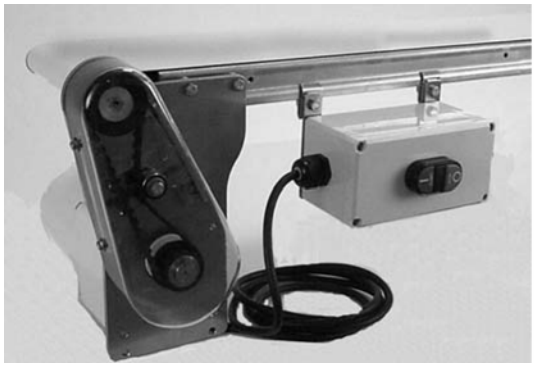
7200/7300 Series Bottom Mount Drive Package for Standard Load Parallel Shaft Sanitary Gearmotors

Installation, Maintenance & Parts Manual



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851-573 Rev. D

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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 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.

Dorner 7200 and 7300 Series conveyors are covered by patent number 5174435, 6109427 and corresponding patents and patent applications in other countries.

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

⚠ WARNING

The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.

⚠ DANGER

Climbing, sitting, walking or riding on conveyor will cause severe injury.

KEEP OFF CONVEYORS.

⚠ DANGER

DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

⚠ DANGER

Hazardous voltage will cause severe injury or death.

LOCKOUT POWER BEFORE WIRING.

⚠ WARNING

Gearmotors may be HOT.

DO NOT TOUCH Gearmotors.

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

⚠ WARNING

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.

Product Description

Refer to Figure 1 for typical components (7300 Series with heavy duty sprocket kit shown).

A	Conveyor
B	Mounting Bracket
C	Gearmotor
D	Timing Chain Tensioner
E	Cover
F	Timing Chain
G	Drive Sprocket
H	Driven Sprocket
I	Motor Control

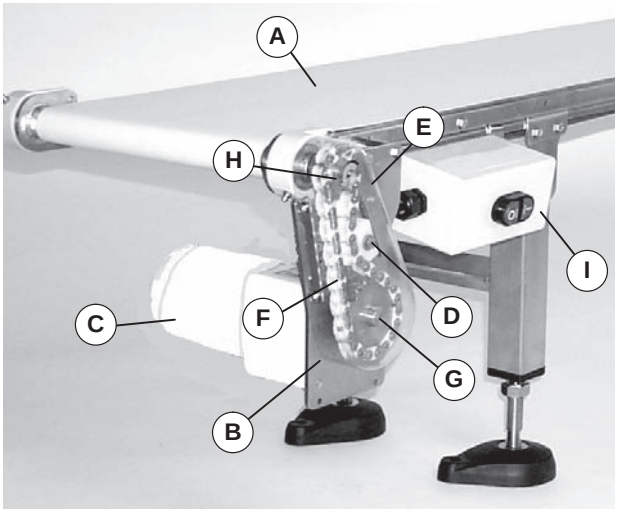
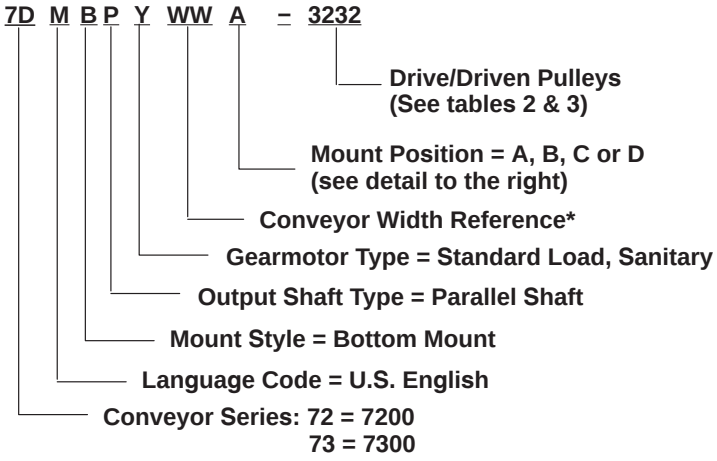


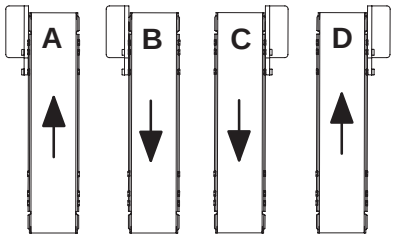
Figure 1

Specifications

Gearmotor Mounting Package Models:

Example:





* See “Ordering and Specifications” Catalog for details.

Table 1: Gearmotor Specifications

	Single-Phase	Three-Phase	VFD Variable Speed
Output Power	0.12 hp (0.09 kw)		
Input Voltage	115 Volts A.C.	230 Volts A.C.	230 Volts A.C.
Input Frequency	60 Hz	50/60 Hz	25 to 63 Hz
Full Load Amperes	1.5 Amperes	0.5 Amperes	
Gearmotor Ratios	9:1 and 30:1		
Protection Ratings	IP65 for Gearmotor, IP55 for Motor Starter		

Table 2: Standard Load Fixed Speed Parallel Shaft 60 Hz Gearmotors

Gearmotor				Conveyor Belt Speed		Belt Drive		Chain Drive	
Part Number	RPM	In-lb	N-m	ft/min	M/min	Drive Pulley	Driven Pulley	Drive Pulley	Driven Pulley
62M030PY4(vp)FN	50	77	8.7	12	3.7	22	32	–	–
62M030PY4(vp)FN	50	77	8.7	21	6.4	–	–	12	10
62M030PY4(vp)FN	50	77	8.7	26	7.9	32	22	–	–
62M030PY4(vp)FN	50	77	8.7	32	9.8	–	–	18	10
62M030PY4(vp)FN	50	77	8.7	38	11.6	48	22	–	–
62M009PY4(vp)FN	167	26	2.8	58	17.7	32	32	–	–
62M009PY4(vp)FN	167	26	2.8	70	21.3	–	–	12	10
62M009PY4(vp)FN	167	26	2.8	94	28.7	–	–	16	10
62M009PY4(vp)FN	167	26	2.8	100	30.5	48	28	–	–
62M009PY4(vp)FN	167	26	2.8	117	35.7	–	–	20	10
62M009PY4(vp)FN	167	26	2.8	148	45.1	48	19	–	–

(vp) = voltage and phase

23 = 230 V, Three-phase

11 = 115 V, Single-phase

Table 3: Standard Load Variable Speed Parallel Shaft VFD Gearmotors

Gearmotor				Conveyor Belt Speed		Timing Belt		Timing Chain	
Part Number	RPM	In-lb	N-m	ft/min	M/min	Drive Pulley	Driven Pulley	Drive Pulley	Driven Pulley
62M030PY423EN	50	109	12.3	2.0 – 12	0.6 – 3.7	22	32	–	–
62M030PY423EN	50	109	12.3	4.3 – 26	1.3 – 7.9	32	22	–	–
62M030PY423EN	50	109	12.3	3.5 – 21	1.1 – 6.4	–	–	12	10
62M030PY423EN	50	109	12.3	5.3 – 32	1.6 – 9.8	–	–	18	–
62M030PY423EN	50	109	12.3	6.3 – 38	1.9 – 11.6	48	22	–	10
62M009PY423EN	167	37	4.2	9.7 – 58	2.9 – 17.7	32	32	–	–
62M009PY423EN	167	37	4.2	11.7 – 70	3.6 – 21.3	–	–	12	–
62M009PY423EN	167	37	4.2	13.3 – 80	4.1 – 24.4	44	32	–	10
62M009PY423EN	167	37	4.2	15.7 – 94	4.8 – 28.7	–	–	16	10
62M009PY423EN	167	37	4.2	16.7 – 100	5.1 – 30.5	48	28	–	–
62M009PY423EN	167	37	4.2	19.5 – 117	5.9 – 35.7	–	–	20	10
62M009PY423EN	167	37	4.2	24.7 – 148	7.5 – 45.1	48	19	–	–

* At 60 Hz

NOTE

For belt speed other than those listed, contact factory for details.

Installation

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Required Tools

- Wrenches (for hexagon head fasteners)
  7 mm, 10 mm
- Hex key wrenches (for set screws)
  2.5 mm, 3 mm
- Straight edge
- Torque wrench

Drive Package Mounting

- A– Mounting a timing belt drive package.
- B – Mounting a timing chain drive package.

A – Mounting a Timing Belt Drive Package

1. Typical components (Figure 2)

NOTE

Figure 2 shows a 7200 Series mounting package with a timing belt and three-phase Motor Starter. Single-phase Motor Starter or VFD Controller similar. 7300 Series mounting package similar.

J	Mounting Plate/Gearmotor Assembly
K	Drive Pulley
L	Driven Pulley
M	Key (from conveyor assembly)
N	M6 x 30 mm, Hexagon Head Screws (2 x) (7200) M6 x 65 mm, Hexagon Head Screws (2 x) (7300)
O	Timing Belt
P	Cover
Q	Accessory Mounting Clips (2x)
R	M6 x 20 mm, Hexagon Head Screws (2x)
S	Typical Motor Starter

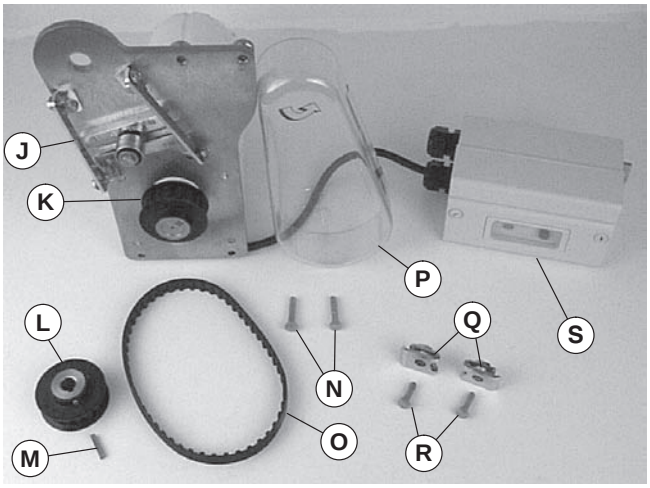
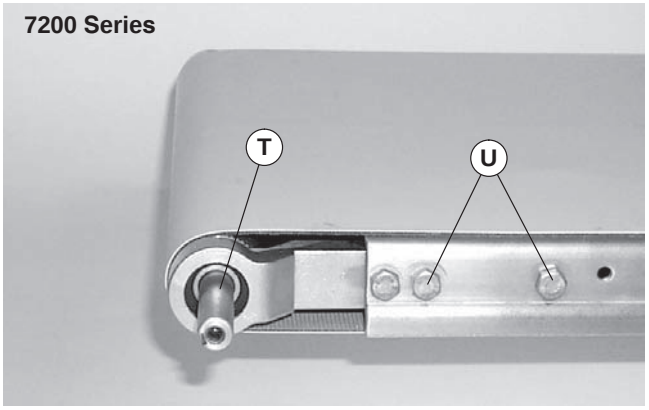


Figure 2

2. Locate conveyor input shaft (Figure 3, item T) and remove two (2) screws (U).



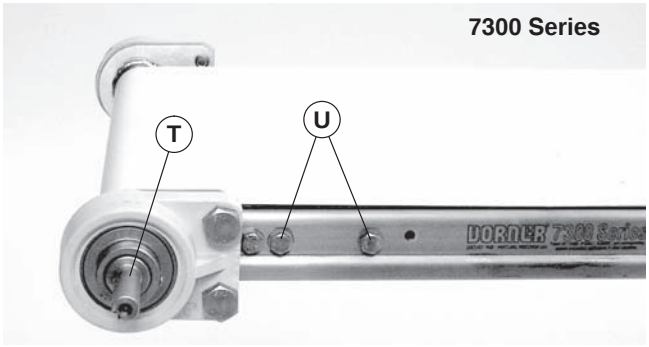


Figure 3

NOTE

For a 7300 Series mounting package, install two 1.758" (44.7mm) long spacers (Figure 4, item V) (shipped loose) between mounting plate/gearmotor assembly (J) and conveyor. On a 7200 Series (shown), the two 0.438" (11.1mm) long spacers (V) are attached to the mounting plate/gearmotor assembly.

3. Attach mounting plate/gearmotor assembly (J) with screws (N). Tighten to 92 in-lb (10.4 Nm).

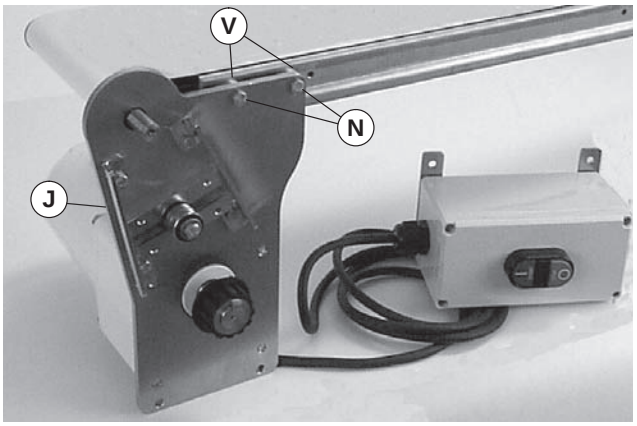


Figure 4

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

NOTE

Figure 6 and Figure 7 show timing belt installation on a 7200 Series conveyor. Installation on a 7300 Series conveyor is similar.

4. Depending on conveyor belt travel (direction 1 or 2), locate timing belt tensioner (Figure 5, item W) as shown. Do not tighten tensioner screw.

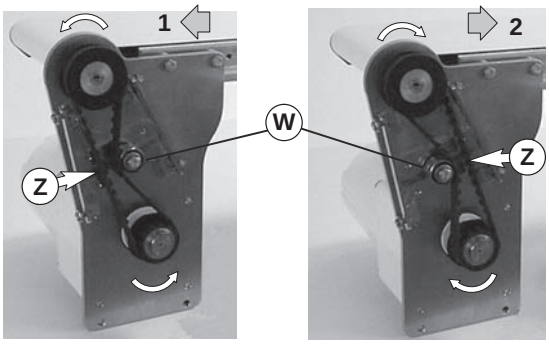


Figure 5

5. Install key (Figure 6, item M) on conveyor input shaft (T).

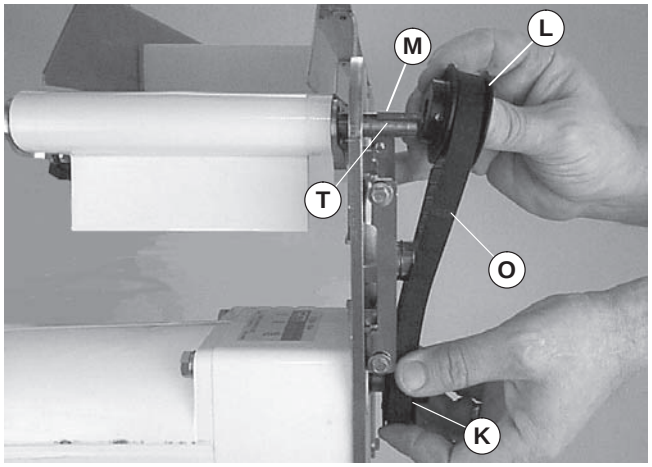


Figure 6

6. Wrap timing belt (O) around driven pulley (L) and drive pulley (K). Install driven pulley (L) onto conveyor input shaft (T) and key (M).
7. Using a straight edge (Figure 7, item Y), align driven pulley (L) with drive pulley (K). Tighten driven pulley set screws (X).

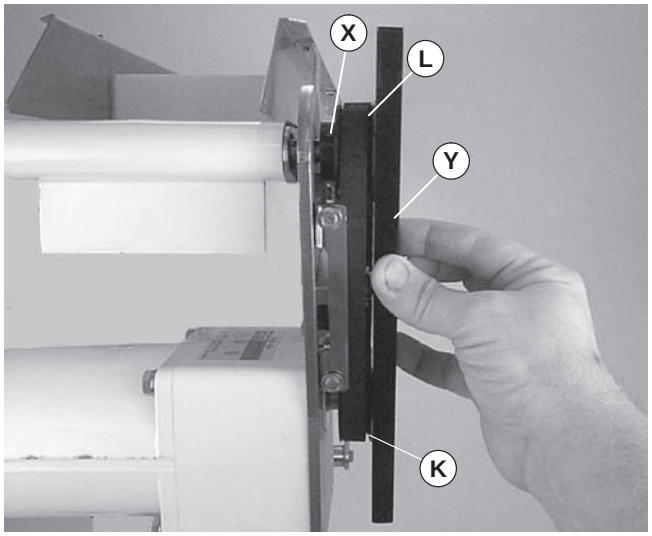


Figure 7

8. Tension timing belt to obtain 0.125¨ (3 mm) deflection for 1.0 lb (456 grams) of force at timing belt mid-point (Figure 5, item Z). Tighten tensioner screw to 92 in-lb (10.4 Nm).

NOTE

Do not over-tighten screws (Figure 8, item AA).

9. Install cover (Figure 8, item P) and tighten four screws (AA) to 35 in-lb (4 Nm).

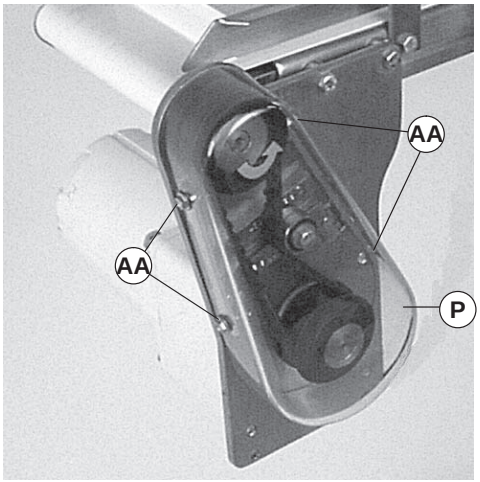


Figure 8

B – Mounting a Timing Chain Drive Package

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Illustration References	
J	Mounting Plate/Gearmotor Assembly
M	Key (from conveyor assembly)
N	M6 x 30 mm, Hexagon Head Screws (2 x) (7200) M6 x 65 mm, Hexagon Head Screws (2 x) (7300)
P	Cover
Q	Accessory Mounting Clips (2x)
R	M6 x 20 mm, Hexagon Head Screws (2x)
S	Typical Motor Starter
V	Spacer (2x) (7300)
AB	Drive Sprocket
AC	Driven Sprocket
AD	Timing Chain

1. Typical components (Figure 9)

NOTE

Figure 9 shows a 7300 Series drive mounting package with a timing chain and single-phase motor starter. Three-phase motor starter or VFD controller is similar. 7200 Series drive mounting package is similar.

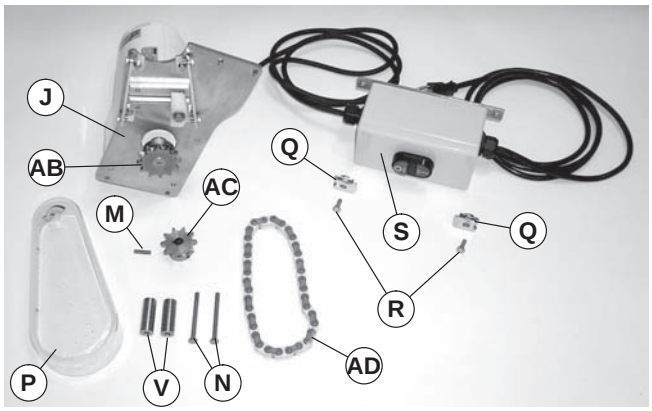


Figure 9

2. Locate conveyor input shaft (Figure 3, item T) and remove two screws (U).

NOTE

For a 7300 Series mounting package, install two 1.758" (44.7mm) long spacers (Figure 9, item V) and (Figure 10, item V) (shipped loose) between mounting plate/gearmotor assembly (J) and conveyor. On a 7200 Series (shown), two 0.438" (11.1mm) long spacers (V) are attached to the mounting plate/ gearmotor assembly.

3. Install mounting plate/gearmotor assembly (J) and spacers (see Note) with two screws (N). Tighten screws to 92 in-lb (10.4 Nm).

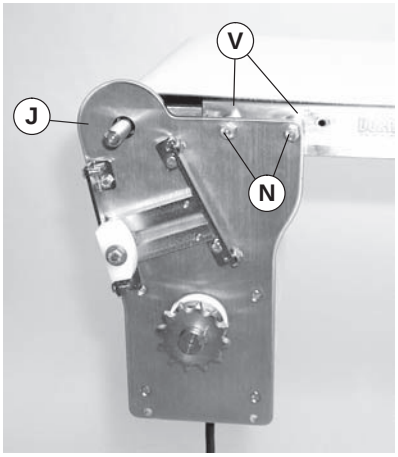


Figure 10

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

NOTE

Figure 11 through Figure 15 show timing chain installation on a 7200 Series conveyor. Installation on a 7300 Series conveyor is similar.

4. Install key (Figure 11, item M) on drive spindle (AE).

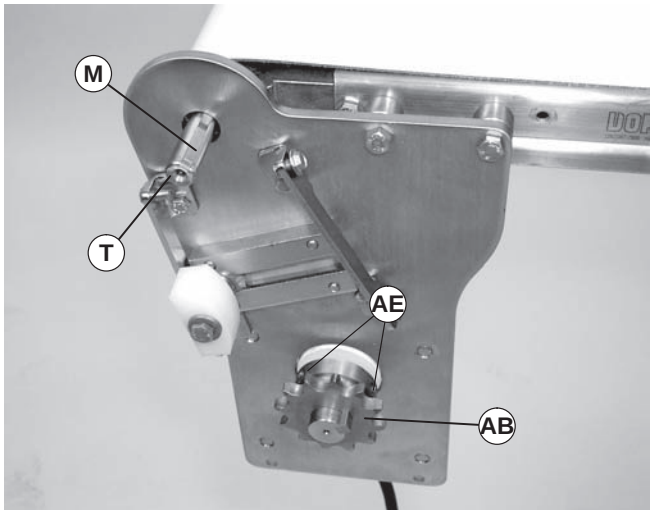


Figure 11

NOTE

Depending on sprocket sizes, it may be necessary to remove drive sprocket (Figure 11, item AB) by loosen two set screws (AE) to install chain and sprockets.

5. Depending on conveyor belt travel (direction 1 or 2 of Figure 12), locate timing chain tensioner (AF) as shown. Do not tighten tensioner screw.

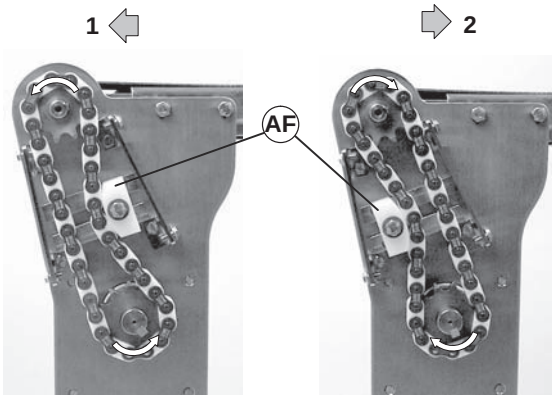


Figure 12

6. Install timing chain (Figure 13, item AD) over sprockets (AB and AC). Install timing chain and sprockets on conveyor input shaft (T) and gearmotor output shaft (AG). Do not tighten sprocket set screws.

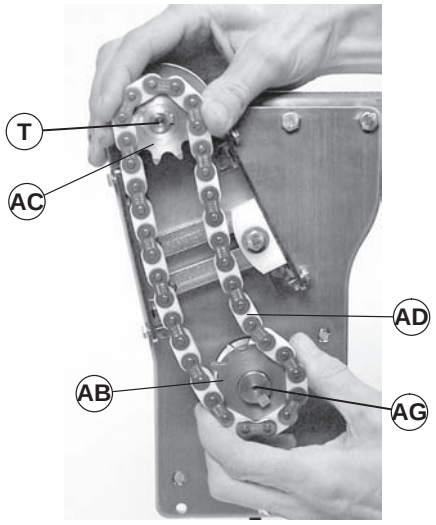


Figure 13

IMPORTANT

Make sure center of timing chain (Figure 14, item AD) aligns with center of chain tensioner (AF). If necessary, loosen two set screws (AE) to move drive sprocket (AB) in or out. Tighten set screws. Also, if necessary, loosen two set screws (AH) to move driven sprocket (AC) in or out. Tighten set screws.

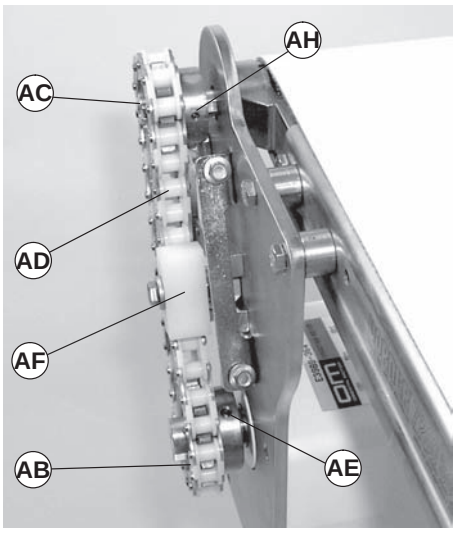


Figure 14

NOTE

Do not over–tension chain (AD). Only tension chain until slack is removed.

7. Slide chain tensioner (AF) to take up chain slack. Tighten chain tensioner screw to 92 in-lb (10.4 Nm).

NOTE

Do not over-tighten screws (Figure 15, item AA).

8. Install cover (Figure 15, item P) and tighten four screws (AA) to 35 in-lb (4 Nm).

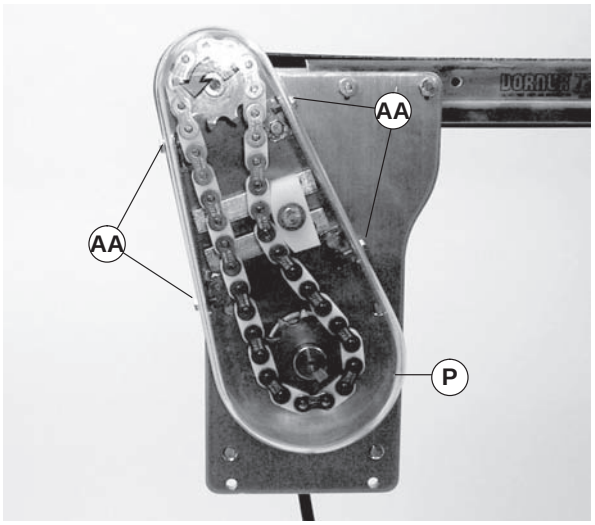


Figure 15

Motor Starter Mounting

NOTE

Single-phase Motor Starter shown, Three-phase Starter similar. For VFD controller mounting, see accessory instructions.

1. Attach two accessory mounting clips (Figure 16, item Q) to motor starter (S) with two M6 x 20mm hex head cap screws (R). Do not tighten screws.

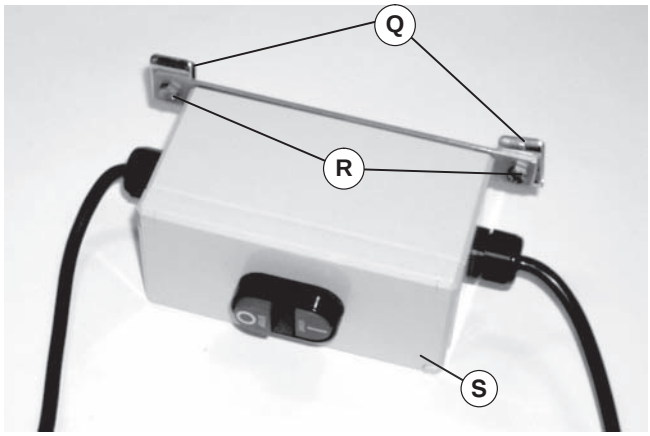


Figure 16

2. Attach motor starter (Figure 17, item S) with clips to conveyor. Tighten screws (R) to 92 in-lb (10.4 Nm).

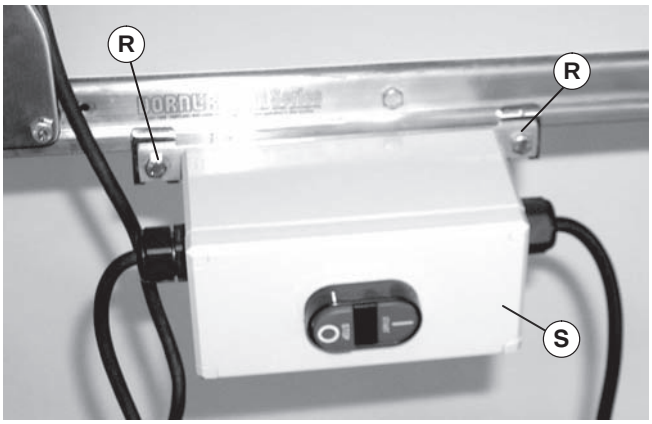


Figure 17

Wiring

Single-phase Motor Starter

NOTE

Power cord must be plugged into a GFI outlet. No additional wiring is required.

Three-phase Motor Starter

⚠ DANGER

Hazardous voltage will cause severe injury or death.

LOCKOUT POWER BEFORE WIRING.

NOTE

230 volt three-phase manual motor starters must be wired in accordance with applicable electrical codes.

1. Loosen cover screws (Figure 18, item AI). Remove cover.

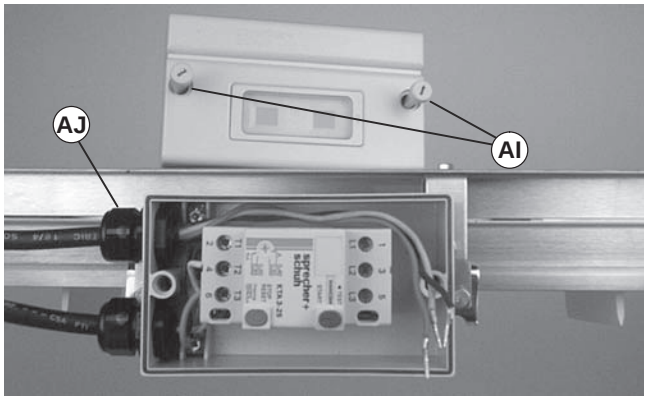


Figure 18

NOTE

Line cord must be 0.28¨ (7 mm) minimum to 0.47¨ (12 mm) maximum in diameter.

2. Insert line cord through grip (AJ) and tighten nut.

3. For correct three-phase motor shaft rotation, connect line phase sequence L1, L2 & L3 to terminals as shown (Figure 19).

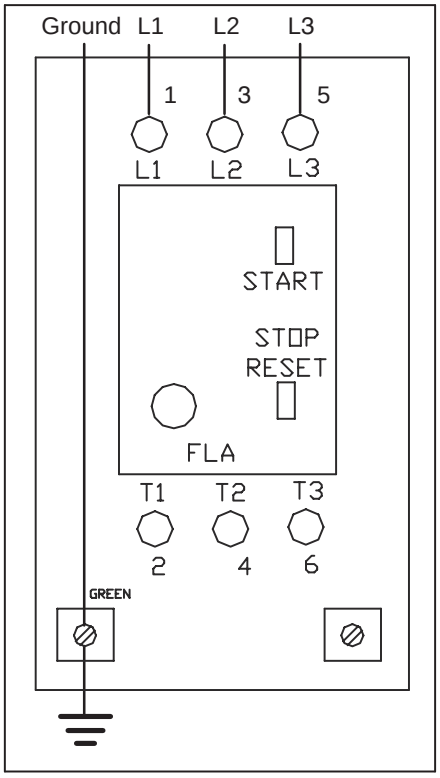


Figure 19

⚠ WARNING

Controller must be properly grounded. Failure to properly ground control box may cause injury to personnel.

NOTE

The motor ground wire is also attached to left terminal marked ⏚ (Figure 19).

4. Attach ground wire to lower left terminal marked ⏚ (Figure 19).
5. Install cover and tighten screws (Figure 18, item AI).

VFD Controllers

NOTE

Refer to VFD Controller Set-up, Operation & Maintenance Manual.

⚠ WARNING

Controller must be properly grounded. Failure to properly ground control box may cause injury to personnel.

NOTE

The motor ground wire is also attached to left terminal marked ⏚ (Figure 19).

1. Attach ground wire to lower left terminal marked ⏚ (see Figure 19).
2. Replace starter cover and tighten screws (Figure 18, item AI).

VFD Controllers

NOTE

Refer to VFD Controller Set-up, Operation & Maintenance Manual.

Required Tools

- Wrenches (for hexagon head fasteners) 7 mm and 10 mm
- Hex key wrenches (for set screws) 2.5 mm and 3 mm
- Straight edge
- Torque wrench

Timing Belt or Chain Replacement

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Replace timing belt or chain following instructions:

- A – Timing Belt Replacement
- B – Timing Chain Replacement

A – Timing Belt Replacement

1. Loosen four screws (Figure 20, item AA) and remove cover (P).

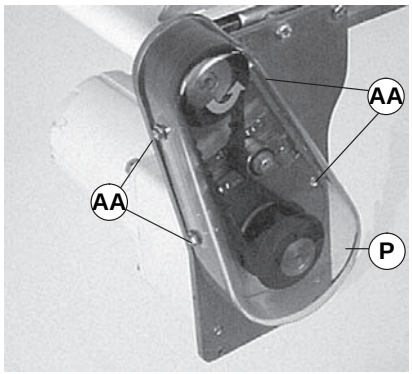


Figure 20

2. Loosen tensioner (Figure 21, item W).

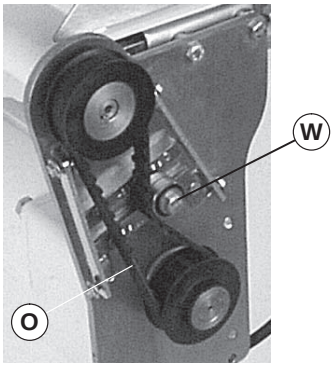


Figure 21

3. Remove timing belt (O).

NOTE

If timing belt does not slide over pulley flange, loosen two driven pulley set screws (Figure 7, item X) and remove driven pulley with belt. For installation, see steps 6 and 7 on page 7.

4. Install new timing belt.
5. Depending on conveyor belt travel (direction 1 or 2 of Figure 22), locate timing belt tensioner (W) as shown. Tension timing belt to obtain 0.125¨ (3 mm) deflection for 1.0 lb (456 grams) of force at timing belt mid-point (Z). Tighten tensioner screw to 92 in-lb (10.4 Nm).

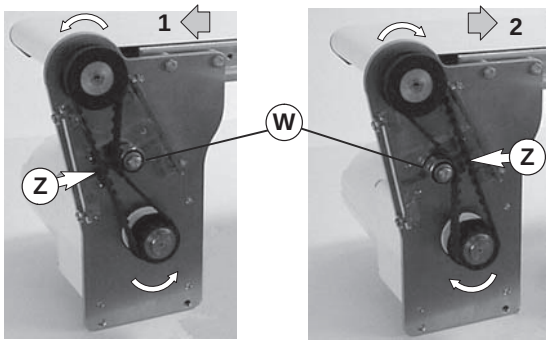


Figure 22

NOTE

Do not over-tighten screws (Figure 20, item AA).

6. Install cover (Figure 20, item P) and tighten four screws (AA) to 35 in-lb (4 Nm).

B – Timing Chain Replacement

1. Loosen four screws (Figure 23, item AA) and remove cover (P).

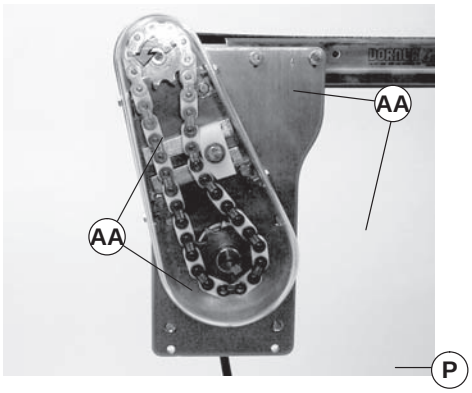


Figure 23

2. Loosen timing chain tensioner screw (Figure 24, item AK).

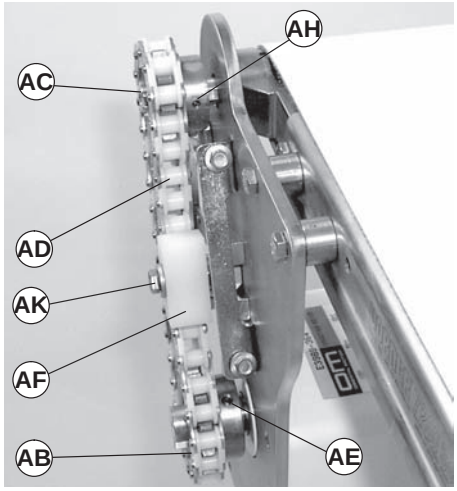


Figure 24

3. Loosen four set screws (AE) and (AH).
4. Remove timing chain (AD) and sprockets (AB and AC) from conveyor input shaft and gearmotor output shaft. Make sure to retain sprocket keys.
5. Depending on conveyor belt travel (direction 1 or 2 of Figure 25), locate timing chain tensioner (AF) as shown. Do not tighten tensioner screw.

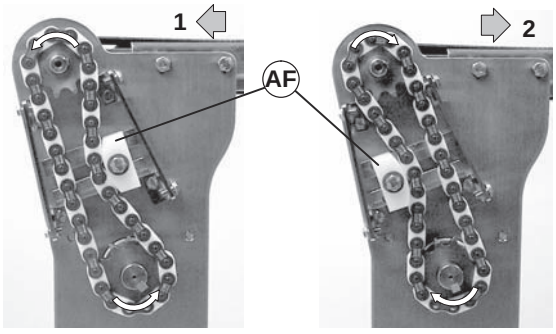


Figure 25

NOTE

Make sure sprocket keys are installed on conveyor input shaft (Figure 26, item T) and gearmotor output shaft (AG).

6. Install new timing chain (AD) over sprockets (AB and AC). Install timing chain and sprockets on conveyor input shaft (T) and gearmotor output shaft (AG). Do not tighten sprocket set screws.

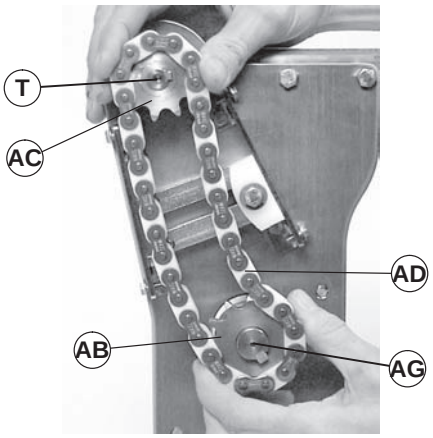


Figure 26

IMPORTANT

Make sure center of timing chain (Figure 24, item AD) aligns with center of chain tensioner (AF). If necessary, loosen two set screws (AE) to move drive sprocket (AB) in or out. Tighten set screws. Also, if necessary, loosen two set screws (AH) to move driven sprocket (AC) in or out. Tighten set screws.

NOTE

Do not overtension chain (AD). Only tension chain until slack is removed.

7. Slide chain tensioner (AF) to take up chain slack. Tighten chain tensioner screw (Figure 24, item AK) to 92 in-lb (10.4 Nm).

NOTE

Do not over-tighten screws (Figure 23, item AA).

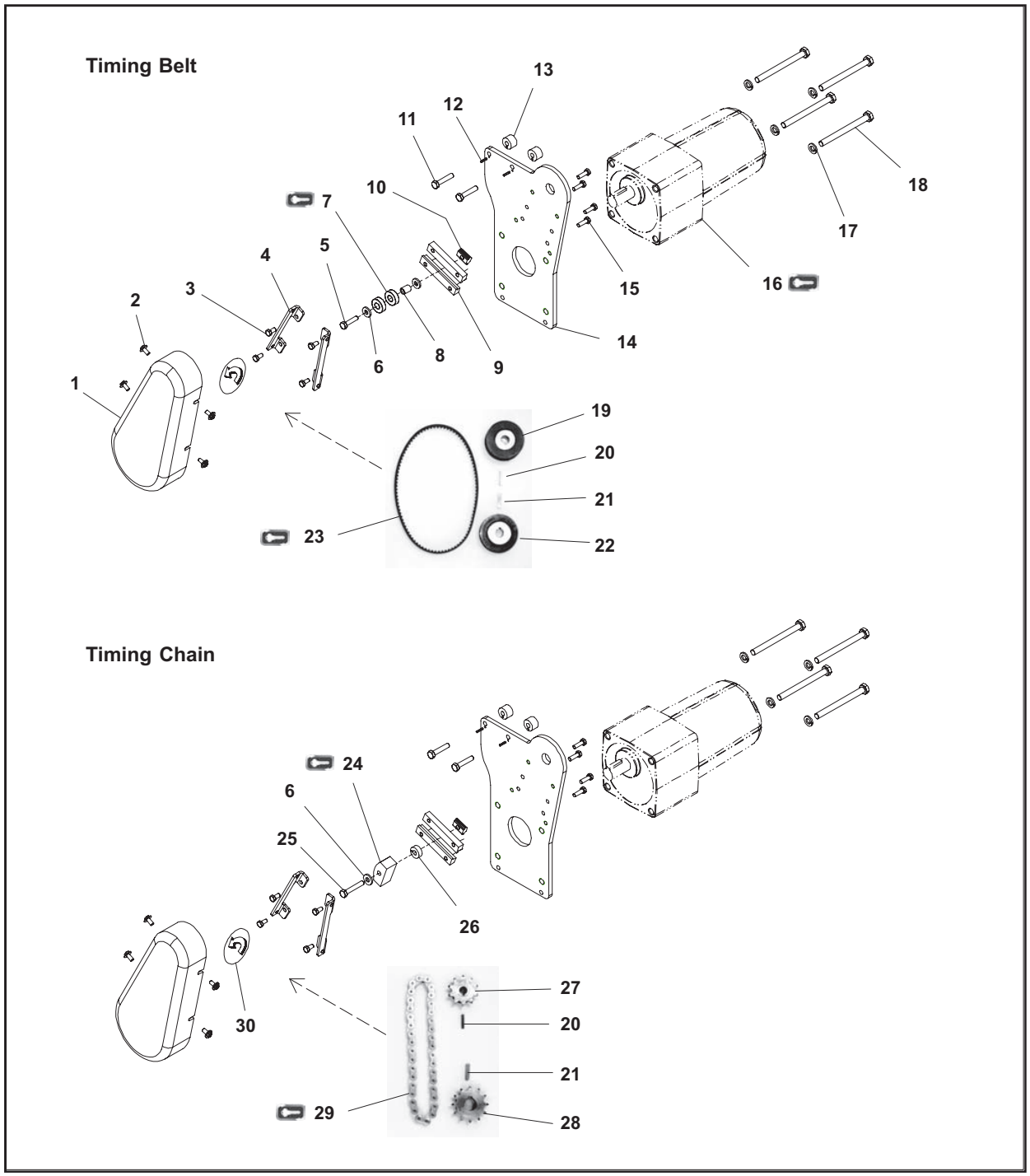
8. Install cover (Figure 23, item P) and tighten four screws (AA) to 35 in-lb (4 Nm).

NOTES

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.

7200 Series Drive Mounting Components



Item	Part Number	Description
1	450028P	Cover, Clear
2	807–968	Hex Flange Head Screw M5–.8x10mm
3	960510MSS	Hex Head Cap Screw M5–.8x10mm
4	450181MSS	Cover Mounting Bracket SS
5	960625MSS	Hex Head Cap Screw M6–1.0x25mm
6	911–201	Flat Washer 1/4" SS
7	802–123	Bearing
8	801–116	Nylon Bearing
9	450178MSS	Slide Bar, Tensioner
10	639971MSS	Drop–In T–Bar
11	960630MSS	Hex Head Cap Screw M6–1.0x30mm
12	807–998	Grooved Pin SS
13	456029	Drive Mounting Plate Spacer SS
14	450179MSS	Drive Mounting Plate
15	960516MSS	Hex Head Cap Screw M5–.8x16mm
16	62M009PY411	Gearmotor, 115V Single Phase, 167 RPM
	62M030PY411	Gearmotor, 115V Single Phase, 50 RPM
	62M009PY423	Gearmotor, 230V Three Phase, 167 RPM
	62M030PY423	Gearmotor, 230V Three Phase, 50 RPM
17	911–120	Lock Washer, 5/16"
18	960890MSS	Hex Head Cap Screw M8–1.25x90mm
19	450101	Driven Pulley, 19 Tooth, 12mm Bore
	450102	Driven Pulley, 22 Tooth, 12mm Bore
	450103	Driven Pulley, 28 Tooth, 12mm Bore
	450104	Drive Pulley, 32 Tooth, 12mm Bore
20	980422MSS	Square Key, 4x22mm
21	826–318	Square Key, 6x25mm
22	450391M	Drive Pulley, 22 Tooth, 18mm Bore
	450393M	Drive Pulley, 32 Tooth, 18mm Bore
	450394M	Driven Pulley, 44 Tooth, 18mm Bore
	450395M	Drive Pulley, 48 Tooth, 18mm Bore
23	See Timing Belt Table	Timing Belt, 15mm
24	456048	Chain Tensioner
25	960635MSS	Hex Head Cap Screw M6–1.0x35mm
26	450182SS	Drive Spacer SS
27	811–296	Driven Sprocket, 10 Tooth, 12mm Bore
28	811–302	Drive Sprocket, 12 Tooth, 18mm Bore
	811–304	Drive Sprocket, 16 Tooth, 18mm Bore
	811–305	Drive Sprocket, 18 Tooth, 18mm Bore
	811–306	Drive Sprocket, 20 Tooth, 18mm Bore
29	See Timing Chain Table	Timing Chain, #40
30	450272P	Rotation Label CW
	450273P	Rotation Label CCW

Item 23: Standard Timing Belts

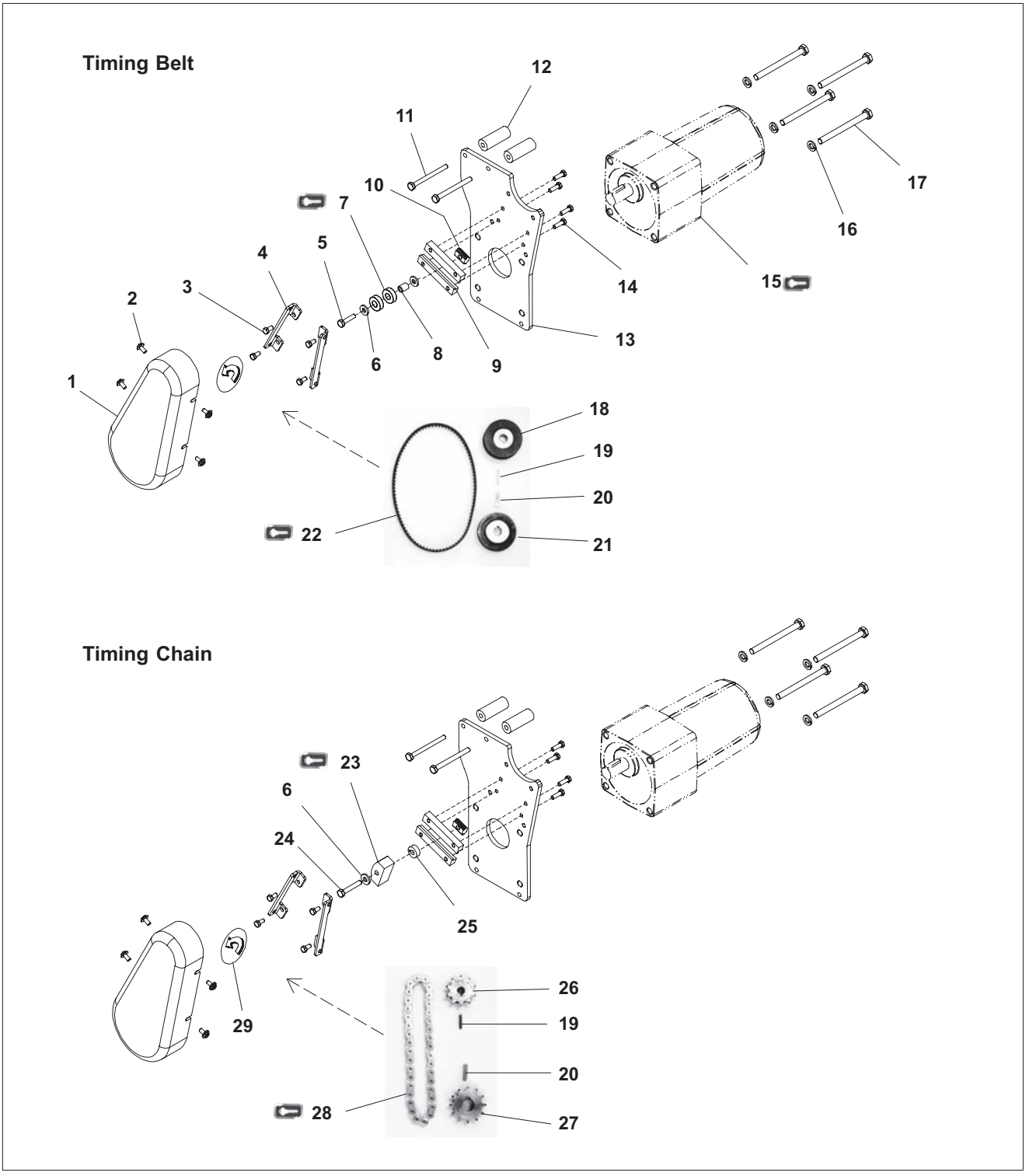
Pulley Teeth		Belt Length	Part Number
Drive Pulley	Driven Pulley		
22	32	460 mm	814–105
32	22	450 mm	814–104
32	32	475 mm	814–065
44	32	520 mm	814–108
48	19	500 mm	814–101
48	22	500 mm	814–101
48	28	535 mm	814–064

Item 29: Standard Timing Chains

Sprocket Teeth		Pitch Length	Part Number
Drive Sprocket	Driven Sprocket		
22	32	35	456050
32	22	37	456052
32	32	39	456053
44	32	39	456053

Service Parts

7300 Series Drive Mounting Components



Item	Part Number	Description
1	450028P	Cover, Clear
2	807–968	Hex Flange Head Screw M5–.8x10mm
3	960510MSS	Hex Head Cap Screw M5–.8x10mm
4	450181MSS	Cover Mounting Bracket SS
5	960625MSS	Hex Head Cap Screw M6–1.0x25mm
6	911–201	Flat Washer 1/4" SS
7	802–123	Bearing
8	801–116	Nylon Bearing
9	450178MSS	Slide Bar, Tensioner
10	639971MSS	Drop–In T–Bar
11	960665MSS	Hex Head Cap Screw M6–1.0x65mm
12	457850	Drive Mounting Plate Spacer SS
13	701472	Drive Mounting Plate
14	960516MSS	Hex Head Cap Screw M5–.8x16mm
15	62M009PY411	Gearmotor, 115V Single Phase, 167 RPM
	62M030PY411	Gearmotor, 115V Single Phase, 50 RPM
	62M009PY423	Gearmotor, 230V Three Phase, 167 RPM
	62M030PY423	Gearmotor, 230V Three Phase, 50 RPM
16	911–120	Lock Washer, 5/16"
17	960890MSS	Hex Head Cap Screw M8–1.25x90mm
18	450101	Driven Pulley, 19 Tooth, 12mm Bore
	450102	Driven Pulley, 22 Tooth, 12mm Bore
	450103	Driven Pulley, 28 Tooth, 12mm Bore
	450104	Driven Pulley, 32 Tooth, 12mm Bore
19	980422MSS	Square Key, 4x22mm
20	826–318	Square Key, 6x25mm
21	450391M	Drive Pulley, 22 Tooth, 18mm Bore
	450393M	Drive Pulley, 32 Tooth, 18mm Bore
	450394M	Drive Pulley, 44 Tooth, 18mm Bore
	450395M	Drive Pulley, 48 Tooth, 18mm Bore
22	See Timing Belt Table	Timing Belt, 15mm
23	456048	Chain Tensioner
24	960635MSS	Hex Head Cap Screw M6–1.0x35mm
25	450182SS	Drive Spacer SS
26	811–296	Driven Sprocket, 10 Tooth, 12mm Bore
27	811–302	Drive Sprocket, 12 Tooth, 18mm Bore
	811–304	Drive Sprocket, 16 Tooth, 18mm Bore
	811–305	Drive Sprocket, 18 Tooth, 18mm Bore
	811–306	Drive Sprocket, 20 Tooth, 18mm Bore
l28	See Timing Belt Table	Timing Chain, #40 x 35 Pitch Length
29	450272P	Rotation Label CW
	450273P	Rotation Label CCW

Item 22: Standard Timing Belts

Pulley Teeth		Belt Length	Part Number
Drive Pulley	Driven Pulley		
22	32	460 mm	814–105
32	22	450 mm	814–104
32	32	475 mm	814–065
44	32	520 mm	814–108
48	19	500 mm	814–101
48	22	500 mm	814–101
48	28	535 mm	814–064

Item 28: Standard Timing Chains

Sprocket Teeth		Pitch Length	Part Number
Drive Sprocket	Driven Sprocket		
22	32	35	456050
32	22	37	456052
32	32	39	456053
44	32	39	456053

Return Policy

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

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

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization (RMA) number for reference. RMA will automatically close 30 days after being issued. To get credit, items must be new and undamaged. There will be a return charge on all items returned for credit, where Dorner was not at fault. It is the customer's responsibility to prevent damage during return shipping. Damaged or modified items will not be accepted. The customer is responsible for return freight.

Conveyors and conveyor accessories	
Standard catalog conveyors	30%
MPB, 7200, 7300 Series, cleated and specialty belt	50%
AquaGard & AquaPruf Series conveyors	non-returnable items
Engineered to order products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

Parts	
Standard stock parts	30%
Plastic chain, cleated and specialty belts	non-returnable items

Returns will not be accepted after 60 days from original invoice date. The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components to inventory. If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Customer Service Team will gladly help with your questions on Dorner products.

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

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

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