



3200 & 5200 Series Bottom Mount Parallel Drive Package for Standard Load 60 Hz Gearmotors

Installation, Maintenance & Parts Manual



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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 3200 Series conveyors are covered by patent numbers 5,156,260, 5,156,261, 5,203,447, 5,265,714, 6,871,737, 6,910,571, 6,971,509, 6,398,981 and patent applications in other countries.

Dorner LPZ Series conveyors are covered by patent numbers 5,156,260, 5,156,261, 5,203,447, 5,265,714, 5,875,883 and patent applications in other countries.

Dorner 5200 Series conveyors are covered by patent numbers 7,735,638, 7,874,419, and patent applications in other countries.

Dorner's Limited Warranty applies.

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



Exposed moving parts can cause severe injury.
REPLACE ALL GUARDS BEFORE RUNNING CONVEYOR.

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.

1	Conveyor
2	Cover
3	Timing Belt
4	Timing Belt Tensioner
5	Drive Pulley
6	Gearmotor
7	Mounting Bracket
8	Driven Pulley

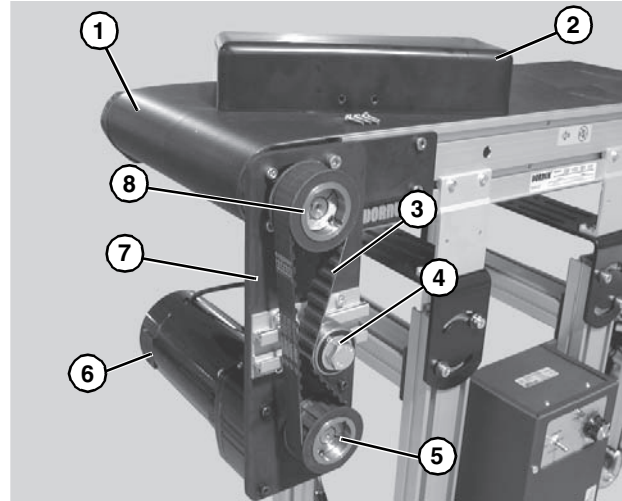


Figure 1

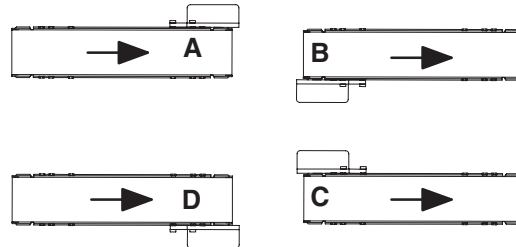
Specifications

Gearmotor Mounting Package Models:

Example:

32 M B P S A - 16 16

- Driven Pulley (see Table 2, 3 & 4)
- Drive Pulley (see Table 2, 3 & 4)
- Belt Type (- = flat belt, A through J = cleated belt)
- Mount Position = A, B, C or D (see detail to the right)
- Gearmotor Type: S = Standard Load
B = Brushless DC
- Output Shaft Type = Parallel Industrial
- Mount Style = Bottom Mount
- Language Code = U.S. English
- Product Series: 32 = 3200 Series
52 = 5200 Series



Specifications

Table 1: Gearmotor Specifications

	Single Phase	Three Phase	DC Variable Speed	VFD Variable Speed	Brushless DC
Power/ Gear Ratio	hp (kW)	hp (kW)	hp (kW)	hp (kW)	hp (kW)
5:1	0.08 (0.06)	0.17 (0.13)	0.12 (0.09)	0.17 (0.13)	-
10:1	0.17 (0.13)	0.17 (0.13)	0.25 (0.19)	0.17 (0.13)	0.25 (0.19)
20:1	0.33 (0.25)	0.38 (0.28)	0.25 (0.19)	0.38 (0.28)	0.25 (0.19)
30:1	0.33 (0.25)	0.38 (0.28)	0.25 (0.19)	0.38 (0.28)	-
50:1 (Brushless Only)	N/A	N/A	N/A	N/A	0.25 (0.19)
60:1	0.33 (0.25)	0.38 (0.28)	0.33 (0.25)	0.38 (0.28)	-
180:1	0.33 (0.25)	0.38 (0.28)	N/A	0.38 (0.28)	-
Input Voltage	115 VAC	230 VAC	130 VDC	230 VAC	*115/230 VAC
Input Frequency	60 Hz	60 Hz	N/A	10 to 60 Hz	60 Hz
Input Current/ Gear Ratio	FLA	FLA	FLA	FLA	N/A
5:1	1.2	1.0	1.0	1.0	N/A
10:1	1.9	1.0	1.8	1.0	N/A
20:1	4	1.9	1.8	1.9	N/A
30:1	4	1.9	1.8	1.9	N/A
60:1	4	1.9	2.3	1.9	N/A
180:1	4	1.9	N/A	1.9	N/A
Motor RPM	1725	1725	2500	1725	3000
Power/Ratio	Totally Enclosed	Fan Cooled	Totally Enclosed Non-Ventilated	Totally Enclosed Fan Cooled	Totally Enclosed Non-Ventilated

* Controller Inputs

Table 2: RPM/Torque for Fixed Speed Parallel Shaft 60 Hz Gearmotors

Standard Load Gearmotors			
Part Number	RPM	In-lb	N-m
62M180PS4vpFn	10	226	25.5
62M060PS4vpFn	29	237	26.8
32M030PS4vpFn	58	142	16.0
32M020PS4vpFn	86	78	8.8
32M010PS4vpFn	173	41	4.6
32M005PS4vpFn	345	41	4.6

(vp) = voltage and phase

11 = 115 V, 1-phase

23 = 208 – 230/460 V, 3-phase

Specifications

Table 3: RPM/Torque for Variable Speed Parallel Shaft VFD Gearmotors

Standard Load Gearmotors			
Part Number	RPM	In-lb	N-m
62M180PS423EN	1.7-10	226	25.5
62M060PS423EN	4.8-29	237	26.8
32M030PS423EN	9.7-58	142	16.0
32M020PS423EN	14.3-86	78	8.8
32M010PS423EN	29.9-173	41	4.6
32M005PS423EN	57.5-345	41	4.6

Table 4: RPM/Torque for Variable Speed Parallel Shaft DC Gearmotors

Standard Load Gearmotors			
Part Number	RPM	In-lb	N-m
62M180PSD3DEN	1.7-14	226	25.5
62M060PSD3DEN	5-42	237	26.8
62M030PSD3DEN	10-83	142	16.0
62M020PSD3DEN	15-125	78	8.8
62M010PSD3DEN	30-250	41	4.6

Table 5: RPM/Torque for Brushless DC Gearmotors

Gearmotors				
Part Number	Gear Ratio	RPM	In-lb	N-m
62M050PSBDDEN	50:1	2-60	240	28
62M020PSBDDEN	20:1	5-150	103	11.7
62M010PSBDDEN	10:1	10-300	52	5.9

NOTE

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

Table 6: Pulley Ratio / Timing Belt Number

Motor (Drive) Pulley Teeth	Conveyor (Driven) Pulley Teeth	Pulley Ratio	Timing Belt	
			Flat Belt	Cleated Belt
14	14	1.00	N/A	814-125
14	16	0.88	814-047	N/A
16	14	1.14	814-047	N/A
16	16	1.00	814-047	814-059
18	14	1.29	814-047	814-059
18	16	1.13	814-048	814-059
20	14	1.43	814-048	814-059
20	16	1.25	814-048	814-060
22	14	1.57	814-048	814-060
22	16	1.38	814-057	814-060
24	14	1.71	814-057	814-060
24	16	1.50	814-057	814-079

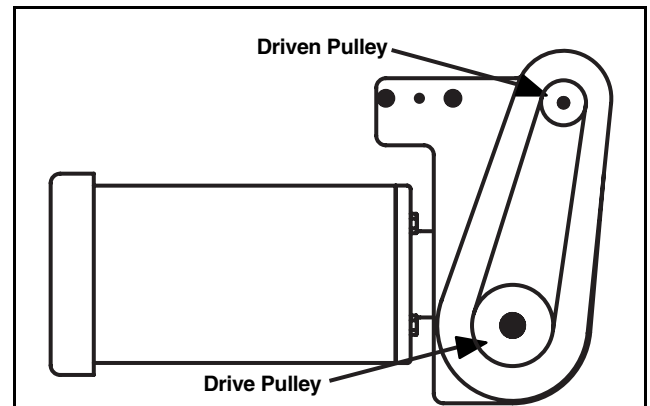


Figure 2

Table 7: Conveyor Belt Speed Factor

Series	Ft/revolution	M/revolution
3200	0.803	0.248
5200 / 5300	1.00	0.305

Belt Speed Calculation:

How to Calculate Belt Speed

1. Determine gearmotor RPM from tables 2-5.
2. Determine the pulley kit ratio. Count the number of teeth on the drive and driven pulleys following figure 2. Using table 6, look up pulley ratio based on pulley combinations.
3. Determine conveyor speed factor using table 7. Based on your conveyor type, select the appropriate factor.
4. Calculate belt speed:

Example: Belt Speed = Gearmotor RPM (tables 2-5) x Pulley Kit Ratio (table 6) x Conveyor Speed Factor (table 7)

3200 Series parallel shaft DC variable speed 20:1 gearmotor with 24 tooth sprocket on gearmotor (Drive) and 16 tooth sprocket on the conveyor output shaft (Driven).


Gearmotor =	62M020PSD3DEN	= 15 - 125 RPM
Pulley Kit =	24 t mtr. - 16 t conv.	= 1.50
Speed Factor =	3200 Series	= 0.803 ft/min per RPM
Minimum Belt Speed =	15 x 1.50 x 0.803	= 18 Ft/min
Maximum Belt Speed =	125 x 1.50 x 0.803	= 151 Ft/min

Installation

Required Tools

- Hex key wrenches:
2 mm, 2.5 mm, 3 mm, 5 mm
- Straight edge
- Torque wrench

Mounting

⚠ WARNING

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

Installation Component List:

1	Bottom Mount Drive Assembly
2	Tensioner
3	Driven Pulley
4	Timing Belt
5	M8 Socket Head Screws (2x)
6	M6 Socket Head Screws (4x)
7	Key
8	Drive Pulley
9	Cover Screws
10	Cover

1. Typical components (**Figure 3**).

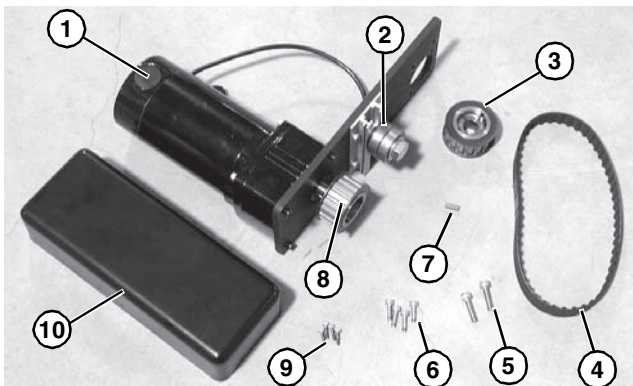


Figure 3

NOTE
<p><i>Cleated belt mounting package shown, flat belt mounting package similar.</i></p>

2. Locate drive output shaft (**Figure 4, item 1**). Remove two (2) M8 screws (**Figure 4, item 2**) and four (4) M6 screws (**Figure 4, item 3**) and discard.

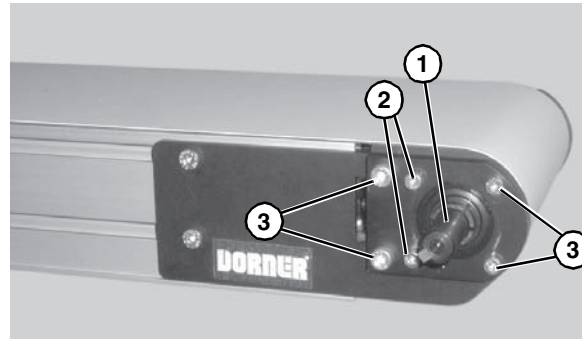


Figure 4

3. Attach bottom mount drive assembly (**Figure 5, item 1**) with two (2) M8 screws (**Figure 5, item 2**) and four (4) M6 screws (**Figure 5, item 3**). Tighten M6 screws to 146 in-lbs (16.5 N-m) and M8 screws to 288 in-lbs (32.5 N-m).

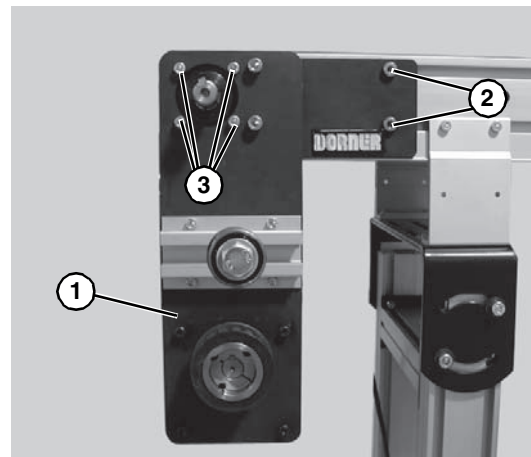


Figure 5

⚠ WARNING

<p>Drive shaft keyway may be sharp.</p> <p>HANDLE WITH CARE.</p>

Installation

4. Install key (Figure 6, item 1).

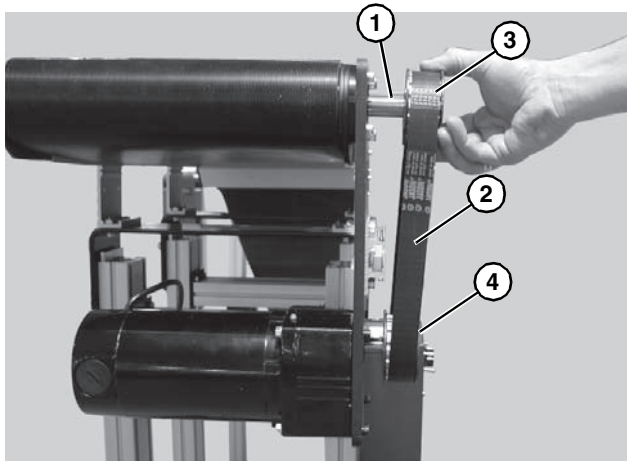


Figure 6

5. Wrap timing belt (Figure 6, item 2) around driven pulley (Figure 6, item 3) and drive pulley (Figure 6, item 4). Install driven pulley onto conveyor shaft.
6. Using a straight edge (Figure 7, item 1), align driven pulley (Figure 7, item 2) with drive pulley (Figure 7, item 3).

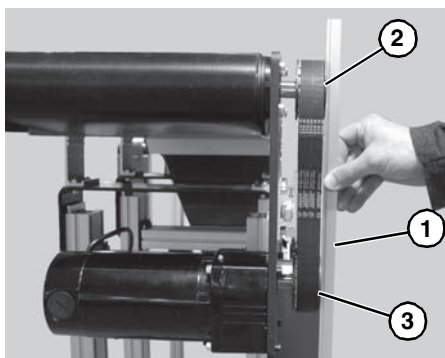


Figure 7

7. Tighten driven pulley taper-lock screws (Figure 8, item 1).

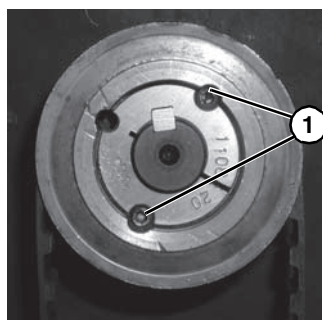


Figure 8

8. Depending on conveyor belt travel (direction A or B), locate timing belt tensioner (Figure 9, item 1) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection for 6 lb (3 Kg) of force at timing belt mid-point (Figure 9, item 2). Tighten tensioner screw to 110 in-lb (12 Nm).

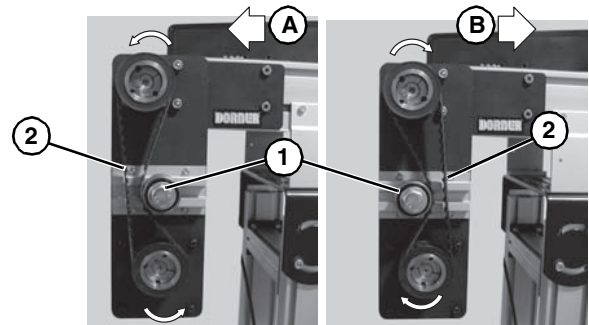


Figure 9

9. Install cover (Figure 10, item 1) with four (4) screws (Figure 10, item 2). Tighten screws to 35 in-lb (4 Nm).

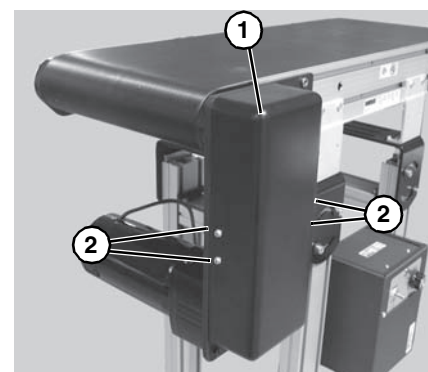



Figure 10

Preventive Maintenance and Adjustment

Required Tools

- Hex key wrenches:
2 mm, 2.5 mm, 3 mm, 5 mm
- Adjustable wrench (for hexagon head screws)
- Straight edge
- Torque wrench

Timing Belt Tensioning

⚠ WARNING

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

1. Remove four (4) screws (**Figure 10, item 2**) and remove cover (**Figure 10, item 1**).
2. Loosen tensioner (**Figure 11, item 1**).

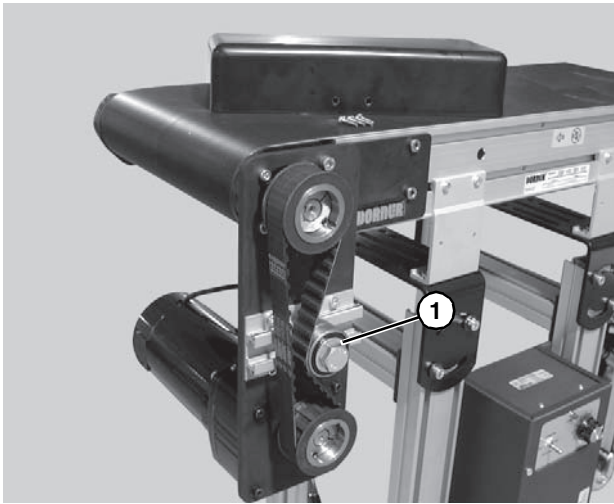



Figure 11

3. Depending on conveyor belt travel (direction A or B), locate timing belt tensioner (**Figure 9, item 1**) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection for 6 lb (3 Kg) of force at timing belt midpoint (**Figure 9, item 2**). Tighten tensioner screw to 110 in-lb (12 Nm).
4. Install cover (**Figure 10, item 1**) with four (4) screws (**Figure 10, item 2**). Tighten screws to 35 in-lb (4 Nm).

Timing Belt Replacement

⚠ WARNING

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

1. Remove four (4) screws (**Figure 10, item 2**) and remove cover (**Figure 10, item 1**).
2. Loosen tensioner (**Figure 11, item 1**).
3. Remove timing belt (**Figure 12, item 1**).

NOTE
<i>If timing belt does not slide over pulley flange, loosen driven pulley taper-lock screws (Figure 8, item 1) & (Figure 12, item 2) and remove pulley with belt (Figure 12, item 1). For re-installation, see steps 5 thru 7 on page 9.</i>

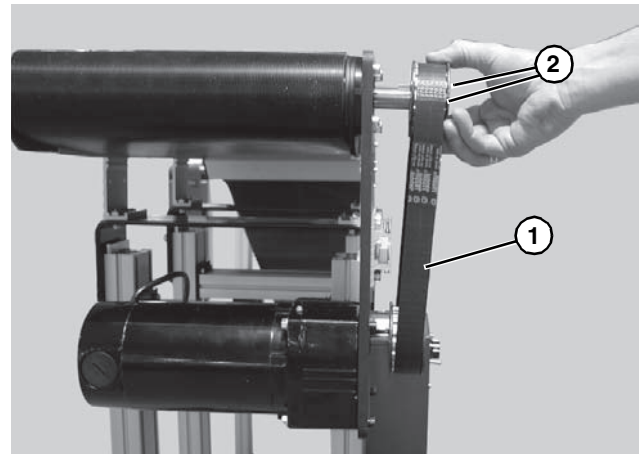



Figure 12

4. Install new timing belt.
5. Depending on conveyor belt travel (direction A or B), locate timing belt tensioner (**Figure 9, item 1**) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection for 6 lb (3 Kg) of force at timing belt midpoint (**Figure 9, item 2**). Tighten tensioner screw to 110 in-lb (12 Nm).
6. Install cover (**Figure 10, item 1**) with four (4) screws (**Figure 10, item 2**). Tighten screws to 35 in-lb (4 Nm).

Preventive Maintenance and Adjustment

Drive or Driven Pulley Replacement

⚠ WARNING

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

1. Complete steps 1 through 3 of “Timing Belt Replacement” section on page 10.
2. Remove taper-lock screws (**Figure 13, item 1**). Insert one (1) of taper lock screws in remaining hole (**Figure 13, item 2**). Tighten screw until pulley is loose. Remove pulley and taper hub assembly.

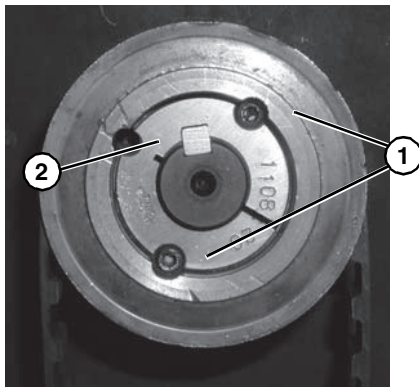




Figure 13

NOTE
<p><i>If drive pulley (Figure 6, item 4) is replaced, wrap timing belt around drive pulley and complete step 3.</i></p>

3. Complete steps 5 through 9 of “Installation” section beginning on page 9.

Motor Replacement

⚠ WARNING

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

⚠ DANGER

<p>Hazardous voltage will cause severe injury or death.</p> <p>LOCK OUT POWER BEFORE WIRING.</p>

Single Phase Motor

1. For single phase motor, unplug power cord from outlet.

Three Phase and VFD Motor

1. Loosen terminal box screws (**Figure 14, item 1**) and remove cover (**Figure 14, item 2**).

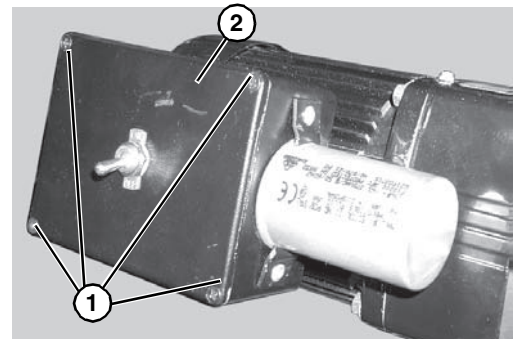


Figure 14

2. Record incoming wire colors on red, black and blue leads. Loosen wire nuts and remove incoming wires.
3. Loosen cord grip and remove cord.

DC Variable Speed Motor

1. For DC variable speed motor, unplug motor cord at disconnect (**Figure 15, item 1**).

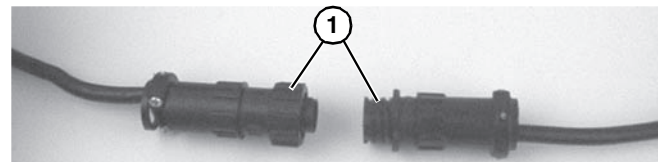


Figure 15

Preventive Maintenance and Adjustment

Brushless Motor

1. Twist covers (**Figure 16, item 1**) apart.

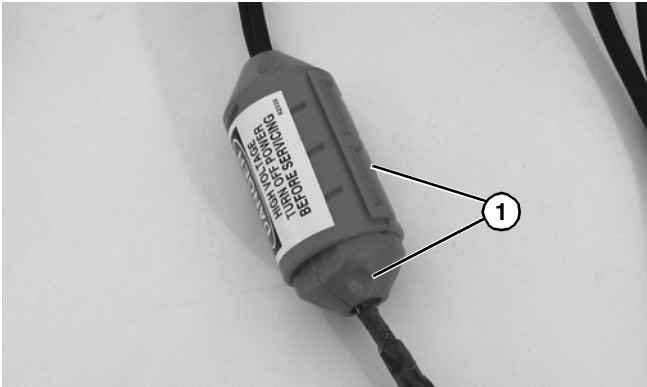


Figure 16

2. Remove outer cord cover (**Figure 17, item 1**) from inner cord cover (**Figure 17, item 2**).

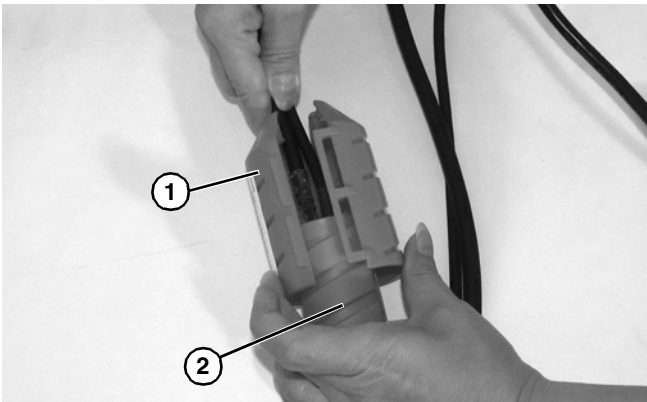


Figure 17

3. Open inner cord cover (**Figure 18, item 1**).

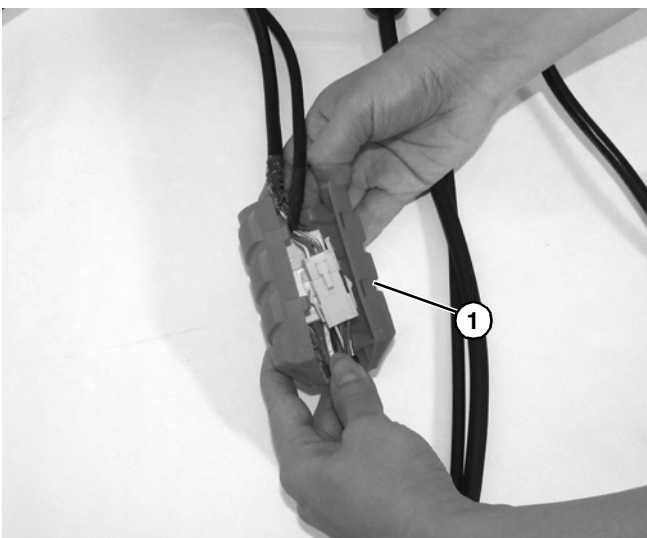


Figure 18

4. Unplug motor cord connectors (**Figure 19, item 1**) and signal cable connectors (**Figure 19, item 2**).

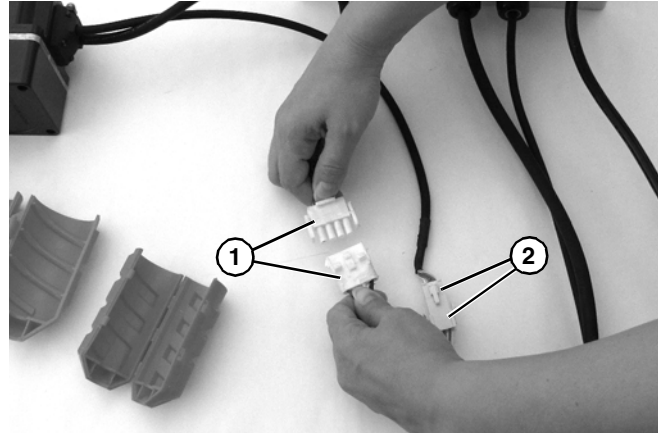


Figure 19

All Models

1. Remove the drive pulley see steps 1 and 2 of “Drive or Driven Pulley Replacement” section on page 11.
2. Remove four (4) screws (**Figure 20, item 1**). Detach motor (**Figure 20, item 2**) from the mounting plate (**Figure 20, item 3**). Retain motor output shaft key (**Figure 20, item 4**).

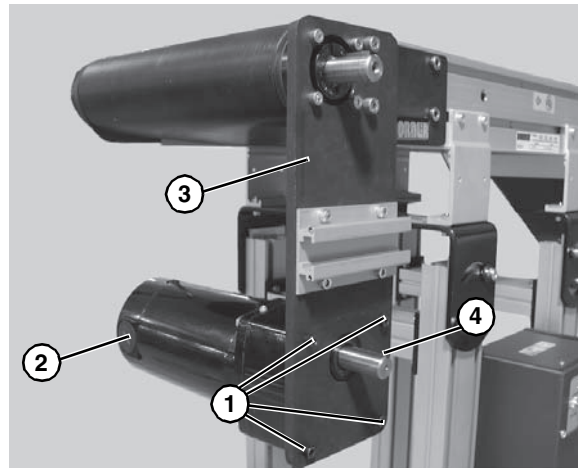



Figure 20

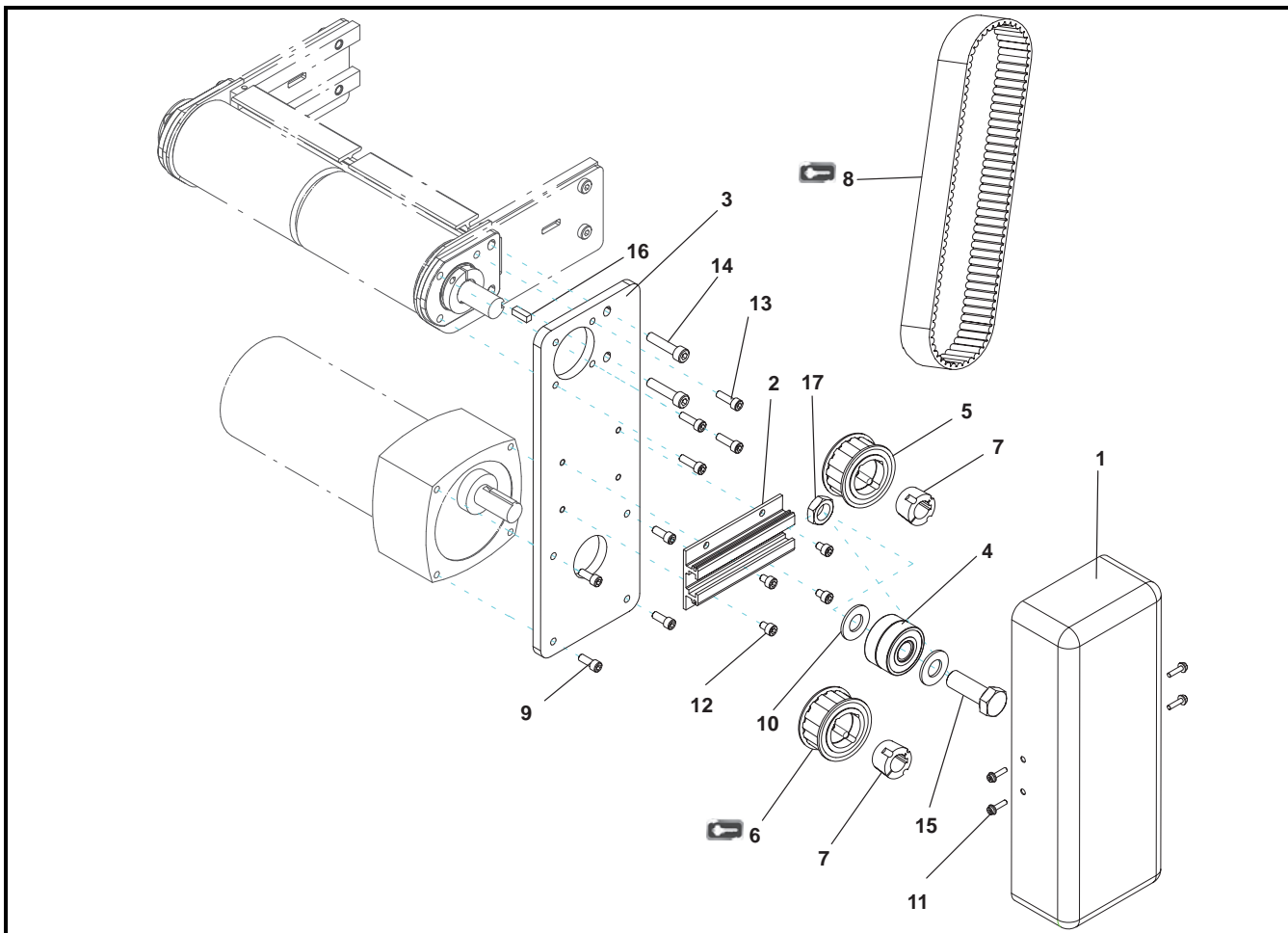
3. Install new motor using the four (4) mounting screws (**Figure 20, item 1**).
4. Re-install the drive pulley reverse step 2 of “Drive or Driven Pulley Replacement” section on page 11.
5. Complete steps 5 through 9 of “Installation” section beginning on page 9.
6. Replace wiring:
 - For a single phase motor, reverse step 1 in “Single Phase Motor” on page 11.
 - For a three phase motor, reverse steps 1-3, in “Three Phase and VFD Motor” on page 11.
 - For a DC variable speed motor, reverse step 1 on “DC Variable Speed Motor” on page 11.
 - For a brushless motor, reverse steps 1-2 on “Brushless Motor” on page 12.

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.


Bottom Mount Parallel Drive Package for Industrial Gearmotors



Item	Part Number	Description
1	300871	Drive Cover
	300349	Drive Cover (Flat Belt)
2	301076	Drive Tensioner Slide
3	301152	Mounting Plate
	301154	Mounting Plate (Flat Belt)
4	301153	Tensioner Bearing Assembly
5	811-133	Driven Pulley, 14 Tooth, Taper Lock TL1108
	811-126	Driven Pulley, 16 Tooth, Taper Lock TL1108

Item	Part Number	Description
6	811-133	Drive Pulley, 14 Tooth, Taper Lock TL1108
	811-126	Drive Pulley, 16 Tooth, Taper Lock TL1108
	811-127	Drive Pulley, 18 Tooth, Taper Lock TL1210
	811-135	Drive Pulley, 20 Tooth, Taper Lock TL1210
	811-136	Drive Pulley, 22 Tooth, Taper Lock TL1610
	811-137	Drive Pulley, 24 Tooth, Taper Lock TL1610
7	811-288	Taper Lock Bushing, 20 MM, TL1108
	811-162	Taper Lock Bushing, 0.75", TL1108
	811-074	Taper Lock Bushing, 0.75", TL1210
	811-167	Taper Lock Bushing, 0.75", TL1610

Service Parts

Item	Part Number	Description
8 	814-047	Timing Belt, 1.0" W x 21.0" L
	814-048	Timing Belt, 1.0" W x 22.0" L
	814-057	Timing Belt, 1.0" W x 23.0" L
	814-125	Timing Belt, 1.0" W x 25.5" L
	814-059	Timing Belt, 1.0" W x 27.0" L
	814-060	Timing Belt, 1.0" W x 28.0" L
	814-079	Timing Belt, 1.0" W x 30.0" L
9	902-157	Cap Head Screw, 1/4-28 x 0.75"

Item	Part Number	Description
10	911-013	Flat Washer
11	920483M	Flange Socket Head Screw, M4 x 16 mm
12	920608M	Socket Head Screw, M6 x 8 mm
13	920622M	Socket Head Screw, M6 x 22 mm
14	920835M	Socket Head Screw, M8 x 35 mm
15	961645M	Socket Head Screw, M16 x 45 mm
16	980630M	Square Key
17	991610M	Hex Jam Nut, M16

Pulley Ratio / Timing Belt Combinations

Motor (Drive) Pulley Teeth	Conveyor (Driven) Pulley Teeth	Pulley Ratio	Timing Belt	
			Flat Belt	Cleated Belt
14	14	1.00	N/A	814-125
14	16	0.88	814-047	N/A
16	14	1.14	814-047	N/A
16	16	1.00	814-047	814-059
18	14	1.29	814-047	814-059
18	16	1.13	814-048	814-059
20	14	1.43	814-048	814-059
20	16	1.25	814-048	814-060
22	14	1.57	814-048	814-060
22	16	1.38	814-057	814-060
24	14	1.71	814-057	814-060
24	16	1.50	814-057	814-079

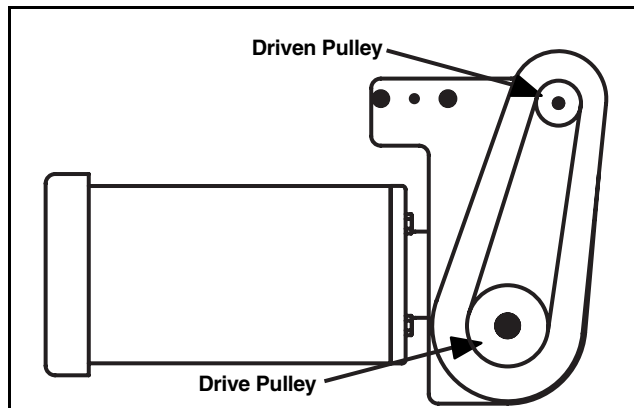
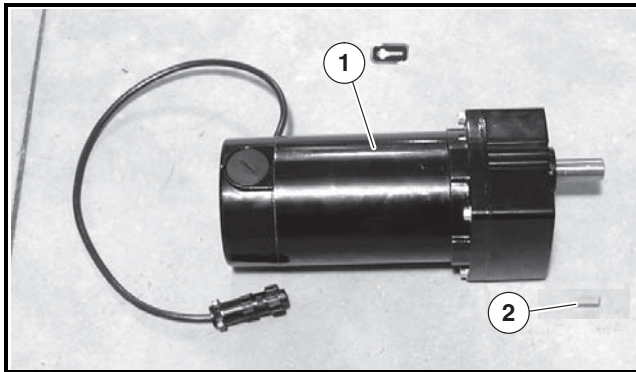



Figure 21

Service Parts

Parallel Shaft Industrial Gearmotors



Item	Part Number	Description
1 	62M180PS411FN	Motor, 0.08hp (0.06Kw), 115 Volts, 60 Hz, 1-Phase
	62M180PS411FR	Motor, 0.08hp (0.06Kw), 115 Volts, 60 Hz, 1-Phase with Reversing
	62M180PS423FN	Motor, 0.17hp (0.13Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	62M060PS411FN	Motor, 0.17hp (0.13Kw), 115 Volts, 60 Hz, 1-Phase
	62M060PS411FR	Motor, 0.17hp (0.13Kw), 115 Volts, 60 Hz, 1-Phase with Reversing
	62M060PS423FN	Motor, 0.17hp (0.13Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	32M030PS411FN	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase
	32M030PS411FR	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase with Reversing
	62M030PS423FN	Motor, 0.38hp (0.28Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	32M020PS411FN	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase
	32M020PS411FR	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase with Reversing
	62M020PS423FN	Motor, 0.38hp (0.28Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	32M010PS411FN	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase
	32M010PS411FR	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase with Reversing
	62M010PS423FN	Motor, 0.38hp (0.28Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	32M005PS411FN	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase
	32M005PS411FR	Motor, 0.33hp (0.25Kw), 115 Volts, 60 Hz, 1-Phase with Reversing
	62M005PS423FN	Motor, 0.38hp (0.28Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	62M180PSD3DEN	Motor, 0.12 hp (0.09 Kw), 130 Volts DC

Item	Part Number	Description	
	62M060PSD3DEN	Motor, 0.25 hp (0.19 Kw), 130 Volts DC	
	62M030PSD3DEN	Motor, 0.25 hp (0.19 Kw), 130 Volts DC	
	62M020PSD3DEN	Motor, 0.25 hp (0.19 Kw), 130 Volts DC	
	62M010PSD3DEN	Motor, 0.33 hp (0.25 Kw), 130 Volts DC	
	62M180PS423EN	Motor, 0.17 hp (0.13 Kw), 230 Volts, 60 Hz, 3–Phase VFD	
	62M060PS423EN	Motor, 0.17 hp (0.13 Kw), 230 Volts, 60 Hz, 3–Phase VFD	
	62M030PS423EN	Motor, 0.38 hp (0.28 Kw), 230 Volts, 60 Hz, 3–Phase VFD	
	62M020PS423EN	Motor, 0.38 hp (0.28 Kw), 230 Volts, 60 Hz, 3–Phase VFD	
	62M010PS423EN	Motor, 0.38 hp (0.28 Kw), 230 Volts, 60 Hz, 3–Phase VFD	
	62M005PS423EN	Motor, 0.38 hp (0.28Kw), 230 Volts, 60 Hz, 3-Phase VFD	
	62M050PSBDDEN	Motor, 0.25hp (0.19Kw), 60 RPM, Brushless DC	
	62M020PSBDDEN	Motor, 0.25hp (0.19Kw), 150 RPM, Brushless DC	
	62M010PSBDDEN	Motor, 0.25hp (0.19Kw), 300 RPM, Brushless DC	
	2	917–078	Key, Square, 0.188" x 0.75" L

3200 & 5200 Series Bottom Mount Parallel Drive Package for Standard Load 60 Hz Gearmotors

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.



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. 2012

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