# 7350 Series Version 2 Conveyors

## Installation, Maintenance and Parts Manual

For other service manuals visit our website at:
www.dornerconveyors.com/manuals-literature

Record Conveyor Serial Number Here

851-879 Rev. A

# Table of Contents

**⚠ 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 Critical 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. Recommended Critical Service Parts and Kits are marked in the Service Parts section of this manual with the Key Service Parts symbol .

# Warnings – General Safety

**⚠ WARNING**

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

**⚠ DANGER**

**SEVERE HAZARD!**

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

**⚠ 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!**

- **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.**

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

| | |
|---|---|
| 1 | Conveyor |
| 2 | Gearmotor |
| 3 | Belt (Flat Belt Shown) |
| 4 | Support Stands |
| 5 | Drive End |
| 6 | Idler End |
| 7 | Guides |

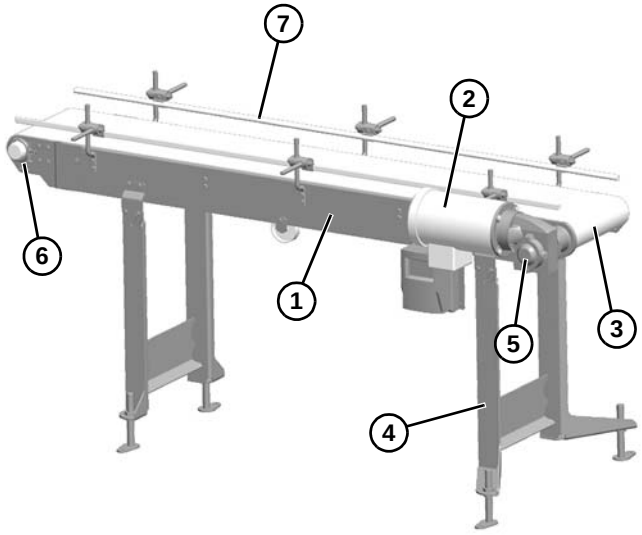
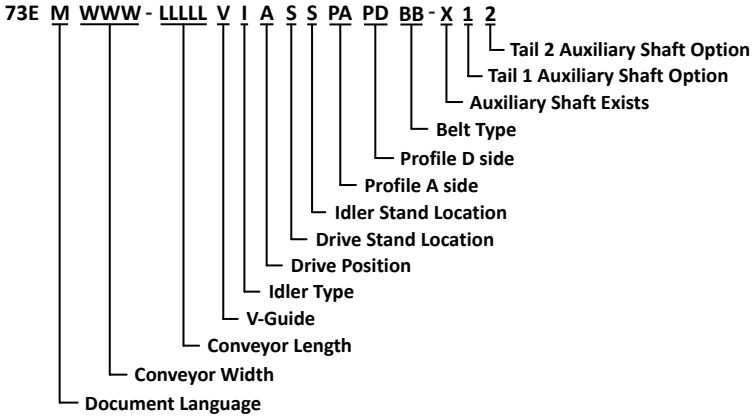



***Figure 1***

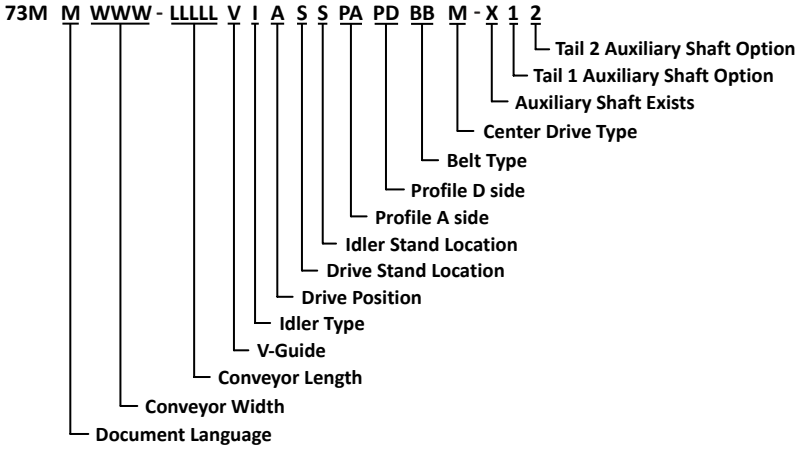
# Specifications

## 7350 Series Version 2 Conveyors

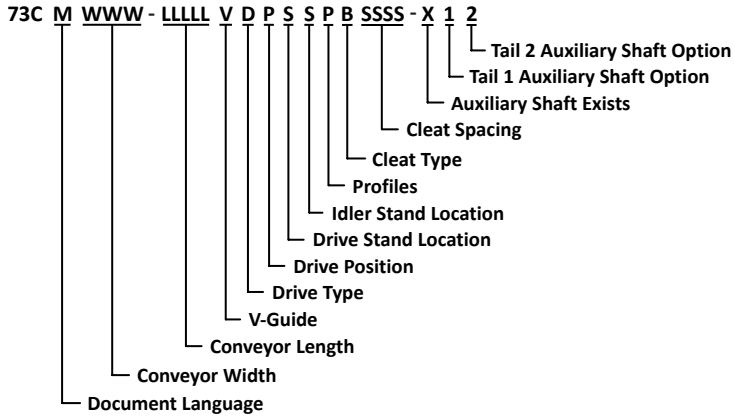
### Flat Belt End Drive 7350 Series Version 2



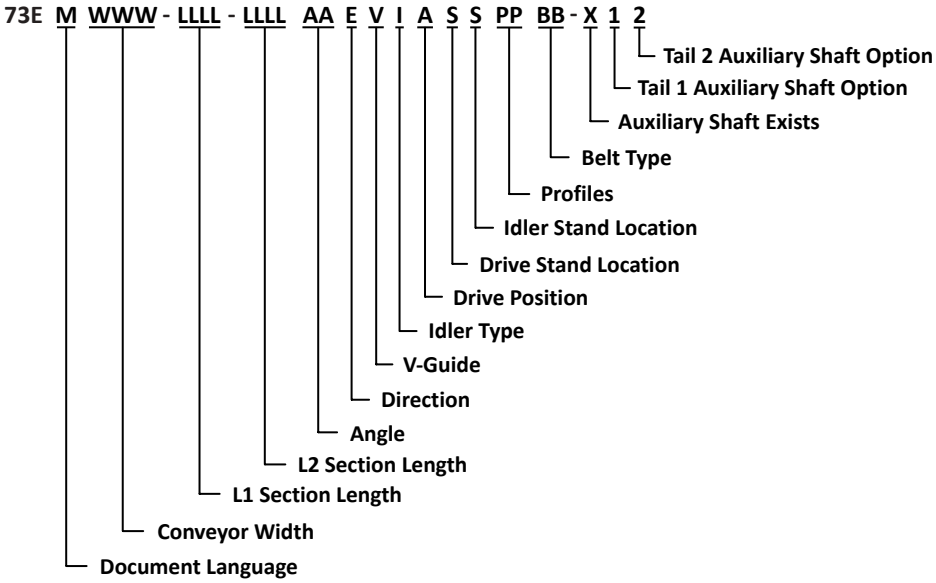

### Flat Belt Center Drive 7350 Series Version 2



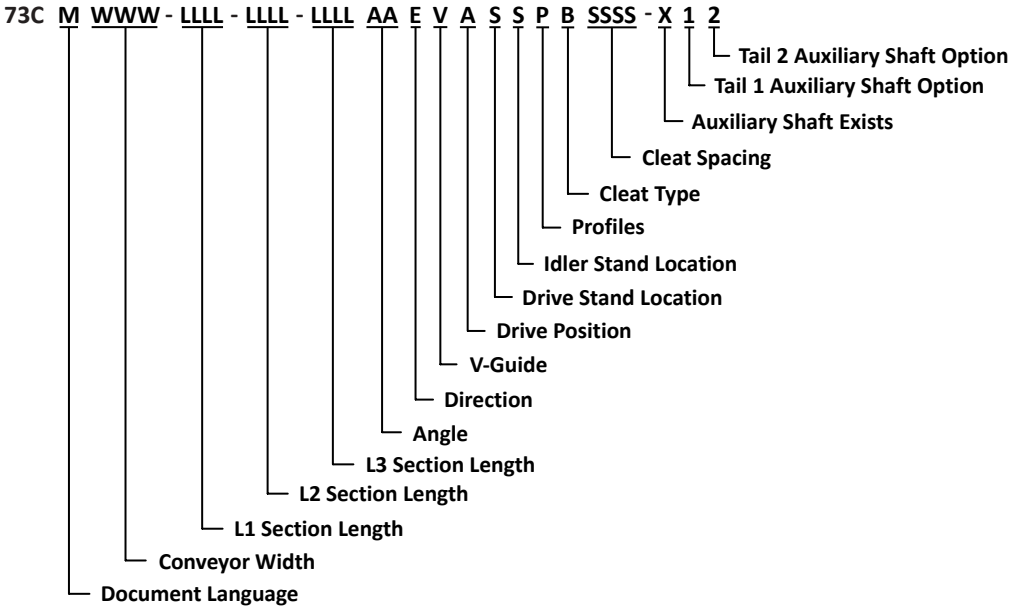

### Cleated Belt End Drive 7350 Series Version 2



## Flat Belt LPZ 7350 Series Version 2




## Cleated Belt LPZ 7350 Series Version 2



# Specifications

## Conveyor Supports

**Maximum Distances:**

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

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

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

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

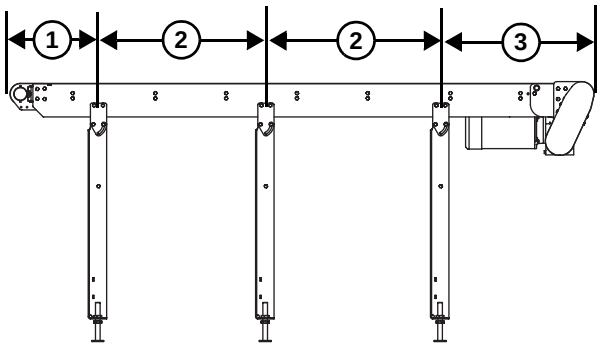



***Figure 2***

## Specifications

| | |
|---|---|
| Conveyor Width Reference (WWW) | 152, 203, 254, 305, 356, 406, 457, 508, 559, 610, 660, 711, 762, 813, 864, 914 |
| Conveyor Belt Width | 152 mm (6") 203 mm (8"), 254 mm (10"), 305 mm (12"), 356 mm (14"), 406 mm (16"), 457 mm (18"), 508 mm (20"), 559 mm (22"), 610 mm (24"), 660 mm (26"), 711 mm (28"), 762 mm (30"), 813 mm (32"), 864 mm (34"), 914 mm (36") |
| Maximum Conveyor Load (See NOTE Below) | 97 kg/ $m^2$ (20 lbs. / $ft^2$) with a maximum of 227 kg (500 lbs.) |
| Belt Travel | 229 mm (9") per revolution of pulley |
| Maximum Belt Speed | 91 m/minute (300 ft/minute) |
| Conveyor Length Reference (LLLLL) | 00915 - 12190 in 00005 increments |
| Conveyor Length | 915 mm (36") - 12190 mm (480") in 5 mm (.20") increments |

**NOTE**

*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.**

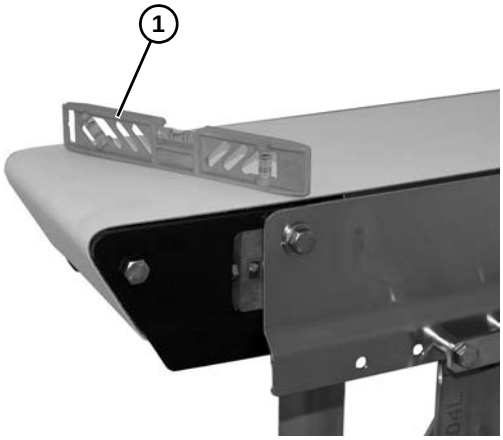



*Figure 3*

## Required Tools

- Level
- Torque wrench
- 5/32" hex wrench
- 10 mm wrench
- 13 mm wrench
- 14 mm wrench
- 17 mm wrench

## Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to “Conveyors Longer than 10 ft (3048 mm)” on page 9.
2. Attach the stands. Refer to “Stand Installation” on page 12.
3. Install the belt. Refer to “Belt Installation” on page 12.
4. Install belt returns. Refer to “Belt Returns” on page 13.
5. Install the gearmotor. Refer to “Drive Package Installation” on page 17.

## Conveyors Longer than 10 ft (3048 mm)

### Connecting Components

Typical connecting components **(Figure 4)**.

| | |
|---|---|
| 1 | Connecting Plate (x2) |
| 2 | Hex Head Cap Screw (x8) |
| 3 | Conveyor Frames |

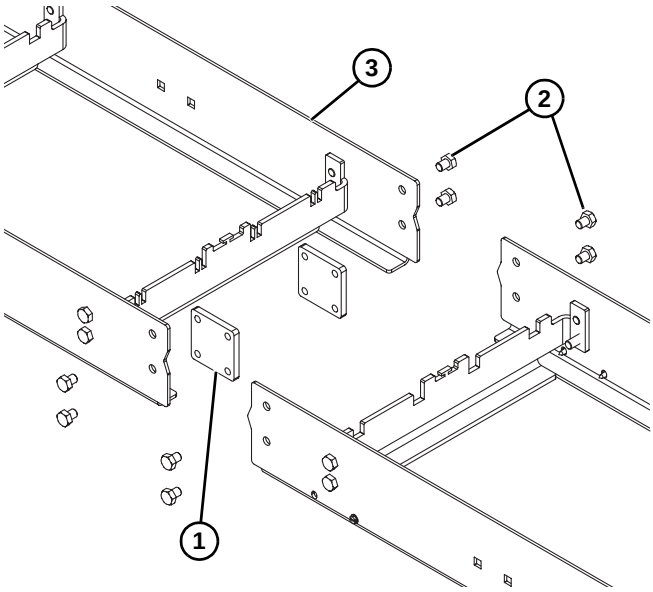



*Figure 4*

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


*Figure 5*

2. Join both conveyor sections and install connecting plates **(Figure 4, item 1)** with four M8x10 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.* |

### Upper Knuckles

1. Attach upper knuckle **(Figure 6, item 1)** to frame using four bolts **(Figure 6, item 2)** and two plates **(Figure 7, item 1)** on each side of the upper knuckle assembly.

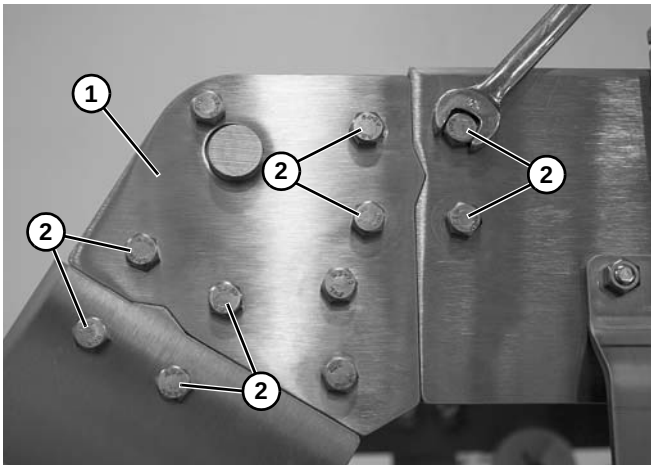



***Figure 6***

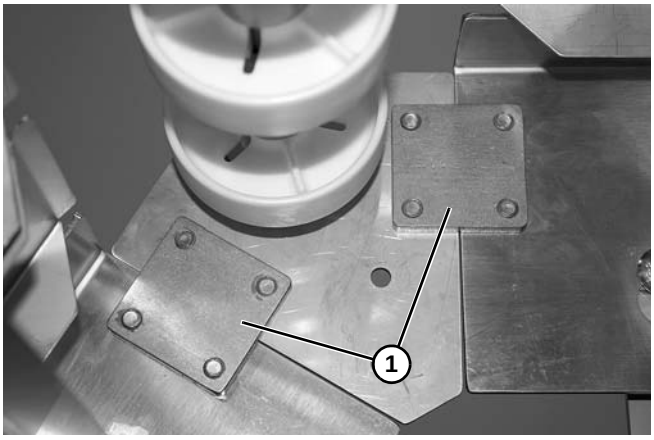



***Figure 7***

2. Remove bolts **(Figure 8, item 1)**.

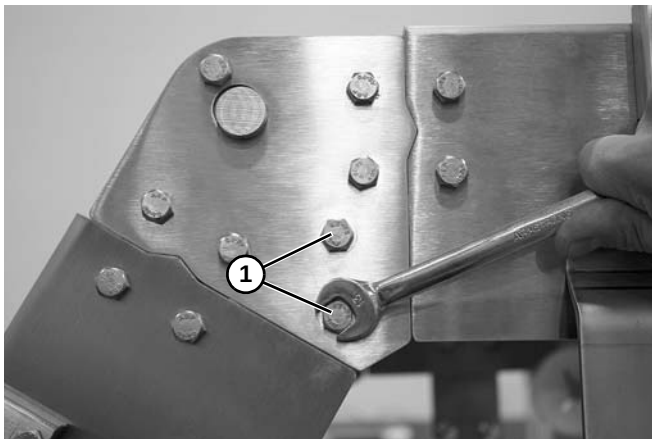



***Figure 8***

3. Remove bearing guard **(Figure 9, item 1)** with bearing.

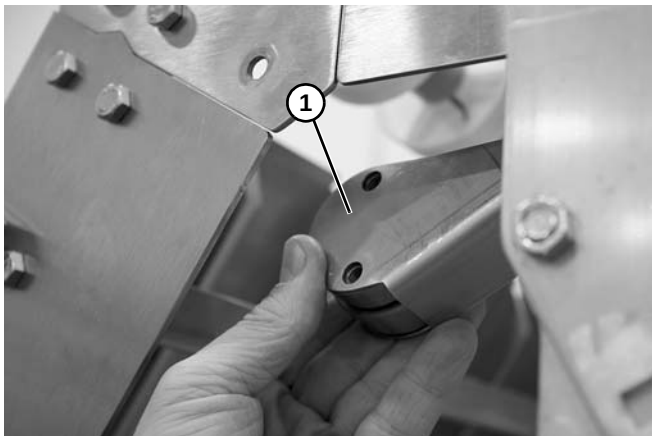



***Figure 9***

4. Install belt. Refer to “Belt Installation” on page 12.
5. Install bearing guard and bearing.
6. Tighten all bolts to 60 in-lb (7 Nm).

## Lower Knuckles

1. Attach lower knuckle **(Figure 10, item 1)** to frame using four bolts **(Figure 10, item 2)** and two plates **(Figure 11, item 1)** on each side of the lower knuckle assembly.

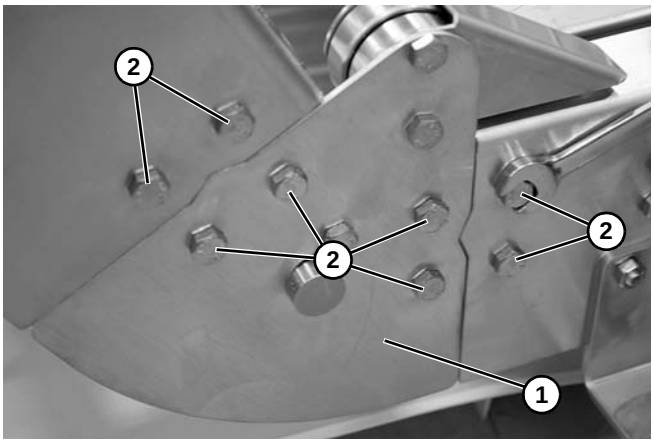



***Figure 10***

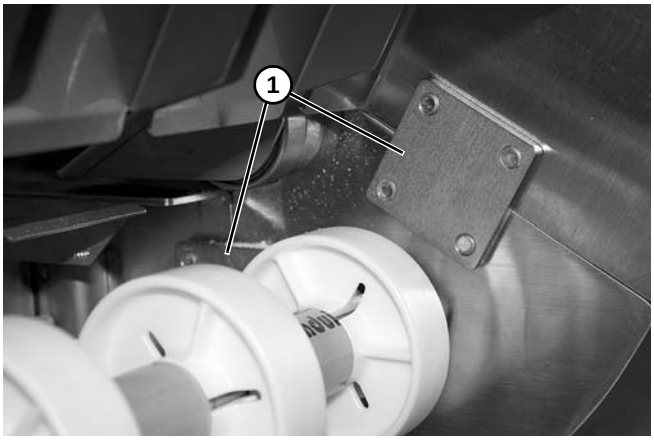



***Figure 11***

2. Remove bolts **(Figure 12, item 1)**.

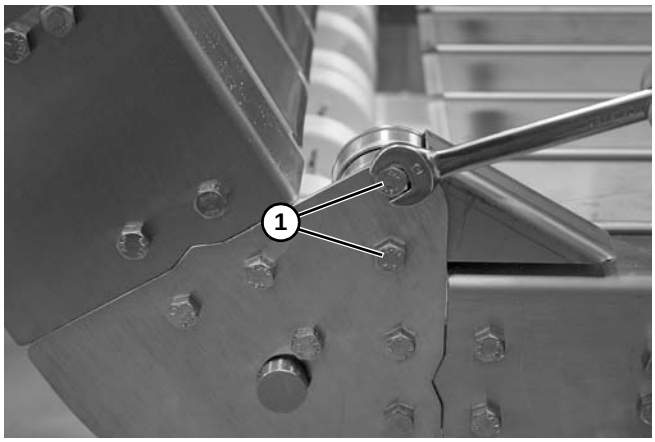



***Figure 12***

3. Remove bearing guard **(Figure 13, item 1)** with bearing.

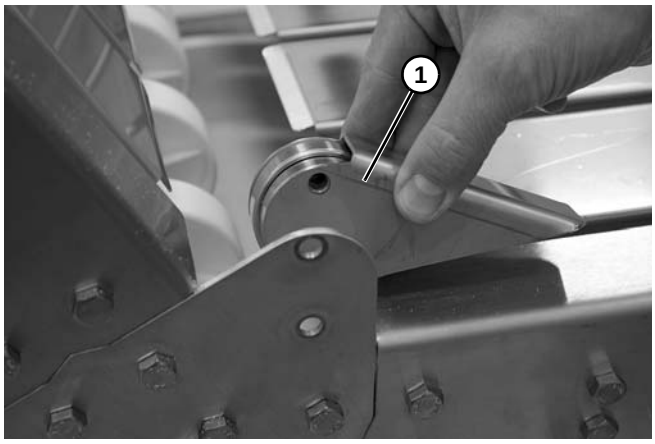



***Figure 13***

4. Install belt. Refer to “Belt Installation” on page 12.
5. Install bearing guard and bearing.
6. Tighten all cap screws to 60 in-lb (7 Nm).

# Installation

## Stand Installation

**NOTE**

*For detailed assembly instructions, please see support stand manual 851-885.*

Typical stand components **(Figure 14)**.

| | |
|---|---|
| 1 | Conveyor Frame |
| 2 | Stand |
| 3 | Carriage Bolt (x4) |
| 4 | Hex Nut (x4) |

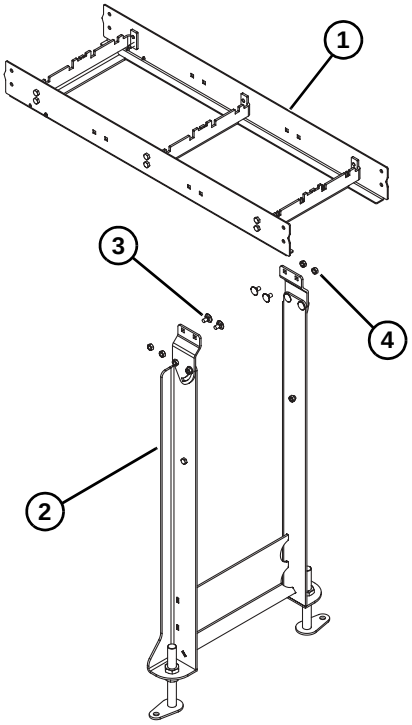



***Figure 14***

1. Position the stands on a flat, level surface.
2. Attach the stands **(Figure 15, item 1)** to the frame.

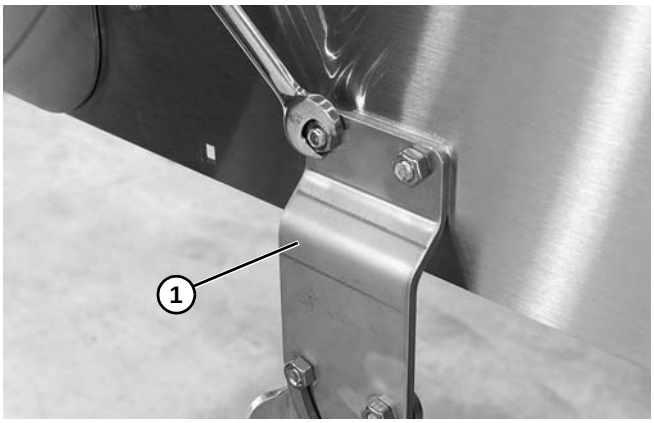



***Figure 15***

## Belt Installation

**⚠ WARNING**

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

**PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.**

1. Place temporary support stands **(Figure 16, item 1)** at both ends of the conveyor. Place an additional support stand **(Figure 16, item 2)** under the drive motor, if equipped. See WARNING.

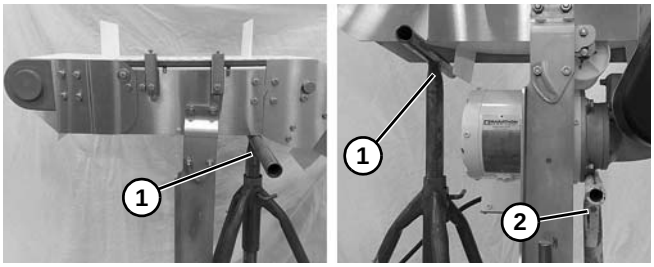



***Figure 16***

2. Remove fasteners **(Figure 17, item 1)** securing the stand brackets from one side of the conveyor and remove brackets.

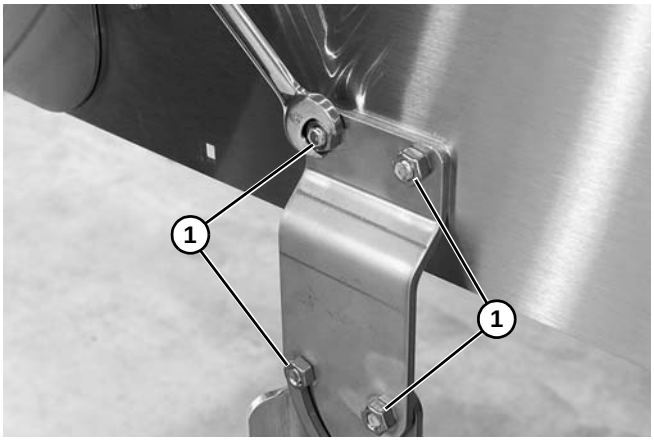



***Figure 17***

3. Rotate idler end **(Figure 18, item 1)** upward as shown.

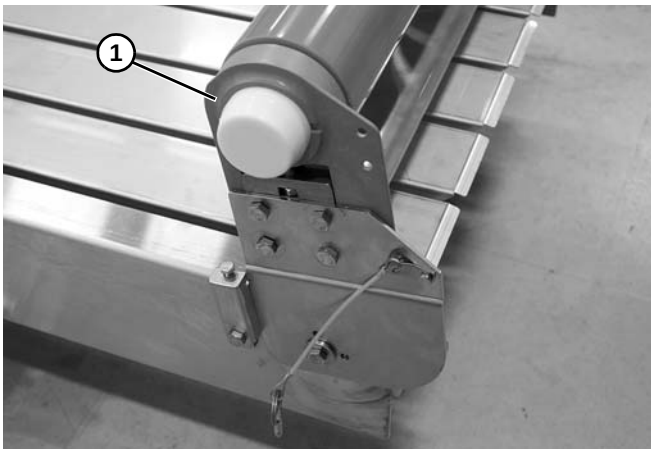



***Figure 18***

4. Position the belt **(Figure 19, item 1)** onto the conveyor **(Figure 19, item 2)**.

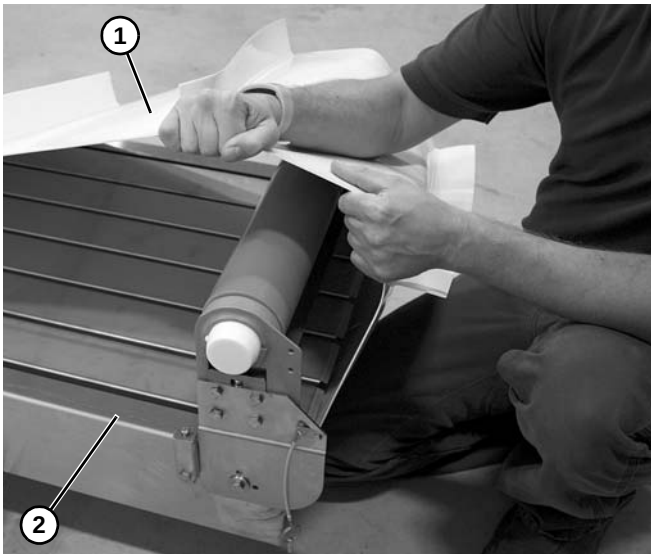



***Figure 19***

5. Install stand brackets to conveyor with fasteners.
6. Repeat procedure for the opposite end of the conveyor to fully install the belt.

## Belt Returns

### Flat Belt Returns 610 mm Wide and Wider

Typical flat return components **(Figure 20)**.

| | |
|---|---|
| 1 | Hex Nut |
| 2 | Return Clip |
| 3 | Return Bracket |
| 4 | Carriage Bolt |
| 5 | Shaft |
| 6 | Retaining Plate |
| 7 | Spacer |
| 8 | Puck |

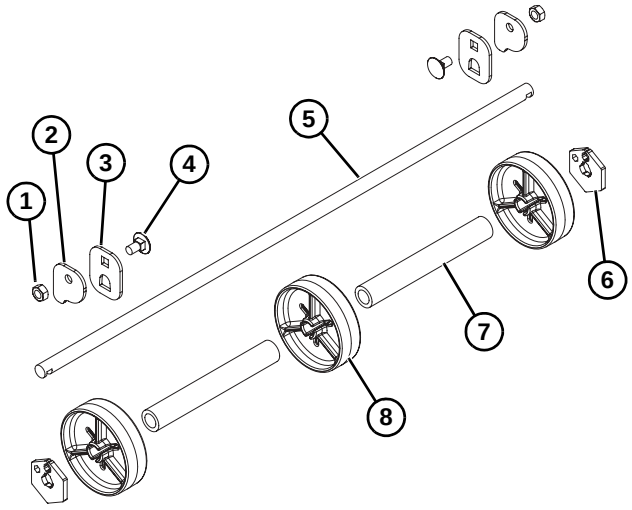



***Figure 20***

1. Install carriage bolt **(Figure 21, item 1)** through frame rail.

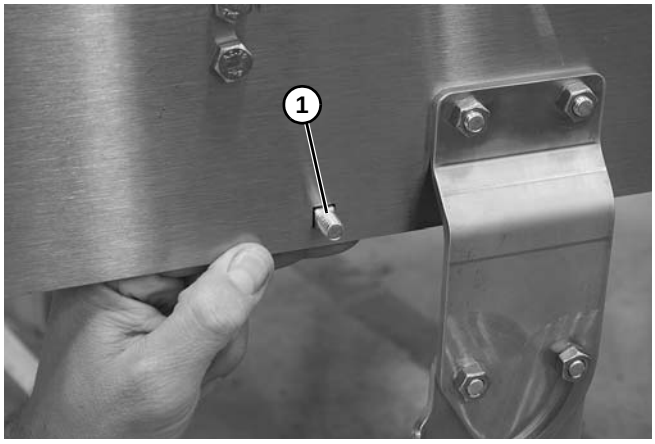



***Figure 21***

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

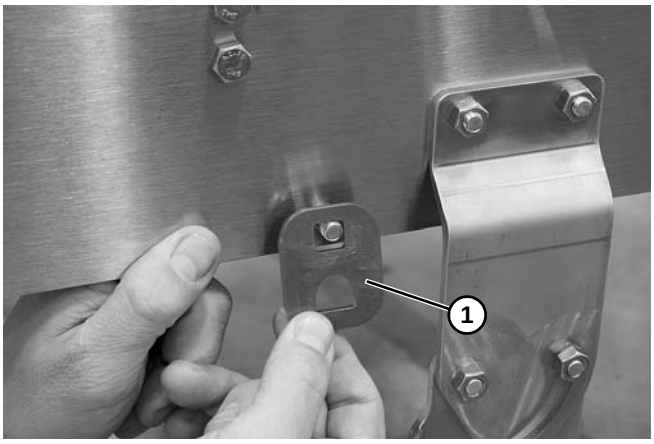



***Figure 22***

3. Install return clip **(Figure 23, item 1)** and loosley secure with nut **(Figure 23, item 2)**.

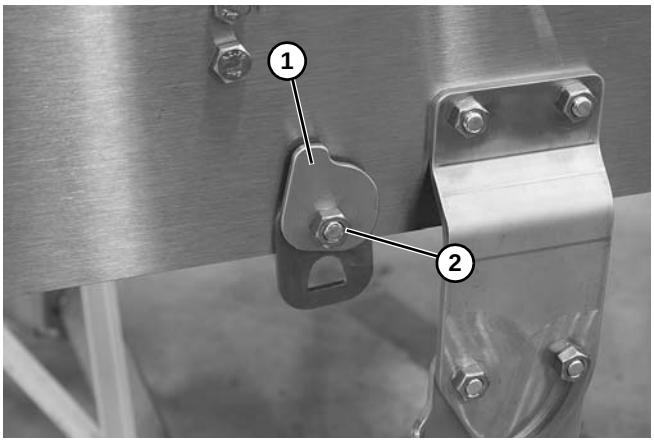



***Figure 23***

4. Repeat on the opposite side of the conveyor.
5. Install belt return assembly **(Figure 24, item 1)** onto return brackets **(Figure 24, item 2)**.

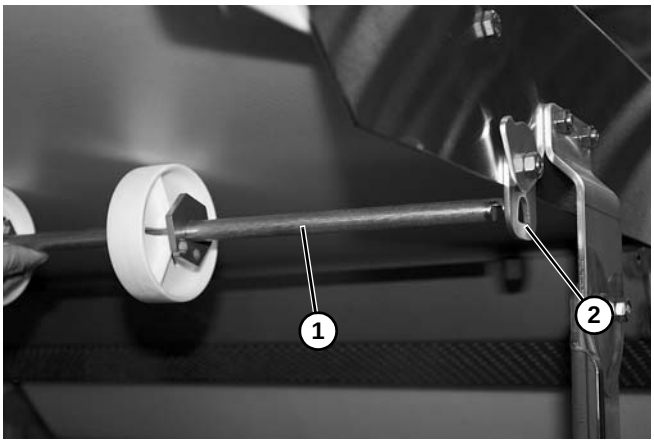



***Figure 24***

6. Rotate return clip **(Figure 25, item 1)** down against shaft **(Figure 25, item 2)** on both sides of conveyor. Tighten nuts **(Figure 25, item 3)**.

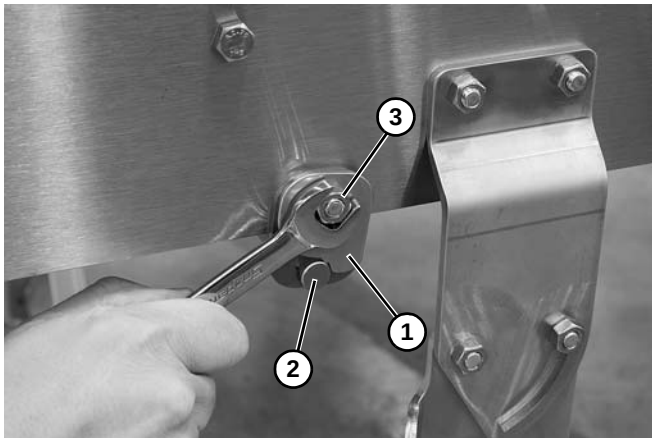



***Figure 25***

## Cleated Belt and Flat Belt Returns Under 610 mm Wide

Typical cleated return components **(Figure 26)**.

| | |
|---|---|
| 1 | Spacer |
| 2 | Puck |
| 3 | Stub Shaft |
| 4 | Hex Nut |
| 5 | Return Clip |
| 6 | Return Bracket |
| 7 | Carriage Bolt |

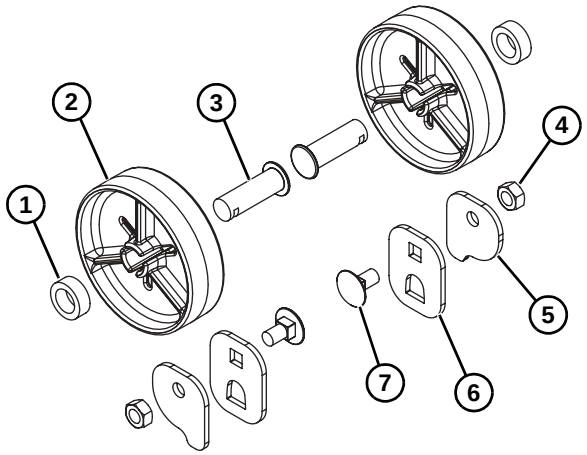



***Figure 26***

1. Install carriage bolt **(Figure 27, item 1)** through frame rail.

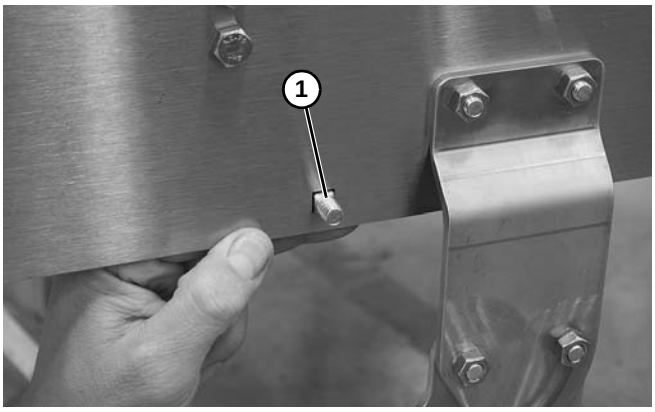



***Figure 27***

2. Install return bracket **(Figure 28, item 1)**.

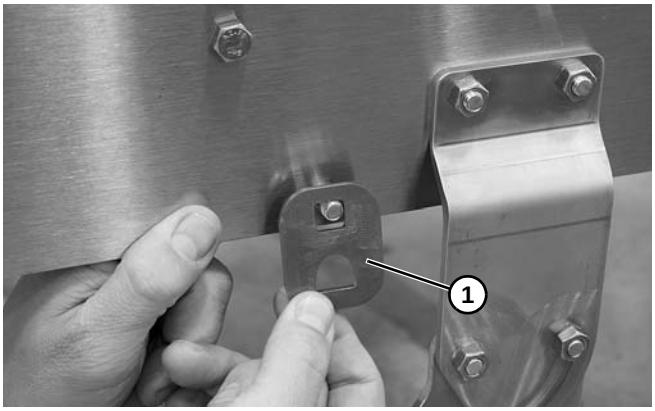



***Figure 28***

3. Install return clip **(Figure 29, item 1)** and loosley secure with nut **(Figure 29, item 2)**.

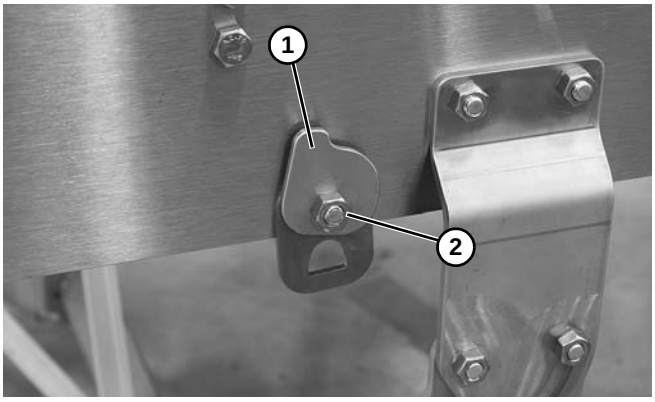



***Figure 29***

4. Repeat on the opposite side of the conveyor.

5. Install each puck **(Figure 30, item 1)** onto return bracket **(Figure 30, item 2)** with stub shaft **(Figure 30, item 3)** and spacer **(Figure 30, item 4)**.

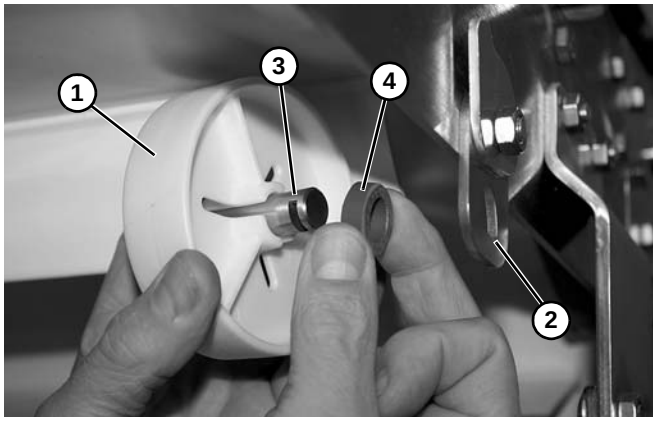



***Figure 30***

6. Rotate return clip **(Figure 31, item 1)** down against shaft **(Figure 31, item 2)** on both sides of conveyor. Tighten nuts **(Figure 31, item 3)**.

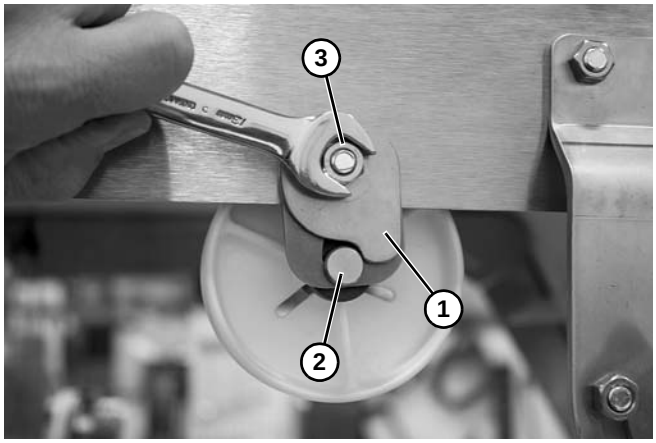



***Figure 31***

# Installation

## Guide Installation

### High Side Guides

1. Remove and discard the top bolt **(Figure 32, item 1)** from the conveyor side.

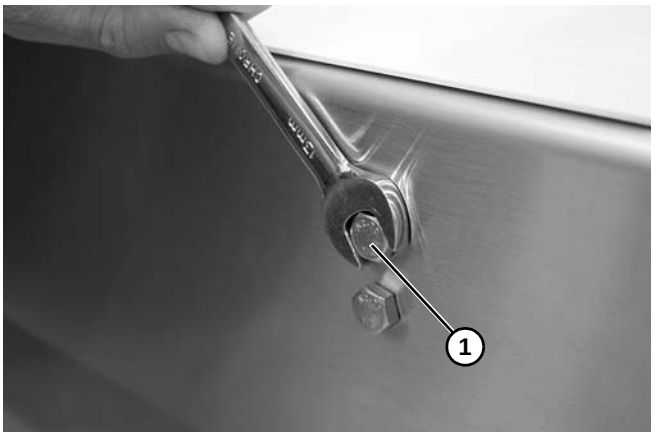



***Figure 32***

2. Assemble the mounting block **(Figure 33, item 1)** to the conveyor side with the bolt **(Figure 33, item 2)** provided with the mounting block.

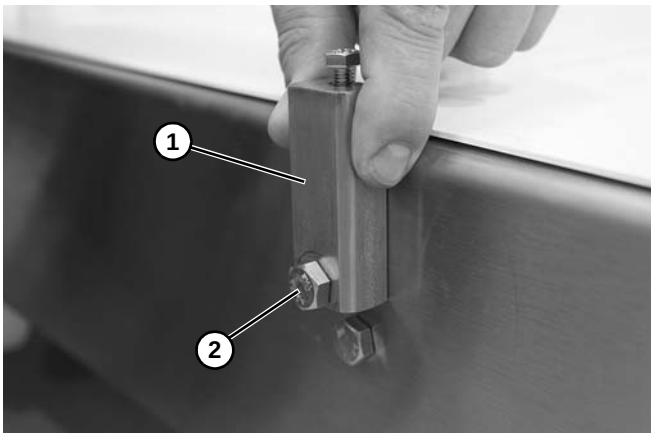



***Figure 33***

3. Install guide **(Figure 34, item 1)** into the slot **(Figure 34, item 2)** of the mounting block and tighten bolts **(Figure 34, item 3)**.

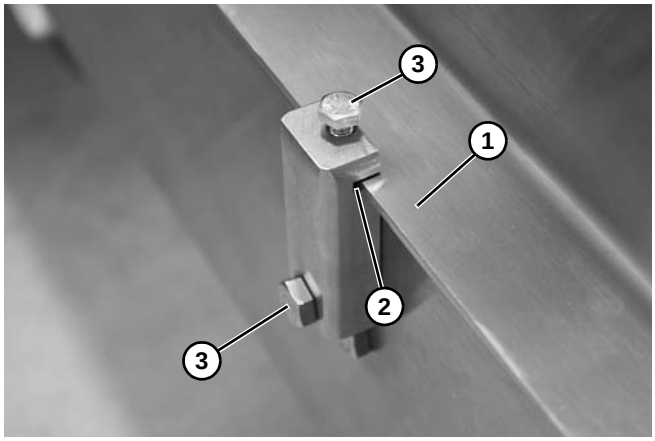



***Figure 34***

4. Install the connecting plate **(Figure 35, item 1)** over the studs.

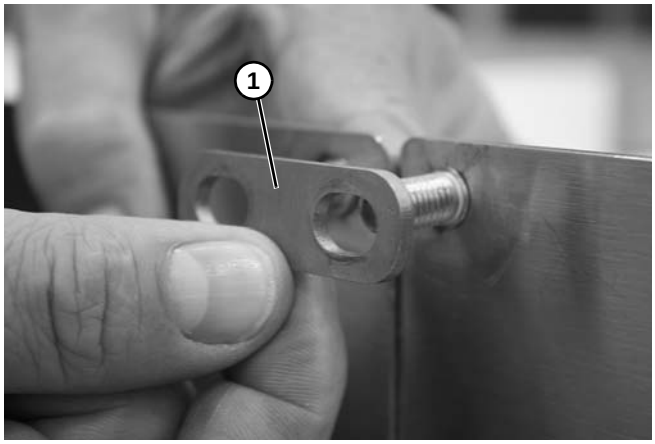



***Figure 35***

5. Install nuts **(Figure 36, item 1)** and tighten.

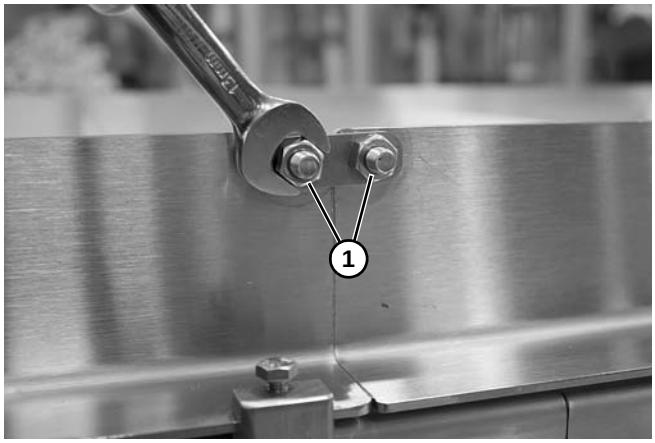



***Figure 36***

## Adjustable Guides

1. Remove the top bolt **(Figure 37, item 1)** and loosen the bottom bolt **(Figure 37, item 2)**.

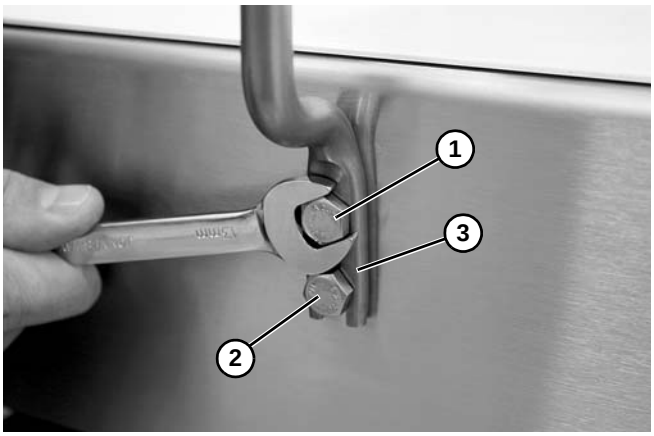



***Figure 37***

2. Install the guide post **(Figure 37, item 3)** behind lower bolt. Reinstall top bolt and tighten bolts.
3. Install guide rail **(Figure 38, item 1)** into rail clamp. Tighten fastener to secure **(Figure 38, item 2)**.

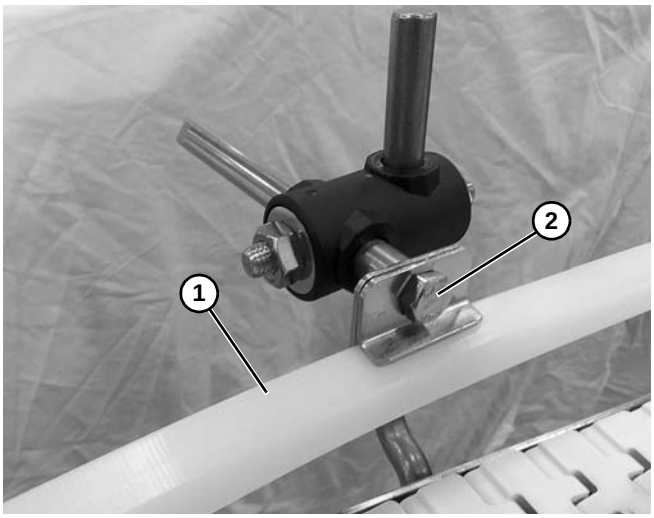



***Figure 38***

| NOTE |
| --- |
| *See pages 66 to 69 for detailed view of guide assembly.* |

## Drive Package Installation

For detailed assembly instructions, refer to the appropriate drive package manual:

- 851-881 7350 Series Version 2 Side Mount Drives
- 851-883 7350 Series Version 2 Bottom Mount Drives
- 851-884 7350 Series Version 2 Center Drives

1. Attach the motor **(Figure 39, item 1)** to the gear reducer **(Figure 39, item 2)**.

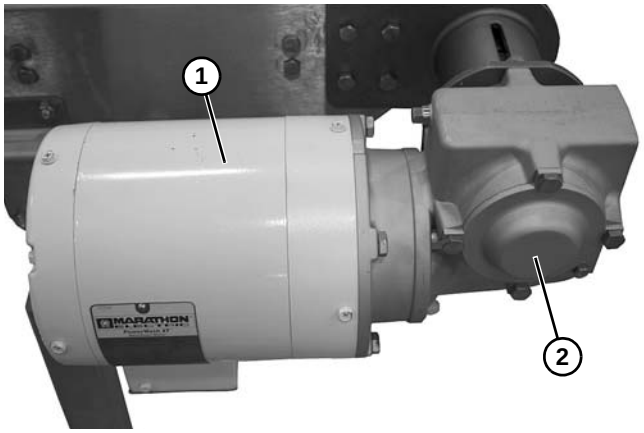



***Figure 39***

# Preventive Maintenance and Adjustment

## Required Tools

- 1/8" hex wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 10 mm hex wrench
- 13 mm hex wrench

## Checklist

- Keep critical service parts on hand. Refer to the "Service Parts" section starting on page 44 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

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 40, item 1)** when required.

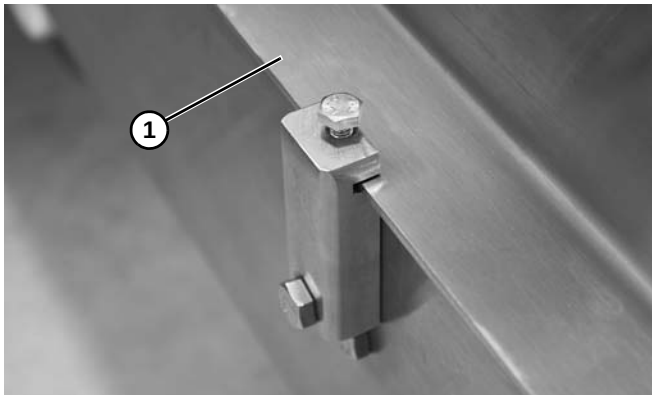



***Figure 40***

2. Remove belt returns:

   a. For flat returns 610 mm wide and wider, refer to "Flat Belt Returns 610 mm Wide and Wider" on page 41. Follow steps 1 and 2.

   b. For cleated returns and flat returns under 610 mm wide, refer to "Cleated Belt and Flat Belt Returns Under 610 mm Wide" on page 42. Follow steps 1 and 2.

**⚠ WARNING**

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

**PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.**

3. Place temporary support stands **(Figure 41, item 1)** at both ends of the conveyor. Place an additional support stand **(Figure 41, item 2)** under the drive motor, if equipped. See WARNING.

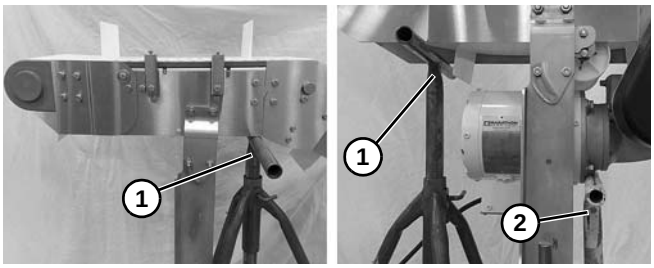



*Figure 41*

4. Remove fasteners **(Figure 42, item 1)** securing the stand brackets from one side of the conveyor and remove brackets.

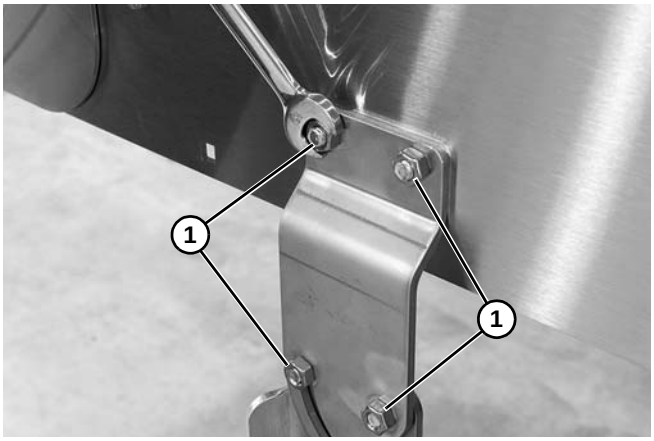



*Figure 42*

5. Rotate idler end **(Figure 43, item 1)** upward as shown.

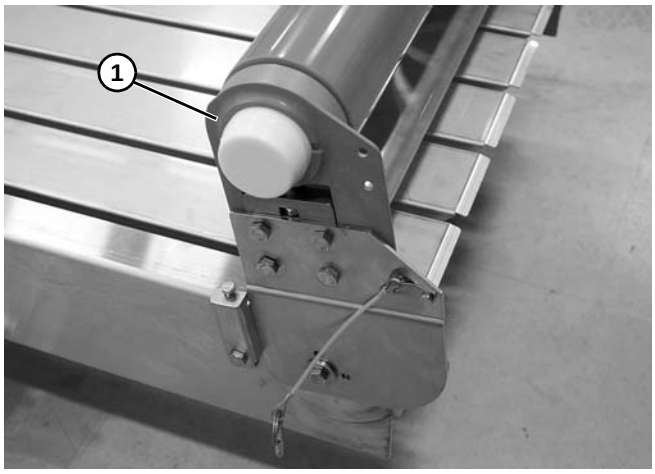



*Figure 43*

6. Remove the belt **(Figure 44, item 1)** from the conveyor **(Figure 44, item 2)**.

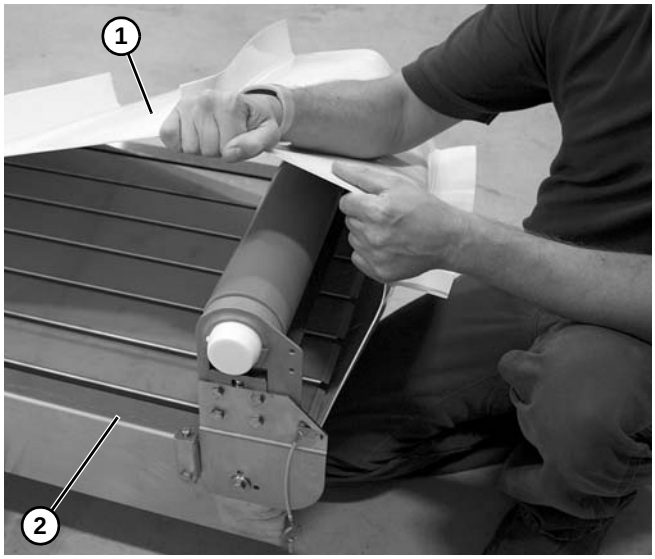



*Figure 44*

7. Repeat procedure for the opposite end of the conveyor to fully remove the belt.
8. Replace the belt. Refer to "Belt Installation" on page 12.

## Center Drive Conveyor Belt Replacement

**WARNING**

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

**WARNING**

**Exposed moving parts can cause severe injury.**
**REMOVE COMPRESSED AIR SUPPLY before removing guards or performing maintenance.**

### Belt Removal

1. Remove guides **(Figure 45, item 1)** when required.

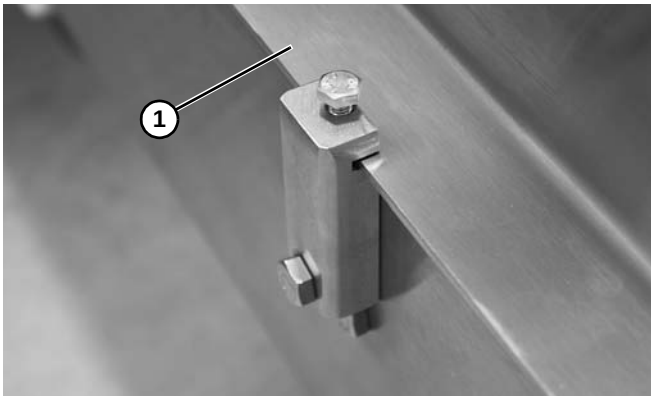



***Figure 45***

2. Remove belt returns:
   a. For flat returns 610 mm wide and wider, refer to "Flat Belt Returns 610 mm Wide and Wider" on page 41. Follow steps 1 and 2.
   b. For flat returns under 610 mm wide, refer to "Cleated Belt and Flat Belt Returns Under 610 mm Wide" on page 42. Follow steps 1 and 2.
3. Remove air supply and remove hose **(Figure 46, item 1)** from the center drive.

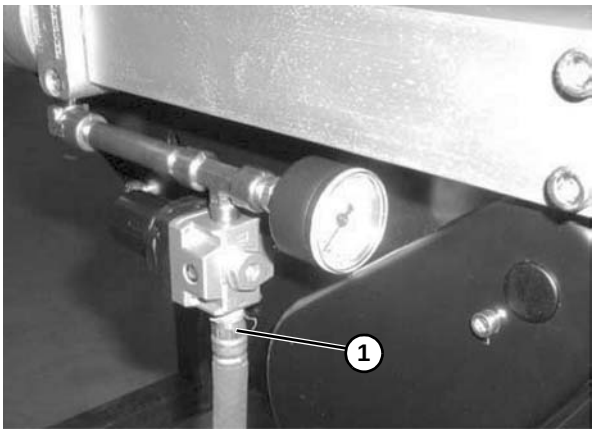



***Figure 46***

4. Tip up tail **(Figure 47, item 1)**.

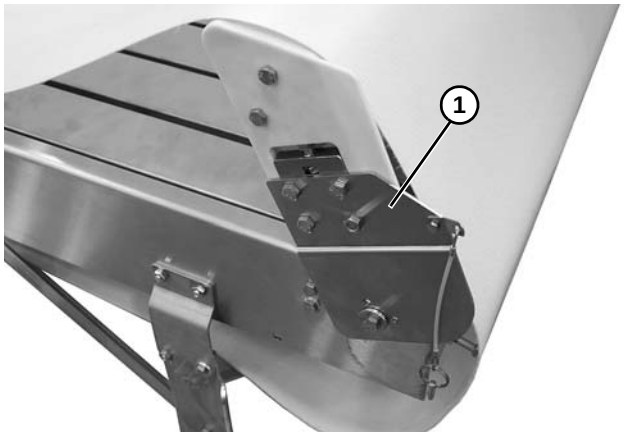



***Figure 47***

5. Rotate tension nut **(Figure 48, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

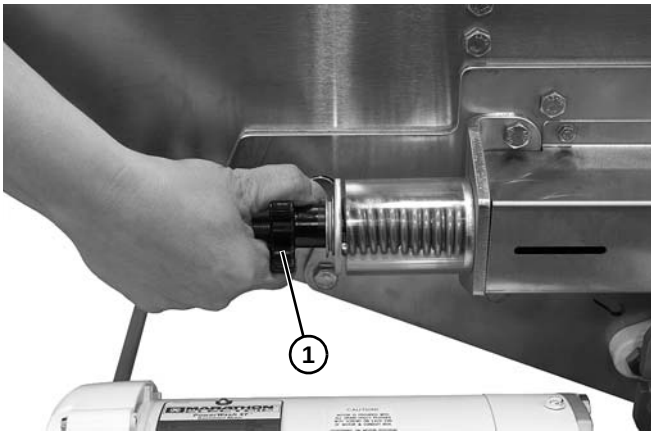



*Figure 48*

6. Remove four screws **(Figure 49, item 1)** and cover **(Figure 49, item 1)**.

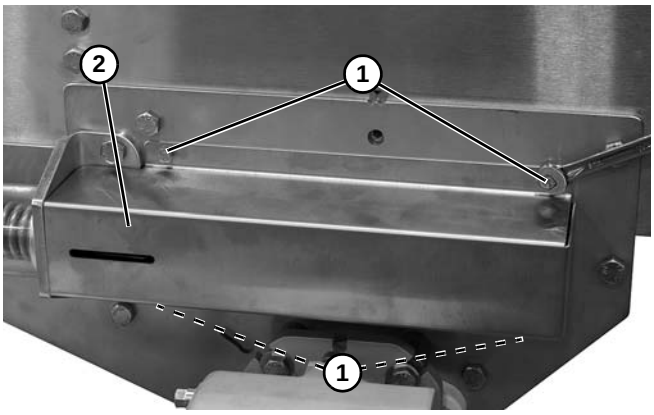



*Figure 49*

7. Remove two bolts **(Figure 50, item 1)** from each side of the center drive. Remove the stationary guard assembly **(Figure 50, item 2)**.

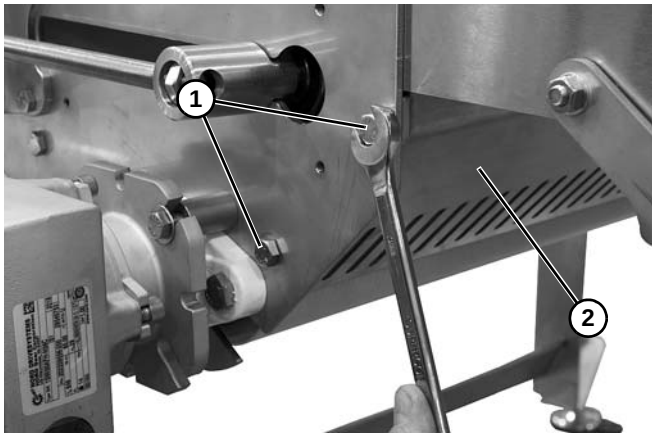



*Figure 50*

8. Remove bolt **(Figure 51, item 1)** from each side of the center drive from the idler guard assembly.

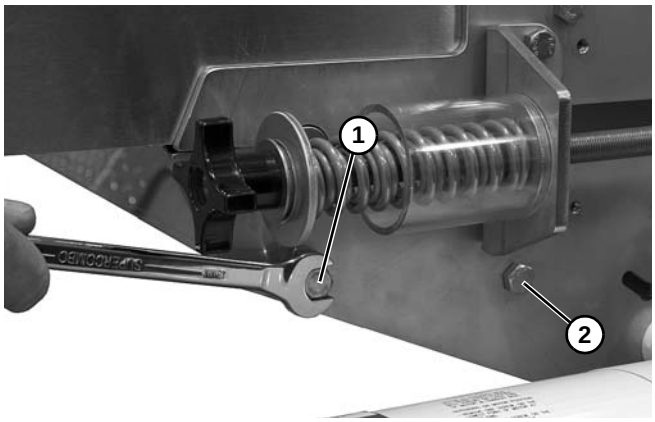



*Figure 51*

9. Loosen bolt **(Figure 51, item 2)** on each side of the center drive.

10. Swing idler guard assembly **(Figure 52, item 1)** down. Remove the idler pulley **(Figure 52, item 2)**.

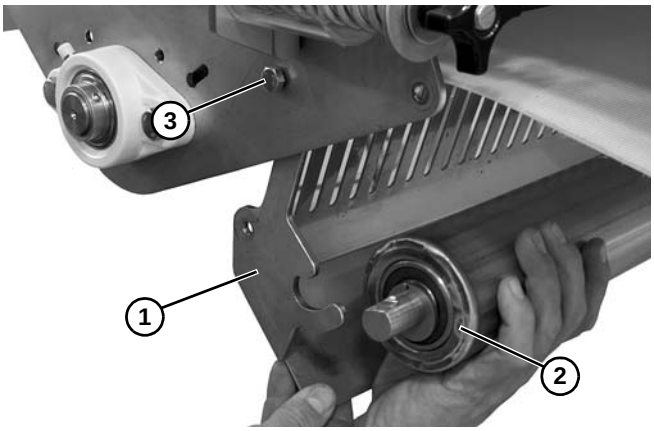



***Figure 52***

11. Remove bolt **(Figure 52, item 3)** from each side of the center drive. Remove the idler guard assembly **(Figure 52, item 1)**.
12. Loosen tension nut **(Figure 53, item 1)** on each side of the center drive so that the tension pulley spacer **(Figure 53, item 2)** aligns with hole **(Figure 53, item 3)**.

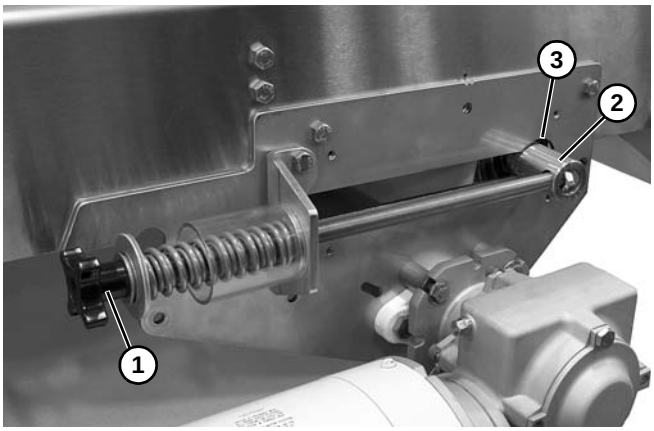



***Figure 53***

13. Remove two bolts **(Figure 54, item 1)** from plate **(Figure 54, item 2)** on both sides of the center drive.

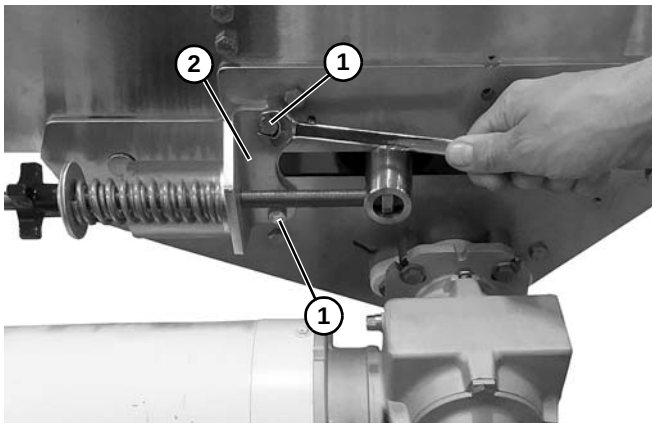



***Figure 54***

14. Remove tension assembly **(Figure 55, item 1)** on both sides of the center drive.

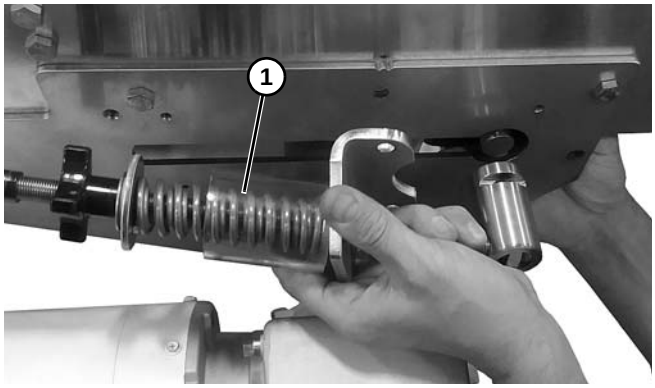



***Figure 55***

15. Slide shaft **(Figure 56, item 1)** into the tensioner pulley **(Figure 56, item 2)**. Remove the tensioner pulley**.**

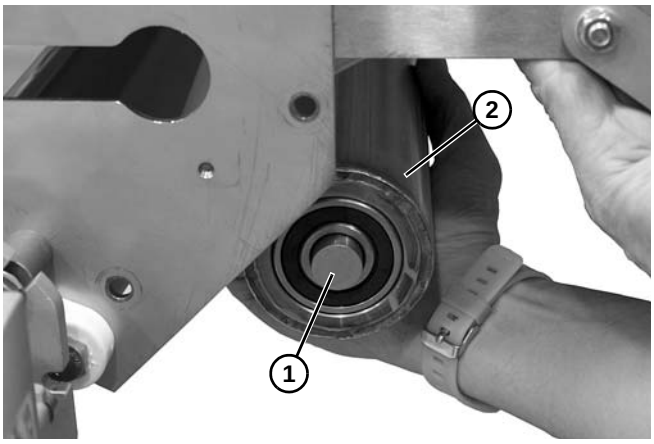



***Figure 56***

16. Remove belt **(Figure 57, item 1)** from center drive module **(Figure 57, item 2)**.

**⚠ WARNING**

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

**PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.**

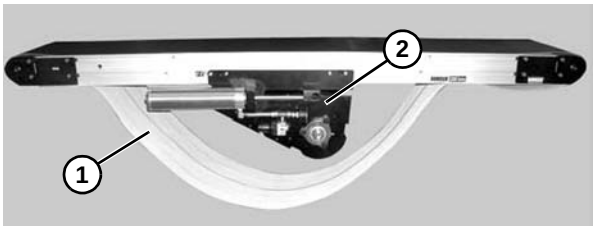



***Figure 57***

17. Place temporary support stands at both ends of the conveyor. See WARNING.

18. Remove fasteners **(Figure 58, item 1)** securing the stand brackets from one side of the conveyor and remove brackets.

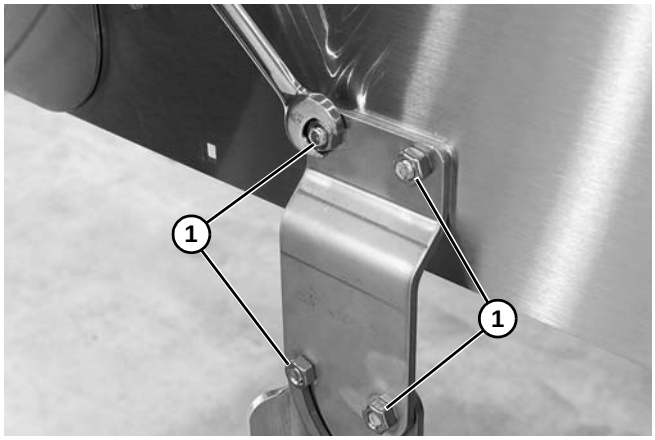



***Figure 58***

19. Repeat procedure for the opposite end of conveyor.
20. Remove the belt from under the stand **(Figure 59, item 1)** and from the conveyor **(Figure 59, item 2)** on both ends.

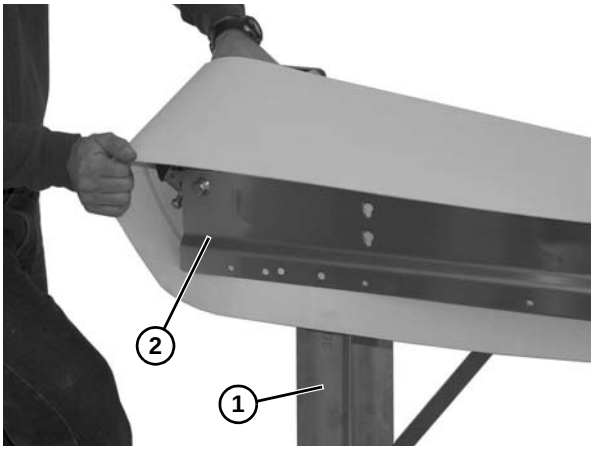



***Figure 59***

21. Replace the old belt with a new one.

## Belt Installation

**⚠ WARNING**

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

**PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.**

1. Ensure that temporary support stands are placed at both ends of the conveyor. See WARNING.
2. Orient belt so splice leading fingers **(Figure 60, item 1)** point in the direction of belt travel as identified by the conveyor directional label **(Figure 60, item 2)**.

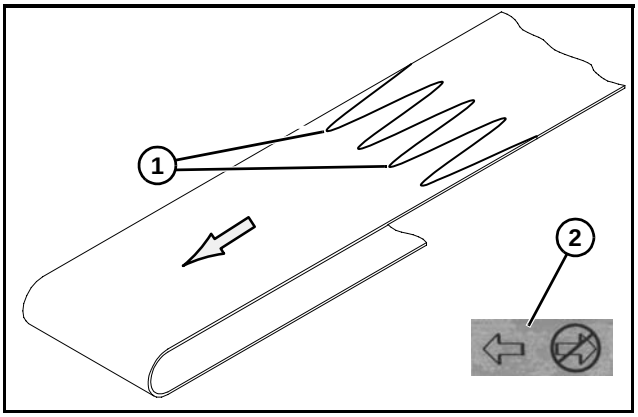



***Figure 60***

3. Install belt **(Figure 61, item 1)** on conveyor. Lift conveyor **(Figure 61, item 2)** slightly to avoid pinching belt on temporary support stands.

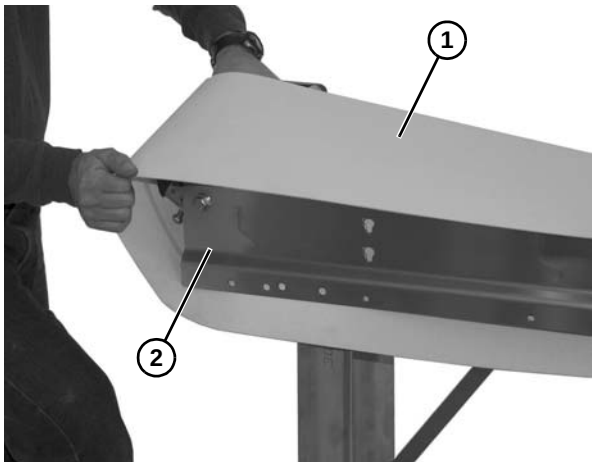



***Figure 61***

4. Reverse steps 1 thru 14 of the Center Drive "Belt Removal" on page 20".
5. If equipped, reinstall guiding.
6. Reattach air supply **(Figure 62, item 1)** to center drive. Refer to "Center Drive Conveyor Belt Tensioning" on page 25" for more information.

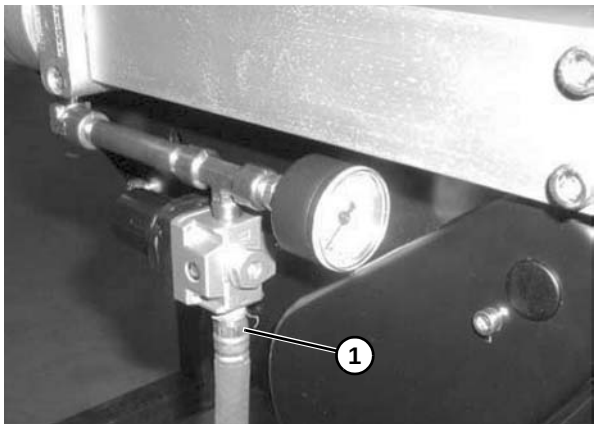



***Figure 62***

7. Track drive and conveyor if required. See "Center Drive Module Tracking" on page 27 and "Conveyor Belt Tracking" on page 27".

## 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 63, item 1)** on each side to take up tension. Align the same arrows **(Figure 63, item 2)** and marks **(Figure 63, item 3)** on each side of the conveyor to keep the tail straight.

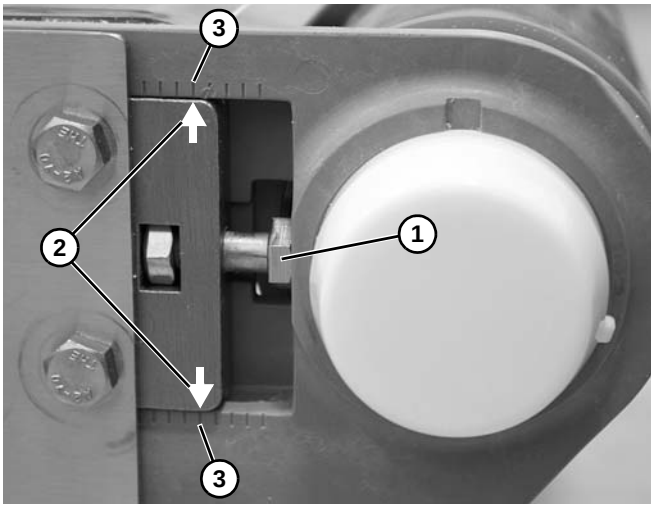



*Figure 63*

## Center Drive Conveyor Belt Tensioning

**WARNING**

**SEVERE HAZARD!**

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

### A - With Pneumatic Tensioning

1. Connect air supply **(Figure 64, item 1)** to regulator **(Figure 64, item 2)**.
2. Adjust regulator knob **(Figure 64, item 3)** until gauge reads the appropriate pressure. Adjust regulator starting at 15 psi, raising the pressure to keep the belt from slipping up to the maximum shown in the following table.

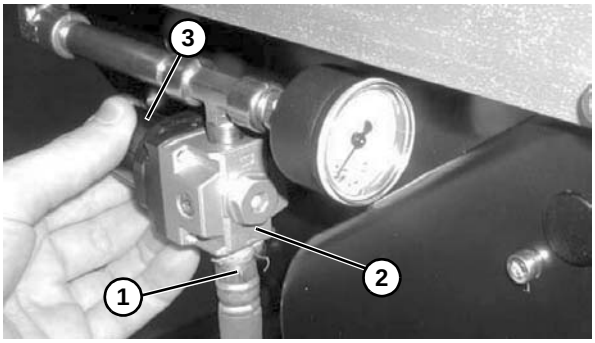



*Figure 64*

| Suggested Maximum Tensioning Air Pressure for Center Drive Conveyors | |
|---|---|
| **Width** | **Pressure** |
| 6" (152 mm) | 30 psi (207 kPa) |
| 8" (203 mm) | 40 psi (276 kPa) |
| 10" (254 mm) | 50 psi (345 kPa) |
| 14" (356 mm) | 60 psi (414 kPa) |
| 18" (457 mm) | 70 psi (483 kPa) |
| 24" (610 mm) & wider | 80 psi (552 kPa) |

3. If proper belt tension cannot be achieved before the out of tension indicator **(Figure 65, item 1)** begins to turn red, the belt must be replaced.

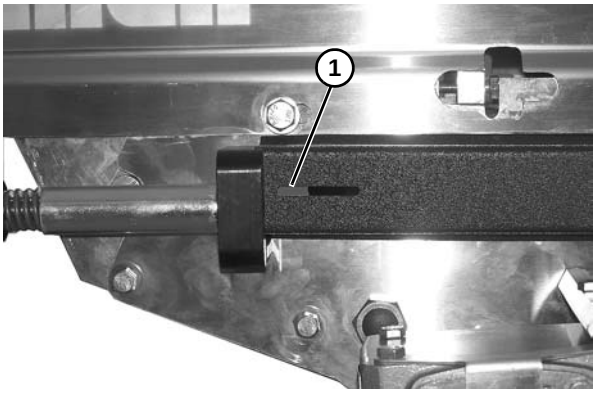



***Figure 65***

4. If belt tracking is necessary, refer to “Conveyor Belt Tracking” on page 27 and “Center Drive Module Tracking” on page 27.

## B - With Manual Tensioning

**⚠ WARNING**

**Threaded rod end may be sharp. Cover with guard while adjusting tension knob.**

**HANDLE WITH CARE.**

1. Turn knob **(Figure 66, item 1)** on each side of the center drive clockwise until the tensioning spring **(Figure 66, item 2)** is completely behind the spring cover **(Figure 66, item 3)**. There should be approximately a 1/8" gap **(Figure 67, item 1)** between knob and spring cover.

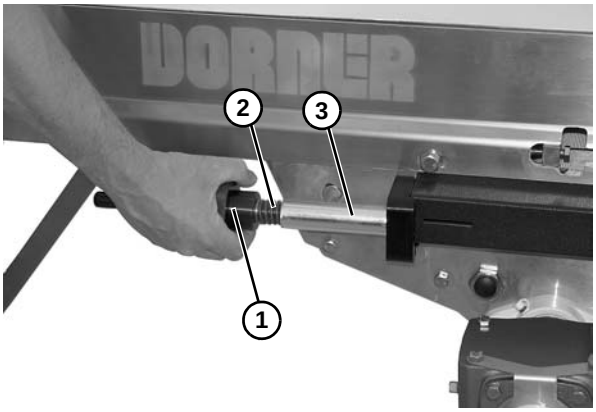



***Figure 66***

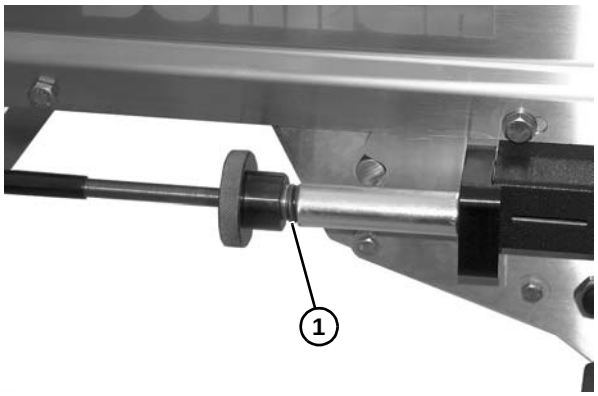



***Figure 67***

2. As normal belt stretch occurs over time, the spring **(Figure 66, item 2)** will be exposed out of the spring cover **(Figure 66, item 3)**. When the spring is exposed over 1/2", or if conveyor belt slippage occurs, retighten knob **(Figure 66, item 1)** on each side of the center drive clockwise until tensioning spring is completely behind the spring cover.
3. If proper belt tension cannot be achieved before the out of tension indicator **(Figure 65, item 1)** begins to turn red, the belt must be replaced.
4. If belt tracking is necessary, refer to “Conveyor Belt Tracking” on page 27 and “Center Drive Module Tracking” on page 27.

## Conveyor Belt Tracking

1. Tighten or loosen bolts **(Figure 68, item 1)** on each side to correct tracking. Align the same arrows **(Figure 68, item 2)** and marks **(Figure 68, item 3)** on each side of the conveyor as a starting point for tracking the belt.

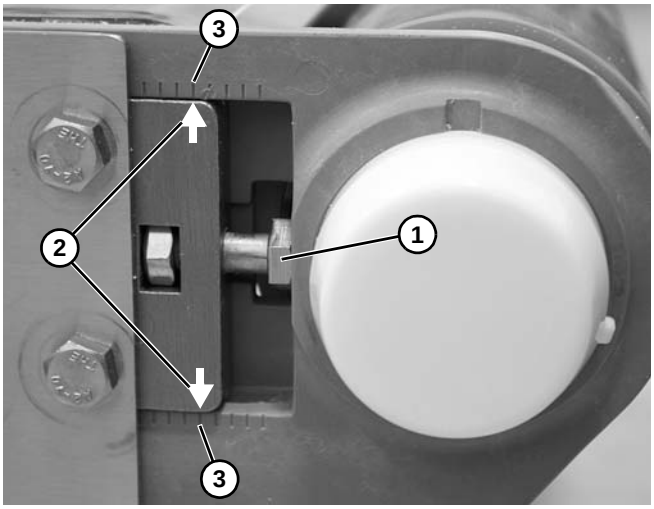



*Figure 68*

## Center Drive Module Tracking

### V-Guided Belts

V-guided belts do not require tracking adjustment.

### Non V-Guided Belts

Non V-guided belt center drives are equipped with tracking bolts.

Non V-guided belt center drives are equipped with tracking cams. Adjust center drive tracking with the conveyor running.

1. Inspect belt as it exits the center drive:
   a. Belt tracking normally, no adjustment required.
   b. If the belt is not tracking normally, adjust the cam on the side where the belt is running tight.
2. If necessary, loosen the center drive fastening bolts **(Figure 69, item 1)** on the side of the center drive that requires adjustment.

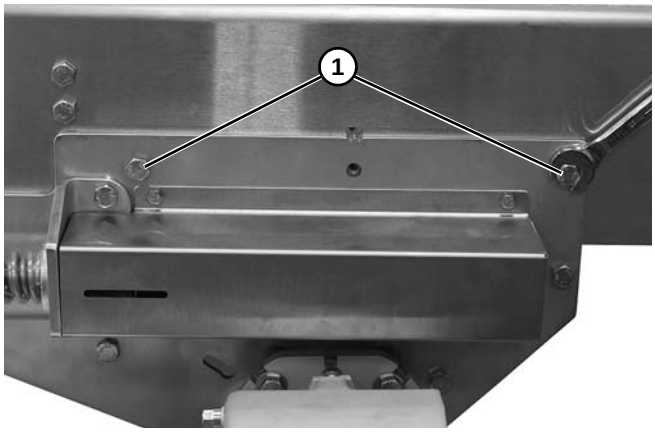



*Figure 69*

3. Rotate the tracking cam **(Figure 70, item 1)** left or right in small increments. After each adjustment, watch the belt as it exits the center drive. Continue to rotate the tracking cam until the conveyor belt is tracking normally.

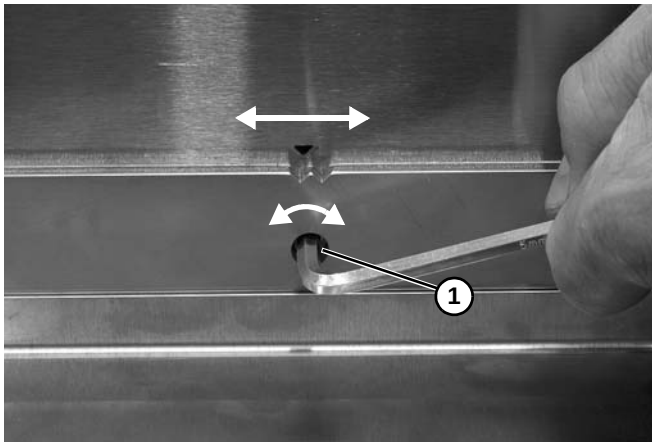



*Figure 70*

4. Tighten the center drive fastening bolts **(Figure 69, item 1)** to 146 in–lbs (16.5 N.m).

## Drive Spindle Replacement

**⚠ WARNING**

**SEVERE HAZARD!**

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

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 18.
3. Remove two headplate bolts **(Figure 71, item 1)**. Repeat on opposite side of the conveyor.

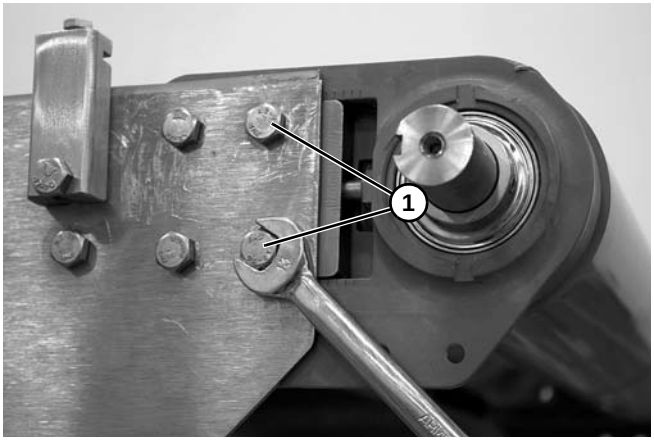



***Figure 71***

4. Slide the drive spindle assembly **(Figure 72, item 1)** off the drive tail blocks **(Figure 72, item 2)**.

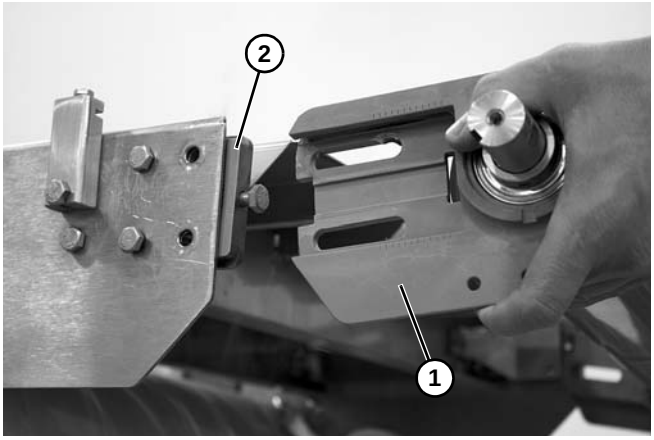



***Figure 72***

5. Remove the bearing cover **(Figure 73, item 1)**.

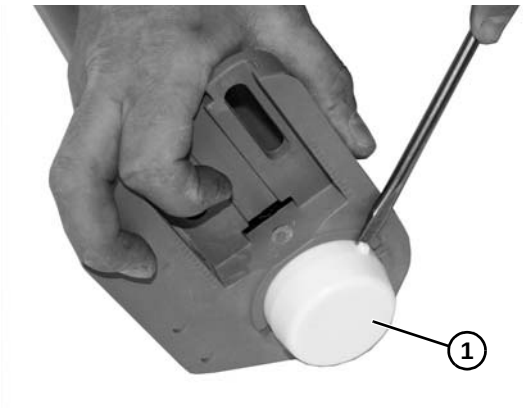



***Figure 73***

6. Loosen two set screws **(Figure 74, item 1)**.

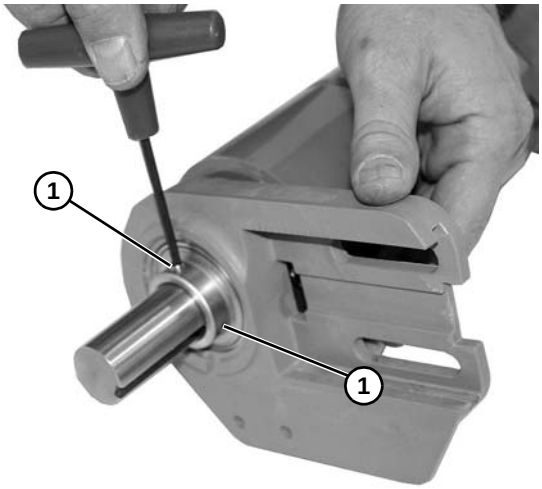



***Figure 74***

7. Slide the headplate with bearing **(Figure 75, item 1)** off the shaft **(Figure 75, item 2)**.

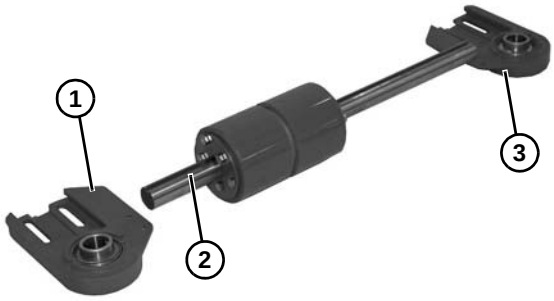



***Figure 75***

8. Repeat for opposite side headplate **(Figure 75, item 3)**.
9. If necessary, refer to “Bearing Replacement” on page 36 for replacing bearing in each headplate.
10. Install parts in reverse order of removal.

## Idler Spindle Replacement

**⚠ WARNING**

**SEVERE HAZARD!**

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

1. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 18.

**⚠ CAUTION**

**Support bracket (Figure 76, item 2) will not be attached and could fall.**

2. Remove two headplate bolts **(Figure 76, item 1)**. Repeat on opposite side of the conveyor.

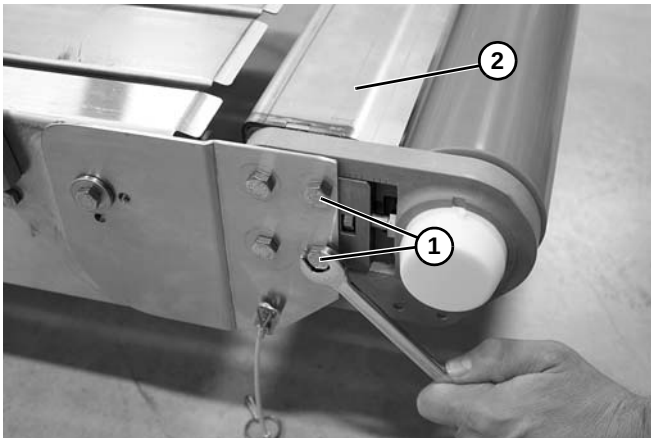



***Figure 76***

3. Remove support bracket **(Figure 77, item 1)**.

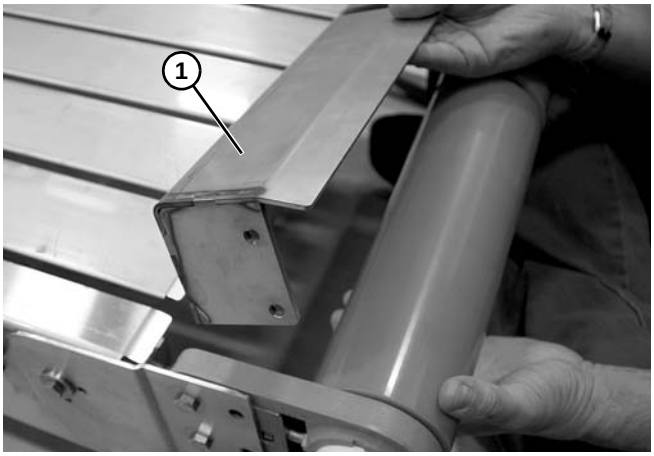



***Figure 77***

4. Slide the idler spindle assembly **(Figure 78, item 1)** off the pivot tail blocks **(Figure 78, item 2)**.

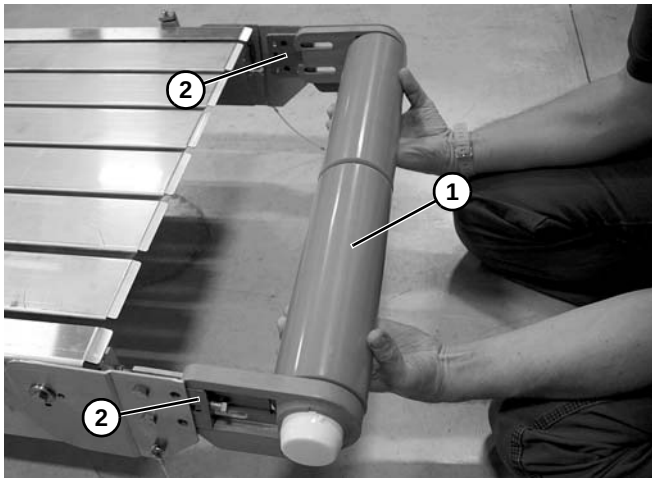



***Figure 78***

5. Remove the bearing cover **(Figure 79, item 1)**. Repeat on opposite side.

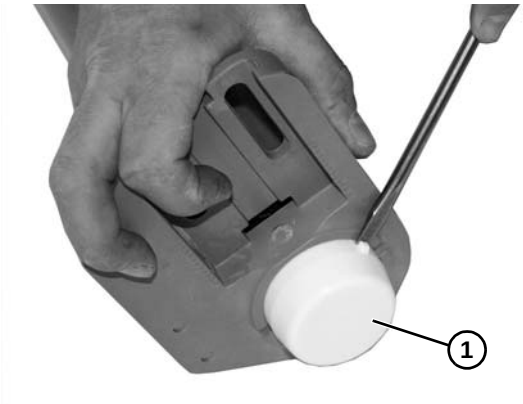



***Figure 79***

6. Loosen two set screws **(Figure 80, item 1)**.

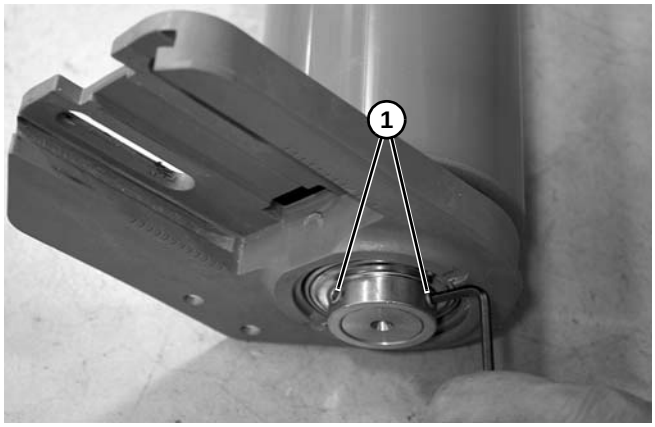



***Figure 80***

7. Slide the headplate with bearing **(Figure 81, item 1)** off the shaft **(Figure 81, item 2)**.

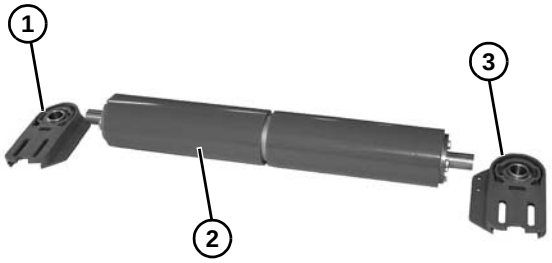



***Figure 81***

8. Repeat for opposite side headplate **(Figure 81, item 3)**.
9. If necessary, refer to "Bearing Replacement" on page 36 for replacing bearing in each headplate.
10. Install parts in reverse order of removal.
11. Check level of idler tail by placing a level **(Figure 82, item 1)** on top of bed rail and support bracket.

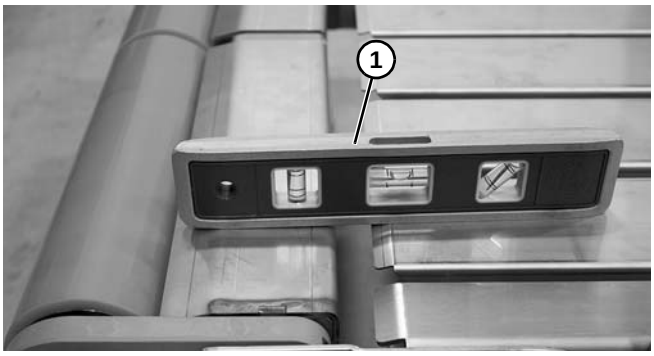



***Figure 82***

12. If needed, raise idler tail and loosen nut **(Figure 83, item 1)**. Tighten or loosen bolt **(Figure 83, item 2)** to move idler tail up or down to level with conveyor bed rail. Ensure that nuts are tight after leveling.

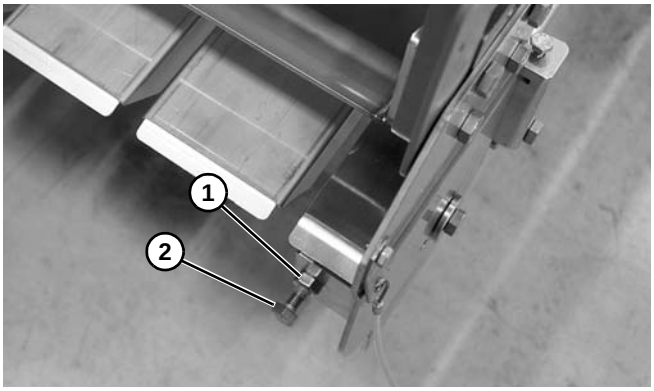



***Figure 83***

## Nose Bar Idler Spindle Replacement

**⚠ WARNING**

**SEVERE HAZARD!**

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

1. Remove conveyor belt. Refer to "Conveyor Belt Replacement" on page 18.
2. Slide the nose bar idler **(Figure 84, item 1)** off the pivot tail blocks **(Figure 84, item 2)**.

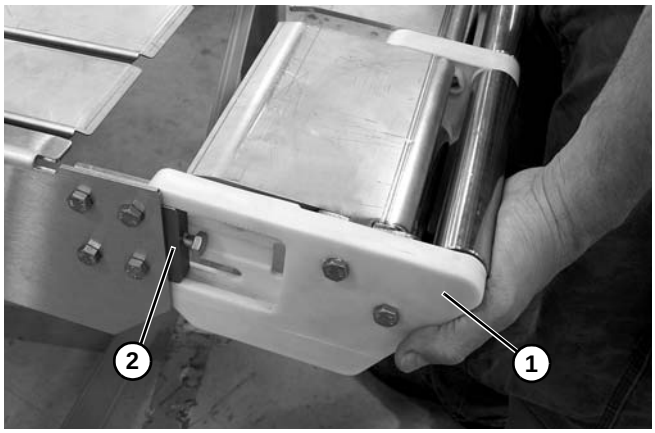



***Figure 84***

3. Remove headplate bolts **(Figure 85, item 1)**.

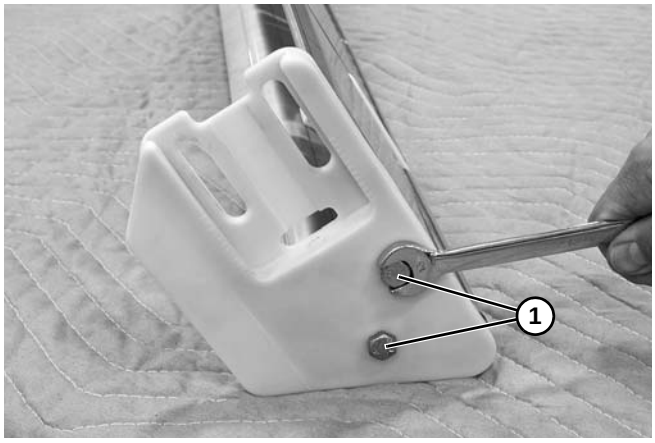



***Figure 85***

4. Slide off end plate **(Figure 86, item 1)**.

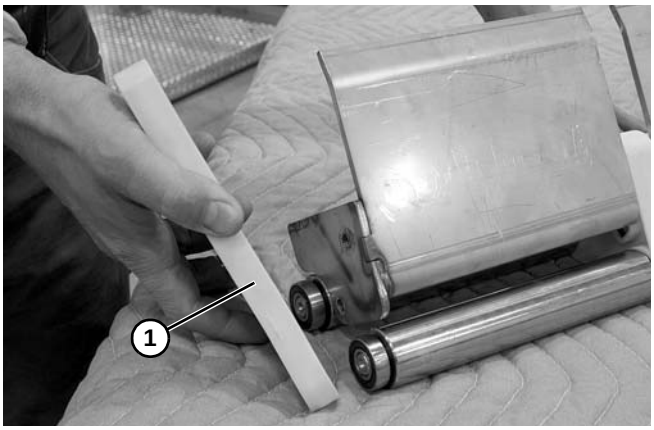



***Figure 86***

5. Remove idler roller bearing assemblies **(Figure 87, item 1)** from nose bar puck.

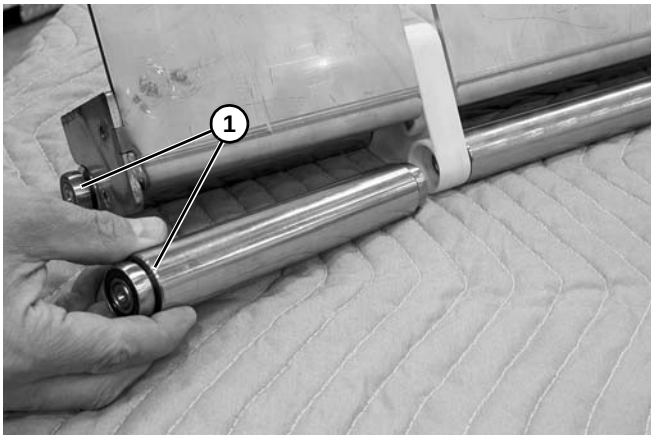



***Figure 87***

6. Remove nose bar puck **(Figure 88, item 1)**.


***Figure 88***

7. Repeat as needed.
8. Install parts in reverse order of removal.

9. For tip up tail only:

   a. Check level of idler tail by placing a level **(Figure 89, item 1)** on top of bed rail and support bracket.


***Figure 89***

   b. If needed, raise idler tail and loosen nut **(Figure 90, item 1)**. Tighten or loosen bolt **(Figure 90, item 2)** to move idler tail up or down to level with conveyor bed rail. Ensure that nuts are tight after leveling.

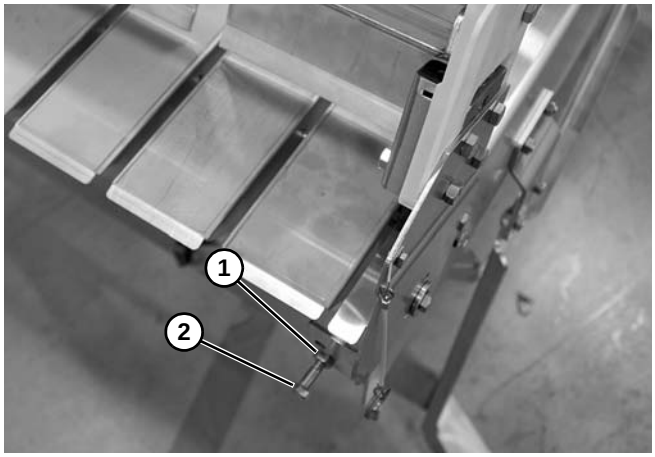



***Figure 90***

## Center Drive Pulleys Removal

**⚠ WARNING**

**SEVERE HAZARD!**

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

**⚠ WARNING**

**Exposed moving parts can cause severe injury.**

**REMOVE COMPRESSED AIR SUPPLY before removing guards or performing maintenance.**

- A – Tensioner Pulley Removal
- B – Idler Pulley Removal
- C – Drive Pulley Removal

### A – Tensioner Pulley Removal

1. Remove air supply and remove hose **(Figure 91, item 1)** from the center drive.

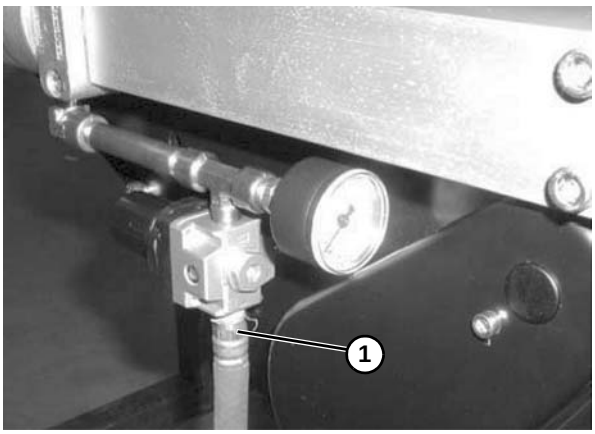



*Figure 91*

2. Tip up tail **(Figure 92, item 1)**.

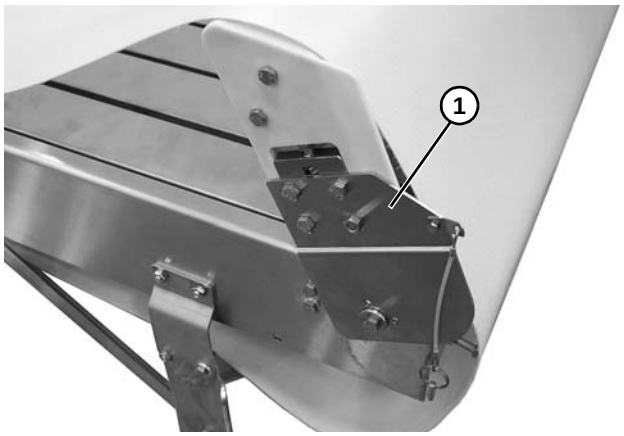



*Figure 92*

3. Rotate tension nut **(Figure 93, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

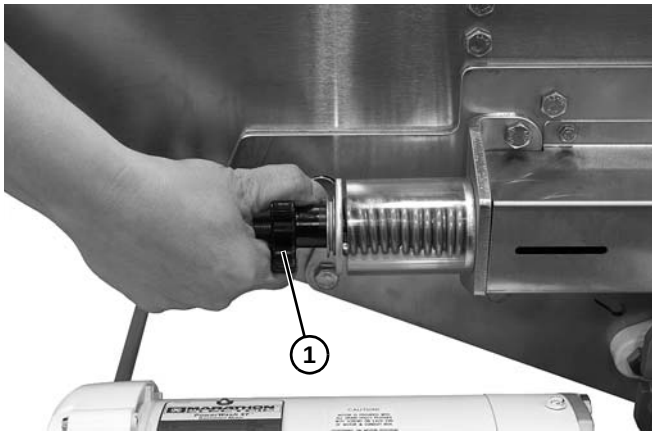



*Figure 93*

4. Remove four screws **(Figure 94, item 1)** and cover **(Figure 94, item 1)**.

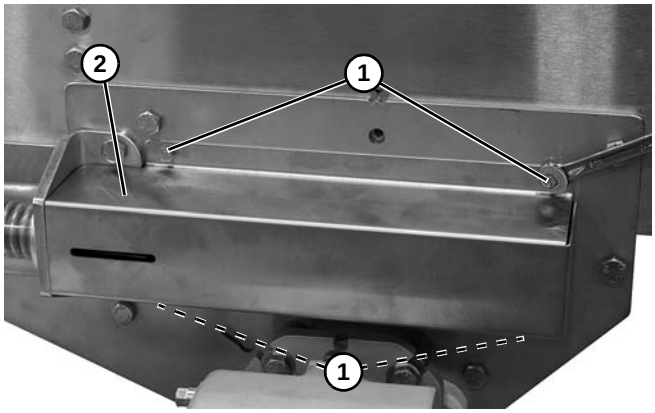



*Figure 94*

5. Remove two bolts **(Figure 95, item 1)** from each side of the center drive. Remove the stationary guard assembly **(Figure 95, item 2)**.

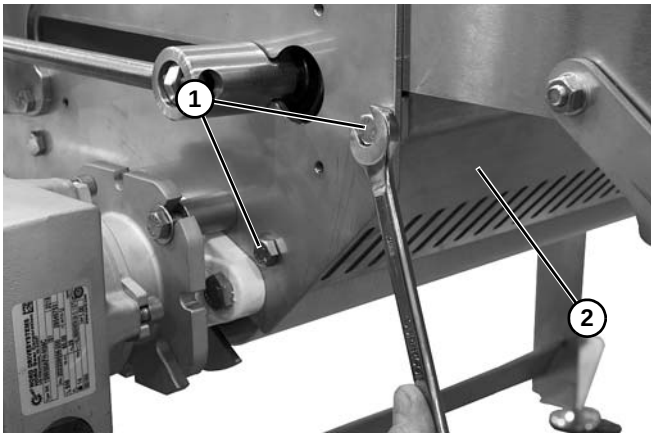



***Figure 95***

6. Loosen tension nut **(Figure 96, item 1)** on each side of the center drive so that the tension pulley spacer **(Figure 96, item 2)** aligns with hole **(Figure 96, item 3)**.

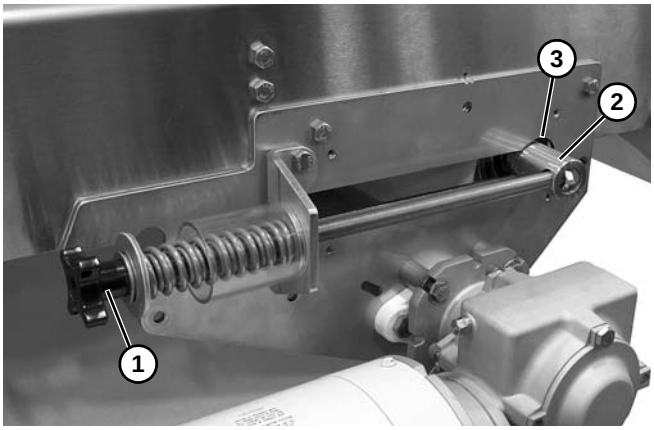



***Figure 96***

7. Remove two bolts **(Figure 97, item 1)** from plate **(Figure 97, item 2)** on both sides of the center drive.

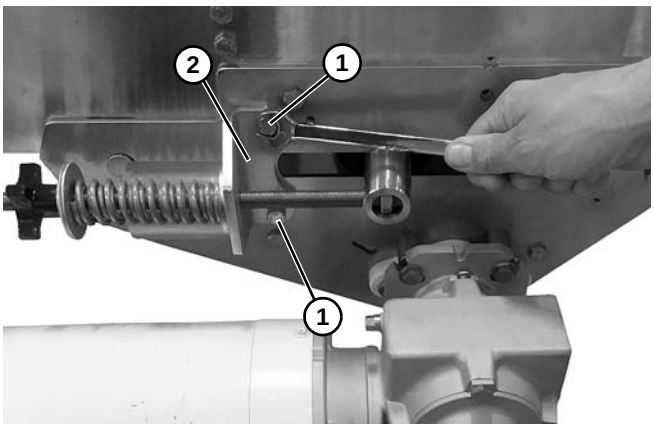



***Figure 97***

8. Remove tension assembly **(Figure 98, item 1)** on both sides of the center drive.

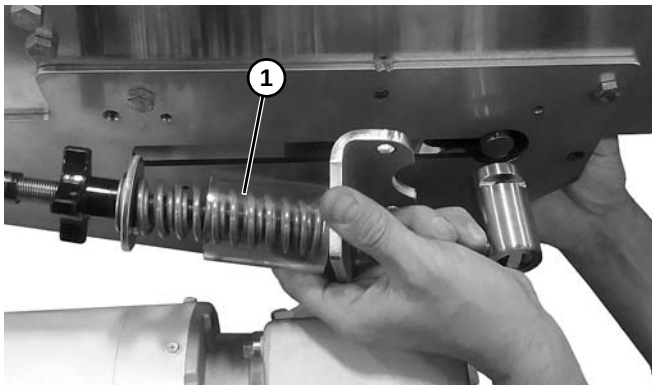



***Figure 98***

9. Slide shaft **(Figure 99, item 1)** into the tensioner pulley **(Figure 99, item 2)**. Remove the tensioner pulley**.**

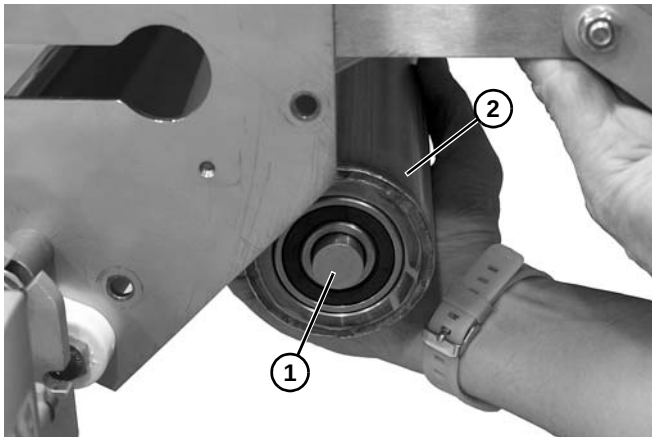



***Figure 99***

10. Remove the shaft **(Figure 100, item 1)** from the tensioner pulley **(Figure 100, item 2)**.

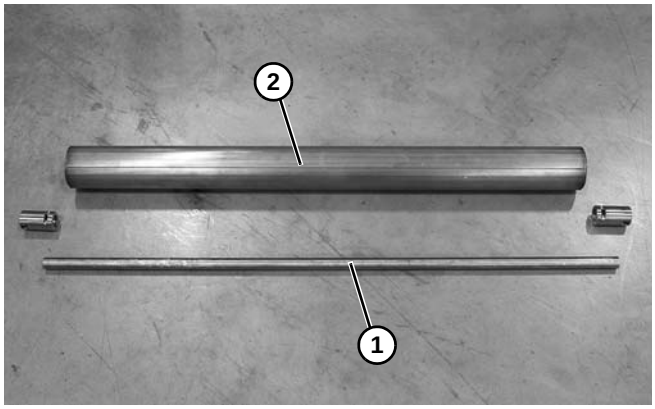



***Figure 100***

## B – Idler Pulley Removal

1. Remove air supply and remove hose **(Figure 101, item 1)** from the center drive.

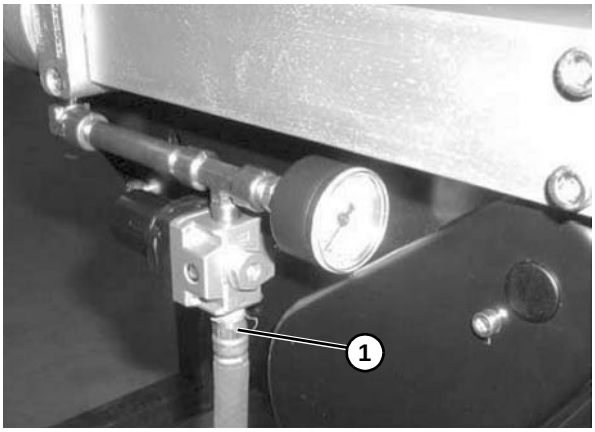



***Figure 101***

2. Rotate tension nut **(Figure 102, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

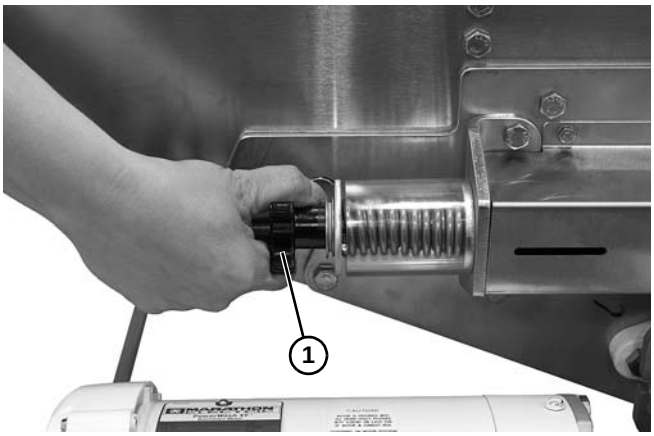



***Figure 102***

3. Remove bolt **(Figure 103, item 1)** from each side of the center drive from the idler guard assembly.

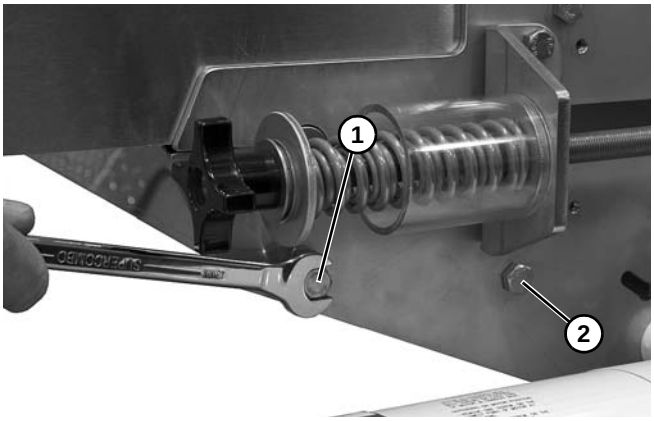



***Figure 103***

4. Loosen bolt **(Figure 103, item 2)** on each side of the center drive.
5. Swing idler guard assembly **(Figure 104, item 1)** down. Remove the idler pulley **(Figure 104, item 2)**.

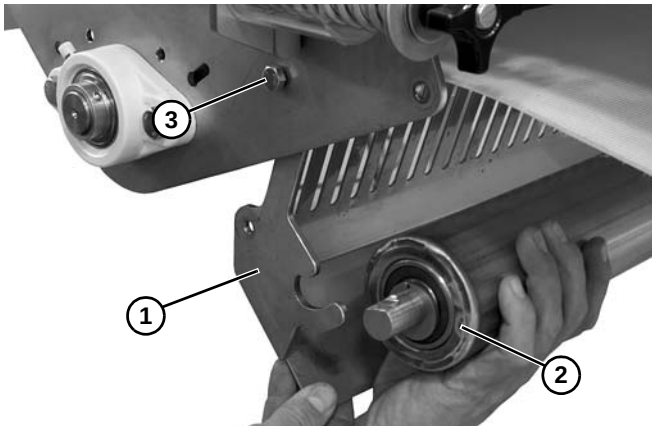



***Figure 104***

6. Remove the spacers **(Figure 105, item 1)** and shaft **(Figure 105, item 2)** from the idler pulley **(Figure 105, item 3)**.

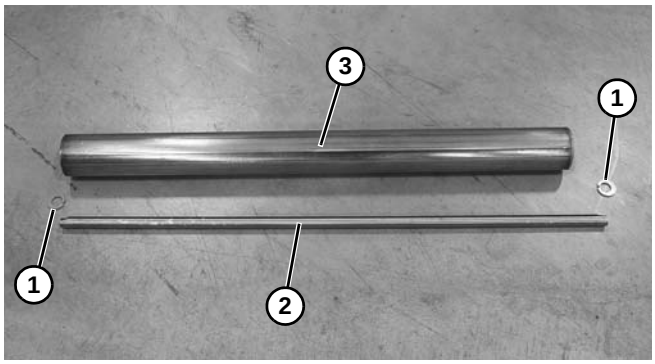



***Figure 105***

## C – Drive Pulley Removal

**⚠ WARNING**

**Drive shaft keyway may be sharp.**
**HANDLE WITH CARE.**

1. Remove air supply and remove hose **(Figure 106, item 1)** from the center drive.

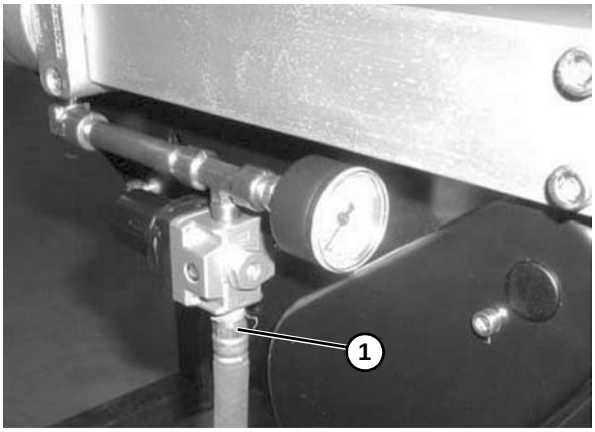



***Figure 106***

2. Rotate tension nut **(Figure 107, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

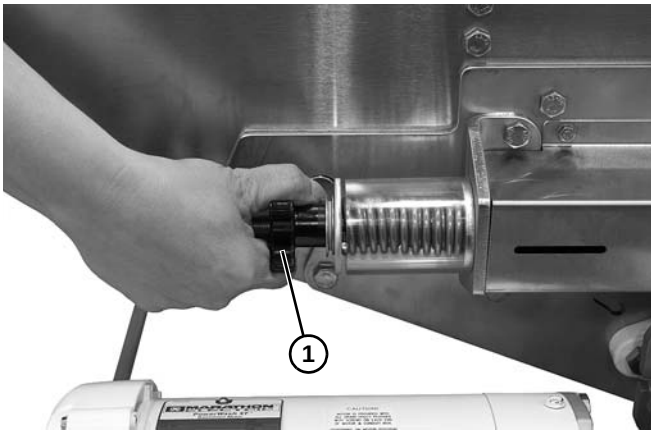



***Figure 107***

3. Complete steps 6 thru 15 of the Center Drive "Belt Removal" on page 20".
4. Remove gearmotor and gear reducer. See Center Drive Package Manual 851-884 for detailed instructions.
5. Loosen bearing set screws **(Figure 108, item 1)** on both sides of the center drive.

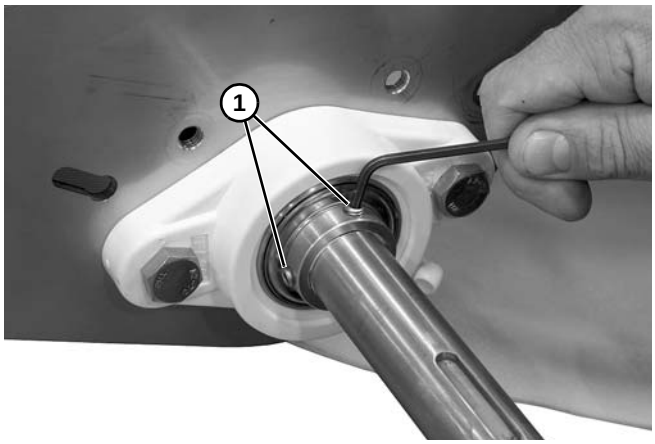



***Figure 108***

6. Remove two bolts **(Figure 109, item 1)** from the bearing housing **(Figure 109, item 2)** on both sides of the center drive.

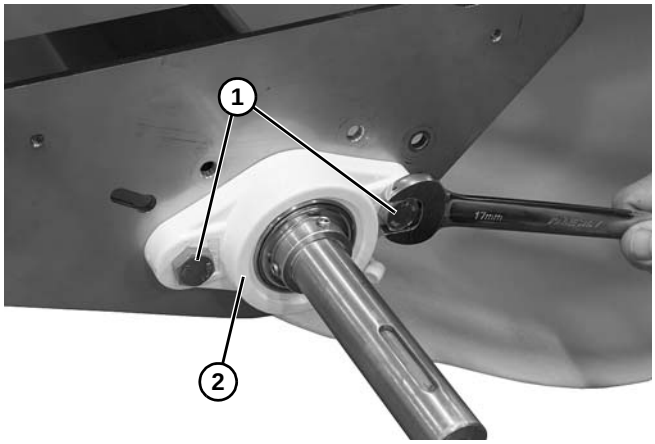



***Figure 109***

7. Slide drive pulley **(Figure 110, item 1)** out.

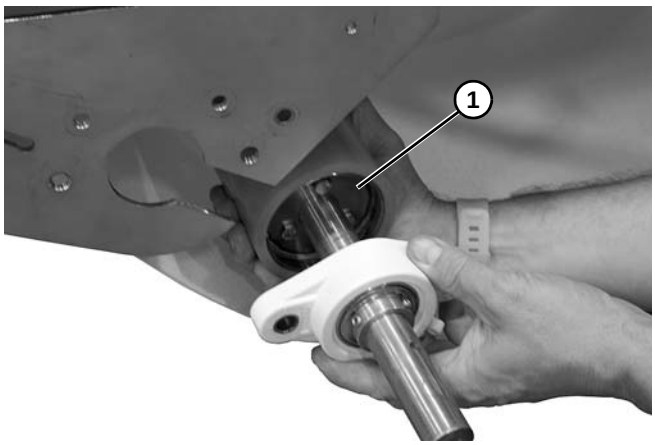



***Figure 110***

## Bearing Replacement

**⚠ WARNING**

**SEVERE HAZARD!**

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

### Drive and Idler Bearing Replacement

**⚠ WARNING**

**PUNCTURE HAZARD!**

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

1. For drive bearing, refer to "Drive Spindle Replacement" on page 28. Follow steps 1 through 7.
2. For idler bearing, refer to "Idler Spindle Replacement" on page 29. Follow steps 1 through 7.
3. Turn bearing **(Figure 111, item 1)** to align with slots **(Figure 111, item 2)** in bearing housing. Then remove bearing.

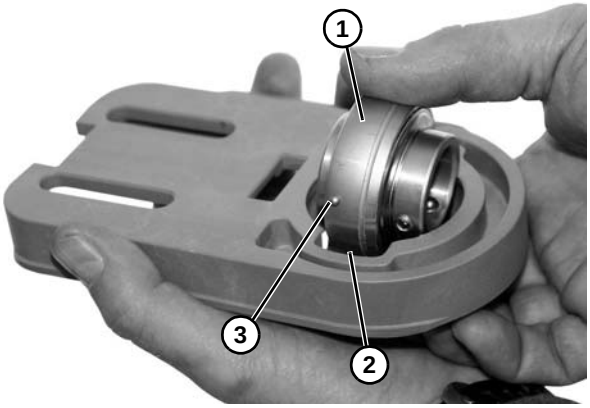



***Figure 111***

4. Inspect bearing housing bearing surface. Replace if worn or damaged. Refer to "Service Parts" on page 44.
5. Insert bearing **(Figure 111, item 1)** into housing slot. Locate anti-rotation nub **(Figure 111, item 3)** to align with slot **(Figure 111, item 2)** and twist bearing into housing.

### Center Drive Bearing Replacement

The bearings in 7350 Series Center Drive Assemblies are not removable. Replace the entire pulley assembly when worn.

When replacing the bearing housing, make sure that the grease fitting **(Figure 112, item 1)** is facing down.

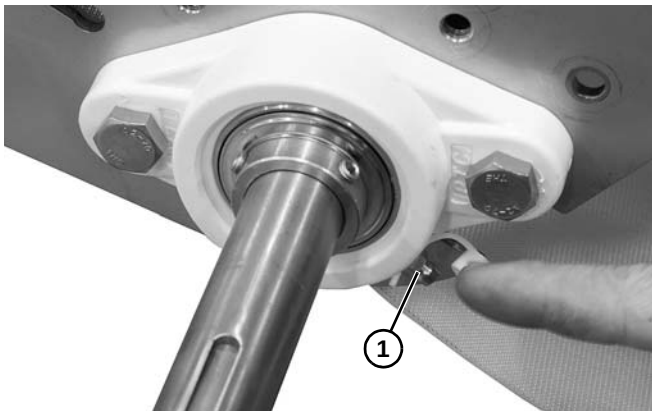



***Figure 112***

## Knuckle Maintenance

**WARNING**

**SEVERE HAZARD!**

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

### Lower Knuckle

#### Bearing Replacement

1. Remove bolts **(Figure 113, item 1)**.

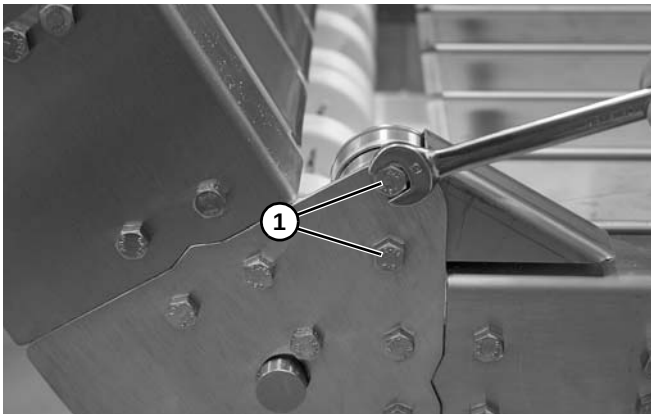



*Figure 113*

2. Remove bearing guard **(Figure 114, item 1)** with bearing.

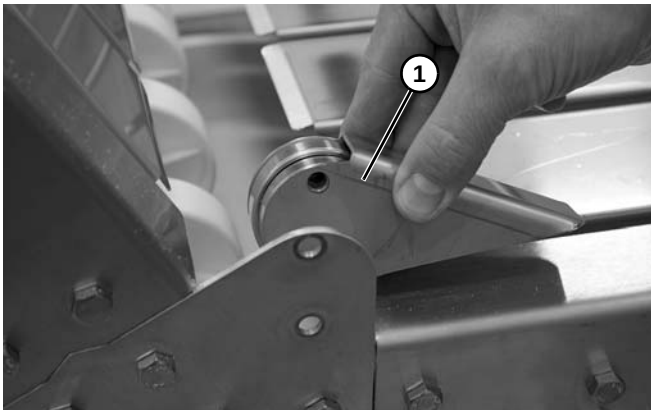



*Figure 114*

3. Remove bearing **(Figure 115, item 1)**.


*Figure 115*

4. Install parts in reverse order of removal.

#### Puck Replacement

1. Remove bolts **(Figure 113, item 1)** and bearing guard **(Figure 114, item 1)**.
2. Remove belt. Refer to "Conveyor Belt Replacement" on page 18.
3. Remove bolt **(Figure 116, item 1)** and shaft retainer **(Figure 116, item 2)** for lower shaft assembly. Repeat for the other side.

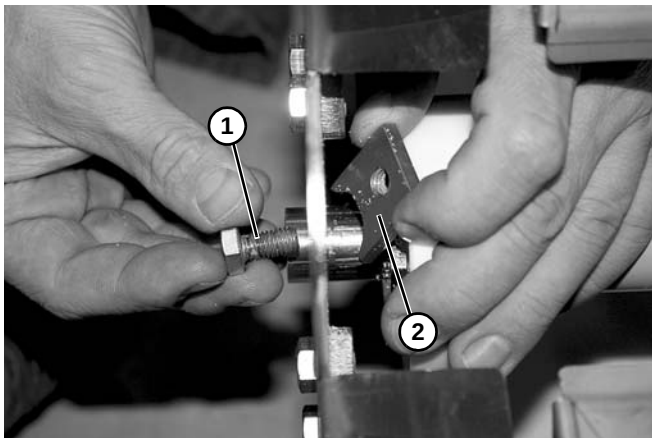



*Figure 116*

4. Remove lower shaft assembly **(Figure 117, item 1)**.

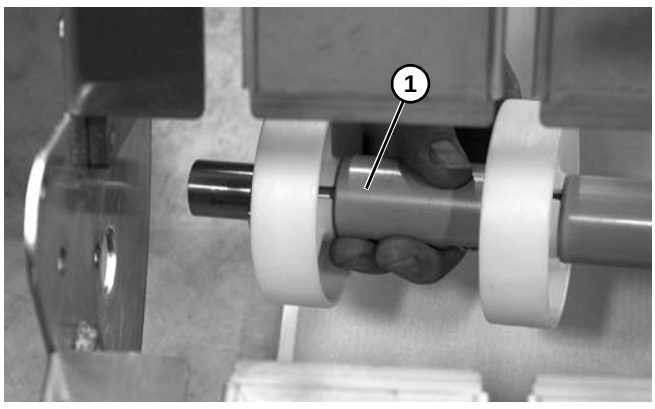



*Figure 117*

5. Insert an 8 mm **(Figure 118, item 1)** and 6 mm **(Figure 118, item 2)** hex wrench into the retainer plate.

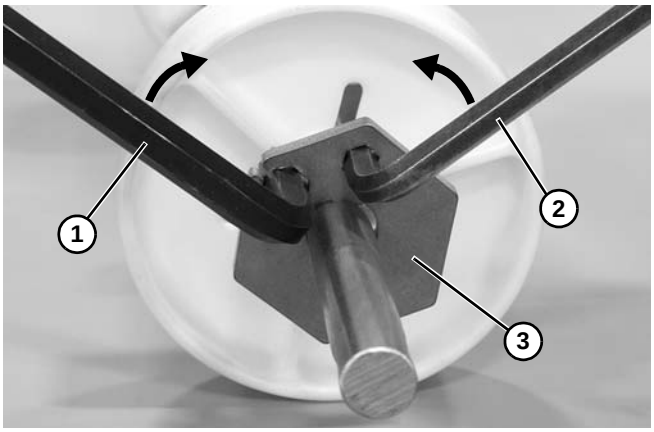



***Figure 118***

6. Move wrenches toward each other to unlock the retainer plate **(Figure 118, item 3)** and remove from the shaft.
7. Remove pucks **(Figure 119, item 1)** and spacers **(Figure 119, item 2)** from the shaft. Repeat as needed.

**NOTE**

*Note the placement of the spacers during disassembly. The spacers MUST be reassembled in the same location.*

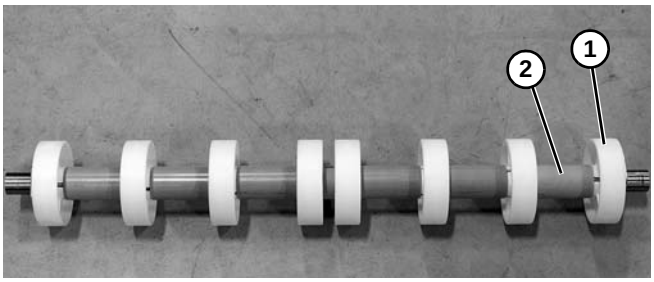



***Figure 119***

8. Install new spacers and pucks and secure to shaft with a retainer plate on both ends.
   a. Insert an 8 mm **(Figure 120, item 1)** and 6 mm **(Figure 120, item 2)** hex wrench into the retainer plate.

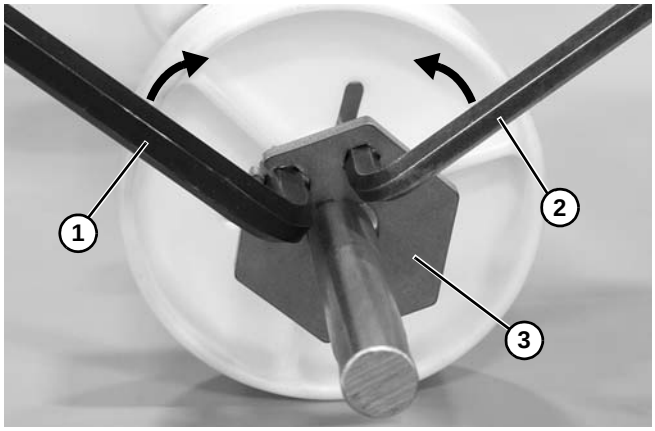



***Figure 120***

   b. Move wrenches toward each other to open the retainer plate **(Figure 120, item 3)** and install onto the shaft. Position retainer plate where needed.
   c. To lock the retainer plate **(Figure 121, item 1)** in place, move the wrenches **(Figure 121, item 2)** away from each other.

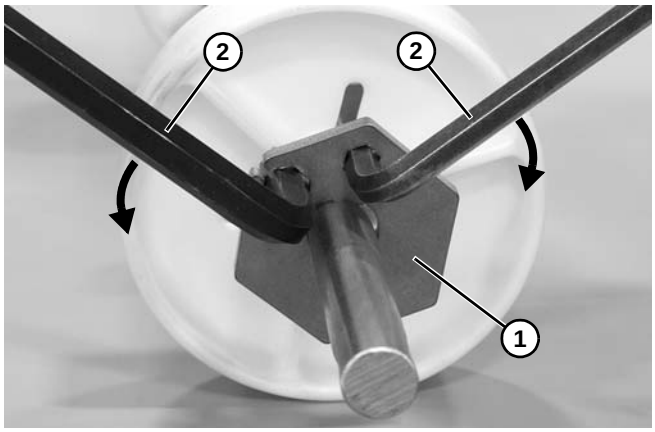



***Figure 121***

9. Install lower shaft assembly in reverse order of removal.

## Upper Knuckle

### Bearing Replacement

1. Remove bolts **(Figure 122, item 1)**.

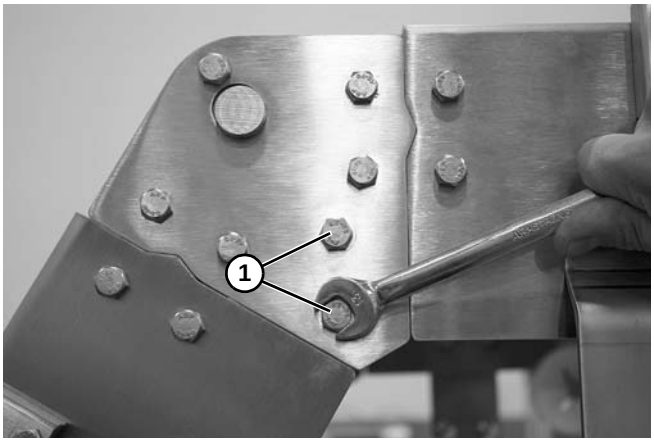



***Figure 122***

2. Remove bearing guard **(Figure 123, item 1)** with bearing.

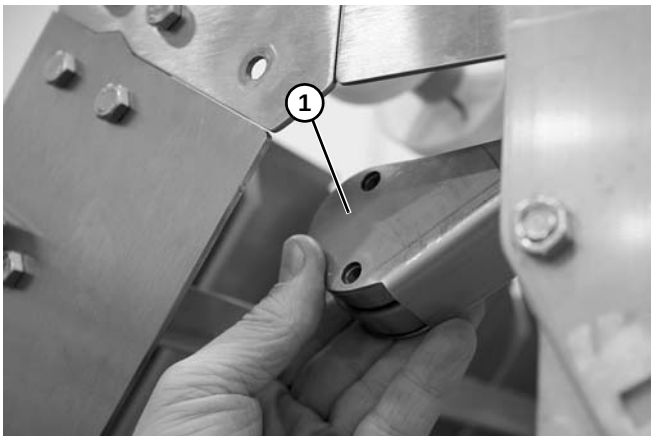



***Figure 123***

3. Remove bearing **(Figure 124, item 1)**.


***Figure 124***

4. Install parts in reverse order of removal.

### Puck Replacement

1. Remove bolts **(Figure 122, item 1)** and bearing guard **(Figure 123, item 1)**.
2. Remove belt. Refer to "Conveyor Belt Replacement" on page 18.
3. Remove bolt **(Figure 125, item 1)** and shaft retainer **(Figure 125, item 2)** for upper shaft assembly. Repeat for the other side.

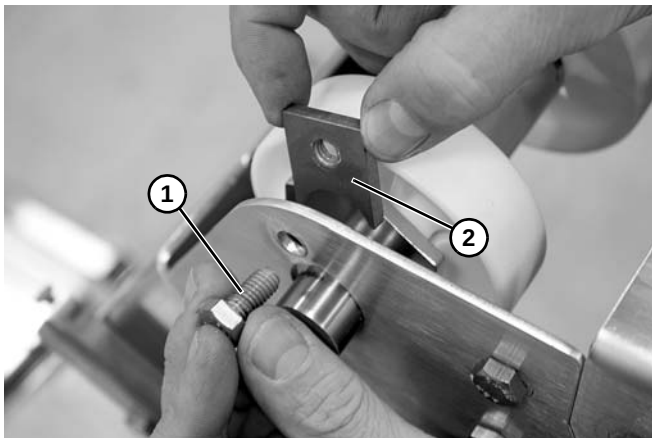



***Figure 125***

4. Remove upper shaft assembly **(Figure 126, item 1)**.

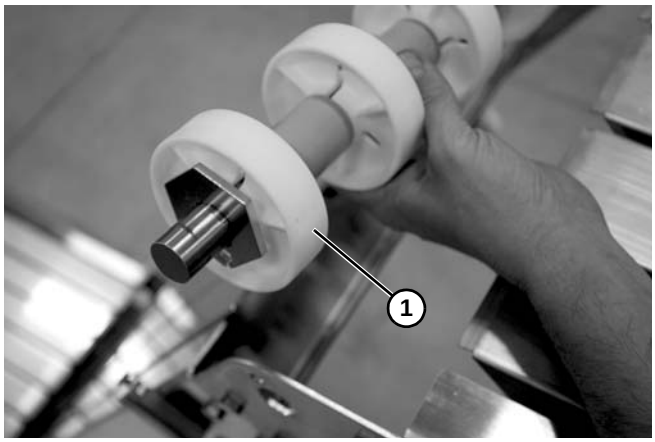



***Figure 126***

5. Insert an 8 mm **(Figure 127, item 1)** and 6 mm **(Figure 127, item 2)** hex wrench into the retainer plate.

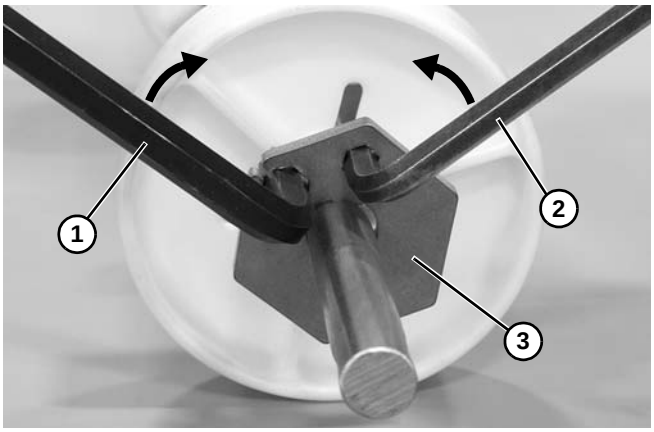



***Figure 127***

6. Move wrenches toward each other to unlock the retainer plate **(Figure 127, item 3)** and remove from the shaft.
7. Remove pucks **(Figure 128, item 1)** and spacers **(Figure 128, item 2)** from the shaft. Repeat as needed.

| NOTE |
| --- |
| *Note the placement of the spacers during disassembly. The spacers MUST be reassembled in the same location.* |

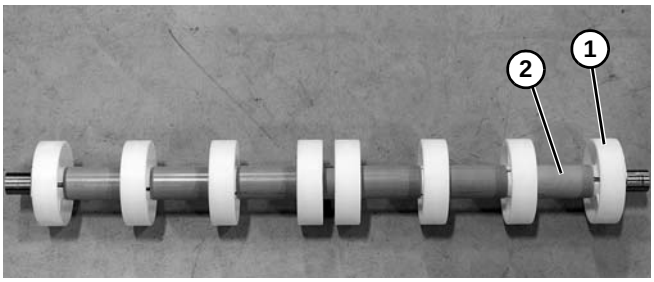



***Figure 128***

8. Install new spacers and pucks and secure to shaft with a retainer plate on both ends.
   a. Insert an 8 mm **(Figure 129, item 1)** and 6 mm **(Figure 129, item 2)** hex wrench into the retainer plate.

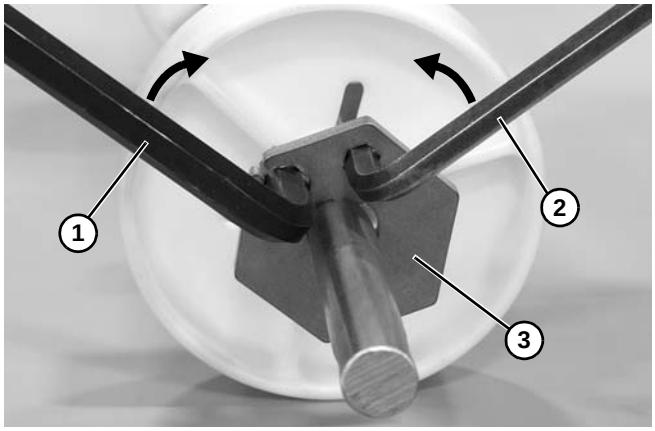



***Figure 129***

   b. Move wrenches toward each other to open the retainer plate **(Figure 129, item 3)** and install onto the shaft. Position retainer plate where needed.
   c. To lock the retainer plate **(Figure 130, item 1)** in place, move the wrenches **(Figure 130, item 2)** away from each other.

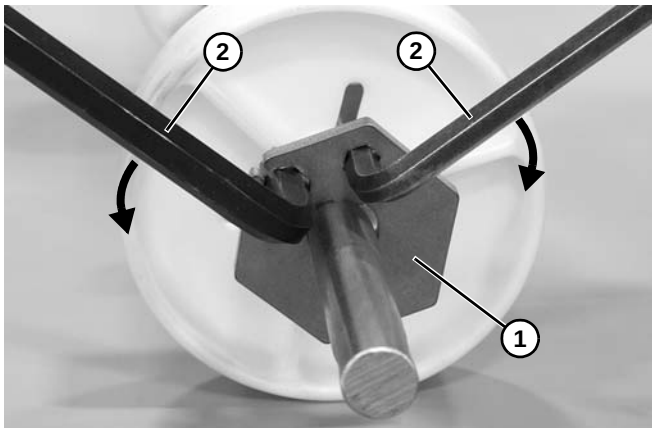



***Figure 130***

9. Install upper shaft assembly in reverse order of removal.

## Belt Return Maintenance

**WARNING**

**SEVERE HAZARD!**

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

### Flat Belt Returns 610 mm Wide and Wider

1. Loosen nut **(Figure 131, item 1)** and rotate return clip **(Figure 131, item 2)** up on both sides of conveyor. Loosely tighten nuts to hold clip in place.

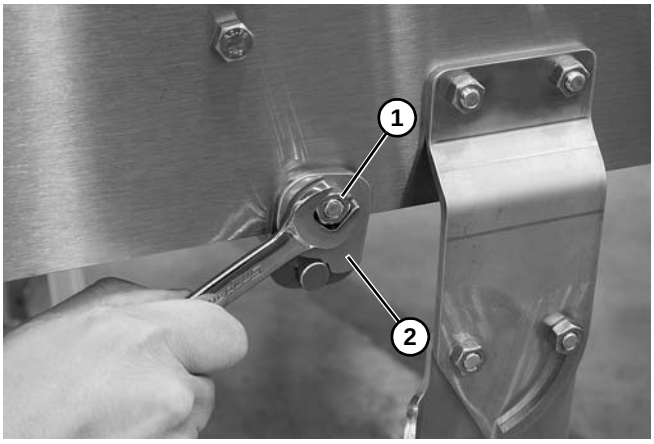



*Figure 131*

2. Remove belt return assembly **(Figure 132, item 1)** from return brackets **(Figure 132, item 2)**.

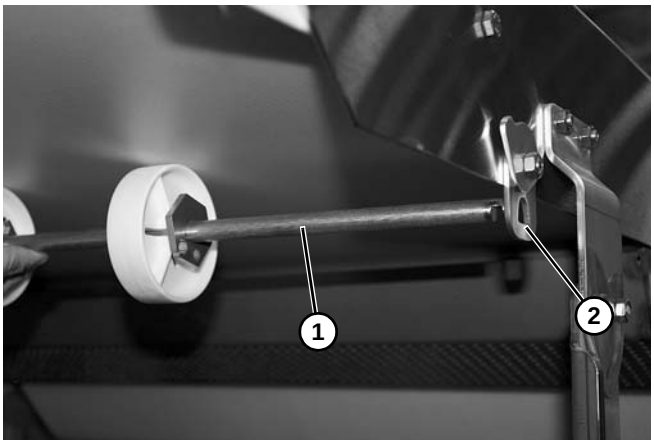



*Figure 132*

3. Insert an 8 mm **(Figure 133, item 1)** and 6 mm **(Figure 133, item 2)** hex wrench into the retainer plate.

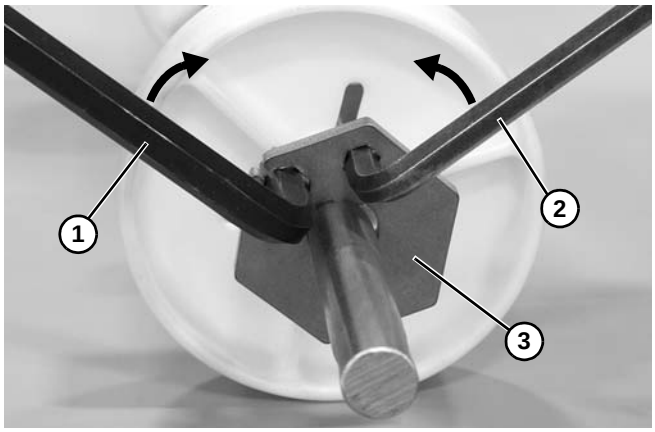



*Figure 133*

4. Move wrenches toward each other to unlock the retainer plate **(Figure 133, item 3)** and remove from the shaft.
5. Remove puck **(Figure 134, item 1)** from the shaft.


*Figure 134*

6. Repeat steps 3 through 5 as needed.

7. Install new pucks with retainer plates on both sides.

   a. Insert an 8 mm **(Figure 135, item 1)** and 6 mm **(Figure 135, item 2)** hex wrench into the retainer plate.

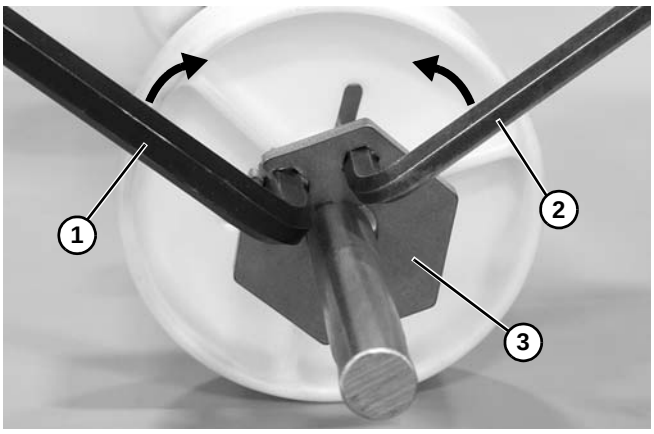



***Figure 135***

   b. Move wrenches toward each other to open the retainer plate **(Figure 135, item 3)** and install onto the shaft. Position retainer plate where needed.

   c. To lock the retainer plate **(Figure 136, item 1)** in place, move the wrenches **(Figure 136, item 2)** away from each other.

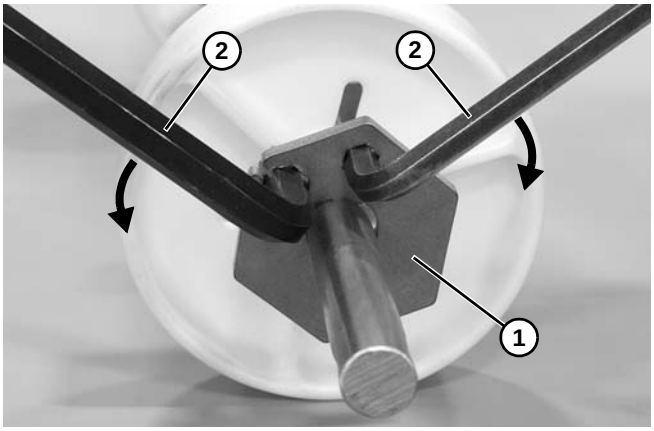



***Figure 136***

8. Install belt return assembly in reverse order of removal.

## Cleated Belt and Flat Belt Returns Under 610 mm Wide

1. Loosen nut **(Figure 137, item 1)** and rotate return clip **(Figure 137, item 2)** up on both sides of conveyor. Loosely tighten nuts to hold clip in place.

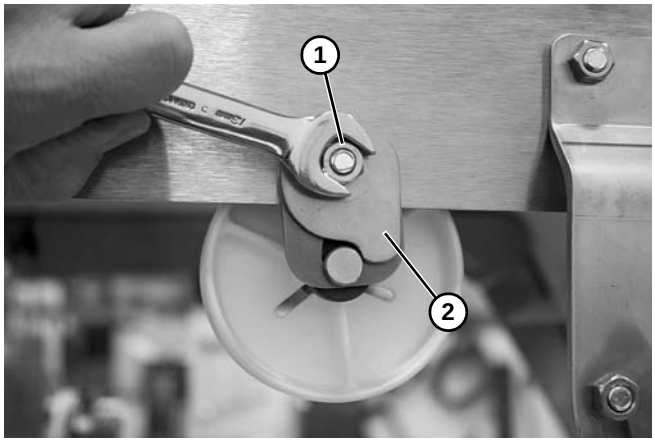



***Figure 137***

2. Remove puck **(Figure 138, item 1)**, stub shaft **(Figure 138, item 2)**, and spacer **(Figure 138, item 3)** from return bracket **(Figure 138, item 4)**.

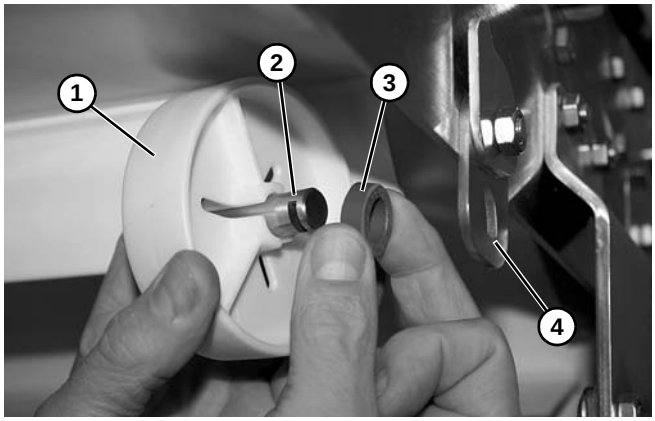



***Figure 138***

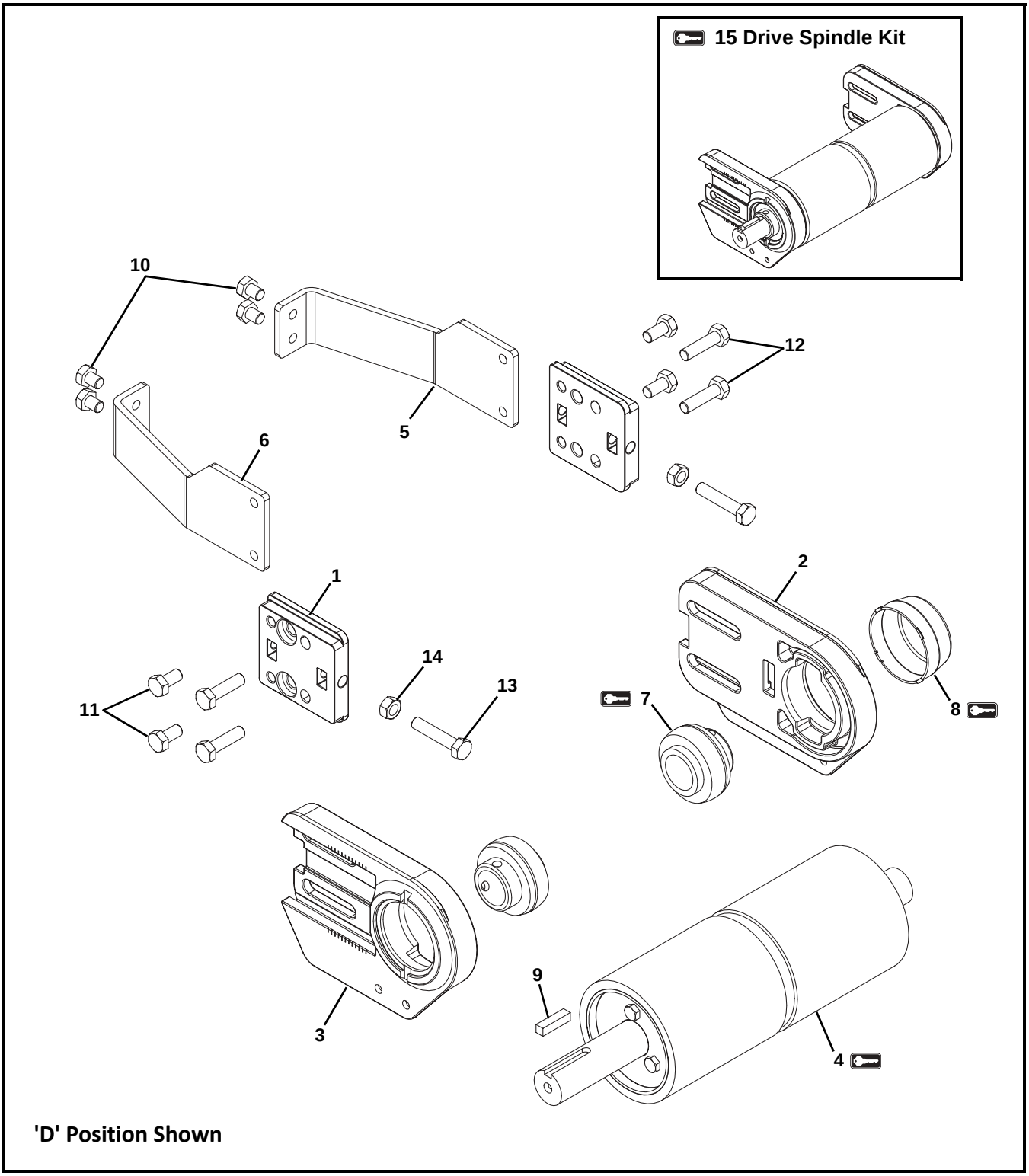
3. Replace worn or damaged parts.
4. Install parts in reverse order of removal.

# Notes

# Service Parts

| NOTE |
| --- |
| *For replacement parts other than those shown in this section, contact an authorized Dorner distributor or Dorner directly. Recommended Critical Service Parts and Kits are identified by the Key Service Parts symbol . Dorner recommends keeping these parts on hand.* |

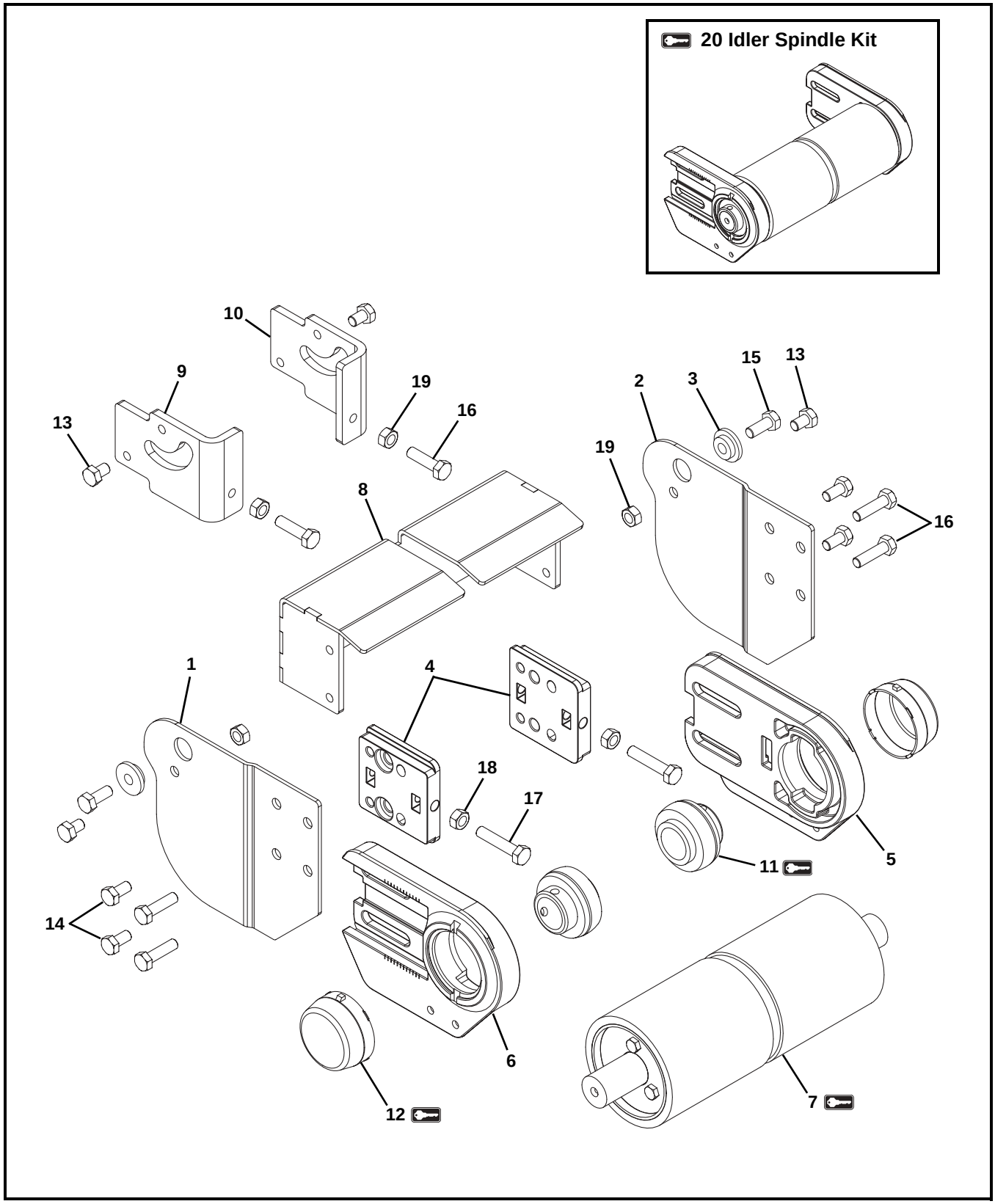
## End Drive Tail



| Item | Part Number | Description |
|---|---|---|
| 1 | 516914 | Drive Tail Block |
| 2 | 532298 | Headplate for A and B Position |
| 3 | 532299 | Headplate for D and C Position |
| 4 | 516819-0K-WW | Drive Spindle for 'A' position |
| | 516819-K0-WW | Drive Spindle for 'D' position |
| | 516819-KK-WW | Dual Shaft Spindle |
| 5 | 516841-LH | Support Bracket, Left Hand |
| 6 | 516841-RH | Support Bracket, Right Hand |
| 7 | 802-161 | Bearing |
| 8 | 807-1454 | Bearing Cap |
| 9 | 912-108SS | Square Key, .25" x 1.00" |
| 10 | 960810MSS | Hex Head Cap Screw, M8-1.25 x 10 mm |
| 11 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 12 | 960830MSS | Hex Head Cap Screw, M8-1.25 x 30 mm |
| 13 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| 14 | 990802MSS | Lock Nut |
| 15 | 520364-0K-WW | Drive Spindle Kit for 'A' position (Includes Items 2, 3, 4, 7 and 9) |
| | 520364-K0-WW | Drive Spindle Kit for 'D' position (Includes Items 2, 3, 4, 7 and 9) |
| | 520364-KK-WW | Dual Shaft Spindle Kit (Includes Items 2, 3, 4, 7 and 9) |
| WW = Conveyor width reference in inches 06 - 36 in 02 increments | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

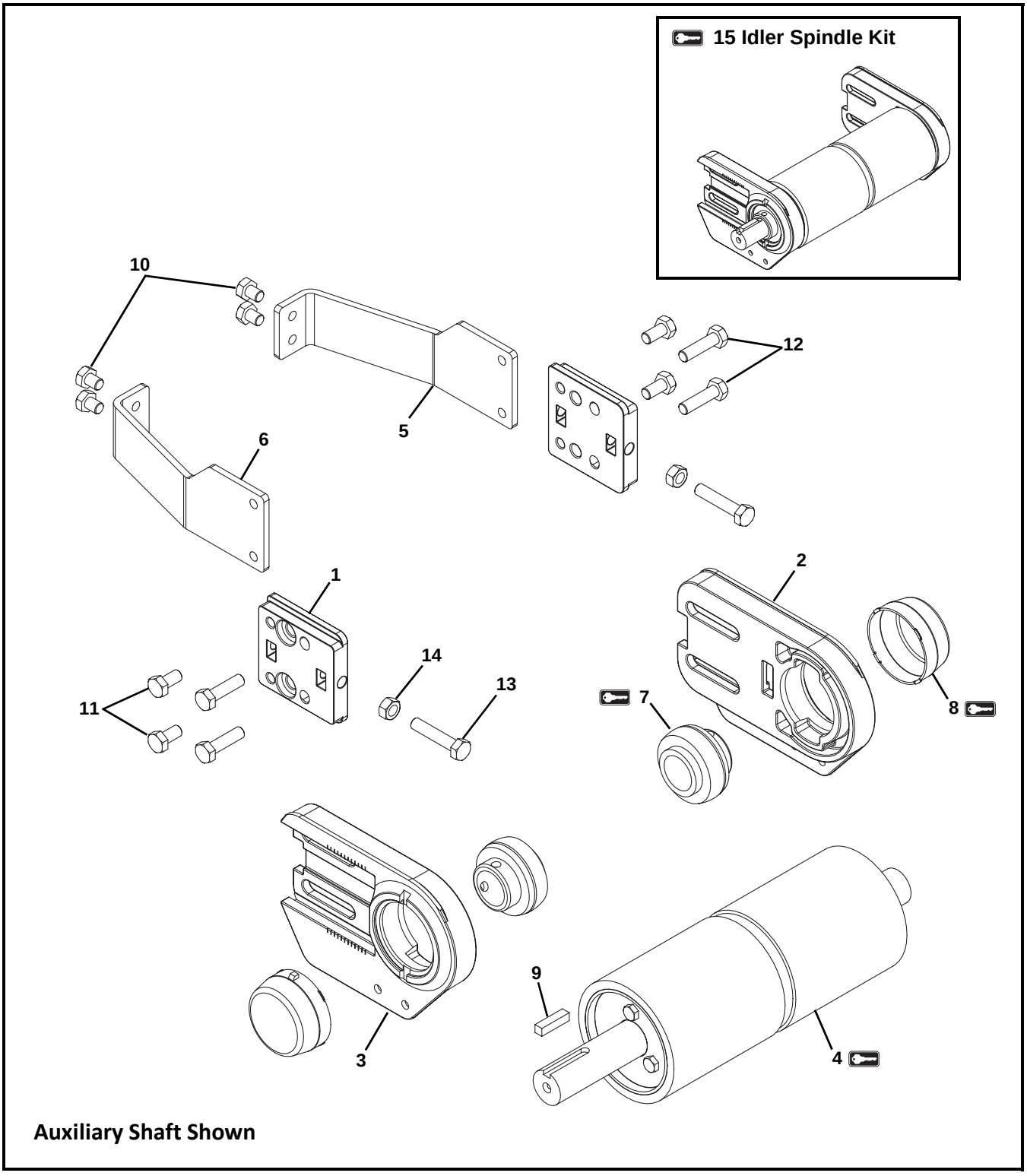
## Tip-Up Idler Tail



| Item | Part Number | Description |
|---|---|---|
| 1 | 516848 | Tip-Up Plate, Left Hand |
| 2 | 516849 | Tip-Up Plate, Right Hand |
| 3 | 516850 | Bushing |
| 4 | 516914 | Block |
| 5 | 532298 | Headplate 'A' Side |
| 6 | 532299 | Headplate 'D' Side |
| 7 | 516819-00-WW | Idler Spindle |
| 8 | 516852-WW | Bracket Assembly |
| 9 | 518415-LH | Tip-Up Bracket, Left Hand |
| 10 | 518415-RH | Tip-Up Bracket, Right Hand |
| 11 | 802-161 | Bearing |
| 12 | 807-1454 | Bearing Cap |
| 13 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |
| 14 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 15 | 960820MSS | Hex Head Cap Screw, M8-1.25 x 20 mm |
| 16 | 960830MSS | Hex Head Cap Screw, M8-1.25 x 30 mm |
| 17 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| 18 | 990802MSS | Lock Nut |
| 19 | 990801MSS | Hex Nut |
| 20 | 520364-00-WW | Idler Spindle Kit (Includes items 5, 6, 7 and 11) |
| WW = Conveyor width reference in inches 06 - 36 in 02 increments | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

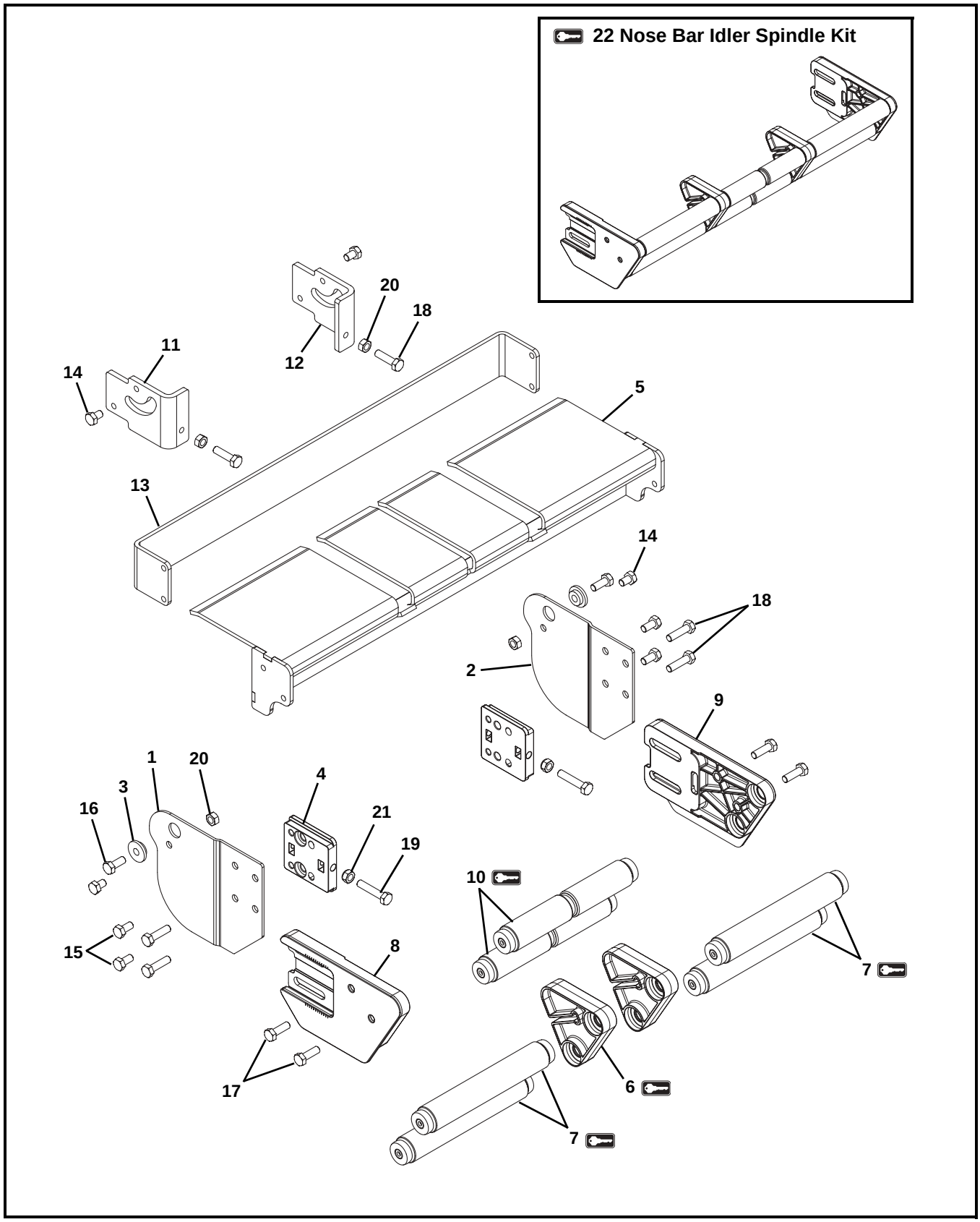
## Fixed Idler Tail for Center Drive Conveyors



| Item | Part Number | Description |
|---|---|---|
| 1 | 516914 | Block |
| 2 | 532298 | Headplate for A and B Position |
| 3 | 532299 | Headplate for D and C Position |
| 4 | 516819-00-WW | Idler Spindle |
| | 516819-0K-WW | Idler Spindle with Auxiliary Shaft for 'A' position |
| | 516819-K0-WW | Idler Spindle with Auxiliary Shaft for 'D' position |
| 5 | 516841-LH | Support Bracket, Left Hand |
| 6 | 516841-RH | Support Bracket, Right Hand |
| 7 | 802-161 | Bearing |
| 8 | 807-1454 | Bearing Cap |
| 9 | 912-108SS | Square Key, .25" x 1.00" |
| 10 | 960810MSS | Hex Head Cap Screw, M8-1.25 x 10 mm |
| 11 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 12 | 960830MSS | Hex Head Cap Screw, M8-1.25 x 30 mm |
| 13 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| 14 | 990802MSS | Lock Nut |
| 15 | 520364-00-WW | Idler Spindle Kit (Includes Items 2, 3, 4, 7 and 9) |
| | 520364-0K-WW | Idler Spindle Kit with Auxiliary Shaft for 'A' position (Includes Items 2, 3, 4, 7 and 9) |
| | 520364-K0-WW | Idler Spindle Kit with Auxiliary Shaft for 'D' position (Includes Items 2, 3, 4, 7 and 9) |
| WW = Conveyor width reference in inches 06 - 36 in 02 increments | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

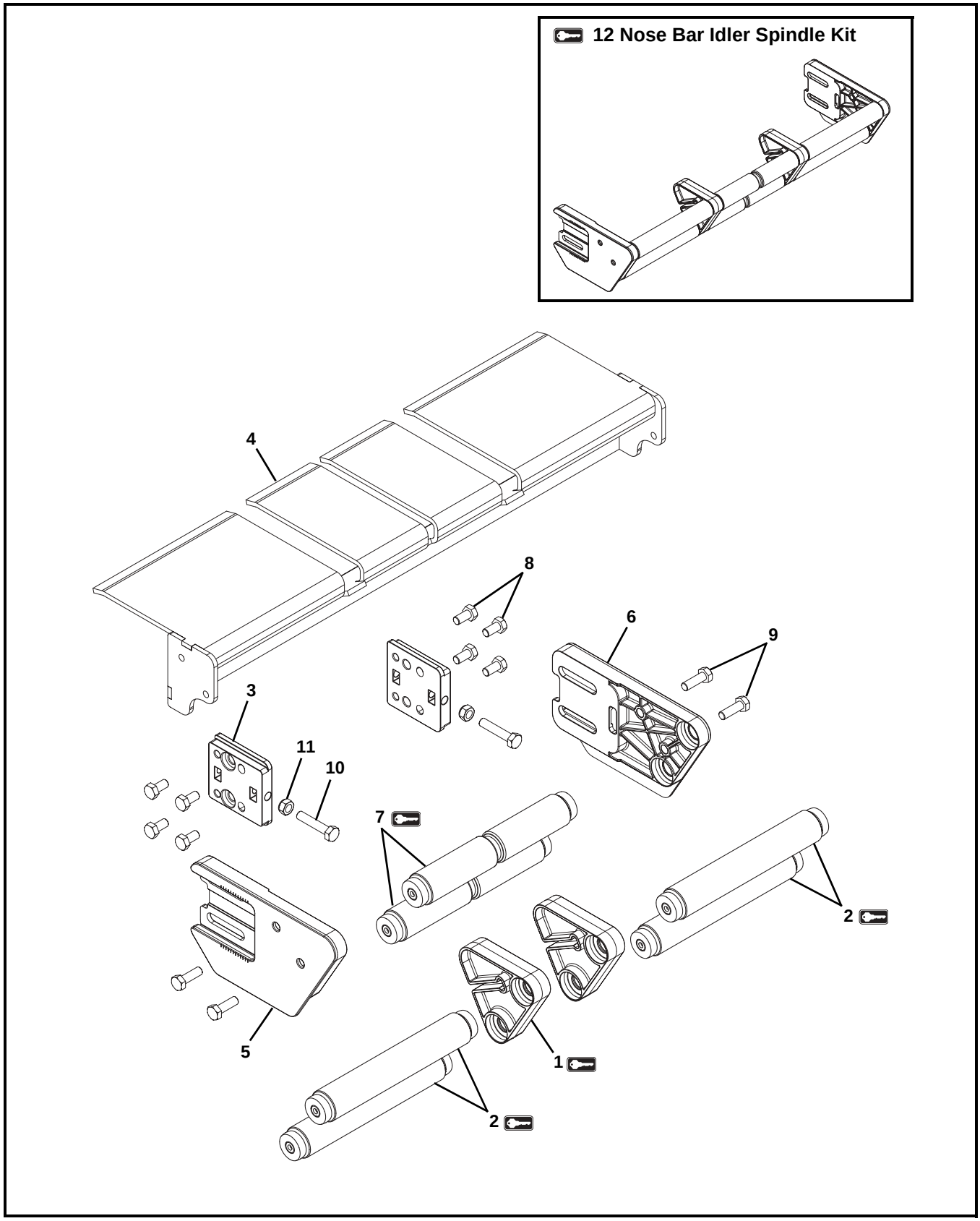
## Tip-Up Nose Bar Idler Tail



| Item | Part Number | Description |
|---|---|---|
| 1 | 516848 | Tip-Up Plate, Left Hand |
| 2 | 516849 | Tip-Up Plate, Right Hand |
| 3 | 516850 | Bushing |
| 4 | 516914 | Block |
| 5 | 516927-T-WW | Crossmember |
| 6 | 516929 | Puck for 22-36 Wide Conveyors Only |
| 7 | 520360 | Spindle Assembly for 22-36 Wide Conveyors Only |
| 8 | 516928-LH | Nose Bar Headplate, Left Hand |
| 9 | 516928-RH | Nose Bar Headplate, Right Hand |
| 10 | 520359-WW | V-Groove Spindle Assembly |
| 11 | 518415-LH | Tip-Up Bracket, Left Hand |
| 12 | 518415-RH | Tip-Up Bracket, Right Hand |
| 13 | 520325-WW | Stop Bracket |
| 14 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |
| 15 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 16 | 960820MSS | Hex Head Cap Screw, M8-1.25 x 20 mm |
| 17 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| 18 | 960830MSS | Hex Head Cap Screw, M8-1.25 x 30 mm |
| 19 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| 20 | 990801MSS | Hex Nut |
| 21 | 990802MSS | Lock Nut |
| 22 | 520365-WW | Nose Bar Idler Spindle Kit (Includes Items 6, 7, 8, 9 and 10) |
| WW = Conveyor width reference in inches 06 - 36 in 02 increments | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

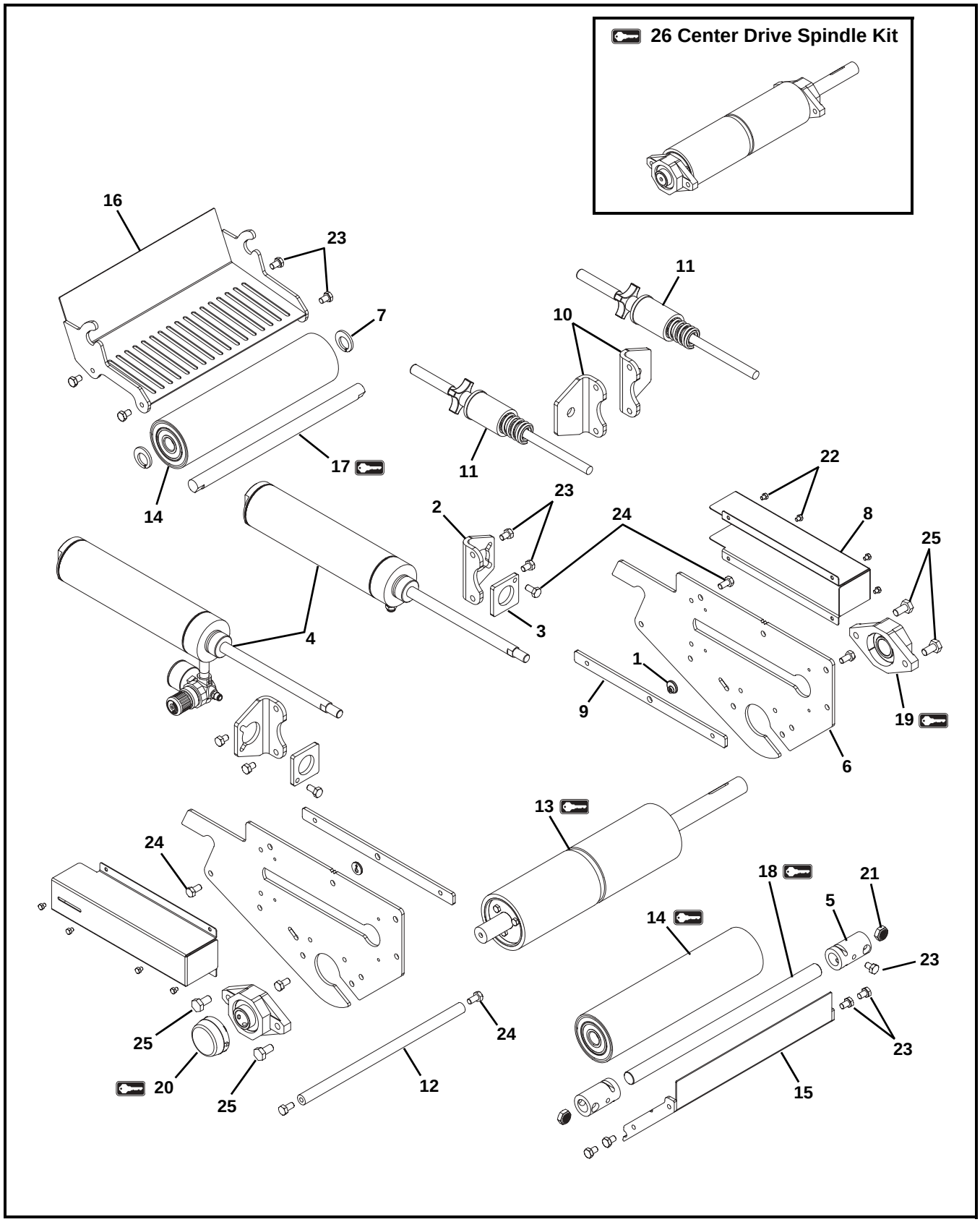
## Fixed Nose Bar Idler Tail for Center Drive Conveyors



| Item | Part Number | Description |
|---|---|---|
| 1 | 516929 | Puck for 22-36 Wide Conveyors Only |
| 2 | 520360 | Spindle Assembly for 22-36 Wide Conveyors Only |
| 3 | 532294 | Block |
| 4 | 516927-F-WW | Crossmember |
| 5 | 516928-LH | Nose Bar Headplate, Left Hand |
| 6 | 516928-RH | Nose Bar Headplate, Right Hand |
| 7 | 520359-WW | V-Groove Spindle Assembly |
| 8 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 9 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| 10 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| 11 | 990802MSS | Lock Nut |
| 12 | 520365-WW | Nose Bar Idler Spindle Kit (Includes Items 1, 2, 5, 6 and 7) |
| WW = Conveyor width reference in inches 06 - 36 in 02 increments | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

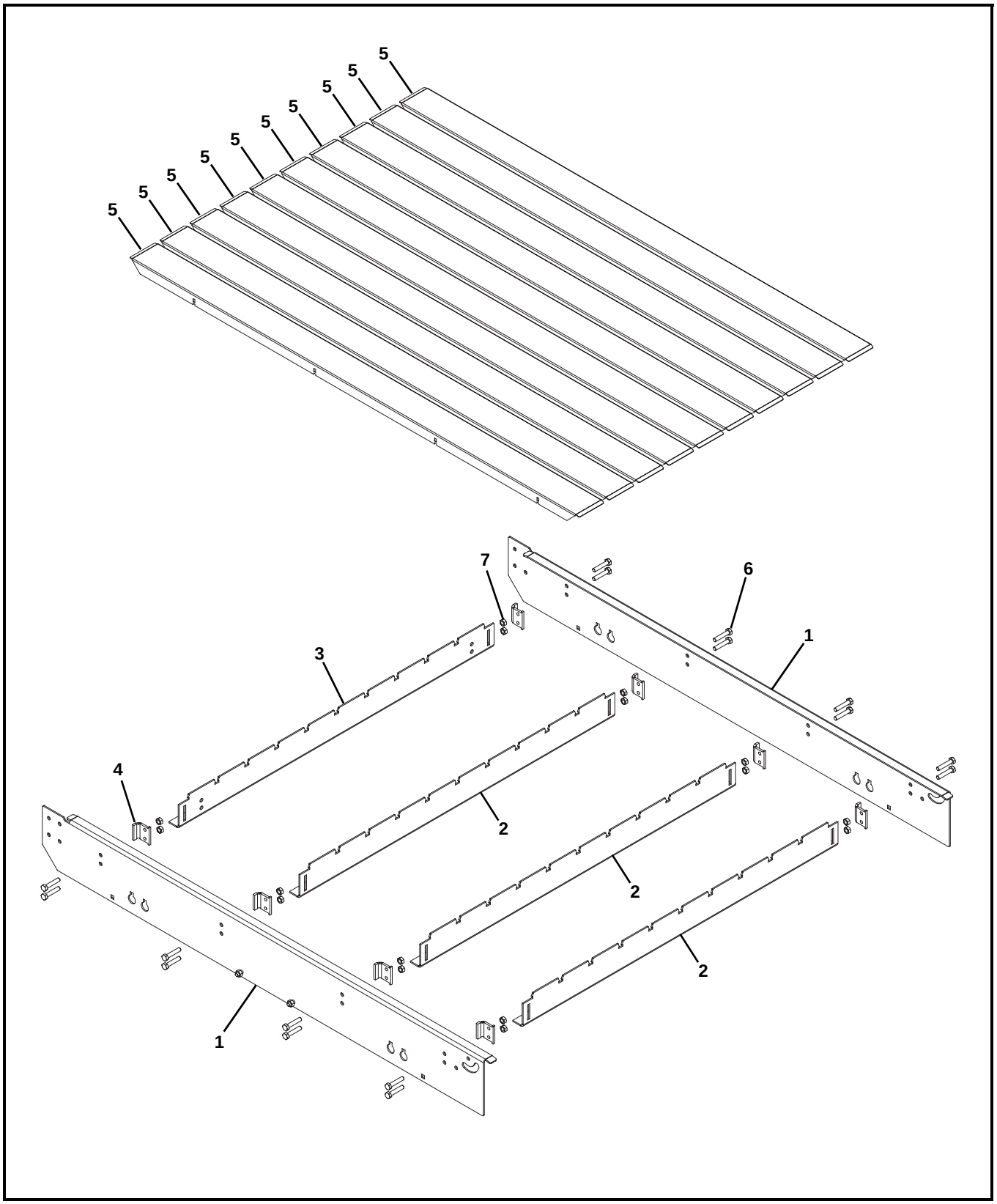
## Center Drive Module



| Item | Part Number | Description |
|---|---|---|
| 1 | 350404 | Cam |
| 2 | 514898 | Cylinder Bracket for Pneumatic Tension Only |
| 3 | 514899 | Nut Plate for Pneumatic Tension Only |
| 4 | 515501 | Pneumatic Tension Kit |
| 5 | 515502 | Spacer |
| 6 | 516867 | Side Plate |
| 7 | 518351 | Bushing |
| 8 | 518379 | Rod Guard |
| 9 | 518380 | Nut Bar |
| 10 | 518492 | Spring Bracket for Manual Tension Only |
| 11 | 514891-WW | Tensioner Assembly for Manual Tension Only |
| 12 | 516881-WW | Cross Tube |
| 13 | 516882-WW | Center Drive Spindle Assembly |
| 14 | 518349-WW | Idler Spindle |
| 15 | 518459-WW | Tension Guard |
| 16 | 518491-WW | Idler Guard |
| 17 | 532409-WW | Idler Shaft |
| 18 | 532425-WW | Axle Shaft |
| 19 | 802-192 | Bearing |
| 20 | 807-1454 | Bearing Cap |
| 21 | 910-083 | Hex Jam Nut |
| 22 | 960506MSS | Hex Head Cap Screw, M5-0.80 x 6 mm |
| 23 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |
| 24 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 25 | 961020MSS | Hex Head Cap Screw, M10-1.50 x 20 mm |
| 26 | 520366-WW | Center Drive Spindle Kit (Includes Items 13 and 19) |
| WW = Conveyor width reference in inches 06 - 36 in 02 increments | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

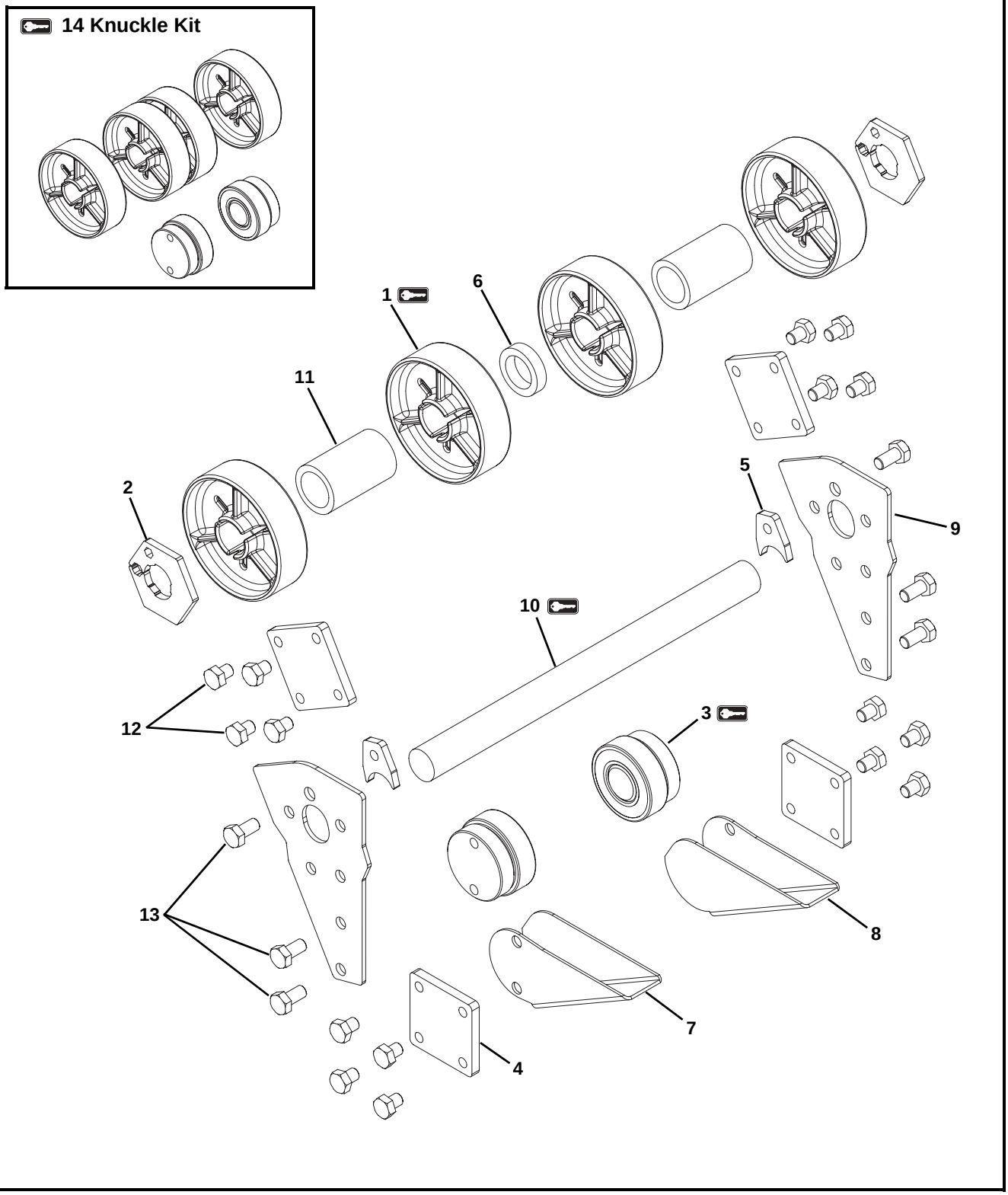
## Frame



| Item | Part Number | Description |
|---|---|---|
| 1 | ---------- | Consult Factory for Frame Part Number |
| 2 | 515593-WW | Crossmember |
| 3 | 517578-WW | Drive End Crossmember |
| 4 | 515596 | Crossmember Mounting Bracket |
| 5 | 516804-LLLLL | Bed Rail |
| 6 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| 7 | 990801MSS | Hex Nut |
| WW = Conveyor width reference in inches 06 - 36 in 02 increments | | |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

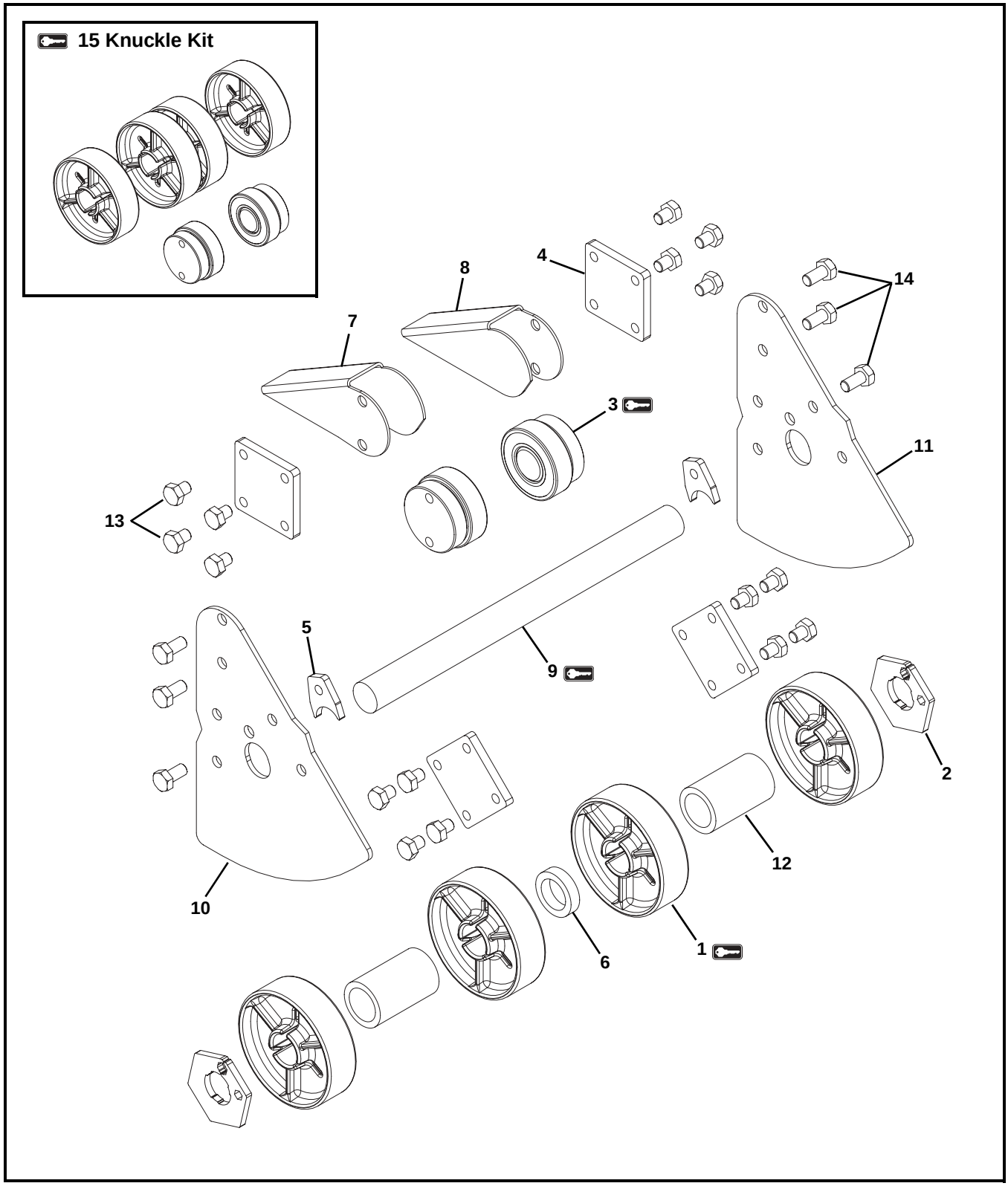
## Upper Knuckle



| Item | Part Number | Description |
|---|---|---|
| 1 | 506296 | Idler Puck |
| 2 | 514823 | Retaining Ring |
| 3 | 520304 | Bearing Assembly (for Cleated Belts Only) |
| 4 | 516942 | Connecting Plate |
| 5 | 518377 | Shaft Clamp |
| 6 | 532379 | Center Spacer |
| 7 | 514831-LH | Bearing Guard, Left Hand (for Cleated Belts Only) |
| 8 | 514831-RH | Bearing Guard, Right Hand (for Cleated Belts Only) |
| 9 | 514887-AA | Side Plate (for Cleated Belts Only) |
| | 514889-AA | Side Plate (for Flat Belts Only) |
| 10 | 516958-WW | Roller Shaft |
| 11 | 532127-LLLLL | Spacer |
| 12 | 960810MSS | Hex Head Cap Screw, M8-1.25 x 10 mm |
| 13 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 14 | 520367-WW | Knuckle Kit (Includes items 1 and 3) |
| AA = Angle 05, 10, 15, 20, 25, 30, 35, 40, 45, 50, 55, 60 | | |
| WW = Conveyor width reference in inches 06 - 24 in 02 increments | | |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

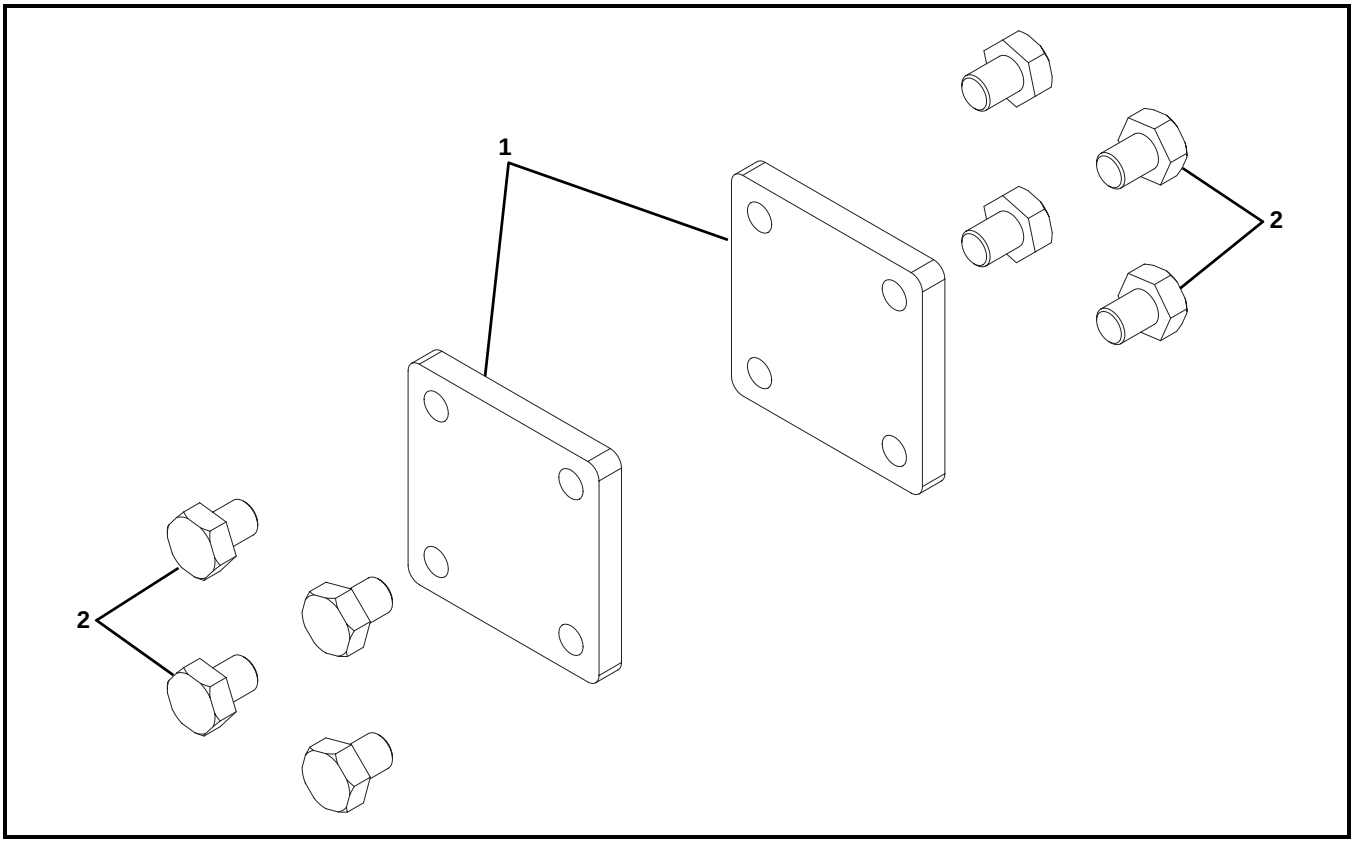
## Lower Knuckle



| Item | Part Number | Description |
|---|---|---|
| 1 | 506296 | Idler Puck |
| 2 | 514823 | Retaining Ring |
| 3 | 520304 | Bearing Assembly |
| 4 | 516942 | Connecting Plate |
| 5 | 518377 | Shaft Clamp |
| 6 | 532379 | Center Spacer |
| 7 | 514831-LH | Bearing Guard, Left Hand (for Sidewall Cleated Belts Only) |
| 8 | 514831-RH | Bearing Guard, Right Hand (for Sidewall Cleated Belts Only) |
| 9 | 516958-WW | Roller Shaft |
| 10 | 518495-AA-LH | Side Plate, Left Hand (for Cleated Belts Only) |
| | 516960-AA | Side Plate (for Sidewall Cleated Belts Only) |
| 11 | 518495-AA-RH | Side Plate, Right Hand (for Cleated Belts Only) |
| | 516960-AA | Side Plate (for Sidewall Cleated Belts Only) |
| 12 | 532127-LLLLL | Spacer |
| 13 | 960810MSS | Hex Head Cap Screw, M8-1.25 x 10 mm |
| 14 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 15 | 520367-WW | Knuckle Kit (Includes items 1 and 3) |
| AA = Angle 30, 35, 40, 45, 50, 55, 60 | | |
| WW = Conveyor width reference in inches 06 - 24 in 02 increments | | |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

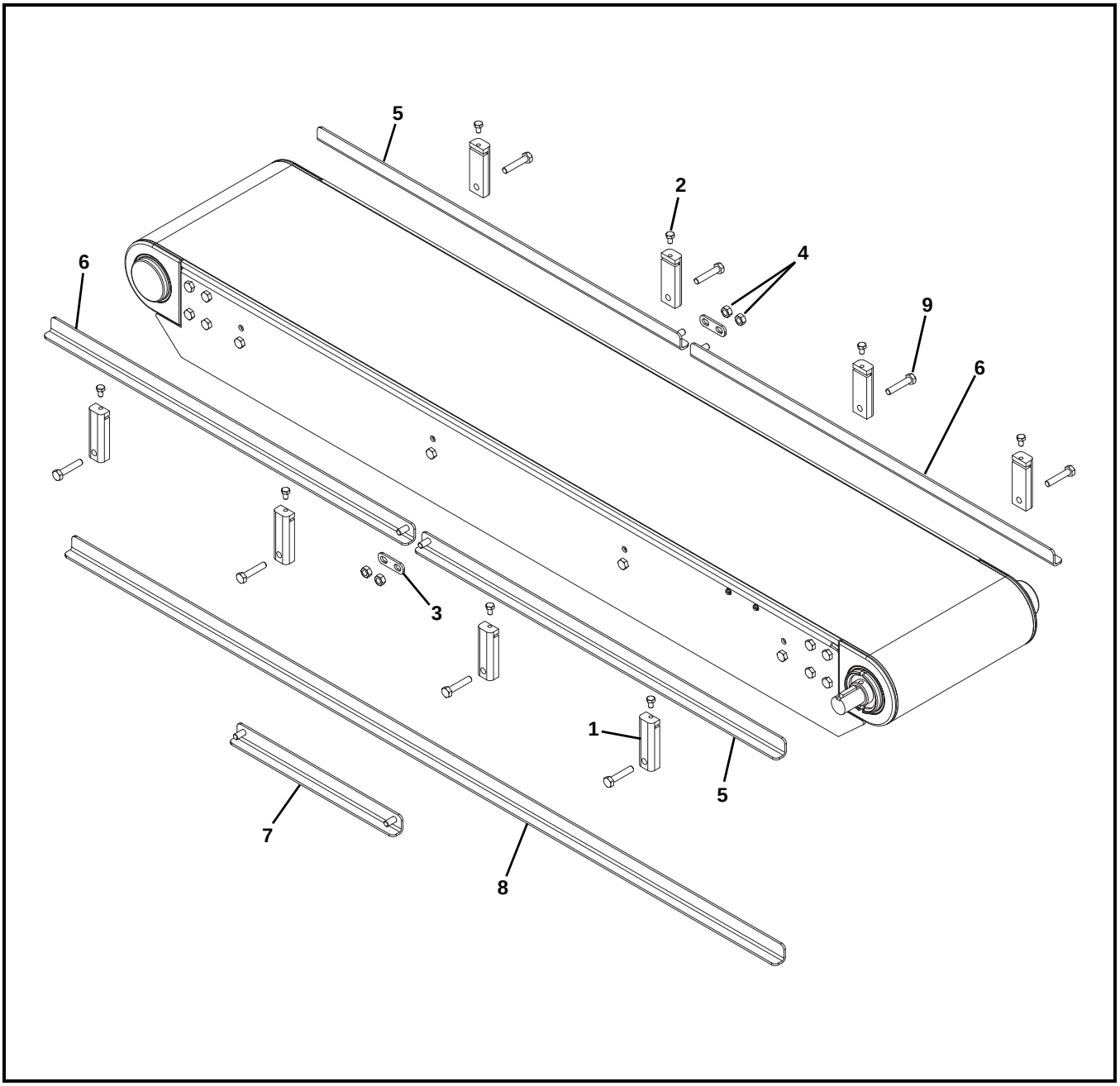
# Service Parts

## Connecting Assembly




| Item | Part Number | Description |
|---|---|---|
| 1 | 516942 | Connecting Plate |
| 2 | 960810MSS | Hex Head Cap Screw,<br>M8-1.25 x 10 mm |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## 25 mm High Sides

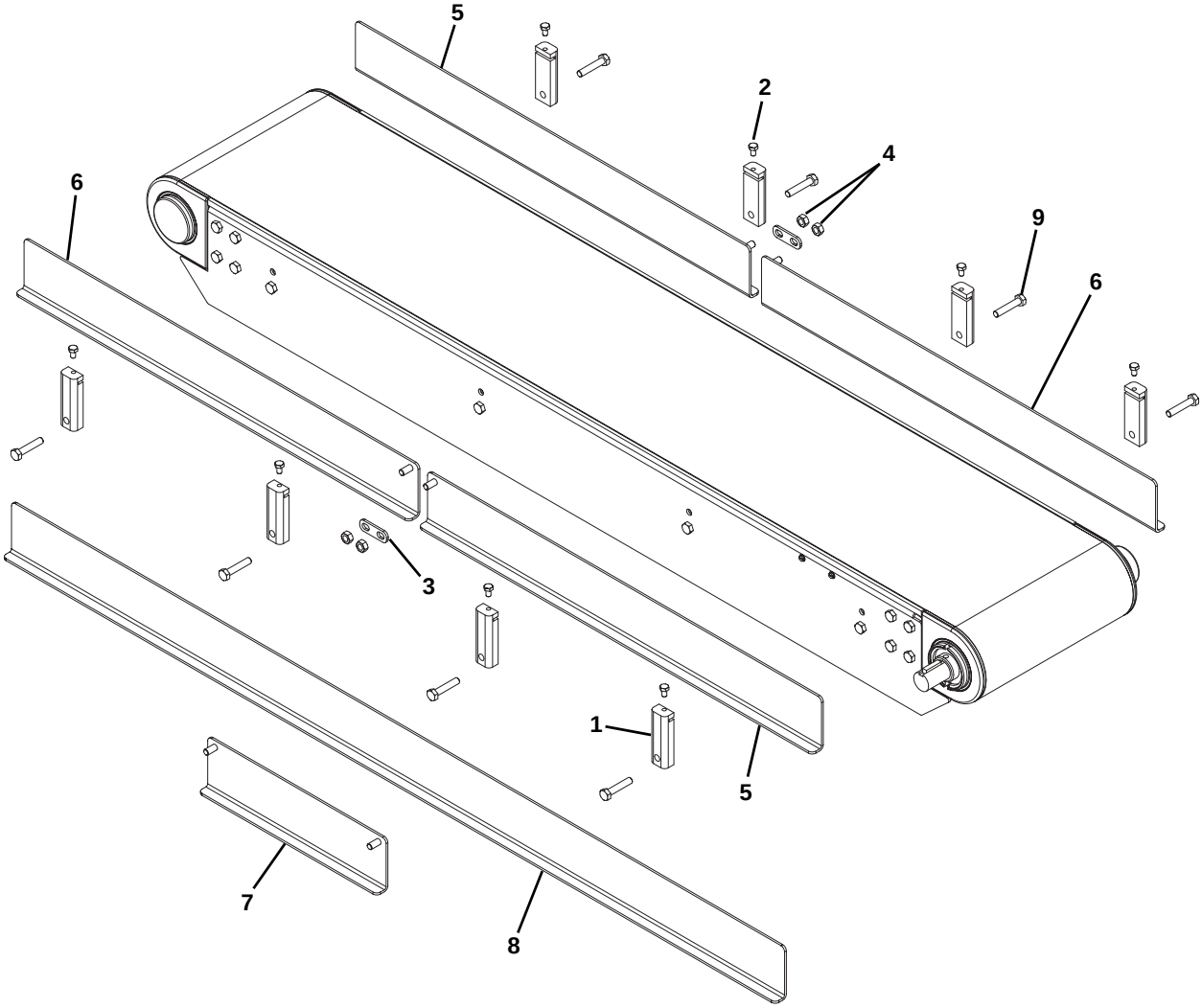



| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518400-05-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 6 | 518400-05-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |
| 7 | 518399-05-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |

| Item | Part Number | Description |
|---|---|---|
| 8 | 516997-01-LLLLL | Guiding (for One Piece Guiding) |
| 9 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

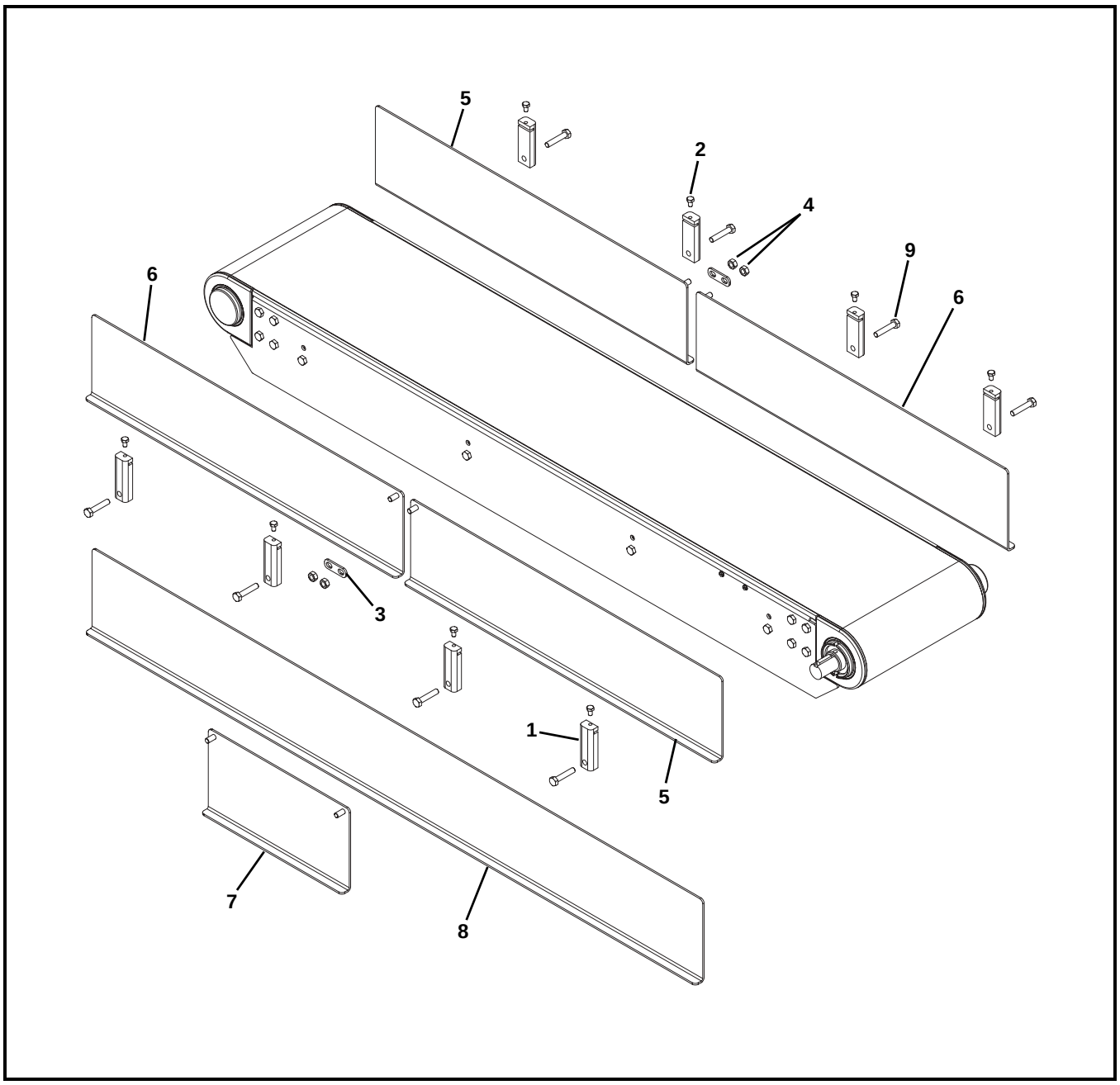
## 75 mm High Sides




| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518400-04-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 6 | 518400-04-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |
| 7 | 518399-04-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |

| Item | Part Number | Description |
|---|---|---|
| 8 | 516997-03-LLLLL | Guiding (for One Piece Guiding) |
| 9 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## 152 mm High Sides

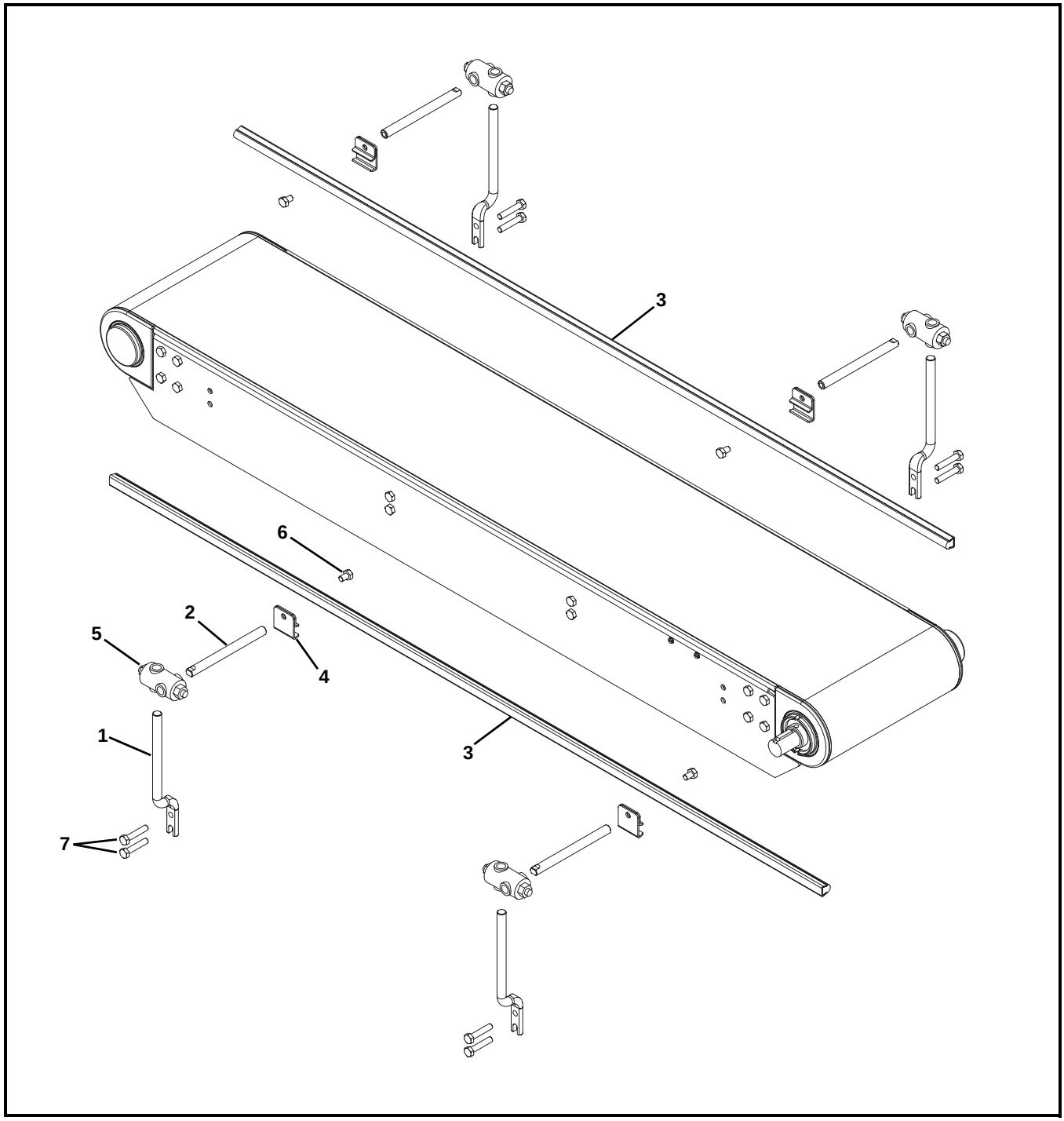



| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518400-06-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 6 | 518400-06-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |
| 7 | 518399-06-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |

| Item | Part Number | Description |
|---|---|---|
| 8 | 516997-06-LLLLL | Guiding (for One Piece Guiding) |
| 9 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

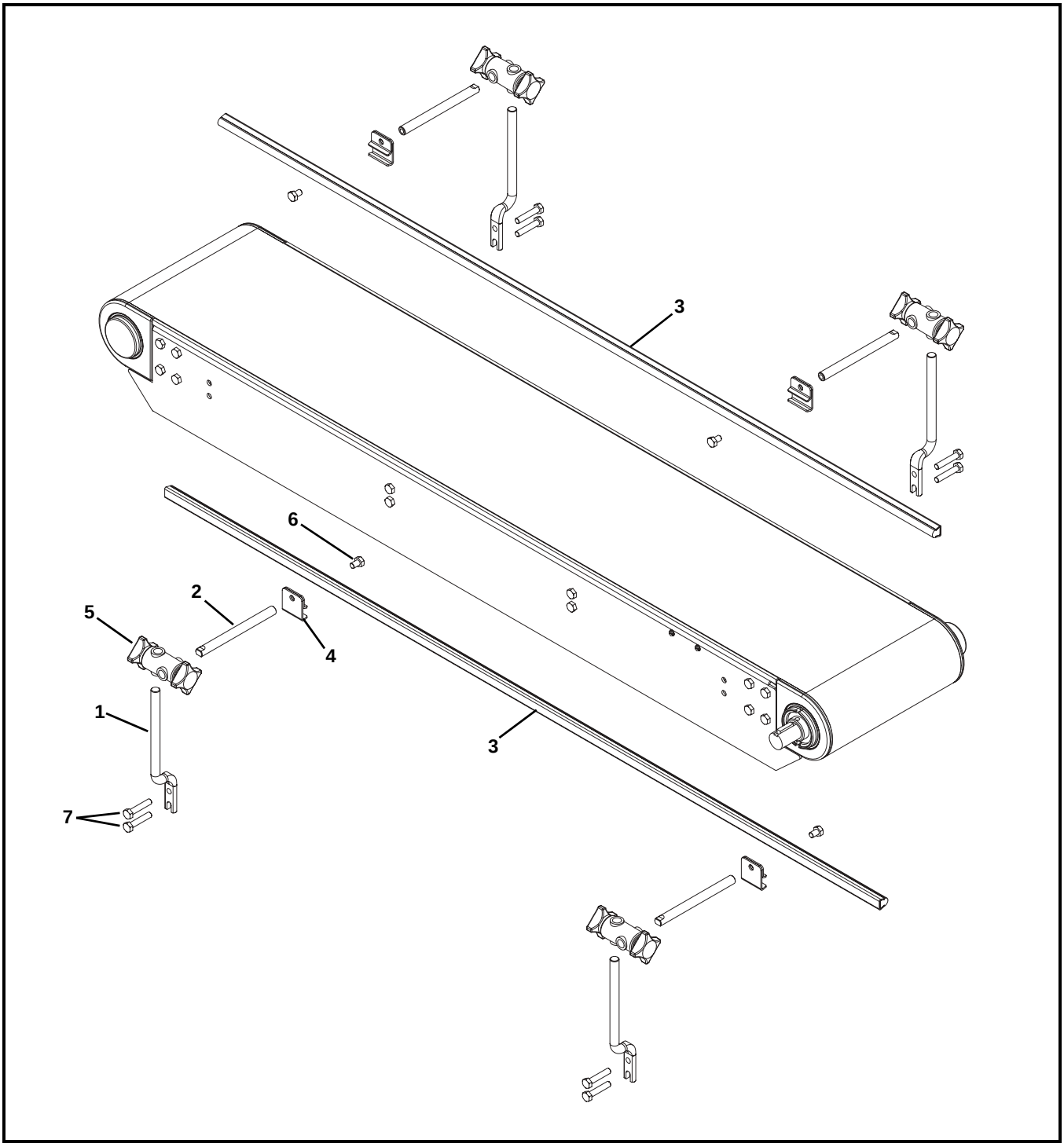
## Fully Adjustable Round Guides




| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 532167-LLLLL | Round Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1387 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## Tool-Less Fully Adjustable Round Guides

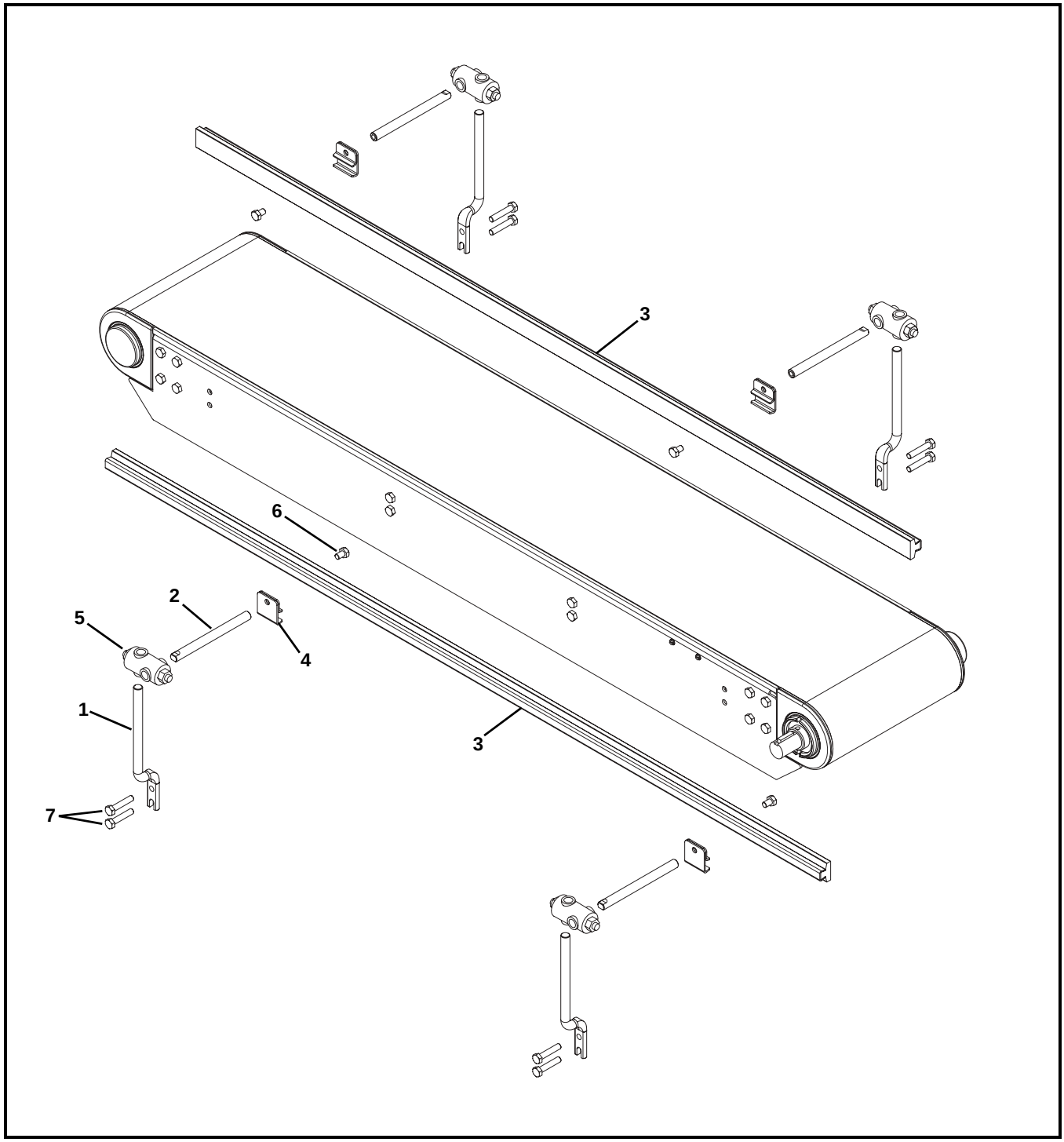



| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 532167-LLLLL | Round Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1470 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

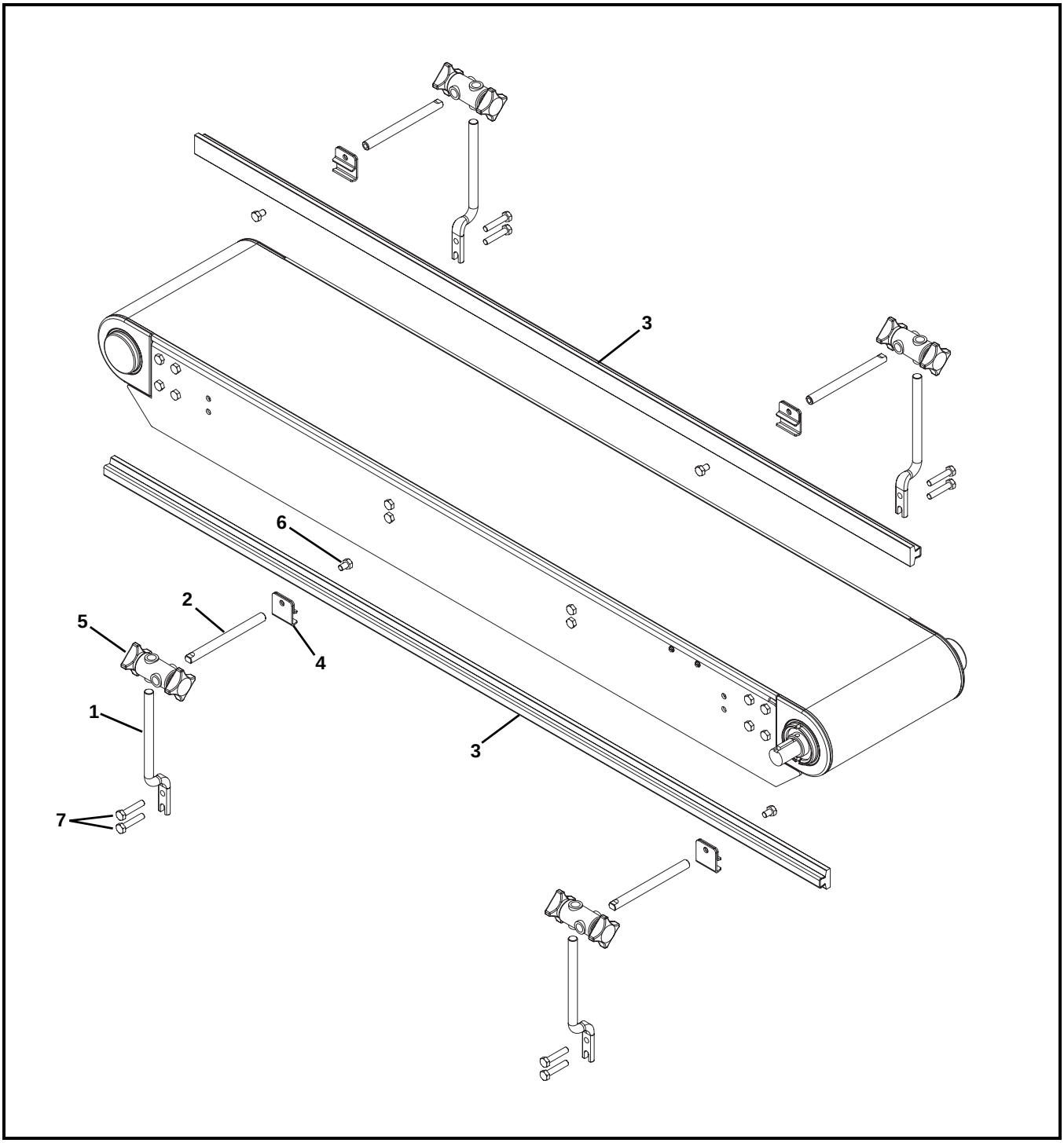
## Fully Adjustable Flat Guides




| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 517599-LLLLL | Flat Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1387 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## Tool-Less Fully Adjustable Flat Guides

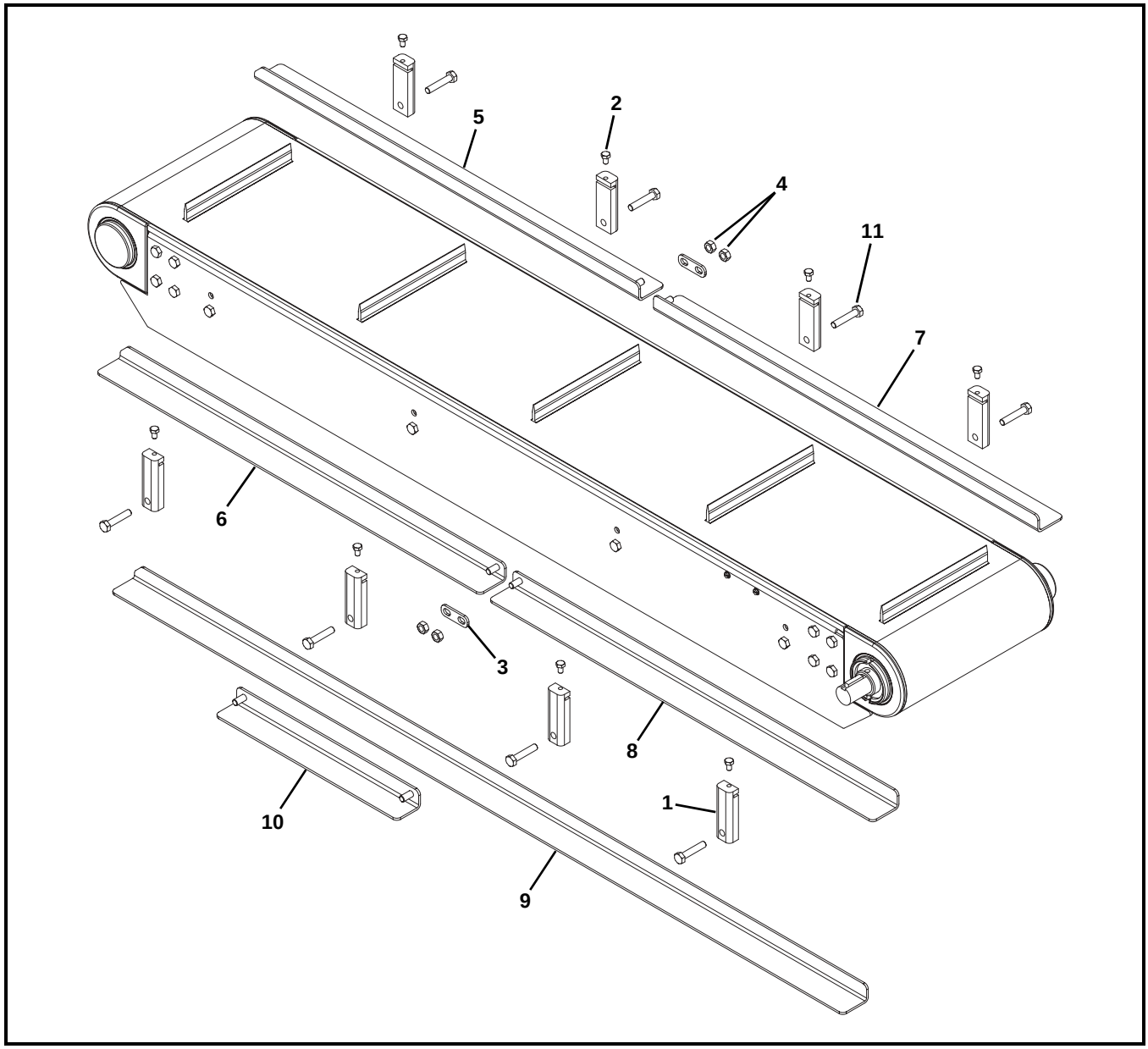



| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 517599-LLLLL | Flat Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1470 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

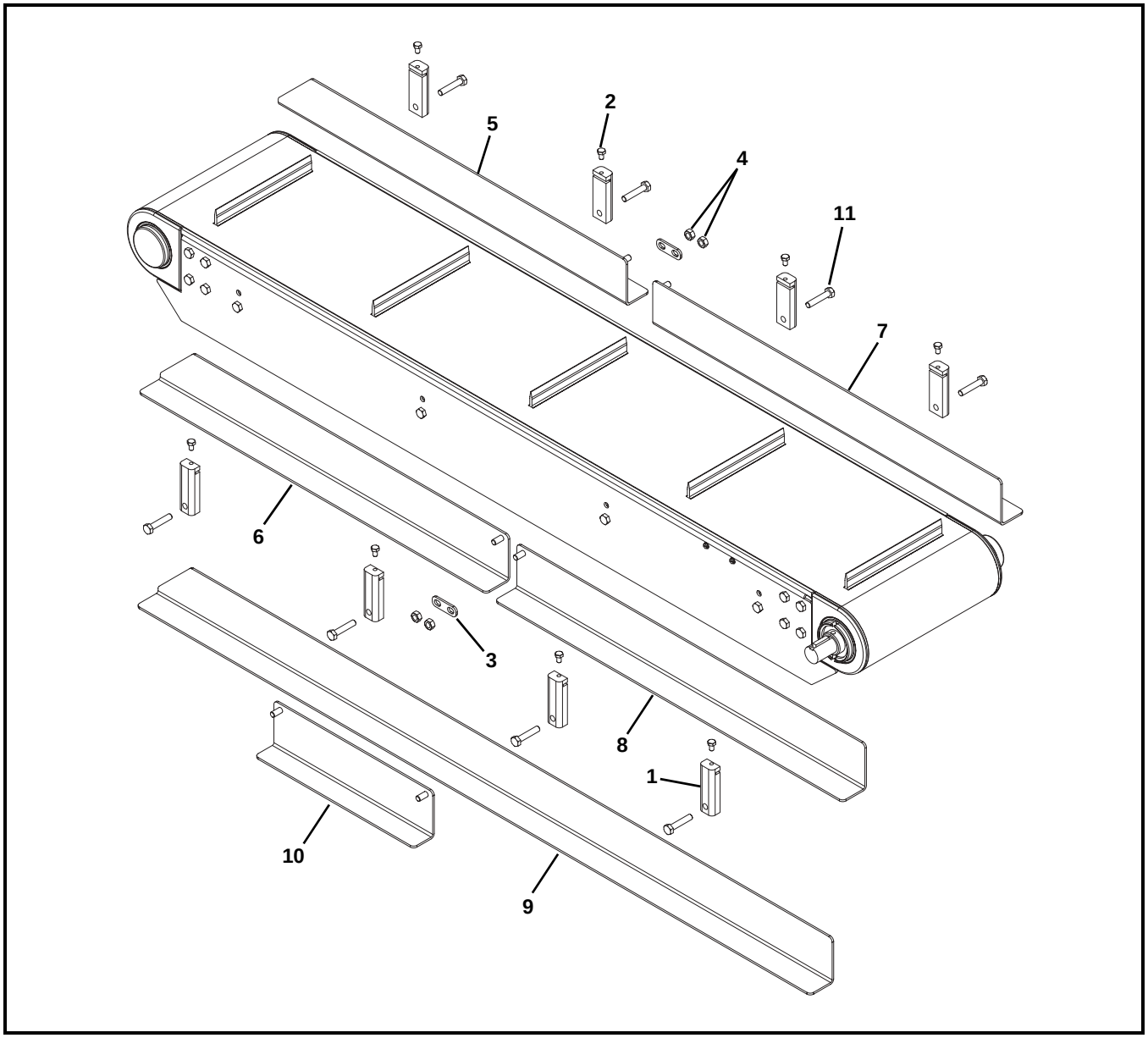
## 25 mm Cleated High Sides




| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518386-02-LLLLL-LH | Guiding, Left Hand |
| 6 | 518386-02-LLLLL-RH | Guiding, Right Hand |
| 7 | 518396-02-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 8 | 518396-02-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |

| Item | Part Number | Description |
|---|---|---|
| 9 | 516998-02-LLLLL-RH | Guiding, Right Hand (for One Piece Guiding) |
| | 516998-02-LLLLL-LH | Guiding, Left Hand (for One Piece Guiding) |
| 10 | 518384-02-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |
| 11 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## 75 mm Cleated High Sides

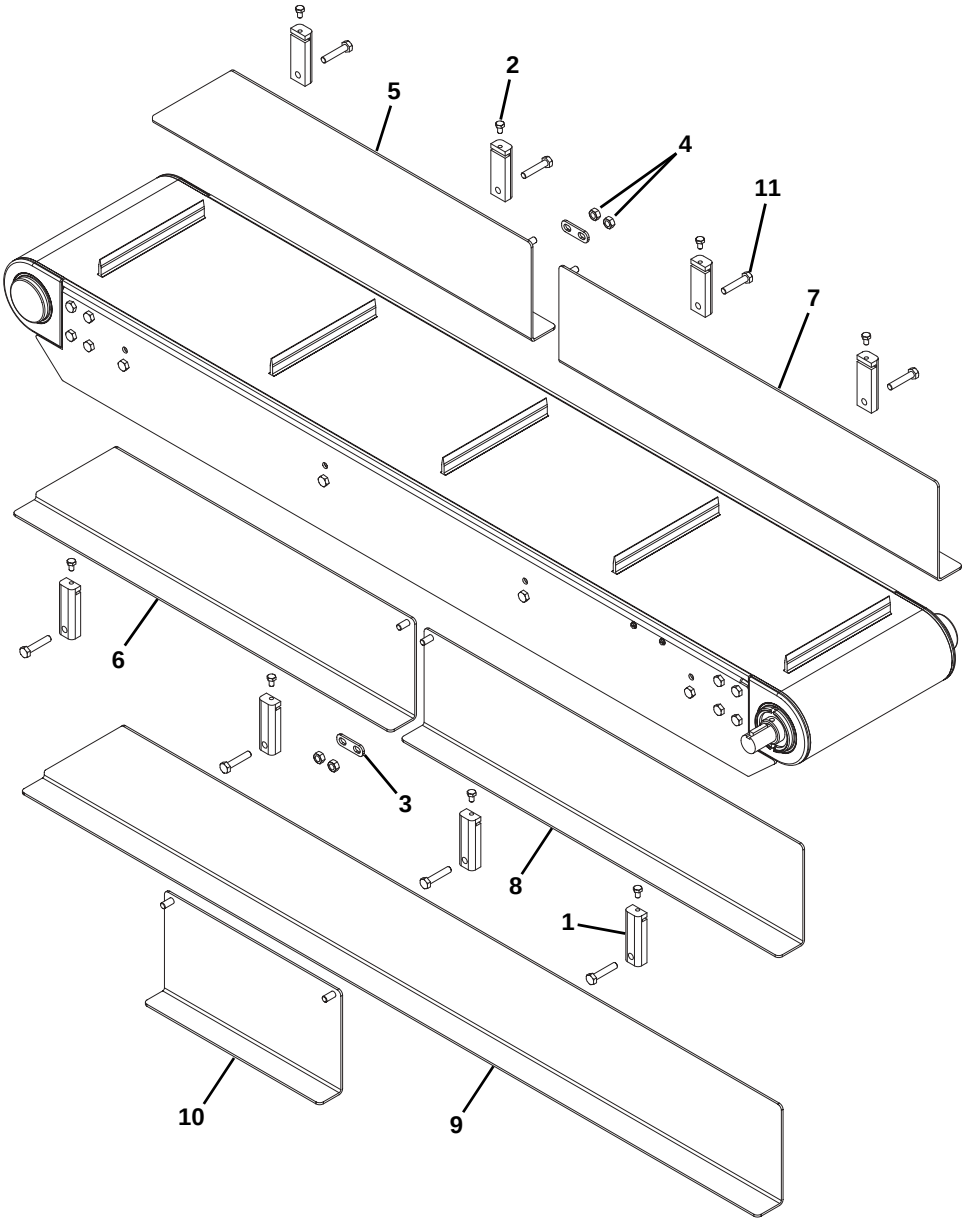



| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518386-03-LLLLL-LH | Guiding, Left Hand |
| 6 | 518386-03-LLLLL-RH | Guiding, Right Hand |
| 7 | 518396-03-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 8 | 518396-03-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |

| Item | Part Number | Description |
|---|---|---|
| 9 | 516998-03-LLLLL-RH | Guiding, Right Hand (for One Piece Guiding) |
| | 516998-03-LLLLL-LH | Guiding, Left Hand (for One Piece Guiding) |
| 10 | 518384-03-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |
| 11 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

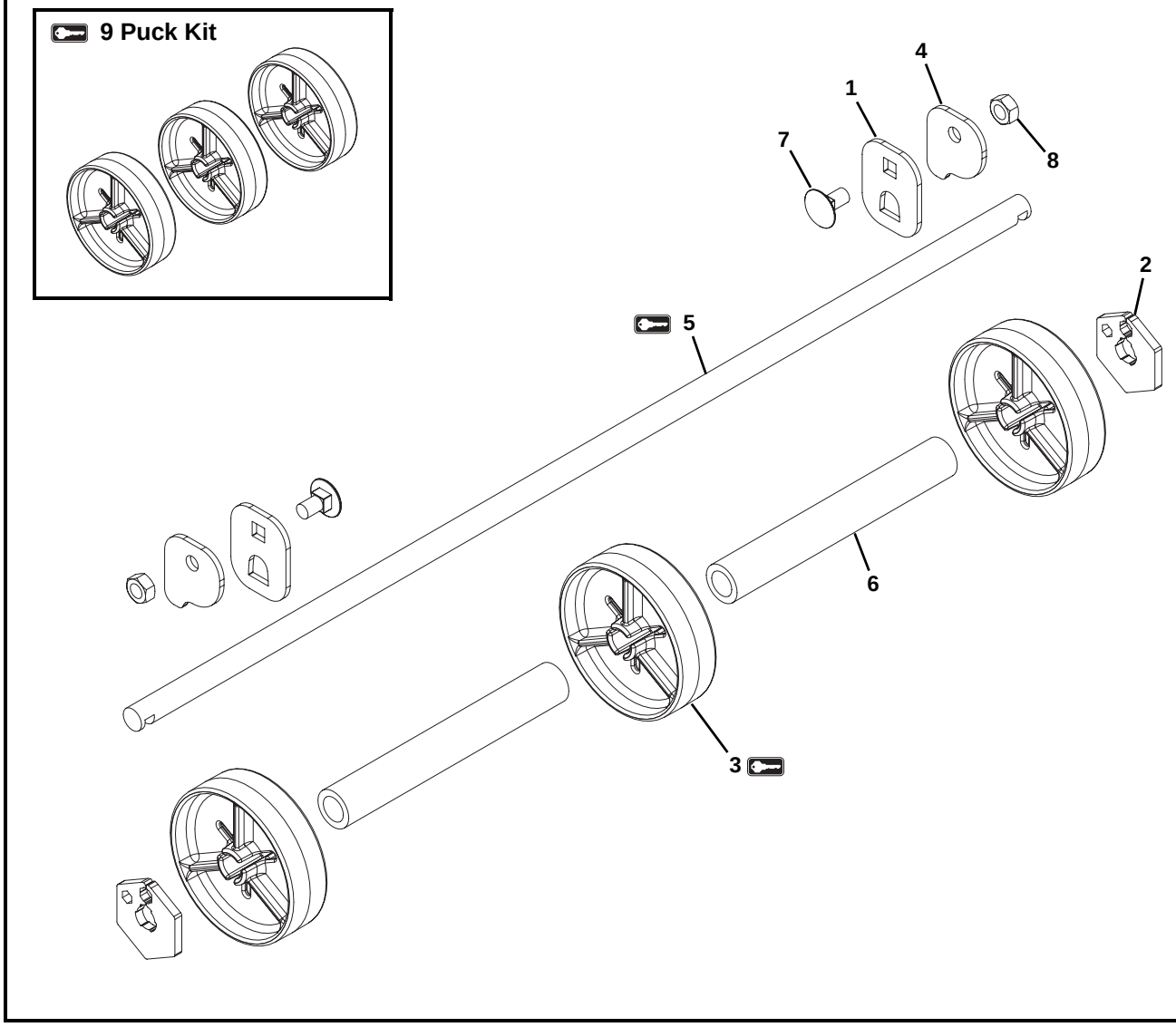
## 152 mm Cleated High Sides




| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518386-06-LLLLL-LH | Guiding, Left Hand |
| 6 | 518386-06-LLLLL-RH | Guiding, Right Hand |
| 7 | 518396-06-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 8 | 518396-06-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |

| Item | Part Number | Description |
|---|---|---|
| 9 | 516998-06-LLLLL-RH | Guiding, Right Hand (for One Piece Guiding) |
| | 516998-06-LLLLL-LH | Guiding, Left Hand (for One Piece Guiding) |
| 10 | 518384-06-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |
| 11 | 960840MSS | Hex Head Cap Screw, M8-1.25 x 40 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

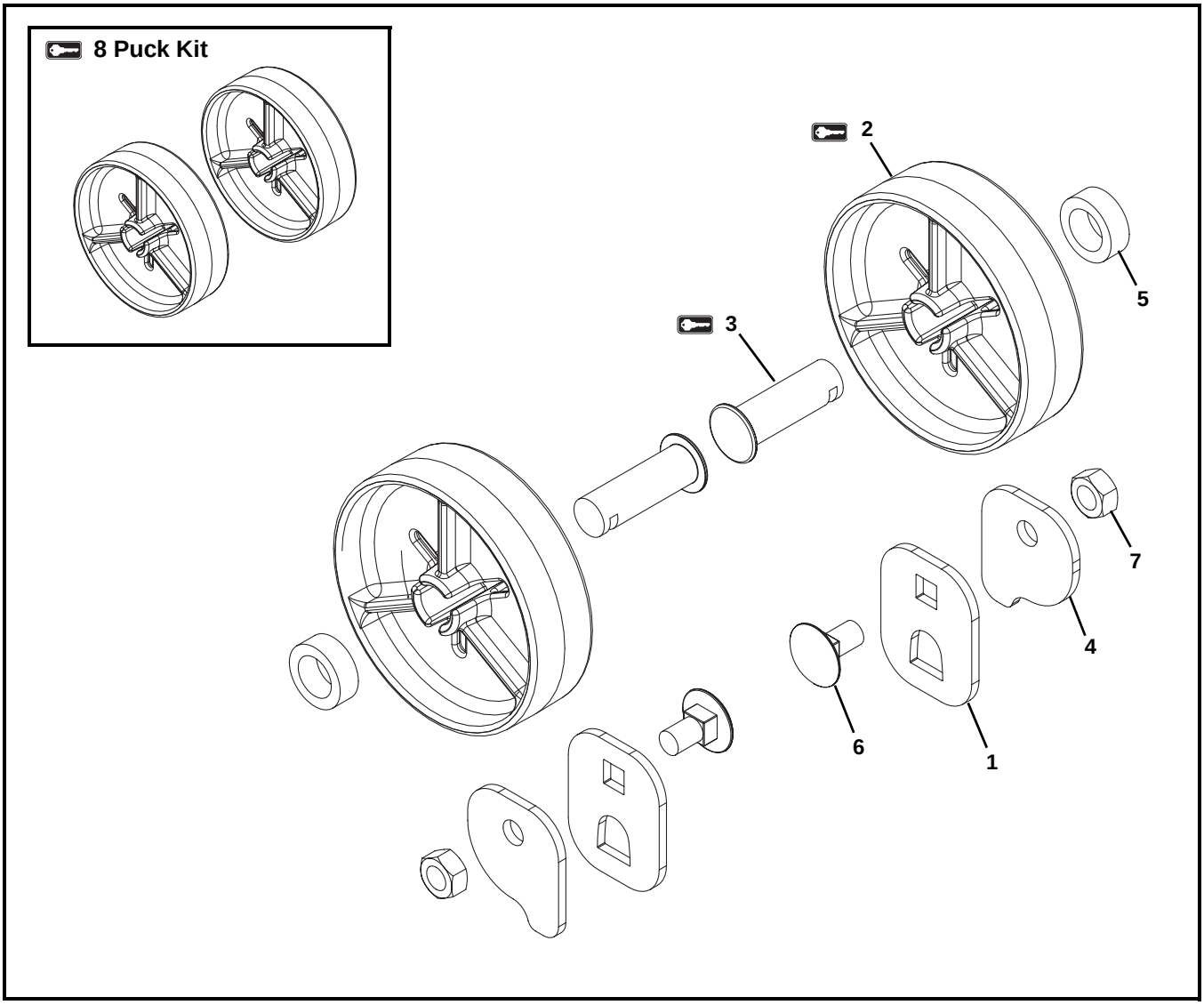
## Flat Belt Returns 610 mm Wide and Wider




| Item | Part Number | Description |
|---|---|---|
| 1 | 516855 | Return Bracket |
| 2 | 517575 | Retaining Plate |
| 3 | 517576 | Puck |
| 4 | 518394 | Return Clip |
| 5 | 517598-LLLLL | Shaft |
| 6 | 518393-00600 | Spacer |
| 7 | 807-3543 | Carriage Bolt, M8 x 16 mm |
| 8 | 990801MSS | Hex Nut |
| 9 | 520368-WW | Puck Kit (Includes item 3) |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

## Cleated Belt and Flat Belt Returns Under 610 mm Wide




| Item | Part Number | Description |
|---|---|---|
| 1 | 516855 | Return Bracket |
| 2 | 517576 | Puck |
| 3 | 517597 | Stub Shaft |
| 4 | 518394 | Return Clip |
| 5 | 518393-00030 | Spacer |
| 6 | 807-3543 | Carriage Bolt, M8 x 16 mm |
| 7 | 990801MSS | Hex Nut |
| 8 | 550369 | Puck Kit (Includes item 2) |

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

## Configuring Conveyor Belt Part Number

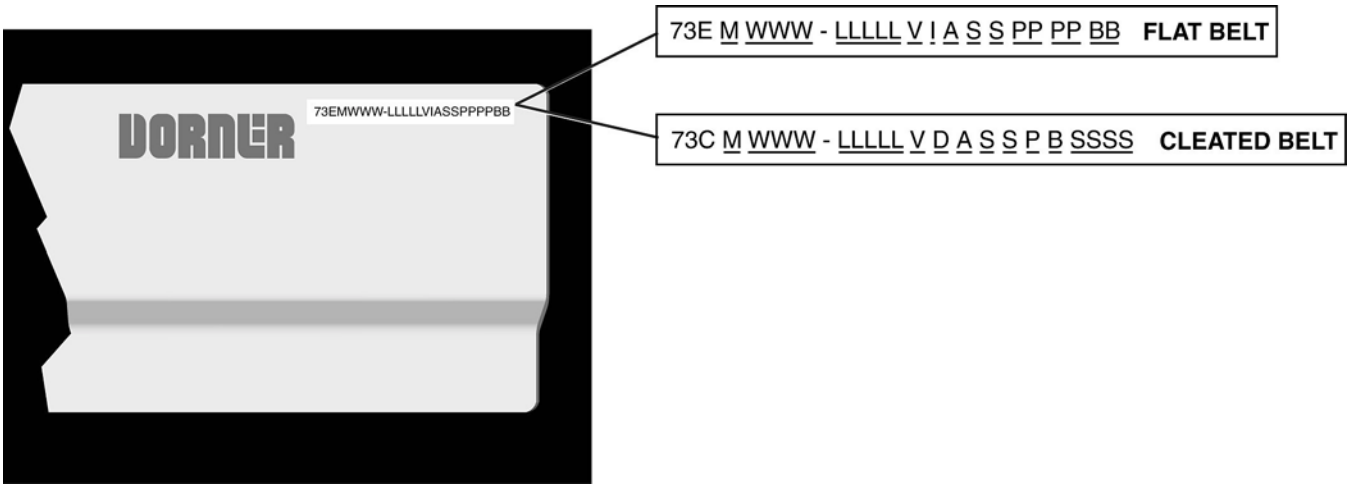



*Figure 139*

### Flat Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 139)**. From the model number determine the conveyor width (WWW), length (LLLLL) and belt type (BB). Use data to configure belt part number as indicated below. *Add “V” for v-guided belts or add “VG” for 06, 08, 57, 59, and 64 v-guided belt types.

**73E-WWW LLLLL / BB V***

**73E-** _____ _____ **/** ___ **V***

**(Fill In)**

### Cleated Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 139)**. From the model number determine the conveyor width (WWW), length (LLLLL), cleat type (B) and cleat spacing (SSSS). Use data to configure belt part number as indicated below. *Add “V” for v-guided belts.

**73C-WWW LLLLL B SSSS V***

**73C-** _____ _____ _ _____ **V***

**(Fill In)**

# Return Policy

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

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

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

<table>
<tr><td></td><td colspan="9">Product Type</td></tr>
<tr><td></td><td colspan="8">Standard Products</td><td>Engineered to order parts</td></tr>
<tr><td>Product Line</td><td>Conveyors</td><td>Gearmotors & Mounting Packages</td><td>Support Stands</td><td>Accessories</td><td>Spare Parts (non-belt)</td><td>Spare Belts - Standard Flat Fabric</td><td>Spare Belts - Cleated & Spec. Fabric</td><td>Spare Belts - Plastic Chain</td><td>All equipment and parts</td></tr>
<tr><td>1100 Series</td><td colspan="6" rowspan="7">30% return fee for all products except:<br>50% return fee for conveyors with modular belt, cleated belt or speciality belts<br><br>All Electrical items are assigned original manufacturers return policy.</td><td colspan="2" rowspan="11">non-returnable</td><td rowspan="11">case-by-case</td></tr>
<tr><td>2200 Series</td></tr>
<tr><td>3200 Series</td></tr>
<tr><td>Pallet Systems</td></tr>
<tr><td>FlexMove/SmartFlex</td></tr>
<tr><td>GAL Series</td></tr>
<tr><td>All Electrical</td></tr>
<tr><td>7100 Series</td><td colspan="6" rowspan="4">50% return fee for all products</td></tr>
<tr><td>7200/7300 Series</td></tr>
<tr><td>AquaGard 7350 Series Version 2</td></tr>
<tr><td>GES Series</td></tr>
<tr><td>AquaGard 7350/7360 Series</td><td colspan="8" rowspan="2">non-returnable</td></tr>
<tr><td>AquaPruf Series</td></tr>
</table>

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

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Customer Service Team will gladly help with your questions on Dorner products.

For a copy of Dorner's Warranty, contact Dorner, an authorized sales channel or visit our website: www.dorner.com.

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

**www.dorner.com**

DORNER

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