7100 Series Conveyor

Installation, Maintenance & Parts Manual

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851-792 Rev. A

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IMPORTANT

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.

Dorner's Limited Warranty applies.

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 .

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

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

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

⚠ WARNING

Gearmotors may be HOT.

DO NOT TOUCH Gearmotors.

⚠ 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.

Refer to **Figure 1** for typical components.

1	Infeed Module
2	Curve Module
3	Drive Module
4	Gearmotor
5	Stands

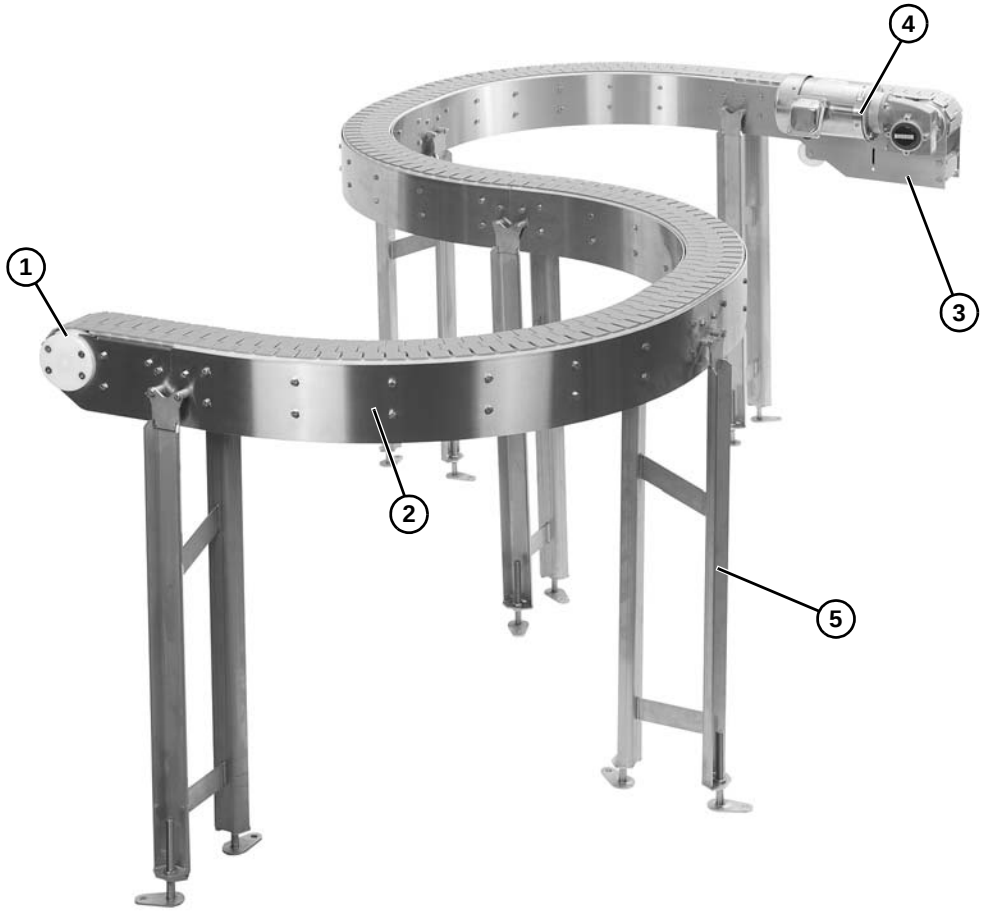
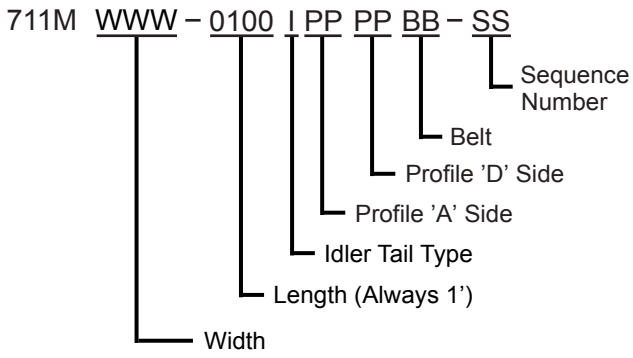


Figure 1

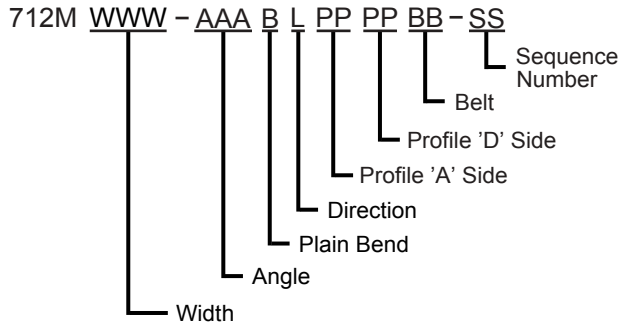
Specifications

Modules:

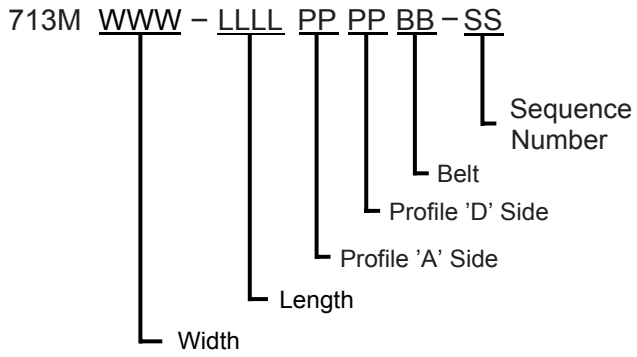
Idler Module



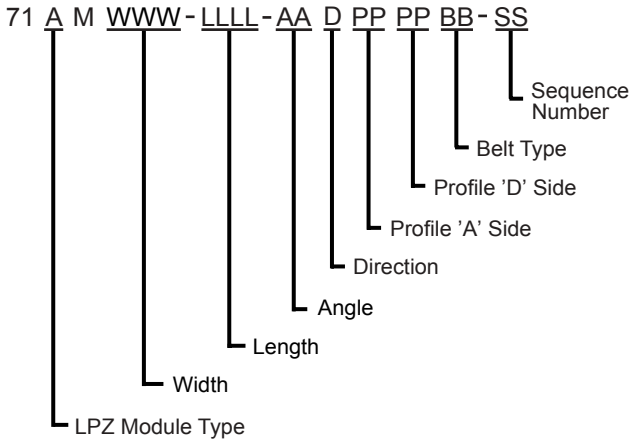
Curve Module



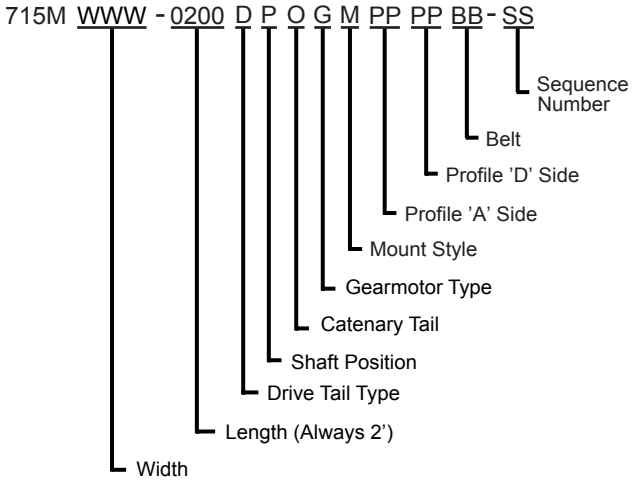
Intermediate Module



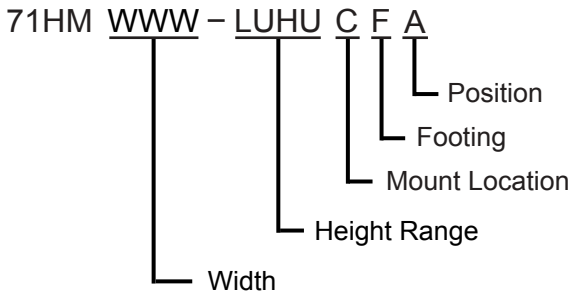
LPZ Module



Drive Module



Support Stands



Conveyor Supports:

Maximum Distances:

1 = 12" (305 mm)

2 = 10 ft (3048 mm)*

3 = 24" (610 mm) for conveyors longer than 6 ft

= 60" (1524 mm) for conveyors up to 6 ft

* For conveyors longer than 10 ft (3048 mm), install support at joint.

Note: Additional support required on 180° curve modules.

Note: Support stand must be located at drive module exit end.

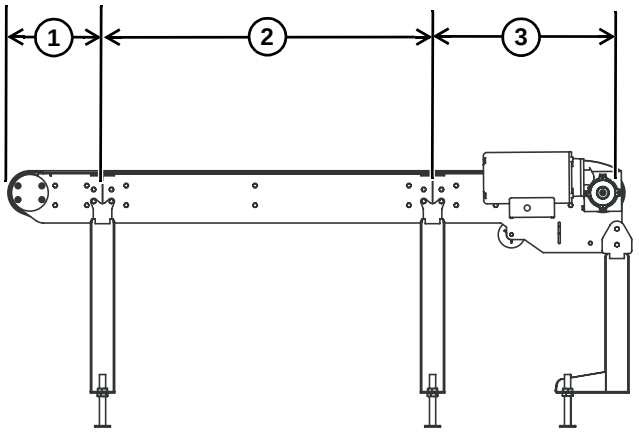


Figure 2

Specifications:

Conveyor Widths Reference (WW)	045	075	100	120
Conveyor Belt Width	4.50" (114 mm)	7.50" (191 mm)	10" (254 mm)	12" (350 mm)
Maximum Load	500 lb (227 kg)	600 lb (272 kg)	700 lb (318 kg)	700 lb (318 kg)
Maximum Belt Speed	250 RPM			
Belt Takeup	Catenary Sag			
Module Length Reference	0100 - 1000			
Module Length	1.00' (305 mm) - 10.00' (3,048 mm)			
Total Conveyor Length	99 ft (30,175 mm) maximum			

Table 1: Gearmotor Specifications

Item			
Output Power	0.5 hp (0.37 kW)	1 hp (0.74 kW)	1.5 hp (1.11 kW)
Input Voltage	230/460 VAC	208 – 230/460 VAC	208 – 230/460 VAC
Input Frequency	60Hz		
Gearmotor Ratios	10:1, 15:1, 20:1, 30:1, 40:1, 60:1		
Frame Size	NEMA 56C		
Motor Type	Totally Enclosed, Non-Ventilated (Except 1.0 hp & 1.5 hp Stainless Steel Gearmotor = Totally Enclosed, Fan Cooled)		

Specifications

Table 2: Belt Speed for Standard Load Fixed Speed Painted 90° Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed	
				Ft/min	M/min
71M060HS423FN	29	442	50	37	11
71M040HS423FN	44	486	55	56	17
71M030HS423FN	58	487	55	74	22
71M020HS423FN	87	407	46	110	33
71M015HS423FN	117	470	53	148	45
71M010HS423FN	175	442	50	222	68

Table 3: Belt Speeds for Standard Load Variable Speed Painted 90° Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed	
				Ft/min	M/min
71M060HS423EN	29	442	50	4-37	1-11
71M040HS423EN	44	486	55	6-56	2-17
71M030HS423EN	58	487	55	7-74	2-22
71M020HS423EN	87	407	46	11-110	3-33
71M015HS423EN	117	470	53	15-148	5-45
71M010HS423EN	175	442	50	22-222	7-68

Table 4: Belt Speeds for Standard Load Fixed Speed Stainless Steel 90° Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed	
				Ft/min	M/min
71M060HZS423FN	29	442	50	37	11
71M040HZS423FN	44	486	55	56	17
71M030HZS423FN	58	487	55	74	22
71M020HZS423FN	87	407	46	110	33
71M015HZS423FN	117	470	53	148	45
71M010HZS423FN	175	442	50	222	68

Table 5: Belt Speeds for Standard Load Variable Speed Stainless Steel 90° VFD Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed	
				Ft/min	M/min
71M060HZS423EN	29	442	50	4-37	1-11
71M040HZS423EN	44	486	55	6-56	2-17
71M030HZS423EN	58	487	55	7-74	2-22
71M020HZS423EN	87	407	46	11-110	3-33
71M015HZS423EN	117	470	53	15-148	5-45
71M010HZS423EN	175	442	50	22-222	7-68

⚠ CAUTION

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

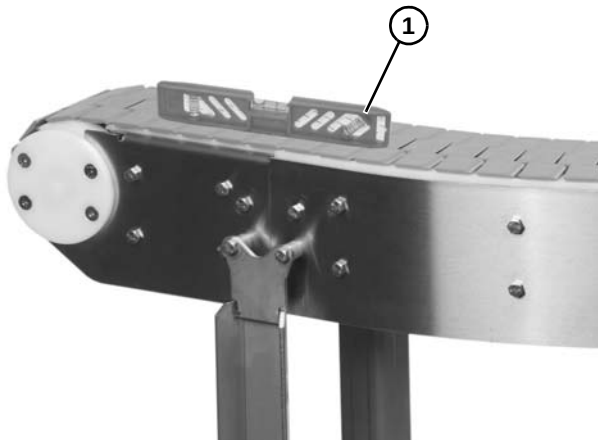


Figure 3

Required Tools

- Adjustable Wrench
- Flat Blade Screw Driver
- Hammer
- Punch
- 5 mm hex wrench
- 8 mm hex wrench
- 7 mm wrench
- 10 mm wrench
- 13 mm wrench
- 14 mm wrench
- 16 mm wrench
- 17 mm wrench
- Belt Removal Tool #514698

Recommended Installation Sequence

- Locate and arrange sections by section labels:
- Assemble conveyor (Module lengths longer than 10 ft. (3048 mm)
- Install knuckles
- Install curves
- Install tails
- Install wear strips
- Install support stands
- Install belt
- Install guiding
- Install drive package
  - Motor mounting package
  - Gearmotor

Module Lengths Longer Than 10 ft (3048 mm)

Connecting Components

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

1	Connecting Plate (x2)
2	Screws
3	Conveyor Frames

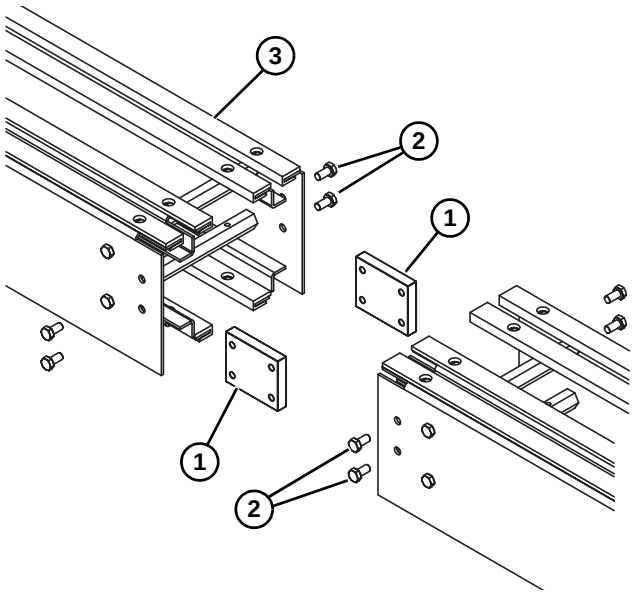


Figure 4

1. Locate and arrange conveyor sections by section labels.
2. Join both conveyor sections, and install connector plates **(Figure 4, item 1)**, and secure with screws **(Figure 4, item 2)** on both sides.

Installation

Knuckles

NOTE
*Be sure all frame sections **(Figure 5, item 2)** are properly supported during knuckle assembly.*

1. Join knuckle conveyor frame section **(Figure 5, item 1)** and conveyor frame **(Figure 5, item 2)**, and secure with four screws **(Figure 5, item 3)** and connecting plate **(Figure 5, item 4)** on both sides. Tighten screws.

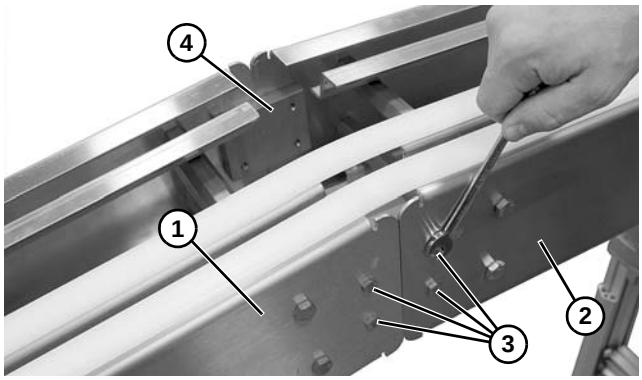


Figure 5

Curves

NOTE
*Be sure all frame sections **(Figure 6, item 1)** are properly supported during assembly.*

Typical Curve Connecting Components **(Figure 6)**.

1	Curve Section
2	Connector Plate (x2)
3	Hex Head Cap Screw

1. Join both conveyor sections **(Figure 6, item 1)** and secure with screws **(Figure 6, item 2)** and connecting plate **(Figure 6, item 3)** on both sides. Tighten screws.

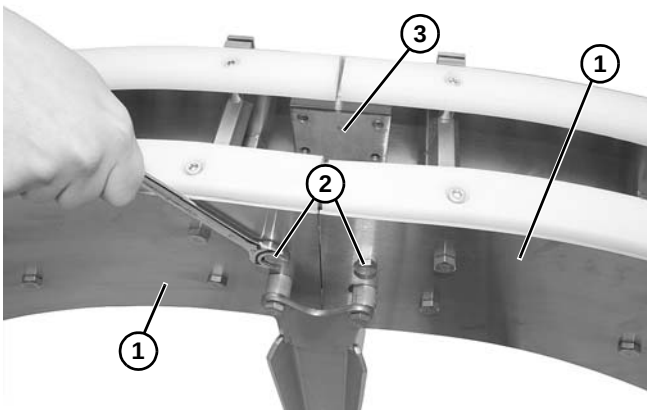


Figure 6

Tails

NOTE

Be sure conveyor section and tail assembly are properly supported during assembly.

1. Join conveyor section **(Figure 7, item 1)** and tail assembly **(Figure 7, item 2)** and secure with two screws **(Figure 7, item 3)** and connecting plate **(Figure 7, item 4)** on both sides. Tighten screws.

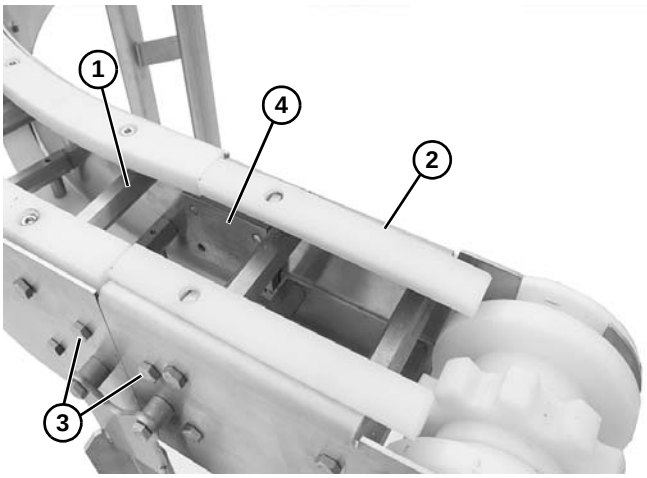


Figure 7

Install Support Stands

NOTE

For detailed assembly instructions, please see your appropriate support stand manual.

1. Install support stand **(Figure 8, item 1)** to conveyor with spacers **(Figure 8, item 2)** and mounting screws **(Figure 8, item 3)**. Stands are typically installed at frame breaks.

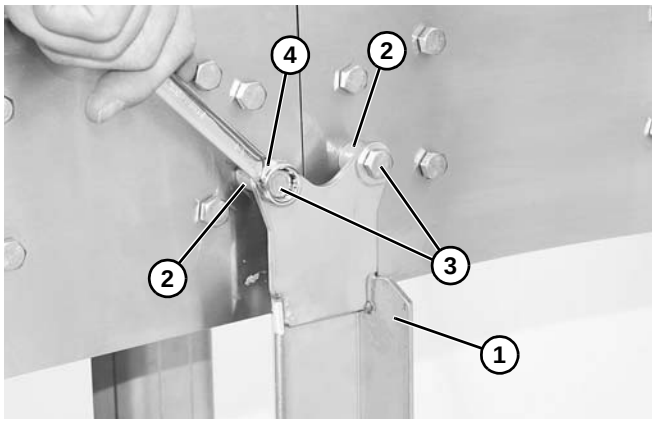


Figure 8

2. Tighten mounting screws with wrench **(Figure 8, item 4)**.

Belt Installation

Typical Belt Components **(Figure 9)**.

1	Chain Belt
2	Belt Rod

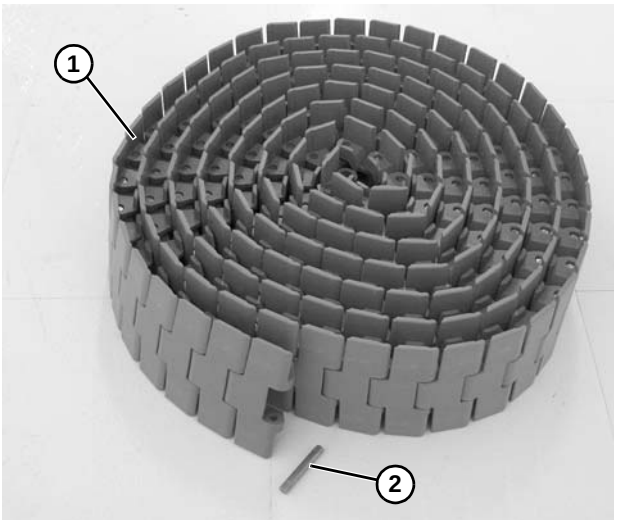


Figure 9

1. Install the belt with direction arrow pointing in direction of belt travel.

2. Install belt **(Figure 10, item 1)** into conveyor under idler pulley assembly **(Figure 10, item 2)**.

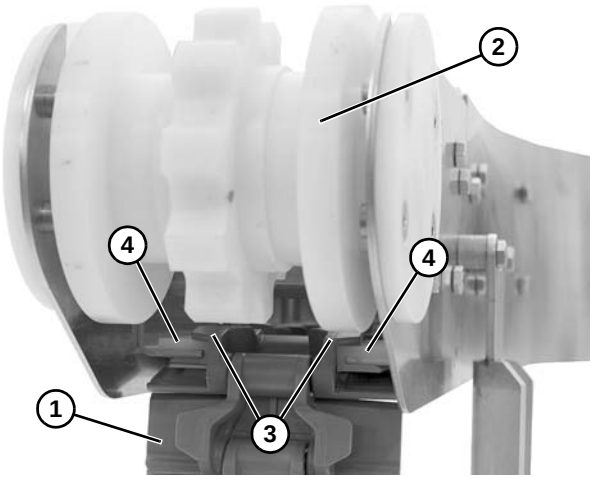


Figure 10

3. Continue feeding belt in toward drive end, making sure that the tabs **(Figure 10, item 3)** ride along the top of the wear strips **(Figure 10, item 4)**.
4. Wrap belt from under tail end **(Figure 11, item 1)** and onto cogs **(Figure 11, item 2)** of sprocket.

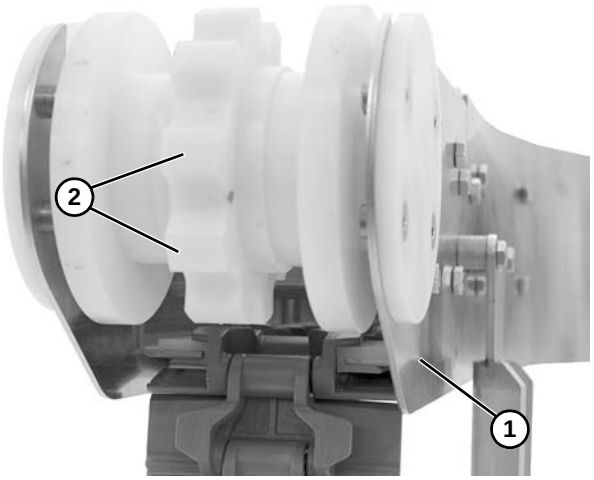


Figure 11

5. Continue wrapping belt on top of idler pulley, making sure that the belt tabs **(Figure 10, item 3)** are installed under the wear strips **(Figure 12, item 1)**.

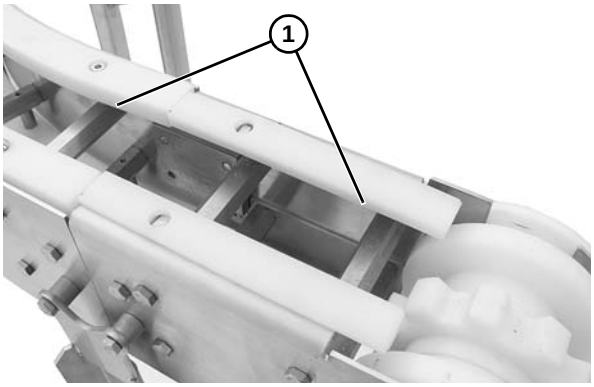


Figure 12

6. Continue to feed belt toward drive end.
7. From underneath conveyor, on the drive side, feed belt over the top of the return rollers **(Figure 13, item 1)**. Make sure that the belt tabs **(Figure 13, item 2)** are riding on top of the wear strips **(Figure 13, item 3)**.

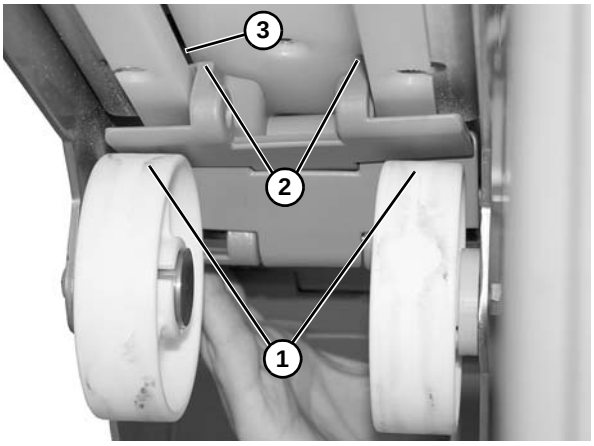


Figure 13

8. Insert the belt rod:
   a. Install belt around drive end **(Figure 14, item 1)** of conveyor and bring the ends of the belt together.

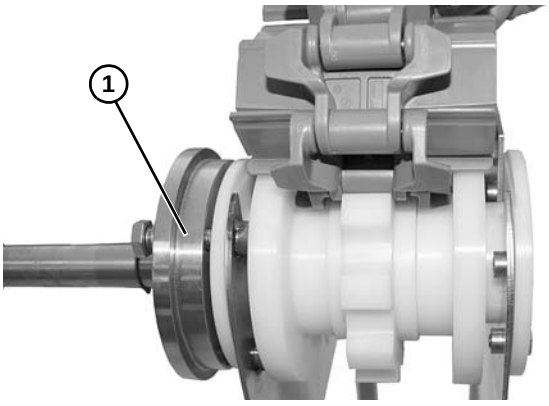


Figure 14

b. Insert rod.

NOTE

*Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area **(Figure 15, item 1)** on conveyor drive end.*

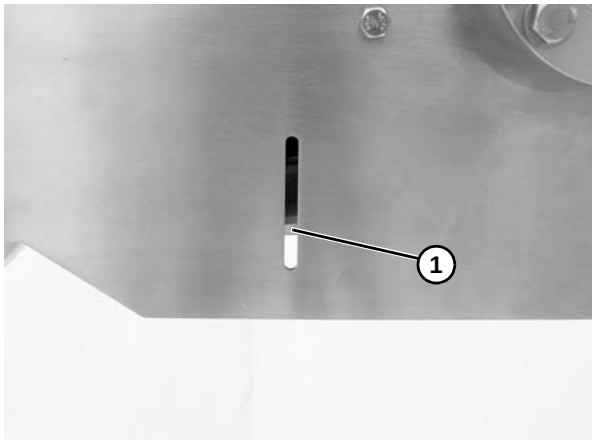


Figure 15

c. Use a punch and hammer **(Figure 16, item 1)** or belt removal tool #514698 to press pin **(Figure 16, item 2)** just below flush with side of belt **(Figure 16, item 3)**. Stop when pin detent is felt.

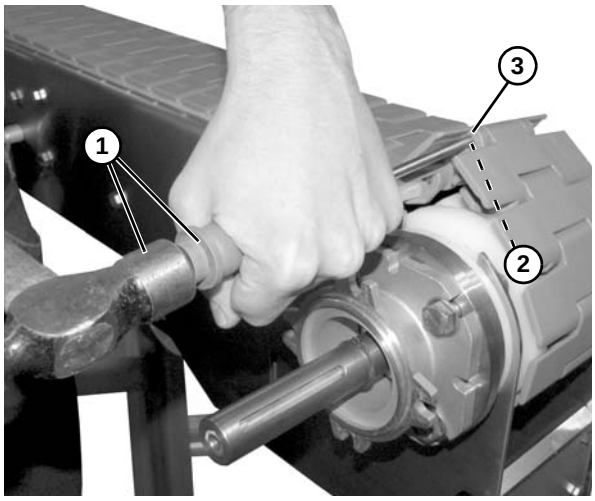


Figure 16

Install Drive Package

NOTE

For detailed assembly instructions, refer to the appropriate Drive Packages Installation, Maintenance and Parts Manual.

Side Drive

1. Install shaft keys onto drive shaft.
2. Attach the motor **(Figure 17, item 1)** and adapter **(Figure 17, item 2)** onto the drive shaft.

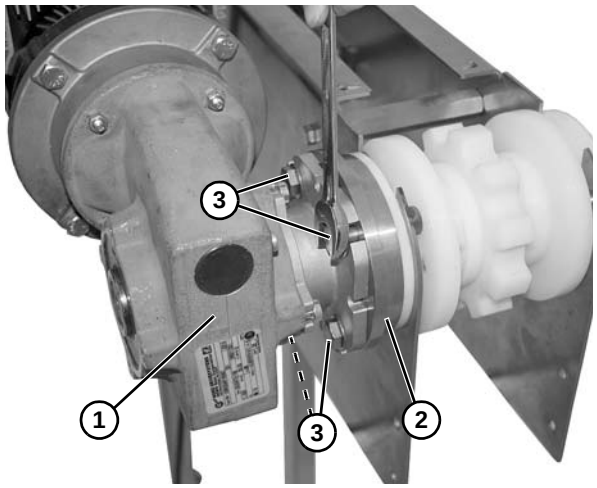


Figure 17

3. Install four bolts and washers **(Figure 17, item 3)** to secure motor to conveyor.
4. Install drive shaft clamp washer **(Figure 18, item 1)** and flat head screw **(Figure 18, item 1)** onto the drive shaft. Tighten flat head screw.

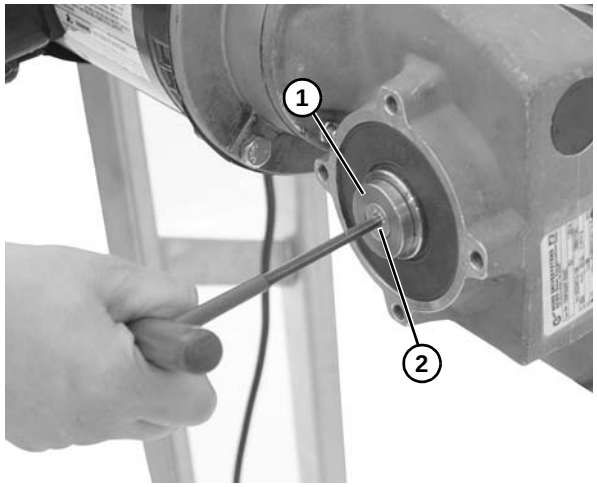


Figure 18

5. Install end cover **(Figure 19, item 1)** to the drive motor with four socket head screws **(Figure 19, item 2)**.

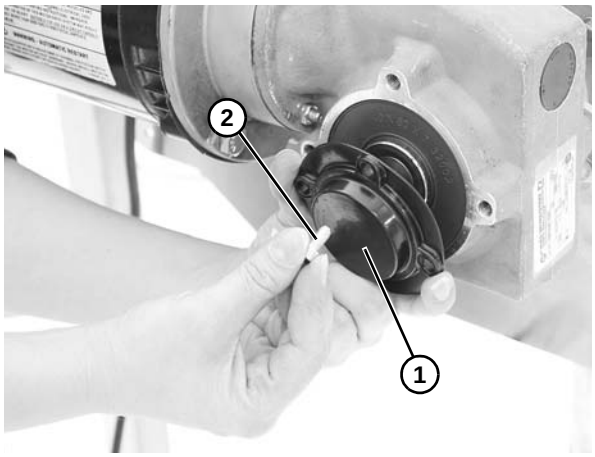


Figure 19

Bottom Drive

1. Attach the motor **(Figure 20, item 1)** to the bottom mount plate **(Figure 20, item 2)** with four screws **(Figure 20, item 3)**.

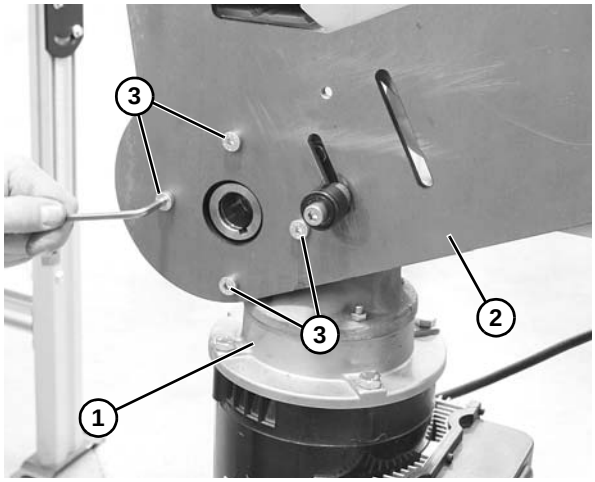


Figure 20

Install Guiding

All guiding must be located and installed by the end user.

High Side Guiding

1. Remove existing screw **(Figure 21, item 1)**. Install guide clip **(Figure 21, item 2)** onto conveyor with bottom of bracket **(Figure 21, item 3)** over screw head.

Figure 21

2. Install screw **(Figure 21, item 1)** and tighten.
3. Install guide **(Figure 22, item 1)** into slot **(Figure 22, item 2)** between conveyor and bracket.

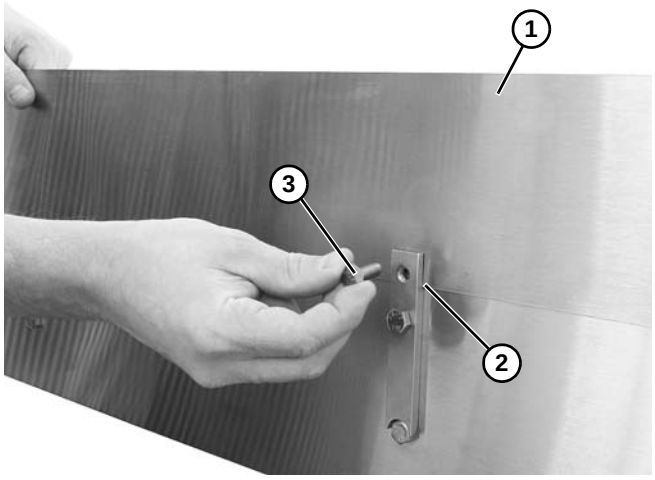


Figure 22

4. Secure guide with screw **(Figure 22, item 3)**.

Fully Adjustable Guiding

1. Install carriage bolts with spacers **(Figure 23, item 1)** into slotted holes in conveyor side.

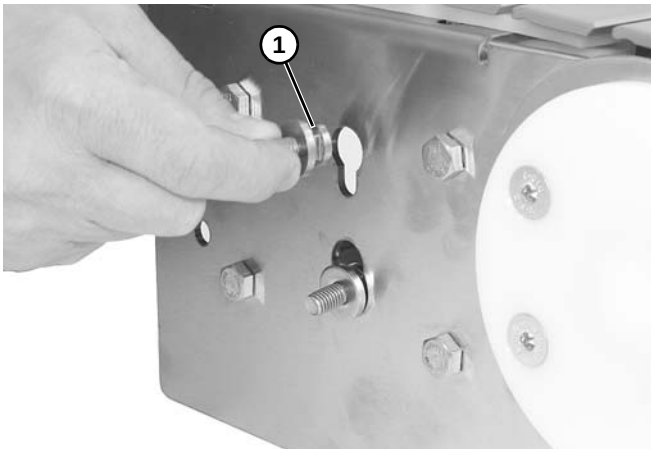


Figure 23

2. Attach the offset guide posts **(Figure 24, item 1)** to the conveyor with hex nuts **(Figure 24, item 2)**. Hand tighten only at this time.

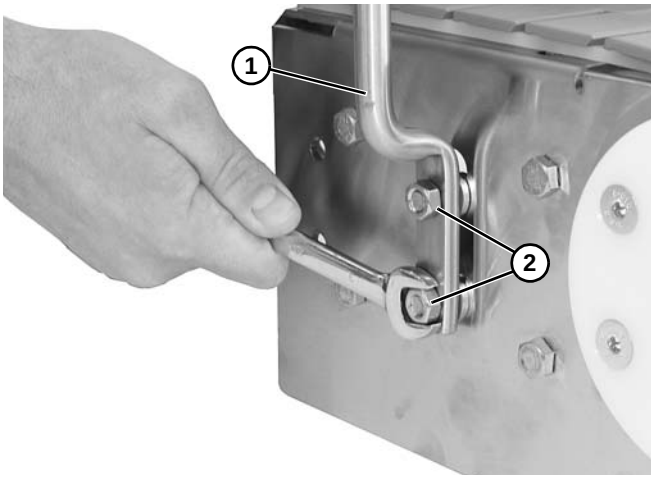


Figure 24

3. Attach rail clamps **(Figure 25, item 1)** to post guide **(Figure 25, item 2)** with hex head screw **(Figure 25, item 3)**. Hand tighten only at this time.

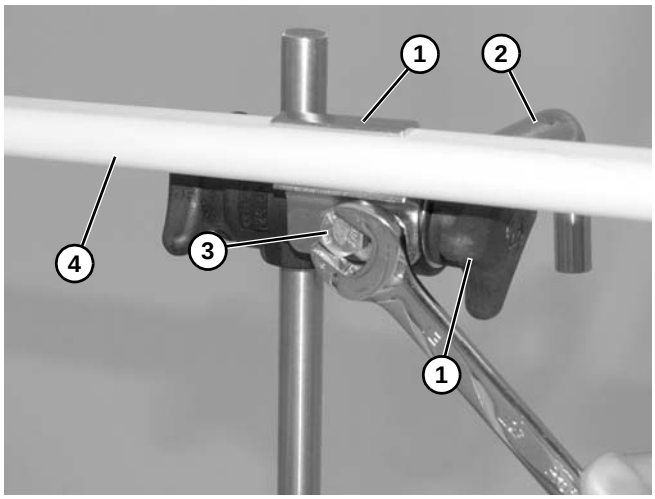


Figure 25

4. Insert guide **(Figure 25, item 4)** into the rail clamps **(Figure 25, item 1)**.
5. Tighten all mounting hardware.
6. Loosen hand clamps **(Figure 26, item 1)** or socket head screws to adjust guiding up/down **(Figure 26, item 2)** or in/out **(Figure 26, item 3)**. Tighten.

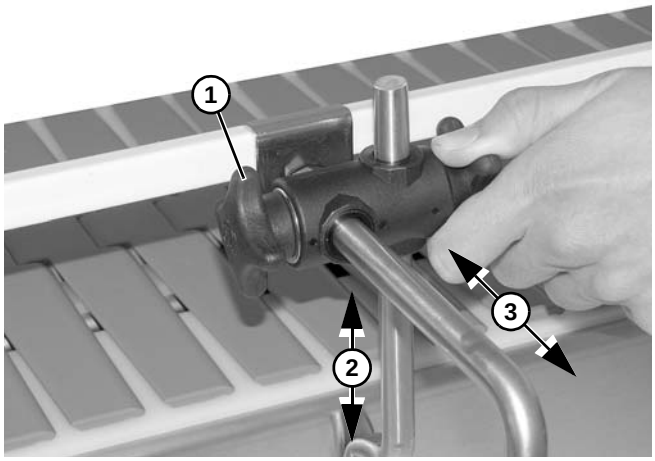


Figure 26

Preventive Maintenance and Adjustment

Required Tools

- Adjustable Wrench
- Flat Blade Screw Driver
- Hammer
- Punch
- 5 mm hex wrench
- 8 mm hex wrench
- 7 mm wrench
- 10 mm wrench
- 13 mm wrench
- 14 mm wrench
- 16 mm wrench
- 17 mm wrench
- Belt Removal Tool #514698
- 1/2" Drill

Checklist

- Replace any worn or damaged parts.

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

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

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

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

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

Skipping indicates:

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

Conveyor Belt Replacement

⚠ WARNING

SEVERE HAZARD!

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

Replacing a Section of Belt

1. Use a punch and hammer **(Figure 27, item 1)** or belt removal tool #514698 to push the belt rod **(Figure 27, item 2)** out by striking the rod end.

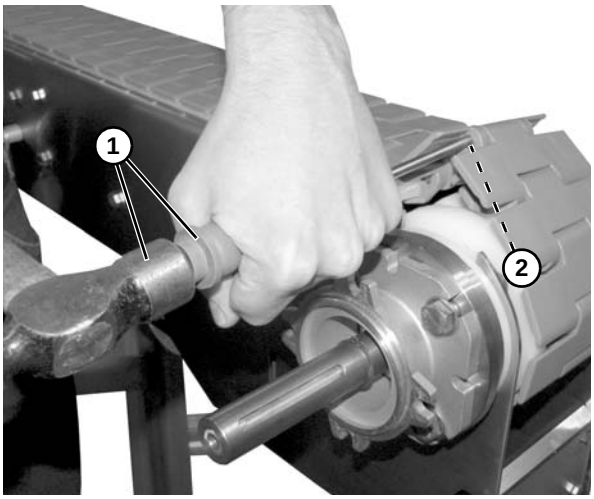


Figure 27

⚠ WARNING

SEVERE HAZARD!

If conveyor belt is damaged or worn, replace belt section.

2. Remove the belt rods on both sides of the section of belt being replaced.

3. Replace old section of belt.

⚠ CAUTION

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

NOTE

*Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area **(Figure 28, item 1)** on convey or drive end.*

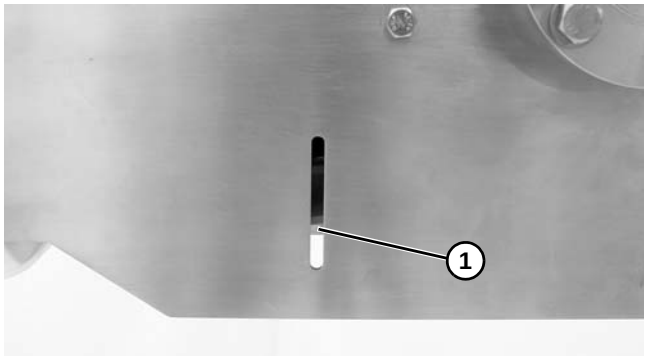


Figure 28

Replacing the Entire Belt

1. Use a punch and hammer **(Figure 29, item 1)** or belt removal tool #514698 to push the belt rod **(Figure 29, item 2)** out by striking the rod end.

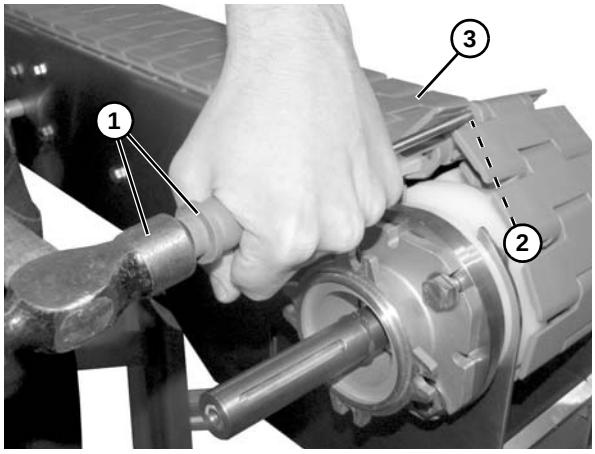


Figure 29

2. Slide the old belt **(Figure 29, item 3)** off the conveyor frame.
3. Replace the old belt with a new one. Refer to "Belt Installation" on page 11.

⚠ CAUTION

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

Conveyor Belt Tensioning

⚠ WARNING

SEVERE HAZARD!

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

NOTE

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

1. If chain slack hangs below slotted sight gauge **(Figure 30, item 1),** 1 or 2 links may need to be removed. Refer to "Replacing a Section of Belt" on page 16.

NOTE

*Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area **(Figure 30, item 1)** on conveyor drive end.*

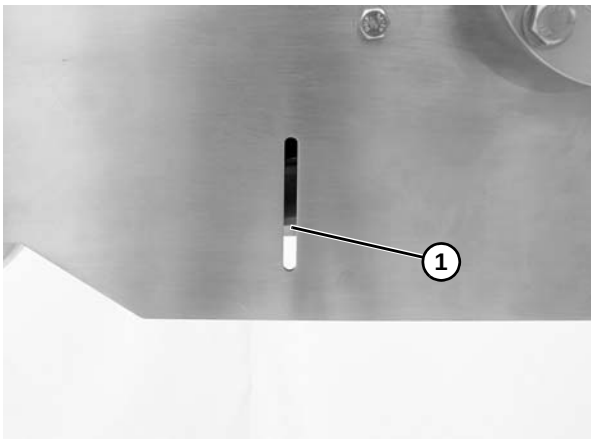


Figure 30

Removing Wear Strips on Curves

Replace the wear strips if they become worn.

1. Remove conveyor belt. See "Replacing the Entire Belt" on page 17.
2. **U**sing an allen wrench **(Figure 31, item 1)**, remove all socket head screws **(Figure 31, item 2)**. Remove upper wear strips **(Figure 31, item 3)**.

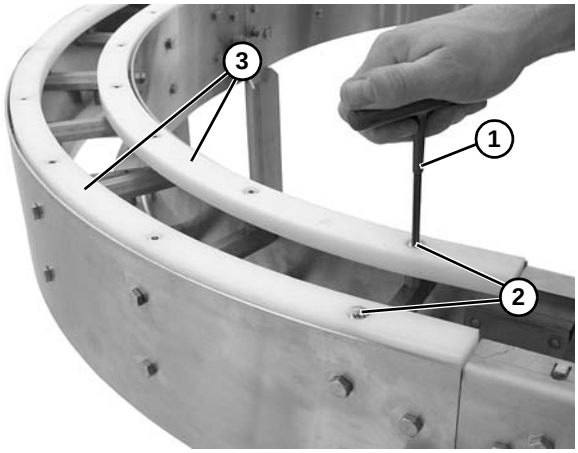


Figure 31

3. Remove lower wear strips, as needed; repeat procedure used for upper wear strips.
4. Install new wear strips.

Removing Wear Strips on Straight Sections

1. Remove conveyor belt. See "Replacing the Entire Belt" on page 17.
2. The wear strips **(Figure 32, item 1)** can be removed in two ways: Use a flat blade screw driver **(Figure 32, item 2)** to pry wear strip up and over tab **(Figure 32, item 3)** on rail **or** use a punch and hammer to flatten tab and remove wear strip.

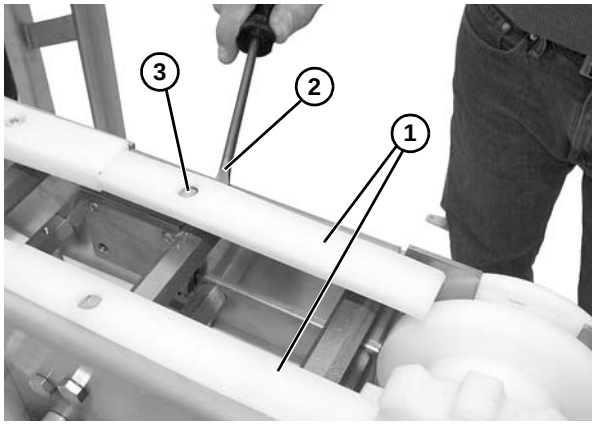


Figure 32

3. Remove lower wear strips, as needed; repeat procedure used for upper wear strips.

Removing Wear Strips on Knuckles

1. Remove conveyor belt. See "Replacing the Entire Belt" on page 17.
2. Press wear strips **(Figure 33, item 1)** off conveyor rails **(Figure 33, item 2)**.

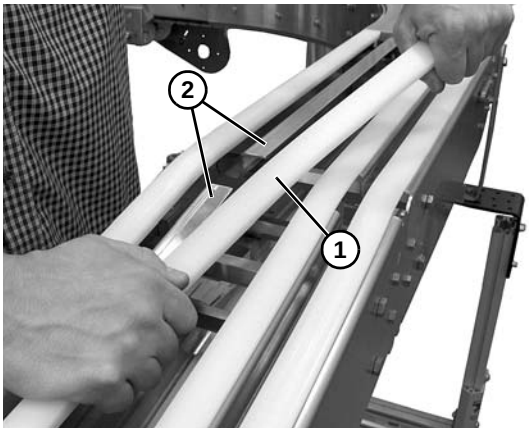


Figure 33

3. Remove lower wear strips, as needed; repeat procedure used for upper wear strips.

Install New Wear Strips

NOTE
Wear strips should be one continuous run over the knuckle.

1. Position new wear strips **(Figure 34, item 1)** on conveyor. Mark tab locations and cut to length.

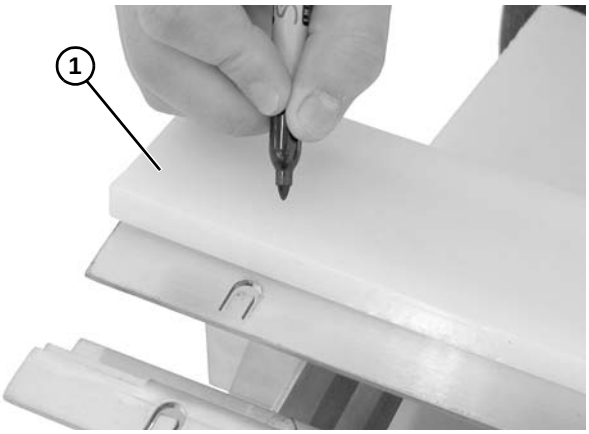


Figure 34

2. Drill 1/2" holes **(Figure 35, item 1)** .515" from bent edge **(Figure 35, item 2)** at tab locations.

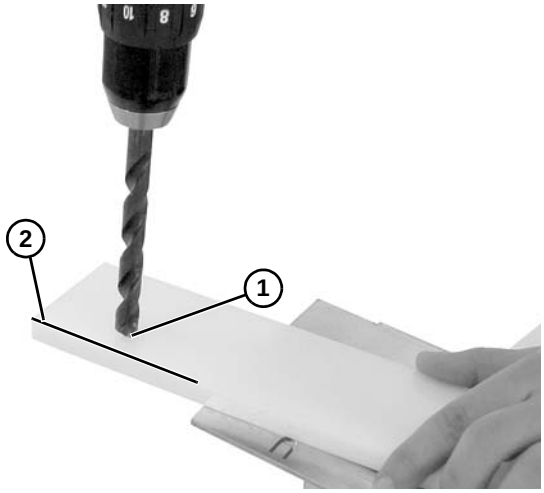


Figure 35

3. Install wear strips **(Figure 36, item 1)**.

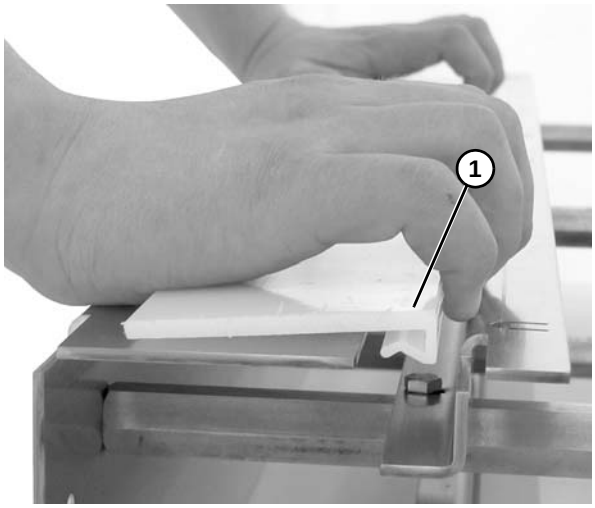


Figure 36

Idler Pulley Assembly

⚠ WARNING

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

1. Remove belt. Refer to "Conveyor Belt Replacement" on page 16.
2. Remove four flat head screws **(Figure 37, item 1)** with an allen wrench **(Figure 37, item 2)**.

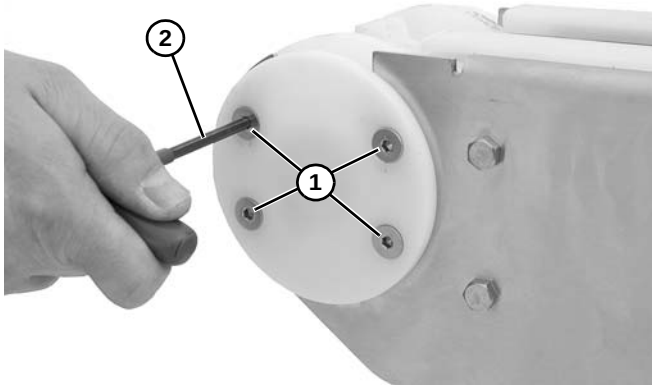


Figure 37

3. Remove bearing housing **(Figure 38, item 1)**.

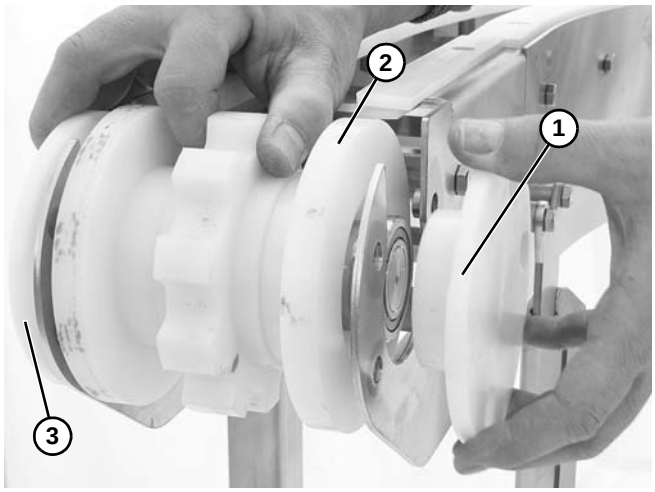


Figure 38

4. While holding onto idler pulley assembly **(Figure 38, item 2)**, remove bearing housing **(Figure 38, item 3)** from opposite side and lift idler assembly from tail.

NOTE

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

5. Using puller **(Figure 39, item 1)**, as shown, remove bearing **(Figure 39, item 2)** from shaft assembly. Repeat on opposite side, if needed.

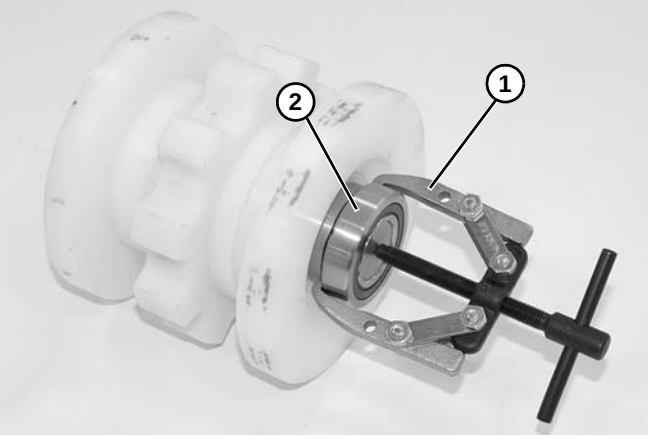


Figure 39

⚠ WARNING

Driveshaft keyway may be sharp, HANDLE WITH CARE.

6. Remove spacer **(Figure 40, item 1)**, support wheel **(Figure 40, item 2)**, sprocket **(Figure 40, item 3)**, and shaft key **(Figure 40, item 4)** from idler shaft.

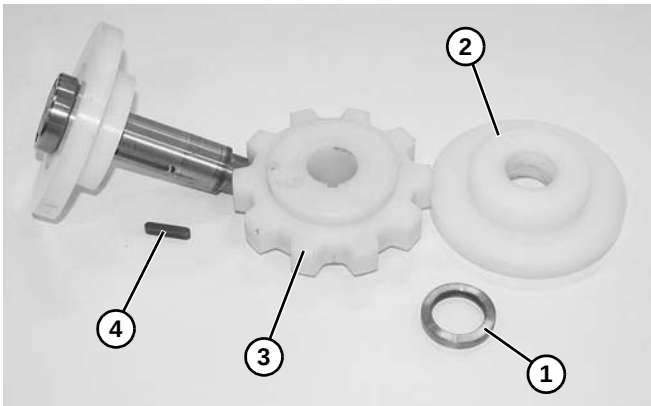


Figure 40

7. Inspect and replace components if worn.
8. Assemble components reverse of removal.
9. Press new bearing(s) onto idler shaft.

Drive Spindle Shaft Assembly

⚠ WARNING

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

1. Remove belt. Refer to "Conveyor Belt Replacement" on page 16.

Side Drive

1. Remove four socket head screws **(Figure 41, item 1)** securing end cover **(Figure 41, item 2)** to the drive motor.

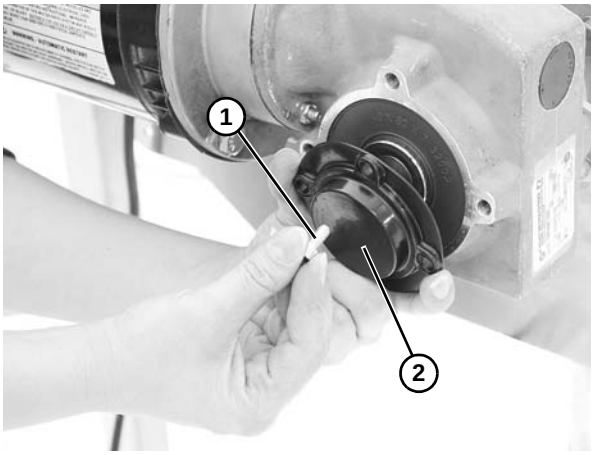


Figure 41

2. Remove flat head screw **(Figure 42, item 1)** and clamp washer **(Figure 42, item 2)** from the drive shaft.

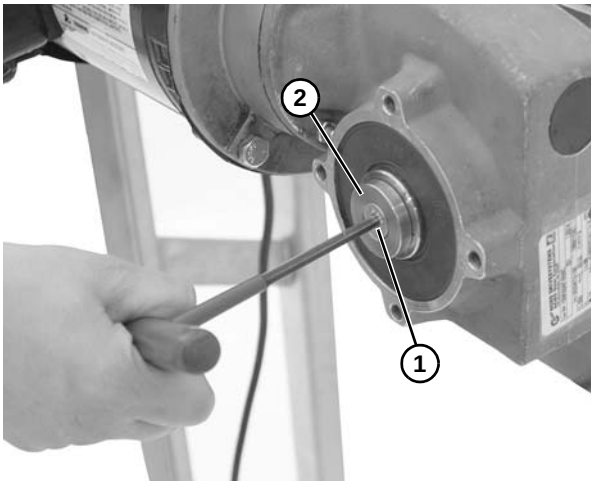


Figure 42

3. Remove four bolts and washers **(Figure 43, item 1)**.

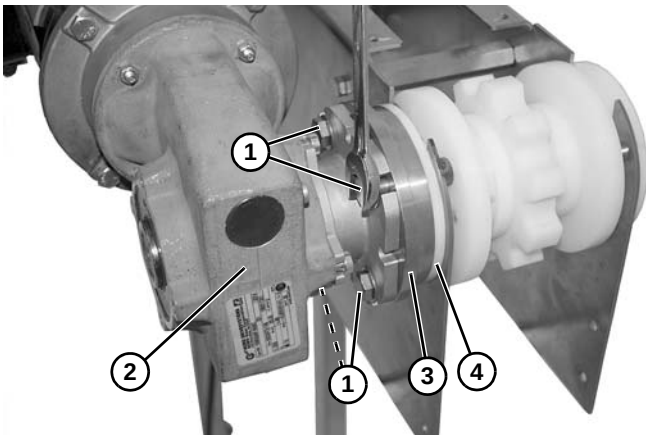


Figure 43

4. Remove motor **(Figure 43, item 2)**, adapter **(Figure 43, item 3)**, and bearing housing **(Figure 43, item 4)** from the drive shaft.
5. Remove four flat head screws **(Figure 44, item 1)** with an allen wrench **(Figure 44, item 2)**.

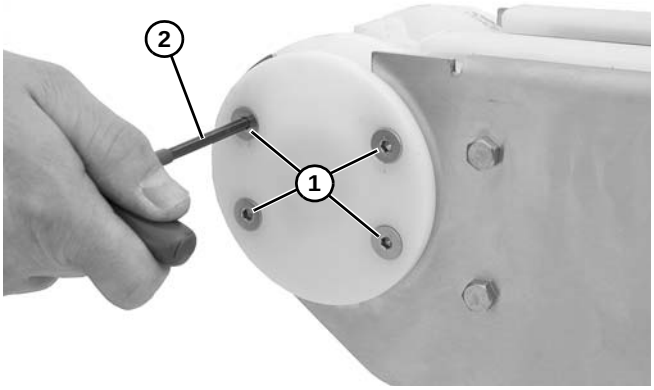


Figure 44

6. Remove bearing housing **(Figure 45, item 1)** and lift spindle shaft assembly from tail.

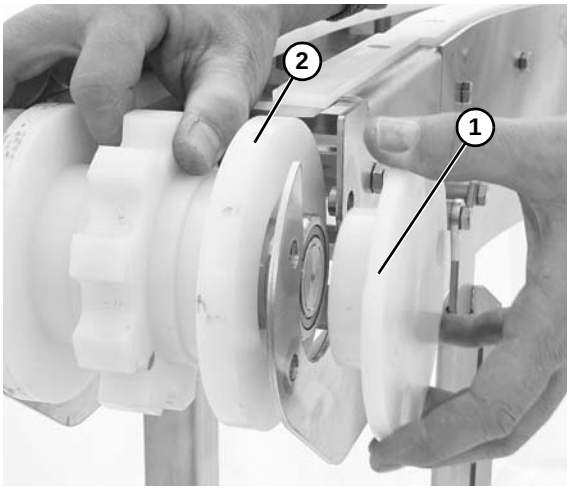


Figure 45

NOTE

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

7. Using puller **(Figure 46, item 1)**, as shown, remove bearing **(Figure 46, item 2)** from shaft assembly. Repeat on opposite side, if needed.

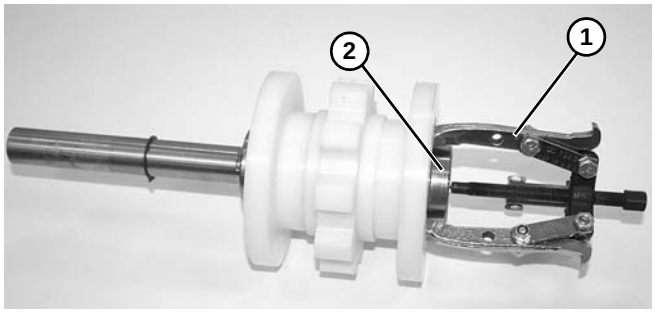


Figure 46

⚠ WARNING

Driveshaft keyway may be sharp, HANDLE WITH CARE.

8. Remove spacer **(Figure 47, item 1)**, support wheel **(Figure 47, item 2)**, sprocket **(Figure 47, item 3)**, and shaft key **(Figure 47, item 4)** from spindle shaft.

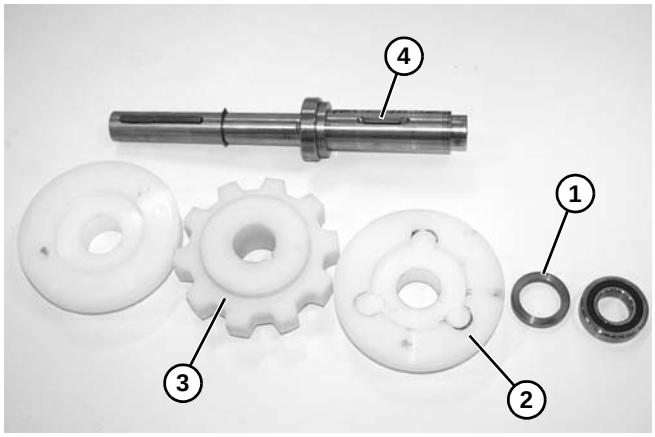


Figure 47

9. Inspect and replace components if worn.
10. Assemble components reverse of removal.
11. Press new bearing(s) onto spindle shaft.

Bottom Drive

⚠ WARNING

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

1. Remove socket head screws **(Figure 48, item 1)** and drive cover **(Figure 48, item 2)**.

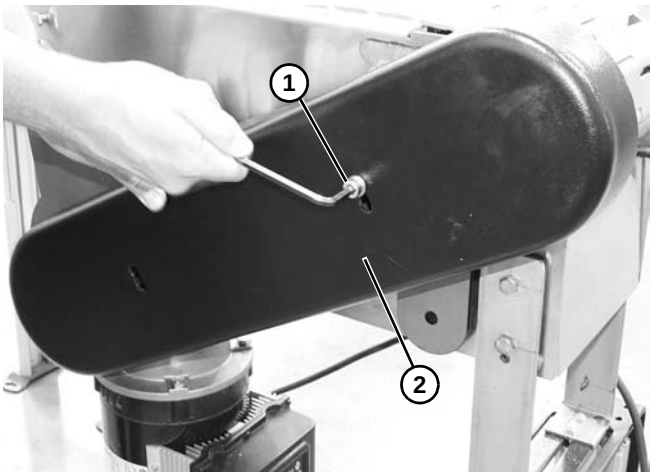


Figure 48

2. Loosen belt tensioner **(Figure 49, item 1)** and remove timing belt **(Figure 49, item 2)**.

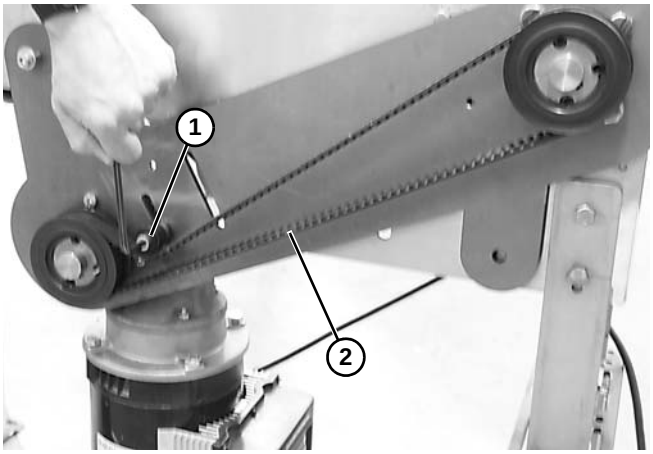


Figure 49

3. Loosen set screws **(Figure 50, item 1)** and remove drive pulley **(Figure 50, item 2)**.

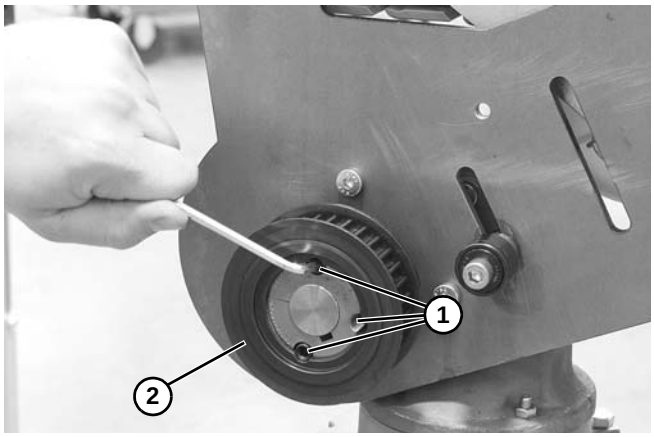


Figure 50

4. Loosen set screws **(Figure 51, item 1)** and remove driven pulley **(Figure 51, item 2)**.

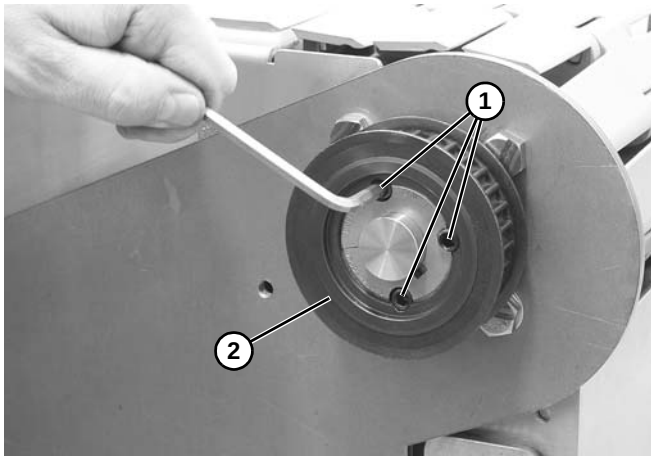


Figure 51

5. Remove motor drive shaft mounting bolt and remove drive shaft.
6. Remove four screws **(Figure 52, item 1)** and drive motor **(Figure 52, item 2)**.

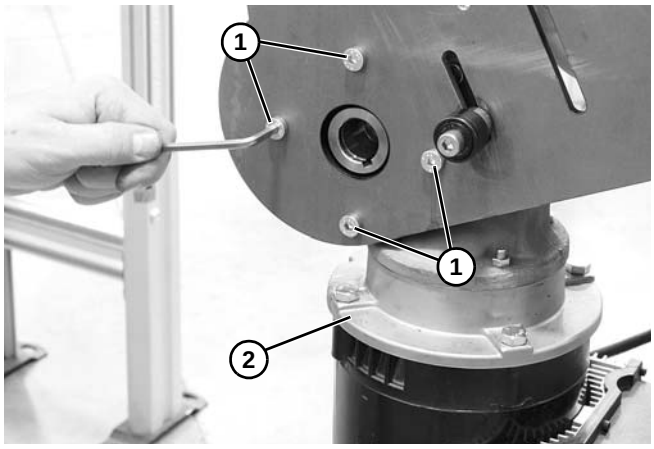


Figure 52

7. Remove mounting hardware **(Figure 53, item 1)** securing bottom mount plate **(Figure 53, item 2)** to conveyor. Remove plate and bearing housing.

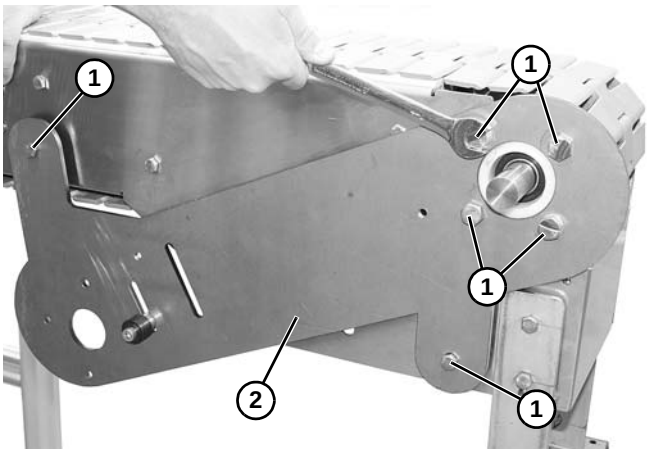


Figure 53

8. Remove four flat head screws **(Figure 54, item 1)** with an allen wrench **(Figure 54, item 2)**.

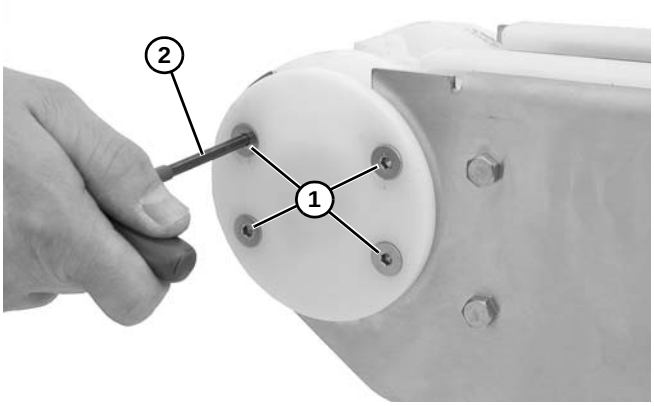


Figure 54

9. Remove bearing housing **(Figure 55, item 1)** and lift spindle shaft assembly from tail.

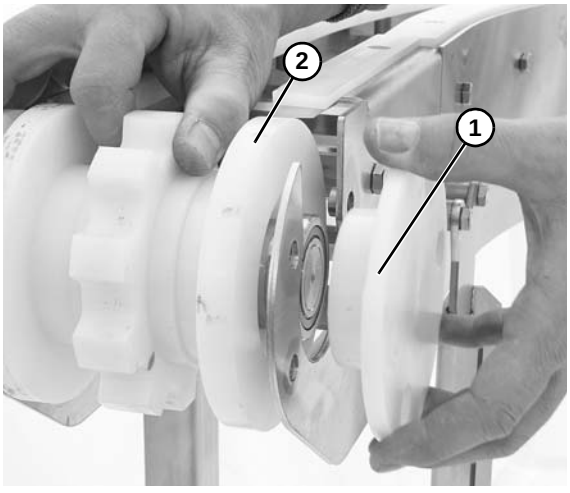


Figure 55

NOTE

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

10. Using puller **(Figure 56, item 1)**, as shown, remove bearing **(Figure 56, item 2)** from shaft assembly. Repeat on opposite side, if needed.

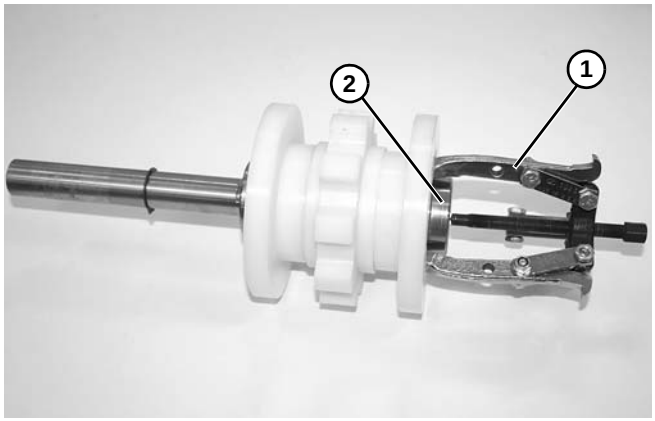


Figure 56

⚠ WARNING

Driveshaft keyway may be sharp, HANDLE WITH CARE.

11. Remove spacer **(Figure 57, item 1)**, support wheel **(Figure 57, item 2)**, sprocket **(Figure 57, item 3)**, and shaft key **(Figure 57, item 4)** from spindle shaft.

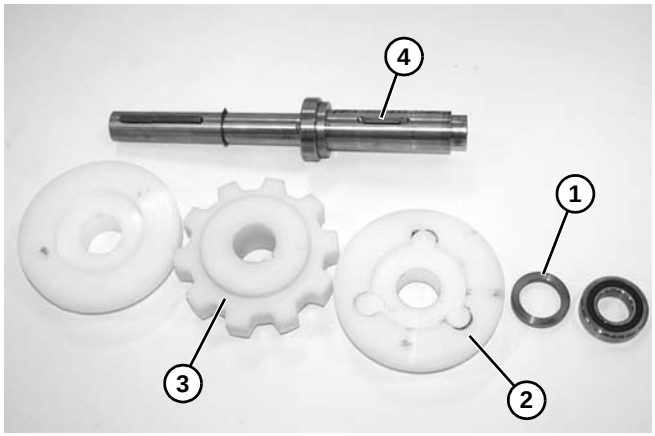


Figure 57

12. Inspect and replace components if worn.
13. Assemble components reverse of removal.
14. Press new bearing(s) onto spindle shaft.

Power Transfer

Removal

1. Remove two hex head screws **(Figure 58, item 1)** and cover **(Figure 58, item 2)** from power transfer assembly.

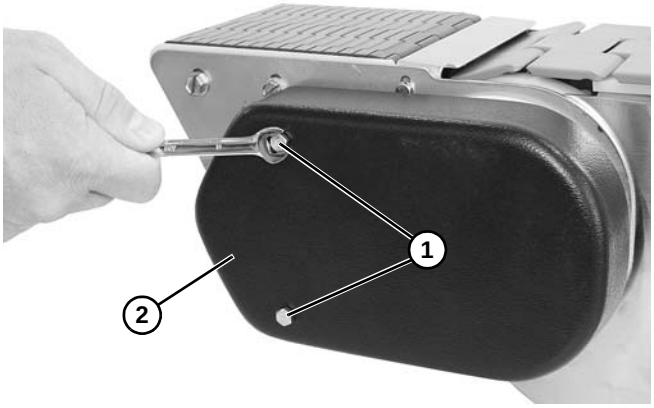


Figure 58

2. Loosen two hex head screws **(Figure 59, item 1)** holding tensioning pulley **(Figure 59, item 2)** onto timing belt **(Figure 59, item 3)**.

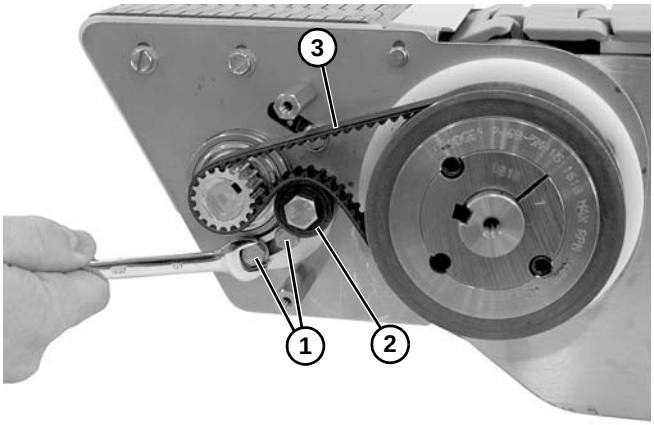


Figure 59

3. Remove timing belt **(Figure 59, item 3)** from assembly.
4. Loosen hex head screw **(Figure 60, item 1)** on both sides to loosen tension on chain **(Figure 60, item 2)**.

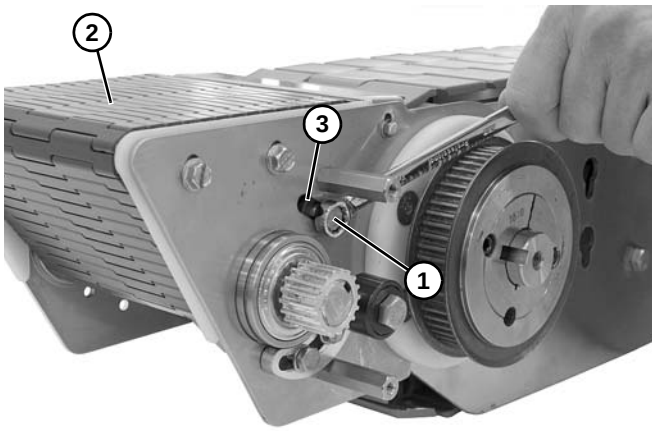


Figure 60

5. Slide assembly within slot **(Figure 60, item 3)** to remove tension on chain.
6. Remove two hex head screws **(Figure 61, item 1)** and transfer plate **(Figure 61, item 2)**.

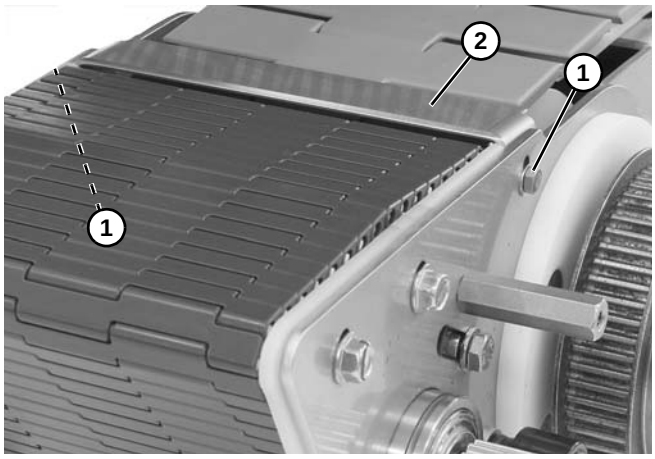


Figure 61

7. Lift slightly on belt **(Figure 62, item 1)** and push pin **(Figure 62, item 2)** out of chain.

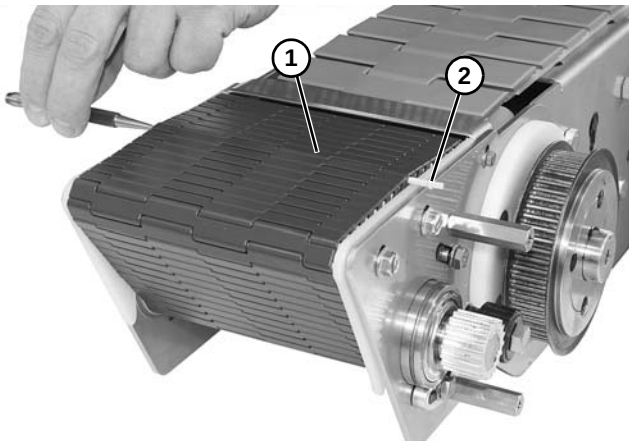


Figure 62

NOTE

*Note that head of pin **(Figure 63, item 1)** should be removed in direction shown.*

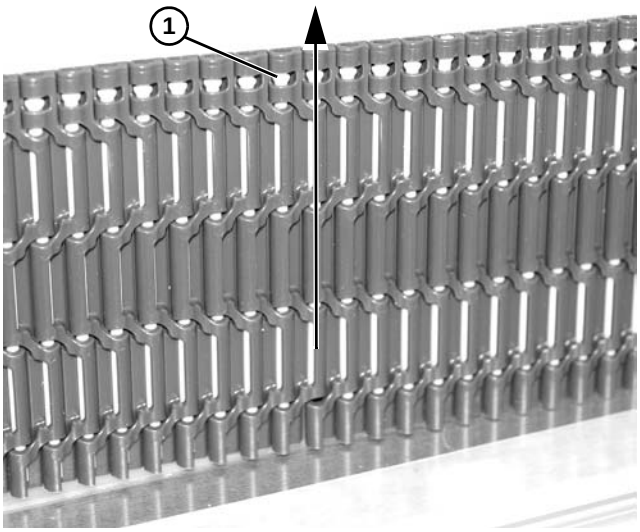


Figure 63

8. Remove chain.
9. Remove four screws **(Figure 64, item 1)** holding wear bar assembly **(Figure 64, item 2)** onto power transfer.

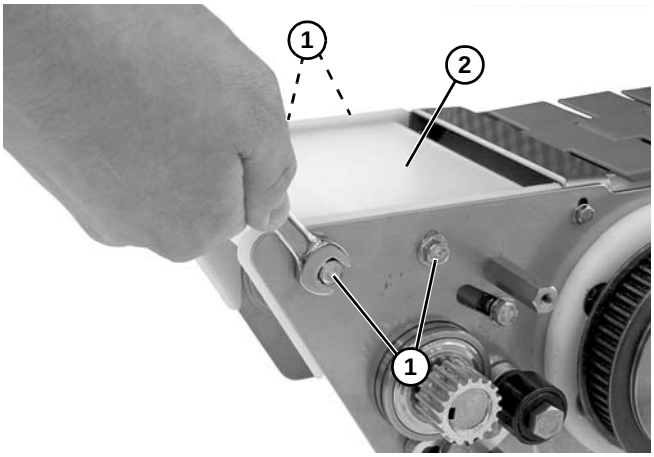


Figure 64

10. Remove wear bar assembly **(Figure 65, item 1)** from power transfer.

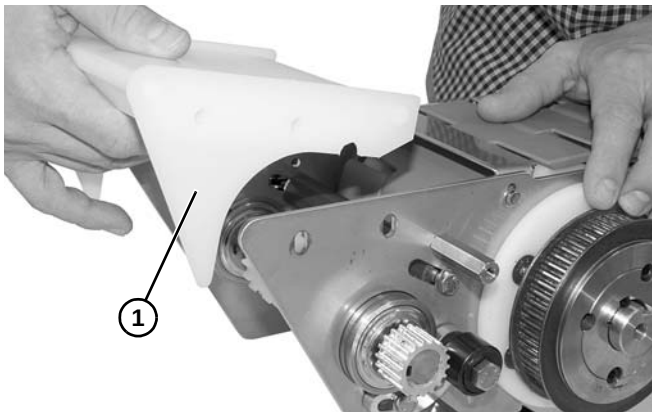


Figure 65

11. Disassemble side guide plates **(Figure 66, item 1)**, wear rods **(Figure 66, item 2)**, and wear bar **(Figure 66, item 3)**. Replace worn components.

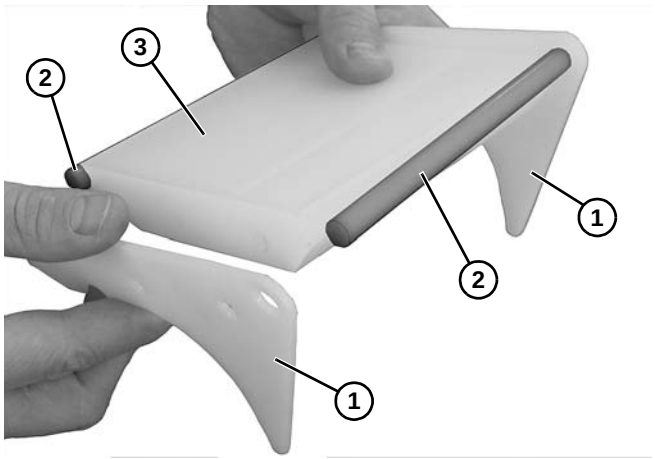


Figure 66

12. Remove hex head screws **(Figure 67, item 1)** and wear tube **(Figure 67, item 2)**.

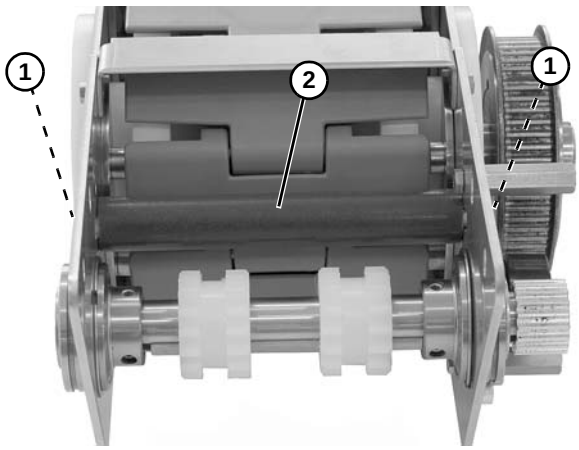


Figure 67

13. Replace wear tube and install screws to secure.

14. Loosen four set screws **(Figure 68, item 1)** on two bearings **(Figure 68, item 2)**.

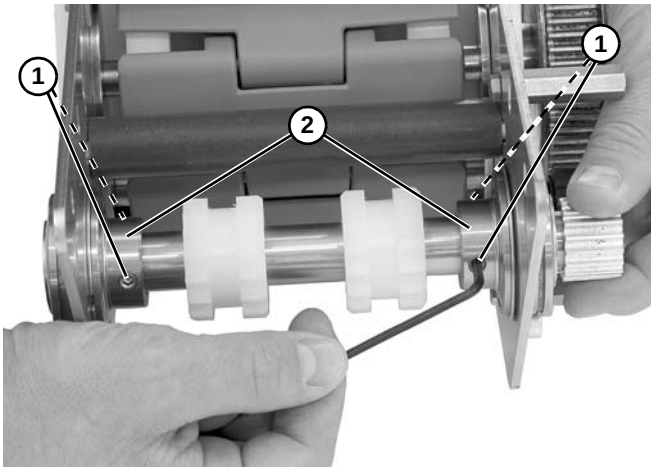


Figure 68

15. Remove drive shaft **(Figure 69, item 1)**, making certain not to loose key **(Figure 69, item 2)** when removing gears **(Figure 69, item 3)**.

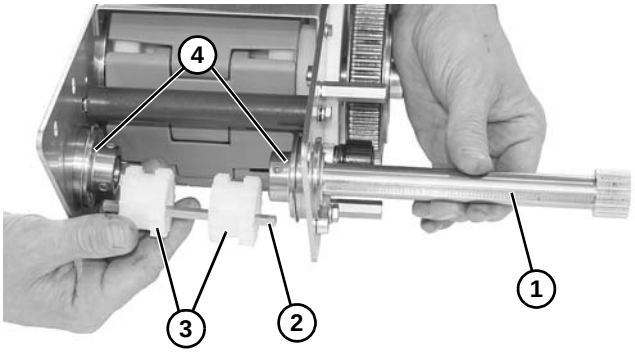


Figure 69

16. Remove key **(Figure 69, item 2)** from gears **(Figure 69, item 3)**.
17. Remove bearings **(Figure 69, item 4)** and replace if worn.

Installation

1. Install gears **(Figure 70, item 1)** onto key **(Figure 70, item 2)**.

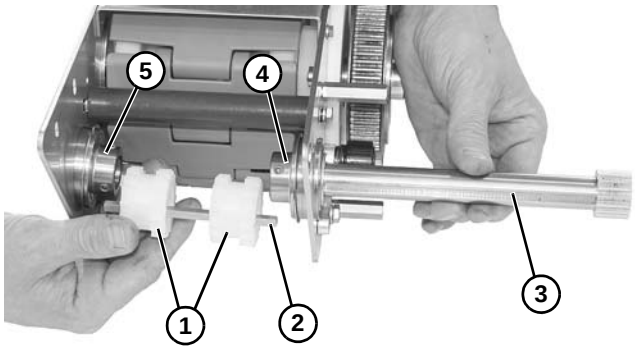


Figure 70

2. Install drive shaft **(Figure 70, item 3)** through bearing **(Figure 70, item 4)**, gears and key, and opposite side bearing **(Figure 70, item 5)**.
3. Secure drive shaft onto bearings with four set screws **(Figure 71, item 1)**.

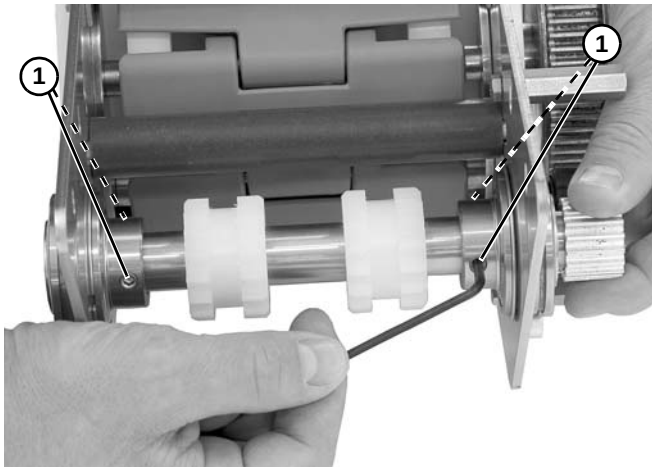


Figure 71

4. Raise chain **(Figure 72, item 1)** into position, and move gears **(Figure 72, item 2)** so that cogs line up with chain, as shown.

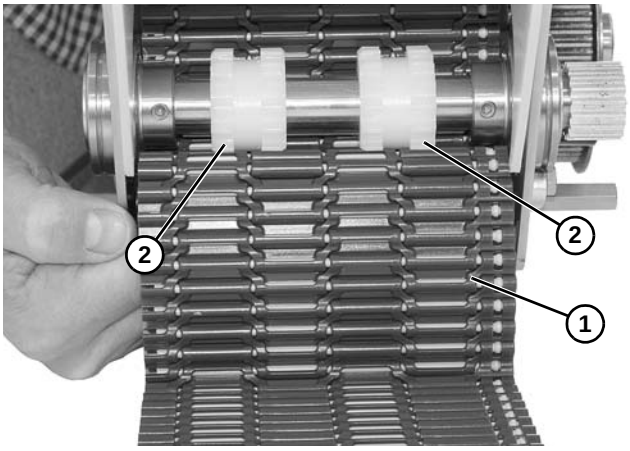


Figure 72

5. Install wear bar assembly **(Figure 73, item 1)** with four screws **(Figure 73, item 2)**.

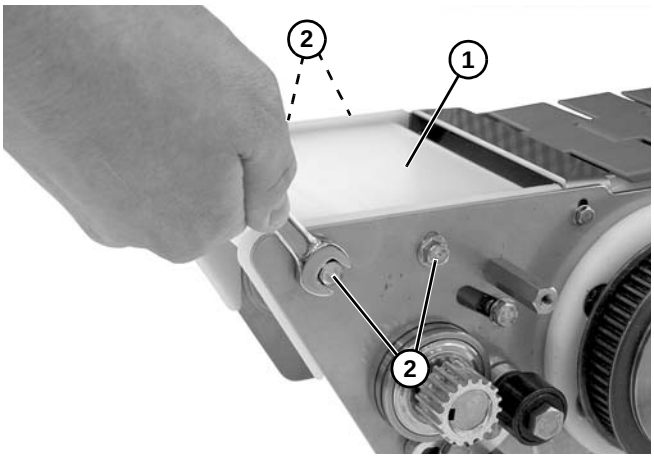


Figure 73

6. Guide belt **(Figure 74, item 1)** through wear bar assembly with belt routing under gears **(Figure 74, item 2)** and over wear tube **(Figure 74, item 3)**.

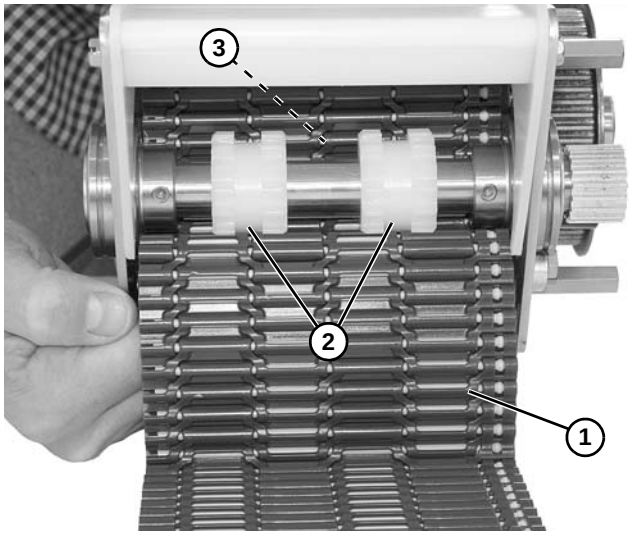


Figure 74

7. Bring ends of belt together and install pin **(Figure 75, item 1)**.

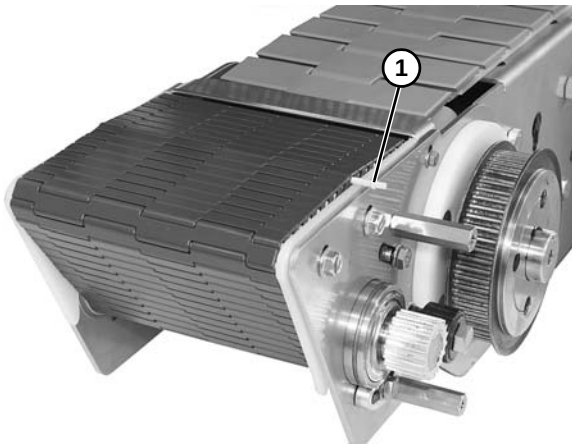


Figure 75

8. Install tensioner plate **(Figure 76, item 1)** with two hex head screws **(Figure 76, item 2)**.

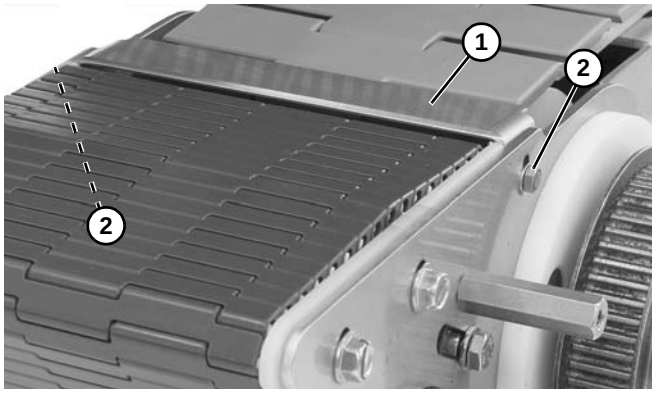


Figure 76

9. Slide assembly within slot **(Figure 77, item 1)** to remove excess slack from belt **(Figure 77, item 2)**.

⚠ CAUTION

DO NOT overtighten belt or excessive wear will occur.

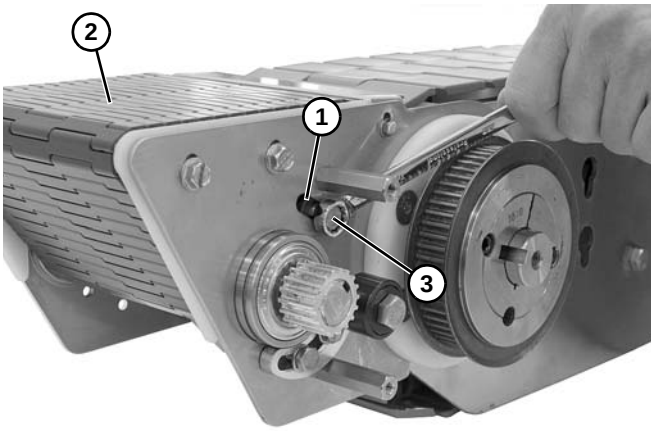


Figure 77

10. Tighten hex head screws **(Figure 77, item 3)** on both sides to keep tension on belt **(Figure 77, item 2)**.
11. Rotate drive shaft **(Figure 78, item 1)** to verify tightness of belt **(Figure 78, item 2)**. Belt should turn freely. Loosen hex head screw **(Figure 78, item 3)** and adjust, if necessary.

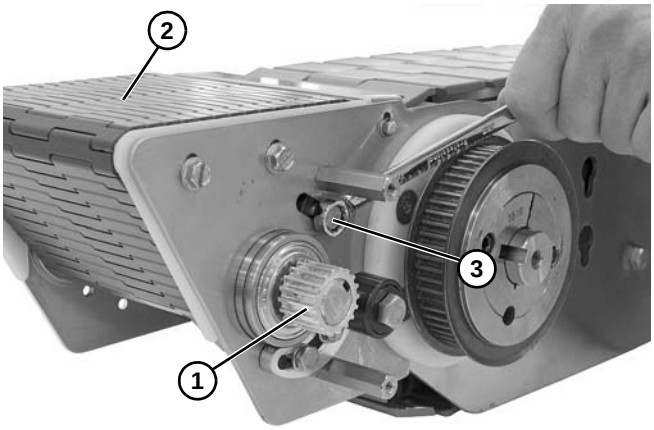


Figure 78

12. Route and install timing belt **(Figure 79, item 1)** as shown. Press down on tensioner **(Figure 79, item 2)** and tighten two hex head screws **(Figure 79, item 3)**.

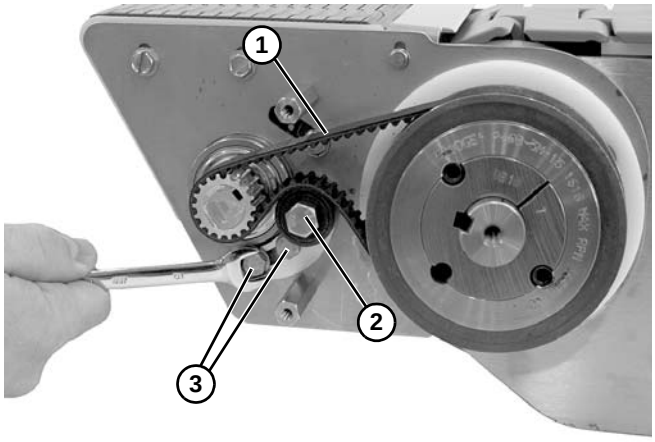


Figure 79

13. Install cover **(Figure 80, item 1)** with two hex head screws **(Figure 80, item 2)**.

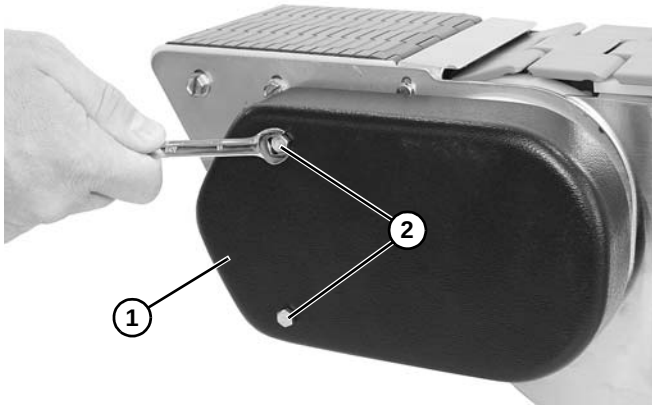


Figure 80

Roller Transfer

1. Remove four hex head screws **(Figure 81, item 1)** and roller transfer assembly **(Figure 81, item 2)** from conveyor.

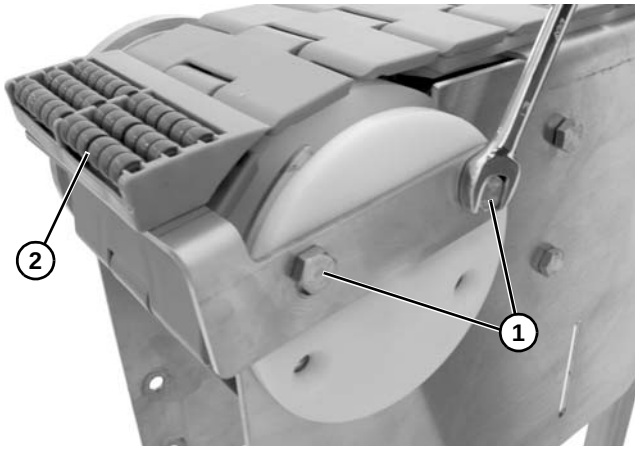


Figure 81

2. Remove two nuts and washers **(Figure 82, item 1)** and roller transfer assembly **(Figure 82, item 2)** from mounting bracket **(Figure 82, item 3)**.

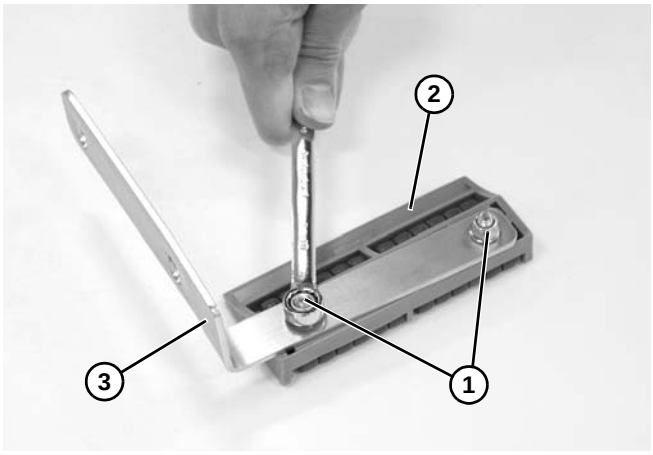
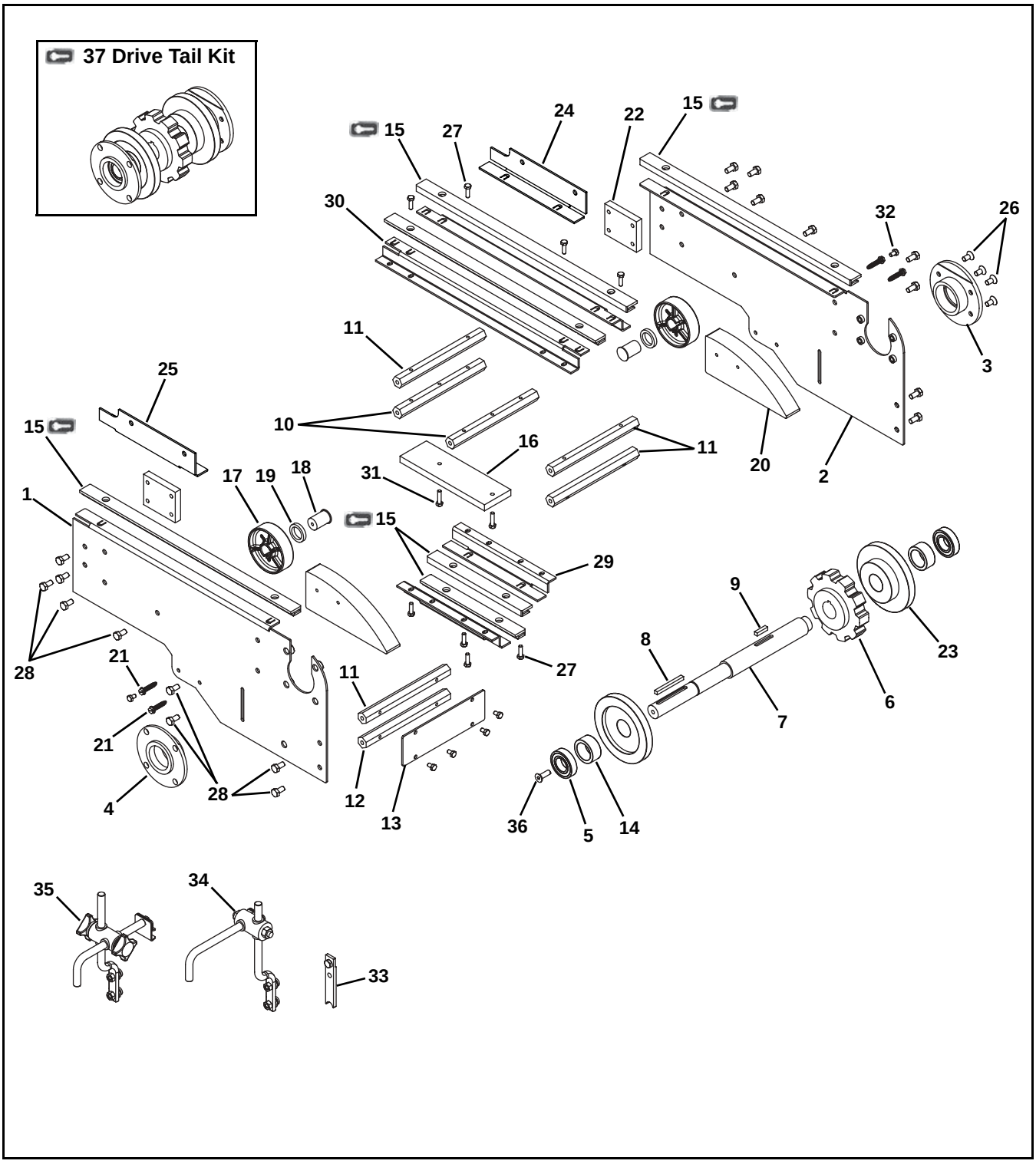


Figure 82

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 Module

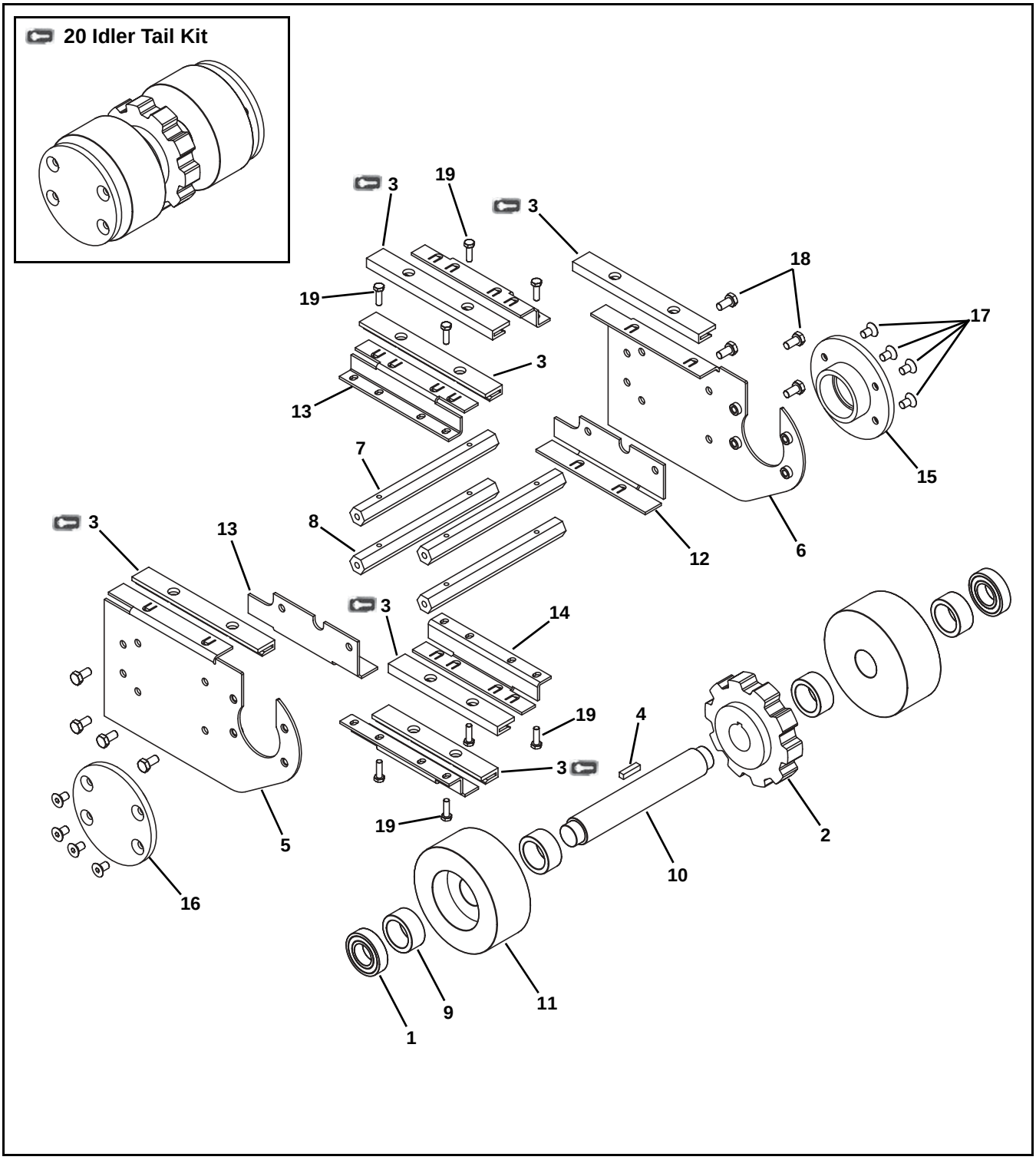


Item	Part Number	Description
1	514643-WW	Side Rail - Right Hand for 'A' Position Conveyor without Keyholes
	514881-WW	Side Rail - Right Hand for 'A' Position Conveyor with Keyholes
	514521-WW	Side Rail - Right Hand for 'D' Position Conveyor without Keyholes
	514884-WW	Side Rail - Right Hand for 'D' Position Conveyor with Keyholes
2	514642-WW	Side Rail - Left Hand for 'A' Position Conveyor without Keyholes
	514882-WW	Side Rail - Left Hand for 'A' Position Conveyor with Keyholes
	514485-WW	Side Rail - Left Hand for 'D' Position Conveyor without Keyholes
	514883-WW	Side Rail - Left Hand for 'D' Position Conveyor with Keyholes
3	514465	Bearing Housing - Non Drive Side
	511301	Bearing Housing - Non Drive Side - Dual Shaft
4	514464	Bearing Housing - Drive Side
5	802-210	Bearing
6	807-2284	Sprocket
7	514466-WW	Side Drive Spindle
	514668-WW	Side Drive Spindle - Dual Shaft
	514650-WW	Bottom Drive Spindle
	514615-WW	Bottom Drive Spindle - Dual Shaft
8	912-111SS	Side Drive Key
	912-103	Bottom Drive Key
9	912-108SS	Sprocket Key
10	514462-WW-R	Return Hex Bar
11	514462-WW	Hex Bar
12	514462-04-T	Turn Hex Bar for 4.5" Wide Conveyors Only
	514462-WW	Turn Hex Bar for 7.5", 10" & 12" Wide Conveyors
13	514472-WW	End Plate
14	514467-WW	Spindle Spacer
15	807-2456	Wear Strip 1" (per foot) used on all width Conveyors
	807-2457	Wear Strip 2" (per foot) used on 10" wide Conveyors
	807-2458	Wear Strip 3" (per foot) used on 12" wide Conveyors
16	506891	Return Plate
17	506296	Idler Puck
18	350472	Idler Stub
19	350474-STUB	Spacer
20	514856	Return for Roller Top Belt Only
21	807-1884	Screw for Roller Top Belt Only
22	514471	Connector Plate
23	514537	Support Wheel for 4.5" Wide Conveyors
	514468-WW	Support Wheel for 7.5", 10" & 12" Wide Conveyors
24	514538	L-Plate for 4.5" Wide Conveyors Only
25	514539	L-Plate for 4.5" Wide Conveyors Only
26	930816MSS	Flat Screw, M8-1.25 x 16 mm
27	960612MSS	Hex Head Cap Screw, M6-1.00 x 12 mm
28	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
29	514519	Bottom Z-Strip for 7.5", 10" & 12" Wide Conveyors Only
30	514506	Top Z-Strip for 7.5", 10" & 12" Wide Conveyors Only
31	960625MSS	Hex Head Cap Screw, M6-1.00 x 25 mm
32	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
33	511300	Mount Assembly for 04 & 05 Profiles
34	532313	Mount Assembly for 13 Profiles
35	532314	Mount Assembly for 14 Profiles
36	960610MSS	Flat Screw, M8-1.25 x 25 mm
37	71-DK-WW	Drive Tail Kit - Includes Items 3, 4, 5, 6, 14 & 23

WW= Conveyor width reference: 04, 07, 10, 12

Service Parts

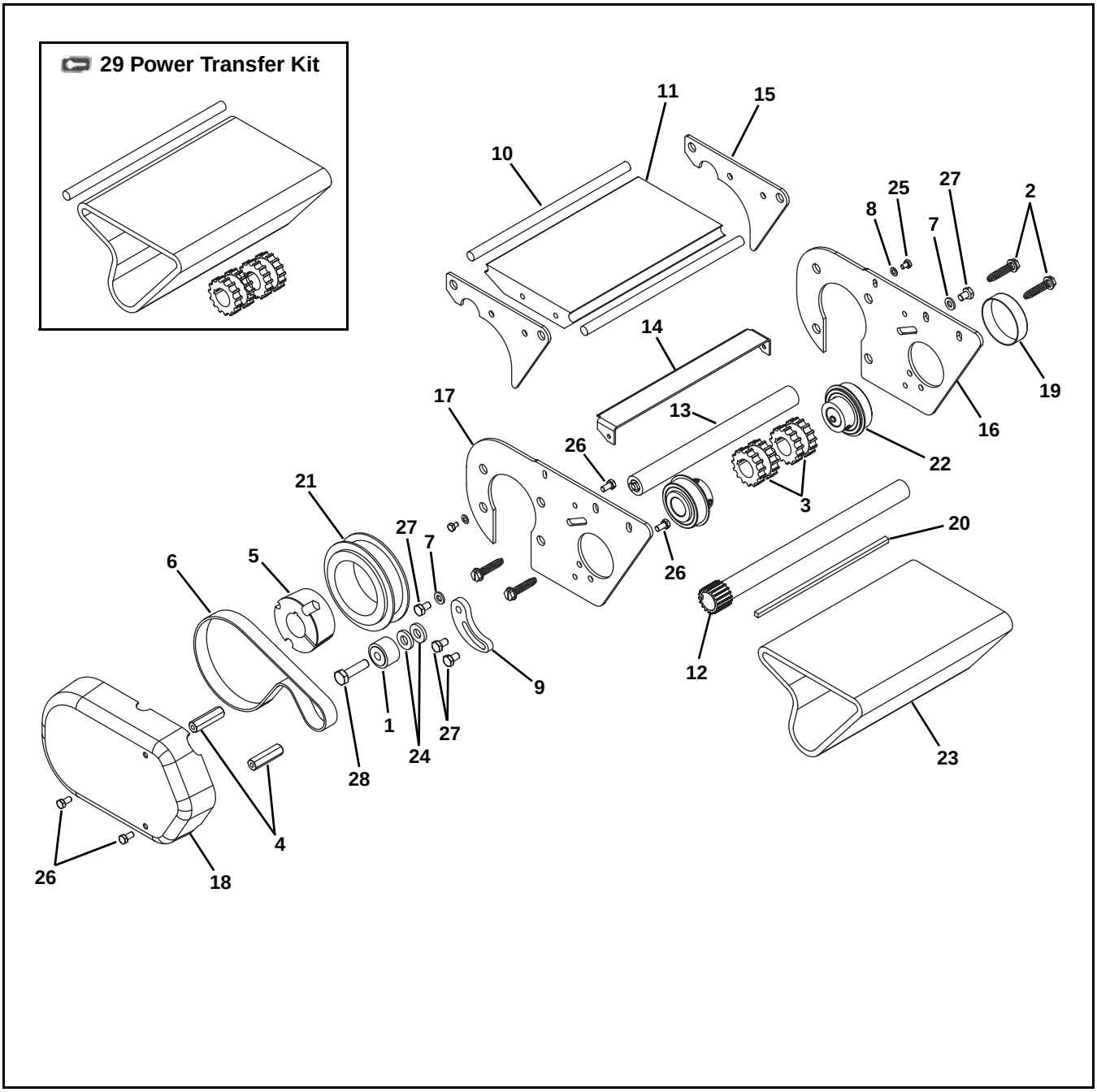
Idler Module



Item	Part Number	Description
1	802-210	Bearing
2	807-2284	Sprocket
3	807-2456	Wear Strip 1" (per foot) used on all width Conveyors
	807-2457	Wear Strip 2" (per foot) used on 10" wide Conveyors
	807-2458	Wear Strip 3" (per foot) used on 12" wide Conveyors
4	912-108SS	Square Key
5	514524-WW	Side Rail Right Hand
	514879-WW	Side Rail Right Hand with Keyhole Slots
6	514525-WW	Side Rail Left Hand
	514878-WW	Side Rail Left Hand with Keyhole Slots
7	514462-WW	Hex Bar
8	514462-WW-L	Lower Hex Bar used on 4.5" wide Conveyors only
	514462-WW	Lower Hex Bar used on 7.5", 10", & 12" wide Conveyors
9	514467-WW	Spacer
10	514488-WW	Shaft
	514650-WW	Auxiliary Shaft, also used with Power Transfer Tail
11	514537	Support Wheel used on 4.5" wide Conveyors only
	514468-WW	Support Wheel used on 7.5", 10", & 12" wide Conveyors
12	514549	L Plate Left Hand used on 4.5" wide Conveyors only
13	514550	L Plate Right Hand used on 4.5" wide Conveyors only
14	514507	Z-Strip used on 7.5", 10", & 12" wide Conveyors
15	514465	Bearing Housing
16	514465	Bearing Housing
	511301	Bearing Housing used with Auxiliary Shaft only
17	930814MSS	Flat Head Cap Screw, M8-1.25 x 12 mm
18	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
19	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm used on 7.5", 10", & 12" wide Conveyors
20	71-EK-WW	Idler Tail Kit - Includes Items 1, 2, 9, 11, 15 & 16
WW= Conveyor width reference: 04, 07, 10, 12		

Service Parts

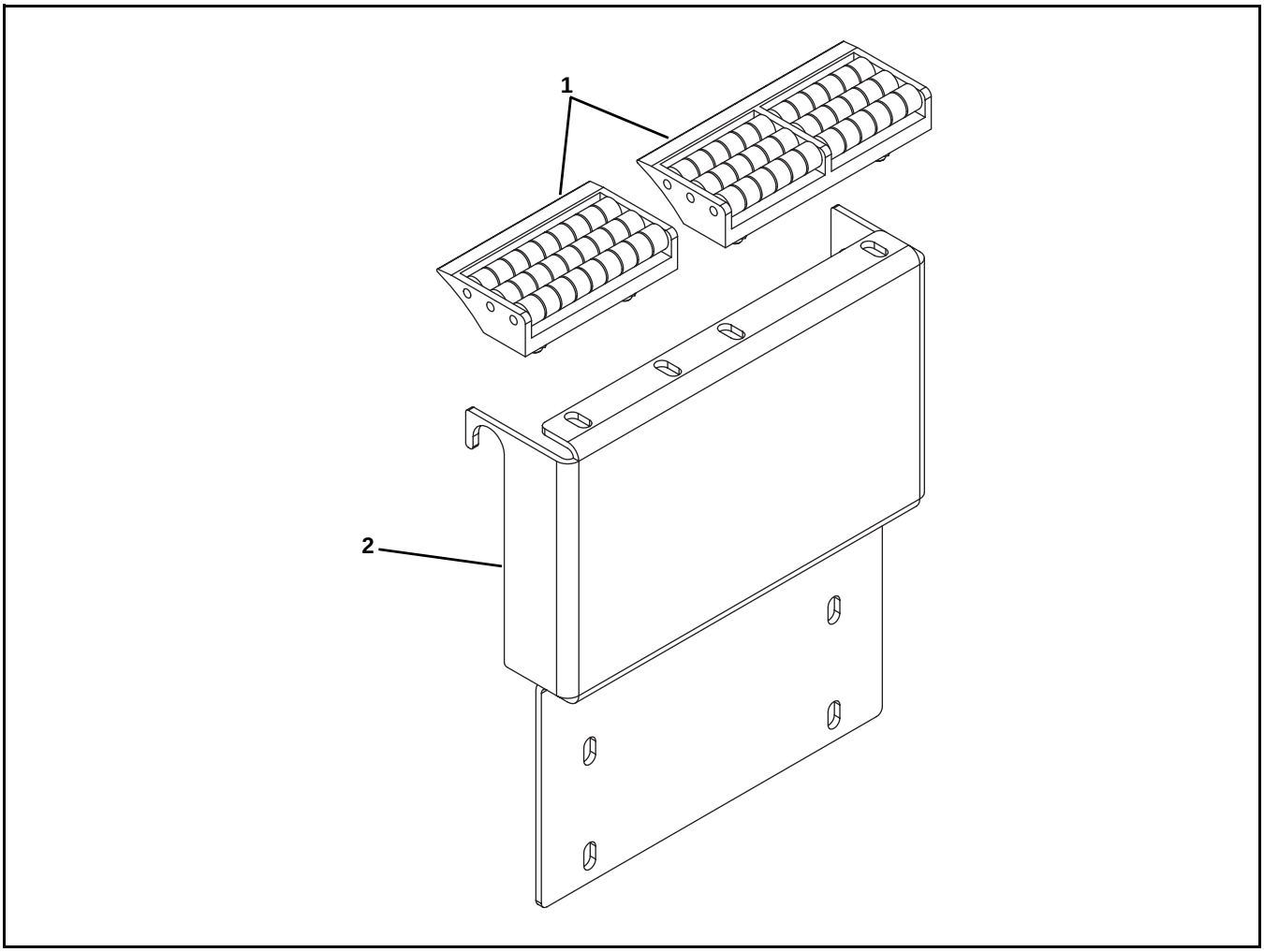
Power Transfer



Item	Part Number	Description
1	802-046	Cam Bearing
2	807-1884	Sheet Metal Screws, #14 x 1.25
3	807-2009	Sprocket
4	807-2287	Hex Post
5	811-119	Bushing
6	804-115	Timing Belt
7	911-222	Washer
8	911-604	Washer
9	203231	Timing Belt Tensioner
10	514622-WW	Wear Rod
11	514623-WW	Wear Bar
12	514624-WW	Shaft Assembly
13	514626-WW	Tensioner Assembly
14	514626-WW	Transfer Plate
15	514629	Side Guard Plate
16	514630	Side Plate for Drive Tail
	514631	Side Plate for Idler Tail
17	514631	Side Plate
18	514633	Cover
19	514644	Bearing Cover
20	514645-WW	Square Key
21	514644	Pulley
22	514647	Bearing
23	514680-WW	Power Transfer Belt
24	605280P	Washer
25	960406MSS	Hex Head Cap Screw, M4-0.70 x 6 mm
26	960510MSS	Hex Head Cap Screw, M5-0.80 x 10 mm
27	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
28	960830MSS	Low Head Cap Screw, M8-1.25 x 30 mm
29	71-PT-WW	Power Transfer Kit - Includes Items 3, 10 & 23
WW= Conveyor width reference: 04, 07, 10, 12		

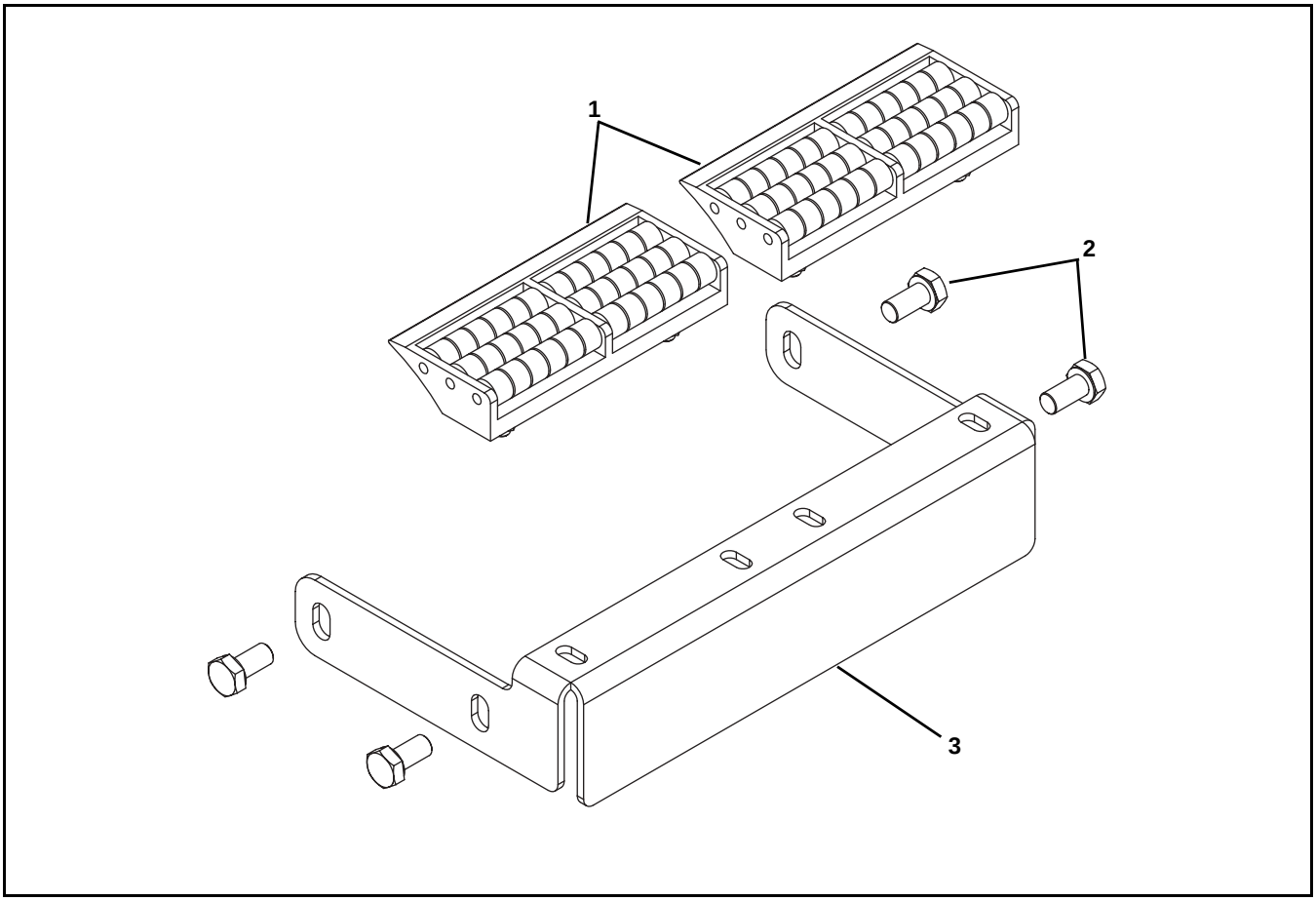
Service Parts

Drive Tail Roller Transfer



Item	Part Number	Description
1	807-1830	Transfer Roller for 4" Wide Conveyor (x1)
	807-1829	Transfer Roller for 7" Wide Conveyor (x1)
	807-1830	Transfer Roller for 7" Wide Conveyor (x1)
	807-1830	Transfer Roller for 10" Wide Conveyor (x2)
	807-1829	Transfer Roller for 12" Wide Conveyor (x1)
	807-1830	Transfer Roller for 12" Wide Conveyor (x2)
2	514868A-WW	Bracket for 'A' Position Drive
	514868D-WW	Bracket for 'D' Position Drive
WW= Conveyor width reference: 04, 07, 10, 12		

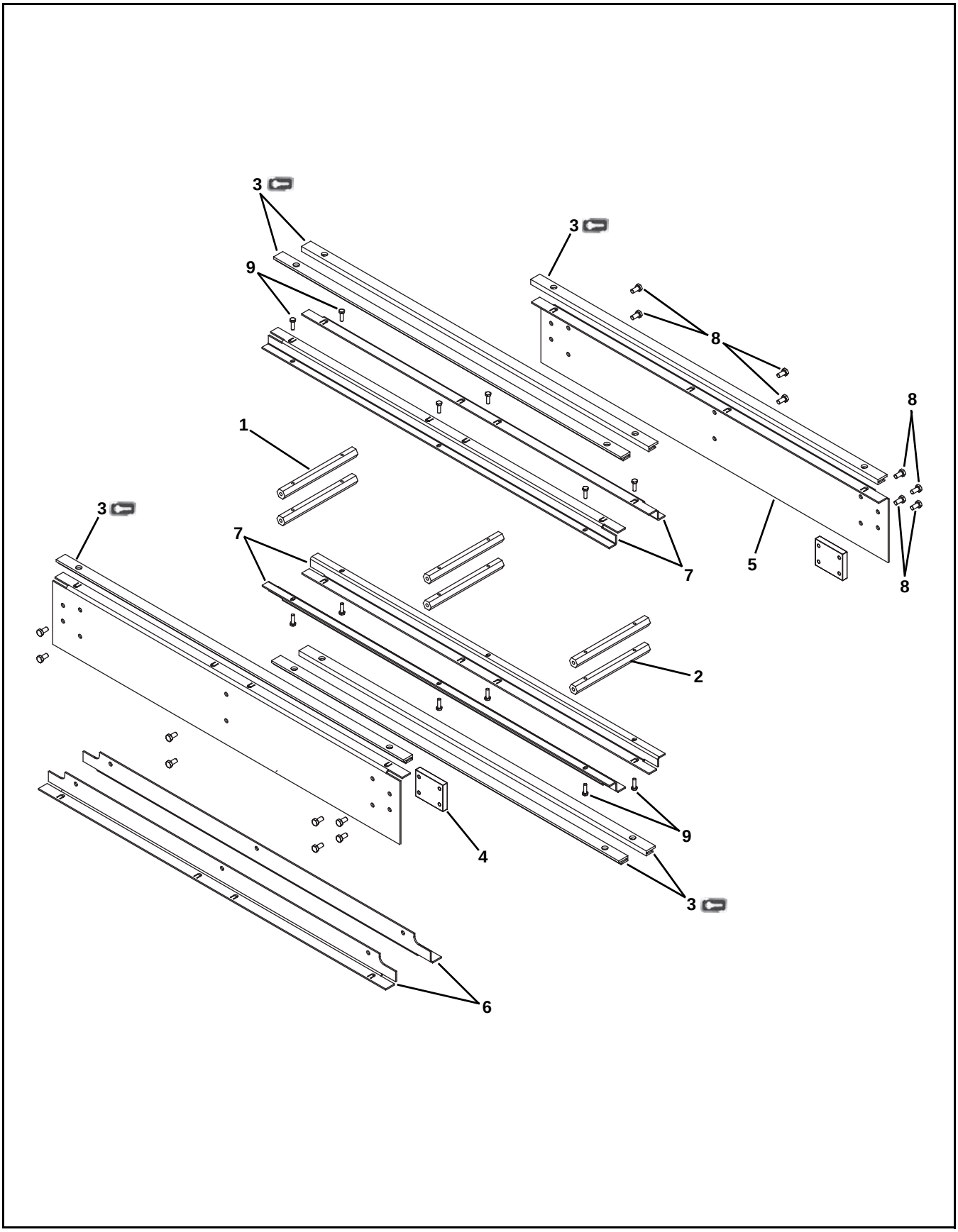
Idler Tail Roller Transfer



Item	Part Number	Description
1	807-1830	Transfer Roller for 4" Wide Conveyor (x1)
	807-1830	Transfer Roller for 7" Wide Conveyor (x2)
	807-1829	Transfer Roller for 10" Wide Conveyor (x2)
	807-1830	Transfer Roller for 10" Wide Conveyor (x1)
	807-1830	Transfer Roller for 12" Wide Conveyor (x3)
2	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
3	514867-WW	Bracket
WW= Conveyor width reference: 04, 07, 10, 12		

Service Parts

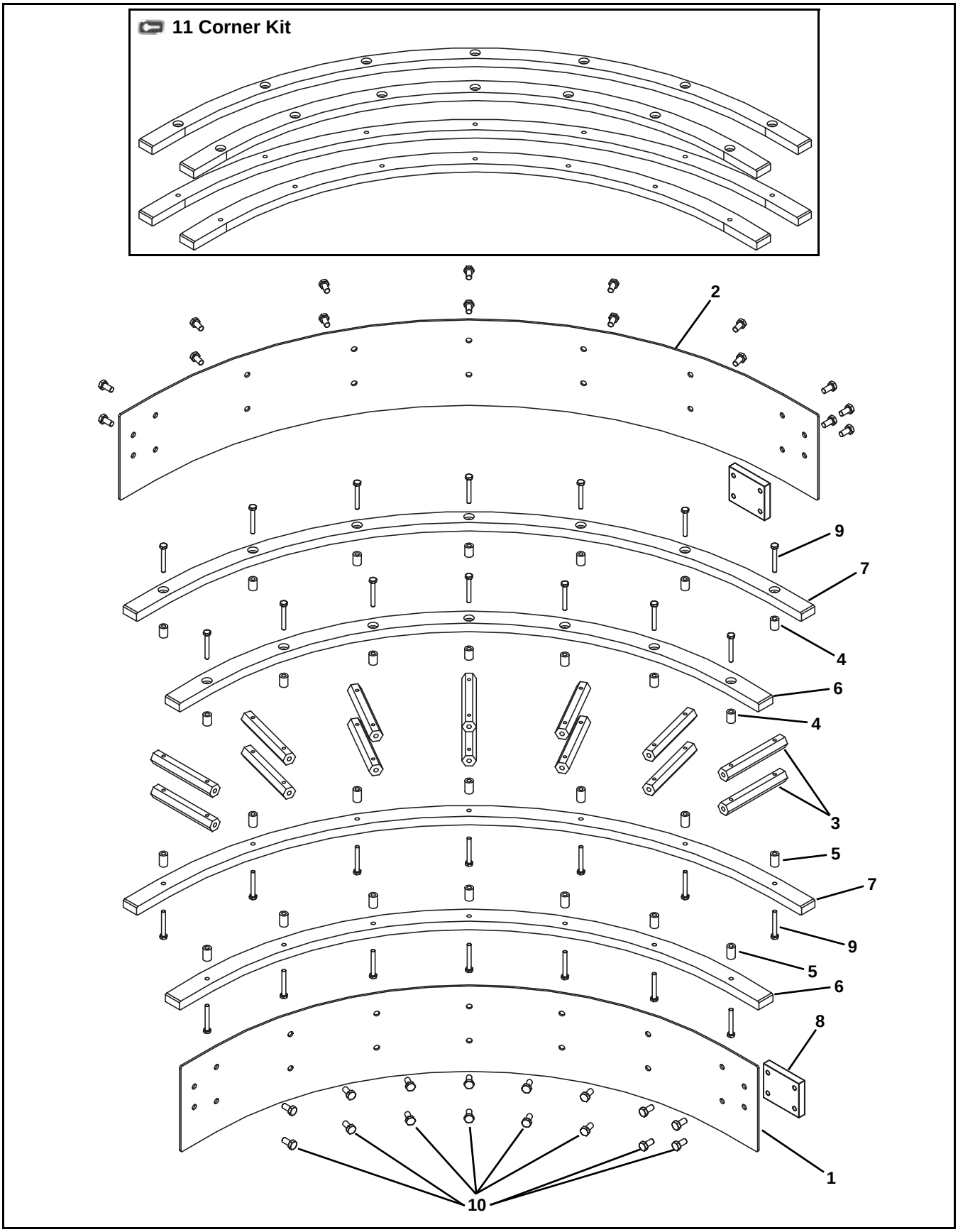
Intermediate Frame Assembly



Item	Part Number	Description
1	514462-WW	Hex Bar
2	514462-WW-L	Lower Hex Bar
3	807-2456	Wear Strip 1" (per foot) used on all width conveyors
	807-2457	Wear Strip 2" (per foot) used on 10" wide conveyors
	807-2458	Wear Strip 3" (per foot) used on 12" wide conveyors
4	514471	Connecting Plate
5	514471-WW-LLLLL	Side Rail
	514841-WW-LLLLL	Side Rail with Keyhole Slots
6	514845-LLLLL	L Plate used on 4.5" wide conveyors only
7	514476-LLLLL	Z-Strip used on 7.5", 10", & 12" wide conveyors
8	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
9	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm used on 7.5", 10", & 12" wide conveyors
WW = Conveyor width reference: 04, 07, 10, 12		
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

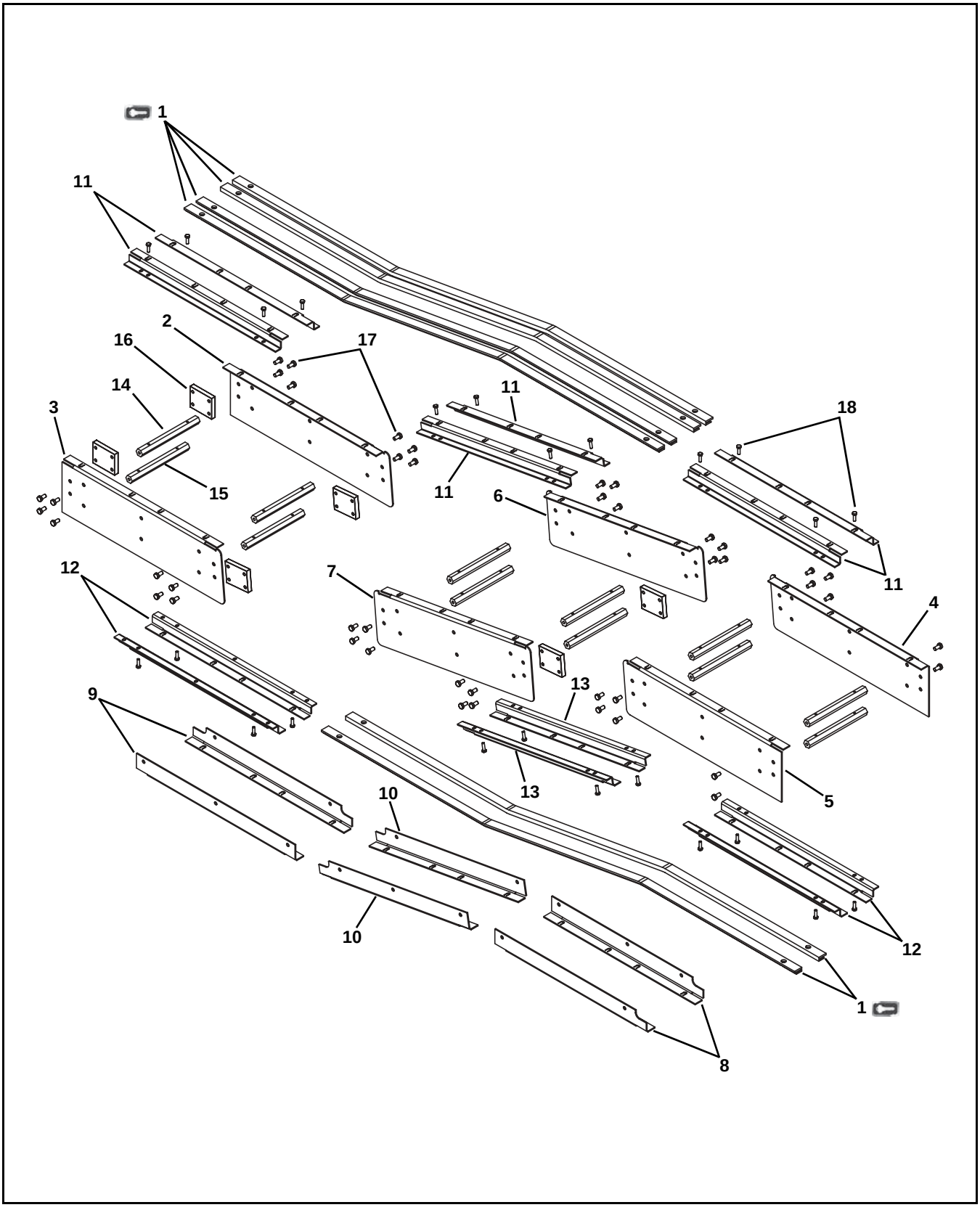
Curve Frame Assembly



Item	Part Number	Description
1	514477-WW-AA	Inner Side Rail
	514875-WW-AA	Inner Side Rail with Keyhole Slots
2	514478-WW-AA	Outer Side Rail
	514874-WW-AA	Outer Side Rail with Keyhole Slots
3	514462-WW-T	Hex Bar
4	514479-TOP	Top Post
5	514479-BOT	Bottom Post
6	514480-WW-AA	Inner Wear Strip for 45° & 90° curves
	514858-WW-180	Inner Wear Strip #1 for 180° curves
	514859-WW-180	Inner Wear Strip #2 for 180° curves
7	514481-WW-AA	Outer Wear Strip for 45° & 90° curves
	514860-WW-180	Outer Wear Strip #1 for 180° curves
	514861-WW-180	Outer Wear Strip #2 for 180° curves
8	514471	Connecting Plate
9	960645MSS	Hex Head Cap Screw, M6-1.00 x 45 mm
10	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
11	74-CK-WWW-AAA	Corner Kit Includes Items 6 & 7
WW = Conveyor width reference: 04, 07, 10, 12		
AA = Conveyor curve angle reference: 45, 90, 180		
WWW = Conveyor width reference: 045, 075, 100, 120		
AAA = Conveyor curve angle reference: 045, 090, 180		

Service Parts

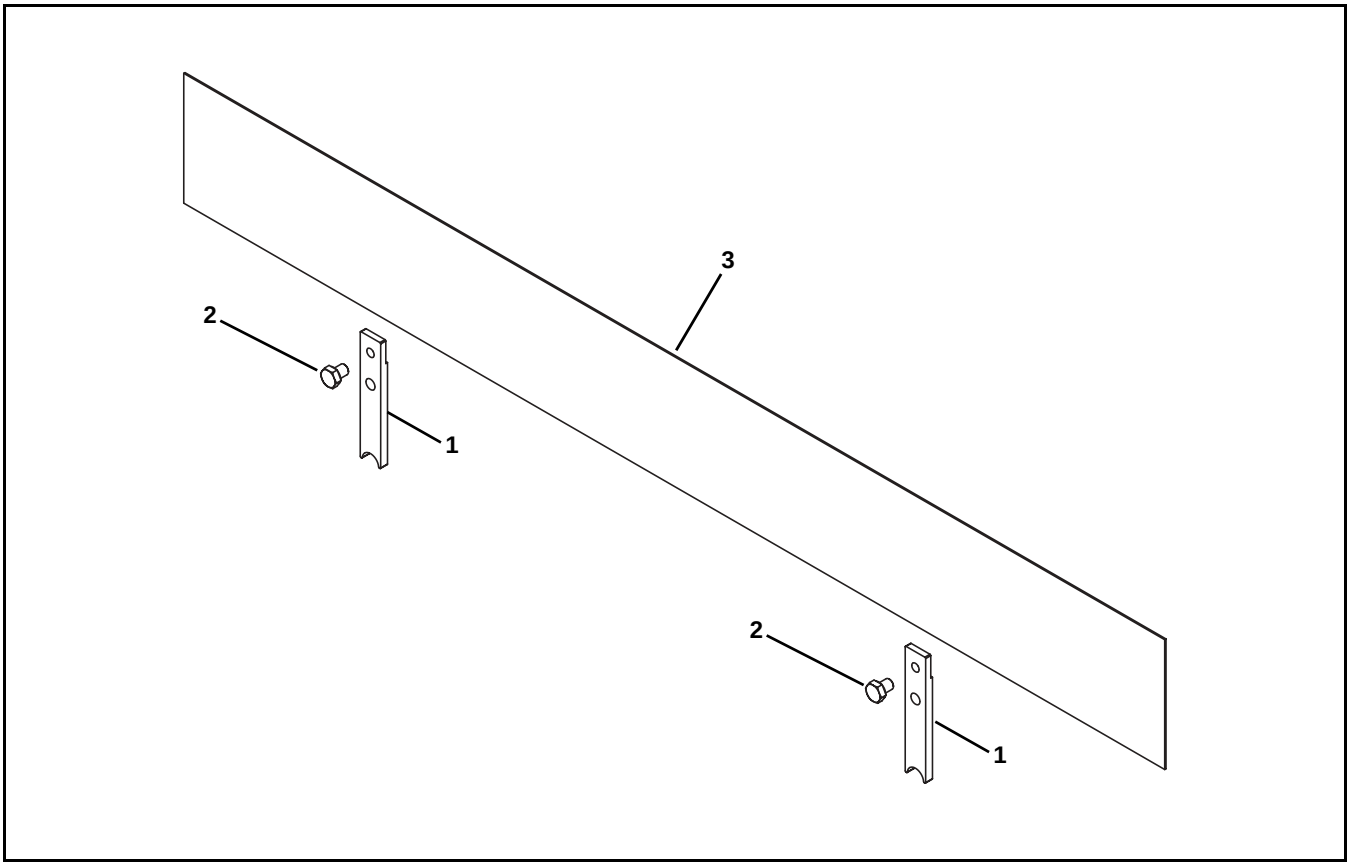
Knuckle Frame Assembly



Item	Part Number	Description
1	807-2456	Wear Strip 1" (per foot) used on all width Conveyors
	807-2457	Wear Strip 2" (per foot) used on 10" wide Conveyors
	807-2458	Wear Strip 3" (per foot) used on 12" wide Conveyors
2	514524-WW-AA-LLLL	Lower Knuckle Side Rail - Side 1
	514846-WW-AA-LLLL	Lower Knuckle Side Rail - Side 1 with Keyholes
3	514527-WW-AA-LLLL	Lower Knuckle Side Rail - Side 2
	514847-WW-AA-LLLL	Lower Knuckle Side Rail - Side 2 with Keyholes
4	514528-WW-AA-LLLL	Upper Knuckle Side Rail - Side 1
	514848-WW-AA-LLLL	Upper Knuckle Side Rail - Side 1 with Keyholes
5	514529-WW-AA-LLLL	Upper Knuckle Side Rail - Side 2
	514849-WW-AA-LLLL	Upper Knuckle Side Rail - Side 2 with Keyholes
6	514509-WW-AA-LLLL	Mid Knuckle Side Rail - Side 1
	514844-WW-AA-LLLL	Mid Knuckle Side Rail - Side 1 with Keyholes
7	514508-WW-AA-LLLL	Mid Knuckle Side Rail - Side 2
	514125-WW-AA-LLLL	Mid Knuckle Side Rail - Side 2 with Keyholes
8	514121-LLLL	L Plate used on 4.5" wide Conveyors only
9	514123-LLLL	L Plate used on 4.5" wide Conveyors only
10	514115-LLLL	L Plate for Mid Section used on 4.5" wide Conveyors only
11	514117-LLLL	Z-Strip used on 7.5", 10", & 12" wide Conveyors
12	514119-LLLL	Z-Strip used on 7.5", 10", & 12" wide Conveyors
13	514113-LLLL	Z-Strip for Mid Section used on 7.5", 10", & 12" wide Conveyors
14	514462-WW	Hex Bar
15	514462-WW-L	Lower Hex Bar used on 4.5" wide Conveyors only
	514462-WW	Lower Hex Bar used on 7.5", 10", & 12" wide Conveyors
16	514471	Connecting Plate
17	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm (x44)
18	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm used on 7.5", 10", & 12" wide Conveyors (x24)
WW= Conveyor width reference: 04, 07, 10, 12		
AA= Conveyor knuckle angle reference: 03-30 (3° - 30°)		
LLLL= Part length in inches with two decimal places		
Length Example: Length = 95.25" LLLLL = 09525		

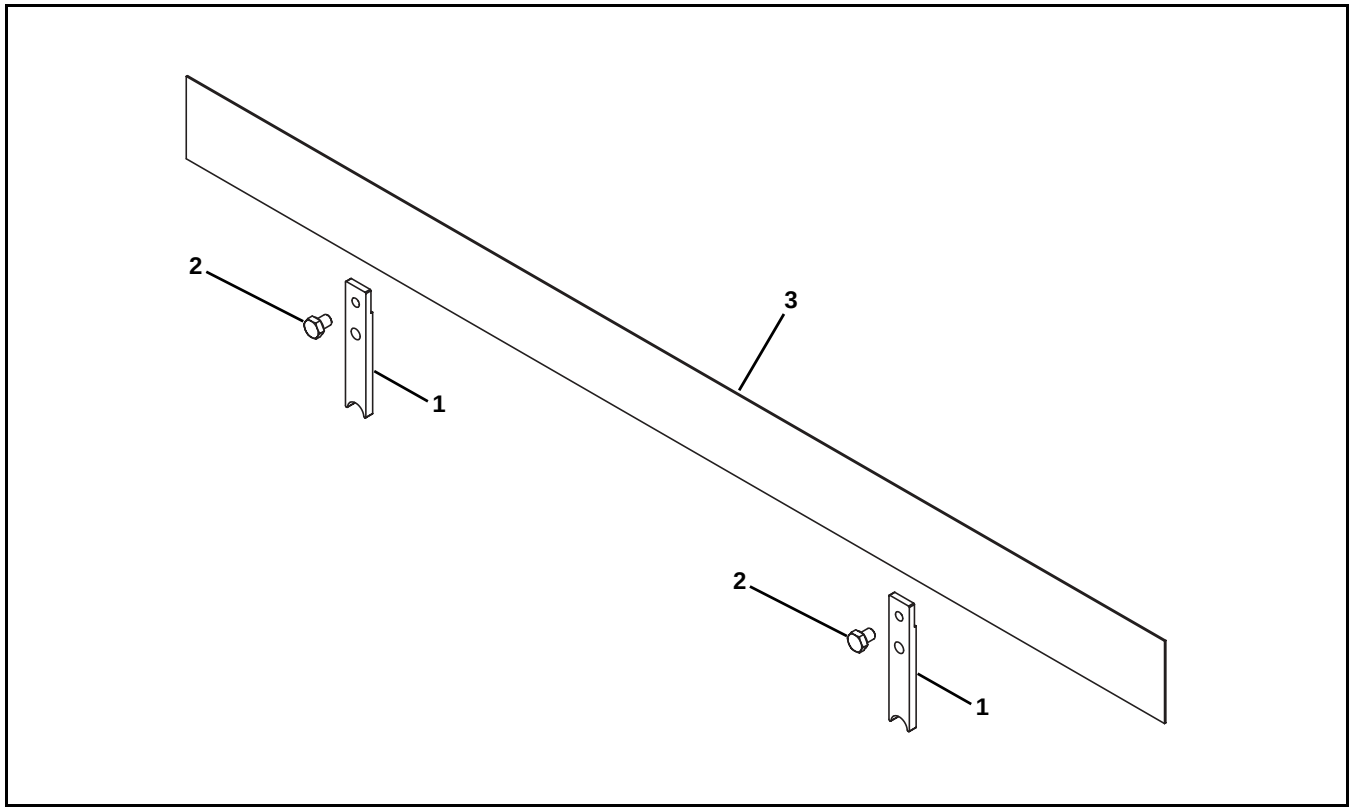
Service Parts

#04 3" High Side



Item	Part Number	Description
1	514857	Guide Clip
2	960810MSS	HexHead Cap Screw, M8-1.25 x 10 mm
3	204127-LLLLL	3" Guiding
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

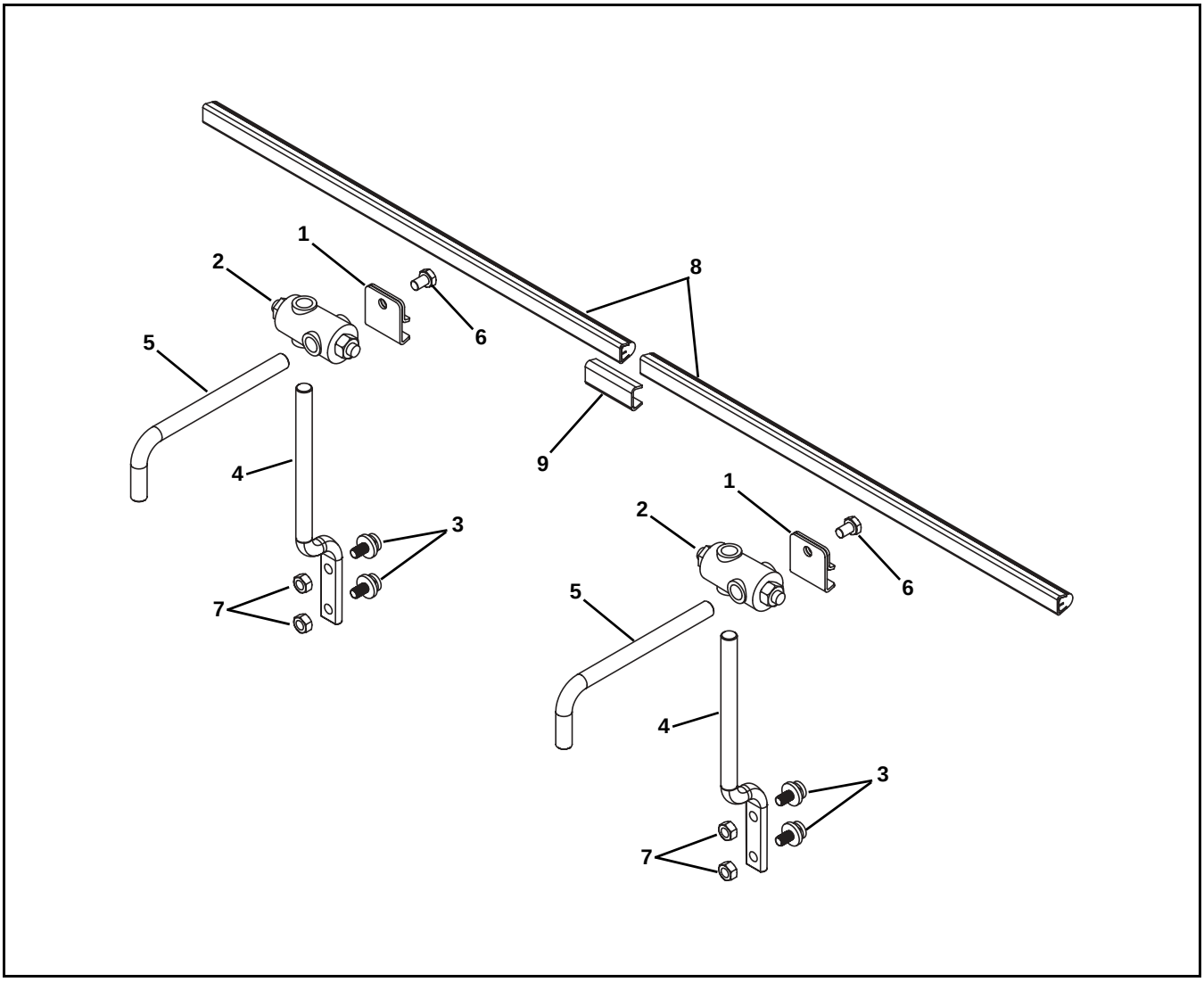
#05 1.50" High Side



Item	Part Number	Description
1	514857	Guide Clip
2	960810MSS	HexHead Cap Screw, M8-1.25 x 10 mm
3	514862-LLLLL	1.5" Guiding
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

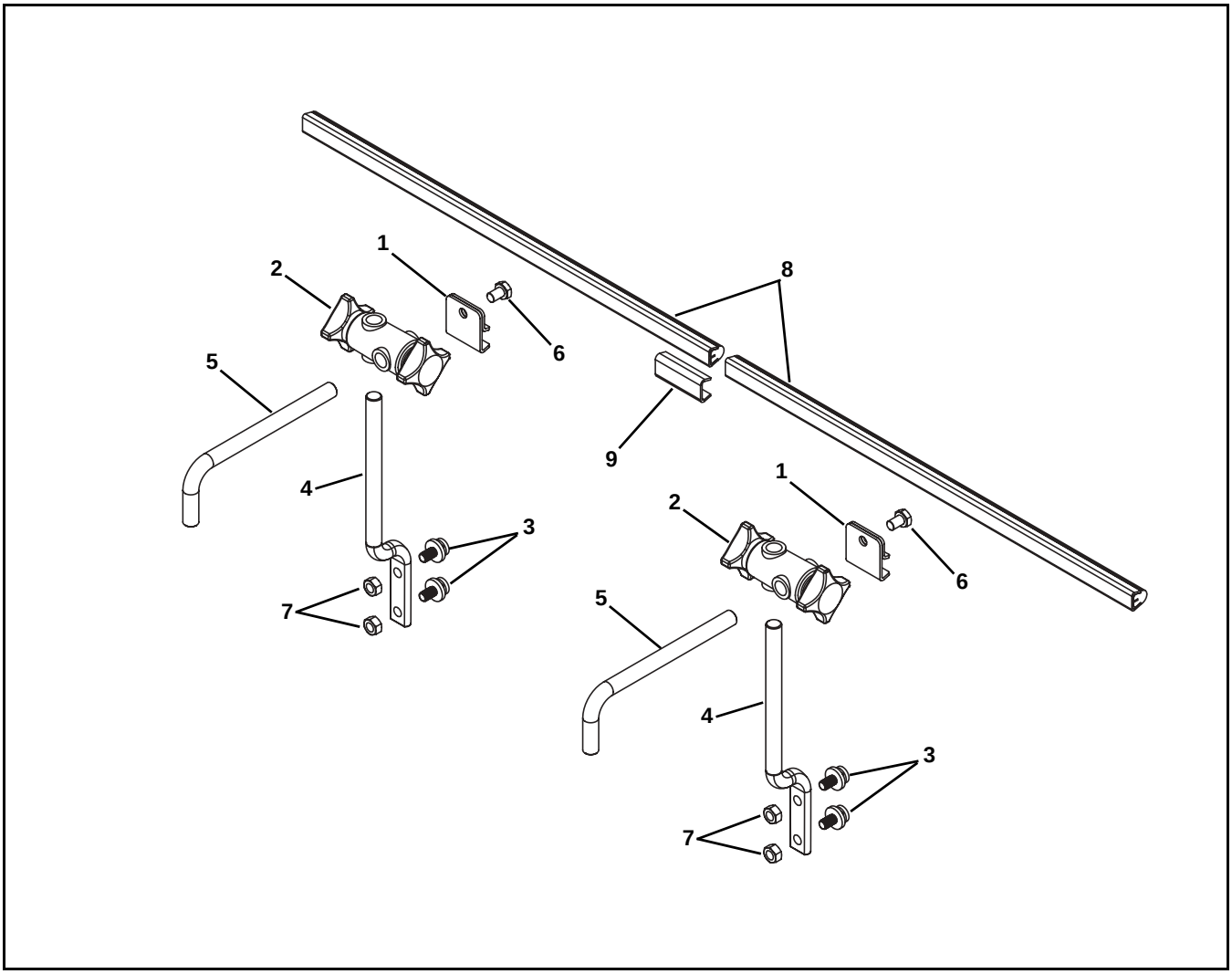
Service Parts

#13 Fully Adjustable Guiding



Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLL	Guiding for Straight Sections
	532258-LLLL	Guiding for Curve Sections
9	807-041	Guiding Splice
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

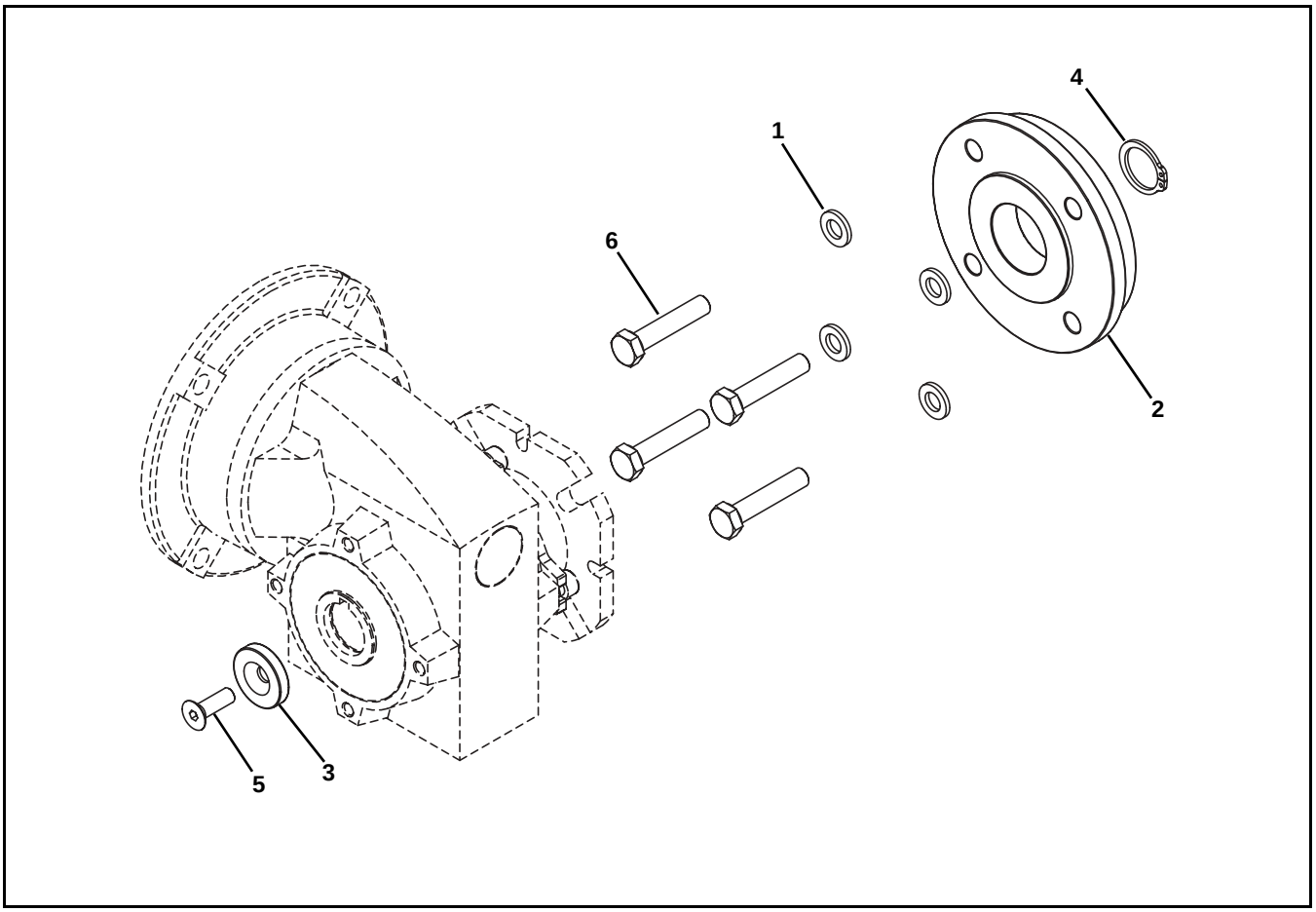
#14 Tool-Less Fully Adjustable Guiding



Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLL	Guiding for Straight Sections
	532258-LLLL	Guiding for Curve Sections
9	807-041	Guiding Splice
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

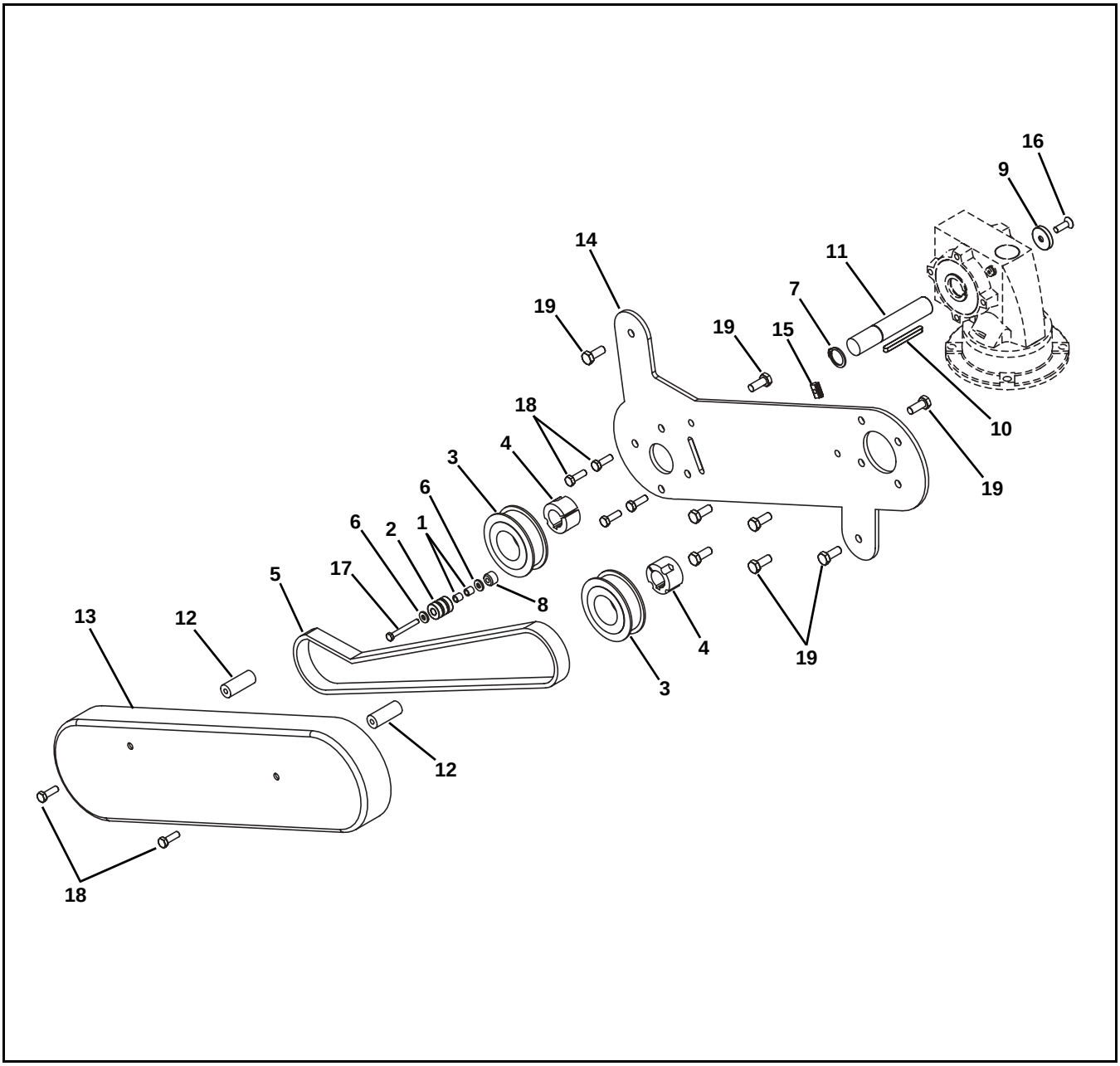
Service Parts

Side Drive Motor Mount



Item	Part Number	Description
1	807-1880	Washer
2	514469	Adapter
3	514498	Drive Shaft Clamp Washer
4	915-245	Retaining Ring
5	930825MSS	Flat Head Screw, M8-1.25 x 25 mm
6	961050MSS	Hex Head Cap Screw, M10-1.50 x 50 mm

Bottom Drive Motor Mount

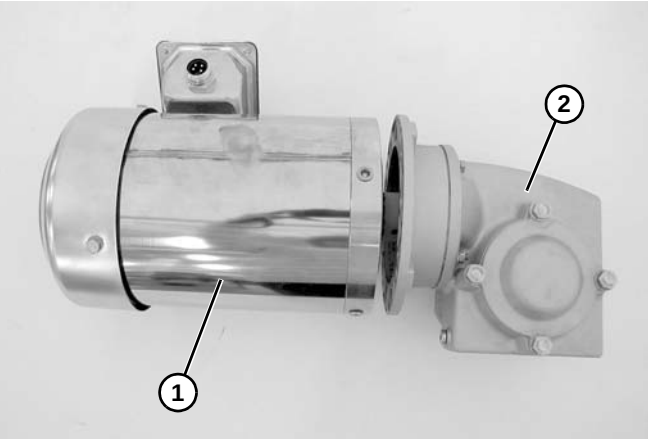


Item	Part Number	Description
1	801-139	Nylon Bearing
2	802-123	Bearing
3	811-571	Pulley 58 Tooth
4	811-578	Bushing
5	814-435	Timing Belt
6	911-201	Washer
7	915-245	Retaining Ring
8	456029	Spacer
9	514498	Drive Shaft Clamp Washer
10	514499	Key
11	514616	Shaft
12	514618	Spacer

Item	Part Number	Description
13	514619-A	Drive Cover for 'A' Position
	514619-D	Drive Cover for 'D' Position
14	514621	Bottom Mount Plate
15	6339971MSS	Drop-In Tee Bar
16	930825MSS	Flat Head Screw, M8-1.25 x 25 mm
17	960650MSS	Hex Head Cap Screw, M6-1.00 x 50 mm
18	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
19	961025MSS	Hex Head Cap Screw, M10-1.50 x 25 mm

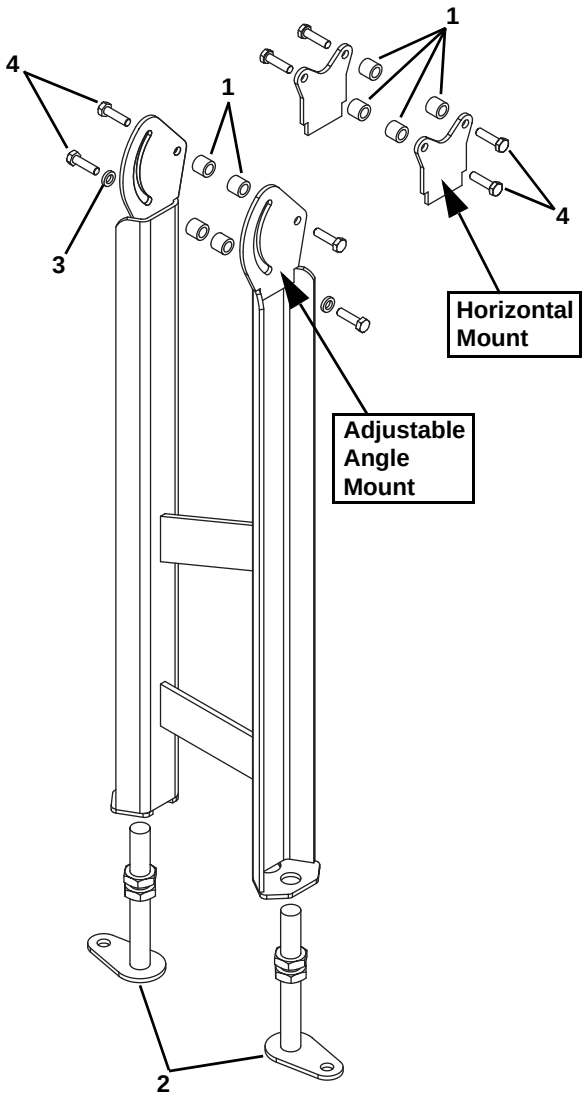
Service Parts

Gearmotors



Item	Part No.	Description
1	826-312	Painted Motor, 0.5 hp, 230/460 volts, 60 Hz, 3 phase
	826-354	Painted Motor, 1.0 hp, 208-230/460 volts, 60 Hz, 3 phase
	826-472	Painted Motor, 1.5 hp, 208-230/460 volts, 60 Hz, 3 phase
	826-431	Stainless Steel Motor, 0.5 hp, 230/460 volts, 60 Hz, 3 phase
	826-466	Stainless Steel Motor, 1.0 hp, 208-230/460 volts, 60 Hz, 3 phase
	826-464	Stainless Steel Motor, 1.5 hp, 208-230/460 volts, 60 Hz, 3 phase
2	820-735	Gear Reducer, 10:1, Nema 56C
	820-736	Gear Reducer, 15:1, Nema 56C
	820-737	Gear Reducer, 20:1, Nema 56C
	820-738	Gear Reducer, 30:1, Nema 56C
	820-739	Gear Reducer, 40:1, Nema 56C
	820-740	Gear Reducer, 60:1, Nema 56C

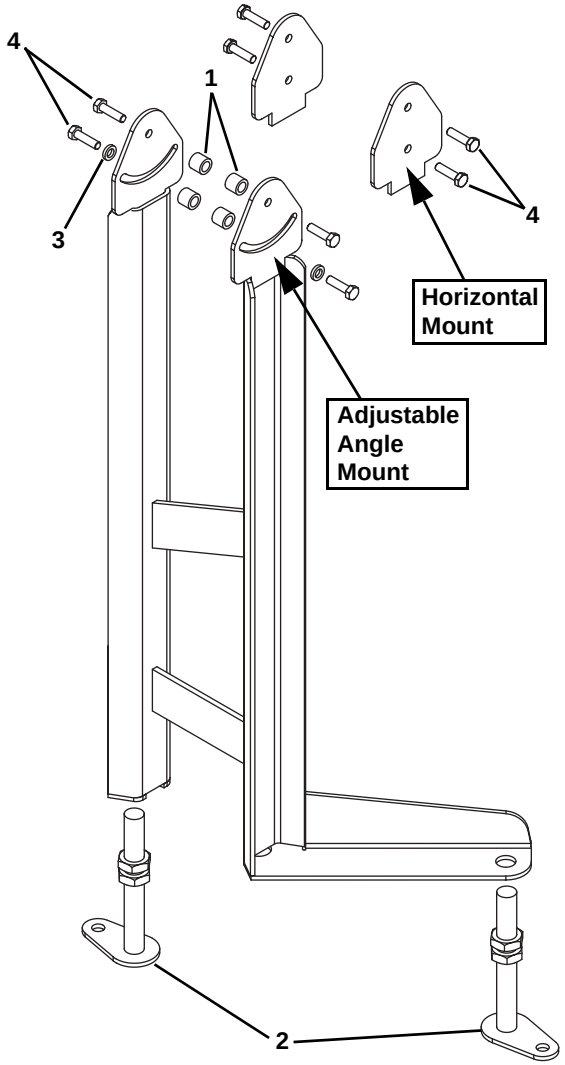
Conveyor Mount Stand



Item	Part No.	Description
1	352314	Spacer
2	532036	Foot Assembly
3	911-223	Washer
4	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		
WW = Conveyor width reference: 04, 07, 10, 12		

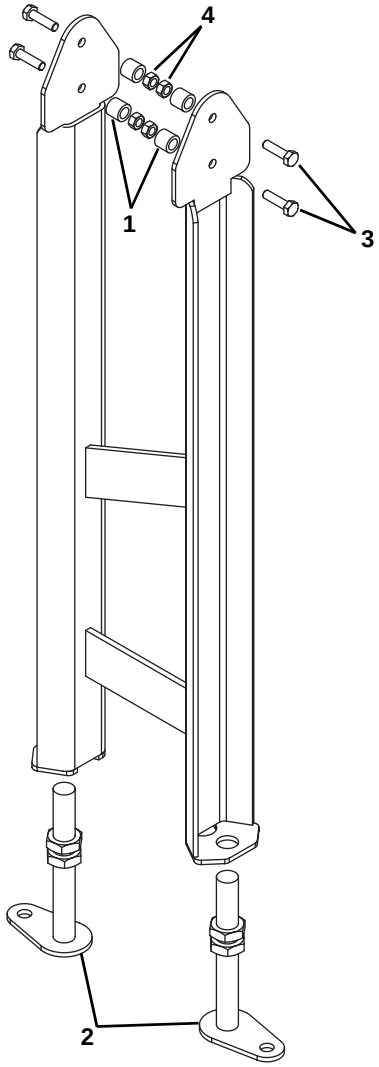
Service Parts

Drive Mount Stand



Item	Part No.	Description
1	352314	Spacer
2	532036	Foot Assembly
3	911-223	Washer
4	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		
WW = Conveyor width reference: 04, 07, 10, 12		

180° Curve Mount Stand



Item	Part No.	Description
1	352314	Spacer
2	532036	Foot Assembly
3	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
4	990801MSS	Hex Nut
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		
WW = Conveyor width reference: 04, 07, 10, 12		

Service Parts

Ordering a Replacement Chain

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

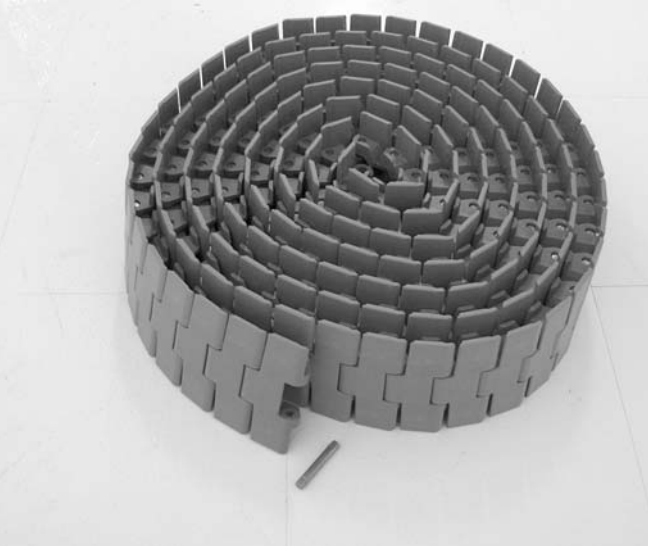
Example:

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

Order Qty (43) of 71-WWW/CC

WWW = Width (045, 075, 100, 120)

CC = Chain type (01=Low Friction, 08=Grip Top, 20=Roller Top)



Item	Part Number	Description
1	71-WWW/CC	Chain Repair Kit (Includes 1 ft (305 mm) of chain and assembly pins)
WWW = Width (045, 075, 100, 120)		
CC = Chain type (01=Low Friction, 08=Grip Top, 20=Roller Top		

Notes

Return Policy

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

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

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

<table>
<tr><th></th><th colspan="8">Product Type</th></tr>
<tr><th></th><th colspan="7">Standard Products</th><th>Engineered to order parts</th></tr>
<tr><th>Product Line</th><th>Conveyors</th><th>Gearmotors & Mounting Packages</th><th>Support Stands</th><th>Accessories</th><th>Spare Parts (non-belt)</th><th>Spare Belts - Standard Flat Fabric</th><th>Spare Belts - Cleated & Specialty Fabric</th><th>Spare Belts - Plastic Chain</th><th>All equipment and parts</th></tr>
<tr><td>1100</td><td colspan="6" rowspan="14">30% return fee for all products except:
50% return fee for conveyors with modular belt, cleated belt or specialty belts</td><td colspan="2" rowspan="15">non-returnable</td><td rowspan="15">case-by-case</td></tr>
<tr><td>2200</td></tr>
<tr><td>2200 Modular Belt</td></tr>
<tr><td>2200 Precision Move</td></tr>
<tr><td>2300</td></tr>
<tr><td>2300 Modular Belt</td></tr>
<tr><td>3200</td></tr>
<tr><td>3200 LPZ</td></tr>
<tr><td>3200 Precision Move</td></tr>
<tr><td>4100</td></tr>
<tr><td>5200</td></tr>
<tr><td>5300</td></tr>
<tr><td>6200</td></tr>
<tr><td>Controls</td></tr>
<tr><td>7200 / 7300</td><td colspan="6">50% return fee for all products</td></tr>
<tr><td>7350</td><td colspan="9" rowspan="4">non-returnable</td></tr>
<tr><td>7360</td></tr>
<tr><td>7400</td></tr>
<tr><td>7600</td></tr>
</table>

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

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

For a copy of Dorner's Warranty, contact 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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851-792 Rev. A

Printed in U.S.A.