3200 Series Modular Belt Curve Conveyors

Installation, Maintenance and Parts Manual

Available with: SmartSlot™

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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 3200 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 .

⚠ DANGER

SEVERE HAZARD!

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

⚠ DANGER

EXPLOSION HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

BURN HAZARD!

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

⚠ WARNING

PUNCTURE HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

Product Description

Refer to **(Figure 1)** for typical conveyor components.

Typical Components	
1	Conveyor
2	Weighted Take-Up
3	Belt
4	Support Stand
5	Drive End
6	Idler End

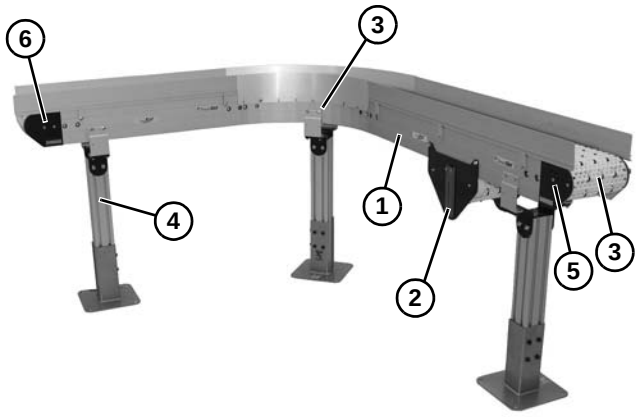


Figure 1

Specifications

Flat Belt Conveyor Width Reference (WW)	06 - 36 in 02 increments
Flat Belt Conveyor Belt Width	6" (152 mm) - 36" (914 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft^2 (97 kg/ m^2) with a maximum of 500 lbs. (227 kg)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	250 ft/minute (76 m/minute)

Conveyor Module Length Reference (LLL)	021 - 999 in 001 increments
Conveyor Module Length	21" (533 mm) - 999" (25.4 m) in 1" (25 mm) increments

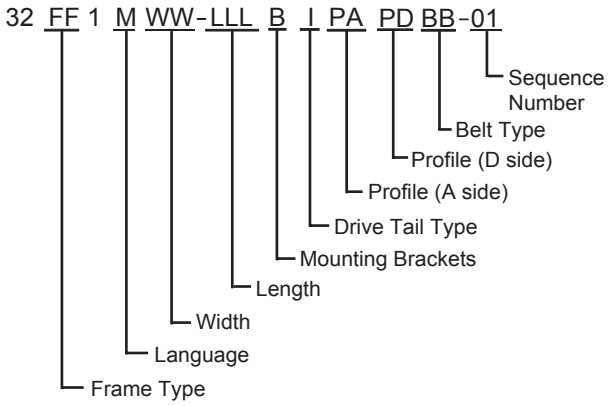
IMPORTANT

Maximum conveyor loads are based on:

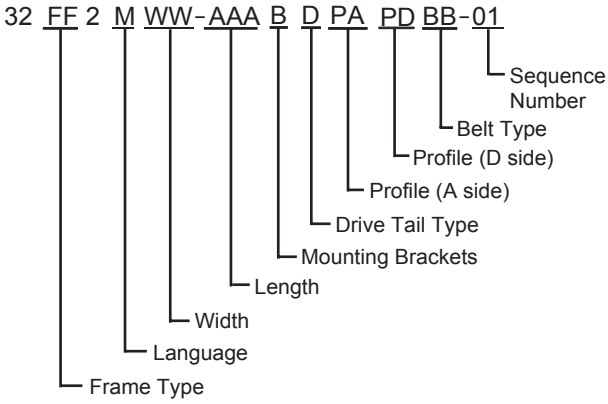
- *Non-accumulating product*
- *Product moving toward gearmotor*
- *Conveyor being mounted horizontally*
- *Conveyor being located in a dry environment*
- *Conveyor equipped with standard belt only*

3200 Series Curve Conveyor Modules

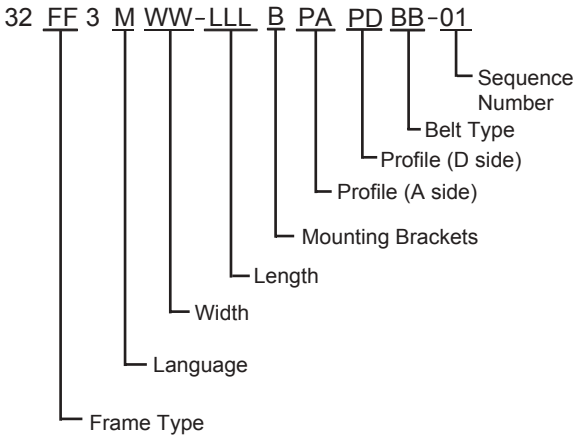
3200 Series Curve Conveyors Infeed Module



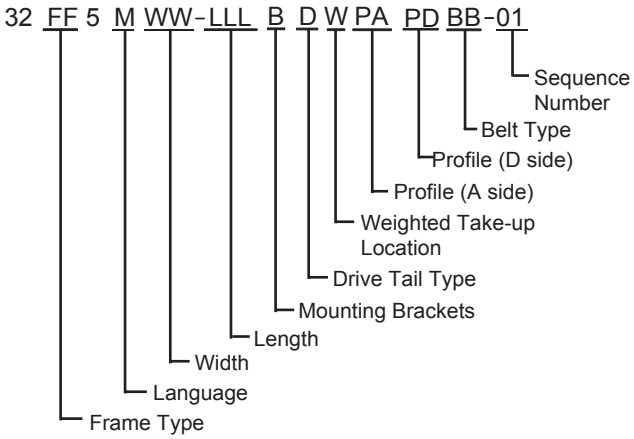
3200 Series Curve Conveyors Curve Module



3200 Series Curve Conveyors Intermediate Module



3200 Series Curve Conveyors Drive Module



Specifications

Conveyor Supports

Infeed / Idler Module:

- "A" = 3 ft (914 mm) maximum (See Figure 2)
- Modules up to 72" long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, plus an additional support stand at each straight section break (over 13' straight frame module)

Intermediate Module:

- Modules up to 84" long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, plus an additional support stand at each straight section break (modules over 13')

Exit / Drive Module:

- "B" = 3 ft (914 mm) maximum (See Figure 2)
- Modules up to 65" long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, plus an additional support stand at each straight section break (modules over 13')

Curve Module:

- Reference chart for support stand quantities, evenly spaced along curve (see chart).

	Number of Stand Mounts		
Degree Width	45°	90°	180°
06	0	0	1
08	0	1	1
10	0	1	1
12	0	1	1
14	0	1	1
16	0	1	2
18	0	1	2
20	1	1	2
22	1	1	2
24	1	1	2
26	1	1	2
28	1	1	3
30	1	1	3
32	1	1	3
34	1	1	3
36	1	1	3

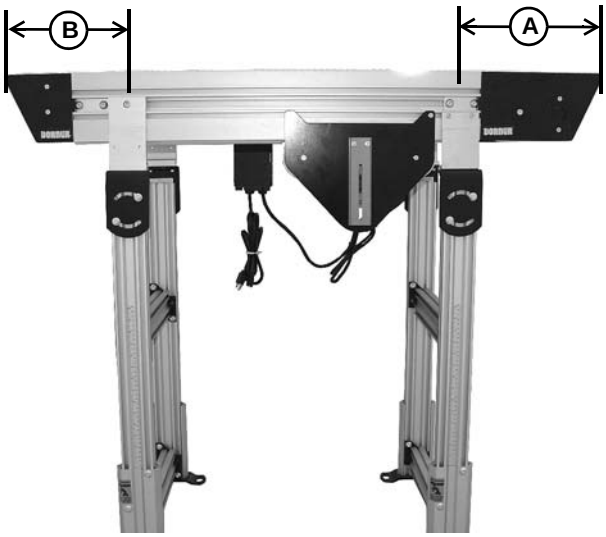


Figure 2

⚠ CAUTION

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

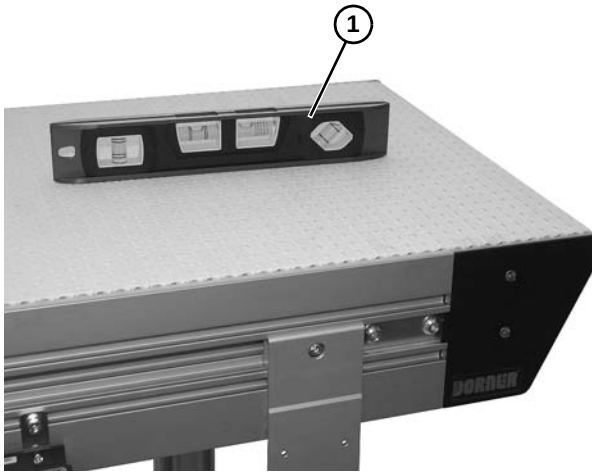


Figure 3

Required Tools

- Level
- Torque wrench
- 4 mm hex wrench
- 5 mm hex wrench

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to "Conveyor Sections Longer than 12 ft (3658 mm)" on page 7 and "All Conveyors" on page 8.
2. Attach the stands. Refer to "All Conveyors" on page 8.
3. Install the belt. Refer to "Belt Installation" on page 9.
4. Install the guiding. Refer to "Guiding (SmartSlot Frames Only)" on page 13 or Refer to "Guiding (T-Slot Frames Only)" on page 13.
5. Install the gearmotor. Refer to "Drive Package Installation" on page 15.

Conveyor Sections Longer than 12 ft (3658 mm)

Connecting Components

Typical Connecting Components **(Figure 4)**

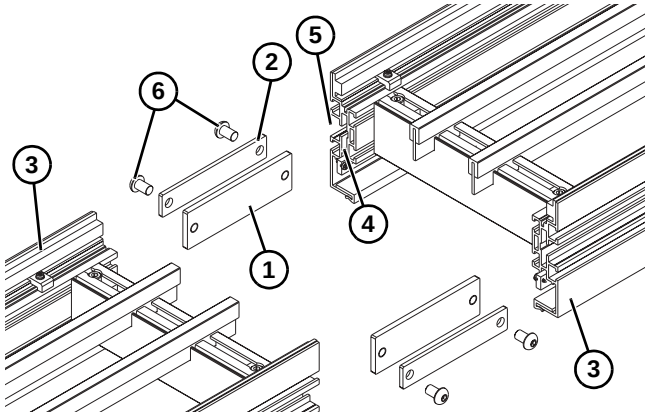


Figure 4

1	Clamp Plate
2	Cover Plate
3	Conveyor frames
4	Inner Channel
5	Outer Channel
6	Button Head Screw, M10-1.50 x 16 mm

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

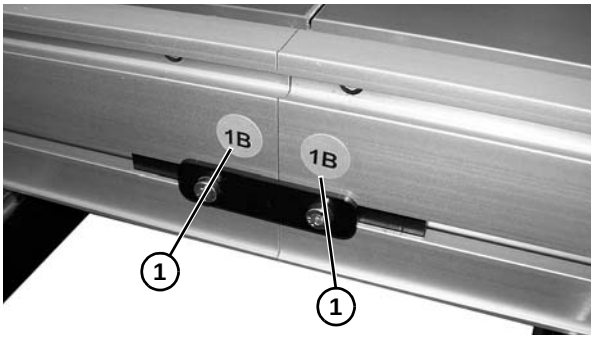


Figure 5

2. Loosely assembly each side clamp plate **(Figure 4, item 1)** and cover plate **(Figure 4, item 2)** with two button head screws **(Figure 4, item 6)**.
3. Line up conveyor sections, and install clamp plates **(Figure 4, item 1)** into inner channel **(Figure 4, item 4)** of conveyor section and cover plate **(Figure 4, item 2)** into outer channel **(Figure 4, item 4)**. Secure with two button head screws **(Figure 4, item 3)** on each side. Tighten screws to 84 in-lb (9 Nm).

Installation

All Conveyors

Curve Connecting Components

Typical Curve Connecting Components **(Figure 6)**

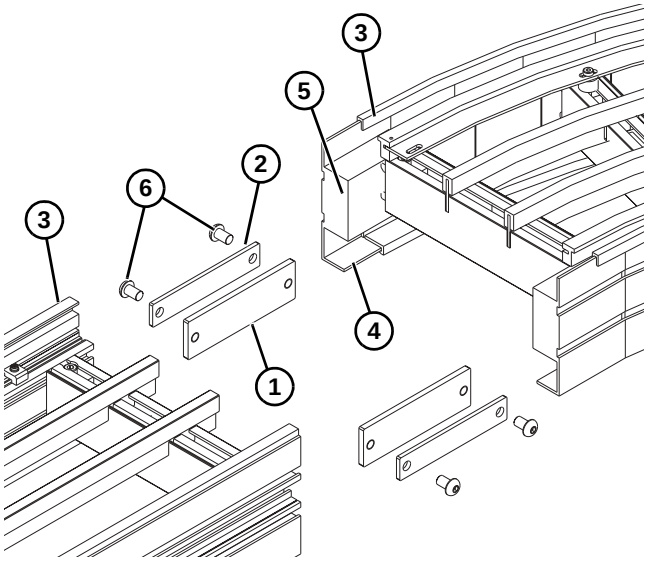


Figure 6

1	Clamp Plate
2	Cover Plate
3	Conveyor frames
4	Inner Channel
5	Outer Channel
6	Button Head Screw, M10-1.50 x 16 mm

1. Locate and arrange conveyor sections by section labels **(Figure 7, item 1)**.

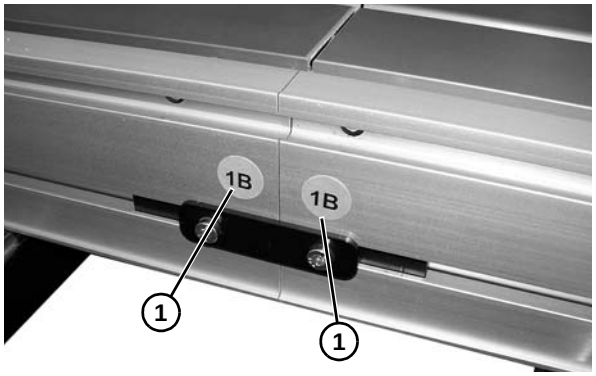


Figure 7

2. Install two clamp plates **(Figure 6, item 1)** into one conveyor section **(Figure 6, item 2)** by lining up two holes in clamp plate with two holes in conveyor frame. Install two M8x16 low head cap screws **(Figure 6, item 3)** to secure each clamp plate.
3. Join both conveyor sections, and secure with two M8x16 low head cap screws **(Figure 6, item 3)** on both sides. Tighten all cap screws to 84 in-lb (9 Nm).

Mounting Brackets for T-Slot Conveyors

Locate brackets. Exploded views shown in **(Figure 8)**.

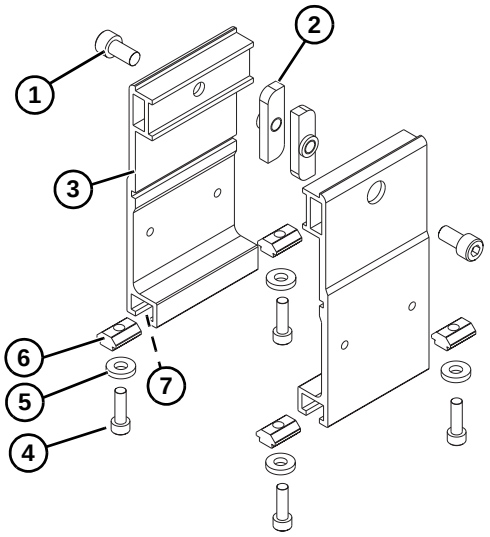


Figure 8

1. Loosen screws **(Figure 8, item 1)** or from nuts **(Figure 8, item 2)**, and leave on brackets **(Figure 8, item 3)**.
2. Remove screws **(Figure 8, item 4)** and washers **(Figure 8, item 5)** from T-bars **(Figure 8, item 6)**. Leave T-bars **(Figure 8, item 6)** in bracket slots **(Figure 8, item 7)**.
3. Insert nut **(Figure 9, item 1)** into conveyor side slots **(Figure 9, item 2)**. Fasten brackets **(Figure 9, item 3)** to conveyor with mounting screws **(Figure 9, item 4)**.

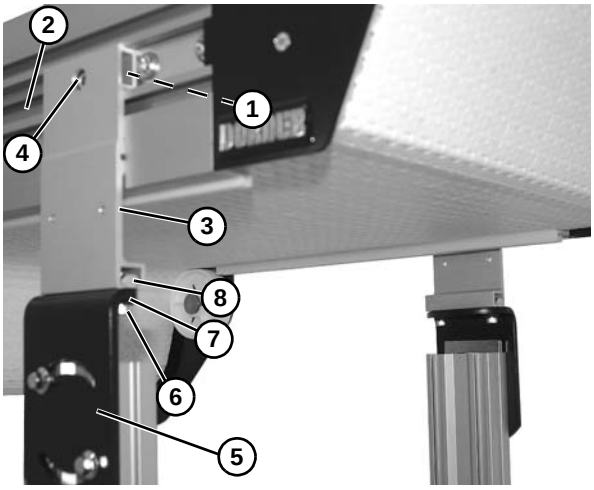


Figure 9

4. Fasten brackets to support stand bracket **(Figure 9, item 5)** with mounting screws **(Figure 9, item 6)**, washers **(Figure 9, item 7)** onto T-bar **(Figure 9, item 8)**.
5. Tighten screws **(Figure 9, item 4 & 6)** to 60 in-lb (7 Nm).

Brackets for SmartSlot Conveyors

Locate brackets. Exploded views shown in **(Figure 10)**.

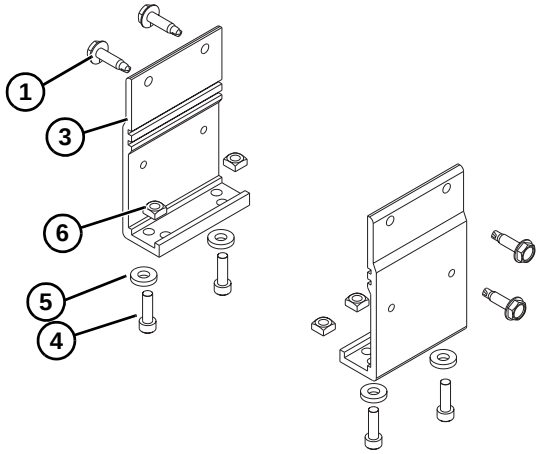


Figure 10

1. Remove screws **(Figure 10, item 1)** or washers **(Item 2)**, nuts **(Item 3)** a from brackets.

IMPORTANT
For proper methods of attachment to conveyor side rail see page 12.

2. Locate and retain self-drilling screws **(Figure 10, item 4**).

NOTE
For maximum support distance see page 6.

3. Measure an equal distance from end of head plate (on both sides of conveyor) and mark placement of mounting brackets **(Figure 11, item 1)**. Fasten mounting brackets to conveyor with mounting screws **(Figure 11, item 2)** following proper methods of attachment instructions on page 12.

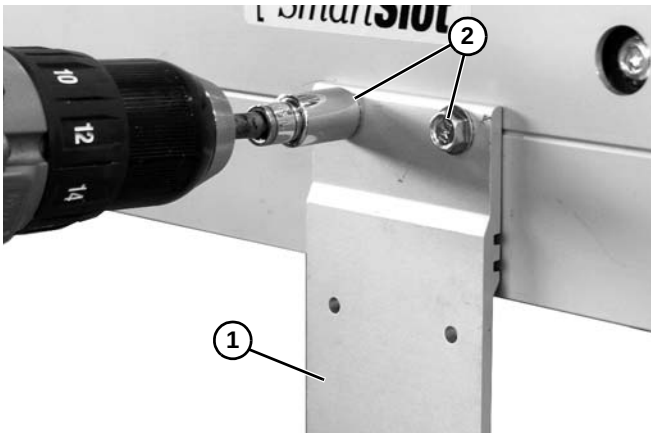


Figure 11

4. Fasten brackets **(Figure 12, item 1)** to support stand **(Figure 12, item 2)** with mounting screws **(Figure 12, item 3)**, washers **(Figure 12, item 4)** and nuts **(Figure 12, item 5)**.

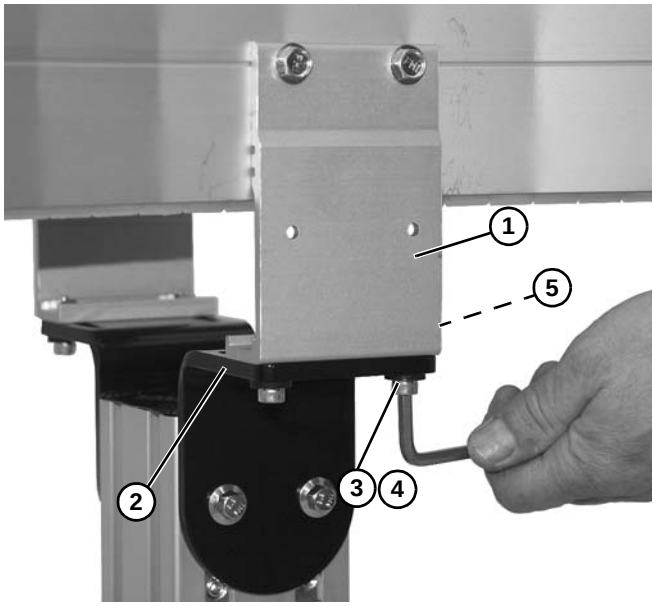


Figure 12

5. Tighten screws **(Figure 12, item 3)** to 60 in-lb (7 Nm).

Belt Installation

Typical Belt Components **(Figure 13)**.

1	Chain Belt
2	Belt Rod

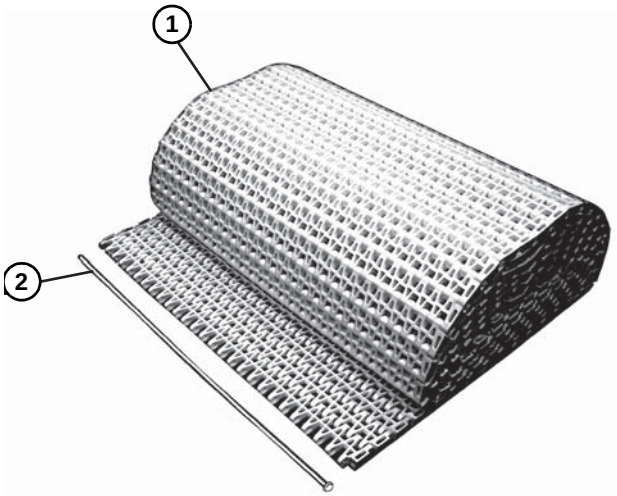


Figure 13

1. Position the belt on the conveyor frame.

2. Orient the belt direction such that the pin heads **(Figure 14, item 1)** are on the outside of the belt radius **(Figure 14, item 2)**. The straight portion on the pin **(Figure 14, item 3)** will be on the inside radius.

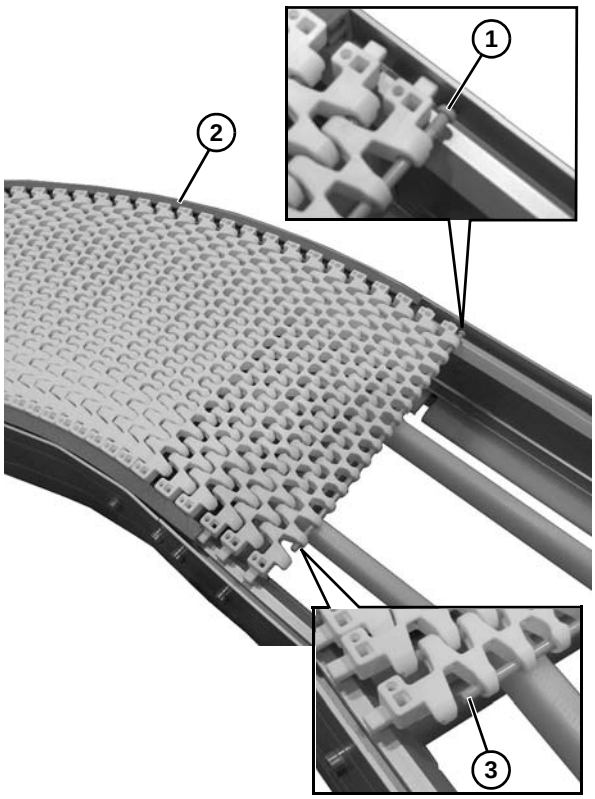


Figure 14

NOTE

*For High Strength Belts the slots on the edge of the belt **(Figure 15, item 1)** must be oriented with the belt flow as shown.*

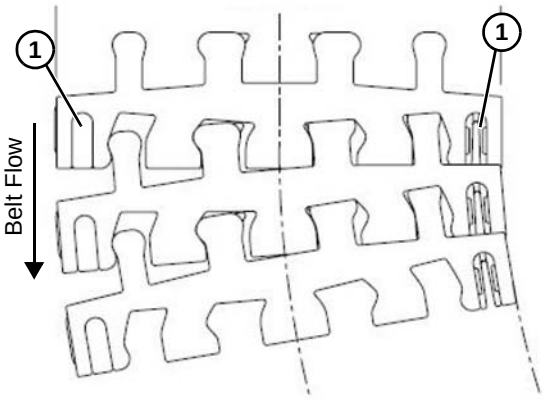


Figure 15

3. Wrap belt around idler tail **(Figure 16, item 1)**.

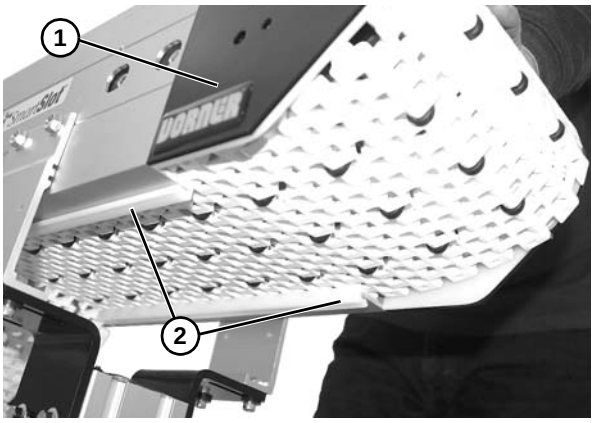


Figure 16

4. Install belt around lower frame section and above lower wear strips **(Figure 16, item 2)**.
5. Install both ends of belt **(Figure 17, item 1)** through wear strip **(Figure 17, item 2)**.

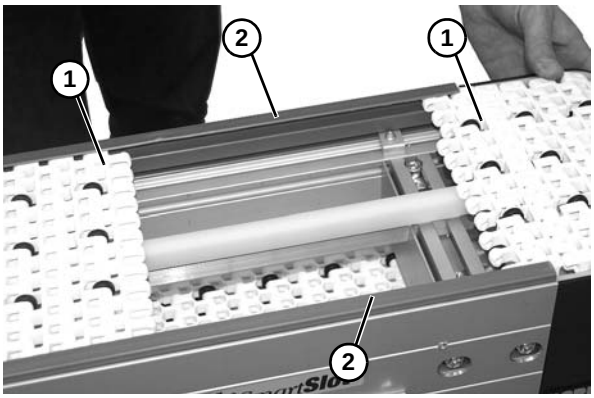
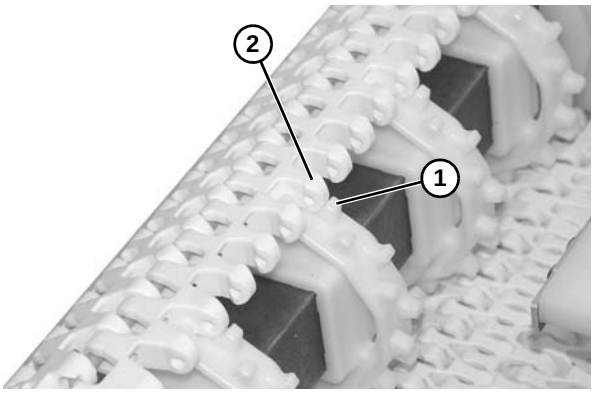


Figure 17

6. Standard Drive Tail: Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth **(Figure 18, item 1)** mating with rounded section **(Figure 18, item 2)** of belt.



Standard Drive Tail

Figure 18

7. Weighted Take-Up: Wrap belt **(Figure 19, item 1)** over pucks **(Figure 19, item 2)** and around bottom of weighted shaft **(Figure 19, item 3)**.

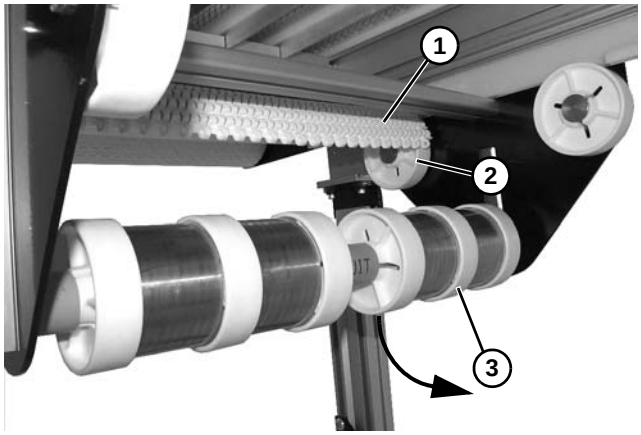


Figure 19

8. Weighted Take-Up: Continue wrapping belt **(Figure 20, item 1)** over top of pucks **(Figure 20, item 2)** and on top of J-Leg wear strips **(Figure 20, item 3)**.

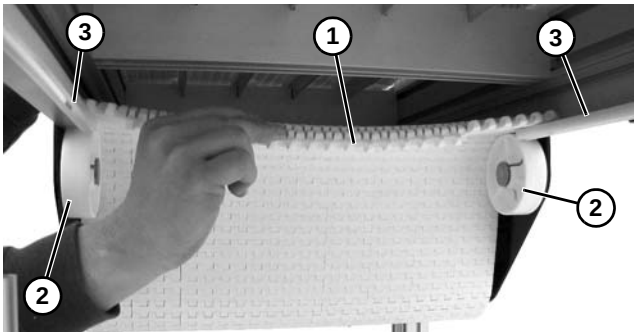


Figure 20

NOTE
For conveyors with weighted take-up units, push up on the weighted shaft to remove belt tension.

9. Bring the ends of the belt together **(Figure 21)**.

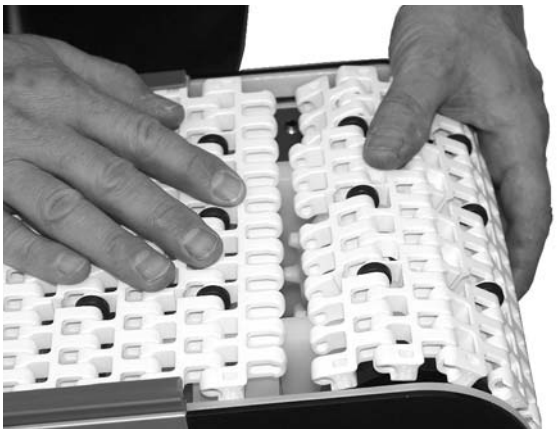


Figure 21

10. Insert the belt rod **(Figure 22, item 1)**.

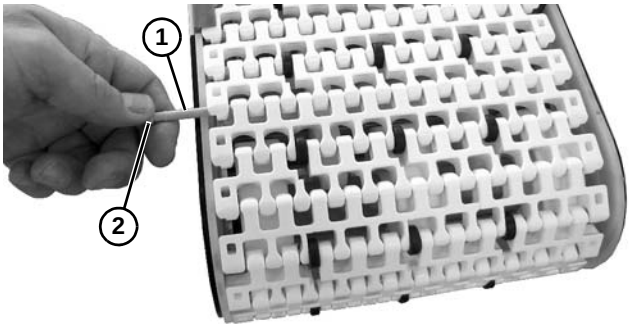


Figure 22

11. Push the belt rod in as far as possible.
12. Lightly tap the head **(Figure 22, item 2)** of the rod with a hammer until it snaps into position.

Proper Methods of Attaching Guiding to Side Rails (SmartSlot Frames Only)

⚠ WARNING

PUNCTURE HAZARD!

Installing self-drilling screws into the SmartSlot side rail requires substantial force.

Failure to properly support the conveyor while installing self-drilling screws may cause the operator or conveyor to slip, causing severe injury.

SUPPORT CONVEYOR FRAMES WHILE INSTALLING SELF-DRILLING SCREWS.

The 3200 SmartSlot side rail is designed for self-drilling attachment of brackets and accessories. This can be done in two methods: self-drilling screws or pre-drill for standard screws.

Self-Drilling Screws

All Dorner accessories are provided with 1/4-20 self-drilling screws.

1. Locate guide **(Figure 23, item 1)** and retaining clip **(Figure 23, item 2)** and hold to side rail. Hole should line up with notch **(Figure 23, item 3)** in side rail.

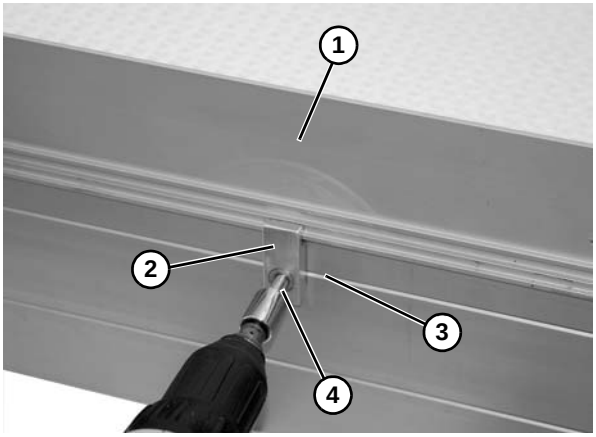


Figure 23

2. With a cordless drill or equivalent install self-drilling screw **(Figure 23, item 4)**. Use high speed setting to drill through side wall. Once the tap portion is started switch drill power to a lower speed. Do not fully tighten with drill.

3. Hand tighten the screws to secure **(Figure 24)**. Recommended torque is 150 in-lb (17 Nm).

Figure 24

Pre-Drill for Standard Screws

The SmartSlot side rail will also accept standard screws. M6-1.0 and 1/4-20 are acceptable. Strength grade 8 is recommended.

1. Locate guide **(Figure 25, item 1)** and retaining clip **(Figure 25, item 2)** and hold to side rail. Hole should line up with notch **(Figure 25, item 3)** in side rail. Mark the hole locations with a center punch **(Figure 25, item 4)** and remove the bracket.

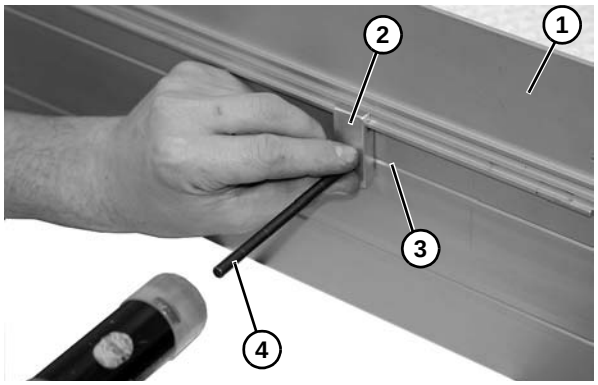


Figure 25

2. Drill the hole locations **(Figure 26, item 1)** with a 3/16" drill bit **(Figure 26, item 2)**.

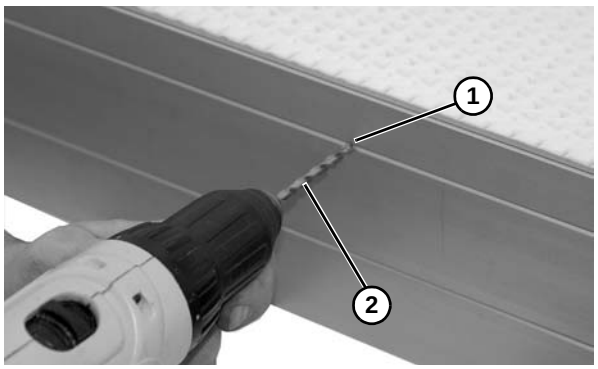


Figure 26

3. Position and hold bracket **(Figure 27, item 1)** to side rail. With a standard M6-1.0 or 1/4-20 screw, install screws **(Figure 27, item 2)** with cordless drill or equivalent. Do not fully tighten with drill.

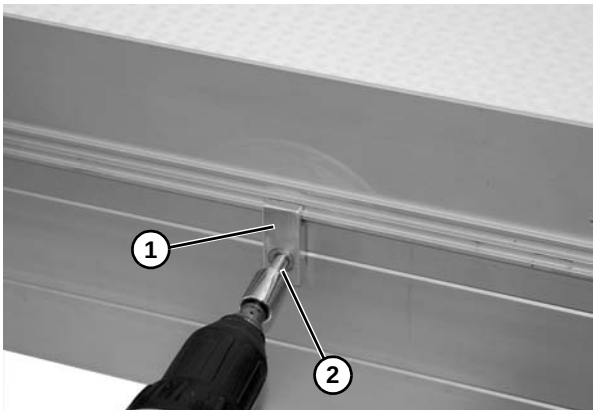


Figure 27

4. Hand tighten the screws to secure **(Figure 28)**. Recommended torque is 150 in-lb (17 Nm).

Figure 28

Guiding (SmartSlot Frames Only)

⚠ WARNING

PUNCTURE HAZARD!

Installing self-drilling screws into the SmartSlot side rail requires substantial force.

Failure to properly support the conveyor while installing self-drilling screws may cause the operator or conveyor to slip, causing severe injury.

SUPPORT CONVEYOR FRAMES WHILE INSTALLING SELF-DRILLING SCREWS.

Due to the SmartSlot construction ALL guiding must be located and installed by the end user. Take care in locating retaining clips prior to final installation.

1. Lay out retaining clip **(Figure 29, item 1)** locations. The end clips should be no greater than 12" from end of the conveyor. Hole should line up with notch **(Figure 29, item 2)** in side rail.

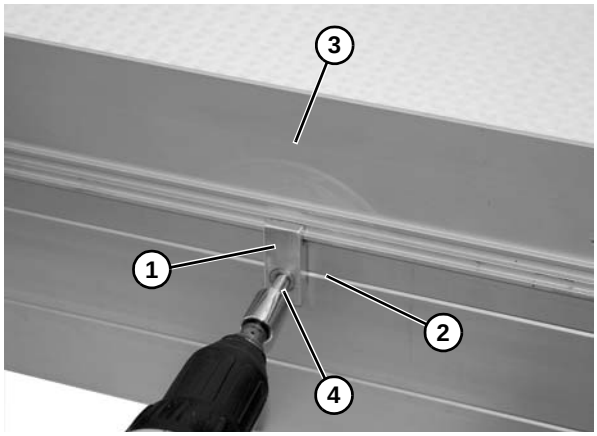


Figure 29

2. Hold guide **(Figure 29, item 3)** and retaining clip **(Figure 29, item 1)** to conveyor side rail. Install self-drilling screws **(Figure 29, item 4)** following the "Proper Methods of Attaching Guiding to Side Rails (SmartSlot Frames Only)" on page 12 procedure.

Guiding (T-Slot Frames Only)

1. Install guide block **(Figure 30, item 1)** with drop-in tee bar **(Figure 30, item 2)** in conveyor slot

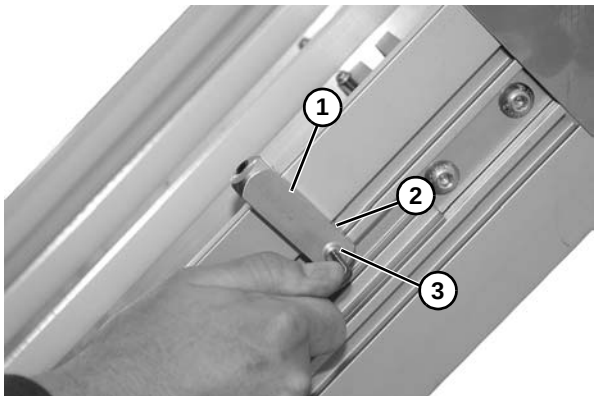


Figure 30

2. Tighten socket head screw **(Figure 30, item 3)** to secure position.

3. Install guide **(Figure 31, item 1)** onto top slot in guide block **(Figure 30, item 2)** and secure with set screw **(Figure 30, item 3)**.

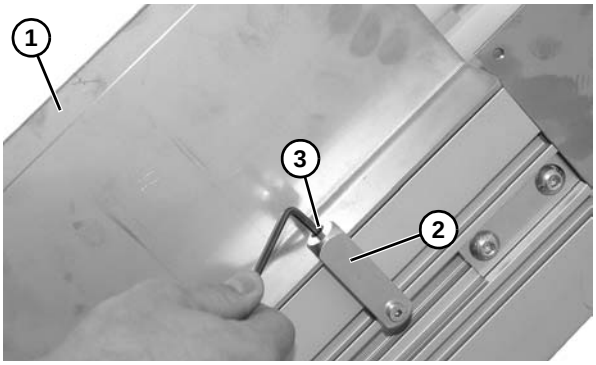


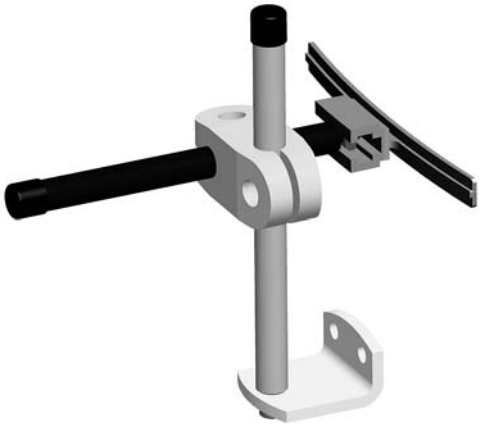
Figure 31

Fully Adjustable Guiding

Fully adjustable guiding may be shipped from the factory in various stages of assembly. If necessary, assemble the components in the manner shown in **(Figure 32)** or **(Figure 33)**.

For Straight Sections

Figure 32



For Curve Sections

Figure 33

1. Insert drop-in tee bars **(Figure 34, item 1)** into the conveyors t-slot **(Figure 34, item 2)**, if applicable, and attach fully adjustable brackets **(Figure 34, item 3)**. Evenly space along length of conveyor.

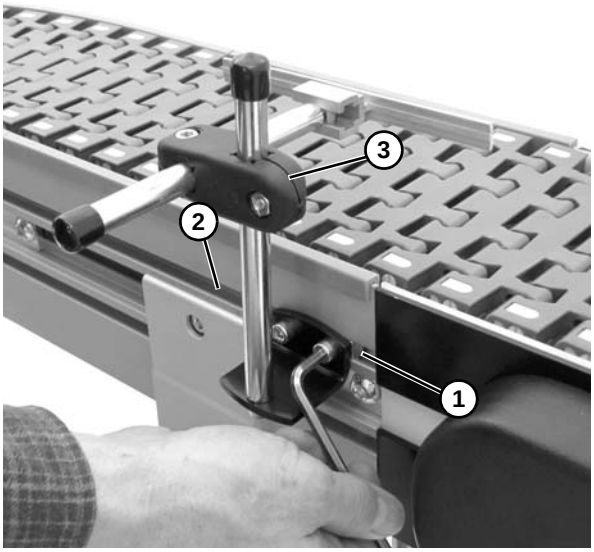


Figure 34

NOTE
For SmartSlot conveyors attach with self-drilling screws as shown in Proper Methods for Attaching Guiding to Side Rails (SmartSlot Frames Only) section on page 13.

2. Curve Sections: Install guiding **(Figure 35, item 1)** onto guide supports **(Figure 35, item 2)**.

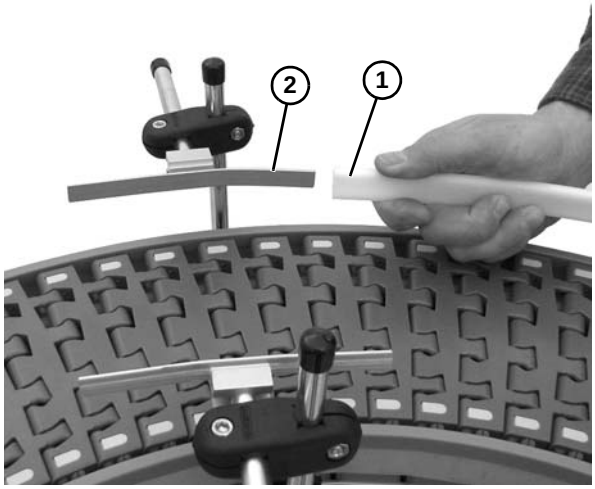


Figure 35

3. Straight Sections: Install extruded guide **(Figure 36, item 1)** onto end of mounting guide shaft **(Figure 36, item 2)**.

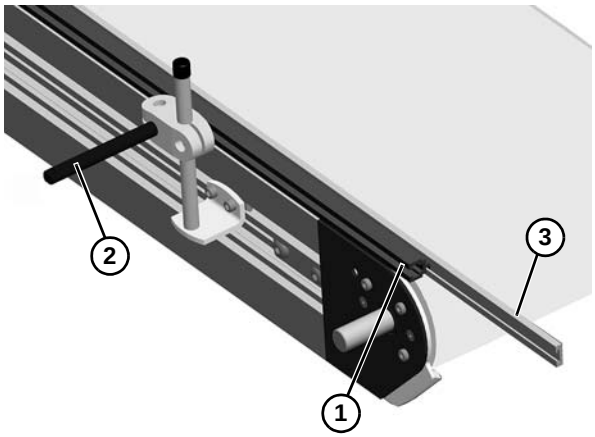


Figure 36

4. Install guiding **(Figure 36, item 3)** onto extruded guide **(Figure 36, item 1)**.

Drive Package Installation

NOTE

For detailed assembly instructions, refer to the appropriate Drive Packages Installation, Maintenance and Parts Manual.

1. Attach the motor **(Figure 37, item 1)** to the gear reducer **(Figure 37, item 2)**. (End Drive shown below.)

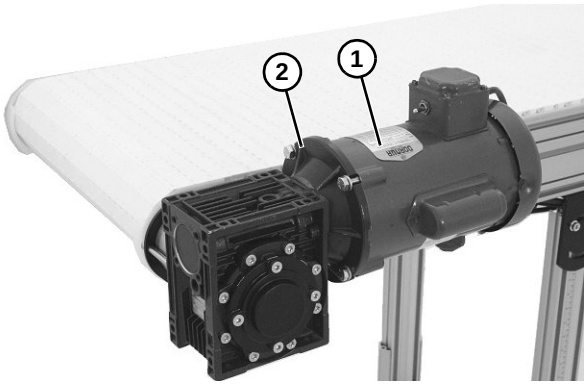


Figure 37

Preventive Maintenance and Adjustment

Required Tools

- 3 mm hex wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 19 mm combination wrench
- Adjustable wrench
- T20 Torx
- Punch and hammer (to remove belt rod)

Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 40 for recommendations.
- Replace any worn or damaged parts.

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

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

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

Skipping indicates:

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

Conveyor Belt Replacement

⚠ WARNING

SEVERE HAZARD!

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

Replacing a Section of Belt

1. Lift belt off of frame at idler end of conveyor past edge strip **(Figure 38, item 1)**.

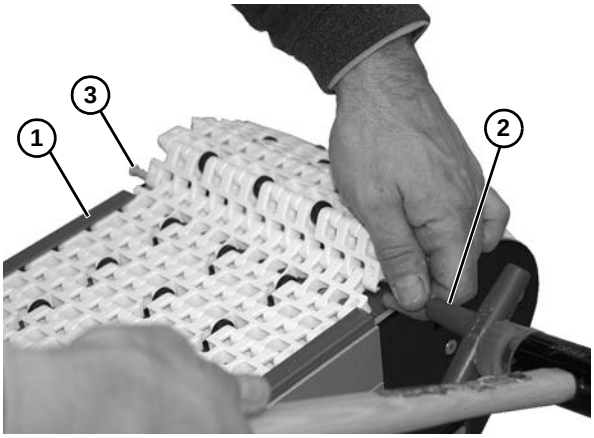


Figure 38

2. Use a punch **(Figure 38, item 2)** and hammer to push the belt rod **(Figure 38, item 3)** out by striking the rod end opposite the retaining head.

⚠ WARNING

SEVERE HAZARD!

If conveyor belt is damaged or worn, replace belt section.

3. Remove the belt rods on both sides of the section of belt being replaced.
4. Replace old section of belt.

⚠ CAUTION

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

Replacing the Entire Belt

1. Lift belt off of frame at idler end of conveyor past edge strip **(Figure 39, item 1)**.

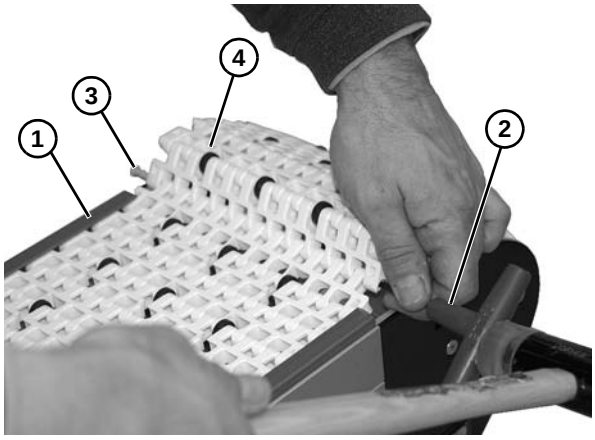


Figure 39

2. Use a punch **(Figure 39, item 2)** and hammer to push the belt rod **(Figure 39, item 3)** out by striking the rod end opposite the retaining head.
3. Slide the old belt **(Figure 39, item 4)** off the conveyor frame.
4. Replace the old belt with a new one. Refer to "Belt Installation" on page 9.

⚠ CAUTION

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

Conveyor Belt Tensioning

⚠ WARNING

SEVERE HAZARD!

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

NOTE

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

1. Remove one or more belt links to take up tension. Refer to "Replacing a Section of Belt" on page 16.

Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips **(Figure 40)**

1	Wear Strips, Top Mid Clip-On
2	Wear Strips, Outer Top
3	Wear Strips, J-Leg
4	Wear Strips, Lower Vertical

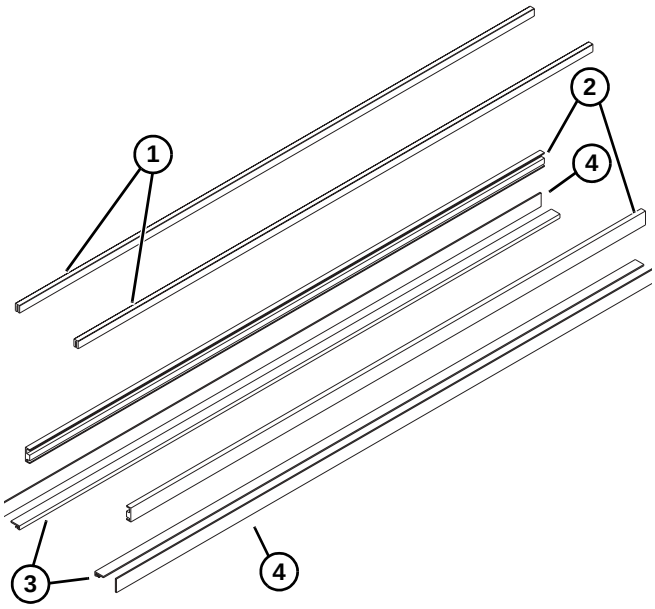


Figure 40

Removal of Top Mid Clip-On Wear Strips

1. Remove belt. See "Conveyor Belt Replacement" on page 16.
2. Remove top clip-on wear strips **(Figure 41, item 1)**.

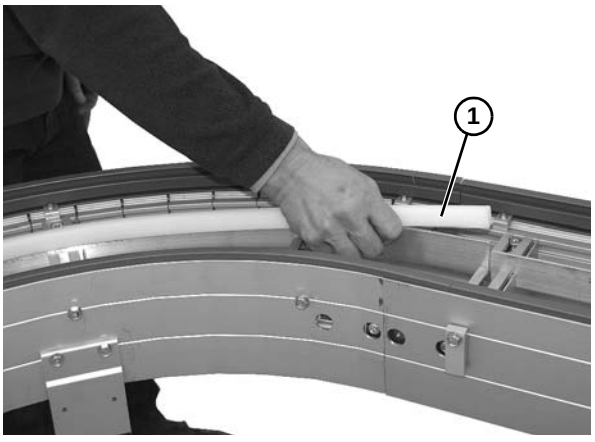


Figure 41

Removal of Outer Top Wear Strips

1. Using T20 torx tool, remove torx screws **(Figure 42, item 1)** and clamps **(Figure 42, item 2)** holding outer top wear strip **(Figure 42, item 3)** to frame.

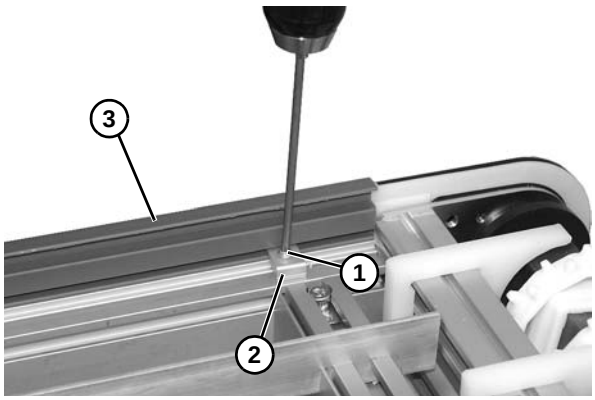


Figure 42

2. Remove outer top wear strip **(Figure 42, item 3)** from frame assembly.

Removal of J-Leg Wear Strips

1. Slide J-leg wear strips **(Figure 43, item 1)** from lower frame **(Figure 43, item 2)**.

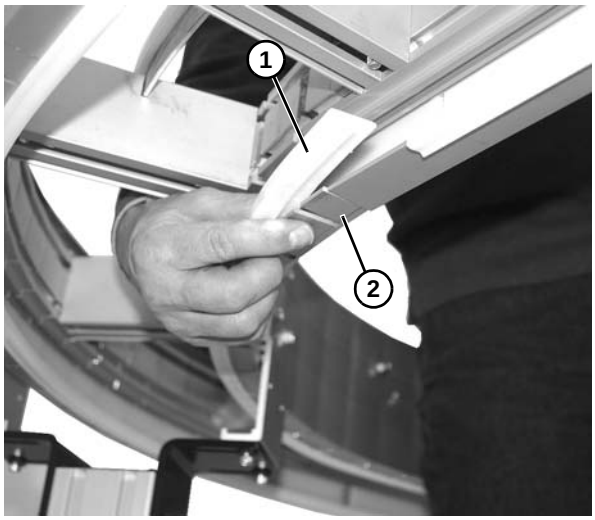


Figure 43

Removal of Lower Vertical Wear Strips

1. Slide lower vertical wear strips **(Figure 44, item 1)** from frame assembly.

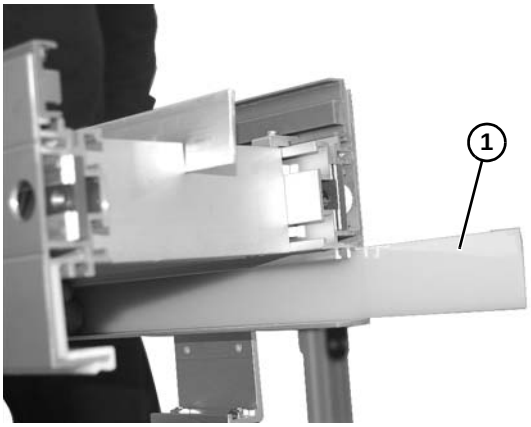


Figure 44

Wear Strip Installation

1. Install outer top wear strips **(Figure 45, item 1)** so that end of wear strip is flush with tail assembly **(Figure 45, item 1)**.

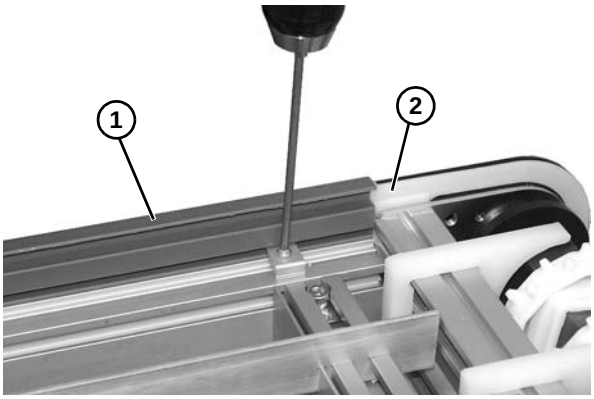


Figure 45

2. Slide lower vertical wear strips **(Figure 46, item 1)** into frame assembly from end of frame.

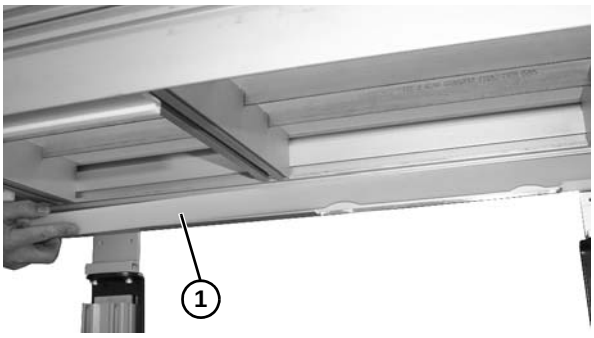


Figure 46

Install remaining components reverse of removal.

Tail Component Removal

WARNING

SEVERE HAZARD!

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

Remove conveyor belt to access spindle(s). See "Replacing the Entire Belt" on page 17. Remove the desired spindle following the corresponding instructions below:

- **A** – Drive Tail Component Removal
- **B** – Drive Roller Transfer Tail Component Removal
- **C** – Idler Tail Component Removal
- **D** – Idler Roller Transfer Tail Component Removal

A – Drive Tail Component Removal

WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Remove the two socket head screws **(Figure 47, item 1)**. Repeat on opposite side.

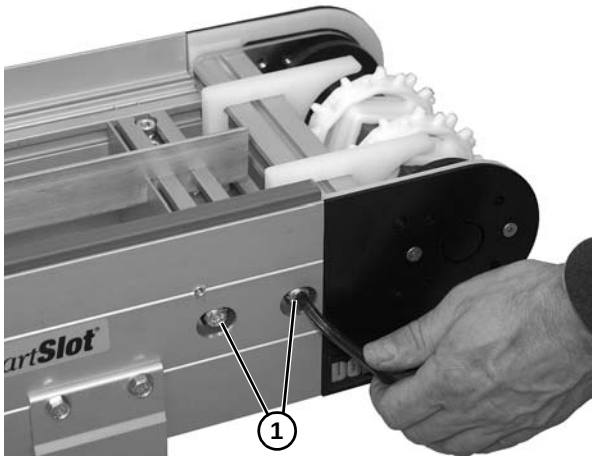


Figure 47

3. Remove the drive tail assembly **(Figure 48, item 1)** from the frame **(Figure 48, item 2)**.

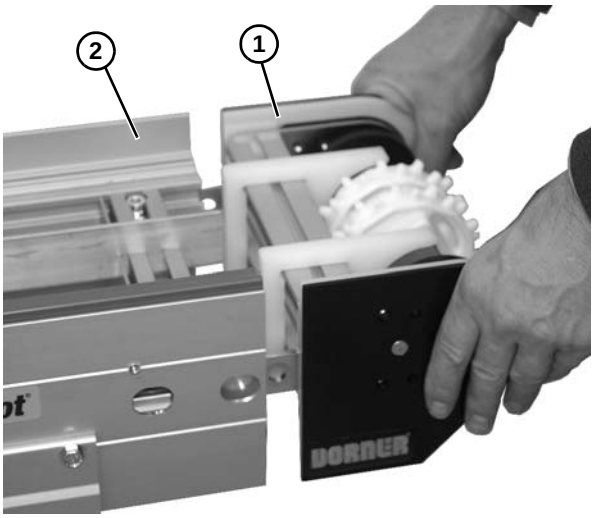


Figure 48

4. Remove the two flat head screws **(Figure 49, item 1)** from cover **(Figure 49, item 2)**.

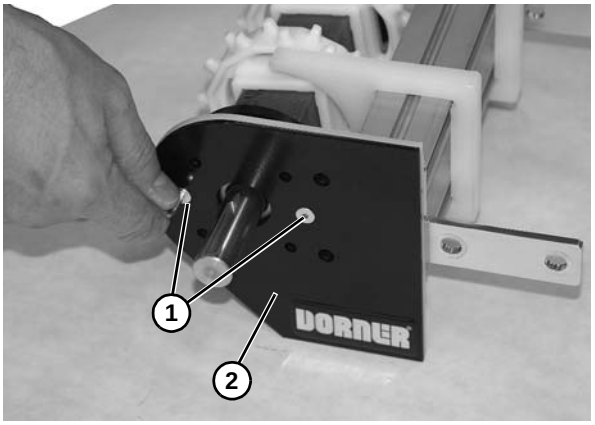


Figure 49

5. Remove cover **(Figure 50, item 1).**

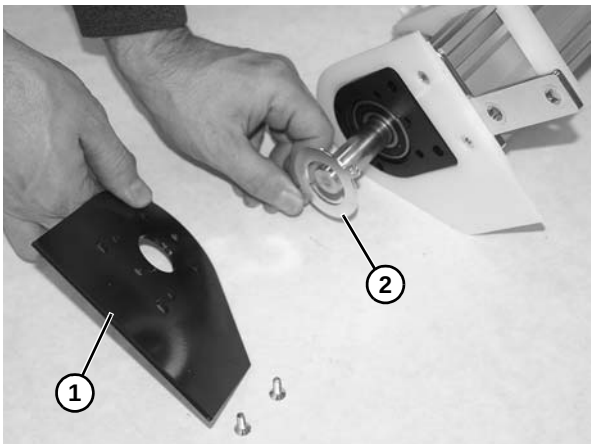


Figure 50

6. Remove bearing stop plate **(Figure 50, item 2)**.

7. Remove two socket head screws **(Figure 51, item 1)** from drive filler plate **(Figure 51, item 2)**.

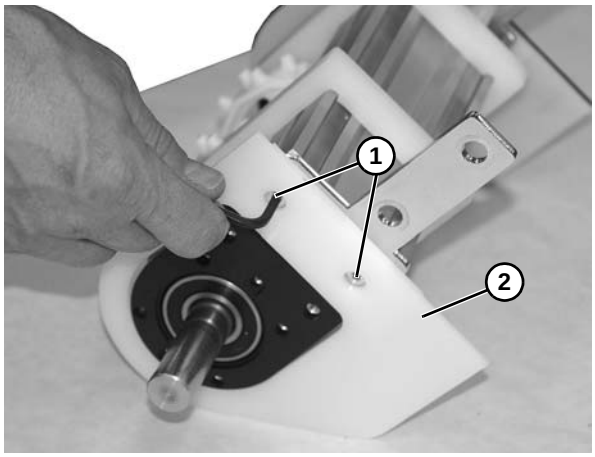


Figure 51

8. Remove drive filler plate **(Figure 52, item 1)** and bearing housing **(Figure 52, item 2)** from drive backing plate **(Figure 52, item 3)**.

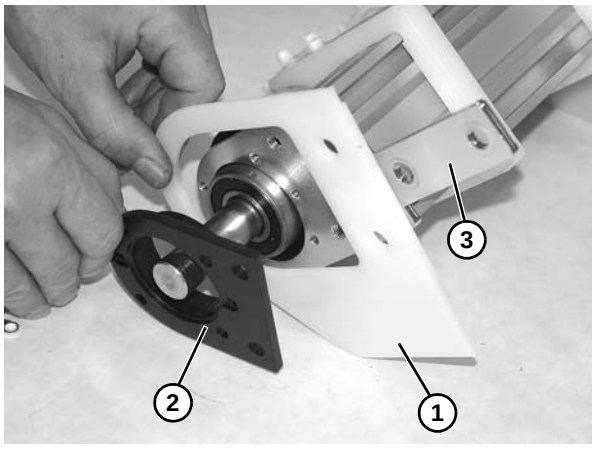


Figure 52

9. Remove two socket head screws **(Figure 53, item 1)** from drive backing plate **(Figure 53, item 2)**.

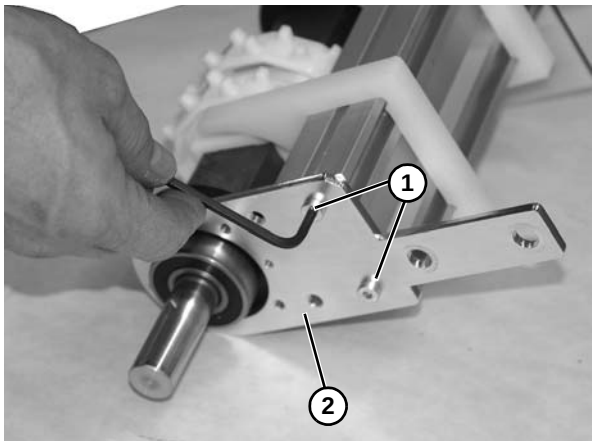


Figure 53

10. Remove drive backing plate **(Figure 54, item 1)** from assembly.

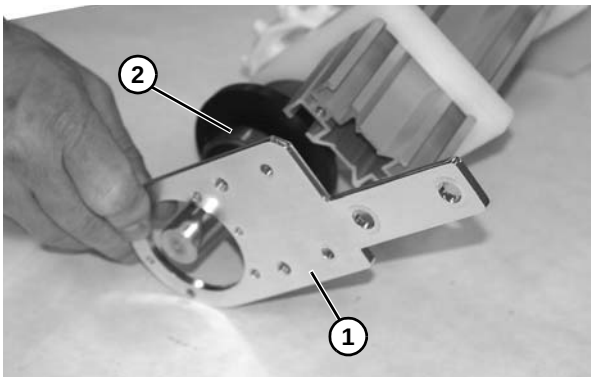


Figure 54

11. Remove drive spindle assembly **(Figure 54, item 2)** from assembly.

IMPORTANT

You must replace with a new bearing after it is removed from shaft.

12. Using puller **(Figure 55, item 1)**, as shown, remove bearing **(Figure 55, item 2)** from shaft assembly. Repeat on opposite side, if needed.

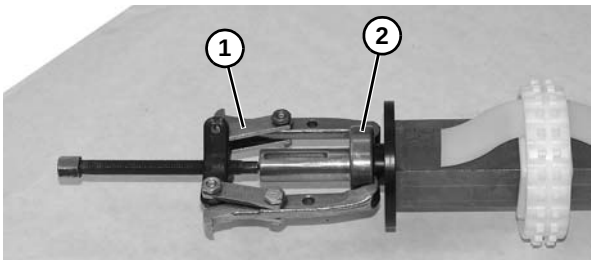


Figure 55

13. Remove washer **(Figure 56, item 1)**, as shown, making note of flange area **(Figure 56, item 2)** of washer. Repeat on opposite side, if needed. (Note: Not applicable for High Strength Belts.)

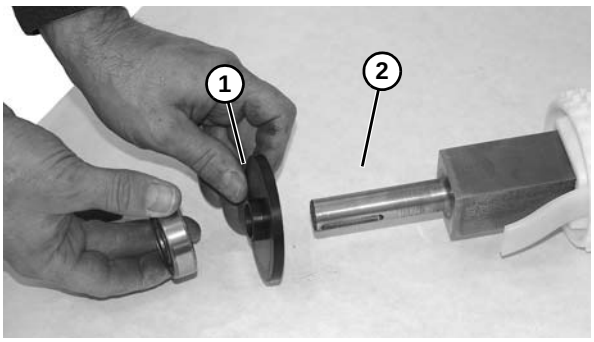


Figure 56

14. Slide entire sprocket assembly slightly outward, and remove the first sprocket **(Figure 57, item 1)** off the drive spindle **(Figure 57, item 2)** and alignment bar **(Figure 57, item 3)**. Inspect and replace if worn.

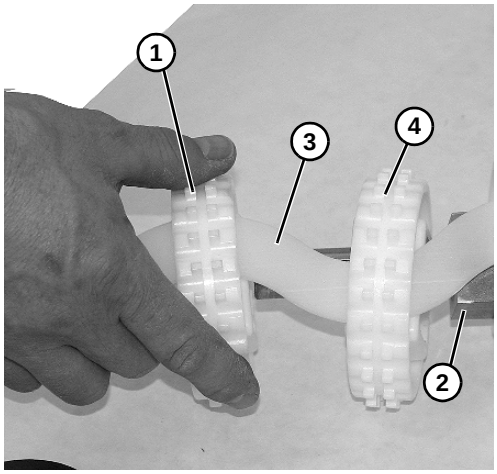


Figure 57

15. Remove remaining sprockets **(Figure 57, item 4)** off the alignment bar as you slide entire assembly off the drive spindle.
16. To assemble sprockets onto drive spindle, slide one sprocket onto alignment bar and slide assembly onto drive spindle.
17. Install second sprocket and subsequent sprockets **(Figure 57, item 4)** one by one, while sliding entire assembly onto alignment bar **(Figure 57, item 3)** and spindle **(Figure 57, item 2)**, making certain each sprocket is locked into retaining tab **(Figure 58, item 1)** on alignment bar **(Figure 58, item 2)**. (Note: Not applicable for High Strength Belts.)

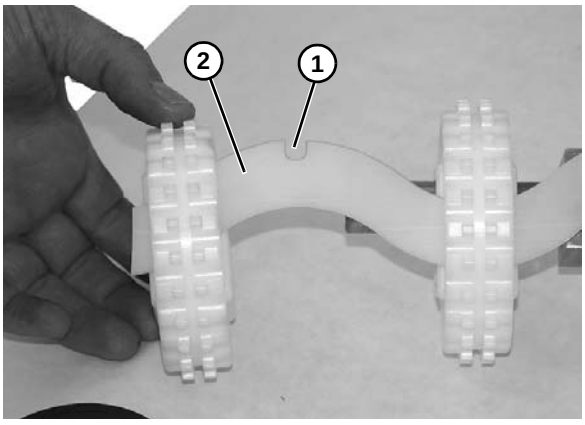


Figure 58

18. Press new bearing onto drive pulley.
19. Remove gap filler plates **(Figure 59, item 1)** from crossmember **(Figure 59, item 2)**.

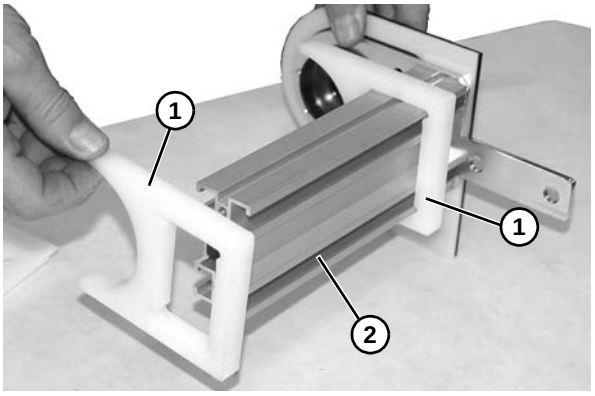


Figure 59

20. To assemble sprockets onto drive spindle, slide all sprockets spaced evenly onto drive spindle.
21. Assemble components reverse of removal.

NOTE

When reinstalling the drive spindle tail assembly, the drive tail assembly ***(Figure 60, item 1)*** *should mate flush with the conveyor frame* ***(Figure 60, item 2)****.*

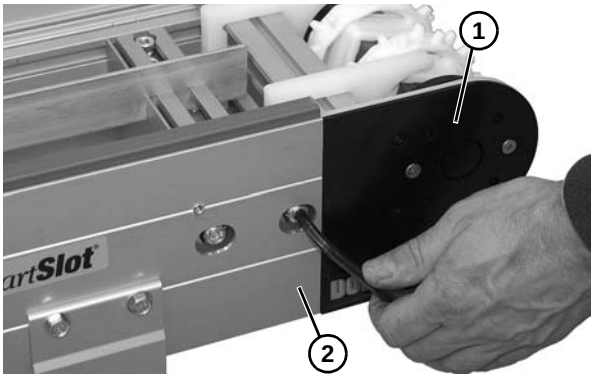


Figure 60

B – Drive Roller Transfer Tail Component Removal

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Loosen two socket head screws **(Figure 61, item 1)** on each side of drive roller transfer tail assembly **(Figure 61, item 2)**.

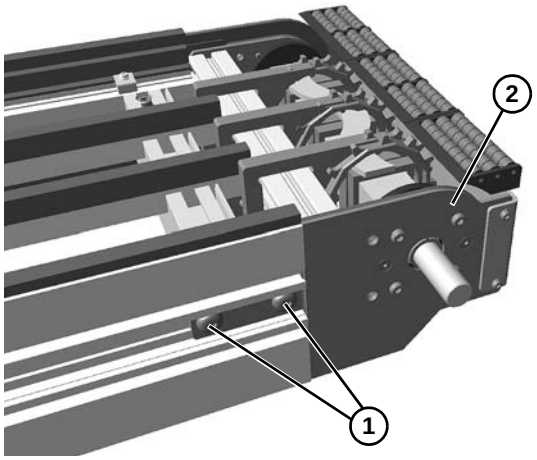


Figure 61

3. Remove the drive tail assembly **(Figure 62, item 1)** from the frame **(Figure 62, item 2)**.

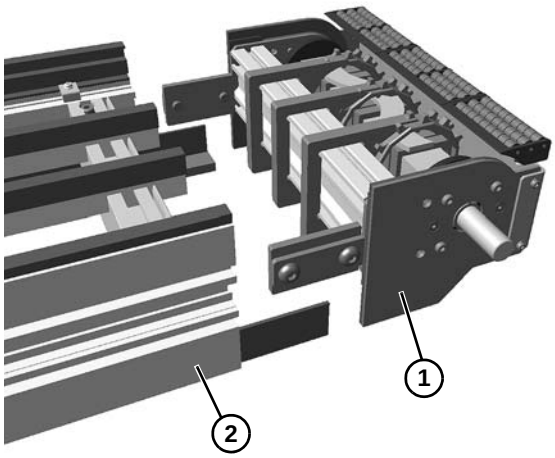


Figure 62

4. Remove two socket head screws **(Figure 63, item 1)** on each side of drive tail assembly **(Figure 63, item 2)**.

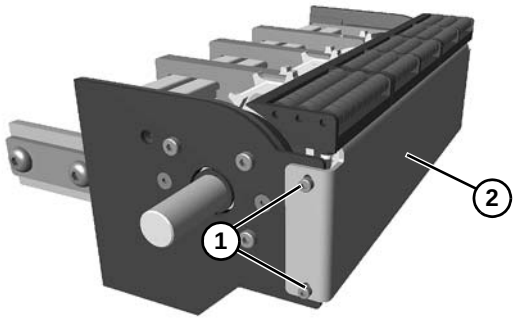


Figure 63

5. Remove the transfer roller and transfer bracket assembly **(Figure 64, item 1)** from the drive tail assembly **(Figure 64, item 2)**.

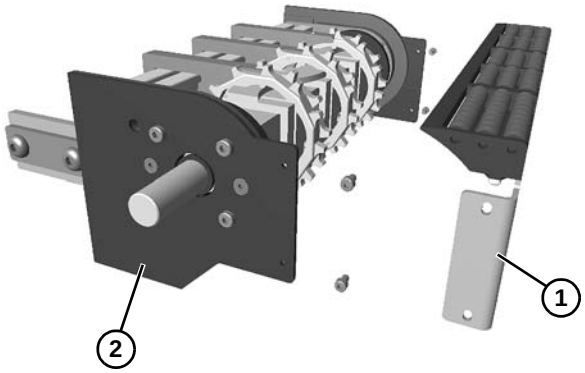


Figure 64

6. If necessary, remove two nuts **(Figure 65, item 1)** securing each transfer roller **(Figure 65, item 2)** on the drive tail assembly bracket **(Figure 65, item 3)**. Replace and install as needed.

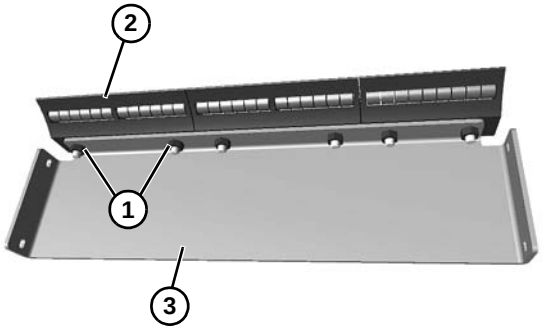


Figure 65

7. Remove four socket head screws **(Figure 66, item 1)** on each side of drive tail assembly **(Figure 66, item 2)**.

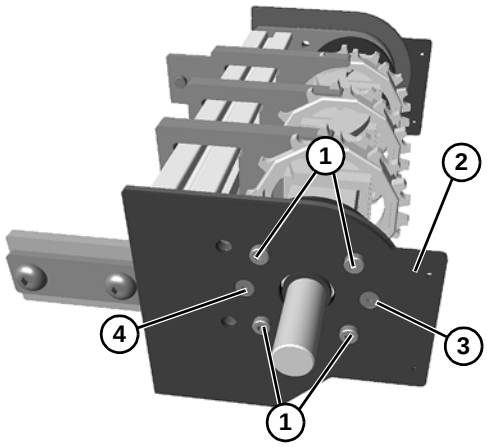


Figure 66

8. Remove two flat head screws **(Figure 66, item 3)** on each side of drive tail assembly **(Figure 66, item 2)**.
9. Remove cover plate **(Figure 67, item 1)**, filler plate **(Figure 67, item 2)**, and bearing stop plate **(Figure 67, item 3)** off of drive tail assembly.

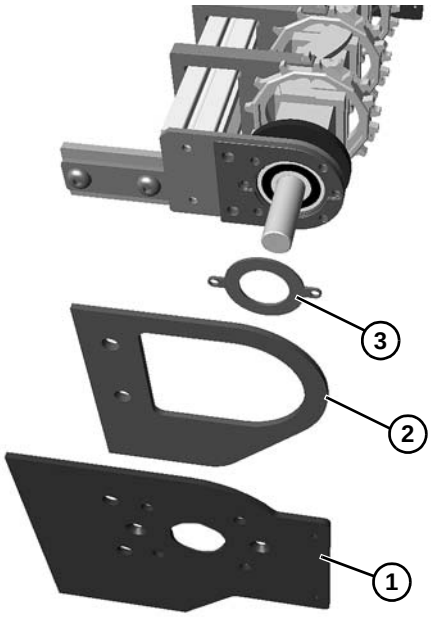


Figure 67

10. Remove bearing housing **(Figure 68, item 1)** and backing plate **(Figure 68, item 2)** off of drive tail assembly.

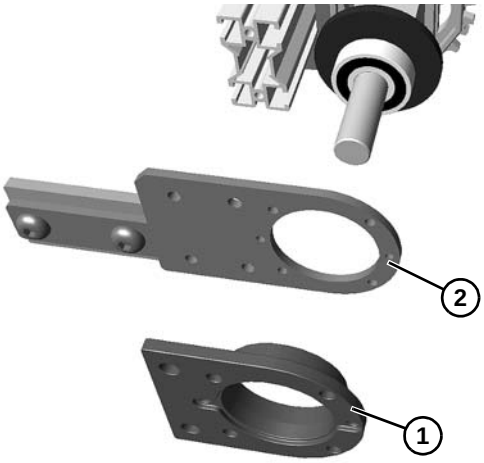


Figure 68

11. Remove shaft assembly **(Figure 69, item 1)**.

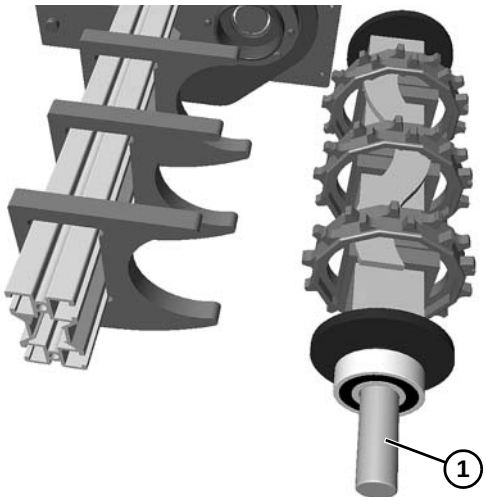


Figure 69

IMPORTANT

You must replace with a new bearing after it is removed from shaft.

12. Using puller **(Figure 70, item 1)**, as shown, remove bearing **(Figure 70, item 2)** from shaft assembly. Repeat on opposite side, if needed.

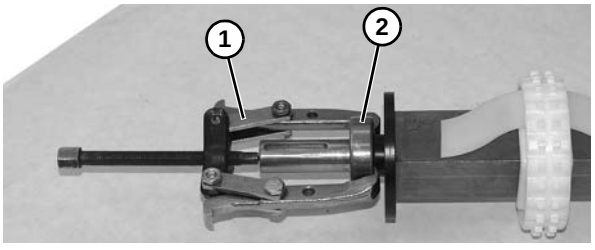


Figure 70

13. Remove washer **(Figure 71, item 1)**, as shown, making note of flange area **(Figure 71, item 2)** of washer. Repeat on opposite side, if needed.

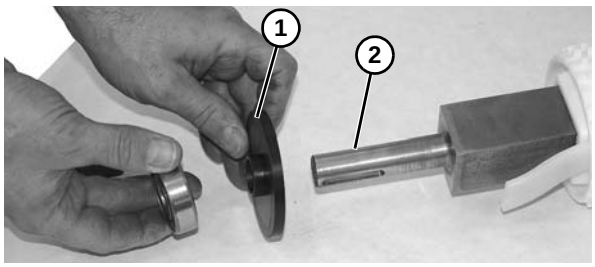


Figure 71

14. Slide entire sprocket assembly slightly outward, and remove the first sprocket **(Figure 72, item 1)** off the drive spindle **(Figure 72, item 2)** and alignment bar **(Figure 72, item 3)**. Inspect and replace if worn.

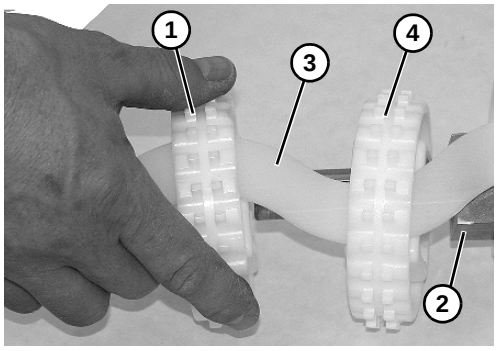


Figure 72

15. Remove remaining sprockets **(Figure 72, item 4)** off the alignment bar as you slide entire assembly off the drive spindle.
16. To assemble sprockets onto drive spindle, slide one sprocket onto alignment bar and slide assembly onto drive spindle.
17. Install second sprocket and subsequent sprockets **(Figure 72, item 4)** one by one, while sliding entire assembly onto alignment bar **(Figure 72, item 3)** and spindle **(Figure 72, item 2)**, making certain each sprocket is locked into retaining tab cut out **(Figure 73, item 1)** on alignment bar **(Figure 73, item 2)**.

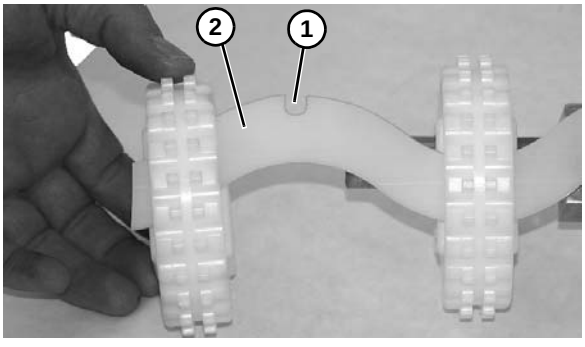


Figure 73

18. Press new bearing onto drive pulley.
19. Remove gap filler plates **(Figure 74, item 1)** from crossmember **(Figure 74, item 2)**.

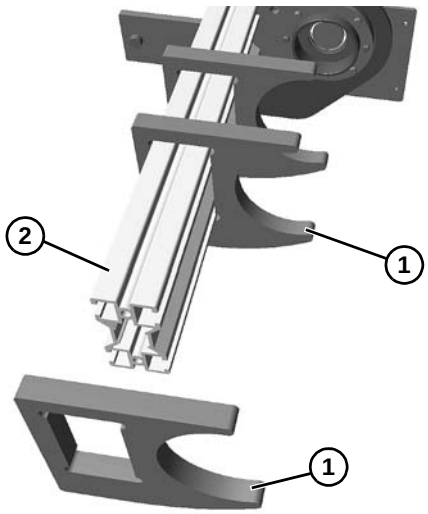


Figure 74

20. To assemble sprockets onto drive spindle, slide all sprockets spaced evenly onto drive spindle.
21. Assemble components reverse of removal.

NOTE

When reinstalling the drive spindle tail assembly, the drive tail assembly ***(Figure 75, item 1)*** *should mate flush with the conveyor frame* ***(Figure 75, item 2)****.*

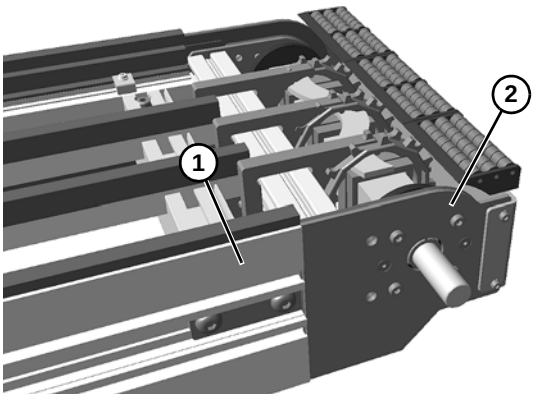


Figure 75

C – Idler Tail Component Removal

1. Be sure the conveyor is supported.
2. Remove the two socket head screws **(Figure 76, item 1)**. Repeat on opposite side.

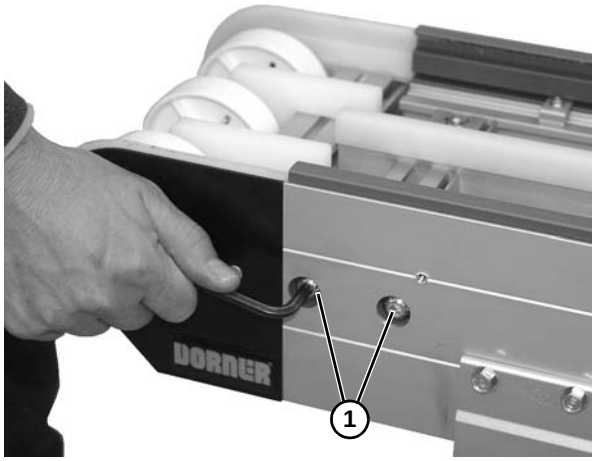


Figure 76

3. Remove idler assembly **(Figure 77, item 1)** from conveyor **(Figure 77, item 2).**

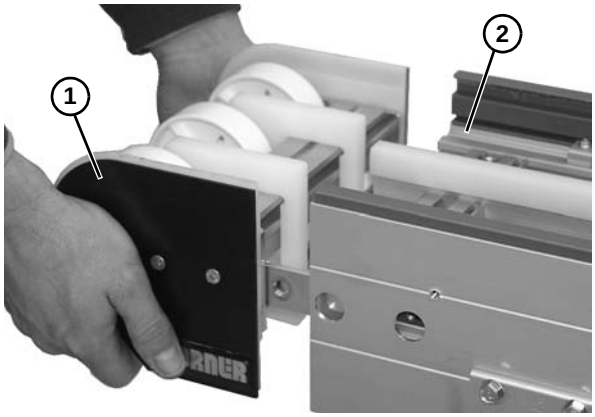


Figure 77

4. Remove two flat head screws **(Figure 78, item 1)** and cover plate **(Figure 78, item 2)**. Repeat procedure on opposite side.

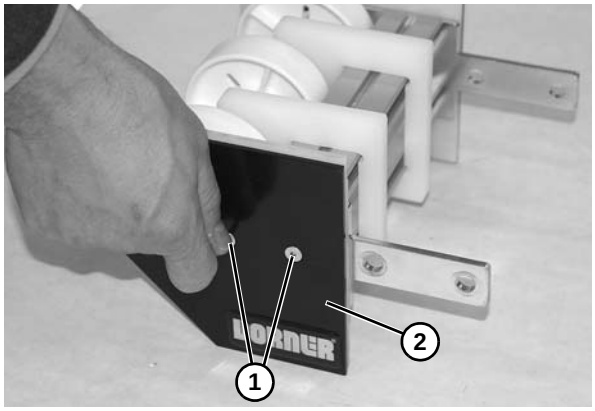


Figure 78

5. Remove cover plate **(Figure 79, item 1)** and filler plate **(Figure 79, item 2)**. Repeat procedure on opposite side.

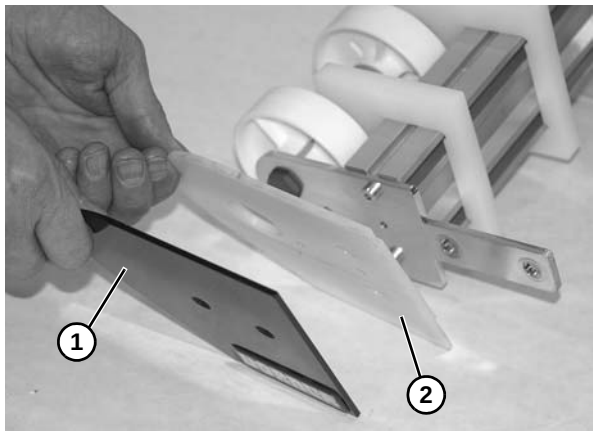


Figure 79

6. Remove two socket head screws **(Figure 80, item 1)** and idler backing plate **(Figure 80, item 2)**.

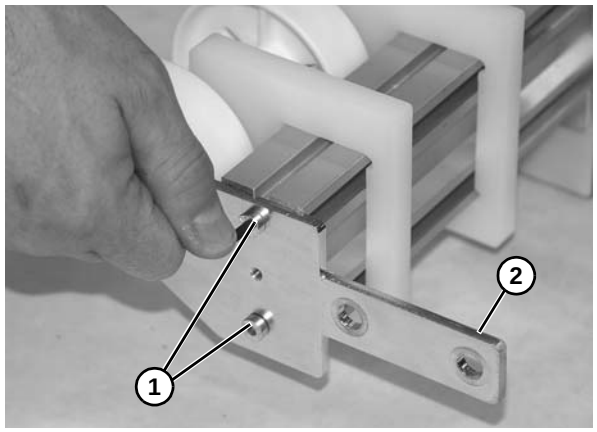


Figure 80

7. Remove idler backing plate **(Figure 81, item 1)** from assembly.

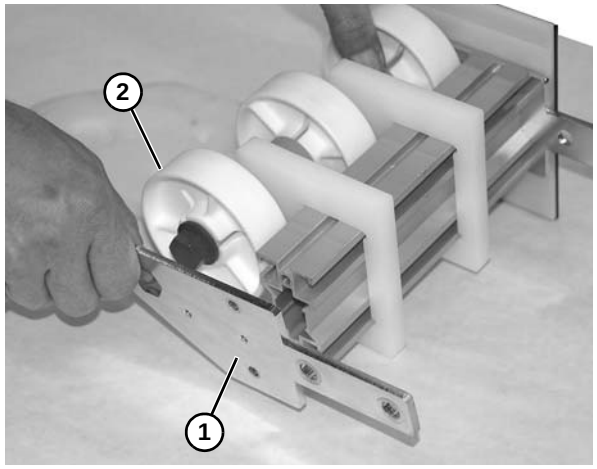


Figure 81

8. Remove idler spindle **(Figure 81, item 2)** from assembly.

9. Use wrenches to remove both bolts **(Figure 82, item 1)** from each side of roller assembly.

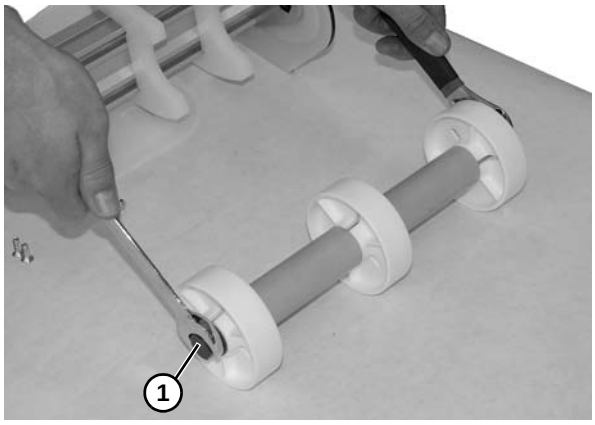


Figure 82

10. Remove idler pucks **(Figure 83, item 1)** and tube spacers **(Figure 83, item 2),** as needed, from each side of assembly.

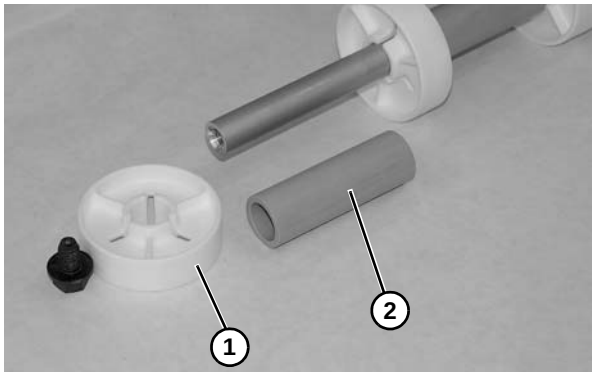


Figure 83

11. Remove gap filler plates **(Figure 84, item 1)** from crossmember **(Figure 84, item 2)**.

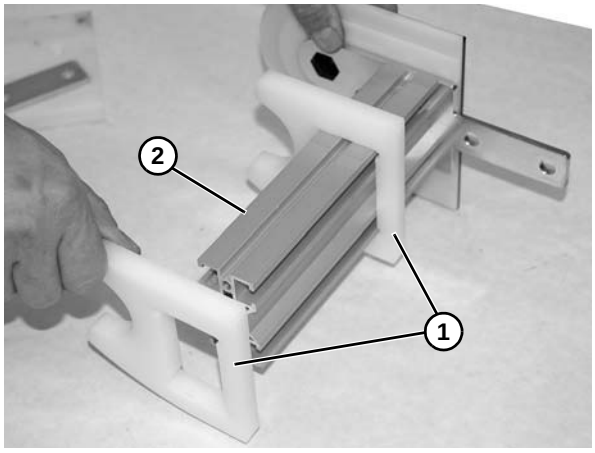


Figure 84

12. Install components reverse of removal, making sure idler pucks **(Figure 85, item 1)** and gap filler plates **(Figure 85, item 2)** are evenly spaced on assembly.

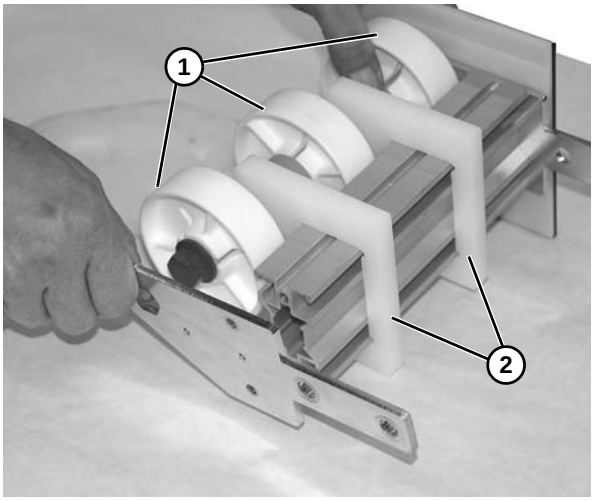


Figure 85

13. Assemble components reverse of removal.

NOTE

*When reinstalling the idler spindle assembly, the idler tail assembly **(Figure 86, item 1)** should mate flush with the conveyor frame **(Figure 86, item 2)**.*

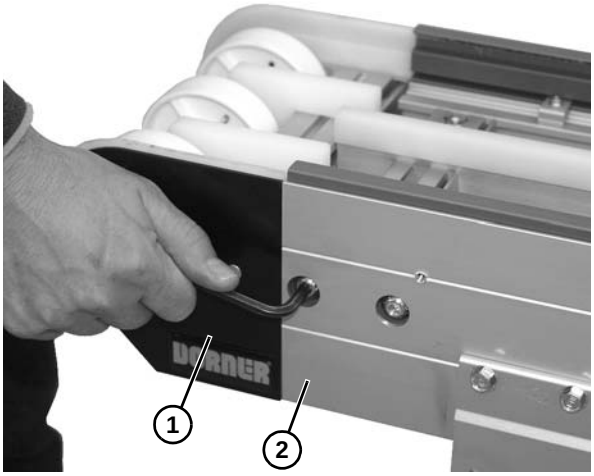


Figure 86

D – Idler Roller Transfer Tail Component Removal

1. Be sure the conveyor is supported.
2. Loosen two socket head screws **(Figure 87, item 1)** on each side of idler roller transfer tail assembly **(Figure 87, item 2)**.

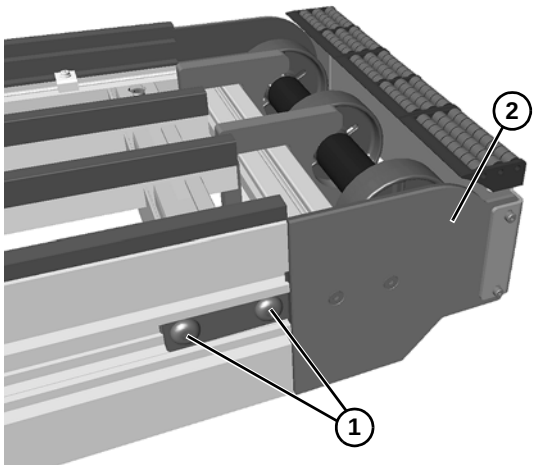


Figure 87

3. Remove the idler tail assembly **(Figure 88, item 1)** from the frame **(Figure 88, item 2)**.

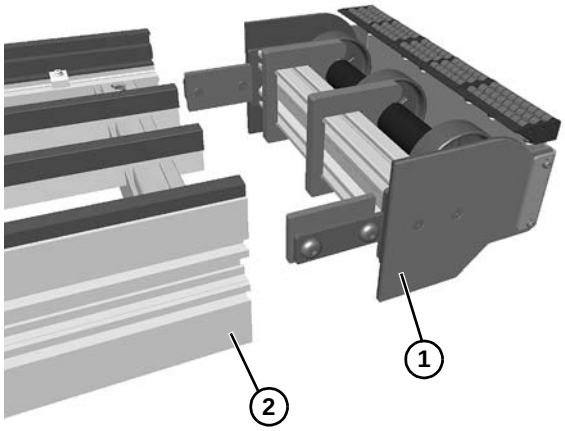


Figure 88

4. Remove two socket head screws **(Figure 89, item 1)** on each side of idler tail assembly **(Figure 89, item 2)**.

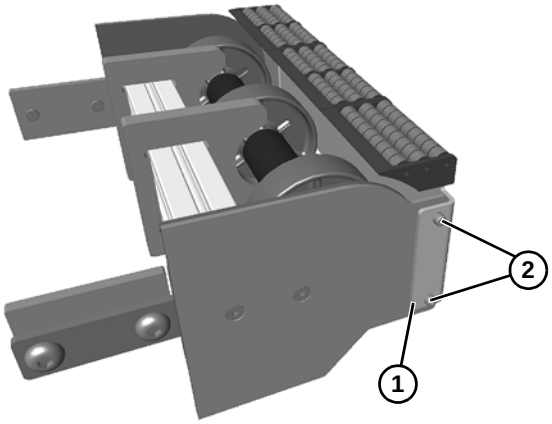


Figure 89

5. Remove the transfer roller and transfer bracket assembly **(Figure 90, item 1)** from the idler tail assembly **(Figure 90, item 2)**.

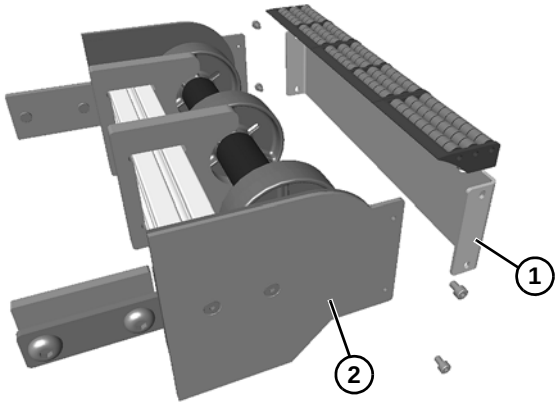


Figure 90

6. If necessary, remove two nuts **(Figure 91, item 1)** securing each transfer roller **(Figure 91, item 2)** on the idler tail assembly bracket **(Figure 91, item 3)**. Replace and install as needed.

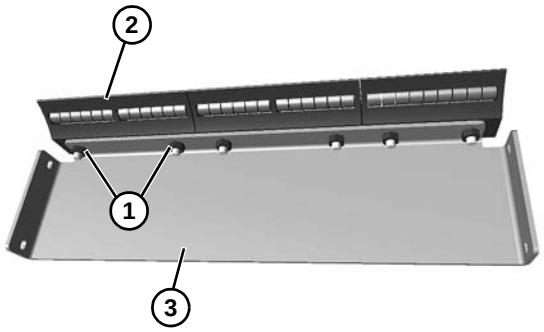


Figure 91

7. Remove two flat head screws **(Figure 92, item 1)** on cover plate **(Figure 92, item 2)** on each side of idler tail assembly.

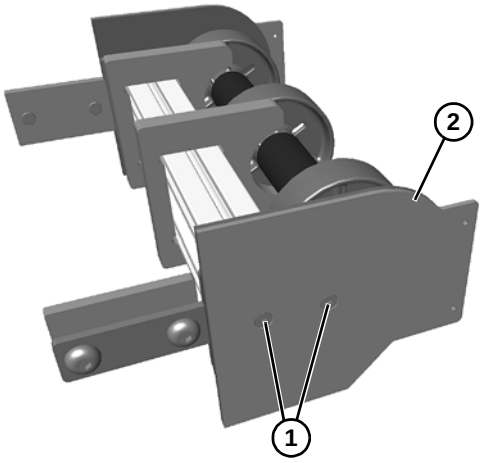


Figure 92

8. Remove cover plate **(Figure 93, item 1)** off of idler tail assembly.

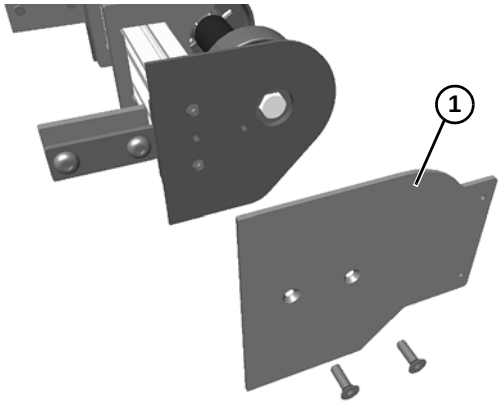


Figure 93

9. Remove two flat head screws **(Figure 94, item 1)** on filler plate **(Figure 94, item 2)** on each side of idler tail assembly.

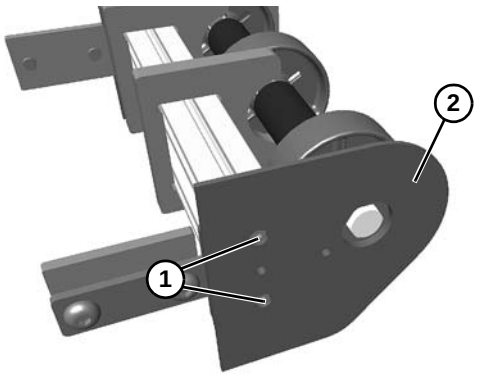


Figure 94

10. Remove filler plate **(Figure 95, item 1)** and backing plate **(Figure 95, item 2)** off of each side of idler tail assembly.

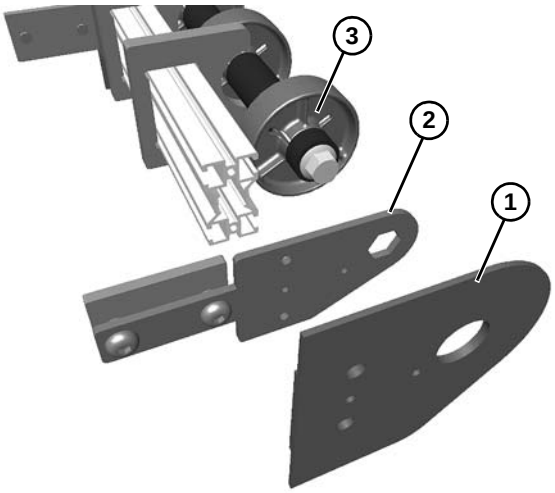


Figure 95

11. Remove idler spindle **(Figure 95, item 3)** from assembly.
12. Use wrenches to remove both bolts **(Figure 96, item 1)** from each side of roller assembly.

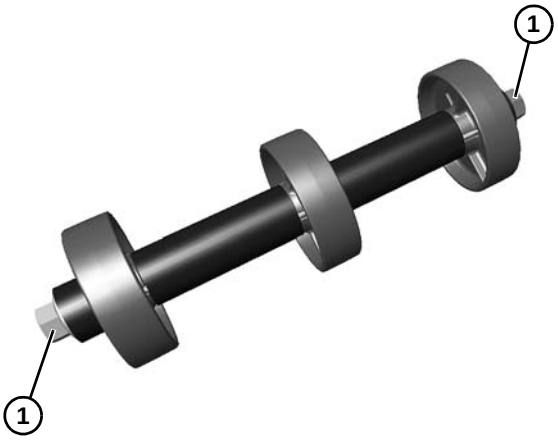


Figure 96

13. Remove tube spacers **(Figure 97, item 1)** and idler pucks **(Figure 97, item 2),** as needed, from each side of idler tube **(Figure 97, item 3)**.

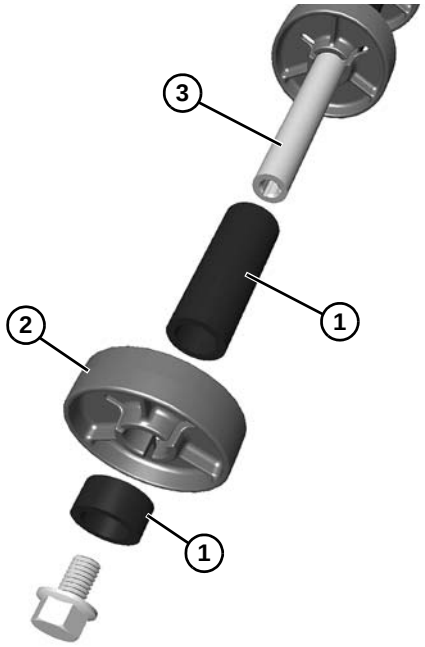


Figure 97

14. Remove gap filler plates **(Figure 98, item 1)** from crossmember **(Figure 98, item 2)**.

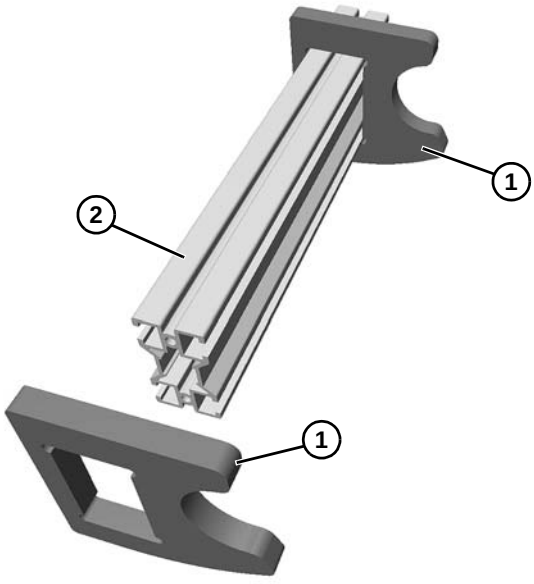


Figure 98

15. Install components reverse of removal, making sure idler pucks **(Figure 99, item 1)** and gap filler plates **(Figure 99, item 2)** are evenly spaced on assembly.

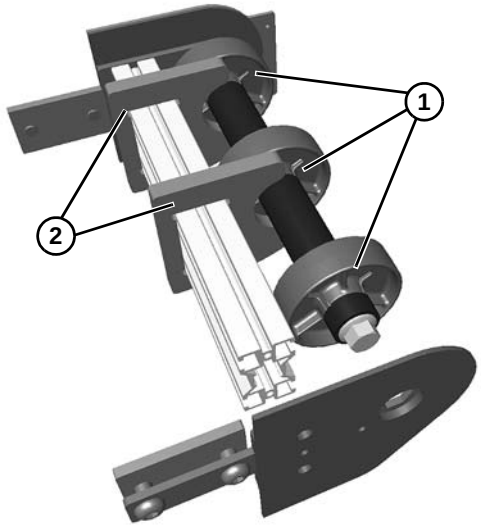


Figure 99

16. Assemble components reverse of removal.

NOTE

When reinstalling the drive spindle tail assembly, the drive tail assembly ***(Figure 100, item 1)*** *should mate flush with the conveyor frame* ***(Figure 100, item 2)****.*

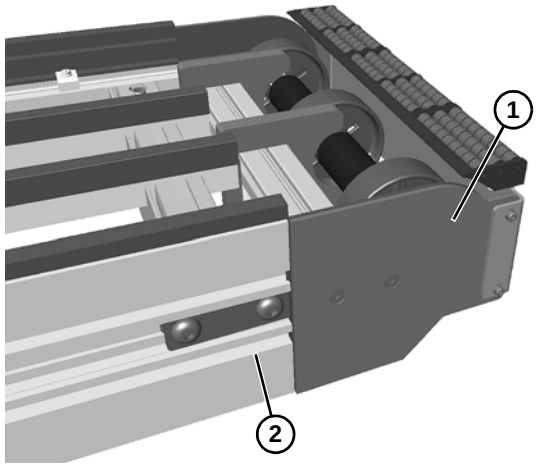


Figure 100

Weighted Take-Up

1. Remove two socket head screws **(Figure 101, item 1)** securing side plate **(Figure 101, item 2)** to weighted take-up plate from one side of conveyor.

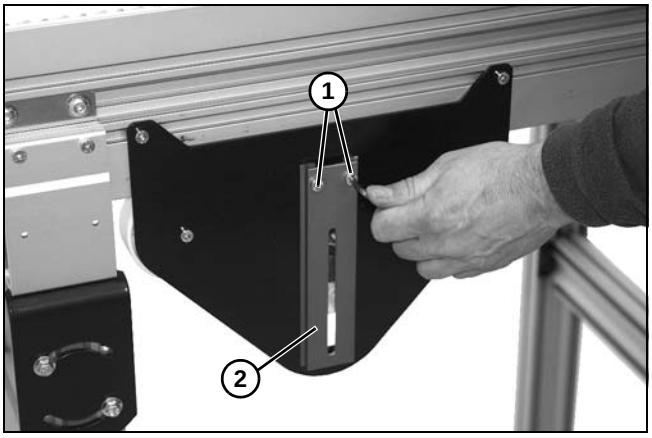


Figure 101

IMPORTANT

Avoid injury. Assembly is heavy and may fall when remaining hardware is removed.

2. Remove two socket head screws **(Figure 102, item 1)** holding weighted take-up assembly **(Figure 102, item 2)** to conveyor frame **(Figure 102, item 3)**.

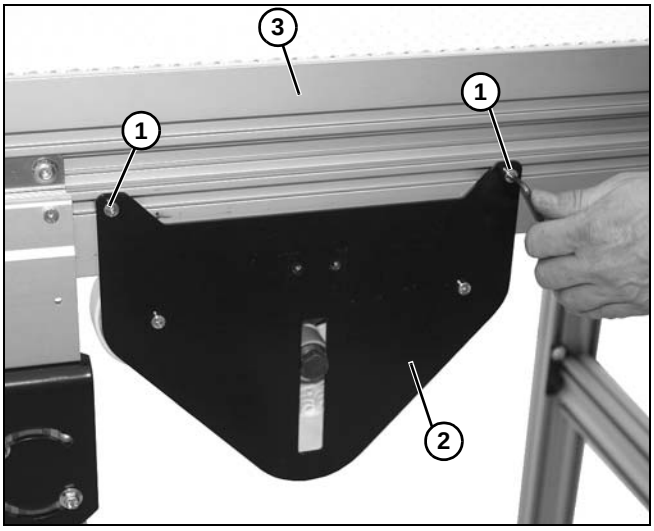


Figure 102

3. While holding belt from underneath, remove weighted take-up plate assembly **(Figure 103, item 1)** from weighted pulley assembly **(Figure 103, item 2)**.

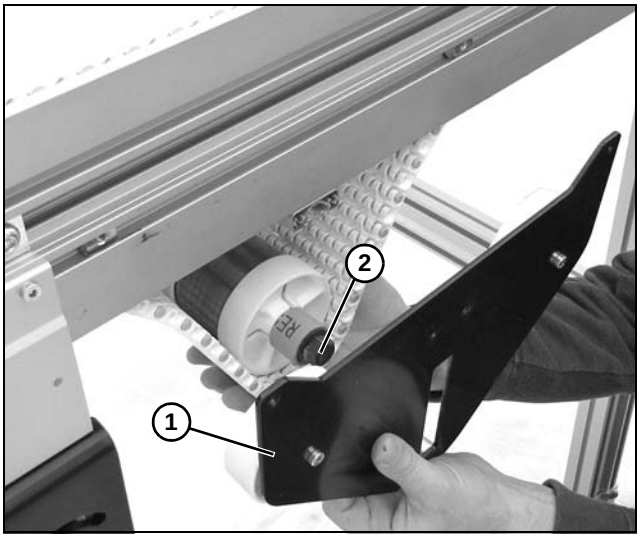


Figure 103

4. Remove weighted pulley assembly **(Figure 104, item 1)** from belt **(Figure 104, item 2)**.

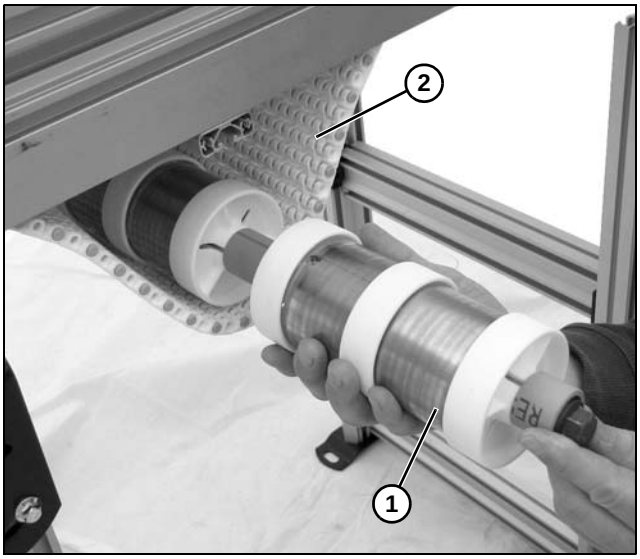


Figure 104

5. Use wrenches to remove both bolts **(Figure 105, item 1)** from each side of roller assembly.

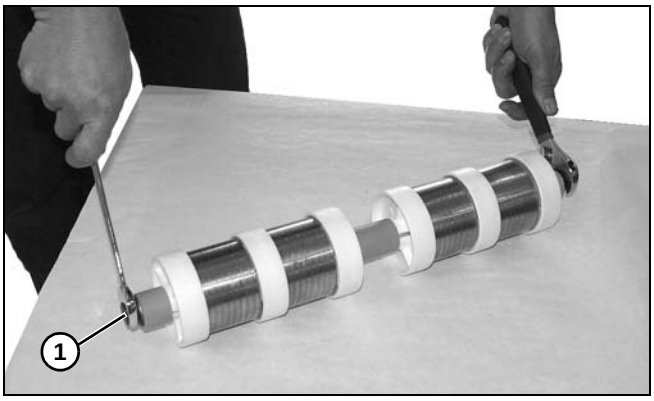


Figure 105

6. Remove tube spacer **(Figure 106, item 1),** as needed, from each side of assembly.

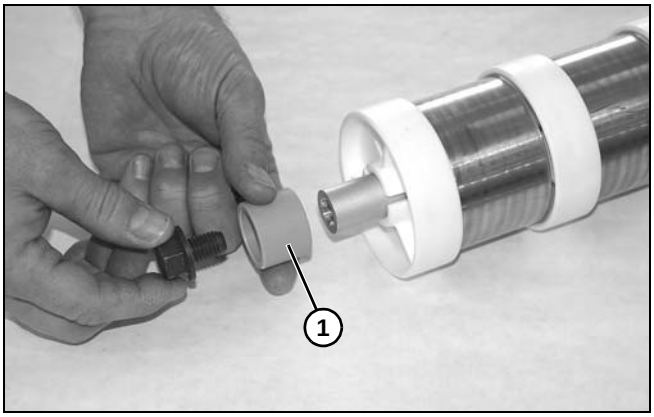


Figure 106

7. Remove idler puck **(Figure 107, item 1)** and weight **(Figure 107, item 2)** off of shaft, as needed. from belt.

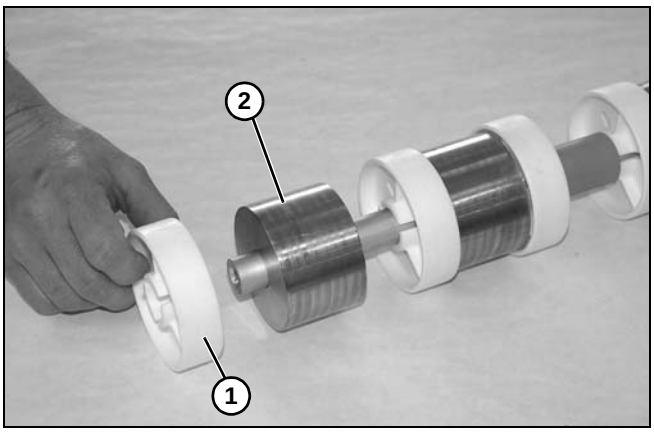


Figure 107

8. Remove socket head screw **(Figure 108, item 1)** on weighted take-up plate assembly **(Figure 108, item 2)**.

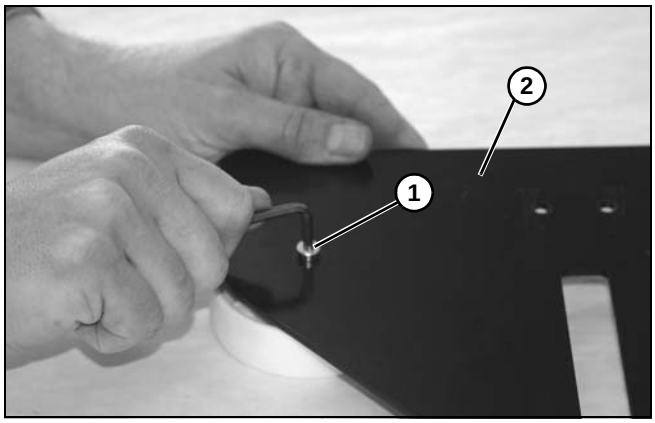


Figure 108

9. On opposite side of socket head screw just removed, remove idler puck **(Figure 109, item 1)**, idler stub **(Figure 109, item 1)**, and spacer **(Figure 109, item 2)**.

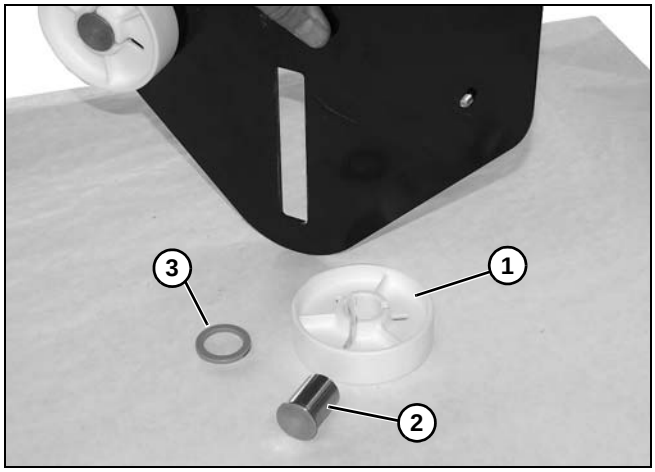


Figure 109

10. Install components reverse of removal.

Power Transfer

Removal

1. Remove two hex head screws **(Figure 110, item 1)** and cover **(Figure 110, item 2)** from power transfer assembly.

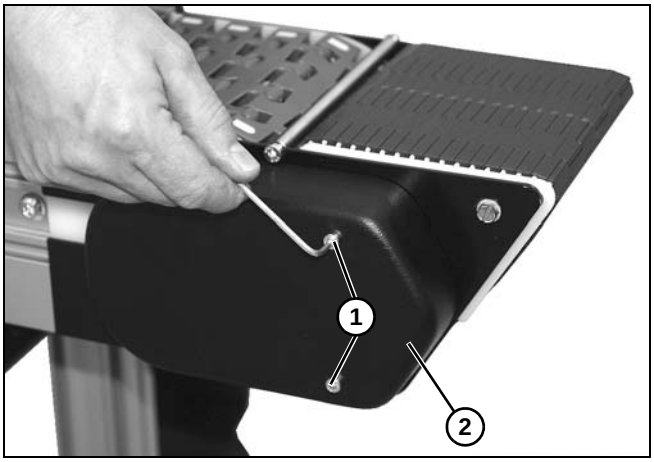


Figure 110

2. Loosen socket head screw **(Figure 111, item 1)** holding tensioning pulley **(Figure 111, item 2)** onto timing belt **(Figure 111, item 3)**.

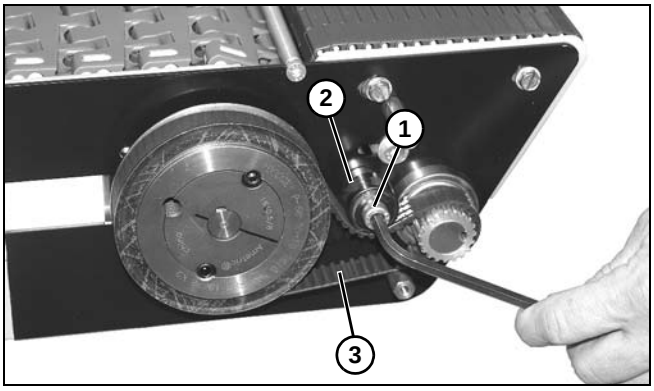


Figure 111

3. Remove timing belt **(Figure 112, item 1)** from assembly.

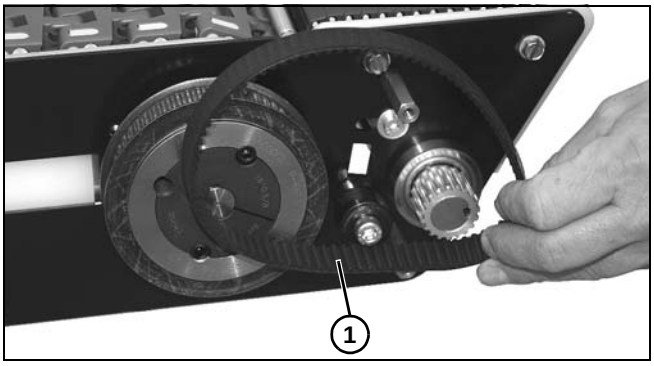


Figure 112

4. While holding onto pulley **(Figure 113, item 1)**, remove one set screw **(Figure 113, item 2)** on pulley.

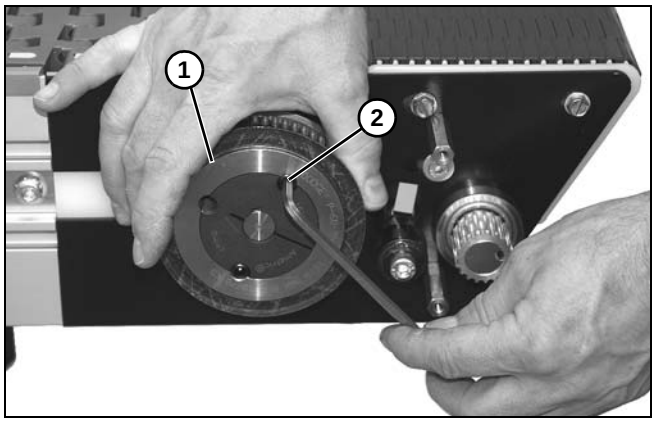


Figure 113

5. Install set screw **(Figure 114, item 1)**, into hole aligned with slot **(Figure 114, item 2)** in pulley **(Figure 114, item 3)**.

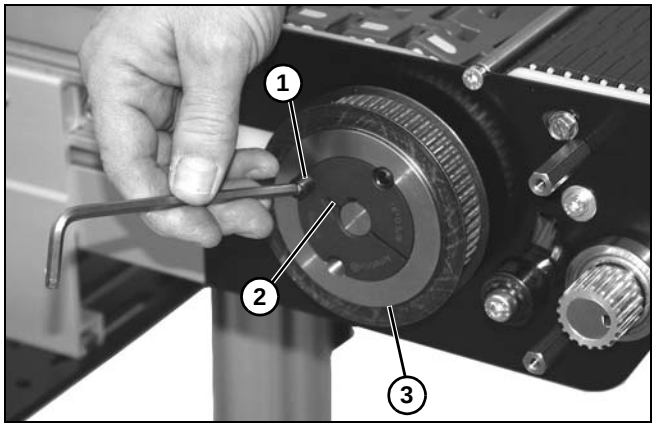


Figure 114

6. Remove pulley **(Figure 114, item 3)**.
7. Remove socket head screws **(Figure 115, item 1)** from power transfer tail **(Figure 115, item 2)**. Repeat on opposite side.

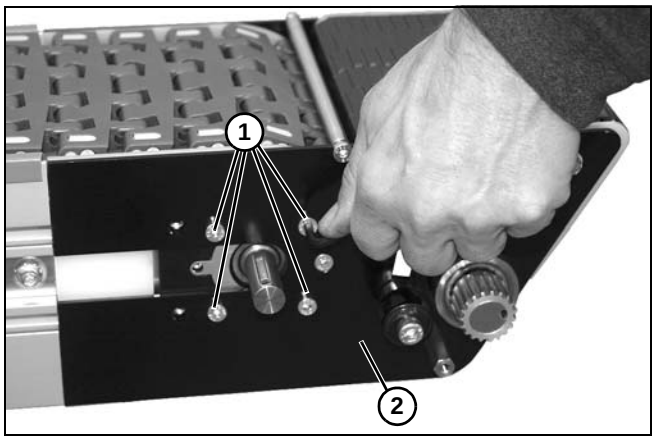


Figure 115

8. Remove socket head screw **(Figure 116, item 1)** from power transfer tail. Repeat on opposite side.

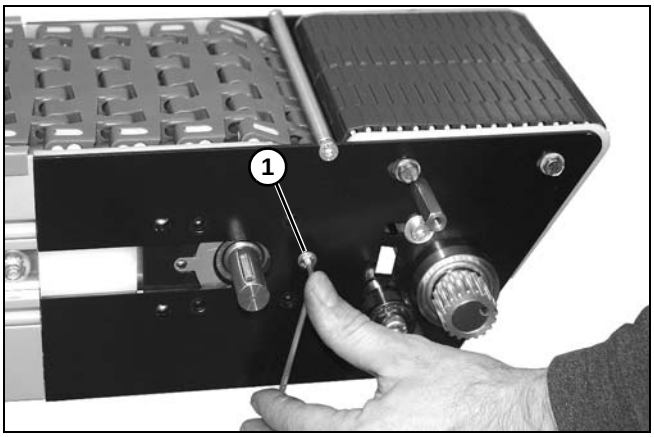


Figure 116

9. Remove power transfer tail **(Figure 117, item 1)** from frame **(Figure 117, item 2)**.

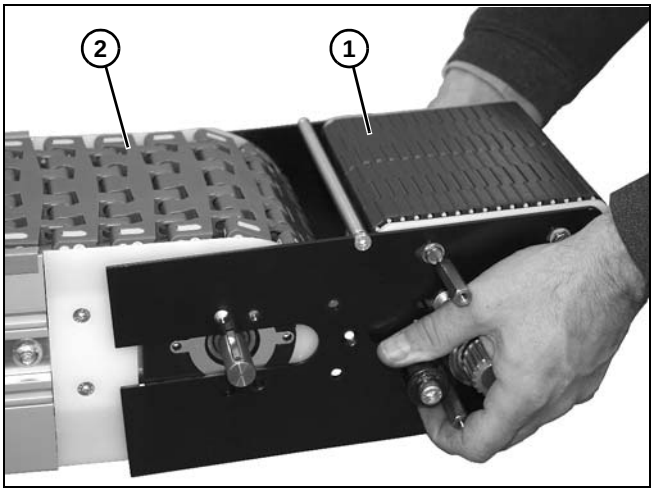


Figure 117

10. Remove bearing stop plate **(Figure 118, item 1)** from drive backing plate **(Figure 118, item 2)**.

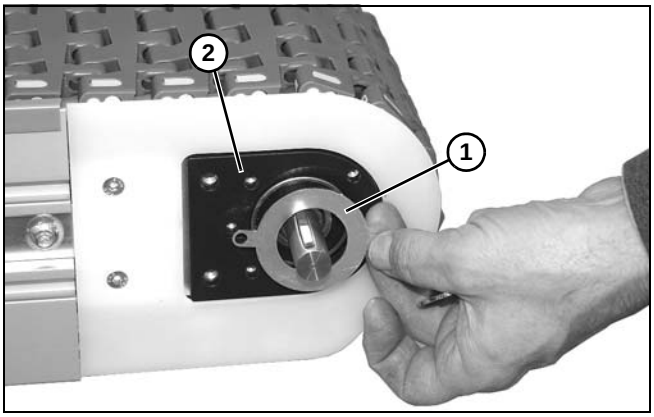


Figure 118

11. Loosen socket head screw **(Figure 119, item 1)** on rod **(Figure 119, item 2)** each side of transfer tail. Remove rod.

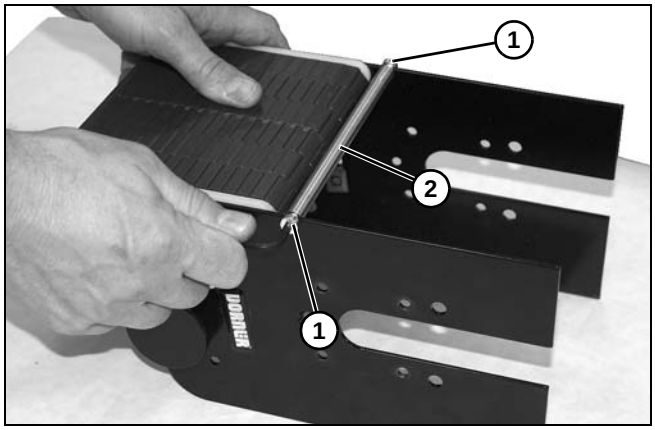


Figure 119

12. Loosen socket head screw **(Figure 120, item 1)** on tensioning rod on each side of transfer tail.

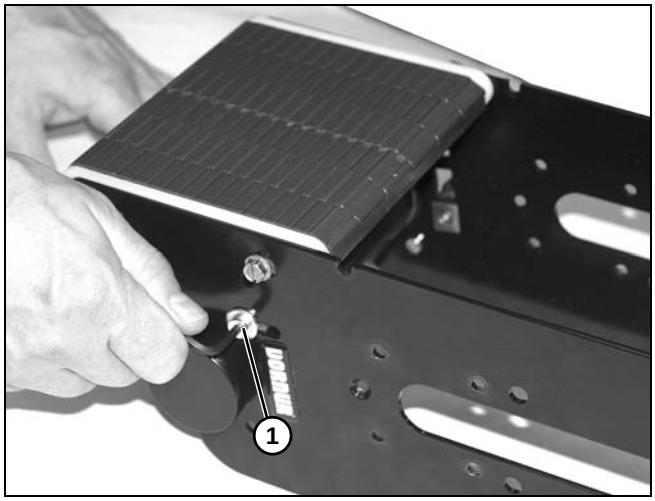


Figure 120

13. Slide assembly within slot **(Figure 121, item 1)** to remove tension on belt.

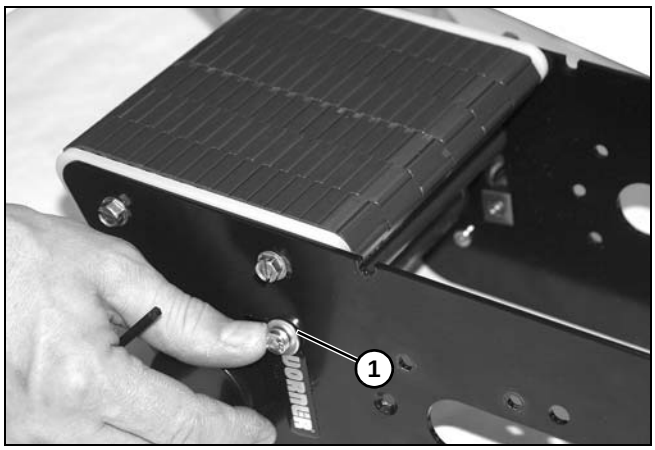


Figure 121

14. Lift slightly on belt **(Figure 122, item 1)** and push pin **(Figure 122, item 2)** out of belt.

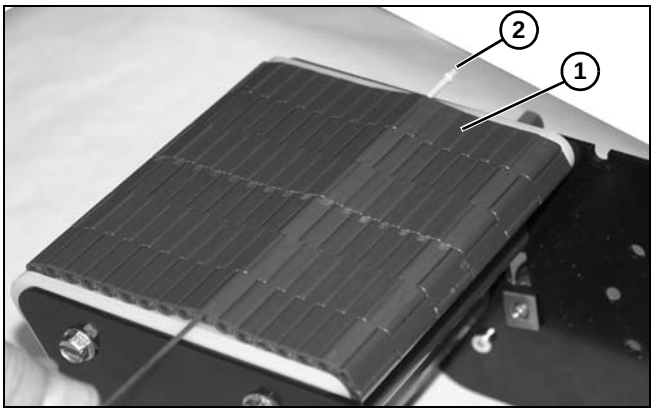


Figure 122

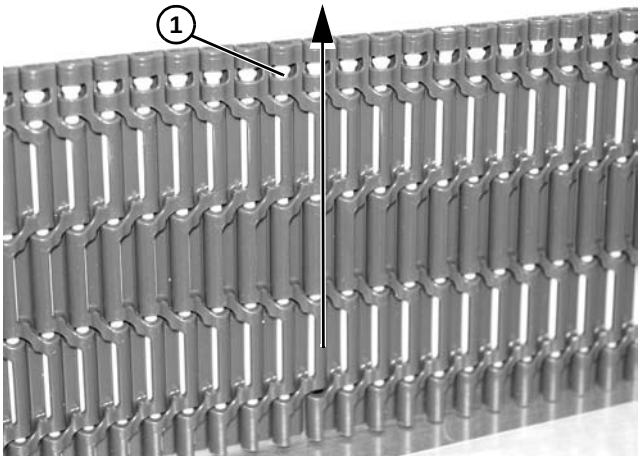


Figure 123

NOTE

*Note that head of pin **(Figure 123, item 1)** should be removed in direction shown.*

15. Remove belt **(Figure 124, item 1)** from around tensioning rod **(Figure 124, item 2)**.

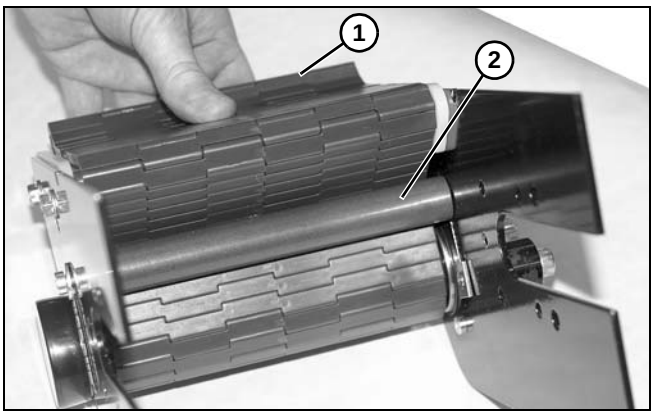


Figure 124

16. Continue to remove belt **(Figure 125, item 1)** from under tensioning rod **(Figure 125, item 2)** and from around drive shaft **(Figure 125, item 3)**.

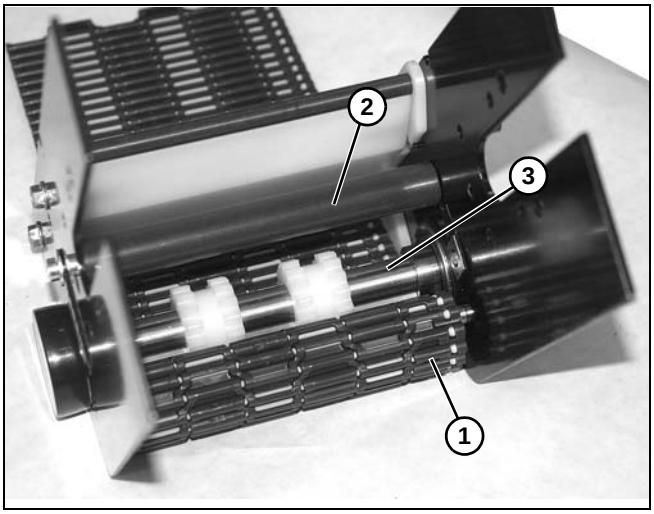


Figure 125

17. Remove two bolts **(Figure 126, item 1)** on each side holding wear bar assembly **(Figure 126, item 2)** onto power transfer.

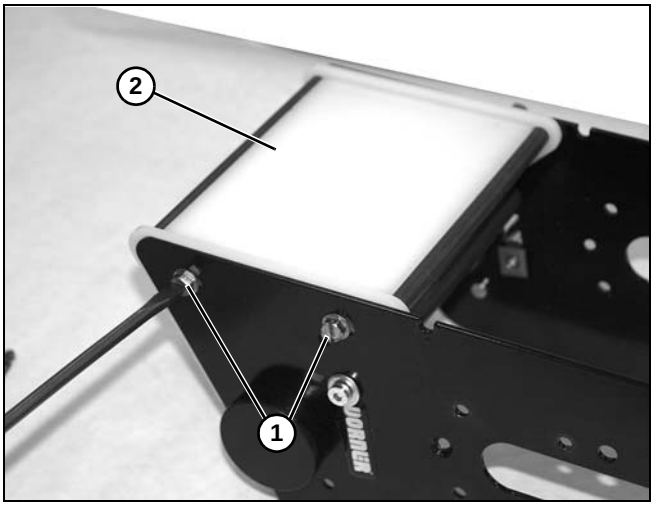


Figure 126

18. Remove socket head screw **(Figure 127, item 1)** on each side holding tension rod **(Figure 127, item 2)** onto power transfer.

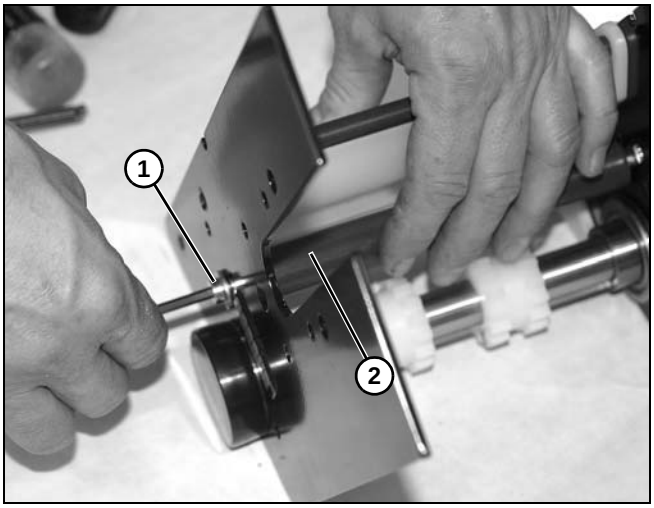


Figure 127

19. Remove cap **(Figure 128, item 1)** from driveshaft assembly **(Figure 128, item 2)**.

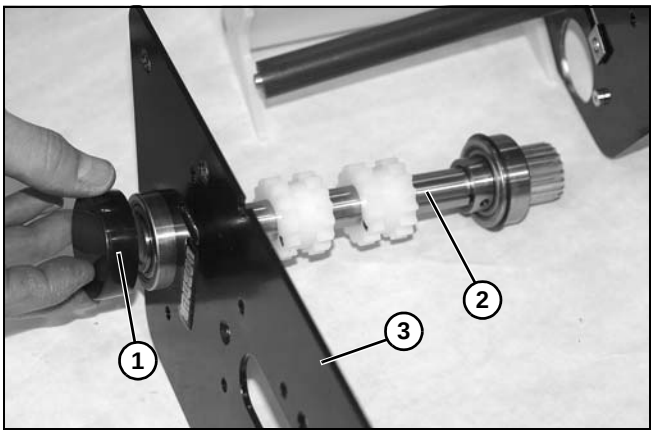


Figure 128

20. Remove driveshaft assembly **(Figure 128, item 2)** from side plate **(Figure 128, item 3)**.
21. Loosen set screws **(Figure 129, item 1)** on driveshaft bearing assembly **(Figure 129, item 2)** and remove from driveshaft **(Figure 129, item 3)**.

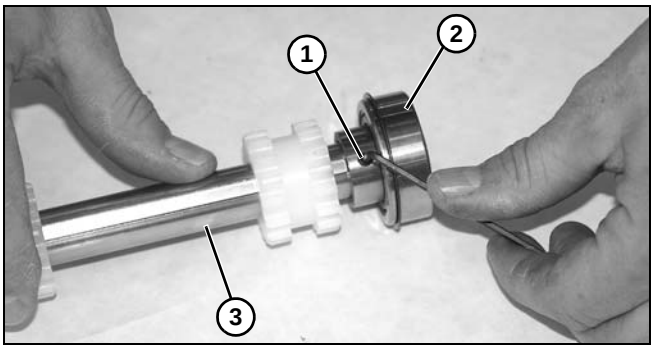


Figure 129

22. Remove gear **(Figure 130, item 1)**, key **(Figure 130, item 2)**, and second gear **(Figure 130, item 3)** off of driveshaft **(Figure 130, item 4)**.

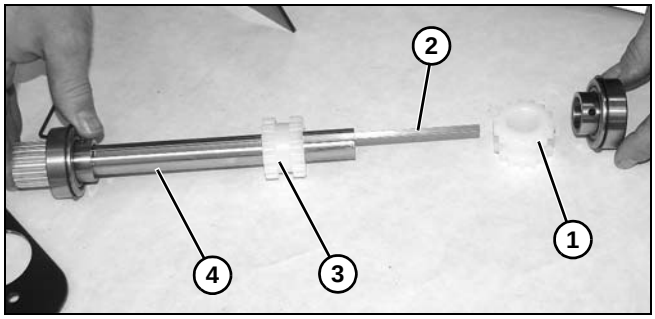


Figure 130

23. Loosen set screw on second driveshaft bearing assembly **(Figure 131, item 1)**, and remove off of driveshaft **(Figure 131, item 2)**.

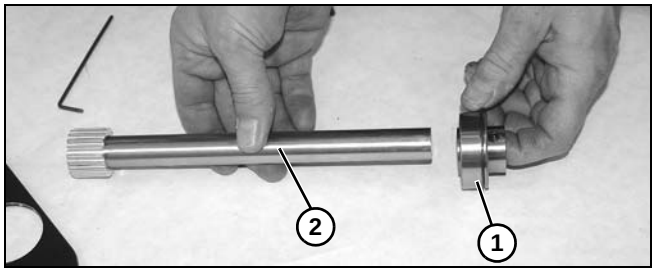


Figure 131

24. Assemble driveshaft components, reverse of removal.
25. Disassemble side guide plate **(Figure 132, item 1)**, from wear rods **(Figure 132, item 2)**.

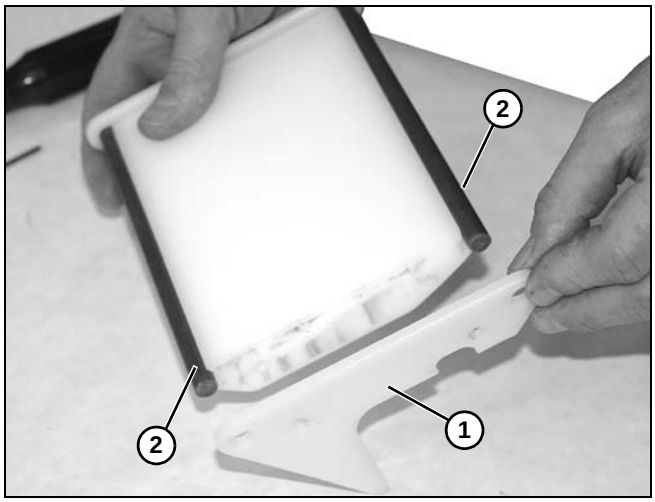


Figure 132

26. Disassemble wear bar **(Figure 133, item 1)**, from wear rods **(Figure 133, item 2)**, and remaining side guide plate **(Figure 133, item 3)**. Replace worn components.

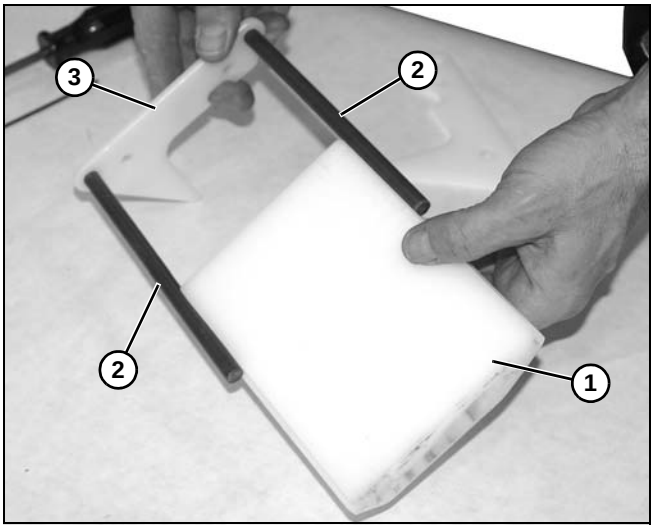


Figure 133

Installation

1. Install driveshaft assembly **(Figure 134, item 1)** onto side plate **(Figure 134, item 3)**.

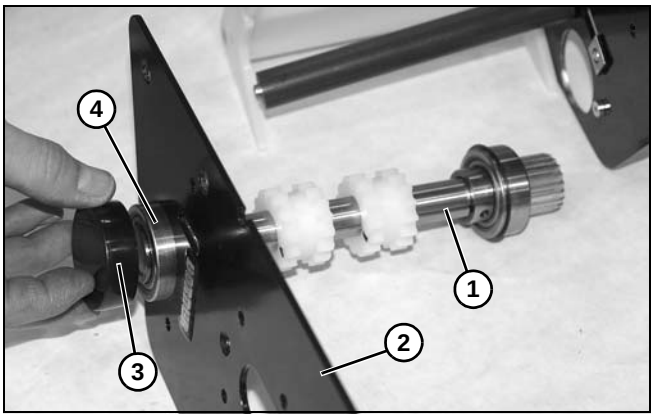


Figure 134

2. Install cap **(Figure 134, item 3)** onto driveshaft bearing assembly **(Figure 134, item 4)**.

3. Install tension rod **(Figure 135, item 1)** with socket head screw **(Figure 135, item 2)** on each side holding onto power transfer.

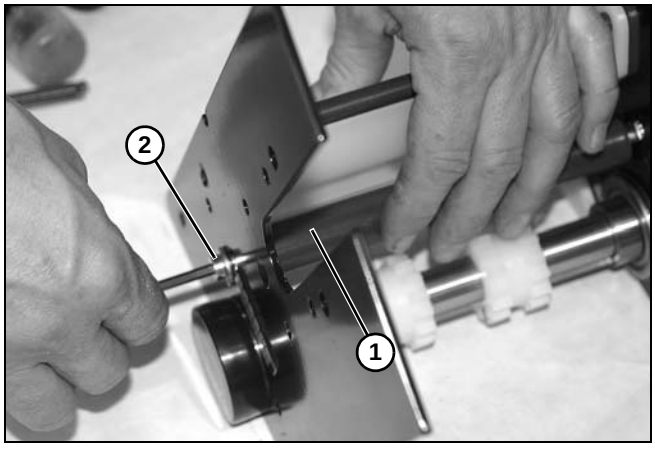


Figure 135

4. Install wear bar assembly **(Figure 136, item 1)** with two bolts **(Figure 136, item 2)** on each side of power transfer.

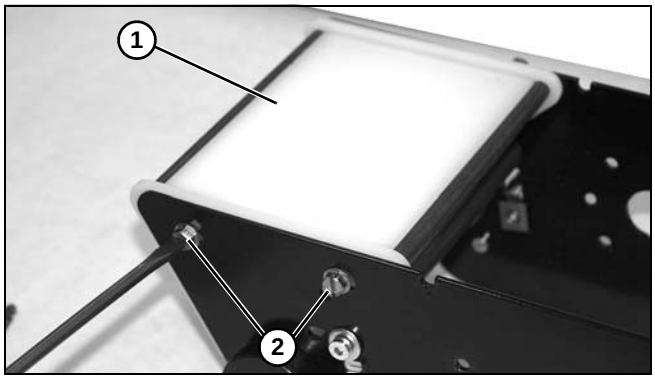


Figure 136

5. Install belt **(Figure 137, item 1)** under drive shaft **(Figure 137, item 2)** and around tensioning rod **(Figure 137, item 3)**.

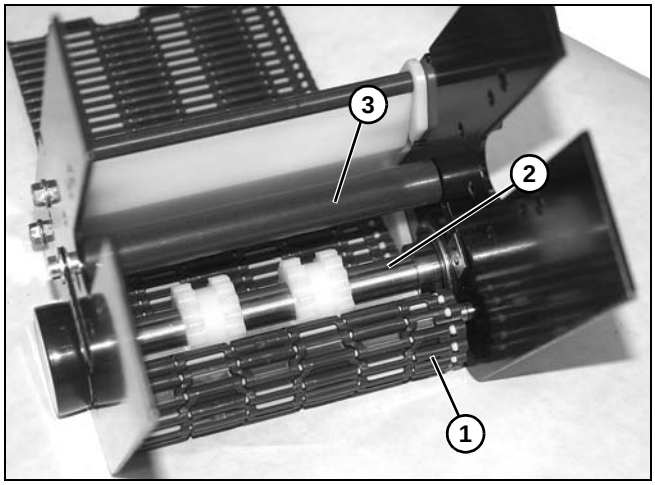


Figure 137

6. Continue routing belt **(Figure 138, item 1)** around tensioning rod **(Figure 138, item 2)**.

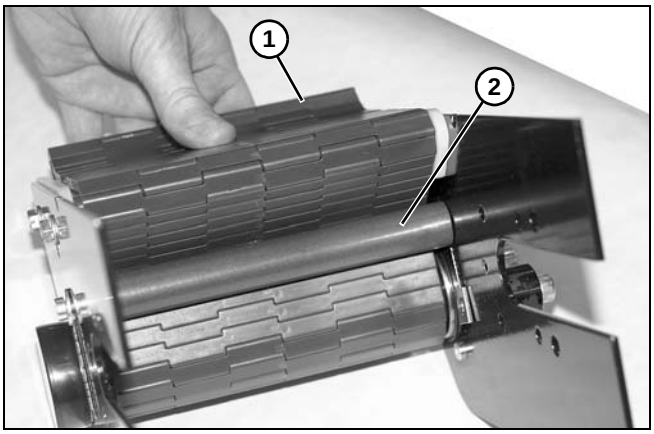


Figure 138

7. Bring ends of belt together and install pin **(Figure 139, item 1)**.

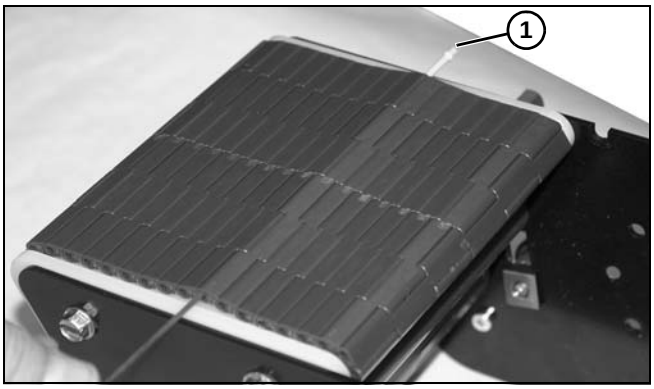


Figure 139

⚠ CAUTION

DO NOT overtighten belt or excessive wear will occur.

8. Slide assembly **(Figure 140, item 1)** within slot to remove excess slack from belt, and tighten socket head screw **(Figure 140, item 2)**.

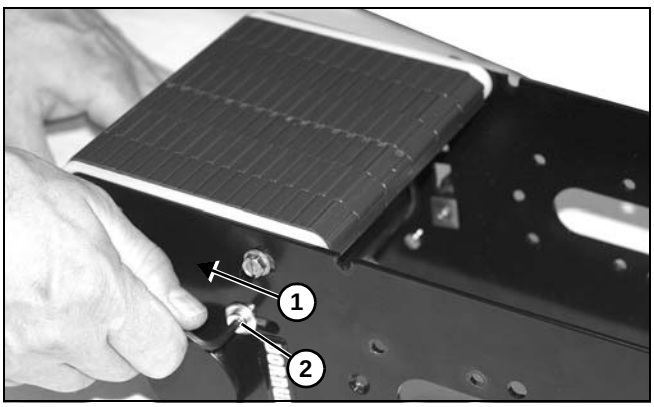


Figure 140

9. Install rod **(Figure 141, item 1)** and secure with socket head screw **(Figure 141, item 2)** each side of transfer tail.

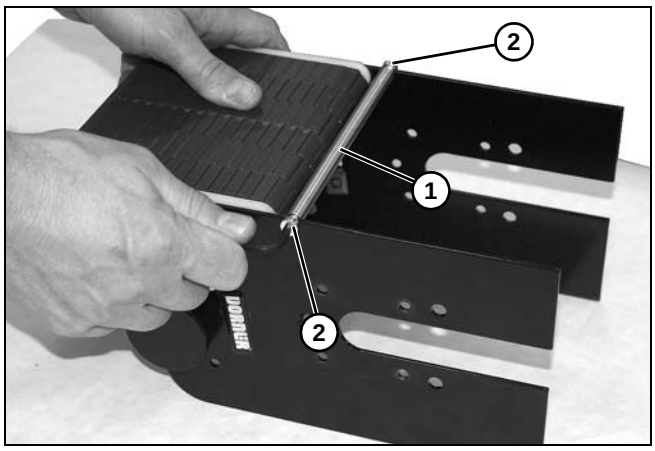


Figure 141

10. Install bearing stop plate **(Figure 142, item 1)** onto drive backing plate **(Figure 142, item 2)**.

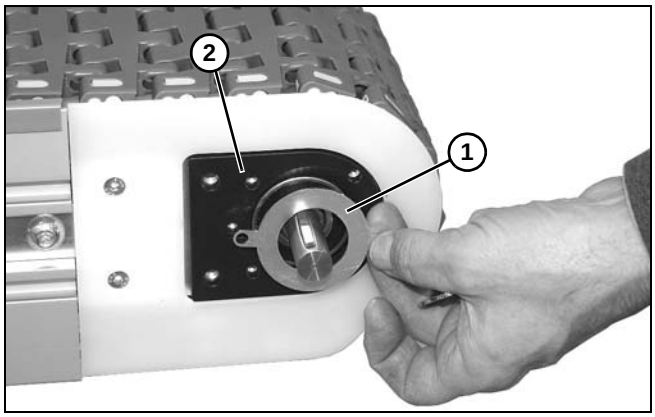


Figure 142

11. Install power transfer tail **(Figure 143, item 1)** onto frame **(Figure 143, item 2)**.

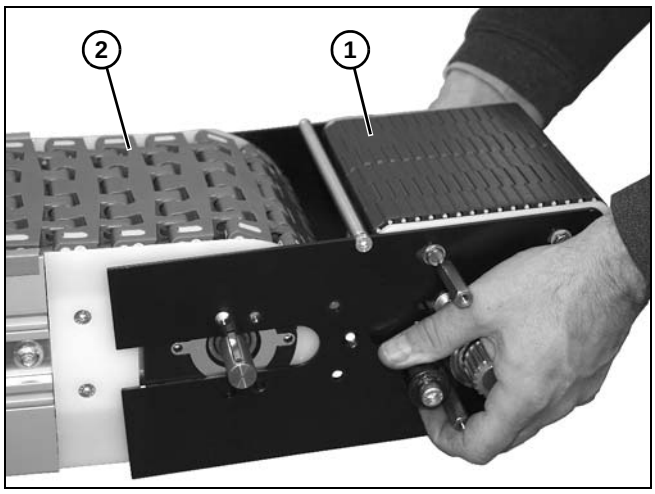


Figure 143

12. Install socket head screw **(Figure 144, item 1)** onto power transfer tail. Repeat on opposite side.

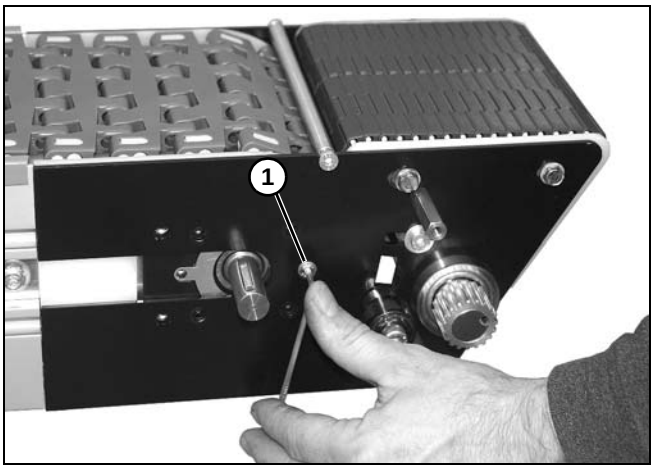


Figure 144

13. Install four socket head screws **(Figure 145, item 1)** securing power transfer tail **(Figure 145, item 2)**. Repeat on opposite side.

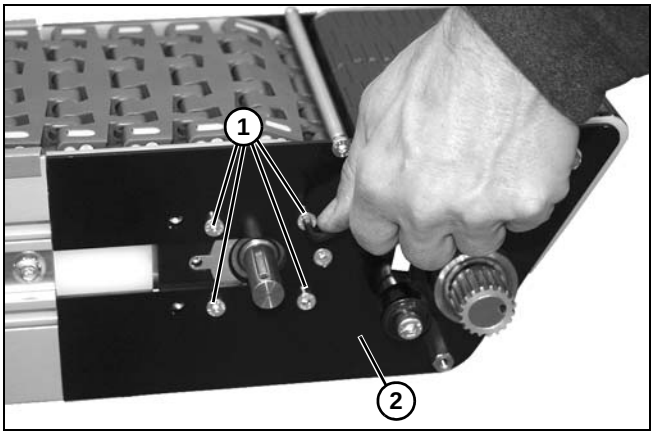


Figure 145

14. Install pulley **(Figure 146, item 1)** until it is flush with driveshaft **(Figure 146, item 2)**.

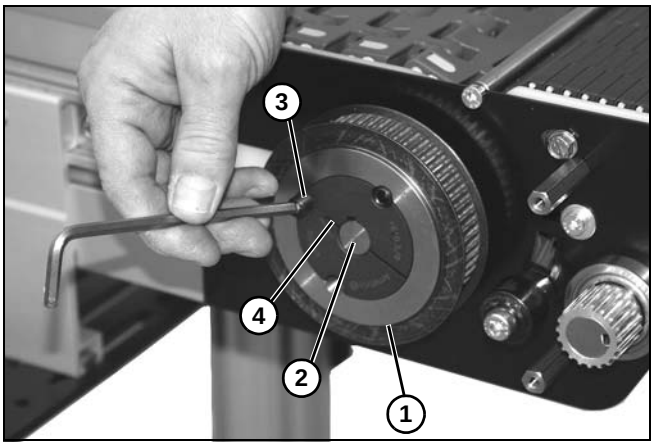


Figure 146

15. Remove set screw **(Figure 146, item 3)** from hole aligned with slot **(Figure 146, item 4)**.
16. While holding onto pulley **(Figure 147, item 1)**, install set screw **(Figure 147, item 2)** on pulley.

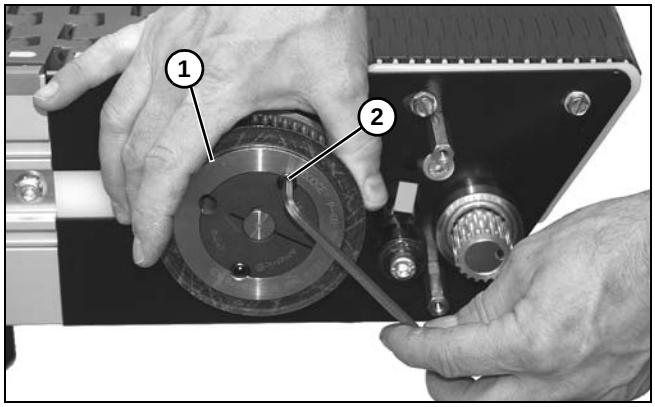


Figure 147

17. Install timing belt **(Figure 148, item 1)** onto transfer tail assembly pulley and driveshaft gear.

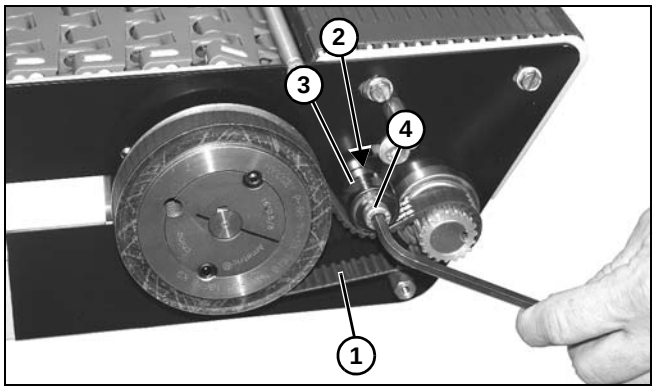


Figure 148

18. Push down **(Figure 148, item 2)** on tension pulley **(Figure 148, item 3)** and tighten socket head screw **(Figure 148, item 4)**.
19. Install cover **(Figure 149, item 1)** with two hex head screws **(Figure 149, item 2)**.

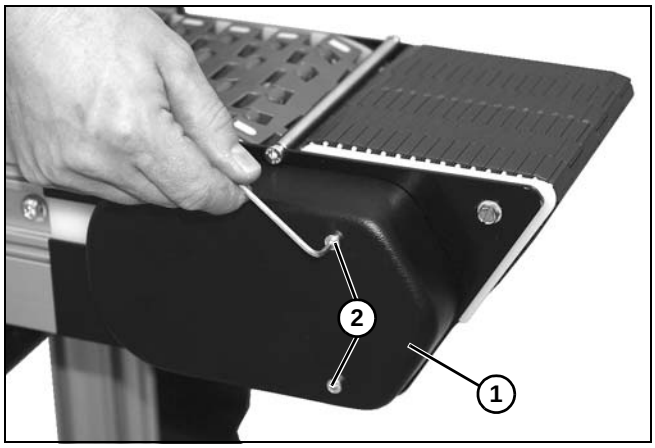


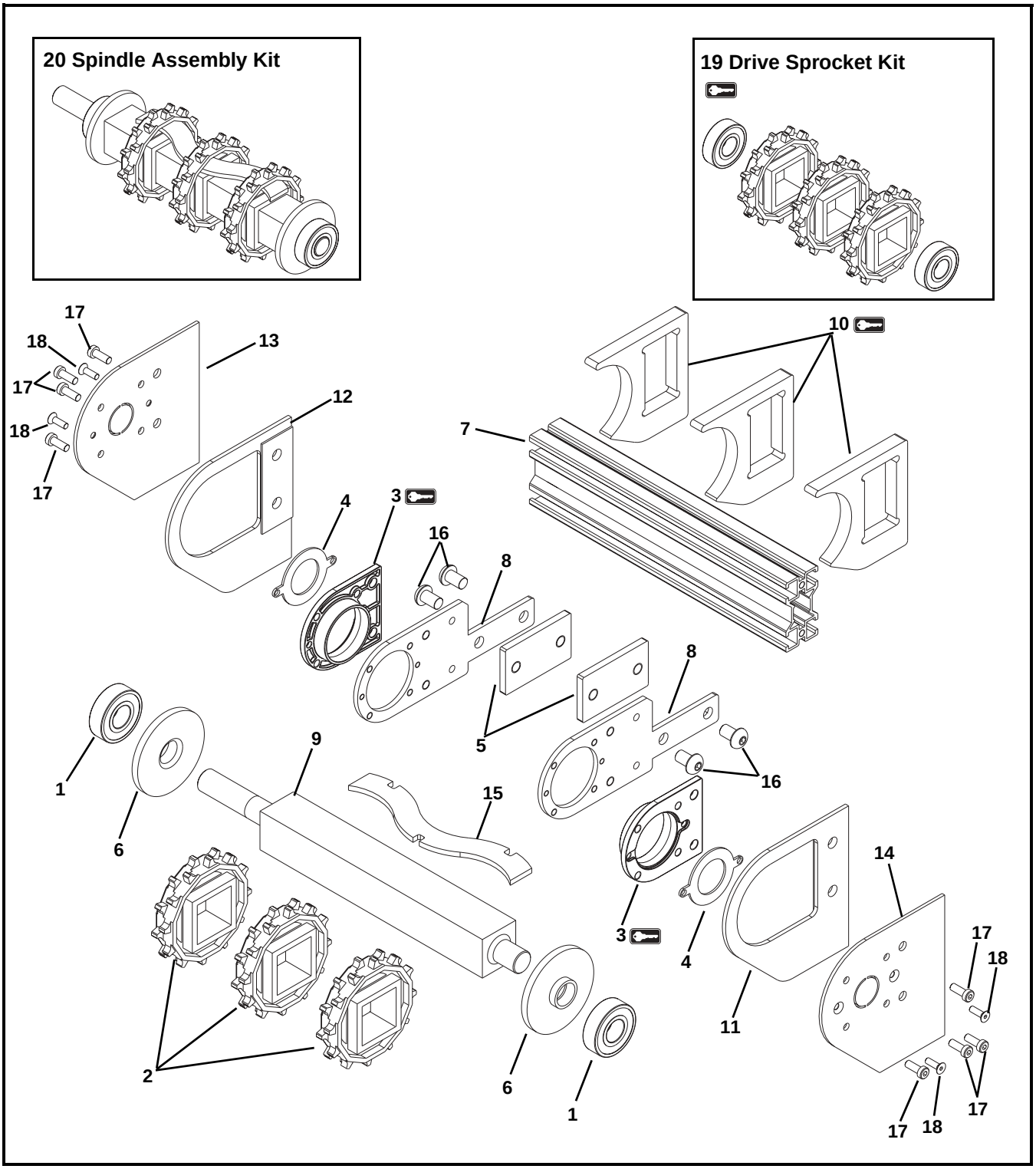
Figure 149

Notes

Service Parts

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

Drive End Tail Assembly



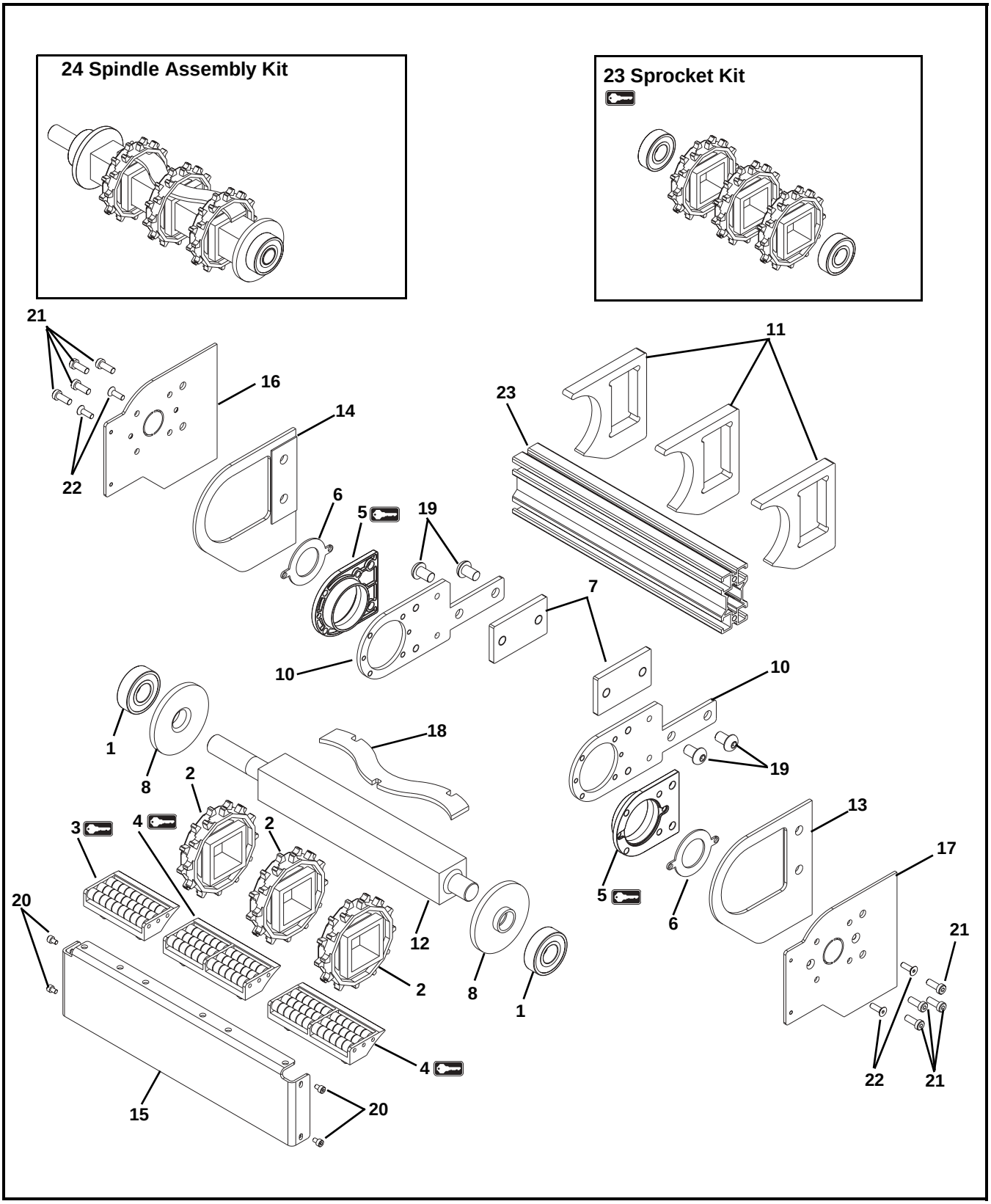
Item	Part Number	Description
1	802-126	Ball Bearing
2	807-1444	Sprocket for Standard Belts
	807-2280	Sprocket for High Strength Belts
3	350313	Bearing Housing
4	350365	Bearing Stop Plate
5	350372	Nut Clamp Plate
6	350394	Washer (for Standard Belts only)
7	350459-WW	Crossmember for Standard Belts
	350366-WW	Crossmember for High Strength Belts
8	350462	Drive Backing Plate for Standard Belts
	350368	Drive Backing Plate for High Strength Belts
9	350464-WW	Spindle for Standard Belts
	350554-WW	Dual Shaft Spindle for Standard Belts
	350455-WW	Spindle for High Strength Belts
	350553-WW	Dual Shaft Spindle for High Strength Belts
10	350465	Gap Filler Plate for Standard Belts
	350454	Gap Filler Plate for High Strength Belts
11	350562	Drive Filler Plate Left Hand for Standard Belts
	350558	Drive Filler Plate Left Hand for High Strength Belts
12	350563	Drive Filler Plate Right Hand for Standard Belts
	350559	Drive Filler Plate Right Hand for High Strength Belts

Item	Part Number	Description
13	350661	Drive Plate Left Hand for Standard Belts
	350450	Drive Plate Left Hand for High Strength Belts
14	350662	Drive Plate Right Hand for Standard Belts
	350451	Drive Plate Right Hand for High Strength Belts
15	350768-WW	Sprocket Alignment Key for Standard Belt Only
16	911016M	Button Head Screw, M10-1.50 x 16 mm
17	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
18	930516M	Flat Head Screw, M5-.80 x 16 mm
19	32CSK-WW	Sprocket Kit for Standard Belts (Includes items 1 & 2)
	32CSKH-WW	Sprocket Kit for High Strength Belts (Includes items 1 & 2)
20	32CSAK-WW	Spindle Assembly Kit for Standard Belts (Includes items 1, 2, 6, 9, & 15)
	32CSAKH-WW	Spindle Assembly Kit for High Strength Belts (Includes items 1, 2, 6, & 9)
	32CDSSAK-WW	Dual Shaft Spindle Assembly Kit for Standard Belts (Includes items 1, 2, 6, 9, & 15)
	32CDSSAKH-WW	Dual Shaft Spindle Assembly Kit for High Strength Belts (Includes items 1, 2, 6, & 9)
WW = Conveyor width reference: 06 – 36 in 02 increments		

Quantity Chart				
Conveyor Width	**Item #2 Sprocket for Standard Belts**	**Item #2 Sprocket for High Strength Belts**	**Item #10 Gap Filler Plate for Standard Belts**	**Item #10 Gap Filler Plate for High Strength Belts**
6”	N/A	1	N/A	2
8”	2	N/A	2	N/A
10”	3	N/A	3	N/A
12”	3	4	3	3
14”	4	N/A	3	N/A
16”	4	N/A	3	N/A
18”	5	4	4	3
20”	5	N/A	4	N/A
22”	6	N/A	4	N/A
24”	6	6	4	4
26”	7	N/A	5	N/A
28”	7	N/A	5	N/A
30”	8	8	5	5
32”	8	N/A	5	N/A
34”	9	N/A	6	N/A
36”	9	N/A	6	N/A

Service Parts

Drive Roller Transfer Tail Assembly



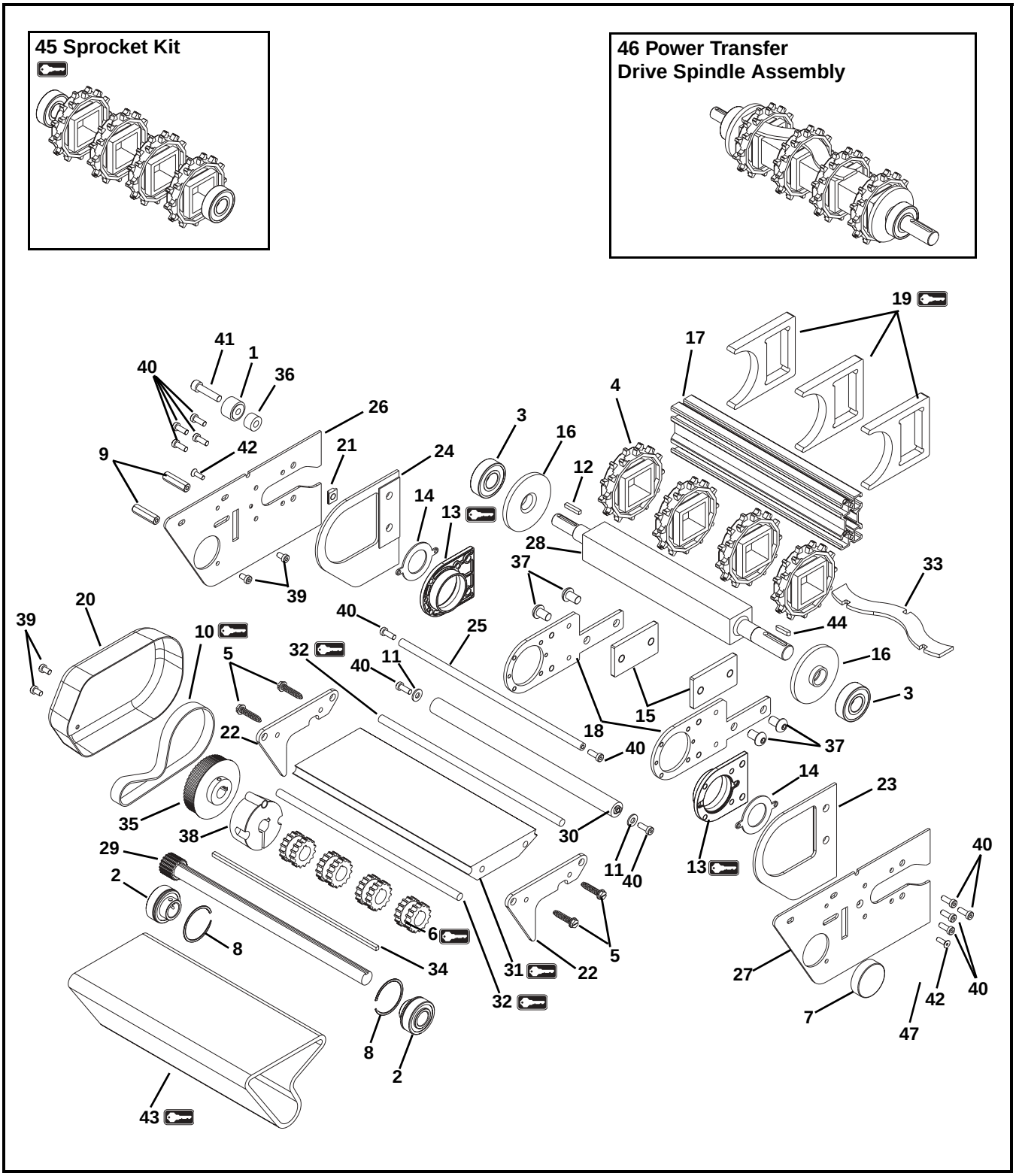
Item	Part Number	Description
1	802-126	Ball Bearing
2	807-1444	Sprocket for Standard Belts
	807-2280	Sprocket for High Strength Belts
3	807-1829	3" Transfer Roller
4	807-1830	6" Transfer Roller
5	350313	Bearing Housing
6	350365	Bearing Stop Plate
7	350372	Nut Clamp Plate
8	350394	Washer for Standard Belts Only
9	350459-WW	Crossmember for Standard Belts
	350366-WW	Crossmember for High Strength Belts
10	350462	Drive Backing Plate for Standard Belts
	350368	Drive Backing Plate for High Strength Belts
11	350465	Gap Filler Plate for Standard Belts
	350454	Gap Filler Plate for High Strength Belts
12	350464-WW	Drive Spindle for Standard Belts
	350455-WW	Drive Spindle for High Strength Belts
13	350562	Drive Filler Plate Left Hand for Standard Belt
	350558	Drive Filler Plate Left Hand for High Strength Belts
14	350563	Drive Filler Plate Right Hand for Standard Belts
	350559	Drive Filler Plate Right Hand for High Strength Belts

Item	Part Number	Description
15	350660-WW	Roller Transfer Support Bracket for Standard Belts
	350544-WW	Roller Transfer Support Bracket for High Strength Belts
16	350663	Cover Plate Right Hand for Standard Belts
	350546	Cover Plate Right Hand for High Strength Belts
17	350664	Cover Plate Left Hand for Standard Belts
	350545	Cover Plate Left Hand for High Strength Belts
18	350768-WW	Sprocket Alignment Key for Standard Belts Only
19	911016M	Button Head Screw, M10-1.50 x 16 mm
20	920406M	Socket head Screw, M4-0.70 x 6 mm
21	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
22	930516M	Flat Head Screw, M5-.80 x 16 m
23	32CSK-WW	Sprocket Kit for Standard Belts (Includes items 1 & 2)
	32CSKH-WW	Sprocket Kit for High Strength Belts (Includes items 1 & 2
24	32CSAK-WW	Spindle Assembly Kit for Standard Belts (Includes items 1, 2, 8, 12, & 18)
	32CSAKH-WW	Spindle Assembly Kit for High Strength Belts (Includes items 1, 2, & 12)
WW = Conveyor width reference: 06 – 36 in 02 increments		

Quantity Chart								
Conveyor Width	**Item # 2 Sprocket for Standard Belts**	**Item # 2 Sprocket for High Strength Belts**	**Item # 11 Gap Filler Plate for Standard Belts**	**Item #11 Gap Filler Plate for High Strength Belts**	**Item # 3 3" Transfer Roller for Standard Belts**	**Item # 3 3" Transfer Roller for High Strength Belts**	**Item # 4 6" Transfer Roller for Standard Belts**	**Item # 4 6" Transfer Roller for High Strength Belts**
6”	N/A	1	N/A	2	N/A	2	N/A	0
8”	2	N/A	2	N/A	1	N/A	1	N/A
10”	3	N/A	3	N/A	3	N/A	0	N/A
12”	3	4	3	3	1	1	2	2
14”	4	N/A	3	N/A	0	N/A	3	N/A
16”	4	N/A	3	N/A	2	N/A	2	N/A
18”	5	4	4	3	0	0	4	4
20”	5	N/A	4	N/A	2	N/A	3	N/A
22”	6	N/A	4	N/A	5	N/A	1	N/A
24”	6	6	4	4	3	3	3	3
26”	7	N/A	5	N/A	1	N/A	5	N/A
28”	7	N/A	5	N/A	3	N/A	4	N/A
30”	8	8	5	5	6	9	2	0
32”	8	N/A	5	N/A	4	N/A	4	N/A
34”	9	N/A	6	N/A	2	N/A	6	N/A
36”	9	N/A	6	N/A	1	N/A	7	N/A

Service Parts

Power Transfer Tail Assembly for Drive and Idler Tails

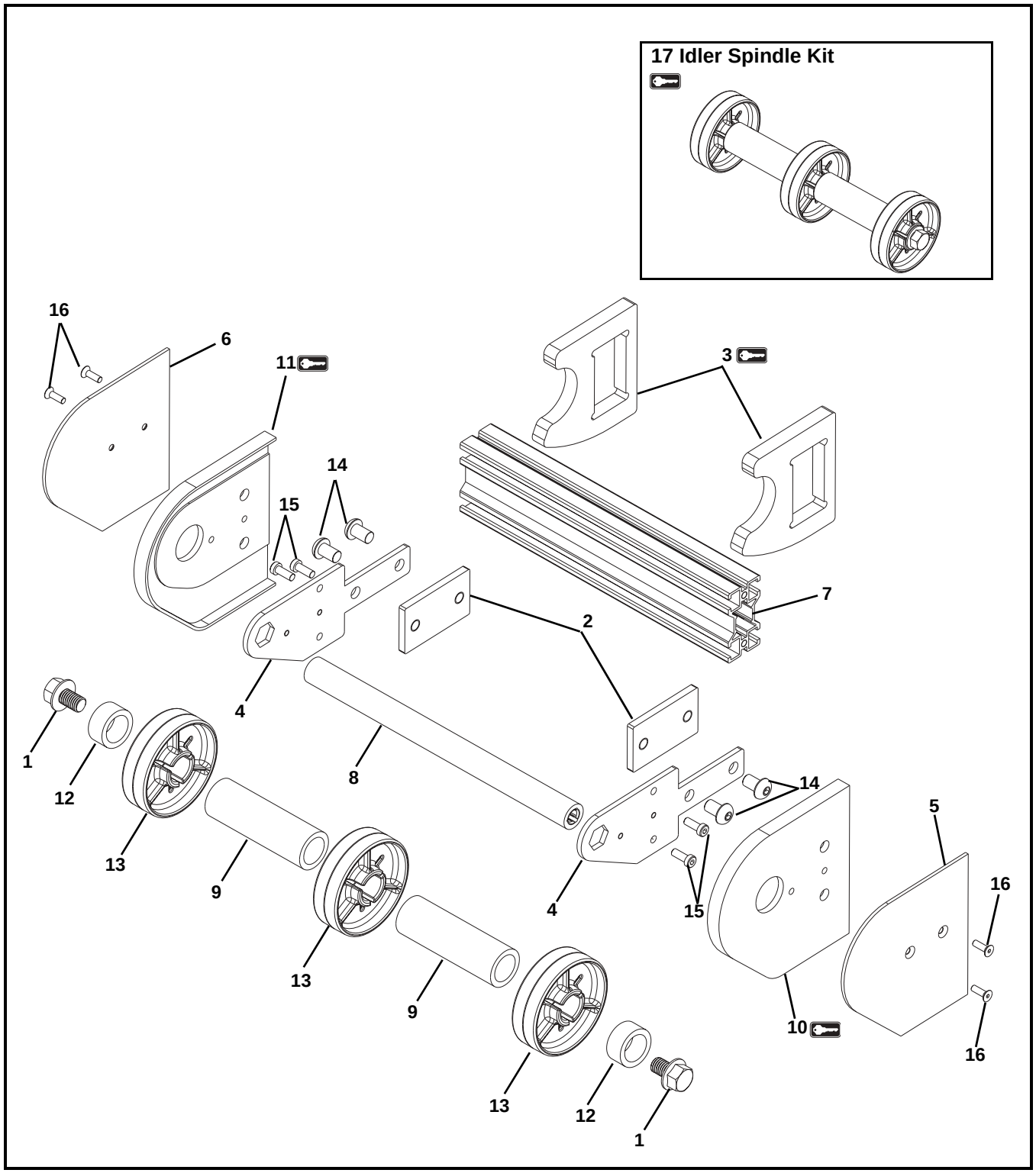


Item	Part Number	Description
1	802-046	Follower Cam Bearing
2	802-110	Bearing
3	802-126	Ball Bearing
4	807-1444	Sprocket for Standard Belts
	807-2280	Sprocket for High Strength Belts
5	807-1884	Sheet Metal Screw, #14 x 1.25"
6	807-2009	Sprocket, 15 Tooth
7	807-2285	Cover
8	807-2286	Retaining Ring
9	807-2287	Hex Post
10	814-103	Timing Belt for Standard Belts
	814-105	Timing Belt for High Strength Belts
11	911-007	Washer
12	912-080	Square Key, 0.188 x 1.00
13	350313	Bearing Housing
14	350365	Bearing Housing
15	350372	Nut Clamp Plate
16	350394	Washer for Standard Belts Only
17	350459-WW	Crossmember for Standard Belts
	350366-WW	Crossmember for High Strength Belts
18	350462	Drive Backing Plate for Standard Belts
	350368	Drive Backing Plate for High Strength Belts
19	350465	Gap Filler Plate for Standard Belts
	350454	Gap Filler Plate for High Strength Belts
20	350505	Power Transfer Cover
21	350536	Follower Nut
22	350547	Power Transfer Side Guard Plate
23	350562	Drive Filler Plate Left Hand for Standard Belts
	350558	Drive Filler Plate Left Hand for High Strength Belts
24	350563	Drive Filler Plate Right Hand for Standard Belts
	350559	Drive Filler Plate Right Hand for High Strength Belts
25	350727-WW	Power Transfer Pinch Guard Rod for Standard Belts
	350682-WW	Power Transfer Pinch Guard Rod for High Strength Belts
26	350747	Cover Plate Right Hand for Standard Belts
	350477	Cover Plate Right Hand for High Strength Belts
27	350748	Cover Plate Left Hand for Standard Belts
	350478	Cover Plate Left Hand for High Strength Belts
28	350749-WW	Drive Spindle for Standard Belts
	350486-WW	Drive Spindle for High Strength Belts
	350750-WW	Idler Spindle for Standard Belts
	350790-WW	Idler Spindle for High Strength Belts
29	350751-WW	Shaft Assembly for Standard Belts
	350685-WW	Shaft Assembly for High Strength Belts

Item	Part Number	Description
30	350752-WW	Power transfer Tensioner Assembly for Standard Belts
	350683-WW	Power transfer Tensioner Assembly for High Strength Belts
31	350753-WW	Wear Bar for Standard Belts
	350787-WW	Wear Bar for High Strength Belt
32	350754-WW	Wear Rod for Standard Belts
	350569-WW	Wear Rod for High Strength Belts
33	350768-WW	Sprocket Alignment Key for Standard Belt
34	350789-WW	Square Key, 3/16" for Standard Belts
	350576-WW	Square Key, 3/16" for High Strength Belts
35	450431	Pulley for Standard Belts
	350575	Pulley for High Strength Belts
36	450445	Spacer
37	911016M	Button Head Screw, M10-1.50 x 16 mm
38	811-110	Tapered Bushing, for High Strength Belts Only
39	950510M	Low Head Cap Screw, M5-0.80 x 10 mm
40	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
41	920835M	Socket Head Screw, M8-1.25 x 35 mm
42	930516M	Flat Head Screw, M5-0.80 x 16 mm
43	2P-WW/01	Micropitch Belt
44	980630M	Square Key, for Drive Tail Only
45	32CSK-WW	Sprocket Kit for Standard Belts (Includes items 3 & 4)
	32CSKH-WW	Sprocket Kit for High Strength Belts (Includes items 3 & 4)
46	32CDSAK-WW	Power Transfer Drive Spindle Assembly Kit for Standard Belts (Includes items 3, 4, 16, 28, & 33)
	32CDSAKH-WW	Power Transfer Drive Spindle Assembly Kit for High Strength Belts (Includes items 3, 4, & 28)
	32CESAK-WW	Power Transfer Idler Spindle Assembly Kit for Standard Belts (Includes items 3, 4, 16, 28, & 33)
	32CESAKH-WW	Power Transfer Idler Spindle Assembly Kit for High Strength Belts (Includes items 3, 4, & 28)
WW = Conveyor width reference: 06 – 36 in 02 increments		

Service Parts

Idler Tail Assembly



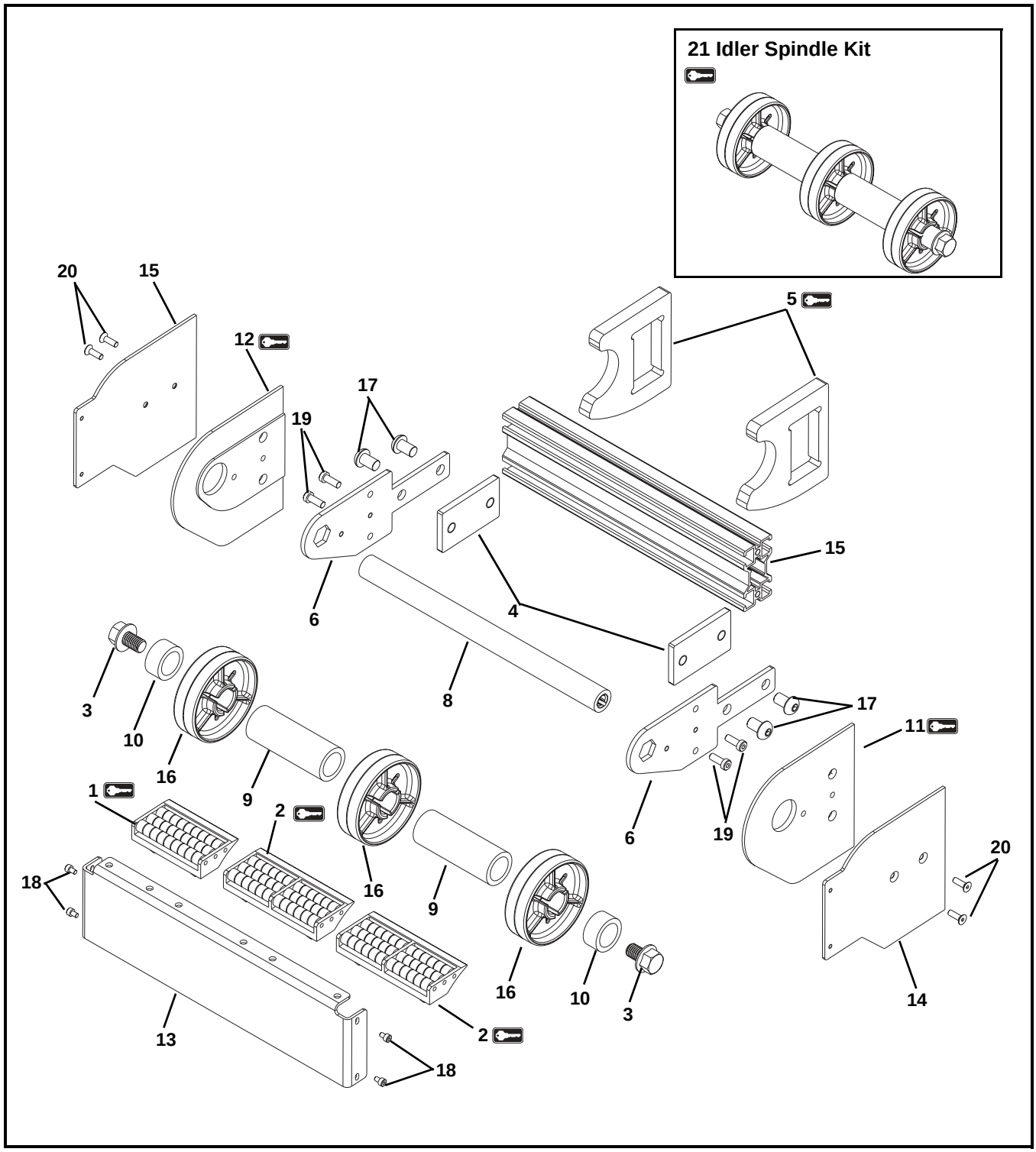
Item	Part Number	Description
1	807-2278	Hex Flange Screw, 1/2"-13 x 0.75"
2	350372	Nut Clamp Plate
3	350453	Gap Filler Plate
4	350456	Idler Backing Plate for Standard Belts
	350369	Idler Backing Plate for High Strength Belts
5	350457	Cover Plate for Standard Belts - Right Hand
	350448	Cover Plate for High Strength Belts - Right Hand
6	350458	Cover Plate for Standard Belts - Left Hand
	350449	Cover Plate for High Strength Belts - Left Hand
7	350459-WW	Crossmember for Standard Belts
	350366-WW	Crossmember for High Strength Belts
8	350460-WW	Idler Tube for Standard Belts
	350367-WW	Idler Tube for High Strength Belts
9	350461-WW	Tube Spacer for Standard Belts
	350452-WW	Tube Spacer for High Strength Belts

Item	Part Number	Description
10	350564	Filler Plate for Standard Belts - Right Hand
	350560	Filler Plate for High Strength Belts - Right Hand
11	350565	Filler Plate for Standard Belts - Left Hand
	350561	Filler Plate for High Strength Belts - Left Hand
12	350452-END	End Tube Spacer for High Strength Belts Only
13	506296	Idler Puck
14	911016M	Button Head Screw, M10-1.50 x 16 mm
15	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
16	930516M	Flat Head Screw, M5-.80 x 16 mm
17	32CCESK-WW	Idler Spindle Kit for Standard Belts (Includes items 1, 8, 9, & 13)
	32CCESKH-WW	Idler Spindle Kit for High Strength Belts (Includes items 1, 8, 9, 12, & 13)
WW = Conveyor width reference: 06 – 36 in 02 increments		

Quantity Chart			
Conveyor Width	**Item # 3 Gap Filler Plate**	**Item # 9 Tube Spacer**	**Item # 12 Idler Puck**
6”	2	1	2
8”	2	2	3
10”	2	2	3
12”	2	2	3
14”	3	3	4
16”	3	3	4
18”	3	3	4
20”	4	4	5
22”	4	4	5
24”	4	4	5
26”	5	5	6
28”	5	5	6
30”	5	5	6
32”	6	6	7
34”	6	6	7
36”	7	7	8

Service Parts

Idler Roller Transfer Tail Assembly



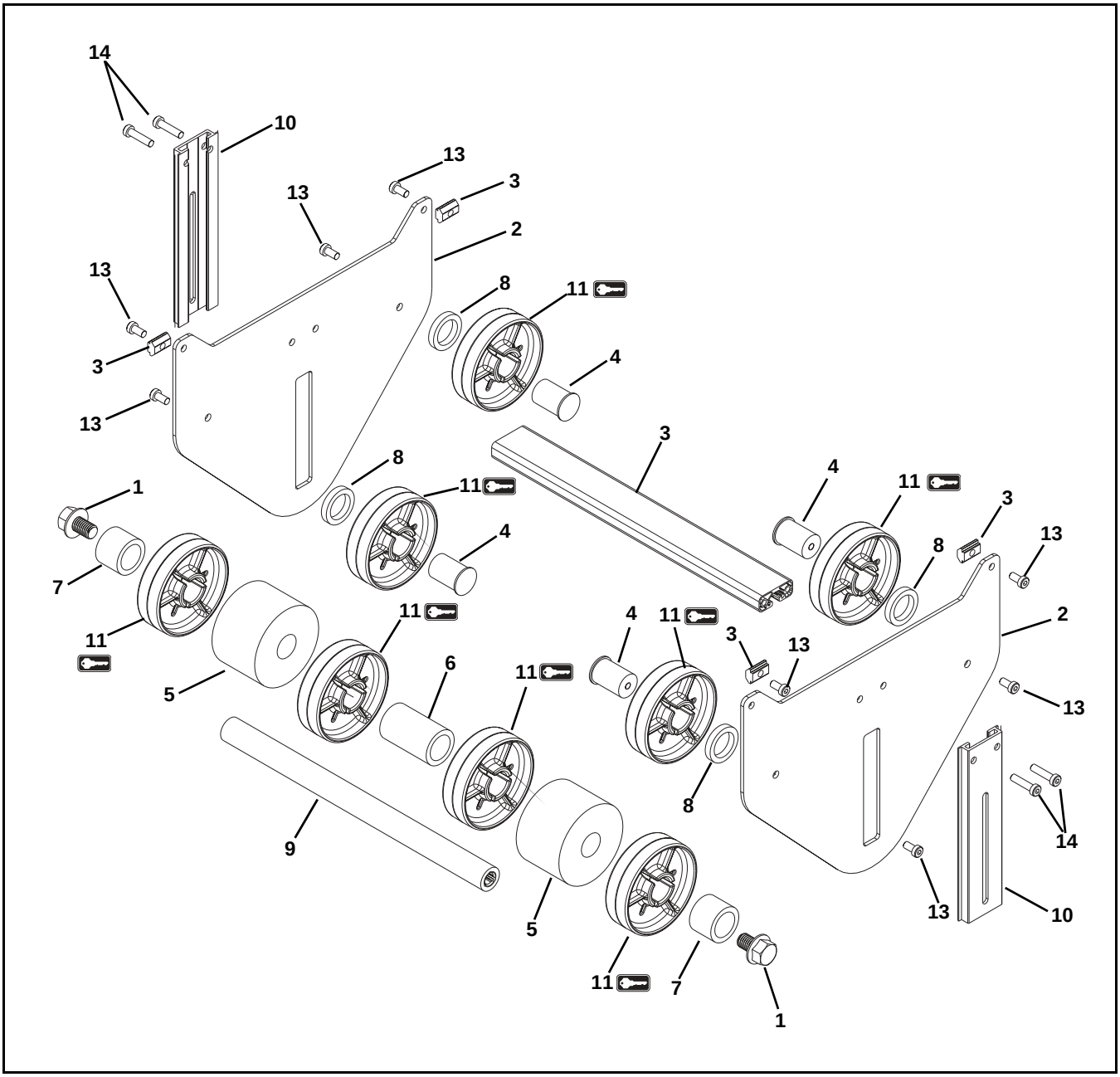
Item	Part Number	Description
1	807-1829	3" Transfer Roller
2	807-1830	6" Transfer Roller
3	807-2278	Hex Flange Screw, 1/2"-13 x 0.75"
4	350372	Nut Clamp Plate
5	350453	Gap Filler Plate
6	350456	Idler Backing Plate for Standard Belts
	350369	Idler Backing Plate for High Strength Belts
7	350459-WW	Crossmember for Standard Belts
	350366-WW	Crossmember for High Strength Belts
8	350460-WW	Idler Tube for Standard Belts
	350367-WW	Idler Tube for High Strength Belts
9	350461-WW	Tube Spacer for Standard Belts
	350452-WW	Tube Spacer for High Strength Belts
10	350452-END	End Tube Spacer for High Strength Belts Only
11	350564	Filler Plate for Standard Belts - Right Hand
	350560	Filler Plate for High Strength Belts - Right Hand
12	350565	Filler Plate for Standard Belts - Left Hand
	350561	Filler Plate for High Strength Belts - Left Hand

Item	Part Number	Description
13	350660-WW	Roller Transfer Support Bracket for Standard Belts
	350544-WW	Roller Transfer Support Bracket for High Strength Belts
14	350665	Cover Plate Right Hand for Standard Belt
	350598	Cover Plate Right Hand for High Strength Belts
15	350666	Cover Plate Left Hand for Standard Belts
	350599	Cover Plate Left Hand for High Strength Belts
16	506296	Idler Puck
17	911016M	Button Head Screw, M10-1.50 x 16 mm
18	920406M	Socket Head Screw, M4-.70 x 6 mm for High Strength Belts Only
19	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
20	930516M	Flat Head Screw, M5-.80 x 16 mm
21	32CCESK-WW	Idler Spindle Kit for Standard Belts (Includes items 3, 8, 9, & 16)
	32CCESKH-WW	Idler Spindle Kit for High Strength Belts (Includes items 3, 8, 9, 10, & 16)
WW = Conveyor width reference: 06 – 36 in 02 increments		

Quantity Chart							
Conveyor Width	**Item # 5 Gap Filler Plate**	**Item # 9 Tube Spacer**	**Item # 16 Idler Puck**	**Item # 1 3" Transfer Roller for Standard Belts**	**Item # 1 3" Transfer Roller for High Strength Belts**	**Item # 2 6" Transfer Roller for Standard Belts**	**Item # 2 6" Transfer Roller for High Strength Belts**
6”	2	1	2	N/A	2	N/A	0
8”	2	2	3	1	N/A	1	N/A
10”	2	2	3	3	N/A	0	N/A
12”	2	2	3	1	1	2	2
14”	3	3	4	0	N/A	3	N/A
16”	3	3	4	2	N/A	2	N/A
18”	3	3	4	0	0	4	4
20”	4	4	5	2	N/A	3	N/A
22”	4	4	5	5	N/A	1	N/A
24”	4	4	5	3	3	3	3
26”	5	5	6	1	N/A	5	N/A
28”	5	5	6	3	N/A	4	N/A
30”	5	5	6	6	9	2	0
32”	6	6	7	4	N/A	4	N/A
34”	6	6	7	2	N/A	6	N/A
36”	7	7	8	1	N/A	7	N/A

Service Parts

Weighted Take-Up Assembly

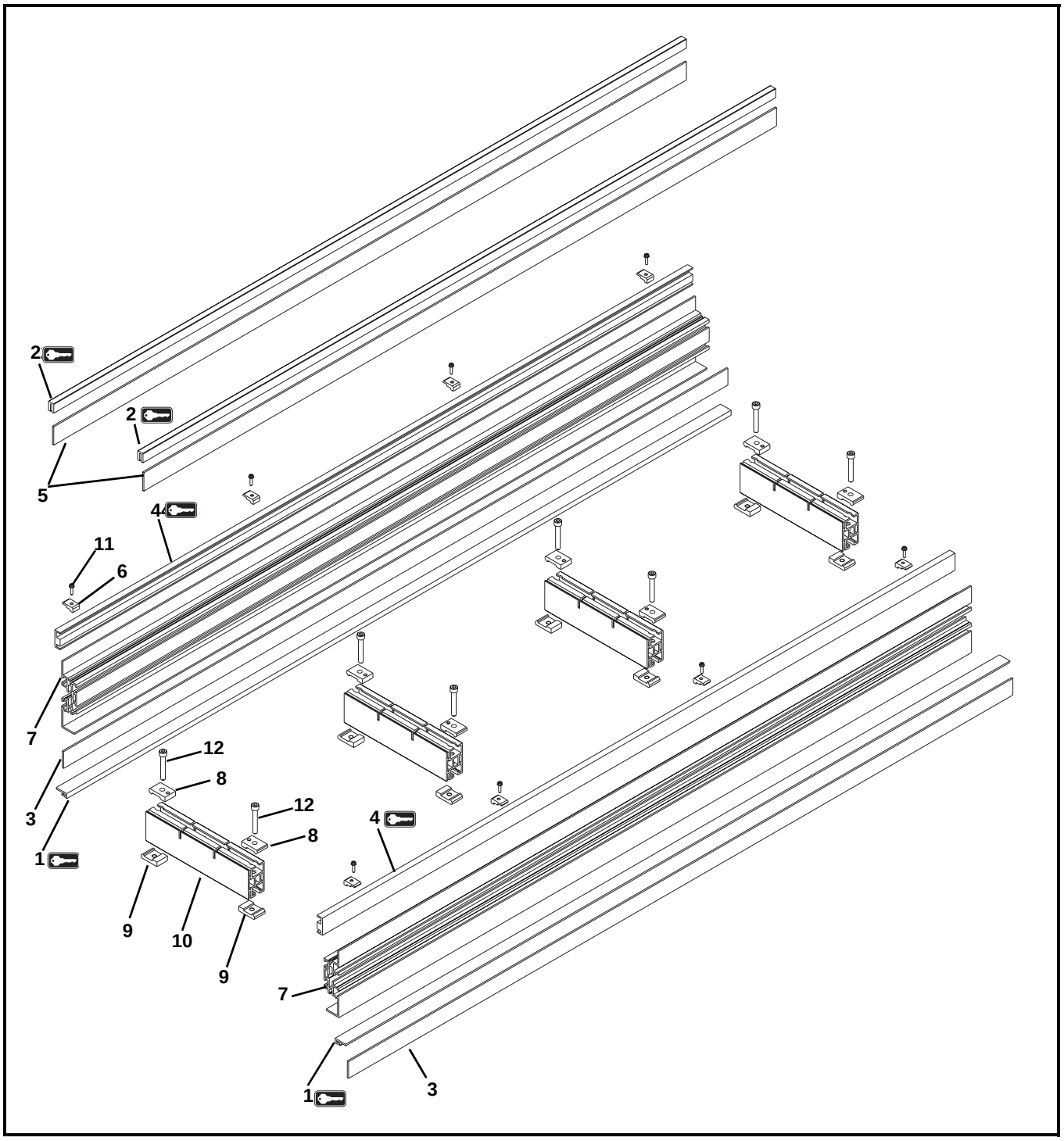


Item	Part Number	Description
1	807-2383	Hex Flange Screw, 1/2"-13 x 0.75"
2	350469	Weighted Take-up Plate
3	350471-WW	Cross Support for Standard Belts
	350470-WW	Cross Support for High Strength Belts
4	350472	Idler Stub
5	350473	Weight
6	350474-WW	Mid Spacer Tube for Standard Belts
	350802-WW	Mid Spacer Tube for High Strength Belts
7	350474-WW	Outer Spacer Tube for Standard Belts
	350802-R	Outer Spacer Tube for High Strength Belts
8	350474-STUB	Stub Spacer
9	350475-WW	Tube for Standard Belts
	350468-WW	Tube for High Strength Belts
10	350524	Cover
11	506296	Idler Puck
12	639971M	Single Drop-In T-Bar
13	950612M	Low Head Cap Screw, M6-1.00 x 12 mm
14	950625M	Low Head Cap Screw, M6-1.00 x 25 mm
WW = Conveyor Width Reference: 06 - 36 in 02 increments		

Quantity Chart			
Conveyor Width	**Item # 5 Weight**	**Item # 6 Mid Spacer Tube**	**Item # 11 Idler Puck**
6”	1	0	6
8”	2	0	6
10”	2	0	8
12”	2	1	8
14”	2	1	8
16”	4	1	8
18”	4	1	10
20”	4	1	10
22”	4	1	10
24”	4	1	10
26”	4	1	10
28”	4	1	10
30”	4	1	10
32”	4	1	10
34”	4	1	10
36”	4	1	10

Service Parts

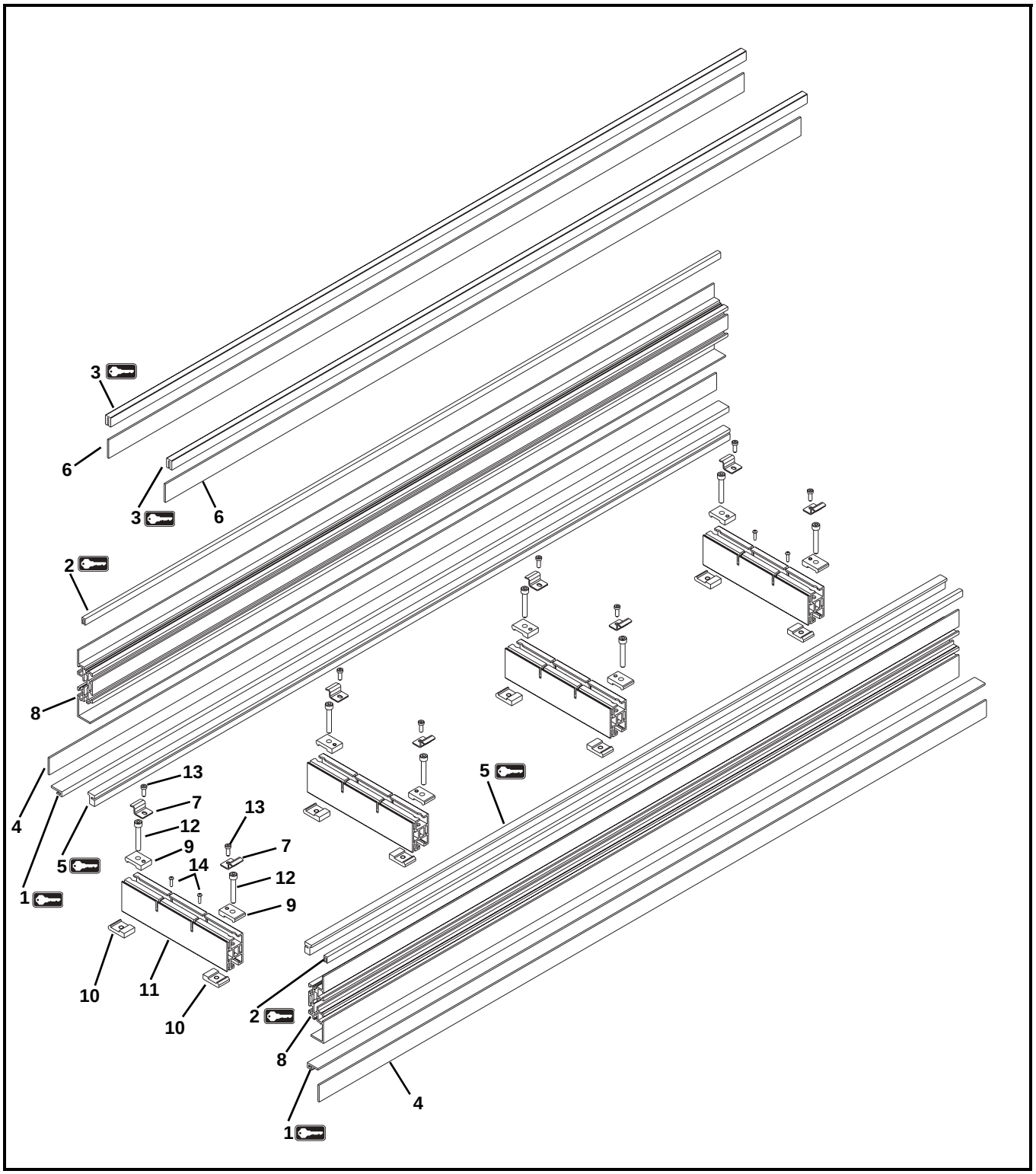
Straight Frame Assembly for Standard Belts



Item	Part Number	Description
1	350900-LLLLL	J-Leg Wear Strip
2	350899-LLLLL	Clip On Wear Strip
3	807-2303	Lower Vertical Wear Strip
4	350338-LLLLL	Outer Top Wear Strip
5	350341-LLLLL	Support Wear Strip
6	350342	Retaining Clip
7	350307-LLLLL	T-Slot Side Rail
	350319-LLLLL	SmartSlot Side Rail
8	350309	Top Clip
9	350310	Bottom Clip
10	350327-WW	Crossmember
11	920484M	Flange Screw, M4-.70 x 16 mm
12	920850M	Socket Head Screw, M8-1.25 x 25 mm
WW = Conveyor width reference: 06 – 36 in 02 increments		
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

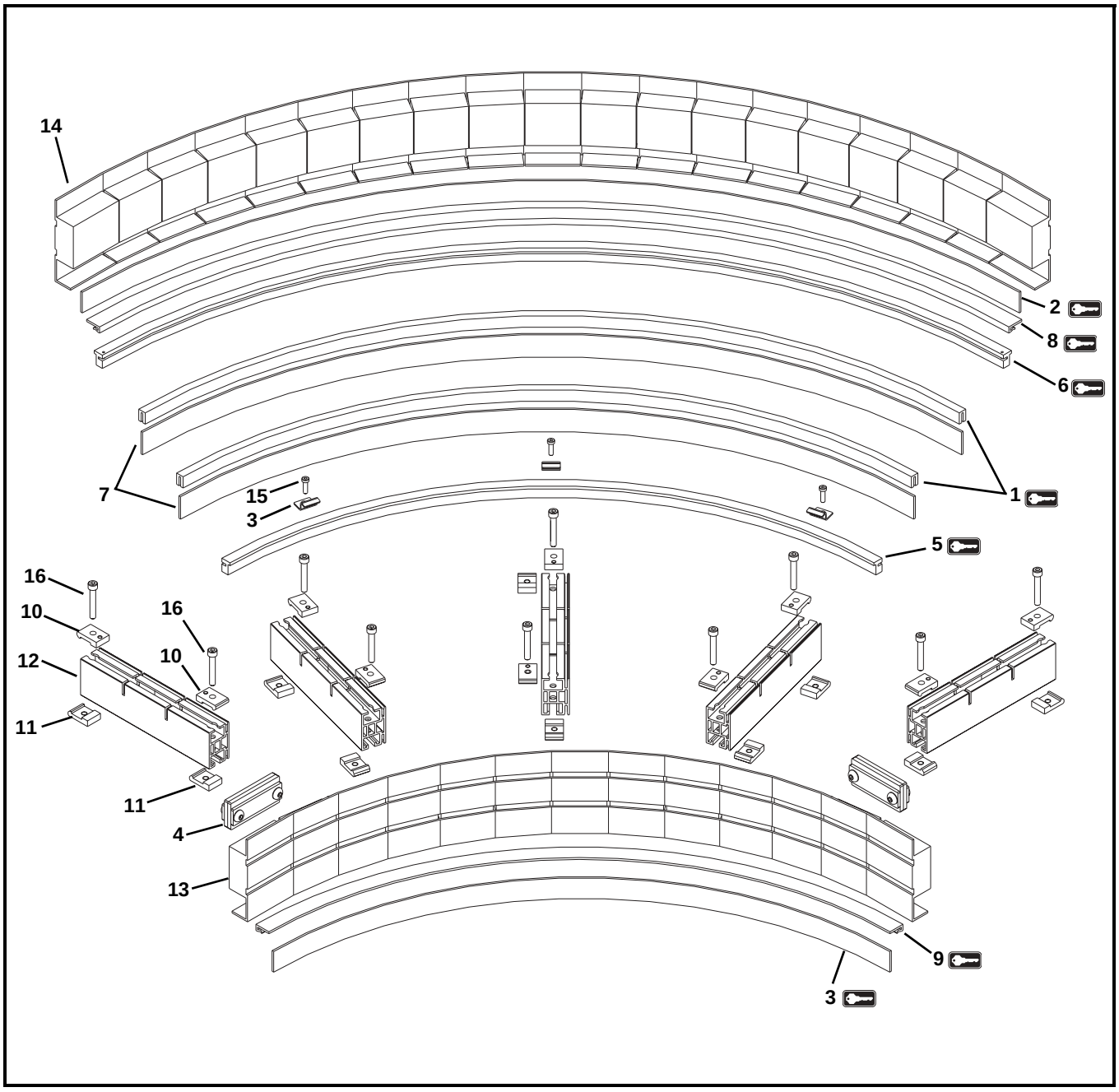
Straight Frame Assembly for High Strength Belts



Item	Part Number	Description
1	350900-LLLLL	J-Leg Wear Strip
2	807-1810	Snap On Edge Wear Strip
3	350899-LLLLL	Clip On Wear Strip
4	807-2303	Lower Vertical Wear Strip
5	350340-LLLLL	Outer Top Wear Strip
6	350341-LLLLL	Support Wear Strip
7	350347	Retaining Clip
8	350307-LLLLL	T-Slot Side Rail
	350319-LLLLL	SmartSlot Side Rail
9	350309	Top Clip
10	350310	Bottom Clip
11	350328-WW	Crossmember
12	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
13	920850M	Socket Head Screw, M8-1.25 x 25 mm
14	910416M	Button Head Screw, M4-0.70 x 16 mm
WW = Conveyor width reference: 06 – 36 in 02 increments		
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

Curve Frame Assembly for Standard Belts

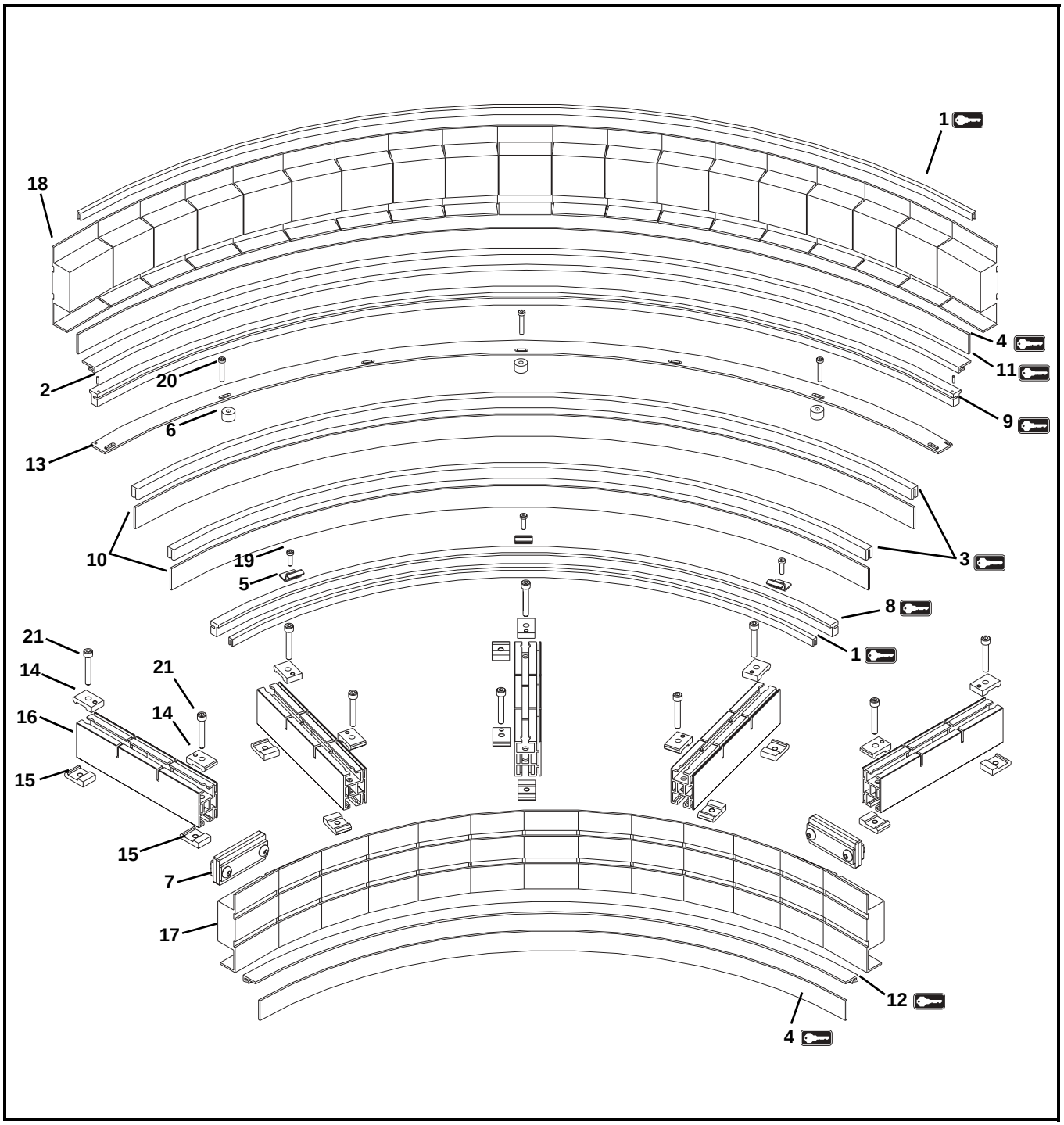


Item	Part Number	Description
1	350889-LLLLL	Clip On Mid Wear Strip
2	807-2303	Lower Vertical Wear Strip
3	350342	Retaining Clip
4	350701	Connector Assembly
5	350338-LLLLL	Top Inner Wear Strip
6	350338-LLLLL	Top Outer Wear Strip
7	350341-LLLLL	Supports
8	350535-LLLLL	Outer J-Leg Wear Strip (Slitted), for Conveyors 12" wide or less
	350900-LLLLL	Outer J-Leg Wear Strip (Non-Slitted), for Conveyors over 12" wide
9	350535-LLLLL	Inner J-Leg Wear Strip (Slitted), for Conveyors 12" wide or less
	350900-LLLLL	Inner J-Leg Wear Strip (Non-Slitted), for Conveyors over 12" wide

Item	Part Number	Description
10	350309	Top Clip
11	350310	Bottom Clip
12	350327-WW	Crossmember
13	350781-WWxAA	Inner T-Slot Side Rail
	350785-WWxAA	Inner SmartSlot Side Rail
14	350782-WWxAA	Outer T-Slot Side Rail
	350786-WWxAA	Outer SmartSlot Side Rail
15	920484M	Flange Screw, M4-0.70 x 16 mm
16	920850M	Socket Head Screw, M8-1.25 x 25 mm
WW = Conveyor width reference: 06 – 36 in 02 increments		
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		
AA = Degree of Curve: 45, 90, 180		

Service Parts

Curve Frame Assembly for High Strength Belts

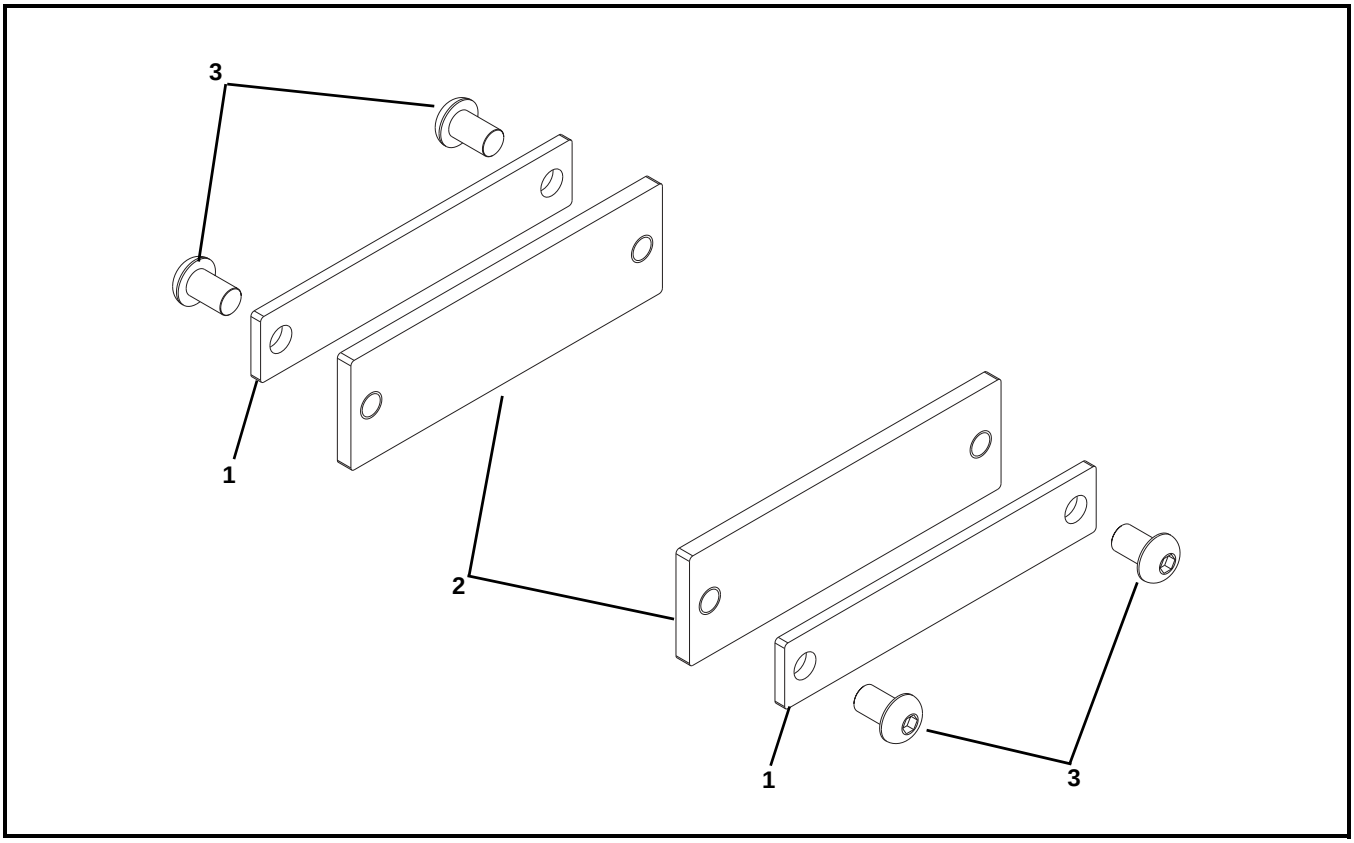


Item	Part Number	Description
1	807-1810	Snap On Edge Wear Strip
2	807-2203	Dowel Pin
3	350899-LLLLL	Clip On Wear Strip
4	807-2303	Lower Vertical Wear Strip
5	350347	Retaining Clip
6	350343	Top Spine Spacer
7	350701	Connector Assembly
8	350340-LLLLL	Top Inner Wear Strip
9	350339-LLLLL	Top Outer Wear Strip for High Strength Belts with Tabs
	350492-LLLLL	Top Outer Wear Strip for High Strength Belts with Bearings
10	350341-LLLLL	Supports
11	350535-LLLLL	Outer J-Leg Wear Strip (Slitted), for Conveyors 12" wide or less
	350900-LLLLL	Outer J-Leg Wear Strip (Non-Slitted), for Conveyors over 12" wide
12	350535-LLLLL	Inner J-Leg Wear Strip (Slitted), for Conveyors 12" wide or less
	350900-LLLLL	Inner J-Leg Wear Strip (Non-Slitted), for Conveyors over 12" wide

Item	Part Number	Description
13	350756-WWxAA	Spine Plate
14	350309	Top Clip
15	350310	Bottom Clip
16	350328-WW	Crossmember
17	350777-WWxAA	Inner T-Slot Side Rail
	350783-WWxAA	Inner SmartSlot Side Rail
18	350778-WWxAA	Outer T-Slot Side Rail
	350784-WWxAA	Outer SmartSlot Side Rail
19	950620M	Low Head Cap Screw, M6-1.00 x 20 mm
20	950635M	Low Head Cap Screw, M6-1.00 x 35 mm
21	920850M	Socket Head Screw, M8-1.25 x 25 mm
WW = Conveyor width reference: 06 – 36 in 02 increments		
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		
AA = Degree of Curve: 45, 90, 180		

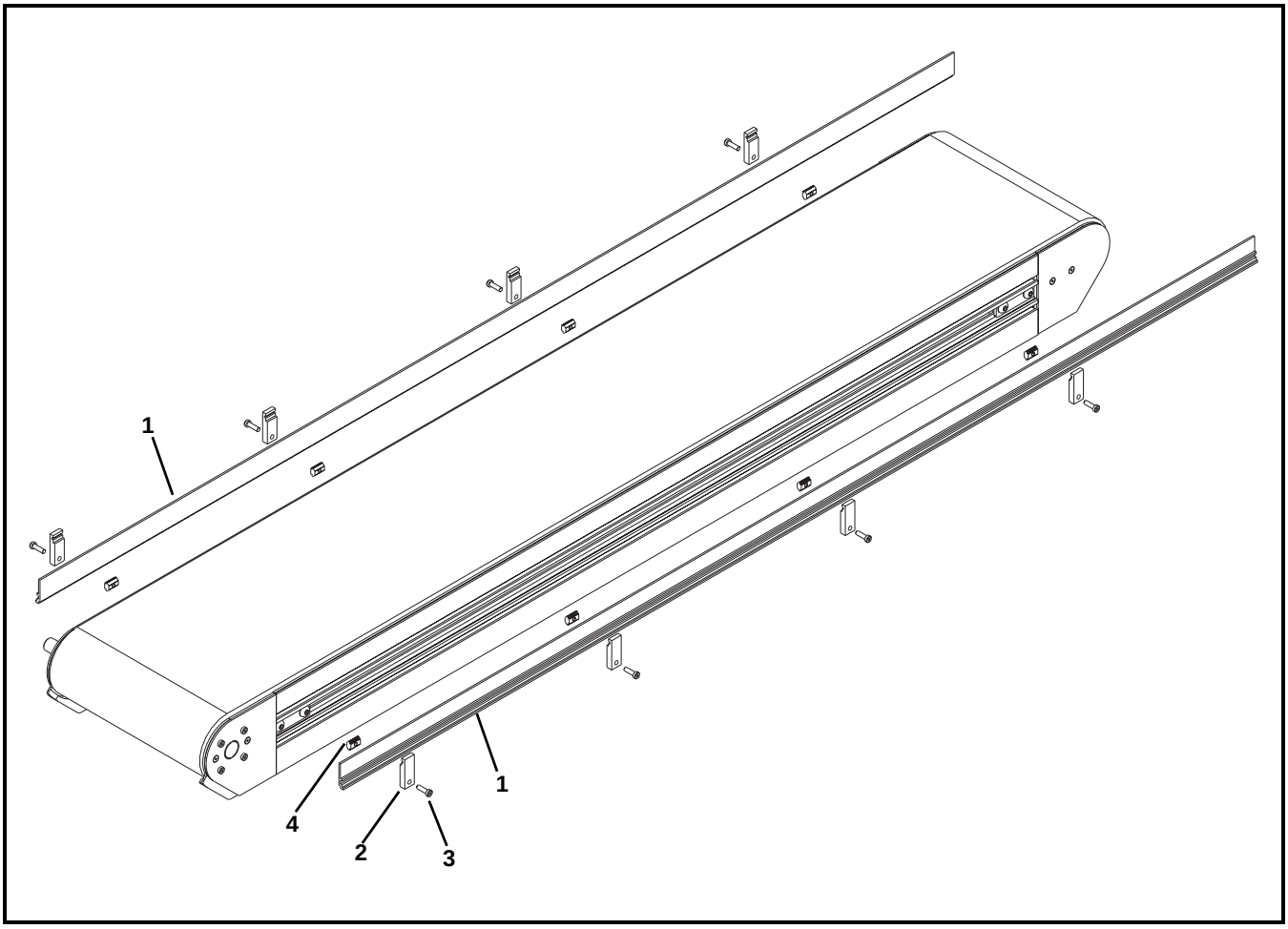
Service Parts

Connecting Assembly



Item	Part Number	Description
1	350580	Cover Plate
2	350581	Clamp Plate for T-Slot Frames
	350808	Clamp Plate for SmartSlot Frames
3	911014M	Button Head Screw, M10-1.50 x 14 mm

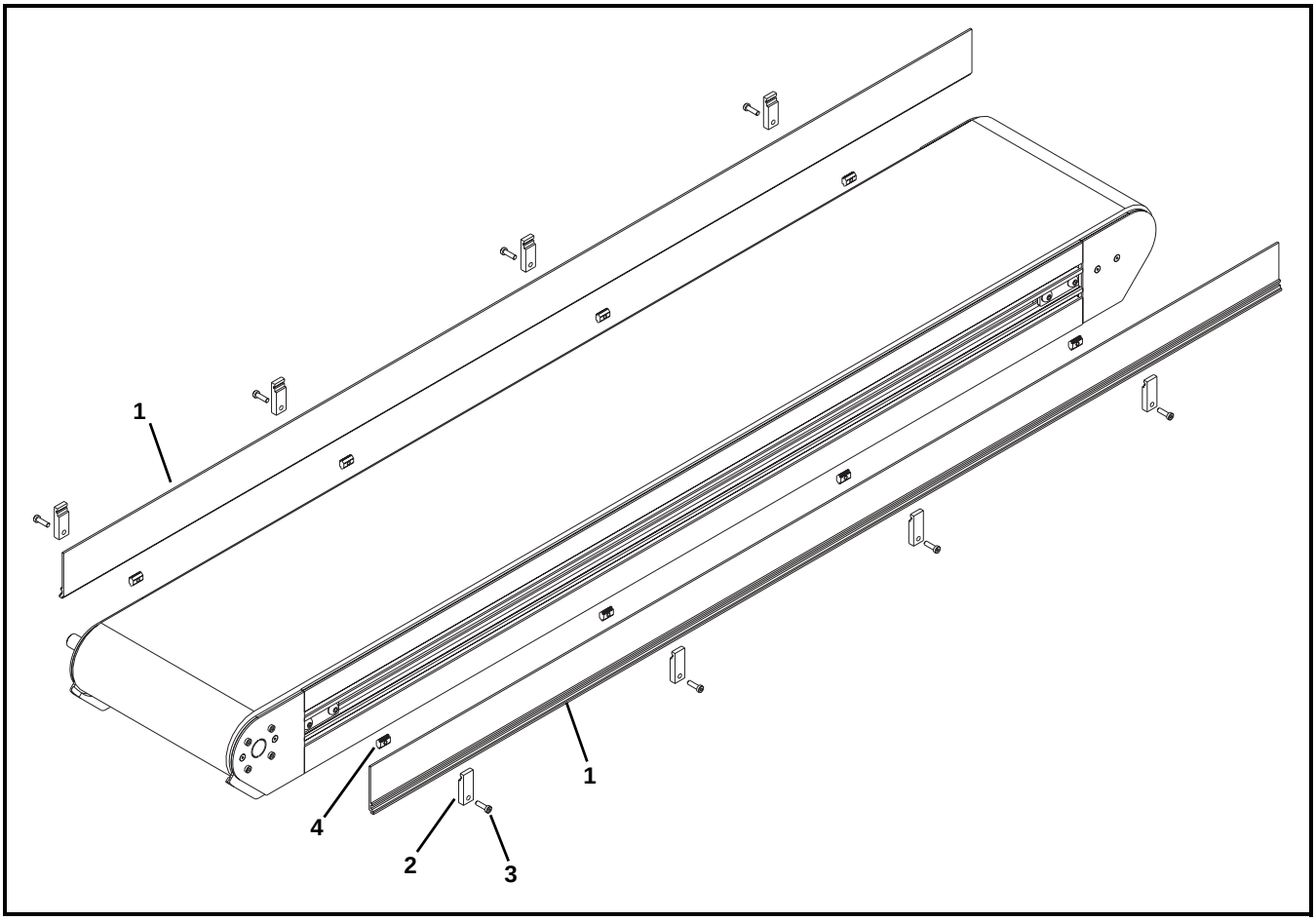
1.5” (38 mm) High Sides



Item	Part Number	Description
1	380500-LLLLL	1.50" Guides
2	350491	Guide Clip
3	950620M	Low Head Cap Screw, M6-1.00 x 20 mm for T-Slot Frames
	807-1937	Self-Drilling Hex Head Screw, 1/4-20 x 1" For SmartSlot Frames
4	639971MK10	Single Drop-In Tee Bar (x10)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

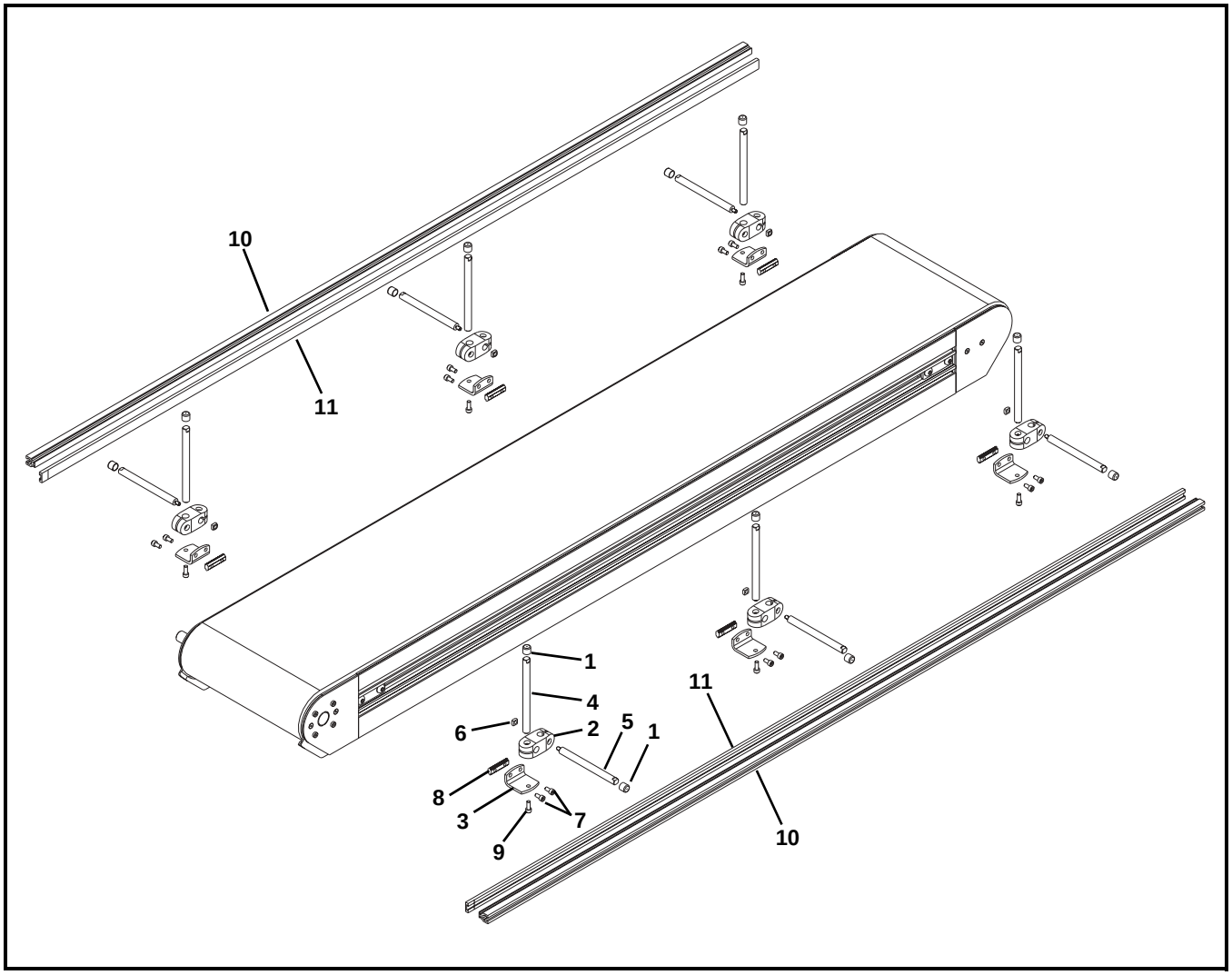
Service Parts

3” (76 mm) High Sides



Item	Part Number	Description
1	380400-LLLLL	3.00" Guides
2	350491	Guide Clip
3	950620M	Low Head Cap Screw, M6-1.00 x 20 mm for T-Slot Frames
	807-1937	Self-Drilling Hex Head Screw, 1/4-20 x 1" For SmartSlot Frames
4	639971MK10	Single Drop-In Tee Bar (x10)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

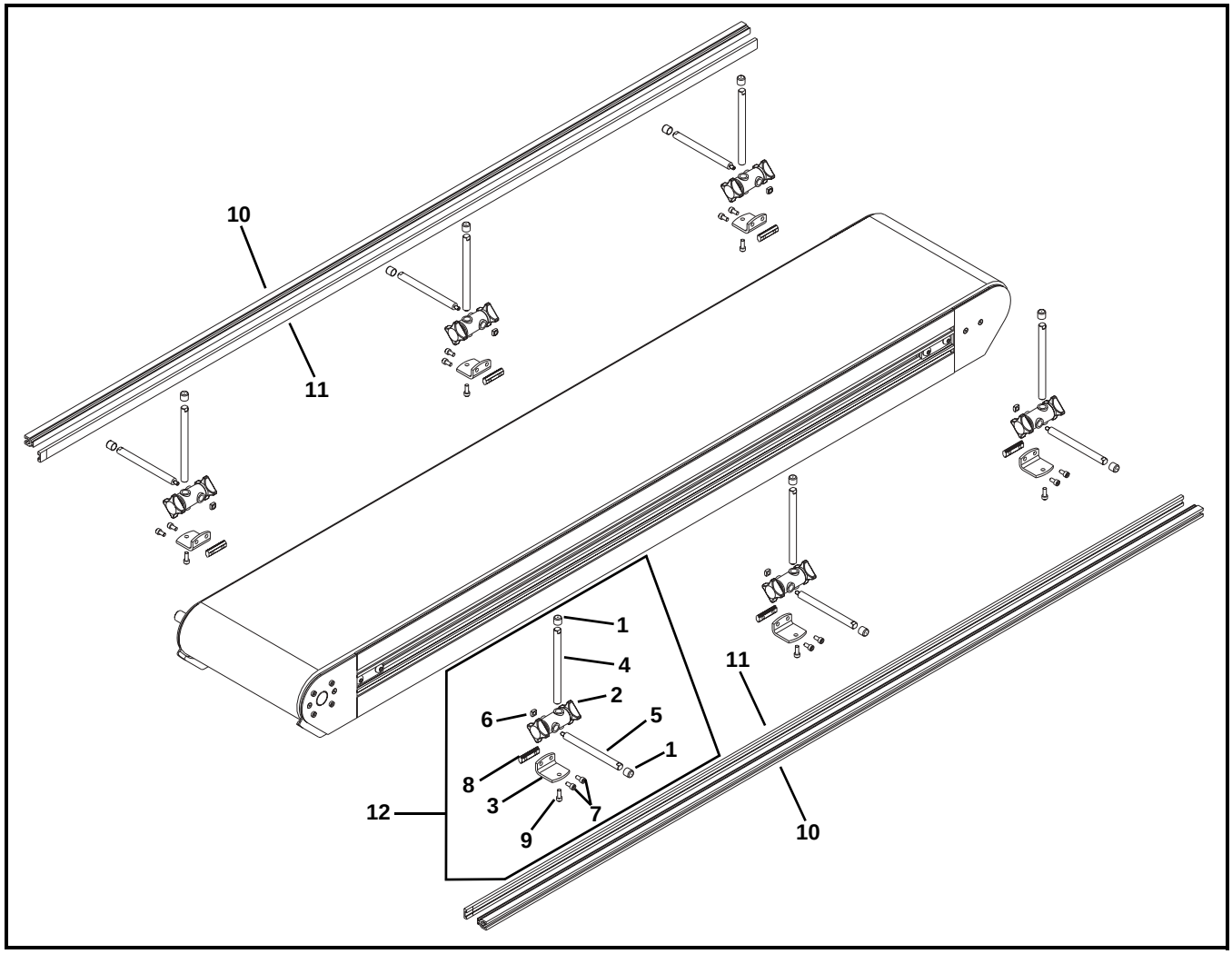
Fully Adjustable Guiding



Item	Part Number	Description
1	807-948	Shaft Cap
2	807-652	Cross Block
3	202004	Mounting Bracket
4	202027M	Vertical Mounting Guide Shaft
5	202028M	Horizontal Mounting Guide Shaft
6	674175MP	Square Nut, M6-1.00
7	920612M	Socket Head Screw, M6-1.00 x 12 mm for T-Slot Frames
	807-1937	Self-Drilling Hex Head Screw, 1/4-20 x 1" For SmartSlot Frames
8	200830M	Drop-In Tee Bar for T-Slot Frames Only
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	460063-LLLLL	Aluminum Profile Guide
11	614068P-LLLLL	Extruded Guide
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

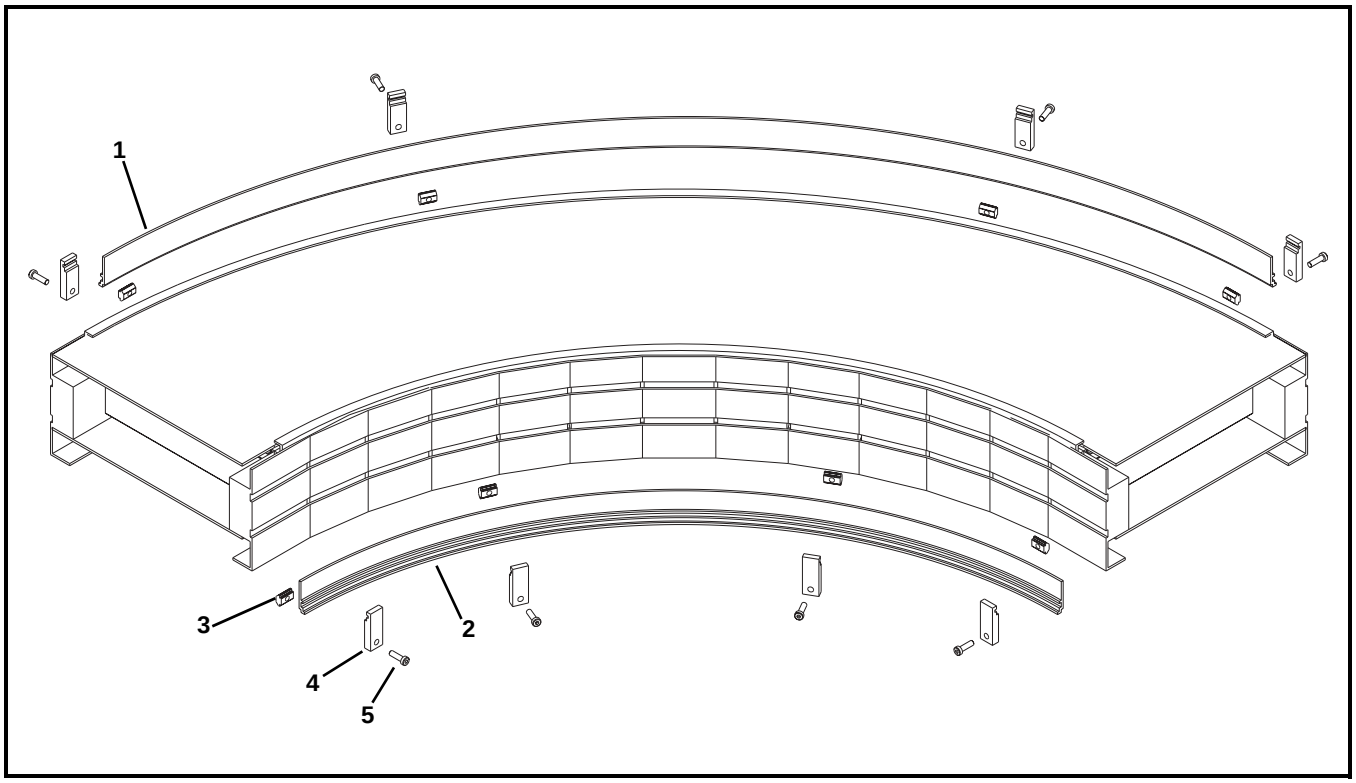
Service Parts

Tool-Less Fully Adjustable Guiding



Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	202004	Mounting Bracket
4	202027M	Vertical Mounting Guide Shaft
5	202028M	Horizontal Mounting Guide Shaft
6	674175MP	Square Nut, M6-1.00
7	920612M	Socket Head Screw, M6-1.00 x 12 mm for T-Slot Frames
	807-1937	Self-Drilling Hex Head Screw, 1/4-20 x 1" For SmartSlot Frames
8	200830M	Drop-In Tee Bar for T-Slot Frames Only
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	460063-LLLLL	Aluminum Profile Guide
11	614068P-LLLLL	Extruded Guide
12	352056	Tool-Less Guiding Assembly for T-Slot Frames (Includes items 1 thru 9)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

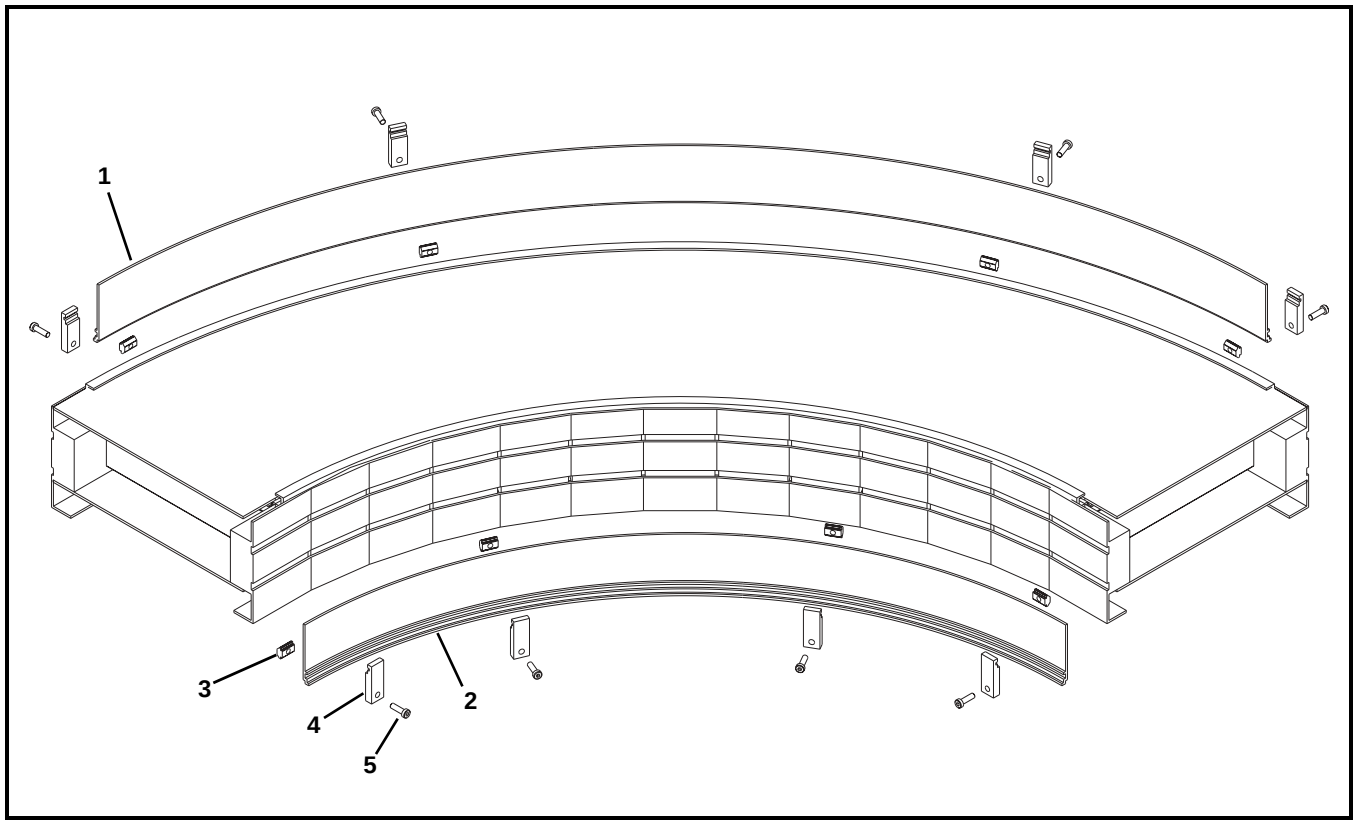
1.5” (38 mm) High Sides for Curve Module



Item	Part Number	Description
1	350905-WWxAA	1.50" Outer Curve Guide
2	350901-WWxAA	1.50" Inner Curve Guide
3	639971MK10	Single Drop-In Tee Bar (x10) for T-Slot Frames Only
4	350491	Guide Clip
5	950620M	Low Head Cap Screw, M6-1.00 x 20 mm
WW = Conveyor width reference: 06 – 36 in 02 increments		
AA = Degree of Curve: 45, 90, 180		

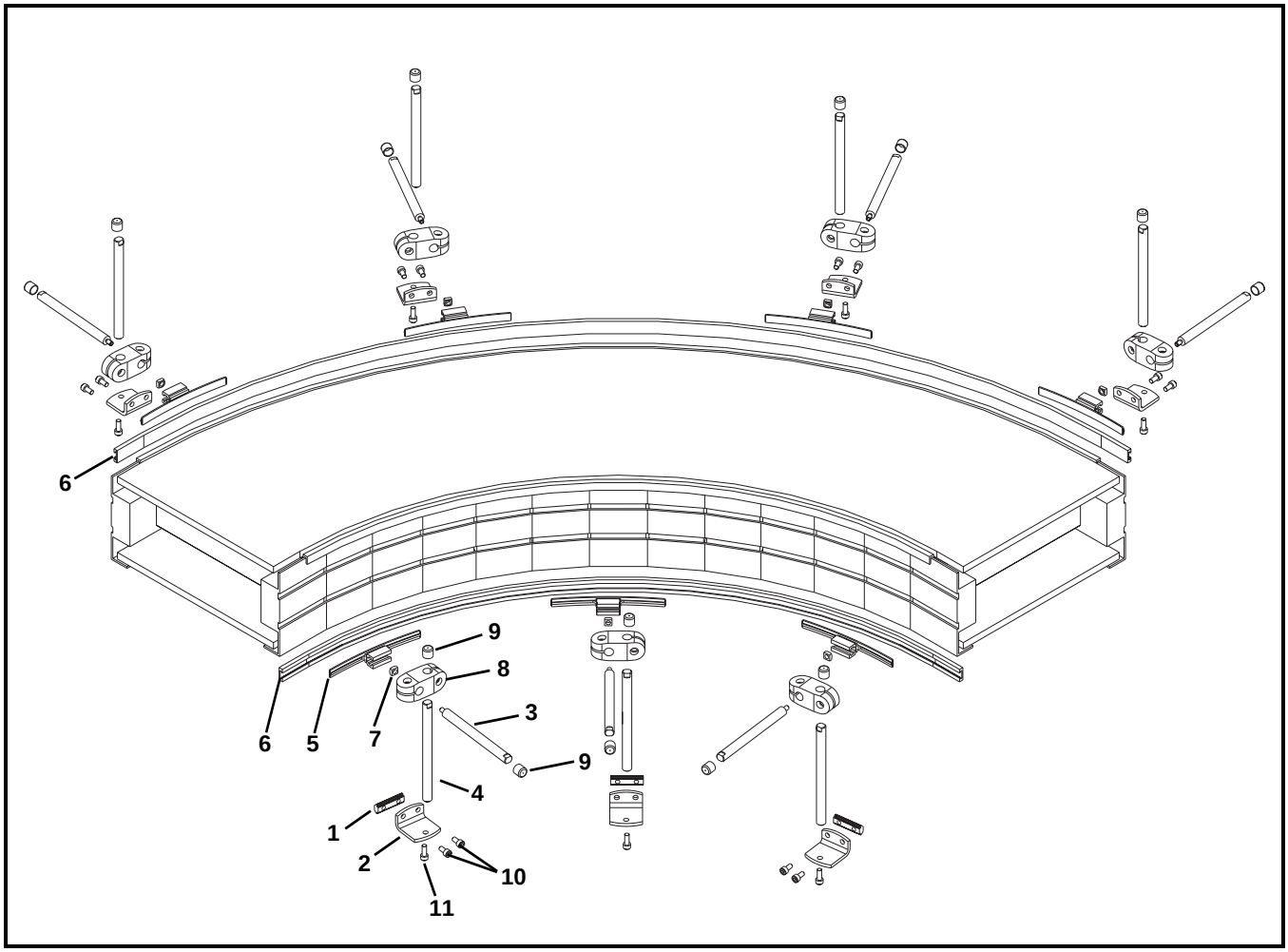
Service Parts

3” (76 mm) High Sides for Curve Module



Item	Part Number	Description
1	350906-WWxAA	3.00" Outer Curve Guide
2	350902-WWxAA	3.00" Inner Curve Guide
3	639971MK10	Single Drop-In Tee Bar (x10) for T-Slot Frames Only
4	350491	Guide Clip
5	950620M	Low Head Cap Screw, M6-1.00 x 20 mm
WW = Conveyor width reference: 06 – 36 in 02 increments		
AA = Degree of Curve: 45, 90, 180		

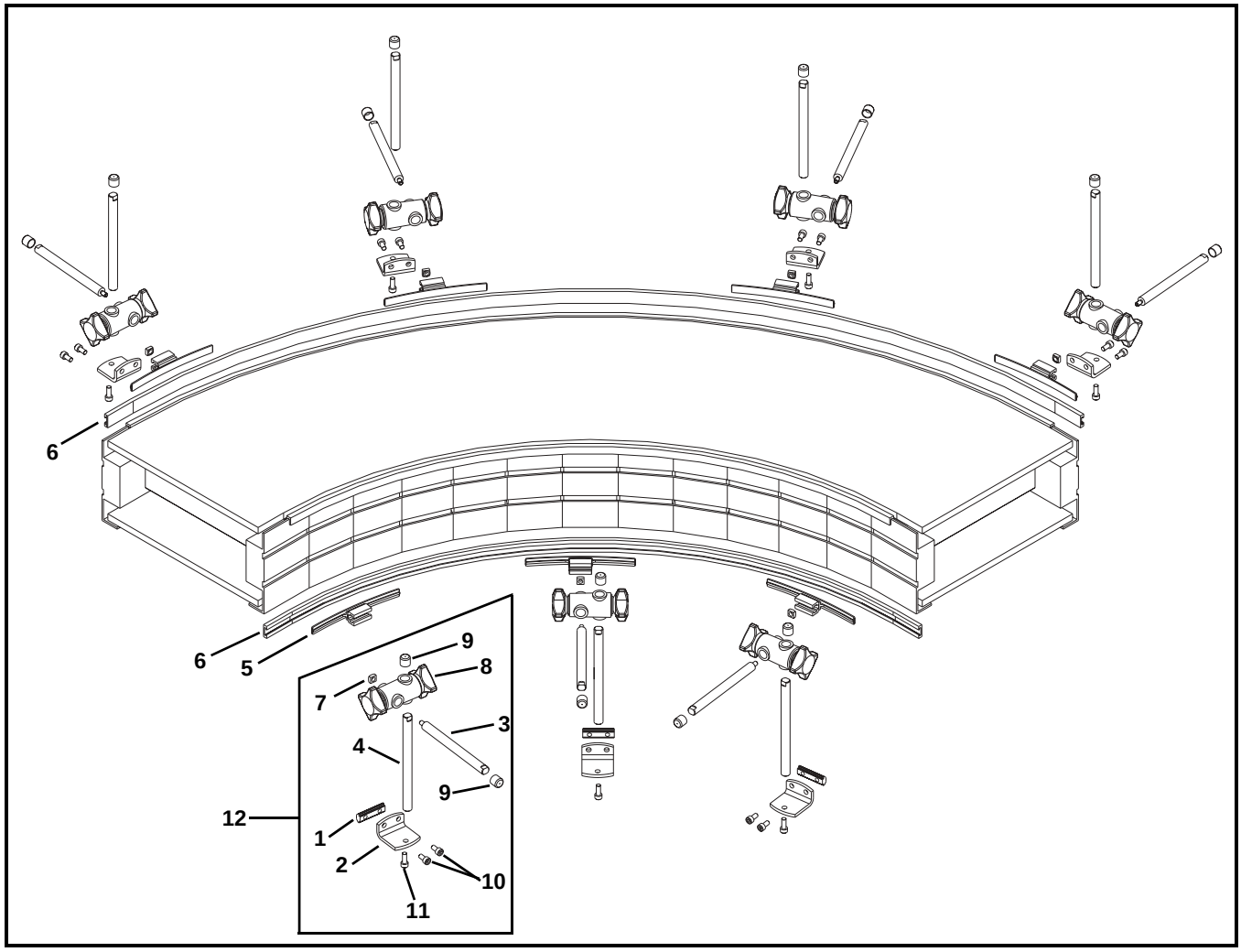
Fully Adjustable Guiding for Curve Module



Item	Part Number	Description
1	200830M	Drop-In Tee Bar for T-Slot Frames Only
2	202004M	Mounting Bracket
3	202027M	Vertical Mounting Guide Shaft
4	202028M	Horizontal Mounting Guide Shaft
5	203494	Guide Support
6	614068P-LLLLL	Guiding
7	674175MP	Square Nut
8	807-652	Cross Block
9	807-948	Shaft Cap
10	920612M	Socket Head Screw, M6-1.00 x 12 mm for T-Slot Frame
	807-1937	Self-Drilling Hex Head Screw, M6-1.00 x 12 mm for SmartSlot Frames
11	920616M	Socket Head Screw, M6-1.00 x 16 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

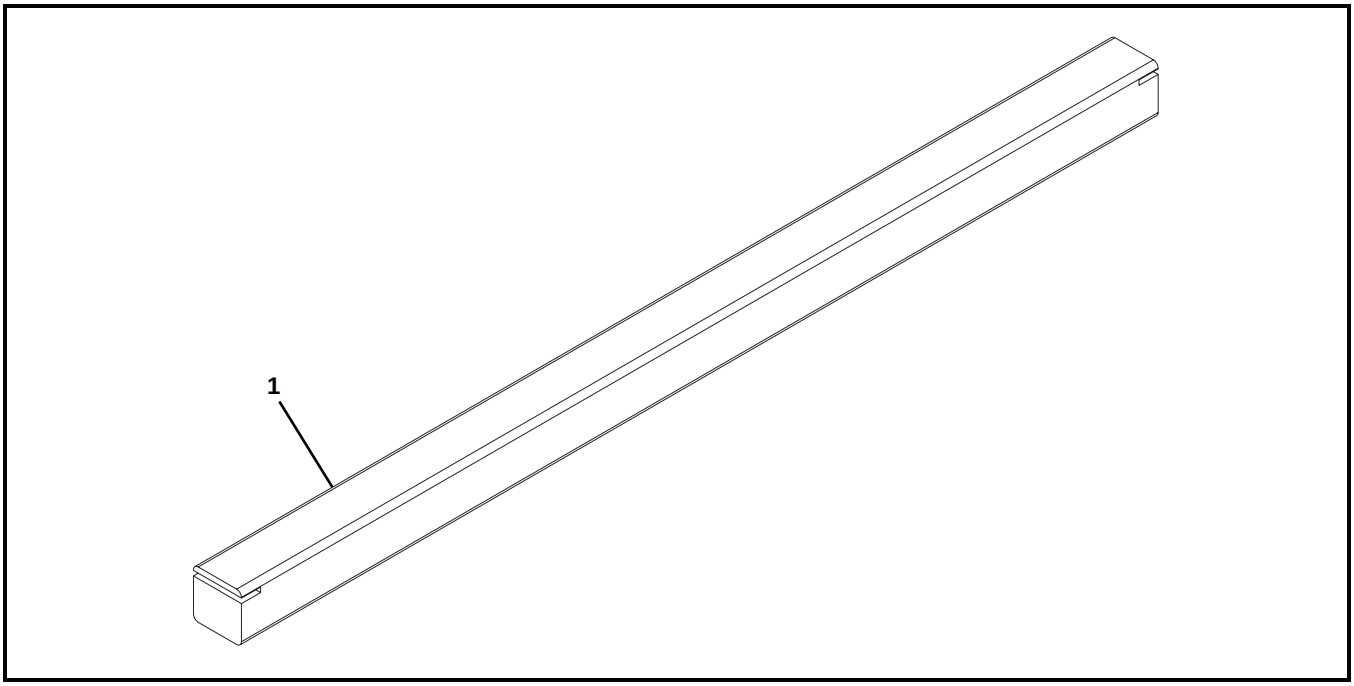
Service Parts

Tool-Less Fully Adjustable Guiding for Curve Module



Item	Part Number	Description
1	200830M	Drop-In Tee Bar for T-Slot Frames Only
2	202004M	Mounting Bracket
3	202027M	Vertical Mounting Guide Shaft
4	202028M	Horizontal Mounting Guide Shaft
5	203494	Guide Support
6	614068P-LLLLL	Guiding
7	674175MP	Square Nut
8	807-1470	Cross Block
9	807-948	Shaft Cap
10	920612M	Socket Head Screw, M6-1.00 x 12 mm for T-Slot Frame
	807-1937	Self-Drilling Hex Head Screw, M6-1.00 x 12 mm for SmartSlot Frames
11	920616M	Socket Head Screw, M6-1.00 x 16 mm
12	352056	Tool-Less Guiding Assembly for T-Slot Frames (Includes items 1 thru 4 and 7 thru 11)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

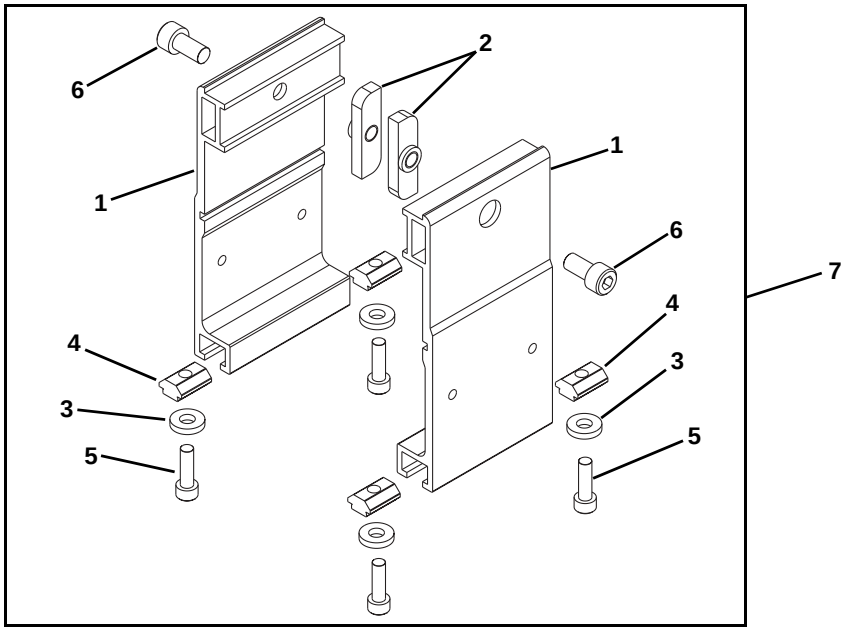
Flat Belt Returns



Item	Part Number	Description
1	350578-WW	Return Bar

Item	Part Number	Description
WW = Conveyor Width Reference: 24 - 36 in 02 increments		

Flat Belt Mounting Brackets for T-Slot Conveyors

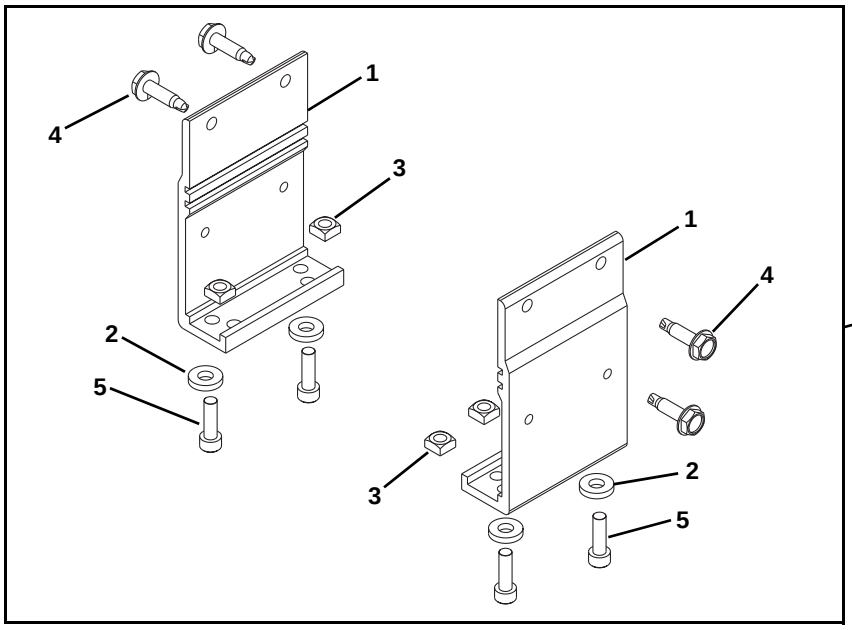


Item	Part Number	Description
1	350533	Stand Mount
2	350534	Nut
3	605279P	Washer
4	639971M	Single Drop-In T-Bar

Item	Part Number	Description
5	920620M	Socket Head Screw, M6-1.00 x 20 mm
6	920816M	Socket Head Screw, M8-1.25 x 16 mm
7	350702	Flat Belt Mounting Assembly for T-Slot Conveyors

Service Parts

Flat Belt Mounting Brackets for SmartSlot Conveyors



Item	Part Number	Description
1	240831	Stand Mount
2	605279P	Washer
3	807-920	Square Nut, M6-1.0
4	807-1937	Drilling Screw, 1/4"-20 x 1"
5	920620M	Socket Head Screw, M6-1.00 x 20 mm
6	715642	Flat Belt Mounting Assembly for SmartSlot Conveyors

Ordering a Replacement Chain

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

Example:

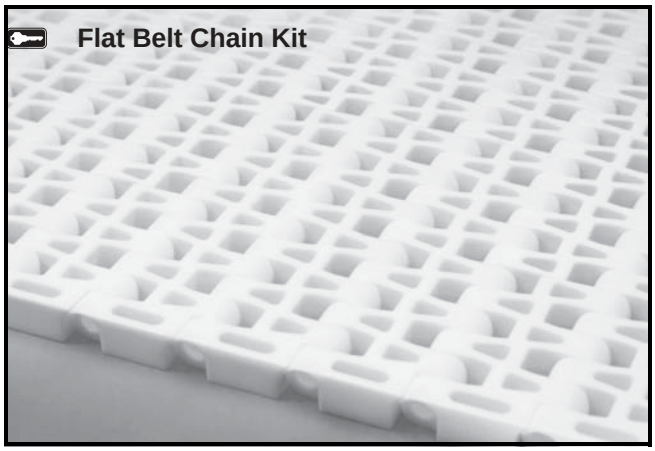
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 52BB-WW

BB = Chain reference number

WW = Conveyor width ref: 08-36 in 02 increments

Flat Belt Chain Repair Kit



Item	Part Number	Description
1	52BB-WW	Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
BB = Chain Reference number		
WW = Conveyor width ref: 06 - 36 in 02 increments		

Notes

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.

<table>
<tr><th></th><th colspan="8">Product Type</th></tr>
<tr><th></th><th colspan="7">Standard Products</th><th>Engineered to order parts</th></tr>
<tr><th>Product Line</th><th>Conveyors</th><th>Gearmotors & Mounting Packages</th><th>Support Stands</th><th>Accessories</th><th>Spare Parts (non-belt)</th><th>Spare Belts - Standard Flat Fabric</th><th>Spare Belts - Cleated & Specialty Fabric</th><th>Spare Belts - Plastic Chain</th><th>All equipment and parts</th></tr>
<tr><td>1100</td><td colspan="6" rowspan="14">30% return fee for all products except:
50% return fee for conveyors with modular belt, cleated belt or specialty belts</td><td colspan="2" rowspan="15">non-returnable</td><td rowspan="15">case-by-case</td></tr>
<tr><td>2200</td></tr>
<tr><td>2200 Modular Belt</td></tr>
<tr><td>2200 Precision Move</td></tr>
<tr><td>2300</td></tr>
<tr><td>2300 Modular Belt</td></tr>
<tr><td>3200</td></tr>
<tr><td>3200 LPZ</td></tr>
<tr><td>3200 Precision Move</td></tr>
<tr><td>4100</td></tr>
<tr><td>5200</td></tr>
<tr><td>5300</td></tr>
<tr><td>6200</td></tr>
<tr><td>Controls</td></tr>
<tr><td>7200 / 7300</td><td colspan="6">50% return fee for all products</td></tr>
<tr><td>7350</td><td colspan="9" rowspan="4">non-returnable</td></tr>
<tr><td>7360</td></tr>
<tr><td>7400</td></tr>
<tr><td>7600</td></tr>
</table>

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.

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

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