7350 Series End Drive Curved Conveyors

Installation, Maintenance and 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:
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851-678 Rev. H

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Introduction

⚠ CAUTION

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

Upon receipt of shipment:

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

The Dorner Limited Warranty applies.

Dorner 7350 Series conveyors have patents pending.

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

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

⚠ DANGER

SEVERE HAZARD!

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

⚠ DANGER

EXPLOSION HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

BURN HAZARD!

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

⚠ WARNING

PUNCTURE HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

Product Description

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

Typical Components	
1	Conveyor
2	Gearmotor
3	Belt
4	Support Stands
5	Drive End
6	Idler End

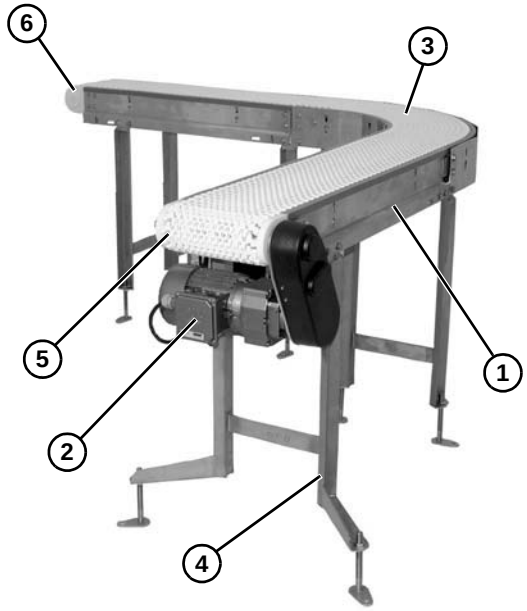


Figure 1

Specifications

Conveyor Width Reference (WW)	04 – 36 in 02 increments
Conveyor Belt Width	4" (102 mm) - 36" (914 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft^2 (97 kg/ m^2) with a maximum of 300 lbs. (136 kg)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	260 ft/minute (79 m/minute)

Conveyor Length Reference (LLL)	036 – 999 in 001 increments
Conveyor Length	36" (914 mm) - 999" (25.4 m) in 1" (25 mm) increments

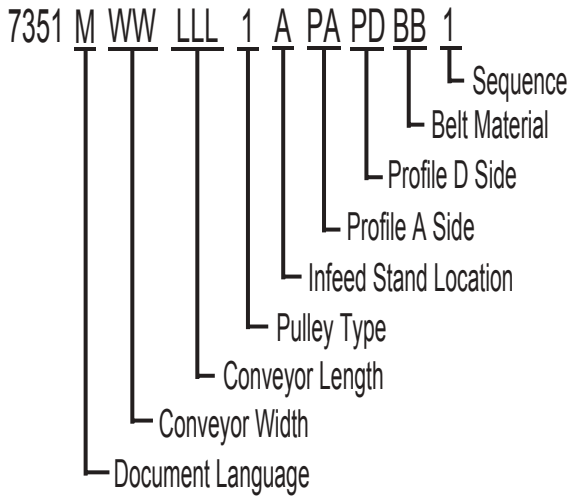
IMPORTANT

Maximum conveyor loads are based on:

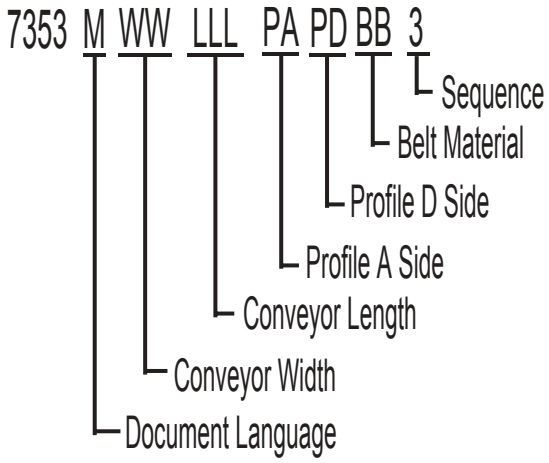
- *Non-accumulating product*
- *Product moving toward gearmotor*
- *Conveyor being mounted horizontally*
- *Conveyor being located in a dry environment*
- *Conveyor equipped with standard belt only*

7350 Series Curve Conveyor Modules

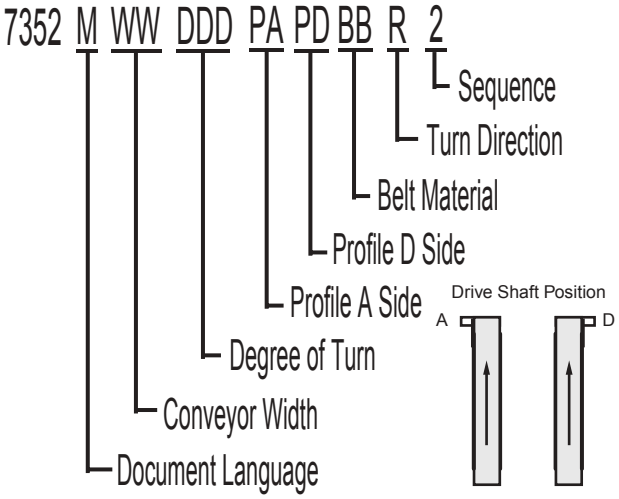
7350 Series Infeed / Idler Module



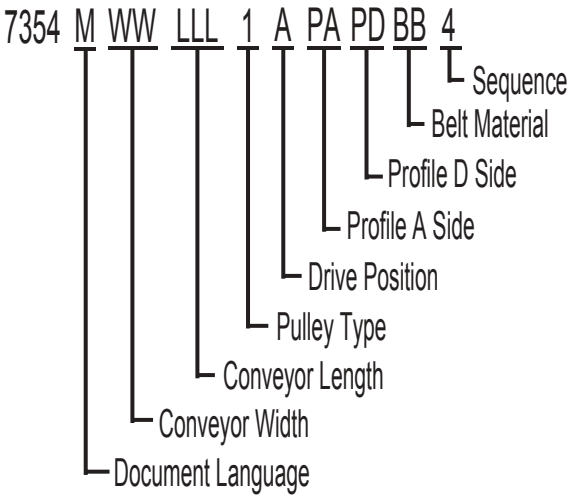
7350 Series Intermediate Module



7350 Series Curve Module



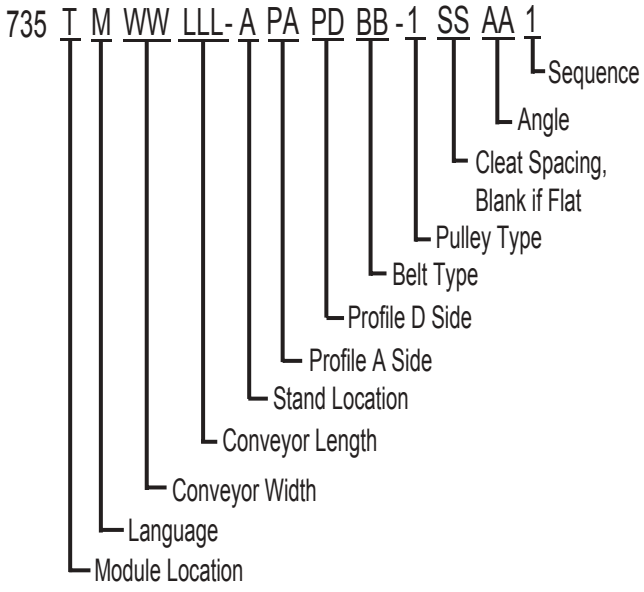
7350 Series Exit / Drive Module



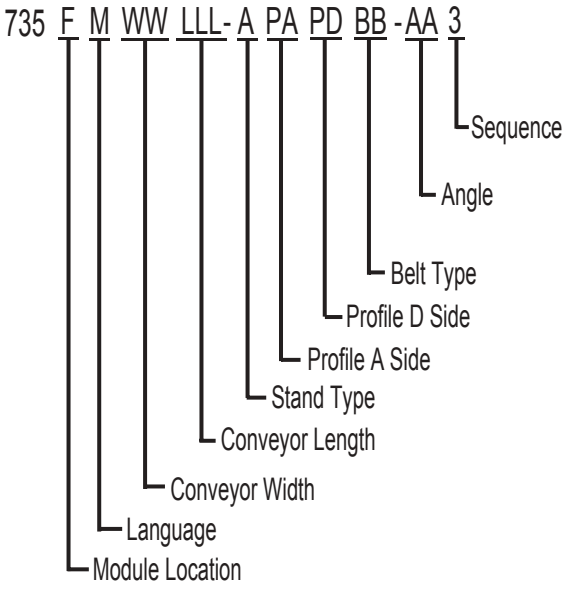
Specifications

7350 Series Z-Frame Conveyor Modules

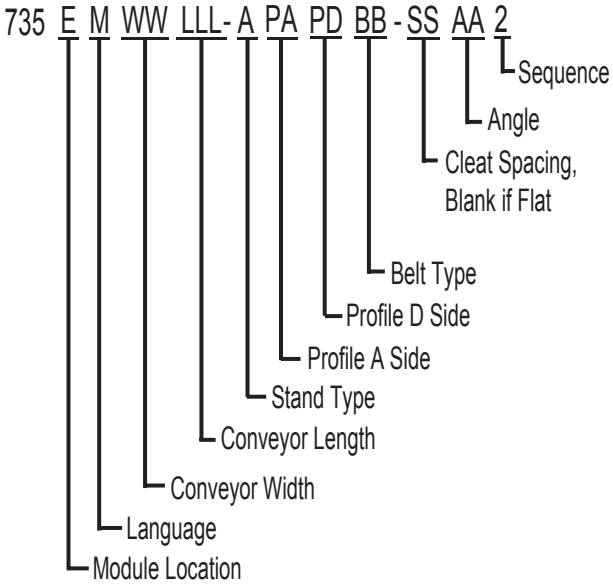
7350 Series Infeed Section to Knuckle



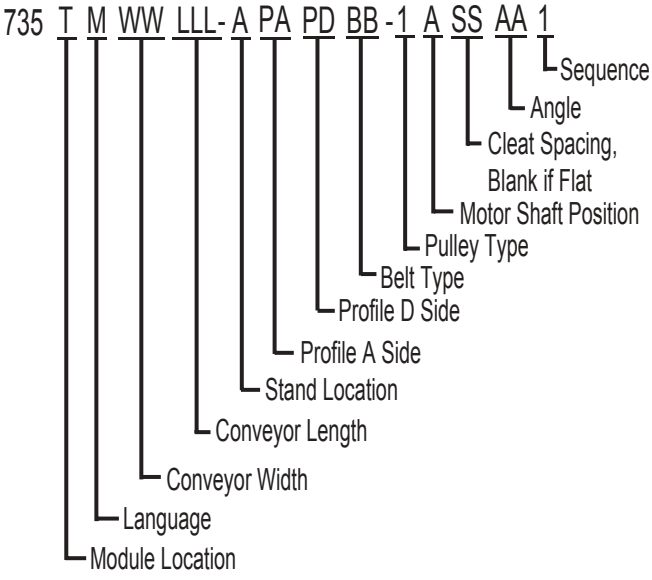
7350 Series Mid Section between Knuckle and Curve



7350 Series Mid Section between two Knuckles



7350 Series Discharge Section from Knuckle



Conveyor Supports

Infeed / Idler Module:

- "A" = 30" (762 mm) maximum **(See Figure 2)**
- Modules 24" - 47" long get 1 support stand
- All other lengths get 2 support stands, plus an additional support stand at each straight section break (over 13' straight frame module)

Intermediate Module:

- Modules 24" - 59" long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, plus an additional support stand at each straight section break (modules over 13')

Exit / Drive Module:

- "B" = 24" (510 mm) maximum **(See Figure 2)**
- Modules 24" - 47" long get 1 support stand
- All other lengths get 2 support stands, plus an additional support stand at each straight section break (modules over 13')

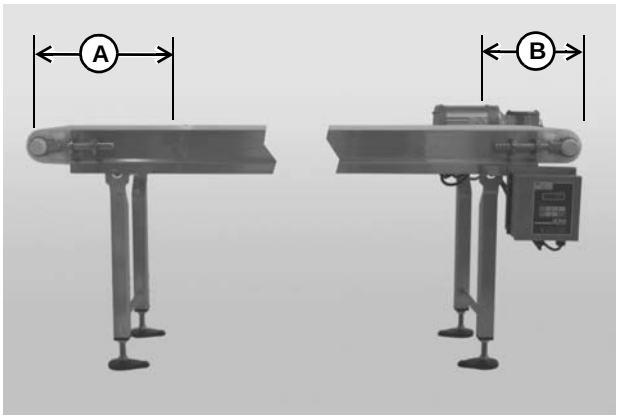


Figure 2

Curve Module:

- Reference chart below for support stand quantities:

Degree/Width	4"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"
45°	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
90°	0	0	0	0	1	1	1	1	1	1	1	1	1	1	1	1	1
135°	0	0	1	1	2	2	2	2	2	2	2	2	2	2	2	2	2
180°	0	0	1	1	3	3	3	3	3	3	3	3	3	3	3	3	3

Installation

⚠ CAUTION

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

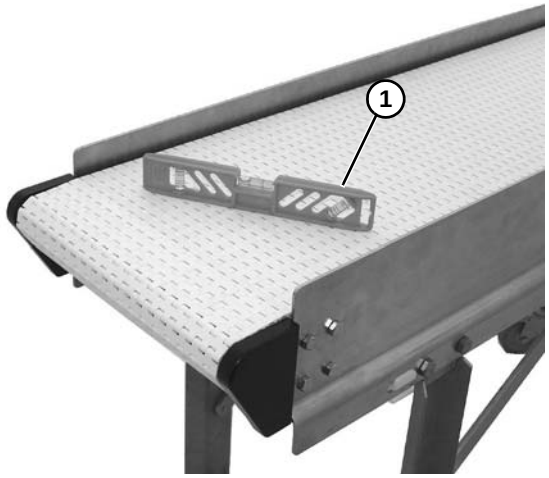


Figure 3

Required Tools

- Level
- Torque wrench
- 5/32” hex wrench (for bearings)
- 13 mm wrench (for tail assemblies)
- 14 mm wrench (for motor mounts)
- 17 mm wrench (for stands)

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to “Conveyors Longer than 10 ft (3048 mm)” on page 8 or “Belt Installation” on page 12.
2. Attach the stands. Refer to “Stand Installation” on page 11.
3. Install the belt. Refer to “Belt Installation” on page 12.
4. Install the gearmotor. Refer to “Drive Package Installation” on page 15.

Conveyors Longer than 10 ft (3048 mm)

Connecting Components

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

1	Connector Plate (x2)
2	Hex Head Cap Screw M10-1.50 x 12mm (x4)
3	Conveyor Frames

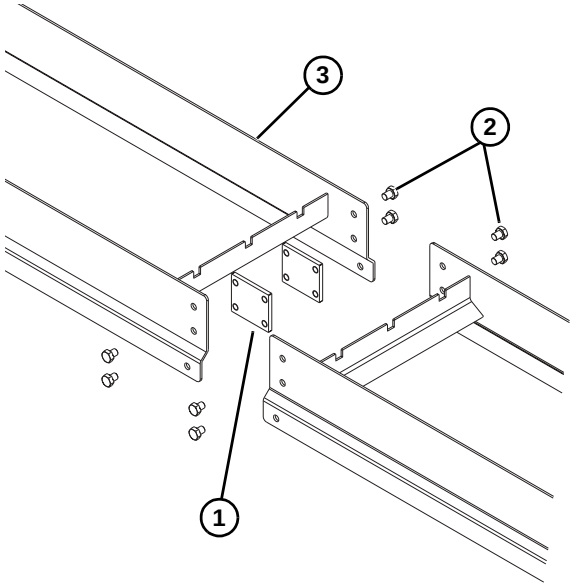


Figure 4

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

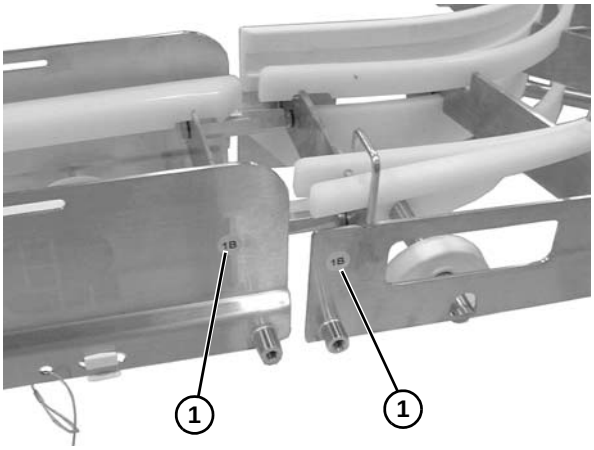


Figure 5

2. Join both conveyor sections, and install plate frame connectors **(Figure 4, item 1)**, and secure with M10x12 hex head cap screws **(Figure 4, item 2)** on both sides.

Z-Frame Conveyors

NOTE
Be sure all frame sections are properly supported during Z-Frame assembly.

Knuckles

Upper Knuckle

1. Attach upper knuckle **(Figure 6, item 1)** to frame **(Figure 6, item 2)** by using two cap screws **(Figure 6, item 3)** and connector plate **(Figure 7, item 1)** on each side of conveyor.

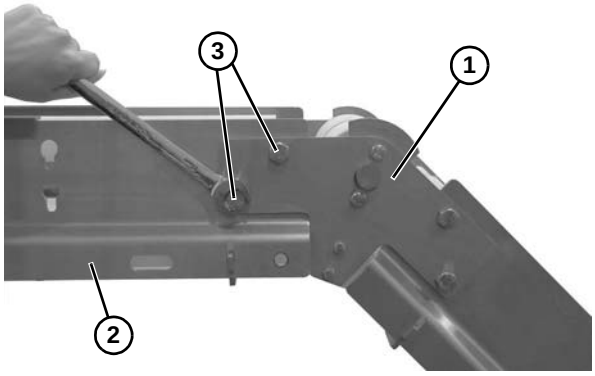


Figure 6

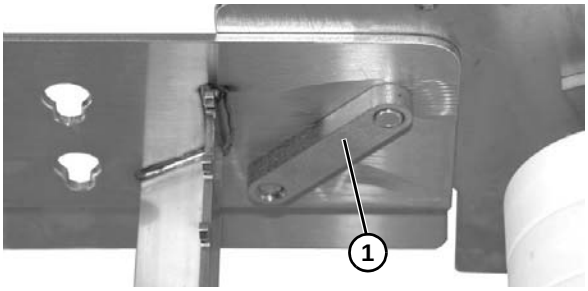


Figure 7

2. Attach bar cap **(Figure 8, item 1)** to frame and knuckle.

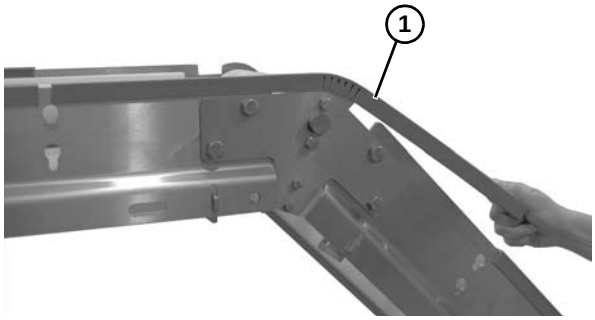


Figure 8

3. Tighten all cap screws to 60 in-lb (7 Nm).

Lower Knuckle

1. Attach lower knuckle **(Figure 9, item 1)** to frame **(Figure 9, item 2)** by using two cap screws **(Figure 9, item 3)** and connector plate **(Figure 10, item 1)** on each side of conveyor.

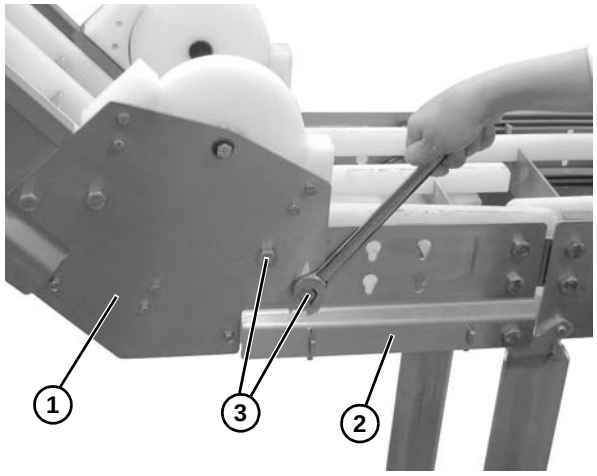


Figure 9

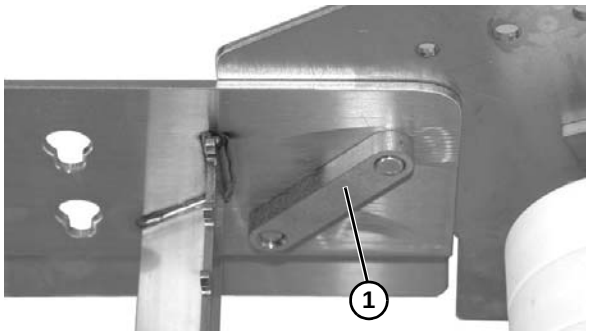


Figure 10

2. Tighten all cap screws to 60 in-lb (7 Nm).
3. Secure belt returns to lower knuckle with cap screw **(Figure 11, item 1)**.

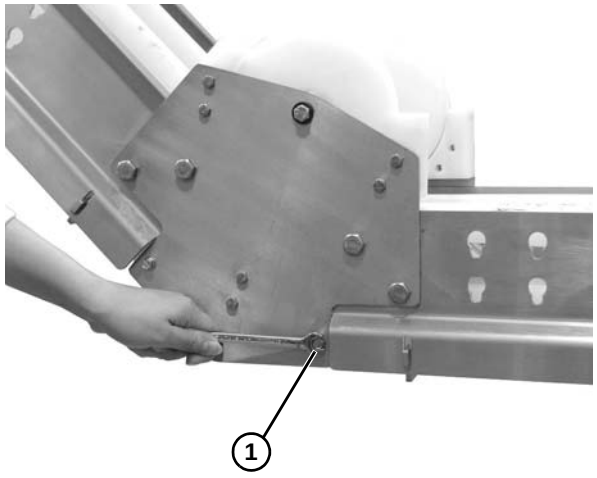


Figure 11

Installation

All Conveyors

Curve Connecting Components

Typical Curve Connecting Components **(Figure 12)**

1	Straight Section
2	Offset Connecting Plate (x2)
3	Curved Section
4	Hex Head Cap Screw M10-1.50 x 12mm (x4)

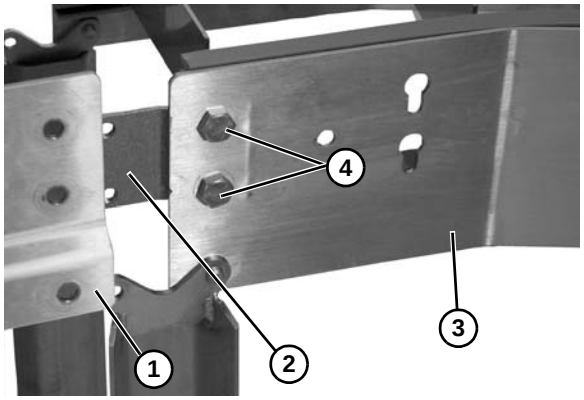


Figure 12

1. For joining curved to straight sections, install offset connecting plates onto curved section **(Figure 13, item 1)** with four hex head bolts **(Figure 13, item 2)** with heads of bolts outside of curved section.

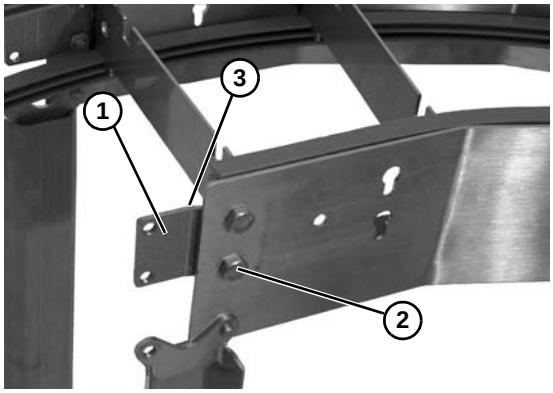


Figure 13

2. Ensure that the offset of connecting plates is to the inside of curved section **(Figure 13, item 3)**.
3. When securing straight section to curved section on inside curve **(Figure 14, item 1)** make sure offset plate is to the inside of straight section **(Figure 14, item 2)**.

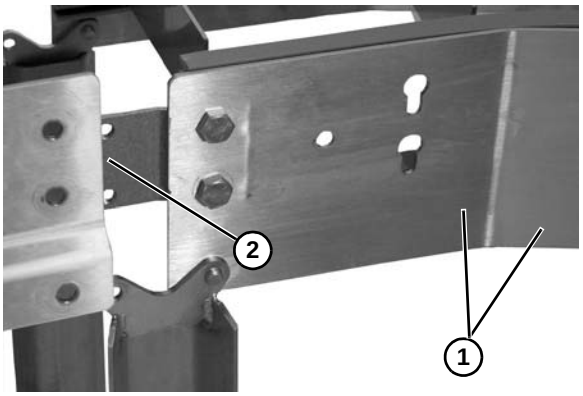


Figure 14

4. Secure straight section **(Figure 15, item 1)** onto curved section with two hex head bolts **(Figure 15, item 2)** with bolt heads to the outside as shown.

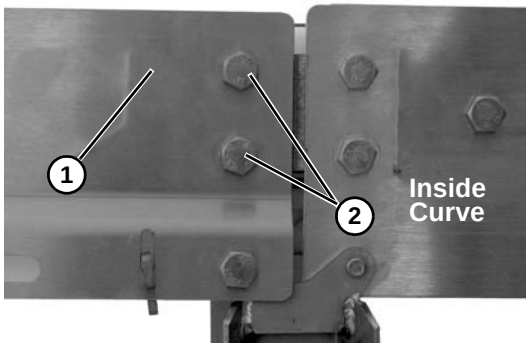


Figure 15

5. When securing straight section to curved section on outside curve **(Figure 16, item 1)** make sure offset plate **(Figure 16, item 2)** is to the outside of straight section.

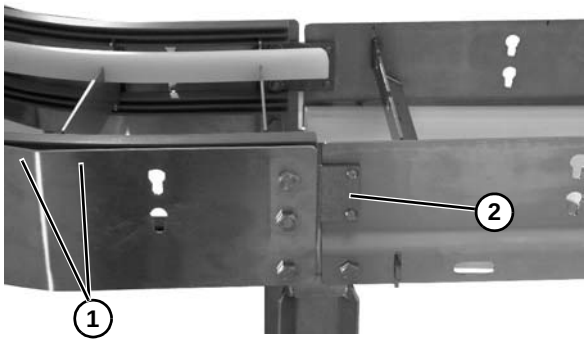


Figure 16

6. Secure straight section **(Figure 17, item 1)** onto curved section with two hex head bolts **(Figure 17, item 2)** with bolt heads to the inside as shown.

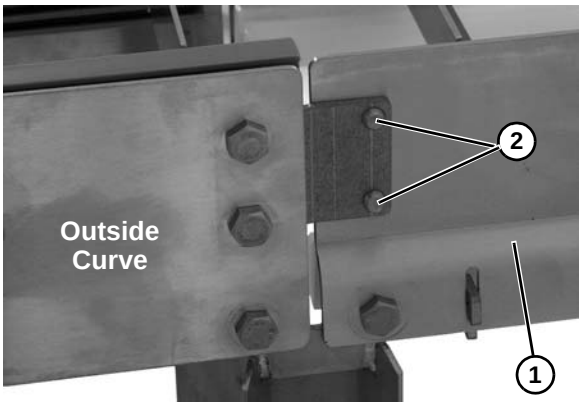


Figure 17

7. Tighten all hardware.

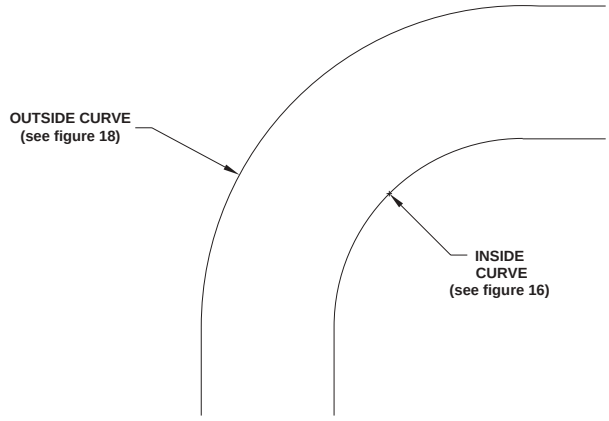


Figure 18

Stand Installation

NOTE
For detailed assembly instructions, please see support stand manual 851-683.

Typical stand components **(Figure 19)**

1	Conveyor Frame
2	Stand
3	M10 - 1.5 x 16 mm hex head cap screws (x4)

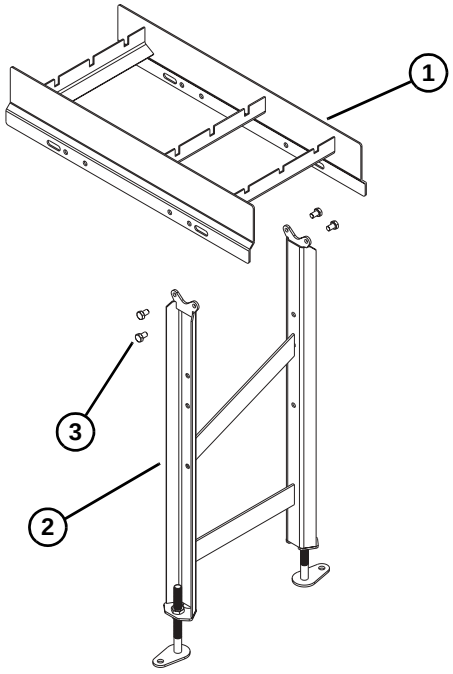


Figure 19

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame **(Figure 20, item 1)**.

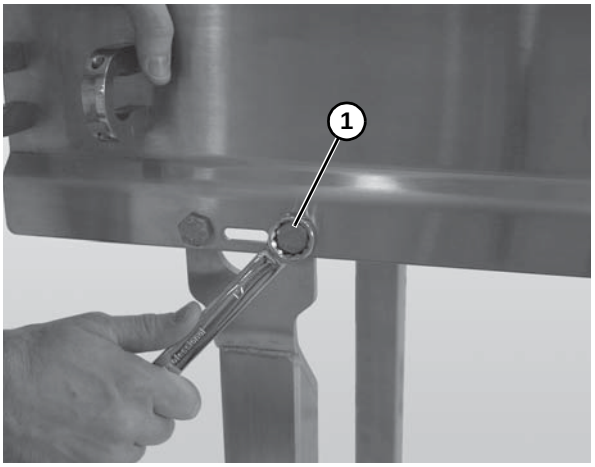


Figure 20

Installation

Belt Installation

Typical Belt Components **(Figure 21)**

1	Chain Belt
2	Belt Rod

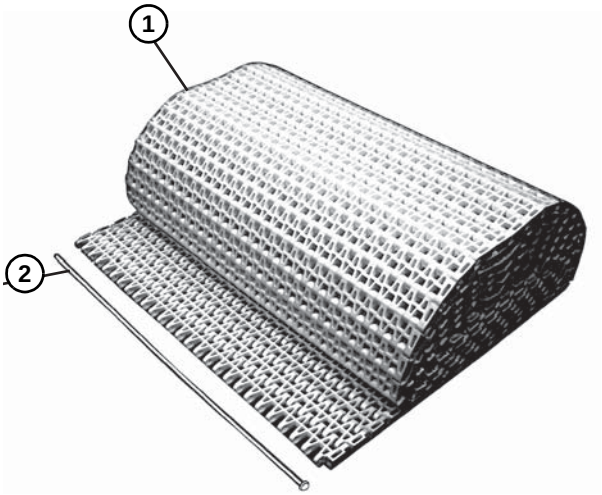


Figure 21

1. Position the belt on the conveyor frame **(Figure 22)**.

Figure 22

2. Orient the belt direction such that the pin heads **(Figure 23, item 1)** are on the outside of the belt radius **(Figure 23, item 2)**. The straight portion on the pin **(Figure 23, item 3)** will be on the inside radius.

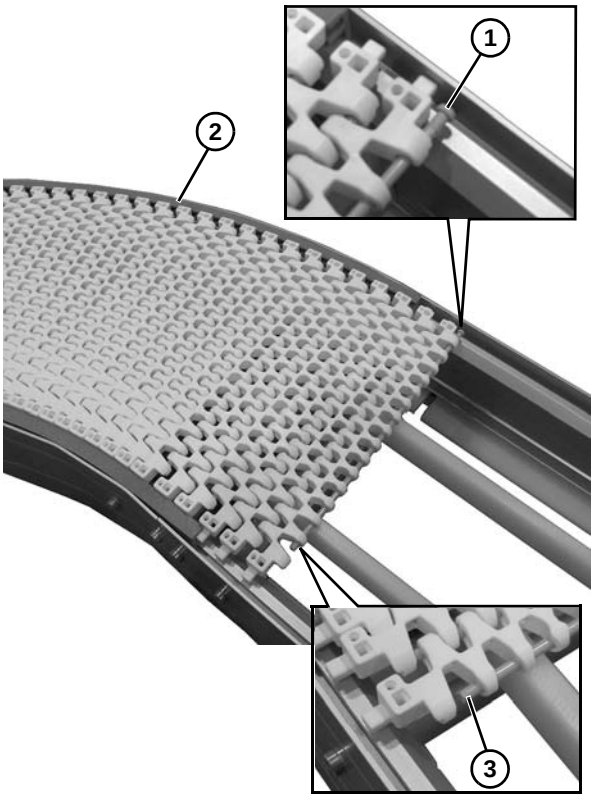


Figure 23

NOTE

For "S" shaped conveyors, the pin heads must be oriented on the outside of the belt radius on the exiting or last curve on the conveyor.

3. Wrap belt around idler tail.
4. Feed the ends of the belt through the top and bottom of the curved frame sections **(Figure 24)**.

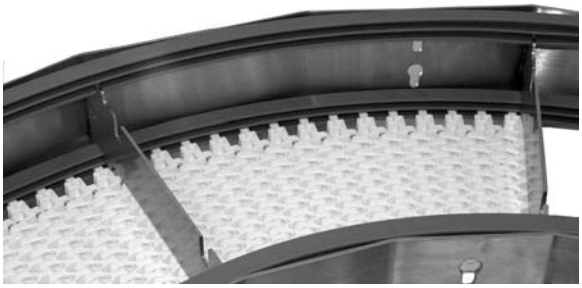


Figure 24

5. Be sure belt tabs are seated in the lower channel of bottom belt guide **(Figure 25, item 1)** and upper channel of top belt guide **(Figure 25, item 2)**.

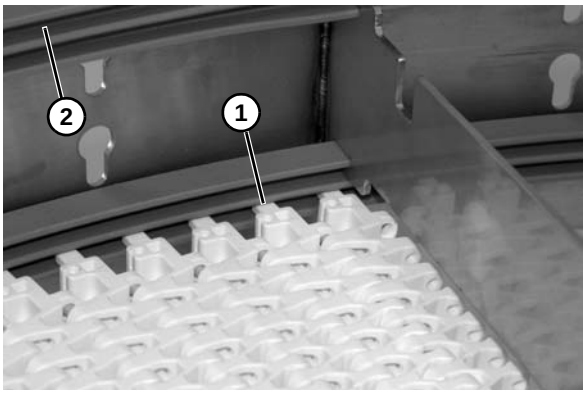


Figure 25

6. When feeding belt through straight section, be sure belt tabs ride on top lip of belt return **(Figure 26, item 1)**.

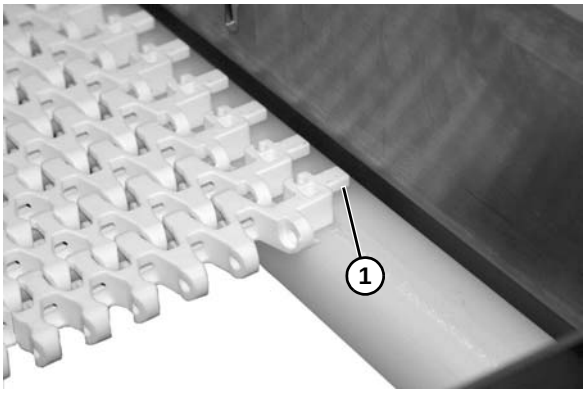


Figure 26

7. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth **(Figure 27, item 1)** mating with rounded section **(Figure 27, item 2)** of belt.

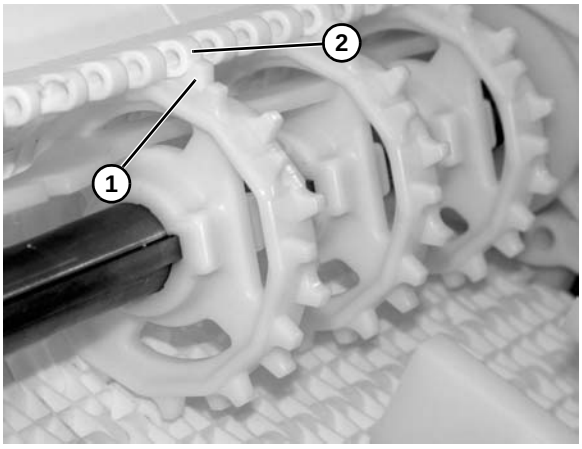


Figure 27

8. For Z-Frame conveyors, guide the belt under the hold down guides **(Figure 28, item 1)** in the lower knuckle.

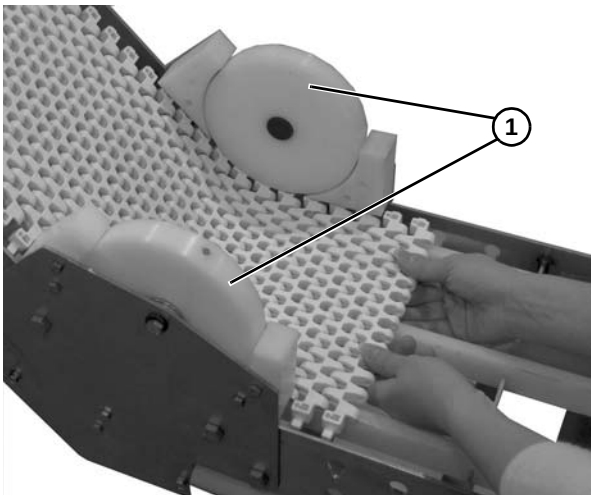


Figure 28

9. Bring the ends of the belt together **(Figure 29)**.

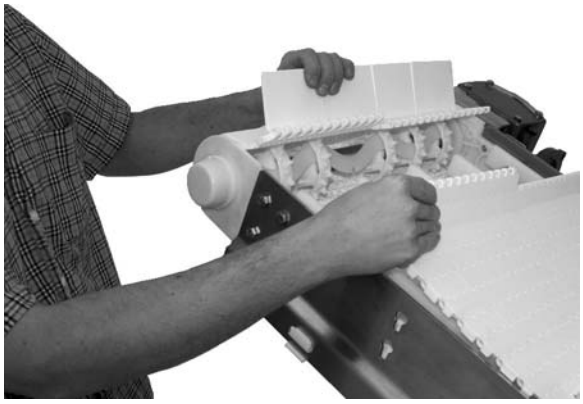


Figure 29

10. Insert the belt rod **(Figure 30, item 1)**.

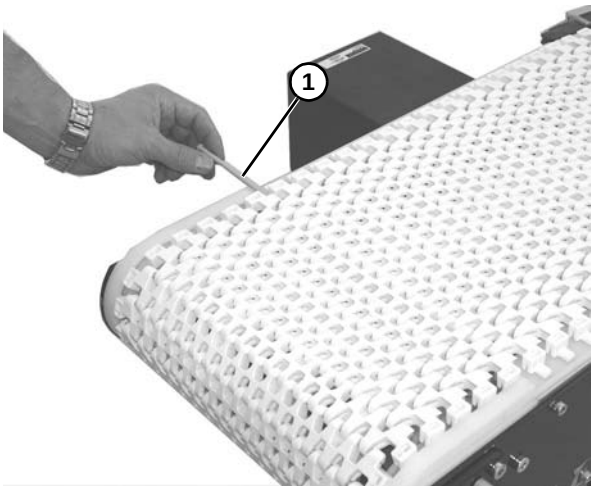


Figure 30

11. Push the belt rod in as far as possible.

12. Lightly tap the head of the rod with a hammer until it snaps into position.
13. Install the top bar caps **(Figure 31, item 1)** on the conveyor frame with wide lip facing up to cover the belt tabs.

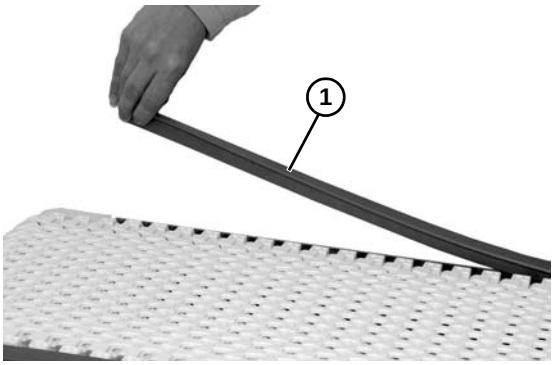


Figure 31

⚠ WARNING

CRUSH HAZARD!

Failure to install the top wear strip in the proper orientation will result in a belt pinch point. Exposed moving parts can cause serious injury.

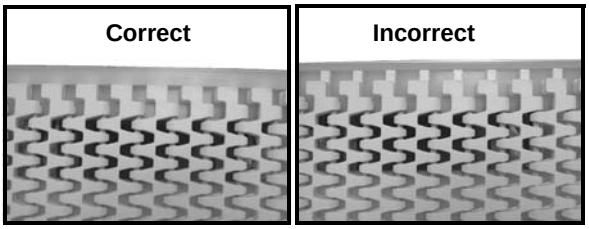


Figure 32

NOTE

Top wear strips are left loose to facilitate ease of belt installation and/or removal.

Belt Returns

1. Install belt return mounting bracket **(Figure 33, item 1)** into slotted frame hole **(Figure 33, item 2)**.

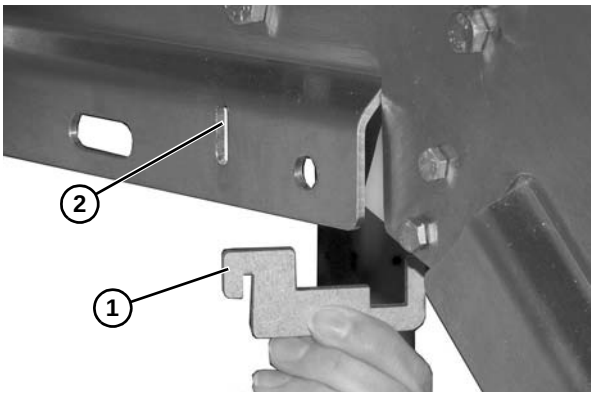


Figure 33

2. Install belt return **(Figure 34, item 1)** onto mounting bracket **(Figure 34, item 2)**.

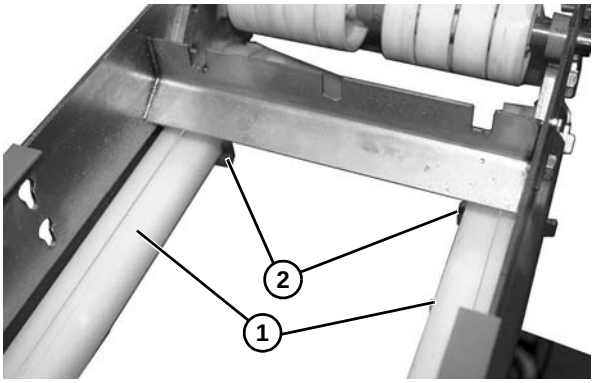


Figure 34

3. Verify that belt returns are mounted correctly by following graphic below **(Figure 35)** shows incorrect mounting and **(Figure 36)** shows correct mounting.

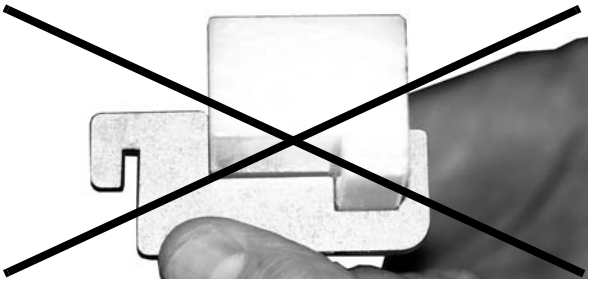


Figure 35

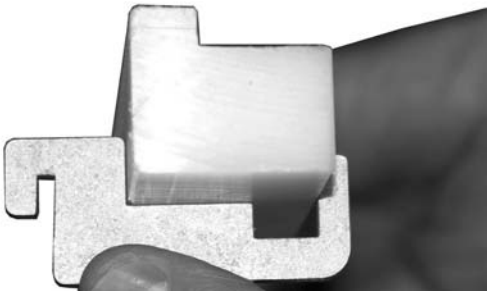


Figure 36

Guide Installation

1. Insert carriage bolts with spacers **(Figure 37, item 1)** into slotted holes in conveyor side.

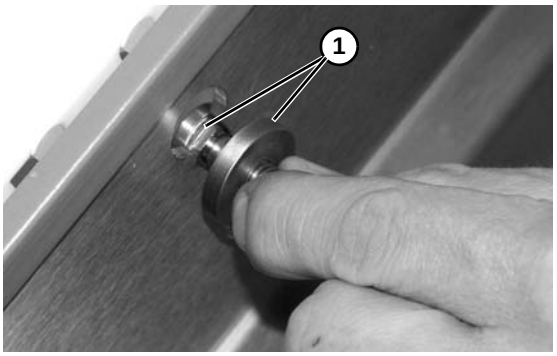


Figure 37

2. Attach the guide mounting brackets **(Figure 38, item 1)** to the conveyor with hex nuts **(Figure 38, item 2)**. Hand tighten only at this time.

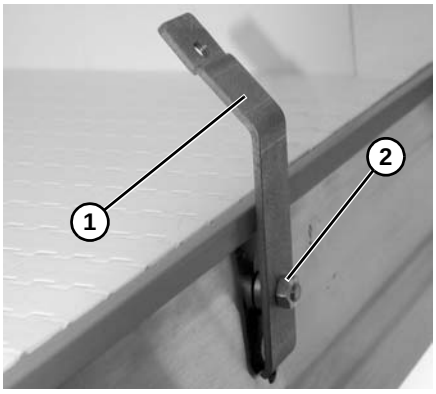


Figure 38

3. Attach guide **(Figure 39, item 1)** to the mounting brackets with hex bolts and spacers **(Figure 39, item 2)**. Hand tighten only at this time.

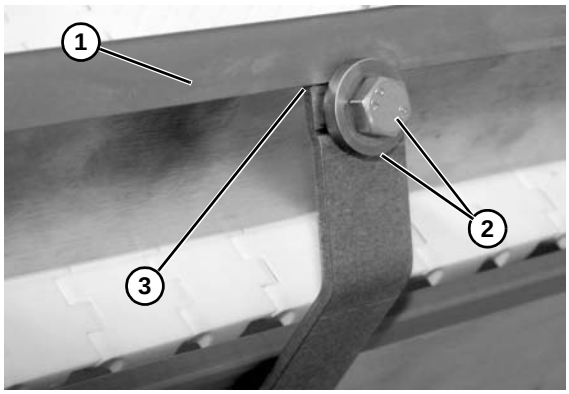


Figure 39

4. Ensure that nose of bracket slips under the lip of guide **(Figure 39, item 3)**.

NOTE

*When installing guides, be sure that the angled end of guide is installed on the idler end of conveyor **(Figure 40, item 1)**.*

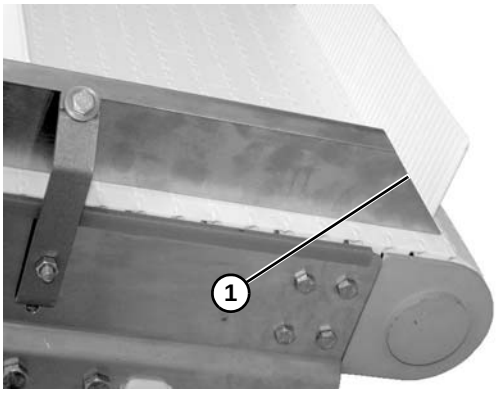


Figure 40

5. Tighten all mounting hardware.

Drive Package Installation

For detailed assembly instructions, refer to the appropriate Drive Packages Manual:

- 851-679 Side Mount 90° Drive Package
- 851-681 Bottom Mount 90° Drive Package
- 851-682 Bottom Mount Parallel Shaft Drive Package

1. Attach the motor **(Figure 41, item 1)** to the gear reducer **(Figure 41, item 2)**.

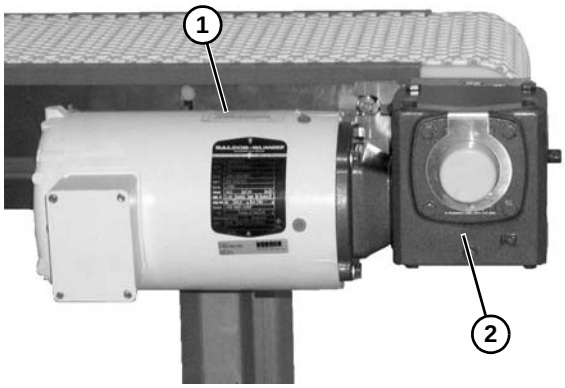


Figure 41

Required Tools

- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- Punch and hammer (to remove belt rod)

Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 26 for recommendations.
- Replace any worn or damaged parts.

Cleaning

NOTE

Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.

⚠ CAUTION

Dorner recommends cleaning all the “food zones” prior to placing conveyor into service. Ensure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.

⚠ WARNING

SEVERE HAZARD!

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

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- 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.

1. Remove guides **(Figure 42, item 1)** when required.

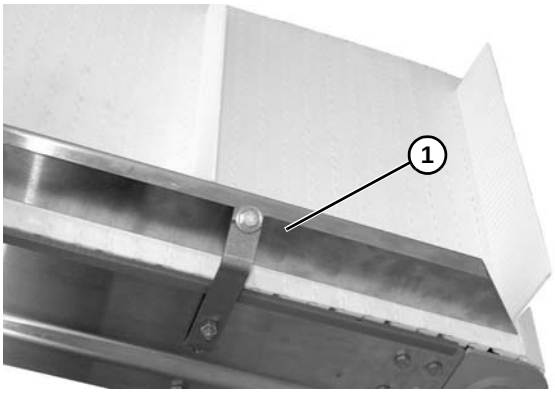


Figure 42

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head **(Figure 43)**.

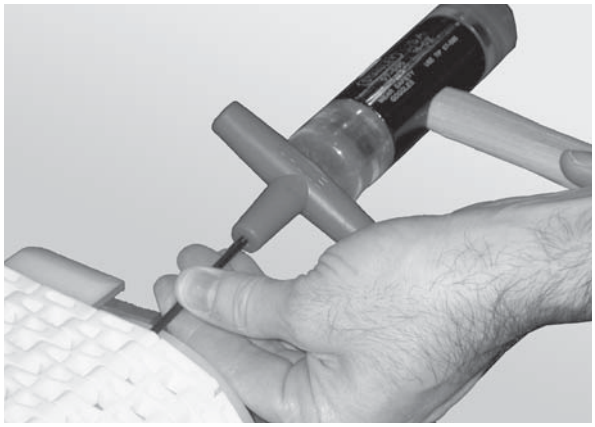


Figure 43

3. Slide the old belt off the conveyor frame.
4. Replace the old belt with a new one. Refer to “Belt Installation” on page 12.

⚠ 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. Remove one or more belt links to take up tension.

Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips **(Figure 44)**

1	Bar Cap
2	Wear Strips, Bed Frame

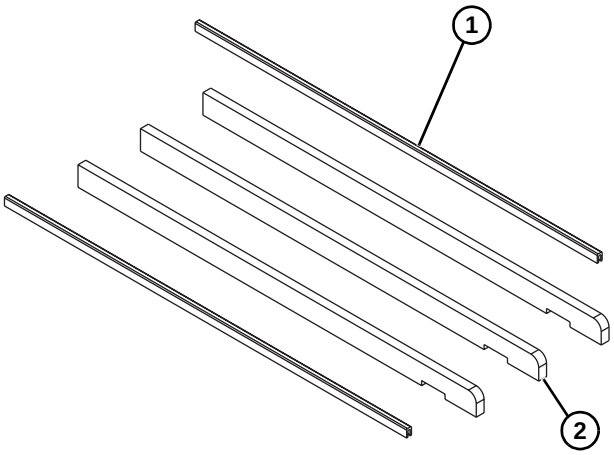


Figure 44

Bar Cap Replacement

1. Remove worn bar cap **(Figure 45, item 1)** by lifting off of conveyor side rail.

Figure 45

2. Replace with new bar cap.

Wear Strip Removal

1. Remove conveyor belt. See “Conveyor Belt Replacement” on page 17.
2. Remove worn wear strips **(Figure 46, item 1)** from frame notches.

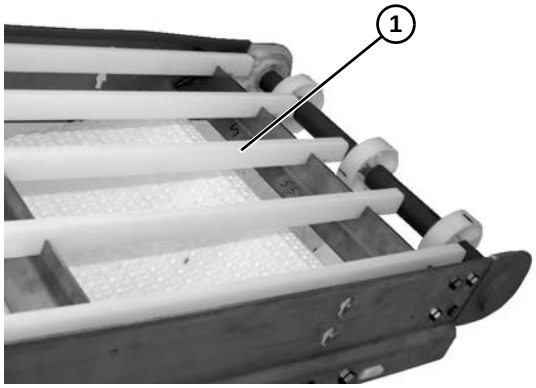


Figure 46

3. Remove curved wear strips from frame notches **(Figure 47, item 1)** when worn.

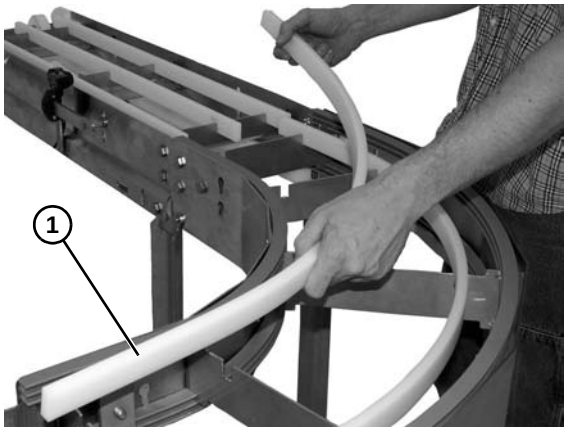


Figure 47

4. Replace with new wear strips.

Belt Guides

Open conveyor belt. See “Conveyor Belt Replacement” on page 17.

Removal

1. Remove the hex head bolt **(Figure 48, item 1)** retaining the wear strip support bracket **(Figure 48, item 2)** from both ends of curve conveyor (for conveyors 4" - 10" wide only).

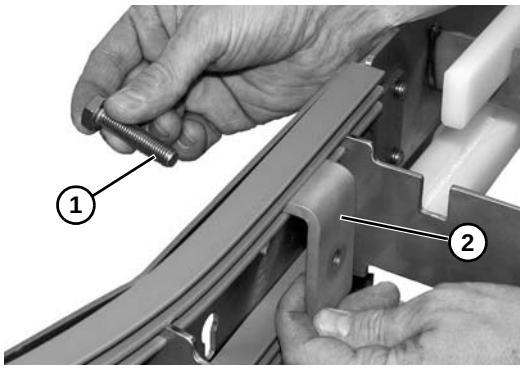


Figure 48

2. Remove two hex head bolts **(Figure 49, item 1)** holding straight section frame to section connecting bracket **(Figure 49, item 2)**. Repeat on opposite side.

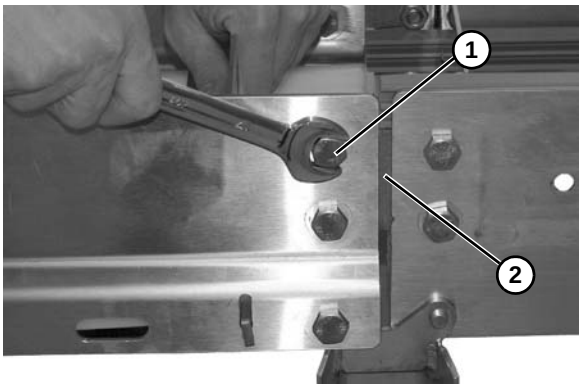


Figure 49

3. Remove hex head bolt **(Figure 50, item 1)** holding straight section frame to conveyor stand **(Figure 50, item 2)**. Repeat on opposite side.

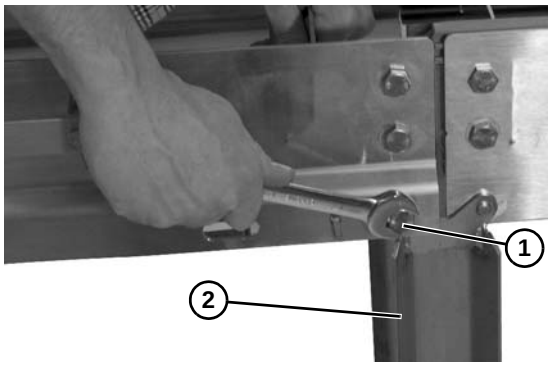


Figure 50

4. Lift up on straight section **(Figure 51, item 1)** and remove from curve section and conveyor stand **(Figure 51, item 2)**. Be sure to support free end of straight section once removed.

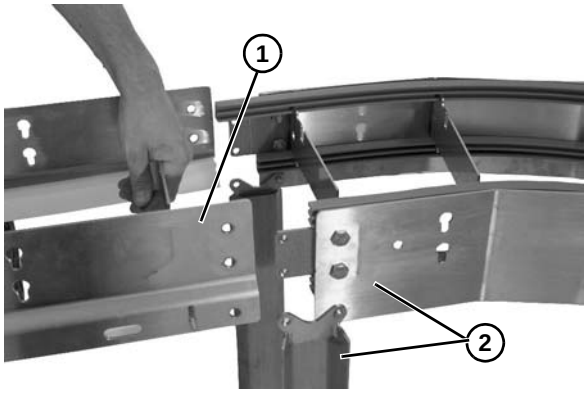


Figure 51

5. Slide off inner **(Figure 52, item 1)** and outer **(Figure 52, item 2)** belt guides.

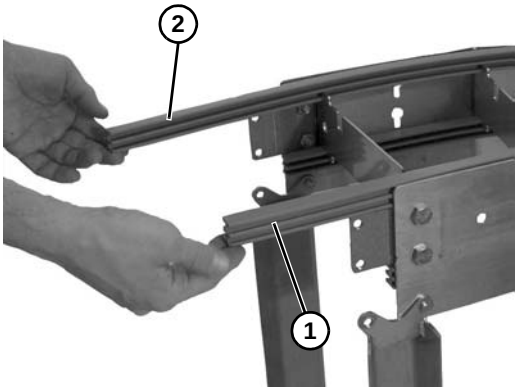


Figure 52

6. Replace with new belt guides.

Drive Sprocket and Spindle Replacement

⚠ WARNING

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

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Open conveyor belt. See "Conveyor Belt Replacement" on page 17.
3. Remove bearing cover **(Figure 53, item 1)**.

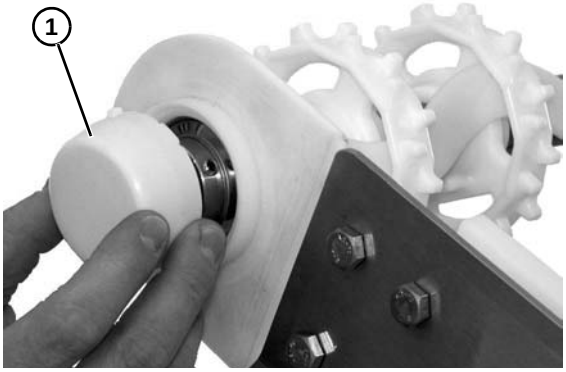


Figure 53

4. Remove the four head plate bolts **(Figure 54, item 1)** on both sides of the conveyor.

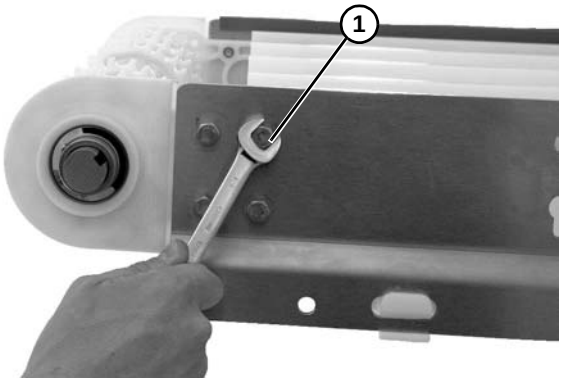


Figure 54

5. Remove tail assembly.
6. Loosen set screws **(Figure 55, item 1)**.

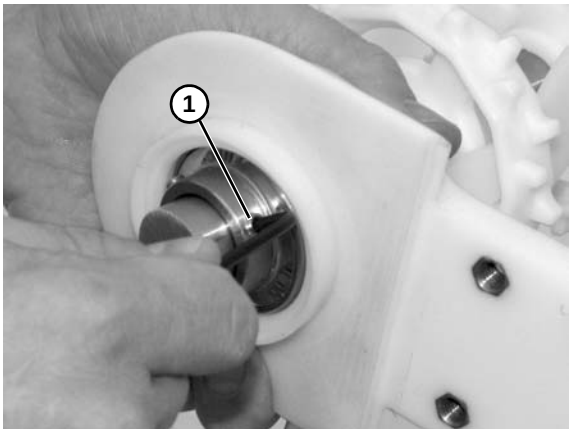


Figure 55

7. Slide the head plate with bearing **(Figure 56, item 1)** off the shaft.

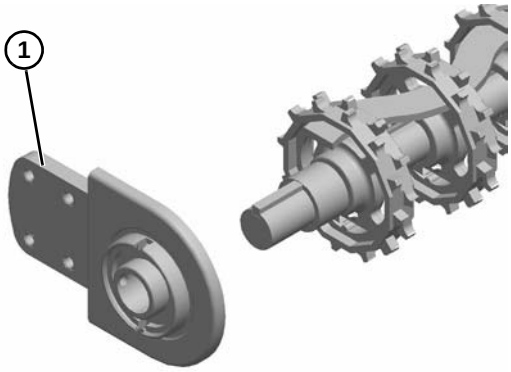


Figure 56

8. Slide off drive sprocket spacer **(Figure 57, item 1)**.

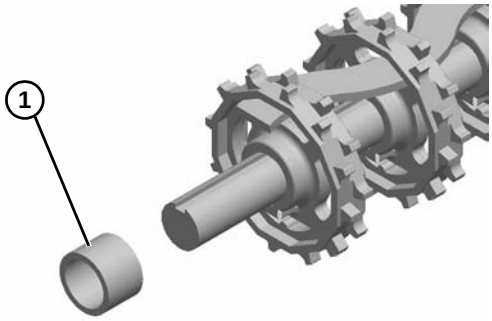


Figure 57

9. Slide entire sprocket assembly slightly outward, and remove the first sprocket **(Figure 58, item 1)** off the drive spindle and alignment bar. **(Figure 58, item 2).**

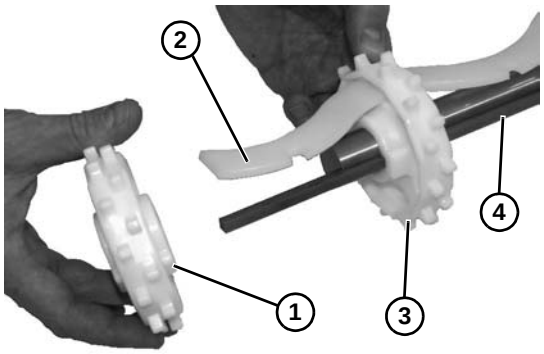


Figure 58

10. Remove remaining sprockets **(Figure 58, item 3)** off the alignment bar as you slide entire assembly off the drive spindle **(Figure 58, item 4)**.

NOTE

To reassemble please note the placement of the sprockets on the alignment key.

Idler Puck and Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

NOTE

Idler tails are equipped with plain bushing pucks, replace when worn.

1. Open conveyor belt. See “Conveyor Belt Replacement” on page 17.

2. Remove four head plate bolts **(Figure 59, item 1)**. Repeat on opposite side.

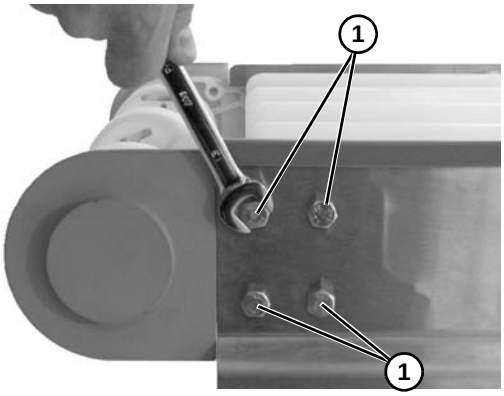


Figure 59

3. Remove idler tail assembly **(Figure 60, item 1)**.

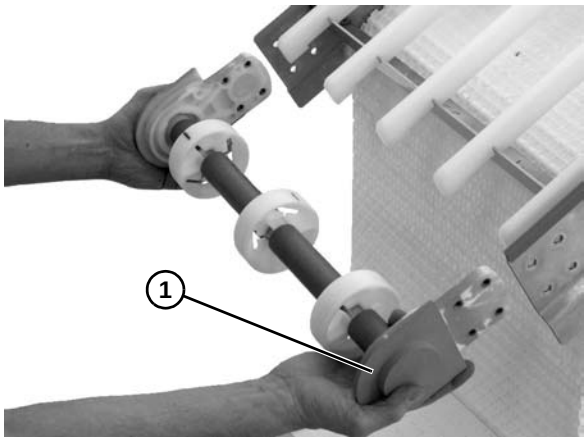


Figure 60

4. Slide off idler head plate **(Figure 61, item 1)** from shaft **(Figure 61, item 2)**.

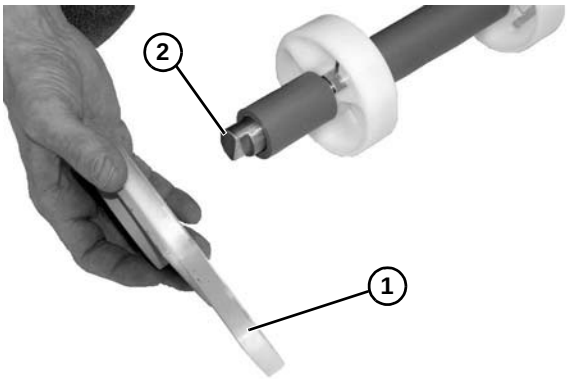


Figure 61

5. Slide off the round puck spacer **(Figure 62, item 1)**.

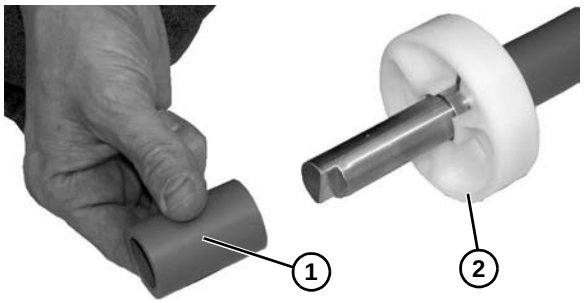


Figure 62

6. Slide off puck and replace **(Figure 62, item 2)**.
7. Repeat as needed.

Bearing Replacement

⚠ WARNING

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

Drive Bearing Removal and Replacement

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. See “Drive Sprocket and Spindle Replacement” on page 20. Follow steps 1 through 7.
2. Twist the bearing out **(Figure 63, item 1)**.

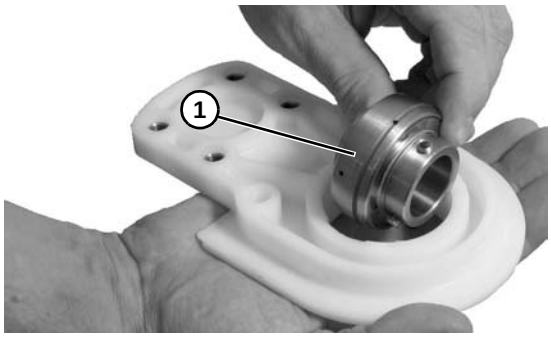


Figure 63

3. Replace bearing.

Maintenance of Knuckles

Lower Knuckle

1. Remove belt. See “Conveyor Belt Replacement” on page 17.
2. Remove two cap screws **(Figure 64, item 1)** on each side of the knuckle and remove the hold down roller guards **(Figure 64, item 2)**. Repeat on opposite side of the conveyor.

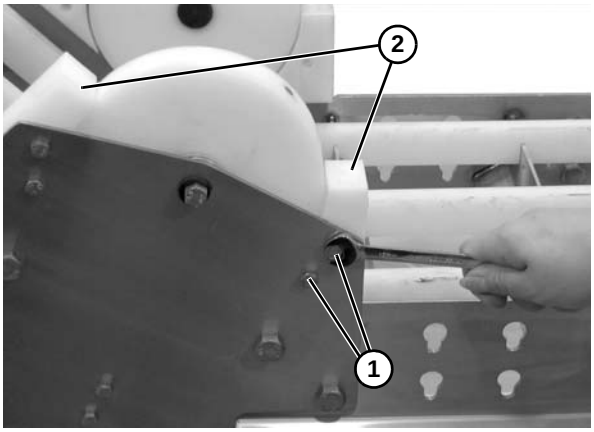


Figure 64

3. Remove the cap screw **(Figure 65, item 1)** and the hold down roller **(Figure 65, item 2)**. Repeat on opposite side of the conveyor.

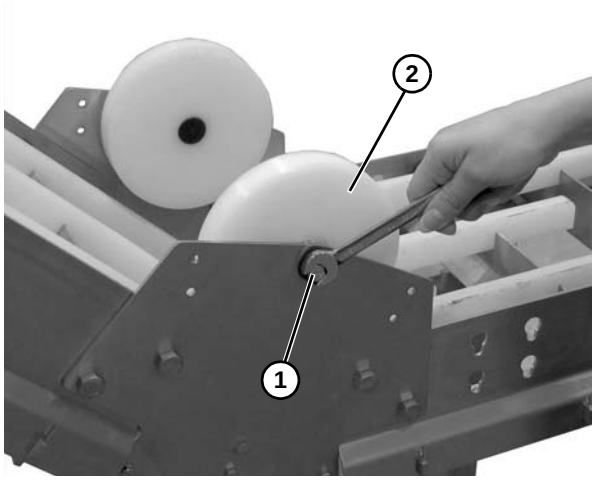


Figure 65

4. Remove two cap screws **(Figure 66, item 1)** and the inner belt return guide **(Figure 67, item 1)**. Repeat on opposite side of the conveyor.

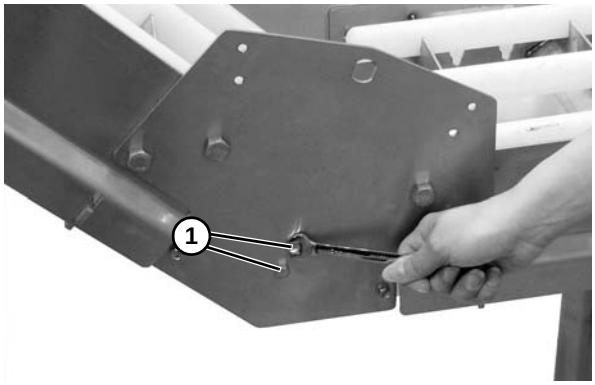


Figure 66

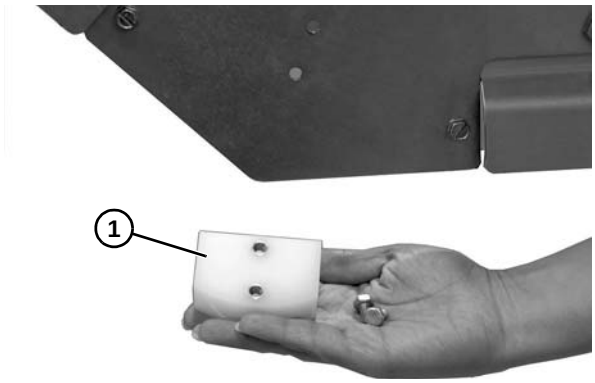


Figure 67

5. Replace parts as necessary.
6. Install parts reverse of removal.

Upper Knuckle

1. Remove belt. See “Conveyor Belt Replacement” on page 17.
2. Remove cap screw **(Figure 68, item 1)** and edge guide plate **(Figure 68, item 2)** from each side of the conveyor.

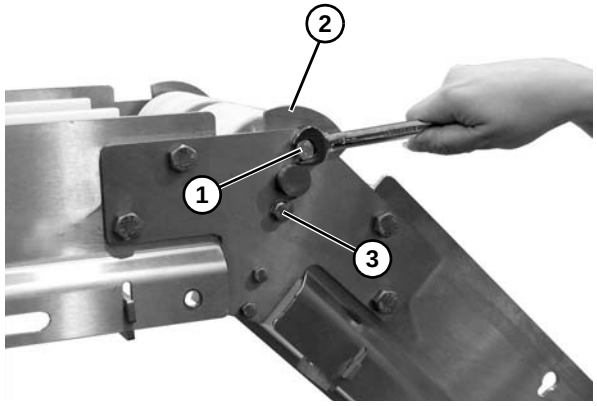


Figure 68

3. Remove the cap screw **(Figure 68, item 3)** and shaft clamp **(Figure 69, item 1)** from each side of the conveyor.

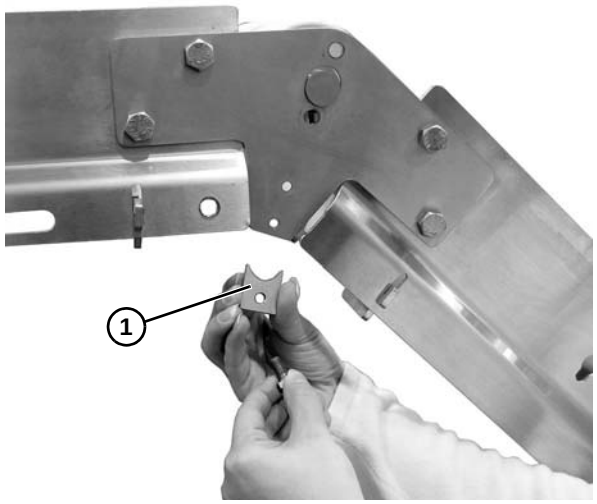


Figure 69

4. Slide shaft **(Figure 70, item 1)** inwards to remove from knuckle frame **(Figure 71, item 1)**.

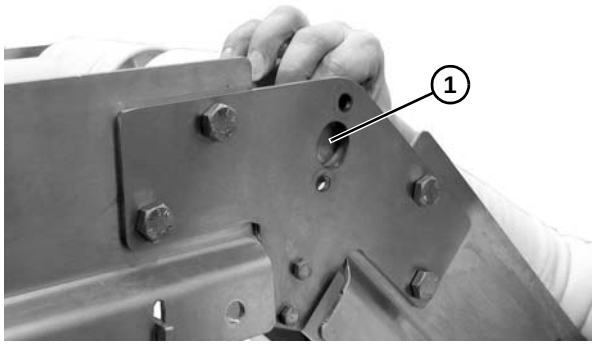


Figure 70

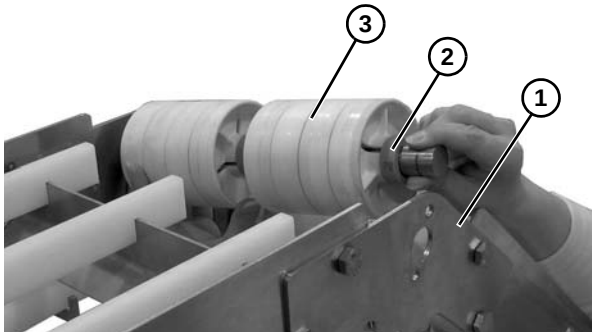


Figure 71

NOTE

*Spacer **(Figure 71, item 2)** and pucks **(Figure 71, item 3)** are loose and can slide off the shaft.*

5. Remove spacer **(Figure 72, item 1)**, rollers **(Figure 72, item 2)** and tube spacers **(Figure 72, item 3)** from shaft.

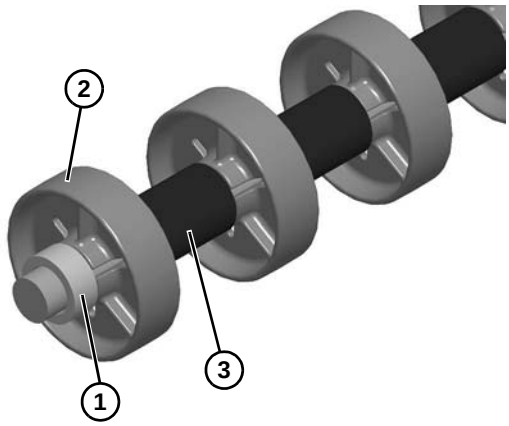


Figure 72

6. Remove two cap screws **(Figure 73, item 1)** and inner belt return guide **(Figure 74, item 1)**. Repeat on opposite side of the conveyor.

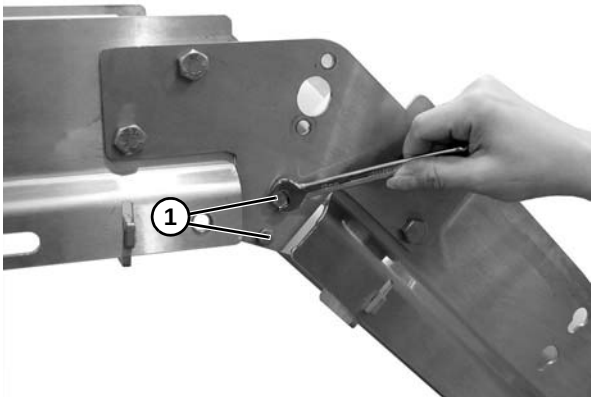


Figure 73

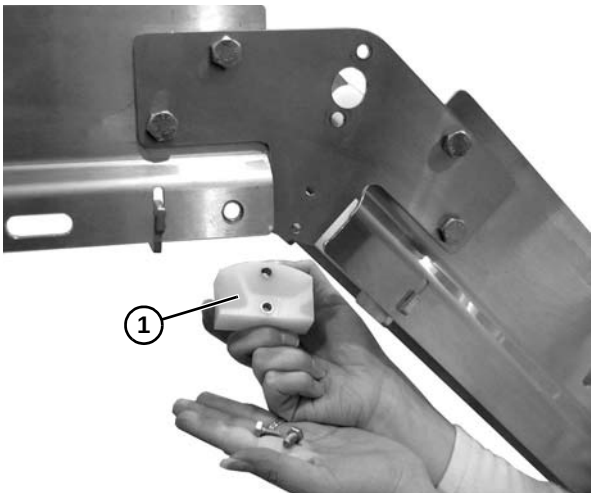


Figure 74

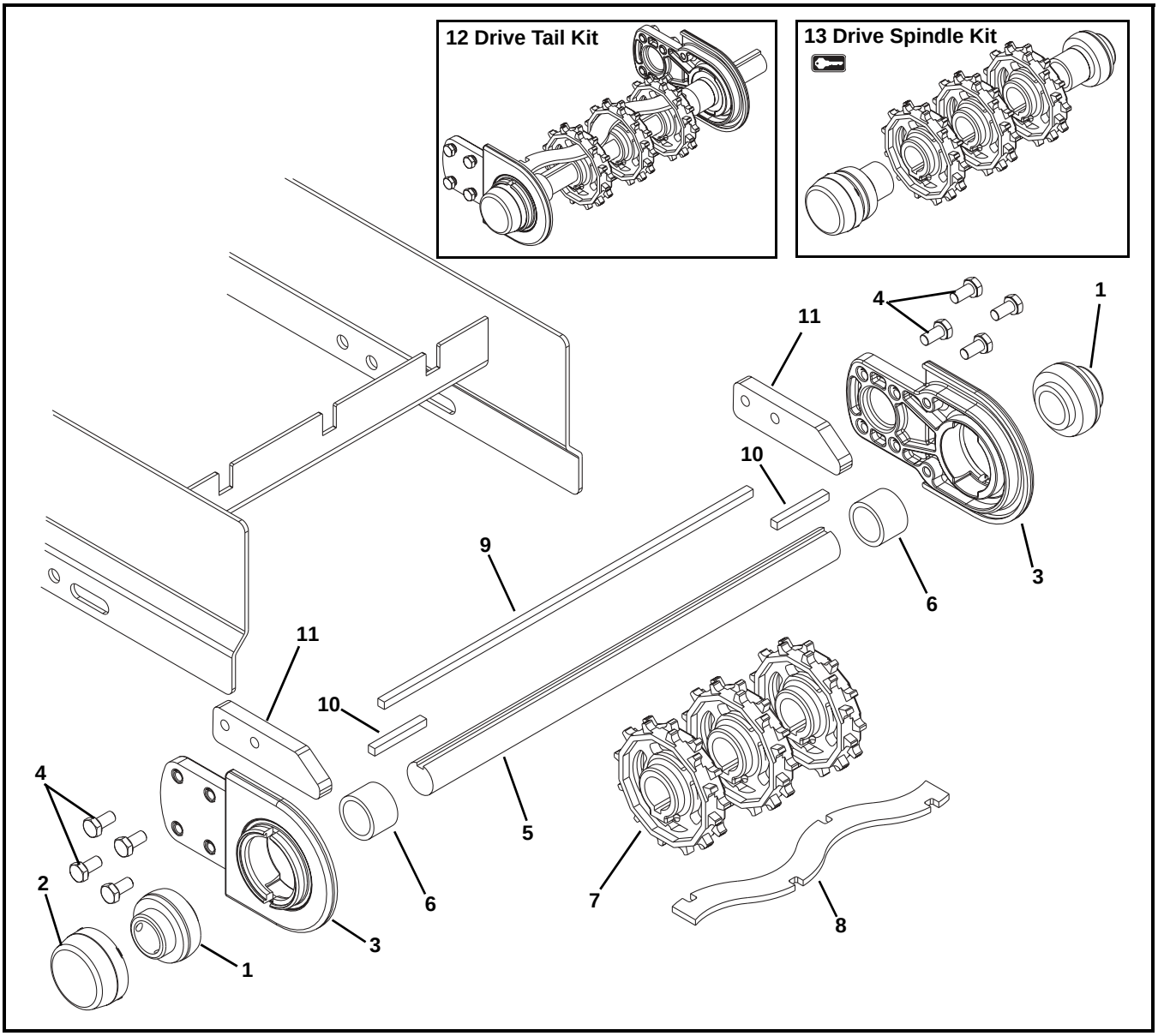
7. Replace parts as necessary.
8. Install parts reverse of removal.

Notes

Service Parts

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

Drive End Components



Item	Part Number	Description
1	735BK	Bearing Kit (Qty. 2)
2*	807-1454	Bearing Cap
3	532013	Headplate
4	960816MSS	Hex Head Cap Screw M8-1.25 x 16mm
5	See Drive Spindle Chart	Spindle
6	532251-LLLLL	Sprocket Spacer
7	807-1754	Sprocket
8	532124-WW	Sprocket Alignment Bar (for 10" - 36" wide only
9	532121-LLLLL	Square Key
10	912-110SS	Square Key
11	532398	Shoe (for 4" - 16" wide only)

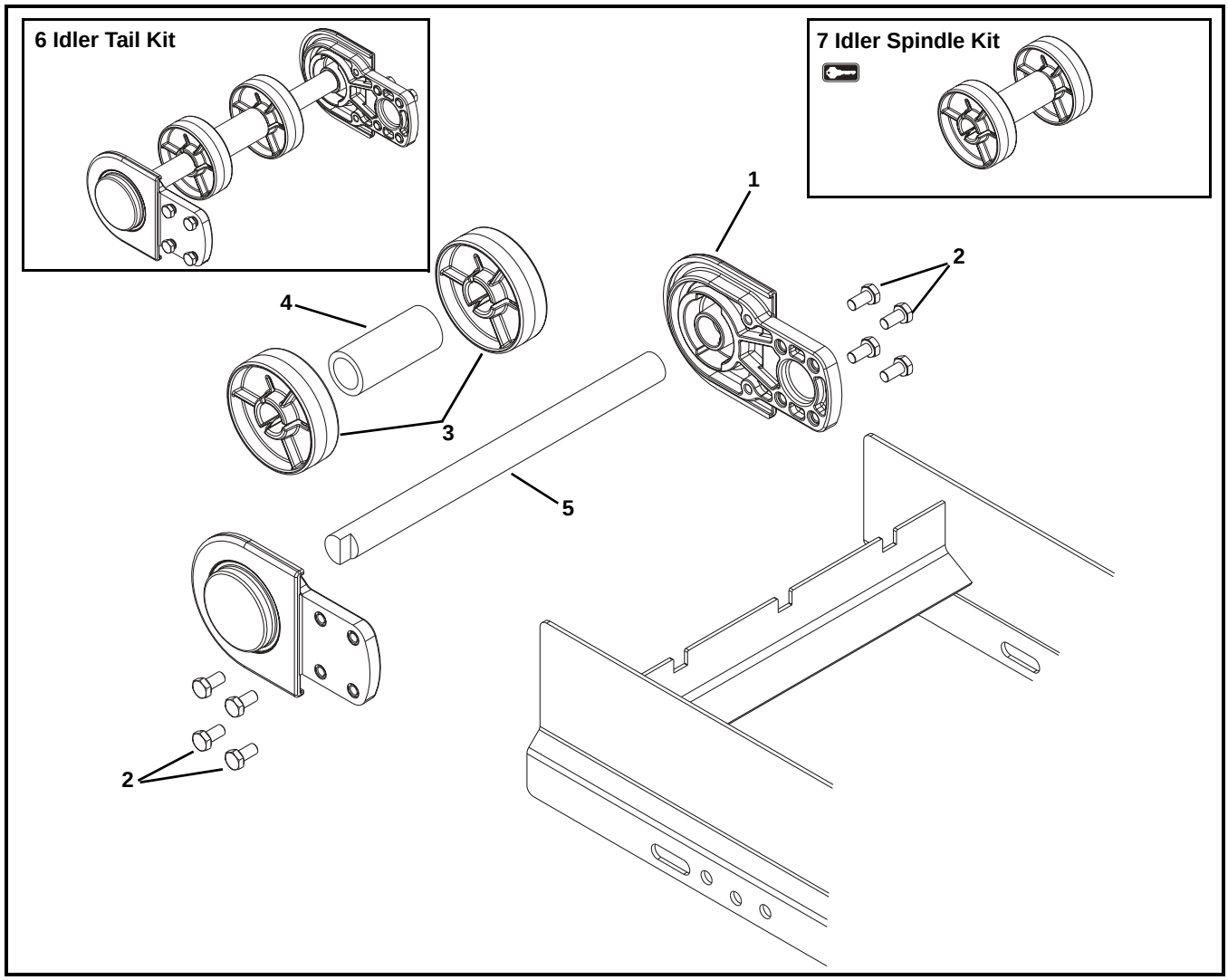
Item	Part Number	Description
12	735CBDT-WW	Drive Tail Kit for Bottom Mount (Includes items 1 through 11)
	735CSDT-WW	Drive Tail Kit for Side Mount (Includes items 1 through 11)
	735CDBDT-WW	Drive Tail Kit for Bottom Mount, with Double Output Shafts (Includes items 1 through 11)
	735CDSDT-WW	Drive Tail Kit for Side Mount, with Double Output Shafts (Includes items 1 through 11)
	735UCSDT-WW	CE Drive Tail Kit for Side Mount, (Includes items 1 through 11)
	735UCDSDT-WW	CE Drive Tail Kit for Side Mount, with Double Output Shafts (Includes items 1 through 11)
13	735CDT-WW	Drive Spindle Kit (Includes items 1, 2, 6, and 7)
WW = Conveyor width reference: 04 – 36 in 02 increments		
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
* Not available with double output shafts		

Drive Spindle Chart - US Gearmotor Version				
Conveyor Width	**Bottom Mount**	**Side Mount**	**Bottom Mount with Double Output Shaft**	**Side Mount with Double Output Shaft**
4"	532113-00824	532232-01425	532113-00980	532232-01581
6"	532113-01024	532232-01625	532113-01180	532232-01781
8"	532113-01212	532232-01813	532113-01368	532232-01969
10"	532113-01413	532232-02014	532113-01569	532232-02170
12"	532113-01602	532232-02203	532113-01758	532232-02359
14"	532113-01799	532232-02400	532113-01955	532232-02556
16"	532113-01996	532232-02597	532113-02152	532232-02753
18"	532113-02190	532232-02791	532113-02346	532232-02947
20"	532113-02387	532232-02988	532113-02543	532232-03144
22"	532113-02583	532232-03184	532113-02739	532232-03340
24"	532113-02780	532232-03381	532113-02936	532232-03537
26"	532113-02973	532232-03574	532113-03129	532232-03730
28"	532113-03170	532232-03771	532113-03326	532232-03927
30"	532113-03364	532232-03965	532113-03520	532232-04121
32"	532113-03561	532232-04162	532113-03717	532232-04318
34"	532113-03757	532232-04358	532113-03913	532232-04514
36"	532113-03954	532232-04555	532113-04110	532232-04711

Drive Spindle Chart - CE Gearmotor Version				
Conveyor Width	**Bottom Mount**	**Side Mount**	**Bottom Mount with Double Output Shaft**	**Side Mount with Double Output Shaft**
4"	532113-00824	532291-01228	532113-00980	532291-01384
6"	532113-01024	532291-01428	532113-01180	532291-01584
8"	532113-01212	532291-01616	532113-01368	532291-01772
10"	532113-01413	532291-01817	532113-01569	532291-01973
12"	532113-01602	532291-02006	532113-01758	532291-02162
14"	532113-01799	532291-02203	532113-01955	532291-02359
16"	532113-01996	532291-02400	532113-02152	532291-02556
18"	532113-02190	532291-02594	532113-02346	532291-02750
20"	532113-02387	532291-02791	532113-02543	532291-02947
22"	532113-02583	532291-02987	532113-02739	532291-03143
24"	532113-02780	532291-03184	532113-02936	532291-03340
26"	532113-02973	532291-03377	532113-03129	532291-03533
28"	532113-03170	532291-03574	532113-03326	532291-03730
30"	532113-03364	532291-03768	532113-03520	532291-03924
32"	532113-03561	532291-03965	532113-03717	532291-04121
34"	532113-03757	532291-04161	532113-03913	532291-04317
36"	532113-03954	532291-04358	532113-04110	532291-04514

Service Parts

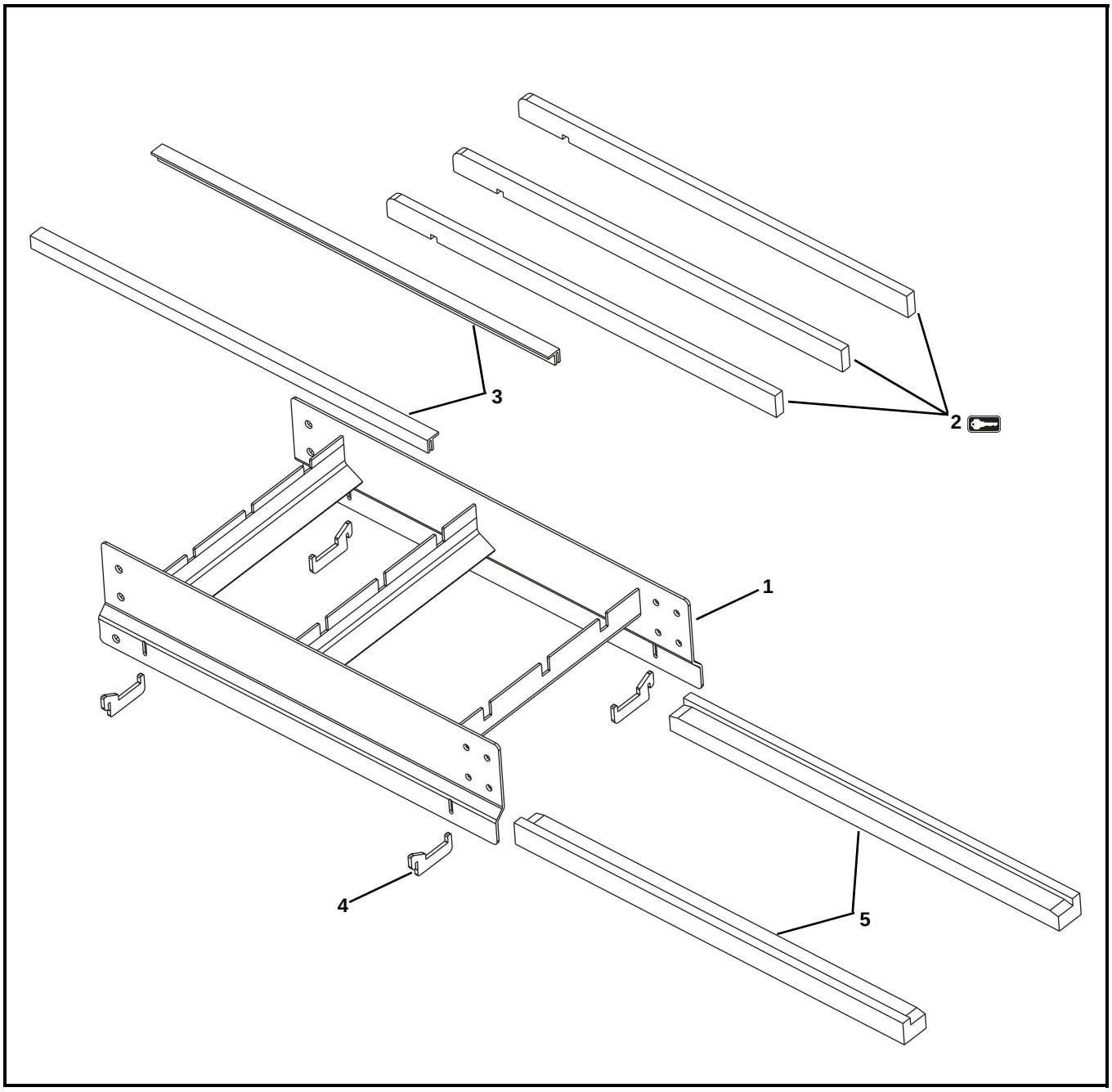
Idler End Components



Item	Part Number	Description
1	532014	Headplate Assembly
2	960816M	Hex Head Cap Screw M8-1.25 x 16mm
3	506296	Idler Puck
4	532127-LLLLL	Tube Spacer
5	See Idler Spindle Chart	Spindle
6	735CIT-WW	Idler Tail Kit (Includes items 1 through 5)
7	735CIS-WW	Idler Spindle Kit (Includes items 3 and 4)
WW = Conveyor width reference: 04 – 36 in 02 increments		
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		

Idler Spindle Chart	
Conveyor Width	**Spindle**
4"	532118-00493
6"	532118-00693
8"	532118-00881
10"	532118-01082
12"	532118-01271
14"	532118-01468
16"	532118-01665
18"	532118-01859
20"	532118-02056
22"	532118-02252
24"	532118-02449
26"	532118-02642
28"	532118-02839
30"	532118-03033
32"	532118-03230
34"	532118-03426
36"	532118-03623

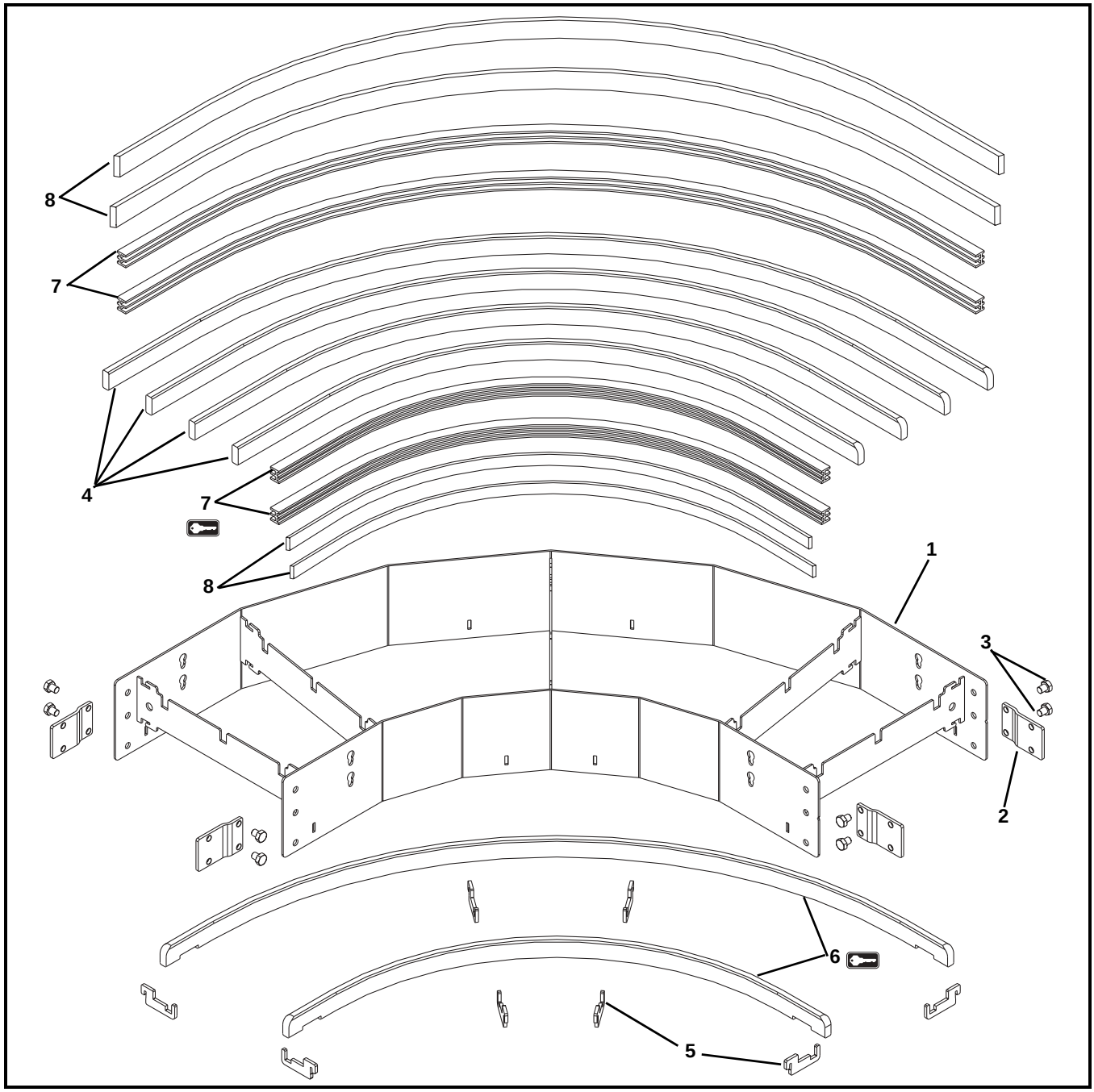
Frame Assembly



Item	Part Number	Description
1	----------	Consult Factory for Frame Part Number
2	532223-LLLLL	Wear Strip
3	807-1807-LLLLL	Bar Cap “F”
4	532152-LLLLL	Return Support
5	532304-LLLLL	Return Strip
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

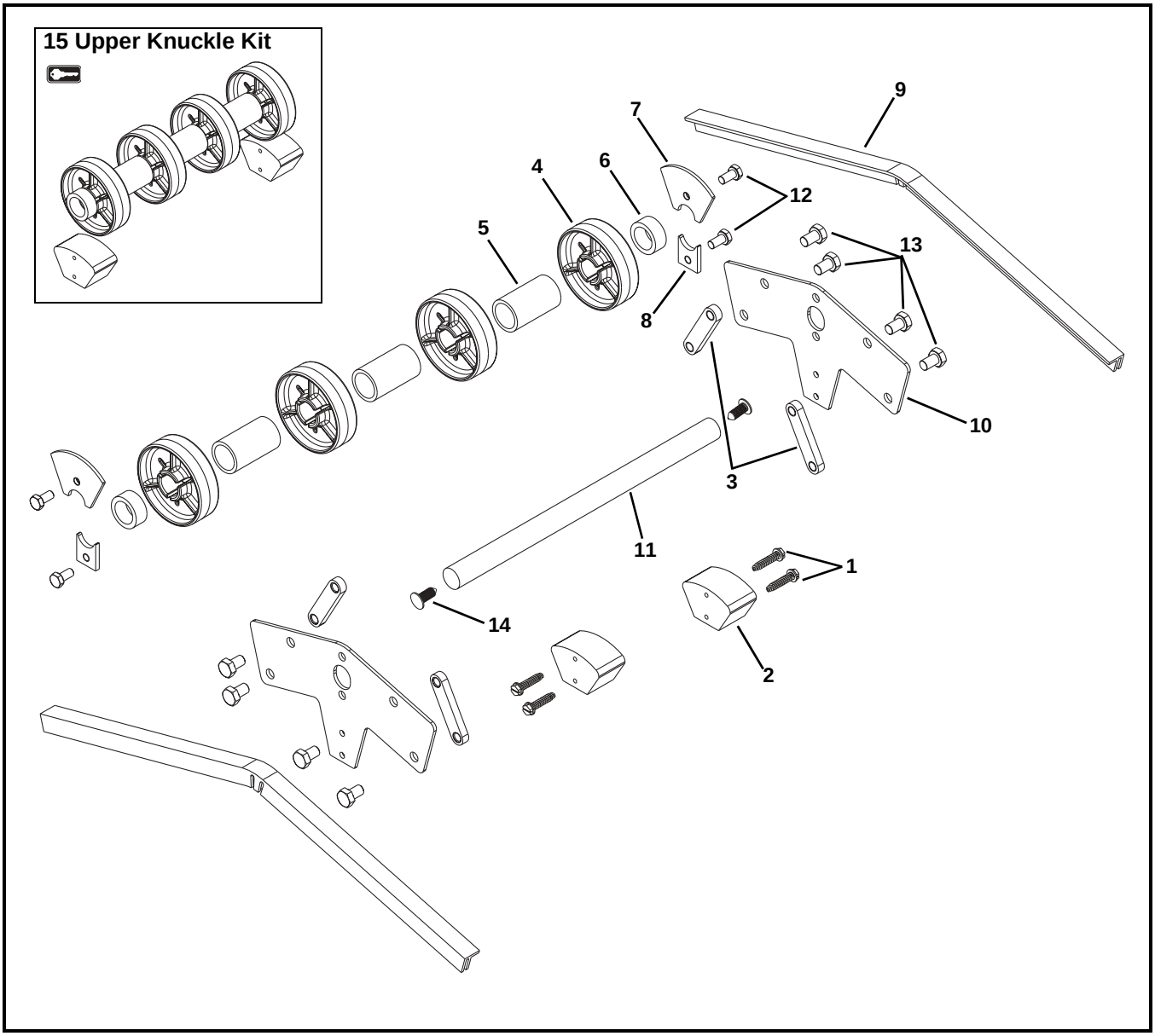
Curve Conveyor Frame and Wear Strips



Item	Part Number	Description
1	----------	Consult Factory for Frame Part Number
2	532158	Connecting Plate for Straight to Curve Sections
	532157	Connecting Plate for Curve to Curve Sections
3	961012MSS	Hex Head Cap Screw M10-1.50 x 12mm
4	532162-LLLLL	Wear Strip (Qty. Varies)
5	532152	Return Support for Conveyors 4" - 20" wide
	532153	Return Support for Conveyors 22" - 36" wide
	532154	Return Support for Conveyors 26" or wider

Item	Part Number	Description
6	532260-LLLLL	Wear Strips for Returns
7	532163-LLLLL	Wear Strip for Edges for Conveyors 4" - 10" wide
	532164-LLLLL	Wear Strip for Edges for Conveyors 12" and wider
8	532168-LLLLL	Filler Strips for Conveyors 4" - 10" wide
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Upper Knuckle

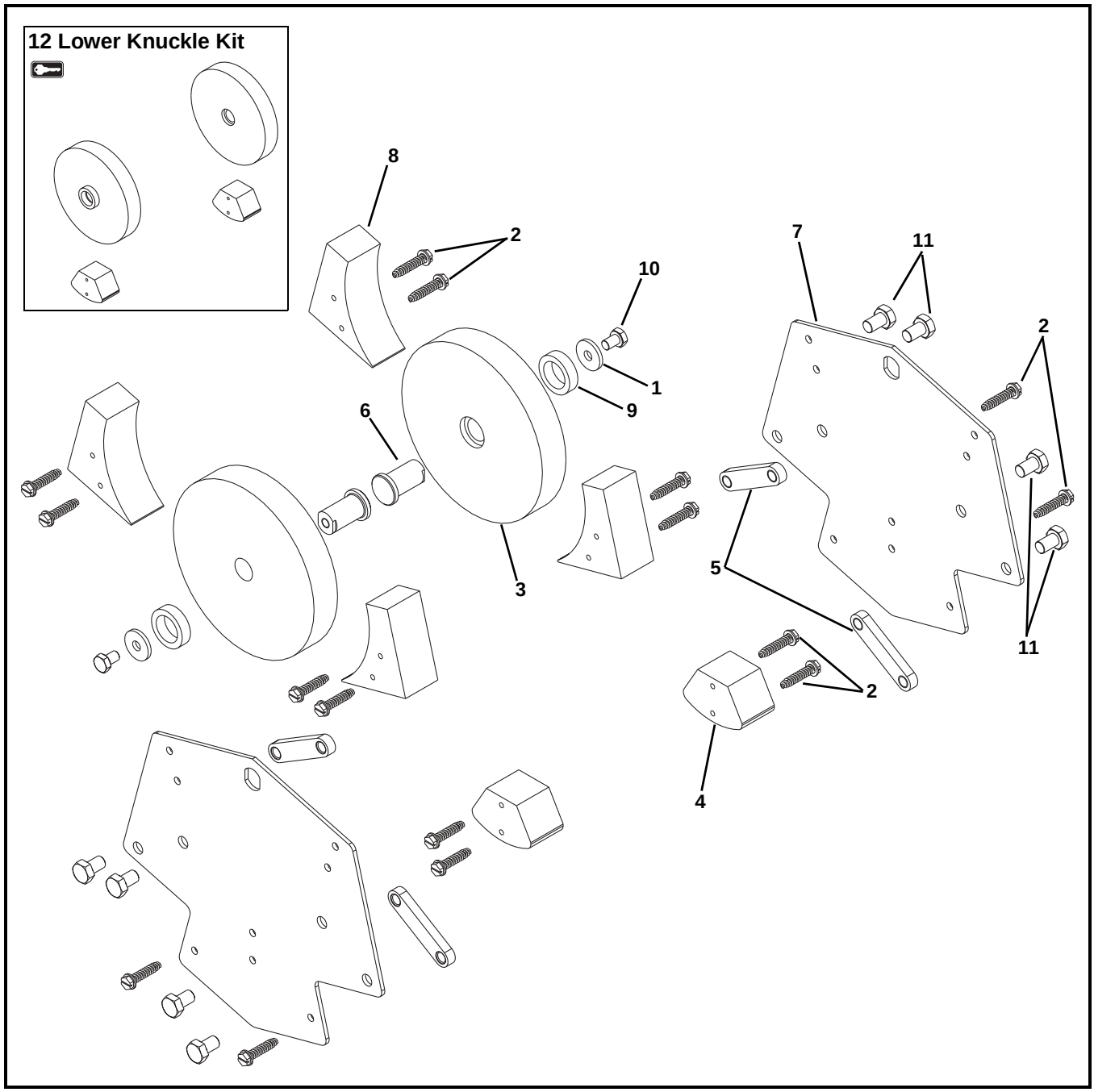


Item	Part Number	Description
1	807-1884	Sheet Metal Screw, #14 x 1.25
2	352326	Inner Belt Return Guide
3	500199	Connector
4	506296	Idler Puck
5	532127-LLLLL	Tube Spacer
6	532305	Spacer
7	532353	Edge Guide Plate
8	532358	Shaft Clamp
9	532360	Bar Cap
10	532376-AA	Side Plate

Item	Part Number	Description
11	532378-WW	Shaft
12	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
13	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
14	807-1292	Cap
15	735UNS-WW	Upper Knuckle Kit for Straight Conveyor (Includes Items 2, 4, 5 and 6)
	735UNC-WW	Upper Knuckle Kit for Curve Conveyor (Includes Items 2, 4, 5 and 6)
AA = Angle 05, 10, 15, 30, 45 or 60		
WW = Conveyor width reference: 08 – 24 in 02 increments		
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

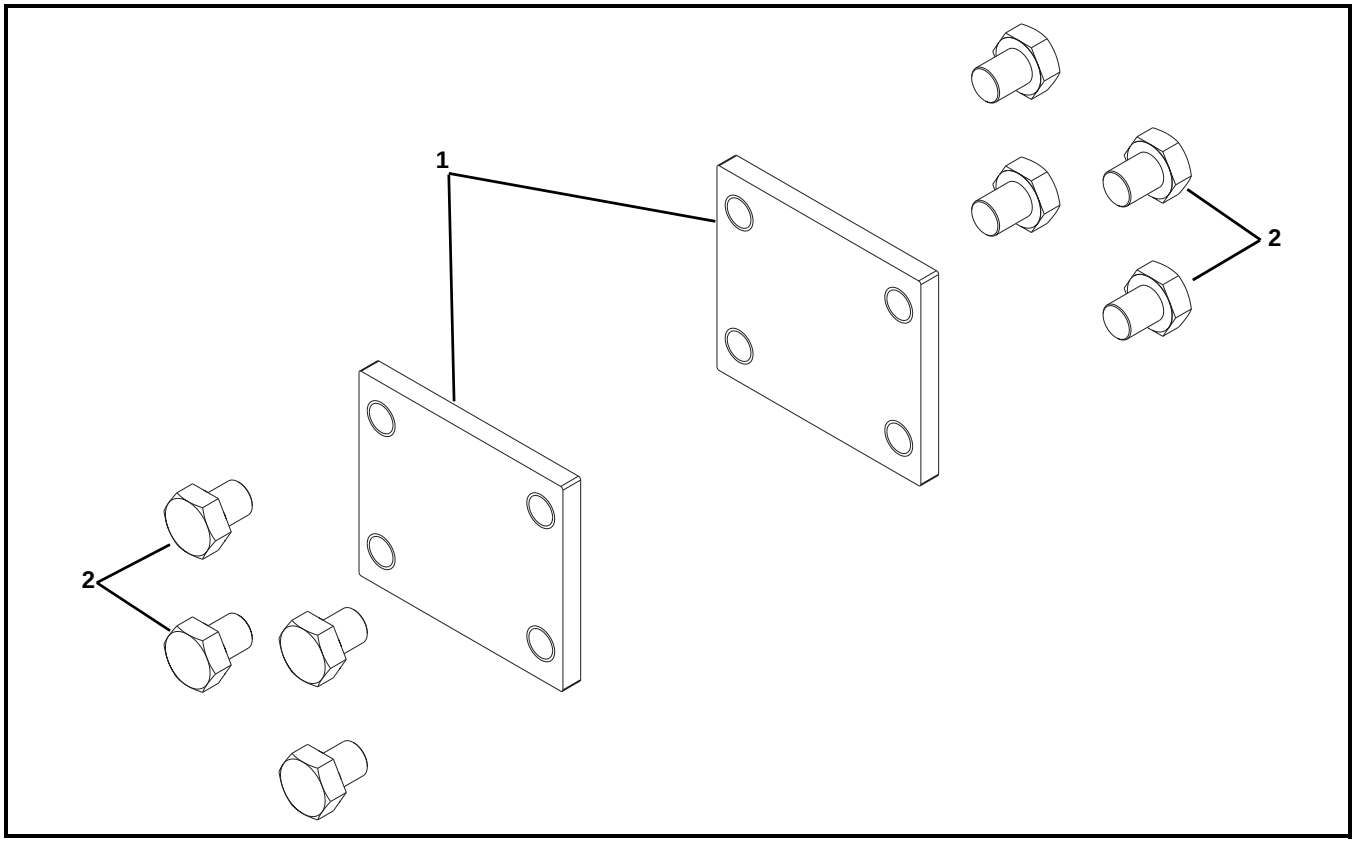
Lower Knuckle



Item	Part Number	Description
1	807-1838	Washer
2	807-1884	Sheet Metal Screw, #14 x 1.25
3	352324	Hold Down Guide
4	352326	Inner Belt Return Guide
5	500199	Connector
6	532351	Stub Shaft
7	532355-AA	Side Plate

Item	Part Number	Description
8	532359	Hold Down Roller Guard
9	532379	Hold Down Roller Spacer
10	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
11	961012MSS	Hex Head Cap Screw, M10-1.50 x 12 mm
12	735LN	Lower Knuckle Kit (Includes Items 3, 4 and 9)
AA = Angle 05, 10, 15, 30, 45 or 60		

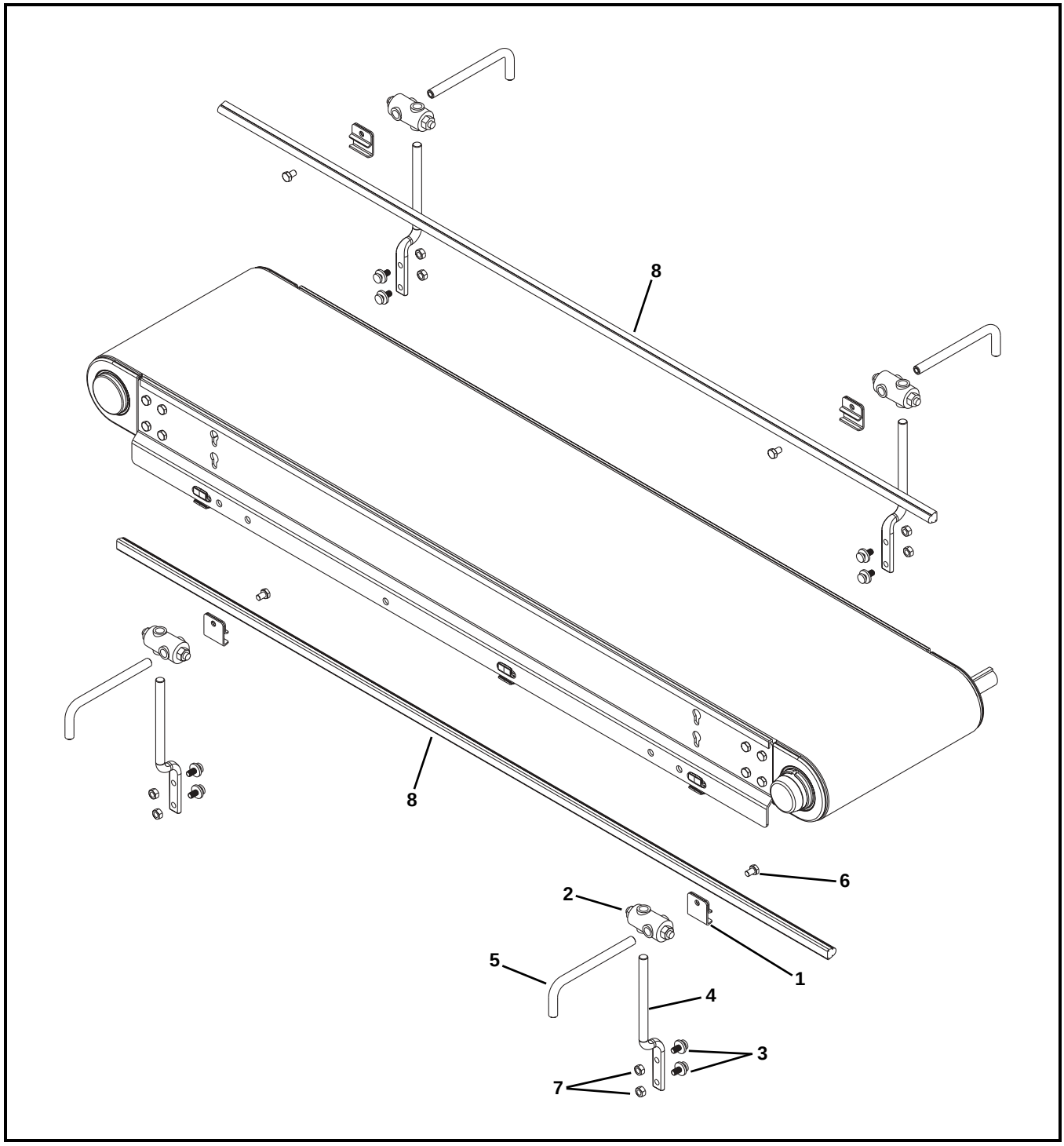
Connecting Assembly



Item	Part Number	Description
1	532157	Connector Plate
2	961012MSS	Hex Head Cap Screw M10-1.50 x 12mm

Service Parts

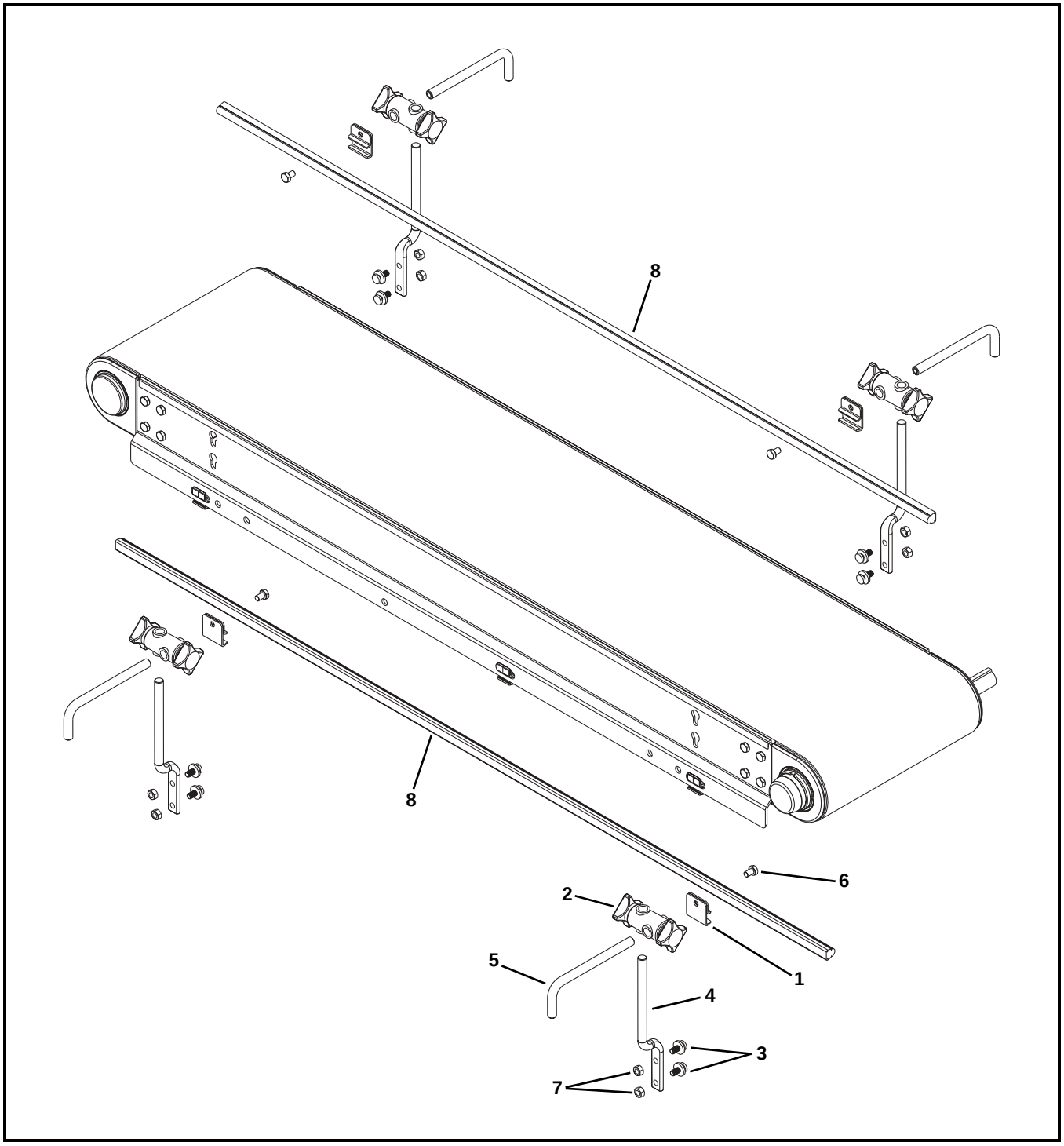
Fully Adjustable Round Guides



Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail for Straight Conveyor Section
	532258-LLLLL	Round Guide Rail for Curve Conveyor Section
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Fully Adjustable Round Guides

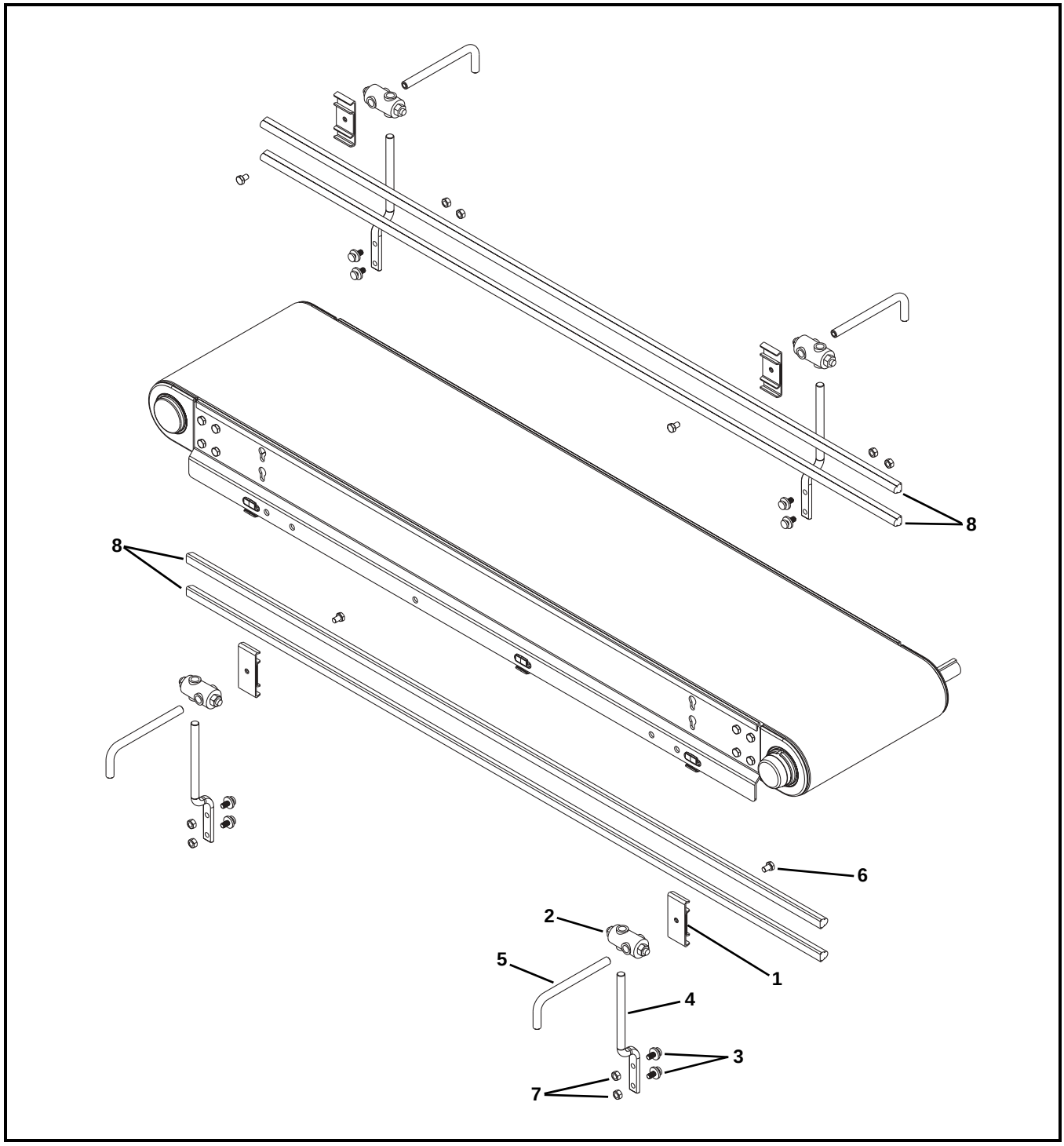


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail for Straight Conveyor Section
	532258-LLLLL	Round Guide Rail for Curve Conveyor Section
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

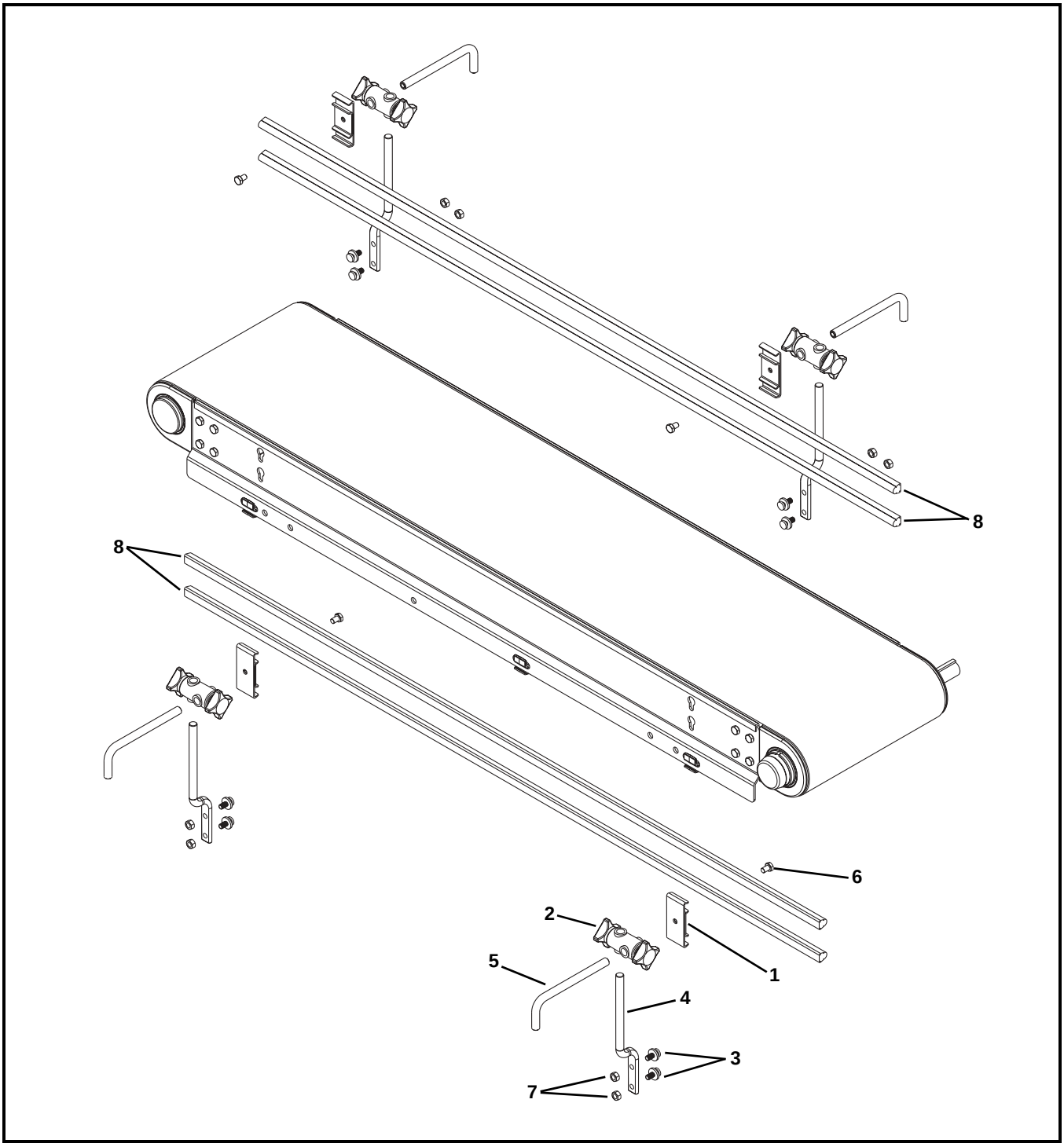
Twin Rail Adjustable Round Guides



Item	Part Number	Description
1	901414	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail for Straight Conveyor Section
	532258-LLLLL	Round Guide Rail for Curve Conveyor Section
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Twin Rail Adjustable Round Guides

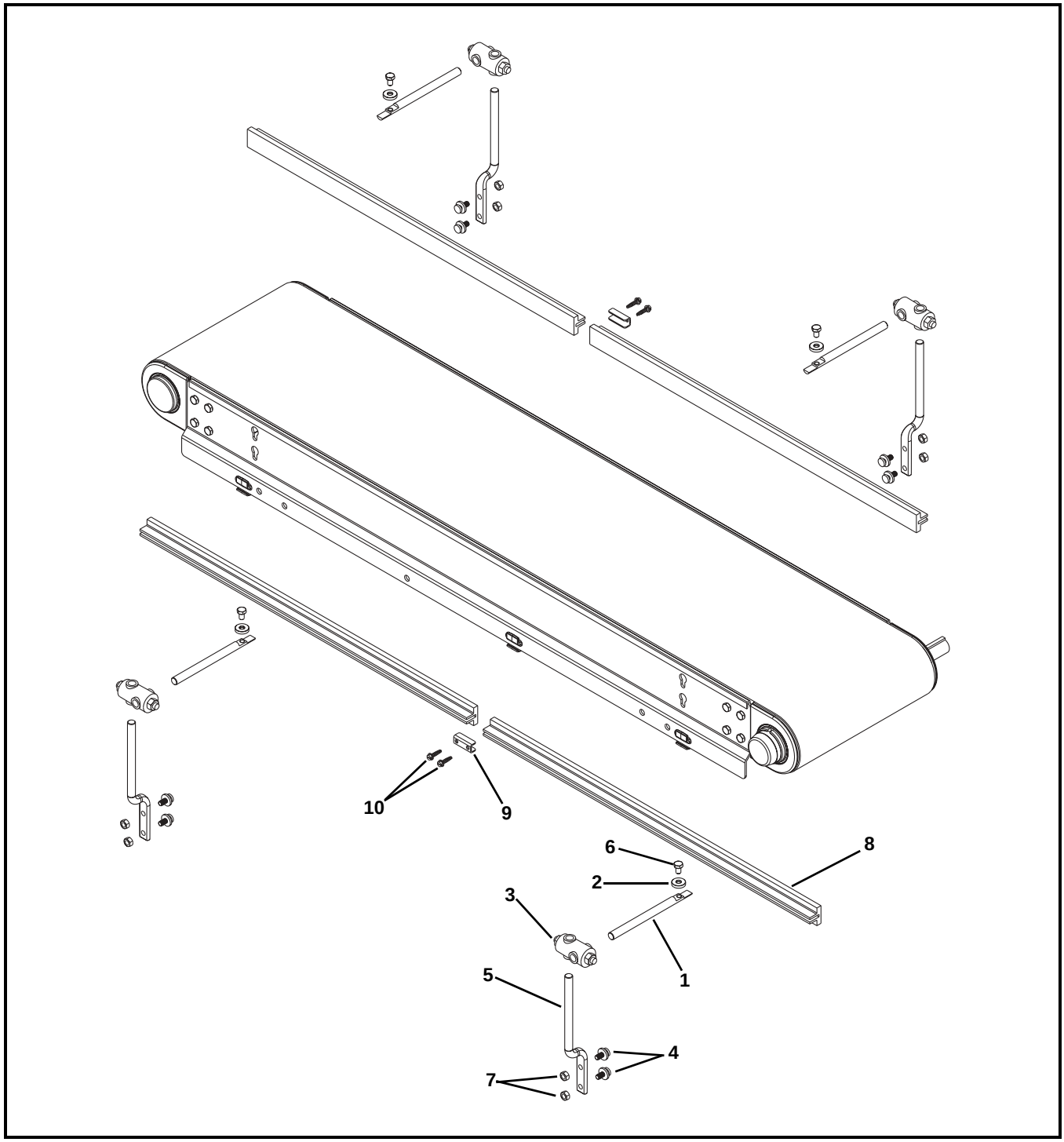


Item	Part Number	Description
1	901414	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail for Straight Conveyor Section
	532258-LLLLL	Round Guide Rail for Curve Conveyor Section
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

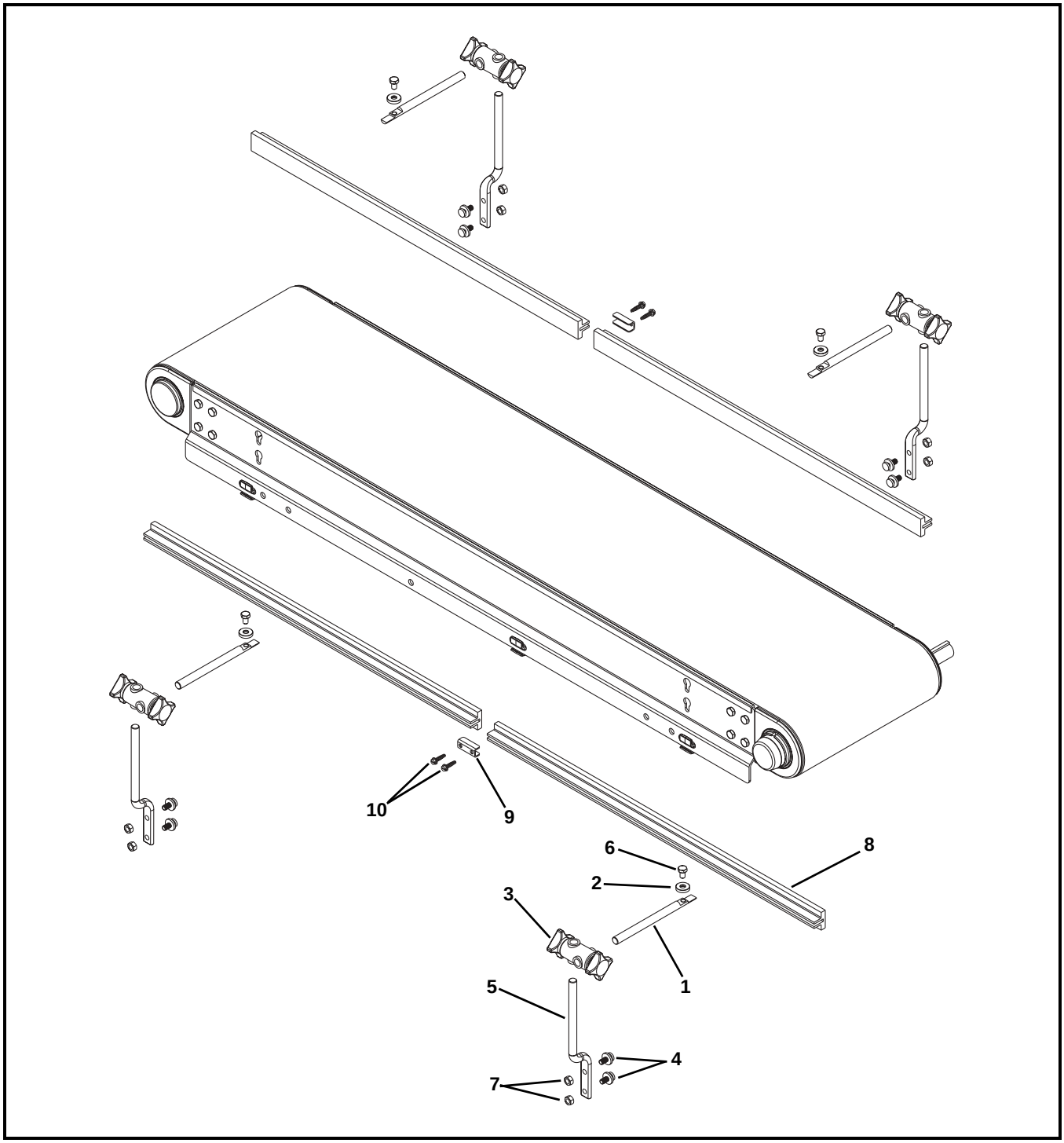
Fully Adjustable 1" (25 mm) Flat Guides



Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1387	Cross Block Clamp
4	532191	Carriage Bolt M8 x 20mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm
7	990801MSS	Hex Nut

Item	Part Number	Description
8	532170-LLLLL	Round Guide Rail
	532171-LLLLL	Round Guide Rail for Inside of Curve Section
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Fully Adjustable 1" (25 mm) Flat Guides



Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1470	Cross Block Clamp
4	532191	Carriage Bolt M8 x 20mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm
7	990801MSS	Hex Nut

Item	Part Number	Description
8	532170-LLLLL	Round Guide Rail
	532171-LLLLL	Round Guide Rail for Inside of Curve Section
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

Ordering a Replacement Chain

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

Example:

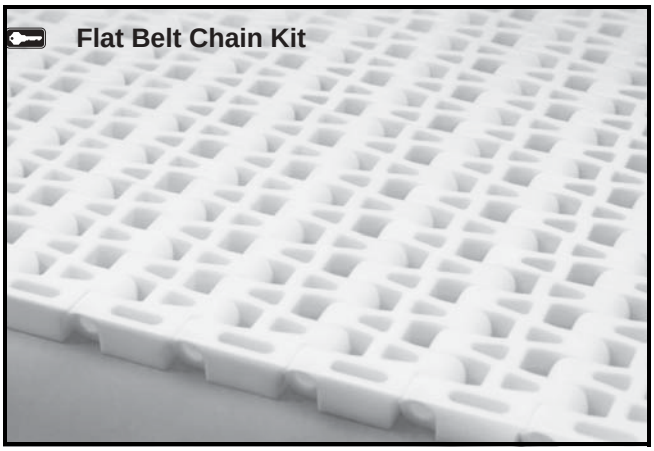
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 52BB-WW

BB = Chain reference number

WW = Conveyor width ref: 04-36 in 02 increments

Flat Belt Chain Repair Kit



Item	Part Number	Description
1	52BB-WW	Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
BB = Chain Reference number		
WW = Conveyor width ref: 04 - 36 in 02 increments		

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="9">Product Type</th></tr>
<tr><th></th><th colspan="8">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.

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

Outside the USA:
TEL 1-262-367-7600
FAX 1-262-367-5827

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