



Diagonal Brace Kit

Installation, Maintenance & Parts Manual



DORNER MFG. CORP.
P.O. Box 20 • 975 Cottonwood Ave.
Hartland, WI 53029-0020 USA

INSIDE THE USA
TEL: 1-800-397-8664
FAX: 1-800-369-2440

OUTSIDE THE USA
TEL: 262-367-7600
FAX: 262-367-5827

For other service manuals visit our website at:
www.dorner.com/service_manuals.asp

Table of Contents

Introduction	2	Connecting to a Single Post Support Stand.....	5
Warnings - General Safety	3	Connecting to all Other Support Stands	6
Product Description	4	Connecting to a 6100 Series Conveyor	7
Specifications	4	Connecting to 2200, MPB, 3200, and LPZ Series Conveyors.....	7
Installation	5	Service Parts.....	8
Recommended Installation Sequence	5	Notes	9
Required Tools.....	5	Return Policy.....	10
Diagonal Bracing	5		
Typical Components	5		

Introduction

IMPORTANT

<i>Some illustrations may show guards removed. DO NOT operate equipment without guards.</i>

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

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



Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.

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.

SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.

⚠ 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 and Figure 1 for typical diagonal brace kit components.

A	Conveyor
B	Support Stand
C	Support Stand Tie Plate
D	Diagonal Brace
E	Connection to Conveyor

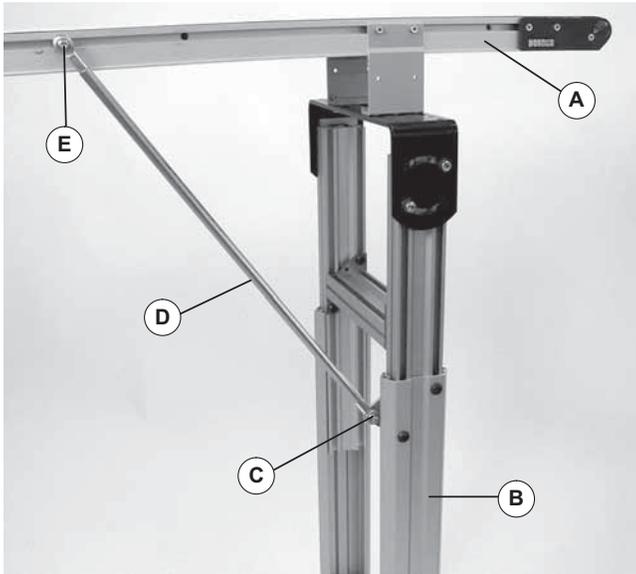


Figure 1

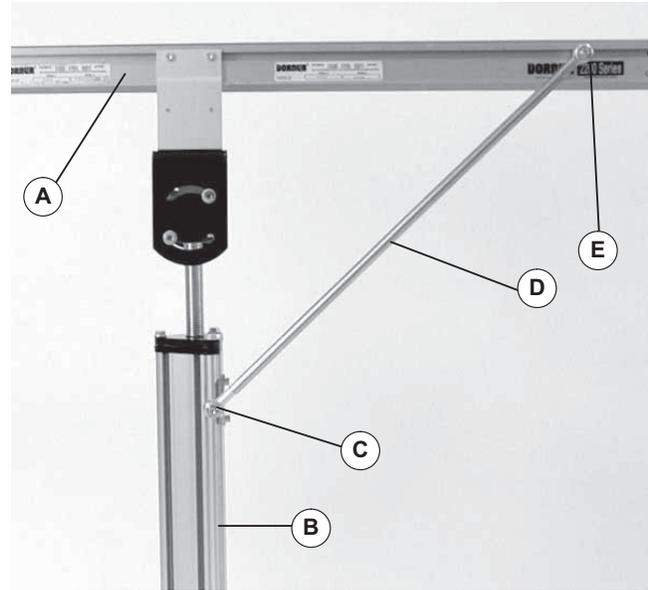


Figure 2

Specifications

Diagonal Brace Models

For Single Post Support Stands = 710247

For All Other Support Stands

Stands under 30" (762mm) tall = 710047

Stands 30" (762mm) and taller = 710046

Recommended Installation Sequence

- Attach stand(s) to conveyor (see Stand Installation Maintenance & Parts Manual)
- Attach diagonal bracing
- Attach end to stand
 - For single post stand see Step 1 (page 5)
 - For all other stands see Step 2 (page 6)
- Attach end to conveyor
 - For 6100 series conveyor see Step 3 (page 7)
 - For all other conveyors see Step 4 (page 7)
- Adjust stand height and level (see Stand Installation, Maintenance & Parts Manual)

Required Tools

- 5 mm Hex Key Wrench

Diagonal Bracing

⚠ WARNING

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

Typical Components

K	Drop-in T-Bar
L	Diagonal Brace Assembly
M	2 Hole Drop-in T-Bar
N	M6 Fastener (2x)
O	6100 Mounting Clip

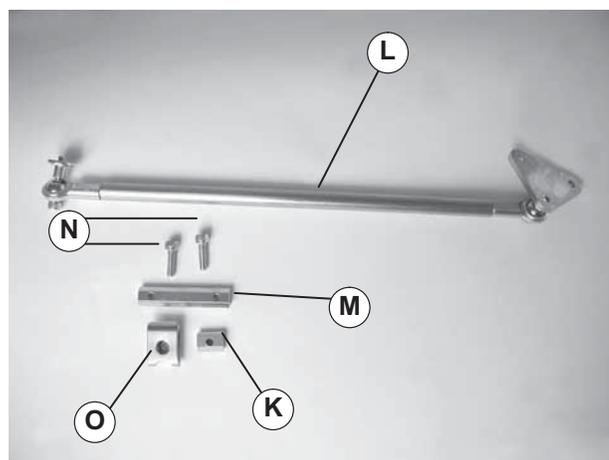


Figure 3

1. Connecting to a Single Post Support Stand

NOTE

One stand leg (Figure 4, item U) must be oriented parallel to conveyor (V). Use t-slot (W) for connection to support stand.

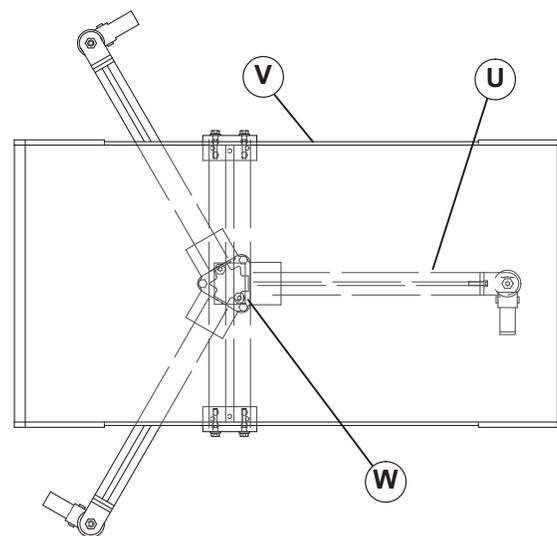


Figure 4

- a. Roll a 2 hole drop-in t-bar (Figure 5, item M) into t-slot (W) of the trileg post (X).

Installation



Figure 5

- b. Attach support stand tie plate (Figure 6, item Z) to the t-bar (M) with two (2) socket screws (Y).

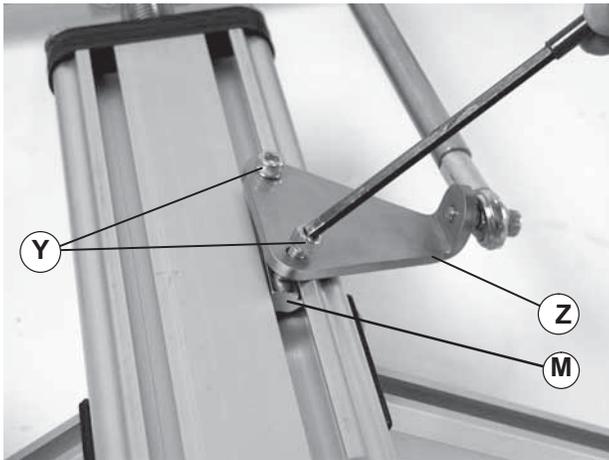


Figure 6

⚠ WARNING
<p>Failure to secure screws (Figure 5, item Y) may cause conveyor sections to drop down causing severe injury.</p> <p>TIGHTEN SCREWS (Y) AFTER ADJUSTMENT.</p>

- c. Tighten screws (Figure 6, item Y) to 100 in-lb (11 N-m).

2. Connecting to all Other Support Stands

- a. Roll a 2 hole drop-in t-bar (Figure 7, item M) into an inside t-slot (AA) of the vertical stand leg (AB).

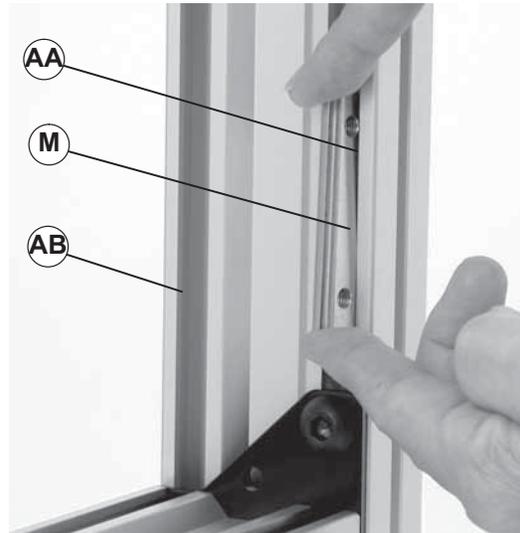


Figure 7

- b. Attach the support stand tie plate (Figure 8, item Z) to the stand (AB) with two (2) socket screws (Y).

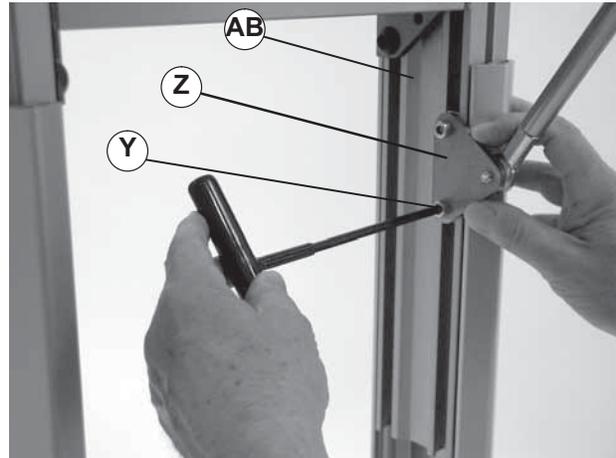


Figure 8

⚠ WARNING
<p>Failure to secure screws (Figure 7, item Y) may cause conveyor sections to drop down causing severe injury.</p> <p>TIGHTEN SCREWS (Y) AFTER ADJUSTMENT.</p>

- c. Tighten socket screws (Figure 8, item Y) to 100 in-lb (11 N-m).

3. Connecting to a 6100 Series Conveyor
 - a. Place mounting clip (Figure 9, item O) onto conveyor quick clamp mounting rail (AC).

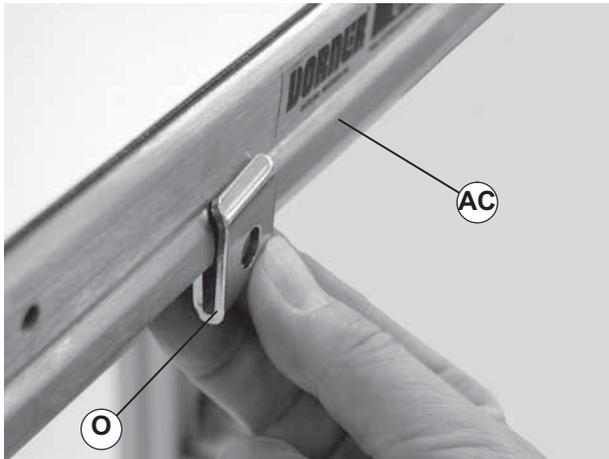


Figure 9

- b. Attach the diagonal brace end (Figure 10, item AD) to the mounting clip (O) with socket screw (AE).

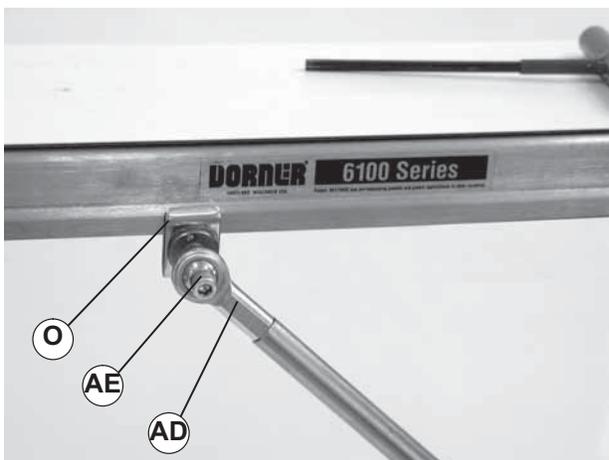


Figure 10

⚠ WARNING
<p>Failure to secure screws (Figure 9, item Y) may cause conveyor sections to drop down causing severe injury.</p> <p>TIGHTEN SCREWS (Y) AFTER ADJUSTMENT.</p>

- c. Tighten screw (Figure 10, item AE) to 100 in-lb (11 N-m).

4. Connecting to 2200, MPB, 3200, and LPZ Series Conveyors
 - a. Roll a drop-in t-bar (Figure 11, item K) into conveyor t-slot (AF).

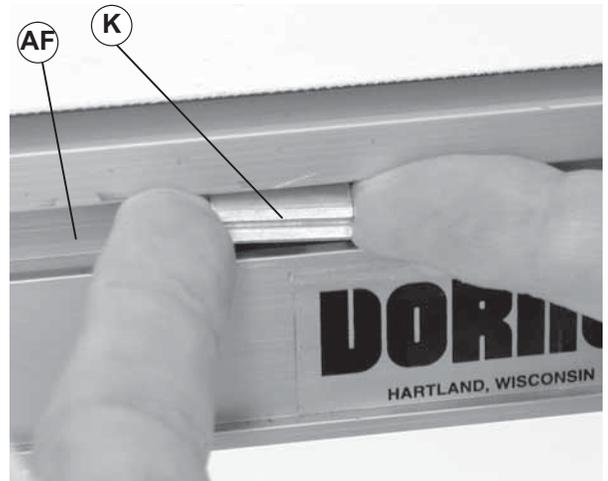


Figure 11

- b. Attach the diagonal brace end (Figure 12, item AD) to the t-bar (K) with a socket screw (AE).

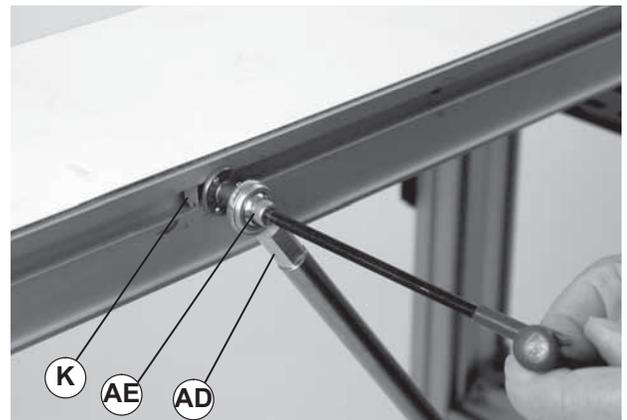


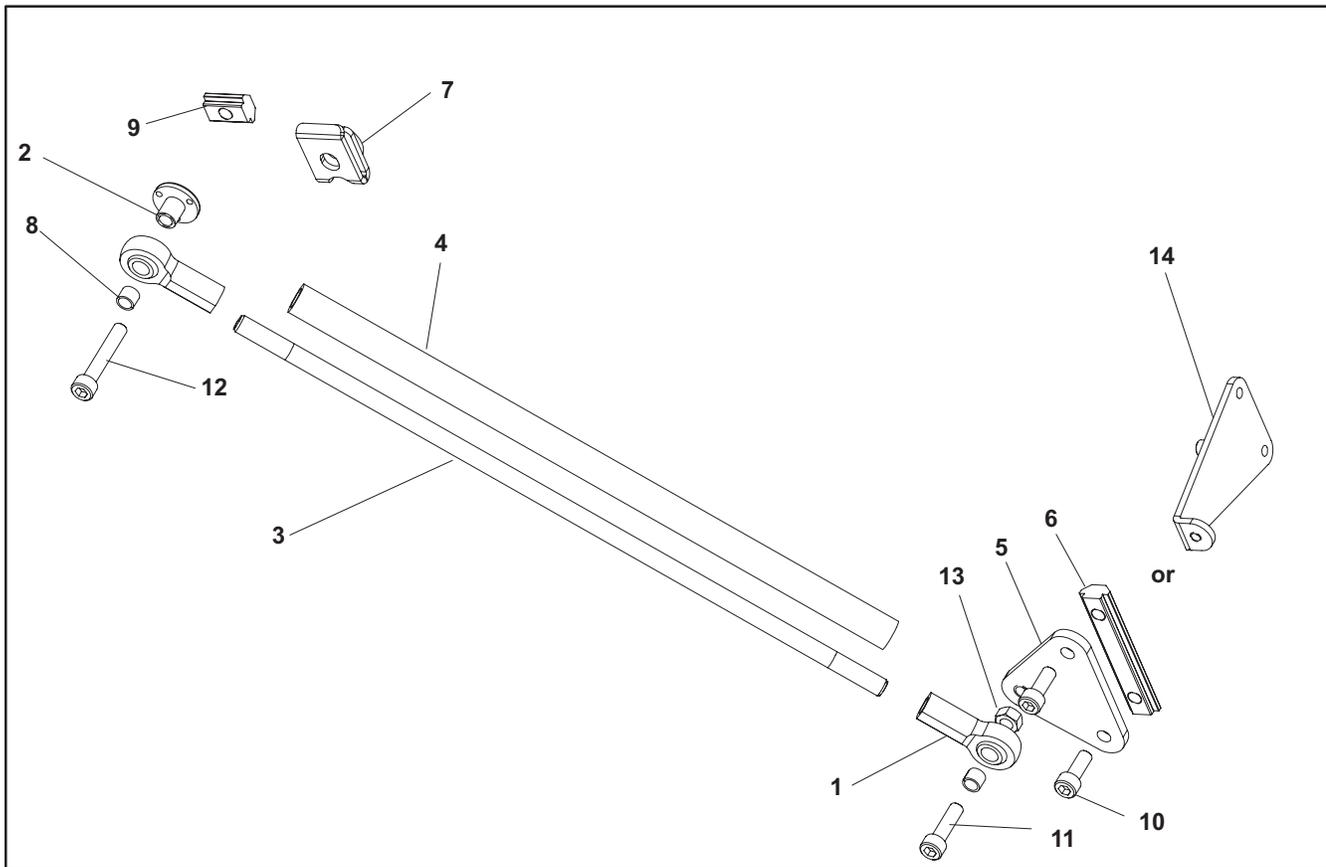
Figure 12

⚠ WARNING
<p>Failure to secure screws (Figure 11, item AE) may cause conveyor sections to drop down causing severe injury.</p> <p>TIGHTEN SCREWS (Y) AFTER ADJUSTMENT.</p>

- c. Tighten screw (Figure 12, item AE) to 100 in-lb (11 N-m).

Service Parts

Brace Assembly for H Style Stand and Single Post Stand



Item	Part Number	Description
1	801-129	M8 Rod End
2	807-1291	Nut, weld, cir Pilot-M6
3	710009	Stud, Diagonal Brace, 10.500 Long
	710008	Stud, Diagonal Brace, 20.500 Long
4	710012	Tube, Diagonal Brace, 11.500 Long
	710011	Tube, Diagonal Brace, 21.500 Long
5	710013	Plate, Post Stand Mtg, Dia Brace
6	300150M	Bar, Tee, Drop-in 1.88" CD Metric
7	450186M	Clip Assy, Mtg, ACC-Metric

Item	Part Number	Description
8	450226SSP	Sleeve, .250 Magnet, Stn Stl
9	639971M	Bar, Tee, Drop-in single Metric
10	920616M	Scr, Sock, Metric M6-1.00x16mm
11	920622M	Scr, Sock, Metric M6-1.00x22mm
12	920635M	Scr, Sock, Metric M6-1.00x35mm
13	990601M	Nut, Hex, Full M6-1.00
14	710216	Plate, Post Stand Mtg, Dia Brace Single Post Stand

Return Policy

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

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

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization number for reference.

There will be a return charge on all new undamaged items returned for credit where Dorner was not at fault. Dorner is not responsible for return freight on such items.

Conveyors and conveyor accessories	
Standard catalog conveyors	30%
MPB Series, cleated and specialty belt conveyors	50%
7400 & 7600 Series conveyors	non-returnable items
Engineered special products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

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

Returns will not be accepted after 60 days from original invoice date.

The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components to inventory.

If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Technical Sales, Catalog Sales and Service Teams will gladly help with your questions on Dorner products.

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

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



Dorner Mfg. Corp. reserves the right to change or discontinue products without notice. All products and services are covered in accordance with our standard warranty. All rights reserved. © Dorner Mfg. Corp. 2006

DORNER MFG. CORP.

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

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