# 7350 Series Version 2 Modular Belt Curved Conveyors

## Installation, Maintenance and Parts Manual

For other service manuals visit our website at:
www.dornerconveyors.com/manuals-literature

Record Conveyor Serial Number Here

851-878 Rev. C

# Table of Contents



# Introduction

**⚠ CAUTION**

**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.

The Dorner Limited Warranty applies.

Dorner 7350 Series conveyors have patents pending.

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

Dorner has convenient, pre-configured kits of Critical 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. Recommended Critical Service Parts and Kits are marked in the Service Parts section of this manual with the Key Service Parts symbol .

**⚠ WARNING**

**The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.**

**⚠ DANGER**

**SEVERE HAZARD!**

**KEEP OFF CONVEYORS. Climbing, sitting, walking or riding on conveyor will result in death or serious injury.**

**⚠ WARNING**

**SEVERE HAZARD!**

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

**⚠ WARNING**

**BURN HAZARD!**

**DO NOT TOUCH the motor while operating, or shortly after being turned off. Motors may be HOT and can cause serious burn injuries.**

**⚠ WARNING**

**PUNCTURE HAZARD!**

**Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.**

**⚠ DANGER**

**EXPLOSION HAZARD!**

- **DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT. The electric gearmotor generates heat and could ignite combustible vapors.**
- **Failure to comply will result in death or serious injury.**

**⚠ WARNING**

**CRUSH HAZARD!**

- **DO NOT place hands or fingers inside the conveyor while it is running.**
- **DO NOT wear loose garments while operating the conveyor. Loose garments can become caught up in the conveyor.**
- **Failure to comply could result in serious injury.**

**⚠ WARNING**

**CRUSH HAZARD!**

- **SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.**
- **Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing serious injury.**

**⚠ WARNING**

**SEVERE HAZARD!**

- **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.**
- **Failure to comply could result in serious injury.**

# Product Description

Refer to **(Figure 1)** for typical conveyor components.

| | |
|---|---|
| 1 | Conveyor |
| 2 | Gearmotor |
| 3 | Belt |
| 4 | Support Stands |
| 5 | Drive End |
| 6 | Idler End |

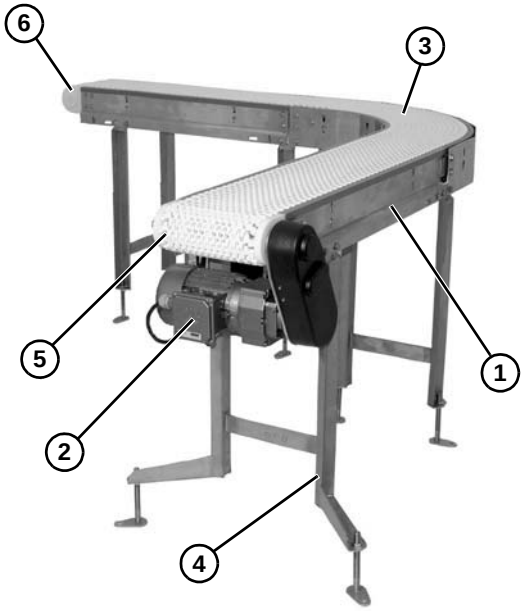



***Figure 1***

# Specifications

| | |
|---|---|
| Conveyor Width Reference (WWW) | 152, 305, 457, 610 |
| Conveyor Belt Width | 152 mm (6"), 305 mm (12"), 457 mm (18"), 610 mm (24") |
| Maximum Conveyor Load<br>(See NOTE Below) | 97 kg/ $m^2$ (20 lbs. / $ft^2$) with a maximum of 227 kg (500 lbs.) |
| Belt Travel | 305 mm (12") per revolution of pulley |
| Maximum Belt Speed | 65 m/minute (213 ft/minute) |
| Conveyor Length Reference (LLLLL) | 00305 - 15240 in 00005 increments |
| Conveyor Length | 305 mm (12") - 15240 mm (600") (25.4 m) in 5 mm (.20") increments |

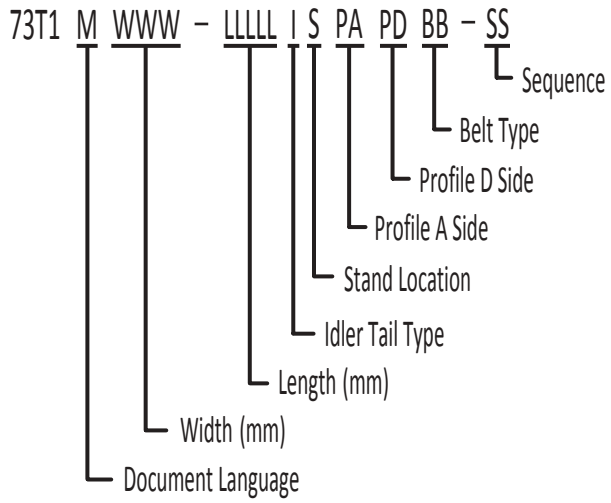
**NOTE**

*Maximum conveyor loads are based on:*

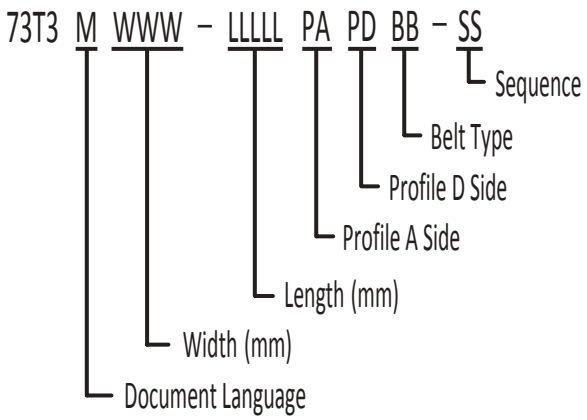
- *Non-accumulating product*
- *Product moving toward gearmotor*
- *Conveyor being mounted horizontally*
- *Conveyor being located in a dry environment*
- *Conveyor equipped with standard belt only*

## 7350 Series Version 2 Curve Conveyor Modules

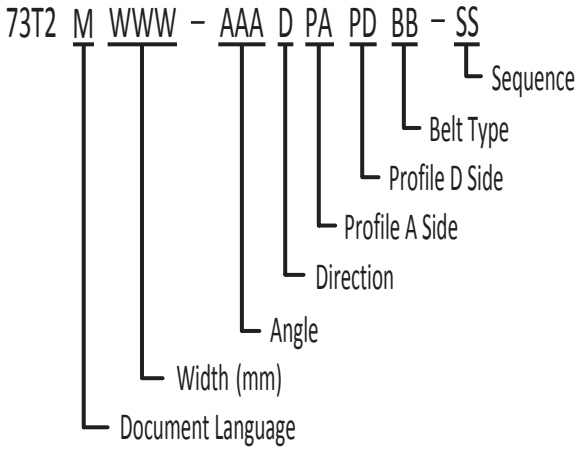
### 7350 Series Version 2 Infeed / Idler Module



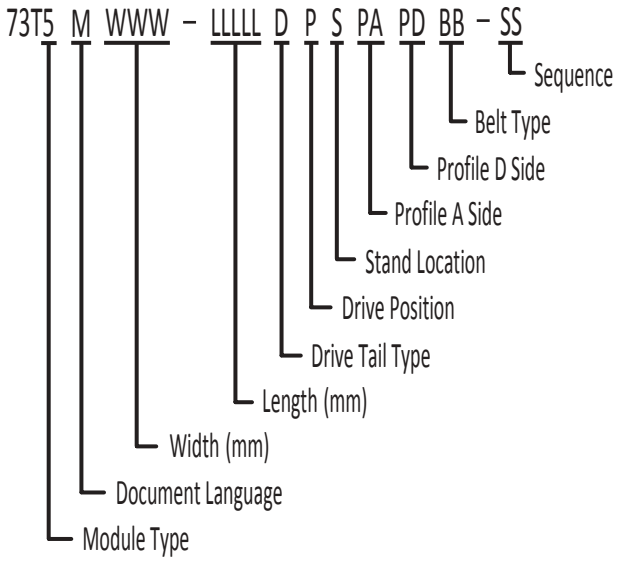

### 7350 Series Version 2 Intermediate Module




### 7350 Series Version 2 Curve Module




### 7350 Series Version 2 Exit / Discharge Module



# Specifications

## Conveyor Supports

**Maximum Distances:**

A = Support Stand on Idler End = 914 mm (36")

B = Support Stand on Drive End = 610 mm (24")

* Additional stands located at frame joints.

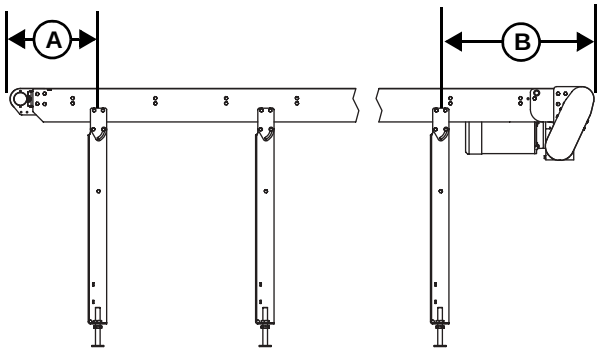



***Figure 2***

### Curve Module

Reference chart below for support stand quantities:

| Degree/Width | 152 mm (6") | 305 mm (12") | 457 mm (18") | 610 mm (24") |
|---|---|---|---|---|
| **45°** | 0 | 0 | 0 | 0 |
| **90°** | 0 | 1 | 1 | 1 |
| **135°** | 1 | 2 | 2 | 2 |
| **180°** | 1 | 3 | 3 | 3 |

**⚠ CAUTION**

**Conveyor MUST be mounted straight, flat and level within confines of conveyor. Use a level (Figure 3, item 1) during setup.**

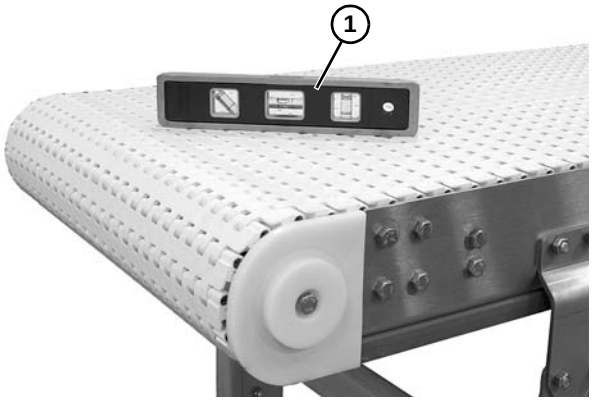



*Figure 3*

## Required Tools

- Level
- Flat blade screwdriver
- 5/32" hex wrench
- 13 mm wrench
- 14 mm wrench
- 17 mm wrench

## Recommended Installation Sequence

1. Remove shipping brackets **(Figure 4, item 1)** from both side of the conveyor.

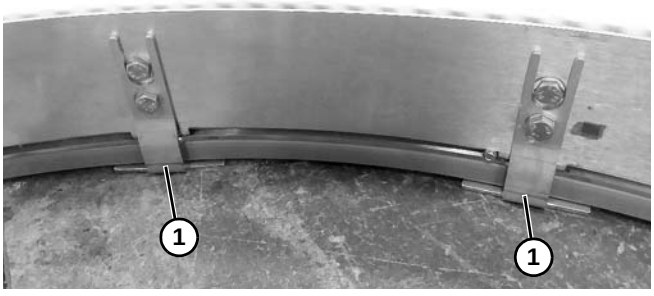



*Figure 4*

2. Assemble the conveyor (if required). Refer to "Connecting Components" on page 7 or "Belt Installation" on page 8.
3. Attach the stands. Refer to "Stand Installation" on page 8.
4. Install the belt. Refer to "Belt Installation" on page 8.
5. Install the gearmotor. Refer to "Drive Package Installation" on page 12.

## Connecting Components

Typical connecting components **(Figure 5)**.

| | |
|---|---|
| 1 | Connecting Plate (x2) |
| 2 | Hex Head Cap Screw (x8) |
| 3 | Conveyor Frames |

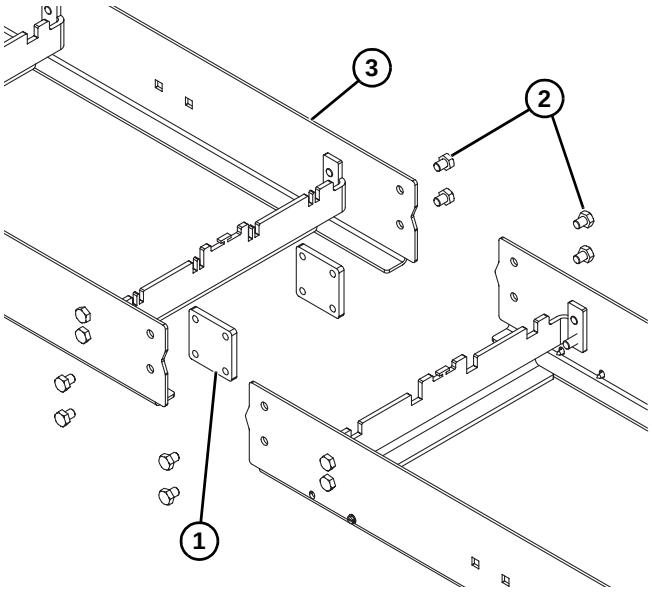



*Figure 5*

1. Locate and arrange conveyor sections by section labels **(Figure 6, item 1).**

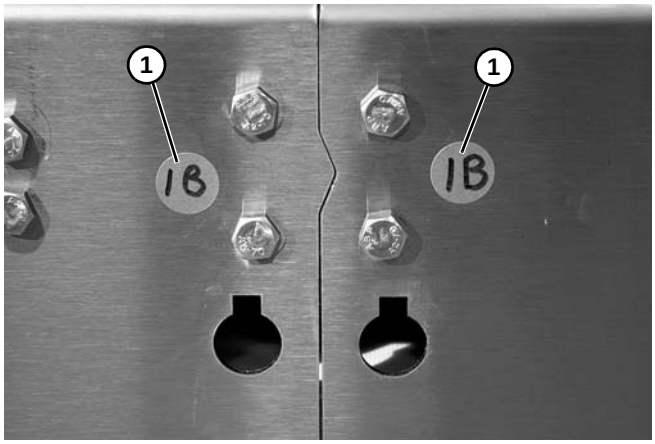



*Figure 6*

2. Join both conveyor sections and install connecting plates **(Figure 5, item 1)** with four screws **(Figure 5, item 2)** on both sides. Tighten to 14-16 ft-lbs (19-22 Nm).

# Installation

## Stand Installation

**NOTE**

*For detailed assembly instructions, please see support stand manual 851-885.*

Typical stand components **(Figure 7)**.

| | |
|---|---|
| 1 | Conveyor Frame |
| 2 | Stand |
| 3 | Carriage Bolt (x4) |
| 4 | Hex Nut (x4) |

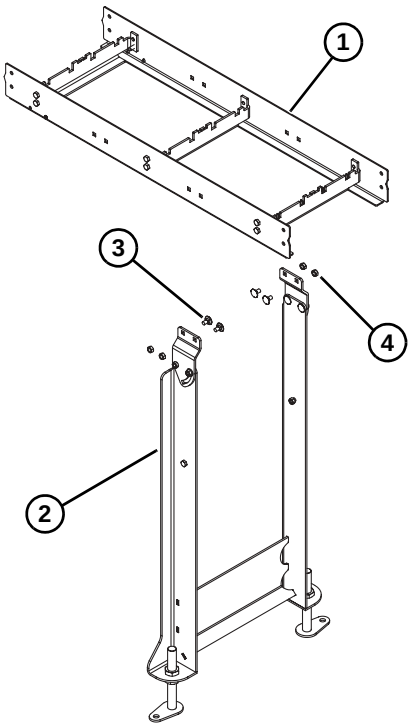



***Figure 7***

1. Position the stands on a flat, level surface.
2. Attach the stands **(Figure 8, item 1)** to the frame. Tighten carriage bolt nuts to 14-16 ft-lbs (19-22 Nm).

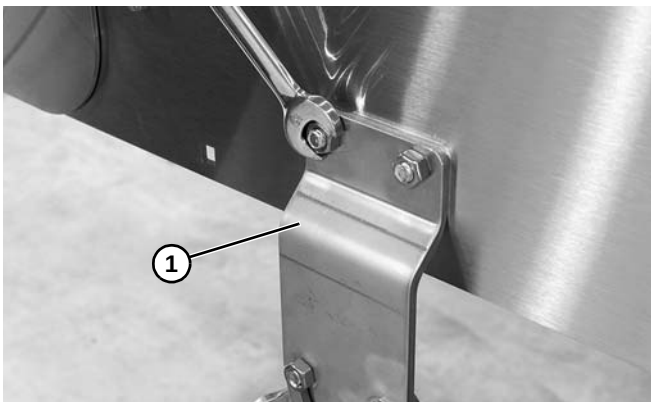



***Figure 8***

## Belt Installation

Typical belt components **(Figure 9)**.

| | |
|---|---|
| 1 | Chain Belt |
| 2 | Belt Rod |

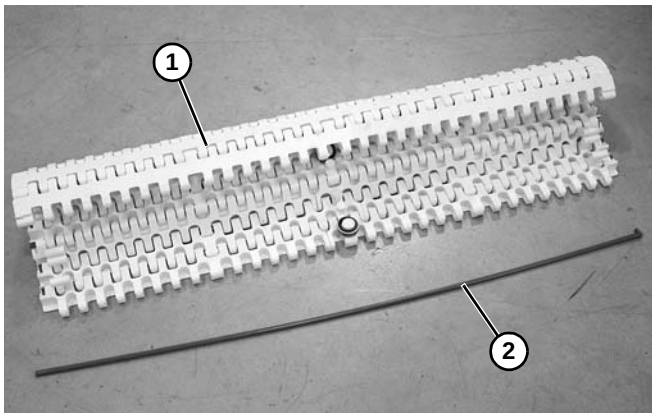



***Figure 9***

1. Position the belt on the conveyor frame.
2. Orient the belt with the arrows **(Figure 10, item 1)** on the underside of the belt pointing in the direction of the travel of the belt.

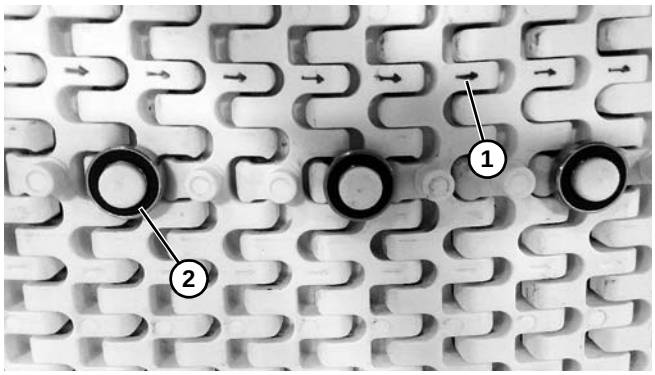



***Figure 10***

**NOTE**

*The bearings **(Figure 10, item 2)** on the underside of the belt must not be next to each other. A minimum of one space, and a maximum of two spaces, is required between bearings.*

3. Wrap the belt around the idler tail **(Figure 11, item 1)**. Feed the belt through the idler tail with belt tabs **(Figure 11, item 2)** riding on the inside of the headplate channel **(Figure 11, item 3)**.

**NOTE**

*The belt tabs must ride on the inside of the headplate channel or jamming occurs.*

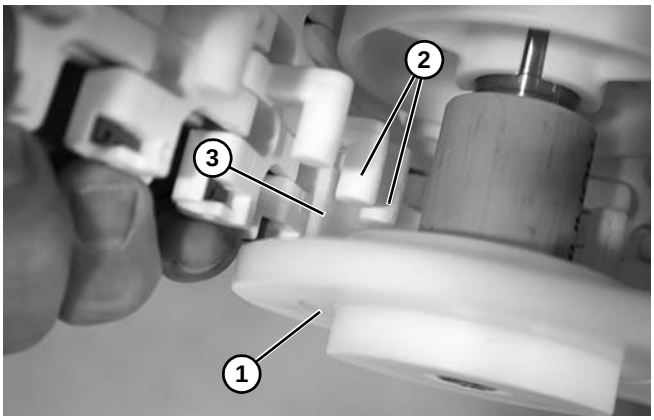



***Figure 11***

4. Feed the ends of the belt through the top and bottom of the curved frame sections. Make sure the belt tabs **(Figure 12, item 1)** and **(Figure 13, item 1)** are properly engaged with the wearstrips **(Figure 12, item 2)** and **(Figure 13, item 2)**.

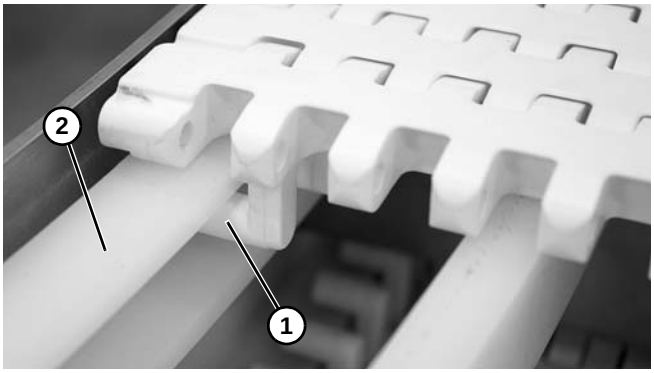



***Figure 12***

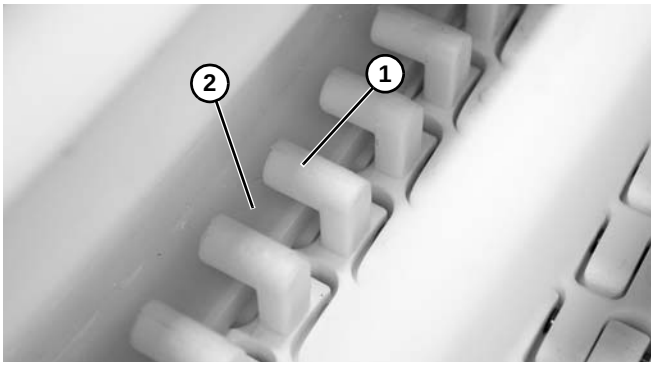



***Figure 13***

5. If applicable, feed the end of the belt around the pucks **(Figure 14, item 1)** in the gravity take-up. Make sure the belt tabs **(Figure 15, item 1)** are properly engaged with the wearstrips **(Figure 15, item 2)**.

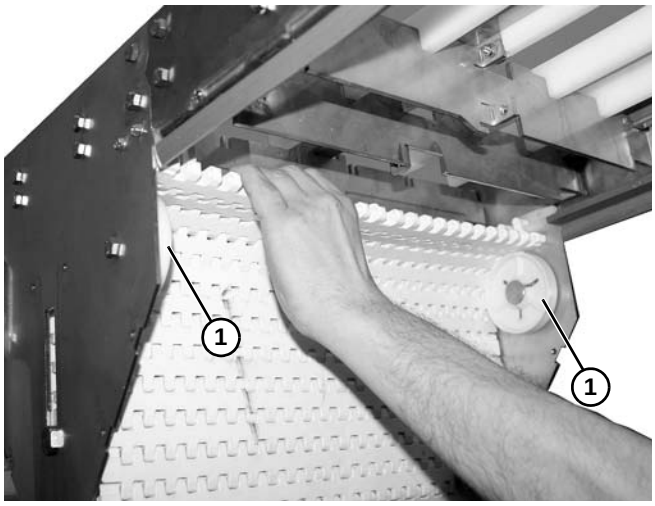



***Figure 14***

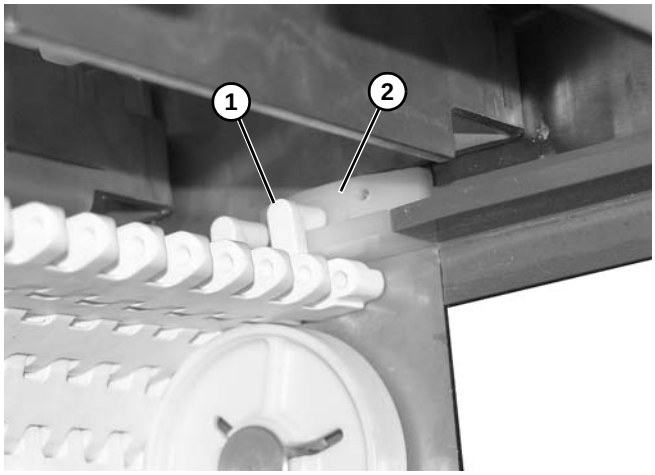



***Figure 15***

6. Continue feeding belt around the gravity take-up **(Figure 16, item 1)**.

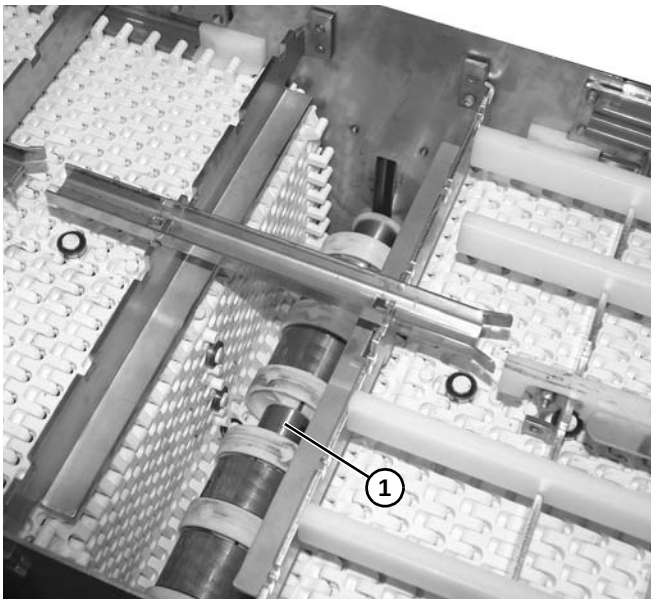



***Figure 16***

7. Wrap the belt around the drive end of the conveyor. Make sure the sprocket teeth have engaged the belt with the teeth **(Figure 17, item 1)** mating with the rounded section **(Figure 17, item 2)** of the belt.

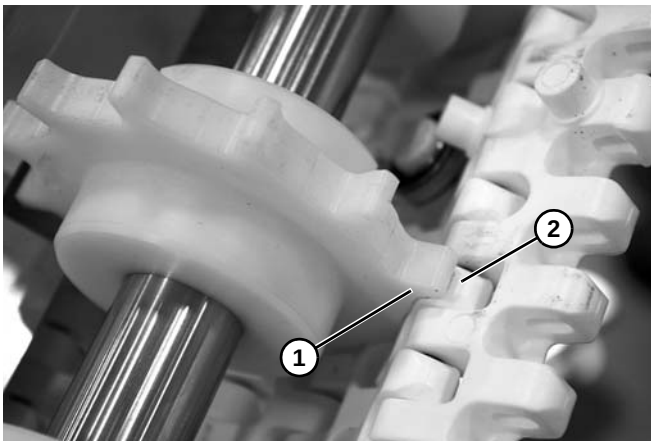



***Figure 17***

8. Bring the ends of the belt together **(Figure 18)**.

***Figure 18***

9. Insert the belt rod **(Figure 19, item 1)** and push it through the belt.

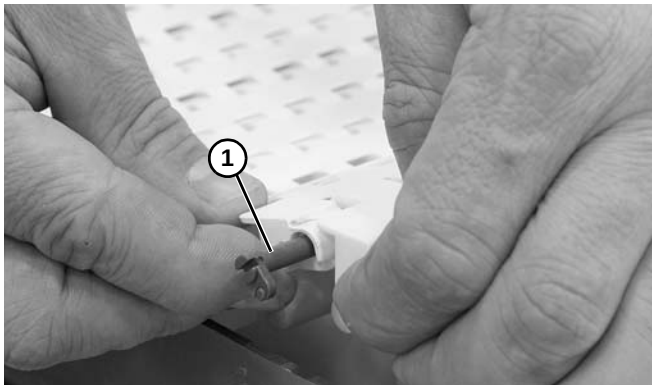



***Figure 19***

10. Insert a flat blade screwdriver into the slot on the rod head **(Figure 20, item 1)**. Rotate rod head clockwise into the locked position **(Figure 20, item 2)**.

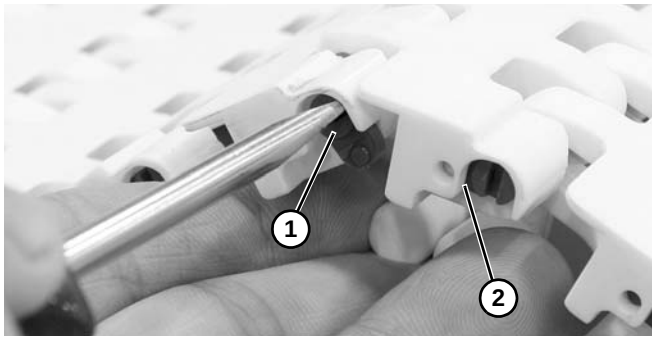



***Figure 20***

## Guide Installation

### High Side Guides

1. Remove and discard the top screw **(Figure 21, item 1)** from the conveyor side.

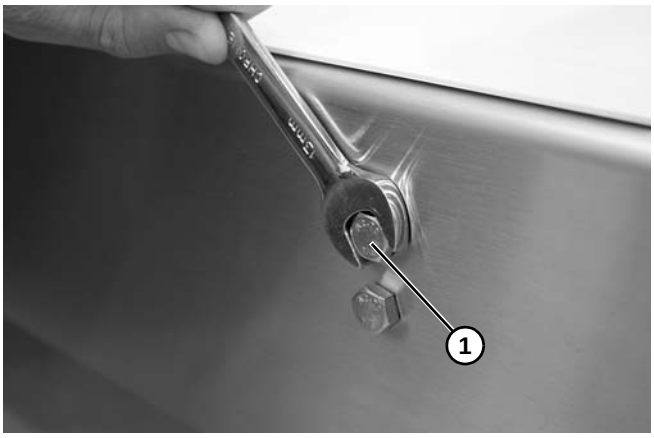



***Figure 21***

2. Assemble the mounting block **(Figure 22, item 1)** to the conveyor side with the screw **(Figure 22, item 2)** provided with the mounting block.

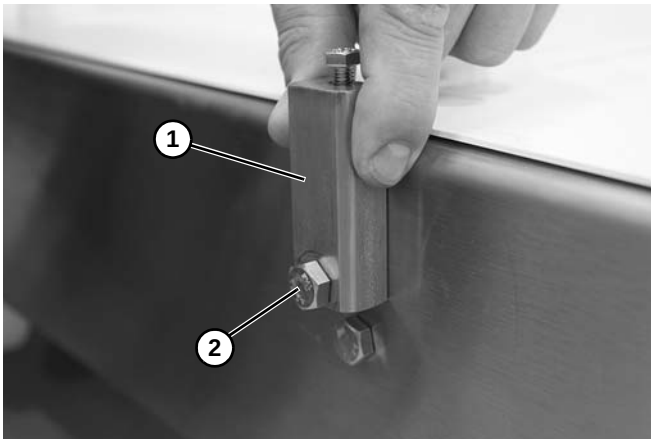



***Figure 22***

3. Install guide **(Figure 23, item 1)** into the slot **(Figure 23, item 2)** of the mounting block and tighten screws **(Figure 23, item 3)**.

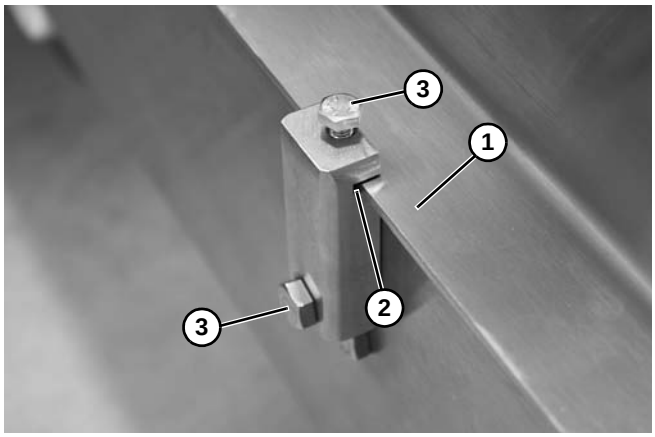



***Figure 23***

4. Install the connecting plate **(Figure 24, item 1)** over the studs.

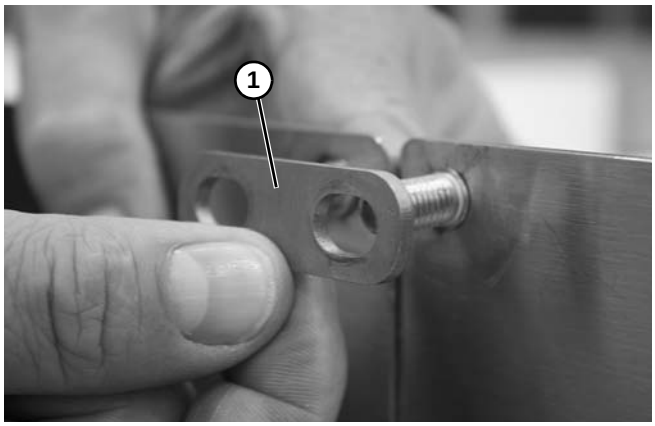



***Figure 24***

5. Install nuts **(Figure 25, item 1)** and tighten.

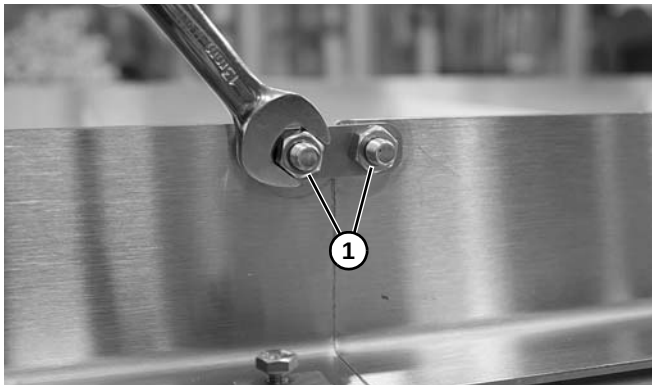



***Figure 25***

## Adjustable Guides

1. Remove the top screw **(Figure 26, item 1)**.

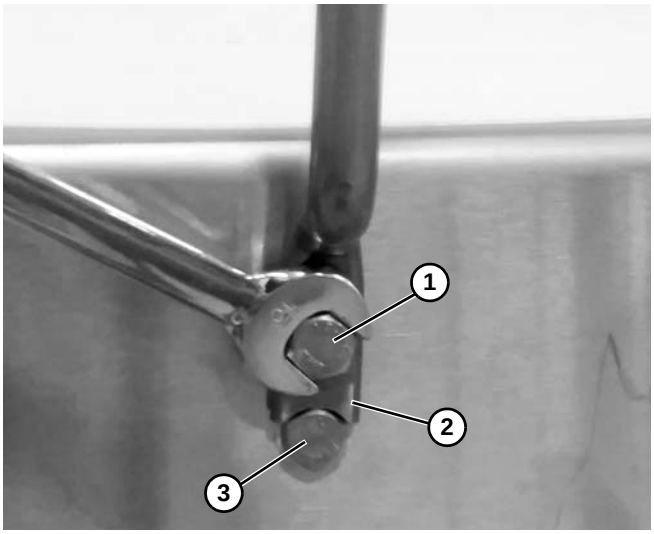



***Figure 26***

2. Install the guide post **(Figure 26, item 2)** resting on lower screw **(Figure 26, item 2)**. Install top screw (provided with the guide post) and tighten.
3. Install guide rail **(Figure 27, item 1)** into rail clamp. Tighten fastener to secure **(Figure 27, item 2)**.

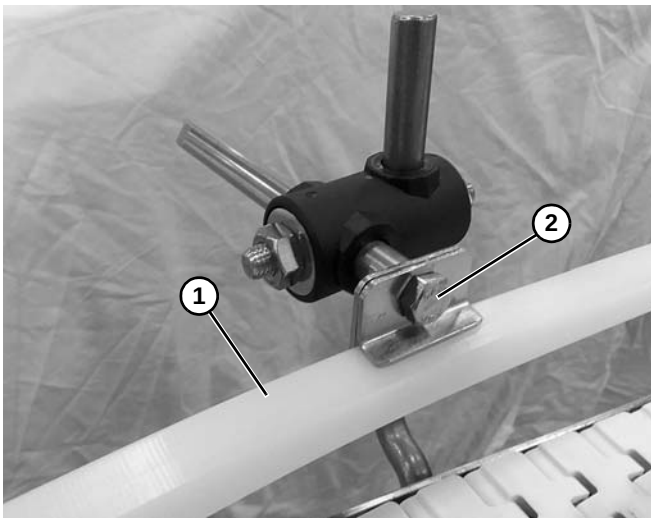



***Figure 27***

| NOTE |
| --- |
| *See pages 51 to 54 for detailed view of guide assembly.* |

## Drive Package Installation

For detailed assembly instructions, refer to the appropriate drive package manual:

- 851-881 7350 Series Version 2 Side Mount Drives
- 851-883 7350 Series Version 2 Bottom Mount Drives

1. Attach the motor **(Figure 28, item 1)** to the gear reducer **(Figure 28, item 2)**.

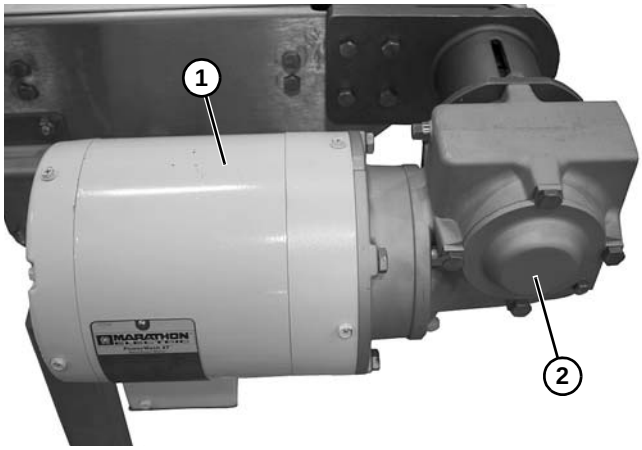



***Figure 28***

# Preventive Maintenance and Adjustment

## Required Tools

- 1/8" hex wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 13 mm wrench
- Punch and hammer (to remove belt rod)
- Phillips screwdriver
- Flat blade screwdriver

## Checklist

- Keep critical service parts on hand. Refer to the "Service Parts" section starting on page 33 for recommendations.
- Replace any worn or damaged parts.

## Cleaning

**NOTE**

*Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.*

**⚠ CAUTION**

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

**⚠ WARNING**

**SEVERE HAZARD!**

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

## Lubrication

No lubrication is required. Replace bearings if worn.

## Maintaining the Conveyor Belt

### Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

Damage to belt links or rods, surface cuts and / or wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories

Skipping indicates:

- Excessive load on belt
- Worn spindle or impacted dirt on drive spindle

## Conveyor Belt Replacement

**⚠ WARNING**

**SEVERE HAZARD!**

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

1. Remove guides **(Figure 29, item 1)** when required.

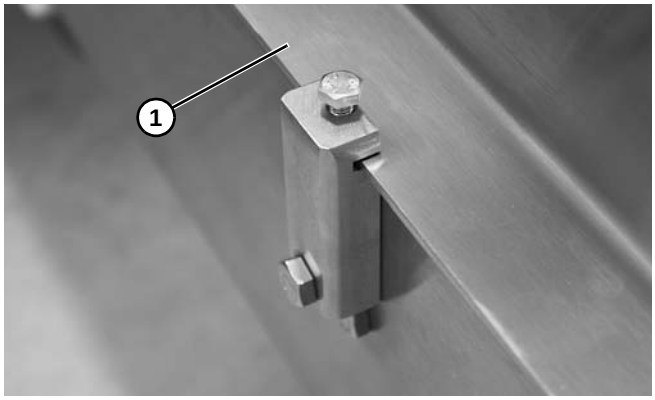



***Figure 29***

**NOTE**

*On 610 mm wide conveyors, DO NOT remove rods located at the bearing. These links are made up of 3 short rods **(Figure 30, item 1)**, not a single piece rod **(Figure 30, item 2)**.*

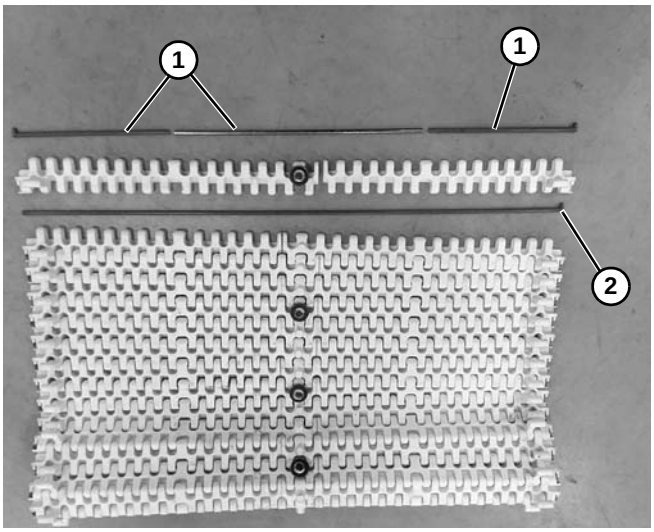



***Figure 30***

2. Lift up the belt near the tail end of the conveyor, or near a straight section. Locate the rod head with a slot **(Figure 31, item 1)**.

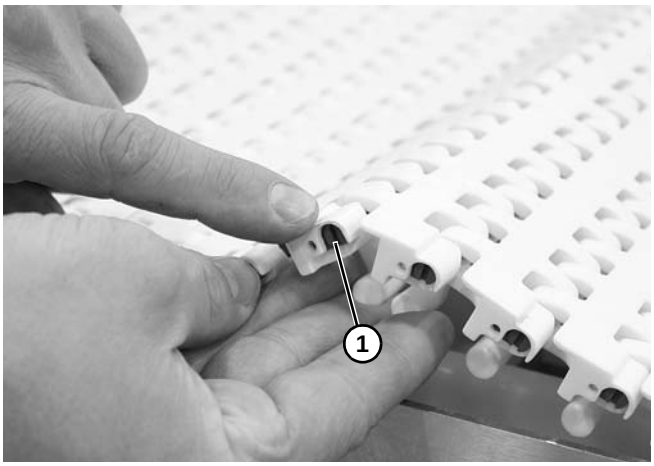



***Figure 31***

3. Insert a flat blade screwdriver into the slot on the rod head **(Figure 32, item 1)** and rotate the rod head counterclockwise to unlock.

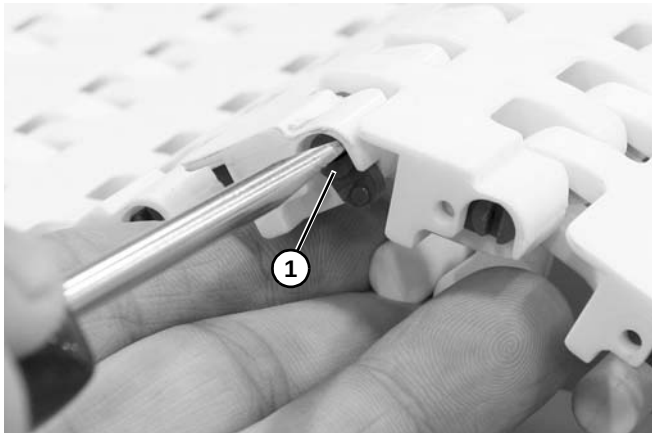



***Figure 32***

4. Remove the belt rod **(Figure 33, item 1)**.

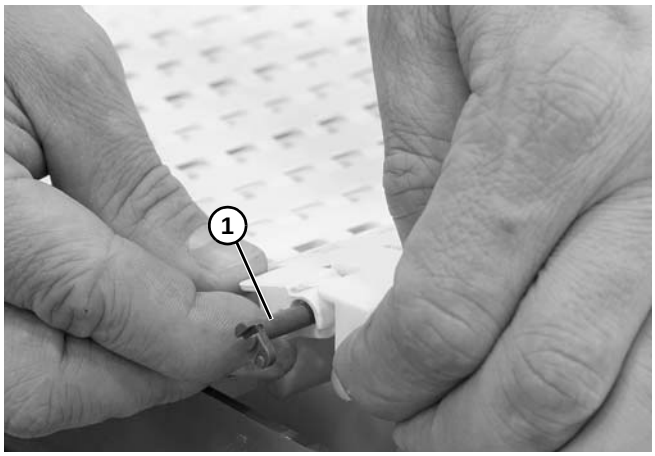



***Figure 33***

5. Slide the old belt off the conveyor frame.
6. Replace the old belt with a new one. Refer to “Belt Installation” on page 8.

**⚠ CAUTION**

**DO NOT reuse belt rods that are damaged or show signs of wear.**

## Conveyor Belt Tensioning

**⚠ WARNING**

**SEVERE HAZARD!**

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

**NOTE**

*On 610 mm wide conveyors, DO NOT remove rods located at the bearing. These links are made up of 3 short rods **(Figure 34, item 1)**, not a single piece rod **(Figure 34, item 2)**.*

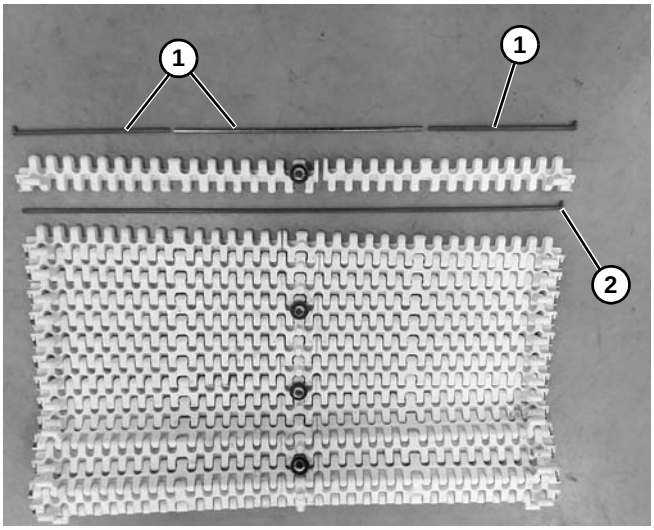



***Figure 34***

1. Lift up the belt near the tail end of the conveyor, or near a straight section. Locate the slotted end of the rod head **(Figure 35, item 1)**.

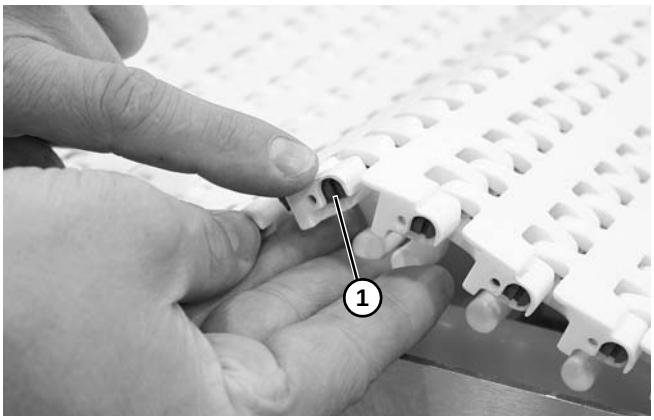



***Figure 35***

2. Insert a flat blade screwdriver into the slot on the rod head **(Figure 36, item 1)** and rotate the rod head counterclockwise to unlock.

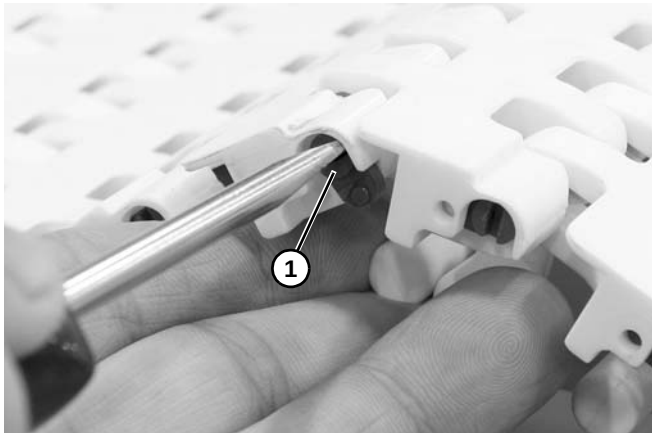



***Figure 36***

3. Remove the belt rod **(Figure 37, item 1)**.

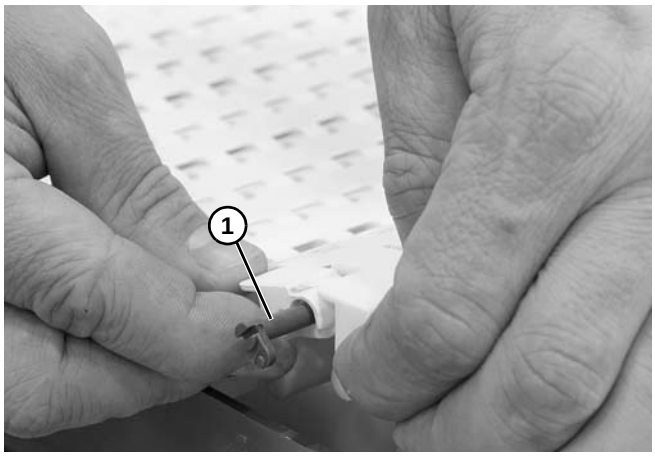



***Figure 37***

4. Remove one or more belt links to take up tension.

**NOTE**

*Belt should not be stretched during installation. A proper length of belt can be installed by interlocking the ends by hand without excess links.*

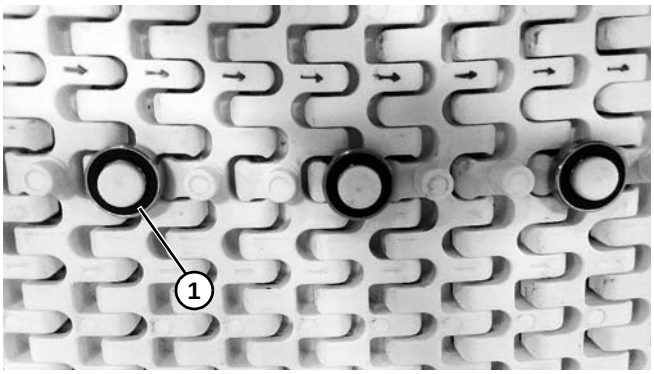



***Figure 38***

| NOTE |
| --- |
| *The bearings **(Figure 38, item 1)** on the underside of the belt must not be next to each other. A minimum of one space, and a maximum of two spaces, is required between bearings.* |

## Wear Strips

Replace the wear strips if they become worn.

Typical straight wear strips **(Figure 39)**.

| | |
| --- | --- |
| 1 | Wear Strip |
| 2 | Wear Strips, Bed Rail |

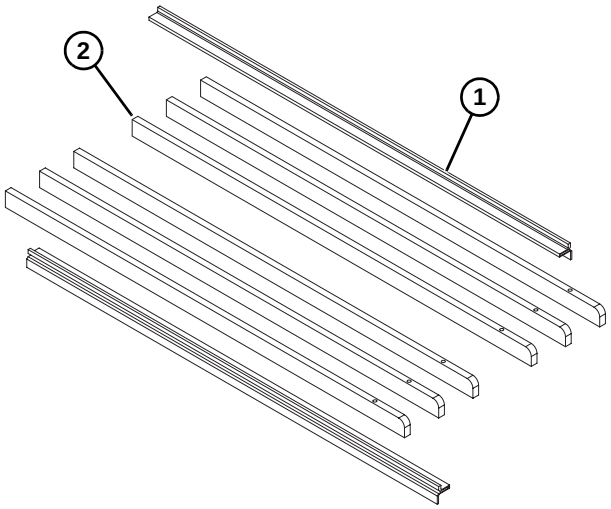



***Figure 39***

Typical curve wear strips **(Figure 40)**.

| | |
| --- | --- |
| 1 | Wear Strip, Upper |
| 2 | Wear Strip, Lower |
| 3 | Wear Strip, Bearing Guide |
| 4 | Wear Strips, Bed Rail |

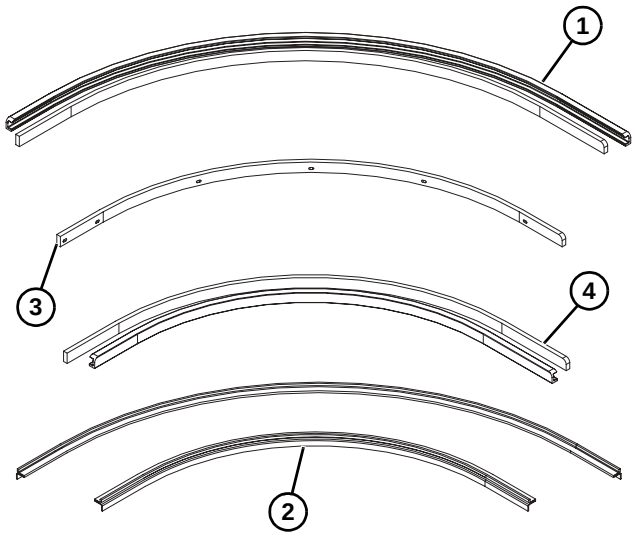



***Figure 40***

## Wear Strip Removal

1. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 13.
2. Remove worn wear strips **(Figure 41, item 1)** from the frame notches.

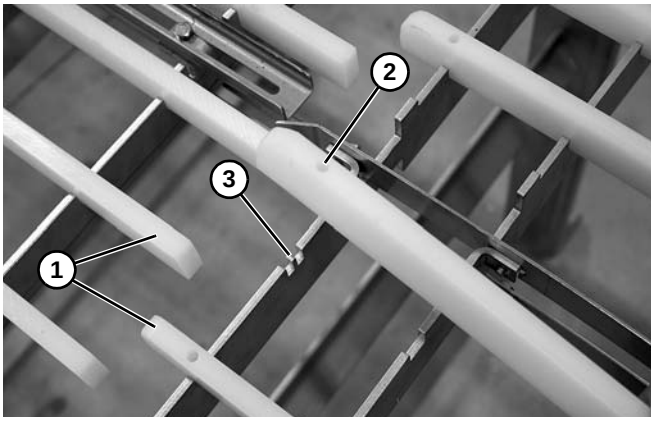



***Figure 41***

3. Attach new wear strips by installing the locating hole **(Figure 41, item 2)** over the tab **(Figure 41, item 3)** on the crossmember.

| NOTE |
| --- |
| *Rounded end of the wear strip must face up.* |

## Curved Wear Strip Removal

### Top Wear Strip

1. Remove the screws **(Figure 42, item 1)** retaining the wear strip support brackets **(Figure 42, item 2)** to the frame crossmembers **(Figure 42, item 3)**.

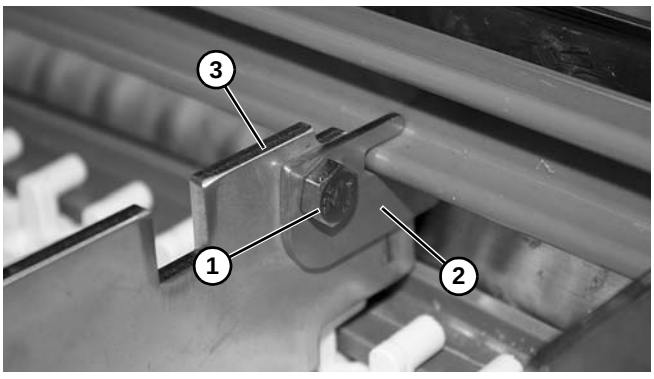



***Figure 42***

2. Remove the upper wear strip **(Figure 43, item 1)** from the frame.

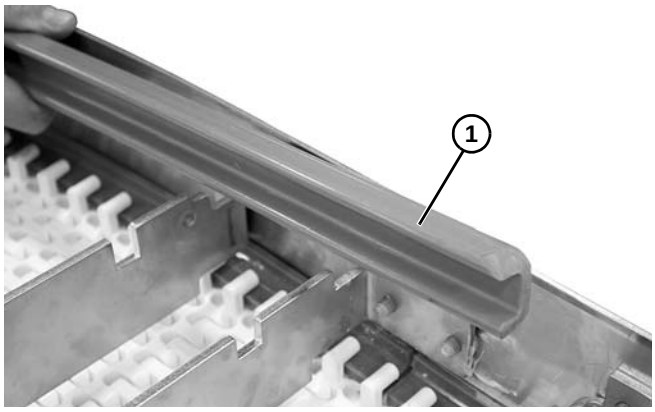



***Figure 43***

3. When installing a new wear strip, make sure the wear strip **(Figure 44, item 1)** is contacting the crossmember tab **(Figure 44, item 2)** - to prevent the wear strip from disengaging.

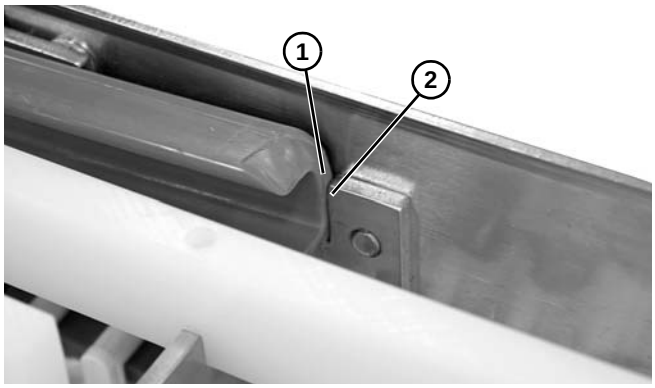



***Figure 44***

### Curve Bearing Guide Wear Strip

1. Remove the screw **(Figure 45, item 1)** retaining the wear strip to the frame crossmember.

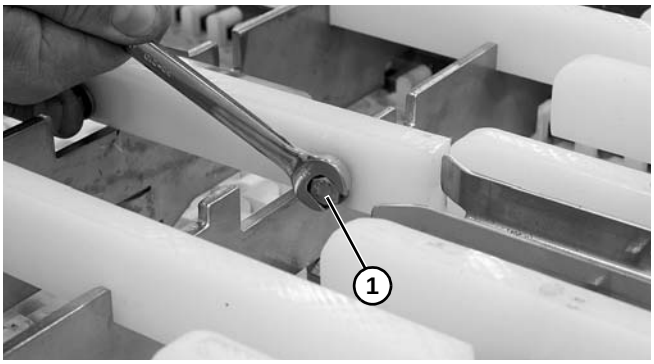



***Figure 45***

2. Remove the wear strip **(Figure 46, item 1)**.

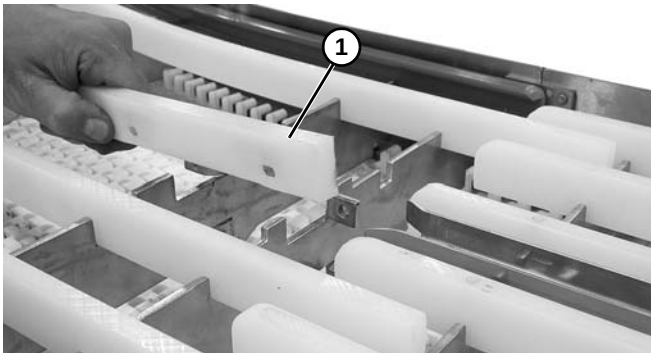



***Figure 46***

3. Install a new wear strip.

**NOTE**

*Insert the first screw on the infeed end of the curve section with the screw head **(Figure 47, item 1)** on the outside of the curve. The remainder of the screw heads **(Figure 47, item 2)** should be located on the inside of the curve.*

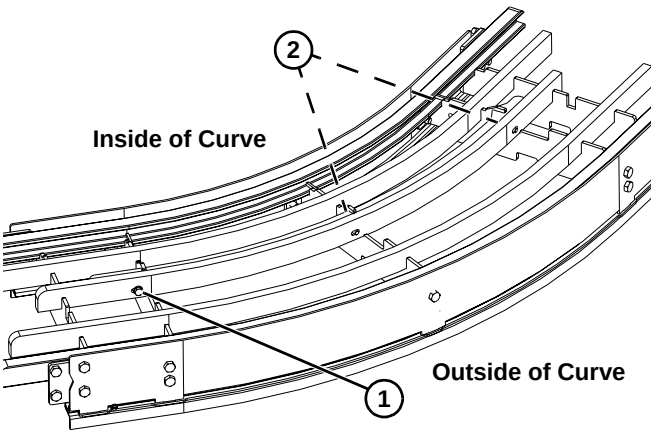



***Figure 47***

### Bottom Wear Strip

1. Remove the screw **(Figure 48, item 1)** retaining the wear strip to the frame.

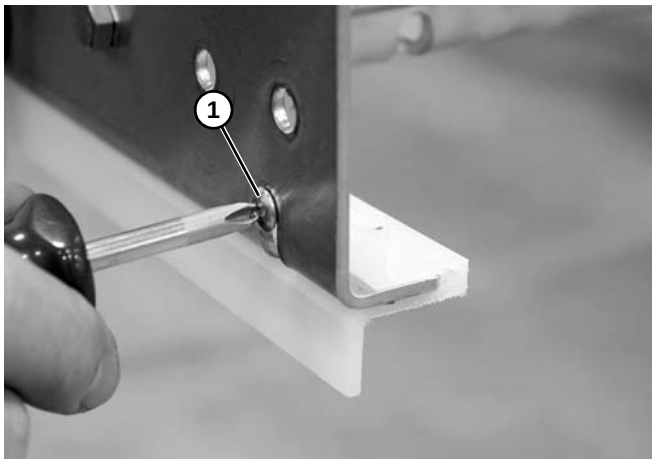



***Figure 48***

2. Remove the bottom wear strip **(Figure 49, item 1)** from the frame rail **(Figure 49, item 2)**.

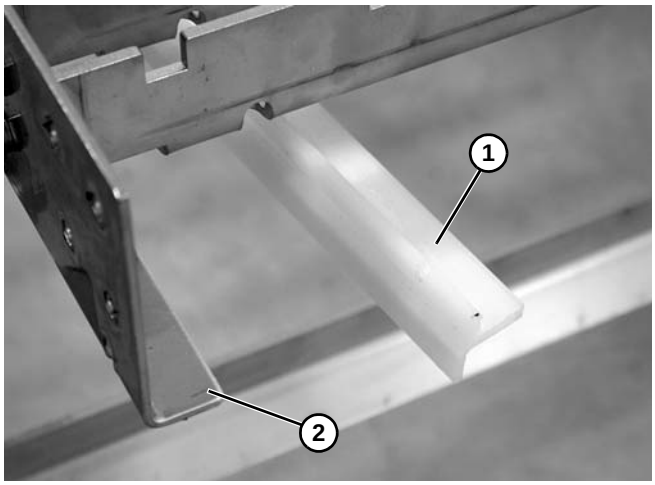



***Figure 49***

3. Install a new wear strip.

## Drive Sprocket and Spindle Replacement

**⚠ WARNING**

**SEVERE HAZARD!**
**LOCK OUT POWER before removing guards or performing maintenance. Exposed moving parts can cause serious injury.**

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Open conveyor belt. Refer to "Conveyor Belt Replacement" on page 13.
3. Remove bearing cover **(Figure 50, item 1)**.

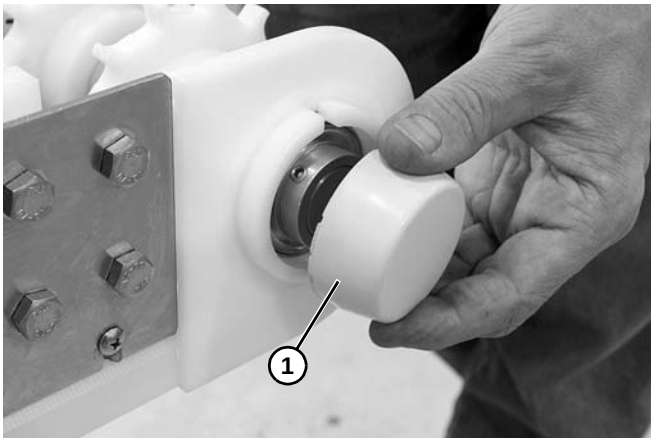



*Figure 50*

4. Remove the four headplate screws **(Figure 51, item 1)** on both sides of the conveyor.

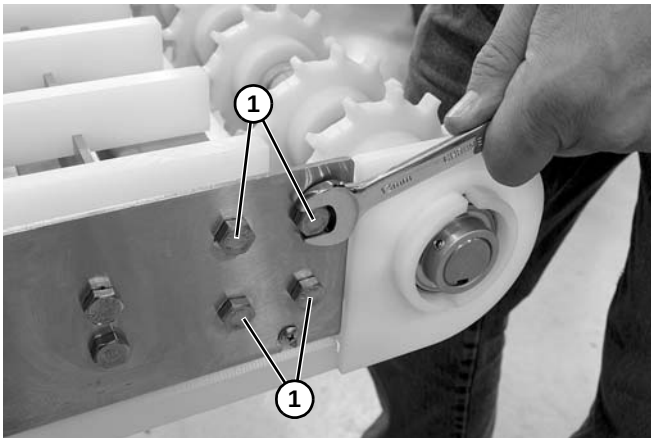



*Figure 51*

**⚠ CAUTION**

**Support bracket (Figure 52, item 2) will not be attached and could fall.**

5. Remove drive tail assembly **(Figure 52, item 1)**.

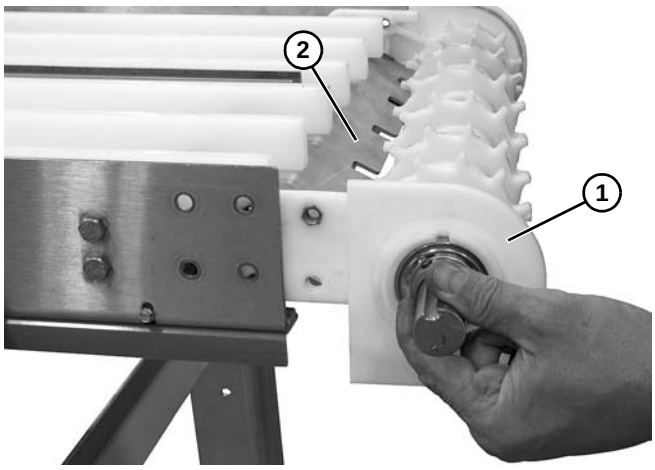



*Figure 52*

6. Loosen set screws **(Figure 53, item 1)**.

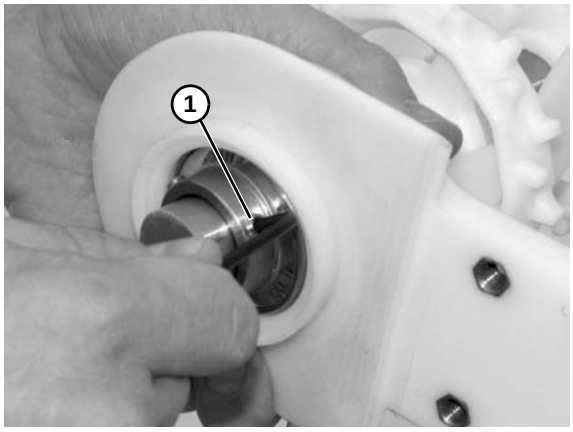



*Figure 53*

7. Slide the headplate with bearing **(Figure 54, item 1)** off the shaft. Replace bearing if worn. Refer to "Bearing Replacement" on page 26.

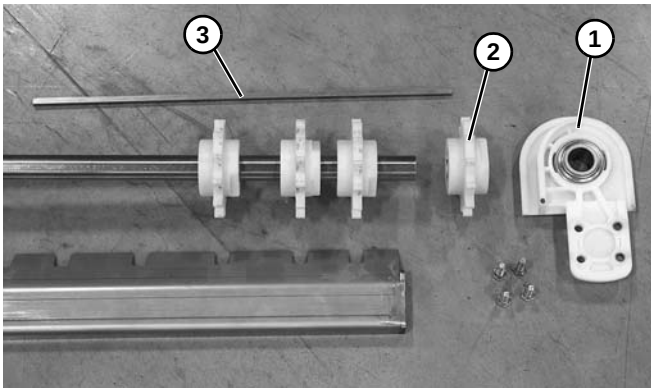



***Figure 54***

8. Slide off the drive sprocket **(Figure 54, item 2).**
9. Repeat as needed.
10. Remove the shaft key **(Figure 54, item 3)**.

## Idler Puck and Spindle Replacement

**⚠ WARNING**

**SEVERE HAZARD!**

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

**NOTE**

*Idler tails are equipped with plain bushing pucks, replace when worn.*

1. Open conveyor belt. Refer to "Conveyor Belt Replacement" on page 13.
2. Remove the four headplate screws **(Figure 55, item 1)** on both sides of the conveyor.

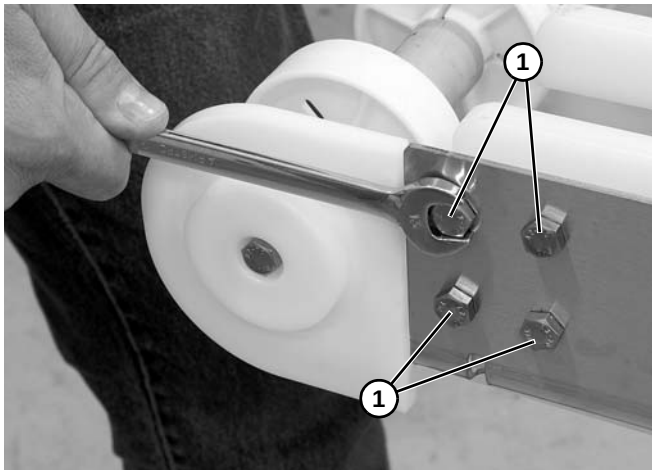



***Figure 55***

3. Remove idler tail assembly **(Figure 56, item 1)**.

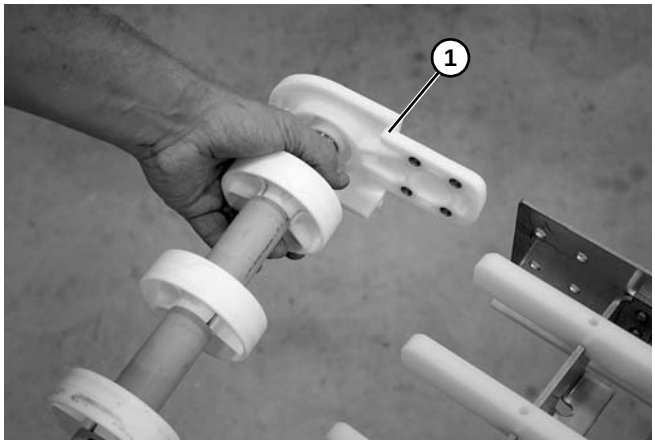



***Figure 56***

4. Using a 13 mm socket **(Figure 57, item 1)**, remove the headplate screw from the shaft.

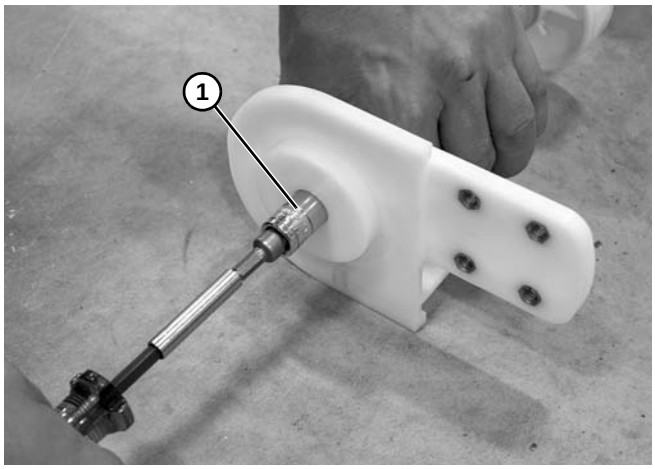



***Figure 57***

5. Slide the headplate **(Figure 58, item 1)** off the shaft.

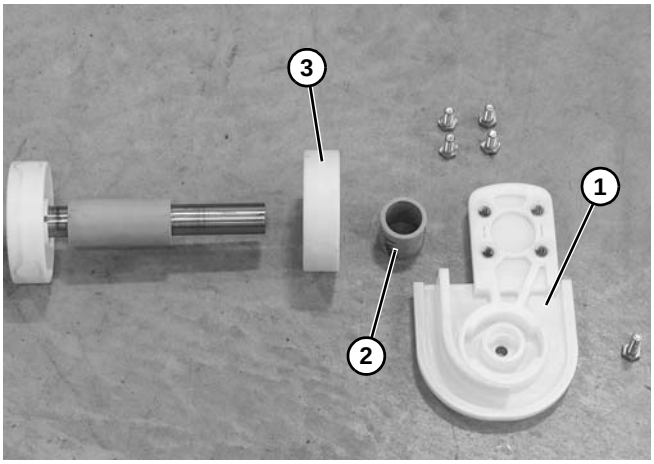



***Figure 58***

6. Slide off the round puck spacer **(Figure 58, item 2)**.
7. Slide off the puck and replace **(Figure 58, item 3)**.
8. Repeat as needed.

## Power Transfers

### Removal

1. Remove two hex head screws **(Figure 59, item 1)** and cover **(Figure 59, item 2)**.

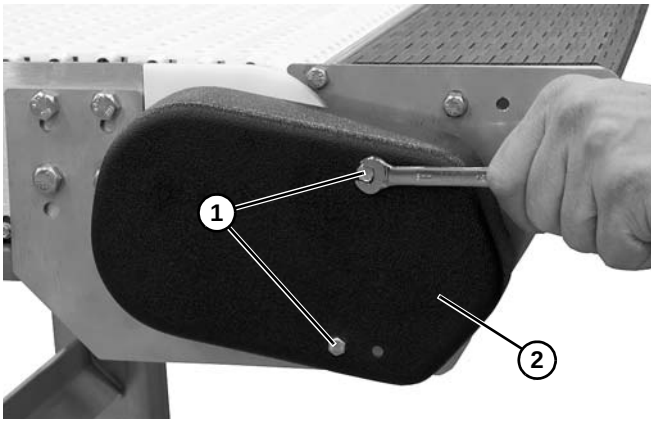



***Figure 59***

2. Loosen two hex head screws **(Figure 60, item 1)** holding tensioning bearing **(Figure 60, item 2)** against timing belt **(Figure 60, item 3)**.

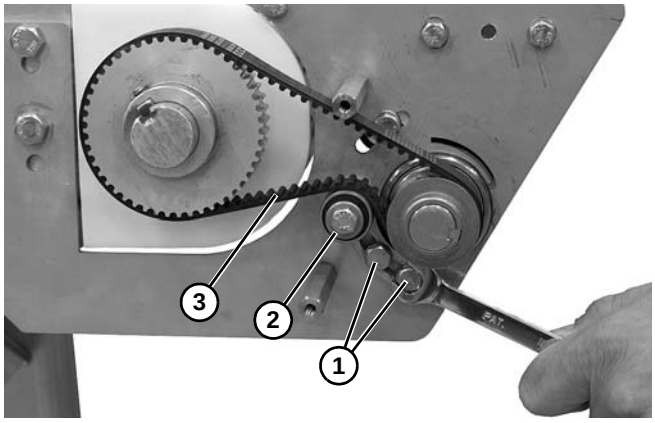



***Figure 60***

3. Remove timing belt **(Figure 61, item 1)**.

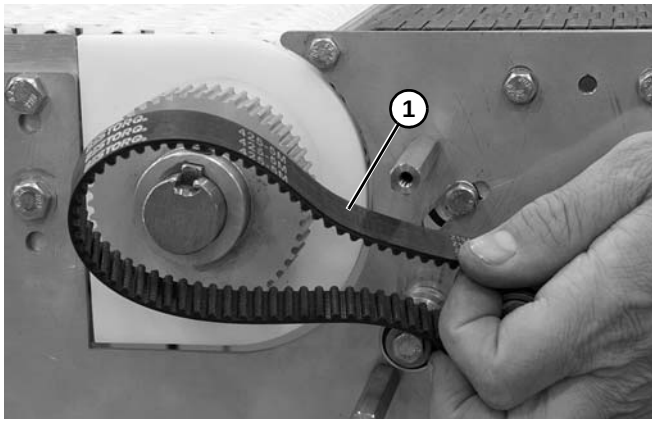



***Figure 61***

4. Loosen hex head screw **(Figure 62, item 1)** on both sides of the power transfer.

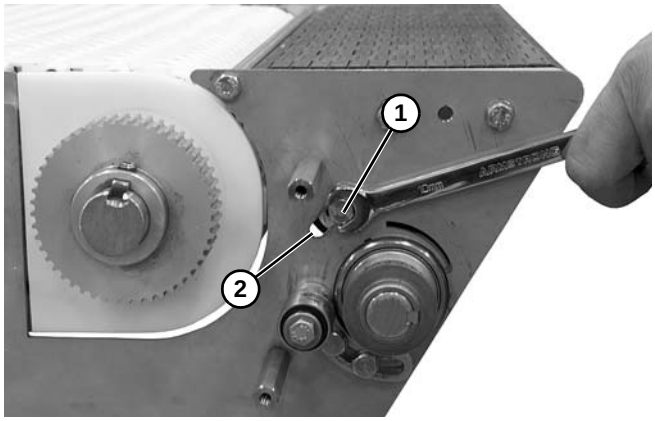



***Figure 62***

5. Slide idler assembly within slot **(Figure 62, item 2)** to remove tension on belt.

6. Lift slightly on belt **(Figure 63, item 1)** and push pin **(Figure 63, item 2)** out of belt.

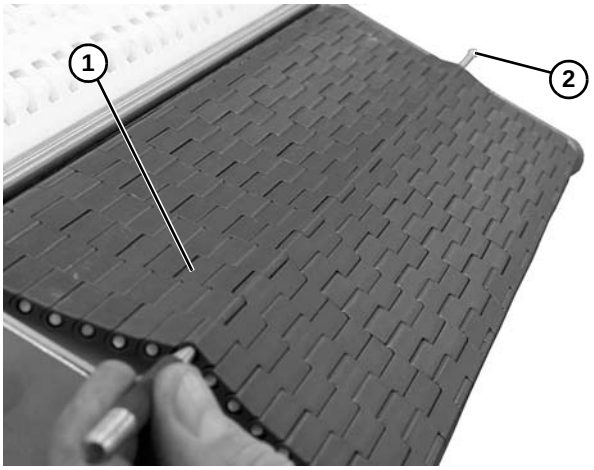



***Figure 63***

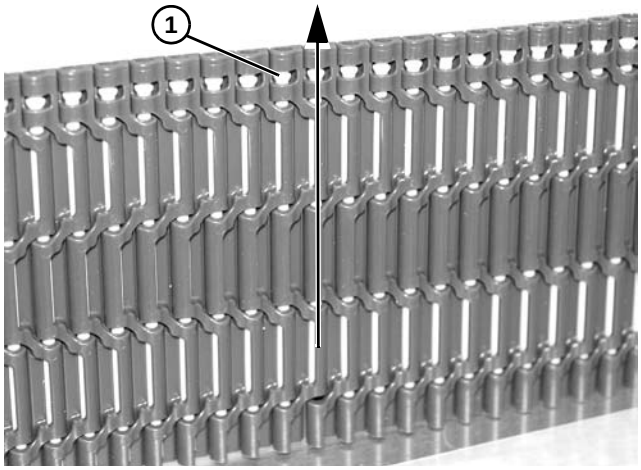



***Figure 64***

| NOTE |
| --- |
| *Note that head of pin **(Figure 64, item 1)** should be removed in direction shown.* |

7. Remove belt.

8. Remove two hex head screws **(Figure 65, item 1)** on both sides of the power transfer.

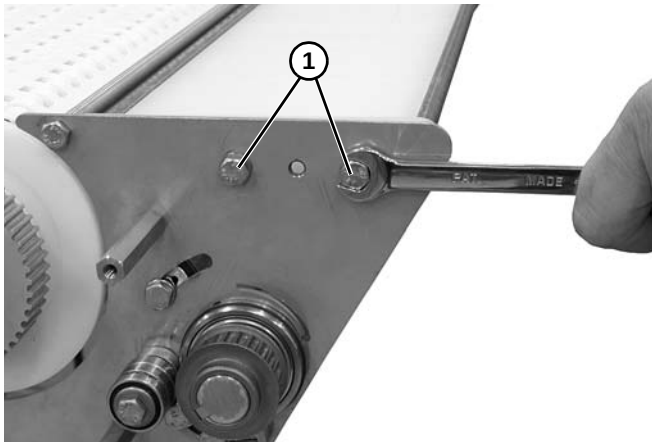



***Figure 65***

9. Remove the wear bar assembly **(Figure 66, item 1)** from the power transfer.

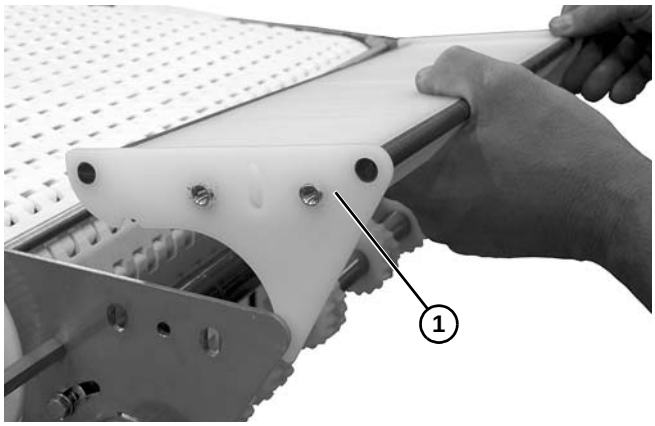



***Figure 66***

10. Disassemble side guide plates **(Figure 67, item 1)**, wear rods **(Figure 67, item 2)**, and wear bar **(Figure 67, item 3)**. Replace worn parts.

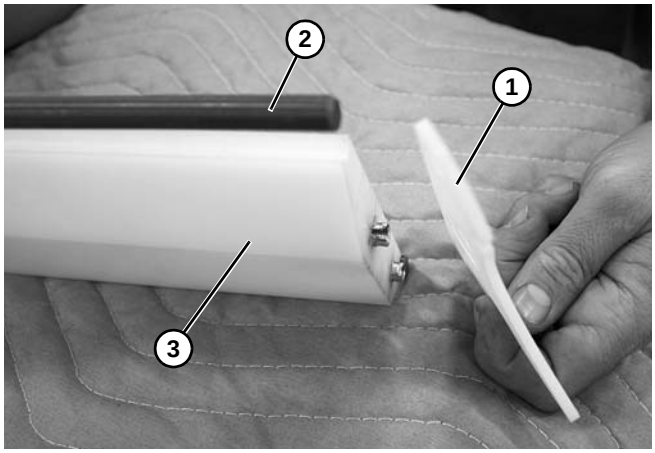



***Figure 67***

11. Remove hex head screw **(Figure 68, item 1)** on both sides of the power transfer and remove idler assembly.

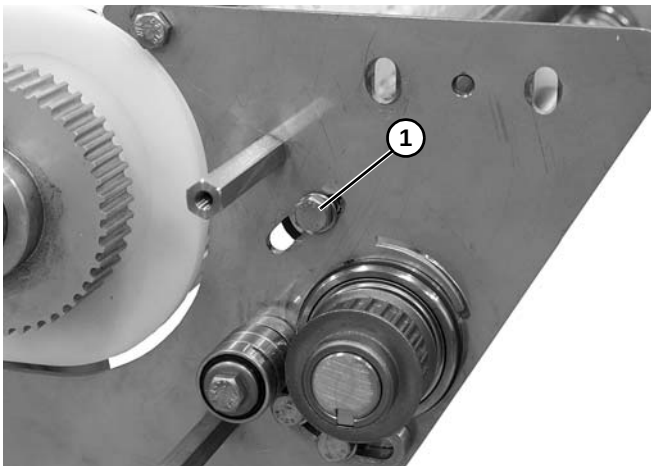



***Figure 68***

12. Replace the idler assembly and install hex head screws to secure.
13. Loosen two set screws **(Figure 69, item 1)** on bearing **(Figure 69, item 2)** on both sides of the power transfer.

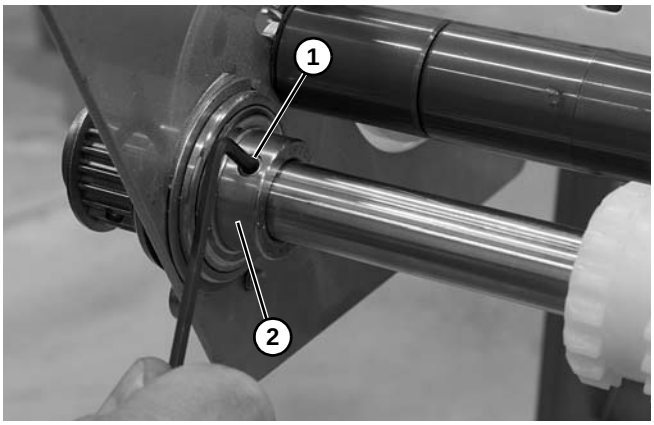



***Figure 69***

14. Loosen set screw **(Figure 70, item 1)** on drive sprocket **(Figure 70, item 2)**.

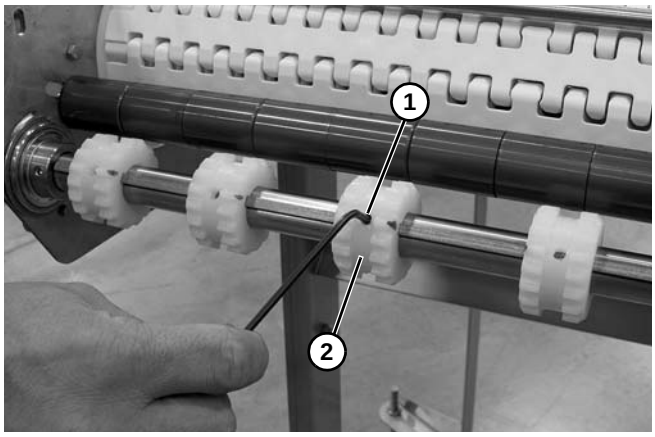



***Figure 70***

15. While removing drive shaft **(Figure 71, item 1)**, slide drive sprockets **(Figure 71, item 2)** and shaft key **(Figure 71, item 3)** from shaft.

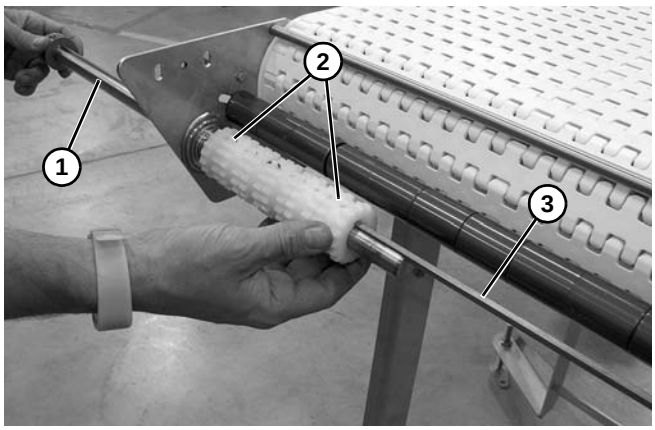



***Figure 71***

## Installation

1. Insert drive shaft **(Figure 72, item 1)** through bearing **(Figure 72, item 2)**.

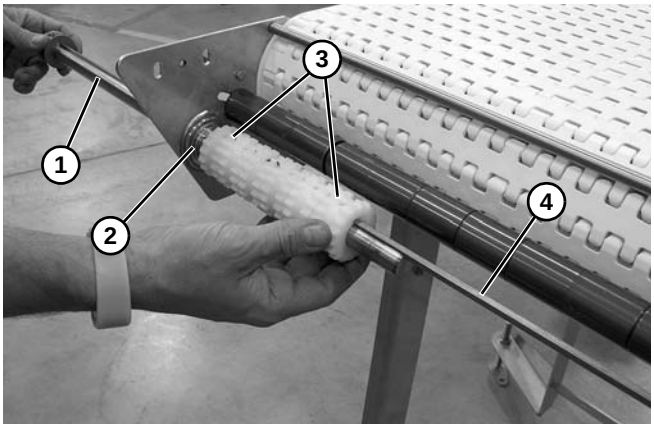



***Figure 72***

2. Slide drive sprockets **(Figure 72, item 3)** and shaft key **(Figure 72, item 4)** onto shaft while pushing shaft through bearing.
3. Insert drive shaft through opposite bearing **(Figure 73, item 1)** and press outward on bearings as shown.

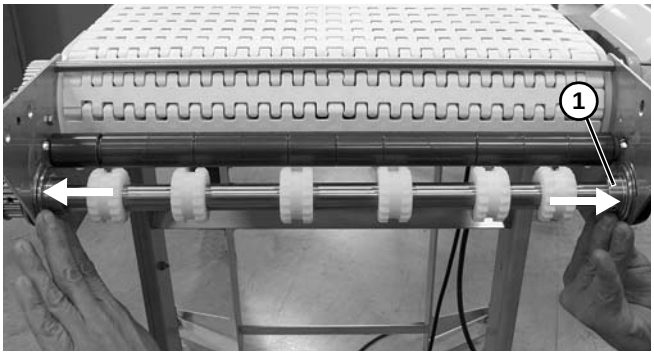



***Figure 73***

4. Tighten set screw **(Figure 74, item 1)** on drive sprocket **(Figure 74, item 2)**.

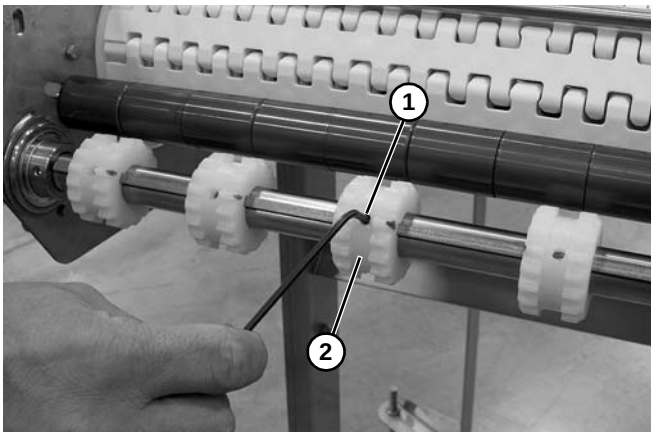



***Figure 74***

5. Tighten two set screws **(Figure 75, item 1)** on bearing **(Figure 75, item 2)** on both sides of the power transfer.

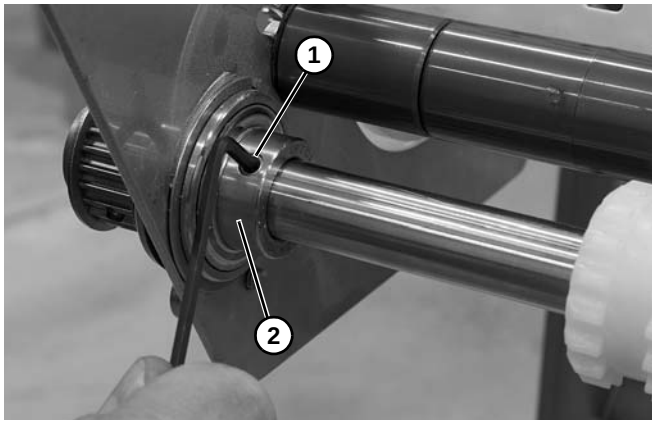



***Figure 75***

6. Raise belt **(Figure 76, item 1)** into position. Move drive sprockets **(Figure 76, item 2)** so that the teeth line up with the belt, as shown.

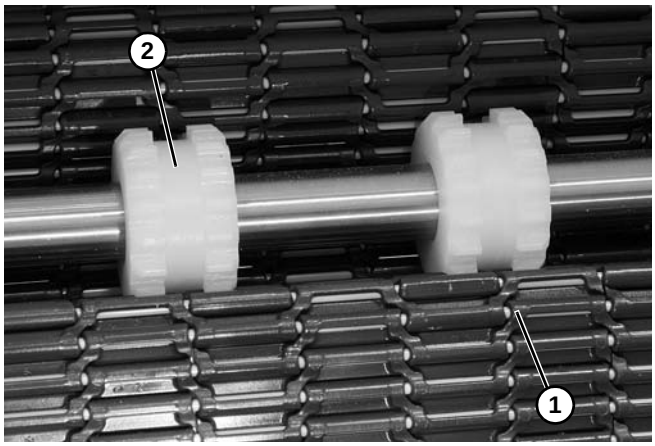



***Figure 76***

7. Install support bar assembly **(Figure 77, item 1)** with two hex head screws **(Figure 77, item 2)** on both sides of the power transfer.

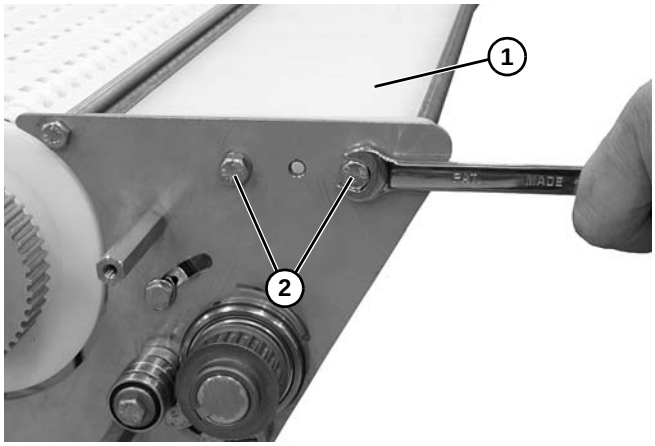



***Figure 77***

8. Guide belt **(Figure 78, item 1)** through idler assembly. Route the belt under the sprocket **(Figure 78, item 2)** and over idler assembly **(Figure 78, item 3)**.

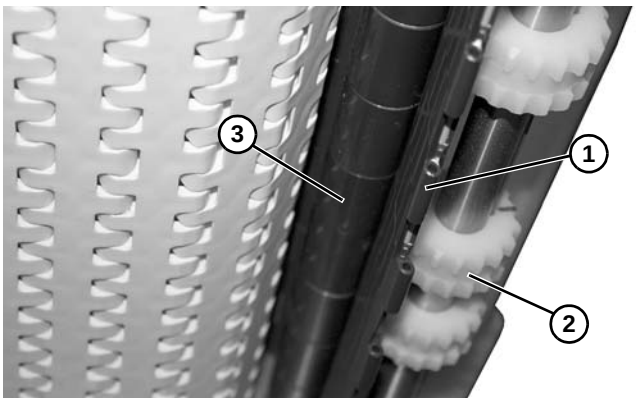



*Figure 78*

9. Bring ends of belt together and install pin **(Figure 79, item 1)**.


*Figure 79*

10. Slide idler assembly within slot **(Figure 80, item 1)** to remove excess slack from belt **(Figure 80, item 2)**. Tighten hex head screws **(Figure 80, item 3)**.

**⚠ CAUTION**

**DO NOT overtighten belt or excessive wear will occur.**

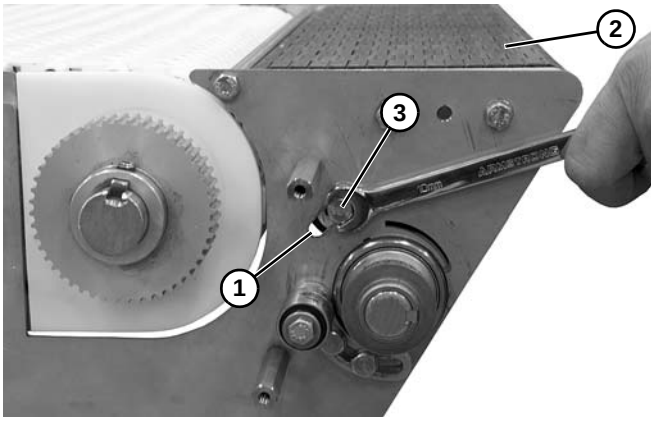



*Figure 80*

11. Rotate drive shaft **(Figure 81, item 1)** to verify tightness of belt **(Figure 81, item 2)**. Belt should turn freely. Loosen hex head screw **(Figure 81, item 3)** on both sides and adjust, if necessary.

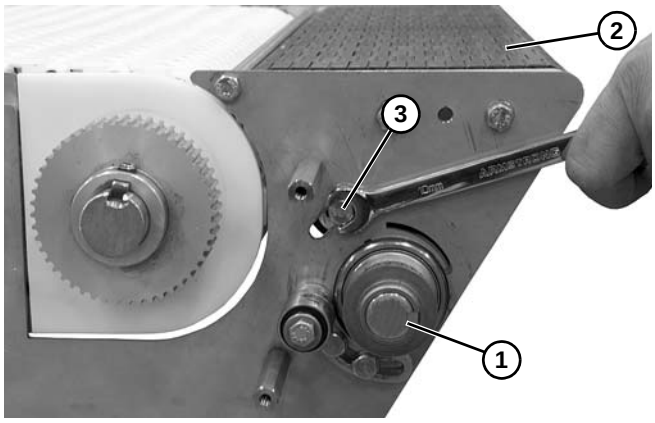



*Figure 81*

12. Route and install belt **(Figure 82, item 1)** as shown. Press up on tensioner **(Figure 82, item 2)** and tighten two hex head screws **(Figure 82, item 3)**.

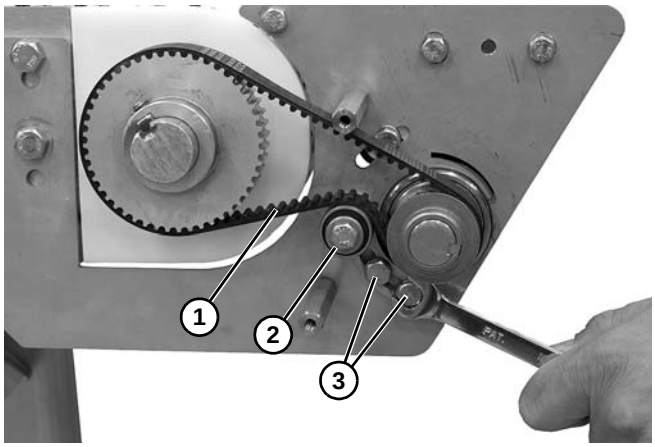



*Figure 82*

13. Install cover **(Figure 83, item 1)** with two hex head screws **(Figure 83, item 2)**.

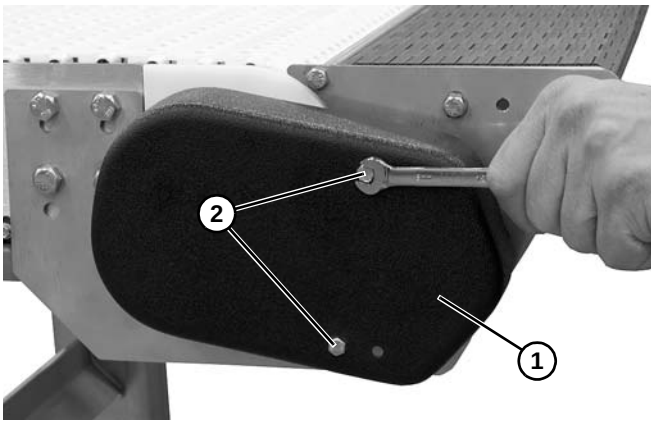



***Figure 83***

14. Adjust height as needed by loosening two hex head screws **(Figure 84, item 1)** on both sides of the power transfer. Tighten screws.

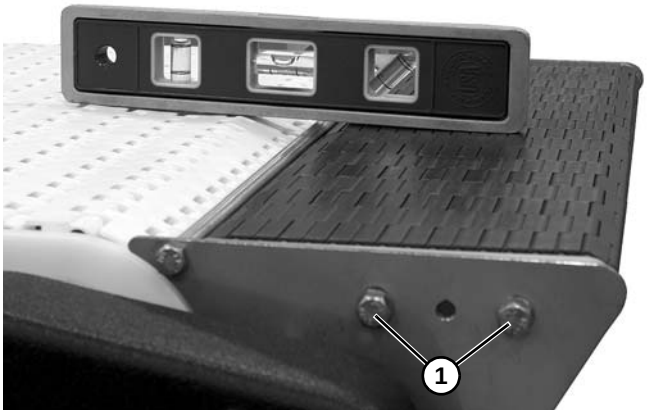



***Figure 84***

## Bearing Replacement

**WARNING**

**SEVERE HAZARD!**

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

### Drive Bearing Removal and Replacement

**WARNING**

**PUNCTURE HAZARD!**

**Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.**

1. Refer to “Drive Sprocket and Spindle Replacement” on page 19. Follow steps 1 through 7.
2. Twist the bearing out **(Figure 85, item 1)**.

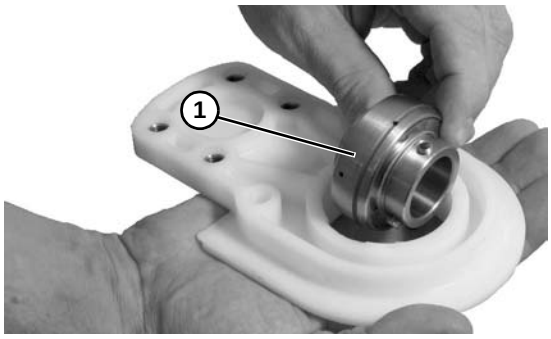



***Figure 85***

3. Replace the bearing.

## Gravity Take-Up

### Removal

1. Lift up the belt near the tail end of the conveyor, or near a straight section. Locate the rod head with a slot **(Figure 86, item 1)**.

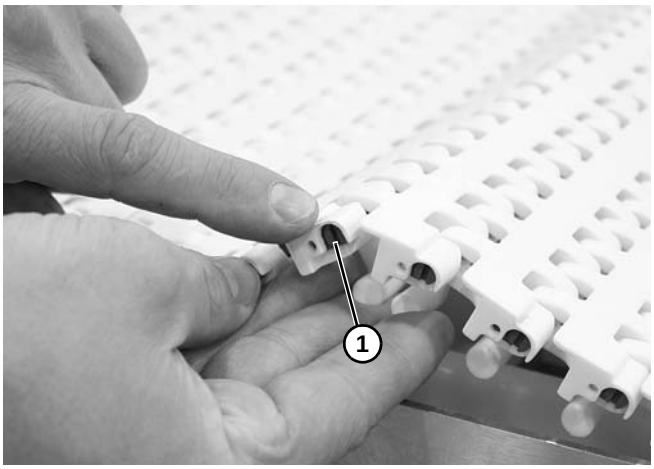



***Figure 86***

2. Insert a flat blade screwdriver into the slot on the rod head **(Figure 87, item 1)** and rotate the rod head counterclockwise to unlock. Remove the belt rod.

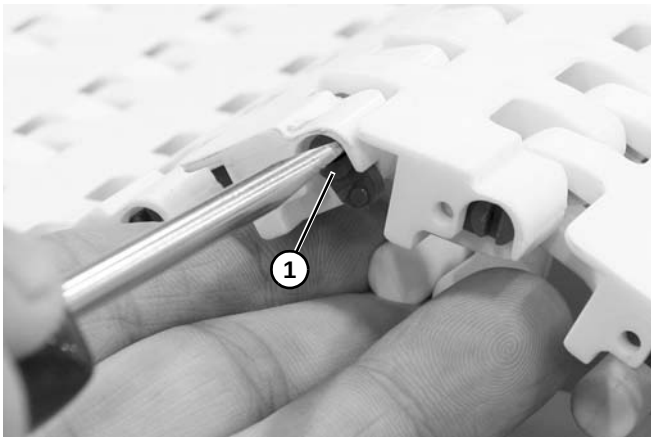



***Figure 87***

3. Disconnect the ends of the belt.

4. Remove two screws **(Figure 88, item 1)** and belt guide **(Figure 89, item 2)**. Repeat on opposite side.

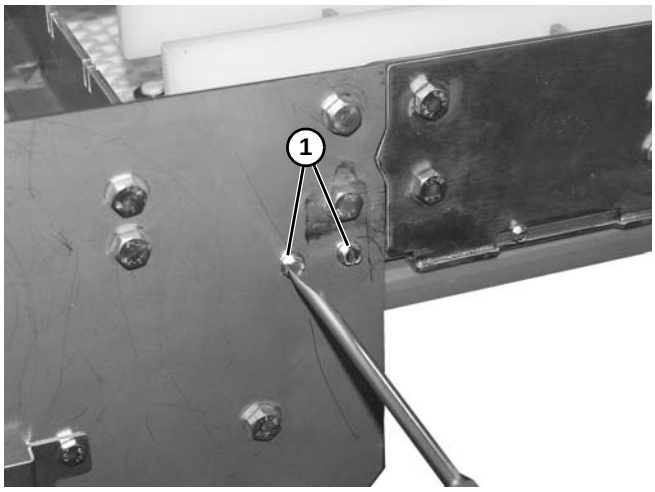



***Figure 88***

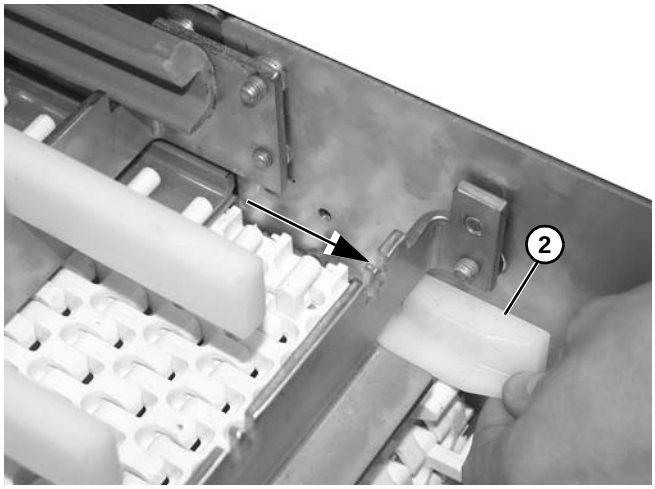



***Figure 89***

5. Remove two hex head screws **(Figure 90, item 1)** on each side, and remove guard plate **(Figure 90, item 2)**.

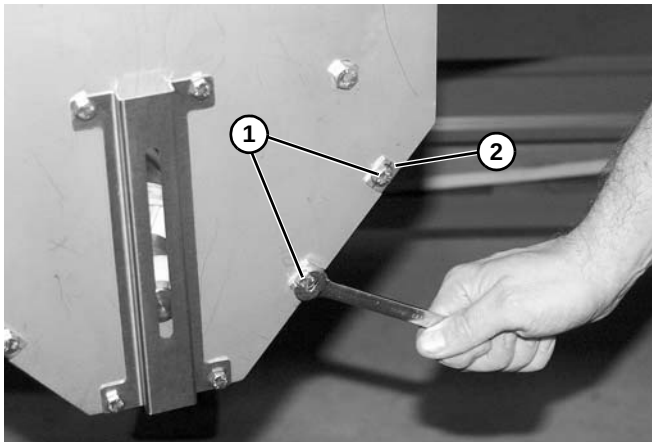



***Figure 90***

6. Remove four hex head screws **(Figure 91, item 1)**, and remove guard **(Figure 91, item 2)**. Repeat on opposite side.

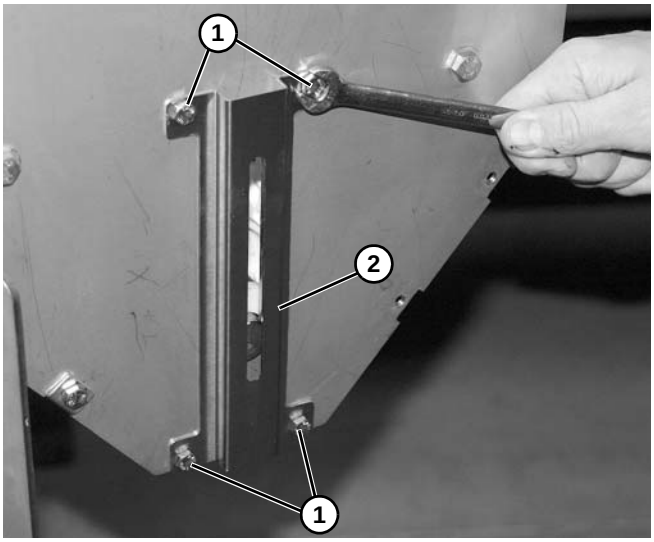



***Figure 91***

7. Remove the end of the belt from around the gravity take-up **(Figure 92, item 1)**.

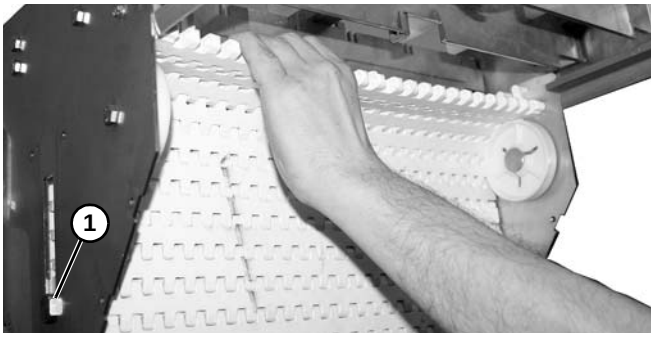



***Figure 92***

8. Tilt one end down and the opposite end upward, and remove gravity take-up assembly **(Figure 93, item 1)**.

| NOTE |
| --- |
| *Be careful as you lower take-up assembly. Parts are loose.* |

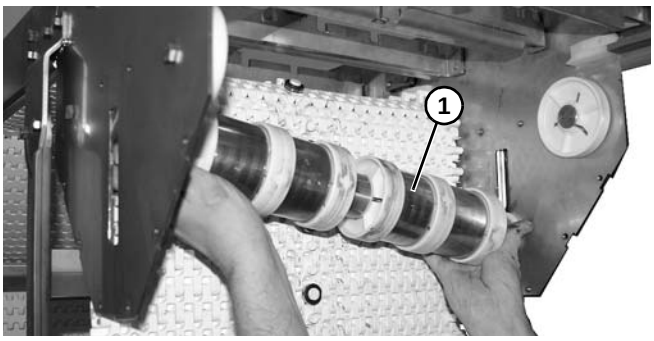



***Figure 93***

9. Remove bushing **(Figure 94, item 1)** and spacer **(Figure 94, item 2)** from end of take-up assembly.

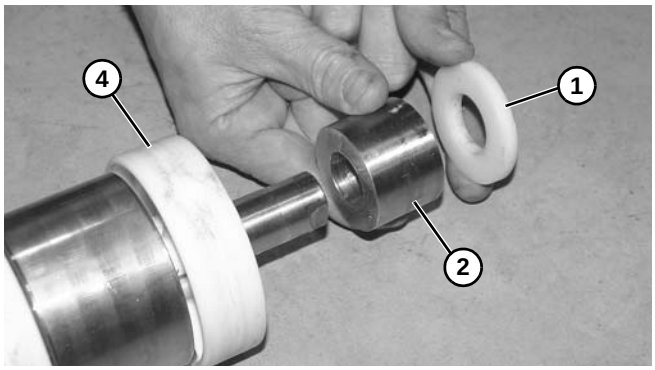



***Figure 94***

10. Remove idler puck **(Figure 94, item 3)** from end of take-up assembly.
11. Remove remaining components, as needed.
12. Remove hex head screw **(Figure 95, item 1)** and puck **(Figure 96, item 2)**. Repeat on opposite side.

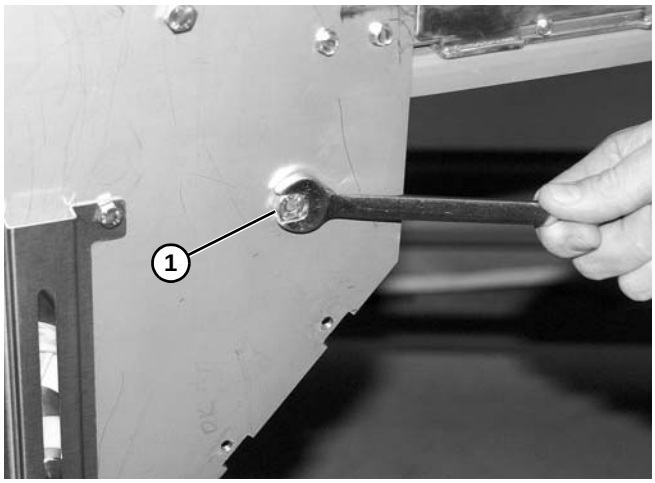



***Figure 95***

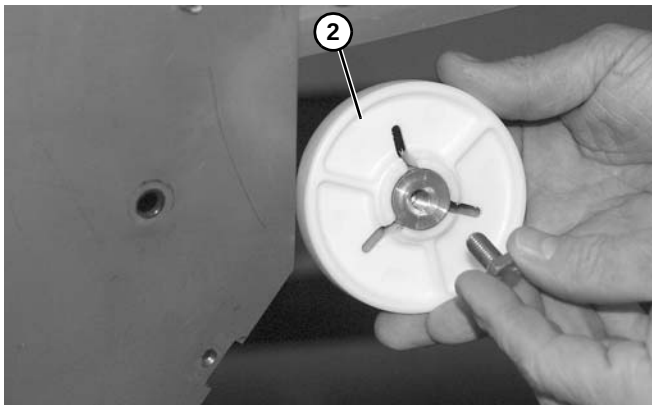



***Figure 96***

## Installation

1. Install puck **(Figure 98, item 1)** with hex head screw **(Figure 97, item 2)**. Repeat on opposite side.

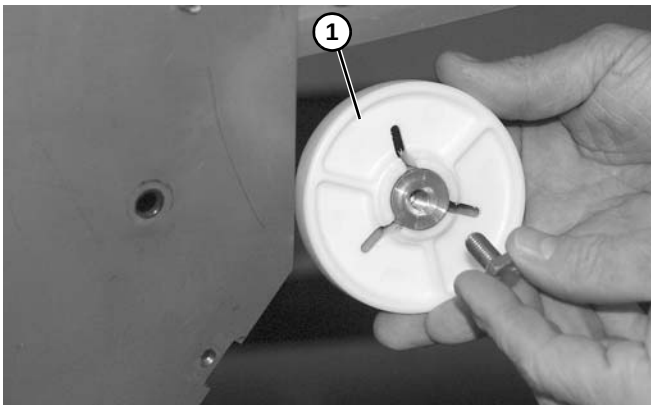



***Figure 97***

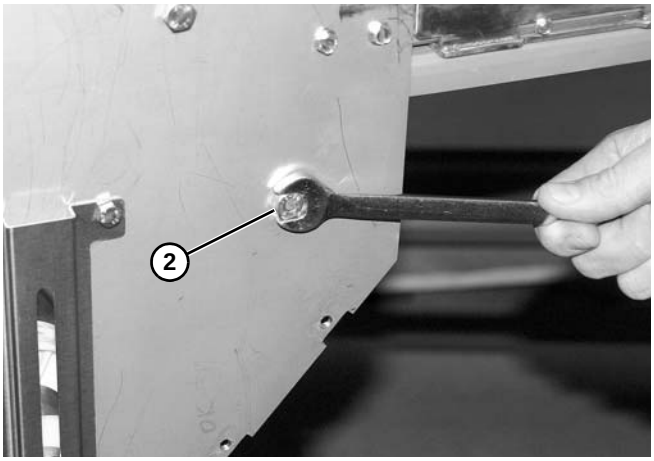



***Figure 98***

2. Install idler puck **(Figure 99, item 1)** onto the end of take-up assembly.

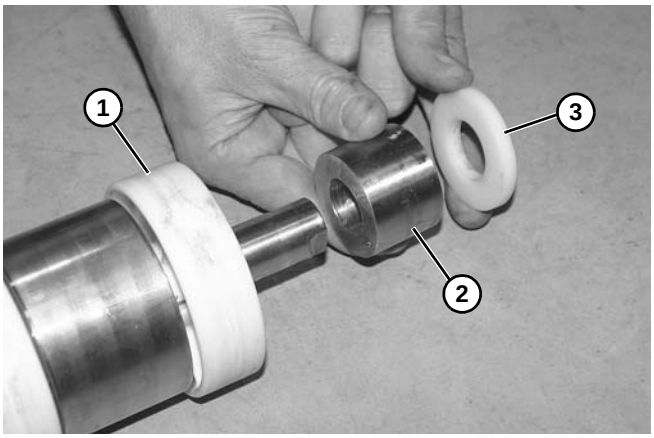



***Figure 99***

3. Install spacer **(Figure 99, item 2)** and bushing **(Figure 99, item 3)** onto the end of take-up assembly.

4. Tilt one end down and the opposite end upward, and install gravity take-up assembly **(Figure 100, item 1)**.

| NOTE |
| --- |
| *Be careful as you raise take-up assembly into position. Parts are loose.* |

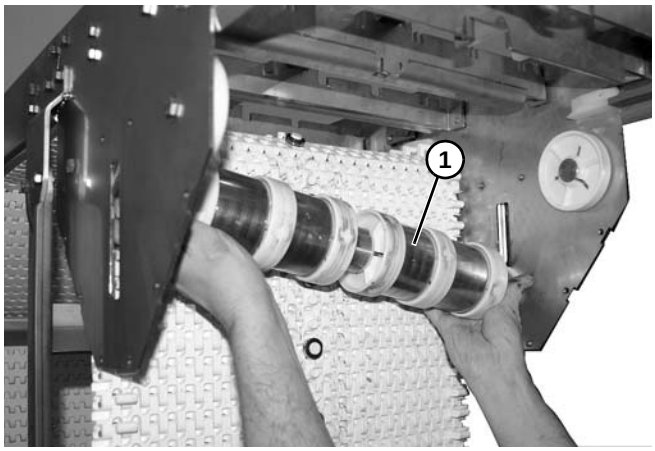



***Figure 100***

5. Lower take-up assembly so that shaft tapered end **(Figure 101, item 1)** fits into slotted end **(Figure 101, item 2)** on frame.

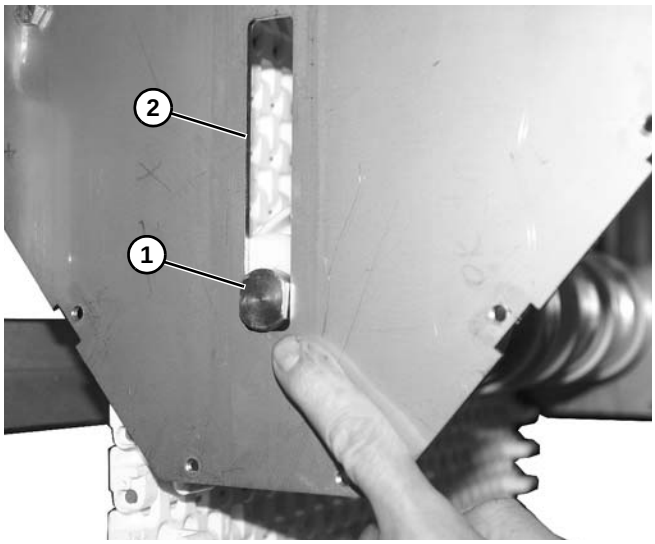



***Figure 101***

6. Install belt guide **(Figure 102, item 1)** with two screws **(Figure 103, item 2)**. Repeat on opposite side.

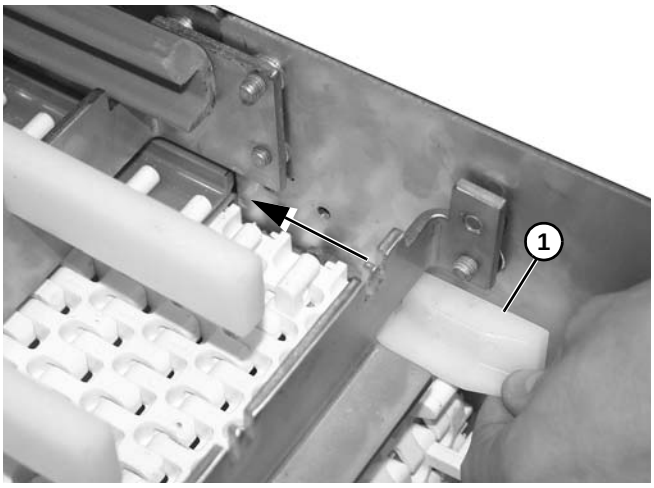



***Figure 102***

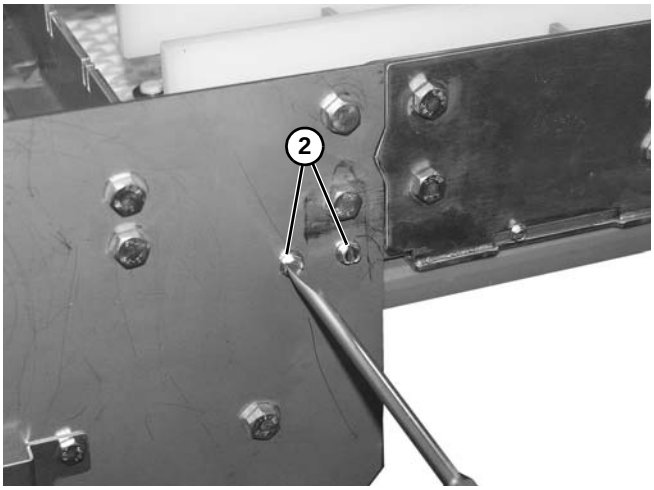



***Figure 103***

7. Install the end of the belt around the gravity take-up **(Figure 104, item 1)** and to the opposite end of conveyor.

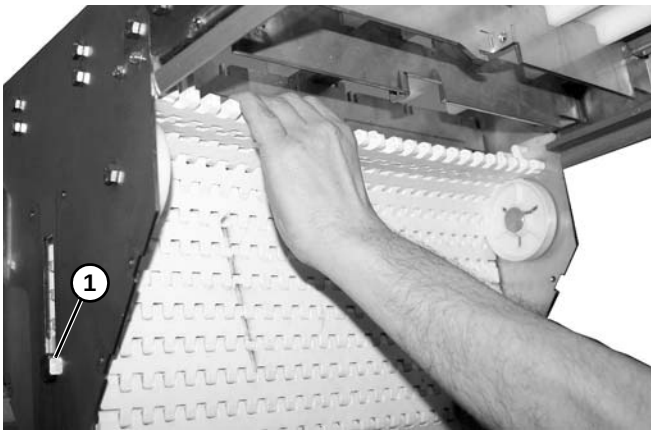



***Figure 104***

| NOTE |
| --- |
| *Be certain that belt tab **(Figure 105, item 1)** rides onto belt guide **(Figure 105, item 2)**.* |

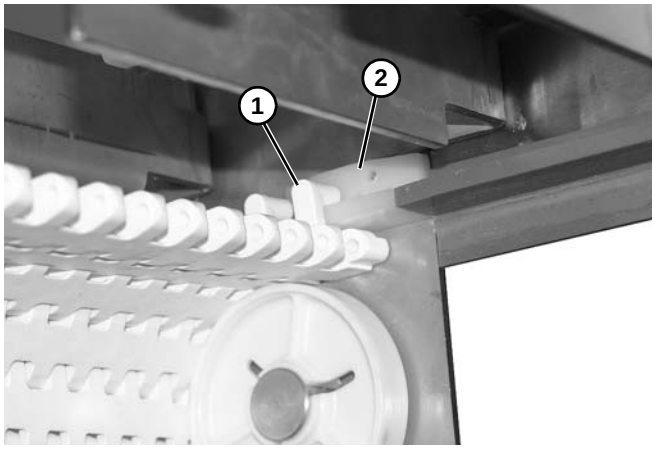



***Figure 105***

8. Continue feeding belt around the gravity take-up **(Figure 106, item 1)**.

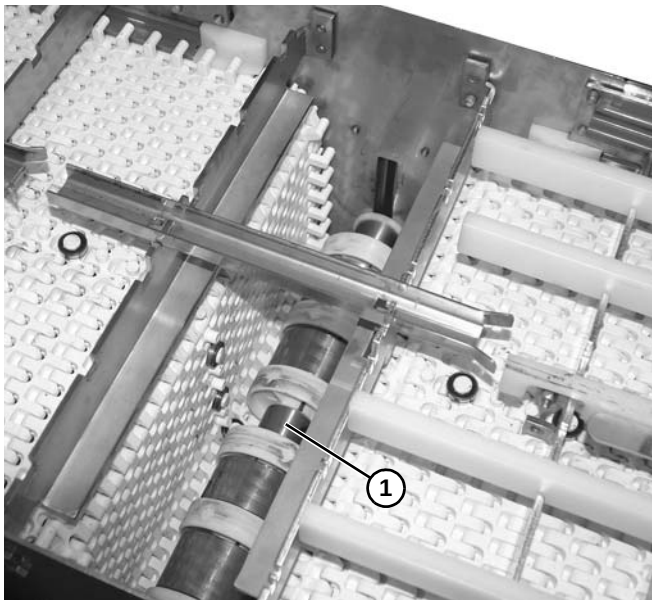



***Figure 106***

9. Bring the ends of the belt together **(Figure 107)**.

***Figure 107***

10. Insert the belt rod **(Figure 108, item 1)** and push it through the belt.

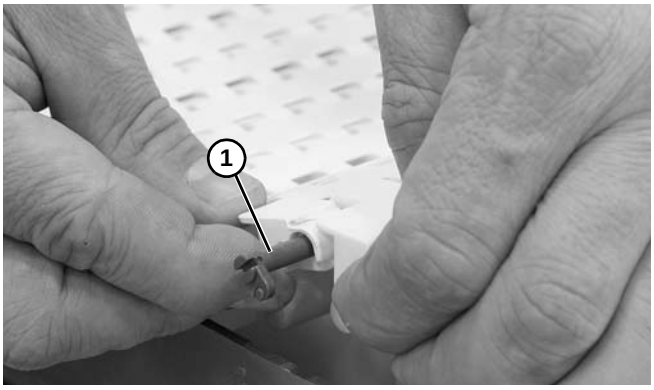



***Figure 108***

11. Insert a flat blade screwdriver into the slot on the rod head **(Figure 109, item 1)**. Rotate rod head clockwise into the locked position **(Figure 109, item 2)**.

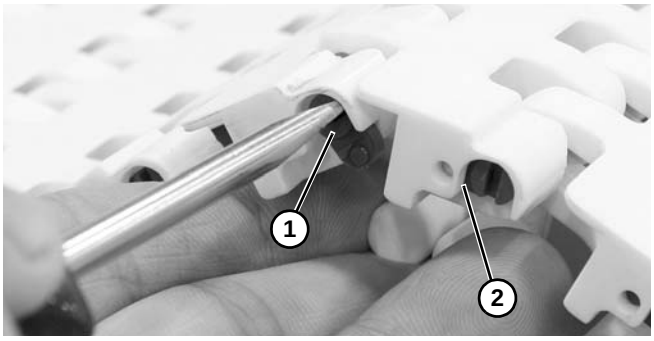



***Figure 109***

12. Install guard **(Figure 110, item 1)**, with four hex head screws **(Figure 110, item 2)**. Repeat on opposite side.

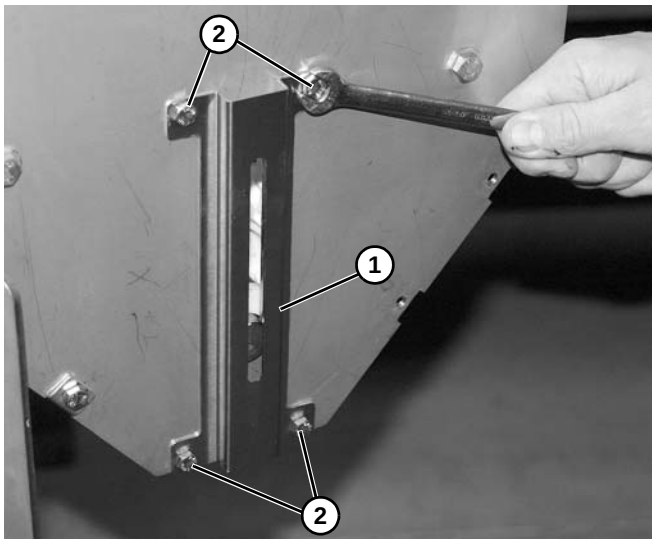



***Figure 110***

13. Install guard plate **(Figure 111, item 1)** with two hex head screws **(Figure 111, item 2)** on each side.

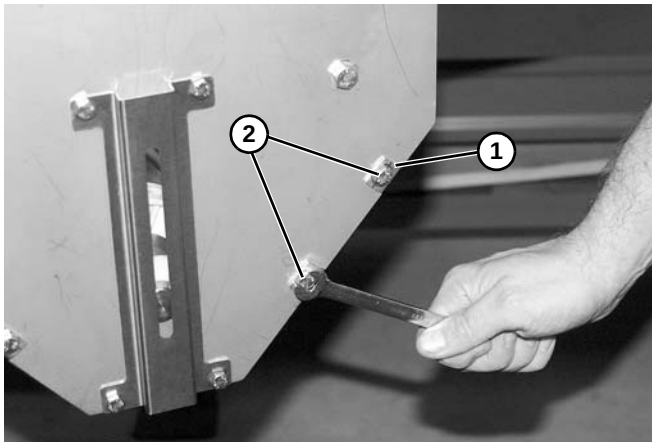


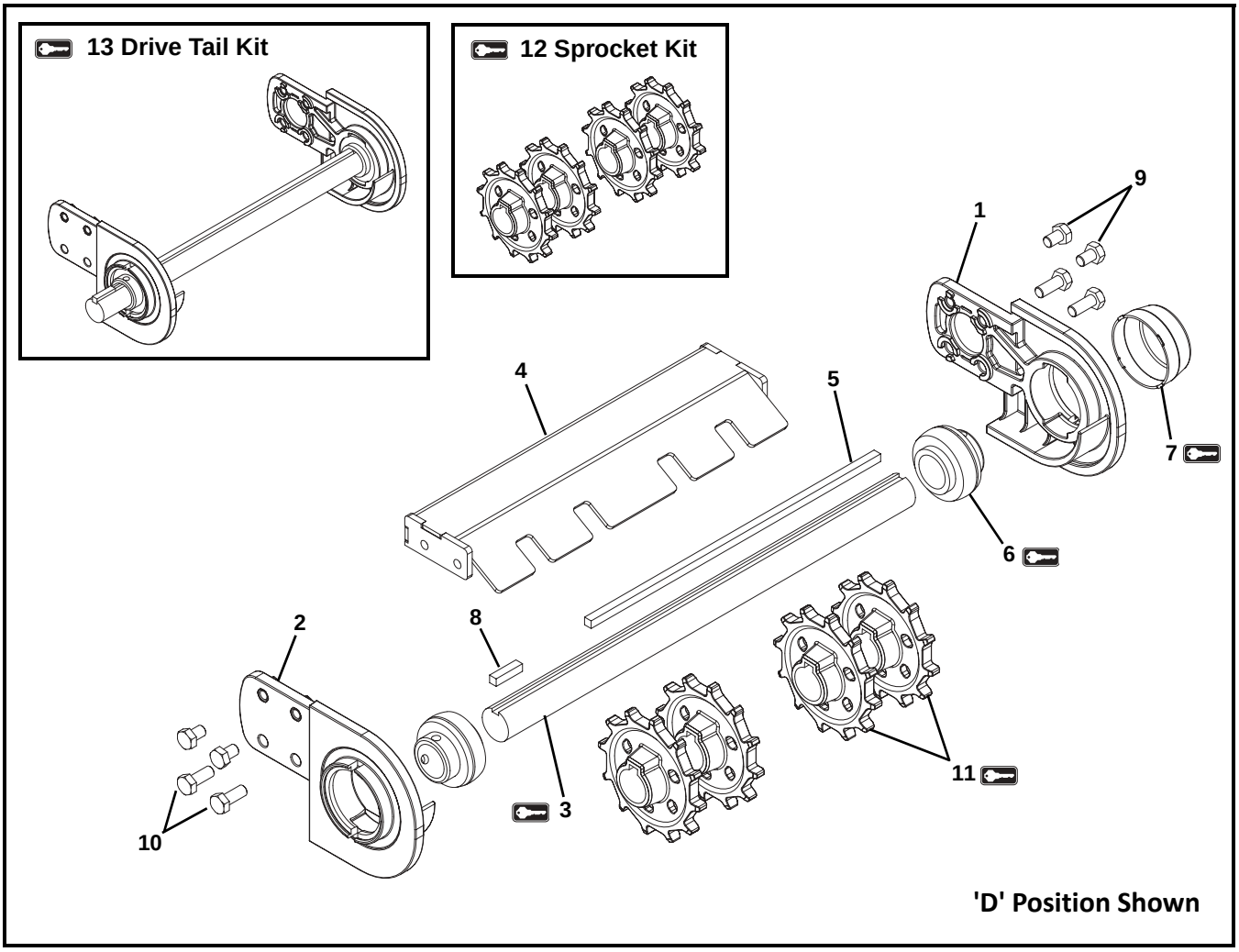

***Figure 111***

# Notes

**NOTE**

*For replacement parts other than those shown in this section, contact an authorized Dorner distributor or Dorner directly. Recommended Critical Service Parts and Kits are identified by the Key Service Parts symbol . Dorner recommends keeping these parts on hand.*

## End Drive Tail




| Item | Part Number | Description |
|---|---|---|
| 1 | 516809 | Headplate, Left Hand |
| 2 | 516811 | Headplate, Right Hand |
| 3 | 516815-K0-WW | Spindle |
| | 516815-KK-WW | Dual Shaft Spindle |
| 4 | 516839-WW | Support Bracket |
| 5 | 532121-LLLLL | Square Key |
| 6 | 802-161 | Bearing |
| 7 | 807-1454 | Bearing Cap |
| 8 | 912-108SS | Square Key, .25" x 1.00" |
| 9 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |
| 10 | 960820MSS | Hex Head Cap Screw, M8-1.25 x 20 mm |

| Item | Part Number | Description |
|---|---|---|
| 11 | FXSPT-12T | Sprocket |
| 12 | 520361-WW | Sprocket Kit (Includes item 11) |
| 13 | 520362-K0-WW | Drive Tail Kit (Includes items 1, 2, 3, 5, 6 and 8) |
| | 520362-KK-WW | Dual Shaft Drive Tail Kit (Includes items 1, 2, 3, 5, 6 and 8) |

WW = Conveyor width reference in inches 06, 12, 18, 24

See Specifications chart on page 4 for conveyor belt widths.

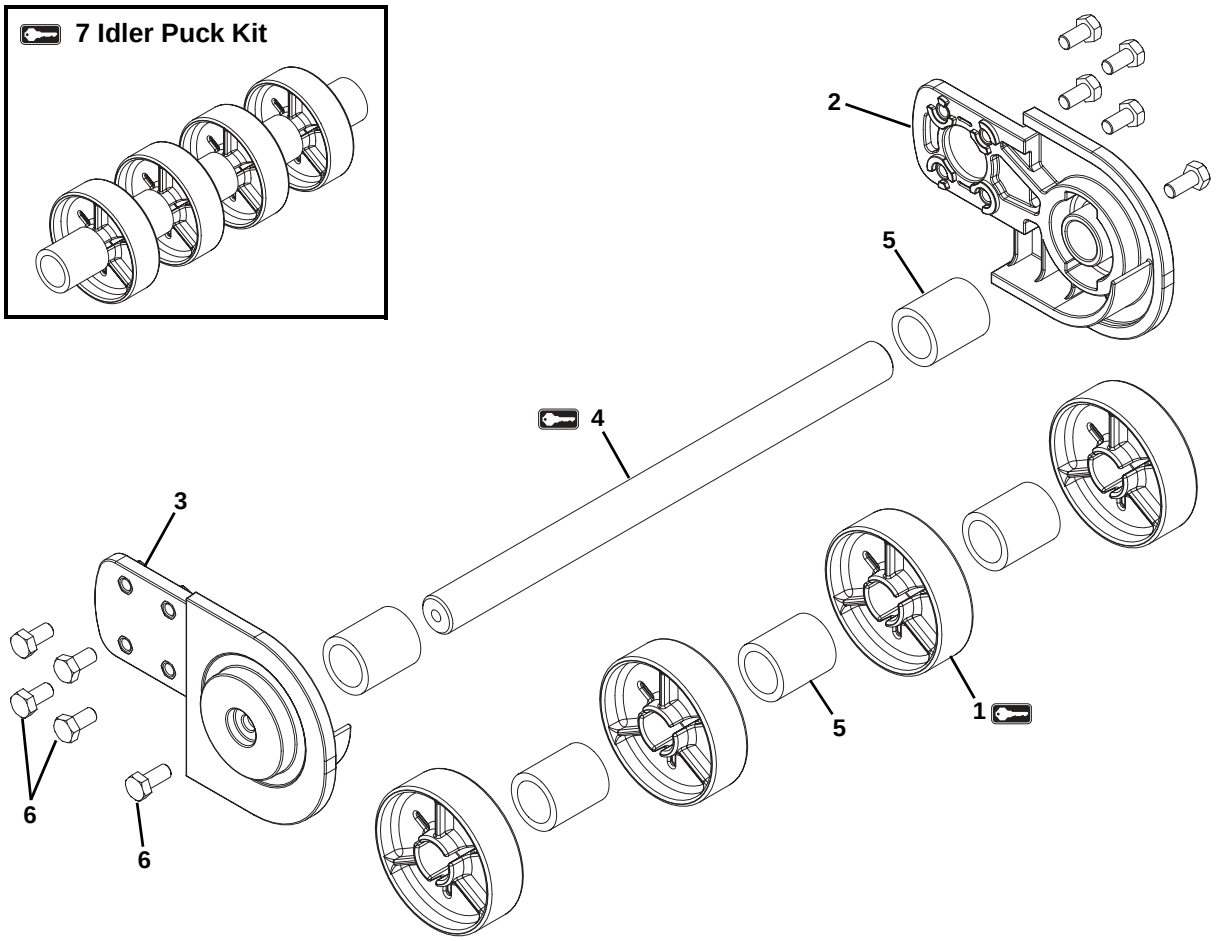
LLLLL = Part length in inches with 2 decimal places.

Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

# Service Parts

## Idler Tail




| Item | Part Number | Description |
|---|---|---|
| 1 | 506296 | Idler Puck |
| 2 | 516805 | Headplate, Left Hand |
| 3 | 516807 | Headplate, Right Hand |
| 4 | 516823-00-WW | Spindle |
| 5 | 532127-LLLLL | Spacer |
| 6 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 7 | 520375-WW | Idler Puck Kit (Includes items 1 and 5) |

WW = Conveyor width reference in inches 06, 12, 18, 24

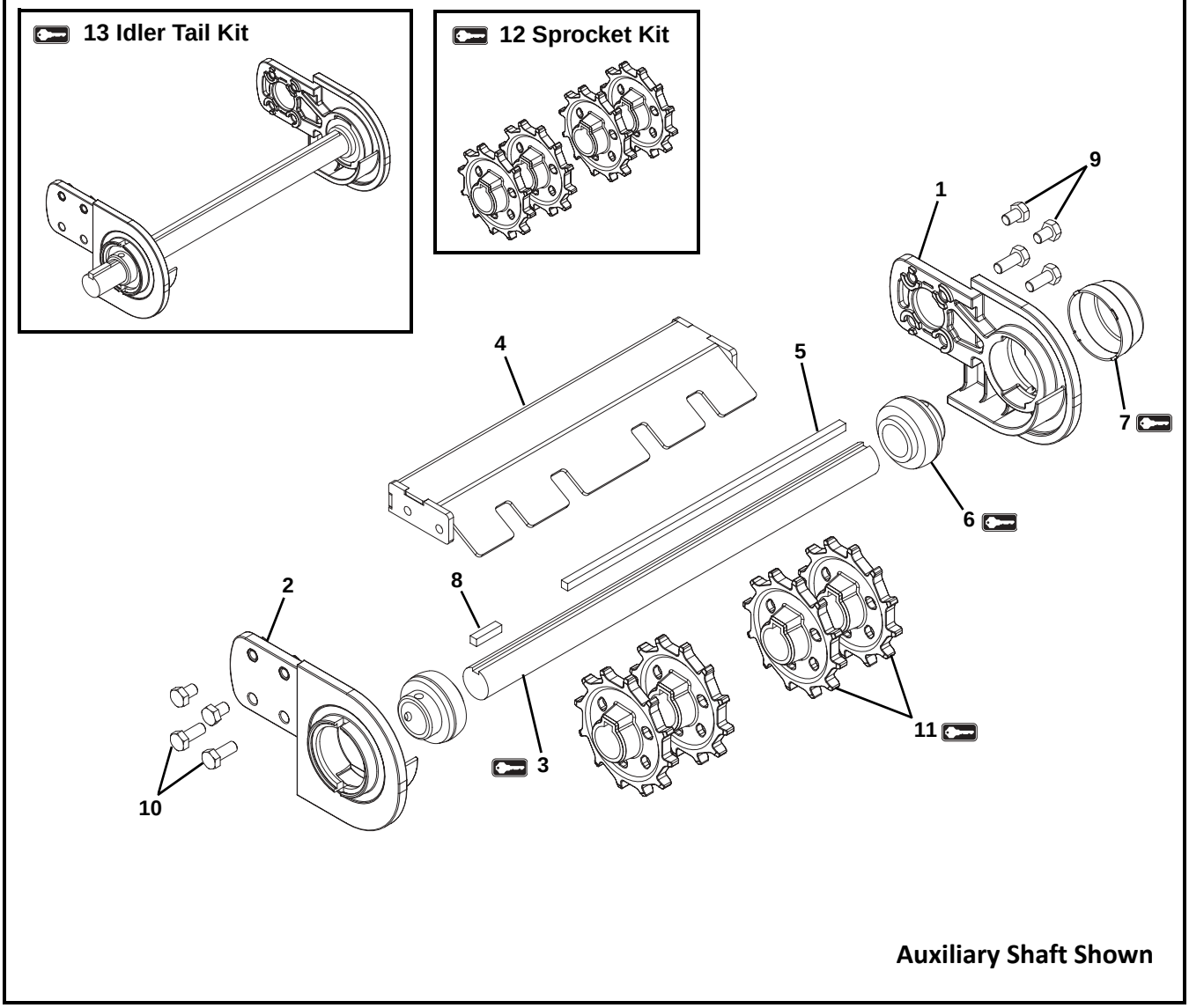
See Specifications chart on page 4 for conveyor belt widths.

LLLLL = Part length in inches with 2 decimal places.

Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

## Idler Tail with Auxiliary Shaft




| Item | Part Number | Description |
|---|---|---|
| 1 | 516809 | Headplate, Left Hand |
| 2 | 516811 | Headplate, Right Hand |
| 3 | 516815-K0-WW | Spindle |
| 4 | 516839-WW | Support Bracket |
| 5 | 532121-LLLLL | Square Key |
| 6 | 802-161 | Bearing |
| 7 | 807-1454 | Bearing Cap |
| 8 | 912-108SS | Square Key, .25" x 1.00" |
| 9 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |
| 10 | 960820MSS | Hex Head Cap Screw, M8-1.25 x 20 mm |
| 11 | FXSPT-12T | Sprocket |

| Item | Part Number | Description |
|---|---|---|
| 12 | 520361-WW | Sprocket Kit (Includes item 11) |
| 13 | 520362-K0-WW | Idler Tail Kit (Includes items 1, 2, 3, 5, 6 and 8) |

WW = Conveyor width reference in inches 06, 12, 18, 24

See Specifications chart on page 4 for conveyor belt widths.

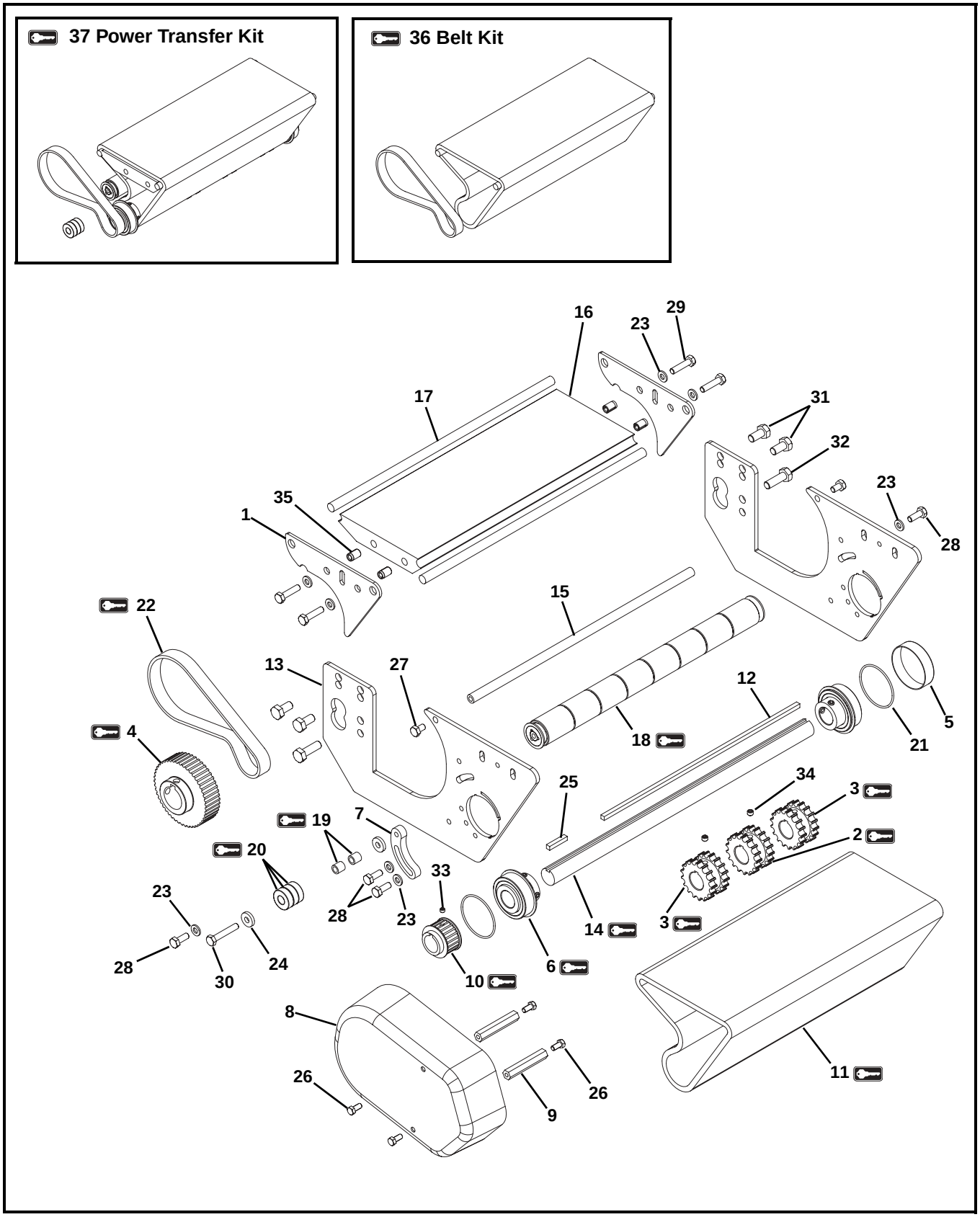
LLLLL = Part length in inches with 2 decimal places.

Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

# Service Parts

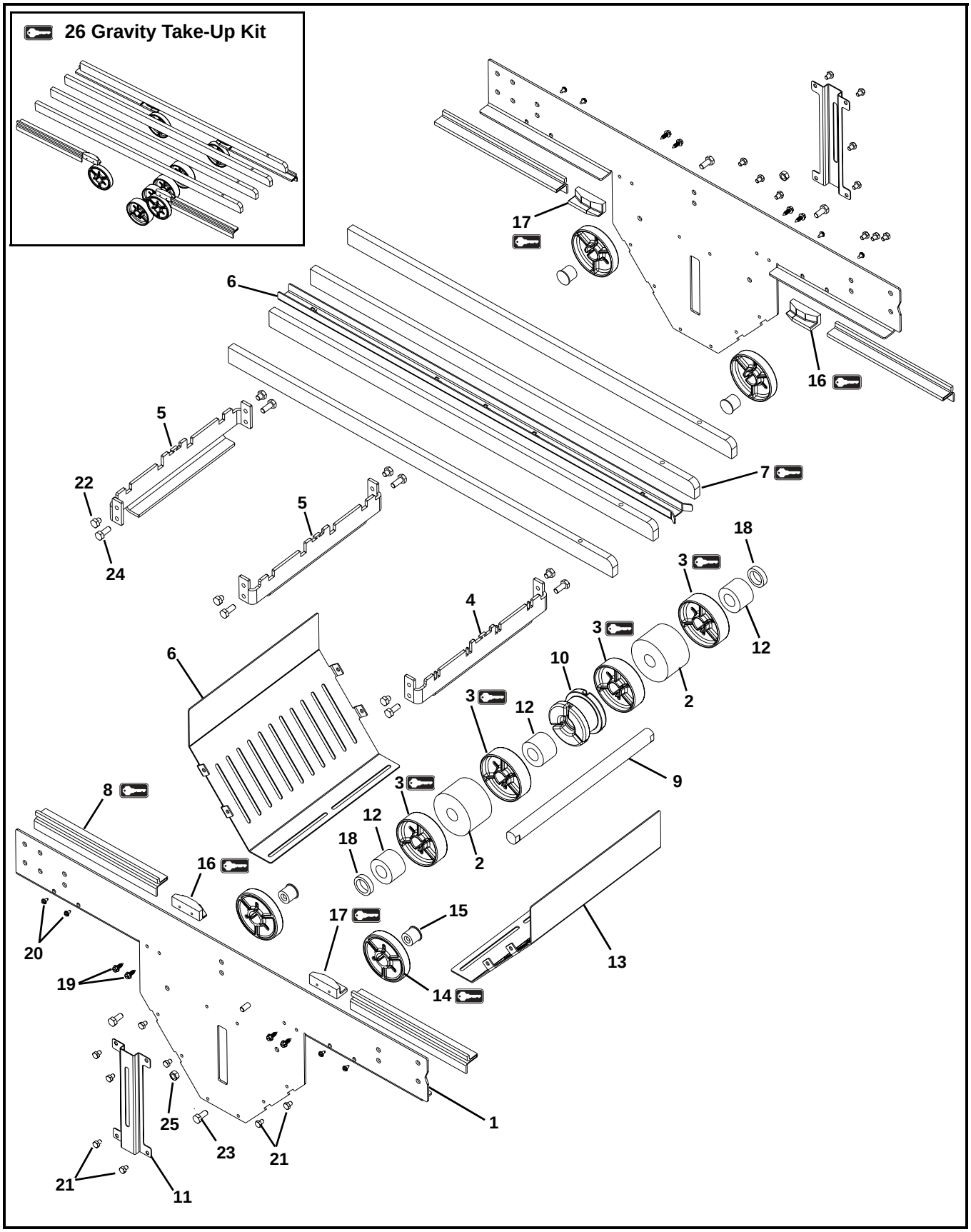
## Power Transfer



| Item | Part Number | Description |
|---|---|---|
| 1 | 203229 | Plate |
| 2 | 203765 | Center Sprocket |
| 3 | 203765P | Sprocket |
| 4 | 509855 | Pulley 48T |
| 5 | 514644 | Bearing Cover |
| 6 | 514647 | Bearing |
| 7 | 516897 | Tensioner |
| 8 | 516981 | Cover |
| 9 | 516982 | Spacer |
| 10 | 518497 | Pulley 22T |
| 11 | 2P-WW/01 | Power Transfer Belt |
| 12 | 350789-WW | Square Key |
| 13 | 516888D | Side Plate |
| 14 | 516891-WW | Spindle |
| 15 | 516896-WW | Pinch Guard |
| 16 | 516901-WW | Support Bar |
| 17 | 516979-WW | Bar |
| 18 | 518498-WW | Idler Assembly |
| 19 | 801-139 | Nylon Bearing |
| 20 | 802-123 | Bearing |
| 21 | 812-097 | O-Ring |
| 22 | 814-096 | Belt |
| 23 | 911-222 | Washer |
| 24 | 911-527 | Washer |
| 25 | 912-080SS | Square Key, .1875" x 1.00" |
| 26 | 960510MSS | Hex Head Cap Screw, M5-0.80 x 10 mm |
| 27 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 28 | 960616MSS | Hex Head Cap Screw, M6-1.00 x 16 mm |
| 29 | 960625MSS | Hex Head Cap Screw, M6-1.00 x 25 mm |
| 30 | 960635MSS | Hex Head Cap Screw, M6-1.00 x 35 mm |
| 31 | 960816MSS | Hex Head Cap Screw, M8-1.25 x 16 mm |
| 32 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| 33 | 970504MSS | Set Cup Screw, M5-0.80 x 5 mm |
| 34 | 970605M | Set Cup Screw, M6-1.00 x 5 mm |
| 35 | 990621M | Nut |
| 36 | 520381-WW | Belt Kit (Includes items 10, 16 and 21) |
| 37 | 520382-WW | Power Transfer Kit (Includes items 2, 5, 10, 15, 16, 17, 19 and 21) |
| WW = Conveyor width reference in inches 06, 12, 18, 24 | | |
| See Specifications chart on page 4 for conveyor belt widths. | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

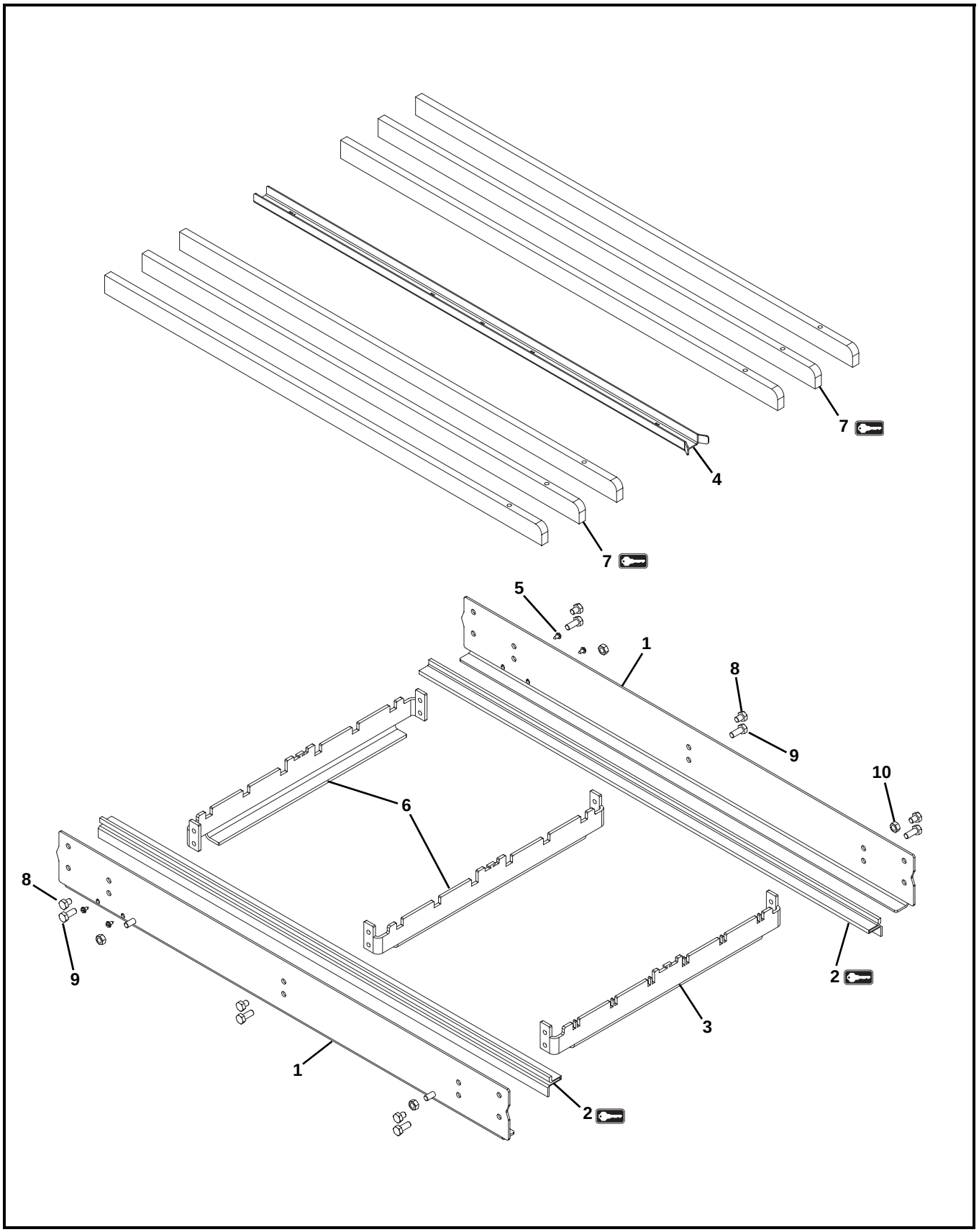
## Gravity Take-Up



| Item | Part Number | Description |
|---|---|---|
| 1 | ----- | Consult Factory for Frame Part Number |
| 2 | 350473 | Weight for 12" (305 mm) Wide and Wider Conveyors |
| 3 | 506296 | Idler Puck |
| 4 | 515586-WW | Crossmember with Pins |
| 5 | 515587-WW | Crossmember |
| 6 | 515597-LLLLL | Bearing Rail |
| 7 | 516802-S-LLLLL | Bed Rail |
| 8 | 517579-LLLLL | Wearstrip |
| 9 | 520345-WW | Shaft |
| 10 | 520346 | Weight |
| 11 | 520347 | End Guard |
| 12 | 520348 | Spacer |
| 13 | 520349-WW | Slotted Guard Plate |
| 14 | 520350 | Puck |
| 15 | 520351 | Idler Stub |
| 16 | 520352 | Belt Guide - Left Hand |
| 17 | 520353 | Belt Guide - Right Hand |
| 18 | 532127-LLLLL | Bushing |
| 19 | 807-3052 | Self-Tapping Hex Screw, 12 x .625" |
| 20 | 807-3341 | Self-Tapping Hex Screw, 8-18 x .375" |
| 21 | 960608MSS | Hex Head Cap Screw, M6-1.00 x 8 mm |
| 22 | 960808MSS | Hex Head Cap Screw, M8-1.25 x 8 mm |
| 23 | 960818MSS | Hex Head Cap Screw, M8-1.25 x 18 mm |
| 24 | 960820MSS | Hex Head Cap Screw, M8-1.25 x 20 mm |
| 25 | 990801MSS | Hex Nut for Diagonal Bracing Only |
| 26 | 520384-WW-LLLLL | Gravity Take-Up (Includes items 3, 7, 8, 14, 16, and 17) |
| WW = Conveyor width reference in inches 06, 12, 18, 24 | | |
| See Specifications chart on page 4 for conveyor belt widths. | | |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

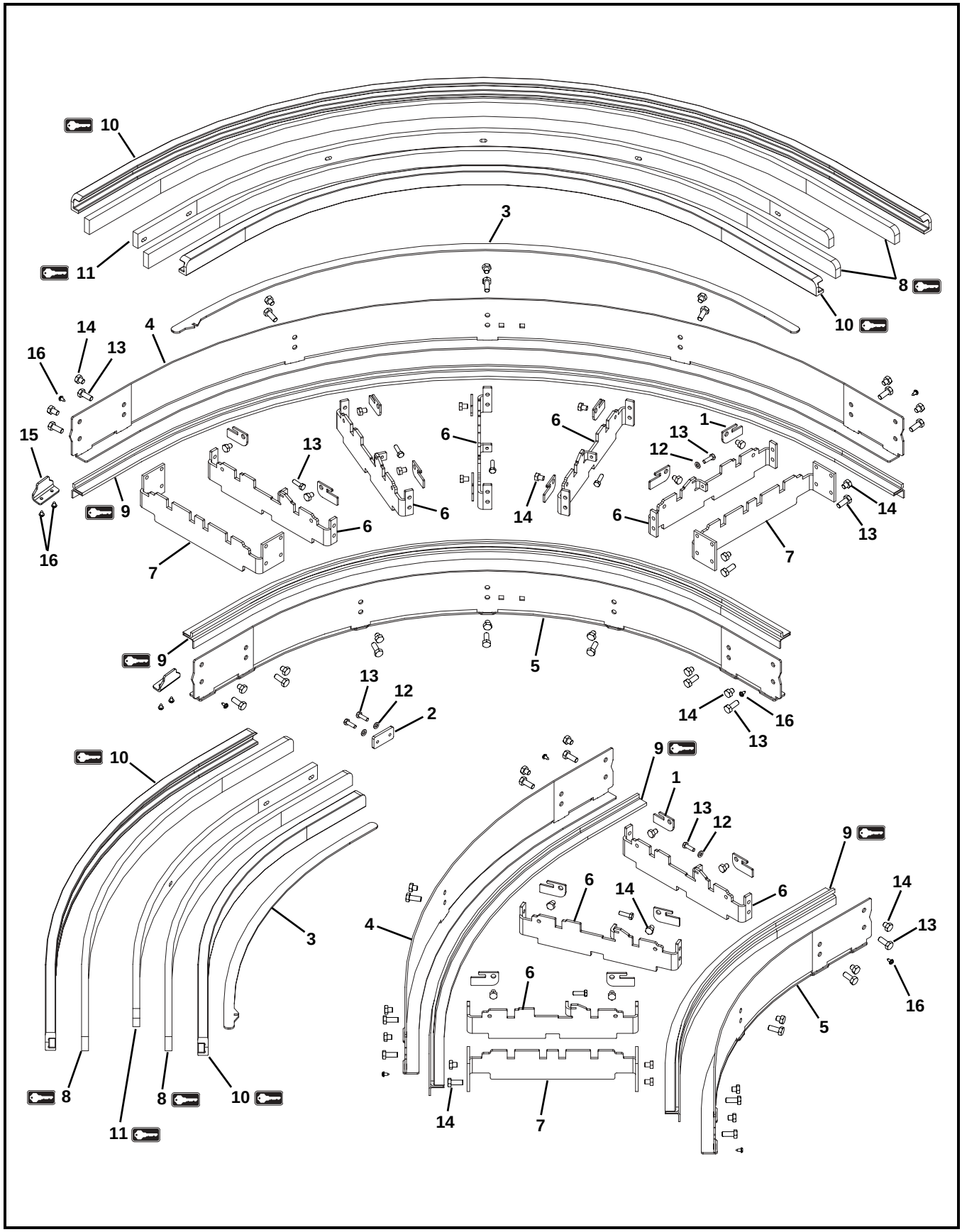
## Straight Frame



| Item | Part Number | Description |
|---|---|---|
| 1 | ---------- | Consult Factory for Frame Part Number |
| 2 | 517579-LLLLL | Wear Strip |
| 3 | 520458-WW | Crossmember for frames under 8.89" (226 cm) long |
| | 515586-WW | Crossmember for frames 8.89" (226 cm) long and longer |
| 4 | 515597-LLLLL | Bearing Rail |
| 5 | 807-3341 | Self Tapping Hex Screw, 8-18 x .375" |
| 6 | 520459-WW | Crossmember for frames under 8.89" (226 cm) long |
| | 515587-WW | Crossmember for frames 8.89" (226 cm) long and longer |
| 7 | 516802-S-LLLLL | Bed Rail |
| 8 | 960808MSS | Hex Head Cap Screw, M8-1.25 x 8 mm |
| 9 | 960820MSS | Hex Head Cap Screw, M8-1.25 x 20 mm |
| 10 | 990801MSS | Hex Nut |
| WW = Conveyor width reference in inches 06, 12, 18, 24 | | |
| See Specifications chart on page 4 for conveyor belt widths. | | |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

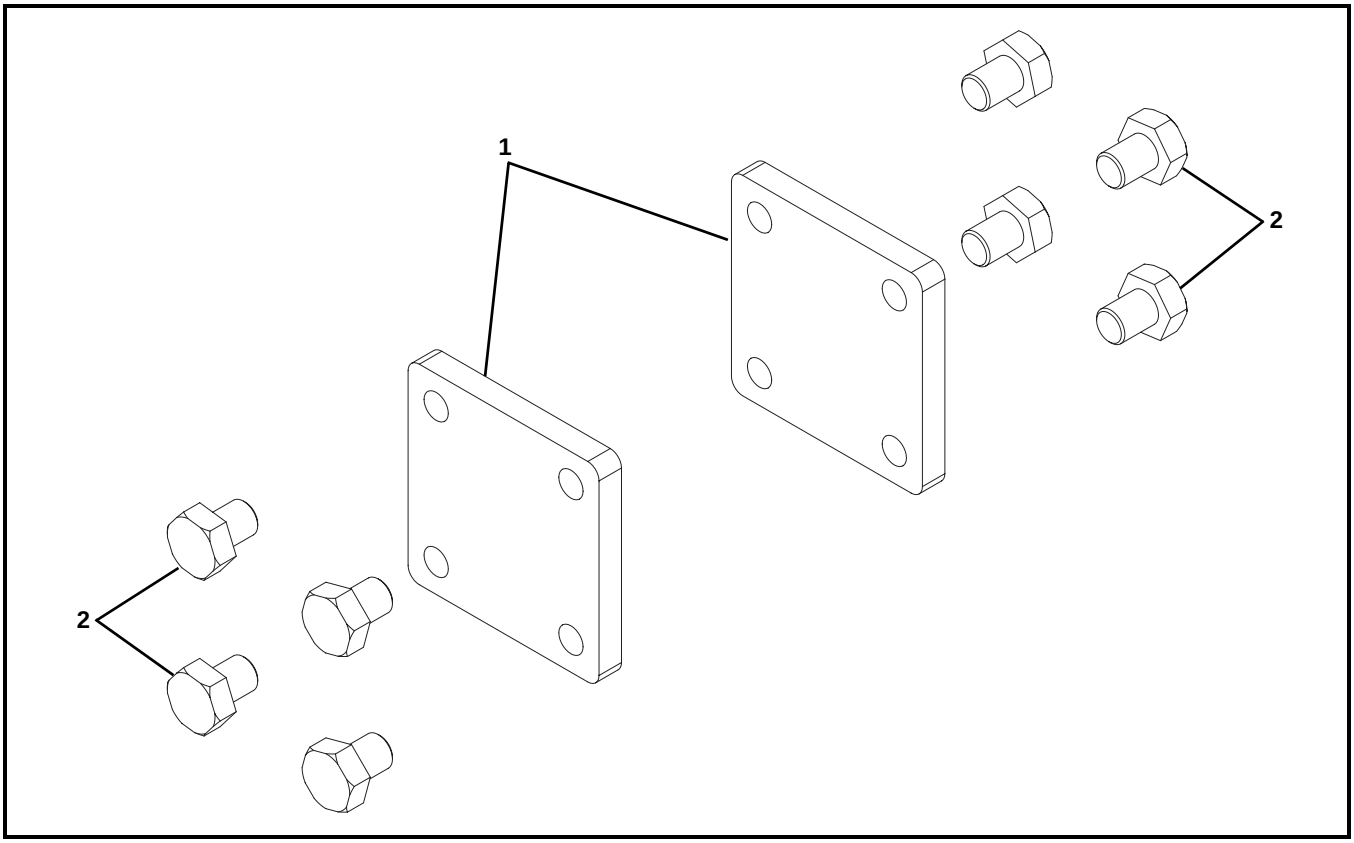
## Curve Frame



| Item | Part Number | Description |
|---|---|---|
| 1 | 515599 | Retaining Clamp |
| 2 | 520330 | Connector Plate (for 135° and 180° Curves Only) |
| 3 | 515503-WW-AA | Bearing Spine |
| 4 | 515577-WW-AA-LH | Outer Frame for Left Hand Curve |
| | 515577-WW-AA-RH | Outer Frame for Right Hand Curve |
| 5 | 515578-WW-AA-LH | Inner Frame for Left Hand Curve |
| | 515578-WW-AA-RH | Inner Frame for Right Hand Curve |
| 6 | 515589-WW-LH | Crossmember for Left Hand Curve |
| | 515589-WW-RH | Crossmember for Left Hand Curve |
| 7 | 515590-WW | Crossmember |
| 8 | 516802-C-LLLLL | Bed Rail |
| 9 | 517579-LLLLL | Wear Strip |
| 10 | 518431-LLLLL | Wear Rail |
| 11 | 520342-WW-AA | Bearing Guide (for 135° and 180° Curves Only) |
| 12 | 911-222 | Washer |
| 13 | 960620MSS | Hex Head Cap Screw, M6-1.00 x 20 mm |
| 14 | 960808MSS | Hex Head Cap Screw, M8-1.25 x 8 mm |
| 15 | 520354 | Support Bracket (for 135" and 180" Curves Only) |
| 16 | 807-3341 | Self-Tapping Hex Screw, 8-18 x .375" |
| AA = Conveyor angle reference 45, 90 | | |
| WW = Conveyor width reference in inches 06, 12, 18, 24 | | |
| See Specifications chart on page 4 for conveyor belt widths. | | |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

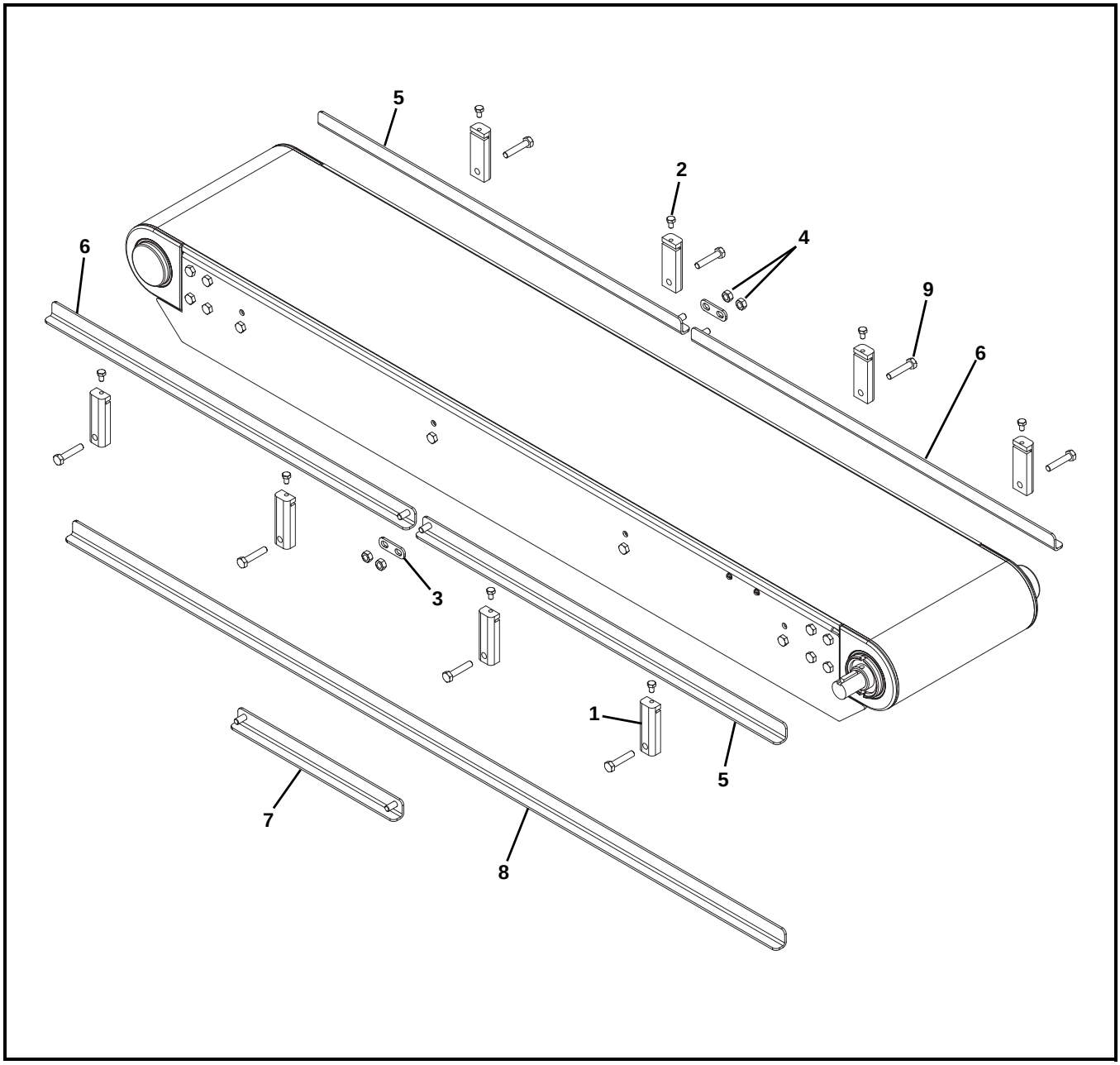
# Service Parts

## Connecting Assembly




| Item | Part Number | Description |
|---|---|---|
| 1 | 516942 | Connecting Plate |
| 2 | 960810MSS | Hex Head Cap Screw,<br>M8-1.25 x 10 mm |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## 25 mm High Sides for Straight Sections

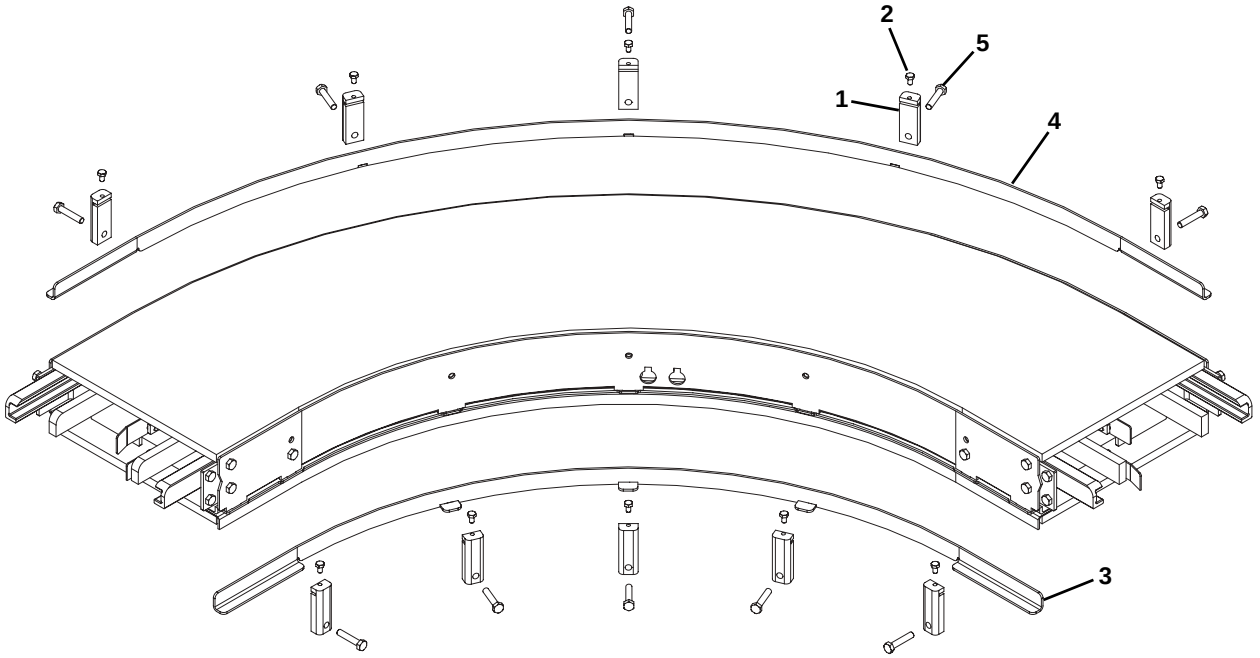



| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518400-01-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 6 | 518400-01-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |
| 7 | 518399-01-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |
| 8 | 516997-01-LLLLL | Guiding (for One Piece Guiding) |

| Item | Part Number | Description |
|---|---|---|
| 9 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

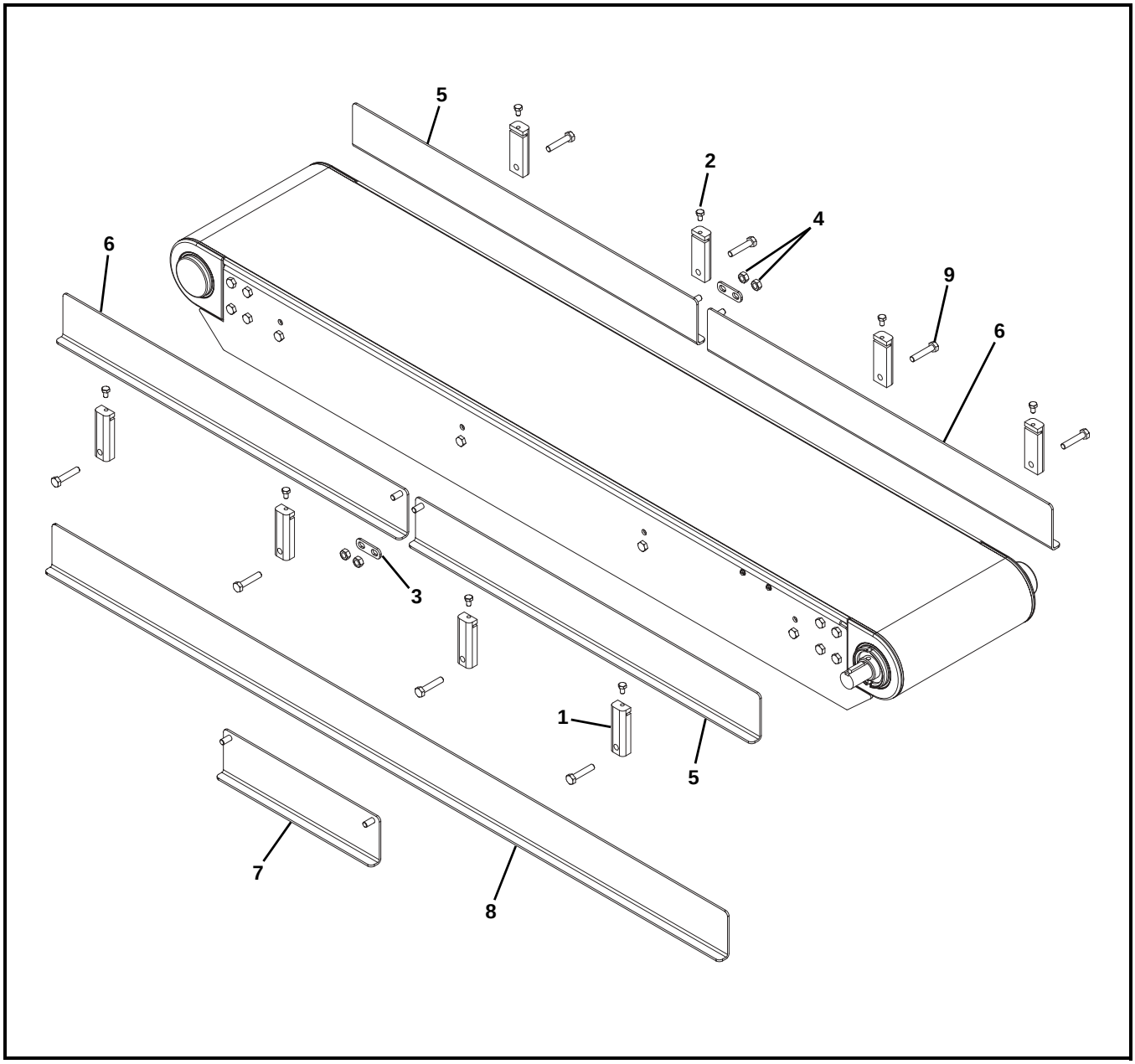
# Service Parts

## 25 mm High Sides for Curve Sections




| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516908-WW-01-AA | Guiding for Inside Curve Section |
| 4 | 516909-WW-01-AA | Guiding for Outside Curve Section |
| 5 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| AA = Conveyor angle reference 45, 90 | | |
| WW = Conveyor width reference in inches 06, 12, 18, 24 | | |
| See Specifications chart on page 4 for conveyor belt widths. | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## 75 mm High Sides for Straight Sections

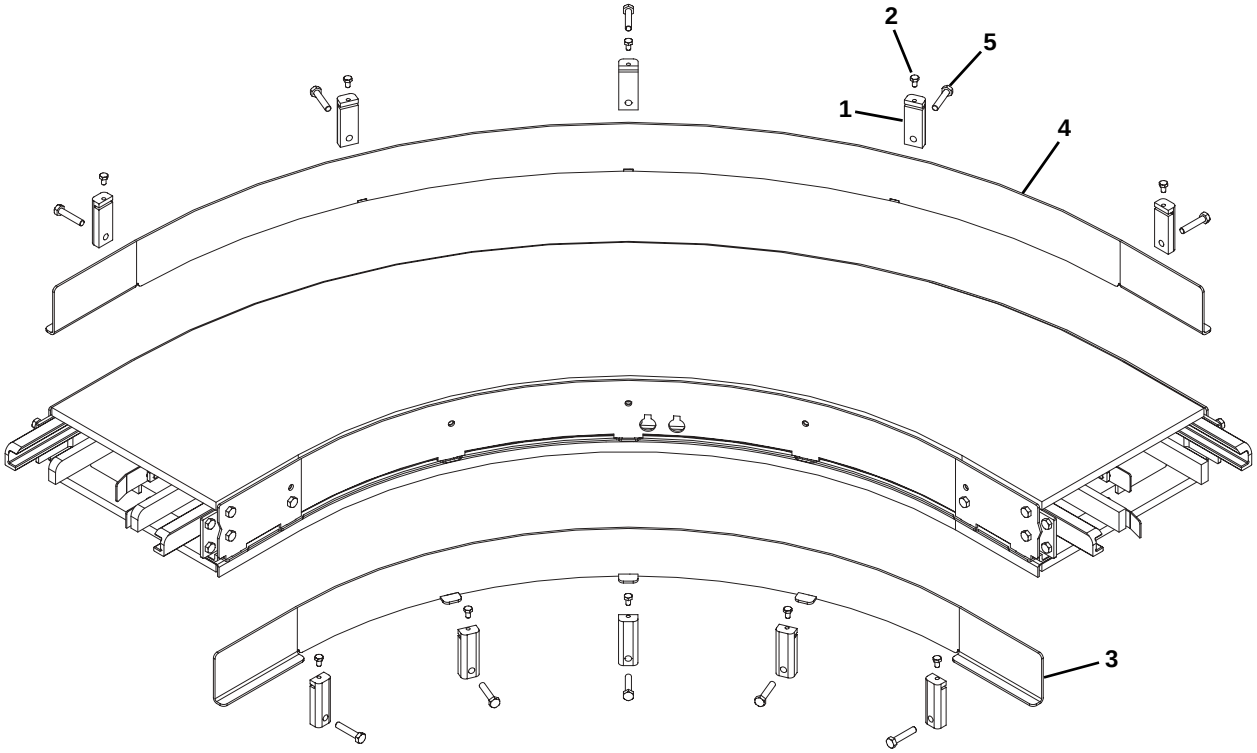



| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518400-03-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 6 | 518400-03-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |
| 7 | 518399-03-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |
| 8 | 516997-03-LLLLL | Guiding (for One Piece Guiding) |

| Item | Part Number | Description |
|---|---|---|
| 9 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

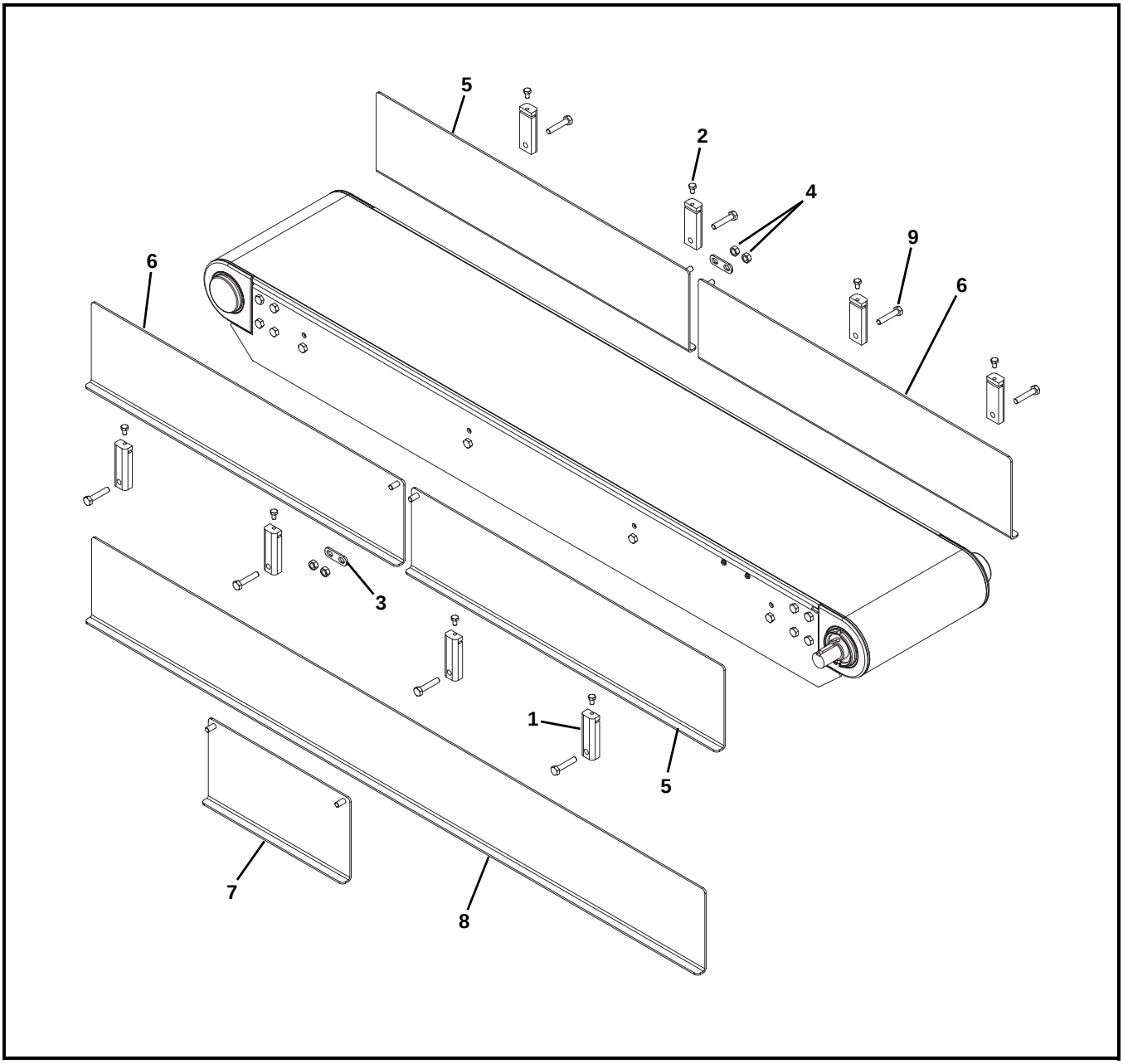
# Service Parts

## 75 mm High Sides for Curve Sections




| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516908-WW-03-AA | Guiding for Inside Curve Section |
| 4 | 516909-WW-03-AA | Guiding for Outside Curve Section |
| 5 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| AA = Conveyor angle reference 45, 90 | | |
| WW = Conveyor width reference in inches 06, 12, 18, 24 | | |
| See Specifications chart on page 4 for conveyor belt widths. | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## 152 mm High Sides for Straight Sections

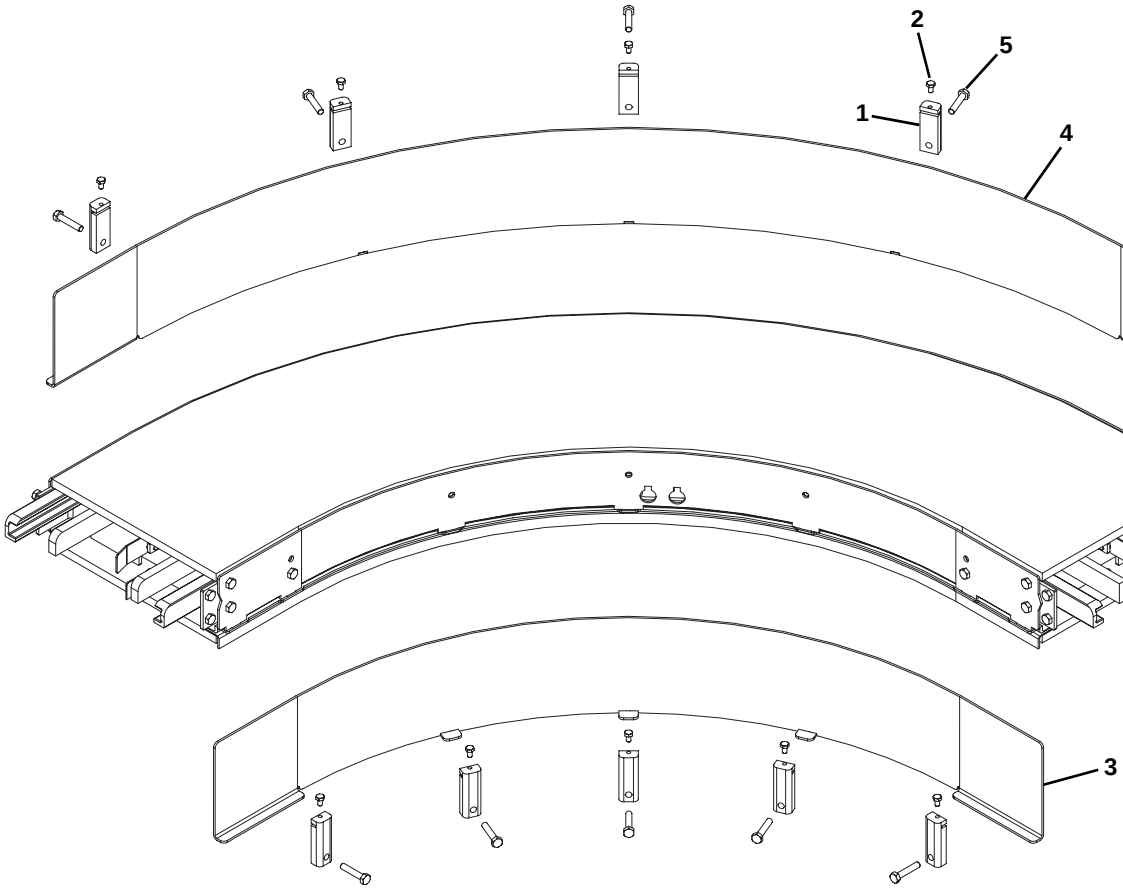



| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516935 | Guide Connecting Plate (for Multiple Guide Sections Only) |
| 4 | 990801MSS | Hex Nut |
| 5 | 518400-06-LLLLL-LH | Guiding, Left Hand (for Multiple Guide Sections Only) |
| 6 | 518400-06-LLLLL-RH | Guiding, Right Hand (for Multiple Guide Sections Only) |
| 7 | 518399-06-LLLLL | Guiding, Middle (for Multiple Guide Sections Only) |
| 8 | 516997-06-LLLLL | Guiding (for One Piece Guiding) |

| Item | Part Number | Description |
|---|---|---|
| 9 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

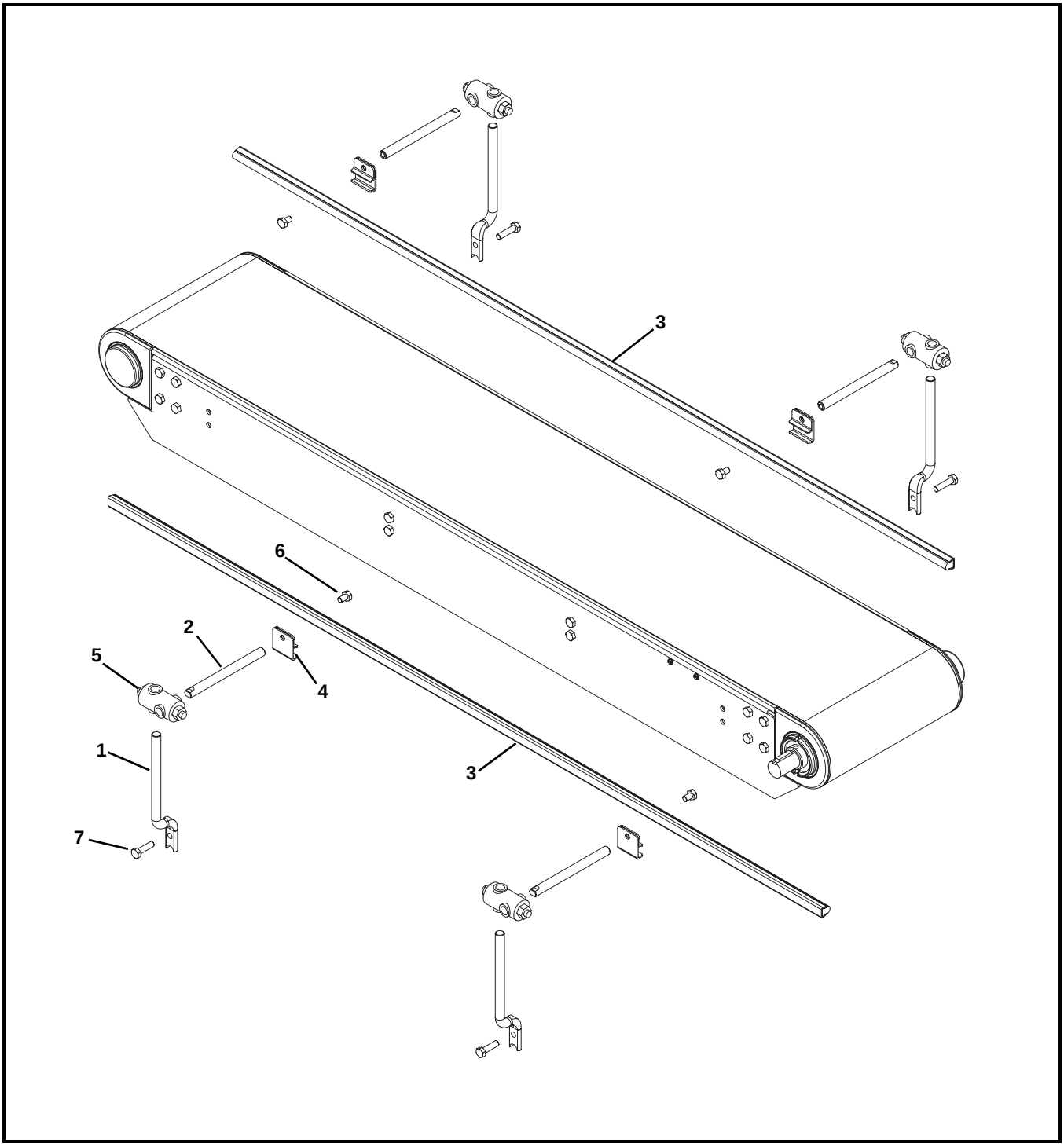
# Service Parts

## 152 mm High Sides for Curve Sections




| Item | Part Number | Description |
|---|---|---|
| 1 | 516999-01 | Mounting Block |
| 2 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 3 | 516908-WW-06-AA | Guiding for Inside Curve Section |
| 4 | 516909-WW-06-AA | Guiding for Outside Curve Section |
| 5 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| AA = Conveyor angle reference 45, 90 | | |
| WW = Conveyor width reference in inches 06, 12, 18, 24 | | |
| See Specifications chart on page 4 for conveyor belt widths. | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## Fully Adjustable Round Guides

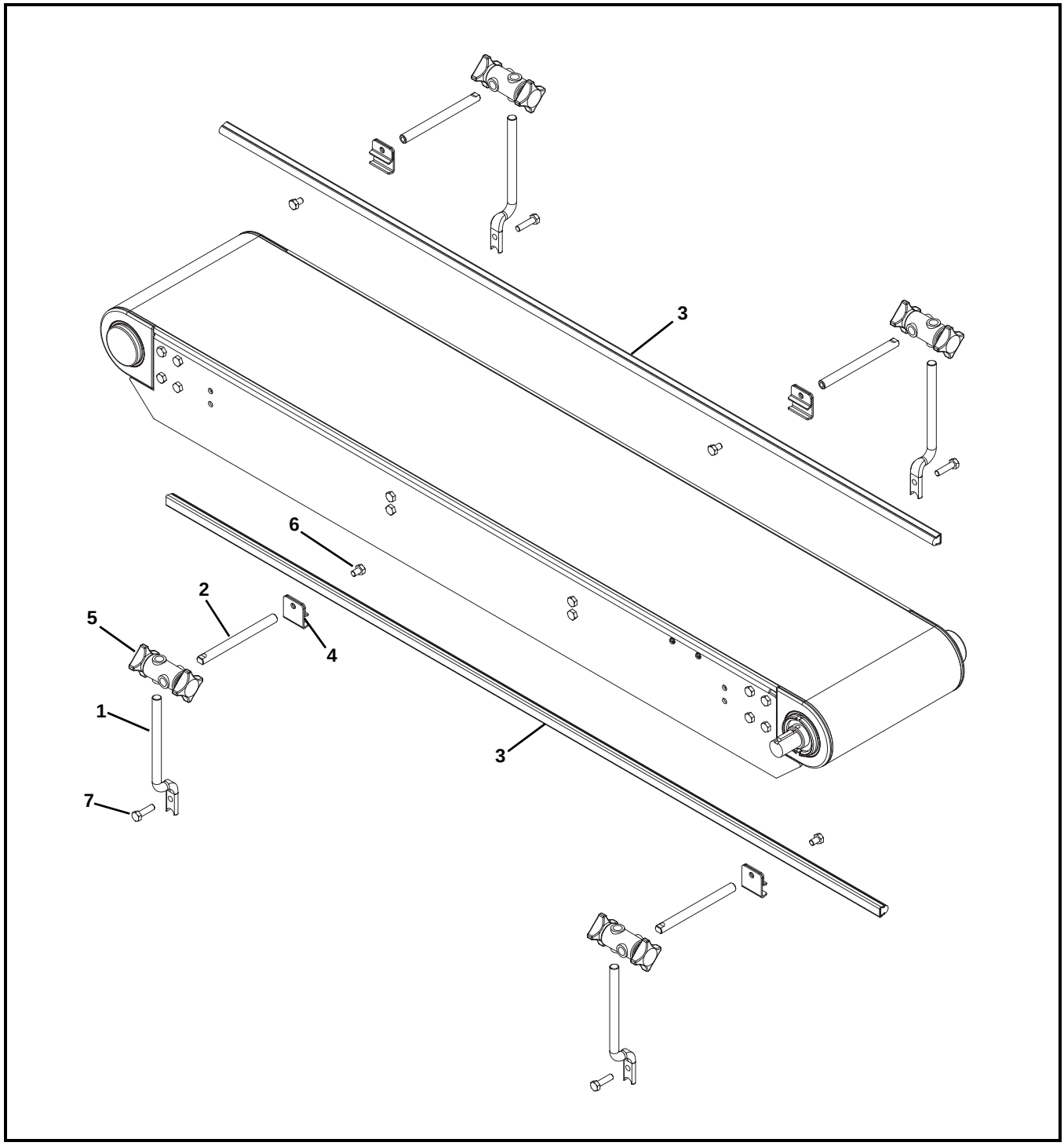



| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 532167-LLLLL | Round Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1387 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

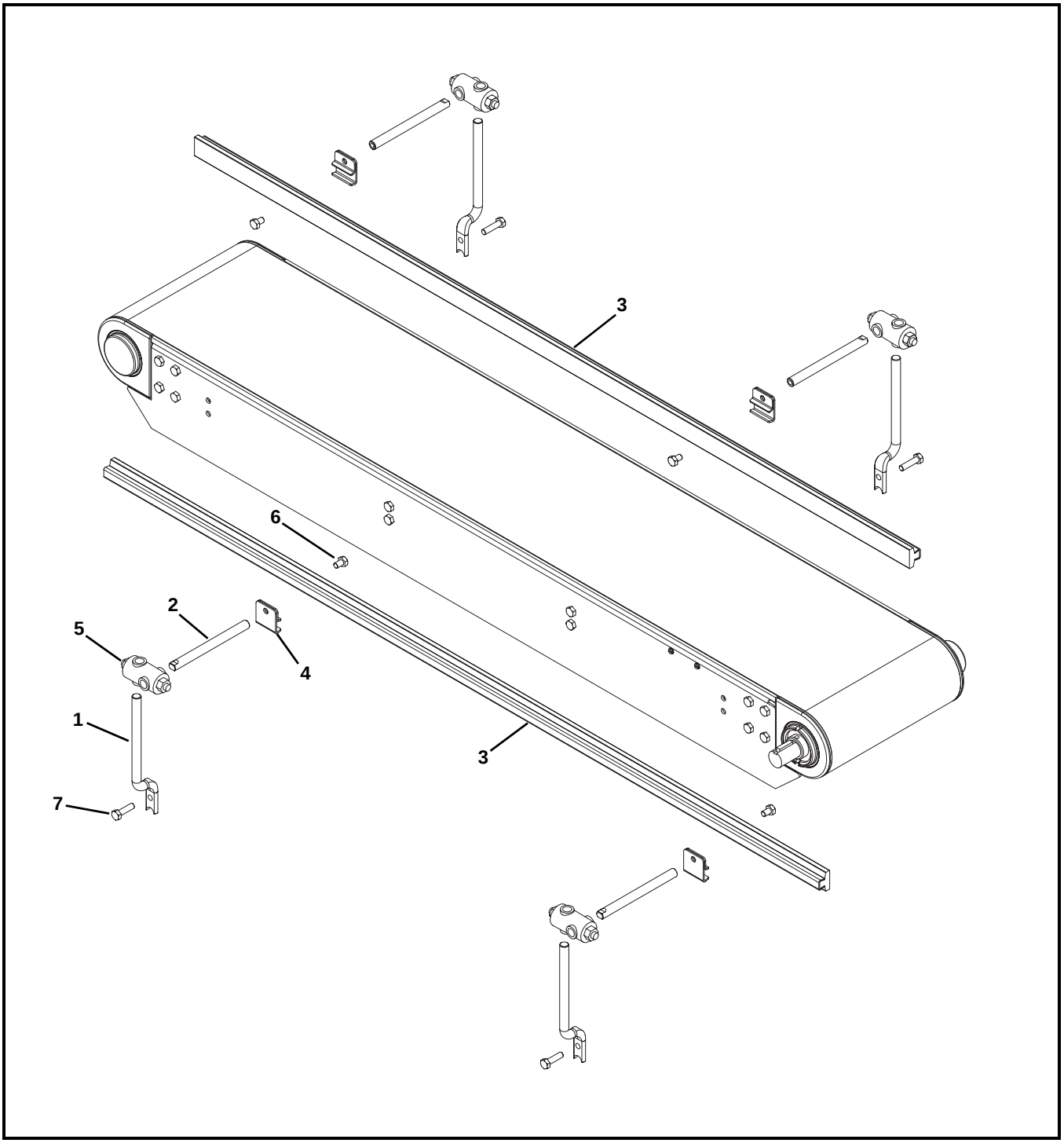
## Tool-Less Fully Adjustable Round Guides




| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 532167-LLLLL | Round Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1470 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## Fully Adjustable Flat Guides

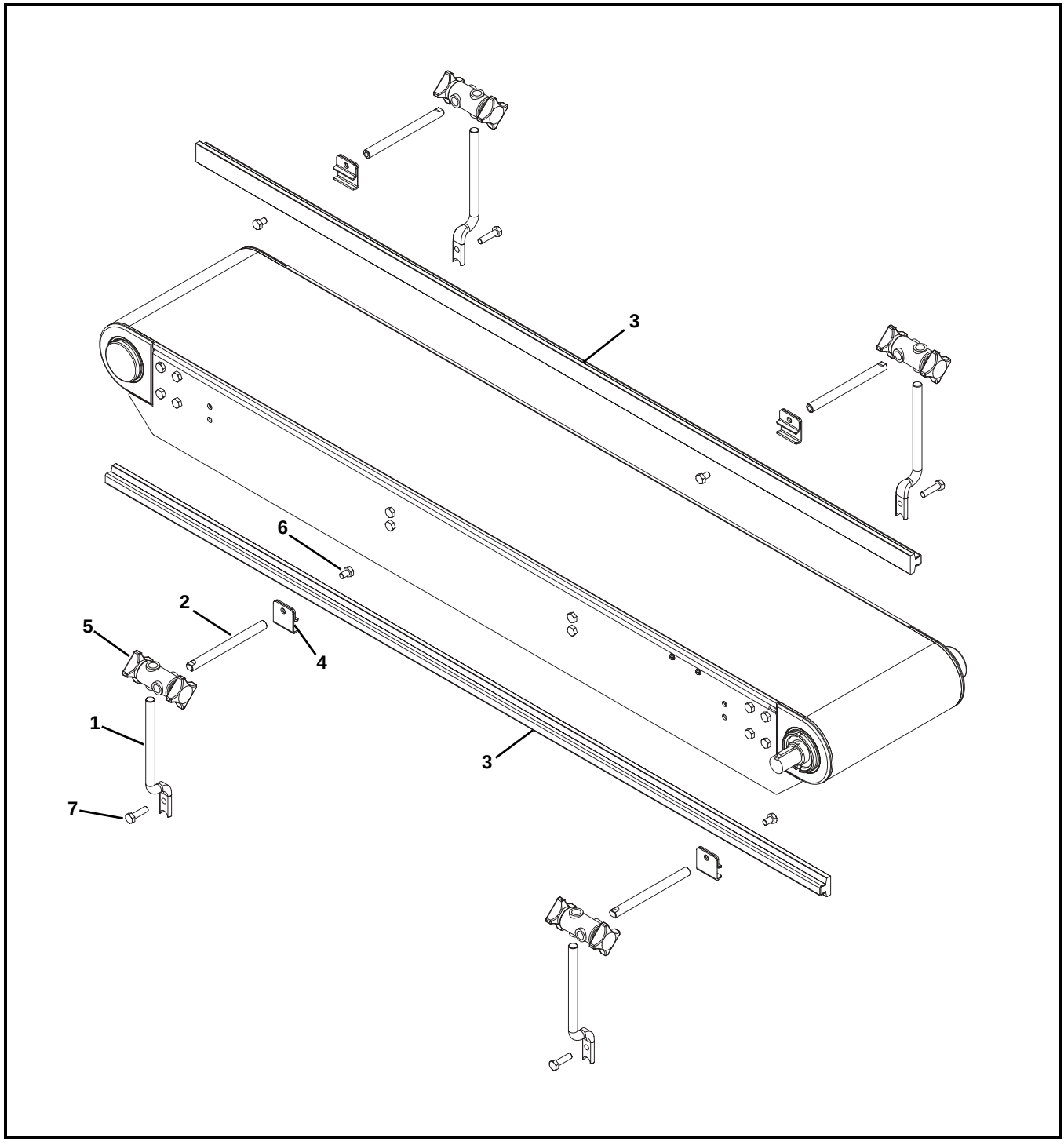



| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 517599-LLLLL | Flat Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1387 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

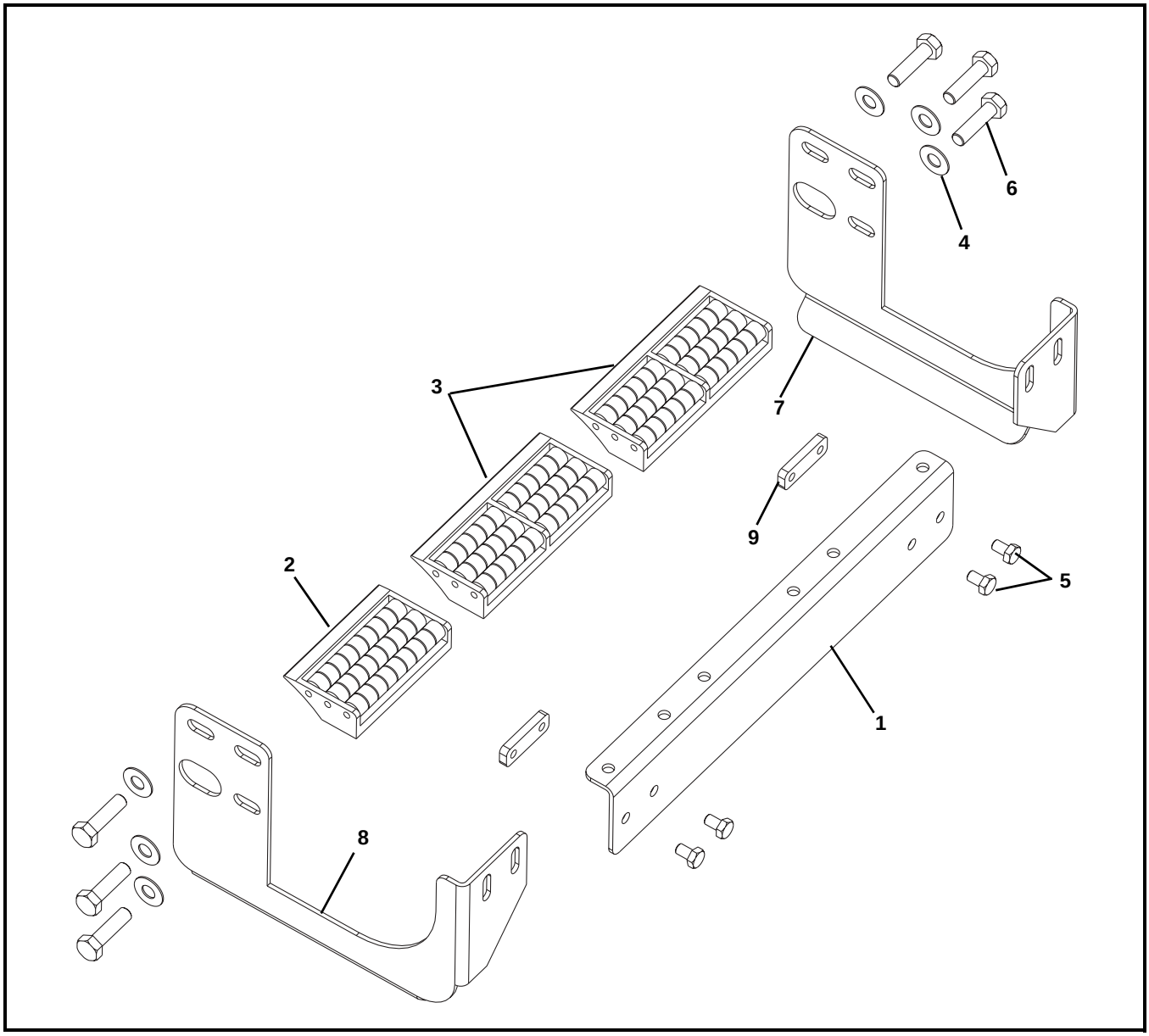
## Tool-Less Fully Adjustable Flat Guides




| Item | Part Number | Description |
|---|---|---|
| 1 | 516996 | Offset Guide Post |
| 2 | 532300 | Post Guide |
| 3 | 517599-LLLLL | Flat Guide Rail |
| 4 | 807-015 | Rail Clamp |
| 5 | 807-1470 | Cross Block Clamp |
| 6 | 960812MSS | Hex Head Cap Screw, M8-1.25 x 12 mm |

| Item | Part Number | Description |
|---|---|---|
| 7 | 960825MSS | Hex Head Cap Screw, M8-1.25 x 25 mm |
| LLLLL = Part length in inches with 2 decimal places. | | |
| Example: Part Length = 95.25" LLLLL = 09525 | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

## Roller Transfer




| Item | Part Number | Description |
|---|---|---|
| 1 | 518390-WW | Support Bracket |
| 2 | 807-1829 | 3.35" Transfer Plate |
| 3 | 807-1830 | 4.53" Transfer Plate |
| 4 | 911-208 | Washer |
| 5 | 960610MSS | Hex Head Cap Screw, M6-1.00 x 10 mm |
| 6 | 960830MSS | Hex Head Cap Screw, M8-1.25 x 30 mm |
| 7 | 518391-LH | Mounting Plate, Left Hand |
| 8 | 518391-RH | Mounting Plate, Right Hand |
| 9 | 532387 | Nut Plate |
| WW = Conveyor width reference in inches 08 - 36 in 02 increments | | |
| Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com | | |

# Service Parts

## Ordering a Replacement Chain

Determine the length of chain required for the conveyor and round up to the nearest foot length. Order the proper number of chain repair kits (1' long each) for your conveyor. Dorner will ship chain kits that are of a reasonable length fully assembled

**Example:**

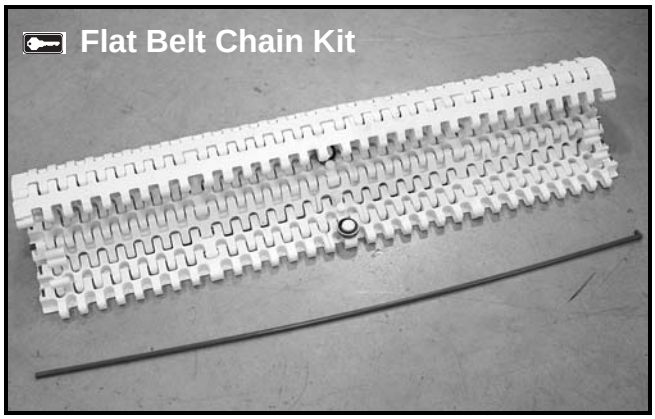
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 52BB-WW

BB = Chain reference number (Refer to belt type in part number. See Page 5 for details.)

WW = Conveyor width ref: 06, 12, 18, 24 increments

## Flat Belt Chain Repair Kit




| Item | Part Number | Description |
|---|---|---|
| 1 | 52BB-WW-FG | Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins) |
| BB = Chain Reference number | | |
| WW = Conveyor width ref: 06, 12, 18, 24 increments | | |

# 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. Include part serial number if available.

A representative will discuss action to be taken on the returned items and provide a Returned Materials 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.

<table>
<tr><td></td><td colspan="9">Product Type</td></tr>
<tr><td></td><td colspan="8">Standard Products</td><td>Engineered to order parts</td></tr>
<tr><td>Product Line</td><td>Conveyors</td><td>Gearmotors & Mounting Packages</td><td>Support Stands</td><td>Accessories</td><td>Spare Parts (non-belt)</td><td>Spare Belts - Standard Flat Fabric</td><td>Spare Belts - Cleated & Spec. Fabric</td><td>Spare Belts - Plastic Chain</td><td>All equipment and parts</td></tr>
<tr><td>1100 Series</td><td colspan="6" rowspan="7">30% return fee for all products except:<br>50% return fee for conveyors with modular belt, cleated belt or speciality belts<br><br>All Electrical items are assigned original manufacturers return policy.</td><td colspan="2" rowspan="11">non-returnable</td><td rowspan="11">case-by-case</td></tr>
<tr><td>2200 Series</td></tr>
<tr><td>3200 Series</td></tr>
<tr><td>Pallet Systems</td></tr>
<tr><td>FlexMove/SmartFlex</td></tr>
<tr><td>GAL Series</td></tr>
<tr><td>All Electrical</td></tr>
<tr><td>7100 Series</td><td colspan="6" rowspan="4">50% return fee for all products</td></tr>
<tr><td>7200/7300 Series</td></tr>
<tr><td>AquaGard 7350 Series Version 2</td></tr>
<tr><td>GES Series</td></tr>
<tr><td>AquaGard 7350/7360 Series</td><td colspan="8" rowspan="2">non-returnable</td></tr>
<tr><td>AquaPruf Series</td></tr>
</table>

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 Dorner, an authorized sales channel or visit our website: www.dorner.com.

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

**www.dorner.com**

DORNER

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