7600 Series CE End Drive Conveyors

Installation, Maintenance and Parts Manual

Flat Belt Conveyor

Cleated Belt Conveyor

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851-643 Rev. D

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Introduction

⚠ CAUTION

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

Upon receipt of shipment:

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

The Dorner Limited Warranty applies.

Dorner AquaPruf conveyors are covered by Patent Numbers 7,207,435, 7,246,697, 7,383,944, additional patent pending applications, and corresponding patents 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 .

⚠ DANGER

SEVERE HAZARD!

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

⚠ DANGER

EXPLOSION HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

BURN HAZARD!

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

⚠ WARNING

PUNCTURE HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

Product Description

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

Typical Components	
1	Conveyor
2	Gearmotor
3	Belt (Flat Belt Shown)
4	Return
5	Support Stands
6	Motor Controller
7	Drive End
8	Idler End

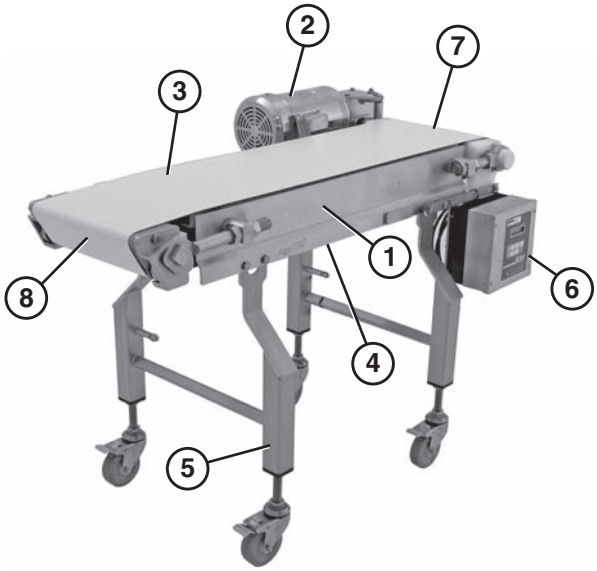
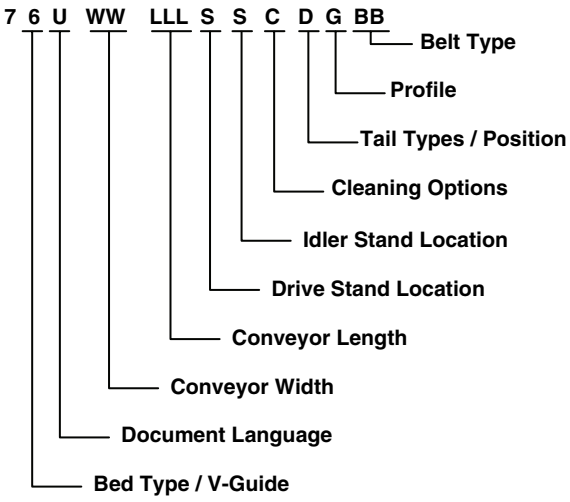
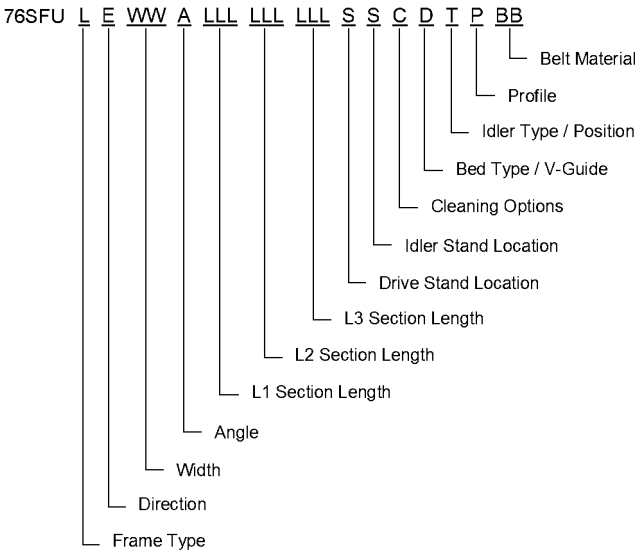


Figure 1

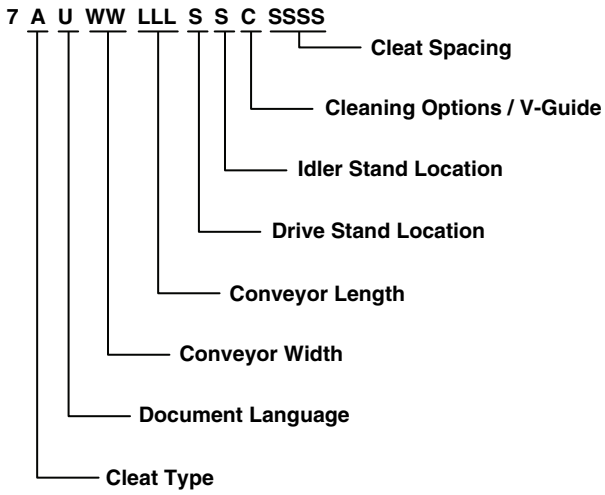
Flat Belt 7600 Series Conveyor



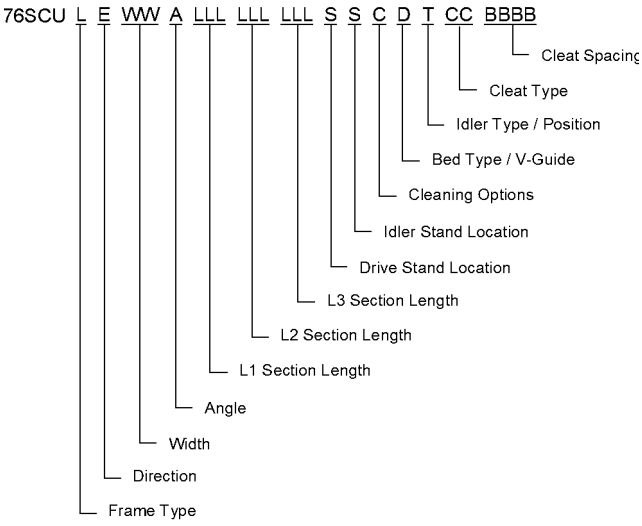
Flat Belt 7600 Series LPZ Conveyor



Cleated Belt 7600 Series Conveyor



Cleated Belt 7600 Series LPZ Conveyor



Specifications

Conveyor Supports

Maximum Distances:

1 = Support Stand on Idler End = 914 mm

2 = Between Support Stands = 2438 mm**

3 = Support Stand on Drive End = 914 mm

** For conveyors longer than 3.05 m, install support at frame joint.

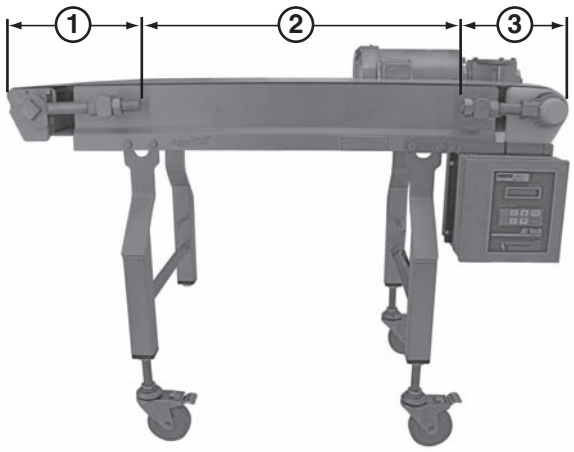


Figure 2

Specifications

Conveyor Width Reference (WW)	06 – 60 in 02 increments
Conveyor Belt Width	6" (152 mm) - 60" (1524 mm) in 2" (51 mm) increments
Maximum Conveyor Load	181 kg (400 lbs.)
Belt Travel	286 mm (11.25") per revolution of pulley
Maximum Belt Speed	100 m/minute (325 ft/minute)
Belt Take-up	38 mm (1.5")

Conveyor Length Reference (LLL)	036 – 480 in 001 increments
Conveyor Length	36" (914 mm) - 480" (12192 mm) in 1" (25 mm) increments
LPZ Section Lengths (LLL)	024 – 252 in 001 increments
LPZ Section Length	24” (610 mm) – 252" (6401 mm) in 1" (25 mm) increments
Total LPZ Conveyor Length	(L1 +L2 + L3) = Maximum 11.6 m (38') long conveyor

IMPORTANT

Maximum conveyor loads are based on:

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

⚠ CAUTION

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.

⚠ CAUTION

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

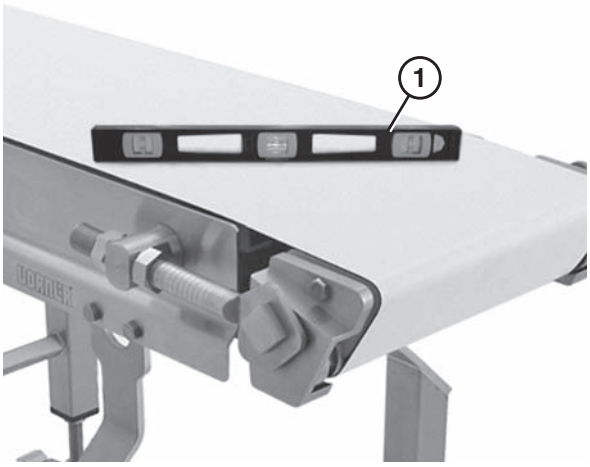


Figure 3

Required Tools

- Level
- Torque wrench

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to "All Conveyors" on page 12.
2. Attach the stands. Refer to "Stand Installation" on page 14.
3. Install the gearmotor. Refer to "Drive Package Installation" on page 15.

Conveyors Longer than 3048 mm

Connecting Components

Typical Connection Components **(Figure 4)**

1	M10 x 1.5 mm hex head cap screws (x4)
2	Connector hex rods (x2)
3	Conveyor frames

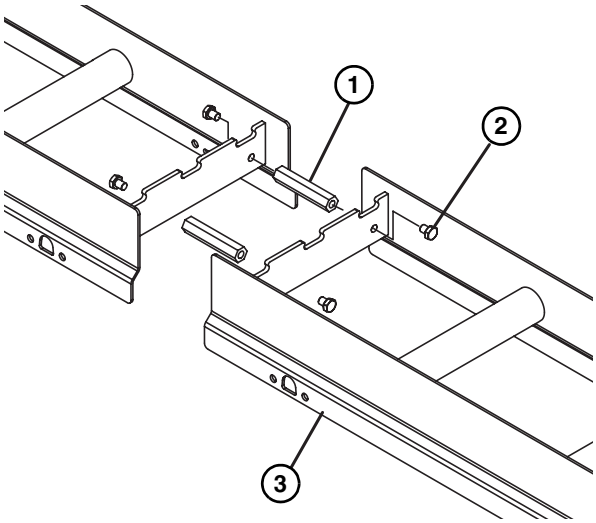


Figure 4

1. Locate the section number sequence etched on each section of frame **(Figure 5, item 1)**.

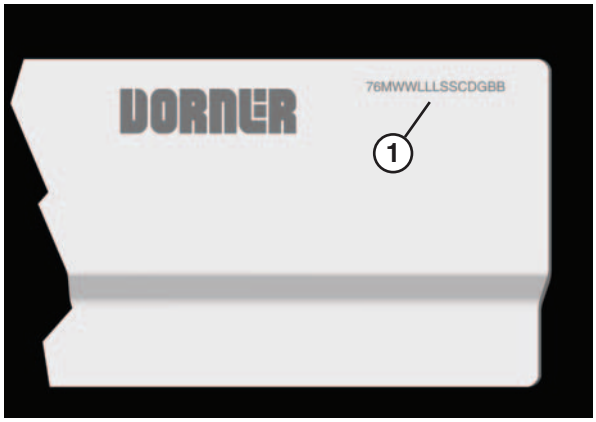


Figure 5

2. Position the frame sections in the correct order.

3. Connect the frame sections by bolting the hex post connectors **(Figure 6, item 1)** to the sections of frame.

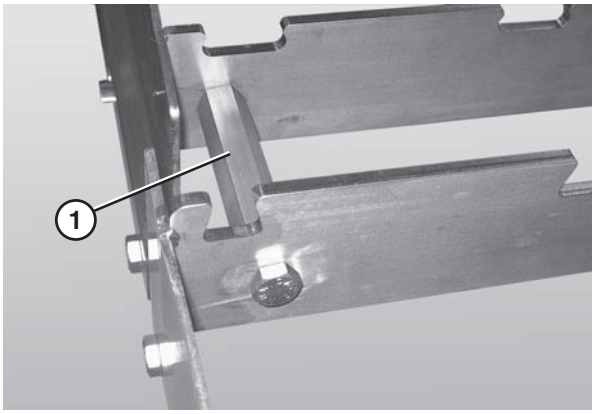


Figure 6

Wear Strip Installation

Standard Wear Strips

Typical Standard Wear Strips **(Figure 7)**

1	Wear Strips

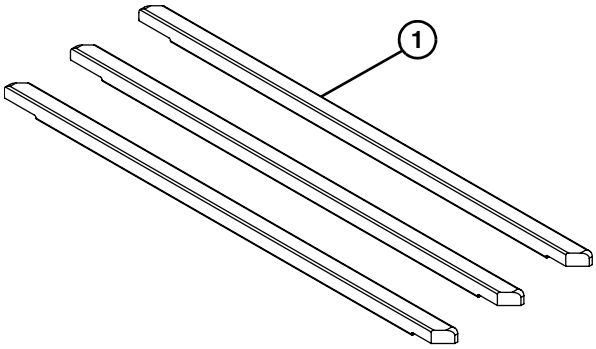


Figure 7

1. Position the wear strips **(Figure 8, item 1)** on the frame.

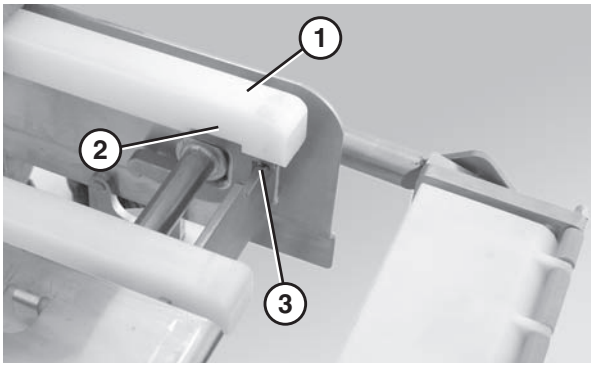


Figure 8

2. Make sure slots in the wear strips **(Figure 8, item 2)** line up properly with frame slots **(Figure 8, item 3)**.

Stainless Steel Sheet Bed Plates (Optional)

Typical Stainless Steel Sheet Bed Plates **(Figure 9)**

1	Bed Plates
2	Wear Strips

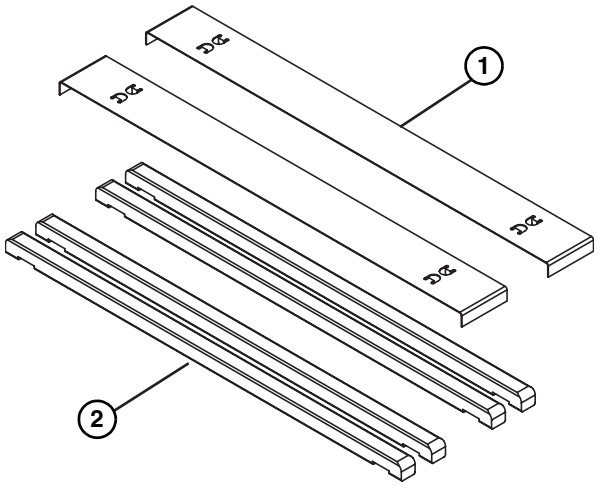


Figure 9

1. Attach the wear strips to the frame. Refer to “Standard Wear Strips” on page 8.
2. Place the sheet bed plates **(Figure 10, item 1)** over the wear strips **(Figure 10, item 2)**.

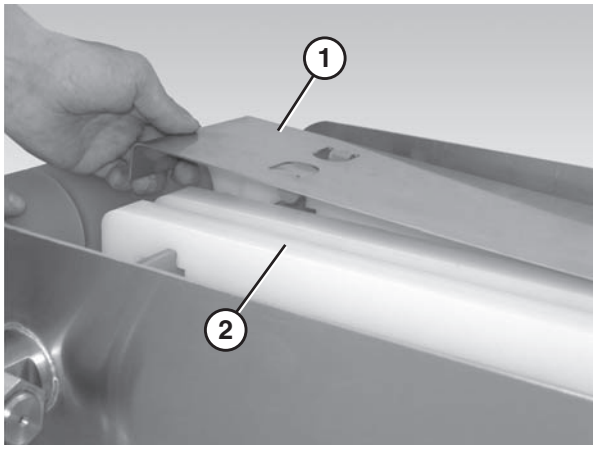


Figure 10

Lifter Installation

Typical Lifter Components **(Figure 11)**

1	Belt lift pivot bar
2	Lifter bars
3	Belt lift handle
4	M8 - 1.25 x 16 mm hex head cap screw

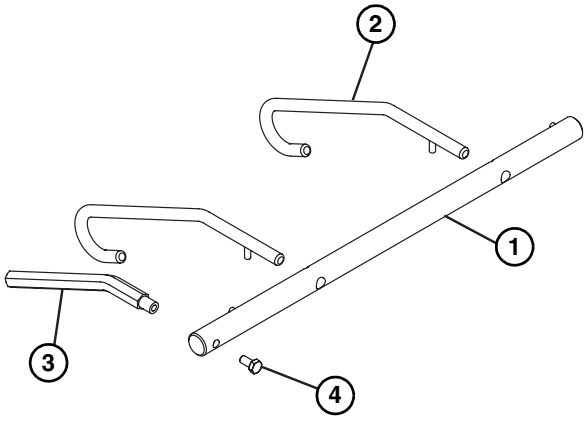


Figure 11

1. Slide the belt lift pivot bar **(Figure 12, item 1)** through the designated holes in the frame. The pins on the belt lift pivot bar should be located inside the frame side rails.

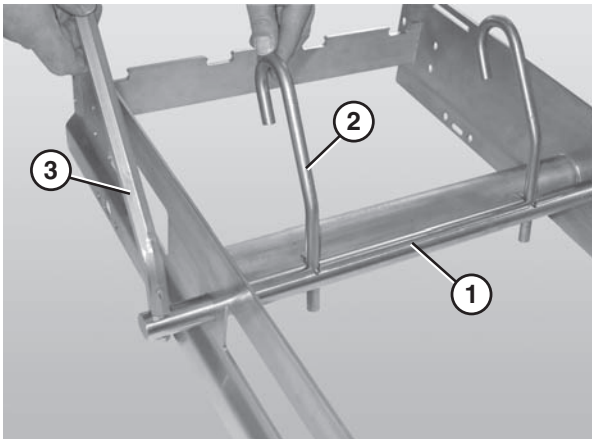


Figure 12

2. Attach the lifter bars **(Figure 12, item 2)** to the belt lift pivot bar **(Figure 12, item 1)**. Make sure the hooked ends of the lifter bars are facing down when resting against the frame.
3. Attach the lifter handle **(Figure 12, item 3)** to the belt lift pivot rod.

Belt Installation

Typical Standard Belt **(Figure 13)**

1	Belt

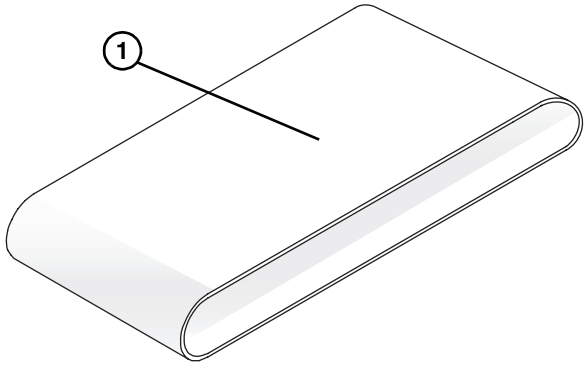


Figure 13

1. Place the idler tail **(Figure 14, item 1)** in the UP position.

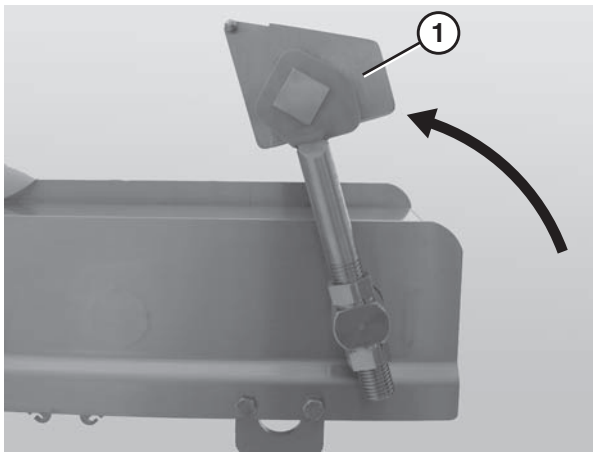


Figure 14

⚠ WARNING

SEVERE HAZARD!

- **ONLY DISCONNECT ONE PIVOT BRACKET AT A TIME AND ONLY IF THE STANDS ARE BOLTED TO THE FLOOR.**
- **Disconnecting more than one pivot bracket at a time or not bolting the stands to the floor can cause the conveyor to tip and may result in serious injury.**

2. Lower the quick release arm **(Figure 15, item 1)** on one of the stands. *Note: if the conveyor is not equipped with Quick Release (QR Type) stands, it will be necessary to remove the entire stand.* For detailed instructions, refer to the "Sanitary Support Stands Installation, Maintenance and Parts Manual."

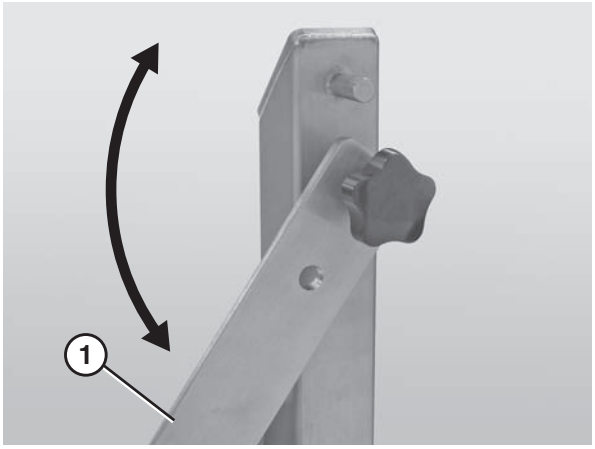


Figure 15

3. Slide the belt **(Figure 16, item 1)** on over the conveyor frame **(Figure 16, item 2)**.

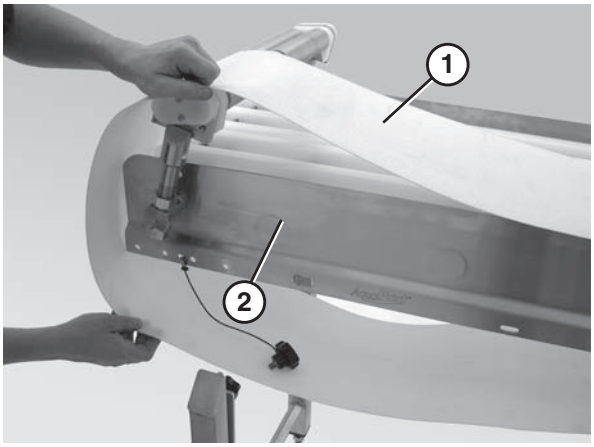


Figure 16

4. Secure the quick release arm on the stand and repeat steps 2 and 3 until the belt is around the entire length of the conveyor.
5. Add tension to the belt by lowering the tip-up tail or by sliding the idler tail out and tightening the nuts. Refer to "Conveyor Belt Tensioning" on page 19.
6. Adjust the belt tracking as necessary. Refer to "Conveyor Belt Tracking" on page 19.

Guide Installation

Typical Guide Components **(Figure 17)**

1	Guide
2	Pull pin

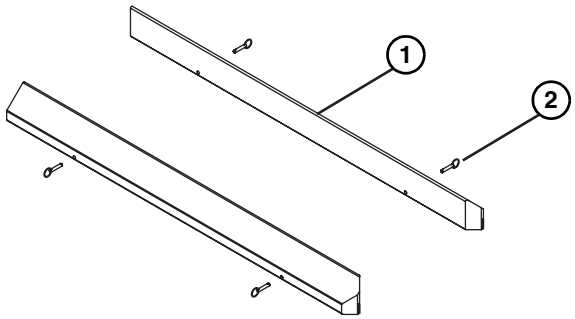


Figure 17

1. Position the guide **(Figure 18, item 1)** so that the flat surface is facing the belt and then slide the guide onto the frame rail **(Figure 18, item 2)**.

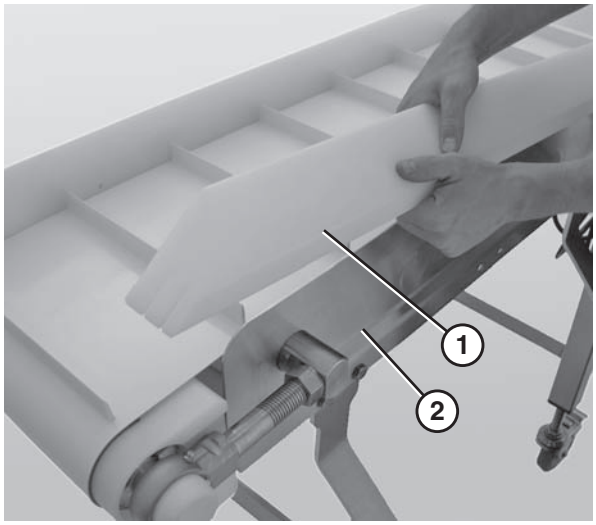


Figure 18

2. Line up the guide holes with the holes in the frame.

3. Insert the pull pins **(Figure 19, item 1)** into the holes in the guide **(Figure 19, item 2)**.

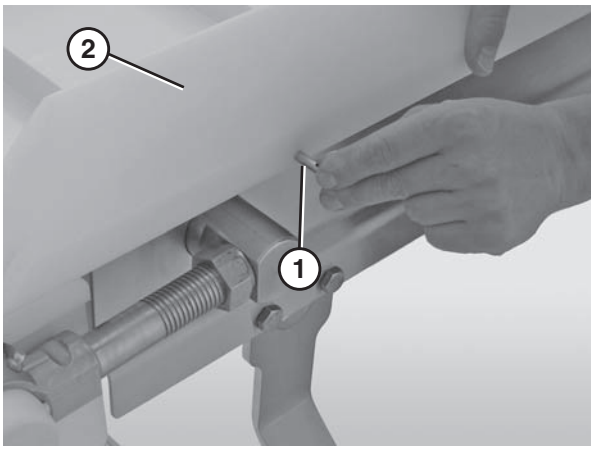


Figure 19

LPZ Conveyors

Knuckles

1. Attach upper knuckle **(Figure 20, item 1)** to frame **(Figure 20, item 2)** with hex rods **(Figure 20, item 3)** and bolts **(Figure 20, item 4)**.

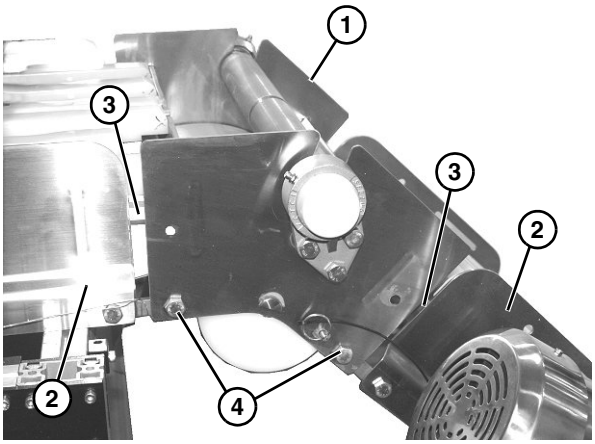


Figure 20

2. Attach lower knuckle **(Figure 21, item 1)** to frame **(Figure 21, item 2)** with hex rods **(Figure 21, item 3)**, and bolts **(Figure 21, item 4)**.

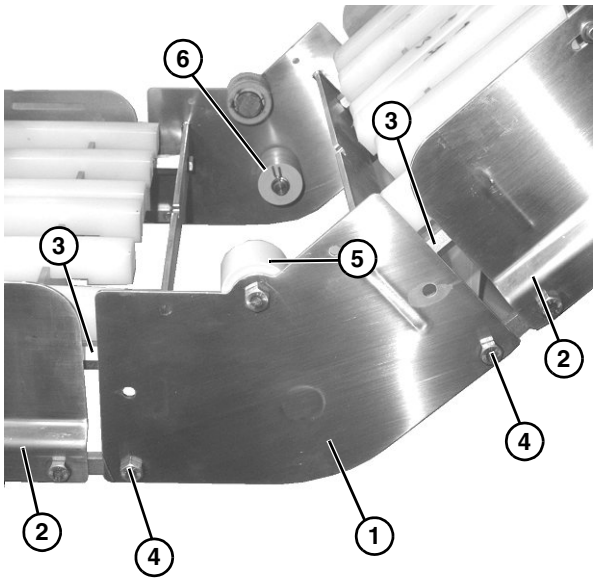


Figure 21

3. Install hold down sleeve bearing **(Figure 21, item 5)**, and secure with cap screw. Repeat on opposite side.
4. Install return sleeve bearing **(Figure 21, item 6)**, and secure with clamp. Repeat on opposite side.

Belt

1. Slide belt **(Figure 22, item 1)** over knuckles and onto top and bottom of wear strips.

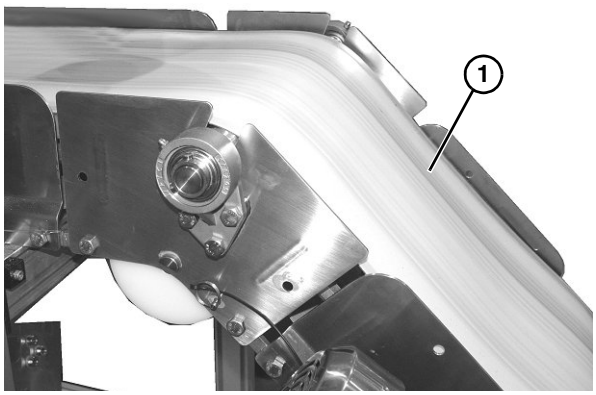


Figure 22

Installation

Guides

1. Install the belt return **(Figure 23, item 1)**.

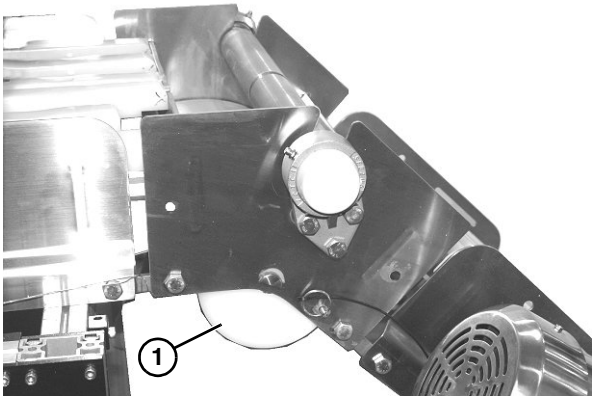


Figure 23

2. Slide the guides **(Figure 24, item 2)** onto the knuckle frame, and secure with two pull pins **(Figure 24, item 3)**.

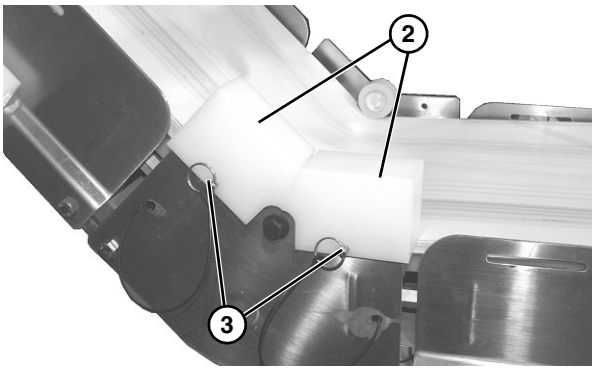


Figure 24

3. Repeat for opposite side of conveyor.

All Conveyors

Belt Return Installation

Flat Belt

Typical Flat Belt Components **(Figure 25)**

1	Flat belt returns

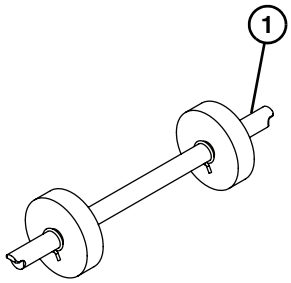


Figure 25

1. Slide the return shaft **(Figure 26, item 1)** up and through the large slot **(Figure 26, item 2)** in the frame.

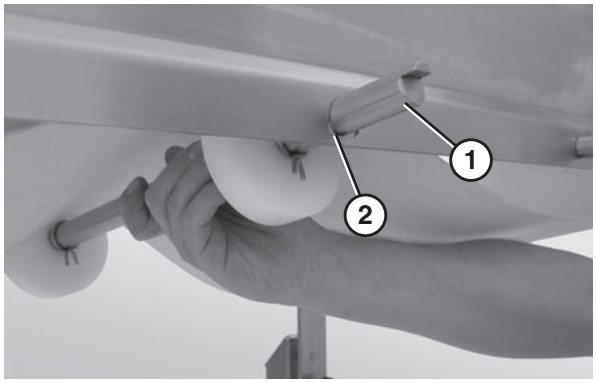


Figure 26

2. Push up on the return shaft **(Figure 27, item 1)** and slide the notched end of the shaft through the small slot **(Figure 27, item 2)** on the opposite side of the frame.

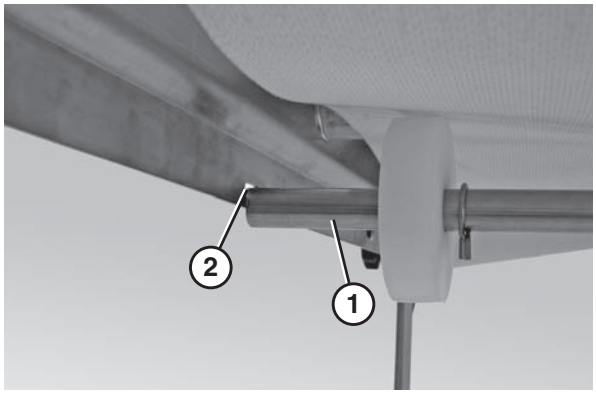


Figure 27

3. Repeat the procedure for all other belt returns.

Cleated Belt

Typical Cleated Belt Components **(Figure 28)**

1	Cleated belt returns

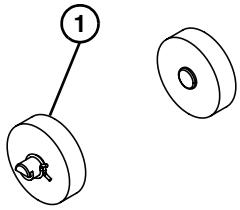


Figure 28

1. Insert the notched end of the return shaft **(Figure 29, item 1)** through the small hole **(Figure 29, item 2)** in the inside of the conveyor frame.

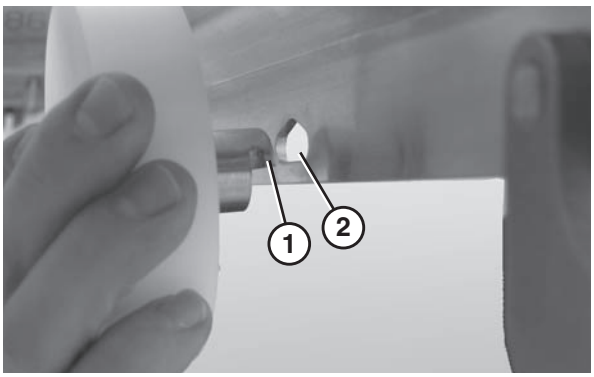


Figure 29

2. Repeat the procedure for all other belt returns.

Scraper Installation

Typical Scraper Components **(Figure 30)**

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

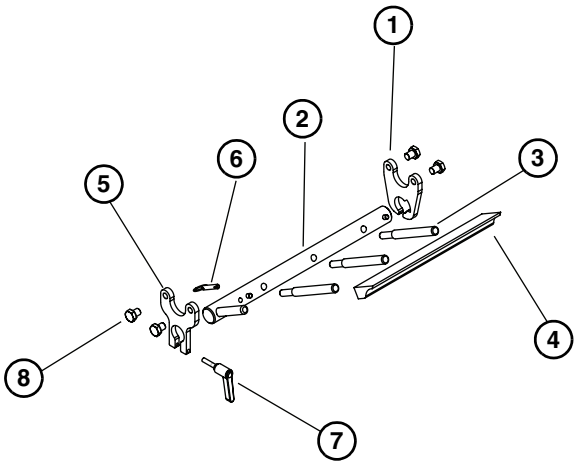


Figure 30

1. Attach the scraper adjust plate **(Figure 30, item 1)** and the scraper mount plate **(Figure 30, item 5)** to the frame using four M10-1.5 x 12 mm hex head cap screws.

2. Slide the notched end of the scraper shaft **(Figure 31, item 1)** through the adjustment plate **(Figure 31, item 2)**.

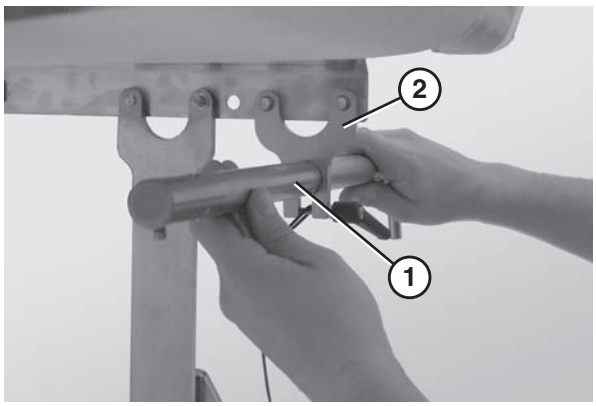


Figure 31

3. Insert the notched end of the scraper shaft **(Figure 32, item 1)** so that it is situated within the groove in the mounting plate **(Figure 32, item 2)**.

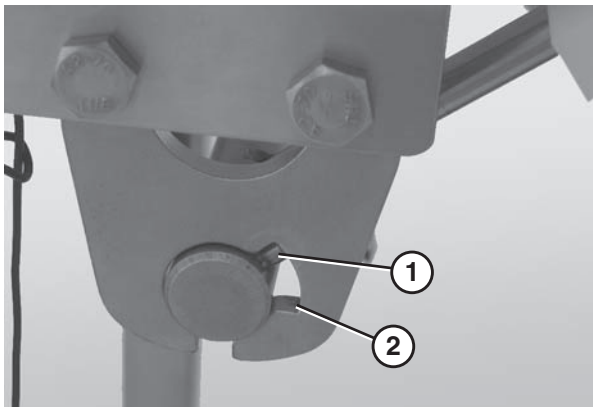


Figure 32

4. Attach the scraper bar holders **(Figure 33, item 1)** to the scraper shaft **(Figure 33, item 2)**.

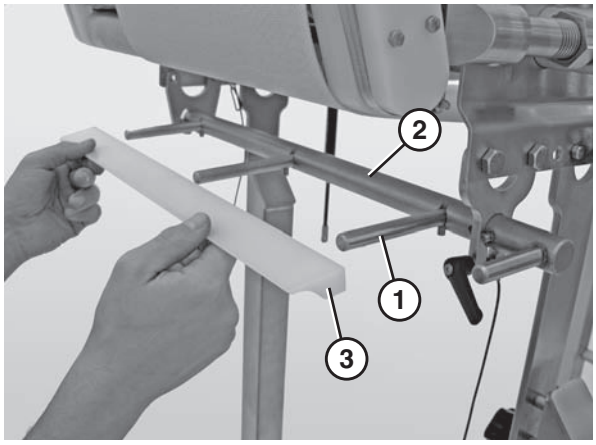


Figure 33

5. Attach the UWHM scraper **(Figure 33, item 3)** to the scraper bar holders **(Figure 33, item 1)**.

6. Insert the pin **(Figure 34, item 1)** to lock the scraper bar in place **(Figure 34, item 2)**.

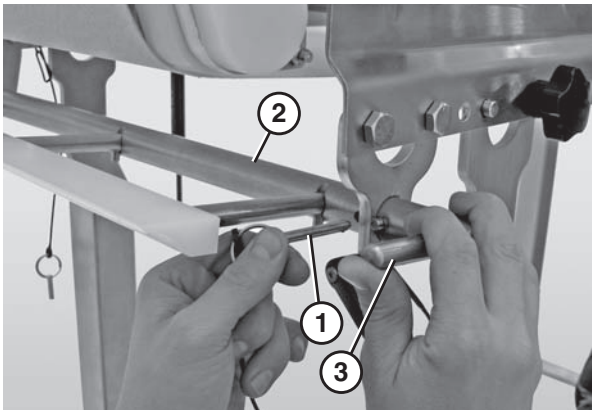


Figure 34

7. Adjust the scraper to the desired position using the scraper bar handle **(Figure 34, item 3)**.

⚠ CAUTION

Apply minimal pressure between the scraper (Figure 35, item 1) and the belt (Figure 35, item 2).

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

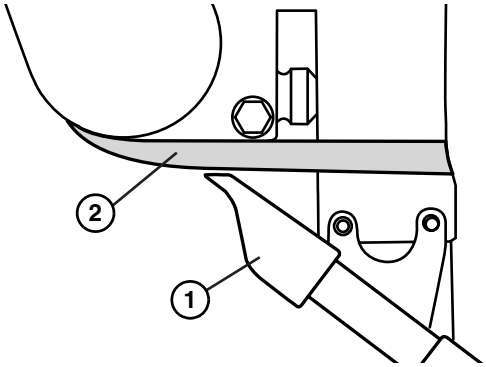


Figure 35

8. Secure the scraper by tightening the handle **(Figure 36, item 1)**.

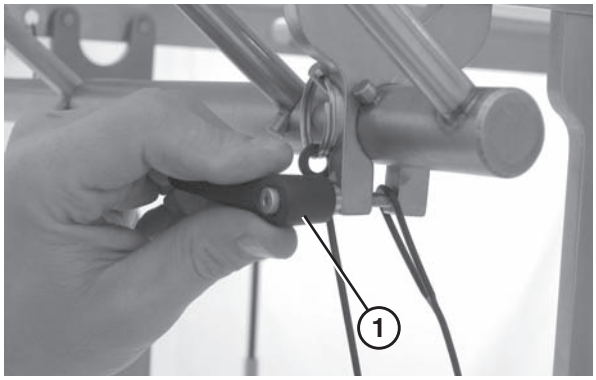


Figure 36

Stand Installation

Typical Stand Components **(Figure 37)**

1	Conveyor
2	Stand
3	Knob
4	M10-1.50 x 12 mm hex head cap screws (x2)

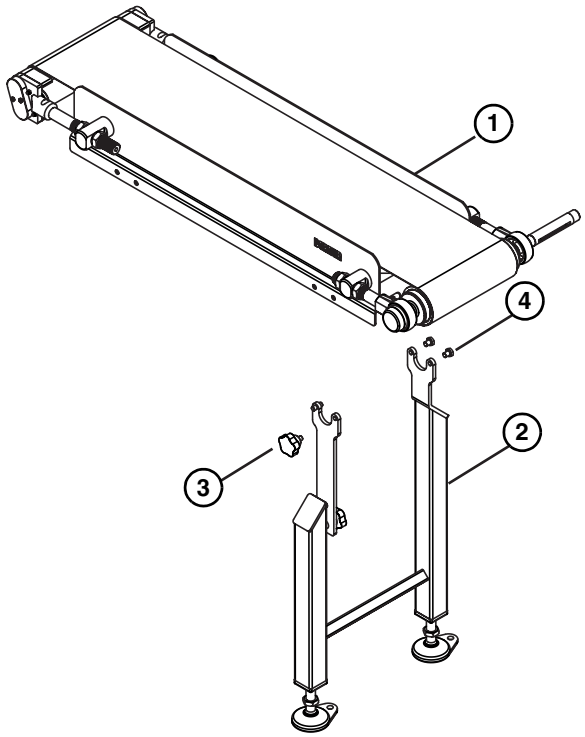


Figure 37

1. Properly support the conveyor.

2. Attach the non-quick release side of the stand **(Figure 38, item 1)** to the MOTOR SIDE of the conveyor **(Figure 38, item 2)** using two M10-1.5 x 12mm hex head cap screws **(Figure 38, item 3)**.

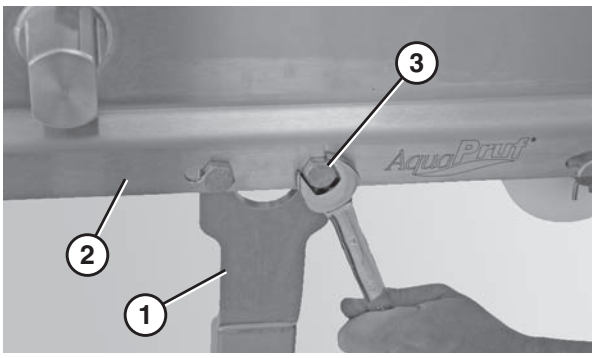


Figure 38

3. Attach the quick-release arm to the stand with the knob **(Figure 37, item 3)**.

For detailed assembly instructions, refer to the "Sanitary Support Stands Installation, Maintenance and Parts Manual."

Drive Package Installation

Typical Motor Components **(Figure 39)** (end drive shown)

1	End drive package
2	Motor

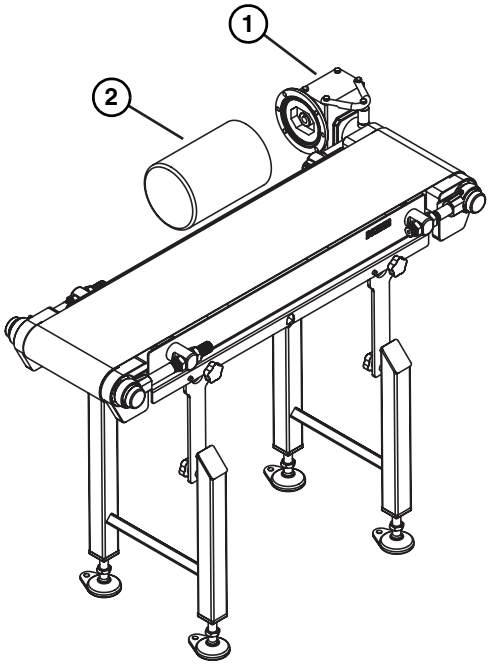


Figure 39

1. Attach the motor **(Figure 40, item 1)** to the gear reducer **(Figure 40, item 2)**.

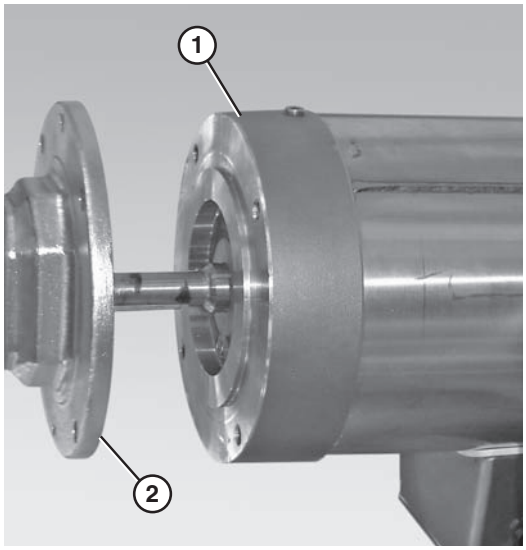


Figure 40

For detailed assembly instructions, refer to the "7600 Series End Drive Packages Installation, Maintenance and Parts Manual."

Required Tools

- 14 mm wrench (or adjustable wrench)
- 4 mm or 5/32 in. hex wrench (for bearing shaft assembly fasteners)
- 8 mm wrench
- 10 mm wrench
- 17 mm wrench
- 3 mm hex wrench
- 5 mm hex wrench

Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 30 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.

Routine Cleaning

⚠ WARNING

SEVERE HAZARD!

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

Dorner recommends cleaning the inside and the outside of the conveyor on a daily basis. Refer to the following steps to access the inside of the conveyor.

Standard Conveyors

1. Remove the guides, if applicable, by removing the pull pins **(Figure 41, item 1)** that connect the guide **(Figure 41, item 2)** to the frame.

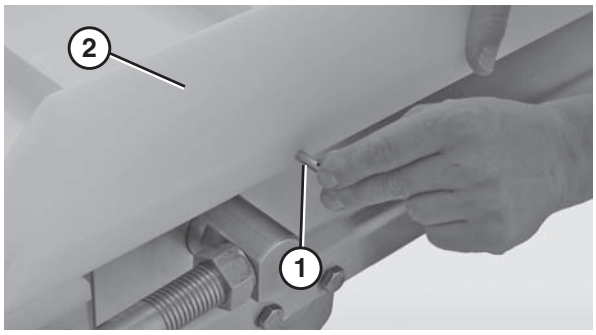


Figure 41

2. Place the tip up tail **(Figure 42, item 1)** in the up position.

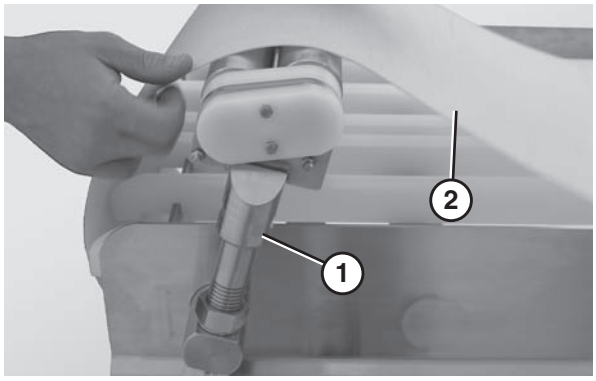


Figure 42

3. Lift up on the belt **(Figure 42, item 2)**.

Conveyors with Lifters

1. Remove the guides, if applicable, by removing the pull pins **(Figure 43, item 1)** that connect the guide **(Figure 43, item 2)** to the frame.
2. Place the tip up tail in the up position.
3. Use the lifter handle **(Figure 43, item 1)** to raise the belt **(Figure 43, item 2)**.

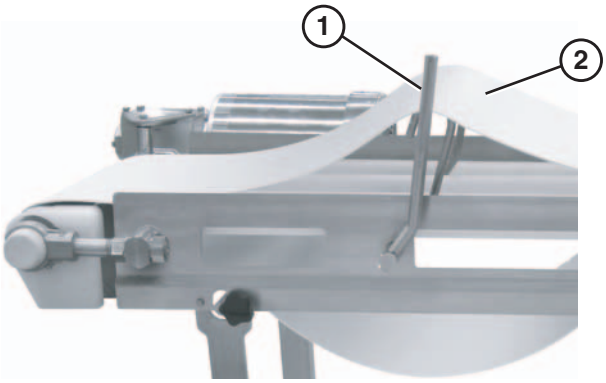


Figure 43

⚠ CAUTION

DO NOT submerge or soak bearing assemblies. This will reduce the life of the bearing.

Periodic Cleaning

Dorner recommends complete disassembly of the conveyor periodically for thorough cleaning.

For conveyor disassembly and reassembly instructions:

- Refer to “Conveyor Belt Replacement” on page 17.
- Refer to “Spindle Removal” on page 20.

Lubrication

Conveyor Bearings

Conveyor bearing lubrication is required. Dorner recommends using an H-1 food grade grease.

NOTE

Although bearings are sealed, re-greasing is recommended to increase bearing life. An H-1 food grade grease is recommended. The frequency of bearing re-greasing is dependent upon the application in which the conveyor is being used. Frequency of re-greasing will increase with the frequency of conveyor washing.

1. Add grease to the bearing using the zerk fitting **(Figure 44, item 1)** on the exterior of the bearing shaft assembly.

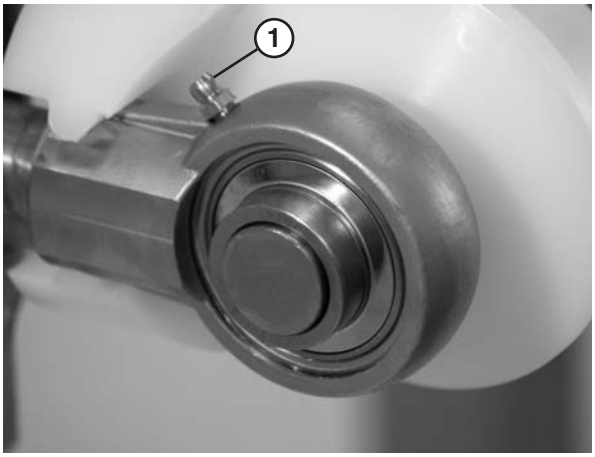


Figure 44

2. Replace the bearings if they become worn.

Wearstrips and Belt Returns

Replace the wearstrips and belt returns if they become worn.

For wearstrip and belt return installation instructions:

- Refer to “Wear Strip Installation” on page 8.
- Refer to “Belt Return Installation” on page 12.

Scraper

Replace the UHMW scraper if it becomes worn.

Refer to “Scraper Installation” on page 13 for scraper installation instructions.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

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

Inspect conveyor belt for:

- Surface cuts or wear

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

- 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.

Conveyors with Guides

1. Remove the pull pins **(Figure 45, item 1)** that connect the guide **(Figure 45, item 2)** to the frame.

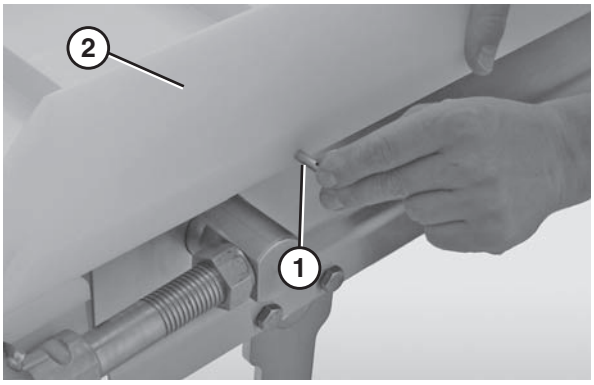


Figure 45

2. Remove the guide **(Figure 46, item 1)** from the conveyor **(Figure 46, item 2)**.

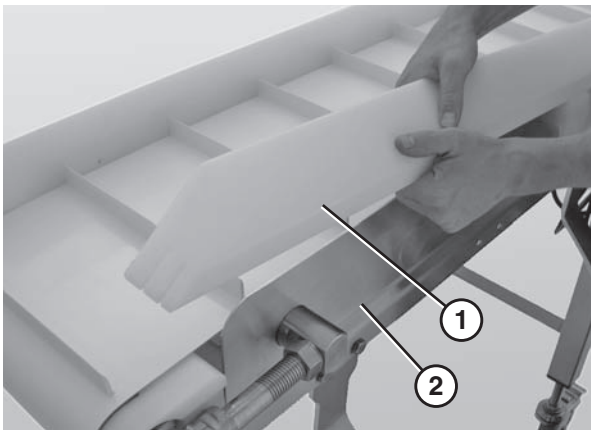


Figure 46

Standard Belts

1. Place the idler tail **(Figure 47, item 1)** in the UP position.

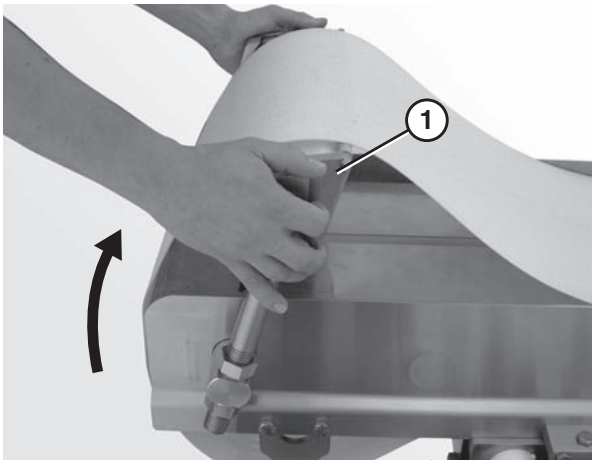


Figure 47

⚠ WARNING

SEVERE HAZARD!

- **ONLY DISCONNECT ONE PIVOT BRACKET AT A TIME AND ONLY IF THE STANDS ARE BOLTED TO THE FLOOR.**
- **Disconnecting more than one pivot bracket at a time or not bolting the stands to the floor can cause the conveyor to tip and may result in serious injury.**

2. Lower the quick release arm **(Figure 48, item 1)** on one of the stands. *Note: if the conveyor is not equipped with Quick Release (QR Type) stands, it will be necessary to remove the entire stand.* For detailed instructions, refer to the "Sanitary Support Stands Installation, Maintenance and Parts Manual."

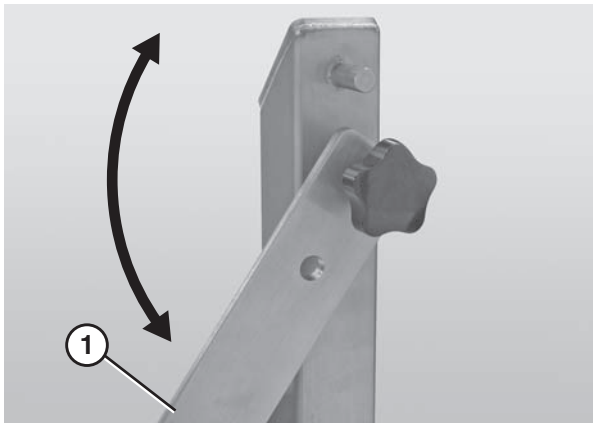


Figure 48

3. Slide the old belt **(Figure 49, item 1)** off the conveyor frame **(Figure 49, item 2)**.

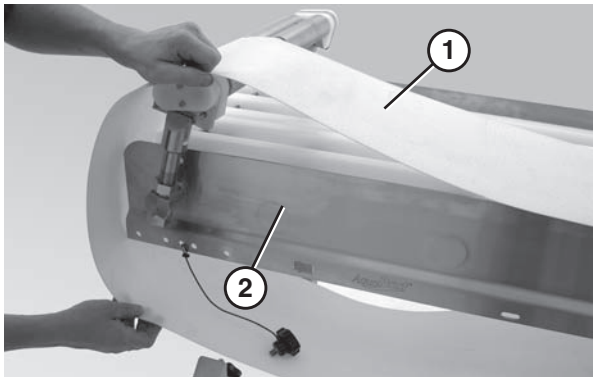


Figure 49

4. Secure the quick release arm on the stand and repeat steps 2 and 3 until the entire belt is off the conveyor.
5. Replace the old belt with a new one. Refer to "Belt Installation" on page 9.

Conveyor Belt Tensioning

⚠ WARNING

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

⚠ CAUTION

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

1. Loosen the back nuts **(Figure 50, item 1)** on both sides of the idler tail shaft.

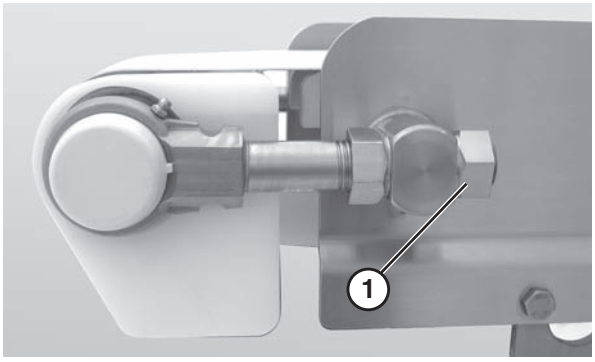


Figure 50

2. Turn the front nuts closest to the tail **(Figure 51, item 1)** clockwise in order to increase tension on the belt.

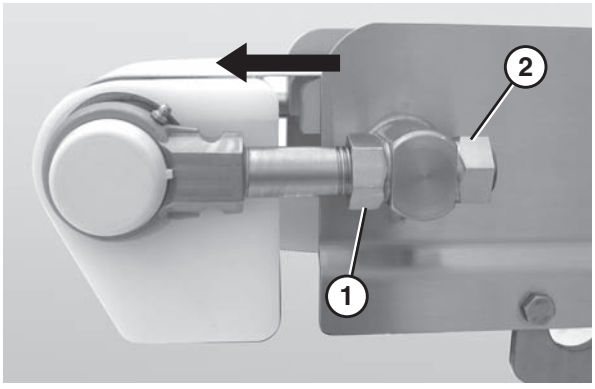


Figure 51

⚠ CAUTION

Ensure that there is at least 152 mm from the frame to the end of the tail.

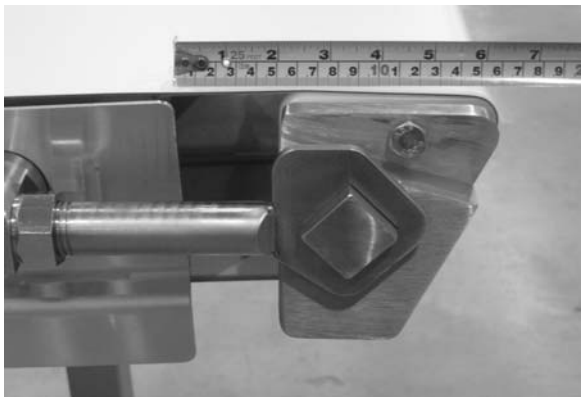


Figure 52

3. Tighten the back nuts **(Figure 51, item 2)** to secure the tail.

Conveyor Belt Tracking

Adjust the lengths of the idler tail shafts to correct conveyor belt tracking.

For v-guide belts, track until the bulge in the conveyor belt **(Figure 53, item 1)** lies flat.

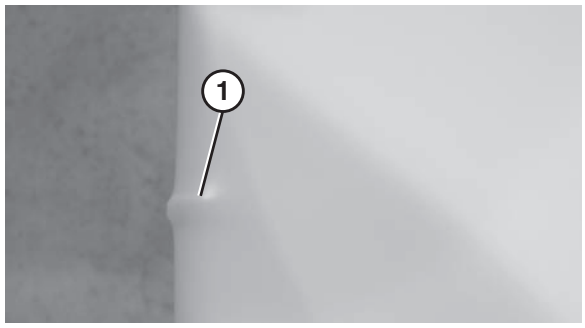


Figure 53

To adjust conveyor belt tracking:

1. Loosen the back nut **(Figure 51, item 2)** on the idler tail shaft that needs to be adjusted.
2. Tighten or loosen the front nut **(Figure 51, item 1)** on the idler tail shaft adjust the belt tracking.

⚠ CAUTION

Ensure that there is at least 152 mm from the frame to the end of the tail.

a. Loosen the nut to shorten the length of the idler tail shaft and bring the belt closer to that side of the conveyor **(Figure 54)**.

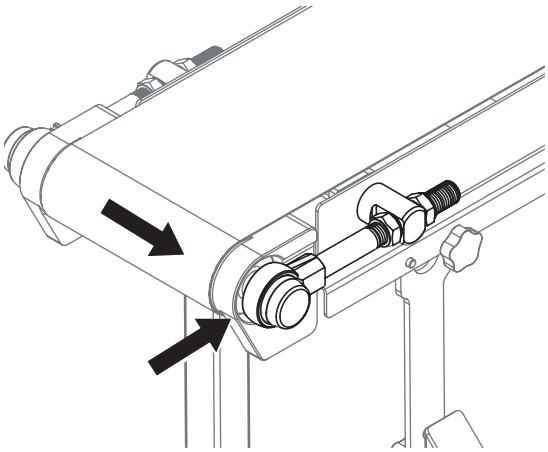


Figure 54

b. Tighten the nut to increase the length of the idler tail shaft and move the belt away from that side of the conveyor **(Figure 55)**.

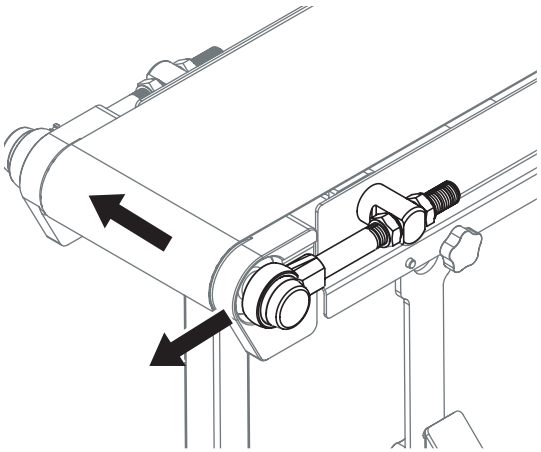


Figure 55

3. Tighten the back nut on the idler tail shaft when finished.

Spindle Removal

⚠ WARNING

SEVERE HAZARD!

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

1. Remove the conveyor belt to access the spindles. Refer to “Conveyor Belt Replacement” on page 17.
2. Remove the spindle by following the instructions for the specific spindle type:

- A - Drive Spindle Removal
- B - Idler Spindle Removal
- C - .5" Nose Bar Idler Spindle Removal
- D - 1" Nose Bar Idler Spindle Removal
- E - 1.875" Nose Bar Idler Spindle Removal

A - Drive Spindle Removal

⚠ WARNING

PUNCTURE HAZARD!

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

1. Remove the plastic cap on the end of the motor and remove the socket head screw**(Figure 56, item 1)** and the bore plug **(Figure 56, item 2).**

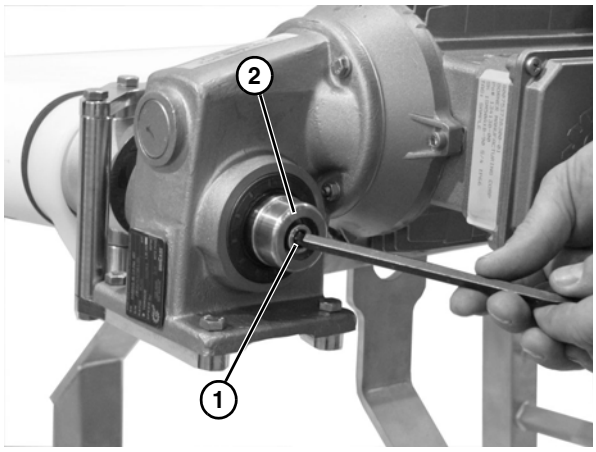


Figure 56

2. Remove the bottom gearhead mounting bar **(Figure 57, item 1)** from the motor mounting bracket **(Figure 57, item 2).** Remove spacer **(Figure 57, item 3)**.

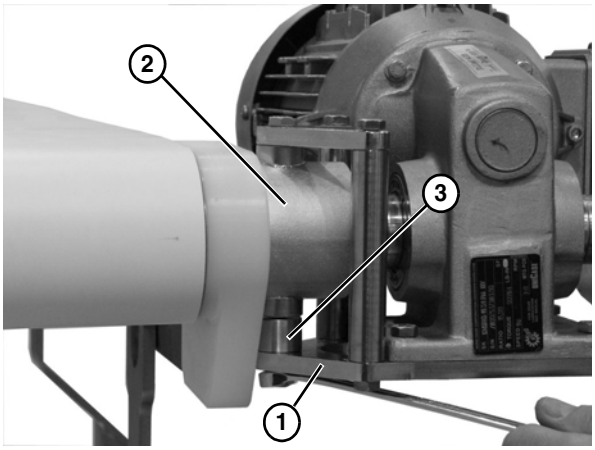


Figure 57

3. Remove the top gearhead mounting bar **(Figure 58, item 1)** from the motor mounting bracket **(Figure 58, item 2)**.

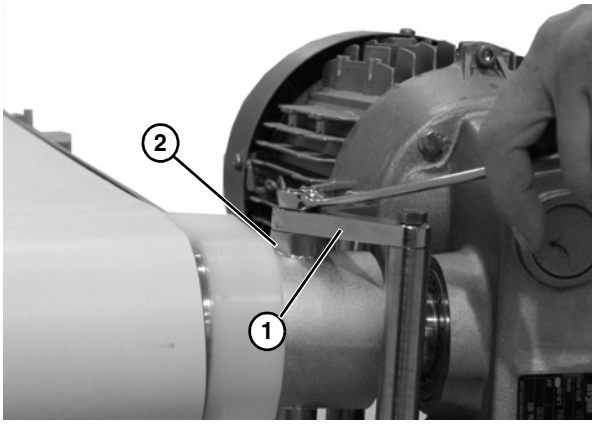


Figure 58

4. Slide the gearmotor assembly **(Figure 59, item 1)** off of the drive spindle **(Figure 59, item 2)**.

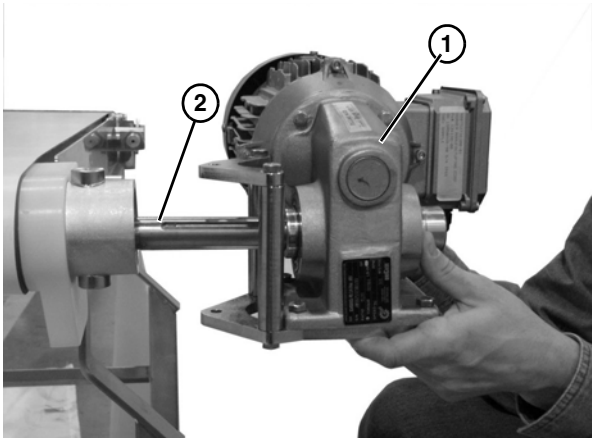


Figure 59

5. Remove the drive spindle key **(Figure 60, item 1)** from the drive spindle keyway **(Figure 60, item 2)**.

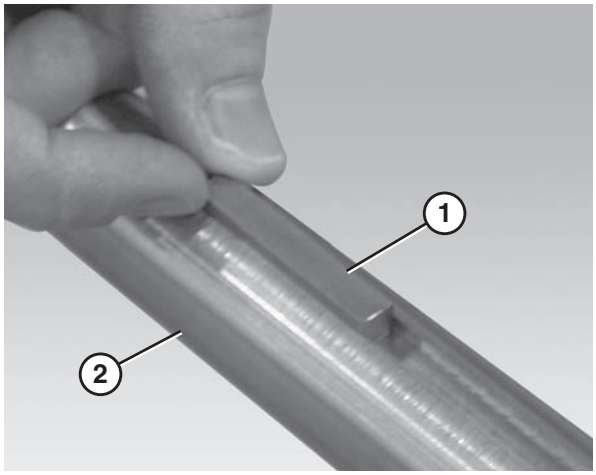


Figure 60

6. Remove the back nut **(Figure 61, item 1)** on both drive tail shafts **(Figure 61, item 2)**.

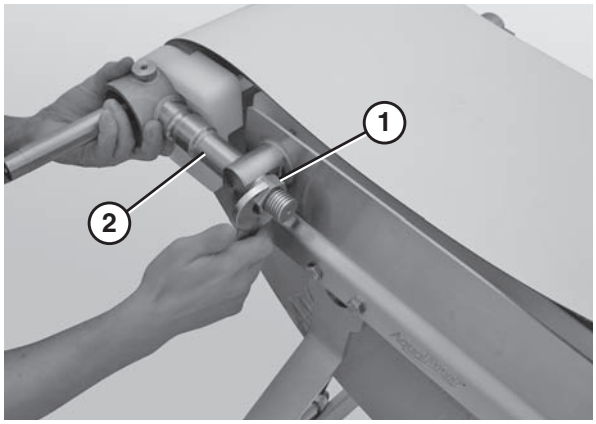


Figure 61

7. Slide the drive tail assembly **(Figure 62, item 1)** out of the take up blocks **(Figure 62, item 2)**.

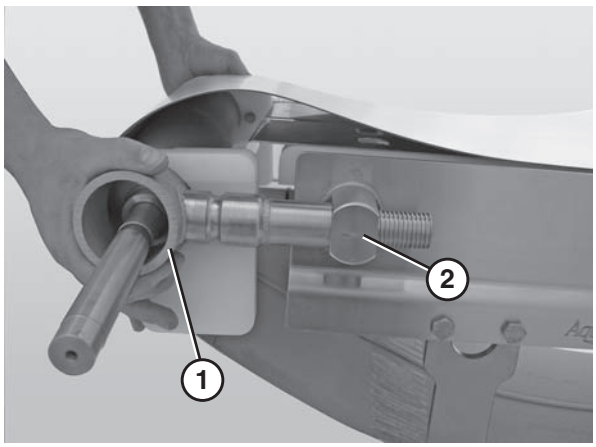


Figure 62

8. Slide the motor support bracket **(Figure 63, item 1)** off the drive spindle **(Figure 63, item 2)**.

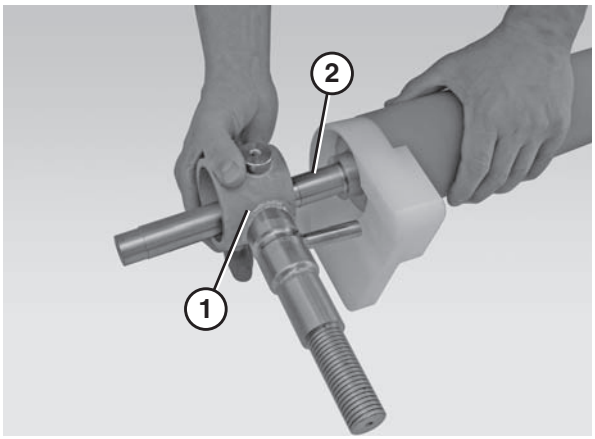


Figure 63

9. Use a 4 mm hex wrench to loosen the bearing fasteners **(Figure 64, item 1)**.

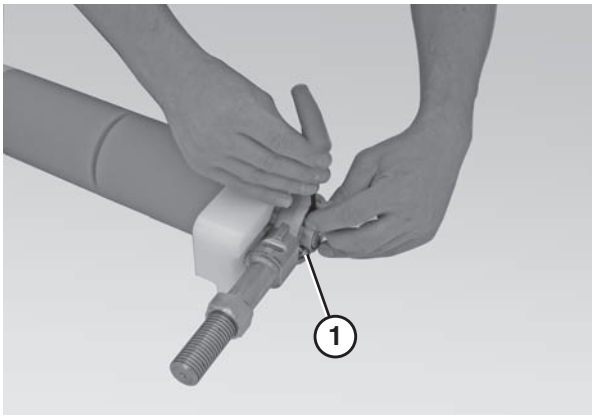


Figure 64

10. Remove the bearing shaft **(Figure 65, item 1)** and both pinch guards **(Figure 65, item 2)**.

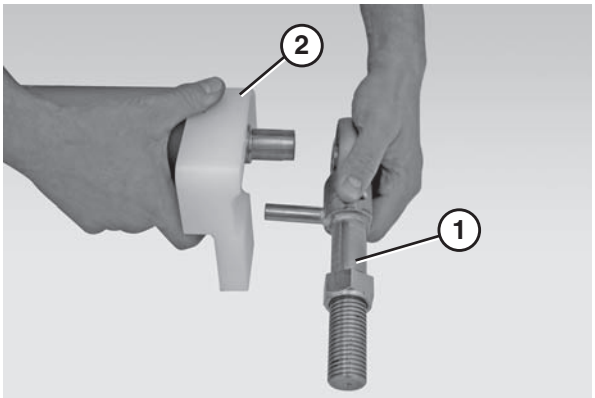


Figure 65

B - Idler Spindle Removal

1. Remove the back nuts **(Figure 66, item 1)** on both idler tail shafts.

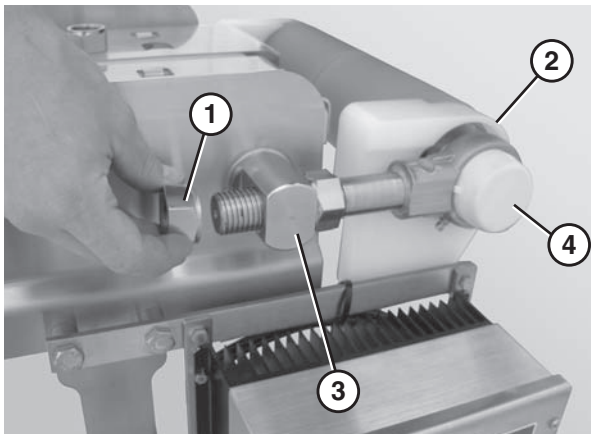


Figure 66

2. Slide the idler tail assembly **(Figure 66, item 2)** out of the take up blocks **(Figure 66, item 3)**.
3. Remove the bearing covers **(Figure 66, item 4)**.
4. Use a 4 mm hex wrench to loosen the bearing shaft assembly fasteners **(Figure 67, item 1)**.

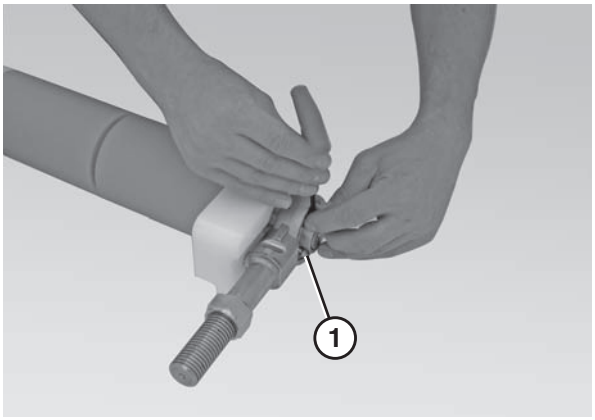


Figure 67

5. Remove the bearing shafts **(Figure 68, item 1)** and both pinch guards **(Figure 68, item 2)**.

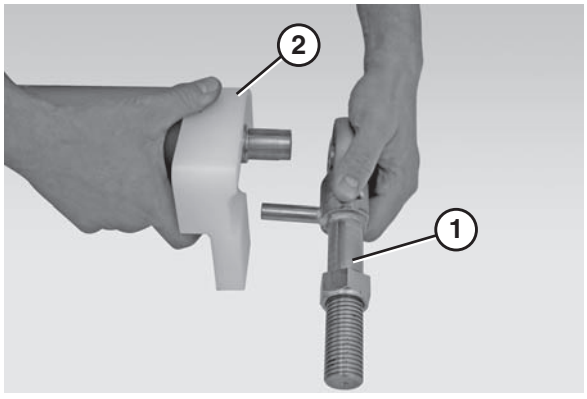


Figure 68

C - .5" Nose Bar Idler Spindle Removal

1. Remove the back nuts **(Figure 69, item 1)** on both discharge nose bar shafts.

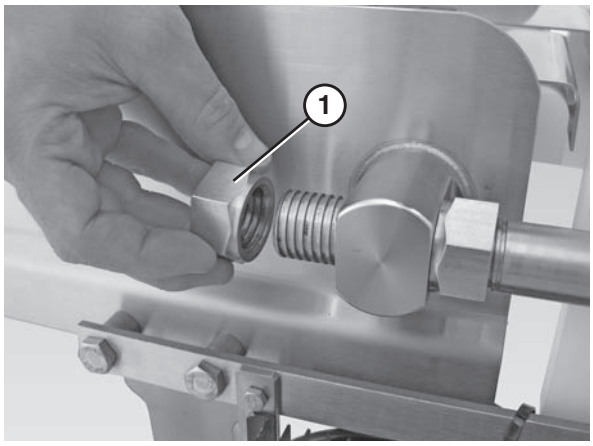


Figure 69

2. Slide the nose bar tail assembly **(Figure 70, item 1)** out of the take up blocks **(Figure 70, item 2)**.

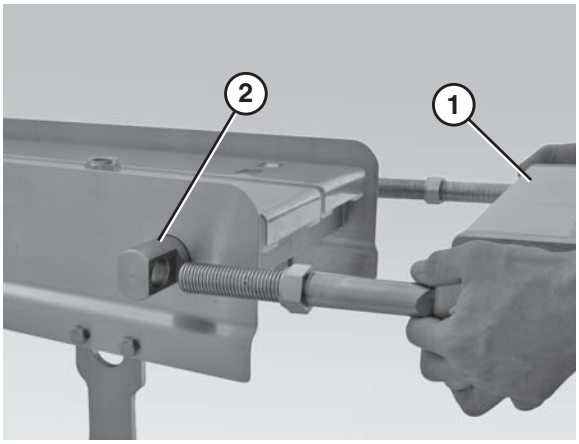


Figure 70

3. Slide the nose bar shafts **(Figure 71, item 1)** off of the nose bar weldment **(Figure 71, item 2)**.

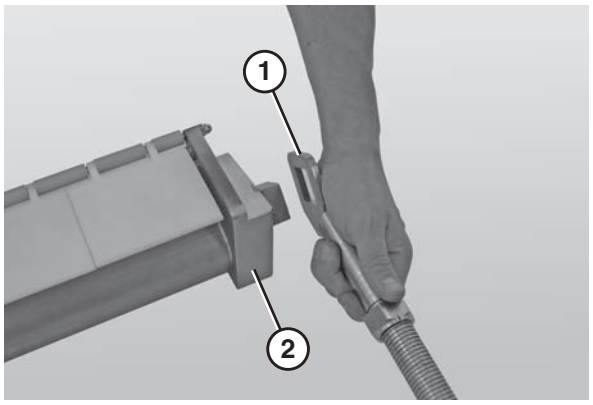


Figure 71

4. Use a 10 mm wrench to remove one of the acorn nuts **(Figure 72, item 1)** from the nose bar shaft.

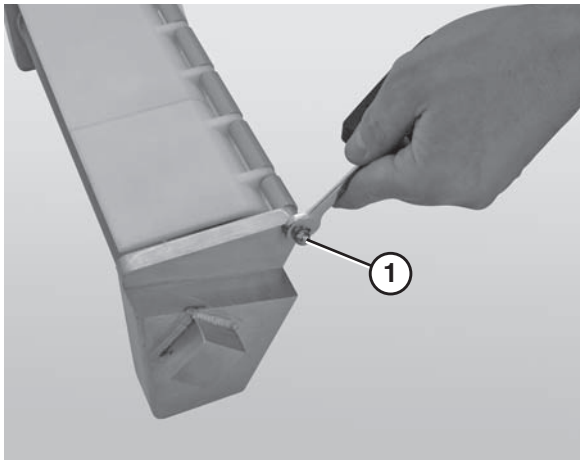


Figure 72

5. Remove the nose bar shaft **(Figure 73, item 1)**, the rollers **(Figure 73, item 2)** and the roller mounts **(Figure 73, item 3)**.

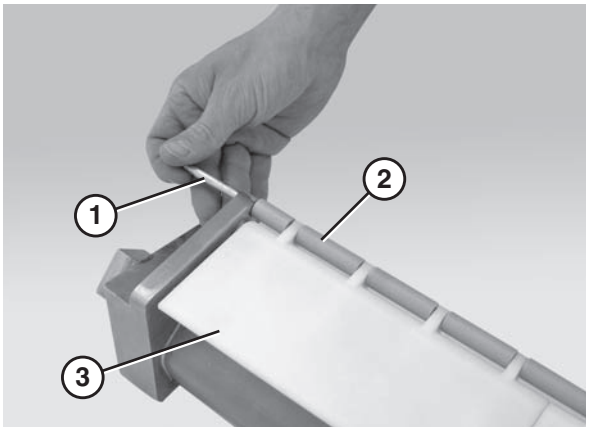


Figure 73

6. Remove the nose bar return spindle **(Figure 74, item 1)**.

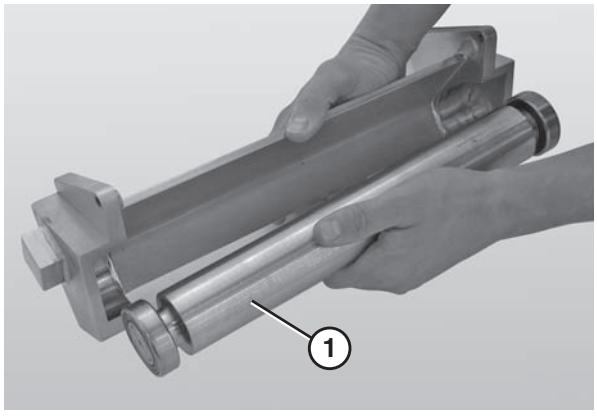


Figure 74

D - 1" Nose Bar Idler Spindle Removal

1. Remove the back nuts **(Figure 75, item 1)** on both discharge nose bar shafts.

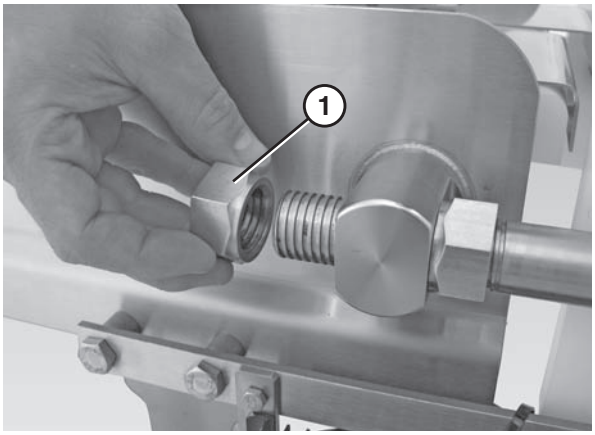


Figure 75

2. Slide the nose bar tail assembly **(Figure 76, item 1)** out of the take up blocks **(Figure 76, item 2)**.

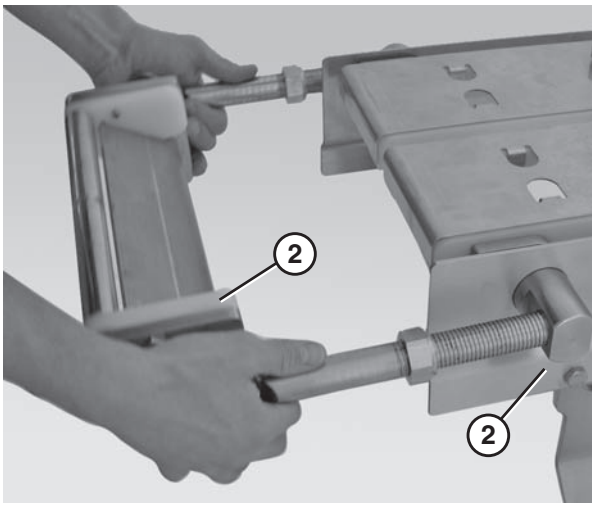


Figure 76

3. Slide the nose bar shafts **(Figure 77, item 1)** off of the nose bar weldment **(Figure 77, item 2)**.

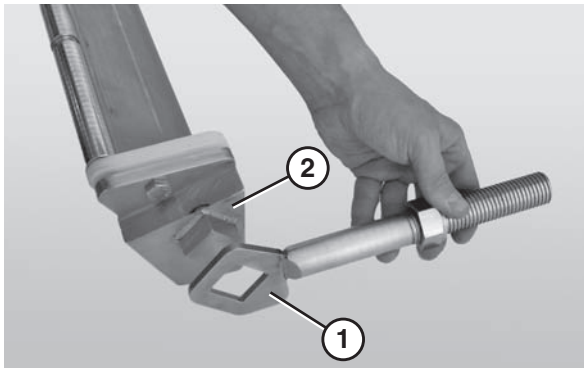


Figure 77

4. Use a 17 mm wrench to remove both pilot nose bolts **(Figure 78, item 1)** from the nose bar weldment **(Figure 78, item 2)**.

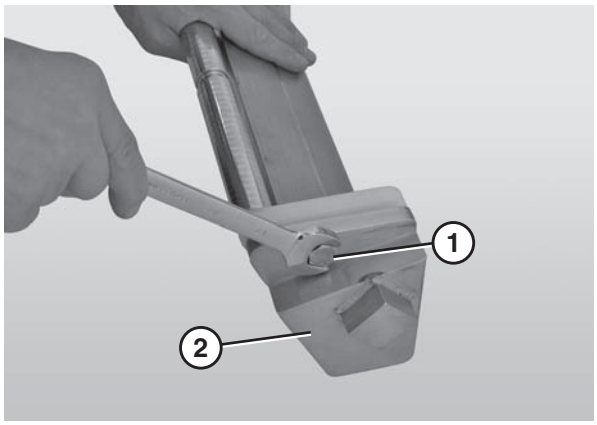


Figure 78

5. Slide the nose bar puck holders **(Figure 79, item 1)** and the nose bar spindle **(Figure 79, item 2)** off of the nose bar weldment **(Figure 79, item 3)**.

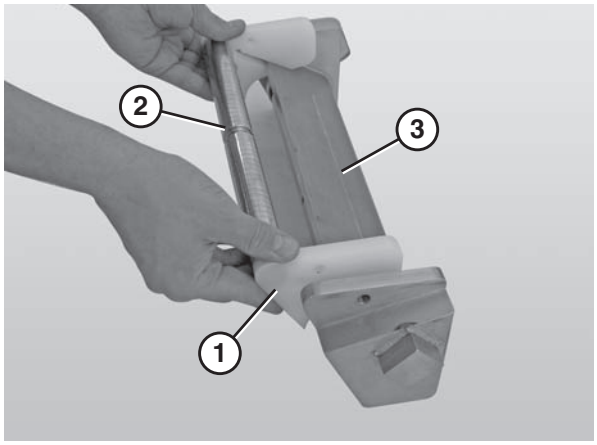


Figure 79

6. Remove the nose bar return spindle **(Figure 80, item 1)**.

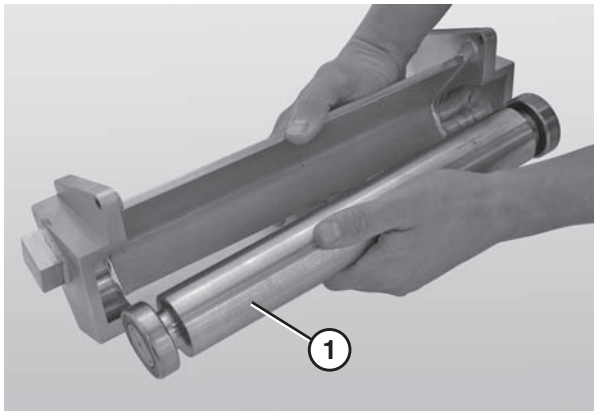


Figure 80

E - 1.875" Nose Bar Idler Spindle Removal

1. Slide the pinch guard blocks **(Figure 81, item 1)** off the nose bar spindles **(Figure 81, item 2)**.

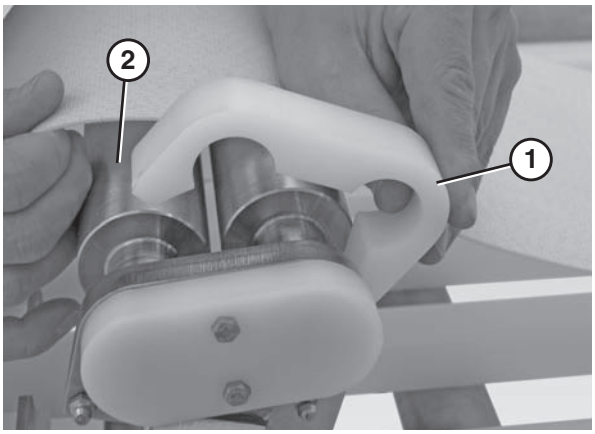


Figure 81

2. Remove the transfer bearing screws **(Figure 82, item 1)** and the cover **(Figure 82, item 2)** using an 8 mm wrench.

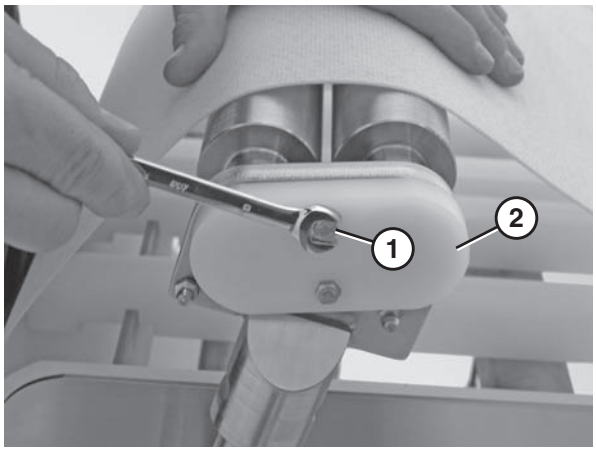


Figure 82

3. Remove the back nuts **(Figure 83, item 1)** on both discharge nose bar shafts.

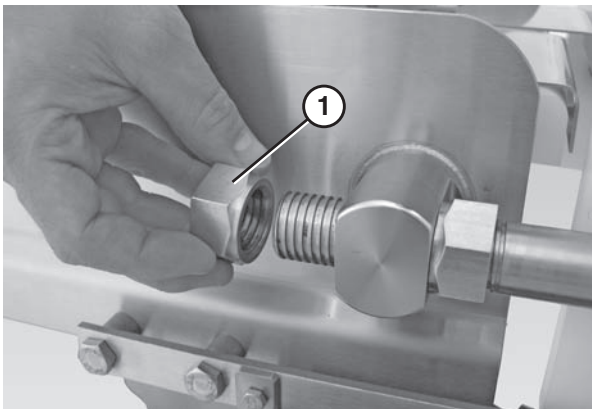


Figure 83

4. Slide the nose bar tail assembly **(Figure 84, item 1)** out of the take up blocks **(Figure 84, item 2)**.

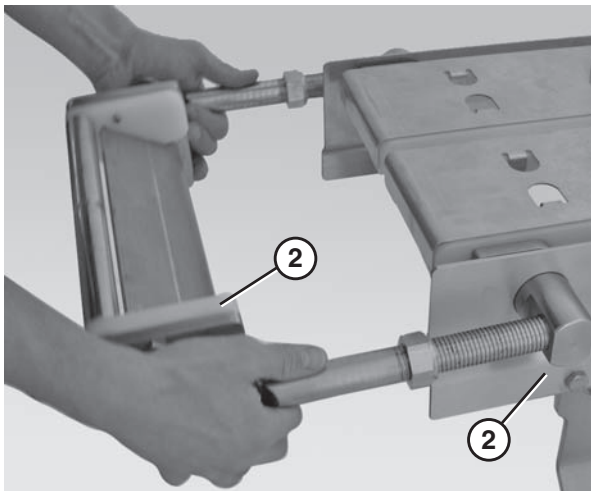


Figure 84

5. Use a 4 mm hex wrench to loosen all the bearing fasteners **(Figure 85, item 1)**.

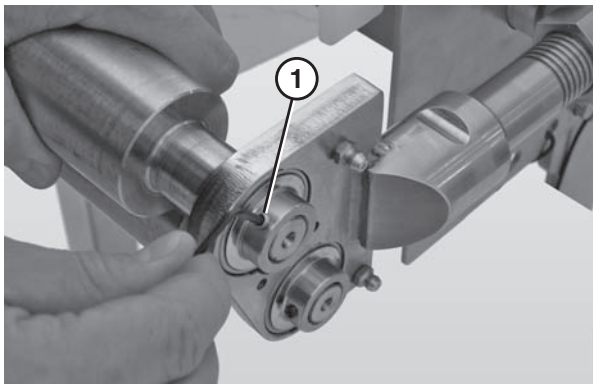


Figure 85

6. Slide the nose bar shafts **(Figure 86, item 1)** off the nose bar spindles **(Figure 86, item 2)**.

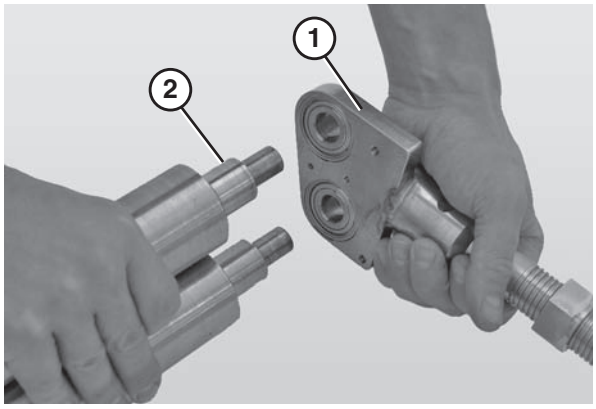


Figure 86

Reassembling Tail Assemblies

Refer to the "Service Parts" section starting on page 30 for complete diagrams and lists of all tail assembly components.

Gas Assist Replacement

1. Raise the tip up tail.
2. Remove the pull pin **(Figure 87, item 1)**.

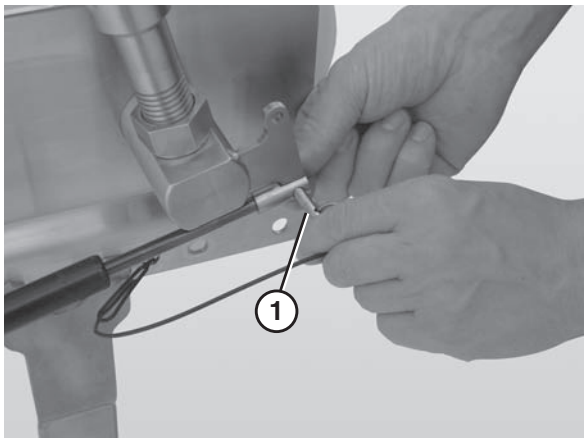


Figure 87

3. Remove the hex bolt **(Figure 88, item 1)** that connects the gas spring **(Figure 88, item 2)** to the gas spring standoff post **(Figure 88, item 3)**.

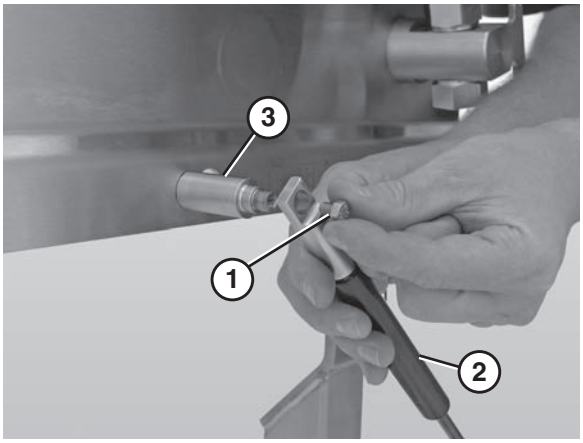


Figure 88

4. Remove the inside hex bolt that connects the standoff post **(Figure 88, item 3)** to the frame.

Bearing Replacement

Standard Bearings

1. Secure the bearing shaft.
2. Remove the bearing cover.
3. Insert the rod end of another bearing shaft through the bearing orifice **(Figure 89)**.

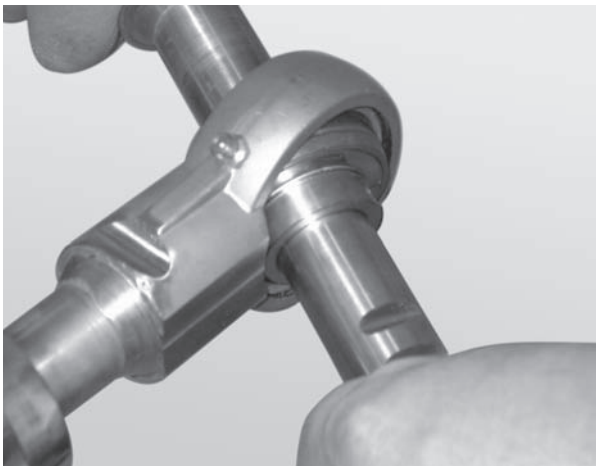


Figure 89

4. Apply lateral pressure to the rod until the bearing comes loose.

5. Remove the worn or damaged bearing **(Figure 90, item)**.

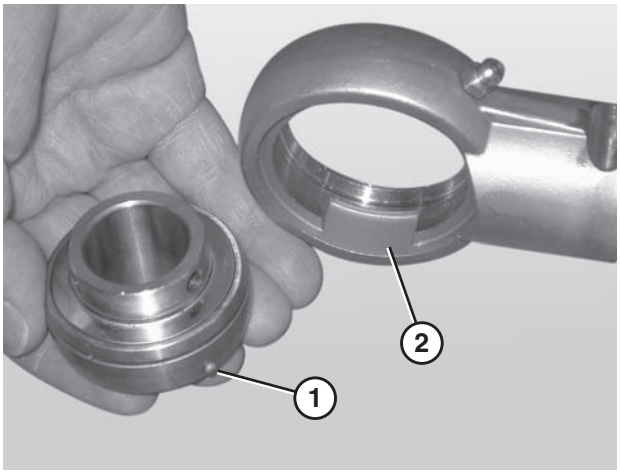


Figure 90

6. Replace the bearing.

NOTE
*When inserting the new bearing, make sure the anti-rotation notch **(Figure 90, item 1)** on the bearing lines up with the groove inside the housing **(Figure 90, item 2)**.*

.5" and 1" Nose Bar Return Spindle Bearings

1. Remove the nose bar return spindle. Refer to "Spindle Removal" starting on page 20.
2. Using a bearing removal tool **(Figure 91, item 1)**, remove the bearing **(Figure 91, item 2)**.

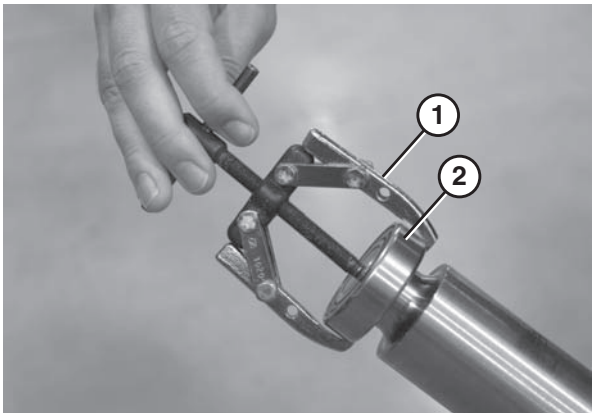


Figure 91

3. Replace the bearing.

1" Nose Bar Bearings

1. Remove the nose bar spindle. Refer to "Spindle Removal" starting on page 20.
2. Remove the nose bar puck holders **(Figure 92, item 1)**.

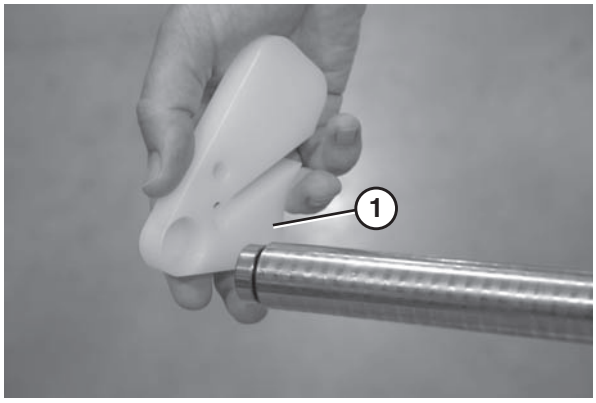


Figure 92

3. Using a bearing removal tool **(Figure 93, item 1)** remove the bearing **(Figure 93, item 2)**.

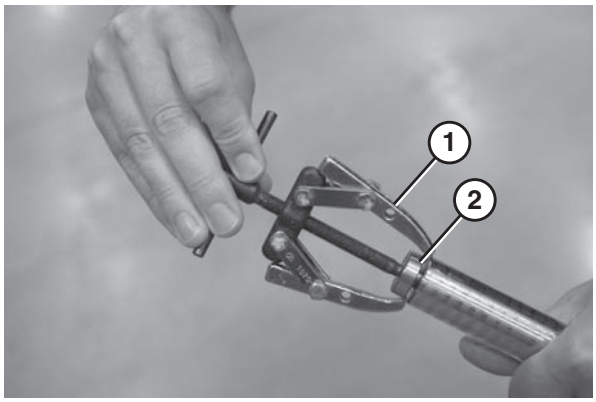


Figure 93

4. Replace the bearing.

1.875" Nose Bar Bearings

1. Remove the nose bar spindle. Refer to "Spindle Removal" starting on page 20.
2. Remove the bearing **(Figure 94, item 1)** from the nose bar shaft assembly **(Figure 94, item 2)**.

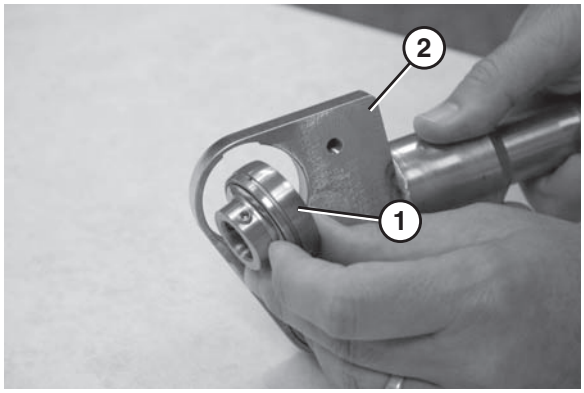


Figure 94

3. Replace the bearing.

LPZ Knuckles

Wearstrips and Belt Returns

Replace the wearstrips and belt returns if they become worn.

For wearstrip and belt return installation instructions:

- For wearstrips, replace as needed, making sure wear strips are situated securely in the frame slots.
- For belt returns, refer to “Belt Return Installation” on page 12.

Removal

1. Remove three bolts **(Figure 95, item 1)** on each side, and remove spindle assembly **(Figure 95, item 2)** from knuckle.

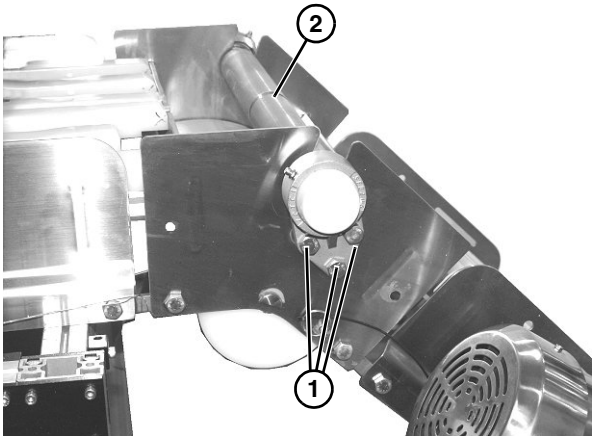


Figure 95

2. Remove the bearing cover **(Figure 96, item 1)**.

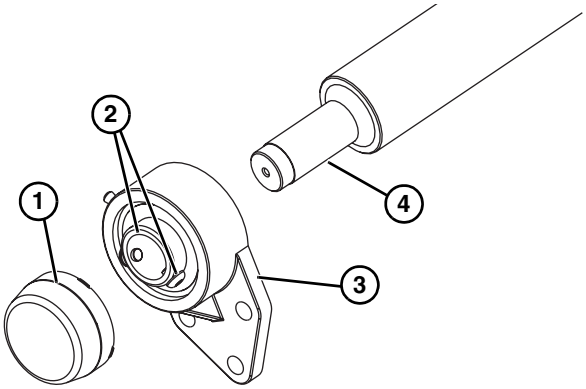


Figure 96

3. Use a hex wrench to loosen the bearing shaft assembly fasteners **(Figure 96, item 2)**.
4. Slide the bearing flange assembly **(Figure 96, item 3)**, off the spindle shaft end **(Figure 96, item 4)**.

Installation

1. Slide the bearing flange assembly **(Figure 97, item 1)**, onto the spindle shaft end **(Figure 97, item 2).**

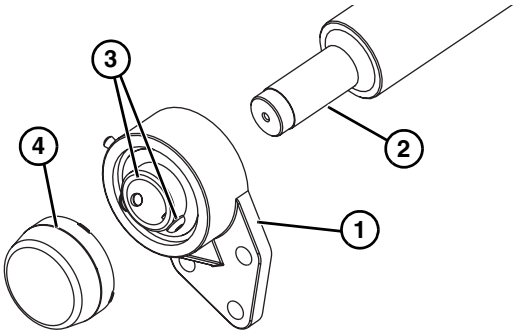


Figure 97

2. Use a hex wrench to tighten the bearing shaft assembly fasteners **(Figure 97, item 3)**.
3. Install the bearing cover **(Figure 97, item 4)**.
4. Insert spindle assembly **(Figure 98, item 1)** onto knuckle, and attach with three bolts **(Figure 98, item 2)**.

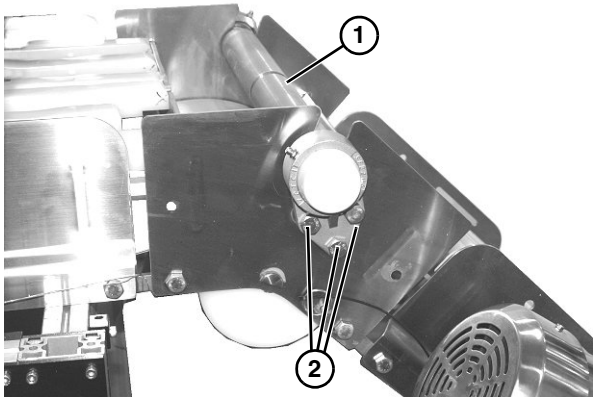


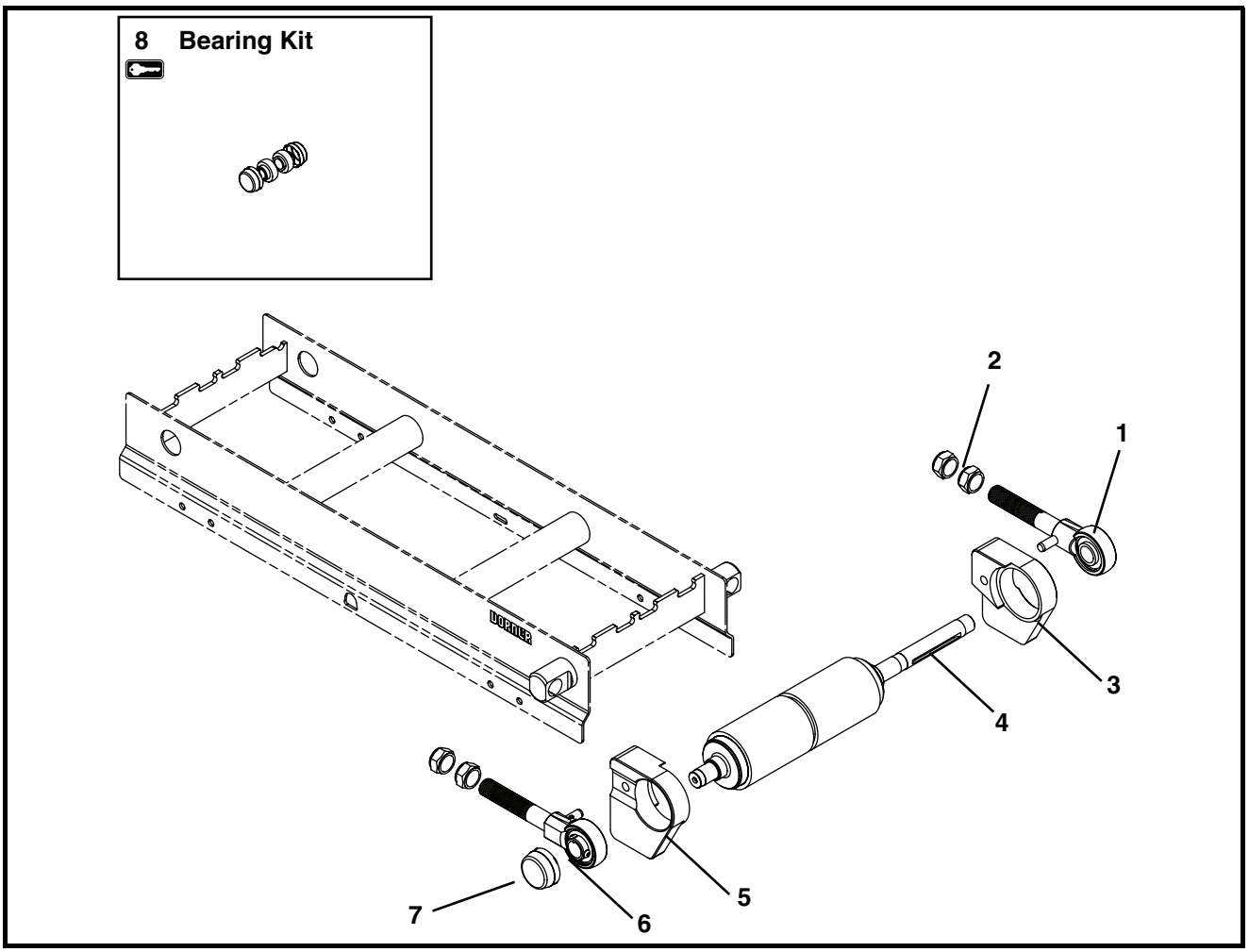
Figure 98

NOTES

Service Parts

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

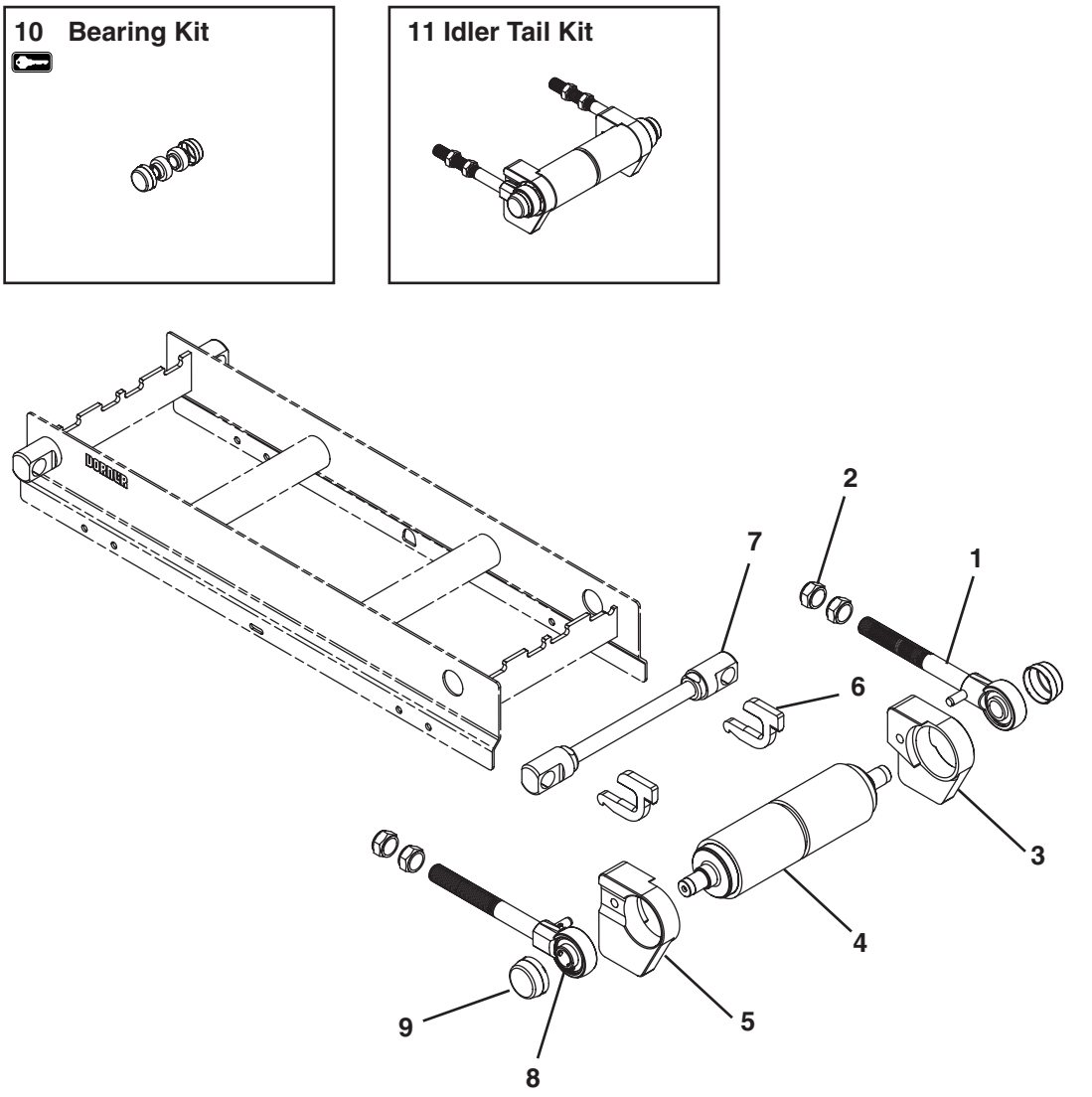
Drive End Components



Item	Part Number	Description
1 *	500892	Drive Shaft Assembly with Bearing and Cover
2	500791	Nut
3	500694	Pinch Guard Right Hand
4	5291WW	Drive Spindle
5	500695	Pinch Guard Left Hand
6	802-162	Bearing
7	807-1454	Bearing Cover

Item	Part Number	Description
8	76BDK	Bearing Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package (Includes Items 6 and 7)
	76BCK	Bearing Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package (Includes Items 6 and 7)
WW = Conveyor width ref: 06 - 60 in 02 increments		
* When the conveyor is ordered with a Dorner gearmotor mounting package a shaft assembly is replaced with a gearmotor mounting bracket.		

Idler End Components



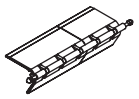
Item	Part Number	Description
1	500891	Idler Shaft Assembly with Bearing and Cover
2	500791	Nut
3	500694	Pinch Guard Right Hand
4	5104WW	Idler Spindle
5	500695	Pinch Guard Left Hand
6	500675	Key Stop

Item	Part Number	Description
7	5048WW	Tip Up Shaft Assembly
8	802-162	Bearing
9	807-1454	Bearing Cover
10	76BK-WW	Bearing Kit (Includes Items 8 and 9)
11	76ST-WW	Idler Tail Kit (Includes Items 1 through 5)
WW = Conveyor width ref: 06 - 60 in 02 increments		

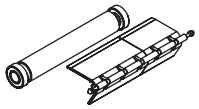
Service Parts

.5" Nose Bar Idler End

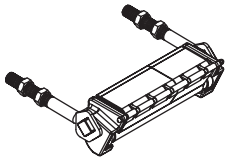
13 .5" Nose Bar Kit

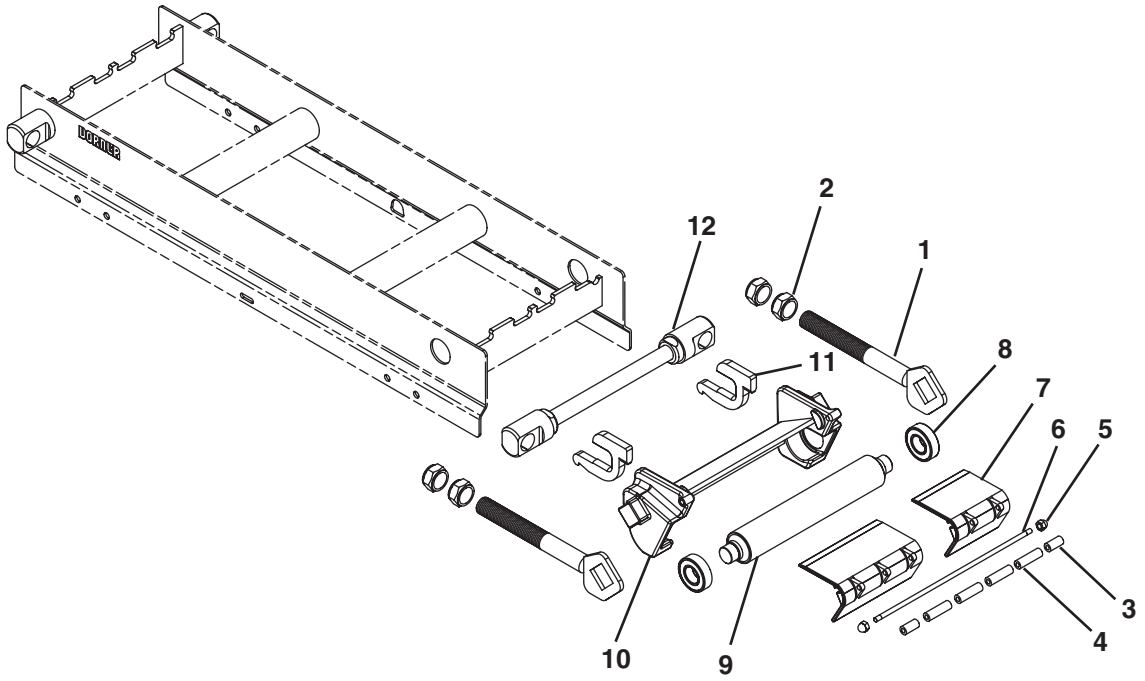


14 .5" Idler Spindle Kit



15 .5" Idler Tail Kit





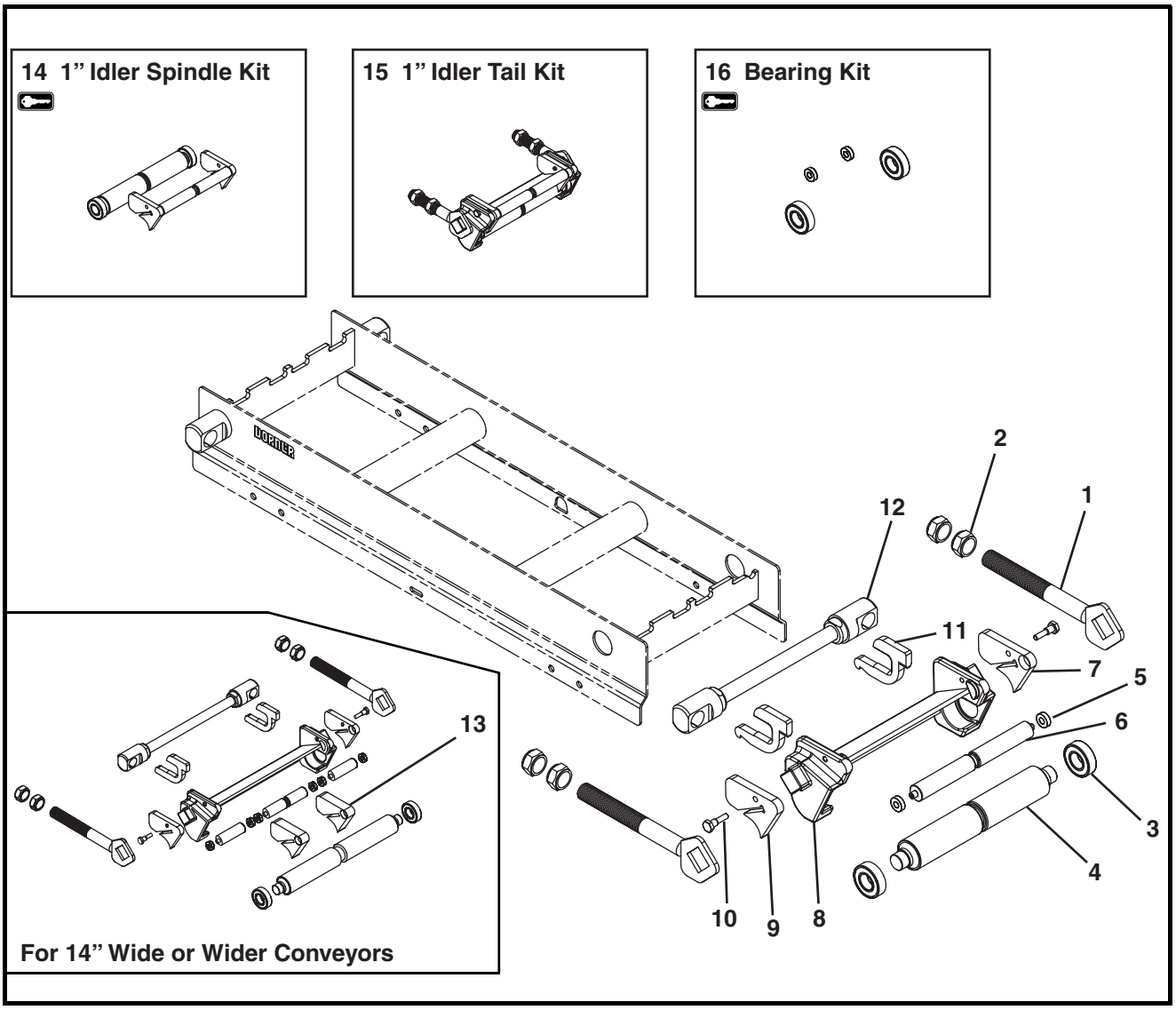
Item	Part Number	Description
1	500997	.5" Nose Bar Shaft Assembly
2	500791	Nut
3	501087	Roller .5" x 1.06"
4	501086	Roller .5" x 1.72"
5	990608MSS	Acorn Nut
6	5099WW	Nose Bar Shaft
7	See Chart	Roller Mount
8	802-164	Return Spindle Bearing
9	5097WW	.5" Nose Bar Return Spindle

Item	Part Number	Description
10	5092WW	.5" Nose Bar Weldment Assembly
11	500675	Key Stop
12	5048WW	Tip Up Shaft Assembly
13	76NB5-WW	.5" Nose Bar Kit (Includes Items 3 through 7)
14	76NB-WW	.5" Idler Spindle Kit (Includes Items 3 through 9)
15	76NBT-WW	.5" Idler Tail Kit (Includes Items 1 through 10)
WW = Conveyor width ref: 06 - 60 in 02 increments		

Item 7: Roller Mount	
Width	**Part Number**
152 mm	501078
203 mm	501077
254 mm	501078 & 501079
305 mm	501077 & 501079
356 mm	501077 & 501078
406 mm	501077 (x2)
457 mm	501077, 501078 & 501079
508 mm	501077 (x2) & 501079
559 mm	501077 (x2) & 501076
610 mm	501077 (x3)
660 mm	501077 (x2), 501078 & 501079
711 mm	501077 (x3) & 501079
762 mm	501077 (x3) & 501078
813 mm	501077 (x4)
864 mm	501077 (x3), 501078 & 501079
914 mm	501077 (x4) & 501079
965 mm	501077 (x4) & 501078
1016 mm	501077 (x5)
1067 mm	501077 (x4), 501078 & 501079
1118 mm	501077 (x5) & 501079
1168 mm	501077 (x5) & 501078
1219 mm	501077 (x6)
1270 mm	501077 (x5), 501078 & 501079
1321 mm	501077 (x6) & 501079
1372 mm	501077 (x6) & 501078
1422 mm	501077 (x7)
1473 mm	501077 (x6), 501078 & 501079
1524 mm	501077 (x7) & 501079

Service Parts

1" Nose Bar Idler End



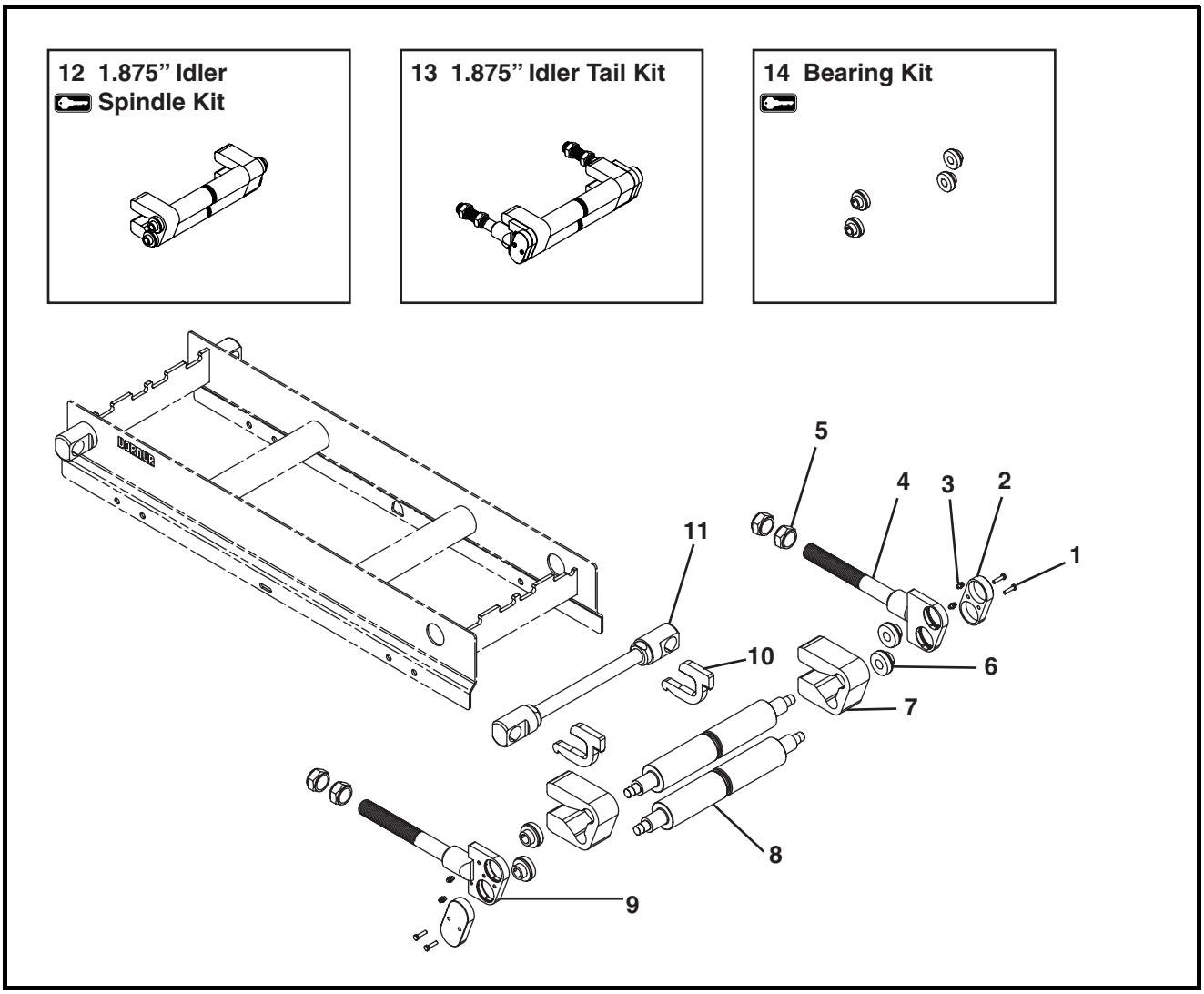
Item	Part Number	Description
1	500997	1" Nose Bar Shaft Assembly
2	500791	Nut
3	802-164	Return Spindle Bearing
4	5107WW	1" Nose Bar Return Spindle
5	802-123	Nose Bar Bearing
6	See Chart	1" Nose Bar Spindle
7	500975	Nose Bar Puck Holder, Right Hand
8	5105WW	1" Nose Bar Weldment Assembly
9	500976	Nose Bar Puck Holder, Left Hand
10	501178	Pilot Nose Bolt

Item	Part Number	Description
11	500675	Key Stop
12	5048WW	Tip Up Shaft Assembly
13	500977	Nose Bar Puck Holder, Center
14	76NB1-WW	1" Idler Spindle Kit (Includes Items 3 through 7 and 9)
15	76NBT1-WW	1" Idler Tail Kit (Includes Items 1 through 10)
16	76BK1-WW	Bearing Kit (Includes Items 3 and 5)
WW = Conveyor width ref: 06 - 60 in 02 increments		

Item 6: 1” Nose Bar Spindle	
Width	**Part Number**
152 mm	505107
203 mm	505108
254 mm	505109
305 mm	505110
356 mm	505103 (x2) & 505107
406 mm	505103 (x2) & 505108
457 mm	505103 (x2) & 505109
508 mm	505103 (x2) & 505110
559 mm	505104 (x2) & 505107
610 mm	505104 (x2) & 505108
660 mm	505104 (x2) & 505109
711 mm	505104 (x2) & 505110
762 mm	505106 (x2) & 505107
813 mm	505106 (x2) & 505108
864 mm	505106 (x2) & 505109
914 mm	505106 (x2) & 505110
965 mm	505104 (x4) & 505107
1016 mm	505104 (x4) & 505108
1067 mm	505104 (x4) & 505109
1118 mm	505104 (x4) & 505110
1168 mm	505105 (x4) & 505107
1219 mm	505105 (x4) & 505108
1270 mm	505105 (x4) & 505109
1321 mm	505105 (x4) & 505110
1372 mm	505106 (x4) & 505107
1422 mm	505106 (x4) & 505108
1473 mm	505106 (x4) & 505109
1524 mm	505106 (x4) & 505110

Service Parts

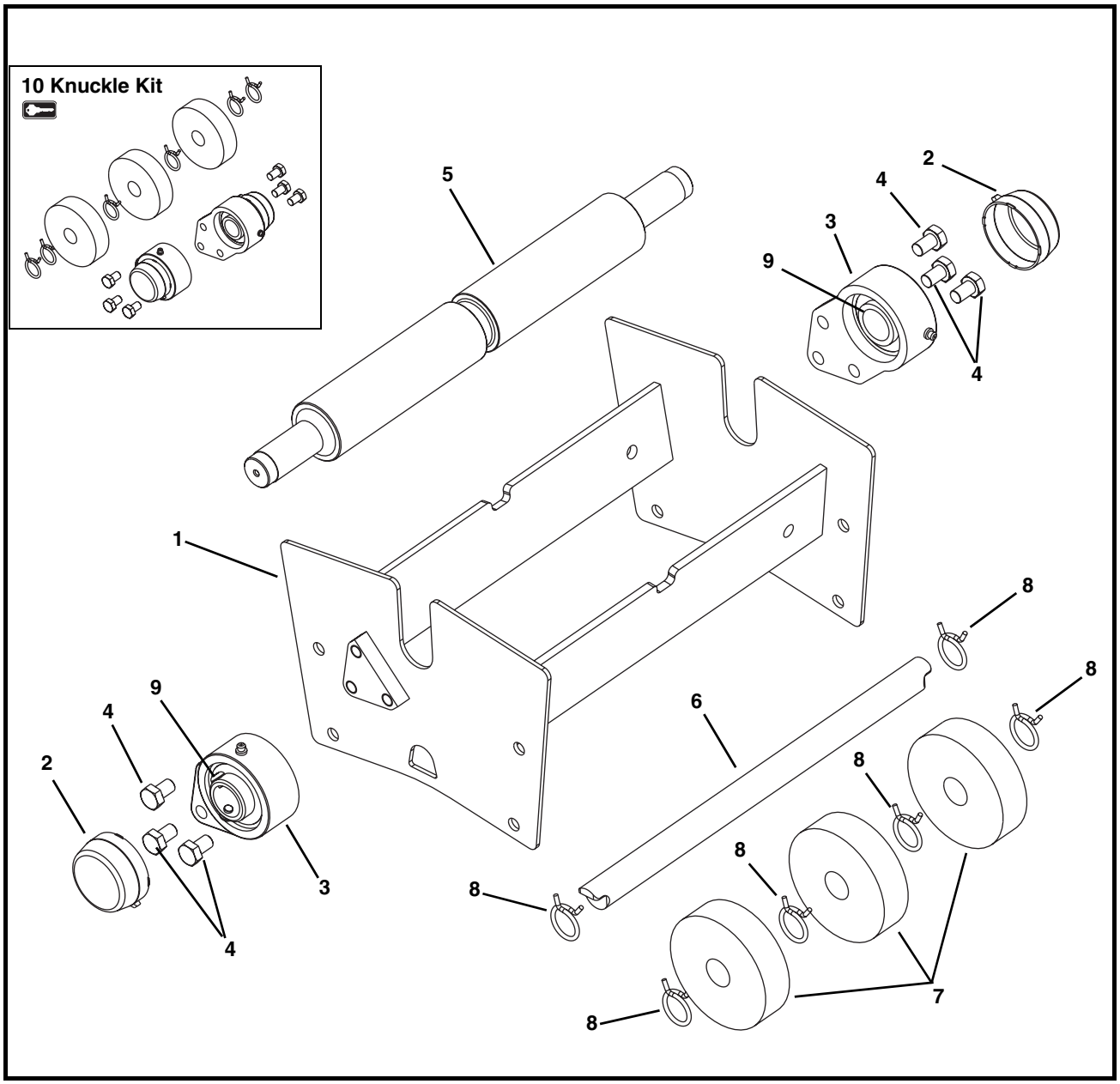
1.875" Nose Bar Idler End



Item	Part Number	Description
1	960520MSS	Hex Head Cap Screw M5-0.8 x 20 mm
2	501085	Transfer Bearing Cover
3	810-187	Grease Fitting
4	501083	1.875" Nose Bar Shaft Assembly Right Hand
5	500791	Nut
6	802-171	Bearing
7	501081	Pinch Guard block
8	5101WW	1.875" Nose Bar Spindle
9	501084	1.875" Nose Bar Shaft Assembly Left Hand

Item	Part Number	Description
10	500675	Key Stop
11	5048WW	Tip Up Shaft Assembly
12	76NB2-WW	1.875" Idler Spindle Kit (Includes Items 6 through 8)
13	76NBT2-WW	1.875" Idler Tail Kit (Includes Items 1 through 9)
14	76BK2-WW	Bearing Kit (Includes Item 6)
WW = Conveyor width ref: 06 - 60 in 02 increments		

Upper Knuckle for Flat Belt Conveyors

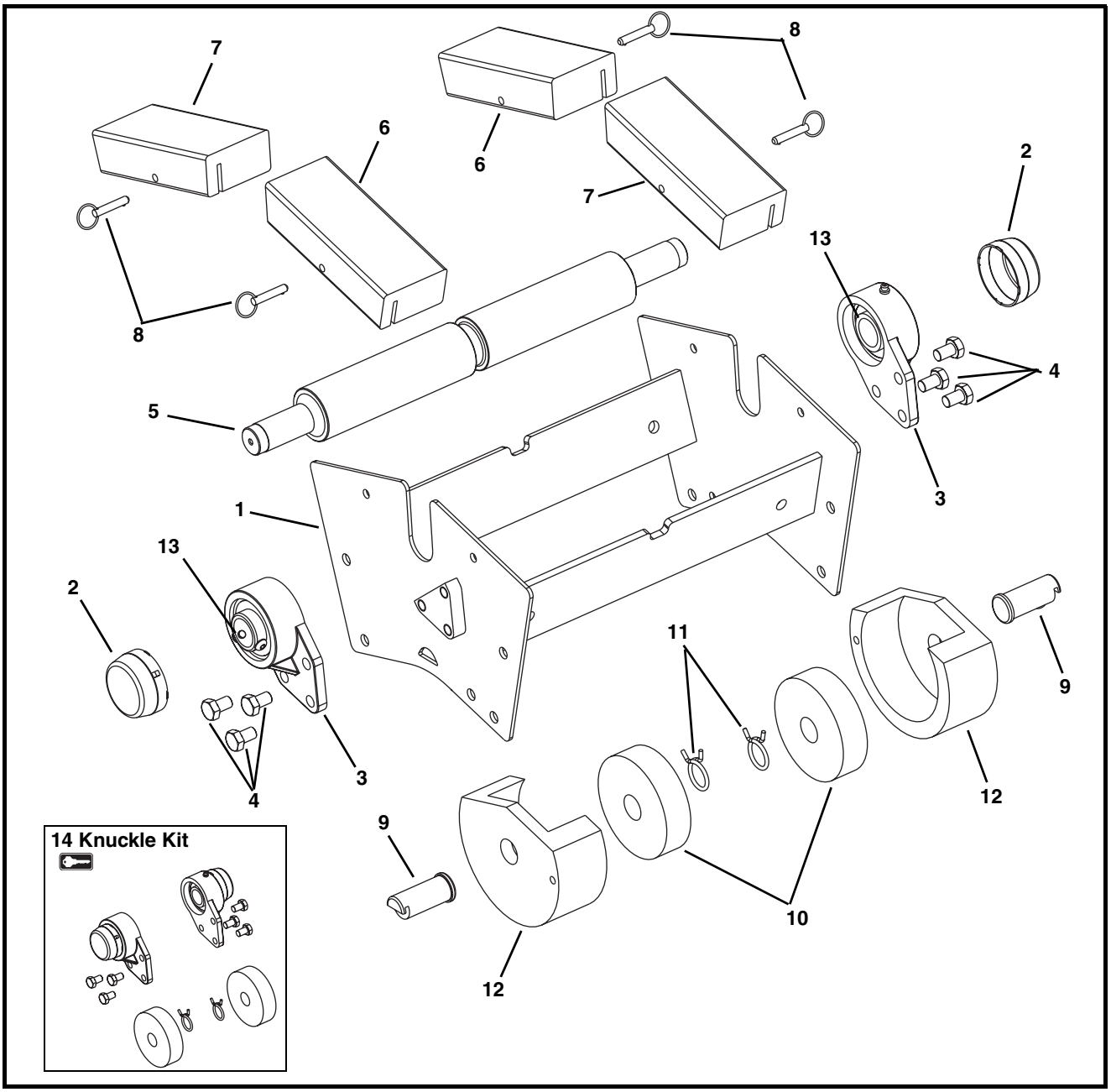


Item	Part Number	Description
1	5266WW	Frame Assembly for 5° Knuckle
	5267WW	Frame Assembly for 15° Knuckle
	5268WW	Frame Assembly for 30° Knuckle
2	807-1454	Bearing Cover
3	500288	3 Hole Flange with Bearing
4	961016MSS	Hex Head Cap Screw, M10-1.5 x 20 mm

Item	Part Number	Description
5	5244WW	Spindle
6	5108WW	Return Shaft
7	500990	Return Disk
8	807-1551	Clamp
9	802-162	Bearing
10	76UKBK-WW	Upper Knuckle Kit (Includes items 2, 3, 4, 7, and 8)
WW = Conveyor length ref: 06 - 24 in 02 increments		

Service Parts

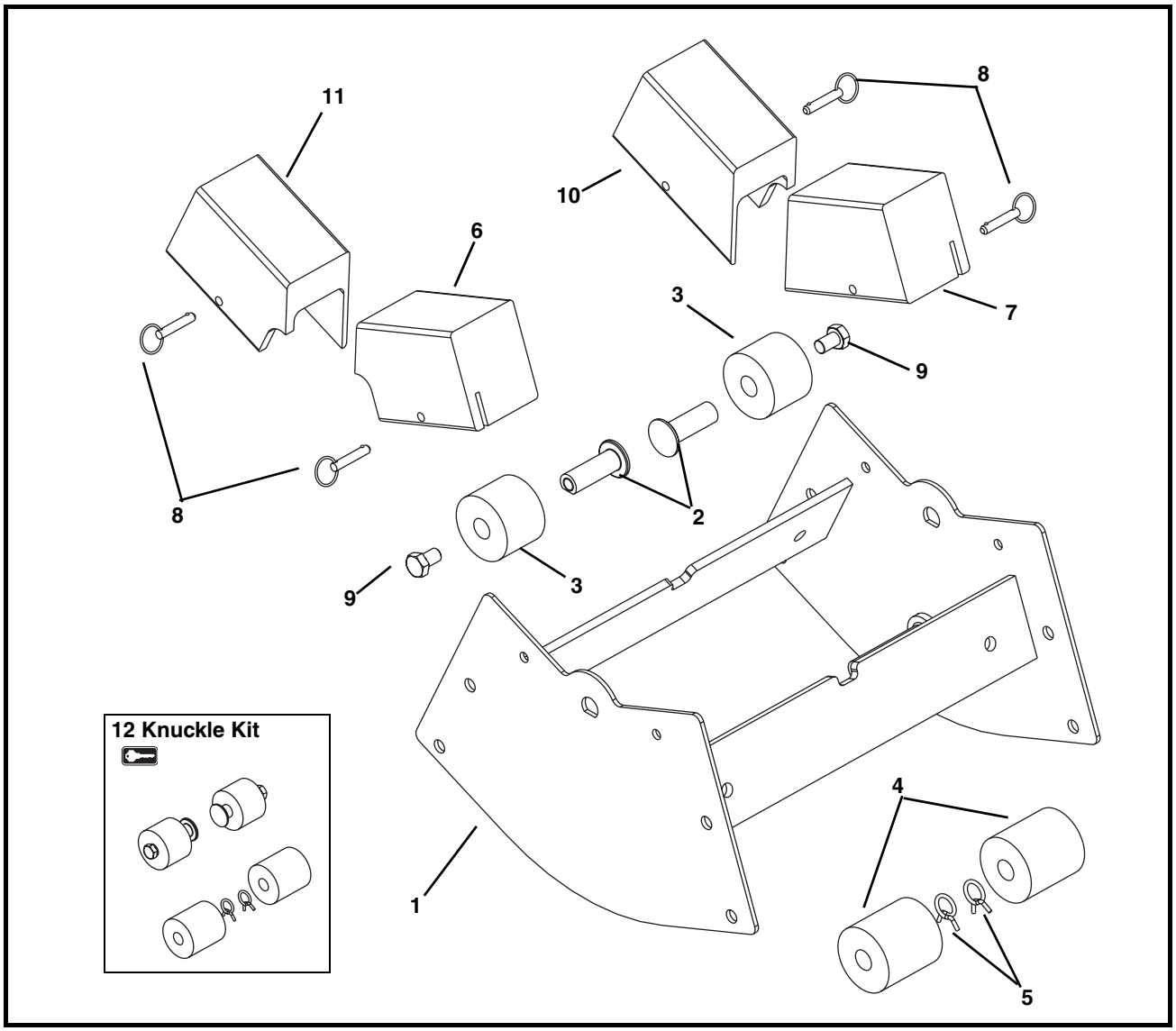
Upper Knuckle for Cleated Belt Conveyors



Item	Part Number	Description
1	5251WW	Frame Assembly for 30° Knuckle
	5252WW	Frame Assembly for 45° Knuckle
	5253WW	Frame Assembly for 60° Knuckle
2	807-1454	Bearing Cover
3	500288	3 Hole Flange with Bearing
4	961016MSS	Hex Head Cap Screw M10-1.5 x 20 mm
5	5244WW	Spindle
6	501788-AA	28 mm Hold Down Guide, for Knuckle Right Hand
	501787-AA	76 mm Hold Down Guide, for Knuckle Right Hand

Item	Part Number	Description
7	501978-AA	28 mm Hold Down Guide, for Knuckle Left Hand
	501977-AA	76 mm Hold Down Guide, for Knuckle Left Hand
8	807-1553	Pull Pin
9	501097	Return Shaft
10	500990	Return Disk
11	807-1551	Clamp
12	501896-AA	Return Guards
13	802-162	Bearing
14	76UKBK	Upper Knuckle Kit (Includes items 2, 3, 4, 10, and 11)
WW = Conveyor length ref: 06 - 24 in 02 increments		
AA = Angle 30, 45 or 60		

Lower Knuckle for Cleated Belt Conveyors

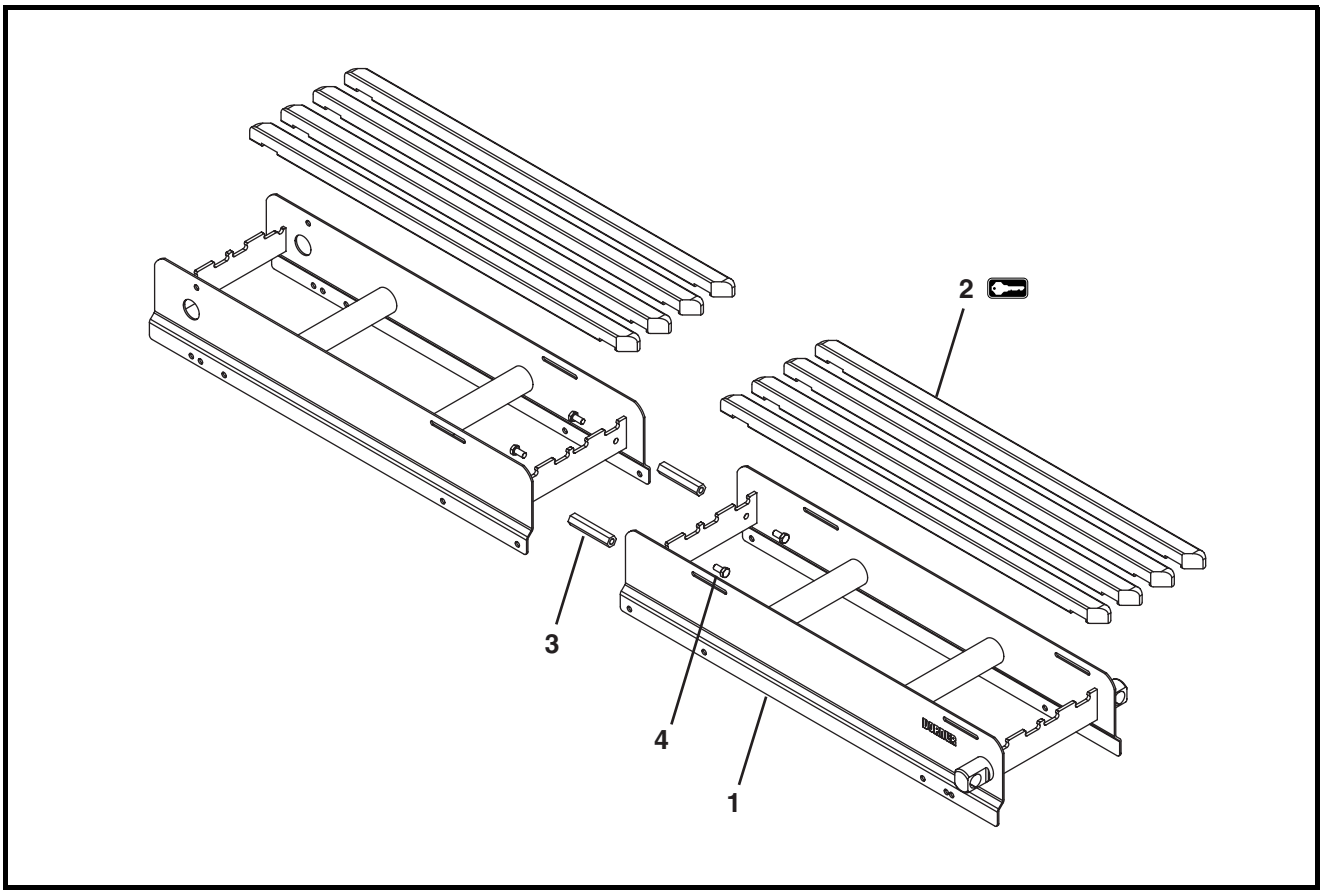


Item	Part Number	Description
1	5245WW	Frame Assembly for 30° Knuckle
	5246WW	Frame Assembly for 45° Knuckle
	5247WW	Frame Assembly for 60° Knuckle
2	501792	Hold Down Shaft
3	801-135	Hold Down Sleeve Bearing
4	801-136	Return Sleeve Bearing
5	807-1682	Clamp
6	501795-AA	Hold Down Guide for Knuckle Right Hand
7	501796-AA	Hold Down Guide for Knuckle Left Hand
8	807-1553	Pull Pin

Item	Part Number	Description
9	961016MSS	Hex Head Cap Screw, M10-1.5x16 mm
10	501795-AA	Hold Down Guide for Knuckle - Right Hand Cleated Belt Only
	501790-AA	Hold Down Guide for Knuckle - Right Hand Sidewall Cleated Belt Only
11	501796-AA	Hold Down Guide for Knuckle - Left Hand Cleated Belt Only
	501793-AA	Hold Down Guide for Knuckle- Left Hand Sidewall Cleated Belt Only
12	76LKBK	Lower Knuckle Kit (Includes items 2, 3, 4, 5, and 9)
WW = Conveyor length ref: 06 - 24 in 02 increments		
AA = Angle 30, 45 or 60		

Service Parts

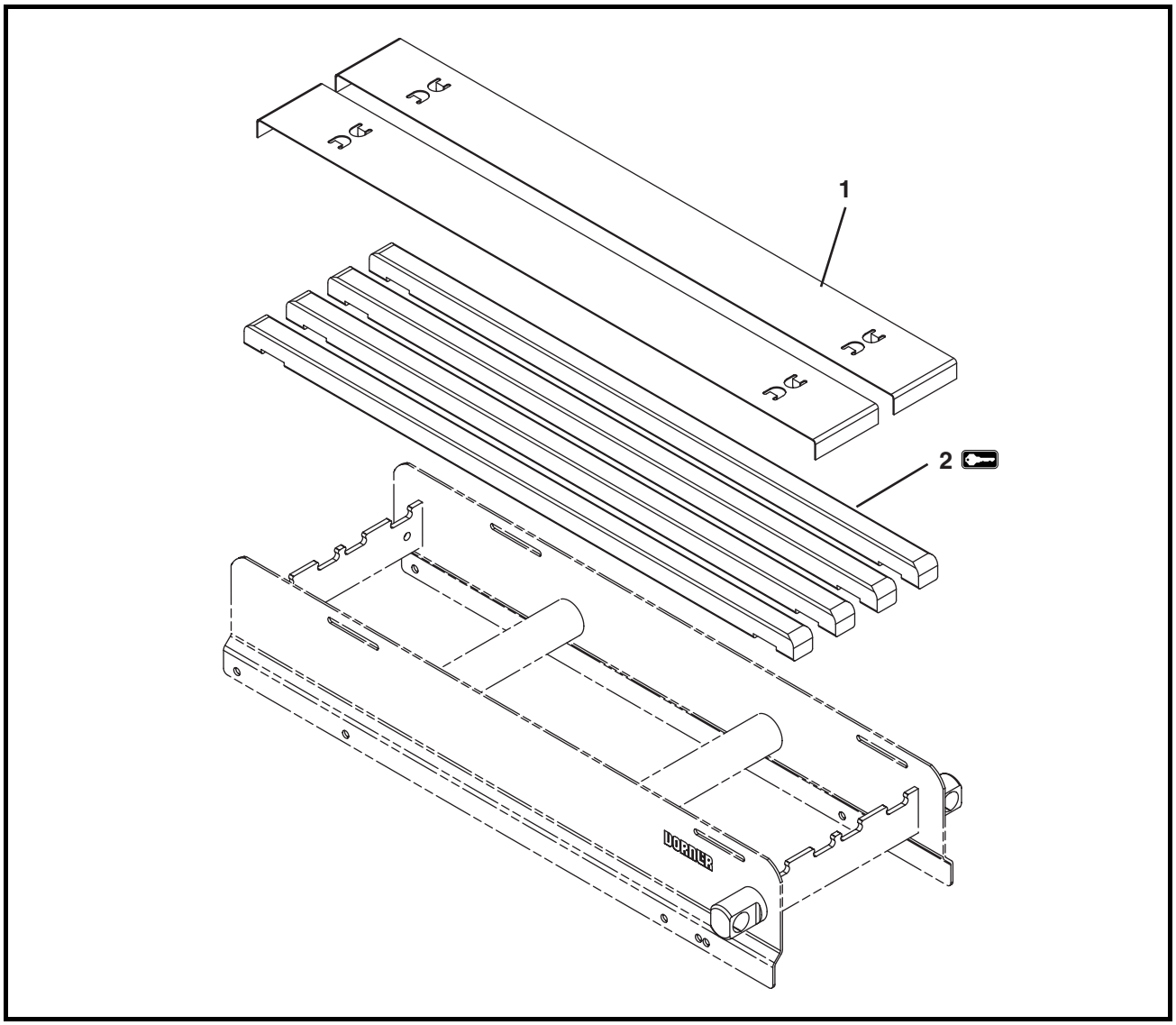
Conveyor Frame and Extensions with Standard Wear Strips



Item	Part Number	Description
1	------	Consult Factory for Frame Part Number
2	501800-LLL	Wear Strip

Item	Part Number	Description
3	500193	Hex Post Connector
4	961020MSS	Hex Head Cap Screw M10-1.5 x 20 mm
LLL = Conveyor length ref: 036 - 480 in 001 increments		

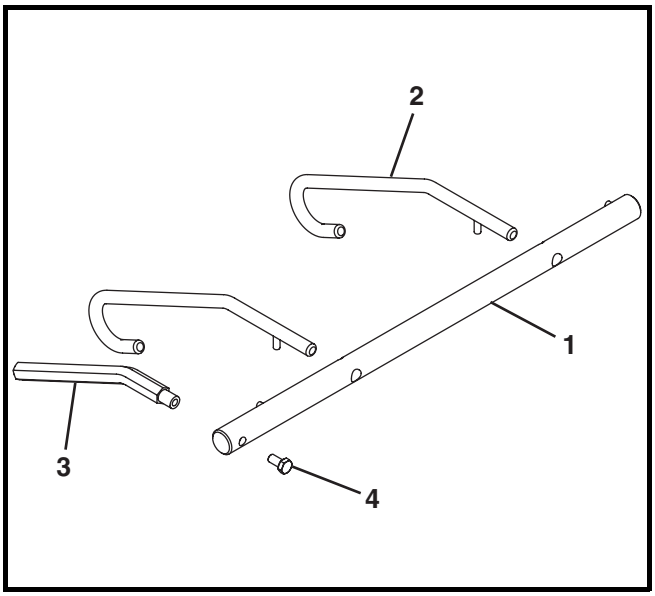
Wear Strips with Stainless Steel Sheet Bed Plate



Item	Part Number	Description
1	5123WW-LLL	Bed Plate
2	501098-LLL	Wear Strip
WW = Conveyor width ref: 06 - 60 in 02 increments		
LLL = Conveyor length ref: 036 - 480 in 001 increments		

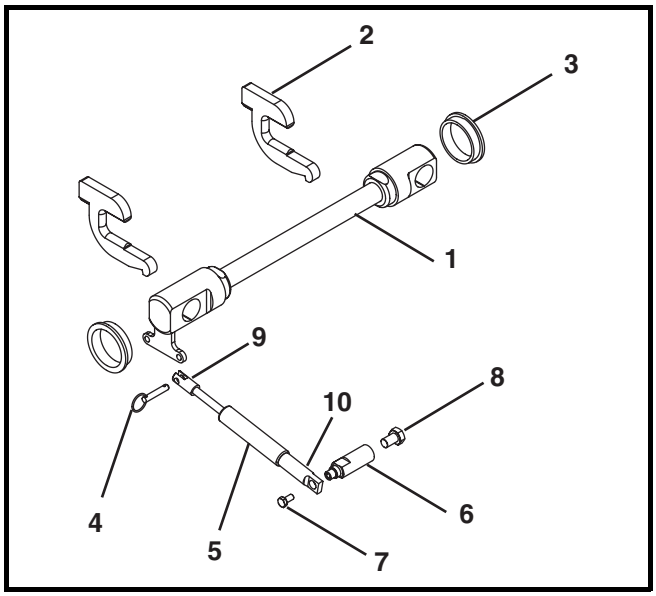
Service Parts

Lifters



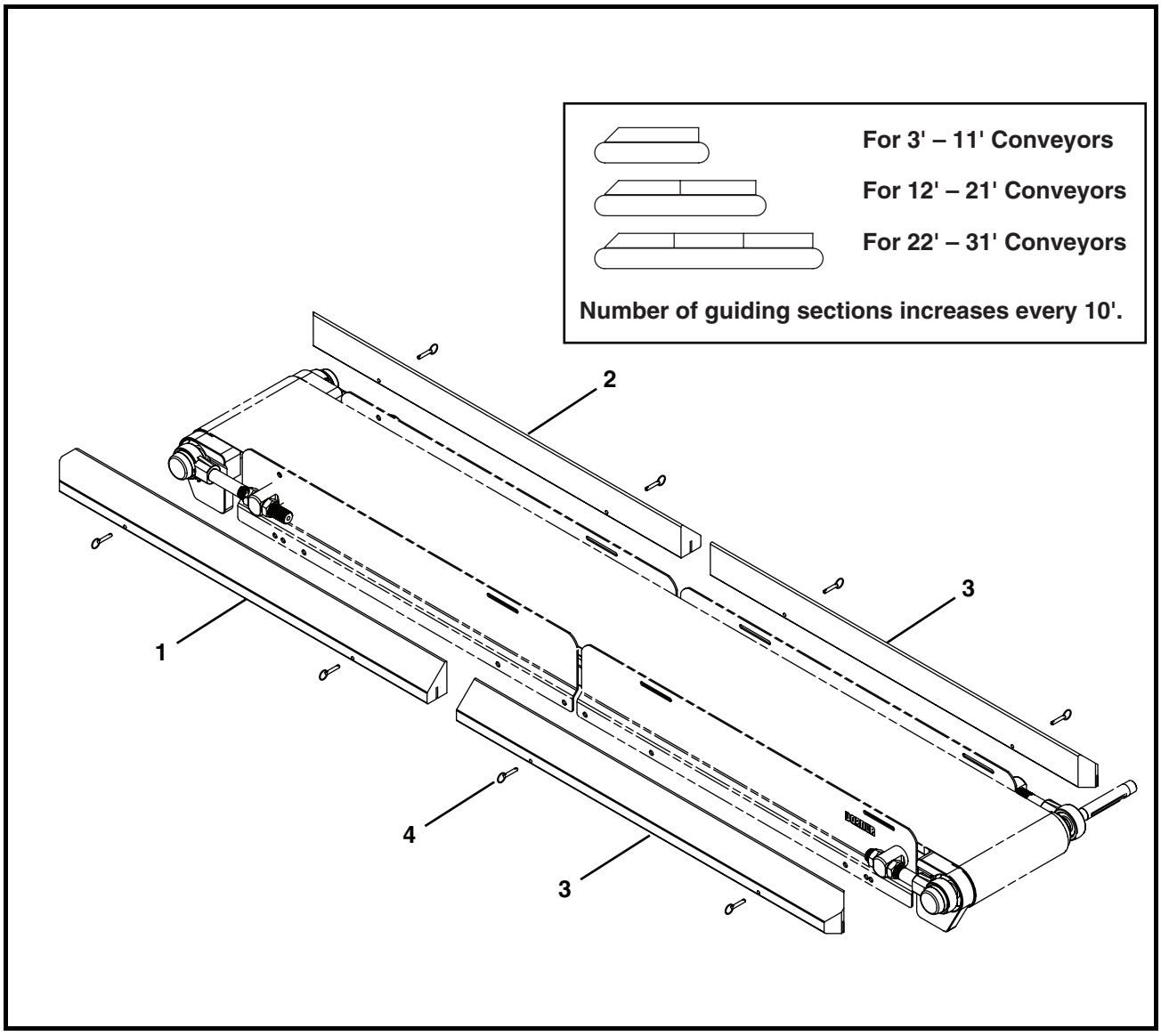
Item	Part Number	Description
1	5121WW	Belt Lifter Shaft
2	500195	Belt Lifter
3	500491	Belt Lifter Handle
4	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
WW = Conveyor width ref: 06 - 60 in 02 increments		

Gas Assisted Tip Up



Item	Part Number	Description
1	5049WW	Gas Assist Tip Up Shaft Assembly
2	500675	Key Stop
3	500895	Tip Up Bushing
4	807-1553	Pull Pin
5	807-1562	Gas Spring 70 lb., for Standard Tails 42"-60" wide or Nose Bar Tails 18"-30" wide
	807-1563	Gas Spring 130 lb., for Nose Bar Tails 32"-46" wide
	807-1564	Gas Spring 160 lb., for Nose Bar Tails 48"-60" wide
6	500794	Gas Spring Stand Off Post
7	960616MSS	Hex Head Cap Screw, M6-1.00 x 16 mm
8	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
9	500792	Gas Spring Clevis
10	500793	Gas Spring Eyelet
WW = Conveyor width ref: 06 - 60 in 02 increments		

3" High Sides

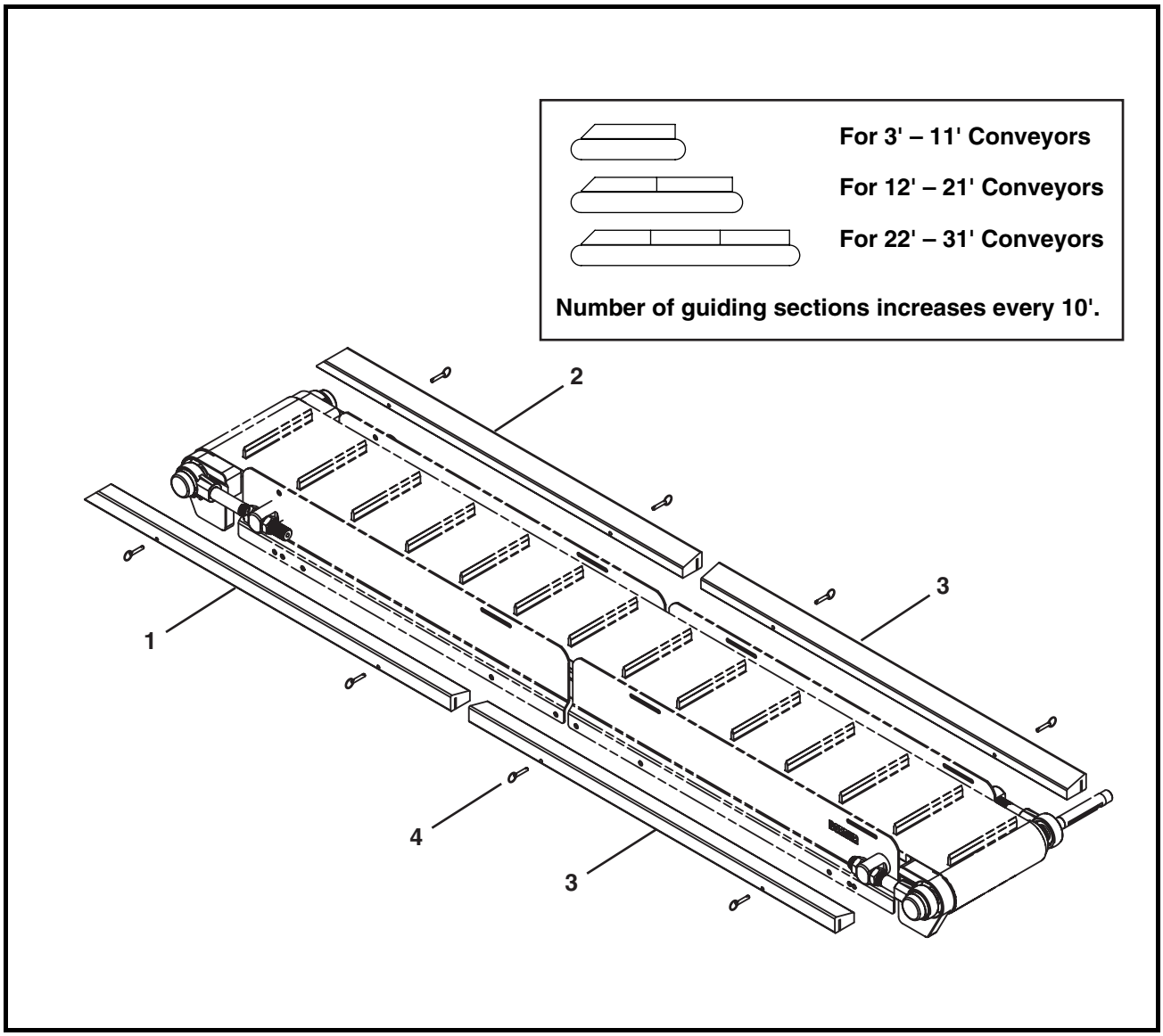


Item	Part Number	Description
1	503460-LLLLL	High Side Guide for Conveyors 3'-11' Long
	503550-LLLLL	High Side Right Hand Guide for Conveyors over 11' Long
2	503460-LLLLL	High Side Guide for Conveyors 3'-11' Long

Item	Part Number	Description
3	503650-LLLLL	High Side Right Hand Guide for Conveyors over 11' Long
	503450-LLLLL	High Side Guide Square End
4	807-1553	Pull Pin
LLLLL = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

Service Parts

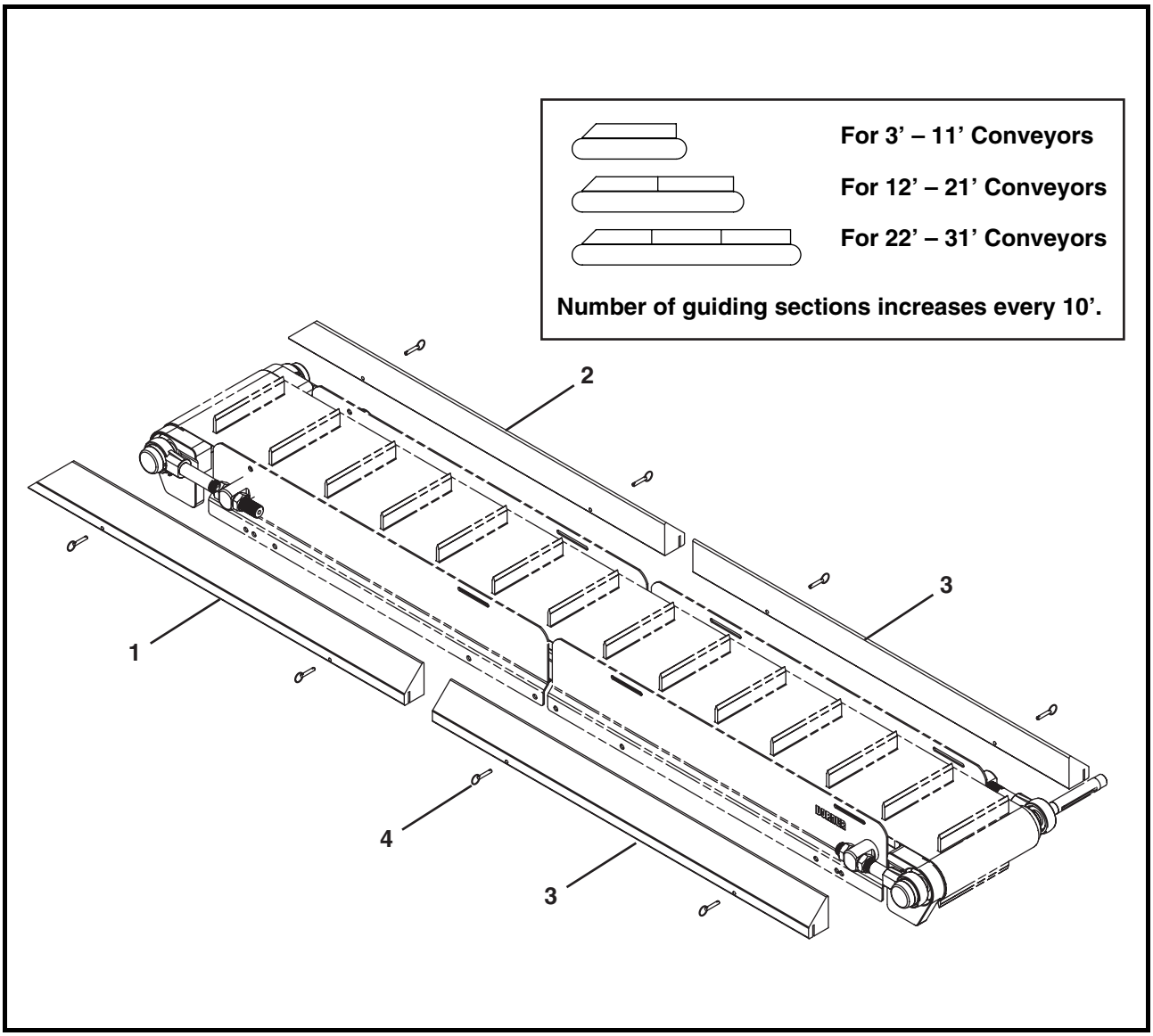
1" Cleated Guides



Item	Part Number	Description
1	502450-LLLLL	1" Cleated Right-hand Guide
2	502460-LLLLL	1" Cleated Left-hand Guide
3	502350-LLLLL	1" Cleated Guide Square End

Item	Part Number	Description
4	807-1553	Pull Pin
LLLLL = Guide Length in inches with two decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

3" Cleated Guides

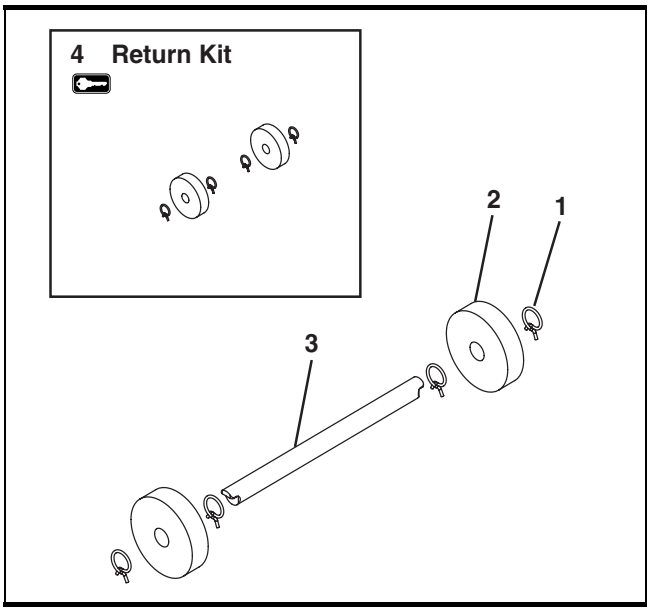


Item	Part Number	Description
1	502750-LLLLL	3" Cleated Right-hand Guide
2	502850-LLLLL	3" Cleated Left-hand Guide
3	502650-LLLLL	3" Cleated Guide Square End

Item	Part Number	Description
4	807-1553	Pull Pin
LLLLL = Guide Length in inches with two decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

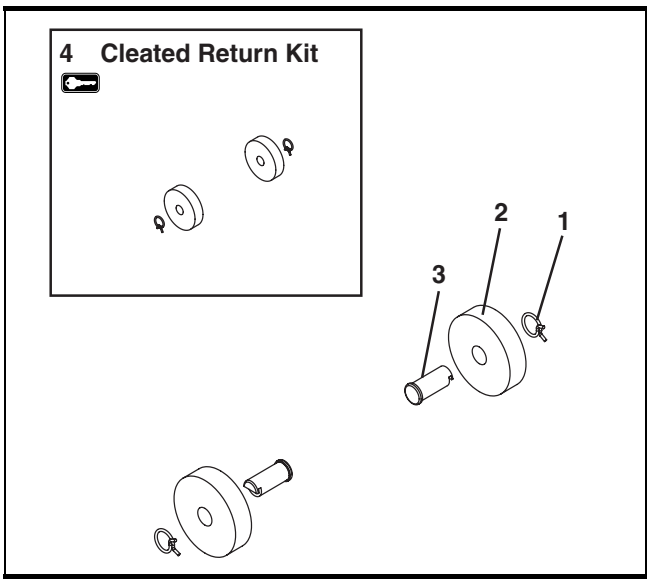
Service Parts

Flat Belt Returns



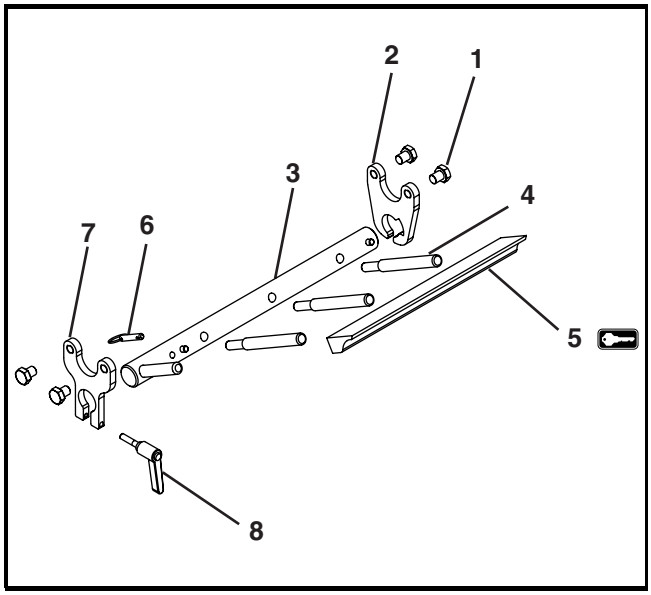
Item	Part Number	Description
1	807-1551	Clamp
2	500990	Return Disk
3	5108WW	Return Shaft
4	76R-WW	Return Kit (Includes Items 1 and 2)
WW = Conveyor width ref: 06 - 60 in 02 increments		

Cleated Belt Return



Item	Part Number	Description
1	807-1551	Clamp
2	500990	Return Disk
3	501097	Cleated Return Shaft
4	76CR	Cleated Return Kit (Includes Items 1 and 2)

Scraper



Item	Part Number	Description
1	961012MSS	Hex Head Cap Screw M10-1.50 x 12 mm
2	500878	Scraper Adjust Plate
3	5102WW	Scraper Shaft Assembly
4	500881	Scraper Holder Bar
5	5047WW	Scraper Wear Bar
6	807-1553	Pull Pin
7	500879	Scraper Mount Plate
8	807-1559	Handle
WW = Conveyor width ref: 06 - 60 in 02 increments		

Configuring Conveyor Belt Part Number

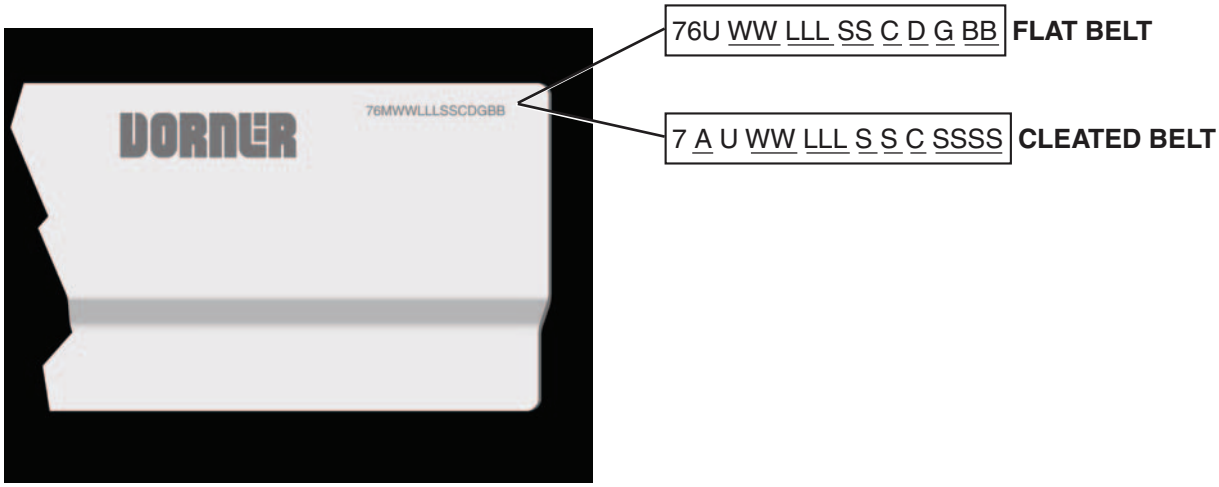


Figure 99

Flat Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 99)**. From the model number determine the conveyor width (WW), length (LLL), drive/tail types (A) and belt type (BB). Use data to configure belt part number as indicated below. *Add “V” for v-guided belts.

76-WW LLL A / BB V*

76-_____ / ___ V*

(Fill In)

Cleated Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 99)**. From the model number determine the conveyor width (WW), length (LLL), cleat type (C) and cleat spacing (SSSS). Use data to configure belt part number as indicated below. *Add “V” for v-guided belts.

76-WW LLL C SSSSS V*

76-__ ___ _ _____ 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.

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization number for reference.

There will be a return charge on all new undamaged items returned for credit where Dorner was not at fault. Dorner is not responsible for return freight on such items.

Conveyors and conveyor accessories	
Standard catalog conveyors	30%
MPB Series, cleated and specialty belt conveyors	50%
7400 & 7600 Series conveyors	non-returnable items
Engineered special products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

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

Returns will not be accepted after 60 days from original invoice date.

The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components to inventory.

If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Technical Sales, Catalog Sales and Service Teams will gladly help with your questions on Dorner products.

For a copy of Dorner's Warranty, contact factory, distributor, service center or visit our website at www.dorner.com.

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

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