Installation, Maintenance & Parts Manual

2200 Series End Drive Conveyors

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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.

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 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981, 6,422,382 and corresponding patents and patent applications in other countries.

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

Product Description

Refer to Figure 1 for typical conveyor components.

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

Figure 1

Specifications

Models:

Flat Belt 2200 Series Conveyor

2 1 0 M WW LLLL A PP BB

- **BB** — Belt Type*
- **PP** — Conveyor Profile*
- **A** — Output Shaft Position*
- **LLLL** — Conveyor Length Reference
- **WW** — Conveyor Width Reference
- **M** — Document Language, M = English
- **0** — Pulley Type:
  - 0 = Standard 1.25” (32mm) Dia.
  - 1 = Gang Drive 1” (25mm) Dia.
- **2** —
  - 1 = with belt tracking cams and mounting brackets
  - 2 = with V-guide tracking and mounting brackets
  - 3 = with nosebar transfer tail and mounting brackets
  - 4 = with V–guide tracking and no mounting brackets
  - 5 = with belt tracking cams and no mounting brackets
  - 6 = with nosebar transfer tail and no mounting brackets

Cleated Belt 2200 Series Conveyor

2 4 C M WW LLLL A SSSS

- **SSSS** — Cleat Spacing*
- **A** — Output Shaft Position*
- **LLLL** — Conveyor Length Reference
- **WW** — Conveyor Width Reference
- **M** — Document Language, M = English
- **C** — Cleat Type*
- **4** —
  - 0 = with V-guide tracking and no mounting brackets
  - 4 = with V-guide tracking and mounting brackets
  - 5 = with belt tracking cams and mounting brackets
  - 9 = with belt tracking cams and no mounting brackets

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

Conveyor Supports:

Maximum Distances:

K = 18" (457 mm)**

L = 6 ft (1829 mm)***

M = 18" (457 mm)

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

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

Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18	21	24
Conveyor Belt Width	1.75" (44mm)	2.75" (70mm)	3.75" (95mm)	5" (127mm)	6" (152mm)	8" (203mm)	10" (254mm)	12" (305mm)	18" (457mm)	21" (533mm)	24" (609mm)
Maximum Conveyor Load* (See NOTE Below)	30 lb (14kg)	35 lb (16kg)	42 lb (19kg)	50 lb (23kg)	60 lb (27kg)	70 lb (32kg)	80 lb (36kg)	80 lb (36kg)	80 lb (36kg)	80 lb (36kg)	80 lb (36kg)
Conveyor Startup Torque*	2 in-lb (0.5Nm)	3 in-lb (0.6Nm)	4 in-lb (0.7Nm)	6 in-lb (0.8Nm)	8 in-lb (0.9Nm)	10 in-lb (1.1Nm)	12 in-lb (1.4Nm)	14 in-lb (1.5Nm)	15 in-lb (1.7Nm)	18 in-lb (2.0Nm)	20 in-lb (2.3Nm)
Belt Travel	4.0" (88 mm) per revolution of pulley										
Maximum Belt Speed*	264 ft/minute (80.5 m/minute)										
Belt Takeup	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 Up to 18 ft in any length to nearest 0.12" (3mm)	2-ft (610 mm)	3-ft (914 mm)	4-ft (1219 mm)	5-ft (1524 mm)	6-ft (1829 mm)	7-ft (2134 mm)	8-ft (2438 mm)	9-ft (2743 mm)	10-ft (3048 mm)	11-ft (3353 mm)	12-ft (3658 mm)	13-ft (3962 mm)**	14-ft (4267 mm)**	15-ft (4572 mm)**	16-ft (4877 mm)**	17-ft (5182 mm)**	18-ft (5486 mm)**

NOTE: Maximum conveyor loads based on:

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

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

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

Installation

NOTE: Conveyor MUST be mounted straight, flat and level within confines of conveyor. Use a level (N of Figure 3) for setup.

Figure 3

Installation Component List

O	Conveyor frame (two sections if longer than 12ft)
P	Conveyor brackets (4x)
Q	Return rollers (for longer conveyors)

Required Tools

- Hex-key wrenches:
  4 mm, 5 mm
- Level
- Torque wrench

Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor (if required)
- Attach mounting brackets to conveyor
- Attach conveyor to stands
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 29 through 37 of "Service Parts" section for details)

Conveyors Up to 12 ft (3658 mm)

No assembly is required. Install mounting brackets and return rollers. Refer to "Mounting Brackets" on page 6 and "Return Rollers" on page 7.

Conveyors Longer Than 12ft (3658 mm)

1. Locate conveyor sections (O Figure 4)

Figure 4

2. On tension end of the conveyor, identified with a label (R of Figure 5), push in head plate assembly (S): On both sides of conveyor, loosen and move cam tracking assemblies (T) (if equipped) away from head plates, then loosen fastening screws (U) and push head plate assembly inward.

Figure 5

3. Roll out conveyor belt and place conveyor frame sections (O of Figure 6) into belt loop.

Figure 6

4. Join conveyor sections and install frame connector plates (V of Figure 7) or connector/mount brackets (VA) and screws (W) on both sides as indicated. Tighten screws to 60 in-lb (7 Nm).

Figure 7

5. With a 5 mm hex-key wrench, rotate pinion gear (X of Figure 8) to tension the conveyor belt. Tighten fastening screws (U) on both sides of conveyor to 80 in-lb (9 Nm). For proper tensioning, refer to "Conveyor Belt Tensioning" on page 11.

Figure 8

6. Install mounting brackets and return rollers. Refer to "Mounting Brackets" on page 6 and "Return Roller" on page 7.
7. If equipped with cam tracking assemblies (T of Figure 5), reposition and adjust belt tracking. Refer to "Conveyor Belt Tracking" on page 12.

Mounting Brackets

1. Locate brackets. Exploded views shown in Figures 9 & 10.

Mounting Brackets for Flat Belt Conveyor

Figure 9

Mounting Brackets for Cleated Belt Conveyor

Figure 10

2. Remove screws (Y & Z of Figures 9 & 10), washers (AA), nuts (AB) and T-bars (AC) from brackets.
3. Insert T-bars (AC of Figures 9 & 10) into conveyor side slots (AD of Figure 11). Fasten brackets (P of Figure 11) to conveyor with mounting screws (Y).

Figure 11

NOTE: Mounting brackets for flat belt conveyors shown.

4. Fasten brackets to support stand with mounting screws (Z of Figure 11), washers (AA) and nuts (AB).
5. Tighten screws (Y & Z of Figure 11) to 60 in-lb (7 Nm).

Return Rollers

Cleated Belt and 2–6" (51–152 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded views shown in Figures 12 & 13.

Return Rollers for Flat Belt Conveyor

Figure 12

Return Rollers for Cleated Belt Conveyor

Figure 13

2. Remove screws (AE of Figures 12 & 13) and clips (AF) from roller assembly.
3. Install roller assemblies (Q of Figure 14) as shown. Tighten screws (AE) to 60 in-lb (7 Nm).

Figure 14

8–24" (203–610 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded view shown in Figure 15.

Figure 15

2. Remove screws (AG of Figure 15) and clips (AH) from roller assembly.
3. Install roller assembly as shown (Q of Figure 16). Tighten screws (AG) to 60 in-lb (7 Nm).

Figure 16

Preventive Maintenance and Adjustment

Required Tools

Standard Tools

- Hex-key wrenches:
  2.5 mm, 4 mm, 5 mm
- Arbor press

Special Tools

- 807−1078 Bearing Puller Tool (or equivalent)
- 450292 Bearing Installation Tool
- 456070 Bearing Removal 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

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 wipers (if installed)
- Accumulated dirt in wipers (if installed)
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:

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

Damage to V-guide indicates:

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

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

Cleaning

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.

Conveyor Belt Replacement Sequence

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

Belt Removal for Conveyor Without Stands or Gearmotor Mounting Package

1. If equipped, remove bottom wipers (AJ of Figure 17): Remove fastening screws (AI) then remove wiper (AJ).

Figure 17

2. If equipped, remove return rollers and guiding and accessories from one side of conveyor.
3. On tension end of the conveyor, identified with a label (R of Figure 18), push in head plate assembly (S): On both sides of conveyor, loosen and move cam tracking assemblies (T) (if equipped) away from head plates, then loosen fastening screws (U) and push head plate assembly inward.

Figure 18

4. Remove conveyor belt.

Belt Removal for Conveyor With Stands and Gearmotor Mounting Package

WARNING

Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT

1. Place temporary support stands (AK of Figure 19) at both ends of the conveyor. Place an additional support stand under the drive motor (AL), if equipped. See **WARNING**.

Figure 19

2. Remove mounting brackets (AM of Figure 19) from one side of conveyor. (Reverse steps 3 & 4 of "Mounting Brackets" section on page 6.) If equipped with heavy load drive package, remove brackets from side opposite drive cover (AN of Figure 20).
3. If equipped, remove bottom wipers (AJ of Figure 17): Remove fastening screws (AI) then remove wiper (AJ).
4. If equipped, remove return rollers, guiding and accessories from side opposite drive cover (AN of Figure 20).

Figure 20

5. If equipped with heavy load drive package, remove drive support bracket (AP of Figure 20): Remove bracket screws (AO) then remove bracket (AP).

6. On tension end of the conveyor, identified with a label (R of Figure 21), push in head plate assembly (S): On both sides of conveyor, loosen and move cam tracking assemblies (T) (if equipped) away from head plates, then loosen fastening screws (U) and push head plate assembly inward.

Figure 21

7. Remove belt (AQ of Figure 22) from conveyor.

Figure 22

Belt Installation for Conveyor without Stands or Gearmotor Mounting Package

1. Orient belt so splice leading fingers (AR of Figure 23) point in the direction of belt travel as identified by the conveyor directional label (AS).

Figure 23

2. Slide belt onto the conveyor frame assembly.
3. Tension belt. Refer to "Conveyor Belt Tensioning" on page 11.
4. If equipped, install wipers, return rollers and guiding.

Belt Installation for Conveyor with Stands and Gearmotor Mounting Package

1. Ensure temporary support stands (AK of Figure 19) are placed at both ends of the conveyor. Place an additional support stand under the drive motor (AL), if equipped. See WARNING.
2. Orient belt so splice leading fingers (AR of Figure 23) point in the direction of belt travel as identified by the conveyor directional label (AS).
3. Install belt (AQ of Figure 24) on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.

Figure 24

4. Re-install conveyor mounting brackets. Refer "Mounting Brackets" on page 6, steps 3 through 5.
5. If equipped with a heavy load drive package, re-install drive support bracket (AP of Figure 20).
6. Tension belt. Refer to "Conveyor Belt Tensioning" on page 11.
7. If equipped, re-install wipers, return rollers and guiding.

Conveyor Belt Tensioning

WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Conveyors with 1.25" (32 mm) Diameter Pulleys

1. On tension end of the conveyor, identified with a label (R of Figure 25), adjust head plate assembly (S): On both sides of conveyor, loosen fastening screws (U) and rotate pinion gear (X) to adjust head plate assembly.

Figure 25

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks (AT & AU of Figure 26). Replace belt if proper tensioning can not be obtained while aligning the end of the conveyor frame with or between the tensioning marks. See **NOTE**.

Figure 26

NOTE: On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12" (44 – 305mm) wide conveyors and 50 in-lb (4.5 Nm) for an 18 – 24" (457 – 610mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten fastening screws (U of Figure 25) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (T of Figure 25), position against head plates and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 12.

Conveyors with Nose Bar Idlers

1. On tension end of the conveyor, identified with a label (R of Figure 27), adjust head plate assembly (S): On both sides of conveyor, loosen fastening screws (U) and rotate pinion gear (X) to adjust head plate assembly.

Figure 27

2. Adjust head plate assembly so the edge of the axle support plate (AV of Figure 28) is separated from the end of the conveyor (AW) by 1.125¨ (29 mm). Replace belt if proper tensioning can not be obtained within a distance of 1.50¨ (38 mm). See **NOTE**.

Figure 28

NOTE: On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12¨ (44 – 305mm) wide conveyors or 50 in-lb (4.5 Nm) for an 18 – 24¨ (457 – 610mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten fastening screws (U of Figure 27) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (T of Figure 27) position against head plates and adjust belt tracking. Refer to “Conveyor Belt Tracking”, next section.

Conveyor Belt Tracking

V-Guided Belts

V-guided belts do not require tracking adjustment.

Non V-Guided Belts

Non V-guided belt conveyors are equipped with belt tracking cam assemblies (T of Figure 29) for belt tracking adjustment.

Figure 29

When adjusting belt tracking, always adjust the discharge end of the conveyor first. To adjust belt tracking:

1. Ensure head plate fastening screws (U of Figure 29) on both sides of conveyor are tightened.
2. On both sides of conveyor, loosen two (2) cam fastening screws (AX). Adjust cams (AY) until indicator slots (AZ) are horizontal and facing end of conveyor. Then slide cam assemblies against head plates (S) and re-tighten cam fastening screws (AX) to 60 in-lb (7 Nm).
3. On the side toward which the belt is tracking, loosen head plate fastening screws (U).
4. With the conveyor running, use a 5 mm hex-key wrench to rotate the tracking cam (AY) in small increments until the belt tracks in the center of the conveyor. Then while holding the cam in position, re-tighten the head plate fastening screws (U) with a 4 mm hex-key wrench to 60 in-lb (7 Nm).

Pulley Removal

WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Leaving the conveyor belt in place, remove the desired pulley following the corresponding instructions below:

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

A – Idler Pulley Removal

1. On one side of the conveyor, loosen two (2) head plate fastening screws (U of Figure 30) and remove them.

NOTE: To prevent damage to the head plates and pulley, be sure to remove them slowly because they are not attached to pulley.

Figure 30

2. Remove the head plate (BA of Figure 31) from the conveyor frame.

Figure 31

3. Pulley will slide out of opposite head plate and drop into slack of belt (Figure 32).

Figure 32

4. Slide spindle out of the belt loop.

B – Drive Pulley Removal

WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

1. On one side of the conveyor, loosen two (2) head plate fastening screws (U of Figure 33) and remove.

NOTE: To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.

Figure 33

2. Remove the head plate (BA of Figure 34) from the conveyor frame.

Figure 34

3. Drive pulley will slide out of opposite head and drop into slack of belt.
4. Slide the drive pulley out of the belt loop.

Bearing Removal & Replacement

Removal

IMPORTANT: Do not use any removed bearings. Replace them.

1. Use a bearing removal tool, (BD of Figure 35, 36), part number 807–1078, or equivalent and remove both bearings from the pulley and the drive pulley.

Figure 35 – Conveyor Pulley

Figure 36 – Drive Pulley

Replacement

1. Inspect the head plates bearing seating surface (BC of Figure 37). If they are worn or damaged, replace the head. See ”Service Parts” on Page 20.

Figure 37

NOTE: Two washers may be required when installing the bearing over the drive shaft on the drive pulley, if the bearing installation tool is not long enough to fit the length of the drive shaft.

2. Use a bearing installation tool, (BE of Figure 38), part number 450292 or equivalent and press bearings onto the pulley and drive pulley.

Figure 38

Drive Pulley and Pulley Installation

Drive Pulley Installation

1. With opposite head plate installed, position the drive pulley through the loop of the belt, into the opposite head plate.

Figure 39

2. Place the head plate (BA of Figure 39) and attach the head plate to the conveyor frame with the two (2) screws removed. Tighten screws 60 in-lb (7Nm).

Idler Pulley Installation

1. With opposite head plate installed, position the idler pulley through the loop of the belt, into the opposite head plate.

Figure 40

2. Place the head plate (BA of Figure 40) and attach the head plate to the conveyor frame with the two (2) screws removed and hand tighten.

Nose Bar Bearing Replacement

1. On both sides of conveyor, use a 4 mm hex-key wrench to loosen cam fastening screws (BI of Figure 41) and slide cam assemblies toward the center of the conveyor.

Figure 41

2. On both sides of conveyor, use a 4 mm hex-key wrench to loosen head plate fastening screws (U) to remove belt tension. Then remove belt from end of conveyor.
3. On one side of conveyor, use a 3 mm and 4 mm hex-key wrench to remove head plate fastening screws (BJ & U) and remove head plate (S).
4. Slide bearing rods (BL of Figure 42) out side of conveyor and replace bearings (BK) as necessary.

Figure 42

5. After replacing bearings, re-install head plate (S of Figure 41). Use a 3 mm hex-key wrench to tighten one (1) fastening screw (BL) to 30 in-lb (3.4 Nm). Leave two (2) fastening screws (U) loose for belt tensioning.
6. Re-install belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 11.
7. Re-position the cam assemblies against the head plates and adjust belt tracking. See “Conveyor Belt Tracking” on page 12.

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.

2” (51mm) Wide Conveyor

Item	Part Number	Description
1	920692M	Socket Head Screw M6 x 12mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	240328	Bearing
6	247302	Idler Spindle 2” (51mm)
7	808–020	Magnet .25” Dia. x .25” long
8	450226SSP	Sleeve, .25” Magnet Stainless Steel
9	240426	Head Plate RH
10	920691M	Socket Head Screw M6 x 10mm
11	240329	Tension Slide Bar
12	240420	Rack Gear 14.5 Degree PA x 24 P
13	240423	Pinion 2” (51mm)
14	240422	Pinion Pin
15	456402	Drive Spindle 2” (51mm)
	247602	Nosebar Drive Spindle Lagged 2” (51mm)
16	980422M	Square Key 4mm x 22mm
17	See Frame Chart	2” (51mm) Frame
18	22A–02	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 15)
	22D–02	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 15)
19	22NA–02	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 15)
	22ND–02	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1,2, 4, 5, 9 and 15)
20	22T–02	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)

Item 17: 2” (51mm) Conveyor Frame	
Length	Part Number
2’ (610mm)	240402–01908
3’ (914mm)	240402–03108
4’ (1219mm)	240402–04308
5’ (1524mm)	240402–05508
6’ (1829mm)	240402–06708
7’ (2134mm)	240402–07908
8’ (2438mm)	240402–09108
9’ (2743mm)	240402–10308
10’ (3048mm)	240402–11508
11’ (3353mm)	240402–12708
12’ (3658mm)	240402–13908

Service Parts

3” (76mm) to 6” (152mm) Wide Conveyor

Item	Part Number	Description
1	920692M	Socket Head Screw M6 x 12mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	240328	Bearing
6	2473WW	Idler Spindle
7	808–020	Magnet .25” Dia. x .25” long
8	450226SSP	Sleeve, .25” Magnet Stainless Steel
9	240426	Head Plate RH
10	920691M	Socket Head Screw M6 x 10mm
11	240329	Tension Slide Bar
12	240420	Rack Gear 14.5 Degree PA x 24P
13	240421	Pinion Bushing
14	2030WWM	Pinion Gear
15	4564WW	Drive Spindle 2” (51mm)
	2476WW	Nosebar Drive Spindle Lagged 2” (51mm)
16	980422M	Square Key 4mm x 22mm
17	See Frame Chart	Conveyor Frame
18	See Bed Plate Chart	Conveyor Bed Plate
19	807–1105	Flat Head Torx Screw M6 x 10mm
20	22A–WW	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1,2, 3, 5, 9 and 15)
	22D–WW	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 15)
21	22NA–WW	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 15)
	22ND–WW	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 15)
22	22T–WW	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)
WW = Conveyor width reference: 03, 04, 05, 06		

Item 17: Conveyor Frame		
Length	Part Number	
2’ (610mm)	2404WW–01908	
3’ (914mm)	2404WW–03108	
4’ (1219mm)	2404WW–04308	
5’ (1524mm)	2404WW–05508	
6’ (1829mm)	2404WW–06708	
7’ (2134mm)	2404WW–07908	
8’ (2438mm)	2404WW–09108	
9’ (2743mm)	2404WW–10308	
10’ (3048mm)	2404WW–11508	
11’ (3353mm)	2404WW–12708	
12’ (3658mm)	2404WW–13908	
13’ (3962mm)	2404WW–07200	2404WW–07908*
14’ (4267mm)	2404WW–07200	2404WW–09108*
15’ (4572mm)	2404WW–07200	2404WW–10308*
16’ (4877mm)	2404WW–07200	2404WW–11508*
17’ (5182mm)	2404WW–07200	2404WW–12708*
18’ (5486mm)	2404WW–07200	2404WW–13908*
WW = Conveyor width reference: 03, 04, 05, 06 * = 6” (152mm) and wider conveyors, only		

Item 18: Bed Plate		
Length	Part Number	
2’ (610mm)	2405WW–01900	
3’ (914mm)	2405WW–03100	
4’ (1219mm)	2405WW–04300	
5’ (1524mm)	2405WW–05500	
6’ (1829mm)	2405WW–06700	
7’ (2134mm)	2405WW–07900	
8’ (2438mm)	2405WW–09100	
9’ (2743mm)	2405WW–10300	
10’ (3048mm)	2405WW–11500	
11’ (3353mm)	2405WW–12700	
12’ (3658mm)	2405WW–13900	
13’ (3962mm)	2405WW–07196	2405WW–07900*
14’ (4267mm)	2405WW–07196	2405WW–09100*
15’ (4572mm)	2405WW–07196	2405WW–10300*
16’ (4877mm)	2405WW–07196	2405WW–11500*
17’ (5182mm)	2405WW–07196	2405WW–12700*
18’ (5486mm)	2405WW–07196	2405WW–13900*
WW = Conveyor Width reference: 03, 04, 05, 06 * = 6” (152mm) and wider conveyors, only		

8” (203mm) to 12” (305mm) Wide Conveyor

Item	Part Number	Description
1	920692M	Socket Head Screw M6 x 12mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	240328	Bearing
6	2473WW	Idler Spindle
7	808–020	Magnet .25” Dia. x .25” long
8	450226SSP	Sleeve, .25” Magnet Stainless Steel
9	240426	Head Plate RH

10	920691M	Socket Head Screw M6 x 10mm
11	240329	Tension Slide Bar
12	240420	Rack Gear 14.5 Degree PA x 24P
13	See Chart	Side Rail RH
14	See Chart	Center Rail
15	2030WWM	Pinion Gear
16	See Chart	Side Rail LH
17	4564WW	Drive Spindle 2” (51mm)
	2476WW	Nosebar Drive Spindle Lagged 2” (51mm)
18	980422M	Square Key 4mm x 22mm

19	See Chart	Conveyor Bed Plate
20	807–1105	Flat Head Torx Screw M6 x 10mm
21	22A–WW	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 17)
	22D–WW	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 17)
22	22NA–WW	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 17)
	22ND–WW	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 17)
23	22T–WW	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)
WW = Conveyor width reference: 08, 10, 12		

Item 13: Side Rail RH	
Length	Part Number
2’ (610mm)	240412–01908
3’ (914mm)	240412–03108
4’ (1219mm)	240412–04308
5’ (1524mm)	240412–05508
6’ (1829mm)	240412–06708
7’ (2134mm)	240412–07908
8’ (2438mm)	240412–09108
9’ (2743mm)	240412–10308
10’ (3048mm)	240412–11508
11’ (3353mm)	240412–12708
12’ (3658mm)	240412–13908
13’ (3962mm)	240412–07200 240412–07908
14’ (4267mm)	240412–07200 240412–09108
15’ (4572mm)	240412–07200 240412–10308
16’ (4877mm)	240412–07200 240412–11508
17’ (5182mm)	240412–07200 240412–12708
18’ (5486mm)	240412–07200 240412–13908

Item 14: Center Rail	
Length	Part Number
2’ (610mm)	240414–01273
3’ (914mm)	240414–02473
4’ (1219mm)	240414–03673
5’ (1524mm)	240414–04873
6’ (1829mm)	240414–06073
7’ (2134mm)	240414–07273
8’ (2438mm)	240414–08473
9’ (2743mm)	240414–09673
10’ (3048mm)	240414–10873
11’ (3353mm)	240414–12073
12’ (3658mm)	240414–13273
13’ (3962mm)	240414–07200 240414–07273
14’ (4267mm)	240414–07200 240414–08473
15’ (4572mm)	240414–07200 240414–09673
16’ (4877mm)	240414–07200 240414–10873
17’ (5182mm)	240414–07200 240414–12073
18’ (5486mm)	240414–07200 240414–13273

Item 16: Side Rail LH	
Length	Part Number
2’ (610mm)	240413–01908
3’ (914mm)	240413–03108
4’ (1219mm)	240413–04308
5’ (1524mm)	240413–05508
6’ (1829mm)	240413–06708
7’ (2134mm)	240413–07908
8’ (2438mm)	240413–09108
9’ (2743mm)	240413–10308
10’ (3048mm)	240413–11508
11’ (3353mm)	240413–12708
12’ (3658mm)	240413–13908
13’ (3962mm)	240413–07200 240413–07908
14’ (4267mm)	240413–07200 240413–09108
15’ (4572mm)	240413–07200 240413–10308
16’ (4877mm)	240413–07200 240413–11508
17’ (5182mm)	240413–07200 240413–12708
18’ (5486mm)	240413–07200 240413–13908

Item 17: Bed Plate	
Length	Part Number
2’ (610mm)	2405WW–01900
3’ (914mm)	2405WW–03100
4’ (1219mm)	2405WW–04300
5’ (1524mm)	2405WW–05500
6’ (1829mm)	2405WW–06700
7’ (2134mm)	2405WW–07900
8’ (2438mm)	2405WW–09100
9’ (2743mm)	2405WW–10300
10’ (3048mm)	2405WW–11500
11’ (3353mm)	2405WW–12700
12’ (3658mm)	2405WW–13900
13’ (3962mm)	2405WW–07196 2405WW–07900
14’ (4267mm)	2405WW–07196 2405WW–09100
15’ (4572mm)	2405WW–07196 2405WW–10300
16’ (4877mm)	2405WW–07196 2405WW–11500
17’ (5182mm)	2405WW–07196 2405WW–12700
18’ (5486mm)	2405WW–07196 2405WW–13900
WW = Conveyor Width reference: 08, 10, 12	

18” (457mm) to 24” (610mm) Wide Conveyor

Item	Part Number	Description
1	920692M	Socket Head Screw M6 x 12mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	240328	Bearing
6	2473WW	Idler Spindle
7	808–020	Magnet .25” Dia. x .25” long
8	450226SSP	Sleeve, .25” Magnet Stainless Steel
9	240426	Head Plate RH
10	920691M	Socket Head Screw M6 x 10mm

11	240329	Tension Slide Bar
12	240420	Rack Gear 14.5 Degree PA x 24 P
13	See Chart	Side Rail RH
14	See Chart	Center Rail
15	2030WWM	Pinion Gear
16	240417	Center Rail Cross Support 18” (457mm)
	240418	Center Rail Cross Support 21” (533mm)
	240419	Center Rail Cross Support 24” (610mm)
17	See Chart	Side Rail LH
18	4564WW	Drive Spindle 2” (51mm)
	2476WW	Nosebar Drive Spindle Lagged 2” (51mm)
19	980422M	Square Key 4mm x 22mm

20	See Chart	Conveyor Bed Plate
21	807–1105	Flat Head Torx Screw M6 x 10mm
22	22A–WW	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 18)
	22D–WW	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 18)
23	22NA–WW	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 18)
	22ND–WW	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 18)
24	22T–WW	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)
WW = Conveyor width reference: 18, 21, 24		

Item 13: Side Rail RH	
Length	Part Number
2’ (610mm)	240412–01908
3’ (914mm)	240412–03108
4’ (1219mm)	240412–04308
5’ (1524mm)	240412–05508
6’ (1829mm)	240412–06708
7’ (2134mm)	240412–07908
8’ (2438mm)	240412–09108
9’ (2743mm)	240412–10308
10’ (3048mm)	240412–11508
11’ (3353mm)	240412–12708
12’ (3658mm)	240412–13908
13’ (3962mm)	240412–07200 240412–07908
14’ (4267mm)	240412–07200 240412–09108
15’ (4572mm)	240412–07200 240412–10308
16’ (4877mm)	240412–07200 240412–11508
17’ (5182mm)	240412–07200 240412–12708
18’ (5486mm)	240412–07200 240412–13908

Item 14: Center Rail	
Length	Part Number
2’ (610mm)	240414–00998
3’ (914mm)	240414–02198
4’ (1219mm)	240414–03398
5’ (1524mm)	240414–04598
6’ (1829mm)	240414–05798
7’ (2134mm)	240414–06998
8’ (2438mm)	240414–08198
9’ (2743mm)	240414–09398
10’ (3048mm)	240414–10598
11’ (3353mm)	240414–11798
12’ (3658mm)	240414–12998
13’ (3962mm)	240414–06600 240414–06998
14’ (4267mm)	240414–06600 240414–08198
15’ (4572mm)	240414–06600 240414–09398
16’ (4877mm)	240414–06600 240414–10598
17’ (5182mm)	240414–06600 240414–11798
18’ (5486mm)	240414–06600 240414–12998

Item 16: Side Rail LH	
Length	Part Number
2’ (610mm)	240413–01908
3’ (914mm)	240413–03108
4’ (1219mm)	240413–04308
5’ (1524mm)	240413–05508
6’ (1829mm)	240413–06708
7’ (2134mm)	240413–07908
8’ (2438mm)	240413–09108
9’ (2743mm)	240413–10308
10’ (3048mm)	240413–11508
11’ (3353mm)	240413–12708
12’ (3658mm)	240413–13908
13’ (3962mm)	240413–07200 240413–07908
14’ (4267mm)	240413–07200 240413–09108
15’ (4572mm)	240413–07200 240413–10308
16’ (4877mm)	240413–07200 240413–11508
17’ (5182mm)	240413–07200 240413–12708
18’ (5486mm)	240413–07200 240413–13908

Item 17: Bed Plate	
Length	Part Number
2’ (610mm)	2405WW–01900
3’ (914mm)	2405WW–03100
4’ (1219mm)	2405WW–04300
5’ (1524mm)	2405WW–05500
6’ (1829mm)	2405WW–06700
7’ (2134mm)	2405WW–07900
8’ (2438mm)	2405WW–09100
9’ (2743mm)	2405WW–10300
10’ (3048mm)	2405WW–11500
11’ (3353mm)	2405WW–12700
12’ (3658mm)	2405WW–13900
13’ (3962mm)	2405WW–07196 2405WW–07900
14’ (4267mm)	2405WW–07196 2405WW–09100
15’ (4572mm)	2405WW–07196 2405WW–10300
16’ (4877mm)	2405WW–07196 2405WW–11500
17’ (5182mm)	2405WW–07196 2405WW–12700
18’ (5486mm)	2405WW–07196 2405WW–13900
WW = Conveyor Width reference: 18, 21, 24	

Nosebar End Assembly

Item	Part Number	Description
1	201965M	Mounting Block, PLT Spindle
2	2076WW	Flex–Link Bar
3	241125	Outer Side Plate
4	241126	Inner Side Plate LH
5	241127	Inner Side Plate RH
6	241128	Head Plate Bar
7	2412WW	Nosebar
8	2413WW	Nosebar Rod
9	200695P	Knurl Pin .125” DIA x .937” Lg
10	801–122	Nose Bar Roller
11	920518M	Sockety Head Screw M5 x 18mm
12	920593M	Socket Head Screw M5 x 16mm
13	920692M	Socket Head Screw M6 x 12mm
14	930512M	Flat Head Screw M5 x 12mm
15	22N–WW	Nosebar Roller Kit (Includes Items 8 and 10)
WW.= Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24		

–04 3” (76mm) Aluminum Side

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 3” (76mm) HS
3	200695P	Single Drop–in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide 3” (76mm) HS			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	280403–02400	N/A
	Right Hand	280403–02400	N/A
3’ (914mm)	Left Hand	280403–03600	N/A
	Right Hand	280403–03600	N/A
4’ (1219mm)	Left Hand	280403–04800	N/A
	Right Hand	280403–04800	N/A
5’ (1524mm)	Left Hand	280403–06000	N/A
	Right Hand	280403–06000	N/A
6’ (1829mm)	Left Hand	280403–07200	N/A
	Right Hand	280403–07200	N/A
7’ (2134mm)	Left Hand	280403–08400	N/A
	Right Hand	280403–08400	N/A
8’ (2438mm)	Left Hand	280403–09600	N/A
	Right Hand	280403–09600	N/A
9’ (2743mm)	Left Hand	280403–10800	N/A
	Right Hand	280403–10800	N/A
10’ (3048mm)	Left Hand	280403–12000	N/A
	Right Hand	280403–12000	N/A
11’ (3353mm)	Left Hand	280403–13200	N/A
	Right Hand	280403–13200	N/A
12’ (3658mm)	Left Hand	280403–14400	N/A
	Right Hand	280403–14400	N/A
13’ (3962mm)	Left Hand	280401–07500	280401–08100
	Right Hand	280402–07500	280402–08100
14’ (4267mm)	Left Hand	280401–07500	280401–09300
	Right Hand	280402–07500	280402–09300
15’ (4572mm)	Left hand	280401–07500	280401–10500
	Right Hand	280402–07500	280402–10500
16’ (4877mm)	Left Hand	280401–07500	280401–11700
	Right Hand	280402–07500	280402–11700
17’ (5182mm)	Left Hand	280401–07500	280401–12900
	Right Hand	280402–07500	280402–12900
18’ (5486mm)	Left Hand	280401–07500	280401–14100
	Right Hand	280402–07500	280402–14100

–05 1.5” (38mm) Aluminum Side

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide .5” (13mm) HS
3	639971M	Single Drop–in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide .5” (13mm) HS			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	280503–02400	N/A
	Right Hand	280503–02400	N/A
3’ (914mm)	Left Hand	280503–03600	N/A
	Right Hand	280503–03600	N/A
4’ (1219mm)	Left Hand	280503–04800	N/A
	Right Hand	280503–04800	N/A
5’ (1524mm)	Left Hand	280503–06000	N/A
	Right Hand	280503–06000	N/A
6’ (1829mm)	Left Hand	280503–07200	N/A
	Right Hand	280503–07200	N/A
7’ (2134mm)	Left Hand	280503–08400	N/A
	Right Hand	280503–08400	N/A
8’ (2438mm)	Left Hand	280503–09600	N/A
	Right Hand	280503–09600	N/A
9’ (2743mm)	Left Hand	280503–10800	N/A
	Right Hand	280503–10800	N/A
10’ (3048mm)	Left Hand	280503–12000	N/A
	Right Hand	280503–12000	N/A
11’ (3353mm)	Left Hand	280503–13200	N/A
	Right Hand	280503–13200	N/A
12’ (3658mm)	Left Hand	280503–14400	N/A
	Right Hand	280503–14400	N/A
13’ (3962mm)	Left Hand	280501–07500	280501–08100
	Right Hand	280502–07500	280502–08100
14’ (4267mm)	Left Hand	280501–07500	280501–09300
	Right Hand	280502–07500	280502–09300
15’ (4572mm)	Left hand	280501–07500	280501–10500
	Right Hand	280502–07500	280502–10500
16’ (4877mm)	Left Hand	280501–07500	280501–11700
	Right Hand	280502–07500	280502–11700
17’ (5182mm)	Left Hand	280501–07500	280501–12900
	Right Hand	280502–07500	280502–12900
18’ (5486mm)	Left Hand	280501–07500	280501–14100
	Right Hand	280502–07500	280502–14100

–07 Low to Side Wiper

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide .5" (13mm) HS
3	41–00–24	Side Wiper Nylatron (per foot)
4	639971M	Single Drop–in Tee Bar
5	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide .5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280903–02400	N/A
	Right Hand	280903–02400	N/A
3' (914mm)	Left Hand	280903–03600	N/A
	Right Hand	280903–03600	N/A
4' (1219mm)	Left Hand	280903–04800	N/A
	Right Hand	280903–04800	N/A
5' (1524mm)	Left Hand	280903–06000	N/A
	Right Hand	280903–06000	N/A
6' (1829mm)	Left Hand	280903–07200	N/A
	Right Hand	280903–07200	N/A
7' (2134mm)	Left Hand	280903–08400	N/A
	Right Hand	280903–08400	N/A
8' (2438mm)	Left Hand	280903–09600	N/A
	Right Hand	280903–09600	N/A
9' (2743mm)	Left Hand	280903–10800	N/A
	Right Hand	280903–10800	N/A
10' (3048mm)	Left Hand	280903–12000	N/A
	Right Hand	280903–12000	N/A
11' (3353mm)	Left Hand	280903–13200	N/A
	Right Hand	280903–13200	N/A
12' (3658mm)	Left Hand	280903–14400	N/A
	Right Hand	280903–14400	N/A
13' (3962mm)	Left Hand	280901–07500	280901–08100
	Right Hand	280902–07500	280902–08100
14' (4267mm)	Left Hand	280901–07500	280901–09300
	Right Hand	280902–07500	280902–09300
15' (4572mm)	Left hand	280901–07500	280901–10500
	Right Hand	280902–07500	280902–10500
16' (4877mm)	Left Hand	280901–07500	280901–11700
	Right Hand	280902–07500	280902–11700
17' (5182mm)	Left Hand	280901–07500	280901–12900
	Right Hand	280902–07500	280902–12900
18' (5486mm)	Left Hand	280901–07500	280901–14100
	Right Hand	280902–07500	280902–14100

–09 Low to High Side

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide .5" (13mm) HS
3	639971M	Single Drop–in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide .5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280903–02400	N/A
	Right Hand	280903–02400	N/A
3' (914mm)	Left Hand	280903–03600	N/A
	Right Hand	280903–03600	N/A
4' (1219mm)	Left Hand	280903–04800	N/A
	Right Hand	280903–04800	N/A
5' (1524mm)	Left Hand	280903–06000	N/A
	Right Hand	280903–06000	N/A
6' (1829mm)	Left Hand	280903–07200	N/A
	Right Hand	280903–07200	N/A
7' (2134mm)	Left Hand	280903–08400	N/A
	Right Hand	280903–08400	N/A
8' (2438mm)	Left Hand	280903–09600	N/A
	Right Hand	280903–09600	N/A
9' (2743mm)	Left Hand	280903–10800	N/A
	Right Hand	280903–10800	N/A
10' (3048mm)	Left Hand	280903–12000	N/A
	Right Hand	280903–12000	N/A
11' (3353mm)	Left Hand	280903–13200	N/A
	Right Hand	280903–13200	N/A
12' (3658mm)	Left Hand	280903–14400	N/A
	Right Hand	280903–14400	N/A
13' (3962mm)	Left Hand	280901–07500	280901–08100
	Right Hand	280902–07500	280902–08100
14' (4267mm)	Left Hand	280901–07500	280901–09300
	Right Hand	280902–07500	280902–09300
15' (4572mm)	Left hand	280901–07500	280901–10500
	Right Hand	280902–07500	280902–10500
16' (4877mm)	Left Hand	280901–07500	280901–11700
	Right Hand	280902–07500	280902–11700
17' (5182mm)	Left Hand	280901–07500	280901–12900
	Right Hand	280902–07500	280902–12900
18' (5486mm)	Left Hand	280901–07500	280901–14100
	Right Hand	280902–07500	280902–14100

–10 .5” (13mm) Extruded Plastic

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	200054P	Snap–On Guide (per foot)
3	See Chart Below	2200 Guide
4	639971M	Single Drop–in Tee Bar
5	920694M	Socket Head Screw M6 x 20mm

Item 3: 2200 Guide			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	281003–02400	N/A
	Right Hand	281003–02400	N/A
3’ (914mm)	Left Hand	281003–03600	N/A
	Right Hand	281003–03600	N/A
4’ (1219mm)	Left Hand	281003–04800	N/A
	Right Hand	281003–04800	N/A
5’ (1524mm)	Left Hand	281003–06000	N/A
	Right Hand	281003–06000	N/A
6’ (1829mm)	Left Hand	281003–07200	N/A
	Right Hand	281003–07200	N/A
7’ (2134mm)	Left Hand	281003–08400	N/A
	Right Hand	281003–08400	N/A
8’ (2438mm)	Left Hand	281003–09600	N/A
	Right Hand	281003–09600	N/A
9’ (2743mm)	Left Hand	281003–10800	N/A
	Right Hand	281003–10800	N/A
10’ (3048mm)	Left Hand	281003–12000	N/A
	Right Hand	281003–12000	N/A
11’ (3353mm)	Left Hand	281003–13200	N/A
	Right Hand	281003–13200	N/A
12’ (3658mm)	Left Hand	281003–14400	N/A
	Right Hand	281003–14400	N/A
13’ (3962mm)	Left Hand	281001–07500	281001–08100
	Right Hand	281002–07500	281002–08100
14’ (4267mm)	Left Hand	281001–07500	281001–09300
	Right Hand	281002–07500	281002–09300
15’ (4572mm)	Left hand	281001–07500	281001–10500
	Right Hand	281002–07500	281002–10500
16’ (4877mm)	Left Hand	281001–07500	281001–11700
	Right Hand	281002–07500	281002–11700
17’ (5182mm)	Left Hand	281001–07500	281001–12900
	Right Hand	281002–07500	281002–12900
18’ (5486mm)	Left Hand	281001–07500	281001–14100
	Right Hand	281002–07500	281002–14100

–13 Adjustable Guiding

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

2	200830M	Drop–In Tee Bar
3	202004	Mounting Bracket
4	202027M	Guide Mounting Shaft Vertical
5	202028M	Guide Moutning Shaft Horizontal
6	674175MP	Square Nut
7	807–652	Cross Block
8	807–948	Vinyl Shaft Cap
9	614068P	Flat Extruded Guide (per foot)
10	920612M	Socket Head Screw M6 x 12mm
11	920616M	Socket Head Screw M6 x 16mm

0.5” (13mm) Cleated Belt Guiding

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide .47” (13mm) Cleated
3	639971M	Drop–In Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	281603–02256	N/A
	Right Hand	281603–02256	N/A
3’ (914mm)	Left Hand	281603–03456	N/A
	Right Hand	281603–03456	N/A
4’ (1219mm)	Left Hand	281603–04656	N/A
	Right Hand	281603–04656	N/A
5’ (1524mm)	Left Hand	281603–05856	N/A
	Right Hand	281603–05856	N/A
6’ (1829mm)	Left Hand	281603–07056	N/A
	Right Hand	281603–07056	N/A
7’ (2134mm)	Left Hand	281603–08256	N/A
	Right Hand	281603–08256	N/A
8’ (2438mm)	Left Hand	281603–09456	N/A
	Right Hand	281603–09456	N/A
9’ (2743mm)	Left Hand	281603–10656	N/A
	Right Hand	281603–10656	N/A
10’ (3048mm)	Left Hand	281603–11856	N/A
	Right Hand	281603–11856	N/A
11’ (3353mm)	Left Hand	281603–13056	N/A
	Right Hand	281603–13056	N/A
12’ (3658mm)	Left Hand	281603–14256	N/A
	Right Hand	281603–14256	N/A
13’ (3962mm)	Left Hand	281601–07428	281601–08028
	Right Hand	281602–07428	281602–08028
14’ (4267mm)	Left Hand	281601–07428	281601–09228
	Right Hand	281602–07428	281602–09228
15’ (4572mm)	Left hand	281601–07428	281601–10428
	Right Hand	281602–07428	281602–10428
16’ (4877mm)	Left Hand	281601–07428	281601–11628
	Right Hand	281602–07428	281602–11628
17’ (5182mm)	Left Hand	281601–07428	281601–12828
	Right Hand	281602–07428	281602–12828
18’ (5486mm)	Left Hand	281601–07428	281601–14028
	Right Hand	281602–07428	281602–14028

1” (25mm) Cleated Belt Guiding

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 1” (25mm) Cleated
3	639971M	Drop–In Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	281703–02256	N/A
	Right Hand	281703–02256	N/A
3’ (914mm)	Left Hand	281703–03456	N/A
	Right Hand	281703–03456	N/A
4’ (1219mm)	Left Hand	281703–04656	N/A
	Right Hand	281703–04656	N/A
5’ (1524mm)	Left Hand	281703–05856	N/A
	Right Hand	281703–05856	N/A
6’ (1829mm)	Left Hand	281703–07056	N/A
	Right Hand	281703–07056	N/A
7’ (2134mm)	Left Hand	281703–08256	N/A
	Right Hand	281703–08256	N/A
8’ (2438mm)	Left Hand	281703–09456	N/A
	Right Hand	281703–09456	N/A
9’ (2743mm)	Left Hand	281703–10656	N/A
	Right Hand	281703–10656	N/A
10’ (3048mm)	Left Hand	281703–11856	N/A
	Right Hand	281703–11856	N/A
11’ (3353mm)	Left Hand	281703–13056	N/A
	Right Hand	281703–13056	N/A
12’ (3658mm)	Left Hand	281703–14256	N/A
	Right Hand	281703–14256	N/A
13’ (3962mm)	Left Hand	281701–07428	281701–08028
	Right Hand	281702–07428	281702–08028
14’ (4267mm)	Left Hand	281701–07428	281701–09228
	Right Hand	281702–07428	281702–09228
15’ (4572mm)	Left hand	281701–07428	281701–10428
	Right Hand	281702–07428	281702–10428
16’ (4877mm)	Left Hand	281701–07428	281701–11628
	Right Hand	281702–07428	281702–11628
17’ (5182mm)	Left Hand	281701–07428	281701–12828
	Right Hand	281702–07428	281702–12828
18’ (5486mm)	Left Hand	281701–07428	281701–14028
	Right Hand	281702–07428	281702–14028

2” (51mm) Cleated Belt Guiding

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 2.3” Cleated
3	639971M	Drop–In Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	281903–02256	N/A
	Right Hand	281903–02256	N/A
3’ (914mm)	Left Hand	281903–03456	N/A
	Right Hand	281903–03456	N/A
4’ (1219mm)	Left Hand	281903–04656	N/A
	Right Hand	281903–04656	N/A
5’ (1524mm)	Left Hand	281903–05856	N/A
	Right Hand	281903–05856	N/A
6’ (1829mm)	Left Hand	281903–07056	N/A
	Right Hand	281903–07056	N/A
7’ (2134mm)	Left Hand	281903–08256	N/A
	Right Hand	281903–08256	N/A
8’ (2438mm)	Left Hand	281903–09456	N/A
	Right Hand	281903–09456	N/A
9’ (2743mm)	Left Hand	281903–10656	N/A
	Right Hand	281903–10656	N/A
10’ (3048mm)	Left Hand	281903–11856	N/A
	Right Hand	281903–11856	N/A
11’ (3353mm)	Left Hand	281903–13056	N/A
	Right Hand	281903–13056	N/A
12’ (3658mm)	Left Hand	281903–14256	N/A
	Right Hand	281903–14256	N/A
13’ (3962mm)	Left Hand	281901–07428	281901–08028
	Right Hand	281902–07428	281902–08028
14’ (4267mm)	Left Hand	281901–07428	281901–09228
	Right Hand	281902–07428	281902–09228
15’ (4572mm)	Left hand	281901–07428	281901–10428
	Right Hand	281902–07428	281902–10428
16’ (4877mm)	Left Hand	281901–07428	281901–11628
	Right Hand	281902–07428	281902–11628
17’ (5182mm)	Left Hand	281901–07428	281901–12828
	Right Hand	281902–07428	281902–12828
18’ (5486mm)	Left Hand	281901–07428	281901–14028
	Right Hand	281902–07428	281902–14028

Flared Side Guiding

Item	Part Number	Description
1	200121	Guide Retaining Clip
2	202212	Side–Flare Mounting Guide 2’ (610mm)
	202213	Side–Flare Mounting Guide 3’ (914mm)
	202214	Side–Flare Mounting Guide 4’ (1219mm)
	202215	Side–Flare Mounting Guide 5’ (1524mm)
	202216	Side–Flare Mounting Guide 6’ (1829mm)

3	202522M	Flared Guide 45° 2’ (610mm)
	202523M	Flared Guide 45° 3’ (914mm)
	202523M	Flared Guide 45° 4’ (1219mm)
	202523M	Flared Guide 45° 5’ (1524mm)
	202523M	Flared Guide 45° 6’ (1829mm)
4	639971	Drop–In Tee Bar
5	910506M	Button Head Screw M5 x 6mm
6	911–512	Washer
7	920694M	Cap Low–Head Screw M6 x 20mm

Flat Belt Stand Mount Assembly

Item	Part Number	Description
1	240831	Stand Mount
2	300150M	Drop−In Tee Bar
3	605279P	Washer
4	807−920	Square Nut M6
5	920620M	Socket Head Screw M6 x 20mm
6	920692M	Socket Low Head Screw M6x12mm
7	240839	Flat Belt Stand Mount Assembly

Cleated Belt Stand Mount Assembly

Item	Part Number	Description
1	240836	Cleated Mount Assembly
2	300150M	Drop−In Tee Bar
3	605279P	Washer
4	807−920	Square Nut M6
5	920620M	Socket Head Screw M6 x 20mm
6	920692M	Socket Low Head Screw M6x12mm
7	240838	Cleated Stand Mount Assembly

Flat Belt Stand Mount Assembly for 2’ (610mm) Conveyors

Item	Part Number	Description
1	240833	Stand Mount, LH 2’ (610mm)
2	240834	Stand Mount, RH 2’ (610mm)
3	605279P	Washer
4	639971M	Drop–In Tee Bar
5	807–920	Square Nut M6
6	920620M	Socket Head Screw M6 x 20mm
7	920692M	Socket Low Head Screw M6x12mm
8	240847	Flat Belt Stand Mount Assembly for 2’ (610mm) Conveyors

Cleated Belt Stand Mount Assembly for 2’ (610mm) Conveyors

Item	Part Number	Description
1	240852	Cleated Stand Bracket Assembly LH 2’ (610mm) Conveyor
2	240853	Cleated Stand Bracket Assembly RH 2’ (610mm) Conveyor
3	605279P	Washer
4	639971M	Drop–In Tee Bar
5	807–920	Square Nut M6
6	920620M	Socket Head Screw M6 x 20mm
7	920692M	Socket Low Head Screw M6x12mm
8	240851	Cleated Belt Stand Mount Assembly for 2’ (610mm) Conveyors

Connecting Assembly without Stand Mount

Item	Part Number	Description
1	240858	Frame Connector Bar
2	240859	Frame Connector Plate
3	920692M	Socket Low Head Screw M6x12mm
4	240861	Connecting Assembly without Stand Mounts

Flat Belt Connecting Assembly with Stand Mount)

Item	Part Number	Description
1	240831	Stand Mount
2	807–920	Square Nut M6 5mm x 10mm
3	605279P	Washer
4	240858	Frame Connector Bar
5	920620M	Socket Head Screw M6 x 20mm
6	920693M	Socket Low Head Screw M6 x 16mm
7	240860	Flat Belt Connecting Assembly with Stand Mounts

Cleated Belt Connecting Assembly with Stand Mount

Item	Part Number	Description
1	240836	Cleated Stand Bracket
2	807–920	Square Nut M6 5mm x 10mm
3	605279P	Washer
4	240858	Frame Connector Bar
5	920620M	Socket Head Screw M6 x 20mm
6	920693M	Socket Low Head Screw M6 x 16mm
7	240863	Cleated Belt Connecting Assembly with Stand Mounts

2” (51mm) to 6” (152mm) Flat Belt Return Roller

Item	Part Number	Description
1	240825	Return Roller Guard – Short
2	240827	Return Roller Clip
3	802–027	Bearing
4	913–100	Dowel Pin
5	920693M	Socket Low Head Screw M6 x 16mm
6	240840	Roller Assembly (Includes Items 1, 3 and 4)
7	240830	2” (51mm) to 6” (152mm) Flat Belt Return Roller Assy

8” (203mm) to 24” (610mm) Flat Belt Return Roller

Item	Part Number	Description
1	240826	Return Roller
2	240827	Return Roller Clip
3	2409WW	Return Roller Guard
4	2410WW	Return Roller Rod
5	920693M	Socket Low Head Screw M6 x 16mm
6	2408WW	8” (203mm) to 24” (610mm) Flat Belt Return Roller Assembly
WW.= Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24		

Cleated Belt Return Roller

Item	Part Number	Description
1	240825	Return Roller Guard – Short
2	240828	Cleated Return Roller Clip
3	802–027	Bearing
4	913–100	Dowel Pin
5	920693M	Socket Low Head Screw M6 x 16mm
6	240840	Roller Assembly (Includes Items 1, 3 and 4)
7	240832	Cleated Belt Return Roller Assembly

Conveyor Belt Part Number Configuration

Figure 43

Flat Belt Part Number Configuration

Refer to Dorner patent 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. *Add "V" for V-guided belts.

22 - WW LLLL / BB V *

22 – __ __ __ __ __ __ / __ __ V*

(Fill In)

Cleated Belt Part Number Configuration

Refer to Dorner patent plate (Figure 43). From the model number, determine conveyor type ("T"), width ("WW"), length ("LLLL"), cleat type ("C") and cleat spacing ("SSSS"). Use data to configure belt part number as indicated below. *Add "V" for V-guided belts.

2T - WW LLLL C SSSS V *

2 __ – __ __ __ __ __ __ / __ __ __ __ V*

(Fill In)

Notes

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.

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