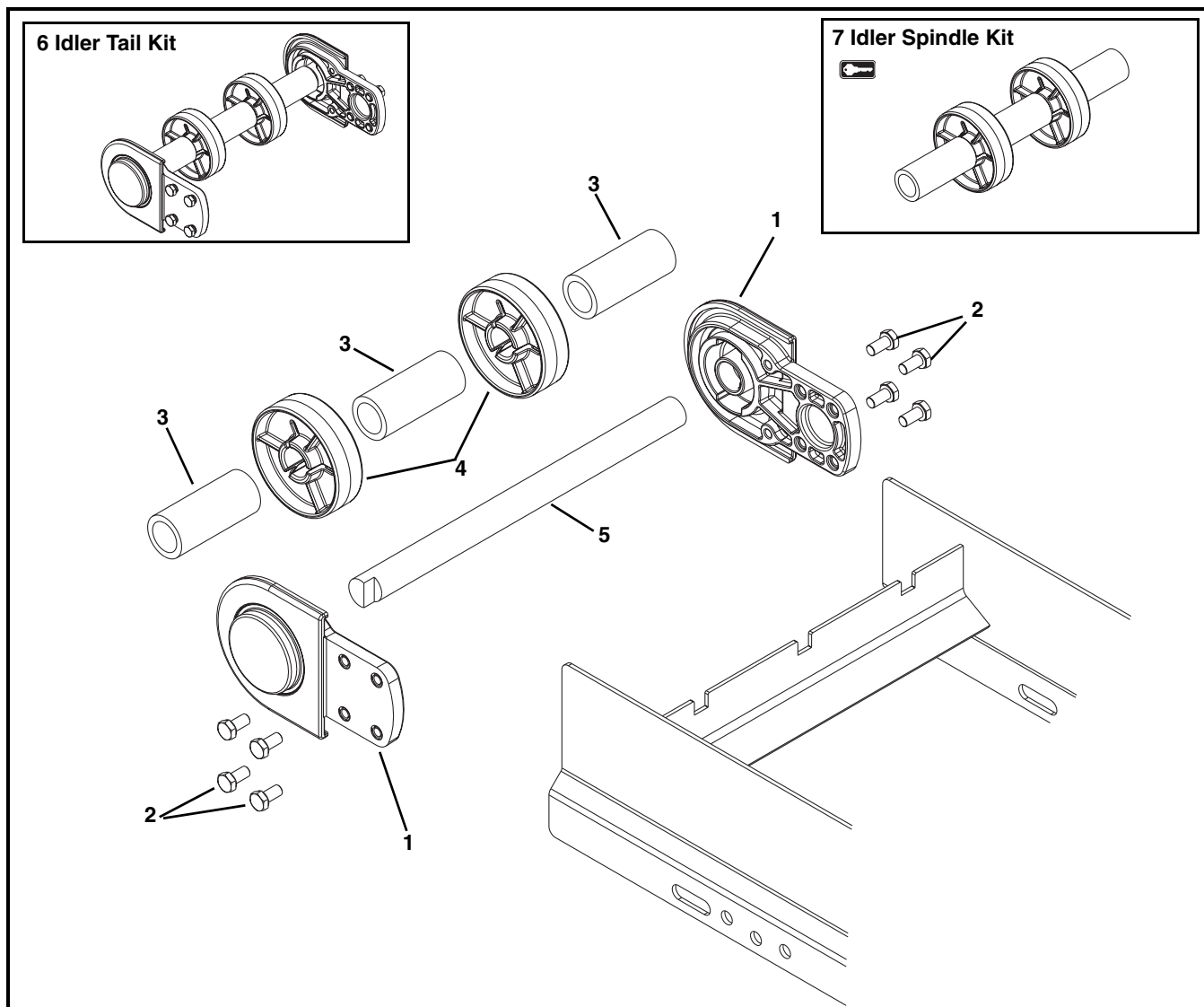
Item	Part Number	Description
11	735BDT-WW	Drive Tail Kit for Bottom Mount (Includes items 1 through 10)
	735SDT-WW	Drive Tail Kit for Side Mount (Includes items 1 through 10)
	735DBDT-WW	Drive Tail Kit for Bottom Mount with Double Output Shafts (Includes items 1 through 10)
	735DSDT-WW	Drive Tail Kit for Side Mount with Double Output Shafts (Includes items 1 through 10)
	735USDT-WW	CE Drive Tail Kit for Side Mount (Includes items 1 through 10)
	735UDSDT-WW	CE Drive Tail Kit for Side Mount with Double Output Shafts (Includes items 1 through 10)
12	735DS-WW	Drive Spindle Kit (Includes items 1, 2, 6, and 7)
WW = Conveyor width reference: 04 – 36 in 02 increments		
LLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLL = 09525		
* Not available with double output shafts		

Drive Spindle Chart - US Gearmotor Version				
Conveyor Width	Bottom Mount	Side Mount	Bottom Mount with Double Output Shaft	Side Mount with Double Output Shaft
4"	532113-00743	532232-01344	532113-00899	532232-01500
6"	532113-00943	532232-01544	532113-01099	532232-01700
8"	532113-01143	532232-01744	532113-01299	532232-01900
10"	532113-01341	532232-01942	532113-01497	532232-02098
12"	532113-01538	532232-02139	532113-01694	532232-02295
14"	532113-01736	532232-02337	532113-01892	532232-02493
16"	532113-01933	532232-02534	532113-02089	532232-02690
18"	532113-02131	532232-02732	532113-02287	532232-02888
20"	532113-02328	532232-02929	532113-02484	532232-03085
22"	532113-02526	532232-03127	532113-02682	532232-03283
24"	532113-02723	532232-03324	532113-02879	532232-03480
26"	532113-02921	532232-03522	532113-03077	532232-03678
28"	532113-03118	532232-03719	532232-03719	532232-03875
30"	532113-03316	532232-03917	532113-03472	532232-04073
32"	532113-03513	532232-04114	532113-03669	532232-04270
34"	532113-03711	532232-04312	532113-03867	532232-04468
36"	532113-03908	532232-04509	532113-04064	532232-04665

Drive Spindle Chart - CE Gearmotor Version				
Conveyor Width	Bottom Mount	Side Mount	Bottom Mount with Double Output Shaft	Side Mount with Double Output Shaft
4"	532113-00743	532291-01147	532113-00899	532291-01303
6"	532113-00943	532291-01347	532113-01099	532291-01503
8"	532113-01143	532291-01547	532113-01299	532291-01703
10"	532113-01341	532291-01745	532113-01497	532291-01901
12"	532113-01538	532291-01942	532113-01694	532291-02098
14"	532113-01736	532291-02140	532113-01892	532291-02296
16"	532113-01933	532291-02337	532113-02089	532291-02493
18"	532113-02131	532291-02535	532113-02287	532291-02691
20"	532113-02328	532291-02732	532113-02484	532291-02888
22"	532113-02526	532291-02930	532113-02682	532291-03086
24"	532113-02723	532291-03127	532113-02879	532291-03283
26"	532113-02921	532291-03325	532113-03077	532291-03481
28"	532113-03118	532291-03522	532113-03274	532291-03678
30"	532113-03316	532291-03720	532113-03472	532291-03876
32"	532113-03513	532291-03917	532113-03669	532291-04073
34"	532113-03711	532291-04115	532113-03867	532291-04271
36"	532113-03908	532291-04312	532113-04064	532291-04468

# Service Parts

## Idler End Components

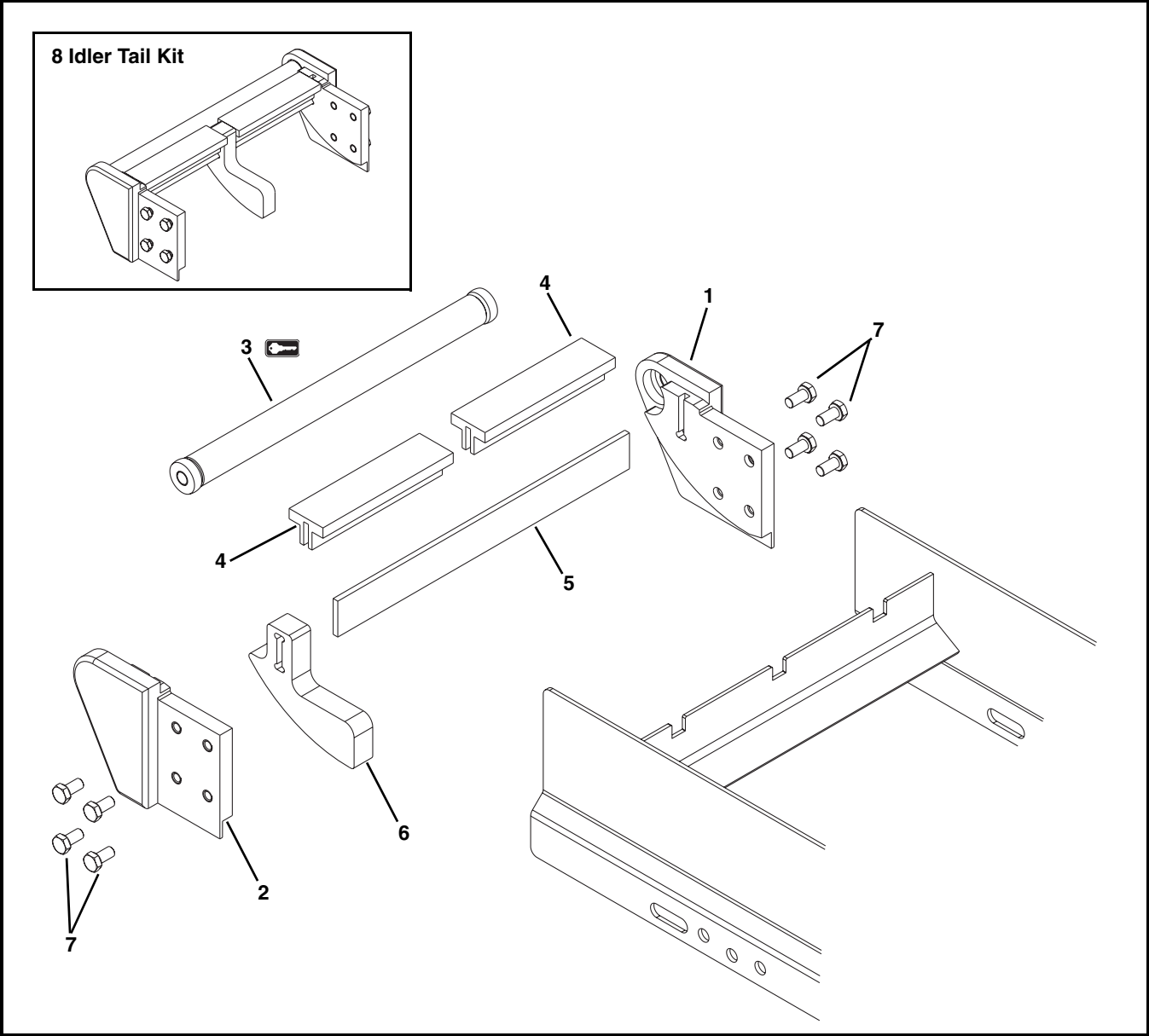


Item	Part Number	Description
1	532012	Headplate Assembly
2	960816M	Hex Head Cap Screw, M8-1.25 x 16 mm
3	532127- <u>LLLLL</u>	Tube Spacer
4	506296	Idler Puck
5	See Idler Spindle Chart	Spindle
6	735IT- <u>WW</u>	Idler Tail Kit (Includes items 1 through 5)
7	735IS- <u>WW</u>	Idler Spindle Kit (Includes items 3 and 4)
<u>WW</u> = Conveyor width reference: 04 – 36 in 02 increments		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		

Idler Spindle Chart	
Conveyor Width	Spindle
4"	532118-00412
6"	532118-00612
8"	532118-00812
10"	532118-01010
12"	532118-01207
14"	532118-01405
16"	532118-01602
18"	532118-01800
20"	532118-01997
22"	532118-02195
24"	532118-02392
26"	532118-02590
28"	532118-02787
30"	532118-02985
32"	532118-03182
34"	532118-03380
36"	532118-03577



Nose Bar Idler End Components

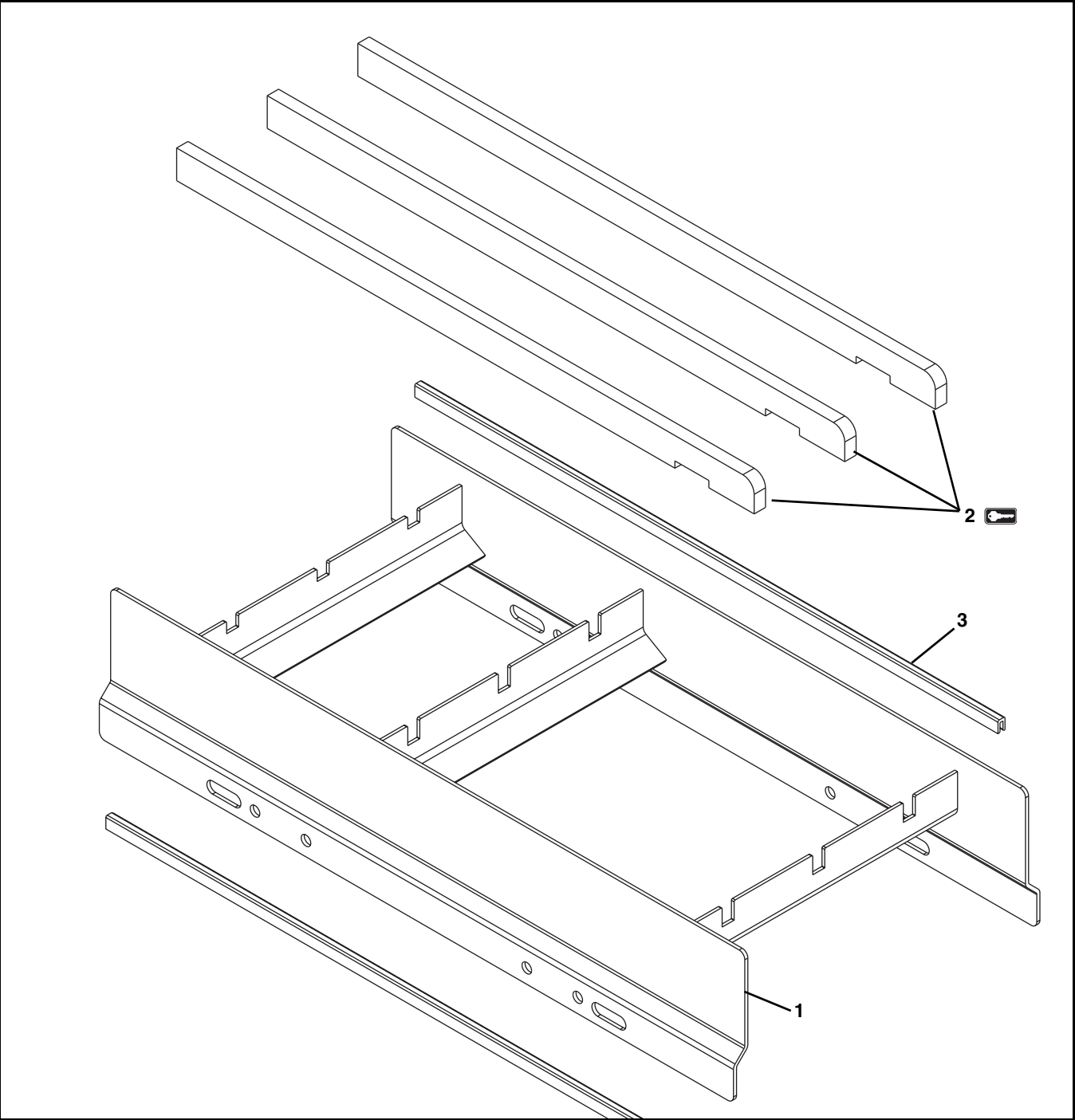



Item	Part Number	Description
1	532025	Nosebar Headplate Right Hand
2	532026	Nosebar Headplate Left Hand
3	735NBK- <u>WW</u>	Bearing Kit
4	532170- <u>LLLLL</u>	Wear Strip
5	532135- <u>WW</u>	Nosebar Idler Bar

Item	Part Number	Description
6	532139	Nosebar Idler Shoe
7	960816M	Hex Head Cap Screw, M8-1.25 x 16 mm
8	735NBT- <u>WW</u>	Nose Bar Idler Tail Kit (Includes items 1 through 7)
<u>WW</u> = Conveyor width reference: 04 – 36 in 02 increments		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		

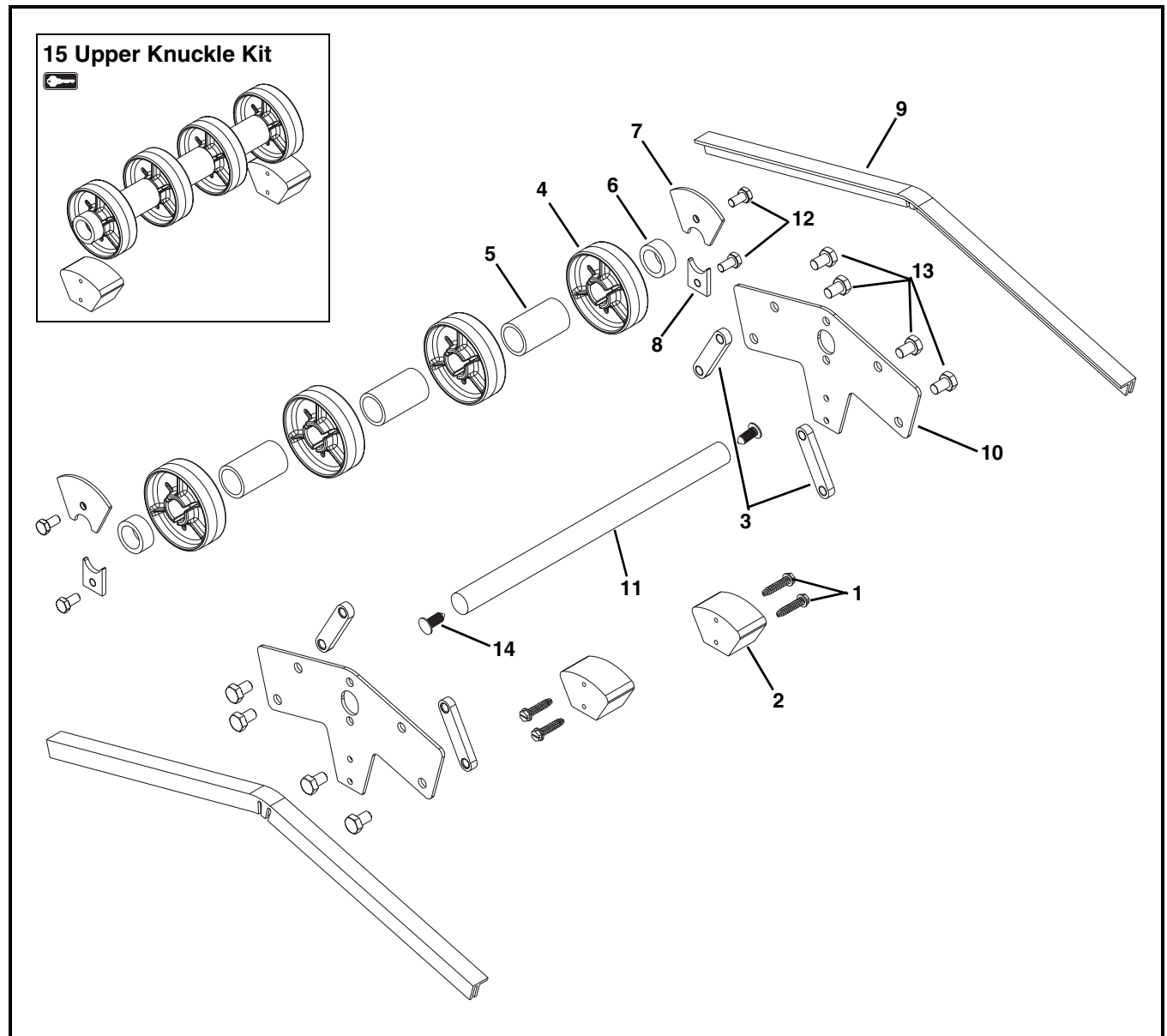
# Service Parts

## Frame Assembly



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	532223- <u>LLLLL</u>	Wear Strip
		
3	532225- <u>LLLLL</u>	Bar Cap
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

## Upper Knuckle

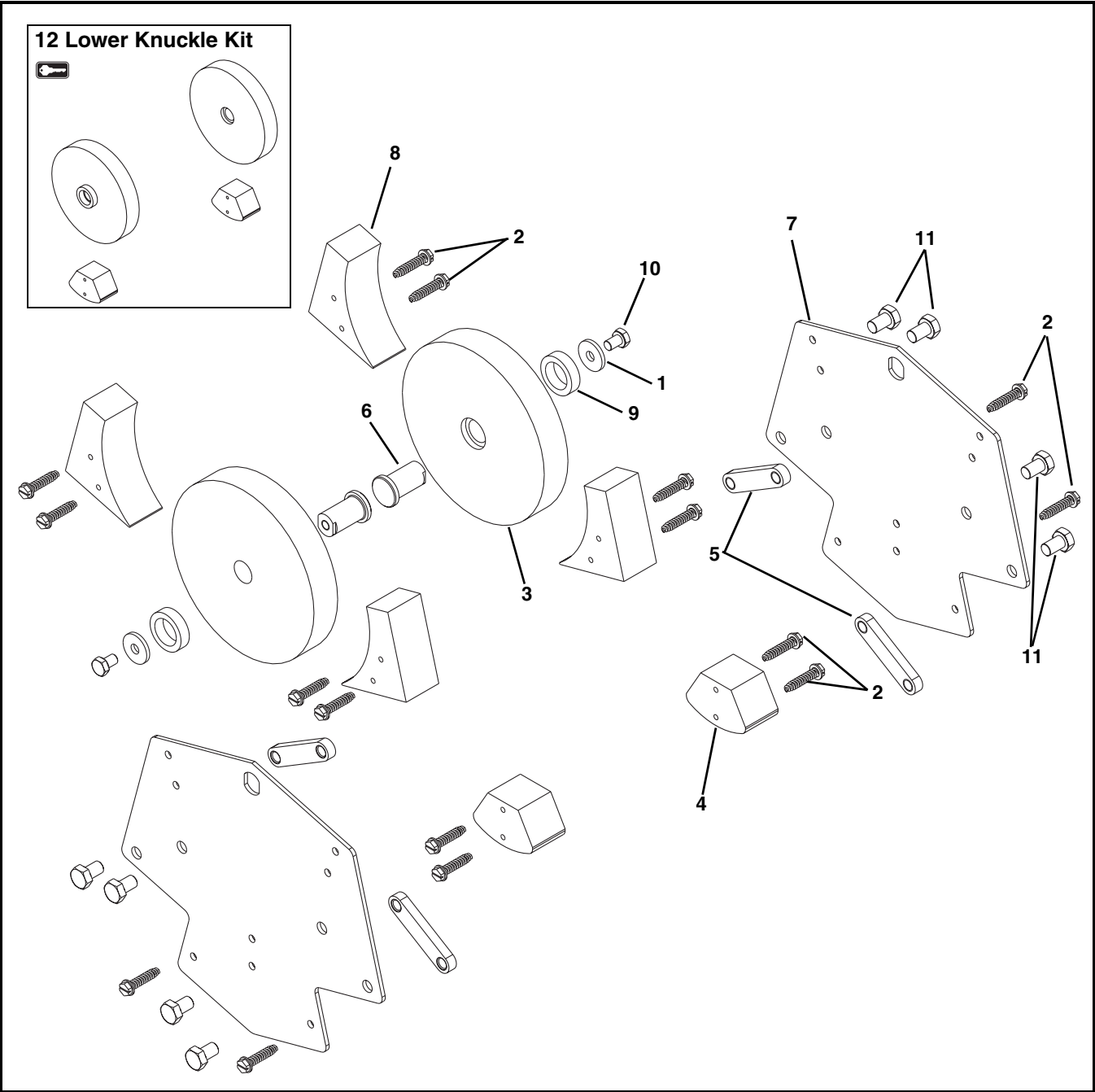


Item	Part Number	Description
1	807-1884	Sheet Metal Screw, #14 x 1.25
2	352326	Inner Belt Return Guide
3	500199	Connector
4	506296	Idler Puck
5	532127- <u>LLLLL</u>	Tube Spacer
6	532305	Spacer
7	532353	Edge Guide Plate
8	532358	Shaft Clamp
9	532361	Bar Cap for Straight Conveyors
10	532376- <u>AA</u>	Side Plate

Item	Part Number	Description
11	532377- <u>WW</u>	Shaft
12	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
13	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
14	807-1292	Cap
15	735UNS- <u>WW</u>	Upper Knuckle Kit for Straight Conveyor (Includes Items 2, 4, 5 and 6)
<u>AA</u> = Angle 05, 10, 15, 30, 45 or 60		
<u>WW</u> = Conveyor width reference: 08 – 24 in 02 increments		
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

# Service Parts

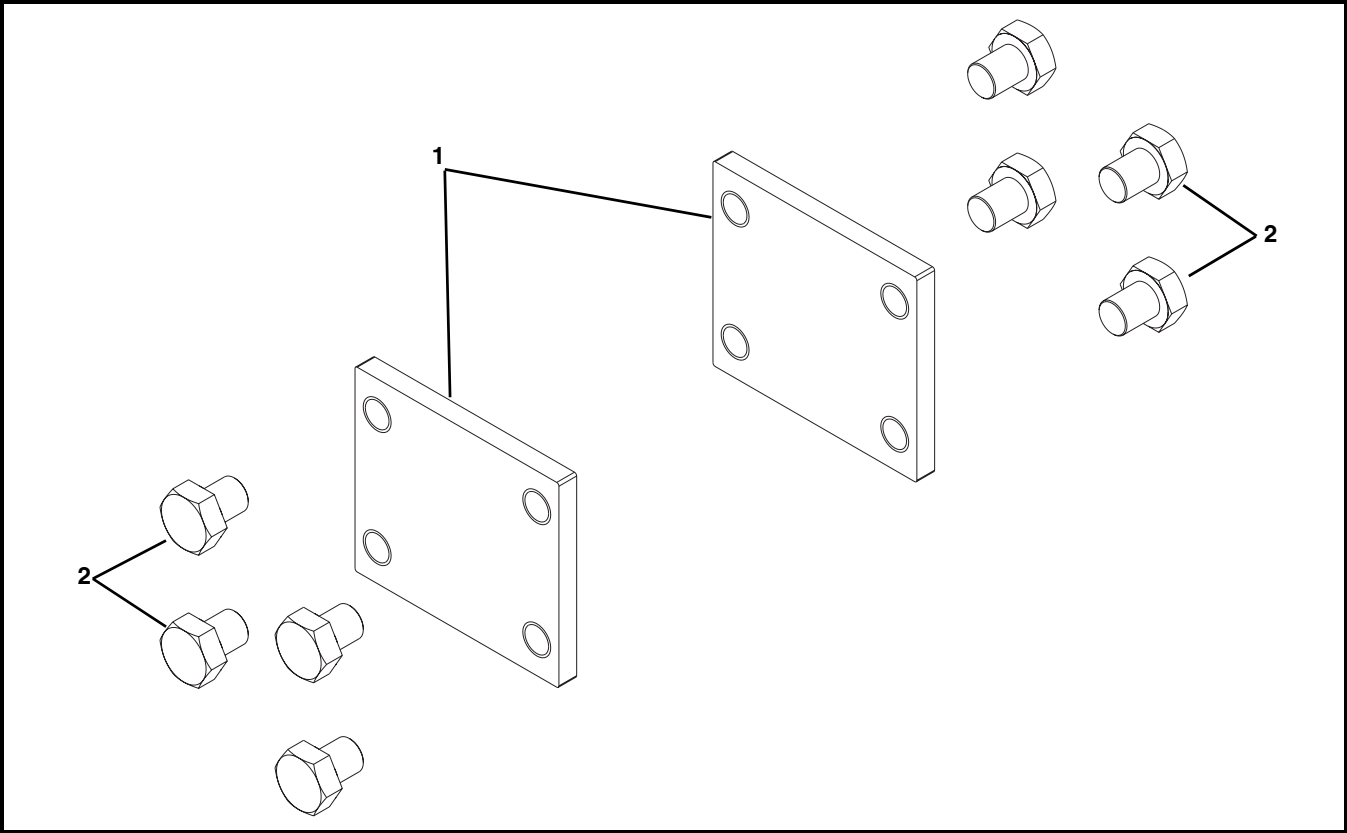
## Lower Knuckle



Item	Part Number	Description
1	807-1838	Washer
2	807-1884	Sheet Metal Screw, #14 x 1.25
3	352324	Hold Down Guide
4	352326	Inner Belt Return Guide
5	500199	Connector
6	532351	Stub Shaft
7	532355-AA	Side Plate

Item	Part Number	Description
8	532359	Hold Down Roller Guard
9	532379	Hold Down Roller Spacer
10	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
11	961012MSS	Hex Head Cap Screw, M10-1.50 x 12 mm
12	735LN	Lower Knuckle Kit (Includes Items 3, 4 and 9)
AA = Angle 05, 10, 15, 30, 45 or 60		

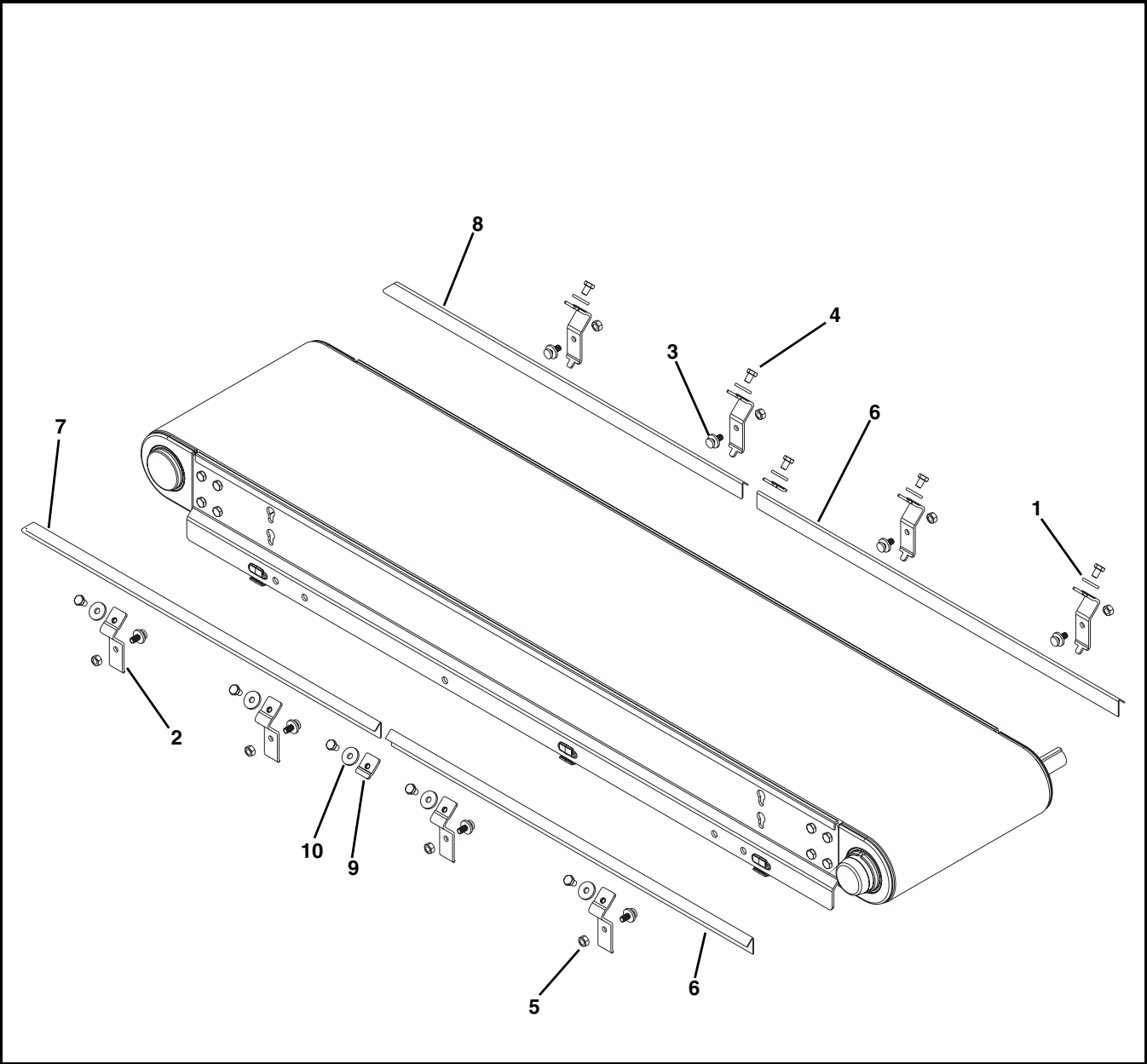
**Connecting Assembly**



Item	Part Number	Description
1	532157	Connector Plate
2	961012MSS	Hex Head Cap Screw, M10-1.50 x 12 mm

# Service Parts

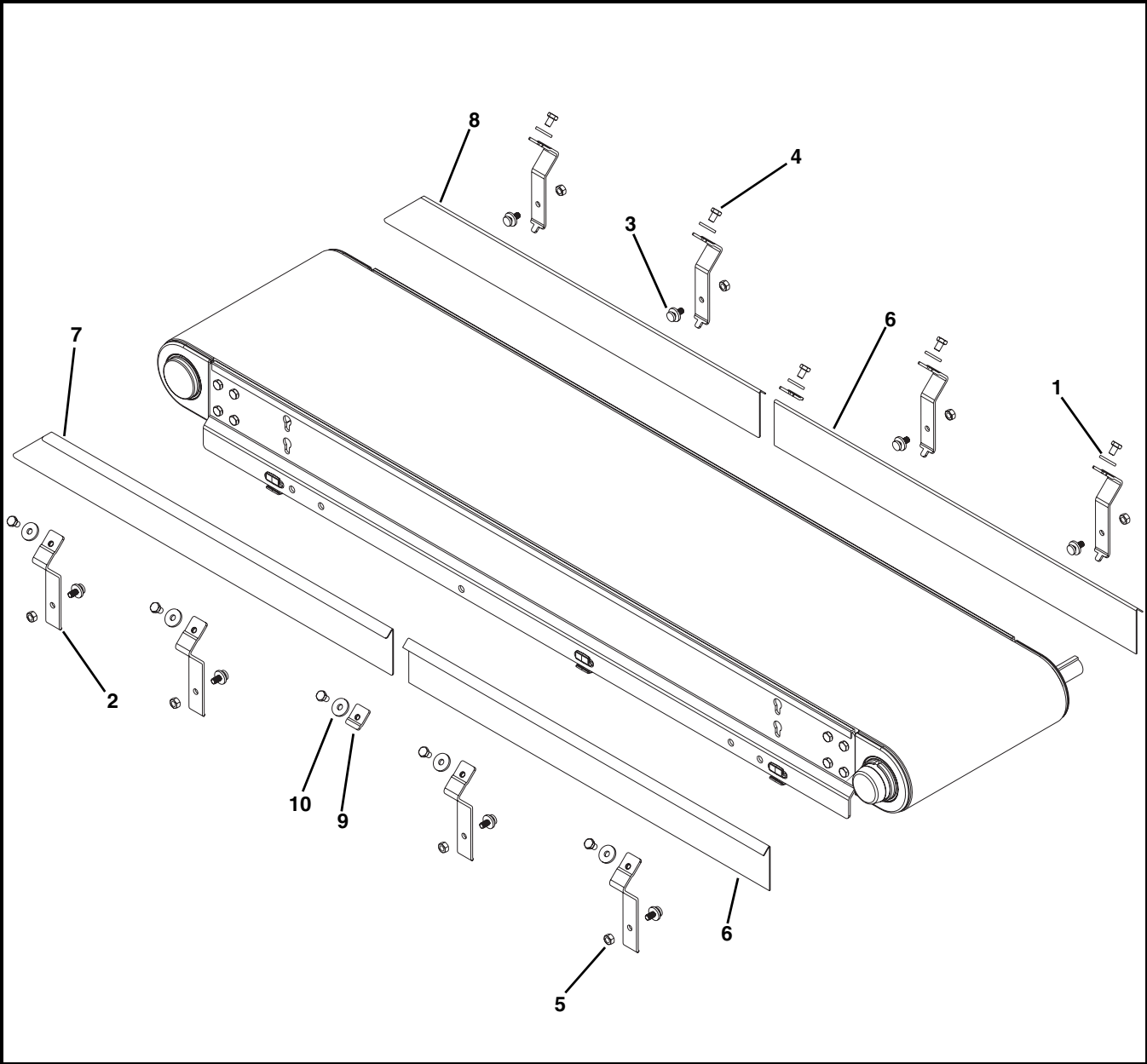
## 1" (25 mm) High Sides



Item	Part Number	Description
1	807-1821	Washer
2	532183	1" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532175- <u>LLLLL</u>	Guiding Straight

Item	Part Number	Description
7	532176- <u>LLLLL</u>	Guiding Left Hand
8	532177- <u>LLLLL</u>	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

3" (76 mm) High Sides

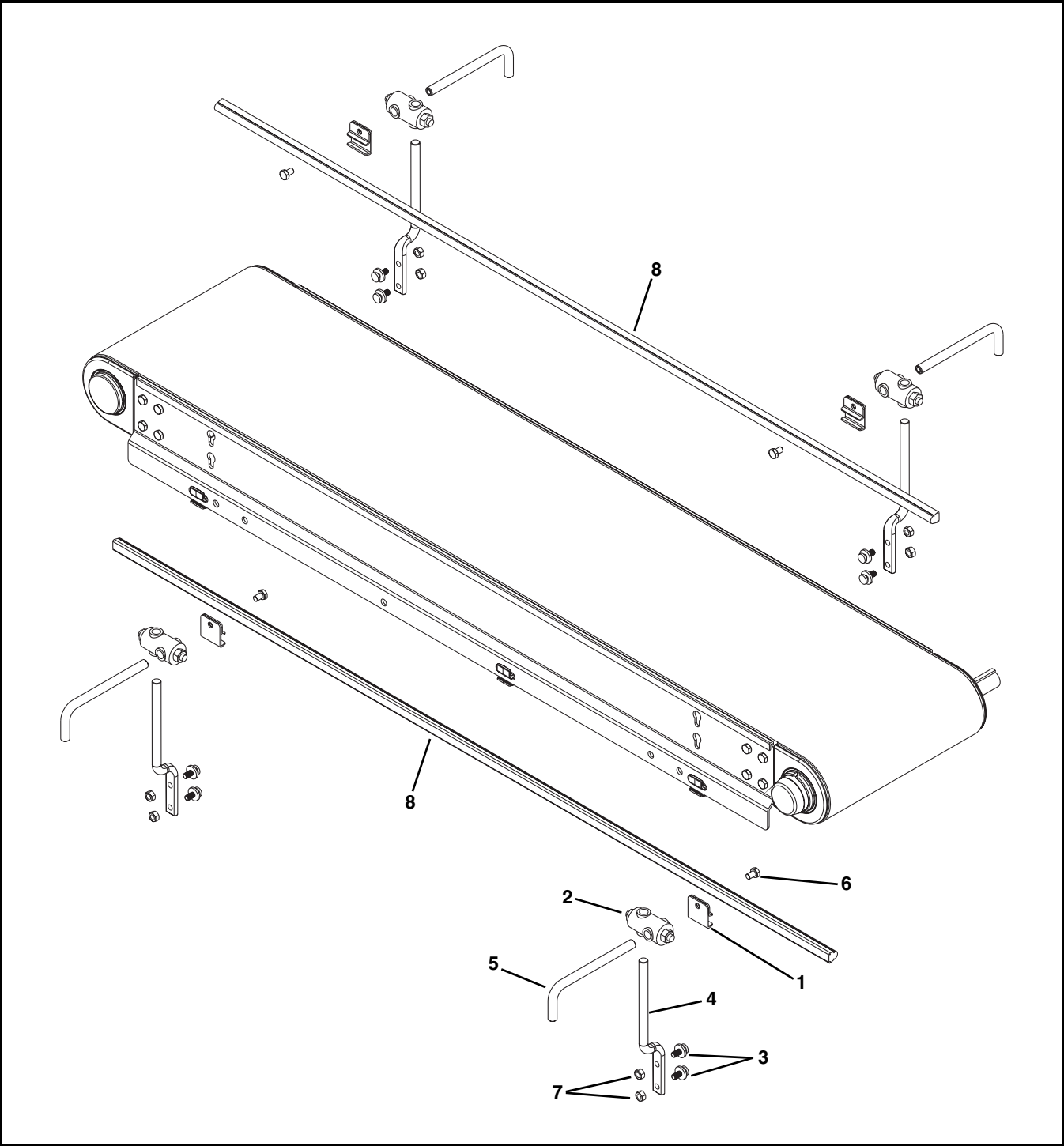


Item	Part Number	Description
1	807-1821	Washer
2	532185	3" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532172-LLLLL	Guiding Straight

Item	Part Number	Description
7	532173-LLLLL	Guiding Left Hand
8	532174-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

## Fully Adjustable Round Guides

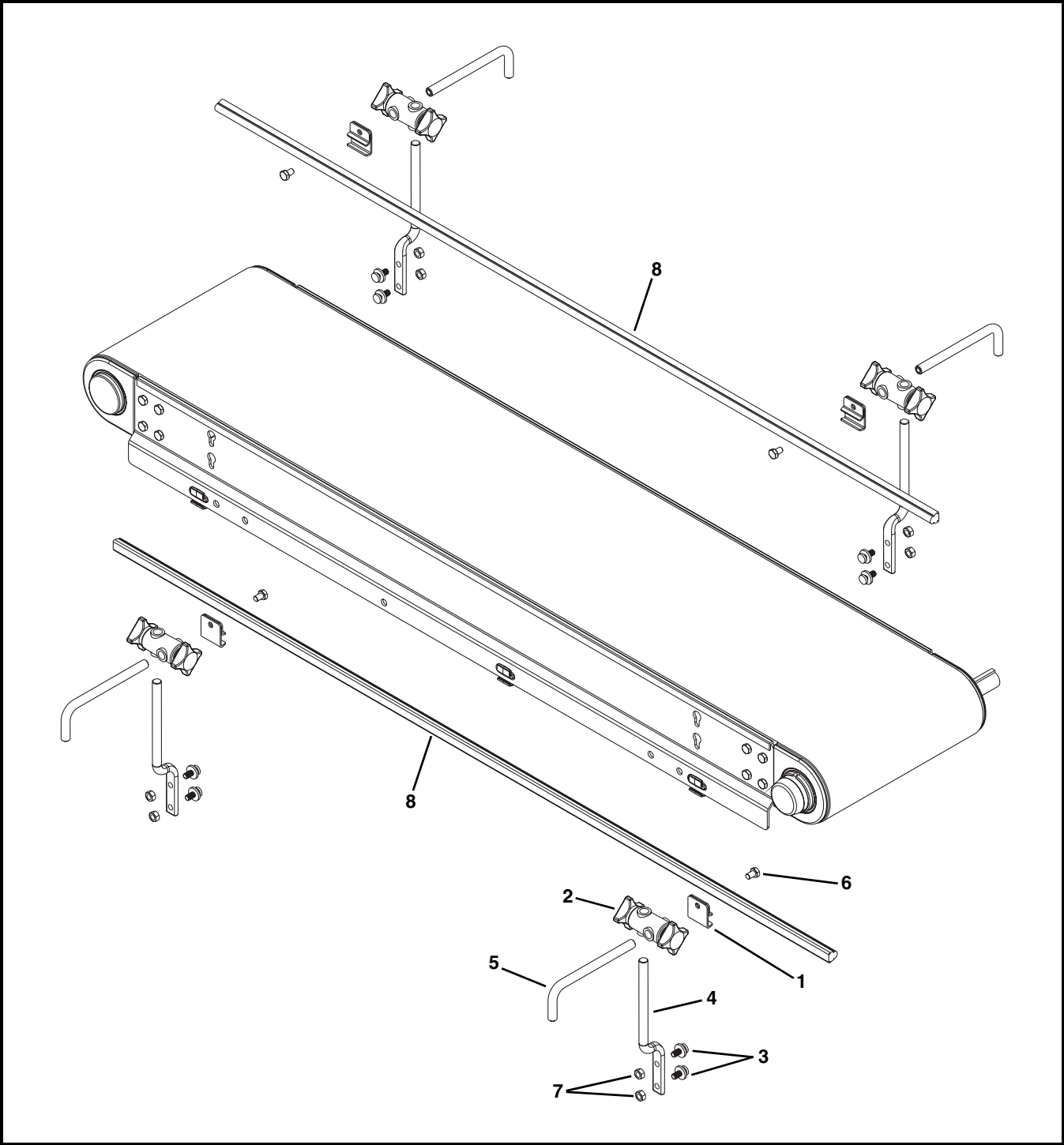


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167- <u>LLLLL</u>	Round Guide Rail
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		



Tool-Less Fully Adjustable Round Guides

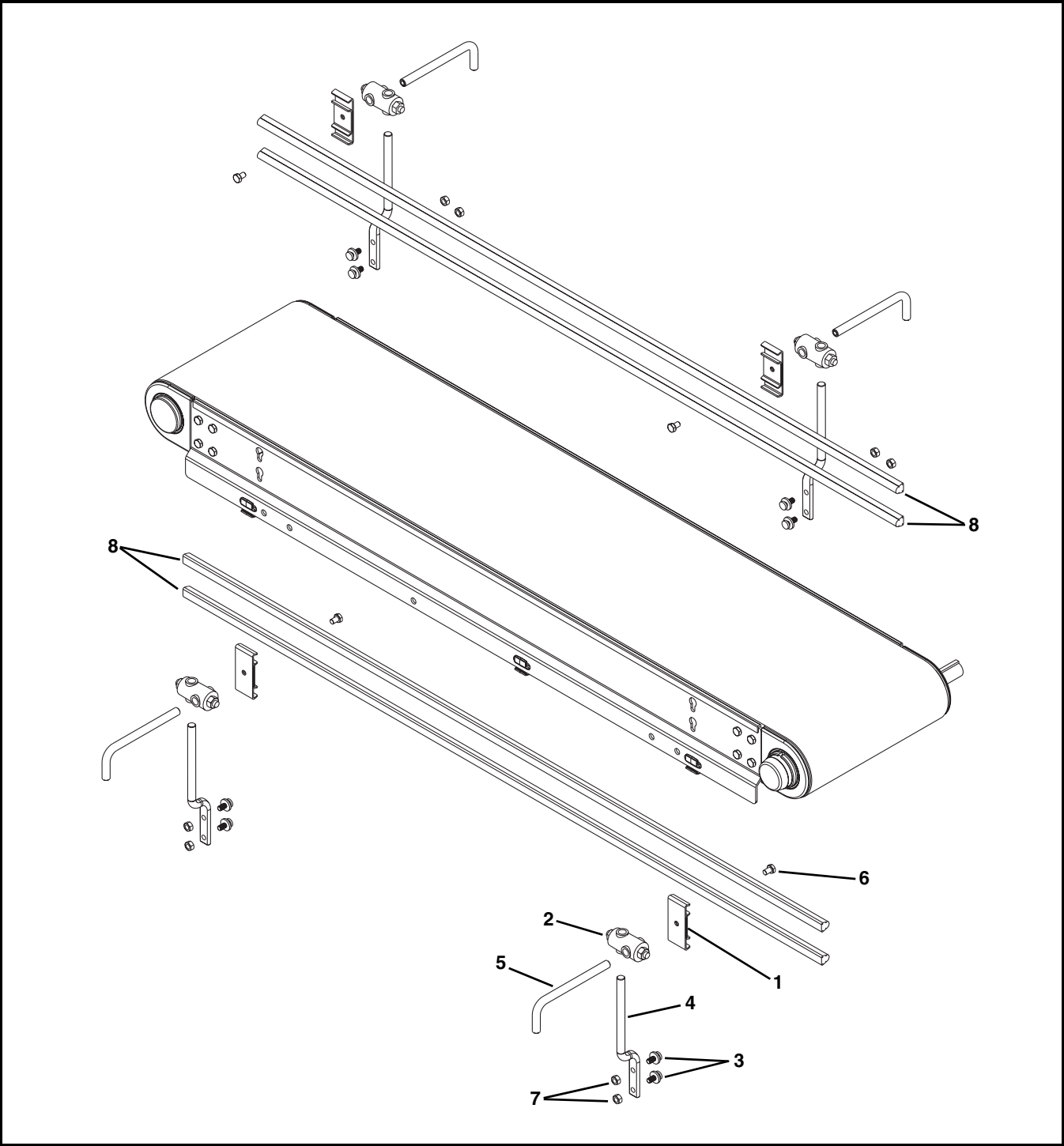


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

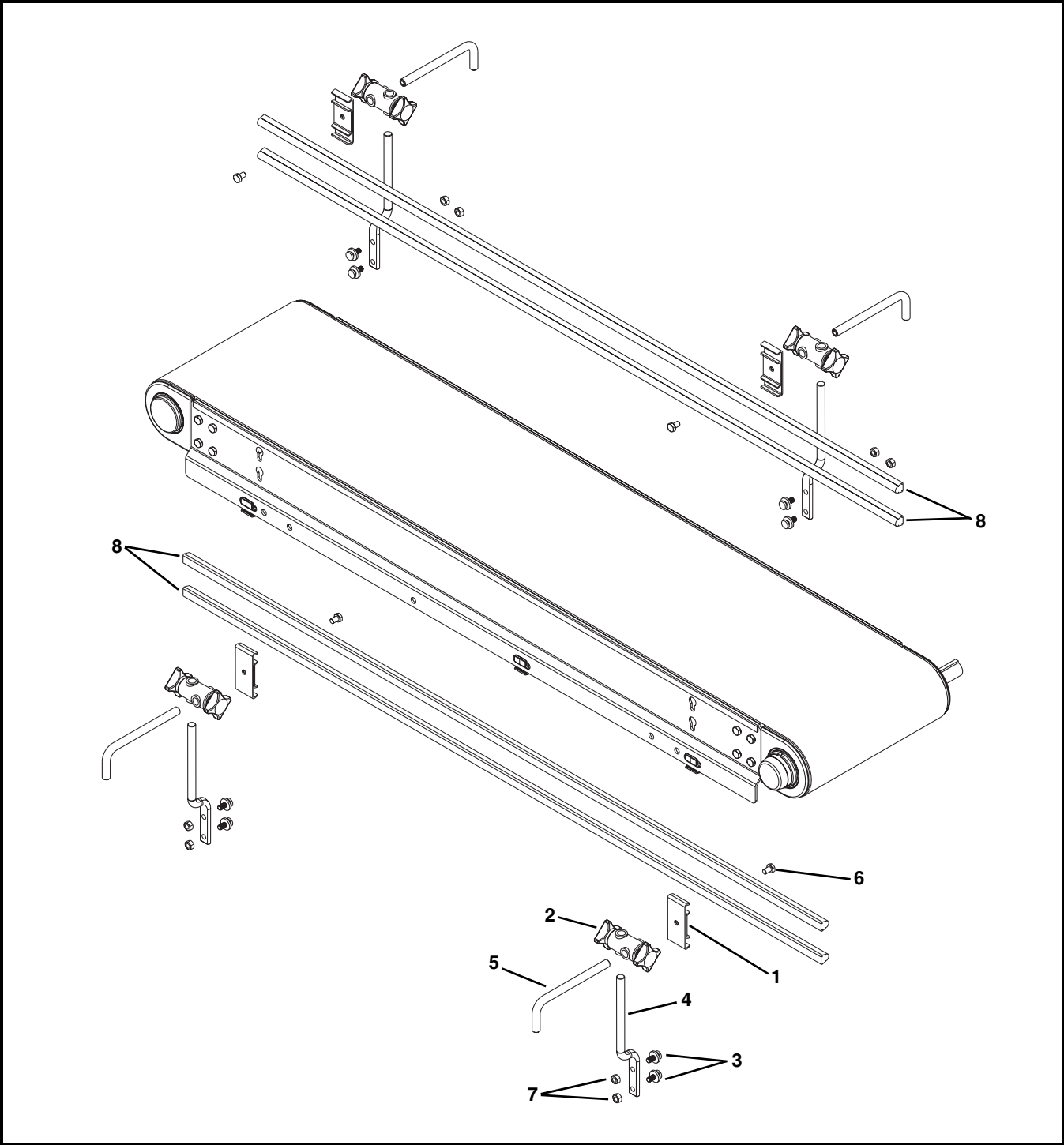
## Twin Rail Adjustable Round Guides



Item	Part Number	Description
1	901414	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167- <u>LLLLL</u>	Round Guide Rail
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

Tool-Less Twin Rail Adjustable Round Guides

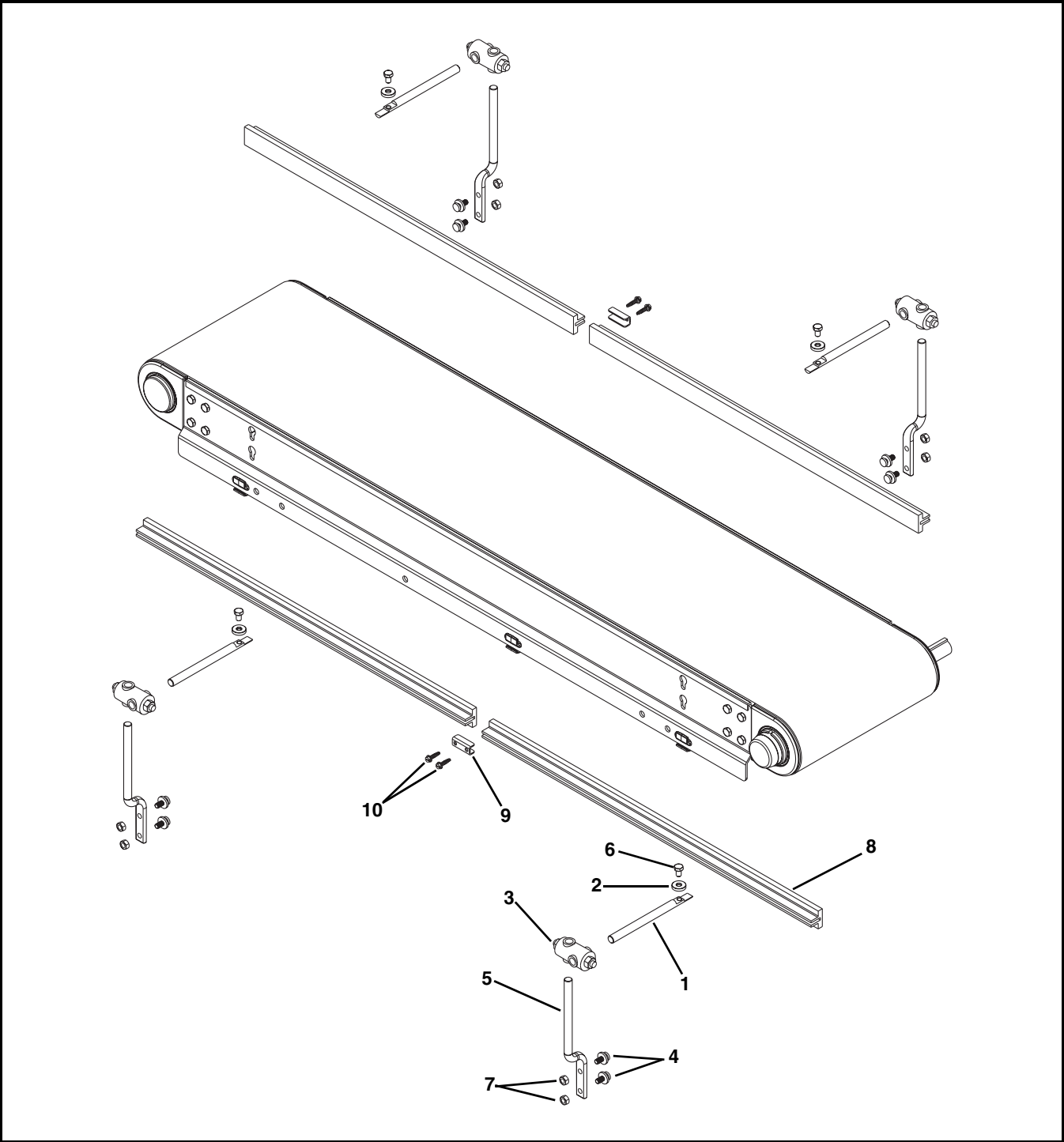


Item	Part Number	Description
1	901414	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167- <u>LLLL</u>	Round Guide Rail
<u>LLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLL</u> = 09525		

# Service Parts

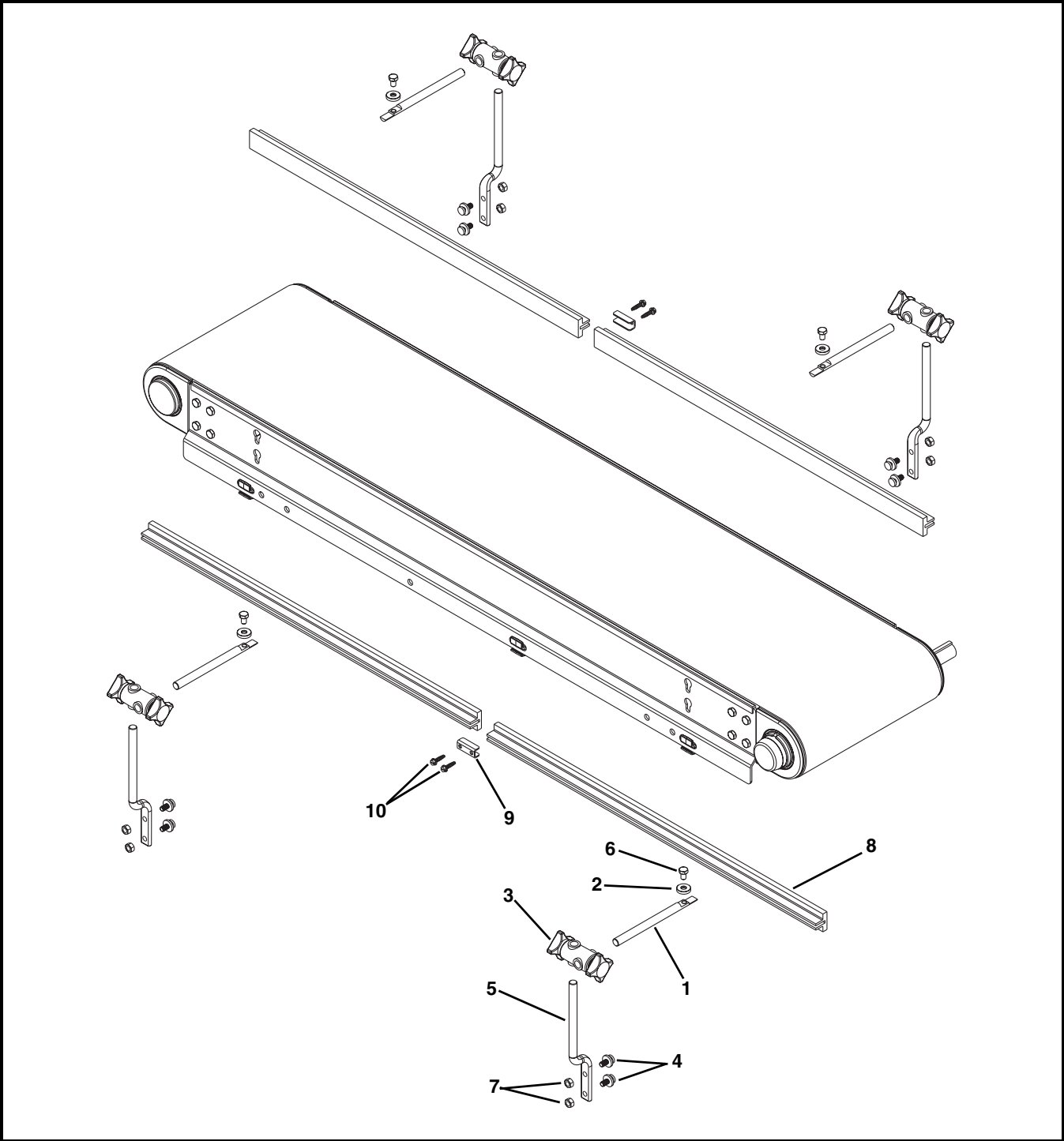
## Fully Adjustable 1" (25 mm) Flat Guides



Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1387	Cross Block Clamp
4	532191	Carriage Bolt, M8 x 20 mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532170-LLLLL	Round Guide Rail
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Fully Adjustable 1" (25 mm) Flat Guides

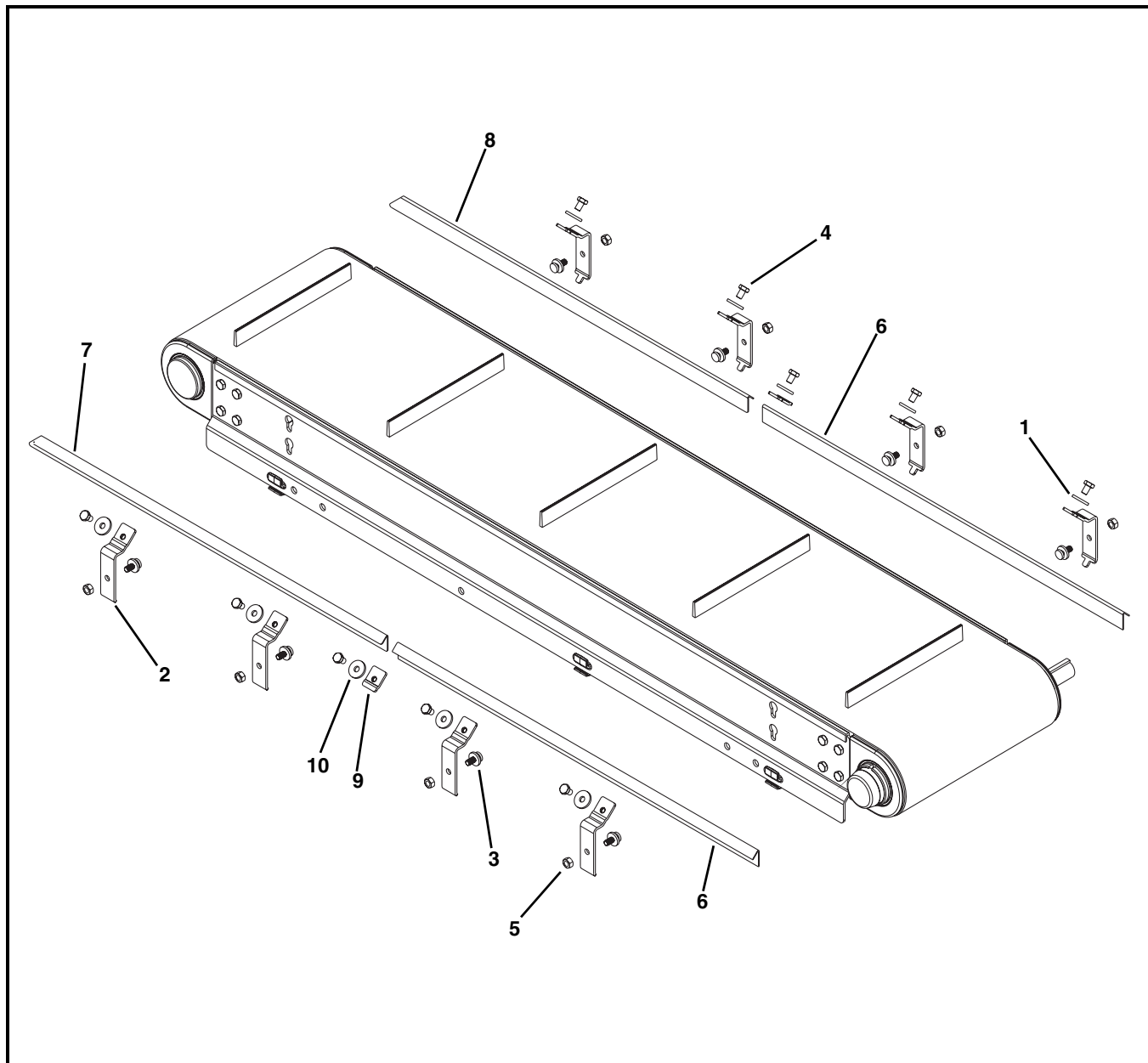


Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1470	Cross Block Clamp
4	532191	Carriage Bolt, M8 x 20 mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532170- <u>LLLL</u>	Round Guide Rail
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
<u>LLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLL</u> = 09525		

# Service Parts

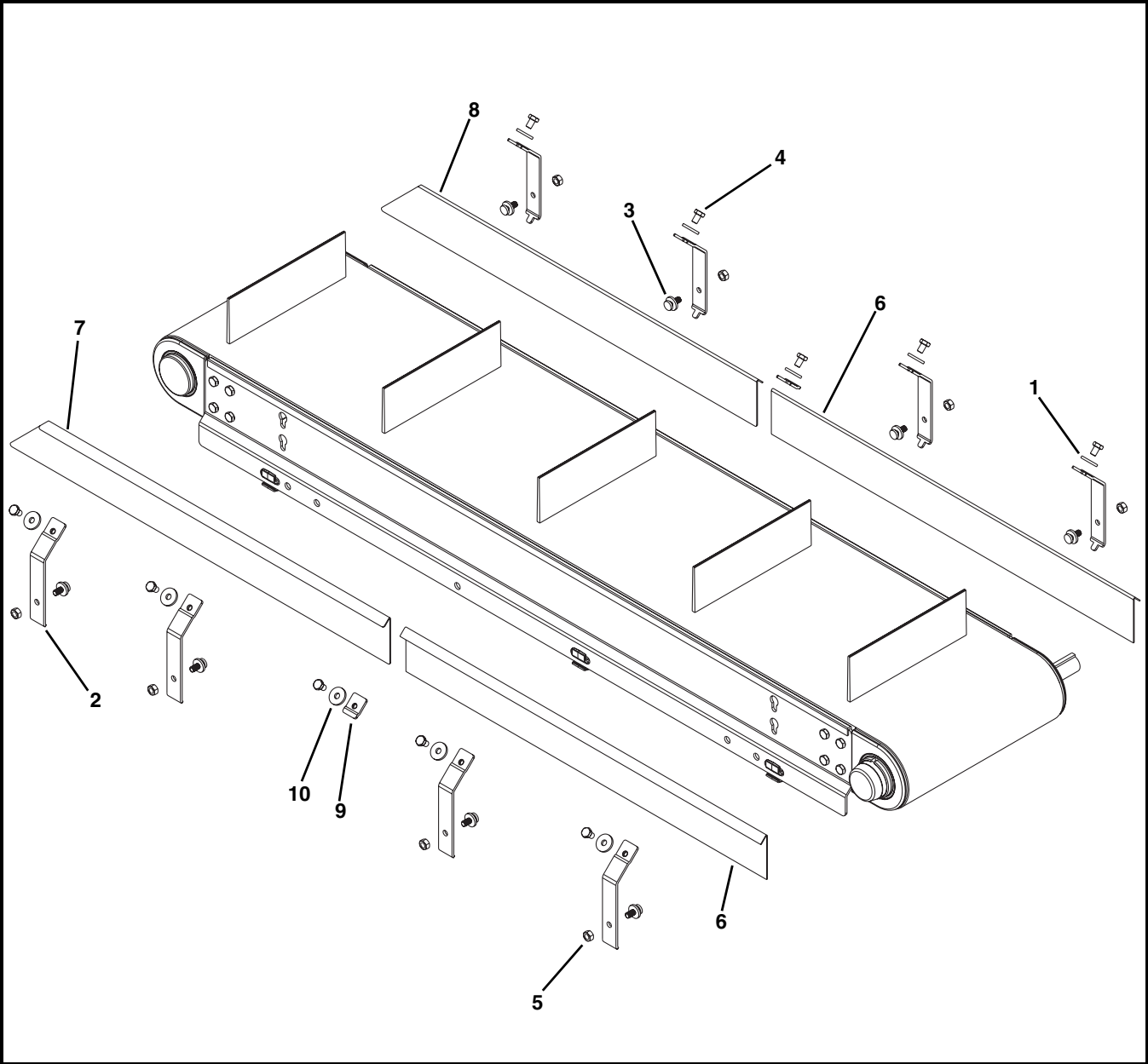
## 1" (25 mm) Cleated High Sides



Item	Part Number	Description
1	807-1821	Washer
2	532184	1" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532175- <u>LLLLL</u>	Guiding Straight

Item	Part Number	Description
7	532176- <u>LLLLL</u>	Guiding Left Hand
8	532177- <u>LLLLL</u>	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

3" (76 mm) Cleated High Sides

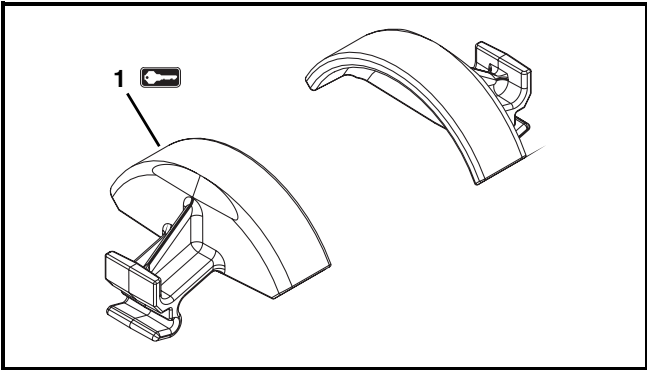



Item	Part Number	Description
1	807-1821	Washer
2	532186	3" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532172-LLLLL	Guiding Straight

Item	Part Number	Description
7	532173-LLLLL	Guiding Left Hand
8	532174-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

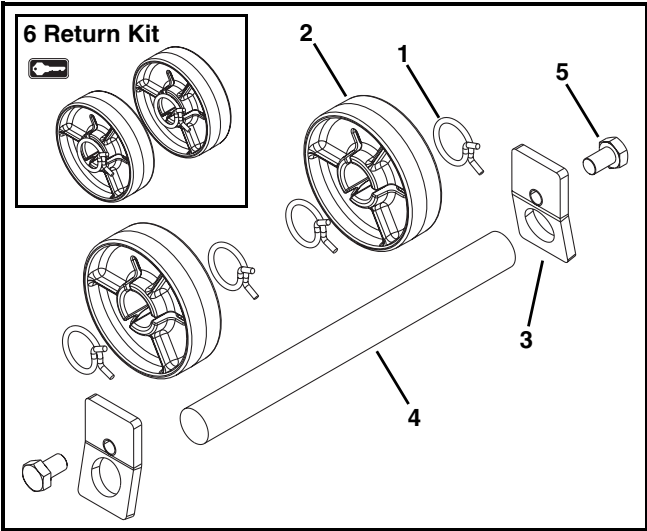
# Service Parts


## 4" (102 mm) - 24" (610 mm) Wide Returns



Item	Part Number	Description
1 	532224	Return Shoe

## 26" (660 mm) - 36" (914 mm) Wide Returns



Item	Part Number	Description
1	807-1551	Clamp
2	506296	Return Disk
3	532307	Return Shaft Bracket
4	532431- <u>WW</u>	Shaft
5	961020MSS	Hex Head Cap Screw, M10-1.50 x 20 mm
6 	736RRF- <u>WW</u>	Return Kit (Includes items 1 and 2)
<u>WW</u> = Conveyor width reference: 26 – 36 in 02 increments		



## Ordering a Replacement Chain

Determine the length of chain required for the conveyor and round up to the nearest foot length. Order the proper number of chain repair kits (1' long each) for your conveyor. Dorner will ship chain kits that are of a reasonable length fully assembled

### Example:

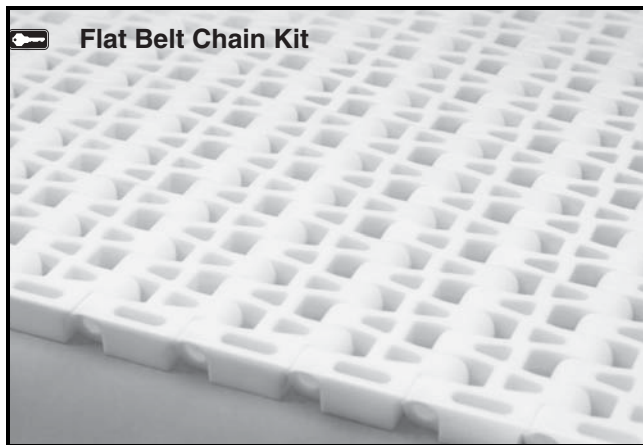
Overall chain length = 42' 5" (rounded up = 43')


Order: Qty (43) of 52BB-WW

BB = Chain reference number

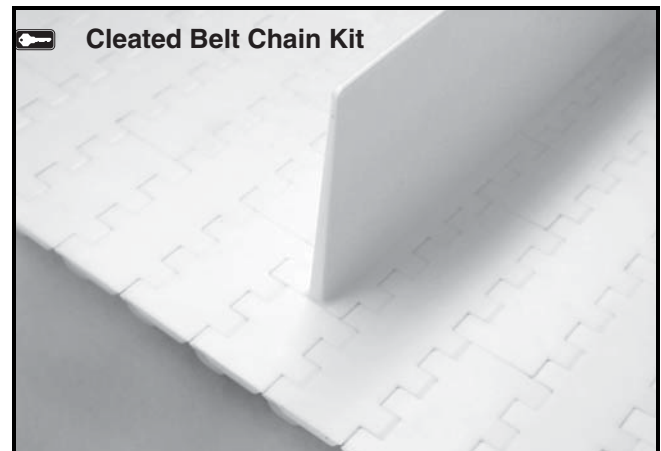
WW = Conveyor width ref: 04-36 in 02 increments


## Flat Belt Chain Repair Kit



Item	Part Number	Description
1 	52 <u>BB</u> - <u>WW</u>	Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
<u>BB</u> = Chain Reference number		
<u>WW</u> = Conveyor width ref: 04 - 36 in 02 increments		

## Cleated Belt Chain Repair Kit



Item	Part Number	Description
1 	52 <u>BB</u> - <u>WW</u> - <u>SS</u>	Cleated Belt Chain Repair Kit (Includes cleats on 1 ft (305mm) of belt chain and assembly pins)
<u>BB</u> = Chain Reference number		
<u>WW</u> = Conveyor width ref: 08 - 24 in 02 increments		
<u>SS</u> = Cleat Spacing		

# Return Policy

Returns must have prior written factory authorization or they will not be accepted. Items that are returned to Dorner without authorization will not be credited nor returned to the original sender. When calling for authorization, please have the following information ready for the Dorner factory representative or your local distributor:

1. Name and address of customer.
2. Dorner part number(s) of item(s) being returned.
3. Reason for return.
4. Customer's original order number used when ordering the item(s).
5. Dorner or distributor invoice number (if available, part serial number).

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization (RMA) number for reference. RMA will automatically close 30 days after being issued. To get credit, items must be new and undamaged. There will be a return charge on all items returned for credit, where Dorner was not at fault. It is the customer's responsibility to prevent damage during return shipping. Damaged or modified items will not be accepted. The customer is responsible for return freight.

## Conveyors and conveyor accessories

Standard catalog conveyors	30%
MPB, 7200, 7300 Series, cleated and specialty belt	50%
AquaGard & AquaPruf Series conveyors	non-returnable items
Engineered to order products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

## Parts

Standard stock parts	30%
Plastic chain, cleated and specialty belts	non-returnable items

Returns will not be accepted after 60 days from original invoice date. The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components to inventory. If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Customer Service Team will gladly help with your questions on Dorner products.

For a copy of Dorner's Warranty, contact factory, distributor, service center or visit our website at [www.dorner.com](http://www.dorner.com).

For replacement parts, contact an authorized Dorner Service Center or the factory.



Dorner Mfg. Corp. reserves the right to change or discontinue products without notice. All products and services are covered in accordance with our standard warranty. All rights reserved. © Dorner Mfg. Corp. 2010

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