



# 2200 Series Modular Belt Conveyors

Installation, Maintenance & Parts Manual



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|                  |
|------------------|
| <b>IMPORTANT</b> |
|------------------|

|   |
|---|
| <i>Some illustrations may show guards removed. DO NOT operate equipment without guards.</i> |
|---|

Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

Dorner 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981, 6,422,382 and corresponding patents and patent applications in other countries.

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

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

# Warnings – General Safety

**⚠ WARNING**

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

**⚠ DANGER**



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

**⚠ DANGER**



**DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.**

**⚠ WARNING**



Gearmotors may be **HOT**. **DO NOT TOUCH** Gearmotors.

**⚠ WARNING**



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

**⚠ WARNING**

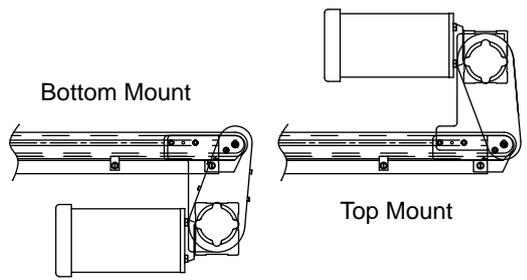


Conveyors are not reversible. Reversing creates pinch points which can cause severe injury. **DO NOT REVERSE CONVEYORS.**

**⚠ WARNING**



Top and Bottom Mount Gearmotors must be mounted as shown below. Failure to do so creates pinch points which can cause severe injury.



**⚠ WARNING**



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

**⚠ WARNING**

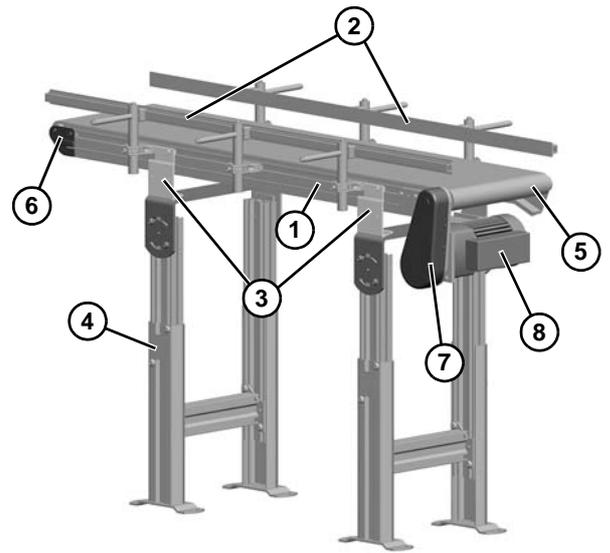


Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury. **SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.**

# Product Description

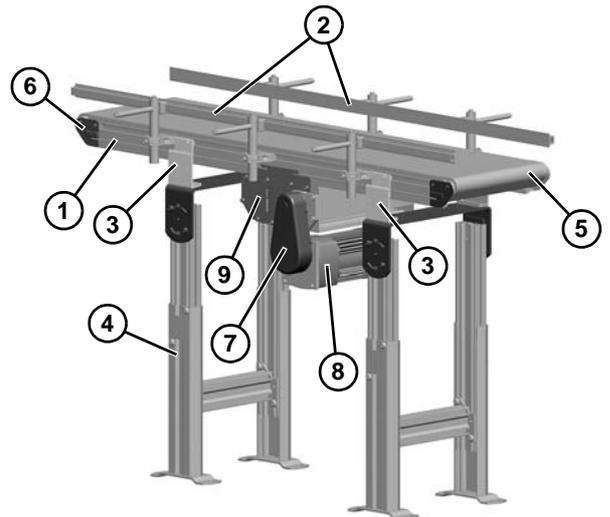
Refer to Figure 1 for typical conveyor components.

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



**End Drive Conveyor**

**Figure 1**



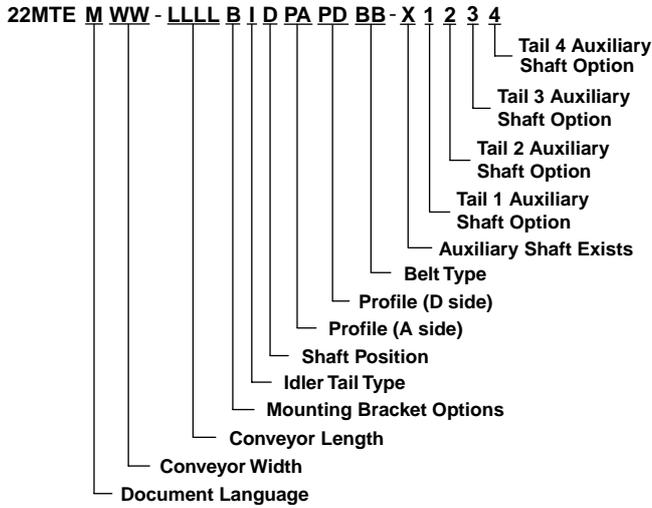
**Center Drive Conveyor**

**Figure 2**

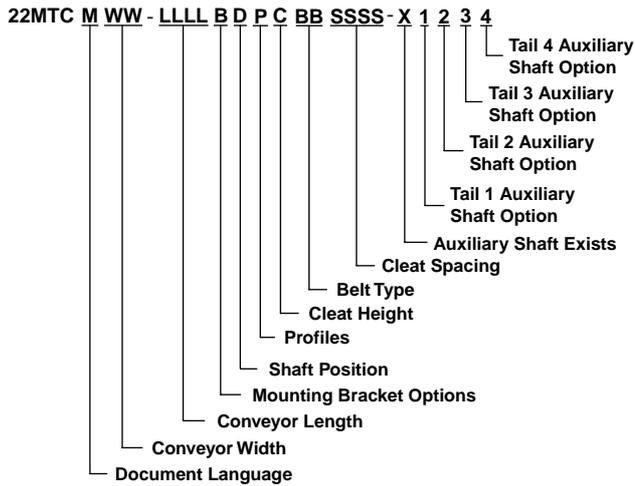
# Specifications

## Models:

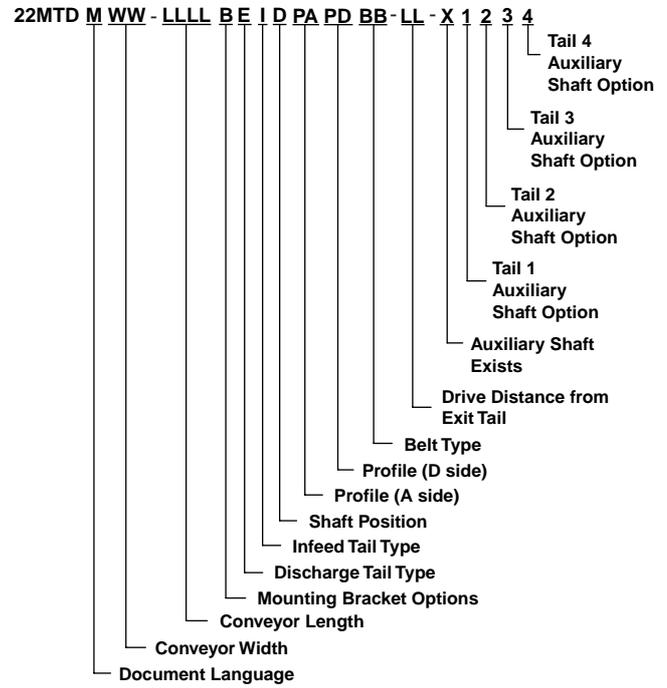
### Flat Belt End Drive Conveyor



### Cleated Belt End Drive Conveyor



### Flat Belt Center Drive Conveyor



\* See Engineering Manual for details.

Center drive location to be at center of first frame section.  
Minimum center drive conveyor length is 91 cm.

## Conveyor Supports:

### Maximum Distances:

1 = 457 mm\*\*

2 = 1829 mm\*\*\*

3 = 457 mm

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

\*\*\* For conveyors longer than 3048 mm, install support at joint.

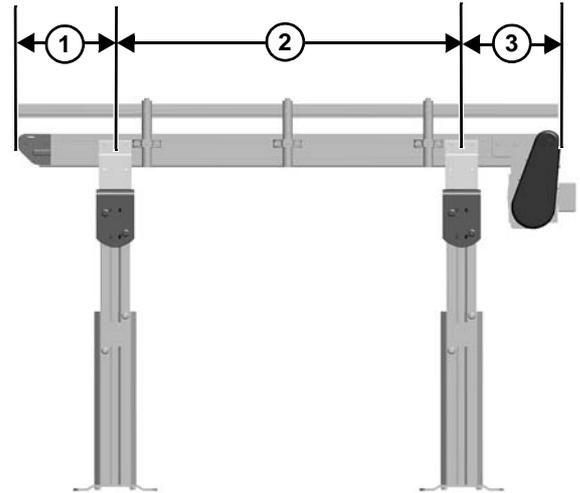


Figure 3

## Conveyor Specifications:

| Standard Micropitch Belts              |                                      |        |        |        |        |        |
|--|--------------------------------------|--------|--------|--------|--------|--------|
| Conveyor Width Reference (WW)          | 04                                   | 06     | 08     | 12     | 18     | 24     |
| Conveyor Belt Width                    | 102 mm                               | 152 mm | 203 mm | 305 mm | 457 mm | 610 mm |
| Conveyor Length Reference (LLLL)       | 01500 to 3000 in 001 increments      |        |        |        |        |        |
| Conveyor Length                        | 457 mm to 9144 mm in 3 mm increments |        |        |        |        |        |
| Belt Travel                            | 136 mm per revolution of pulley      |        |        |        |        |        |
| End / Center Drive Maximum Belt Speed* | 76.2 m/minute                        |        |        |        |        |        |
| iDrive Maximum Belt Speed*             | 27.4 m/minute                        |        |        |        |        |        |

| Standard Metalworking Belts            |                                      |        |        |        |        |        |
|--|--------------------------------------|--------|--------|--------|--------|--------|
| Conveyor Width Reference (WW)          | 03                                   | 06     | 09     | 12     | 18     | 24     |
| Conveyor Belt Width                    | 76 mm                                | 152 mm | 229 mm | 305 mm | 457 mm | 610 mm |
| Conveyor Length Reference (LLLL)       | 01500 to 3000 in 001 increments      |        |        |        |        |        |
| Conveyor Length                        | 457 mm to 9144 mm in 3 mm increments |        |        |        |        |        |
| Belt Travel                            | 150 mm per revolution of pulley      |        |        |        |        |        |
| End / Center Drive Maximum Belt Speed* | 76.2 m/minute                        |        |        |        |        |        |
| iDrive Maximum Belt Speed*             | 27.4 m/minute                        |        |        |        |        |        |

\* See Engineering Manual for details.

# Installation

## ⚠ WARNING

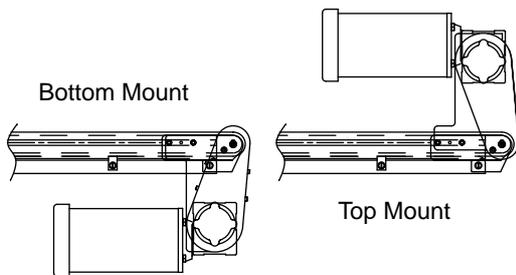


Conveyors are not reversible. Reversing creates pinch points which can cause severe injury.  
**DO NOT REVERSE CONVEYORS.**

## ⚠ WARNING



Top and Bottom Mount Gearmotors must be mounted as shown below.  
Failure to do so creates pinch points which can cause severe injury.



## NOTE

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

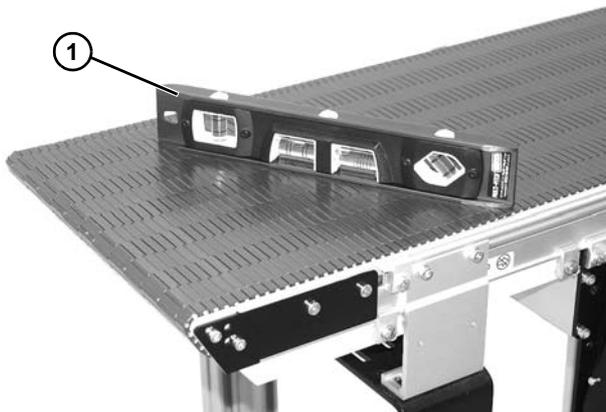


Figure 4

## Required Tools

- Hex-key wrenches: 4 mm, 5 mm
- Level
- Torque wrench
- 2.4 mm wide flat blade screwdriver

## Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor frame (if required)
- Attach mounting brackets to conveyor frame and stands
- Install belt
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories. (See “Service Parts” section beginning on page 26 for details.)

## Conveyors Up to 3048 mm

No assembly is required. Install mounting brackets. Refer to “Mounting Brackets” on page 9.

## Conveyors Longer Than 3658 mm

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

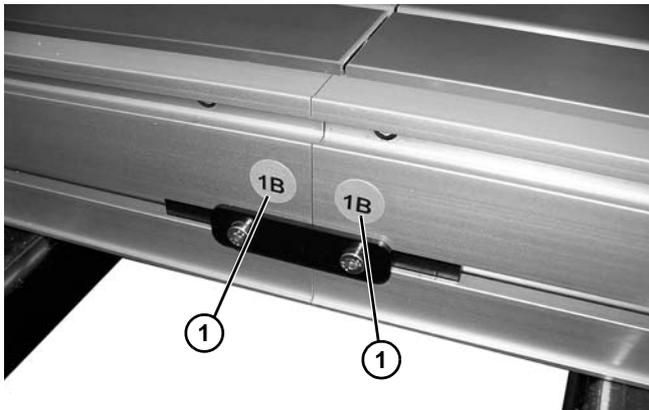


Figure 5

2. Join conveyor sections and install connector brackets (Figure 6, item 1) or connector/mount brackets (Figure 6, item 2) and screws (Figure 6, item 3) on both sides as indicated.

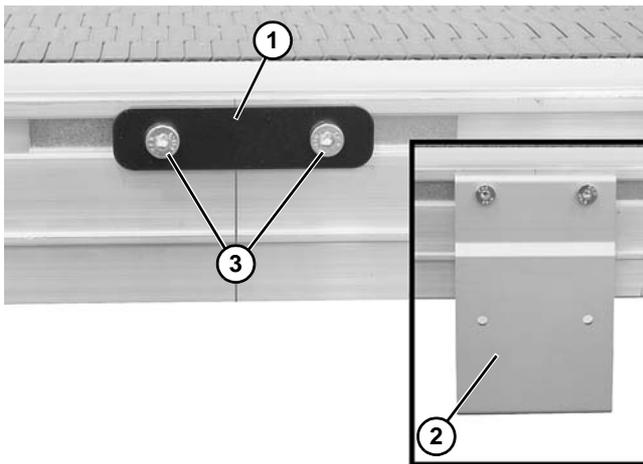


Figure 6

3. Tighten screw (Figure 6, item 3) to 7 Nm on both sides of conveyor.

## Mounting Brackets

1. Locate brackets. Exploded view shown in Figure 7.

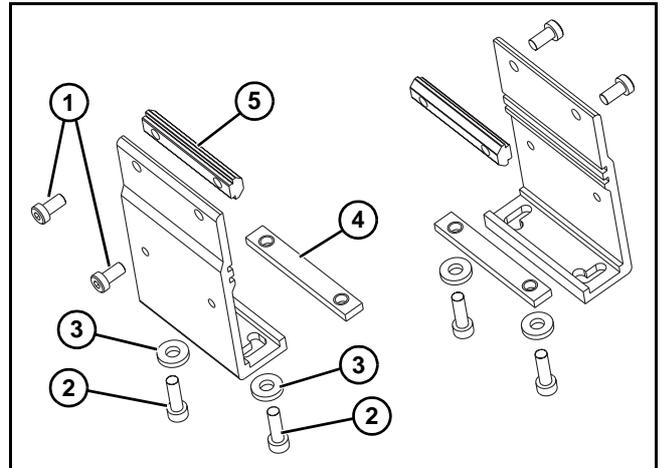


Figure 7

2. Remove screws (Figure 7, item 1 & 2), washers (Figure 7, item 3), nutbars (Figure 7, item 4) and T-bars (Figure 7, item 5) from brackets.
3. Insert T-bars (Figure 7, item 5) into conveyor side slots (Figure 8, item 1). Fasten brackets (Figure 8, item 2) to conveyor with mounting screws (Figure 8, item 3).

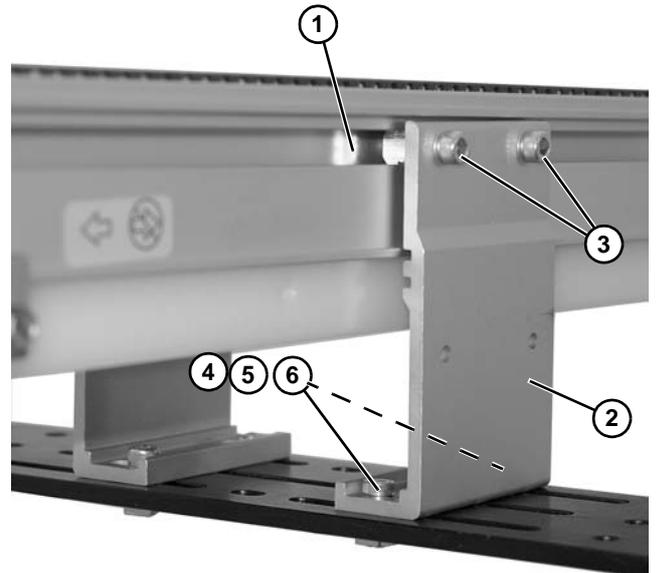


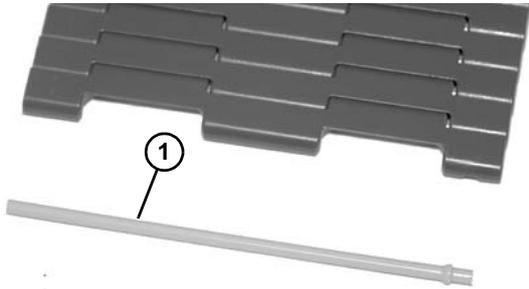
Figure 8

4. Fasten brackets to support stand with mounting screws (Figure 8, item 4), washers (Figure 8, item 5) and nuts (Figure 8, item 6).
5. Tighten screws (Figure 8, item 3 & 4) to 7 Nm.

# Installation

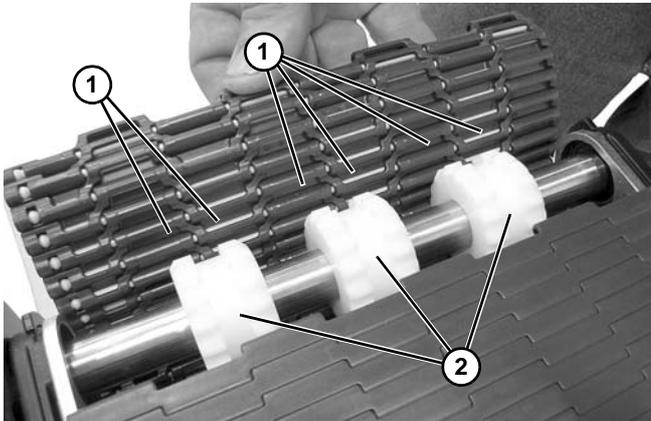
## Installing Plastic Belt

1. Locate the conveyor belt retaining rod (**Figure 9, item 1**).



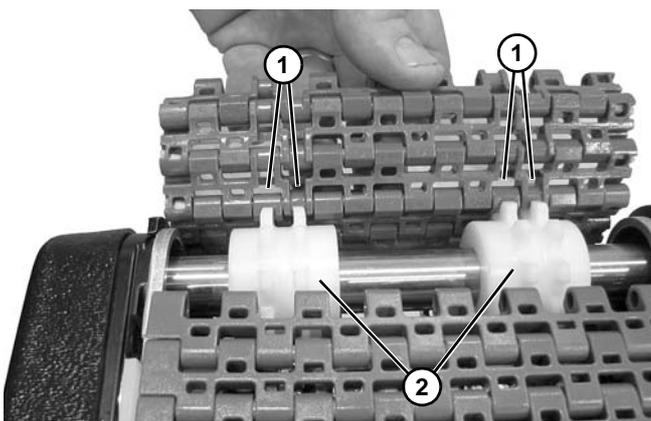
**Figure 9**

2. Align the belt grooves (**Figure 10, item 1**) or (**Figure 11, item 1**) to the evenly spaced sprockets (**Figure 10, item 2**) or (**Figure 11, item 2**) on the drive end of the conveyor.



**Micropitch Belt**

**Figure 10**



**Metalworking Belt**

**Figure 11**

3. Feed belt into bottom wear strips (**Figure 12, item 1**) and pull through to the far end.



**Figure 12**

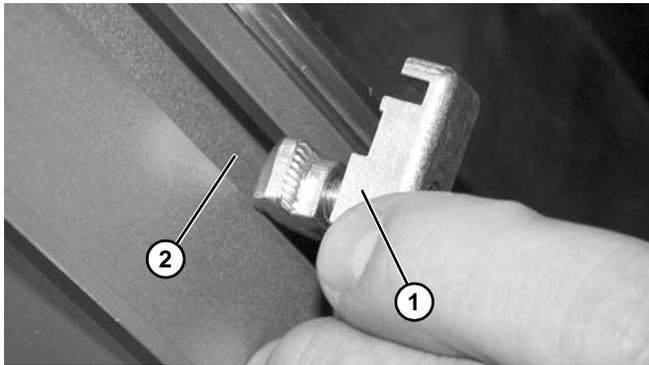
4. Splice the belt together by pushing the plastic rod (**Figure 13, item 1**) through the side hole on the rod retaining side of belt.



**Figure 13**

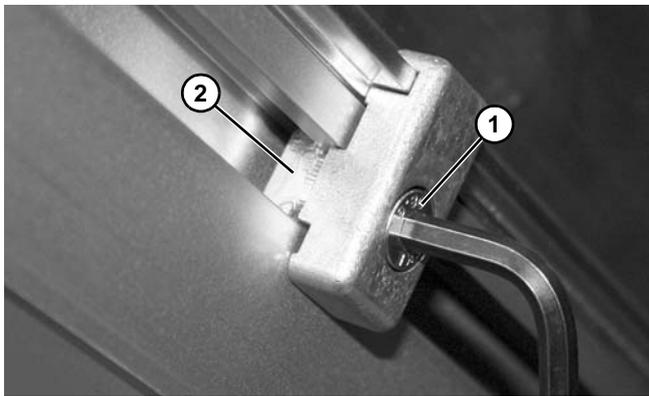
## Guide Clips

1. Install guide clip assembly (**Figure 14, item 1**) into conveyor t-slot (**Figure 14, item 2**) as shown.



**Figure 14**

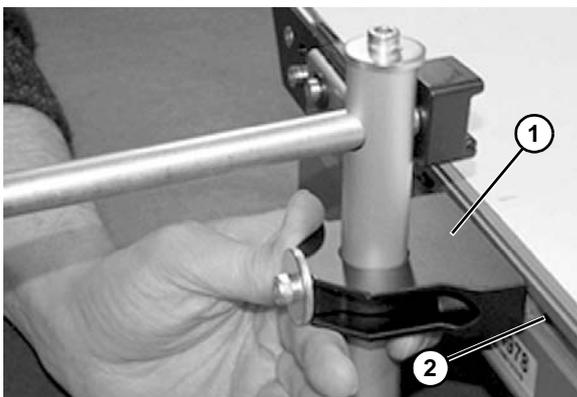
2. Tighten screw (**Figure 15, item 1**) making sure t-bar (**Figure 15, item 2**) rotates and engages inside of t-slot.



**Figure 15**

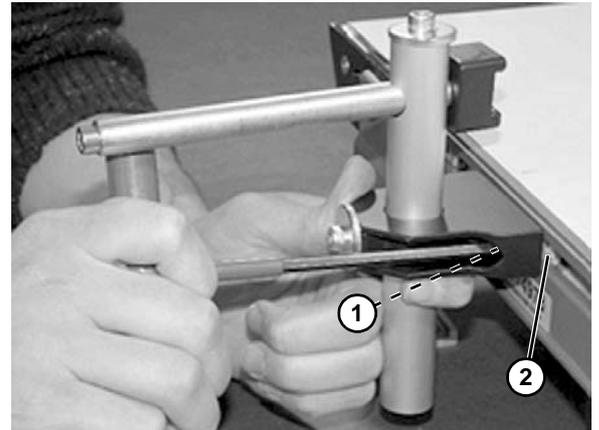
## Adjustable Guides

1. Install guide bracket assembly (**Figure 16, item 1**) into the conveyor t-slot (**Figure 16, item 2**).



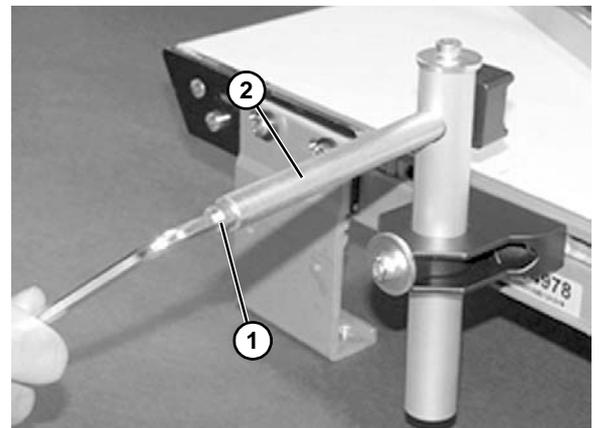
**Figure 16**

2. Tighten screws (**Figure 17, item 1**) making sure t-nut (**Figure 17, item 2**) rotates and engages inside of the t-slot.

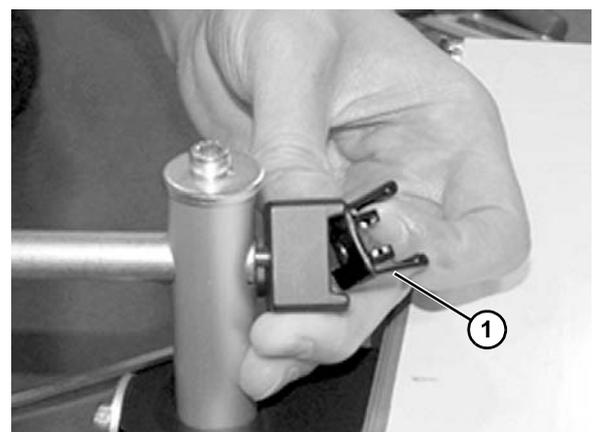


**Figure 17**

3. Loosen screw (**Figure 18, item 1**) on end of shaft (**Figure 18, item 2**) to remove clip (**Figure 19, item 1**).



**Figure 18**



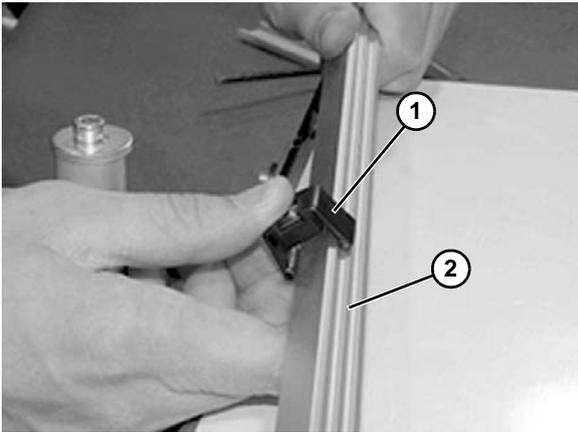
**Figure 19**

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# Installation

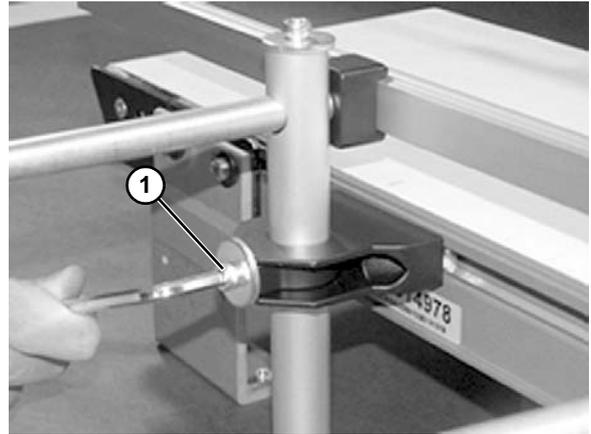
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4. Snap clip (**Figure 20, item 1**) onto guide rail (**Figure 20, item 2**).



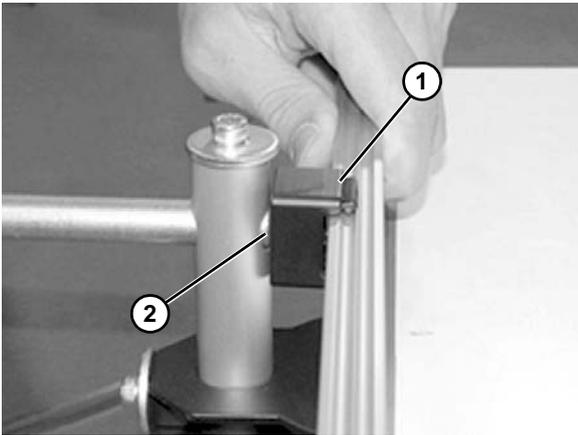
**Figure 20**

7. Adjust rail height with lower screw (**Figure 23, item 1**).



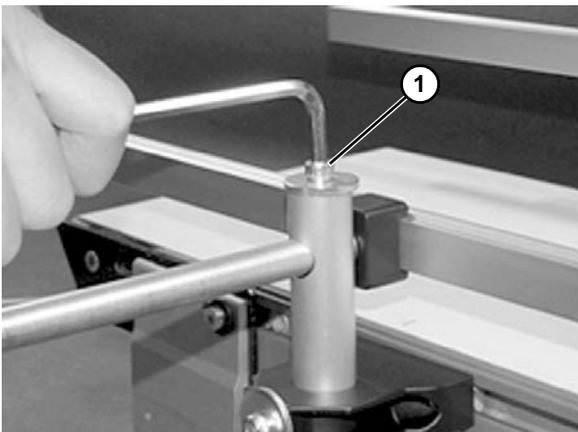
**Figure 23**

5. Reassemble clip (**Figure 21, item 1**) and attach to shaft (**Figure 21, item 2**). Tighten screw (**Figure 18, item 1**) on end of shaft.



**Figure 21**

6. Adjust rail width with top screw (**Figure 22, item 1**).



**Figure 22**

---

# Preventive Maintenance and Adjustment

---

## Required Tools

### Standard Tools

- Hex-key wrenches: 2.5 mm, 4 mm, 5 mm
- 2.4 mm wide flat blade screw driver
- Arbor press
- Adjustable wrench to 25 mm wide

### Special Tools

- 807–1078 Sealed Bearing Removal Tool
- 450293 Sealed Bearing Installation Tool

## Checklist

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

## Lubrication

No lubrication is required. Replace bearings if worn.

## Maintaining Conveyor Belt

### Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Tooth skipping
- Loose links

Surface cuts and wear indicate:

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

Stalling or skipping belt indicates:

- Belt stretching
- Conveyor belt or drive timing belt are not properly tensioned
- Worn sprocket or impacted dirt on drive pulley
- Intermittent jamming or drive train problems

## Cleaning

### IMPORTANT

*Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.*

Use mild soap and water to clean the belt and conveyor. Do not soak the belt.

## Conveyor Belt Replacement

### ⚠ WARNING



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

## Conveyor Belt Replacement Sequence

- Remove old conveyor belt
- Install new conveyor belt

# Preventive Maintenance and Adjustment

## Belt Removal

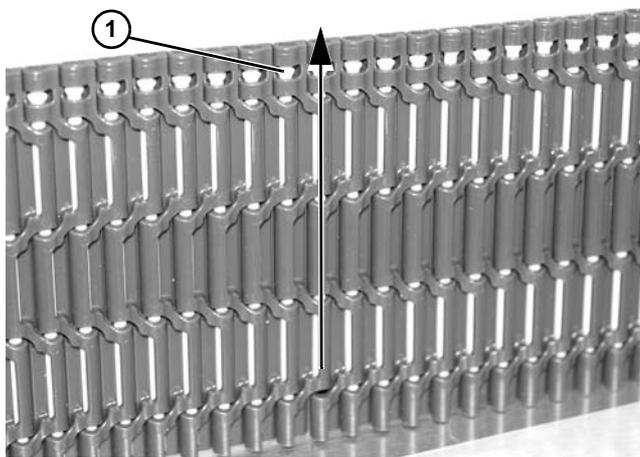
### IMPORTANT

You may need to slightly raise the underside of the conveyor belt to properly drive pin out of slots.

### NOTE

For Micropitch Belts follow steps 1, 2, 3, 6 and 7. For Metalworking Belts follow steps 4, 5, 6 and 7.

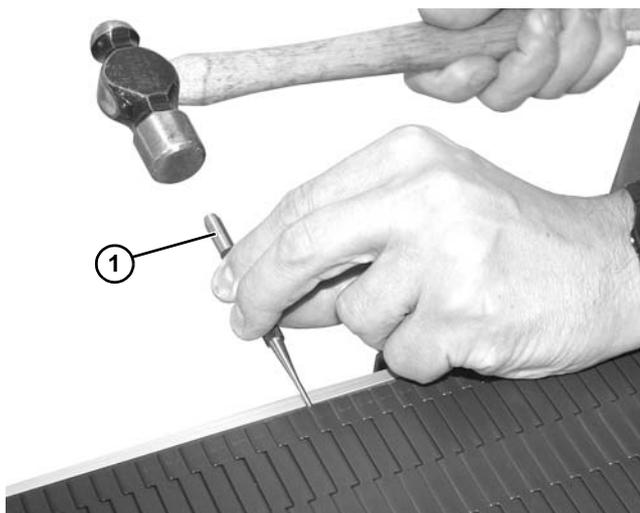
1. Choose one link on either end of the conveyor to remove belt pin. Locate end of rod without retaining feature (Figure 24, item 1).



Micropitch Belt

Figure 24

2. Insert punch (Figure 25, item 1) into non-retaining side of belt, pushing rod out.



Micropitch Belt

Figure 25

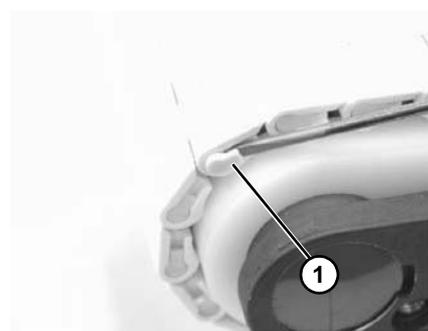
3. Remove rod (Figure 26, item 1) and separate belt.



Micropitch Belt

Figure 26

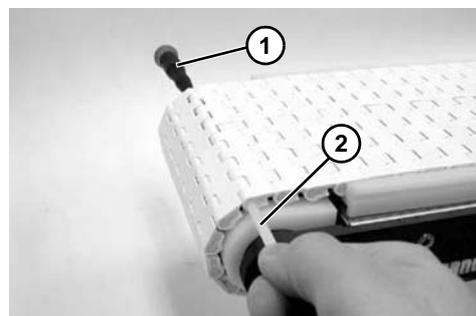
4. Choose one link on the idler end of chain to remove endcaps. With a 2.4 mm flat blade screwdriver, pry under tab of end caps (Figure 27, item 1) and remove end cap. Repeat for opposite side of conveyor.



Metalworking Belt

Figure 27

5. Insert screwdriver (Figure 28, item 1) into one side of belt, pushing rod (Figure 28, item 2) out. Remove rod and separate belt.



Metalworking Belt

Figure 28

# Preventive Maintenance and Adjustment

6. Pull back topside of belt to the drive end of the conveyor. See Figure 29.



Figure 29

7. Remove belt by pulling belt out of bottom wear strips (Figure 30, item 1).

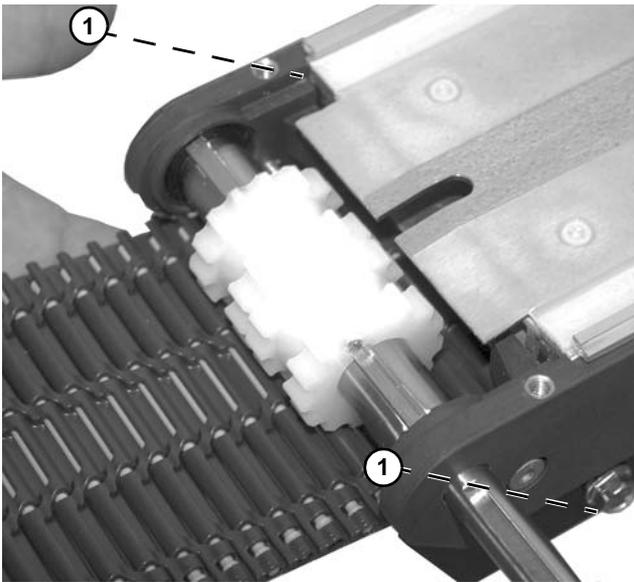


Figure 30

## Belt Installation

1. See "Installing Plastic Belt" page 10.

## Conveyor Belt Tension

### ⚠ WARNING



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

### NOTE

The Modular Belt Conveyor is designed to operate with minimal belt tension. Conveyor will come with proper amount of belt sag at drive end of conveyor belt. See Figure 31. As belt stretches, it may be necessary to remove links to avoid too much belt sag. See Figure 32.

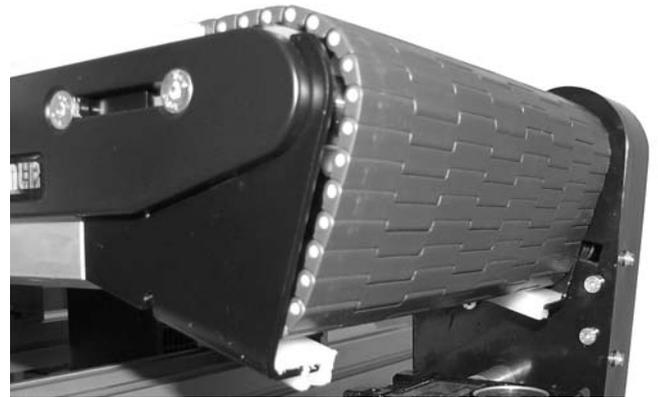


Figure 31



Figure 32

# Preventive Maintenance and Adjustment

|  |
|--|
| <b>⚠ WARNING</b>   |
|   |
| <p>Operating conveyor with belt sag beyond maximum shown in Figure 32 will create belt pinch points which can cause injury.<br/><b>REMOVE BELT LINKS IF MAXIMUM SAG IS REACHED</b></p> |

## Removal of Belt Links

|   |
|---|
| <b>IMPORTANT</b>  |
| <p><i>You may need to slightly raise the underside of the conveyor belt to properly drive pin out of slots.</i></p> |

### Micropitch Belts

1. Choose one link on either end of the conveyor to remove belt pin. Locate end of rod without retaining feature (Figure 33, item 1).

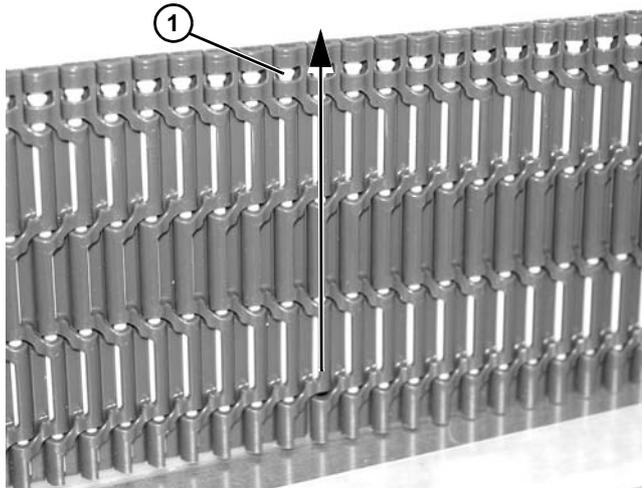


Figure 33

2. Insert punch (Figure 34, item 1) into non-retaining side of belt, pushing rod out.

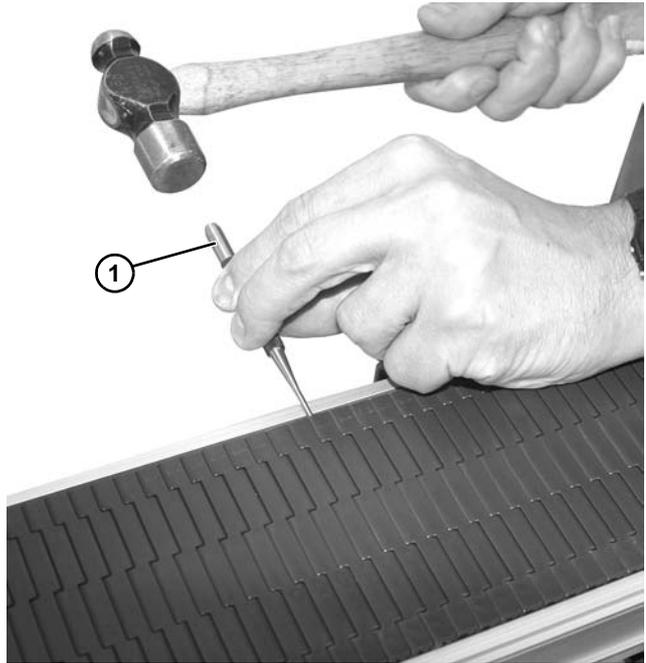


Figure 34

3. Remove rod (Figure 35, item 1) and separate belt.



Figure 35

4. Determine the number of links to be removed. Start with 1 link and remove more as needed. If additional tensioning is required repeat steps 1 - 3.

# Preventive Maintenance and Adjustment

5. Splice the belt together by pushing the plastic rod (Figure 36, item 1) through the side hole on the rod retaining side of belt.

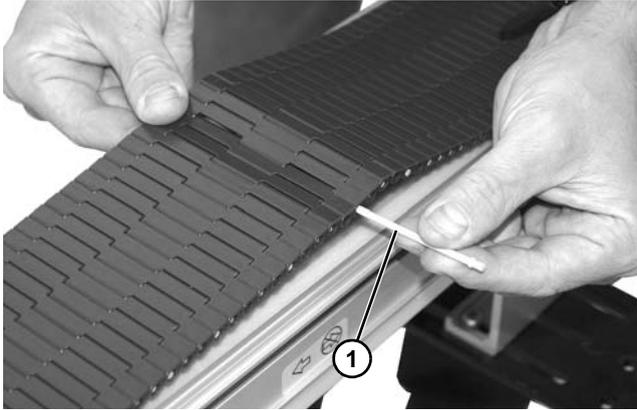


Figure 36

6. Review belt sag at drive end to ensure it stays within the sag area of the tail. If additional tensioning is required repeat steps 1 - 5.

## Metalworking Belts

1. Choose one link on the idler end of chain to remove endcaps. With a 2.4 mm flat blade screwdriver, pry under tab of end caps (Figure 37, item 1) and remove end cap. Repeat for opposite side of conveyor.

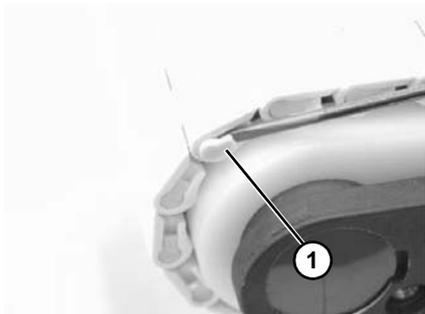


Figure 37

2. Insert screwdriver (Figure 38, item 1) into one side of belt, pushing rod (Figure 38, item 2) out. Remove rod and separate belt.

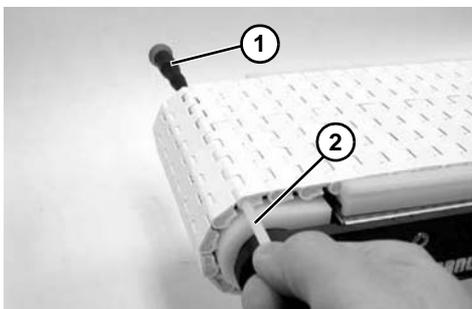


Figure 38

3. Determine the number of links to be removed. Start with 1 link and remove more as needed. If additional tensioning is required repeat steps 1 and 2.
4. Splice the belt together by pushing the plastic rod (Figure 39, item 1) through the side hole.

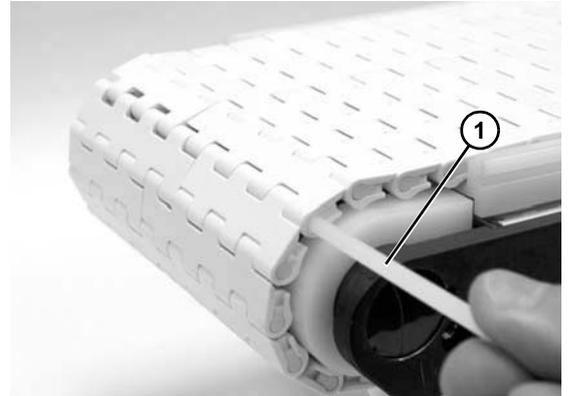


Figure 39

5. Insert rod retaining end caps (Figure 40, item 1) on both sides of belt.

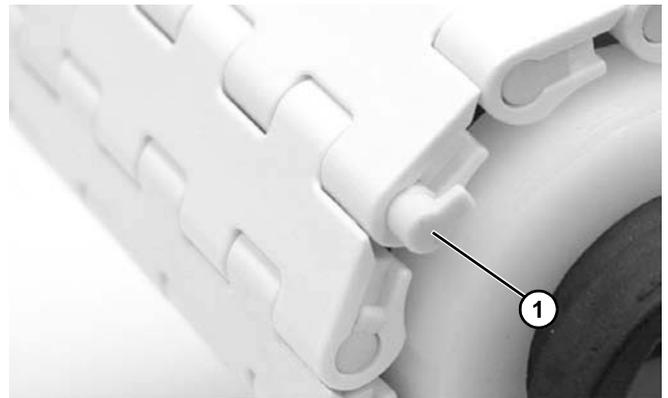


Figure 40

6. Review belt sag at drive end to ensure it stays within the sag area of the tail. If additional tensioning is required repeat steps 1 - 5.

# Preventive Maintenance and Adjustment

## Pulley Removal

|   |
|---|
| <b>⚠ WARNING</b>  |
|                                      |
| <b>Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.</b> |

Remove conveyor belt to access pulley(s). See “Conveyor Belt Replacement” on page 13. Remove the desired pulley following the corresponding instructions below:

- A – End Drive Conveyor
- B – Center Drive Conveyor

### A – End Drive Conveyor

|  |
|--|
| <b>⚠ WARNING</b>   |
|  |
| <b>Drive shaft keyway may be sharp. HANDLE WITH CARE.</b>                          |

1. Remove belt from drive tail. See “Belt Removal” on page 14.
2. Remove upper wear strips (**Figure 41, item 1**) from end drive.

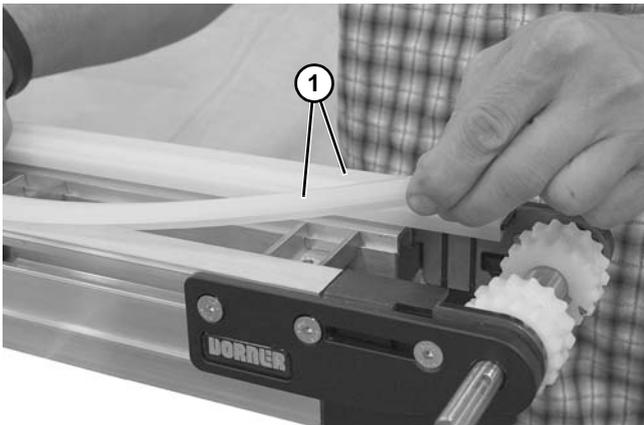


Figure 41

3. Remove lower wear strips (**Figure 42, item 1**) from end drive.

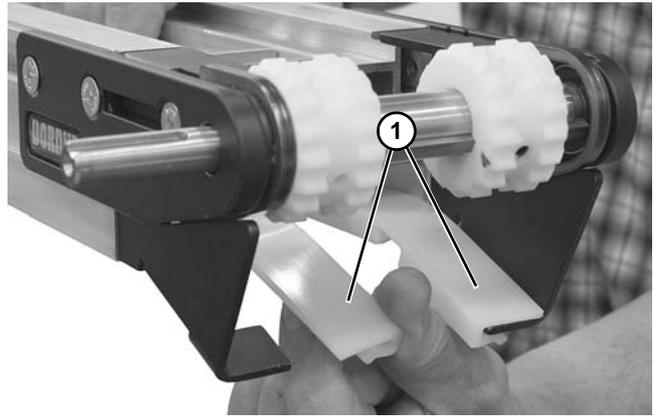


Figure 42

4. Loosen two fastening screws (**Figure 43, item 1**) on both sides of conveyor.

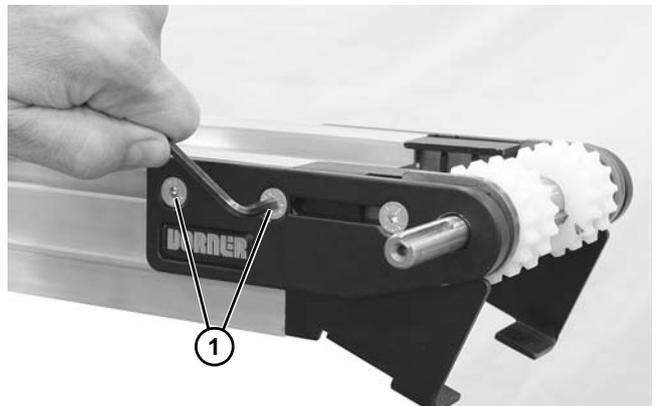


Figure 43

5. Remove end drive (**Figure 44, item 1**) from conveyor.

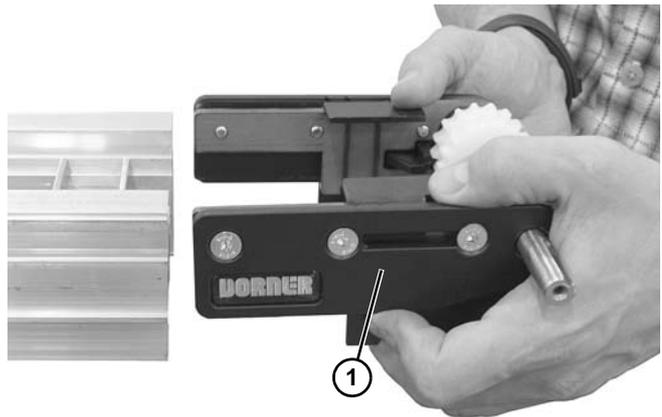
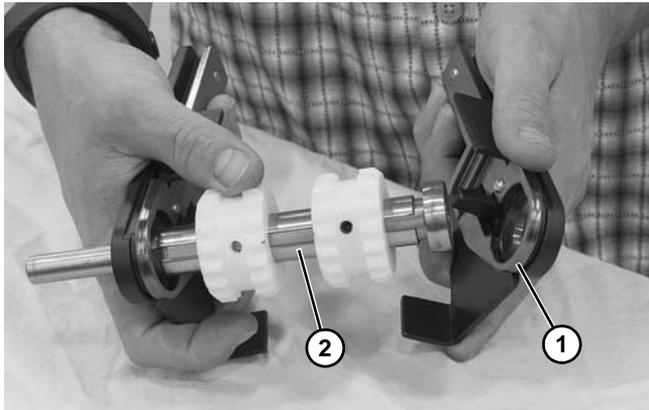


Figure 44

# Preventive Maintenance and Adjustment

6. Remove headplate (**Figure 45, item 1**) and spindle (**Figure 45, item 2**).

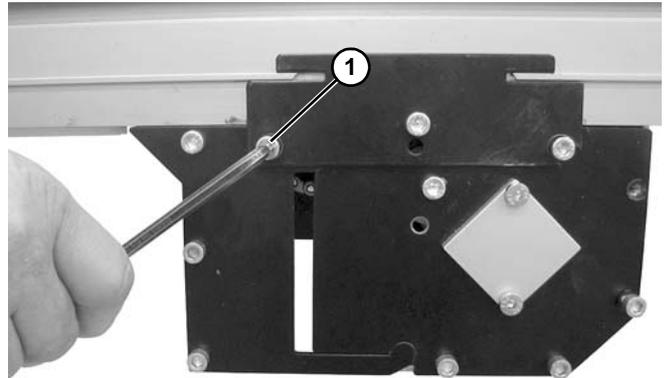


**Figure 45**

7. Remove and replace worn bearings and sprockets. See “Bearing and Sprocket Removal and Replacement” on page 21.
8. Reassemble in reverse order.

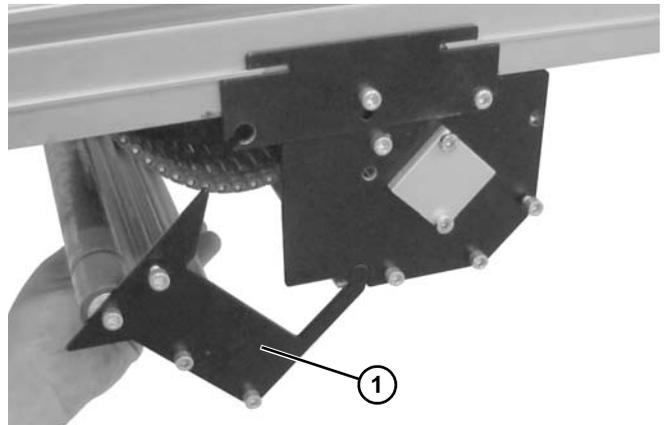
## B – Center Drive Conveyor

1. Loosen screw (**Figure 46, item 1**) on each side of conveyor.



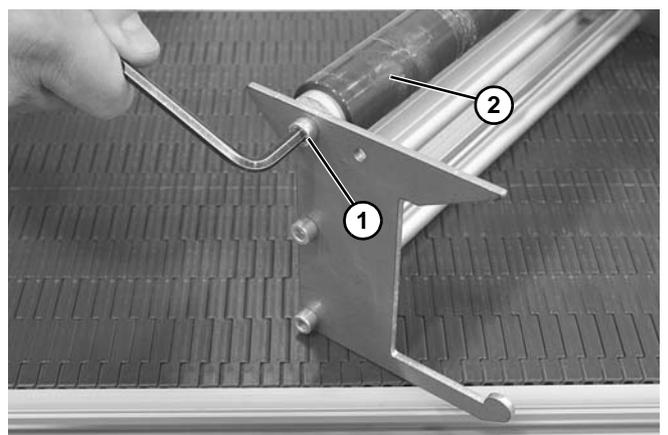
**Figure 46**

2. Lower bracket (**Figure 47, item 1**).



**Figure 47**

3. Remove screw (**Figure 48, item 1**) on both sides of bracket and remove takeup roller (**Figure 48, item 2**).

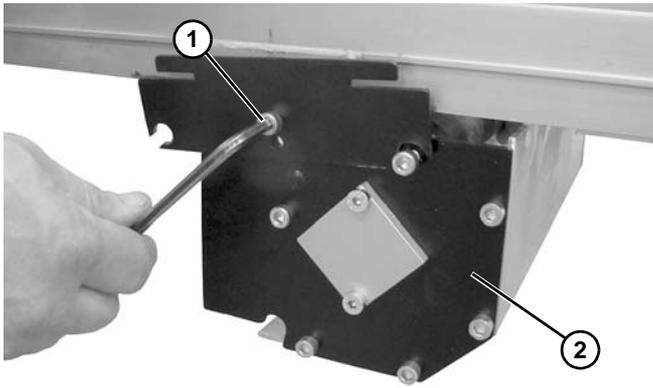


**Figure 48**

4. Remove belt from drive tail. See “Belt Removal” on page 14.

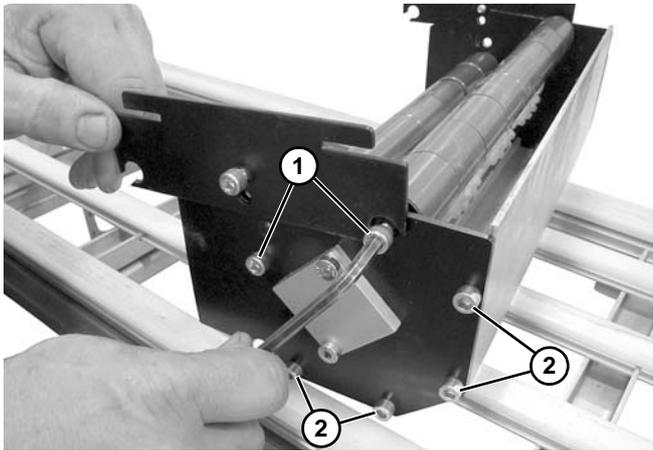
# Preventive Maintenance and Adjustment

- 5. Loosen screw (**Figure 49, item 1**) on both sides of the conveyor to remove center drive module (**Figure 49, item 2**).



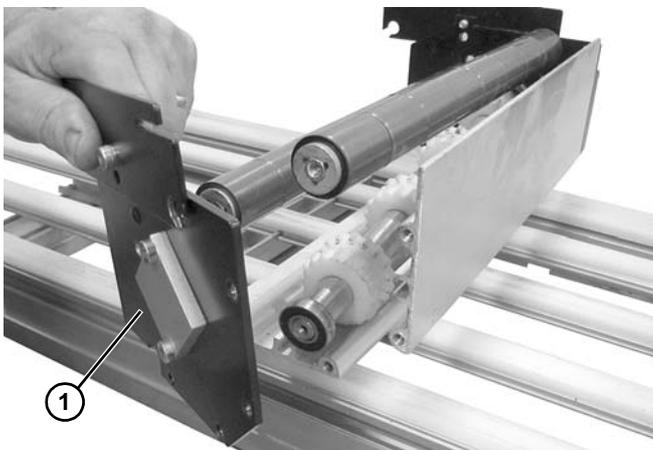
**Figure 49**

- 6. Remove two screws (**Figure 50, item 1**) on both sides of the center drive module.



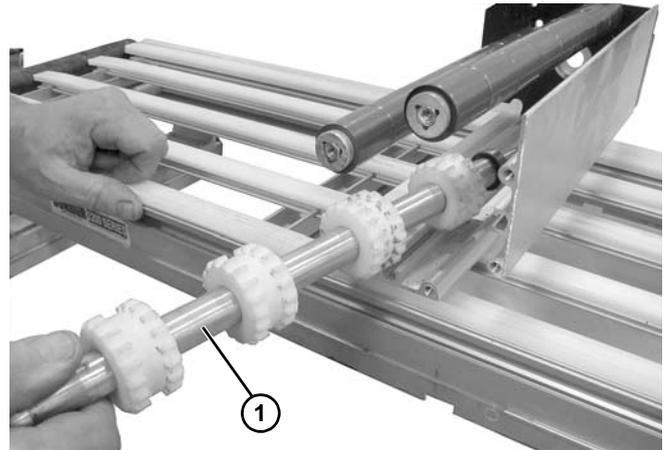
**Figure 50**

- 7. Remove four screws (**Figure 50, item 2**) from the non-motor side of the center drive module.
- 8. Remove side plate (**Figure 51, item 1**).



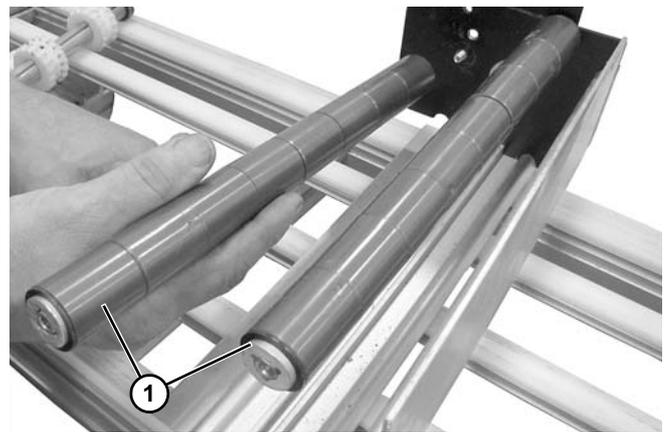
**Figure 51**

- 9. Remove drive shaft (**Figure 52, item 1**).



**Figure 52**

- 10. Remove and replace worn bearings and sprockets. See “Bearing and Sprocket Removal and Replacement” on page 21.
- 11. Remove shafts (**Figure 53, item 1**), replace if worn.



**Figure 53**

- 12. Reassemble in reverse order.

# Preventive Maintenance and Adjustment

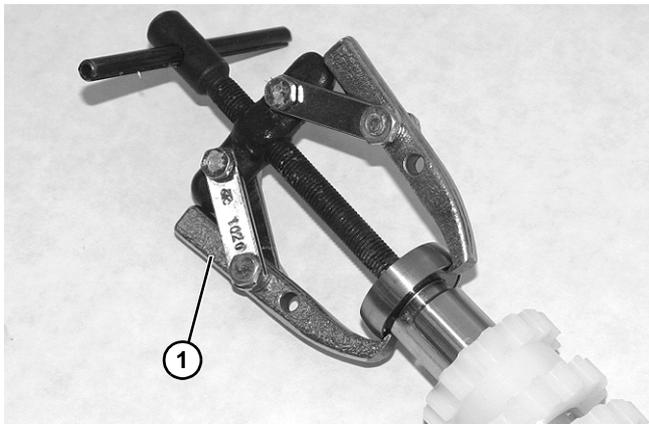
## Bearing and Sprocket Removal and Replacement

### Removal

1. Remove drive pulley. For end drive pulley see section "A – End Drive Conveyor." For center drive pulley see section "B – Center Drive Conveyor."
2. Use bearing removal tool (807-1078) (**Figure 54, item 1**) to remove bearings from drive pulley.

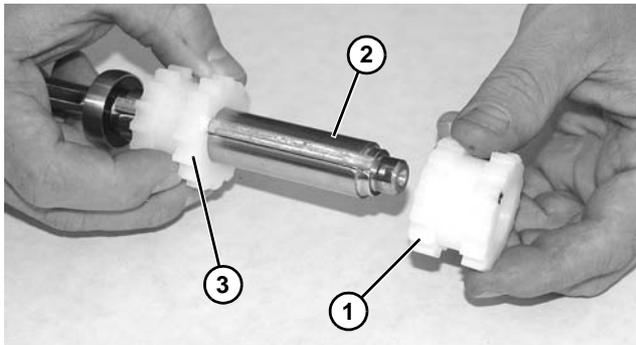
### IMPORTANT

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



**Figure 54**

3. Slide free moving sprocket(s) (**Figure 55, item 1**) off the end of pulley (**Figure 55, item 2**).

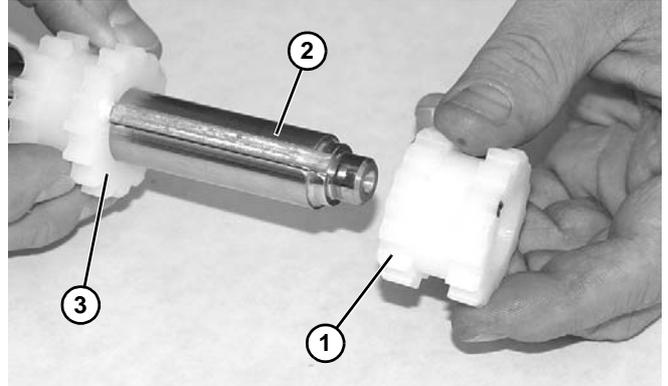


**Figure 55**

4. Measure location of fixed sprocket (**Figure 55, item 3**), loosen set screw, and remove fixed sprocket.

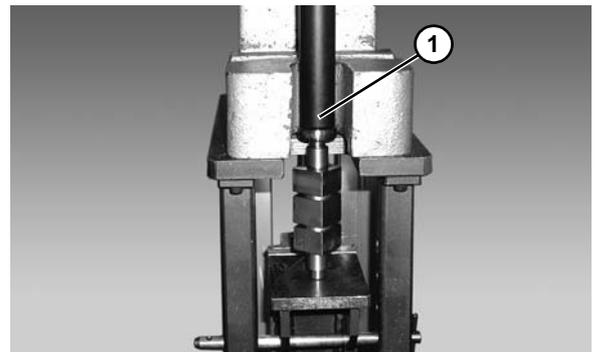
### Replacement

1. Inspect headplate bearing surface. If worn or damaged, replace headplate. See "Service Parts" on page 26.
2. Install required quantity of free moving sprockets (**Figure 56, item 1**) onto drive pulley (**Figure 56, item 2**).



**Figure 56**

3. Install fixed sprocket (**Figure 56, item 3**) at the same location it was removed, making sure it engages the belt. Tighten set screw.
4. Press new bearing onto drive pulley using installation tool 450293 (**Figure 57, item 1**).



**Figure 57**

# Preventive Maintenance and Adjustment

## Idler End Wear Items

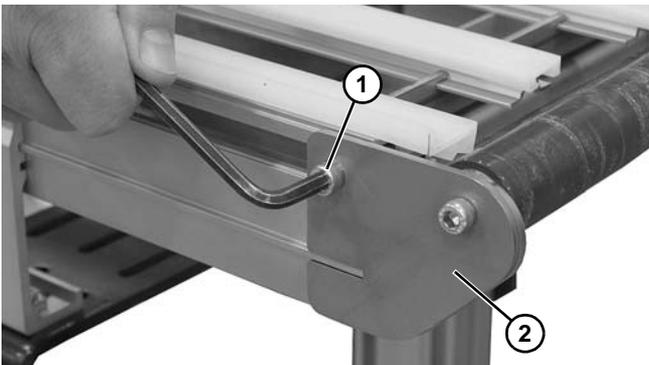
|  |
|--|
| <b>⚠ WARNING</b>   |
|   |
| <p><b>Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.</b></p> |

Remove conveyor belt to access pulley(s). See “Conveyor Belt Replacement” on page 13. Remove the desired pulley following the corresponding instructions below:

- A – Standard Idler Tail
- B – Nose Bar Idler Tail

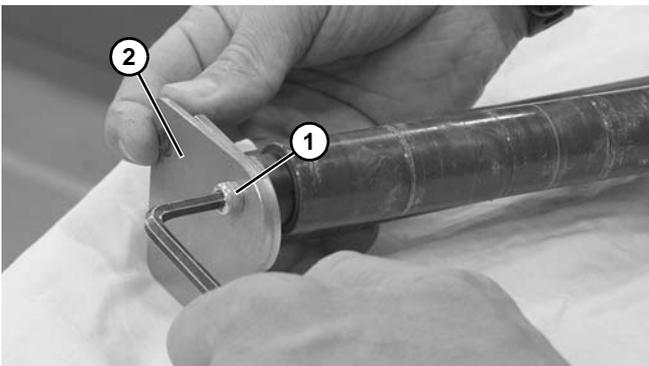
### A - Standard Idler Tail

1. On both sides of conveyor, remove fastening screw (Figure 58, item 1).



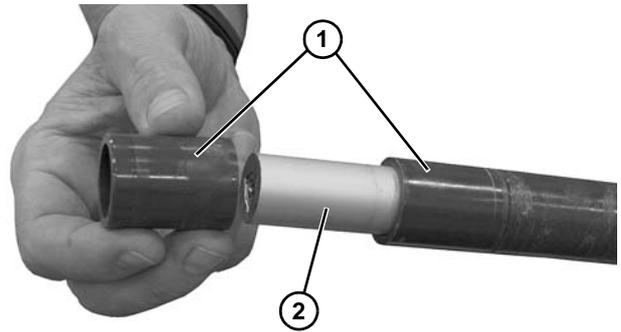
**Figure 58**

2. Remove idler tail (Figure 58, item 2) from conveyor.
3. Remove screw (Figure 59, item 1) and headplate (Figure 59, item 2).



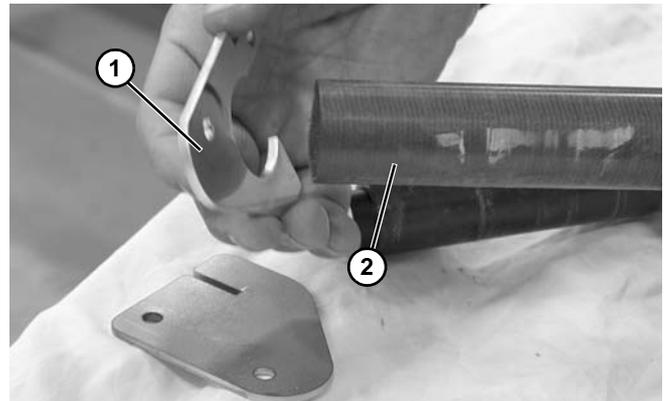
**Figure 59**

4. Slide idler sleeves (Figure 60, item 1) off the end of the idler shaft (Figure 60, item 2). If equipped, remove second idler shaft and remove idler sleeves.



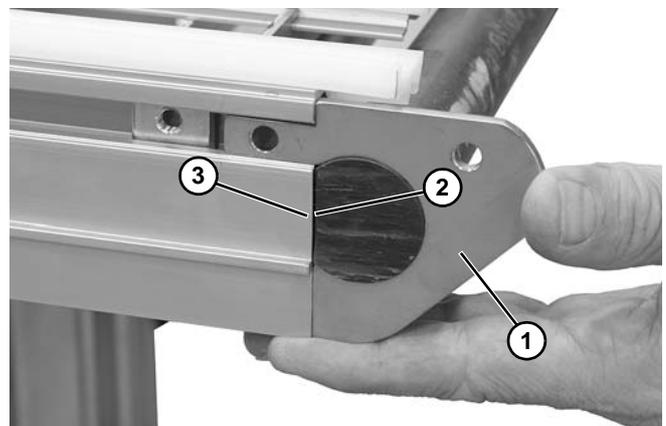
**Figure 60**

5. If equipped, remove retaining plates (Figure 61, item 1) off the ends of the wear bar (Figure 61, item 2). Inspect bar surface. If worn or damaged, replace bar. See “Service Parts” on page 26.



**Figure 61**

6. When re-installing idler tail (Figure 62, item 1) with wear bar, make sure that the flat end (Figure 62, item 2) of the wear bar is flush against the conveyor (Figure 62, item 3).



**Figure 62**

# Preventive Maintenance and Adjustment

## B - Nose Bar Idler Tail

1. On both sides of conveyor, remove two fastening screws (Figure 63, item 1).

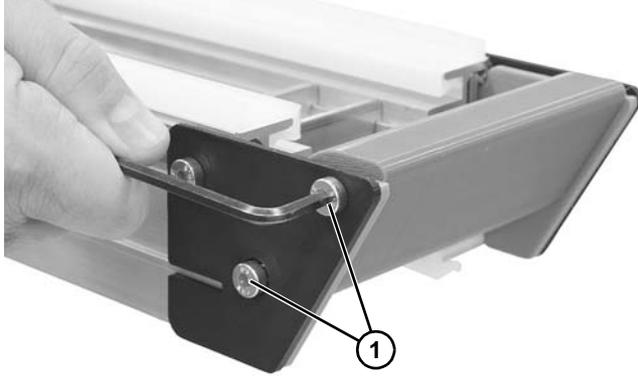


Figure 63

2. Remove bar (Figure 64, item 1), flip 180°, and re-install bar.

|  |
|--|
| <b>NOTE</b>  |
| <i>Bar may be flipped 180° to use second wear surface (Figure 64, item 2).</i> |

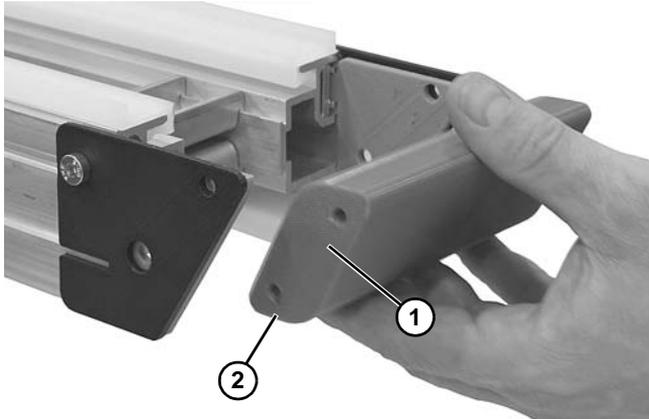


Figure 64

## Frame Wear Strip Replacement

### ⚠ WARNING



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

1. Remove conveyor belt. See “Belt Removal” section on page 14.
2. Remove upper wear strips (Figure 65, item 1).

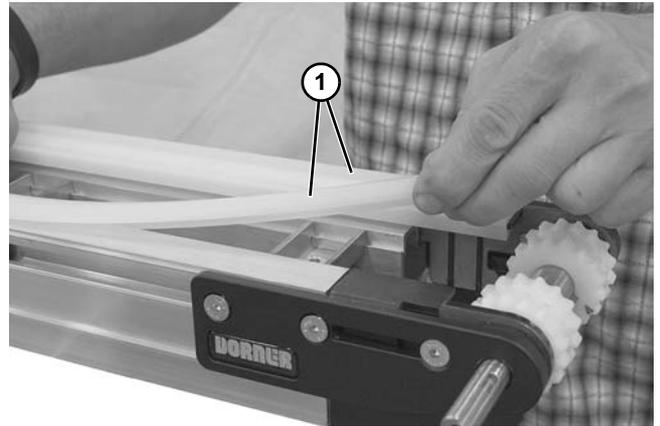


Figure 65

3. Remove lower wear strips (Figure 66, item 1).

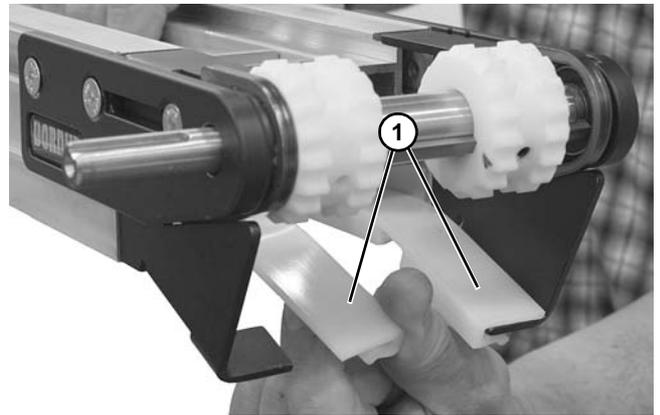


Figure 66

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# Preventive Maintenance and Adjustment

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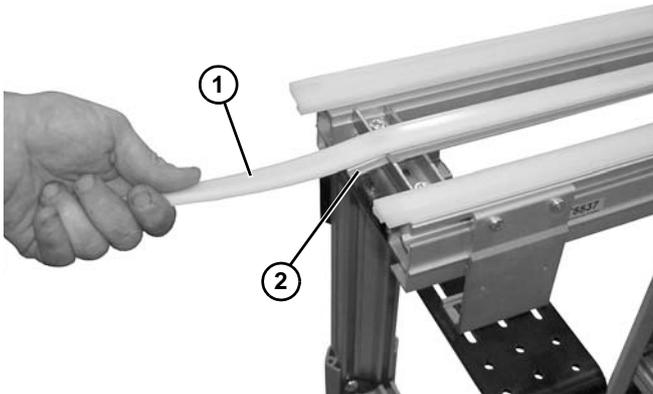
## Center Rail Replacement

### **⚠ WARNING**



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

1. Remove conveyor belt. See “Belt Removal” section on page 14.
2. Slide center rail (**Figure 67, item 1**) from frame assembly (**Figure 67, item 2**).



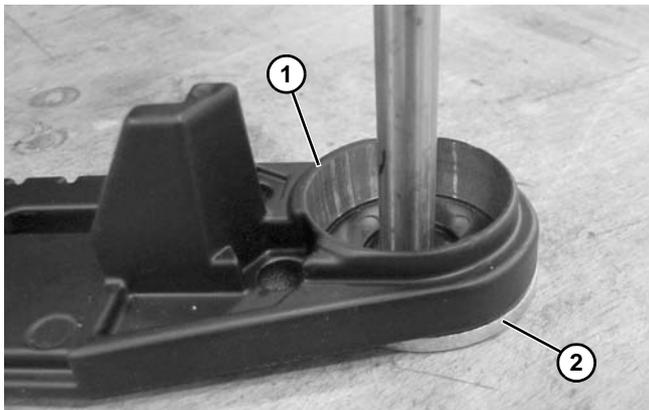
**Figure 67**

3. Install new center rail.

# Preventive Maintenance and Adjustment

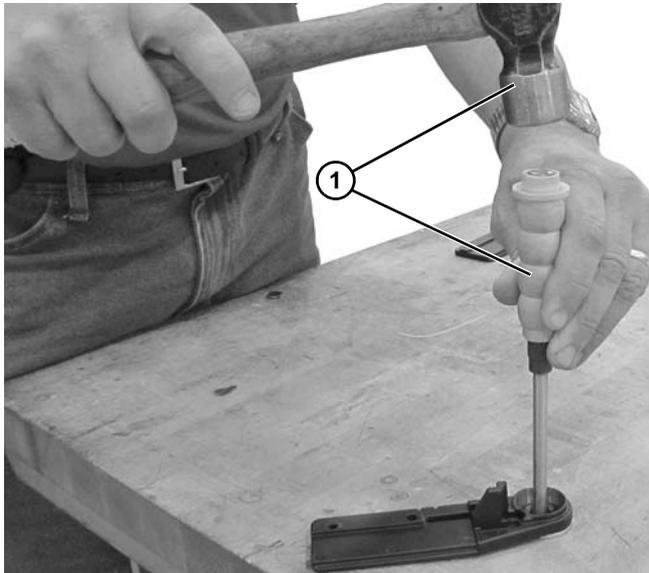
## Tail Plate Shaft Knockout Removal

1. Determine which tail plate or plates require the removal of the hole knockout slug for the drive shaft.
  - Position A or B = 205370-LH
  - Position C or D = 205370-RH
2. Set tail plate (**Figure 68, item 1**) flat side down over washer (**Figure 68, item 2**) or hole in workbench that has a minimum diameter of 16 mm.

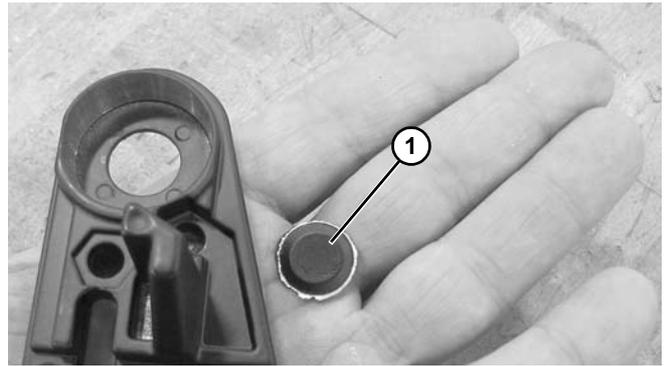


**Figure 68**

3. Use a hammer and punch (6 mm - 13 mm diameter) (**Figure 69, item 1**) or long bolt to knock out slug (**Figure 73, item 1**) for shaft backing up tail plate with washer.

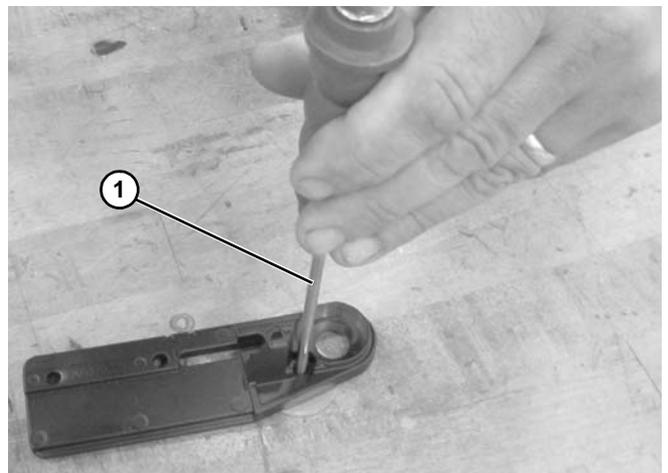


**Figure 69**

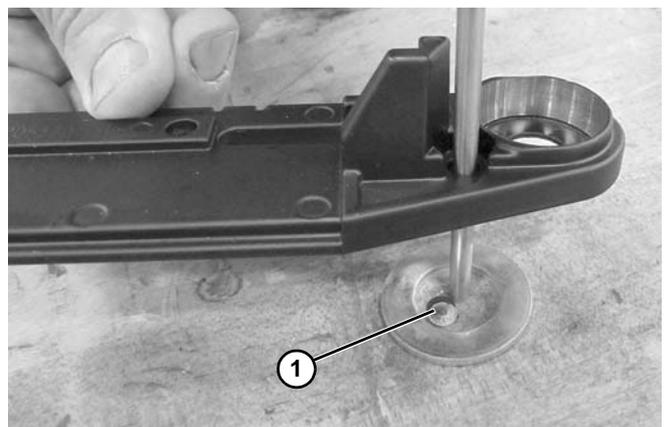


**Figure 70**

4. Repeat the same operation to knockout (**Figure 72, item 1**) for alignment screw hole using 3 mm - 5 mm punch (**Figure 71, item 1**) or M5 - M6 bolt.



**Figure 71**



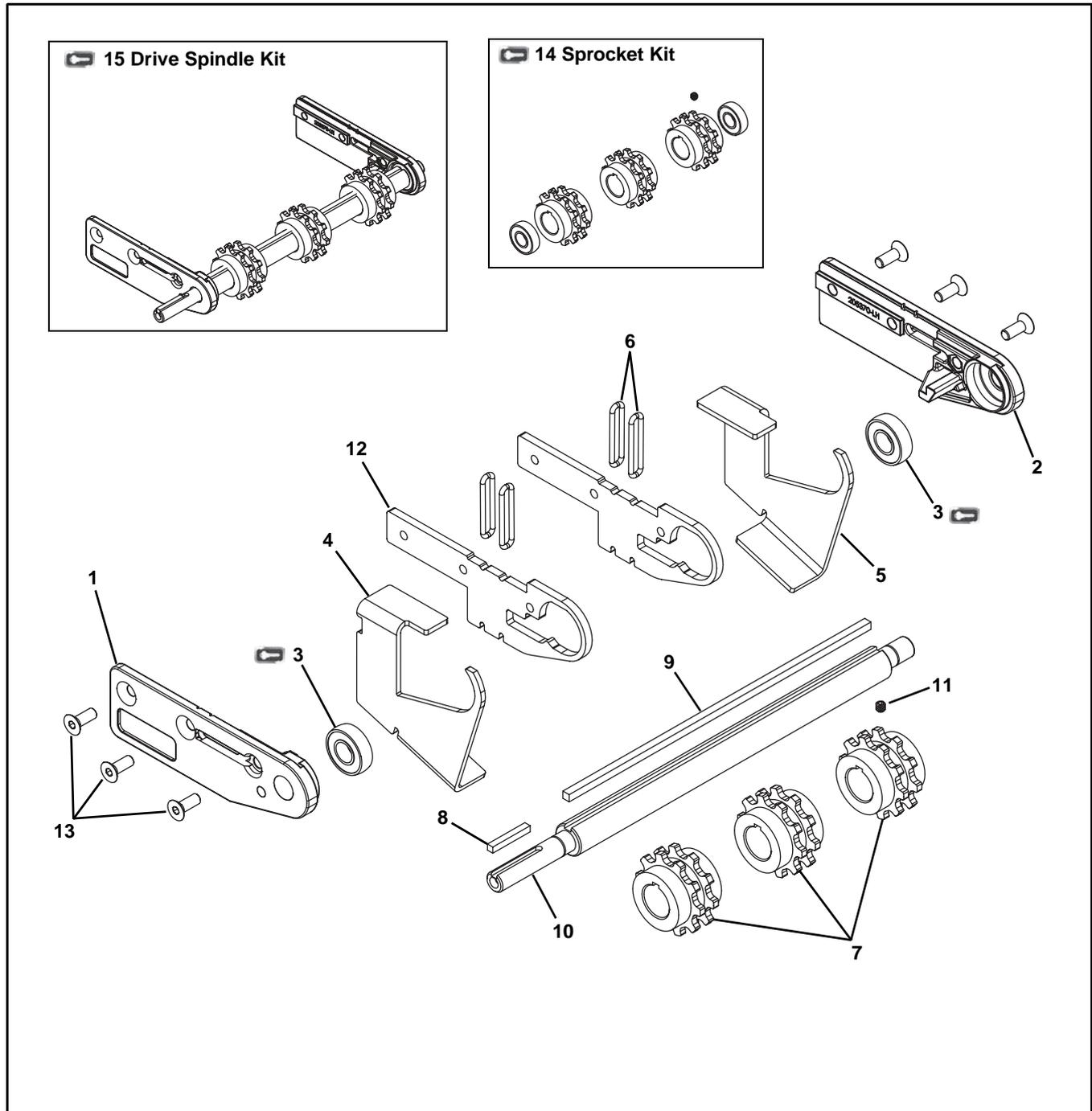
**Figure 72**

# Service Parts

## NOTE

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

## End Drive Tail



# Service Parts

| Item | Part Number         | Description  |
|------|---------------------|--|
| 1    | 205370-RH           | Headplate, Right Hand for Metal Working Conveyors and 04 wide Micropitch Conveyors |
|      | 207140-RH           | Headplate, Right Hand for 08 - 24 wide Micropitch Conveyors                        |
| 2    | 205370-LH           | Headplate, Left Hand for Metal Working Conveyors and 04 wide Micropitch Conveyors  |
|      | 207140-LH           | Headplate, Left Hand for 08 - 24 wide Micropitch Conveyors                         |
| 3    | 22BK2               | Bearing Kit (2 Pack)   |
|      | 22BK4               | Bearing Kit (4 Pack)   |
| 4    | 206792              | Pinch Tail, Right Hand   |
| 5    | 206791              | Pinch Tail, Left Hand  |
| 6    | 915-346             | O-Ring   |
| 7    | 203765              | Sprocket for Micropitch Conveyors  |
|      | 203766              | Sprocket for Metal Working Conveyors   |
| 8    | 980428M             | Square Key, 4 mm x 28 mm   |
| 9    | 201433- <u>WW</u>   | Sprocket Key   |
| 10   | 206023K- <u>WW</u>  | Spindle (One Keyed Shaft)  |
|      | 206194KK- <u>WW</u> | Dual Shaft Spindle (Two Keyed Shafts)  |
|      | 206194KS- <u>WW</u> | Common Drive Spindle (Keyed Shaft & Stub Shaft)                                    |
|      | 206194SS- <u>WW</u> | Common Drive Spindle - Mid Conveyor (Two Stub Shafts)                              |
|      | 206023S- <u>WW</u>  | Common Drive Spindle - End Conveyor (One Stub Shaft)                               |
| 11   | 970505M             | Cup Set Screw, M5-0.80 x 5 mm  |
| 12   | 206790              | Nutbar Tail  |
| 13   | 930616M             | Flat Head Screw, M6-1.00 x 16 mm   |
| 14   | 22V2MB1S- <u>WW</u> | Sprocket Kit for Micropitch Conveyors (Includes Items 3, 7, & 11)                  |
|      | 22V2MB2S- <u>WW</u> | Sprocket Kit for Metal Working Conveyors (Includes Items 3, 7, & 11)               |

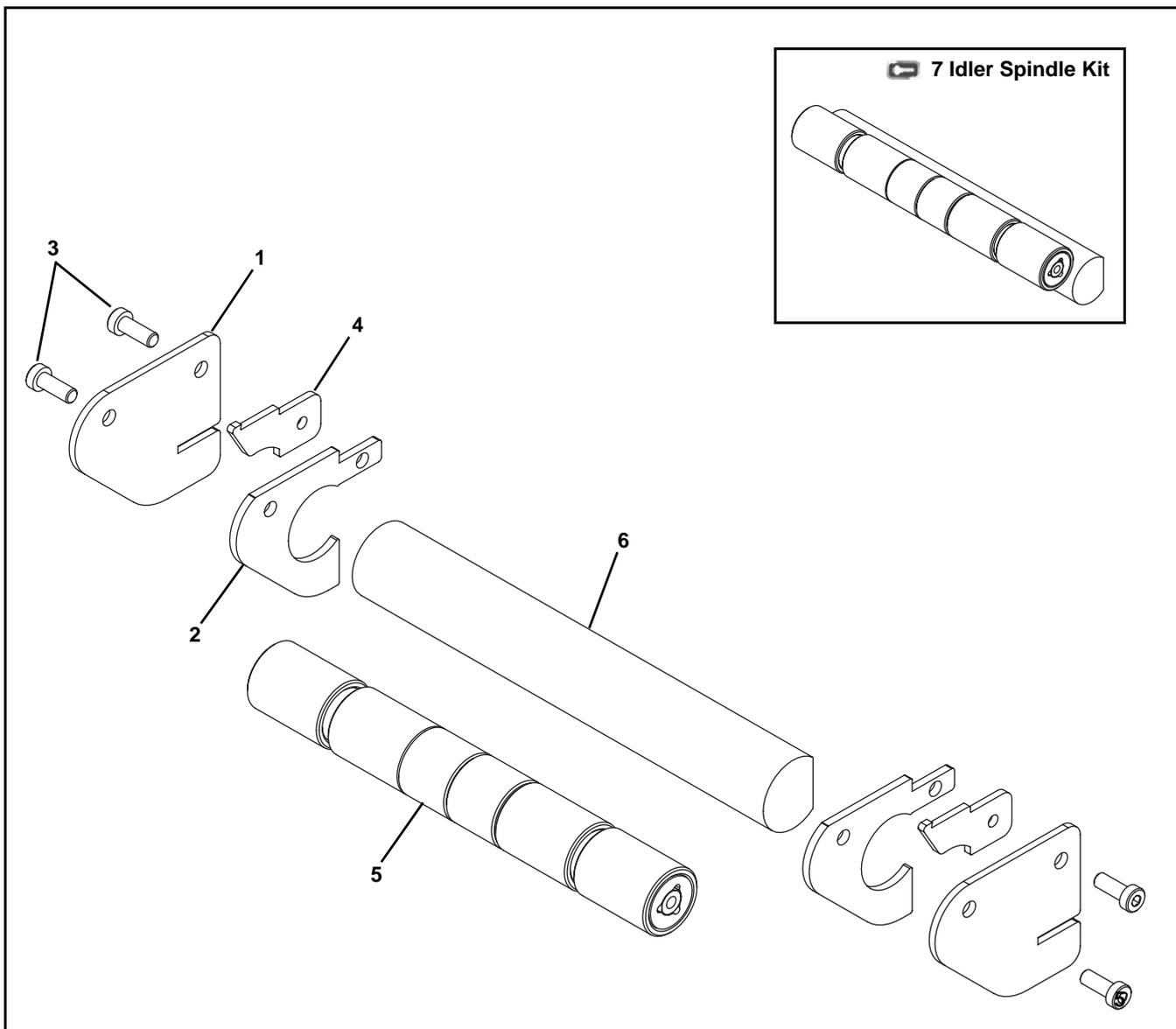
| Item | Part Number          | Description   |
|------|----------------------|---|
| 15   | 22V2MB1FO- <u>WW</u> | Spindle Kit for Micropitch Conveyors (One Keyed Shaft) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)                               |
|      | 22V2MB1FK- <u>WW</u> | Dual Shaft Spindle Kit for Micropitch Conveyors (Two Keyed Shafts) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)                   |
|      | 22V2MB1FS- <u>WW</u> | Common Drive Spindle Kit for Micropitch Conveyors (Keyed Shaft & Stub Shaft) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)         |
|      | 22V2MB1FE- <u>WW</u> | Common Drive Spindle Kit for Micropitch Conveyors - Mid Conveyor (2 Stub Shafts) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)     |
|      | 22V2MB1FC- <u>WW</u> | Common Drive Spindle Kit for Micropitch Conveyors - End Conveyor (One Stub Shaft) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)    |
|      | 22V2MB2FO- <u>WW</u> | Spindle Kit for Metal Working Conveyors (One Keyed Shaft) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)                            |
|      | 22V2MB2FK- <u>WW</u> | Dual Shaft Spindle Kit for Metal Working Conveyors (Two Keyed Shafts) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)                |
|      | 22V2MB2FS- <u>WW</u> | Common Drive Spindle Kit for Metal Working Conveyors (Keyed Shaft & Stub Shaft) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)      |
|      | 22V2MB2FE- <u>WW</u> | Common Drive Spindle Kit for Metal Working Conveyors - Mid Conveyor (2 Stub Shafts) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11)  |
|      | 22V2MB2FC- <u>WW</u> | Common Drive Spindle Kit for Metal Working Conveyors - End Conveyor (One Stub Shaft) (Includes Items 1, 2, 3, 7, 8, 9, 10 & 11) |

\*WW = Conveyor width reference: 03, 04, 06, 08, 09, 12, 18, 24

\* See page 7 for cross-reference to width reference and conveyor width.

# Service Parts

## Idler Tail

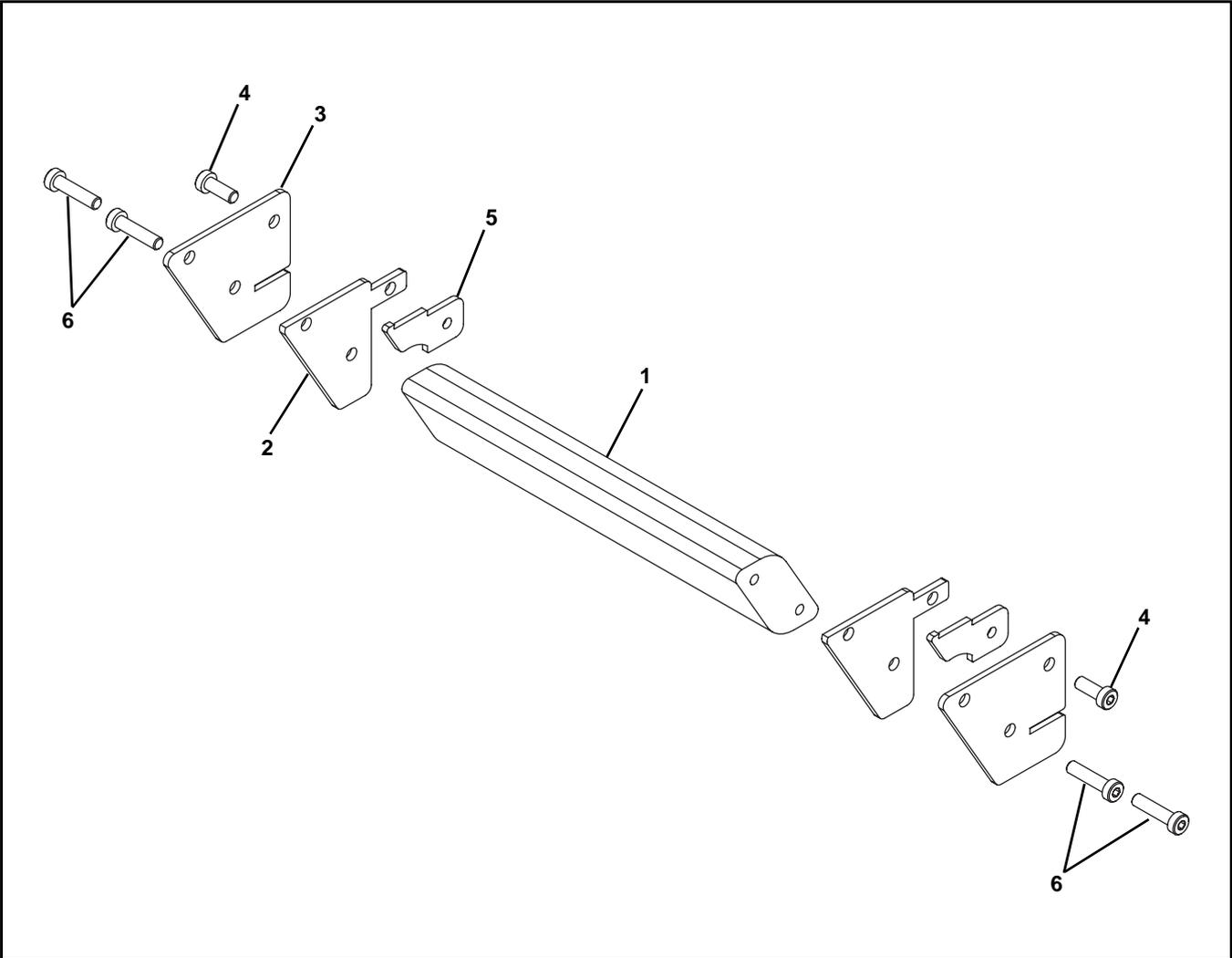


| Item | Part Number        | Description                              |
|------|--------------------|--|
| 1    | 206794             | Tail Plate                               |
| 2    | 206793             | Pinch Plate                              |
| 3    | 950616M            | Low Head Cap Screw,<br>M6-1.00 x 16 mm   |
| 4    | 203796             | Slide-In Nut                             |
| 5    | 205428- <u>WW</u>  | Idler Assembly                           |
| 6    | 203698- <u>WW</u>  | Wear Bar                                 |
| 7    | 22V2MBT- <u>WW</u> | Idler Spindle Kit (Includes Items 5 & 6) |

\*WW = Conveyor width reference: 03, 04, 06, 08, 09, 12, 18, 24

\* See page 7 for cross-reference to width reference and conveyor width.

**Nose Bar Idler Tail**



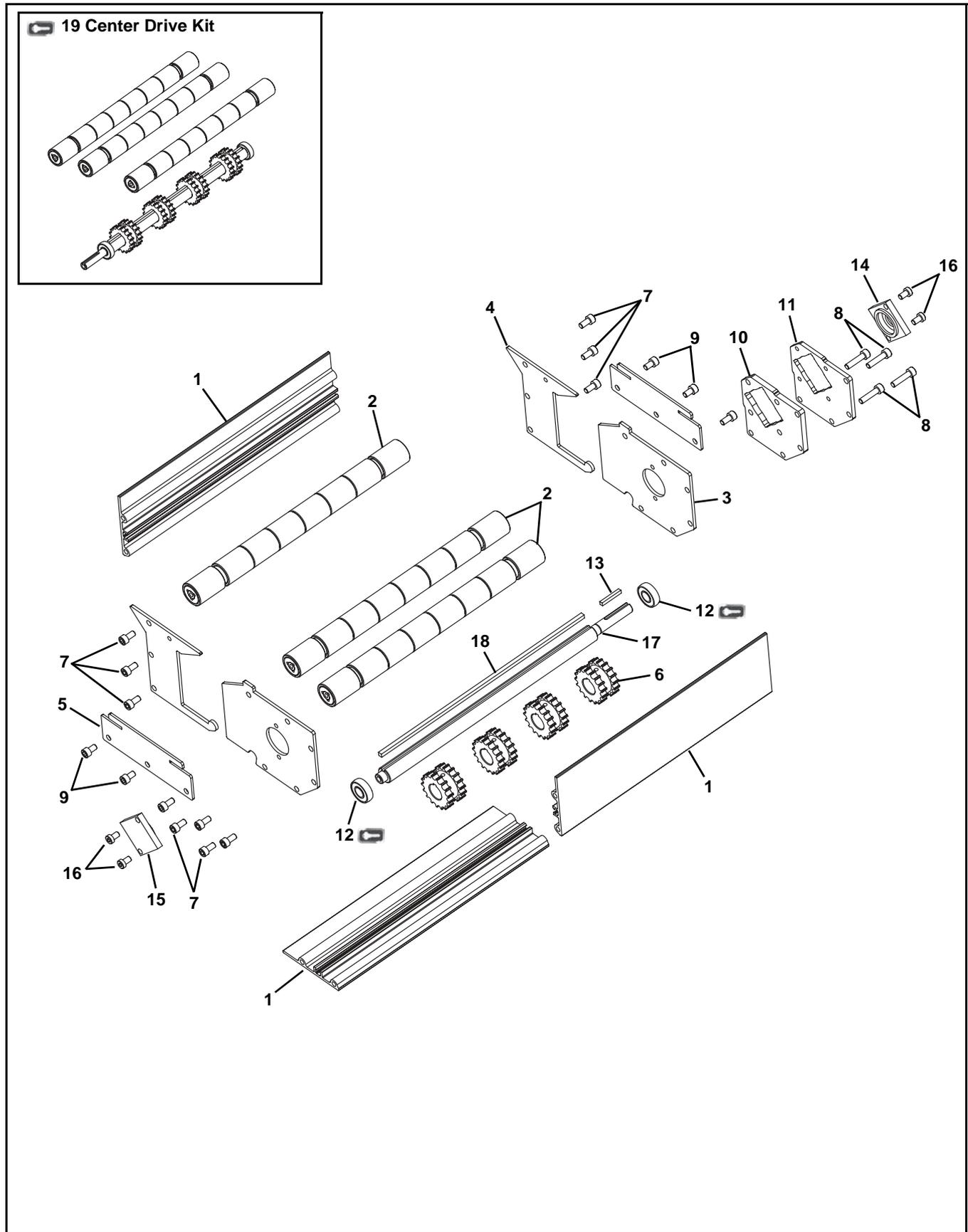
| Item | Part Number       | Description                            |
|------|-------------------|--|
| 1    | 206027- <u>WW</u> | Static Bar                             |
| 2    | 206796            | Pinch Plate                            |
| 3    | 206797            | Tail Plate                             |
| 4    | 950616M           | Low Head Cap Screw,<br>M6-1.00 x 16 mm |
| 5    | 203796            | Slide-In Nut                           |
| 6    | 950625M           | Low Head Cap Screw,<br>M6-1.00 x 25mm  |

\*WW = Conveyor width reference: 04, 06, 08, 12, 18, 24

\* See page 7 for cross-reference to width reference and conveyor width.

# Service Parts

## Center Drive Module



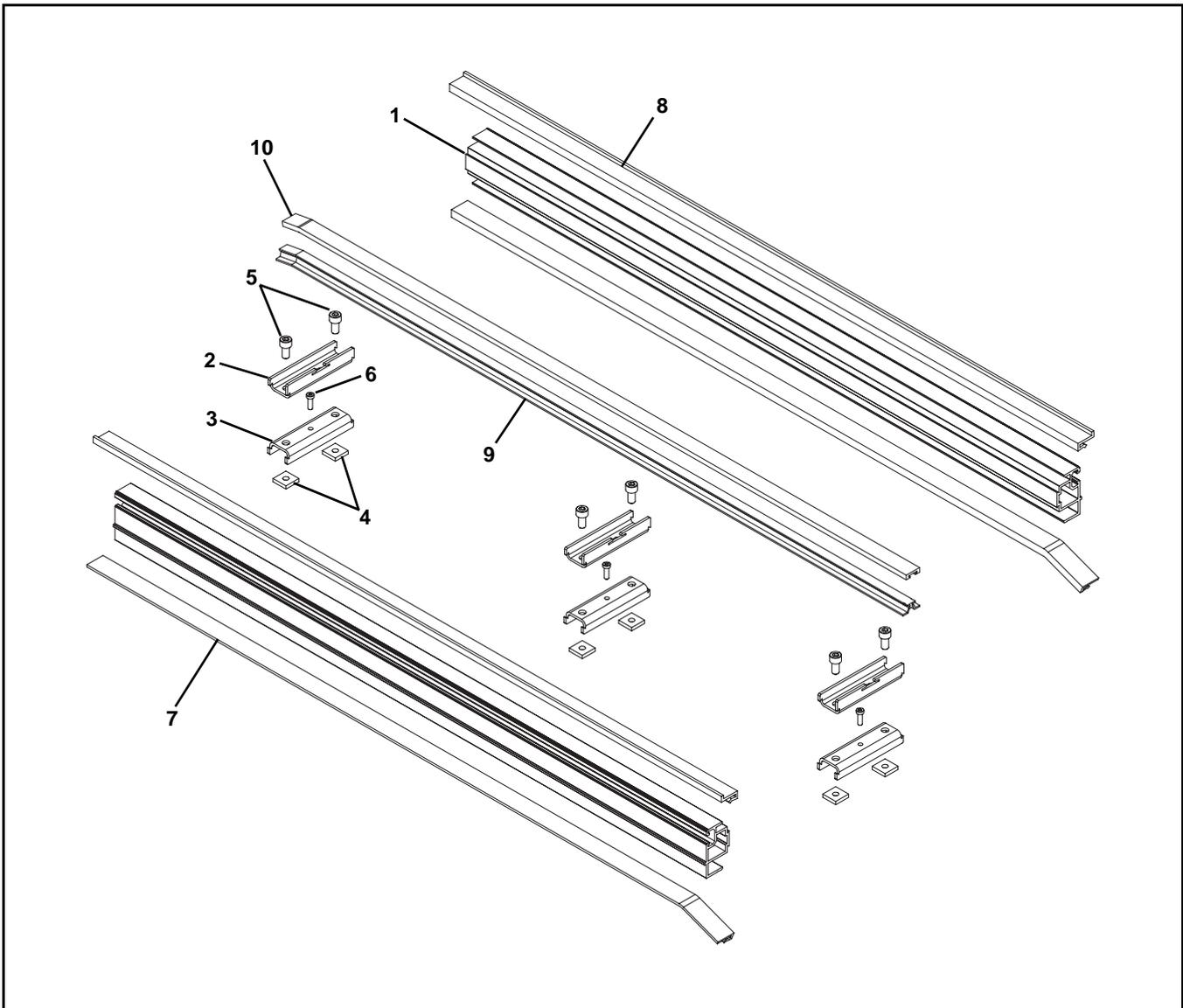
| Item | Part Number          | Description  |
|------|----------------------|--|
| 1    | 205425- <u>WW</u>    | Support Rail   |
| 2    | 205428- <u>WW</u>    | Idler Assembly   |
| 3    | 205444               | Motor Side Plate   |
| 4    | 205445               | Tension Side Plate   |
| 5    | 203598               | Clamp Plate  |
| 6    | 203765               | Sprocket for Micropitch Conveyors  |
|      | 203766               | Sprocket for Metal Working Conveyors   |
| 7    | 920614M              | Socket Head Screw, M6-1.00 x 14 mm   |
| 8    | 920625M              | Socket Head Screw, M6-1.00 x 25 mm   |
| 9    | 920608M              | Socket Head Screw, M6-1.00 x 8 mm  |
| 10   | 205446               | Inside Mounting Plate  |
| 11   | 205447               | Outside Mounting Plate   |
| 12   | 22BK2                | Bearing Kit (2 Pack)   |
|      | 22BK4                | Bearing Kit (4 Pack)   |
| 13   | 980428M              | Square Key, 4 mm x 28 mm   |
| 14   | 203628               | Mounting Block with Hole   |
| 15   | 203728               | Mounting Block   |
| 16   | 950610M              | Low Head Cap Screw, M6-1.00 x 10 mm  |
| 17   | 206023K- <u>WW</u>   | Spindle (One Keyed Shaft)  |
|      | 206194KK- <u>WW</u>  | Dual Shaft Spindle (Two Keyed Shafts)  |
| 18   | 201433- <u>WW</u>    | Sprocket Key   |
| 19   | 22V2MB1CD- <u>WW</u> | Center Drive Kit for Micropitch Conveyors (Includes Items 2, 6, 9, 12, 17 & 18)    |
|      | 22V2MB2CD- <u>WW</u> | Center Drive Kit for Metal Working Conveyors (Includes Items 2, 6, 9, 12, 17 & 18) |

\*WW = Conveyor width reference: 03, 04, 06, 08, 09, 12, 18, 24

\* See page 7 for cross-reference to width reference and conveyor width.

# Service Parts

## Frame Assembly

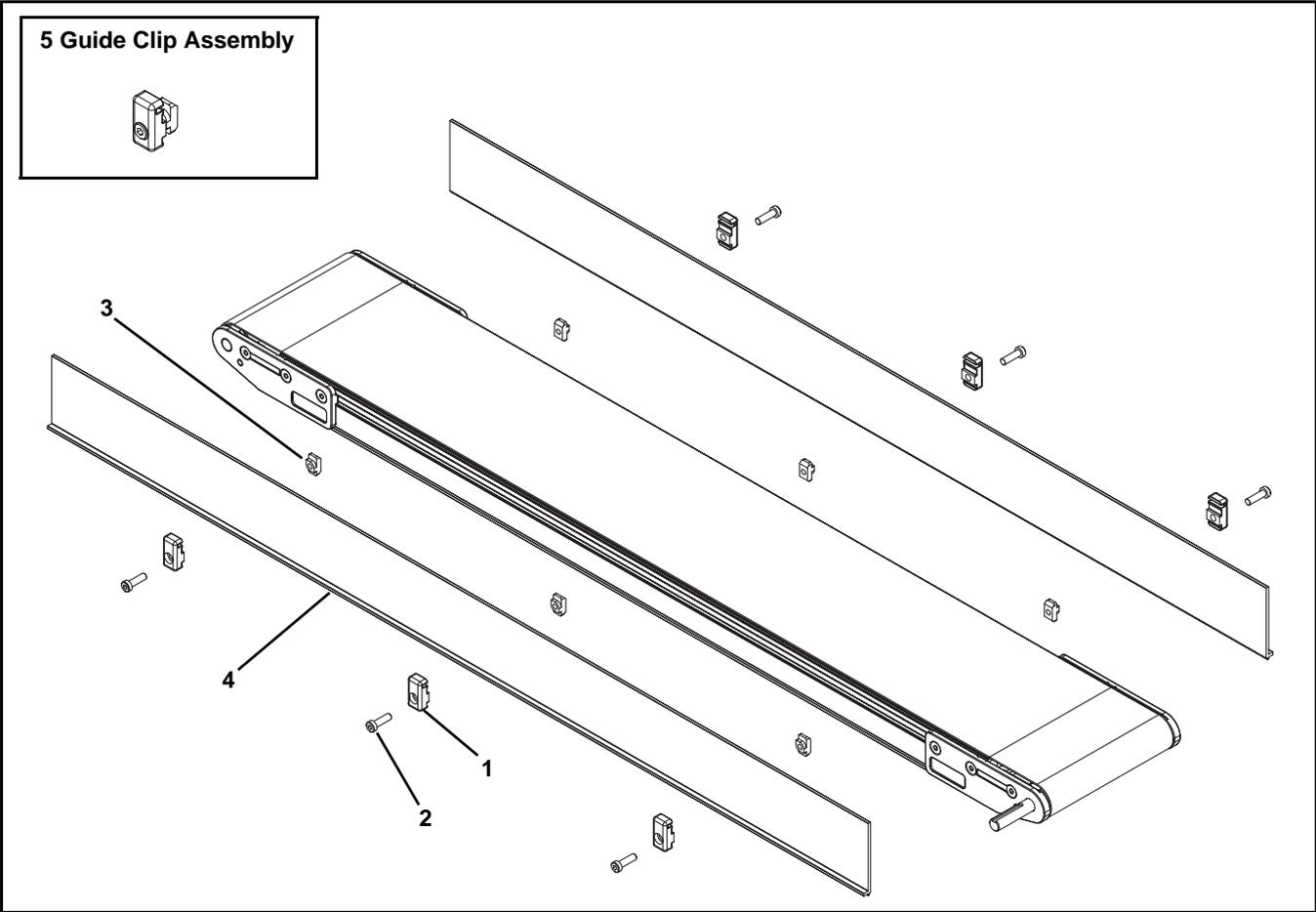


| Item | Part Number          | Description                                   |
|------|----------------------|---|
| 1    | 206507-LLLLL         | Side Rail, End Drive Conveyors                |
|      | 205401RH-LLLLL-YYYYY | Side Rail, Center Drive Conveyors, Right Hand |
|      | 205401RH-LLLLL-YYYYY | Side Rail, Center Drive Conveyors, Left Hand  |
| 2    | 203642-WW            | Top Connecting Clip                           |
| 3    | 203641-WW            | Bottom Connecting Clip                        |
| 4    | 834-014              | Slide-In Nut                                  |
| 5    | 950816M              | Low Head Screw, M8-1.25 x 16 mm               |
| 6    | 950516M              | Low Head Cap Screw, M5-0.80 x 16 mm           |
| 7    | 807-1102-LLLLL       | Wear Strip                                    |
| 8    | 807-2845-LLLLL       | J-Leg   |
| 9    | 203638-LLLLL         | Mid Support                                   |
| 10   | 614068P-LLLLL        | Guide   |

| Item  | Part Number | Description |
|---|-------------|-------------|
| *WW = Conveyor width reference: 03, 04, 06, 08, 09, 12, 18, 24                                  |             |             |
| LLLLL = Part length in inches with 2 decimal places   |             |             |
| YYYYY = Length from end of center drive cut out to discharge end of frame with 2 decimal places |             |             |
| Length Example: Length = 35.25 inches LLLLL = 03525   |             |             |

\* See page 7 for cross-reference to width reference and conveyor width.

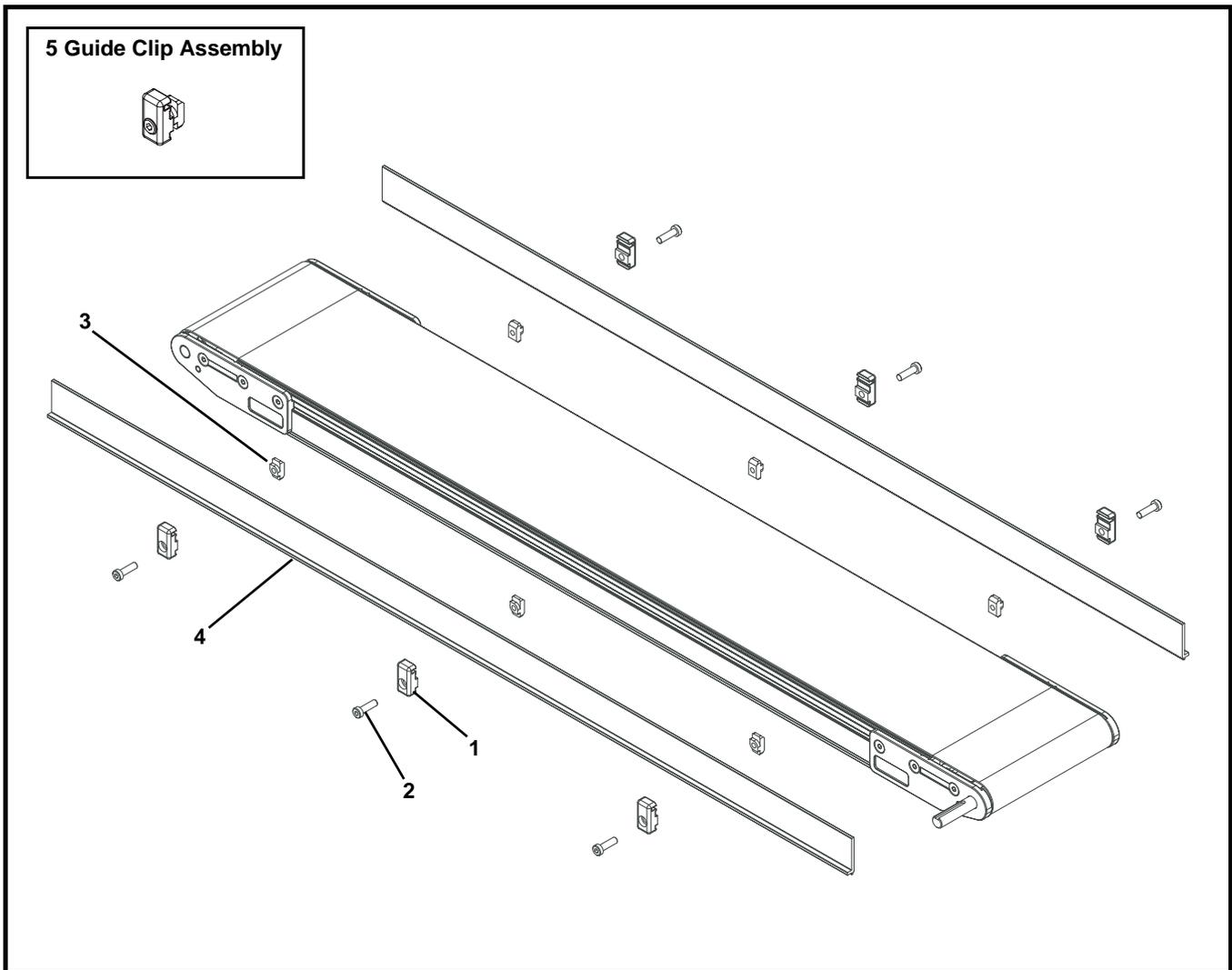
**#04 Profile - 76 mm Aluminum Side**



| Item   | Part Number          | Description                                      |
|--|----------------------|--|
| 1  | 206503               | Guide Clip                                       |
| 2  | 807-2878             | Low Head Cap Screw, M6-1.00 x 16 mm              |
| 3  | 206685               | T-Nut  |
| 4  | 206514- <u>LLLLL</u> | 76 mm Guides                                     |
|  | GTB04A04             | 76 mm Guides 1219 mm long                        |
|  | GTB04A08             | 76 mm Guides 2438 mm long                        |
| 5  | 203661               | Guide Clip Assembly (Includes items 1, 2, and 3) |
| <u>LLLLL</u> = part length in inches with 2 decimal places |                      |  |
| Length Example: Length = 35.25 inches <u>LLLLL</u> = 03525 |                      |  |

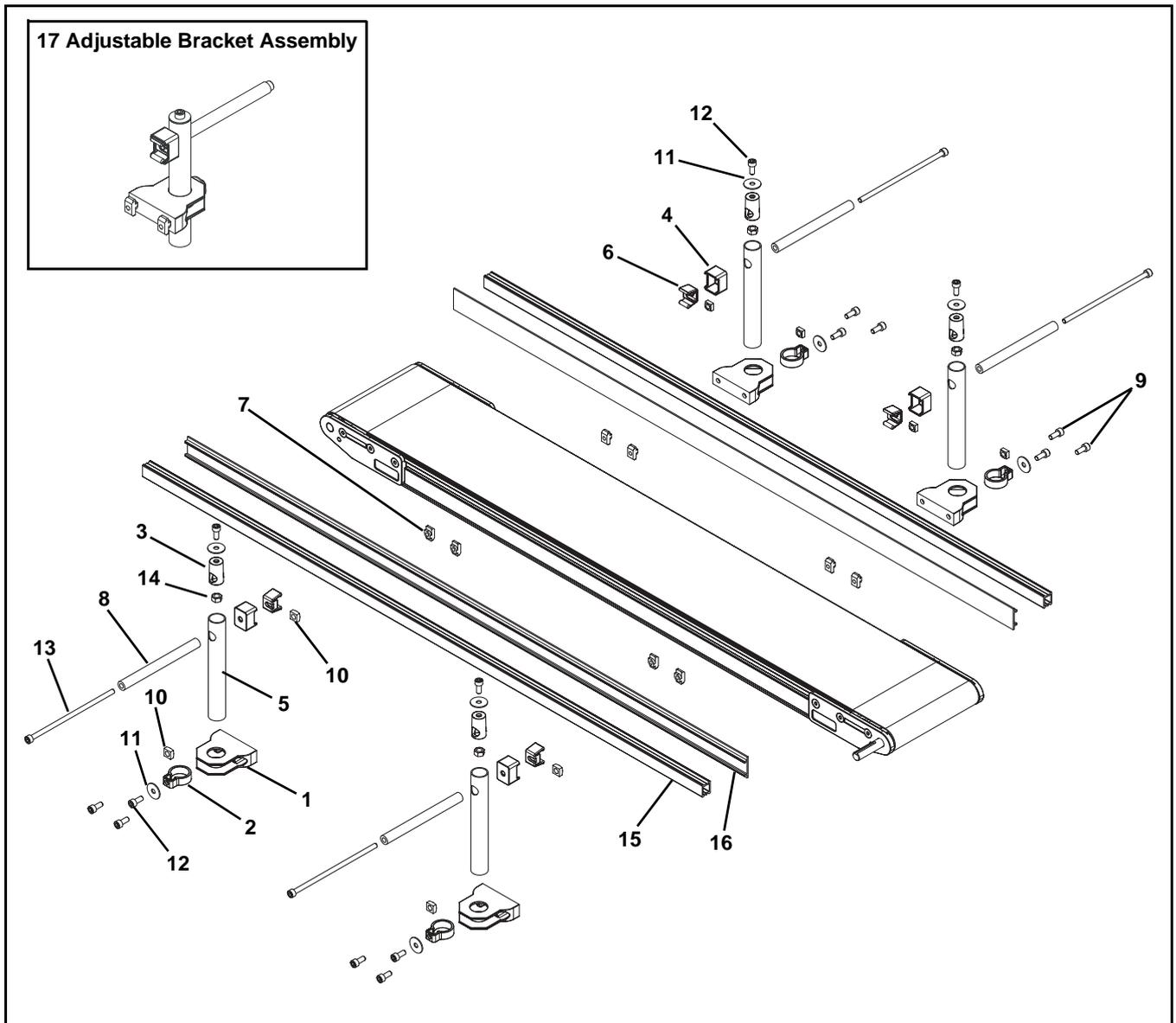
# Service Parts

## #05 Profile - 38 mm Aluminum Side



| Item   | Part Number          | Description   |
|--|----------------------|---|
| 1  | 206503               | Guide Clip  |
| 2  | 807-2878             | Low Head Cap Screw,<br>M6-1.00 x 16 mm              |
| 3  | 206685               | T-Nut   |
| 4  | 206513- <u>LLLLL</u> | 38 mm Guides  |
|  | GTB05A04             | 38 mm Guides 1219 mm long                           |
|  | GTB05A08             | 38 mm Guides 2438 mm long                           |
| 5  | 203661               | Guide Clip Assembly (Includes items<br>1, 2, and 3) |
| <u>LLLLL</u> = part length in inches with 2 decimal places |                      |   |
| Length Example: Length = 35.25 inches <u>LLLLL</u> = 03525 |                      |   |

## #13, 33 & 43 Profile - Adjustable Guiding



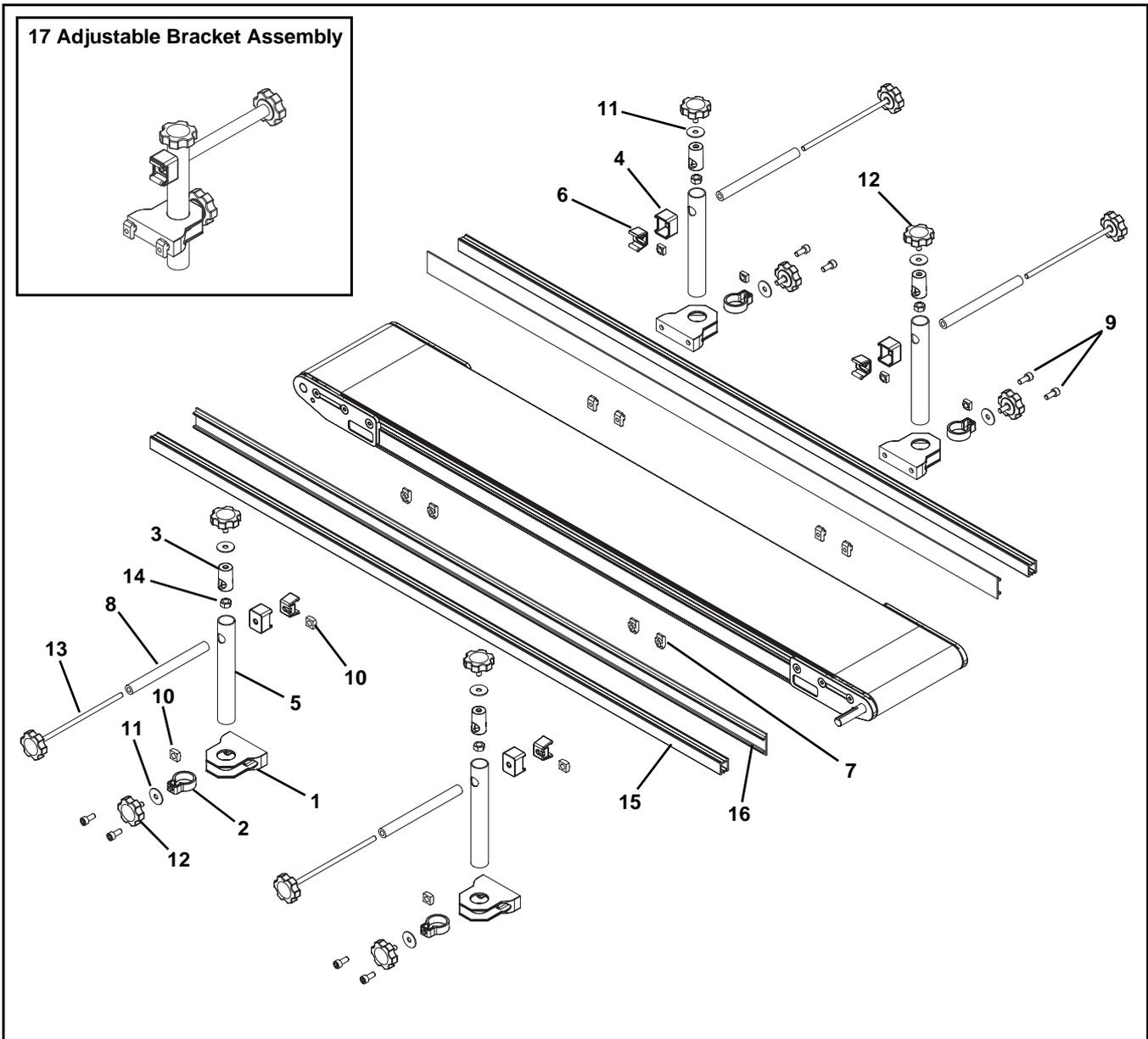
| Item | Part Number | Description                         |
|------|-------------|-------------------------------------|
| 1    | 206380      | Base                                |
| 2    | 206381      | Base Clamp                          |
| 3    | 206382      | Insert Clamp                     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

| Item | Part Number   | Description   |
|------|---------------|---|
| 14   | 990601M       | Hex Nut   |
| 15   | 834-238-LLLLL | Guide Rail  |
|      | GTB13A04      | Guide Rail 1219 mm long                                   |
|      | GTB13A08      | Guide Rail 2438 mm long                                   |
| 16   | 834-241       | 33 mm UHMW Guiding (per 305 mm)                           |
|      | GTB13B04      | 33 mm UHMW Guiding 1219 mm long                           |
|      | GTB13B08      | 33 mm UHMW Guiding 2438 mm long                           |
|      | 206683        | 51 mm UHMW Guiding (per 305 mm)                           |
|      | GTB13C04      | 51 mm UHMW Guiding 1219 mm long                           |
|      | GTB13C08      | 51 mm UHMW Guiding 2438 mm long                           |
| 17   | 206686        | Adjustable Bracket Assembly (Includes Items 1 through 14) |

LLLLL = part length in inches with 2 decimal places  
 Length Example: Length = 35.25 inches LLLLL = 03525

# Service Parts

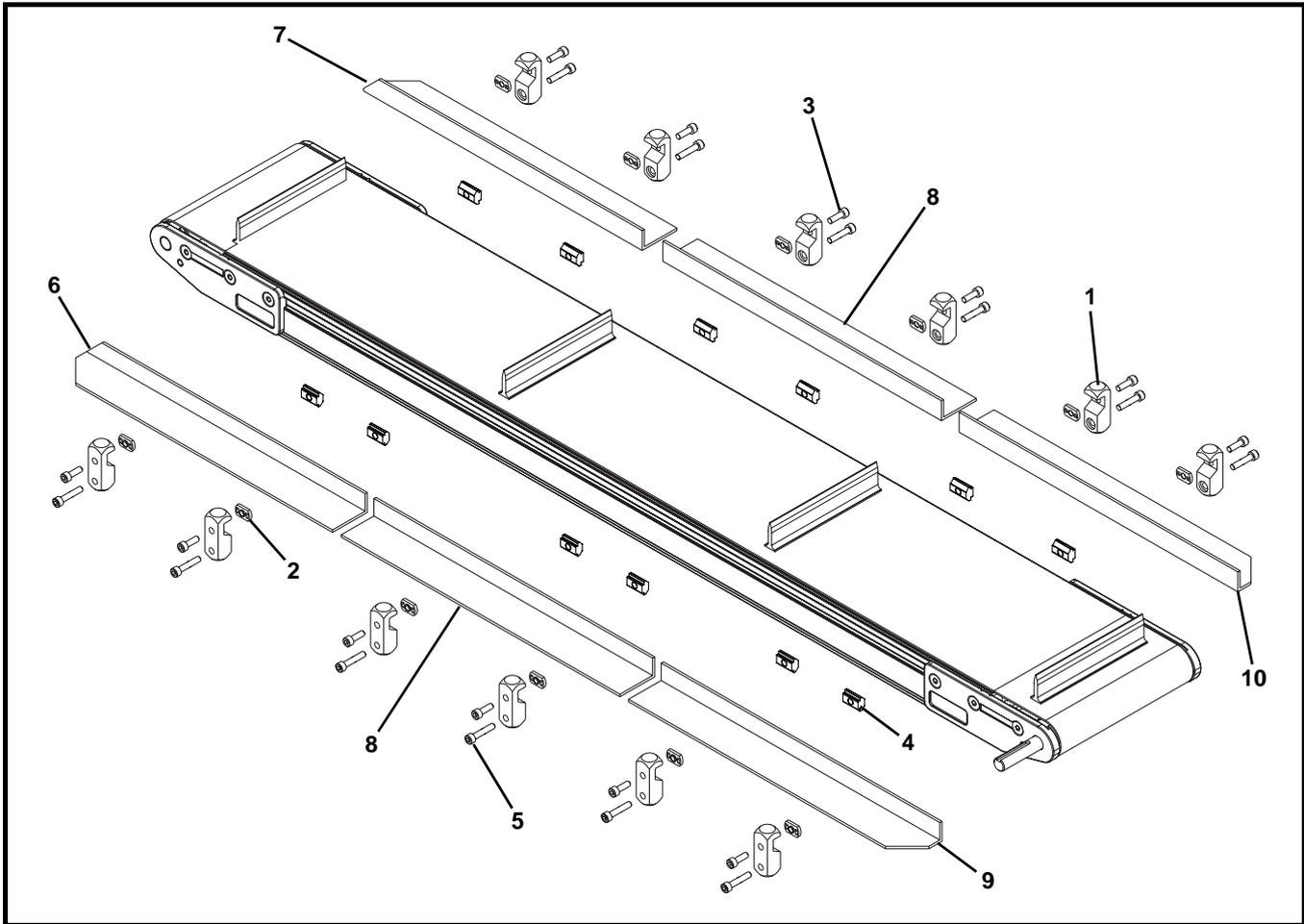
## #14, 34 & 44 Profile - Tool-Less Adjustable Guiding



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

| Item | Part Number           | Description   |
|------|-----------------------|---|
| 15   | 834-238- <u>LLLLL</u> | Guide Rail  |
|      | GTB13A04              | Guide Rail 1219 mm long   |
|      | GTB13A08              | Guide Rail 2438 mm long   |
| 16   | 834-241               | 33 mm UHMW Guiding (per 305 mm)                                     |
|      | GTB13B04              | 33 mm UHMW Guiding 1219 mm long                                     |
|      | GTB13B08              | 33 mm UHMW Guiding 2438 mm long                                     |
|      | 206683                | 51 mm UHMW Guiding (per 305 mm)                                     |
|      | GTB13C04              | 51 mm UHMW Guiding 1219 mm long                                     |
|      | GTB13C08              | 51 mm UHMW Guiding 2438 mm long                                     |
| 17   | 206687                | Tool-Less Adjustable Bracket Assembly (Includes Items 1 through 14) |
|      |                       | <u>LLLLL</u> = part length in inches with 2 decimal places          |
|      |                       | Length Example: Length = 35.25 inches <u>LLLLL</u> = 03525          |

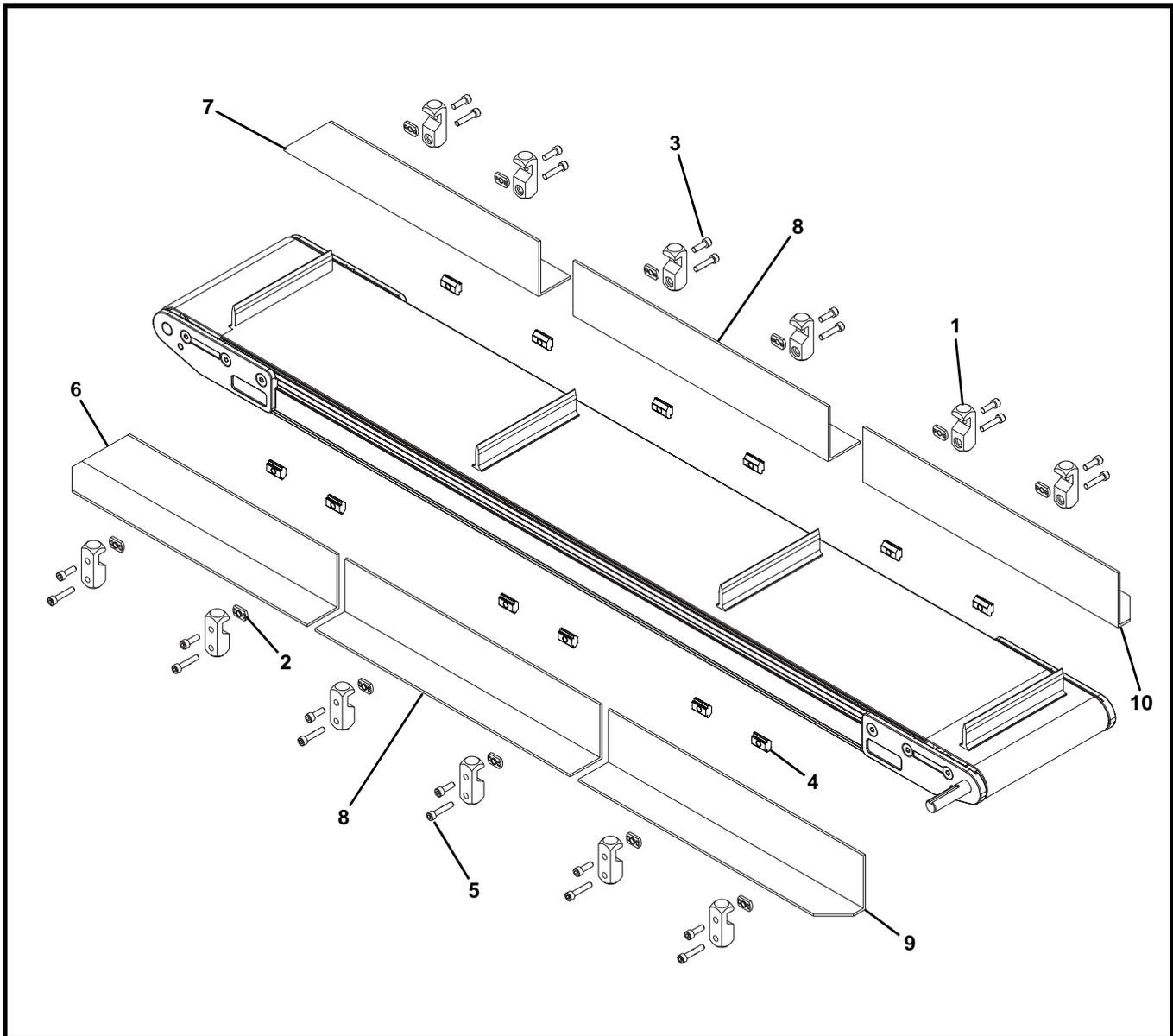
25 mm Cleated Profiles



| Item | Part Number   | Description   |
|------|---------------|---|
| 1    | 207161        | Clamping Block  |
| 2    | 807-2005      | Weld Nut  |
| 3    | 920618M       | Socket Head Screw, M6-1.00 x 18 mm                                    |
| 4    | 639971M       | Drop-In Tee Bar   |
| 5    | 920630M       | Socket Head Screw, M6-1.00 x 30 mm                                    |
| 6    | 204603-LLLLL  | One Piece Guiding Right Hand (for Conveyors up to 12 long)            |
|      | 204603D-LLLLL | One Piece Guiding Right Hand Drive Side (for Conveyors up to 12 long) |
|      | 204603-LLLLL  | Infeed Guiding Right Hand   |
| 7    | 204602-LLLLL  | One Piece Guiding Left Hand (for Conveyors up to 12 long)             |
|      | 204602D-LLLLL | One Piece Guiding Left Hand Drive Side (for Conveyors up to 12 long)  |
|      | 204602-LLLLL  | Infeed Guiding Left Hand  |
| 8    | 204601-LLLLL  | Mid Guiding   |
| 9    | 204601-LLLLL  | Exit Guiding Right Hand   |
|      | 204601D-LLLLL | Exit Guiding Right Hand Drive Side                                    |
| 10   | 204601-LLLLL  | Exit Guiding Left Hand  |
|      | 204601A-LLLLL | Exit Guiding Left Hand Drive Side                                     |
|      |               | LLLLL = Part length in inches with 2 decimal places                   |
|      |               | Length Example: Length = 35.25 inches LLLLL = 03525                   |

# Service Parts

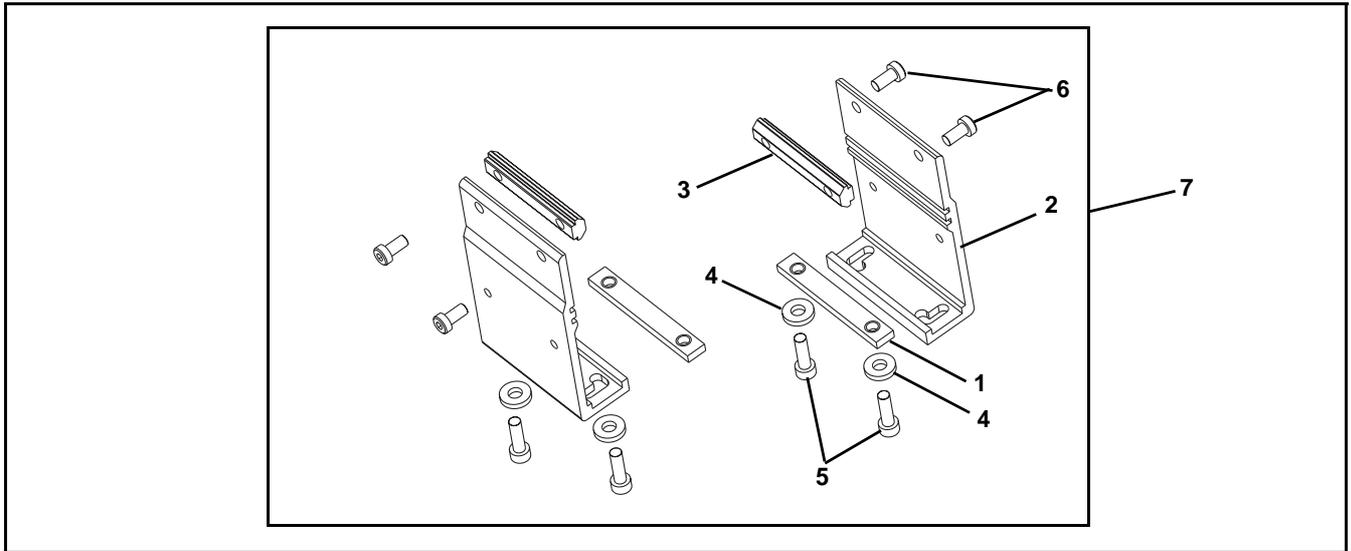
## 51 mm Cleated Profiles



| Item | Part Number   | Description   |
|------|---------------|---|
| 1    | 207161        | Clamping Block  |
| 2    | 807-2005      | Weld Nut  |
| 3    | 920618M       | Socket Head Screw, M6-1.00 x 18 mm                                    |
| 4    | 639971M       | Drop-In Tee Bar   |
| 5    | 920630M       | Socket Head Screw, M6-1.00 x 30 mm                                    |
| 6    | 208103-LLLLL  | One Piece Guiding Right Hand (for Conveyors up to 12 long)            |
|      | 208103D-LLLLL | One Piece Guiding Right Hand Drive Side (for Conveyors up to 12 long) |
|      | 208103-LLLLL  | Infeed Guiding Right Hand   |
| 7    | 208102-LLLLL  | One Piece Guiding Left Hand (for Conveyors up to 12 long)             |
|      | 208102D-LLLLL | One Piece Guiding Left Hand Drive Side (for Conveyors up to 12 long)  |
|      | 208102-LLLLL  | Infeed Guiding Left Hand  |

| Item  | Part Number   | Description                        |
|---|---------------|------------------------------------|
| 8   | 208101-LLLLL  | Mid Guiding                        |
| 9   | 208101-LLLLL  | Exit Guiding Right Hand            |
|   | 208101D-LLLLL | Exit Guiding Right Hand Drive Side |
| 10  | 208101-LLLLL  | Exit Guiding Left Hand             |
|   | 208101A-LLLLL | Exit Guiding Left Hand Drive Side  |
| LLLLL = Part length in inches with 2 decimal places |               |                                    |
| Length Example: Length = 35.25 inches LLLLL = 03525 |               |                                    |

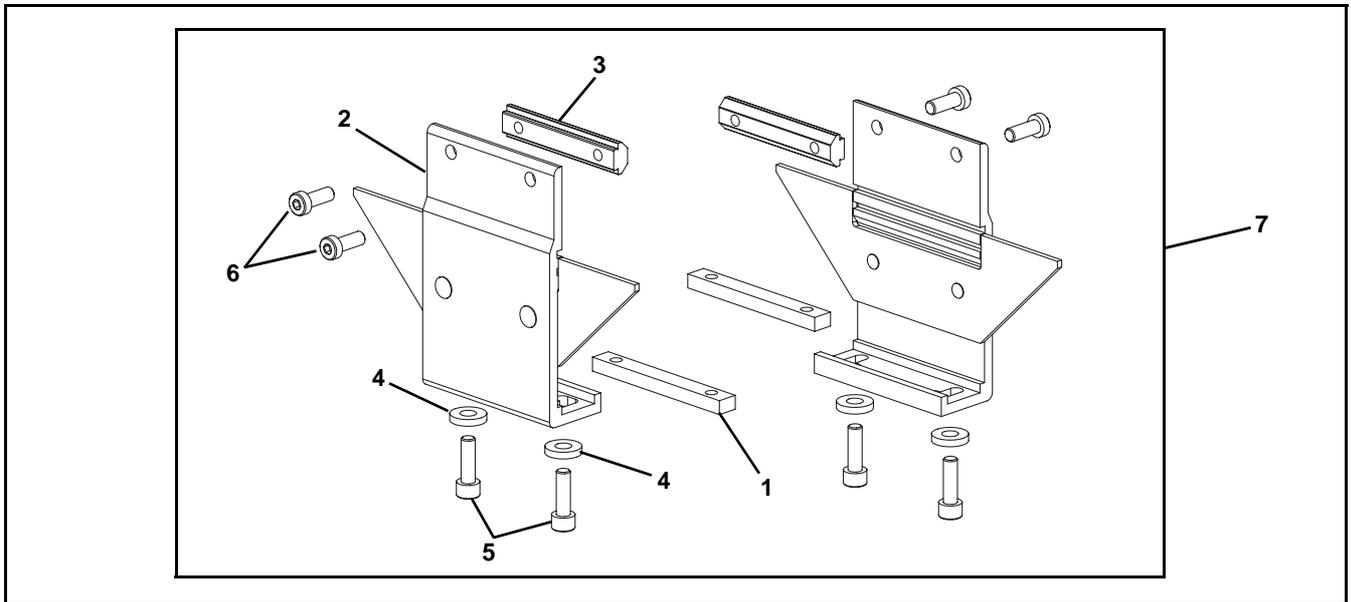
## Flat Belt Mounting Brackets



| Item | Part Number | Description     |
|------|-------------|-----------------|
| 1    | 202303      | Connector Bar   |
| 2    | 202394      | Stand Mount     |
| 3    | 300150M     | Drop-in Tee Bar |
| 4    | 605279P     | Washer          |

| Item | Part Number | Description                          |
|------|-------------|--------------------------------------|
| 5    | 920620M     | Socket Head Screw, M6 - 1.00 x 20 mm |
| 6    | 950616M     | Low Head Cap Screw, M6-1.00 x 16 mm  |
| 7    | 202389      | Stand Mount Assembly                 |

## Cleated Belt Mounting Brackets

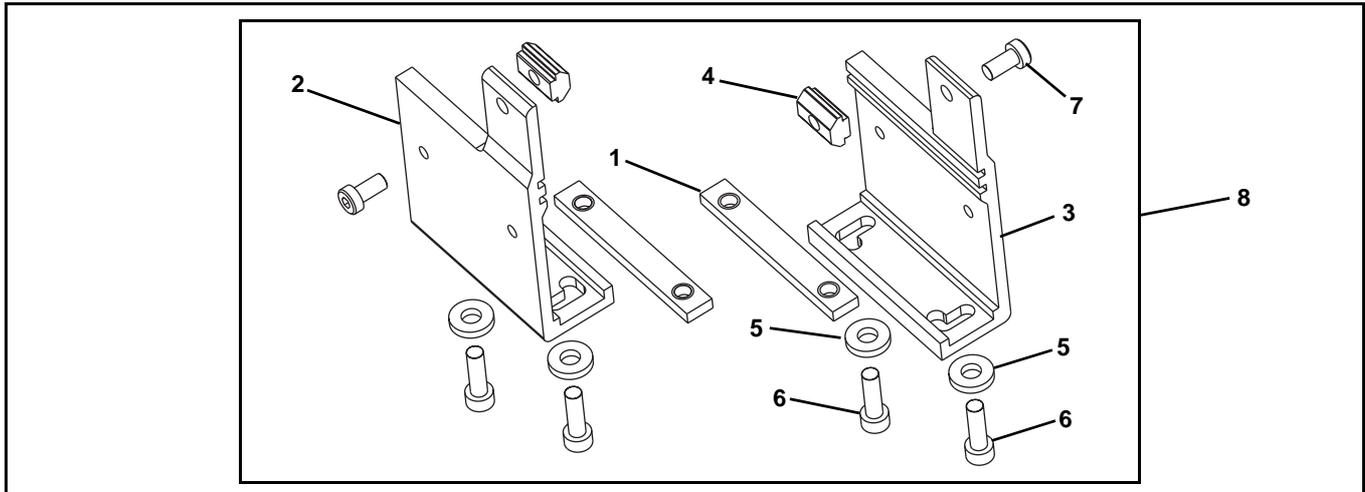


| Item | Part Number | Description                    |
|------|-------------|--------------------------------|
| 1    | 202303      | Connector Bar                  |
| 2    | 207529      | Cleated Stand Bracket Assembly |
| 3    | 300150M     | Drop-in Tee Bar                |
| 4    | 605279P     | Washer                         |

| Item | Part Number | Description                          |
|------|-------------|--------------------------------------|
| 5    | 920620M     | Socket Head Screw, M6 - 1.00 x 20 mm |
| 6    | 950616M     | Low Head Cap Screw, M6-1.00 x 16 mm  |
| 7    | 207526      | Cleated Stand Mount Assembly         |

# Service Parts

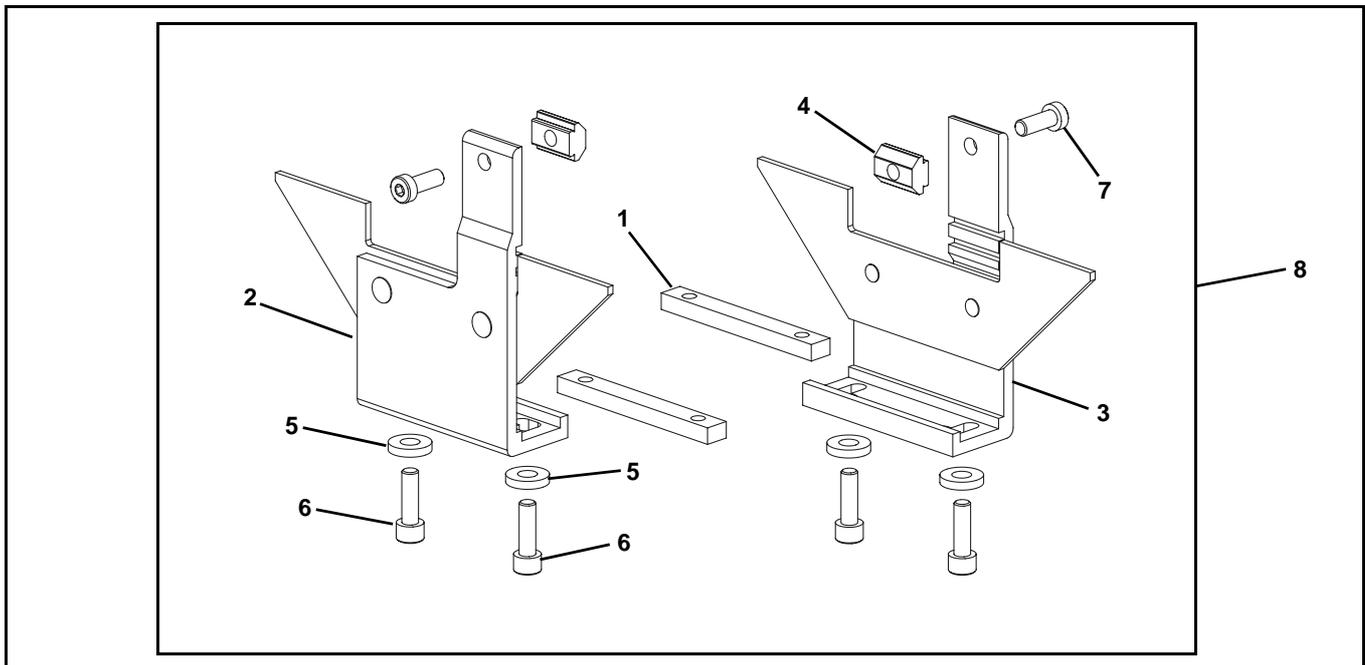
## Flat Belt Mounting Brackets for Short Conveyors



| Item | Part Number | Description                    |
|------|-------------|--------------------------------|
| 1    | 202303      | Connector Bar                  |
| 2    | 202304      | 610 mm Stand Mount, Left Hand  |
| 3    | 202305      | 610 mm Stand Mount, Right Hand |
| 4    | 639971M     | Drop-in Tee Bar                |

| Item | Part Number | Description                           |
|------|-------------|---------------------------------------|
| 5    | 605279P     | Washer                                |
| 6    | 920620M     | Socket Head Screw, M6 - 1.00 x 20 mm  |
| 7    | 950616M     | Low Head Cap Screw, M6 - 1.00 x 16 mm |
| 8    | 202392      | Stand Mount Assembly                  |

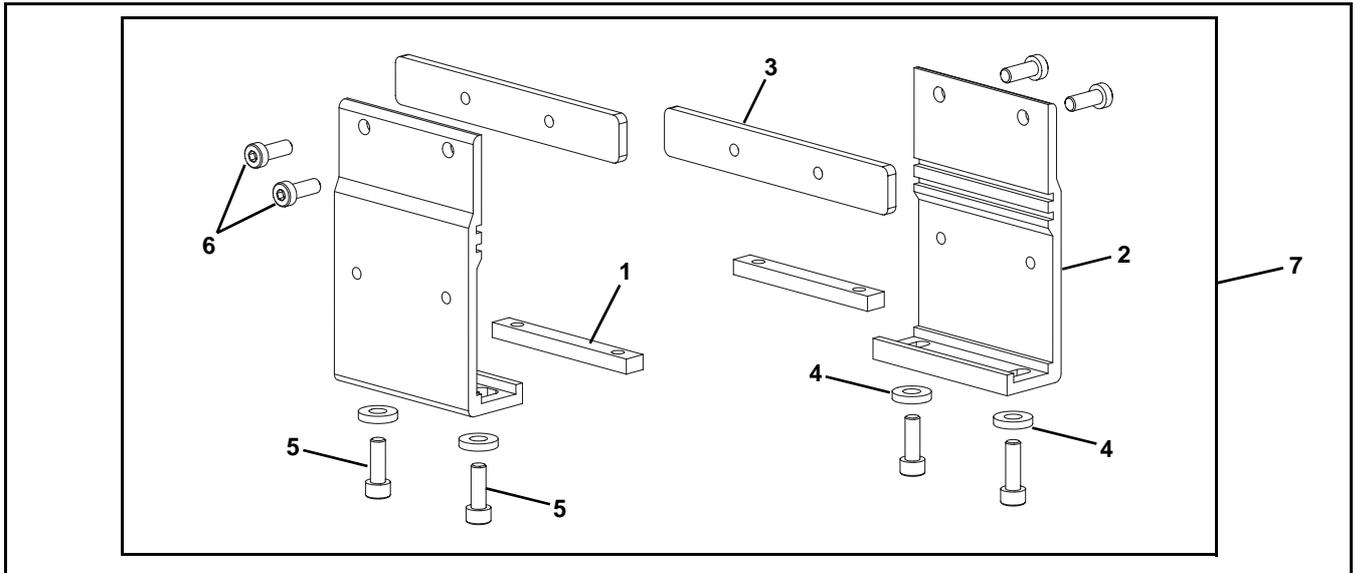
## Cleated Belt Mounting Brackets for Short Conveyors



| Item | Part Number | Description                                       |
|------|-------------|---|
| 1    | 202303      | Connector Bar                                     |
| 2    | 207530      | 610 mm Cleated Stand Bracket Assembly, Left Hand  |
| 3    | 207531      | 610 mm Cleated Stand Bracket Assembly, Right Hand |
| 4    | 639971M     | Drop-in Tee Bar                                   |

| Item | Part Number | Description                           |
|------|-------------|---------------------------------------|
| 5    | 605279P     | Washer                                |
| 6    | 920620M     | Socket Head Screw, M6 - 1.00 x 20 mm  |
| 7    | 950616M     | Low Head Cap Screw, M6 - 1.00 x 16 mm |
| 8    | 207527      | Cleated Stand Mount Assembly          |

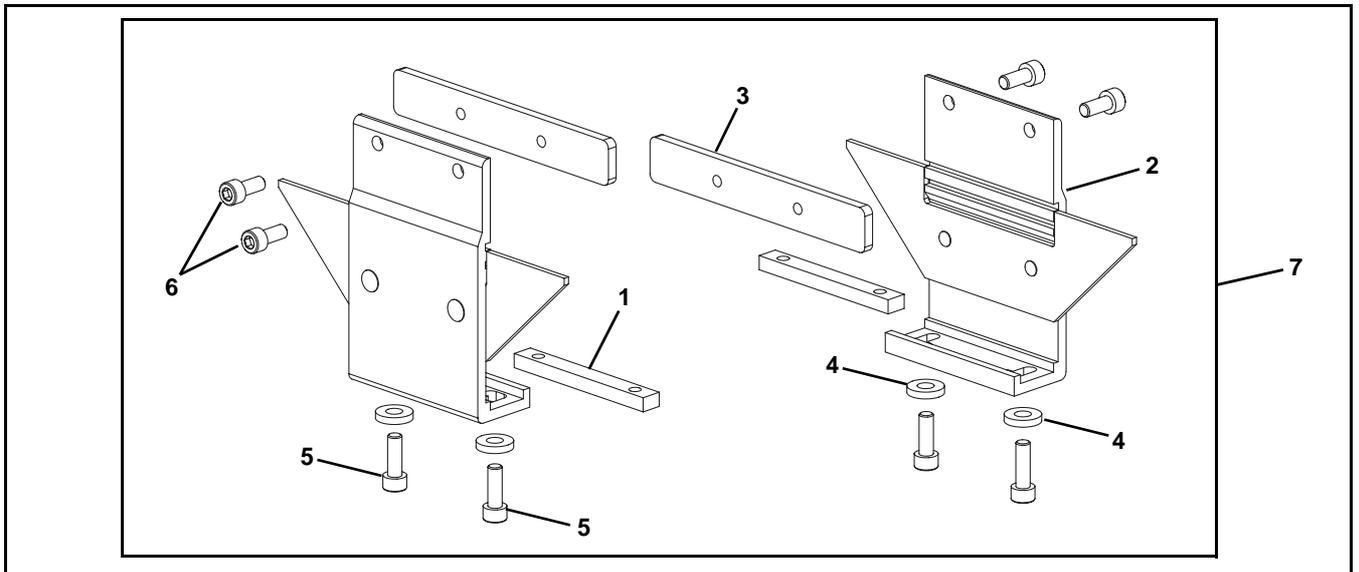
## Flat Belt Connecting Assembly with Stand Mount



| Item | Part Number | Description     |
|------|-------------|-----------------|
| 1    | 202303      | Connector Bar   |
| 2    | 202394      | Stand Mount     |
| 3    | 206520      | Frame Connector |
| 4    | 605279P     | Washer          |

| Item | Part Number | Description                        |
|------|-------------|------------------------------------|
| 5    | 920620M     | Socket Head Screw, M6-1.00 x 20 mm |
| 6    | 920614M     | Socket Head Screw, M6-1.00 x 14 mm |
| 7    | 203771      | Connecting Stand Mount Assembly    |

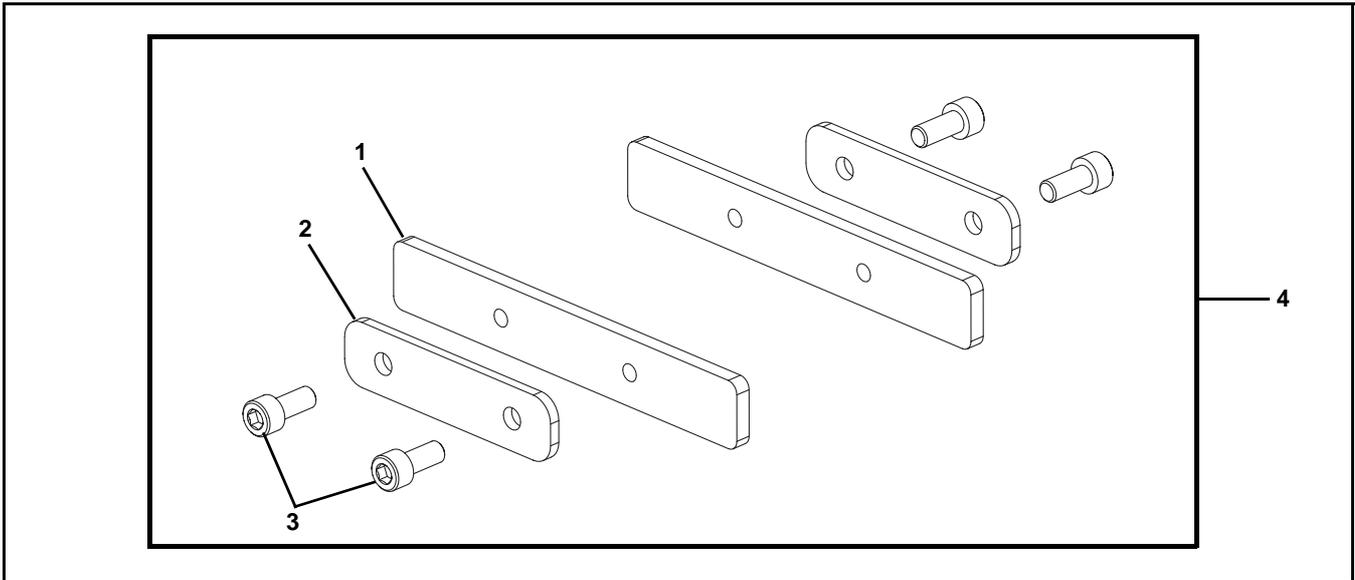
## Cleated Belt Connecting Assembly with Stand Mount



| Item | Part Number | Description                        |
|------|-------------|------------------------------------|
| 1    | 202303      | Connector Bar                      |
| 2    | 207529      | Cleated Stand Bracket Assembly     |
| 3    | 206520      | Frame Connector                    |
| 4    | 605279P     | Washer                             |
| 5    | 920620M     | Socket Head Screw, M6-1.00 x 20 mm |
| 6    | 920614M     | Socket Head Screw, M6-1.00 x 14 mm |
| 7    | 207528      | Cleated Stand Mount Assembly       |

# Service Parts

## Connecting Assembly without Stand Mount



| Item | Part Number | Description                        |
|------|-------------|------------------------------------|
| 1    | 206520      | Connecting Bar                     |
| 2    | 240859      | Plate                              |
| 3    | 920614M     | Socket Head Screw, M6-1.00 x 14 mm |
| 4    | 206519      | Connecting Assembly                |

## Micropitch Conveyor Belting

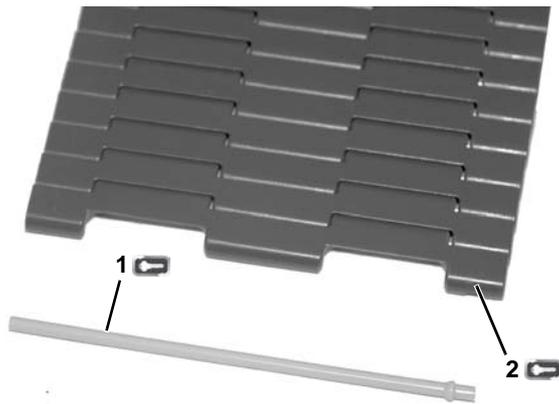


Figure 73

| Item   | Part Number               | Description                   |
|--|---------------------------|-------------------------------|
| 1  | 807-2103                  | 102 mm Belt Rod               |
|  | 807-3011                  | 152 mm Belt Rod               |
|  | 807-2104                  | 203 mm Belt Rod               |
|  | 807-2105                  | 305 mm Belt Rod               |
|  | 807-2400                  | 457 mm Belt Rod               |
|  | 807-2106                  | 610 mm Belt Rod               |
| 2  | 2P- <u>WW</u> / <u>BB</u> | Micropitch Belting per 305 mm |
| * <u>WW</u> = Conveyor width reference: 04, 06, 08, 12, 18, 24 |                           |                               |
| <u>BB</u> = Belt Types 01, 02                                  |                           |                               |

\* See page 7 for cross-reference to width reference and conveyor width.

## Metal Working Conveyor Belting

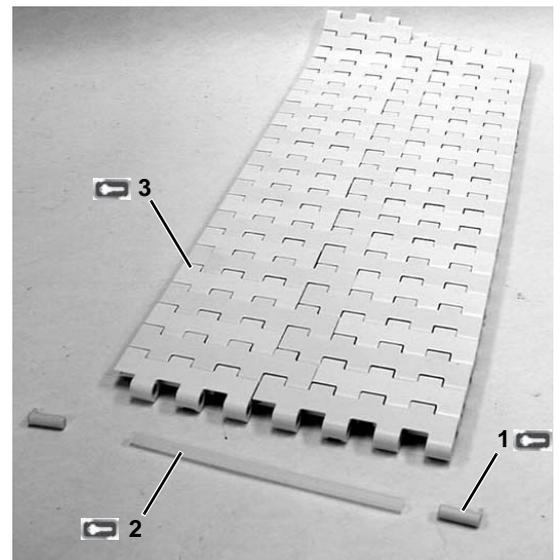


Figure 74

| Item   | Part Number                | Description                               |
|--|----------------------------|---|
| 1  | 807-1118                   | Retaining Pin for Metal Working Belt Only |
| 2  | 807-1113                   | 76 mm Belt Rod for Metal Working Belt     |
|  | 807-3021                   | 152 mm Belt Rod for Metal Working Belt    |
|  | 807-3013                   | 229 mm Belt Rod for Metal Working Belt    |
|  | 807-3014                   | 305 mm Belt Rod for Metal Working Belt    |
|  | 807-3015                   | 457 mm Belt Rod for Metal Working Belt    |
|  | 807-3016                   | 610 mm Belt Rod for Metal Working Belt    |
| 3  | 22P- <u>WW</u> / <u>BB</u> | Metal Working Belt per 305 mm             |
| * <u>WW</u> = Conveyor width reference: 03, 06, 09, 12, 18, 24 |                            |   |
| <u>BB</u> = Belt Types: 30, 31, 32, 40, 41, 42                 |                            |   |

\* See page 7 for cross-reference to width reference and conveyor width.

# 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.

| Product Line                   | Product Type   |                                |                |             |                        |                                    |                                      |                             | Engineered to order parts |
|--------------------------------|--|--------------------------------|----------------|-------------|------------------------|------------------------------------|--------------------------------------|-----------------------------|---------------------------|
|                                | Standard Products  |                                |                |             |                        |                                    |                                      |                             |                           |
|                                | Conveyors  | Gearmotors & Mounting Packages | Support Stands | Accessories | Spare Parts (non-belt) | Spare Belts - Standard Flat Fabric | Spare Belts - Cleated & Spec. Fabric | Spare Belts - Plastic Chain | All equipment and parts   |
| 1100 Series                    | 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. |                                |                |             |                        |                                    | non-returnable                       |                             | case-by-case              |
| 2200 Series                    |  |                                |                |             |                        |                                    |                                      |                             |                           |
| 3200 Series                    |  |                                |                |             |                        |                                    |                                      |                             |                           |
| Pallet Systems                 |  |                                |                |             |                        |                                    |                                      |                             |                           |
| FlexMove/SmartFlex             |  |                                |                |             |                        |                                    |                                      |                             |                           |
| GAL Series                     |  |                                |                |             |                        |                                    |                                      |                             |                           |
| All Electrical                 |  |                                |                |             |                        |                                    |                                      |                             |                           |
| 7100 Series                    | 50% return fee for all products  |                                |                |             |                        |                                    | non-returnable                       |                             | case-by-case              |
| 7200/7300 Series               |  |                                |                |             |                        |                                    |                                      |                             |                           |
| AquaGard 7350 Series Version 2 |  |                                |                |             |                        |                                    |                                      |                             |                           |
| GES Series                     |  |                                |                |             |                        |                                    |                                      |                             |                           |
| AquaGard 7350/7360 Series      | non-returnable   |                                |                |             |                        |                                    |                                      |                             |                           |
| AquaPruf Series                | non-returnable   |                                |                |             |                        |                                    |                                      |                             |                           |

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](http://www.dorner.com).

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

[www.dorner.com](http://www.dorner.com)



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