



3200, 5200, and 5300 Series Bottom Mount Drive Package for Standard Load SEW 60 Hz Gearmotors

Installation, Maintenance & Parts Manual



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

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

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

For other service manuals visit our website at:
www.dorner.com/service_manuals.asp

Table of Contents

Introduction	2	Required Tools	7
Warnings - General Safety	3	Mounting	7
Product Description	4	Motor Wiring.....	9
Specifications	4	Preventive Maintenance and Adjustment	10
Gearmotor Mounting Package Models:.....	4	Required Tools	10
Table 1: Gearmotor Specifications	4	Timing Belt Tensioning.....	10
Table 2: Belt Speeds for 3200		Timing Belt Replacement.....	11
Fixed Speed 90° 60 Hz Gearmotors	5	Drive or Driven Pulley Replacement	12
Table 3: Belt Speeds for 3200		Gear Motor Replacement	12
Variable Speed 90° 60 Hz Gearmotors.....	5	Service Parts.....	14
Table 4: Belt Speeds for 5200 and 5300		Bottom Mount Drive Package for	
Fixed Speed 90° 60 Hz Gearmotors	6	90° SEW Gearmotors	14
Table 5: Belt Speeds for 5200 and 5300		90° SEW Gearmotors	15
Variable Speed 90° 60 Hz Gearmotors.....	6	Return Policy.....	16
Installation	7		

Introduction

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 3200 Series conveyors are covered by patent numbers 5156260, 5156261, 5203447, 5265714, 6871737, 6910571, 6971509, and patent applications in other countries.

Dorner LPZ Series conveyors are covered by patent numbers 5156260, 5156261, 5203447, 5265714, 5875883 and patent applications in other countries.

Dorner 5200 Series conveyors have patents pending.

Dorner's Limited Warranty applies.

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

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

Warnings - General Safety

WARNING

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

DANGER



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

DANGER



DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

WARNING



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



Exposed moving parts can cause severe injury.
REPLACE ALL GUARDS BEFORE RUNNING CONVEYOR.

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.

Product Description

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

- | | |
|---|-----------------------|
| 1 | Conveyor |
| 2 | Cover |
| 3 | Driven Pulley |
| 4 | Timing Belt |
| 5 | Drive Pulley |
| 6 | Gearmotor |
| 7 | Timing Belt Tensioner |
| 8 | Mounting Bracket |

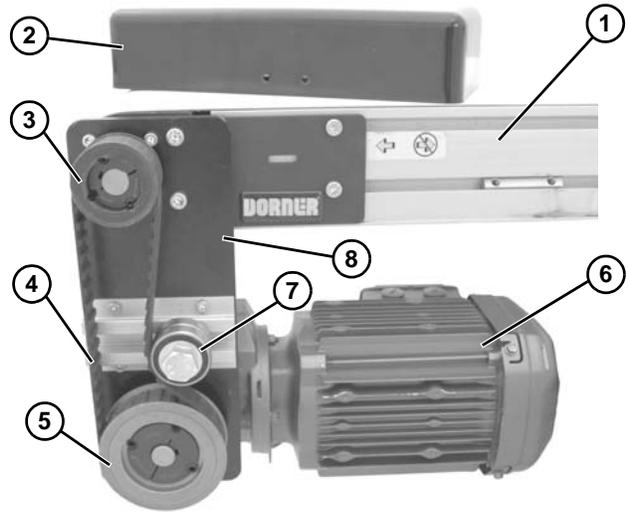


Figure 1

Specifications

Gearmotor Mounting Package Models:

Example:

32 M B W S A - 16 16

- Driven Pulley
- Drive Pulley
- Belt Type (- = flat belt, C = cleated belt)
- Mount Position = A, B, C or D (see detail to the right)
- Gearmotor Type: Standard Load
- Output Shaft Type = SEW
- Mount Style = Bottom Mount
- Language Code = U.S. English
- Product Series: 32 = 3200 Series
52 = 5200 Series
53 = 5300 Series

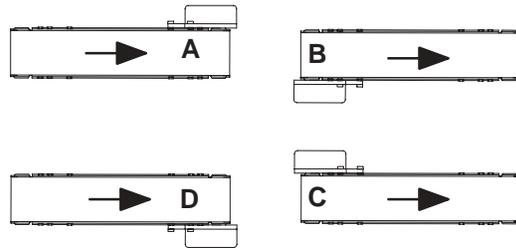


Table 1: Gearmotor Specifications

	Three Phase			VFD Vari Speed		
	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)
Output Power	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)
Input Voltage	230/460			230/460		
Input Frequency	60 Hz			10 to 60 Hz		
Input Current	1.84/0.92	2.50/1.25	2.90/1.44	1.84/0.92	2.50/1.25	2.90/1.44
RPM	47	134	264	8 to 47	22 to 134	44 to 264
Ratio	37.7:1	13.4:1	6.8:1	37.7:1	13.4:1	6.8:1
Motor Frame	IEC71	IEC71	IEC80	IEC71	IEC71	IEC80
Motor Type	IP54 Totally Enclosed Fan Cooled			IP54 Totally Enclosed Fan Cooled		

3200, 5200, and 5300 Series Bottom Mount Drive Package for Standard Load SEW 60 Hz Gearmotors

Specifications

Table 2: Belt Speeds for 3200 Fixed Speed 90° 60 Hz Gearmotors

Part Number	RPM	In-lb	N-m	Ft/min	M/min	Drive Pulley	Driven Pulley
32M038WS423EN	47	548	61.9	36.5	11.1	14	14
32M038WS423EN	47	548	61.9	41.0	12.5	18	16
32M038WS423EN	47	548	61.9	45.6	13.9	20	16
32M038WS423EN	47	548	61.9	50.1	15.3	22	16
32M038WS423EN	47	548	61.9	52.1	15.9	20	14
32M038WS423EN	47	548	61.9	54.7	16.7	24	16
32M038WS423EN	47	548	61.9	57.3	17.5	22	14
32M038WS423EN	47	548	61.9	62.5	19.1	24	14
32M013WS423EN	134	327	37.0	102.5	31.3	14	14
32M013WS423EN	134	327	37.0	115.4	35.2	18	16
32M013WS423EN	134	327	37.0	128.2	39.1	20	16
32M013WS423EN	134	327	37.0	141.0	43.0	22	16
32M013WS423EN	134	327	37.0	146.5	44.7	20	14
32M013WS423EN	134	327	37.0	153.8	46.9	24	16
32M013WS423EN	134	327	37.0	161.1	49.1	22	14
32M013WS423EN	134	327	37.0	175.8	53.6	24	14
32M007WS423EN	264	221	25.0	201.9	61.6	14	14
32M007WS423EN	264	221	25.0	227.1	69.2	18	16
32M007WS423EN	264	221	25.0	252.4	76.9	20	16
32M007WS423EN	264	221	25.0	277.6	84.6	22	16
32M007WS423EN	264	221	25.0	288.4	87.9	20	14
32M007WS423EN	264	221	25.0	302.9	92.3	24	16
32M007WS423EN	264	221	25.0	317.3	96.7	22	14
32M007WS423EN	264	221	25.0	346.1	105.5	24	14

Table 3: Belt Speeds for 3200 Variable Speed 90° 60 Hz Gearmotors

Part Number	RPM	In-lb	N-m	Ft/min (max)	Ft/min (min)	M/min (max)	M/min (min)	Drive Pulley	Driven Pulley
32M038WS423EN	47	548	61.9	36.5	6.1	11.1	1.9	14	14
32M038WS423EN	47	548	61.9	41.0	6.8	12.5	2.1	18	16
32M038WS423EN	47	548	61.9	45.6	7.6	13.9	2.3	20	16
32M038WS423EN	47	548	61.9	50.1	8.4	15.3	2.5	22	16
32M038WS423EN	47	548	61.9	52.1	8.7	15.9	2.6	20	14
32M038WS423EN	47	548	61.9	54.7	9.1	16.7	2.8	24	16
32M038WS423EN	47	548	61.9	57.3	9.5	17.5	2.9	22	14
32M038WS423EN	47	548	61.9	62.5	10.4	19.1	3.2	24	14
32M013WS423EN	134	327	37.0	102.5	17.1	31.3	5.2	14	14
32M013WS423EN	134	327	37.0	115.4	19.2	35.2	5.9	18	16
32M013WS423EN	134	327	37.0	128.2	21.4	39.1	6.5	20	16
32M013WS423EN	134	327	37.0	141.0	23.5	43.0	7.2	22	16
32M013WS423EN	134	327	37.0	146.5	24.4	44.7	7.4	20	14
32M013WS423EN	134	327	37.0	153.8	25.6	46.9	7.8	24	16
32M013WS423EN	134	327	37.0	161.1	26.9	49.1	8.2	22	14
32M013WS423EN	134	327	37.0	175.8	29.3	53.6	8.9	24	14
32M007WS423EN	264	221	25.0	201.9	33.7	61.6	10.3	14	14
32M007WS423EN	264	221	25.0	227.1	37.9	69.2	11.5	18	16
32M007WS423EN	264	221	25.0	252.4	42.1	76.9	12.8	20	16
32M007WS423EN	264	221	25.0	277.6	46.3	84.6	14.1	22	16
32M007WS423EN	264	221	25.0	288.4	48.1	87.9	14.7	20	14
32M007WS423EN	264	221	25.0	302.9	50.5	92.3	15.4	24	16
32M007WS423EN	264	221	25.0	317.3	52.9	96.7	16.1	22	14
32M007WS423EN	264	221	25.0	346.1	57.7	105.5	17.6	24	14

Specifications

Table 4: Belt Speeds for 5200 and 5300 Fixed Speed 90° 60 Hz Gearmotors

Part Number	RPM	In-lb	N-m	Ft/min	M/min	Drive Pulley	Driven Pulley
32M038WS423EN	47	548	61.9	47.0	14.3	14	14
32M038WS423EN	47	548	61.9	52.9	16.1	18	16
32M038WS423EN	47	548	61.9	58.8	17.9	20	16
32M038WS423EN	47	548	61.9	64.6	19.7	22	16
32M038WS423EN	47	548	61.9	67.1	20.5	20	14
32M038WS423EN	47	548	61.9	70.5	21.5	24	16
32M038WS423EN	47	548	61.9	73.9	22.5	22	14
32M038WS423EN	47	548	61.9	80.6	24.6	24	14
32M013WS423EN	134	327	37.0	134.0	40.9	14	14
32M013WS423EN	134	327	37.0	150.8	46.0	18	16
32M013WS423EN	134	327	37.0	167.5	51.1	20	16
32M013WS423EN	134	327	37.0	184.3	56.2	22	16
32M013WS423EN	134	327	37.0	191.4	58.4	20	14
32M013WS423EN	134	327	37.0	201.0	61.3	24	16
32M013WS423EN	134	327	37.0	210.6	64.2	22	14
32M013WS423EN	134	327	37.0	229.7	70.0	24	14
32M007WS423EN	264	221	25.0	264.0	80.5	14	14

Table 5: Belt Speeds for 5200 and 5300 Variable Speed 90° 60 Hz Gearmotors

Part Number	RPM	In-lb	N-m	Ft/min (max)	Ft/min (min)	M/min (max)	M/min (min)	Drive Pulley	Driven Pulley
32M038WS423EN	47	548	61.9	47.0	7.8	14.3	2.4	14	14
32M038WS423EN	47	548	61.9	52.9	8.8	16.1	2.7	18	16
32M038WS423EN	47	548	61.9	58.8	9.8	17.9	3.0	20	16
32M038WS423EN	47	548	61.9	64.6	10.8	19.7	3.3	22	16
32M038WS423EN	47	548	61.9	67.1	11.2	20.5	3.4	20	14
32M038WS423EN	47	548	61.9	70.5	11.8	21.5	3.6	24	16
32M038WS423EN	47	548	61.9	73.9	12.3	22.5	3.8	22	14
32M038WS423EN	47	548	61.9	80.6	13.4	24.6	4.1	24	14
32M013WS423EN	134	327	37.0	134.0	22.3	40.9	6.8	14	14
32M013WS423EN	134	327	37.0	150.8	25.1	46.0	7.7	18	16
32M013WS423EN	134	327	37.0	167.5	27.9	51.1	8.5	20	16
32M013WS423EN	134	327	37.0	184.3	30.7	56.2	9.4	22	16
32M013WS423EN	134	327	37.0	191.4	31.9	58.4	9.7	20	14
32M013WS423EN	134	327	37.0	201.0	33.5	61.3	10.2	24	16
32M013WS423EN	134	327	37.0	210.6	35.1	64.2	10.7	22	14
32M013WS423EN	134	327	37.0	229.7	38.3	70.0	11.7	24	14
32M007WS423EN	264	221	25.0	264.0	44.0	80.5	13.4	14	14

NOTE

For belt speed other than those listed, contact factory for details.

Required Tools

- Hex key wrenches:
2 mm, 2.5 mm, 3 mm, 5 mm
- Straight edge
- Torque wrench

Mounting

⚠ **WARNING**



Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Installation Component List:

1	Bottom Mount Assembly
2	Drive Pulley
3	Cover
4	Driven Pulley
5	M6 Socket Head Screws (4x)
6	M8 Socket Head Screws (2x)
7	Timing Belt

1. Typical components (**Figure 2**).

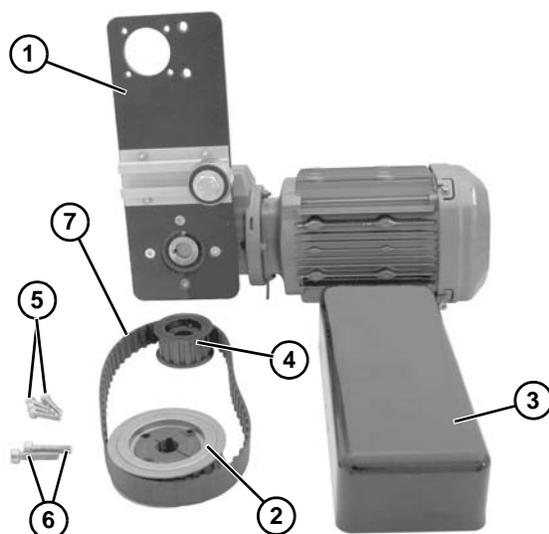


Figure 2

NOTE

*Gearmotor may be operated in positions 1, 3 or 4 (**Figure 3**).*

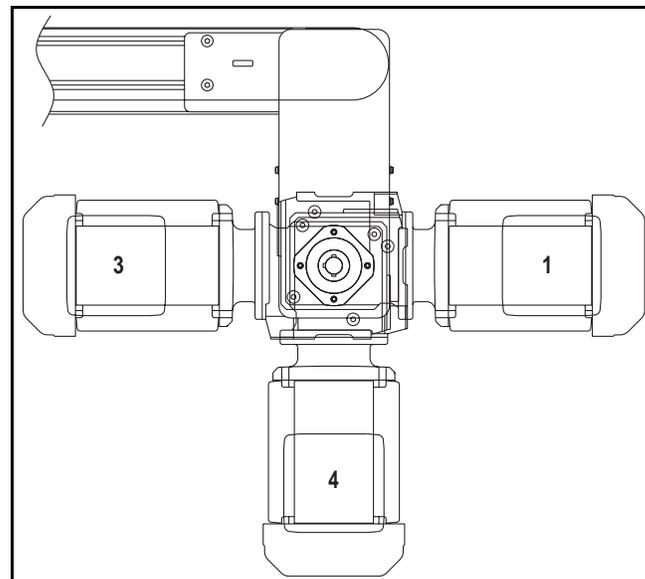


Figure 3

2. If required, change gearmotor position by removing four (4) screws (**Figure 4, item 1**). Rotate gearmotor to other position and replace screws (**Figure 4, item 1**). Tighten to 110 in-lb (12 Nm).

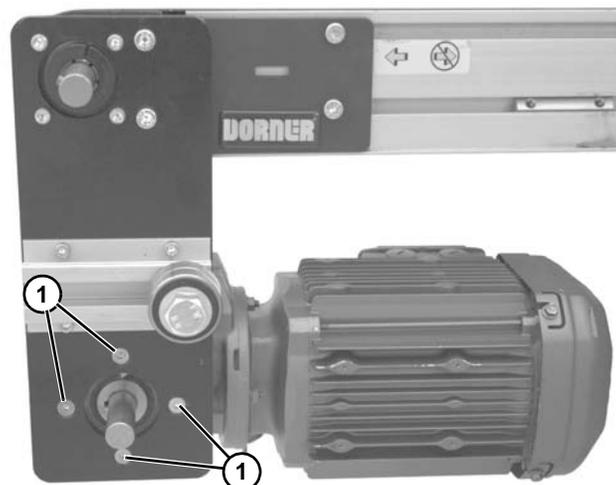


Figure 4

Installation

3. Locate drive output shaft (**Figure 5, item 1**). Remove two (2) M8 screws (**Figure 5, item 2**) and four (4) M6 screws (**Figure 5, item 3**) and discard.

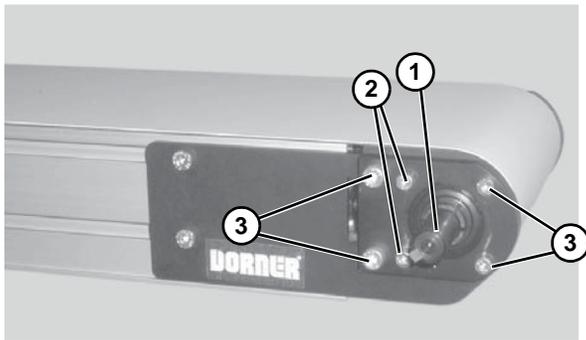


Figure 5

4. Attach mount assembly (**Figure 6, item 1**) with two (2) M8 screws (**Figure 6, item 2**) and four (4) M6 screws (**Figure 6, item 3**). Tighten M6 screws to 146 in-lbs (16.5 N-m) and M8 screws to 288 in-lbs (32.5 N-m).

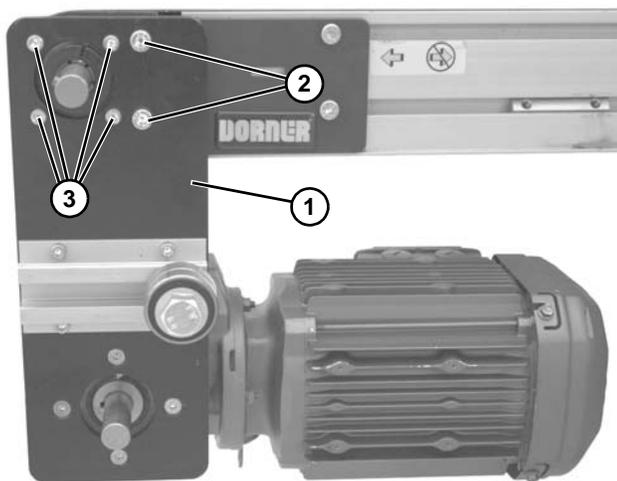


Figure 6

⚠ WARNING
Drive shaft keyway may be sharp. HANDLE WITH CARE.

5. Install key (**Figure 7, item 1**).

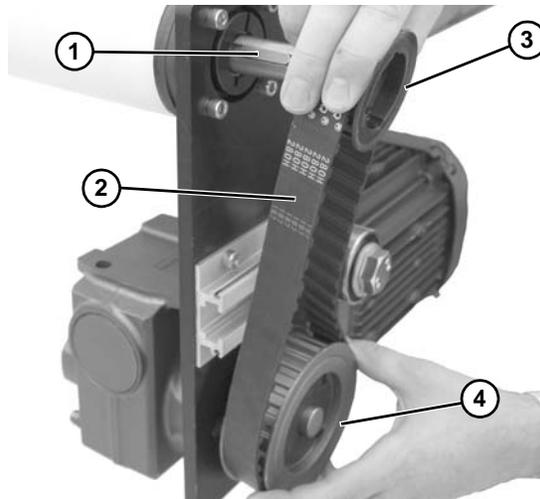


Figure 7

6. Wrap timing belt (**Figure 7, item 2**) around driven pulley (**Figure 7, item 3**) and drive pulley (**Figure 7, item 4**). Install driven pulley onto conveyor shaft.
7. Using a straight edge (**Figure 8, item 1**), align driven pulley (**Figure 8, item 2**) with drive pulley (**Figure 8, item 3**).

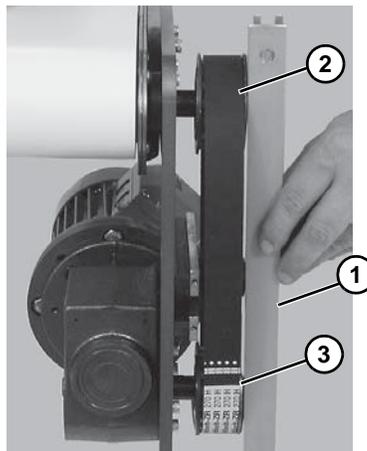


Figure 8

8. Tighten driven pulley taper-lock screws (**Figure 9, item 1**).

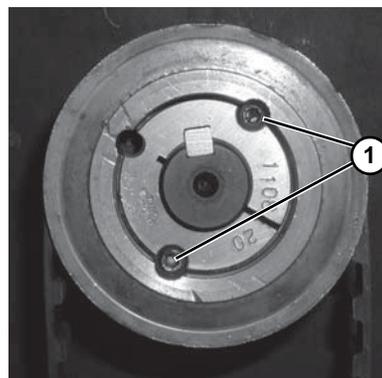


Figure 9

Installation

- Depending on conveyor belt travel (direction A or B), locate timing belt tensioner (**Figure 10, item 1**) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection for 6 lb (3 Kg) of force at timing belt mid-point (**Figure 10, item 2**). Tighten tensioner screw to 110 in-lb (12 Nm).

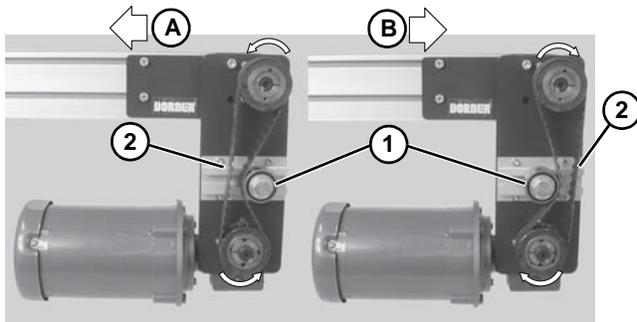


Figure 10

- Install cover (**Figure 11, item 1**) with four (4) screws (**Figure 11, item 2**). Tighten screws to 35 in-lb (4 Nm).

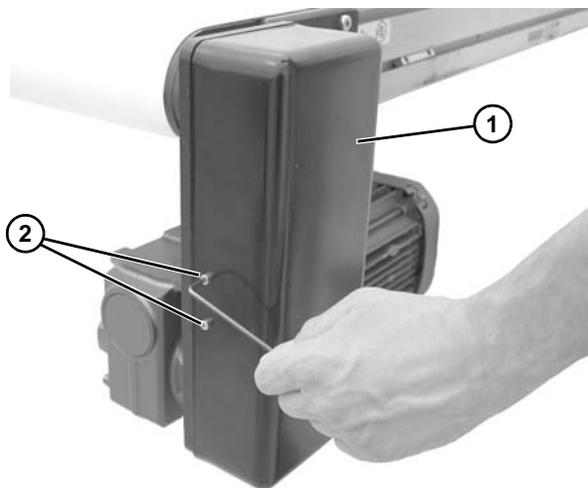


Figure 11

Motor Wiring

⚠ DANGER
<p>Hazardous voltage will cause severe injury or death. LOCK OUT POWER BEFORE WIRING.</p>
NOTE
<p><i>Lug terminals are recommended for wiring connections.</i></p>

- Remove cover (**Figure 12, item 1**).

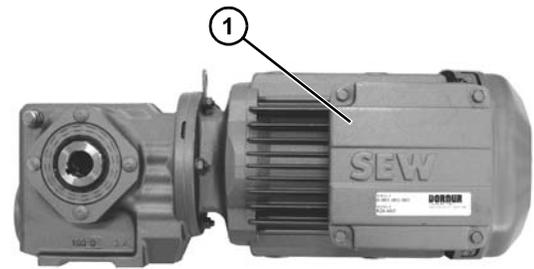


Figure 12

- To determine wiring configuration, refer to the inside of the motor cover (**Figure 13**).

NOTE
<p><i>Image of wiring diagram for reference only. See inside motor cover for motor specific instructions.</i></p>



Figure 13

- Install cord grip and power cord (**Figure 14, item 1**) mount to terminal box as required.

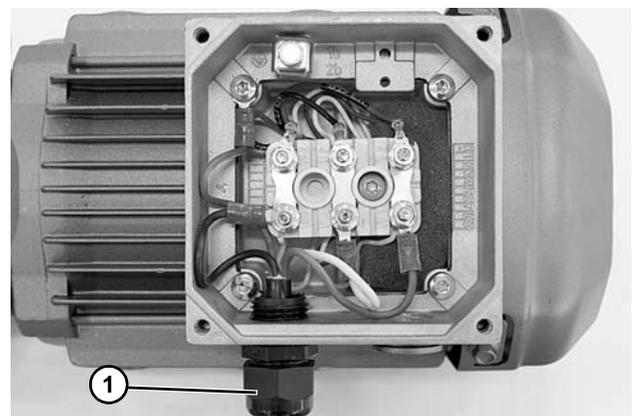


Figure 14

- Connect wires.
- Close cover.

Preventive Maintenance and Adjustment

Required Tools

- Hex key wrenches:
2 mm, 2.5 mm, 3 mm, 5 mm
- Adjustable wrench (for hexagon head screws)
- Straight edge
- Torque wrench

Timing Belt Tensioning

⚠ WARNING

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

1. Remove four (4) screws (**Figure 15, item 1**) and remove cover (**Figure 15, item 2**).

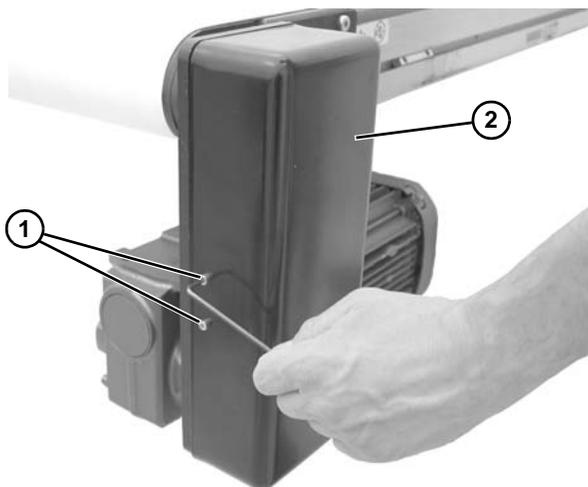


Figure 15

2. Loosen tensioner (**Figure 16, item 1**).

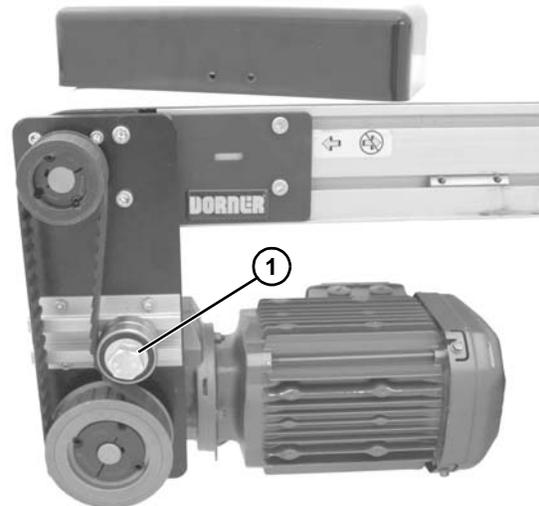


Figure 16

3. Depending on conveyor belt travel (direction A or B), locate timing belt tensioner (**Figure 17, item 1**) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection for 6 lb (3 Kg) of force at timing belt midpoint (**Figure 17, item 2**). Tighten tensioner screw to 110 in-lb (12 Nm).

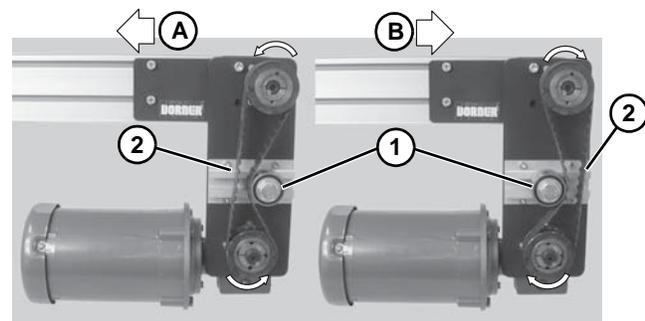


Figure 17

4. Install cover (**Figure 15, item 2**) with four (4) screws (**Figure 15, item 1**). Tighten screws to 35 in-lb (4 Nm).

Preventive Maintenance and Adjustment

Timing Belt Replacement

⚠ WARNING

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

1. Remove four (4) screws (Figure 18, item 1) and remove cover (Figure 18, item 2).

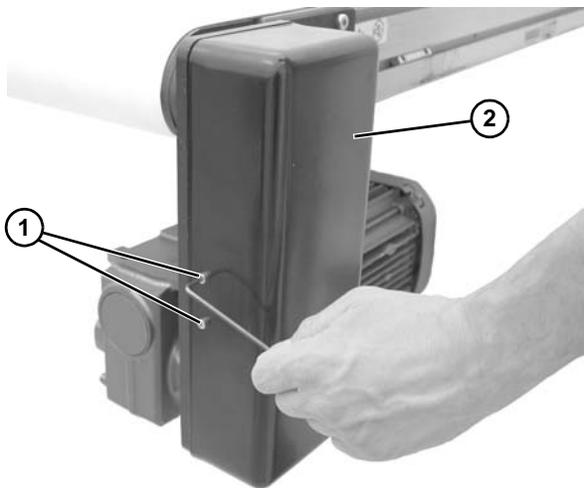


Figure 18

2. Loosen tensioner (Figure 19, item 1).

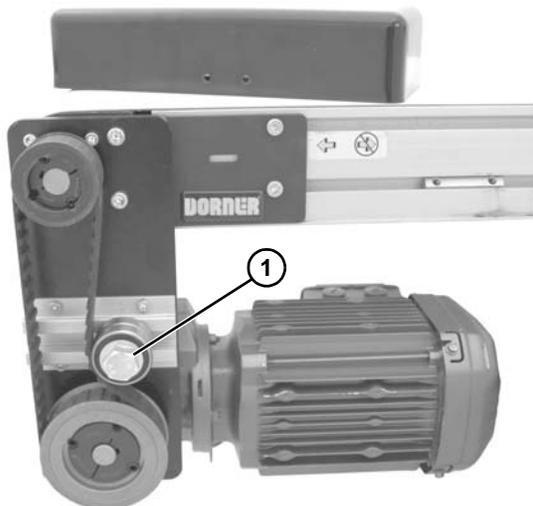


Figure 19

3. Remove timing belt (Figure 20, item 1).

NOTE
<p>If timing belt does not slide over pulley flange, loosen driven pulley taper-lock screws (Figure 20, item 2) and remove pulley with belt (Figure 20, item 1). For re-installation, see steps 6 thru 8 on beginning on page 8.</p>

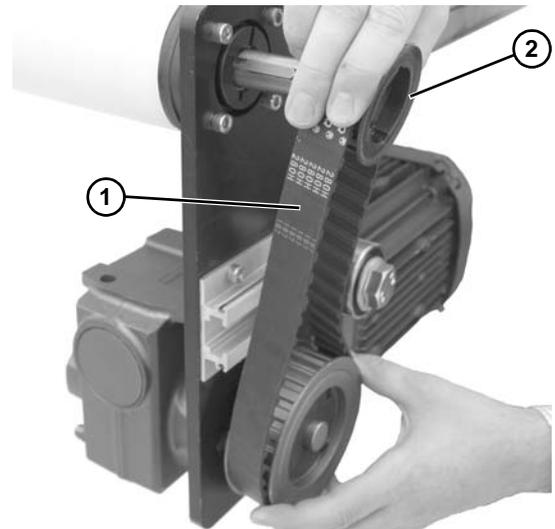


Figure 20

4. Install new timing belt.
5. Depending on conveyor belt travel (direction A or B), locate timing belt tensioner (Figure 21, item 1) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection for 6 lb (3 Kg) of force at timing belt midpoint (Figure 21, item 2). Tighten tensioner screw to 110 in-lb (12 Nm).

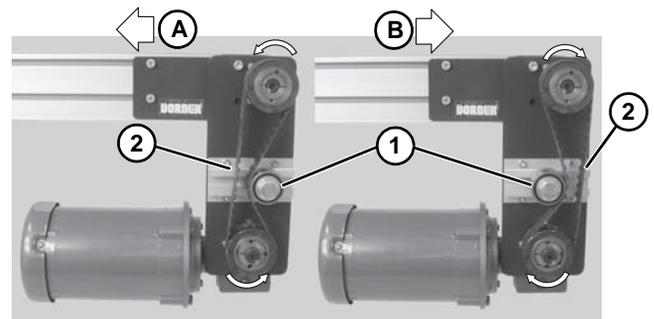


Figure 21

6. Install cover (Figure 18, item 2) with four (4) screws (Figure 18, item 1). Tighten screws to 35 in-lb (4 Nm).

Preventive Maintenance and Adjustment

Drive or Driven Pulley Replacement

⚠ WARNING



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

1. Complete steps 1 through 3 of “Timing Belt Replacement” section on page 11.
2. Remove taper-lock screws (**Figure 22, item 1**). Insert one (1) of taper lock screws in remaining hole (**Figure 22, item 2**). Tighten screw until pulley is loose. Remove pulley and taper hub assembly.

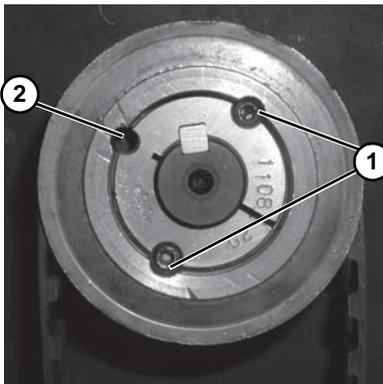


Figure 22

NOTE

If drive pulley (**Figure 27, item 1**) is replaced, wrap timing belt around drive pulley and complete step 3.

3. Complete steps 6 through 9 of “Installation” section beginning on page 8.

Gear Motor Replacement

⚠ WARNING



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

⚠ DANGER



Hazardous voltage will cause severe injury or death.
LOCK OUT POWER BEFORE WIRING.

1. Disconnect power and remove terminal box cover.
2. Record wire colors on terminals 1, 2 and 3 (**Figure 23, item 1**). Loosen terminals and remove wires.

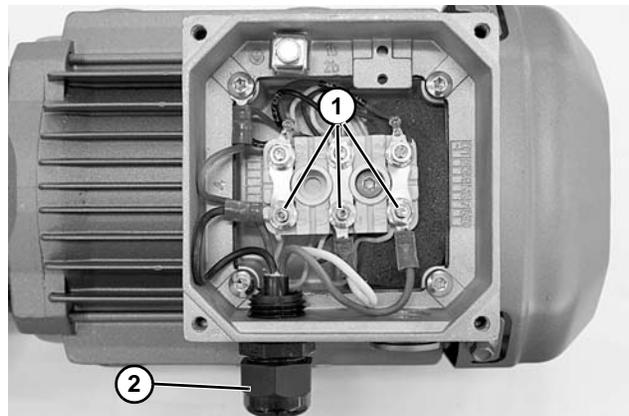


Figure 23

3. Loosen cord grip (**Figure 23, item 2**) and remove power cord.

Preventive Maintenance and Adjustment

4. Remove four (4) screws (Figure 24, item 1) and remove cover (Figure 24, item 2).

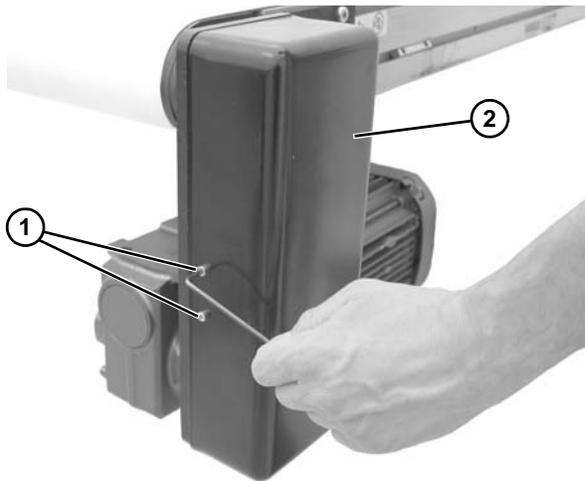


Figure 24

5. Loosen tensioner (Figure 25, item 1).

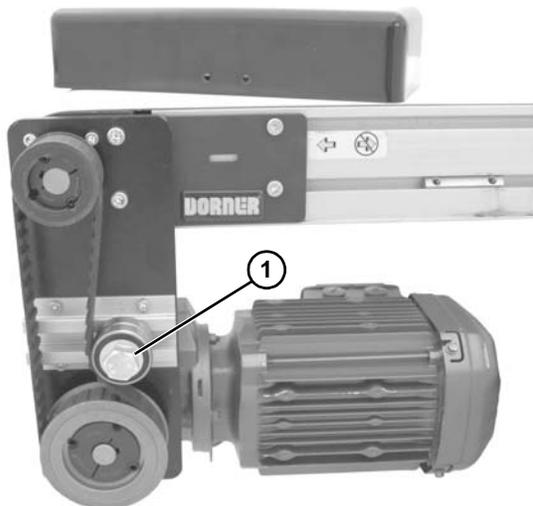


Figure 25

6. Loosen taper-lock screws (Figure 26, item 1) and remove drive pulley: Insert one (1) of taper lock screws in remaining hole (Figure 26, item 2). Tighten screw until pulley is loose.

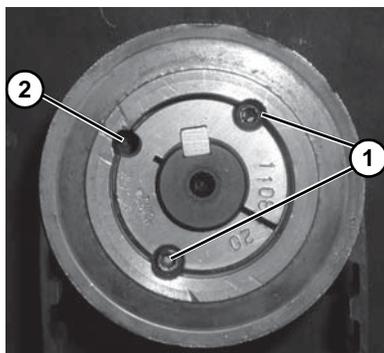


Figure 26

7. Remove pulley (Figure 27, item 1), taper hub assembly (Figure 27, item 2), and timing belt (Figure 27, item 3).

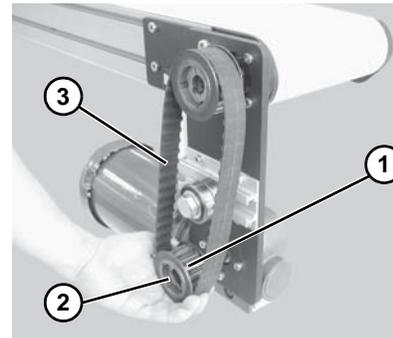


Figure 27

8. Remove four (4) gear motor mounting screws (Figure 28, item 1). Remove gearmotor.

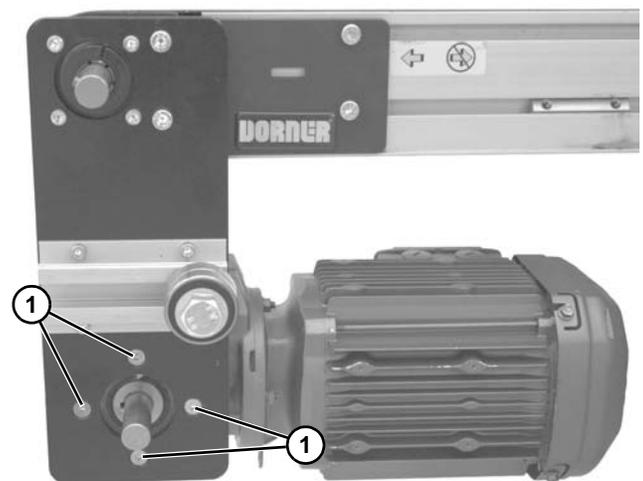


Figure 28

9. Install gearmotor to mounting bracket and tighten screws (Figure 28, item 1) to 110 in-lb (12 Nm).

NOTE

If drive pulley (Figure 27, item 1) is removed. Wrap timing belt around drive pulley and complete step 13.

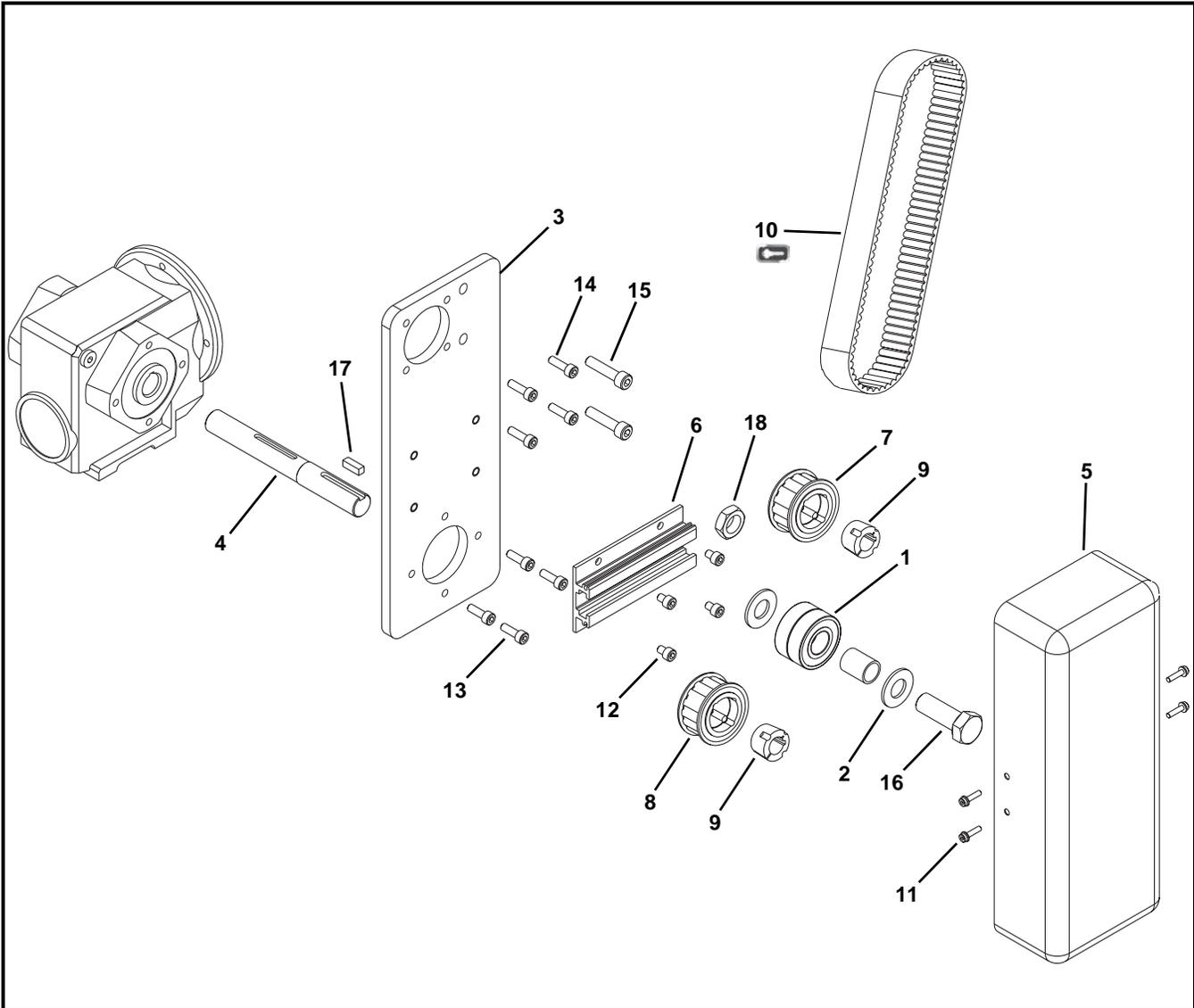
10. Complete steps 6 through 10 of "Installation" section beginning on page 8.

Service Parts

NOTE

For replacement parts other than those shown on this page, 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.

Bottom Mount Drive Package for 90° SEW Gearmotors

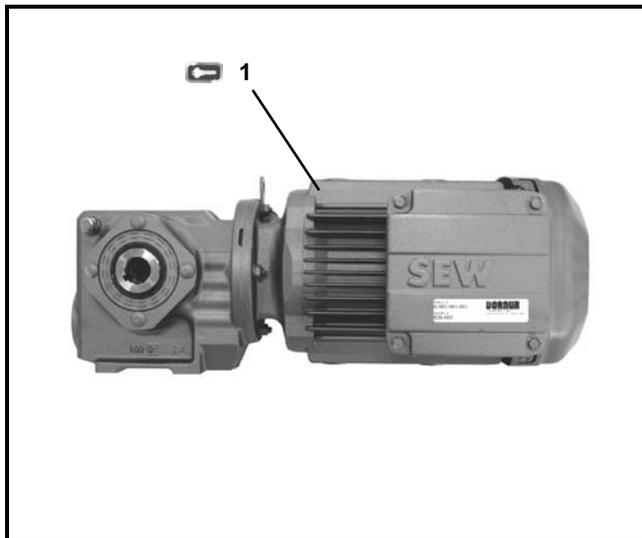


Service Parts

Item	Part Number	Description
1	301153	Tensioner Bearing Assy
2	911-013	Flat Washer
3	201678	Mounting Plate
4	201680	Output Shaft
5	300871	Drive Cover
6	301076	Drive Tensioner Slide
7	811-133	Driven Pulley, 14 Tooth Taper Lock TL1108
	811-126	Driven Pulley, 16 Tooth Taper Lock TL1108
8	811-133	Drive Pulley, 14 Tooth Taper Lock TL1108
	811-126	Drive Pulley, 16 Tooth Taper Lock TL1108
	811-127	Drive Pulley, 18 Tooth Taper Lock TL1210
	811-135	Drive Pulley, 20 Tooth Taper Lock TL1210
	811-136	Drive Pulley, 22 Tooth Taper Lock TL1610
	811-137	Drive Pulley, 24 Tooth Taper Lock TL1610

Item	Part Number	Description
9	811-288	Taper Lock Bushing, 20 MM, TL1108
	811-289	Taper Lock Bushing, 20 MM, TL1210
	811-290	Taper Lock Bushing, 20 MM, TL1610
10	814-125	Timing Belt, 1.0" Wide x 25.5" Long
	814-059	Timing Belt, 1.0" Wide x 27.0" Long
	814-060	Timing Belt, 1.0" Wide x 28.0" Long
	814-079	Timing Belt, 1.0" Wide x 30.0" Long
11	920408M	Socket Head Screw, M4-0.70 x 8 mm
12	920612M	Socket Head Screw, M6 - 1.00 x 12 mm
13	950616M	Low Head Cap Screw, M6 - 1.00 x 16 mm
14	920630M	Socket Head Screw, M6 - 1.00 x 30 mm
15	920835M	Socket Head Screw, M8 - 1.25 x 35 mm
16	961645M	Socket Head Screw, M16 - 2.00 x 45 mm
17	980630M	Square Key
18	991610M	Hex Jam Nut, M16

90° SEW Gearmotors



Item	Part Number	Description
1	32M038WS423EN	Gearmotor, 0.80 Hp (0.37 Kw), 230/460 Volts, 37.7:1
	32M013WS423EN	Gearmotor, 0.75 Hp (0.56 Kw), 230/460 Volts, 13.4:1
	32M007WS423EN	Gearmotor, 1.00 Hp (0.75 Kw), 230/460 Volts, 6.8:1

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.

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

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.

 <p>Dorner Mfg. Corp. reserves the right to change or discontinue products without notice. All products and services are covered in accordance with our standard warranty. All rights reserved. © Dorner Mfg. Corp. 2015</p>	<p>DORNER MFG. CORP. 975 Cottonwood Ave., PO Box 20 Hartland, WI 53029-0020 USA TEL 1-800-397-8664 (USA) FAX 1-800-369-2440 (USA) Internet: www.dorner.com</p>	<p>Outside the USA: TEL 1-262-367-7600 FAX 1-262-367-5827</p>
---	--	---