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. B

Table of Contents

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

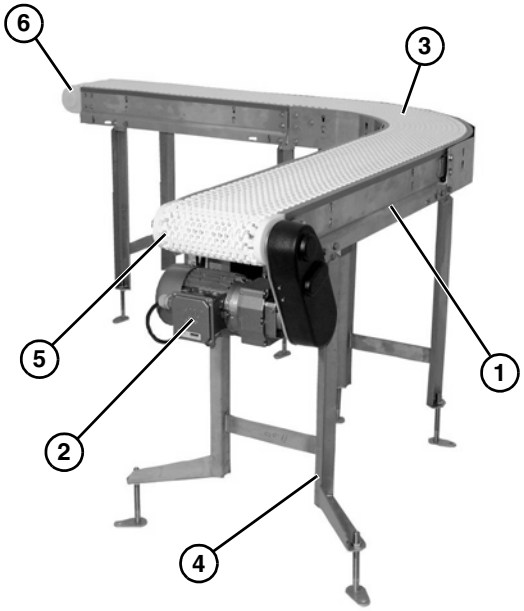


Figure 1

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

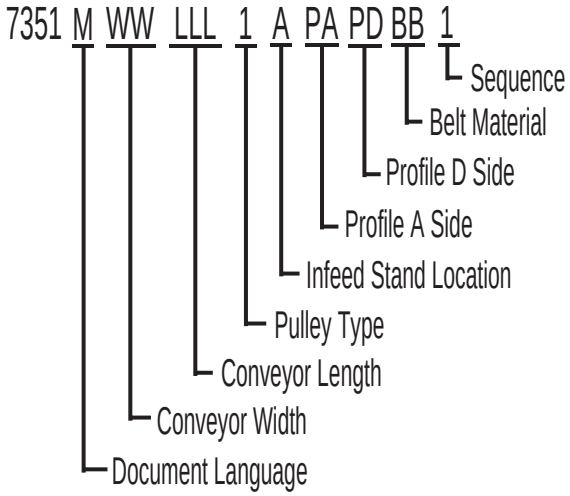
IMPORTANT

Maximum conveyor loads are based on:

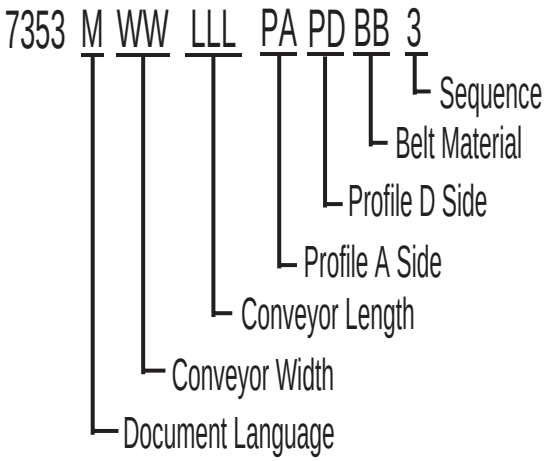
- *Non-accumulating product*
- *Product moving toward gearmotor*
- *Conveyor being mounted horizontally*
- *Conveyor being located in a dry environment*
- *Conveyor equipped with standard belt only*

7350 Series Curve Conveyor Modules

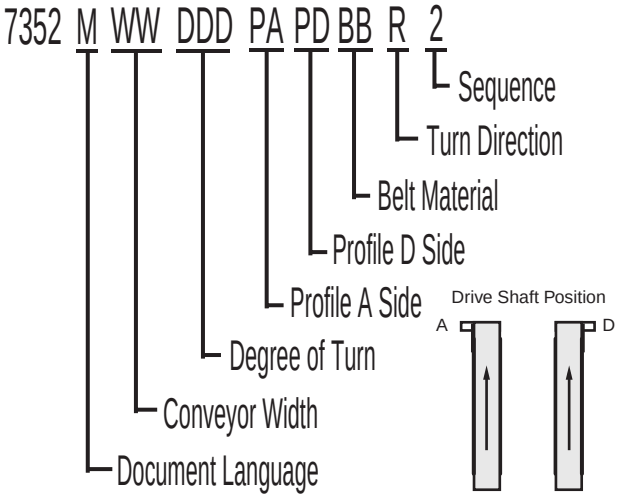
7350 Series Infeed / Idler Module



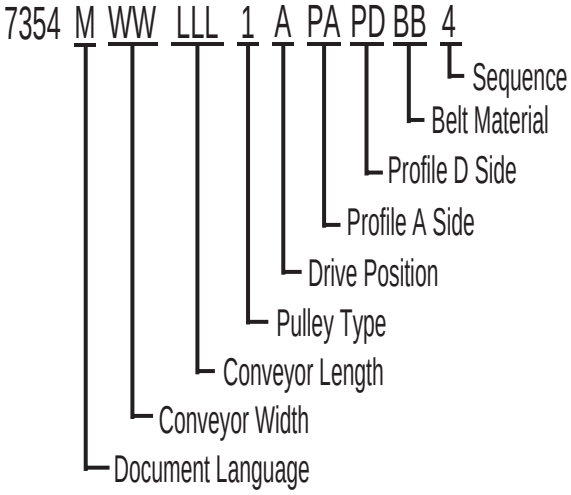
7350 Series Intermediate Module



7350 Series Curve Module



7350 Series Exit / Drive Module



Specifications

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’)

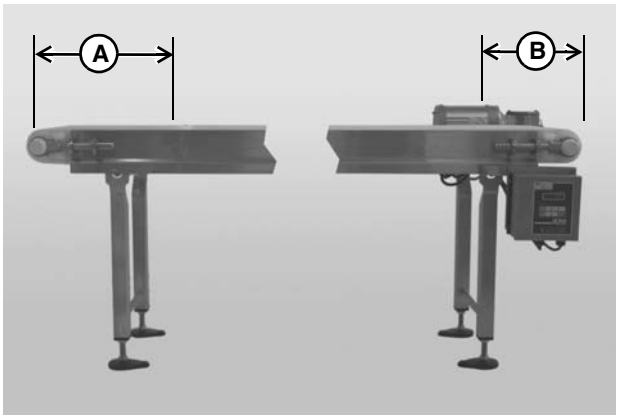


Figure 2

Curve Module:

- Reference chart for support stand quantities **(See Figure 3)**

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

Figure 3

CAUTION

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

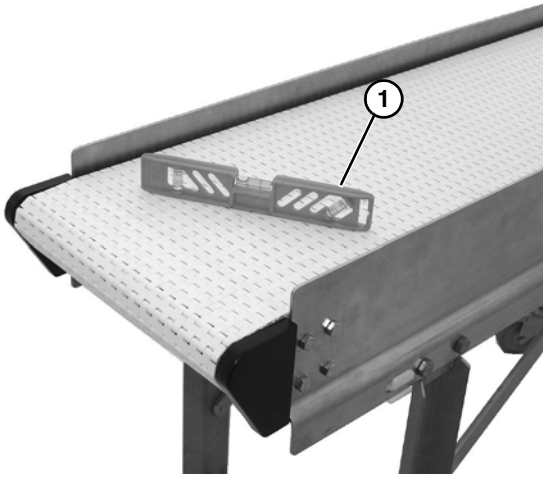


Figure 4

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 7 or “Belt Installation” on page 10.
2. Attach the stands. Refer to “Stand Installation” on page 9.
3. Install the belt. Refer to “Belt Installation” on page 10.
4. Install the gearmotor. Refer to “Drive Package Installation” on page 13.

Conveyors Longer than 10 ft (3048 mm)

Connecting Components

Typical Connecting Components **(Figure 5)**.

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

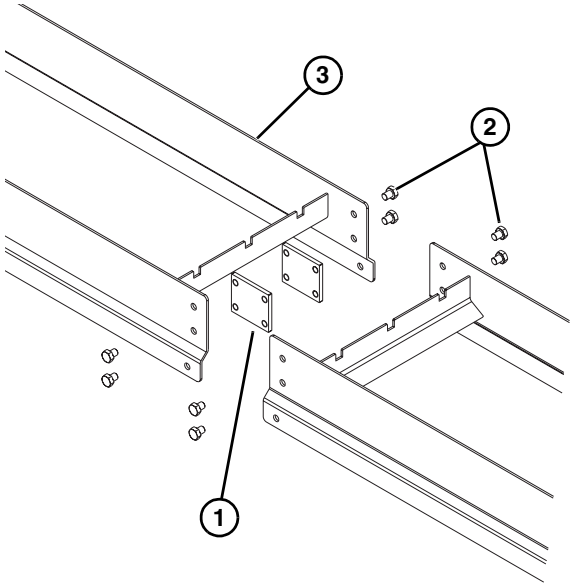


Figure 5

1. Join both conveyor sections, and install plate frame connectors **(Figure 5, item 1)**, and secure with M10x12 hex head cap screws **(Figure 5, item 2)** on both sides.

Installation

All Conveyors

Curve Connecting Components

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

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

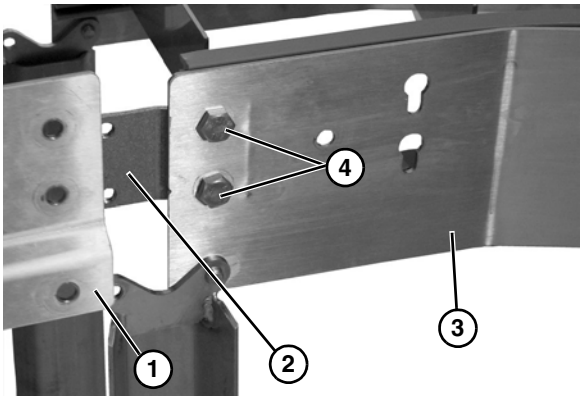


Figure 6

1. For joining curved to straight sections, install offset connecting plates onto curved section **(Figure 7, item 1)** with four hex head bolts **(Figure 7, item 2)** with heads of bolts outside of curved section.

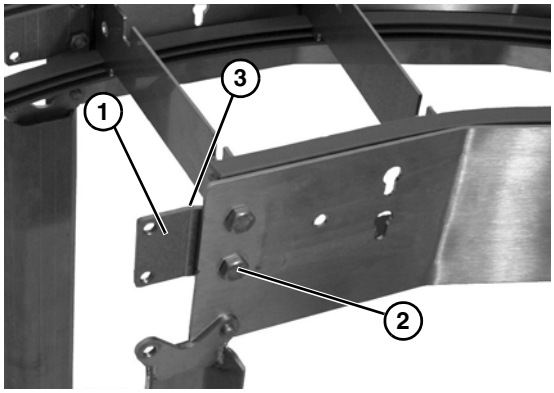


Figure 7

2. Ensure that the offset of connecting plates is to the inside of curved section **(Figure 7, item 3)**.

3. When securing straight section to curved section on inside curve **(Figure 8, item 1)** make sure offset plate is to the inside of straight section **(Figure 8, item 2)**.

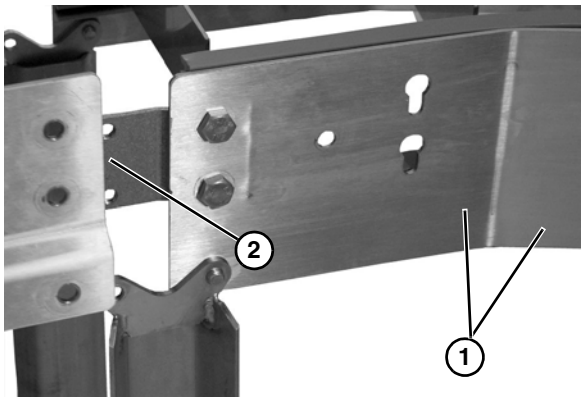


Figure 8

4. Secure straight section **(Figure 9, item 1)** onto curved section with two hex head bolts **(Figure 9, item 2)** with bolt heads to the outside as shown.

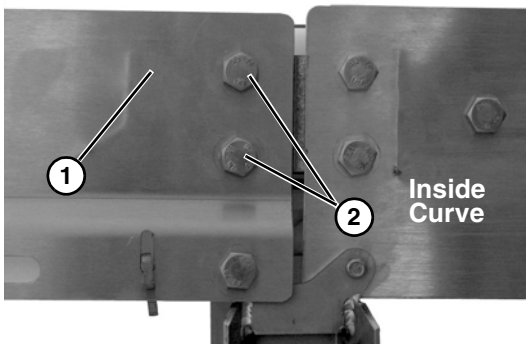


Figure 9

5. When securing straight section to curved section on outside curve **(Figure 10, item 1)** make sure offset plate **(Figure 10, item 2)** is to the outside of straight section.

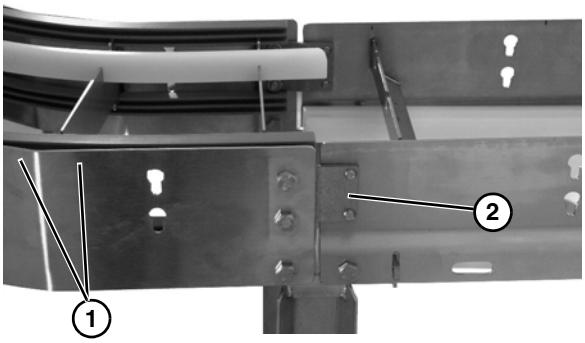


Figure 10

6. Secure straight section **(Figure 11, item 1)** onto curved section with two hex head bolts **(Figure 11, item 2)** with bolt heads to the inside as shown.

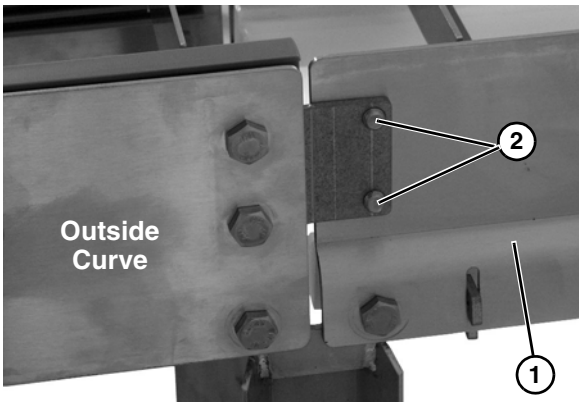


Figure 11

7. Tighten all hardware.

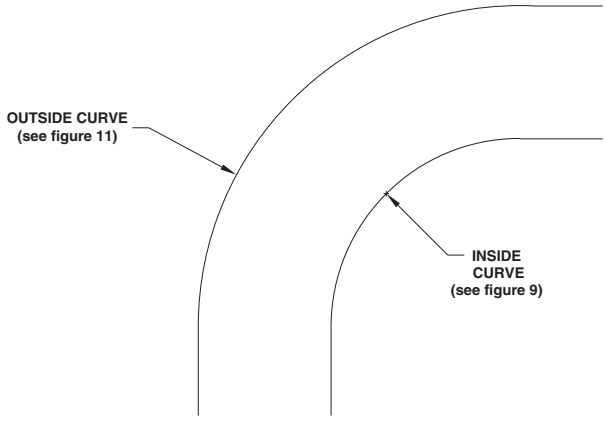


Figure 12

Stand Installation

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

Typical stand components **(Figure 13)**

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

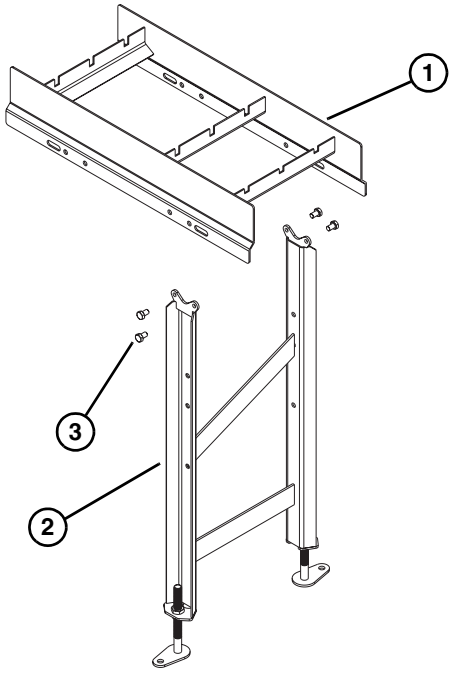


Figure 13

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame **(Figure 14, item 1)**.

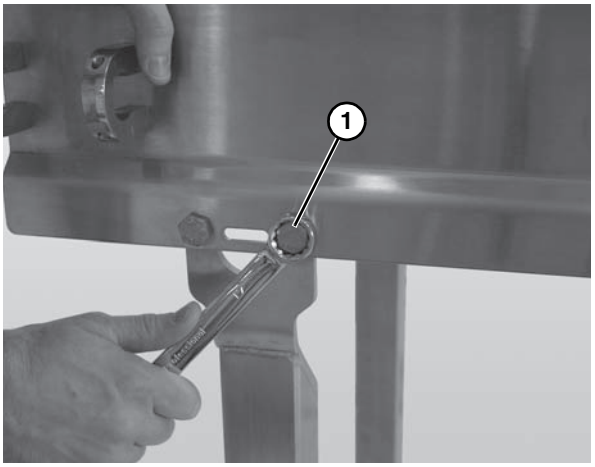


Figure 14

Installation

Belt Installation

Typical Belt Components **(Figure 15)**

1	Chain Belt
2	Belt Rod

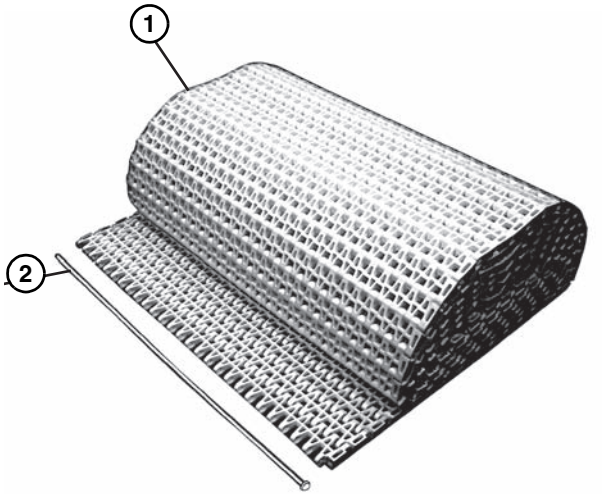


Figure 15

NOTE

*Ensure the belt is running in the correct direction, with hole **(Figure 16, item 1)** towards conveyor motor.*

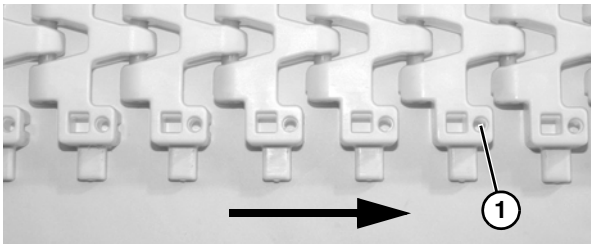


Figure 16

1. Position the belt on the conveyor frame **(Figure 17)**.

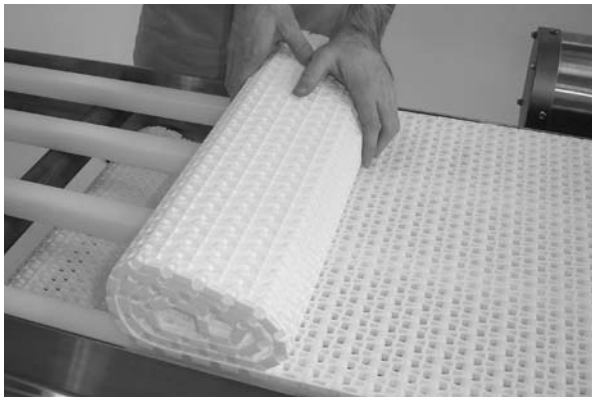


Figure 17

2. Wrap belt around idler tail.

3. Feed the ends of the belt through the top and bottom of the curved frame sections **(Figure 18)**.

Figure 18

4. Be sure belt tabs are seated in the lower channel of bottom belt guide **(Figure 19, item 1)** and upper channel of top belt guide **(Figure 19, item 2)**.

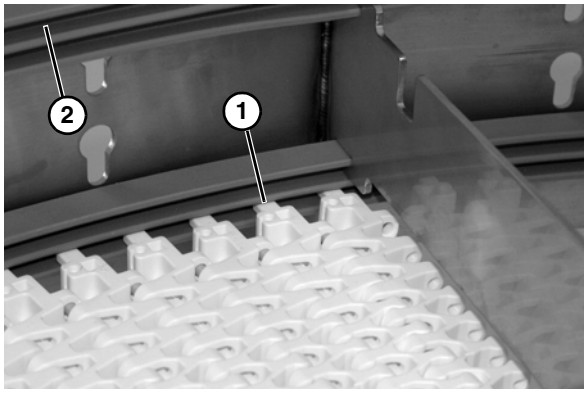


Figure 19

5. When feeding belt through straight section, be sure belt tabs ride on top lip of belt return **(Figure 20, item 1)**.

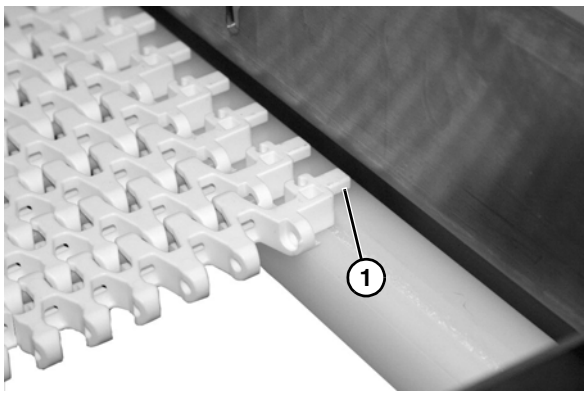


Figure 20

6. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth **(Figure 21, item 1)** mating with rounded section **(Figure 21, item 2)** of belt.

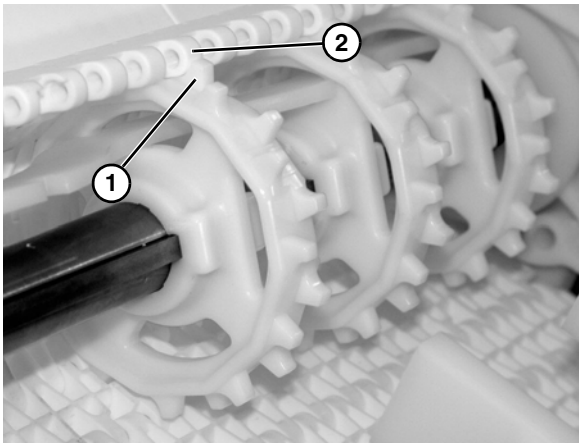


Figure 21

7. Bring the ends of the belt together **(Figure 22)**.

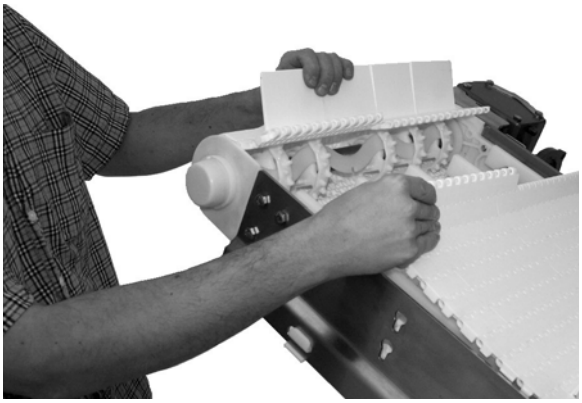


Figure 22

8. Insert the belt rod **(Figure 23, item 1)**.

Figure 23

9. Push the belt rod in as far as possible.
10. Lightly tap the head of the rod with a hammer until it snaps into position.
11. Install the top bar caps **(Figure 24, item 1)** on the conveyor frame with wide lip facing up to cover the belt tabs.

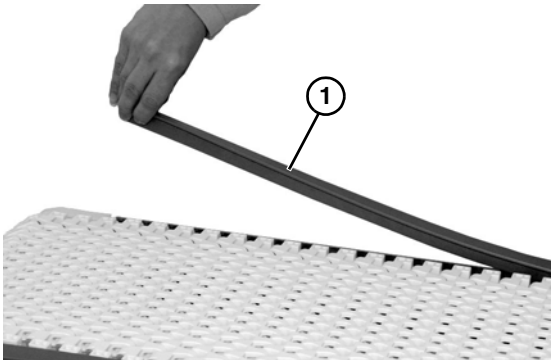


Figure 24

⚠ 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.

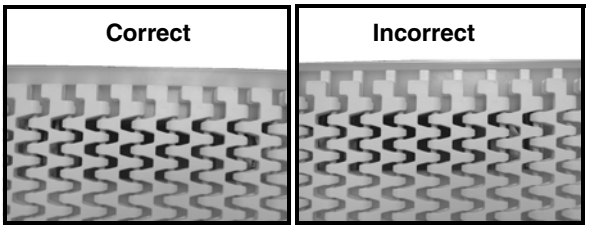


Figure 25

NOTE

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

Installation

Belt Returns

1. Install belt return mounting bracket **(Figure 26, item 1)** into slotted frame hole **(Figure 26, item 2)**.

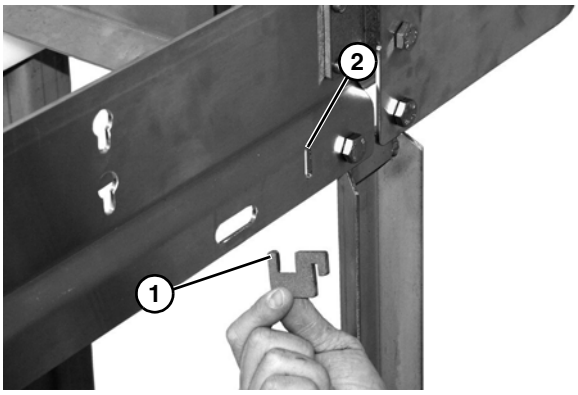


Figure 26

2. Install belt return **(Figure 27, item 1)** onto mounting bracket **(Figure 27, item 2)**.

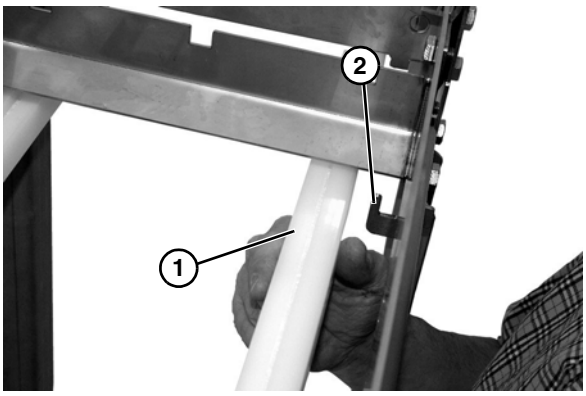


Figure 27

Guide Installation

1. Insert carriage bolts with spacers **(Figure 28, item 1)** into slotted holes in conveyor side.

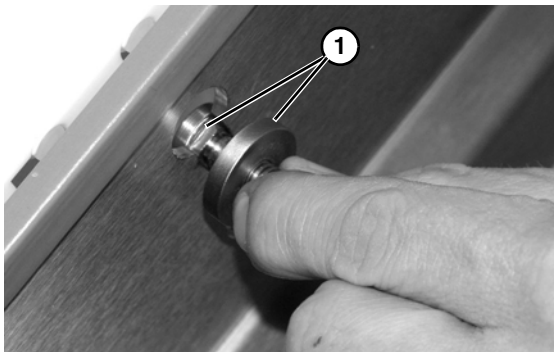


Figure 28

2. Attach the guide mounting brackets **(Figure 29, item 1)** to the conveyor with hex nuts **(Figure 29, item 2)**. Hand tighten only at this time.

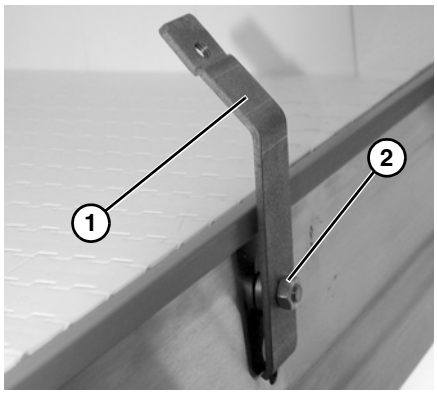


Figure 29

3. Attach guide **(Figure 30, item 1)** to the mounting brackets with hex bolts and spacers **(Figure 30, item 2)**. Hand tighten only at this time.

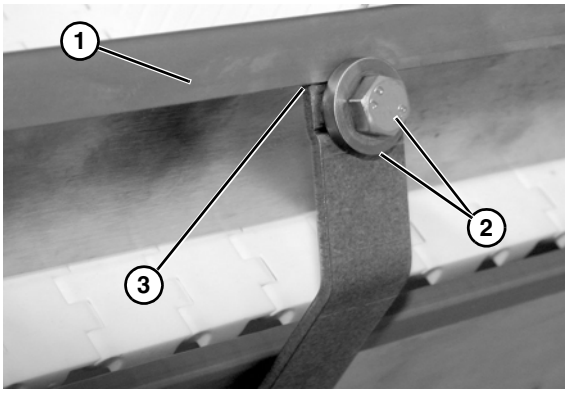


Figure 30

4. Ensure that nose of bracket slips under the lip of guide **(Figure 30, item 3)**.

NOTE

When installing guides, be sure that the angled end of guide is installed on the idler end of conveyor ***(Figure 31, item 1)****.*

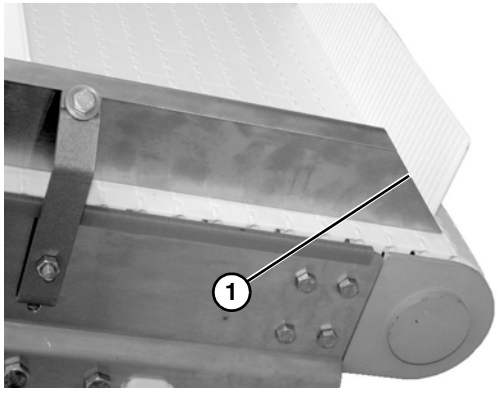


Figure 31

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°
- 851-680 Side Mount Nose Bar Drive Package
- 851-681 Bottom Mount 90° Drive Package
- 851-682 Bottom Mount Parallel Shaft Drive Package

1. Attach the motor **(Figure 32, item 1)** to the gear reducer **(Figure 32, item 2)**.

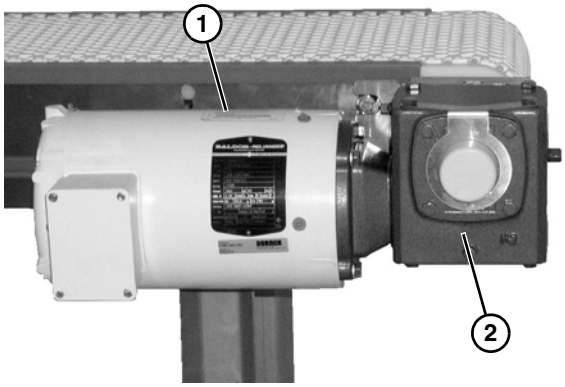


Figure 32

Preventive Maintenance and Adjustment

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 22 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

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.

1. Remove guides **(Figure 33, item 1)** when required.

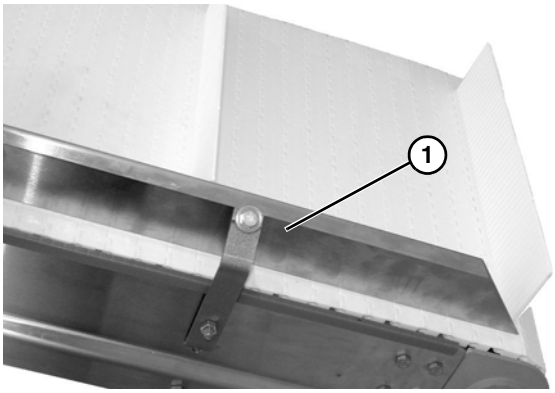


Figure 33

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head **(Figure 34)**.

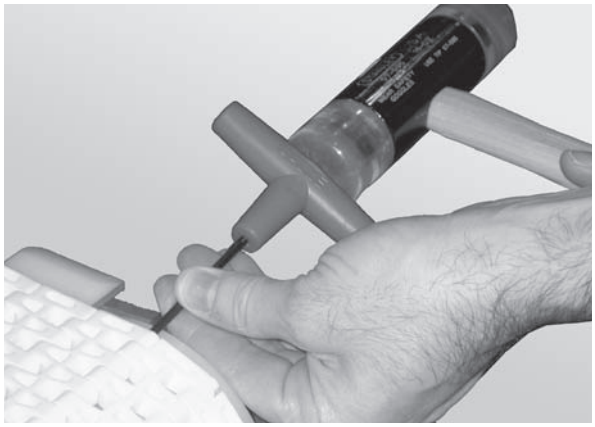


Figure 34

3. Slide the old belt off the conveyor frame.
4. Replace the old belt with a new one. Refer to “Belt Installation” on page 10.

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.

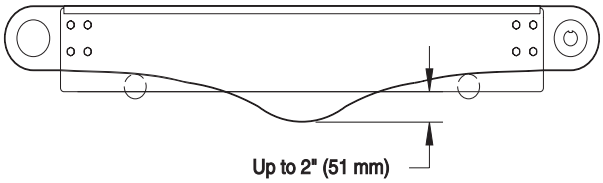


Figure 35

CAUTION

Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame (Figure 35).

Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips **(Figure 36)**

1	Bar Cap
2	Wear Strips, Bed Frame

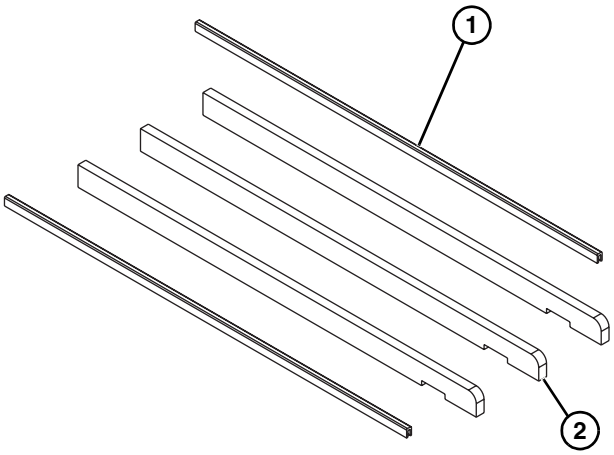


Figure 36

Bar Cap Replacement

1. Remove worn bar cap **(Figure 37, item 1)** by lifting off of conveyor side rail.

Figure 37

2. Replace with new bar cap.

Wear Strip Removal

1. Remove conveyor belt. See “Conveyor Belt Replacement” on page 15.
2. Remove worn wear strips **(Figure 38, item 1)** from frame notches.

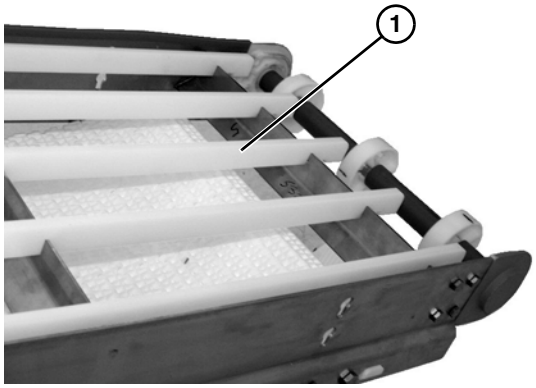


Figure 38

3. Remove curved wear strips from frame notches **(Figure 39, item 1)** when worn.

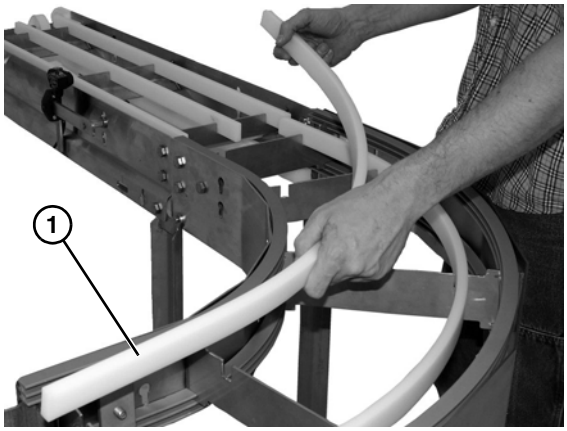


Figure 39

4. Replace with new wear strips.

Belt Guides

Open conveyor belt. See “Conveyor Belt Replacement” on page 15.

Removal

1. Remove the hex head bolt **(Figure 40, item 1)** retaining the wear strip support bracket **(Figure 40, item 2)** from both ends of curve conveyor (for conveyors 4" - 10" wide only).

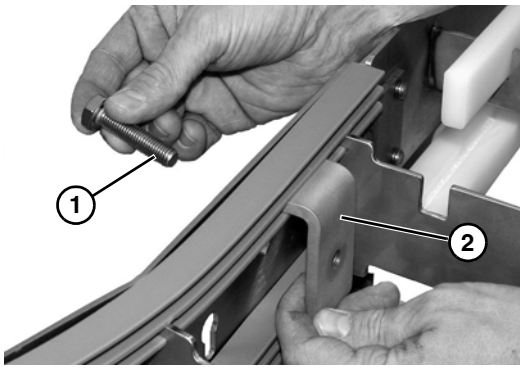


Figure 40

2. Remove two hex head bolts **(Figure 41, item 1)** holding straight section frame to section connecting bracket **(Figure 41, item 2)**. Repeat on opposite side.

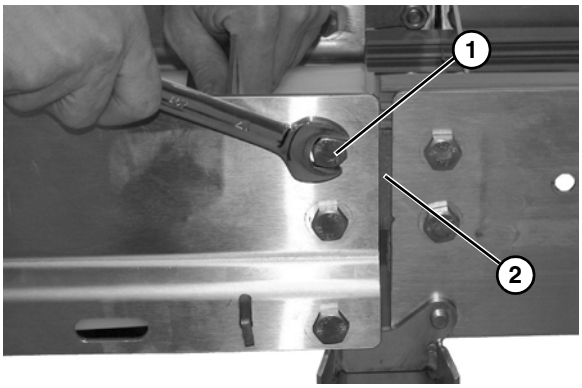


Figure 41

3. Remove hex head bolt **(Figure 42, item 1)** holding straight section frame to conveyor stand **(Figure 42, item 2)**. Repeat on opposite side.

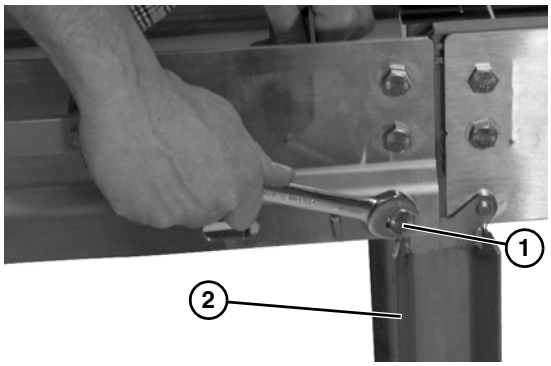


Figure 42

4. Lift up on straight section **(Figure 43, item 1)** and remove from curve section and conveyor stand **(Figure 43, item 2)**. Be sure to support free end of straight section once removed.

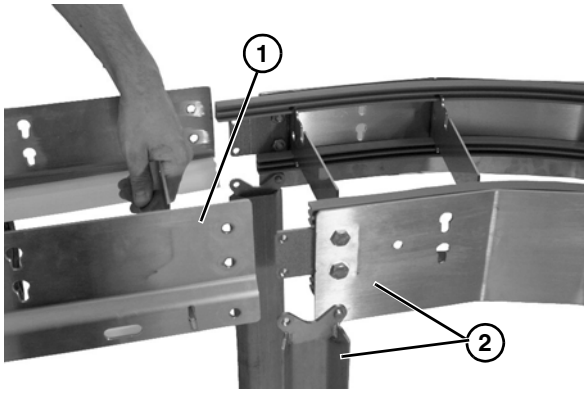


Figure 43

5. Slide off inner **(Figure 44, item 1)** and outer **(Figure 44, item 2)** belt guides.

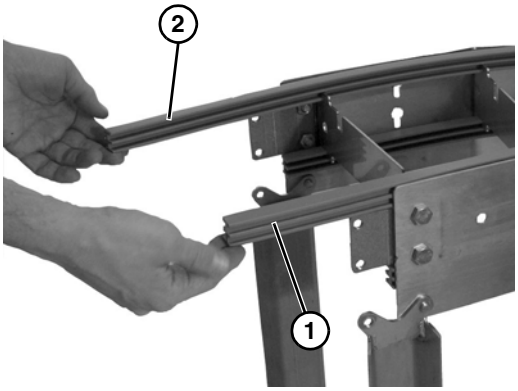


Figure 44

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 15.
3. Remove bearing cover **(Figure 45, item 1)**.

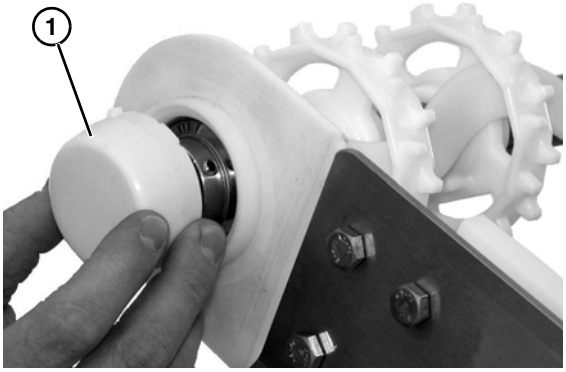


Figure 45

4. Remove the four head plate bolts **(Figure 46, item 1)** on both sides of the conveyor.

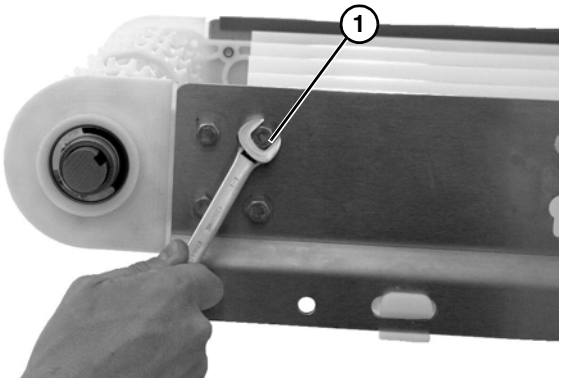


Figure 46

5. Remove tail assembly.
6. Loosen set screws **(Figure 47, item 1)**.

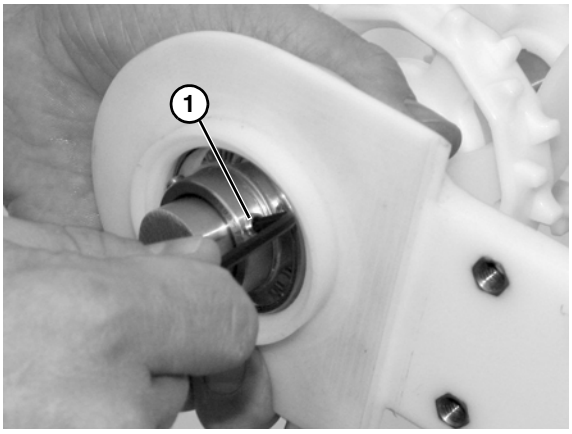


Figure 47

7. Slide the head plate with bearing **(Figure 48, item 1)** off the shaft.

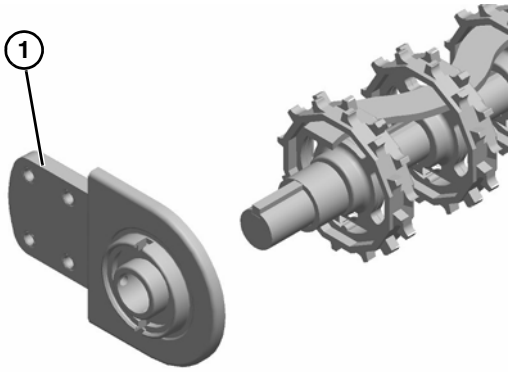


Figure 48

8. Slide off drive sprocket spacer **(Figure 49, item 1)**.

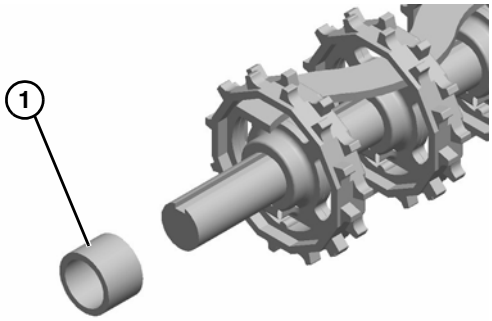


Figure 49

9. Slide entire sprocket assembly slightly outward, and remove the first sprocket **(Figure 50, item 1)** off the drive spindle and alignment bar. **(Figure 50, item 2).**

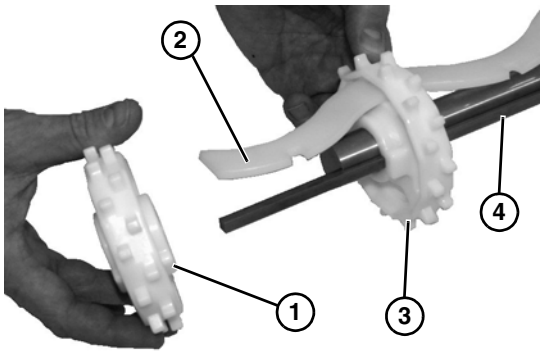


Figure 50

10. Remove remaining sprockets **(Figure 50, item 3)** off the alignment bar as you slide entire assembly off the drive spindle **(Figure 50, 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 15.

2. Remove four head plate bolts **(Figure 51, item 1)**. Repeat on opposite side.

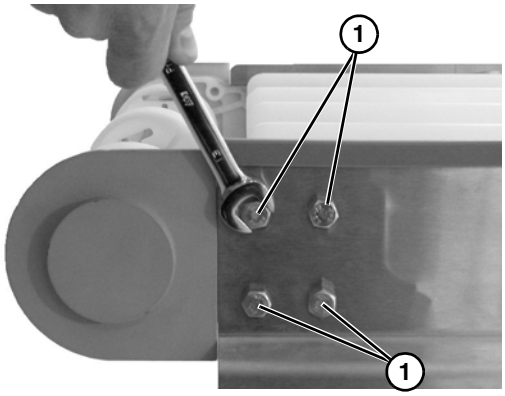


Figure 51

3. Remove idler tail assembly **(Figure 52, item 1)**.

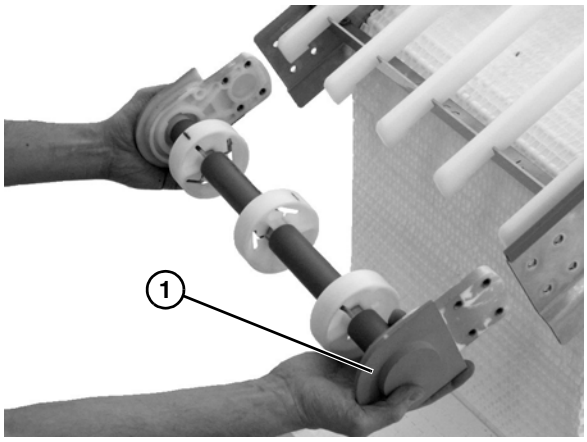


Figure 52

4. Slide off idler head plate **(Figure 53, item 1)** from shaft **(Figure 53, item 2)**.

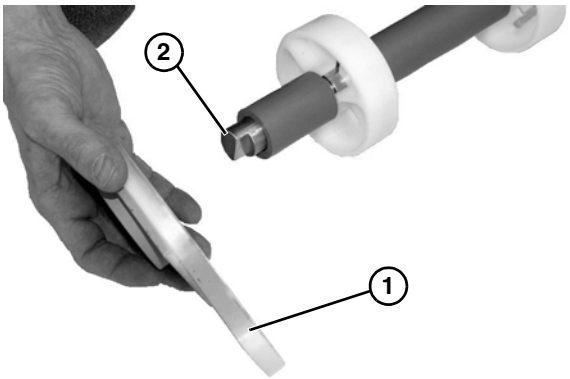


Figure 53

5. Slide off the round puck spacer **(Figure 54, item 1)**.

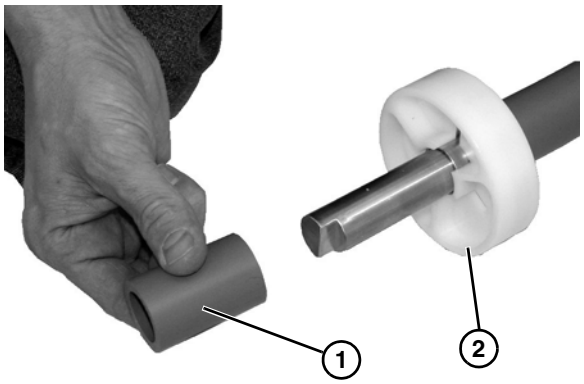


Figure 54

6. Slide off puck and replace **(Figure 54, 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 18. Follow steps 1 through 7.
2. Twist the bearing out **(Figure 55, item 1)**.

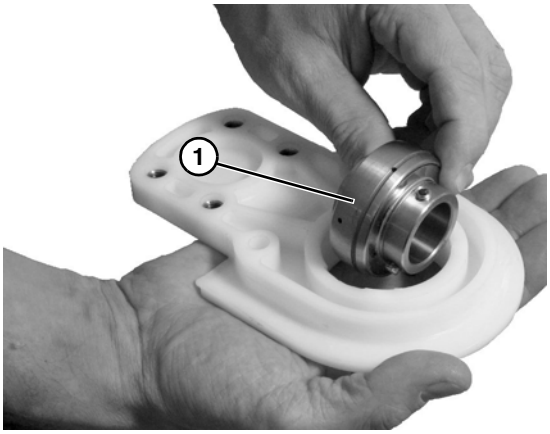


Figure 55

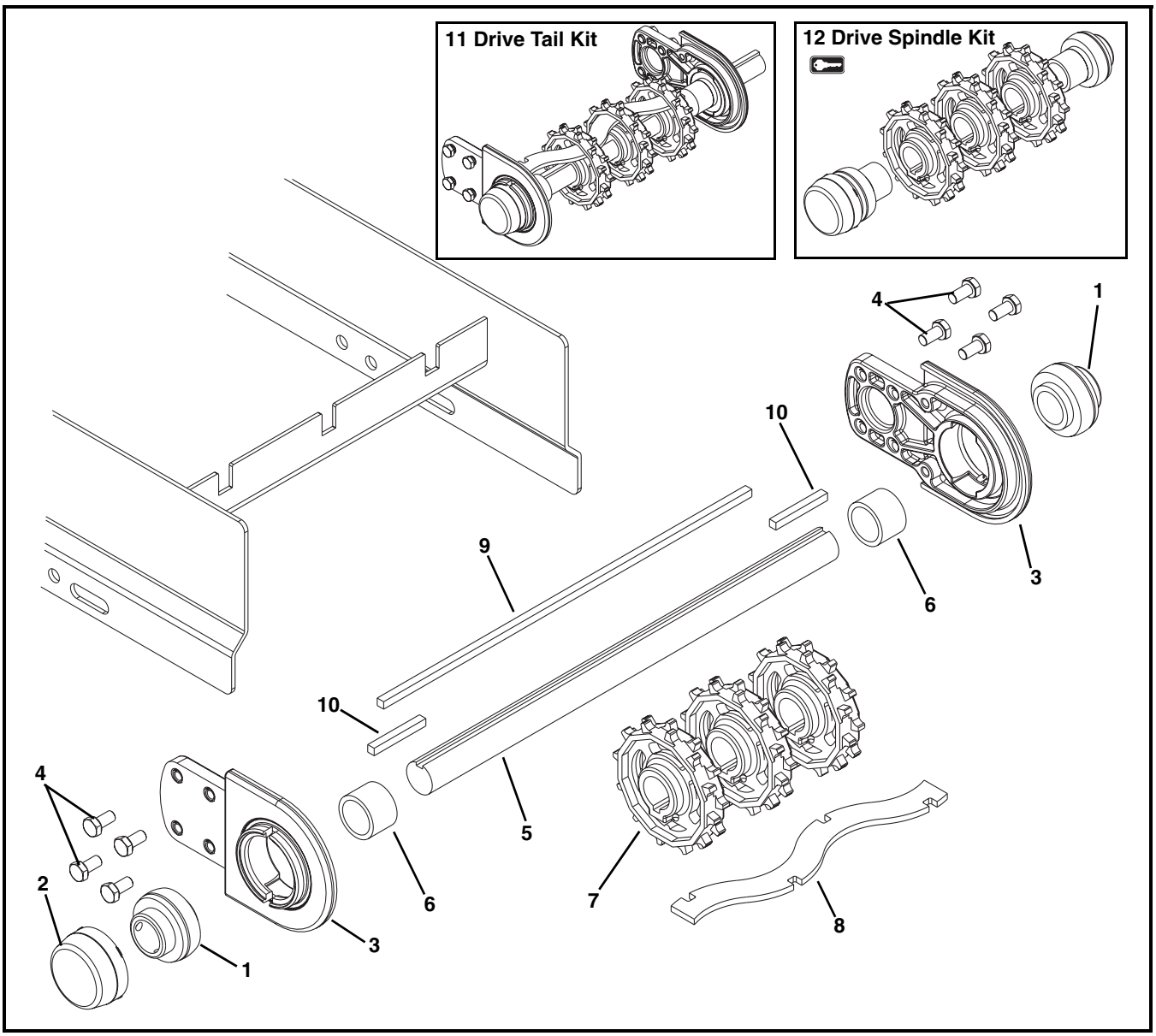
3. Replace bearing.

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



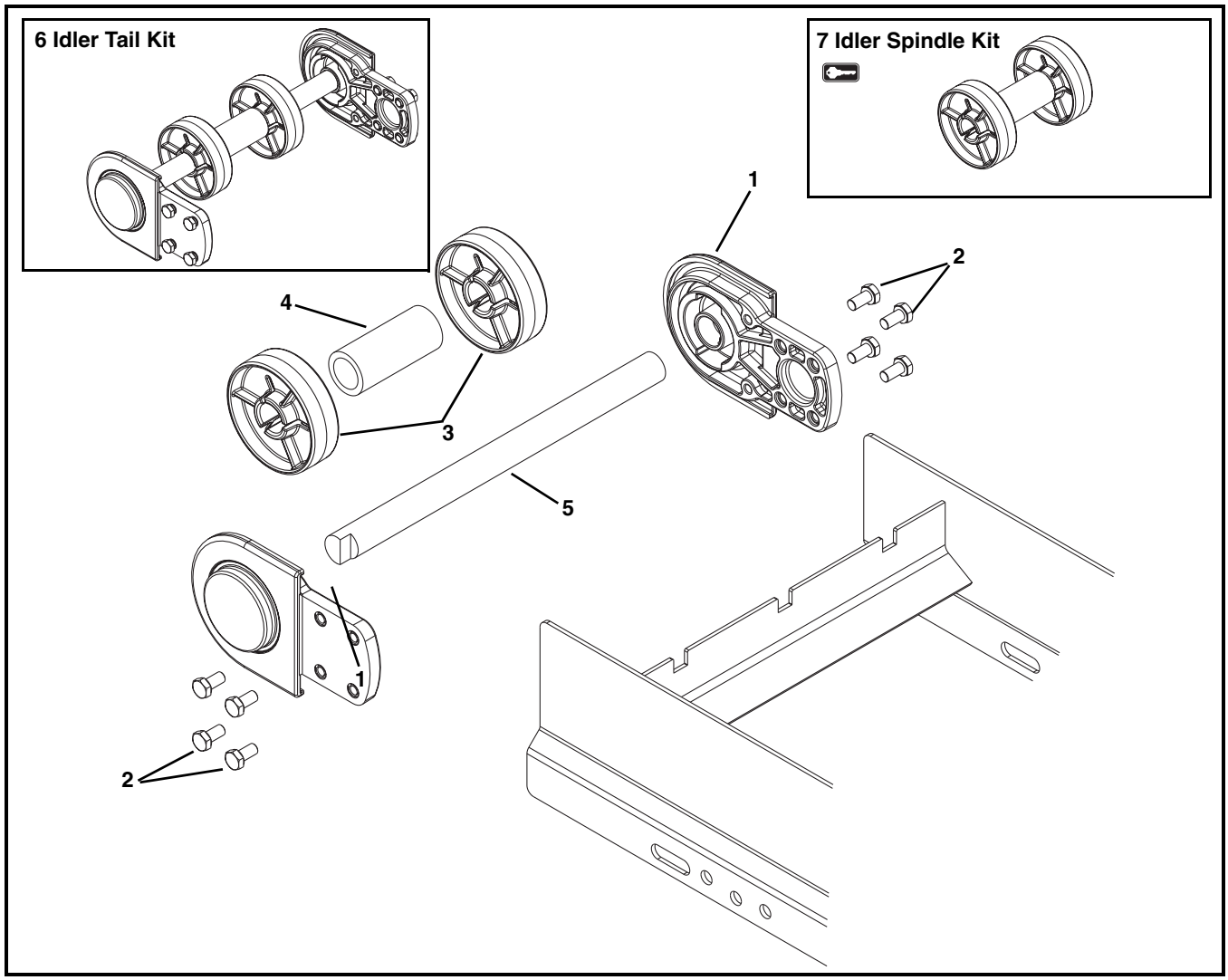
Item	Part Number	Description
1	735BK	Bearing Kit (Qty. 2)
2*	807-1454	Bearing Cap
3	532013	Headplate
4	960816MSS	Hex Head Cap Screw M8-1.25 x 16mm
5	See Drive Spindle Chart	Spindle
6	532251-LLLLL	Sprocket Spacer
7	807-1754	Sprocket
8	532124-WW	Sprocket Alignment Bar (for 10" - 36" wide only
9	532121-LLLLL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

Item	Part Number	Description
11	735CBDT-WW	Drive Tail Kit for Bottom Mount (Includes items 1 through 10)
	735CSDT-WW	Drive Tail Kit for Side Mount (Includes items 1 through 10)
	735CDBDT-WW	Drive Tail Kit for Bottom Mount, with Double Output Shafts (Includes items 1 through 10)
	735CDSDT-WW	Drive Tail Kit for Side Mount, with Double Output Shafts (Includes items 1 through 10)
12	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				
Conveyor Width	**Bottom Mount**	**Side Mount**	**Bottom Mount with Double Output Shaft**	**Side Mount with Double Output Shaft**
4"	532113-00859	532232-01280	532113-01038	532232-01460
6"	532113-01059	532232-01480	532113-01238	532232-01660
8"	532113-01247	532232-01668	532113-01426	532232-01848
10"	532113-01448	532232-01869	532113-01627	532232-02049
12"	532113-01637	532232-02058	532113-01816	532232-02238
14"	532113-01834	532232-02255	532113-02013	532232-02435
16"	532113-02031	532232-02452	532113-02210	532232-02632
18"	532113-02225	532232-02646	532113-02404	532232-02826
20"	532113-02422	532232-02843	532113-02601	532232-03023
22"	532113-02618	532232-03039	532113-02797	532232-03219
24"	532113-02815	532232-03236	532113-02994	532232-03416
26"	532113-03008	532232-03429	532113-03187	532232-03609
28"	532113-03205	532232-03626	532113-03384	532232-03806
30"	532113-03399	532232-03820	532113-03578	532232-04000
32"	532113-03596	532232-04017	532113-03775	532232-04197
34"	532113-03792	532232-04213	532113-03971	532232-04393
36"	532113-03989	532232-04410	532113-04168	532232-04590

Service Parts

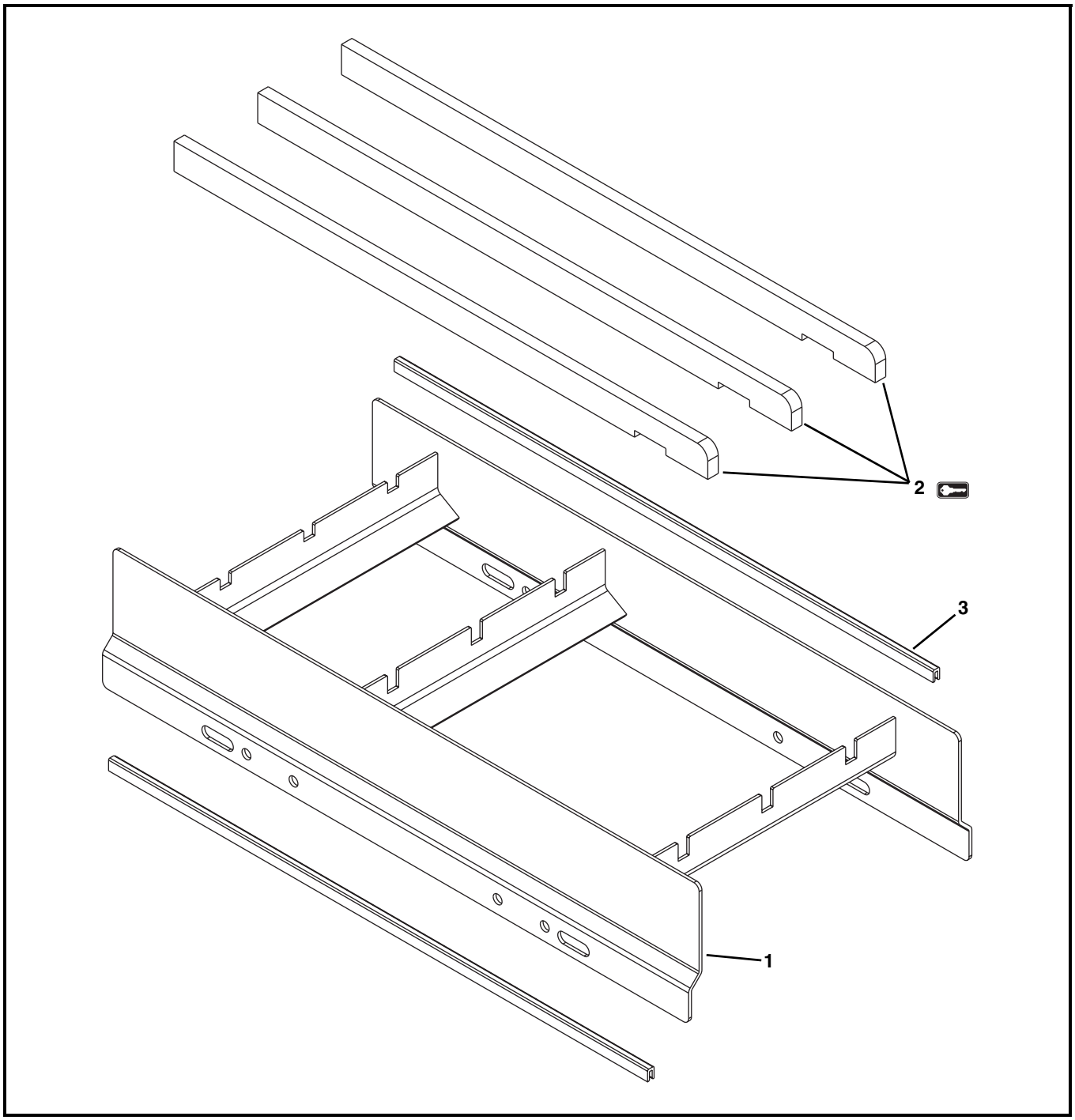
Idler End Components



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"	532118-00503
6"	532118-00703
8"	532118-00891
10"	532118-01092
12"	532118-01281
14"	532118-01478
16"	532118-01675
18"	532118-01869
20"	532118-02066
22"	532118-02262
24"	532118-02459
26"	532118-02652
28"	532118-02849
30"	532118-03043
32"	532118-03240
34"	532118-03436
36"	532118-03633

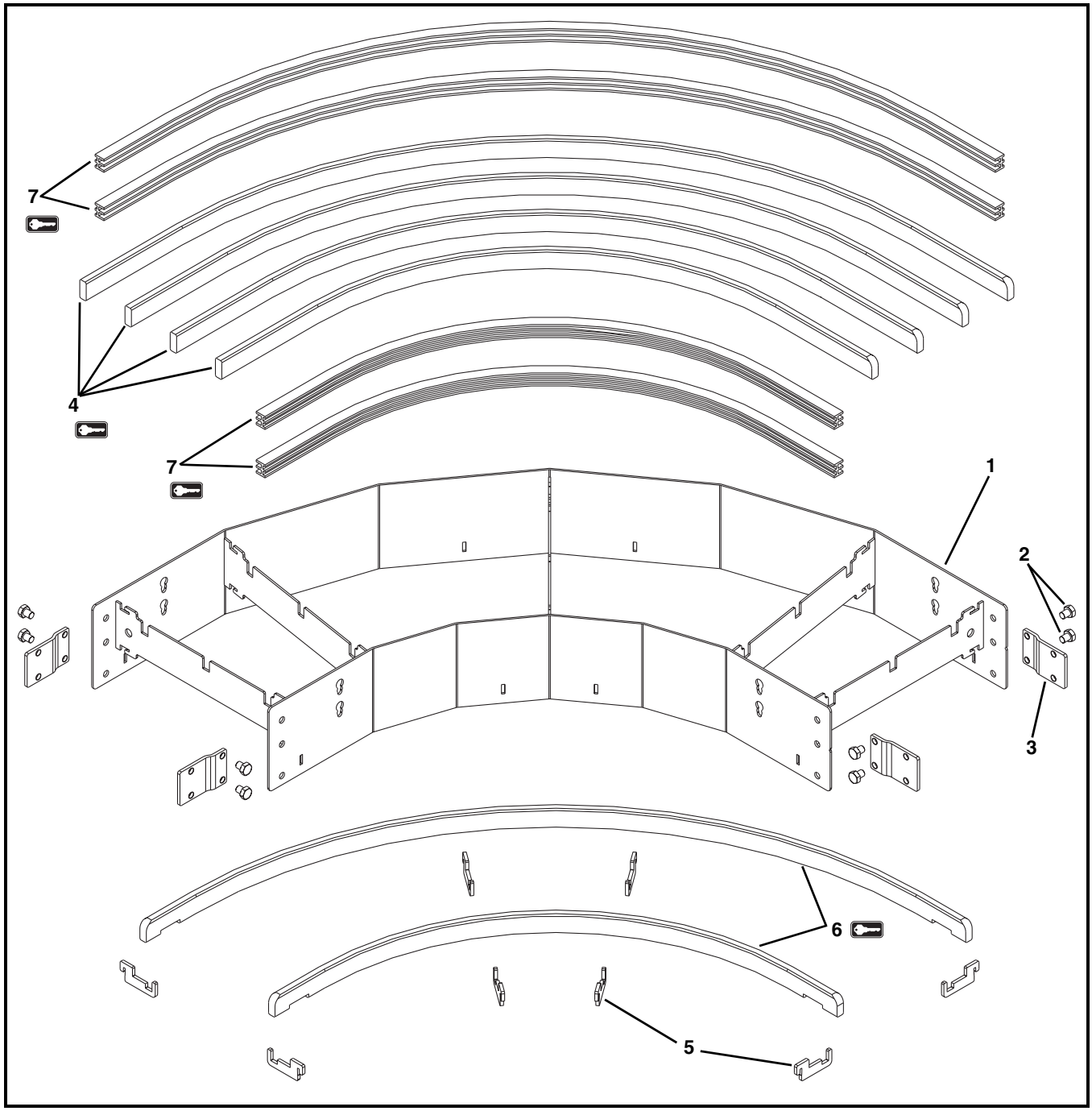
Frame Assembly



Item	Part Number	Description
1	----------	Consult Factory for Frame Part Number
2	532223-LLLLL	Wear Strip
3	532225-LLLLL	Bar Cap
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

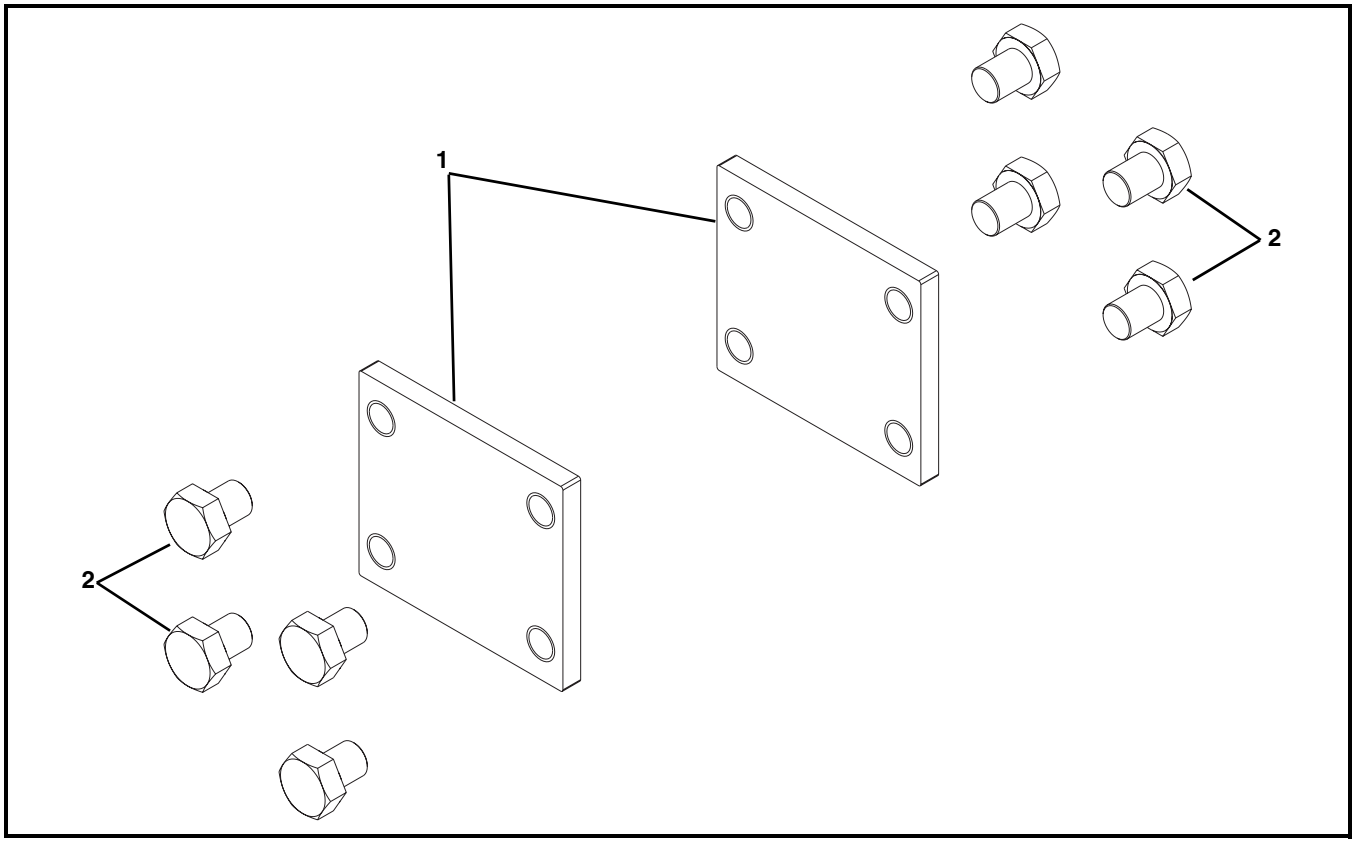
Curve Conveyor Frame and Wear Strips



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

Item	Part Number	Description
5	532152	Return Support
	532154	Front Return Support for Conveyors 26" or Wider
6	532223-LLLLL	Wear Strips for Returns
7	532164-LLLLL	Wear Strip for Edges
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

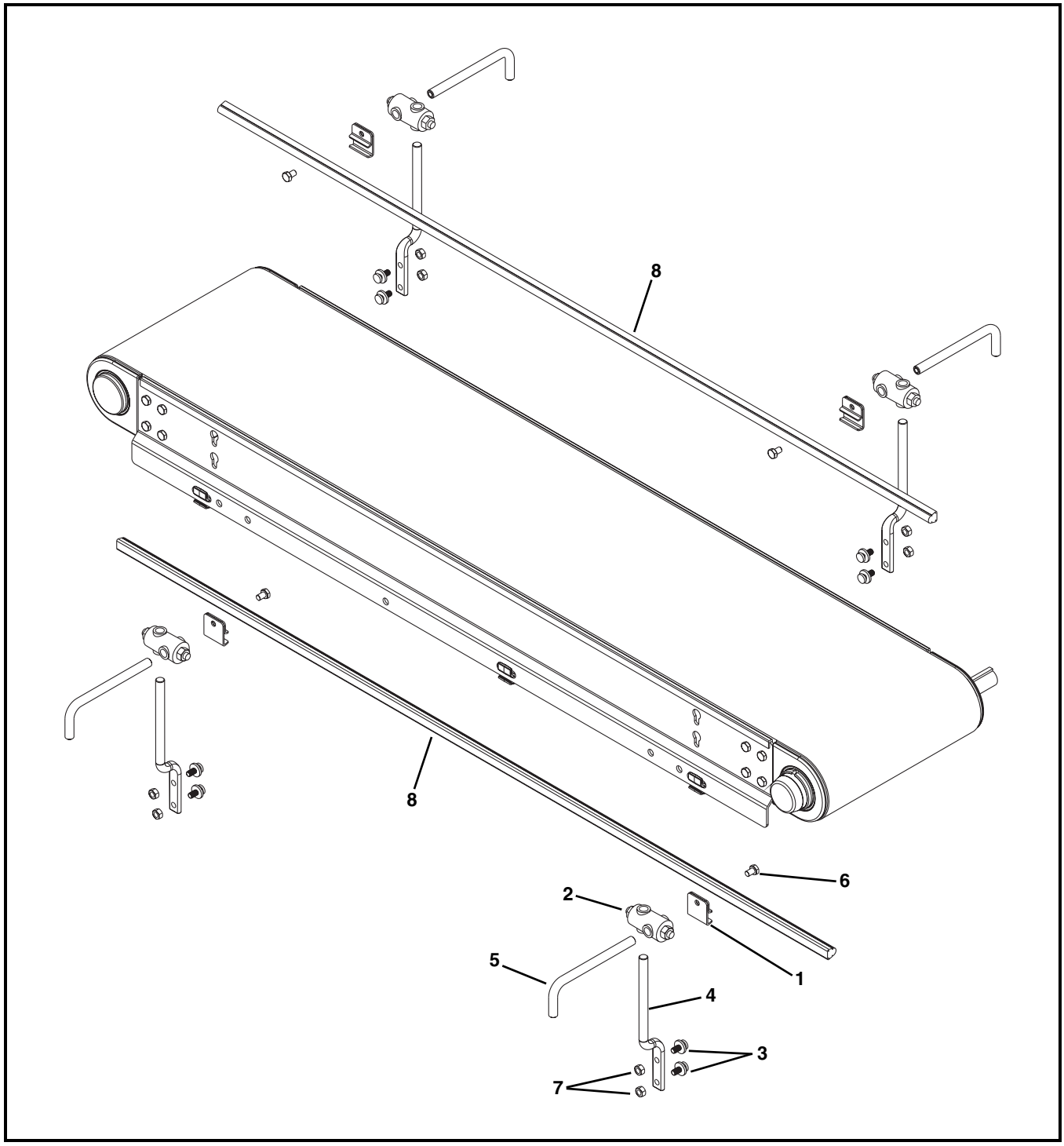
Connecting Assembly



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

Service Parts

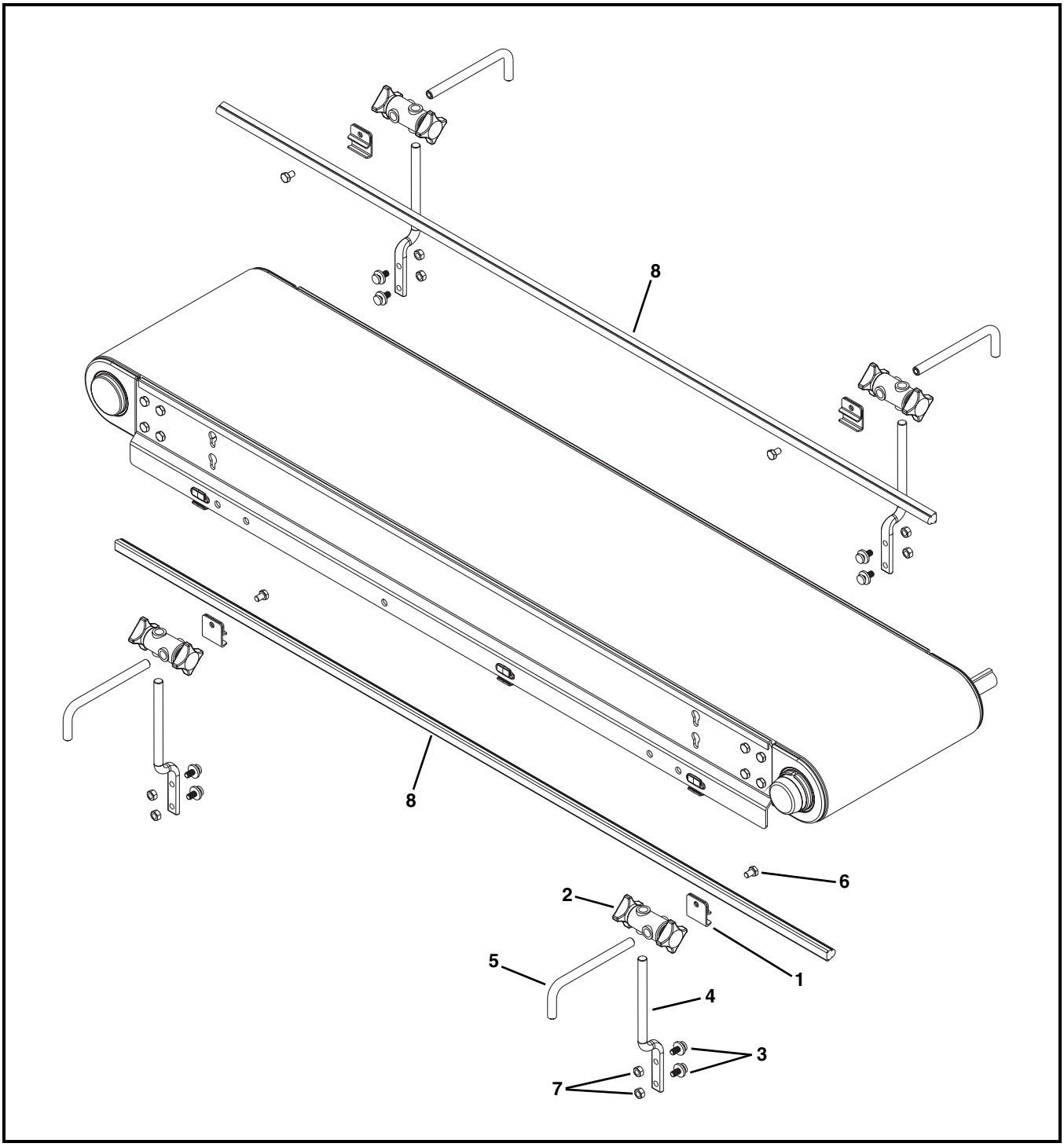
Fully Adjustable Round Guides



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

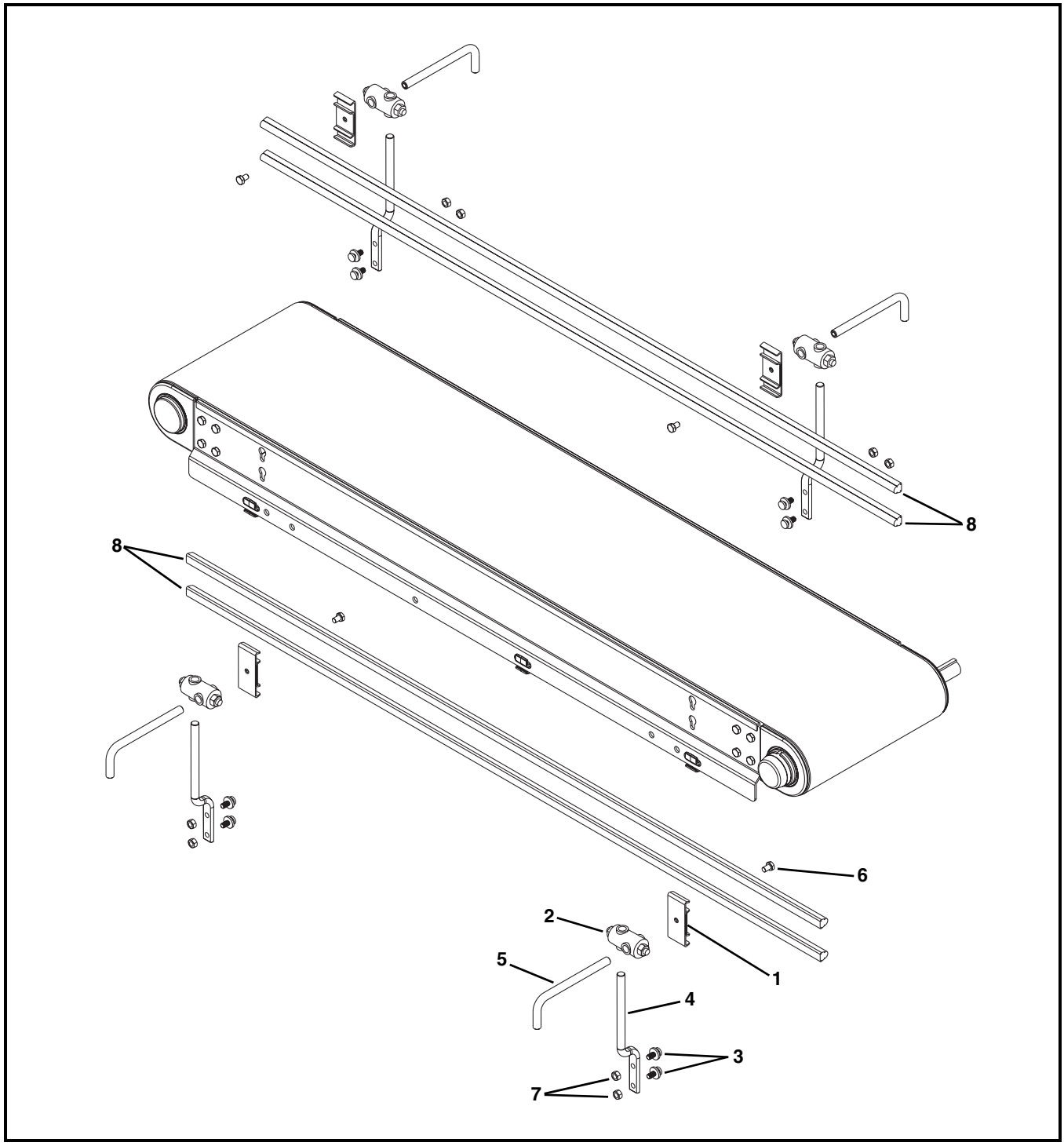


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm

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

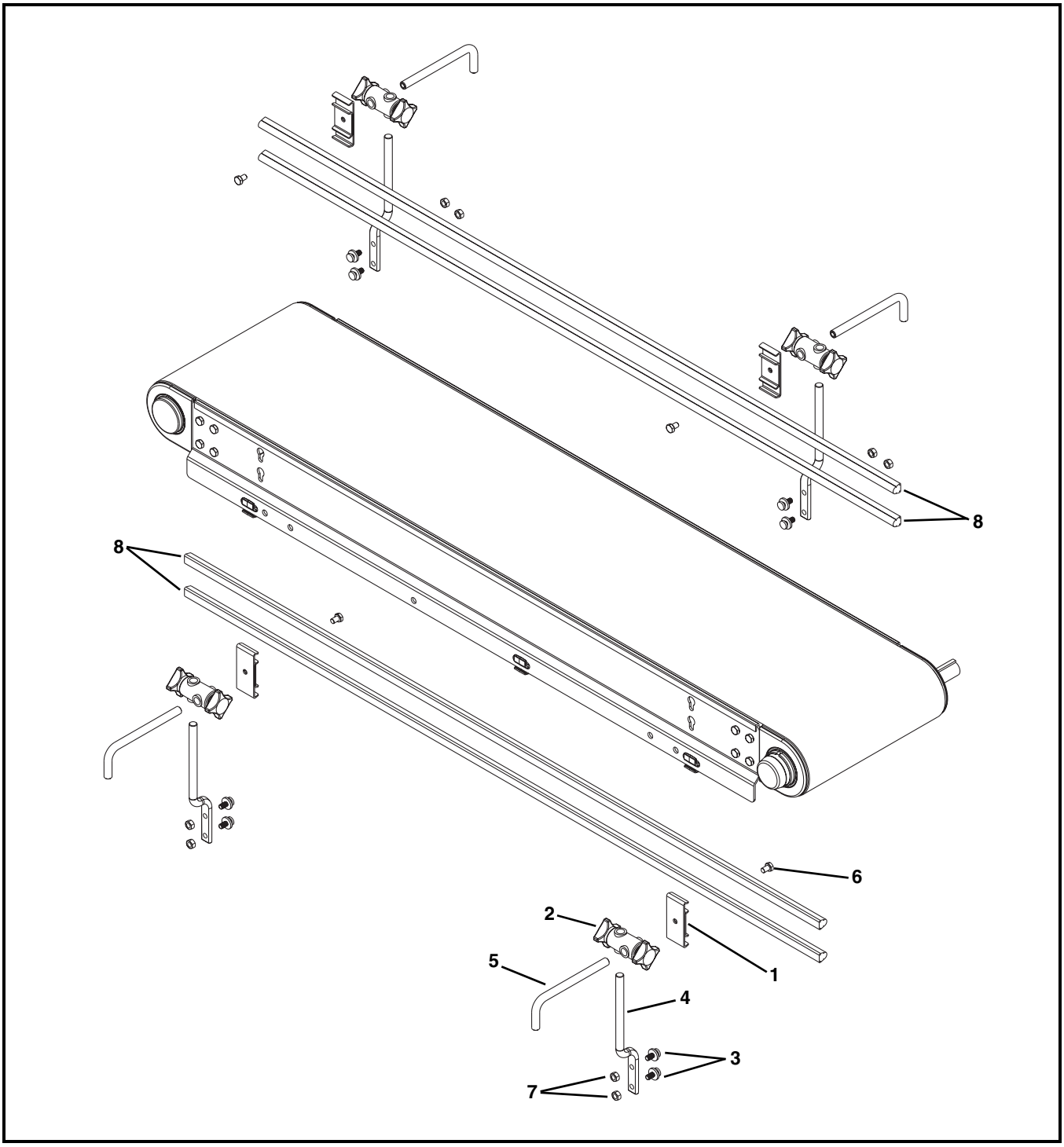
Twin Rail Adjustable Round Guides



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

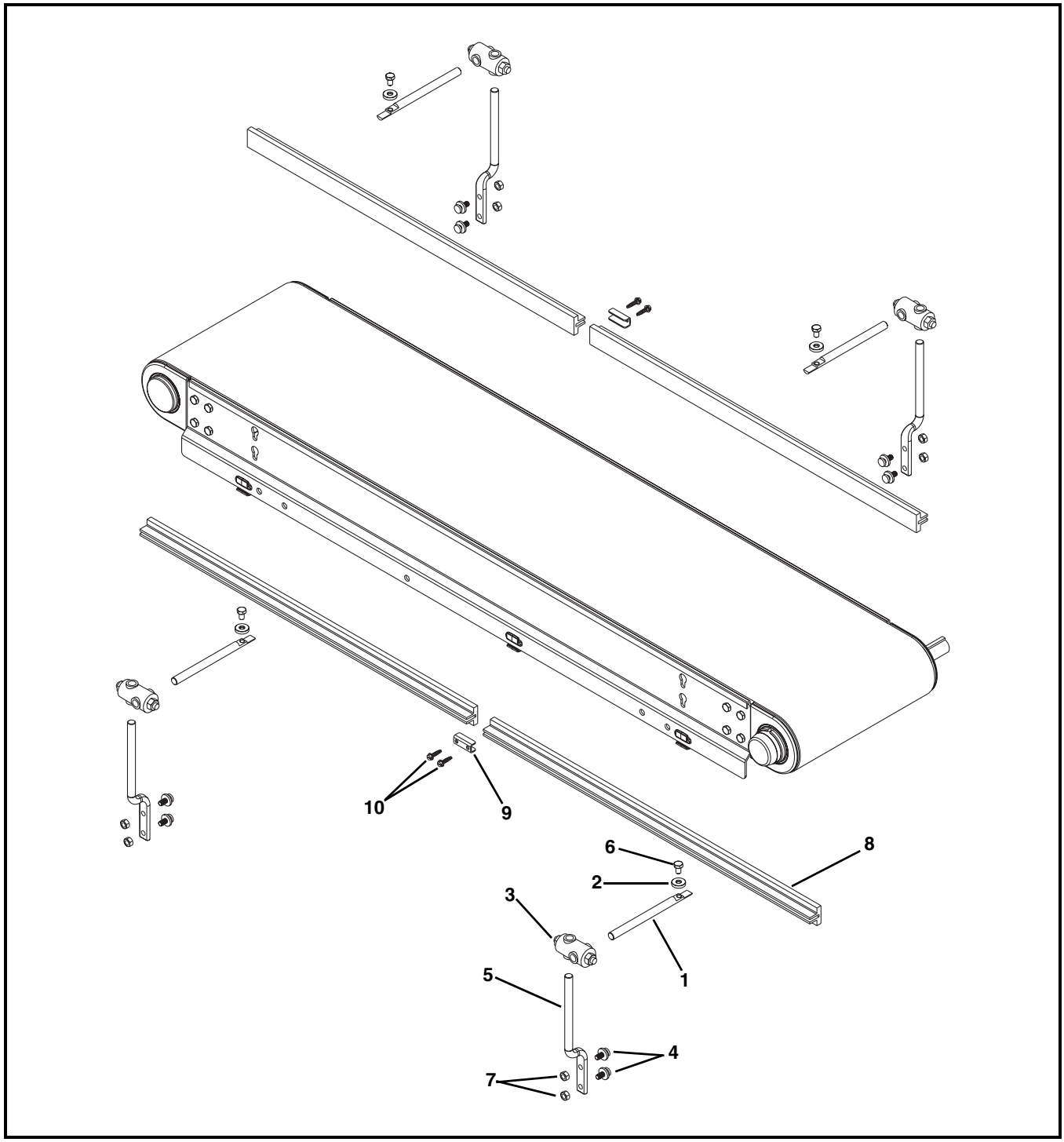


Item	Part Number	Description
1	901414	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt M8 x 20mm
4	532192	Offset Guide Post
5	532300	Post Guide
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm

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

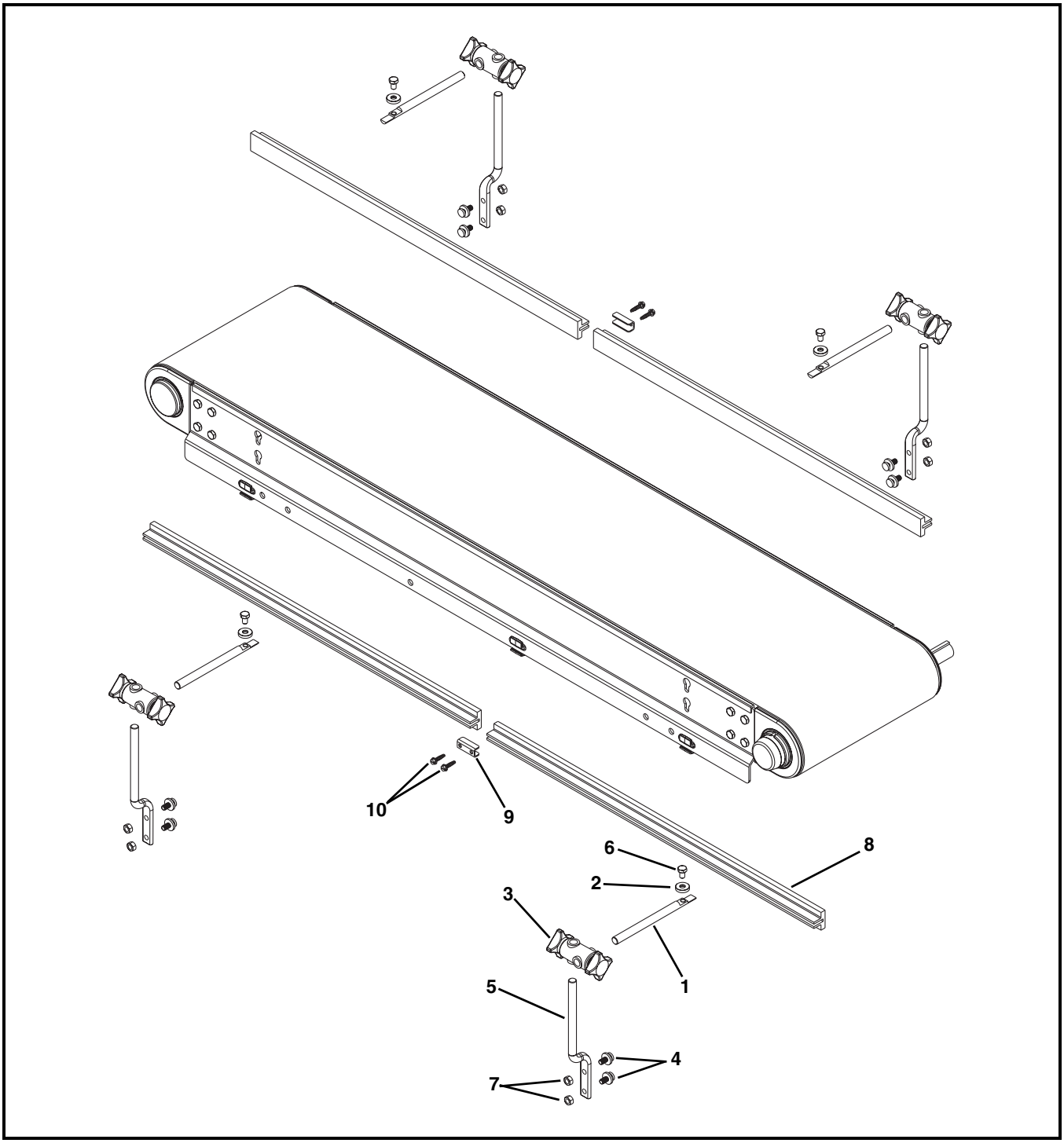
Fully Adjustable 1" (25 mm) Flat Guides



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

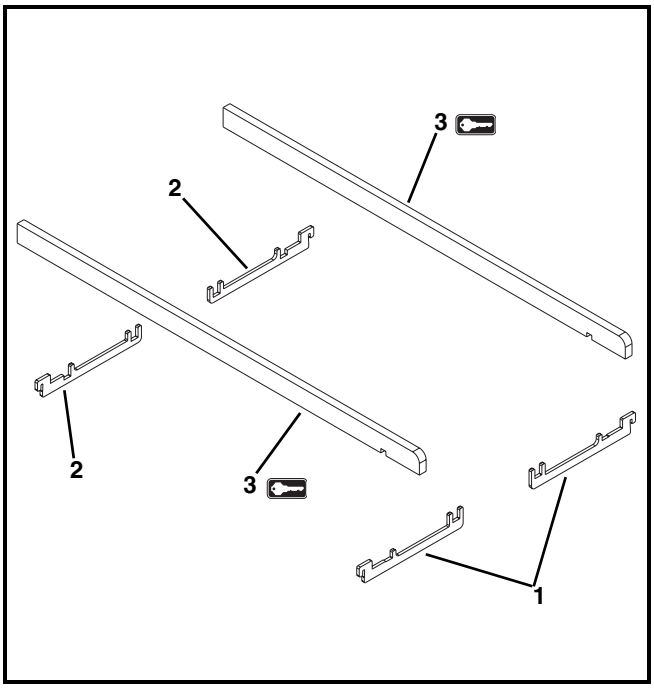


Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1470	Cross Block Clamp
4	532191	Carriage Bolt M8 x 20mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw M8-1.25 x 12mm
7	990801MSS	Hex Nut

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

Belt Returns



Item	Part Number	Description
1	532154	Front Return Support
2	532153	Return Support
3	532223-LLLLL	Wear Strips
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

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:

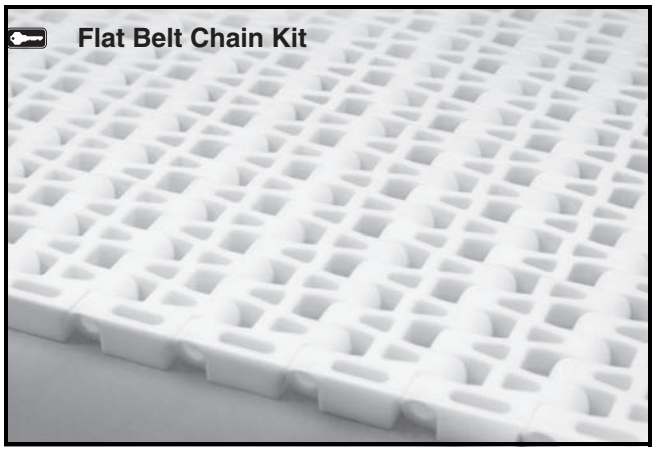
Overall chain length = 42' 5" (rounded up = 43')

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.

Conveyors and conveyor accessories	
Standard catalog conveyors	30%
MPB, 7200, 7300 Series, cleated and specialty belt	50%
AquaGard & AquaPruf Series conveyors	non-returnable items
Engineered special products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

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

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

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

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

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

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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