7360 Series End Drive Conveyors

Installation, Maintenance and Parts Manual

Straight Conveyor

Z-Frame Conveyor

DORNER MFG. CORP.
P.O. Box 20 • 975 Cottonwood Ave.
Hartland, WI 53029-0020 USA

INSIDE THE USA
TEL: 1-800-397-8664
FAX: 1-800-369-2440

OUTSIDE THE USA
TEL: 262-367-7600
FAX: 262-367-5827

For other service manuals visit our website at:
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851-696 Rev. A

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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 7360 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 (Flat Belt Shown)
4	Support Stands
5	Drive End
6	Idler End

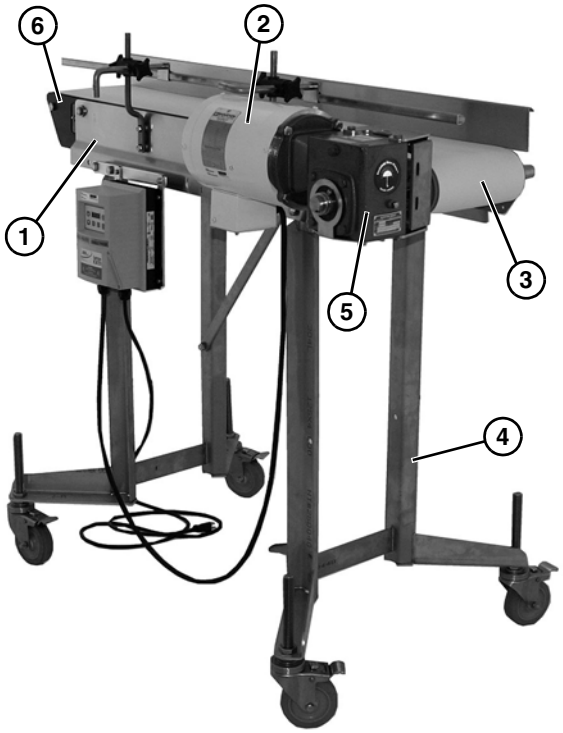
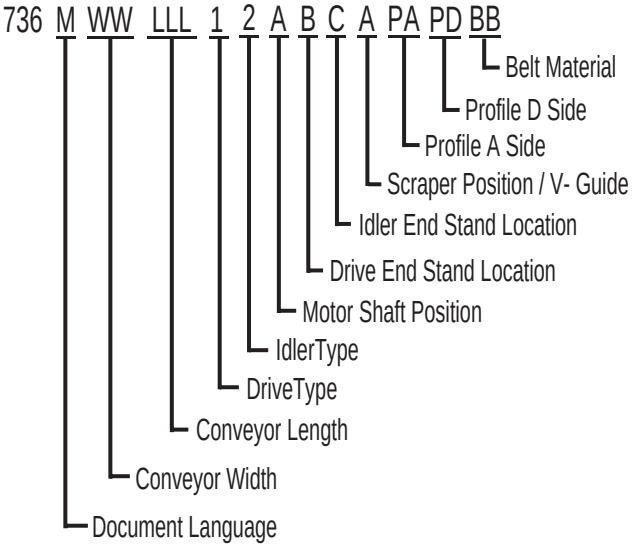
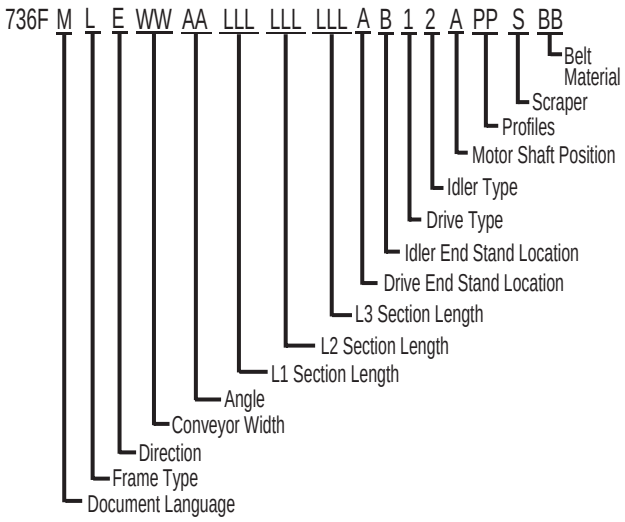


Figure 1

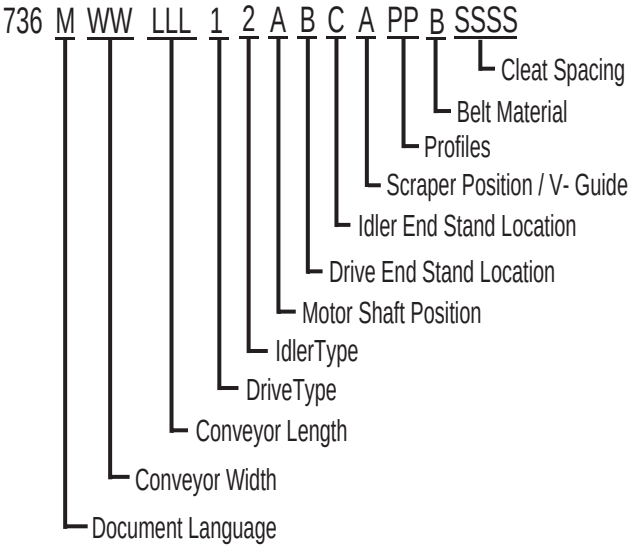
Flat Belt 7360 Series Conveyor



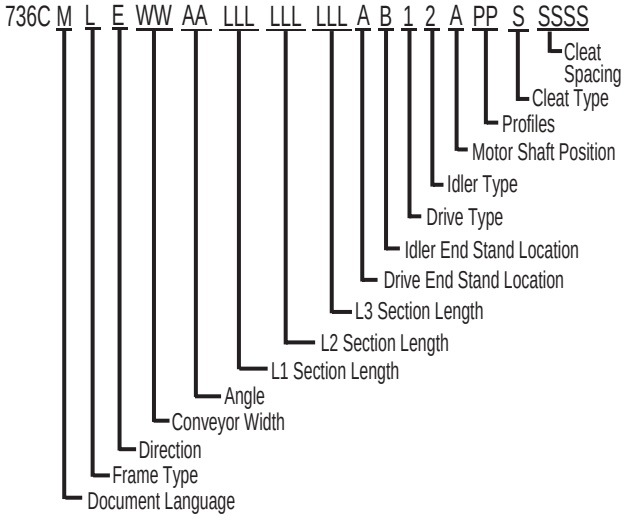
Flat Belt 7360 Series Z-Frame Conveyor



Cleated Belt 7360 Series Conveyor



Cleated Belt 7360 Series Z-Frame Conveyor



Specifications

Conveyor Supports

Maximum Distances:

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

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

3 = Support Stand on Idler End = 30" (762 mm)

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

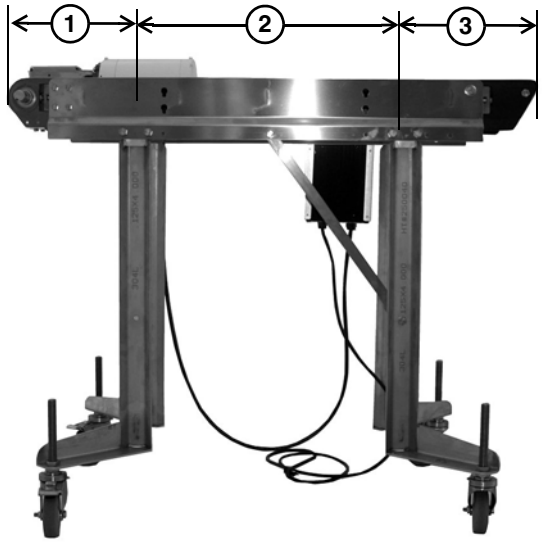


Figure 2

Specifications

Conveyor Width Reference (WW)	04 – 52 in 02 increments
Conveyor Belt Width	4" (102 mm) - 52" (1321 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft^2 (97 kg/ m^2) with a maximum of 500 lbs. (228 kg)
Belt Travel	11" (279 mm) per revolution of pulley
Maximum Belt Speed	300 ft/minute (91 m/minute)

Conveyor Length Reference (LLL)	036 – 480 in 001 increments
Conveyor Length	36" (914 mm) - 480" (12,129 mm) in 1" (25 mm) increments

IMPORTANT

Maximum conveyor loads are based on:

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

CAUTION

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

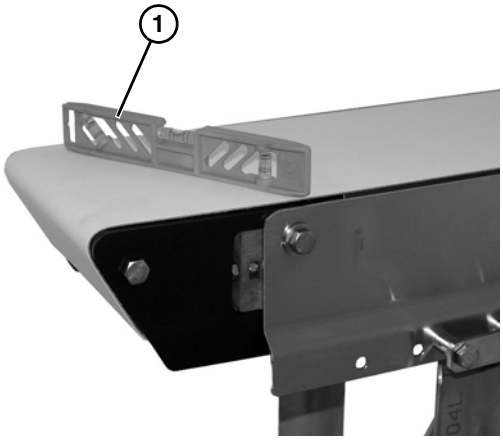


Figure 3

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 8.
3. Install the belt. Refer to “Belt Installation” on page 9.
4. Install belt returns. Refer to “Belt Returns” on page 9.
5. 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

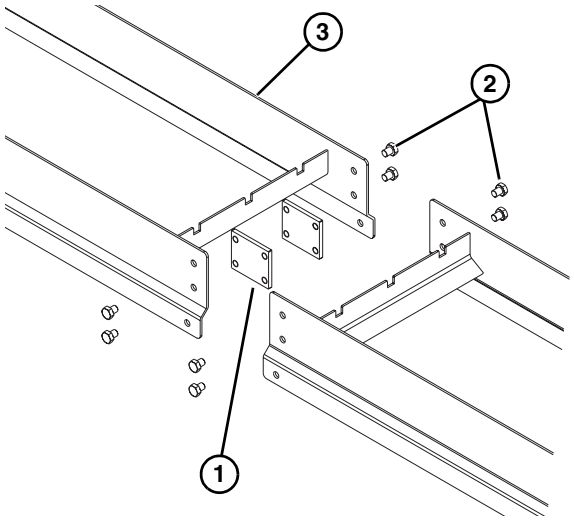


Figure 4

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.

Z-Frame Conveyors

NOTE

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

Knuckles

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

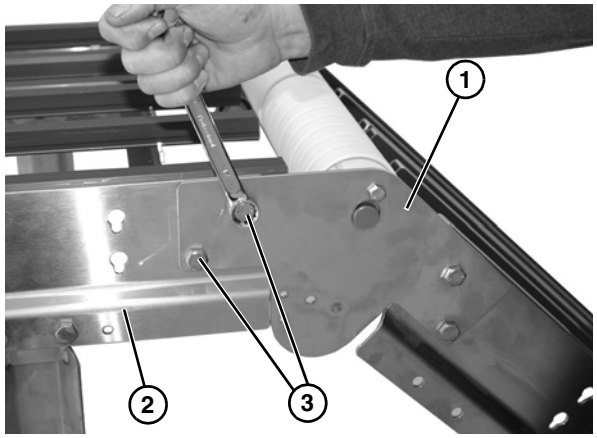


Figure 5

2. Attach lower knuckle **(Figure 6, item 1)** to frame **(Figure 6, item 2)** by using two cap screws **(Figure 6, item 3)** and plate **(Figure 7, item 4)** on each side of lower knuckle assembly.

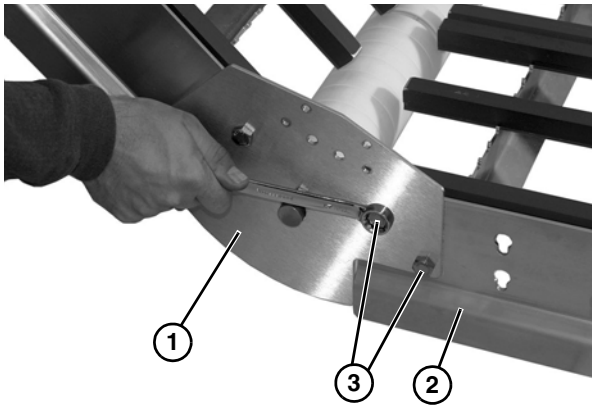


Figure 6

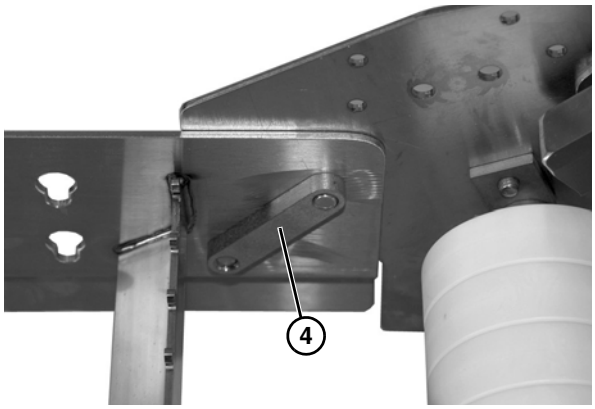


Figure 7

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

All Conveyors

Stand Installation

NOTE
For detailed assembly instructions, please see support stand manual 851-695.

Typical stand components **(Figure 8)**

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

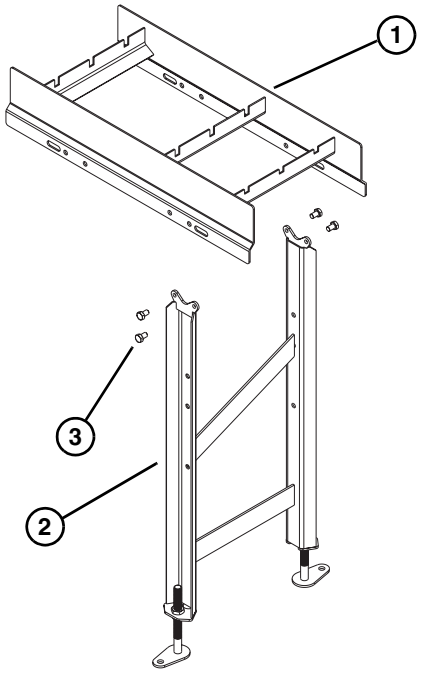


Figure 8

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame with two cap screws **(Figure 9, item 1)**.

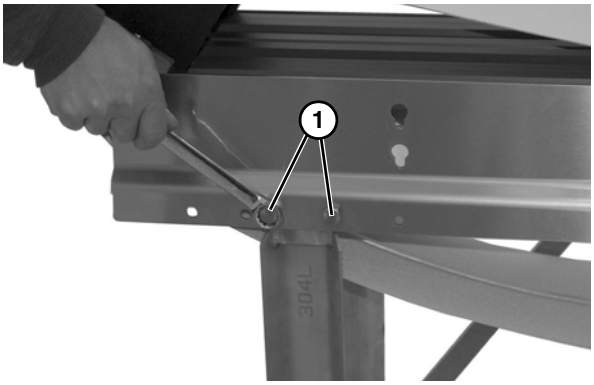


Figure 9

Bed Rail Installation

NOTE
If bed rails fall off during shipping, install as follows.

1. Install two outer bed rails **(Figure 10, item 1)** and inner bed rails **(Figure 10, item 2)**, making certain that bed rails notched area **(Figure 11, item 3)** cradles frame clip **(Figure 11, item 4)**.

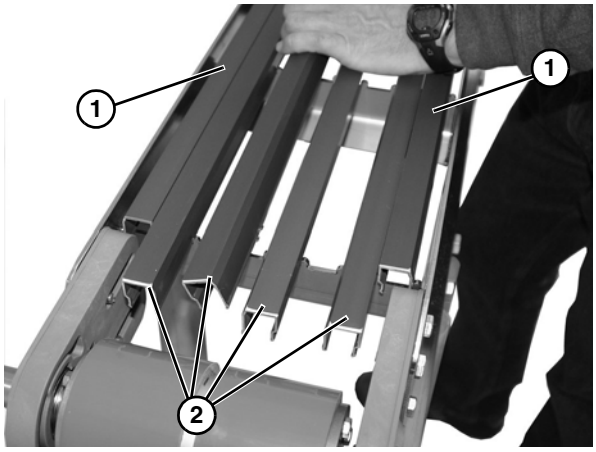


Figure 10

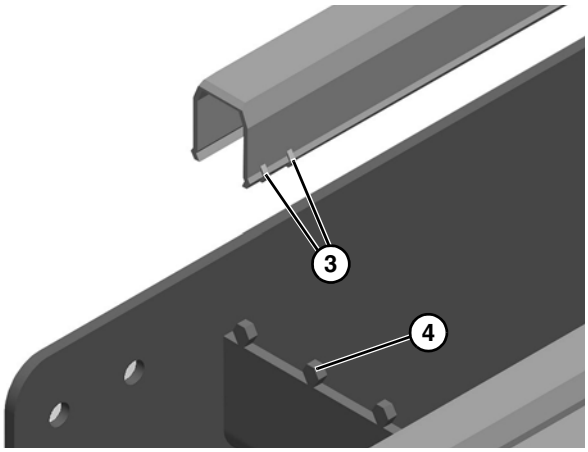


Figure 11

Belt Installation

1. Remove two cap screws **(Figure 12, item 1)** holding stand to conveyor.

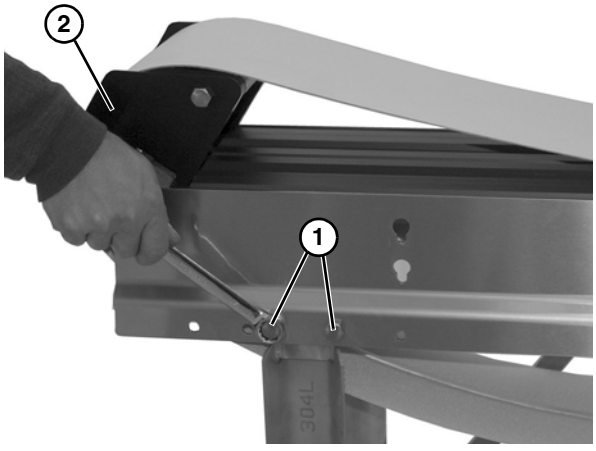


Figure 12

2. Rotate idler end **(Figure 12, item 2)** upward.
3. Position the belt under the stand **(Figure 13, item 1)** on the conveyor **(Figure 13, item 2)**.

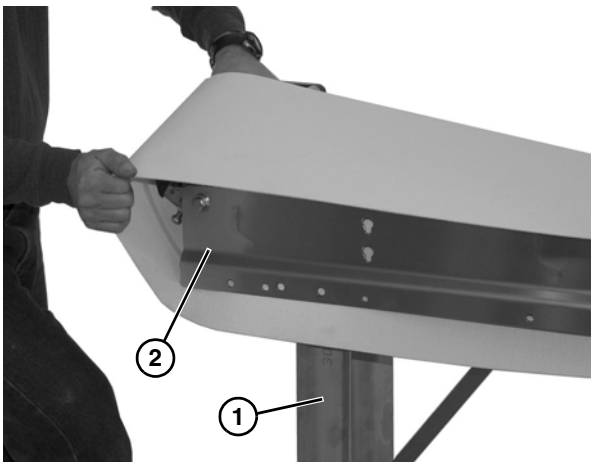


Figure 13

4. Install two cap screws holding conveyor to stand.
5. Repeat procedure for opposite end of conveyor to fully install belt.

Belt Returns

Flat Returns

Typical flat return components **(Figure 14)**

1	Cap Screw, M10-1.50 x 16 mm
2	Return Shaft Bracket
3	Clamp
4	Return Disk
5	Shaft

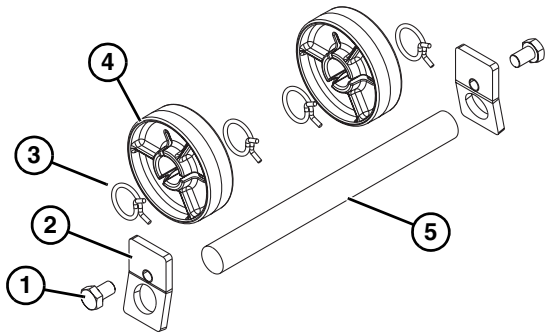


Figure 14

1. Install return disks **(Figure 15, item 1)** onto shaft **(Figure 15, item 2)**, and secure with clamps **(Figure 15, item 3)**.

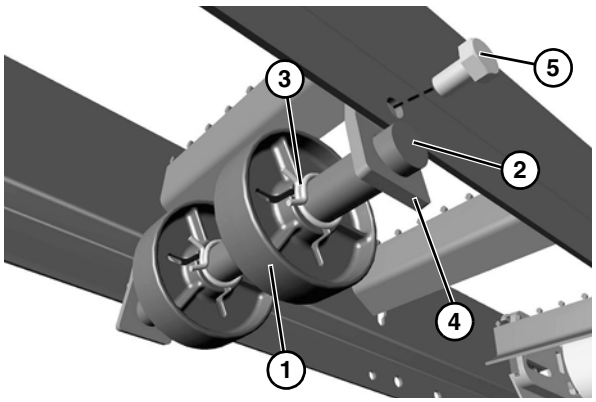


Figure 15

2. Install belt return assembly onto frame with return shaft brackets **(Figure 15, item 4)** and cap screws **(Figure 15, item 5)** on the outside of conveyor.

Cleated Returns

Typical flat return components **(Figure 16)**

1	Cap Screw, M10-1.50 x 16 mm
2	Spacer
3	Return Disk
4	Stub Shaft

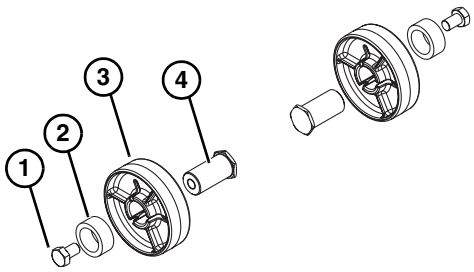


Figure 16

1. Install each return disk **(Figure 17, item 1)** onto conveyor frame with stub shaft **(Figure 17, item 2)**, spacer **(Figure 17, item 3)**, and cap screw **(Figure 17, item 4)**.

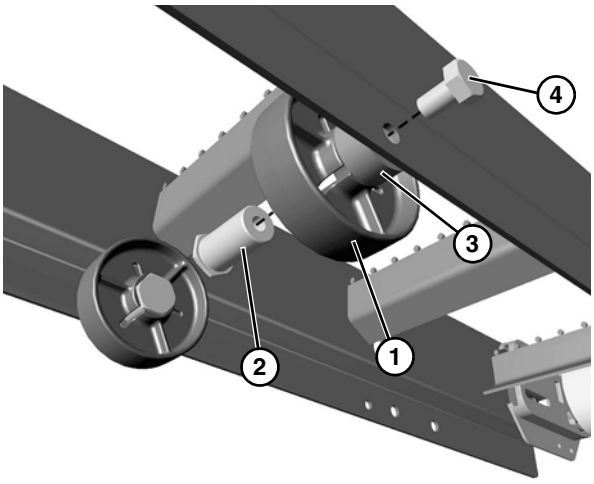


Figure 17

Guide Installation

1. Insert carriage bolts with spacers **(Figure 18, item 1)** into slotted holes in conveyor side.

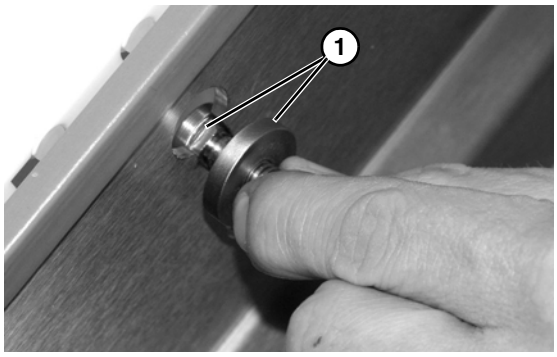


Figure 18

2. Attach the guide mounting brackets **(Figure 19, item 1)** to the conveyor with hex nuts **(Figure 19, item 2)**. Hand tighten only at this time.

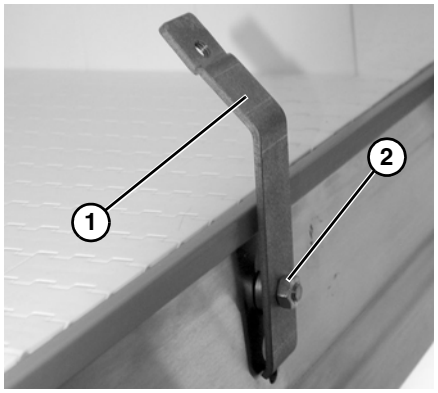


Figure 19

3. Attach guide **(Figure 20, item 1)** to the mounting brackets with hex bolts and spacers **(Figure 20, item 2)**. Hand tighten only at this time.

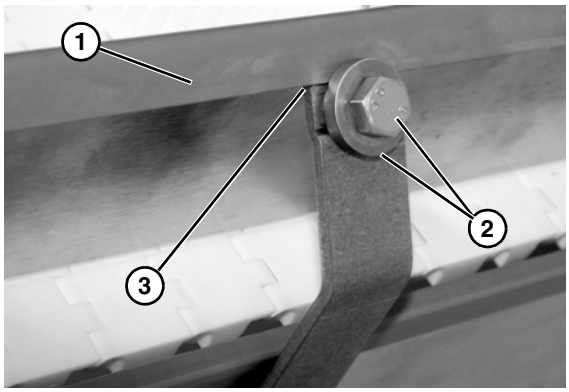


Figure 20

4. Ensure that nose of bracket slips under the lip of guide **(Figure 20, item 3)**.

NOTE
*When installing guides, be sure that the angled end of guide is installed on the idler end of conveyor **(Figure 21, item 1)**.*

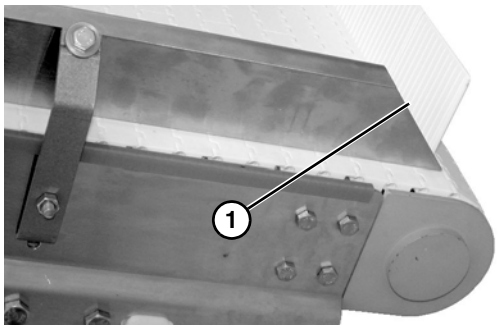


Figure 21

5. Tighten all mounting hardware.

Scraper Installation

Typical Scraper Components **(Figure 22)**

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

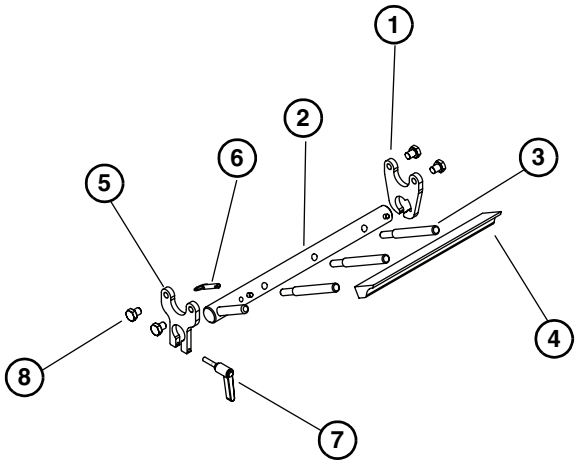


Figure 22

1. Attach the scraper adjust plate **(Figure 22, item 1)** and the scraper mount plate **(Figure 22, item 5)** to the frame using four M10-1.5 x 12mm hex head cap screws.
2. Slide the notched end of the scraper shaft **(Figure 23, item 1)** through the adjustment plate **(Figure 23, item 2)**.

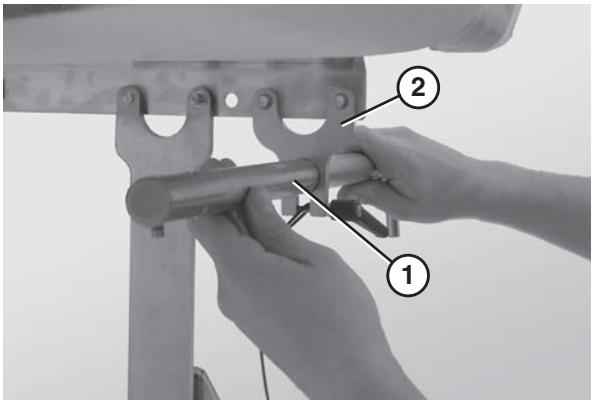


Figure 23

3. Insert the notched end of the scraper shaft **(Figure 24, item 1)** so that it is situated within the groove in the mounting plate **(Figure 24, item 2)**.

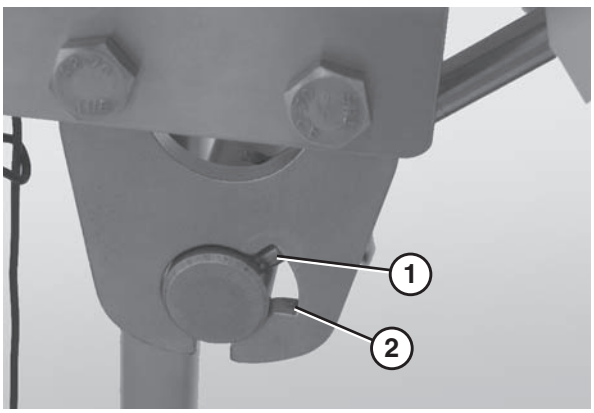


Figure 24

4. Attach the scraper bar holders **(Figure 25, item 1)** to the scraper shaft **(Figure 25, item 2)**.

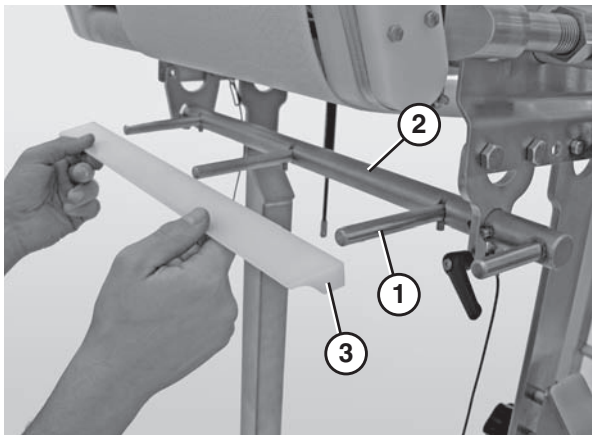


Figure 25

5. Attach the UWHM scraper **(Figure 25, item 3)** to the scraper bar holders **(Figure 25, item 1)**.
6. Insert the pin **(Figure 26, item 1)** to lock the scraper bar in place **(Figure 26, item 2)**.

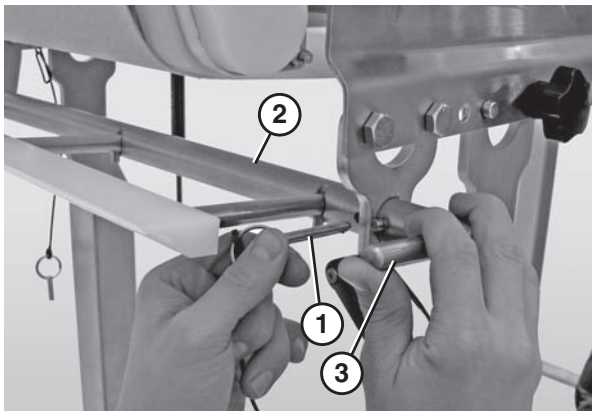


Figure 26

7. Adjust the scraper to the desired position using the scraper bar handle **(Figure 26, item 3)**.

CAUTION

Apply minimal pressure between the scraper (Figure 27, item 1) and the belt (Figure 27, item 2).

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

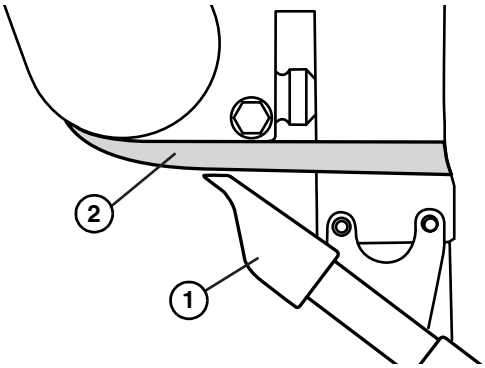


Figure 27

8. Secure the scraper by tightening the handle **(Figure 28, item 1)**.

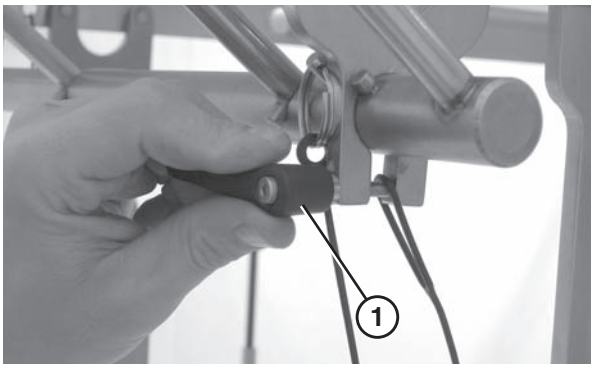


Figure 28

Drive Package Installation

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

- 851-679 Side Mount 90° Drive Package
- 851-681 Bottom Mount 90° Drive Package
- 851-682 Bottom Mount Parallel Shaft Drive Package

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

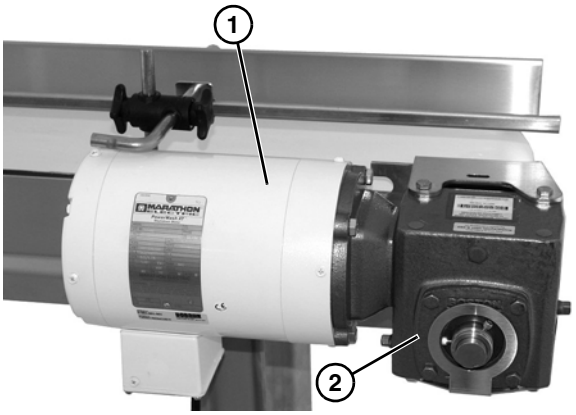


Figure 29

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 22 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

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

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

Skipping indicates:

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

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.

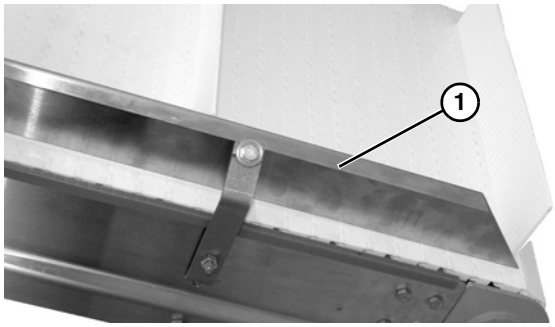


Figure 30

2. Remove belt returns.
3. Rotate idler tail end **(Figure 31, item 1)** of conveyor upward as shown.

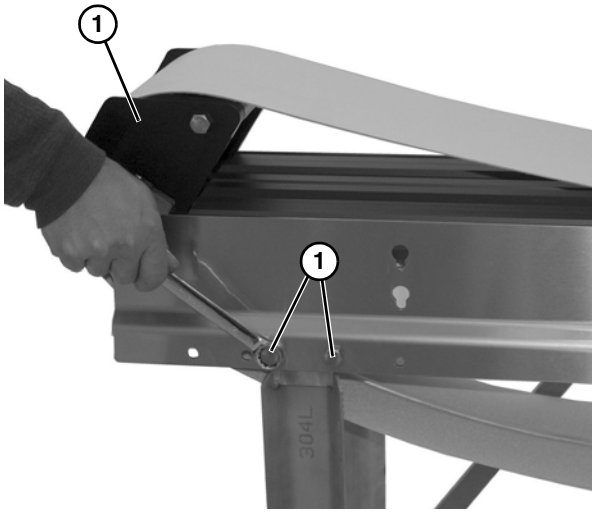


Figure 31

4. Remove two cap screws **(Figure 31, item 2)** holding stand to conveyor.
5. Repeat procedure for opposite end of conveyor.
6. Remove the belt from under the stand **(Figure 32, item 1)** and from the conveyor **(Figure 32, item 2)** on both ends.

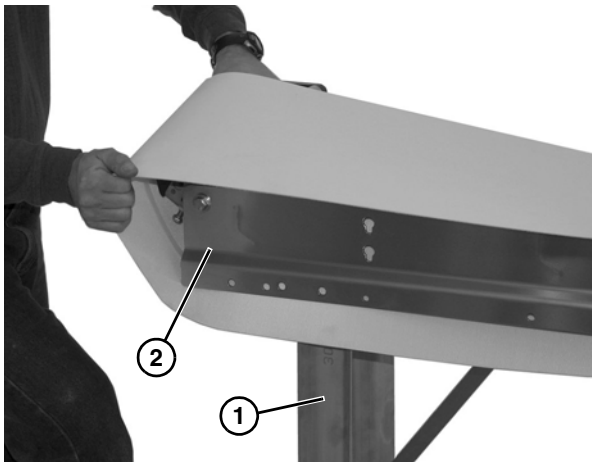


Figure 32

NOTE

*If conveyor belt is not easily removable, removing the outer bed rails **(Figure 33, item 1)** will allow the idler tail end to rotate further and allow the belt to be removed.*

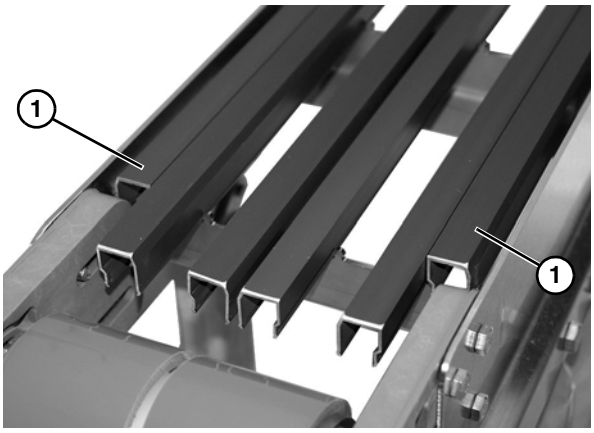


Figure 33

7. Replace the old belt with a new one. Refer to "Belt Installation" on page 9.

Conveyor Belt Tensioning

⚠ WARNING

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

CAUTION

Over-tensioning of conveyor may stretch conveyor belt and reduce bearing life.

1. Tighten bolts **(Figure 34, item 1)** on each side to take up tension. Align the same arrows **(Figure 34, item 2)** and marks **(Figure 34, item 3)** on each side of the conveyor to keep the tail straight.

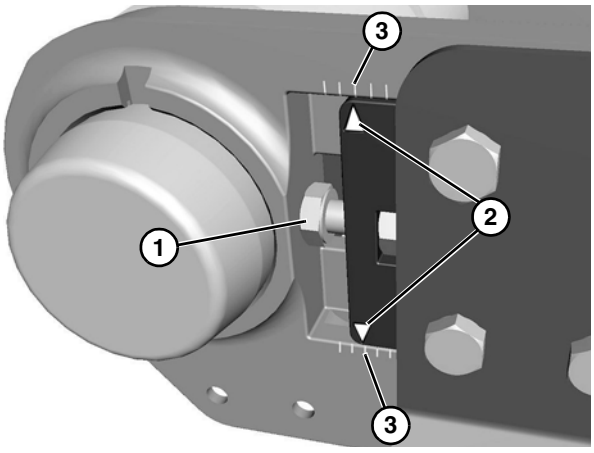


Figure 34

Conveyor Belt Tracking

1. Tighten or loosen bolts **(Figure 35, item 1)** on each side to correct tracking. (Align the same arrows **(Figure 35, item 2)** and marks **(Figure 35, item 3)** on each side of the conveyor as a starting point for tracking the belt.)

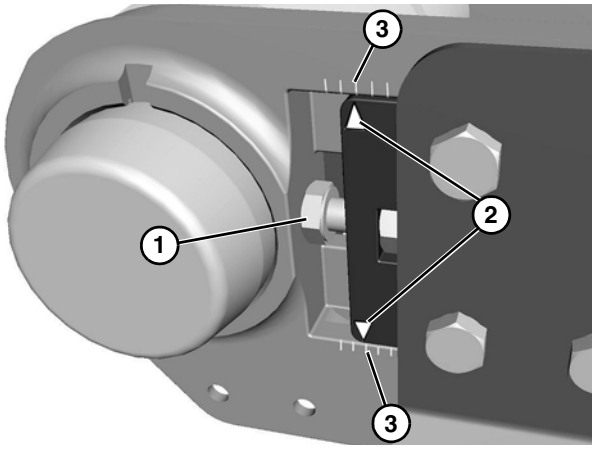


Figure 35

Bed Rails

Replace the bed rails if they become worn.

Refer to “Bed Rail Installation” on page 8 for bed rail replacement.

Scraper

Replace the UHMW scraper if it becomes worn.

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

Drive Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Remove conveyor belt. See “Conveyor Belt Replacement” on page 13.
3. Loosen the four head plate bolts **(Figure 36, item 1)** so that bolts **(Figure 37, item 1)** are flush with drive tail blocks **(Figure 37, item 2)**. Repeat on opposite side of the conveyor.

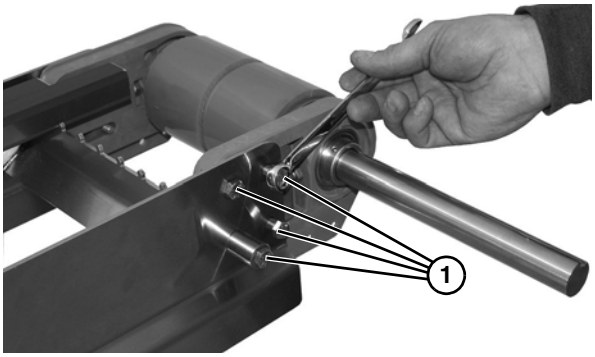


Figure 36

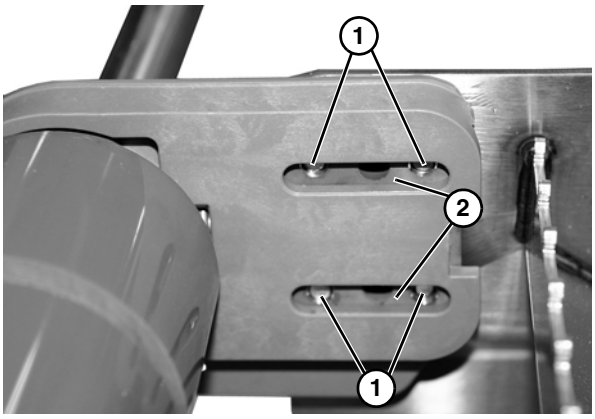


Figure 37

4. Slide the drive spindle assembly **(Figure 38, item 1)** off the drive tail blocks **(Figure 38, item 2)**.

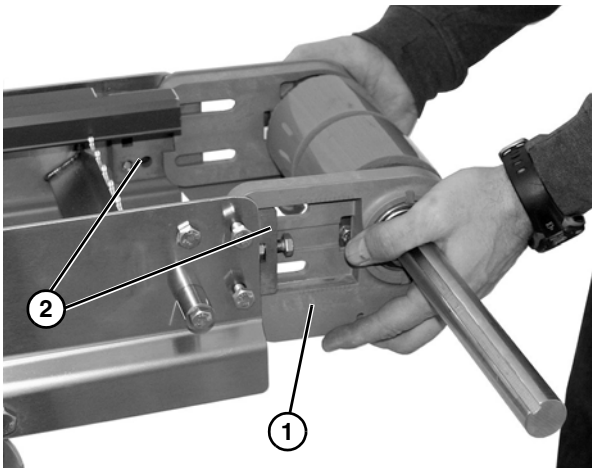


Figure 38

5. Loosen two set screws **(Figure 39, item 1)**.

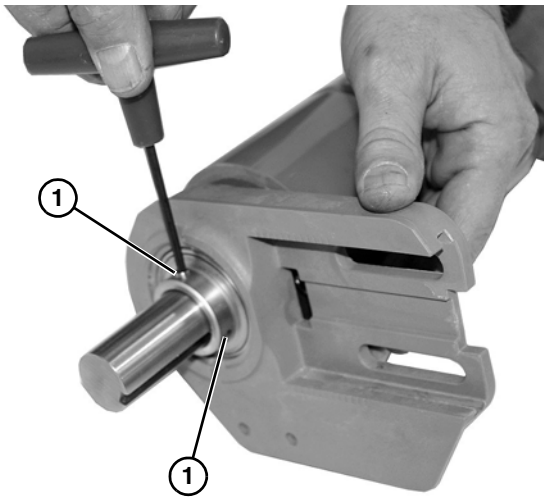


Figure 39

6. Slide the head plate with bearing **(Figure 40, item 1)** off the shaft **(Figure 40, item 2)**.

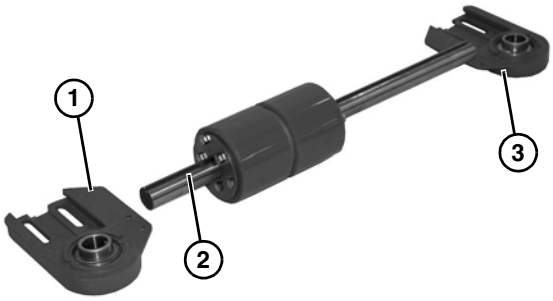


Figure 40

7. Repeat for opposite side head plate **(Figure 40, item 3)**.
8. If necessary, see “Bearing Replacement” on page 18 for replacing bearing in each head plate.
9. Install components in reverse order of removal.

Idler Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

1. Remove conveyor belt. See “Conveyor Belt Replacement” on page 13.
2. Loosen the head plate bolt **(Figure 41, item 1)** so that bolt **(Figure 42, item 1)** is flush with pivot tail block **(Figure 42, item 2)**. Repeat on opposite side of the conveyor.

Figure 41

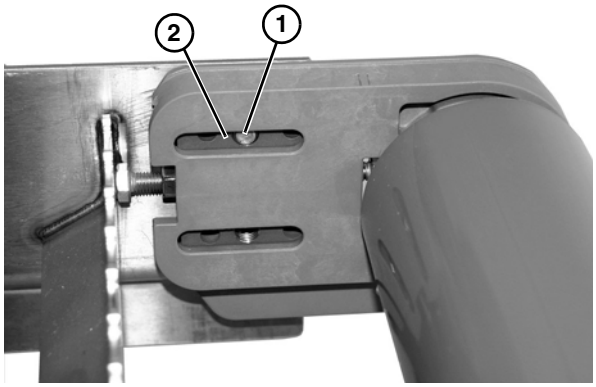


Figure 42

3. Slide the idler spindle assembly **(Figure 43, item 1)** off the pivot tail blocks **(Figure 43, item 2)**.

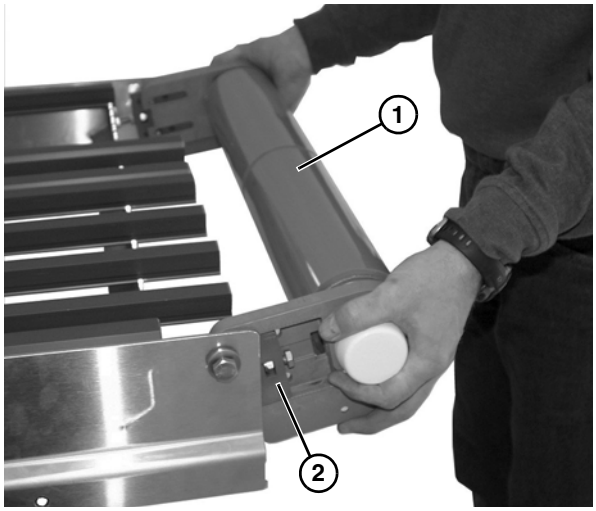


Figure 43

4. Remove the bearing cover **(Figure 44, item 1)**. Repeat on opposite side.

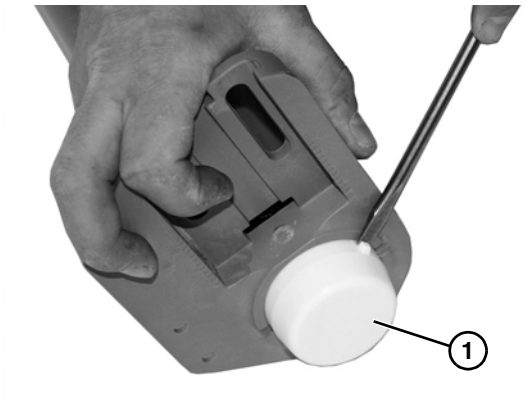


Figure 44

5. Loosen two set screws **(Figure 45, item 1)**.

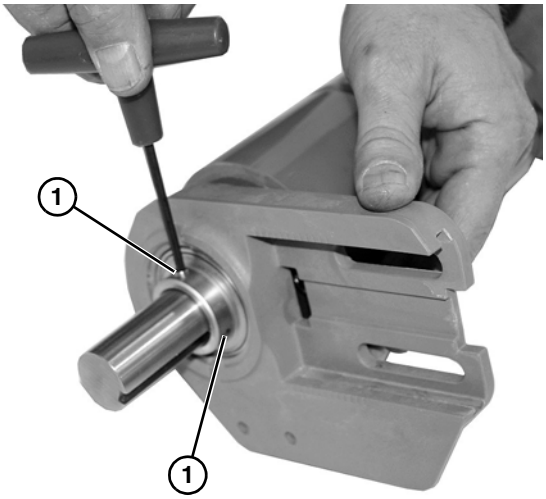


Figure 45

6. Slide the head plate with bearing **(Figure 46, item 1)** off the shaft **(Figure 46, item 2)**.

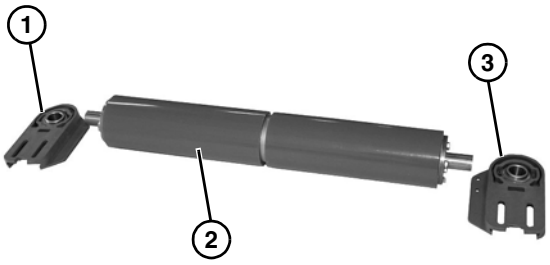


Figure 46

7. Repeat for opposite side head plate **(Figure 46, item 3)**.
8. If necessary, see “Bearing Replacement” on page 18 for replacing bearing in each head plate.
9. Install components in reverse order of removal.
10. Check level of head plate by placing a bed rail **(Figure 47, item 1)** onto top of conveyor frame and head plate.

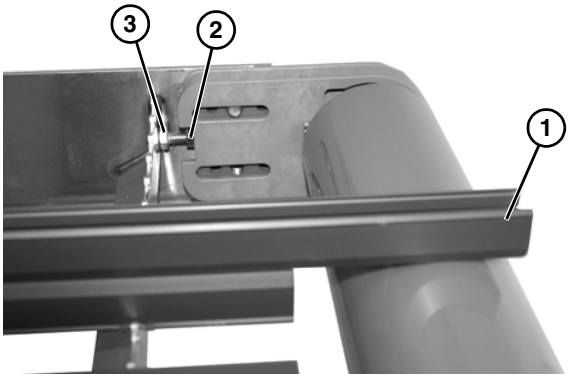


Figure 47

11. Loosen nut **(Figure 47, item 2)** and tighten or loosen bolt **(Figure 47, item 3)** to move head plate up or down to level with conveyor bed rail.

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. Remove conveyor belt. See “Conveyor Belt Replacement” on page 13.
2. Slide the nose bar idler **(Figure 48, item 1)** off the pivot tail blocks **(Figure 48, item 2)**.

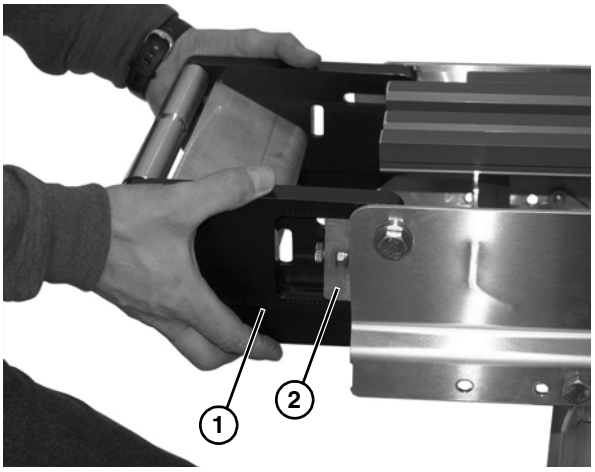


Figure 48

3. Remove head plate bolt **(Figure 49, item 1)** from each side.

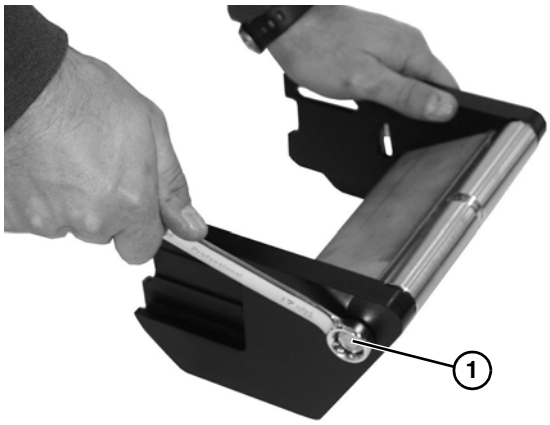


Figure 49

4. Slide off end plate **(Figure 50, item 1)**.

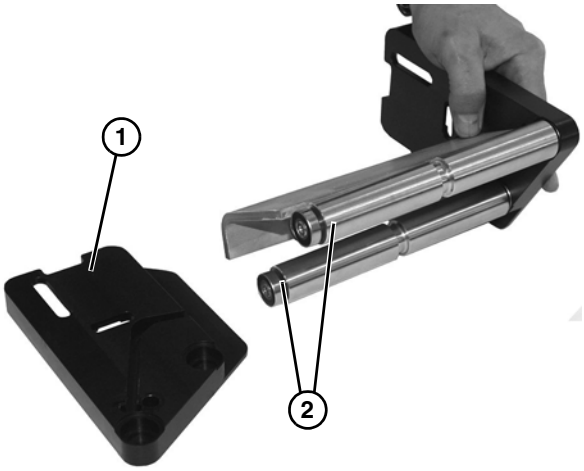


Figure 50

5. Remove idler roller bearing assemblies **(Figure 50, item 2)** from each end plate.

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 Spindle Replacement” on page 15. Follow steps 1 through 7.
2. Turn bearing **(Figure 51, item 1)** to align with slots **(Figure 51, item 2)** in bearing housing. Then remove bearing.

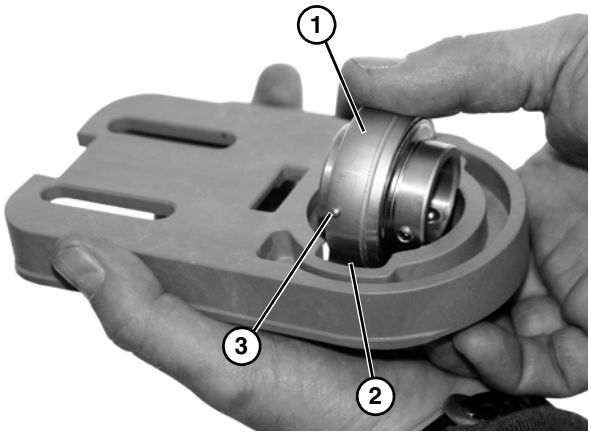


Figure 51

3. Inspect bearing housing bearing surface. If worn or damaged, replace. See “Service Parts” on page 22.
4. Insert bearing **(Figure 51, item 1)** into housing slot: Locate anti-rotation nub **(Figure 51, item 3)** to align with slot **(Figure 51, item 2)**, and twist bearing into housing.

Idler Bearing Removal and Replacement

1. See “Nose Bar Idler Spindle Replacement” on page 17. Follow steps 1 through 6.
2. Using a bearing removal tool **(Figure 52, item 1)** remove the bearing **(Figure 52, item 2)**.

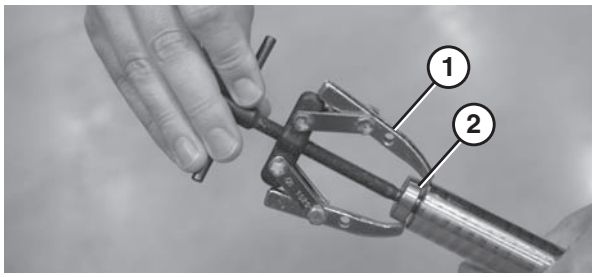


Figure 52

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 two cap screws **(Figure 53, item 1)** on side of lower knuckle assembly **(Figure 53, item 2)**, and remove hold down guide **(Figure 53, item 3)**. Repeat for second hold down guide **(Figure 53, item 4)**. Repeat on opposite side.

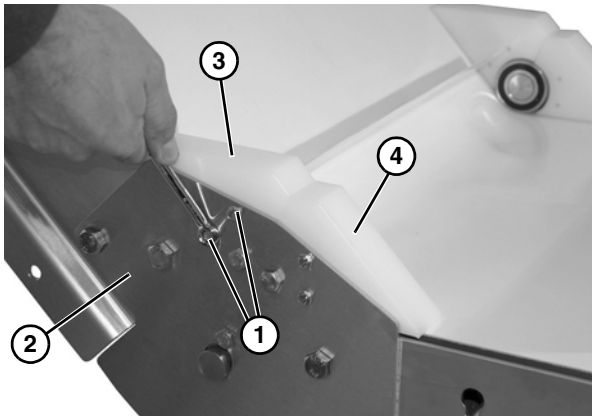


Figure 53

2. Remove two cap screws **(Figure 54, item 1)** for bearing assembly **(Figure 54, item 2)** on side of lower knuckle assembly.

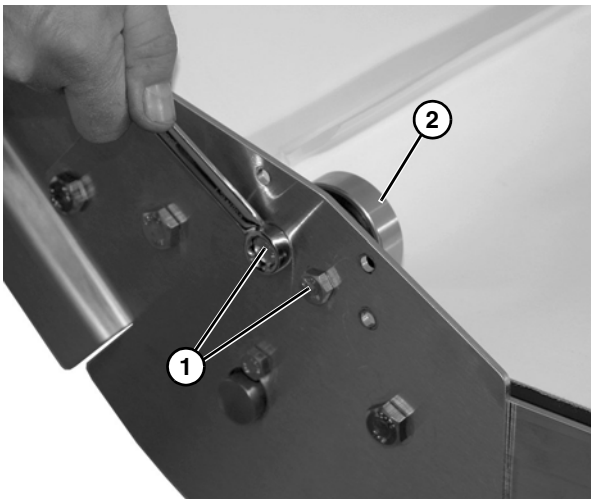


Figure 54

3. Remove belt. See “Conveyor Belt Replacement” on page 13.
4. Remove cap screw **(Figure 55, item 1)** for lower knuckle shaft assembly **(Figure 55, item 2)**.

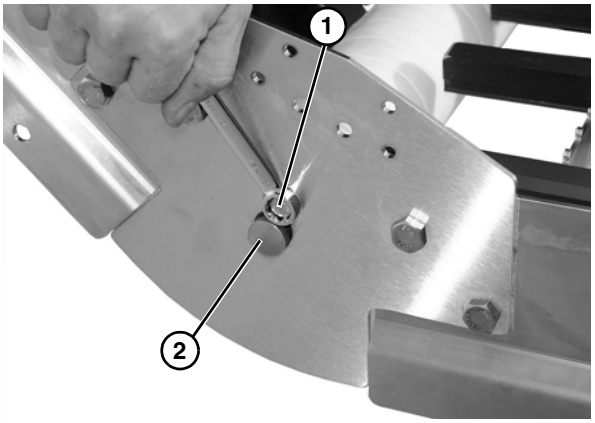


Figure 55

5. Remove lower knuckle shaft assembly retainer **(Figure 56, item 1)**.

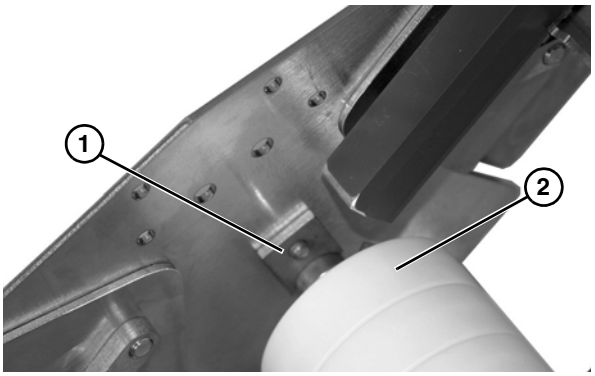


Figure 56

6. Remove shaft and roller assembly **(Figure 56, item 2)**.

7. Remove spacer **(Figure 57, item 1)**, rollers **(Figure 57, item 2)** and tube spacers **(Figure 57, item 3)** from shaft.

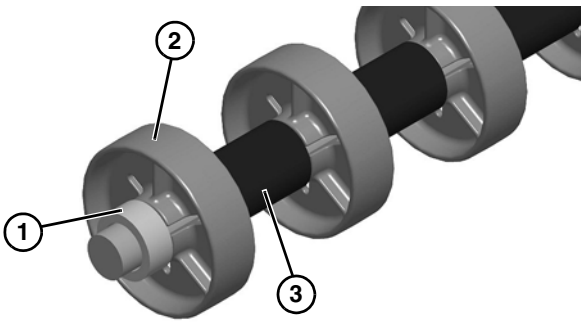


Figure 57

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

Upper Knuckle

1. Remove two flat head screws **(Figure 58, item 1)**, on upper knuckle assembly, and remove roller guide **(Figure 58, item 2)**. Repeat on opposite side.

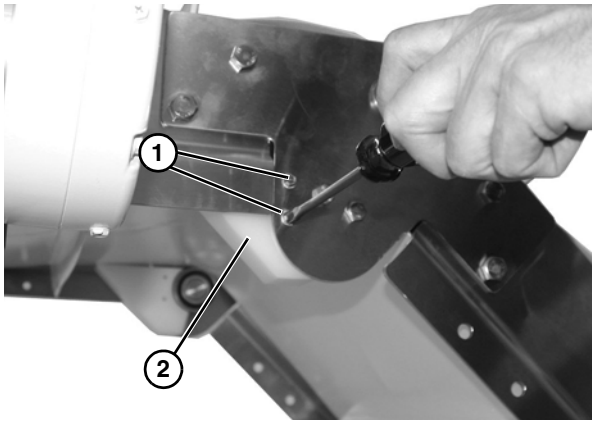


Figure 58

2. Remove two cap screws **(Figure 59, item 1)** and bearing assembly on side of lower knuckle assembly.

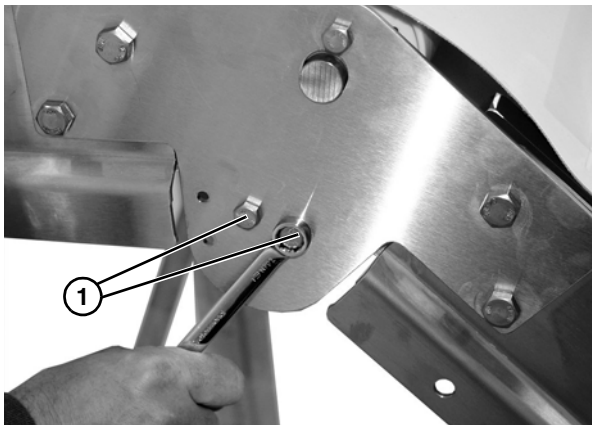


Figure 59

3. Remove belt. See “Conveyor Belt Replacement” on page 13.
4. Remove cap screw **(Figure 60, item 1)** for upper knuckle shaft assembly **(Figure 60, item 2)**.

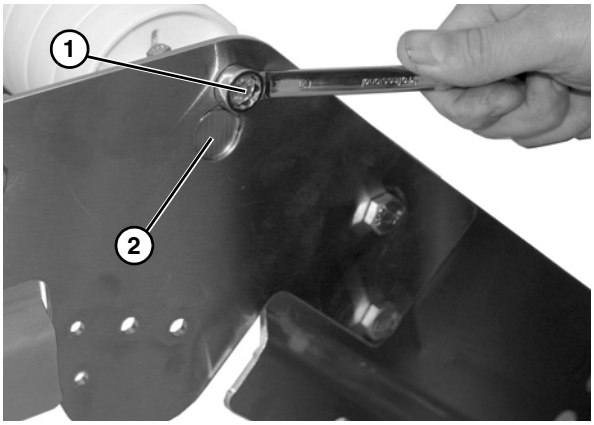


Figure 60

5. Remove upper knuckle shaft assembly retainer **(Figure 61, item 1)**.

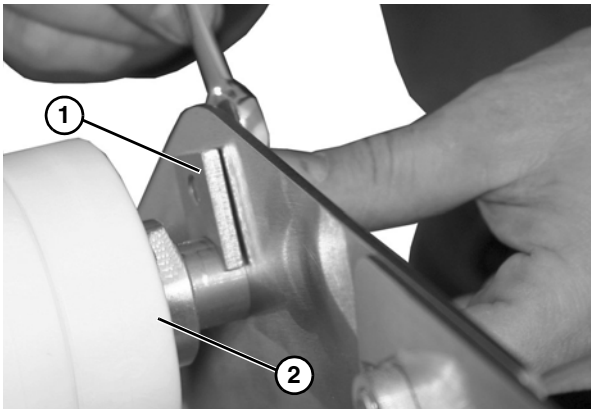


Figure 61

6. Remove shaft and roller assembly **(Figure 61, item 2)**.
7. Remove spacer **(Figure 62, item 1)**, rollers **(Figure 62, item 2)** and tube spacers **(Figure 62, item 3)** from shaft.

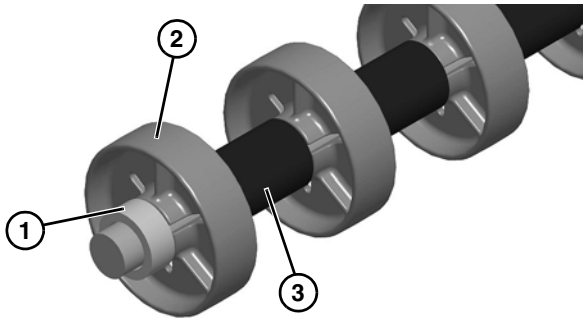


Figure 62

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

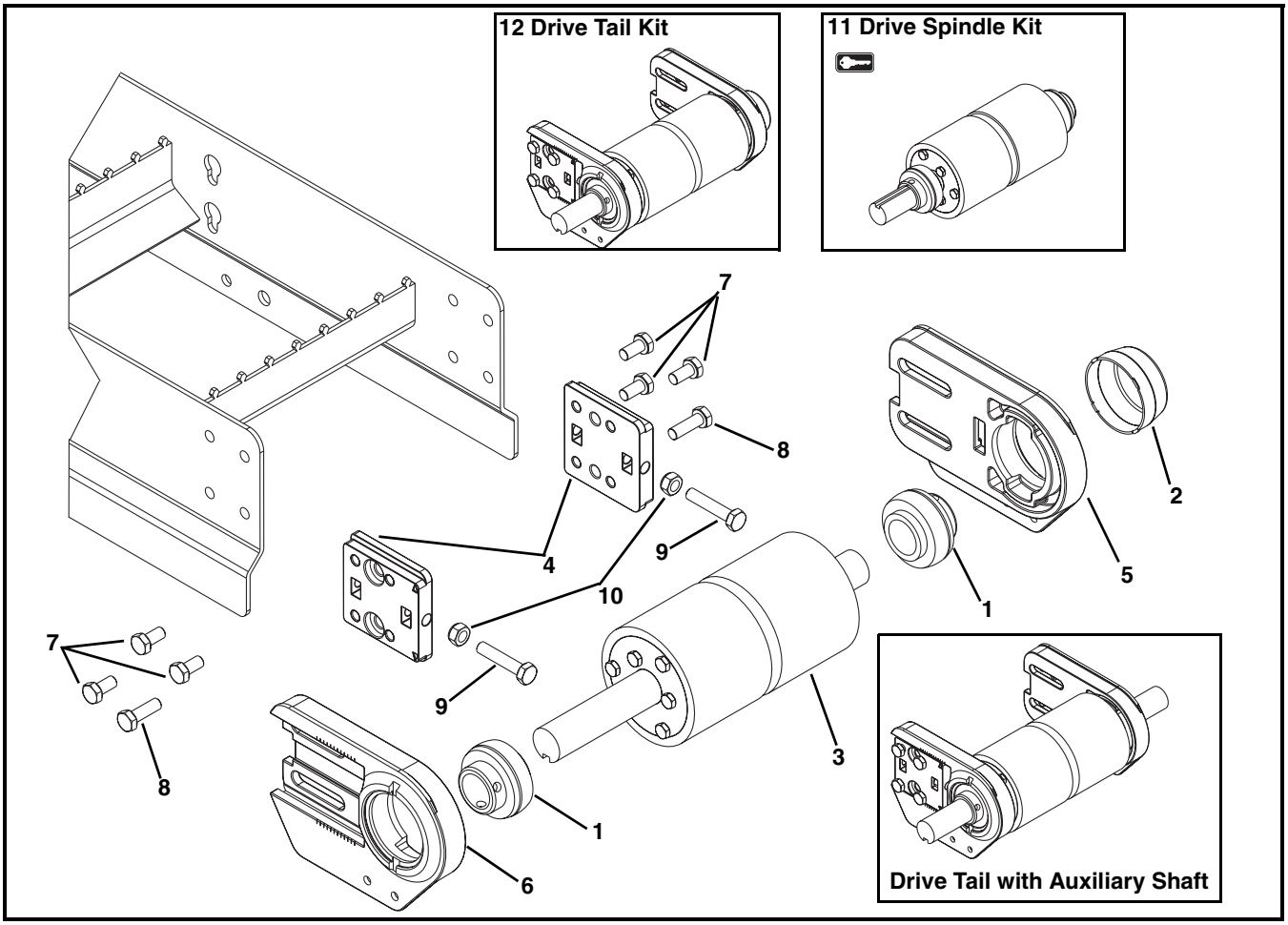
NOTES

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.

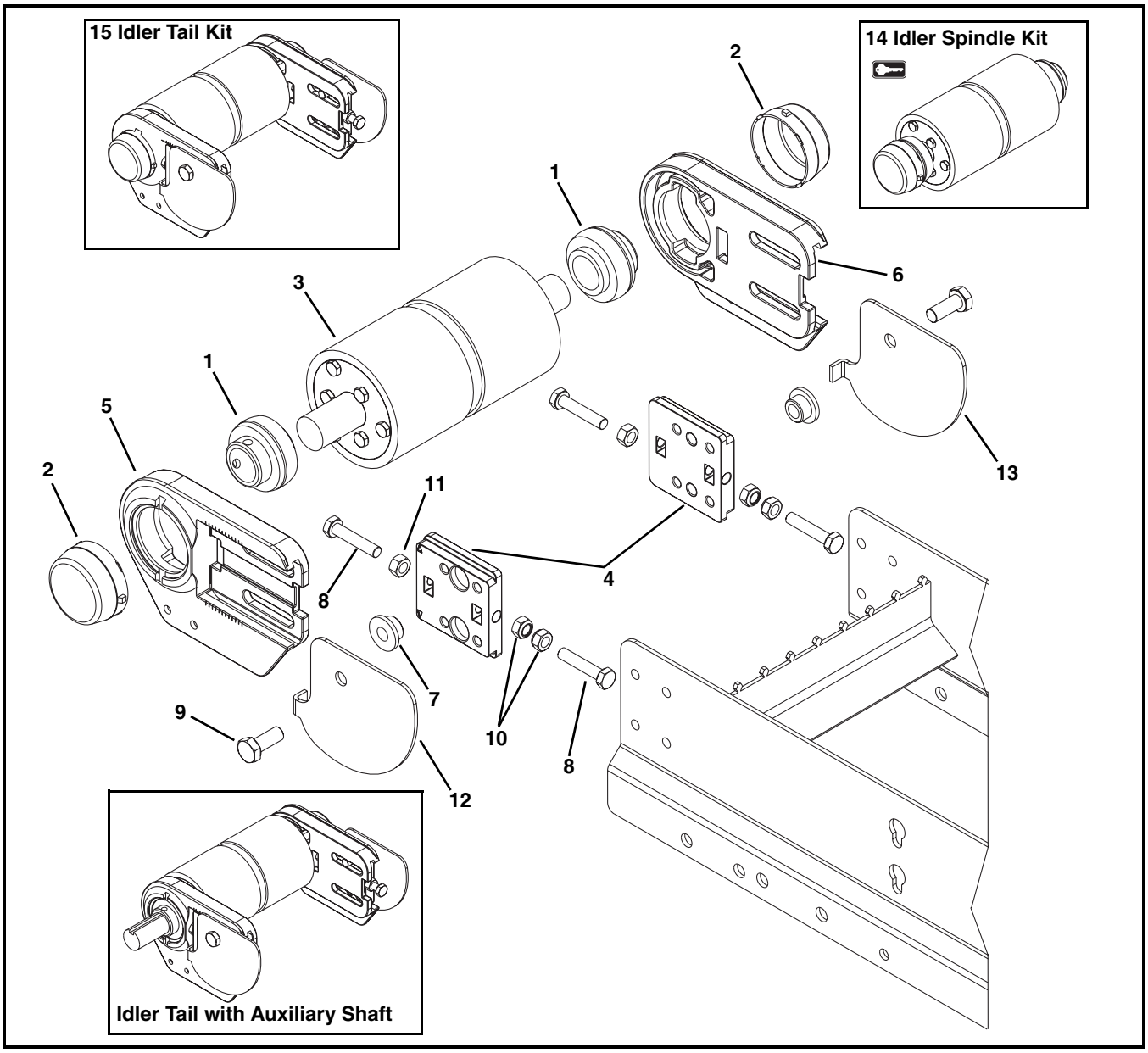
Drive End Components



Item	Part Number	Description
1	802-161	Bearing
2*	807-1454	Bearing Cap
3	532084-WW	Side Drive Spindle Assembly
	532085-WW	Side Drive with Auxiliary Shaft Spindle Assembly
	532086-WW	Bottom Drive Spindle Assembly
	532087-WW	Bottom Drive with Auxiliary Shaft Spindle Assembly
4	532294	Drive Tail Block
5	532298	Headplate for A and C Position
6	532299	Headplate for B and D Position
7	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
8	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
10	990802MSS	Hex Nut, M8-1.25

Item	Part Number	Description
11	736DSS-WW	Drive Spindle Kit for Side Drive (Includes Items 1 and 3)
	736DSSA-WW	Drive Spindle Kit for Side Drive with Auxiliary Shaft (Includes Items 1 and 3)
	736DSB-WW	Drive Spindle Kit for Bottom Drive (Includes Items 1 and 3)
	736DSBA-WW	Drive Spindle Kit for Bottom Drive with Auxiliary Shaft (Includes Items 1 and 3)
12	736DKS-WW	Drive Tail Kit for Side Drive (Includes Items 1 through 10)
	736DKSA-WW	Drive Tail Kit for Side Drive with Auxiliary Shaft (Includes Items 1 through 10)
	736DKB-WW	Drive Tail Kit for Bottom Drive (Includes Items 1 through 10)
	736DKBA-WW	Drive Tail Kit for Bottom Drive with Auxiliary Shaft (Includes Items 1 through 10)
WW = Conveyor width reference: 04 – 52 in 02 increments		
* Not available with double output shafts		

Idler End Components

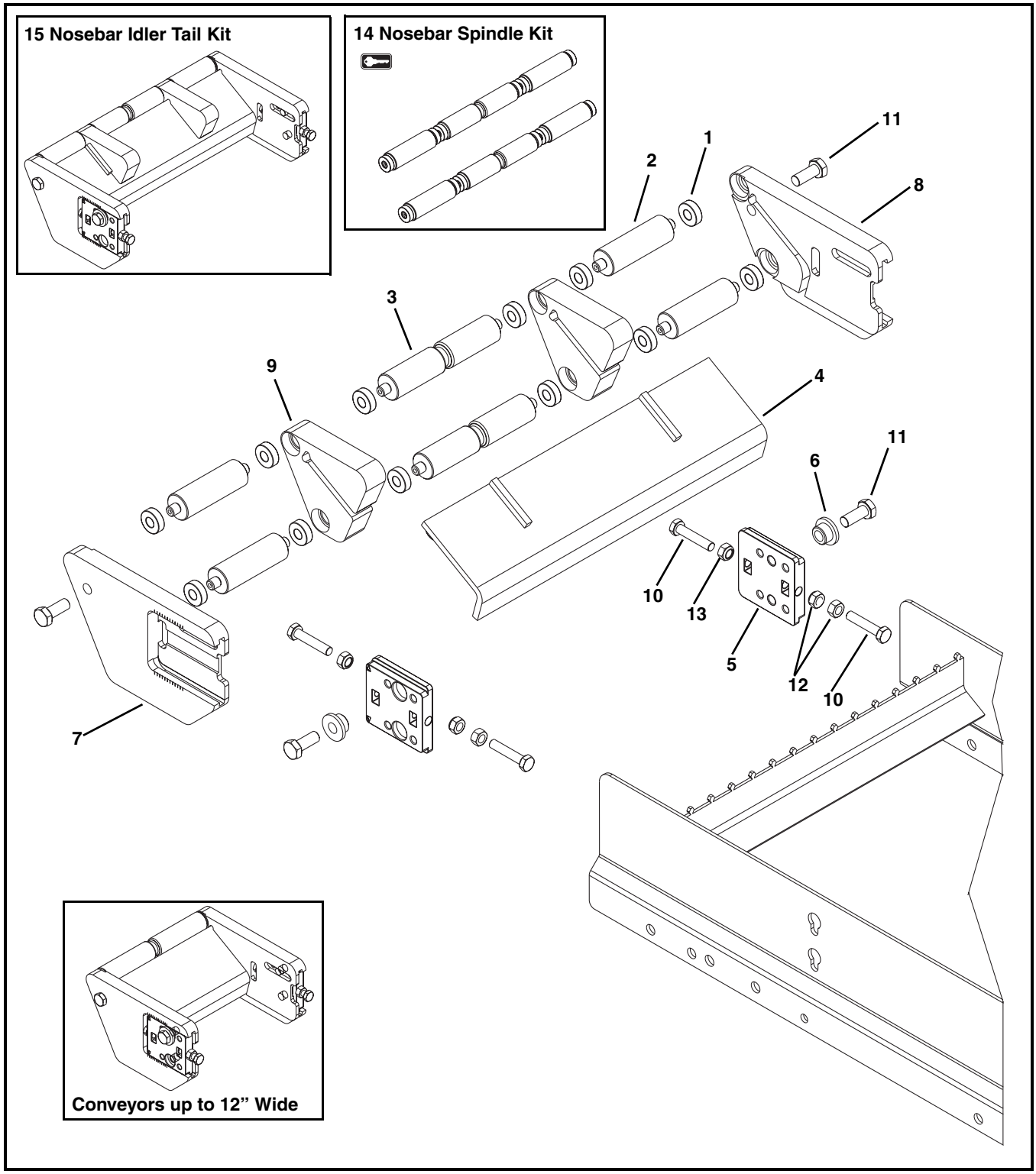


Item	Part Number	Description
1	802-161	Bearing
2	807-1454	Bearing Cover
3	532090-WW	Spindle Assembly
	532091-WW	Spindle Assembly with Auxiliary Shaft
4	532295	Pivot Tail Block
5	532298	Headplate for A and C Position
6	532299	Headplate for B and D Position
7	532346	Pivot Bushing
8	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
9	961030MSS	Hex Head Cap Screw, M10-1.50 x 30 mm
10	990801MSS	Hex Nut, M8-1.25

Item	Part Number	Description
11	990802MSS	Hex Nut, M8-1.25
12	532393	Pinch Guard, for Tip Up Tail A and C Position
13	532394	Pinch Guard, for Tip Up Tail B and D Position
14	736TS3-WW	Idler Spindle Kit (Includes Items 1 through 3)
	736TS3A-WW	Idler Spindle with Auxiliary Shaft Kit (Includes Items 1 through 3)
15	736TK3-WW	Idler Tail Kit (Includes Items 1 through 13)
	736TK3A-WW	Idler Tail with Auxiliary Shaft Kit (Includes Items 1 through 13)
WW = Conveyor width reference: 04 – 52 in 02 increments		

Service Parts

Nose Bar Idler End Components



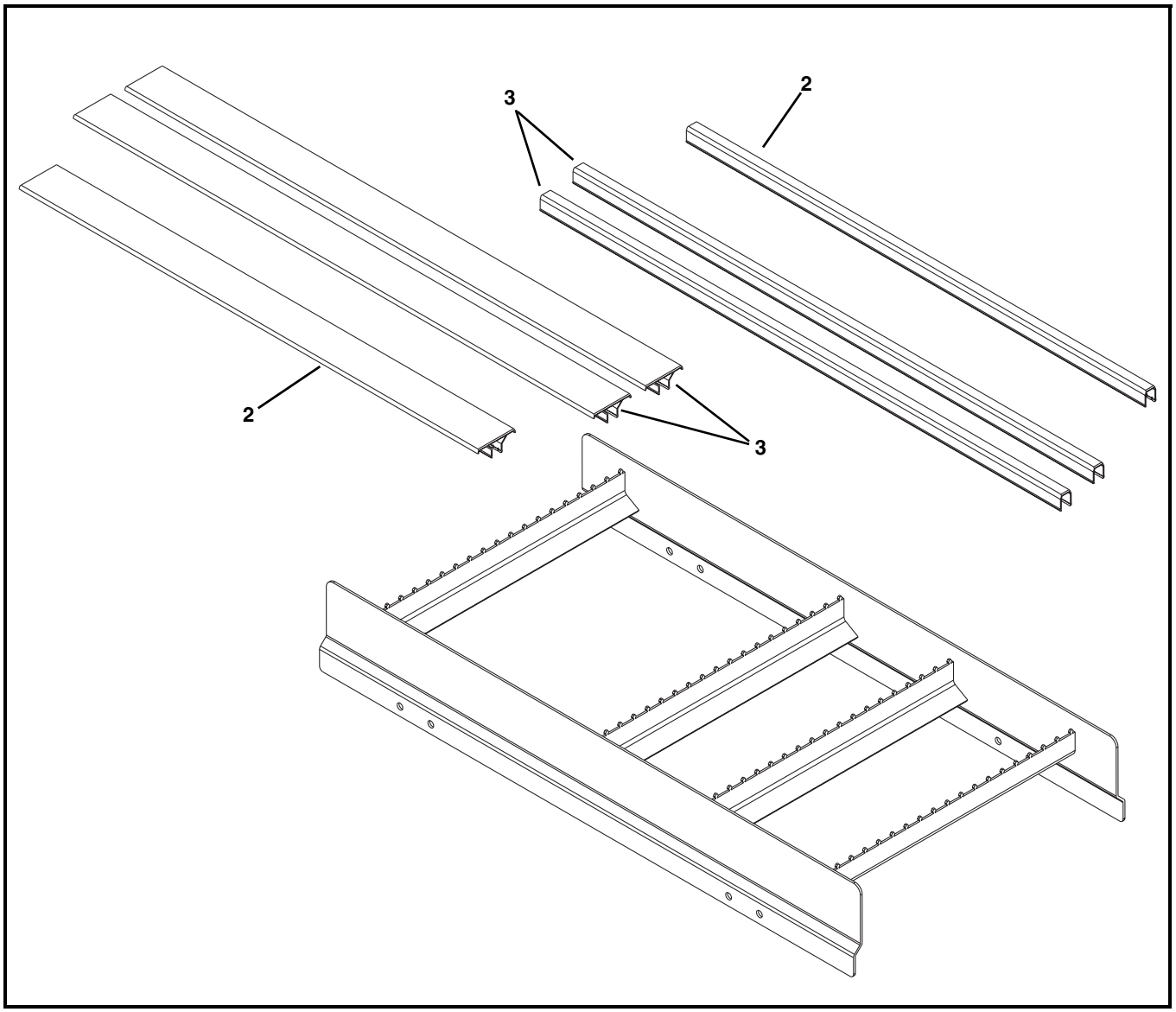
Item	Part Number	Description
1	802-123	Bearing
2	See Spindle Chart	Nosebar Spindle (for conveyors 14" wide and wider)
3	See V-Guide Spindle Chart	Center V-Guide Nosebar Spindle
4	532092-WW	Support Assembly
5	532295	Pivot Block
6	532346	Pivot Bushing
7	532347	Nosebar Headplate for A and C Position
8	532348	Nosebar Headplate for B and D Position
9	532349	Nosebar Puck (for conveyors 14" wide and wider)
10	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
11	961025MSS	Hex Head Cap Screw, M10-1.50 x 25 mm
12	990801MSS	Hex Nut, M8-1.25
13	990802MSS	Hex Nut, M8-1.25
14	736TS1-WW	Nosebar Idler Spindle Kit (Includes Items 1 through 3)
15	736TK1-WW	Nosebar Idler Tail Kit (Includes Items 1 through 13)
WW = Conveyor width reference: 04 – 52 in 02 increments		

Spindle Chart	
Conveyor Width	**Spindle**
4" (102 mm)	N/A
6" (152 mm)	N/A
8" (203 mm)	N/A
10" (254 mm)	N/A
12" (305 mm)	N/A
14" (356 mm)	505103
16" (406 mm)	505103
18" (457 mm)	505103
20" (508 mm)	505103
22" (559 mm)	505104
24" (610 mm)	505104
26" (660 mm)	505104
28" (711 mm)	505104
30" (762 mm)	505106
32" (813 mm)	505106
34" (864 mm)	505106
36" (914 mm)	505106
38" (965 mm)	505104
40" (1016 mm)	505104
42" (1067 mm)	505104
44" (1118 mm)	505104
46" (1168 mm)	505105
48" (1219 mm)	505105
50" (1270 mm)	505105
52" (1321 mm)	505105

V- Guide Spindle Chart	
Conveyor Width	**Spindle**
4" (102 mm)	532413
6" (152 mm)	505107
8" (203 mm)	505108
10" (254 mm)	505109
12" (305 mm)	505110
14" (356 mm)	505107
16" (406 mm)	505108
18" (457 mm)	505109
20" (508 mm)	505110
22" (559 mm)	505107
24" (610 mm)	505108
26" (660 mm)	505109
28" (711 mm)	505110
30" (762 mm)	505107
32" (813 mm)	505108
34" (864 mm)	505109
36" (914 mm)	505110
38" (965 mm)	505107
40" (1016 mm)	505108
42" (1067 mm)	505109
44" (1118 mm)	505110
46" (1168 mm)	505107
48" (1219 mm)	505108
50" (1270 mm)	505109
52" (1321 mm)	505110

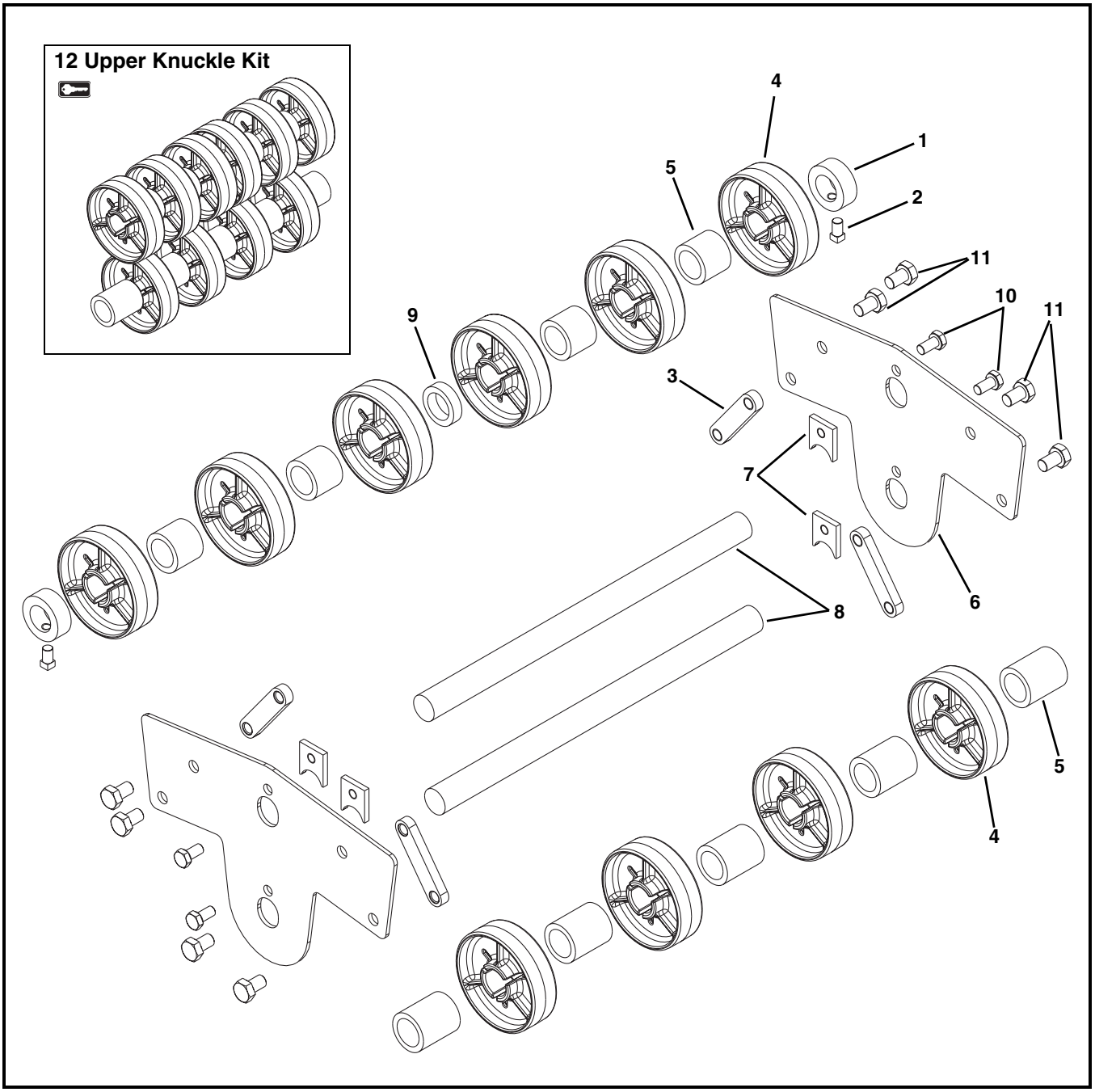
Service Parts

Frame Assembly



Item	Part Number	Description
1	----------	Consult Factory for Frame Part Number
2	532311-LLLLL-025	Outer Bed Rail
	532312-LLLLL-025	3" Wide Outer Bed Rail
3	532311-LLLLL-250	Center Bed Rail for Straight Conveyors and Z-Frame Conveyors less than 30°
	532312-LLLLL-250	3" Center Bed Rail for Straight Conveyors and Z-Frame Conveyors less than 30°
	532311-LLLLL-350	Center Bed Rail for Z-Frame Conveyors 30° and greater
	532312-LLLLL-350	3" Center Bed Rail for Z-Frame Conveyors 30° and greater
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 36.25" LLLLL = 03625		

Upper Knuckle - Flat

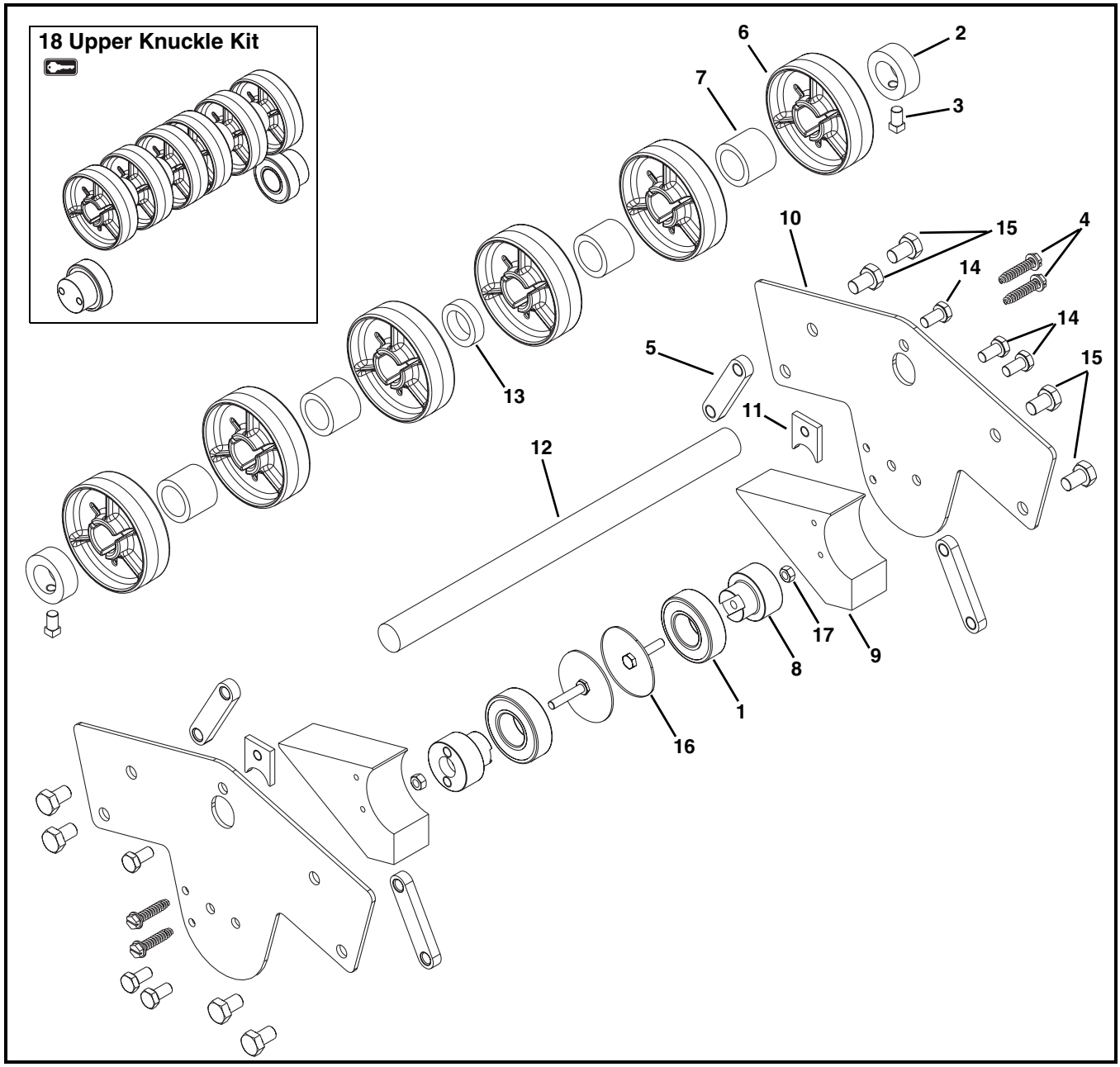


Item	Part Number	Description
1	807-1882	Roller Spacer
2	807-1883	Square Head Set Screw, 5/16-18 x 0.5
3	500199	Connector
4	506296	Idler Puck
5	532127-LLLLL	Tube Spacer
6	532356-AA	Side Plate
7	532358	Shaft Clamp
8	532375-WW	Shaft
9	532379	Center Spacer

Item	Part Number	Description
10	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
11	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
12	736UNF-WW	Upper Flat Belt Knuckle Kit (Includes Items 4, 5 and 9)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 3.25" LLLLL = 0325		
AA = Angle 05, 10, 15, 20, 25 or 30		
WW = Conveyor width reference: 08 – 24 in 02 increments		

Service Parts

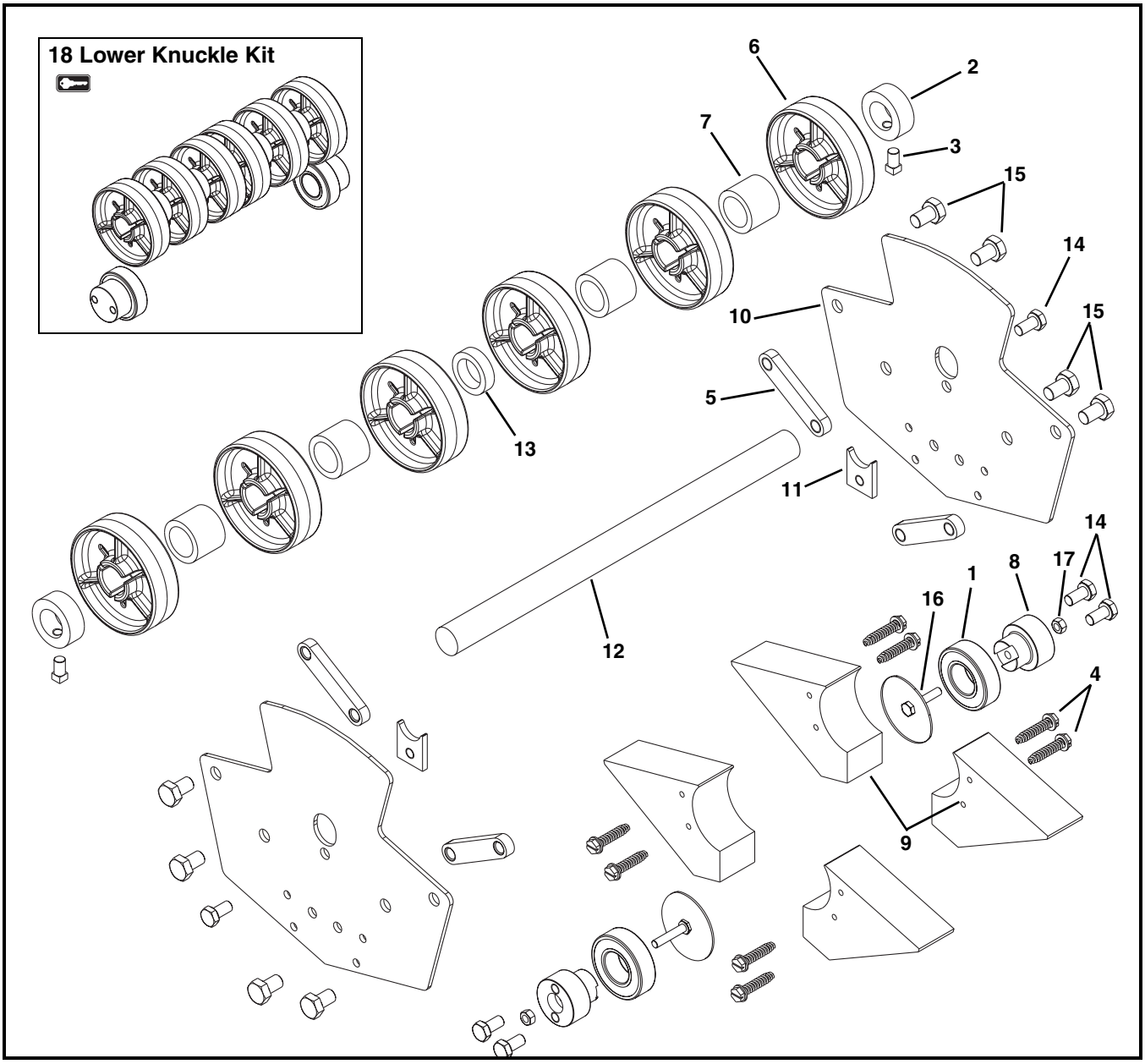
Upper Knuckle - Cleated



Item	Part Number	Description
1	802-164	Bearing
2	807-1882	Roller Spacer
3	807-1883	Square Head Set Screw, 5/16-18 x 0.5
4	807-1884	Sheet Metal Screw, #14 x 1.25
5	500199	Connector
6	506296	Idler Puck
7	532127-00108	Tube Spacer
8	532350	Bearing Axle Nut
9	532352-30	Roller Guide
10	532356-AA	Side Plate
11	532358	Shaft Clamp
11	532358	Shaft Clamp

Item	Part Number	Description
12	532375-WW	Shaft
13	532379	Center Spacer
14	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
15	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
16	532396	Bearing Cover
17	990601MSS	Hex Nut, M6-1.00
18	736UN-WW	Upper Knuckle Kit (Includes Items 1, 6, 7, 8 and 13)
AA = Angle 30, 35, 40, 45, 50, 55 or 60		
WW = Conveyor width reference: 08 – 24 in 02 increments		

Lower Knuckle

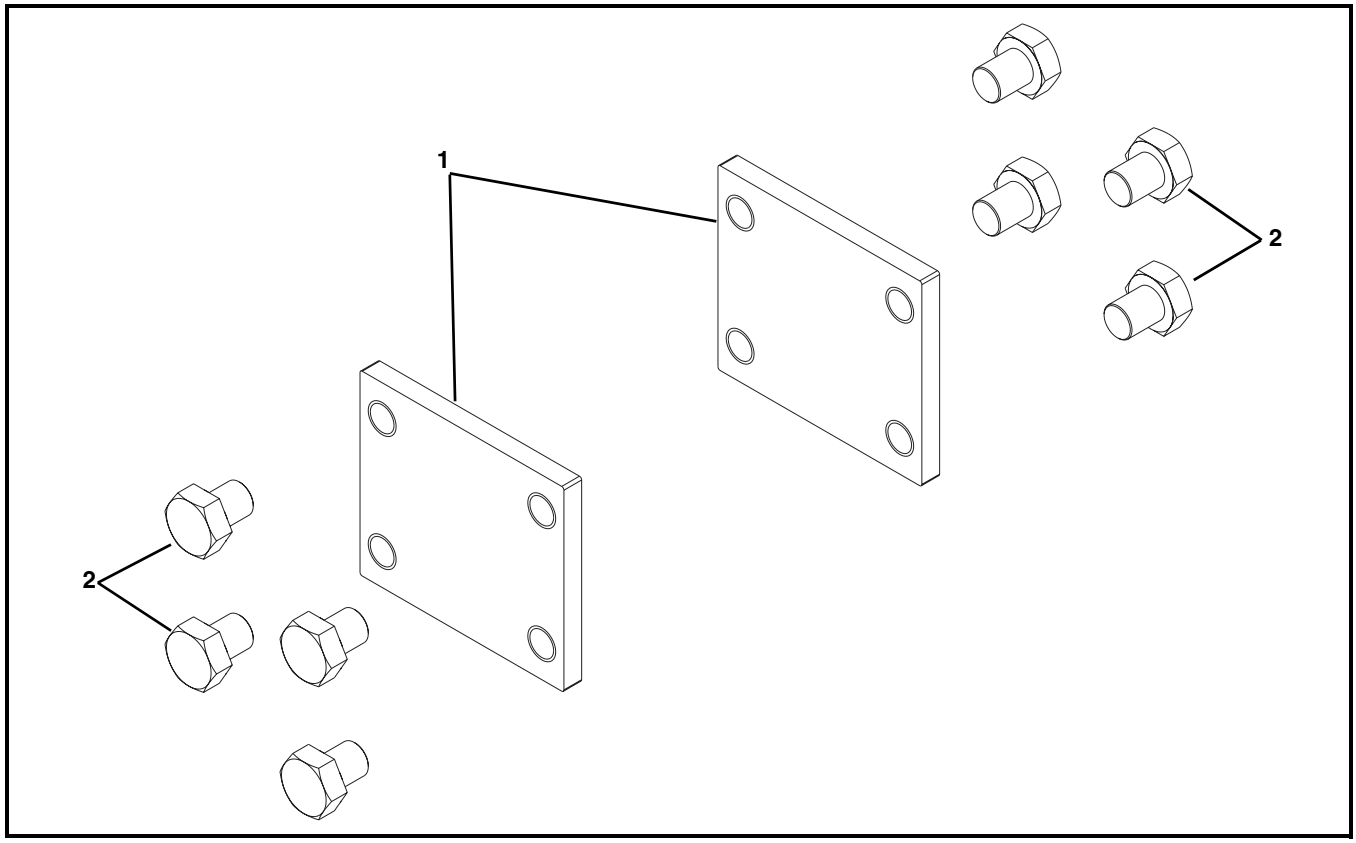


Item	Part Number	Description
1	802-164	Bearing
2	807-1882	Roller Spacer
3	807-1883	Square Head Set Screw, 5/16-18 x 0.5
4	807-1884	Sheet Metal Screw, #14 x 1.25
5	500199	Connector
6	506296	Idler Puck
7	532127-00108	Tube Spacer
8	532350	Bearing Axle Nut
9	532352-AA	Roller Guide
10	532354-AA	Side Plate

Item	Part Number	Description
11	532358	Shaft Clamp
12	532375-WW	Shaft
13	532379	Center Spacer
14	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
15	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
16	532396	Bearing Cover
17	990601MSS	Hex Nut, M6-1.00
18	736LN-WW	Lower Knuckle Kit (Includes Items 1, 6, 7, 8 and 13)
AA = Angle 30, 35, 40, 45, 50, 55 or 60		
WW = Conveyor width reference: 08 – 24 in 02 increments		

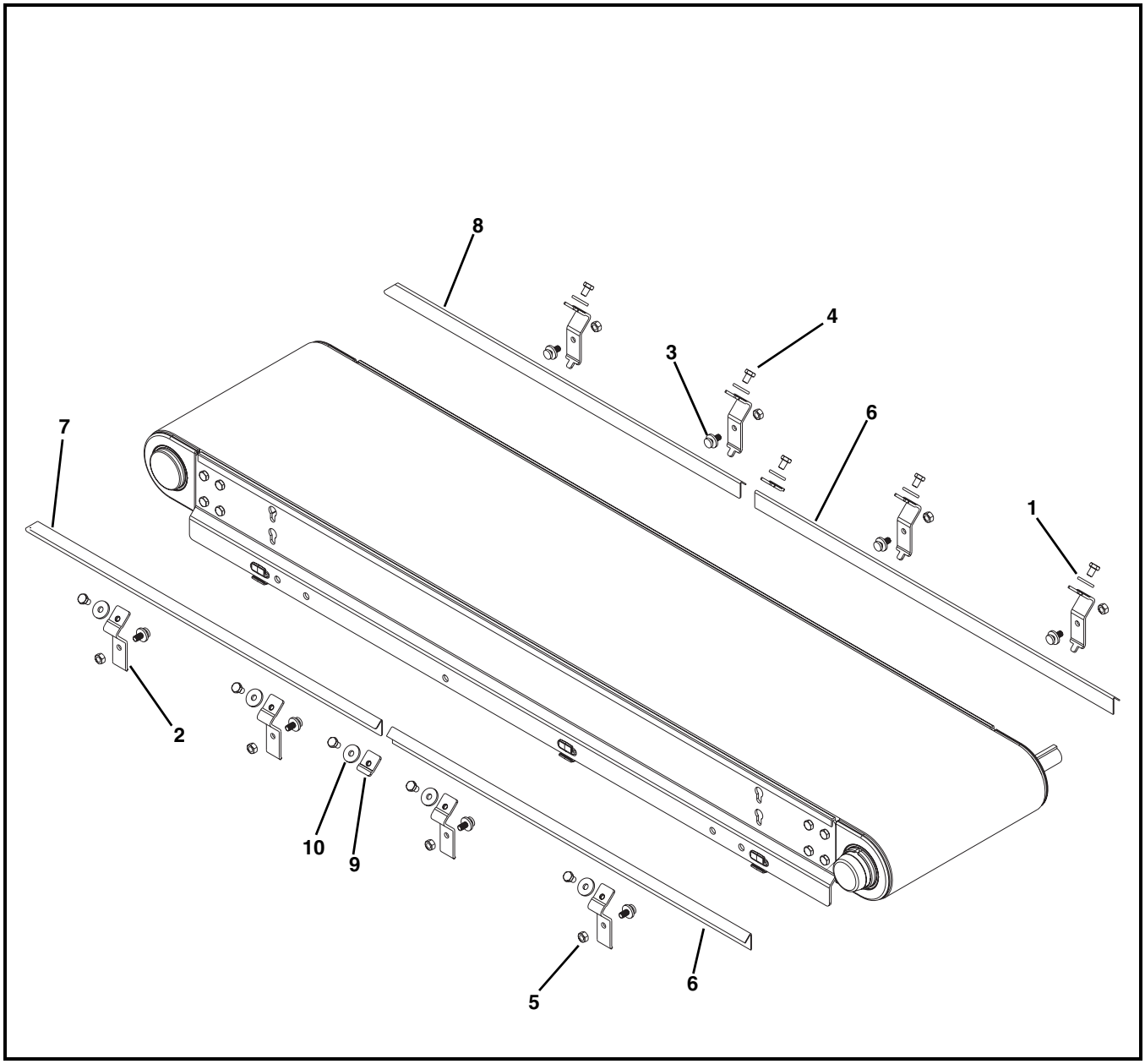
Service Parts

Connecting Assembly



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

1" (25 mm) High Sides

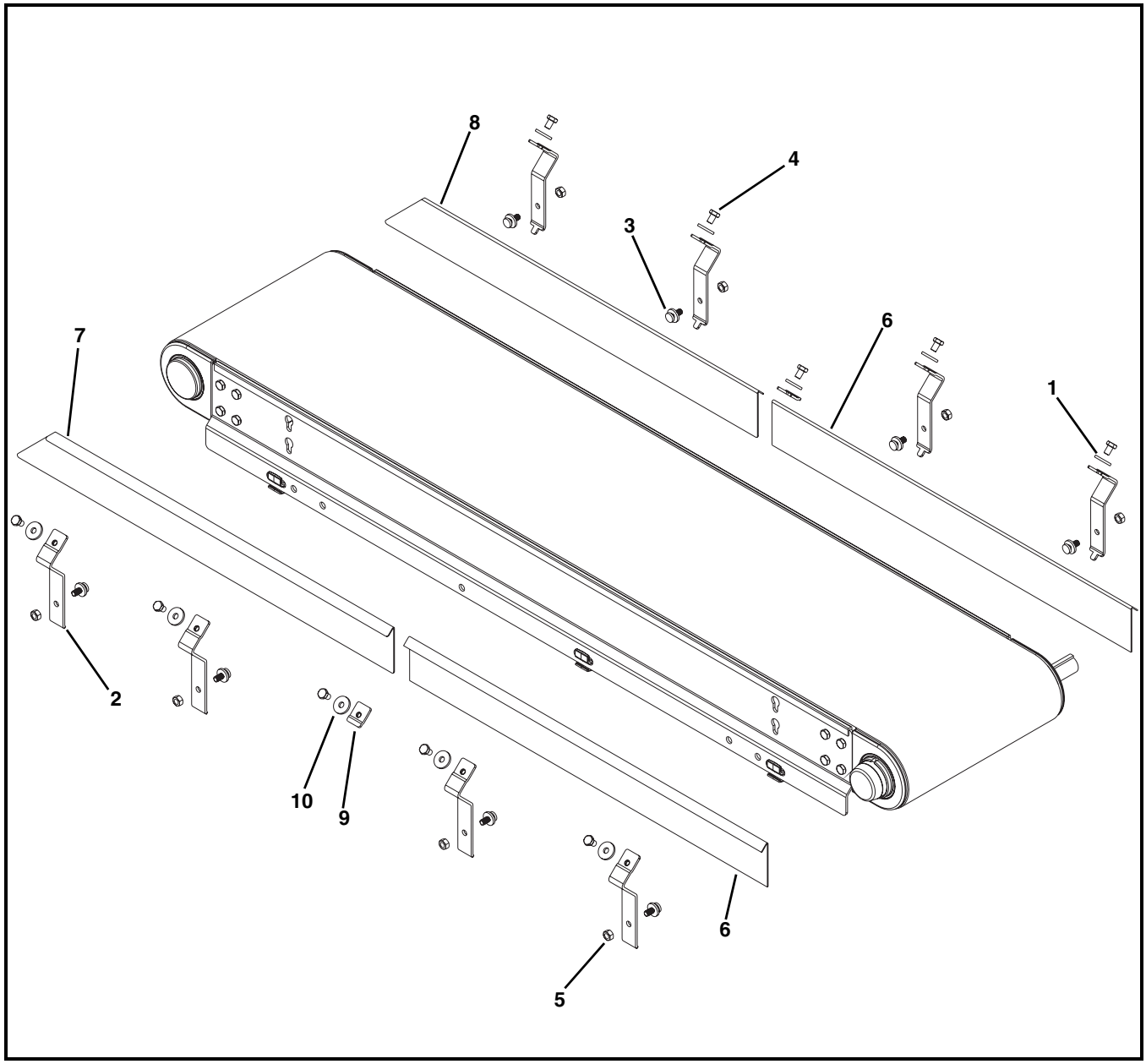


Item	Part Number	Description
1	807-1821	Washer
2	532183	1" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532175-LLLLL	Guiding Straight

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		

Service Parts

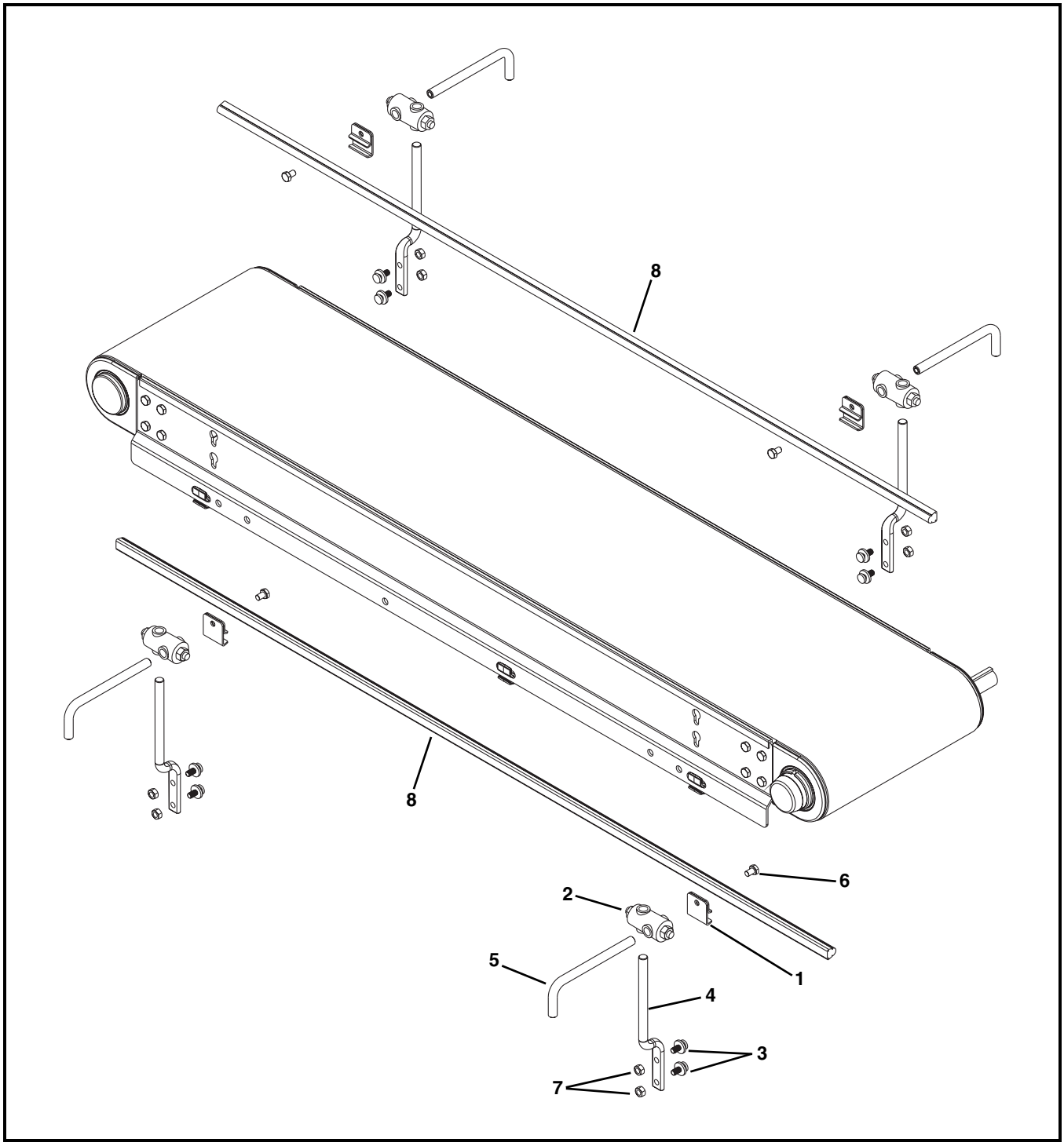
3" (76 mm) High Sides



Item	Part Number	Description
1	807-1821	Washer
2	532185	3" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
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		

Fully Adjustable Round Guides

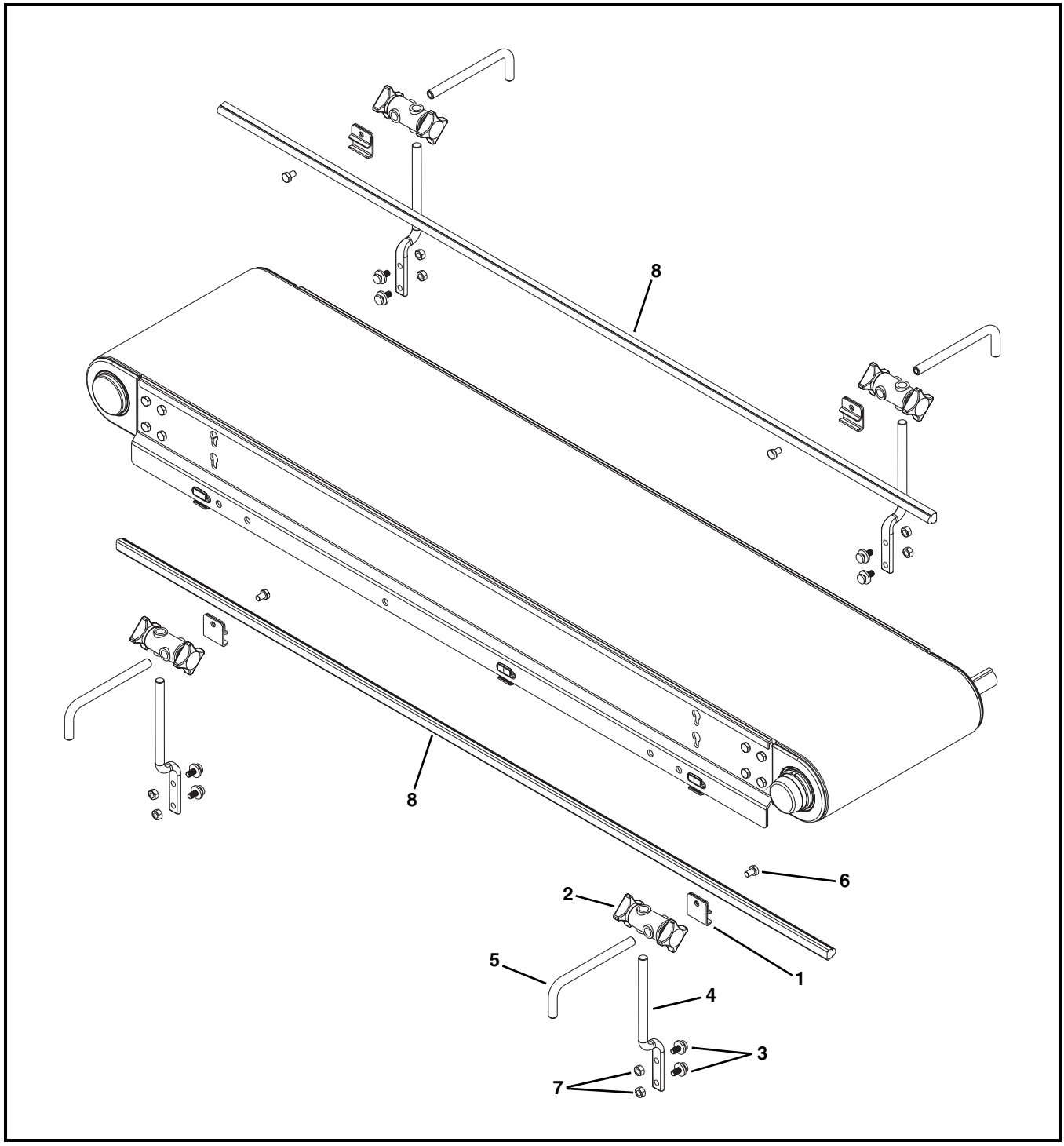


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
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

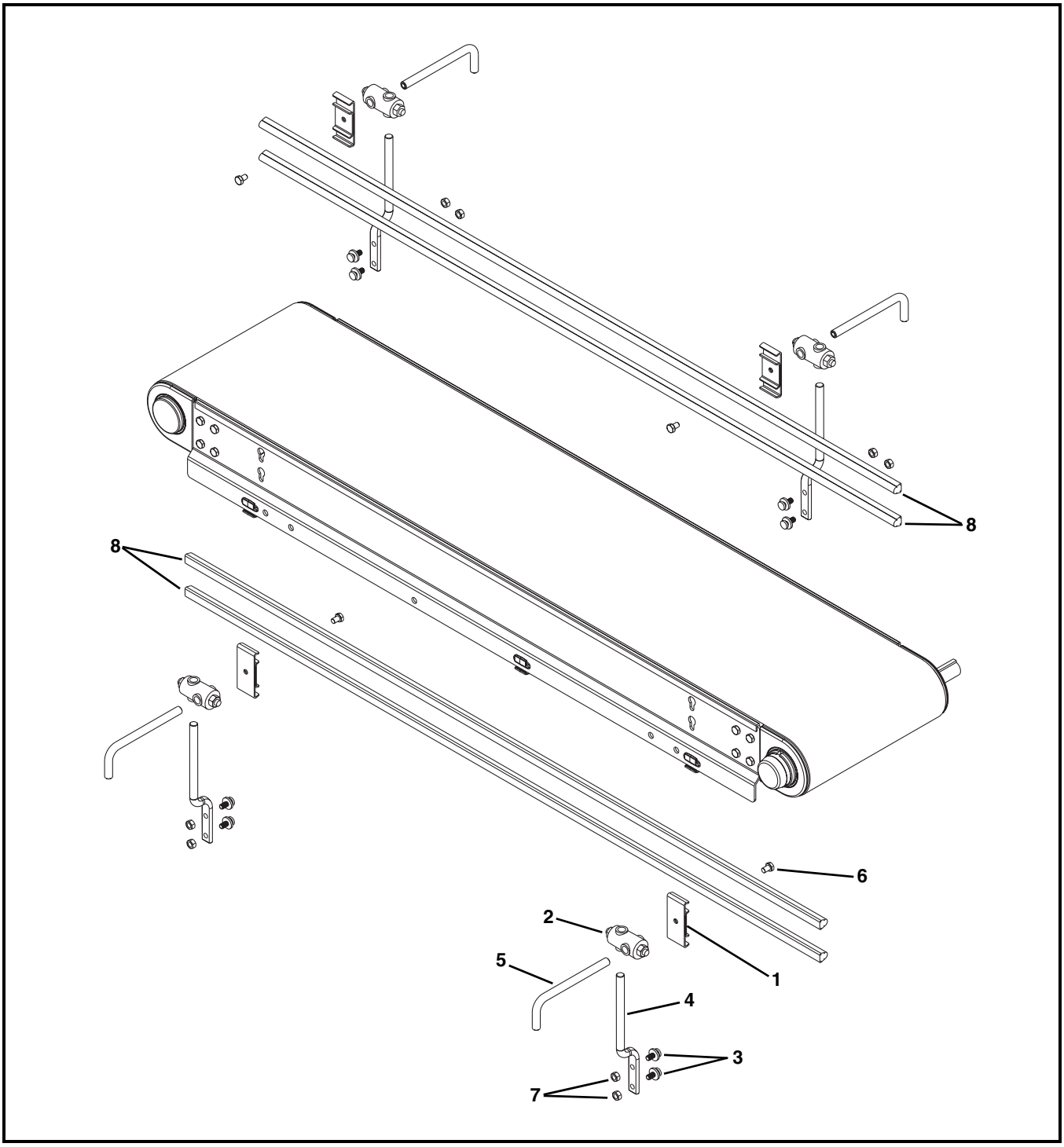
Tool-Less Fully Adjustable Round Guides



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

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
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		

Twin Rail Adjustable Round Guides

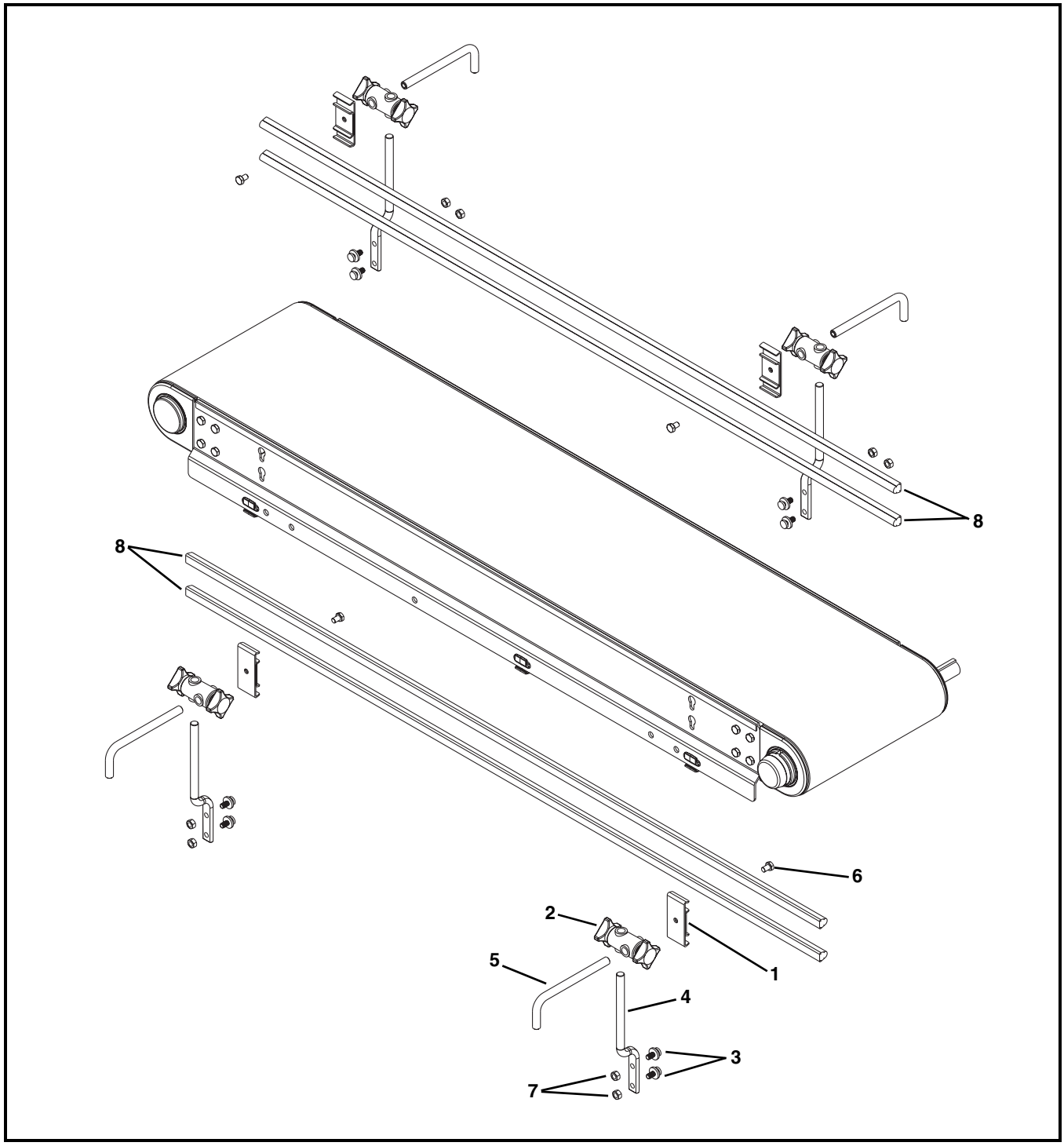


Item	Part Number	Description
1	901414	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
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

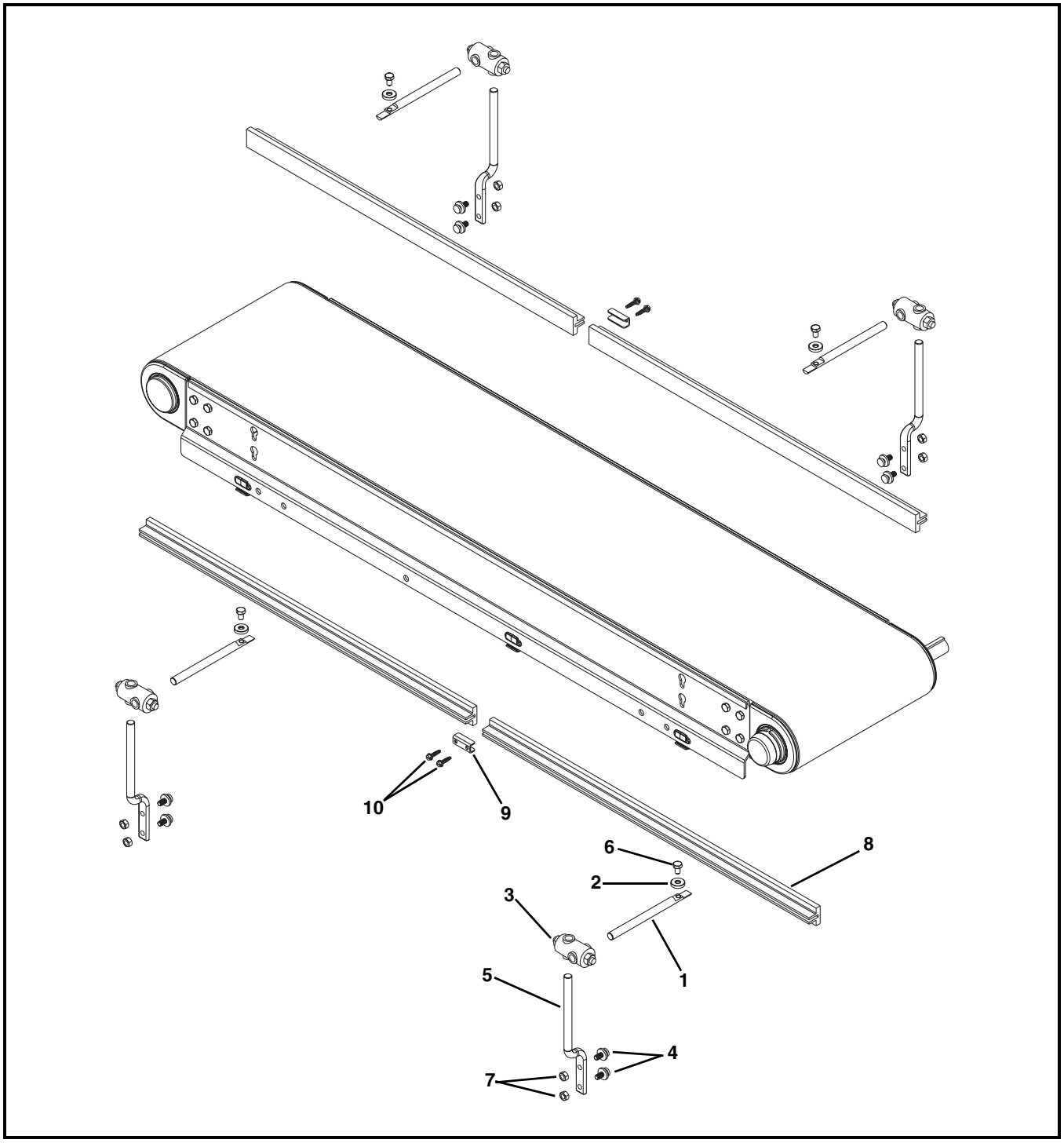
Tool-Less Twin Rail Adjustable Round Guides



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

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
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		

Fully Adjustable 1" (25 mm) Flat Guides

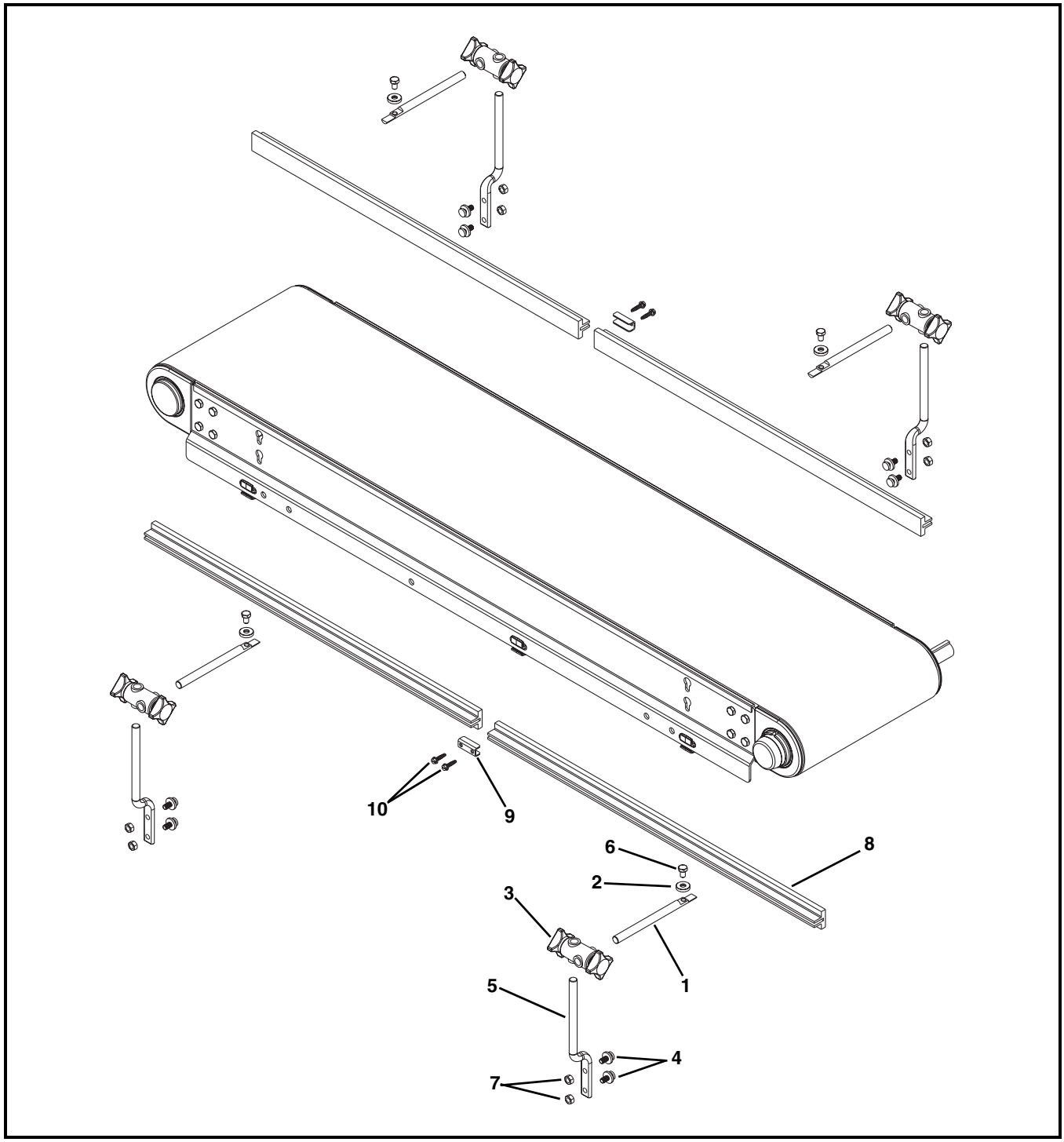


Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1387	Cross Block Clamp
4	532191	Carriage Bolt, M8 x 20 mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

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

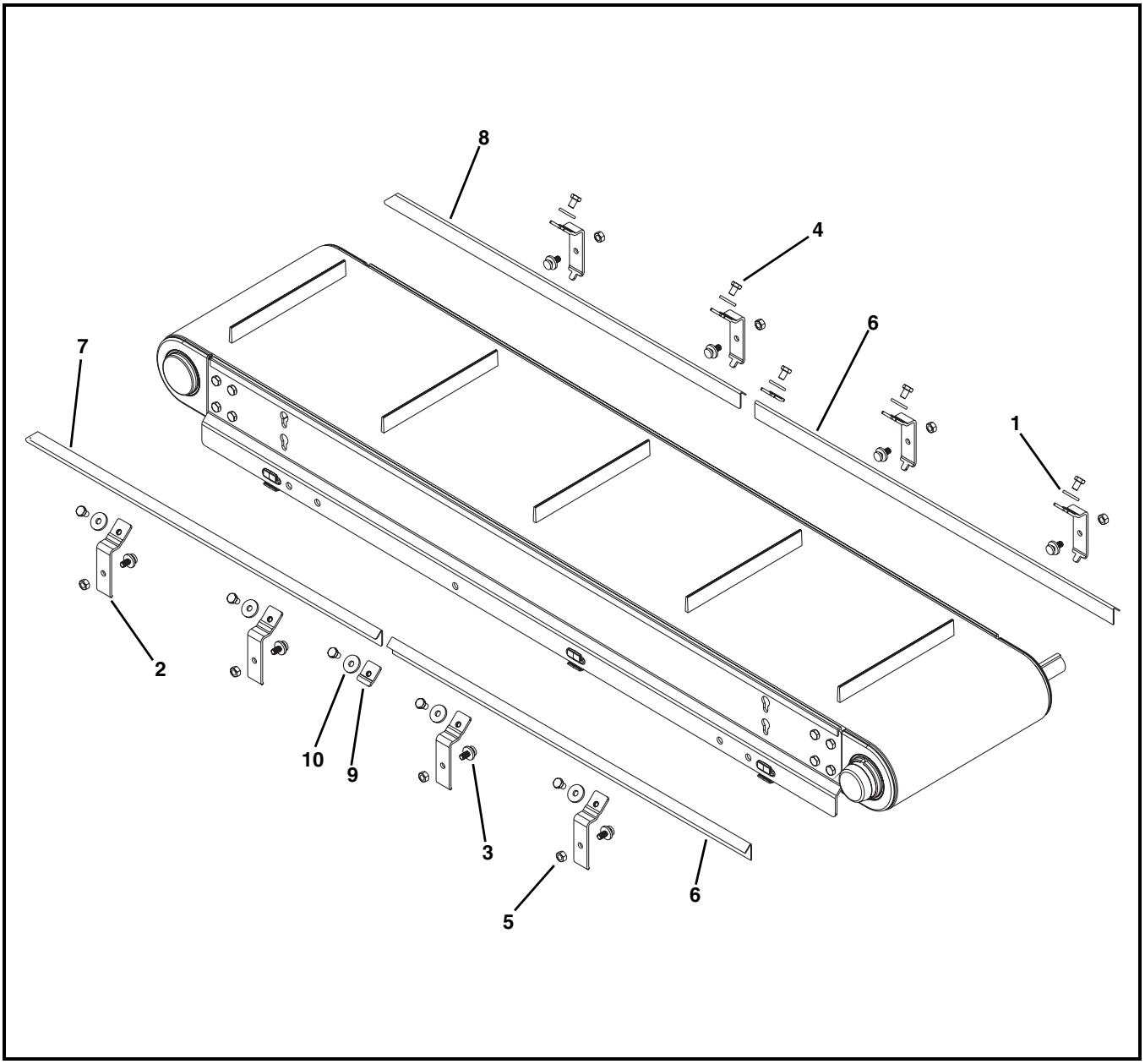
Tool-Less Fully Adjustable 1" (25 mm) Flat Guides



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

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		

1" (25 mm) Cleated High Sides

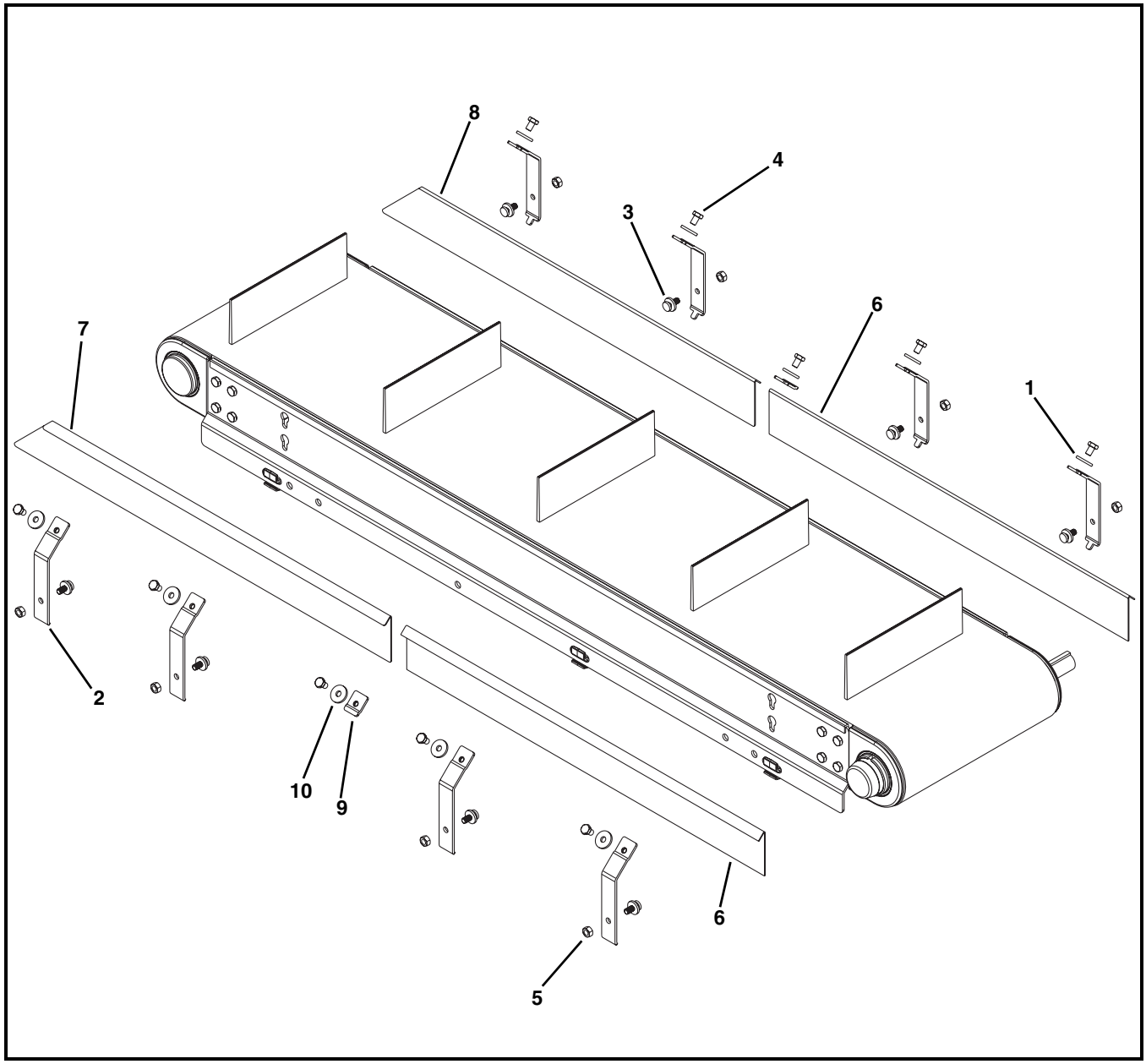


Item	Part Number	Description
1	807-1821	Washer
2	532184	1" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532175-LLLLL	Guiding Straight

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		

Service Parts

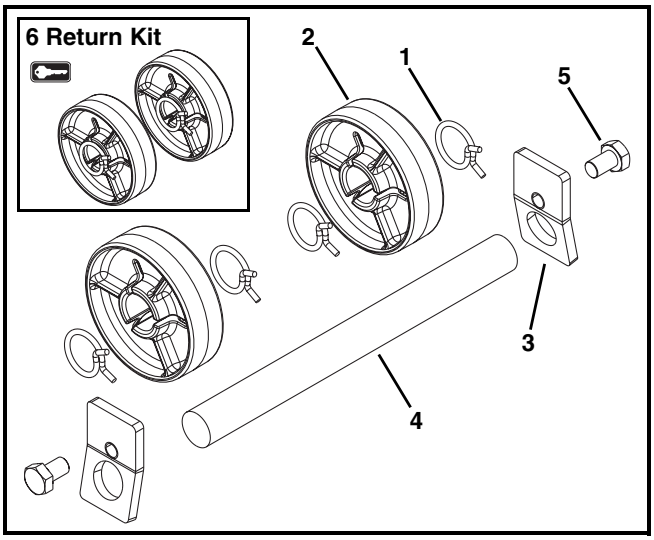
3" (76 mm) Cleated High Sides



Item	Part Number	Description
1	807-1821	Washer
2	532186	3" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
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		

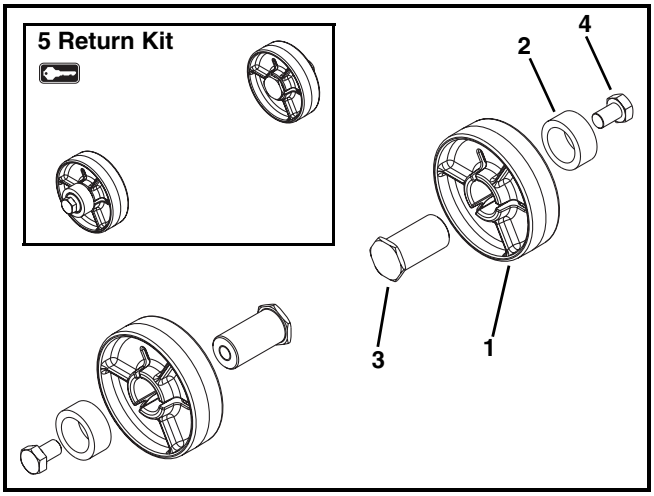
Returns - Flat



Item	Part Number	Description
1	807-1551	Clamp
2	506296	Return Disk
3	532307	Return Shaft Bracket
4	532375-WW	Shaft
5	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
6	736RRF-WW	Return Kit (Includes items 1 and 2)

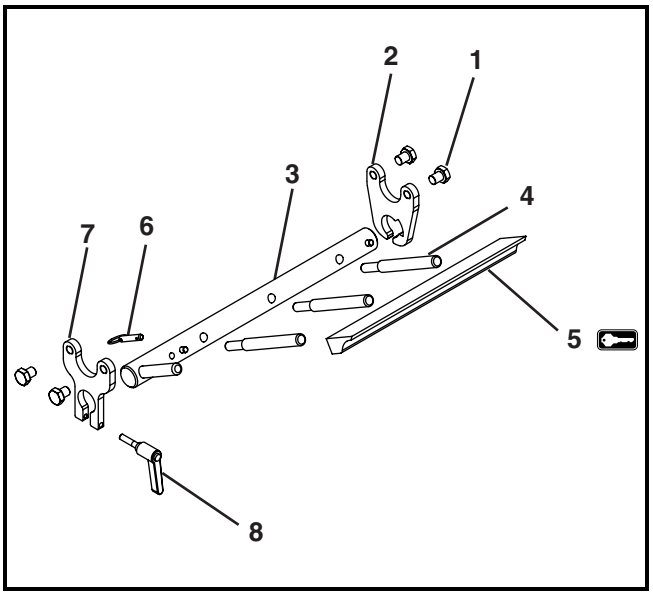
WW = Conveyor width reference: 04 – 52 in 02 increments

Returns - Cleated



Item	Part Number	Description
1	506296	Return Disk
2	532305	Spacer
3	532306	Stub Shaft
4	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
5	736RRC	Return Kit (Includes Items 1 through 4)

Scraper



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

WW = Conveyor width ref: 04 - 52 in 02 increments

Configuring Conveyor Belt Part Number

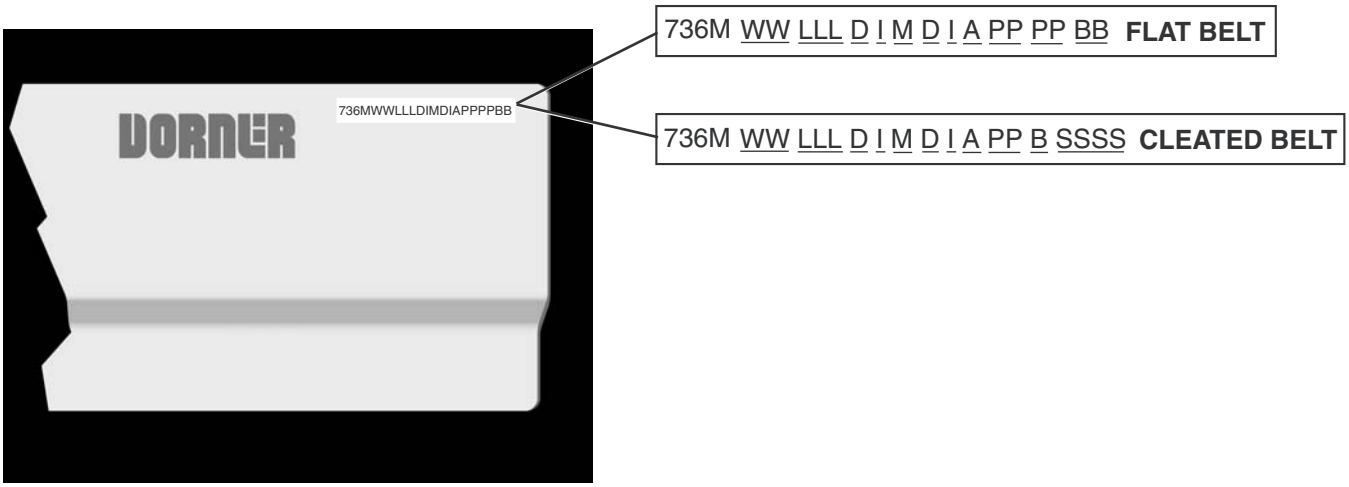


Figure 63

Flat Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 63)**. From the model number determine the conveyor width (WW), length (LLL), drive/tail types (A) and belt type (BB). Use data to configure belt part number as indicated below. *Add “V” for v-guided belts.

736-WW LLL A / BB V*

736-___ ___ __ / ___ V*

(Fill In)

Cleated Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 63)**. From the model number determine the conveyor width (WW), length (LLL), cleat type (C) and cleat spacing (SSSS). Use data to configure belt part number as indicated below. *Add “V” for v-guided belts.

736-WW LLL C SSSS V*

736-___ ___ __ _____ V*

(Fill In)

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 to order 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 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.

DORNER MFG. CORP.
975 Cottonwood Ave., PO Box 20
Hartland, WI 53029-0020 USA
TEL 1-800-397-8664 (USA)
FAX 1-800-369-2440 (USA)
Internet: www.dorner.com

Outside the USA:
TEL 1-262-367-7600
FAX 1-262-367-5827

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