7350 Series Nose Bar Drive Conveyors

Installation, Maintenance and Parts Manual

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Introduction

⚠ CAUTION

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

Upon receipt of shipment:

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

The Dorner Limited Warranty applies.

Dorner 7350 Series conveyors have patents pending.

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

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

⚠ DANGER

SEVERE HAZARD!

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

⚠ DANGER

EXPLOSION HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

BURN HAZARD!

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

⚠ WARNING

PUNCTURE HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

Product Description

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

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

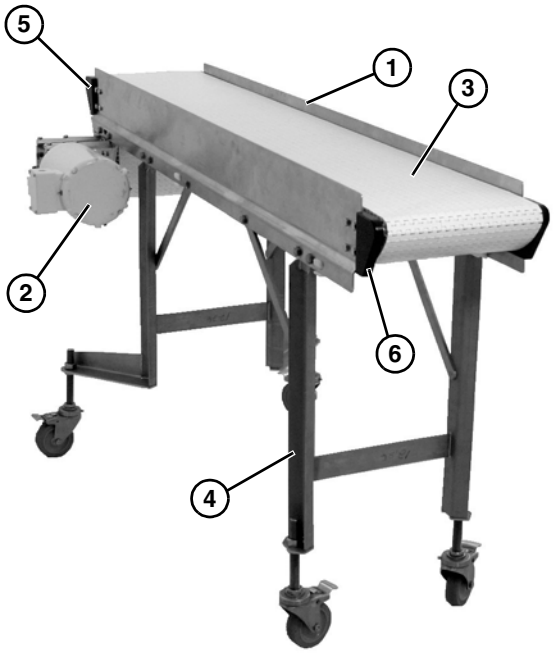
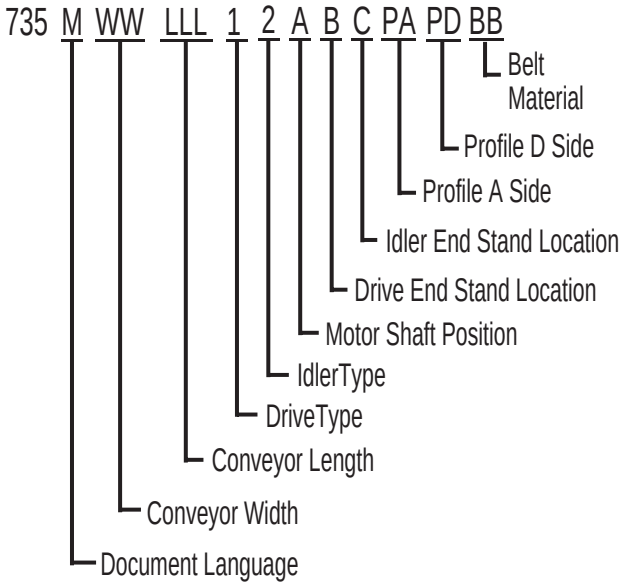
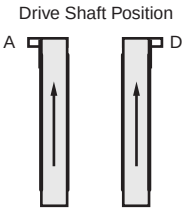


Figure 1

Specifications

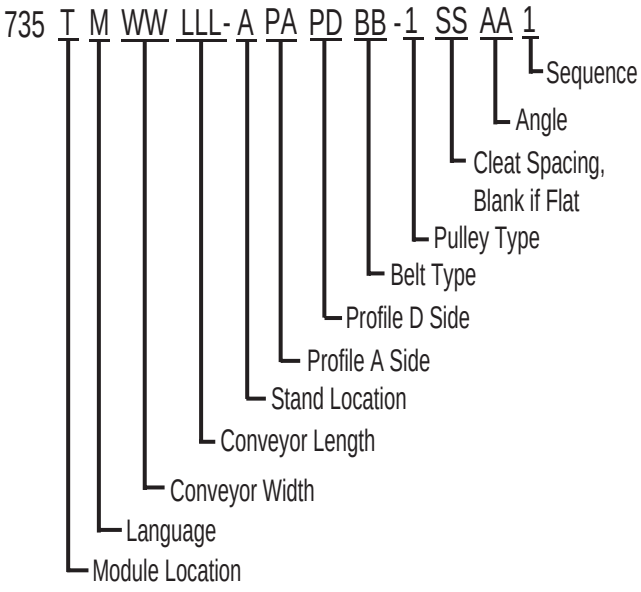
Flat Belt 7350 Series Conveyor



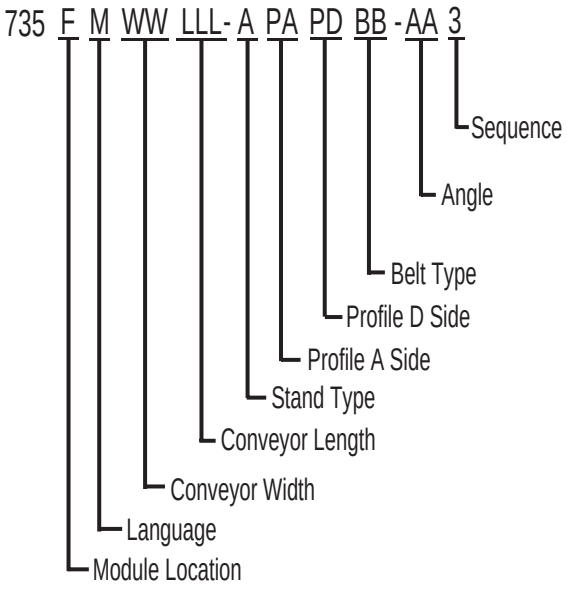


7350 Series Z-Frame Conveyor Modules

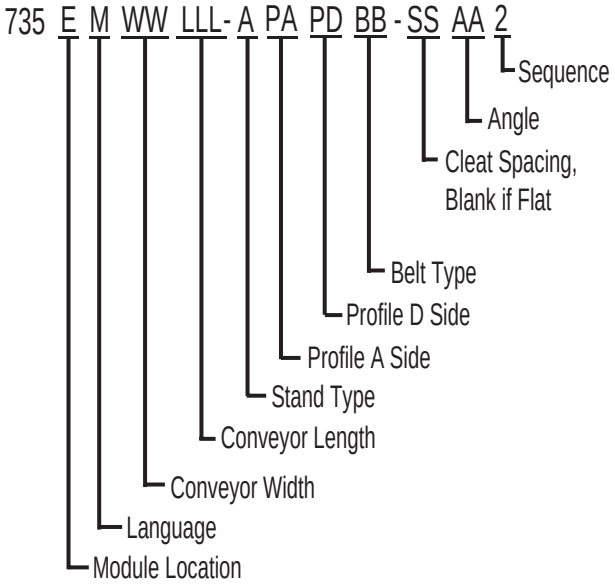
7350 Series Infeed Section to Knuckle



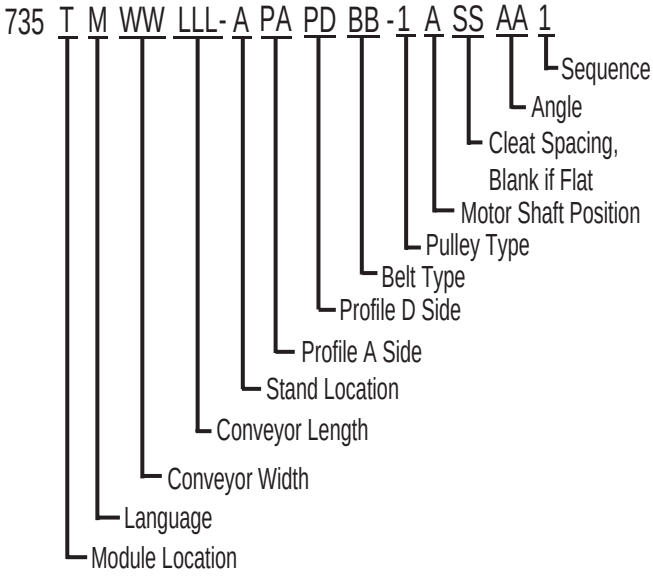
7350 Series Mid Section between Knuckle and Curve



7350 Series Mid Section between two Knuckles



7350 Series Discharge Section from Knuckle



Specifications

Conveyor Supports

Maximum Distances:

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

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

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

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

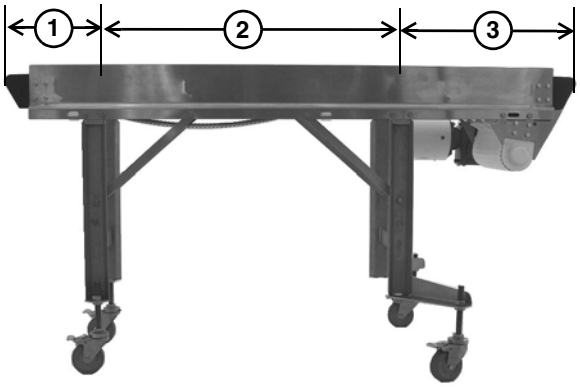


Figure 2

Specifications

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

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

IMPORTANT

Maximum conveyor loads are based on:

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

CAUTION

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

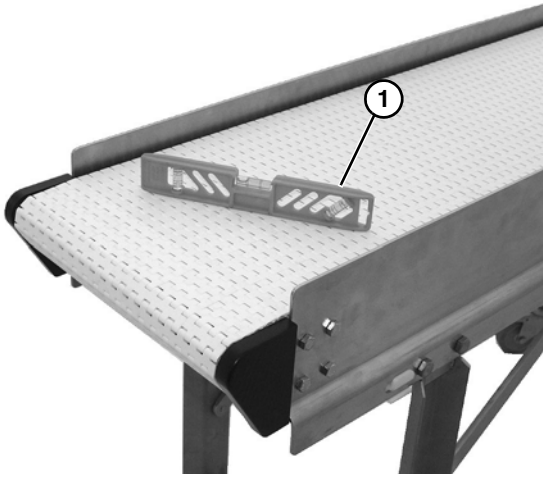


Figure 3

Required Tools

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

Recommended Installation Sequence

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

Conveyors Longer than 10 ft (3048 mm)

Connecting Components

Typical Connecting Components **(Figure 4)**.

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

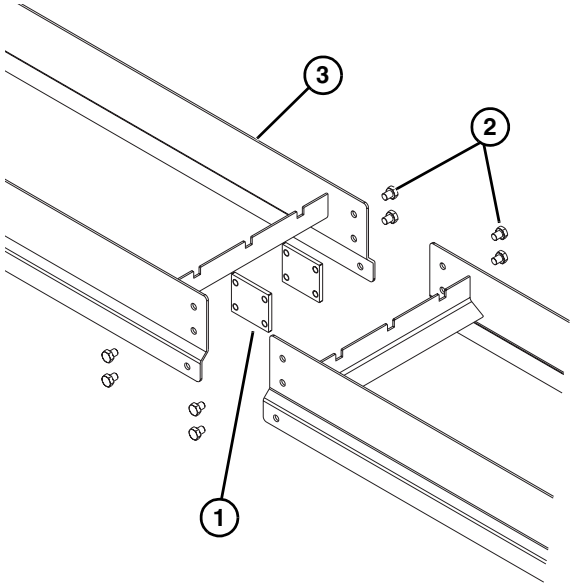


Figure 4

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

Installation

Z-Frame Conveyors

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

Knuckles

Upper Knuckle

1. Attach upper knuckle **(Figure 5, item 1)** to frame **(Figure 5, item 2)** by using two cap screws **(Figure 5, item 3)** and connector plate **(Figure 6, item 1)** on each side of conveyor.

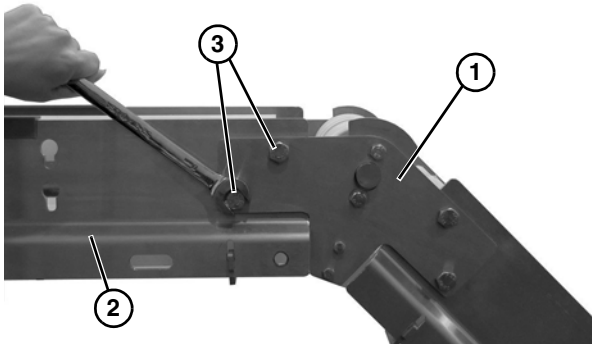


Figure 5

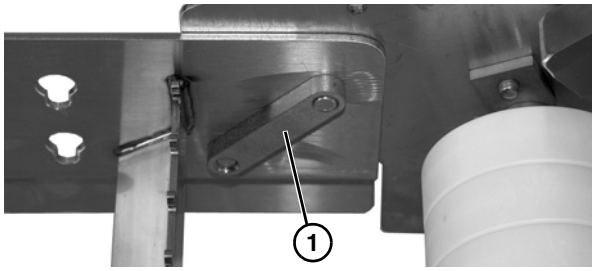


Figure 6

2. Attach bar cap **(Figure 7, item 1)** to frame and knuckle.

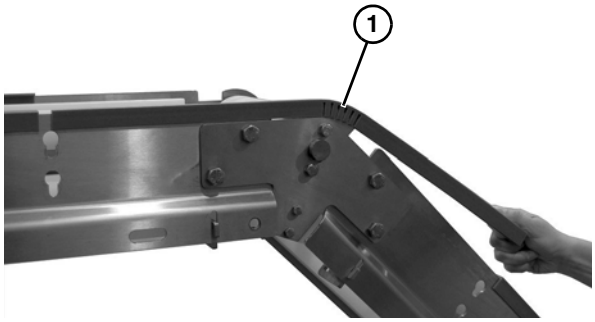


Figure 7

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

Lower Knuckle

1. Attach lower knuckle **(Figure 8, item 1)** to frame **(Figure 8, item 2)** by using two cap screws **(Figure 8, item 3)** and connector plate **(Figure 9, item 1)** on each side of conveyor.

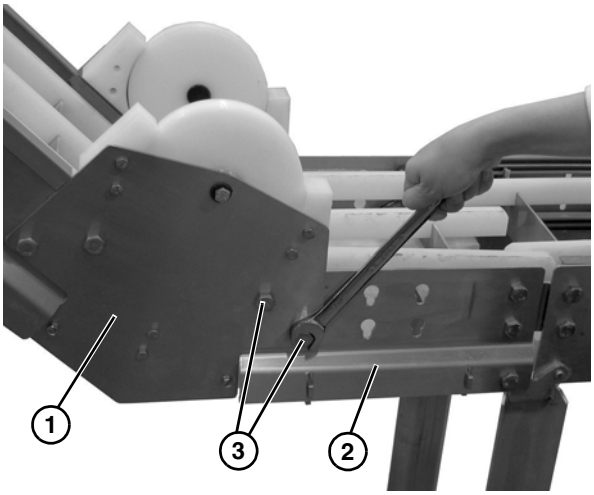


Figure 8

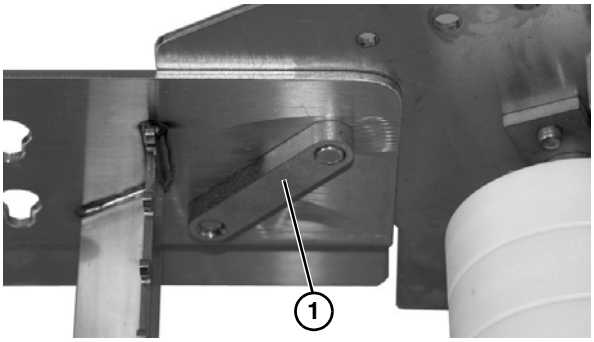


Figure 9

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

All Conveyors

Stand Installation

NOTE

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

Typical stand components **(Figure 10)**

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

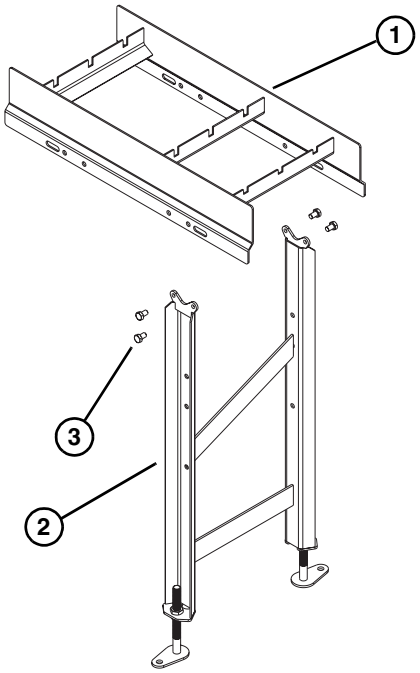


Figure 10

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame **(Figure 11, item 1)**.

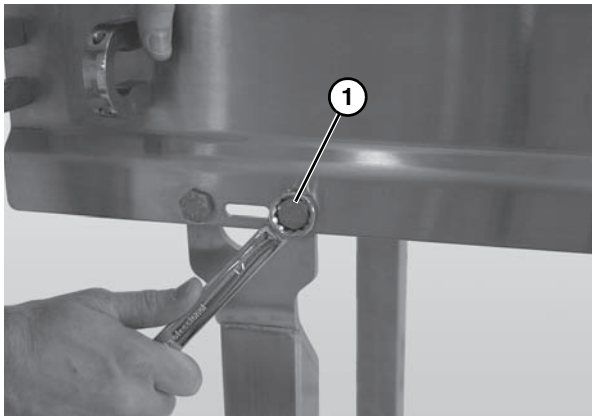


Figure 11

Belt Installation

Typical Belt Components **(Figure 12)**

1	Chain Belt
2	Belt Rod

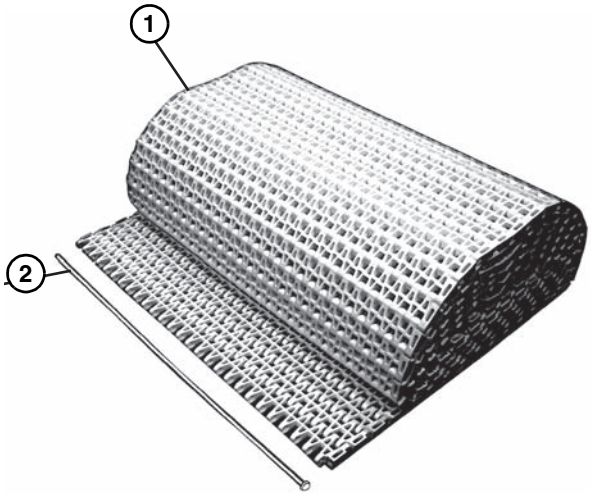


Figure 12

1. Position the belt on the conveyor frame **(Figure 13)**.

Figure 13

2. Wrap belt around idler tail.

3. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth **(Figure 14, item 1)** mating with rounded section **(Figure 14, item 2)** of belt.

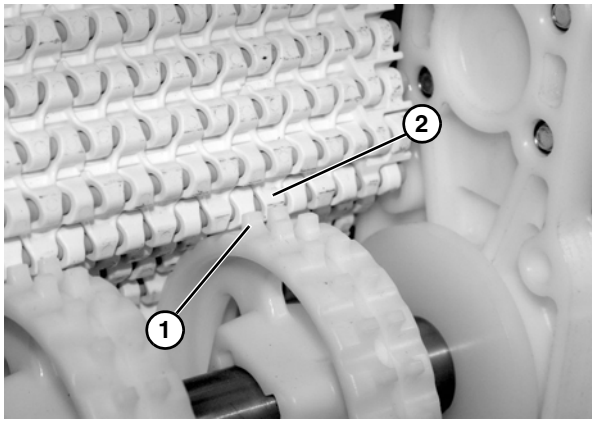


Figure 14

4. For Z-Frame conveyors, guide the belt under the hold down guides **(Figure 15, item 1)** in the lower knuckle.

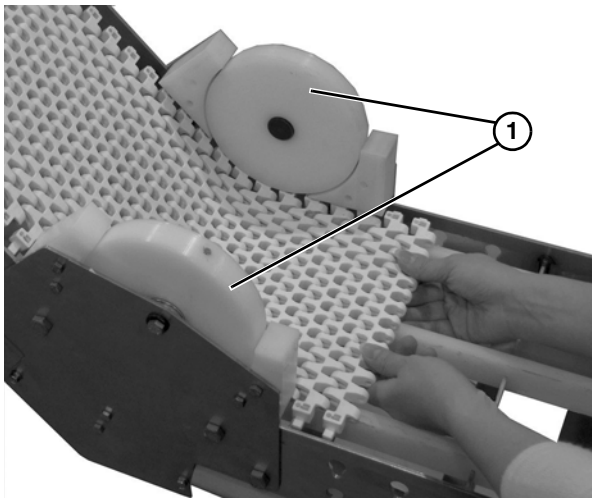


Figure 15

5. Bring the ends of the belt together **(Figure 16)**.

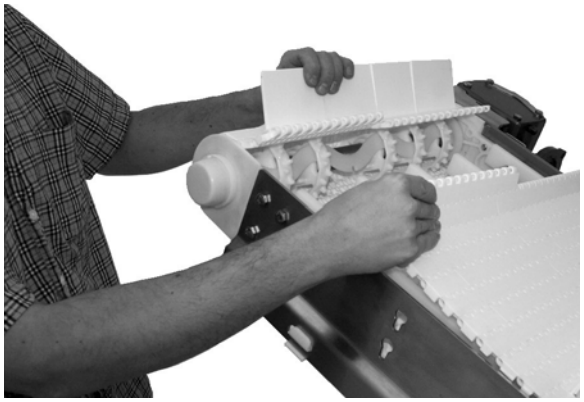


Figure 16

6. Insert the belt rod **(Figure 17, item 1)**.

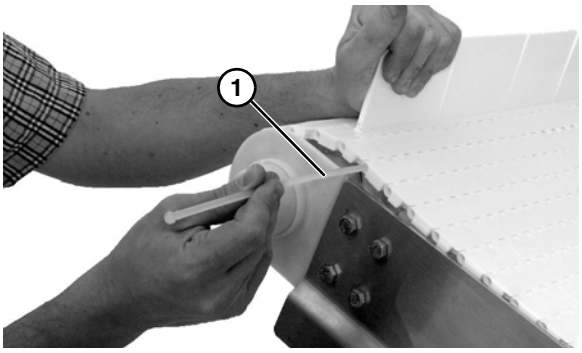


Figure 17

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

Belt Returns

Returns for conveyors up to 24" wide

1. Install belt return **(Figure 18, item 1)** into slotted frame hole **(Figure 18, item 2)**.

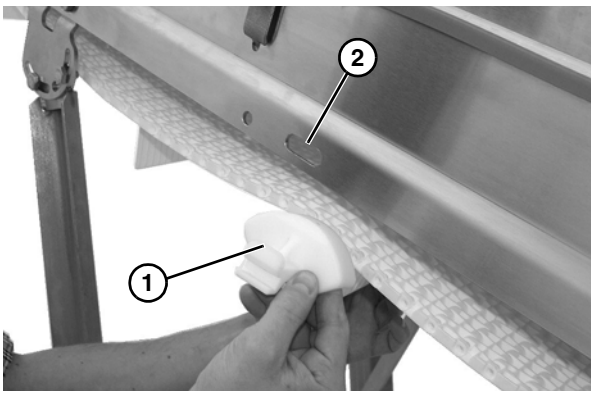


Figure 18

2. Install belt **(Figure 19, item** 1) around lower frame section and above lower wear strip **(Figure 19, item** 2).

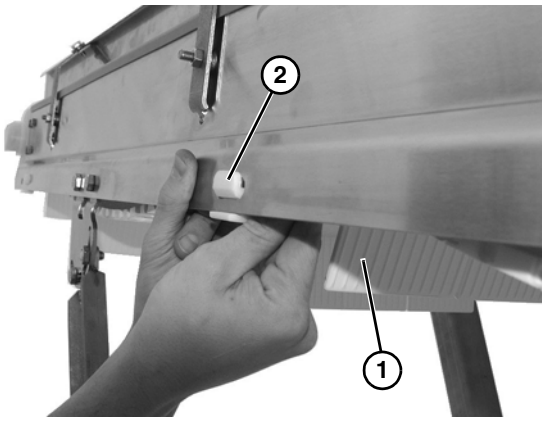


Figure 19

1. Check belt sag by measuring from the bottom of conveyor frame **(Figure 20)**. Belt sag should not exceed 2" (51 mm).

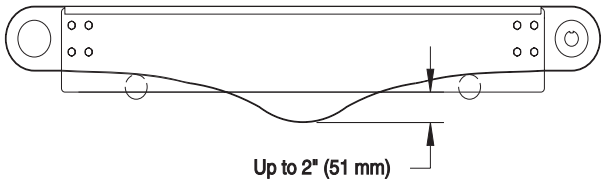


Figure 20

CAUTION

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

Returns for conveyors 26" - 36" wide

1. Install belt return mounting bracket **(Figure 21, item 1)** into slotted frame hole **(Figure 21, item 2)**.

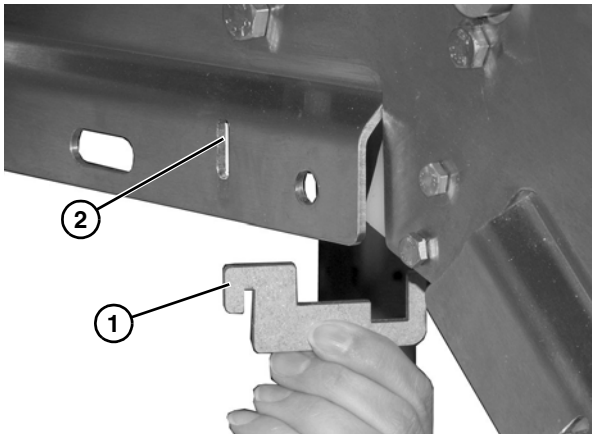


Figure 21

2. Install belt return **(Figure 22, item 1)** onto mounting bracket **(Figure 22, item 2)**.

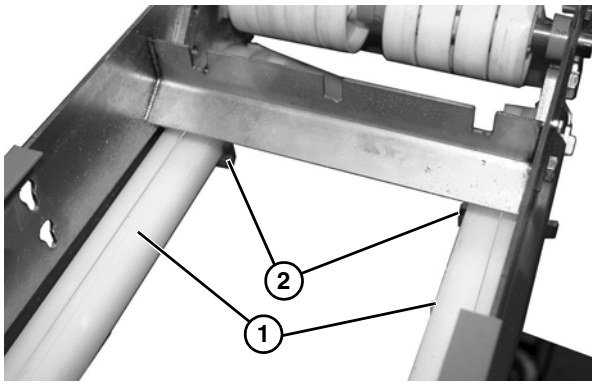


Figure 22

3. Verify that belt returns are mounted correctly by following graphic below **(Figure 23)** shows incorrect mounting and **(Figure 24)** shows correct mounting.

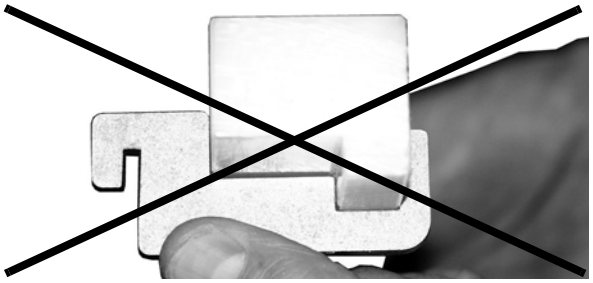


Figure 23

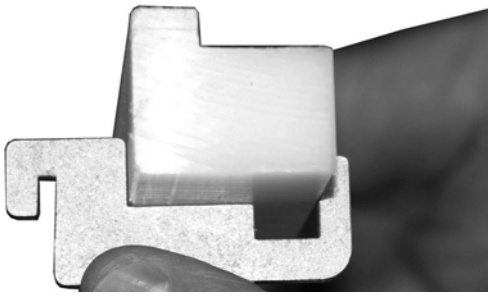


Figure 24

Guide Installation

1. Insert carriage bolts with spacers **(Figure 25, item 1)** into slotted holes in conveyor side.

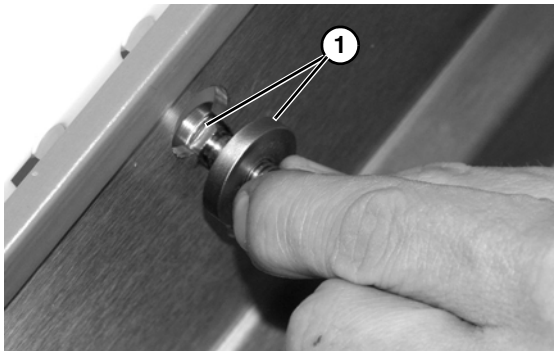


Figure 25

2. Attach the guide mounting brackets **(Figure 26, item 1)** to the conveyor with hex nuts **(Figure 26, item 2)**. Hand tighten only at this time.

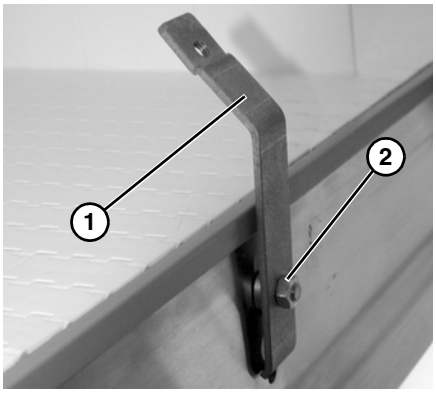


Figure 26

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

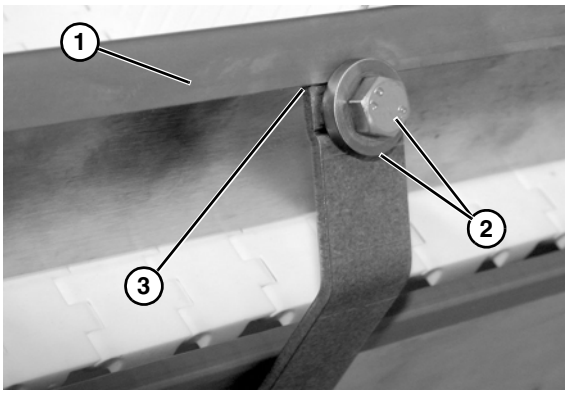


Figure 27

4. Ensure that nose of bracket slips under the lip of guide **(Figure 27, item 3)**.

NOTE
*When installing guides, be sure that the angled end of guide is installed on the idler end of conveyor **(Figure 28, item 1)**.*

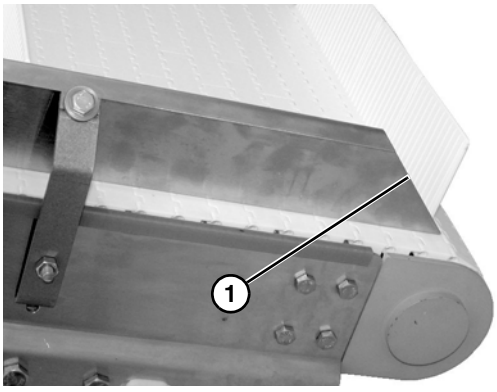


Figure 28

5. Tighten all mounting hardware.

Drive Package Installation

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

- 851-680 Side Mount Nose Bar Drive Package

1. Attach the motor **(Figure 29, item 1)** to the gear reducer **(Figure 29, item 2)**.

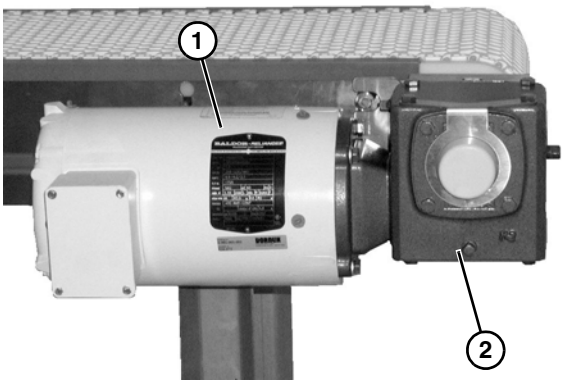


Figure 29

Required Tools

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

Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 24 for recommendations.
- Replace any worn or damaged parts.

Cleaning

NOTE

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

CAUTION

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

⚠ WARNING

SEVERE HAZARD!

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

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

Visit www.dorner.com for complete list of troubleshooting solutions.

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

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

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

Skipping indicates:

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

Preventive Maintenance and Adjustment

Conveyor Belt Replacement

⚠ WARNING

SEVERE HAZARD!

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

1. Remove guides **(Figure 30, item 1)** when required.

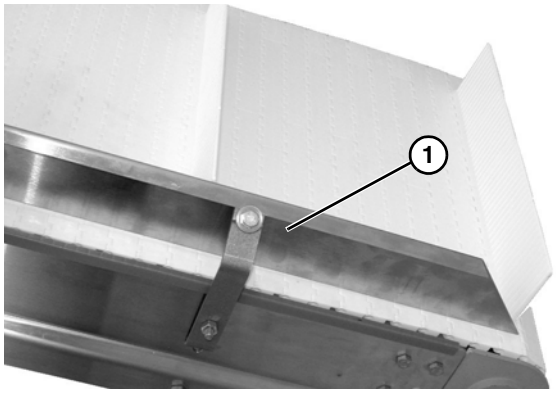


Figure 30

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head **(Figure 31)**.

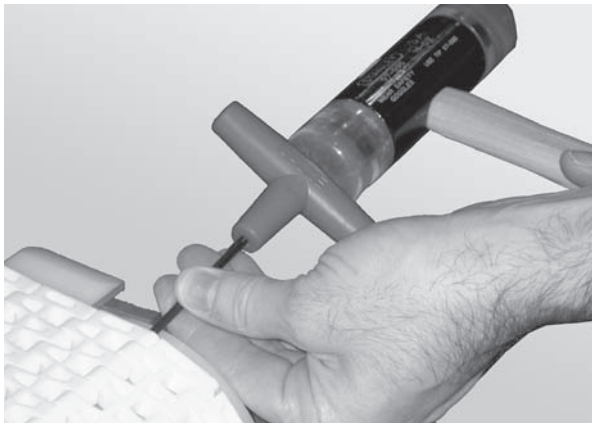


Figure 31

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

CAUTION

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

Conveyor Belt Tensioning

⚠ WARNING

SEVERE HAZARD!

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

NOTE

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

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

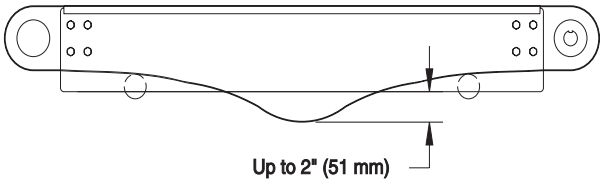


Figure 32

CAUTION

Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame (Figure 32).

Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips **(Figure 33)**

1	Bar Cap
2	Wear Strips, Bed Frame

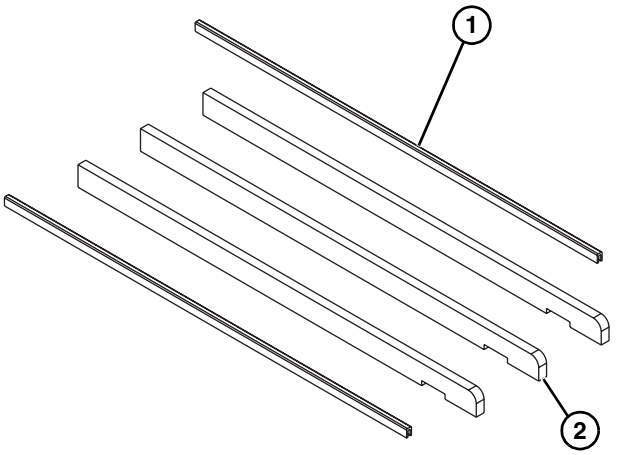


Figure 33

Bar Cap Replacement

1. Remove worn bar cap **(Figure 34, item 1)** by lifting off of conveyor side rail.

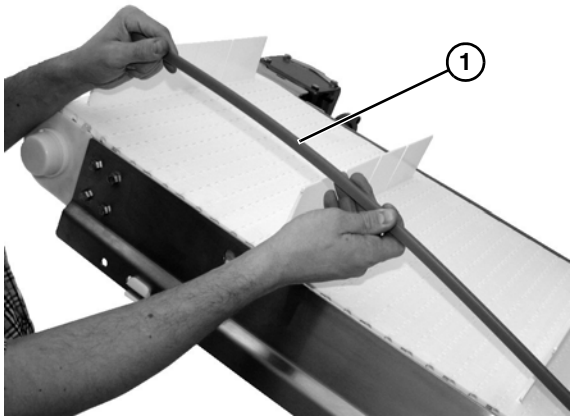


Figure 34

2. Replace with new bar cap.

Wear Strip Removal

1. Remove conveyor belt. See “Conveyor Belt Replacement” on page 14.
2. Remove worn wear strips **(Figure 35, item 1)** from frame notches.

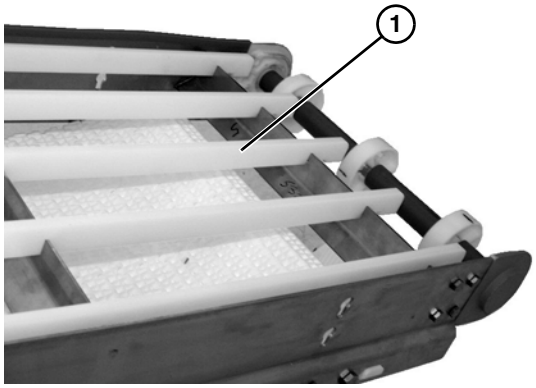


Figure 35

3. Replace with new wear strips.

Drive Sprocket and Spindle Replacement

⚠ WARNING

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

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Open conveyor belt. See “Conveyor Belt Replacement” on page 14.
3. Remove output shaft key **(Figure 36, item 1)**.

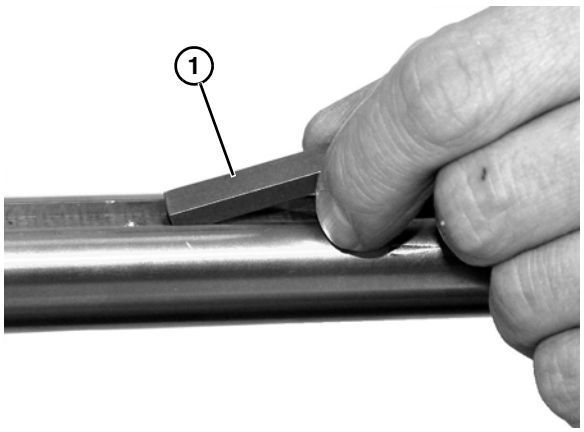


Figure 36

4. Remove belt return **(Figure 37, item 1)**.

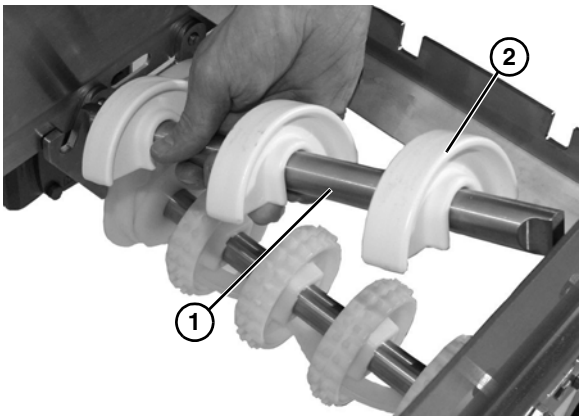


Figure 37

5. Remove and replace belt return shoes if worn **(Figure 37, item 2)**.
6. When replacing belt return, be sure shaft is seated in pocket on side plate **(Figure 38, item 1)**.

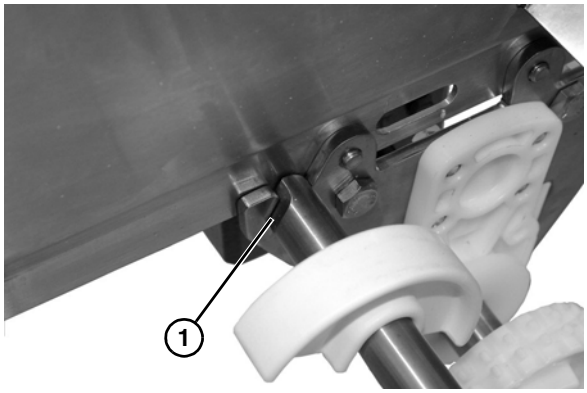


Figure 38

7. Remove the four head plate bolts **(Figure 39, item 1)** on both sides of conveyor.

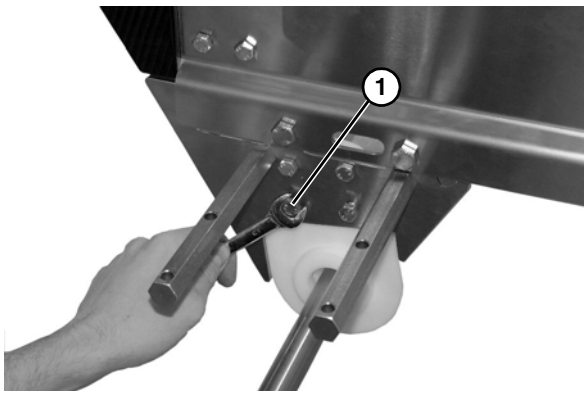


Figure 39

8. Remove tail assembly.

9. Slide off tube spacer **(Figure 40, item 1)** and tail through plate **(Figure 40, item 2)**.

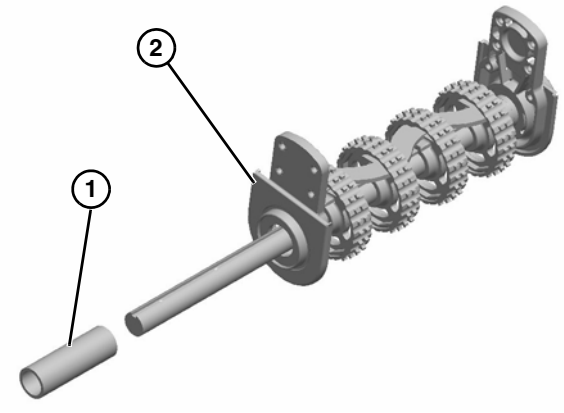


Figure 40

10. Slide entire sprocket assembly slightly outward, and remove the first sprocket **(Figure 41, item 1)** off the drive spindle and alignment bar **(Figure 41, item 2).**

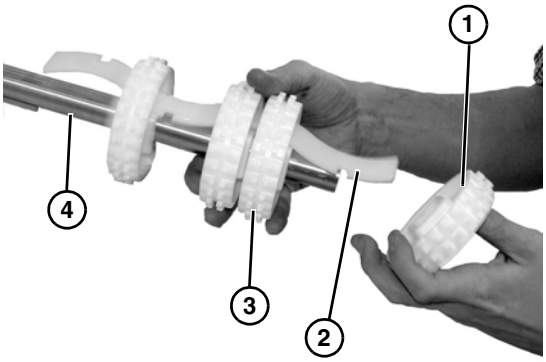


Figure 41

11. Remove remaining sprockets **(Figure 41, item 3)** off the alignment bar as you slide entire assembly off the drive spindle **(Figure 41, item 4)**.
12. Remove drive spindle key **(Figure 42, item 1)** and tube spacer **(Figure 42, item 2)**.

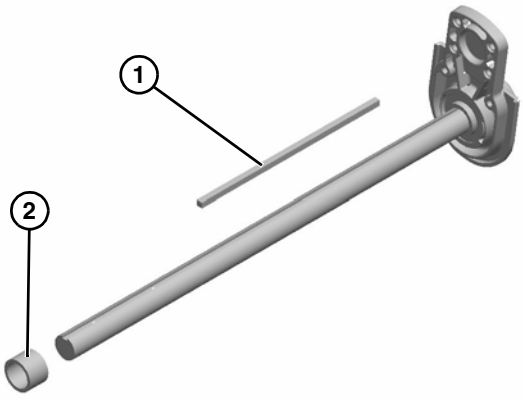


Figure 42

13. Remove bearing cover **(Figure 43, item 1)**.

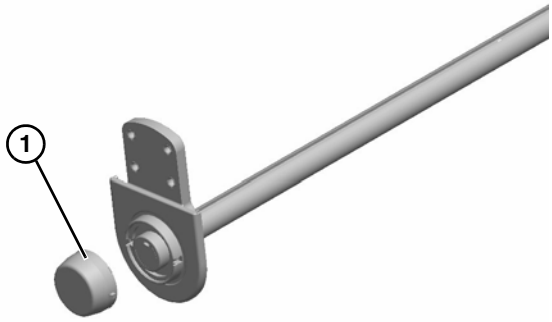


Figure 43

14. Loosen set screws **(Figure 44, item 1)** and remove tail plate **(Figure 44, item 2)**.

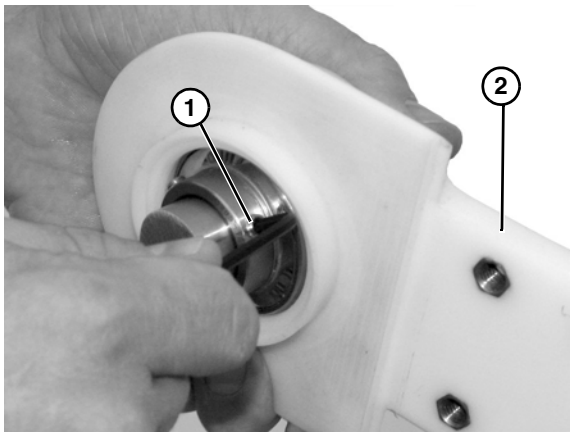


Figure 44

15. Replace bearing if worn. See “Bearing Replacement” on page 20.

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

Idler Puck and Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

NOTE

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

1. Open conveyor belt. See “Conveyor Belt Replacement” on page 14.
2. Remove four head plate bolts **(Figure 45, item 1)**. Repeat on opposite side.

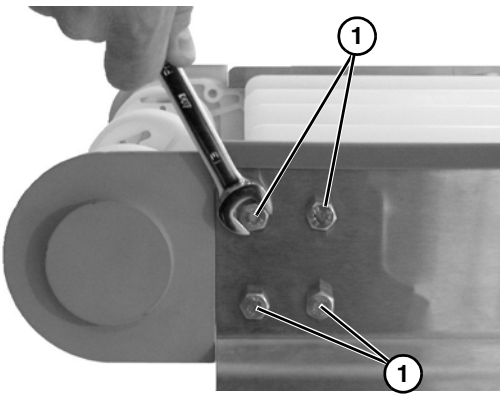


Figure 45

3. Remove idler tail assembly **(Figure 46, item 1)**.

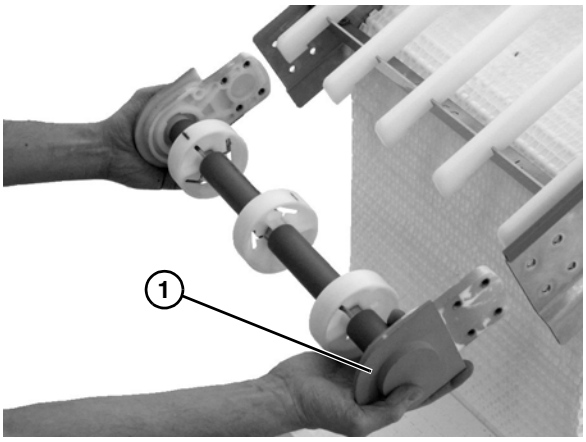


Figure 46

4. Slide off idler head plate **(Figure 47, item 1)** from shaft **(Figure 47, item 2)**.

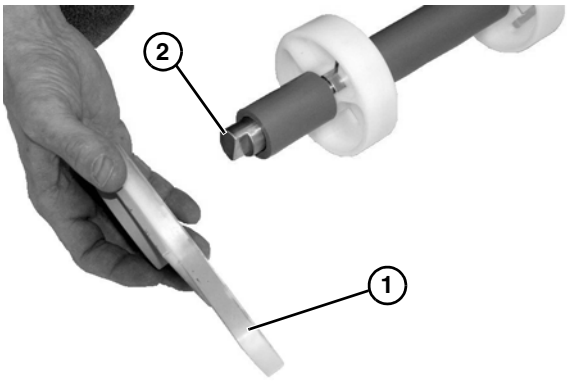


Figure 47

5. Slide off the round puck spacer **(Figure 48, item 1)**.

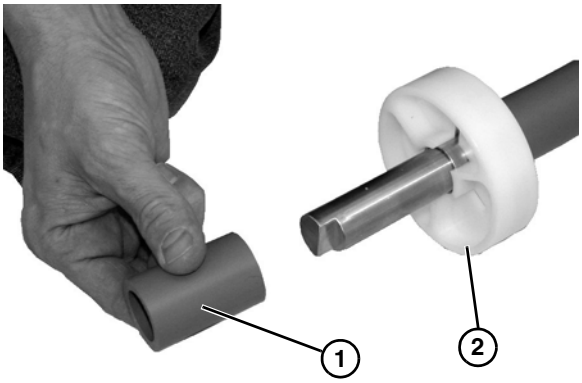


Figure 48

6. Slide off puck **(Figure 48, item 2)** and replace if worn.
7. Repeat as needed.

Nose Bar Idler Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

1. Open conveyor belt. See “Conveyor Belt Replacement” on page 14.
2. Remove the nose bar idler bar with wear strips and idler shoe attached **(Figure 49, item 1)**.

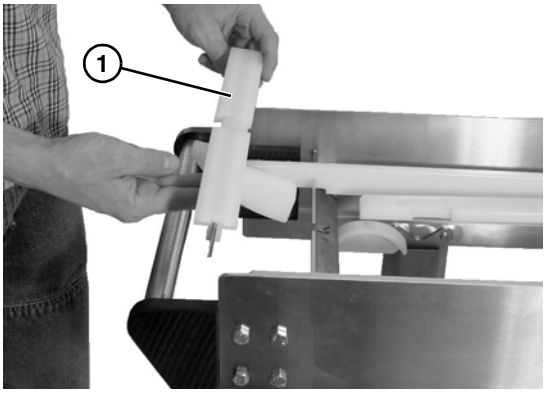


Figure 49

3. Remove and replace wear strips if worn **(Figure 50, item 1)**.

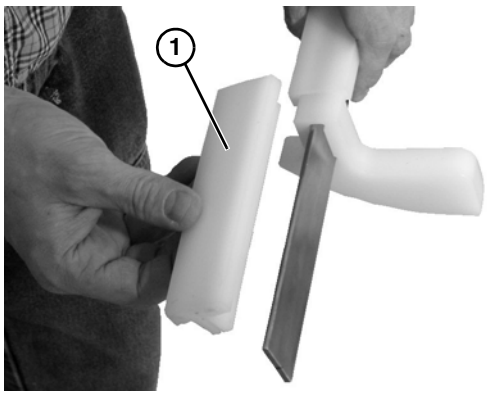


Figure 50

4. Remove and replace nose bar idler shoe if worn **(Figure 50, item 1)**.

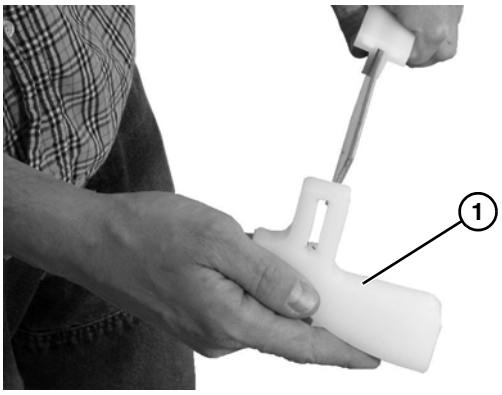


Figure 51

5. Remove four head plate bolts **(Figure 52, item 1)**.

Figure 52

6. Slide off idler roller bearing assembly **(Figure 53, item 1)**.

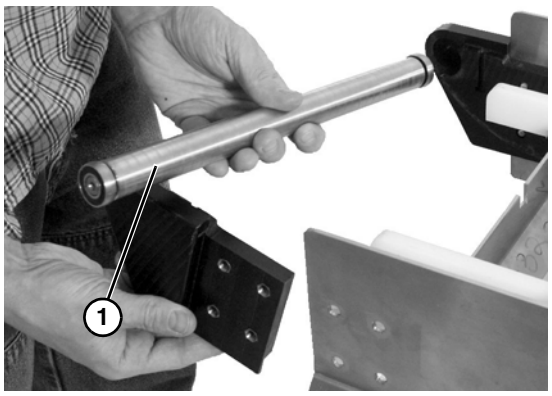


Figure 53

7. Replace bearing if worn. See “Bearing Replacement” on page 20.

Bearing Replacement

⚠ WARNING

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

Drive Bearing Removal and Replacement

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. See “Drive Sprocket and Spindle Replacement” on page 16. Follow steps 1 through 14.
2. Twist the bearing out **(Figure 54, item 1)**.

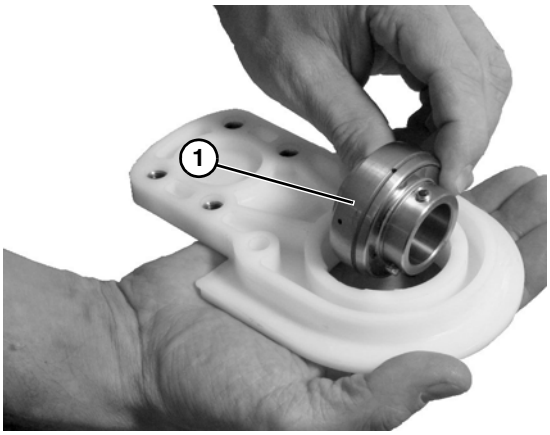


Figure 54

3. Replace bearing.

Idler Bearing Removal and Replacement

1. See “Nose Bar Idler Spindle Replacement” on page 19. Follow steps 1 through 6.
2. Using a bearing removal tool **(Figure 55, item 1)** remove the bearing **(Figure 55, item 2)**.

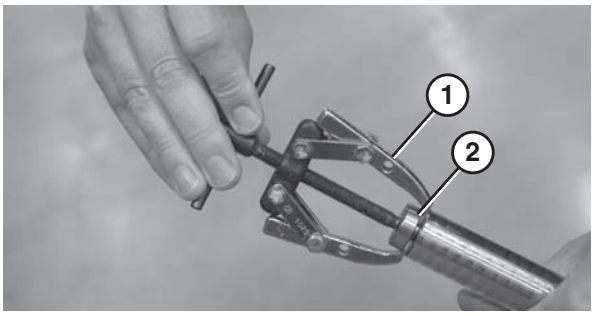


Figure 55

3. Press on new bearing.

CAUTION

Press on inner race only, pressing on outer race could damage bearing.

Maintenance of Knuckles

Lower Knuckle

1. Remove belt. See “Conveyor Belt Replacement” on page 14.
2. Remove two cap screws **(Figure 56, item 1)** on each side of the knuckle and remove the hold down roller guards **(Figure 56, item 2)**. Repeat on opposite side of the conveyor.

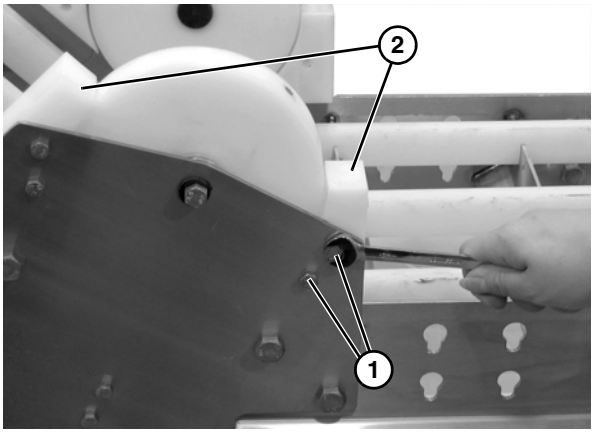


Figure 56

3. Remove the cap screw **(Figure 57, item 1)** and the hold down roller **(Figure 57, item 2)**. Repeat on opposite side of the conveyor.

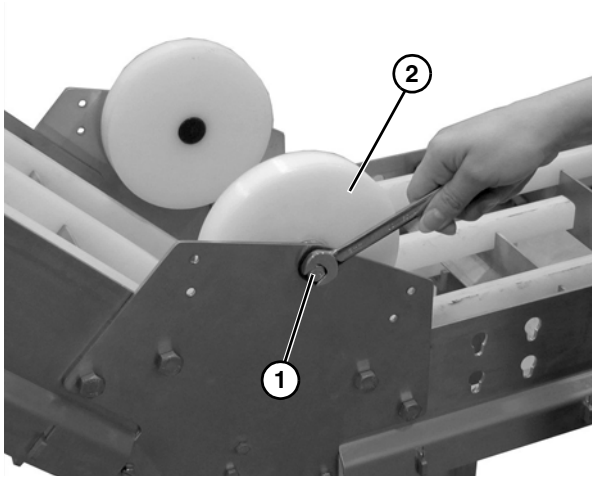


Figure 57

4. Remove two cap screws **(Figure 58, item 1)** and the inner belt return guide **(Figure 59, item 1)**. Repeat on opposite side of the conveyor.

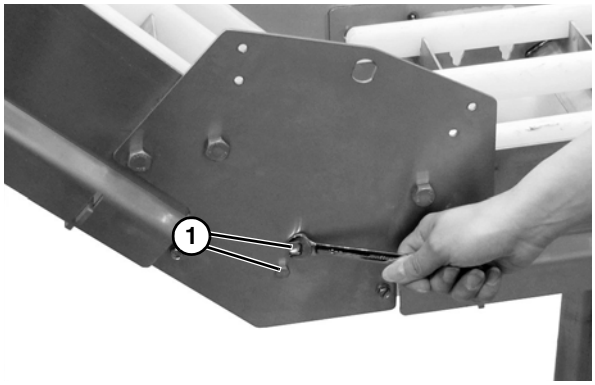


Figure 58

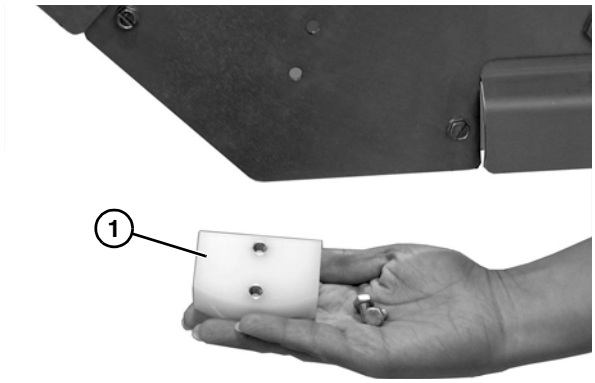


Figure 59

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

Upper Knuckle

1. Remove belt. See “Conveyor Belt Replacement” on page 14.
2. Remove cap screw **(Figure 60, item 1)** and edge guide plate **(Figure 60, item 2)** from each side of the conveyor.

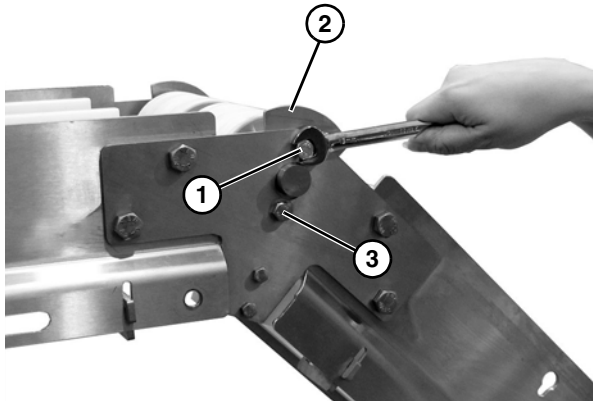


Figure 60

3. Remove the cap screw **(Figure 60, item 3)** and shaft clamp **(Figure 61, item 1)** from each side of the conveyor.

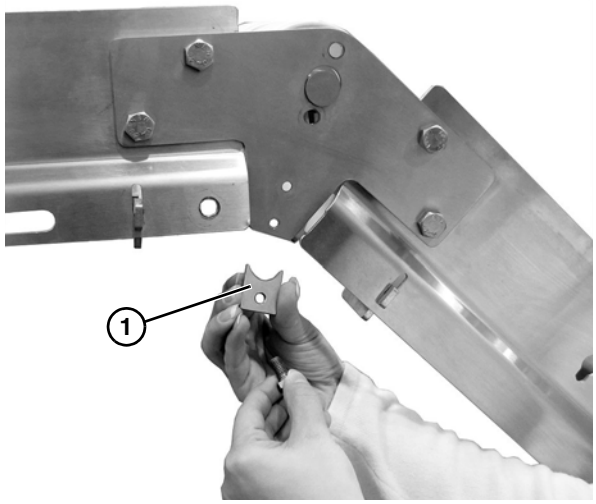


Figure 61

4. Slide shaft **(Figure 62, item 1)** inwards to remove from knuckle frame **(Figure 63, item 1)**.

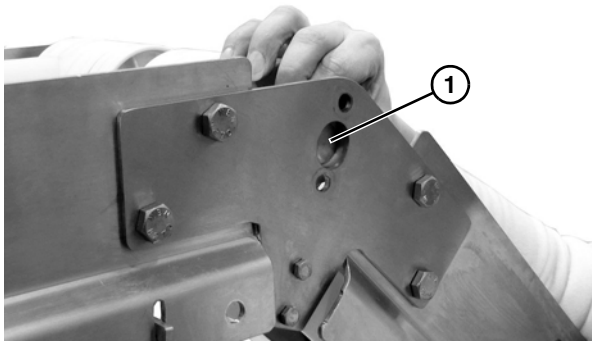


Figure 62

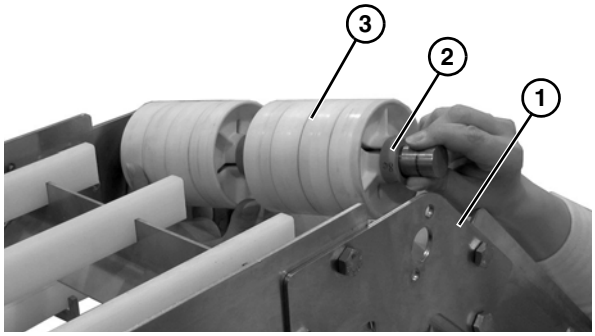


Figure 63

NOTE

*Spacer **(Figure 63, item 2)** and pucks **(Figure 63, item 3)** are loose and can slide off the shaft.*

5. Remove spacer **(Figure 64, item 1)**, rollers **(Figure 64, item 2)** and tube spacers **(Figure 64, item 3)** from shaft.

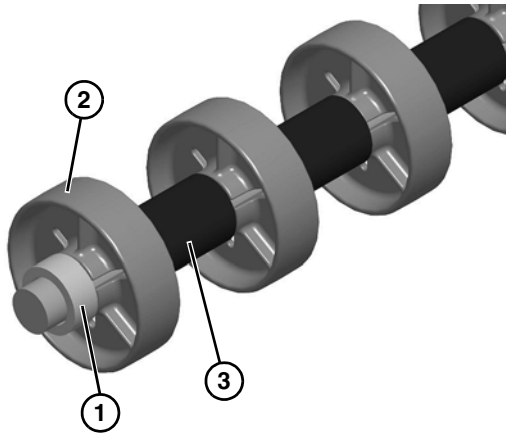


Figure 64

6. Remove two cap screws **(Figure 65, item 1)** and inner belt return guide **(Figure 66, item 1)**. Repeat on opposite side of the conveyor.

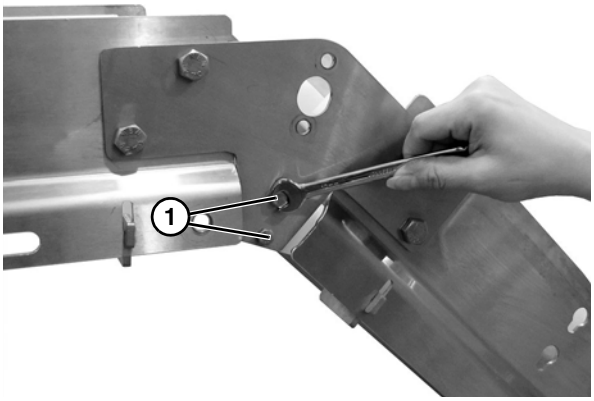


Figure 65

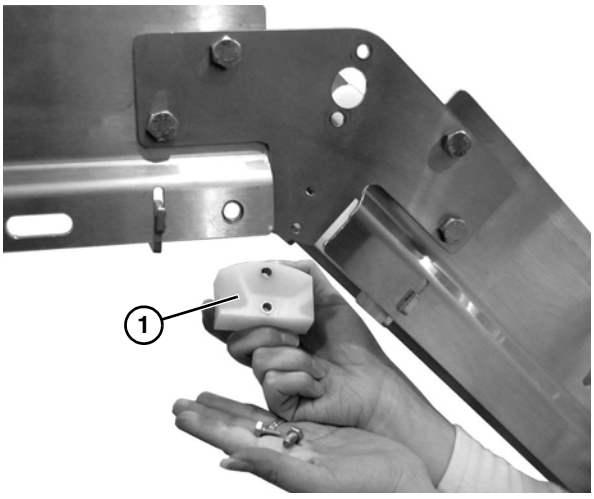


Figure 66

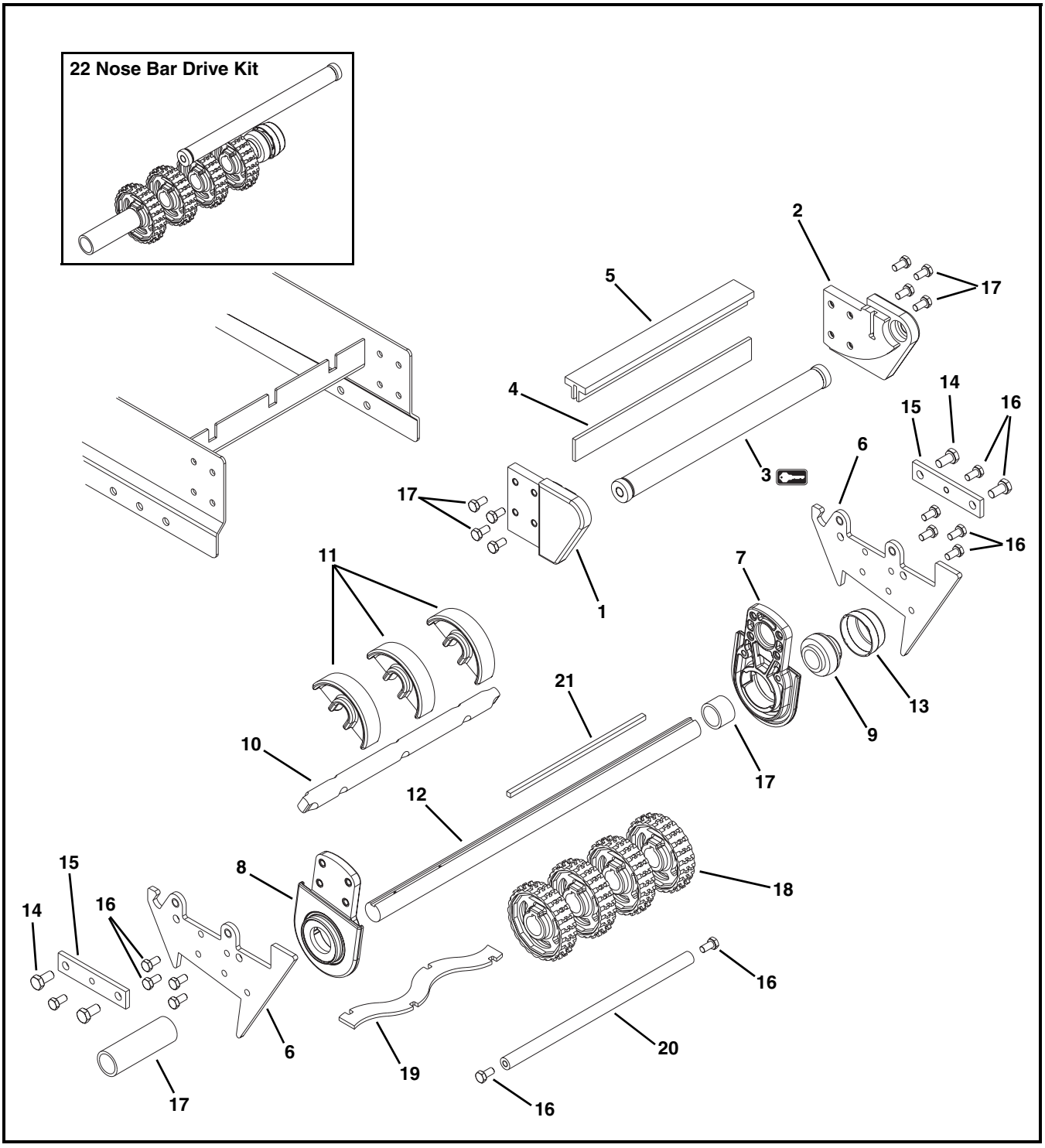
7. Replace parts as necessary.
8. Install parts reverse of removal.

Notes

Service Parts

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

Drive End Components

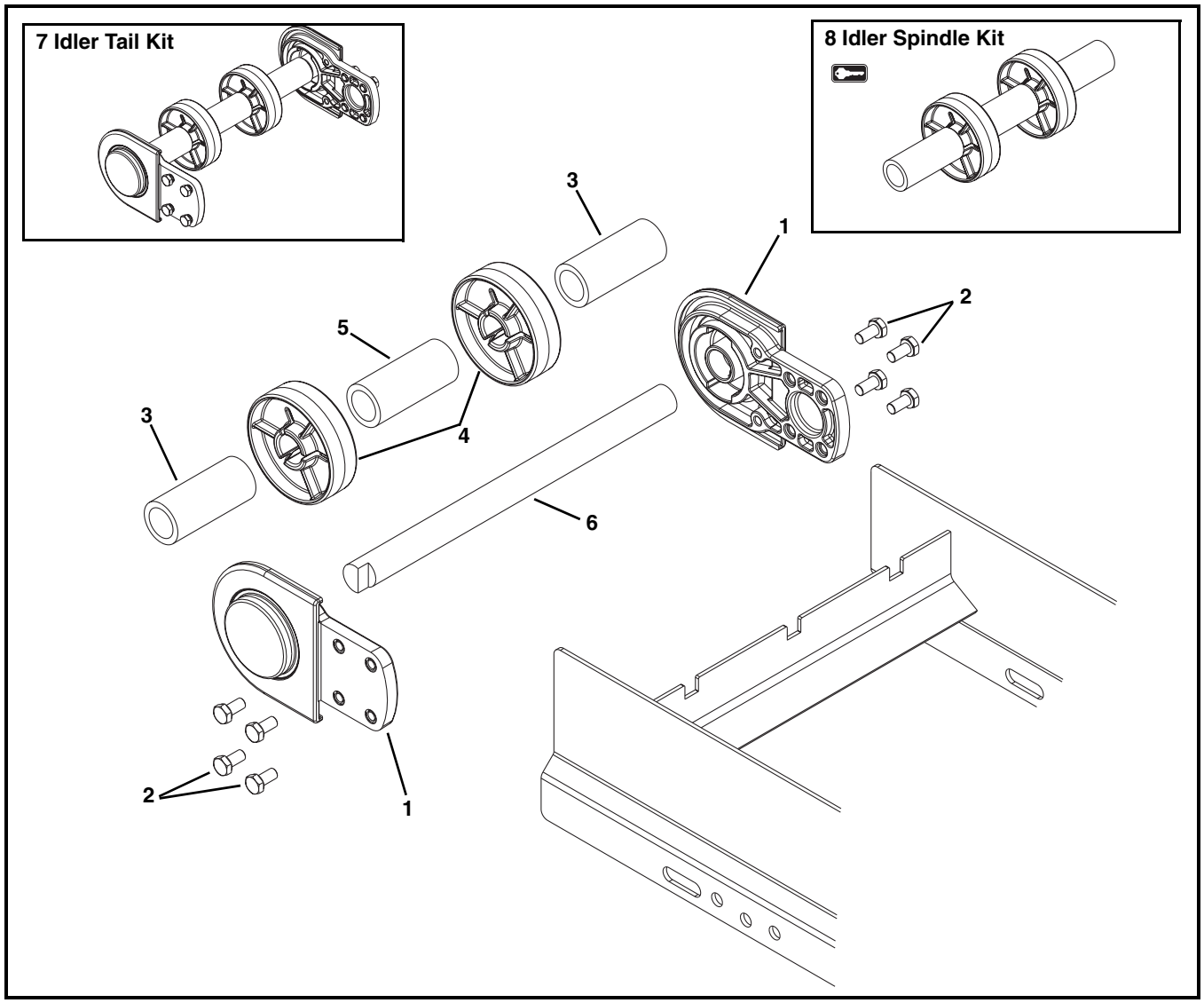


Item	Part Number	Description
1	532025	Headplate Assembly Right Hand
2	532026	Headplate Assembly Left Hand
3	735NBK-WW	Nosebar Spindle Bearing Kit
4	532135-WW	Nosebar Idler Bar
5	532136-WW	Nosebar Drive Wearstrip
6	532138	Side Plate
7	532011	Tail Plate Assembly
8	532015	Tail Plate Thru Assembly
9	802-161	Bearing
10	532134-WW	Return Shaft
11	500075	Return Shoe
12	See Nose Bar Drive Spindle Chart	Spindle
13*	807-1454	Bearing Cover
14	961020MSS	Hex Head Cap Screw, M10-1.50 x 20 mm
15	532248	Spacer Plate
16	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
17	532251-LLLLL	Tube Spacer
18	807-1761	Sprocket
19	532126-WW	Sprocket Key
20	532119-LLLLL	Rod
21	532121-LLLLL	Key
22	735NBD-WW	Nose Bar Drive Kit (Includes items 3, 9, 13, 17, and 18)
WW = Conveyor width reference: 04 – 36 in 02 increments		
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
* Not available with double output shafts		

Nose Bar Drive Spindle Chart		
Conveyor Width	US Version Gearmotor	CE Version Gearmotor
4"	532232-01340	532291-01147
6"	532232-01540	532291-01347
8"	532232-01740	532291-01547
10"	532232-01938	532291-01745
12"	532232-02135	532291-01942
14"	532232-02333	532291-02140
16"	532232-02530	532291-02337
18"	532232-02728	532291-02535
20"	532232-02925	532291-02732
22"	532232-03123	532291-02930
24"	532232-03320	532291-03127
26"	532232-03518	532291-03325
28"	532232-03715	532291-03522
30"	532232-03913	532291-03720
32"	532232-04110	532291-03917
34"	532232-04308	532291-04115
36"	532232-04505	532291-04312

Service Parts

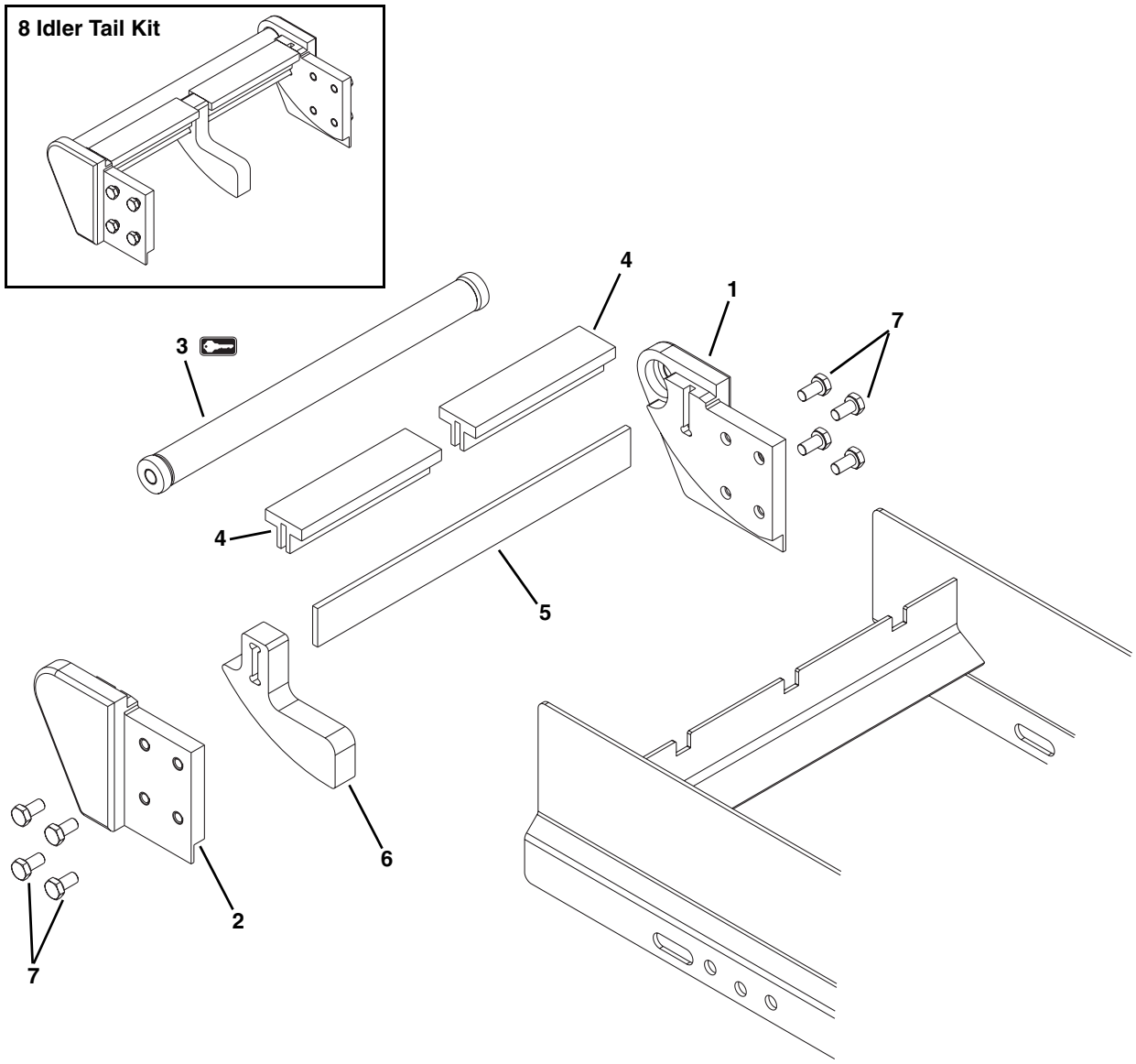
Idler End Components



Item	Part Number	Description
1	532012	Headplate Assembly
2	960816M	Hex Head Cap Screw M8-1.25 x 16mm
3	532128-WW	End Tube Spacer
4	506296	Idler Puck
5	532127-LLLLL	Tube Spacer
6	See Idler Spindle Chart	Spindle
7	735IT-WW	Idler Tail Kit (Includes items 1 through 6)
8	735IS-WW	Idler Spindle Kit (Includes items 3, 4, and 5)
WW = Conveyor width reference: 04 – 36 in 02 increments		
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		

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

Nose Bar Idler End Components

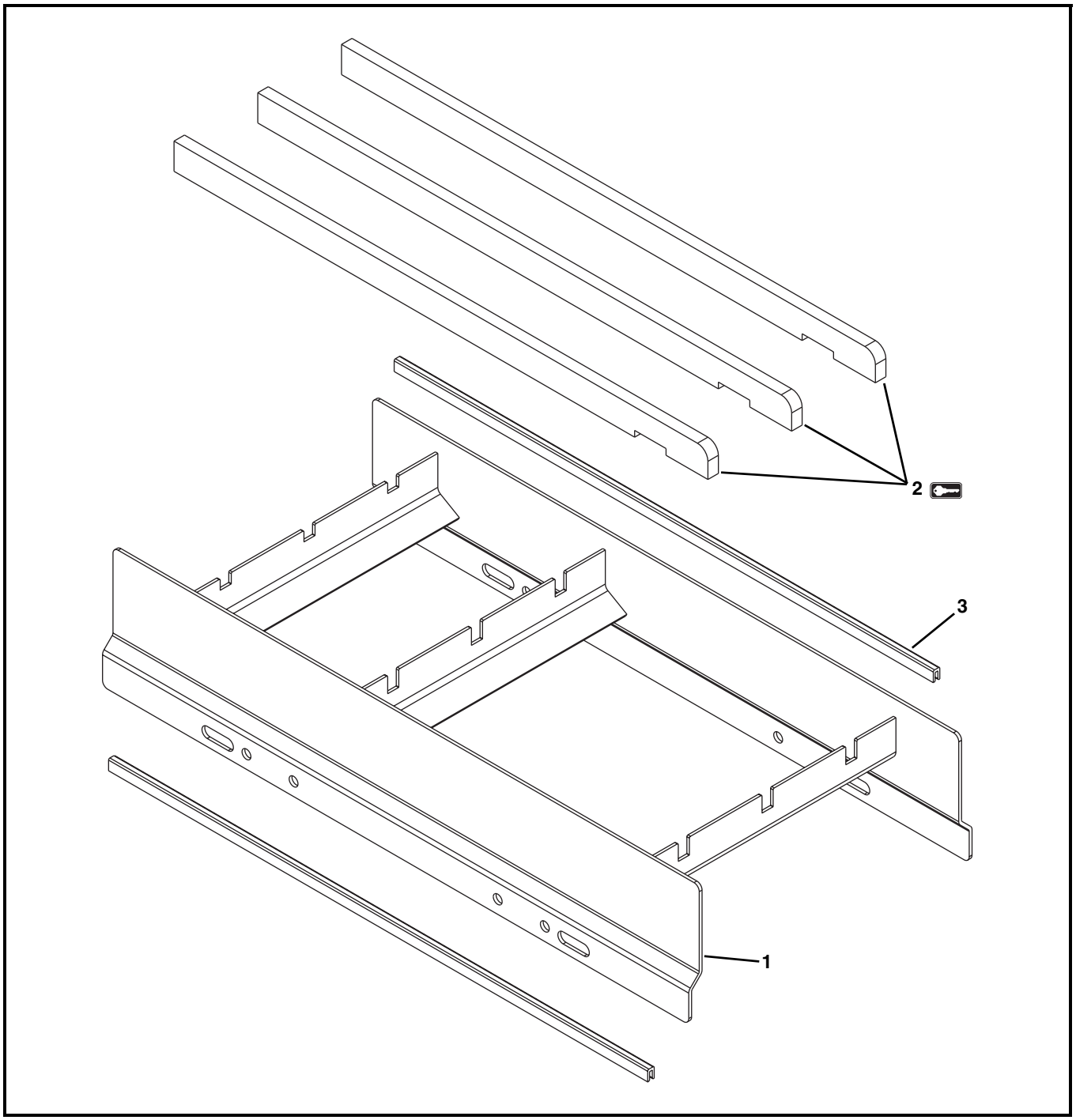


Item	Part Number	Description
1	532025	Nosebar Headplate Right Hand
2	532026	Nosebar Headplate Left Hand
3	735NBK-WW	Bearing Kit
4	532137-WW	Wear Strip
5	532135-WW	Nosebar Idler Bar

Item	Part Number	Description
6	532139	Nosebar Idler Shoe
7	960816M	Hex Head Cap Screw, M8-1.25 x 16 mm
8	735NBT-WW	Nose Bar Idler Tail Kit (Includes items 1 through 7)
WW = Conveyor width reference: 04 – 36 in 02 increments		

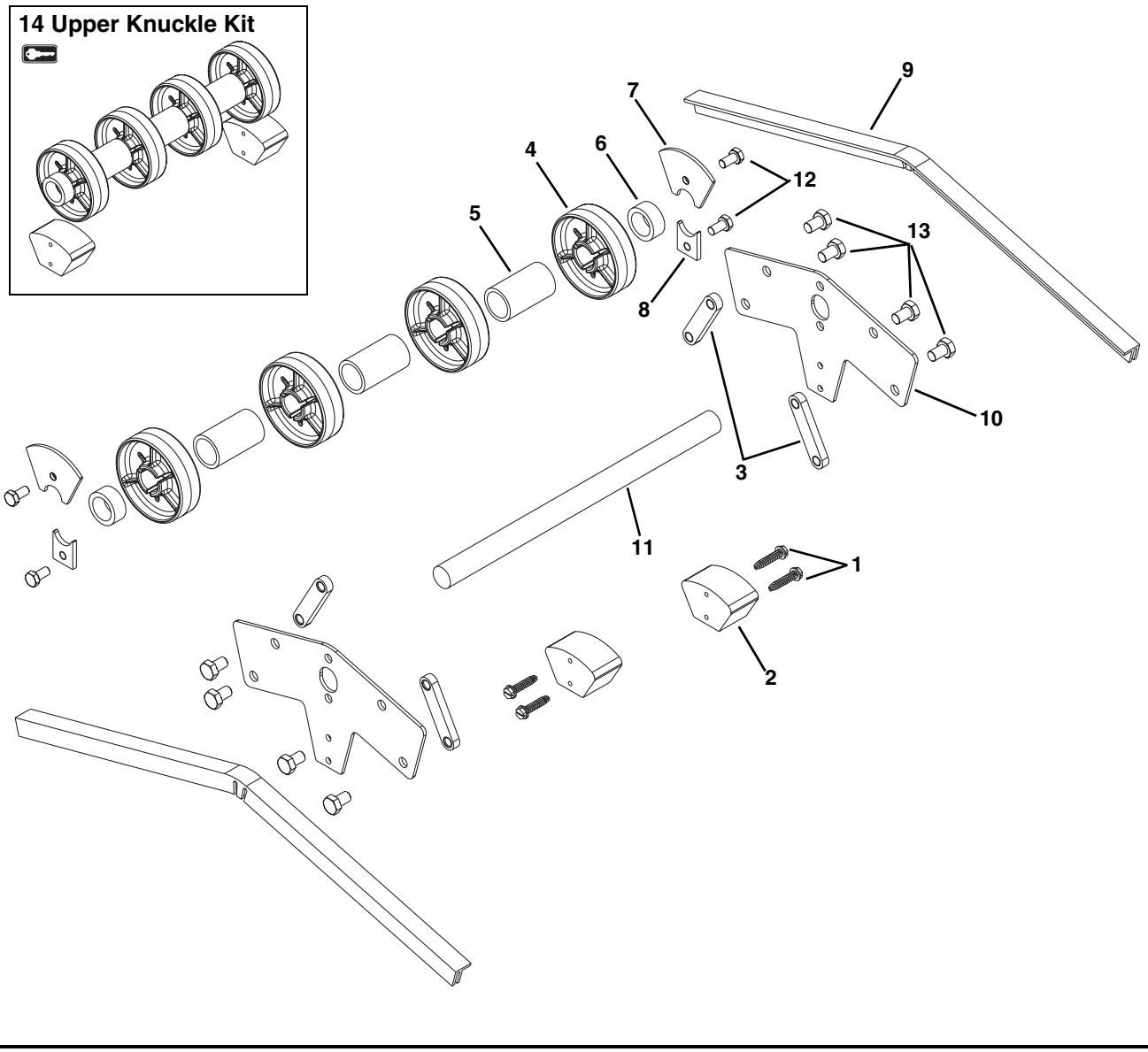
Service Parts

Frame Assembly



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

Upper Knuckle

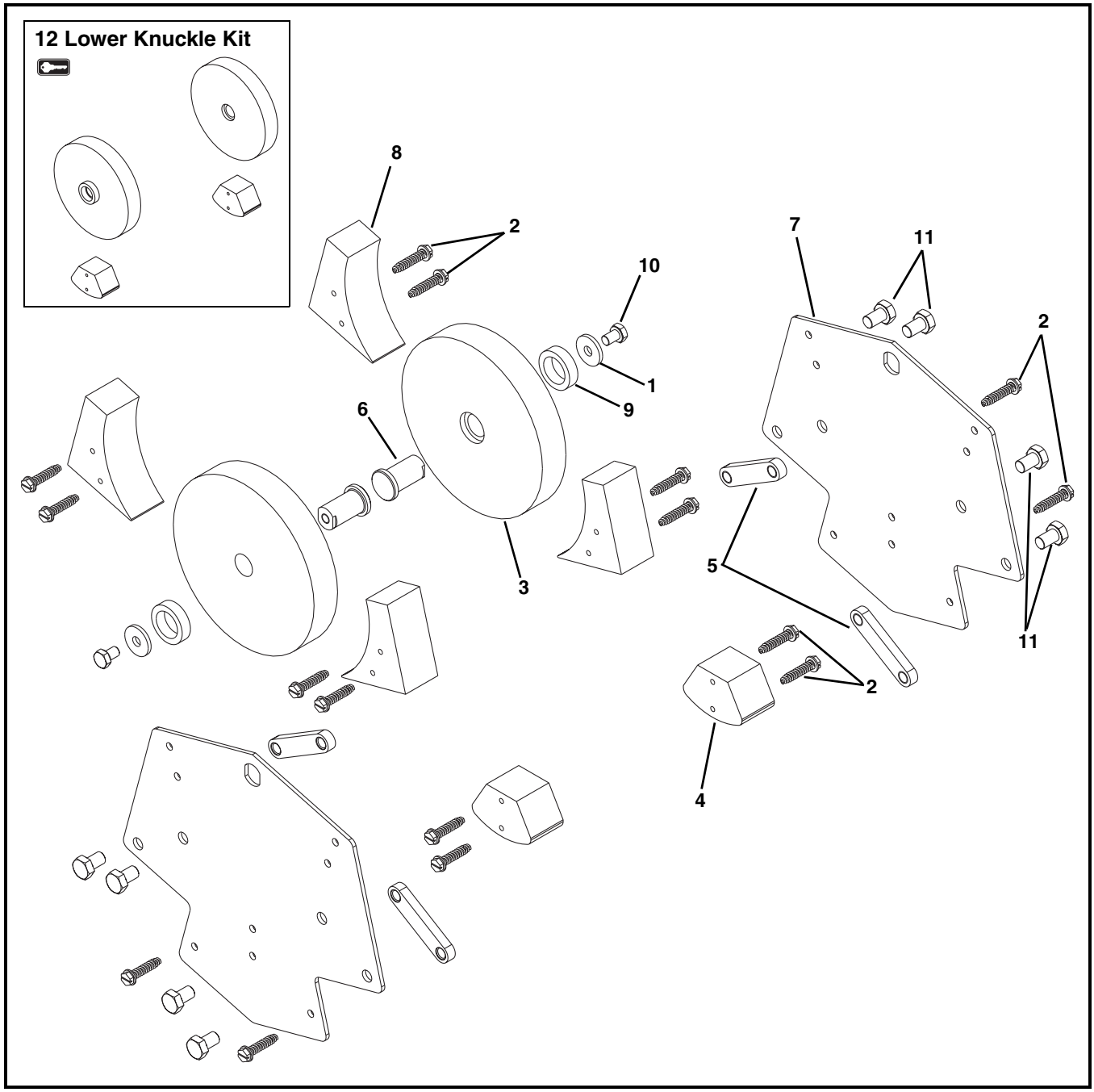


Item	Part Number	Description
1	807-1884	Sheet Metal Screw, #14 x 1.25
2	352326	Inner Belt Return Guide
3	500199	Connector
4	506296	Idler Puck
5	532251-00228	Tube Spacer
6	532305	Spacer
7	532353	Edge Guide Plate
8	532358	Shaft Clamp
9	532361	Bar Cap for Straight Conveyors
	532360	Bar Cap for Curve Conveyors
10	532376-AA	Side Plate

Item	Part Number	Description
11	532377-WW	Shaft
12	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
13	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
14	735UNS-WW	Upper Knuckle Kit for Straight Conveyor (Includes Items 2, 4, 5 and 6)
	735UNC-WW	Upper Knuckle Kit for Curve Conveyor (Includes Items 2, 4, 5 and 6)
AA = Angle 05, 10, 15, 30, 45 or 60		
WW = Conveyor width reference: 08 – 24 in 02 increments		

Service Parts

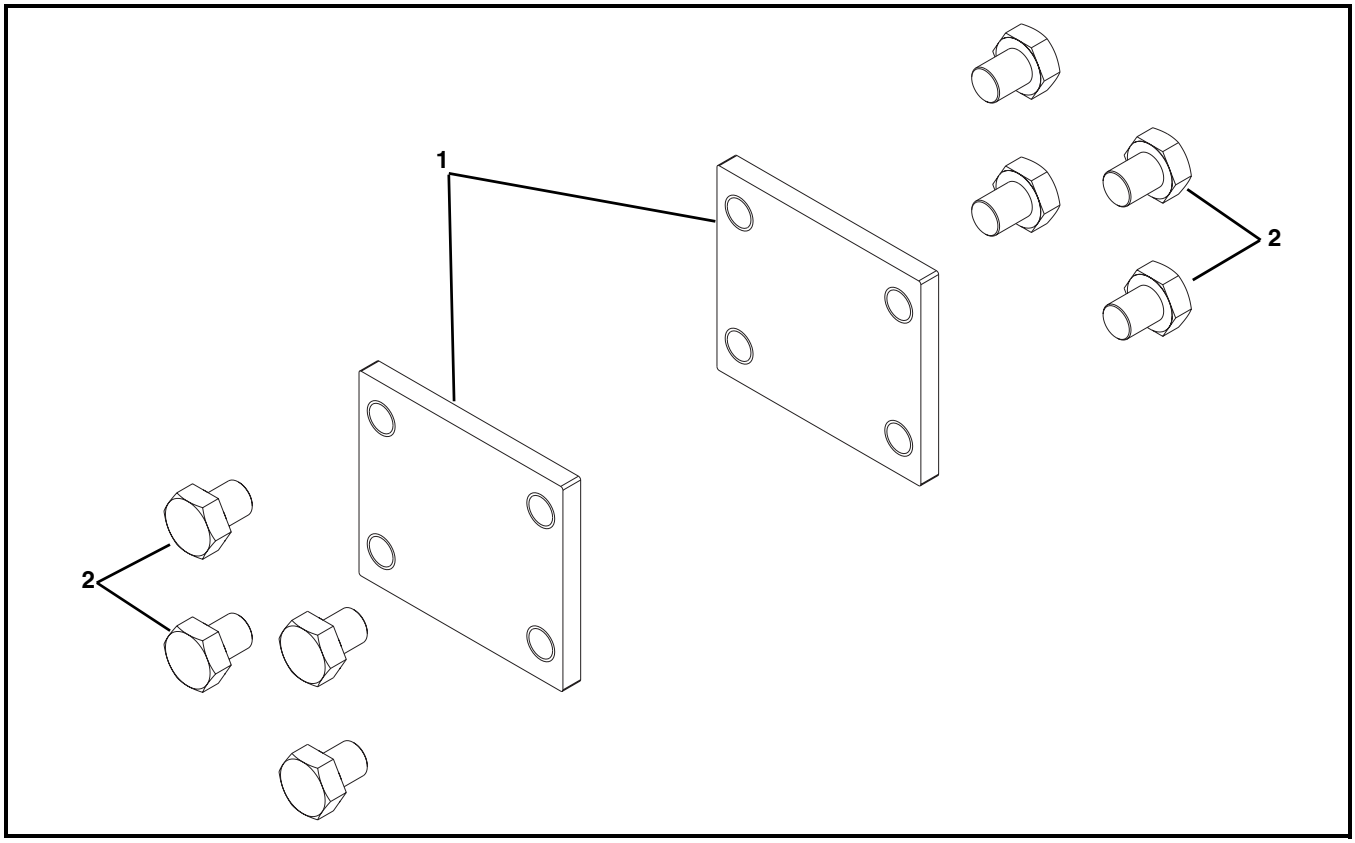
Lower Knuckle



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

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

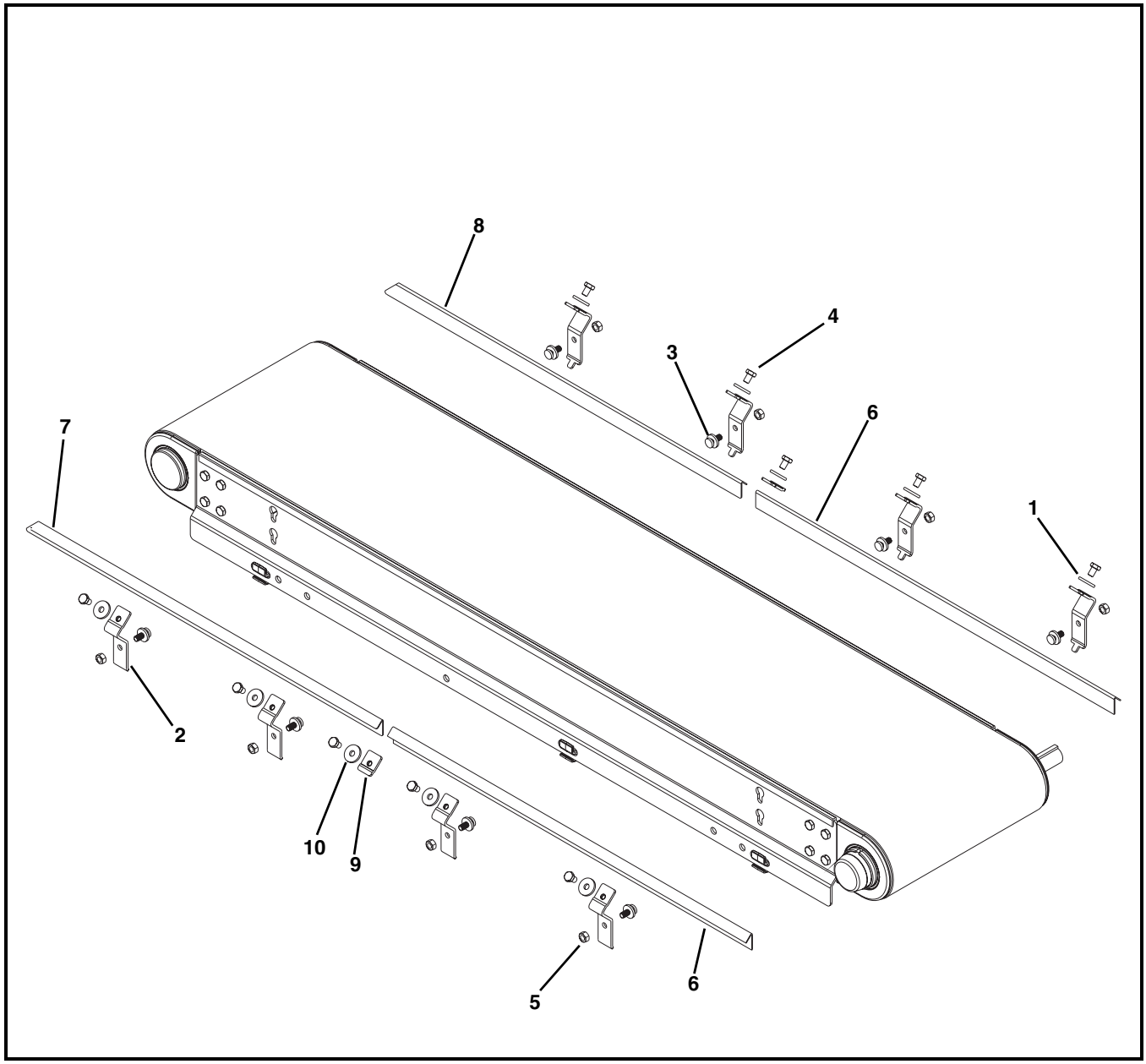
Connecting Assembly



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

Service Parts

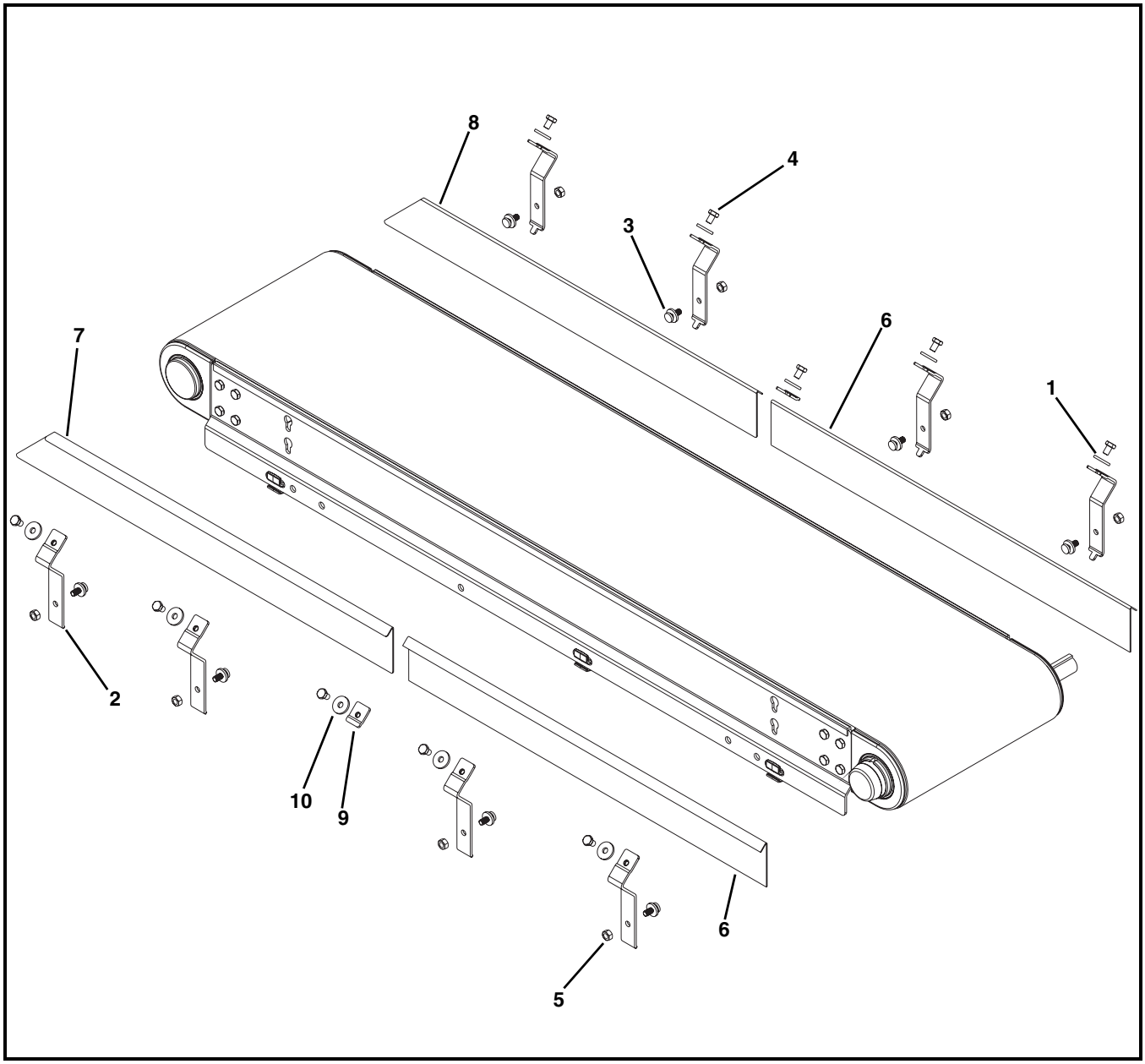
1" (25 mm) High Sides



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

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

3" (76 mm) High Sides

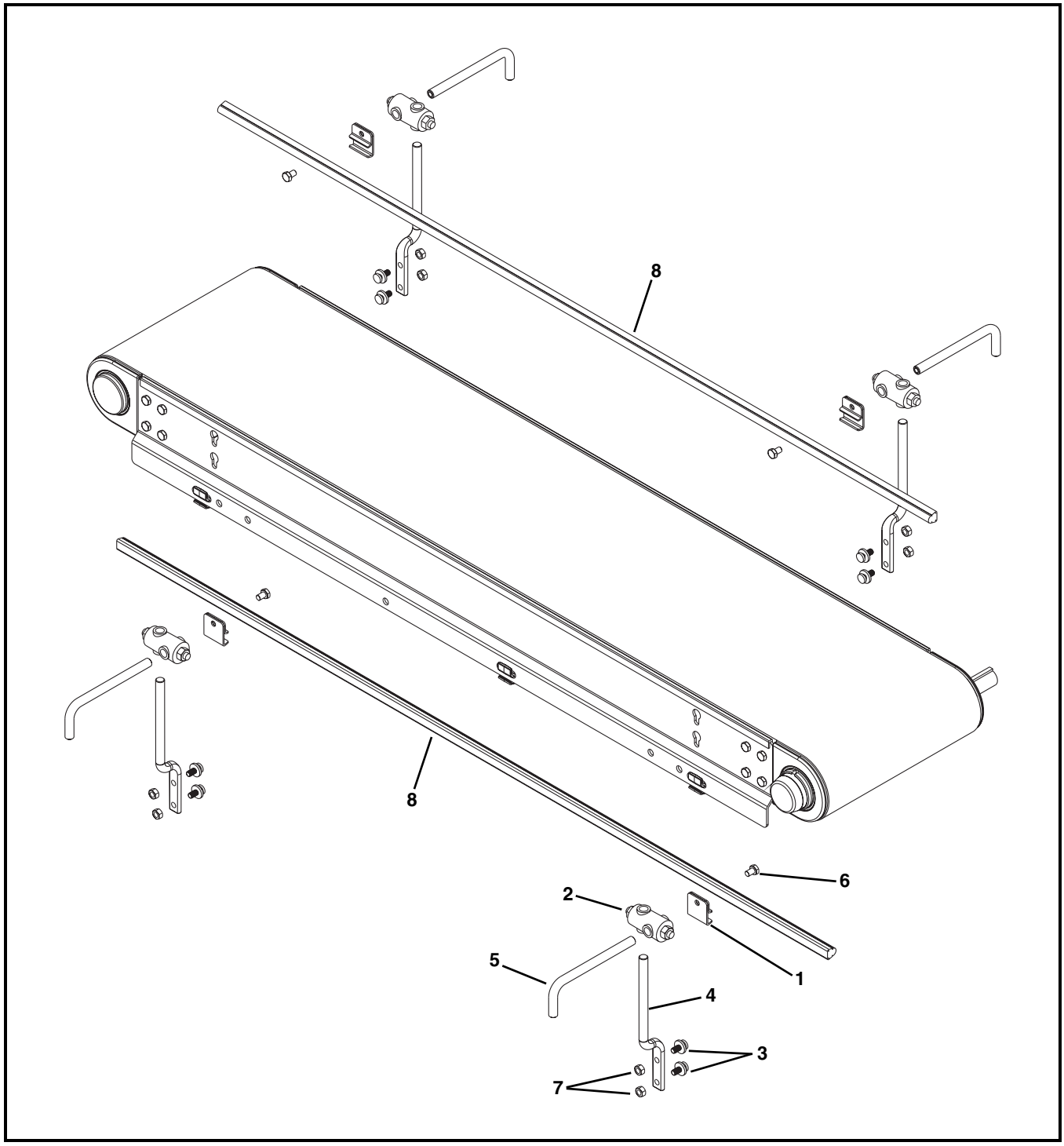


Item	Part Number	Description
1	807-1821	Washer
2	532185	3" Bracket
3	532191	Carriage Bolt M8 x 20mm
4	960812M	Hex Head Cap Screw M8-1.25 x 12mm
5	990801MSS	Hex Nut
6	532172-LLLLL	Guiding Straight

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

Service Parts

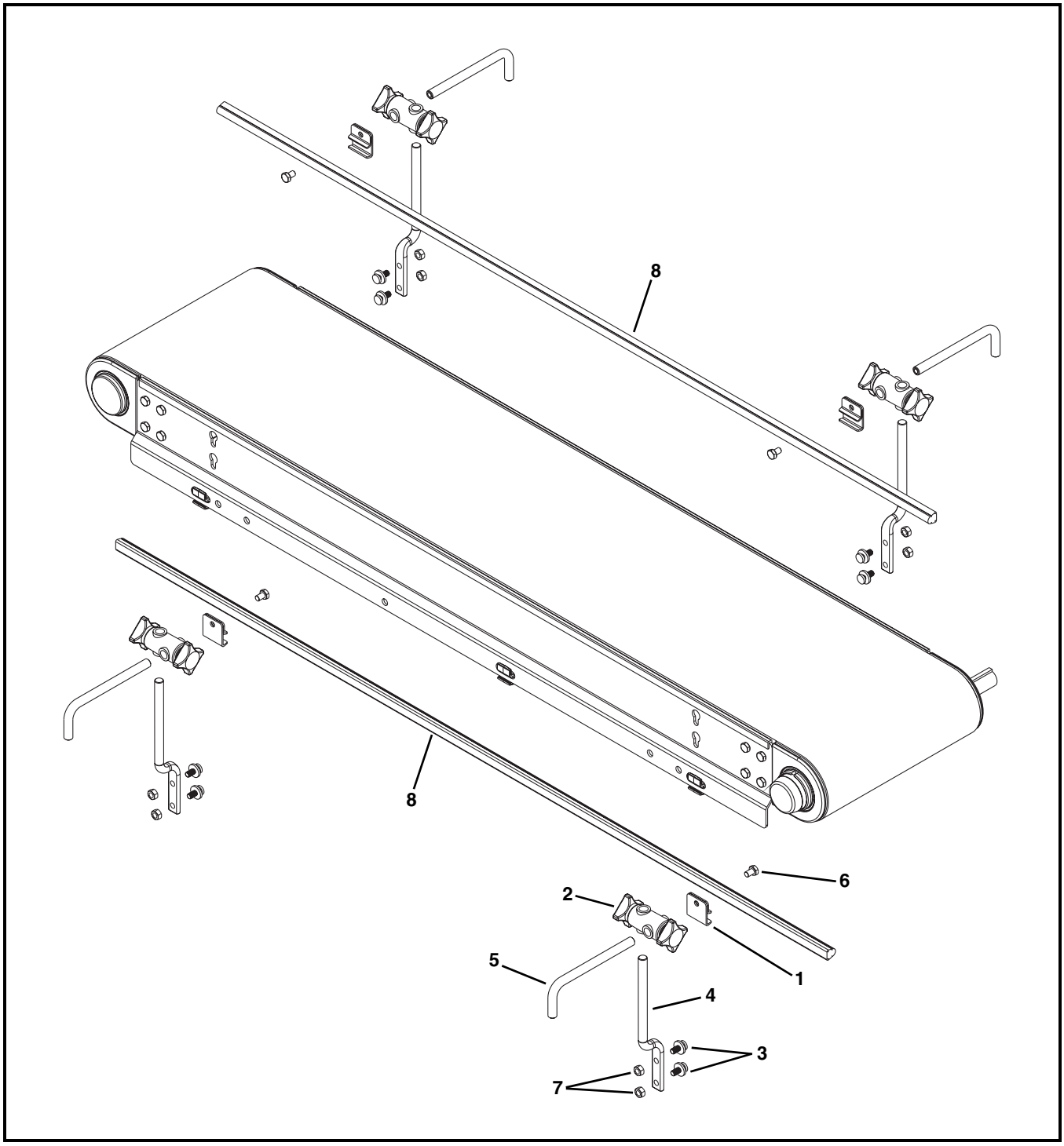
Fully Adjustable Round Guides



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

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

Tool-Less Fully Adjustable Round Guides

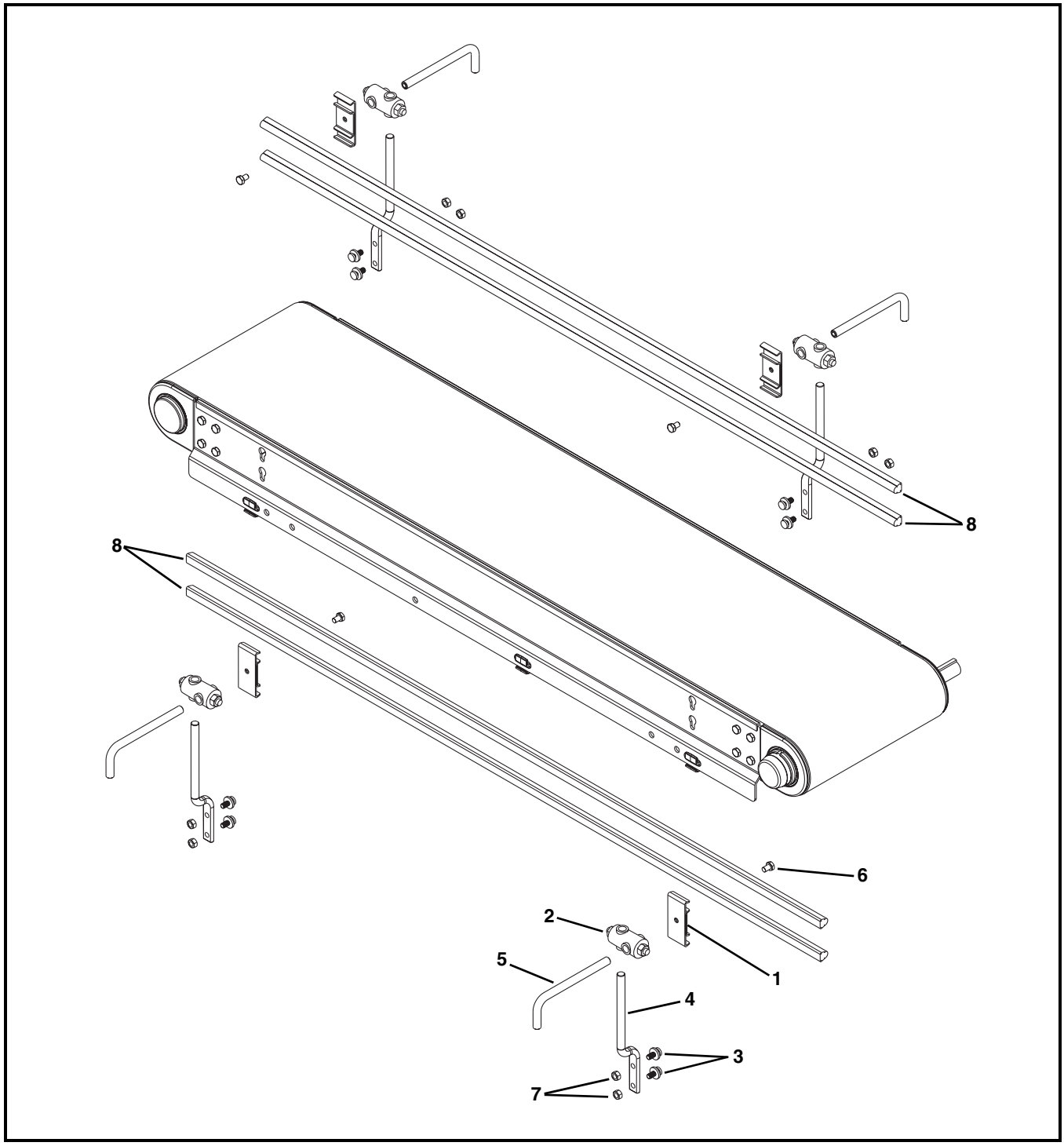


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide

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

Service Parts

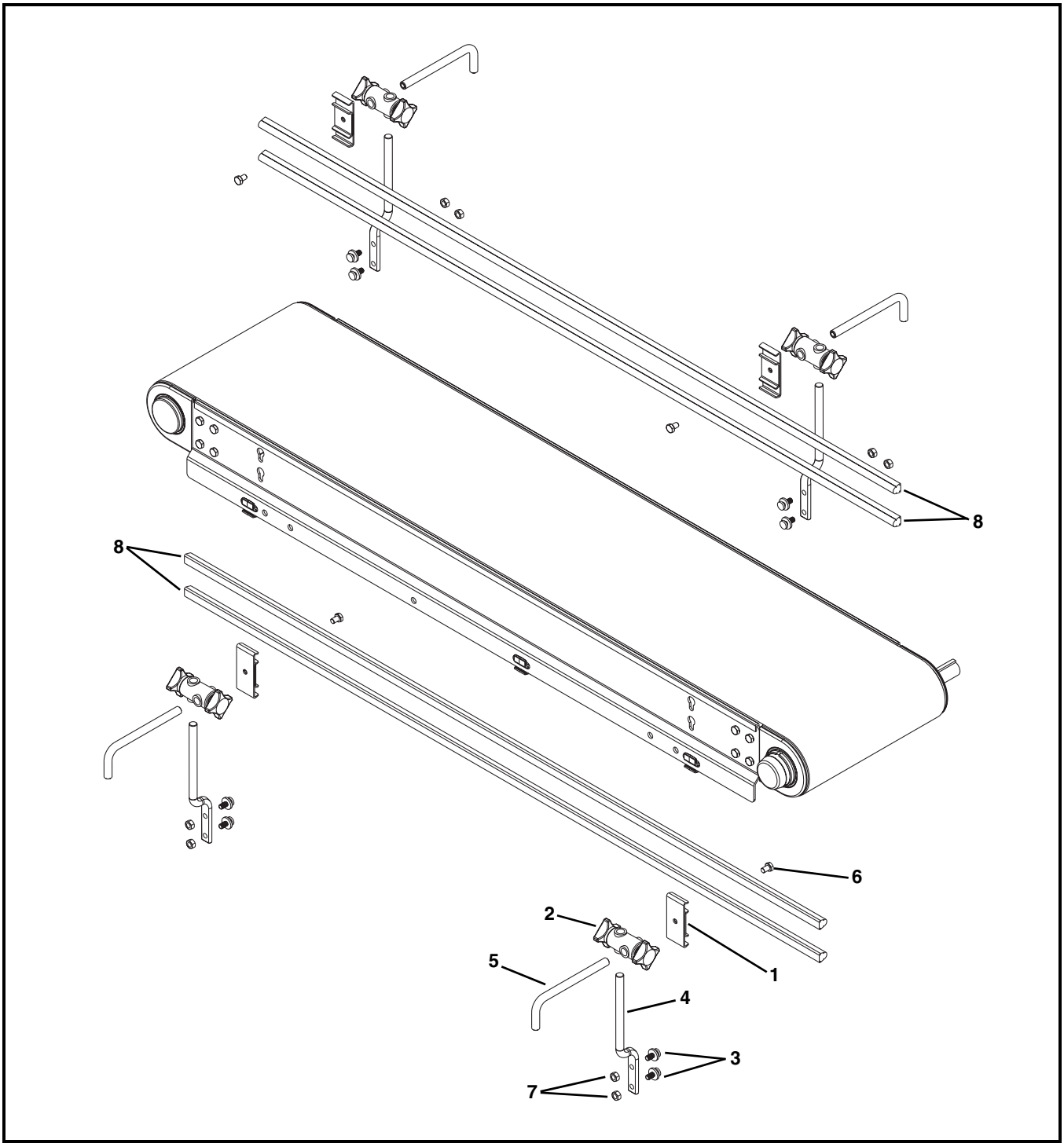
Twin Rail Adjustable Round Guides



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

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

Tool-Less Twin Rail Adjustable Round Guides

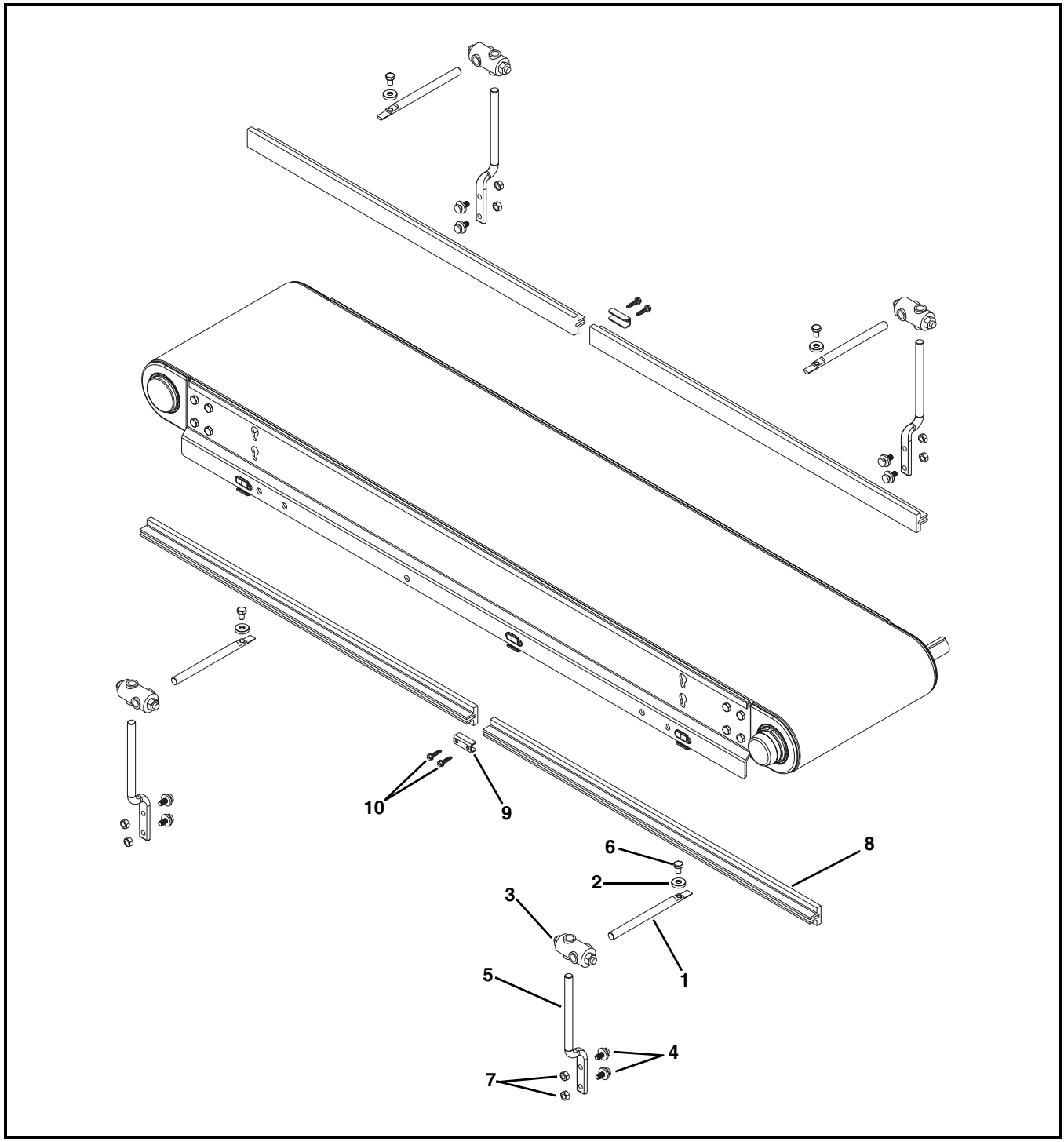


Item	Part Number	Description
1	901414	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide

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

Service Parts

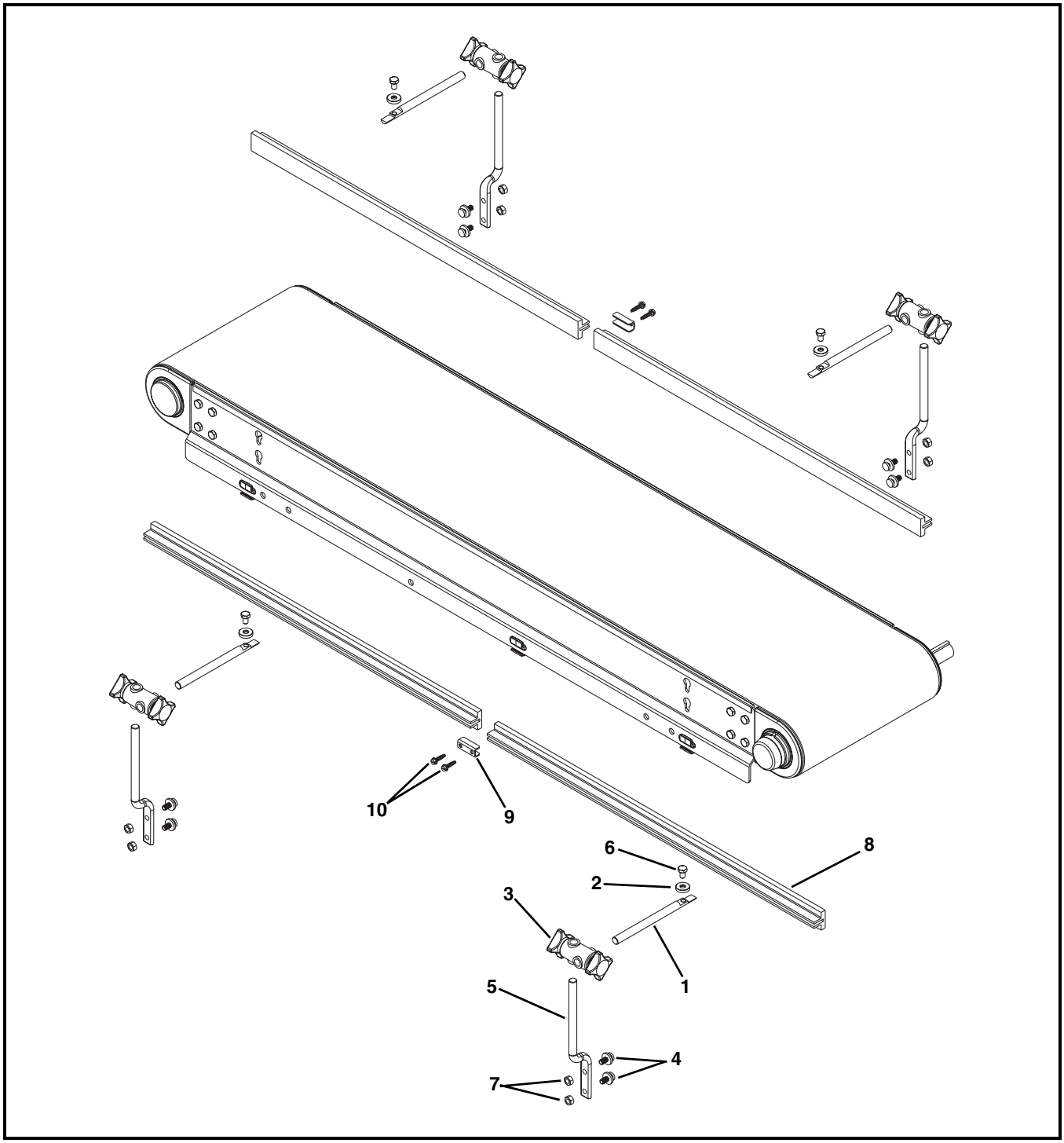
Fully Adjustable 1" (25 mm) Flat Guides



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

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

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

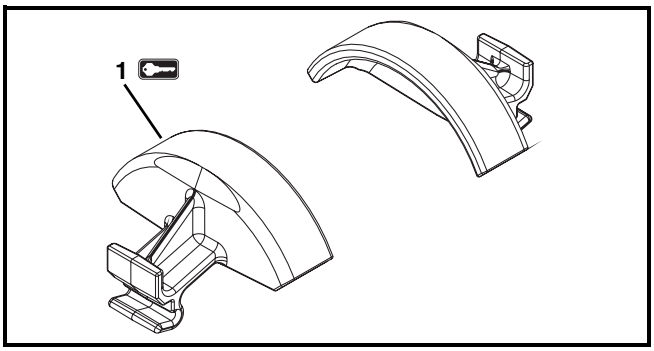


Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1470	Cross Block Clamp
4	532191	Carriage Bolt M8 x 20mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm

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

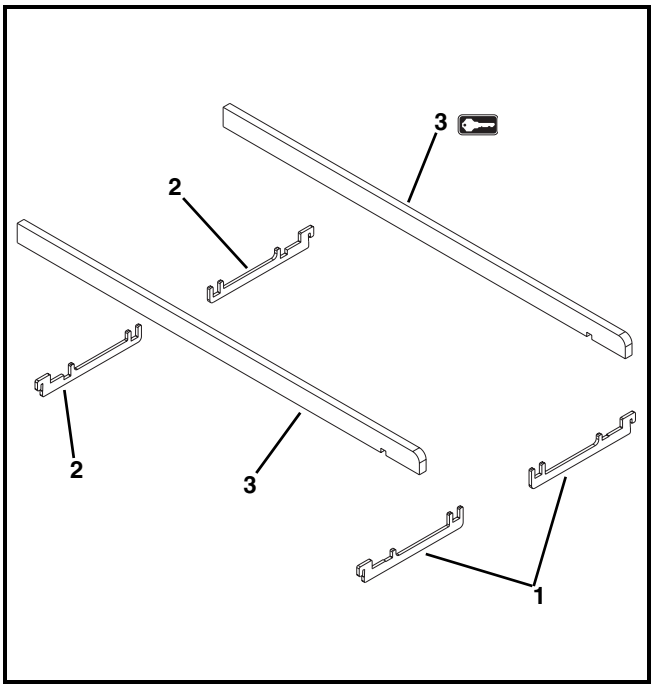
Service Parts

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



Item	Part Number	Description
1	532224	Return Shoe

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



Item	Part Number	Description
1	532154	Front Return Support
2	532153	Return Support
3	532223-LLLLL	Wear Strips
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Ordering a Replacement Chain

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

Example:

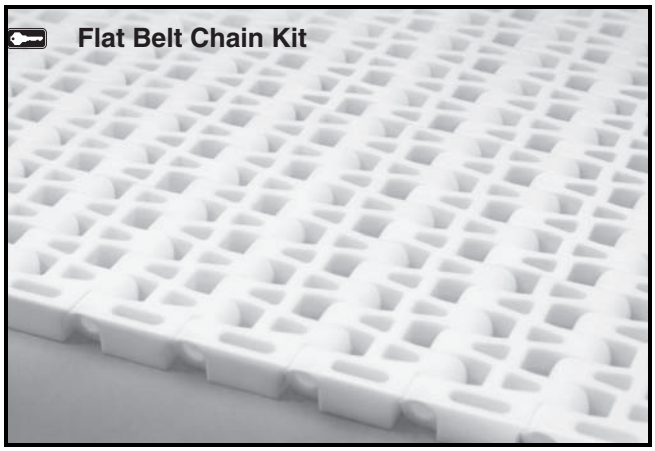
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 52BB-WW

BB = Chain reference number

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

Flat Belt Chain Repair Kit



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

Notes

Return Policy

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

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

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

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

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

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

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Customer Service Teams 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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