



5200 Series Curved Nose Bar 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

Table of Contents

Introduction	2	Removal	12
Warnings – General Safety	3	Installation	13
Product Description	4	Spindle Removal	14
Specifications	4	A - Nose Bar Drive Spindle Removal	14
5200 Series Curve Conveyor Modules	5	B - Idler Spindle Removal	16
5200 Series Infeed / Idler Module	5	C - Nose Bar Idler Spindle Removal	17
5200 Series Curve Module	5	Spindle Replacement	19
5200 Series Intermediate Module	5	Drive Spindle	19
5200 Series Exit / Drive Module	5	Idler Spindle	19
Conveyor Supports	6	Bearing Replacement	19
Installation	7	Drive Bearing Removal and Replacement	19
Required Tools	7	Removal	19
Recommended Installation Sequence	7	Replacement	19
Conveyors Longer than 12 ft (3658 mm)	7	Service Parts	20
Frame Connecting Components	7	Drive End Components	20
All Conveyors	8	Idler End Components	22
Curve Connecting Components	8	Nose Bar Idler End Components	23
Belt Installation	8	Frame Assembly	24
Stand Installation	10	Curve Conveyor Frame and Wear Strips	25
Drive Package Installation	10	Connecting Assembly	27
Preventive Maintenance and Adjustment	11	Flat Belt Returns	27
Required Tools	11	Stand Mount Kit	27
Checklist	11	Fully Adjustable Guiding (Straight Module)	28
Lubrication	11	Fully Adjustable Guiding (Curve Module)	29
Maintaining the Conveyor Belt	11	Tool-Less Fully Adjustable Guiding (Straight Module)	30
Troubleshooting	11	Tool-Less Fully Adjustable Guiding (Curve Module) ...	31
Conveyor Belt Replacement	11	Ordering a Replacement Chain	32
Replacing a Section of Belt	11	Flat Belt Chain Repair Kit	32
Replacing the Entire Belt	12	Notes	33
Conveyor Belt Tensioning	12	Return Policy	34
Wear Strips	12		

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 5200 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

4

Support Stands

5

Motor Controller

6

Drive End

7

Idler End

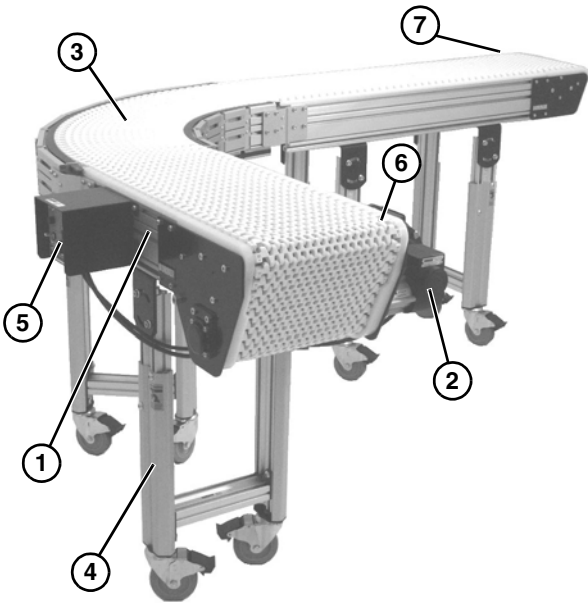


Figure 1

Specifications

Conveyor Width Reference (<u>WW</u>)	08 – 36 in 02 increments
Conveyor Belt Width	8" (203 mm) - 36" (914 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft ² (97 kg/ m ²) with a maximum of 500 lbs. (227 kg)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	250 ft/minute (76 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

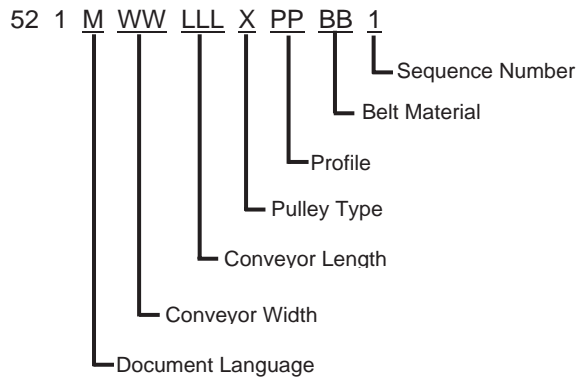
• Conveyor being mounted horizontally

• Conveyor being located in a dry environment

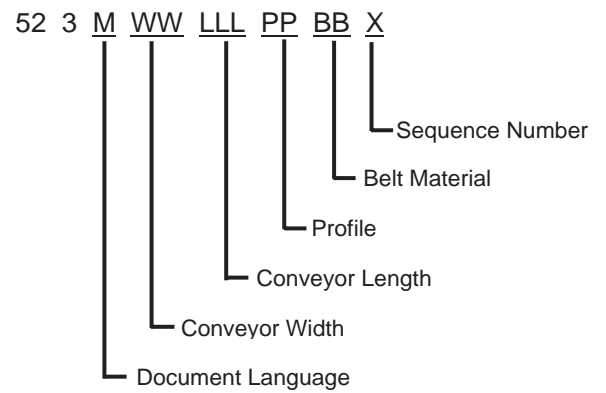
• Conveyor equipped with standard belt only

5200 Series Curve Conveyor Modules

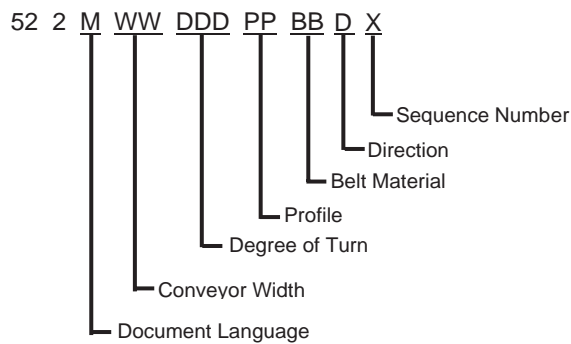
5200 Series Infeed / Idler Module



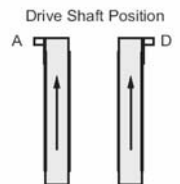
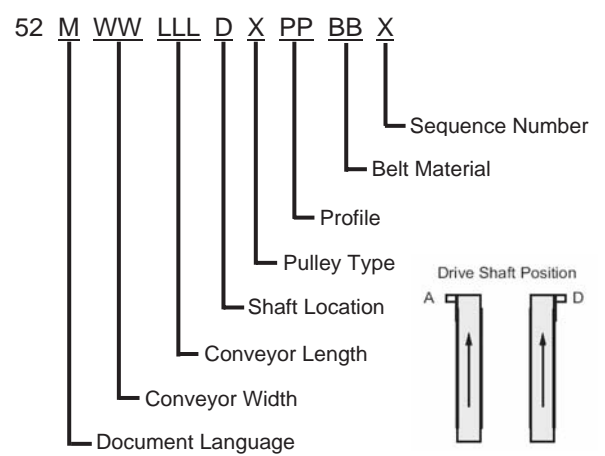
5200 Series Intermediate Module



5200 Series Curve Module



5200 Series Exit / Drive Module



Specifications

Conveyor Supports

Infeed / Idler Module:

- “A” = 3 ft (914 mm) maximum (See **Figure 2**)
- Modules 24” - 47” long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, 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” = 3 ft (914 mm) maximum (See **Figure 2**)
- Modules 24” - 47” 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’)

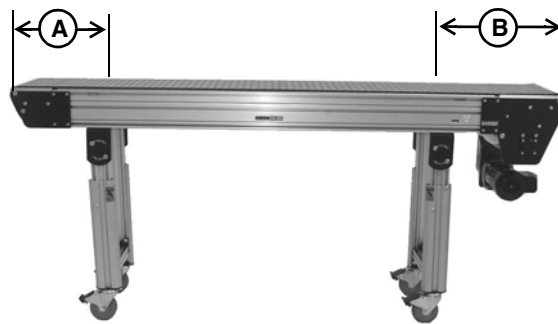


Figure 2

Curve Module:

- Reference chart for support stand quantities, evenly spaced along curve (See **Figure 3**)

Width Degree	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"
15°	0	0	0	0	0	0	0	0	0	0	0	0	0	1	1
30°	0	0	0	0	0	1	1	1	1	1	1	1	1	1	1
45°	0	0	1	1	1	1	1	1	1	1	1	1	1	1	1
60°	0	1	1	1	1	1	1	1	1	1	1	1	1	1	1
75°	1	1	1	1	1	1	1	1	1	1	1	1	1	2	2
90°	1	1	1	1	1	1	1	1	1	1	2	2	2	2	2
105°	1	1	1	1	1	1	1	1	2	2	2	2	2	2	2
120°	1	1	1	1	1	1	1	2	2	2	2	2	2	2	2
135°	1	1	1	1	1	1	2	2	2	2	2	2	2	3	3
150°	1	1	1	1	1	2	2	2	2	2	2	3	3	3	3
165°	1	1	1	1	2	2	2	2	2	2	3	3	3	3	3
180°	1	1	1	2	2	2	2	2	2	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.

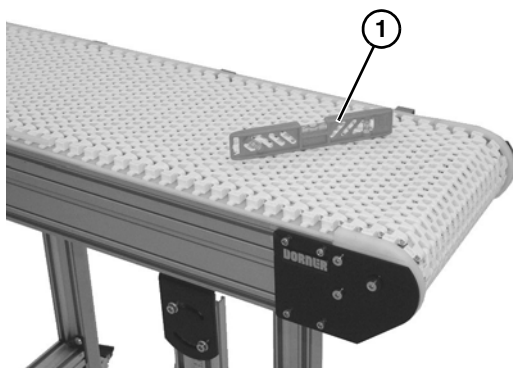


Figure 4

Required Tools

- Level
- Torque wrench
- 4 mm hex wrench
- 5 mm hex wrench

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to “Conveyors Longer than 12 ft (3658 mm)” on page 7 or “All Conveyors” on page 8.
2. Attach the stands. Refer to “Stand Installation” on page 10.
3. Install the gearmotor. Refer to “Drive Package Installation” on page 10.

Conveyors Longer than 12 ft (3658 mm)

Frame Connecting Components

Typical Frame Connecting Components (Figure 5)

- | | |
|---|---------------------------------------|
| 1 | Bar Frame Connector |
| 2 | Drop-in Tee Bar |
| 3 | Conveyor frames |
| 4 | Plate Frame Connector |
| 5 | Low Head Cap Screw, M6 - 1.00 x 12 mm |
| 6 | Washer |
| 7 | Socket Head Screw, M6 - 1.00 x 20 mm |

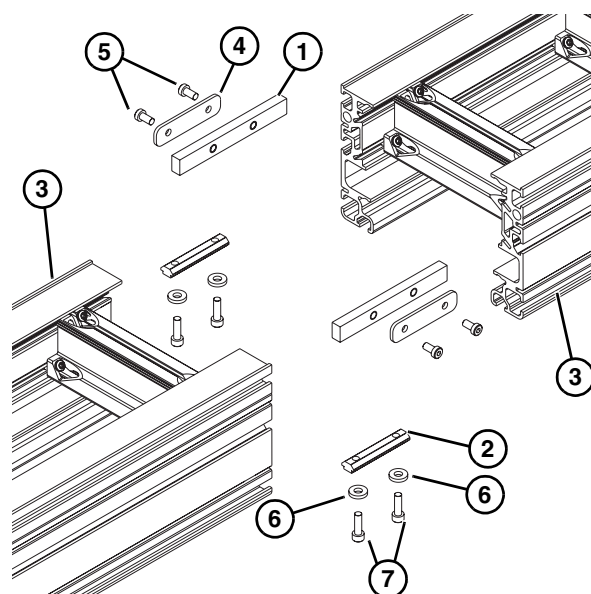


Figure 5

1. Install two bar frame connectors (Figure 5, item 1) and two drop-in tee bars (Figure 5, item 2) into one conveyor section (Figure 5, item 3).
2. Join both conveyor sections, and install plate frame connectors (Figure 5, item 4), and secure with M6x12 low head cap screws (Figure 5, item 5) on both sides. Tighten cap screws to 60 in-lb (7 Nm).
3. Install washers (Figure 5, item 6) and M6x20 socket head screws (Figure 5, item 7) into drop-in tee bar (Figure 5, item 2) on both sides as indicated. (Do not tighten hardware. This is for stand installation.)

NOTE

The stop plate (Figure 6, item 1) on the center wear strip (Figure 6, item 2) faces the drive end (Figure 6, item 3) of the conveyor.

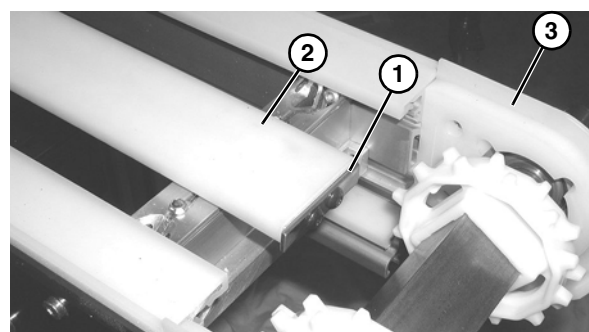


Figure 6

Installation

All Conveyors

Curve Connecting Components

Typical Curve Connecting Components (**Figure 7**)

- | | |
|---|--------------------------------------|
| 1 | Offset Connecting Plate, Left |
| 2 | Offset Connecting Plate, Right |
| 3 | Curved Section |
| 4 | Drop-in Tee Bar |
| 5 | Socket Head Screw, M6 - 1.00 x 16 mm |
| 6 | Straight Section |

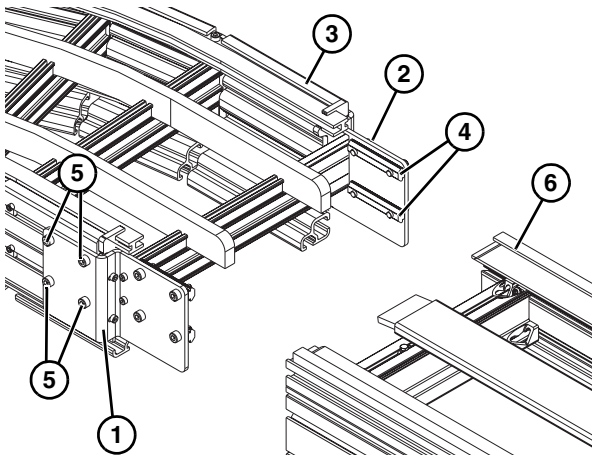


Figure 7

1. For joining curved to straight sections, install left offset connecting plate (**Figure 7, item 1**) and right connecting plate (**Figure 7, item 2**) onto curved section (**Figure 7, item 3**) with two drop-in tee bars (**Figure 7, item 4**) and four M6x16 socket head screws (**Figure 7, item 5**), making sure the straight frame section is flush to the curve section crossmember.
2. Secure straight section (**Figure 7, item 6**) onto curved section with the same hardware as previous step. Tighten all socket head screws to 60 in-lb (7 Nm).

NOTE

*The bottom of the straight frame sections (**Figure 8, item 1**) and curve frame sections (**Figure 8, item 2**) must be level.*

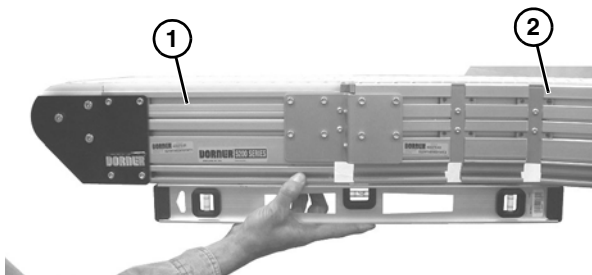


Figure 8

Belt Installation

Typical Belt Components (**Figure 9**)

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

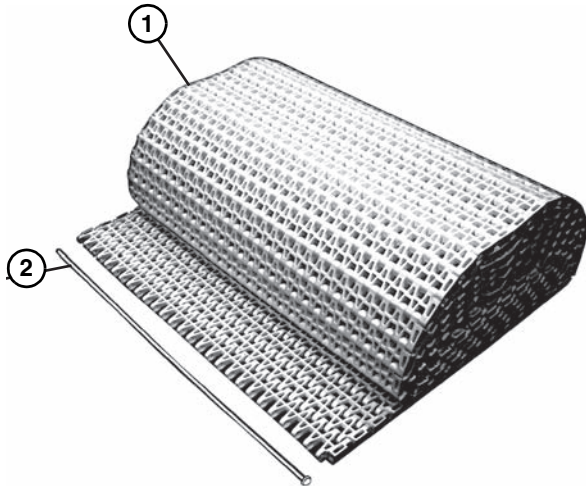


Figure 9

NOTE

*Ensure the belt is running in the correct direction, with hole (**Figure 10, item 1**) towards conveyor motor.*

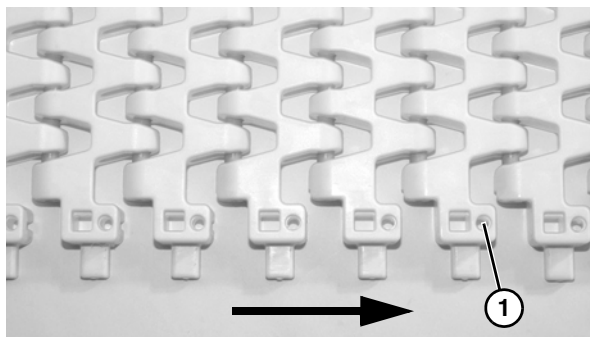


Figure 10

1. Position the belt on the conveyor frame (**Figure 11**).

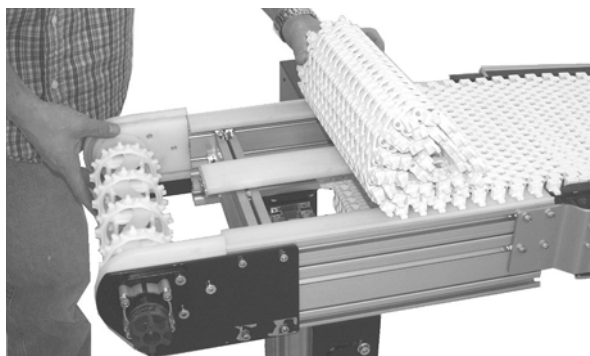


Figure 11

2. Wrap belt around idler tail.
3. Install belt around lower frame section and above lower wear strips (**Figure 12, item 1**).

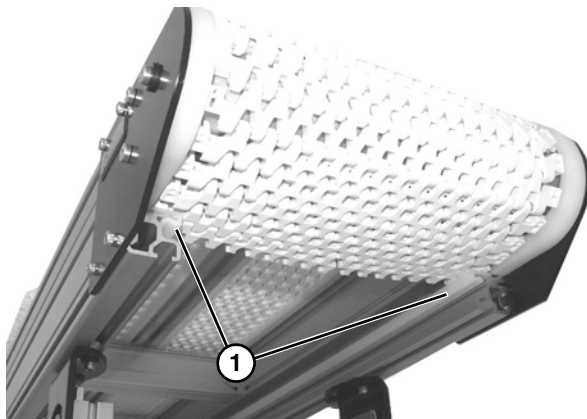


Figure 12

4. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth (**Figure 13, item 1**) mating with rounded section (**Figure 13, item 2**) of belt.

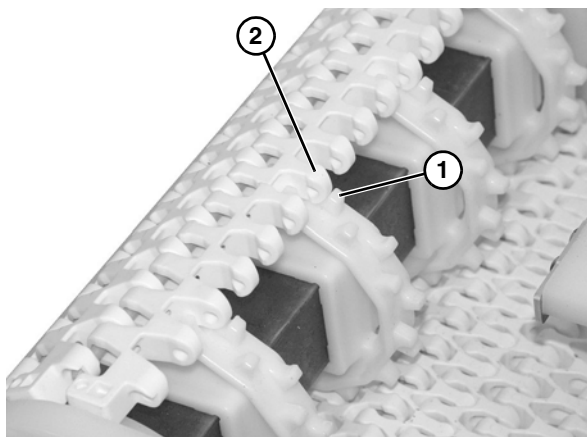


Figure 13

5. Feed the ends of the belt through the top and bottom of the curved frame sections.
6. Bring the ends of the belt together (**Figure 14**).

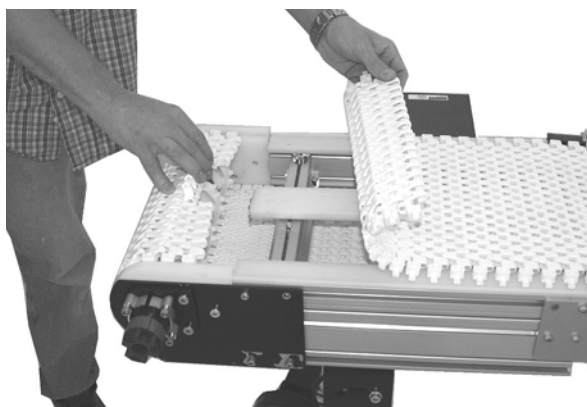


Figure 14

7. Insert the belt rod (**Figure 15, item 1**).

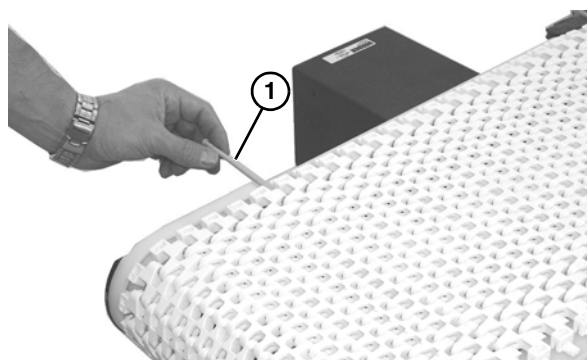


Figure 15

8. Push the belt rod in as far as possible.
9. Lightly tap the head of the rod with a hammer until it snaps into position.
10. Slide the top wear strips (**Figure 16, item 1**) with wide lip facing up, under the conveyor belt (**Figure 16, item 2**) catching the bottom lip on conveyor frame, to cover the belt tabs.

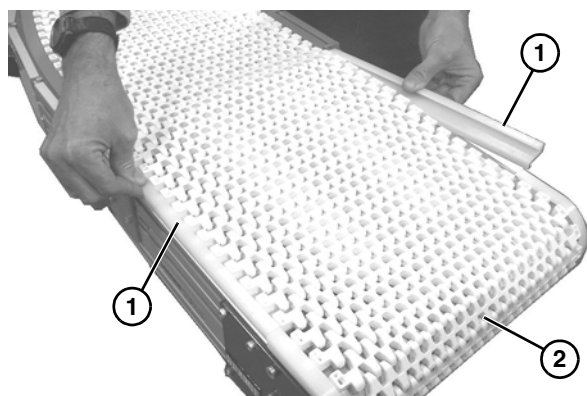


Figure 16

 WARNING

<p>CRUSH HAZARD!</p> <p>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.</p>

Installation

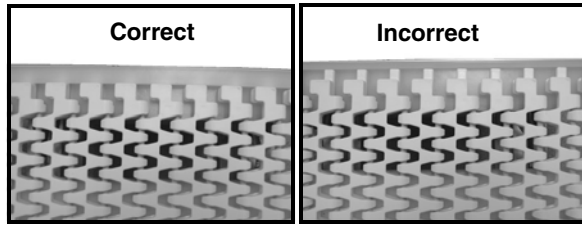


Figure 17

NOTE

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

Stand Installation

NOTE

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

Typical stand components (Figure 18)

- | | |
|---|--|
| 1 | Conveyor Frame |
| 2 | Stand |
| 3 | M6 - 1.0 x 20 mm socket head cap screws (x4) |

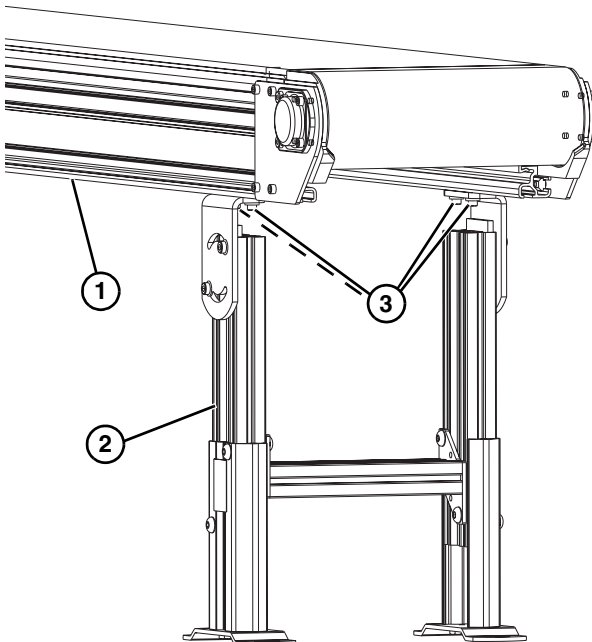


Figure 18

1. Properly support the conveyor.

2. Attach stands (Figure 19, item 1) to the bottom of the conveyor frame (Figure 19, item 2). Tighten socket head screws (Figure 19, item 3), on each side, to secure in place.

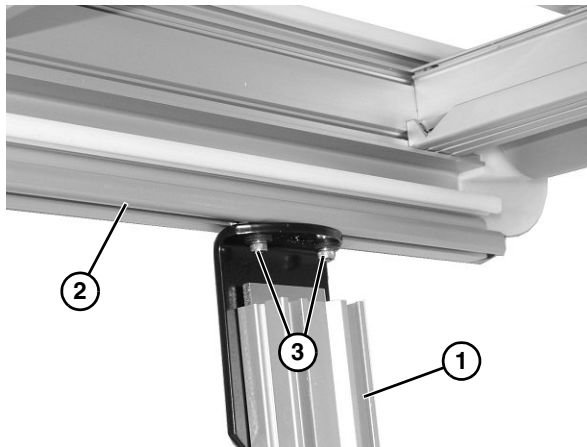


Figure 19

Drive Package Installation

NOTE

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

1. Attach the motor (Figure 20, item 1) to the gear reducer (Figure 20, item 2).

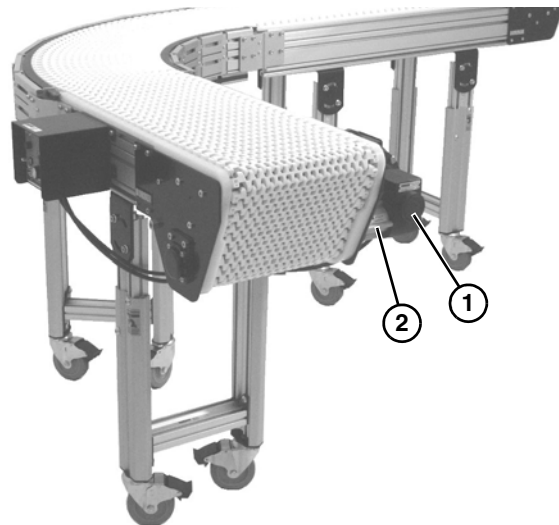


Figure 20

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 20 for recommendations.
- Replace any worn or damaged parts.

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

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

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

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

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

Skipping indicates:

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

Conveyor Belt Replacement



WARNING



SEVERE HAZARD!

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

Replacing a Section of Belt

1. Use a punch and hammer to push the belt rod (Figure 21, item 1) out by striking the rod end opposite the retaining head.



WARNING



SEVERE HAZARD!

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

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

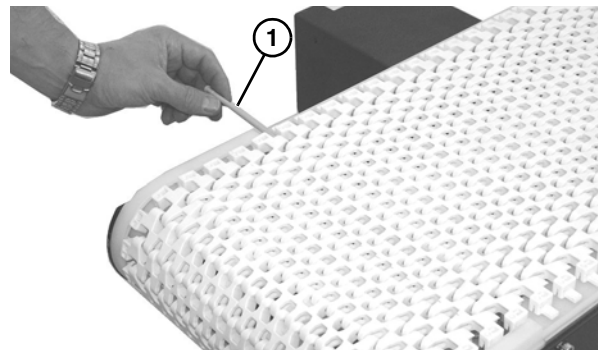


Figure 21

3. Replace old section of belt.

CAUTION

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

Preventive Maintenance and Adjustment

Replacing the Entire Belt

1. Use a punch and hammer to push the belt rod (Figure 22, item 1) out by striking the rod end opposite the retaining head.

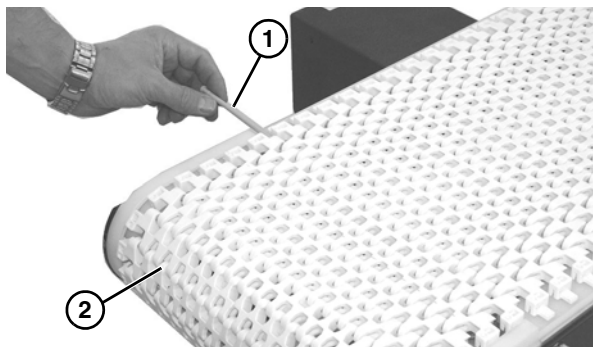


Figure 22

2. Slide the old belt (Figure 22, item 2) off the conveyor frame.
3. Replace the old belt with a new one. Refer to “Belt Installation” on page 8.

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. Refer to “Replacing a Section of Belt” on page 11.

Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips (Figure 23)

- | | |
|---|-------------------------------|
| 1 | Wear Strip, Center |
| 2 | Wear Strips, Lower Side |
| 3 | Wear Strips, Lower Side |
| 4 | Stop Plate, Center Wear Strip |

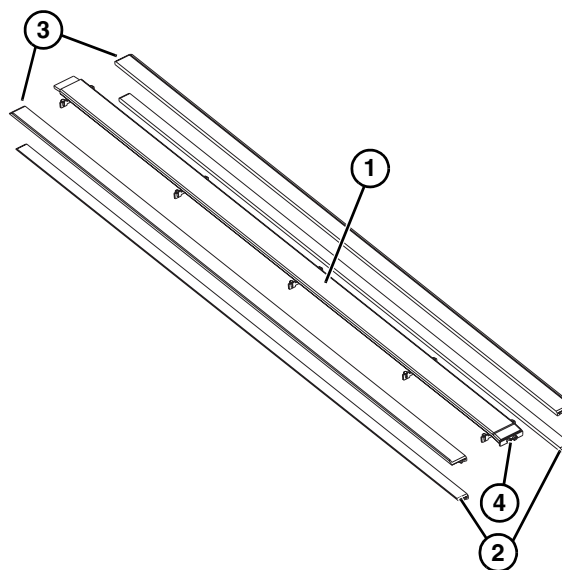


Figure 23

Removal

1. Remove upper wear strips (Figure 24, item 1) from top of frame assembly.

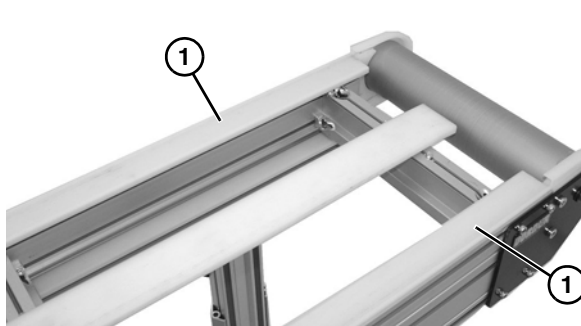


Figure 24

Preventive Maintenance and Adjustment

2. Remove lower wear strips (**Figure 25, item 1**), and if necessary, lower belt return (**Figure 25, item 2**) from lower frame assembly.

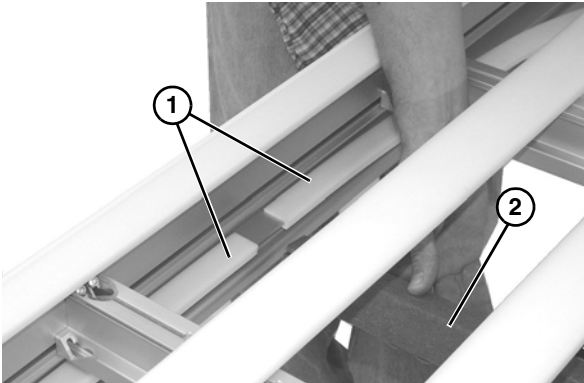


Figure 25

3. Remove two screws (**Figure 26, item 1**) from each clamp on center frame channel.

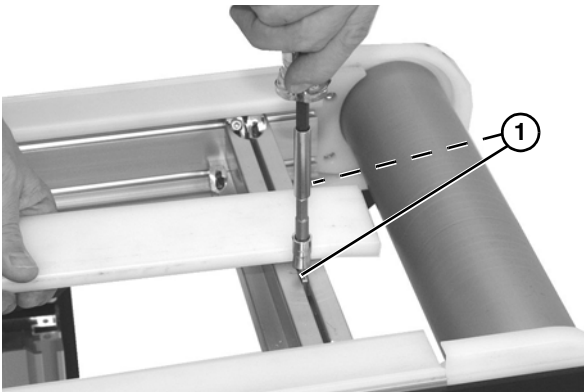


Figure 26

4. Remove center frame channel (**Figure 27, item 1**), making sure to keep each clamp matched with channel of each cross member (**Figure 27, item 2**).

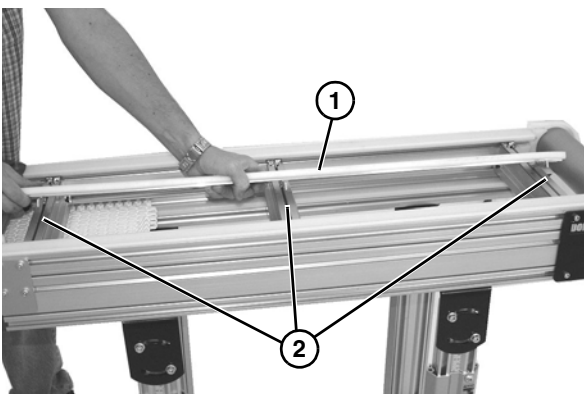


Figure 27

5. Remove the center wear strip (**Figure 28, item 1**) from the center frame channel (**Figure 28, item 2**).

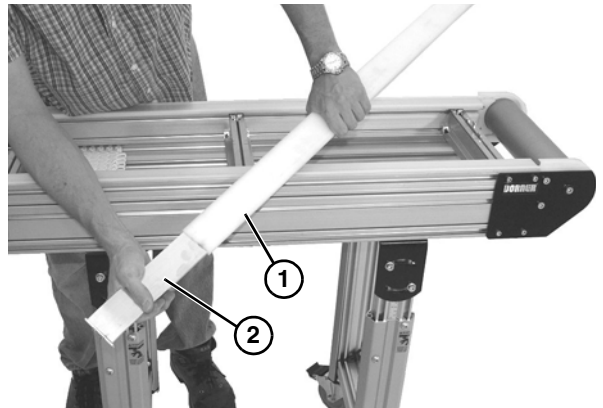


Figure 28

Installation

NOTE

*The stop plate (**Figure 29, item 1**) on the center wear strip (**Figure 29, item 2**) faces the drive end (**Figure 29, item 3**) of the conveyor.*

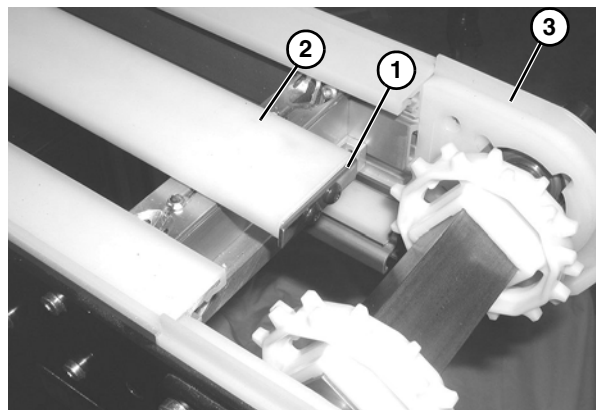



Figure 29

Install components reverse of removal.

Preventive Maintenance and Adjustment

Spindle Removal

⚠ WARNING

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

Remove conveyor belt to access spindle(s). See “Replacing the Entire Belt” on page 12. Remove the desired spindle following the corresponding instructions below:

- **A** – Nose Bar Drive Spindle Removal
- **B** – Idler Spindle Removal
- **C** – Nose Bar Idler Spindle Removal

A – Nose Bar Drive Spindle Removal

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Remove socket head bolt (**Figure 30, item 1**) on each side of drive tail assembly (**Figure 30, item 2**).

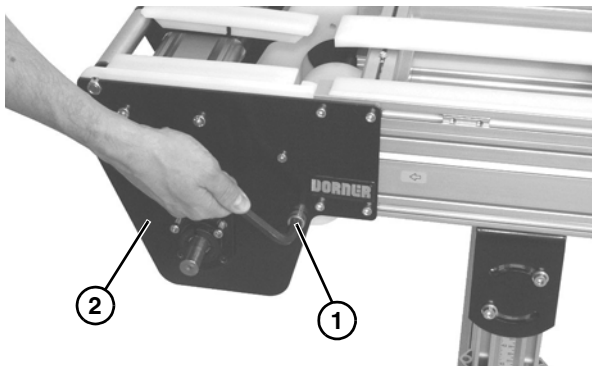


Figure 30

3. Lower roller assembly (**Figure 31, item 1**) from drive tail assembly (**Figure 31, item 2**).

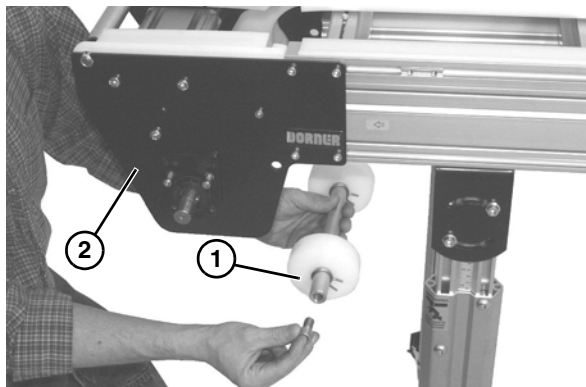


Figure 31

4. Loosen the four socket head screws (**Figure 32, item 1**). Repeat on opposite side.

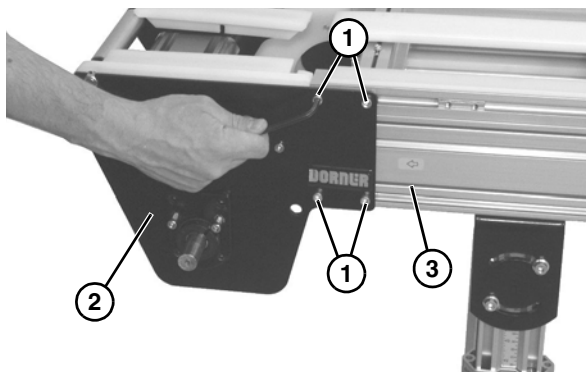


Figure 32

5. Remove the drive tail assembly (**Figure 32, item 2**) from the frame (**Figure 32, item 3**).
6. On right side, remove four socket head screws (**Figure 33, item 1**) and cover (**Figure 33, item 2**).

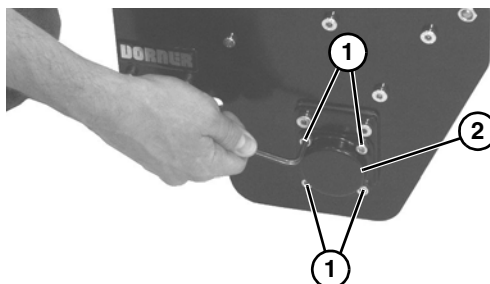


Figure 33

Preventive Maintenance and Adjustment

7. Loosen the bearing collar set screw (**Figure 34, item 1**) and remove bearing collar (**Figure 34, item 2**).

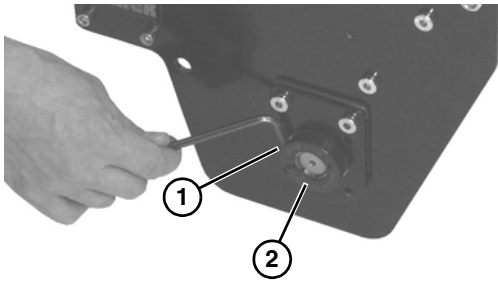


Figure 34

8. Remove three socket head screws (**Figure 34, item 1**), and remove plate and drive terminal assembly (**Figure 34, item 2**) from drive spindle (**Figure 34, item 3**) and crossmember (**Figure 34, item 4**).

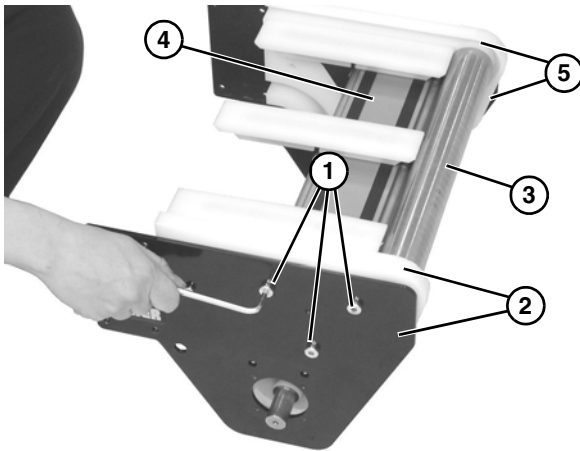


Figure 35

9. Remove drive spindle (**Figure 34, item 3**), from opposite side plate and drive terminal assembly (**Figure 34, item 5**).
10. Remove retaining clip (**Figure 36, item 1**) and flanged puck (**Figure 36, item 2**) from drive spindle.

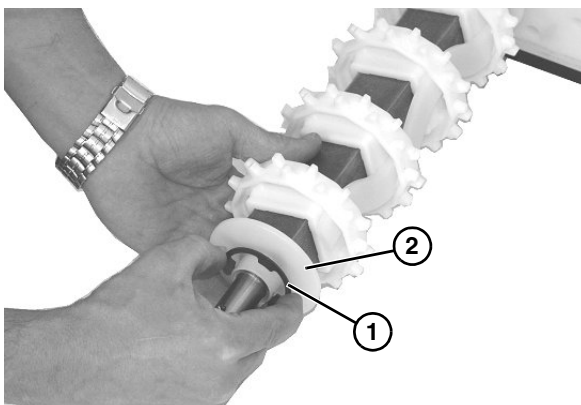


Figure 36

11. Slide entire sprocket assembly slightly outward, and remove the first sprocket (**Figure 37, item 1**) off the drive spindle and alignment bar (**Figure 37, item 2**).

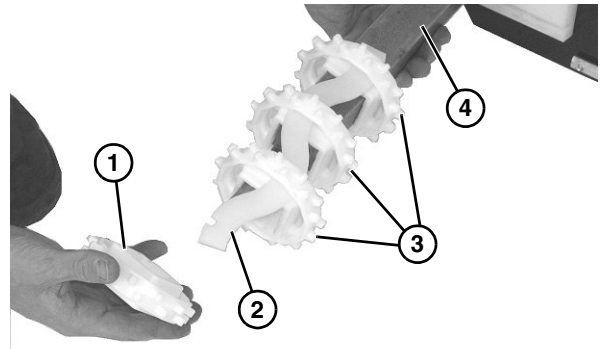


Figure 37

12. Remove remaining sprockets (**Figure 37, item 3**) off the alignment bar as you slide entire assembly off the drive spindle (**Figure 37, item 4**).
13. To assemble sprockets onto drive spindle, slide one sprocket (**Figure 38, item 1**) onto alignment bar (**Figure 38, item 2**) and slide assembly onto drive spindle (**Figure 38, item 3**).

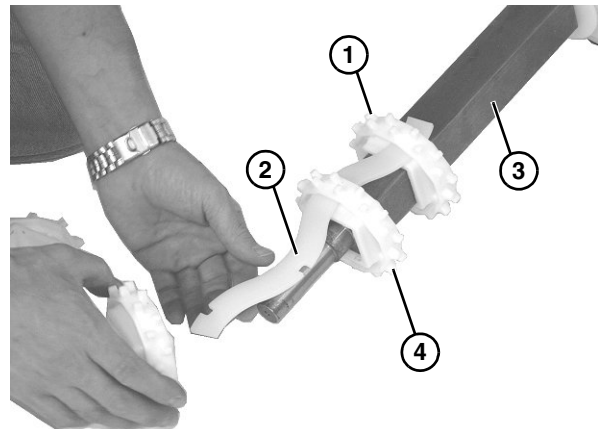


Figure 38

14. Install second sprocket (**Figure 38, item 4**) and subsequent sprockets one by one, while sliding entire assembly onto alignment bar and spindle.
15. Check drive terminal assembly (**Figure 39, item 1**) for wear. If worn, remove two low head cap screws (**Figure 39, item 2**) and low head cap screw (**Figure 39, item 3**) and replace.

Preventive Maintenance and Adjustment

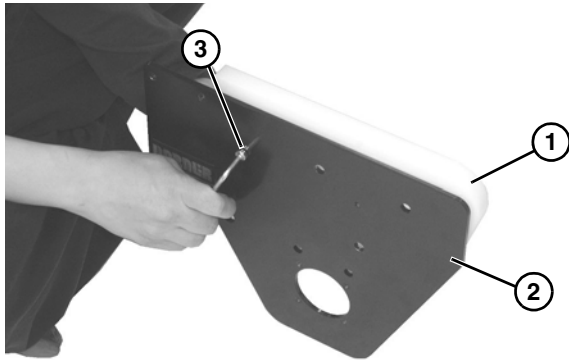


Figure 39

NOTE

When reinstalling the drive spindle tail assembly, the terminal assembly (Figure 40, item 1) should be flush with the conveyor frame (Figure 40, item 2).

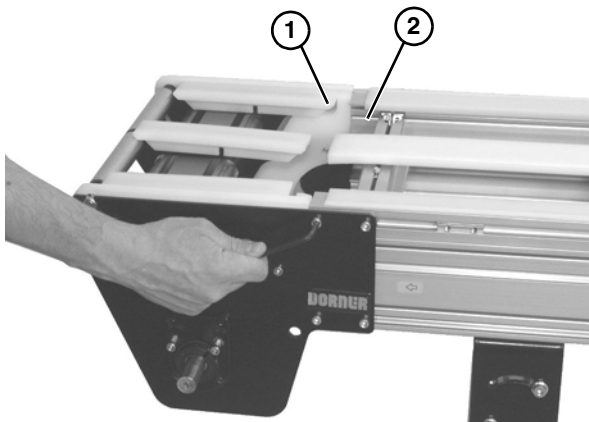


Figure 40

B – Idler Spindle Removal

1. Be sure the conveyor is supported.
2. On one side of conveyor, loosen the four socket head screws (Figure 41, item 1). Repeat on opposite side.

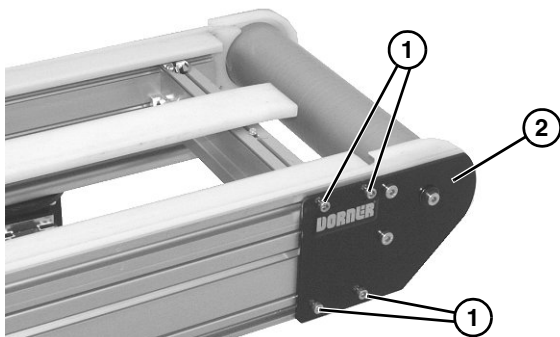


Figure 41

3. Remove idler tail assembly (Figure 41, item 2).

4. Remove socket head screw (Figure 42, item 1) from plate (Figure 42, item 2) and center of spindle shaft (Figure 42, item 3). Repeat procedure on opposite side.

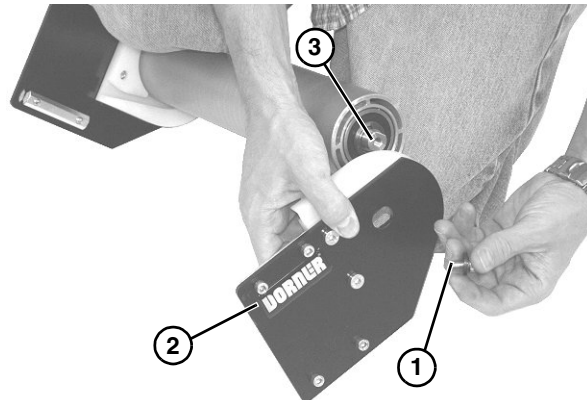


Figure 42

5. Remove the spindle shaft assembly: remove the clip ring (Figure 43, item 1) and washer (Figure 43, item 2) from one side of the spindle assembly.

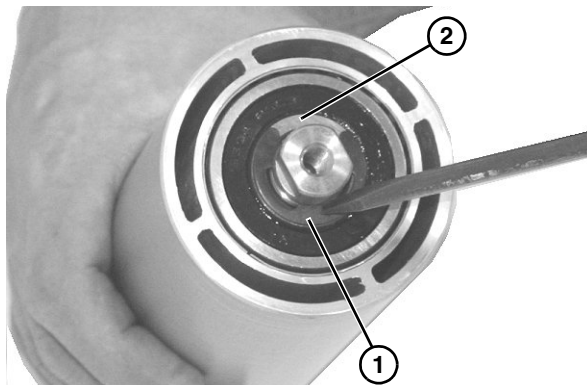


Figure 43

6. Slide the shaft assembly (Figure 44, item 1) out of the pulley (Figure 44, item 2).

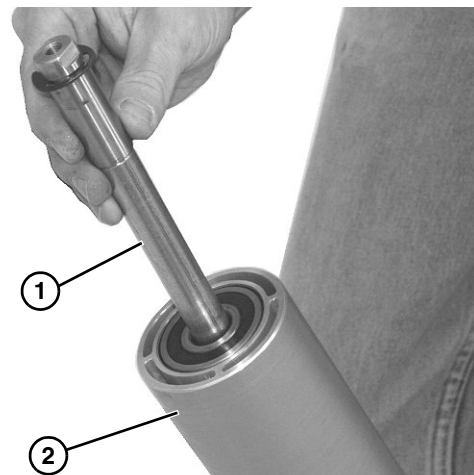


Figure 44

Preventive Maintenance and Adjustment

7. Check idler terminal assembly (**Figure 45, item 1**) for wear. If worn, remove two low head cap screws (**Figure 45, item 2**) and replace.

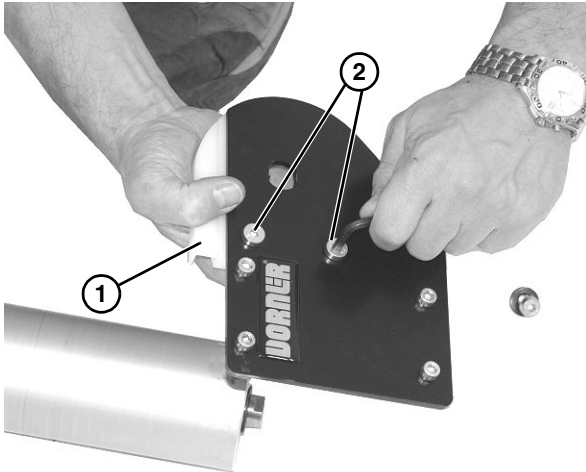


Figure 45

NOTE

*When reinstalling the idler spindle tail assembly, the idler terminal assembly (**Figure 46, item 1**) should be flush with the conveyor frame (**Figure 46, item 2**).*

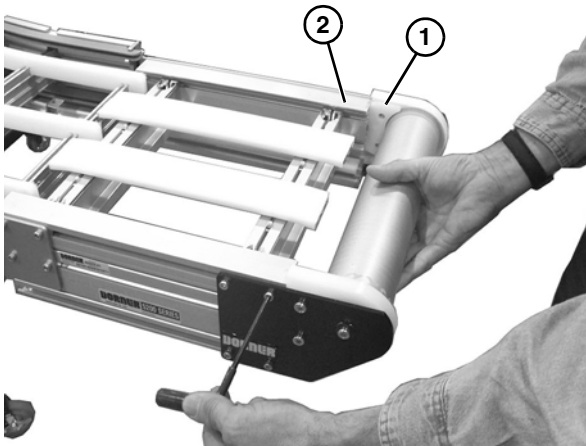


Figure 46

C – Nose Bar Idler Spindle Removal

1. Be sure the conveyor is supported.
2. On one side of conveyor, loosen the four socket head screws (**Figure 47, item 1**). Repeat on opposite side.

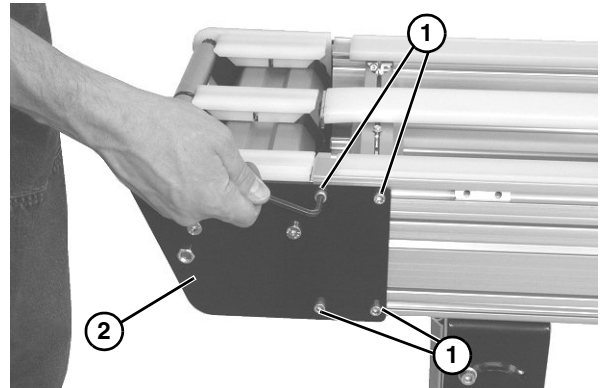


Figure 47

3. Remove idler tail assembly (**Figure 47, item 2**).
4. Remove two low head cap screws (**Figure 48, item 1**) from plate (**Figure 48, item 2**). Repeat procedure on opposite side.

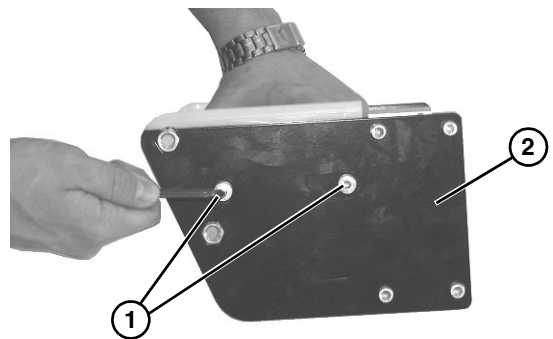


Figure 48

5. Remove upper nut (**Figure 49, item 1**) and spacer from end of axle shaft assembly.

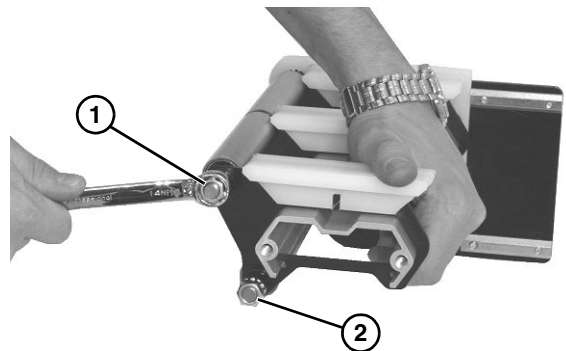


Figure 49

6. Remove lower nut (**Figure 49, item 2**) and spacer from lower axle shaft assembly.

Preventive Maintenance and Adjustment

7. Slide the support plate (**Figure 50, item 1**) off of both axle shafts.

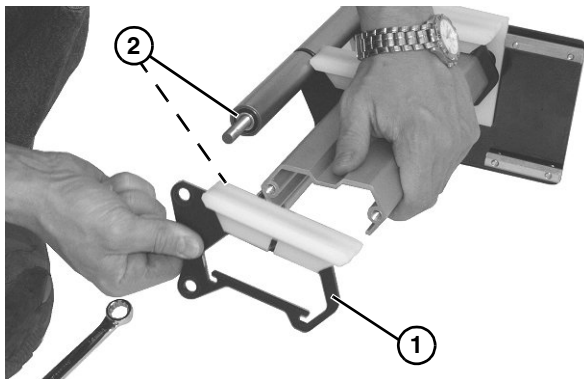


Figure 50

8. Remove washer (**Figure 50, item 2**) off of lower and upper axle shafts.
9. Remove roller assembly (**Figure 51, item 1**) and washer (**Figure 51, item 2**) from axle shaft (**Figure 51, item 3**).

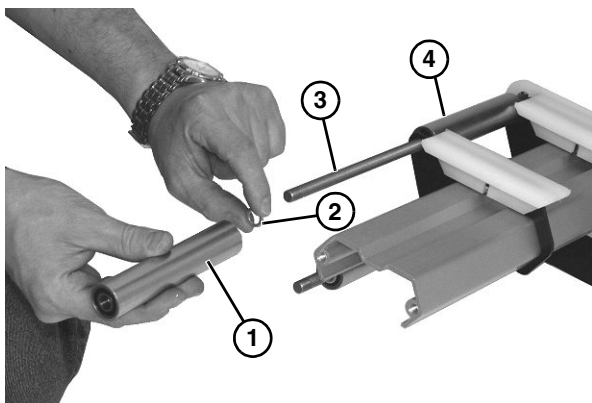


Figure 51

10. Remove remaining roller assembly components (**Figure 51, item 4**) on opposite side.

11. Check idler terminal assembly on each side (**Figure 52, item 1**) for wear. If worn, replace.

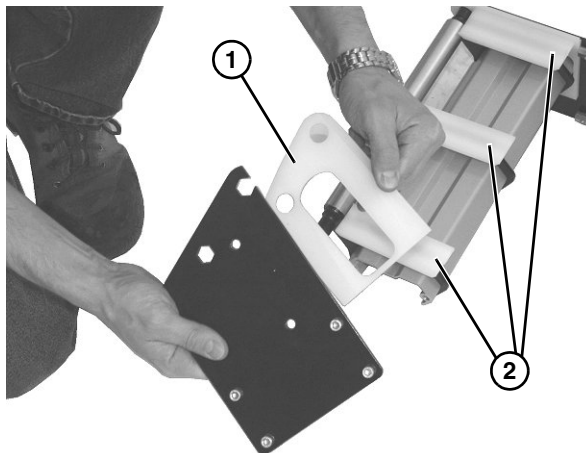


Figure 52

12. Remove and replace wear guides (**Figure 52, item 2**) if worn. When replacing, secure onto pins on each support plate.

NOTE

*When reinstalling the idler spindle tail assembly, the idler terminal assembly (**Figure 53, item 1**) should be flush with the conveyor frame (**Figure 53, item 2**).*

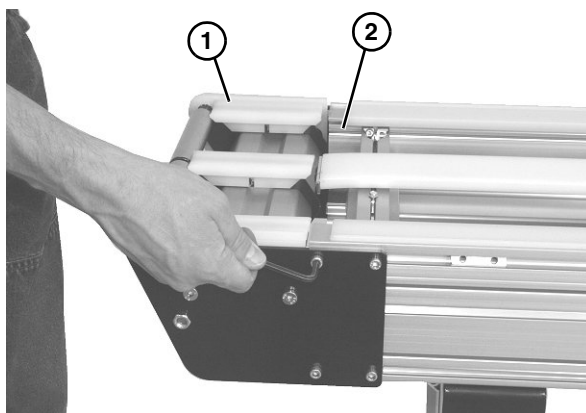


Figure 53

Preventive Maintenance and Adjustment

Spindle Replacement


Drive Spindle

To replace the drive spindle, reverse the "A - Nose Bar Drive Spindle Removal" procedure on page 14.

Idler Spindle

To replace the idler spindle, reverse the "B - Idler Spindle Removal" procedure on page 16.

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.

Removal

1. Turn bearing (**Figure 54, item 1**) to align with slots (**Figure 54, item 2**) in bearing housing. Then remove bearing.

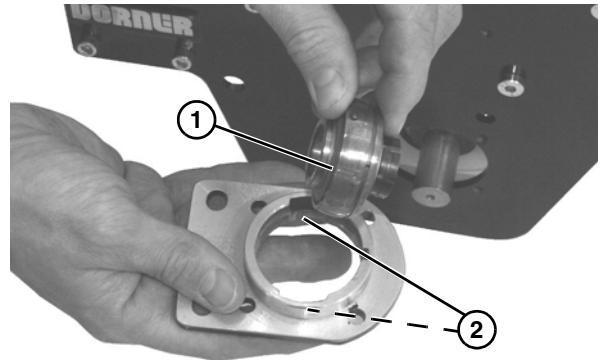


Figure 54

Replacement

1. Inspect bearing housing bearing surface. If worn or damaged, replace. See "Service Parts" on page 20.
2. Insert bearing (**Figure 55, item 1**) into housing slot: Locate anti-rotation nub (**Figure 55, item 2**) to align with slot (**Figure 55, item 3**), and twist bearing into housing.

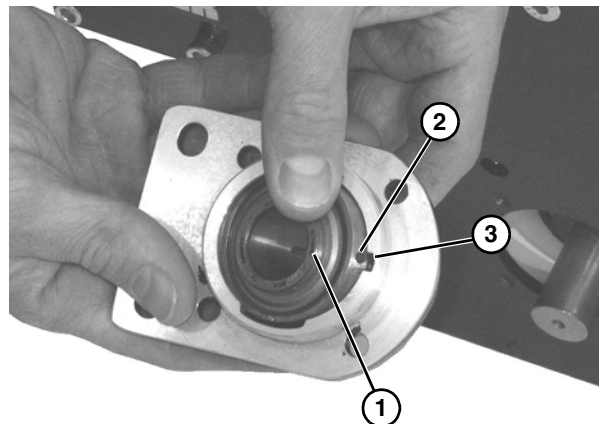



Figure 55

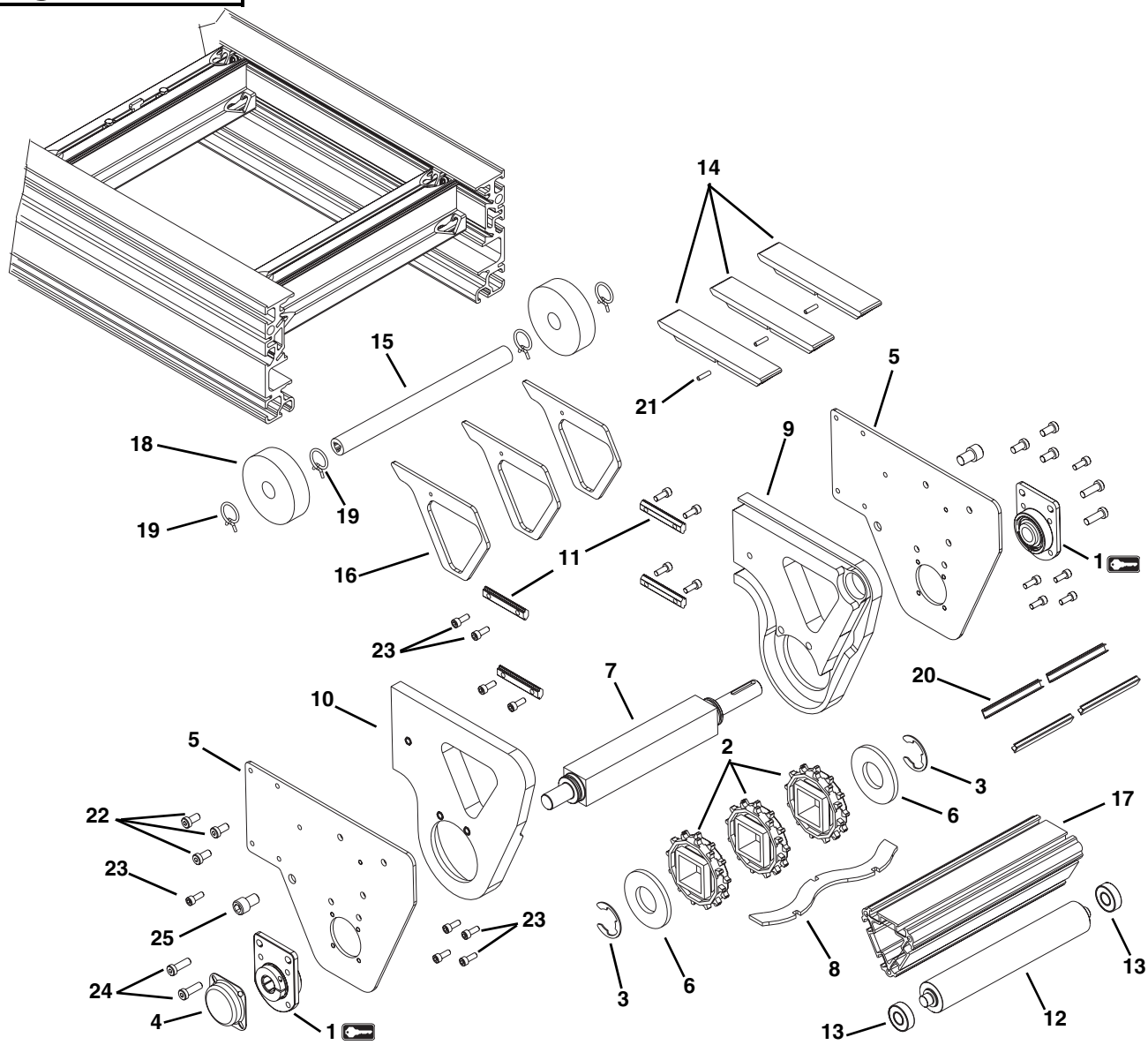
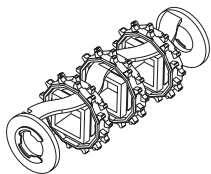
Service Parts

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

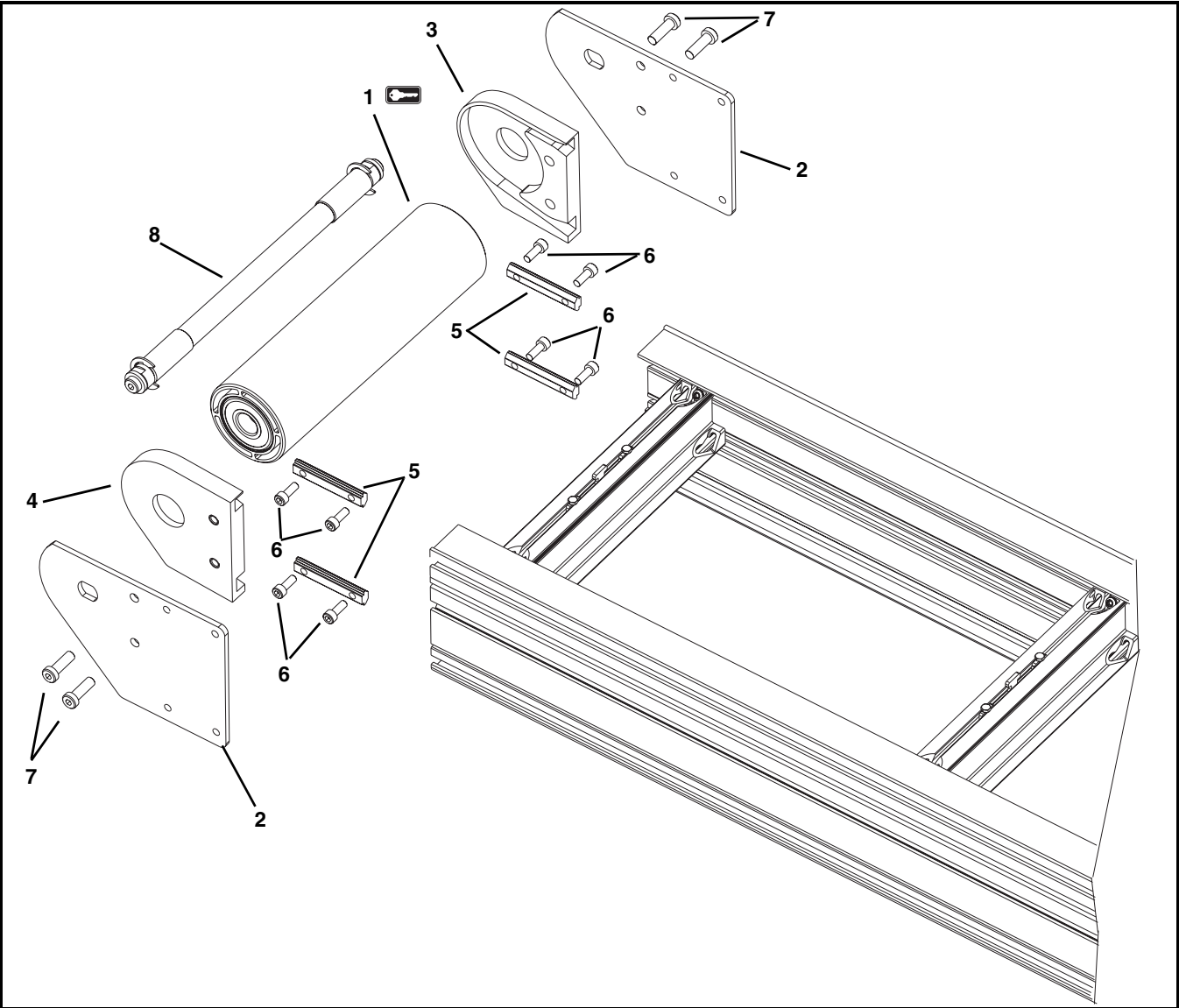
26 Drive Spindle Kit



Item	Part Number	Description
1 	52BKD	Drive Bearing Kit
2	807-1444	Sprocket
3	915-240	Retaining Ring
4	300139	Shaft Cover
5	352248	Tail Plate
6	352111	Sprocket Alignment Retainer Key
7	352212- <u>WW</u>	Drive Spindle
8	352213- <u>WW</u>	Sprocket Alignment Bar
9	352257	Drive Terminal Assembly Left Hand
10	352258	Drive Terminal Assembly Right Hand
11	300150M	Drop-In Tee Bar
12	352252- <u>WW</u>	Spindle, 1-5/8 in.
13	802-124	Bearing (15 mm)
14	352127	Wear Guide
15	352245- <u>WW</u>	Roller Rod
16	352247	Support Plate
17	352250- <u>WW</u>	Crossmember
18	500990	Return Disk
19	807-1151	Clamp
20	352267- <u>WW</u>	Spacer Cover
21	913-405	Pin
22	920893M	Low Head Cap Screw, M8-1.25 x 16 mm
23	920616M	Socket Head Screw, M6-1.00 x 16 mm
24	920895M	Low Head Cap Screw, M8-1.25 x 25 mm
25	921218M	Socket Head Screw, M12-1.75 x 18 mm
26 	52DT- <u>WW</u>	Drive Spindle Kit (Includes Items 2, 3, 6 and 8)
<u>WW</u> = Conveyor width reference: 08 – 60 in 02 increments		

Service Parts

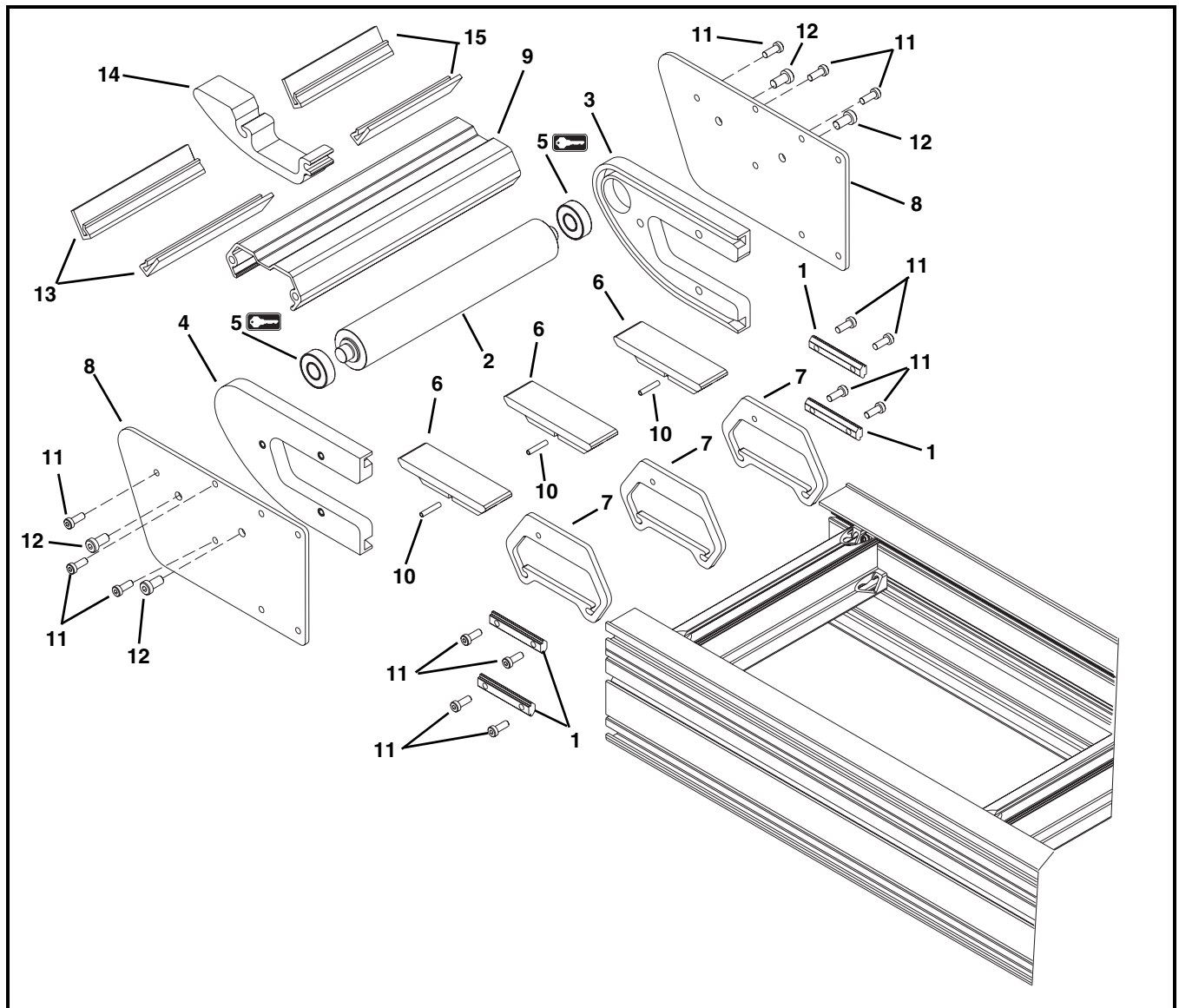
Idler End Components



Item	Part Number	Description
1	352033- <u>WW</u>	Idler Pulley Assembly
2	352110	Cover Plate
3	352223	Idler Terminal Assembly Left Hand
4	352224	Idler Terminal Assembly Right Hand

Item	Part Number	Description
5	300150M	Drop-In Tee Bar
6	920616M	Socket Head Screw, M6-1.00 x 16 mm
7	920895M	Low Head Cap Screw, M8-1.25 x 25 mm
8	352034- <u>WW</u>	Idler Wand Assembly
<u>WW</u> = Conveyor width reference: 08 – 36 in 02 increments		

Nose Bar Idler End Components

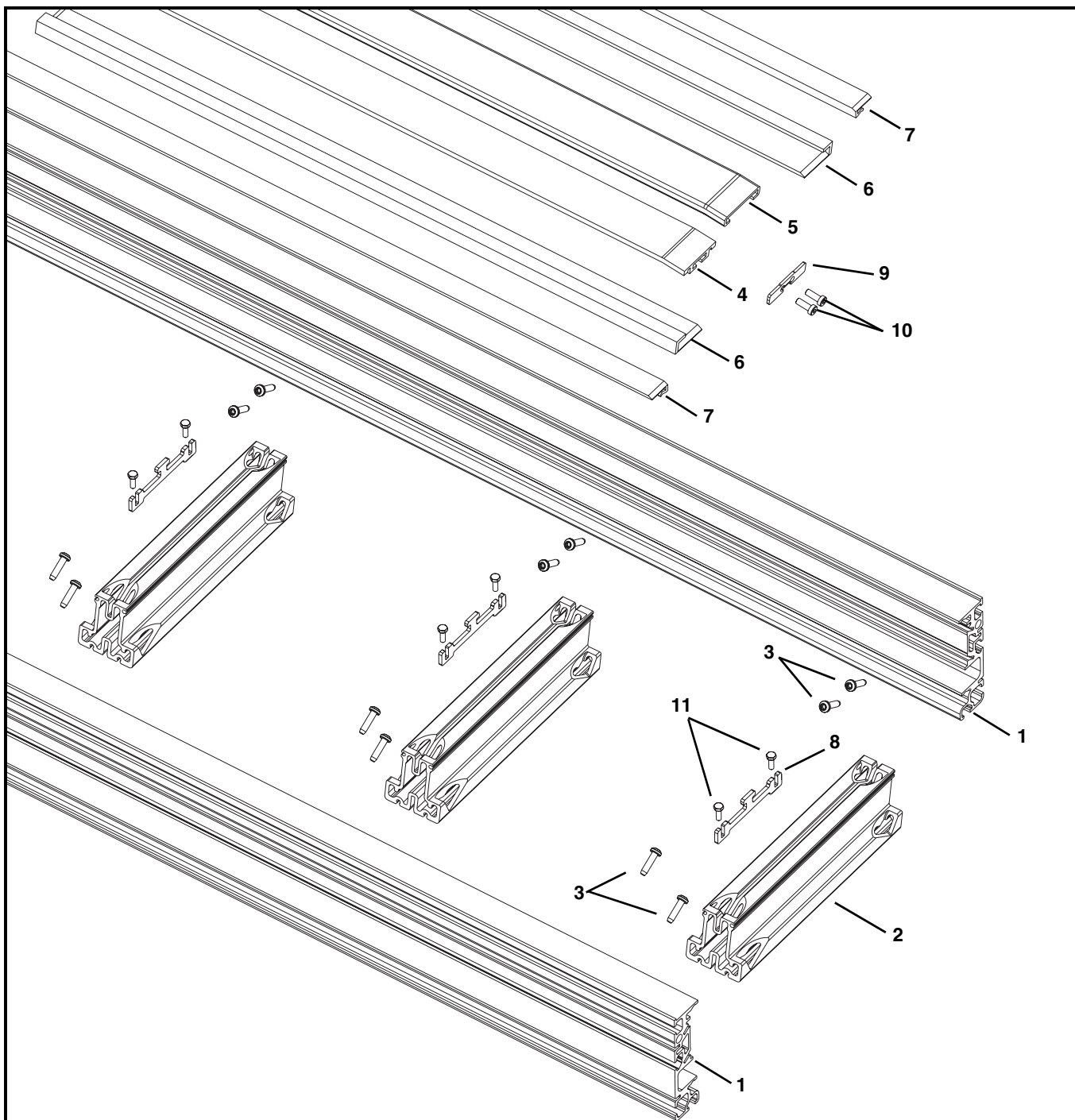


Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	352252- <u>WW</u>	Spindle
3	352259	Nose Bar Terminal Assembly, Left Hand
4	352260	Nose Bar Terminal Assembly, Right Hand
5	52BKNBC	Bearing Kit
6	352128	Wear Guide
7	352246	Support Plate
8	352249	Tail Plate

Item	Part Number	Description
9	352251- <u>WW</u>	Crossmember
10	913-405	Pin
11	920616M	Socket Head Screw, M6-1.00 x 16 mm
12	920893M	Low Head Cap Screw, M8-1.25 x 25 mm
13	352268- <u>WW</u>	Spacer
14	352266	Transfer Shoe
15	352269- <u>WW</u>	Shoe Spacer
<u>WW</u> = Conveyor width reference: 08 – 36 in 02 increments		

Service Parts

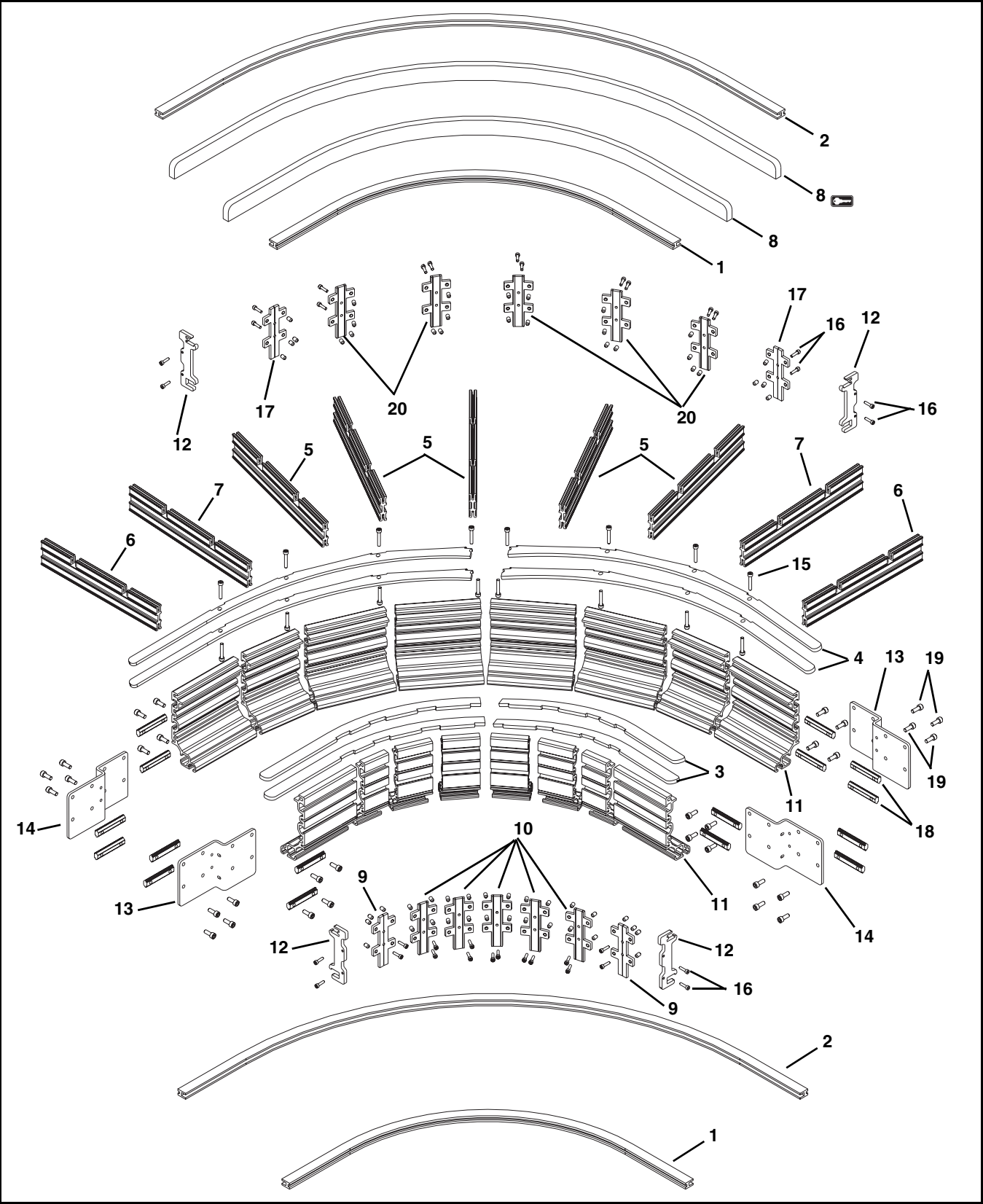
Frame Assembly



Item	Part Number	Description
1	352100- <u>LLLL</u>	Side Rail
2	352201- <u>WW</u>	Cross Support Rail
3	352108	Pan Screw, M5-.80 x 20 mm
4	352102- <u>LLLL</u>	Center Bed Rail
5	352103- <u>LLLL</u>	Center Wearstrip
6	352210- <u>LLLL</u>	Top Wearstrip
7	352105- <u>LLLL</u>	Return Wearstrip
8	352106	Center Bed Rail Hold Down Clip

Item	Part Number	Description
9	352107	Center Wearstrip Stop Plate
10	901-135	Button Head Cap Screw, 1/4-20 x 0.88"
11	960498M	Hex Head Cap Screw, M4-.70 x 12 mm
<u>WW</u> = Conveyor width reference: 08 – 36 in 02 increments		
<u>LLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLL</u> = 09525		

Curve Conveyor Frame and Wear Strips



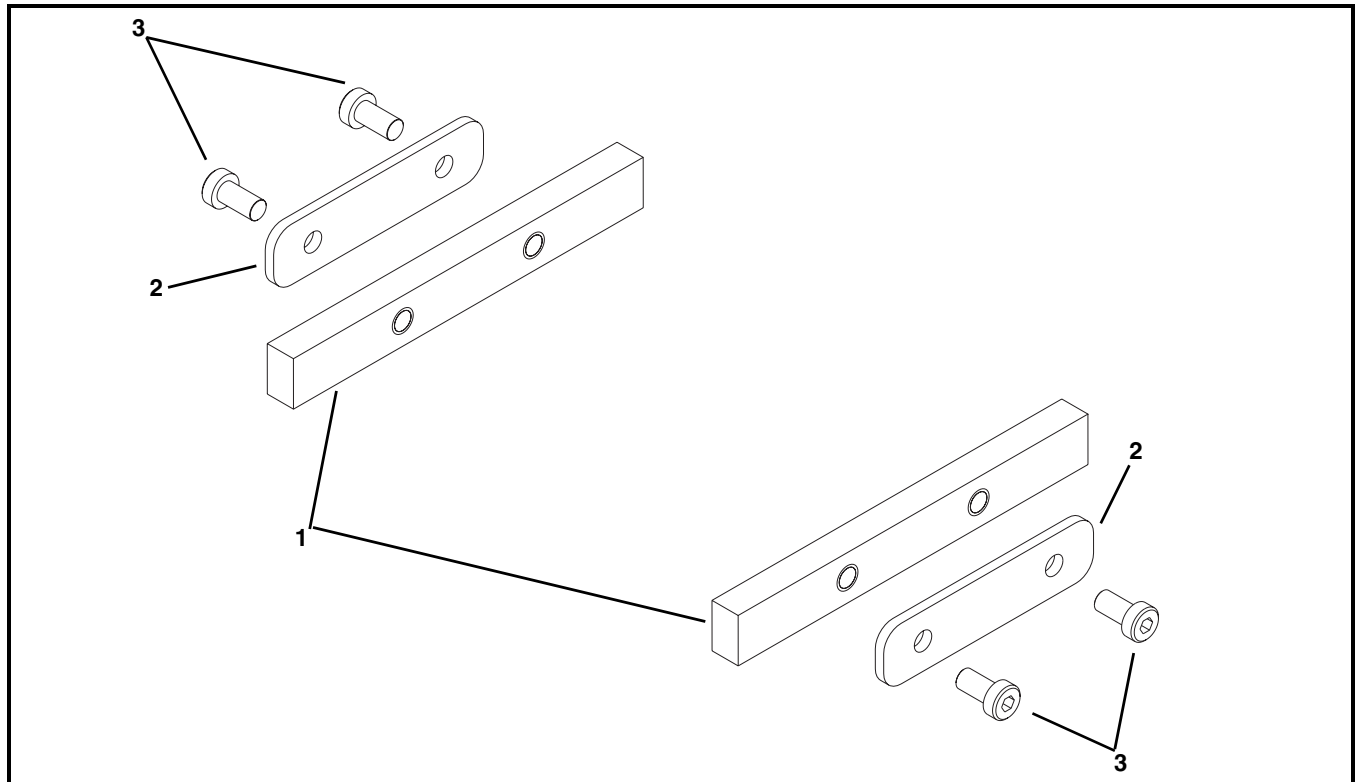
Service Parts

Item	Part Number	Description
1	352203- <u>WW</u> - <u>DDD</u>	Inner Guide
2	352204- <u>WW</u> - <u>DDD</u>	Outer Guide
3	See Chart #3	Inner Spine
4	See Chart #4	Outer Spine
5	352202- <u>WW</u>	Cross Support Rail
6	352207- <u>WW</u>	End Cross Support Rail
7	352209- <u>WW</u>	7.5° Cross Support Rail
8	352208- <u>LLLL</u>	Top Wearstrip
9	352273	7.5° Inner Connecting Plate Assembly
10	352271	15° Inner Connecting Plate Assembly
11	352200- <u>LLLL</u>	Side Rail
12	352226	Guide Alignment Plate
13	352227	Offset Connecting Plate, Right
14	352228	Offset Connecting Plate, Left
15	920530M	Socket Head Screw, M5-.80x30mm
16	920416M	Socket Head Screw, M4-.70x16mm
17	352274	7.5° Outer Connecting Plate Assembly
18	300150M	Drop-In Tee Bar
19	920616M	Socket Head Screw, M6-1x16mm
20	352272	15° Outer Connecting Plate Assembly
<u>WW</u> = Conveyor width reference: 08 – 36 in 02 increments		
<u>DDD</u> = Degree of curve		
Degree Example: Curve = 30° <u>DDD</u> = 030		
<u>LLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLL</u> = 09525		

Chart #3	
Degree	Part Number
15°	352231- <u>WW</u> (x2)
30°	352233- <u>WW</u> (x2)
45°	352235- <u>WW</u> (x2)
60°	352237- <u>WW</u> (x2)
75°	352239- <u>WW</u> & 352237- <u>WW</u>
90°	352239- <u>WW</u> (x2)
105°	352237- <u>WW</u> (x2) & 352243- <u>WW</u>
120°	352239- <u>WW</u> (x2) & 352241- <u>WW</u>
135°	352239- <u>WW</u> (x2) & 352243- <u>WW</u>
150°	352239- <u>WW</u> (x2) & 352241- <u>WW</u> (x2)
165°	352239- <u>WW</u> (x2), 352241- <u>WW</u> & 352243- <u>WW</u>
180°	352239- <u>WW</u> (x2) & 352243- <u>WW</u> (x2)

Chart #4	
Degree	Part Number
15°	352232- <u>WW</u> (x2)
30°	352234- <u>WW</u> (x2)
45°	352236- <u>WW</u> (x2)
60°	352238- <u>WW</u> (x2)
75°	352240- <u>WW</u> & 352238- <u>WW</u>
90°	352240- <u>WW</u> (x2)
105°	352238- <u>WW</u> (x2) & 352244- <u>WW</u>
120°	352240- <u>WW</u> (x2) & 352242- <u>WW</u>
135°	352240- <u>WW</u> (x2) & 352244- <u>WW</u>
150°	352240- <u>WW</u> (x2) & 352242- <u>WW</u> (x2)
165°	352240- <u>WW</u> (x2), 352242- <u>WW</u> & 352244- <u>WW</u>
180°	352240- <u>WW</u> (x2) & 352244- <u>WW</u> (x2)

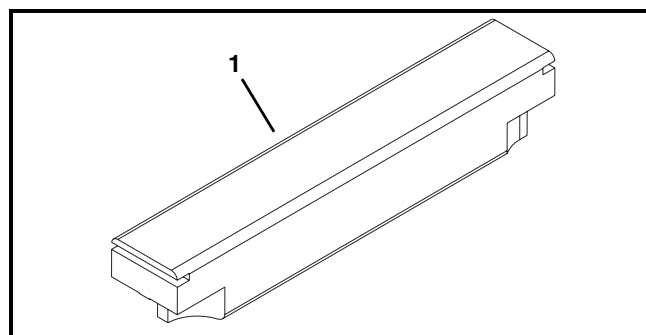
Connecting Assembly



Item	Part Number	Description
1	352315	Bar Frame Connector
2	240859	Plate Frame Connector

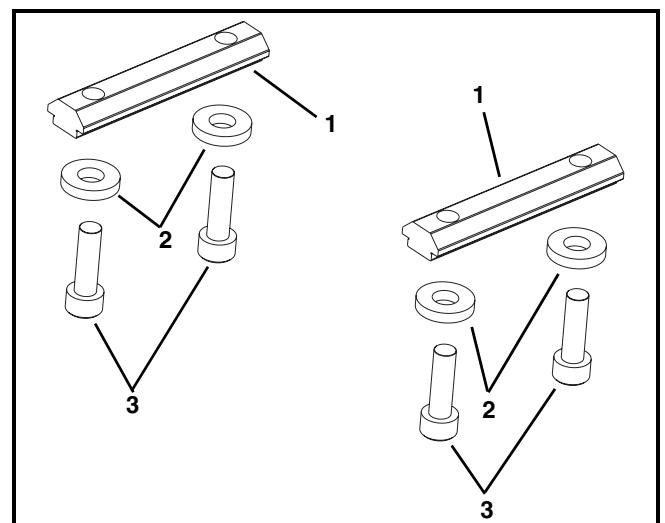
Item	Part Number	Description
3	920692M	Low Head Cap Screw, M6-1.00 x 12 mm

Flat Belt Returns



Item	Part Number	Description
1	352220- <u>WW</u>	Returns - Straight Sections of Conveyor
	352211- <u>WW</u>	Returns - Curved Sections of Conveyor
<u>WW</u> = Conveyor width ref: 18 - 36 in 02 increments		

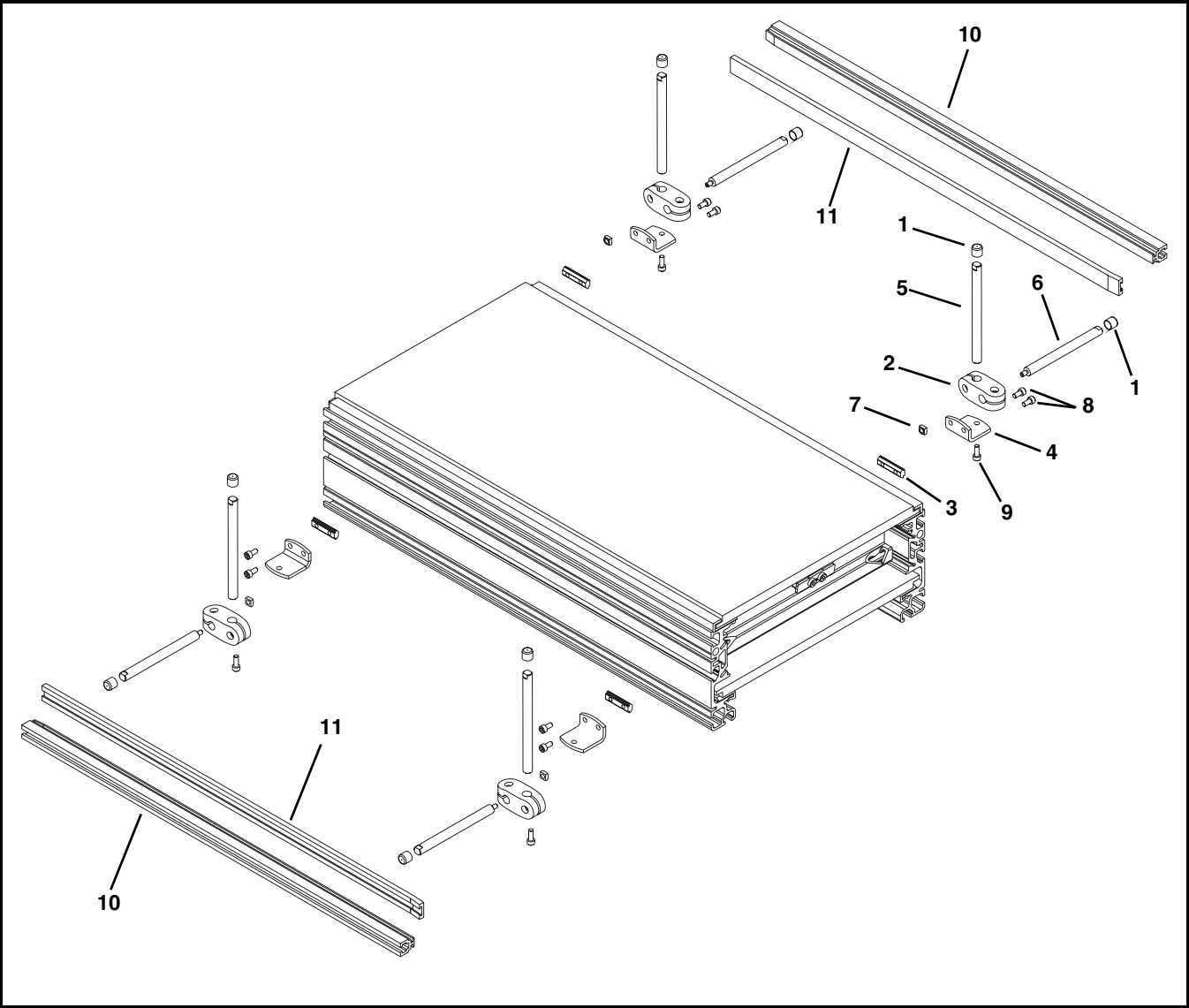
Stand Mount Kit



Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	605279P	Washer
3	920620M	Socket Head Screw, M6-1.00 x 20 mm

Service Parts

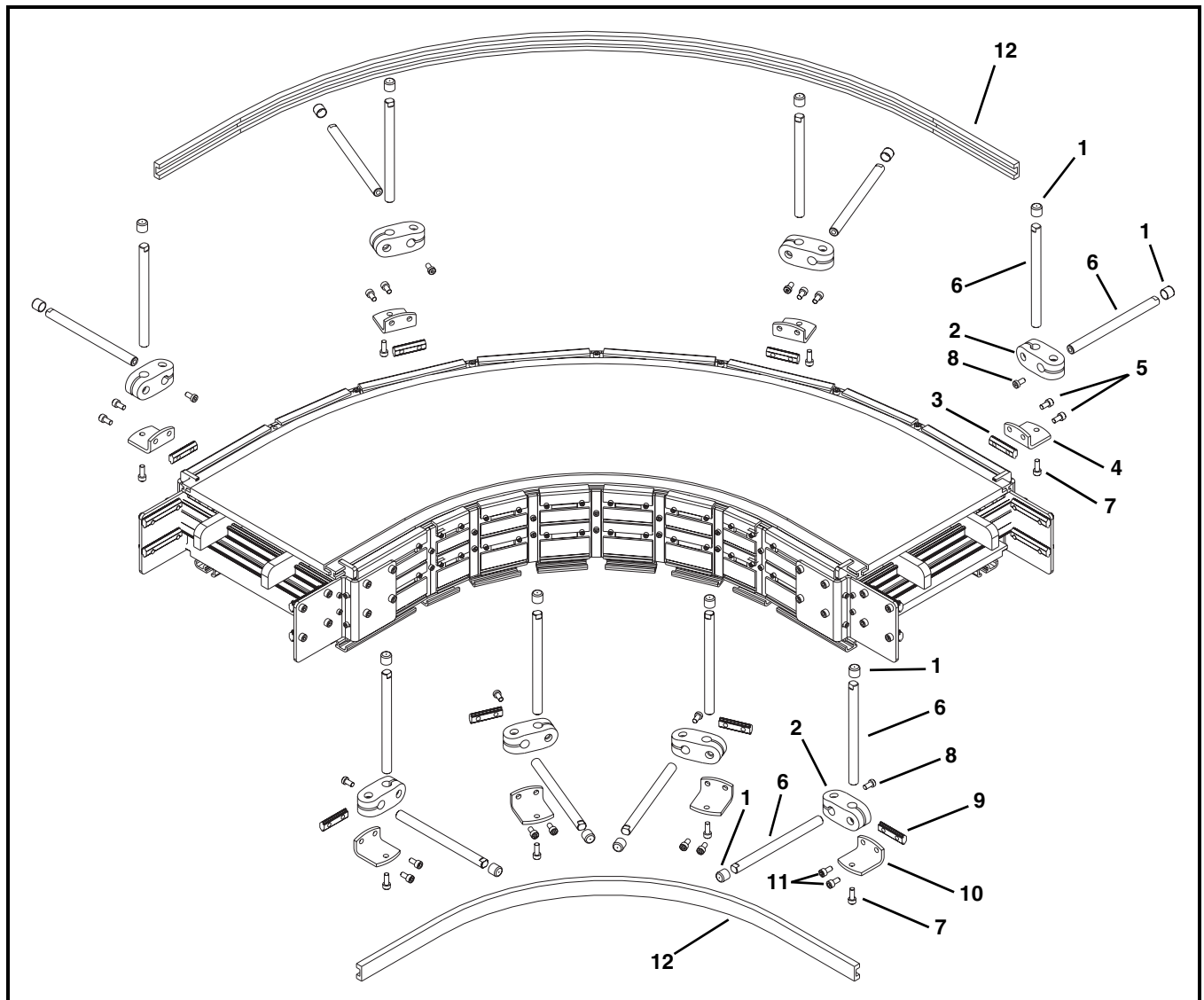
Fully Adjustable Guiding (Straight Module)



Item	Part Number	Description
1	807-948	Shaft Cap
2	807-652	Cross Block
3	200830M	Drop-In Tee Bar
4	202004M	Mounting Bracket
5	202027M	Vertical Mounting Guide Shaft
6	202028M	Horizontal Mounting Guide Shaft

Item	Part Number	Description
7	674175MP	Square Nut, M6-1.00
8	920612M	Socket Head Screw, M6-1.00 x 12 mm
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	381300-LLLLL	Aluminum Profile Guide
11	614068P	Extruded Guide (Per Foot)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Fully Adjustable Guiding (Curve Module)

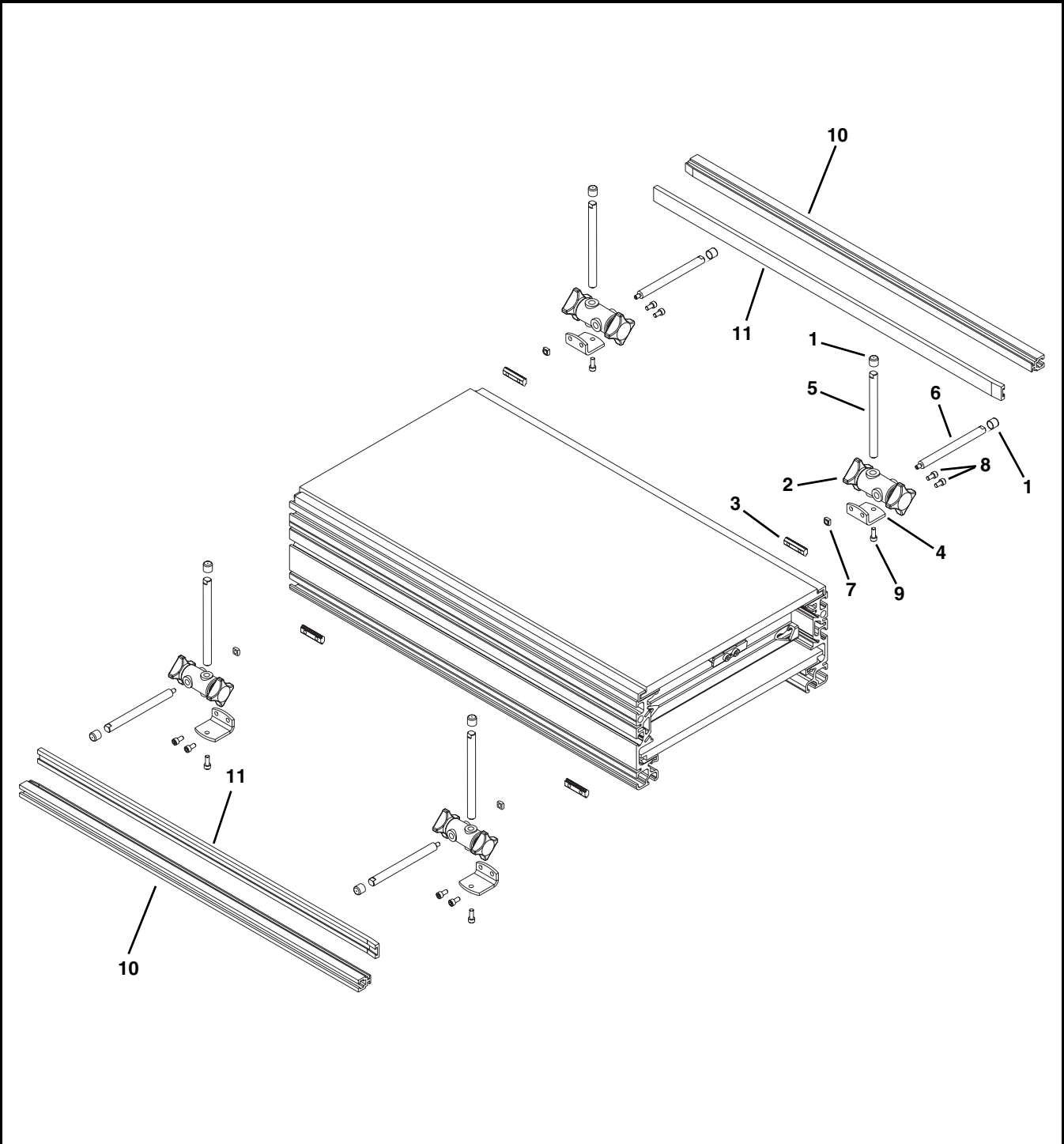


Item	Part Number	Description
1	807-948	Shaft Cap
2	807-652	Cross Block
3	200830M	Drop-In Tee Bar, Outer Curve
4	202004M	Mounting Bracket, Outer Curve
5	920612M	Socket Head Screw, M6-1.00x12 mm
6	202027M	Mounting Guide Shaft
7	920616M	Socket Head Screw, M6-1.00x16 mm
8	920692M	Low Head Cap Screw, M6-1.00x16 mm
9	200830M	Drop-In Tee Bar, Inner Curve (12" through 36" wide)

Item	Part Number	Description
10	325303	Mounting Bracket, Inner Curve (8" and 10" wide)
	202004M	Mounting Bracket, Inner Curve (12" through 36" wide)
11	920512M	Socket Head Screw, M5-.80x12 mm for inner curve (8" and 10" wide)
	920616M	Socket Head Screw, M6-1.00x12 mm for inner curve (12" through 36" wide)
12	234014	U-Channel Guide, 4' Long

Service Parts

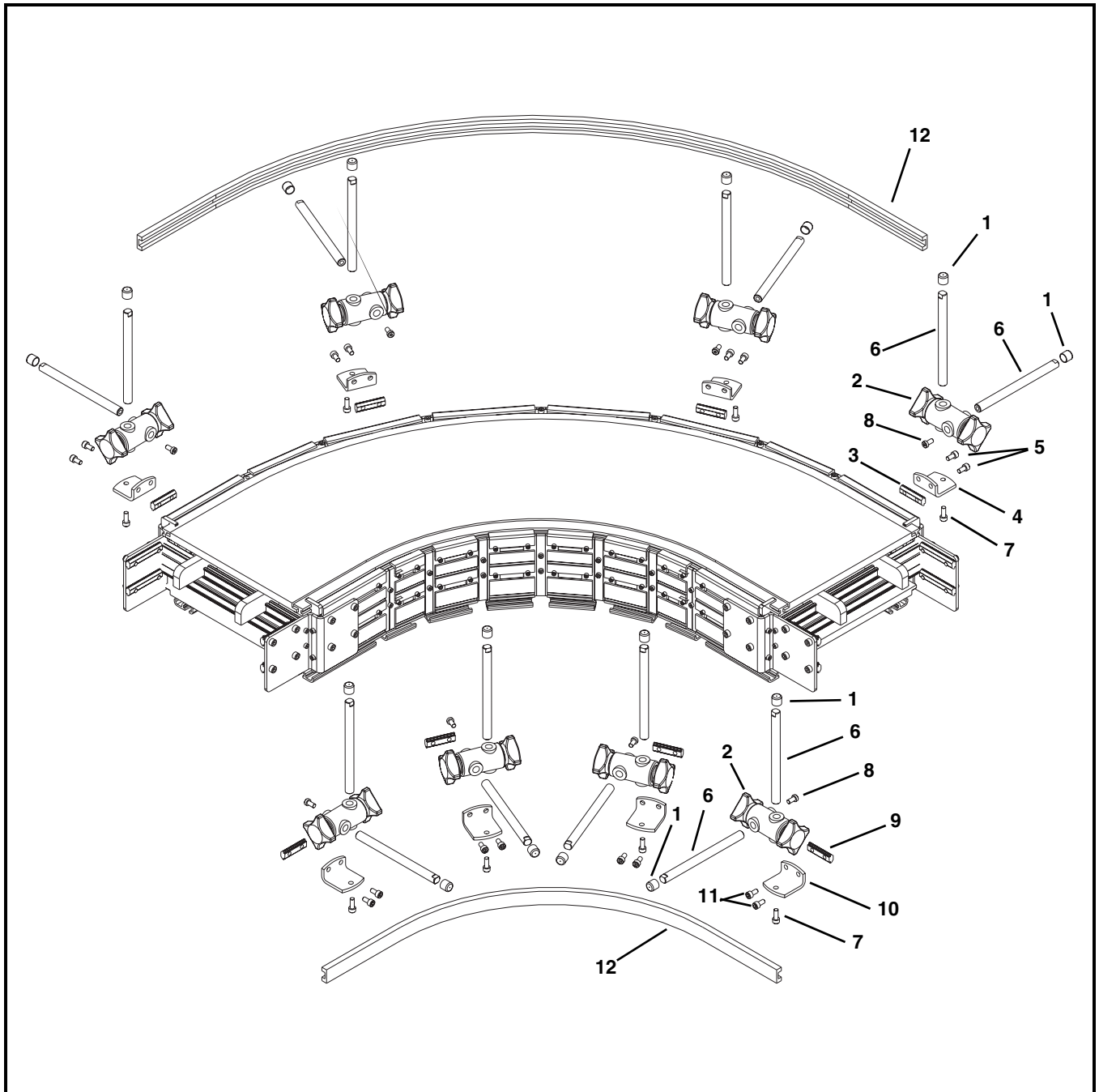
Tool-Less Fully Adjustable Guiding (Straight Module)



Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	200830M	Drop-In Tee Bar
4	202004M	Mounting Bracket
5	202027M	Vertical Mounting Guide Shaft
6	202028M	Horizontal Mounting Guide Shaft
7	674175MP	Square Nut, M6-1.00

Item	Part Number	Description
8	920612M	Socket Head Screw, M6-1.00 x 12 mm
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	381400-LLLLL	Aluminum Profile Guide
11	614068P	Extruded Guide (Per Foot)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Fully Adjustable Guiding (Curve Module)



Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	200830M	Drop-In Tee Bar, Outer Curve
4	202004M	Mounting Bracket, Outer Curve
5	920612M	Socket Head Screw, M6-1.00x12 mm
6	202027M	Mounting Guide Shaft
7	920616M	Socket Head Screw, M6-1.00x16 mm
8	920692M	Low Head Cap Screw, M6-1.00x16 mm
9	200830M	Drop-In Tee Bar, Inner Curve (12" through 36" wide)

Item	Part Number	Description
10	325303	Mounting Bracket, Inner Curve (8" and 10" wide)
	202004M	Mounting Bracket, Inner Curve (12" through 36" wide)
11	920512M	Socket Head Screw, M5-.80x12 mm for inner curve (8" and 10" wide)
	920616M	Socket Head Screw, M6-1.00x12 mm for inner curve (12" through 36" wide)
12	234014	U-Channel Guide, 4' Long

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:

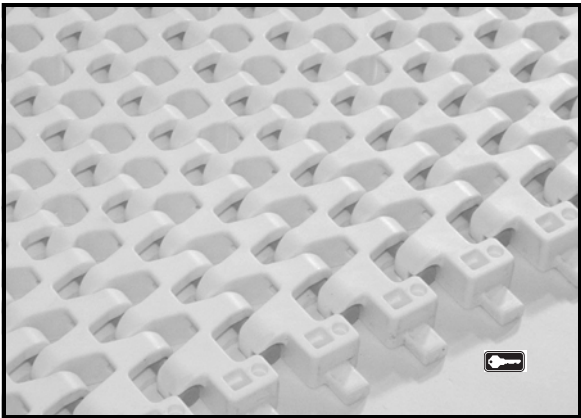
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 52MT-WW

MT = Chain reference number

WW = Conveyor width ref: 08-36 in 02 increments

Flat Belt Chain Repair Kit



Item	Part Number	Description
1	52MT- <u>WW</u>	Flat Belt Chain Repair kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
<u>WW</u> = Conveyor width ref: 08 - 36 in 02 increments		

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.

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization number for reference.

There will be a return charge on all new undamaged items returned for credit where Dorner was not at fault. Dorner is not responsible for return freight on such items.

Conveyors and conveyor accessories

Standard catalog conveyors	30%
MPB Series, cleated and specialty belt conveyors	50%
7400 & 7600 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%
MPB, 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 Technical Sales, Catalog Sales and 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. 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. 2008

DORNER MFG. CORP.

975 Cottonwood Ave., PO Box 20
Hartland, WI 53029-0020 USA
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