

6100 Series Corrosion Resistant End Drive Conveyors

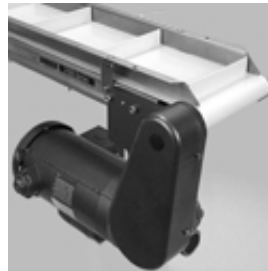
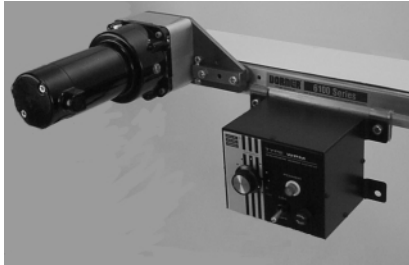




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Warnings – General Safety



	WARNING	
<p>The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.</p>		

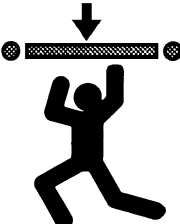

		WARNING
<p>Gearmotors may be HOT. DO NOT TOUCH Gearmotors.</p>		

		ANGER
<p>Climbing, sitting, walking or riding on conveyor will cause severe injury. KEEP OFF CONVEYORS.</p>		

		WARNING
<p>Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.</p> <p>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.</p>		

		ANGER
<p>DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.</p>		

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

		WARNING
<p>Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury. SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.</p>		

Introduction

IMPORTANT: 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.

Dorner's Limited Warranty applies.

Dorner 6100 Series conveyors are covered by Patent Nos. 5174435, 6109472 and corresponding patents and patent applications in other countries.

Dorner reserves the right to make changes at any time without notice or obligation.

Product Description

Refer to Figure 1 for typical conveyor components.

Typical Components	
A	Conveyor
B	Gearmotor Mounting Package
C	Gearmotor
D	Guiding & Accessories
E	Mounting Brackets with Return Rollers
F	Support Stands
G	Variable Speed Controller
H	Drive End
I	Idler/Tension End

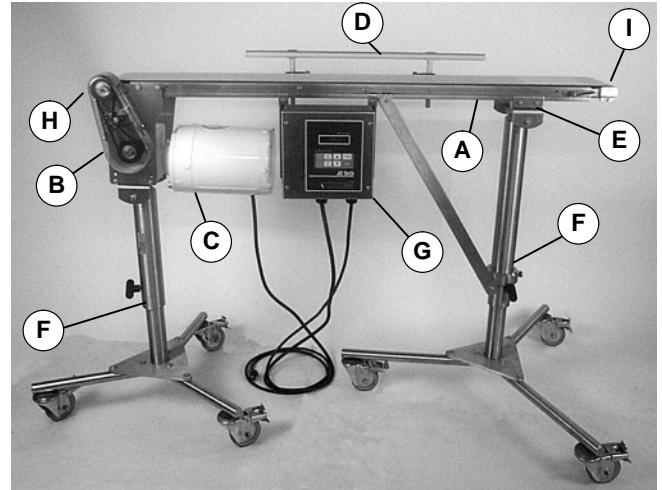
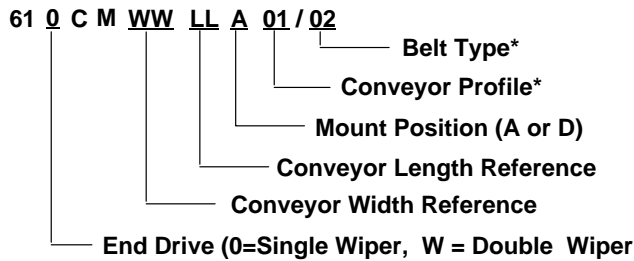


Figure 1

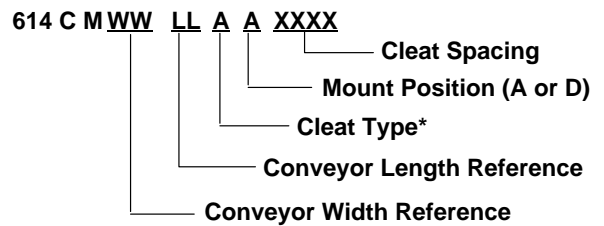
Specifications

Models:

Flat Belt 6100 Series Corrosion Resistant Conveyor



Cleated Belt 6100 Series Corrosion Resistant Conveyor



* See "Ordering and Specifications" Catalog for details.

Conveyor Supports:

Maximum Distances:

J = 18" (457 mm)**

K = 6 ft (1829 mm)***

L = 18" (457 mm)

** For Heavy Load Bottom Mount Package, mount support under gear head.

*** For conveyors longer than 13 ft (3962 mm), install support at joint.

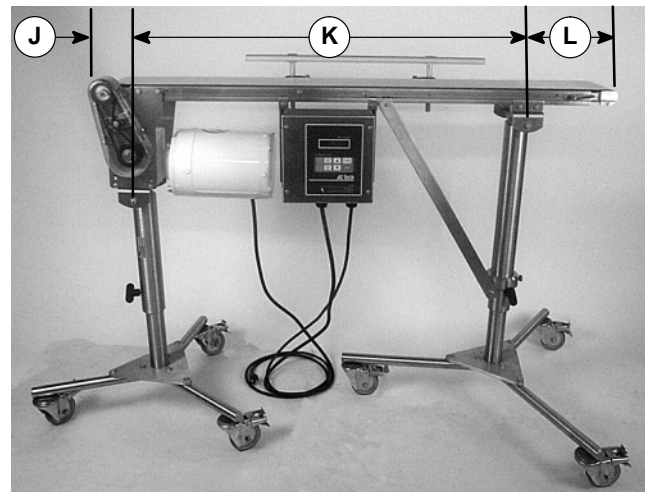


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18
Conveyor Belt Width	1.75" (44 mm)	2.75" (70 mm)	3.75" (95 mm)	5" (127 mm)	6" (152 mm)	8" (203 mm)	10" (254 mm)	12" (305 mm)	18" (457 mm)
Maximum Conveyor Load* (See NOTE Below)	30 lb (14 kg)	35 lb (16 kg)	42 lb (19 kg)	50 lb (23 kg)	60 lb (27 kg)	60 lb (27 kg)	60 lb (27 kg)	60 lb (27 kg)	60 lb (27 kg)
Conveyor Start-up Torque*	4 in-lb (0.5 Nm)	5 in-lb (0.6 Nm)	6 in-lb (0.7 Nm)	7 in-lb (0.8 Nm)	8 in-lb (0.9 Nm)	10 in-lb (1.1 Nm)	12 in-lb (1.4 Nm)	14 in-lb (1.5 Nm)	15 in-lb (1.7 Nm)
Belt Travel	3.5" (88 mm) per revolution of pulley								
Maximum Belt Speed*	235 feet/minute (72 meters/minute)								
Belt Take-up	0.38" (10 mm) of stroke = 0.75" (19 mm) of belt take-up								

Conveyor Length Reference (LL)	02	03	04	05	06	07	08	09	10	11	12	13**	14**	15**	16**	17**	18**
Conveyor Length	2-ft (610 mm)	3-ft (914 mm)	4-ft (1219 mm)	5-ft (1524 mm)	6-ft (1829 mm)	7-ft (2134 mm)	8-ft (2438 mm)	9-ft (2743 mm)	10-ft (3048 mm)	11-ft (3353 mm)	12-ft (3658 mm)	13-ft (3962 mm)**	14-ft (4267 mm)**	15-ft (4572 mm)**	16-ft (4877 mm)**	17-ft (5182 mm)**	18-ft (5486 mm)**

* See "Ordering and Specifications" Catalog for details.

** Lengths available only in 6" (152 mm) & wider conveyors.

NOTE: Maximum conveyor loads based on:

- Non-accumulating product
- Product moving towards gearmotor
- Conveyor being mounted horizontal

Installation

NOTE: Conveyor **MUST** be mounted straight, flat and level within confines of conveyor. Use a level (M of Figure 3) for set-up.

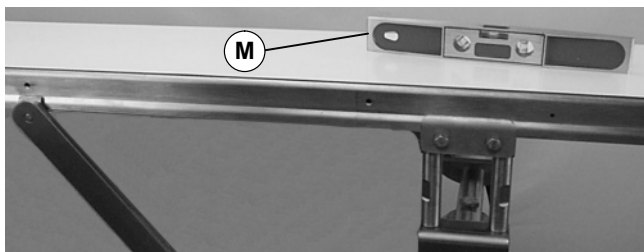


Figure 3

Illustration References

M	Level
N	Conveyor frame without belt
O	M6 x 10 mm Hex Head Socket Head Screws (6x) (shipped loose)
P	Connector Strips (2x) (Attached to conveyor section)
Q	Conveyor frame with belt
R	M6 x 12 mm Hex Head Screws (4x)
S	M6 x 16 mm Hex Head Screws & Hard Washers (4x)

Required Tools

Standard Tools

- 10 mm wrench (for hexagon head fasteners)
- 5 mm hex key wrench
- Level
- Torque wrench

Recommended Installation Sequence (see Table of Contents for page number)

- Assemble conveyor (if required)
- Attach mounting bracket(s) with return roller to conveyor (see pages 6 and 7)
- Install stands (see accessory instructions)
- Attach conveyor to stands
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see “Service Parts” section, pages 16 through 30)

Conveyors Up to 13 ft (3962 mm)

No additional assembly is required.

Conveyors Longer Than 13 ft (3962 mm)

1. Typical components (Figure 4)

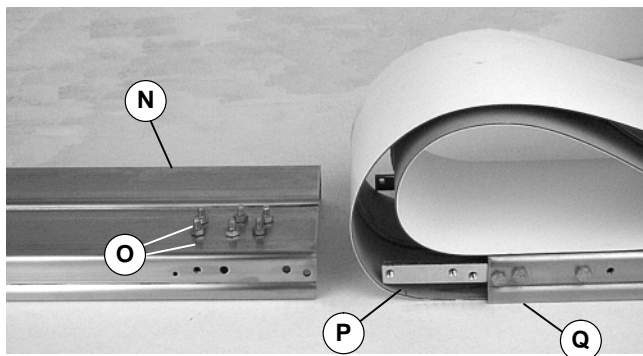


Figure 4

2. Compress tension end (Figure 5). Refer to steps 3, 4 & 5 under the “Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands” on page 9.



Figure 5

3. Roll out conveyor belt.
4. Place conveyor frame (N Figure 6) into belt loop.

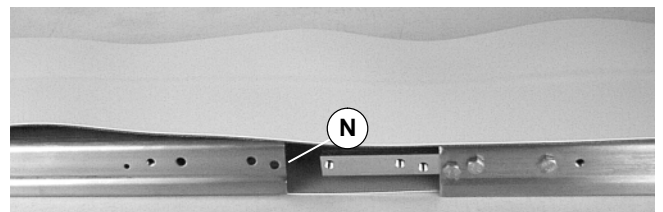


Figure 6

5. Join conveyor sections (N and Q of Figure 7). Install screws (O) on both sides. Tighten to 92 in-lb (10.4 Nm).

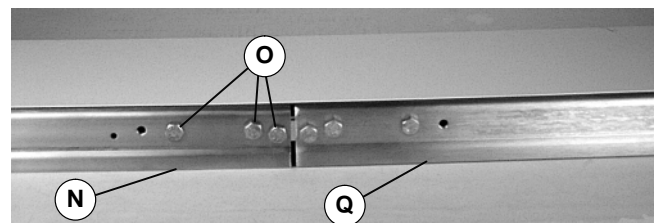


Figure 7

6. Tension conveyor belt. Refer to “Conveyor Belt Tensioning” on page 11.

Installation

Mounting Brackets with Return Rollers Cleated Belt Conveyors

1. Typical components (Figure 8)

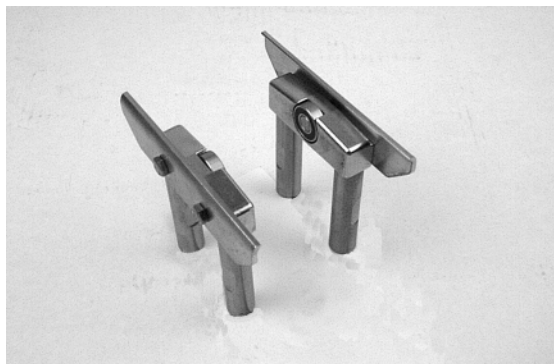


Figure 8

2. Loosen screws (R of Figure 9) and remove screws and washers (S).

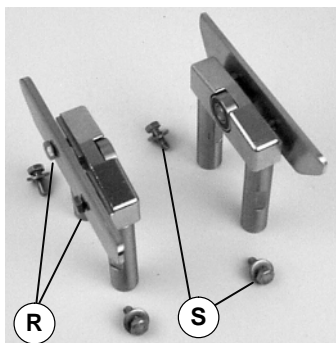


Figure 9

3. Attach clamp plates on each side of conveyor (Figure 10). Tighten the screws (R) to 92 in-lb (10.4 Nm).

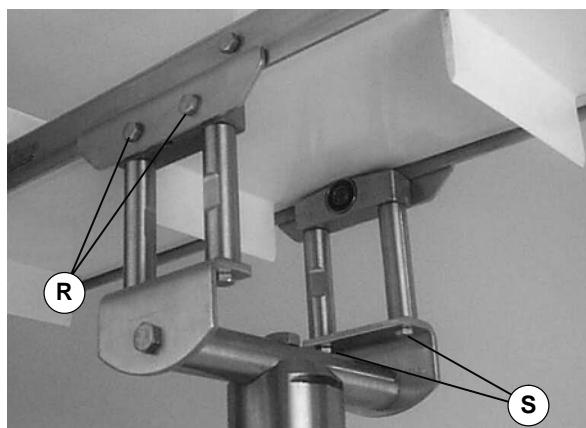


Figure 10

4. Attach to support stand. Tighten screws (S) to 92 in-lb (10.4 Nm). Make sure belt is free to move.

2" to 6" (44 mm to 152 mm) Wide Flat Belt Conveyors

1. Typical components (Figure 11)

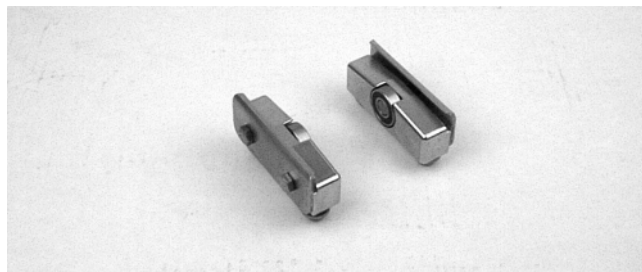


Figure 11

2. Loosen screws (R of Figure 12) and remove screws and washers (S).

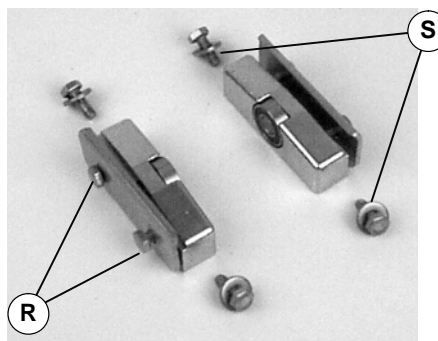


Figure 12

3. Attach clamp plates on each side of conveyor (Figure 13). Tighten the screws (R) to 92 in-lb (10.4 Nm).

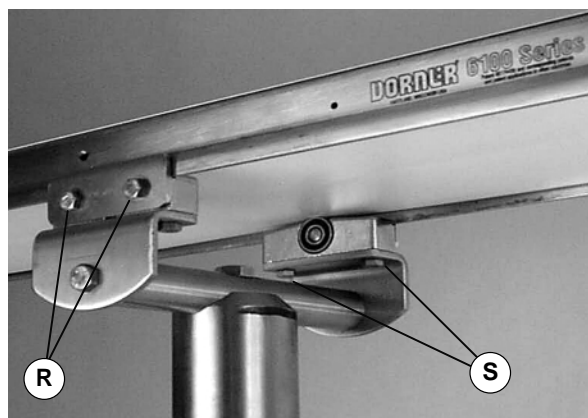


Figure 13

4. Attach to support stand. Tighten screws (S) to 92 in-lb (10.4 Nm). Make sure belt is free to move.

8" (203 mm) & Wider Flat Belt Conveyors

1. Typical components (Figure 14)

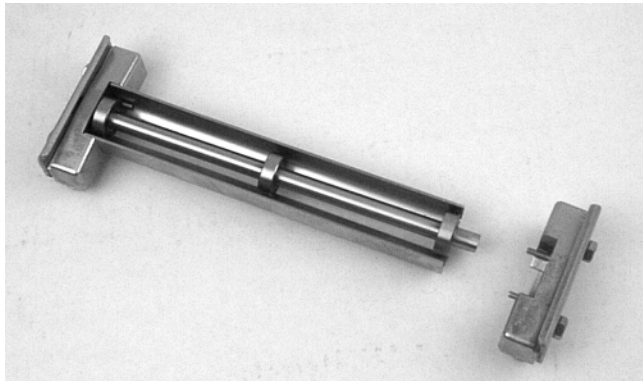


Figure 14

2. Loosen screws (R of Figure 15) and remove screws and washers (S).

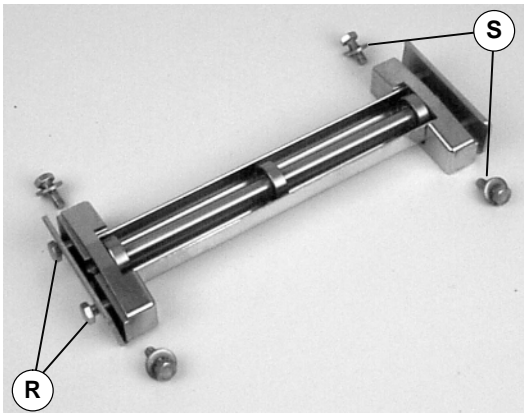


Figure 15

3. Attach clamp plates on each side of conveyor (Figure 16). Tighten the screws (R) to 92 in-lb (10.4 Nm).



Figure 16

4. Attach to support stand. Tighten screws (S) to 92 in-lb (10.4 Nm). Make sure belt is free to move.

Preventative Maintenance & Adjustment

Required Tools

Standard Tools

- Wrenches (for hexagon head fasteners)
 - 8 mm & 10 mm
- 5 mm hex key wrench
- Narrow blade screwdriver
- Arbor press

Special Tools

- 450281 Sealed Bearing Removal Tool
- 450282 Sealed Bearing Installation Tool

Checklist

- Keep service parts on hand (see "Service Parts" section for recommendations)
- Keep supply of belt cleaner (part # 625619)
- Clean entire conveyor and knurled pulley while disassembled
- Replace worn or damaged parts

Lubrication

Conveyor with Standard 0.47" (12 mm) Diameter Output Shaft

No lubrication is required. Replace bearings if worn.

Mounting Brackets with Return Rollers

No lubrication is required. Replace bearings if worn.

Preventive Maintenance and Adjustment

Maintaining Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Stalling or slipping
- Damage to V-guide

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Improperly installed bottom wiper(s)
- Accumulated dirt in wiper(s)
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:

- Excessive load on belt
- Conveyor belt or drive timing belt are not properly tensioned
- Worn knurl or impacted dirt on drive pulley
- Intermittent jamming or drive train problems

Damage to V-guide indicates:

- Twisted or damaged conveyor frame
- Dirt impacted on pulleys
- Excessive or improper side loading

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

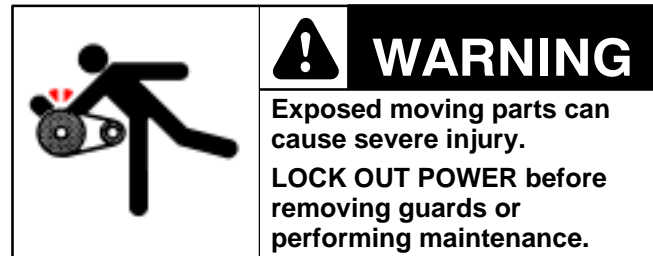
Cleaning Conveyor Belt

IMPORTANT: Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.

Use Dorner Belt Cleaner (part # 625619). Mild soap and water may also be used. Do not soak the belt.

For /05 woven polyester and /06 black anti-static belts, use a bristled brush to improve cleaning.

Conveyor Belt Replacement



Conveyor Belt Replacement Sequence (see Table of Contents for page number)

- Remove old conveyor belt
 - Conveyor without Gearmotor Mounting Package or Stands
 - Conveyor with Stands and/or Gearmotor Mounting Package
- Install new conveyor belt
- Tension conveyor belt

Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands

1. For a flat belt conveyor, remove and retain the bottom wiper(s) (T of Figure 17).

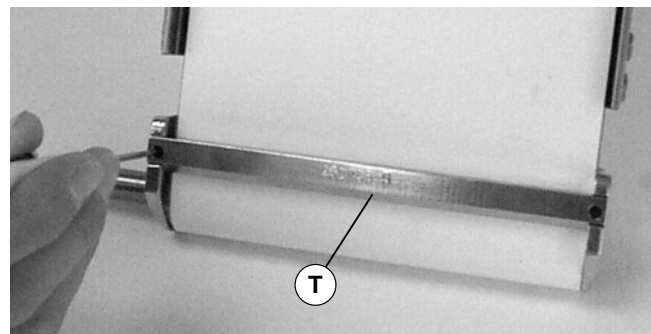



Figure 17

2. If conveyor is equipped with guiding and accessories, remove them from one side.

Preventive Maintenance and Adjustment

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

3. On tension end of the conveyor identified with a  label (U Figures 18 & 19), insert a 5 mm hex key wrench to engage pinion gear (V of Figure 18).

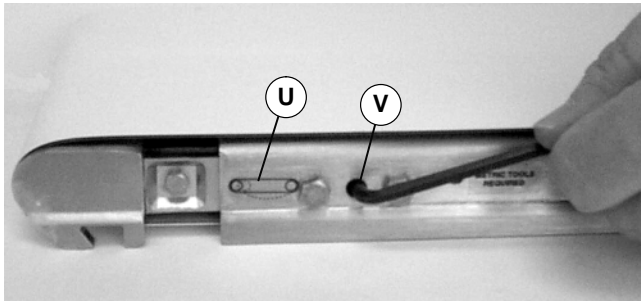


Figure 18

4. With pinion gear engaged, place a 10 mm wrench on lock screw (W of Figure 19).

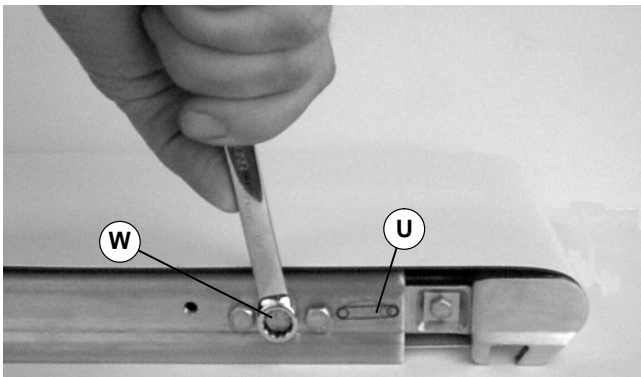


Figure 19

5. While maintaining tension on pinion gear (V of Figure 20) loosen lock screw (W). Rotate pinion gear (V) clockwise to release conveyor belt tension.

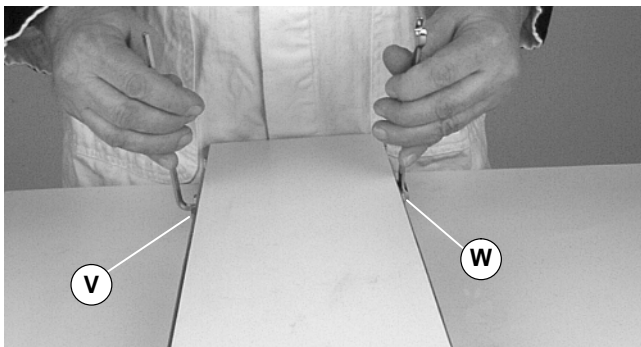


Figure 20

6. Remove conveyor belt.

Belt Removal for Conveyor With Stands and/or Gearmotor Mounting Package

NOTE: For conveyor with a Heavy Load Bottom or Top Mount Package, bracket (AA of Figure 21) must be removed.

- Remove two (2) M6 x 30 mm cap screws (AB).
- Remove two (2) M6 x 16 mm cap screws (AC).
- Remove bracket (AA).

NOTE: Bottom Mount Drive Package for Heavy Load Sanitary Gearmotor shown. Package for Industrial Gearmotor similar. For Industrial Gearmotor, screws (AB) are M6 x 16 mm socket heads and screws (AC) are M6 x 12 mm socket heads.

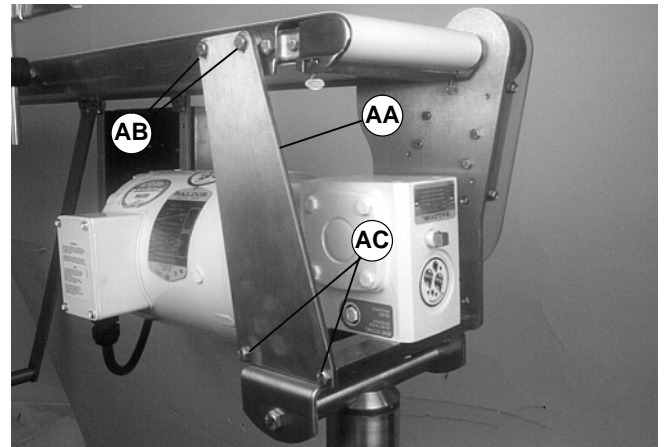
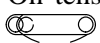


Figure 21

1. For a flat belt conveyor, remove and retain the bottom wiper(s) (T of Figure 17).
2. If conveyor is equipped with guiding and accessories, remove them from one side.

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

3. On tension end of the conveyor identified with a  label (U Figures 18 & 19), insert a 5 mm hex key wrench to engage pinion gear (V of Figure 18).
4. With pinion gear engaged, place a 10 mm wrench on lock screw (W of Figure 19).
5. While maintaining tension on pinion gear (V of Figure 20) loosen lock screw (W). Rotate pinion gear (V) clockwise to release conveyor belt tension.

Preventive Maintenance and Adjustment

WARNING

The weight of the gearmotor is all on one end of the conveyor which could cause it to tip off the stands when the mounting clamp plates are loosened. Be sure to provide support (AD of Figure 22) underneath the gearmotor while changing the belt.

6. Temporarily support conveyor at gearmotor mounting package (AD of Figure 22).

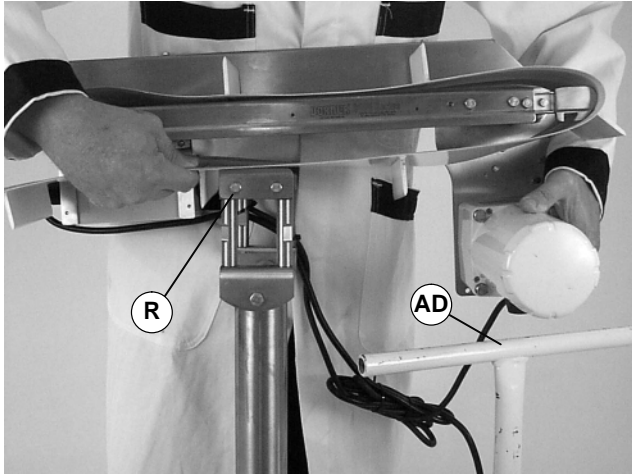


Figure 22

NOTE: To remove belt, complete steps 7 & 8, at each stand location.

WARNING

To prevent injury from the support stand tipping-over when conveyor is uncoupled, anchor stand to floor or otherwise stabilize the stand.

7. Loosen the mounting clamp plates (R of Figures 22 and 23), on both sides of the conveyor. Raise the conveyor and remove the belt.

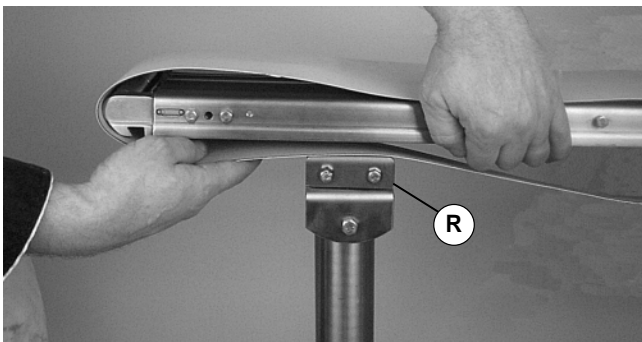


Figure 23

8. With belt removed, secure conveyor with clamp plates (R).

Belt Installation for Conveyor without Gearmotor Mounting Package or Stands

IMPORTANT: On a flat belt conveyor, the wiper is installed on discharge end. Belt travel direction is identified by an arrow decal on the side of the conveyor (AG of Figure 24). With a reversing gearmotor, a second bottom wiper must be installed on opposite end.

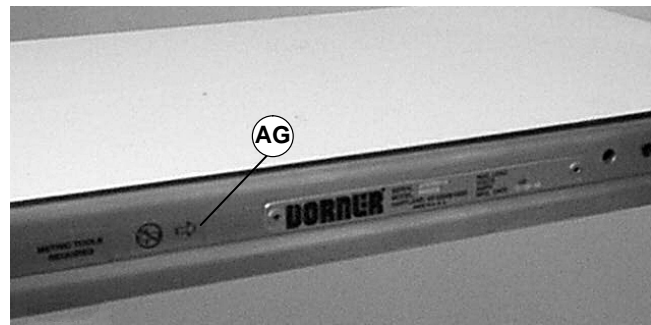


Figure 24

1. Orient the conveyor belt so that the splice leading fingers (AE of Figure 25) point in the direction of belt travel (AF) as identified by the label (AG of Figure 24).

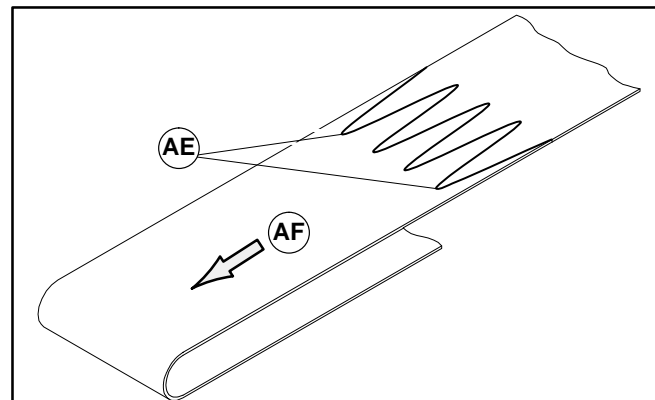


Figure 25

2. Slide belt onto the conveyor frame assembly.
3. On a flat belt conveyor, install bottom wiper(s) (T of Figure 17). Center set screws in frame and tighten to 33 in-lb (3.7 Nm).
4. Tension belt. Refer to "Conveyor Belt Tensioning" on page 11.
5. Where applicable, replace guiding.

Preventive Maintenance and Adjustment

Belt Installation for Conveyor with Gearmotor Mounting Package and/or Stands

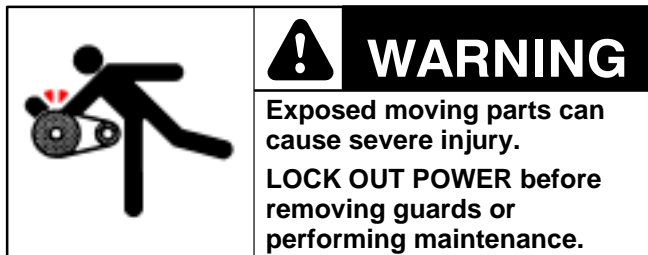
IMPORTANT: On a flat belt conveyor, the wiper is installed on discharge end. Belt travel direction is identified by an arrow decal on the side of the conveyor (AG of Figure 24). With a reversing gearmotor, a second bottom wiper must be installed on opposite end.

1. Orient the conveyor belt so that the splice leading fingers (AE of Figure 25) point in the direction of belt travel (AF) as identified by the label (AG of Figure 24).


NOTE: To install belt, complete steps 2, 3 & 4, at each stand location.

2. Loosen the mounting clamp plates (R of Figures 22 and 23), on both sides of the conveyor. Raise the conveyor and replace the belt.
3. Lower the conveyor onto the mounting blocks being careful not to pinch belt.
4. Tighten clamp plates screws (R) to 92 in-lb (10.4 Nm).
5. On a flat belt conveyor, install bottom wiper(s) (T of Figure 17). Center set screws in frame and tighten to 33 in-lb (3.7 Nm).
6. Tension belt. Refer to the “Conveyor Belt Tensioning” topic on this page.
7. Where applicable, replace guiding.

Conveyor Belt Tensioning



NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

1. On tension end of the conveyor identified with a  label (U Figures 18 & 19), insert a 5 mm hex key wrench to engage pinion gear (V of Figure 18).
2. With pinion gear engaged, place a 10 mm wrench on lock screw (W of Figure 19).

NOTE: On pinion gear (V of Figure 18), do not exceed of 25 in-lb (2.8 Nm) for 2" to 12" (44 mm to 305 mm) wide conveyors and 40 in-lb (4.5 Nm) for an 18" (457 mm) wide conveyor. Over-tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. Loosen lock screw (W of Figure 20).
- 4a. For existing belt:
With V-guide seated in pulley, rotate the pinion gear (V) counter-clockwise to sufficiently tension the belt to handle the conveyor load.

NOTE: If the maximum take-up stroke is achieved, replace the conveyor belt.

- 4b. For a new belt:
With V-guide seated in pulley, rotate the pinion gear (V) counter-clockwise to a distance of 1" (25 mm) (AH of Figure 26).

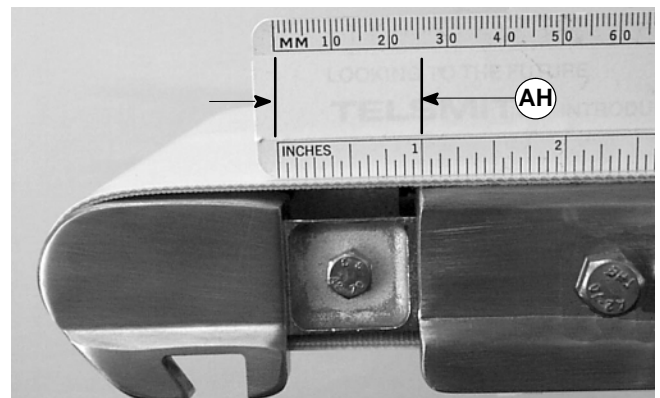
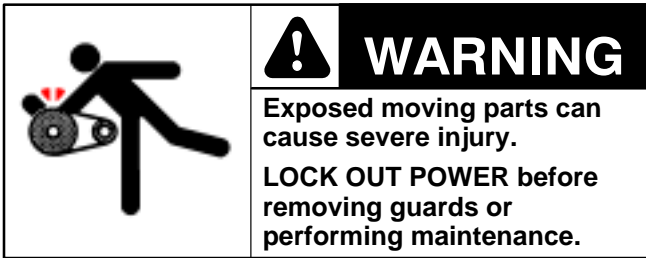


Figure 26

5. Secure lock screw (W of Figure 19) to 40 in-lb (4.5 Nm).

Preventive Maintenance and Adjustment

Pulley Removal



Remove conveyor belt to access pulley(s). See “Conveyor Belt Replacement” on page 8. Remove the desired pulley following instructions:

- A – Drive Pulley with Standard 0.47” (12 mm) Diameter Output Shaft
- B – Idler Pulley
- C – Idler Pulley with Tool-less Belt Release

A – Removal of Drive Pulley with Standard 0.47” (12 mm) Diameter Output Shaft



1. Remove the gearmotor mounting package. See accessory instructions.
2. Remove screw (AI).

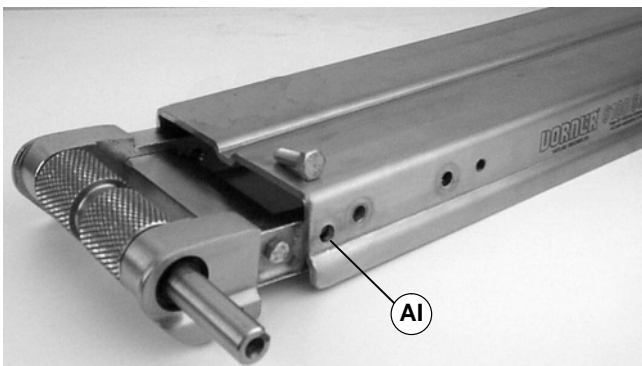


Figure 27

NOTE: With a Heavy Load Mount Package, two (2) screws (AB of Figure 21) were removed in step 1.

3. Remove three (3) screws (AJ of Figure 28) on the side opposite the drive shaft.

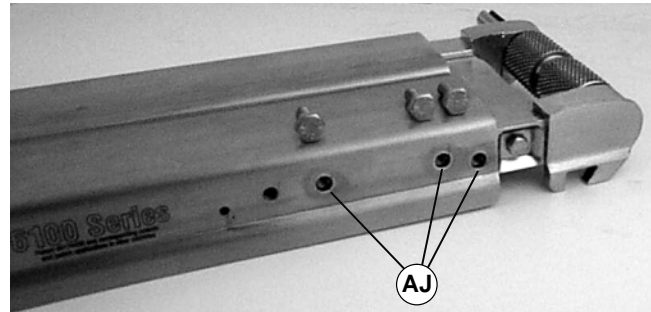


Figure 28

4. Remove the drive tail assembly.
5. Remove screw (AK of Figure 29).

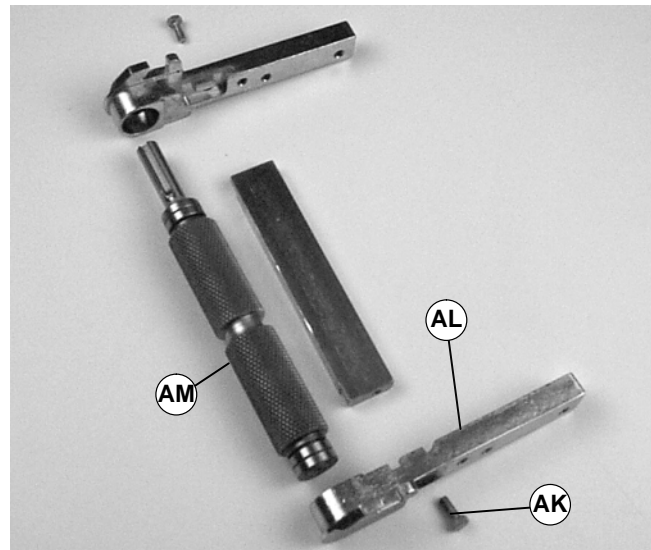


Figure 29

6. Remove headplate (AL).
7. Remove pulley (AM).

B – Idler Pulley Removal

1. Remove screw (W of Figure 30).
2. Remove four (4) tail plate mounting screws (AN of Figures 30 & 31).

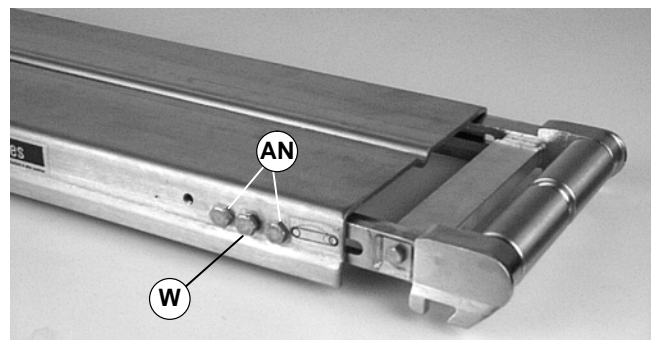


Figure 30

Preventive Maintenance and Adjustment

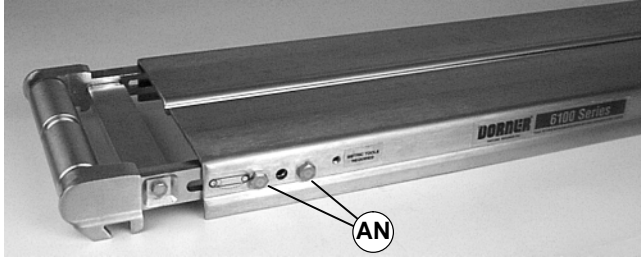


Figure 31

3. Remove tail assembly.
4. Remove screw (AK of Figure 32).

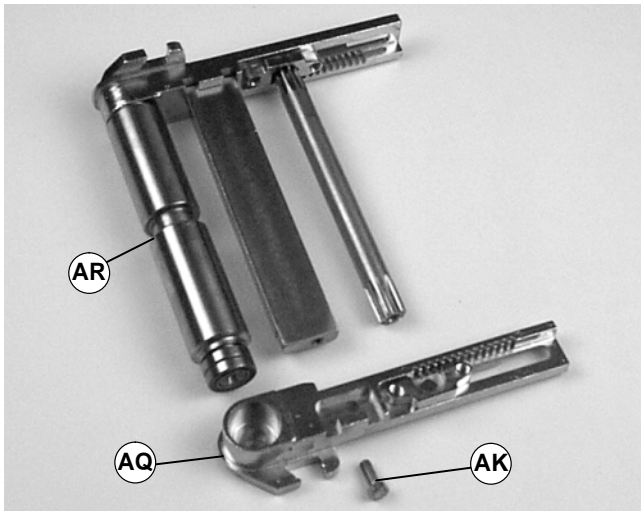


Figure 32

5. Remove headplate (AQ).
6. Remove pulley (AR).

C – Removal of Idler Pulley with Tool-less Belt Release

1. Remove handle (AO of Figure 33).

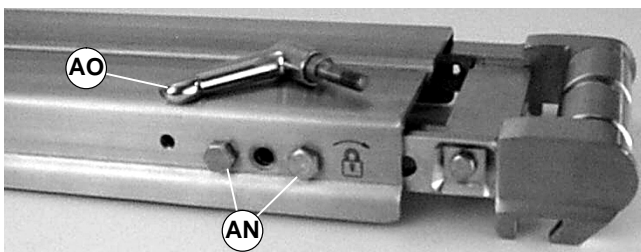


Figure 33

2. Remove two (2) screws (AN of Figure 33).

3. Remove two (2) screws (AN of Figure 34). Remove handle assembly (AP).

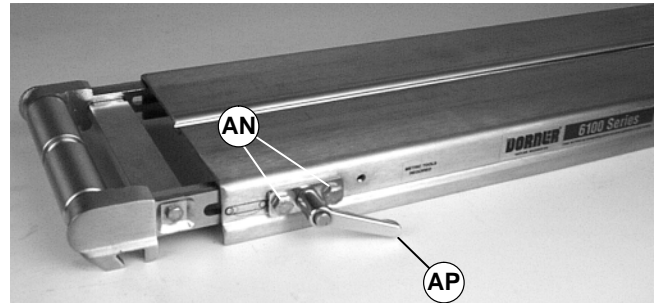


Figure 34

4. Remove tail assembly.
5. Remove screw (AK of Figure 32).
6. Remove headplate (AQ).
7. Remove pulley (AR).

Bearing Replacement

Bearing Removal

1. Place bearing removal tool (part # 450281) over bearing(s) with lip (AS of Figure 35) located in Bearing gap (AT) as shown.

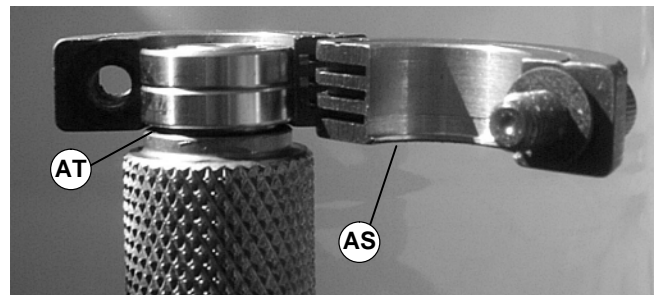


Figure 35

2. Using 3/16" hex key wrench (AU of Figure 36), tighten tool.

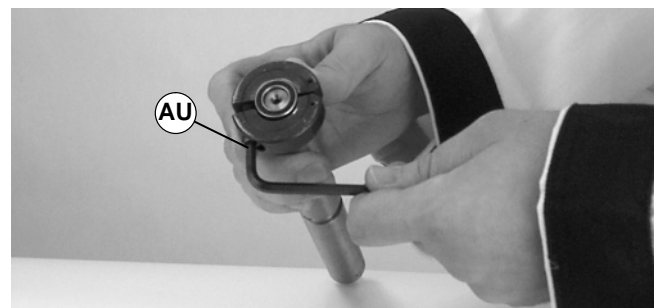


Figure 36

Preventive Maintenance and Adjustment

- Using a puller (AV of Figure 37), remove and discard bearing(s).

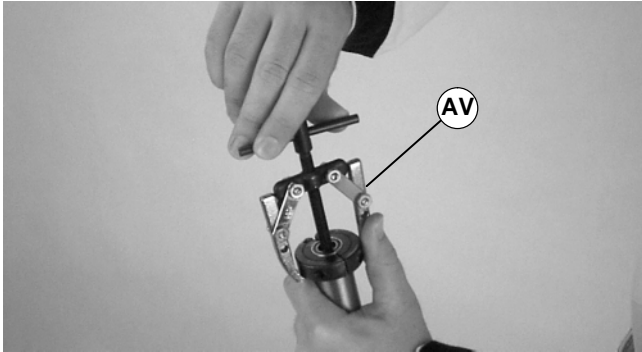


Figure 37

- Place open end of shaft (AY of Figure 40) into sleeve.

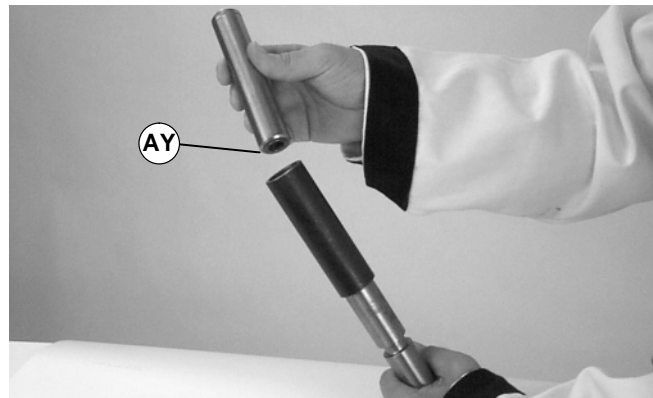


Figure 40

Bearing Installation

IMPORTANT: Install bearings one at a time.

- Inspect seating surface(s) for damage. Replace if damaged.
- Slide bearing (part # 802-120) (AW of Figure 38) onto pulley shaft.



Figure 38

- Slide the sleeve of tool (part # 450282) (AX of Figure 39) over bearing.

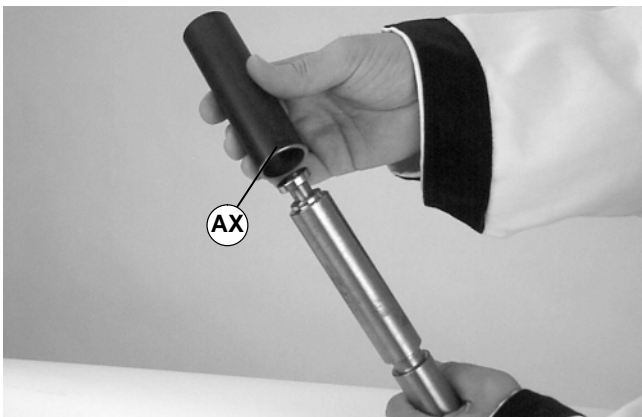


Figure 39

- Using arbor press or similar device, press bearing onto pulley shaft (see Figure 41).



Figure 41

- Repeat steps 1 through 5 for each bearing.

Preventive Maintenance and Adjustment

Drive Pulley Shaft Seal Replacement

1. Remove drive pulley from headplate. See “Pulley Removal” topic on page 12.
2. Push-out and discard old seal.
3. Install new seal (part # 807-1016) with grooved surface (AZ of Figure 42) facing out.

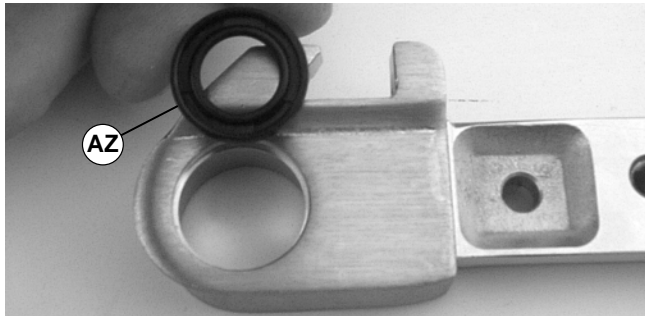


Figure 42

4. Using Food Grade Grease (part # 829-012), apply a small bead (BA) around entire edge of shaft hole in seal.

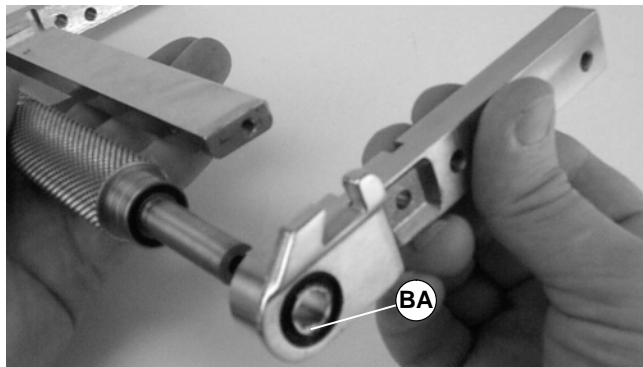


Figure 43

5. Re-install drive pulley per the following topic.

Pulley Replacement

Drive Pulley with Standard 0.47” (12 mm) Diameter Output Shaft

1. Reverse the removal procedure “A” (see page 12).

Idler Pulley

IMPORTANT: On tension tail, be sure to correctly orient components to match the factory orientation. Orient threaded hole side of pinion (BB of Figure 44) so it is toward detached tail plate as shown. Be sure both pinion housings (BC) engage the same tooth positions of racks as shown.

1. Reverse the removal procedure “B” (see page 12).

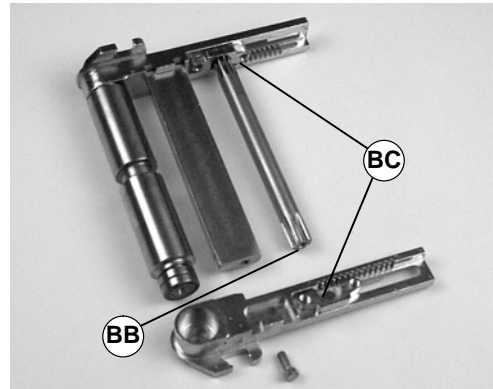


Figure 44

Idler Pulley with Tool-less Belt Release

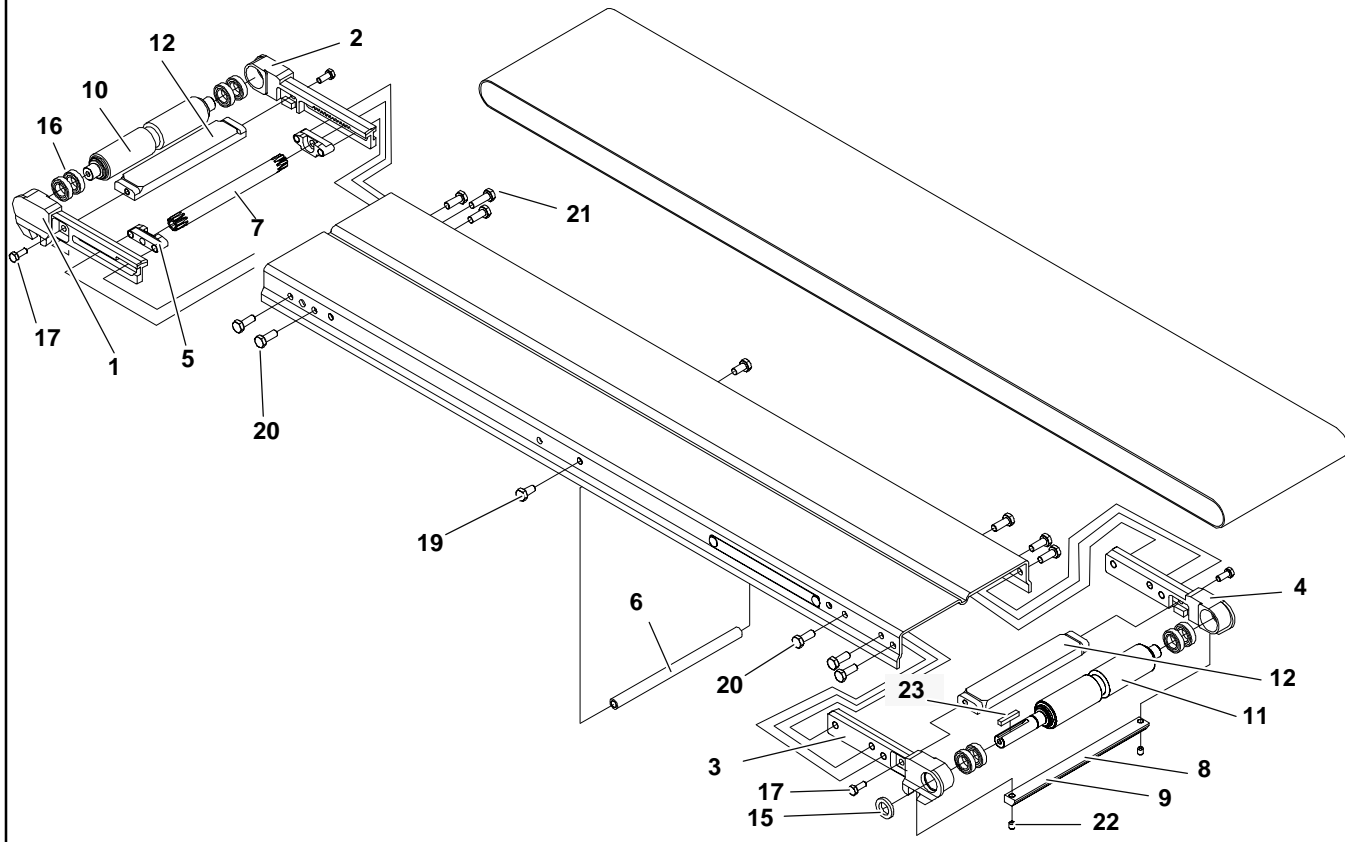
IMPORTANT: On tension tail, be sure to correctly orient components to match the factory orientation. Orient threaded hole side of pinion (BB of Figure 44) so it is toward detached tail plate as shown. Be sure both pinion housings (BC) engage the same tooth positions of racks as shown.

1. Reverse the removal procedure “C” (see page 13).

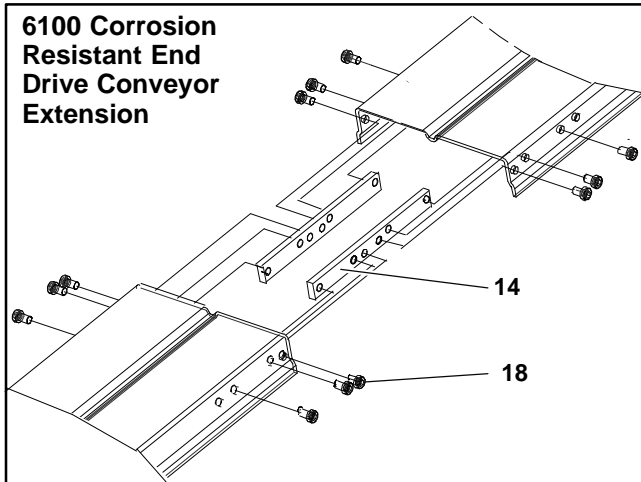
Service Parts

NOTE: For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory.

6100 Corrosion Resistant End Drive Conveyor



6100 Corrosion Resistant End Drive Conveyor Extension



Item	Part Number	Description
1	450231MSS	Tension Plate RH 2-3" Wide
	450031MSS	Tension Plate RH 4-18" Wide
2	450232MSS	Tension Plate LH 2-3" Wide
	450032MSS	Tension Plate LH 4-18" Wide

3	450233MSS	Fixed Plate, No Shaft, RH 2-3" Wide
	450033MSS	Fixed Plate, No Shaft, RH 4-18" Wide
	450243MSS	Fixed Plate, Shaft, RH 2-3" Wide
	450043MSS	Fixed Plate, Shaft, RH 4-18" Wide
4	450234MSS	Fixed Plate, No Shaft, LH 2-3" Wide
	450034MSS	Fixed Plate, No Shaft, LH 4-18" Wide
	450244MSS	Fixed Plate, Shaft, LH 2-3" Wide
	450044MSS	Fixed Plate, Shaft, LH 4-18" Wide
5	450039MSS	Pinion Retainer Block
6	452502MSS	Frame Support Post 2" (51mm)
	452503MSS	Frame Support Post 3" (76mm)
	452504MSS	Frame Support Post 4" (102mm)
	452505MSS	Frame Support Post 5" (127mm)
	452506MSS	Frame Support Post 6" (152mm)
	452508MSS	Frame Support Post 8" (203mm)
	452510MSS	Frame Support Post 10" (254mm)
	452512MSS	Frame Support Post 12" (305mm)
452518MSS	Frame Support Post 18" (457mm)	

Service Parts

7	453702MSS	Pinion 2" (51mm)
	453703MSS	Pinion 3" (76mm)
	453704MSS	Pinion 4" (102mm)
	453705MSS	Pinion 5" (127mm)
	453706MSS	Pinion 6" (152mm)
	453708MSS	Pinion 8" (203mm)
	453710MSS	Pinion 10" (254mm)
	453712MSS	Pinion 12" (305mm)
	453718MSS	Pinion 18" (457mm)
8	452702SS	Bottom Wiper 2" (51mm)
	452703SS	Bottom Wiper 3" (76mm)
	452704SS	Bottom Wiper 4" (102mm)
	452705SS	Bottom Wiper 5" (127mm)
	452706SS	Bottom Wiper 6" (152mm)
	452708SS	Bottom Wiper 8" (203mm)
	452710SS	Bottom Wiper 10" (254mm)
	452712SS	Bottom Wiper 12" (305mm)
	452718SS	Bottom Wiper 18" (457mm)
9	452802SS	Bottom Bar 2" (51mm)
	452803SS	Bottom Bar 3" (76mm)
	452804SS	Bottom Bar 4" (102mm)
	452805SS	Bottom Bar 5" (127mm)
	452806SS	Bottom Bar 6" (152mm)
	452808SS	Bottom Bar 8" (203mm)
	452810SS	Bottom Bar 10" (254mm)
	452812SS	Bottom Bar 12" (305mm)
	452818SS	Bottom Bar 18" (457mm)
10	452902SS	Idler Spindle 2" (51mm)
	452903SS	Idler Spindle 3" (76mm)
	452904SS	Idler Spindle 4" (102mm)
	452905SS	Idler Spindle 5" (127mm)
	452906SS	Idler Spindle 6" (152mm)
	452908SS	Idler Spindle 8" (203mm)
	452910SS	Idler Spindle 10" (254mm)
	452912SS	Idler Spindle 12" (305mm)
	452918SS	Idler Spindle 18" (457mm)
11	453102M	Drive Spindle 2" (51mm)
	453103M	Drive Spindle 3" (76mm)
	453104M	Drive Spindle 4" (102mm)
	453105M	Drive Spindle 5" (127mm)
	453106M	Drive Spindle 6" (152mm)
	453108M	Drive Spindle 8" (203mm)
	453110M	Drive Spindle 10" (254mm)
	453112M	Drive Spindle 12" (305mm)
	453118M	Drive Spindle 18" (457mm)

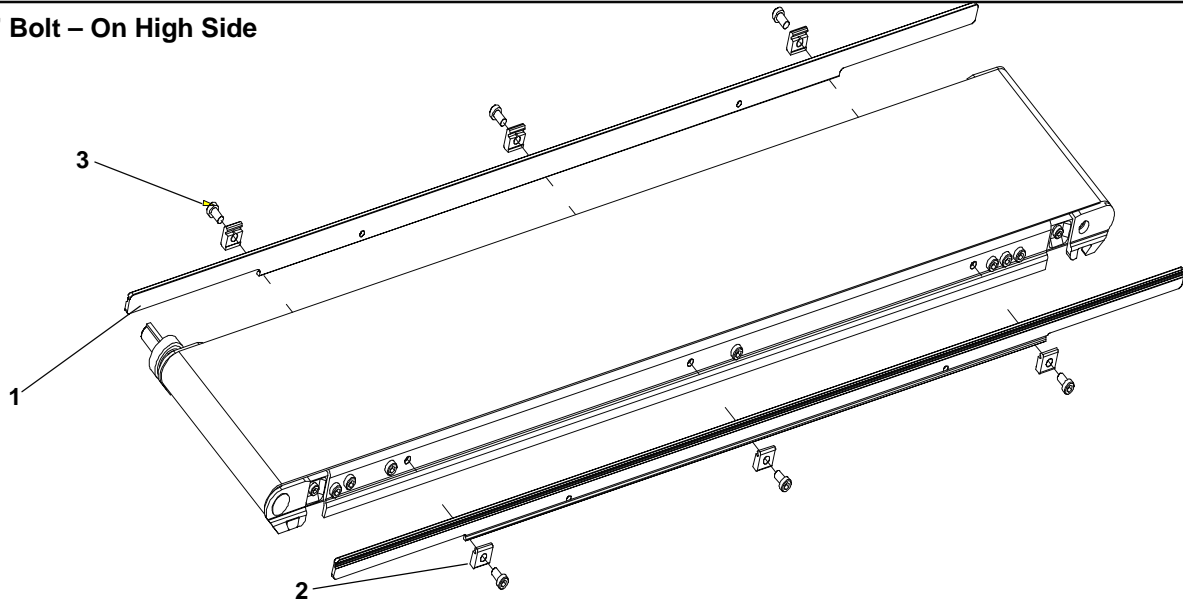
12	453802MSS	Fixed Tension Support 2" (51mm)
	453803MSS	Fixed Tension Support 3" (76mm)
	453804MSS	Fixed Tension Support 4" (102mm)
	453805MSS	Fixed Tension Support 5" (127mm)
	453806MSS	Fixed Tension Support 6" (152mm)
	453808MSS	Fixed Tension Support 8" (203mm)
	453810MSS	Fixed Tension Support 10" (254mm)
	453812MSS	Fixed Tension Support 12" (305mm)
	453818MSS	Fixed Tension Support 18" (457mm)
13	See chart below	6100 Conveyor Frame
14	450160MSS	Bar Connecting Frame
15	807-1016	Lip Seal
16	802-120	Ball Bearing 12mm (Bore) x 21mm (OD)
17	960512MSS	Hex Head Screw M5-.80 x 12mm
18	960610MSS	Hex Head Screw M6-1.0 x 10mm
19	960612MSS	Hex Head Screw M6-1.0 x 12mm
20	960616MSS	Hex Head Screw M6-1.0 x 16mm
21	960620MSS	Hex Head Screw M6-1.0 x 20mm
22	907-159	Socket Head Set Screw #10-32 x .25"
23	980422M	Key Square 4mm x 22mm

Item 13: 6100 Conveyor Frame	
Length	Part Number(s)
2' (610mm)	47WW02M
3' (914mm)	47WW03M
4' (1219mm)	47WW04M
5' (1524mm)	47WW05M
6' (1829mm)	47WW06M
7' (2134mm)	47WW07M
8' (2438mm)	47WW08M
9' (2743mm)	47WW09M
10' (3048mm)	47WW10M
11' (3353mm)	47WW11M
12' (3658mm)	47WW12M
13' (3962mm)	47WW07M 47WW13M
14' (4267mm)	47WW08M 47WW13M
15' (4572mm)	47WW09M 47WW13M
16' (4877mm)	47WW09M 47WW13M
17' (5182mm)	47WW09M 47WW13M
18' (5486mm)	47WW09M 47WW13M
19' (5791mm)	47WW09M 47WW13M
20' (6096mm)	47WW09M 47WW13M
21' (6401mm)	47WW09M 47WW13M
22' (6706mm)	47WW09M 47WW13M
23' (7011mm)	47WW09M 47WW13M
24' (7316mm)	47WW09M 47WW13M

WW = frame width reference: 02, 03, 04, 05, 06, 08, 10, 12, 18

Service Parts

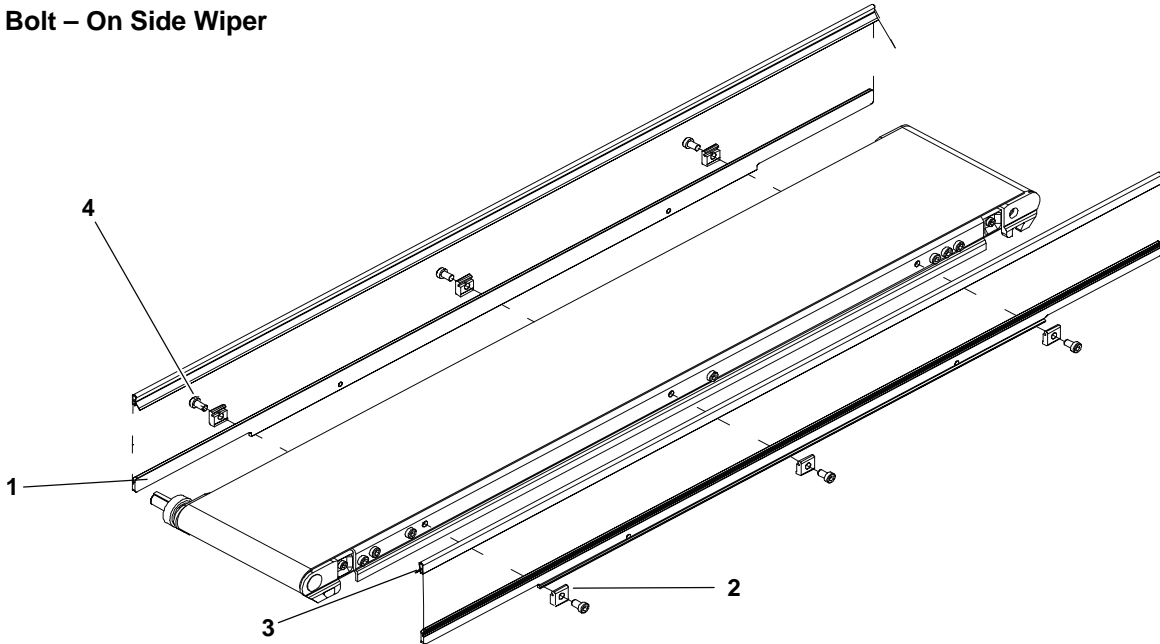
-02 .5" Bolt – On High Side



Item	Part Number	Description
1	460232	Rail Guide .5" HS x 2' (610mm)
	460233	Rail Guide .5" HS x 3' (914mm)
	460234	Rail Guide .5" HS x 4' (1219mm)
	460235	Rail Guide .5" HS x 5' (1524mm)
	460236	Rail Guide .5" HS x 6' (1829mm)

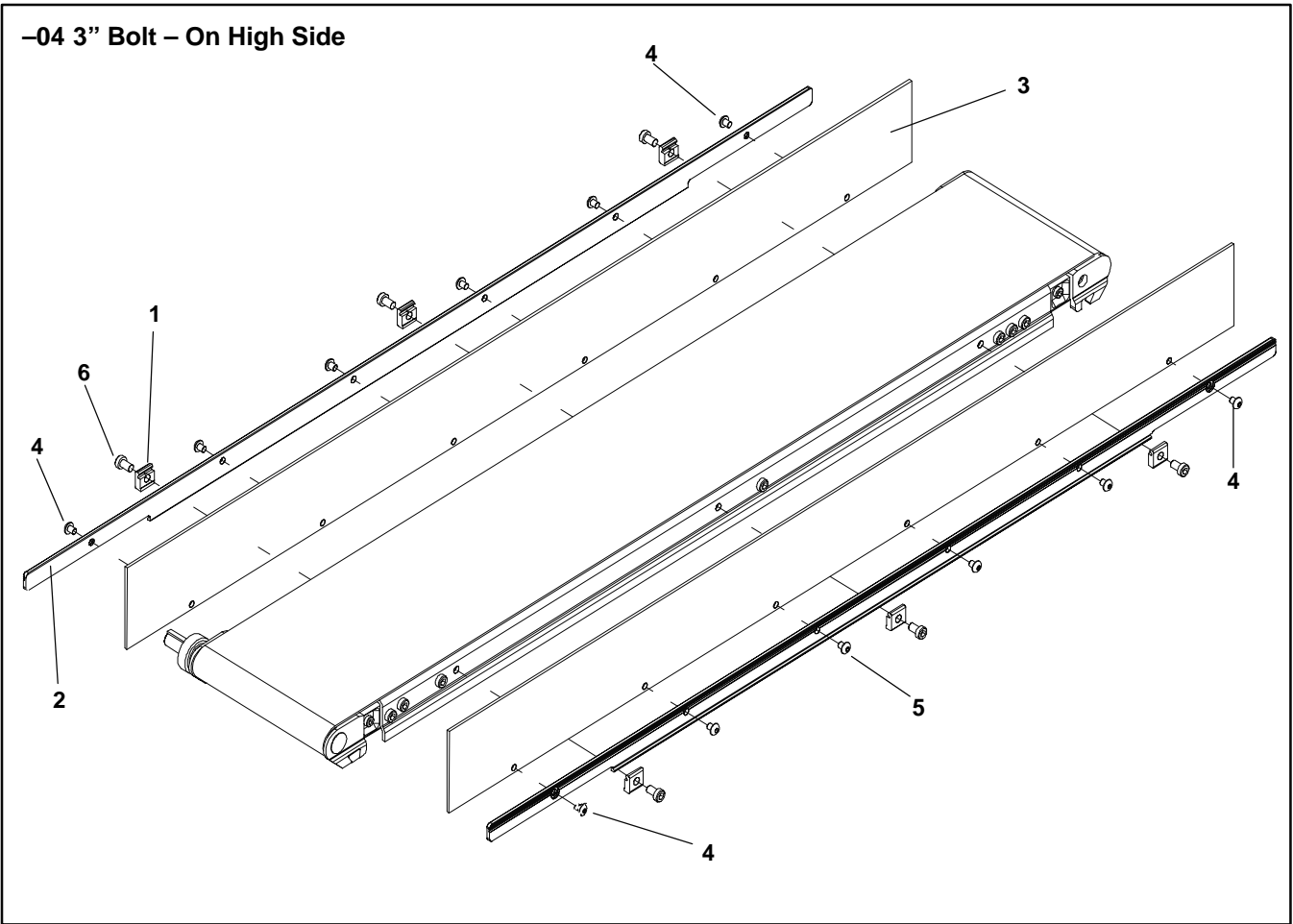
2	460250	Clip Mounting Guide
3	920691M	Socket Head Cap Screw (Metric) Low M6-1.00 x 10mm

-03 Bolt – On Side Wiper



Item	Part Number	Description
1	460232	Rail Guide .5" HS x 2' (610mm)
	460233	Rail Guide .5" HS x 3' (914mm)
	460234	Rail Guide .5" HS x 4' (1219mm)
	460235	Rail Guide .5" HS x 5' (1524mm)
	460236	Rail Guide .5" HS x 6' (1829mm)

2	460250	Clip Mounting Guide
3	41-00-24	Wiper Side Nylatron (per foot)
4	920691M	Socket Head Cap Screw (Metric) M6-1.0 x 10mm

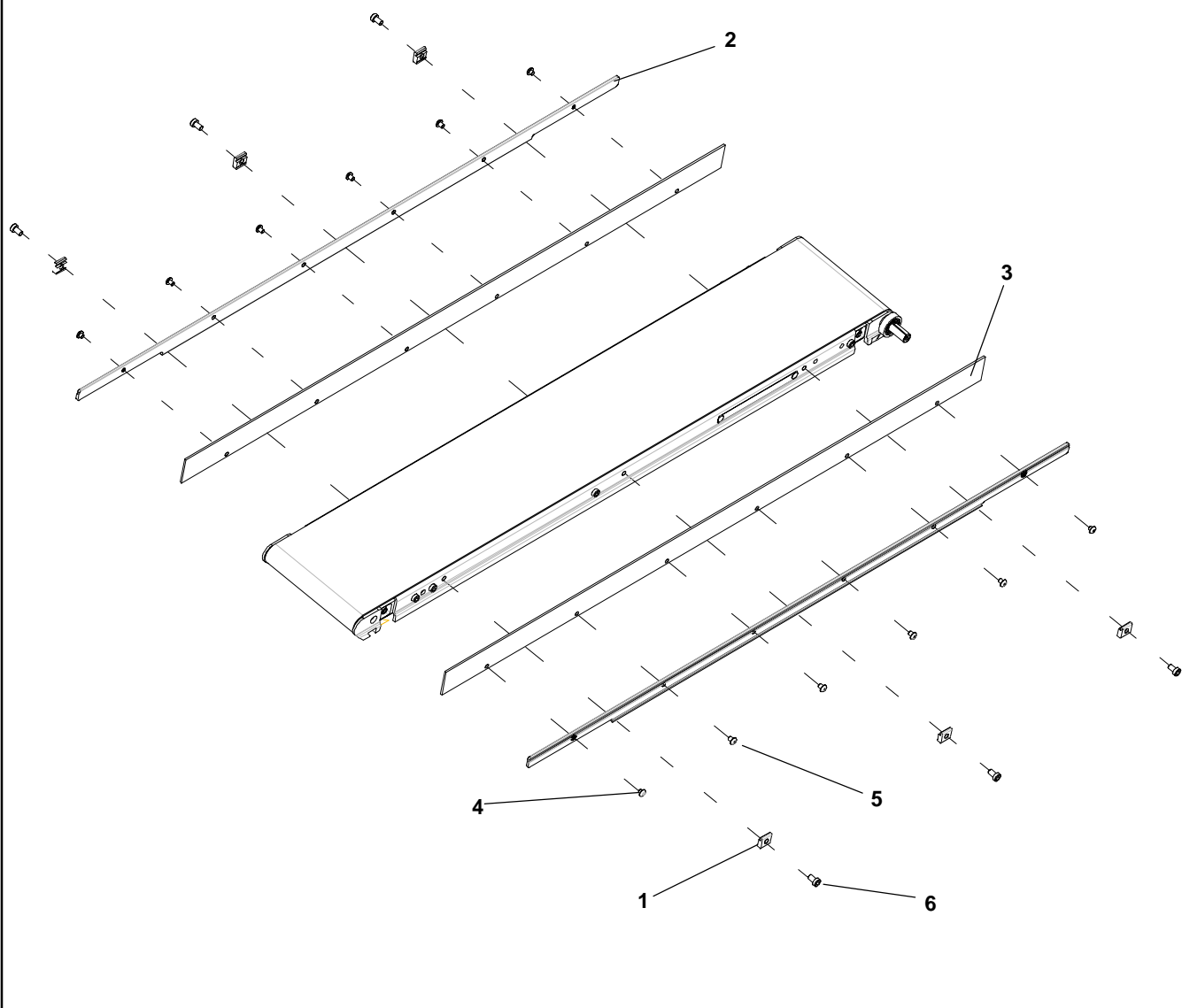


Item	Part Number	Description
1	460250	Clip Mounting Guide
2	460432	Rail guide .5" HS w/holes 2' (610mm)
	460433	Rail guide .5" HS w/holes 3' (914mm)
	460434	Rail guide .5" HS w/holes 4' (1219mm)
	460435	Rail guide .5" HS w/holes 5' (1524mm)
	460436	Rail guide .5" HS w/holes 6' (1829mm)
3	460452M	Guide Side #4 – 2' (610mm)
	460453M	Guide Side #4 – 3' (914mm)
	460454M	Guide Side #4 – 4' (1219mm)
	460455M	Guide Side #4 – 5' (1524mm)
	460456M	Guide Side #4 – 6' (1829mm)

4	910504M	Socket Head Cap Screw Button (Metric) M5 – .80 x 4mm
5	910506M	Socket Head Cap Screw Button (Metric) M5–.80 x 6mm
6	920691M	Socket Head Cap Screw (Metric) M6–1.0 x 10MM

Service Parts

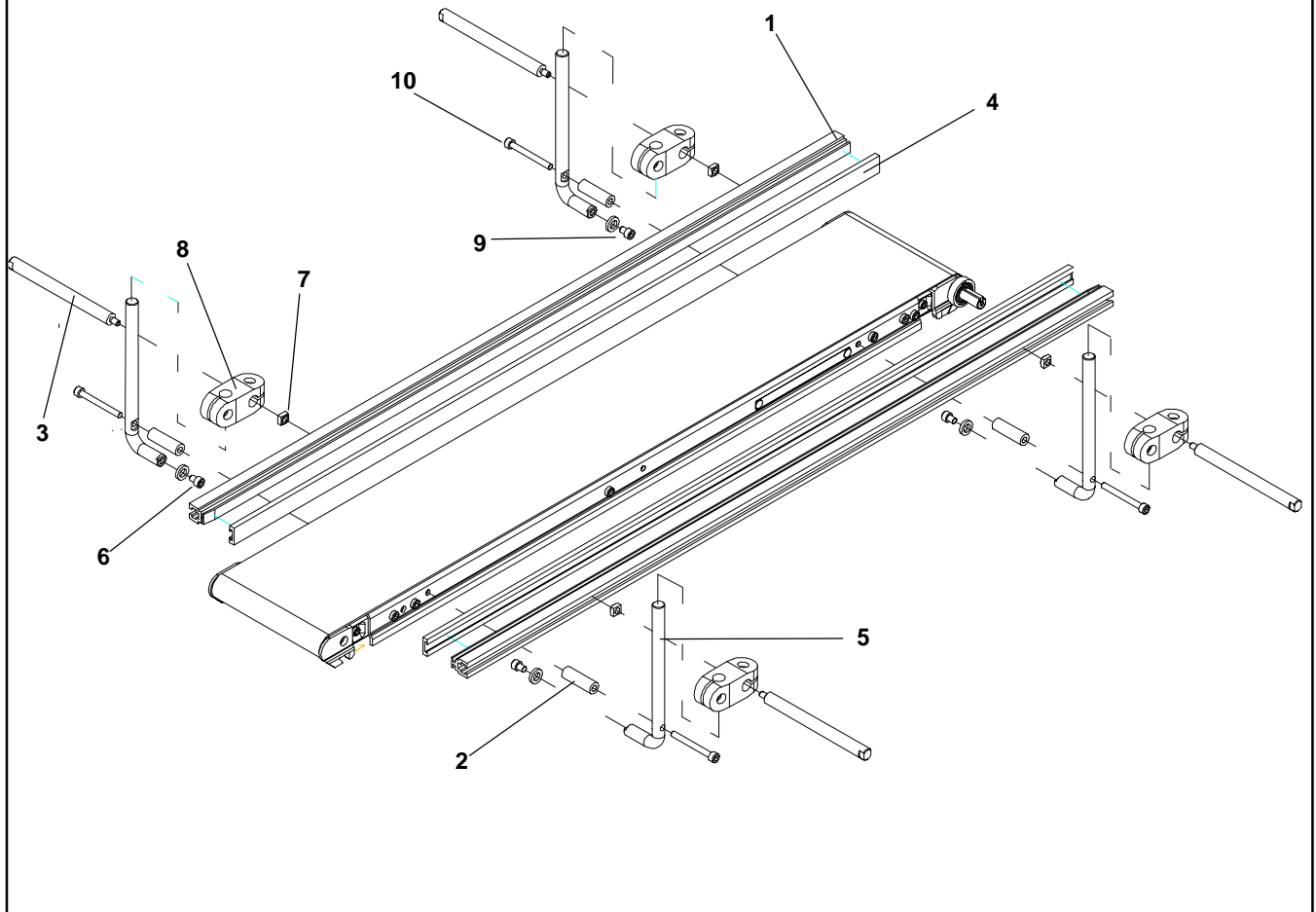
-05 1.5" Bolt – On High Side



Item	Part Number	Description
1	460250	Guide Mounting Clip
2	460432	Rail guide .5" HS w/holes 2' (610mm)
	460433	Rail guide .5" HS w/holes 3' (914mm)
	460434	Rail guide .5" HS w/holes 4' (1219mm)
	460435	Rail guide .5" HS w/holes 5' (1524mm)
	460436	Rail guide .5" HS w/holes 6' (1829mm)
3	460452M	Guide Side #4 – 2' (610mm)
	460453M	Guide Side #4 – 3' (914mm)
	460454M	Guide Side #4 – 4' (1219mm)
	460455M	Guide Side #4 – 5' (1524mm)
	460456M	Guide Side #4 – 6' (1829mm)

4	910504M	Socket Head Cap Screw Button (Metric) M5-.80 x 4mm
5	910506M	Socket Head Cap Screw Button (Metric) M5-.80 x 6mm
6	920691M	Socket Head Cap Screw (Metric) Low M6-1.0 x 10mm

-13 Fully Adjustable UHMW Guide

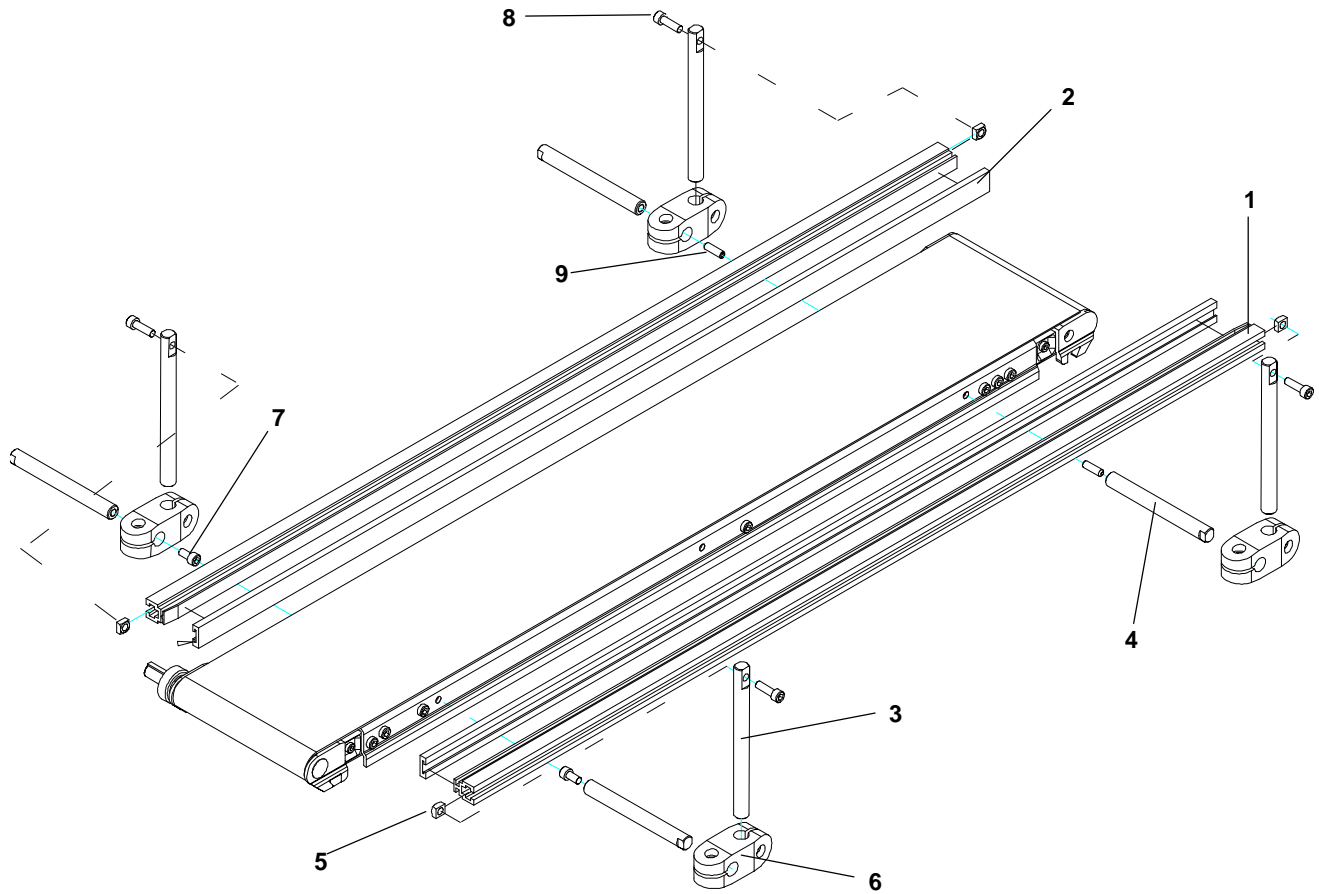


Item	Part Number	Description
1	202983	Guide Mounting Rail 2' (610mm)
	202984	Guide Mounting Rail 3' (914mm)
	202985	Guide Mounting Rail 4' (1219mm)
	202986	Guide Mounting Rail 5' (1524mm)
	202987	Guide Mounting Rail 6' (1829mm)
	202988	Guide Mounting Rail 7' (2134mm)
	202989	Guide Mounting Rail 8' (2438mm)
	202990	Guide Mounting Rail 9' (2743mm)
	202991	Guide Mounting Rail 10' (3053mm)
	202992	Guide Mounting Rail 11' (3353mm)
	202993	Guide Mounting Rail 12' (3658mm)
	202994	Guide Mounting Rail 13' (3962mm)

2	461351	Shaft Brace
3	202028M	Horizontal Shaft Mounting Guide
4	614068	Guide Extruded Flat (per foot)
5	461350M	Vertical Shaft Adj Guide
6	605279M	Hard washer
7	674175MP	Square Nut M6-1.0 w/1/4-20
8	807-652	Cross Block
9	920608M	Socket Head Cap Screw (Metric) M6-1.0 x 8mm
10	920655M	Socket Head Cap Screw (Metric) M6-1.0 x 55mm

Service Parts

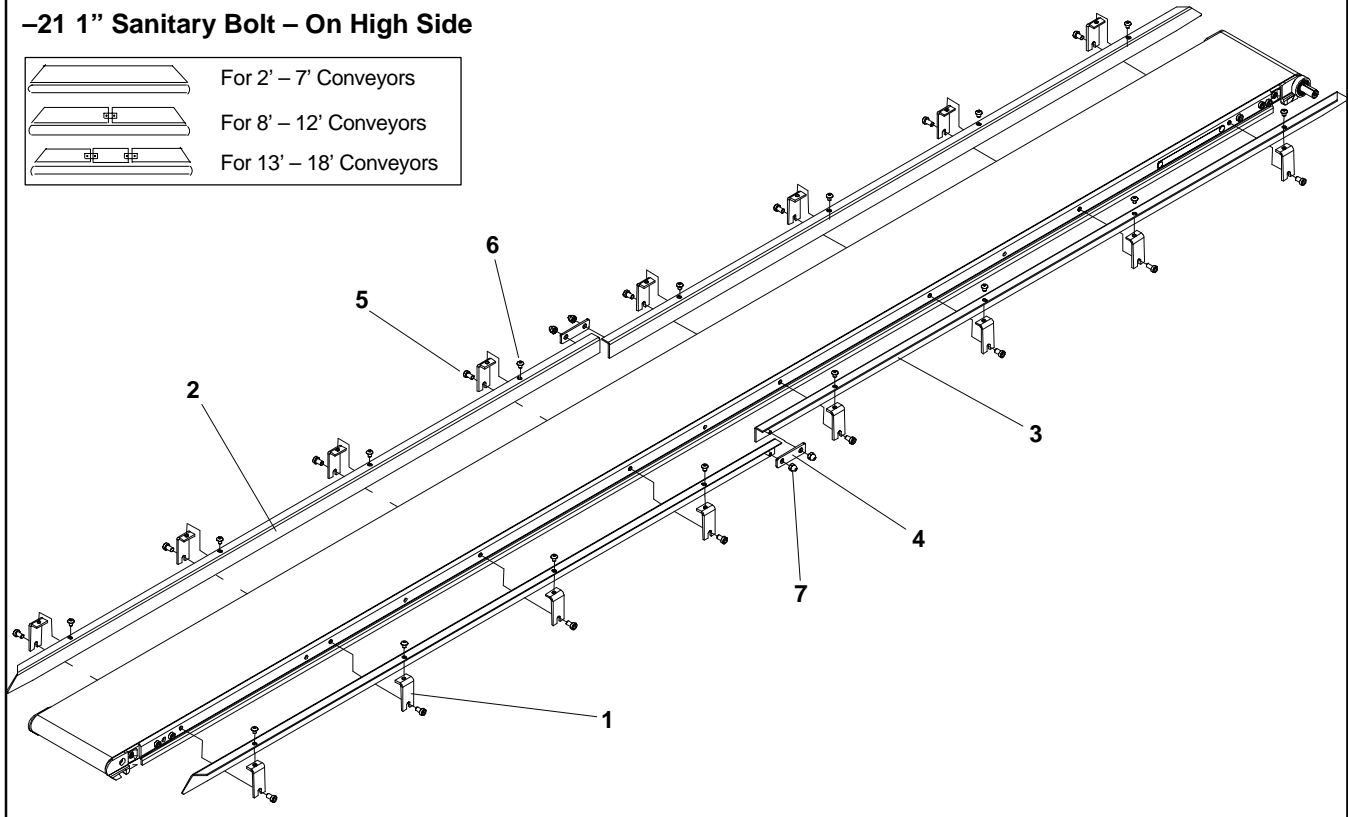
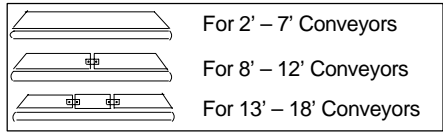
-20 Adjustable Width UHMW Guide



Item	Part Number	Description
1	202983	Guide Mounting Rail 2' (610mm)
	202984	Guide Mounting Rail 3' (914mm)
	202985	Guide Mounting Rail 4' (1219mm)
	202986	Guide Mounting Rail 5' (1524mm)
	202987	Guide Mounting Rail 6' (1829mm)
	202988	Guide Mounting Rail 7' (2134mm)
	202989	Guide Mounting Rail 8' (2438mm)
	202990	Guide Mounting Rail 9' (2743mm)
	202991	Guide Mounting Rail 10' (3048mm)
	202992	Guide Mounting Rail 11' (3353mm)
	202993	Guide Mounting Rail 12' (3658mm)
	202994	Guide Mounting Rail 13' (3962mm)

2	614068	Guide extruded flat (per foot)
3	462050M	Vertical Shaft Gullwing Guide
4	462052M	Horizontal Shaft Gullwing Guide
5	674175MP	Square Nut M6-1.0 w/1/4-20
6	807-652	Cross Block
7	920612M	Socket Head Cap Screw (Metric) M6-1.0 x 12mm
8	920620M	Socket Head Cap Screw (Metric) M6-1.0 x 20mm
9	970620M	Socket Head Set Screw (Metric) M6-1.0 x 20mm

-21 1" Sanitary Bolt – On High Side




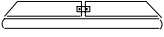
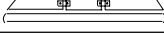
Item	Part Number	Description
1	462150MSS	1" Guide Mounting Bracket
2	See chart below	1" Guide RH
3	See chart below	1" Guide LH
4	450188SS	Guide Tie Plate
5	960608MSS	M6-1.0 x 8mm Hex Head Screw
6	960506MSS	M5-0.8 x 6mm Hex Head Screw
7	990508MSS	M5 Acorn Nut

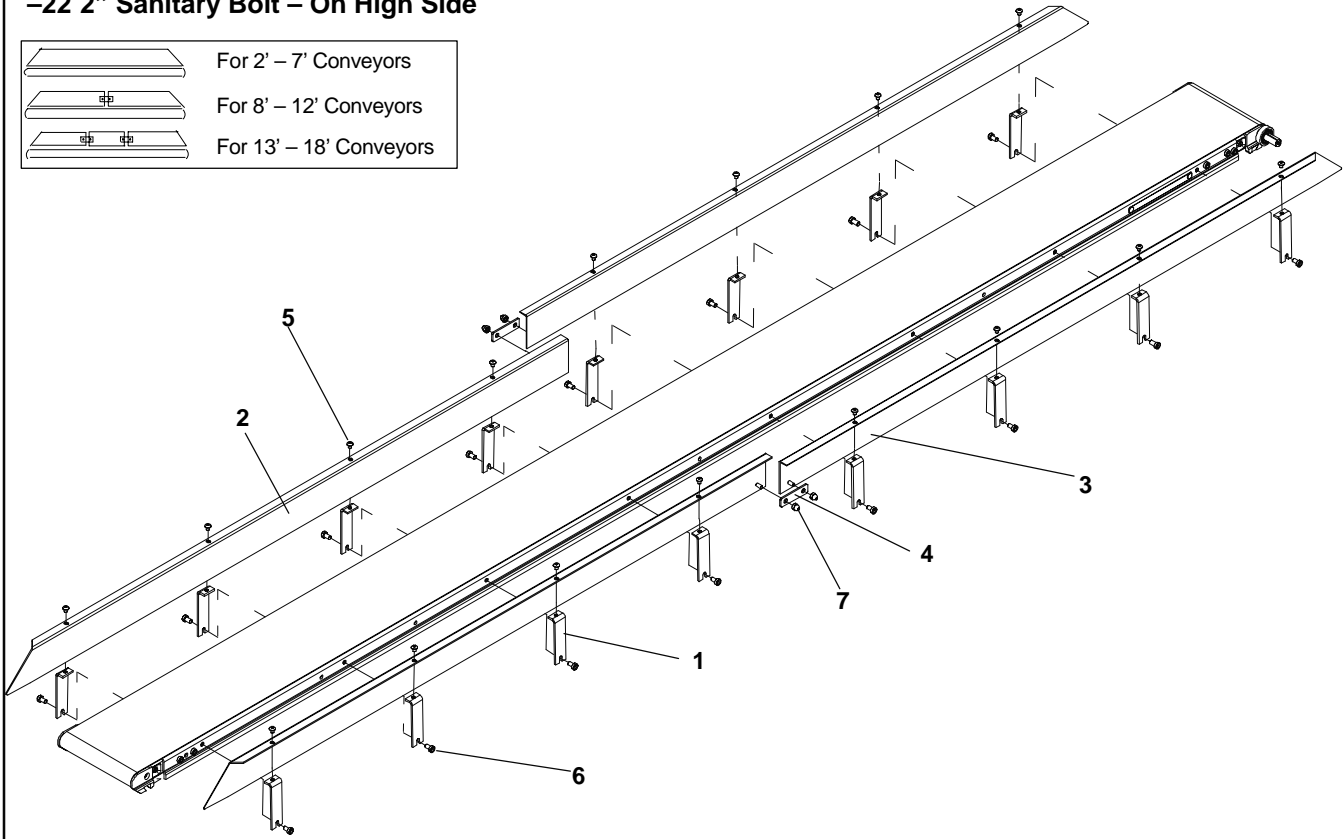
Conveyor Length		End Guide	Center Guide	End Guide
2' (610mm)	Right Hand	462132SSP	N/A	N/A
	Left Hand	462132SSP	N/A	N/A
3' (914mm)	Right Hand	462133SSP	N/A	N/A
	Left Hand	462133SSP	N/A	N/A
4' (1219mm)	Right Hand	462134SSP	N/A	N/A
	Left Hand	462134SSP	N/A	N/A
5' (1524mm)	Right Hand	462135SSP	N/A	N/A
	Left Hand	462135SSP	N/A	N/A
6' (1829mm)	Right Hand	462136SSP	N/A	N/A
	Left Hand	462136SSP	N/A	N/A
7' (2134mm)	Right Hand	462137SSP	N/A	N/A
	Left Hand	462137SSP	N/A	N/A

8' (2438mm)	Right Hand	462144SSP	N/A	462154SSP
	Left Hand	462154SSP	N/A	462144SSP
9' (2743mm)	Right Hand	462144SSP	N/A	462154SSP
	Left Hand	462145SSP	N/A	462155SSP
10' (3048mm)	Right Hand	462155SSP	N/A	462145SSP
	Left Hand	462145SSP	N/A	462155SSP
11' (3353mm)	Right Hand	462146SSP	N/A	462156SSP
	Left Hand	462145SSP	N/A	462155SSP
12' (3658mm)	Right Hand	462146SSP	N/A	462156SSP
	Left Hand	462156SSP	N/A	462146SSP
13' (3962mm)	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462144SSP	462163SSP	462154SSP
14' (4267mm)	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462145SSP	462163SSP	462155SSP
15' (4572mm)	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462156SSP	462163SSP	462146SSP
16' (4877mm)	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462144SSP	462166SSP	462154SSP
17' (5182mm)	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462145SSP	462166SSP	462155SSP
18' (5486mm)	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462156SSP	462166SSP	462146SSP

Service Parts

-22 2" Sanitary Bolt – On High Side

	For 2' – 7' Conveyors
	For 8' – 12' Conveyors
	For 13' – 18' Conveyors

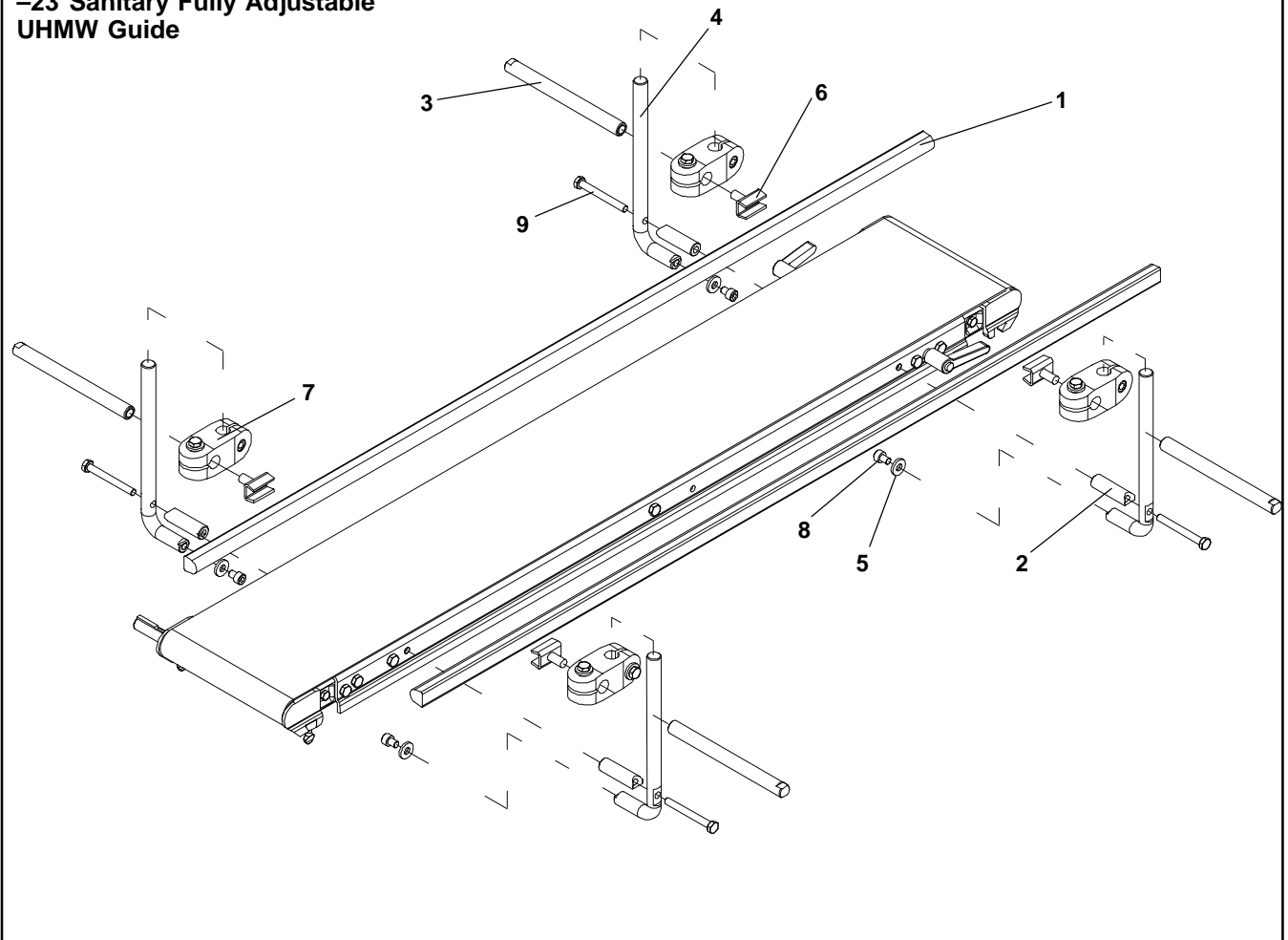


Item	Part Number	Description
1	462250MSS	2" Guide Mounting Bracket
2	See chart below	2" Guide RH
3	See chart below	2" Guide LH
4	450188SS	Guide Tie Plate
5	960608MSS	M6-1.0 x 10mm Hex Head Screw
6	960506MSS	M5-0.8 x 6mm Hex Head Screw
7	990508MSS	M5 Acorn Nut

Conveyor Length		End Guide	Center Guide	End Guide
2' (610mm)	Right Hand	462232SSP	N/A	N/A
	Left Hand	462232SSP	N/A	N/A
3' (914mm)	Right Hand	462233SSP	N/A	N/A
	Left Hand	462233SSP	N/A	N/A
4' (1219mm)	Right Hand	462234SSP	N/A	N/A
	Left Hand	462234SSP	N/A	N/A
5' (1524mm)	Right Hand	462235SSP	N/A	N/A
	Left Hand	462235SSP	N/A	N/A
6' (1829mm)	Right Hand	462236SSP	N/A	N/A
	Left Hand	462236SSP	N/A	N/A
7' (2134mm)	Right Hand	462237SSP	N/A	N/A
	Left Hand	462237SSP	N/A	N/A

8' (2438mm)	Right Hand	462244SSP	N/A	462254SSP
	Left Hand	462254SSP	N/A	462244SSP
9' (2743mm)	Right Hand	462244SSP	N/A	462254SSP
	Left Hand	462245SSP	N/A	462255SSP
10' (3048mm)	Right Hand	462255SSP	N/A	462245SSP
	Left Hand	462245SSP	N/A	462255SSP
11' (3353mm)	Right Hand	462246SSP	N/A	462256SSP
	Left Hand	462245SSP	N/A	462255SSP
12' (3658mm)	Right Hand	462246SSP	N/A	462256SSP
	Left Hand	462256SSP	N/A	462246SSP
13' (3962mm)	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462244SSP	462263SSP	462254SSP
14' (4267mm)	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462245SSP	462263SSP	462255SSP
15' (4572mm)	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462256SSP	462263SSP	462246SSP
16' (4877mm)	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462244SSP	462266SSP	462254SSP
17' (5182mm)	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462245SSP	462266SSP	462255SSP
18' (5486mm)	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462256SSP	462266SSP	462246SSP

-23 Sanitary Fully Adjustable UHMW Guide

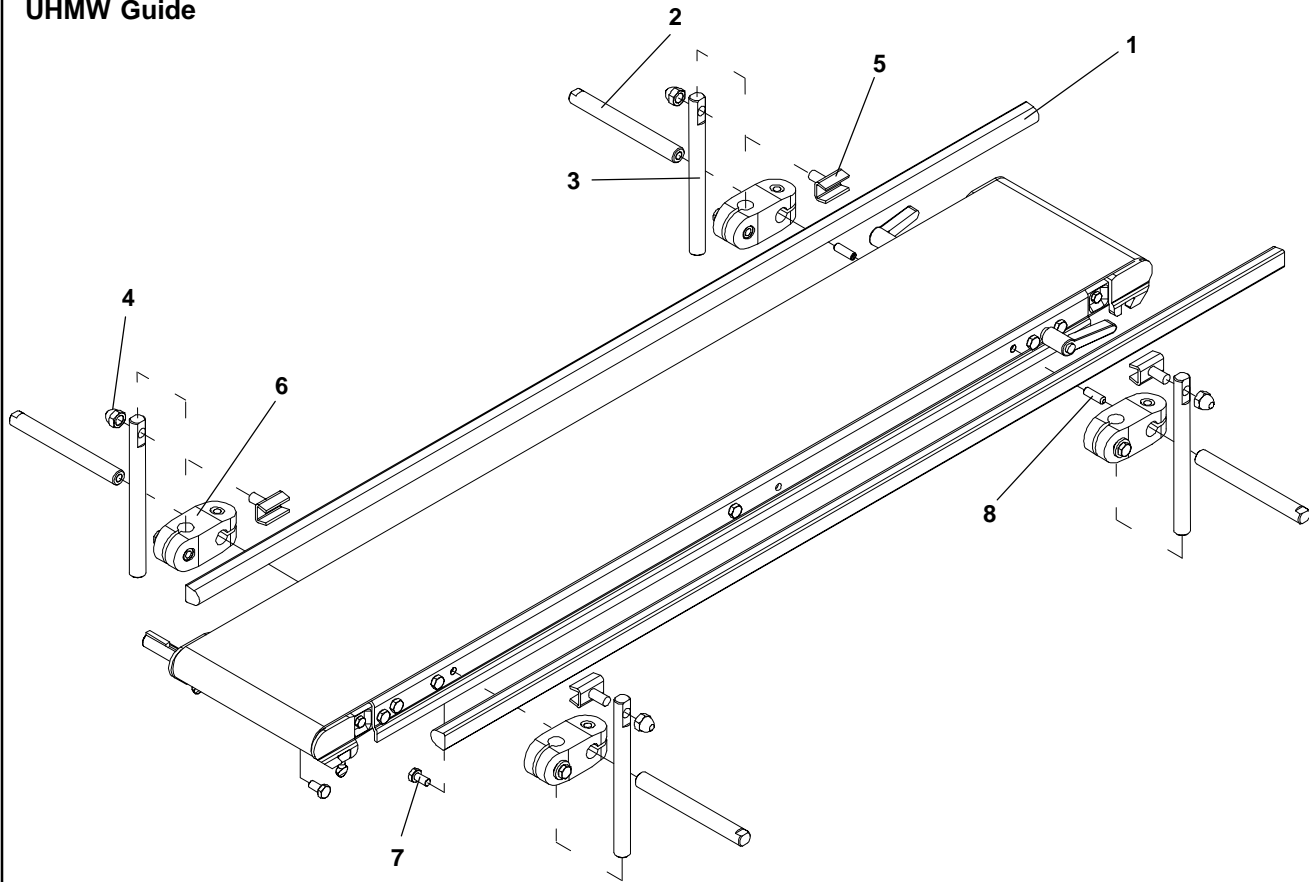


Item	Part Number(s)	Description
1	462332	Guide Mounting Rail 2' (610mm)
	462333	Guide Mounting Rail 3' (914mm)
	462334	Guide Mounting Rail 4' (1219mm)
	462335	Guide Mounting Rail 5' (1524mm)
	462336	Guide Mounting Rail 6' (1829mm)
	462337	Guide Mounting Rail 7' (2134mm)
	462338	Guide Mounting Rail 8' (2438mm)
	462339	Guide Mounting Rail 9' (2743mm)
	462340	Guide Mounting Rail 10' (3053mm)
	462341	Guide Mounting Rail 11' (3353mm)
	462342	Guide Mounting Rail 12' (3658mm)
	462337 462336	Guide Mounting Rail 13' (3962mm)
	462337 462337	Guide Mounting Rail 14' (4267mm)
	462338 462337	Guide Mounting Rail 15' (4572mm)
	462338 462338	Guide Mounting Rail 16' (4877mm)
	462339 462338	Guide Mounting Rail 17' (5182mm)
	462339 462339	Guide Mounting Rail 18' (5486mm)

2	462351MSS	Shaft Brace
3	462352MSS	Horizontal Shaft Mounting Guide
4	462350MSS	Vertical Shaft Adjustable Guide
5	911-201	Flat Washer
6	807-978	Guide Clamp
7	450787MSS	Cross Block
8	960608MSS	Hex Head Screw (Metric) M6-1.0 x 8mm
9	960655MSS	Hex Head Screw (Metric) M6-1.0 x 55mm

Service Parts

-24 Sanitary Adjustable Width UHMW Guide



Item	Part Number(s)	Description
1	462332	Guide Mounting Rail 2' (610mm)
	462333	Guide Mounting Rail 3' (914mm)
	462334	Guide Mounting Rail 4' (1219mm)
	462335	Guide Mounting Rail 5' (1524mm)
	462336	Guide Mounting Rail 6' (1829mm)
	462337	Guide Mounting Rail 7' (2134mm)
	462338	Guide Mounting Rail 8' (2438mm)
	462339	Guide Mounting Rail 9' (2743mm)
	462340	Guide Mounting Rail 10' (3053mm)
	462341	Guide Mounting Rail 11' (3353mm)
	462342	Guide Mounting Rail 12' (3658mm)
	462337 462336	Guide Mounting Rail 13' (3962mm)
	462337 462337	Guide Mounting Rail 14' (4267mm)
	462338 462337	Guide Mounting Rail 15' (4572mm)
	462338 462338	Guide Mounting Rail 16' (4877mm)
	462339 462338	Guide Mounting Rail 17' (5182mm)
	462339 462339	Guide Mounting Rail 18' (5486mm)

2	462452MSS	Horizontal Shaft Gullwing Guide
3	462450MSS	Vertical Shaft Gullwing Guide
4	807-977	Acorn Nut
5	807-978	Guide Clamp
6	450187MSS	Cross Block
7	960612MSS	Hex Head Cap Screw (Metric) M6-1.0 x 12mm
8	970620MSS	Socket Head Set Screw (Metric) M6-1.0 x 20mm

Configuring Conveyor Belt Part Number

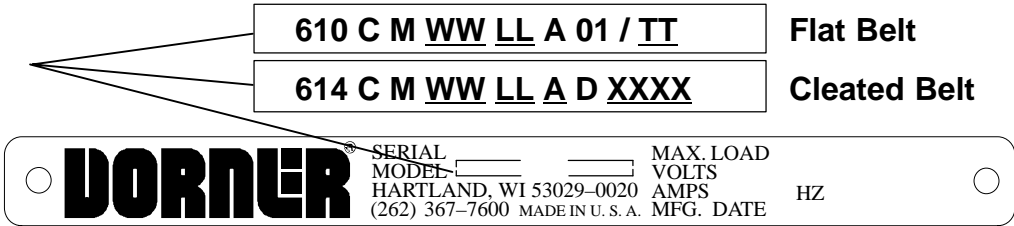


Figure 45

Flat Belt Conveyor

Refer to your serial and model number plate (Figure 45). Determine conveyor length (“LL”), width (“WW”) and belt type (“TT”).

61 - WW LL / TT

61- _____ / _____
(Fill In)

Cleated Belt Conveyor

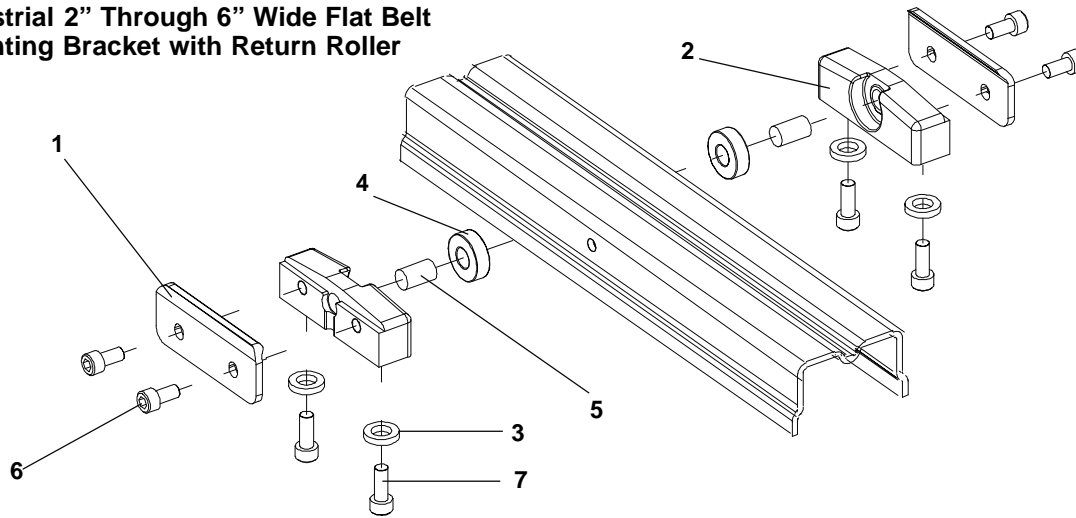
Refer to your serial and model number plate (Figure 45). Determine conveyor length (“LL”), width (“WW”), cleat type (“AA”) and cleat spacing (“XXXX”).

64 - WW LL AA XXXX

64 - _____
(Fill In)

Service Parts

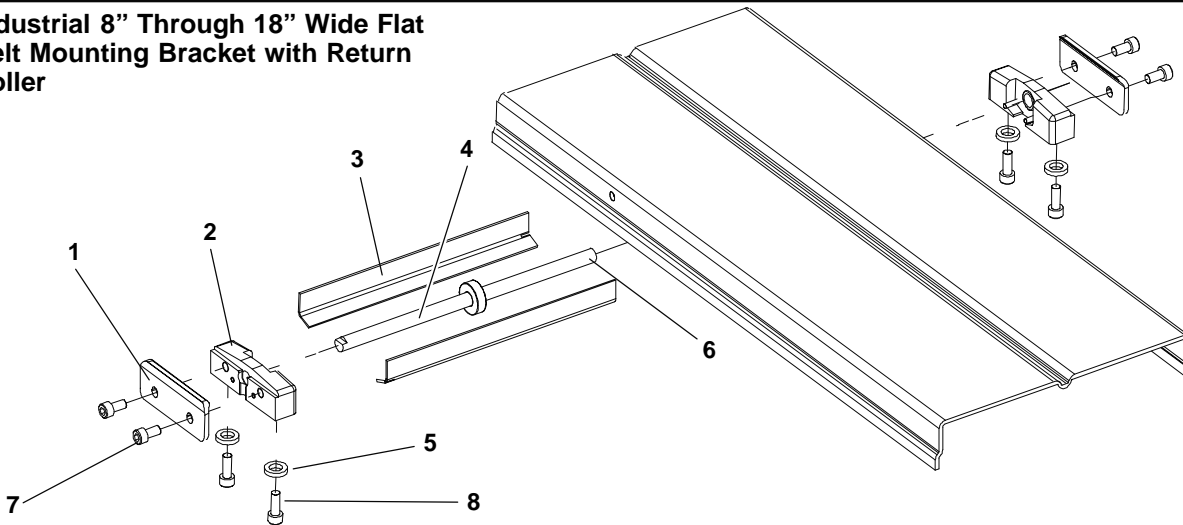
Industrial 2" Through 6" Wide Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492564M	Clamp Plate
2	493026M	Mounting Block
3	605279P	Washer
4	802-123	Bearing

5	913-103	Dowel Pin
6	920612M	Socket Head Cap Screw (Metric) M6 – 1.0 x 12mm
7	920616M	Socket Head Cap Screw (Metric) M5–.8 x 16mm

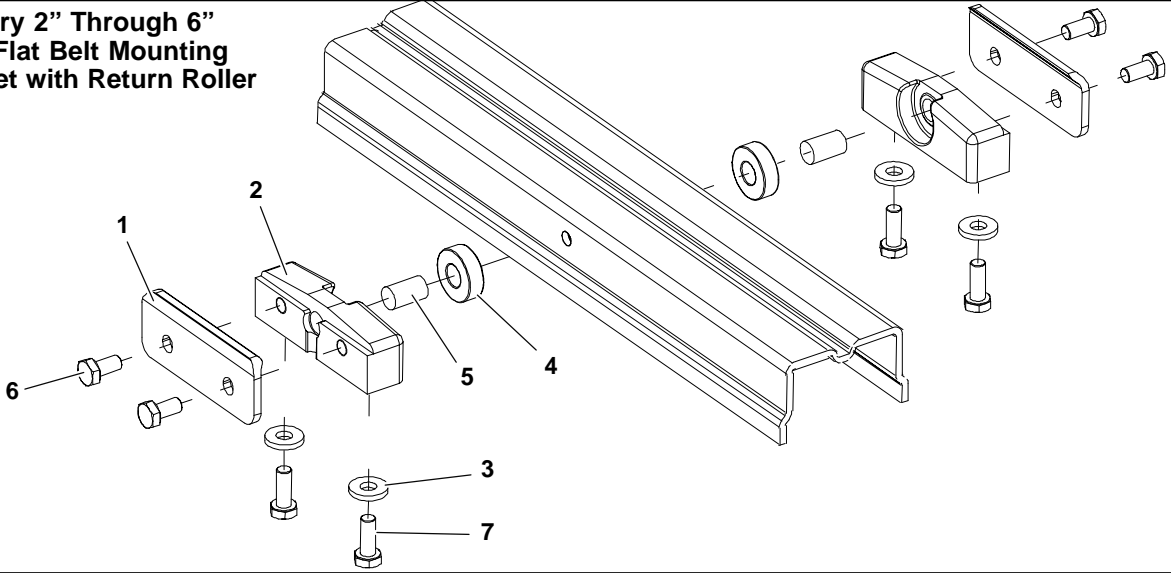
Industrial 8" Through 18" Wide Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492564M	Clamp Plate
2	492571M	Mounting Block
3	493108SSP	Bottom Roller Guard 8" (203mm)
	493110SSP	Bottom Roller Guard 10" (254mm)
	493112SSP	Bottom Roller Guard 12" (305mm)
	493118SSP	Bottom Roller Guard 18" (457mm)

4	493308SS	Shaft Assembly Belt Support 8" (203mm)
	493310SS	Shaft Assembly Belt Support 10" (254mm)
	493312SS	Shaft Assembly Belt Support 12" (305mm)
	493318SS	Shaft Assembly Belt Support 18" (457mm)
5	605279P	Hard Washer
6	807-1019	Groove Pin
7	920612M	Socket Head Cap Screw (Metric) M6-1.0 x 12mm
8	920616M	Socket Head Cap Screw (Metric) M6-1.0 x 16mm

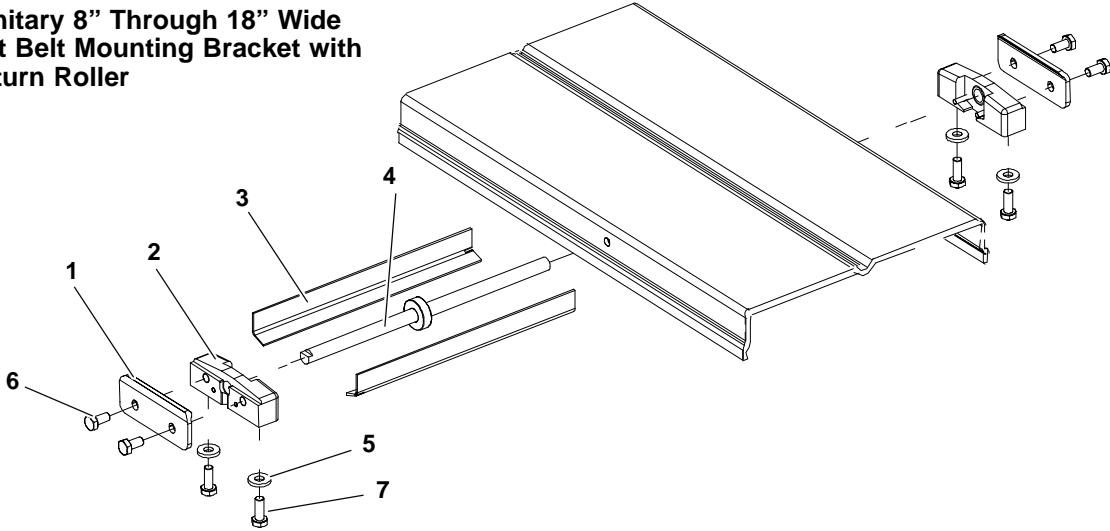
Sanitary 2" Through 6" Wide Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492564SS	Clamp Plate
2	493026MSS	Mounting Block
3	911-201	Washer
4	802-123	Bearing

5	913-103	Dowel Pin
6	960612MSS	Hex Head Screw (Metric) M6 - 1.0 x 12mm
7	960616MSS	Hex Head Screw (Metric) M6-1.0 x 16mm

Sanitary 8" Through 18" Wide Flat Belt Mounting Bracket with Return Roller

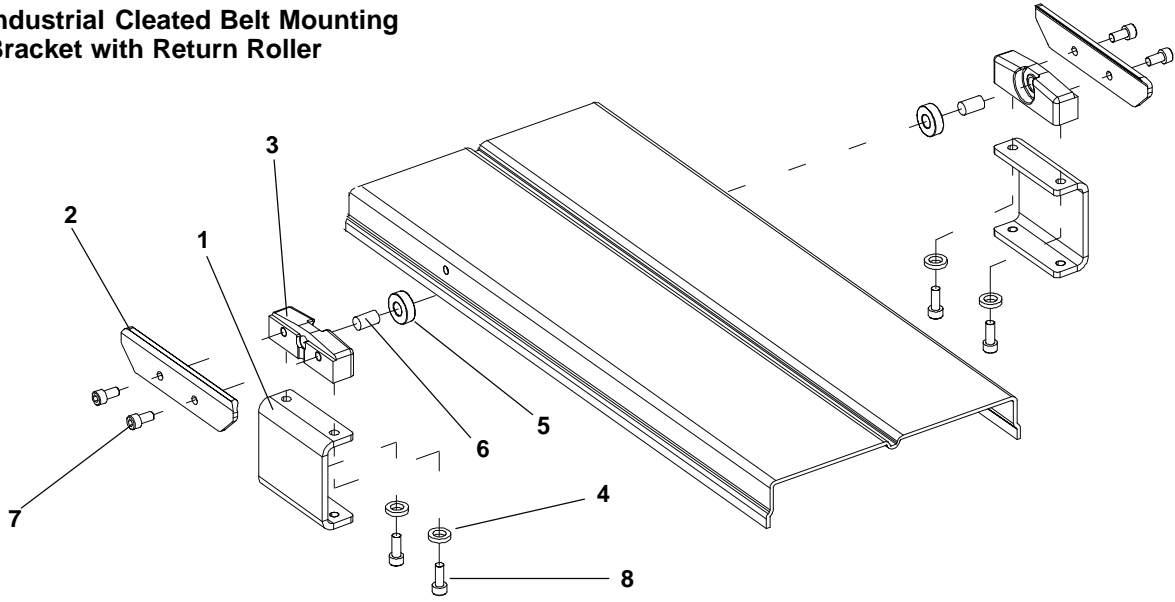


Item	Part Number	Description
1	492564SS	Clamp Plate
2	492571MSS	Mounting Block
3	493108SS	Bottom Roller Guard 8" (203mm)
	493110SS	Bottom Roller Guard 10" (254mm)
	493112SS	Bottom Roller Guard 12" (305mm)
	493118SS	Bottom Roller Guard 18" (457mm)

4	493308SS	Shaft Assembly Belt Support 8" (203mm)
	493310SS	Shaft Assembly Belt Support 10" (254mm)
	493312SS	Shaft Assembly Belt Support 12" (305mm)
	493318SS	Shaft Assembly Belt Support 18" (457mm)
5	911-201	Hard Washer
6	960612MSS	Hex Head Screw (Metric) M6-1.0 x 12mm
7	960616MSS	Hex Head Screw (Metric) M6-1.0 x 16mm

Service Parts

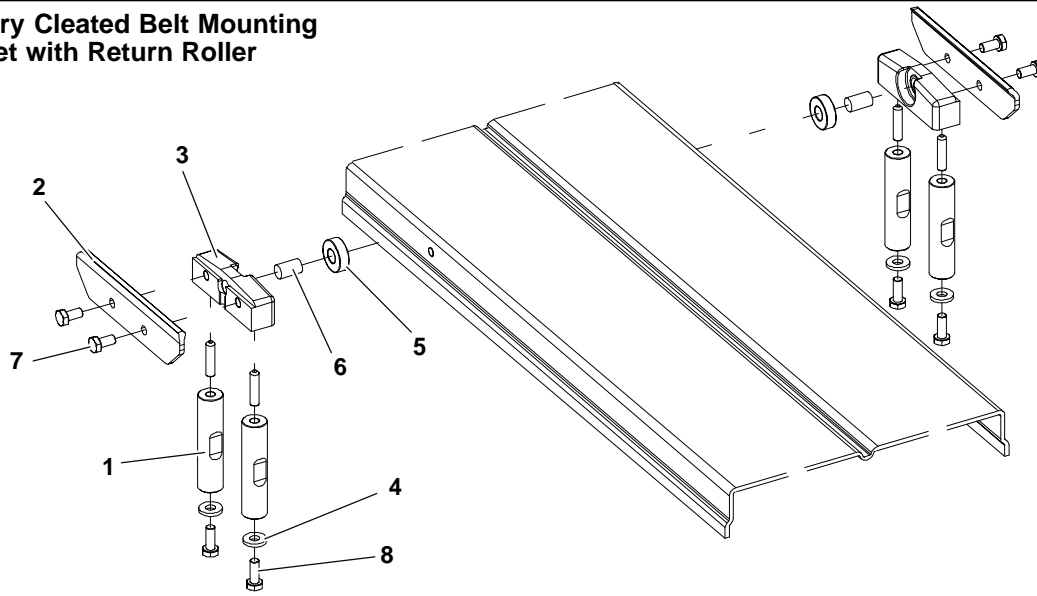
Industrial Cleated Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492565M	Bracket Riser Cleated Stand
2	492566M	Clamp Plate
3	493026M	Mounting Block
4	605279P	Washer

5	802-123	Bearing
6	913-103	Dowel Pin
7	920612M	Socket Head Cap Screw (Metric) M6-1.0 x 12mm
8	920616M	Socket Head Cap Screw (Metric) M6-1.0 x 16mm

Sanitary Cleated Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492563MSS	Standoff Post
2	492566SS	Clamp Plate
3	493026MSS	Mounting Block
4	911-201	Washer
5	802-123	Bearing

6	913-103	Dowel Pin
7	960612MSS	Hex Head Screw (Metric) M6-1.0 x 12mm
8	970625MSS	Socket Head Set Screw (Metric) M6-1.0 x 25mm

Return Policy

No returns will be accepted without prior written factory authorization. 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. 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 to reference.

There will be a 15% restocking charge on all new items returned for credit where Dorner was not at fault. These will not be accepted after 60 days from original invoice date. The restocking charge covers inspection, cleaning, disassembly, and reissuing 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. Feel free to contact Dorner for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dorner products.

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

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

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