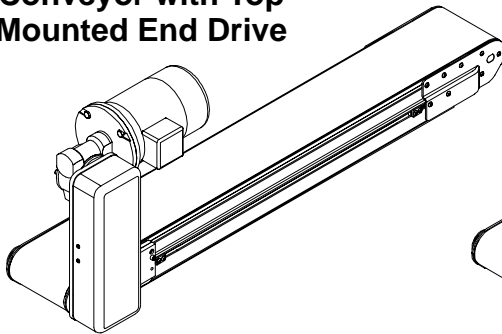


## **3100 Series End Drive Conveyors**

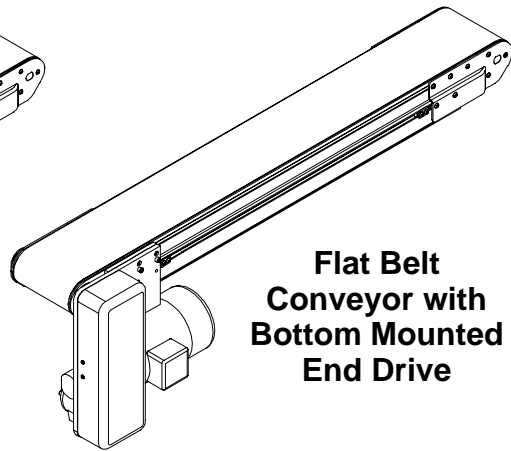
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### **Set-up, Operation & Maintenance Manual**

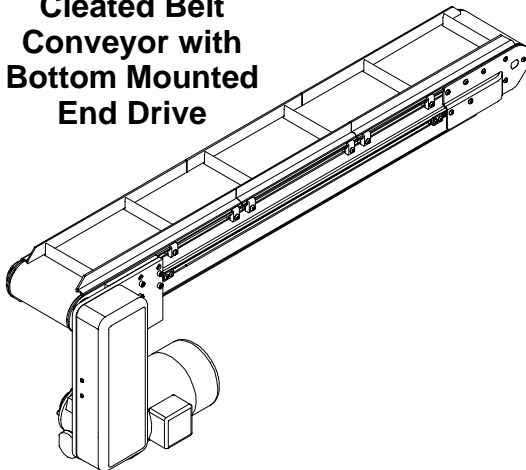
**Conveyor with Top  
Mounted End Drive**



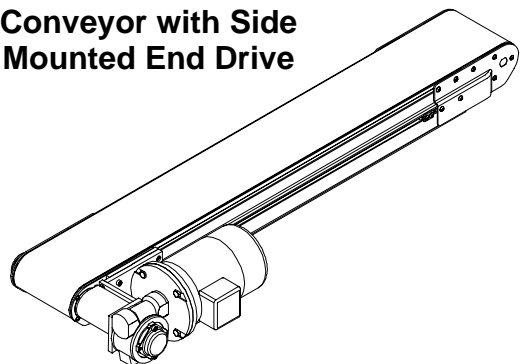
**Flat Belt  
Conveyor with  
Bottom Mounted  
End Drive**



**Cleated Belt  
Conveyor with  
Bottom Mounted  
End Drive**



**Conveyor with Side  
Mounted End Drive**



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## Safe Practices



# WARNING

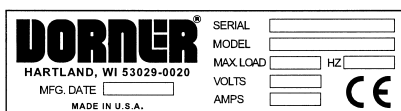


- The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.
- Standing on a conveyor or transporting people is prohibited.
- When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, check for potential pinch points and other mechanical hazards before system start-up. Because Dorner Mfg. Corp. cannot control the physical installation and applications of multiple conveyor systems, taking protective measures is the responsibility of the user.
- Operating Dorner conveyors in an explosive environment is prohibited.
- NEVER operate equipment without guards or other protective devices properly secured in place. In addition, to prevent injury, make sure all electrical and pneumatic power sources have been disconnected and locked-out before you perform any maintenance, make any adjustments or replace any components.
- These gearmotors operate at an elevated temperature which may cause people to be startled if they accidentally touch the motor housing.
- Before proceeding to loosen hardware that locks-in the selected stand height, be sure that all related Conveyor sections are securely supported to prevent them from moving suddenly and dropping-down which may pinch or strike you, causing serious personal injury.

## Foreword

By following the set-up, operation & maintenance instructions in this manual, you will prolong the life of your conveyor and maintain its maximum efficiency.

When ordering replacement parts, always give the serial and model numbers. These numbers are on the plate (Figure 1) which is located on the conveyor side rail. Record these numbers, in the spaces provided, for future reference.



**Figure 1: Typical Model & Order Number Nameplate**

Specified "MAX. LOAD" is based on conveyor being in a horizontal position with a non-accumulating, evenly distributed load.

Serial Number \_\_\_\_\_

(Fill In)

Model Number \_\_\_\_\_

(Fill In)

The Timing Belt has a length designation stamped onto it and the Gear Reducer and Electric Drive Motor have Dorner part number tags affixed to them. Use the spaces provided to record these numbers:

Timing Belt ( \_ \_ \_ H )

Gear Reducer (820- \_ \_ \_ )

Electric Drive Motor (826- \_ \_ \_ )

For pictorial clarity, some illustrations in this manual may show guards or other protective devices open or removed. Under no circumstances should the conveyor be operated without these devices securely in place.

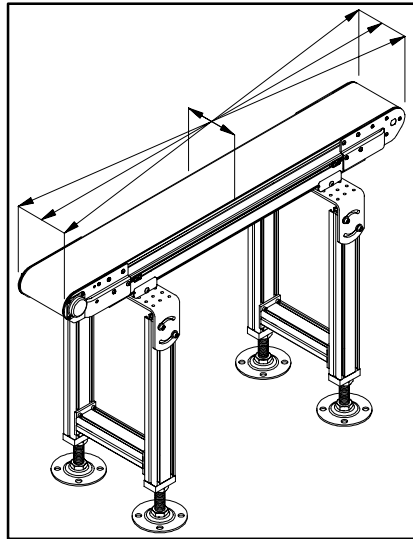
**NOTE:** All technical data in this publication is based on the product information available at time of printing. Dorner reserves the right to make changes at any time without notice or obligation to install those changes on units previously delivered.

## General Information

Using appropriate lifting means, carefully remove the conveyor assembly or section from the shipping container and place it in its correct operating position and direction.

Use Dorner stands and compatible mounting hardware, or your own mounting provisions, to securely mount the conveyor. For details, refer to a Dorner Support Stands Manual.

The conveyor must be mounted straight, flat and level, within the confines of the conveyor. Refer to Figure 2 and use a straight edge and a level for initial set up.



**Figure 2: Conveyor Alignment Reference Detail**

**IMPORTANT:** Do not bend or twist the conveyor frame when mounting the conveyor.

Refer to separate Mounting Package Re-assembly Instructions to attach the gearmotor.

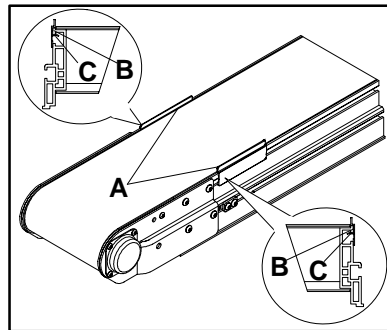
**NOTE:** To achieve maximum load carrying capability, the gearmotor should pull the conveyor belt towards the drive.

All low side conveyors without optional guiding have factory installed belt tracking guides (A of Figure 3) installed on both ends of conveyor.

**To remove the guide,** apply a slight outward and downward finger-pressure on one of the top corners of the guide and gradually peel it off the portion of the conveyor sidewall (B).

**To install the guide,** place the lower lip (C) of the guide against the upper edge of the conveyor sidewall upper T-slot channel. Then, apply inward and upward pressure to completely snap it into place.

**NOTE:** Use the belt tracking guides (A of Figure 3) during initial conveyor startup for tracking conveyor belt, as necessary. Guides may be left on or removed after startup. Be sure to save the belt tracking guides for start-up after conveyor belt cleaning or replacement.



**Figure 3: Conveyor Low Side Belt Tracking Guide Installation Detail**

## Special Instructions for Conveyors Over 3965 mm

**NOTE:** The following setup procedures apply to End Drive Conveyors longer than 3965 mm.

All end-driven conveyors are manufactured with endless conveyor belts. Conveyors over 3965 mm long are configured and built at the factory. Then, they are partially disassembled, crated and shipped in sections. The customer must re-assemble the sections and tension the conveyor belt. The following procedure is recommended:

**1.** Position each stand, with its mounting bracket with return roller assembly attached, in the proper location to support the drive end, frame split and tail end. For details, refer to a Dorner Support Stands Manual.

**2.** Place the conveyor belt around the assembled drive/intermediate section. Push the lower return run of the belt up into the conveyor frame, when lowering the section onto the mounting bracket with return roller assembly, to prevent pinching the belt.

**NOTE:** On the underside of the conveyor, the belt rides on the return rollers. The rollers **MUST** be perpendicular to the conveyor belt and rotate freely.

**3.** Clamp the drive/intermediate section to the stand with mounting bracket and return roller assembly.

**4.** Unroll the belt toward the tail end of the conveyor.

**5.** Install the tension end tail section into the intermediate section end, if not already assembled.

**6.** Place each section inside the conveyor belt loop. To prevent pinching the conveyor belt, make sure the return belt is tucked-up into the conveyor frame while the conveyor is being set down onto the mounting bracket with return roller assembly. Fasten sections together using a connecting assembly. Each conveyor joint must also be clamped to a support stand.

**7.** Make sure that intermediate sections and tail assemblies are butted tightly together and securely fastened.

**8.** Clamp all intermediate/tail sections to the support stands.

**9.** Set the conveyor belt tension. Refer to "Conveyor Belt Tension Adjustment" topic beginning on page 7.

# Lubrication & Maintenance

## Lubrication

### **WARNING**

To prevent injury, make sure all electrical power sources have been disconnected and locked-out before you perform any maintenance, make any adjustments or replace any components.

## 76 mm Pulley Bearings (Not Re-greasable)

**NOTE:** All 76 mm Pulley Bearings are sealed and are not re-greasable.

## Optional Interface Tail Section with Twin 25 mm Pulley Bearings

Lubricate the twin 25 mm pulley bearings (A of Figure 4), on each side of the conveyor, every 750 hours of operation or more frequently, when conditions warrant. Use a conventional hand-operated grease gun with a maximum of one pump per application. To prevent damage to the bearing, do not use a power grease gun which creates undue pressure that may unseat the bearing. Use Dornier Red Grease 397 gram cartridge, part number 829-002, or 397 gram can, part number 829-003.

**NOTE:** Do not over-lubricate the twin pulley bearings.

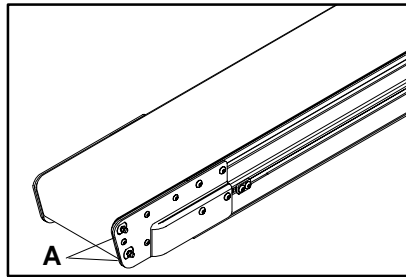


Figure 4: Twin 25 mm Pulley  
Lubrication Detail

## Conveyor Belt Maintenance

### Inspection

**NOTE:** When a problem is identified, be sure to perform the necessary corrective maintenance.

Inspect the conveyor belt for:

- Surface cuts or wear
- Tracking problems
- Worn edges
- Accumulated dirt
- Jammed parts
- Stalling or slipping
- Stretching or breaking
- Belts that walk to one side
- Non-uniform movement of the conveyor belt
- Lines or rough edges on belt

### Problem Identification

Belts that walk to one side indicate:

- Belt tracking incorrectly. Refer to “Conveyor Belt Tracking Adjustment” topic beginning on page 8.
- Twisted or damaged conveyor frame
- Dirt accumulating on the outside diameter of the pulleys
- Side load on belt.

Non-uniform movement indicates:

- Excessive load on conveyor belt
- Intermittent jam or drive train problems
- Conveyor belt or drive timing belt, when applicable, are not properly tensioned

Lines or rough edges on belt could indicate:

- Belt tracking incorrectly. Refer to “Conveyor Belt Tracking Adjustment” topic on page 8.
- Jammed part
- Foreign material inside the conveyor
- Improperly positioned mounted accessories causing interference

## Cleaning

**IMPORTANT:** Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.

For most conveyor belts, use Dornier Belt Cleaner, part number 625619, or equivalent. Mild soap and water may also be used. Do not soak the belt.

Due to the texture of woven polyester and black anti-static belts, use a small semi-stiff bristled brush to improve cleaning.

# Component Replacement and Adjustments

## Conveyor Repair Preparations

### Tools

Use Dorner Tool Kit Part Number 2500M-ENG for proper maintenance. Follow instructions accompanying the tool kit.


### Checklist

To avoid costly delays in repair, use the following checklist:


- Have complete pulley assemblies, replacement belts, return roller bearings, drive components, gearmotors and fasteners in stock and ready for use.
- Inspect the entire conveyor while it is disassembled.
- Thoroughly clean the conveyor inside and outside during repair. Remove any impacted dirt from the knurls on the outside diameter of the pulley.
- Replace all worn and damaged parts.
- Check all bearings for smooth operation.

### General Information

Disconnect and lock-out the electrical power source. To facilitate re-assembly, mark any critical accessory locations along the entire side of the conveyor frame from which the belt is going to be removed.



**WARNING**



**To prevent injury, make sure all electrical power sources have been disconnected and locked-out before you perform any maintenance, make any adjustments or replace any components.**

**In addition, the weight of the gearmotor is all on one end of the conveyor. This could cause the conveyor to tip off the stands when the mounting clamps are removed. Be sure to provide some form of support (L of Figure 8) underneath the gearmotor while the belt is being changed.**

## Conveyor Belt Replacement Procedure

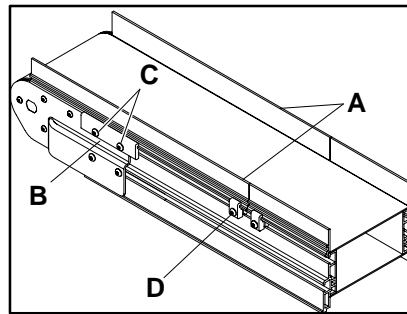
### Conveyor Guiding & Return Belt Skirting

A low-sided flat belt conveyor may be equipped with guiding (A of Figure 5) on both sides of the conveyor. Similarly, cleated belt conveyors are equipped with guiding and may also be equipped with return belt skirting. When the conveyor belt is going to be replaced, the guiding and skirting, if present, must be temporarily removed from the side opposite the gearmotor mounting

package so that the existing conveyor belt can be removed from that section and the new belt installed.

Be sure also to remove tension end guiding and return belt skirting, if present, on both sides of the conveyor to enable releasing conveyor belt tension.

The guiding on the ends of the conveyor may be secured with end guide mounting clamps (B) which are secured to the tail plate covers with two (2) M6 x 18 mm button head cap screws (C). Guiding, in all other places is secured with appropriate quantities of guide retaining clips (D), M6 x 18 mm button head cap screws and single drop-in T-bars.



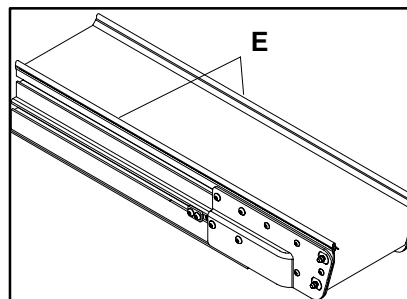
**Figure 5: Low-sided Conveyor Guiding Removal Detail**

Be sure to mark (or make appropriate notation of) the clip (D) positions and guide section (A) locations. Then, remove guiding and return belt skirting, if present, from the side of the conveyor opposite the gearmotor.

To remove the guiding and return belt skirting, if present, refer to Figure 5 and loosen, remove and retain the guide clamps. Guide and return belt skirt replacement is in reverse sequence of removal.

### High-sided Conveyor Side Wipers

A standard high-sided flat belt conveyor may be equipped with side wipers (E of Figure 6). These side wipers must be temporarily removed from both sides of the conveyor so that the existing conveyor belt can be removed and the new belt installed.



**Figure 6: Optional Side Wipers Installation Detail**

### Releasing Conveyor Belt Tension

The following procedure should be used to release the conveyor belt tension, before proceeding to remove the old belt:

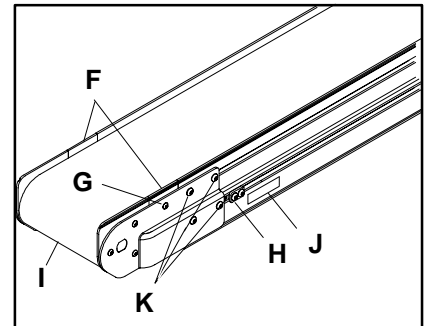
1. Locate the tension end (I of Figure 7) of the conveyor, identified with label (J)

2. On a standard high-sided conveyor only, remove each filler plate screw (G) and each filler plate (F) from both sides of the conveyor.

3. If engaged, loosen the belt tracking cam assemblies (H), on both sides of the tensioning end (I). Slide the cam assemblies toward the middle of the conveyor.

4. Loosen the tail cover plate screws (K), on both sides of the tensioning end.

5. Collapse the tensioning end (I) of the conveyor by pushing it back into the conveyor frame, using the heel of your hand. This will sufficiently loosen the conveyor belt for removal.



**Figure 7**


### Belt Removal

Wherever possible, the conveyor belt should always be removed from the side opposite the gearmotor. In addition, remove any controls, stops or other attached accessories from that side, which could interfere with belt removal.


1. Safely and temporarily support the conveyor section with a sturdy support mechanism (L of Figure 8) (such as wooden blocks or a sawhorse).

**NOTE:** For additional details, refer your Support Stands Set-up, Operation & Maintenance Manual.

2. Remove and retain the mounting clamp plate screws (N) and clamp plates (M) from both sides of the conveyor.



**WARNING**



**To prevent injury from the support stand tipping-over when conveyor is uncoupled, be sure to anchor the stand to the floor or otherwise properly stabilize the stand before it is detached from the conveyor.**

3. With the clamp plates (M) removed, from both sides of the conveyor, carefully raise-up the side opposite the gearmotor and slide the old belt sideways and away from conveyor.

# Conveyor Belt Replacement & Adjustments

4. As necessary, remove the old conveyor belt, section by section, until it is completely off.

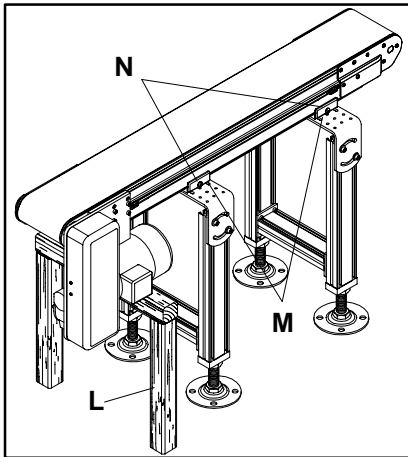


Figure 8

## Belt Replacement

Orient the replacement belt so the belt splice leading fingers (P of Figure 9) point in the direction of belt travel (AS) and that the outside fingers (Q) are positioned as shown.

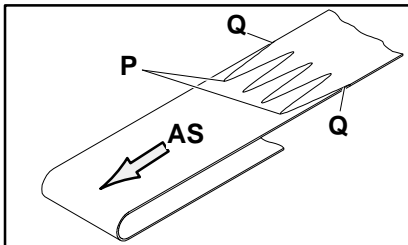


Figure 9: Replacement Belt Orientation Detail

1. Begin a new conveyor belt installation on the same end and side of the conveyor from which the old belt was last removed. Install the new belt by sliding it sideways onto the conveyor frame assembly, from the non-drive side. Once the new belt is in position, the conveyor can be lowered into contact with the clamp blocks while being careful not to pinch the conveyor belt. With the conveyor in position, replace and fully tighten the screws (N of Figure 8) to secure the mounting clamp plates to the clamp blocks.

2. Install the new conveyor belt by raising the side opposite the gearmotor and sliding the new belt sideways between the bottom of conveyor and the top of the mounting bracket return belt roller.

3. As necessary, install the new conveyor belt, section by section, until it is completely in position around the conveyor.

4. Then, replace and re-secure the clamp plates (M) and mounting clamp plate screws (N).

**NOTE:** Do not replace the guiding and return belt skirting, if present, at this time. Replace after proper conveyor belt tension has been achieved.

5. Do not tightly secure the tail cover plate screws at this time. Make sure all other hardware that was either removed or loosened is replaced and properly tightened.

6. Refer to procedures under the "Conveyor Belt Tension Adjustment" topic, on page 7, for conveyor belt tension adjustment procedures. Then, refer to the "Conveyor Belt Tracking Adjustment" topic, on page 8, for belt tracking procedures.

7. Replace the guiding and return belt skirting, if present, after the proper belt tension and tracking is established.

8. Refer to the positions previously marked and replace the controls, stops and other attached accessories, after the proper belt tension and tracking is established.

## Optional Twin 25 mm Pulley Removal & Bearings Replacement

### Pulley Removal

1. Remove the conveyor belt from the tail for access to the pulleys. Refer to the "Conveyor Belt Replacement Procedure" beginning on page 5.

2. Remove the tail cover plate screws (K of Figure 10) and tail cover plates (R) on both sides of the conveyor.

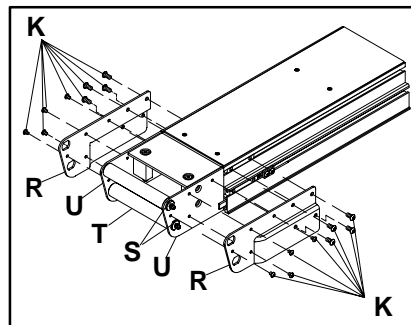


Figure 10

3. Remove the retaining sleeves (S) and pulley (T). If retaining sleeves are stuck or wedged-tight in the tail plate (U), proceed to the next step.

4. To remove a wedged sleeve, refer to Figure 11 and remove the grease fitting. Then, working through the grease fitting hole (V of Figure 11) in the sleeve (S), form a puller arrangement as shown. Use the bearing anvil/sleeve removal tool, 25-09 (W), washer 605279 (X) and M6 x 35 mm socket head cap screw 920635M (Y). (All

part numbers are provided in the Tool Kit 2500M.)

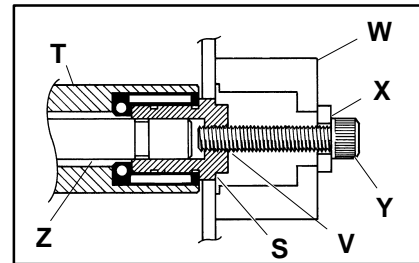


Figure 11

5. Remove the pulley shaft (Z) from the pulley (T) and replace the pulley bearing. See "Bearing Removal" subtopic on this page.

## Bearing Replacement

### Bearing Removal

Use the following procedure to remove pulley bearings:

1. Make sure that the shoulder (AC of Figure 12) on the bearing removal tool is completely closed. If it is slightly open it may not fit into the bearing (AF of Figure 13). Use the hex key wrench extension tool 25-08 (AD) and loosen the tapered screw (AB of Figure 12) while compressing the flare (AC) inward to make sure that the tool is completely closed. (All part numbers are provided in the Tool Kit 2500M.)

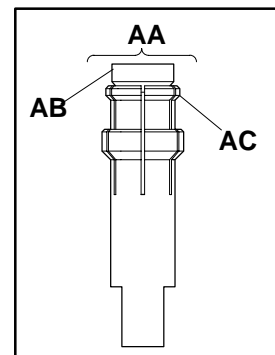


Figure 12: Bearing Removal Tool

2. Insert bearing removal tool (AE of Figure 13) into the pulley (T) through bearing (AF).

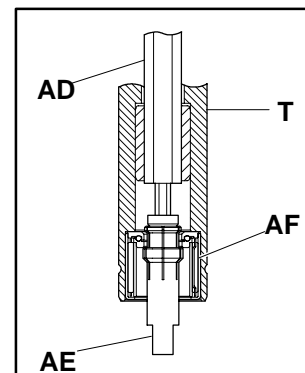


Figure 13

## 3100 Series End Drive Conveyor Set-up, Operation and Maintenance 7

# Conveyor Belt Replacement & Adjustments

## Conveyor Belt Tracking Adjustment

Make sure the conveyor belt is properly tensioned and that the conveyor is straight and level in all directions within the confines of the conveyor.

This conveyor is equipped with an articular linkage which allows the pulley to be positioned at a slight angle to facilitate belt tracking.

If you are working on a low side conveyor, re-install the belt tracking guides following the details of Figure 3 on page 3.

Check both ends of the conveyor for proper belt tracking. The belt should track centered between the tail plates on both ends of the conveyor. Conveyor belt tracking should always be adjusted on the discharge end of conveyor first. Then, check the tracking on the opposite (infeed) end of the conveyor and readjust, if necessary.

To adjust belt tracking:

**1.** Loosen (but do not remove) the two cam clamping plate screws (AP) on both sides of

the conveyor discharge.

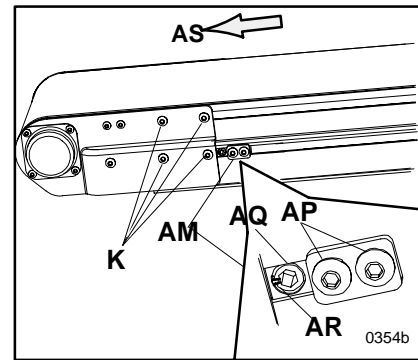
**2.** Slide both belt tracking cam assemblies (AM of Figure 17) as far as they can be moved toward the end of the conveyor.

**3.** The belt tracking cam (AQ) must be set to the low point at the point of contact as illustrated. The slot (AR), in the belt tracking cam, should be horizontal and pointing towards the end of the conveyor.

**4.** Tighten the two (2) belt tracking cam retaining plate screws (AP), on both sides of the conveyor.

**5. Only loosen the four tail cover plate screws (K of Figure 17) on the side of the conveyor that the belt is tracking toward.**

**6.** Use the 5 mm key wrench (AN of Figure 16) to slowly rotate the belt tracking cam (AQ of Figure 17) in small increments in either direction to cause the belt to track away from the conveyor side, until the belt tracks in the center of the conveyor. Always allow the conveyor belt to make several revolutions between adjustments.



**Figure 17**

**IMPORTANT:** Rotate belt tracking cam very slowly and in small increments, to prevent the belt from moving beyond the desired centered position.



**7.** While holding the belt tracking cam (AQ of Figure 17) in position, tighten the tail cover plate screws (K) and re-check the belt tracking.

**8.** Recheck belt tracking, on opposite end of the conveyor, and adjust if needed.



# Component Replacement and Adjustments

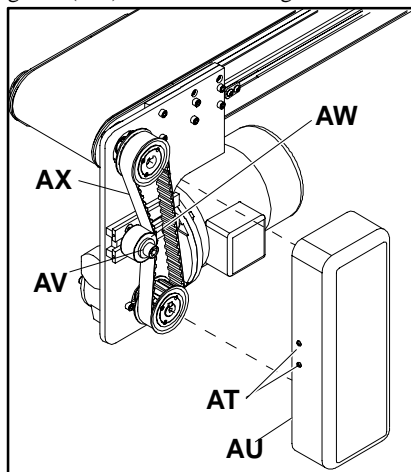
## Timing Belt Tension Adjustment for Top & Bottom Mounting Packages

**WARNING**

To prevent injury, make sure all electrical power sources have been disconnected and locked-out before you perform any maintenance, make any adjustments or replace any components.

**NOTE:** The following information applies to both top mounting (Figures 19 & 20) and bottom mounting (Figures 21 & 22) packages. The position of the tensioning bearing assembly (AW) with respect to the timing belt (AX) is dictated by the direction of conveyor belt travel (AS).

1. Disconnect power. Then, remove the screws (AT of Figure 18) securing the belt guard (AU) and remove the guard.



**Figure 18: Belt Guard Removal Detail**

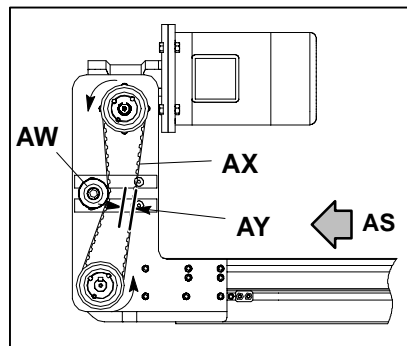
2. Check the timing belt for wear. Replace it if worn.
3. Loosen the cap screw (AV) that secures the tensioning bearing assembly (AW).

4. Slide the tensioning bearing assembly (AW) against the timing belt (AX), until the deflection of the belt at the midpoint of the section of belt (AY of Figures 19 through 22) (opposite the tensioning bearing assembly) is 3 mm for a 3 kg force applied at that point. For optimum performance, the timing belt should be tensioned so as to prevent jumping of teeth under the most severe conditions which the drive will encounter.

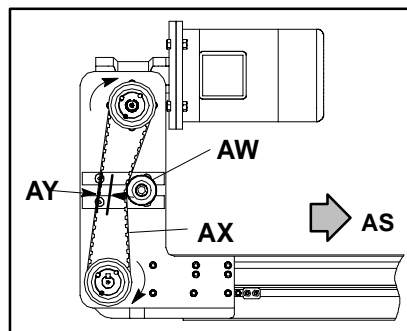
**NOTE:** Over-tensioning the timing belt may cause reduced belt life or bearing and drive damage.

5. Tighten the tensioning bearing assembly cap screw (AV of Figure 18) with 24 Nm of torque.

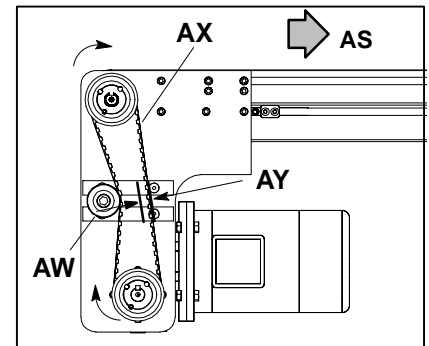
6. Re-assemble the belt guard (AU) and belt guard screws (AT).



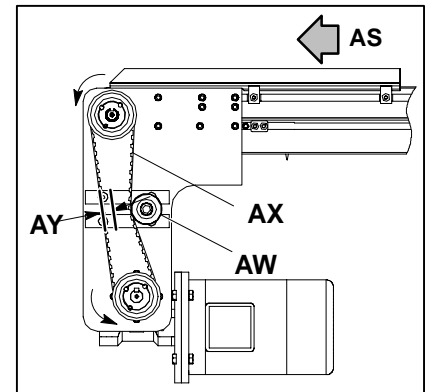
**Figure 19: Top Mount Package**



**Figure 20: Top Mount Package**

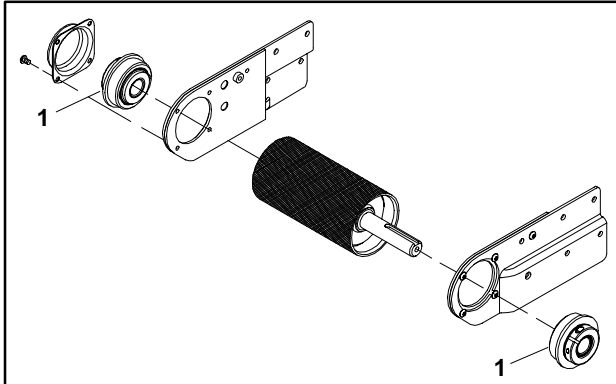


**Figure 21: Flat Belt Bottom Mount Package**

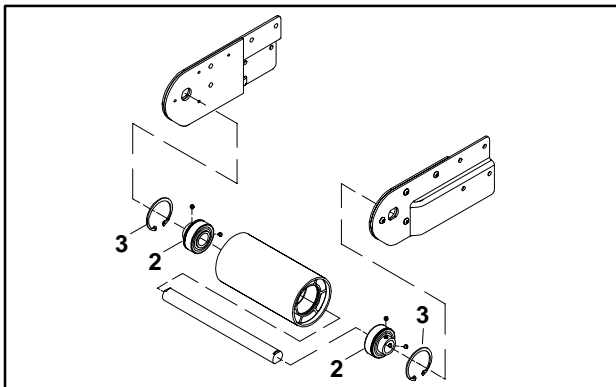


**Figure 22: Cleated Belt Bottom Mount Package**

## Replacement Component Part Numbers

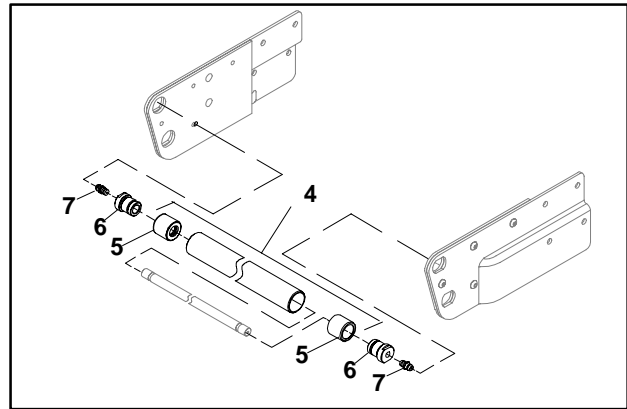


Item	Part No.	Part Description
1	300146	Bearing Assembly



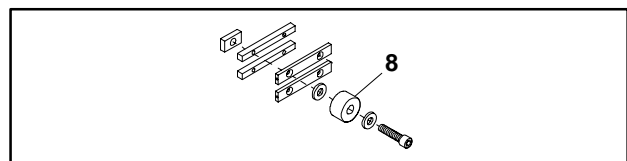
Item	Part No.	Part Description
2	802-110	Ball Bearing & Set Screws Assembly
3	915-051	Retaining Ring

**NOTE:** For replacement **Drive Belt Tensioning Idler Bearing (8)**, order part number 802-059. See (AW) on page 9, for access and disassembly details.



Item	Part No.	Part Description
4	303104	Pulley Ass'y, 95 mm
	303105	Pulley Ass'y, 127 mm
	303106	Pulley Ass'y, 152 mm
	303108	Pulley Ass'y, 203 mm
	303110	Pulley Ass'y, 254 mm
	303112	Pulley Ass'y, 305 mm
	303118	Pulley Ass'y, 457 mm
	303124	Pulley Ass'y, 610 mm
5	41-33	Bearing
6	300035M	Retaining Sleeve Ass'y
7	810-292	Grease Fitting, Straight

**NOTE:** For replacement parts, other than those shown on this page, contact the factory.



**Configuring Conveyor Belt Part Number****Flat Belt for Standard Conveyor**

To configure a part number for ordering an identical replacement flat conveyor belt, refer to your serial and model number plate and fill-in the same original “WW”, “LL” & “BB” numbers.

**30- WWLL/BB**

30- _____ / _____ (Fill In) (Fill In)
--

The following information is stamped onto the conveyor serial number and model number plate which you should have also recorded on page 2 of this manual.

<b>DORNER®</b> HARTLAND, WI 53029-0020 MFG. DATE _____ MADE IN U.S.A.	SERIAL	_____
	MODEL	3100CWWLL-00/BB
	MAX. LOAD	_____ HZ _____
	VOLTS	_____
	AMPS	_____
		<b>CE</b>

**Flat Belt for Conveyor with Transfer Tail**

To configure a part number for ordering an identical replacement flat conveyor belt, refer to your serial and model number plate and fill-in the same original “WW”, “LL” & “BB” numbers.

**30T WWLL/BB**

30T _____ / _____ (Fill In) (Fill In)
--

The following information is stamped onto the conveyor serial number and model number plate which you should have also recorded on page 2 of this manual.

<b>DORNER®</b> HARTLAND, WI 53029-0020 MFG. DATE _____ MADE IN U.S.A.	SERIAL	_____
	MODEL	3101CWWLL-00/BB
	MAX. LOAD	_____ HZ _____
	VOLTS	_____
	AMPS	_____
		<b>CE</b>

**Cleated Belt Conveyor**

To configure a part number for ordering an identical replacement cleated conveyor belt, refer to your serial and model number plate and fill-in all of the same original “WW”, “LL”, “TT” & “SSSS” numbers.

**34- WWLLTTSSSS**

34- _____ (Fill In)
------------------------

The following information is stamped onto the conveyor serial number and model number plate which you should have also recorded on page 2 of this manual.

<b>DORNER®</b> HARTLAND, WI 53029-0020 MFG. DATE _____ MADE IN U.S.A.	SERIAL	_____
	MODEL	3140CWWLLTTSSSS
	MAX. LOAD	_____ HZ _____
	VOLTS	_____
	AMPS	_____
		<b>CE</b>

## RETURN POLICY

No returns will be accepted without prior written factory authorization. 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. 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.

A representative will discuss action to be taken on the Returned items and provide a Returned Goods Authorization Number to reference.

There will be a 15% restocking charge on all new items returned for credit where Dorner was not at fault. These will not be accepted after 60 days from original invoice date. The restocking charge covers inspection, cleaning, disassembly, and reissuing 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. Feel free to contact Dorner for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dorner products.



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