



# 7200 Series Sanitary End Drive Conveyors

## Installation, Maintenance & Parts Manual



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## Introduction

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### 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 7200 Series conveyors are covered by Patent Nos. 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.

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

### 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.**

### WARNING



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

### WARNING



Gearmotors may be **HOT**.  
**DO NOT TOUCH** Gearmotors.

### 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.

### WARNING



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.**

# Product Description

Refer to Figure 1 for typical conveyor components.

A	Conveyor
B	Gearmotor
C	Belt (Flat Belt Shown)
D	Mounting Plates
E	Return Roller
F	Support Stands
G	Motor Controller
H	Drive End
I	Tensioning End

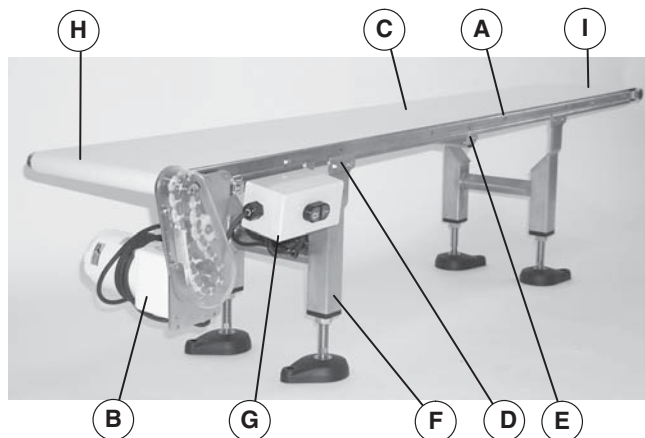


Figure 1

## Specifications

### Models

#### Flat Belt 7200 Series Sanitary Conveyor

##### Flat Belt 7200 Series Sanitary Conveyor

72 B M WW LLLL P GG BB

- 72 = Document Language, M = USA English
- B = Conveyor Width Reference
- M = Conveyor Length Reference
- WW = Output Shaft Position\*
- LLLL = Conveyor Profile\*
- P = Belt Type\*
- GG = 1 = No Wiper – with Mounting Brackets
- BB = 2 = No Wiper – without Mounting Brackets
- 3 = End Wiper – with Mounting Brackets
- 4 = End Wiper – without Mounting Brackets
- 5 = Dual Wiper – with Mounting Brackets
- 6 = Dual Wiper – without Mounting Brackets
- 2 = Flat Belt End Drive Conveyor

#### Cleated Belt 7200 Series Sanitary Conveyor

7 D B M WW LLLL P SSSS

- 7 = Document Language, M = USA English
- D = Cleat Type (A–J)\*
- B = Conveyor Width Reference
- M = Conveyor Length Reference
- WW = Output Shaft Position\*
- LLLL = Conveyor Profile\*
- P = Cleat Spacing\*
- SSSS = 4 = Cleated Belt with Mounting Brackets
- 5 = Cleated Belt without Mounting Brackets
- 8 = Low Friction Cleated Belt with Mounting Brackets
- 9 = Low Friction Cleated Belt without Mounting Brackets

\* See “Ordering and Specifications” Catalog for details.

### Conveyor Supports:

Maximum Distances:

J = 18" (457mm)\*\*

K = 6 ft (1829mm)\*\*\*

L = 18" (457mm)

\*\* For Heavy Load Bottom Mount Package, mount support under gearmotor.

\*\*\* For conveyors longer than 12 ft (3658mm), install support at frame joint.

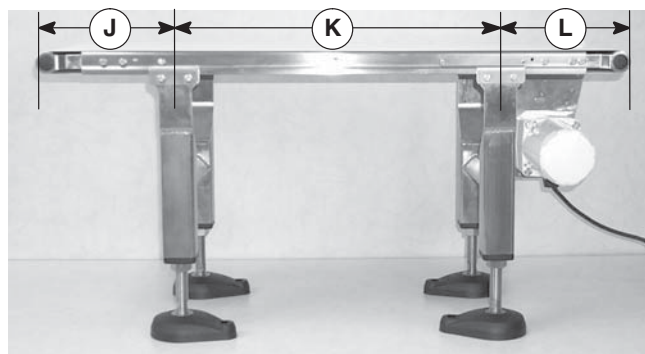


Figure 2

# Specifications

## Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18
Conveyor Belt Width	1.75" (44mm)	2.75" (70mm)	3.75" (95mm)	5" (127mm)	6" (152mm)	8" (203mm)	10" (254mm)	12" (305mm)	18" (457mm)
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)	70 lb (32 kg)	80 lb (36 kg)	80 lb (36 kg)	80 lb (36 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	4.3" (109 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 (610mm)	3-ft (914mm)	4-ft (1219mm)	5-ft (1524mm)	6-ft (1829mm)	7-ft (2134mm)	8-ft (2438mm)	9-ft (2743mm)	10-ft (3048mm)	11-ft (3353mm)	12-ft (3658mm)	13-ft (3962mm)**	14-ft (4267mm)**	15-ft (4572mm)**	16-ft (4877mm)**	17-ft (5182mm)**	18-ft (5486mm)**

\* See "Ordering and Specifications" Catalog for details.

### NOTE

*Maximum conveyor loads are based on:*

- *Non-accumulating product*
- *Product moving towards gearmotor*
- *Conveyor being mounted horizontal*
- *Conveyor being located in a dry environment*
- *Conveyor with standard belt only*

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

# Installation

## NOTE

7200 Series sanitary conveyors are shipped with a “belt travel direction” sticker (Figure 3, item M) installed. After drive is installed and tested, remove sticker.

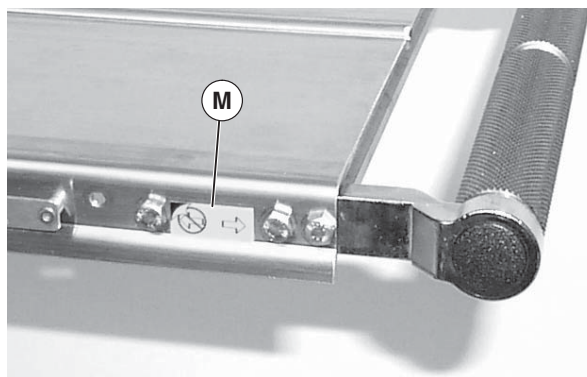


Figure 3

## NOTE

Dorner recommends cleaning all the “food zones” prior to placing conveyor into service. Insure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.

## NOTE

Conveyor **MUST** be mounted straight, flat, and level within confines of conveyor. Use a level (Figure 4, item N) during setup.

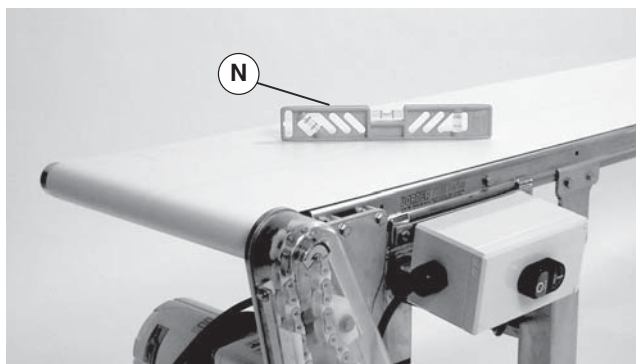


Figure 4

## Required Tools

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

## Recommended Installation Sequence

- Assemble conveyor (if required)
- Install stands (see accessory instructions)
- Attach stands/mounting brackets to conveyor (see page 7)
- Mount gearmotor mounting package (see accessory instructions)
- Attach return rollers (see page 8)
- Attach guides/accessories (see “Service Parts” section starting on page 18)

## Conveyors Up to 12 ft (3658mm)

No assembly is required. Install stands/mounting brackets and return rollers. Refer to “Attaching Conveyor to Stands or Mounting Brackets” on page 7 and “Return Rollers” on page 8.

## Conveyors Longer Than 12 ft (3658mm)

1. Typical components (Figure 5).

O	Conveyor frame extension
P	M6 x 10mm Hex Head Cap Screws (12x)
Q	Connector Strips (2x)
R	Conveyor frame

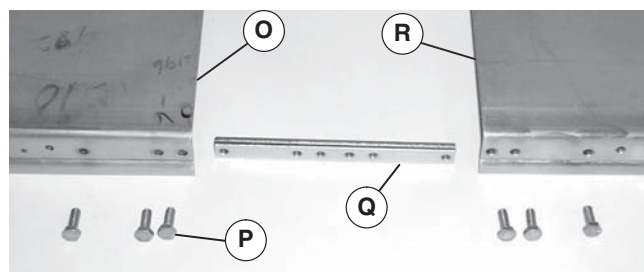
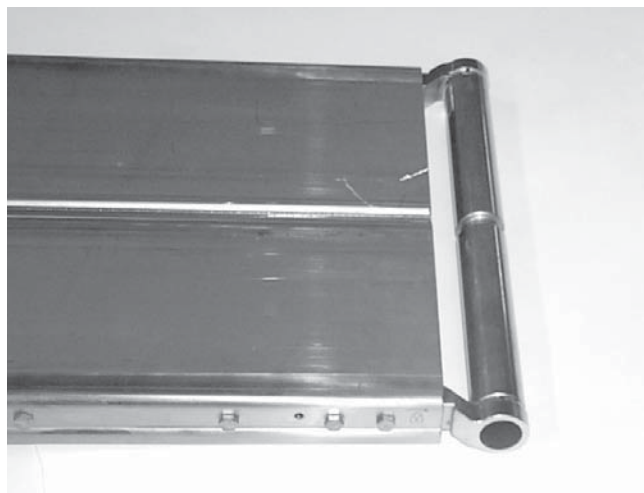


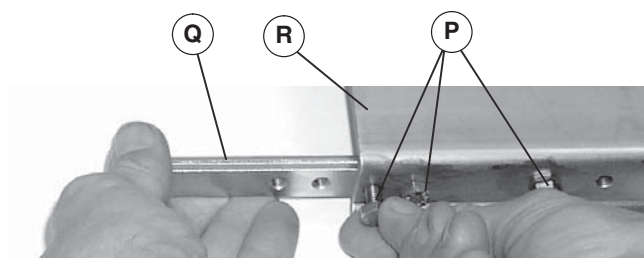
Figure 5

2. Compress tensioning end (Figure 6). Refer to steps 4 and 5 under the “Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands” on page 11.



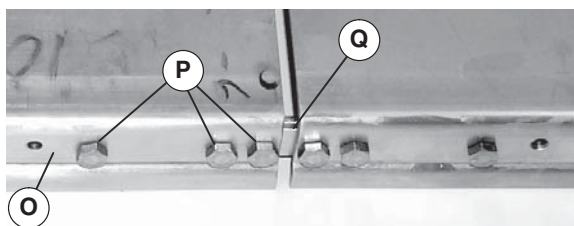
**Figure 6**

3. Install frame connecting bar (Figure 7, item Q) on conveyor frame (R) with three screws (P). Do not tighten screws.



**Figure 7**

4. Repeat step 3 for other side of conveyor frame.
5. Install conveyor frame extension (Figure 8, item O) on frame connecting bar (Q) with three screws (P). Install three screws (P) on opposite side. Tighten all screws to 92 in-lb (10.4 Nm).



**Figure 8**

6. Install conveyor belt. Refer to steps 1 through 3 under “Belt Installation for Conveyor without Gearmotor Mounting Package or Stands” on page 13.
7. Tension conveyor belt. Refer to “Conveyor Belt Tensioning” on page 13.

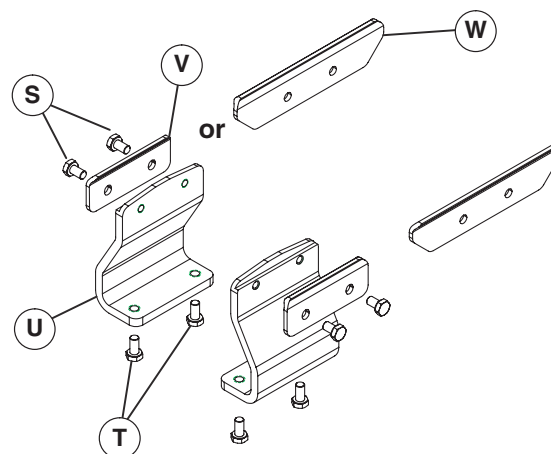
## Attaching Conveyor to Stands or Mounting Brackets

### NOTE

*Conveyor may be mounted using mounting brackets as shown in Figure 9 and Figure 10 or directly to support stands. For direct support stand mounting, see stand manual.*

1. Typical mounting bracket components (Figure 9) (One Pair).

S	M6 x 10 mm Hex Head Cap Screw (4x)
T	M6 x 12 mm Hex Head Cap Screw (4x)
U	Stand/Conveyor Ear Mount Bracket (2x)
V	Clamp Plate, Flat Belt (2x)
	or
W	Clamp Plate, Cleated Belt (2x)



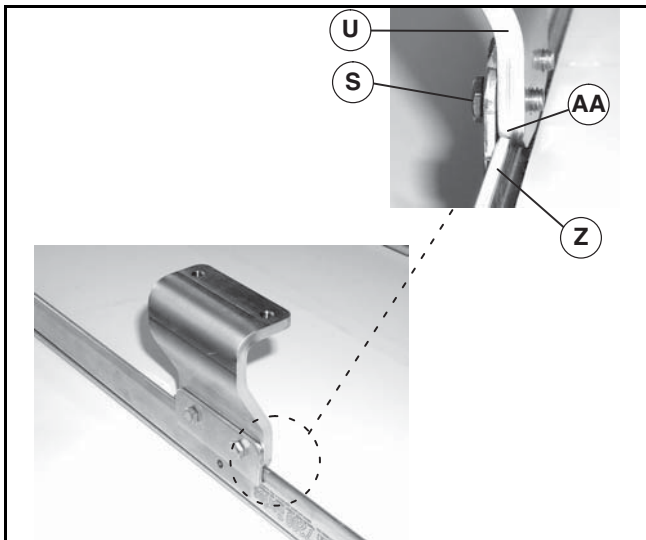
**Figure 9**

2. Attach clamp plate (Figure 9, item V or W) to stand/conveyor ear mount bracket (U) with two screws (S). Do not tighten screws.



# Installation

3. Attach stand/conveyor ear mount bracket (Figure 10, item U) to bottom of conveyor (Z). Make sure notch (AA) on bracket straddles conveyor edge as shown. Snug-up two screws (S).



**Figure 10**

4. Repeat steps 2 and 3 for other mounting bracket(s). Tighten all screws (S) to 80 in-lb (9 Nm).

## Return Rollers

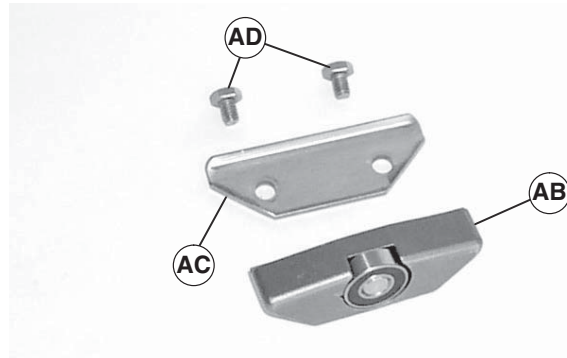
### 2" to 6" (44mm to 152mm) Wide Conveyor

#### NOTE

*No return rollers are required on conveyor lengths up to 7 ft (2134 mm). Use one pair of rollers centered between the tensioning and drive spindles on 8–15 ft (2438–4572 mm) conveyors. Use two pairs of rollers at one third distances between the tensioning and drive spindles on 16–18 ft (4877–5486 mm) conveyors.*

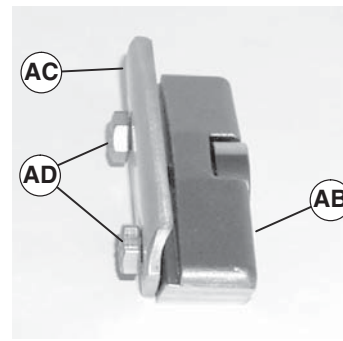
1. Return roller components (Figure 11).

AB	Mounting Block
AC	Clamp Plate
AD	Hex Head Cap Screw M6–1.0 x 12mm (2x)



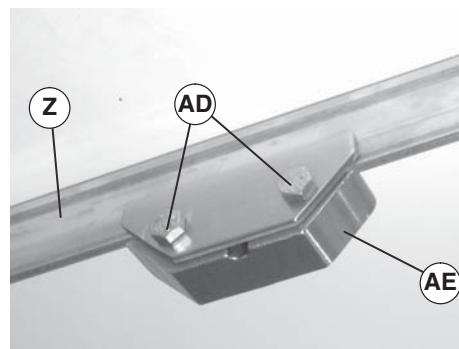
**Figure 11**

2. Loosely attach clamp plate (Figure 12, item AC) on mounting block (AB) with two screws (AD). Do not tighten screws.



**Figure 12**

3. Attach return roller assembly (Figure 13, item AE) on each side of conveyor (Z). Tighten screws (AD) to 80 in-lb (9 Nm).



**Figure 13**

4. On 8–18 ft (2338–5486 mm) conveyor, repeat step 3 as necessary for other return rollers.



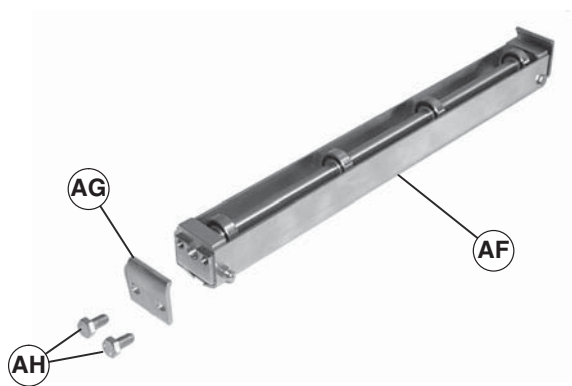
## 8" to 18" (203mm to 457mm) Wide Flat Belt Conveyors

### NOTE

*No return rollers are required on conveyor lengths up to 7 ft (2134 mm). Use one roller centered between the idler and drive spindles on 8–15 ft (2438–4572 mm) conveyors. Use two rollers at one third distances between the idler and drive spindles on 16–18 ft (4877–5486 mm) conveyors.*

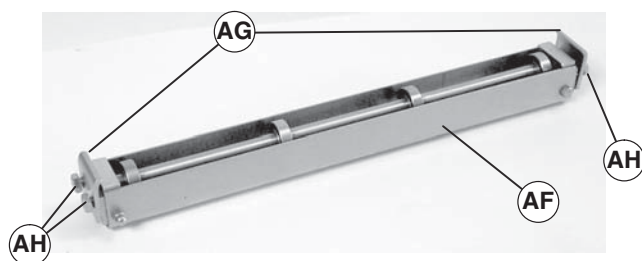
1. Typical return roller components (Figure 14)

AF	Return Roller and Guard Assembly
AG	Return Roller Clamp Plate (2x)
AH	Hex Head Cap Screw M6–1.0 x 12mm (4x)



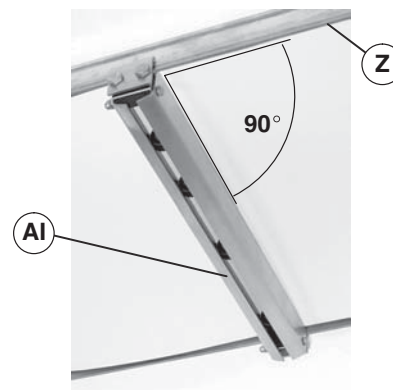
**Figure 14**

2. Loosely attach two clamp plates (Figure 15, item AG) on roller and guard assembly (AF) with four screws (AH). Do not tighten screws.



**Figure 15**

3. Attach return roller assembly (Figure 16, item AI) on conveyor (Z). Make sure return roller assembly is perpendicular with conveyor frame as shown. Tighten screws (Figure 15, item AH) to 80 in-lb (9 Nm).



**Figure 16**

4. On 16–18 ft (4877–5486 mm) conveyor, repeat step 3 for other return roller.

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# Preventive Maintenance and Adjustment

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## Required Tools

### Standard Tools

- Wrenches: 8 mm, 10 mm, 3/8" (or an adjustable wrench)
- Small bearing puller
- Arbor press

### Special Tools

- 456063 Bearing Removal Tool
- 456085 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 Bearings

No lubrication is required. Replace bearings if worn.

### Return Rollers

No lubrication is required. Replace bearings if worn.

## 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

## Cleaning

### NOTE

*Dorner recommends cleaning all the "food zones" prior to placing conveyor into service. Insure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.*

### 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

### ⚠ WARNING



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

# Preventive Maintenance and Adjustment

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

- Remove old conveyor belt

A - Conveyor without Gearmotor Mounting Package or Stands

B - Conveyor with Stands and/or Gearmotor Mounting Package

- Install new conveyor belt

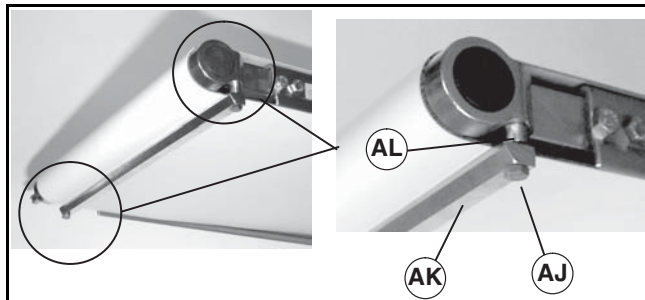
A - Conveyor without Gearmotor Mounting Package or Stands

B - Conveyor with Stands and/or Gearmotor Mounting Package

- Tension conveyor belt

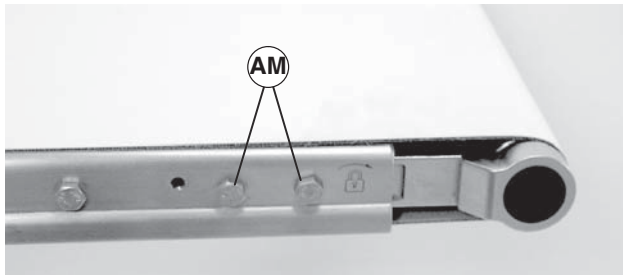
## A – Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands

1. If installed, remove and retain two M5 hex head screws (Figure 17, item AJ), bottom wiper (AK) and two sleeves (AL).



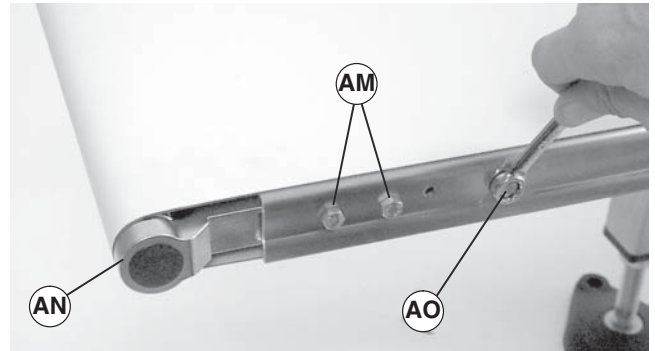
**Figure 17**

2. If installed, repeat step 1 for tension end wiper.
3. If conveyor is equipped with guiding and accessories or return rollers, remove and retain them as necessary.
4. Loosen four M6 hex head cap screws (Figure 18, item AM) and (Figure 19, item AM).



**Figure 18**

5. Retract idler spindle assembly (Figure 19, item AN) by pushing in on it or by turning M6 hex head pinion screw (AO) clockwise.



**Figure 19**

6. Remove conveyor belt (Figure 20, item AP).



**Figure 20**

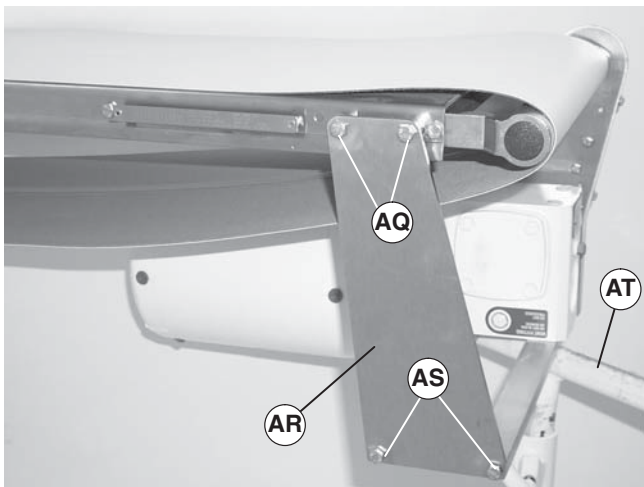
# Preventive Maintenance and Adjustment

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

### NOTE

*For conveyor with a Heavy Load Bottom or Top Gearmotor Mounting Package, bracket (Figure 21, item AR) must be removed.*

- Remove two M6x30 mm hex head cap screws and spacers (AQ).
- Remove two M6x16 mm hex head cap screws (AS).
- Remove bracket (AR).



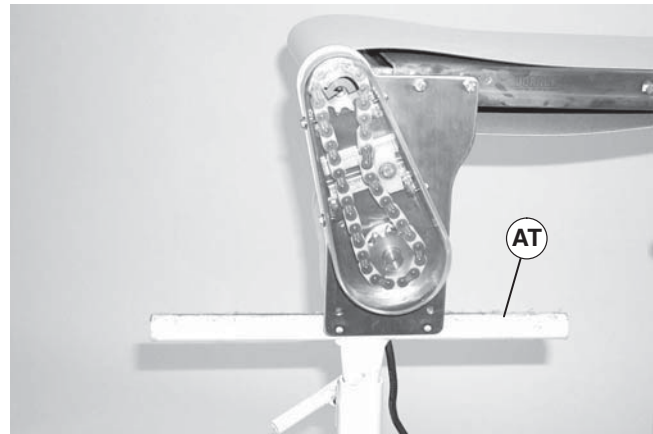
**Figure 21**

1. If installed, remove and retain two M5 hex head screws (Figure 17, item AJ), bottom wiper (AK) and two sleeves (AL).
2. If installed, repeat step 1 for tension end wiper.
3. If conveyor is equipped with guiding and accessories or return rollers, remove and retain them as necessary.
4. Loosen four M6 x 20 mm hex head cap screws (Figure 18, item AM) and (Figure 19, item AM).
5. Retract idler spindle assembly (Figure 19, item AN) by pushing in on it or by turning M6 x 25 mm hex head pinion screw (Figure 19, item AO) and (Figure 20, item AO) clockwise.

### ⚠ WARNING

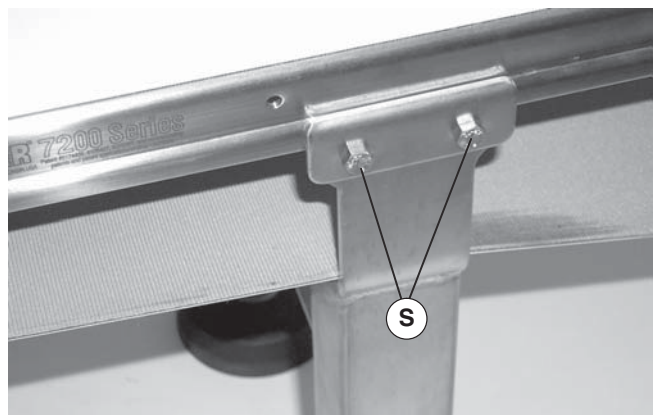
**The weight of the gearmotor is all on one end of the conveyor which could cause it to tip off the stands when the mounting clamp plates are loosened. Be sure to provide support (Figure 21, item AT) and (Figure 22, item AT) underneath the gearmotor while changing the belt.**

6. Place a temporary support (Figure 21, item AT) and (Figure 22, item AT) under gearmotor mounting package.



**Figure 22**

7. Loosen two clamp plate screws (Figure 23, item S) on side of conveyor opposite drive motor.



**Figure 23**

8. Repeat step 7 for remaining stand/conveyor ear mount brackets or stand assemblies on same side of conveyor.
9. Raise conveyor and remove conveyor belt (Figure 24, item AP).



**Figure 24**

10. If a new belt will not be installed immediately, secure conveyor with stand/conveyor ear mount brackets or stand assemblies.

# Preventive Maintenance and Adjustment

## A – Belt Installation for Conveyor without Gearmotor Mounting Package or Stands

1. Orient conveyor belt so the splice leading fingers (Figure 25, item AV) point in the direction of belt travel (AW) as identified by the label (Figure 26, item AU).

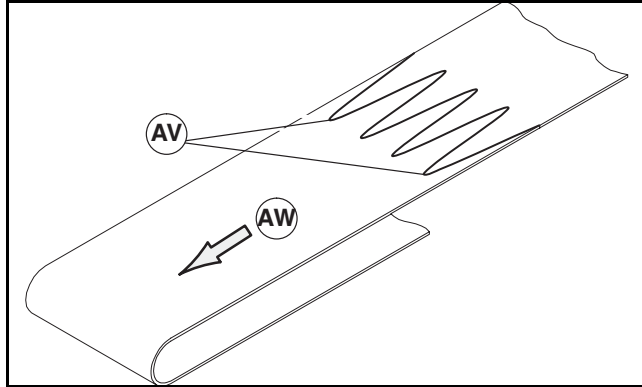


Figure 25

2. Slide belt (Figure 20, item AP) onto the conveyor frame assembly.
3. If removed, install sleeves (Figure 17, item AL), bottom wiper(s) (AK) and M5 hex head screws (AJ). Tighten screws to 33 in-lb (3.7 Nm).
4. Tension belt. Refer to “Conveyor Belt Tensioning” on page 13.
5. If removed, install return rollers, guiding and accessories.

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

### IMPORTANT

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

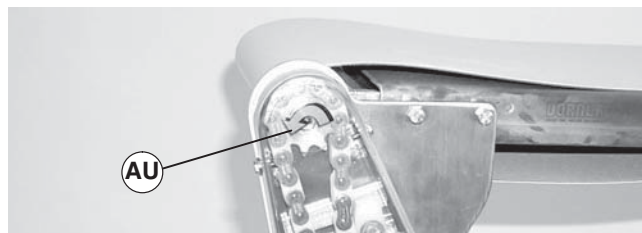


Figure 26

1. Orient conveyor belt so that the splice leading fingers (Figure 25, item AV) point in the direction of belt travel (AW) as identified by the label (Figure 26, item AU).
2. Slide belt (Figure 24, item AP) onto conveyor frame assembly.
3. Tighten two clamp plate screws (Figure 23, item S)

4. Repeat step 3 for remaining stand/conveyor ear mount brackets or stand assemblies.
5. If removed, install sleeves (Figure 17, item AL), bottom wiper(s) (AK) and M5 hex head screws (AJ). Tighten screws to 33 in-lb (3.7 Nm).
6. For a conveyor with a Heavy Load Bottom or Top Mounting package, install bracket (Figure 21, item AR).
7. Tension belt. Refer to “Conveyor Belt Tensioning” on page 13.
8. If removed, install return rollers, guiding and accessories.

## Conveyor Belt Tensioning

### ⚠ WARNING



**Exposed moving parts can cause severe injury.**

**LOCK OUT POWER before removing guards or performing maintenance.**

1. On tension end of the conveyor, loosen two M6 hex head cap screws (Figure 27, item AM) on each side of conveyor.

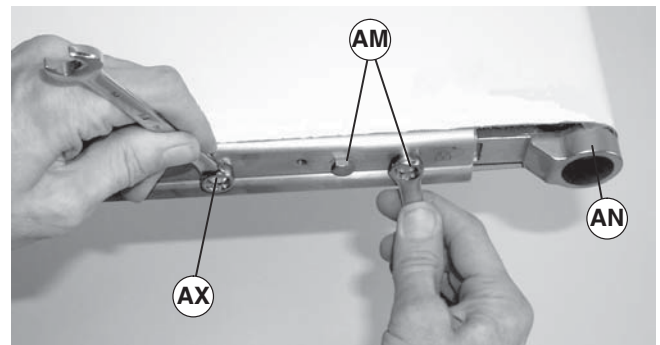


Figure 27

### NOTE

*Do not exceed a torque of 25 in-lb (2.8 Nm) for 2" through 12" (44 mm through 305 mm) wide conveyors or 40 in-lb (4.5 Nm) for an 18" (457 mm) wide conveyor on tensioning screw (AX). Over-tensioning the conveyor belt could cause excessive pulley bearing load and early failure.*

2. Extend idler spindle assembly (AN) by turning M6 hex head screw (AX) clockwise to sufficiently tension belt to handle conveyor load.
3. Tighten four M6 hex head screws (AM) to 40 in-lb (4.5 Nm) to secure idler spindle assembly (AN).



# Preventive Maintenance and Adjustment

## NOTE

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

## Pulley Removal

### ⚠ WARNING



Exposed moving parts can cause severe injury.

**LOCK OUT POWER** before removing guards or performing maintenance.

Remove conveyor belt to access pulley(s). See “Conveyor Belt Replacement” on page 10. Remove the desired pulley following instructions:

- A – Drive Pulley Removal
- B – Idler Pulley Removal

### A – Drive Pulley Removal

### ⚠ WARNING



Drive shaft keyway may be sharp.  
**HANDLE WITH CARE.**

1. Remove the gearmotor mounting package. See accessory instructions.

## NOTE

Two screws (Figure 28, item AY) were removed in step 1.

Cross support post (Figure 30, item BC) will not be secure and may drop when screws (Figure 28, item AZ) and (Figure 29, item AZ) are removed.

2. Remove screw (Figure 28, item AZ) and (Figure 29, item AZ) from each side of conveyor.

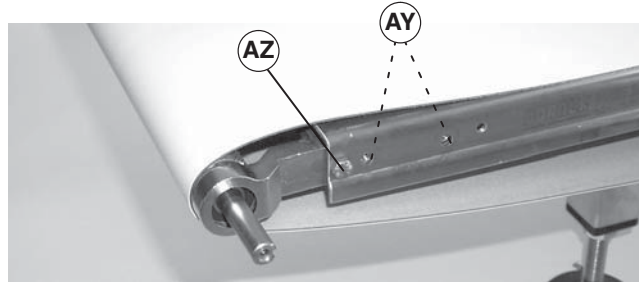


Figure 28

## NOTE

For a conveyor with a Heavy Load Bottom or Top Gearmotor Mounting Package, the two screws (Figure 29, item BA) were removed in step 1.

Drive spindle assembly (Figure 29, item BB) will not be secure and may drop when screws (Figure 28, item AZ and AY) and (Figure 29, item AZ and BA) are removed.

3. Remove two screws (Figure 29, item BA) from side of conveyor opposite drive shaft.

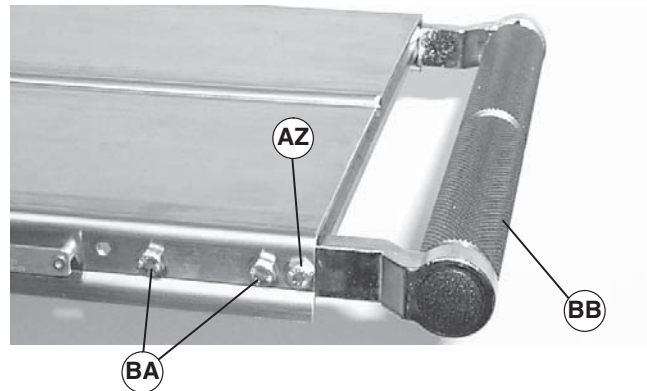


Figure 29

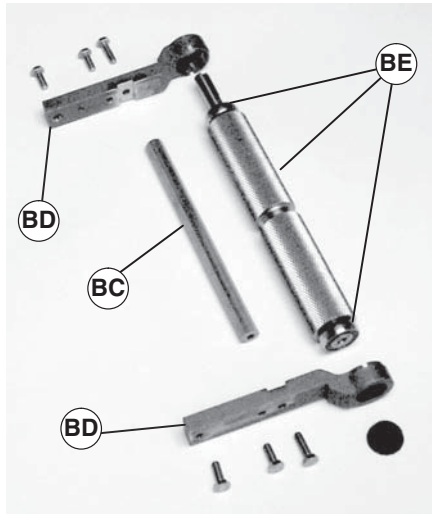
4. Remove drive spindle assembly (BB).

# Preventive Maintenance and Adjustment

5. Remove cross support post (Figure 30, item BC).
6. Remove two head plates (BD).
7. Remove drive pulley and bearing assembly (BE).

## NOTE

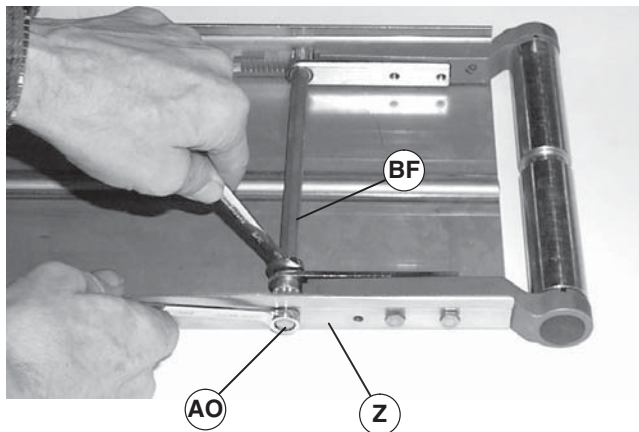
*If bearings require removal from drive pulley, see "Bearing Removal" on page 16.*



**Figure 30**

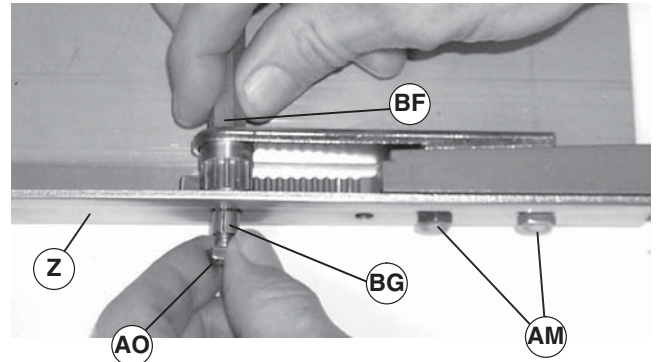
## B – Idler Pulley Removal

1. While holding hex pinion (Figure 31, item BF) with a 3/8" open-end wrench, loosen M6 hex head cap screw (AO).



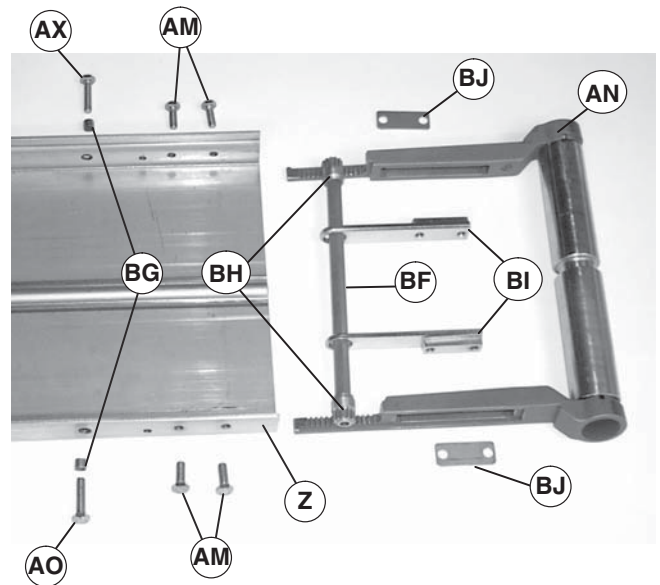
**Figure 31**

2. Remove M6 hex head cap screw (Figure 32, item AO) and sleeve (BG) from conveyor (Z) and hex pinion (BF).



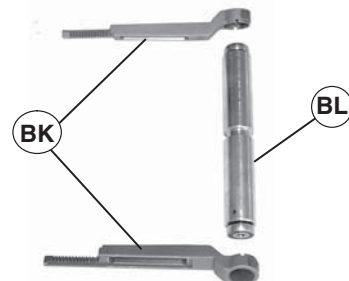
**Figure 32**

3. Repeat steps 1 and 2 for screw (Figure 27, item AX) and (Figure 33, item AX) on opposite side of conveyor.
4. Remove two M6 hex head cap screws (AM) from each side of conveyor.
5. Remove two pinion ends (Figure 33, item BH), clamp blocks (BI), hex pinion (BF), two spacers (BJ) and tail assembly (AN) from conveyor (Z).



**Figure 33**

6. Remove two head plates (Figure 34, item BK) from spindle and bearing assembly (BL).



**Figure 34**



# Preventive Maintenance and Adjustment

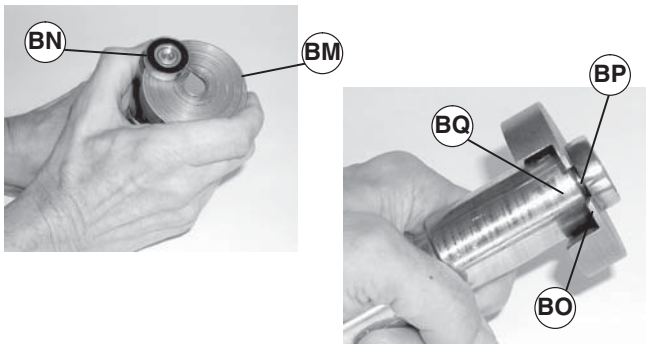
## Bearing Replacement for Drive or Idler Pulley

### IMPORTANT

*Once removed, do not re-use bearings.*

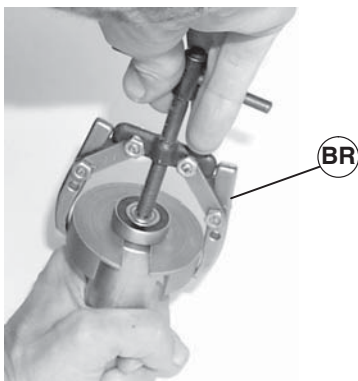
### Bearing Removal

1. Place bearing removal tool (Figure 35, item BM) (part # 456063) below bearing (BN) with lip (BO) located in gap (BP) between bearing and spindle hub (BQ) as shown.



**Figure 35**

2. Using a puller (Figure 36, item BR), remove and discard bearing.

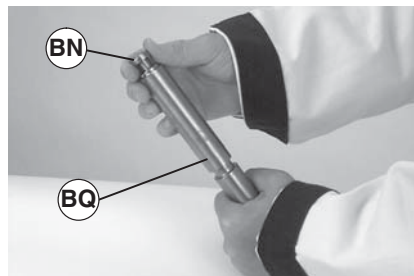


**Figure 36**

### Bearing Installation

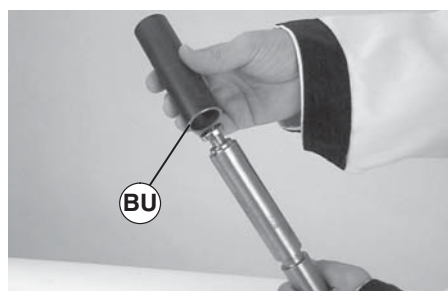
1. Inspect bearing seating surface(s) for damage. Replace spindle if damaged.

2. Slide bearing (part # 240338) (Figure 37, item BN) onto spindle (BQ).



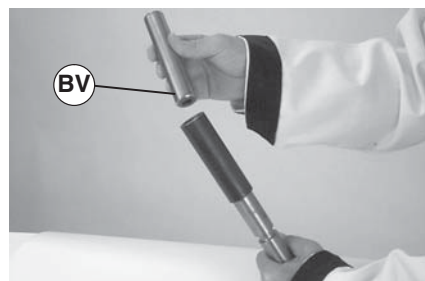
**Figure 37**

3. Slide sleeve (Figure 38, item BU) of tool (part # 456085) over bearing.



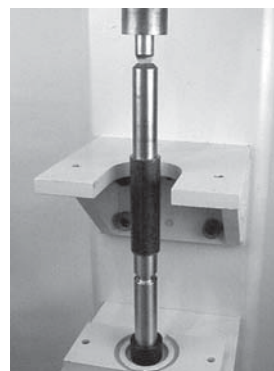
**Figure 38**

4. Place open end of pusher (Figure 39, item BV) into sleeve.



**Figure 39**

5. Using an arbor press or similar device, press bearing onto pulley shaft (Figure 40).



**Figure 40**

6. Repeat steps 1 through 5 for each bearing.

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# Preventive Maintenance and Adjustment

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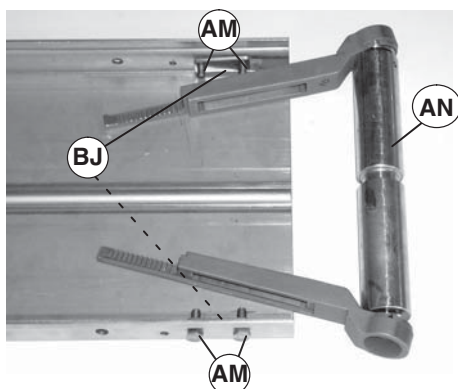
## Pulley Installation

### A – Drive Pulley Installation

1. Reverse the removal procedure “A” (see page 14).

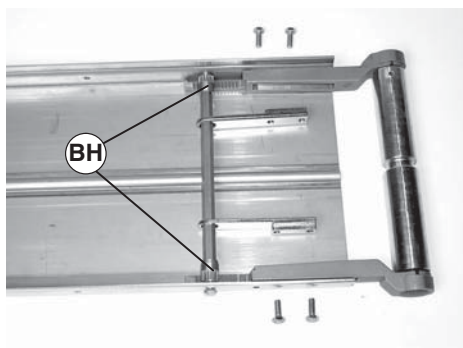
### B – Idler Pulley Installation

IMPORTANT
<i>Loosely install two spacers (Figure 33, item BJ) and (Figure 41, item BJ) and four screws (AM) prior to installing idler tail assembly (AN) on conveyor.</i>



**Figure 41**

IMPORTANT
<i>During idler pulley installation, orient both pinion ends (Figure 42, item BH) so they engage the same tooth positions on their respective racks.</i>




**Figure 42**

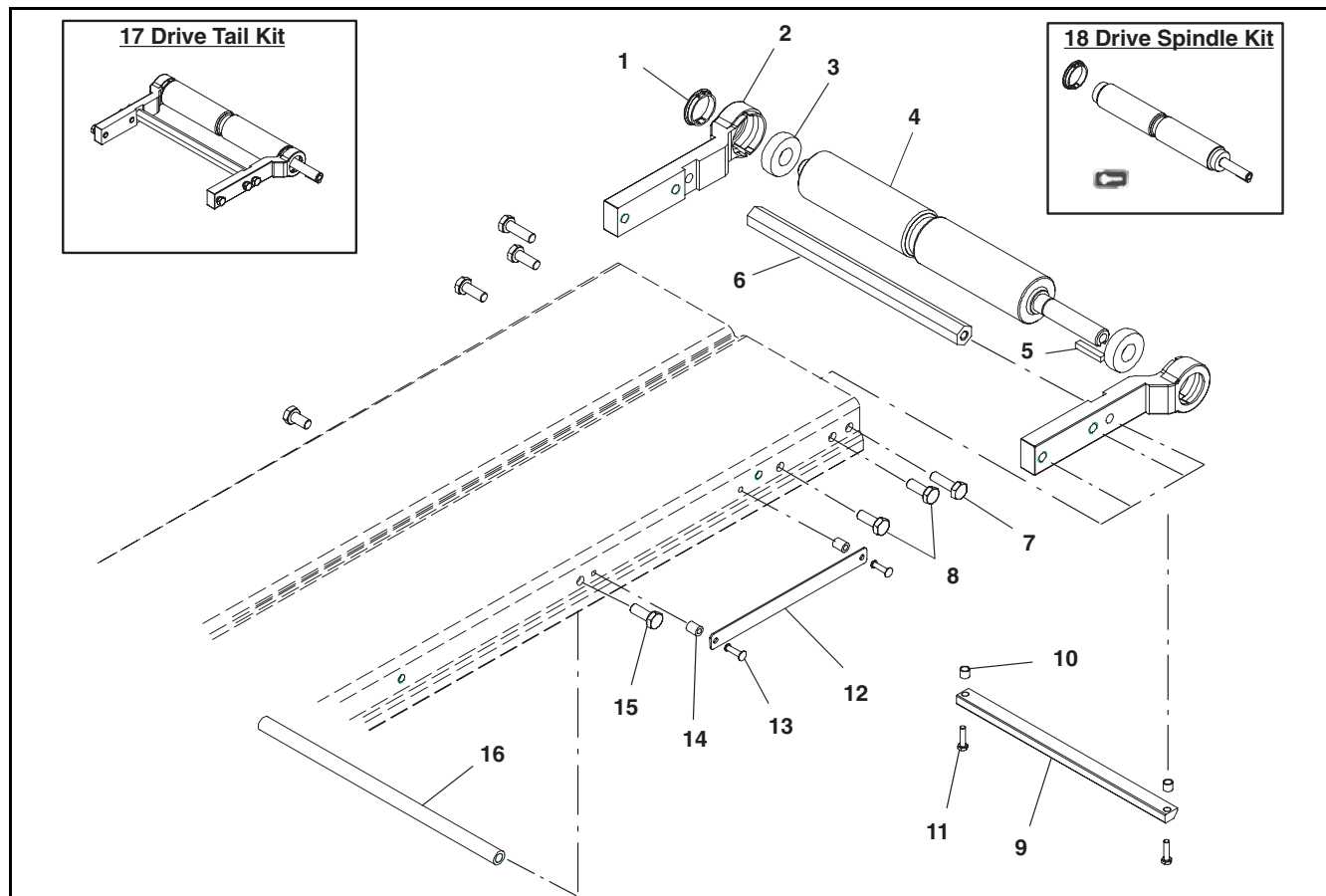
1. Reverse the removal procedure “B” (see page 15).

# 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

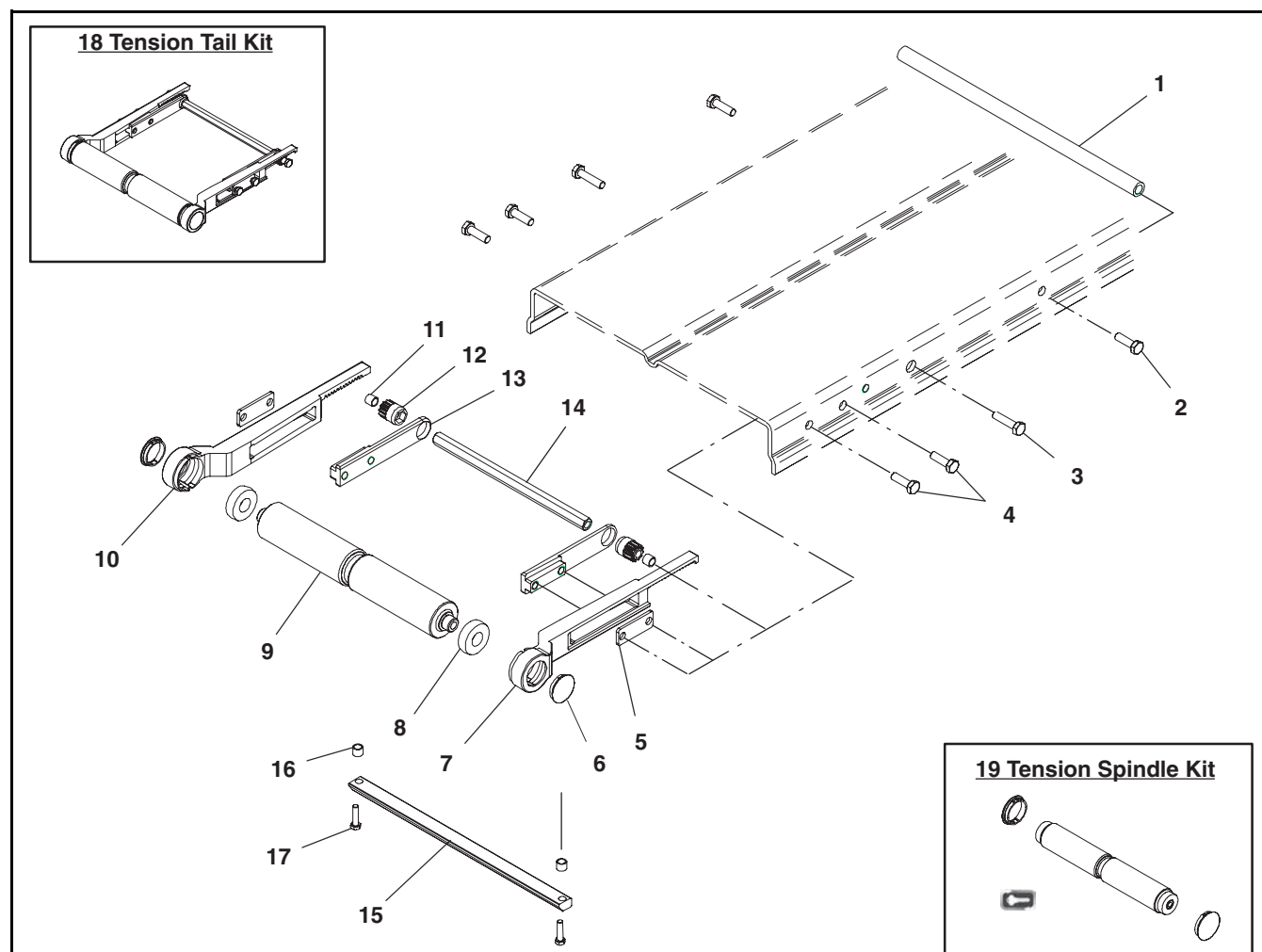


Item	Part Number	Description
1	807-1263	Plastic Hole Plug
2	456005	Head Plate Fixed w/o Wiper
	450646	Head Plate Fixed w/Wiper LH
	450647	Head Plate Fixed w/Wiper RH
3	72BK2	Bearing Kit (x2)
	72BK4	Bearing Kit (x4)
4	4564WW	Drive Spindle
5	980422MSS	Square Key 4mm x 22mm
6	4588WW	Cross Support Post
7	960620MSS	Hex Head Cap Screw M6-1.0x20mm
8	960616MSS	Hex Head Cap Screw M6-1.0x16mm
9	4557WW	Washdown Wiper
10	456049	Sleeve
11	960520MSS	Hex Head Cap Screw, M5-0.80 x 20mm

Item	Part Number	Description
12	456034	Name Tag
13	914-008	Rivet
14	807-1301	Spacer
15	960612MSS	Hex Head Cap Screw, M6-1.0x12mm
16	4525WW	Frame Support Post
17	72DT-WW	Drive Tail Kit w/o Wiper (Includes Items 1 through 8)
	72DTWA-WW	Drive Tail Kit w/Wiper – Shaft Position A or B (Includes Items 1 through 11)
	72DTWD-WW	Drive Tail Kit w/Wiper – Shaft Position C or D (Includes Items 1 through 11)
18	72DS-WW	Drive Spindle Kit (Includes Items 1, 3, 4 and 5)

WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18

## Tension End Components



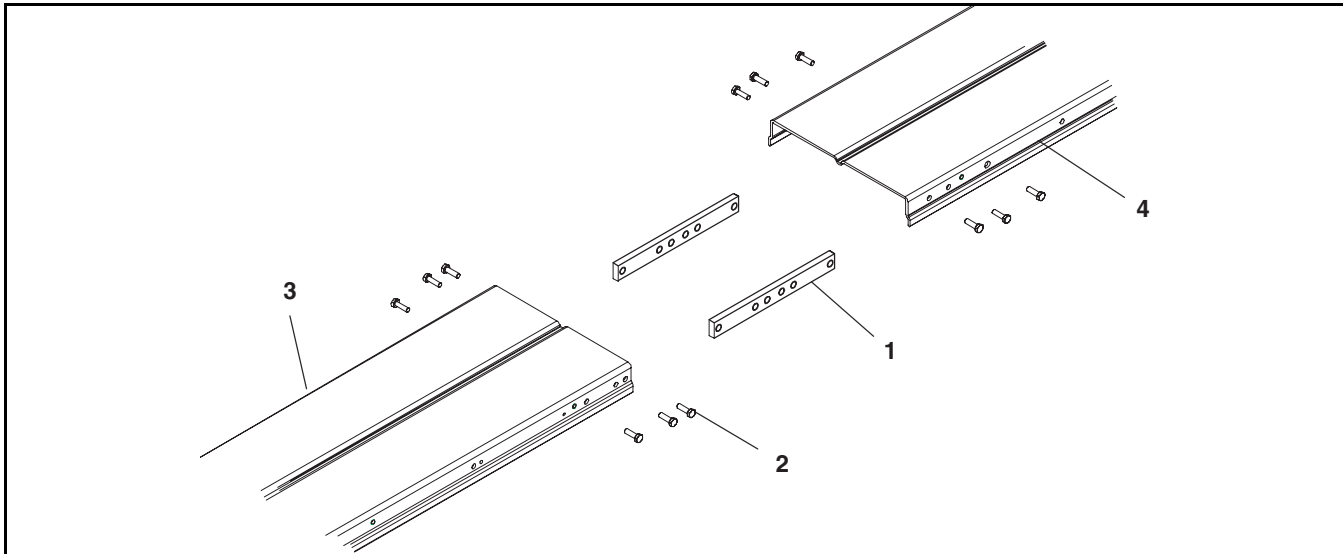
Item	Part Number	Description
1	4525 <del>WW</del> SS	Frame Support Post
2	960612MSS	Hex Head Cap Screw, M6-1.0x12mm
3	960625MSS	Hex Head Cap Screw, M6-1.0x25mm
4	960620MSS	Hex Head Cap Screw, M6-1.0x20mm
5	456064	Head Plate Spacer
6	807-1263	Plastic Hole Plug
7	456003	Head Plate Tension, RH w/o Wiper
	450645	Head Plate Tension, RH w/Wiper
8	72BK2	Bearing Kit (x2)
	72BK4	Bearing Kit (x4)
9	4561 <del>WW</del>	Idler Spindle
10	456002	Head Plate Tension, LH w/o Wiper
	450644	Head Plate Tension, LH w/Wiper

Item	Part Number	Description
11	456049	Sleeve, 0.312 OD x 0.035 Wall
12	456045	Pinion End
13	456041	Clamp Block, 3 - 18" Wide
	456042	Clamp Block, 2" Wide
14	4563 <del>WW</del>	Hex Pinion
15	4557 <del>WW</del>	Washdown Wiper
16	456049	Sleeve
17	960520MSS	Hex Head Cap Screw, M5-0.80 x 20mm
18	72TT- <del>WW</del>	Tension Tail Kit w/o Wiper (Includes Items 3 through 14)
	72TTW- <del>WW</del>	Tension Tail Kit w/Wiper (Includes Items 3 through 17)
19	72TS- <del>WW</del>	Tension Spindle Kit (Includes Items 6, 8 and 9)

~~WW~~ = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18

# Service Parts

## Conveyor Frame and Extension



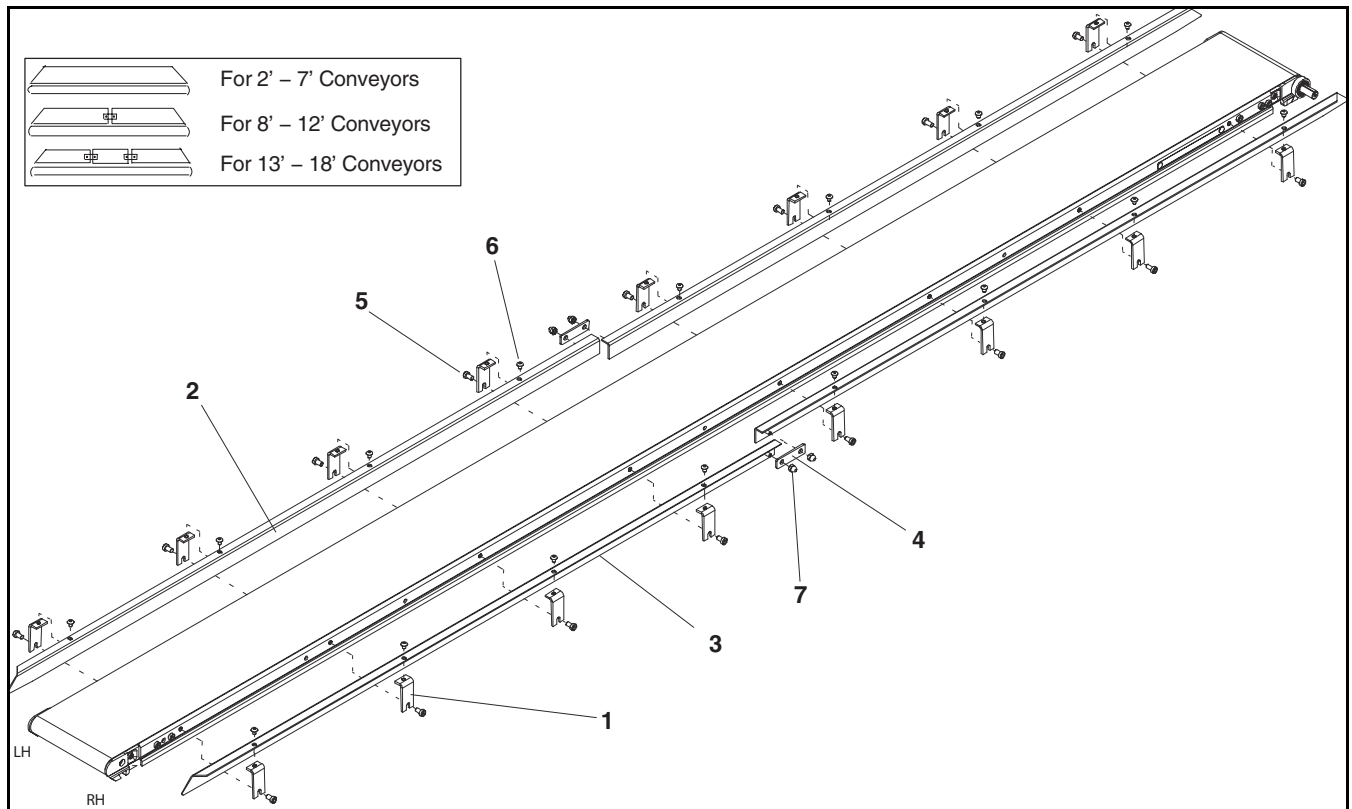
Item	Part Number	Description
1	456046	Frame Connecting Bar
2	960610MSS	Hex Head Cap Screw, M6-1.0x10mm

Item	Part Number	Description
3	See Conveyor Frame chart	Conveyor Frame
4	See Conveyor Frame chart	Conveyor Frame Extension

Items 3 and 4: Conveyor Frame		
Length	Frame Part Number	Frame Extension Part Number
2' (610mm)	4730WW-01860	n/a
3' (914mm)	4730WW-03060	n/a
4' (1219mm)	4730WW-04260	n/a
5' (1524mm)	4730WW-05460	n/a
6' (1829mm)	4730WW-06660	n/a
7' (2134mm)	4730WW-07860	n/a
8' (2438mm)	4730WW-09060	n/a
9' (2743mm)	4730WW-10260	n/a

Items 3 and 4: Conveyor Frame		
Length	Frame Part Number	Frame Extension Part Number
10' (3048mm)	4730WW-11460	n/a
11' (3353mm)	4730WW-12660	n/a
12' (3658mm)	4730WW-13860	n/a
13' (3962mm)	4730WW-07860	4750WW
14' (4267mm)	4730WW-09060	4750WW
15' (4572mm)	4730WW-10260	4750WW
16' (4877mm)	4730WW-11460	4750WW
17' (5182mm)	4730WW-12660	4750WW
18' (5486mm)	4730WW-13860	4750WW

## -21 1" (25mm) Sanitary Bolt-On High Sides



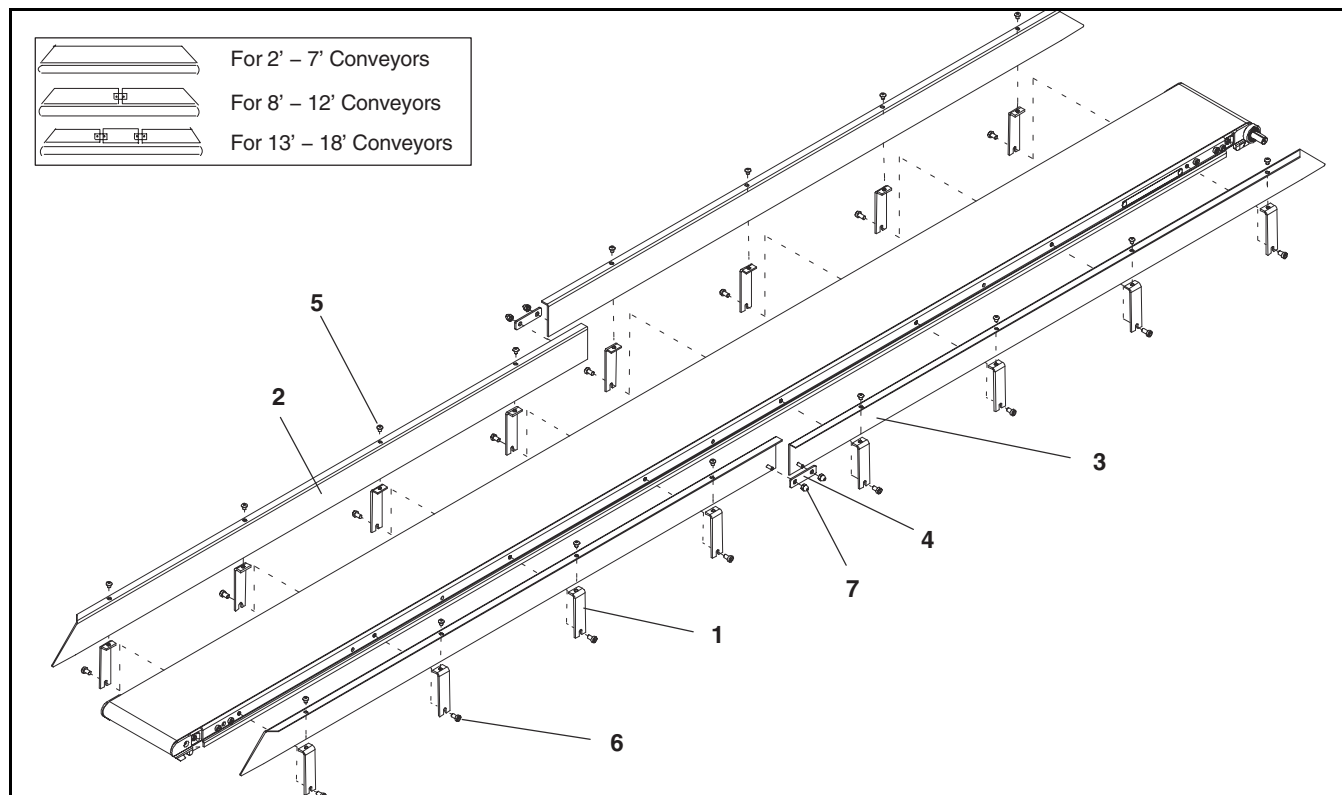
Item	Part Number	Description
1	462150MSS	1" Guide Mounting Bracket Guide
2	See chart below	1" Guide, LH
3	See chart below	1" Guide, RH
4	450188SS	Tie Plate
5	960608MSS	Hex Head Screw, M6-1.0 x 8mm
6	960506MSS	Hex Head Screw, M5-0.8 x 6mm
7	990508MSS	Acorn Nut, M5

Conveyor Length		Tail End Guide	Center Guide	Drive 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	462154SSP	N/A	462144SSP
	Left Hand	462144SSP	N/A	462154SSP
9' (2743mm)	Right Hand	462155SSP	N/A	462144SSP
	Left Hand	462145SSP	N/A	462154SSP
10' (3048mm)	Right Hand	462155SSP	N/A	462145SSP
	Left Hand	462145SSP	N/A	462155SSP

Conveyor Length		Tail End Guide	Center Guide	Drive End Guide
11' (3353mm)	Right Hand	462156SSP	N/A	462145SSP
	Left Hand	462146SSP	N/A	462155SSP
12' (3658mm)	Right Hand	462156SSP	N/A	462146SSP
	Left Hand	462146SSP	N/A	462156SSP
13' (3962mm)	Right Hand	462156SSP	462163SSP	462144SSP
	Left Hand	462146SSP	462163SSP	462154SSP
14' (4267mm)	Right Hand	462156SSP	462163SSP	462145SSP
	Left Hand	462146SSP	462163SSP	462155SSP
15' (4572mm)	Right Hand	462156SSP	462163SSP	462146SSP
	Left Hand	462146SSP	462163SSP	462156SSP
16' (4877mm)	Right Hand	462156SSP	462166SSP	462144SSP
	Left Hand	462146SSP	462166SSP	462154SSP
17' (5182mm)	Right Hand	462156SSP	462166SSP	462145SSP
	Left Hand	462146SSP	462166SSP	462155SSP
18' (5486mm)	Right Hand	462156SSP	462166SSP	462146SSP
	Left Hand	462146SSP	462166SSP	462156SSP

# Service Parts

## –22 2” (51mm) Sanitary Bolt – On High Sides



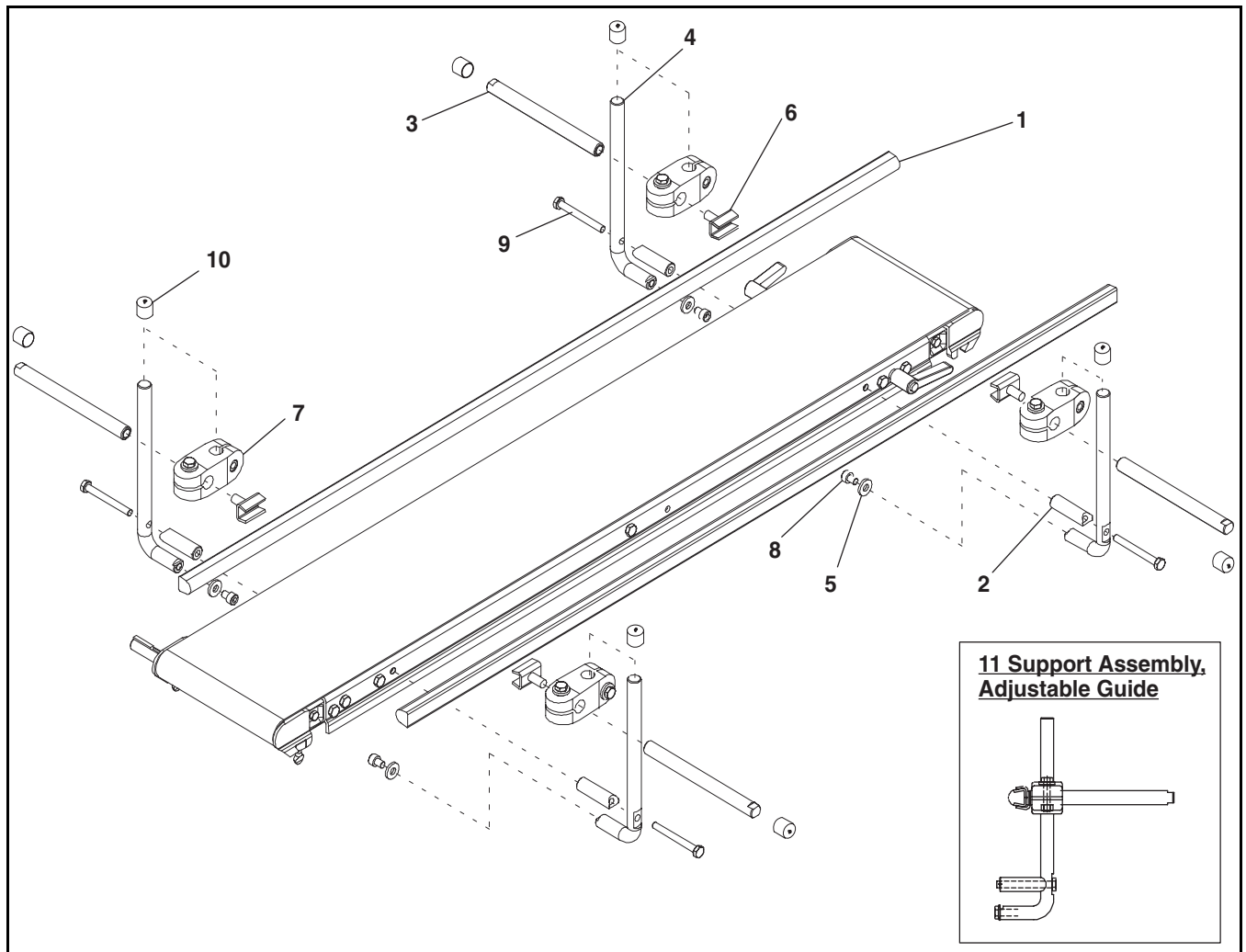
Item	Part Number	Description
1	462250MSS	2" Guide Mounting Bracket Guide
2	See chart below	2" Guide, LH
3	See chart below	2" Guide, RH
4	450188SS	Guide Tie Plate
5	960608MSS	Hex Head Screw, M6–1.0 x 10mm
6	960506MSS	Hex Head Screw, M5–0.8 x 6mm
7	990508MSS	Acorn Nut, M5

Conveyor Length		Tail End Guide	Center Guide	Drive 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	462254SSP	N/A	462244SSP
	Left Hand	462244SSP	N/A	462254SSP
9' (2743mm)	Right Hand	462255SSP	N/A	462244SSP
	Left Hand	462245SSP	N/A	462254SSP
10' (3048mm)	Right Hand	462255SSP	N/A	462245SSP
	Left Hand	462245SSP	N/A	462255SSP

Conveyor Length		Tail End Guide	Center Guide	Drive End Guide
11' (3353mm)	Right Hand	462256SSP	N/A	462245SSP
	Left Hand	462246SSP	N/A	462255SSP
12' (3658mm)	Right Hand	462256SSP	N/A	462246SSP
	Left Hand	462246SSP	N/A	462256SSP
13' (3962mm)	Right Hand	462256SSP	462263SSP	462244SSP
	Left Hand	462246SSP	462263SSP	462254SSP
14' (4267mm)	Right Hand	462256SSP	462263SSP	462245SSP
	Left Hand	462246SSP	462263SSP	462255SSP
15' (4572mm)	Right Hand	462256SSP	462263SSP	462246SSP
	Left Hand	462246SSP	462263SSP	462256SSP
16' (4877mm)	Right Hand	462256SSP	462266SSP	462244SSP
	Left Hand	462246SSP	462266SSP	462254SSP
17' (5182mm)	Right Hand	462256SSP	462266SSP	462245SSP
	Left Hand	462246SSP	462266SSP	462255SSP
18' (5486mm)	Right Hand	462256SSP	462266SSP	462246SSP
	Left Hand	462246SSP	462266SSP	462256SSP



## -23 Sanitary Fully Adjustable UHMW Guide

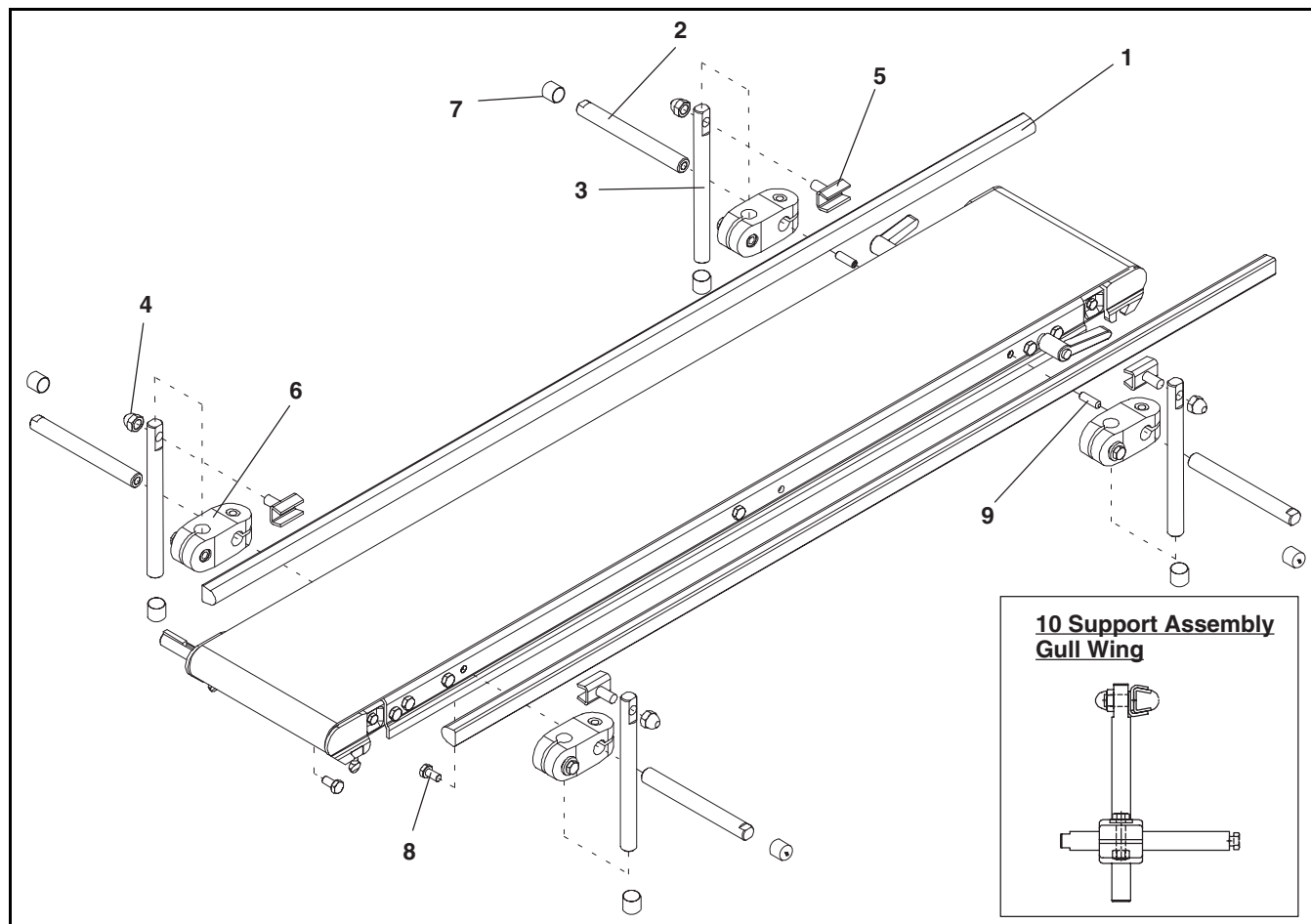


Item	Part Number(s)	Description
1	462332	Guide Mounting Rail 2' (610mm)
	462333	Guide Mounting Rail 3' (914mm)
	462334	Guide Mounting Rail 4' (1219mm)
	462335	Guide Mounting Rail 5' (1524mm)
	462336	Guide Mounting Rail 6' (1829mm)
	462337	Guide Mounting Rail 7' (2134mm)
	462338	Guide Mounting Rail 8' (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)

Item	Part Number(s)	Description
2	462351MSS	Shaft Brace
3	462352SS	Horizontal Shaft Mounting Guide
4	462350MSS	Vertical Shaft Adjustable Guide
5	911-201	Flat Washer
6	807-978	Guide Clamp
7	450187MSS	Cross Block
8	960608MSS	Hex Head Screw (Metric), M6-1.0 x 8mm
9	960650MSS	Hex Head Screw (Metric), M6-1.0 x 50mm
10	807-948	Cap, Vinyl
11	462300MSS	Support Assembly, Adjustable Guide (Includes Items: 2 through 10)

# Service Parts

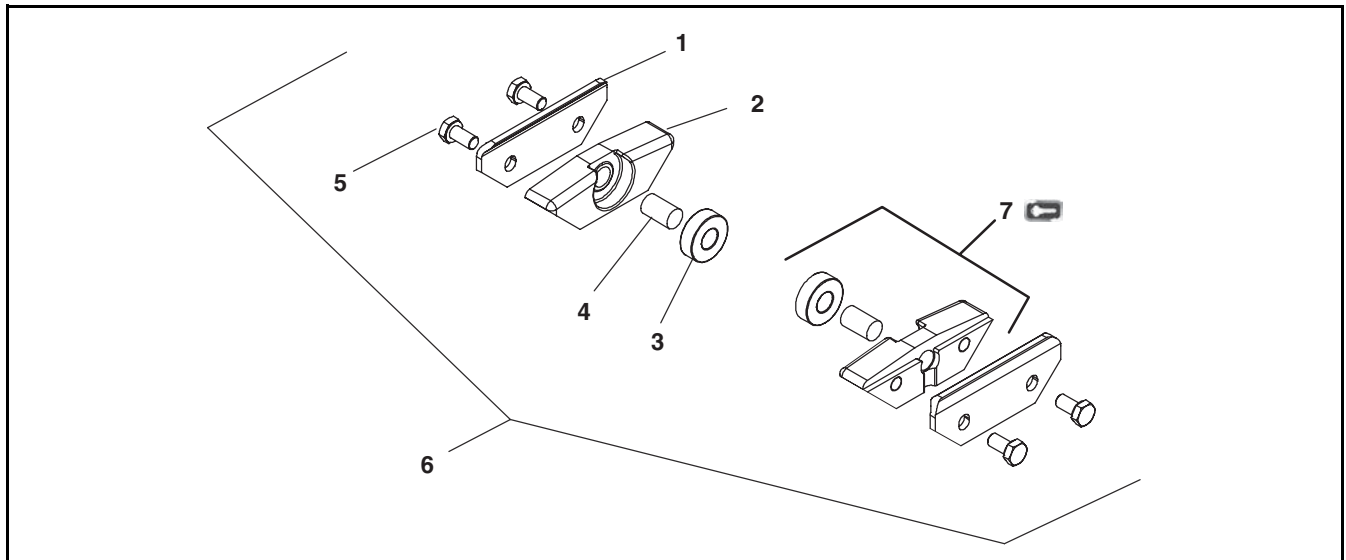
## –24 Sanitary Adjustable Width UHMW Guides



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)

Item	Part Number(s)	Description
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	807-948	Cap, Vinyl
8	960612MSS	Hex Head Cap Screw, M6-1.0 x 12mm
9	970620MSS	Socket Head Set Screw, M6-1.0 x 20mm
10	462400MSS	Support Assembly, Gull Wing (Includes Items: 2 through 7)

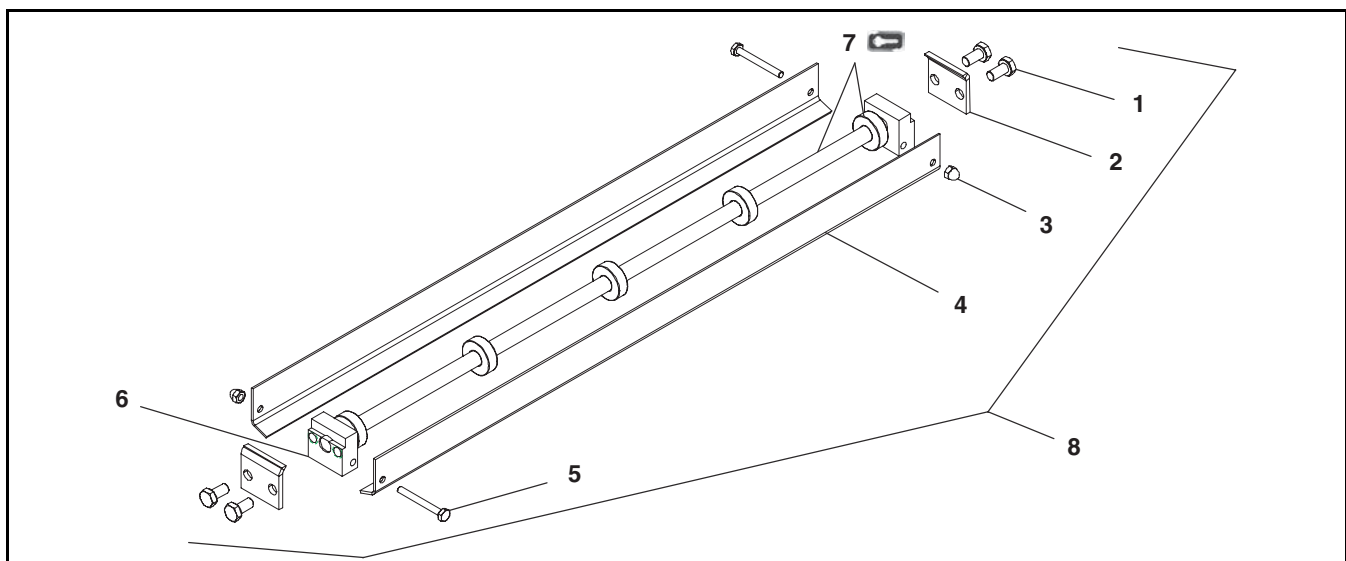
## Sanitary 2" (51mm) Through 6" (152mm) Wide Flat or Cleated Belt Return Roller



Item	Part Number	Description
1	450593	Clamp Plate
2	450596	Mounting Block
3	802-123	Bearing
4	913-103	Dowel Pin

Item	Part Number	Description
5	960612MSS	Hex Head Screw M6-1.0 x 12mm
6	450594	Return Roller Assembly
7	450595	Roller Assembly (3 piece)

## Sanitary 8" (203mm) Through 18" (457mm) Wide Flat Belt Return Roller

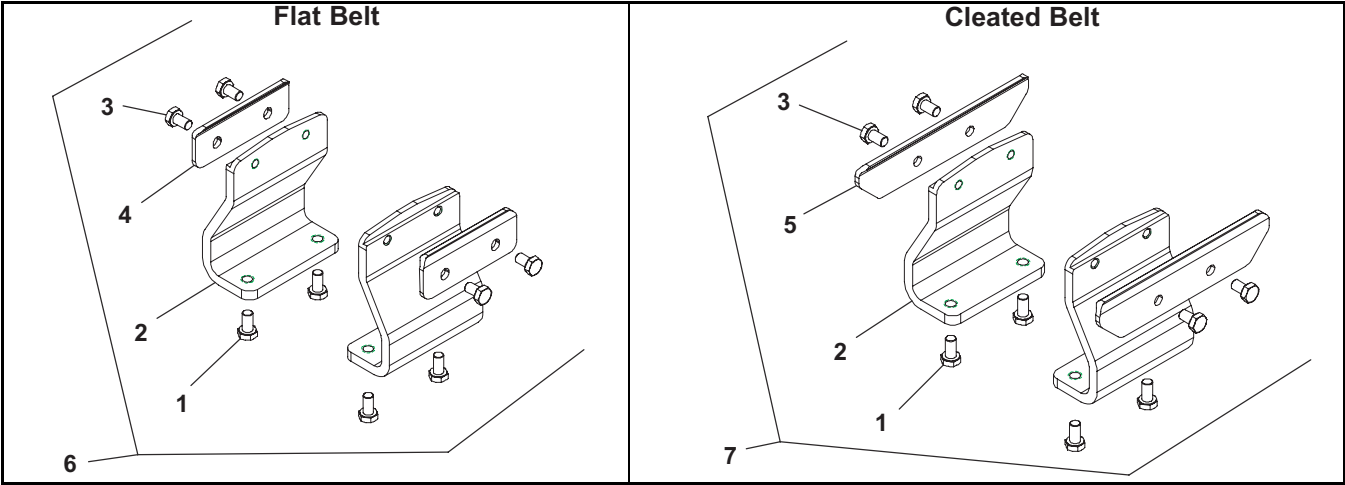


Item	Part Number	Description
1	960612MSS	Hex Head Cap Screw M6-1.0 x 12mm
2	450628	Clamp Plate
3	990408MSS	Acorn Nut M4-0.70
4	4516WW	Return Roller Guard

Item	Part Number	Description
5	960435MSS	Hex Head Cap Screw M4-0.70 x 35mm
6	450626	Mounting Block
7	4517WW	Shaft/Bearing Assembly
8	4514WW	Return Roller Assembly
WW = Conveyor width ref.: 08, 10, 12, 18		

# Service Parts

## Conveyor Mounting Brackets



Item	Part Number	Description
1	960612MSS	Hex Head Cap Screw M6–1.0 x 12mm
2	450590	Stand/Conveyor Ear Mount Bracket
3	960610MSS	Hex Head Cap Screw M6–1.0 x 10mm
4	492564SS	Clamp Plate – Flat Belt

Item	Part Number	Description
5	492566SS	Clamp Plate – Cleated Belt
6	450589	Mount Assembly – Flat Belt
7	450591	Mount Assembly – Cleated Belt

Configuring Conveyor Belt Part Number

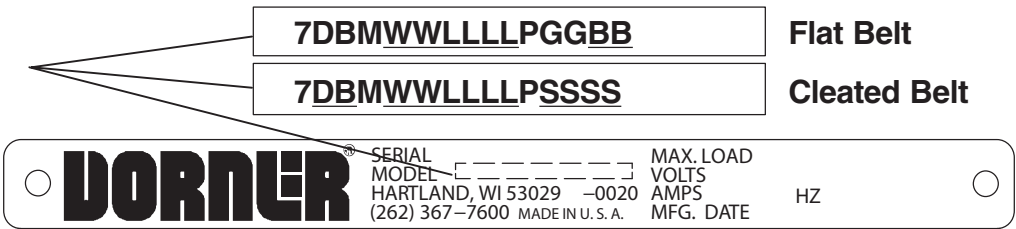


Figure 43

Flat Belt

Refer to your serial and model number plate (Figure 43). From the model number, determine conveyor width (WW), length (LLLL) and belt type (BB). Use data to configure belt part number as indicated below.

7D-WWLLLL / BBV

72- \_\_\_\_\_ / \_\_\_\_\_ V  
 (Fill In)

EXAMPLE:

721M030200A0102 Conveyor

7200 Series end drive, flat belt conveyor with mounting brackets, USA English, 3” (76mm) wide x 2.0 ft (610mm) long, shaft position A, guide profile 01 and belt type /02 (general purpose)

72-030200/02V Belt

Cleated Belt

Refer to your serial and model number plate (Figure 43). From the model number, determine conveyor type (D), width (WW), length (LLLL), belt cleat type (B), and cleat spacing (SSSS). Use data to configure belt part number as indicated below.

7D-WWLLLLBSSSSV

7- \_\_\_\_\_ V  
 (Fill In)

EXAMPLE:

74AM030200A0659 Conveyor

7200 Series standard cleated belt conveyor with mounting brackets, A-style cleat, USA English, 3” (76mm) wide x 2.0 ft (610mm) long, shaft position A, and 6.59 in (167.4mm) cleat spacing

74-030200A0659V Belt

# 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](http://www.dorner.com).

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



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