



5200 Series End Drive Conveyors

Installation, Maintenance and Parts Manual



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Introduction

⚠ CAUTION

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

Upon receipt of shipment:

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

The Dorner Limited Warranty applies.

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

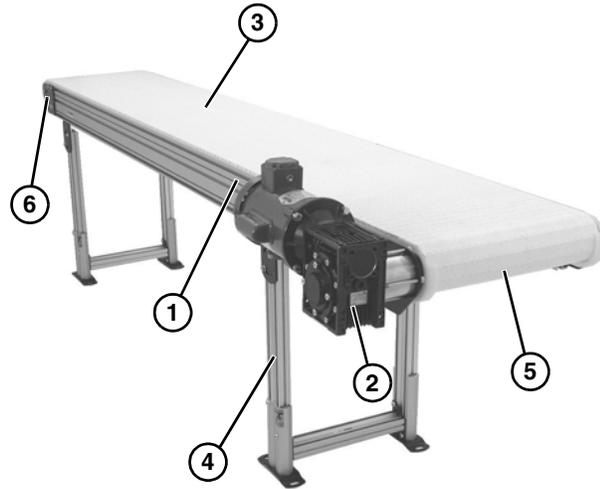
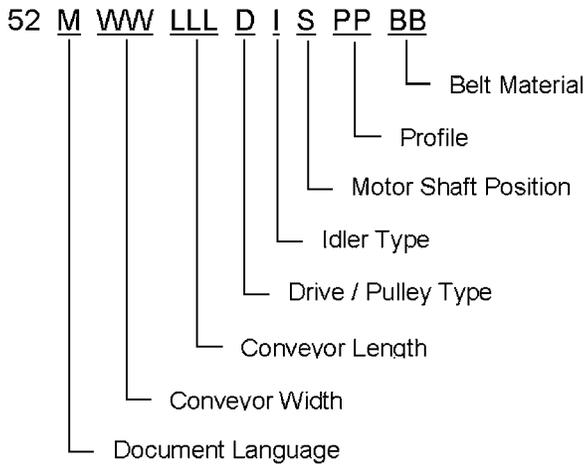


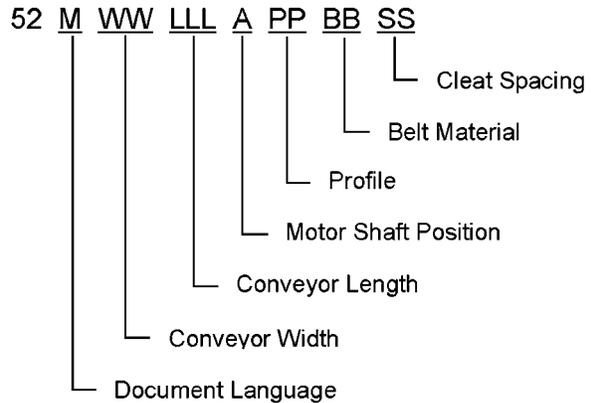
Figure 1

Specifications

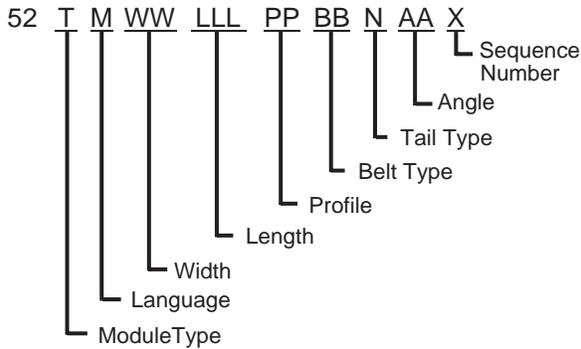
Flat Belt Straight 5200 Series Conveyor



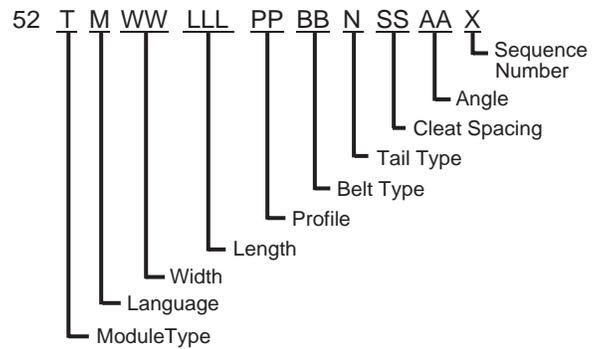
Cleated Belt Straight 5200 Series Conveyor



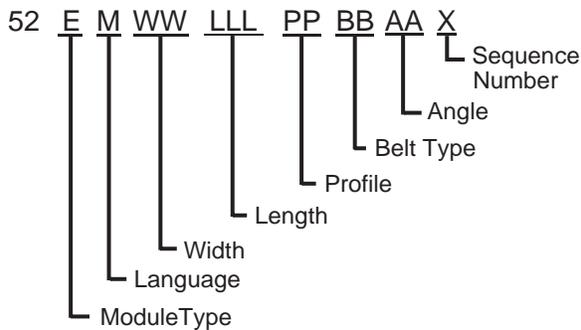
Flat Belt LPZ 5200 Series Conveyor (Infeed Section to Knuckle)



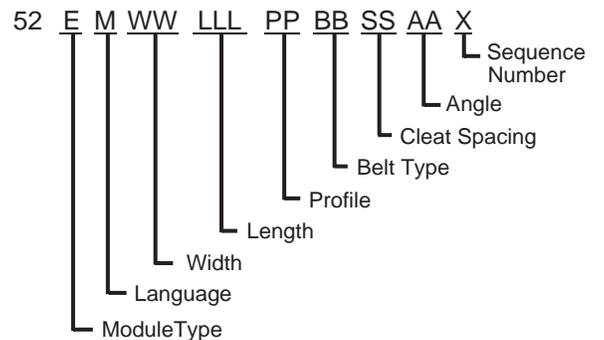
Cleated Belt LPZ 5200 Series Conveyor (Infeed Section to Knuckle)



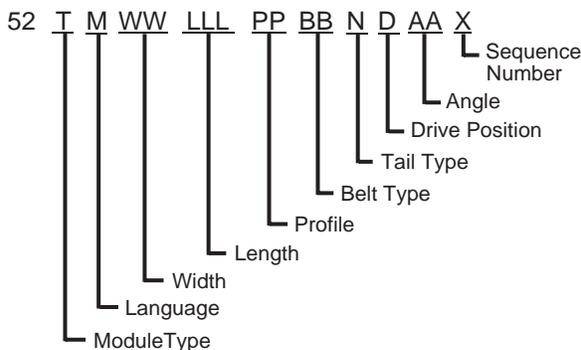
Flat Belt LPZ 5200 Series Conveyor (Mid Section Between Knuckles)



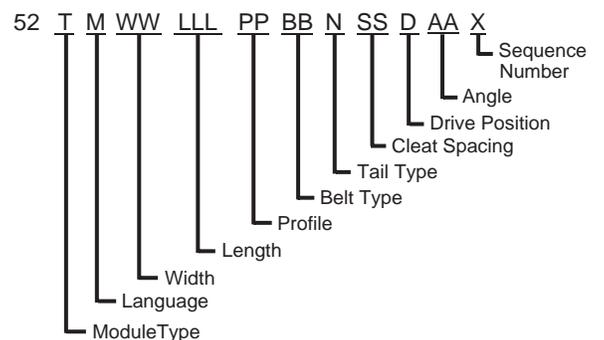
Cleated Belt LPZ 5200 Series Conveyor (Mid Section Between Knuckles)



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



Cleated Belt LPZ 5200 Series Conveyor (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.

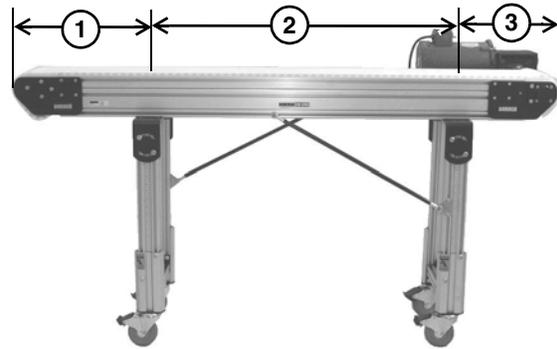


Figure 2

Specifications

Conveyor Width Reference (<u>WW</u>)	08 - 60 in 02 increments
Conveyor Belt Width	8" (203 mm) - 60" (1524 mm) in 2" (51 mm) increments
LPZ Conveyor Width Reference (<u>WW</u>)	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 (<u>LLL</u>)	036 - 999 in 001 increments
Conveyor Length	36" (914 mm) - 999" (25.4 m) in 1" (25 mm) increments
LPZ Section Length (<u>LLL</u>)	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.

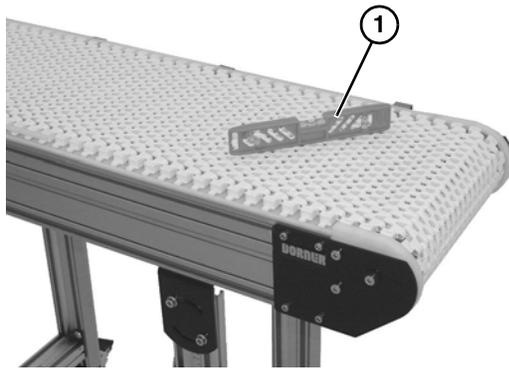


Figure 3

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

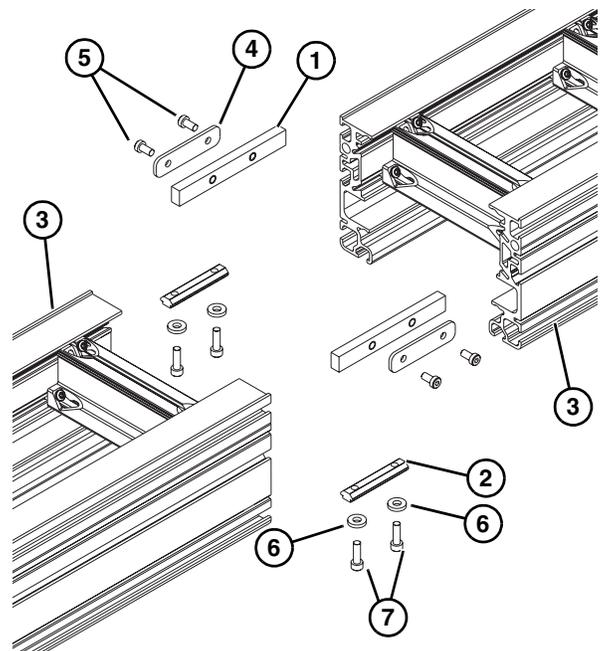


Figure 4

1. 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).
2. 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).
3. 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.)

Installation

NOTE

The stop plate (Figure 5, item 1) on the center wear strip (Figure 5, item 2) faces the drive end (Figure 5, item 3) of the conveyor.

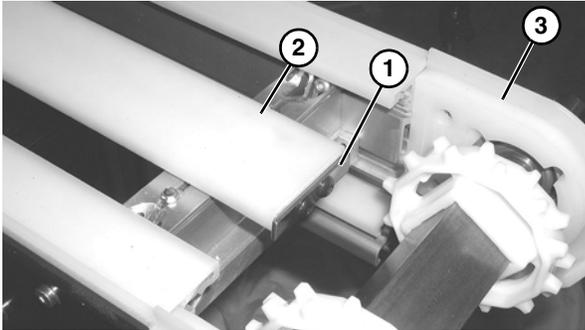


Figure 5

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 capscrews (Figure 6, item 1) on each side of upper knuckle assembly (Figure 6, item 2), and sliding T-Nuts into straight frame section (Figure 6, item 3).

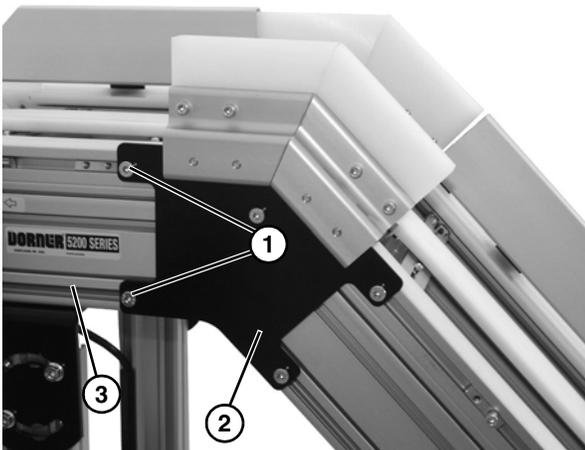


Figure 6

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

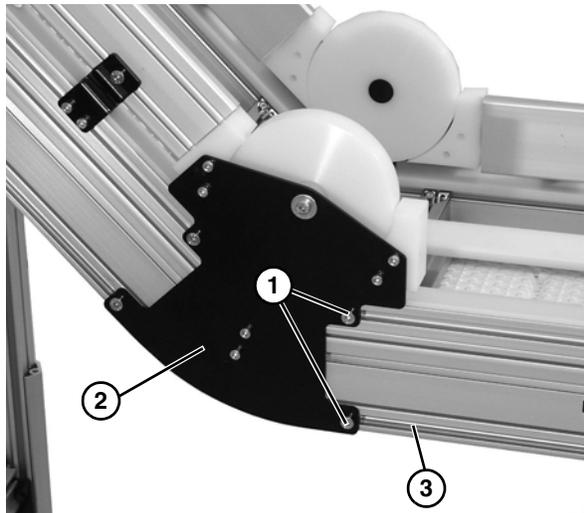


Figure 7

3. Tighten all socket head capscrews 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 8)

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

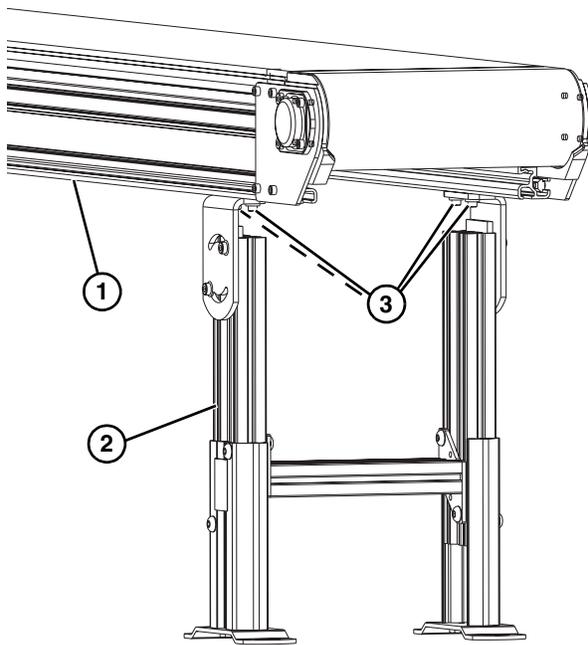


Figure 8

1. Properly support the conveyor.
2. Attach stands (Figure 9, item 1) to the bottom of the conveyor frame (Figure 9, item 2). Tighten socket head screws (Figure 9, item 3), on each side, to secure in place.

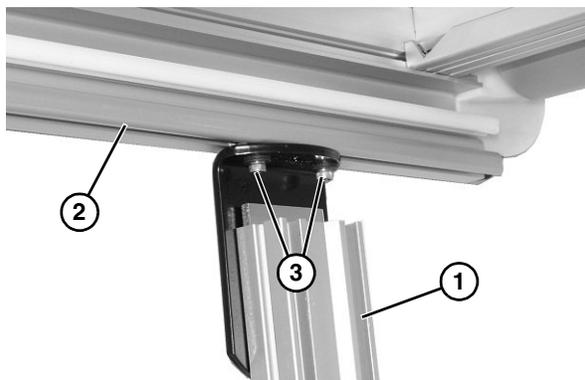


Figure 9

Belt Installation

Typical Belt Components (Figure 10)

1	Chain Belt
2	Belt Rod

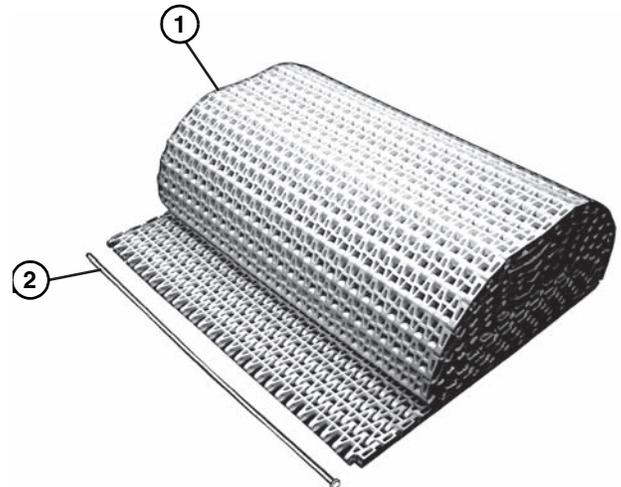


Figure 10

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

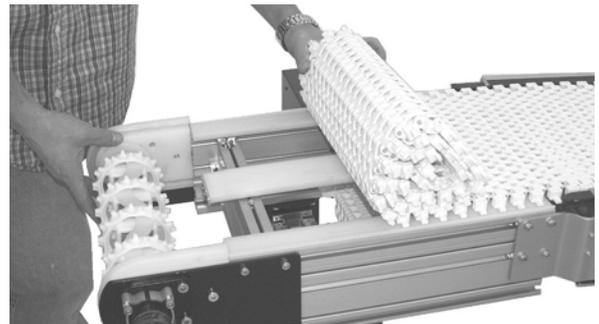


Figure 11

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

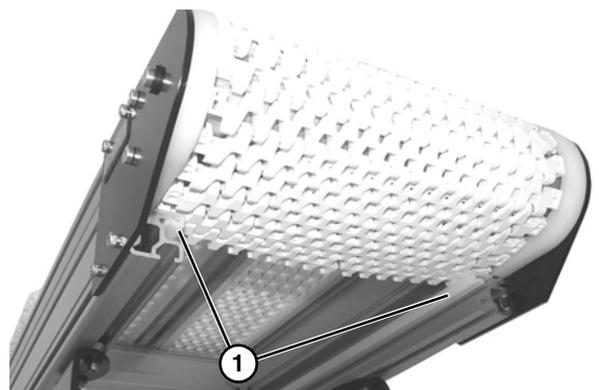


Figure 12

Installation

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.

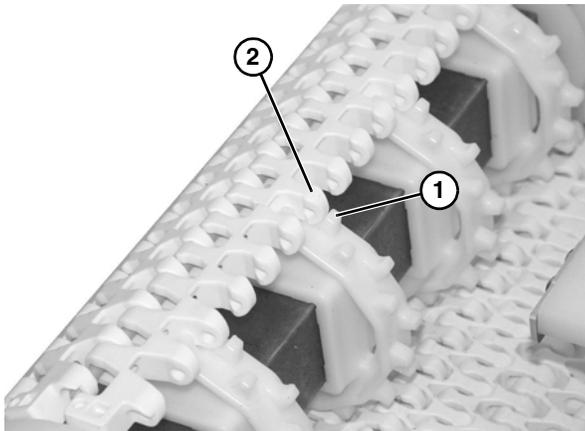


Figure 13

5. Bring the ends of the belt together (**Figure 14**).

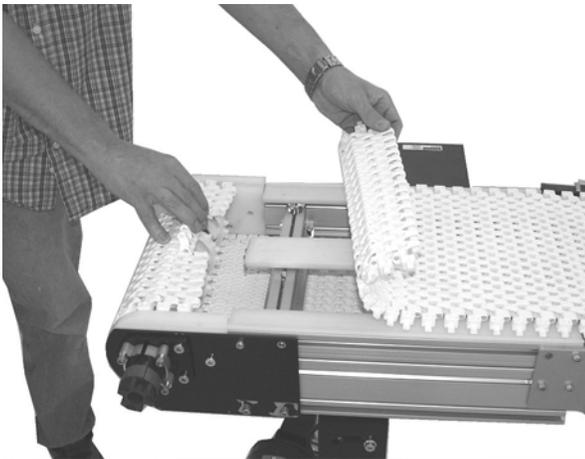


Figure 14

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

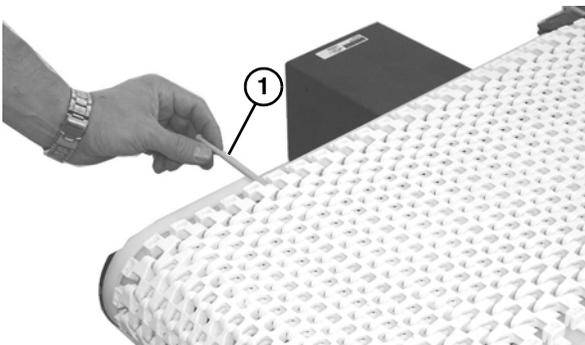


Figure 15

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 16, item 1**) to the gear reducer (**Figure 16, item 2**).

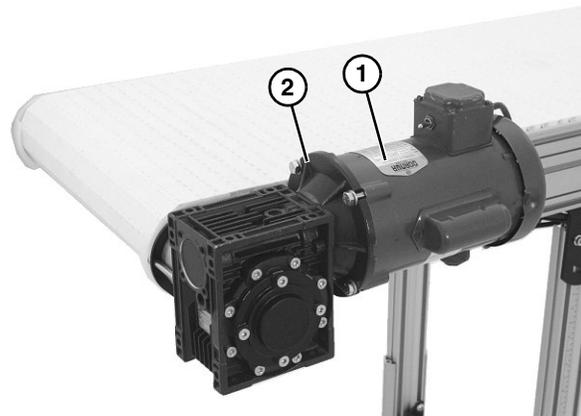


Figure 16

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 17, 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.

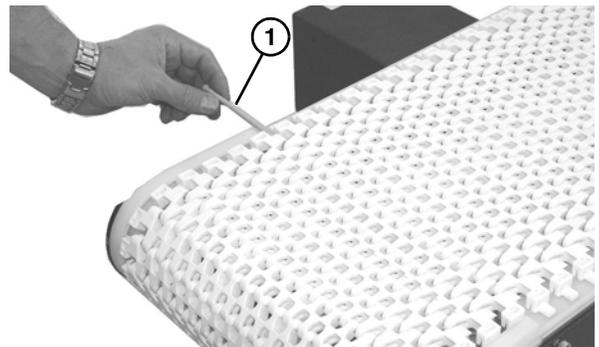


Figure 17

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 18, item 1) out by striking the rod end opposite the retaining head.

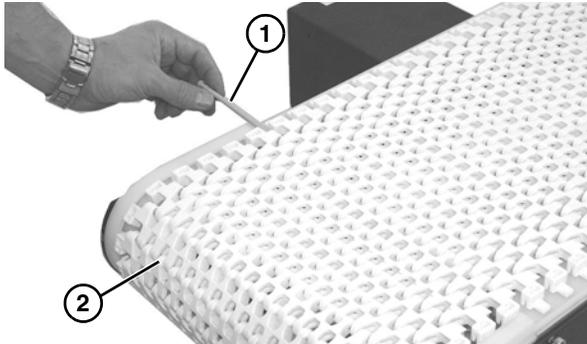


Figure 18

2. Slide the old belt (Figure 18, 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 11.

Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips (Figure 19)

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

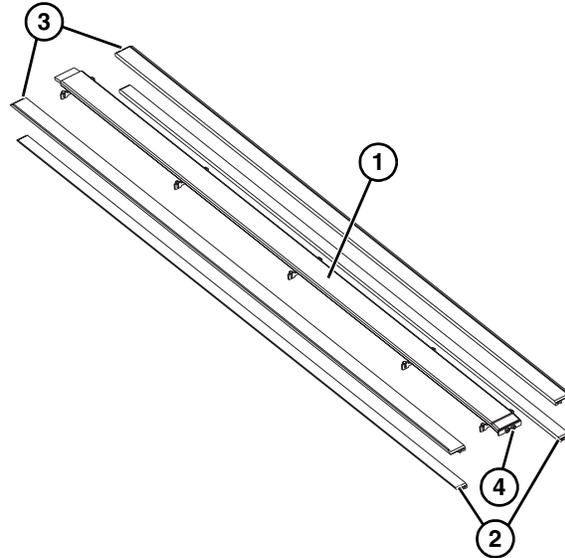


Figure 19

Removal

1. Remove upper wear strips (Figure 20, item 1) from top of frame assembly.

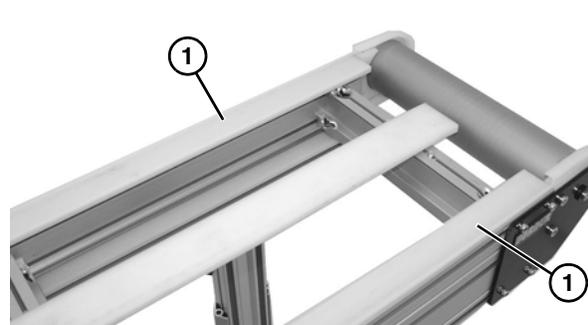


Figure 20

Preventive Maintenance and Adjustment

2. Remove lower wear strips (**Figure 21, item 1**), and if necessary, lower belt return (**Figure 21, item 2**) from lower frame assembly.

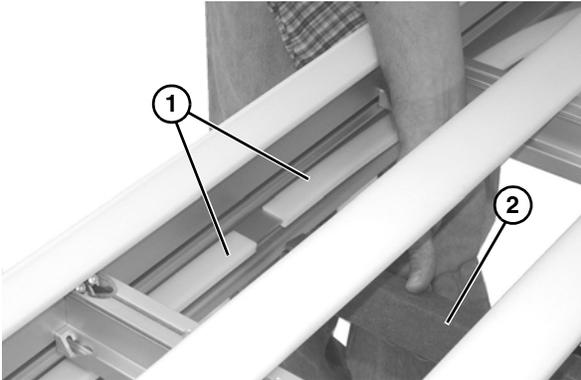


Figure 21

3. Remove two screws (**Figure 22, item 1**) from each clamp on center frame channel.

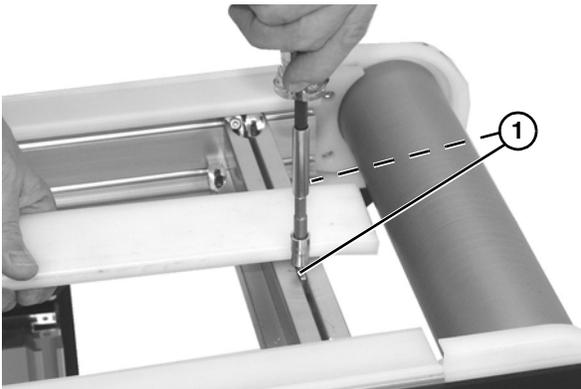


Figure 22

4. Remove center frame channel (**Figure 23, item 1**), making sure to keep each clamp matched with channel of each cross member (**Figure 23, item 2**).

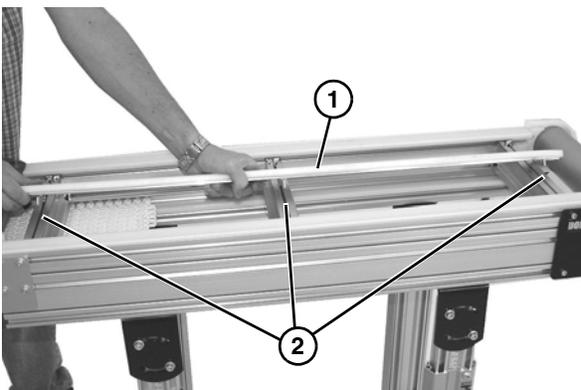


Figure 23

5. Remove the center wear strip (**Figure 24, item 1**) from the center frame channel (**Figure 24, item 2**).

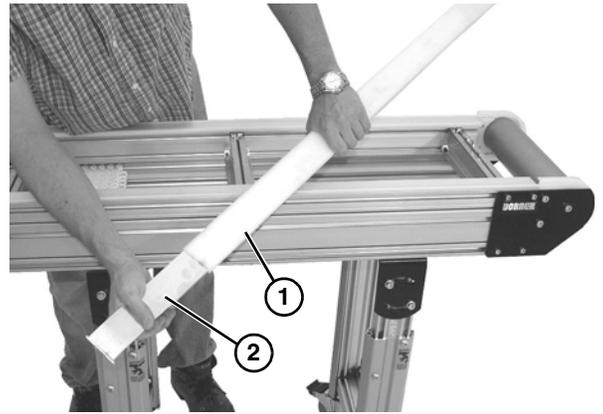


Figure 24

Installation

NOTE

The stop plate (**Figure 25, item 1**) on the center wear strip (**Figure 25, item 2**) faces the drive end (**Figure 25, item 3**) of the conveyor.

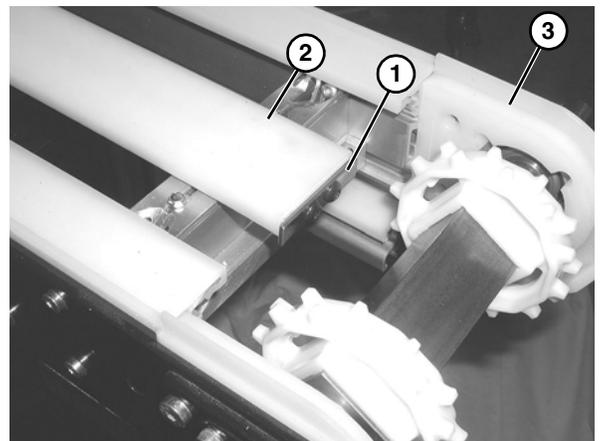


Figure 25

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 – 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 26, item 1**). Repeat on opposite side.

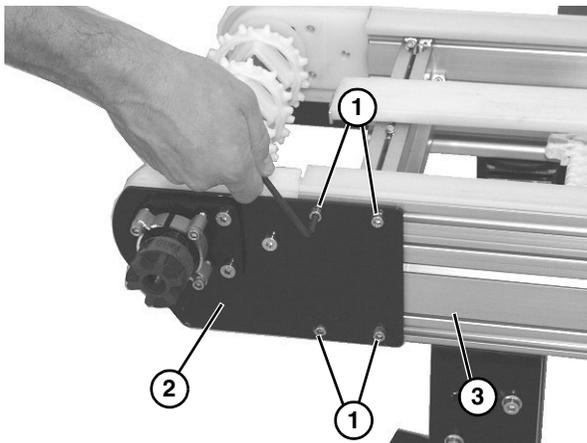


Figure 26

3. Remove the drive tail assembly (**Figure 26, item 2**) from the frame (**Figure 26, item 3**).
4. Loosen set screw (**Figure 27, item 1**) and remove coupling (**Figure 27, item 2**).

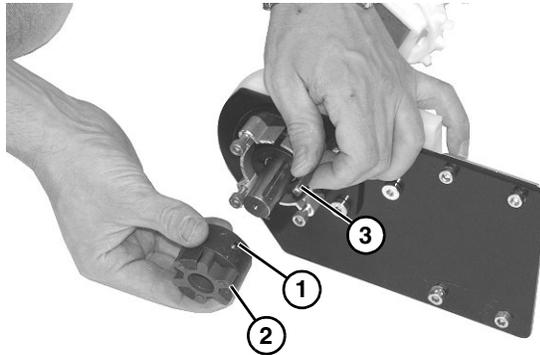


Figure 27

5. Remove key (**Figure 27, item 3**).
6. Remove four socket head screws (**Figure 28, item 1**) and drive guards (**Figure 28, item 2**).

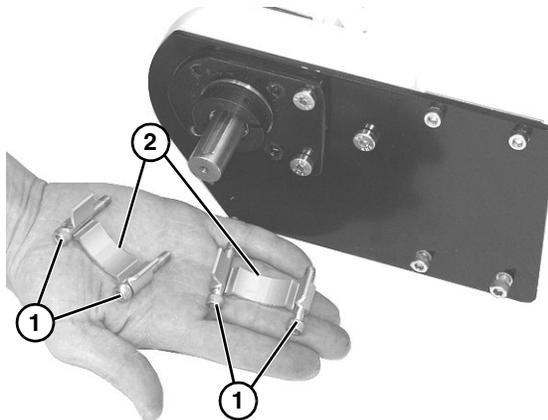


Figure 28

7. Loosen the bearing collar set screw (**Figure 29, item 1**) and remove bearing collar (**Figure 29, item 2**).

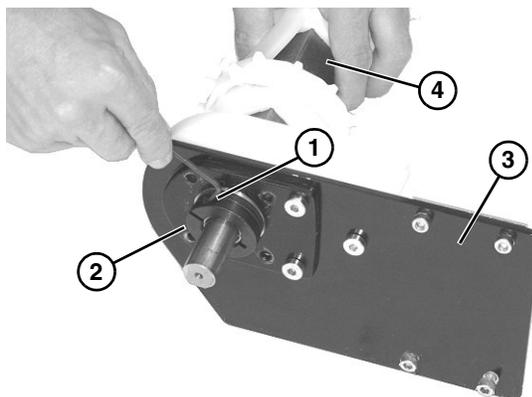


Figure 29

8. Remove plate (**Figure 29, item 3**) from drive spindle (**Figure 29, item 4**).

Preventive Maintenance and Adjustment

9. Remove retaining clip (**Figure 30, item 1**) and flanged puck (**Figure 30, item 2**) from drive spindle.

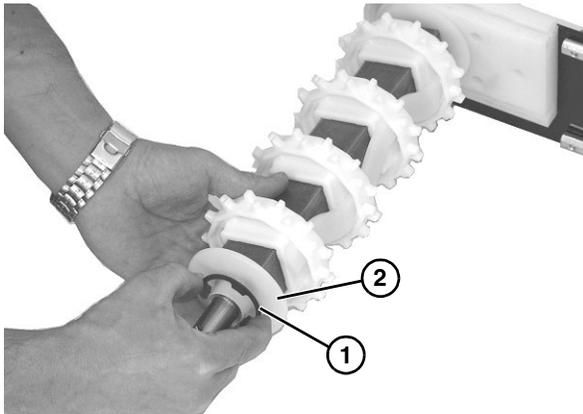


Figure 30

10. Slide entire sprocket assembly slightly outward, and remove the first sprocket (**Figure 31, item 1**) off the drive spindle and alignment bar (**Figure 31, item 2**).

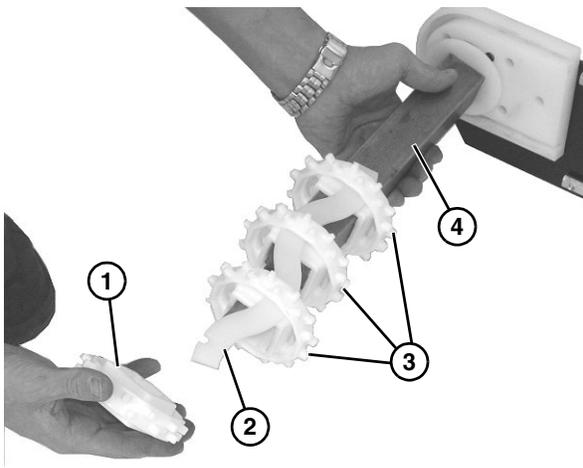


Figure 31

11. Remove remaining sprockets (**Figure 31, item 3**) off the alignment bar as you slide entire assembly off the drive spindle (**Figure 31, item 4**).
12. To assemble sprockets onto drive spindle, slide one sprocket (**Figure 32, item 1**) onto alignment bar (**Figure 32, item 2**) and slide assembly onto drive spindle (**Figure 32, item 3**).

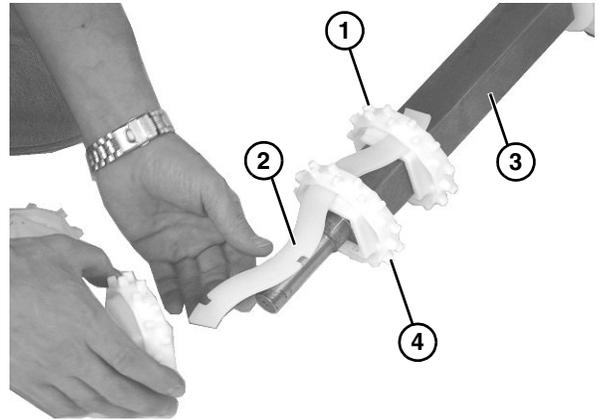


Figure 32

13. Install second sprocket (**Figure 32, item 4**) and subsequent sprockets one by one, while sliding entire assembly onto alignment bar and spindle.
14. Check drive terminal assembly (**Figure 33, item 1**) for wear. If worn, remove three low head cap screws (**Figure 33, item 2**) and replace.

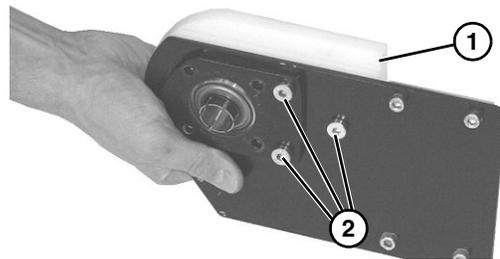


Figure 33

NOTE

*When reinstalling the drive spindle tail assembly, the terminal assembly (**Figure 34, item 1**) should mate flush with the conveyor frame (**Figure 34, item 2**).*

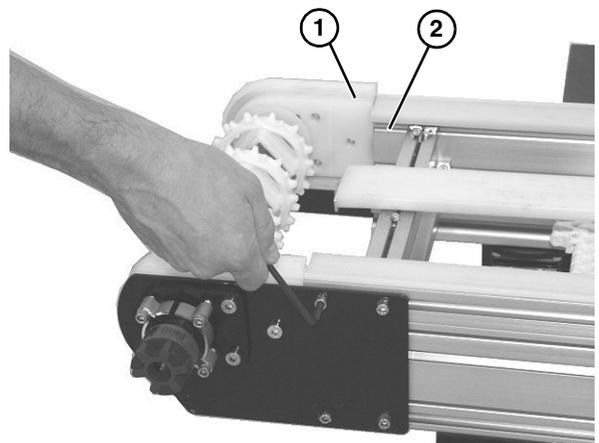


Figure 34

Preventive Maintenance and Adjustment

B – Idler Spindle Removal

1. Be sure the conveyor is supported.
2. On one side of conveyor, loosen the four socket head screws (**Figure 35, item 1**). Repeat on opposite side.

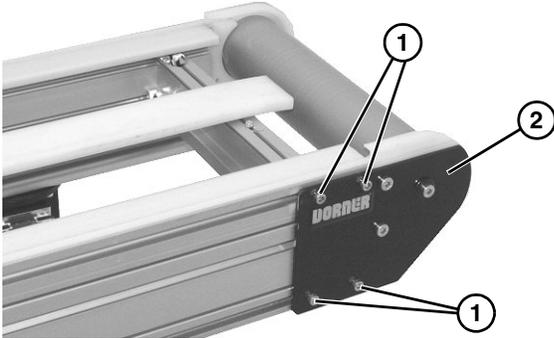


Figure 35

3. Remove idler tail assembly (**Figure 35, item 2**).
4. Remove socket head screw (**Figure 36, item 1**) from plate (**Figure 36, item 2**) and center of spindle shaft (**Figure 36, item 3**). Repeat procedure on opposite side.

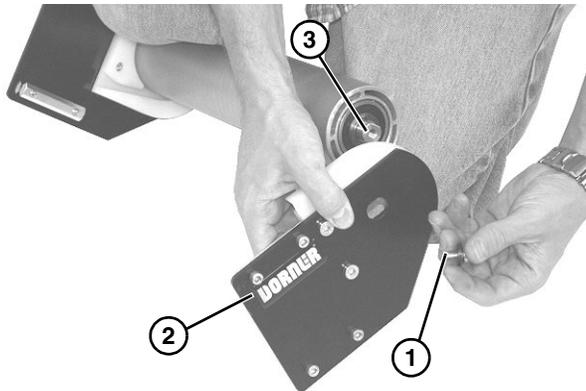


Figure 36

5. Remove the spindle shaft assembly: remove the clip ring (**Figure 37, item 1**) and washer (**Figure 37, item 2**) from one side of the spindle assembly.

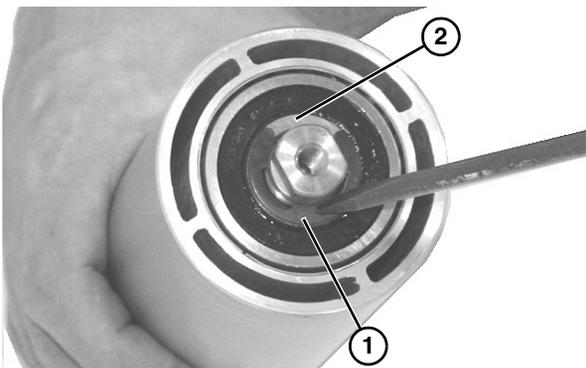


Figure 37

6. Slide the shaft assembly (**Figure 38, item 1**) out of the pulley (**Figure 38, item 2**).

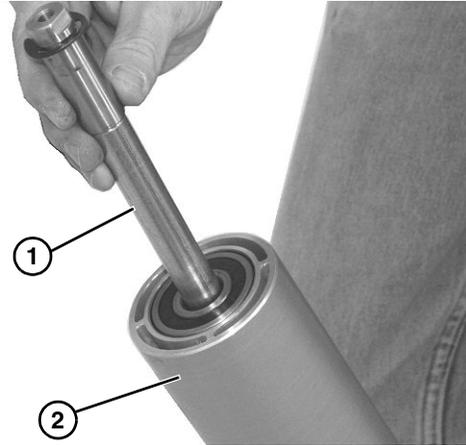


Figure 38

7. Check idler terminal assembly (**Figure 39, item 1**) for wear. If worn, remove two low head cap screws (**Figure 39, item 2**) and replace.

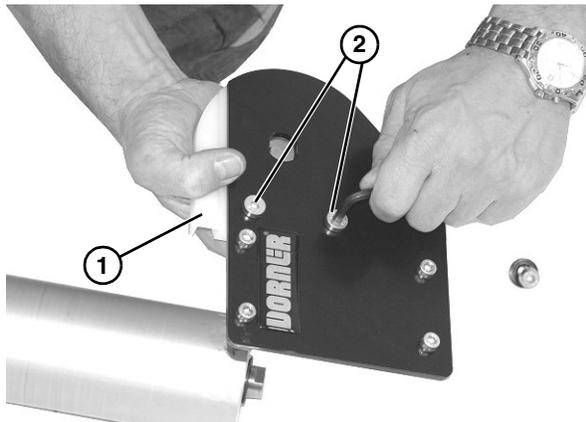


Figure 39

NOTE

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

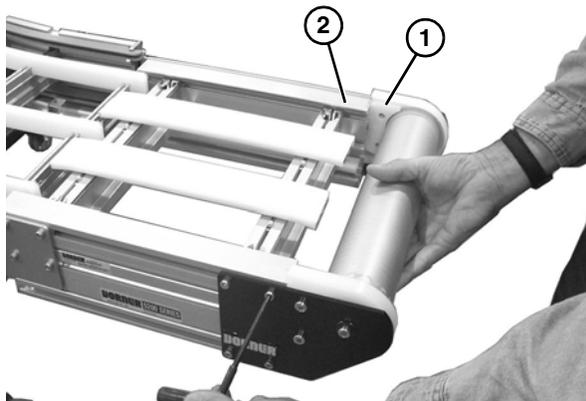


Figure 40

Preventive Maintenance and Adjustment

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

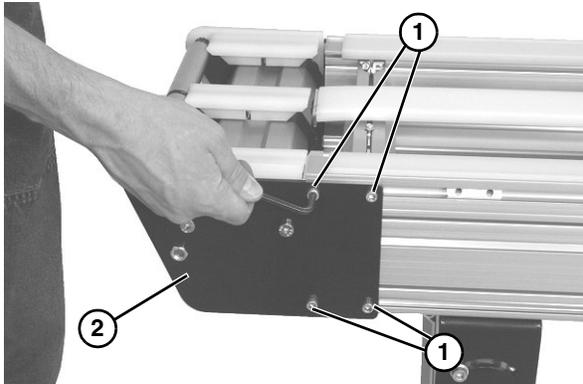


Figure 41

3. Remove idler tail assembly (**Figure 41, item 2**).
4. Remove two low head cap screws (**Figure 42, item 1**) from plate (**Figure 42, item 2**). Repeat procedure on opposite side.

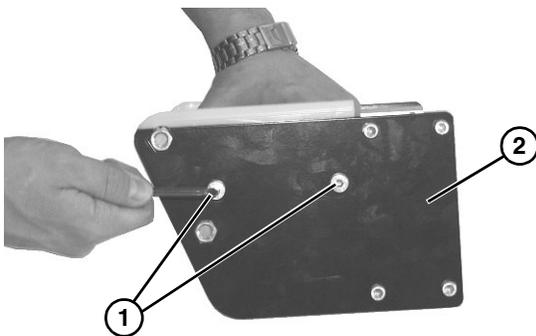


Figure 42

5. Remove upper nut (**Figure 43, item 1**) and spacer from end of axle shaft assembly.

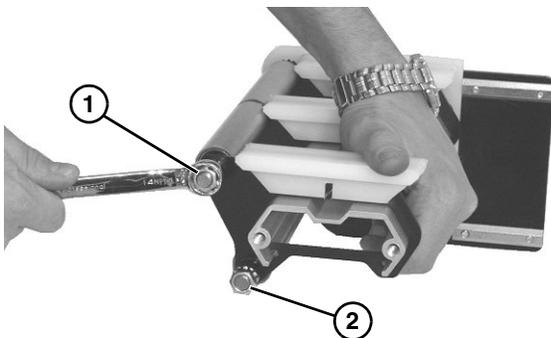


Figure 43

6. Remove lower nut (**Figure 43, item 2**) and spacer from lower axle shaft assembly.
7. Slide the support plate (**Figure 44, item 1**) off of both axle shafts.

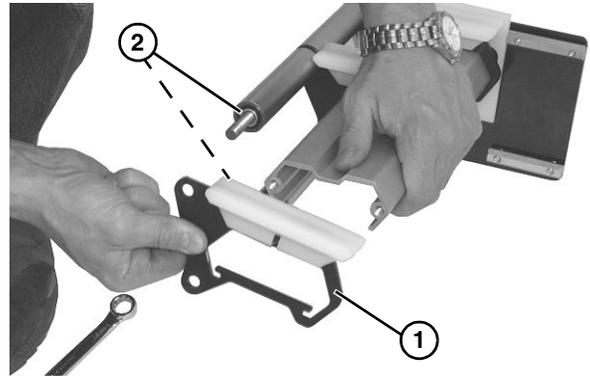


Figure 44

8. Remove washer (**Figure 44, item 2**) off of lower and upper axle shafts.
9. Remove roller assembly (**Figure 45, item 1**) and washer (**Figure 45, item 2**) from axle shaft (**Figure 45, item 3**).

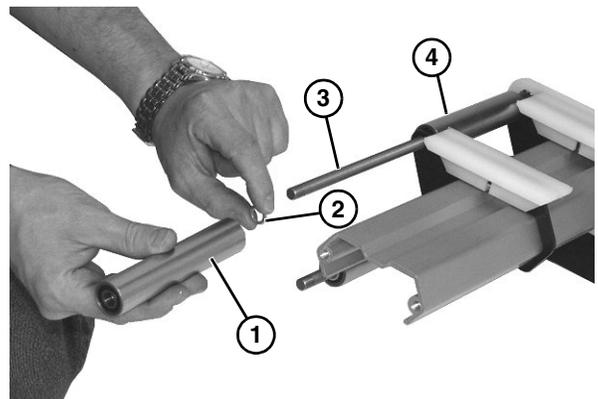


Figure 45

10. Remove remaining roller assembly components (**Figure 45, item 4**) on opposite side.
11. Check idler terminal assembly on each side (**Figure 46, item 1**) for wear. If worn, replace.

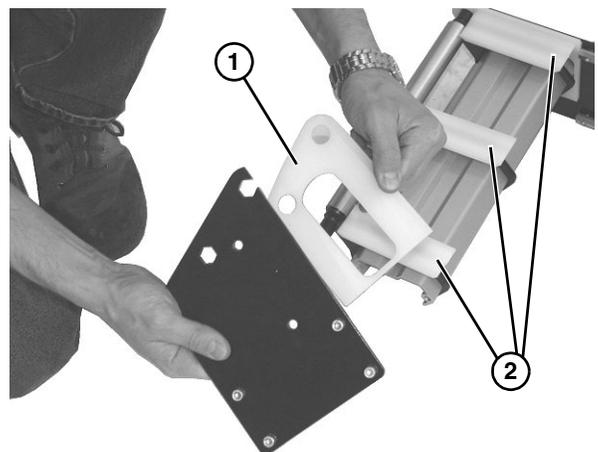


Figure 46

12. Remove and replace wear guides (**Figure 46, item 2**) if worn. When replacing, secure onto pins on each support plate.

Preventive Maintenance and Adjustment

NOTE

When reinstalling the idler spindle tail assembly, the idler terminal assembly (**Figure 47, item 1**) should mate flush with the conveyor frame (**Figure 47, item 2**).

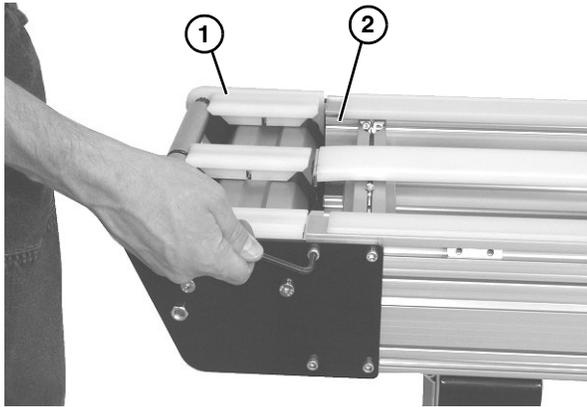


Figure 47

Spindle Replacement

Drive Spindle

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

Idler Spindle

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

Nose Bar Idler Spindle

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

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 48, item 1**) to align with slots (**Figure 48, item 2**) in bearing housing. Then remove bearing.

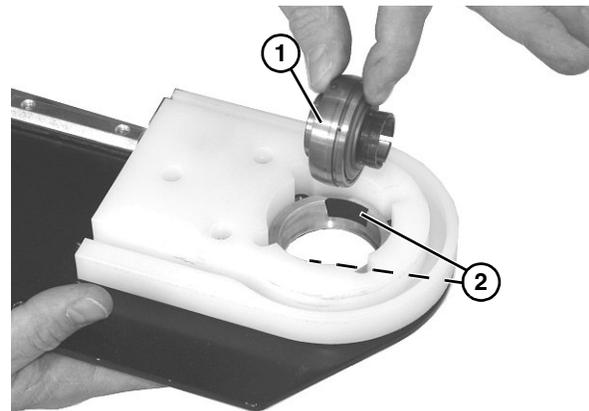


Figure 48

Replacement

1. Inspect bearing housing bearing surface. If worn or damaged, replace. See "Service Parts" on page 20.
2. Insert bearing (**Figure 49, item 1**) into housing slot: Locate anti-rotation nub (**Figure 49, item 2**) to align with slot (**Figure 49, item 3**), and twist bearing into housing.

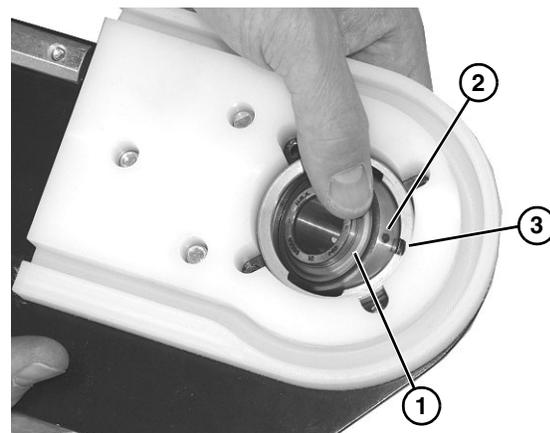


Figure 49

Preventive Maintenance and Adjustment

Maintenance of Knuckles

Lower Knuckle

1. Remove cap screw (**Figure 50, item 1**), washer, and spacer on side of lower knuckle assembly (**Figure 50, item 2**), and remove hold down guide (**Figure 50, item 3**). Repeat on opposite side.

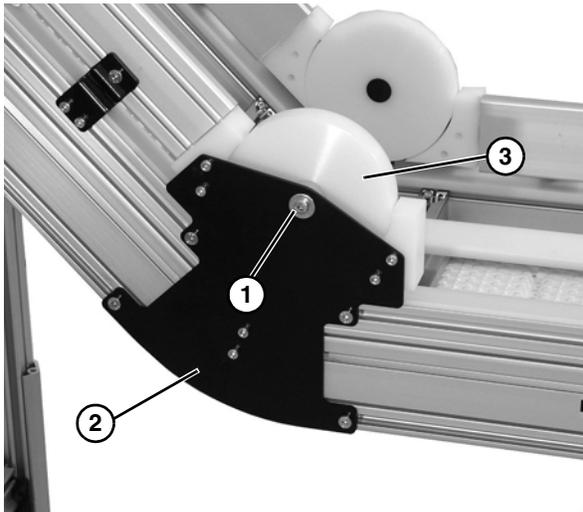


Figure 50

2. Remove two socket cap screws (**Figure 51, item 1**) for all four hold down guards (**Figure 51, item 2**) on side of lower knuckle assembly (**Figure 51, item 3**).

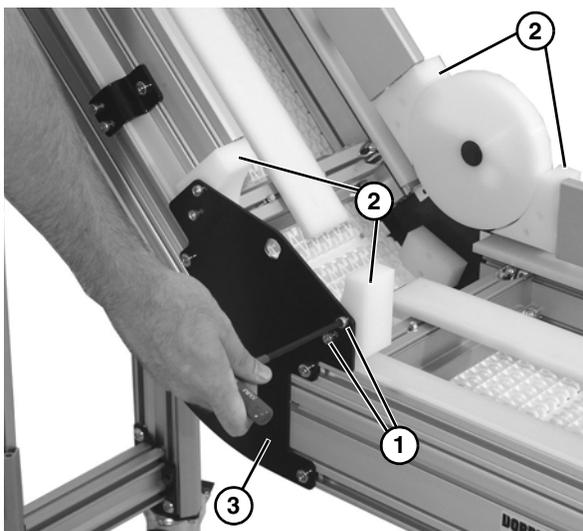


Figure 51

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

Upper Knuckle

1. Remove socket head cap screw (**Figure 52, item 1**), on each side of upper knuckle assembly, and remove shaft and sprocket assembly (**Figure 52, item 2**).

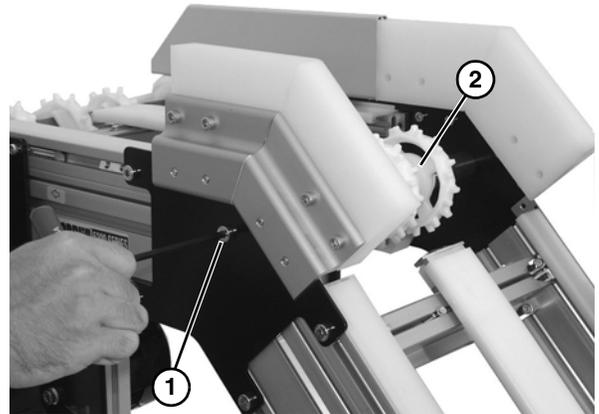


Figure 52

2. Remove three sprockets (**Figure 53, item 1**) off of shaft (**Figure 53, item 2**).

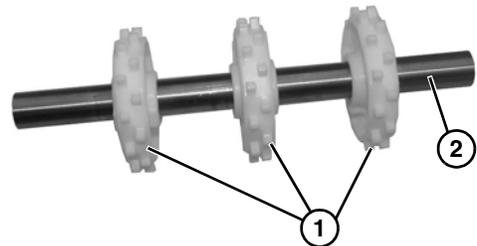


Figure 53

3. Remove socket cap screw (**Figure 54, item 1**) for each belt guide (**Figure 54, item 2**) on side of upper knuckle assembly. Repeat on opposite side.

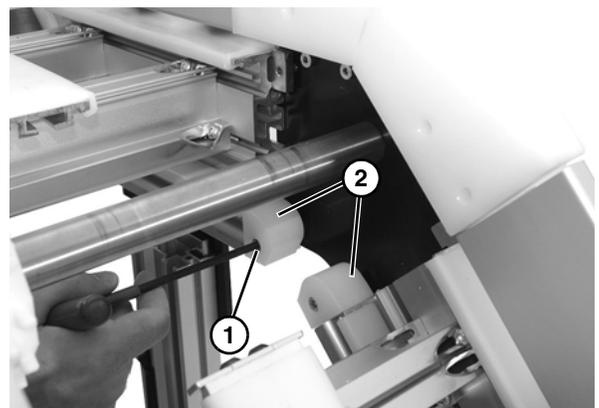


Figure 54

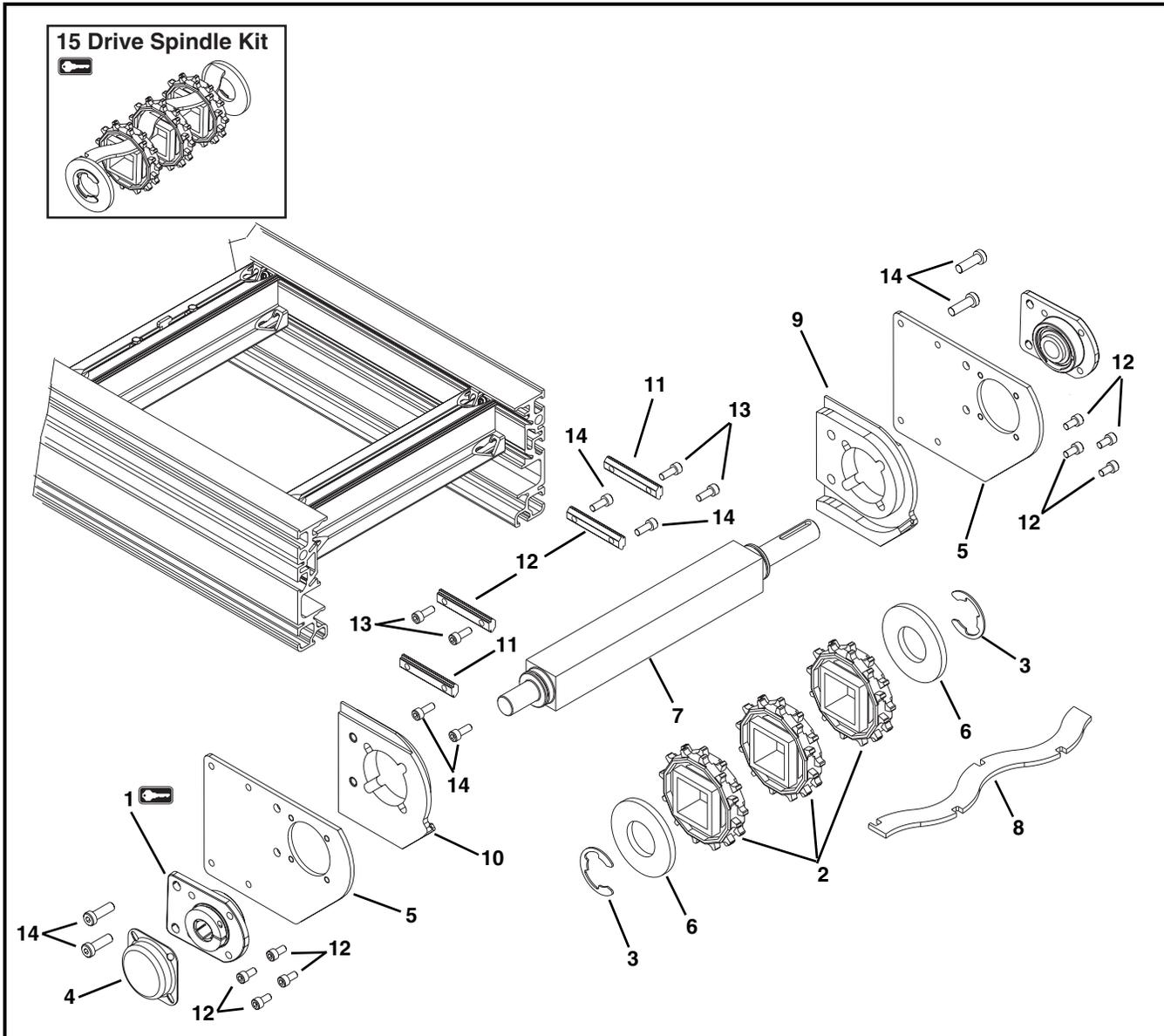
4. Replace parts as necessary.
5. Install parts reverse of removal.

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.

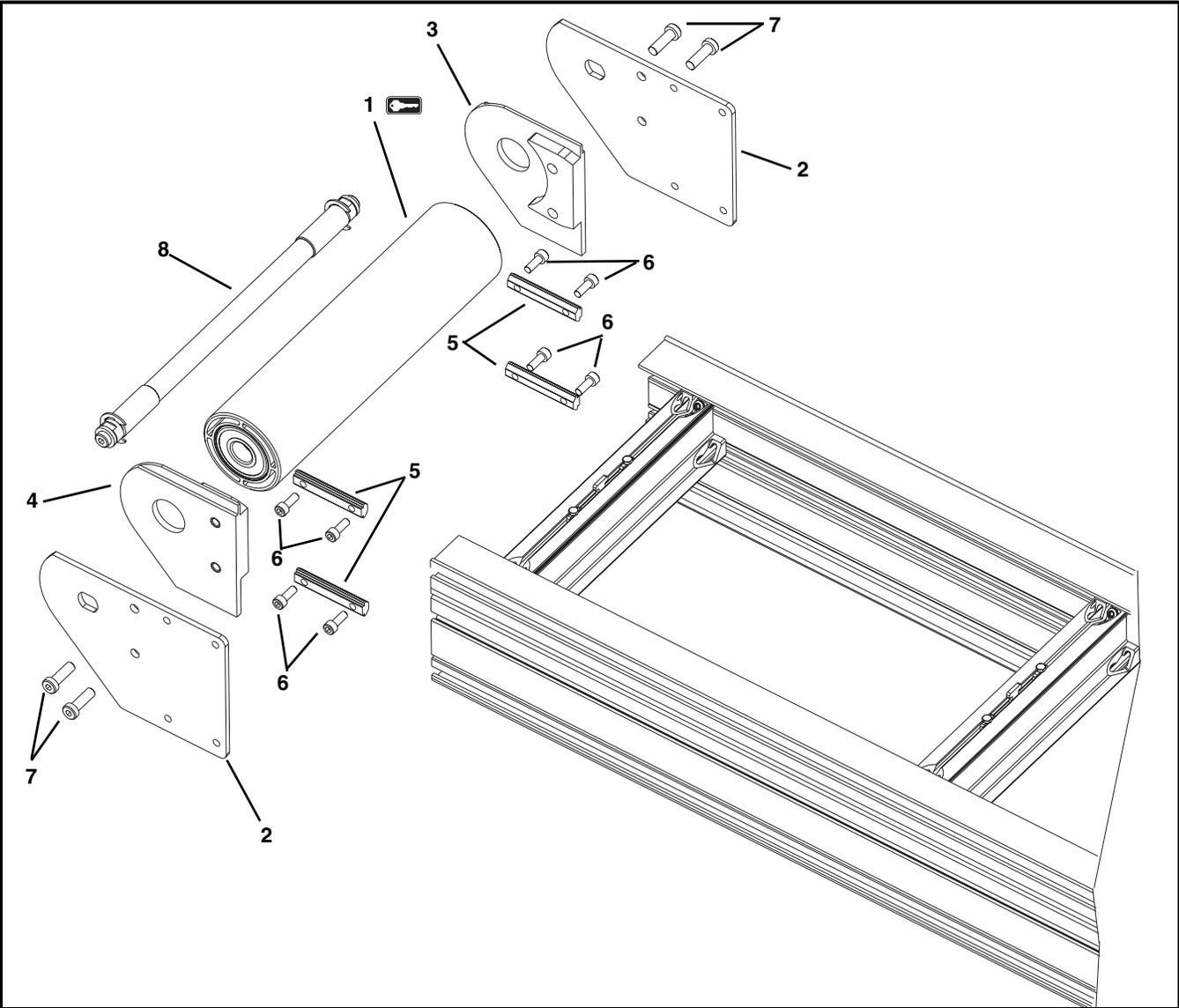
Drive End Components



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- <u>WW</u>	Drive Spindle
8	352113- <u>WW</u>	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- <u>WW</u>	Drive Spindle Kit (Includes Items 2, 3, 6 and 8)
		<u>WW</u> = Conveyor width reference: 08 – 60 in 02 increments

Idler End Components

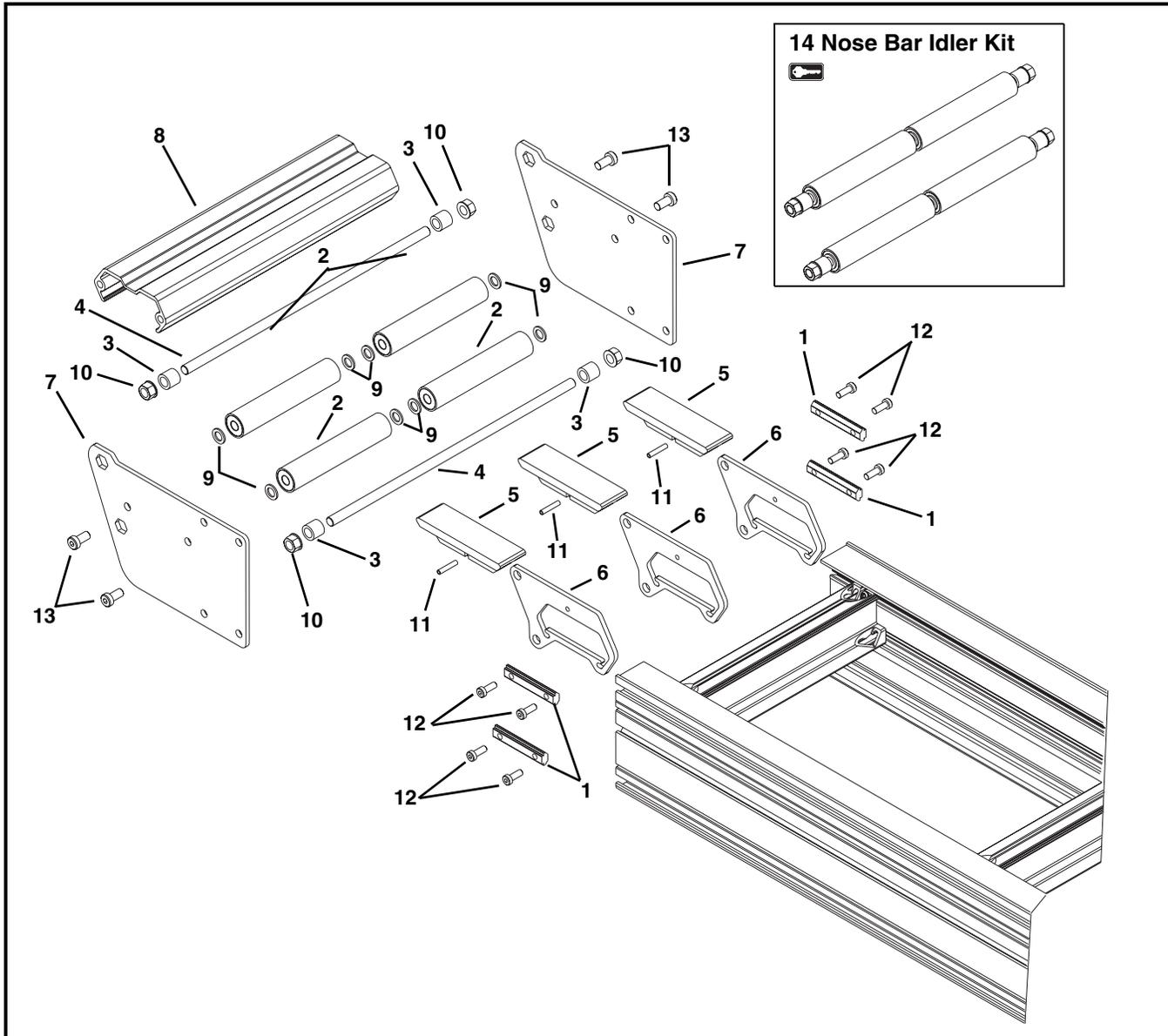


Item	Part Number	Description
1 	352011- <u>WW</u>	Idler Pulley Assembly
2	352110	Cover Plate
3	352123	Idler Terminal Assembly Left Hand
4	352124	Idler Terminal Assembly Right Hand

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- <u>WW</u>	Idler Wand Assembly
<u>WW</u> = Conveyor width reference: 08 – 60 in 02 increments		

Service Parts

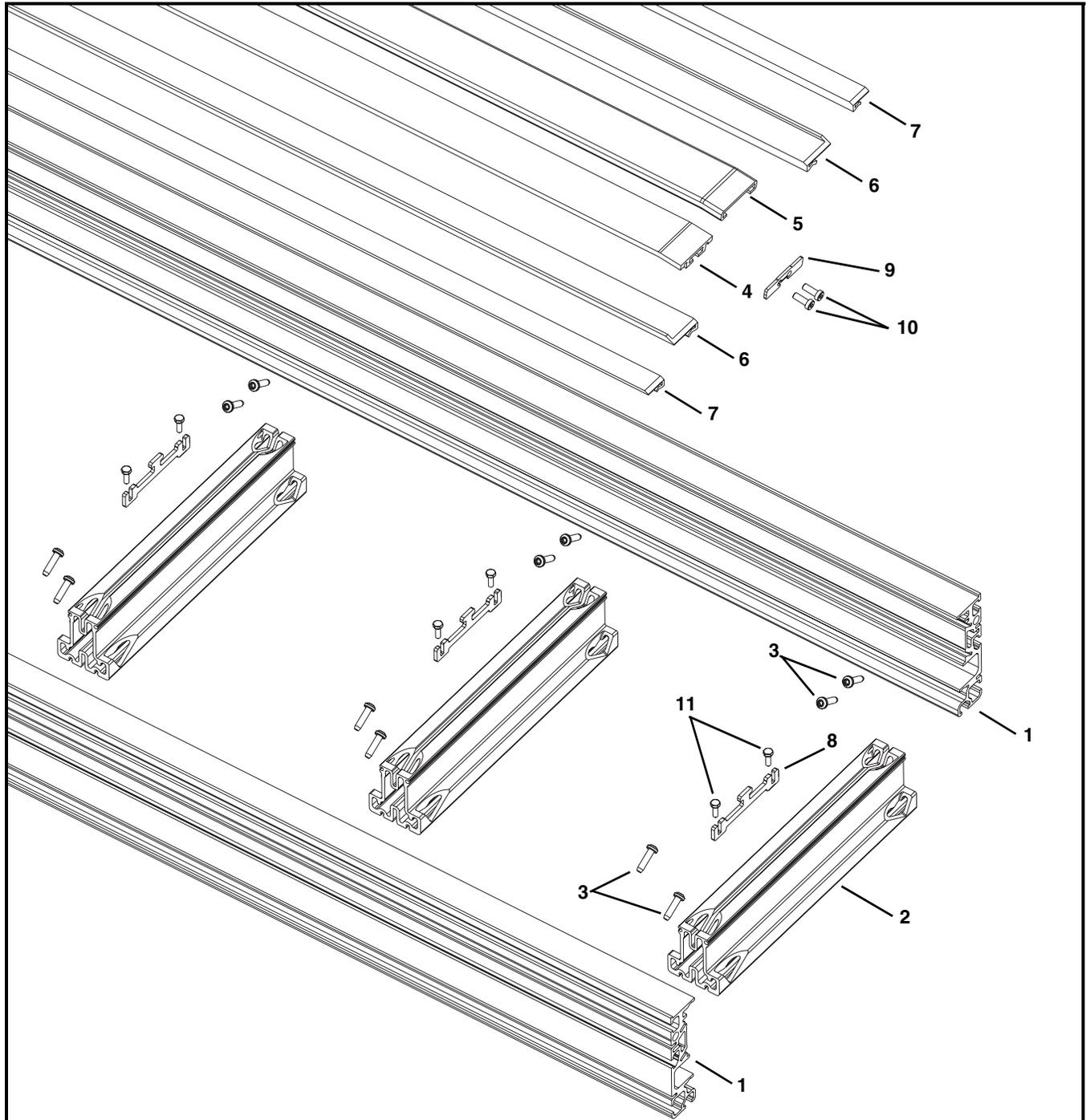
Nose Bar Idler End Components



Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	352013- <u>WW</u>	Roller Assembly
3	352125	Spacer
4	352126- <u>WW</u>	Axle Shaft
5	352128	Wear Guide
6	352146	Support Plate
7	352149	Cover Plate
8	352151- <u>WW</u>	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- <u>WW</u>	Nose Bar Idler Kit (Includes Items 2,3,4,9,10 and 13)
<u>WW</u> = Conveyor width reference: 08 – 60 in 02 increments		

Frame Assembly

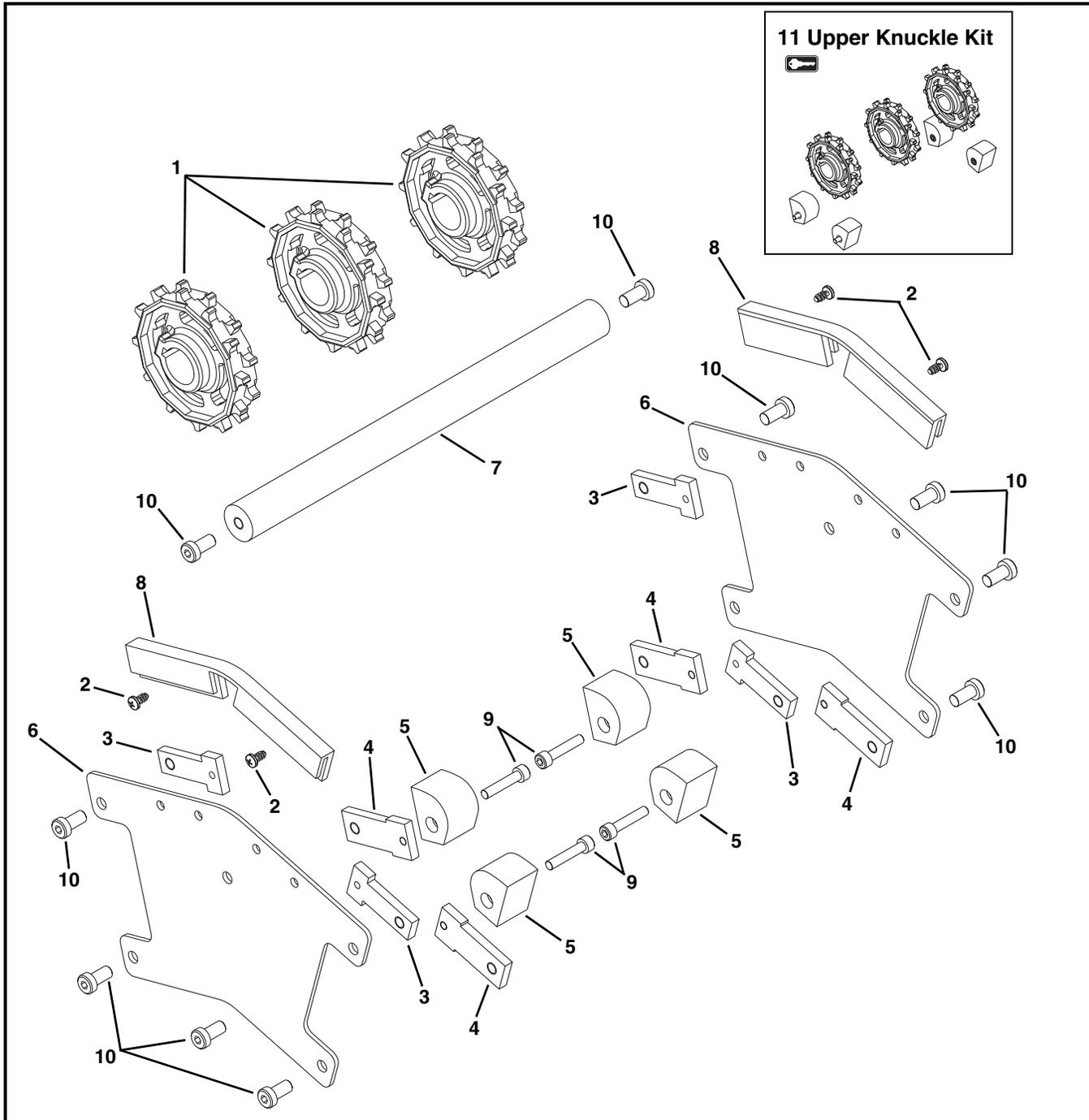


Item	Part Number	Description
1	352100- <u>LLLLL</u>	Side Rail
2	352101- <u>WW</u>	Cross Support Rail
3	352108	Pan Screw, M5-.80 x 20 mm
4	352102- <u>LLLLL</u>	Center Bed Rail
5	352103- <u>LLLLL</u>	Center Wearstrip
6	352104- <u>LLLLL</u>	Top Wearstrip
7	352105- <u>LLLLL</u>	Return Wearstrip
8	352106	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 – 60 in 02 increments <u>LLLLL</u> = Length in inches with 2 decimal places. Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

Service Parts

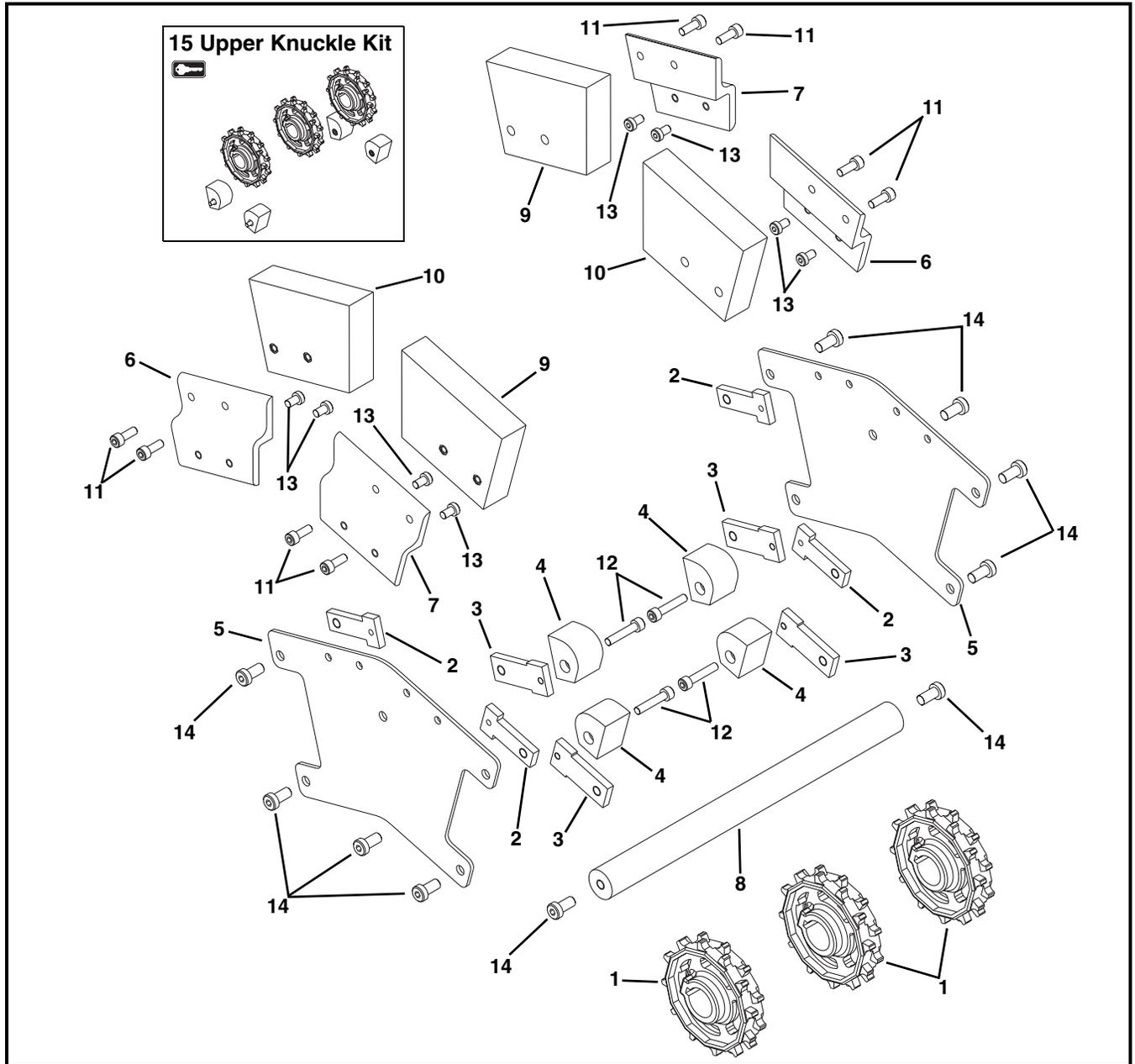
Upper Knuckle - Low Side



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- <u>AA</u>	Side Plate
7	352336- <u>WW</u>	Shaft
8	352341- <u>AA</u>	Lowside guide

Item	Part Number	Description
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- <u>WW</u>	Upper Knuckle Kit (Includes Items 1, 5 and 9)
<u>WW</u> = Conveyor width reference: 08 – 24 in 02 increments		
<u>AA</u> = Angle 05, 10, 15, 30, 45 and 60		

Upper Knuckle - High Side

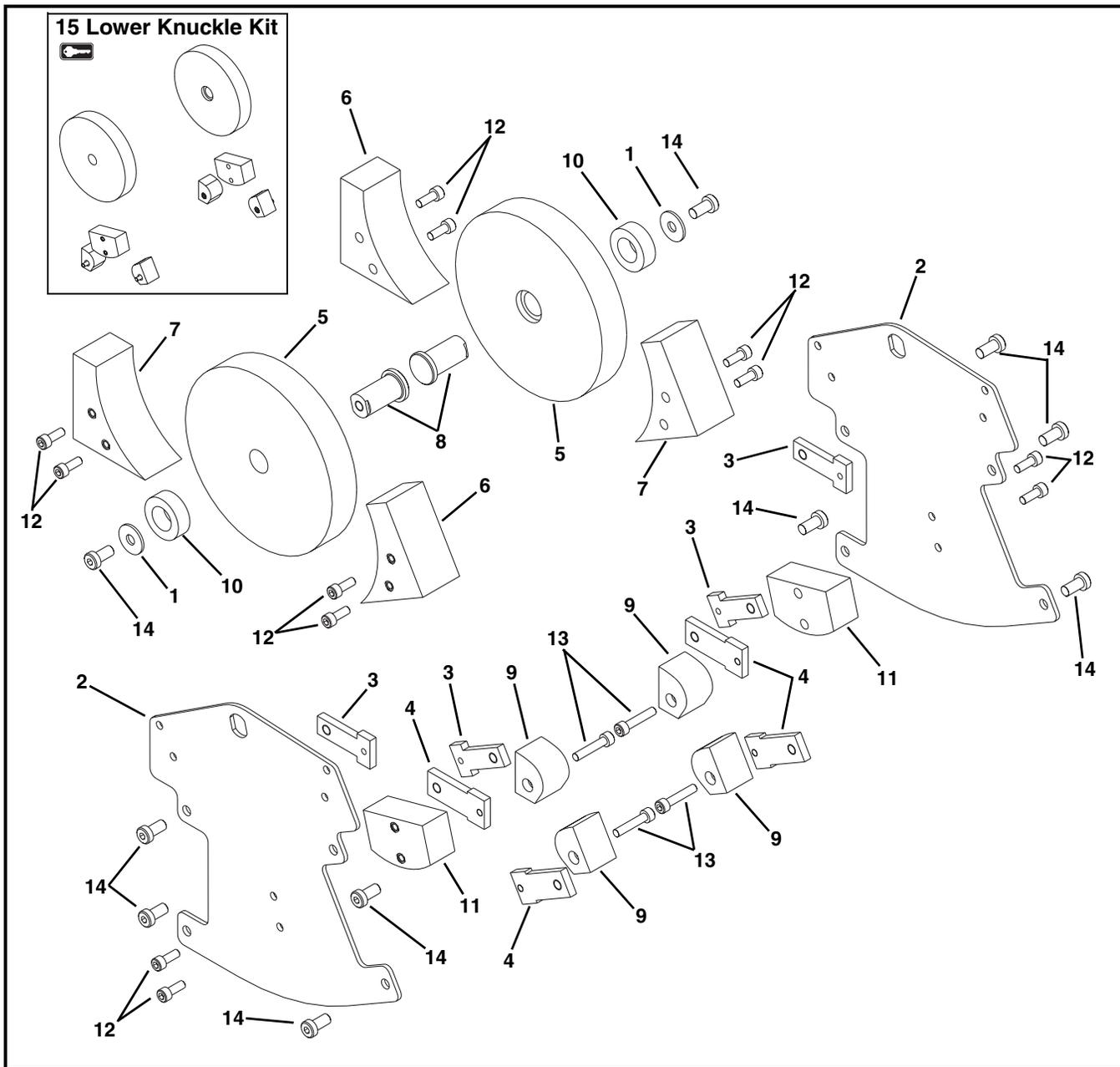


Item	Part Number	Description
1	807-1754	Sprocket
2	352322	Top Stop Nut
3	352323	Bottom Stop Nut
4	352328	Belt Guide
5	325329- <u>AA</u>	Side Plate
6	352332- <u>AA</u>	High Side Mounting Guide Left Hand
7	352333- <u>AA</u>	High Side Mounting Guide Right Hand
8	352336- <u>WW</u>	Shaft
9	352343- <u>AA</u> -L	High Side Guide Left Hand
10	352343- <u>AA</u> -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- <u>WW</u>	Upper Knuckle Kit (Includes Items 1,4 and 12)
<u>WW</u> = Conveyor width reference: 08 – 24 in 02 increments		
<u>AA</u> = Angle 05, 10, 15, 30, 45 and 60		

Service Parts

Lower Knuckle

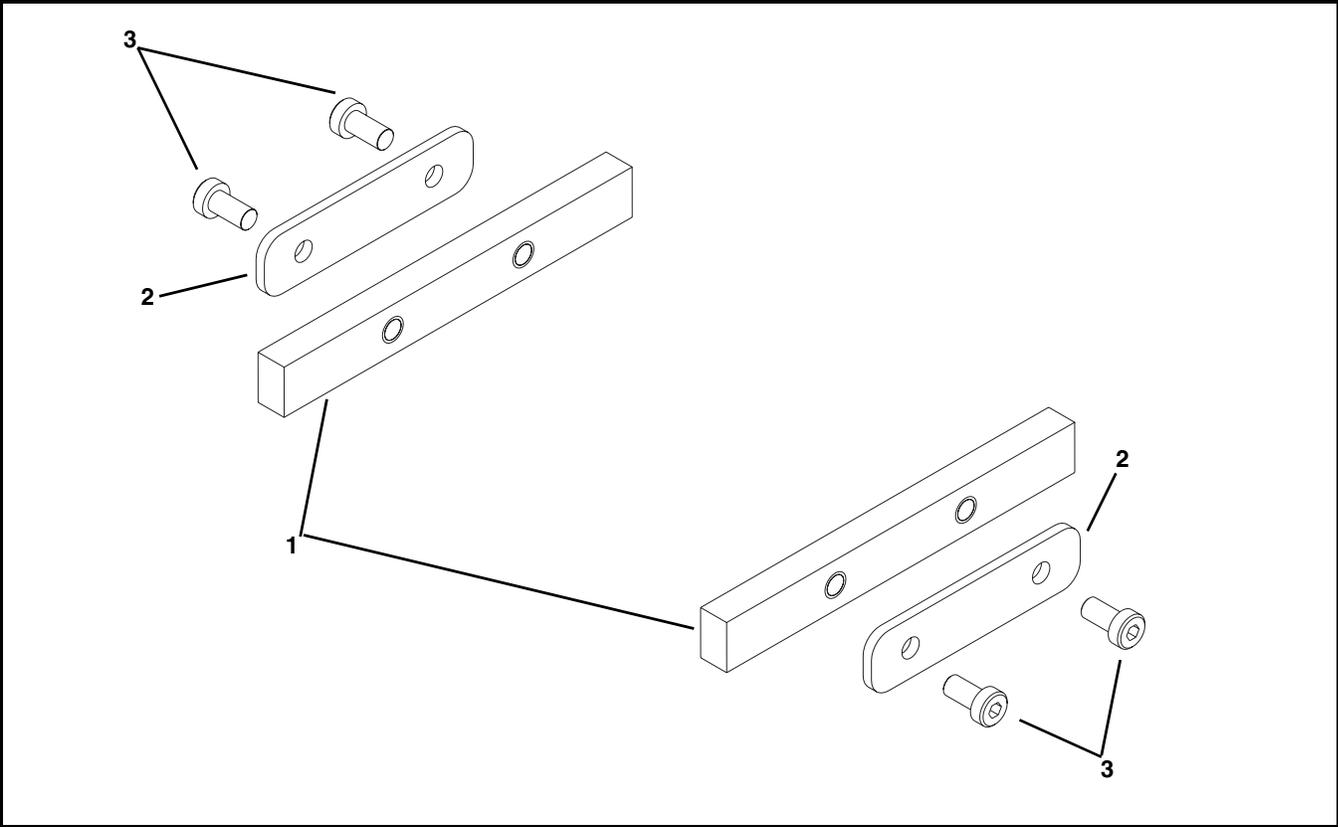


Item	Part Number	Description
1	807-1760	Washer
2	352321-AA	Side Plate
3	352322	Top Stop Nut
4	352323	Bottom Stop Nut
5	352324	Hold Down Guide
6	352325-L	Hold Down Guard Assembly Left Hand
7	352325-R	Hold Down Guard Assembly Right Hand
8	352327	Stub Shaft
9	352328	Belt Guide

Item	Part Number	Description
10	352337	Hold Down Spacer
11	352340	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	52HI	Lower Knuckle Kit (Includes Items 5, 9, 11 and 13)

AA = Angle 05, 10, 15, 30, 45 and 60

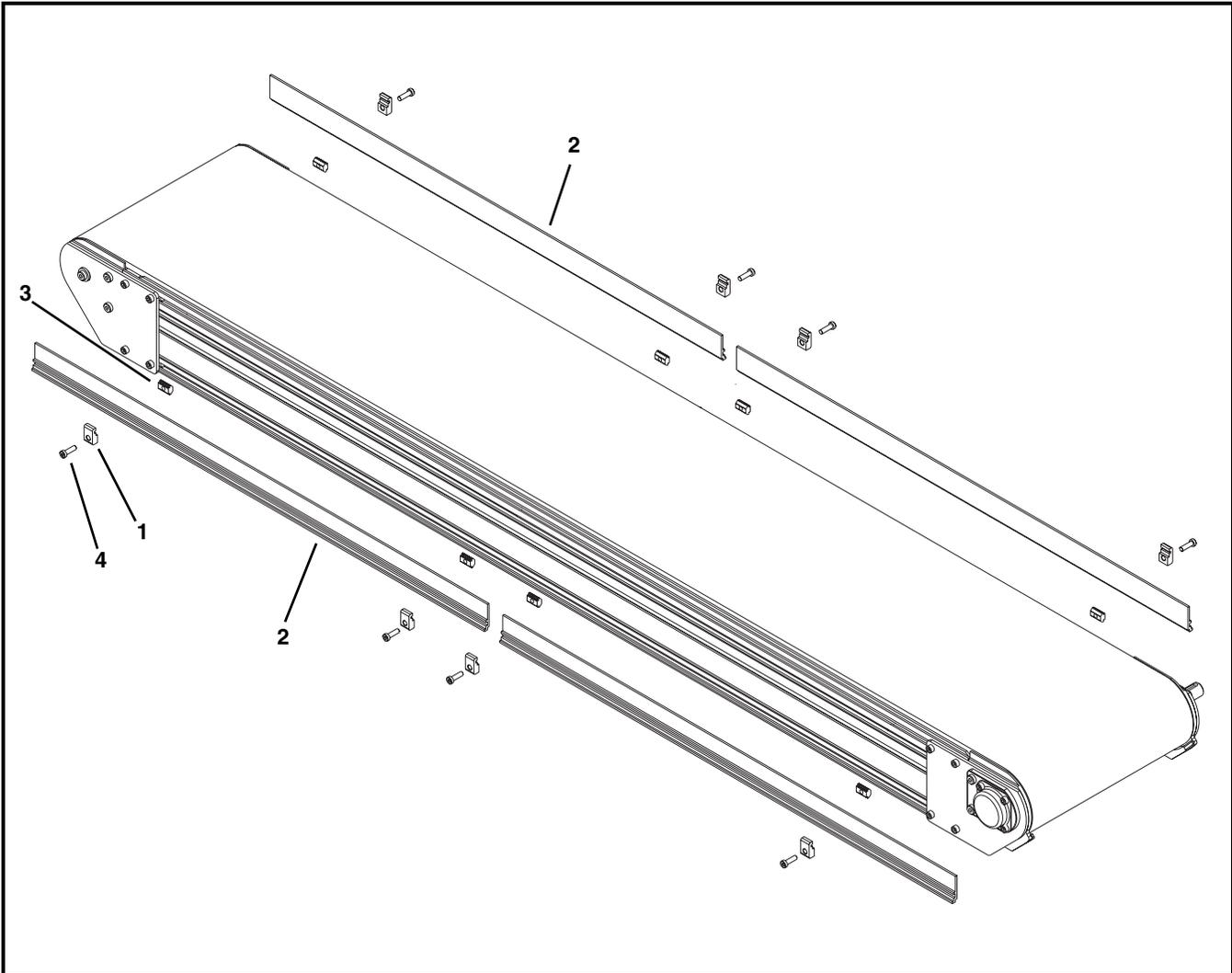
Connecting Assembly



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

Service Parts

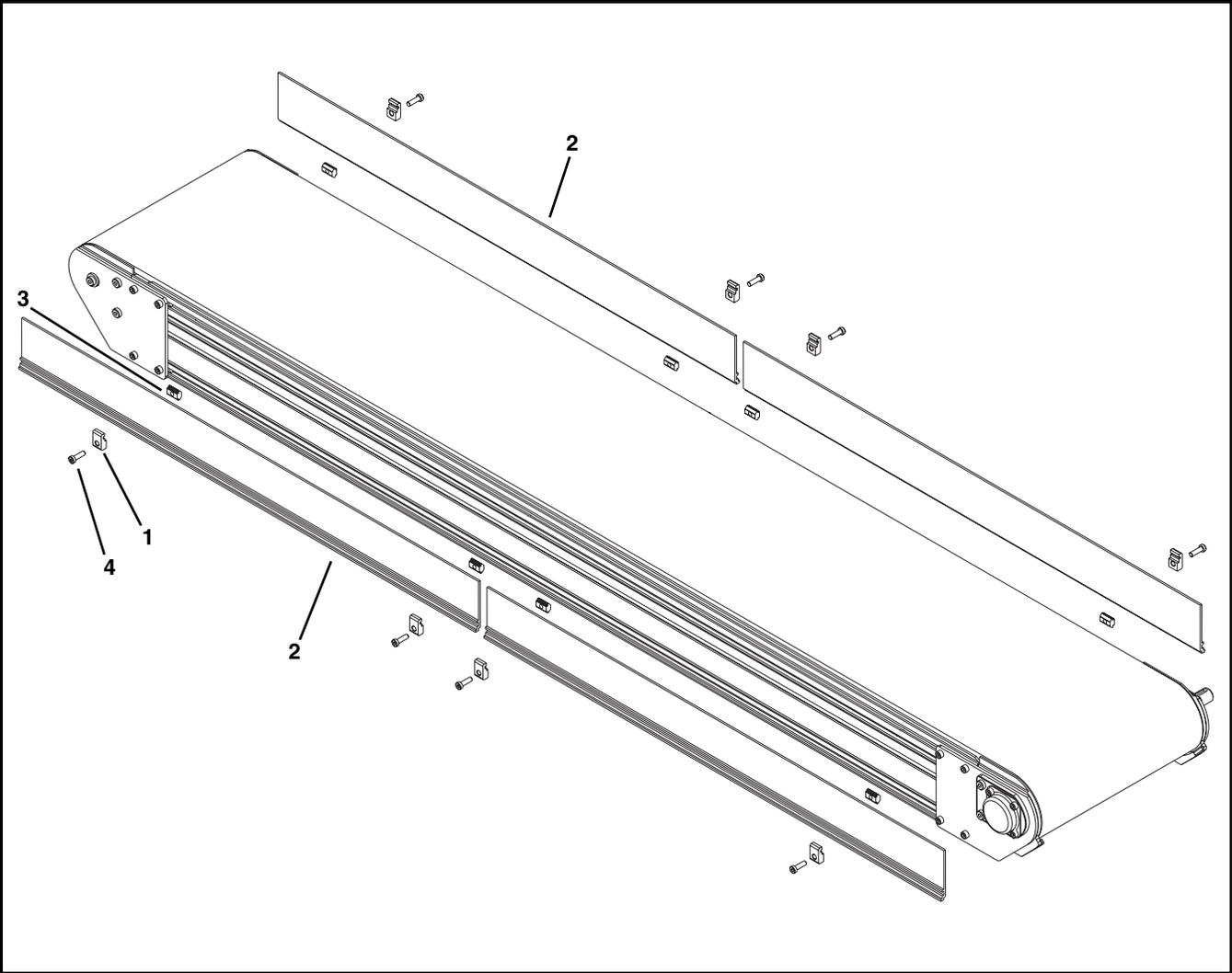
1" (25 mm) High Sides



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		

3" (76 mm) High Sides

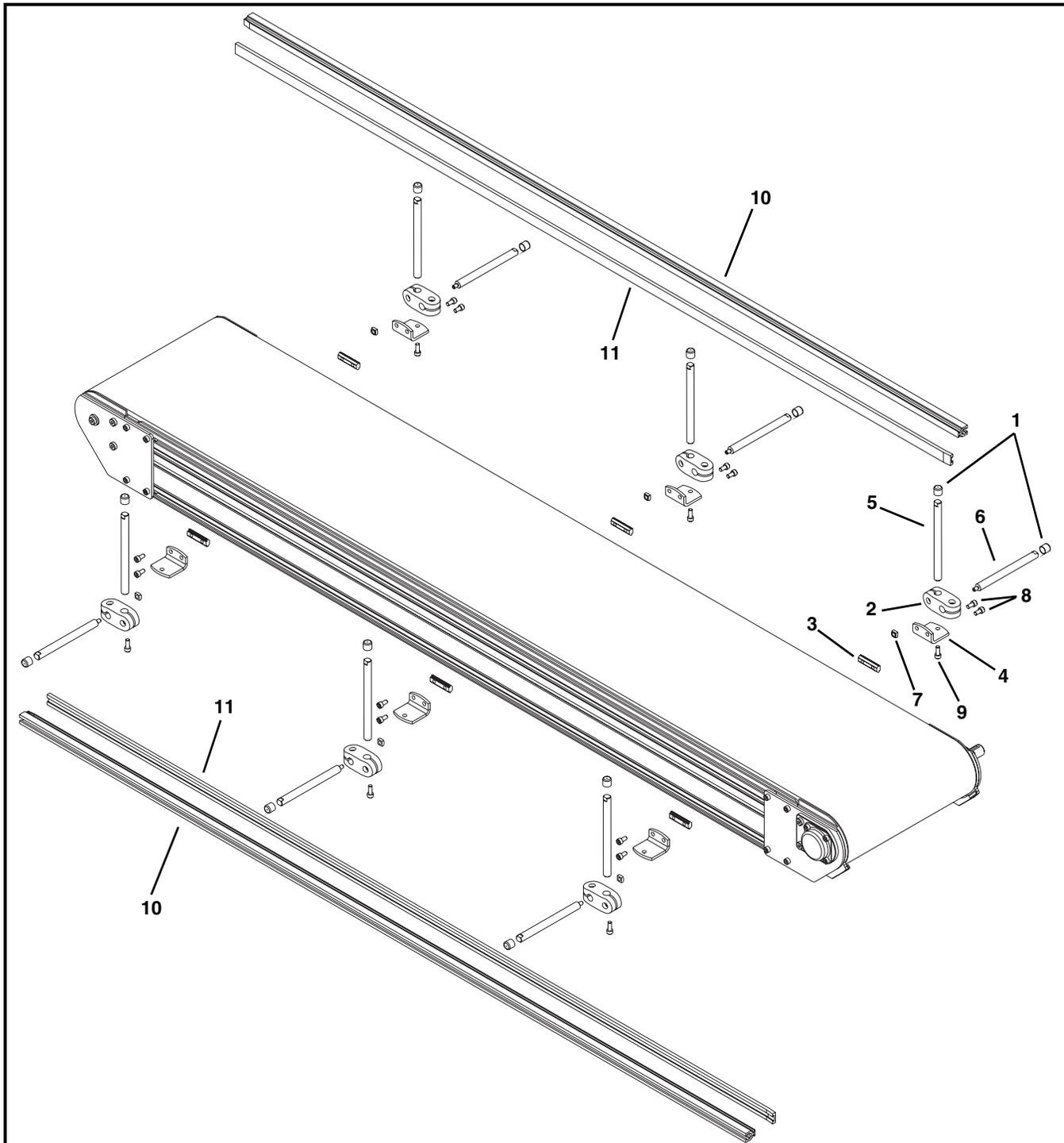


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	380400- <u>LLLLL</u>	3" Guides
3	639971M	Single Drop -In Tee Bar

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

Service Parts

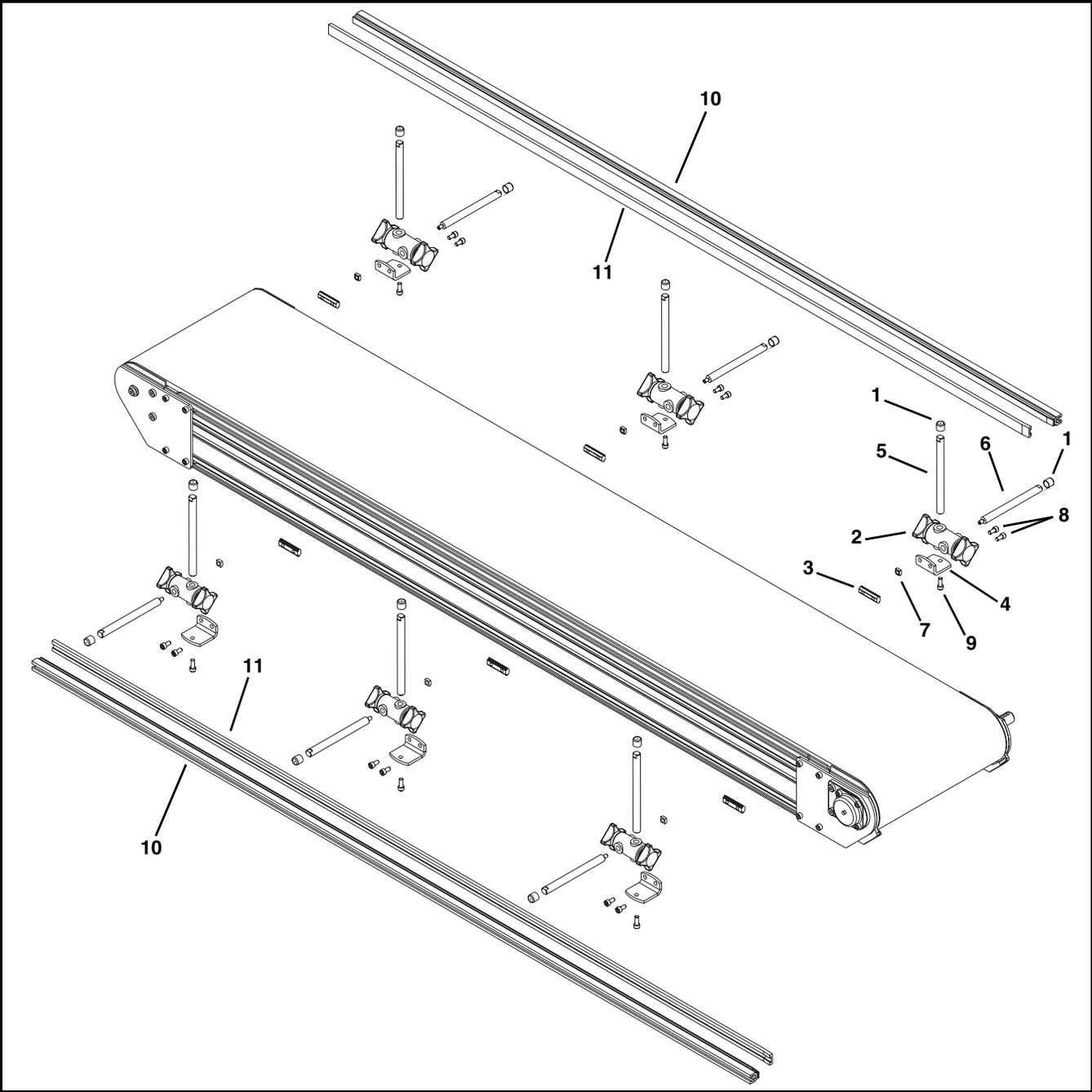
Fully Adjustable Guiding



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- <u>LLLL</u>	Aluminum Profile Guide
11	614068P- <u>LLLL</u>	Extruded Guide
<u>LLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLL</u> = 09525		

Tool-Less Fully Adjustable Guiding

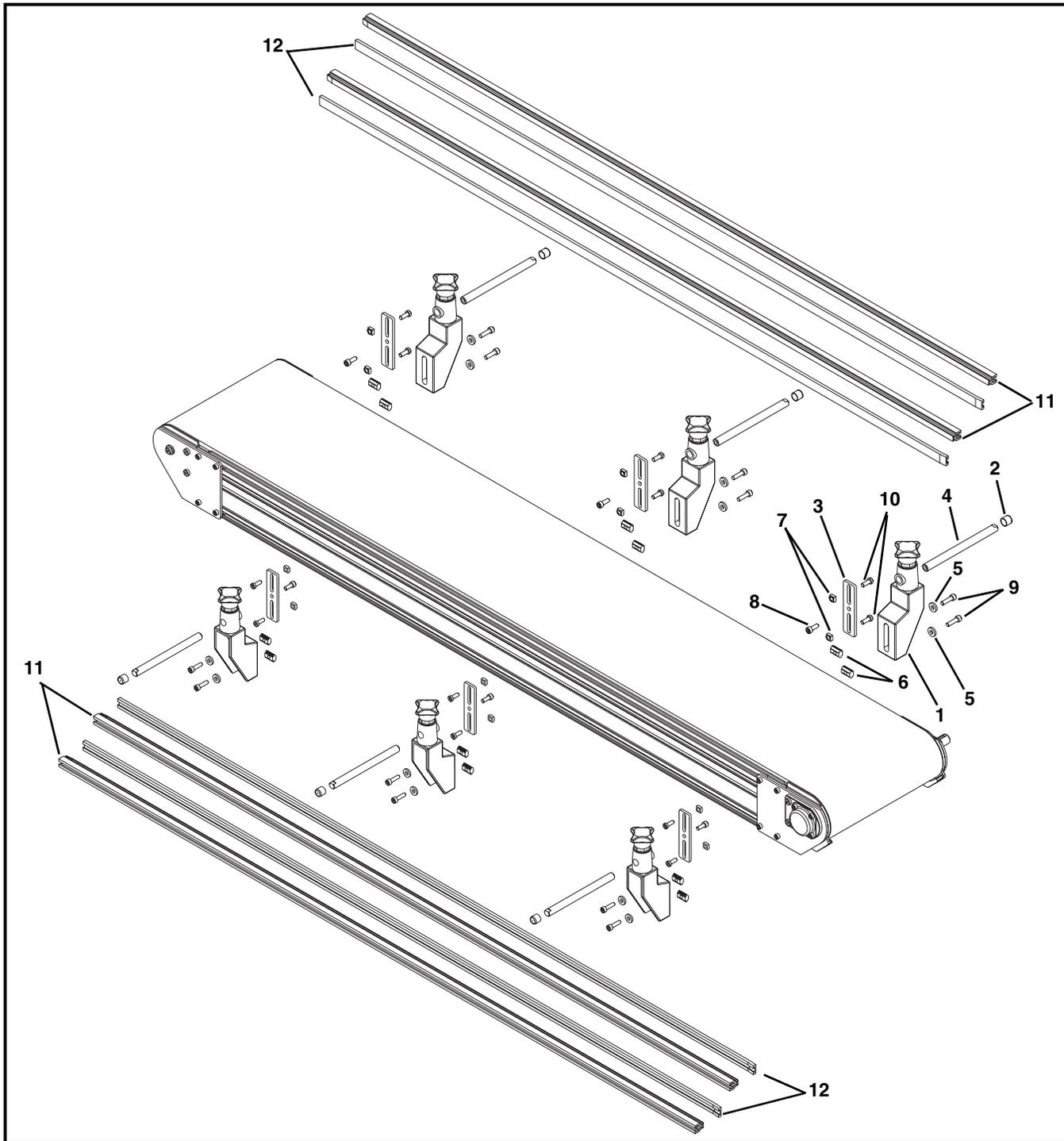


Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	200830M	Drop-In Tee Bar
4	202004M	Mounting Bracket
5	202027M	Vertical Mounting Guide Shaft
6	202028M	Horizontal Mounting Guide Shaft

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		

Service Parts

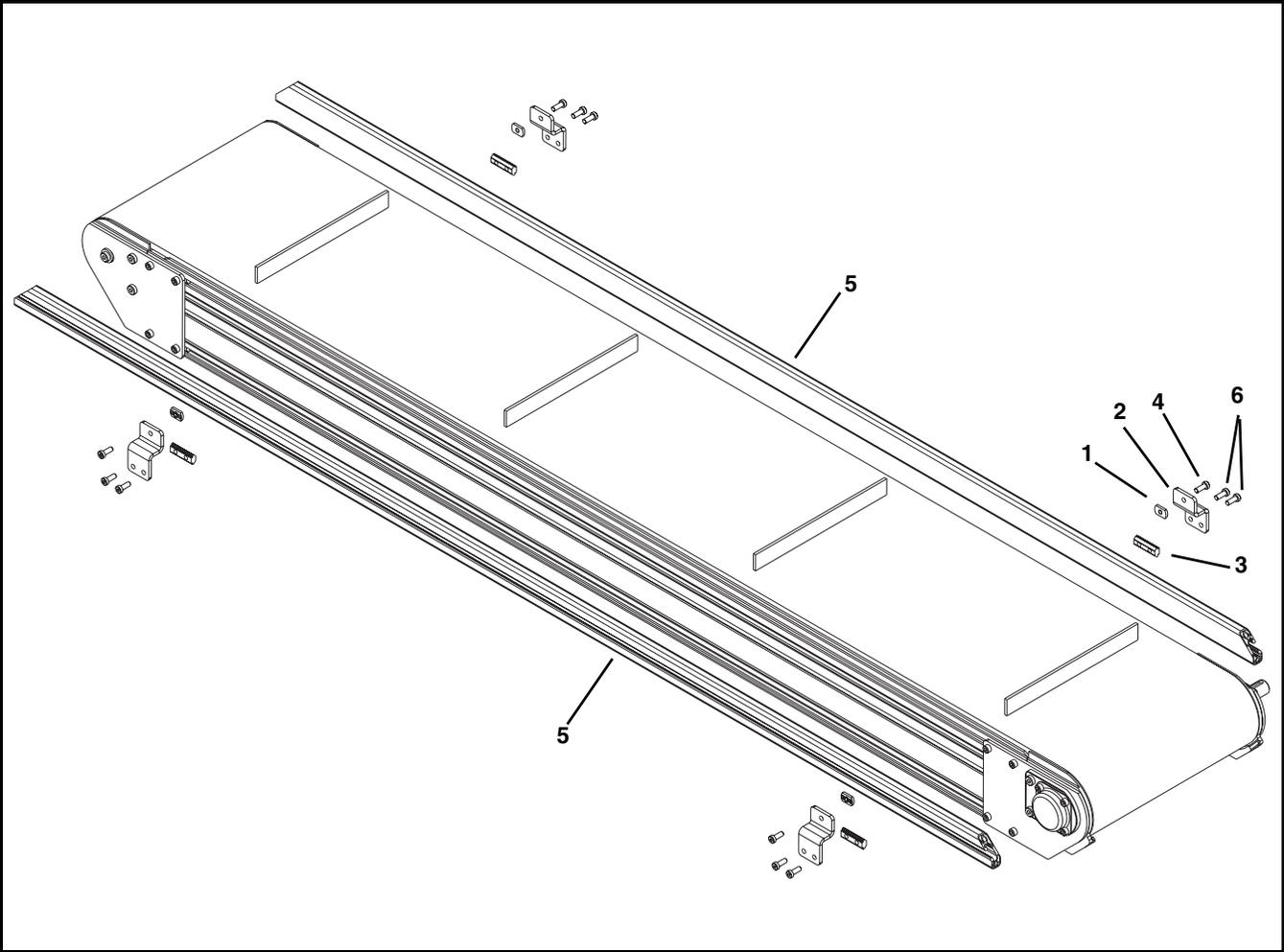
Twin Rail Adjustable Guiding



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		

1" (25 mm) Cleated Guiding

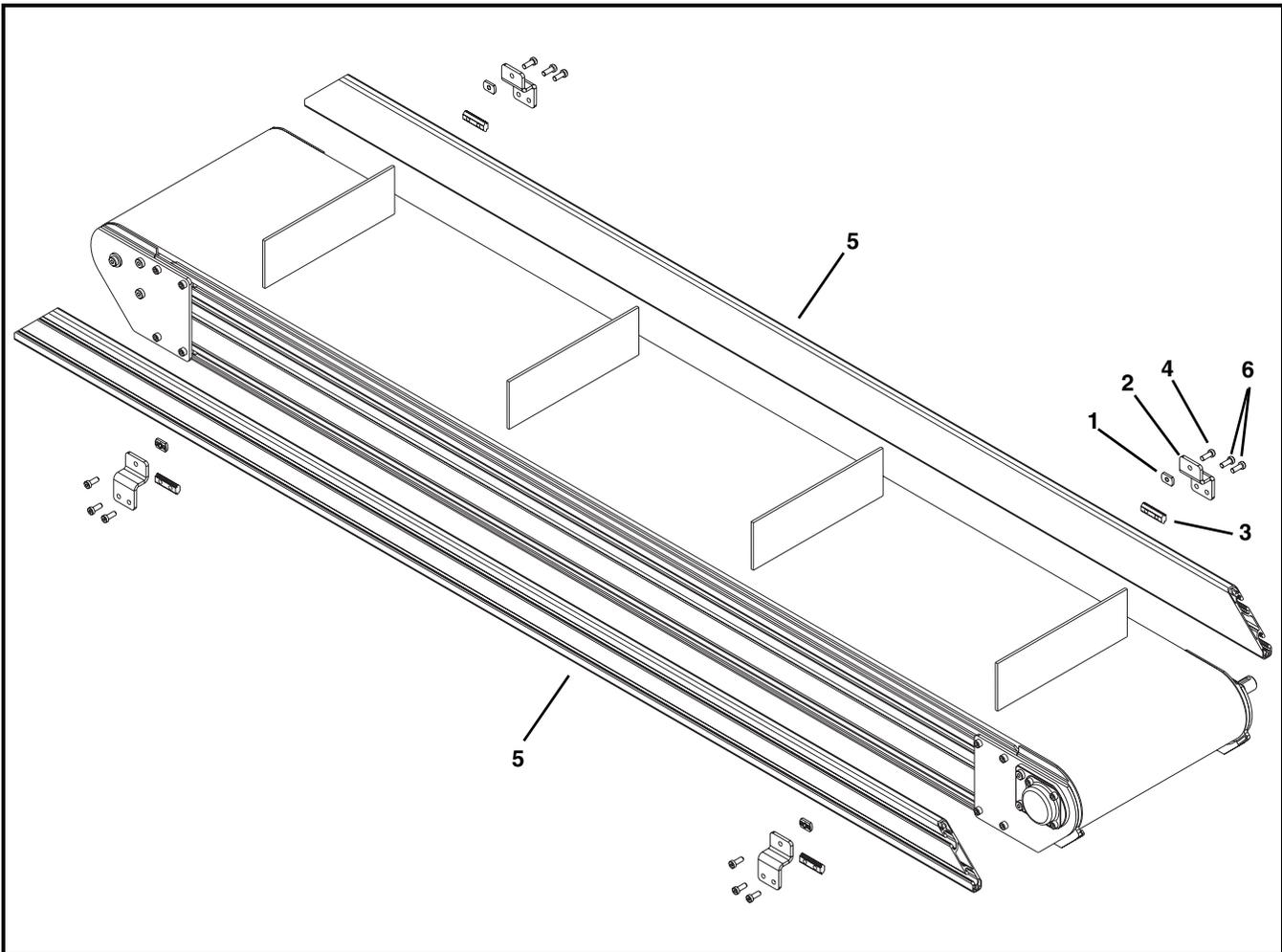


Item	Part Number	Description
1	807-1075	Weld Nut, M8-1.25
2	352300	Cleated Guiding Mounting Bracket
3	643874M	Drop -In Tee Bar
4	920893M	Low Head Cap Screw, M6-1.00 x 16 mm

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		

Service Parts

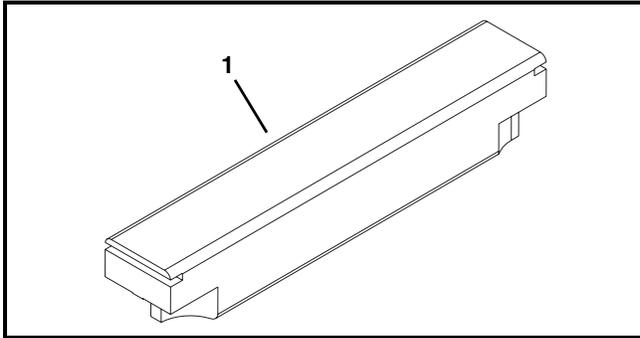
3" (76 mm) Cleated Guiding



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

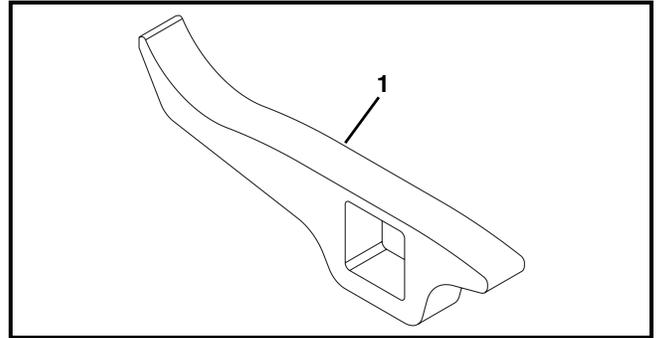
Item	Part Number	Description
5	352302-LLLLL	3" (76 mm) Cleated Guide
6	920616M	Socket Head Cap Screw, M6-1.00 x 16 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Guiding Length = 95.25" LLLLL = 09525		

Flat Belt Returns



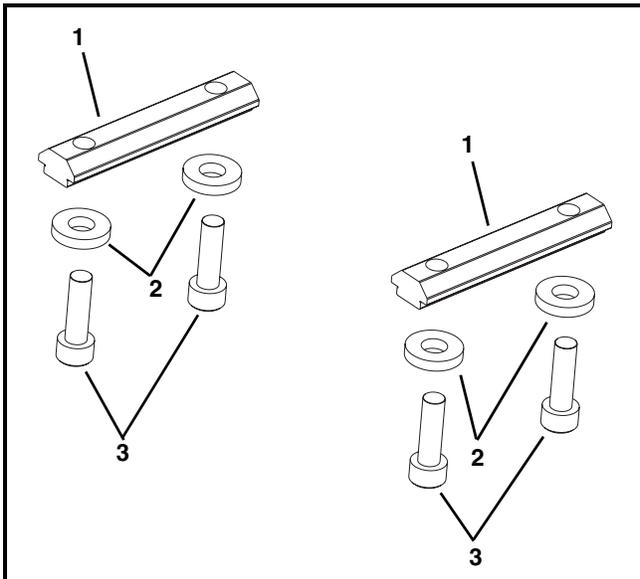
Item	Part Number	Description
1	352120- <u>WW</u>	Returns
<u>WW</u> = Conveyor width ref: 26 - 60 in 02 increments		

High Speed Shoe Kit



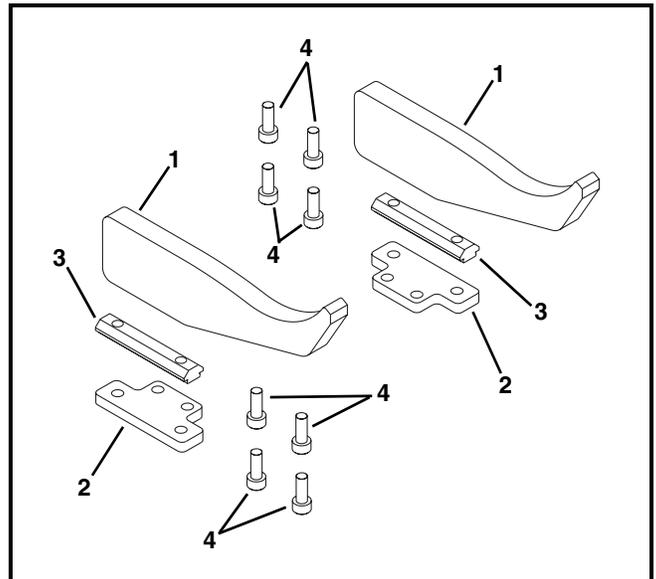
Item	Part Number	Description
1	352316- <u>WW</u>	Shoe kit for straight conveyors
<u>WW</u> = Conveyor width ref: 26 - 60 in 02 increments		

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

Service Parts

Ordering a Replacement Chain

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

Example:

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

Order: Qty (43) of 52BB-WW

BB = Chain reference number

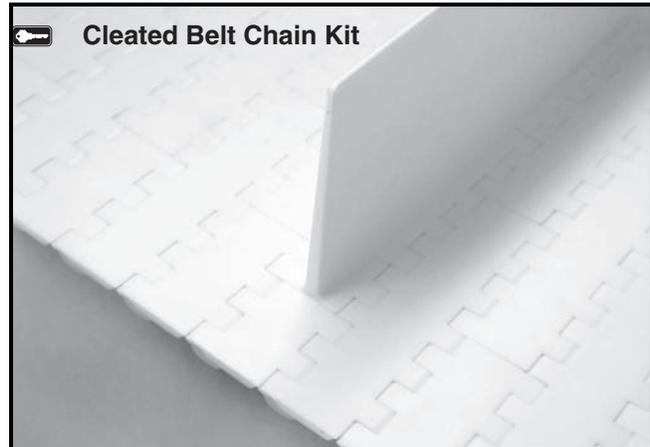
WW = Conveyor width ref: 08-60 in 02 increments

Flat Belt Chain Repair Kit



Item	Part Number	Description
1 	52 <u>BB</u> - <u>WW</u>	Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
<u>BB</u> = Chain Reference number		
<u>WW</u> = Conveyor width ref: 08 - 60 in 02 increments		

Cleated Belt Chain Repair Kit



Item	Part Number	Description
1 	52 <u>BB</u> - <u>WW</u> - <u>SS</u>	Cleated Belt Chain Repair Kit (Includes cleats on 1 ft (305mm) of belt chain and assembly pins)
<u>BB</u> = Chain Reference number		
<u>WW</u> = Conveyor width ref: 08 - 60 in 02 increments		
<u>SS</u> = Cleat Spacing		

Return Policy

Returns must have prior written factory authorization or they will not be accepted. Items that are returned to Dorner without authorization will not be credited nor returned to the original sender. When calling for authorization, please have the following information ready for the Dorner factory representative or your local distributor:

1. Name and address of customer.
2. Dorner part number(s) of item(s) being returned.
3. Reason for return.
4. Customer's original order number used when ordering the item(s).
5. Dorner or distributor invoice number.

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.
