



# 7350 Series End Drive 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:  
[www.dorner.com/service\\_manuals.asp](http://www.dorner.com/service_manuals.asp)

# Table of Contents

Introduction .....	2	Bar Cap Replacement .....	13
Warnings – General Safety.....	3	Wear Strip Removal.....	13
Product Description .....	4	Drive Sprocket and Spindle Replacement.....	14
Specifications .....	4	Idler Puck and Spindle Replacement.....	15
Flat Belt 7350 Series Conveyor.....	4	Nose Bar Idler Spindle Replacement .....	16
Cleated Belt 7350 Series Conveyor .....	4	Bearing Replacement .....	17
Conveyor Supports .....	5	Drive Bearing Removal and Replacement.....	17
Specifications.....	5	Idler Bearing Removal and Replacement .....	17
Installation .....	6	Service Parts.....	18
Required Tools.....	6	Drive End Components .....	18
Recommended Installation Sequence .....	6	Idler End Components.....	20
Conveyors Longer than 10 ft (3048 mm) .....	6	Nose Bar Idler End Components.....	21
Connecting Components .....	6	Frame Assembly.....	22
All Conveyors .....	7	Connecting Assembly.....	23
Stand Installation.....	7	1" (25 mm) High Sides.....	24
Belt Installation.....	7	3" (76 mm) High Sides.....	25
Belt Returns .....	8	Fully Adjustable Round Guides .....	26
Returns for conveyors up to 24" wide.....	8	Tool-Less Fully Adjustable Round Guides .....	27
Returns for conveyors 26" - 36" wide.....	9	Twin Rail Adjustable Round Guides.....	28
Guide Installation.....	9	Tool-Less Twin Rail Adjustable Round Guides .....	29
Drive Package Installation .....	10	Fully Adjustable 1" (25 mm) Flat Guides .....	30
Preventive Maintenance and Adjustment.....	11	Tool-Less Fully Adjustable 1" (25 mm) Flat Guides.....	31
Required Tools.....	11	1" (25 mm) Cleated High Sides.....	32
Checklist .....	11	3" (76 mm) Cleated High Sides.....	33
Cleaning.....	11	4" (102 mm) - 24" (610 mm) Wide Returns.....	34
Lubrication.....	11	26" (660 mm) - 36" (914 mm) Wide Returns.....	34
Maintaining the Conveyor Belt.....	11	Ordering a Replacement Chain .....	35
Troubleshooting .....	11	Flat Belt Chain Repair Kit.....	35
Conveyor Belt Replacement .....	12	Cleated Belt Chain Repair Kit.....	35
Conveyor Belt Tensioning .....	12	Return Policy.....	36
Wear Strips .....	13		

## 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 .

# Warnings – General Safety

**⚠ 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 (Cleated Belt Shown)
4	Support Stands
5	Drive End
6	Idler End

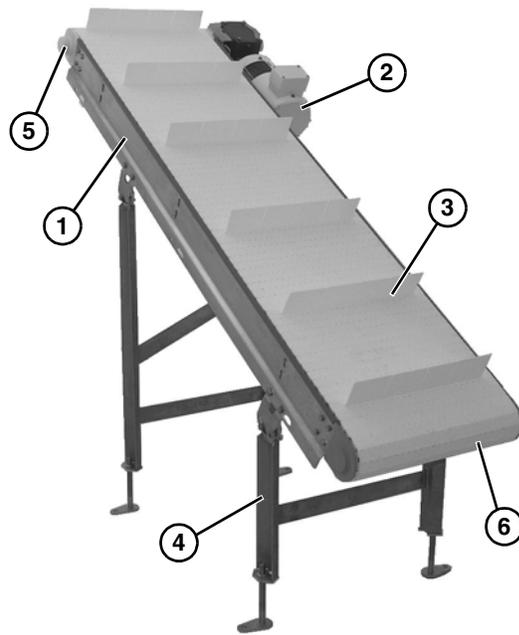
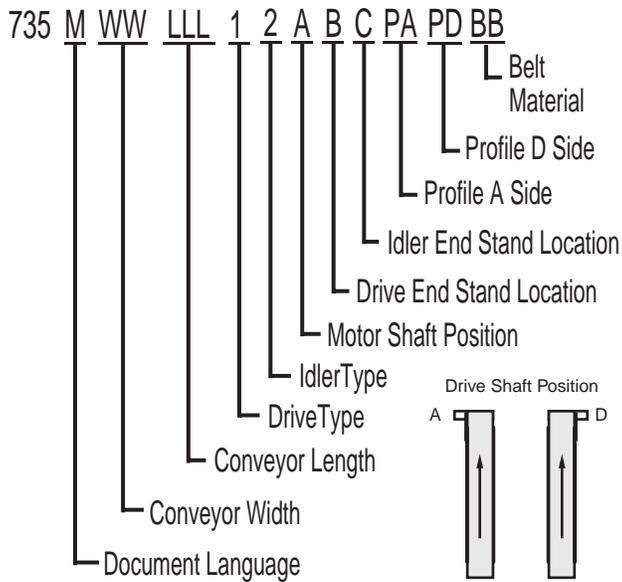


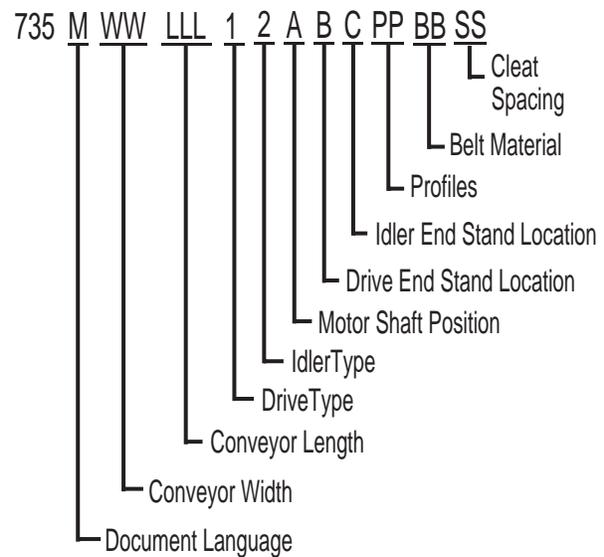
Figure 1

# Specifications

## Flat Belt 7350 Series Conveyor



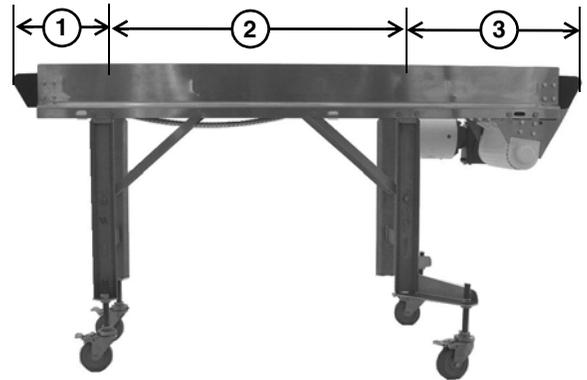
## Cleated Belt 7350 Series Conveyor



## Conveyor Supports

**Maximum Distances:**

- 1 = Support Stand on Idler End = 30" (762 mm)
  - 2 = Between Support Stands = 8 ft (2438 mm)\*\*
  - 3 = Support Stand on Drive End = 24" (610 mm)
- \*\* For conveyors longer than 10 ft (3048 mm),  
install stand mount kit at frame joint.



**Figure 2**

## Specifications

Conveyor Width Reference ( <u>WW</u> )	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 <sup>2</sup> (97 kg/ m <sup>2</sup> ) with a maximum of 750 lbs. (340 kg)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	260 ft/minute (79 m/minute)

Conveyor Length Reference ( <u>LLL</u> )	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*

# Installation

## CAUTION

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

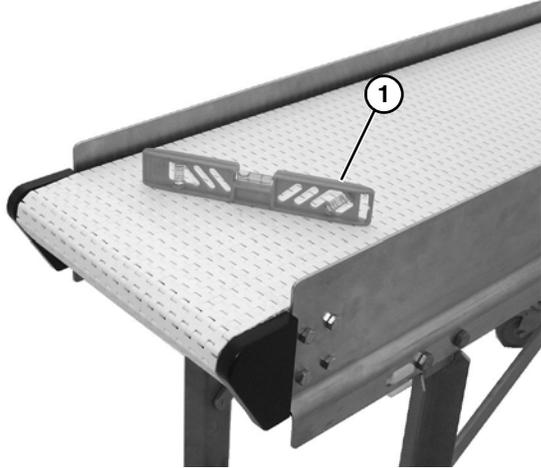


Figure 3

## 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 6.
2. Attach the stands. Refer to "Stand Installation" on page 7.
3. Install the belt. Refer to "Belt Installation" on page 7.
4. Install the gearmotor. Refer to "Drive Package Installation" on page 10.

## 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

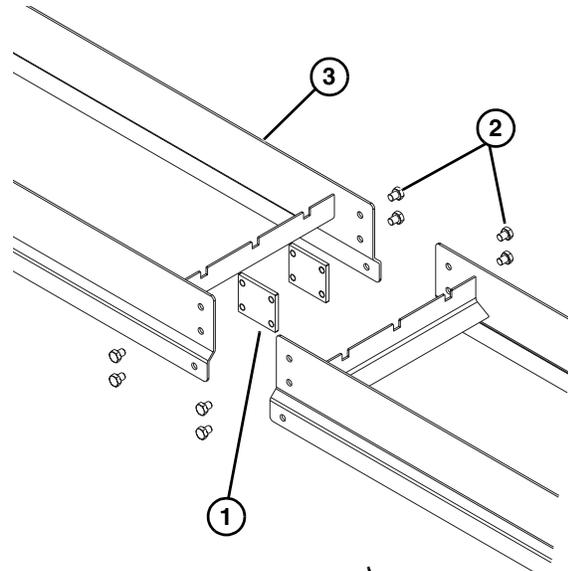


Figure 4

1. 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.

## All Conveyors

### Stand Installation

#### NOTE

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

Typical stand components (Figure 5)

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

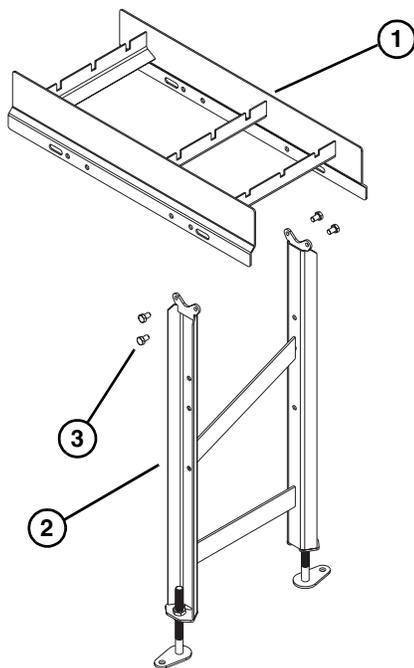


Figure 5

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame (Figure 6, item 1).

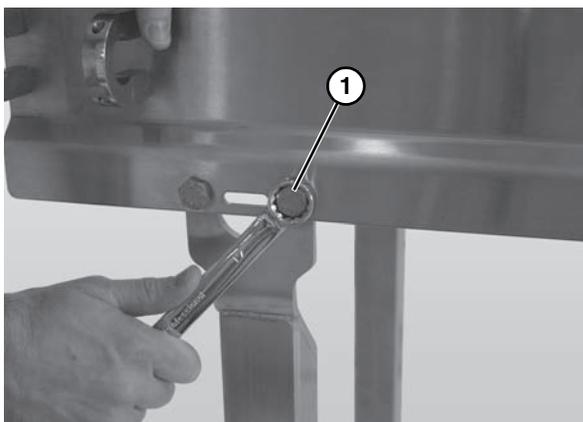


Figure 6

## Belt Installation

Typical Belt Components (Figure 7)

- |   |            |
|---|------------|
| 1 | Chain Belt |
| 2 | Belt Rod   |

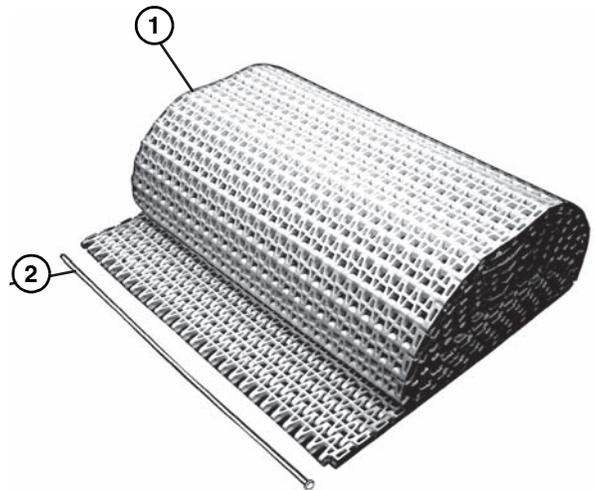


Figure 7

1. Position the belt on the conveyor frame (Figure 8).

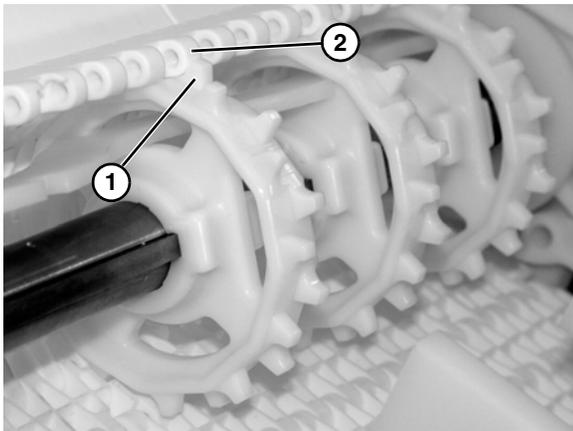


Figure 8

2. Wrap belt around idler tail.

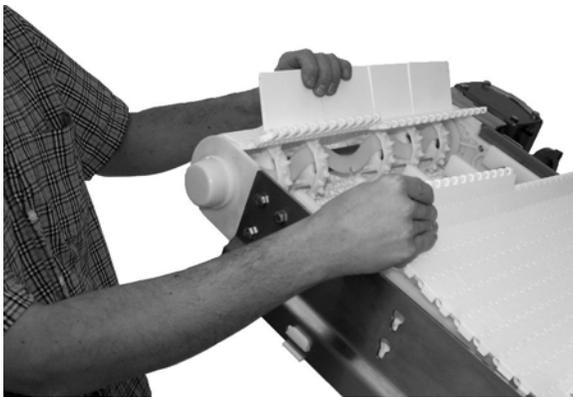
# Installation

3. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth (**Figure 9, item 1**) mating with rounded section (**Figure 9, item 2**) of belt.



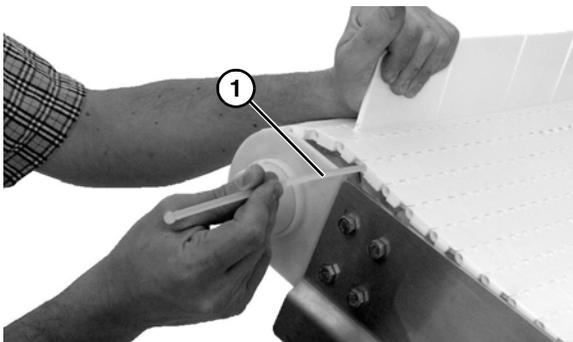
**Figure 9**

4. Bring the ends of the belt together (**Figure 10**).



**Figure 10**

5. Insert the belt rod (**Figure 11, item 1**).



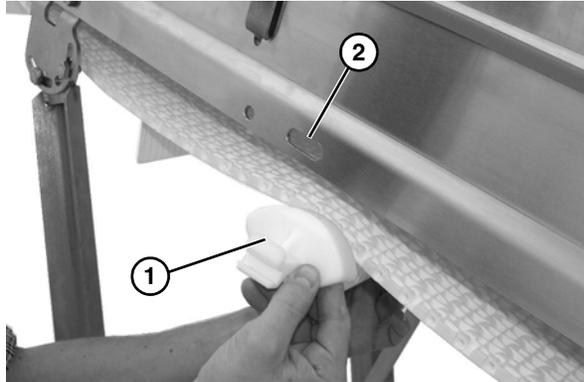
**Figure 11**

6. Push the belt rod in as far as possible.
7. Lightly tap the head of the rod with a hammer until it snaps into position.

## Belt Returns

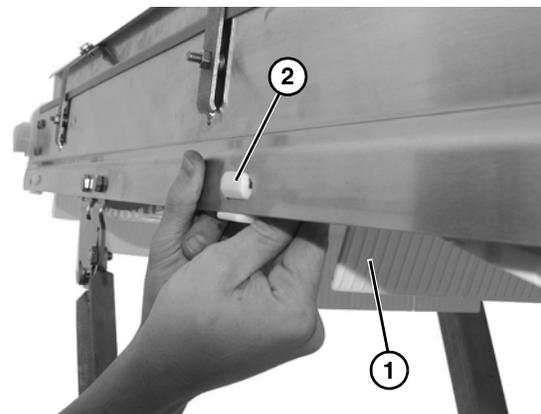
### Returns for conveyors up to 24" wide

1. Install belt return (**Figure 12, item 1**) into slotted frame hole (**Figure 12, item 2**).



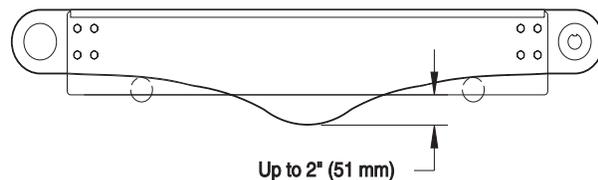
**Figure 12**

2. Install belt (**Figure 13, item 1**) around lower frame section and above lower wear strip (**Figure 13, item 2**).



**Figure 13**

1. Check belt sag by measuring from the bottom of conveyor frame (**Figure 14**). Belt sag should not exceed 2" (51 mm).



**Figure 14**

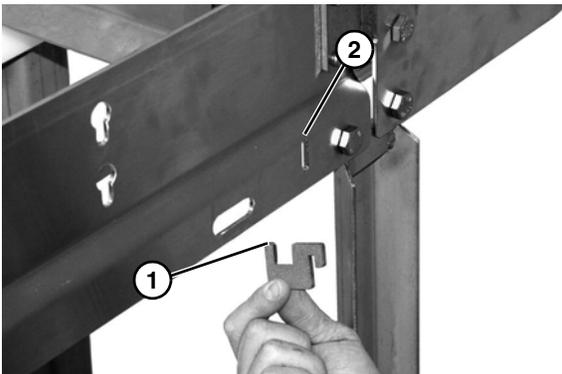
### CAUTION

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

# Installation

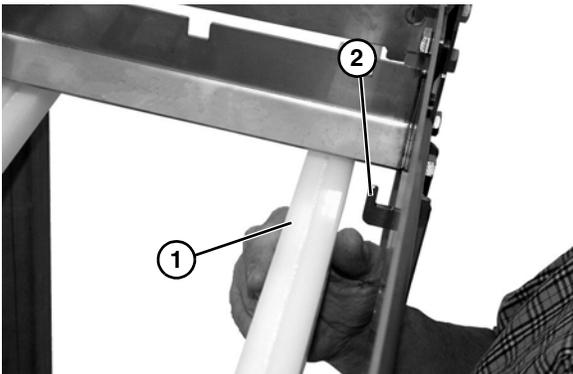
## Returns for conveyors 26" - 36" wide

1. Install belt return mounting bracket (**Figure 15, item 1**) into slotted frame hole (**Figure 15, item 2**).



**Figure 15**

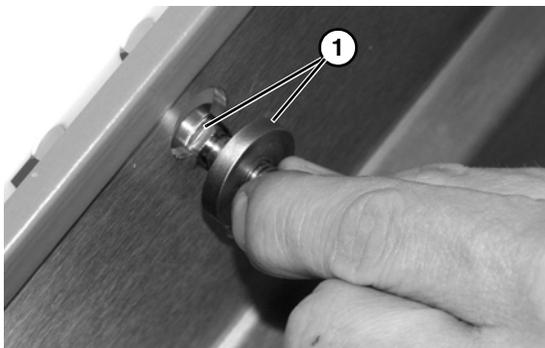
2. Install belt return (**Figure 16, item 1**) onto mounting bracket (**Figure 16, item 2**).



**Figure 16**

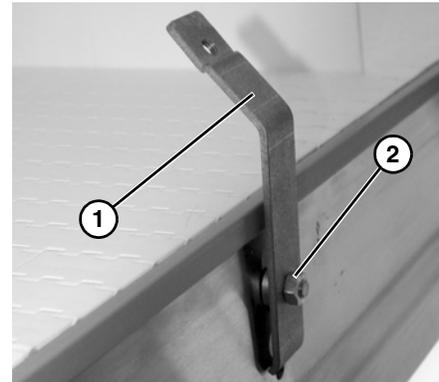
## Guide Installation

1. Insert carriage bolts with spacers (**Figure 17, item 1**) into slotted holes in conveyor side.



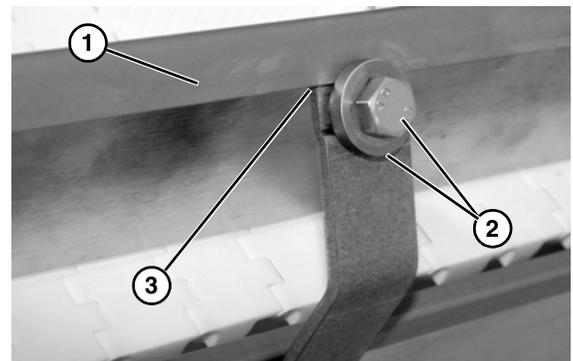
**Figure 17**

2. Attach the guide mounting brackets (**Figure 18, item 1**) to the conveyor with hex nuts (**Figure 18, item 2**). Hand tighten only at this time.



**Figure 18**

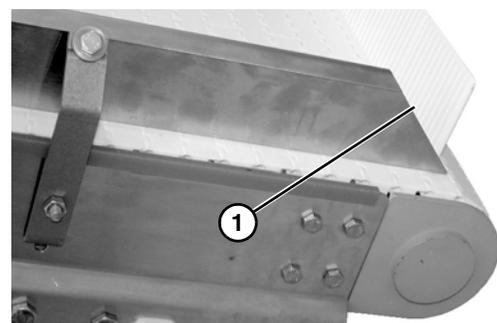
3. Attach guide (**Figure 19, item 1**) to the mounting brackets with hex bolts and spacers (**Figure 19, item 2**). Hand tighten only at this time.



**Figure 19**

4. Ensure that nose of bracket slips under the lip of guide (**Figure 19, item 3**).

NOTE
<i>When installing guides, be sure that the angled end of guide is installed on the idler end of conveyor (<b>Figure 20, item 1</b>).</i>



**Figure 20**

5. Tighten all mounting hardware.

---

# Installation

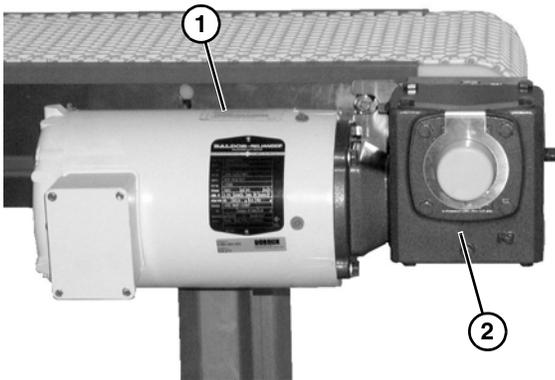
---

## 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 21, item 1**) to the gear reducer (**Figure 21, item 2**).



**Figure 21**

---

# 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 18 for recommendations.
- Replace any worn or damaged parts.

## Cleaning

NOTE
<i>Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.</i>

CAUTION
<b>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.</b>

 WARNING

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

## Lubrication

No lubrication is required. Replace bearings if worn.

## Maintaining the Conveyor Belt

### Troubleshooting

NOTE
<i>Visit <a href="http://www.dorner.com">www.dorner.com</a> for complete list of troubleshooting solutions.</i>

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

# Preventive Maintenance and Adjustment

## Conveyor Belt Replacement

<b>⚠ WARNING</b>

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

1. Remove guides (Figure 22, item 1) when required.

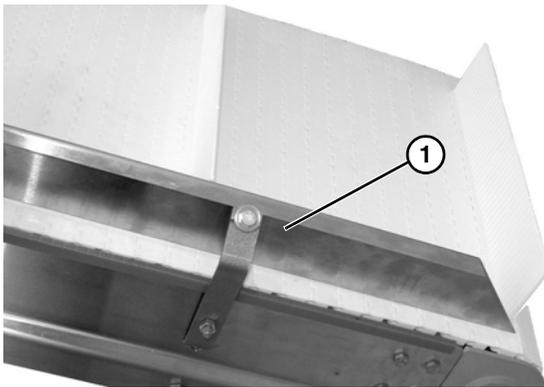


Figure 22

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head (Figure 23).



Figure 23

3. Slide the old belt off the conveyor frame.
4. Replace the old belt with a new one. Refer to "Belt Installation" on page 7.

<b>CAUTION</b>
<b>DO NOT reuse belt rods that are damaged or show signs of wear.</b>

## Conveyor Belt Tensioning

<b>⚠ WARNING</b>

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

<b>NOTE</b>
<i>Belt should not be stretched during installation. A proper length of belt can be installed by interlocking the ends by hand without excess links.</i>

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

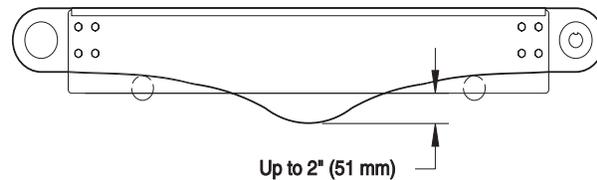


Figure 24

<b>CAUTION</b>
<b>Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame (Figure 24).</b>

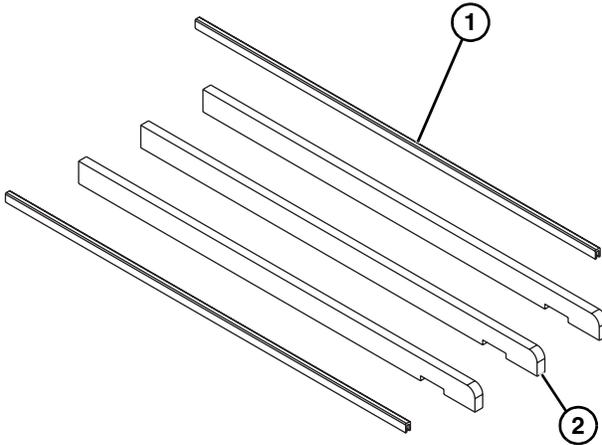
# Preventive Maintenance and Adjustment

## Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips (**Figure 25**)

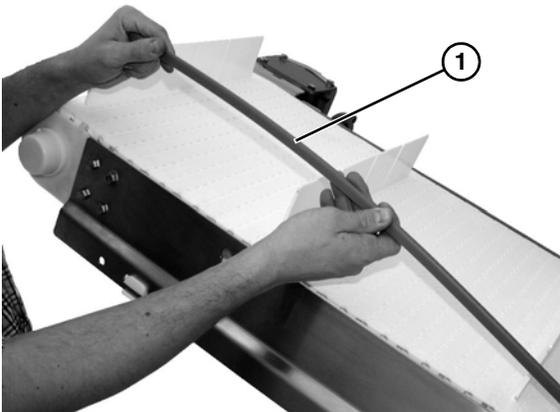
1	Bar Cap
2	Wear Strips, Bed Frame



**Figure 25**

## Bar Cap Replacement

1. Remove worn bar cap (**Figure 26, item 1**) by lifting off of conveyor side rail.

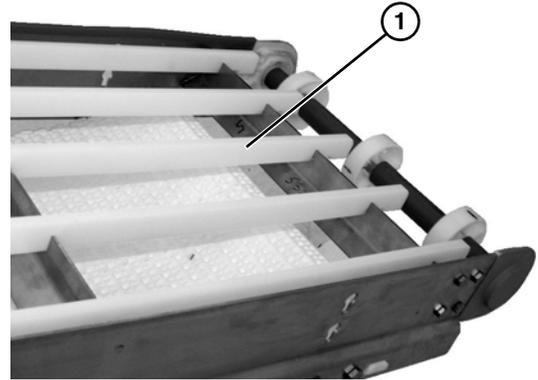


**Figure 26**

2. Replace with new bar cap.

## Wear Strip Removal

1. Remove conveyor belt. See “Conveyor Belt Replacement” on page 12.
2. Remove worn wear strips (**Figure 27, item 1**) from frame notches.



**Figure 27**

3. Replace with new wear strips.

# Preventive Maintenance and Adjustment

## Drive Sprocket and Spindle Replacement

 <b>WARNING</b>

<b>SEVERE HAZARD!</b> 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 12.
3. Remove bearing cover (Figure 28, item 1).

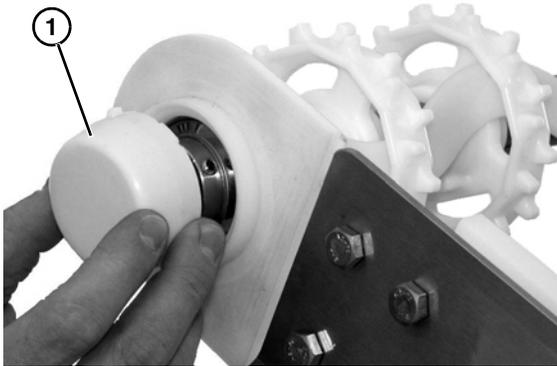


Figure 28

4. Remove the four head plate bolts (Figure 29, item 1) on both sides of the conveyor.

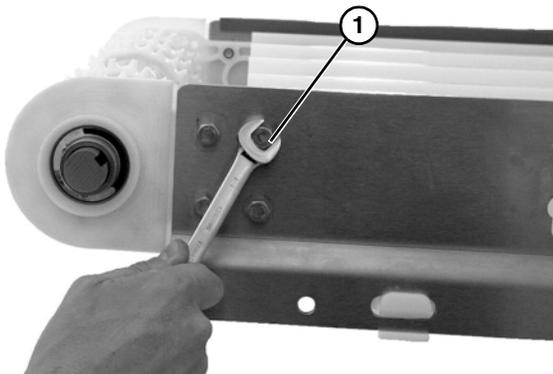


Figure 29

5. Remove tail assembly.

6. Loosen set screws (Figure 30, item 1).

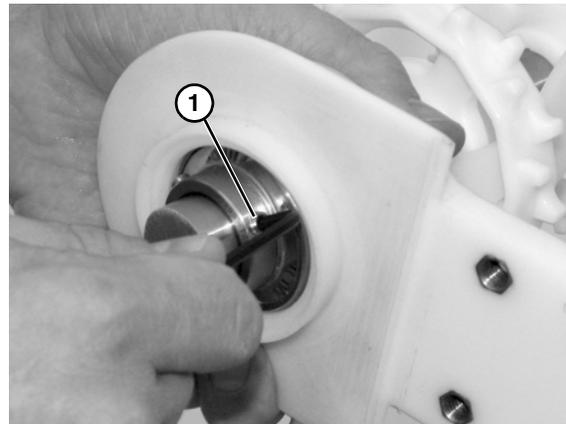


Figure 30

7. Slide the head plate with bearing (Figure 31, item 1) off the shaft.

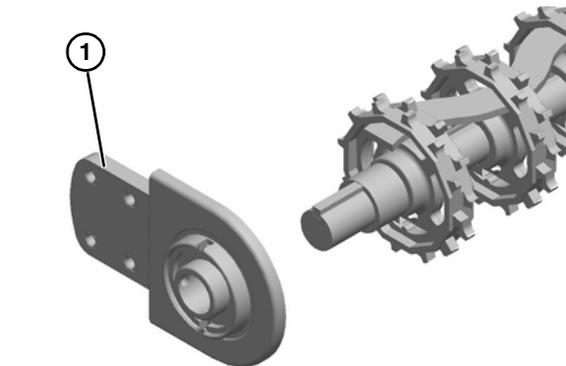


Figure 31

8. Slide off drive sprocket spacer (Figure 32, item 1).

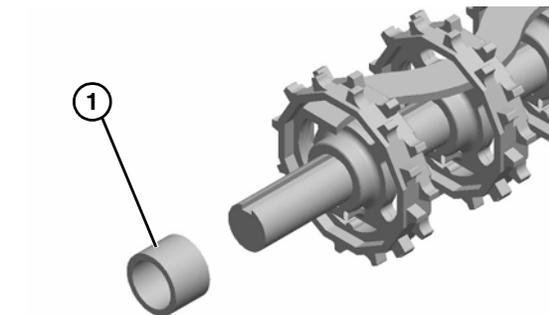
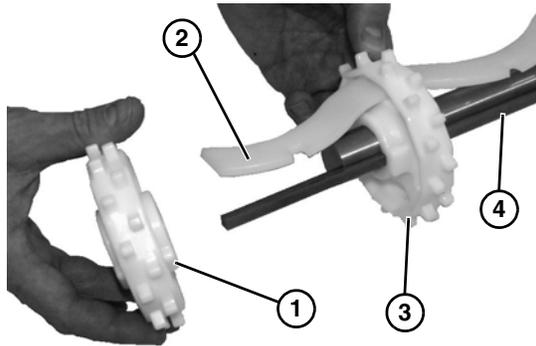


Figure 32

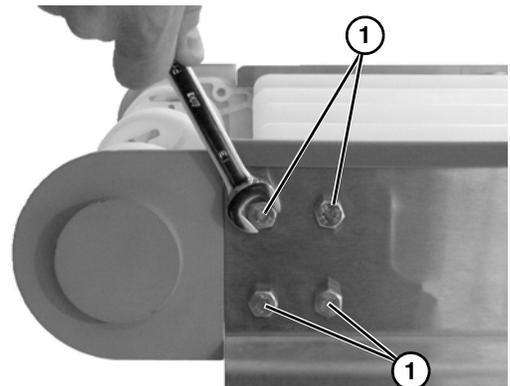
# Preventive Maintenance and Adjustment

- Slide entire sprocket assembly slightly outward, and remove the first sprocket (**Figure 33, item 1**) off the drive spindle and alignment bar (**Figure 33, item 2**).



**Figure 33**

- Remove four head plate bolts (**Figure 34, item 1**). Repeat on opposite side.



**Figure 34**

- Remove remaining sprockets (**Figure 33, item 3**) off the alignment bar as you slide entire assembly off the drive spindle (**Figure 33, item 4**).

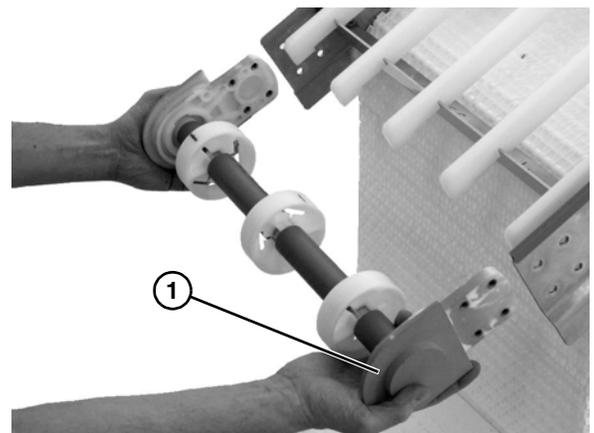
<b>NOTE</b>
To reassemble please note the placement of the sprockets on the alignment key.

## Idler Puck and Spindle Replacement

<b>⚠ WARNING</b>
<b>SEVERE HAZARD!</b> Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.
<b>NOTE</b>
<i>Idler tails are equipped with plain bushing pucks, replace when worn.</i>

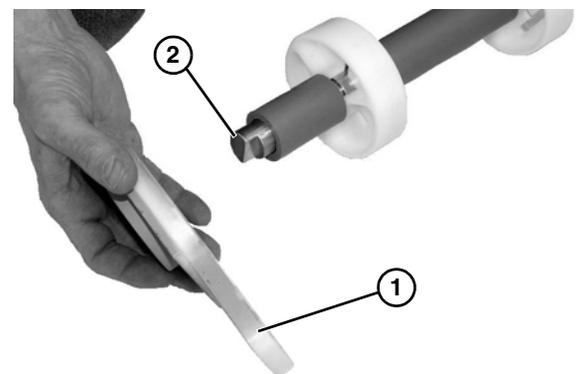
- Open conveyor belt. See “Conveyor Belt Replacement” on page 12.

- Remove idler tail assembly (**Figure 35, item 1**).



**Figure 35**

- Slide off idler head plate (**Figure 36, item 1**) from shaft (**Figure 36, item 2**).



**Figure 36**

# Preventive Maintenance and Adjustment

- Slide off the round puck spacer (Figure 37, item 1).

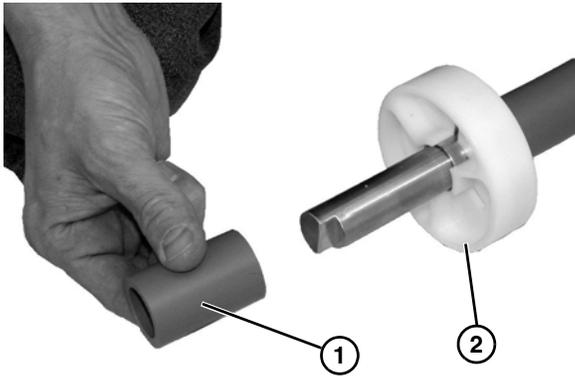


Figure 37

- Slide off puck and replace (Figure 37, item 2).
- Repeat as needed.

- Remove and replace wear strips if worn (Figure 39, item 1).

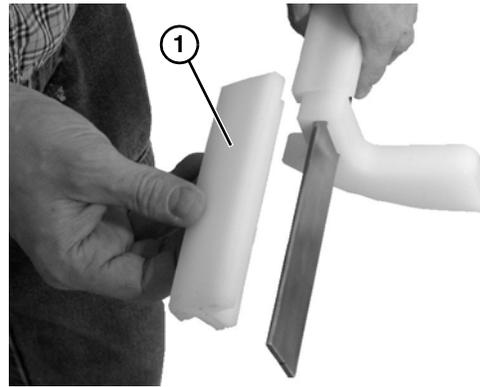


Figure 39

- Remove and replace nose bar idler shoe if worn (Figure 40, item 1).

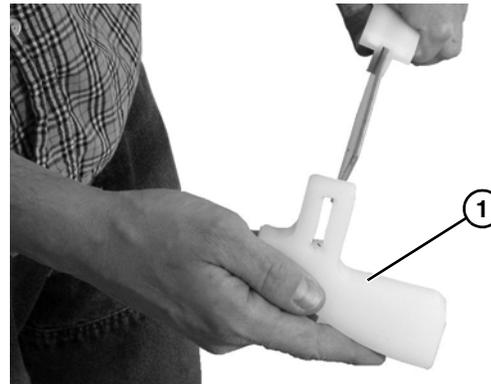


Figure 40

## Nose Bar Idler Spindle Replacement

 <b>WARNING</b>

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

- Open conveyor belt. See “Conveyor Belt Replacement” on page 12.
- Remove the nose bar idler bar with wear strips and idler shoe attached (Figure 38, item 1).

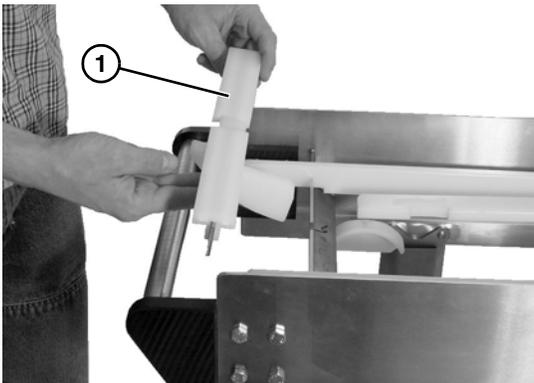


Figure 38

- Remove four head plate bolts (Figure 41, item 1).



Figure 41

# Preventive Maintenance and Adjustment

- Slide off idler roller bearing assembly (Figure 42, item 1).

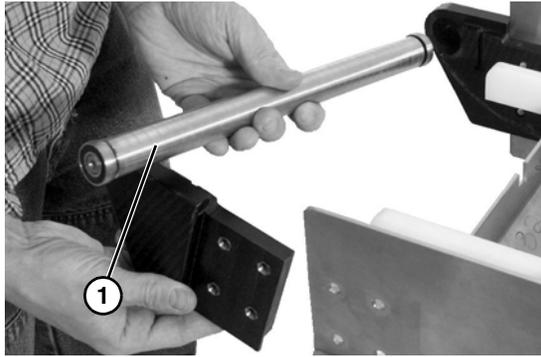


Figure 42

- Twist the bearing out (Figure 43, item 1).

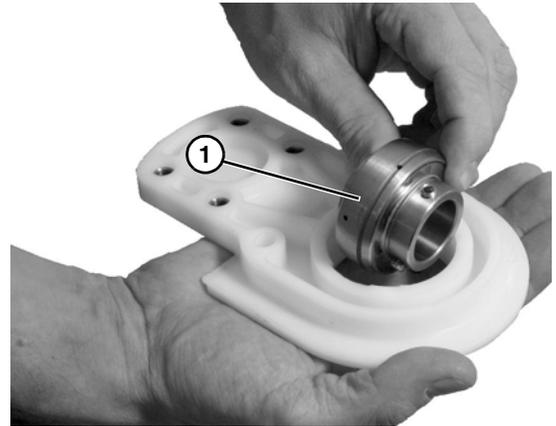


Figure 43

## Bearing Replacement

 <b>WARNING</b>

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

## Drive Bearing Removal and Replacement

 <b>WARNING</b>

<b>Drive shaft keyway may be sharp. HANDLE WITH CARE.</b>

- See "Drive Sprocket and Spindle Replacement" on page 14. Follow steps 1 through 7.

- Replace bearing.

## Idler Bearing Removal and Replacement

- See "Nose Bar Idler Spindle Replacement" on page 16. Follow steps 1 through 6.
- Using a bearing removal tool (Figure 44, item 1) remove the bearing (Figure 44, item 2).

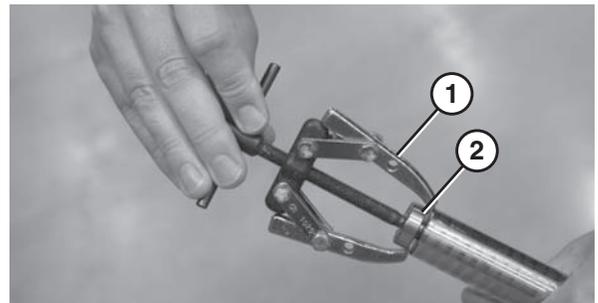


Figure 44

- Press on new bearing.

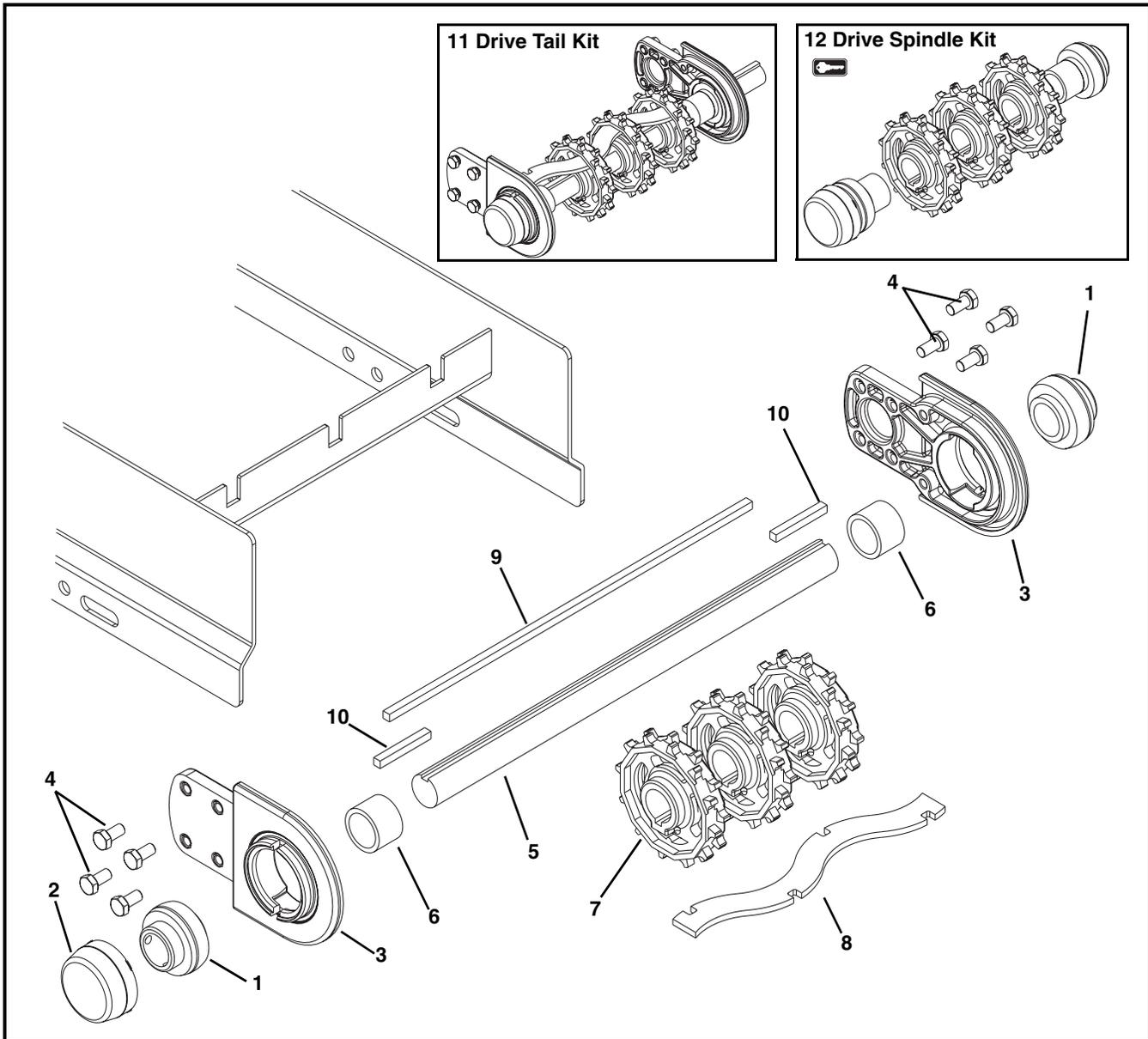
<b>CAUTION</b>
<b>Press on inner race only, pressing on outer race could damage bearing.</b>

# 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



# Service Parts

Item	Part Number	Description
1	735BK	Bearing Kit (Qty. 2)
2*	807-1454	Bearing Cap
3	532011	Headplate
4	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
5	See Drive Spindle Chart	Spindle
6	532251-LLLL	Sprocket Spacer
7	807-1754	Sprocket
8	532124-WW	Sprocket Alignment Bar
9	532121-LLLL	Square Key
10	912-110SS	Square Key

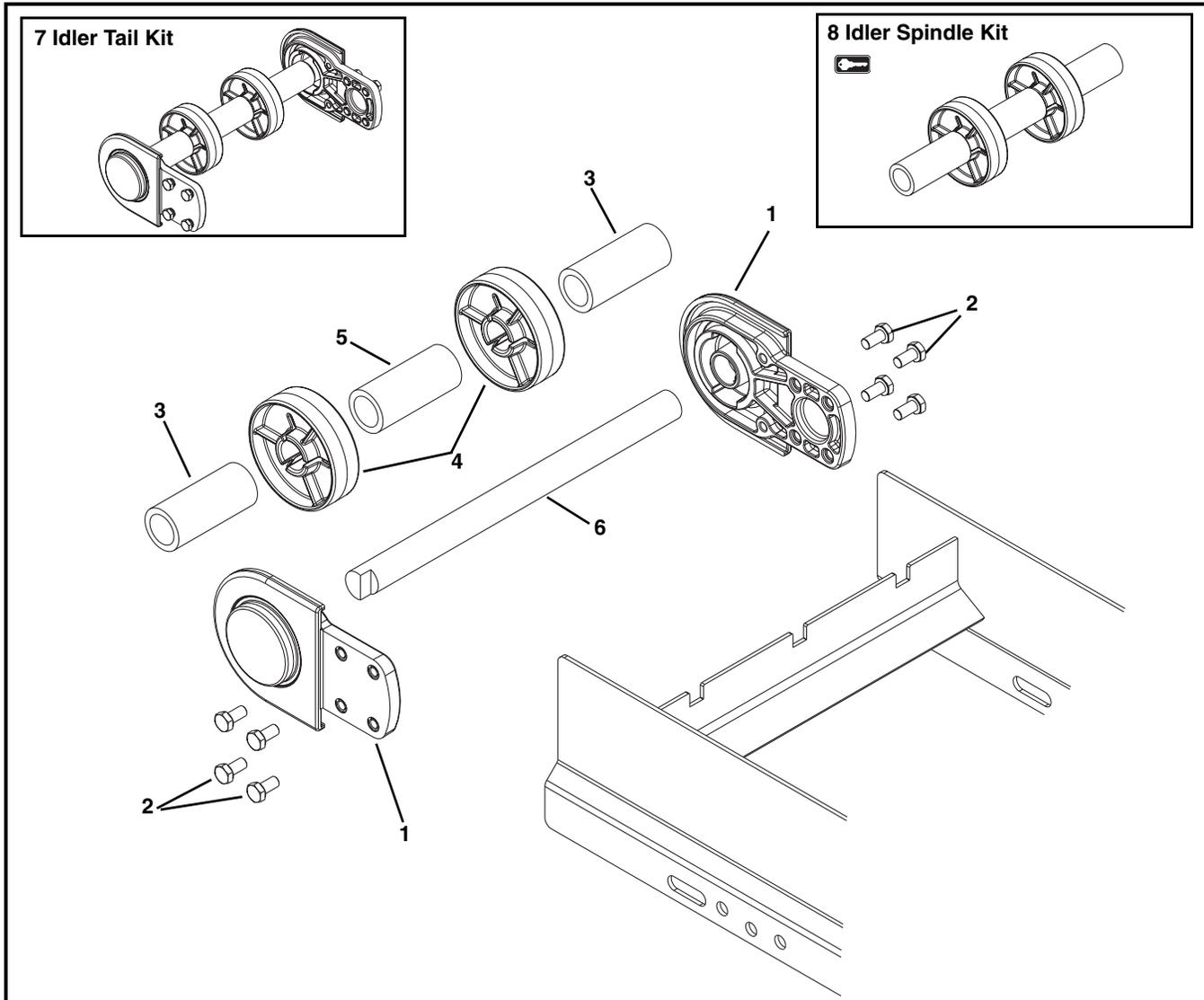
Item	Part Number	Description
11	735BDT-WW	Drive Tail Kit for Bottom Mount (Includes items 1 through 10)
	735SDT-WW	Drive Tail Kit for Side Mount (Includes items 1 through 10)
	735DBDT-WW	Drive Tail Kit for Bottom Mount, with Double Output Shafts (Includes items 1 through 10)
	735DSDT-WW	Drive Tail Kit for Side Mount, with Double Output Shafts (Includes items 1 through 10)
12	735DS-WW	Drive Spindle Kit (Includes items 1, 2, 6, and 7)

 WW = Conveyor width reference: 04 – 36 in 02 increments  
 LLLL = Part length in inches with 2 decimal places.  
 Example: Part Length = 95.25" LLLL = 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"	532113-00778	532232-01199	532113-00957	532232-01379
6"	532113-00978	532232-01399	532113-01157	532232-01579
8"	532113-01178	532232-01599	532113-01357	532232-01779
10"	532113-01376	532232-01797	532113-01555	532232-01977
12"	532113-01573	532232-01994	532113-01752	532232-02174
14"	532113-01771	532232-02192	532113-01950	532232-02372
16"	532113-01968	532232-02389	532113-02147	532232-02569
18"	532113-02166	532232-02587	532113-02345	532232-02767
20"	532113-02363	532232-02784	532113-02542	532232-02964
22"	532113-02561	532232-02982	532113-02740	532232-03162
24"	532113-02758	532232-03179	532113-02937	532232-03359
26"	532113-02956	532232-03377	532113-03135	532232-03557
28"	532113-03153	532232-03574	532113-03332	532232-03754
30"	532113-03351	532232-03772	532113-03530	532232-03952
32"	532113-03548	532232-03969	532113-03727	532232-04149
34"	532113-03746	532232-04167	532113-03925	532232-04347
36"	532113-03943	532232-04364	532113-04122	532232-04544

# Service Parts

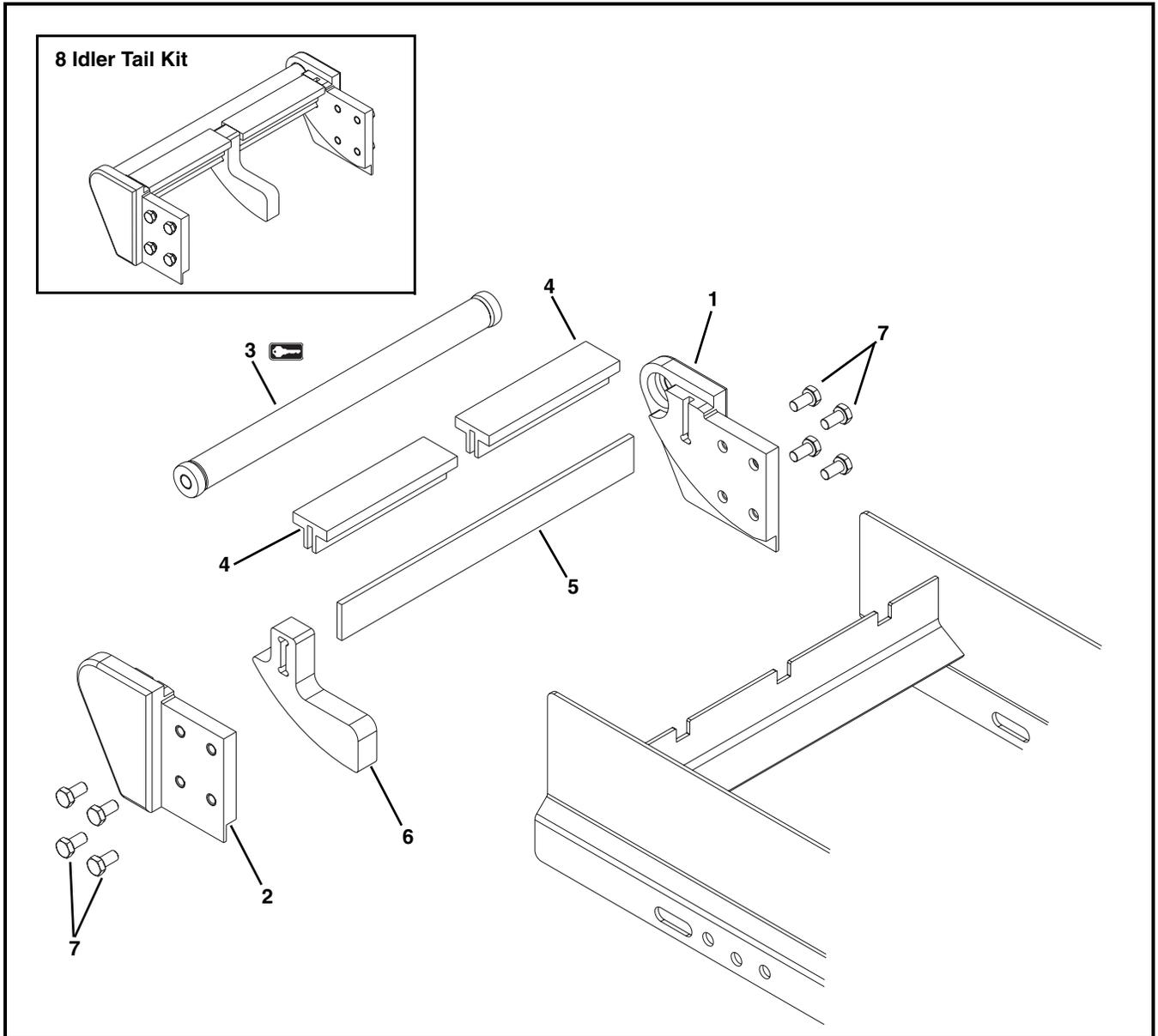
## Idler End Components



Item	Part Number	Description
1	532012	Headplate Assembly
2	960816M	Hex Head Cap Screw, M8-1.25 x 16 mm
3	532128- <u>WW</u>	End Tube Spacer
4	506296	Idler Puck
5	532127- <u>LLLLL</u>	Tube Spacer
6	See Idler Spindle Chart	Spindle
7	735IT- <u>WW</u>	Idler Tail Kit (Includes items 1 through 6)
8	735IS- <u>WW</u>	Idler Spindle Kit (Includes items 3, 4, and 5)
<u>WW</u> = Conveyor width reference: 04 – 36 in 02 increments		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		

Idler Spindle Chart	
Conveyor Width	Spindle
4"	532118-00422
6"	532118-00622
8"	532118-00822
10"	532118-01020
12"	532118-01217
14"	532118-01415
16"	532118-01612
18"	532118-01810
20"	532118-02007
22"	532118-02205
24"	532118-02402
26"	532118-02600
28"	532118-02797
30"	532118-02995
32"	532118-03192
34"	532118-03390
36"	532118-03587

## Nose Bar Idler End Components

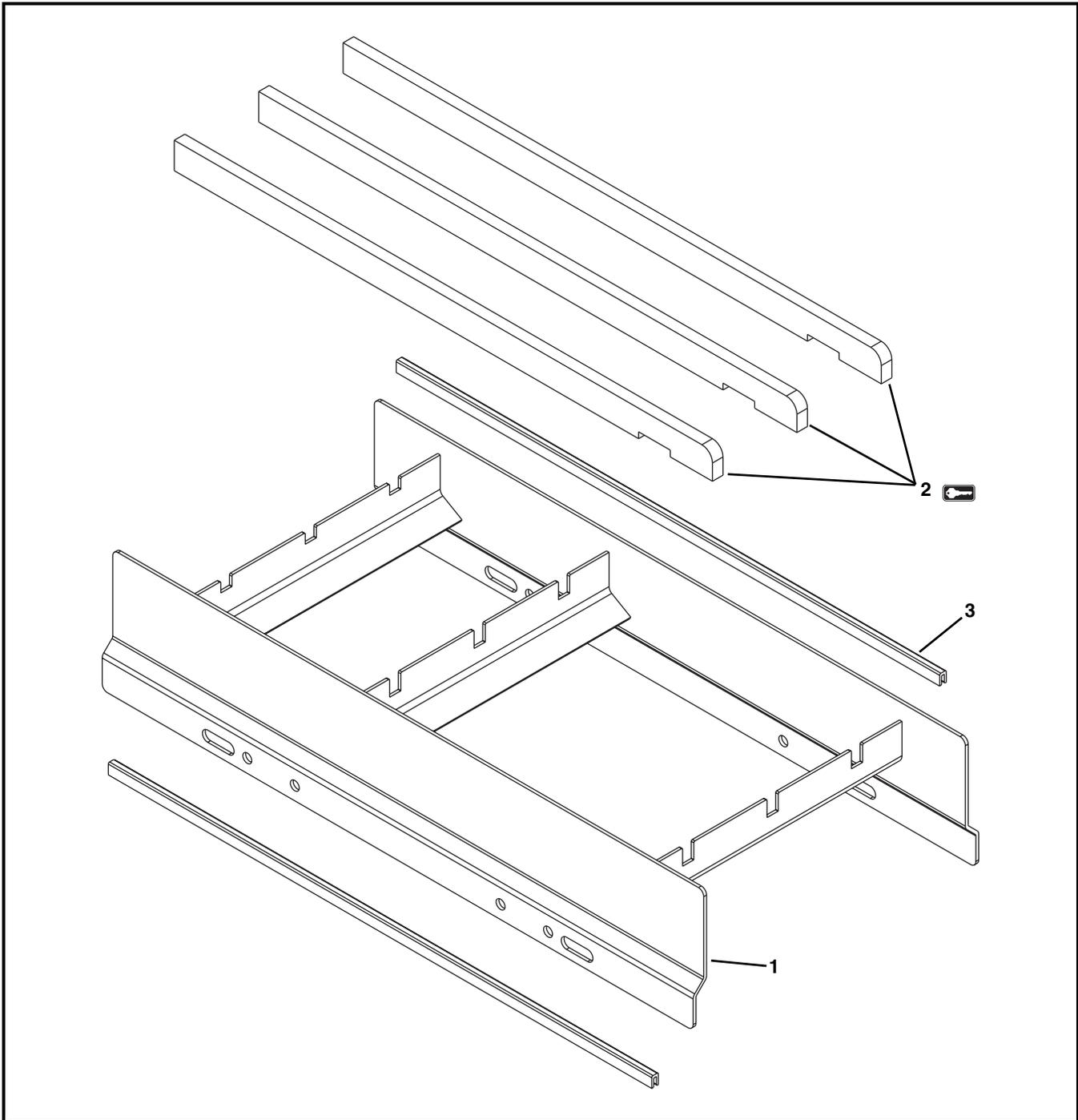


Item	Part Number	Description
1	532025	Nosebar Headplate Right Hand
2	532026	Nosebar Headplate Left Hand
3	735NBK- <u>WW</u>	Bearing Kit
4	532137- <u>WW</u>	Wear Strip
5	532135- <u>WW</u>	Nosebar Idler Bar

Item	Part Number	Description
6	532139	Nosebar Idler Shoe
7	960816M	Hex Head Cap Screw, M8-1.25 x 16 mm
8	735NBT- <u>WW</u>	Nose Bar Idler Tail Kit (Includes items 1 through 7)
<u>WW</u> = Conveyor width reference: 04 – 36 in 02 increments		

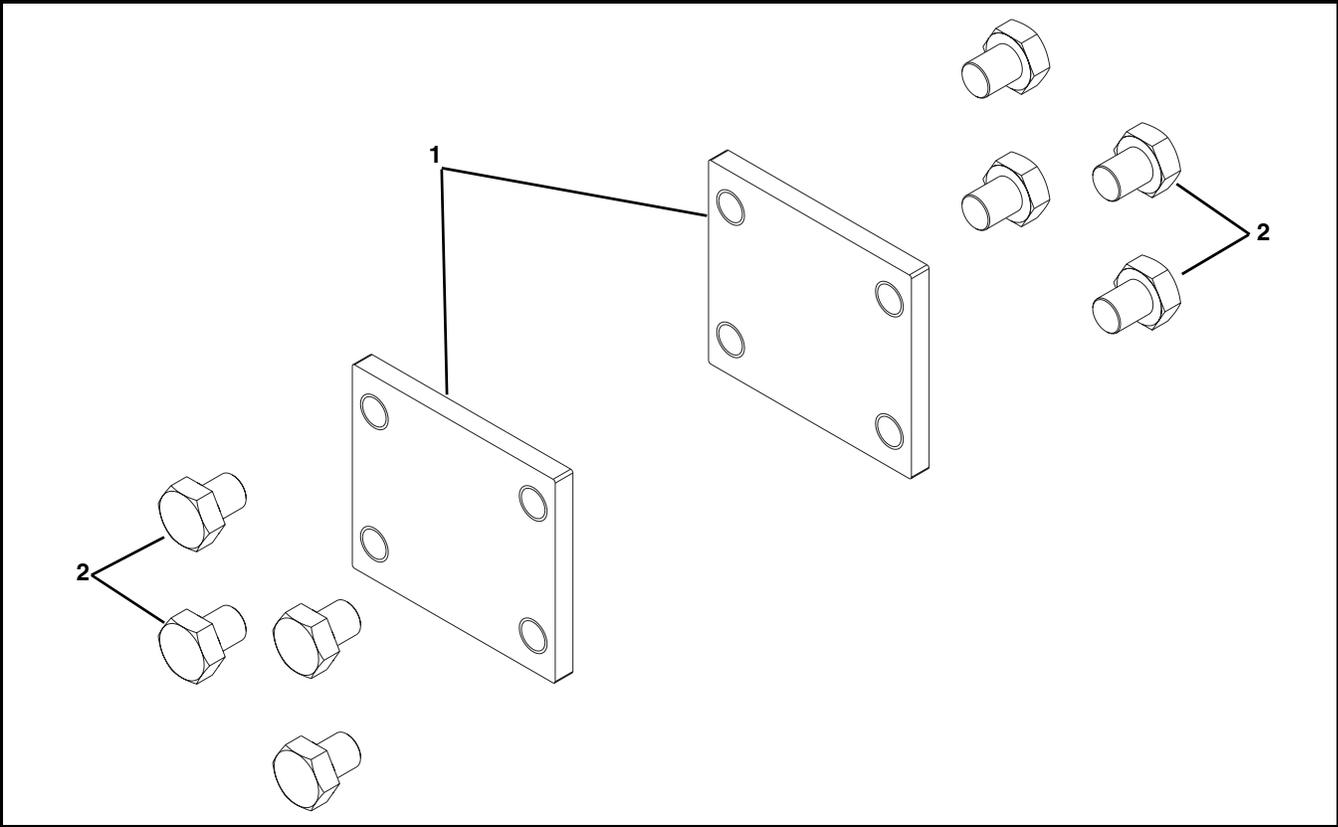
# Service Parts

## Frame Assembly



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

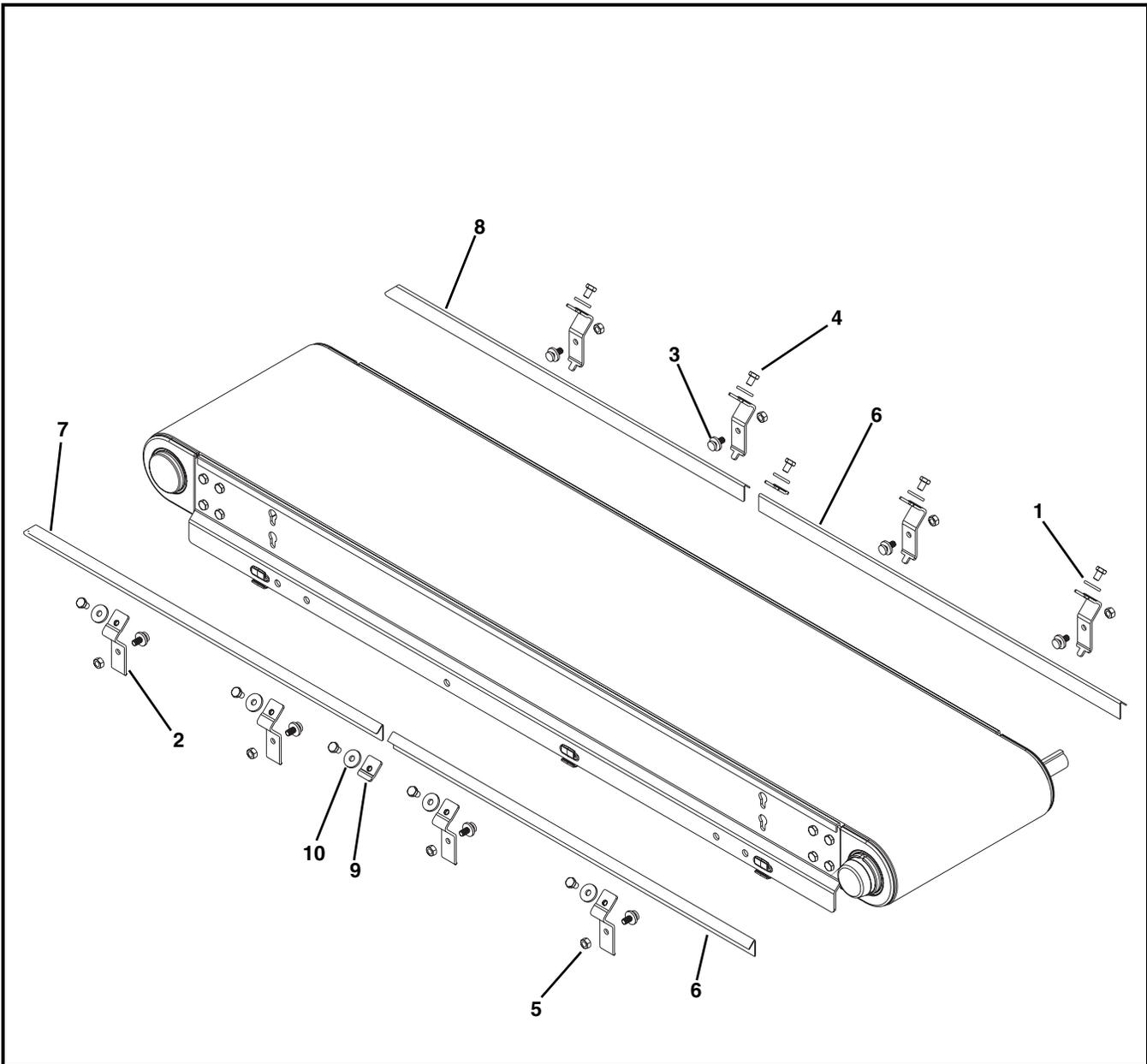
**Connecting Assembly**



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

# Service Parts

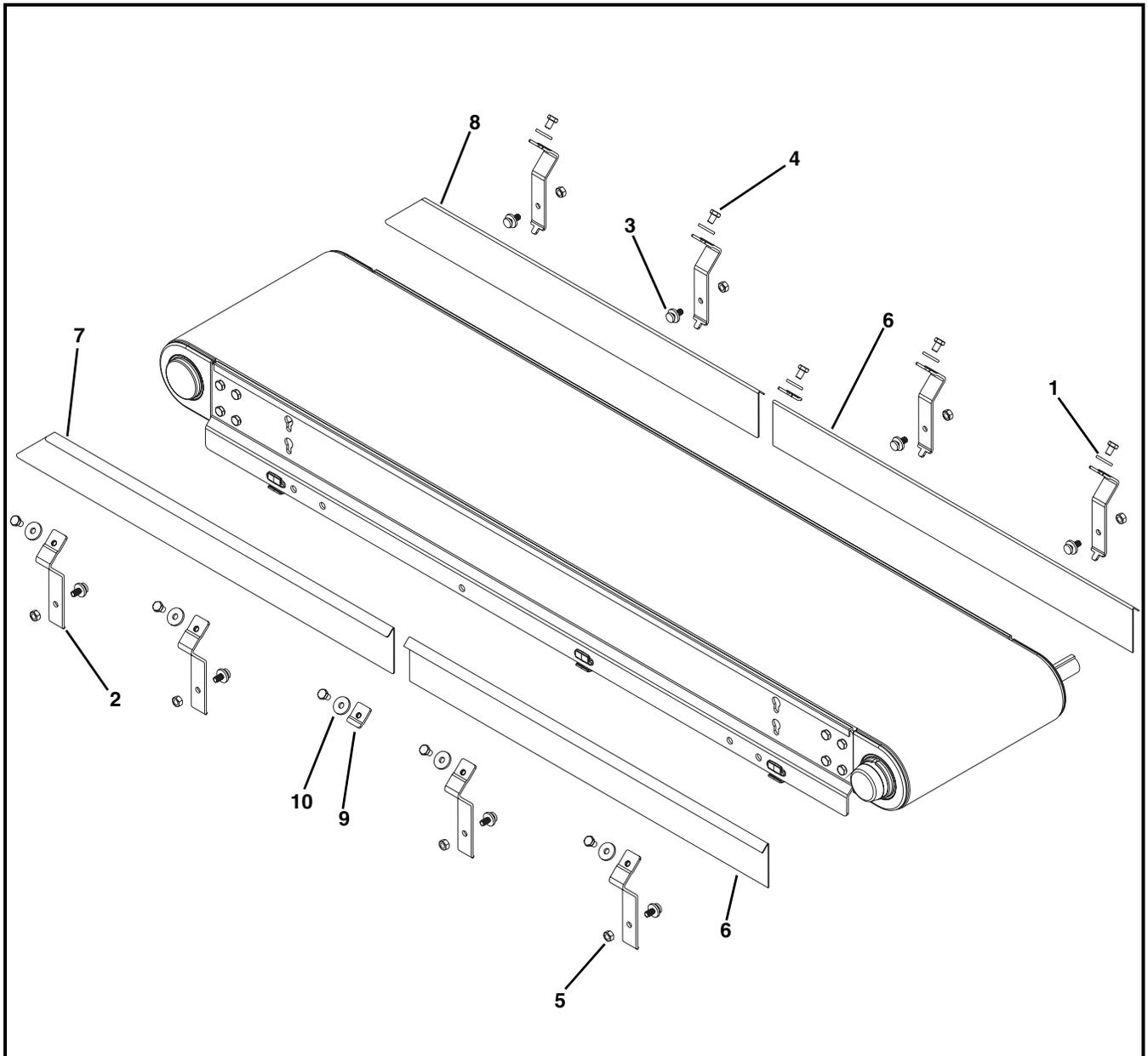
## 1" (25 mm) High Sides



Item	Part Number	Description
1	807-1821	Washer
2	532183	1" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532175-LLLLL	Guiding Straight

Item	Part Number	Description
7	532176-LLLLL	Guiding Left Hand
8	532177-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

## 3" (76 mm) High Sides

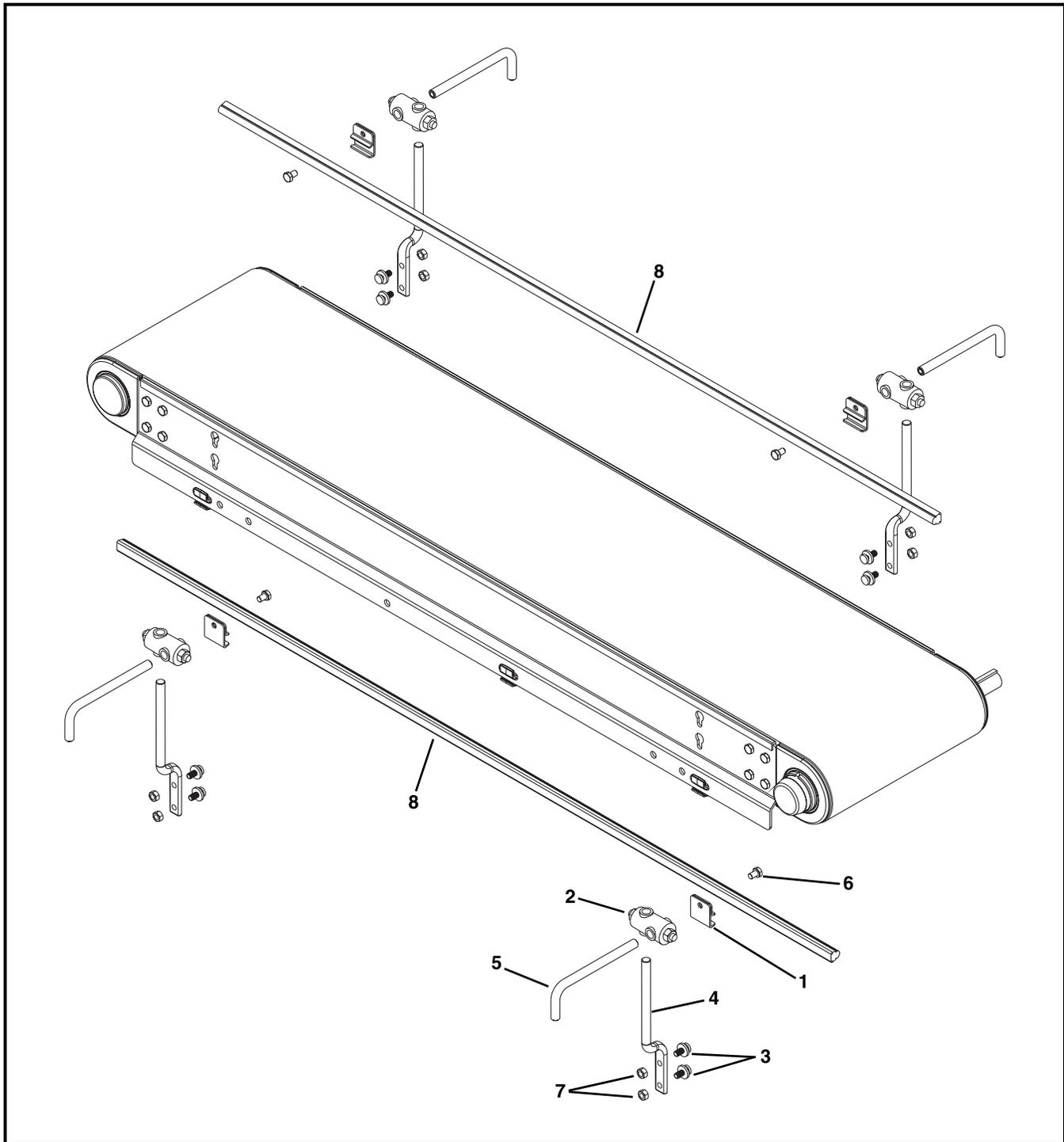


Item	Part Number	Description
1	807-1821	Washer
2	532185	3" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532172-LLLLL	Guiding Straight

Item	Part Number	Description
7	532173-LLLLL	Guiding Left Hand
8	532174-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

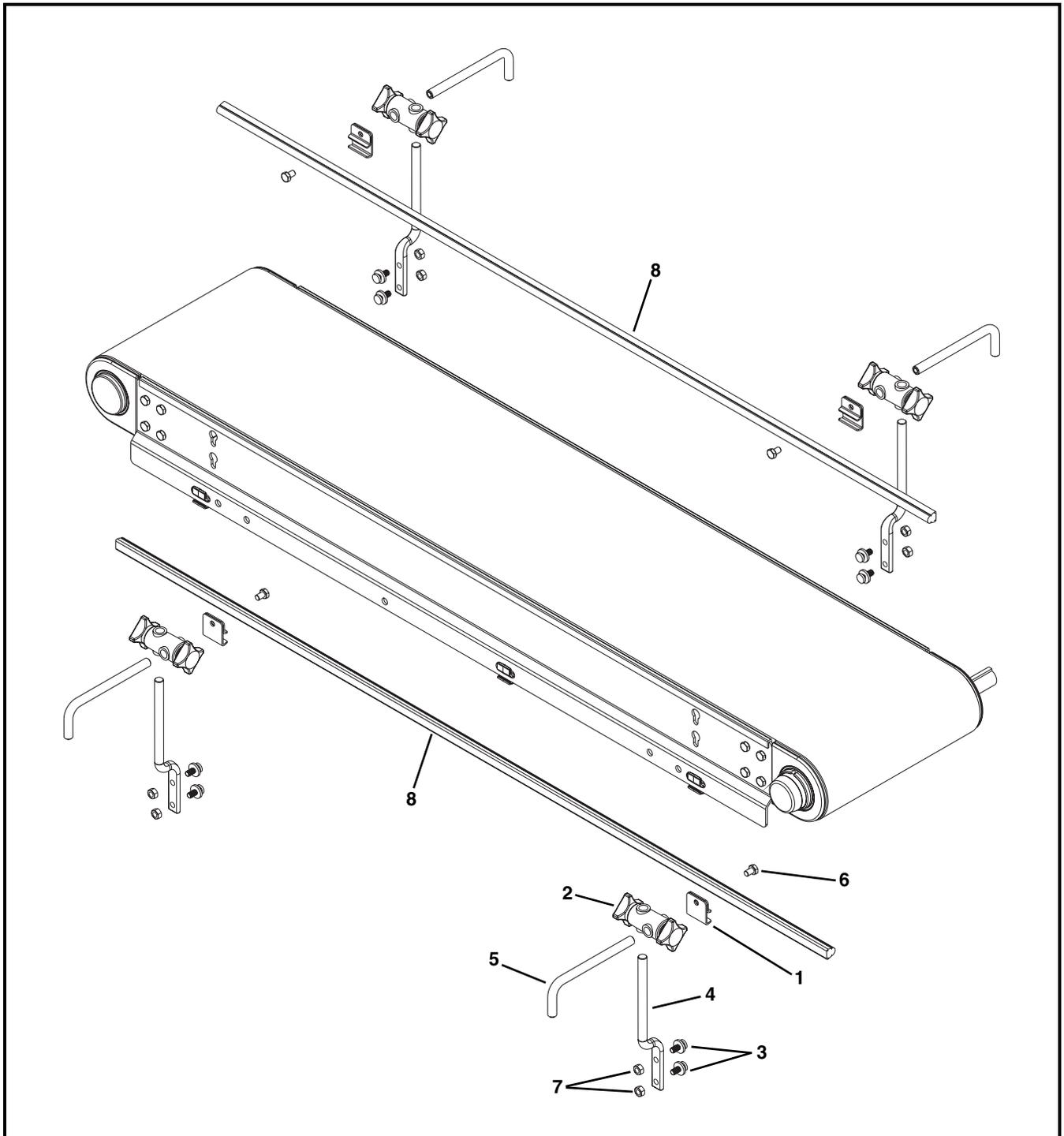
## Fully Adjustable Round Guides



Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

## Tool-Less Fully Adjustable Round Guides

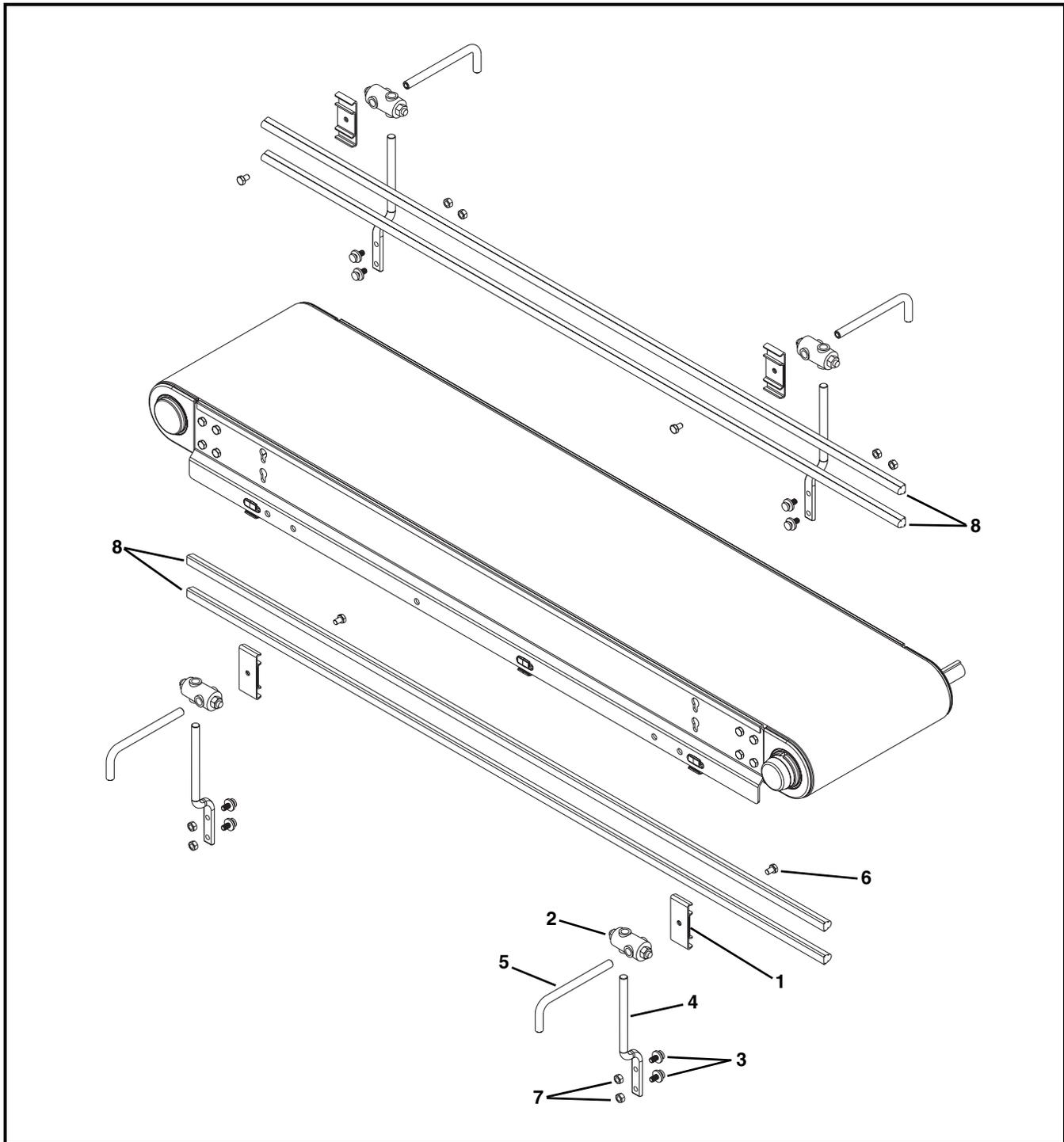


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

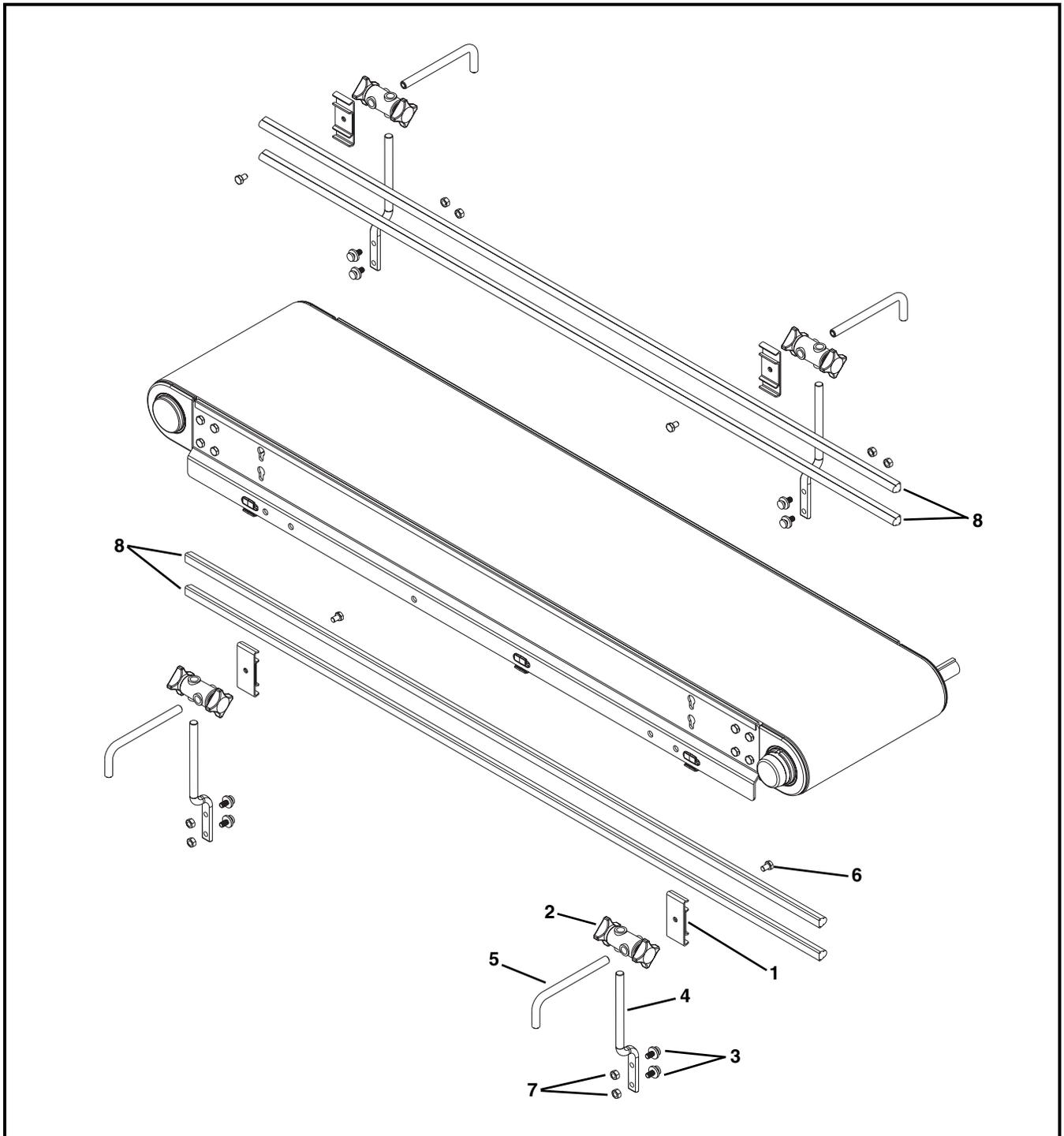
## Twin Rail Adjustable Round Guides



Item	Part Number	Description
1	901414	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

## Tool-Less Twin Rail Adjustable Round Guides

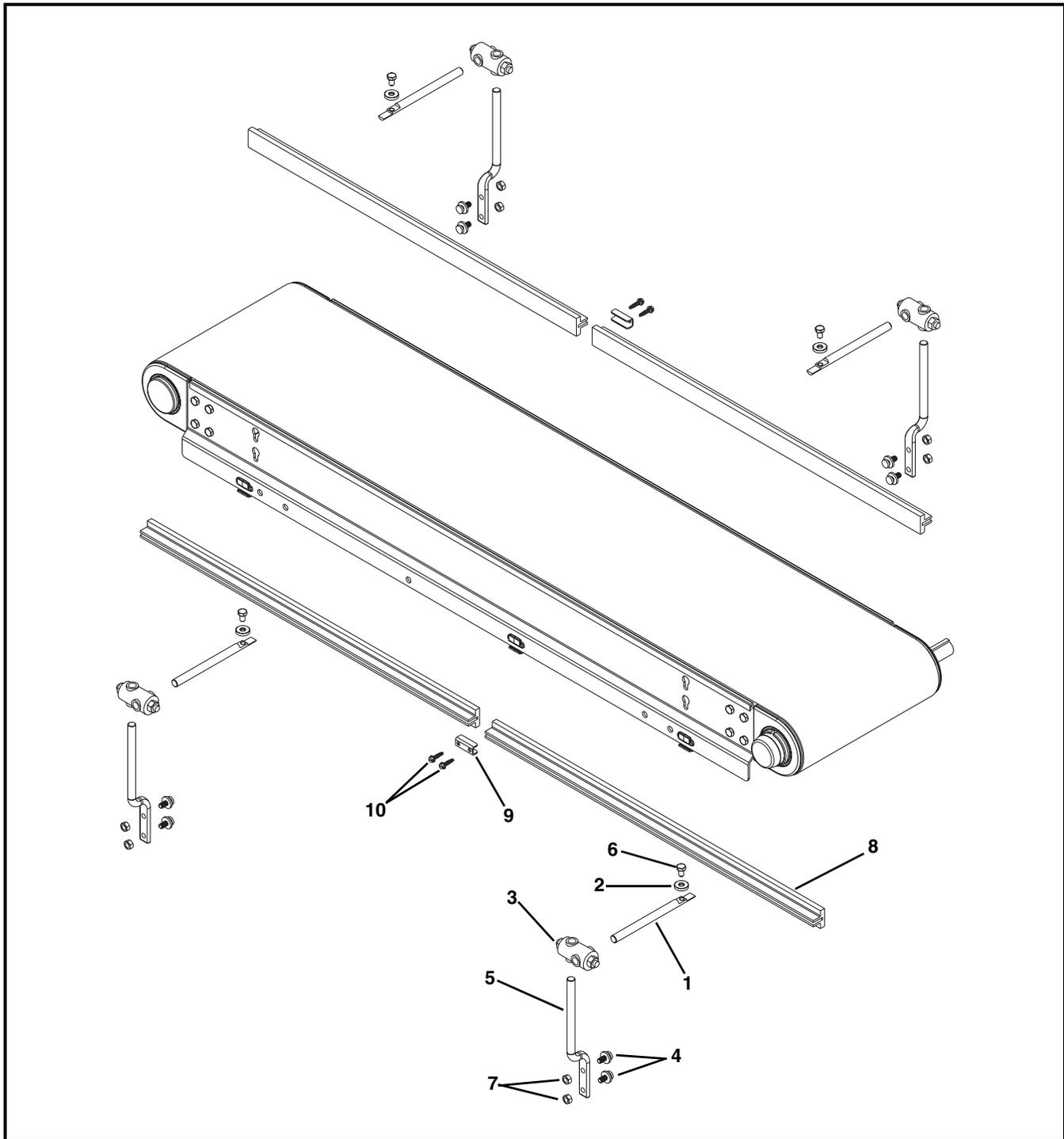


Item	Part Number	Description
1	901414	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

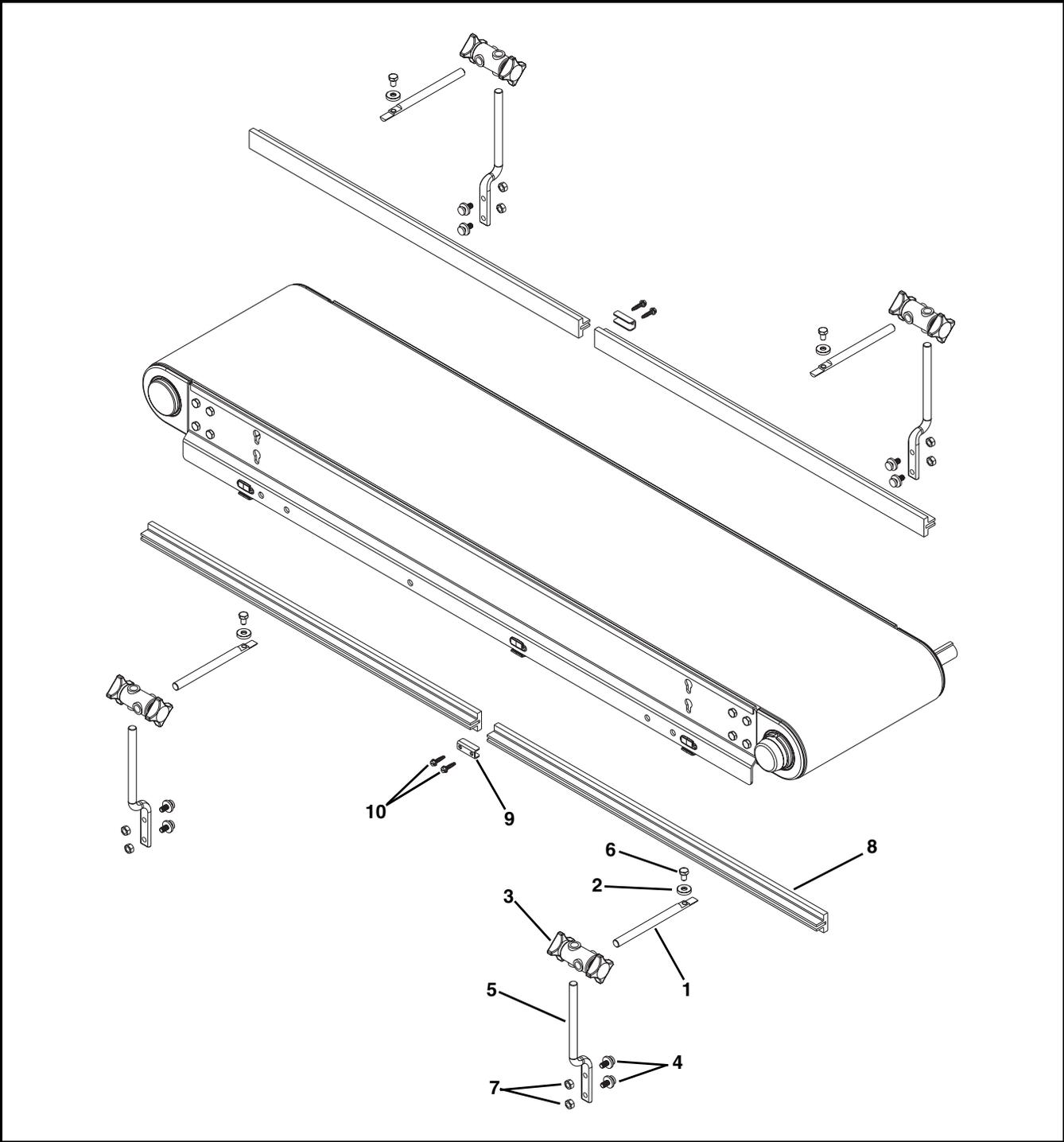
## Fully Adjustable 1" (25 mm) Flat Guides



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

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532170- <u>LLLLL</u>	Round Guide Rail
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

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

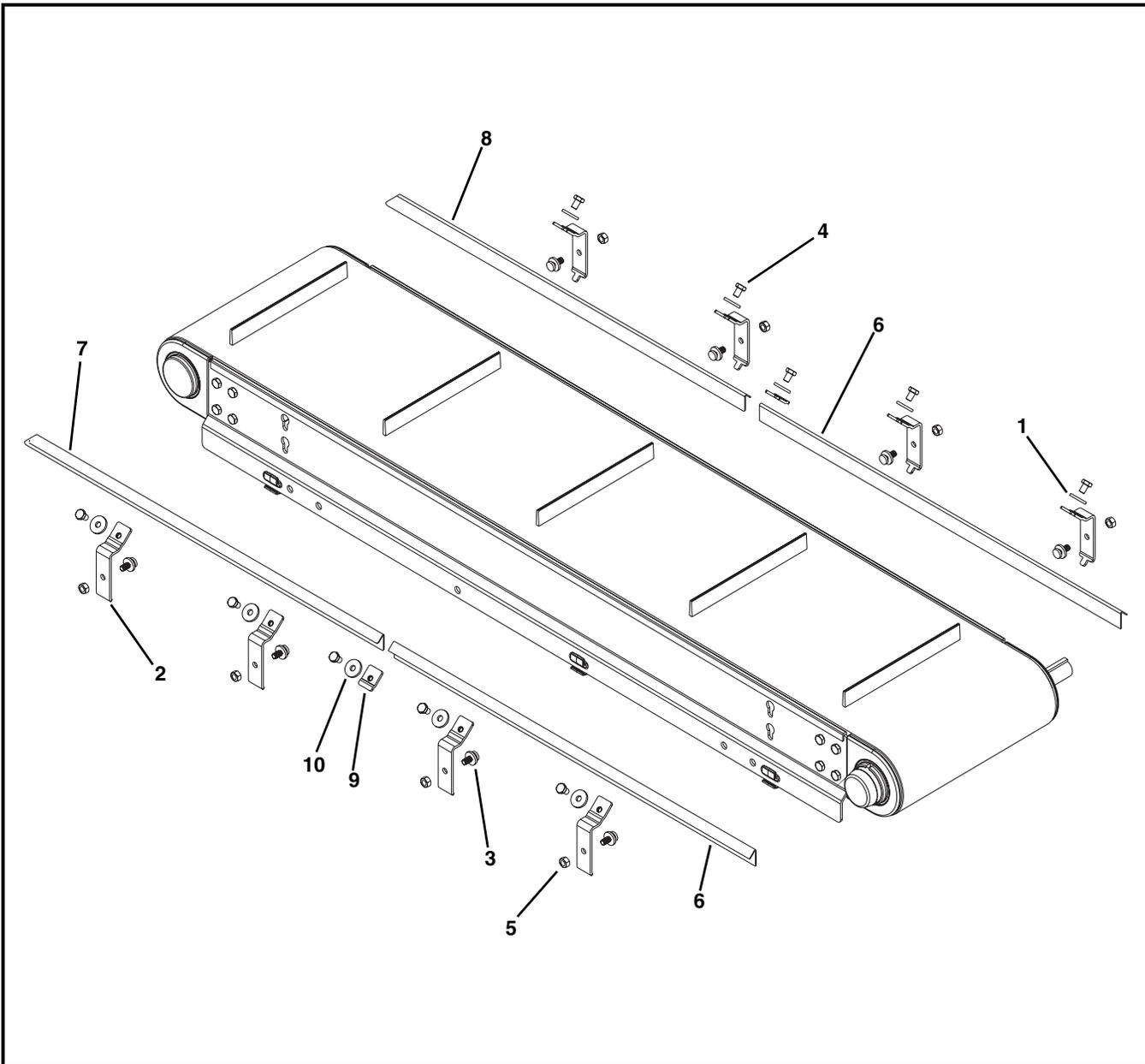


Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1470	Cross Block Clamp
4	532191	Carriage Bolt, M8 x 20 mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532170- <u>LLLLL</u>	Round Guide Rail
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

# Service Parts

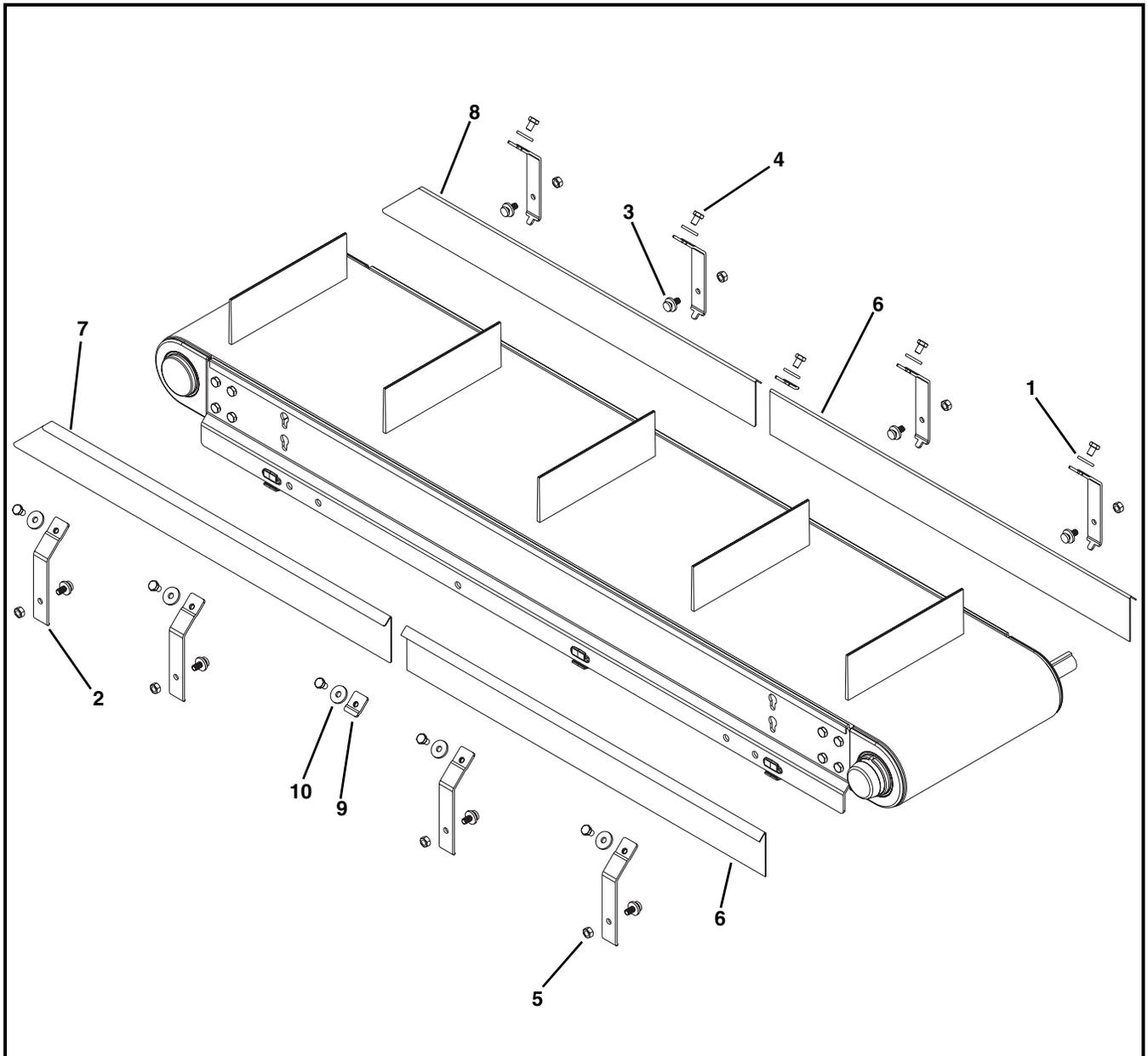
## 1" (25 mm) Cleated High Sides



Item	Part Number	Description
1	807-1821	Washer
2	532184	1" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532175-LLLLL	Guiding Straight

Item	Part Number	Description
7	532176-LLLLL	Guiding Left Hand
8	532177-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

## 3" (76 mm) Cleated High Sides

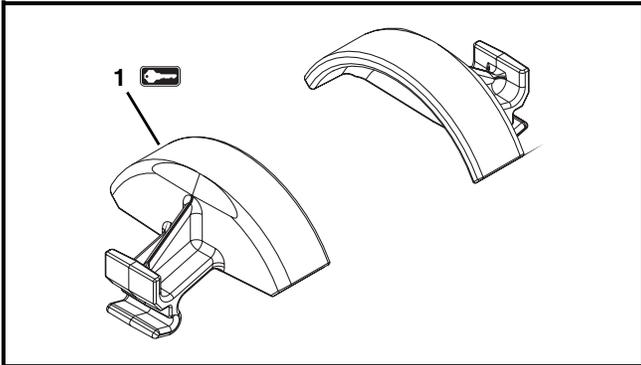


Item	Part Number	Description
1	807-1821	Washer
2	532186	3" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532172-LLLLL	Guiding Straight

Item	Part Number	Description
7	532173-LLLLL	Guiding Left Hand
8	532174-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

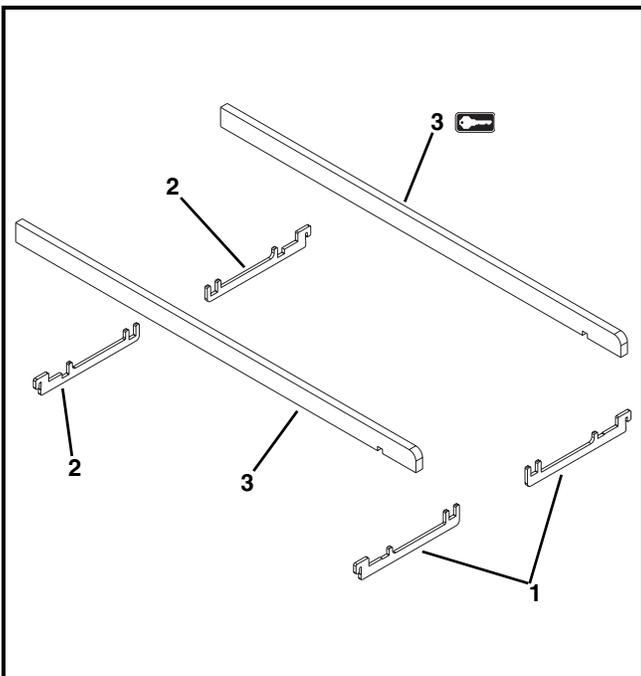
# Service Parts

## 4" (102 mm) - 24" (610 mm) Wide Returns



Item	Part Number	Description
1	532224	Return Shoe

## 26" (660 mm) - 36" (914 mm) Wide Returns



Item	Part Number	Description
1	532154	Front Return Support
2	532153	Return Support
3	532223- <u>LLLLL</u>	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

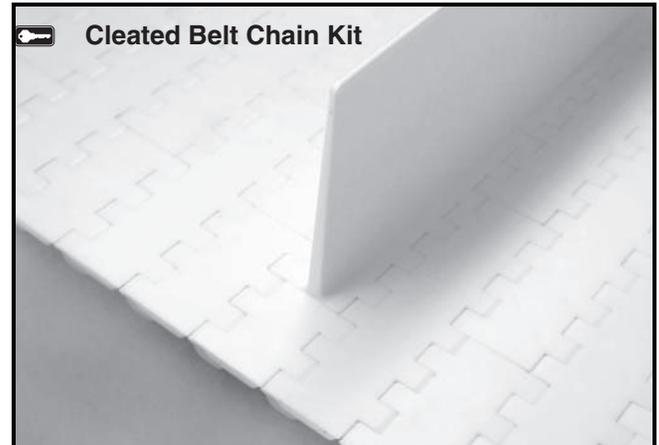
WW = Conveyor width ref: 04-36 in 02 increments

## Flat Belt Chain Repair Kit



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

## Cleated Belt Chain Repair Kit



Item	Part Number	Description
1 	52 <u>BB</u> - <u>WW</u> - <u>SS</u>	Cleated Belt Chain Repair Kit (Includes cleats on 1 ft (305mm) of belt chain and assembly pins)
<u>BB</u> = Chain Reference number		
<u>WW</u> = Conveyor width ref: 08 - 24 in 02 increments		
<u>SS</u> = Cleat Spacing		

# 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](http://www.dorner.com).

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



Dorner Mfg. Corp. reserves the right to change or discontinue products without notice. All products and services are covered in accordance with our standard warranty. All rights reserved. © Dorner Mfg. Corp. 2009

## 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](http://www.dorner.com)

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