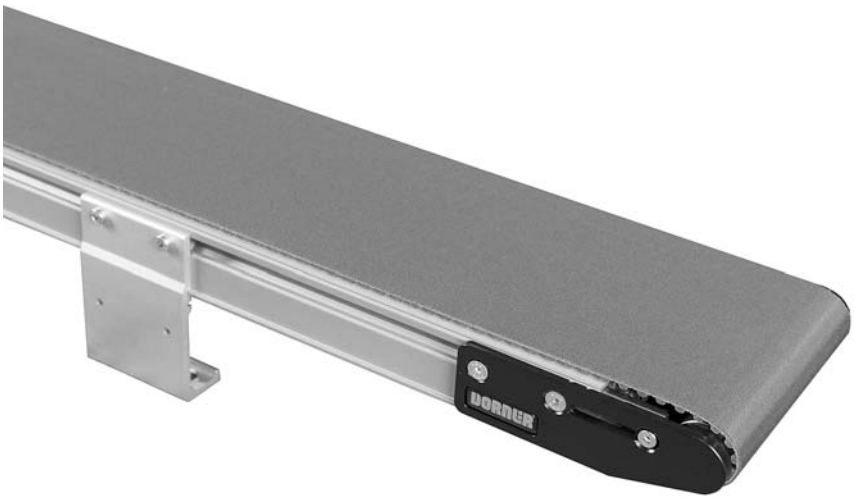
2200 Series Version 2 Precision Move Conveyors

Installation, Maintenance & Parts Manual



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851-817 Rev. A

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IMPORTANT

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.

Dorner's Limited Warranty applies.

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 .

Dorner 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,422,382 and corresponding patents and patent applications in other countries.

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

Warnings – General Safety

⚠ WARNING

The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.

⚠ DANGER

Climbing, sitting, walking or riding on conveyor will cause severe injury. KEEP OFF CONVEYORS.

⚠ DANGER

DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

⚠ WARNING

Gearmotors may be HOT.

DO NOT TOUCH Gearmotors.

⚠ WARNING

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

⚠ WARNING

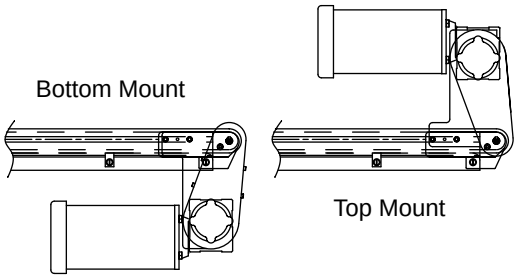
Conveyors are not reversible. Reversing creates pinch points which can cause severe injury.

DO NOT REVERSE CONVEYORS.

⚠ WARNING

Top and Bottom Mount Gearmotors must be mounted as shown below.

Failure to do so creates pinch points which can cause severe injury.



⚠ WARNING

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.

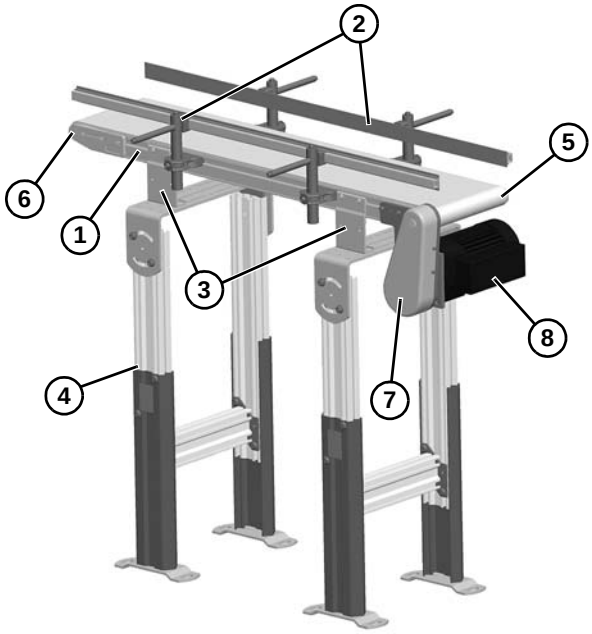
⚠ WARNING

Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.

SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.

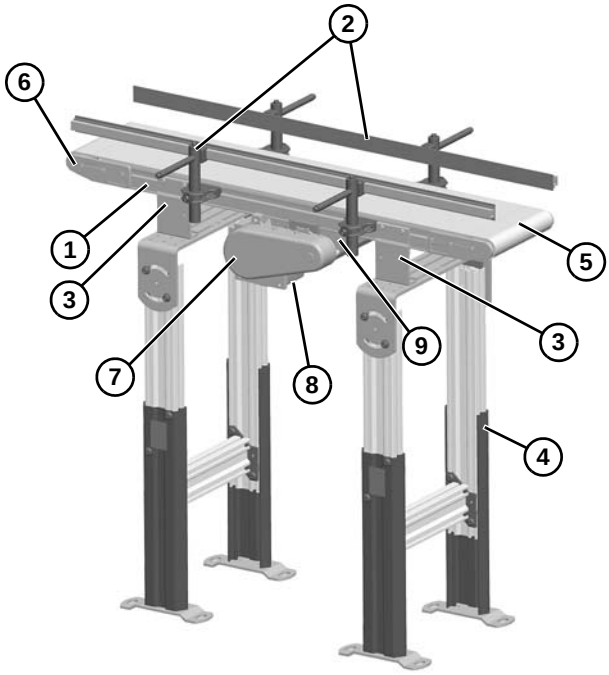
Refer to Figure 1 for typical conveyor components.

1	Conveyor
2	Guiding & Accessories
3	Mounting Brackets
4	Support Stand
5	Drive End
6	Idler/Tension End
7	Gearmotor Mounting Package
8	Gearmotor
9	Center Drive Box (Center Drive Units)



End Drive Conveyor

Figure 1



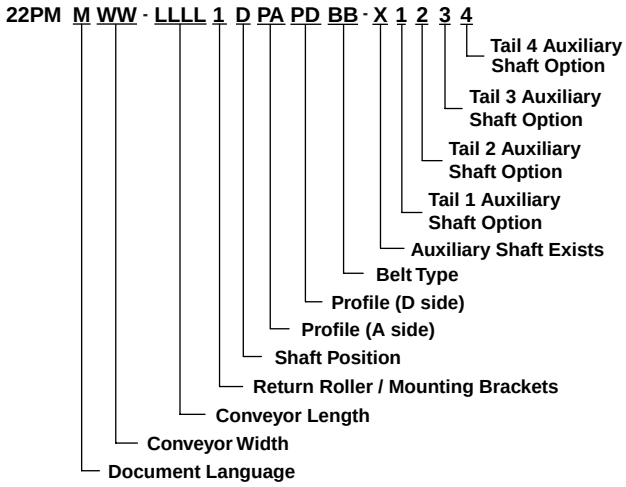
Center Drive Conveyor

Figure 2

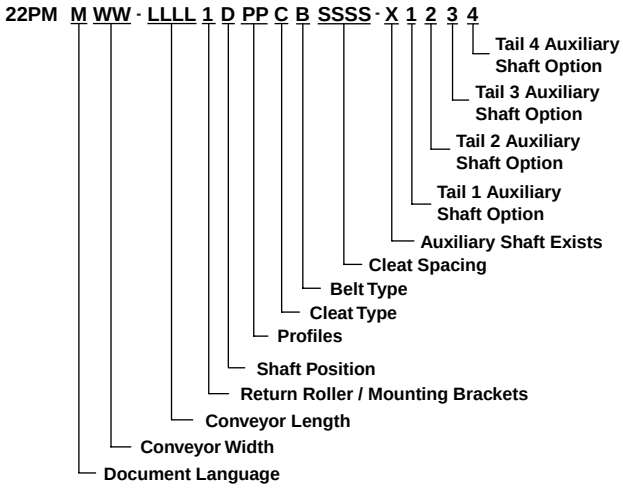
Specifications

Models:

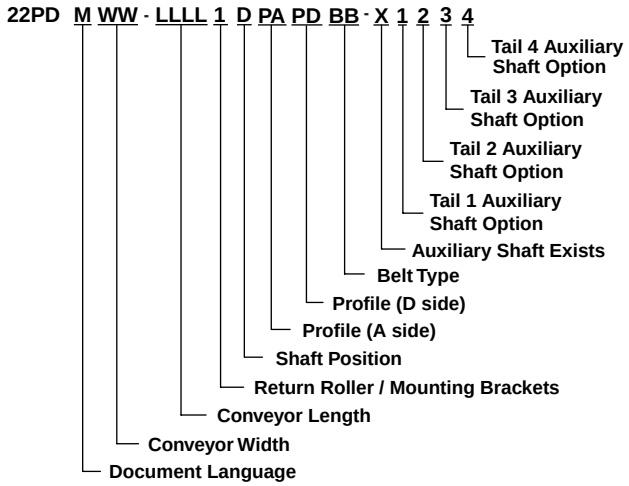
Flat Belt End Drive Conveyor



Cleated Belt End Drive Conveyor



Flat Belt Mid Drive Conveyor



Conveyor Supports:

Maximum Distances:

1 = 24" (607 mm)**

2 = 96" (2438 mm)***

3 = 18" (457 mm)

** For Heavy Load Bottom Mount Package, mount support under gear head.

*** For conveyors longer than 12 ft (3658 mm), install support at joint.

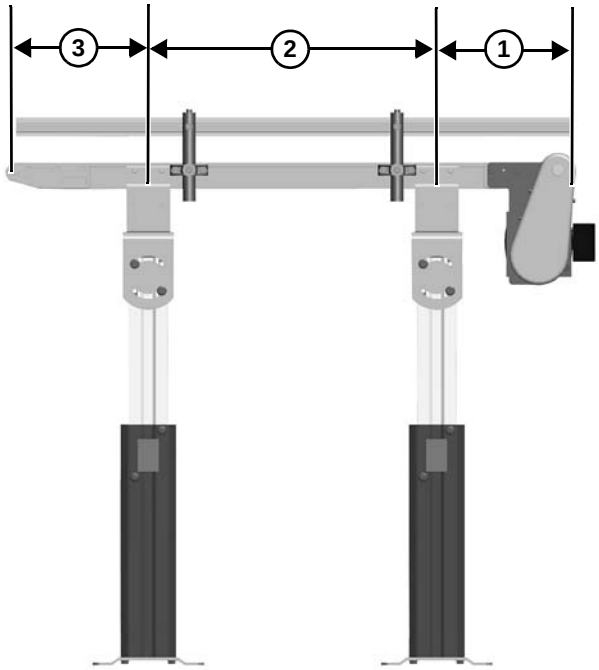


Figure 3

Conveyor Specifications:

Conveyor Width Reference (WW)	01	02	03	04	06	08	12	18	24
Conveyor Belt Width	1" (25 mm)	1.75" (44 mm)	2.75" (70 mm)	3.75" (95 mm)	6" (152 mm)	8" (203 mm)	12" (305 mm)	18" (457 mm)	24" (609 mm)
Maximum Conveyor Load* (See NOTE Below)	25 lb (11 kg)	25 lb (11 kg)	40 lb (18 kg)	55 lb (25 kg)	90 lb (41 kg)	120 lb (54 kg)	180 lb (82 kg)	200 lb (90 kg)	200 lb (90 kg)
Conveyor Startup Torque*	2 in-lb (0.5 Nm)	2 in-lb (0.5 Nm)	3 in-lb (0.6 Nm)	4 in-lb (0.7 Nm)	8 in-lb (0.9 Nm)	10 in-lb (1.1 Nm)	14 in-lb (1.5 Nm)	15 in-lb (1.7 Nm)	20 in-lb (2.3 Nm)
Belt Travel	4.724" (120 mm) per revolution of pulley								
Maximum Belt Speed*	264 ft/minute (80.5 m/minute)								
Belt Takeup	0.38" (10 mm) of stroke = 0.75" (19 mm) of belt take-up								

NOTE

Maximum conveyor loads based on:

- *Non-accumulating product*
- *Conveyor being mounted horizontal*
- *Not exceeding 15 lb / linear ft.*
- *Steel cord belt maximum load = 200 lb all widths*

* See Ordering and Specifications Catalog for details.

LLLL:

- Minimum = 0150 = 1.5 feet (18")
- Maximum = 3000 = 30 feet (360")

Installation

NOTE

Conveyor MUST be mounted straight and level within confines of conveyor. Use a level ***(Figure 4, item 1)*** *for setup.*

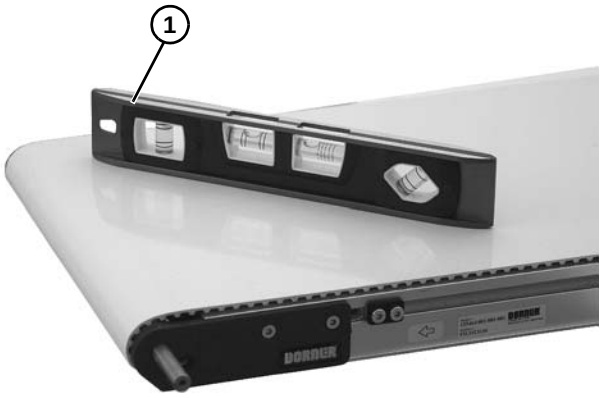


Figure 4

Installation Component List

Conveyor frame (two sections if longer than 12 ft)
Conveyor brackets (4x)
Return rollers (for longer conveyors)

Required Tools

- Hex-key wrenches:
  4 mm, 5 mm, 6 mm
- Level
- Torque wrench

Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor (if required)
- Attach mounting brackets to conveyor
- Attach conveyor to stands
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 44 through page 61 of "Service Parts" section for details)

Conveyors Up to 12 ft (3658 mm)

No assembly is required. Install mounting brackets and return rollers. Refer to "2200 Series Mounting Brackets" on page 9 and "Return Rollers" on page 10.

Conveyors Longer Than 12 ft (3658 mm)

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

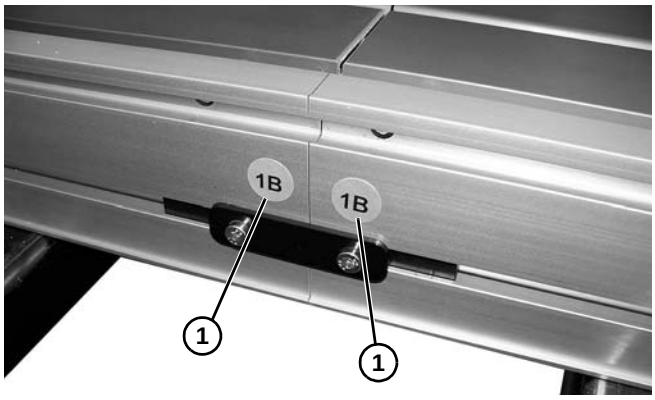
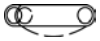


Figure 5

2. On tension end of the conveyor, identified with  a label **(Figure 6, item 1)**, push in head plate assembly **(Figure 6, item 2)**: On both sides of conveyor, loosen fastening screws **(Figure 6, item 3)** and push head plate assembly inward.

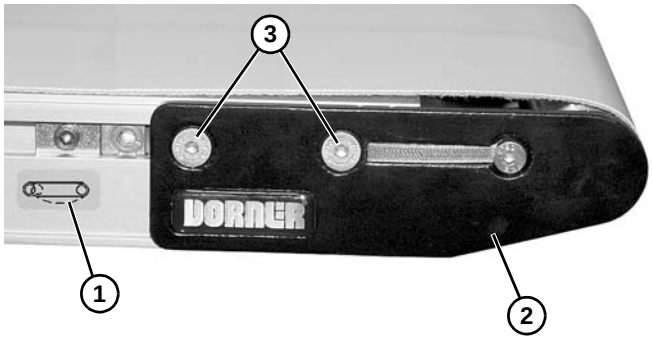


Figure 6

3. Roll out conveyor belt and place conveyor frame sections **(Figure 7, item 1)** into belt loop.

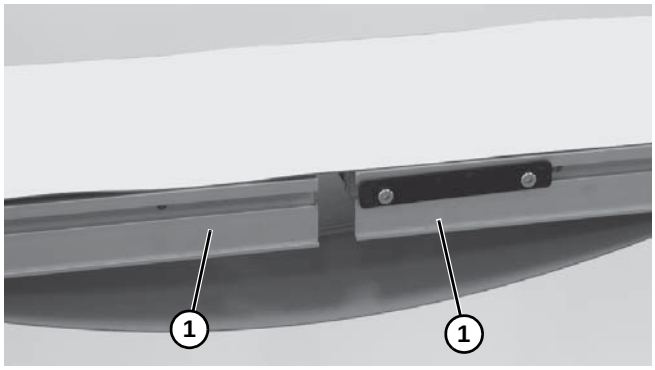


Figure 7

⚠ WARNING

SUPPORT CONVEYOR SECTIONS PRIOR TO CONNECTING FRAME SECTIONS.

4. Join conveyor sections and install frame connector plates **(Figure 8, item 1)** or connector/mount brackets **(Figure 8, item 2)** and screws **(Figure 8, item 3)** on both sides as indicated. Tighten screws to 60 in-lb (7 Nm).

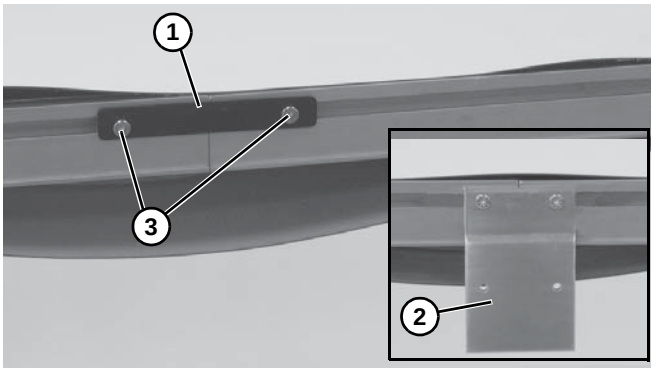


Figure 8

5. With a 5 mm hex-key wrench, rotate pinion gear **(Figure 9, item 1)** to tension the conveyor belt. Tighten fastening screws **(Figure 9, item 2)** on both sides of conveyor to 80 in-lb (9 Nm). For proper tensioning, refer to "Conveyor Belt Tensioning" on page 20".

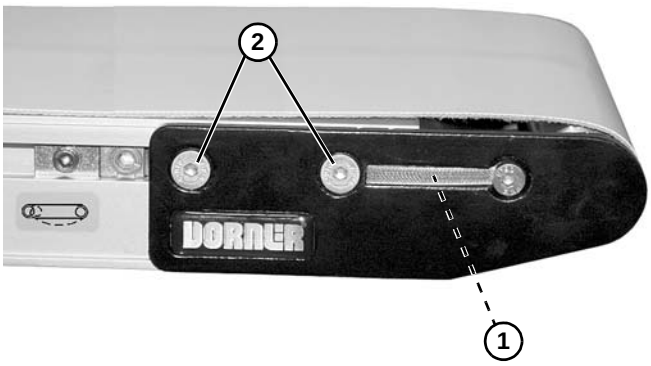


Figure 9

6. Install mounting brackets and return rollers. Refer to "2200 Series Mounting Brackets" on page 9 and "Return Rollers" on page 10.

2200 Series Mounting Brackets

1. Locate brackets. Exploded view shown in Figure 10.

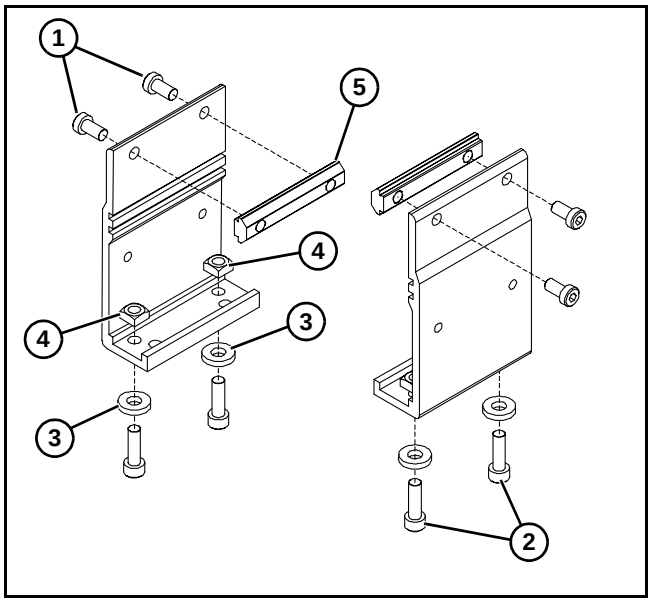


Figure 10

2. Remove screws **(Figure 10, item 1 & 2)**, washers **(Figure 10, item 3)**, nuts **(Figure 10, item 4)** and T-bars **(Figure 10, item 5)** from brackets.
3. Insert T-bars **(Figure 10, item 5)** into conveyor side slots **(Figure 11, item 1)**. Fasten brackets **(Figure 11, item 2)** to conveyor with mounting screws **(Figure 11, item 3)**.

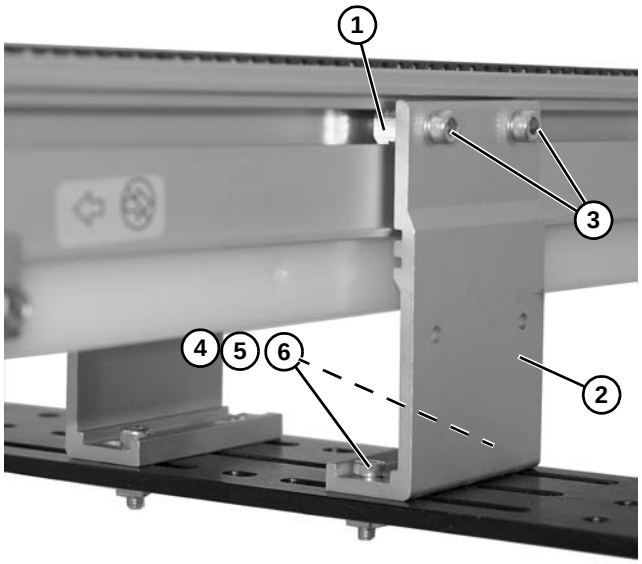


Figure 11

⚠ WARNING

Moving parts can cut or crush. Keep hands clear when raising conveyor frame onto stands.

4. Fasten brackets to support stand with mounting screws **(Figure 11, item 4)**, washers **(Figure 11, item 5)** and nuts **(Figure 11, item 6)**.
5. Tighten screws **(Figure 11, item 3 & 4)** to 60 in-lb (7 Nm).

Return Rollers

Cleated Belt and 2–6" (51–152 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded views shown in Figure 12 & Figure 13.

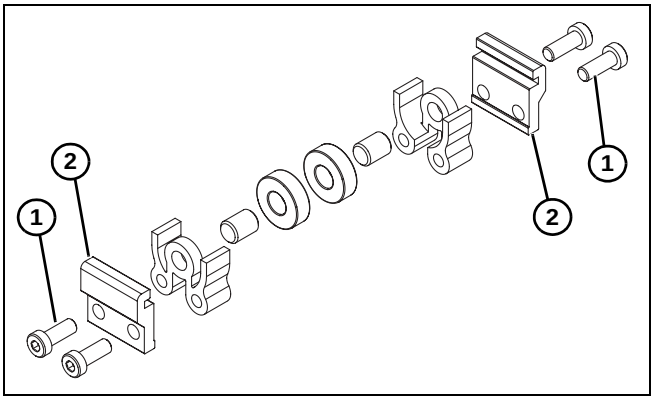


Figure 12

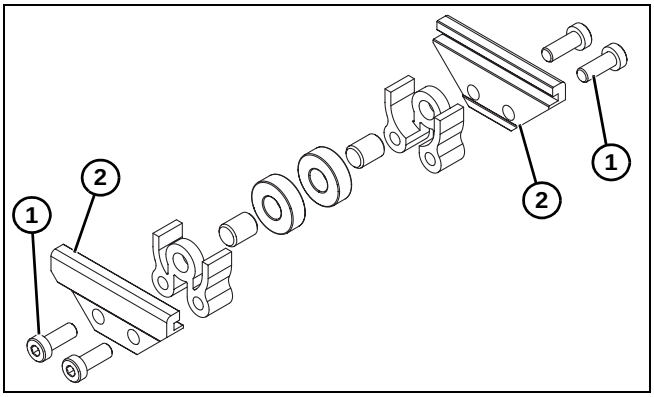


Figure 13

2. Remove screws **(Figure 12, item 1)** & **(Figure 13, item 1)** and clips **(Figure 12, item 2)** and **(Figure 13, item 2)** from roller assembly.
3. Install roller assemblies **(Figure 14, item 1)** as shown. Tighten screws **(Figure 14, item 2)** to 60 in-lb (7 Nm).

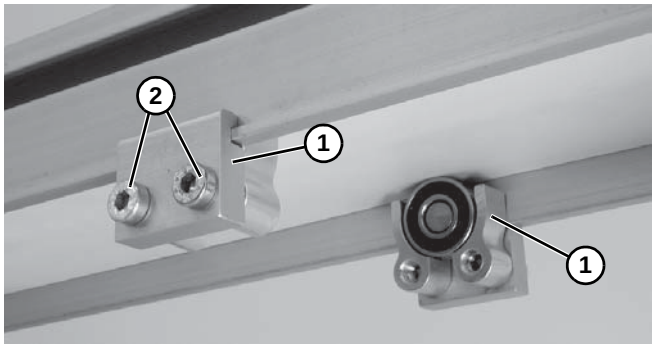


Figure 14

8–24" (203–610 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded view shown in Figure 15.

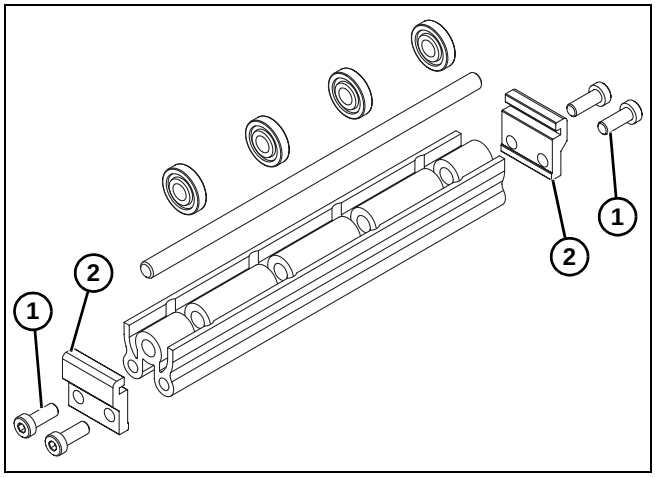


Figure 15

2. Remove screws **(Figure 15, item 1)** and clips **(Figure 15, item 2)** from roller assembly.
3. Install roller assembly as shown **(Figure 16, item 1)**. Tighten screws **(Figure 16, item 2)** to 60 in-lb (7 Nm).

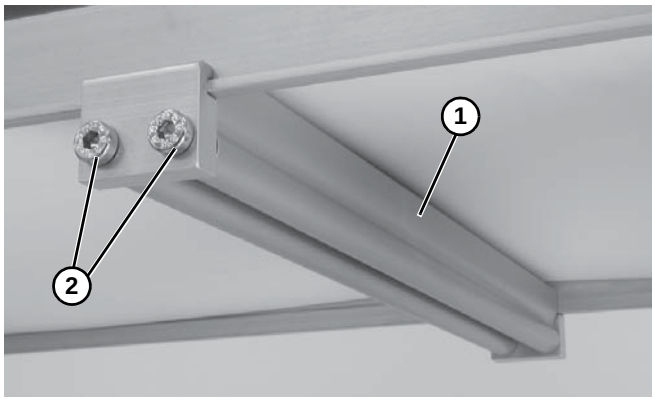


Figure 16

Slave Drive Installation

⚠ WARNING

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

1. Install slave drive plate **(Figure 17, item 1)** onto drive end of driven conveyor.

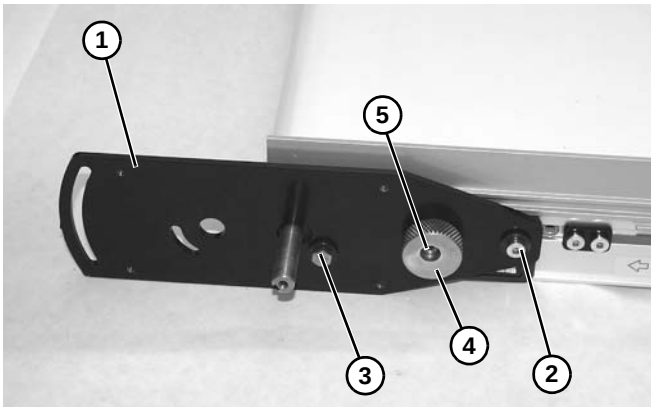


Figure 17

2. Install washer and screw **(Figure 17, item 2)**. Do not tighten.
3. Install washer and screw **(Figure 17, item 3)**. Do not tighten.
4. Install cam knob **(Figure 17, item 4)** with screw **(Figure 17, item 5)**. Do not tighten.
5. Install drive conveyor tension end **(Figure 18, item 1)** onto slave drive plate **(Figure 18, item 2)**.

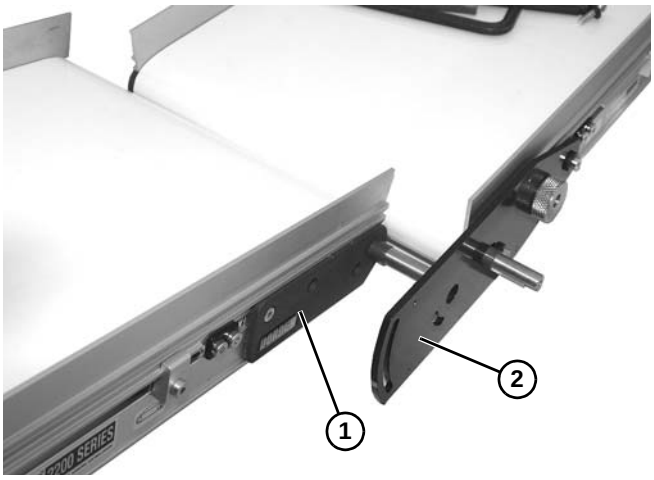


Figure 18

6. Install slave drive plate on opposite side, and install screws and washers from steps 2 and 3.
7. Install screw **(Figure 19, item 1)**. Adjust conveyor angle and tighten. Repeat on opposite side.

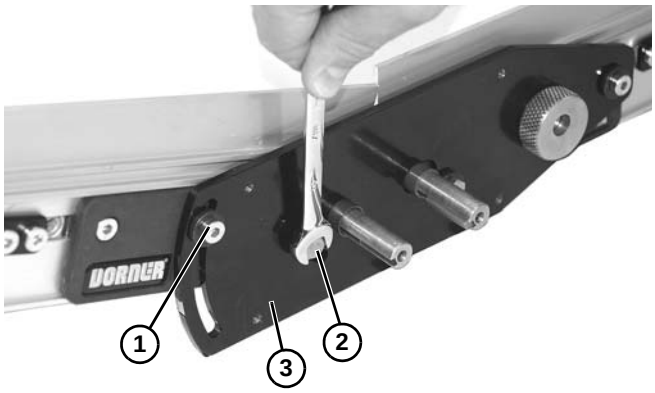


Figure 19

8. Install washer and screw **(Figure 19, item 2)** from slave drive plate **(Figure 19, item 3)**. Repeat on opposite side.
9. Install two keys **(Figure 20, item 1)**.

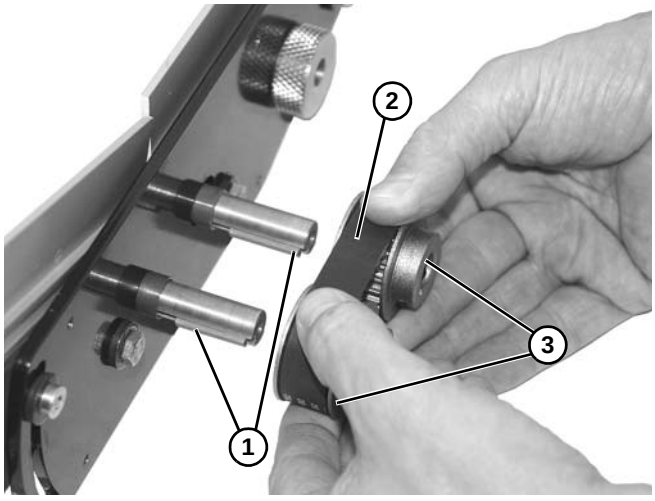


Figure 20

10. Install belt **(Figure 20, item 2)** and both pulleys **(Figure 20, item 3)**.
11. Be certain both pulleys are flush with shaft and tighten set screws **(Figure 21, item 1)** onto pulleys.

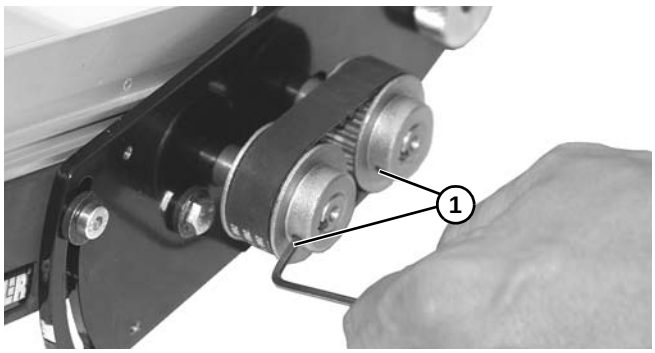


Figure 21

12. Rotate cam knob **(Figure 22, item 1)** to obtain 1/8 - 1/4" belt deflection at center of belt **(Figure 22, item 2)** with approximately 3-5 in-lb of pressure.

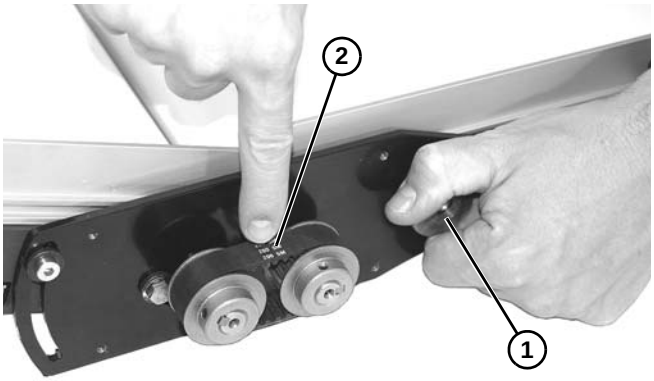


Figure 22

13. Tighten screw **(Figure 23, item 1)** in cam to lock belt tension.

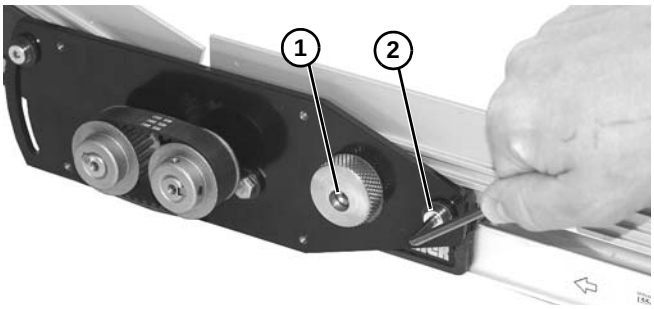


Figure 23

14. Tighten screw **(Figure 23, item 2)** to 60 in-lb (7 Nm) to secure position.
15. Tighten remaining hardware to 60 in-lb (7 Nm).
16. Install cover **(Figure 24, item 1)** and two screws **(Figure 24, item 2)**. Tighten screws enough to secure cover.

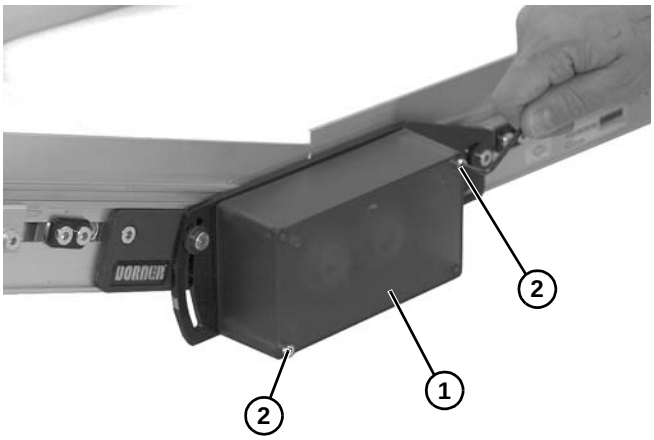


Figure 24

17. Install conveyor belt. See "Conveyor Belt Replacement" section on page 17.

Common Drive Installation

⚠ WARNING

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

NOTE

Ensure driven conveyor is not rigidly mounted to allow tie tube to align conveyors.

1. Install tie tube **(Figure 25, item 1)** between conveyor belts **(Figure 25, item 2)**.

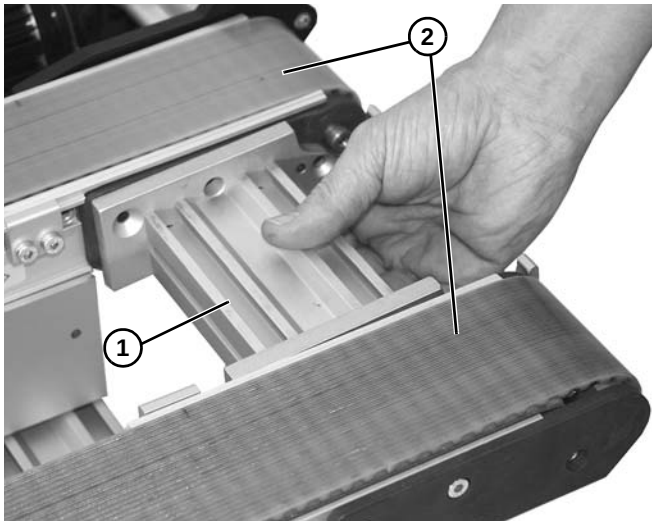


Figure 25

2. Install screw **(Figure 26, item 1)** onto spindle plate **(Figure 26, item 2)**.

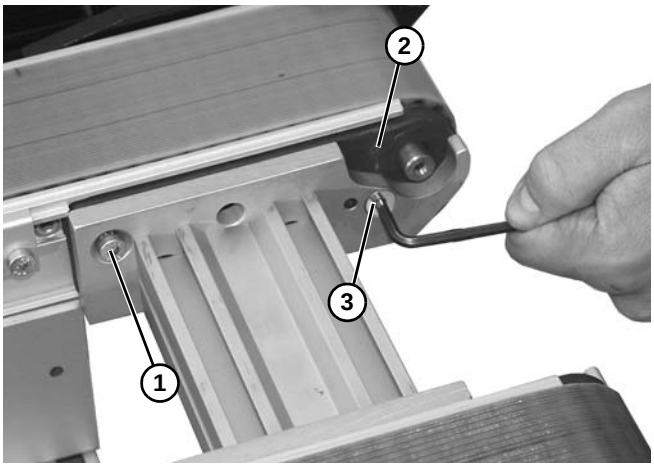


Figure 26

3. Install screw **(Figure 26, item 3)** to secure front side of plate. Repeat on opposite side.
4. Tighten screws to 60 in-lb (7 Nm).
5. Separate and install outer portion of 3-jaw coupling **(Figure 27, item 1)** onto shaft portion of each end of conveyor.

NOTE

*When securing inner portion of 3-jaw coupling **(Figure 27, item 1)** Maintain 0.30 - 0.60 in. clearance from headplates **(Figure 27, item 2)**.*

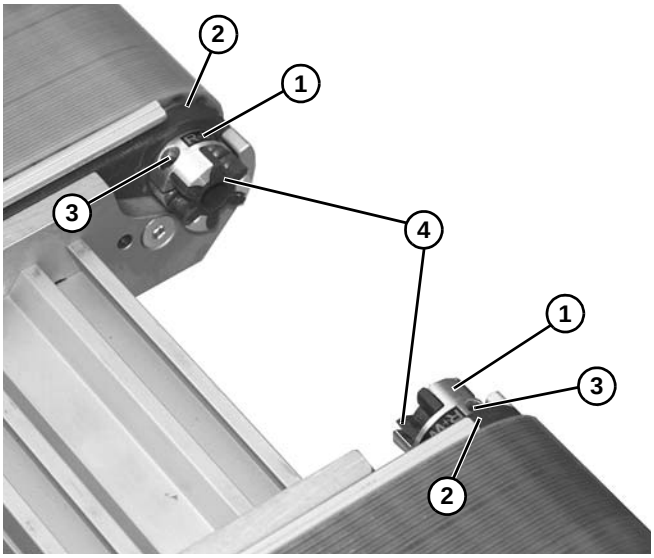


Figure 27

6. Tighten clamp screws **(Figure 27, item 3)** to 17 in-lb (2 Nm) to secure outer portion position of 3-jaw coupler.
7. Install 3-jaw spider **(Figure 27, item 4)** into each end of outer portion of 3-jaw coupling.
8. Install inner portion of 3-jaw coupling **(Figure 28, item 1)** onto center shaft **(Figure 28, item 2)**.

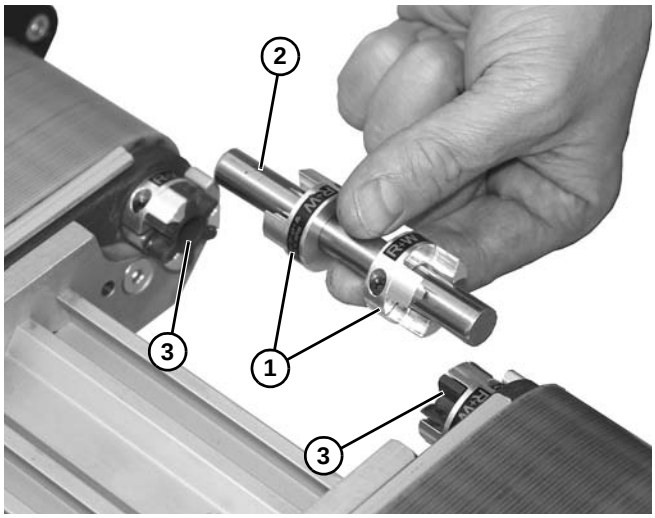


Figure 28

9. Install center shaft assembly into end of each 3-jaw spider **(Figure 28, item 3)**.
10. Slide both ends of inner portion of 3-jaw coupling **(Figure 29, item 1)** onto mating surface of outer 3-jaw coupling **(Figure 29, item 2)** and secure with clamp screws **(Figure 29, item 3)**. Tighten screws to 17 in-lb (2 Nm).

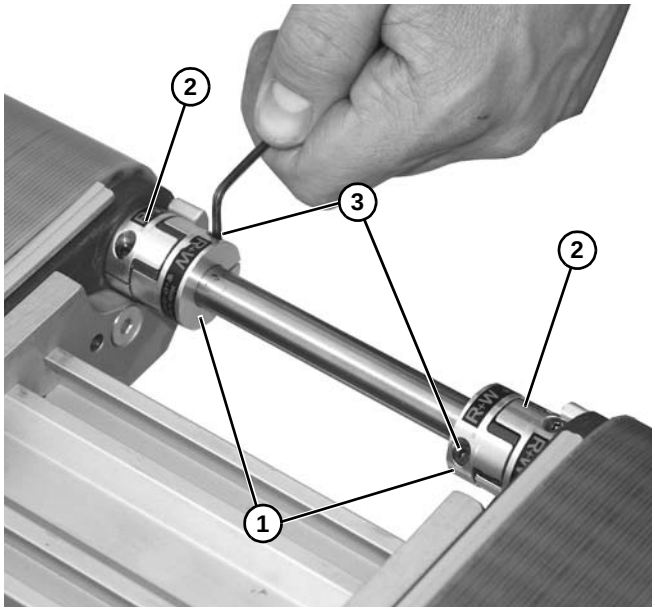


Figure 29

11. Install guard plate **(Figure 30, item 1)** pin into hole **(Figure 30, item 2)** on each side of tie tube **(Figure 30, item 3)**.

IMPORTANT

*Install guard plate **(Figure 30, item 1)** with offset angle **(Figure 30, item 4)** facing tie tube **(Figure 30, item 3)**.*

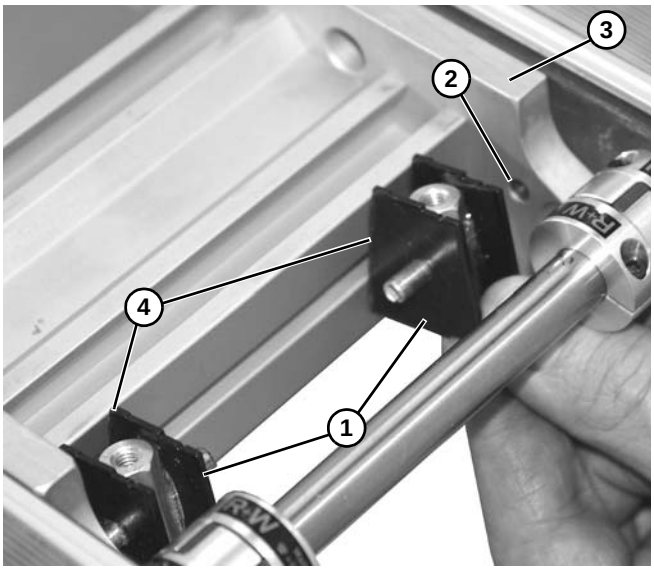


Figure 30

12. Install top guard and bottom guard **(Figure 31, item 1)** over shaft and 3-jaw couplers.

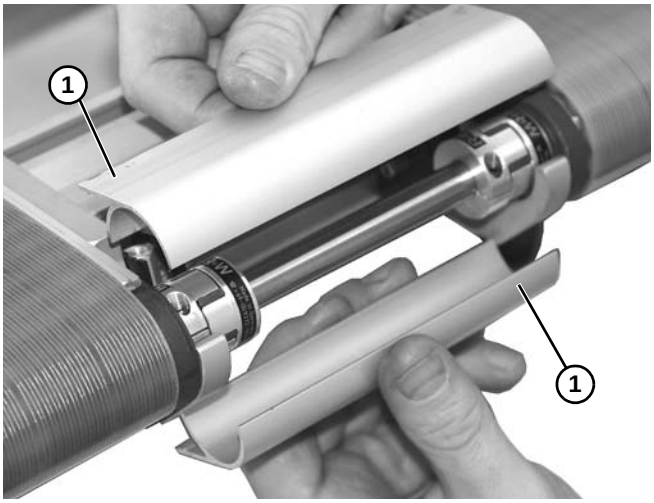


Figure 31

13. Secure top and bottom guards with weld nut **(Figure 32, item 1)** and screw **(Figure 32, item 2)** on each side of assembly. Repeat on bottom side.

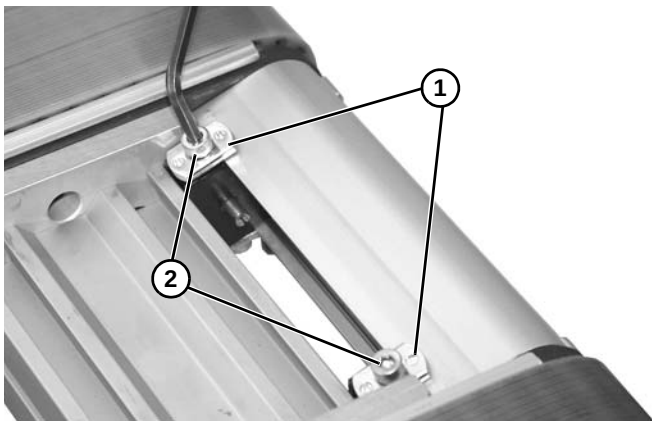


Figure 32

14. Tighten screws **(Figure 32, item 2)**.
15. Secure remaining stand mounts on conveyor ensuring alignment is not disturbed.

Guide Clips

1. Install guide clip assembly **(Figure 33, item 1)** into conveyor t-slot **(Figure 33, item 2)** as shown.

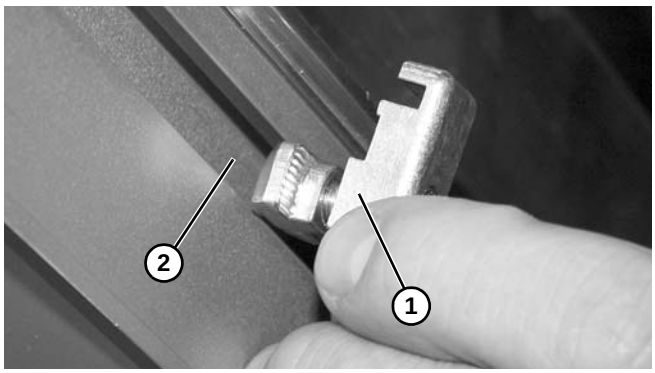


Figure 33

2. Tighten screw **(Figure 34, item 1)** making sure t-bar **(Figure 34, item 2)** rotates and engages inside of t-slot.

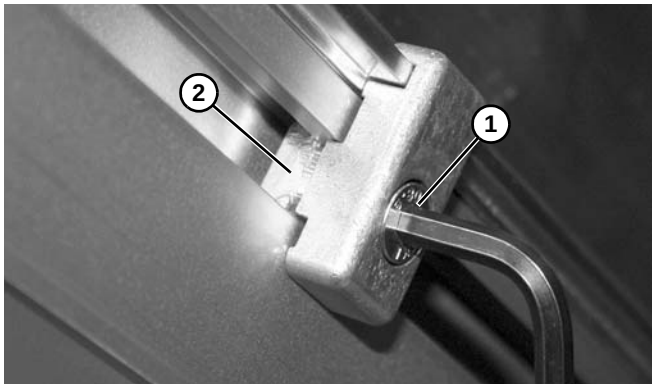


Figure 34

Adjustable Guides

1. Install guide bracket assembly **(Figure 35, item 1)** into the conveyor t-slot **(Figure 35, item 2)**.

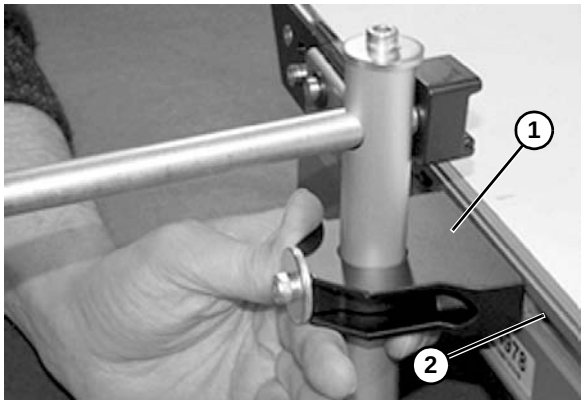


Figure 35

2. Tighten screws **(Figure 36, item 1)** making sure t-nut **(Figure 36, item 2)** rotates and engages inside of the t-slot.

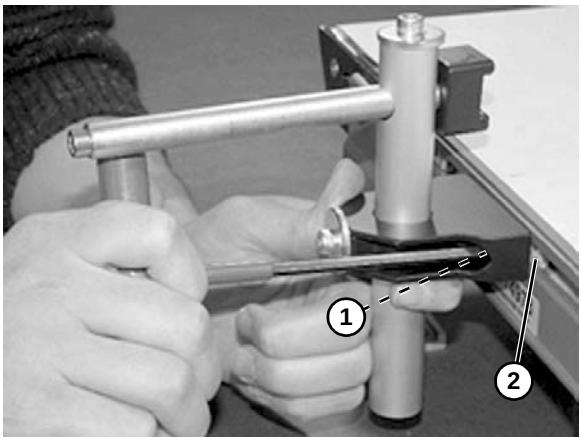


Figure 36

3. Loosen screw **(Figure 37, item 1)** on end of shaft **(Figure 37, item 2)** to remove clip **(Figure 38, item 1)**.

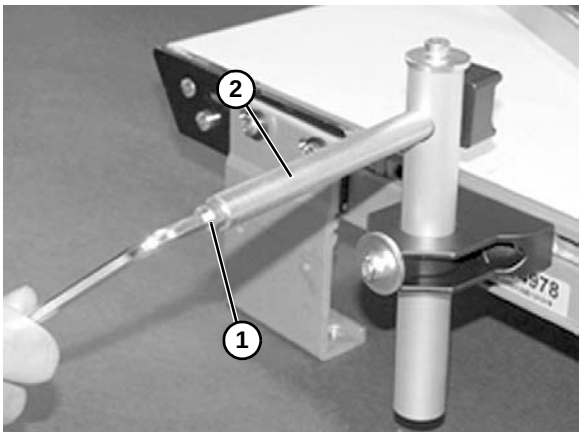


Figure 37

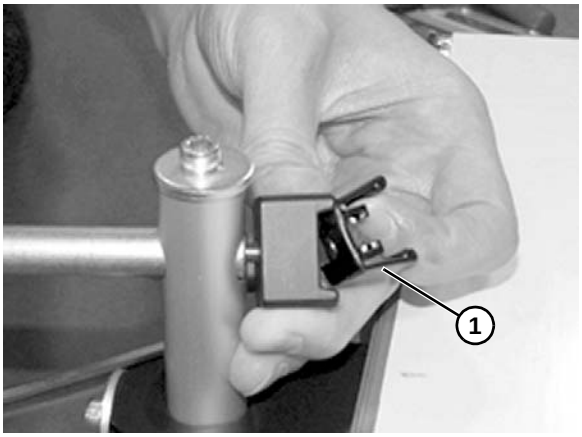


Figure 38

4. Snap clip **(Figure 39, item 1)** onto guide rail **(Figure 39, item 2)**.

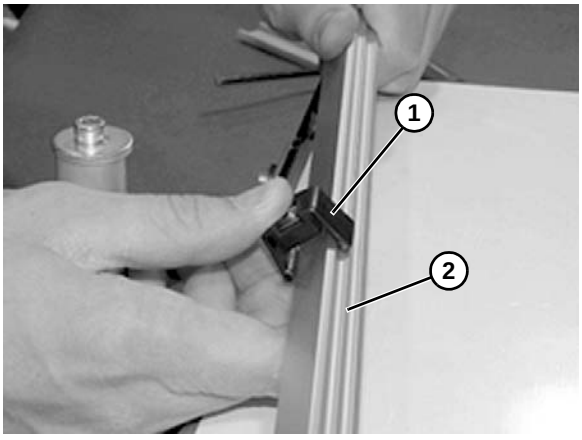


Figure 39

5. Reassemble clip **(Figure 40, item 1)** and attach to shaft **(Figure 40, item 2)**. Tighten screw **(Figure 37, item 1)** on end of shaft.

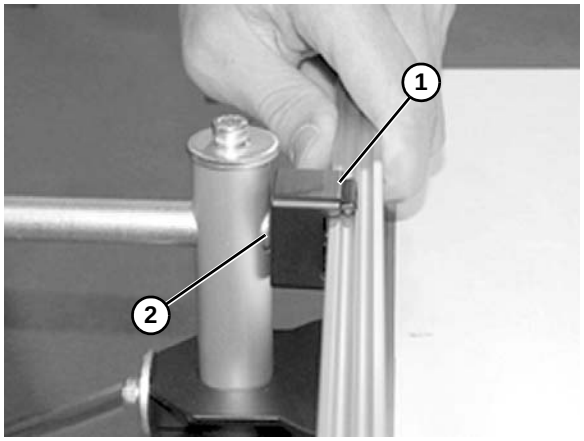


Figure 40

6. Adjust rail width with top screw **(Figure 41, item 1)**.

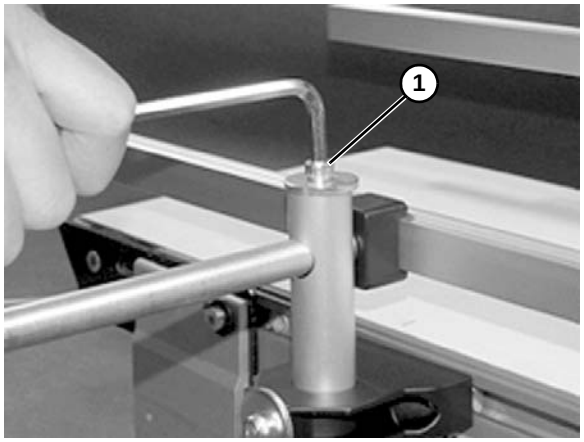


Figure 41

7. Adjust rail height with lower screw **(Figure 42, item 1)**.

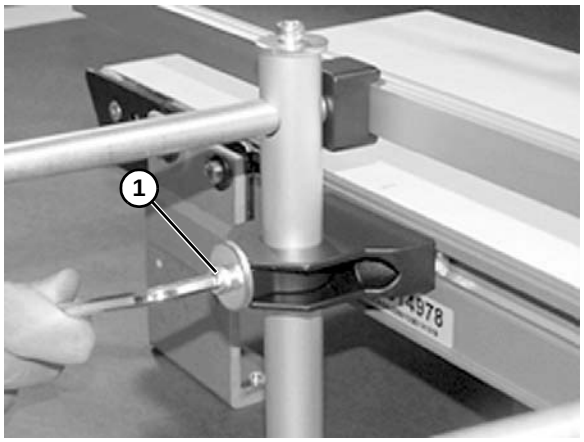


Figure 42

Required Tools

Standard Tools

- Hex-key wrenches:
  2.5 mm, 4 mm, 5 mm, 6 mm
- Arbor press

Special Tools

- 807–1716 Bearing Puller Tool (or equivalent)
- 450293 Bearing Installation Tool (Bearing Pusher)
- 456063 Bearing Removal Tool

Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner
- Clean entire conveyor while disassembled
- Replace worn or damaged parts

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Stalling or slipping

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:

- Excessive load on belt
- Conveyor belt or drive timing belt are not properly tensioned
- Impacted dirt on drive pulley
- Intermittent jamming or drive train problems

Cleaning

Use Dorner Belt Cleaner. Mild soap and water may also be used. Do not soak the belt.

Conveyor Belt Replacement

⚠ WARNING

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

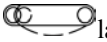
Conveyor Belt Replacement Sequence

Remove old conveyor belt:

- Conveyor without Stands or Gearmotor Mounting Package
- Conveyor with Stands and Gearmotor Mounting Package

- Install new conveyor belt
- Tension conveyor belt

Belt Removal for Conveyor Without Stands or Gearmotor Mounting Package

1. If equipped, remove return rollers and guiding and accessories from one side of conveyor.
2. On tension end of the conveyor, identified with a  label **(Figure 43, item 1)**, push in head plate assembly **(Figure 43, item 2)**: On both sides of conveyor, loosen fastening screws **(Figure 43, item 3)** and push head plate assembly inward.

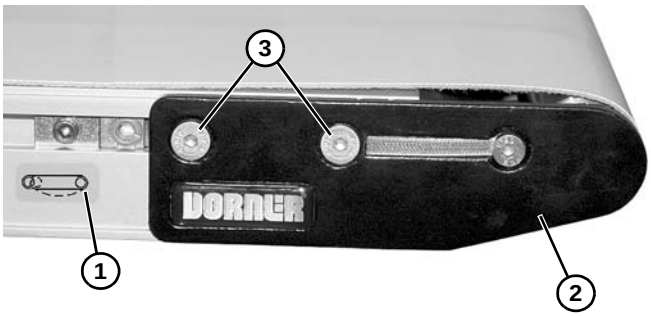


Figure 43

3. Remove conveyor belt.

Belt Removal for Conveyor With Stands and Gearmotor Mounting Package

⚠ WARNING

Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT

1. Place temporary support stands **(Figure 44, item 1)** at both ends of the conveyor. Place an additional support stand under the drive motor **(Figure 44, item 2)**, if equipped. See WARNING.

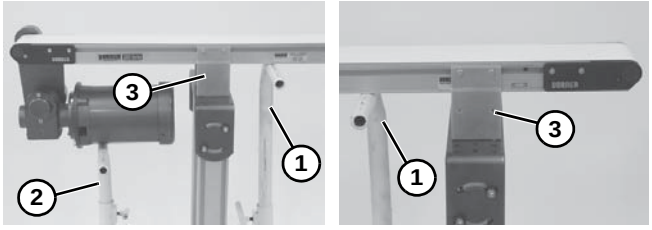


Figure 44

2. Remove mounting brackets **(Figure 44, item 3)** from one side of conveyor. (Reverse steps 3 & 4 of "2200 Series Mounting Brackets" section beginning on page 9.) If equipped with heavy load drive package, remove brackets from side opposite drive cover **(Figure 45, item 1)**.
3. If equipped, remove return rollers, guiding and accessories from side opposite drive cover **(Figure 45, item 1)**.

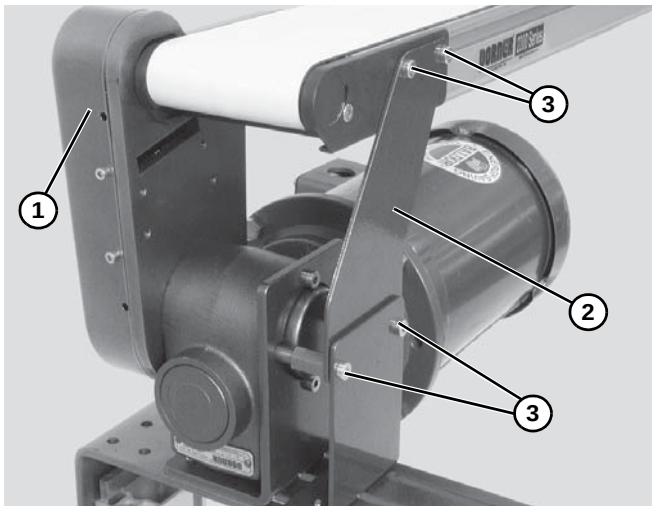
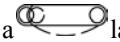


Figure 45

4. If equipped with heavy load drive package, remove drive support bracket **(Figure 45, item 2)**: Remove bracket screws **(Figure 45, item 3)** then remove bracket **(Figure 45, item 2)**.
5. On tension end of the conveyor, identified with a  label **(Figure 46, item 1)**, push in head plate assembly **(Figure 46, item 2)**: On both sides of conveyor, loosen fastening screws **(Figure 46, item 3)** and push head plate assembly inward.

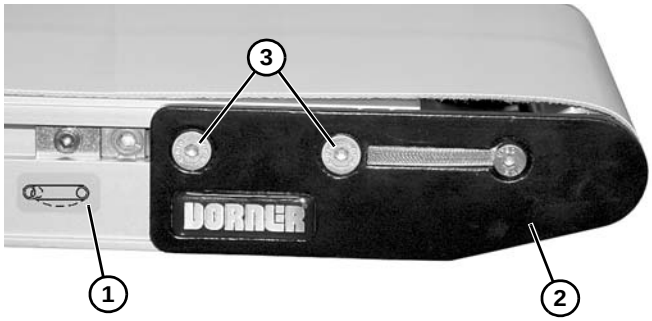


Figure 46

6. Remove belt **(Figure 47, item 1)** from conveyor.

Figure 47

Belt Removal for 1" Tip Up

1. Remove screw **(Figure 48, item 1)** on both sides of the conveyor.

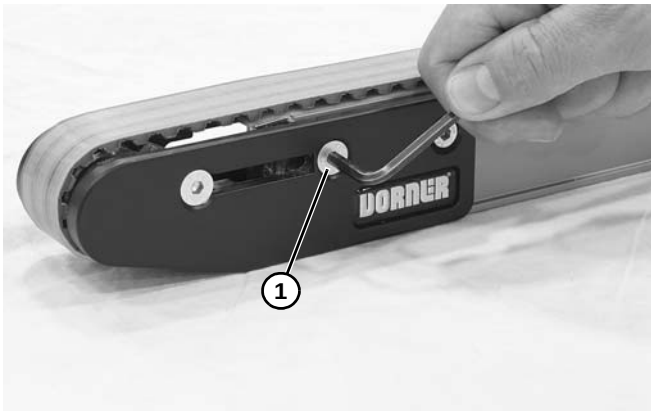


Figure 48

2. Tip head plate assembly **(Figure 49, item 1)** up and remove belt **(Figure 49, item 2)**.

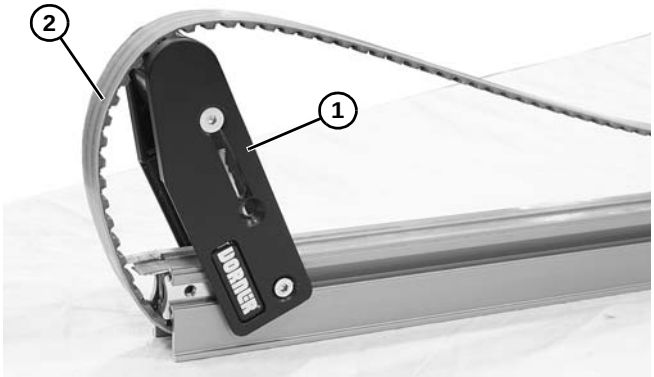


Figure 49

Belt Installation for Conveyor Without Stands or Gearmotor Mounting Package

1. Orient belt so splice leading fingers **(Figure 50, item 1)** point in the direction of belt travel as identified by the conveyor directional label **(Figure 50, item 2)**.

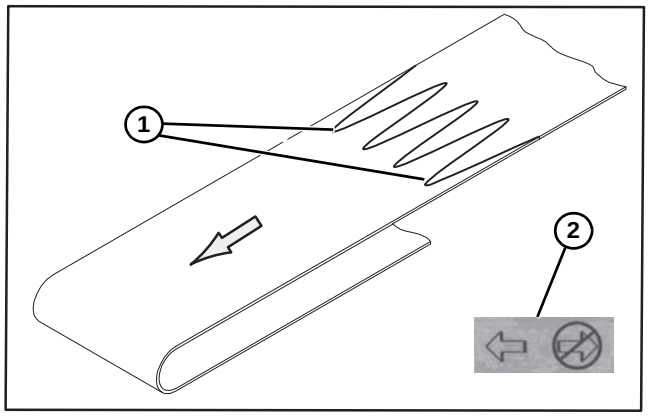


Figure 50

2. Slide belt onto the conveyor frame assembly.
3. Tension belt. Refer to “Conveyor Belt Tensioning” on page 20.
4. If equipped, install return rollers and guiding.

Belt Installation for Conveyor With Stands and Gearmotor Mounting Package

⚠ WARNING

Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT

1. Ensure temporary support stands **(Figure 44, item 1)** are placed at both ends of the conveyor. Place an additional support stand under the drive motor **(Figure 44, item 2)**, if equipped. See WARNING.
2. Orient belt so splice leading fingers **(Figure 50, item 1)** point in the direction of belt travel as identified by the conveyor directional label **(Figure 50, item 2)**.

3. Install belt **(Figure 51, item 1)** on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.

Figure 51

4. Re-install conveyor mounting brackets. Refer "2200 Series Mounting Brackets" beginning on page 9, steps 3 through 5.
5. If equipped with a heavy load drive package, re-install drive support bracket **(Figure 45, item 2)**.
6. Tension belt. Refer to "Conveyor Belt Tensioning" on page 20
7. If equipped, re-install return rollers and guiding.

Mid Drive Belt Replacement

⚠ WARNING

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

1. Remove belt tension. See "Conveyor Belt Tensioning" steps 1 & 2 section on page 20.
2. Remove screw **(Figure 52, item 1)** from each side of mid drive assembly **(Figure 52, item 2)**.

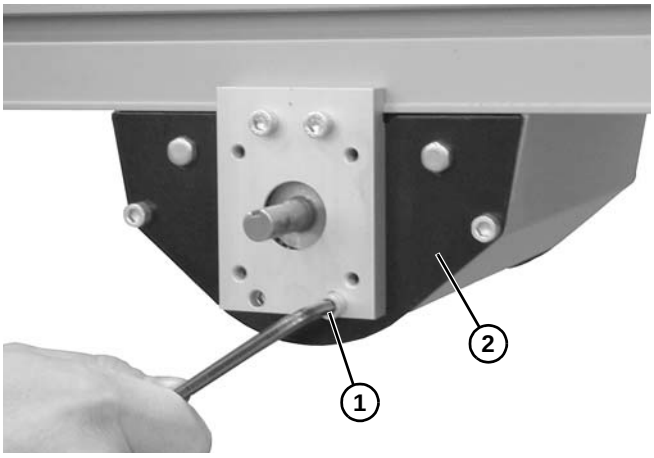


Figure 52

3. Lower and remove mid drive assembly **(Figure 53, item 1)** from belt **(Figure 53, item 2)**.

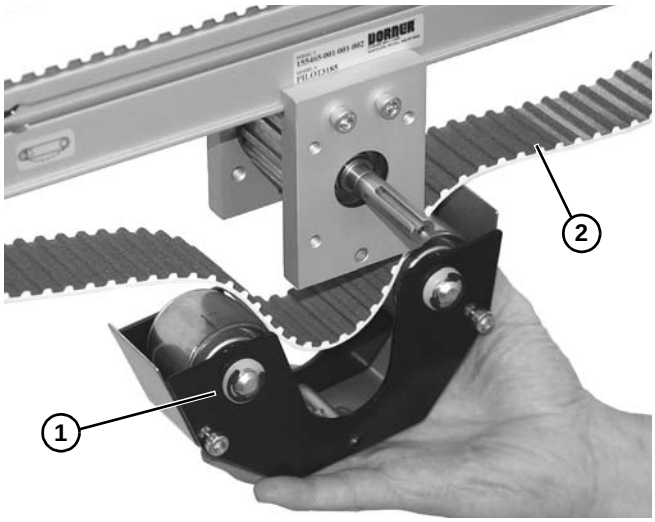


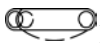
Figure 53

4. Remove belt.

Conveyor Belt Tensioning

⚠ WARNING

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

1. On tension end of the conveyor, identified with a  label **(Figure 54, item 1)**, adjust head plate assembly **(Figure 54, item 2)**: On both sides of conveyor, loosen fastening screws **(Figure 54, item 3)** and rotate pinion gear **(Figure 54, item 4)** to adjust head plate assembly.

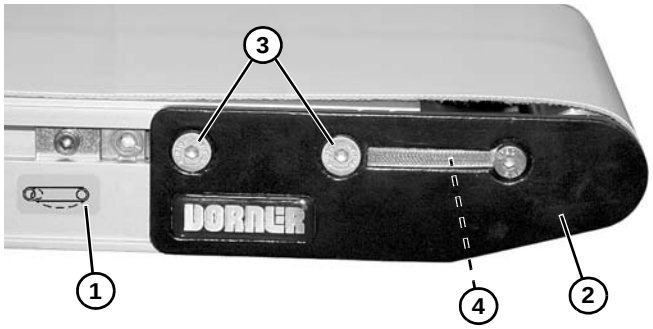


Figure 54

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks **(Figure 55, item 1 & 2)**. Replace belt if proper tensioning can not be obtained while aligning the end of the conveyor frame with or between the tensioning marks. See NOTE.

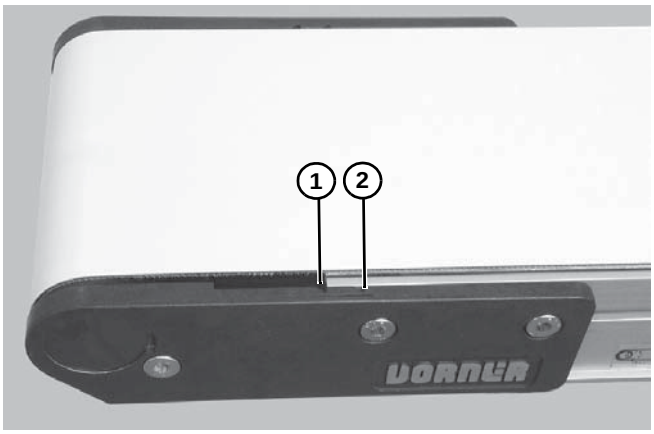


Figure 55

NOTE

On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12" (44 – 305 mm) wide conveyors and 50 in-lb (4.5 Nm) for an 18 – 24" (457 – 610 mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten fastening screws **(Figure 54, item 3)** on both sides of conveyor to 60 in-lb (7 Nm).

Pulley Removal

⚠ WARNING

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

Unless instructed otherwise, leave belt in place to remove the desired pulley. Follow the corresponding instructions below:

- A – Idler Pulley Removal
- B – 1" Wide Idler Pulley Removal
- C – Drive Pulley Removal
- D – 1" Wide Drive Pulley Removal

A – Idler Pulley Removal

1. Remove belt tension.
2. On one side of the conveyor, remove screw **(Figure 56, item 1)** and remove dust cover **(Figure 56, item 2)**, if installed.

NOTE

To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.

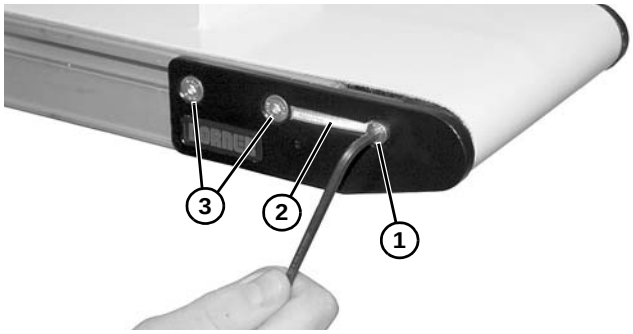


Figure 56

3. Remove two fastening screws **(Figure 56, item 3)**.
4. Remove the head plate **(Figure 57, item 1)** from the conveyor frame, holding spindle in place.

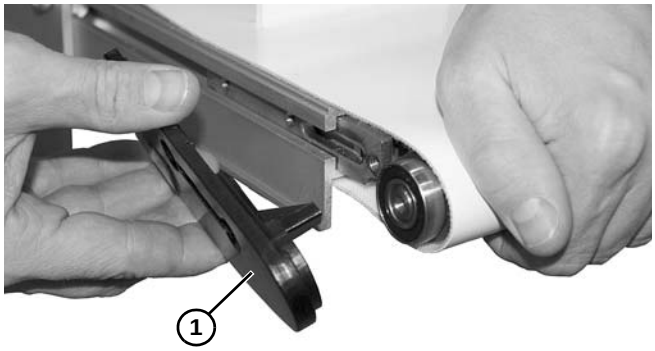


Figure 57

5. Slide spindle out of the belt loop.
6. To replace the idler tail pulley, reverse the removal procedure.
7. Re-install belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 20.

B – 1" Wide Idler Pulley Removal

1. Remove belt. See “Belt Removal for 1" Tip Up” on page 19.
2. Loosen screw **(Figure 58, item 1)** on both sides of conveyor. Remove idler tail **(Figure 58, item 2)** from conveyor.

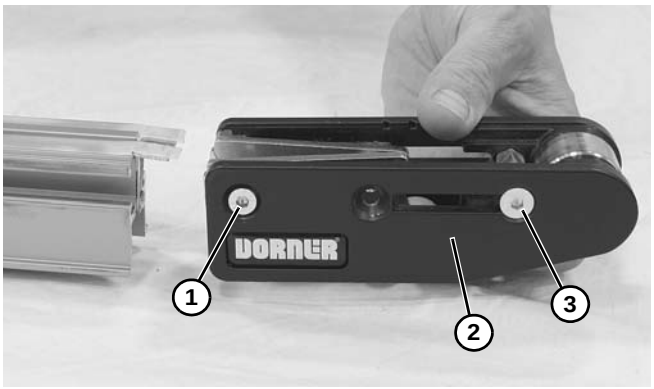


Figure 58

3. Remove fastening screw **(Figure 58, item 3)**.
4. Remove the head plate **(Figure 59, item 1)** and remove the spindle **(Figure 59, item 2)**.

NOTE

To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.

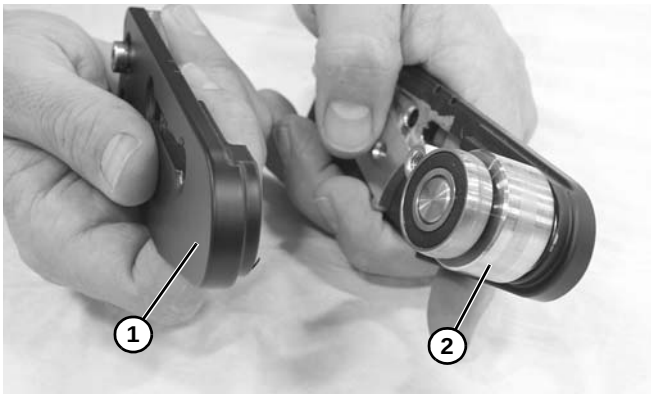


Figure 59

5. To replace the idler tail pulley, reverse the removal procedure.
6. Re-install belt on end of conveyor. Tension the belt by reversing the steps in “Belt Removal for 1" Tip Up” on page 19.

C – Drive Pulley Removal

1. Remove belt tension.
2. On one side of the conveyor, remove screw **(Figure 60, item 1)** and remove dust cover **(Figure 60, item 2)**, if installed.

NOTE

To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.

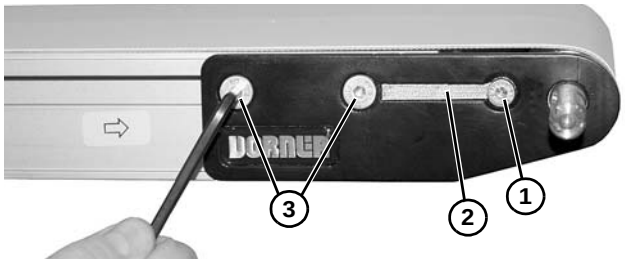


Figure 60

3. Remove two fastening screws **(Figure 60, item 3)**.

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

4. Remove the head plate **(Figure 61, item 1)** from the conveyor frame, holding spindle in place.

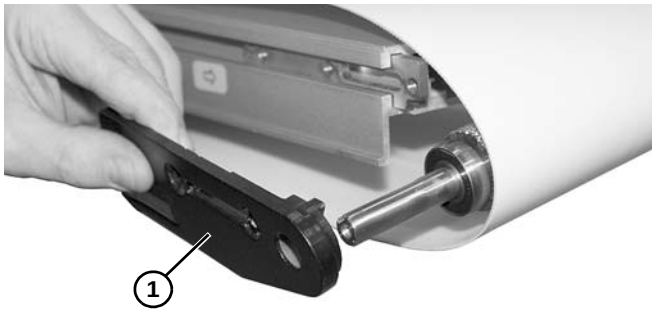


Figure 61

5. Slide the drive pulley out of the belt loop.
6. To replace the drive tail pulley, reverse the removal procedure.
7. Re-install belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 20.

D – 1" Wide Drive Pulley Removal

1. Remove belt. See “Belt Removal for 1" Tip Up” on page 19.
2. Loosen two screws **(Figure 62, item 1)** on both sides of conveyor. Remove drive tail **(Figure 62, item 2)** from conveyor.

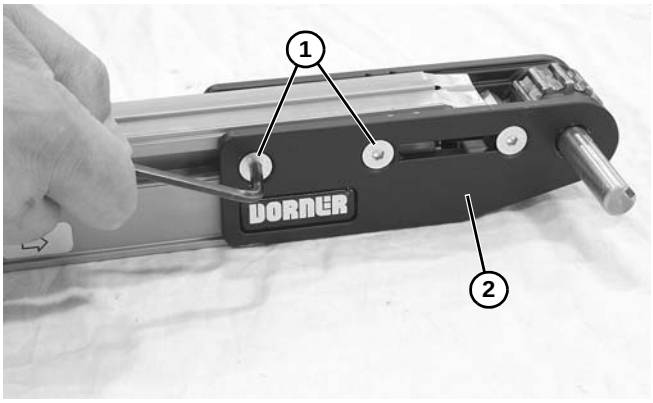


Figure 62

3. Remove fastening screw **(Figure 63, item 1)**.

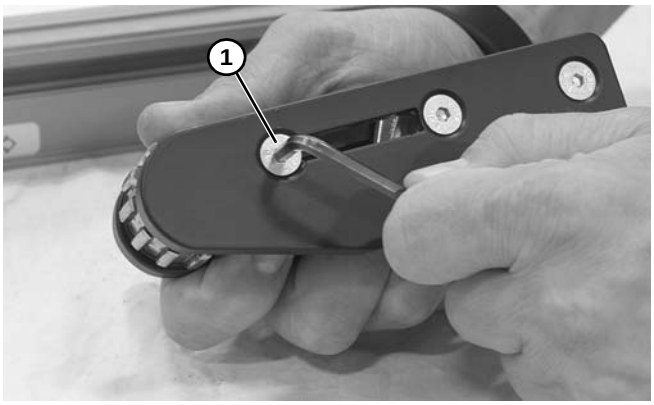


Figure 63

4. Remove the head plate **(Figure 64, item 1)** and remove the spindle **(Figure 64, item 2)**.

NOTE

To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.

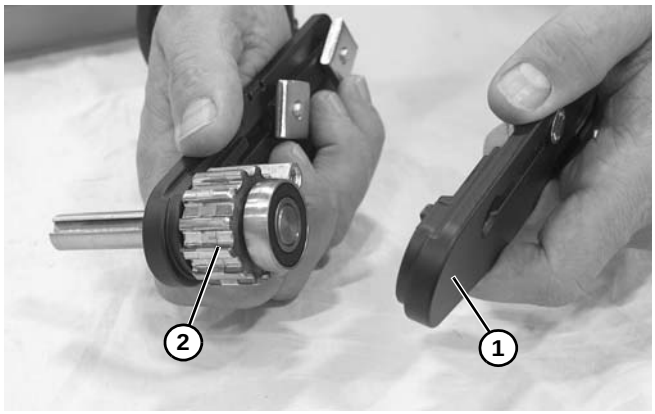


Figure 64

5. To replace the idler tail pulley, reverse the removal procedure.
6. Re-install belt on end of conveyor. Tension the belt by reversing the steps in “Belt Removal for 1" Tip Up” on page 19.

Bearing Removal & Replacement

Removal

IMPORTANT

Do not use any removed bearings. Replace them.

1. Place bearing removal tool part #456063 **(Figure 65, item 1)** below bearing **(Figure 65, item 2)** with lip **(Figure 65, item 3)** located in gap **(Figure 65, item 4)** between bearing and spindle hub **(Figure 65, item 5)** as shown.

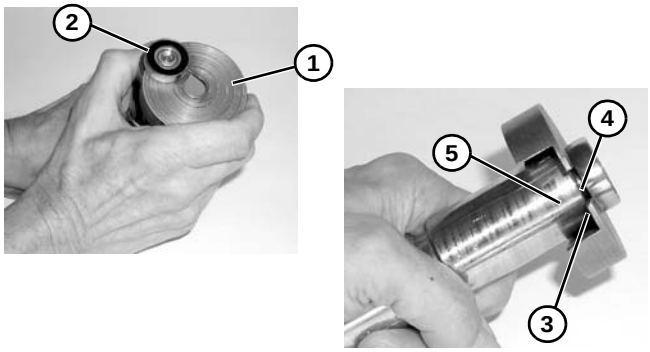


Figure 65

2. Using puller part #807–1716 **(Figure 66, item 1)**, remove and discard bearing.

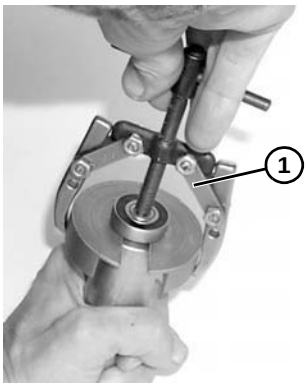


Figure 66

Replacement

1. Inspect the head plates bearing seating surface **(Figure 67, item 1)**. If they are worn or damaged, replace. See "Service Parts" on page 35.

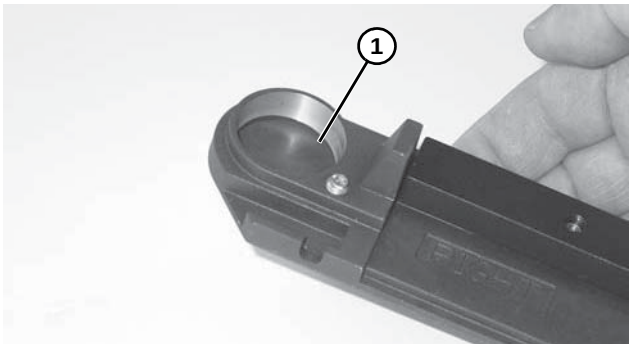


Figure 67

2. Inspect spindle **(Figure 68, item 1)**. Replace if worn.
3. Slide bearing **(Figure 68, item 2)** onto spindle.

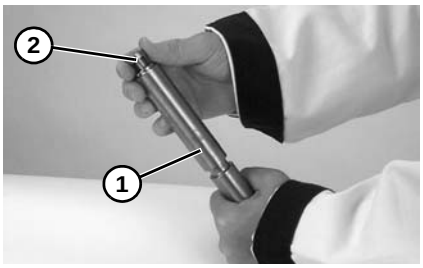


Figure 68

4. Using an arbor press or similar device, press bearing onto pulley shaft (Figure 69).

⚠ WARNING

Be certain that bearing and shaft is set onto press completely flush with press cylinder plate. If not, damage to bearing or shaft could result.

Keep hands and fingers away from press and components during procedure.

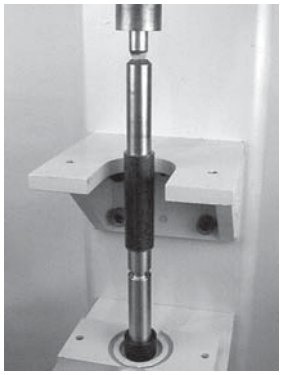


Figure 69

5. Repeat steps 1 through 4 for each bearing.

Drive Pulley and Idler Pulley Installation

Drive Pulley Installation

1. With opposite head plate installed, position the drive pulley through the loop of the belt, into the opposite head plate.
2. Add spring washer **(Figure 70, item 1)** to head plate spindle bore **(Figure 70, item 2)** opposite motor drive side with fingers **(Figure 70, item 3)** toward head plate spindle bore.

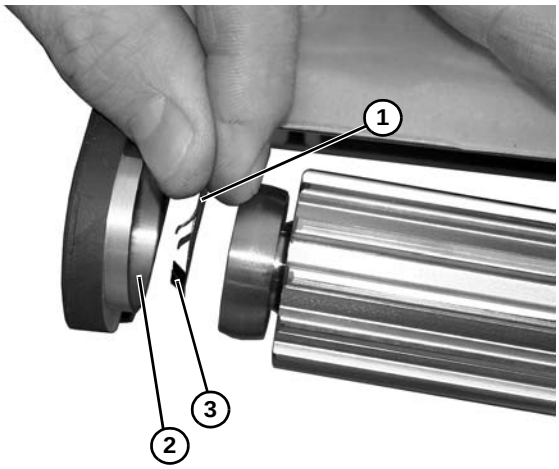


Figure 70

3. Install the head plate over the drive pulley and attach the head plate to the conveyor frame with three screws **(Figure 71, item 1)**. Tighten screws to 60 in-lb (7 Nm).

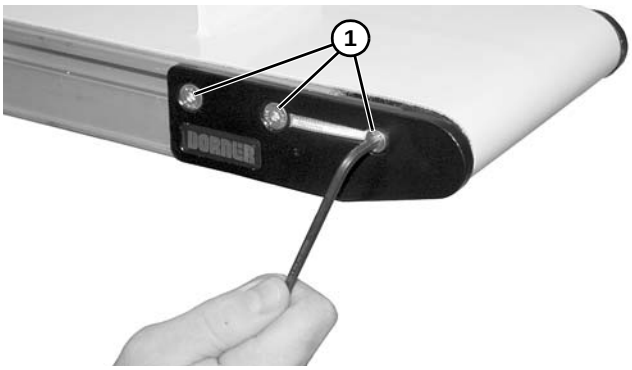


Figure 71

Idler Pulley Installation

1. With opposite head plate installed, position the idler pulley through the loop of the belt, into the opposite head plate.
2. Install the head plate over the drive pulley and attach the head plate to the conveyor frame with three screws **(Figure 72, item 1)**. Tighten screws to 60 in-lb (7 Nm).

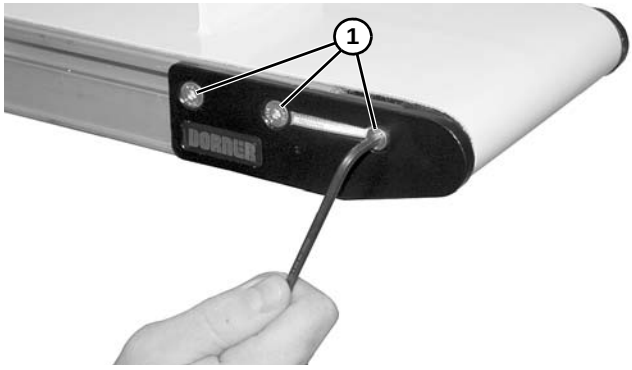


Figure 72

Upper Wear Strip Replacement

⚠ WARNING

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

1. Remove conveyor belt. See “Conveyor Belt Replacement” section on page 17.
2. With a putty knife **(Figure 73, item 1)**, start by raising edge of wear strip **(Figure 73, item 2)**.

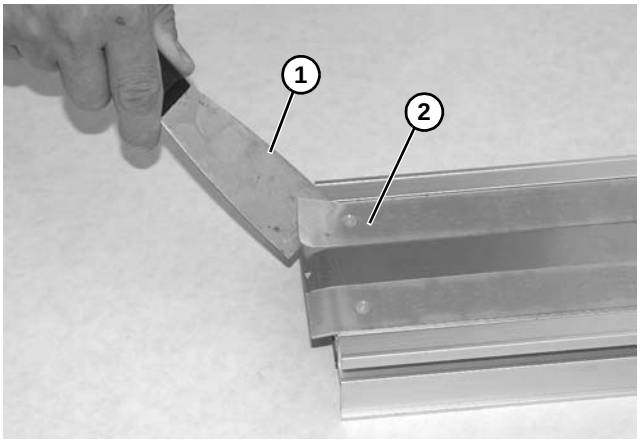


Figure 73

3. Remove old wear strip with a pliers **(Figure 74, item 1)**.

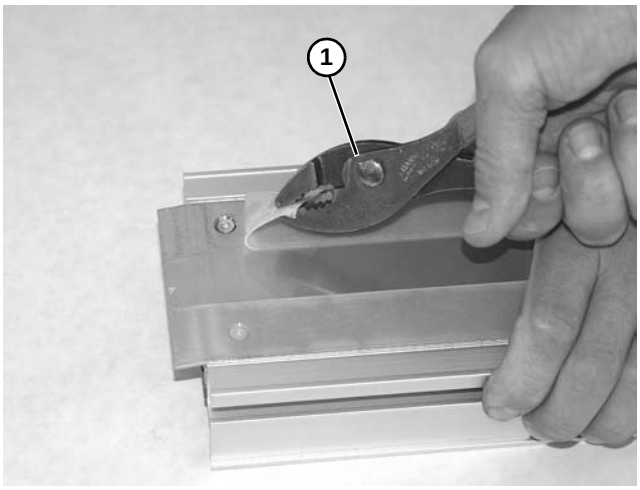


Figure 74

4. Clean conveyor surface with isopropyl alcohol and allow to fully dry.
5. Install new wear strip **(Figure 75, item 1)**.

⚠ WARNING

Utility knife will be sharp. HANDLE WITH CARE.

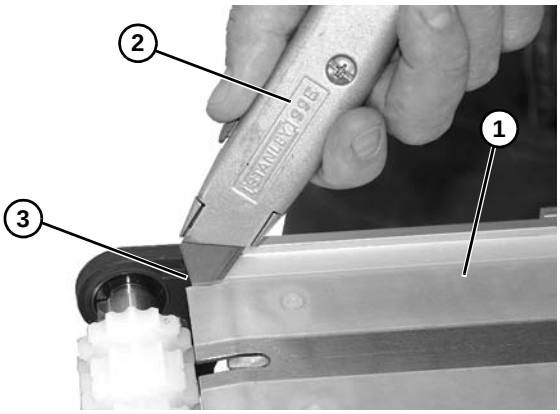


Figure 75

6. Using a utility knife **(Figure 75, item 2)**, cut out notch in each corner **(Figure 75, item 3)**.

Slave Drive Belt Replacement

⚠ WARNING

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

1. Remove two screws **(Figure 76, item 1)** and cover **(Figure 76, item 2)**.

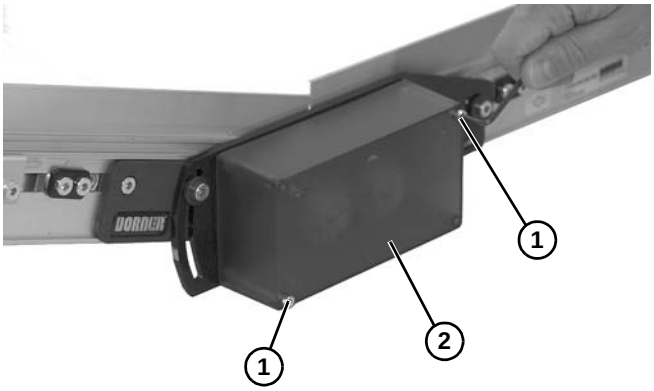


Figure 76

2. Loosen set screws **(Figure 77, item 1)** on pulleys.

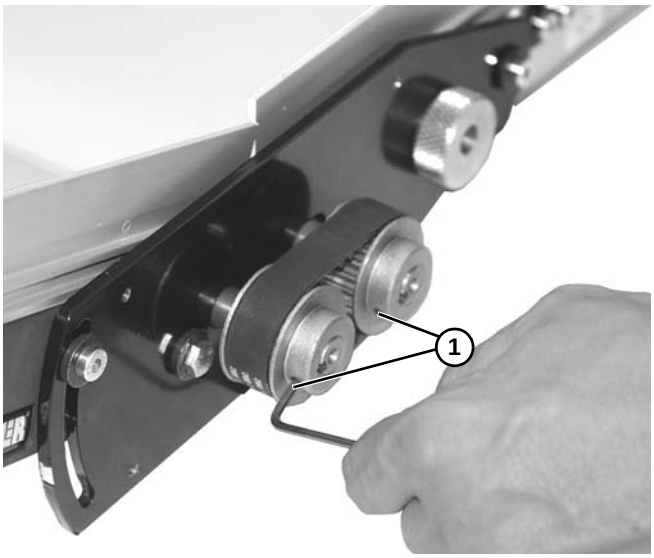


Figure 77

3. Loosen screws **(Figure 78, item 1, 2, and 3)** from both sides of conveyor. Turn cam knob **(Figure 78, item 4)** to remove belt tension.

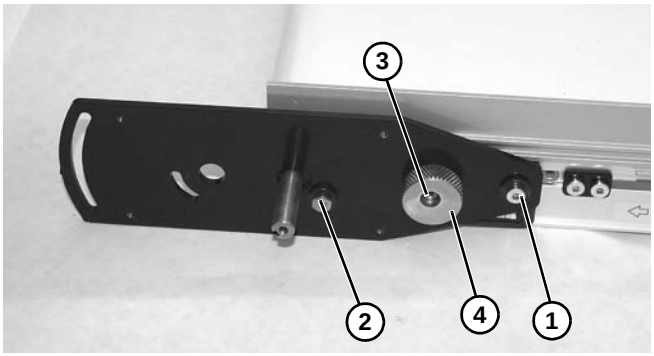


Figure 78

4. Remove both pulleys **(Figure 79, item 1)** and belt **(Figure 79, item 2)**.

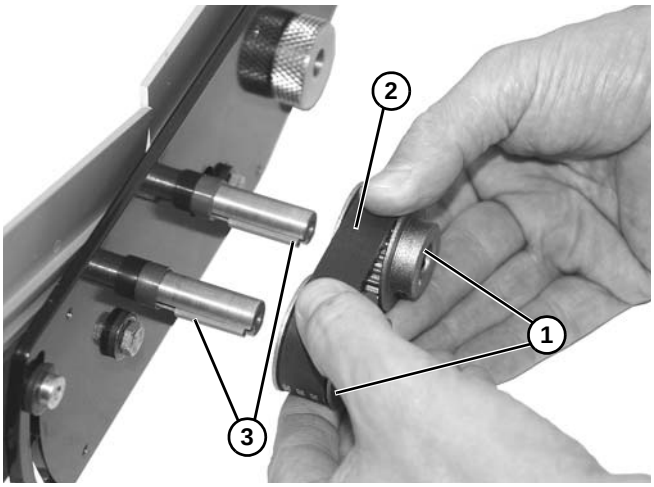


Figure 79

5. Be certain two keys **(Figure 79, item 3)** are installed onto each shaft.
6. Install new belt **(Figure 79, item 2)** and both pulleys **(Figure 79, item 1)**.
7. Be certain both pulleys are flush with shaft and tighten set screws **(Figure 80, item 1)** onto pulleys.

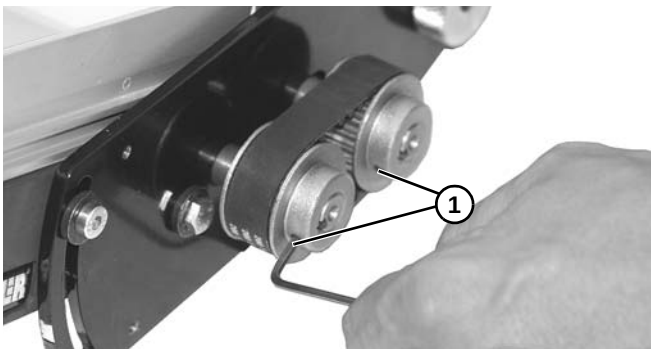


Figure 80

8. Rotate cam knob **(Figure 81, item 1)** to obtain 1/8 - 1/4" belt deflection at center of belt **(Figure 81, item 2)** with approximately 3-5 in-lb of pressure.

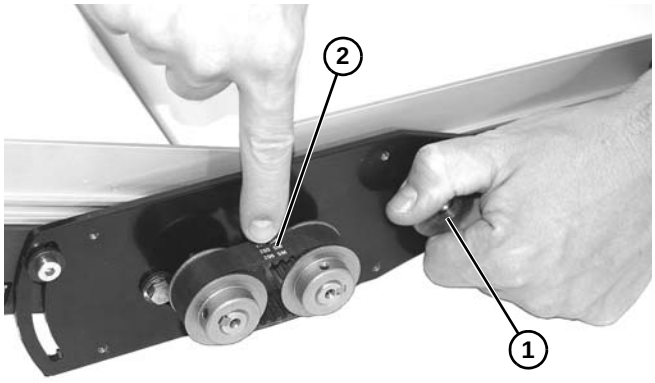


Figure 81

9. Tighten low head capscrew **(Figure 82, item 1)** in cam to lock belt tension.

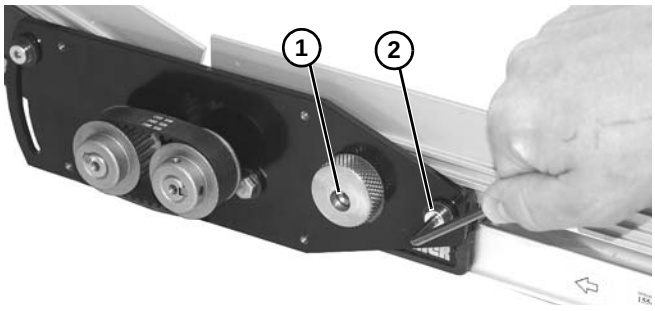


Figure 82

10. Tighten screw **(Figure 82, item 2)** to 60 in-lb (7 Nm) to secure position.
11. Tighten remaining hardware to 60 in-lb (7 Nm).
12. Install cover **(Figure 83, item 1)** and two screws **(Figure 83, item 2)**. Tighten screws enough to secure cover.

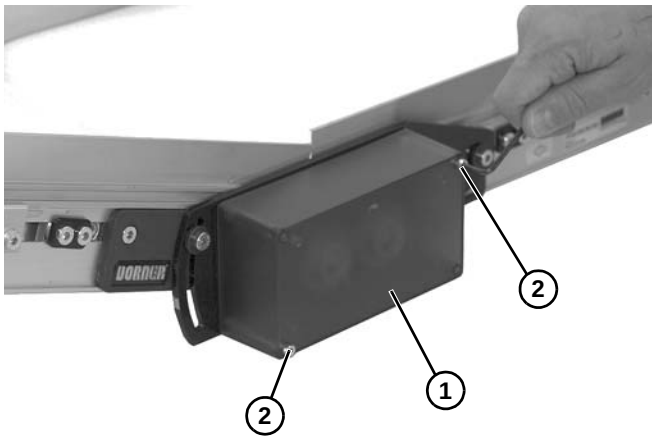


Figure 83

Mid Drive Spindle Replacement

1. Remove belt. See “Conveyor Belt Replacement” on page 17.
2. Remove two screws **(Figure 84, item 1)** from each side of mounting block **(Figure 84, item 2)**.

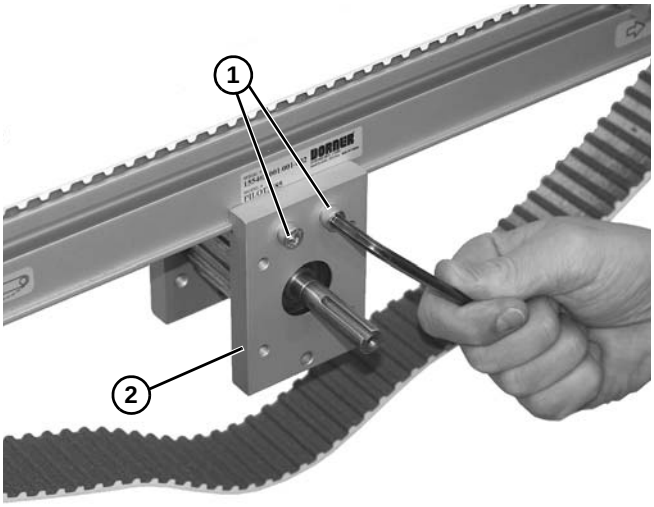


Figure 84

3. Lower center spindle assembly **(Figure 85, item 1)** clamp block **(Figure 85, item 2)** from conveyor channel **(Figure 85, item 3)** on each side of conveyor frame.

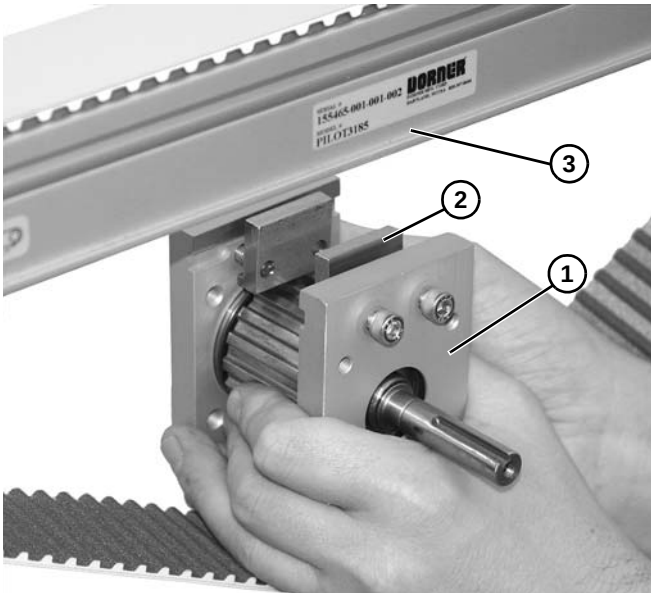


Figure 85

4. Separate mounting blocks **(Figure 86, item 1)** from spindle **(Figure 86, item 2)**.

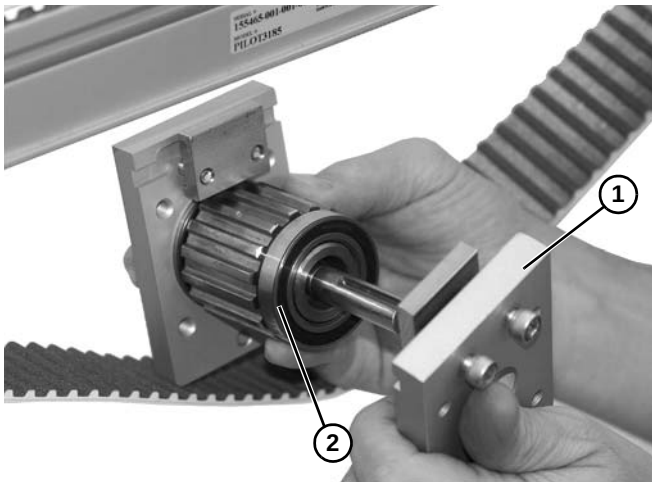


Figure 86

5. Replace spindle.
6. Install mounting block **(Figure 87, item 1)** onto spindle **(Figure 87, item 2)**.

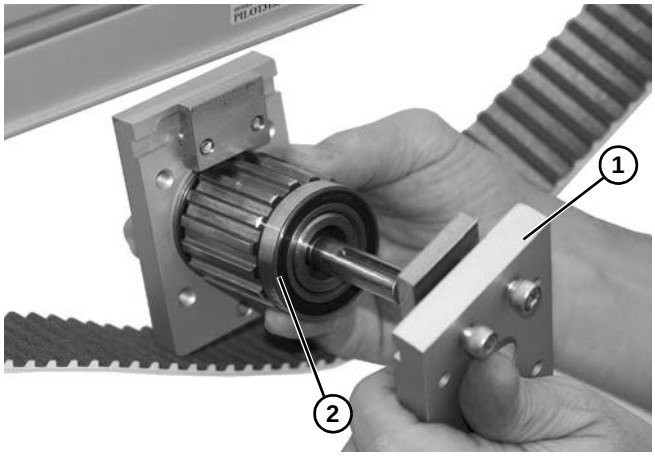


Figure 87

7. Raise center spindle assembly **(Figure 88, item 1)** tracking clamp block **(Figure 88, item 2)** onto conveyor channel **(Figure 88, item 3)** on each side of conveyor frame.

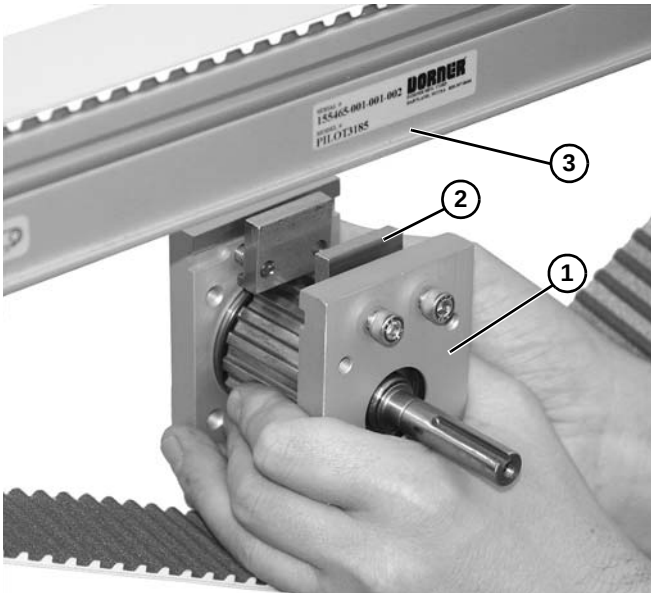


Figure 88

8. Secure center spindle assembly **(Figure 89, item 1)** with two screws **(Figure 89, item 2)** on each side of mounting block. Do not tighten.

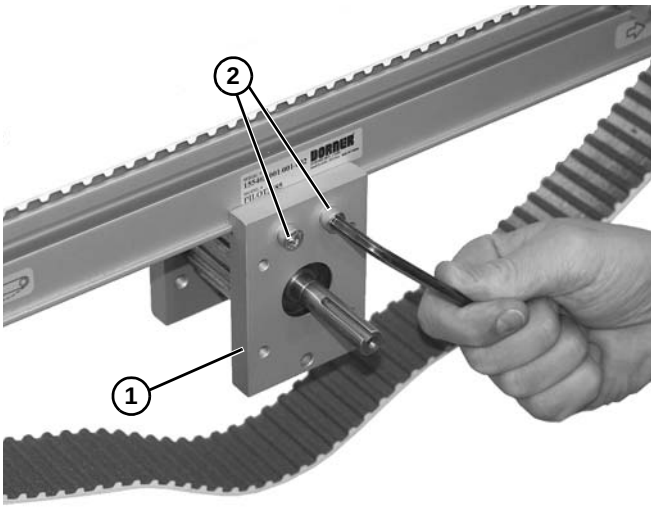


Figure 89

9. Raise mid drive assembly **(Figure 90, item 1)** onto belt **(Figure 90, item 2)**.

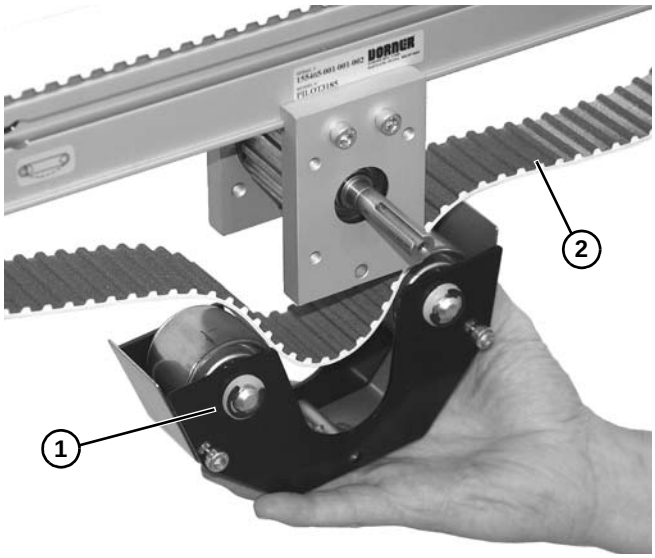


Figure 90

10. Secure mid drive assembly **(Figure 91, item 1)** with screw **(Figure 91, item 2)** on each side of assembly. Tighten screw to 60 in-lb (7 Nm).

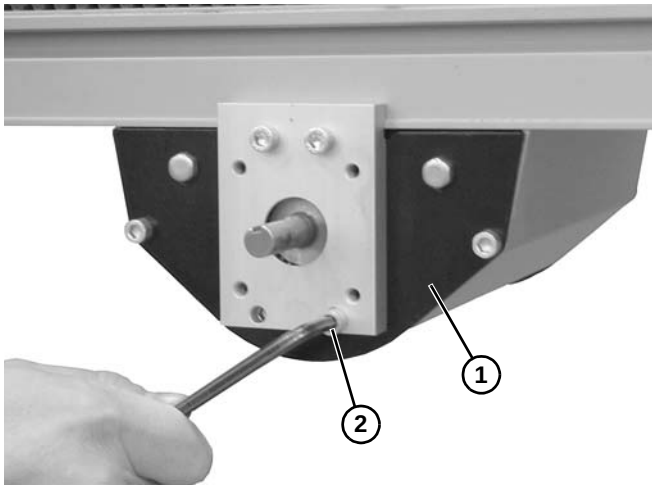


Figure 91

11. Tighten socket head screws **(Figure 89, item 2)** to 60 in-lb (7 Nm).
12. Tension conveyor belt. See “Conveyor Belt Tensioning” on page 20.

Tail Plate Shaft Knockout Removal

1. Determine which tail plate(s) require the hole knockout slug to be removed for the drive shaft.
   - Position A or B = 205370-LH
   - Position C or D = 205370-RH
2. Set tail plate **(Figure 92, item 1)** flat side down over washer **(Figure 92, item 2)** or hole in workbench that has a minimum diameter of 5/8".

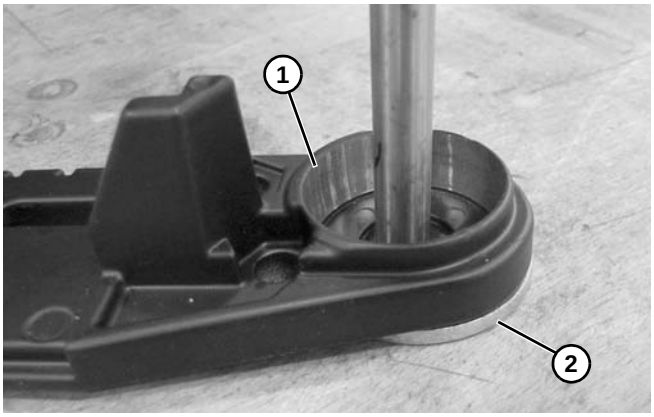


Figure 92

3. Use a hammer and punch (1/4" - 1/2" dia) **(Figure 93, item 1)** or long bolt to knock out slug **(Figure 94, item 1)** for shaft backing up tail plate with washer.

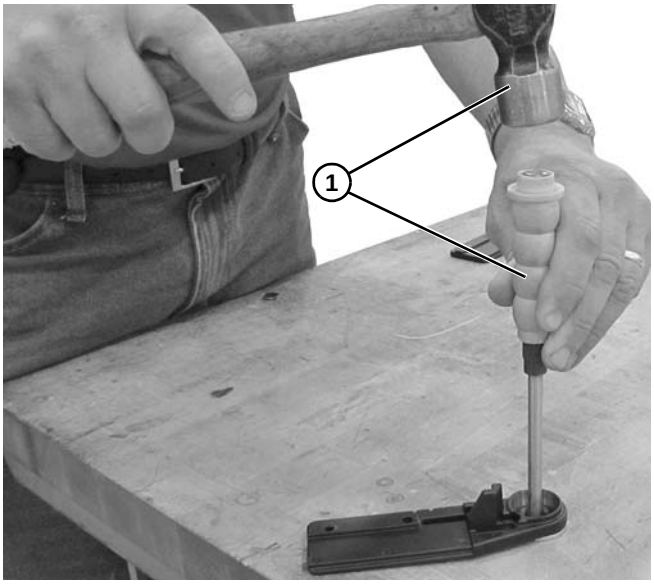


Figure 93

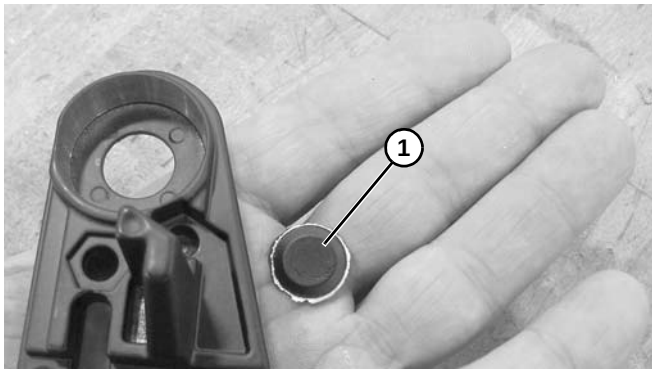


Figure 94

4. Repeat the same operation to knockout **(Figure 96, item 1)** for alignment screw hole using 1/8" - 3/16" punch **(Figure 95, item 1)** or M5 - M6 bolt.

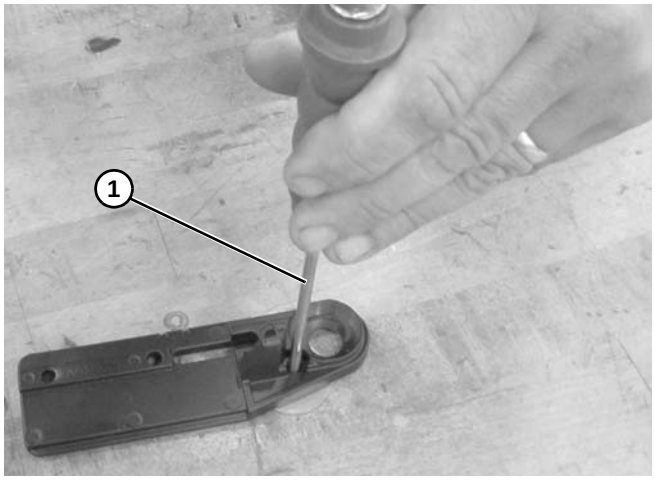


Figure 95

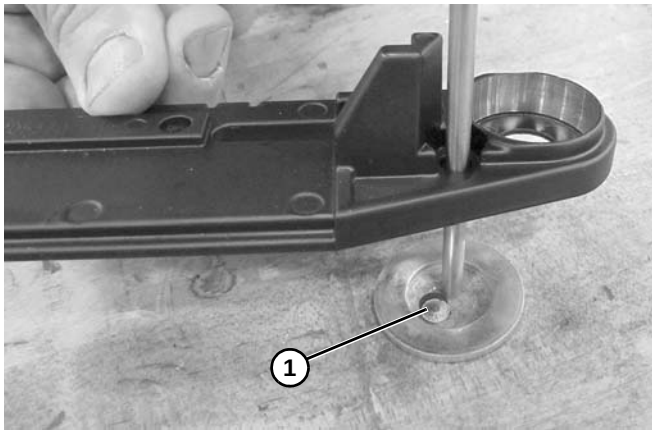


Figure 96

Pinion Replacement

1. Remove conveyor belt. See "Conveyor Belt Replacement" section on page 17.
2. Remove idler tail **(Figure 97, item 1)** by sliding off of the conveyor **(Figure 97, item 2)**.

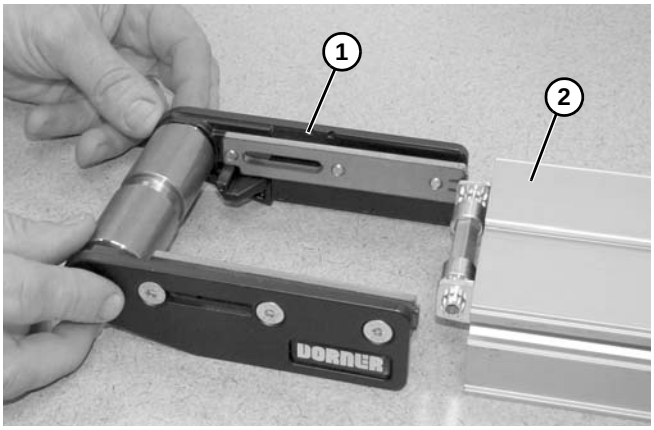


Figure 97

3. Pry pinion assembly **(Figure 98, item 1)** from conveyor frame by alternating sides.

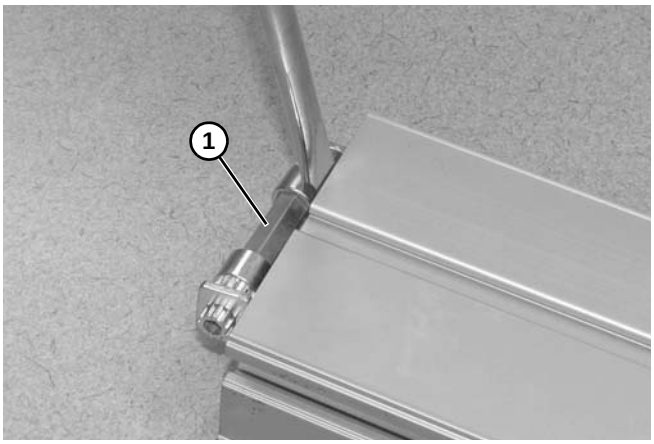


Figure 98

4. Replace worn components.

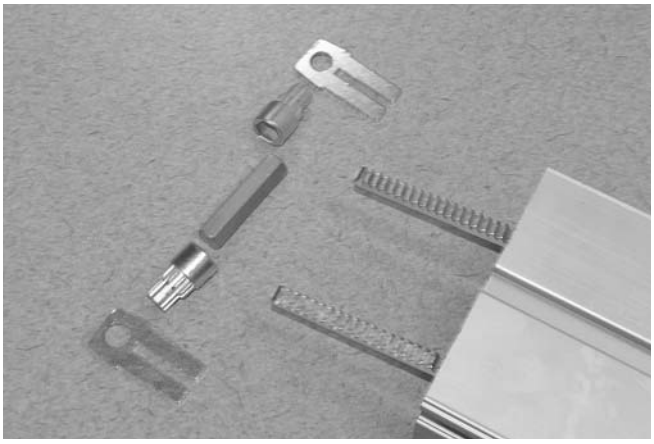


Figure 99

5. To reassemble, make sure that the lines **(Figure 100, item 1)** on the pinion end gears **(Figure 100, item 2)** are aligned.

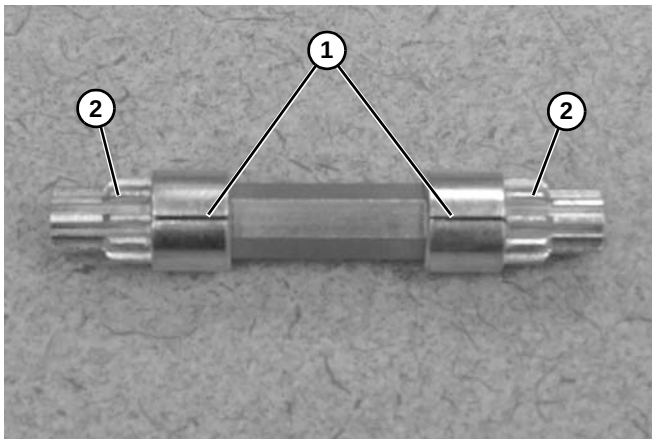


Figure 100

6. Slide on retaining plates **(Figure 101, item 1)**.

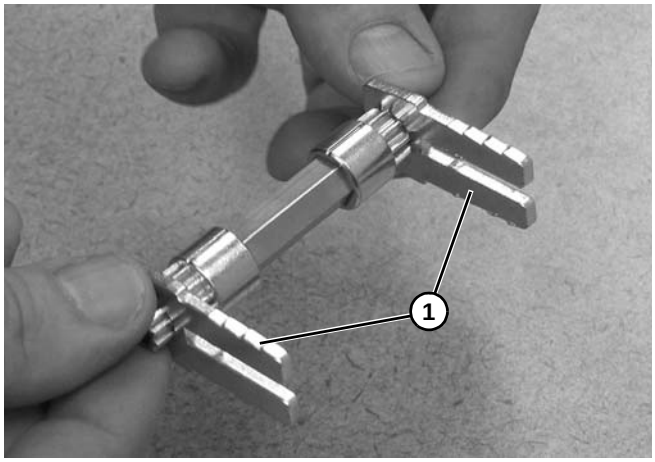


Figure 101

7. Insert pinion assembly **(Figure 102, item 1)** into conveyor frame.

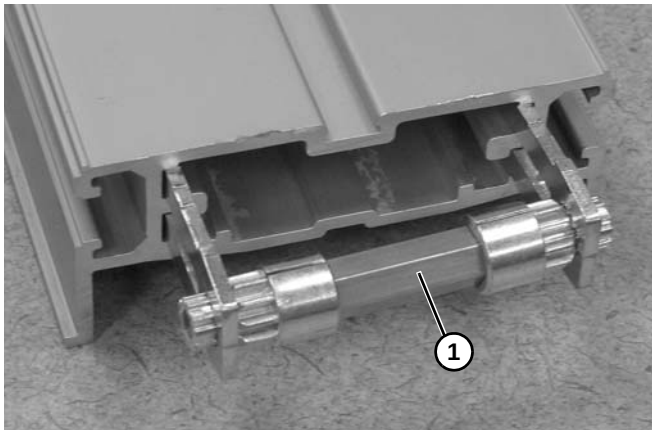


Figure 102

8. Tap alternating retaining plates **(Figure 103, item 1)** and **(Figure 104, item 1)** with a hammer until fully assembled onto conveyor frame.

⚠ CAUTION

Do not hit pinion gear with hammer. It may cause damage to the pinion teeth.

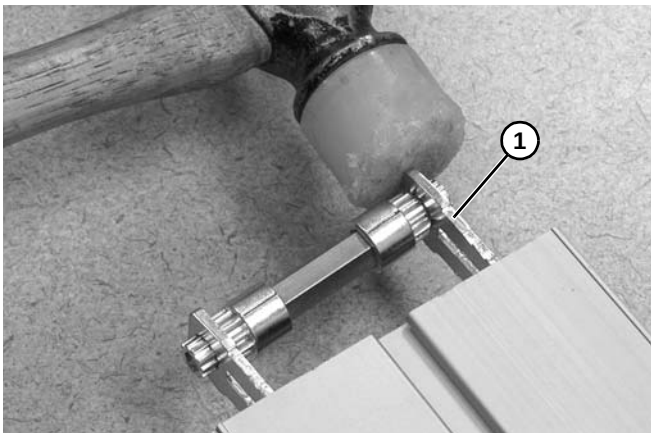


Figure 103

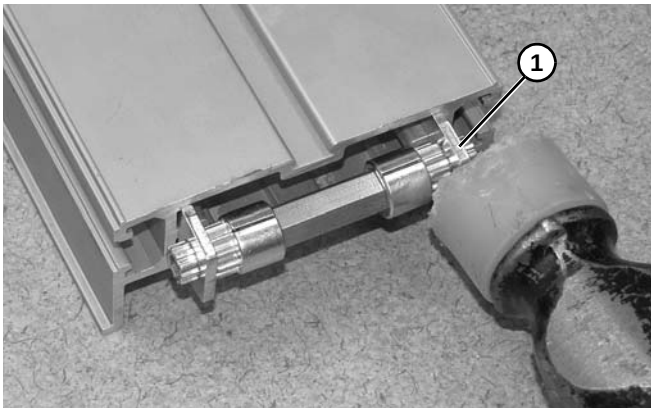


Figure 104

9. Insert both gear racks **(Figure 105, item 1)** into conveyor frame.

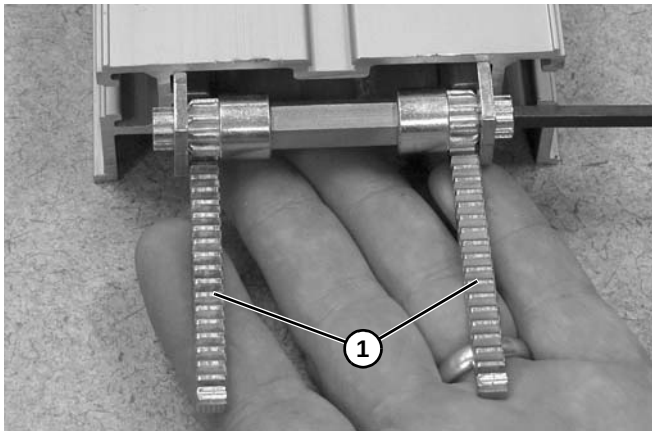


Figure 105

NOTE

*Make sure the bent end **(Figure 106, item 1)** of the gear rack is NOT assembled into the conveyor frame.*

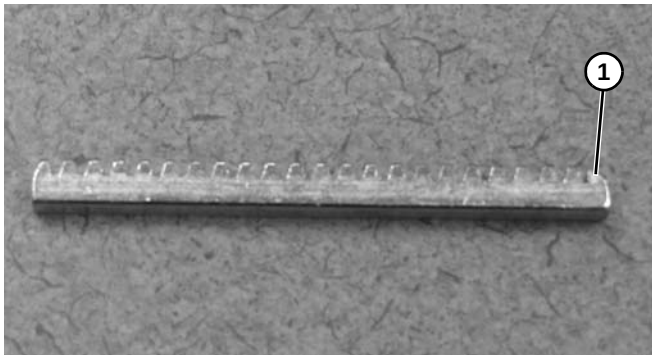


Figure 106

10. Rotate pinion **(Figure 107, item 1)** with hex wrench until gear racks **(Figure 107, item 2)** are fully collapsed.

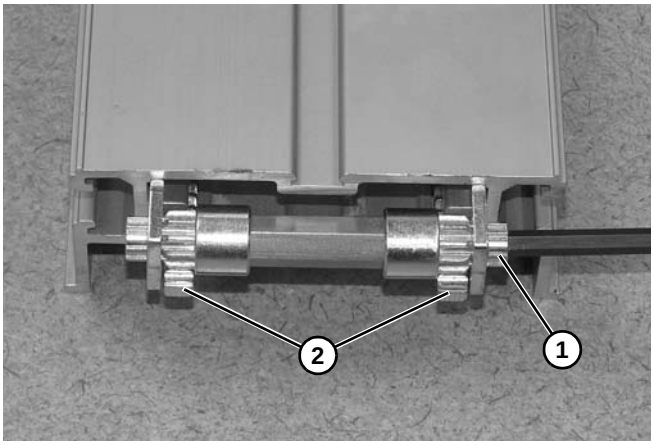


Figure 107

NOTE

The gear racks must be aligned with each other, as shown above. Example of misaligned gear racks shown below.

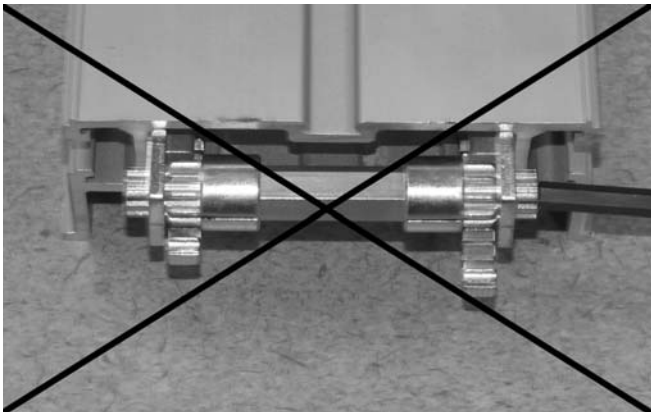


Figure 108

11. Reinstall idler tail by sliding tail assembly **(Figure 109, item 1)** fully back onto conveyor frame.

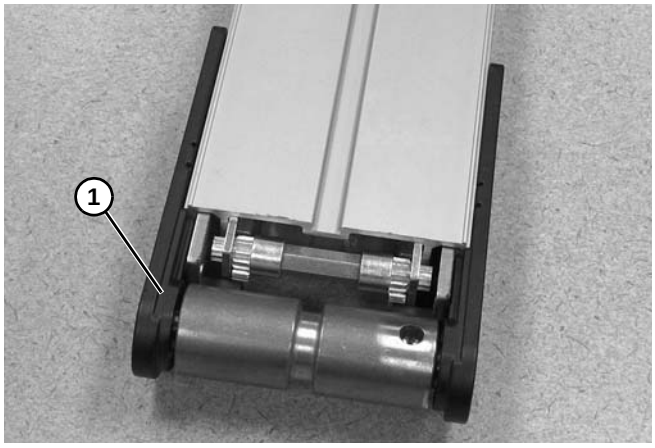


Figure 109

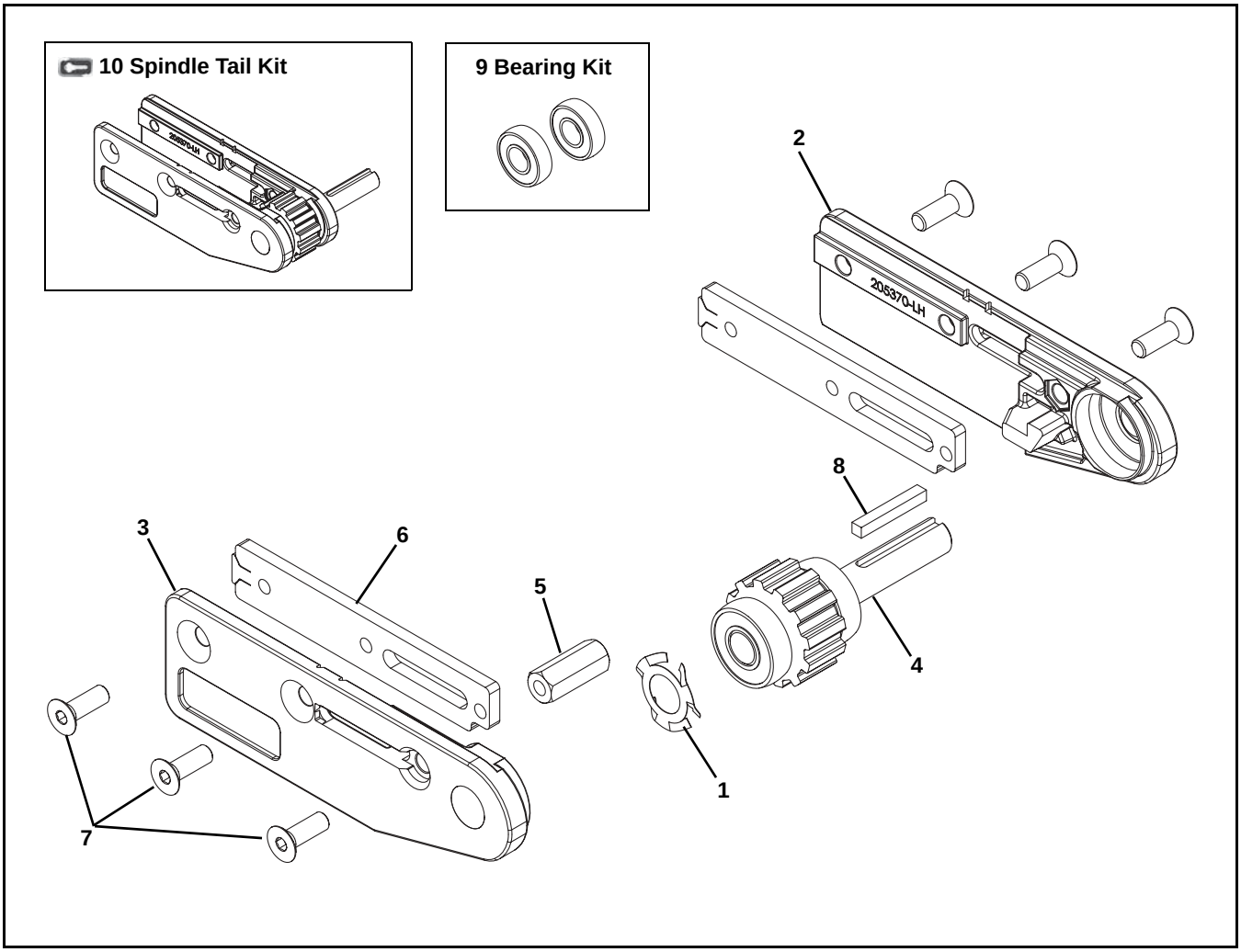
12. Reinstall belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 20.

Notes

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 Tail for 1" (25 mm) wide Conveyor

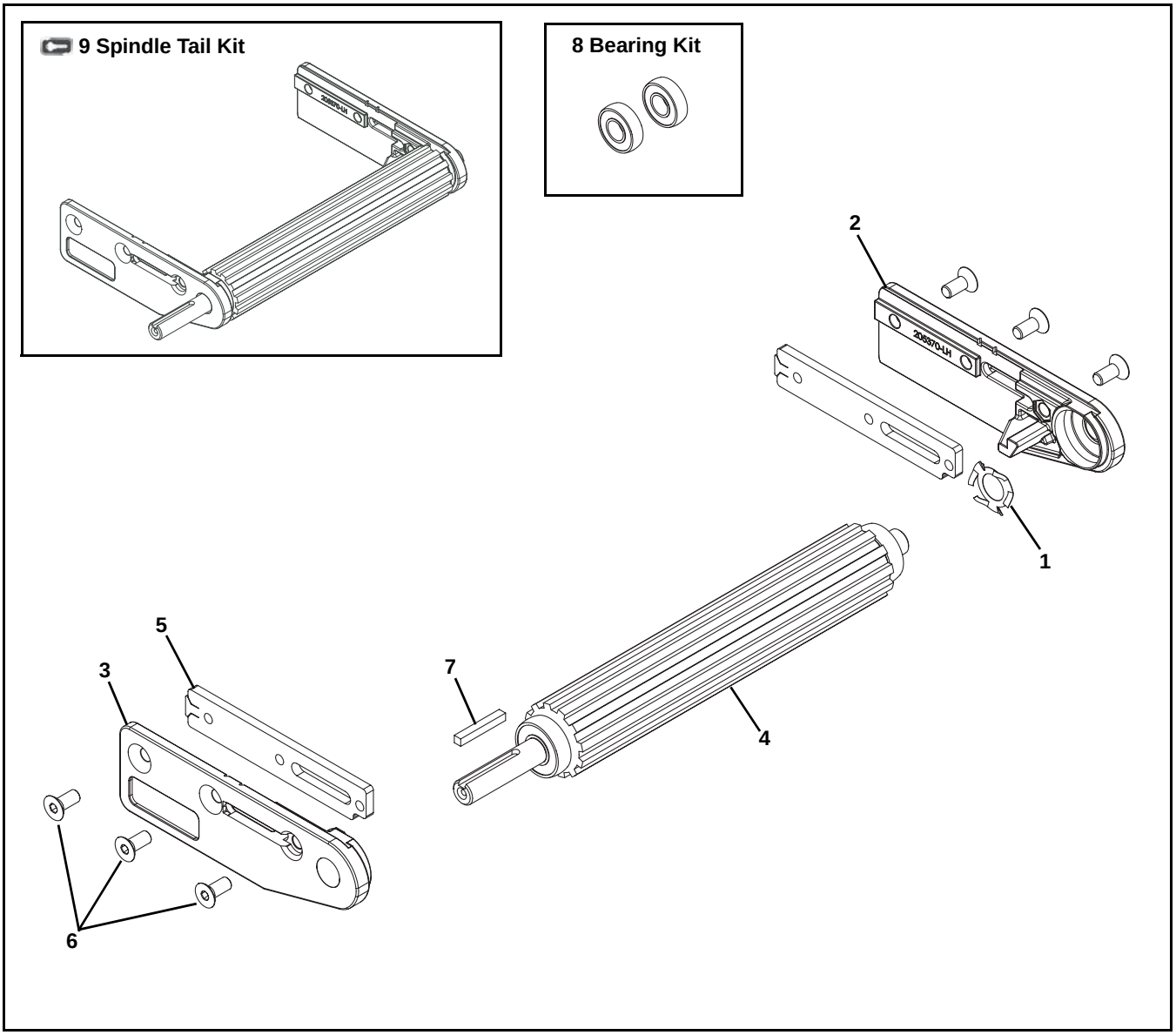


Item	Part Number	Description
1	807-2108	Spring Disk
2	207140-LH	Head Plate, Left Hand
3	207140-RH	Head Plate, Right Hand
4	202514-01	Spindle Assembly (One Keyed Shaft)
	202517-01	Spindle Assembly (Two Keyed Shafts)
	202516-01	Spindle Assembly - Common Drive (Keyed Shaft & Stub Shaft)
	202518-01	Spindle Assembly - Mid Common Drive (Two Stub Shafts)
	202515-01	Spindle Assembly - End Common Drive (One Stub Shaft)
5	807-2862	Hex Standoff
6	206006	Tail Nut Bar

Item	Part Number	Description
7	930618M	Flat Head Screw, M6-1.00 x 18 mm
8	980428M	Square Key 4 mm x 28 mm
9	22BK2	Bearing Kit (2 pack)
	22BK4	Bearing Kit (4 pack)
10	22PMDS-01	Spindle Tail Kit (Includes Items 1 - 4)
	22PMDDS-01	Dual Shaft Spindle Tail Kit (Includes Items 1 - 4)
	22PMDSC-01	Common Drive Spindle Tail Kit (Includes Items 1 - 4)
	22PMDDC-01	Mid Common Drive Spindle Tail Kit (Includes Items 1 - 4)
	22PMDC-01	End Common Drive Spindle Tail Kit (Includes Items 1 - 4)

Service Parts

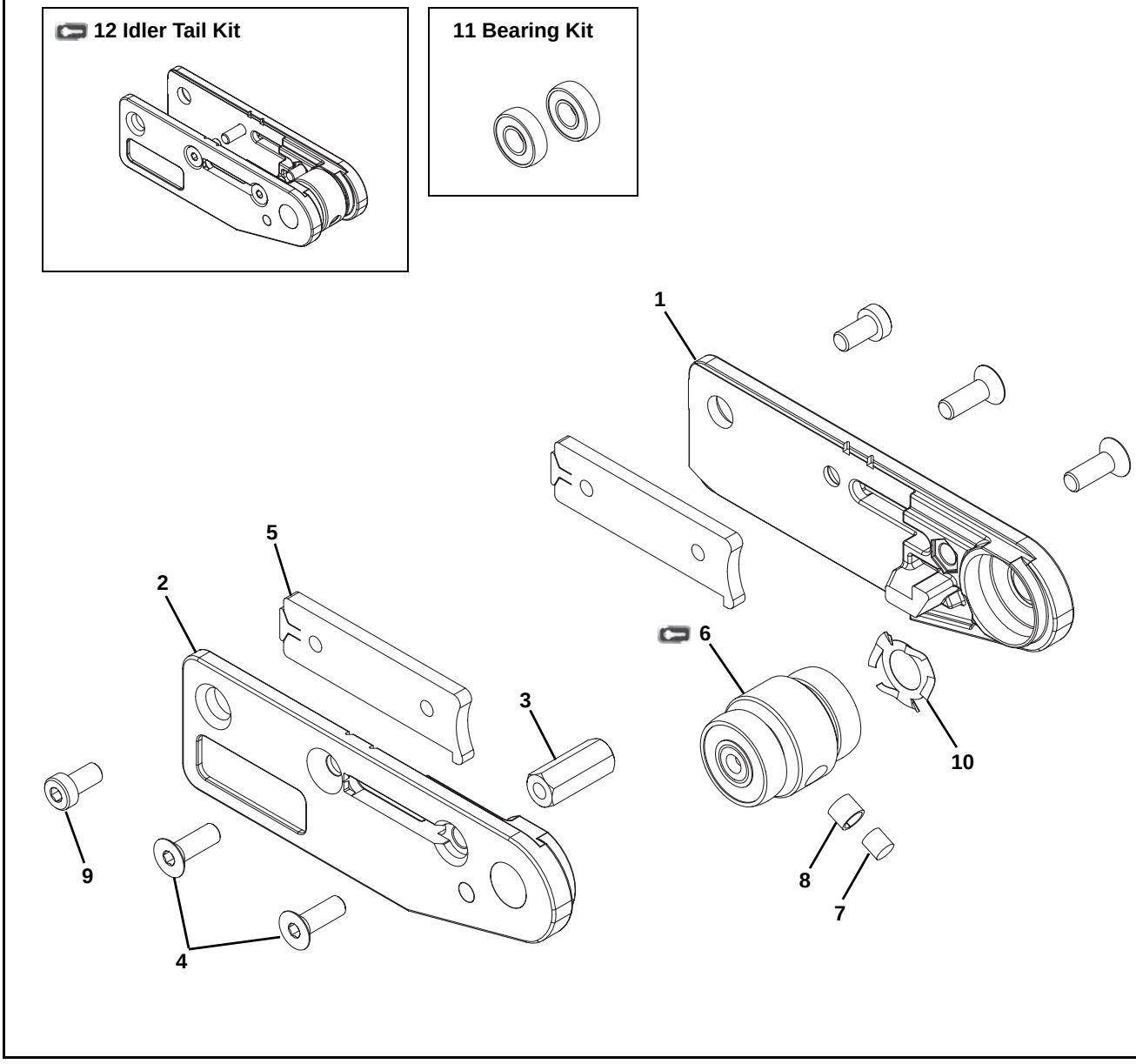
Drive Tail for 1.75" (44 mm) wide or wider Conveyor



Item	Part Number	Description
1	807-2108	Spring Disk
2	205370-LH	Head Plate, Left Hand
3	205370-RH	Head Plate, Right Hand
4	202514-WW	Spindle Assembly (One Keyed Shaft)
	202517-WW	Spindle Assembly (Two Keyed Shafts)
	202516-WW	Spindle Assembly - Common Drive (Keyed Shaft & Stub Shaft)
	202518-WW	Spindle Assembly - Mid Common Drive (Two Stub Shafts)
	202515-WW	Spindle Assembly - End Common Drive (One Stub Shaft)
5	206006	Tail Nut Bar
6	930614M	Flat Head Screw, M6-1.00 x 14 mm
7	980428M	Square Key 4 mm x 28 mm

Item	Part Number	Description
8	22BK2	Bearing Kit (2 pack)
	22BK4	Bearing Kit (4 pack)
9	22PMDS-WW	Spindle Tail Kit (Includes Items 1 - 4)
	22PMDDS-WW	Dual Shaft Spindle Tail Kit (Includes Items 1 - 4)
	22PMDSC-WW	Common Drive Spindle Tail Kit (Includes Items 1 - 4)
	22PMDDC-WW	Mid Common Drive Spindle Tail Kit (Includes Items 1 - 4)
	22PMDC-WW	End Common Drive Spindle Tail Kit (Includes Items 1 - 4)
WW = Conveyor width reference: 02, 03, 04, 06, 08, 12, 18, 24		

Idler Tail for 1" (25 mm) wide Conveyor

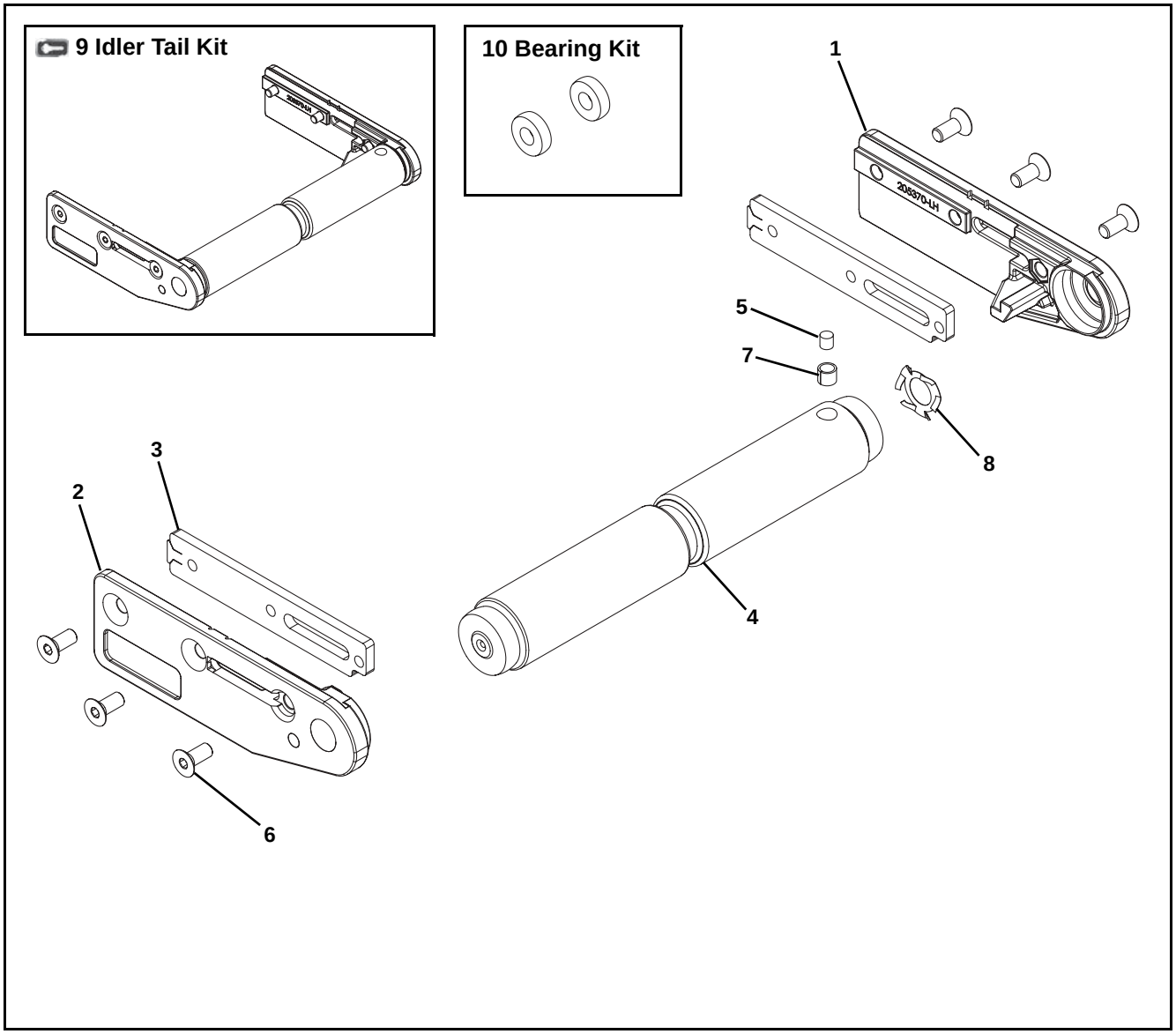


Item	Part Number	Description
1	207141-LH	Head Plate, Left Hand
2	207141-RH	Head Plate, Right Hand
3	807-2862	Hex Standoff
4	930618M	Flat Head Screw, M6-1.00 x 18 mm
5	203639	Nut Bar
6	201273-01	Spindle Assembly
	202515-01	Spindle Assembly with One Stub Shaft
	202514-01	Spindle Assembly with Auxiliary Keyed Shaft
7	808-020	Magnet (Optional)
8	450226SSP	Magnet Sleeve (Optional)

Item	Part Number	Description
9	920612M	Low Head Cap Screw, M6-1.00 x 12 mm
10	807-2108	Disc Spring with Auxiliary Shaft Spindle Only
11	22BK2	Bearing Kit (2 pack)
	22BK4	Bearing Kit (4 pack)
12	22V2TO-01	Idler Tail Kit (Includes Items 1, 2, 4, and 6)
	22V2TM-01	Idler Tail Kit with Magnet (Includes Items 1, 2, 4, 6, 7 and 8)
	22PMTC-01	Idler Tail Kit with Stub Shaft (Includes Items 1, 2, 4, and 6)
	22PMTS-01	Idler Tail Kit with Auxiliary Shaft (Includes Items 1, 2, 4, and 6)

Service Parts

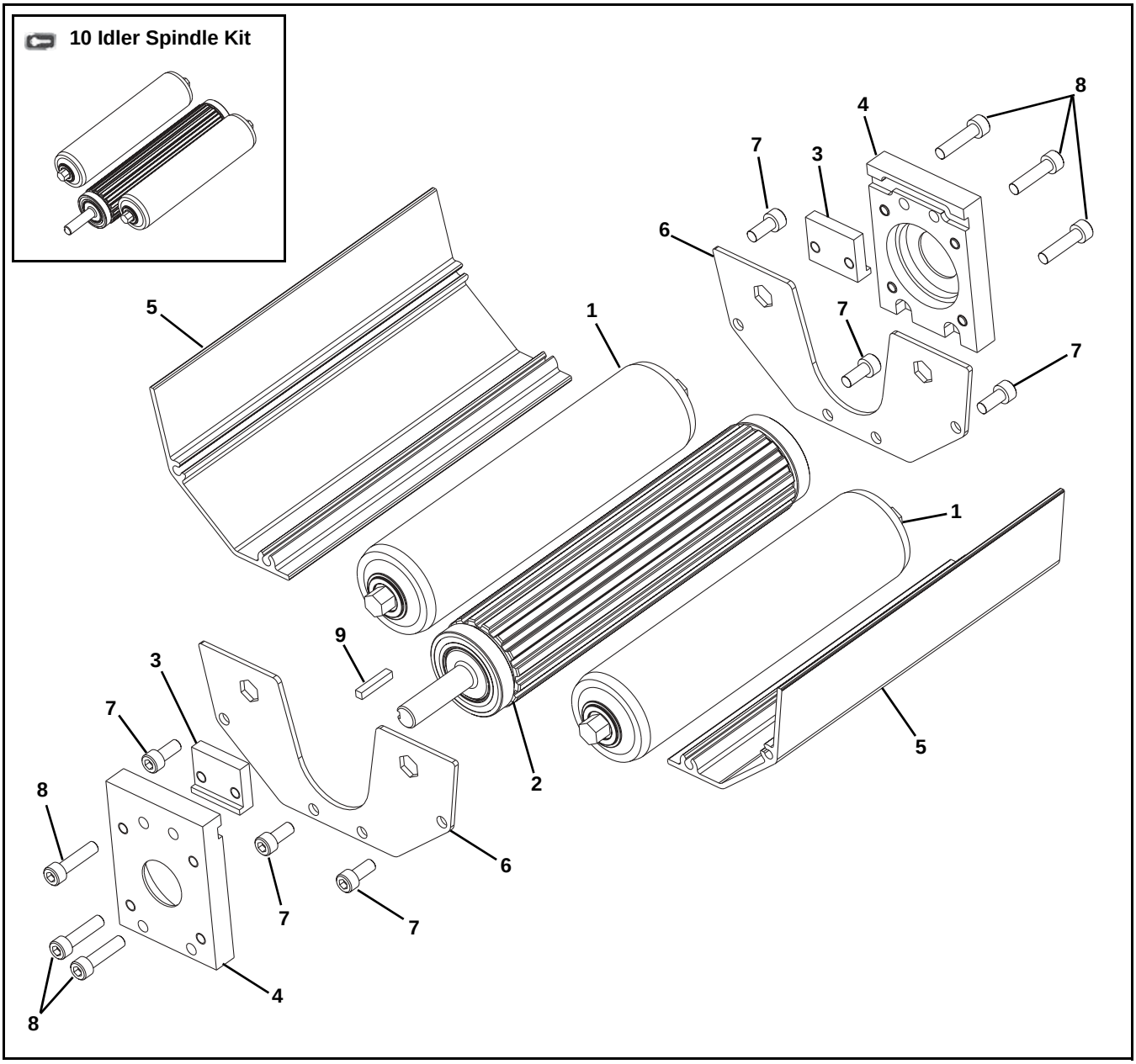
Idler Tail for 1.75" (44 mm) wide or wider Conveyor



Item	Part Number	Description
1	205370-LH	Head Plate, Left Hand
2	205370-RH	Head Plate, Right Hand
3	206006	Tail Nut Bar
4	201273-WW	Standard Spindle Assembly
	202515-WW	Spindle Assembly with One Stub Shaft
	202514-WW	Spindle Assembly with Auxiliary Keyed Shaft
5	808-020	Magnet (Optional)
6	930614M	Flat Head Screw, M6-1.00 x 10.7 mm
7	450226SSP	Magnet Sleeve (Optional)
8	807-2108	Disc Spring with Auxiliary Shaft Spindle Only

Item	Part Number	Description
9	22V2TO-WW	Standard Idler Spindle Kit (Includes Items 1, 2, 4, and 6)
	22V2TM-WW	Idler Tail Kit with Magnet (Includes Items 1, 2, 4, 5, 6, and 7)
	22PMDC-WW	Idler Tail Kit with Stub Shaft (Includes Items 1, 2, 4, and 6)
	22PMDS-WW	Idler Tail Kit with Auxiliary Shaft (Includes Items 1, 2, 4, and 6)
10	22BK2	Bearing Kit (2 Pack)
	22BK4	Bearing Kit (4 Pack)
WW = Conveyor width reference: 02, 03, 04, 06, 08, 12, 18, 24		

Mid Drive Module



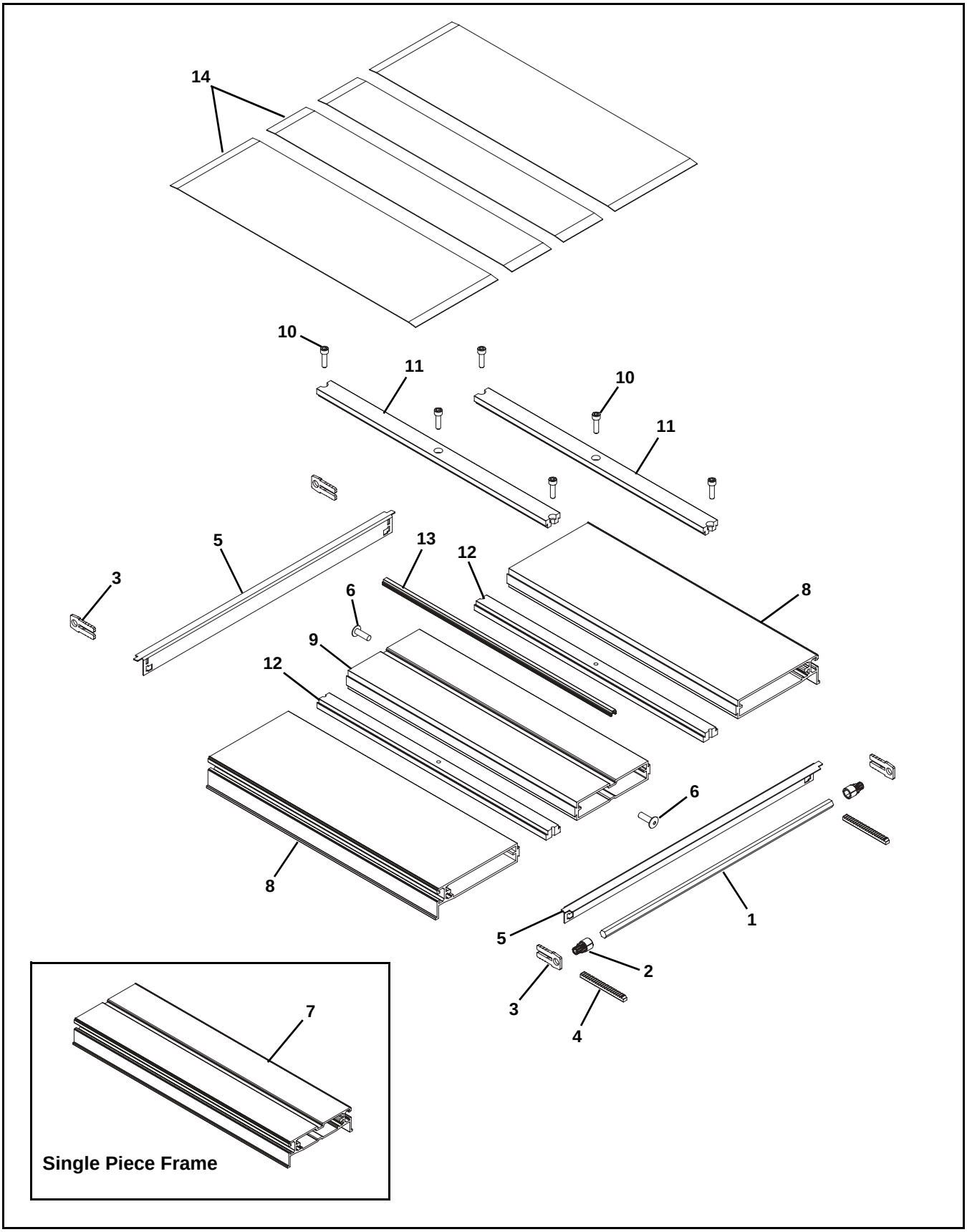
Item	Part Number	Description
1	203980	Idler Roller Assembly for 1" wide conveyors
	463040	Idler Roller Assembly for 2" wide conveyors
	463041	Idler Roller Assembly for 3" wide conveyors
	463042	Idler Roller Assembly for 4" wide conveyors
	203635-WW	Idler Roller Assembly for 5" wide and wider conveyors
2	202447-WW	Spindle Assembly
	202335-WW	Drive Pulley for 2"-6" wide Gang Drive Conveyors
	202332-WW	Drive Pulley for 8"-24" wide Gang Drive Conveyors

Item	Part Number	Description
3	202353	Clamp Block
4	202354	Mounting Block
5	202455-WW	Bottom Guard
6	202355	Side Plate
7	708180P	Trilobe Screw, M6-1.00 x 25 mm
8	920625M	Socket Head Screw, M6-1.00 x 25 mm
9	980428M	Square Key 4 mm x 28 mm
10	22PMMD-WW	Spindle Kit (Includes items 1 & 2)
	22PMGMD-WW	Gang Drive Spindle Kit (Includes items 1 & 2)

WW = Conveyor width reference: 01, 02, 03, 04, 06, 08, 12, 18, 24

Service Parts

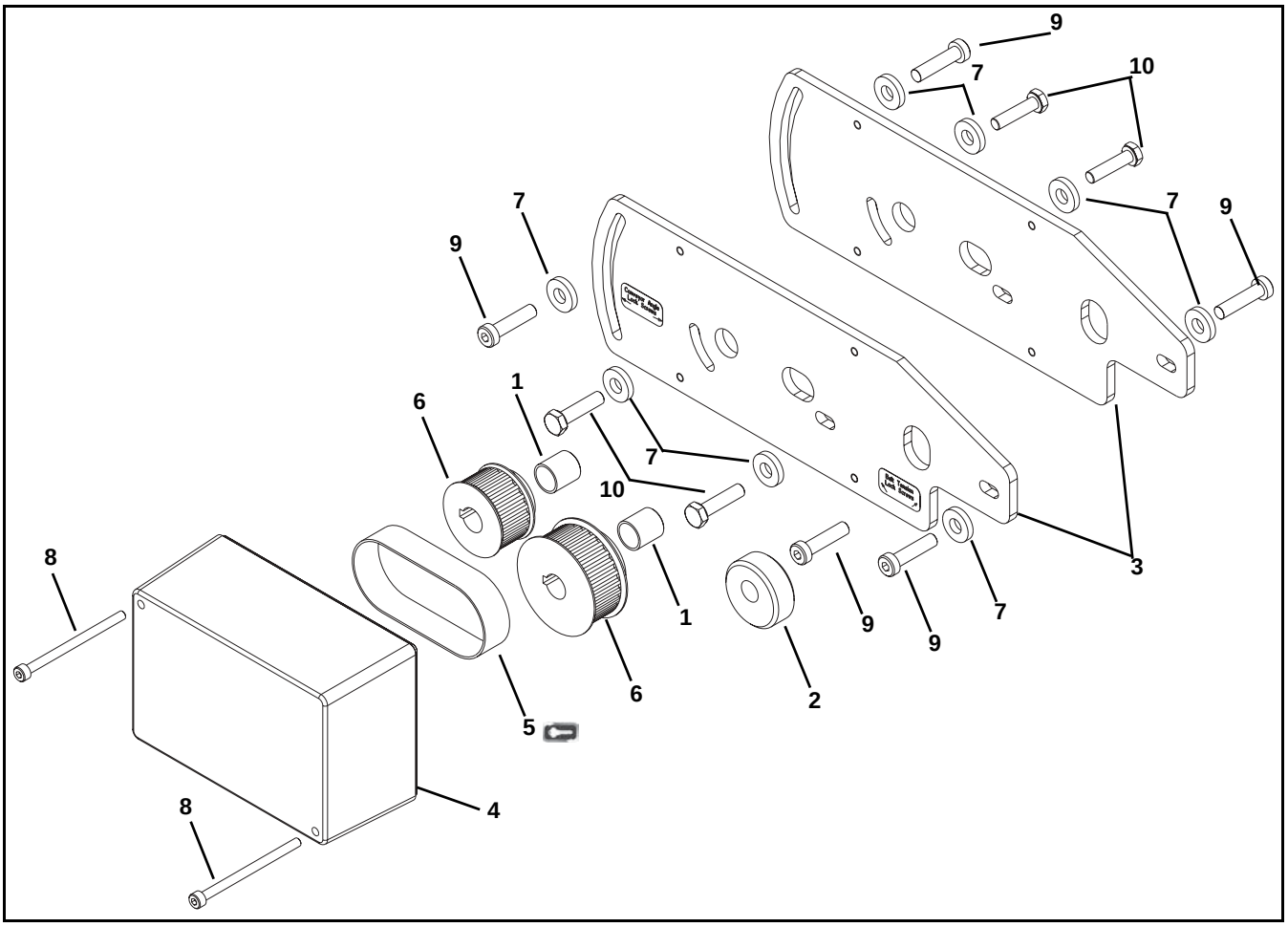
Frame



Item	Part Number	Description
1	205469-WW	Hex Pinion, for 3"-24" wide Conveyors
2	207145	Pinion Gear, for 2" wide Conveyors
	205383	Pinion End Gear, for 3"-24" wide conveyors
3	205450	Retaining Plate, for 2"-24" wide conveyors
4	203595	Gear Rack, for 2"-24" wide conveyors
5	207144	Lead In for 1" wide conveyor
	207148-WW	Lead In for 2" wide and wider conveyor
6	914-005	Rivet for 1" wide conveyors
7	203629-WW-LLLLL	Single Piece Frame, for 1"-12" wide conveyors
8	205393-LLLLL	Outside Frame, for Multi Piece 14" & 20" wide conveyors (Qty. 2)
	205394-LLLLL	Outside Frame, for Multi Piece 16" & 22" wide conveyors (Qty. 2)
	205395-LLLLL	Outside Frame, for Multi Piece 18" & 24" wide conveyors (Qty. 2)
9	205396-LLLLL	Mid Frame, for Multi Piece 14"-18" wide conveyors
	205398-LLLLL	Mid Frame, for Multi Piece 20"-24" wide conveyors
10	920622M	Socket Head Screw, M6-1.00 x 22 mm, for 2"-24" wide conveyors
11	206505-LLLLL	Upper Connecting Strip for 14"-24" wide conveyors
12	206506-LLLLL	Lower Connecting Strip for 14"-24" wide conveyors
13	205449-LLLLL	Center Guide Extrusion, for 2"-24" wide conveyors
14	807-2869	UHMW Tape .25" wide
	807-2870	UHMW Tape .625" wide
	807-2871	UHMW Tape 1.125" wide
	807-2872	UHMW Tape 2.75" wide
	807-2054	UHMW Tape 5.75" wide
WW = Conveyor width reference: 01, 02, 03, 04, 06, 08, 12, 18, 24		
LLLLL = Part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

Slave Drive



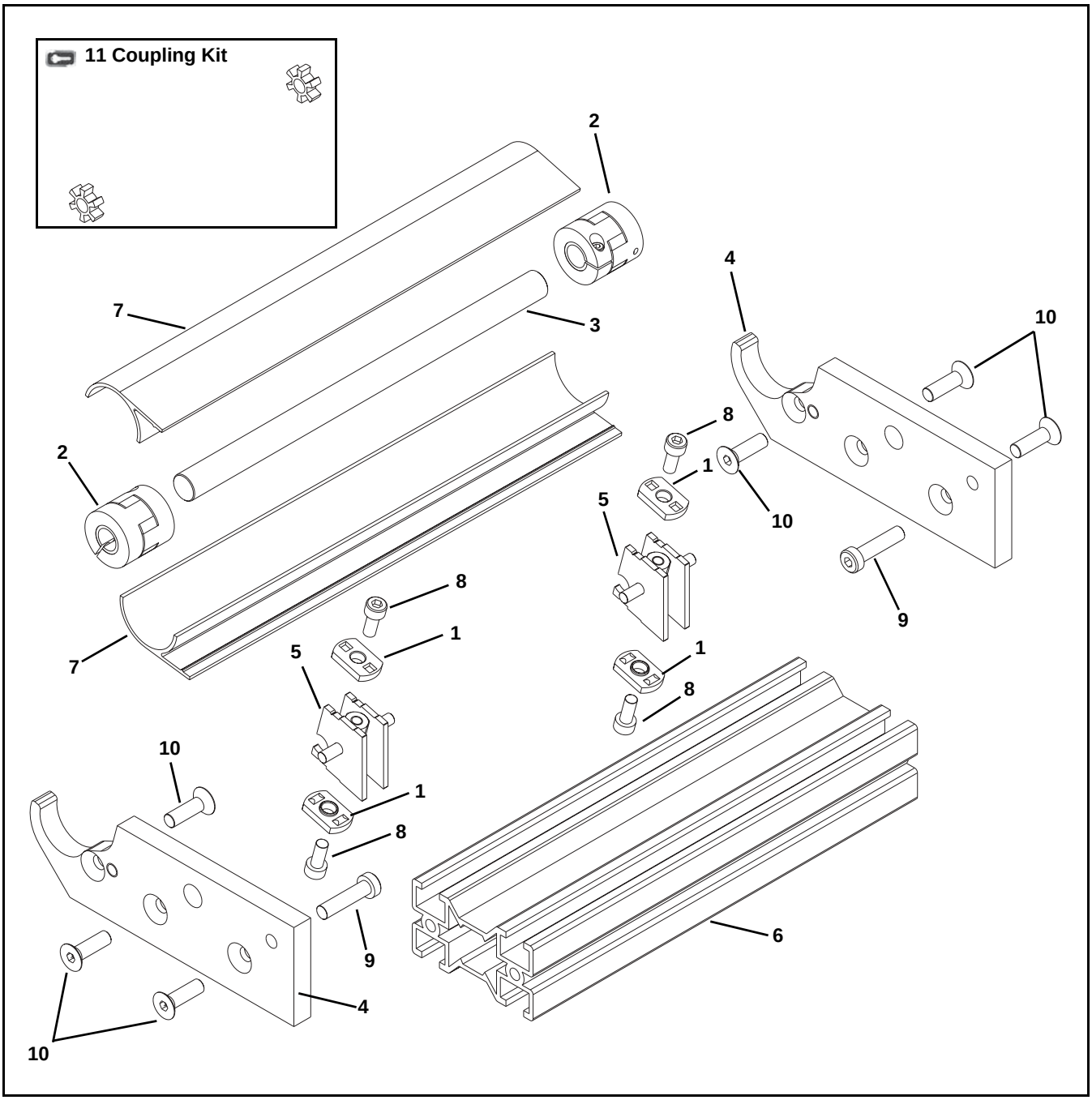
Item	Part Number	Description
1	801-144	Bearing
2	202361	Cam Knob
3	202362	Slave Drive Plate
4	202482	Guard Box
5	814-421	Timing Belt, 215 mm Long
	814-080	Timing Belt, 200 mm Long
6	202497	Pulley 16 Tooth
	452366MP	Pulley 22 Tooth
	450367MP	Pulley 28 Tooth
	450368MP	Pulley 32 Tooth

Item	Part Number	Description
7	605279P	Washer
8	920460M	Socket Head Screw, M4-.70 x 60 mm
9	920695M	Low Head Cap Screw, M6-1.00 x 25 mm
10	960625MSS	Hex Head Cap Screw, M6-1.00 x 25 mm

Slave Drive Belt and Pulley Chart

Ratio	Belt	Drive Pulley	Driven Pulley	Pulley Kit
0.50	814-421	202497	450368MP	16:32
0.57	814-080	202497	450367MP	16:28
0.79	814-421	452366MP	450367MP	22:28
1.00	814-080	452366MP	450366MP	22:22
1.27	814-421	452367MP	450366MP	28:22
1.75	814-080	452367MP	202497	28:16
2.00	814-421	452368MP	202497	32:16

Common Drive

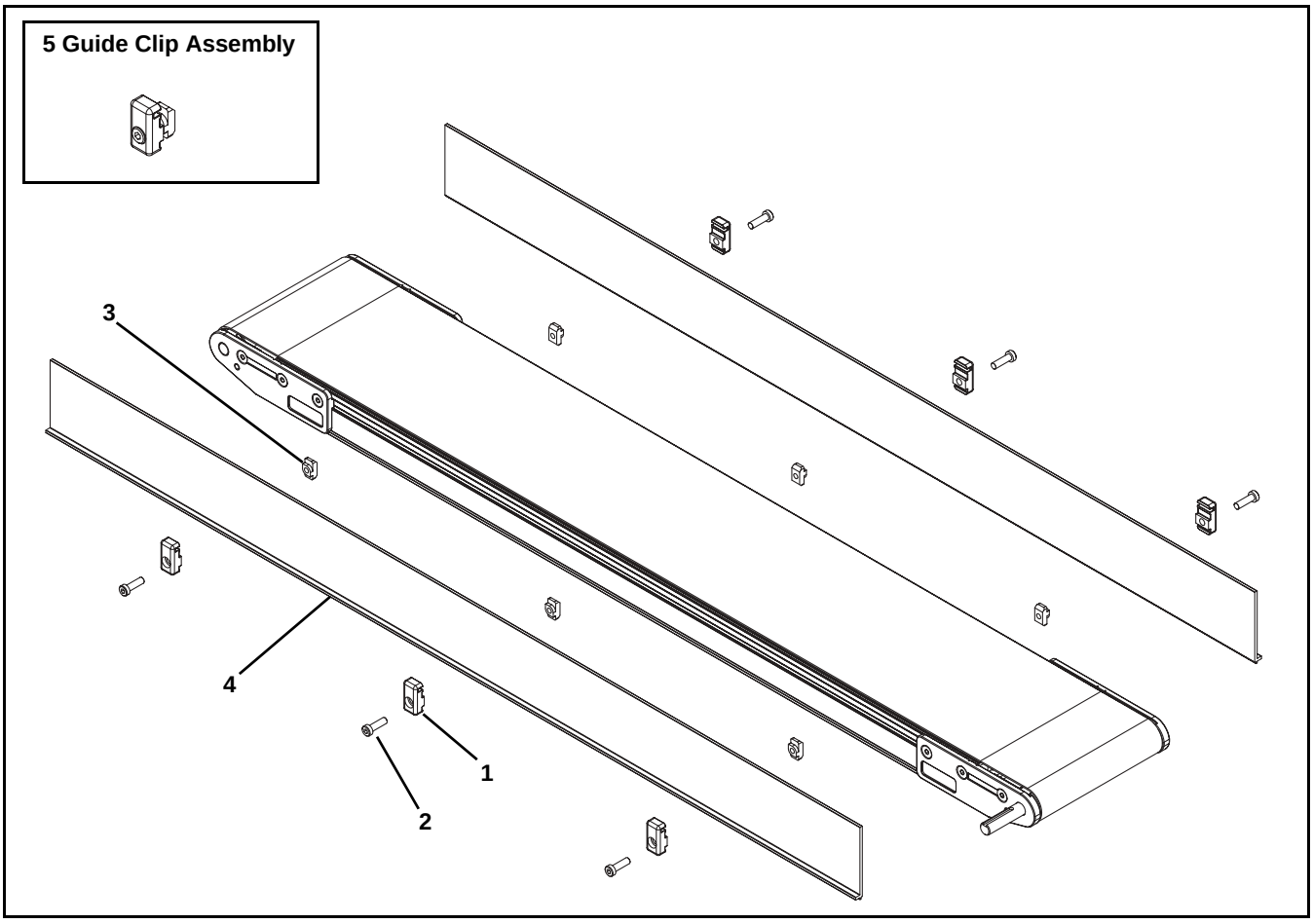


Item	Part Number	Description
1	807-2005	Weld Nut M6-1.00
2	807-2095	3 Jaw Coupling
3	202438-LLLLL	Shaft
4	202494	Alignment Block
5	202501	Guard Plate Assembly
6	202498-LLLLL	Tie Tube
7	242526-LLLLL	Guard
8	920512M	Socket Head Screw, M5-.80 x 12 mm
9	920695M	Low Head Cap Screw, M6-1.00 x 25 mm

Item	Part Number	Description
10	930620M	Flat head Screw, M6-1.00 x 20 mm
11	22PMCD	Coupling Kit
LLLLL = Part length in inches with 2 decimal places.		
Length Example: Length = 35.25" LLLLL = 03525		

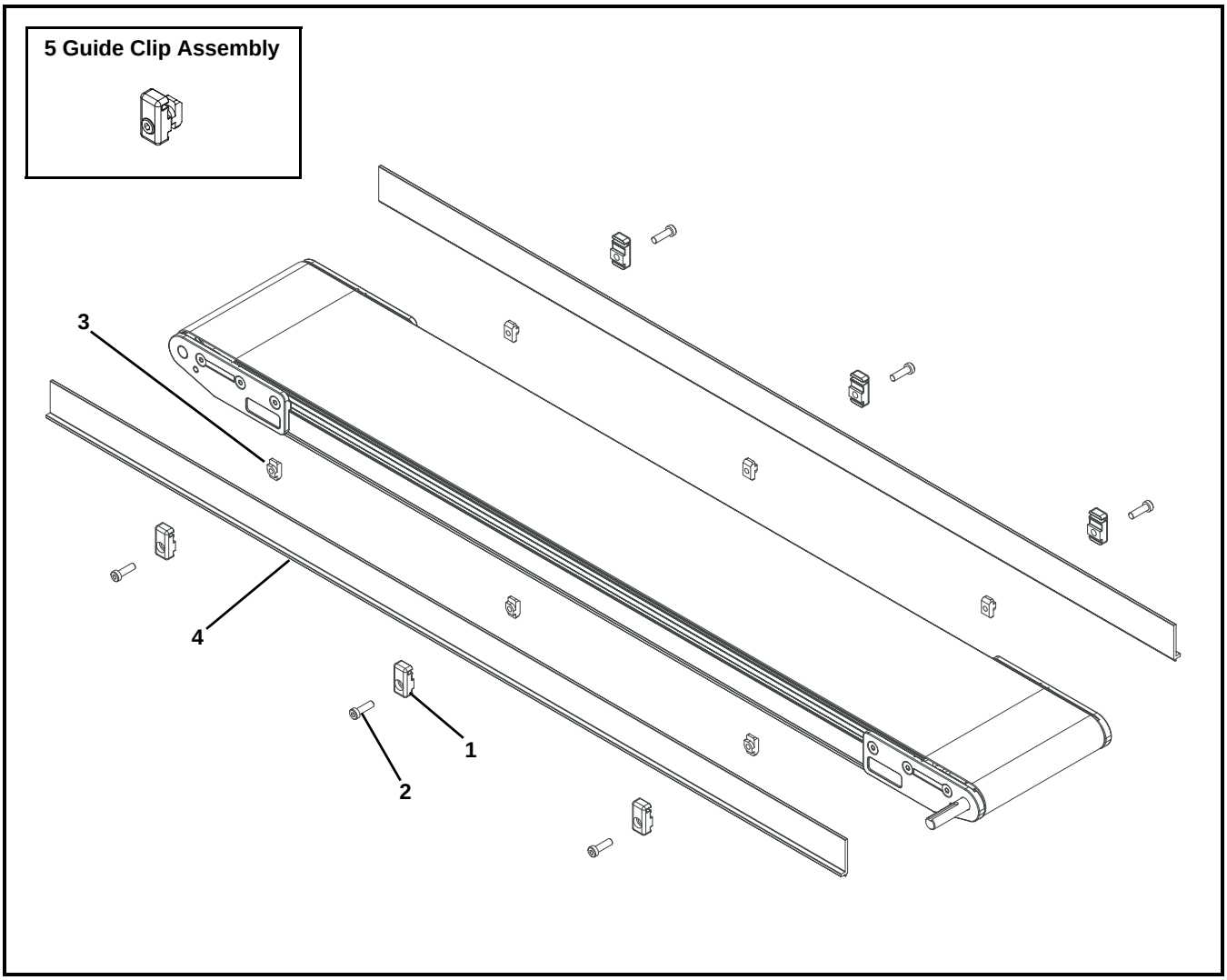
Service Parts

#04 Profile - 3.00" (76 mm) Aluminum Side



Item	Part Number	Description
1	206503	Guide Clip
2	807-2878	Low Head Cap Screw, M6-1.00 x 16 mm
3	206685	T-Nut
4	206514-LLLLL	3.00" Guides
	GTB04A04	3.00" Guides 4' long
	GTB04A08	3.00" Guides 8' long
5	203661	Guide Clip Assembly (Includes items 1, 2, and 3)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

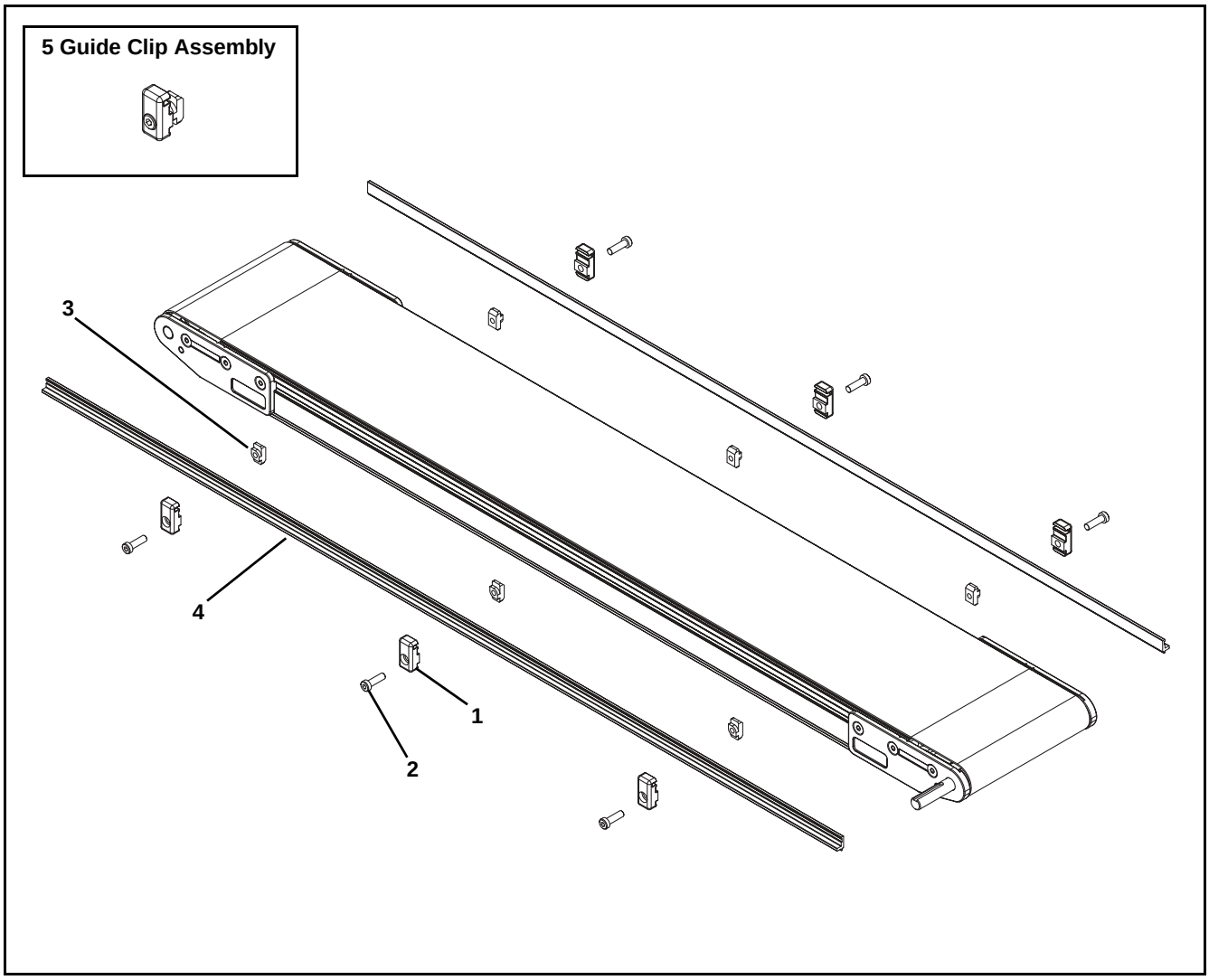
#05 Profile - 1.50" (38 mm) Aluminum Side



Item	Part Number	Description
1	206503	Guide Clip
2	807-2878	Low Head Cap Screw, M6-1.00 x 16 mm
3	206685	T-Nut
4	206513-LLLLL	1.50" Guides
	GTB05A04	1.50" Guides 4' long
	GTB05A08	1.50" Guides 8' long
5	203661	Guide Clip Assembly (Includes items 1, 2, and 3)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

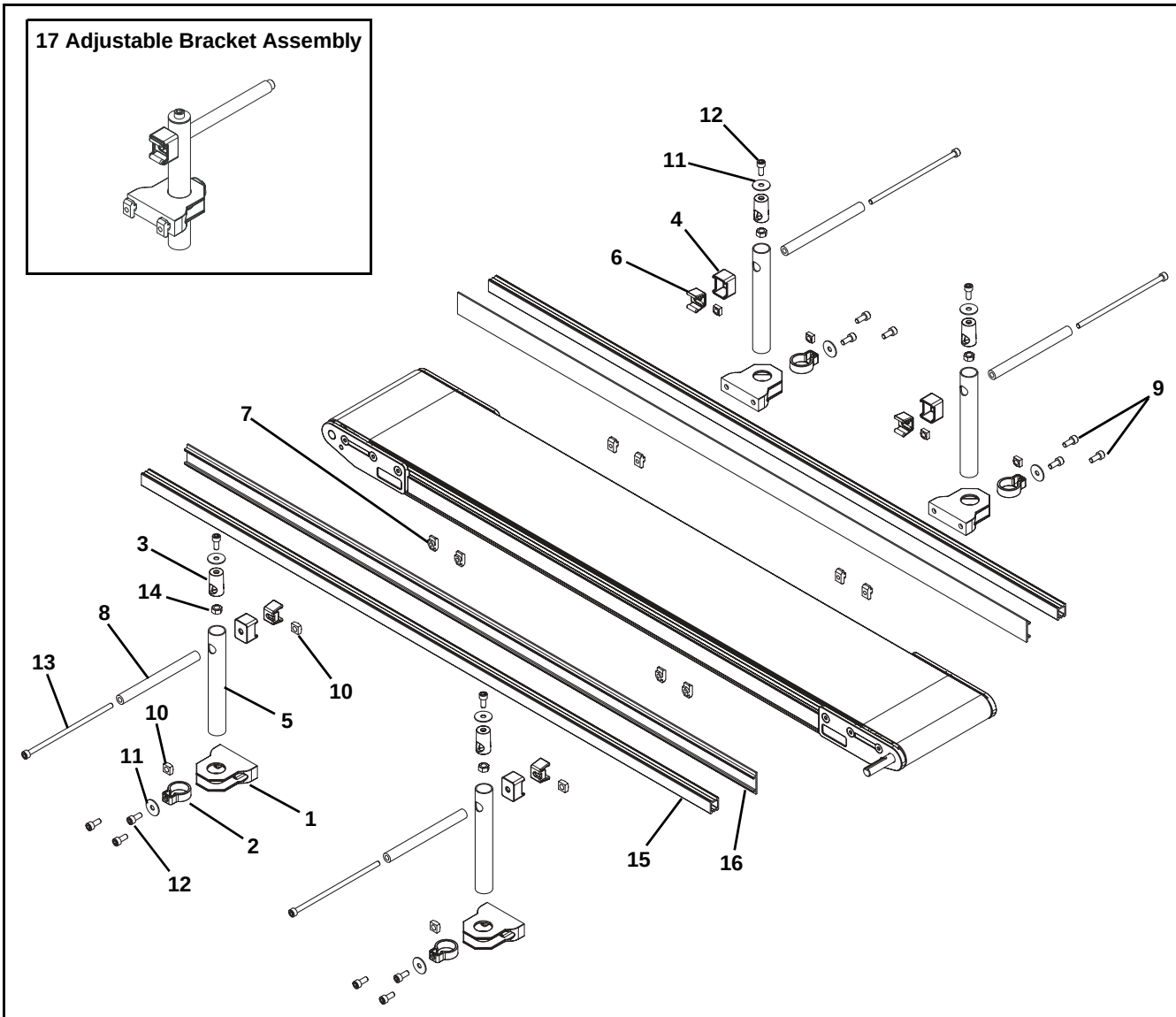
Service Parts

#09 Profile - Low to High Side



Item	Part Number	Description
1	206503	Guide Clip
2	807-2878	Low Head Cap Screw, M6-1.00 x 16 mm
3	206685	T-Nut
4	206512-LLLLL	.50" Guides
	GTB09A04	.50" Guides 4' long
	GTB09A08	.50" Guides 8' long
5	203661	Guide Clip Assembly (Includes items 1, 2, and 3)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

#13, 33 & 43 Profile - Adjustable Guiding

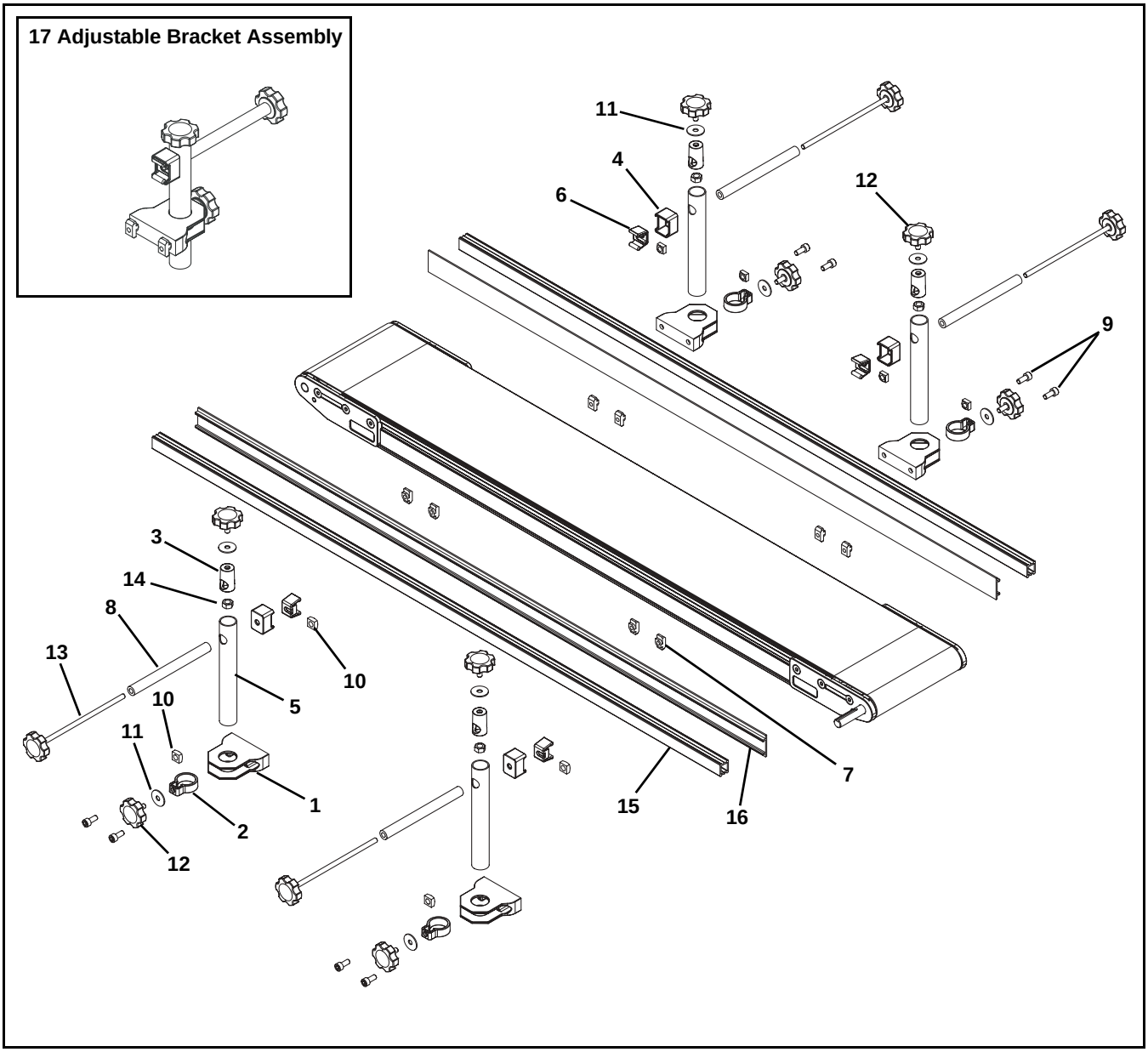


Item	Part Number	Description
1	206380	Base
2	206381	Base Clamp
3	206382	Insert Clamp
4	206383	Guide Ring
5	206385	Tube
6	206397	Clip
7	206685	T-Nut
8	206692	Guide Tube
9	807-2859	Nylon Cap Screw, N6 x 16 mm
10	807-920	Square Nut, M6-1.0
11	911-710	Washer
12	920616M	Socket Head Screw, M6-1.00 x 16 mm
13	9206150M	Socket Head Screw, M6-1.00 x 150 mm

Item	Part Number	Description
14	990601M	Hex Nut
15	834-238-LLLLL	Guide Rail
	GTB13A04	Guide Rail 4' long
	GTB13A08	Guide Rail 8' long
16	834-241	1.3" UHMW Guiding (per foot)
	GTB13B04	1.3" UHMW Guiding 4' long
	GTB13B08	1.3" UHMW Guiding 8' long
	206683	2" UHMW Guiding (per foot)
	GTB13C04	2" UHMW Guiding 4' long
	GTB13C08	2" UHMW Guiding 8' long
17	206686	Adjustable Bracket Assembly (Includes Items 1 through 14)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

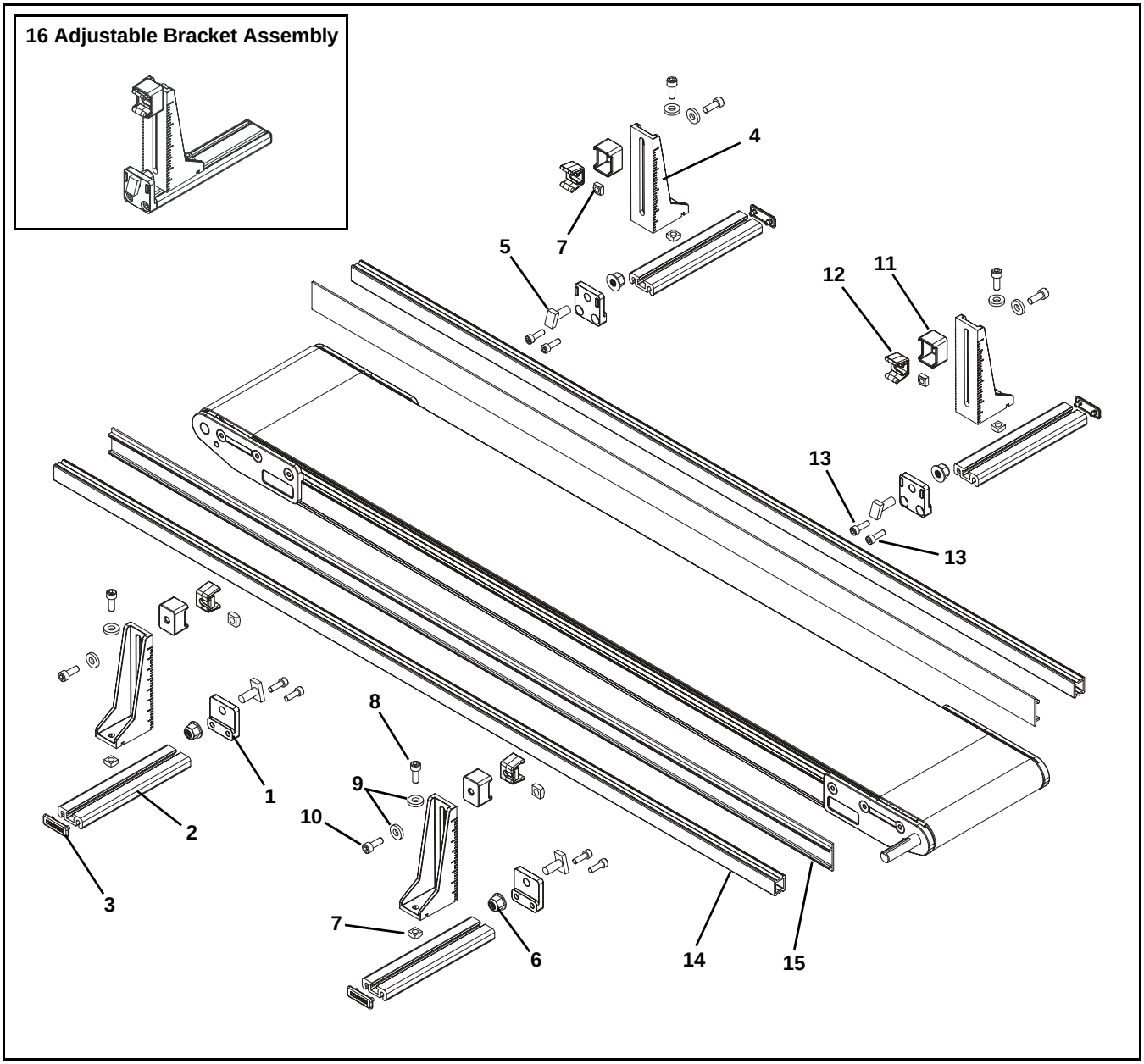
#14, 34 & 44 Profile - Tool-Less Adjustable Guiding



Item	Part Number	Description
1	206380	Base
2	206381	Base Clamp
3	206382	Insert Clamp
4	206383	Guide Ring
5	206385	Tube
6	206397	Clip
7	206685	T-Nut
8	206692	Guide Tube
9	807-2859	Nylon Cap Screw, N6 x 16 mm
10	807-920	Square Nut, M6-1.0
11	911-710	Washer
12	206698	Knob, 12 mm
13	206697	Knob, 150 mm
14	990601M	Hex Nut

Item	Part Number	Description
15	834-238-LLLLL	Guide Rail
	GTB13A04	Guide Rail 4' long
	GTB13A08	Guide Rail 8' long
16	834-241	1.3" UHMW Guiding (per foot)
	GTB13B04	1.3" UHMW Guiding 4' long
	GTB13B08	1.3" UHMW Guiding 8' long
	206683	2" UHMW Guiding (per foot)
	GTB13C04	2" UHMW Guiding 4' long
	GTB13C08	2" UHMW Guiding 8' long
17	206687	Tool-Less Adjustable Bracket Assembly (Includes Items 1 through 14)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

#16, 36 & 46 Profile - Outboard Adjustable Guiding

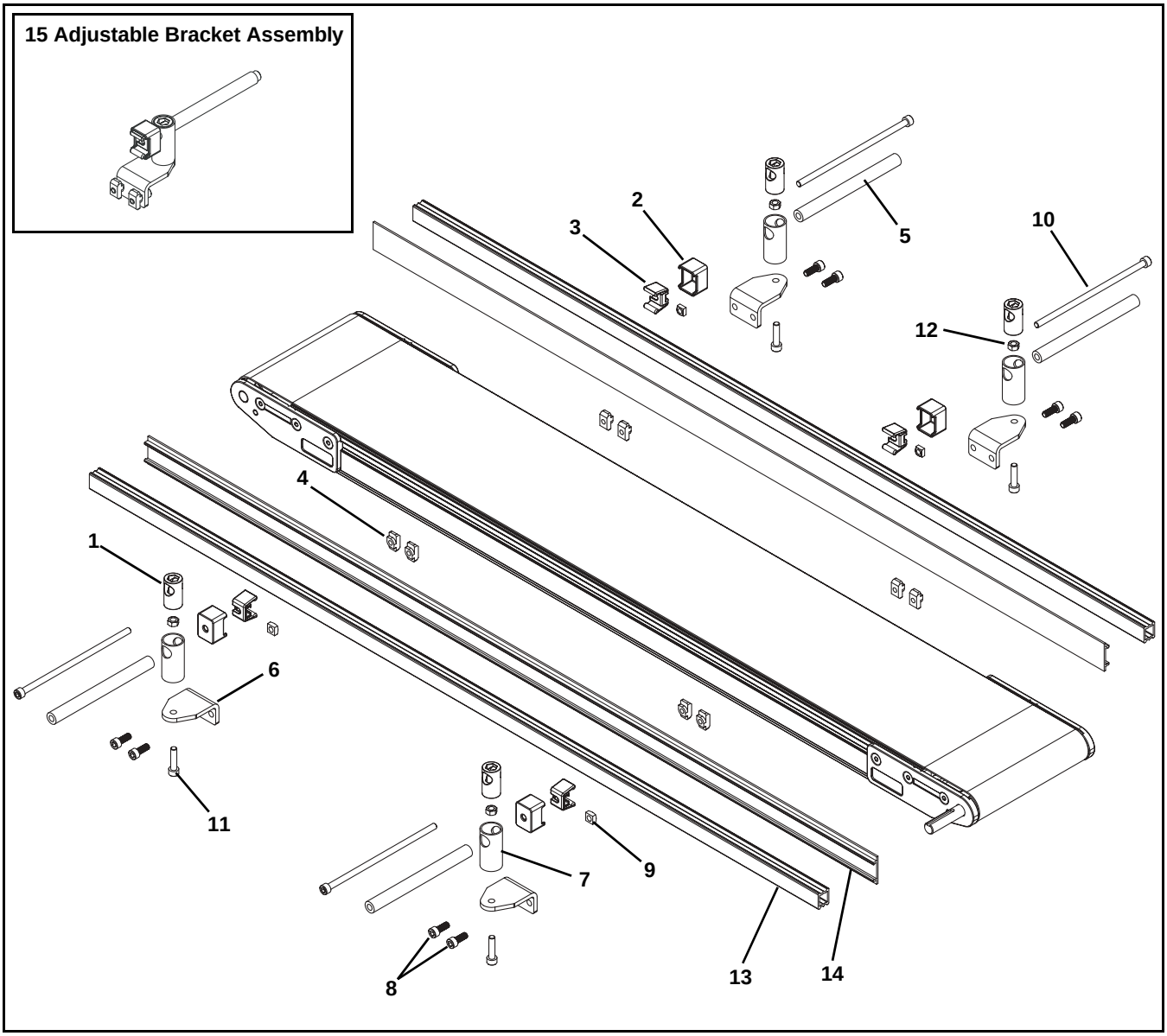


Item	Part Number	Description
1	210848	Mounting Block
2	210846-00600	Extrusion Base
3	210849	Cap
4	210847	Mounting Bracket
5	834-007	Stud, M8 x 20 mm
6	990812M	Hex Nut, M8-1.25
7	807-920	Square Nut, M6-1.0
8	920616M	Socket Head Screw, M6-1.00 x 16 mm
9	605279P	Washer
10	920622M	Socket Head Screw, M6-1.00 x 22 mm
11	206383	Guide Ring
12	206397	Clip
13	920516M	Socket Head Screw, M5-.80 x 16 mm

Item	Part Number	Description
14	834-238-LLLLL	Guide Rail
	GTB13A04	Guide Rail 4' long
	GTB13A08	Guide Rail 8' long
15	834-241	1.3" UHMW Guiding (per foot)
	GTB13B04	1.3" UHMW Guiding 4' long
	GTB13B08	1.3" UHMW Guiding 8' long
	206683	2" UHMW Guiding (per foot)
	GTB13C04	2" UHMW Guiding 4' long
	GTB13C08	2" UHMW Guiding 8' long
16	206193	Adjustable Bracket Assembly (Includes Items 1 through 13)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

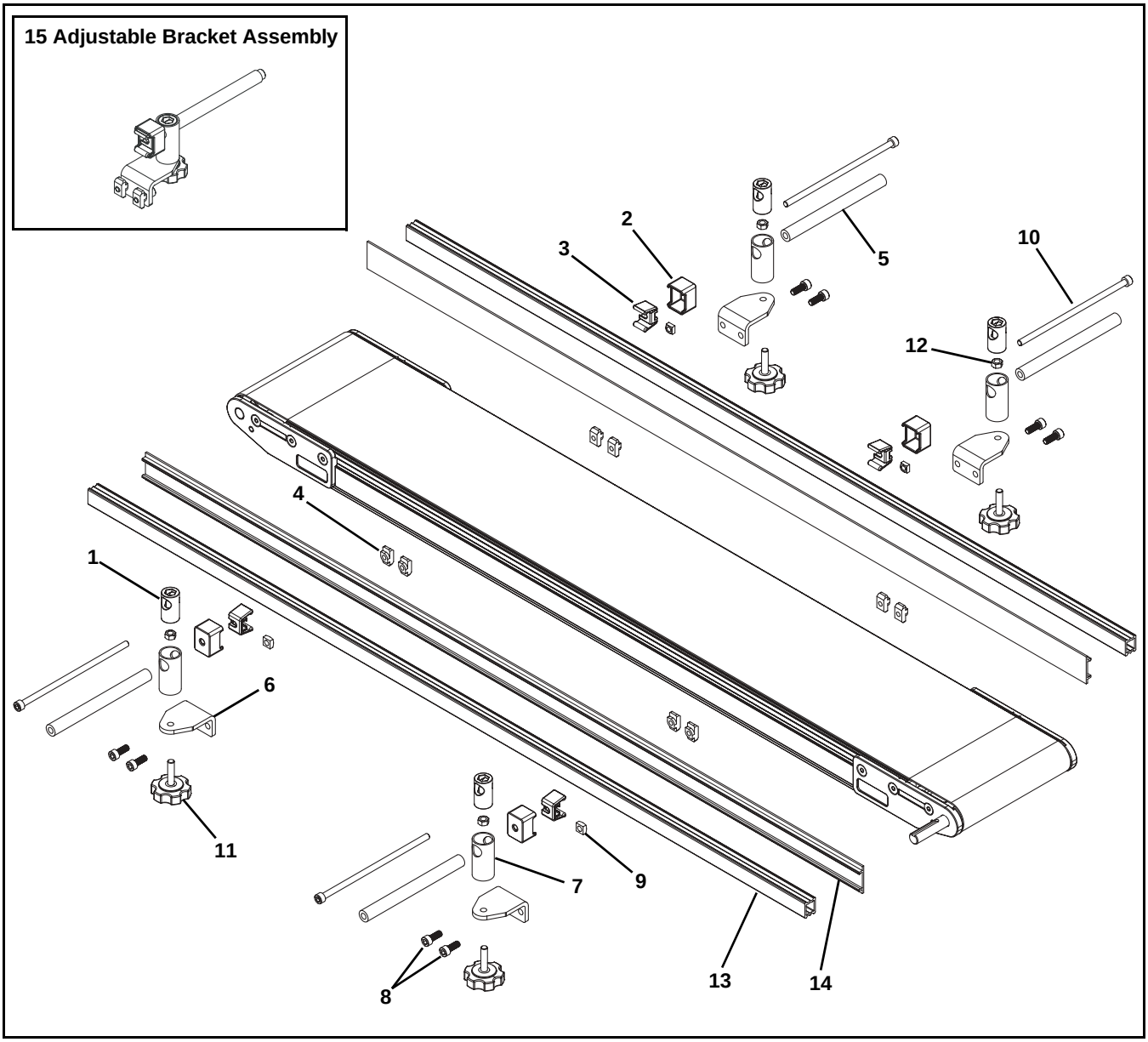
#19, 39 & 49 Profile - Horizontal Adjustable Guiding



Item	Part Number	Description
1	206382	Insert Clamp
2	206383	Guide Ring
3	206397	Clip
4	206685	T-Nut
5	206692	Guide Tube
6	207146	Bracket
7	207147	Guide Tube
8	807-2859	Nylon Cap Screw, N6 x 16 mm
9	807-920	Square Nut, M6-1.0
10	9206150M	Socket Head Screw, M6-1.00 x 150 mm
11	920625M	Socket Head Screw, M6-1.00 x 25 mm
12	990601M	Hex Nut

Item	Part Number	Description
13	834-238-LLLLL	Guide Rail
	GTB13A04	Guide Rail 4' long
	GTB13A08	Guide Rail 8' long
14	834-241	1.3" UHMW Guiding (per foot)
	GTB13B04	1.3" UHMW Guiding 4' long
	GTB13B08	1.3" UHMW Guiding 8' long
	206683	2" UHMW Guiding (per foot)
	GTB13C04	2" UHMW Guiding 4' long
	GTB13C08	2" UHMW Guiding 8' long
15	207150	Adjustable Bracket Assembly (Includes Items 1 through 13)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

#20, 40 & 50 Profile - Tool-Less Horizontal Adjustable Guiding

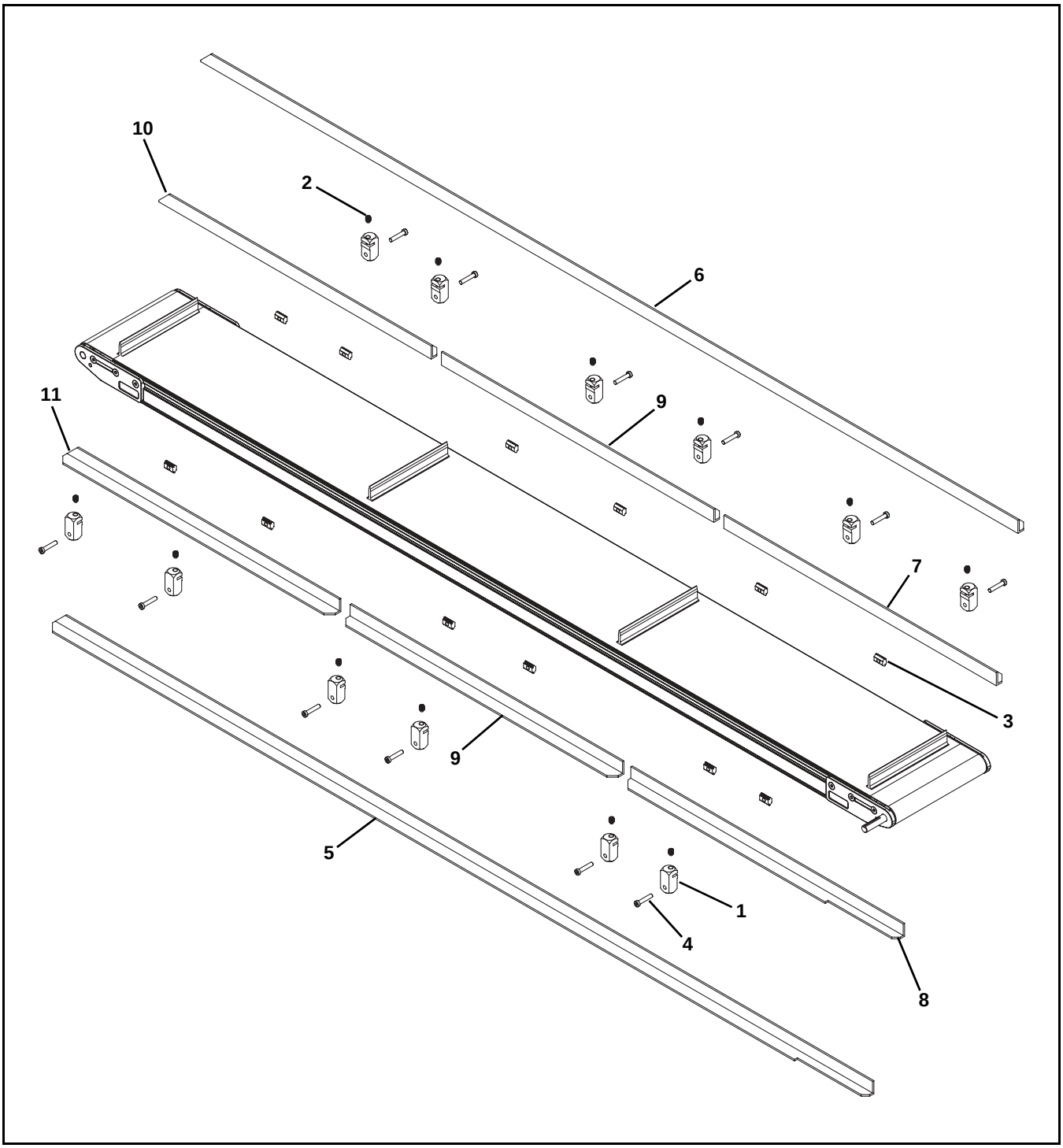


Item	Part Number	Description
1	206382	Insert Clamp
2	206383	Guide Ring
3	206397	Clip
4	206685	T-Nut
5	206692	Guide Tube
6	207146	Bracket
7	207147	Guide Tube
8	807-2859	Nylon Cap Screw, N6 x 16 mm
9	807-920	Square Nut, M6-1.0
10	9206150M	Socket Head Screw, M6-1.00 x 150 mm
11	207155	Knob, 18 mm
12	990601M	Hex Nut

Item	Part Number	Description
13	834-238-LLLLL	Guide Rail
	GTB13A04	Guide Rail 4' long
	GTB13A08	Guide Rail 8' long
14	834-241	1.3" UHMW Guiding (per foot)
	GTB13B04	1.3" UHMW Guiding 4' long
	GTB13B08	1.3" UHMW Guiding 8' long
	206683	2" UHMW Guiding (per foot)
	GTB13C04	2" UHMW Guiding 4' long
	GTB13C08	2" UHMW Guiding 8' long
15	207151	Tool-Less Adjustable Bracket Assembly (Includes Items 1 through 13)
LLLLL = part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

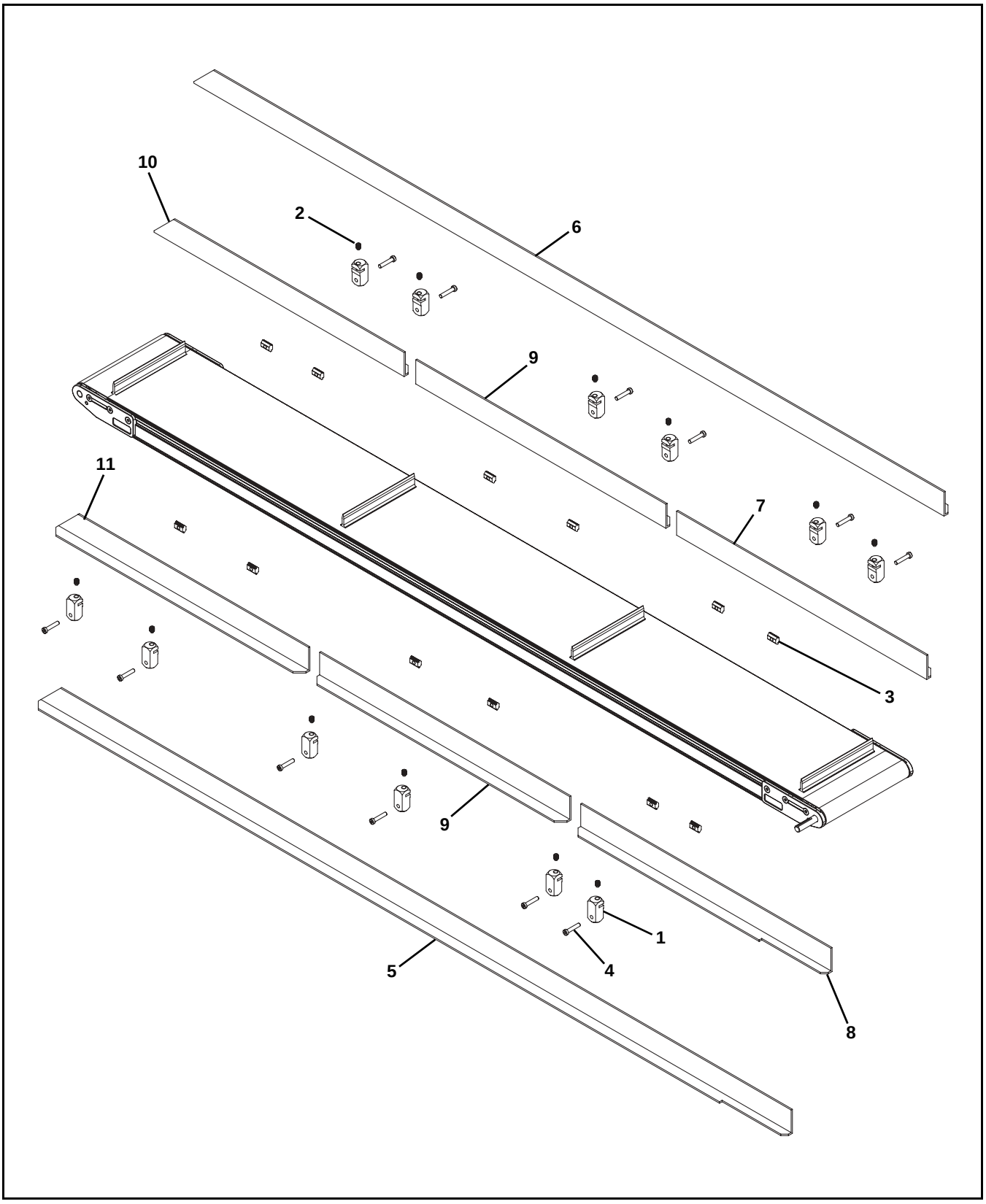
#2 Cleated Profile - 1.00" (25 mm) High Side



Item	Part Number	Description
1	350177	Clamping Block
2	807-2121	Set Screw
3	639971M	Drop-In Tee Bar
4	950630M	Low Head Cap Screw, M6-1.00 x 30 mm
5	350182A-LLLLL	1" Cleated Guiding, Drive Side, Motor in the A position, Single Piece Guides for 1" - 8" wide Conveyors
	350183B-LLLLL	1" Cleated Guiding, Drive Side, Motor in the B position, Single Piece Guides for 1" - 8" wide Conveyors
	350182C-LLLLL	1" Cleated Guiding, Drive Side, Motor in the C position, Single Piece Guides for 1" - 8" wide Conveyors
	350183D-LLLLL	1" Cleated Guiding, Drive Side, Motor in the D position, Single Piece Guides for 1" - 8" wide Conveyors
	204602A-LLLLL	1" Cleated Guiding, Drive Side, Motor in the A position, Single Piece Guides for 10" - 24" wide Conveyors
	204603B-LLLLL	1" Cleated Guiding, Drive Side, Motor in the B position, Single Piece Guides for 10" - 24" wide Conveyors
	204602C-LLLLL	1" Cleated Guiding, Drive Side, Motor in the C position, Single Piece Guides for 10" - 24" wide Conveyors
	204603D-LLLLL	1" Cleated Guiding, Drive Side, Motor in the D position, Single Piece Guides for 10" - 24" wide Conveyors
6	350183Z-LLLLL	1" Cleated Guiding, Non-Drive Side, Motor in the A or C positions, Single Piece Guides for 1" - 8" wide Conveyors
	350182Z-LLLLL	1" Cleated Guiding, Non-Drive Side, Motor in the D or B positions, Single Piece Guides for 1" - 8" wide Conveyors
	204603-LLLLL	1" Cleated Guiding, Non-Drive Side, Motor in the A or C positions, Single Piece Guides for 10" - 24" wide Conveyors
	204602-LLLLL	1" Cleated Guiding, Non-Drive Side, Motor in the D or B positions, Single Piece Guides for 10" - 24" wide Conveyors
7	350181A-LLLLL	1" Cleated Guiding, Drive Side, Discharge End, Motor in the A position, Multi Piece Guides for 1" - 8" wide Conveyors
	350181Z-LLLLL	1" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 1" - 8" wide Conveyors
	204601A-LLLLL	1" Cleated Guiding, Drive Side, Discharge End, Motor in the A position, Multi Piece Guides for 10" - 24" wide Conveyors
	204601-LLLLL	1" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 10" - 24" wide Conveyors
8	350181D-LLLLL	1" Cleated Guiding, Drive Side, Discharge End, Motor in the D position, Multi Piece Guides for 1" - 8" wide Conveyors
	350181Z-LLLLL	1" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 1" - 8" wide Conveyors
	204601D-LLLLL	1" Cleated Guiding, Drive Side, Discharge End, Motor in the D position, Multi Piece Guides for 10" - 24" wide Conveyors
	204601-LLLLL	1" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 10" - 24" wide Conveyors
9	350181Z-LLLLL	1" Cleated Guiding, Intermediate Section, Multi Piece Guides for 1" - 8" wide Conveyors
	204601-LLLLL	1" Cleated Guiding, Intermediate Section, Multi Piece Guides for 10" - 24" wide Conveyors
10	350182C-LLLLL	1" Cleated Guiding, Drive Side, Infeed End, Motor in the C position, Multi Piece Guides for 1" - 8" wide Conveyors
	350182Z-LLLLL	1" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 1" - 8" wide Conveyors
	204602C-LLLLL	1" Cleated Guiding, Drive Side, Infeed End, Motor in the C position, Multi Piece Guides for 10" - 24" wide Conveyors
	204602-LLLLL	1" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 10" - 24" wide Conveyors
11	350183B-LLLLL	1" Cleated Guiding, Drive Side, Infeed End, Motor in the B position, Multi Piece Guides for 1" - 8" wide Conveyors
	350183Z-LLLLL	1" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 1" - 8" wide Conveyors
	204603B-LLLLL	1" Cleated Guiding, Drive Side, Infeed End, Motor in the B position, Multi Piece Guides for 10" - 24" wide Conveyors
	204603-LLLLL	1" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 10" - 24" wide Conveyors
LLLLL = Part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

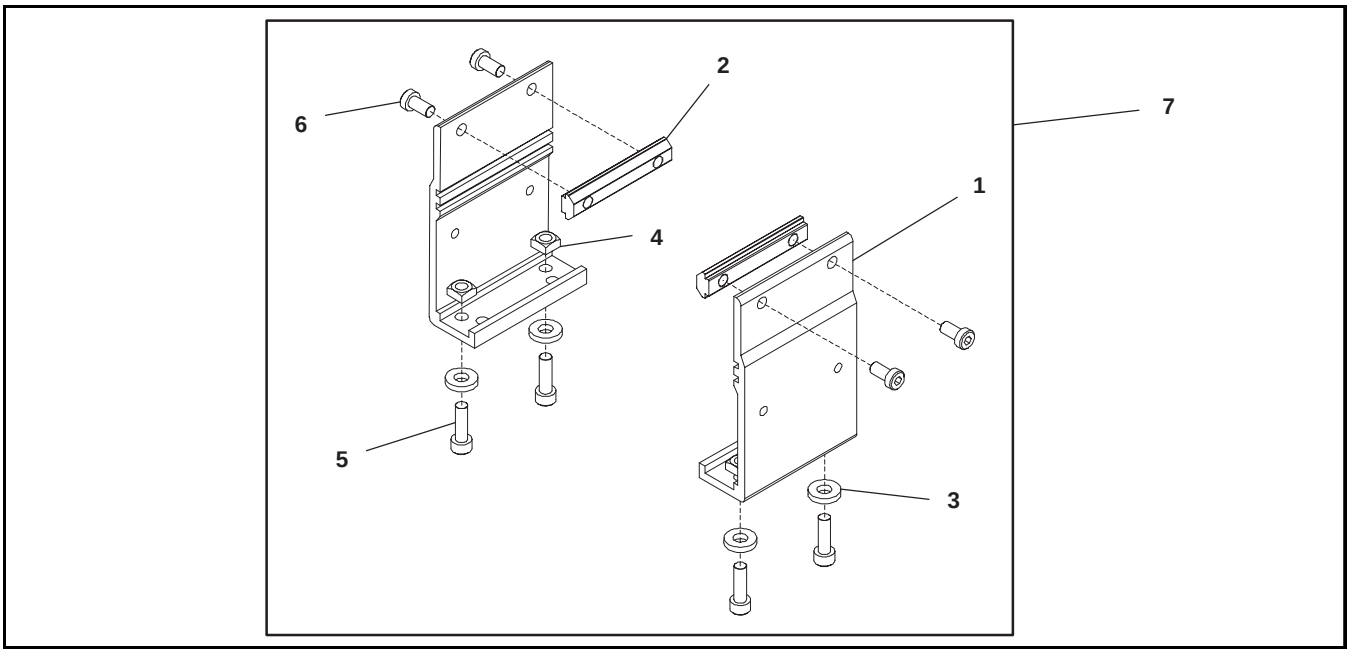
#3 Cleated Profile - 2.00" (51 mm) High Side



Item	Part Number	Description
1	350177	Clamping Block
2	807-2121	Set Screw
3	639971M	Drop-In Tee Bar
4	950630M	Low Head Cap Screw, M6-1.00 x 30 mm
5	205002A-LLLLL	2" Cleated Guiding, Drive Side, Motor in the A position, Single Piece Guides for 1" - 8" wide Conveyors
	205003B-LLLLL	2" Cleated Guiding, Drive Side, Motor in the B position, Single Piece Guides for 1" - 8" wide Conveyors
	205002C-LLLLL	2" Cleated Guiding, Drive Side, Motor in the C position, Single Piece Guides for 1" - 8" wide Conveyors
	205003D-LLLLL	2" Cleated Guiding, Drive Side, Motor in the D position, Single Piece Guides for 1" - 8" wide Conveyors
	208102A-LLLLL	2" Cleated Guiding, Drive Side, Motor in the A position, Single Piece Guides for 10" - 24" wide Conveyors
	208103B-LLLLL	2" Cleated Guiding, Drive Side, Motor in the B position, Single Piece Guides for 10" - 24" wide Conveyors
	208102C-LLLLL	2" Cleated Guiding, Drive Side, Motor in the C position, Single Piece Guides for 10" - 24" wide Conveyors
	208103D-LLLLL	2" Cleated Guiding, Drive Side, Motor in the D position, Single Piece Guides for 10" - 24" wide Conveyors
6	205003-LLLLL	2" Cleated Guiding, Non-Drive Side, Motor in the A or C positions, Single Piece Guides for 1" - 8" wide Conveyors
	205002-LLLLL	2" Cleated Guiding, Non-Drive Side, Motor in the D or B positions, Single Piece Guides for 1" - 8" wide Conveyors
	208103-LLLLL	2" Cleated Guiding, Non-Drive Side, Motor in the A or C positions, Single Piece Guides for 10" - 24" wide Conveyors
	208102-LLLLL	2" Cleated Guiding, Non-Drive Side, Motor in the D or B positions, Single Piece Guides for 10" - 24" wide Conveyors
7	205001A-LLLLL	2" Cleated Guiding, Drive Side, Discharge End, Motor in the A position, Multi Piece Guides for 1" - 8" wide Conveyors
	205001-LLLLL	2" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 1" - 8" wide Conveyors
	208101A-LLLLL	2" Cleated Guiding, Drive Side, Discharge End, Motor in the A position, Multi Piece Guides for 10" - 24" wide Conveyors
	208101-LLLLL	2" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 10" - 24" wide Conveyors
8	205001D-LLLLL	2" Cleated Guiding, Drive Side, Discharge End, Motor in the D position, Multi Piece Guides for 1" - 8" wide Conveyors
	205001-LLLLL	2" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 1" - 8" wide Conveyors
	208101D-LLLLL	2" Cleated Guiding, Drive Side, Discharge End, Motor in the D position, Multi Piece Guides for 10" - 24" wide Conveyors
	208101-LLLLL	2" Cleated Guiding, Non-Drive Side, Discharge End, Multi Piece Guides for 10" - 24" wide Conveyors
9	205001-LLLLL	2" Cleated Guiding, Intermediate Section, Multi Piece Guides for 1" - 8" wide Conveyors
	208101-LLLLL	2" Cleated Guiding, Intermediate Section, Multi Piece Guides for 10" - 24" wide Conveyors
10	205002C-LLLLL	2" Cleated Guiding, Drive Side, Infeed End, Motor in the C position, Multi Piece Guides for 1" - 8" wide Conveyors
	205002-LLLLL	2" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 1" - 8" wide Conveyors
	208102C-LLLLL	2" Cleated Guiding, Drive Side, Infeed End, Motor in the C position, Multi Piece Guides for 10" - 24" wide Conveyors
	208102-LLLLL	2" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 10" - 24" wide Conveyors
11	205003B-LLLLL	2" Cleated Guiding, Drive Side, Infeed End, Motor in the B position, Multi Piece Guides for 1" - 8" wide Conveyors
	205003-LLLLL	2" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 1" - 8" wide Conveyors
	208103B-LLLLL	2" Cleated Guiding, Drive Side, Infeed End, Motor in the B position, Multi Piece Guides for 10" - 24" wide Conveyors
	208103-LLLLL	2" Cleated Guiding, Non-Drive Side, Infeed End, Multi Piece Guides for 10" - 24" wide Conveyors
LLLLL = Part length in inches with 2 decimal places		
Length Example: Length = 35.25" LLLLL = 03525		

Service Parts

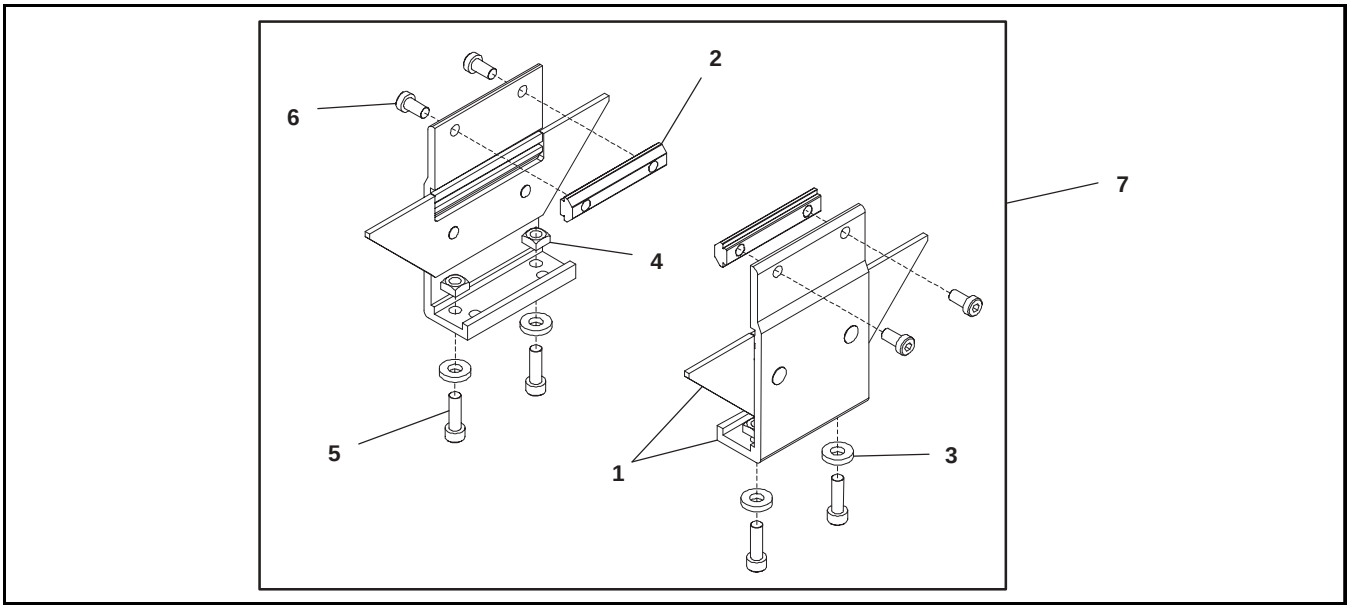
Flat Belt Mounting Brackets



Item	Part Number	Description
1	240831	Stand Mount
2	300150MK4	Drop–In Tee Bar (x4)
3	605279P	Washer
4	807–920	Square Nut M6

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20 mm
6	950616M	Low Head Cap Screw M6 x 16 mm
7	207375	Flat Belt Stand Mount Assembly for 1" wide Conveyors
	240839	Flat Belt Stand Mount Assembly for 2" wide or wider Conveyors

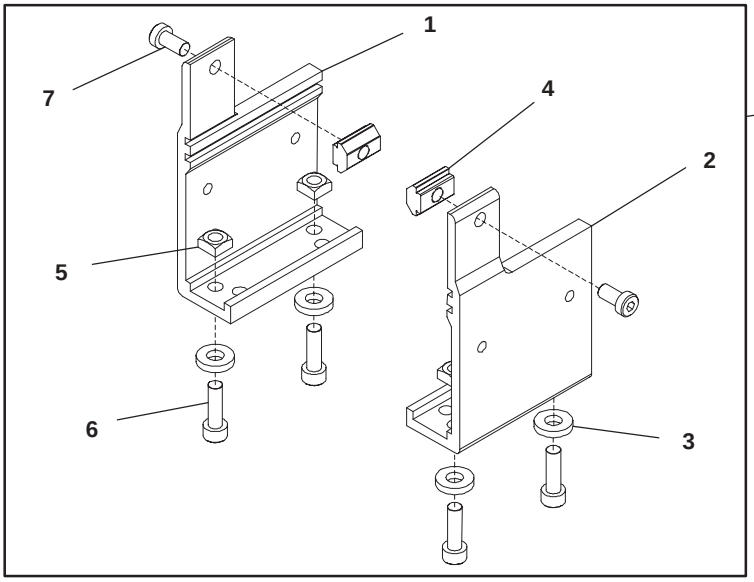
Cleated Belt Mounting Brackets



Item	Part Number	Description
1	240836	Cleated Mount Assembly
2	300150MK4	Drop–In Tee Bar (x4)
3	605279P	Washer
4	807–920	Square Nut M6

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20 mm
6	950616M	Low Head Cap Screw M6x16 mm
7	240838	Cleated Stand Mount Assembly

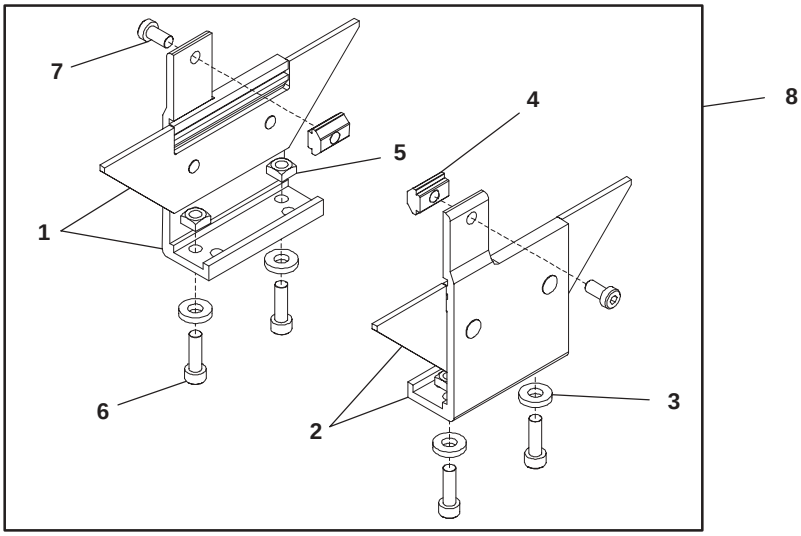
Flat Belt Mounting Brackets for Short Conveyors



Item	Part Number	Description
1	240833	Stand Mount, LH 2’ (610mm)
2	240834	Stand Mount, RH 2’ (610mm)
3	605279P	Washer
4	639971MK10	Drop−In Tee Bar (x10)
5	807−920	Square Nut M6
6	920620M	Socket Head Screw M6 x 20 mm

Item	Part Number	Description
7	950616M	Low Head Cap Screw M6 x 16 mm
8	207376	Flat Belt Stand Mount Assembly for 1" wide Short Conveyors, Left Hand
	207377	Flat Belt Stand Mount Assembly for 1" wide Short Conveyors, Right Hand
	240847	Flat Belt Stand Mount Assembly for 2" wide or wider Short Conveyors

Cleated Belt Mounting Brackets for Short Conveyors

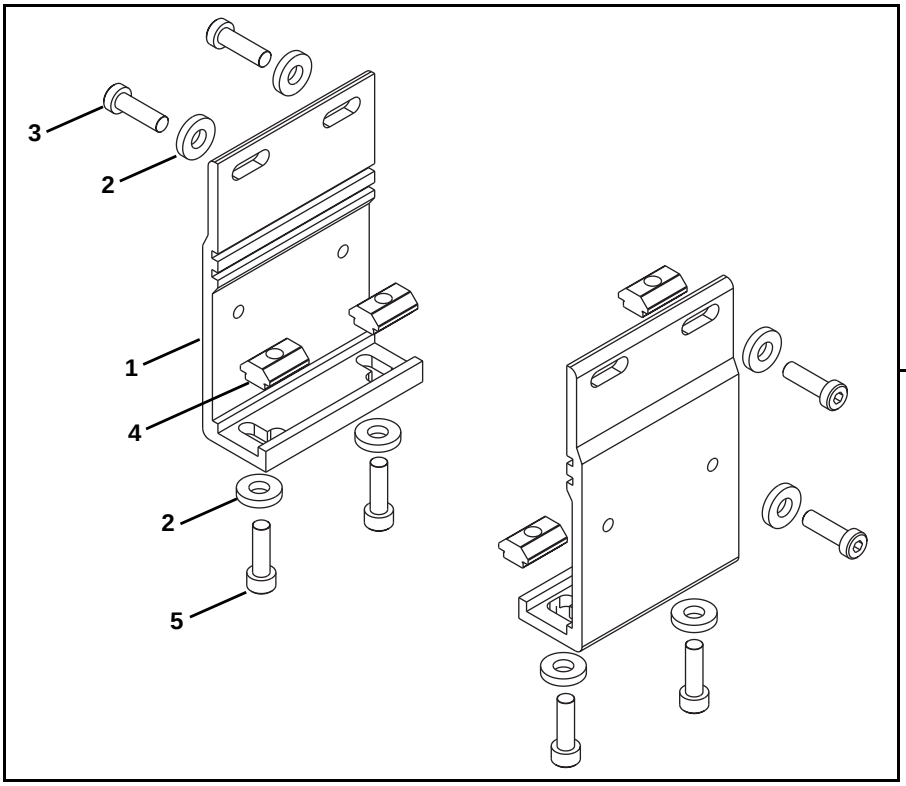


Item	Part Number	Description
1	240852	Cleated Stand Bracket Assembly LH 2’ (610mm) Conveyor
2	240853	Cleated Stand Bracket Assembly RH 2’ (610mm) Conveyor
3	605279P	Washer
4	639971MK10	Drop−In Tee Bar (x10)

Item	Part Number	Description
5	807−920	Square Nut M6
6	920620M	Socket Head Screw M6 x 20 mm
7	950616M	Low Head Cap Screw M6 x 16 mm
8	240851	Cleated Belt Stand Mount Assembly for 2’ (610mm) Conveyors

Service Parts

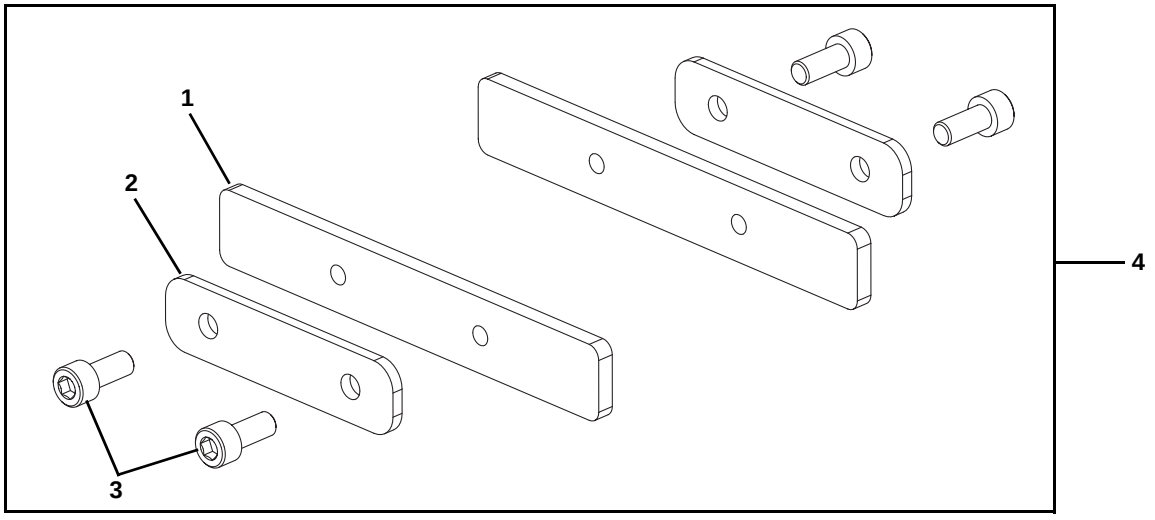
Flat Belt Mounting Brackets Assembled to the Tail



Item	Part Number	Description
1	240850	Stand Mount
2	605279P	Washer
3	950620M	Socket Low Head Screw M6 x 20 mm

Item	Part Number	Description
4	639971MK10	Drop–In Tee Bar (x10)
5	920620M	Socket Head Screw M6 x 20 mm
6	240854	Flat Belt Stand Mount Assembly for Tail Mounts

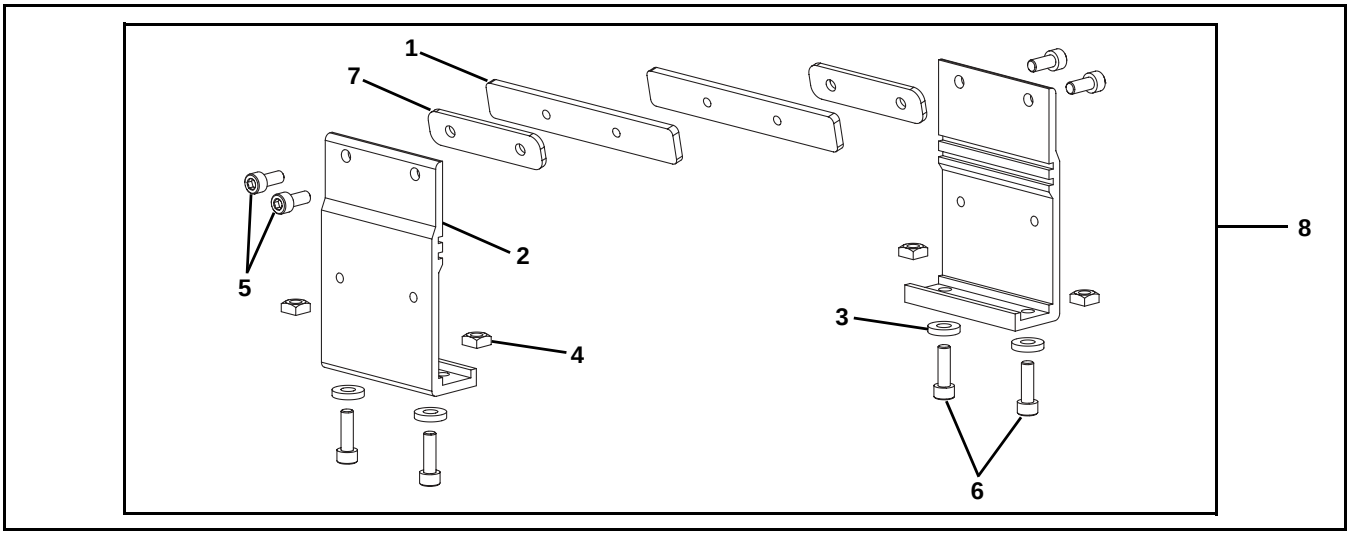
Connecting Assembly without Stand Mount



Item	Part Number	Description
1	206520	Connecting Bar
2	240859	Plate

Item	Part Number	Description
3	920614M	Socket Head Screw, M6-1.00 x 14 mm
4	206519	Connecting Assembly

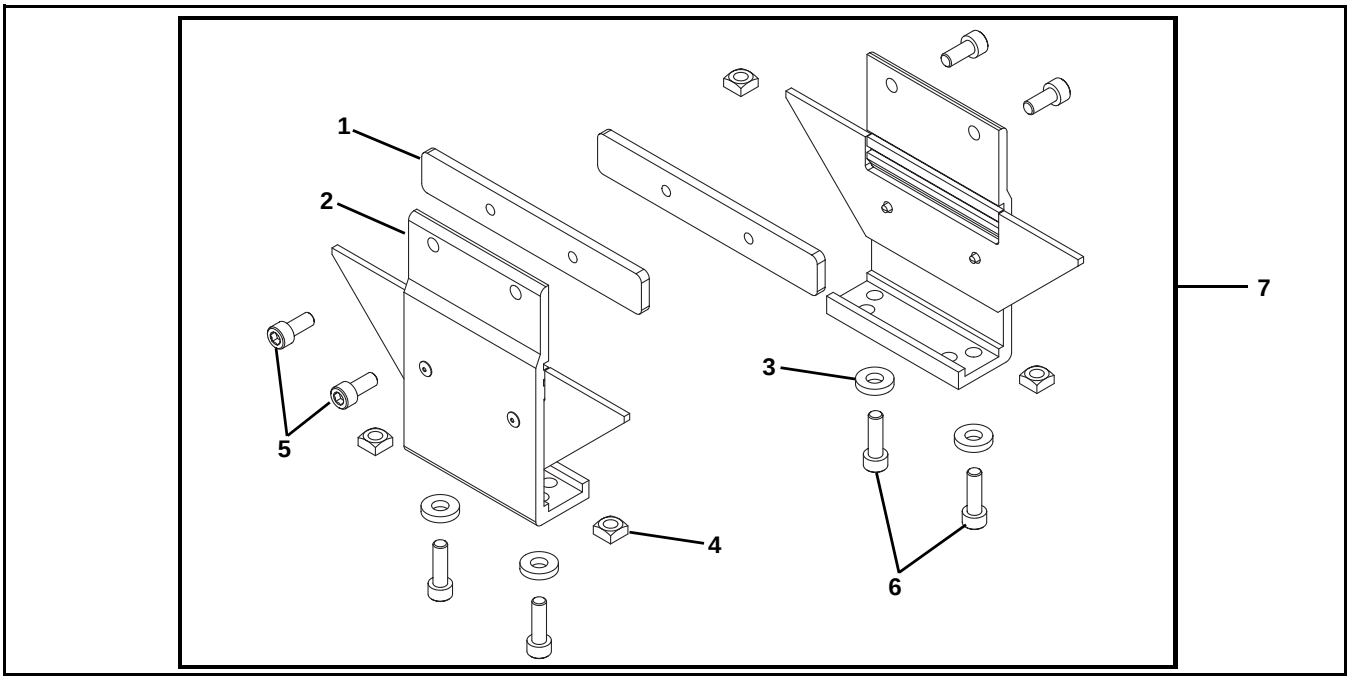
Flat Belt Connecting Assembly with Stand Mount



Item	Part Number	Description
1	206520	Connecting Bar
2	240831	Stand Mount
3	605279P	Washer
4	807-920	Square Nut M6

Item	Part Number	Description
5	920614M	Socket Head Screw, M6-1.00 x 14 mm
6	920620M	Socket Head Screw, M6-1.00 x 20 mm
7	240859	Plate (for 1" wide only)
8	207378	Connecting Assembly for 1" wide Conveyors
	206518	Connecting Assembly for 2" wide or wider Conveyors

Cleated Belt Connecting Assembly with Stand Mount

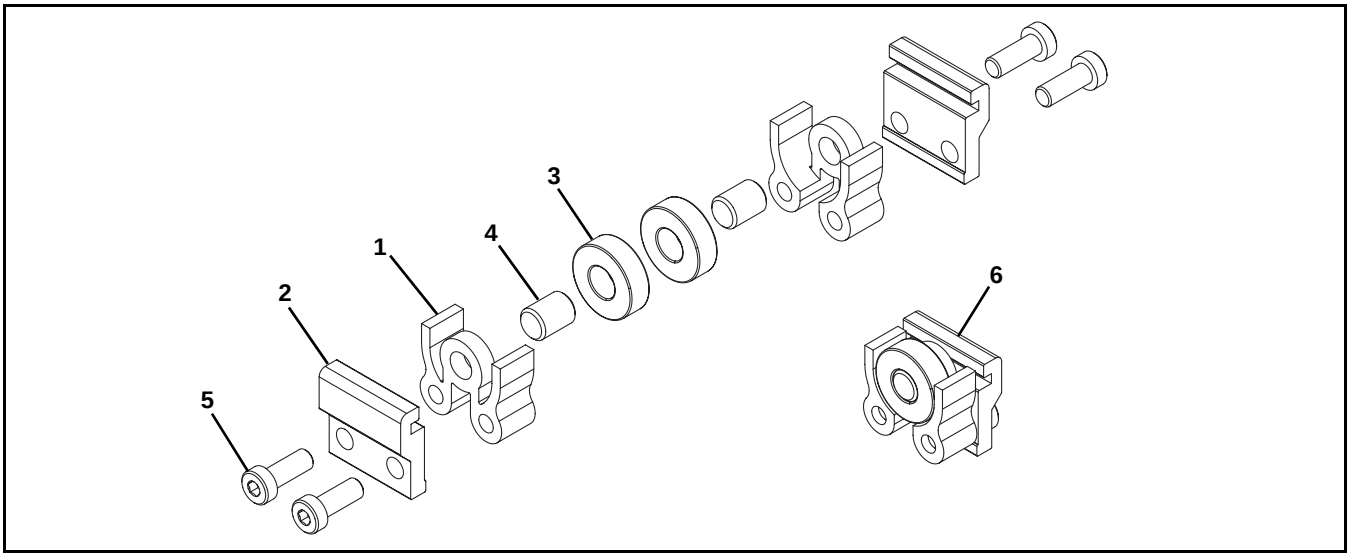


Item	Part Number	Description
1	206520	Connecting Bar
2	240836	Cleated Stand Mount Assembly
3	605279P	Washer
4	807-920	Square Nut M6

Item	Part Number	Description
5	920614M	Socket Head Screw, M6-1.00 x 14 mm
6	920620M	Socket Head Screw, M6-1.00 x 20 mm
7	240929	Connecting Assembly

Service Parts

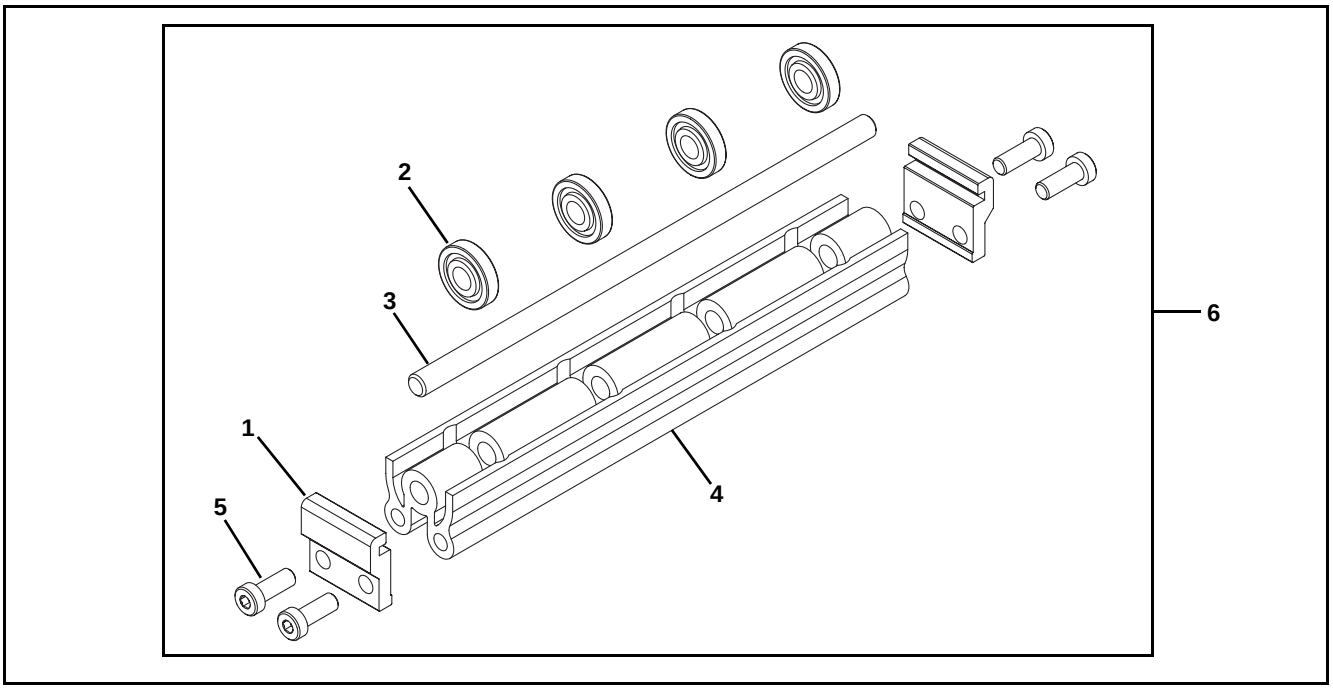
1" (25 mm) to 6" (152 mm) Flat Belt Return Roller



Item	Part Number	Description
1	240825	Return Roller Guard – Short
2	205978	Flat Return Roller Clip
3	802–027	Bearing
4	913–100	Dowel Pin

Item	Part Number	Description
5	950616M	Low Head Cap Screw M6-1.00 x 16 mm
6	206522	Return Roller Assembly

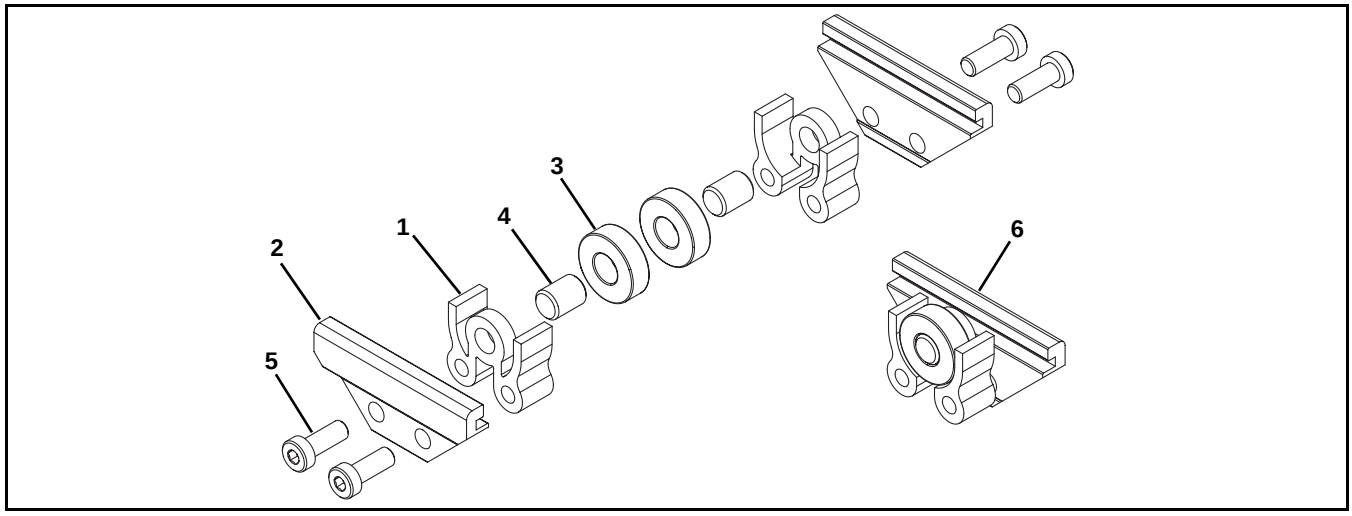
8" (203 mm) to 24" (610 mm) Flat Belt Return Roller



Item	Part Number	Description
1	205978	Flat Return Roller Clip
2	240826	Return Roller
3	2410WW	Return Roller Rod
4	2436WW	Return Roller Guard

Item	Part Number	Description
5	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
6	206523-WW	Return Roller Assembly
WW.= Conveyor width reference: 08, 10, 12, 14, 16, 18, 20, 22, & 24		

Cleated Belt Return Roller



Item	Part Number	Description
1	240825	Return Roller Guard – Short
2	205979	Cleated Return Roller Clip
3	802–027	Bearing
4	913–100	Dowel Pin

Item	Part Number	Description
5	950616M	Low Head Cap Screw M6-1.00 x 16 mm
6	206521	Cleated Belt Return Roller Assembly

Conveyor Belt Part Number Configuration

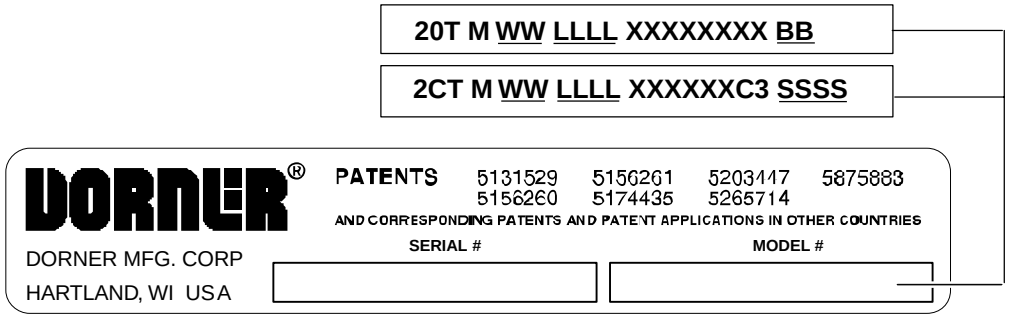


Figure 110

Flat Belt Part Number Configuration

Refer to Dorner patent plate (Figure 110). From the model number, determine conveyor width ("WW"), length ("LLLL") and belt type ("BB"). Use data to configure belt part number as indicated below.

22T - WW LLLL / BB

22T– __ __ __ __ __ __ __ **/** __ __

(Fill In)

Cleated Belt Part Number Configuration

Refer to Dorner patent plate (Figure 110). From the model number, width ("WW"), length ("LLLL"), cleat type ("C") and cleat spacing ("SSSS"). Use data to configure belt part number as indicated below.

24T - WW LLLL C SSSS

24T – __ __ __ __ __ __ __ **/** __ __ __ __

(Fill In)

Return Policy

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

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

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

<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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