



# 7600 Series Center 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 7600 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.

- 1

Conveyor
- 2

Gearmotor
- 3

Belt (Flat Belt Shown)
- 4

Support Stands
- 5

Motor Controller
- 6

Discharge End
- 7

Infeed End
- 8

Center Drive Module

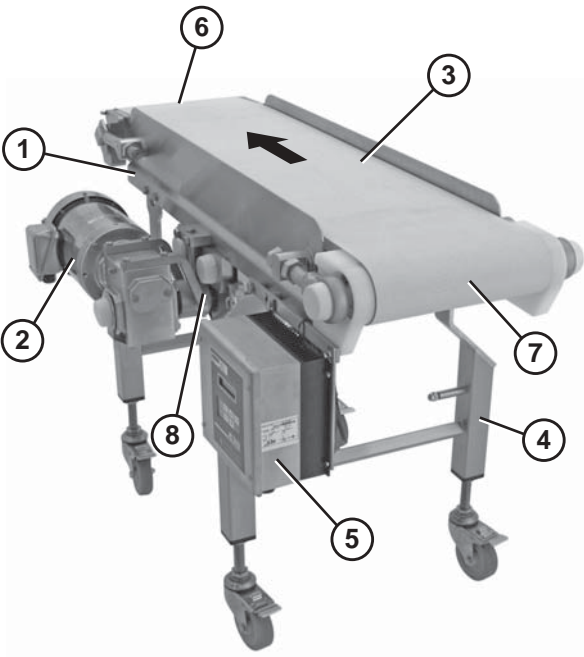
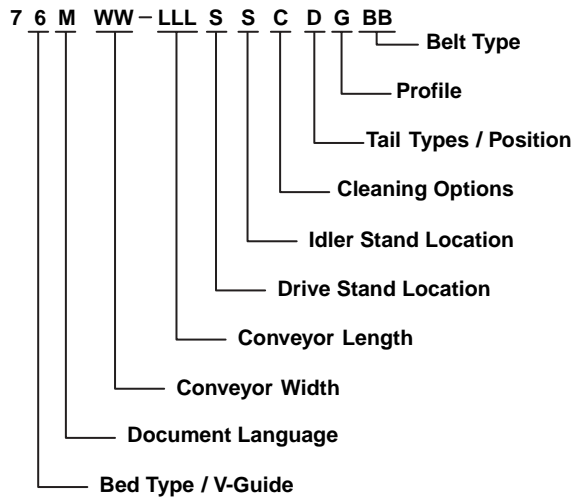


Figure 1

# Specifications

## Flat Belt 7600 Series Center Drive Conveyor

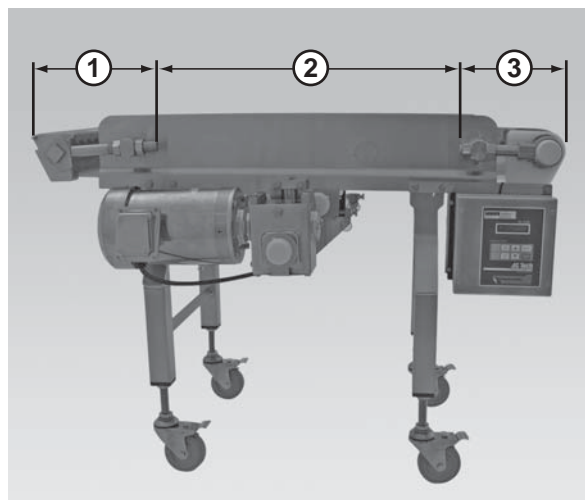




## Conveyor Supports

### Maximum Distances:

- 1 = Support Stand on Infeed End = 3 ft (914 mm)  
 2 = Between Support Stands = 8 ft (2438 mm)\*\*  
 3 = Support Stand on Discharge End = 3 ft (914 mm)  
 \*\* For conveyors longer than 10 ft (3.05 m),  
 install support at frame joint.



**Figure 2**

## Specifications

Conveyor Width Reference ( <u>WWW</u> )	06 – 60 in 02 increments
Conveyor Belt Width	6" (152 mm) - 60" (1524 mm) in 2" (51 mm) increments
Maximum Conveyor Load	400 lbs. (181 kg)
Belt Travel	11.25" (286 mm) per revolution of pulley
Maximum Belt Speed	325 ft/minute (100 m/minute)
Belt Take-up	1.5" (38 mm)

Conveyor Length Reference ( <u>LLL</u> )	048 - 480 in 001 increments
Conveyor Length	48" (1219 mm) - 480" (12192 mm) 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*

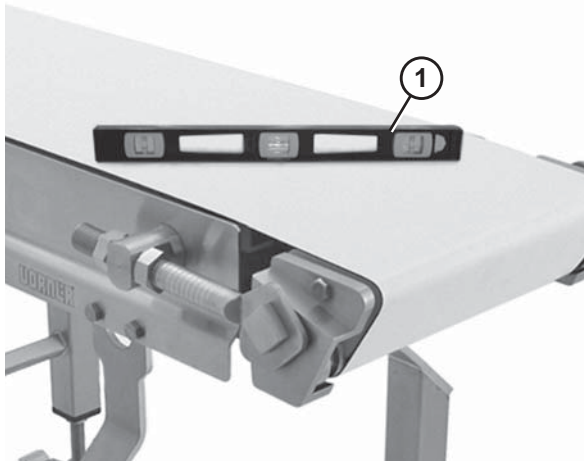
# Installation

## ⚠ 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.

## ⚠ 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

## Recommended Installation Sequence

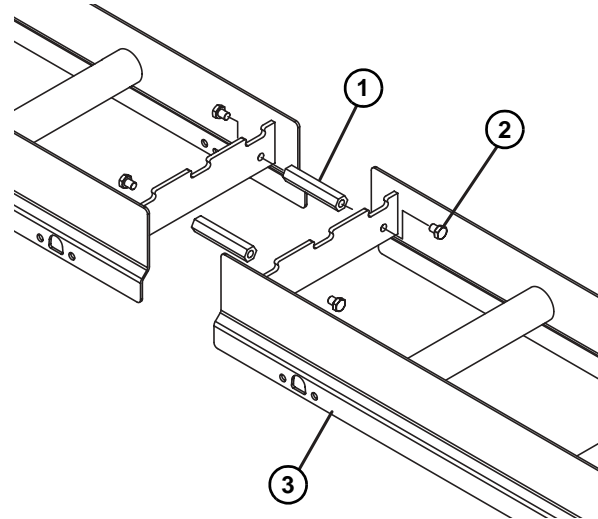
1. Assemble the conveyor (if required). Refer to “All Conveyors” on page 10.
2. Attach the stands. Refer to “Stand Installation” on page 12.
3. Install the gearmotor. Refer to “Drive Package Installation” on page 13.

## Conveyors Longer than 10 ft (3048 mm)

### Connecting Components

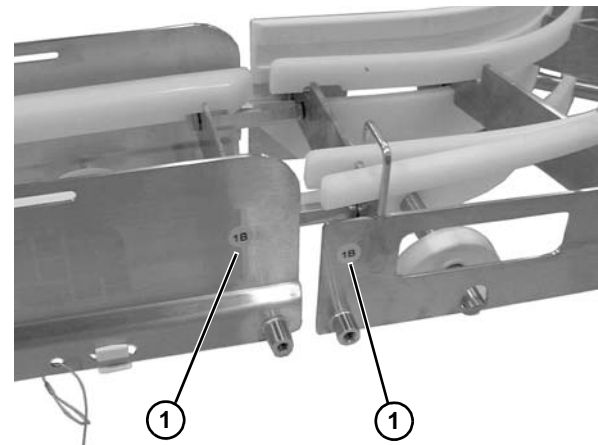
Typical Connection Components (Figure 4)

- |   |                                       |
|---|---------------------------------------|
| 1 | M10 x 1.5 mm hex head cap screws (x4) |
| 2 | Connector hex rods (x2)               |
| 3 | Conveyor frames                       |



**Figure 4**

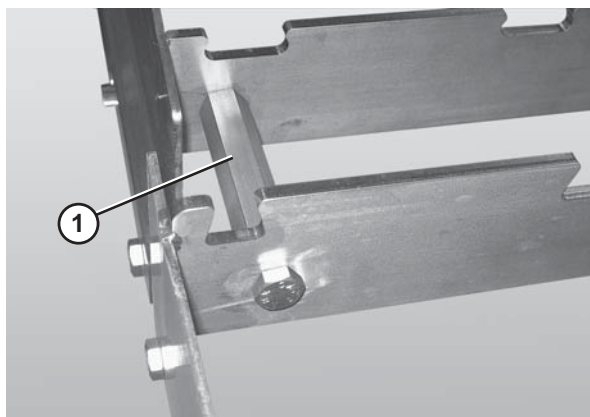
1. Locate and arrange conveyor sections by section labels (Figure 5, item 1).



**Figure 5**

2. Position the frame sections in the correct order.

3. Connect the frame sections by bolting the hex post connectors (**Figure 6, item 1**) to the sections of frame.



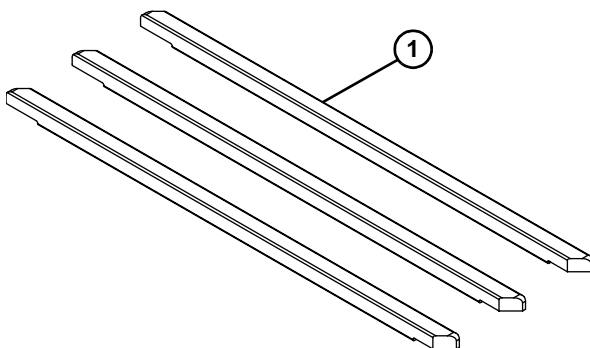
**Figure 6**

## Wear Strip Installation

### Standard Wear Strips

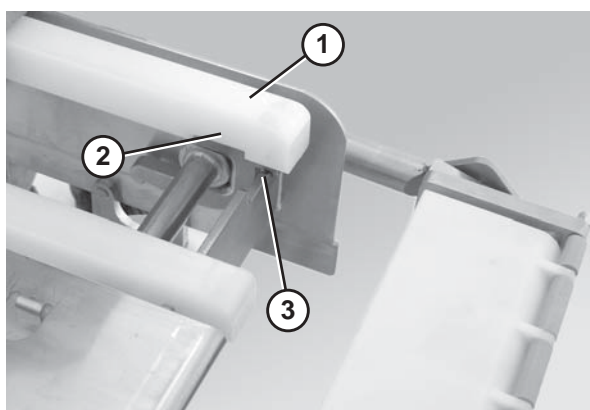
Typical Standard Wear Strips (**Figure 7**)

1	Wear Strips
---	-------------



**Figure 7**

1. Position the wear strips (**Figure 8, item 1**) on the frame.



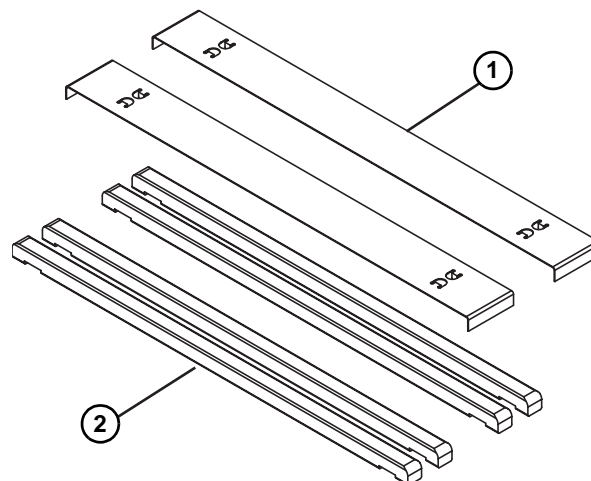
**Figure 8**

2. Make sure the slots in the wear strips (**Figure 8, item 2**) line up properly with the frame slots (**Figure 8, item 3**).

### Stainless Steel Sheet Bed Plates (optional)

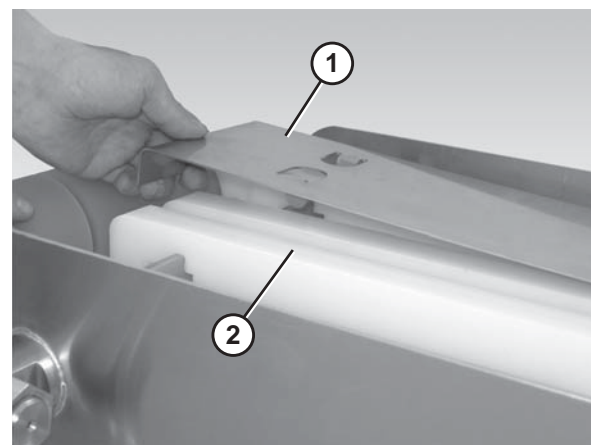
Typical Stainless Steel Sheet Bed Plates (**Figure 9**)

1	Bed Plates
2	Wear Strips



**Figure 9**

1. Attach the wear strips to the frame. Refer to “Standard Wear Strips” on page 7.
2. Place the sheet bed plates (**Figure 10, item 1**) over the wear strips (**Figure 10, item 2**).



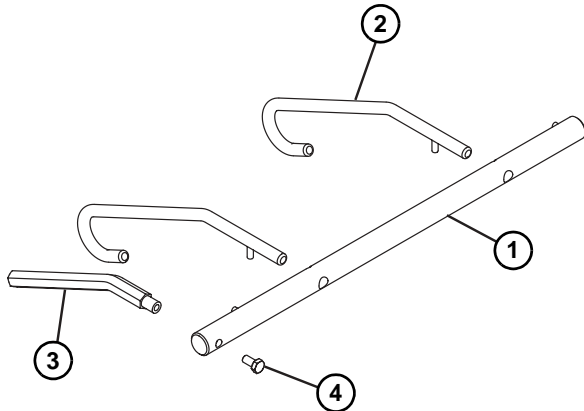
**Figure 10**

# Installation

## Lifter Installation

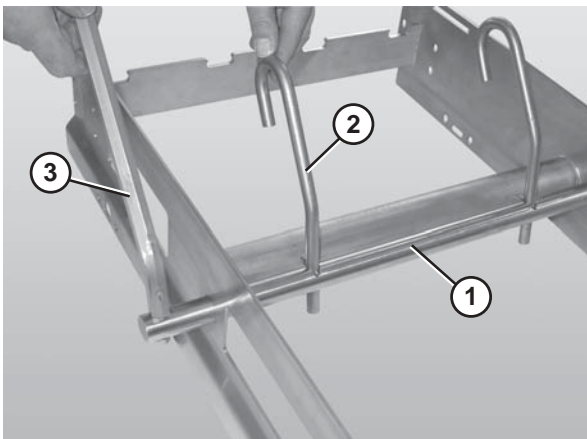
Typical Lifter Components (**Figure 11**)

1	Belt lift pivot bar
2	Lifter bars
3	Belt lift handle
4	M8 - 1.25 x 16 mm hex head cap screw



**Figure 11**

1. Slide the belt lift pivot bar (**Figure 12, item 1**) through the designated holes in the frame. The pins on the belt lift pivot bar should be located inside the frame side rails.



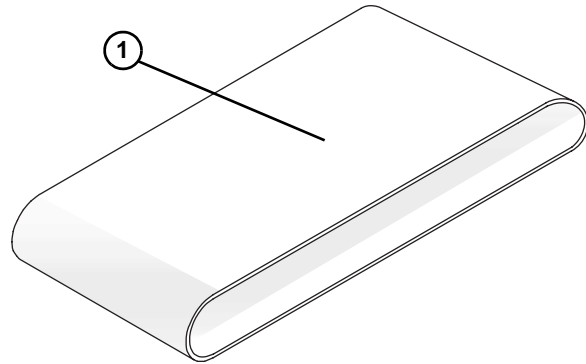
**Figure 12**

2. Attach the lifter bars (**Figure 12, item 2**) to the belt lift pivot bar (**Figure 12, item 1**). Make sure the hooked ends of the lifter bars are facing down when resting against the frame.
3. Attach the lifter handle (**Figure 12, item 3**) to the belt lift pivot rod.

## Belt Installation

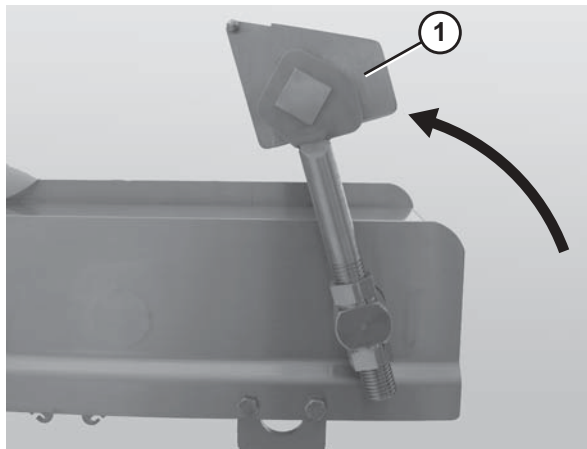
Typical Standard Belt (**Figure 13**)

1	Belt
---	------



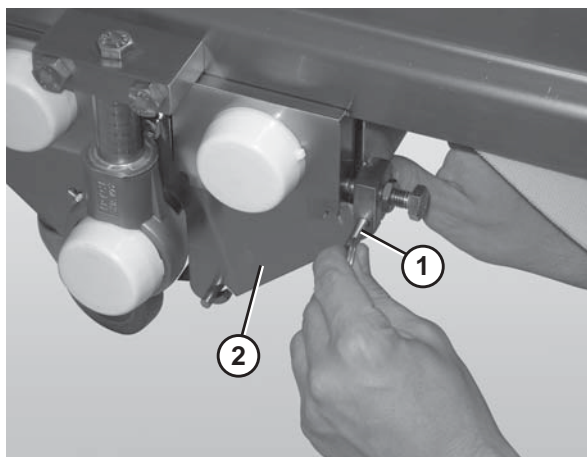
**Figure 13**

1. Place the idler tail (**Figure 14, item 1**) in the up position.



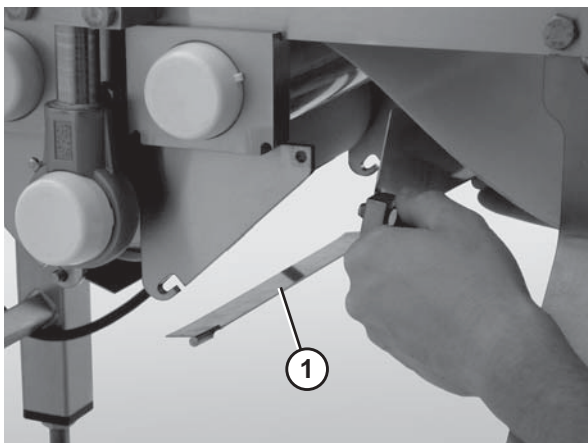
**Figure 14**

2. Remove the 2 pull pins (**Figure 15, item 1**) from the center drive side plate (**Figure 15, item 2**).



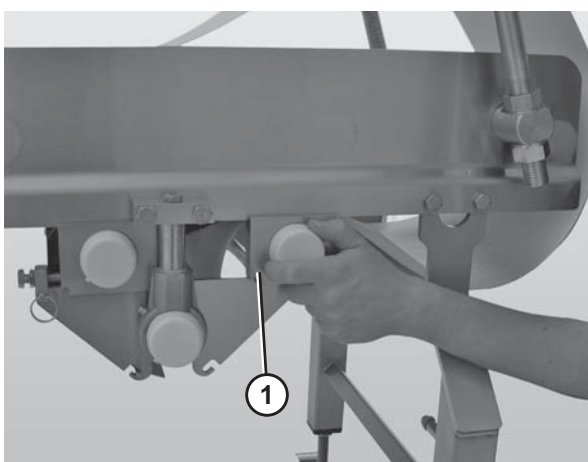
**Figure 15**

3. Lift up on the center drive guard (**Figure 16, item 1**) and remove it.





**Figure 16**

4. Slide the tension spindle assembly (**Figure 17, item 1**) out of the housing.

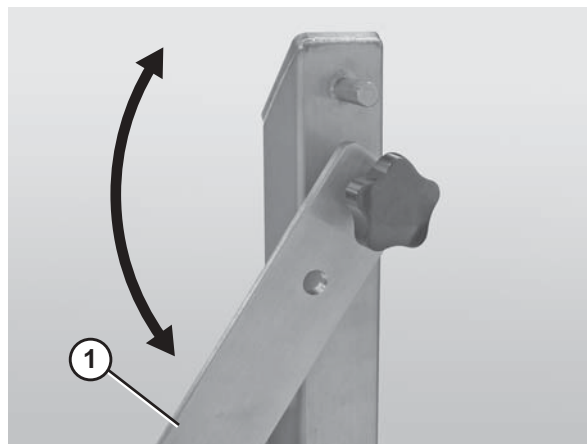


**Figure 17**

5. Repeat steps 2 - 4 on the other side of the drive assembly.

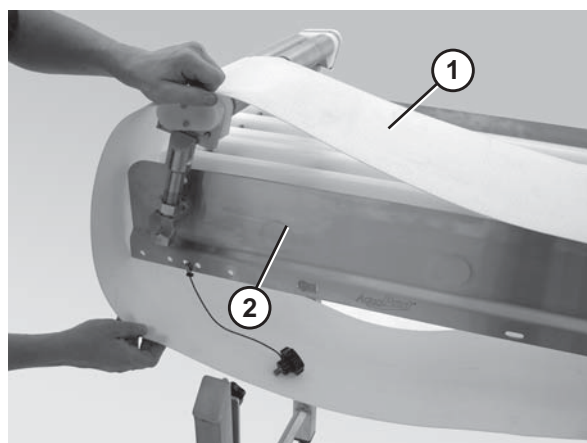
 <b>WARNING</b>

<p style="text-align: center;"><b>SEVERE HAZARD!</b></p> <ul style="list-style-type: none"> <li>• <b>ONLY DISCONNECT ONE PIVOT BRACKET AT A TIME AND ONLY IF THE STANDS ARE BOLTED TO THE FLOOR.</b></li> <li>• <b>Disconnecting more than one pivot bracket at a time or not bolting the stands to the floor can cause the conveyor to tip and may result in serious injury.</b></li> </ul>

6. Lower the quick release arm (**Figure 18, item 1**) on one of the stands. *Note: if the conveyor is not equipped with Quick Release (QR Type) stands, it will be necessary to remove the entire stand. For detailed instructions, refer to the “Sanitary Support Stands Installation, Maintenance and Parts Manual.”*



**Figure 18**

7. Slide the belt (**Figure 19, item 1**) on over the conveyor frame (**Figure 19, item 2**).



**Figure 19**

8. Secure the quick release arm on the stand and repeat steps 6 and 7 until the belt is around the entire length of the conveyor.
9. Slide the tension spindle assemblies (**Figure 17, item 1**) back into the housing.
10. Reattach the center drive guards (**Figure 16, item 1**).
11. Insert the pull pins (**Figure 15, item 1**).
12. Add tension to the belt by lowering the tip-up tail or by sliding the idler tail out and tightening the nuts. Refer to “Conveyor Belt Tensioning” on page 17.
13. Adjust the belt tracking as necessary. Refer to “Conveyor Belt Tracking” on page 18.

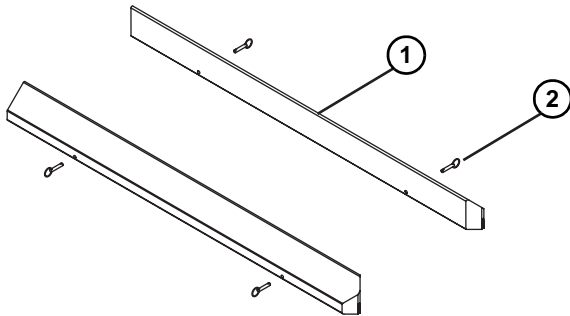


# Installation

## Guide Installation

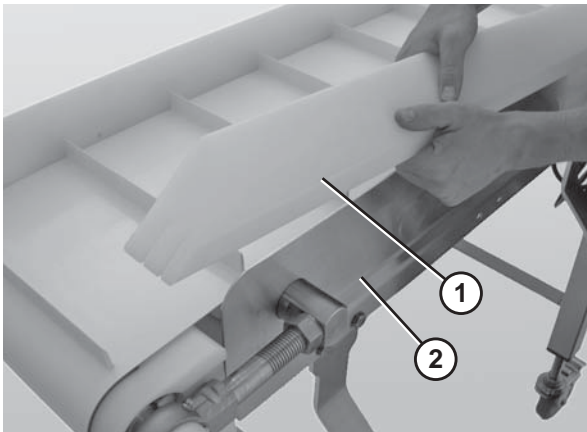
Typical Guide Components (**Figure 20**)

1	Guide
2	Pull pin



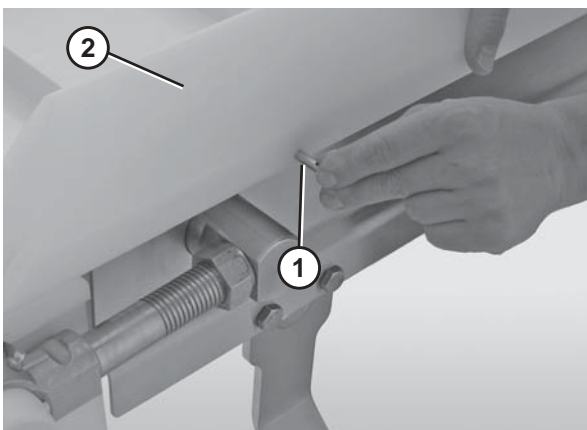
**Figure 20**

1. Position the guide (**Figure 21, item 1**) so that the flat surface is facing the belt and then slide the guide onto the frame rail (**Figure 21, item 2**).



**Figure 21**

2. Line up the guide holes with the holes in the frame.
3. Insert the pull pins (**Figure 22, item 1**) into the holes in the guide (**Figure 22, item 2**).



**Figure 22**

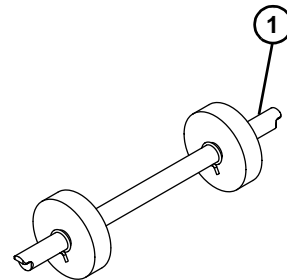
## All Conveyors

### Belt Return Installation

#### Flat Belt

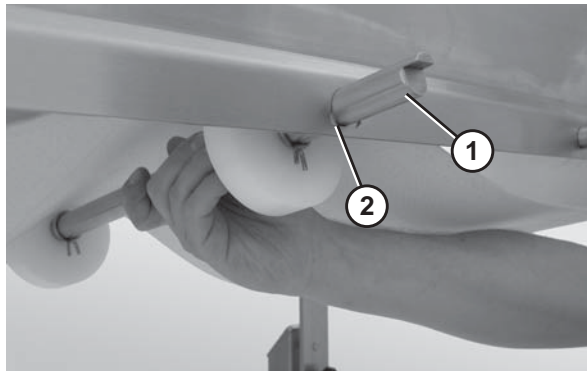
Typical Flat Belt Components (**Figure 23**)

1	Flat belt returns
---	-------------------



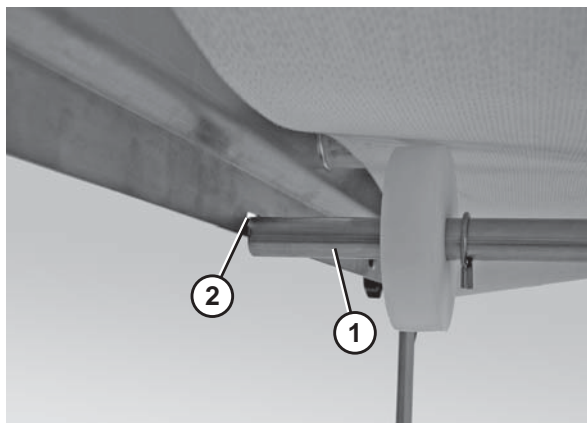
**Figure 23**

1. Slide the return shaft (**Figure 24, item 1**) up and through the large slot (**Figure 24, item 2**) in the frame.



**Figure 24**

2. Push up on the return shaft (**Figure 25, item 1**) and slide the notched end of the shaft through the small slot (**Figure 25, item 2**) on the opposite side of the frame.



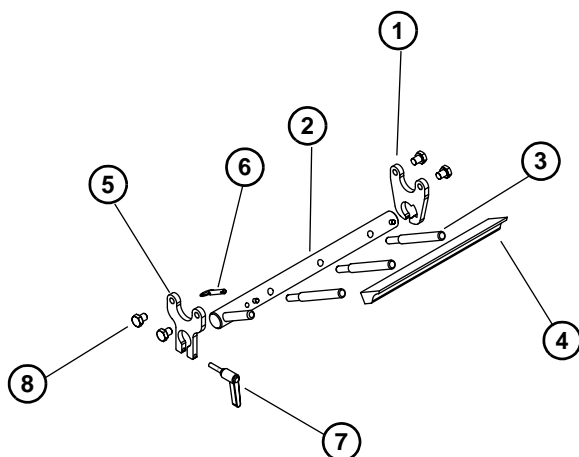
**Figure 25**

3. Repeat the procedure for all other belt returns.

## Scraper Installation

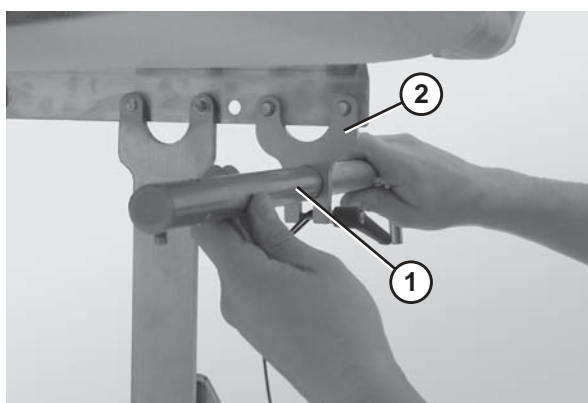
Typical Scraper Components (Figure 26)

1	Scraper adjust plate
2	Scraper shaft
3	Scraper bar holder
4	UHMW scraper
5	Scraper mount plate
6	Pull pin
7	Handle
8	M10-1.50 hex head cap screws (x4)



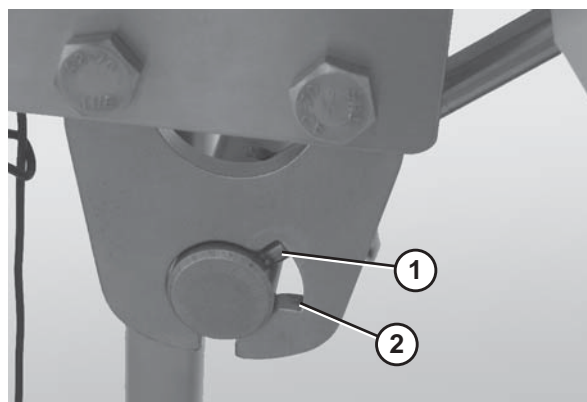
**Figure 26**

1. Attach the scraper adjust plate (Figure 26, item 1) and the scraper mount plate (Figure 26, item 5) to the frame using four M10-1.5 x 12mm hex head cap screws.
2. Slide the notched end of the scraper shaft (Figure 27, item 1) through the adjustment plate (Figure 27, item 2).



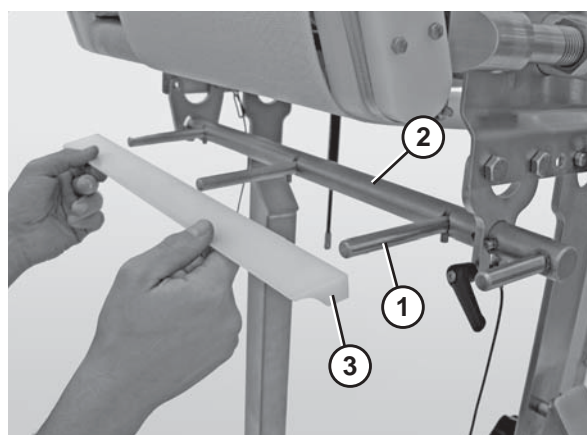
**Figure 27**

3. Insert the notched end of the scraper shaft (Figure 28, item 1) so that it is situated within the groove in the mounting plate (Figure 28, item 2).



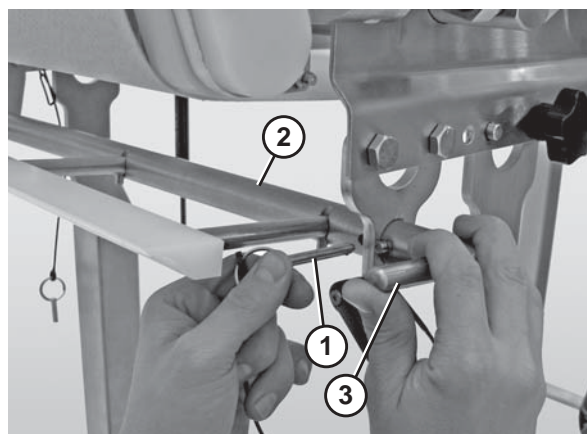
**Figure 28**

4. Attach the scraper bar holders (Figure 29, item 1) to the scraper shaft (Figure 29, item 2).



**Figure 29**

5. Attach the UHMW scraper (Figure 29, item 3) to the scraper bar holders (Figure 29, item 1).
6. Insert the pin (Figure 30, item 1) to lock the scraper bar in place (Figure 30, item 2).



**Figure 30**



# Installation

- Adjust the scraper to the desired position using the scraper bar handle (Figure 30, item 3).

## CAUTION

Apply minimal pressure between the scraper (Figure 31, item 1) and the belt (Figure 31, item 2).

Positioning the scraper so that it is digging into the belt will increase resistance, cause unnecessary strain on the motor and lead to premature belt failure.

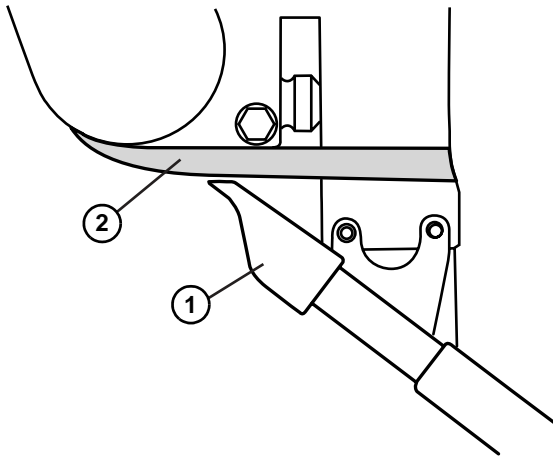


Figure 31

- Secure the scraper by tightening the handle (Figure 32, item 1).

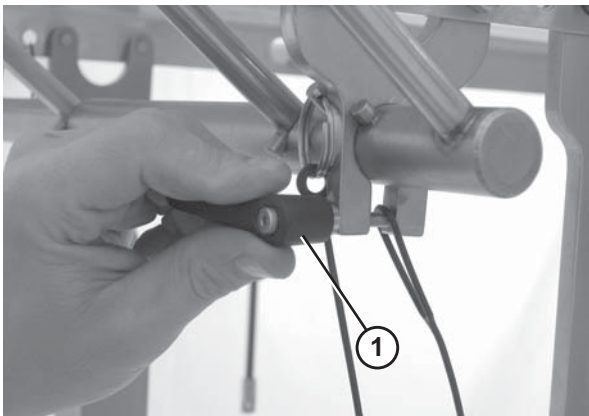


Figure 32

## Stand Installation

### Typical Stand Components (Figure 33)

- |   |   |
|---|---|
| 1 | Conveyor                                  |
| 2 | Stand                                     |
| 3 | Knob                                      |
| 4 | M10-1.50 x 12 mm hex head cap screws (x2) |

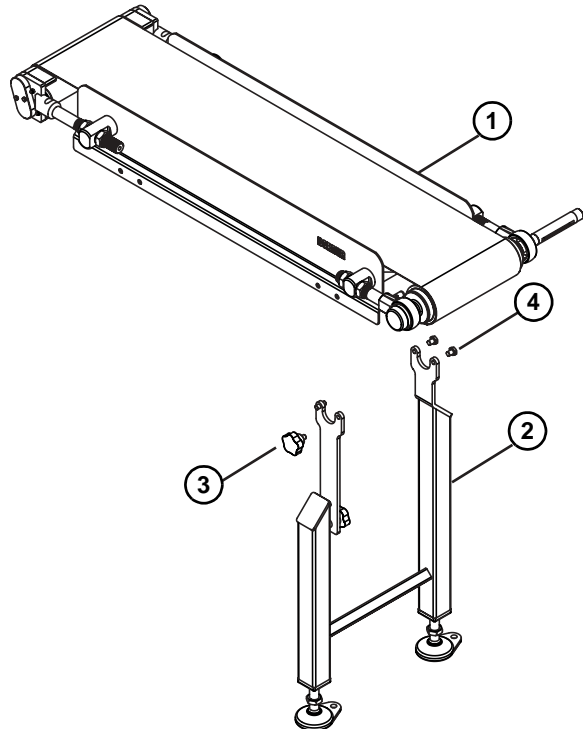


Figure 33

- Properly support the conveyor.
- Attach the non-quick release side of the stand (Figure 34, item 1) to the MOTOR SIDE of the conveyor (Figure 34, item 2) using two M10-1.5 x 12mm hex head cap screws (Figure 34, item 3).

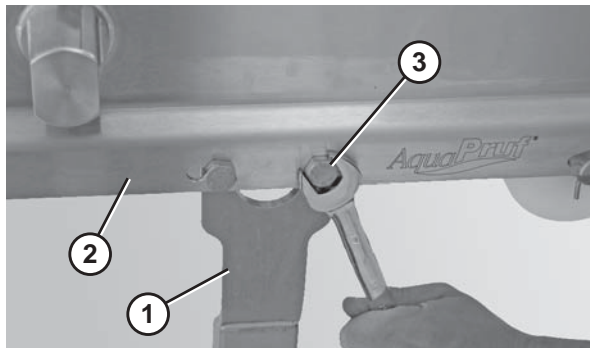


Figure 34

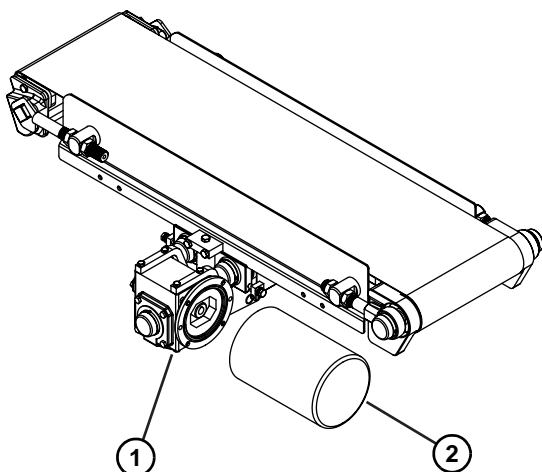
- Attach the quick-release arm to the stand with the knob. (Figure 33, item 3).

For detailed assembly instructions, refer to the "Sanitary Support Stands Installation, Maintenance and Parts Manual."

## Drive Package Installation

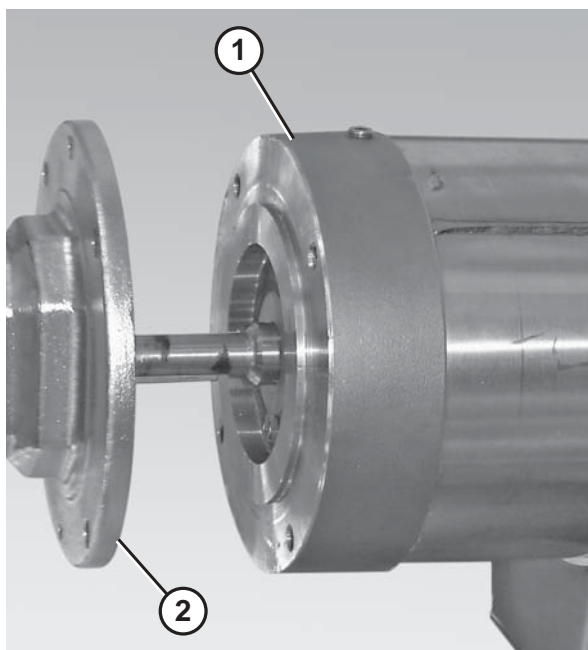
### Typical Motor Components (Figure 35)

- |   |                   |
|---|-------------------|
| 1 | End drive package |
| 2 | Motor             |



**Figure 35**

1. Attach the motor (Figure 36, item 1) to the gear reducer (Figure 36, item 2).

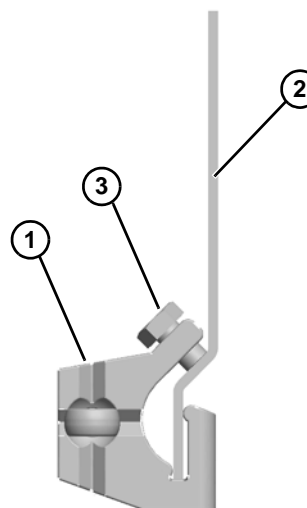


**Figure 36**

For detailed assembly instructions, refer to the “7600 Series Center Drive Packages Installation, Maintenance and Parts Manual.”

## Mounting Block Installation

1. Clamp mounting block (Figure 37, item 1) to frame (Figure 37, item 2).
2. Tighten bolt to 20 in-lb (2 Nm) (Figure 37, item 3) to secure.



**Figure 37**



### CAUTION

Do not overtighten bolt. Over tightening may cause the mounting block to deform.

# Preventive Maintenance and Adjustment

## Required Tools

- 8 mm wrench (or adjustable wrench)
- 10 mm wrench
- 17 mm wrench
- 14 mm wrench
- 1/8" hex wrench (for bearing shaft assembly fasteners)
- 3 mm hex wrench

## Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 30 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.

## Routine Cleaning

### ⚠ WARNING



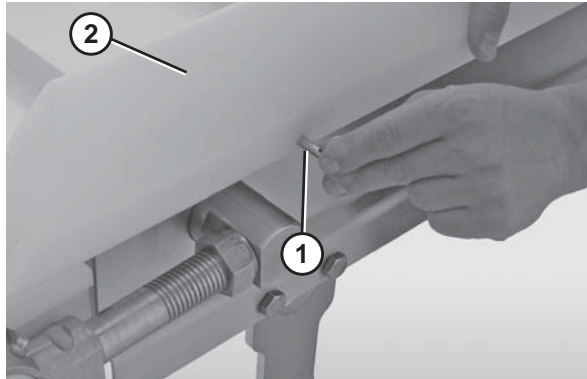
#### SEVERE HAZARD!

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

Dorner recommends cleaning the inside and the outside of the conveyor on a daily basis. Refer to the following steps to access the inside of the conveyor.

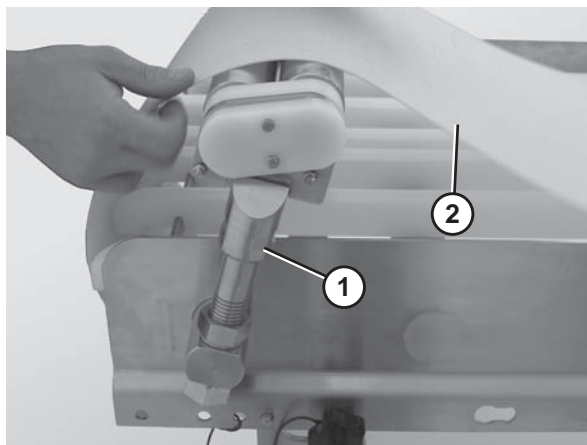
## Standard Conveyors

1. Remove the guides, if applicable, by removing the pull pins (**Figure 38, item 1**) that connect the guide (**Figure 38, item 2**) to the frame.



**Figure 38**

2. Place the tip up tail (**Figure 39, item 1**) in the up position.



**Figure 39**

3. Lift up on the belt (**Figure 39, item 2**).

# Preventive Maintenance and Adjustment

## Conveyors with Lifters

1. Remove the guides, if applicable, by removing the pull pins (**Figure 38, item 1**) that connect the guide (**Figure 38, item 2**) to the frame.
2. Place the tip up tail in the up position.
3. Use the lifter handle (**Figure 40, item 1**) to raise the belt (**Figure 40, item 2**).

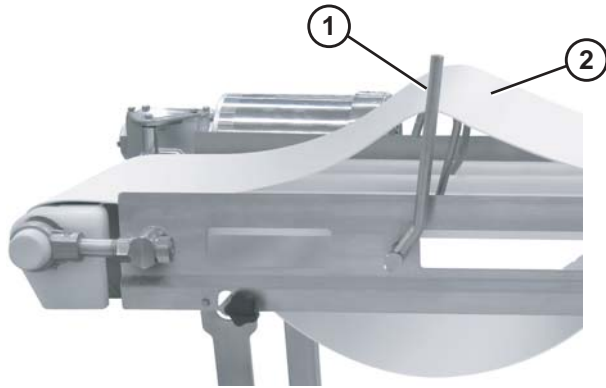


Figure 40



### CAUTION

**DO NOT submerge or soak bearing assemblies. This will reduce the life of the bearing.**

## Periodic Cleaning

Dorner recommends complete disassembly of the conveyor periodically for thorough cleaning.

For conveyor disassembly and reassembly instructions:

- Refer to “Conveyor Belt Replacement” on page 16.
- Refer to “Spindle Removal” on page 19.

## Lubrication

### Conveyor Bearings

Conveyor bearing lubrication is required. Dorner recommends using an H-1 food grade grease.

### NOTE

*Although bearings are sealed, re-greasing is recommended to increase bearing life. An H-1 food grade grease is recommended. The frequency of bearing re-greasing is dependent upon the application in which the conveyor is being used. Frequency of re-greasing will increase with the frequency of conveyor washing.*

1. Add grease to the bearing using the zerk fitting (**Figure 41, item 1**) on the exterior of the bearing shaft assembly.

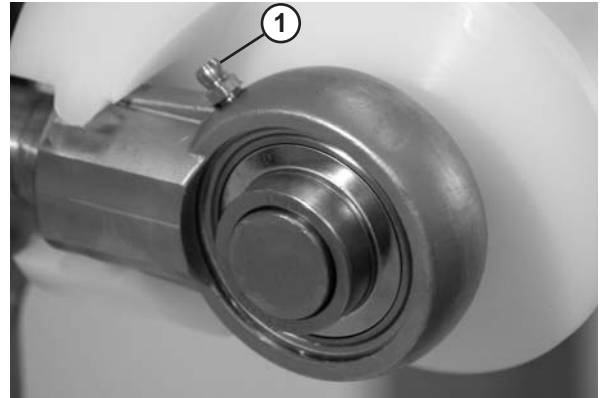


Figure 41

2. Replace the bearings if they become worn.

## Wearstrips and Belt Returns

Replace the wearstrips and belt returns if they become worn.

For wearstrip and belt return installation instructions:

- Refer to “Wear Strip Installation” on page 7.
- Refer to “Belt Return Installation” on page 10.

## Scraper

Replace the UHMW scraper if it becomes worn.

Refer to “Scraper Installation” on page 11 for scraper installation instructions.

## Maintaining the Conveyor Belt

### Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear

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

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories
- Excessive load on belt
- Dirt impacted on spindle
- Excessive or improper side loading
- Improper tracking

Skipping indicates:

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

# Preventive Maintenance and Adjustment

## Conveyor Belt Replacement

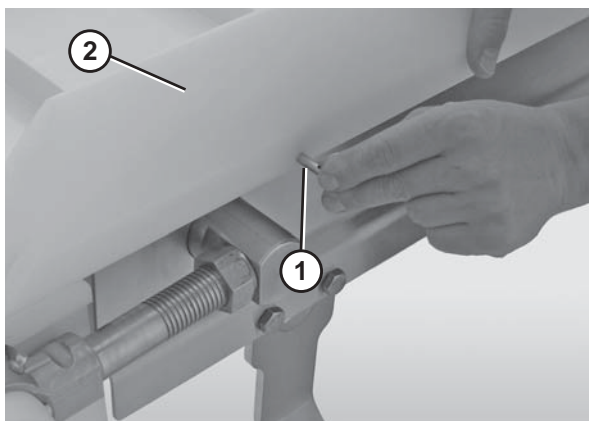
### **WARNING**



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

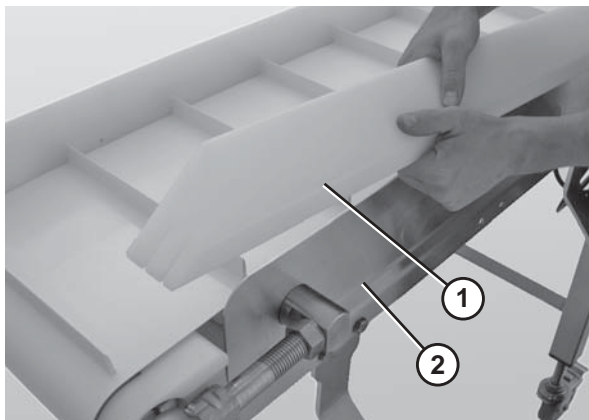
### Conveyors with Guides

1. Remove the pull pins (**Figure 42, item 1**) that connect the guide (**Figure 42, item 2**) to the frame.



**Figure 42**

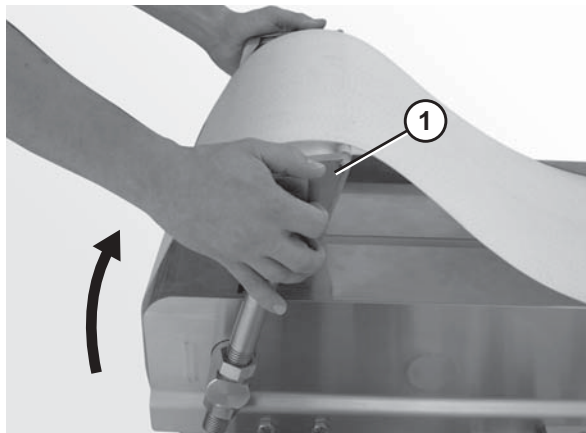
2. Remove the guide (**Figure 43, item 1**) from the conveyor (**Figure 43, item 2**).



**Figure 43**

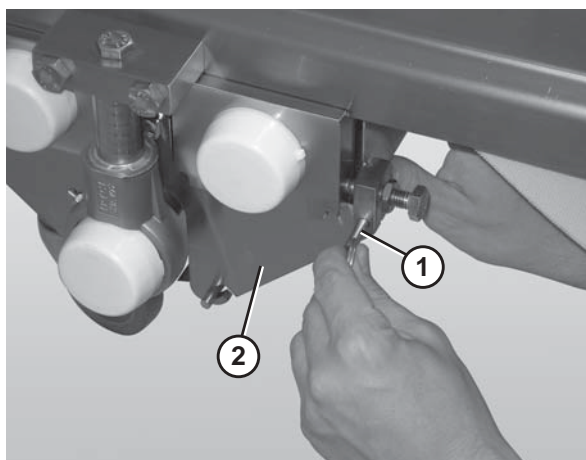
### Standard Belts

1. Place the idler tail (**Figure 44, item 1**) in the up position.



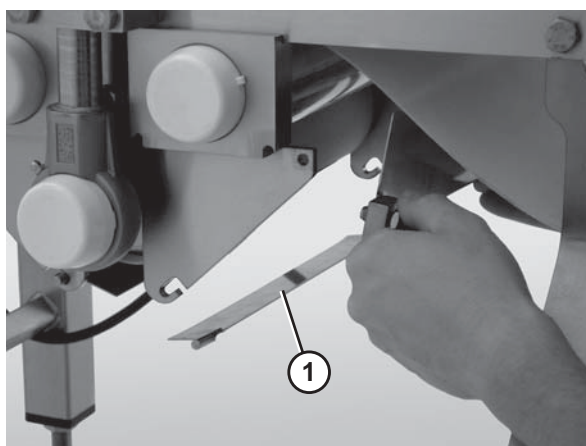
**Figure 44**

2. Remove the pull pins (**Figure 45, item 1**) from the center drive side plate (**Figure 45, item 2**).



**Figure 45**

3. Lift up on the center drive guard (**Figure 46, item 1**) and remove it.



**Figure 46**



# Preventive Maintenance and Adjustment

4. Slide the tension spindle assembly (Figure 47, item 1) out of the housing.

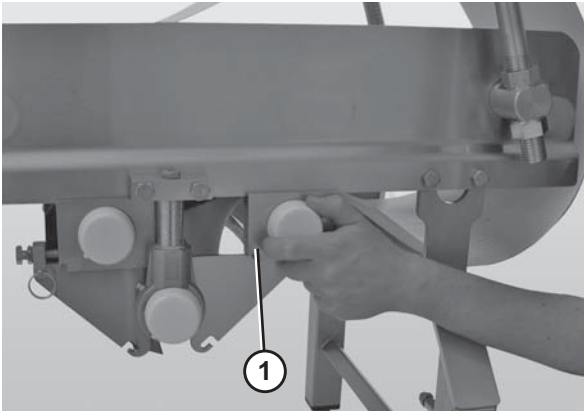


Figure 47

5. Repeat steps 2 - 4 on the other side of the drive assembly.

<b>⚠ WARNING</b>
<b>SEVERE HAZARD!</b> <ul style="list-style-type: none"><li>• <b>ONLY DISCONNECT ONE PIVOT BRACKET AT A TIME AND ONLY IF THE STANDS ARE BOLTED TO THE FLOOR.</b></li><li>• <b>Disconnecting more than one pivot bracket at a time or not bolting the stands to the floor can cause the conveyor to tip and may result in serious injury.</b></li></ul>

6. Lower the quick release arm (Figure 48, item 1) on one of the stands. *Note: if the conveyor is not equipped with Quick Release (QR Type) stands, it will be necessary to remove the entire stand.* For detailed instructions, refer to the “Sanitary Support Stands Installation, Maintenance and Parts Manual.”

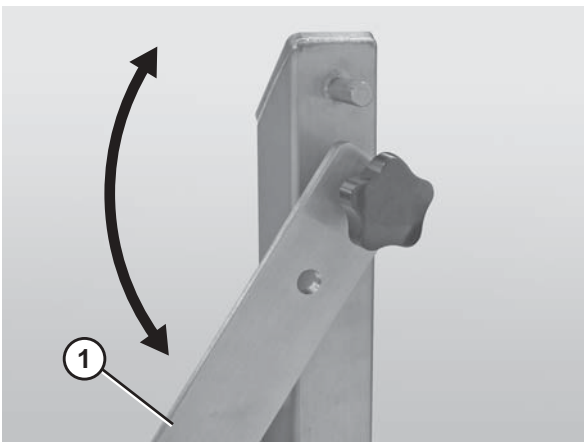


Figure 48

7. Slide the old belt (Figure 49, item 1) off the conveyor frame (Figure 49, item 2).

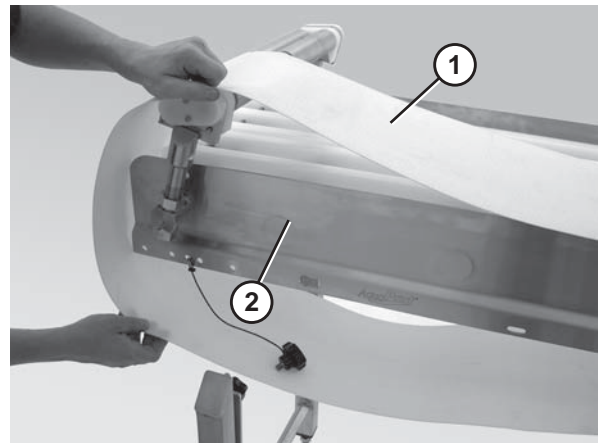


Figure 49

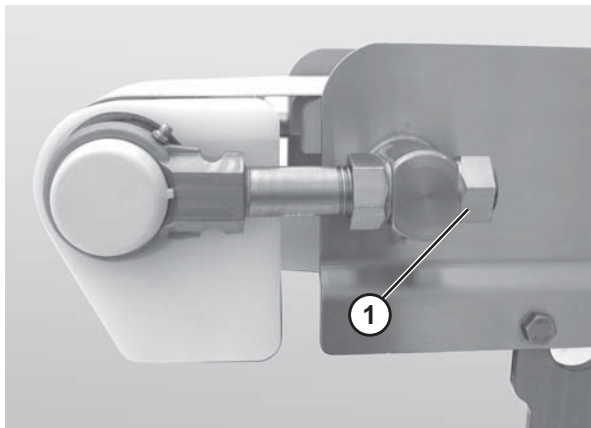
8. Secure the quick release arm on the stand and repeat steps 6 and 7 until the entire belt is off the conveyor.
9. Replace the old belt with a new one. Refer to “Belt Installation” on page 8.

## Conveyor Belt Tensioning

<b>⚠ WARNING</b>
<b>SEVERE HAZARD!</b> <p><b>LOCK OUT POWER</b> before removing guards or performing maintenance. Exposed moving parts can cause serious injury.</p>
<b>⚠ CAUTION</b>
<b>Over-tensioning of conveyor may stretch conveyor belt and reduce bearing life.</b>

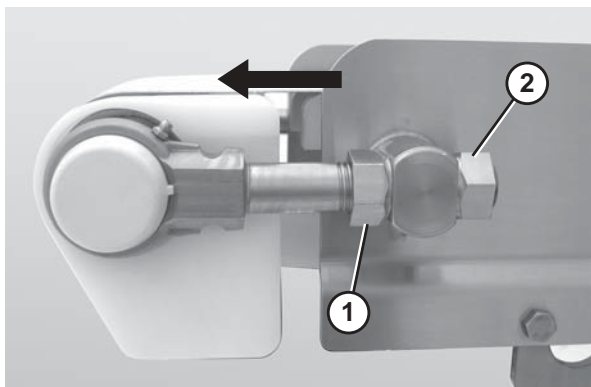
# Preventive Maintenance and Adjustment

1. Loosen the back nuts (**Figure 50, item 1**) on both sides of the idler tail shaft.



**Figure 50**

2. Turn the front nuts closest to the tail (**Figure 51, item 1**) clockwise in order to increase tension on the belt.



**Figure 51**

## **⚠ CAUTION**

Ensure that there is at least 6" (152 mm) from the frame to the end of the tail.



**Figure 52**

3. Tighten the back nuts (**Figure 51, item 2**) to secure the tail.

## Conveyor Belt Tracking

### IMPORTANT

When installing a new belt, set conveyor tracking elements to the "zero position" and start the tracking procedure. The zero position is when the tails are tensioned out to the 6" dimension as shown in (**Figure 52**, and the infeed tension roller (**Figure 55, item 1**) on the center drive assembly is set to its outermost position (roller away from center of box, against guard).

### Tracking Procedure

Inspect belt tracking at tails and at center drive assembly. Track belt where needed. Refer to "Conveyor Belt Tracking at Tails" on page 18 and "Conveyor Belt Tracking at Center Drive" on page 19.

For conveyors 6 ft long and under, the majority of the belt tracking will be accomplished at the center drive assembly (may be able to track belt without tracking the tails).

### Conveyor Belt Tracking at Tails

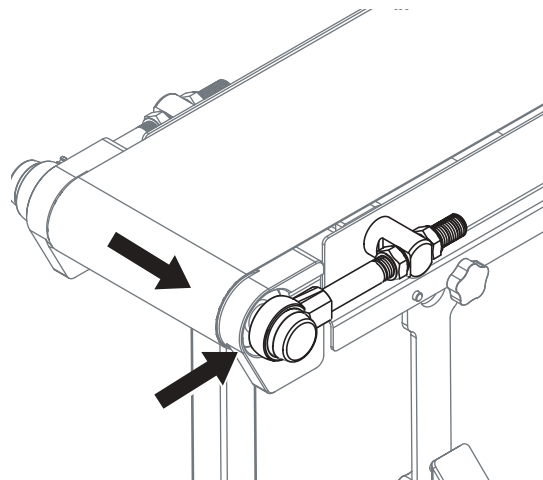
To adjust conveyor belt tracking at the tails:

1. Loosen the back nut (**Figure 51, item 2**) on the idler tail shaft that needs to be adjusted.
2. Tighten the front nut (**Figure 51, item 1**) on the idler tail shaft to adjust the belt tracking.

## **⚠ CAUTION**

Ensure that there is at least 6" (152 mm) from the frame to the end of the tail.

- a. Loosen the nut to shorten the length of the idler tail shaft and bring the belt closer to that side of the conveyor (**Figure 53**).

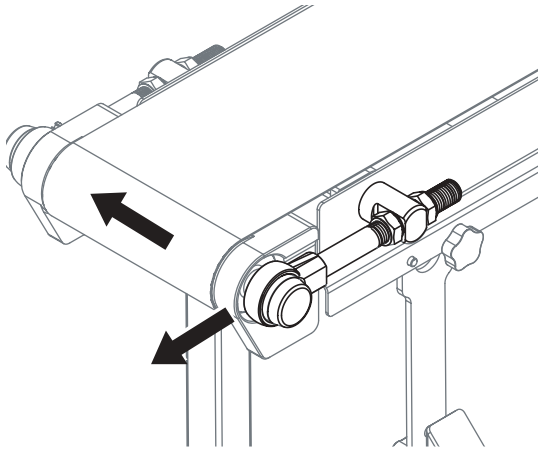


**Figure 53**



# Preventive Maintenance and Adjustment

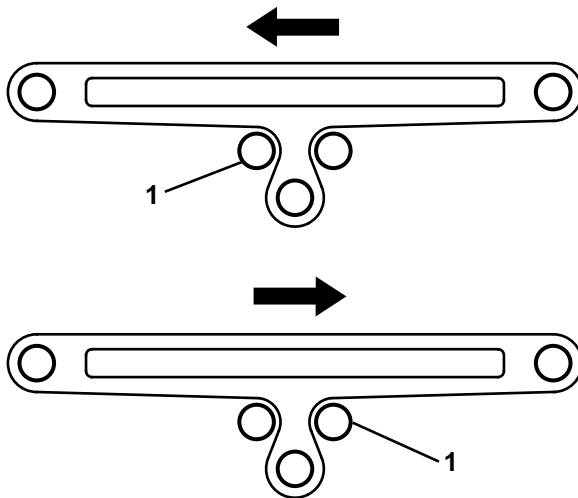
- b. Tighten the nut to increase the length of the idler tail shaft and move the belt away from that side of the conveyor (**Figure 54**).



**Figure 54**

3. Tighten the back nut on the idler tail shaft when finished.

## Conveyor Belt Tracking at Center Drive

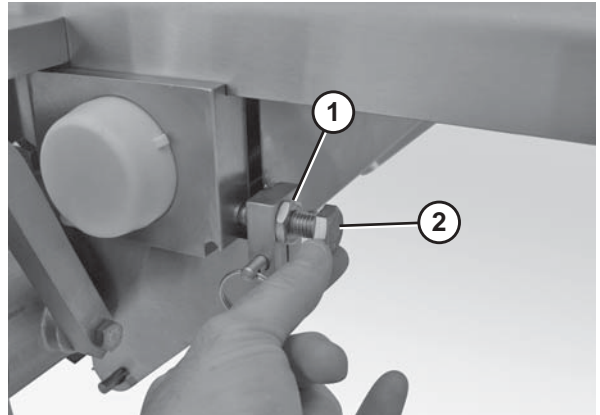


**Figure 55**

Tracking of belt through the center drive is done by adjusting the position of the infeed roller (**Figure 55, item 1**) on the center drive assembly.

To adjust conveyor belt tracking at the center drive:

1. Loosen the guide plate nuts (**Figure 56, item 1**) on the infeed side of the center drive assembly.



**Figure 56**

2. Tighten the guide plate bolt (**Figure 56, item 2**) to move the belt away from that side of the conveyor.
3. Tighten the guide plate nuts when finished.

## IMPORTANT

*Belt tracking will need to be readjusted if the direction of travel is changed.*

## Spindle Removal

### ⚠ WARNING



### SEVERE HAZARD!

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

1. Remove the conveyor belt to access the spindles. Refer to "Conveyor Belt Replacement" on page 16.
2. Remove the spindle by following the instructions for the specific spindle type:
  - A - Center Drive Spindle Removal
  - B - Idler Spindle Removal
  - C - .5" Nose Bar Idler Spindle Removal
  - D - 1" Nose Bar Idler Spindle Removal
  - E - 1.875" Nose Bar Idler Spindle Removal

# Preventive Maintenance and Adjustment

## A - Center Drive Spindle Removal

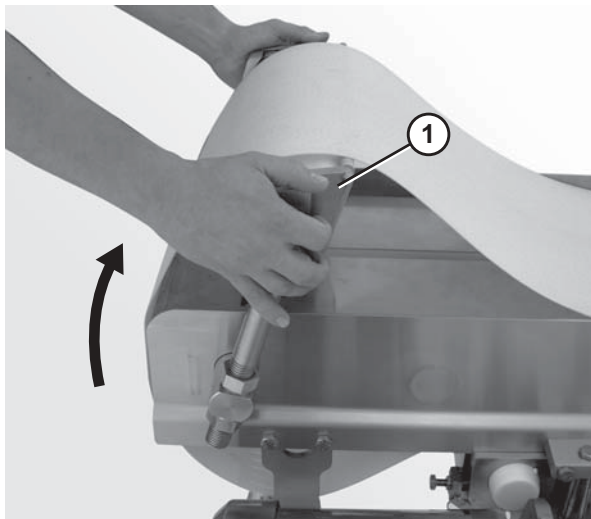
### **WARNING**



#### **PUNCTURE HAZARD!**

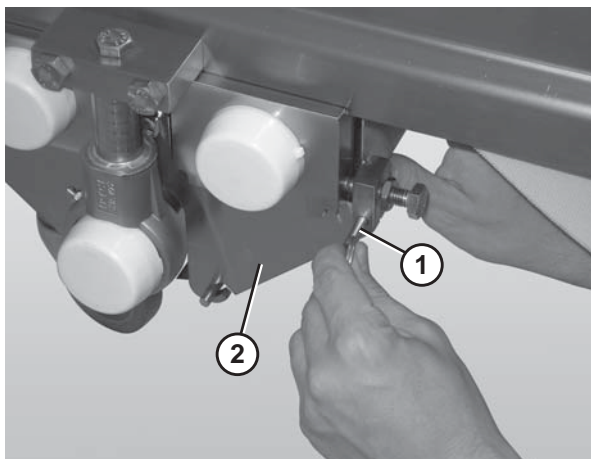
Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.

1. Place the idler tail (Figure 57, item 1) in the up position.



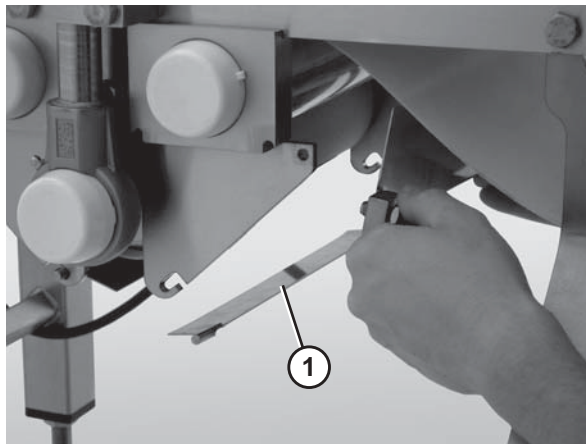
**Figure 57**

2. Remove the pull pins (Figure 58, item 1) from the center drive side plate (Figure 58, item 2).



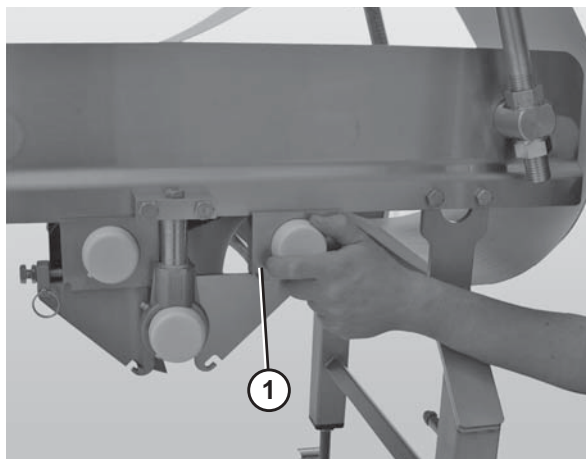
**Figure 58**

3. Lift up on the center drive guard (Figure 59, item 1) and remove it.



**Figure 59**

4. Slide the tension spindle assembly (Figure 60, item 1) out of the housing.



**Figure 60**

5. Repeat steps 2 - 4 on the other side of the drive assembly.

### **WARNING**

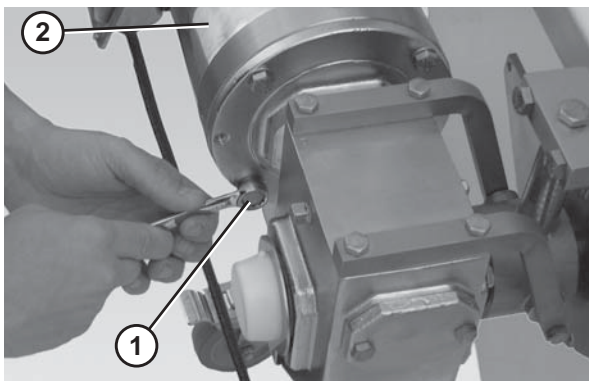


#### **CRUSH HAZARD!**

- **SUPPORT MOTOR PRIOR TO LOOSENING THE BOLTS.**
- **Loosening motor bolts may cause it to drop down, causing serious injury.**

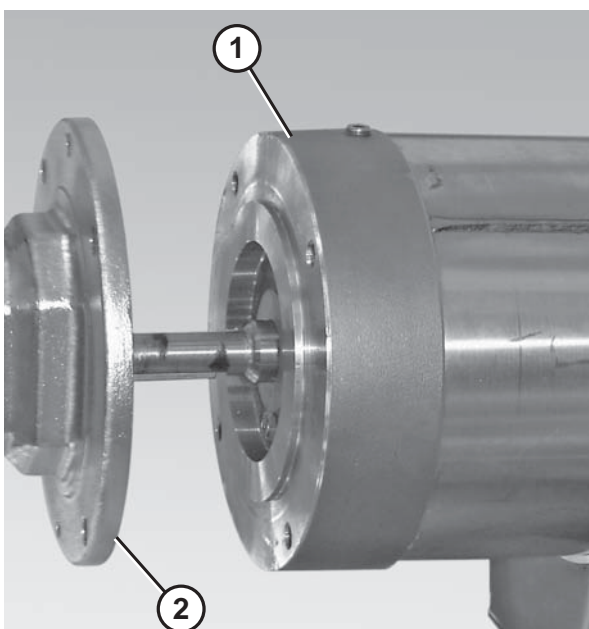
6. Remove the bolts (Figure 61, item 1) that connect the motor (Figure 61, item 2) to the gear reducer (Figure 61, item 3).

## Preventive Maintenance and Adjustment



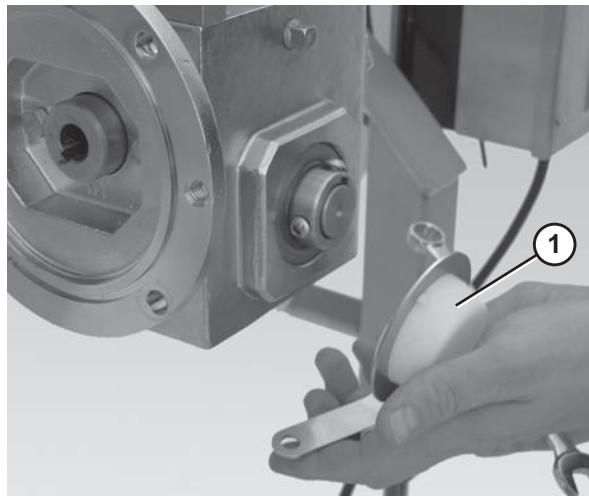
**Figure 61**

7. Disconnect the motor (**Figure 62, item 1**) from the gear reducer (**Figure 62, item 2**).



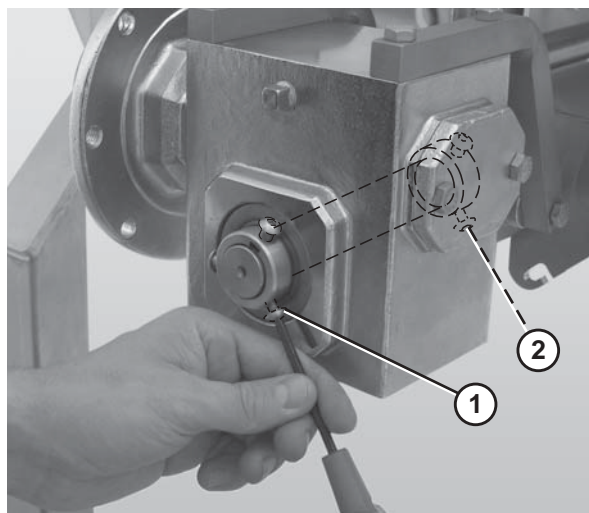
**Figure 62**

8. Remove the drive spindle cover (**Figure 63, item 1**).



**Figure 63**

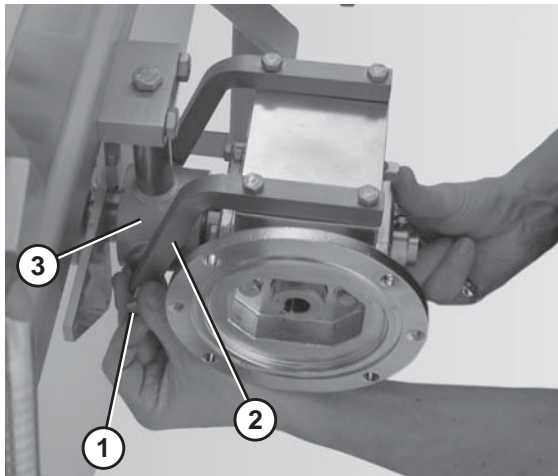
9. Use a 4 mm hex wrench to loosen the outside button head screws (**Figure 64, item 1**) and the inside button head screws (**Figure 64, item 2**) that connect the gearmotor to the drive spindle.



**Figure 64**

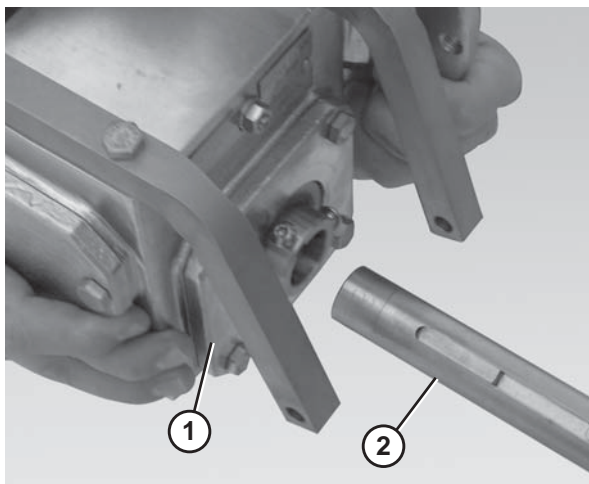
# Preventive Maintenance and Adjustment

10. Remove the bolts (**Figure 65, item 1**) that connect the bent bars (**Figure 65, item 2**) to the drive mounting bracket (**Figure 65, item 3**).



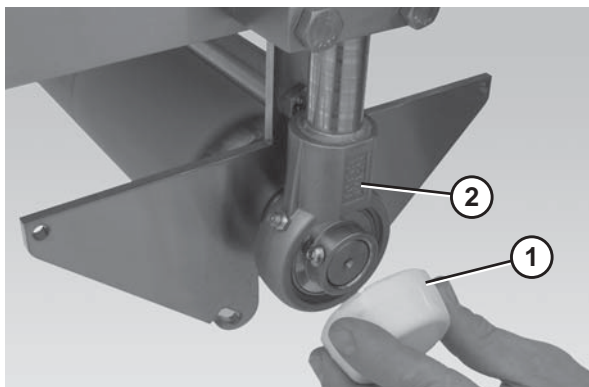
**Figure 65**

11. Slide the gear reducer (**Figure 66, item 1**) off the drive shaft (**Figure 66, item 2**).



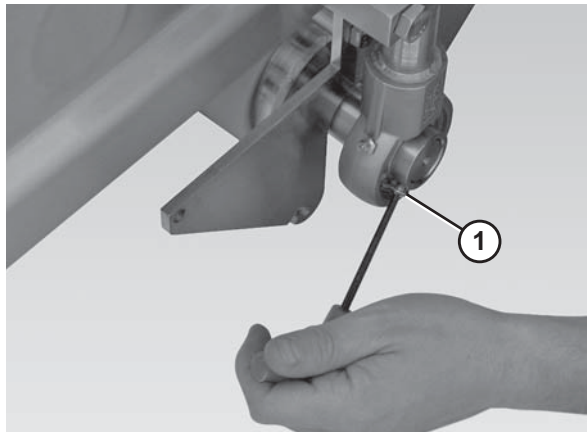
**Figure 66**

12. Remove the bearing cover (**Figure 67, item 1**) on the center drive shaft assembly (**Figure 67, item 2**).



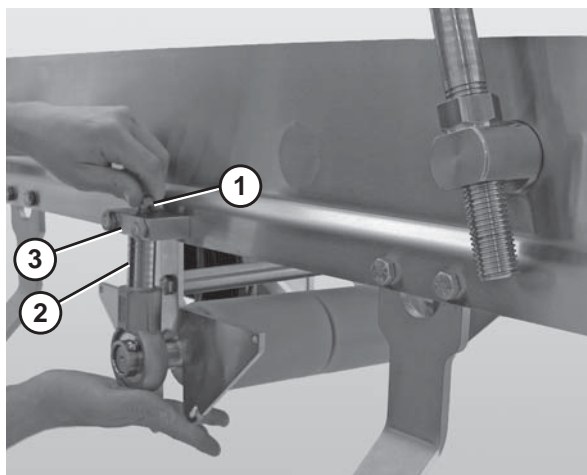
**Figure 67**

13. Use a 4 mm hex wrench to loosen the button head screws on the bearing (**Figure 68, item 1**).



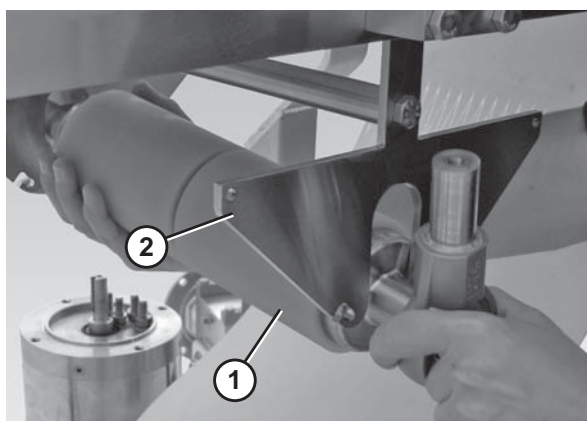
**Figure 68**

14. Remove the bolt (**Figure 69, item 1**) that connects the drive shaft assembly (**Figure 69, item 2**) to the block shaft mount (**Figure 69, item 3**).



**Figure 69**

15. Lower the end of the drive shaft spindle (**Figure 70, item 1**) until it is clear of the side plate (**Figure 70, item 2**) and remove it.



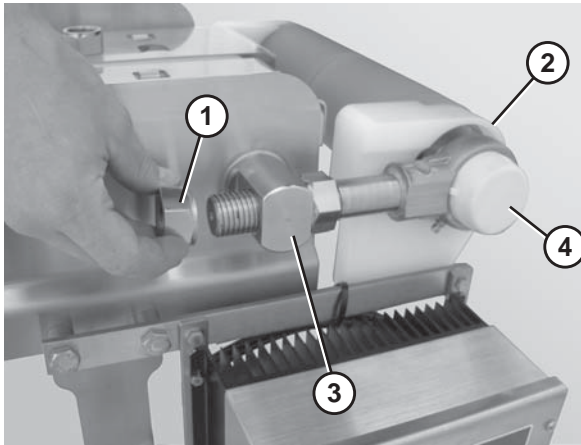
**Figure 70**



# Preventive Maintenance and Adjustment

## B - Idler Spindle Removal

1. Remove the back nuts (**Figure 71, item 1**) on both idler tail shafts.



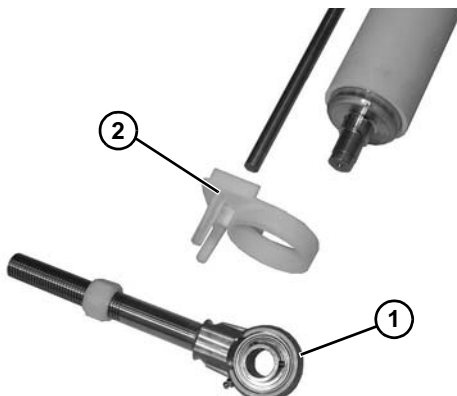
**Figure 71**

2. Slide the idler tail assembly (**Figure 71, item 2**) out of the take up blocks (**Figure 71, item 3**).
3. Remove the bearing covers (**Figure 71, item 4**).
4. Use a 4 mm hex wrench (**Figure 72, item 1**) to loosen the bearing shaft assembly fasteners (**Figure 72, item 2**).



**Figure 72**

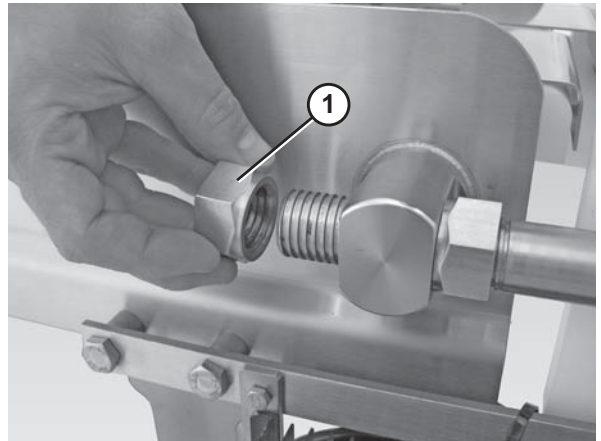
5. Remove the bearing shafts (**Figure 73, item 1**) and both pinch guards (**Figure 73, item 2**).



**Figure 73**

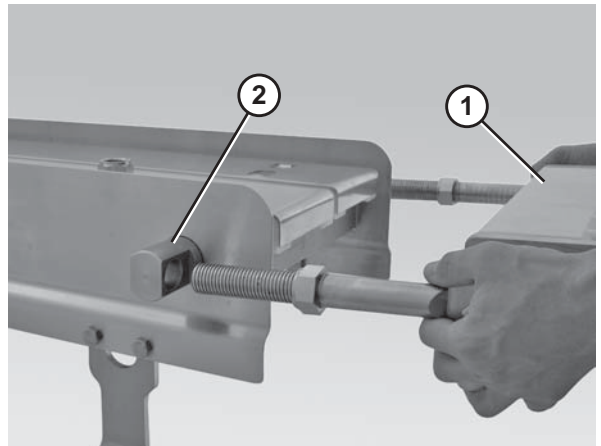
## C - .5" Nose Bar Idler Spindle Removal

1. Remove the back nuts (**Figure 74, item 1**) on both discharge nose bar shafts.



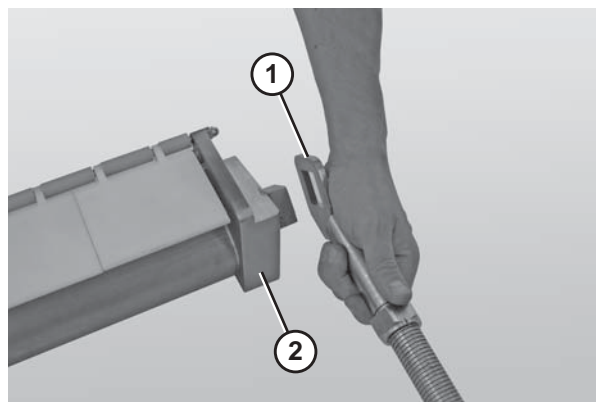
**Figure 74**

2. Slide the nose bar tail assembly (**Figure 75, item 1**) out of the take up blocks (**Figure 75, item 2**).



**Figure 75**

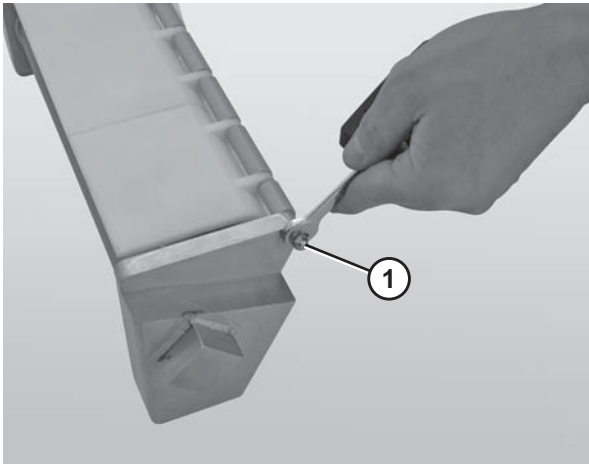
3. Slide the nose bar shafts (**Figure 76, item 1**) off of the nose bar weldment (**Figure 76, item 2**).



**Figure 76**

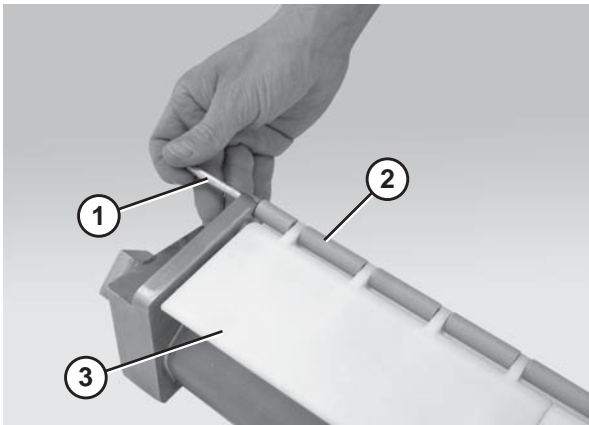
# Preventive Maintenance and Adjustment

4. Use a 10 mm wrench to remove one of the acorn nuts (**Figure 77, item 1**) from the nose bar shaft.



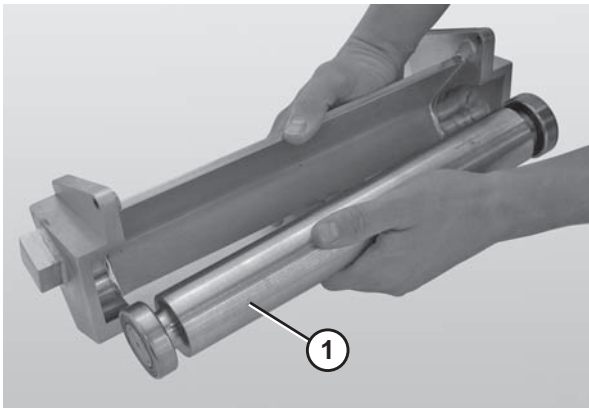
**Figure 77**

5. Remove the nose bar shaft (**Figure 78, item 1**), the rollers (**Figure 78, item 2**) and the roller mounts (**Figure 78, item 3**).



**Figure 78**

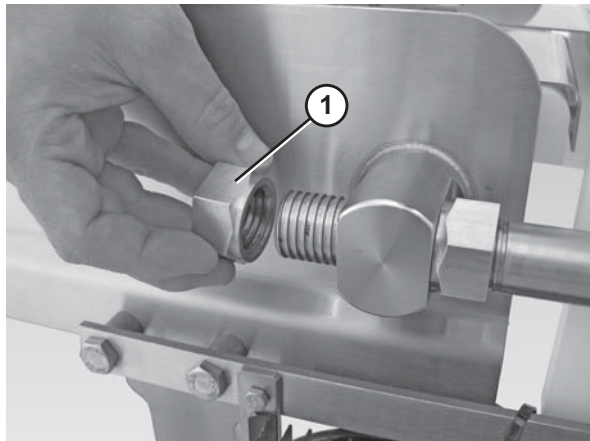
6. Remove the nose bar return spindle (**Figure 79, item 1**).



**Figure 79**

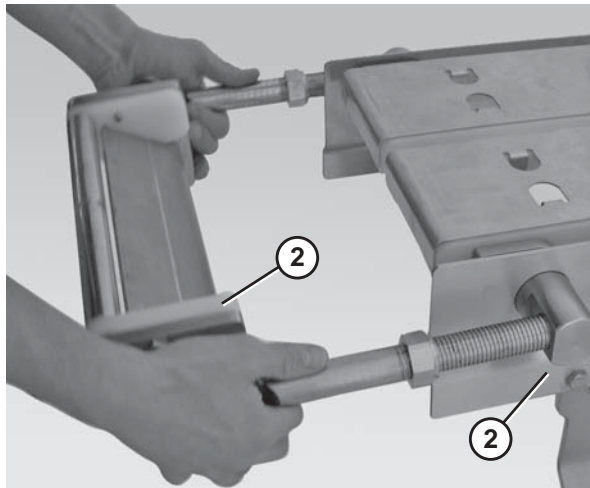
## D - 1" Nose Bar Idler Spindle Removal

1. Remove the back nuts (**Figure 80, item 1**) on both discharge nose bar shafts.



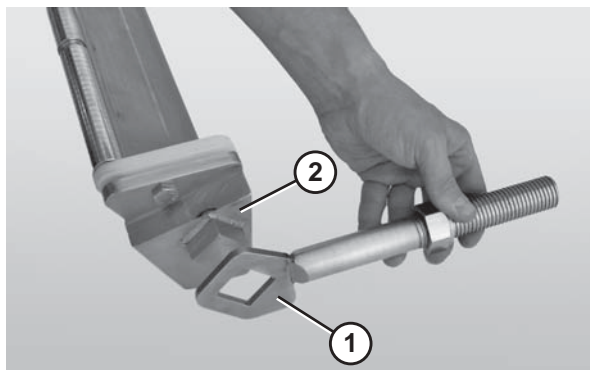
**Figure 80**

2. Slide the nose bar tail assembly (**Figure 81, item 1**) out of the take up blocks (**Figure 81, item 2**).



**Figure 81**

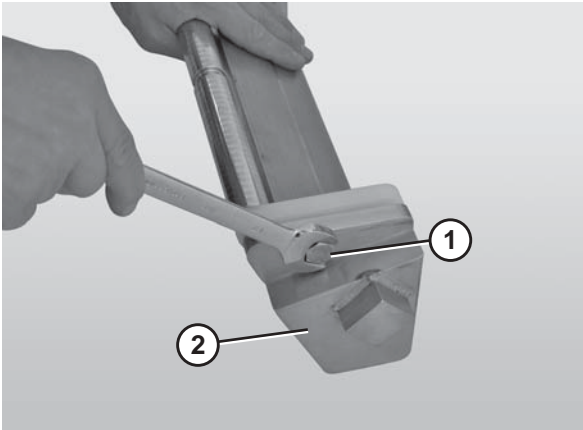
3. Slide the nose bar shafts (**Figure 82, item 1**) off of the nose bar weldment (**Figure 82, item 2**).



**Figure 82**

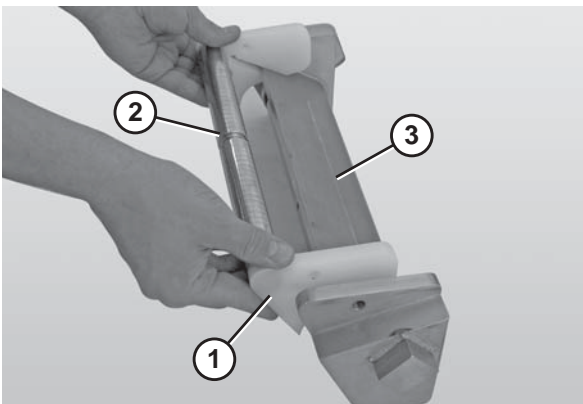
# Preventive Maintenance and Adjustment

4. Use a 17 mm wrench to remove both pilot nose bolts (**Figure 83, item 1**) from the nose bar weldment (**Figure 83, item 2**).



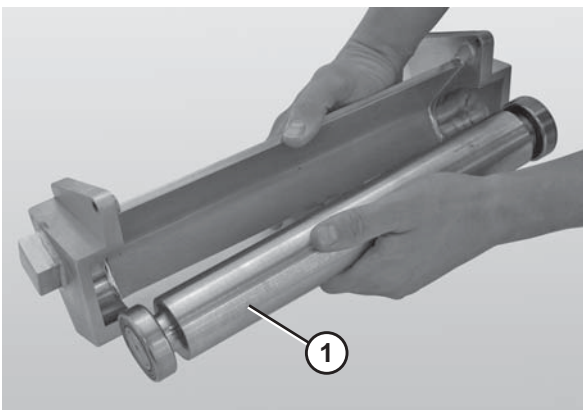
**Figure 83**

5. Slide the nose bar puck holders (**Figure 84, item 1**) and the nose bar spindle (**Figure 84, item 2**) off of the nose bar weldment (**Figure 84, item 3**).



**Figure 84**

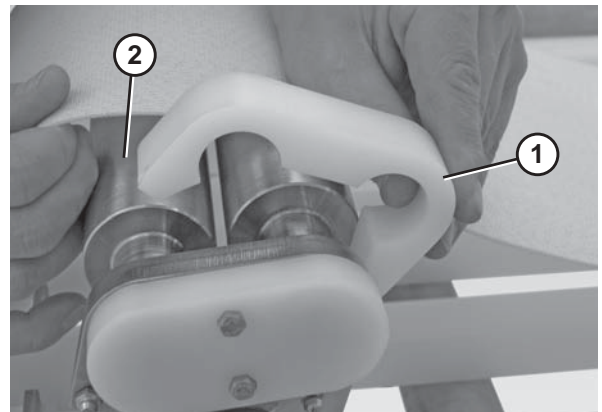
6. Remove the nose bar return spindle (**Figure 85, item 1**).



**Figure 85**

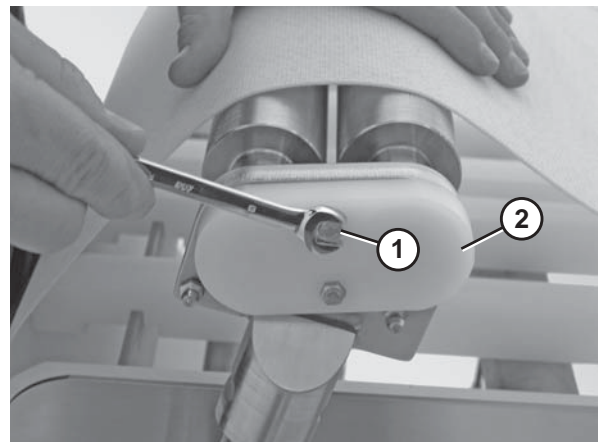
## E - 1.875" Nose Bar Idler Spindle Removal

1. Slide the pinch guard blocks (**Figure 86, item 1**) off the nose bar spindles (**Figure 86, item 2**).



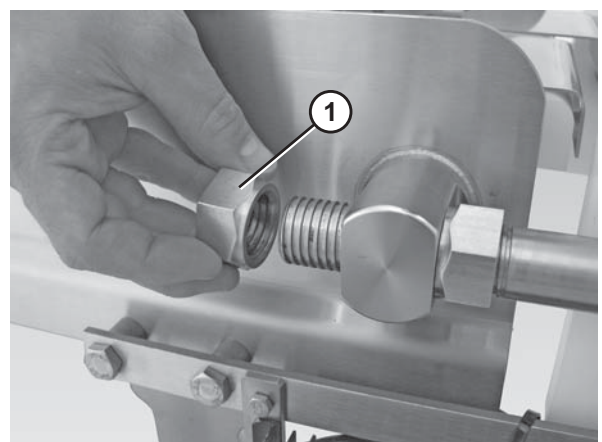
**Figure 86**

2. Remove the transfer bearing screws (**Figure 87, item 1**) and the cover (**Figure 87, item 2**) using an 8 mm wrench.



**Figure 87**

3. Remove the back nuts (**Figure 88, item 1**) on both discharge nose bar shafts.

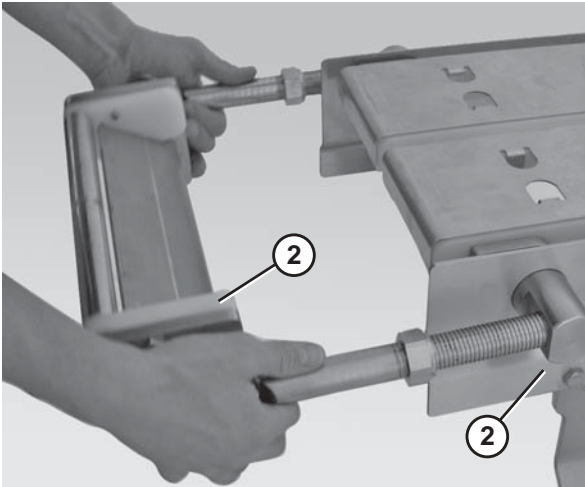


**Figure 88**



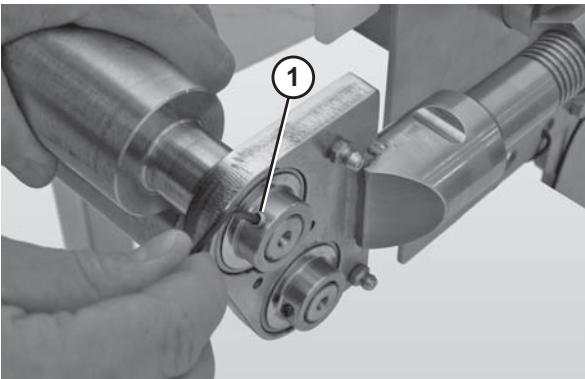
# Preventive Maintenance and Adjustment

- Slide the nose bar tail assembly (**Figure 89, item 1**) out of the take up blocks (**Figure 89, item 2**).



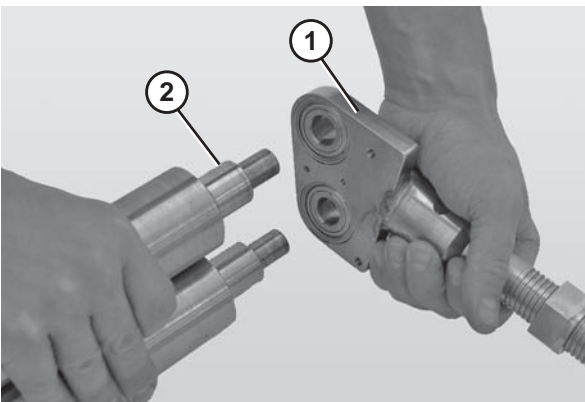
**Figure 89**

- Use a 4 mm hex wrench to loosen all the bearing fasteners (**Figure 90, item 1**).



**Figure 90**

- Slide the nose bar shafts (**Figure 91, item 1**) off the nose bar spindles (**Figure 91, item 2**).



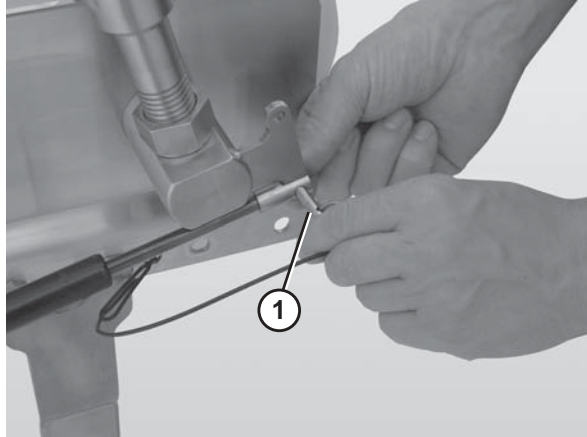
**Figure 91**

## Reassembling Tail Assemblies

Refer to the "Service Parts" section starting on page 30 for complete diagrams and lists of all tail assembly components.

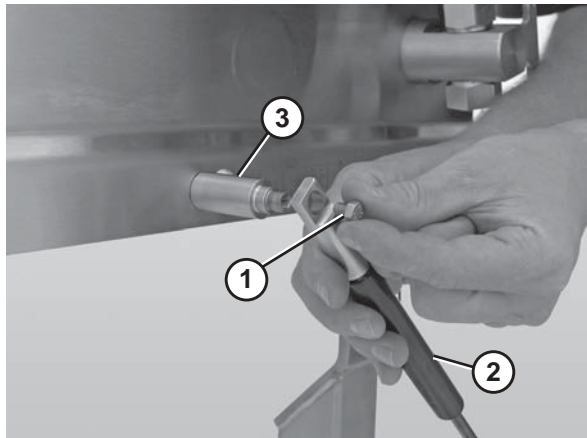
## Gas Assist Replacement

- Raise the tip up tail.
- Remove the pull pin (**Figure 92, item 1**).



**Figure 92**

- Remove the hex bolt (**Figure 93, item 1**) that connects the gas spring (**Figure 93, item 2**) to the gas spring standoff post (**Figure 93, item 3**).



**Figure 93**

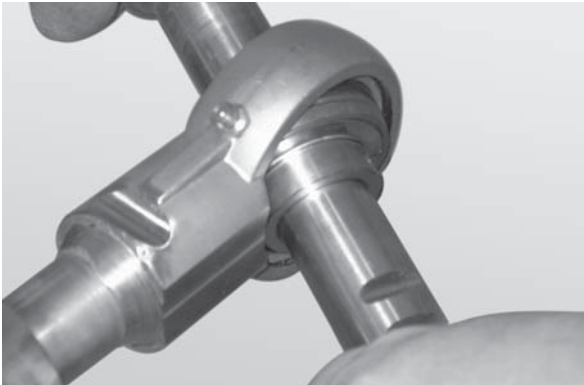
- Remove the inside hex bolt that connects the standoff post (**Figure 93, item 3**) to the frame.

# Preventive Maintenance and Adjustment

## Bearing Replacement

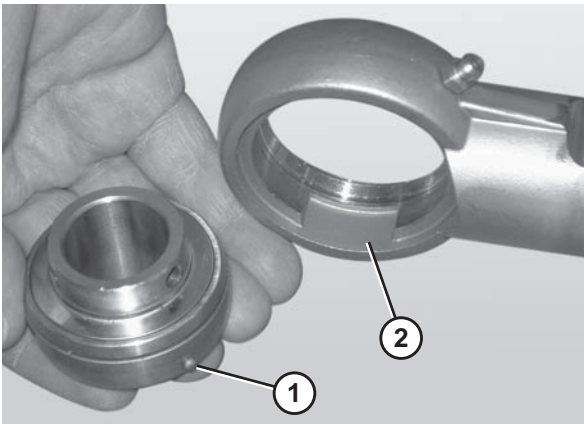
### Standard Bearings

1. Secure the bearing shaft.
2. Remove the bearing cover.
3. Insert the rod end of another bearing shaft through the bearing orifice (**Figure 94**).



**Figure 94**

4. Apply lateral pressure to the rod until the bearing comes loose.
5. Remove the worn or damaged bearing (**Figure 95**).



**Figure 95**

6. Replace the bearing.

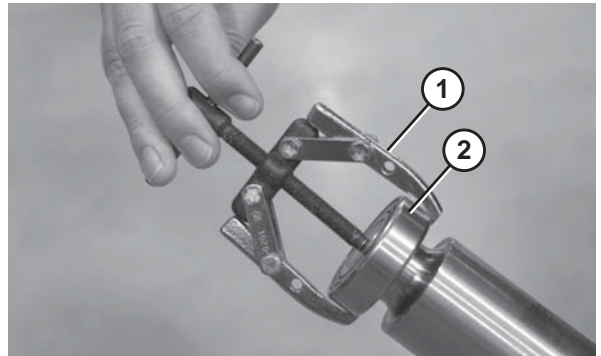
### NOTE

*When inserting the new bearing, make sure the anti-rotation notch (**Figure 95, item 1**) on the bearing lines up with the groove inside the housing (**Figure 95, item 2**).*

7. Use a hex wrench to tighten the bearing shaft assembly fasteners to 54 in-lbs (6 N•m). Check after 24 hours of conveyor use.

### .5" and 1" Nose Bar Return Spindle Bearings

1. Remove the nose bar return spindle. Refer to "Spindle Removal" starting on page 19.
2. Using a bearing removal tool (**Figure 96, item 1**), remove the bearing (**Figure 96, item 2**).

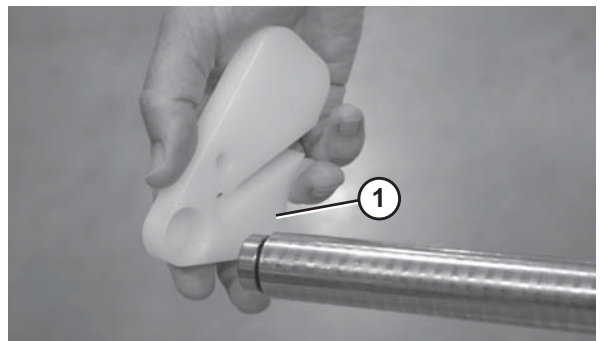


**Figure 96**

3. Replace the bearing.

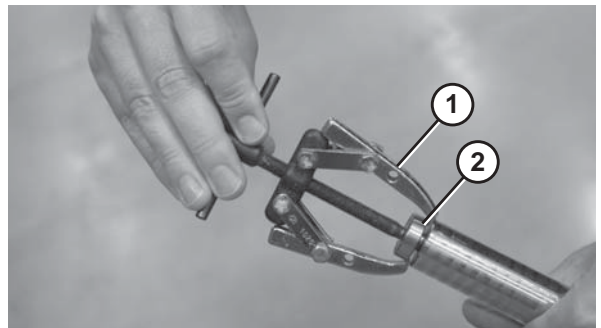
### 1" Nose Bar Bearings

1. Remove the nose bar spindle. Refer to "Spindle Removal" starting on page 19.
2. Remove the nose bar puck holders (**Figure 97, item 1**).



**Figure 97**

3. Using a bearing removal tool (**Figure 98, item 1**) remove the bearing (**Figure 98, item 2**).



**Figure 98**

4. Replace the bearing.

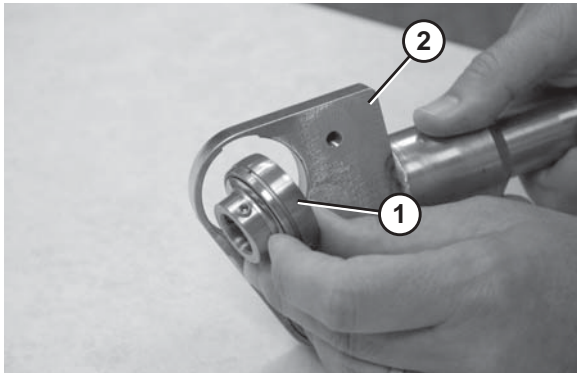
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# Preventive Maintenance and Adjustment

---

## 1.875" Nose Bar Bearings

1. Remove the nose bar spindle. Refer to "Spindle Removal" starting on page 19.
2. Remove the bearing (**Figure 99, item 1**) from the nose bar shaft assembly (**Figure 99, item 2**).

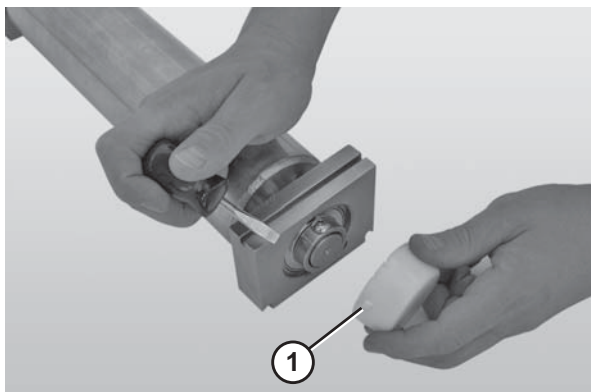


**Figure 99**

3. Replace the bearing.

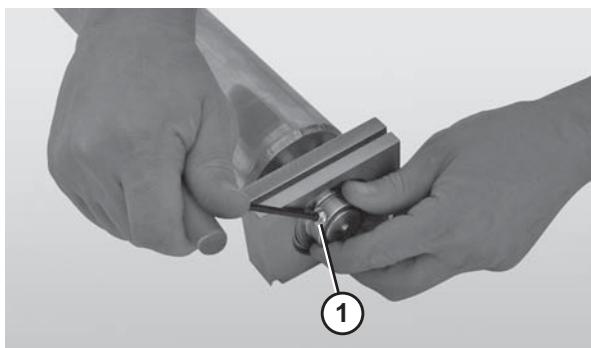
## Center Drive Tension Spindle Bearings

1. Remove the tension spindle. Refer to steps 1 - 5 in "A - Center Drive Spindle Removal" on page 20.
2. Remove the bearing cover (**Figure 100, item 1**).



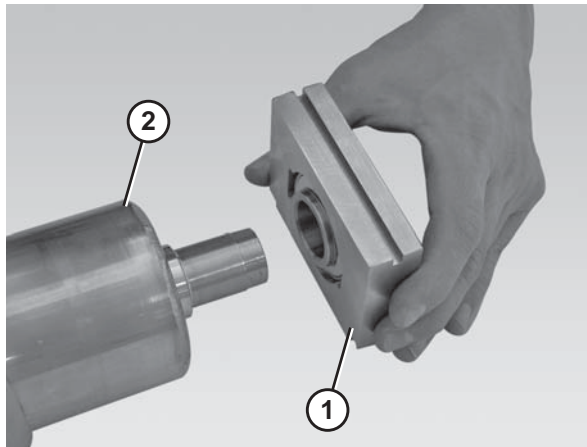
**Figure 100**

3. Use a 4 mm hex wrench to remove the button head screws that connect the bearing to the spindle (**Figure 101, item 1**).



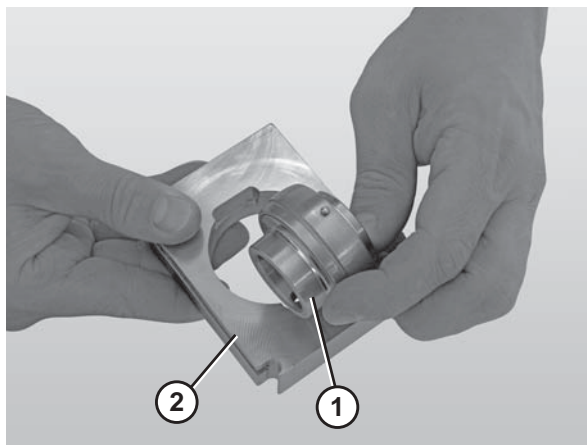
**Figure 101**

4. Slide the housing block (**Figure 102, item 1**) and bearing off of the tension spindle (**Figure 102, item 2**).



**Figure 102**

5. Remove the bearing (**Figure 103, item 1**) from the housing block (**Figure 103, item 2**).




**Figure 103**

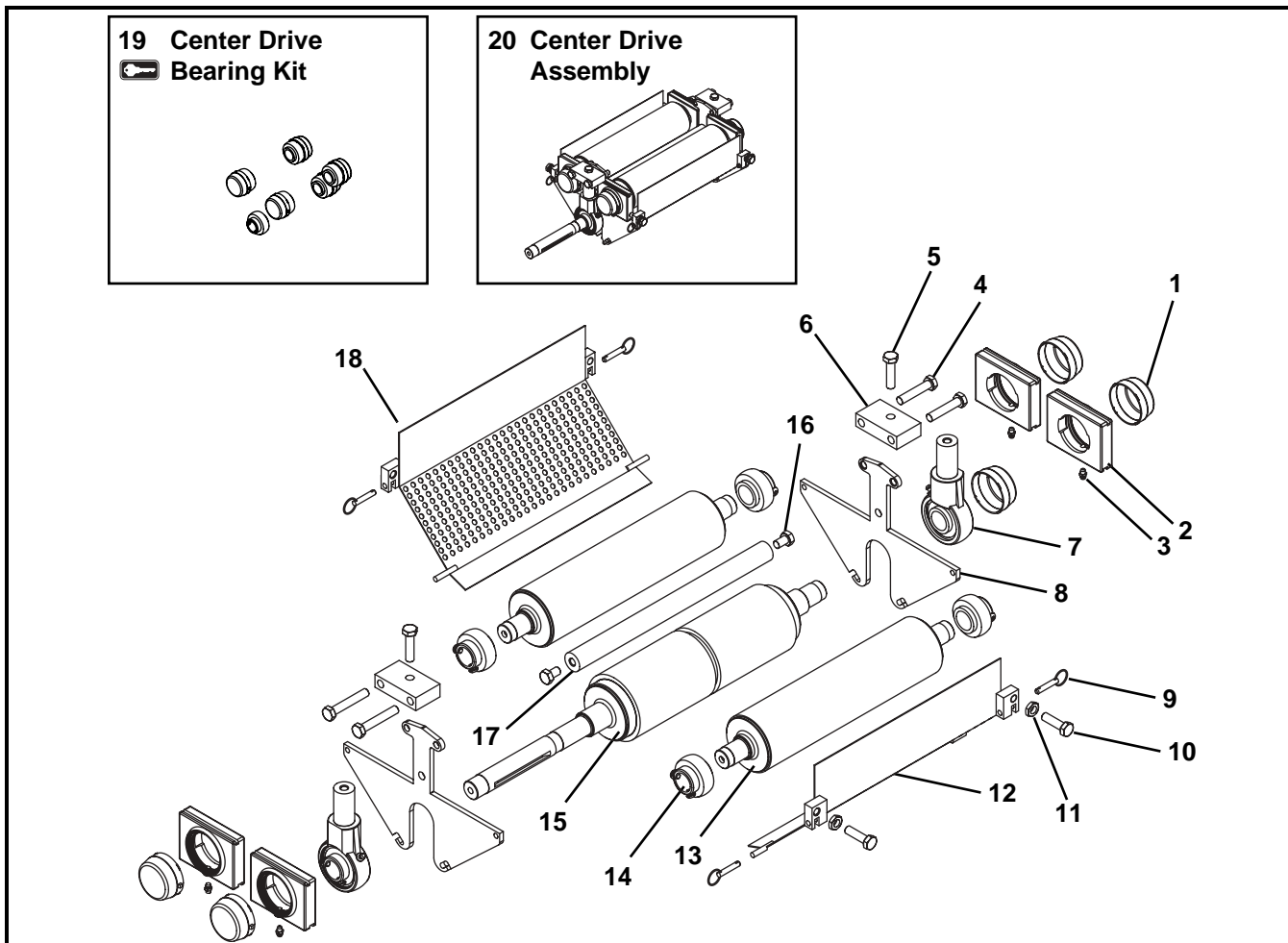


# Service Parts

## 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.

## Center Drive Assembly Components

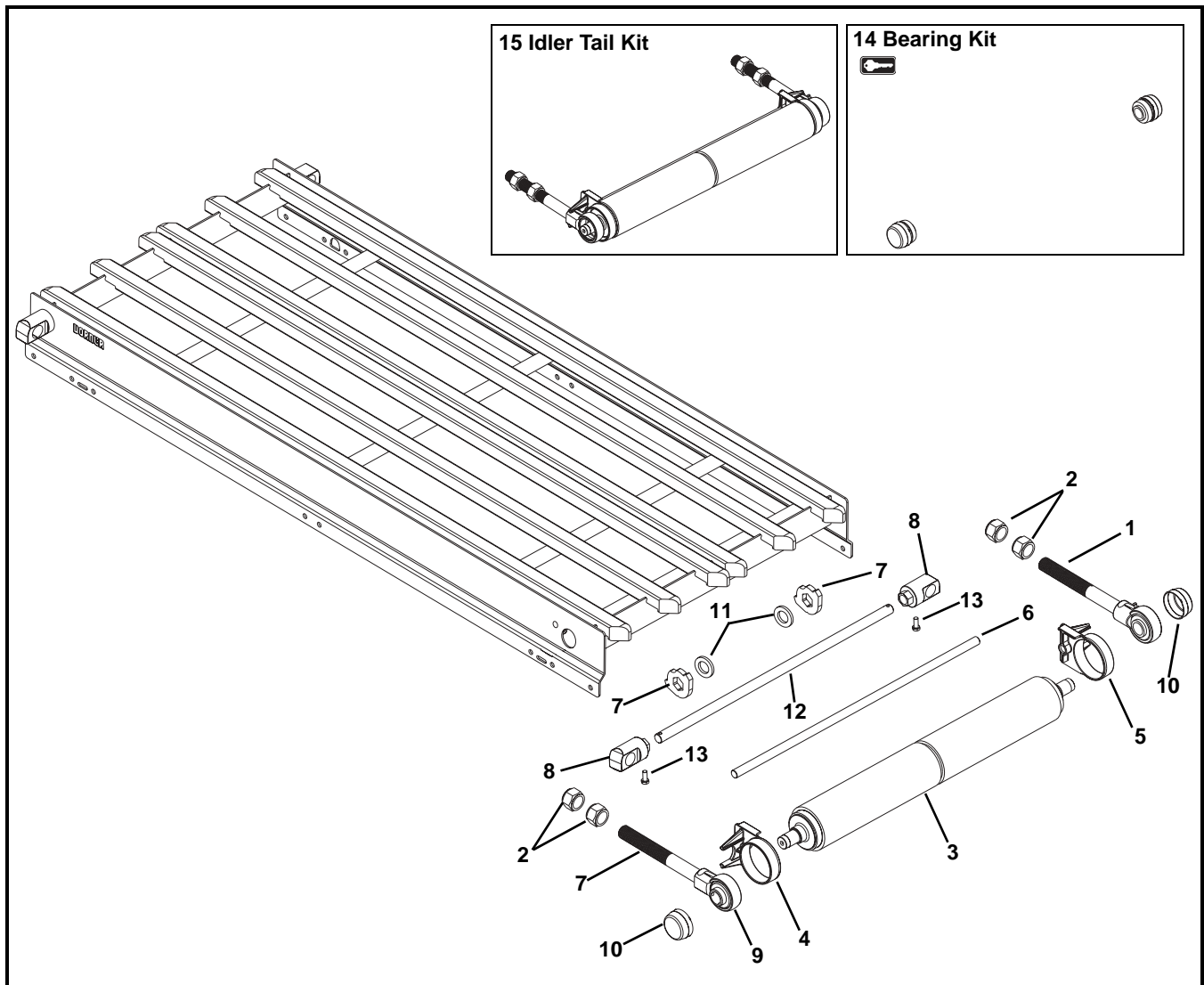


Item	Part Number	Description
1	807-1454	Bearing Cover
2	500683	Center Drive Housing Block
3	810-187	Zerk Fitting
4	961055MSS	Hex Head Cap Screw, M10-1.50 x 55 mm
5	961040MSS	Hex Head Cap Screw, M10-1.50 x 40 mm
6	500688	Center Drive Block Shaft Mount
7 *	500696	Center Drive Shaft Assembly, with Bearing and Cover
8	500692	Center Drive Side Plate
9	807-1553	Pull Pin
10	961035MSS	Hex Head Cap Screw, M10-1.50 x 35 mm
11	991009MSS	Hex Nut
12	5094WW	Infeed Center Drive Guard Assembly
13	5095WW	Center Drive Tension Spindle
14	802-162	Bearing
15	5096WW	Center Drive Spindle
	5292WW	CE Center Drive Spindle

Item	Part Number	Description
16	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
17	5125WW	Center Drive Cross Member Post
18	5149WW	Outfeed Center Drive Guard Assembly
19	76CDD	Center Drive Bearing Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package (Includes Items 1 and 14)
	76CDC	Center Drive Bearing Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package (Includes Items 1 and 14)
20	5127WW	Center Drive Module (Includes items 1 through 18)
	5301WW	CE Center Drive Module (Includes items 1 through 18)
WW = Conveyor width ref: 06 - 60 in 02 increments		
* When the conveyor is ordered with a Dorner gearmotor mounting package a shaft assembly is replaced with a gearmotor mounting bracket.		



## Idler End Components



Item	Part Number	Description
1	506375	Shaft Assembly, with Bearing and Cover
2	500791	Nut
3	5104 <del>WW</del>	Idler Spindle
4	506293	Pinch Guard, Left Hand
5	506294	Pinch Guard, Right Hand
6	506369- <del>WW</del>	Pinch Shaft Guard
7	506357	Key Stop

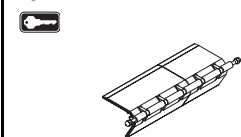
Item	Part Number	Description
8	506318	Tip Up Knob
9	802-162	Bearing
10	807-1454	Bearing Cover
11	514373	Spacer
12	506370- <del>WW</del>	Tip Up Shaft
13	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm
14	76BKX- <del>WW</del>	Bearing Kit (Includes Items 9 and 10)
15	76STX- <del>WW</del>	Idler Tail Kit (Includes Items 1 through 6)

~~WW~~ = Conveyor width ref: 06 - 60 in 02 increments

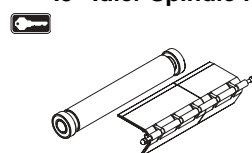
# Service Parts

## .5" Nose Bar Idler End

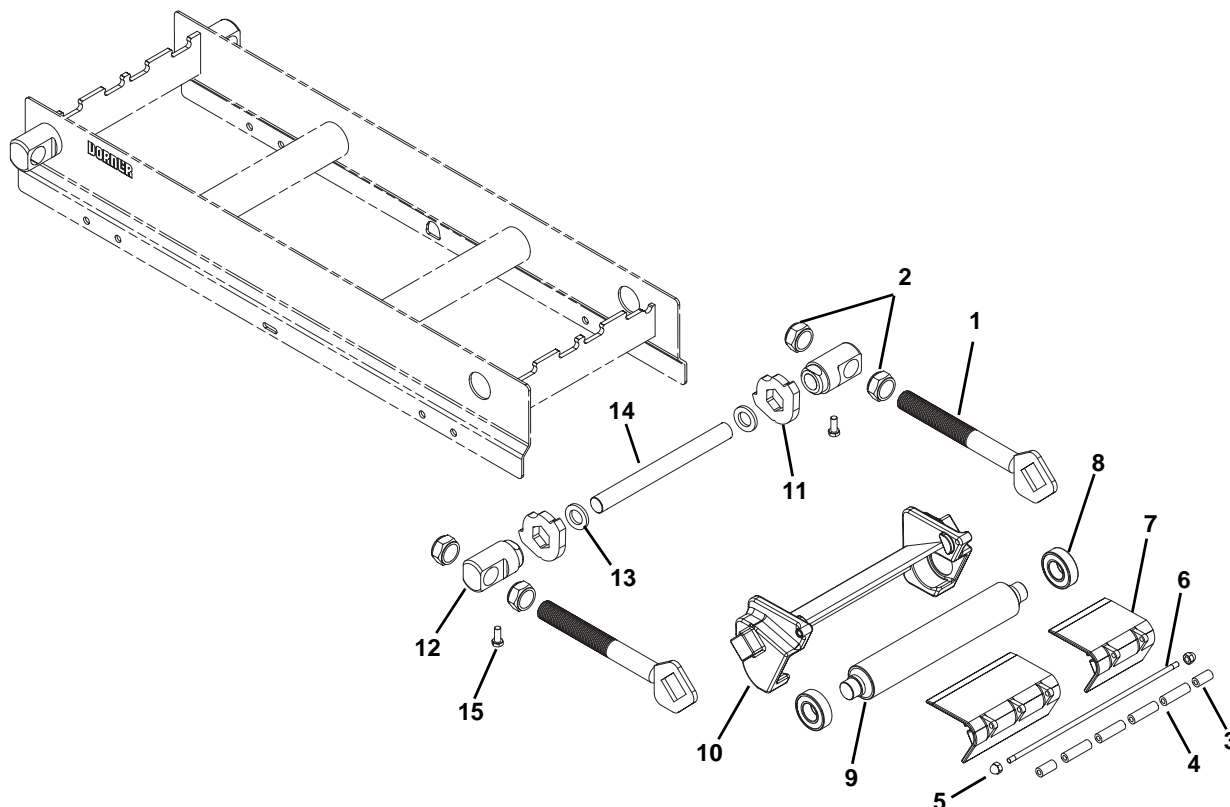
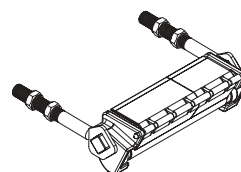
16 .5" Nose Bar Kit



17 .5" Idler Spindle Kit



18 .5" Idler Tail Kit



Item	Part Number	Description
1	500997	0.5" Nose Bar Shaft Assembly
2	500791	Nut
3	501087	Roller, 0.5" x 1.06"
4	501086	Roller, 0.5" x 1.72"
5	990608MSS	Acorn Nut
6	5099WW	Nose Bar Shaft
7	See Chart	Roller Mount
8	802-164	Return Spindle Bearing
9	5097WW	0.5" Nose Bar Return Spindle

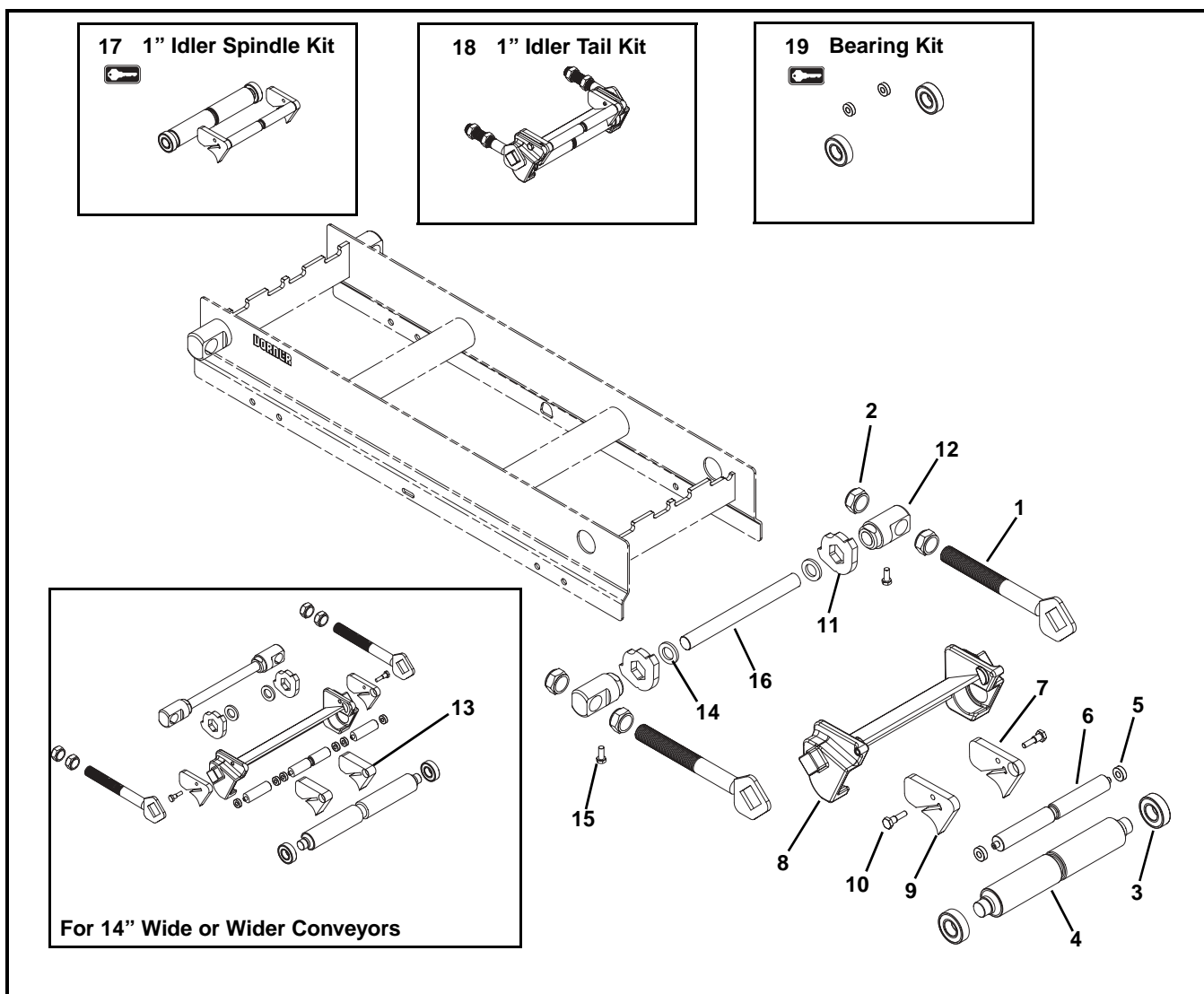
Item	Part Number	Description
10	5092WW	0.5" Nose Bar Weldment Assembly
11	506357	Key Stop
12	506318	Tip Up Knob
13	514373	Spacer
14	506370-WW	Tip Up Shaft
15	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm
16	76NB5-WW	0.5" Nose Bar Kit (Includes Items 3 through 7)
17	76NB-WW	0.5" Idler Spindle Kit (Includes Items 3 through 9)
18	76NBT-WW	0.5" Idler Tail Kit (Includes Items 1 through 10)
WW = Conveyor width ref: 06 - 60 in 02 increments		



Item 7: Roller Mount	
Width	Part Number
6" (152 mm)	501078
8" (203 mm)	501077
10" (254 mm)	501078 & 501079
12" (305 mm)	501077 & 501079
14" (356 mm)	501077 & 501078
16" (406 mm)	501077 (x2)
18" (457 mm)	501077, 501078 & 501079
20" (508 mm)	501077 (x2) & 501079
22" (559 mm)	501077 (x2) & 501076
24" (610 mm)	501077 (x3)
26" (660 mm)	501077 (x2), 501078 & 501079
28" (711 mm)	501077 (x3) & 501079
30" (762 mm)	501077 (x3) & 501078
32" (813 mm)	501077 (x4)
34" (864 mm)	501077 (x3), 501078 & 501079
36" (914 mm)	501077 (x4) & 501079
38" (965 mm)	501077 (x4) & 501078
40" (1016 mm)	501077 (x5)
42" (1067 mm)	501077 (x4), 501078 & 501079
44" (1118 mm)	501077 (x5) & 501079
46" (1168 mm)	501077 (x5) & 501078
48" (1219 mm)	501077 (x6)
50" (1270 mm)	501077 (x5), 501078 & 501079
52" (1321 mm)	501077 (x6) & 501079
54" (1372 mm)	501077 (x6) & 501078
56" (1422 mm)	501077 (x7)
58" (1473 mm)	501077 (x6), 501078 & 501079
60" (1524 mm)	501077 (x7) & 501079

# Service Parts

## 1" Nose Bar Idler End



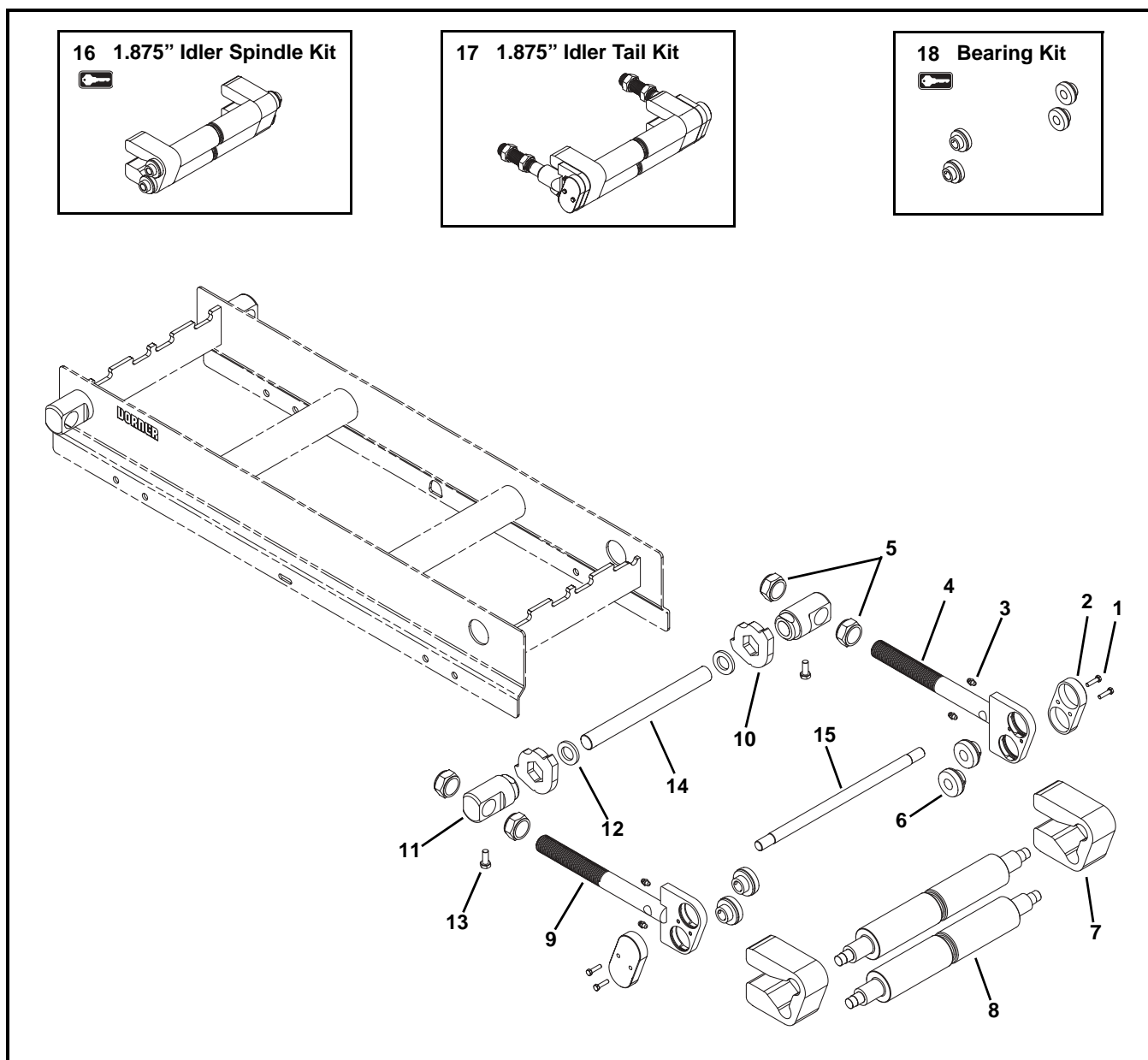
Item	Part Number	Description
1	500997	1" Nose Bar Shaft Assembly
2	500791	Nut
3	802-164	Return Spindle Bearing
4	5107 <del>WW</del>	1" Nose Bar Return Spindle
5	802-123	Nose Bar Bearing
6	See Chart	1" Nose Bar Spindle
7	500975	Nose Bar Puck Holder Right Hand
8	5105 <del>WW</del>	1" Nose Bar Weldment Assembly
9	500976	Nose Bar Puck Holder Left Hand
10	501178	Pilot Nose Bolt
11	506357	Key Stop

Item	Part Number	Description
12	506318	Tip Up Knob
13	500977	Nose Bar Puck Holder, Center
14	514373	Spacer
15	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm
16	506370- <del>WW</del>	Tip Up Shaft
17	76NB1- <del>WW</del>	1" Idler Spindle Kit (Includes Items 3 through 7, 9 and 13)
18	76NBT1- <del>WW</del>	1" Idler Tail Kit (Includes Items 1 through 10 and 13)
19	76BK1- <del>WW</del>	Bearing Kit (Includes Items 3 and 5)
<del>WW</del> = Conveyor width ref: 06 - 60 in 02 increments		

Item 6: 1" Nose Bar Spindle	
Width	Part Number
6" (152mm)	505107
8" (203mm)	505108
10" (254mm)	505109
12" (305mm)	505110
14" (356mm)	505103 (x2) & 505107
16" (406mm)	505103 (x2) & 505108
18" (457mm)	505103 (x2) & 505109
20" (508mm)	505103 (x2) & 505110
22" (559mm)	505104 (x2) & 505107
24" (610mm)	505104 (x2) & 505108
26" (660mm)	505104 (x2) & 505109
28" (711mm)	505104 (x2) & 505110
30" (762mm)	505106 (x2) & 505107
32" (813mm)	505106 (x2) & 505108
34" (864mm)	505106 (x2) & 505109
36" (914mm)	505106 (x2) & 505110
38" (965mm)	505104 (x4) & 505107
40" (1016mm)	505104 (x4) & 505108
42" (1067mm)	505104 (x4) & 505109
44" (1118mm)	505104 (x4) & 505110
46" (1168mm)	505105 (x4) & 505107
48" (1219mm)	505105 (x4) & 505108
50" (1270mm)	505105 (x4) & 505109
52" (1321mm)	505105 (x4) & 505110
54" (1372mm)	505106 (x4) & 505107
56" (1422mm)	505106 (x4) & 505108
58" (1473mm)	505106 (x4) & 505109
60" (1524mm)	505106 (x4) & 505110

# Service Parts

## 1.875" Nose Bar Idler End

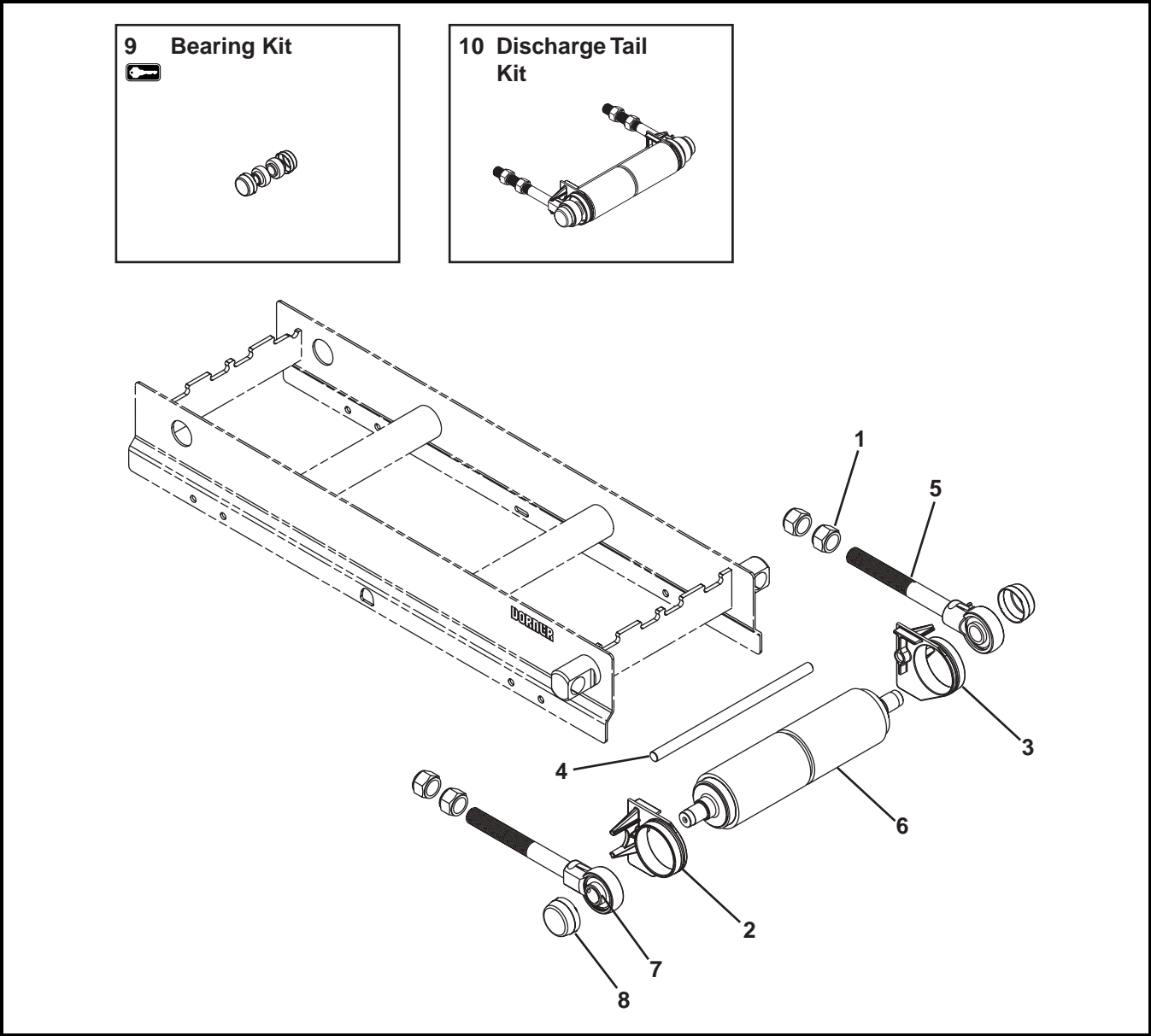


Item	Part Number	Description
1	960520MSS	Hex Head Cap Screw M5-0.8 x 20 mm
2	501085	Transfer Bearing Cover
3	810-187	Grease Fitting
4	501083	1.875" Nose Bar Shaft Assembly Right Hand
5	500791	Nut
6	802-171	Bearing
7	501081	Pinch Guard block
8	5101WW	1.875" Nose Bar Spindle
9	501084	1.875" Nose Bar Shaft Assembly Left Hand
10	506357	Key Stop

Item	Part Number	Description
11	506318	Tip Up Knob
12	514373	Spacer
13	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm
14	506370-WW	Tip Up Shaft
15	514403-WW	Anti-Rotation Bar
16	76NB2-WW	1.875" Idler Spindle Kit (Includes Items 6 through 8)
17	76NBT2-WW	1.875" Idler Tail Kit (Includes Items 1 through 9)
18	76BK2-WW	Bearing Kit (Includes Item 6)

WW = Conveyor width ref: 06 - 60 in 02 increments

Discharge End



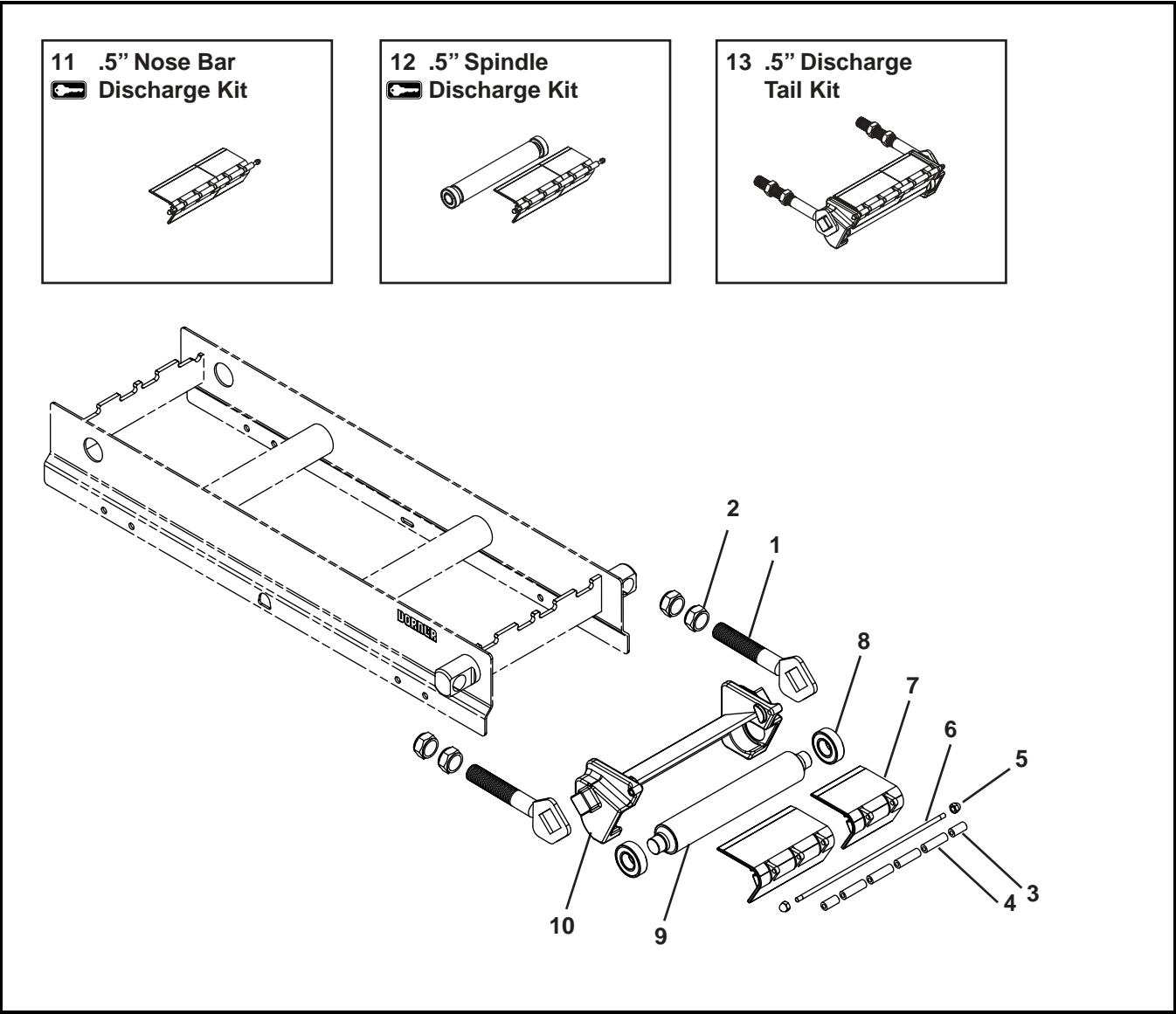
Item	Part Number	Description
1	500791	Nut
2	506293	Pinch Guard Left Hand
3	506294	Pinch Guard Right Hand
4	506369- <u>WW</u>	Pinch Guard Shaft
5	506375	Discharge Shaft Assembly, with Bearing and Cover
6	5104 <u>WW</u>	Idler Spindle

Item	Part Number	Description
7	802-162	Bearing
8	807-1454	Cover
9	76BK	Bearing Kit (Includes Items 7 and 8)
10	76SDX- <u>WW</u>	Discharge Tail Kit (Includes Items 1 through 8)
<u>WW</u> = Conveyor width ref: 06 - 60 in 02 increments		



# Service Parts

## .5" Nose Bar Discharge End



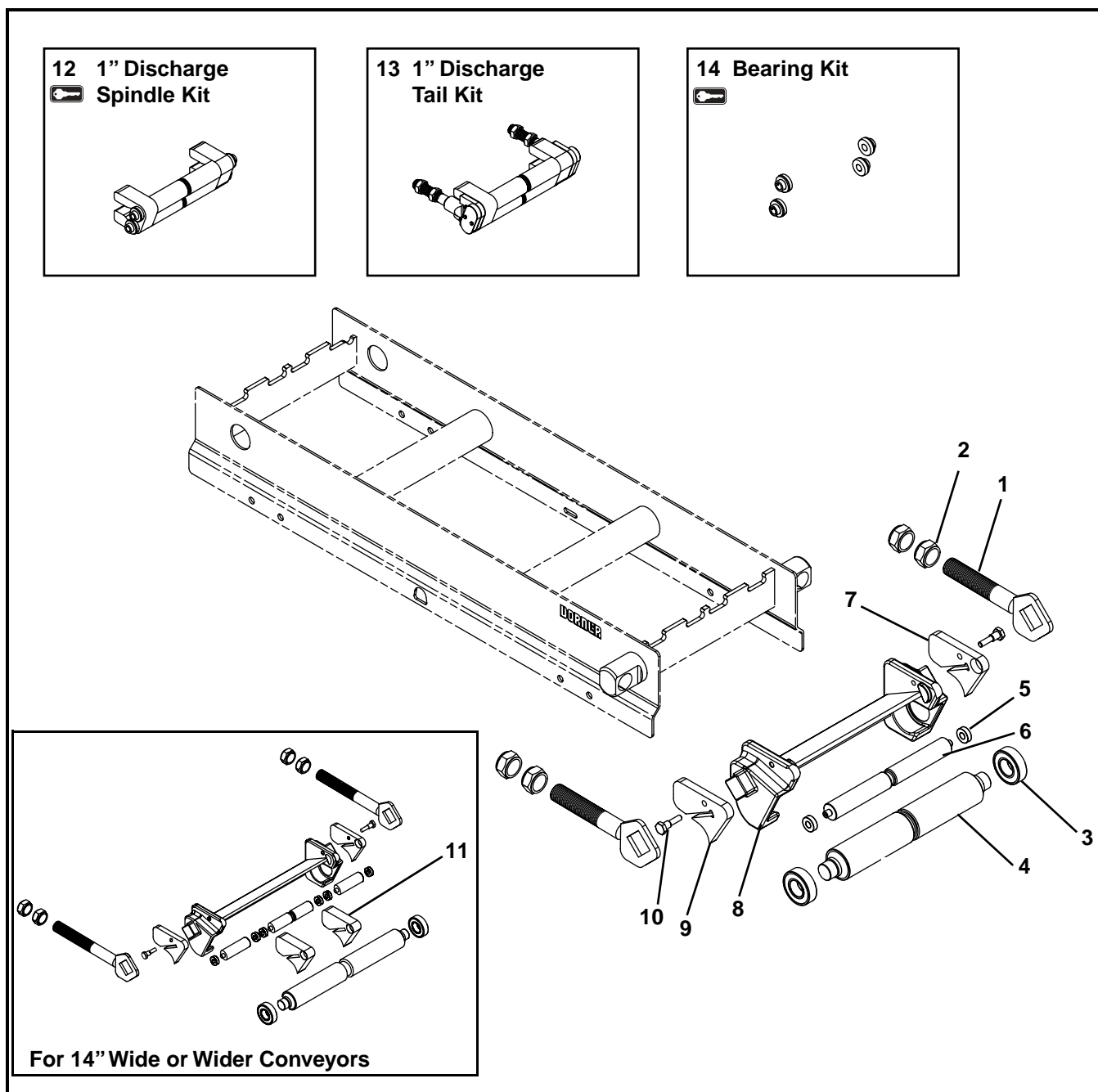
Item	Part Number	Description
1	501093	Discharge Nose Bar Shaft Assembly
2	500791	Nut
3	501087	Roller .5" x 1.06"
4	501086	Roller .5" x 1.72"
5	990608MSS	Acorn Nut
6	5099WW	Nose Bar Shaft
7	See Chart	Roller Mount
8	802-164	Return Spindle Bearing

Item	Part Number	Description
9	5097WW	.5" Nose Bar Return Spindle
10	5092WW	.5" Nose Bar Weldment Assembly
11	76NB5-WW	.5" Nose Bar Discharge Kit (Includes Items 3 through 7)
12	76NB-WW	.5" Spindle Discharge Kit (Included Items 3 through 9)
13	76NBD5-WW	.5" Discharge Tail Kit (Includes Items 1 through 10)
WW = Conveyor width ref: 06 - 60 in 02 increments		

Item 7: Roller Mount	
Width	Part Number
6" (152 mm)	501078
8" (203 mm)	501077
10" (254 mm)	501078 & 501079
12" (305 mm)	501077 & 501079
14" (356 mm)	501077 & 501078
16" (406 mm)	501077 (x2)
18" (457 mm)	501077, 501078 & 501079
20" (508 mm)	501077 (x2) & 501079
22" (559 mm)	501077 (x2) & 501076
24" (610 mm)	501077 (x3)
26" (660 mm)	501077 (x2), 501078 & 501079
28" (711 mm)	501077 (x3) & 501079
30" (762 mm)	501077 (x3) & 501078
32" (813 mm)	501077 (x4)
34" (864 mm)	501077 (x3), 501078 & 501079
36" (914 mm)	501077 (x4) & 501079
38" (965 mm)	501077 (x4) & 501078
40" (1016 mm)	501077 (x5)
42" (1067 mm)	501077 (x4), 501078 & 501079
44" (1118 mm)	501077 (x5) & 501079
46" (1168 mm)	501077 (x5) & 501078
48" (1219 mm)	501077 (x6)
50" (1270 mm)	501077 (x5), 501078 & 501079
52" (1321 mm)	501077 (x6) & 501079
54" (1372 mm)	501077 (x6) & 501078
56" (1422 mm)	501077 (x7)
58" (1473 mm)	501077 (x6), 501078 & 501079
60" (1524 mm)	501077 (x7) & 501079

# Service Parts

## 1" Nose Bar Discharge End



Item	Part Number	Description
1	501093	Discharge Nose Bar Shaft Assembly
2	500791	Nut
3	802-164	Return Spindle Bearing
4	5107WW	1" Nose Bar Return Spindle
5	802-123	Nose Bar Bearing
6	See Chart	1" Nose Bar Spindle
7	500975	Nose Bar Puck Holder, Right Hand
8	5105WW	1" Nose Bar Weldment Assembly
9	500976	Nose Bar Puck Holder, Left Hand

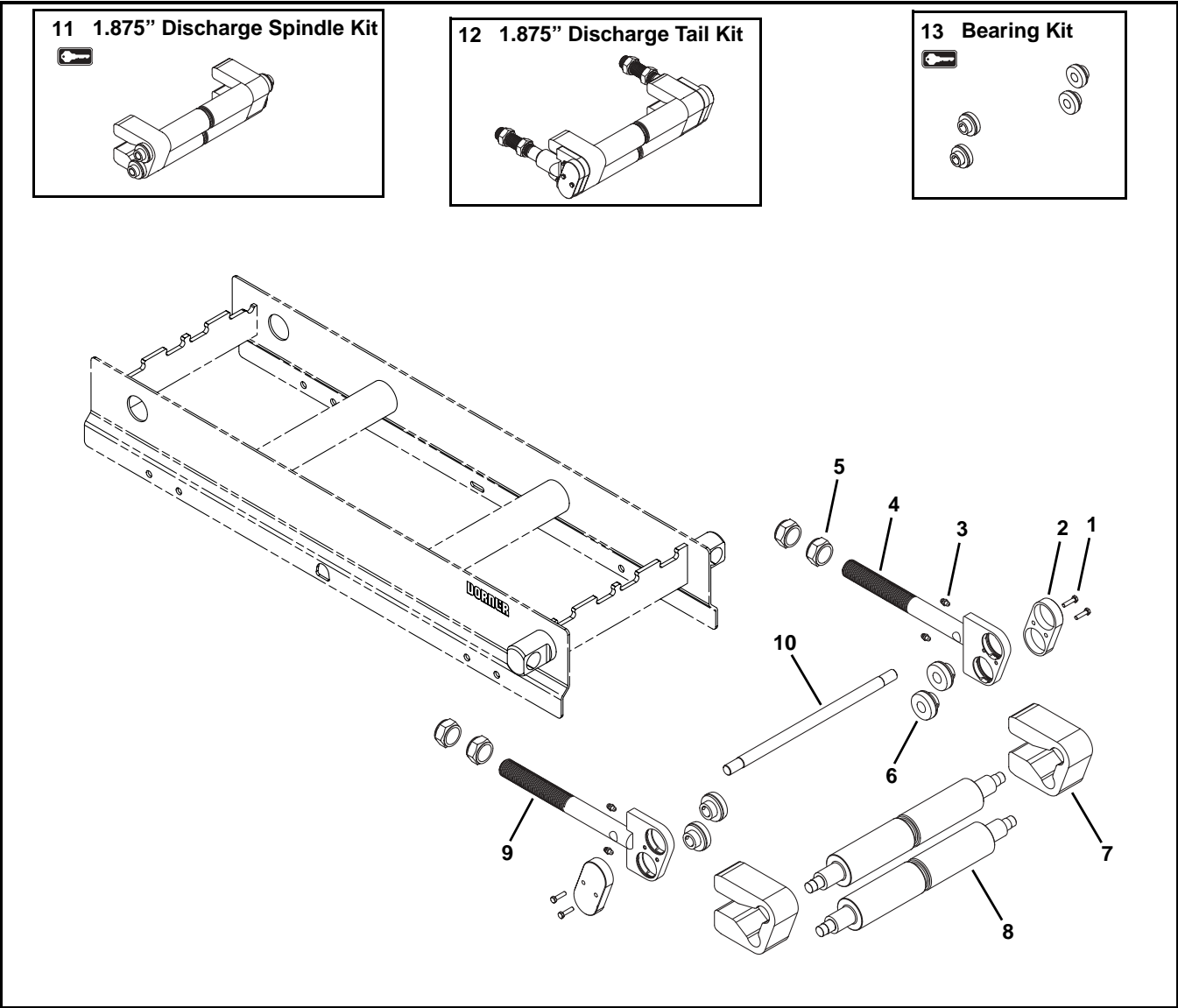
Item	Part Number	Description
10	501178	Pilot Nose Bolt
11	500977	Nose Bar Puck Holder, Center
12	76NB1-WW	1" Discharge Spindle Kit (Includes Items 3 through 7, 9 and 11)
13	76NBD1-WW	1" Discharge Tail Kit (Includes Items 1 through 11)
14	76BK1-WW	Bearing Kit (Includes Items 3 and 5)

WW = Conveyor width ref: 06 - 60 in 02 increments

Item 6: 1" Nose Bar Spindle	
Width	Part Number
6" (152mm)	505107
8" (203mm)	505108
10" (254mm)	505109
12" (305mm)	505110
14" (356mm)	505103 (x2) & 505107
16" (406mm)	505103 (x2) & 505108
18" (457mm)	505103 (x2) & 505109
20" (508mm)	505103 (x2) & 505110
22" (559mm)	505104 (x2) & 505107
24" (610mm)	505104 (x2) & 505108
26" (660mm)	505104 (x2) & 505109
28" (711mm)	505104 (x2) & 505110
30" (762mm)	505106 (x2) & 505107
32" (813mm)	505106 (x2) & 505108
34" (864mm)	505106 (x2) & 505109
36" (914mm)	505106 (x2) & 505110
38" (965mm)	505104 (x4) & 505107
40" (1016mm)	505104 (x4) & 505108
42" (1067mm)	505104 (x4) & 505109
44" (1118mm)	505104 (x4) & 505110
46" (1168mm)	505105 (x4) & 505107
48" (1219mm)	505105 (x4) & 505108
50" (1270mm)	505105 (x4) & 505109
52" (1321mm)	505105 (x4) & 505110
54" (1372mm)	505106 (x4) & 505107
56" (1422mm)	505106 (x4) & 505108
58" (1473mm)	505106 (x4) & 505109
60" (1524mm)	505106 (x4) & 505110

# Service Parts

## 1.875" Nose Bar Discharge End



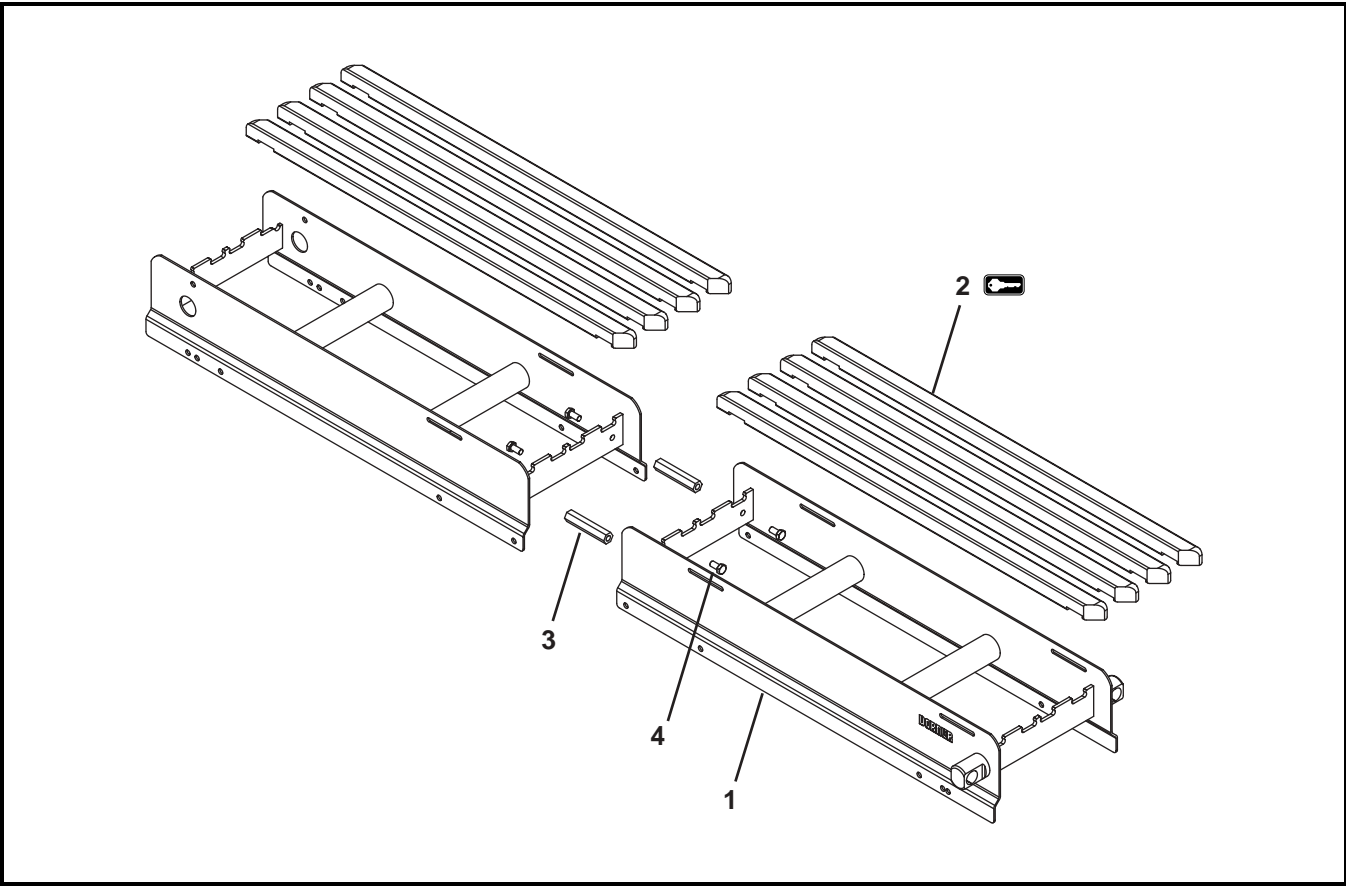
Item	Part Number	Description
1	960520MSS	Hex Head Cap Screw M5-0.8 x 20mm
2	501085	Transfer Bearing Cover
3	810-187	Grease Fitting
4	501083	1.875" Discharge Nose Bar Shaft Assembly Right Hand
5	500791	Nut
6	802-171	Bearing
7	501081	Pinch Guard block
8	5101 <del>WW</del>	1.875" Nose Bar Spindle

Item	Part Number	Description
9	501084	1.875" Discharge Nose Bar Shaft Assembly Left Hand
10	514403- <del>WW</del>	Anti-Rotation Bar
11	76NB2- <del>WW</del>	1.875" Discharge Spindle Kit (Includes Items 6 through 8)
12	76NBD2- <del>WW</del>	1.875" Discharge Tail Kit (Includes Items 1 through 9)
13	76BK2- <del>WW</del>	Bearing Kit (Includes Item 6)

~~WW~~ = Conveyor width ref: 06 - 60 in 02 increments



Conveyor Frame and Extensions with Standard Wear Strips

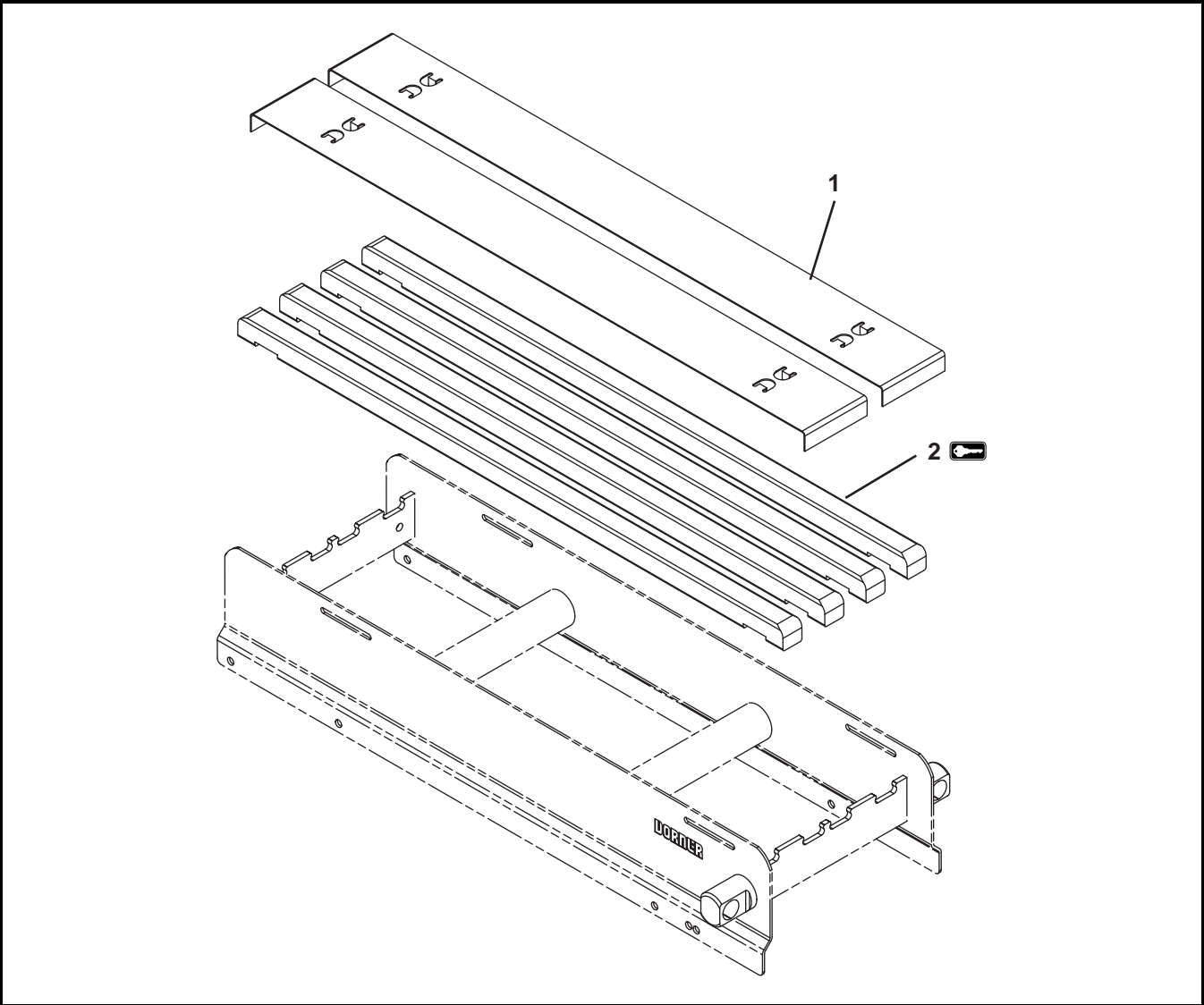



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	501800- <u>LLL</u>	Wear Strip

Item	Part Number	Description
3	500193	Hex Post Connector
4	961020MSS	Hex Head Cap Screw M10-1.5 x 20 mm
<u>LLL</u> = Conveyor length ref: 036 - 480 in 001 increments		

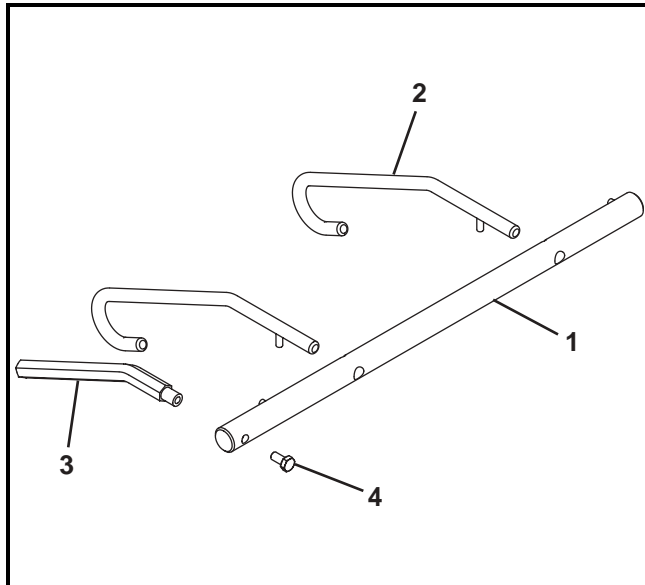
# Service Parts

## Wear Strips with Stainless Steel Sheet Bed Plate



Item	Part Number	Description
1	5123 <u>WW</u> - <u>LLL</u>	Bed Plate
2 	501098- <u>LLL</u>	Wear Strip
<u>WW</u> = Conveyor width ref: 06 - 60 in 02 increments		
<u>LLL</u> = Conveyor length ref: 036 - 480 in 001 increments		

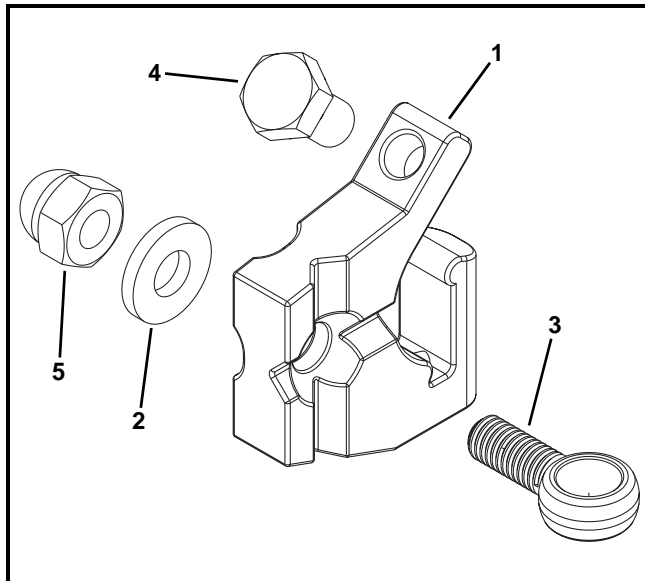
## Lifters



Item	Part Number	Description
1	5121WW	Belt Lifter Shaft
2	501376	Belt Lifter
3	500491	Belt Lifter Handle
4	960812MSS	Hex Head Cap Screw M8-1.25 x 12 mm

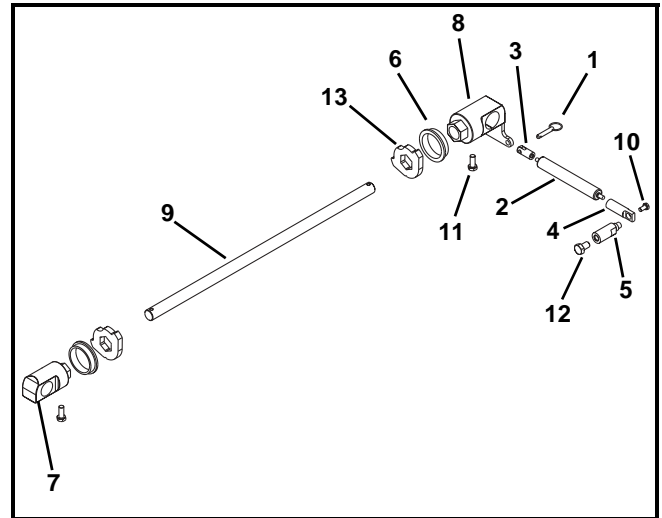
WW = Conveyor width ref: 06 - 60 in 02 increments

## Mounting Block



Item	Part Number	Description
1	509868	Mounting Block
2	807-1821	Washer
3	807-1994	Eyebolt, M10 x 1.50
4	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
5	991008MSS	Hex Nut, M10 - 1.50

## Gas Assisted Tip Up

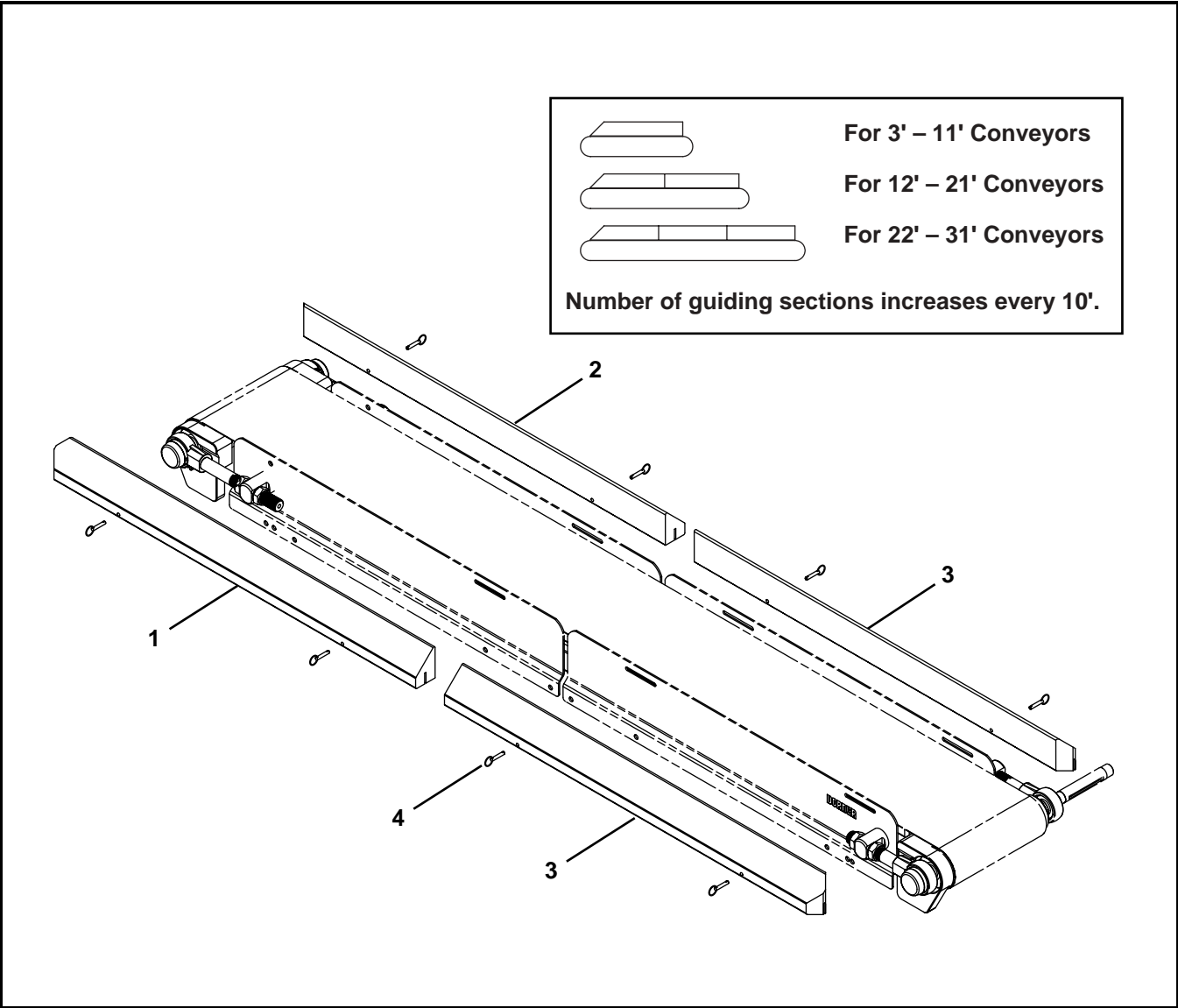


Item	Part Number	Description
1	807-1553	Pin
2	807-1562	Gas Spring for 70# Assist
	807-1563	Gas Spring for 130# Assist
	807-1564	Gas Spring for 160# Assist
3	500792	Gas Spring Clevis
4	500793	Gas Spring Eyelet
5	500794	Gas Spring Stand Off Post
6	500895	Tip Up Bushing
7	506318	Tip Up Knob
8	506329	Tip Up Knob Assembly
9	506370-WW	Tip Up Shaft
10	960612MSS	Hex Head Cap Screw, M6-1.00 x 12 mm
11	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm
12	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
13	506356	Key Stop

WW = Conveyor width ref: 18 - 60 in 02 increments

# Service Parts

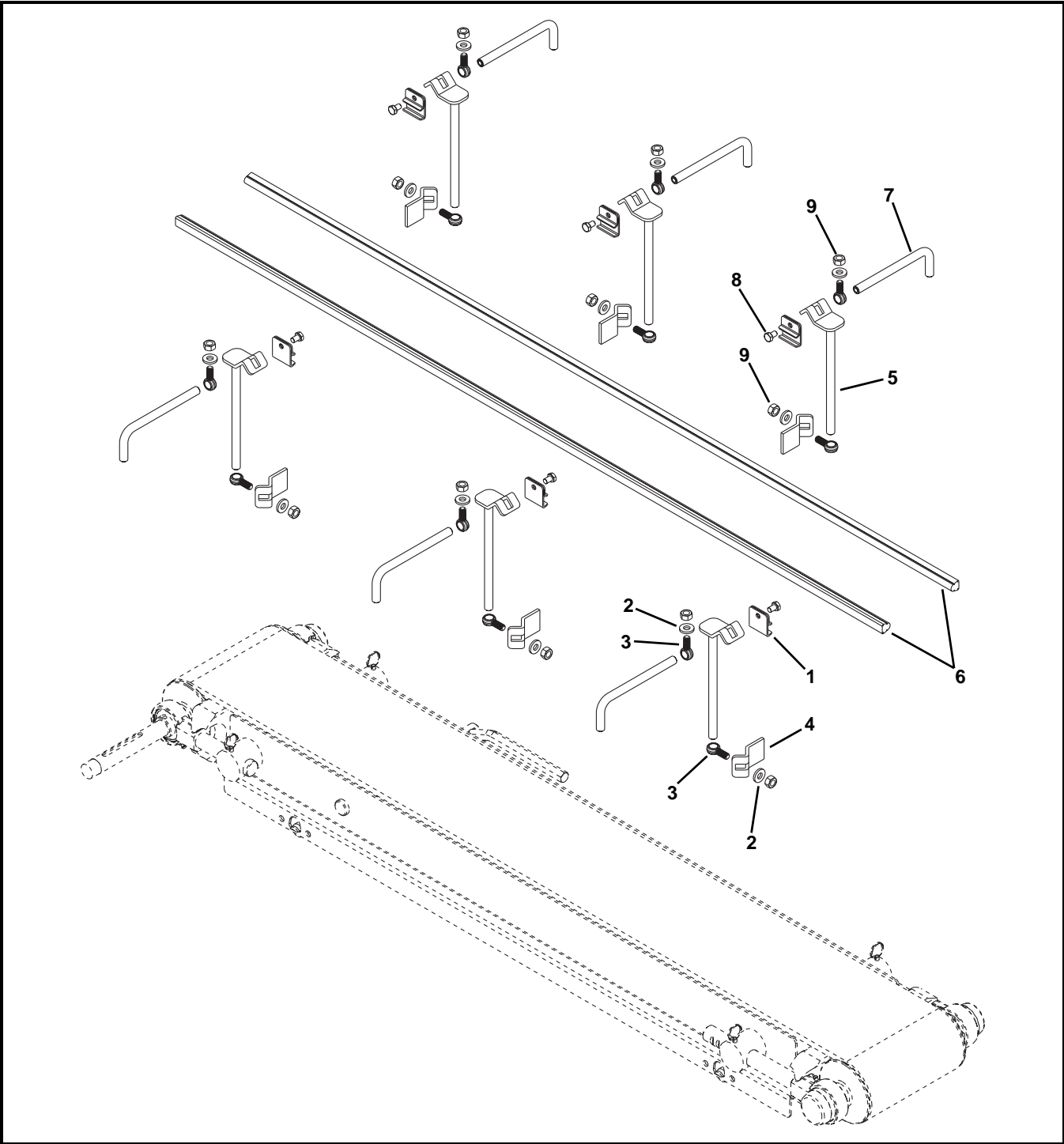
## 3" High Sides



Item	Part Number	Description
1	503460- <u>LLLLL</u>	High Side Guide for Conveyors 3'-11' Long
	503550- <u>LLLLL</u>	High Side Right Hand Guide for Conveyors over 11' Long
2	503460- <u>LLLLL</u>	High Side Guide for Conveyors 3'-11' Long

Item	Part Number	Description
3	503650- <u>LLLLL</u>	High Side Right Hand Guide for Conveyors over 11' Long
	503450- <u>LLLLL</u>	High Side Guide Square End
4	807-1553	Pull Pin
<u>LLLLL</u> = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" <u>LLLLL</u> = 09525		

Adjustable Guiding



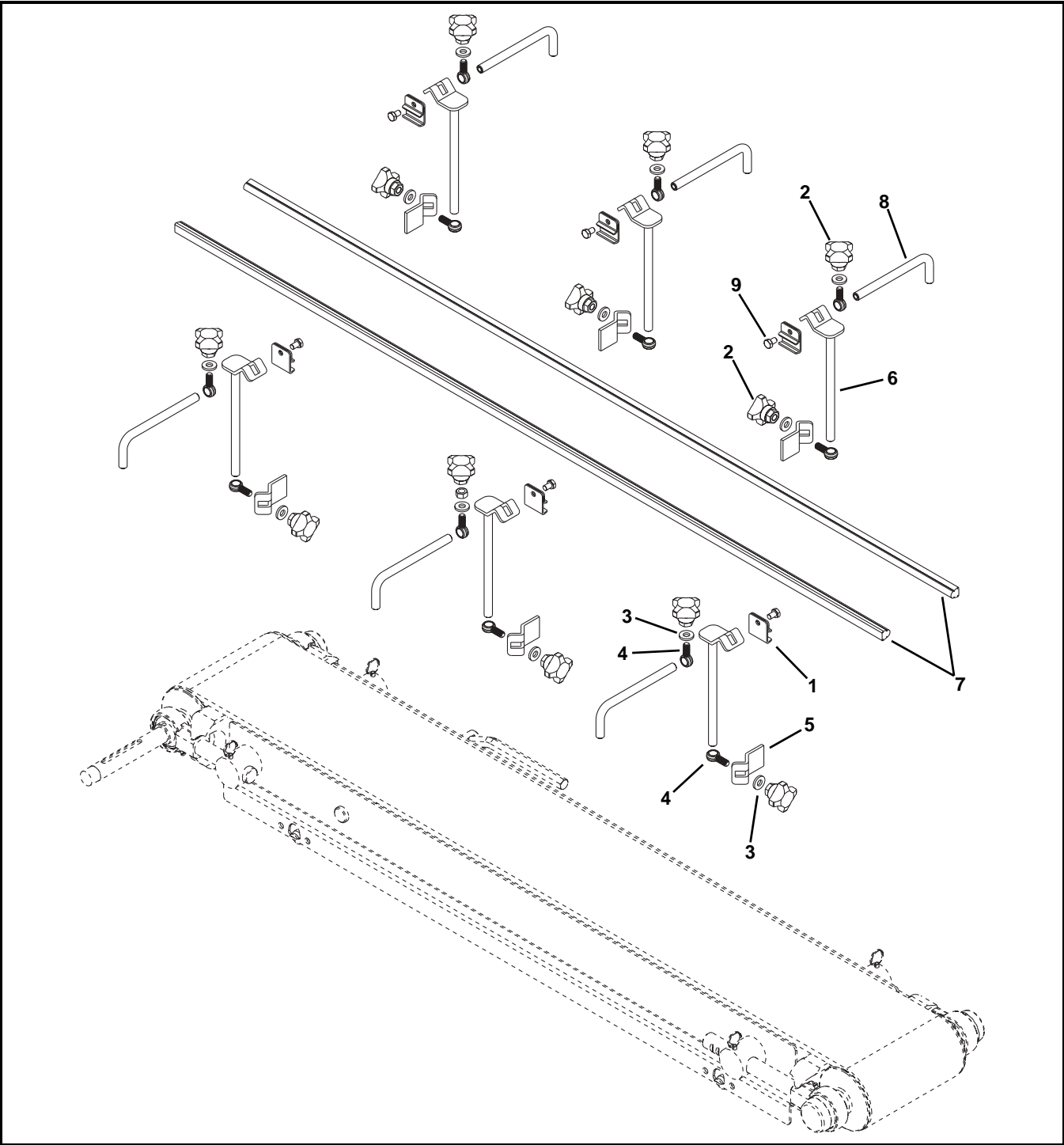
Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1821	Washer
3	807-1994	Eye Bolt M10 x 1.50
4	509875	Mounting Bracket
5	509876	Vertical Post Assembly
6	532167- <u>LLLLL</u>	Round Guide Rail

Item	Part Number	Description
7	532300	Guide Post
8	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
9	991001MSS	Hex Nut, M10 - 1.50
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" <u>LLLLL</u> = 09525		



# Service Parts

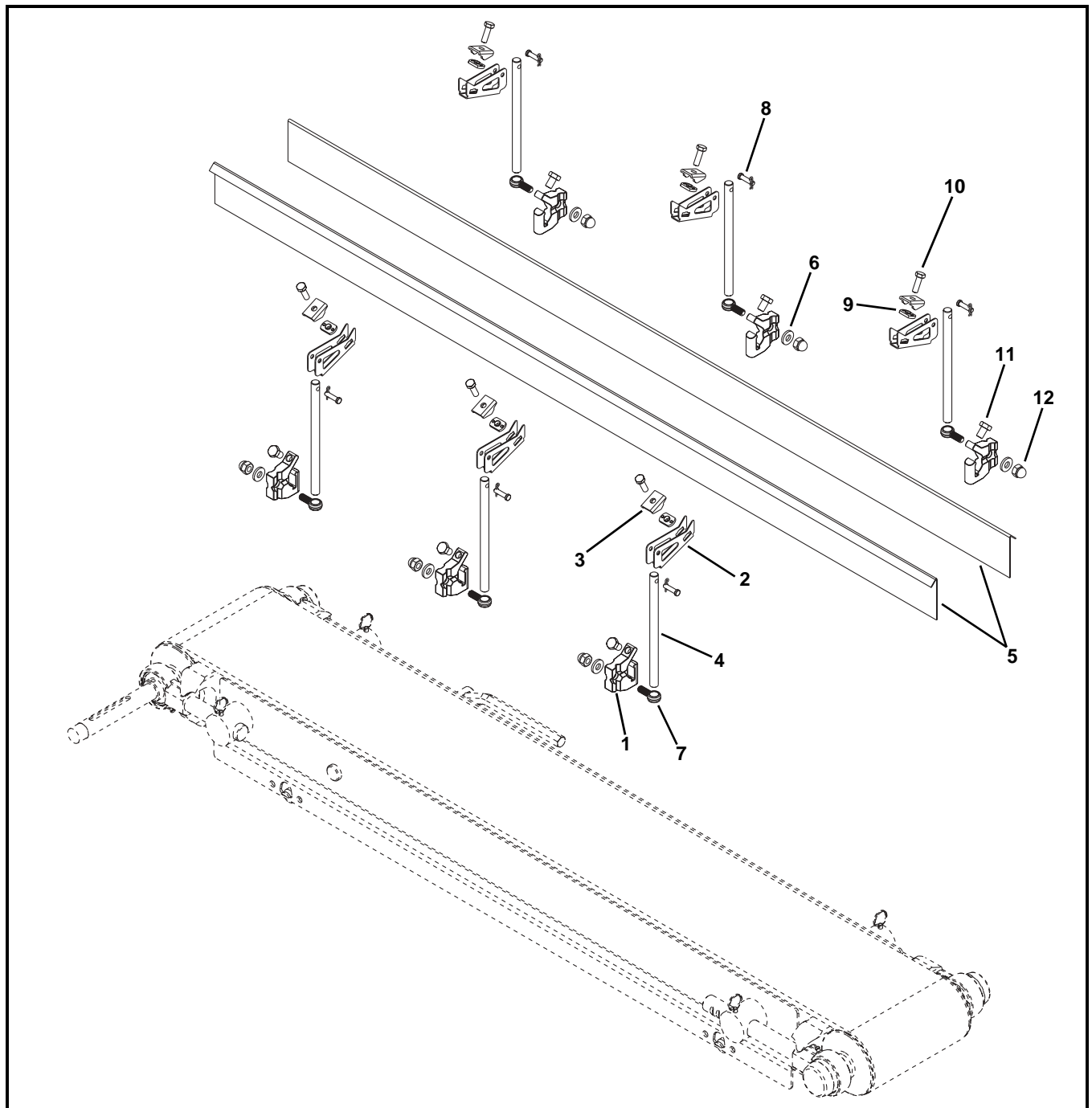
## Tool-Less Adjustable Guiding



Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1057	Handle
3	807-1821	Washer
4	807-1994	Eye Bolt M10 x 1.50
5	509875	Mounting Bracket
6	509876	Vertical Post Assembly

Item	Part Number	Description
7	532167- <u>LLLL</u>	Round Guide Rail
8	532300	Guide Post
9	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
<u>LLLL</u> = Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" <u>LLLL</u> = 09525		

## Hinged Guides

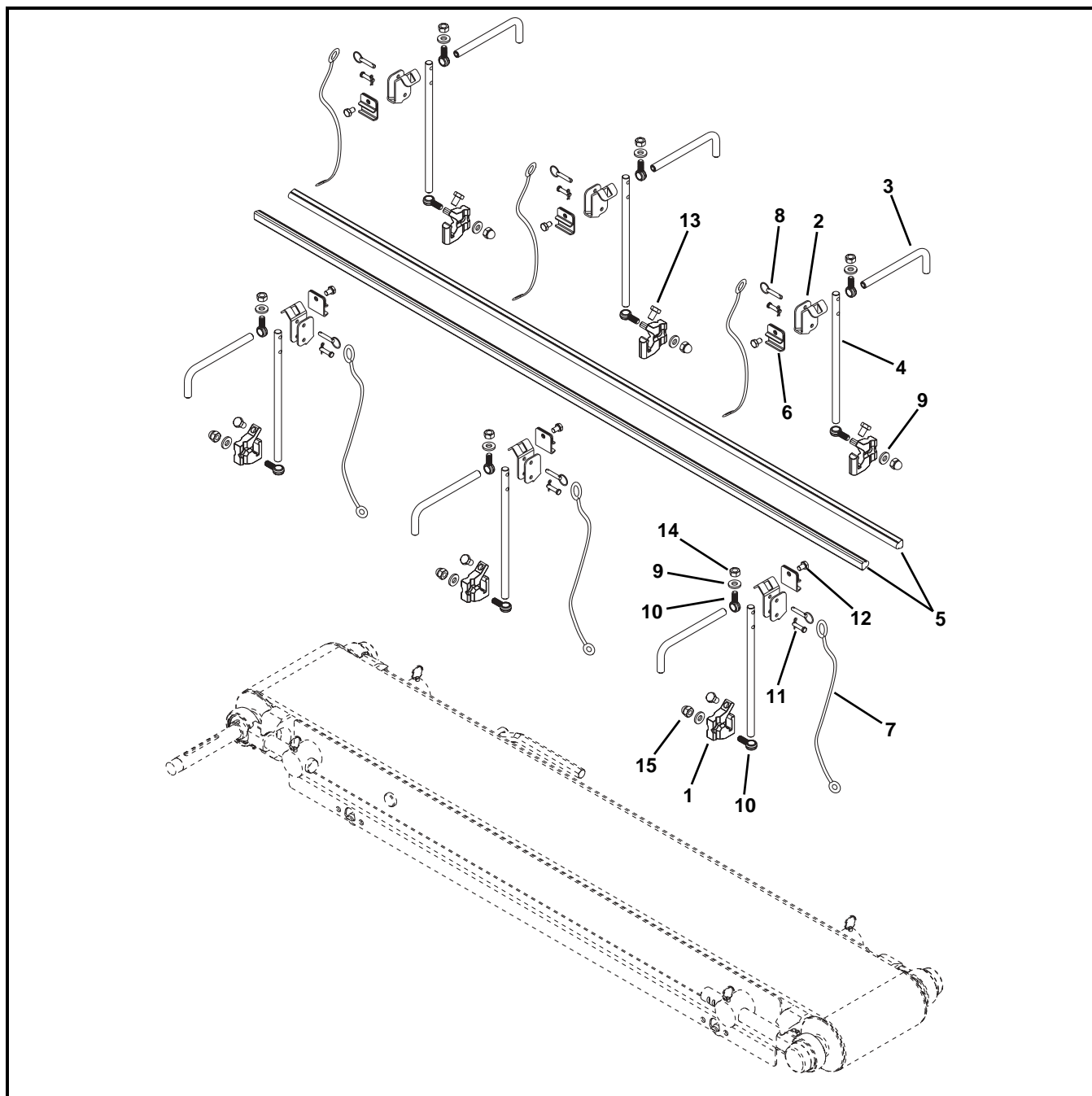


Item	Part Number	Description
1	509868	Mounting Block
2	509870	Pivot Guide Mounting Bracket
3	509871	Guide Clamp Bracket
4	509872-PH-0800	Mounting Guide Shaft for 3" Guides
	509872-PH-1100	Mounting Guide Shaft for 6" Guides
5	532172-LLLL	Guiding for 3" Guides
	509890-LLLL	Guiding for 6" Guides
6	807-1821	Washer
7	807-1994	Eyebolt M10 x 1.50 mm

Item	Part Number	Description
8	807-1995	Cotter Pin
9	807-1075SS	Weld Nut, M8 x 1.25 mm
10	960825MSS	Hex Head Cap Screw, M8 - 1.25 x 25 mm
11	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
12	991008MSS	Hex Nut, M10 - 1.50 mm
LLLL = Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" LLLL = 09525		

# Service Parts

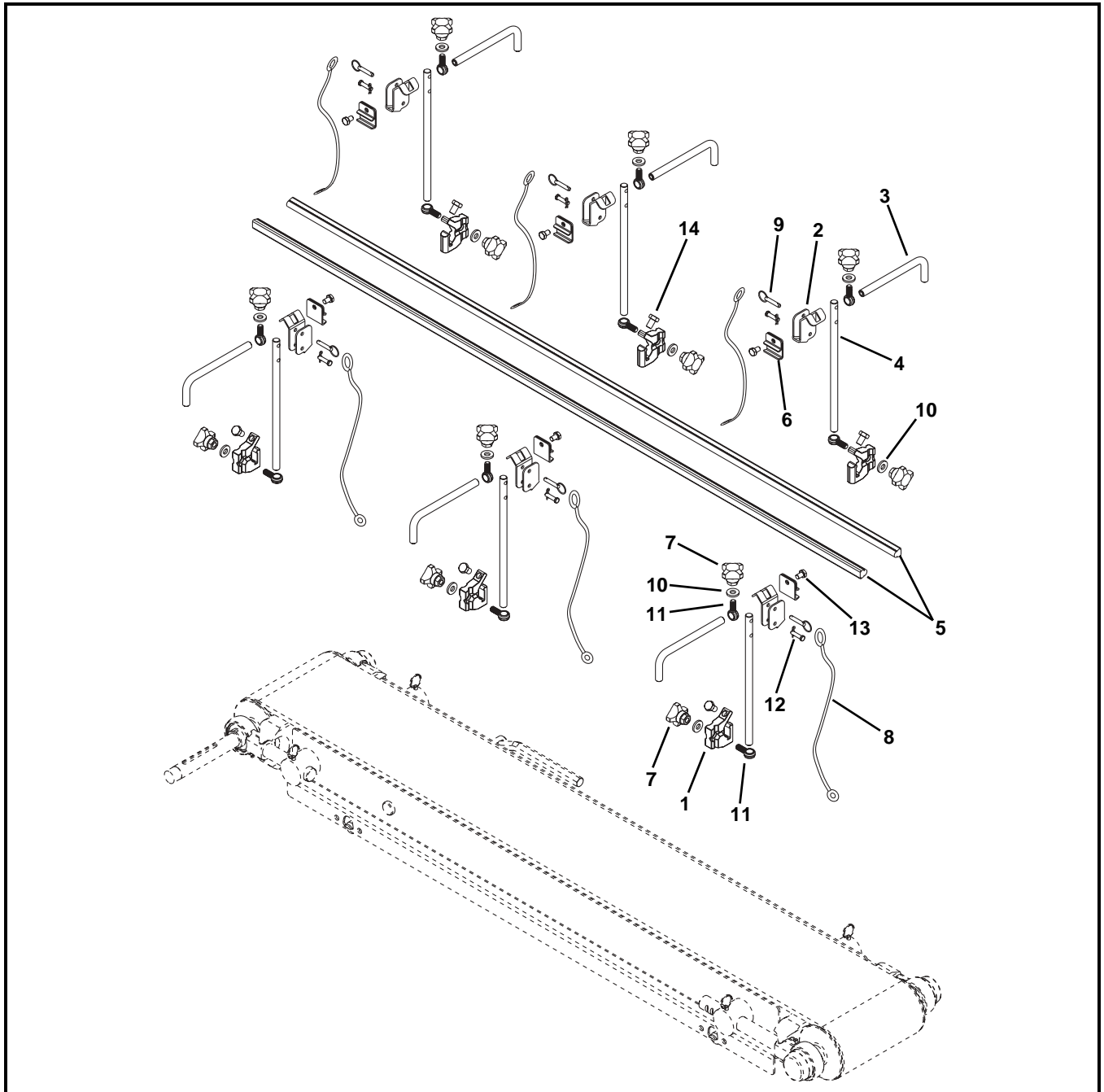
## Adjustable Hinged Guides



Item	Part Number	Description
1	509868	Mounting Block
2	509883	Pivot Guide Bracket
3	532300	Guide Post
4	509872-DH-1100	Adjustable Guide Shaft
5	532167-LLLLL	Guiding
6	807-015	Clamp Rail
7	807-1448	Lanyard
8	807-1553	Pin
9	807-1821	Washer
10	807-1994	Eyebolt M10 x 1.50

Item	Part Number	Description
11	807-1995	Cotter Pin
12	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
13	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
14	991001MSS	Hex Nut, M10 - 1.50
15	991008MSS	Hex Nut, M10 - 1.50 mm
LLLLL = Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

## Tool-Less Adjustable Hinged Guides

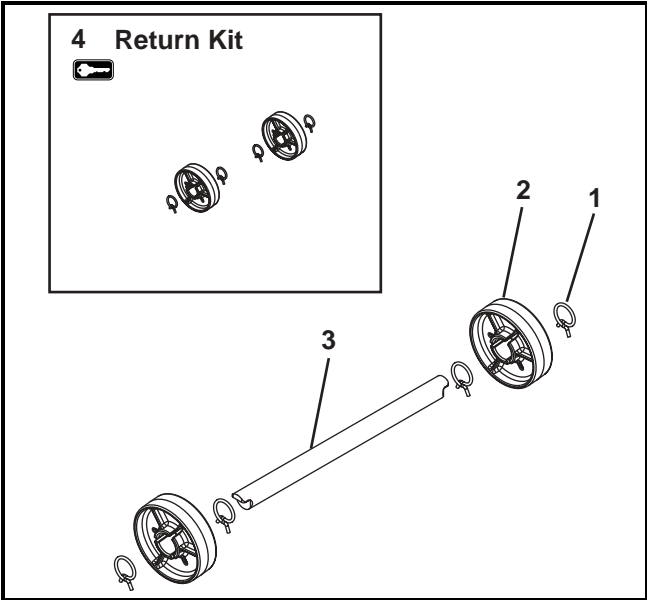


Item	Part Number	Description
1	509868	Mounting Block
2	509883	Pivot Guide Bracket
3	532300	Guide Post
4	509872-DH-1100	Adjustable Guide Shaft
5	532167-LLLLL	Guiding
6	807-015	Clamp Rail
7	807-1057	Handle
8	807-1448	Lanyard
9	807-1553	Pin
10	807-1821	Washer

Item	Part Number	Description
11	807-1994	Eyebolt M10 x 1.50
12	807-1995	Cotter Pin
13	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
14	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
LLLLL = Length in inches with 2 decimal places. Example: Guide Length = 95.25" LLLLL = 09525		

# Service Parts

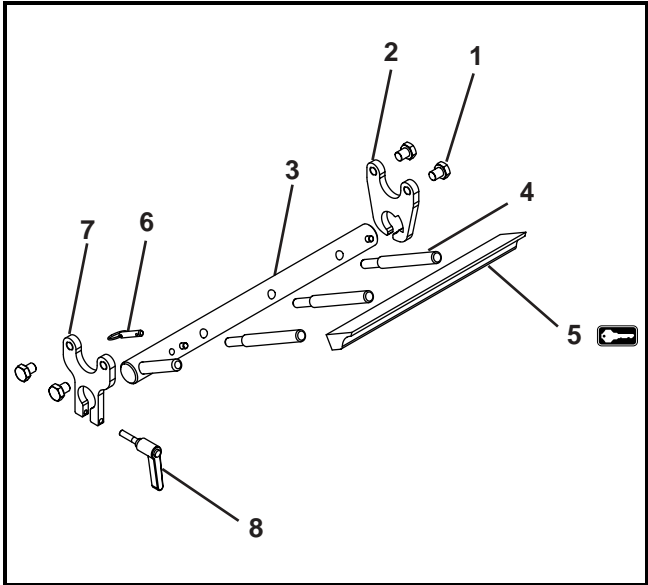
## Flat Belt Returns



Item	Part Number	Description
1	807-1551	Clamp
2	506296	Return Disk
3	5108 <del>WW</del>	Return Shaft
4	76R- <del>WW</del>	Return Kit (Includes Items 1 and 2)

~~WW~~ = Conveyor width ref: 06 - 60 in 02 increments

## Scraper

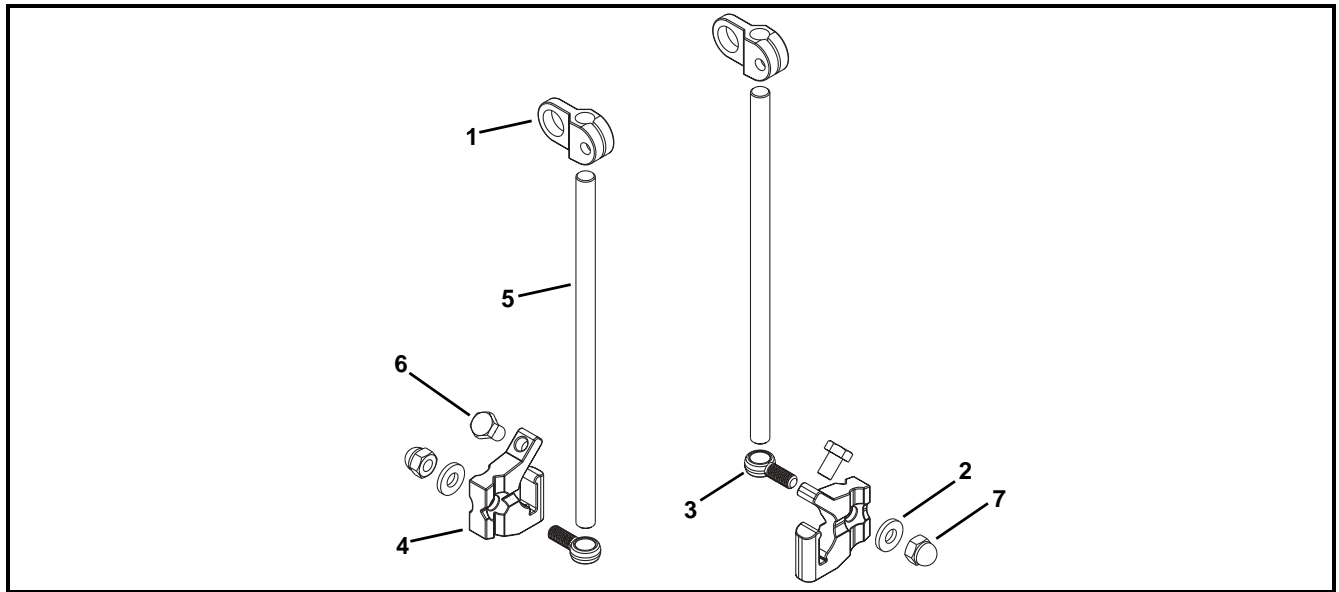


Item	Part Number	Description
1	961012MSS	Hex Head Cap Screw, M10-1.50 x 12 mm
2	500878	Scraper Adjust Plate
3	5102 <del>WW</del>	Scraper Shaft Assembly
4	500881	Scraper Holder Bar
5	5047 <del>WW</del>	Scraper Wear Bar
6	807-1553	Pull Pin
7	500879	Scraper Mount Plate
8	807-1559	Handle

~~WW~~ = Conveyor width ref: 06 - 60 in 02 increments



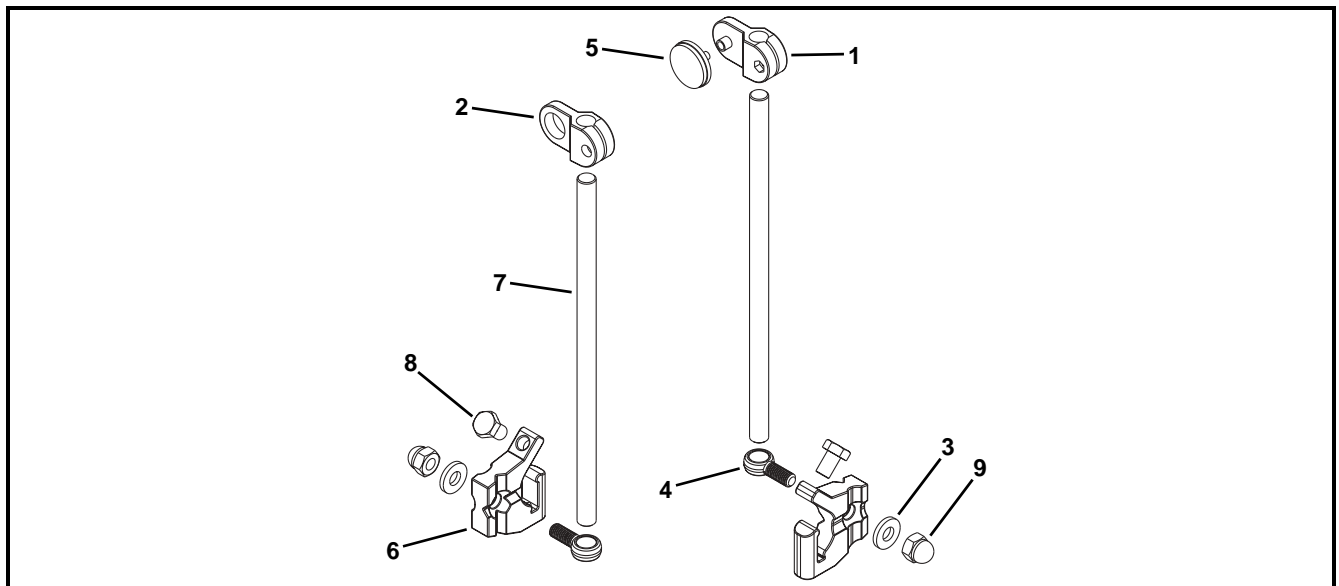
## Opposed (Thru Beam) Photo Eye Mount



Item	Part Number	Description
1	807-1391	Mount Clamp
2	807-1821	Washer
3	807-1994	Eyebolt, M10 x 1.50
4	509868	Mounting Block

Item	Part Number	Description
5	509872-NH-1100	Mounting Shaft
6	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
7	991008MSS	Hex Nut, M10 - 1.50

## Reflective Photo Eye Mount

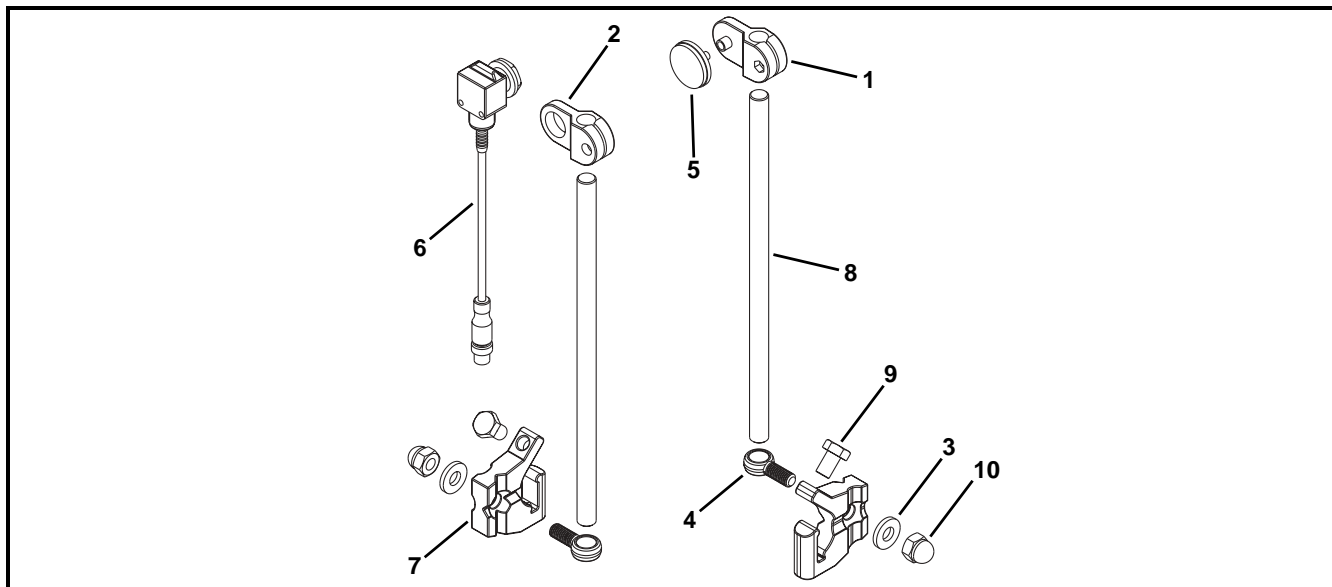


Item	Part Number	Description
1	807-1390	Reflector Mount Clamp
2	807-1391	Photo Eye Mount Clamp
3	807-1821	Washer
4	807-1994	Eyebolt, M10 x 1.50
5	809-289	Reflector

Item	Part Number	Description
6	509868	Mounting Block
7	509872-NH-1100	Mounting Shaft
8	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
9	991008MSS	Hex Nut, M10 - 1.50

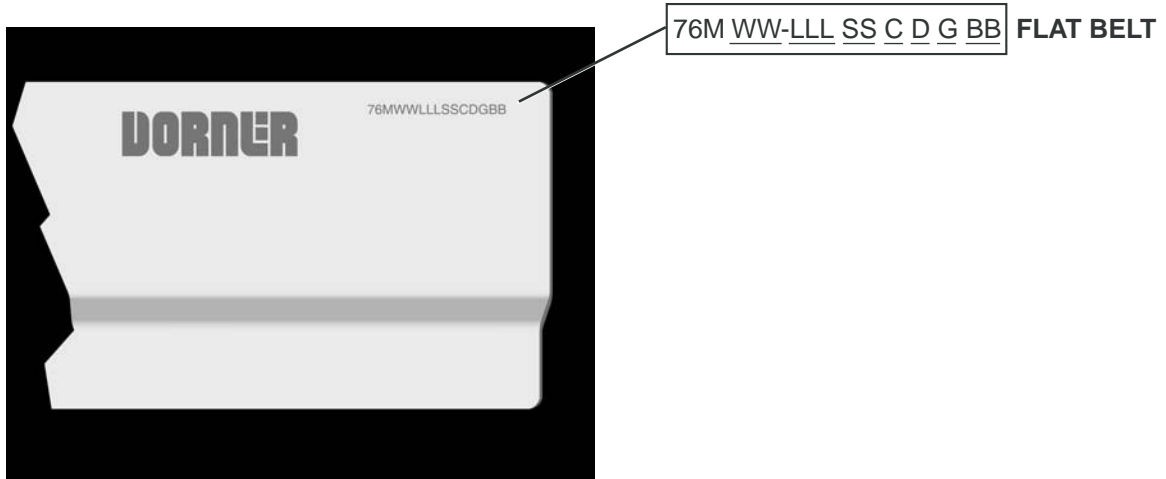
# Service Parts

## Reflective Photo Eye Kit



Item	Part Number	Description
1	807-1390	Reflector Mount Clamp
2	807-1391	Photo Eye Mount Clamp
3	807-1821	Washer
4	807-1994	Eyebolt, M10 x 1.50
5	809-289	Reflector
6	809-315	Photo Eye Sensor
7	509868	Mounting Block
8	509872-NH-1100	Mounting Shaft
9	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
10	991008MSS	Hex Nut, M10 - 1.50

## Configuring Conveyor Belt Part Number



*Figure 104*

### Flat Belt Part Number Configuration

Refer to model number on the conveyor frame (**Figure 104**). From the model number determine the conveyor width (WW), length (LLL), drive/tail types (A) and belt type (BB). Use data to configure belt part number as indicated below.  
\*Add "V" for v-guided belts.

**76-WW LLL A / BB V\***  
**76-\_\_\_\_\_ / \_\_\_\_\_ V\***  
(Fill In)

# 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.

	Product Type								
	Standard Products								Engineered to order parts
Product Line	Conveyors	Gearmotors & Mounting Packages	Support Stands	Accessories	Spare Parts (non-belt)	Spare Belts - Standard Flat Fabric	Spare Belts - Cleated & Specialty Fabric	Spare Belts - Plastic Chain	All equipment and parts
1100	30% return fee for all products except: 50% return fee for conveyors with modular belt, cleated belt or specialty belts						non-returnable		case-by-case
2200									
2200 Modular Belt									
2200 Precision Move									
2300									
2300 Modular Belt									
3200									
3200 LPZ									
3200 Precision Move									
4100									
5200									
5300									
6200									
Controls									
7200 / 7300	50% return fee for all products								
7350	non-returnable								
7360									
7400									
7600									

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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