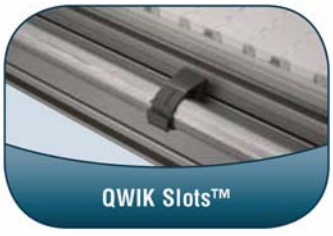
5200 Series End Drive Conveyors

Installation, Maintenance and Parts Manual

Featuring: QwikSlot™ Attachment Method



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

851-629 Rev. C

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 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 .

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

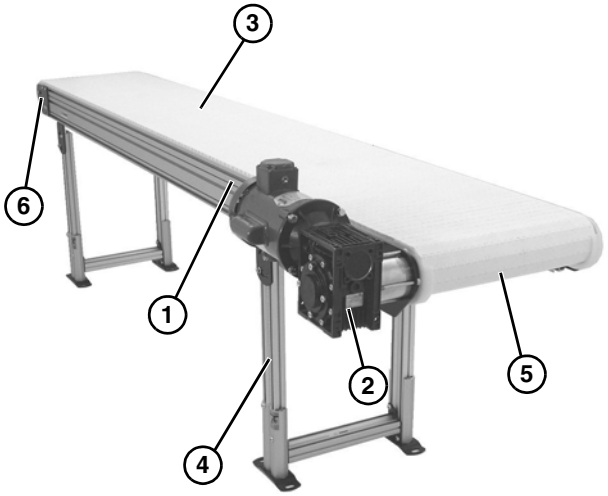
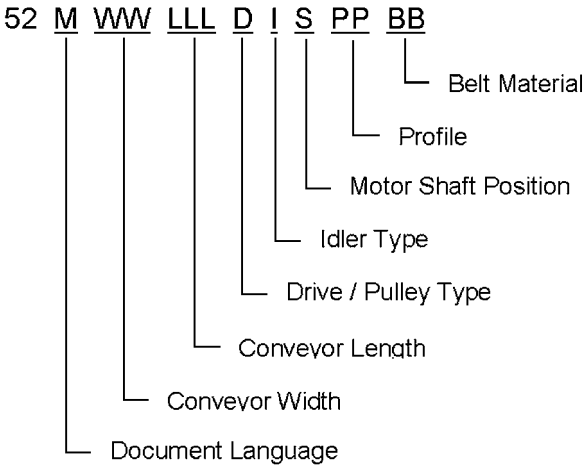


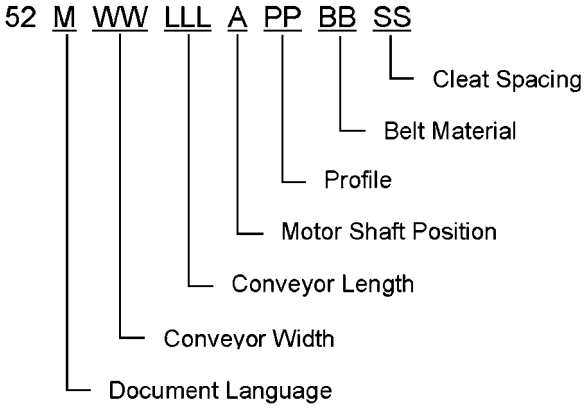
Figure 1

Specifications

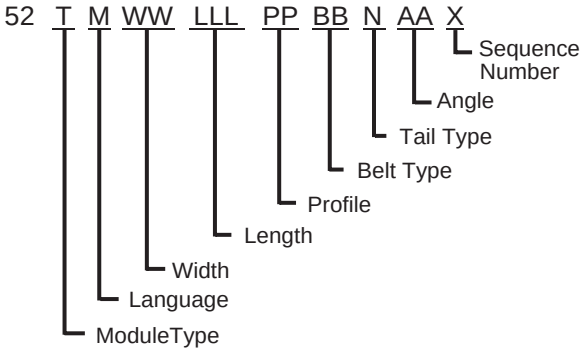
Flat Belt Straight 5200 Series Conveyor



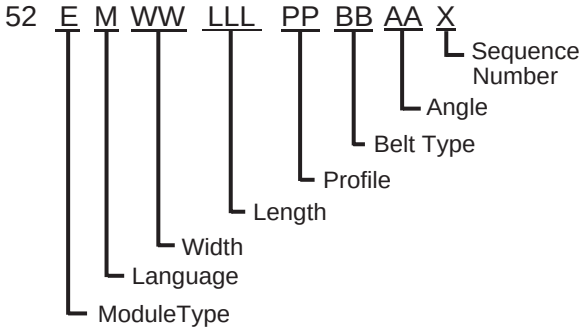
Cleated Belt Straight 5200 Series Conveyor



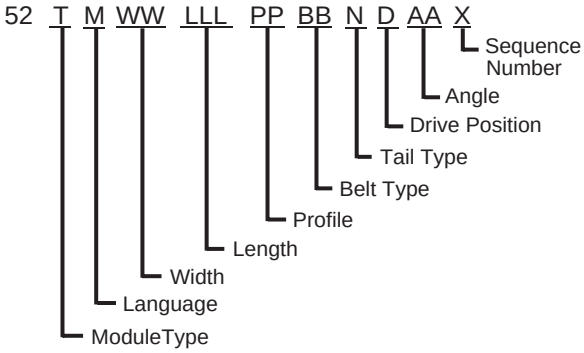
Flat Belt LPZ 5200 Series Conveyor (Infeed Section to Knuckle)



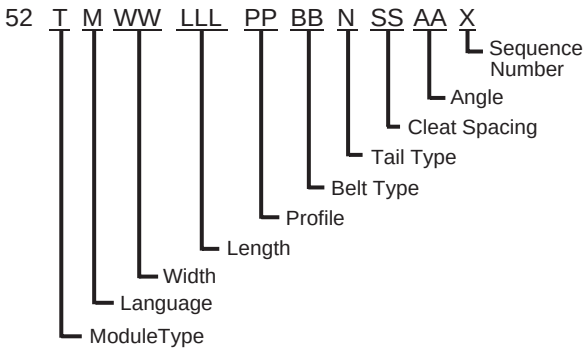
Flat Belt LPZ 5200 Series Conveyor (Mid Section Between Knuckles)



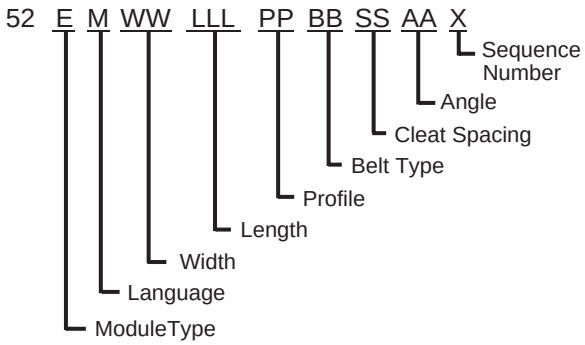
Flat Belt LPZ 5200 Series Conveyor (Discharge Section to Knuckle)



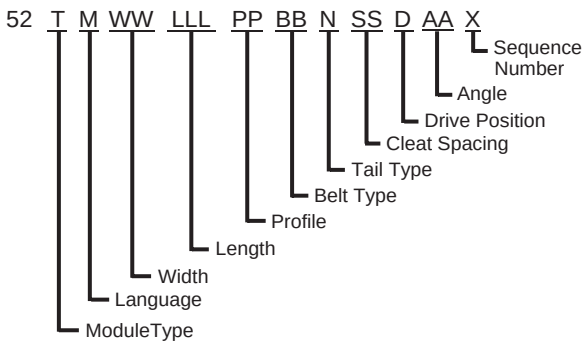
Cleated Belt LPZ 5200 Series Conveyor (Infeed Section to Knuckle)



Cleated Belt LPZ 5200 Series Conveyor (Mid Section Between Knuckles)



Cleated Belt LPZ 5200 Series Conveyor (Discharge Section to Knuckle)



Specifications

Conveyor Supports

Maximum Distances:

1 = Support Stand on Idler End = 3 ft (914 mm)

2 = Between Support Stands = 12 ft (3658 mm)**

3 = Support Stand on Drive End = 3 ft (914 mm)

** For conveyors longer than 12 ft (3658 mm), install stand mount kit at frame joint.

* LPZ stand positions may vary, please consult factory.

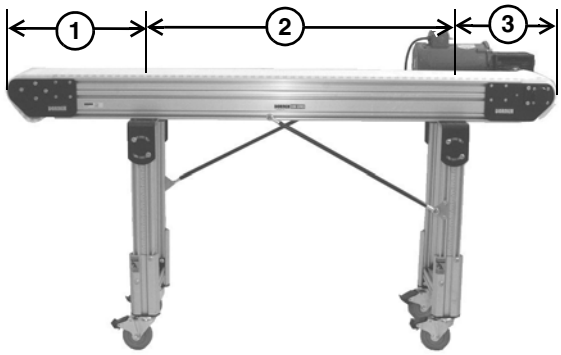


Figure 2

Specifications

Conveyor Width Reference (WW)	08 - 60 in 02 increments
Conveyor Belt Width	8" (203 mm) - 60" (1524 mm) in 2" (51 mm) increments
LPZ Conveyor Width Reference (WW)	08 - 24 in 02 increments
LPZ Conveyor Belt Width	8” (103 mm) - 24” (610 mm) in 2” (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft^2 (97 kg/ m^2) with a maximum of 1000 lbs. (454 kg)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	250 ft/minute (76 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
LPZ Section Length (LLL)	024 - 288 in 001 increments
LPZ Section Length	24” (610 mm) - 288” (7315 mm) 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*

CAUTION

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

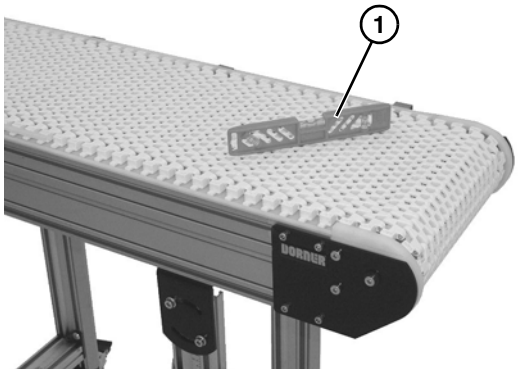


Figure 3

Required Tools

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

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to "Conveyor Sections Longer than 12 ft (3658 mm)" on page 7, "All Conveyors" on page 9, or Refer to "LPZ Conveyors" on page 8.
2. Attach the stands. Refer to "Stand Installation" on page 9.
3. Install the gearmotor. Refer to "Drive Package Installation" on page 10.

Conveyor Sections Longer than 12 ft (3658 mm)

Connecting Components

Typical Connecting Components **(Figure 4)**

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

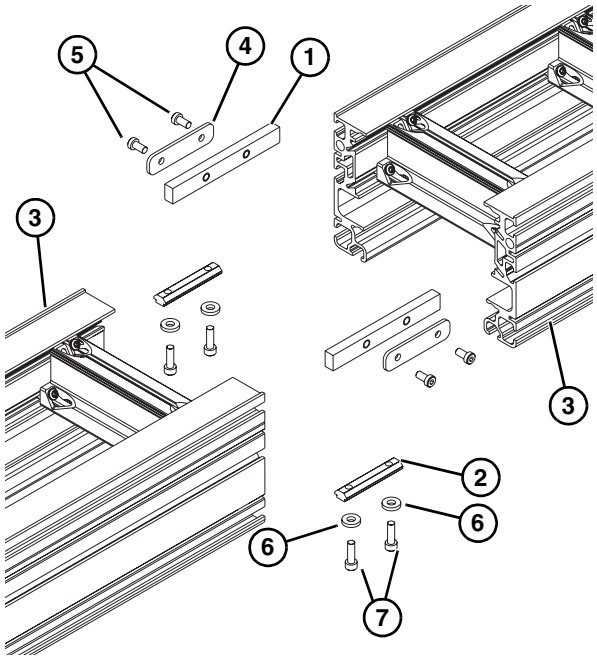


Figure 4

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

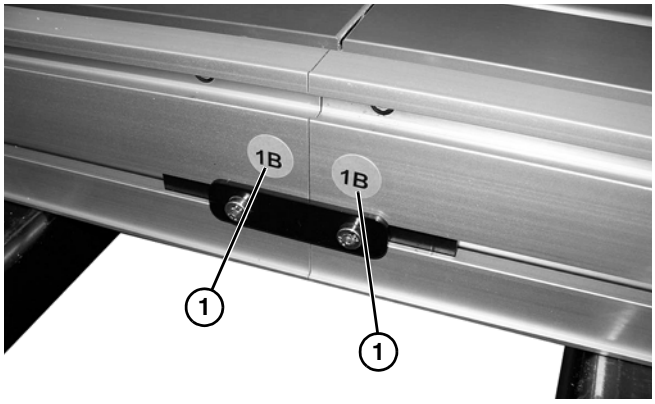


Figure 5

2. Install two bar frame connectors **(Figure 4, item 1)** and two drop-in tee bars **(Figure 4, item 2)** into one conveyor section **(Figure 4, item 3)**.
3. Join both conveyor sections, and install plate frame connectors **(Figure 4, item 4)**, and secure with M6x12 low head cap screws **(Figure 4, item 5)** on both sides. Tighten cap screws to 60 in-lb (7 Nm).
4. Install washers **(Figure 4, item 6)** and M6x20 socket head screws **(Figure 4, item 7)** into drop-in tee bar **(Figure 4, 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.*

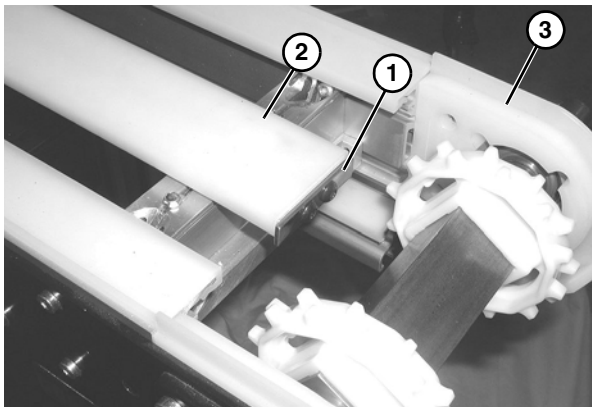


Figure 6

LPZ Conveyors

NOTE

Be sure all frame sections are properly supported during LPZ assembly.

Knuckles

1. Attach upper knuckle to frame by loosening two socket head cap screws **(Figure 7, item 1)** on each side of upper knuckle assembly **(Figure 7, item 2)**, and sliding T-Nuts into straight frame section **(Figure 7, item 3)**.

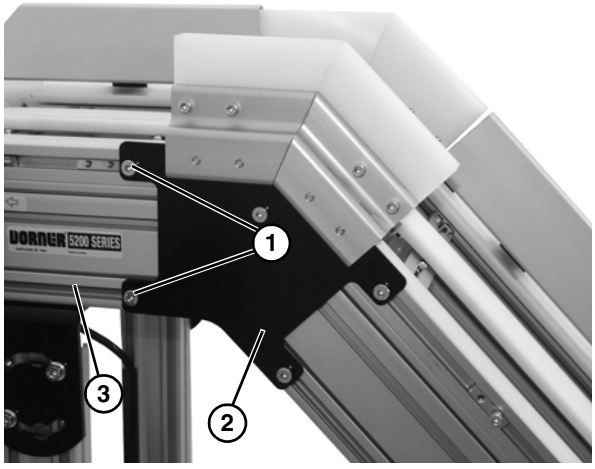


Figure 7

2. Attach lower knuckle to frame by loosening two socket head cap screws **(Figure 8, item 1)** on each side of lower knuckle assembly **(Figure 8, item 2)**, and sliding T-Nuts into straight frame section **(Figure 8, item 3)**.

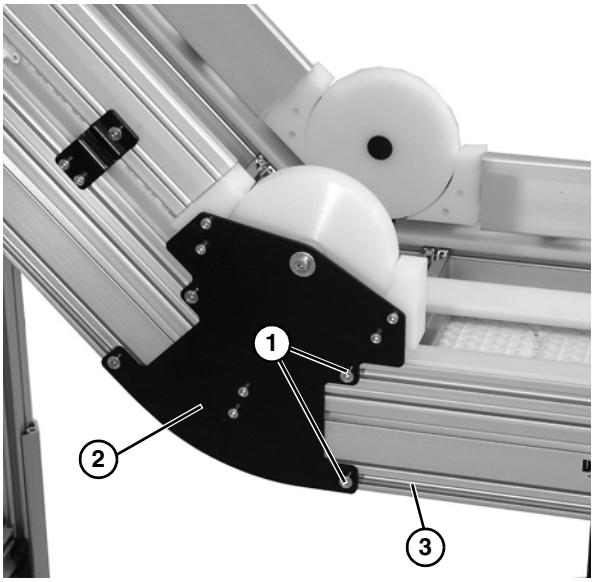


Figure 8

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

All Conveyors

Stand Installation

NOTE

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

Typical stand components **(Figure 9)**

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

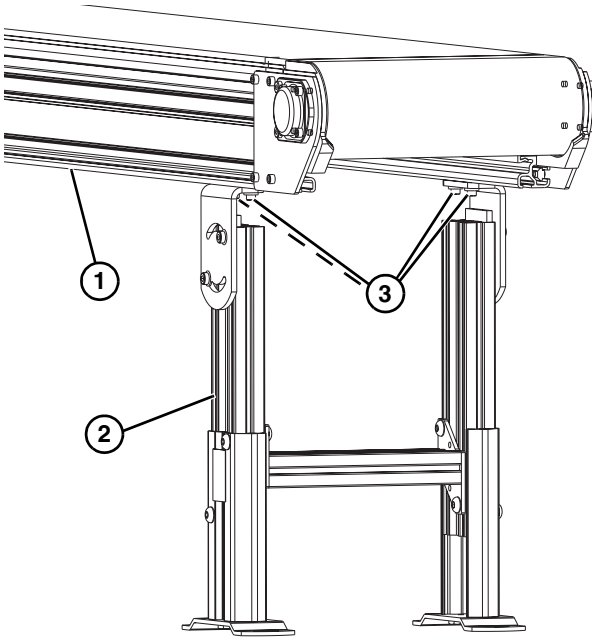


Figure 9

1. Properly support the conveyor.
2. Attach stands **(Figure 10, item 1)** to the bottom of the conveyor frame **(Figure 10, item 2)**. Tighten socket head screws **(Figure 10, item 3)**, on each side, to secure in place.

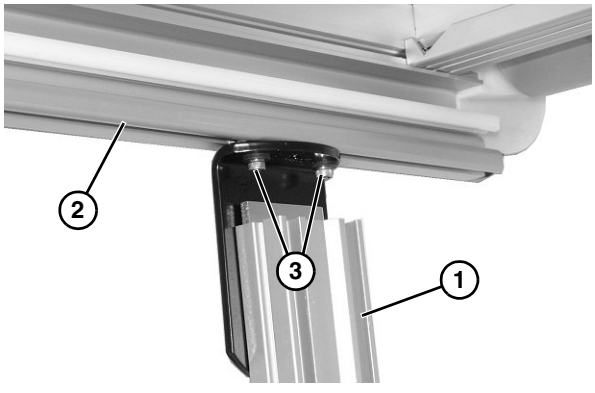


Figure 10

Belt Installation

Typical Belt Components **(Figure 11)**

1	Chain Belt
2	Belt Rod

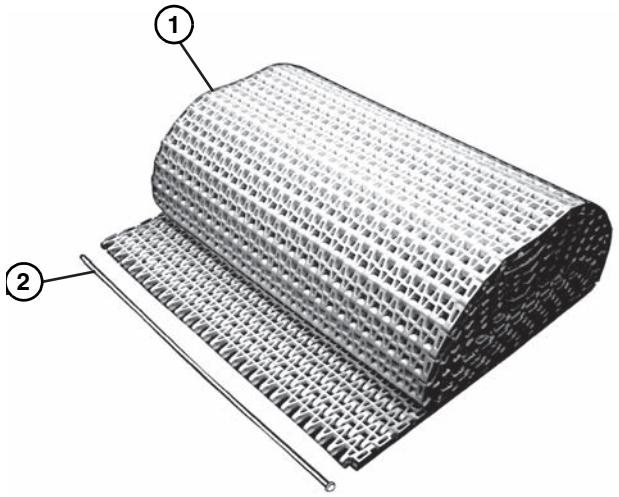


Figure 11

1. Position the belt on the conveyor frame **(Figure 12)**.

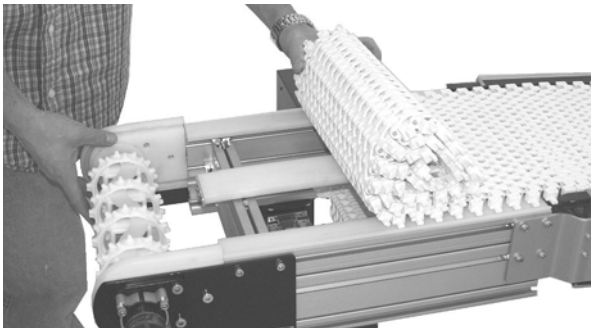


Figure 12

2. Wrap belt around idler tail.
3. Install belt around lower frame section and above lower wear strips **(Figure 13, item 1)**.

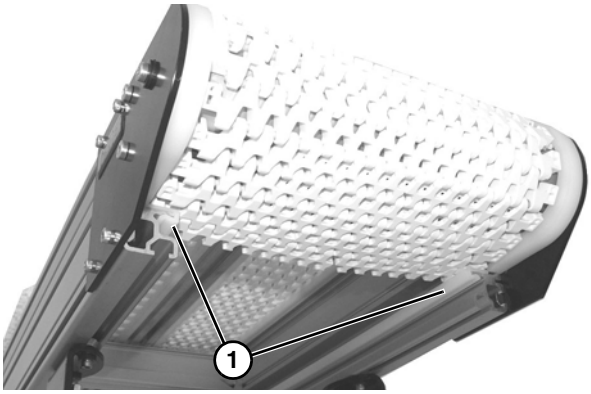


Figure 13

4. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth **(Figure 14, item 1)** mating with rounded section **(Figure 14, item 2)** of belt.

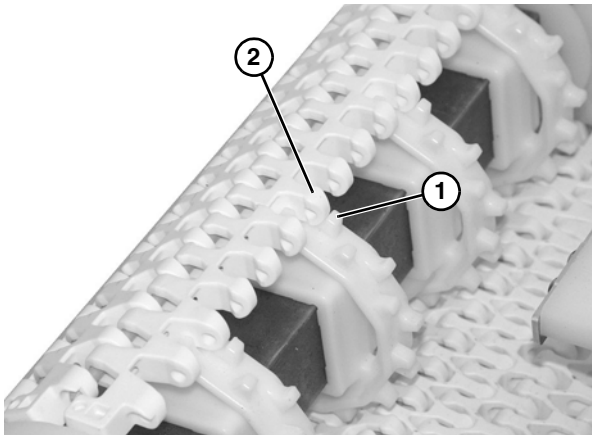


Figure 14

5. Bring the ends of the belt together **(Figure 15)**.

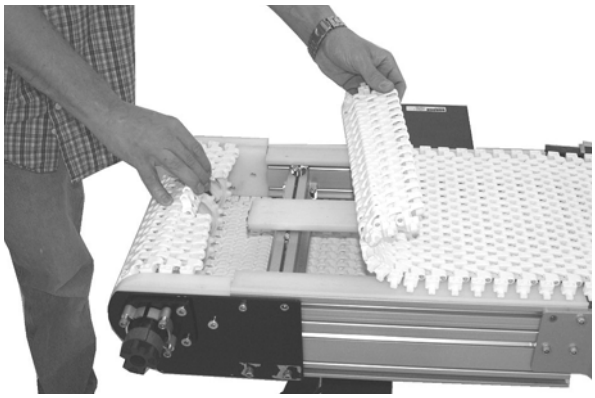


Figure 15

6. Insert the belt rod **(Figure 16, item 1)**.

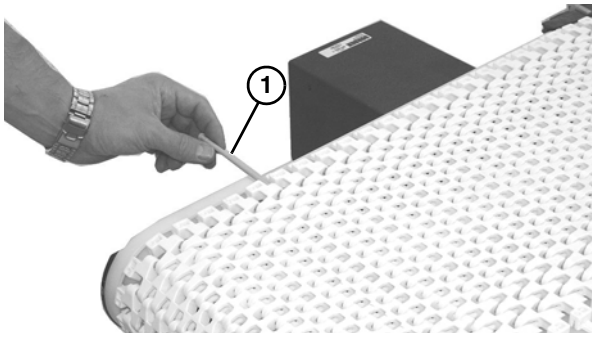


Figure 16

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

Drive Package Installation

NOTE

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

1. Attach the motor **(Figure 17, item 1)** to the gear reducer **(Figure 17, item 2)**.

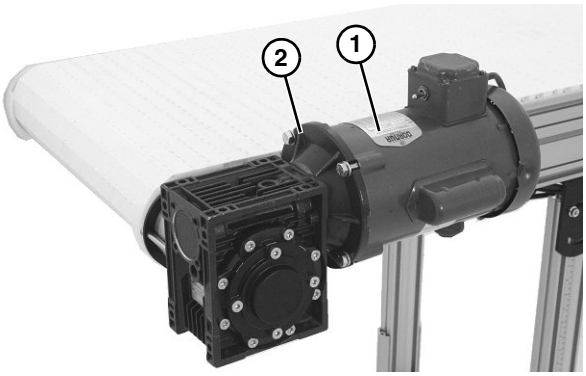


Figure 17

Attachment of Accessories to the QwikSlot™

⚠ WARNING

CRUSH HAZARD!

- **DO NOT ATTACH CONVEYOR SUPPORTS OR STRUCTORAL OR HEAVY COMPONENTS TO THE QWIKSLOT COMPONENTS OR CONVEYOR MAY FALL.**
- **Failure to comply could result in serious injury.**

NOTE

The QwikSlot is an attachment method for quickly attaching devices such as cable ties, conduit mounts, air lines, small junction boxes, etc. to the conveyor side frame. This greatly reduces the time to install a conveyor system.

1. Locate the appropriate fastener for attachment. The QwikSlot will accept #8-32 or M4-0.7 standard fasteners. The maximum depth of engagement is 0.25 inches.
2. Locate the QwikSlot. The Dorner 5200 series conveyor has (2) QwikSlot locations **(Figure 18)**.

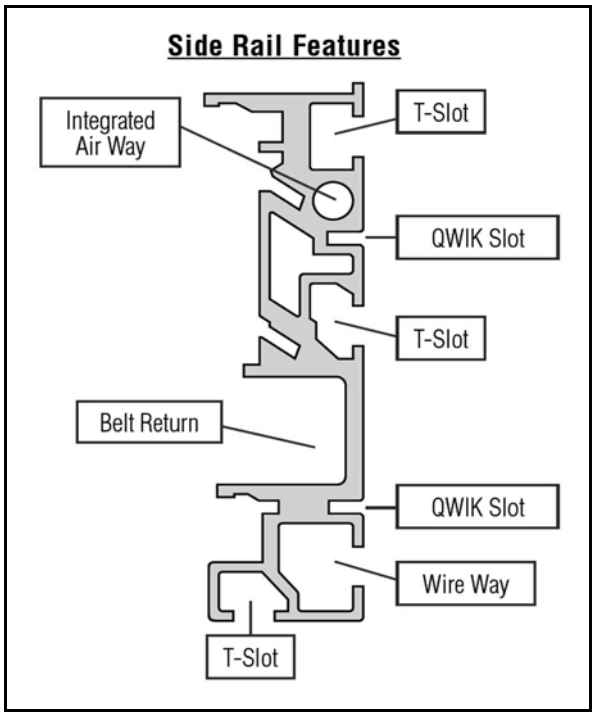


Figure 18

3. With a cordless drill or equivalent, insert the fastener and accessory device into the QwikSlot. Figure 19 shows a wire tie clamp example. Figure 20 shows an air line fitting example.

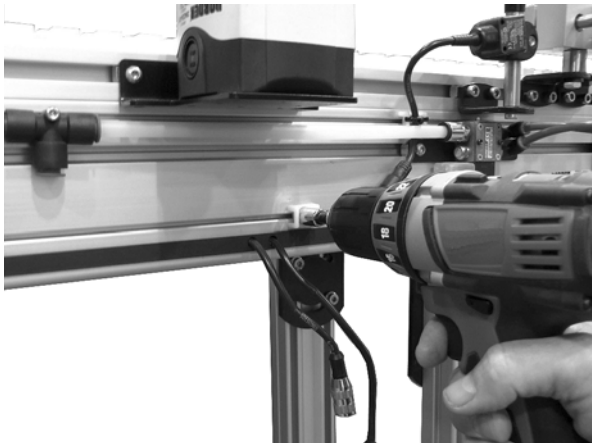


Figure 19

Figure 20

4. Confirm that the fastener is snug by hand tightening **(Figure 21**). Do not exceed 50 in.lb (6 Nm).

Figure 21

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 21 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 22, 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.

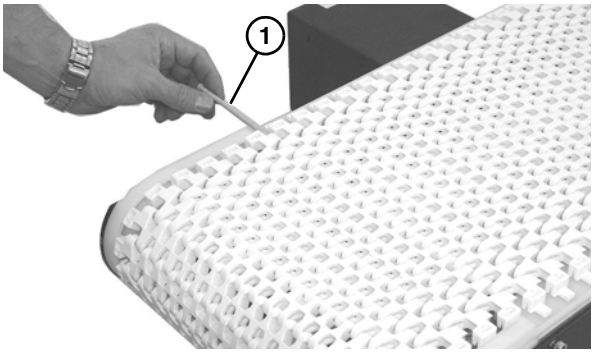


Figure 22

3. Replace old section of belt.

CAUTION

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

Replacing the Entire Belt

1. Use a punch and hammer to push the belt rod **(Figure 23, item 1)** out by striking the rod end opposite the retaining head.

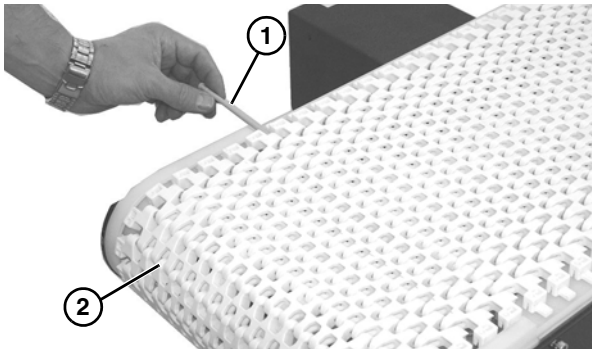


Figure 23

2. Slide the old belt **(Figure 23, item 2)** off the conveyor frame.
3. Replace the old belt with a new one. Refer to “Belt Installation” on page 9.

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 12.

Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips **(Figure 24)**

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

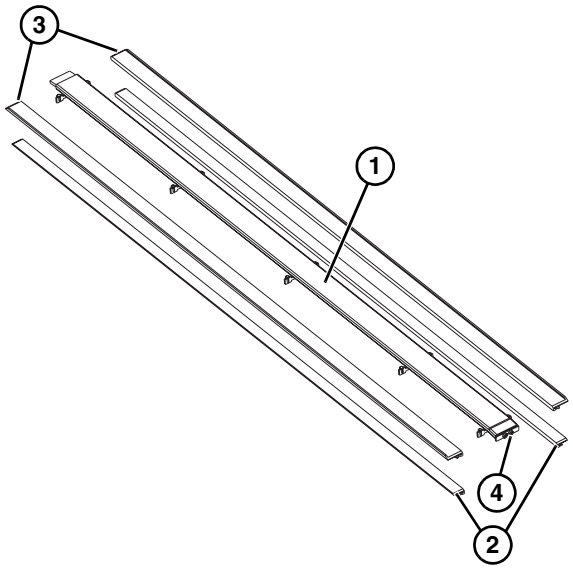


Figure 24

Removal

1. Remove upper wear strips **(Figure 25, item 1)** from top of frame assembly.

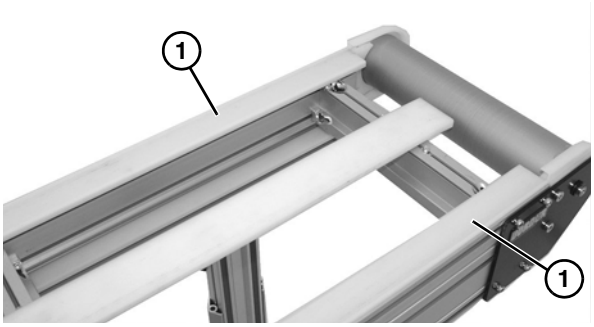


Figure 25

2. Remove lower wear strips **(Figure 26, item 1)**, and if necessary, lower belt return **(Figure 26, item 2)** from lower frame assembly.

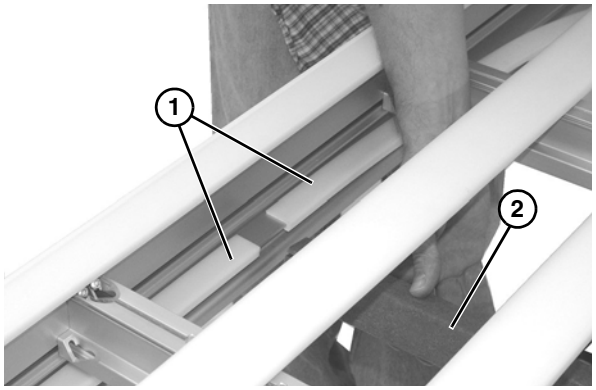


Figure 26

3. Remove two screws **(Figure 27, item 1)** from each clamp on center frame channel.

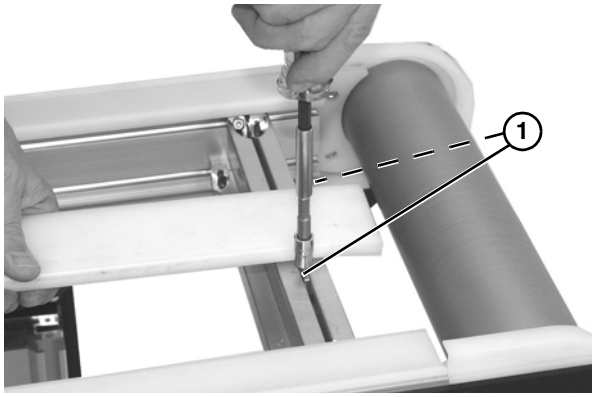


Figure 27

4. Remove center frame channel **(Figure 28, item 1)**, making sure to keep each clamp matched with channel of each cross member **(Figure 28, item 2)**.

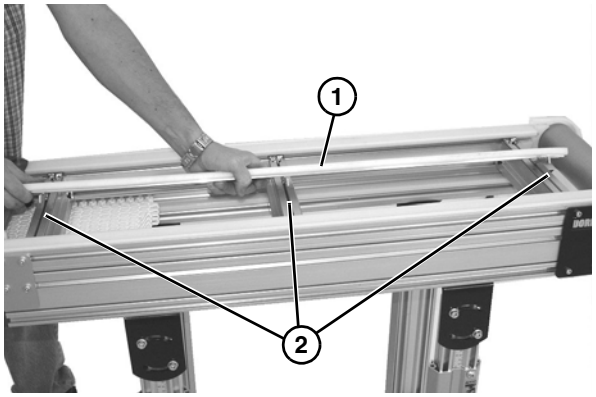


Figure 28

5. Remove the center wear strip **(Figure 29, item 1)** from the center frame channel **(Figure 29, item 2)**.

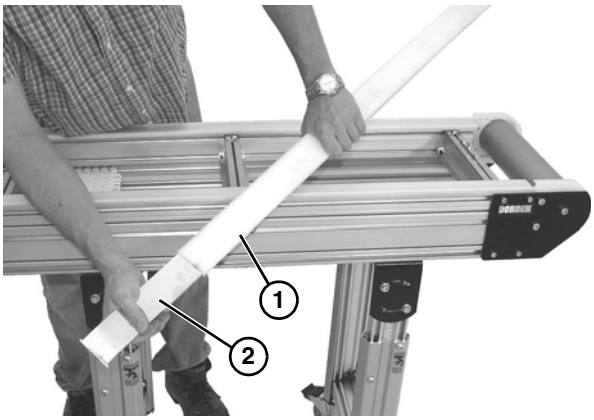


Figure 29

Installation

NOTE
*The stop plate **(Figure 30, item 1)** on the center wear strip **(Figure 30, item 2)** faces the drive end **(Figure 30, item 3)** of the conveyor.*

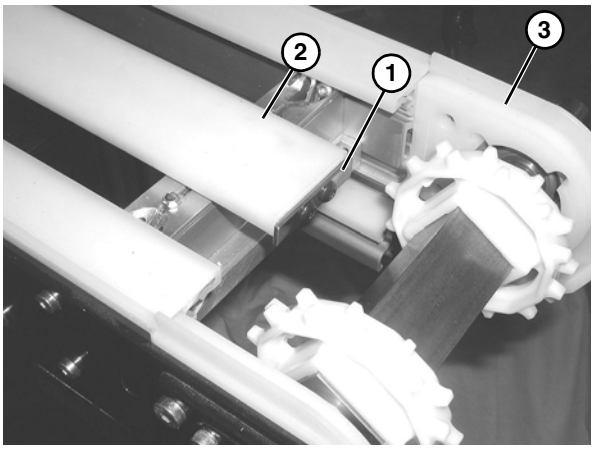


Figure 30

Install components reverse of removal.

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 13. Remove the desired spindle following the corresponding instructions below:

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

A – 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. Loosen the four socket head screws **(Figure 31, item 1)**. Repeat on opposite side.

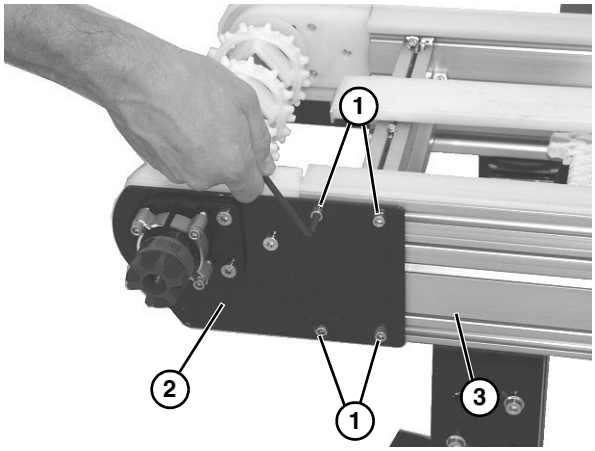


Figure 31

3. Remove the drive tail assembly **(Figure 31, item 2)** from the frame **(Figure 31, item 3)**.
4. Loosen set screw **(Figure 32, item 1)** and remove coupling **(Figure 32, item 2)**.

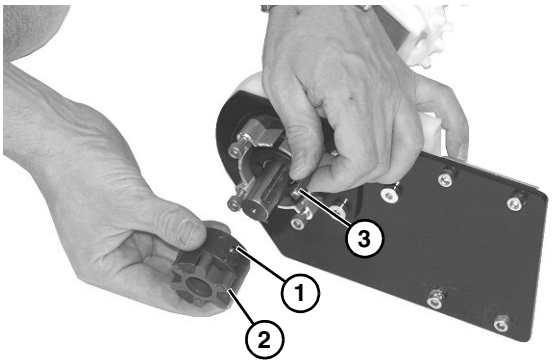


Figure 32

5. Remove key **(Figure 32, item 3)**.
6. Remove four socket head screws **(Figure 33, item 1)** and drive guards **(Figure 33, item 2)**.

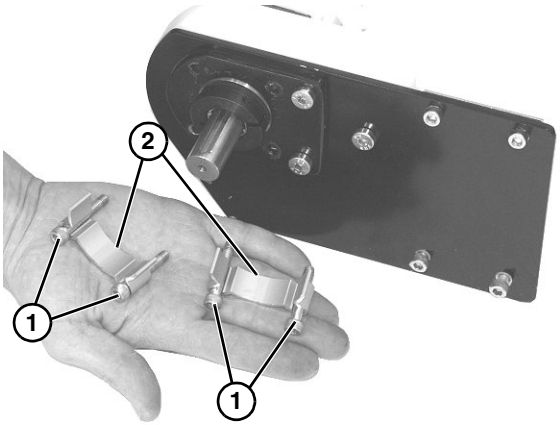


Figure 33

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

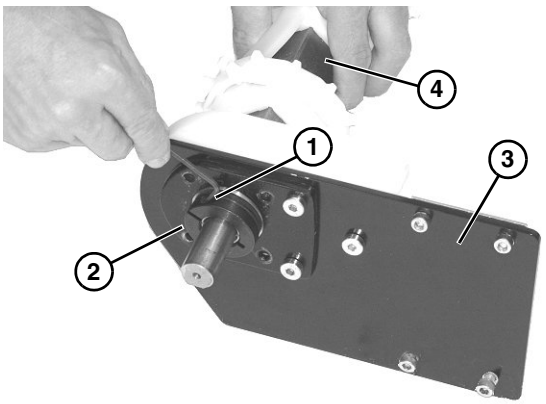


Figure 34

8. Remove plate **(Figure 34, item 3)** from drive spindle **(Figure 34, item 4)**.

9. Remove retaining clip **(Figure 35, item 1)** and flanged puck **(Figure 35, item 2)** from drive spindle.

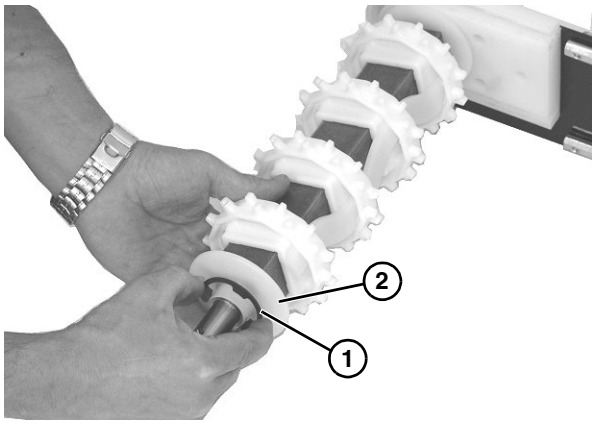


Figure 35

10. Slide entire sprocket assembly slightly outward, and remove the first sprocket **(Figure 36, item 1)** off the drive spindle and alignment bar **(Figure 36, item 2)**.

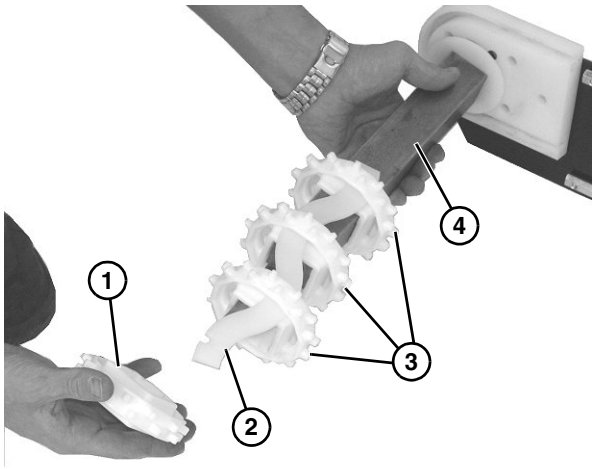


Figure 36

11. Remove remaining sprockets **(Figure 36, item 3)** off the alignment bar as you slide entire assembly off the drive spindle **(Figure 36, item 4).**
12. To assemble sprockets onto drive spindle, slide one sprocket **(Figure 37, item 1)** onto alignment bar **(Figure 37, item 2)** and slide assembly onto drive spindle **(Figure 37, item 3)**.

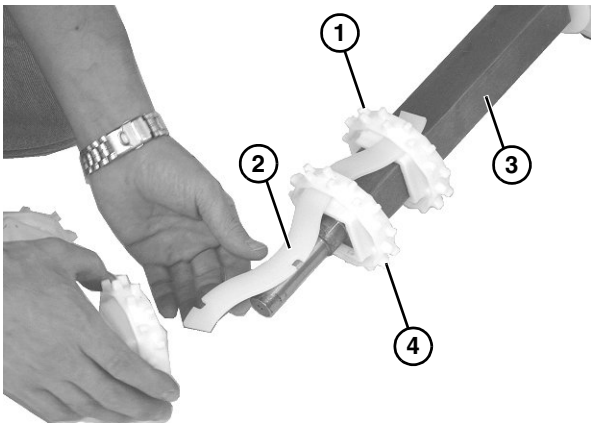


Figure 37

13. Install second sprocket **(Figure 37, item 4)** and subsequent sprockets one by one, while sliding entire assembly onto alignment bar and spindle.
14. Check drive terminal assembly **(Figure 38, item 1)** for wear. If worn, remove three low head cap screws **(Figure 38, item 2)** and replace.

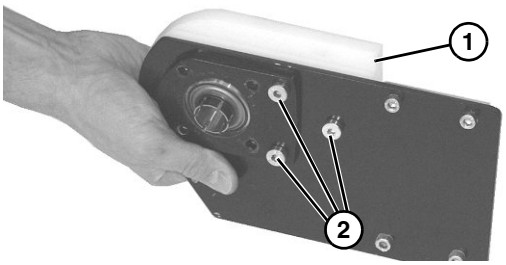


Figure 38

NOTE

*When reinstalling the drive spindle tail assembly, the terminal assembly **(Figure 39, item 1)** should mate flush with the conveyor frame **(Figure 39, item 2)**.*

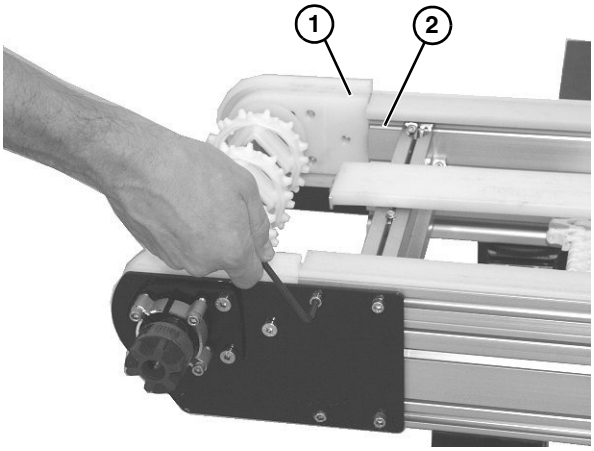


Figure 39

B – Idler Spindle Removal

1. Be sure the conveyor is supported.
2. On one side of conveyor, loosen the four socket head screws **(Figure 40, item 1)**. Repeat on opposite side.

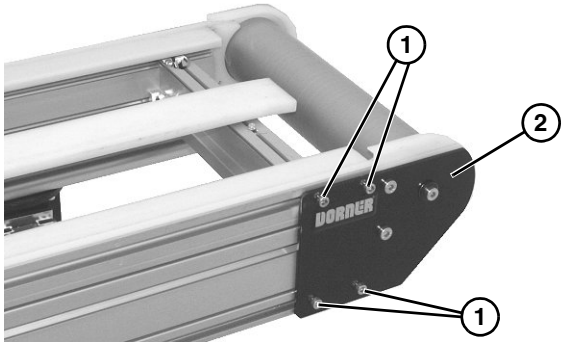


Figure 40

3. Remove idler tail assembly **(Figure 40, item 2)**.
4. Remove socket head screw **(Figure 41, item 1)** from plate **(Figure 41, item 2)** and center of spindle shaft **(Figure 41, item 3)**. Repeat procedure on opposite side.

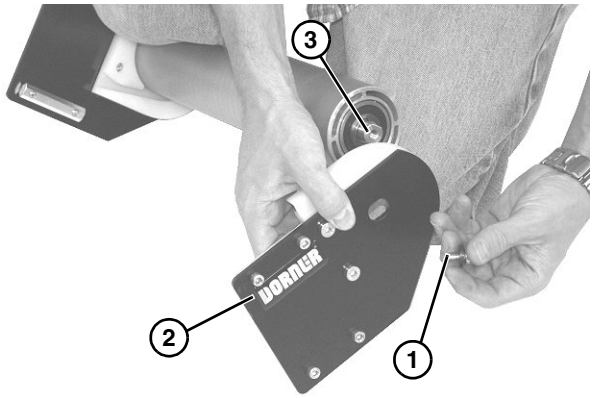


Figure 41

5. Remove the spindle shaft assembly: remove the clip ring **(Figure 42, item 1)** and washer **(Figure 42, item 2)** from one side of the spindle assembly.

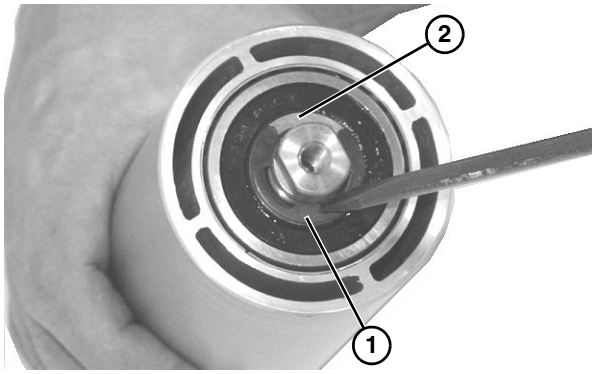


Figure 42

6. Slide the shaft assembly **(Figure 43, item 1)** out of the pulley **(Figure 43, item 2)**.

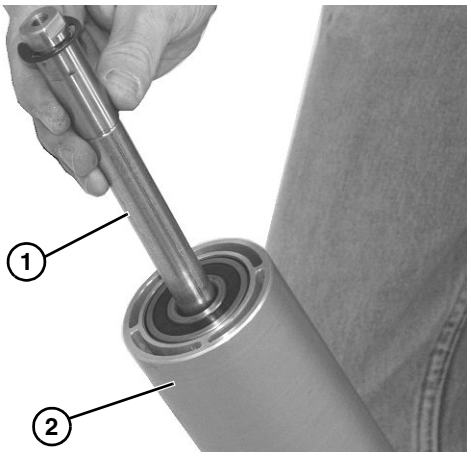


Figure 43

7. Check idler terminal assembly **(Figure 44, item 1)** for wear. If worn, remove two low head cap screws **(Figure 44, item 2)** and replace.

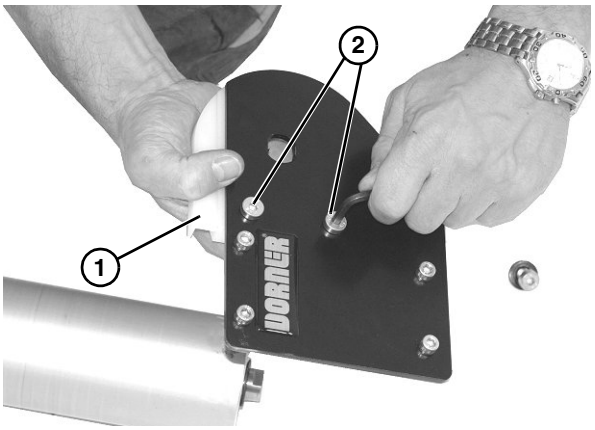


Figure 44

NOTE

When reinstalling the idler spindle tail assembly, the idler terminal assembly ***(Figure 45, item 1)*** *should mate flush with the conveyor frame* ***(Figure 45, item 2)****.*

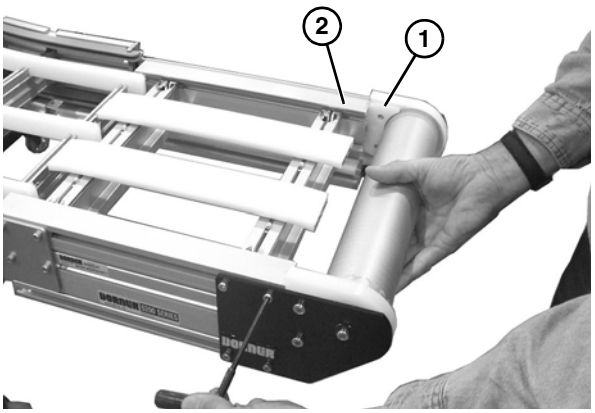


Figure 45

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 46, item 1)**. Repeat on opposite side.

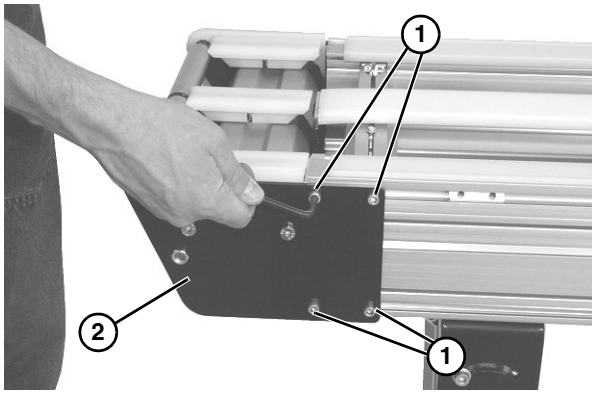


Figure 46

3. Remove idler tail assembly **(Figure 46, item 2)**.
4. Remove two low head cap screws **(Figure 47, item 1)** from plate **(Figure 47, item 2)**. Repeat procedure on opposite side.

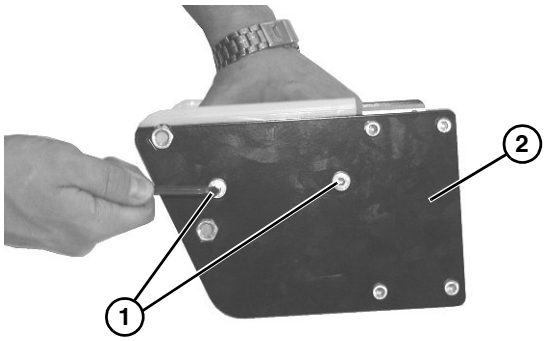


Figure 47

5. Remove upper nut **(Figure 48, item 1)** and spacer from end of axle shaft assembly.

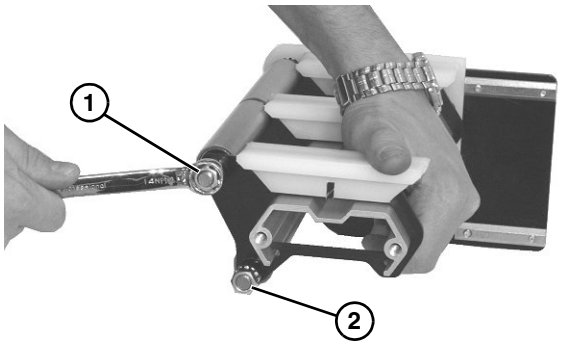


Figure 48

6. Remove lower nut **(Figure 48, item 2)** and spacer from lower axle shaft assembly.
7. Slide the support plate **(Figure 49, item 1)** off of both axle shafts.

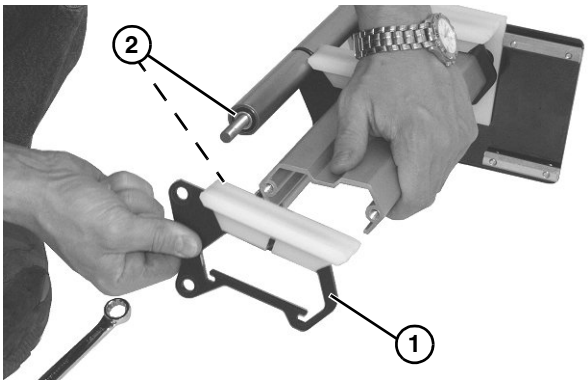


Figure 49

8. Remove washer **(Figure 49, item 2)** off of lower and upper axle shafts.
9. Remove roller assembly **(Figure 50, item 1)** and washer **(Figure 50, item 2)** from axle shaft **(Figure 50, item 3)**.

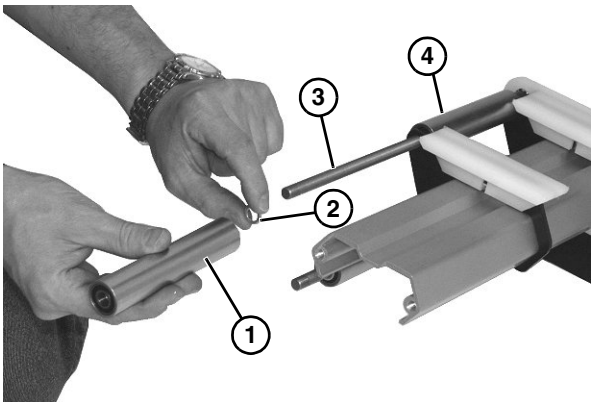


Figure 50

10. Remove remaining roller assembly components **(Figure 50, item 4)** on opposite side.
11. Check idler terminal assembly on each side **(Figure 51, item 1)** for wear. If worn, replace.

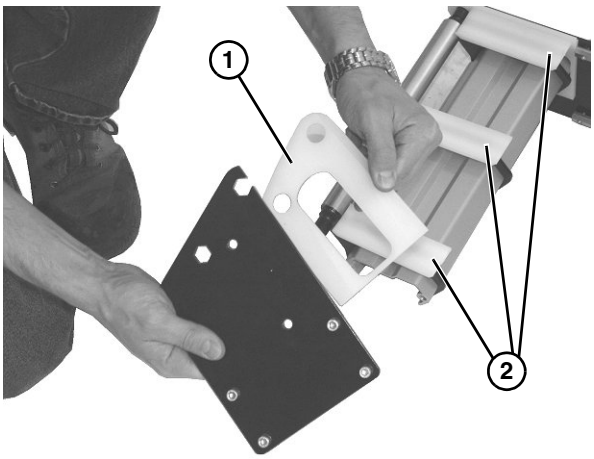


Figure 51

12. Remove and replace wear guides **(Figure 51, 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 52, item 1)*** *should mate flush with the conveyor frame* ***(Figure 52, item 2)****.*

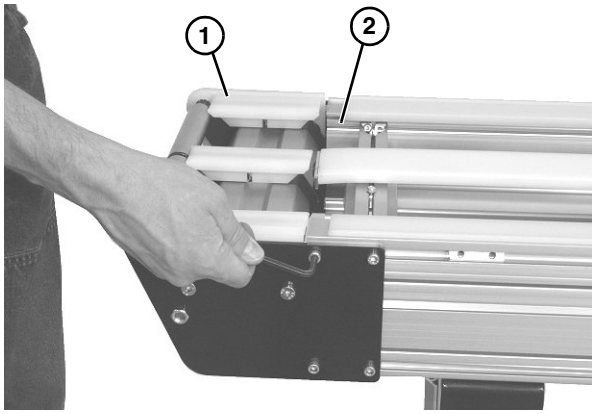


Figure 52

Spindle Replacement

Drive Spindle

To replace the drive spindle, reverse the "A - Drive Spindle Removal" procedure on page 15.

Idler Spindle

To replace the idler spindle, reverse the "B - Idler Spindle Removal" procedure on page 17.

Nose Bar Idler Spindle

To replace the idler spindle, reverse the "C - Nose Bar Idler Spindle Removal" procedure on page 18.

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 53, item 1)** to align with slots **(Figure 53, item 2)** in bearing housing. Then remove bearing.

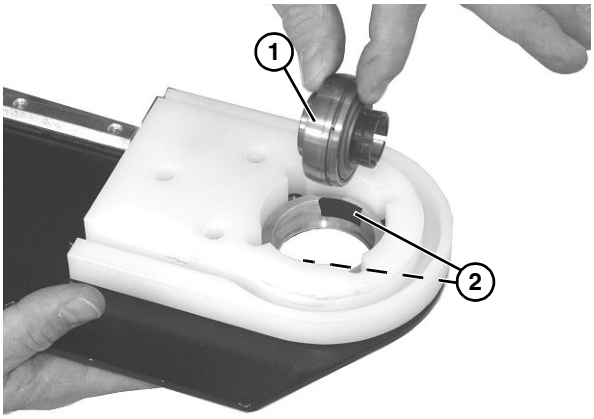


Figure 53

Replacement

1. Inspect bearing housing bearing surface. If worn or damaged, replace. See “Service Parts” on page 21.
2. Insert bearing **(Figure 54, item 1)** into housing slot: Locate anti–rotation nub **(Figure 54, item 2)** to align with slot **(Figure 54, item 3)**, and twist bearing into housing.

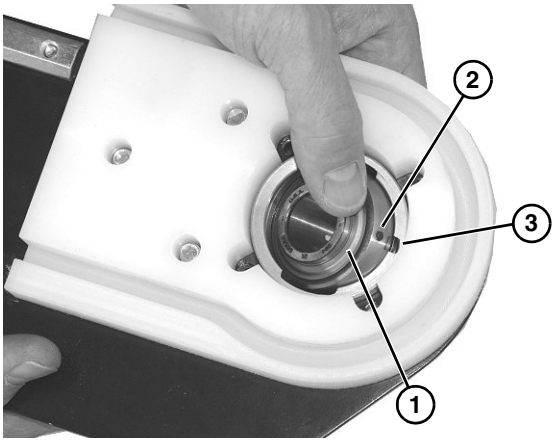


Figure 54

Maintenance of Knuckles

Lower Knuckle

1. Remove cap screw **(Figure 55, item 1)**, washer, and spacer on side of lower knuckle assembly **(Figure 55, item 2)**, and remove hold down guide **(Figure 55, item 3)**. Repeat on opposite side.

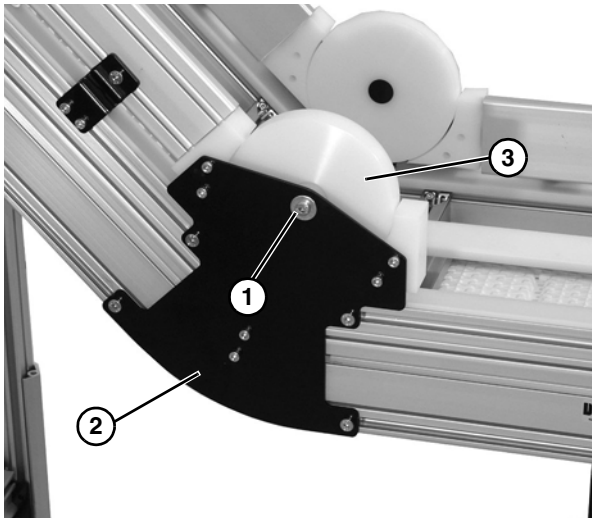


Figure 55

2. Remove two socket cap screws **(Figure 56, item 1)** for all four hold down guards **(Figure 56, item 2)** on side of lower knuckle assembly **(Figure 56, item 3)**.

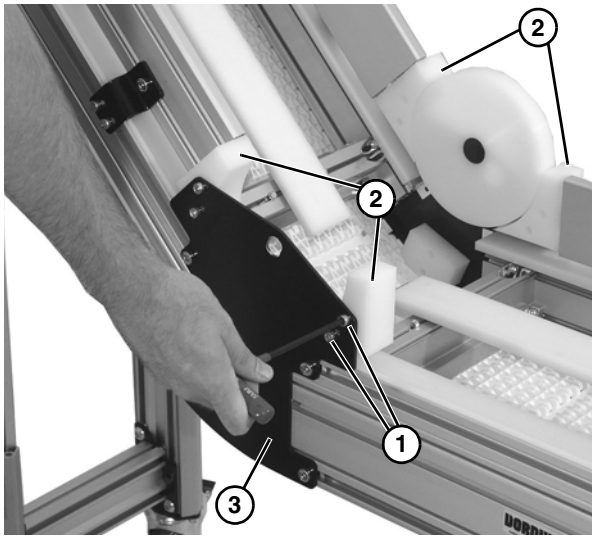


Figure 56

3. Replace parts as necessary.
4. Install parts reverse of removal.

Upper Knuckle

1. Remove socket head cap screw **(Figure 57, item 1)**, on each side of upper knuckle assembly, and remove shaft and sprocket assembly **(Figure 57, item 2)**.

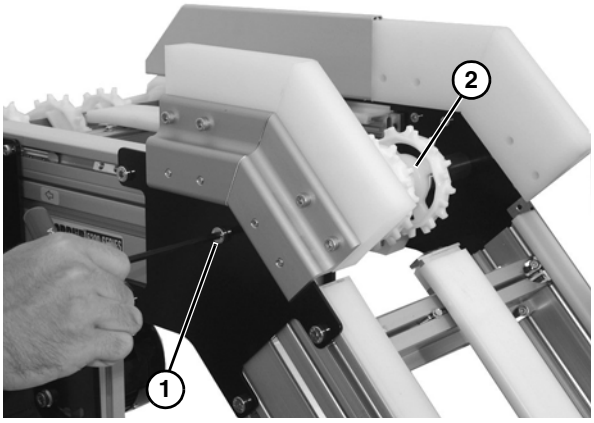


Figure 57

2. Remove three sprockets **(Figure 58, item 1)** off of shaft **(Figure 58, item 2).**

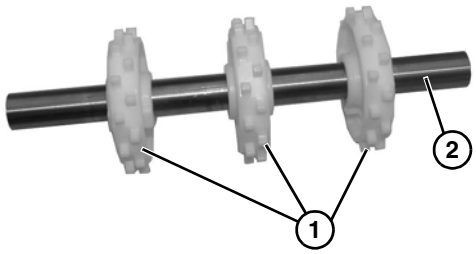


Figure 58

3. Remove socket cap screw **(Figure 59, item 1)** for each belt guide **(Figure 59, item 2)** on side of upper knuckle assembly. Repeat on opposite side.

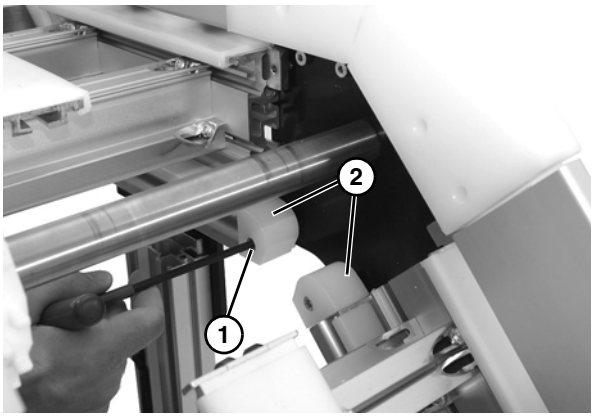


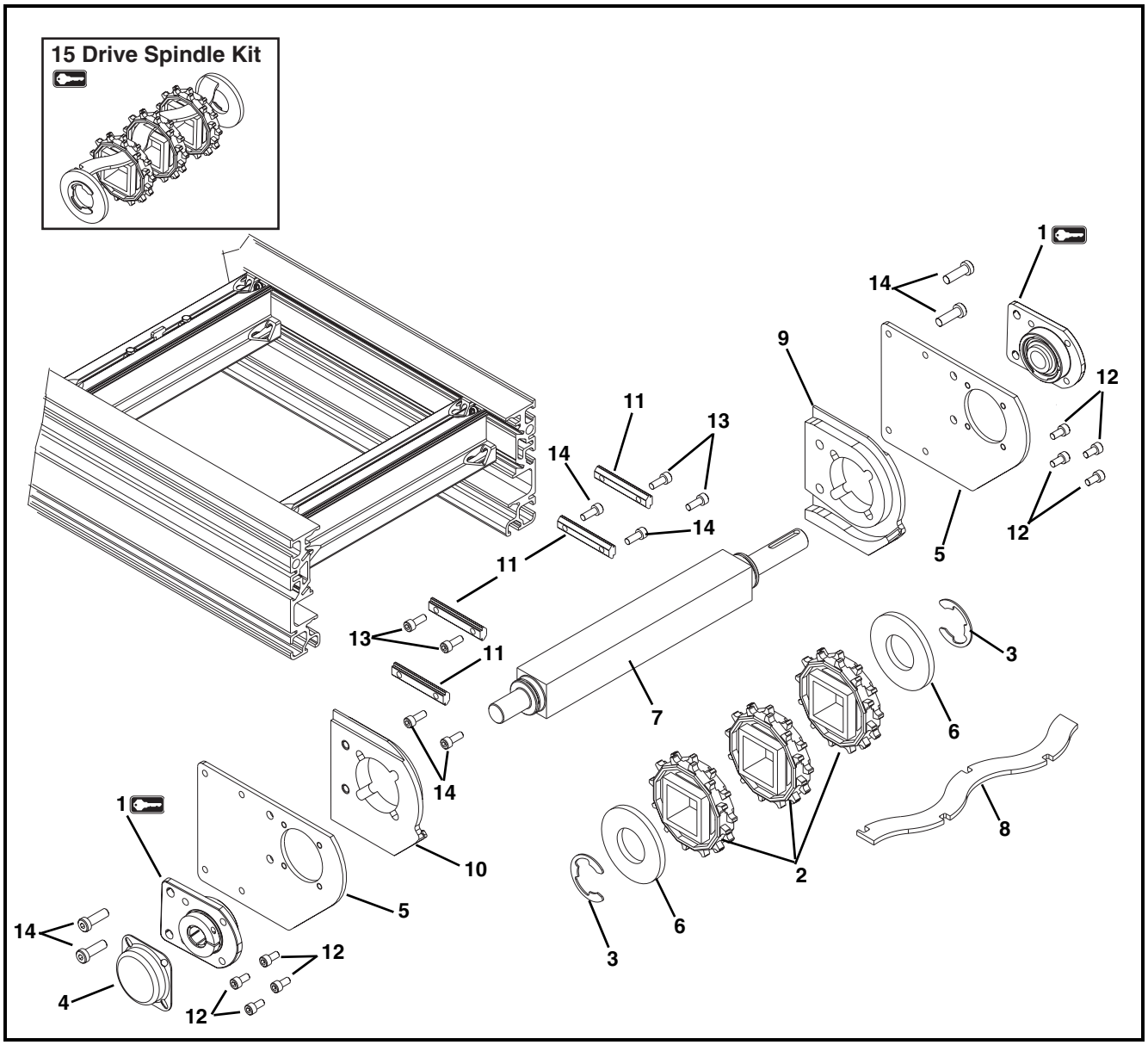
Figure 59

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

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

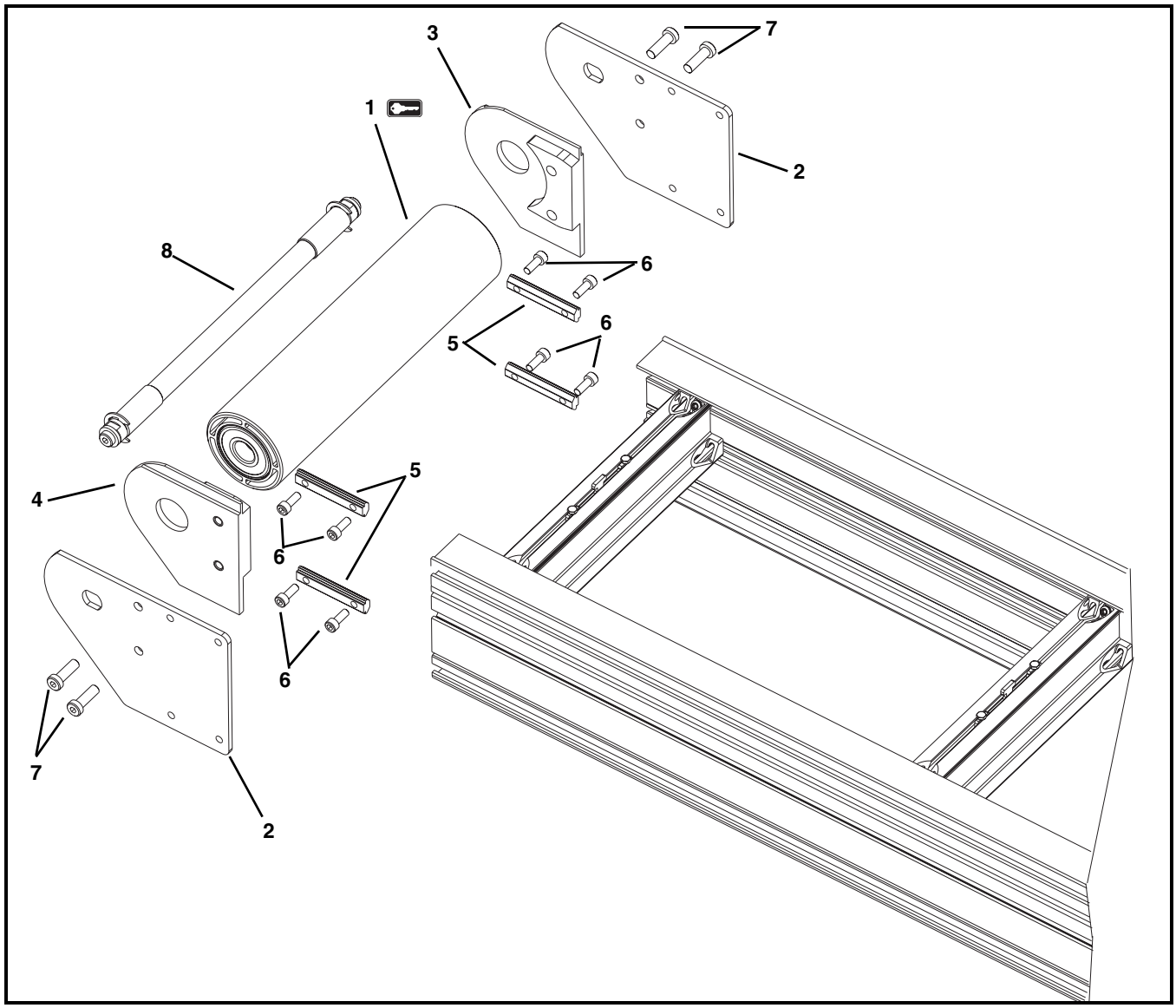


Item	Part Number	Description
1	52BKD	Drive Bearing Kit (Qty 2)
2	807-1444	Sprocket
3	915-240	Retaining Ring
4	300139	Shaft Cover
5	352109	Cover Plate
6	352111	Sprocket Alignment Retainer Key
7	352112-WW	Drive Spindle
8	352113-WW	Sprocket Alignment Bar
9	352121	Drive Terminal Assembly Left Hand
10	352122	Drive Terminal Assembly Right Hand

Item	Part Number	Description
11	300150M	Drop-In Tee Bar
12	920612M	Socket Head Screw, M6-1.00 x 12 mm
13	920616M	Socket Head Screw, M6-1.00 x 16 mm
14	920895M	Low Head Cap Screw, M8-1.25 x 25 mm
15	52DT-WW	Drive Spindle Kit (Includes Items 2, 3, 6 and 8)
WW = Conveyor width reference: 08 – 60 in 02 increments		

Service Parts

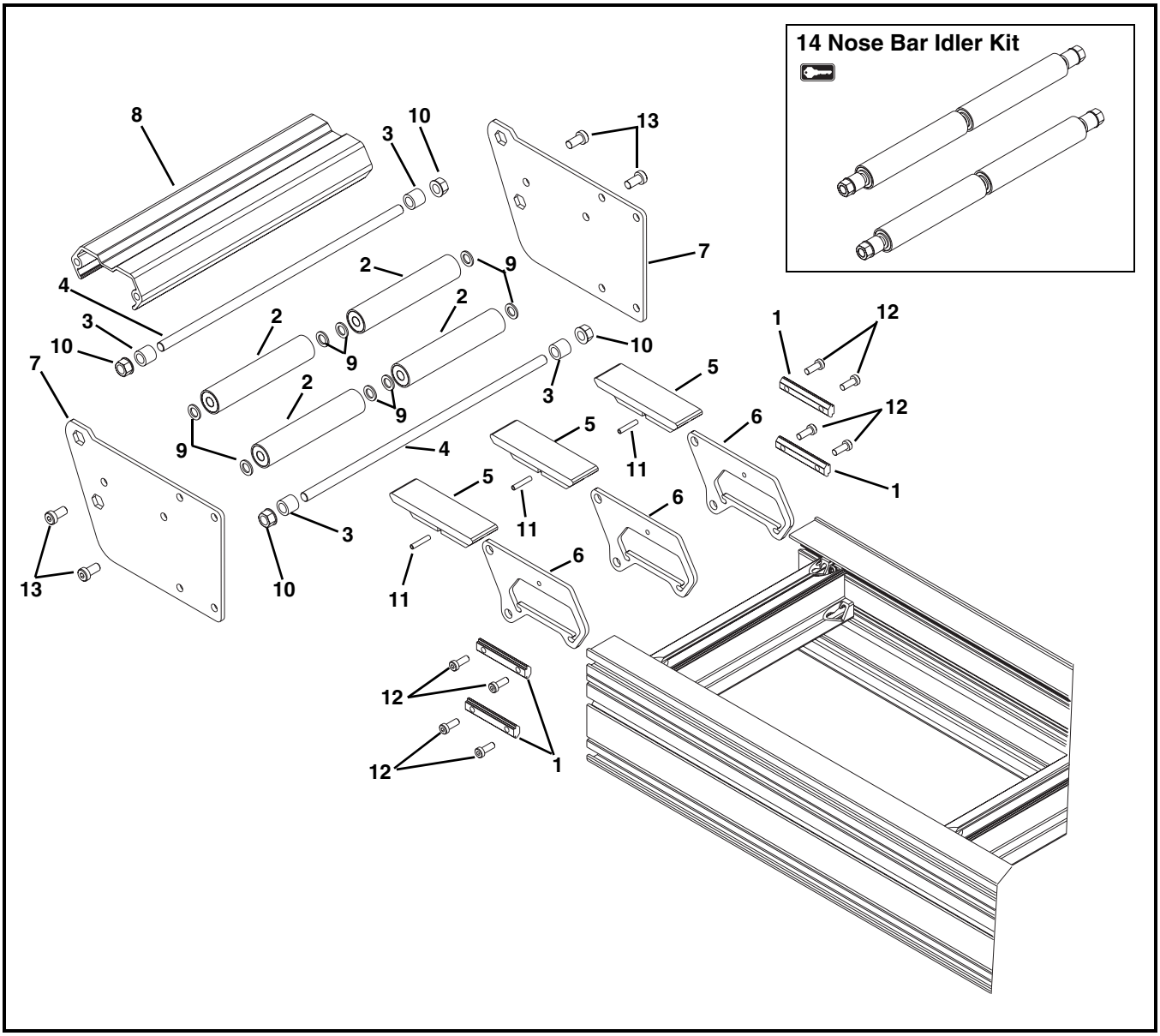
Idler End Components



Item	Part Number	Description
1	352011-WW	Idler Pulley Assembly
2	352110	Cover Plate
3	352123	Idler Terminal Assembly Left Hand
4	352124	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	352012-WW	Idler Wand Assembly
WW = Conveyor width reference: 08 – 60 in 02 increments		

Nose Bar Idler End Components

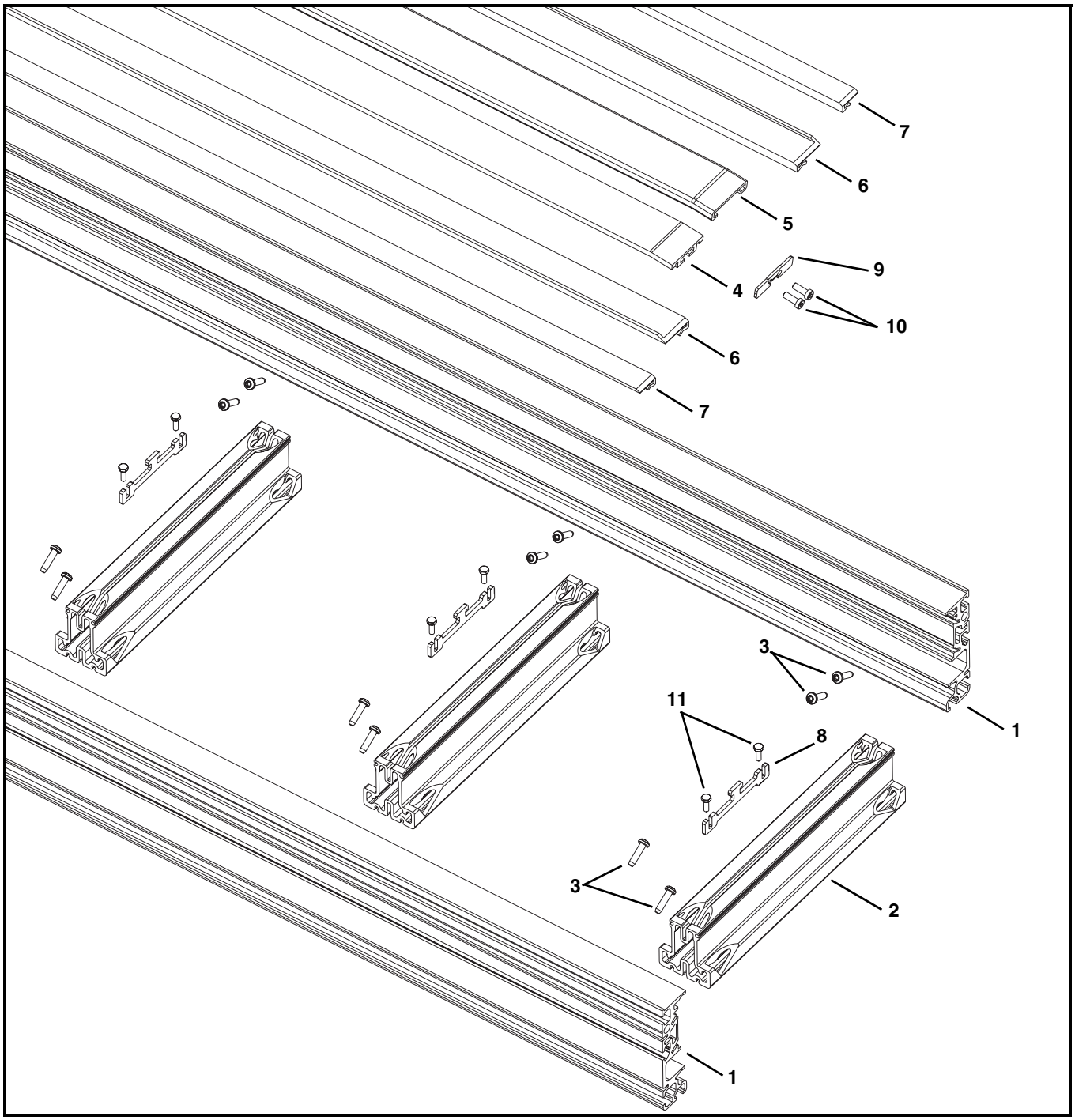


Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	352013-WW	Roller Assembly
3	352125	Spacer
4	352126-WW	Axle Shaft
5	352128	Wear Guide
6	352146	Support Plate
7	352149	Cover Plate
8	352151-WW	Crossmember
9	807-1136	Washer

Item	Part Number	Description
10	910-203	Hex Nut
11	913-409	Pin
12	920693M	Socket Head Screw, M6-1.00 x 16 mm
13	920893M	Low Head Cap Screw, M8-1.25 x 25 mm
14	52NBT-WW	Nose Bar Idler Kit (Includes Items 2, 3, 4, 9, 10 and 13)
WW = Conveyor width reference: 08 – 60 in 02 increments		

Service Parts

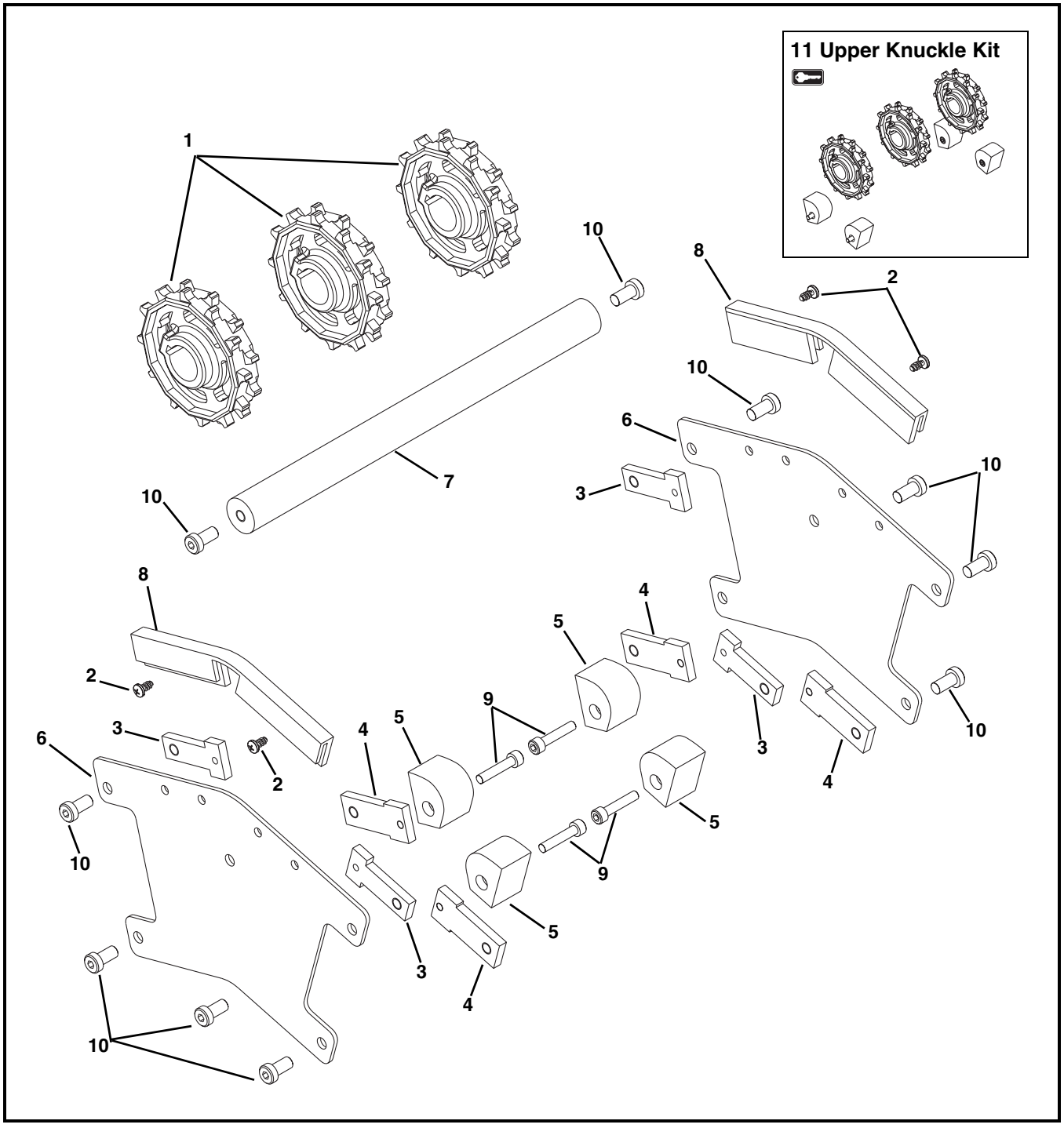
Frame Assembly



Item	Part Number	Description
1	352100-LLLLL	Side Rail
2	352101-WW	Cross Support Rail
3	352108	Pan Screw, M5-.80 x 20 mm
4	352102-LLLLL	Center Bed Rail
5	352103-LLLLL	Center Wearstrip
6	352104-LLLLL	Top Wearstrip
7	352105-LLLLL	Return Wearstrip
8	352106	Center Bed Rail Hold Down Clip

Item	Part Number	Description
9	352107	Center Wearstrip Stop Plate
10	901-133	Button Head Cap Screw, 1/4- 20 x 0.88"
11	960498M	Hex Head Cap Screw, M4-.70 x 12 mm
WW = Conveyor width reference: 08 – 60 in 02 increments		
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Upper Knuckle - Low Side

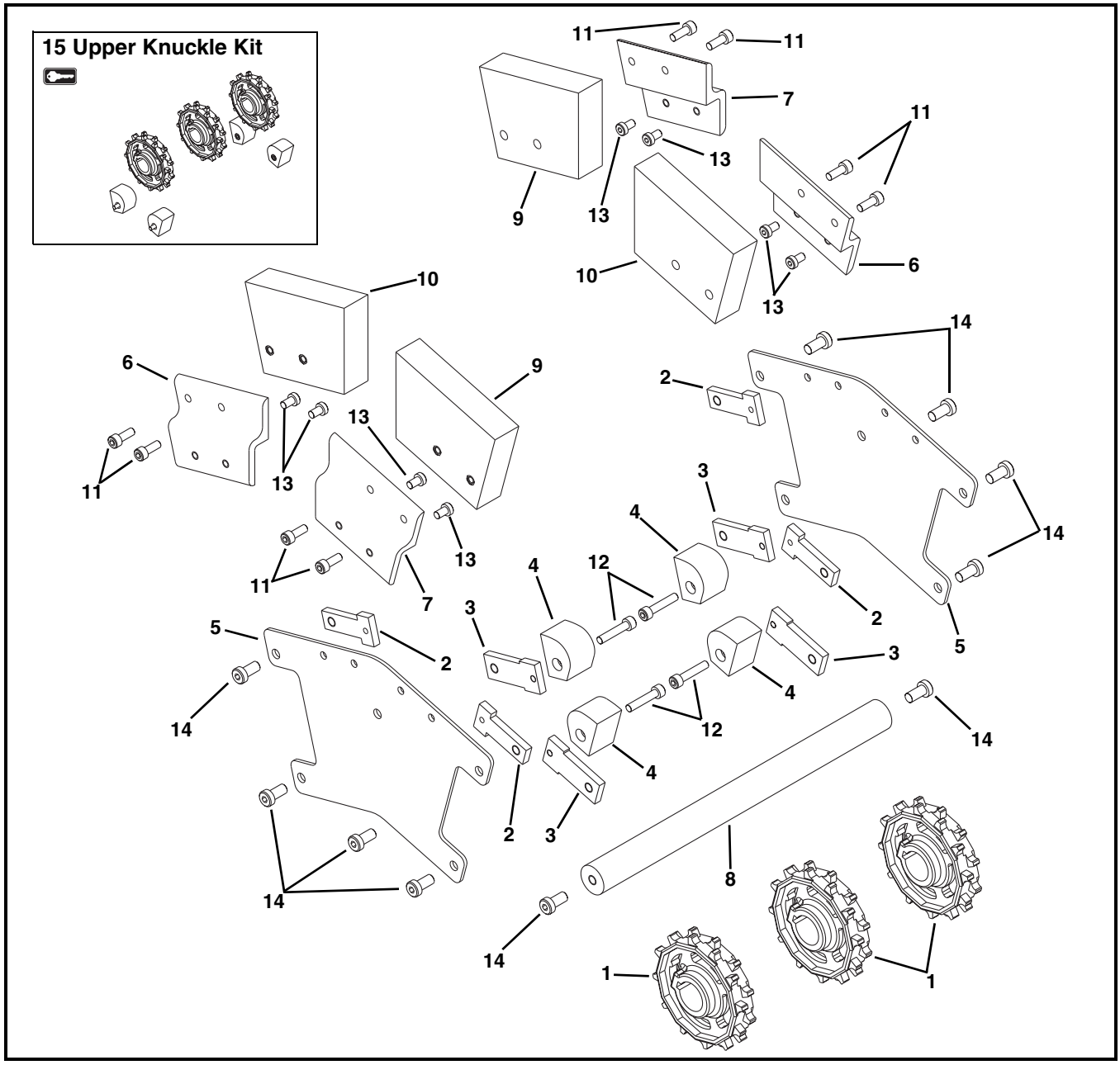


Item	Part Number	Description
1	807-1754	Sprocket
2	807-1759	Screw, M5 x 10 mm
3	352322	Top Stop Nut
4	352323	Bottom Stop Nut
5	352328	Belt Guide
6	325329-AA	Side Plate
7	352336-WW	Shaft

Item	Part Number	Description
8	352341-AA	Lowside guide
9	920630M	Socket Head Screw, M6-1.00 x 30 mm
10	920893M	Low Head Cap Screw, M8-1.25 x 16 mm
11	52NO-WW	Upper Knuckle Kit (Includes Items 1, 5 and 9)
WW = Conveyor width reference: 08 – 24 in 02 increments		
AA = Angle 05, 10, 15, 30, 45 and 60		

Service Parts

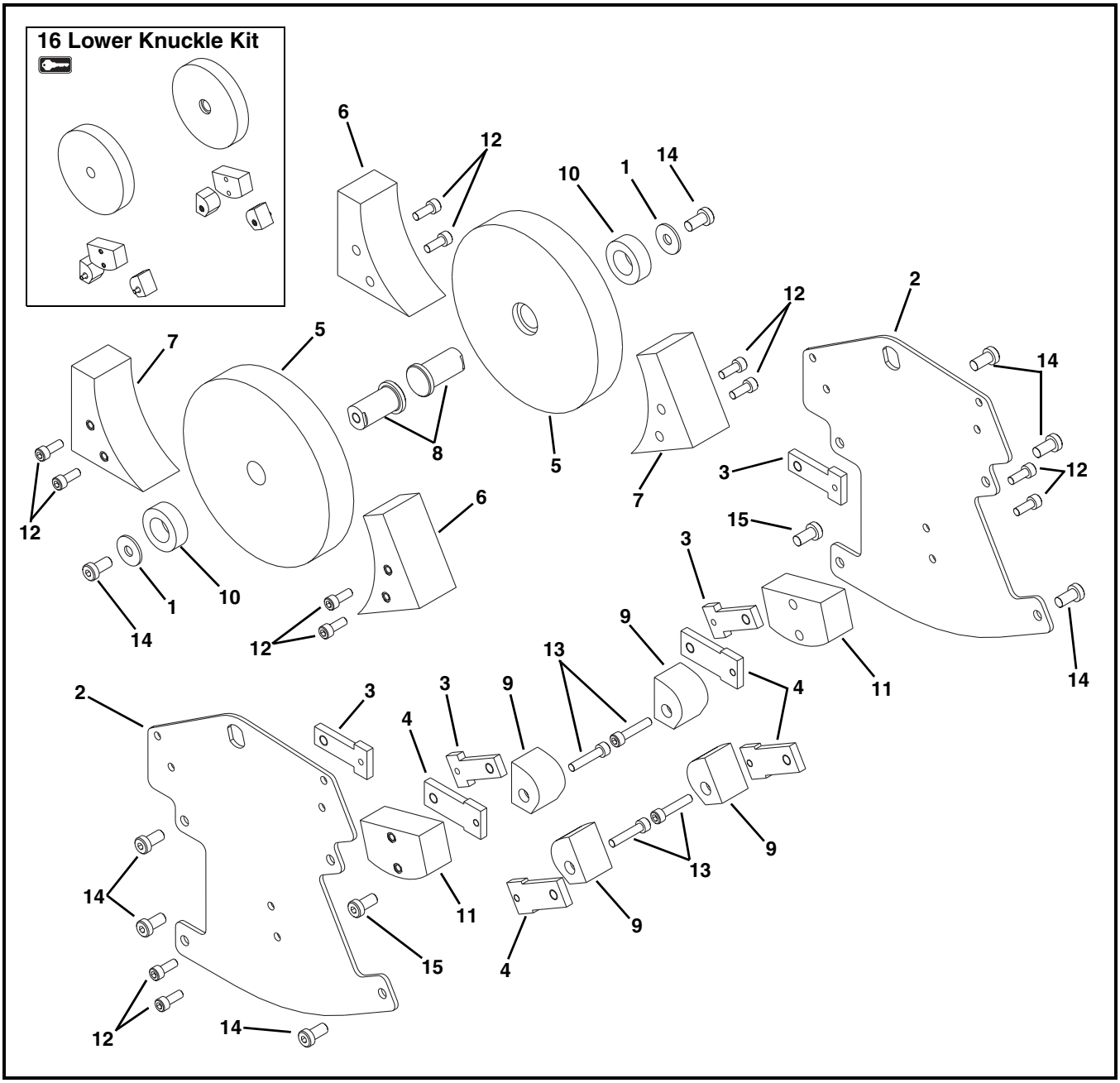
Upper Knuckle - High Side



Item	Part Number	Description
1	807-1754	Sprocket
2	352322	Top Stop Nut
3	352323	Bottom Stop Nut
4	352328	Belt Guide
5	325329-AA	Side Plate
6	352332-AA	High Side Mounting Guide Left Hand
7	352333-AA	High Side Mounting Guide Right Hand
8	352336-WW	Shaft
9	352343-AA-L	High Side Guide Left Hand
10	352343-AA-R	High Side Guide Right Hand

Item	Part Number	Description
11	920616M	Socket Head Screw, M6-1.00 x 16 mm
12	920630M	Socket Head Screw, M6-1.00 x 30 mm
13	920691M	Low Head Cap Screw, M6-1.00 x 10 mm
14	920893M	Low Head Cap Screw, M8-1.23 x 16 mm
15	52NO-WW	Upper Knuckle Kit (Includes Items 1,4 and 12)
WW = Conveyor width reference: 08 – 24 in 02 increments		
AA = Angle 05, 10, 15, 30, 45 and 60		

Lower Knuckle

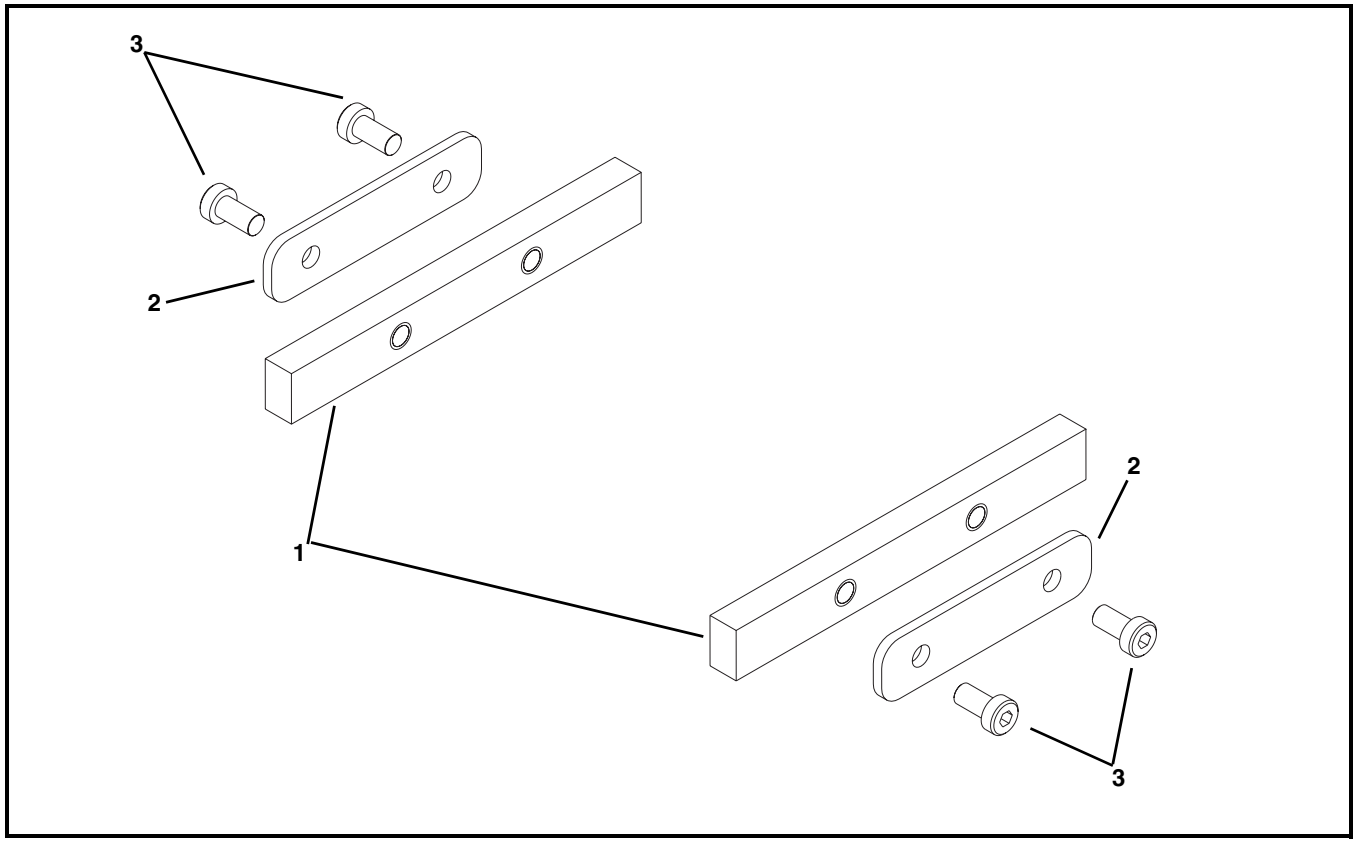


Item	Part Number	Description
1	807-1760	Washer
2	352321-AA	Side Plate
3	352322	Top Stop Nut
4	352323	Bottom Stop Nut
5	352324	Hold Down Guide
6	352325-L	Hold Down Guard Assembly Left Hand
7	352325-R	Hold Down Guard Assembly Right Hand
8	352327	Stub Shaft
9	352328	Belt Guide

Item	Part Number	Description
10	352337	Hold Down Spacer
11	352326	Return Block Guide
12	920616M	Socket Head Screw, M6-1.00 x 16 mm
13	920630M	Socket Head Screw, M6-1.00 x 30 mm
14	920893M	Low Head Cap Screw, M8-1.23 x 16 mm
15	807-1884	Sheet Metal Screw, #14 x 1.25”
16	52HI	Lower Knuckle Kit (Includes Items 5, 9, 11 and 13)
AA = Angle 05, 10, 15, 30, 45 and 60		

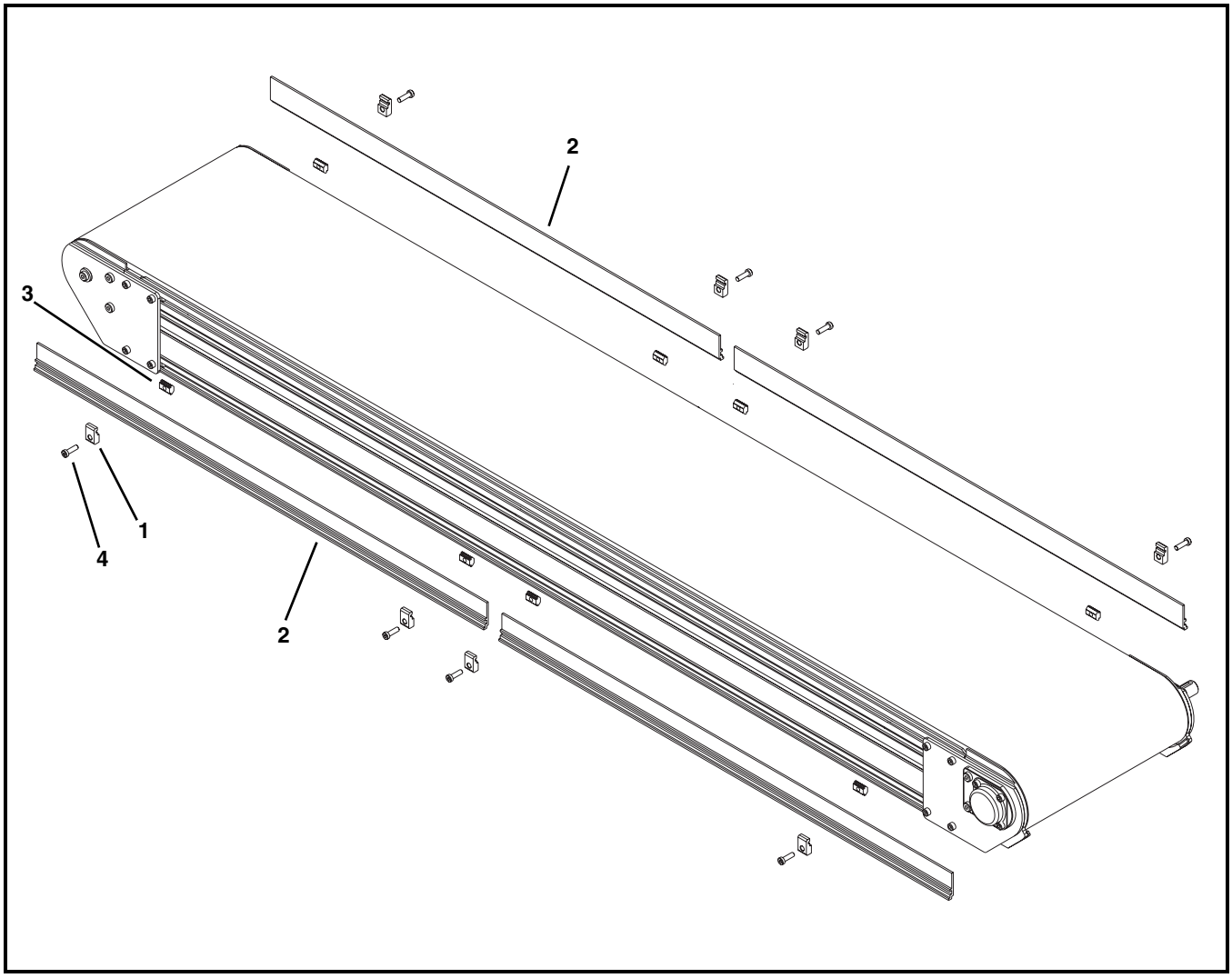
Service Parts

Connecting Assembly



Item	Part Number	Description
1	352315	Bar Frame Connector
2	240859	Plate Frame Connector
3	920692M	Low Head Cap Screw, M6-1.00 x 12 mm

1” (25 mm) High Sides

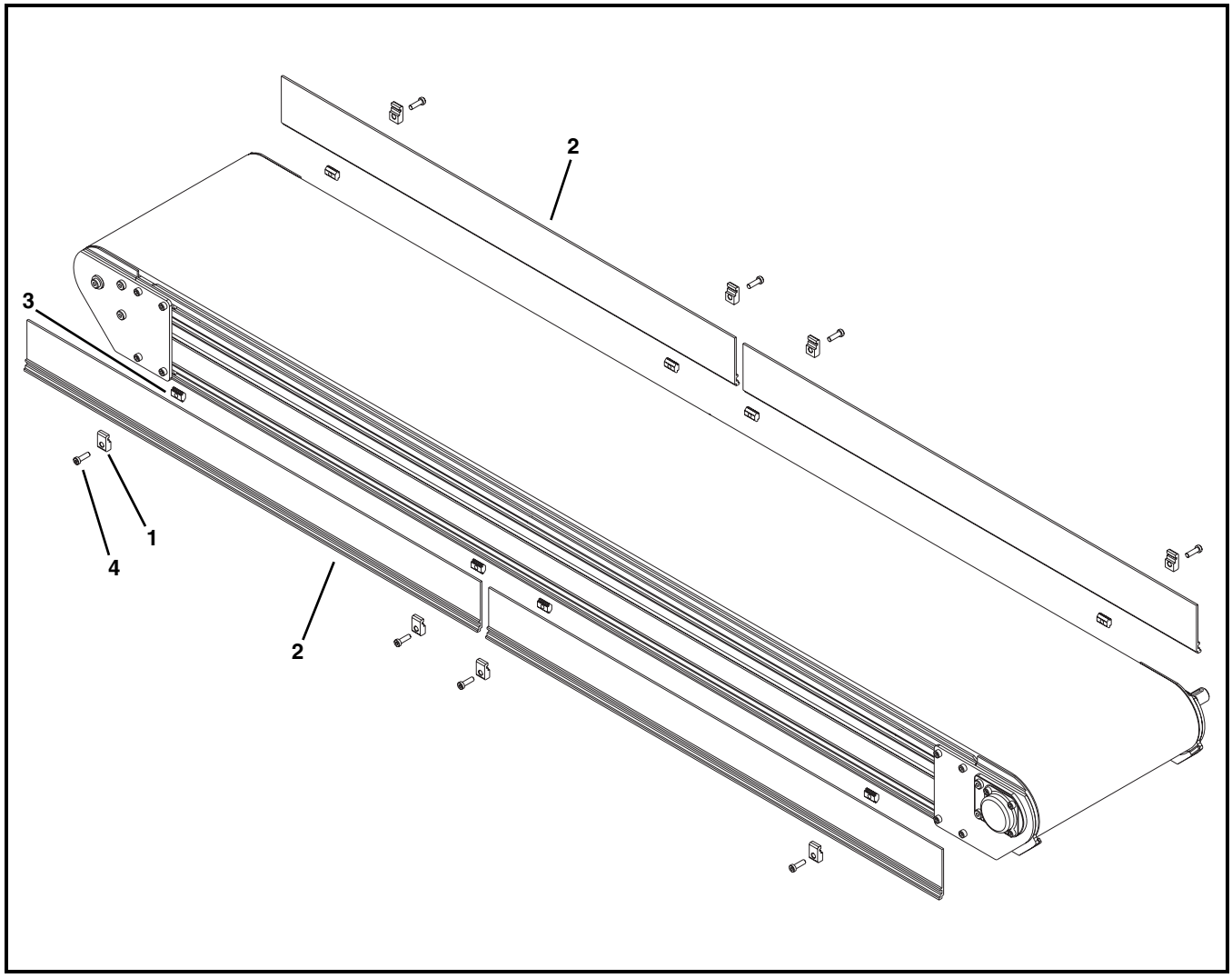


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	380500-LLLLL	1" Guides
3	639971M	Single Drop -In Tee Bar

Item	Part Number	Description
4	920694M	Low Head Cap Screw, M6-1.00 x 20 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

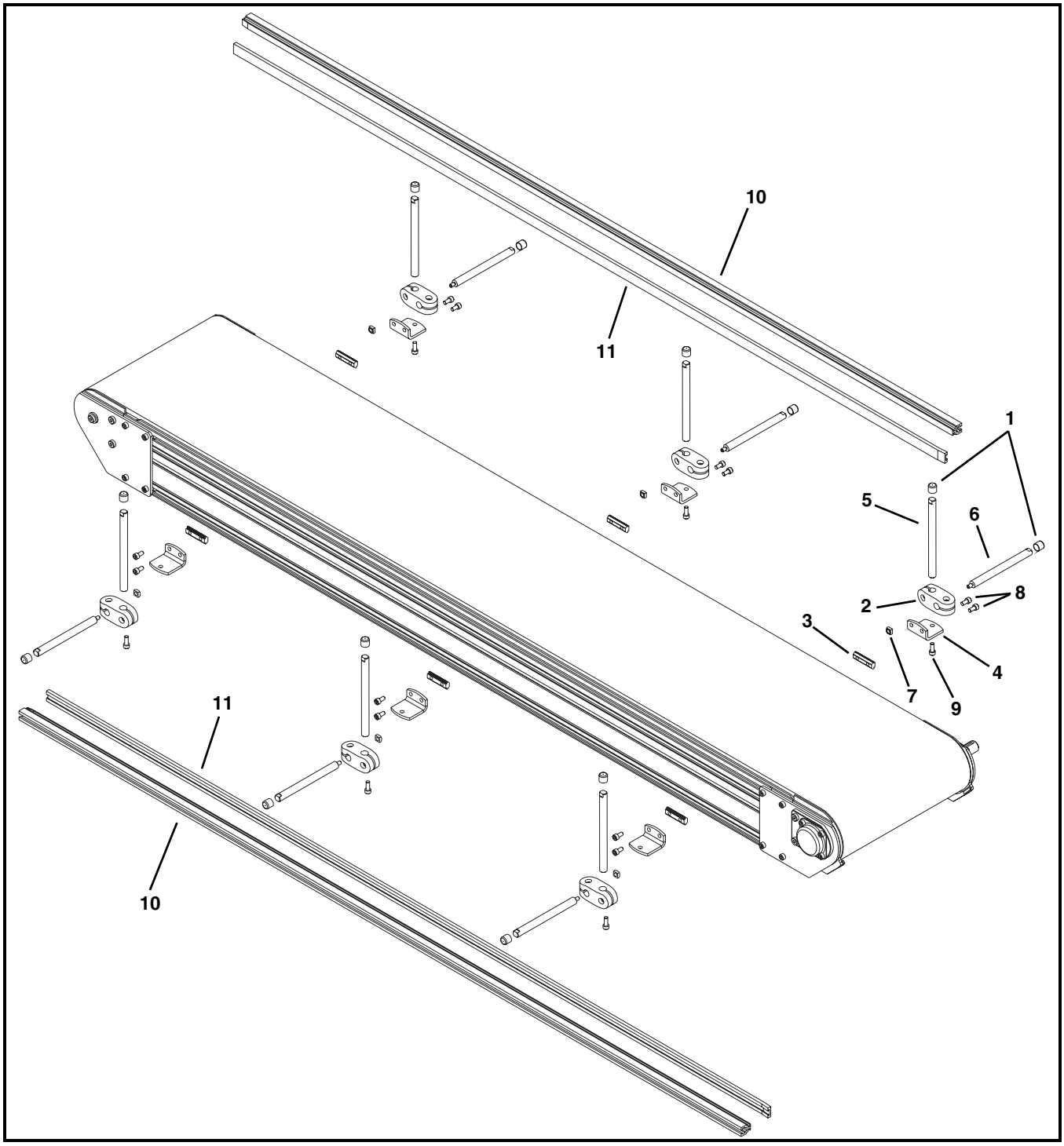
3” (76 mm) High Sides



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	380400-LLLLL	3" Guides
3	639971M	Single Drop -In Tee Bar

Item	Part Number	Description
4	920694M	Low Head Cap Screw, M6-1.00 x 20 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Fully Adjustable Guiding

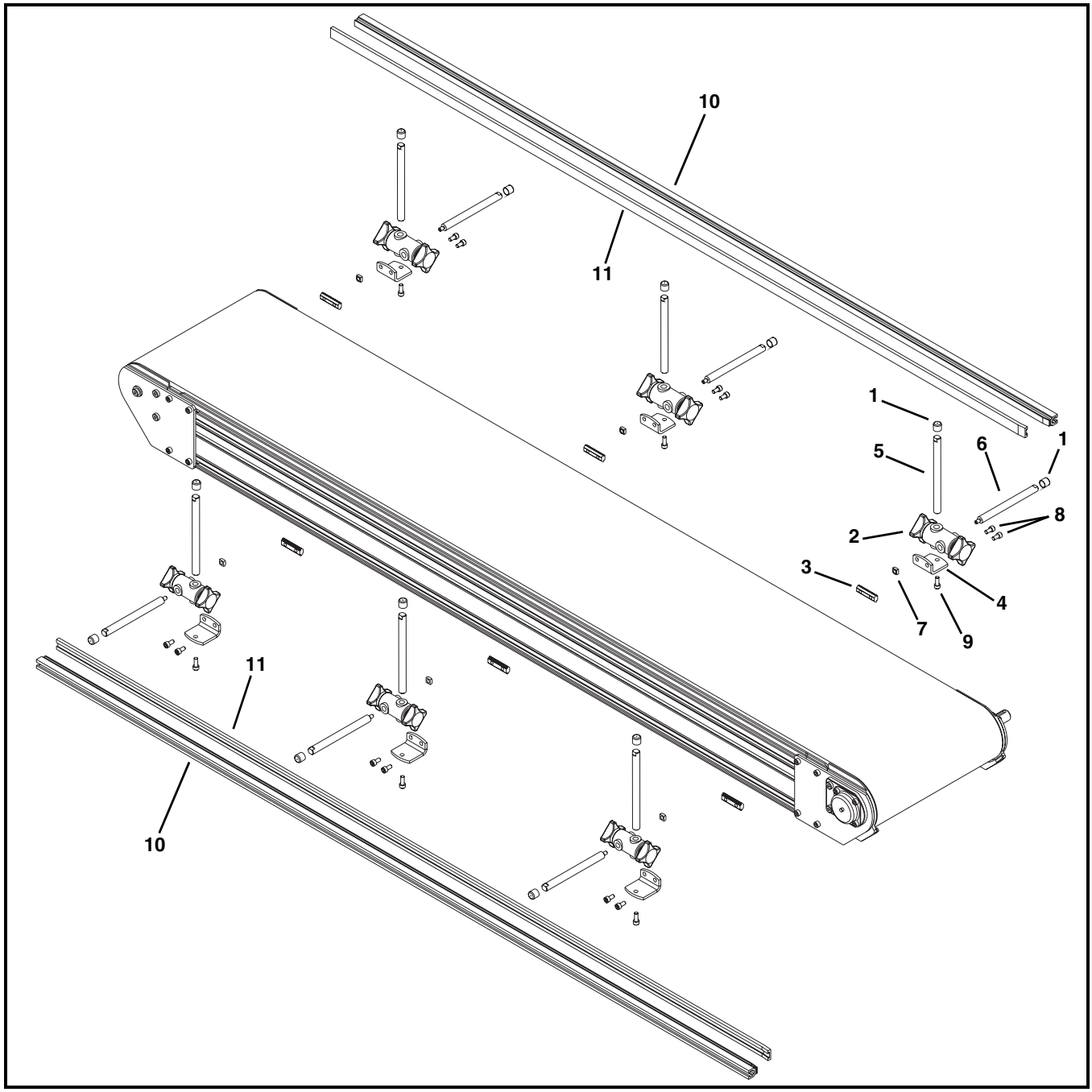


Item	Part Number	Description
1	807-948	Shaft Cap
2	807-652	Cross Block
3	200830M	Drop-In Tee Bar
4	202004M	Mounting Bracket
5	202027M	Vertical Mounting Guide Shaft
6	202028M	Horizontal Mounting Guide Shaft
7	674175MP	Square Nut, M6-1.00

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	460063-LLLLL	Aluminum Profile Guide
11	614068P-LLLLL	Extruded Guide
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

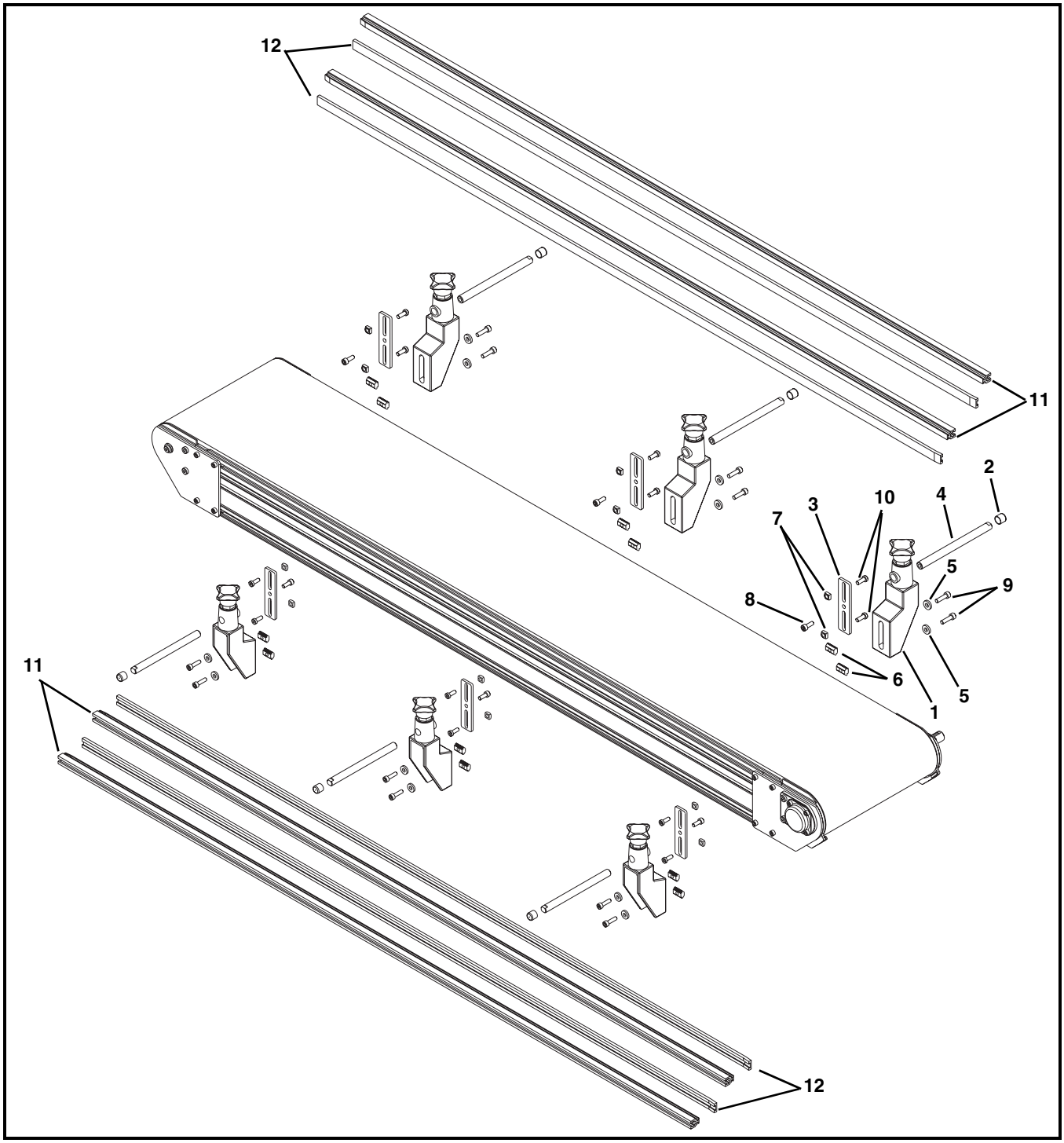
Tool-Less Fully Adjustable Guiding



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

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	460063-LLLLL	Aluminum Profile Guide
11	614068P-LLLLL	Extruded Guide
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Twin Rail Adjustable Guiding

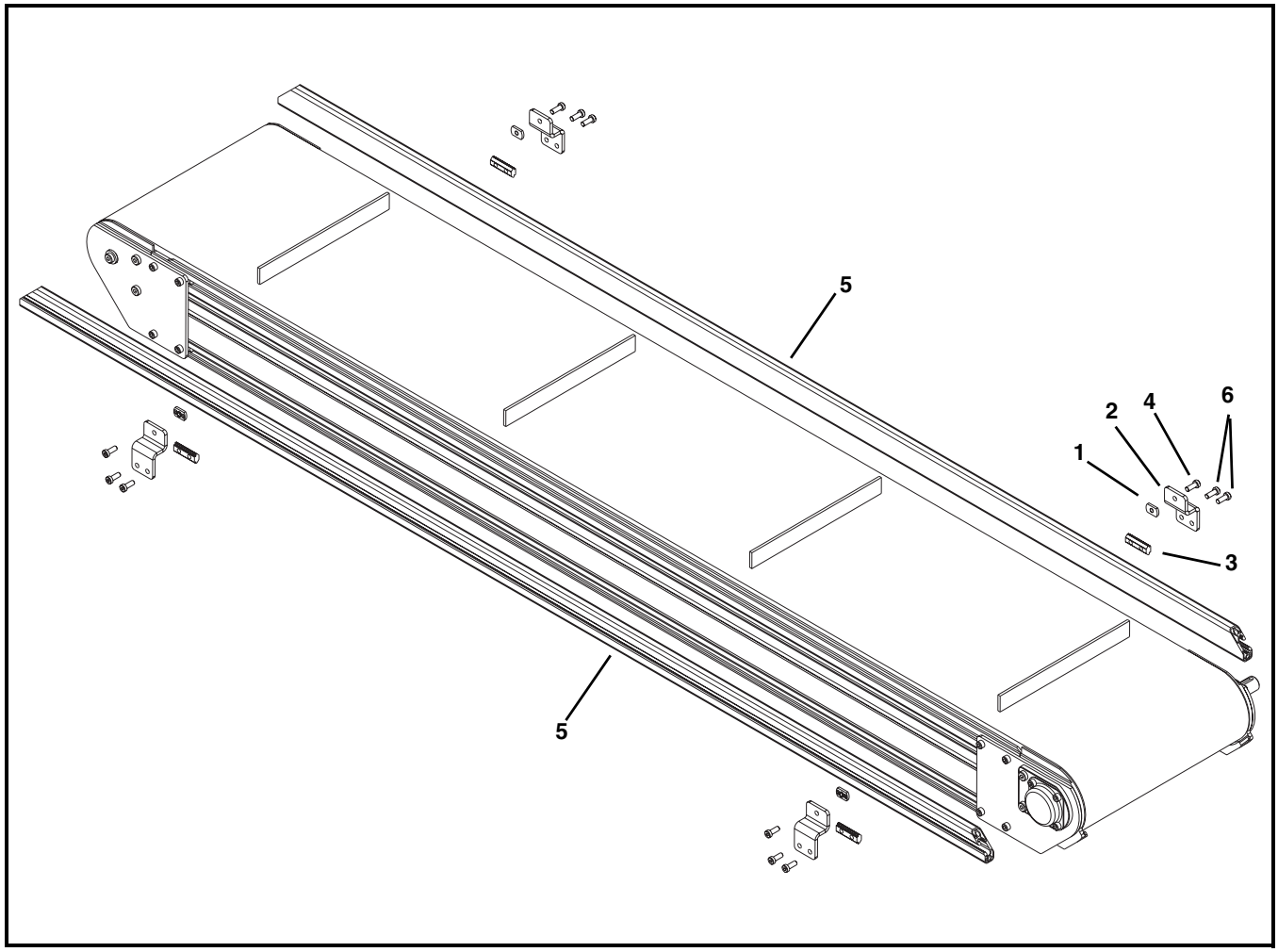


Item	Part Number	Description
1	807-1708	Swivel Guide Rail Bracket
2	807-948	Shaft Cap
3	352304	Guide Mounting Bracket
4	202027M	Mounting Shaft
5	605279P	Washer
6	639971M	Drop-In Tee Bar
7	674175MP	Square Nut, M6-1.00

Item	Part Number	Description
8	920616M	Socket Head Screw, M6-1.00 x 16 mm
9	920622M	Socket Head Screw, M6-1.00 x 22 mm
10	920693M	Low Head Cap Screw, M6-1.00 x 16 mm
11	460063-LLLLL	Aluminum Profile Guide
12	614068P-LLLLL	Extruded Guide
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

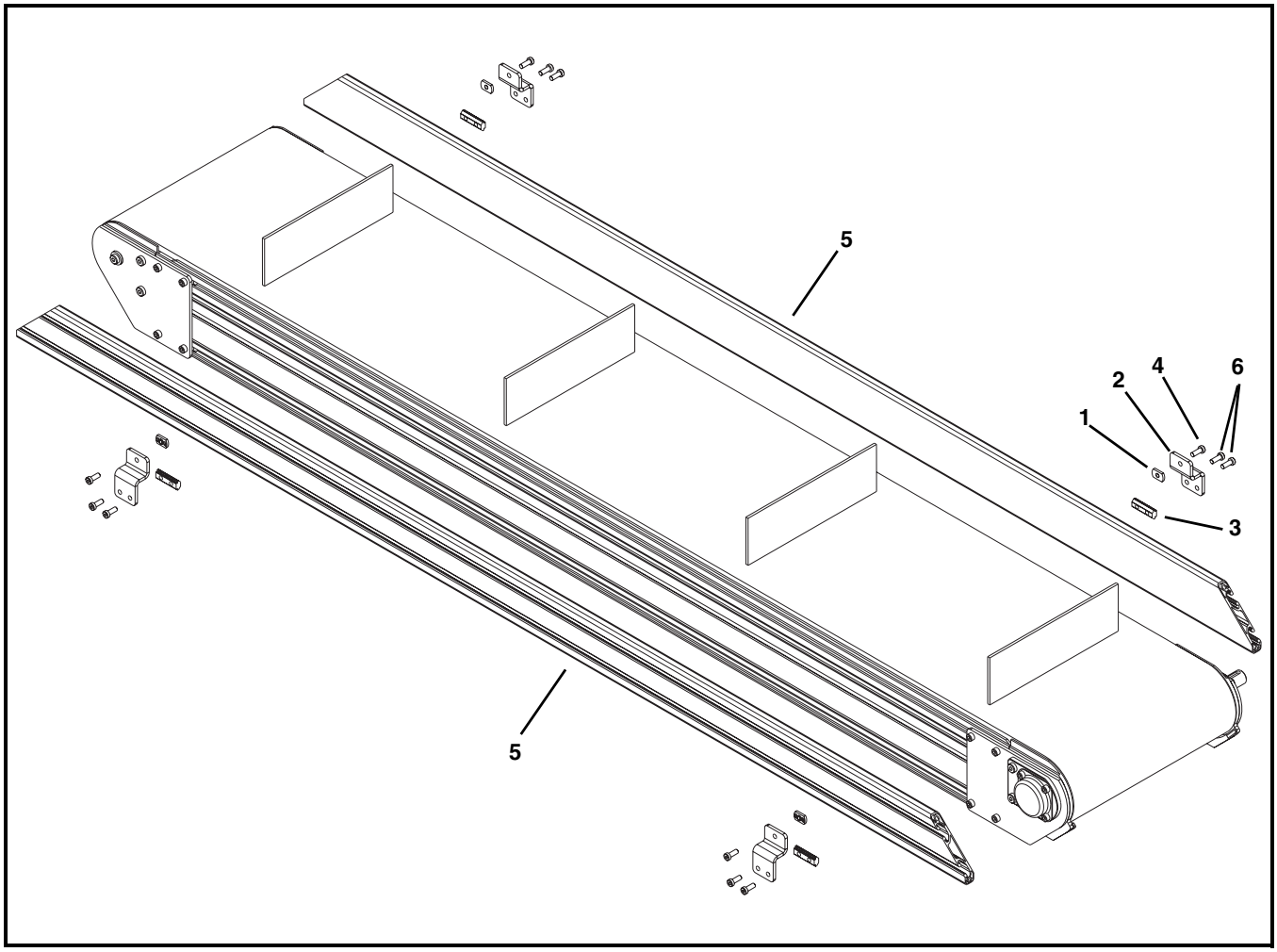
1” (25 mm) Cleated Guiding



Item	Part Number	Description
1	807-1075	Weld Nut, M8-1.25
2	352300	Cleated Guiding Mounting Bracket
3	643874M	Drop -In Tee Bar
4	920893M	Low Head Cap Screw, M6-1.00 x 16 mm

Item	Part Number	Description
5	352301-LLLLL	1" (25mm) Cleated Guide
6	920616M	Socket Head Cap Screw, M6-1.00 x 16 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Guiding Length = 95.25" LLLLL = 09525		

3” (76 mm) Cleated Guiding

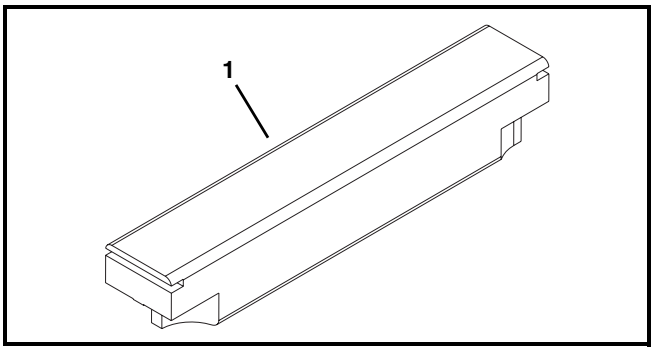


Item	Part Number	Description
1	807-1075	Weld Nut, M8-1.25
2	352300	Cleated Guiding Mounting Bracket
3	643874M	Drop -In Tee Bar
4	920893M	Low Head Cap Screw, M6-1.00 x 16 mm

Item	Part Number	Description
5	352302-LLLLL	3" (76 mm) Cleated Guide
6	920616M	Socket Head Cap Screw, M6-1.00 x 16 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Guiding Length = 95.25" LLLLL = 09525		

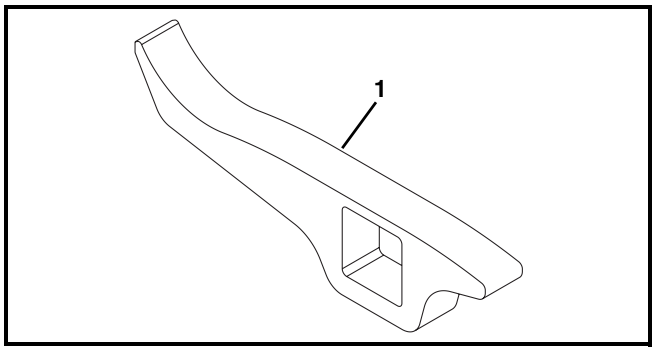
Service Parts

Flat Belt Returns



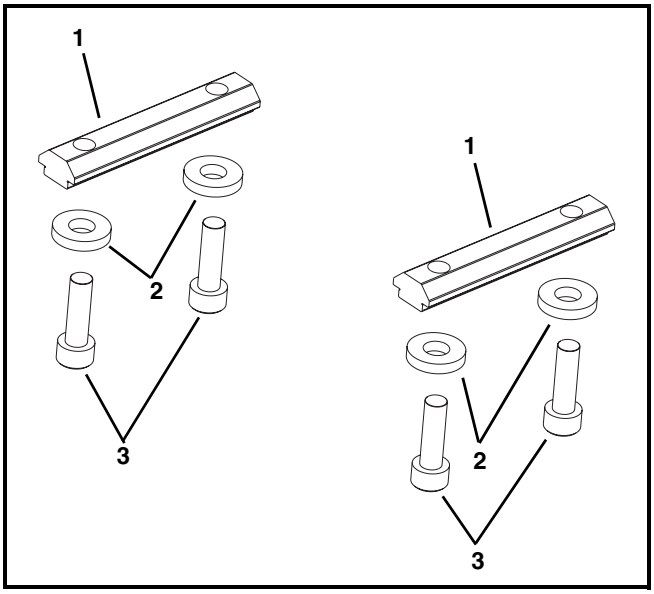
Item	Part Number	Description
1	352120-WW	Returns
WW = Conveyor width ref: 26 - 60 in 02 increments		

High Speed Shoe Kit



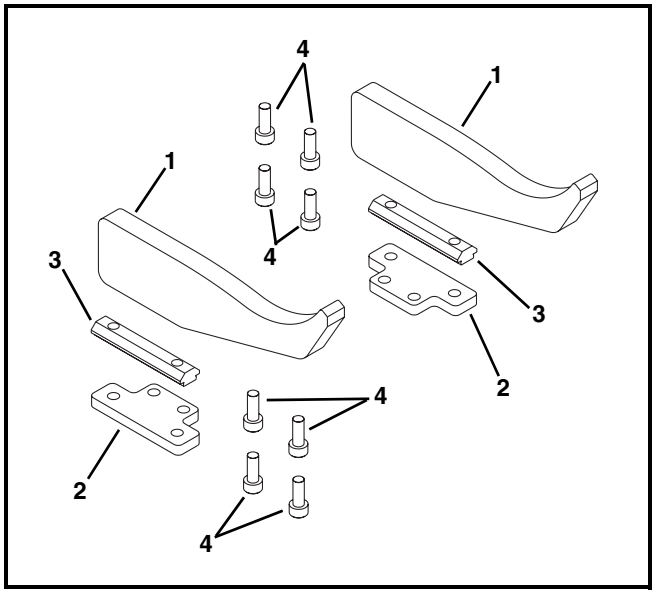
Item	Part Number	Description
1	352316-WW	Shoe kit for straight conveyors
WW = Conveyor width ref: 26 - 60 in 02 increments		

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

LPZ High Speed Shoe Kit



Item	Part Number	Description
1	352338	Shoe Assembly
2	352345	Shoe Plate
3	300150M	Drop-In Tee Bar
4	920616M	Socket Head Screw, M6-1.00 x 16 mm

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:

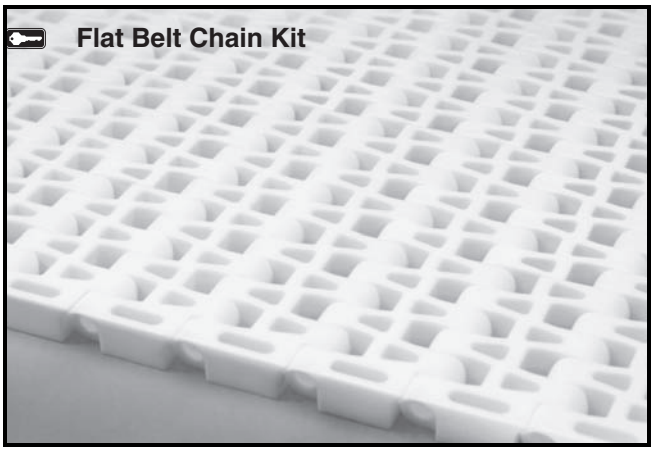
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 52BB-WW

BB = Chain reference number

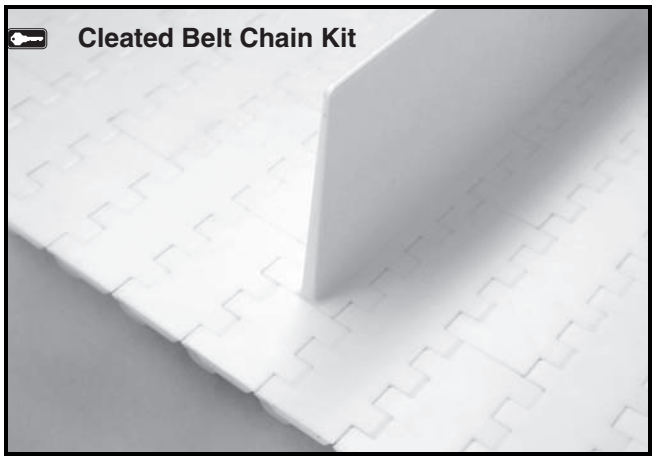
WW = Conveyor width ref: 08-60 in 02 increments

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: 08 - 60 in 02 increments		

Cleated Belt Chain Repair Kit



Item	Part Number	Description
1	52BB-WW	Cleated Belt Chain Repair Kit (Includes cleats on 1 ft (305mm) of belt chain and assembly pins)
BB = Chain Reference number		
WW = Conveyor width ref: 08 - 60 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 (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 to order 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 Team will gladly help with your questions on Dorner products.

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

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

DORNER MFG. CORP.
975 Cottonwood Ave., PO Box 20
Hartland, WI 53029-0020 USA
TEL 1-800-397-8664 (USA)
FAX 1-800-369-2440 (USA)
Internet: www.dorner.com

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

851-629 Rev. C

Printed in U.S.A.