

**Adjustable Tie Brackets**





**Table of Contents**



Warnings – General Safety .....	2	Steel Stand Attachment Methods .....	4
Introduction .....	2	Aluminum Stand Attachment Methods .....	5
Product Description .....	3	Attachment to Conveyor .....	6
Models .....	3	Preventative Maintenance & Adjustment .....	7
Specifications .....	3	Required Tools .....	7
Installation .....	4	Tie Kit Length Adjustment .....	7
RequiredTools .....	4	Return Policy .....	8

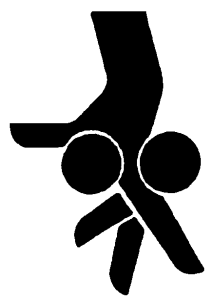

## Warnings – General Safety

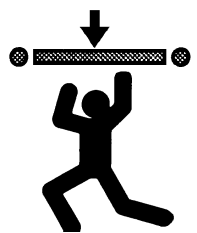

	<b>WARNING</b>	
<p>The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.</p>		

	 <b>DANGER</b>
<p>Climbing, sitting, walking or riding on conveyor will cause severe injury. <b>KEEP OFF CONVEYORS.</b></p>	

	 <b>DANGER</b>
<p><b>DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.</b></p>	

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

	 <b>WARNING</b>
<p>Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.</p> <p>When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, <b>CHECK FOR POTENTIAL PINCH POINTS</b> and other mechanical hazards before system start-up.</p>	

	 <b>WARNING</b>
<p>Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury. <b>SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.</b></p>	

## 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 conveyors are covered by the following patent numbers: 5131529, 5156260, 5156261, 5174435, 5203447, 5265714, 5875883, and corresponding patents 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.

# Product Description

The adjustable tie bracket is a universal bracket compatible with Dorner conveyors and stands. Refer to Figures 1, 2 & 3 for some typical configurations.

- Conveyor (4100 Series not applicable) to stand mounting (Figure 1)
- Stand to stand mounting (Figure 2)
- 90° stand to stand mounting (Figure 3)

## Typical Components

- |   |                    |
|---|--------------------|
| A | Aluminum Stand     |
| B | Adjustable Bar     |
| C | T-slot of Conveyor |
| D | 90° Bracket        |
| E | Steel Stand        |

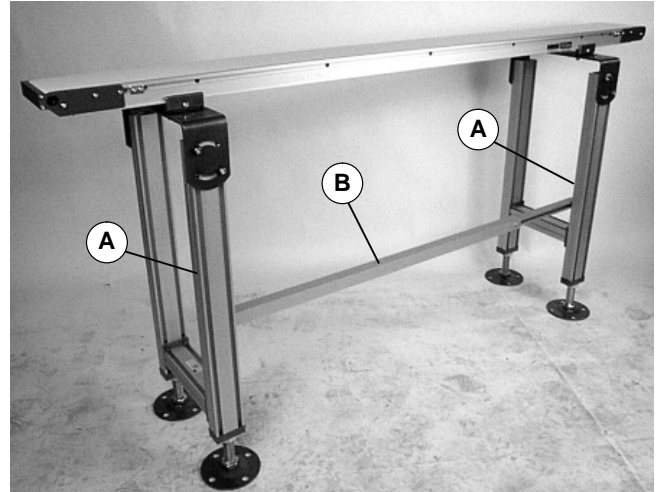


Figure 2

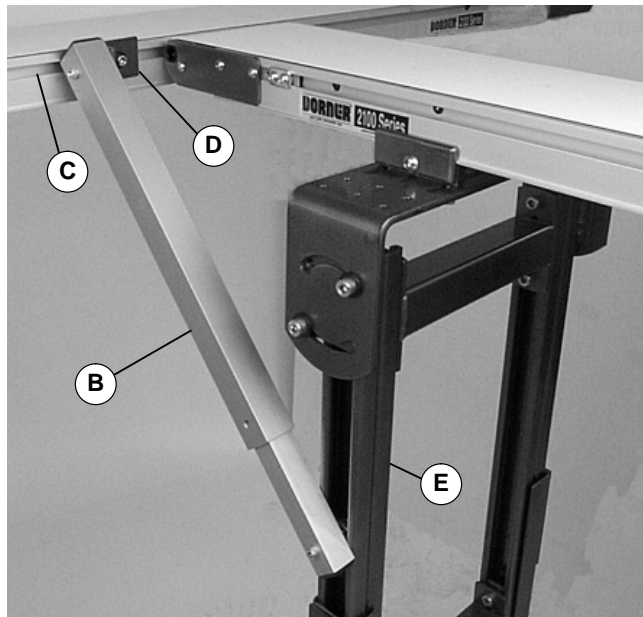


Figure 1

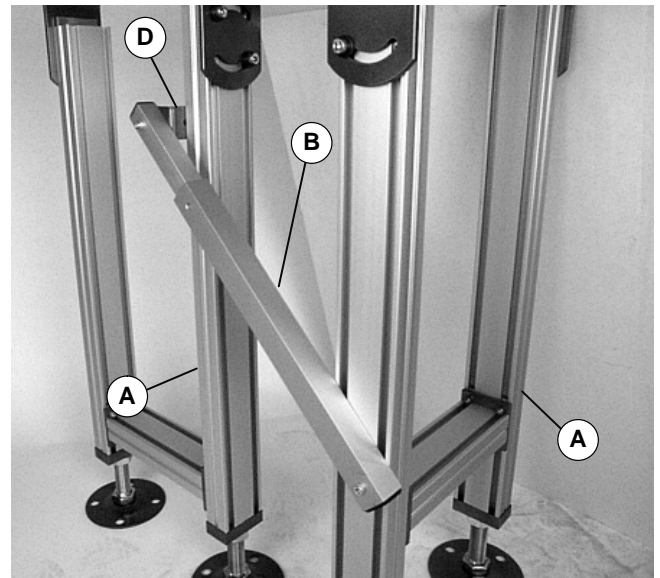



Figure 3

# Specifications

## Models:

Kit Number	Nominal Length		Length Range	
27M400-02	2 ft	610 mm	16.25 to 27"	413 to 686 mm
27M400-03	3 ft	914 mm	28.25 to 39"	718 to 1295 mm
27M400-04	4 ft	1219 mm	40.25 to 51"	1022 to 1295 mm
27M400-05	5 ft	1524 mm	52.25 to 63"	1327 to 1600 mm
27M400-06	6 ft	1829 mm	64.25 to 75"	1632 to 1905 mm

# Installation



**WARNING**

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

## Required Tools

- 5 mm hex key wrench
- Torque wrench

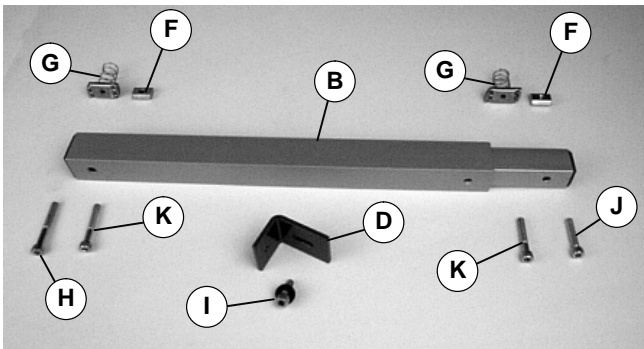


Figure 4

### Illustration References

B	Adjustable Bar
D	90° Bracket
F	M6 T-bars (2x)
G	M6 Spring Channel Nuts (2x)
H	M6 x 45 mm Socket Head Screw
I	M6 x 16 mm Socket Head Screw & Hard Washer
J	M6 x 35 mm Socket Head Screw
K	M6 x 40 mm Socket Head Screw (2x)

## Steel Stand Attachment Methods

**NOTE:** For steel stands, parts (F & J of Figure 4) are not used; please discard.

1. Loosen screw (L of Figure 5) of adjustable bar (B).

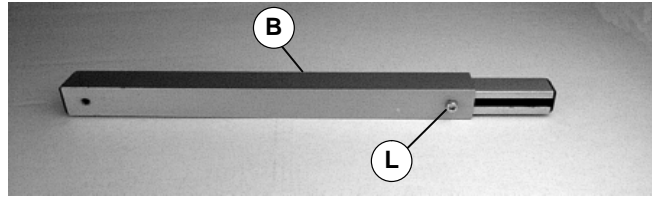


Figure 5

2. Install spring nut (G of Figure 6) into steel stand channel.



Figure 6

**NOTE:** For a 90° stand to stand mounting, loosely attach 90° bracket (D of Figure 7) spring nut (G) using screw and washer (I).

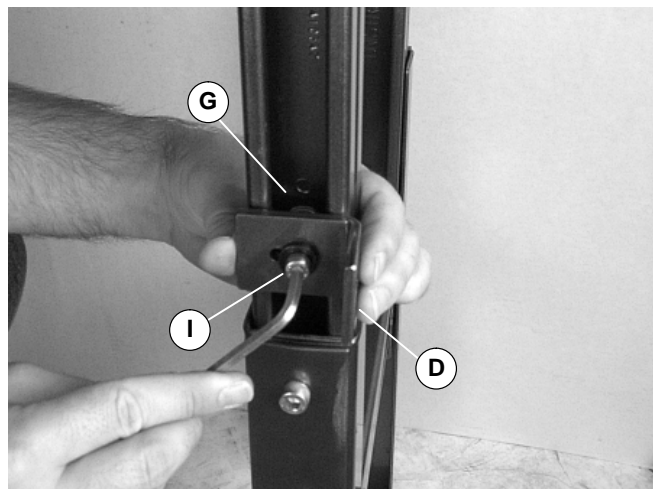


Figure 7

3. Loosely attach adjustable bar (B of Figure 8 or 9) to 90° bracket or steel stand channel as required.
- Attach outer tube end with screw (H of Figure 8)



Figure 8

- Attach inner channel end with screw (K of Figure 9)

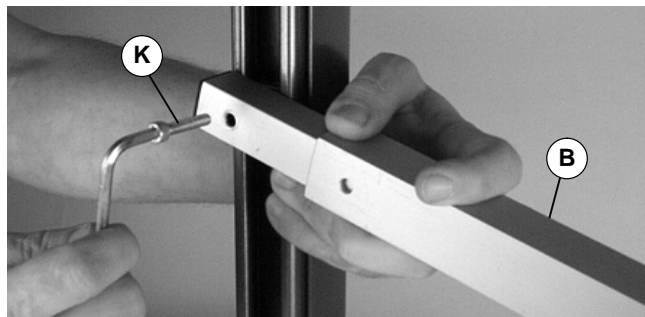


Figure 9

	<div style="text-align: center;"> <h2 style="margin: 0;">WARNING</h2> </div> <p>Failure to secure screws (H, K &amp; L) may cause conveyor sections to drop down, causing severe injury.</p> <p><b>TIGHTEN SCREWS (H, K &amp; L) AFTER ADJUSTMENT.</b></p>
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4. Tighten screws (H, K & L) to 80 in-lb (9 Nm).

## Aluminum Stand Attachment Methods

**NOTE:** For aluminum stands, parts (G & H of Figure 4) are not used; please discard.

1. Loosen screw (L of Figure 10) of adjustable bar (B).

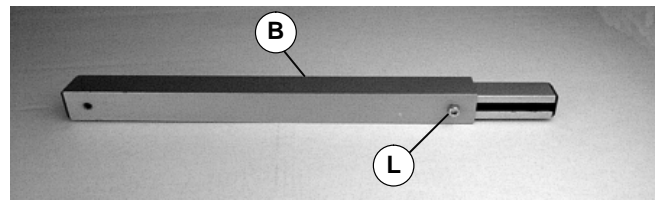


Figure 10

2. Install T-bar (F of Figure 11) in T-slot.

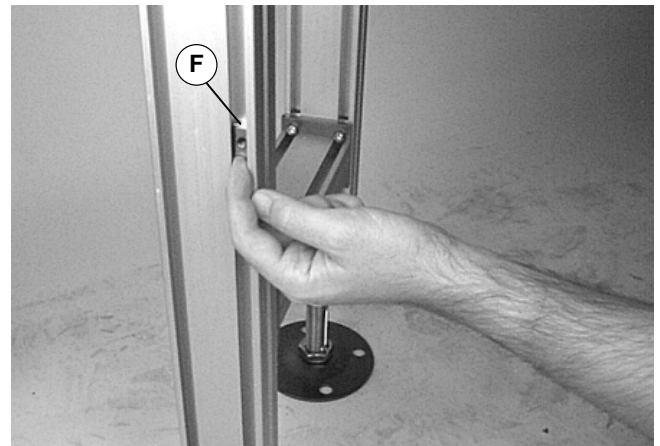


Figure 11

**NOTE:** For a 90° stand to stand mounting, loosely attach 90° bracket (D of Figure 12) to T-bar (F) using screw and washer (I).

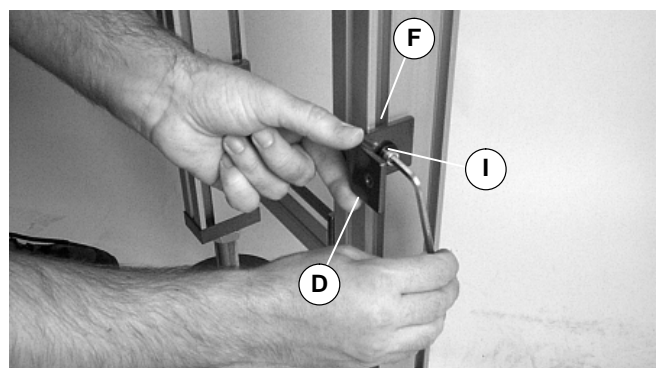


Figure 12

# Installation

3. Loosely attach adjustable bar (B of Figure 13 or 14) to 90° bracket or aluminum stand T-slot as required.
- Attach outer tube end with screw (K of Figure 13)

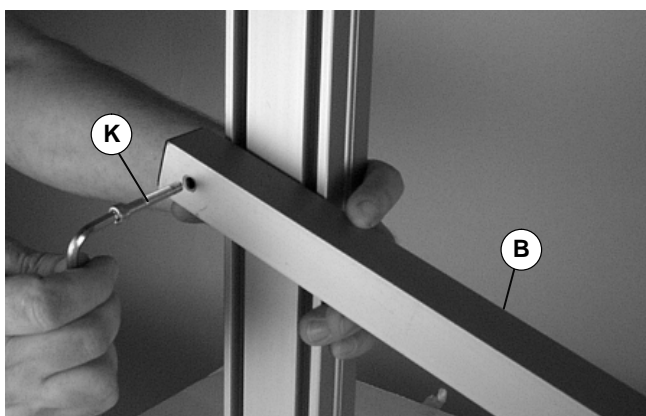


Figure 13

- Attach inner channel end with screw (J of Figure 14)

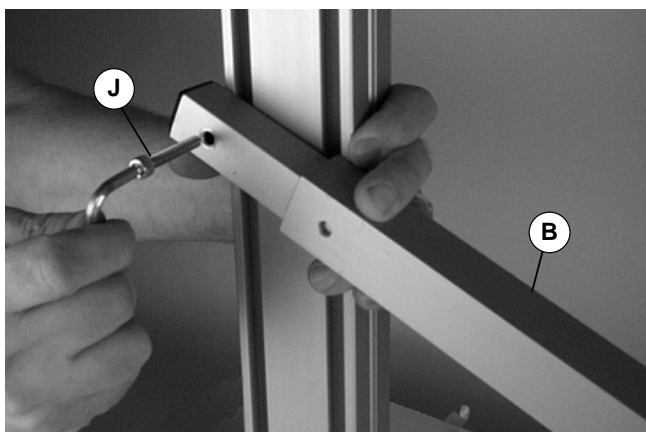


Figure 14

	<div><b>WARNING</b></div> <p>Failure to secure screws (J, K, &amp; L) may cause conveyor sections to drop down, causing severe injury.</p> <p><b>TIGHTEN SCREWS (J, K &amp; L) AFTER ADJUSTMENT.</b></p>
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4. Tighten screws (J, K & L) to 80 in-lb (9 Nm).

## Attachment to Conveyor

1. Loosen screw (L of Figure 15) of adjustable bar (B).

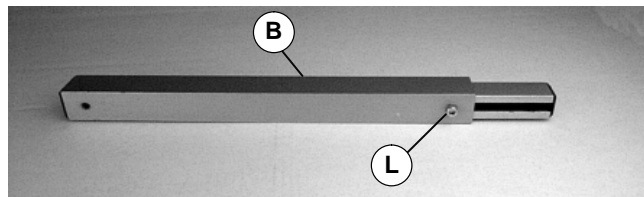


Figure 15

**NOTE:** For 6100 installation, order mounting clip 450186M.

2. Install T-bar (F of Figure 11) in T-slot.

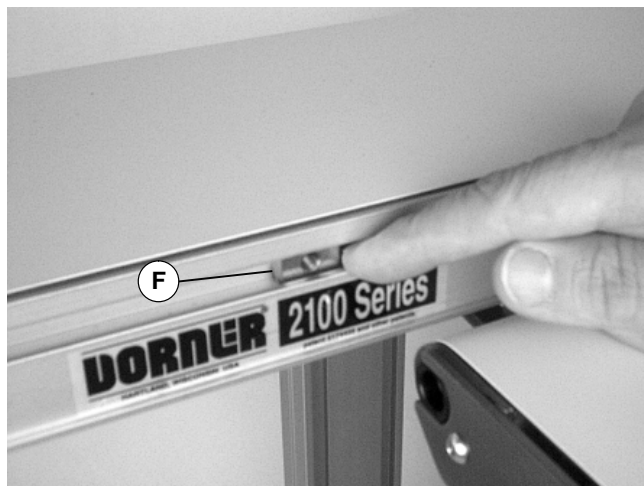


Figure 16

3. Loosely attach 90° bracket (D of Figure 17) to T-bar (F) using screw and washer (I).

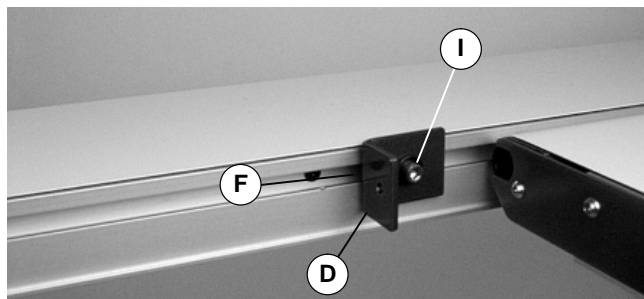


Figure 17



4. Loosely attach adjustable bar (B of Figure 18 or 19).
- Attach outer tube end with screw (K of Figure 18)

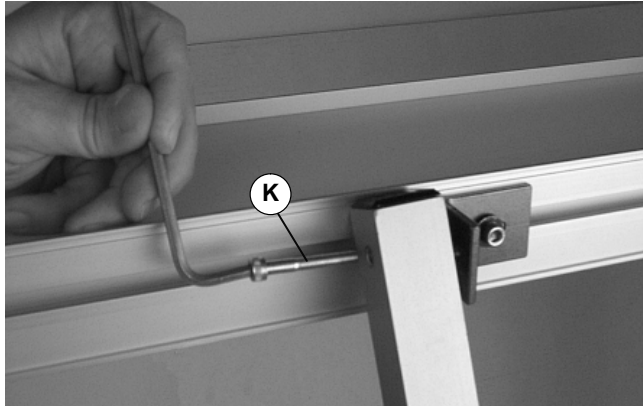


Figure 18

- Attach inner channel end with screw (J of Figure 19)

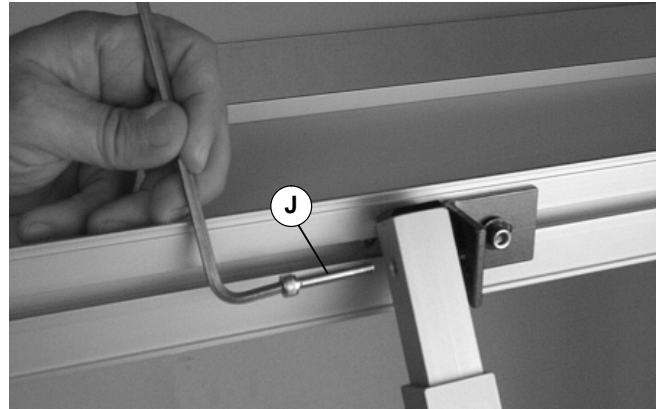


Figure 19

	<p><b>! WARNING</b></p> <p>Failure to secure screws (J, K &amp; L) may cause conveyor sections to drop down, causing severe injury.</p> <p><b>TIGHTEN SCREWS (J, K &amp; L) AFTER ADJUSTMENT.</b></p>
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5. Tighten screws (J, K & L) to 80 in-lb (9 Nm).

## Preventive Maintenance and Adjustment

### Required Tools

- 5 mm hex key wrench
- Torque wrench

### Tie Kit Length Adjustment

	<p><b>! WARNING</b></p> <p>Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.</p> <p><b>SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.</b></p>
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1. Loosen screws (M, N & O of Figure 20).
2. Shorten or lengthen adjustable bar as required.

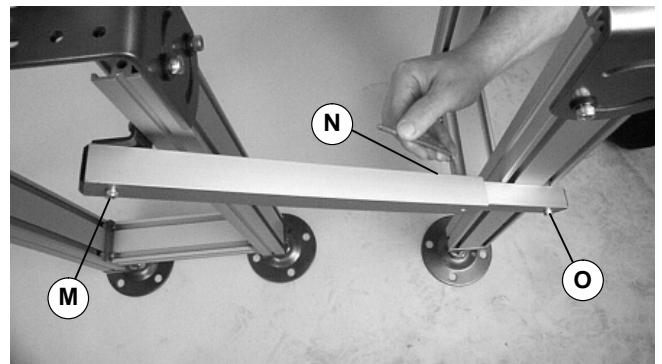


Figure 20

	<p><b>! WARNING</b></p> <p>Failure to secure screws (M, N &amp; O) may cause conveyor sections to drop down, causing severe injury.</p> <p><b>TIGHTEN SCREWS (M, N &amp; O) AFTER ADJUSTMENT.</b></p>
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3. Tighten screws (M, N & O of Figure 20) to 80 in-lb (9 Nm).

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## Return Policy

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No returns will be accepted without prior written factory authorization. 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. 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 to reference.

There will be a 15% restocking charge on all new items returned for credit where Dorner was not at fault. These will not be accepted after 60 days from original invoice date. The restocking charge covers inspection, cleaning, disassembly, and reissuing 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. Feel free to contact Dorner for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dorner products.

For a copy of Dorner's Limited Warranty, contact factory, distributor, service center or visit our website @ [www.dorner.com](http://www.dorner.com)

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

**DORNER®**

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