2200 Series SmartFlex Conveyors with Cast Tails

Installation, Maintenance & Parts Manual

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851-829 Rev. B

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Introduction

IMPORTANT

Some illustrations may show guards removed. DO NOT operate equipment without guards.

Upon receipt of shipment:

- Compare shipment with packing slip. Contact factory regarding discrepancies.
- Inspect packages for shipping damage. Contact carrier regarding damage.
- Accessories may be shipped loose. See accessory instructions for installation.

Dorner's Limited Warranty applies.

Dorner has convenient, pre–configured kits of Key Service Parts for all conveyor products. These time saving kits are easy to order, designed for fast installation, and guarantee you will have what you need when you need it. Key Parts and Kits are marked in the Service Parts section of this manual with the Performance Parts Kits logo .

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

⚠ WARNING

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

⚠ DANGER

Climbing, sitting, walking or riding on conveyor will cause severe injury. KEEP OFF CONVEYORS.

⚠ DANGER

DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

⚠ WARNING

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

⚠ WARNING

Gearmotors may be HOT.

DO NOT TOUCH Gearmotors.

⚠ WARNING

Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.

When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, CHECK FOR POTENTIAL PINCH POINTS and other mechanical hazards before system start-up.

⚠ WARNING

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

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

Product Description

Refer to **Figure 1** for typical components.

1	Infeed Module
2	Curve Module
3	Incline Module
4	Decline Module
5	Intermediate Module
6	Drive Module
7	Gearmotor
8	Stands

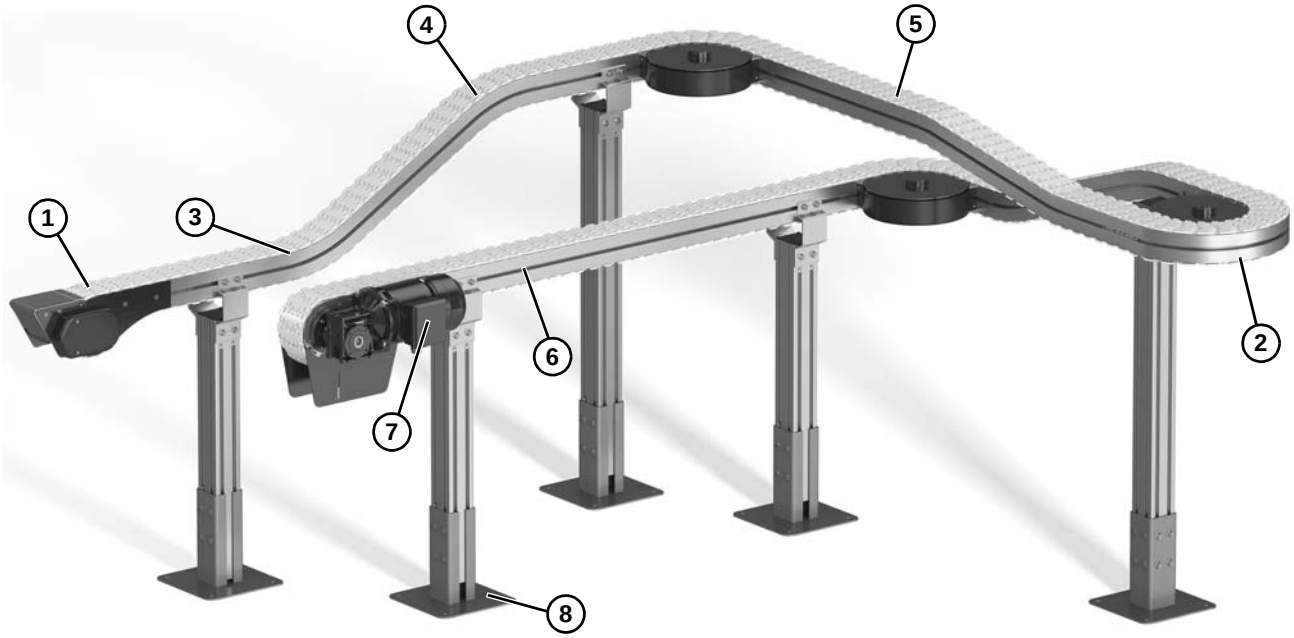
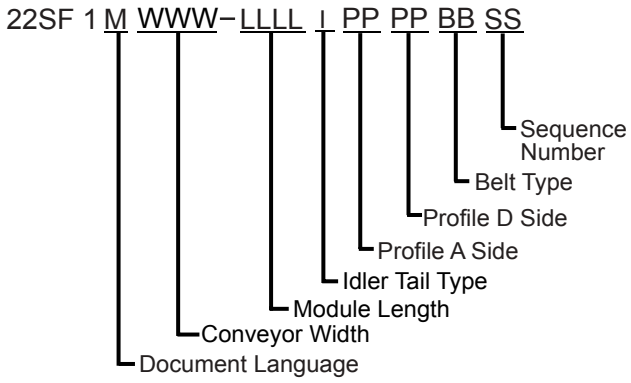


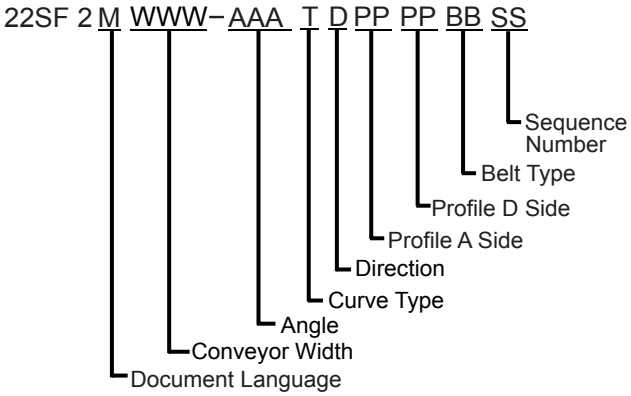
Figure 1

Modules:

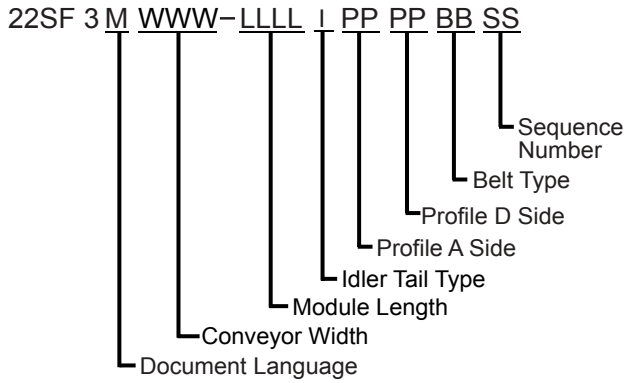
Infeed Module



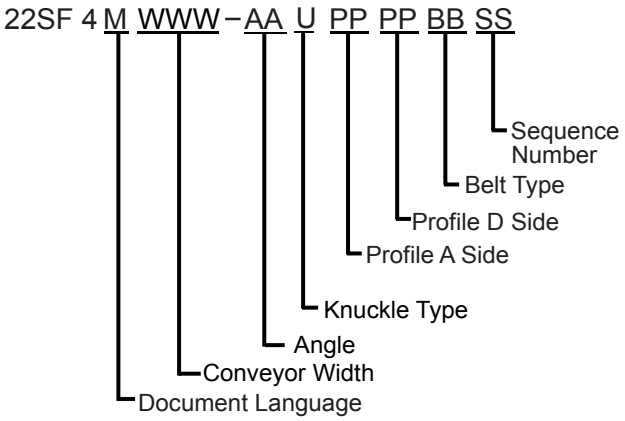
Curve Module



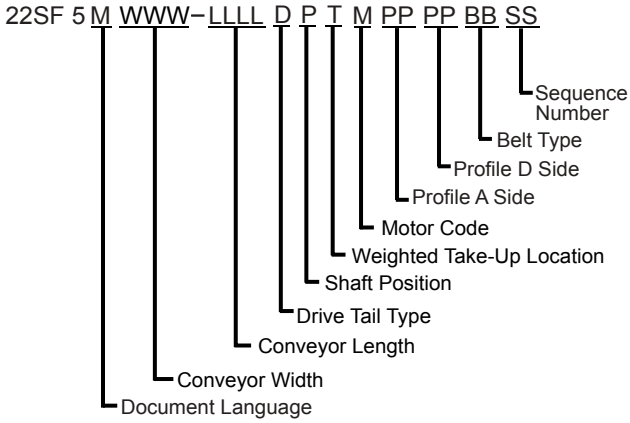
Intermediate Module



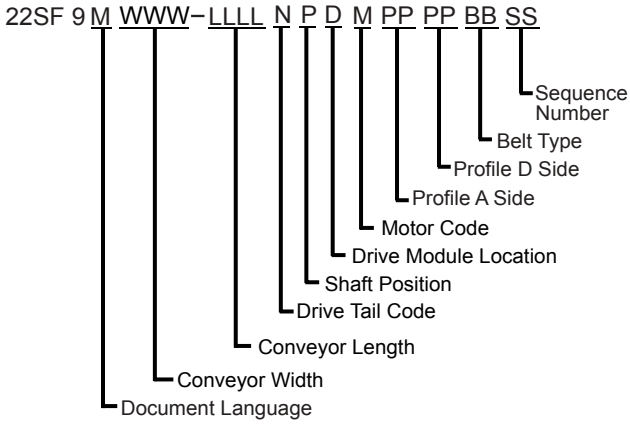
Incline/Decline Module



Drive Module



Top Running Drive Module



Specifications

Conveyor Supports:

Maximum Distances:

1 = 36" (914 mm)

2 = 10 ft (3048 mm)*

3 = 36" (914 mm)

* For conveyors longer than 10 ft (3048 mm), install support at joint.

Note: Additional support required on 180° curve modules.

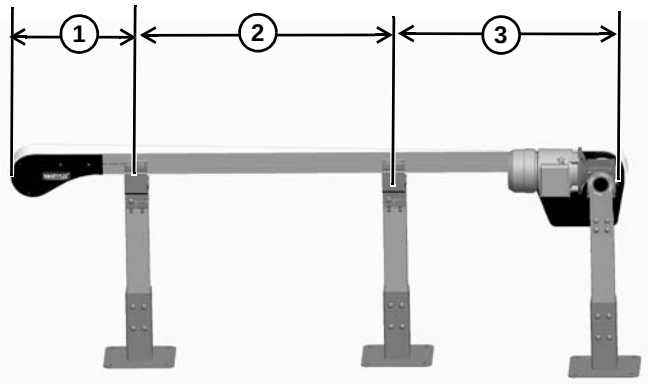


Figure 2

Specifications:

Conveyor Widths Reference (WW)	065	085	105	150
Conveyor Belt Width	2.47" (63 mm)	3.27" (83 mm)	4.05" (103 mm)	5.91" (150 mm)
Maximum Load	330 lb (149 kg)	660 lb (299 kg)	660 lb (299 kg)	660 lb (299 kg)
Maximum Belt Speed	250 Ft/min (76 M/min)			
Belt Takeup (Standard Weighted Take-up)	8" (203 mm)			
Module Length Reference	0167-5000			
Module Length	1.67' (509 mm)- 50.00' (15,240 mm)			
Total Conveyor Length	99 ft (30,175 mm) maximum			

Table 1: Gearmotor Specifications

U.S. Version

Item	Standard Load Gearmotor		
	Single Phase	Three Phase	VFD Variable Speed
Output Power	0.5 hp (0.37 kw)		
Input Voltage	115 VAC	208 – 230/460 VAC	230 VAC
Input Frequency	60Hz		10 – 60Hz
Input Current	7.4 Amperes	2.1 – 2/1 Amperes	1.6 Amperes
Gearmotor Ratios	5:1, 10:1, 20:1		
Frame Size	NEMA 56C		
Motor Type	Totally enclosed, Fan cooled		

CE Version

Item	Standard Load Gearmotor		
	Single Phase	Three Phase	VFD Variable Speed
Output Power	0.37 kW		
Input Voltage	230 VAC	230/400 VAC	230 VAC
Input Frequency	50 Hz		25 to 63 Hz
Input Current	2.6 Amperes	2.1/1.2 Amperes	2.1 Amperes
Gearmotor Ratios	5:1, 10:1, 20:1		
Protection Rating	IP55		
Frame Size	IEC 71 B5		

SEW Gearmotor Specifications

Item	SEW Gearmotor					
	Three Phase			VFD Variable Speed		
Output Power	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)
Input Voltage	230/460			230/460		
Input Frequency	60 Hz			10 to 60 Hz		
Input Current	1.84/0.92 Amperes	2.50/1.25 Amperes	2.90/1.44 Amperes	1.84/0.92 Amperes	2.50/1.25 Amperes	2.90/1.44 Amperes
RPM	47	134	264	8 to 47	22 to 134	44 to 264
Ratio	37.7:1	13.4:1	6.8:1	37.7:1	13.4:1	6.8:1
Motor Frame	IEC71	IEC71	IEC80	IEC71	IEC71	IEC80
Motor Type	IP54 Totally Enclosed Fan Cooled			IP54 Totally Enclosed Fan Cooled		

Heavy Load Gearmotor Specifications

Item	Heavy Load Gearmotor			
	Single Phase	Three Phase		
Output Power	0.5 Hp (0.37 kW)	0.5 Hp (0.37 kW)	1 Hp (0.75 kW)	1.5 Hp (1.11 kW)
Input Voltage	115 VAC	208-230/460 VAC		
Input Frequency	60 Hz			
Input Current	8.0 Amperes	2.0/1.0 Amperes	3.4/1.7 Amperes	5.0/2.5 Amperes
Gearmotor Ratios	60:1, 80:1, 100:1	60:1, 80:1, 100:1	40:1, 50:1	15:1, 20:1, 25:1, 30:1
Frame Size	NEMA 56 C	NEMA 56 C	NEMA 56 C	NEMA 145TC C
Motor Type	Totally Enclosed Fan Cooled			

Heavy Load Gearmotor Specifications (continued)

Item	Heavy Load Gearmotor		
	VFD Variable Speed		
Output Power	0.5 Hp (0.37 kW)	1 Hp (0.75 kW)	1.5 Hp (1.11 kW)
Input Voltage	230/460 VAC		
Input Frequency	15 to 60 Hz		
Input Current	1.6/0.8 Amperes	3.2/1.6 Amperes	4.2/2.1 Amperes
Gearmotor Ratios	60:1, 80:1, 100:1	40:1, 50:1	15:1, 20:1, 25:1, 30:1
Frame Size	NEMA 56 C	NEMA 56 C	NEMA 145TC C
Motor Type	Totally Enclosed Fan Cooled		

Specifications

Table 2: Belt Speed for Standard Load Fixed Speed 90° Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M060ES4(vp)FN	29	378	36	39	12	38	12	41	12
32M040ES4(vp)FN	43	378	36	57	17	57	17	60	18
32M020ES4(vp)FN	86	285	32.2	115	35	113	35	120	37

(vp) = voltage and phase

11 = 115 V, 1-phase

23 = 208 – 230/460 V, 3-phase

CE Version (50 Hz Gearmotors)

Part Number	RPM	N-m 1-phase/3-phase	Belt Speed					
			65 mm		85 mm		105 mm & 150 mm	
			Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
62Z060ES4(vp)FN	23	36/36	31	9.3	30	9.2	32	9.8
62Z040ES4(vp)FN	35	26.9/35.5	47	14	46	14	49	15
32Z020ES4(vp)FN	70	32.2/32.2	93	28	92	28	98	30
32Z010ES4(vp)FN	140	17.3/17.3	187	57	185	56	196	60

(vp) = voltage and phase

21 = 230 V, 1-phase

23 = 230 V, 3-phase

43 = 400 V, 3-phase

Table 3: Belt Speeds for Standard Load Variable Speed 90° VFD Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M060ES423EN	29	378	36	9.7 - 39	2.9 - 12	9.6 - 38	2.9 - 12	10 - 41	3.1 - 12
32M040ES423EN	43	378	36	14 - 57	4.4 - 17	14 - 57	4.3 - 17	15 - 60	4.6 - 18
32M020ES423EN	86	285	32.2	29 - 115	8.7 - 35	28 - 113	8.6 - 35	30 - 120	9.2 - 37
32M010ES423EN	173	153	17.3	58 - 231	18 - 70	57 - 228	17 - 70	60 - 242	18 - 74

CE Version (50 Hz Gearmotors)

Part Number	RPM	N-m	Belt Speed					
			65 mm		85 mm		105 mm & 150mm	
			Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
62Z060ES423EN	23	36	7.7 - 31	2.3 - 9.3	7.6 - 30	2.3 - 9.2	8 - 32	2.4 - 9.8
62Z040ES423EN	35	35.5	12 - 47	3.6 - 14	12 - 46	3.5 - 14	12 - 49	3.7 - 15
32Z020ES423EN	70	32.2	23 - 93	7.1 - 28	23 - 92	7 - 28	24 - 98	7.5 - 30
32Z010ES423EN	140	17.3	47 - 187	14 - 57	46 - 185	14 - 56	49 - 196	15 - 60

Table 4: Belt Speeds for Standard Load SEW Fixed Speed Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M038WS423EN	47	548	61.9	63	19	62	19	66	20
32M013WS423EN	134	327	37.0	179	54	177	54	187	57

Table 5: Belt Speeds for Standard Load SEW Variable Speed Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M038WS423EN	47	548	61.9	16 - 63	4.8 - 19	15 - 62	4.7 - 19	16 - 66	5 - 20
32M013WS423EN	134	327	37.0	45 - 179	14 - 54	44 - 177	13 - 54	47 - 187	14 - 57

Table 6: Belt Speed for Heavy Load Fixed Speed 90° Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M100EH4(vp)FN	17	913	103	23	6.9	22	6.8	24	7.2
32M080EH4(vp)FN	22	833	94	29	8.9	29	8.8	31	9.4
32M060EH4(vp)FN	29	679	76	39	12	38	12	41	12
32M050EH423FN	35	1205	136	47	14	46	14	49	15
32M040EH423FN	43	1023	115	57	17	57	17	60	18
32M030EH423FN	58	1216	137	77	24	76	23	81	25
32M025EH423FN	70	1068	121	93	28	92	28	98	30
52M020EH423FN	86	887	101	115	35	113	35	120	37
52M015EH423FN	115	682	77	153	47	152	46	161	49

Table 7: Belt Speed for Heavy Load Variable Speed 90° VFD Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M100HH423EN	17	913	103	5.7 - 23	1.7 - 6.9	5.6 - 22	1.7 - 6.8	5.9 - 24	1.8 - 7.2
32M080HH423EN	22	833	94	7.3 - 29	2.2 - 8.9	7.3 - 29	2.2 - 8.8	7.7 - 31	2.3 - 9.4
32M060HH423EN	29	679	76	9.7 - 39	2.9 - 12	9.6 - 38	2.9 - 12	10 - 41	3.1 - 12
32M050HH423EN	35	1205	136	12 - 47	3.6 - 14	12 - 46	3.5 - 14	12 - 49	3.7 - 15
32M040HH423EN	43	1023	115	14 - 57	4.4 - 17	14 - 57	4.3 - 17	15 - 60	4.6 - 18
32M030HH423EN	58	1216	137	19 - 77	5.9 - 24	19 - 76	5.8 - 23	20 - 81	6.2 - 25
32M025HH423EN	70	1068	121	23 - 93	7.1 - 28	23 - 92	7 - 28	24 - 98	7.5 - 30
52M020HH423EN	86	887	101	29 - 115	8.7 - 35	28 - 113	8.6 - 35	30 - 120	9.2 - 37
52M015HH423EN	115	682	77	38 - 153	12 - 47	38 - 152	12 - 46	40 - 161	12 - 49
52M010HH423EN	173	477	54	58 - 231	18 - 70	57 - 228	17 - 70	60 - 242	18 - 74

Installation

Required Tools

- 3/32" hex wrench
- 3 mm hex wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 10 mm wrench
- 13 mm wrench
- 16 mm wrench
- Belt Removal Tool #203480

Recommended Installation Sequence

- Locate and arrange sections by section labels:
- Assemble conveyor (Module lengths longer than 10 ft. (3000 mm)
- Install knuckles
- Install curves
- Install tails
- Unroll wear strips
- Install mounting bracket
- Install support stands
- Install belt
- Install weighted take-up
- Install guiding
- Install drive package
  - Motor mounting package
  - Gearmotor

Typical Connecting Components **(Figure 3)**

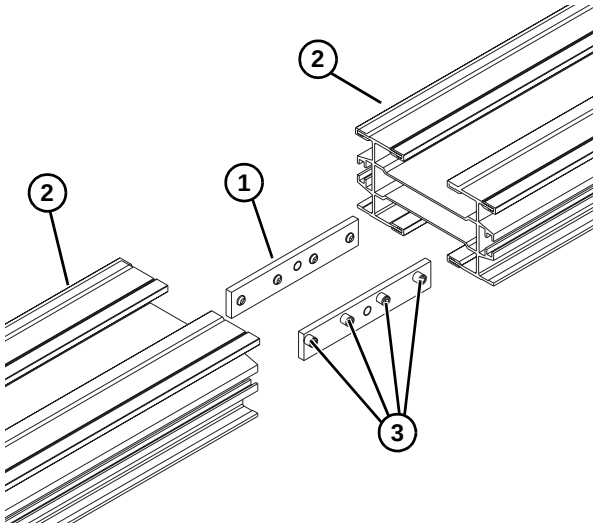


Figure 3

1	Clamp Plate
2	Conveyor frames
3	Set Screw, M8 - 1.25 x 10 mm

Module Lengths Longer Than 10 ft (3048 mm)

1. Locate and arrange conveyor sections by section labels **(Figure 4, item 1)**.

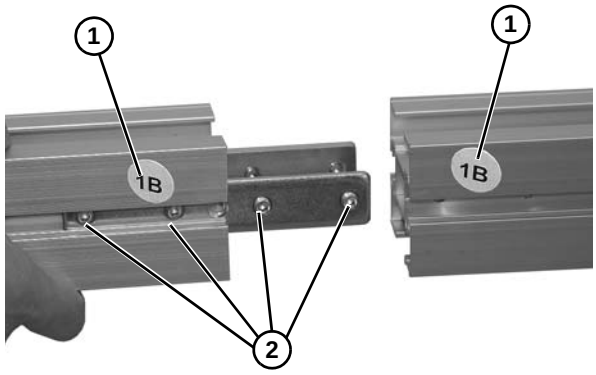


Figure 4

2. Join both conveyor sections, and tighten two set screws **(Figure 4, item 2)** on both sides. Tighten all set screws 1/4 turn past contact with frame.

Knuckles

NOTE

*Be sure all frame sections **(Figure 5, item 1)** are properly supported during knuckle assembly.*

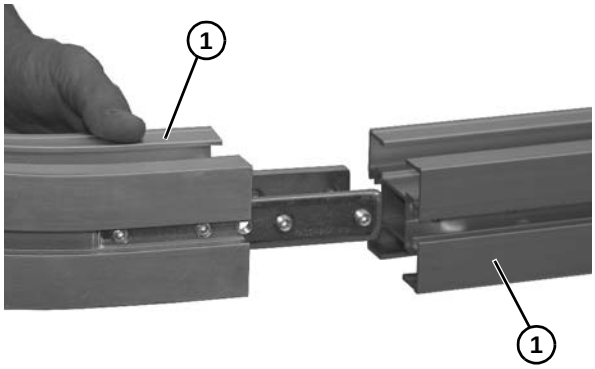


Figure 5

1. Join knuckle conveyor frame section **(Figure 6, item 1)**, and conveyor frame **(Figure 6, item 2)** and secure with two set screws **(Figure 6, item 3)** on both sides. Tighten all set screws 1/4 turn past contact with frame.

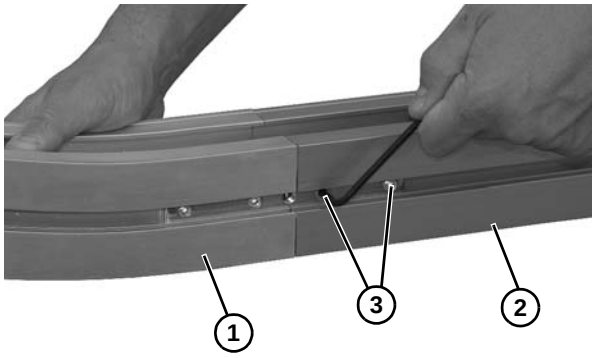


Figure 6

Curves

Typical Curve Connecting Components **(Figure 7)**

1	Clamp Plate
2	Conveyor Frames
3	Curve Assembly
4	Set Screw, M8 - 1.25 x 10 mm

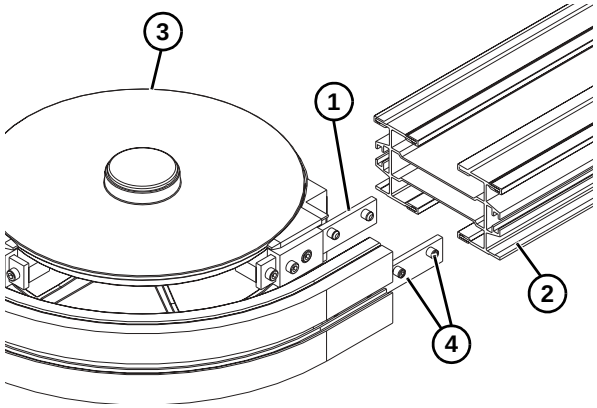


Figure 7

1. Remove two screws **(Figure 8, item 1)** and guard **(Figure 8, item 2)** from curve assembly.

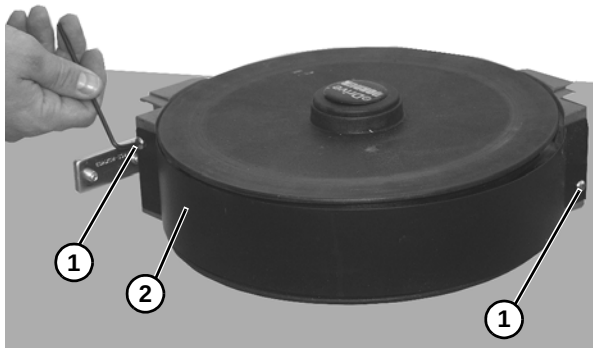


Figure 8

2. Install curve assembly **(Figure 9, item 1)** clamp plates **(Figure 9, item 2)** into one conveyor section **(Figure 9, item 3)** by lining up clamp plate with slot in conveyor frame.

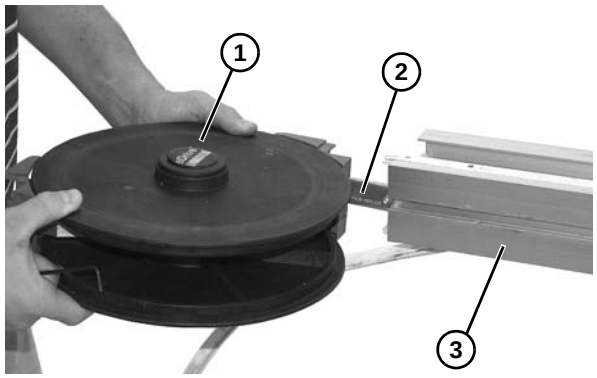


Figure 9

3. Secure with two set screws **(Figure 10, item 1)**. Tighten all set screws 1/4 turn past contact with frame.

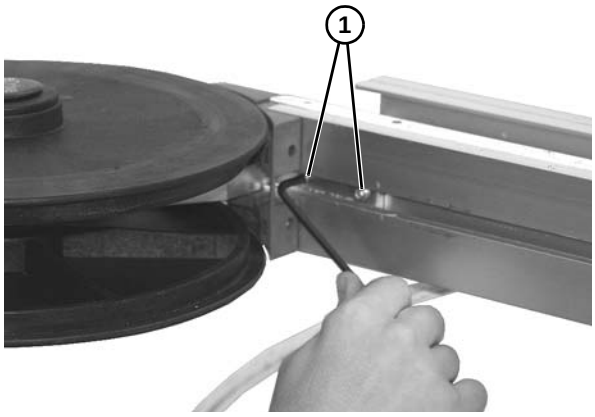


Figure 10

4. Install outer curve frame assembly **(Figure 11, item 1)** clamp plate **(Figure 11, item 2)** into conveyor frame section **(Figure 11, item 3)** by lining up clamp plate with slot in conveyor frame.

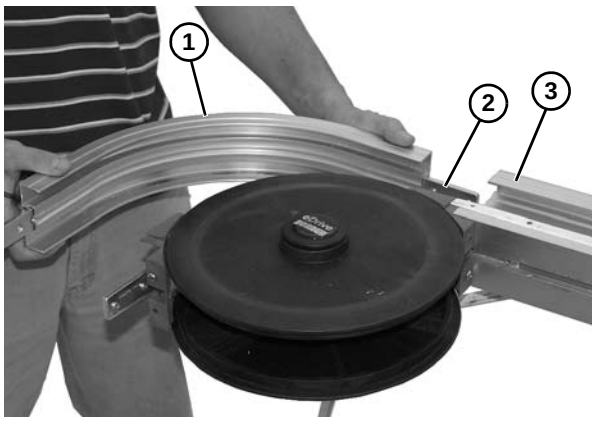


Figure 11

5. Install opposite end of conveyor onto curve assembly, repeating procedure. Tighten all set screws 1/4 turn past contact with frame.
6. Install guard with **(Figure 12, item 1)** two screws **(Figure 12, item 2)**.

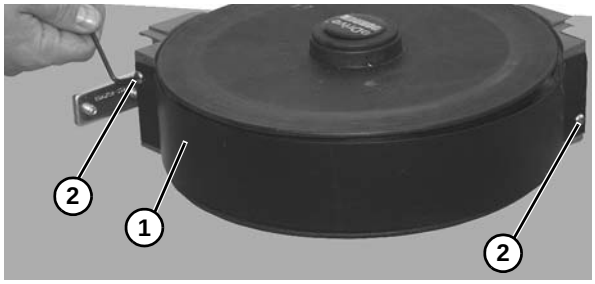


Figure 12

Tails

1. Install tail assembly **(Figure 13, item 1)** clamp plate into conveyor frame section **(Figure 9, item 2)** by lining up clamp plate with slot in conveyor frame.

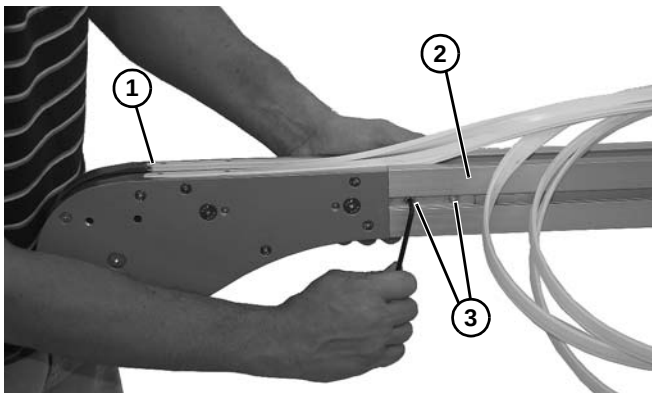


Figure 13

2. Secure with two set screws **(Figure 13, item 3)**. Tighten all set screws 1/4 turn past contact with frame.

Unroll Wear Strips

NOTE
Top and bottom wear strips are shipped pinned/attached at various places on conveyor.

1. **U**nroll wear strip **(Figure 14, item 1)**.

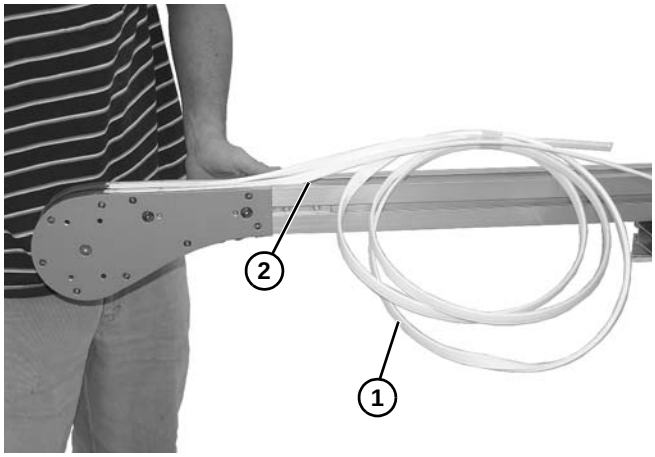


Figure 14

2. Guide wear strip into channel **(Figure 14, item 2)** on conveyor frame.

Mounting Brackets

1. Locate brackets. Exploded views shown in **Figure 15**.

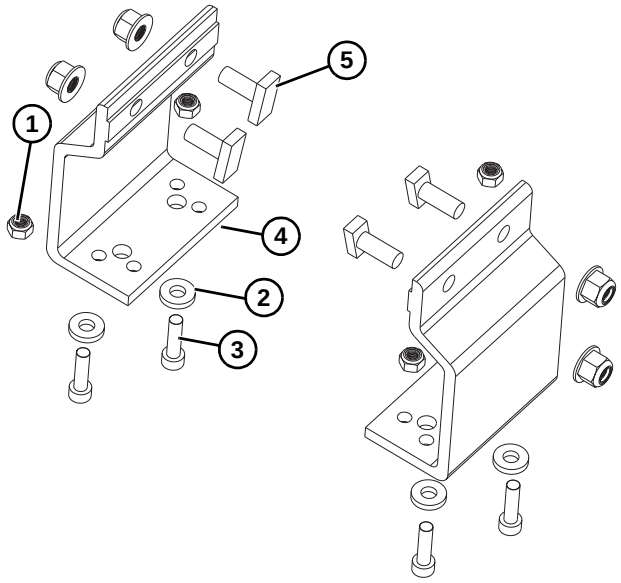


Figure 15

2. Remove nuts **(Figure 15, item 1)**, washers **(Figure 15, item 2)**, and screws **(Figure 15, item 3)** from brackets **(Figure 15, item 4)**.
3. Insert bracket with studs **(Figure 15, item 5)** with head parallel to slot into conveyor side slots.
4. Fasten brackets **(Figure 16, item 1)** to conveyor with nuts **(Figure 16, item 2)** on studs. Turn nuts clockwise to rotate studs in side slots.

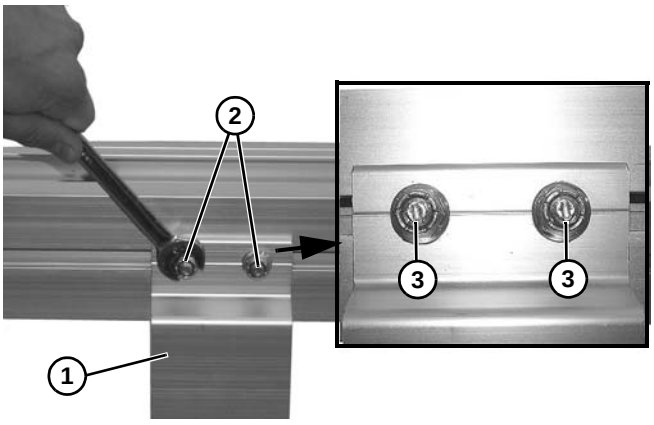


Figure 16

NOTE

*Be certain that stud slot **(Figure 16, item 3)** is close to vertical when finished tightening nut.*

5. Tighten nuts **(Figure 16, item 2)**.

Install Support Stands

NOTE

For detailed assembly instructions, please see your appropriate support stand manual.

1. Fasten brackets **(Figure 17, item 1)** to support stand **(Figure 17, item 2)** with mounting screws, washers, and nuts **(Figure 17, item 3)**.

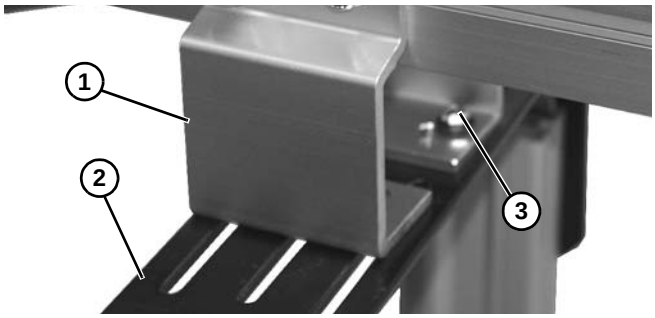


Figure 17

Belt Installation

Typical Belt Components **(Figure 18)**.

1	Chain Belt
2	Belt Rod

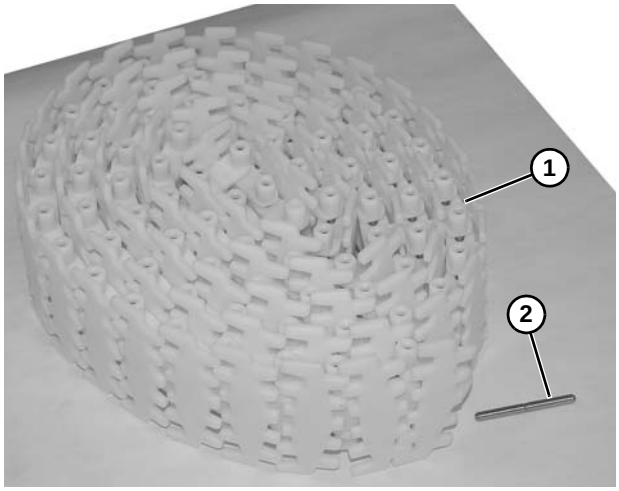


Figure 18

1. Position the belt on the conveyor frame.

2. Install the belt with direction arrow **(Figure 19, item 1)** pointing in direction of belt travel **(Figure 19, item 2)**. Install belt from under tail end **(Figure 19, item 3)** and onto cogs **(Figure 19, item 4)** of shaft.

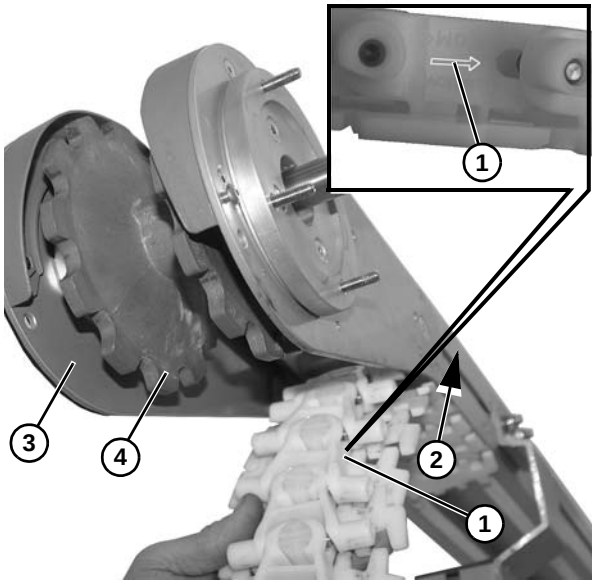


Figure 19

3. Continue wrapping belt **(Figure 20, item 1)** on top of idler tail retaining guide **(Figure 20, item 2)**, continuing to turn shaft **(Figure 20, item 3)** to guide belt around cogs **(Figure 20, item 4)** of shaft.

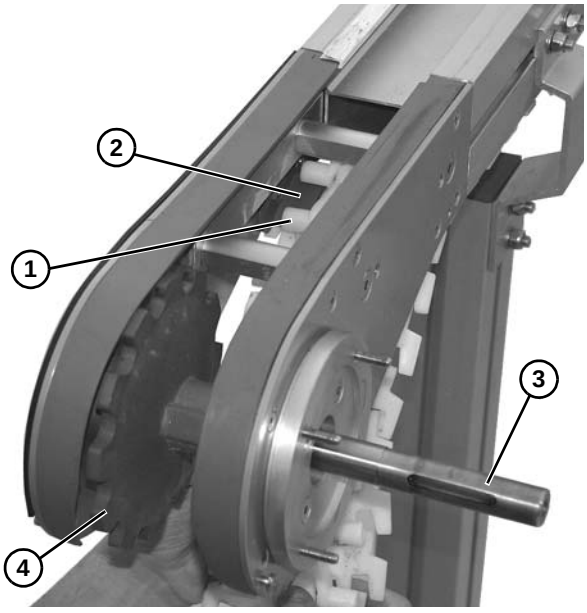


Figure 20

4. Insert the belt rod:

Standard Tail

- Install belt around drive end of conveyor and bring the ends of the belt **(Figure 22, item 1)** together.
- Insert rod **(Figure 22, item 2)**.

NOTE
*Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area **(Figure 21, item 1)** on conveyor drive end.*

- Use punch and hammer or belt removal tool #203480 to press pin just below flush with side of belt. Stop when pin detent is felt.

Figure 21

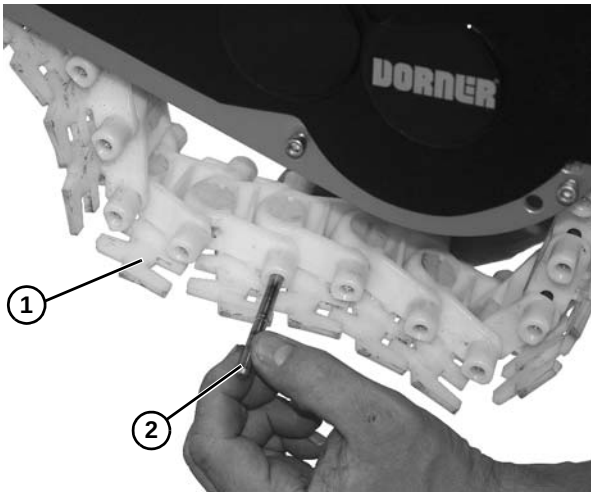


Figure 22

Weighted Take Up Tail

- Install belt around drive end of conveyor and bring the ends **(Figure 23, item 1)** of the belt together.
- Belt should only have enough slack to allow the idler assembly to be installed.
- Insert rod **(Figure 23, item 2)**.
- Use punch and hammer or belt removal tool #203480 to press pin just below flush with side of belt. Stop when pin detent is felt.

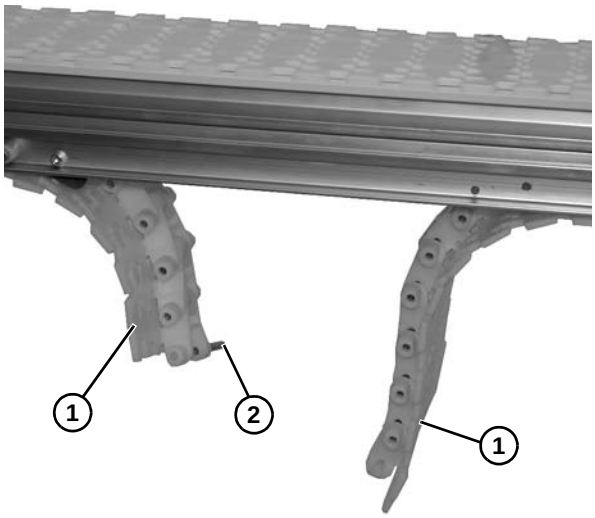


Figure 23

Weighted Take-Up

1. Install idler pulley assembly **(Figure 24, item 1)** onto belt **(Figure 24, item 2)**.

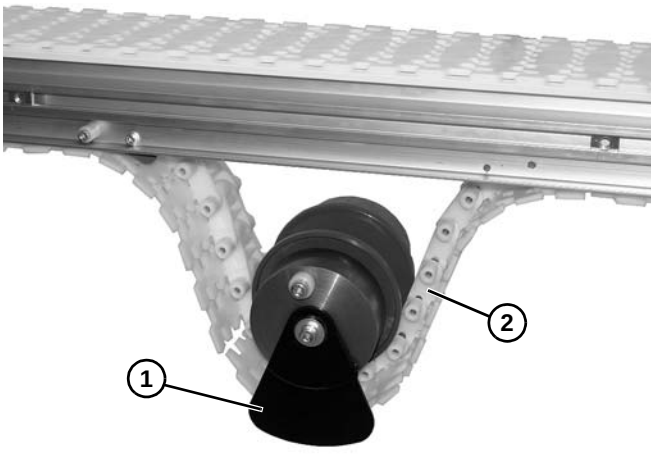


Figure 24

2. Make sure teeth on pulley and guard are facing mating teeth on take up box assembly.
3. Raise weighted take up box assembly, with plate **(Figure 25, item 1)** on idler pulley assembly on outside of outer plate **(Figure 25, item 2)** weighted take up assembly.

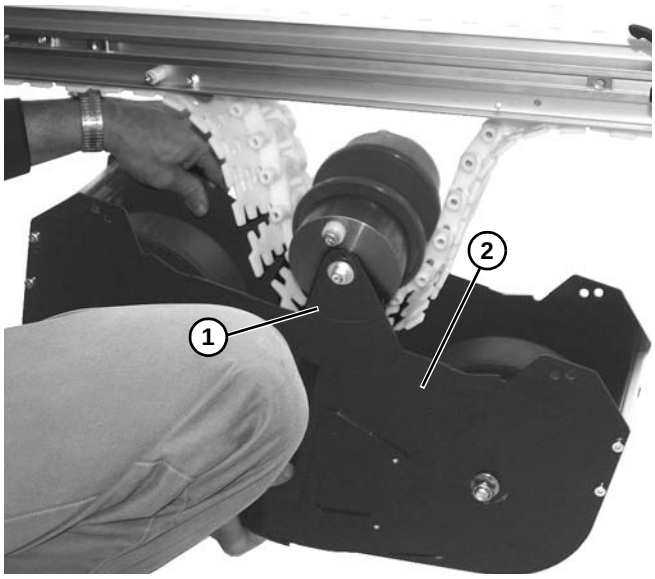


Figure 25

4. Raise weighted take up assembly **(Figure 26, item 1)** with notch **(Figure 26, item 2)** in assembly mating with stud **(Figure 26, item 3)** on conveyor frame.

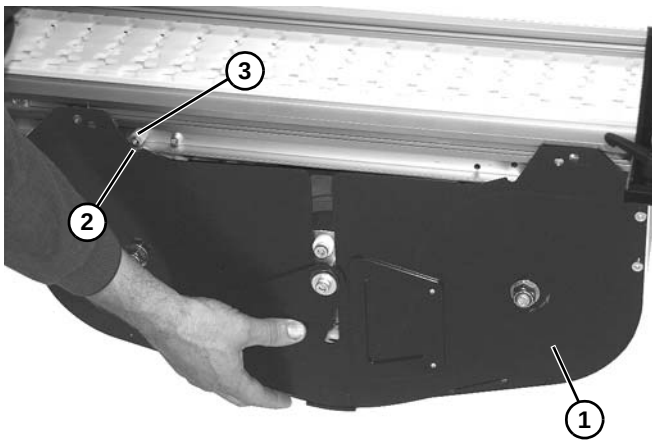


Figure 26

5. Install and tighten two hex head screws **(Figure 27, item 1)** on each side to secure assembly to frame.

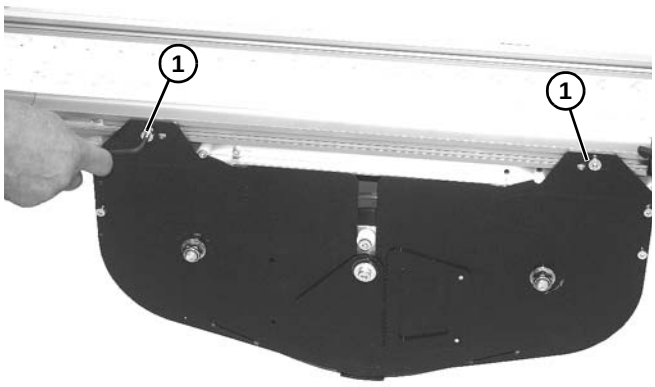


Figure 27

Installation

Top Running Drive

1. Install top running drive assembly **(Figure 28, item 1)** clamp plates into conveyor frame sections **(Figure 28, item 2)** by lining up clamp plates with slots in conveyor frame.

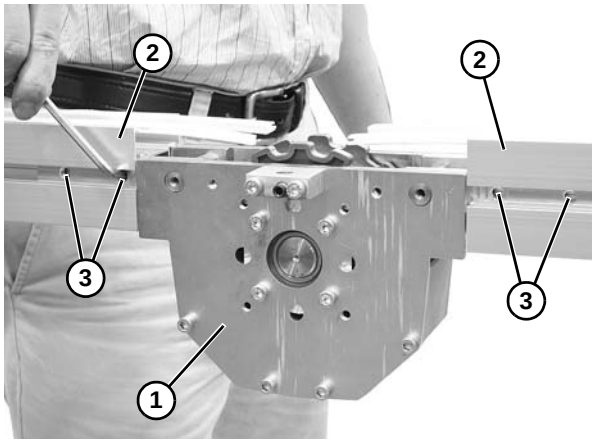


Figure 28

2. Secure with four set screws **(Figure 28, item 3)** on both sides of conveyor. Tighten all set screws 1/4 turn past contact with frame.
3. Install belt with the direction arrow pointing in the direction of belt travel.
4. Install belt around conveyor ends and bring the ends of the belt **(Figure 29, item 1)** together.

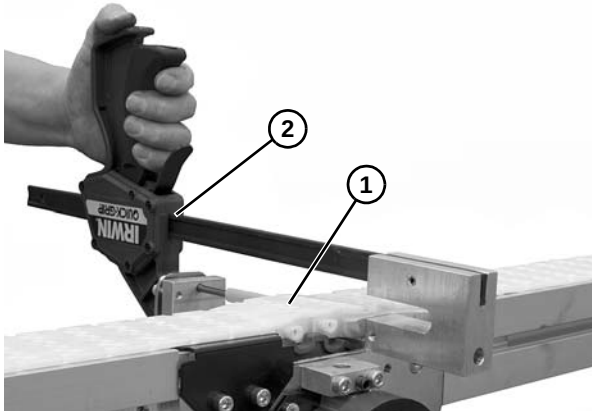


Figure 29

5. Insert the belt rod. Use a punch and hammer or belt removal tool #203480 **(Figure 29, item 2)** to press pin just below flush with side of belt. Stop when pin detent is felt.
6. Install drive motor mounting plate **(Figure 30, item 1)** using four hex head cap screws **(Figure 30, item 2)**.

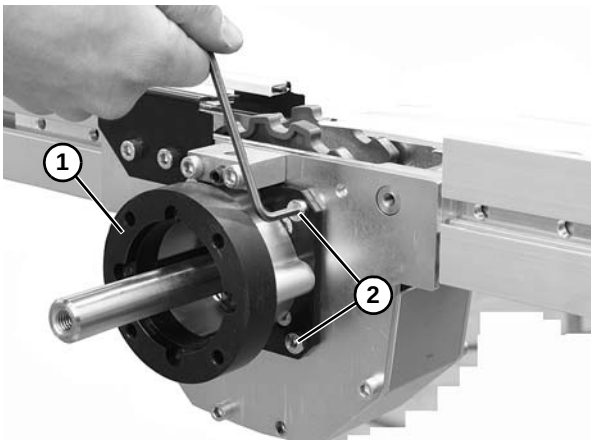


Figure 30

7. Install belt hold down tabs **(Figure 31, item 1)** to drive assembly **(Figure 31, item 2)** using four socket head screws **(Figure 31, item 3)**.

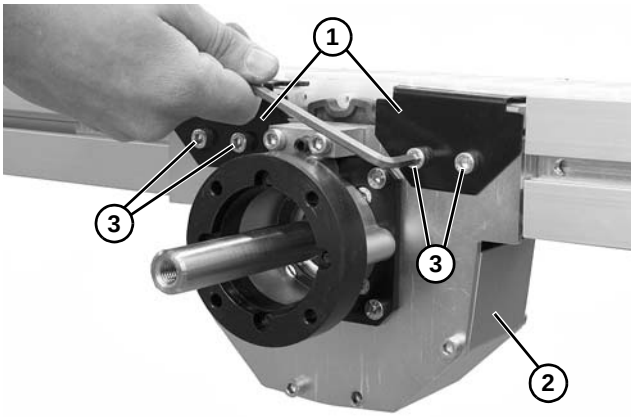


Figure 31

8. Repeat on opposite side.
9. Install belt hold down wheel **(Figure 32, item 1)** and tighten set screw **(Figure 32, item 2)**.

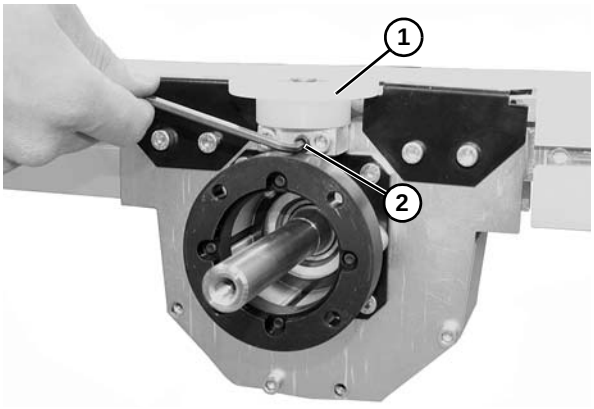


Figure 32

10. Install spacer, washer, and key onto drive shaft.
11. Install drive package **(Figure 33, item 1)** to drive motor mounting bracket **(Figure 33, item 2)** using four socket head screws **(Figure 33, item 3)**.

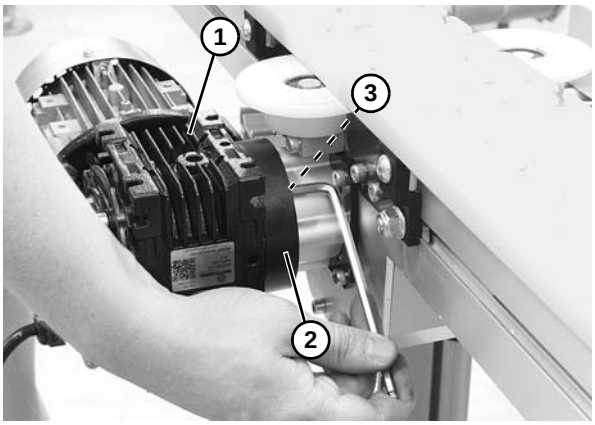


Figure 33

12. Install and tighten flat head screw **(Figure 34, item 1)** onto the drive shaft.

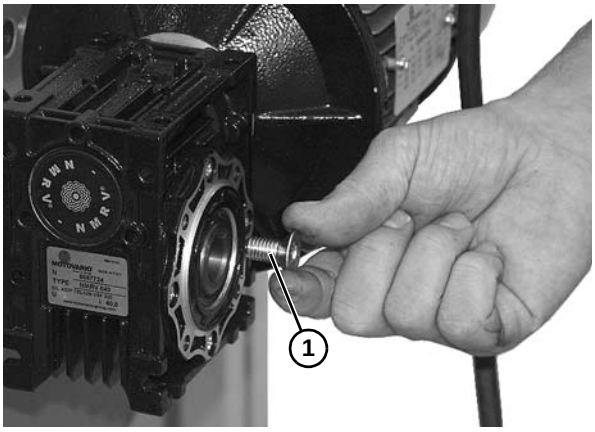


Figure 34

Install Guiding

All guiding must be located and installed by the end user.

Standard 1.5" and 3" Guiding

1. Install stud **(Figure 35, item 1)** onto retaining clip **(Figure 35, item 2)** with nut **(Figure 35, item 3)**.

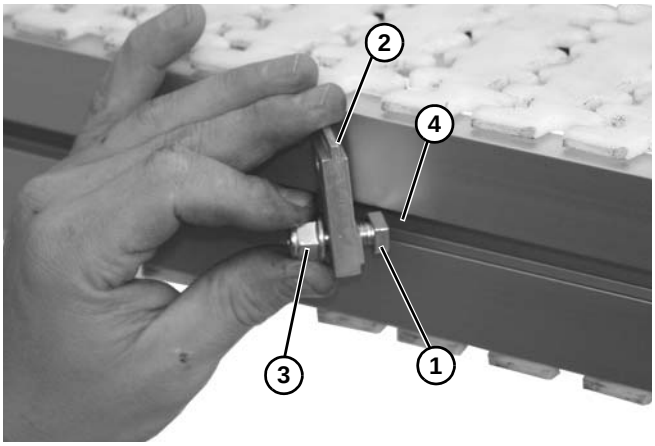


Figure 35

2. Install stud **(Figure 35, item 1)** into side rail channel **(Figure 35, item 4)**. The end clips should be no greater than 12" from end of the conveyor.
3. Fasten retaining clip **(Figure 36, item 1)** to conveyor with nut **(Figure 36, item 2)** on stud.

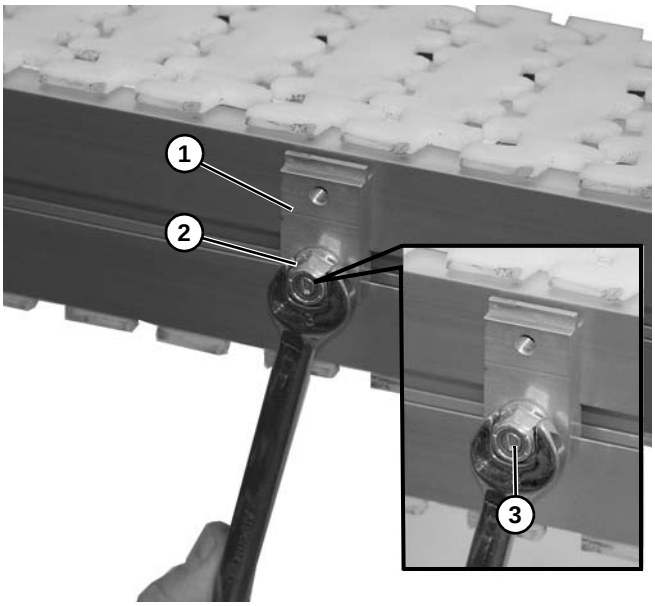


Figure 36

NOTE
*Be certain that slot **(Figure 36, item 3)** is close to vertical when finished tightening nut.*

4. Tighten nuts **(Figure 36, item 2)**.

5. Install guide **(Figure 37, item 1)** and retaining clip **(Figure 37, item 2)** to conveyor side rail with socket head screw **(Figure 37, item 3)**.

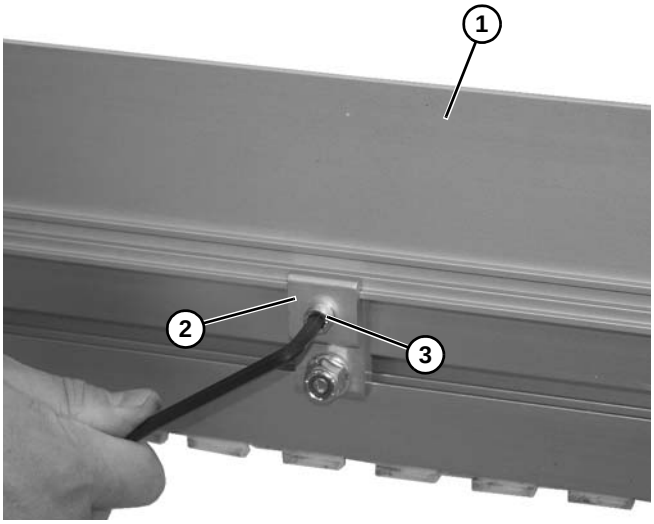


Figure 37

Puck/Pallet Guiding

1. Install clip assembly **(Figure 38, item 1)** into side rail channel **(Figure 38, item 2)**. The end clips should be no greater than 12" from the end of the conveyor.

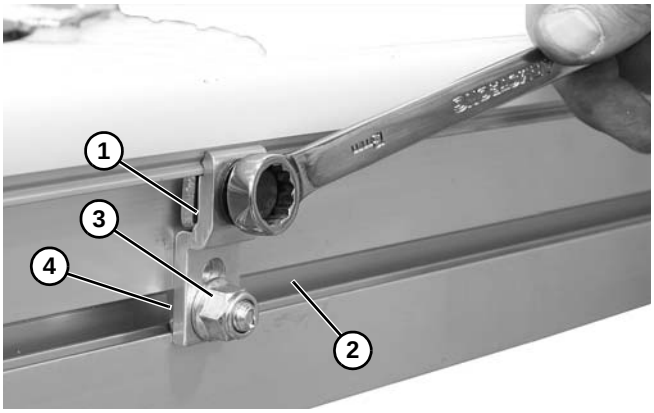


Figure 38

NOTE

*Make sure that the studs **(Figure 38, item 4)** rotate inside the channel and engage with the conveyor.*

2. Fasten clip **(Figure 38, item 1)** to conveyor with nut **(Figure 38, item 3)** on stud.

3. Tighten nuts **(Figure 39, item 1)**.

NOTE

*Be certain that slot **(Figure 39, item 2)** is close to vertical when finished tightening nut.*

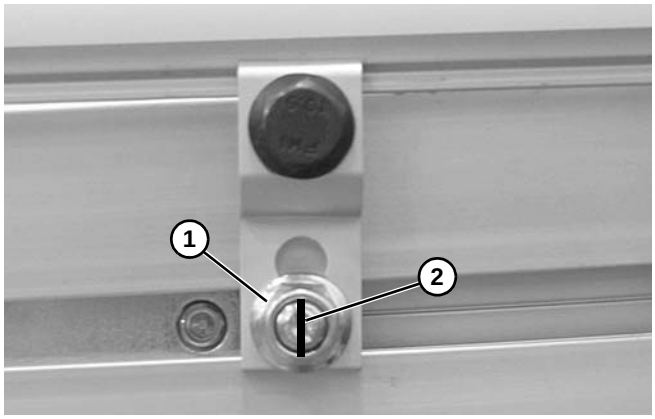


Figure 39

4. Attach wear strip **(Figure 40, item 1)** to guiding **(Figure 40, item 2)**.

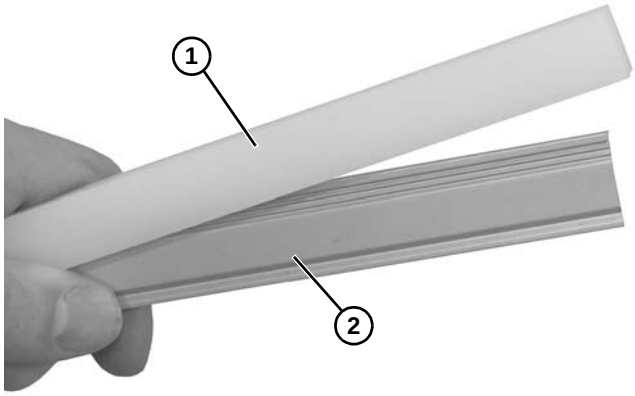


Figure 40

5. Attach guiding **(Figure 41, item 1)** to clip **(Figure 41, item 2)** and tighten screw **(Figure 41, item 3)**.

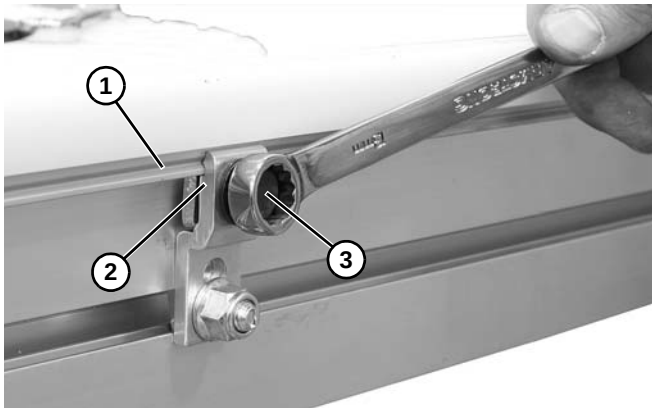


Figure 41

Fully Adjustable Guiding

1. Install stud **(Figure 42, item 1)** on guiding assembly **(Figure 42, item 2)** into side rail channel **(Figure 42, item 3)**. The end guiding assemblies should be no greater than 12" from end of the conveyor.

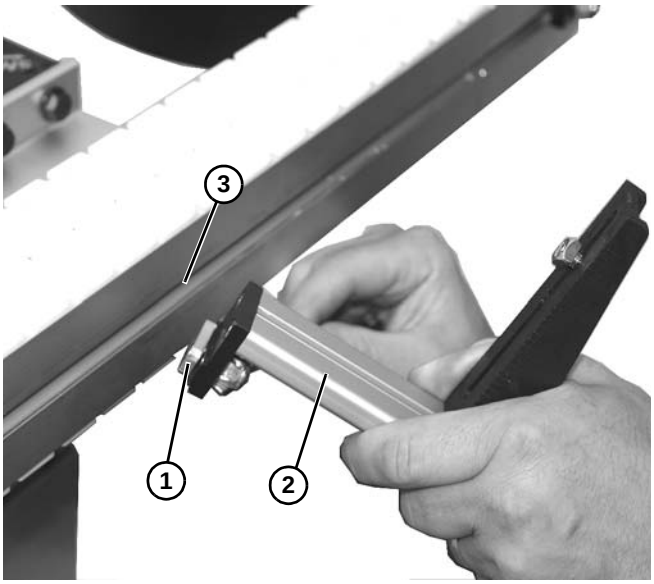


Figure 42

2. Tighten stud on guiding assembly **(Figure 43, item 1)** to conveyor with nut **(Figure 43, item 2)** on stud.

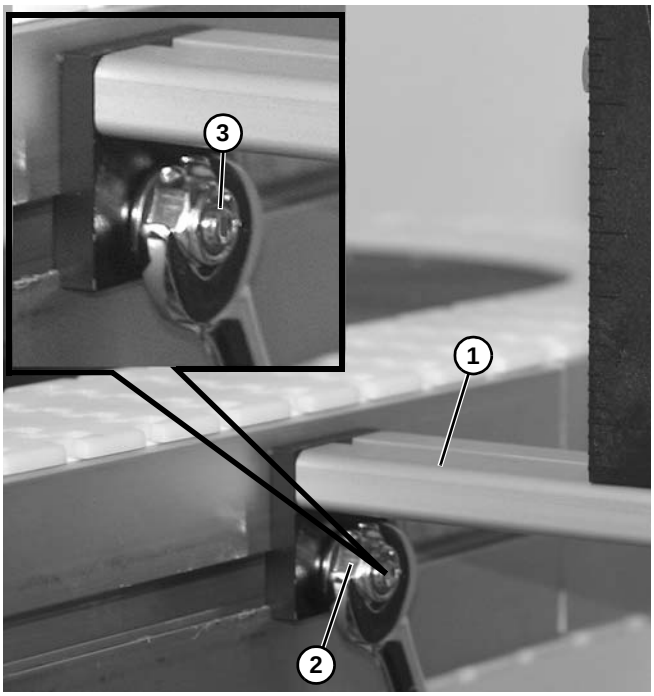


Figure 43

NOTE

*Be certain that slot **(Figure 43, item 3)** is close to vertical when finished tightening nut.*

3. Tighten nuts **(Figure 43, item 2)**.
4. Install guide rail **(Figure 44, item 1)** onto square nut **(Figure 44, item 2)** onto mounting bracket **(Figure 44, item 3)** with socket head screw **(Figure 44, item 4)** or handle **(Figure 45, item 1)** for tool-less guiding.

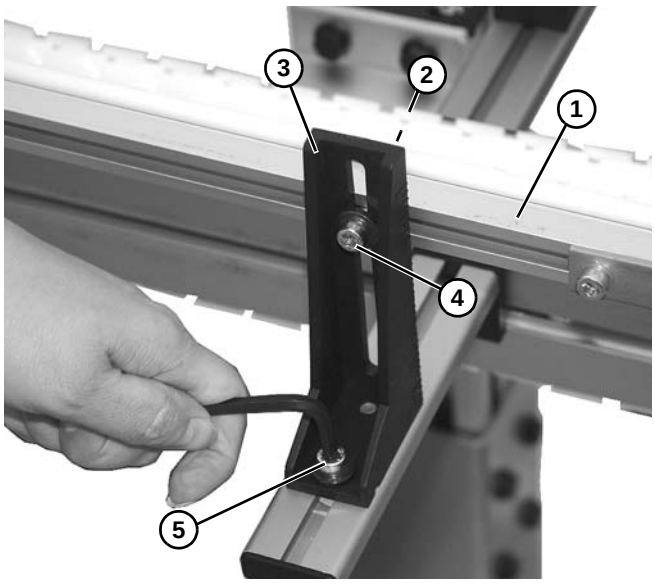


Figure 44

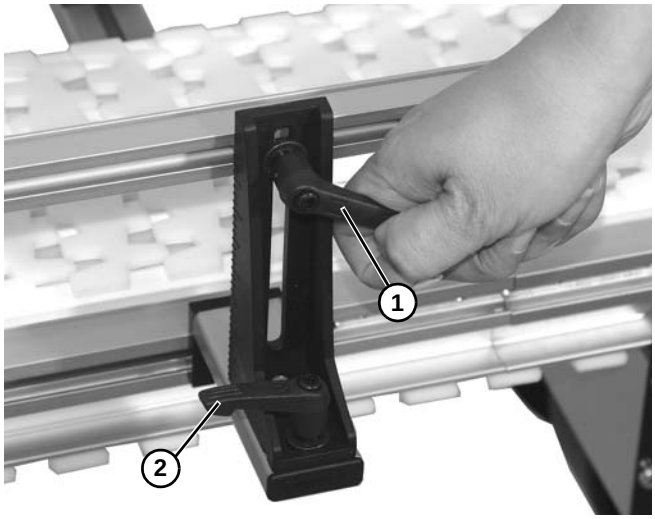


Figure 45

5. Loosen socket head screw **(Figure 44, item 5)** or handle **(Figure 45, item 2)** and adjust mounting bracket **(Figure 44, item 3)** as needed.

6. For curves, install inside of curve guide rail **(Figure 46, item 1)** to straight guide rails **(Figure 46, item 2)**. Tighten set screws **(Figure 46, item 3)**.

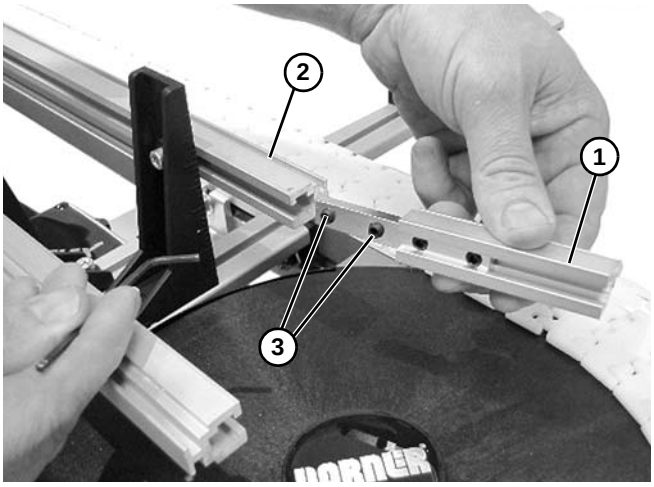


Figure 46

7. To install curve assembly guiding, start at one end of the conveyor and slide the guiding over the guide rails.
8. On the inside of the curve, install inner guiding **(Figure 47, item 1)** onto both of the inner guide rails **(Figure 47, item 2)**.

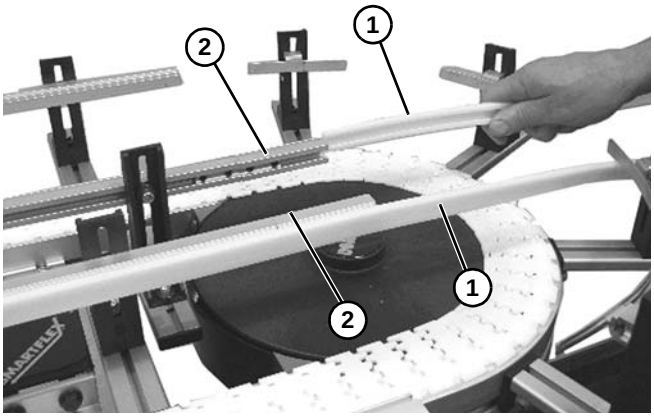


Figure 47

9. On outside of curve, install guiding **(Figure 48, item 1)** on the guide supports **(Figure 48, item 2)**.

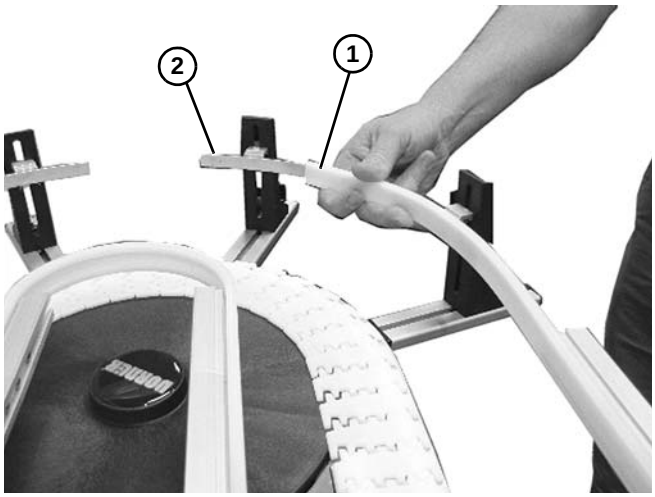


Figure 48

10. To adjust guiding width loosen screws **(Figure 44, item 5)** or handle **(Figure 45, item 2)**. Adjust to desired width. Tighten screw or handle.
11. To adjust guiding height loosen screws **(Figure 44, item 4)** or handle **(Figure 45, item 1)**. Adjust to desired height. Tighten screw or handle.

Install Drive Package

1. Install spacer (when applicable) **(Figure 49, item 1)**, washer **(Figure 49, item 2)**, and key **(Figure 49, item 3)** onto drive shaft.

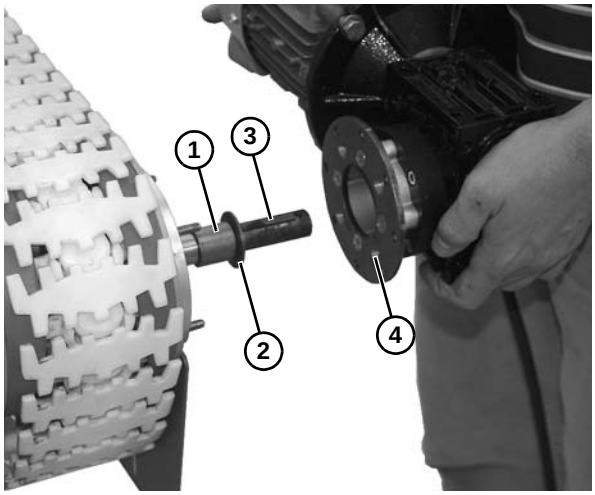


Figure 49

2. Attach the motor **(Figure 49, item 4)** onto the drive shaft.
3. Install four washers **(Figure 50, item 1)** and nuts **(Figure 50, item 2)** to secure motor to conveyor.

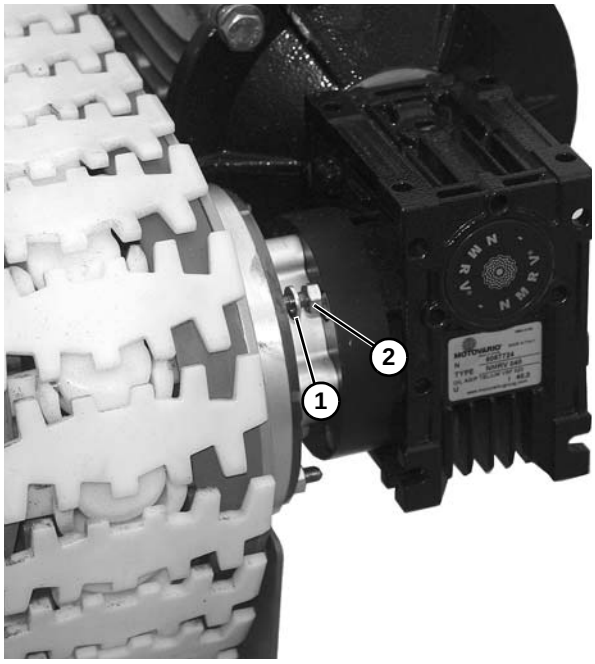


Figure 50

4. Install and tighten flat head screw **(Figure 51, item 1)** onto the drive shaft.

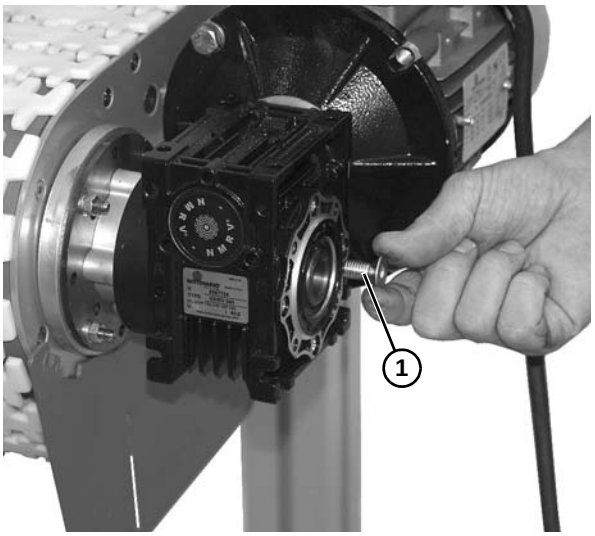


Figure 51

5. Install drive motor stand mounting bracket **(Figure 52, item 1)** onto the drive motor **(Figure 52, item 2)** with four washers and socket head screws **(Figure 52, item 3)**.

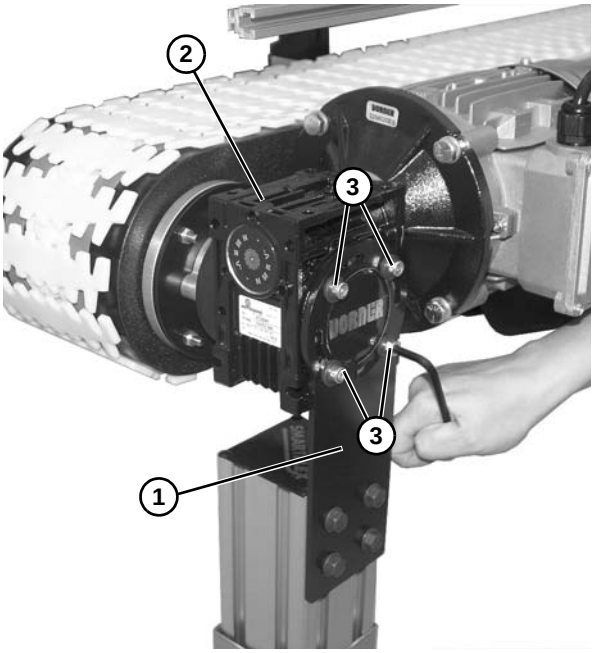


Figure 52

Preventive Maintenance and Adjustment

Required Tools

- 3/32" hex wrench
- 3 mm hex wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 10 mm wrench
- 13 mm wrench
- 16 mm wrench
- Belt Removal Tool #203480

Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 46 for recommendations.
- Replace any worn or damaged parts.

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

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

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.

Replacing a Section of Belt

1. Use a punch and hammer or belt removal tool #203480 to push the belt rod **(Figure 53, item 1)** out by striking the rod end.

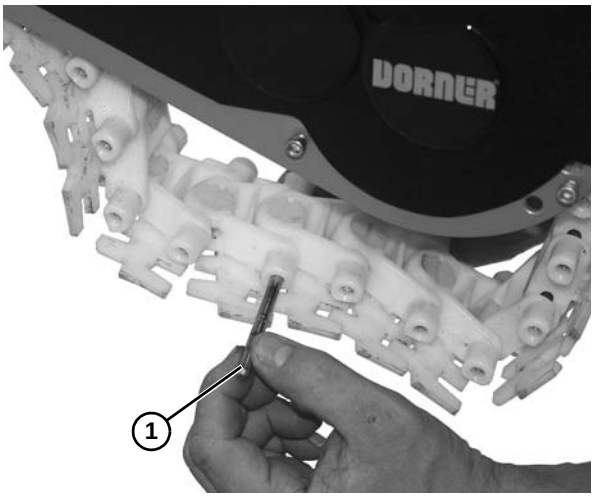


Figure 53

⚠ WARNING

SEVERE HAZARD!

If conveyor belt is damaged or worn, replace belt section.

2. Remove the belt rods on both sides of the section of belt being replaced.
3. Replace old section of belt.

⚠ CAUTION

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

NOTE

*Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area **(Figure 54, item 1)** on convey or drive end.*

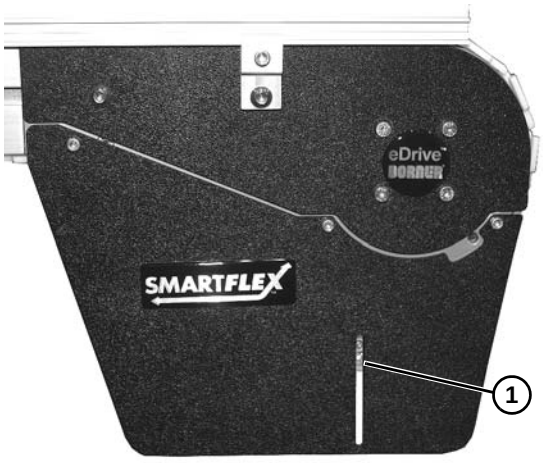


Figure 54

Replacing the Entire Belt

1. Use a punch and hammer or belt removal tool #203480 to push the belt rod **(Figure 55, item 1)** out by striking the rod end.

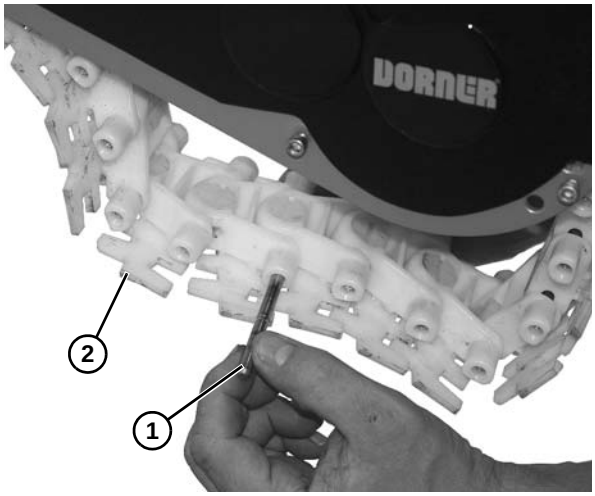


Figure 55

2. Slide the old belt **(Figure 55, item 2)** off the conveyor frame.
3. Replace the old belt with a new one. Refer to "Belt Installation" on page 15.

NOTE

Drive spindle shaft assembly replacement is recommended with belt replacement (see "Drive Spindle Shaft Assembly" on page 30).

⚠ 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

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

1. Remove one or more belt links to take up tension. Refer to "Replacing a Section of Belt" on page 24.

NOTE

*Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area **(Figure 56, item 1)** on convey or drive end.*

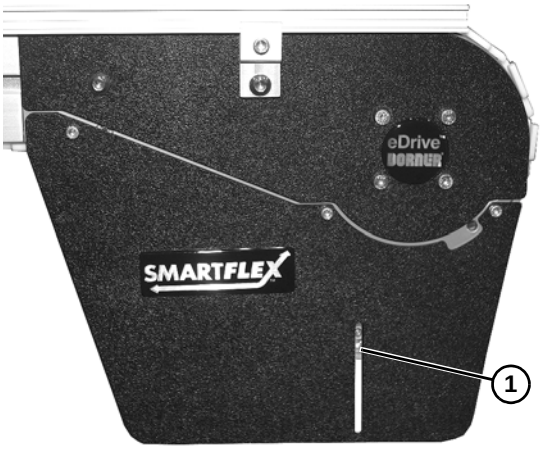


Figure 56

Wear Strip Removal

Replace the wear strips if they become worn.

NOTE

Top and bottom wear strips are shipped pinned/attached at various places on conveyor.

1. Remove belt. See “Conveyor Belt Replacement” on page 24.
2. Remove wear strip **(Figure 57, item 1)** from top of frame assembly up to pinned end **(Figure 57, item 2)**.

Figure 57

3. Cut and remove worn wear strip section and replace with new wear strip. See “Wear Strip Installation” on page 26.
4. Remove lower wear strips, as needed, repeat procedure used for upper wear strips.

Wear Strip Installation

1. Remove wear strips. See “Wear Strip Removal” on page 26.

Attaching Wear Strip on Straight Frame

1. Start the wear strips **(Figure 58, item 1)** at an idler end **(Figure 58, item 2)** of conveyor. Separate the top and bottom flange of the wear strip at the end of rail and press into place.

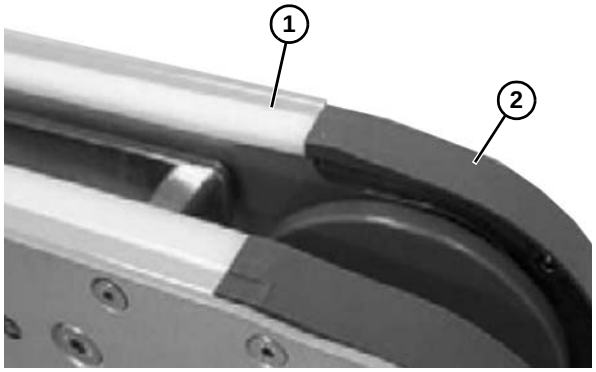


Figure 58

2. Make sure the wear strip **(Figure 59, item 1)** is properly mounted and snaps onto the frame **(Figure 59, item 2)**. Please identify the longer flange of the wear strip must always face the inside of the conveyor.

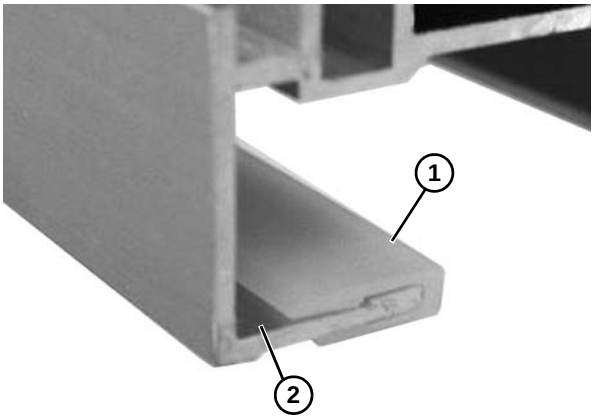
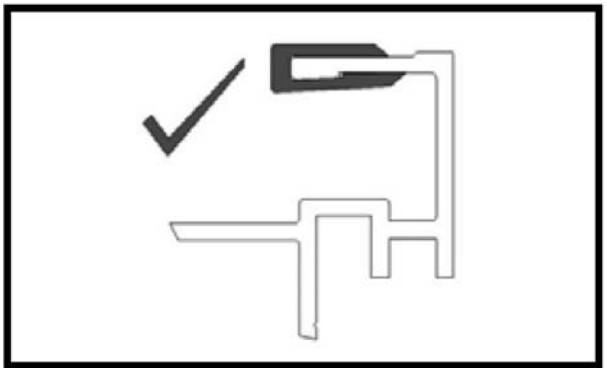
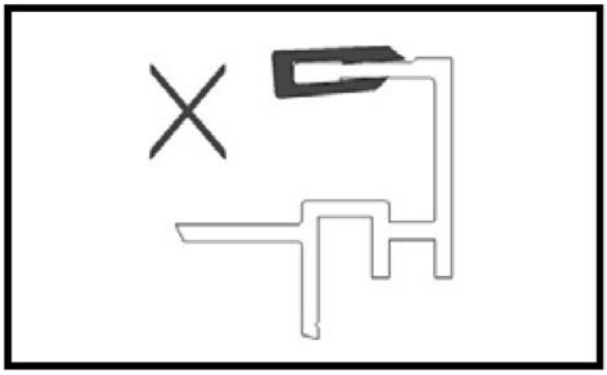


Figure 59



Correct Installation



Wrong Installation

Attaching Wear Strip on Conveyor Frame

1. Cut both wear strip **(Figure 60, item 1)** ends in a 45° angle. The beginning of a new wear strip (in the direction of travel) must cut back a small angle.

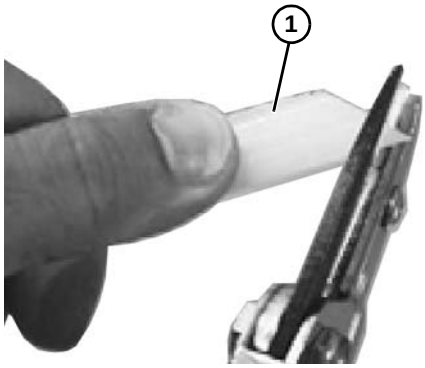


Figure 60

2. Allow a space of approximately 1/16" to 1/8" **(Figure 61, item 1)** between two wear strip ends. The travel direction is indicated by arrow.

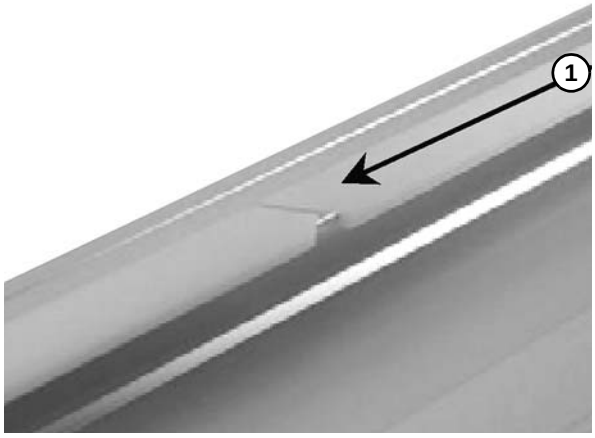


Figure 61

3. Do not place two wear strip joints opposite each other. Make sure there is a distance of at least 4" **(Figure 62, item 1)** between them to make the chain run smoother. This does not apply to a wear strip that begins by an idler unit or after a drive tail, where joints are always parallel.

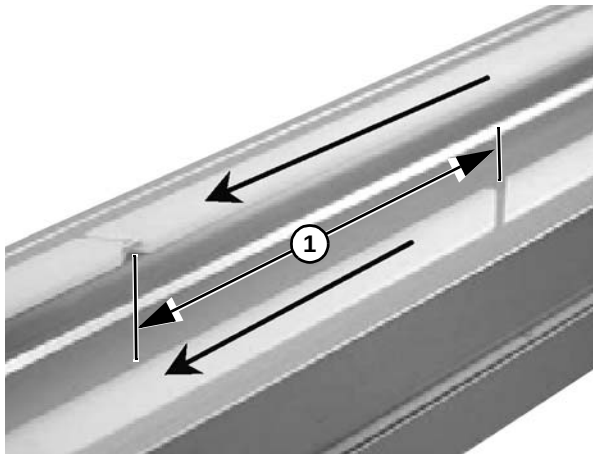


Figure 62

NOTE

Try to let the wear strip run in as continuous lengths as possible by reducing number of breaks, except in circumstances stated below:

- *It is recommended to use short wear strips (75"- 100") where chemicals may have an effect on the wear strip composition.*
- *It is important to cut the wear strip and allow for elongation in high load areas. Cutting is required in wheel bends (see following page), at idler tails and where the conveyor will be heavily loaded, especially at drive unit. This prevents the wear strip from stretching out and entering into the drive tail, which may block the chain movement.*
- *Never join wear strip in horizontal or vertical bends, since forces are higher on the wear strip side in these sections. Instead, place the joint before the bend.*
- *Avoid joining wear strips on top of the conveyor frame joints.*

Attaching Wear Strip at Wheel Bend

1. Cut the wear strip end flat **(Figure 63, item 1)**. Make sure there is no gap created at the plastic molding part.

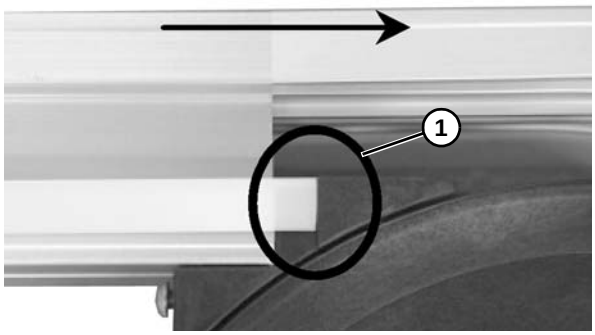


Figure 63

2. The step is applied onto out feed end **(Figure 64, item 1)** as well.

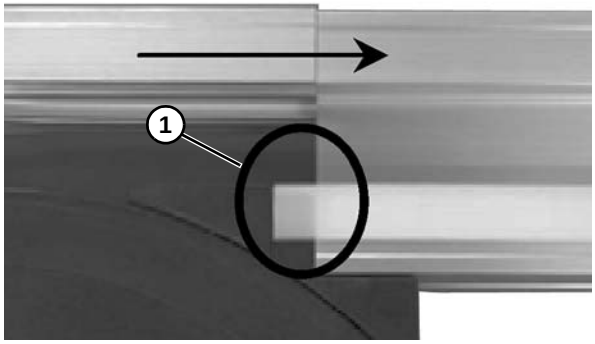


Figure 64

3. In the outer bend **(Figure 65, item 1)**, make sure that the wear strip is properly connected to the conveyor frame.

Figure 65

Attaching Wear Strip

1. Attach wear strip replacement tool **(Figure 66, item 1)** over wear strip **(Figure 66, item 2)** and frame near the beginning of each wear strip section. Tightly secure in place.

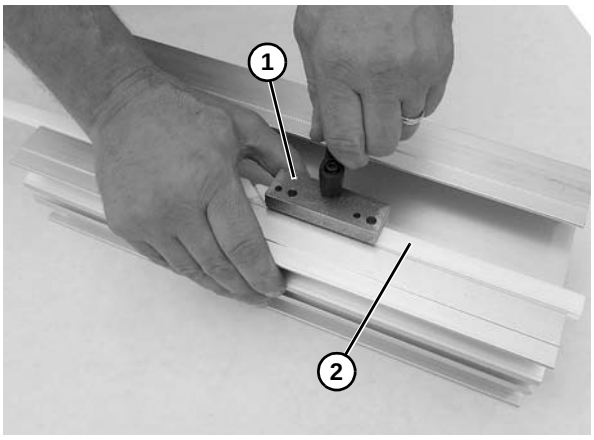


Figure 66

2. Using the wear strip replacement tool **(Figure 67, item 1)** drill two holes through the two small location holes **(Figure 67, item 2)** through the wear strip and frame using the #18 drill bit from the wear strip replacement kit.

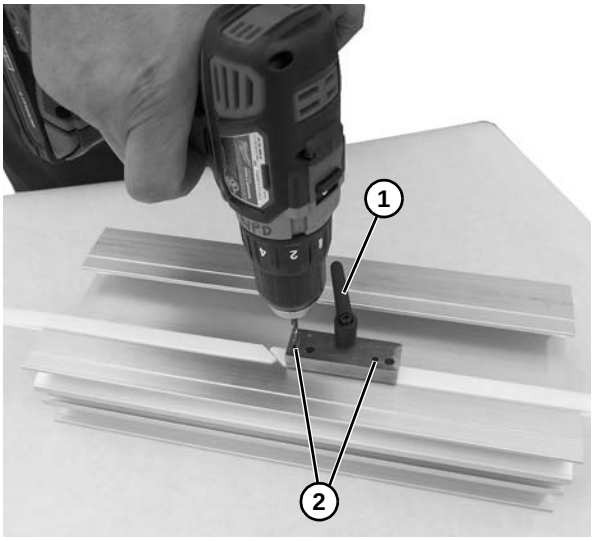


Figure 67

3. Remove debris from conveyor frame.
4. Relocate wear strip replacement tool to align the two larger guide holes with the holes drilled in the frame.

5. Pressing down firmly, install nylon set screws **(Figure 68, item 1)** through larger guide holes **(Figure 68, item 2)** into conveyor frame.

NOTE
Nylon set screw should be almost flush with the wear strip top when installed correctly.

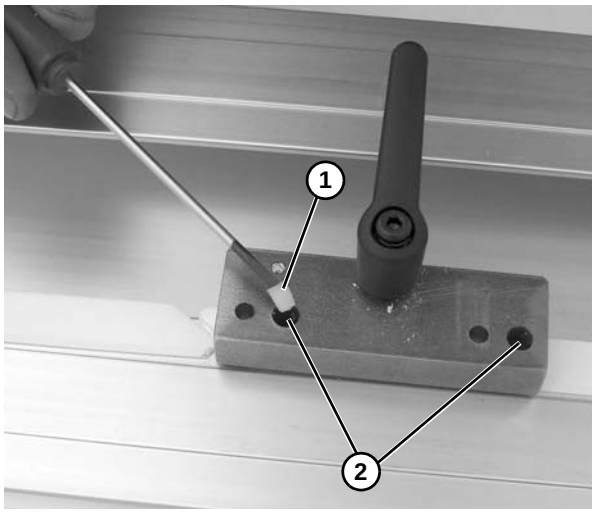


Figure 68

6. Using a file, scrape off the top of the nylon set screw above the wear strip **(Figure 69, item 1)** to assure a smooth surface for the belt.

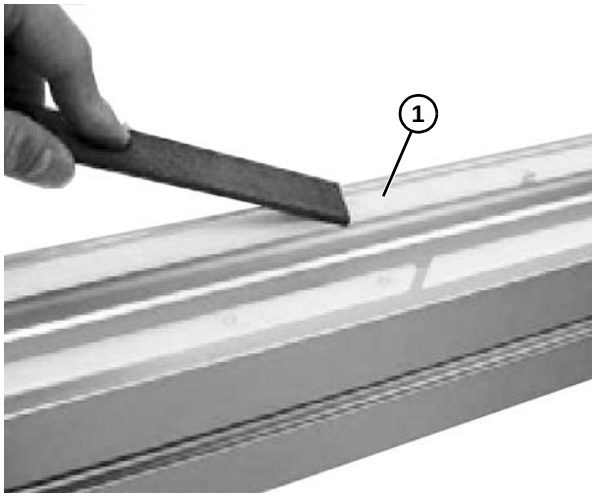


Figure 69

Idler Pulley Assembly

⚠ WARNING

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

1. Remove three flat head screws **(Figure 70, item 1)**.

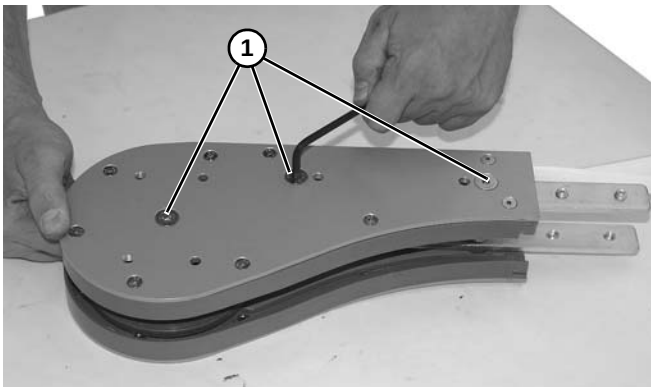


Figure 70

2. Remove the head plate **(Figure 71, item 1)** from the idler end.

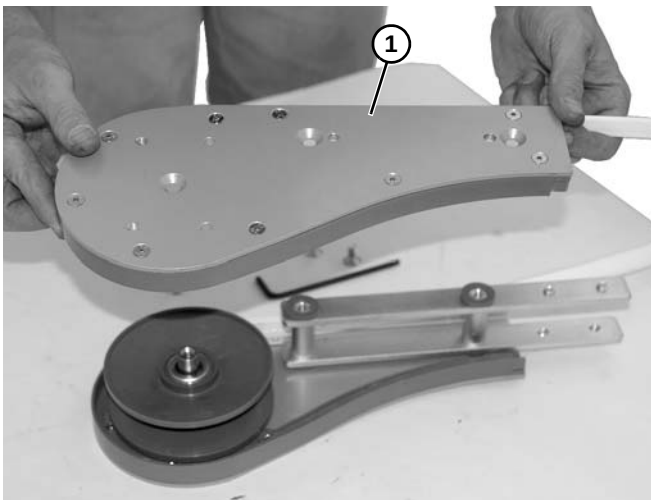


Figure 71

3. Remove flat head screw **(Figure 72, item 1)** and remove idler pulley **(Figure 72, item 2)** from idler head plate assembly.

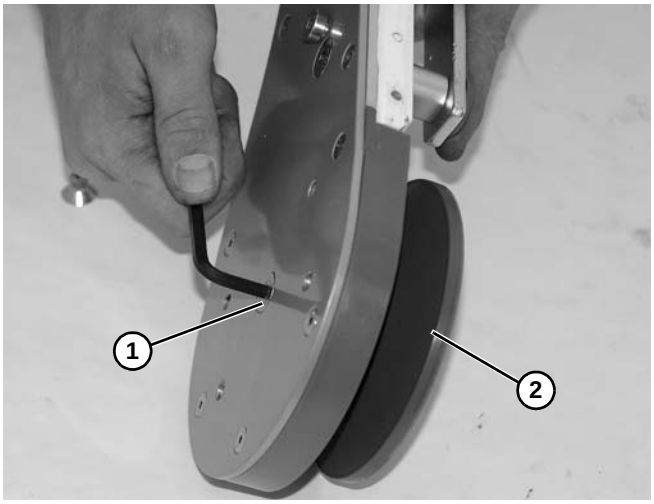


Figure 72

4. Install components reverse of removal.

Drive Spindle Shaft Assembly

⚠ WARNING

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

1. Remove the gearmotor.
2. Loosen two socket head set screws **(Figure 73, item 1)** on each side of conveyor, and remove the drive tail assembly **(Figure 73, item 2)** from the conveyor frame **(Figure 73, item 3)**.

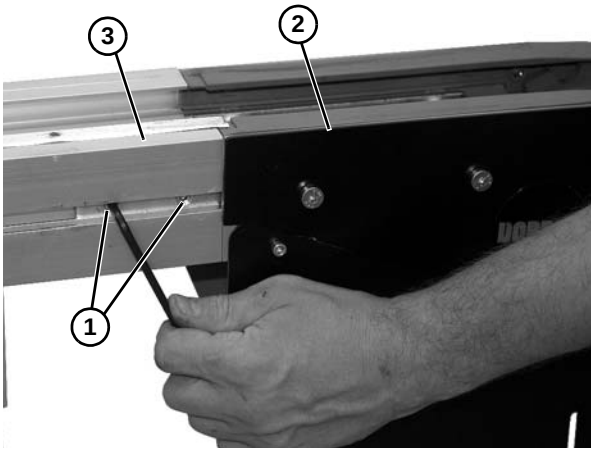


Figure 73

3. Remove four socket head screws **(Figure 74, item 1)** on side of drive spindle.

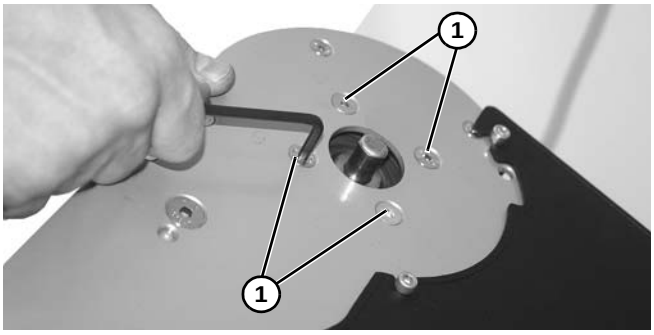


Figure 74

4. Remove two socket head screws **(Figure 75, item 1)** on side of drive spindle.

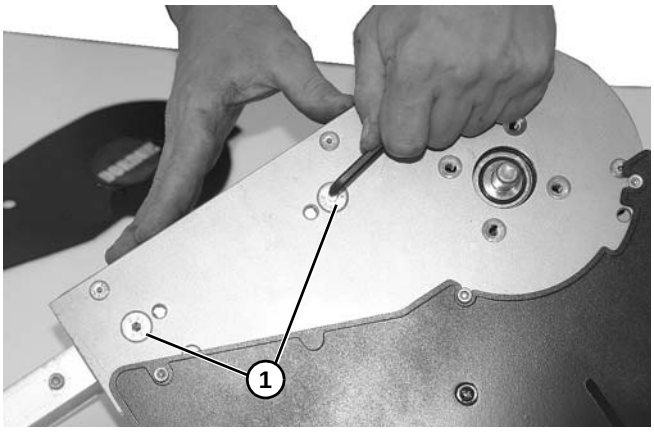


Figure 75

5. Remove the head plate **(Figure 76, item 1)** from the drive end.

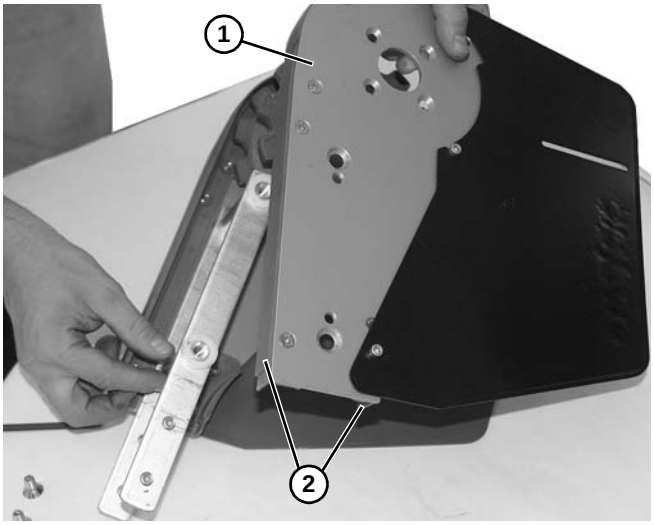


Figure 76

6. To remove upper and lower retaining guides **(Figure 76, item 2)**, see "Retaining Guide Replacement" on page 32.

7. Remove spindle shaft assembly **(Figure 77, item 1)** from idler head plate assembly.

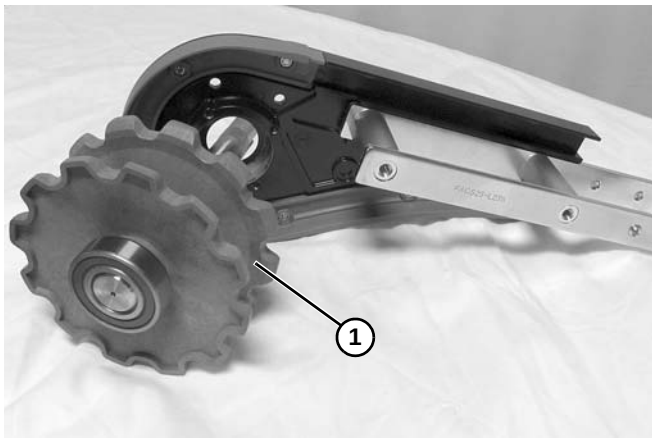


Figure 77

8. Install components reverse of removal.

Retaining Guide Replacement

Cantenary Drive End

1. Remove drive spindle shaft assembly. See “Drive Spindle Shaft Assembly” on page 30.
2. Remove three socket head screws **(Figure 78, item 1)** and remove drive plate guard **(Figure 78, item 2)** from drive plate **(Figure 78, item 3)**.

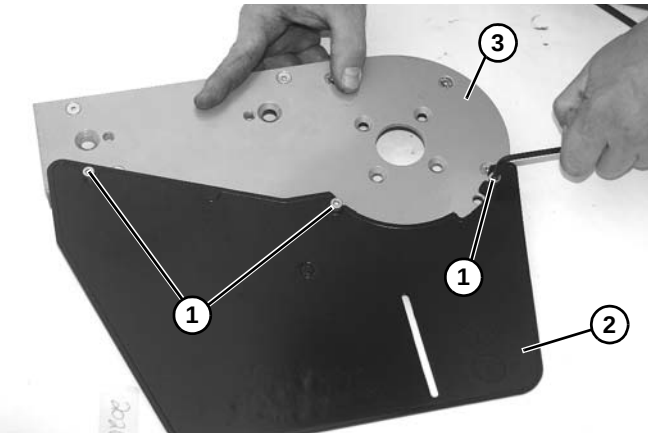


Figure 78

3. Remove two socket head screws **(Figure 79, item 1)**.

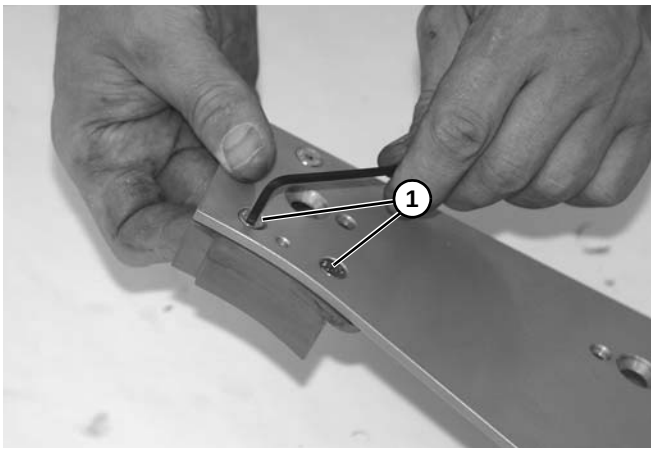


Figure 79

4. Remove lower retaining guide **(Figure 80, item 1)** from drive plate **(Figure 80, item 2)**.

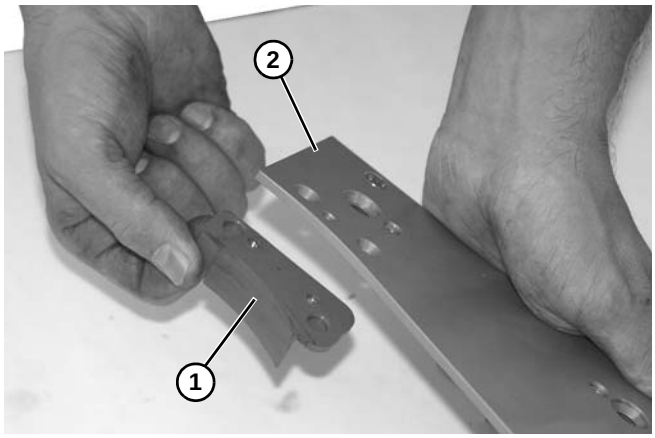


Figure 80

5. Remove three socket head screws **(Figure 81, item 1)**.

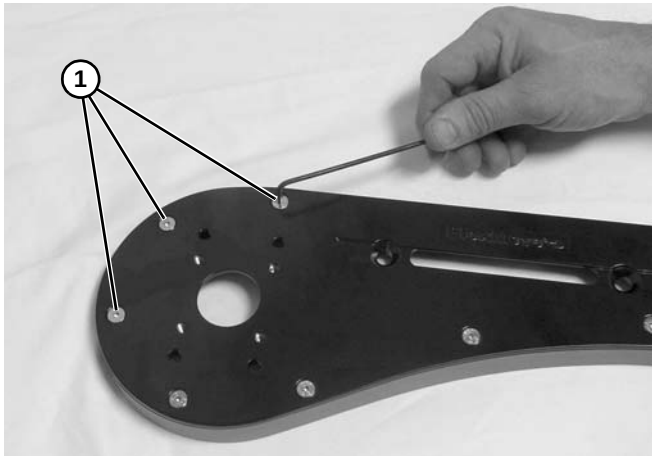


Figure 81

6. Remove upper retaining guide **(Figure 82, item 1)** from drive plate **(Figure 82, item 2)**.

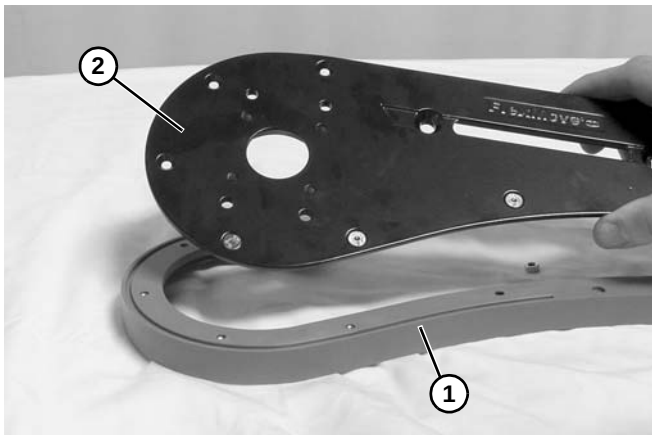


Figure 82

7. Install components reverse of removal.

Idler End and GTU Drive Tail

1. Remove idler pulley assembly. See “Idler Pulley Assembly” on page 30.
2. Remove seven (7) socket head screws **(Figure 83, item 1)** from idler head plate assembly.

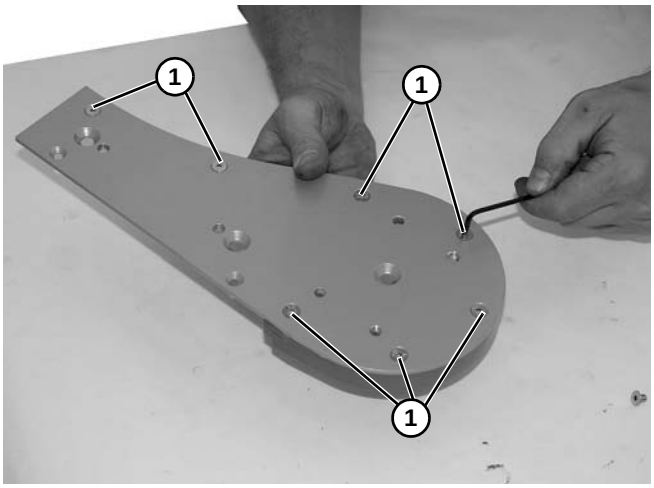


Figure 83

3. Remove retaining guide **(Figure 84, item 1)** from idler head plate assembly **(Figure 84, item 2)**. Replace components, as needed.

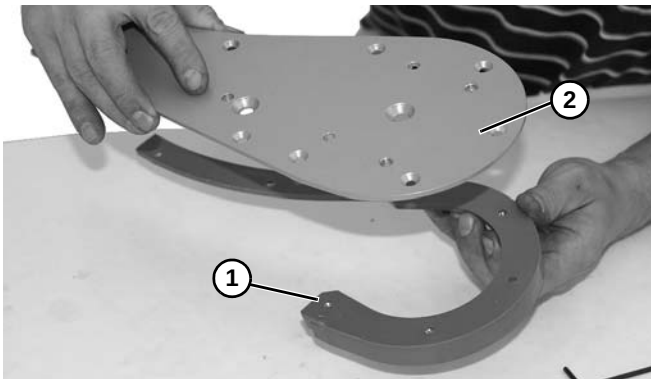


Figure 84

4. Install components reverse of removal.

Top Running Drive

1. Remove four socket head screws **(Figure 85, item 1)**. Remove drive package **(Figure 85, item 2)** from drive motor mounting bracket **(Figure 85, item 3)**.

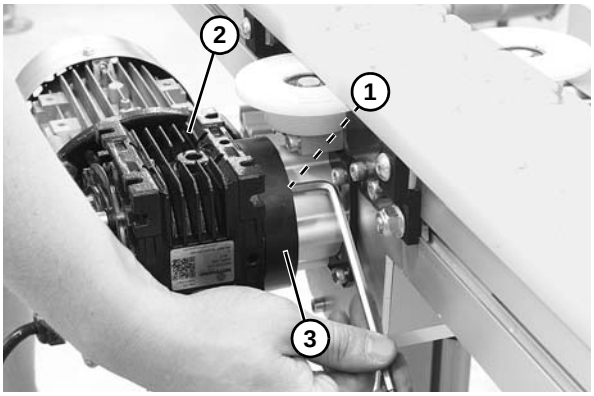


Figure 85

2. Loosen set screw **(Figure 86, item 1)** and remove belt hold down wheel **(Figure 86, item 2)**.

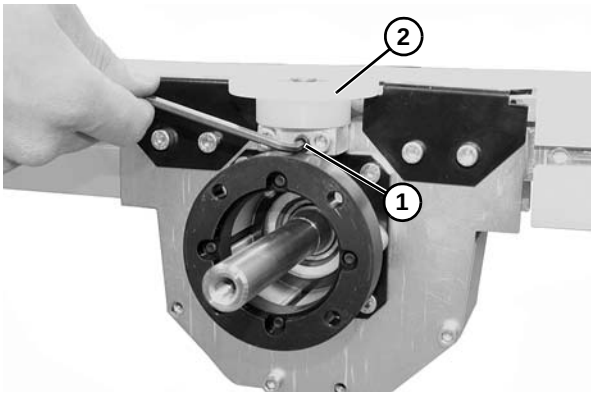


Figure 86

3. Repeat on opposite side.
4. Remove four socket head screws **(Figure 87, item 1)** securing belt hold down tabs **(Figure 87, item 2)** to drive assembly **(Figure 87, item 3)**.

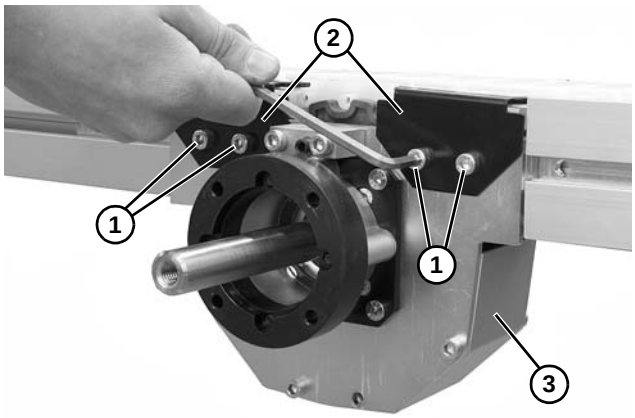


Figure 87

5. Repeat on opposite side.
6. Use belt removal tool #203480 **(Figure 88, item 1)** or a punch and hammer to push the belt rod out by striking the rod end.

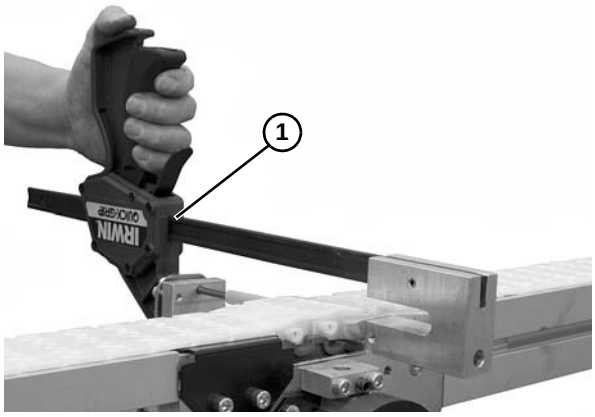


Figure 88

⚠ WARNING

SEVERE HAZARD!

If conveyor belt is damaged or worn, replace belt section.

7. Remove four hex head cap screws **(Figure 89, item 1)** and remove drive motor mounting plate **(Figure 89, item 2)**.

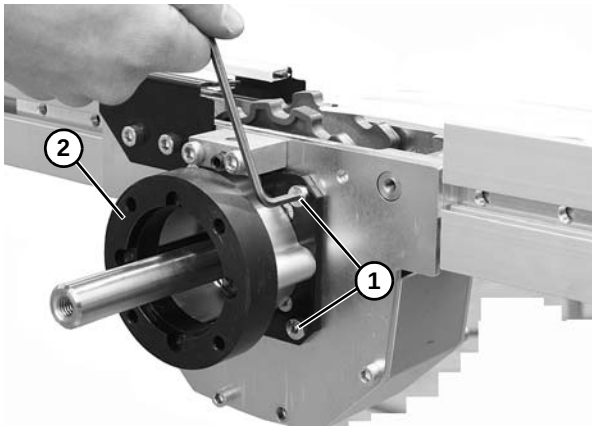


Figure 89

8. Loosen set screws **(Figure 90, item 1)** on both sides of conveyor.

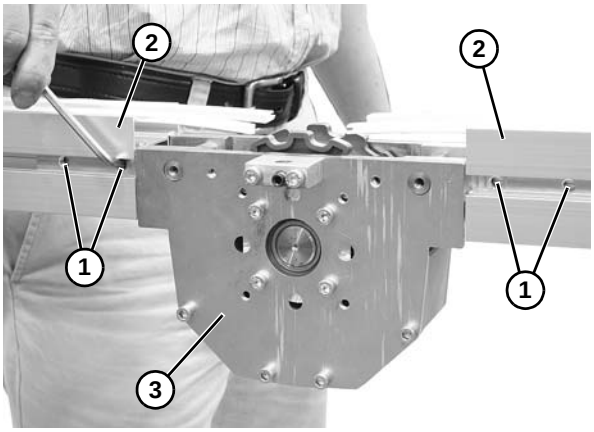


Figure 90

9. Separate conveyor halfs **(Figure 90, item 2)** and remove drive assembly **(Figure 90, item 3)**.
10. Remove four socket head screws **(Figure 91, item 1)**.

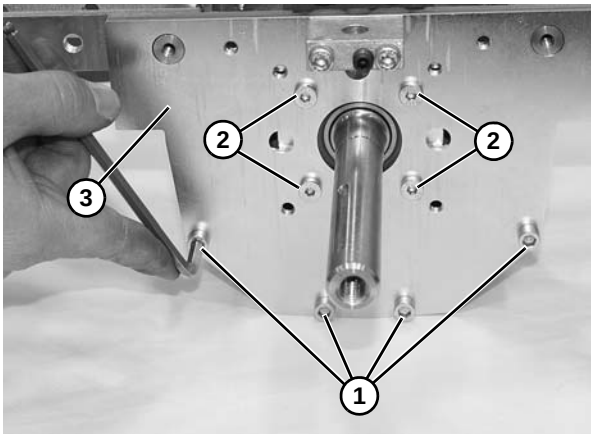


Figure 91

11. Remove four low head cap screws **(Figure 91, item 2)** and remove side plate **(Figure 91, item 3)**.
12. Remove four low head cap screws securing spindle assembly to side plate on the opposite side.
13. Replace spindle assembly.

Curve Assembly

⚠ WARNING

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

1. Remove socket head screw **(Figure 92, item 1)** and socket head screw **(Figure 92, item 2)** from corner wheel assembly pinch bracket **(Figure 92, item 3)**.

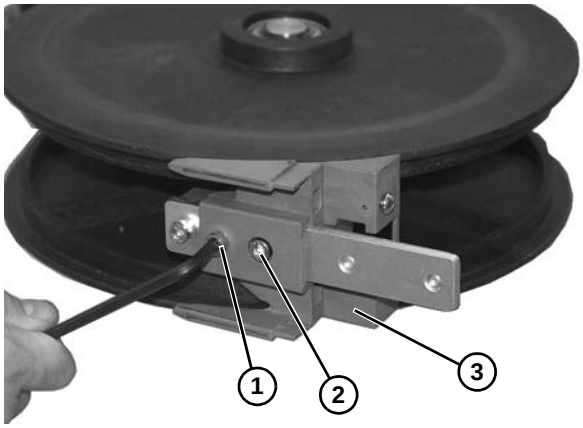


Figure 92

2. Install components reverse of removal.

Weighted Take-Up

1. Remove two socket head screws **(Figure 93, item 1)** on each side securing assembly to frame.

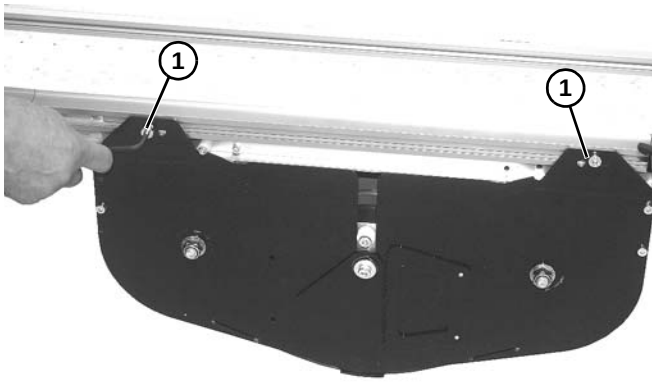


Figure 93

2. Lower weighted take up assembly **(Figure 94, item 1)** from conveyor **(Figure 94, item 2)** by disengaging locking teeth **(Figure 94, item 3)** on both sides.

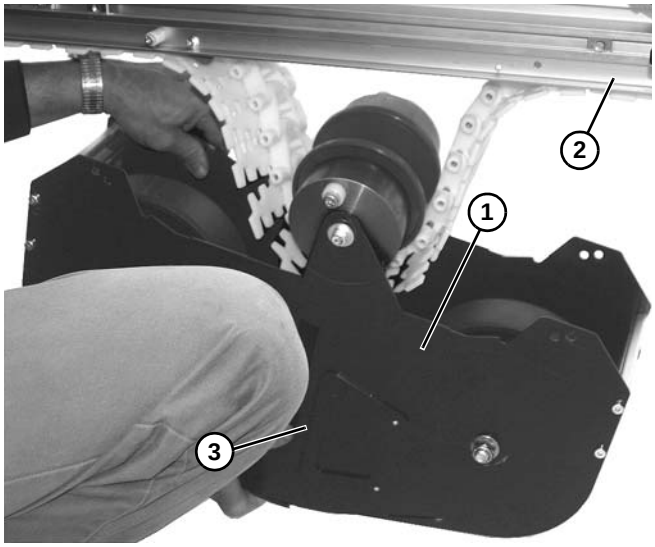


Figure 94

3. Use two wrenches to remove nut **(Figure 95, item 1)** on bolt securing wheel **(Figure 95, item 2)** onto weighted take up assembly housing **(Figure 95, item 3)**.

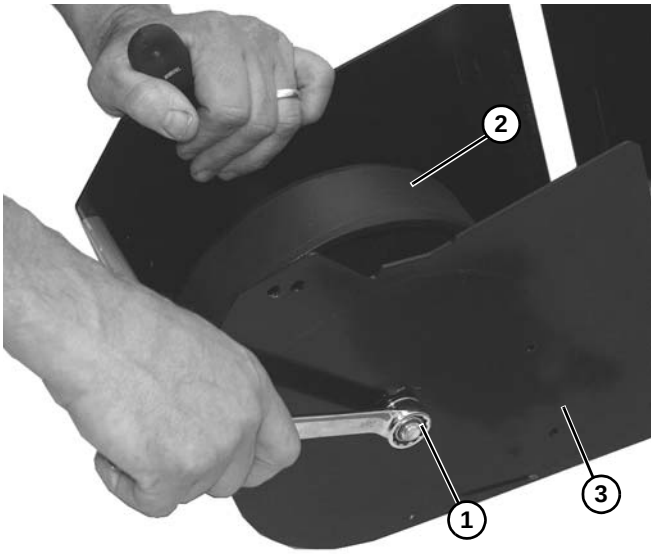


Figure 95

4. Remove bolt **(Figure 96, item 1)**, washer **(Figure 96, item 2)**, two spacers **(Figure 96, item 3)**, and wheel **(Figure 96, item 4)** from take up assembly housing **(Figure 96, item 5)**.

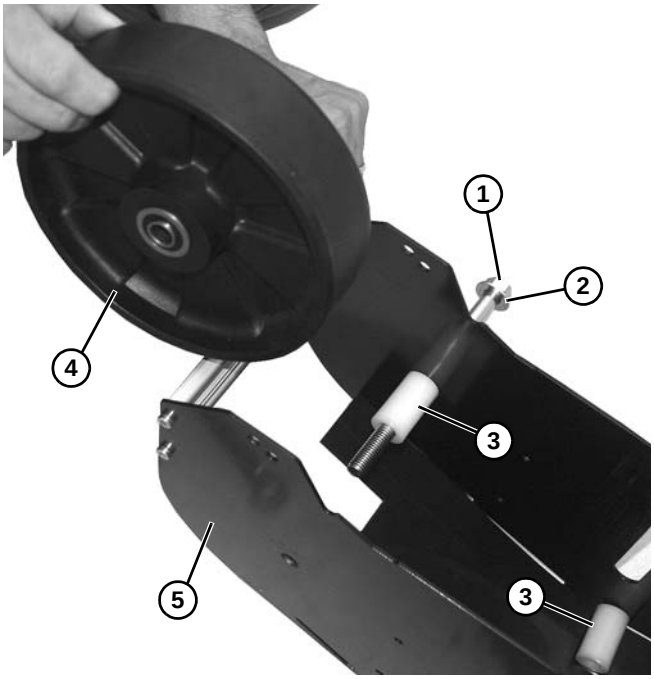


Figure 96

5. Remove idler pulley assembly **(Figure 97, item 1)** from belt **(Figure 97, item 2)**.

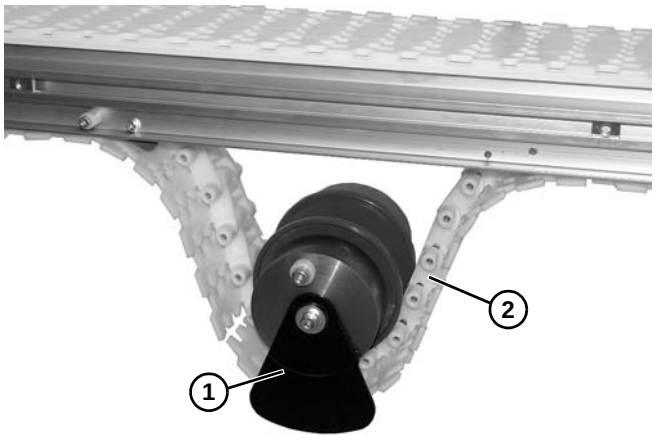


Figure 97

6. Remove socket head screw **(Figure 98, item 1)** from end of idler pulley assembly.

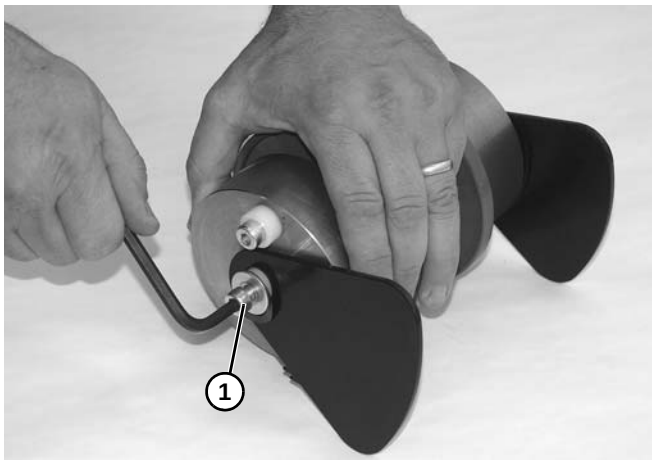


Figure 98

7. Remove bolt **(Figure 99, item 1)**, washer **(Figure 99, item 2)**, spacer **(Figure 99, item 3)**, wave washer **(Figure 99, item 4)**, and plate **(Figure 99, item 5)** from end of idler assembly **(Figure 99, item 6)**.

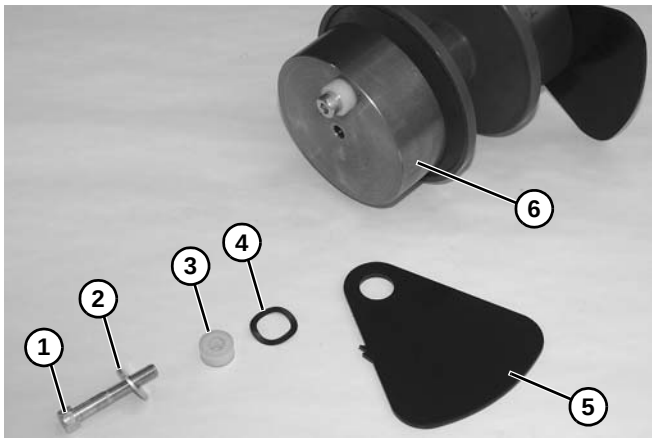


Figure 99

8. Repeat on opposite side.
9. Remove two weights **(Figure 100, item 1)** from each side of pulley **(Figure 100, item 2)**.

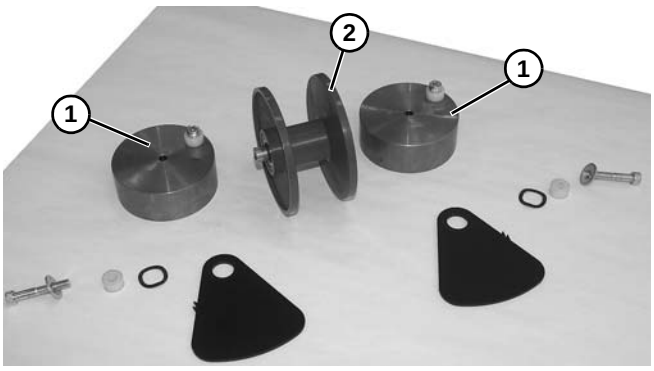


Figure 100

10. Install components reverse of removal, using two hex wrenches **(Figure 101, item 1)** on each side of idler assembly to tighten components.

NOTE
*Be certain that notches **(Figure 101, item 2)** on both plates are on top side, and spacers are in same orientation, as shown, before tightening components.*

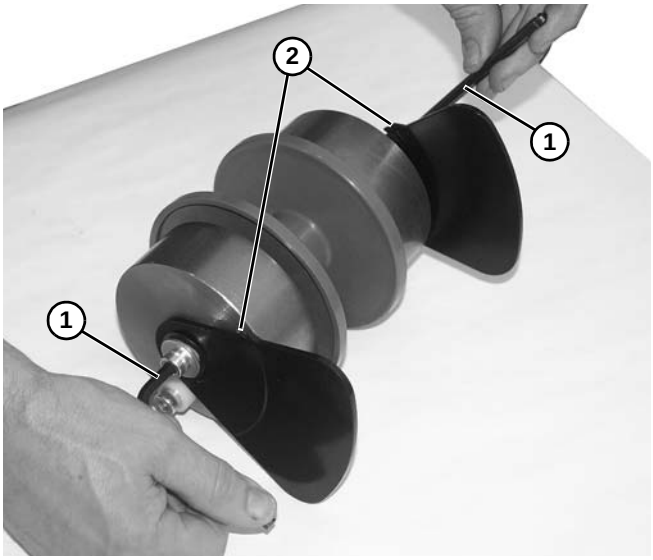


Figure 101

11. Install idler pulley assembly **(Figure 102, item 1)** onto weighted take up assembly **(Figure 102, item 2)**.

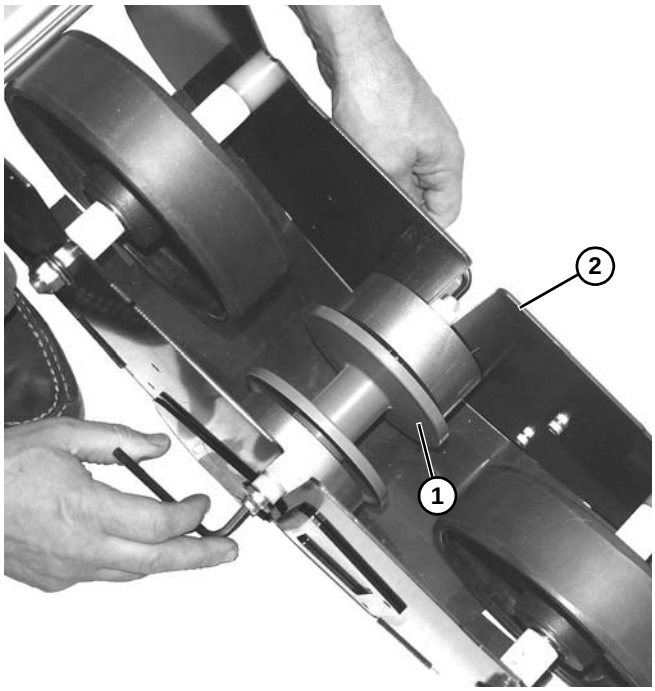


Figure 102

12. Install remaining components reverse of removal.

Power Transfer

Removal

1. Remove two hex head screws **(Figure 103, item 1)** and cover **(Figure 103, item 2)** from power transfer assembly.

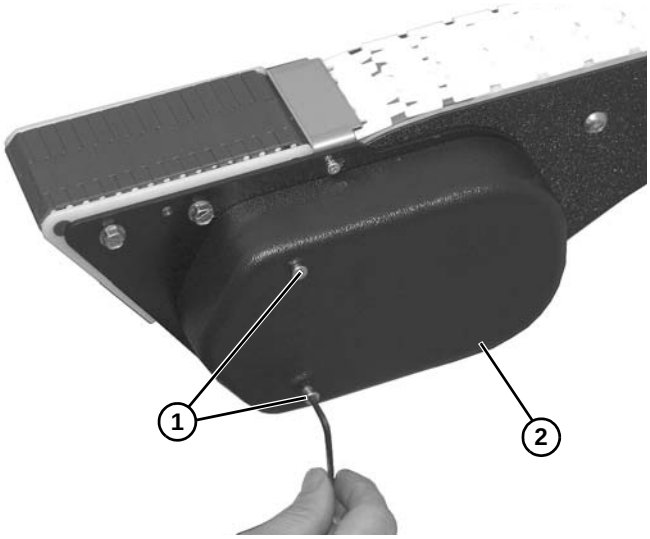


Figure 103

2. Loosen two socket head screws **(Figure 104, item 1)** holding tensioning pulley **(Figure 104, item 2)** onto timing belt **(Figure 104, item 3)**.

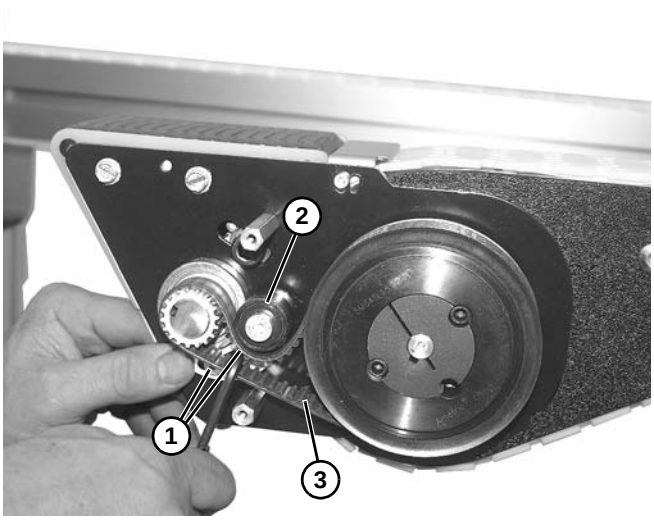


Figure 104

3. Remove timing belt **(Figure 104, item 3)** from assembly.

4. Loosen socket head screw **(Figure 105, item 1)** on both sides of the conveyor.

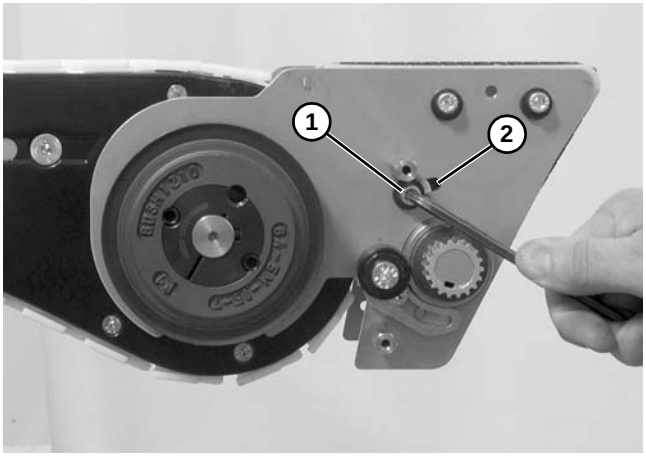


Figure 105

5. Slide idler assembly within slot **(Figure 105, item 2)** to remove tension on belt.
6. Remove two socket head screws **(Figure 106, item 1)** and tensioner plate **(Figure 106, item 2)**.

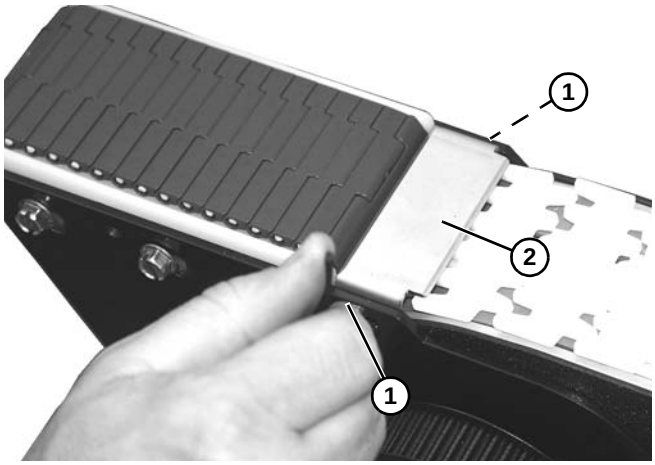


Figure 106

7. Lift slightly on belt **(Figure 107, item 1)** and push pin **(Figure 107, item 2)** out of belt.

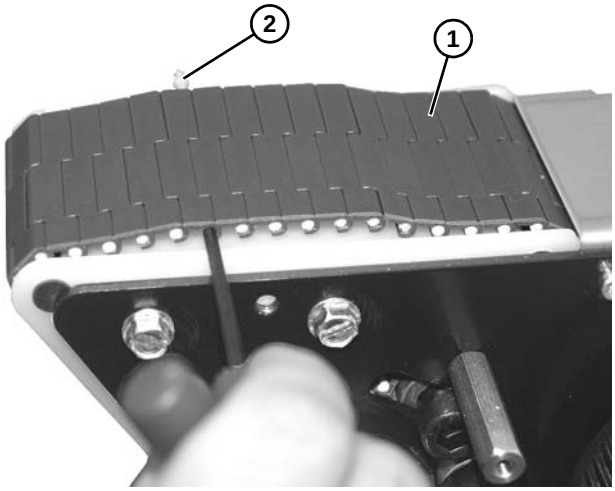


Figure 107

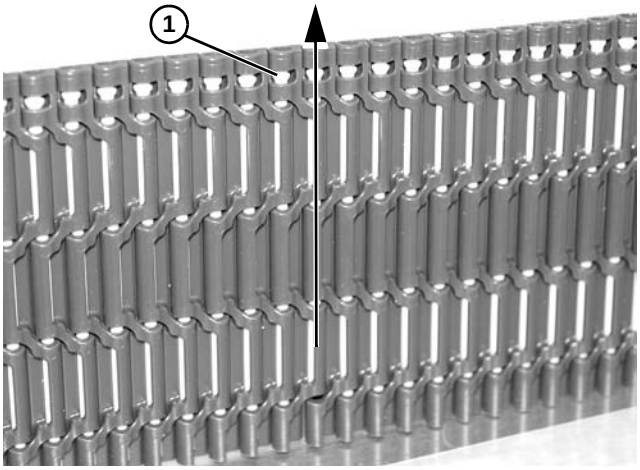


Figure 108

NOTE
*Note that head of pin **(Figure 108, item 1)** should be removed in direction shown.*

8. Remove belt.

9. Remove four socket head screws **(Figure 109, item 1)** holding wear bar assembly **(Figure 109, item 2)** onto power transfer.

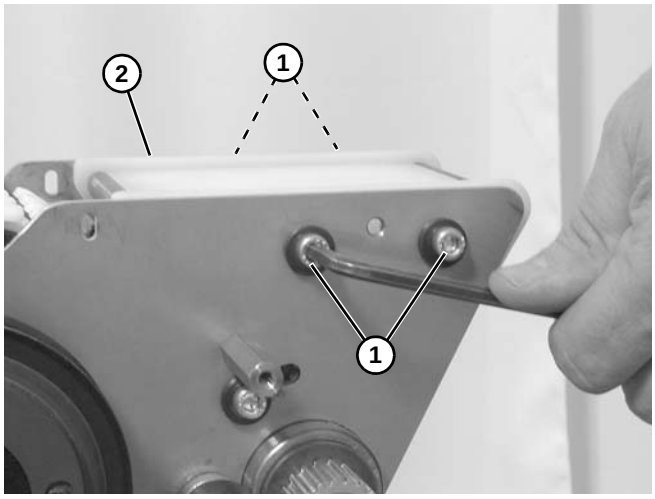


Figure 109

10. Remove wear bar assembly **(Figure 110, item 1)** from power transfer.

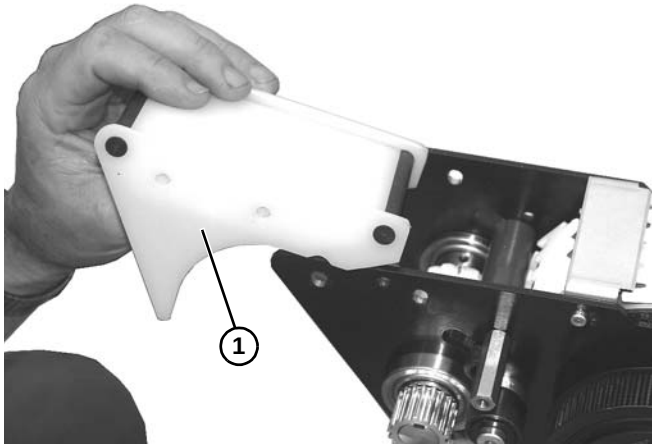


Figure 110

11. Disassemble side guide plates **(Figure 111, item 1)**, wear rods **(Figure 111, item 2)**, and wear bar **(Figure 111, item 3)**. Replace worn components.

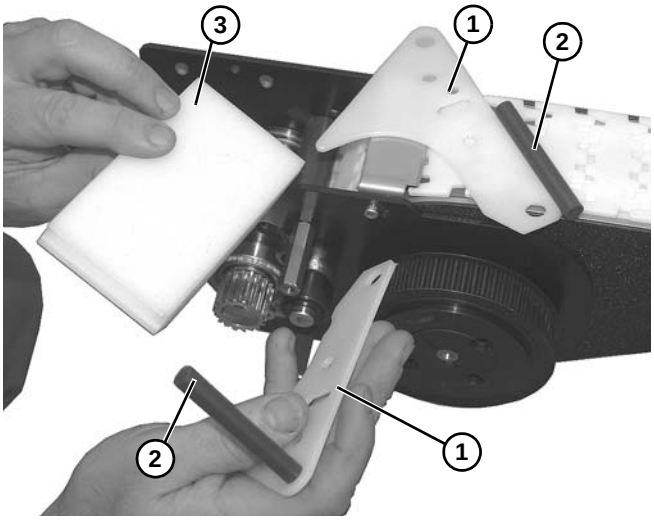


Figure 111

12. Remove socket head screw **(Figure 112, item 1)** on both sides of the conveyor and remove idler assembly.

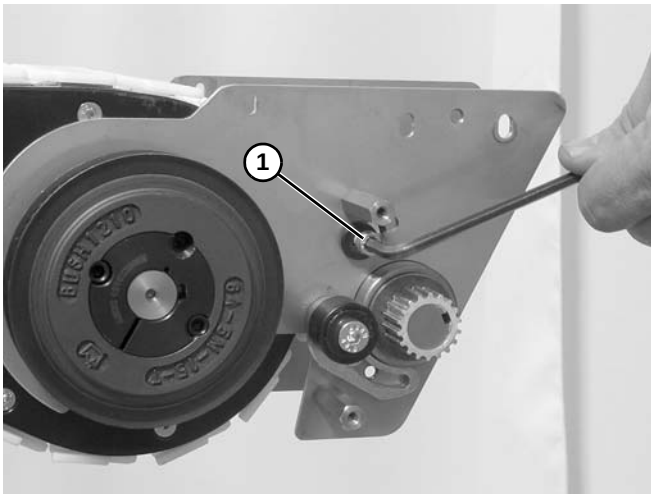


Figure 112

13. Replace idler assembly and install socket head screws to secure.

14. Loosen two set screws **(Figure 113, item 1)** on two bearings **(Figure 113, item 2)**.

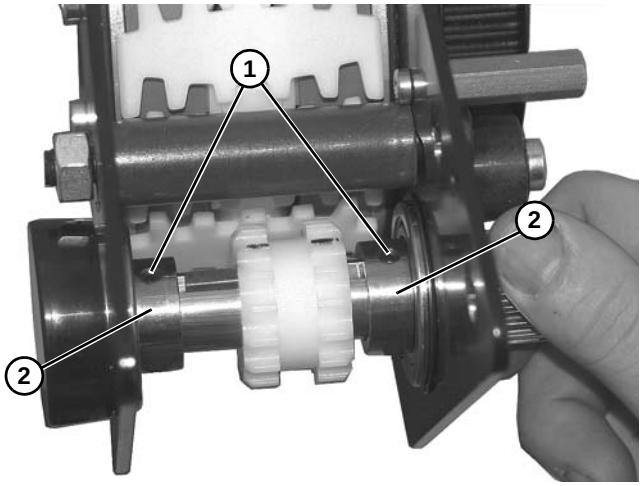


Figure 113

15. Remove drive shaft **(Figure 114, item 1)**, making certain not to loose key **(Figure 114, item 2)** when removing gear **(Figure 114, item 3)**.

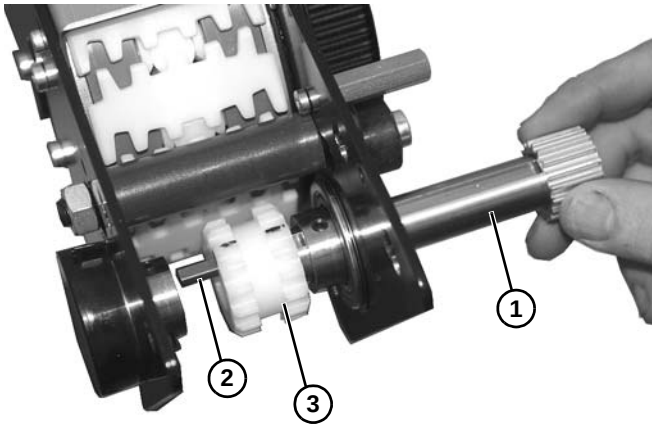


Figure 114

16. Remove key **(Figure 115, item 1)** from gear **(Figure 115, item 2)**.

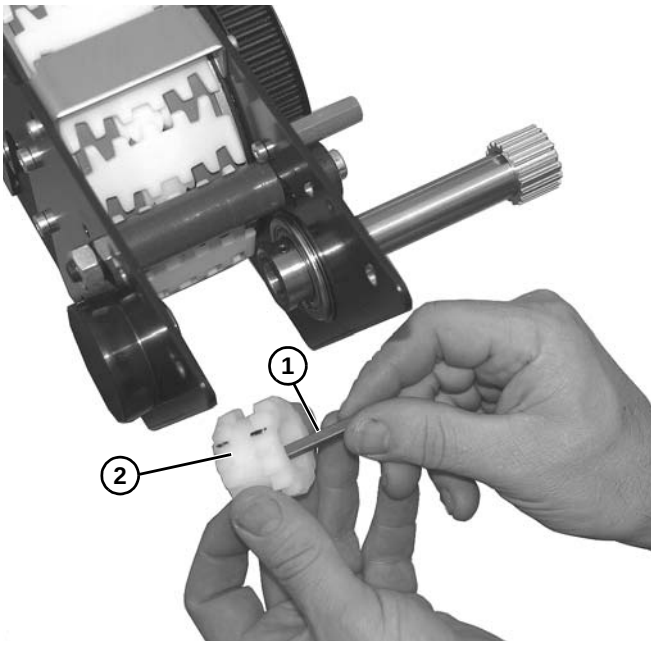


Figure 115

Installation

1. Install drive shaft **(Figure 116, item 1)** on two bearings **(Figure 116, item 2)** and press outward as shown.

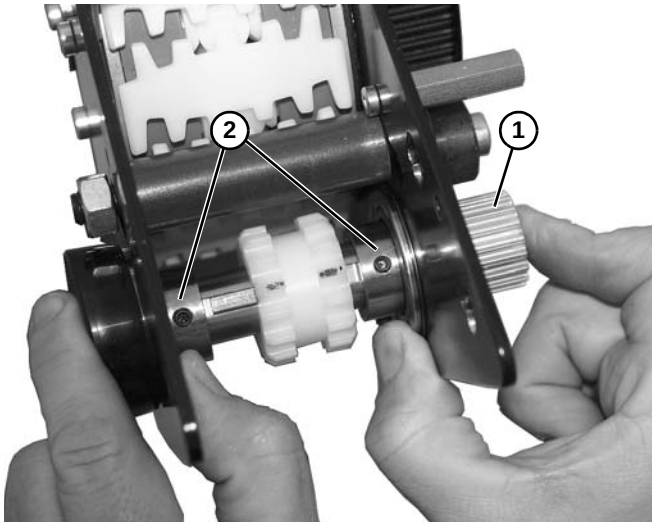


Figure 116

2. Secure drive shaft onto bearings with two set screws **(Figure 117, item 1)**.

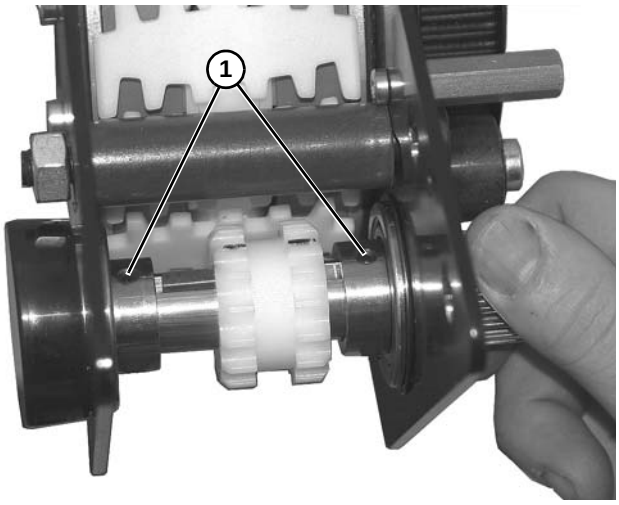


Figure 117

3. Raise belt **(Figure 118, item 1)** into position, and move gear **(Figure 118, item 2)** so that cogs line up with belt, as shown.

Figure 118

4. Install wear bar assembly **(Figure 119, item 1)** with four socket head screws **(Figure 119, item 2)**.

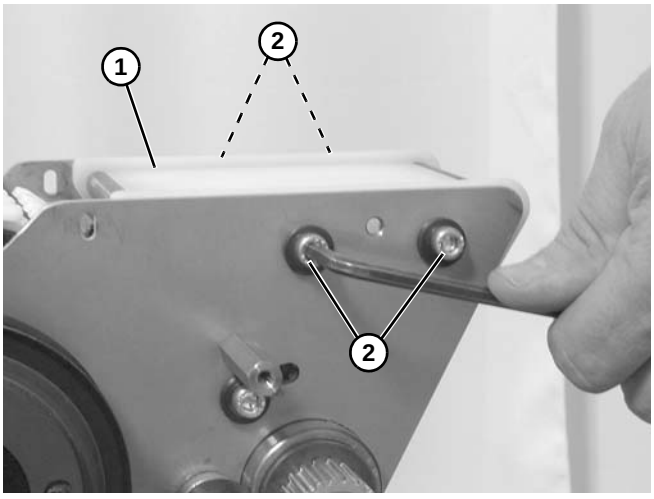


Figure 119

5. Guide belt **(Figure 120, item 1)** through idler assembly with belt routing under gear **(Figure 120, item 2)** and over wear tube **(Figure 120, item 3)**.

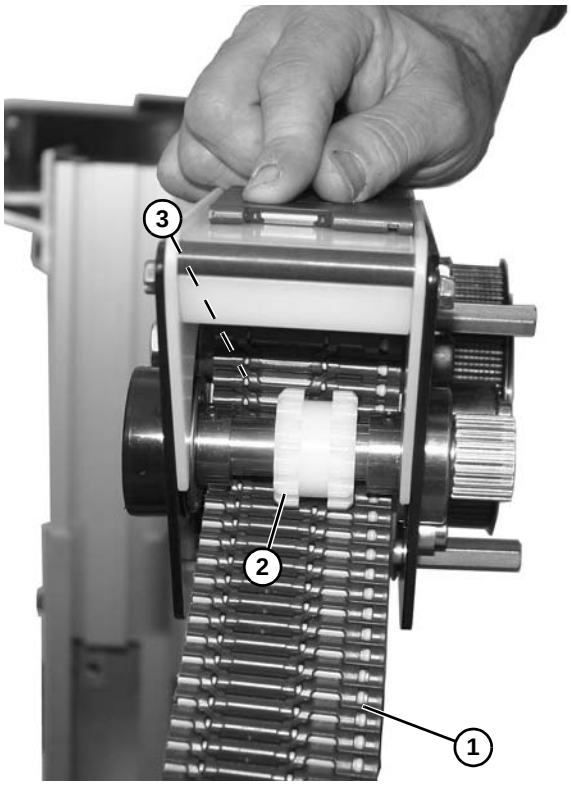


Figure 120

6. Bring ends of belt together and install pin **(Figure 121, item 1)**.

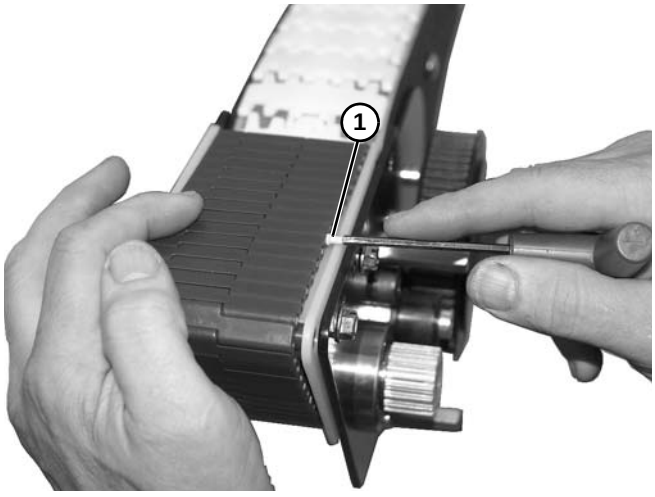


Figure 121

7. Install tensioner plate **(Figure 122, item 1)** with two socket head screws **(Figure 122, item 2)**.

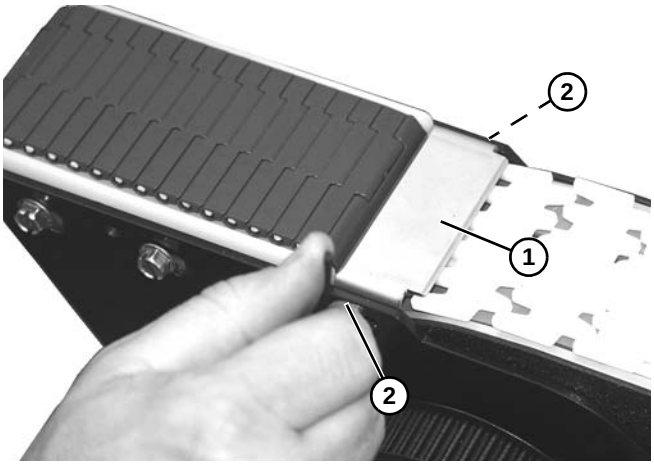


Figure 122

8. Slide idler assembly within slot **(Figure 123, item 1)** to remove excess slack from belt **(Figure 123, item 2)**. Tighten socket head screws **(Figure 123, item 3)**.

⚠ CAUTION

DO NOT overtighten belt or excessive wear will occur.

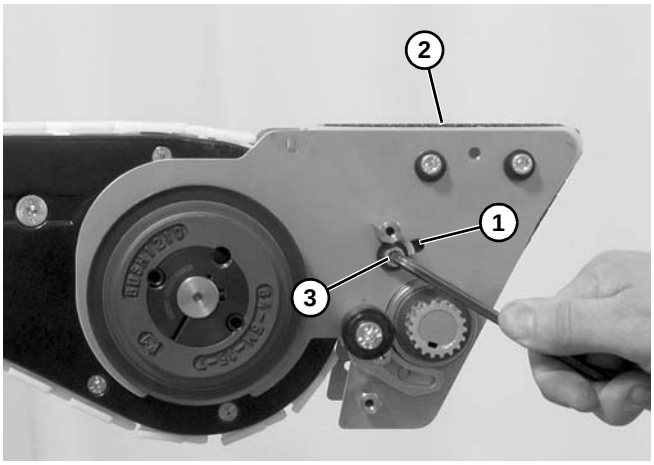


Figure 123

9. Rotate drive shaft **(Figure 124, item 1)** to verify tightness of belt **(Figure 124, item 2)**. Belt should turn freely. Loosen socket head screw **(Figure 124, item 3)** and adjust, if necessary.

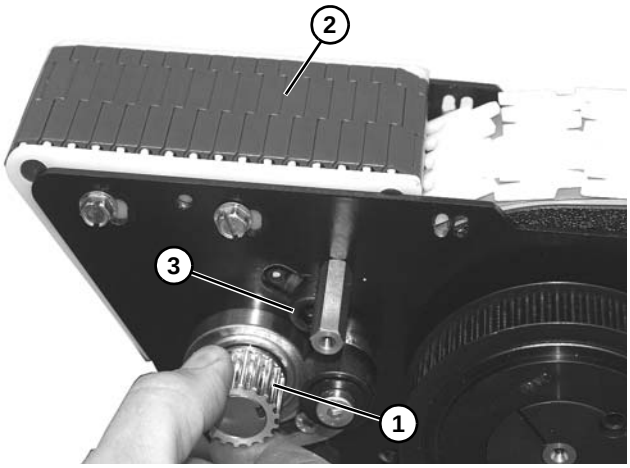


Figure 124

10. Install timing belt:

- On idler end, route and install belt **(Figure 125, item 1)** as shown. Press up on tensioner **(Figure 125, item 2)** and tighten two hex head screws **(Figure 125, item 3)**.

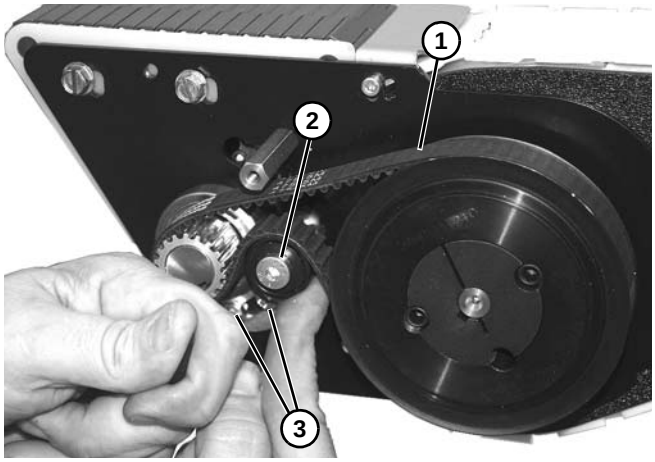


Figure 125

- On drive end, route and install belt **(Figure 126, item 1)** as shown. Press down on tensioner **(Figure 126, item 2)** and tighten two hex head screws **(Figure 126, item 3)**

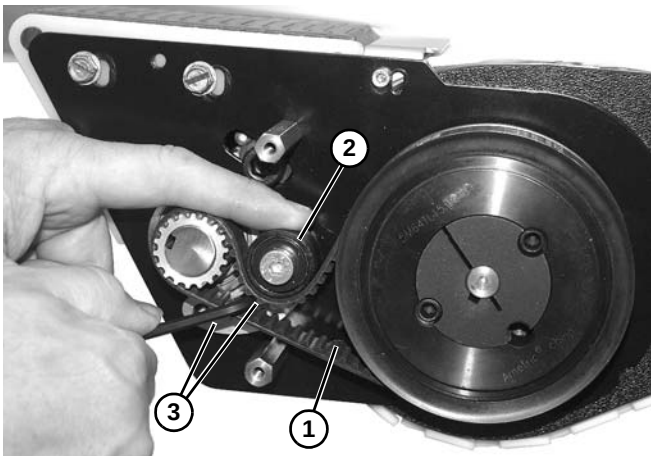


Figure 126

11. Install cover **(Figure 127, item 1)** with two hex head screws **(Figure 127, item 2)**.

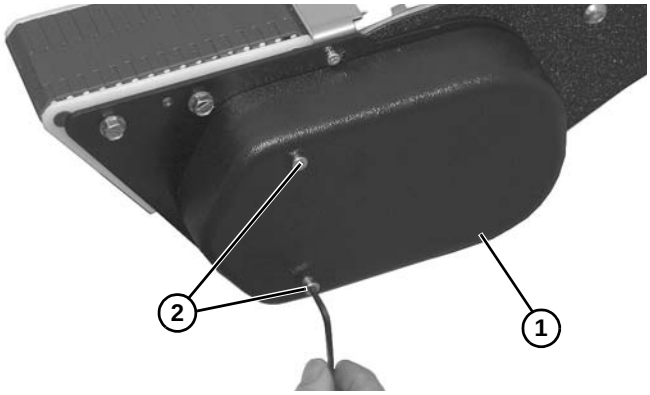


Figure 127

Roller Transfer

1. Remove two hex head screws **(Figure 128, item 1)** on each side of conveyor, and remove roller transfer assembly **(Figure 128, item 2)** from conveyor.

Figure 128

2. Remove nuts **(Figure 129, item 1)**, washers **(Figure 129, item 2)**, and roller transfer **(Figure 129, item 3)** from support bracket **(Figure 129, item 4)**.

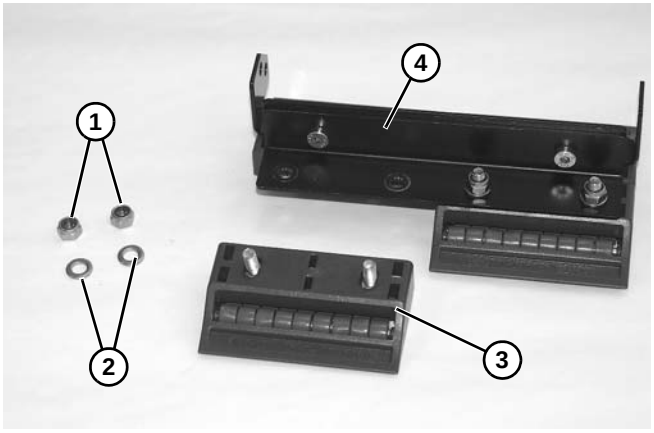


Figure 129

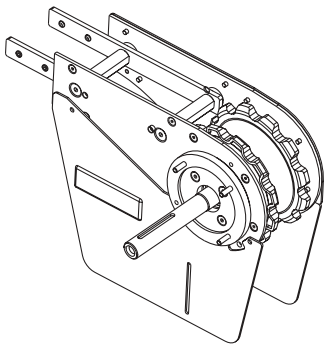
Notes

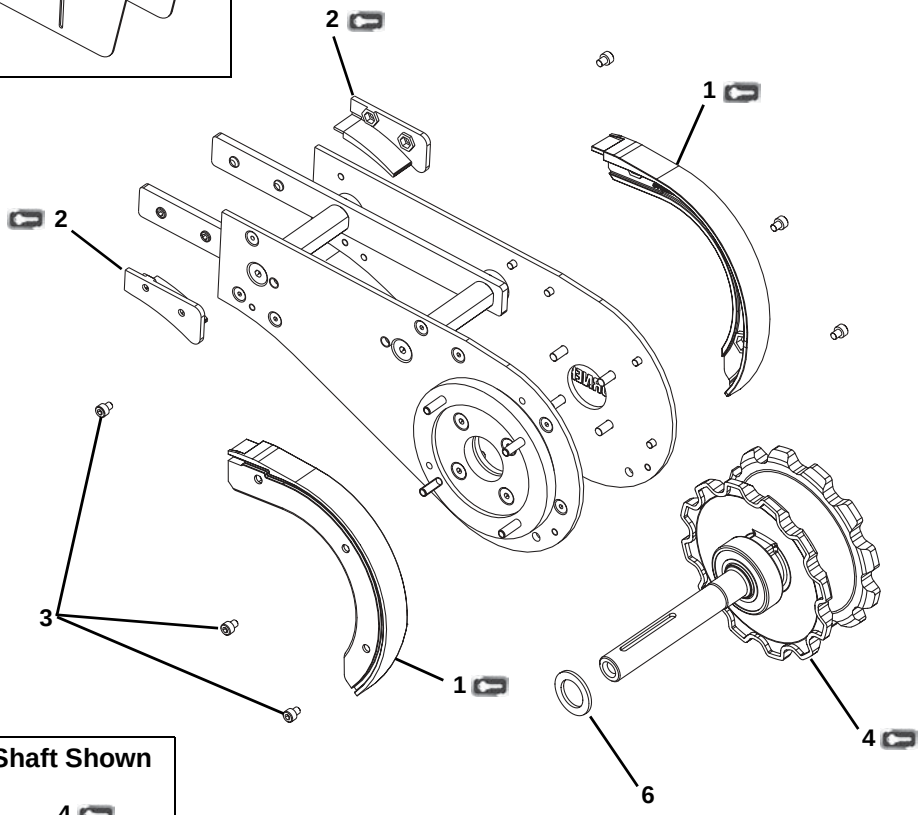
Service Parts

NOTE
For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory. Key Service Parts and Kits are identified by the Performance Parts Kits logo. Dorner recommends keeping these parts on hand.

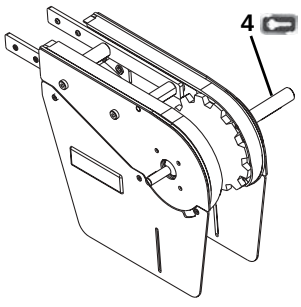
Drive Tail

5 Drive Tail Kit





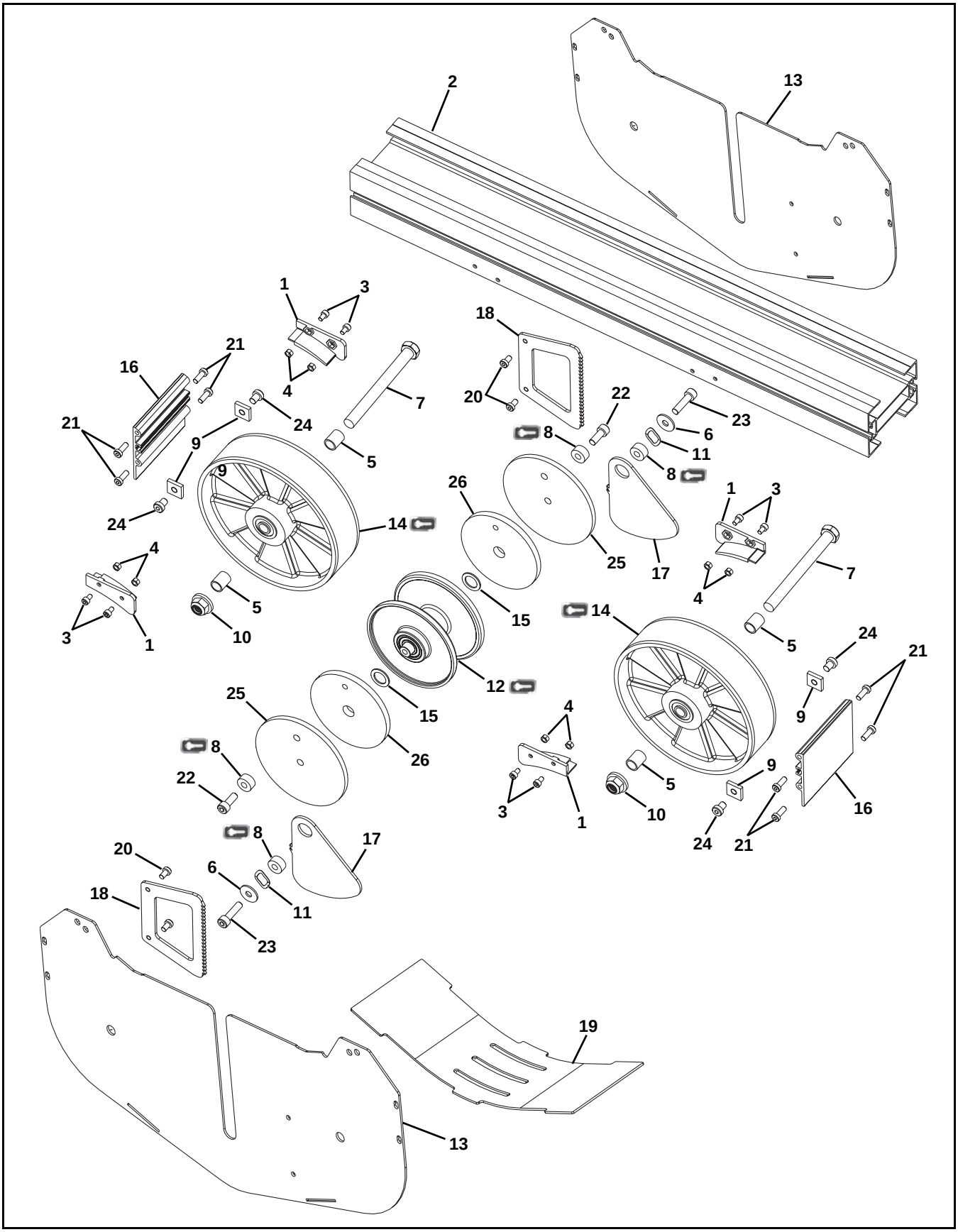
Optional Auxiliary Shaft Shown



Item	Part Number	Description
1	834-FSD63101-A	Retaining Guide Set for 65 width Conveyors
	834-FMD83101-A	Retaining Guide Set for 85 width Conveyors
	834-FCD103101-A	Retaining Guide Set for 105 & 150 width Conveyors
2	834-FSD63102-A	Belt Capture Guide Set for 65 width Conveyors
	834-FMD83102-A	Belt Capture Guide Set for 85 width Conveyors
	834-FCD103102-A	Belt Capture Guide Set for 105 & 150 width Conveyors
3	920506M	Socket Head Screw, M5-.80 x 6 mm
4	205700-EN-WWW	Standard Load Spindle Shaft Assembly
	205700-CN-WWW	CE Spindle Shaft Assembly
	205700-EA-WWW	Standard Load Spindle Shaft Assembly with Auxiliary Shaft
	205700-CA-WWW	CE Spindle Shaft Assembly with Auxiliary Shaft
	205700-HN-WWW	Heavy Load Spindle Shaft Assembly
	205700-HA-WWW	Heavy Load Spindle Shaft Assembly with Auxiliary Shaft
5	205750-WWW-EN	Standard Load Drive Tail Kit with Shaft in the 'A' Position
	205750-WWW-NE	Standard Load Drive Tail Kit with Shaft in the 'D' Position
	205750-WWW-CN	CE Drive Tail Kit with Shaft in the 'A' Position
	205750-WWW-NC	CE Drive Tail Kit with Shaft in the 'D' Position
	205750-WWW-HN	Heavy Load Drive Tail Kit with Shaft in the 'A' Position
	205750-WWW-NH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position
	205750-WWW-EA	Standard Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750-WWW-AE	Standard Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750-WWW-CA	CE Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750-WWW-AC	CE Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750-WWW-HA	Heavy Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750-WWW-AH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750-WWW-AA	Drive Tail Kit with two Auxiliary Shafts
6	807-3105	Washer, used with Standard Load Drive Package with Power or Roller Transfer Tails only
	203844	Washer, used with Heavy Load Drive Package with Power or Roller Transfer Tails only
WWW= Conveyor width reference: 065, 085, 105, 150		

Service Parts

Weighted Take-Up

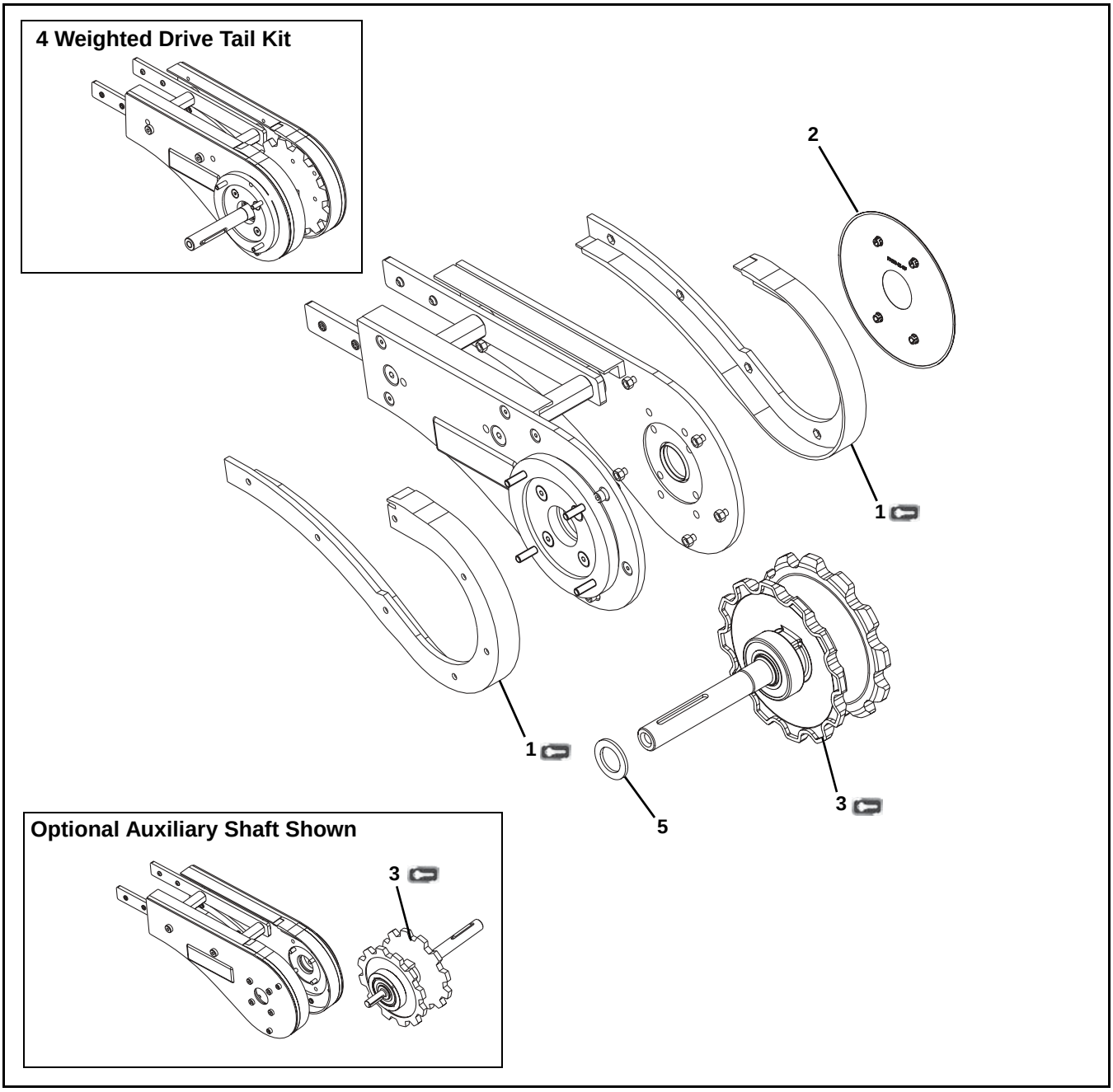


Item	Part Number	Description
1	834-FSD63102-1	Belt Capture Guide Set, for 65 width Conveyors
	834-FMD83102-1	Belt Capture Guide Set, for 85 width Conveyors
	834-FCD103102-1	Belt Capture Guide Set, for 105 & 150 width Conveyors
2	203345-WWW-LLL	Conveyor Section
3	920516M	Socket Head Screw, M5-.80 x 16 mm
4	990501M	Hex Nut, M5-0.80
5	203851	Spacer, 0.50" x 0.438" for 85 width Conveyors
	203455	Spacer, 0.50" x 0.841" for 105 width Conveyors
	203456	Spacer, 0.50" x 1.750" for 150 width Conveyors
6	807-1760	Washer
7	807-2290	Hex Bolt, 1/2-13 x 3.5" for 65 width Conveyors
	807-3092	Hex Bolt, 1/2-13 x 4.5" for 85 width Conveyors
	807-2291	Hex Bolt, 1/2-13 x 5" for 105 width Conveyors
	807-2292	Hex Bolt, 1/2-13 x 7" for 150 width Conveyors
8	807-2297	Nylon Spacer, 0.75" x 0.32" x 0.375"
9	834-FASN-M8	Slide Nut
10	910-320	Lock Nut
11	807-2314	Spring Washer
12	834-FSIM-A15	Idler Pulley Assembly for 65 width Conveyors
	834-FMIM-A15	Idler Pulley Assembly for 85 width Conveyors
	834-FCIM-A15	Idler Pulley Assembly for 105 width Conveyors
	834-FLIM-A15	Idler Pulley Assembly for 150 width Conveyors
13	203330	Weighted Take-Up Plate
14	203331	Wheel (Standard Belt)
	201759	Wheel (Friction Top Belt)
15	911-516	Washer
16	203344-WWW	End Guard
17	203349	Latching Cover
18	203351	Ratchet Plate
19	203457-WWW	Bottom Guard
20	950610M	Low Head Cap Screw, M6-1.00 x 10 mm
21	920612M	Socket Head Cap Screw, M6-1.00 x 12 mm

Item	Part Number	Description
22	920820M	Socket Head Cap Screw, M8-1.25 x 20 mm for 65 & 85 width Conveyors
	920822M	Socket Head Cap Screw, M8-1.25 x 22 mm for 105 width Conveyors
	920840M	Socket Head Cap Screw, M8-1.25 x 40 mm for 150 width Conveyors
23	920830M	Socket Head Cap Screw, M8-1.25 x 30 mm for 65, 85 & 105 width Conveyors
	920850M	Socket Head Cap Screw, M8-1.25 x 50 mm for 150 width Conveyors
24	950810M	Low Head Cap Screw, M8-1.25 x 10 mm
25	207746	Weighted Take-Up Disk, 1/4"
26	207747	Weighted Take-Up Disk, 5/16"
WWW= Conveyor width reference: 065, 085, 105, 150		
LLL= Conveyor frame section in inches: 029, 035, 047, 059		
Length Example: Length = 29" LLL = 029		

Service Parts

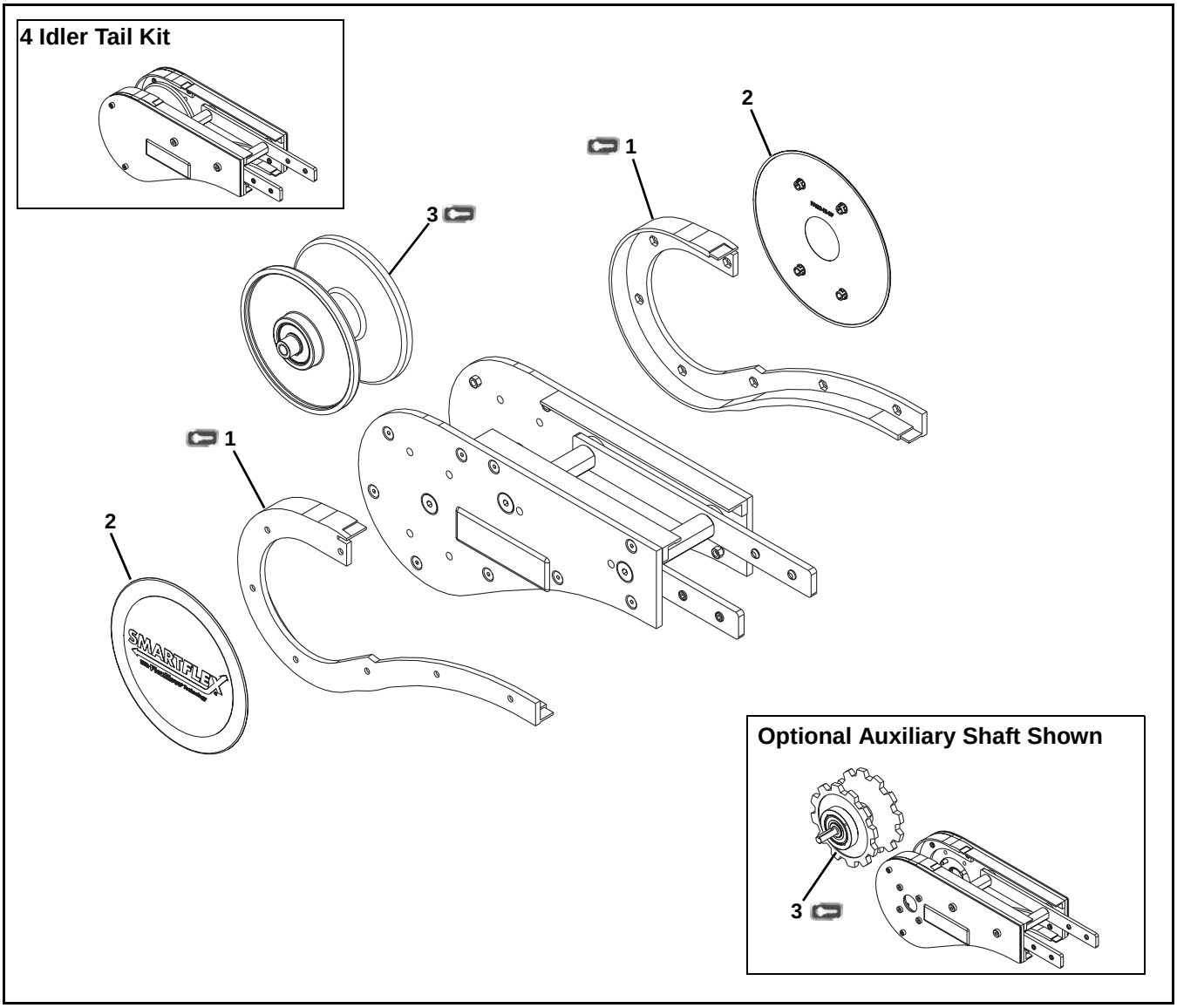
Weighted Take-Up Drive Tail



Item	Part Number	Description
1	834-FSE63001-A	Retaining Guide Set for 65 width Conveyors
	834-FME83001-A	Retaining Guide Set for 085 width Conveyors
	834-FCE103001-A	Retaining Guide Set for 105 and 150 width Conveyors
2	834-FAEC-IE-SF	Idler Tail Cover
3	205700-EN-WWW	Standard Load Spindle Shaft Assembly
	205700-CN-WWW	CE Spindle Shaft Assembly
	205700-EA-WWW	Standard Load Spindle Shaft Assembly with Auxiliary Shaft
	205700-CA-WWW	CE Spindle Shaft Assembly with Auxiliary Shaft
	205700-HN-WWW	Heavy Load Spindle Shaft Assembly
	205700-HA-WWW	Heavy Load Spindle Shaft Assembly with Auxiliary Shaft
4	205750-WWW-EN	Standard Load Drive Tail Kit with Shaft in the 'A' Position
	205750-WWW-NE	Standard Load Drive Tail Kit with Shaft in the 'D' Position
	205750-WWW-CN	CE Drive Tail Kit with Shaft in the 'A' Position
	205750-WWW-NC	CE Drive Tail Kit with Shaft in the 'D' Position
	205750-WWW-HN	Heavy Load Drive Tail Kit with Shaft in the 'A' Position
	205750-WWW-NH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position
	205750-WWW-EA	Standard Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750-WWW-AE	Standard Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750-WWW-CA	CE Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750-WWW-AC	CE Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750-WWW-HA	Heavy Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750-WWW-AH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750-WWW-AA	Drive Tail Kit with two Auxiliary Shafts
5	807-3105	Washer, used with Standard Load Drive Package with Power or Roller Transfer Tails only
	203844	Washer, used with Heavy Load Drive Package with Power or Roller Transfer Tails only
WWW= Conveyor width reference: 065, 085, 105, 150		

Service Parts

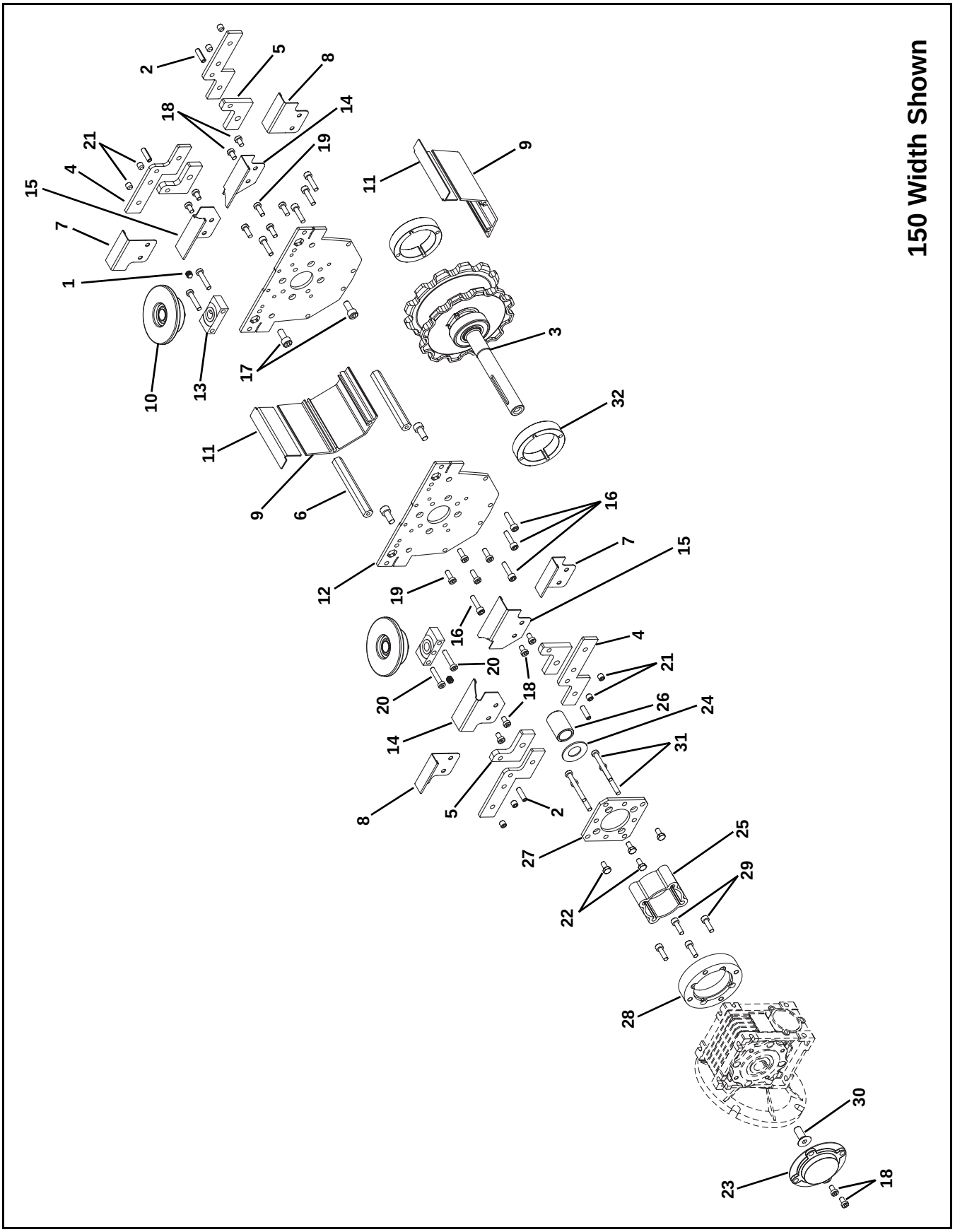
Idler Tail



Item	Part Number	Description
1	834-FSE63001-A	Retaining Guide Set for 65 width Conveyors
	834-FME83001-A	Retaining Guide Set for 085 width Conveyors
	834-FCE103001-A	Retaining Guide Set for 105 and 150 width Conveyors
2	834-FAEC-IE-SF	Idler Tail Cover
3	834-FSIM-15	Idler Pulley Assembly for 65 width Conveyors
	834-FMIM-15	Idler Pulley Assembly for 85 width Conveyors
	834-FCIM-15	Idler Pulley Assembly for 105 width Conveyors
	834-FLIM-15	Idler Pulley Assembly for 150 width Conveyors
	205700-AN-WWW	Idler Pulley Assembly with Auxiliary Shaft
4	205749-WWW-NN	Idler Tail Kit
	205749-WWW-AN	Idler Tail Kit with Auxiliary Shaft in the 'A' Postion
	205749-WWW-NA	Idler Tail Kit with Auxiliary Shaft in the 'D' Postion
	205749-WWW-AA	Idler Tail Kit with two Auxiliary Shafts
WWW= Conveyor width reference: 065, 085, 105, 150		

Service Parts

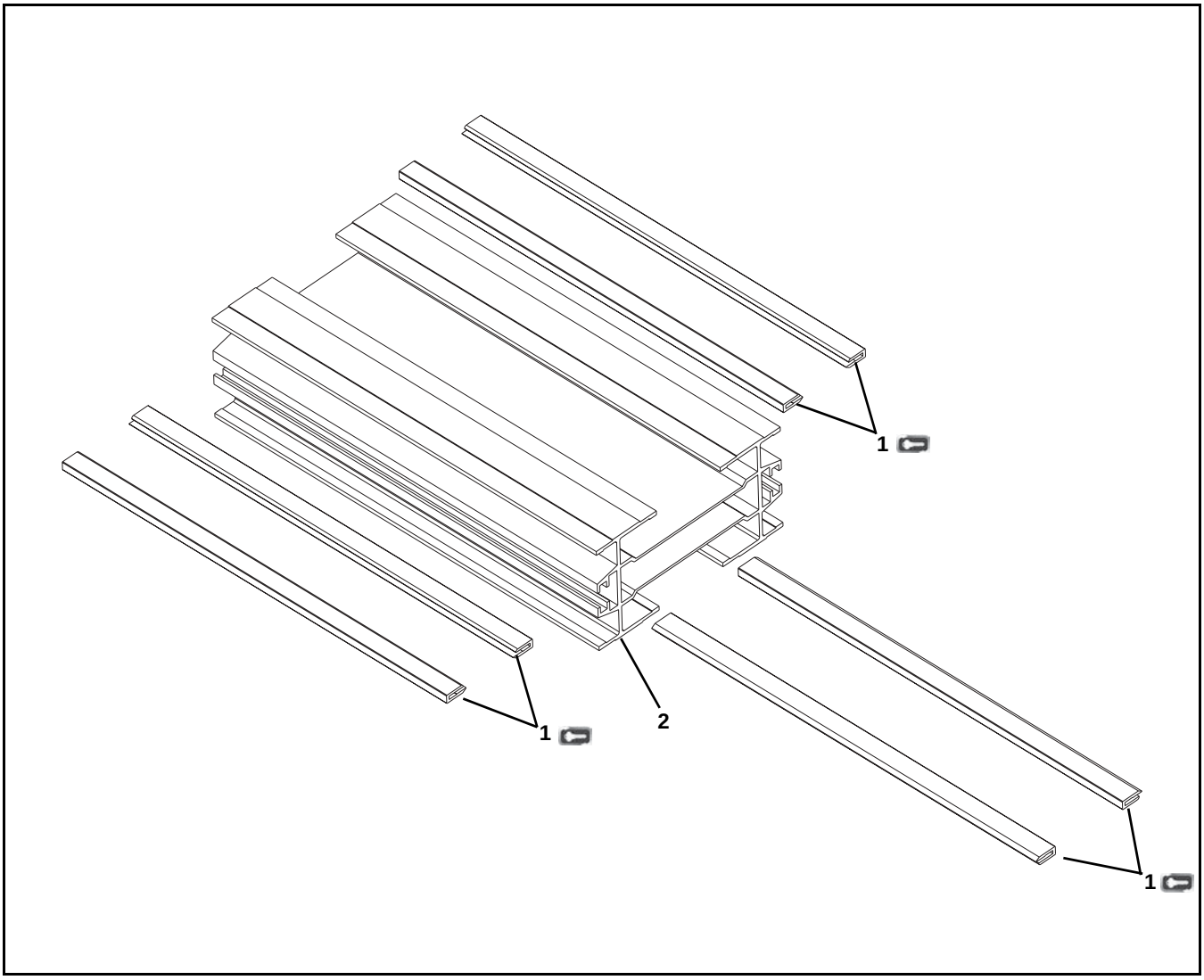
Top Running Drive



Item	Part Number	Description
1	807-2555	Set Screw, M8-1.25 x 10 mm
2	913-051	Pin for 065 width Conveyors
	913-509	Pin for 150 width Conveyors
3	834-FSDD-A65DL-314	Spindle Assembly for 065 width Conveyors
	834-FMDD-A85DL-314	Spindle Assembly for 085 width Conveyors
	834-FCDD-A105DL-314	Spindle Assembly for 105 width Conveyors
	834-FLDD-A150DL-314	Spindle Assembly for 150 width Conveyors
4	205140	Connecting Bar for 065 width Conveyors
	205142	Connecting Bar for 085 & 105 width Conveyors
	204290	Connecting Bar for 150 width Conveyors
5	205141	Spacing Bar for 065 width Conveyors Only
	204291	Spacing Bar for 150 width Conveyors Only
6	205147	Hex Post for 065 width Conveyors
	206266	Hex Post for 085 width Conveyors
	205116	Hex Post for 105 width Conveyors
	204292	Hex Post for 150 width Conveyors
7	204293-LH	Wear Strip Support Left Hand for 150 width Conveyors Only
8	204293-RH	Wear Strip Support Right Hand for 150 width Conveyors Only
9	205125	Extrusion Guard for 065 width Conveyors
	206269	Extrusion Guard for 085 width Conveyors
	204380	Extrusion Guard for 105 & 150 width Conveyors
10	204379	Hold Down Assembly for 065 width Conveyors
	206283	Hold Down Assembly for 085 width Conveyors
	204381	Hold Down Assembly for 105 & 150 width Conveyors
11	204790	Pinch Guard for 065 width Conveyors
	206270	Pinch Guard for 085 width Conveyors
	204791	Pinch Guard for 105 & 150 width Conveyors
12	205115	Side Plate
13	205134	Wheel Block
14	205139-LH	Wear Strip Support Left Hand for 065 width Conveyors
	206267-LH	Wear Strip Support Left Hand for 085 width Conveyors
	205137-LH	Wear Strip Support Left Hand for 105 & 150 width Conveyors
15	205139-RH	Wear Strip Support Right Hand for 065 width Conveyors
	206268-RH	Wear Strip Support Right Hand for 085 width Conveyors
	205137-RH	Wear Strip Support Right Hand for 105 & 150 width Conveyors
16	708180P	Trilobe Screw, M6-1.00 x 25 mm
17	920818M	Socket Head Screw, M8-1.25 x 18 mm for 150 width Conveyors Only
18	950610M	Low Head Cap Screw, M6-1.00 x 10 mm
19	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
20	950630M	Low Head Cap Screw, M6-1.00 x 30 mm
21	970808M	Set Screw, M8-1.25 x 10 mm
22	960612MSS	Hex Head Cap Screw, M6-1.00 x 12 mm
23	807-2016	Cover
24	807-2277	Disc Spring
25	202270-00134	Extrusion for 065 & 105 width Conveyors
	202270-00223	Extrusion for 150 width Conveyors
26	203065	Drive Spacer
27	205132	Motor Mount
28	350115	Adapter Ring
29	920620M	Socket Head Screw, M6-1.00 x 20 mm
30	931025M	Flat Head Screw, M10-.50 x 25 mm
31	950650M	Low Head Cap Screw, M6-1.00 x 50 mm
32	834-B6005-C70-T12	Bearing Retainer for 065 width Conveyors
	834-B6205-C70-T15	Bearing Retainer for 085, 105 & 150 width Conveyors

Service Parts

Frame Assembly



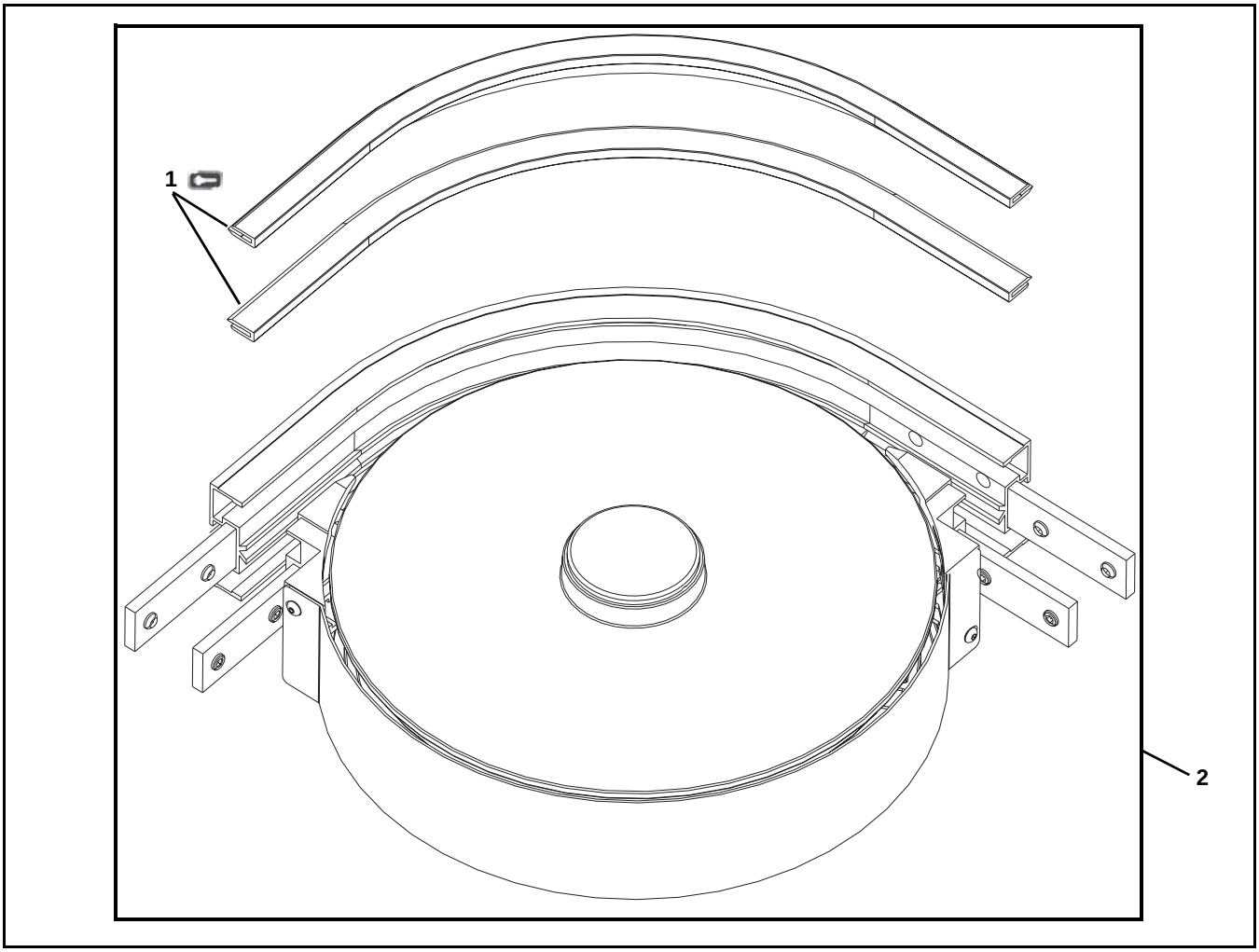
Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	834-FSCB-3-LLLLL	Frame for 65 width Conveyors
	834-FMCB-3-LLLLL	Frame for 85 width Conveyors
	834-FCCB-3-LLLLL	Frame for 105 width Conveyors
	834-FLCB-3-LLLLL	Frame for 150 width Conveyors
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Wear Strip Replacement Tool

Item	Part Number	Description
1	203475	Wear Strip Replacement Tool Kit
2	834-FASLS-M5	Nylon Set Screws, M5 x 6 mm
3	896-1008	Drill Bit, #18, 0.1695"

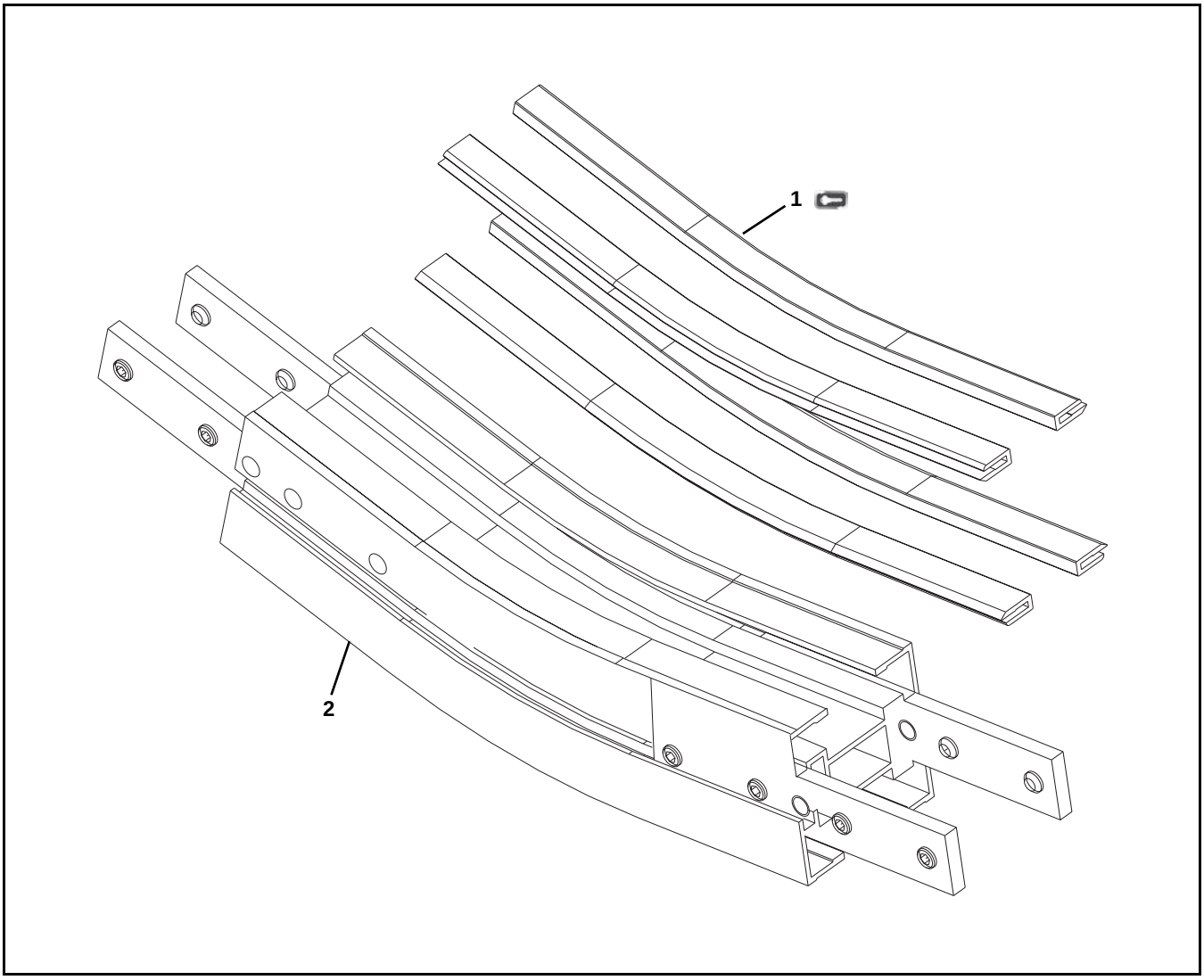
Service Parts

Curve Frame Assembly



Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	834-FFWB-A RRR	Wheel Curve Kit
	834-FFHB-90R500	90° 500 Radius Plain Bend Curve Kit
	834-FFHB-90R700	90° 700 Radius Plain Bend Curve Kit
3	205165-WWW	Guard Assembly for Top Running Drive Only (Not Shown)
FF = Conveyor Width: FS = 065 width, FM = 085 width, FC = 105 width and FL = 150 width		
A = Curve Angle: 45, 90, 135, 180		
RRR = Radius per conveyor Width: 150 = 065 width, 160 = 085 width, 170 = 105 width and 210 = 150 width		
WWW = Conveyor width reference: 065, 085, 105, 150		

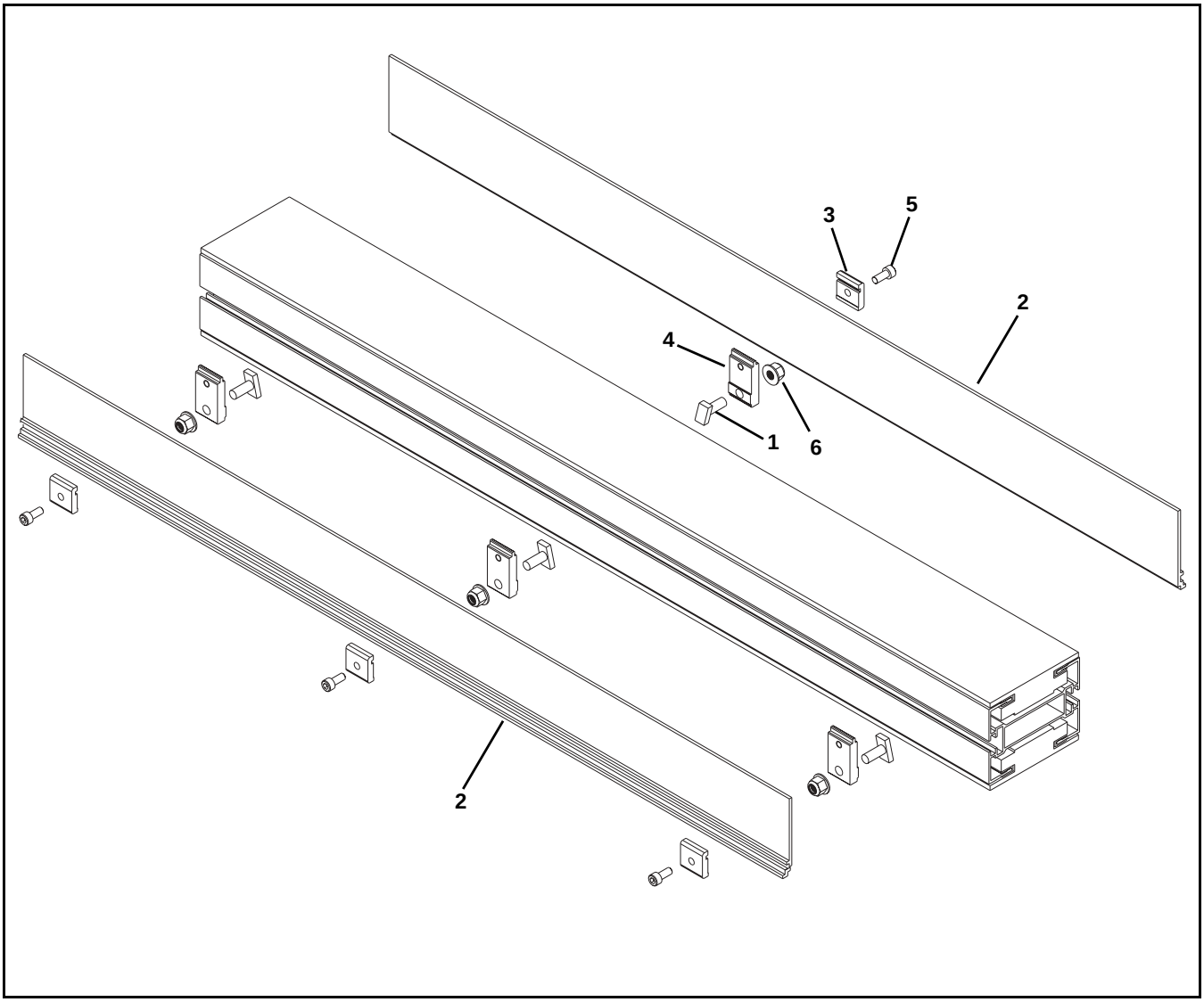
Knuckle Frame Assembly



Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	834-FFVB-5RBBB	5° Knuckle Kit
	834-FFVB-7RBBB	7° Knuckle Kit
	834-FFVB-10RBBB	10° Knuckle Kit
	834-FFVB-15RBBB	15° Knuckle Kit
	834-FFVB-20RBBB	20° Knuckle Kit
	834-FFVB-30RBBB	30° Knuckle Kit
FF = Conveyor Width: FS = 065 width, FM = 085 width, FC = 105 width and FL = 150 width		
BBB = Radius per conveyor Width: 300 = 065 width, 400 = 085 and 105 width, 500 = 150 width		

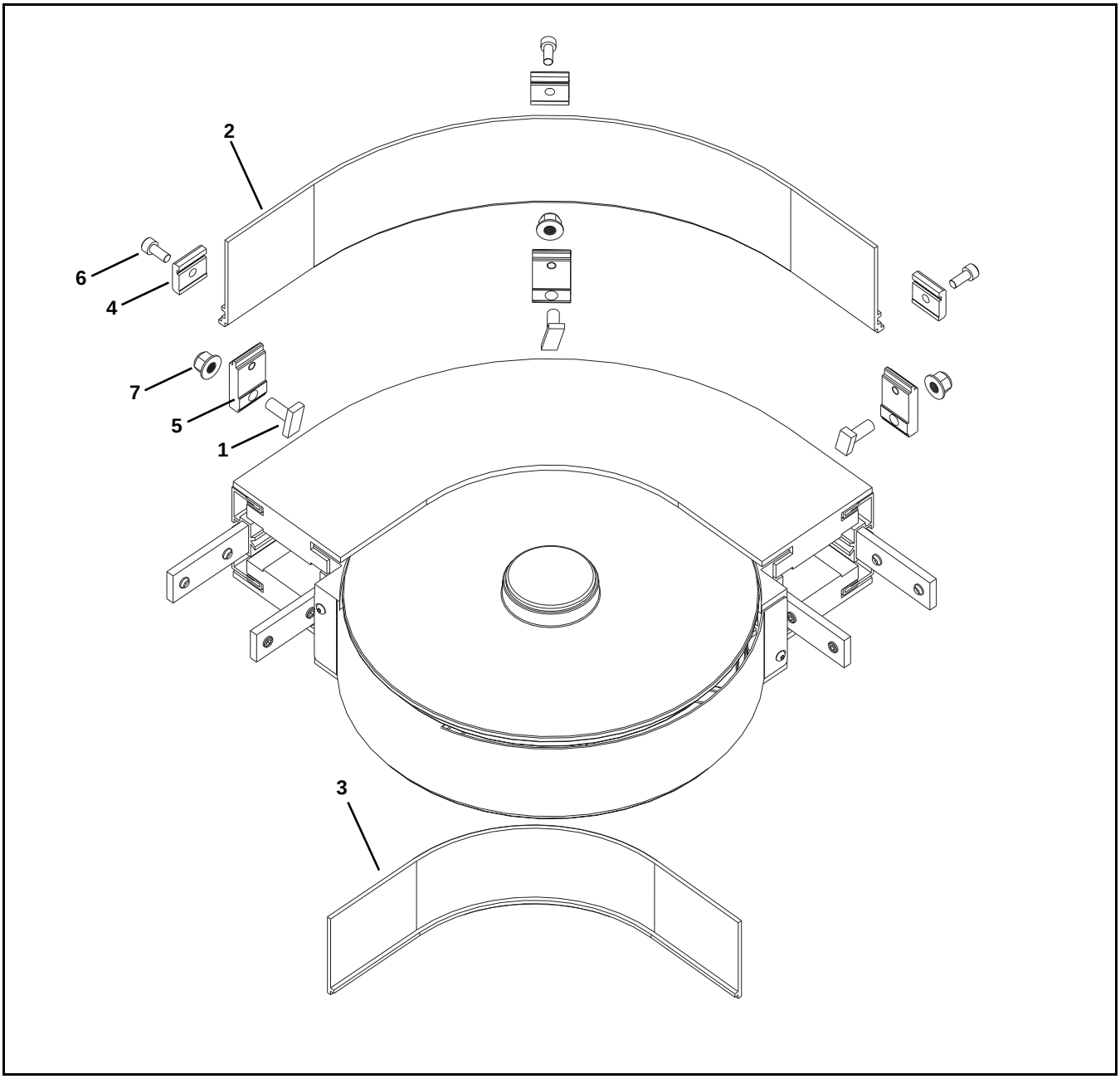
Service Parts

04 3" High Sides for Straight Modules



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204127-LLLLL	3" High Side
3	204566	Mounting Clip
4	210829	Guide Clip Adapter
	210831	Guide Clip Adapter for Tail Mount Only
	210836	Guide Clip Adapter for Roller Transfer Tail Mount Only
5	920614M	Socket Head Screw, M6-1.00 x 14 mm
6	990812M	Hex Nut, M8-1.25
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

04 3" High Sides for Curve Modules

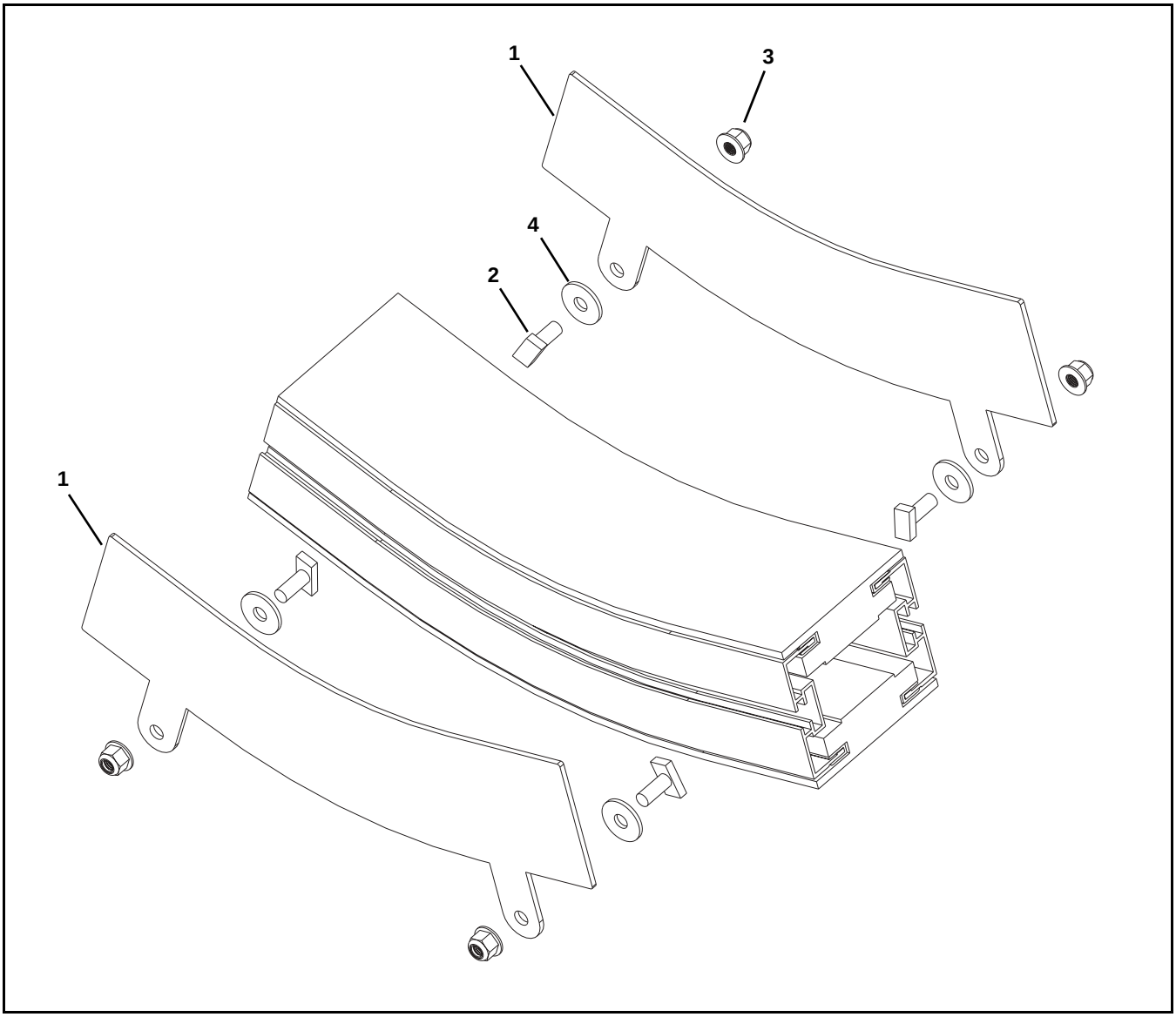


Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204134-WWW-AAA	3" High Side for Wheel Bend Curves - Outside Edge
	204336-WWW-AAA	3" High Side for 500R Plain Bend Curves - Outside Edge
	204340-WWW-AAA	3" High Side for 700R Plain Bend Curves - Outside Edge
3	204136-WWW-AAA	3" High Side for Wheel Bend Curves - Inside Edge
	204335-WWW-AAA	3" High Side for 500R Plain Bend Curves - Inside Edge
	204339-WWW-AAA	3" High Side for 700R Plain Bend Curves - Inside Edge

Item	Part Number	Description
4	204566	Mounting Clip
5	210829	Clip Guide Adapter
6	920614M	Socket Head Screw, M6-1.00 x 14 mm
7	990812M	Hex Nut, M8-1.25
WWW = Conveyor width reference: 065, 085, 105, 150		
AAA = Angle of curve: 045, 090, 135, 180		

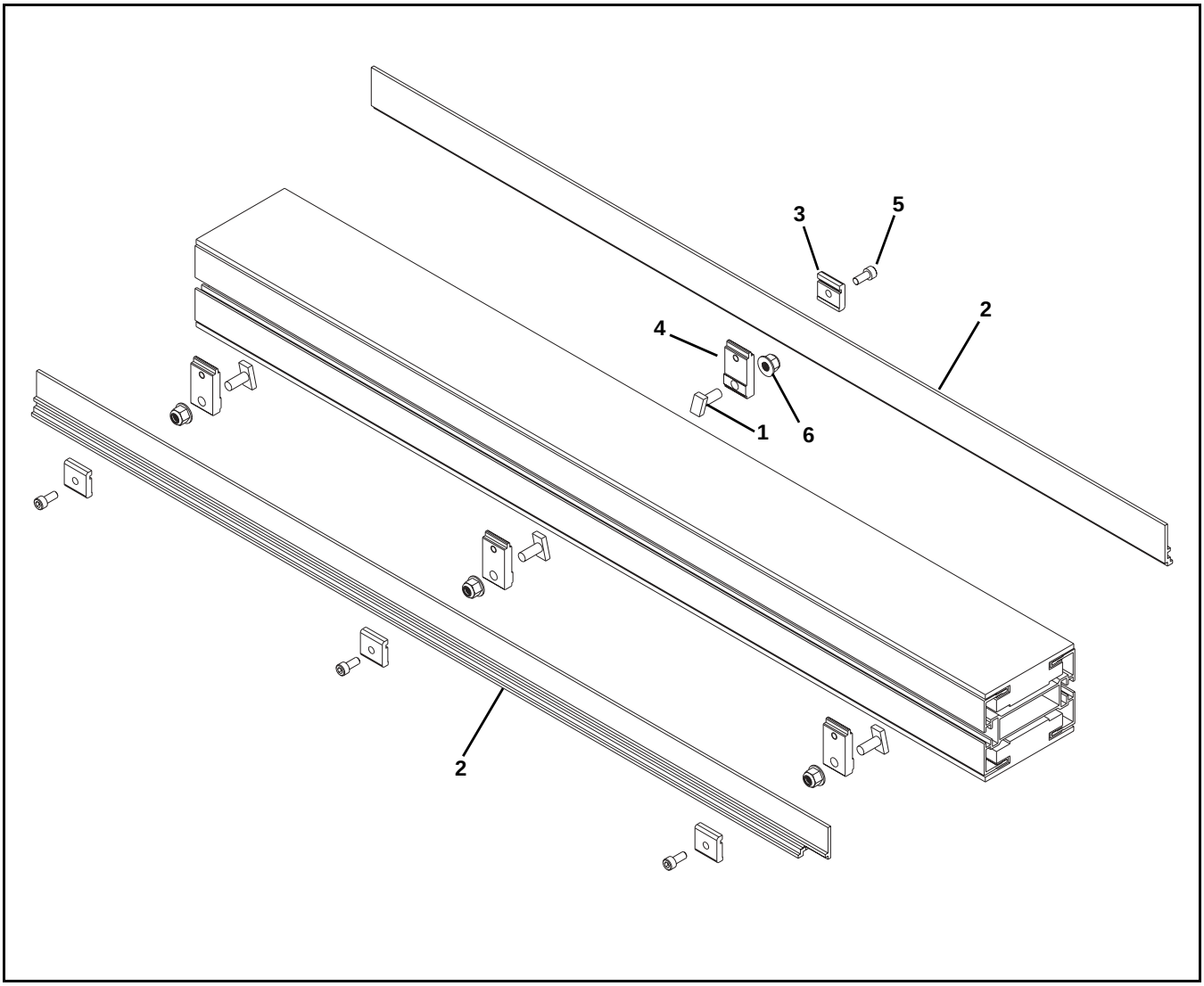
Service Parts

04 3" High Sides for Incline/Decline Modules



Item	Part Number	Description
1	204144-AA-WWW	Guide Plate for Lower knuckle
	204174-AA-WWW	Guide Plate for Upper Knuckle
2	834-FATB-20	Stud, M8 x 20 mm
3	990812M	Hex Nut, M8-1.25
4	204145	Spacer
WWW = Conveyor width reference: 065, 085, 105, 150		
AAA = Angle of curve: 045, 090, 135, 180		

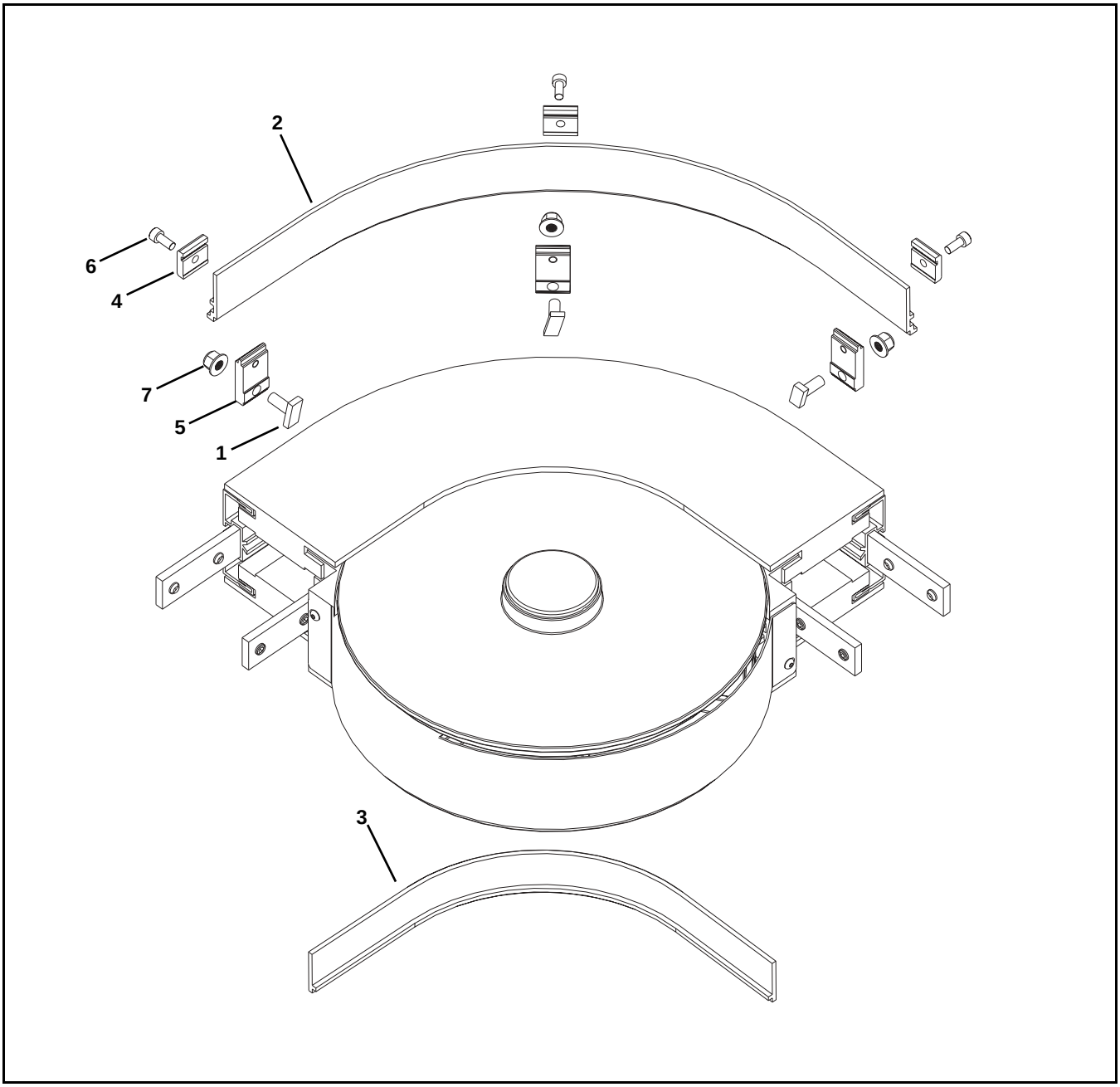
05 1.50" High Sides for Straight Modules



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204172-LLLLL	1.50" High Side
3	204566	Mounting Clip
4	210829	Guide Clip Adapter
	210831	Guide Clip Adapter for Tail Mount Only
	210836	Guide Clip Adapter for Roller Transfer Tail Mount Only
5	920614M	Socket Head Screw, M6-1.00 x 14 mm
6	990812M	Hex Nut, M8-1.25
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

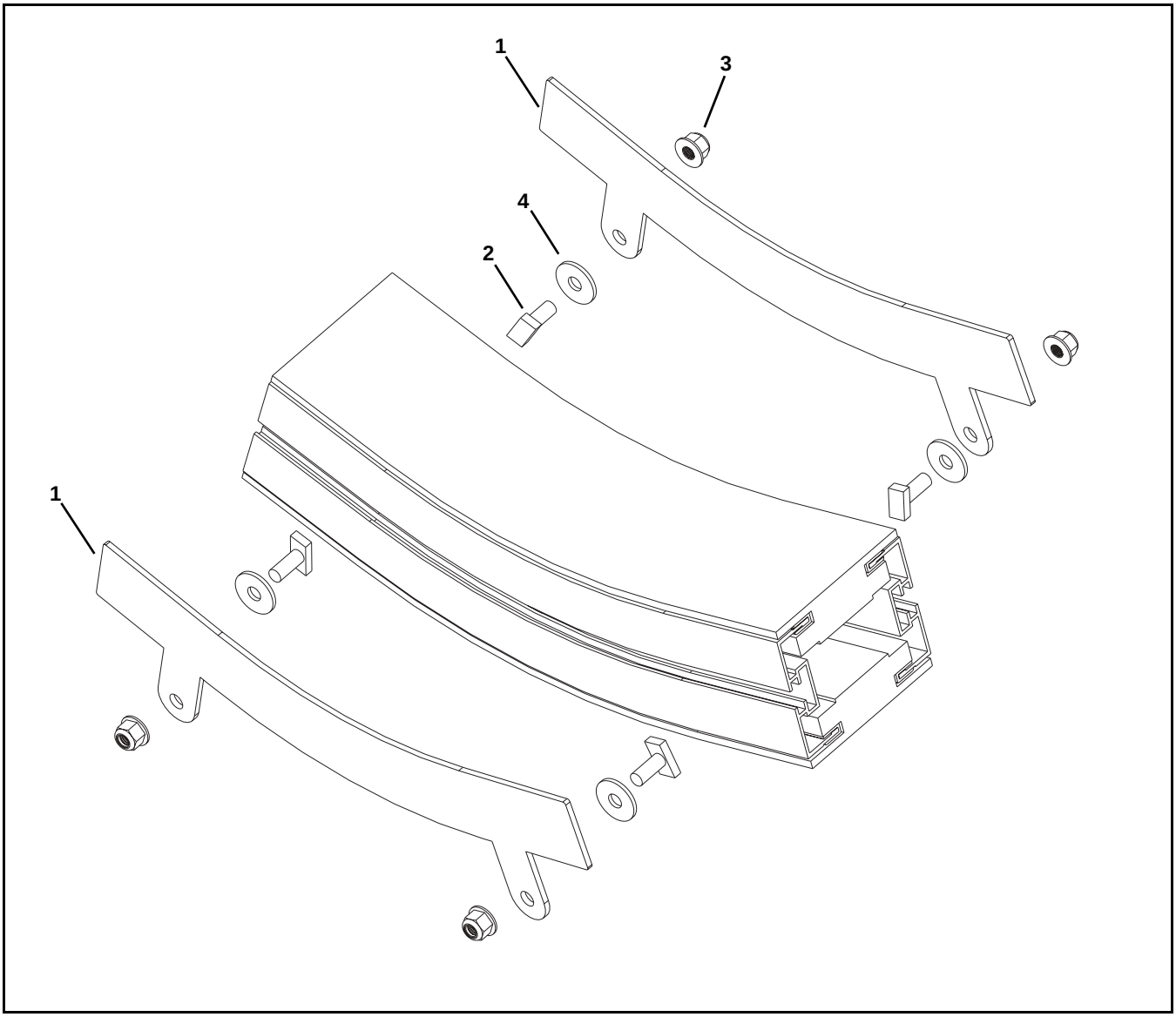
05 1.50" High Sides for Curve Modules



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204135-WWW-AAA	1.50" High Side for Wheel Bend Curves - Outside Edge
	204334-WWW-AAA	1.50" High Side for 500R Plain Bend Curves - Outside Edge
	204338-WWW-AAA	1.50" High Side for 700R Plain Bend Curves - Outside Edge
3	204137-WWW-AAA	1.50" High Side for Wheel Bend Curves - Inside Edge
	204333-WWW-AAA	1.50" High Side for 500R Plain Bend Curves - Inside Edge
	204337-WWW-AAA	1.50" High Side for 700R Plain Bend Curves - Inside Edge

Item	Part Number	Description
4	204566	Mounting Clip
5	210829	Clip Guide Adapter
6	920614M	Socket Head Screw, M6-1.00 x 14 mm
7	990812M	Hex Nut, M8-1.25
WWW = Conveyor width reference: 065, 085, 105, 150		
AAA = Angle of curve: 045, 090, 135, 180		

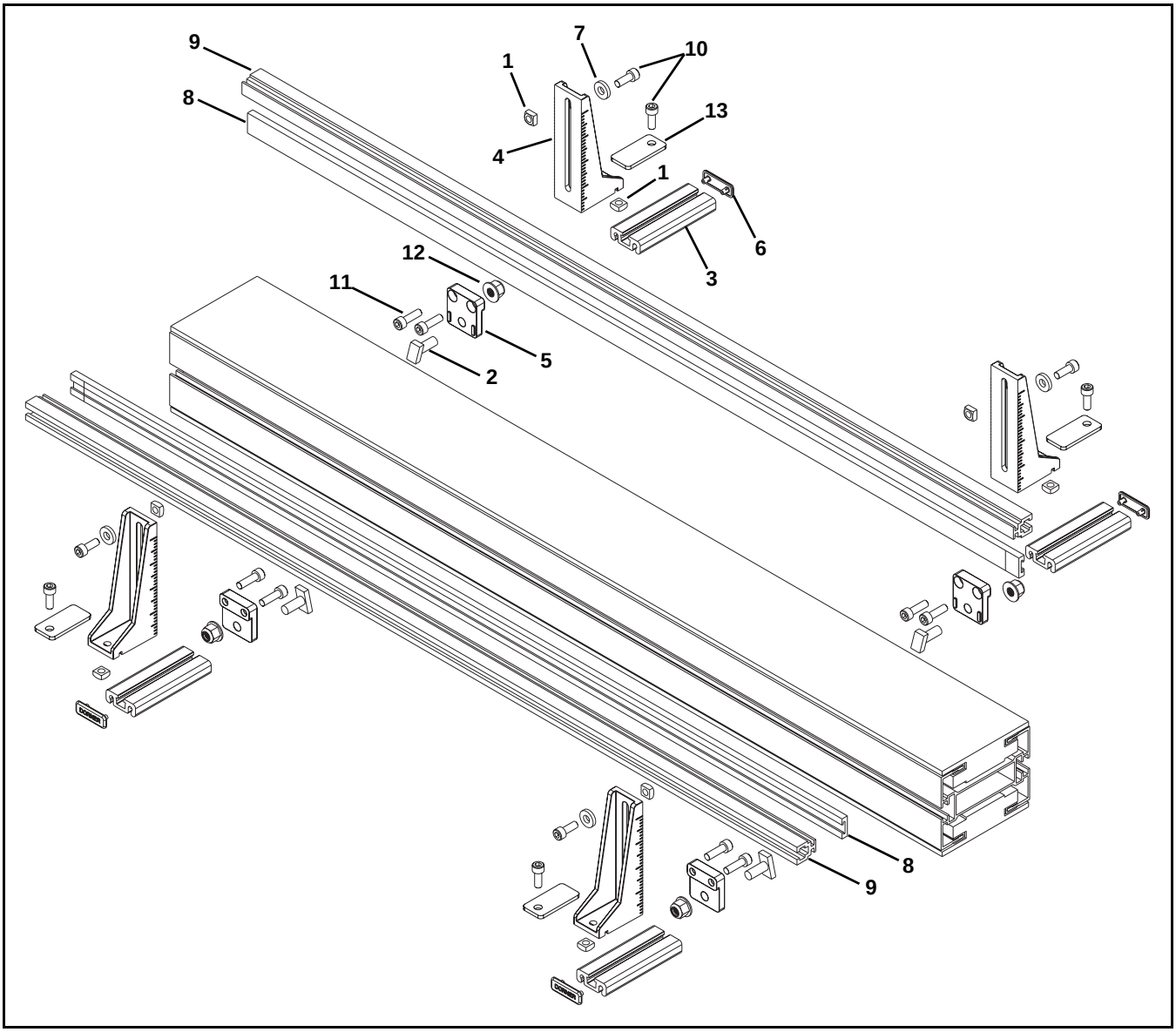
05 1.50" High Sides for Incline/Decline Modules



Item	Part Number	Description
1	204342-AA-WWW	Guide Plate for Lower knuckle
	204343-AA-WWW	Guide Plate for Upper Knuckle
2	834-FATB-20	Stud, M8 x 20 mm
3	990812M	Hex Nut, M8-1.25
4	204145	Spacer
WWW = Conveyor width reference: 065, 085, 105, 150		
AAA = Angle of curve: 045, 090, 135, 180		

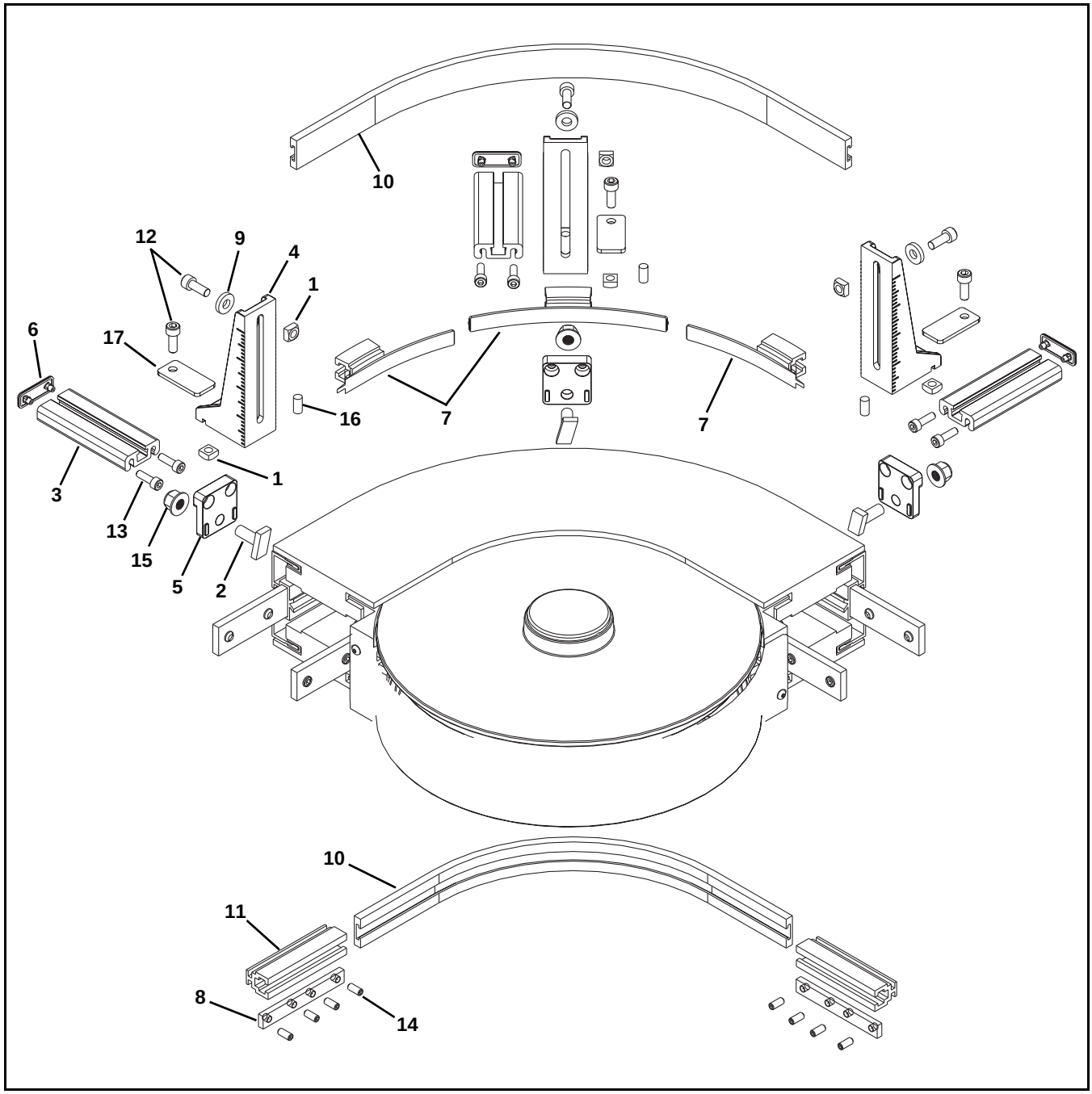
Service Parts

13 Fully Adjustable Guiding for Straight Modules



Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00353	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	605279P	Washer
8	614068P-LLLLL	Guiding
9	636975P-LLLLL	Guide Rail
10	920616M	Socket Head Screw, M6-1.00 x 16 mm
11	920516M	Socket Head Screw, M5-0.80 x 16 mm
12	990812M	Hex Nut, M8-1.25
13	207388	Guide Plate
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

13 Fully Adjustable Guiding for Curve Modules

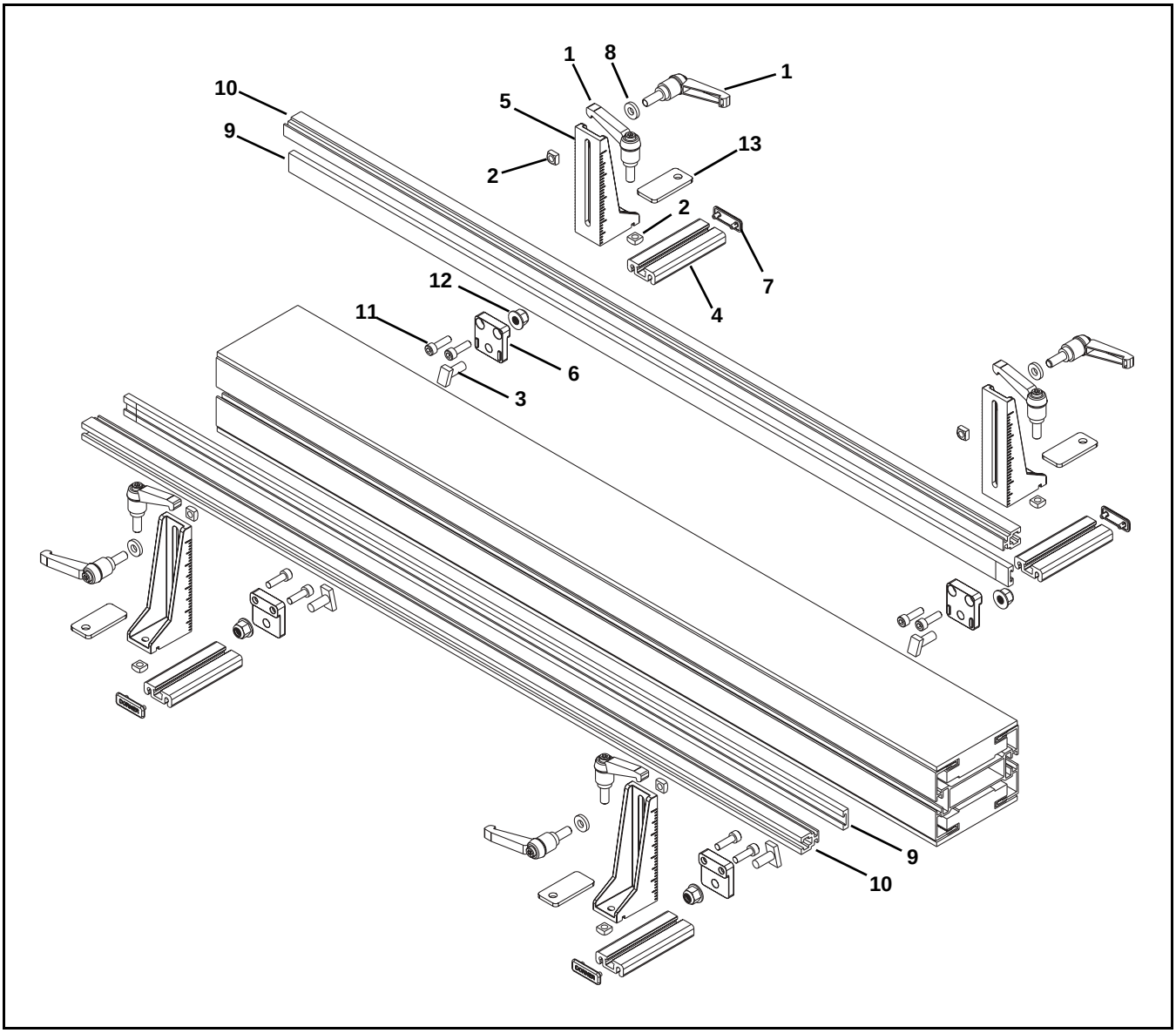


Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00353	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	203494	Guide Support
8	210913	Nut Bar
9	605279P	Washer
10	614068P-LLLLL	Guiding

Item	Part Number	Description
11	636975P-LLLLL	Guide Rail
12	920616M	Socket Head Screw, M6-1.00 x 16 mm
13	920516M	Socket Head Screw, M5-0.80 x 16 mm
14	930510M	Flat Head Screw, M5-0.80 x 10 mm
15	990812M	Hex Nut, M8-1.25
16	913-051	Roll Pin
17	207388	Guide Plate
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

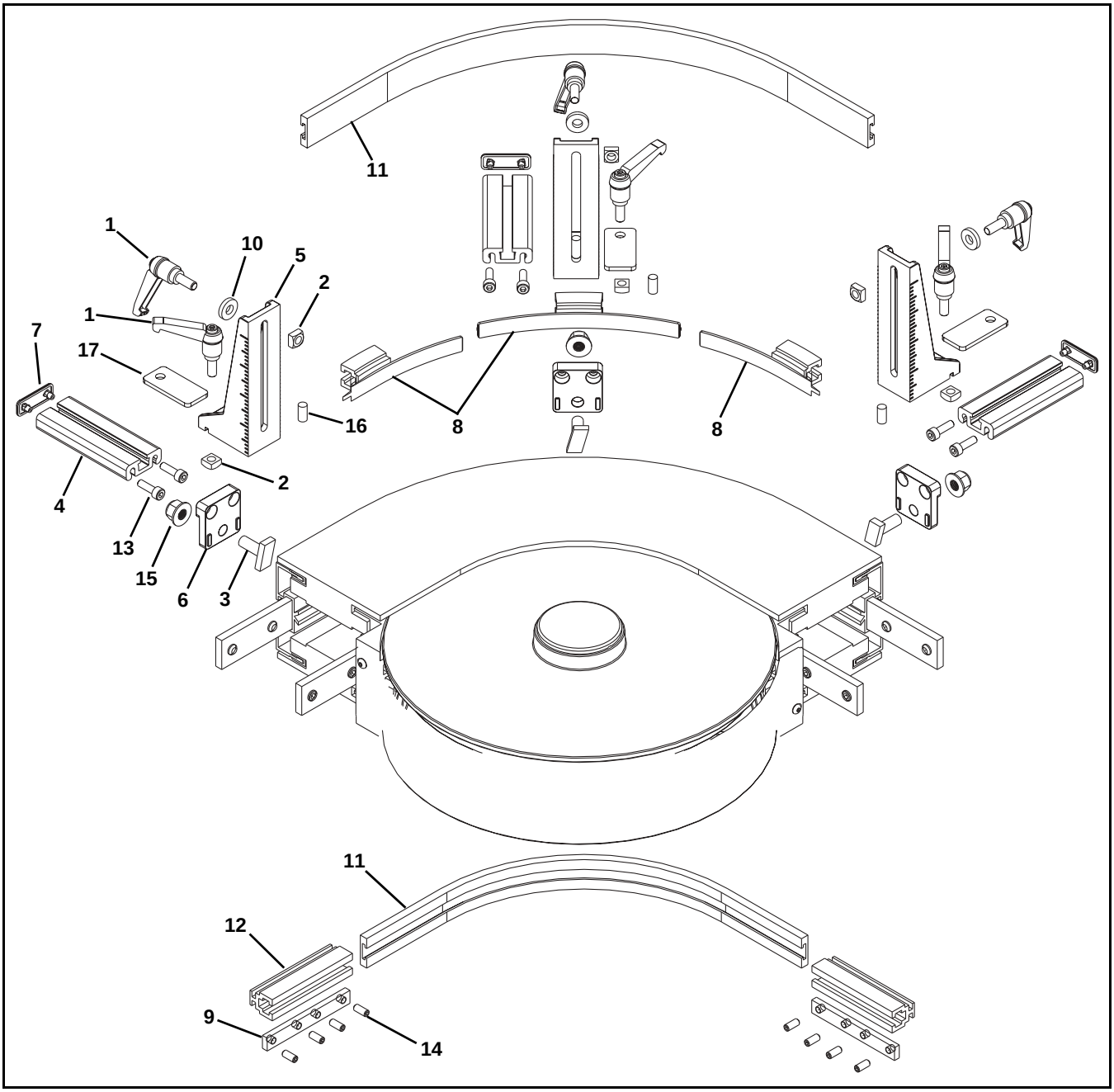
Service Parts

14 Tool-Less Fully Adjustable Guiding for Straight Modules



Item	Part Number	Description
1	807-2272	Handle
2	807-920	Square Nut, M6-1.0
3	834-FATB-20	Stud, M8 x 20 mm
4	210846-00353	Extrusion Base
5	210847	Mounting Bracket
6	210848	Mounting Block
7	210849	Cap
8	605279P	Washer
9	614068P-LLLLL	Guiding
10	636975P-LLLLL	Guide Rail
11	920516M	Socket Head Screw, M5-0.80 x 16 mm
12	990812M	Hex Nut, M8-1.25
13	207388	Guide Plate
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

14 Tool-Less Fully Adjustable Guiding for Curve Modules

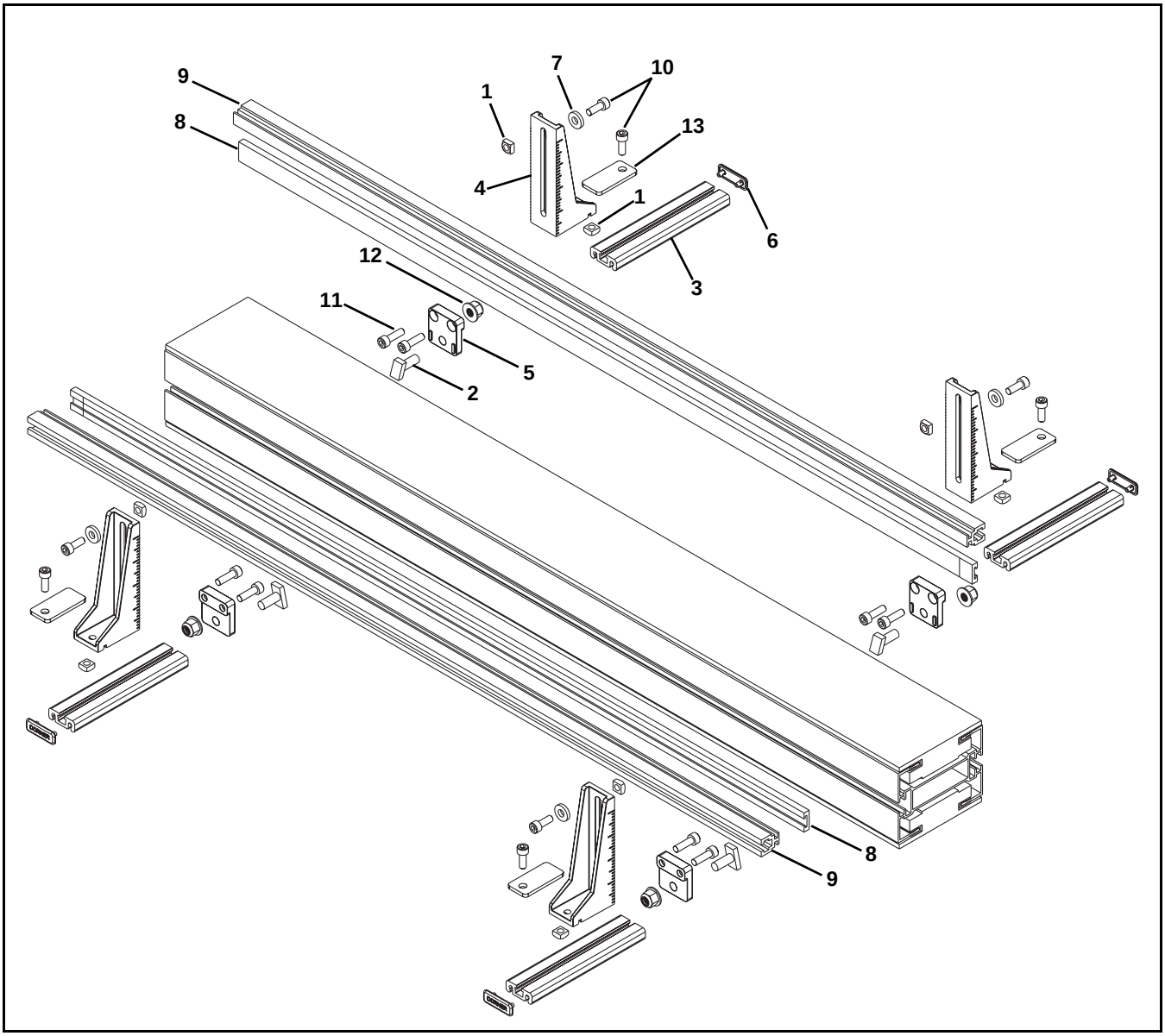


Item	Part Number	Description
1	807-2272	Handle
2	807-920	Square Nut, M6-1.0
3	834-FATB-20	Stud, M8 x 20 mm
4	210846-00353	Extrusion Base
5	210847	Mounting Bracket
6	210848	Mounting Block
7	210849	Cap
8	203494	Guide Support
9	210913	Nut Bar
10	605279P	Washer
11	614068P-LLLLL	Guiding

Item	Part Number	Description
12	636975P-LLLLL	Guide Rail
13	920516M	Socket Head Screw, M5-0.80 x 16 mm
14	930510M	Flat Head Screw, M5-0.80 x 10 mm
15	990812M	Hex Nut, M8-1.25
16	913-051	Roll Pin
17	207388	Guide Plate
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

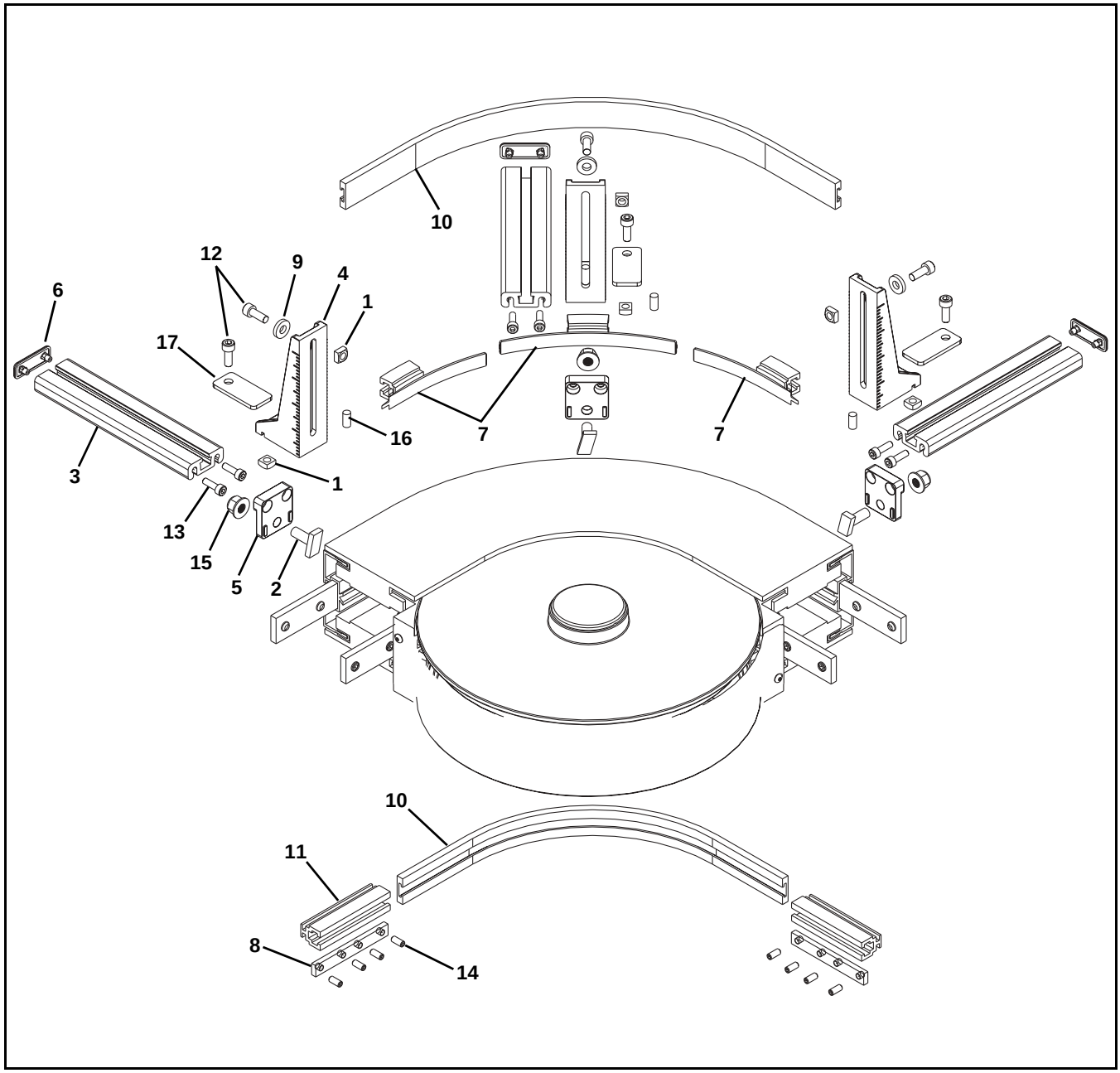
Service Parts

16 Gull Wing Guiding for Straight Modules



Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00600	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	605279P	Washer
8	614068P-LLLLL	Guiding
9	636975P-LLLLL	Guide Rail
10	920616M	Socket Head Screw, M6-1.00 x 16 mm
11	920516M	Socket Head Screw, M5-0.80 x 16 mm
12	990812M	Hex Nut, M8-1.25
13	207388	Guide Plate
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

16 Gull Wing Guiding for Curve Modules

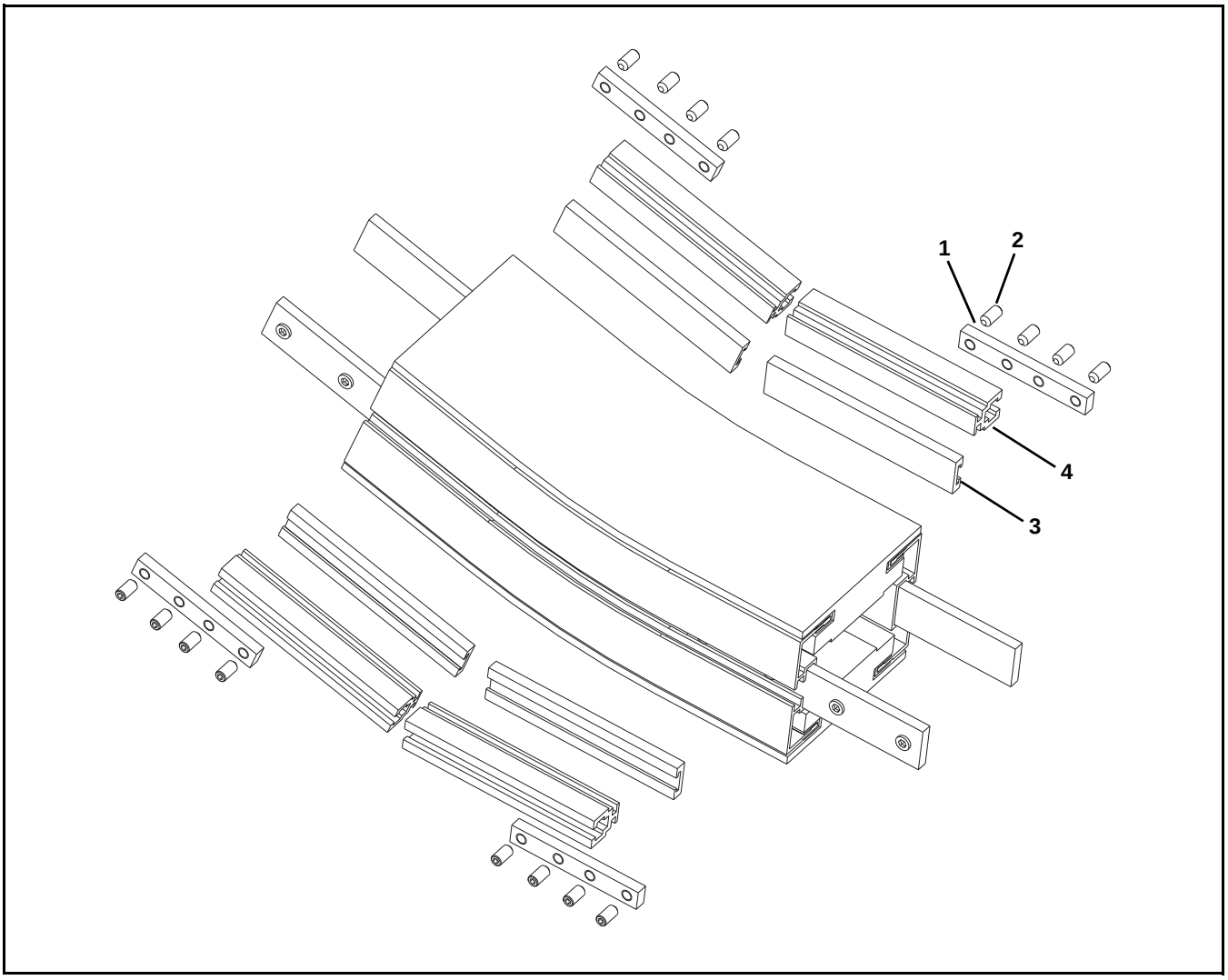


Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00600	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	203494	Guide Support
8	210913	Nut Bar
9	605279P	Washer
10	614068P-LLLLL	Guiding
11	636975P-LLLLL	Guide Rail
12	920616M	Socket Head Screw, M6-1.00 x 16 mm

Item	Part Number	Description
13	920516M	Socket Head Screw, M5-0.80 x 16 mm
14	930510M	Flat Head Screw, M5-0.80 x 10 mm
15	990812M	Hex Nut, M8-1.25
16	913-051	Roll Pin
17	207388	Guide Plate
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

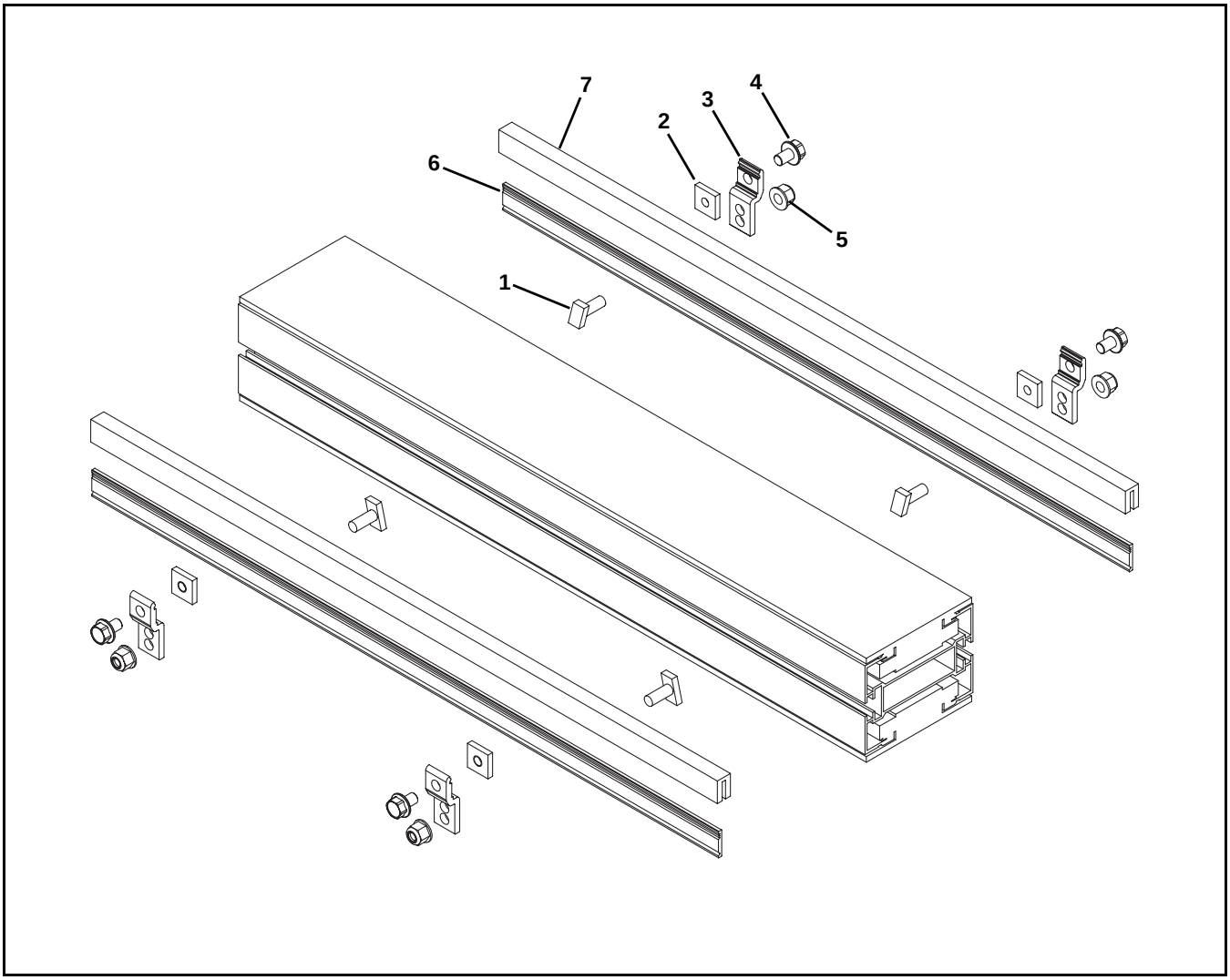
Service Parts

#13 & #14 - Adjustable Guiding and #16 - Gull Wing Guiding for Incline/ Decline Modules



Item	Part Number	Description
1	210913	Nut Bar
2	930510M	Flat Head Screw, M5-0.80 x 10 mm
3	614068P-LLLLL	Guiding
4	636975P-LLLLL	Guide Rail
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

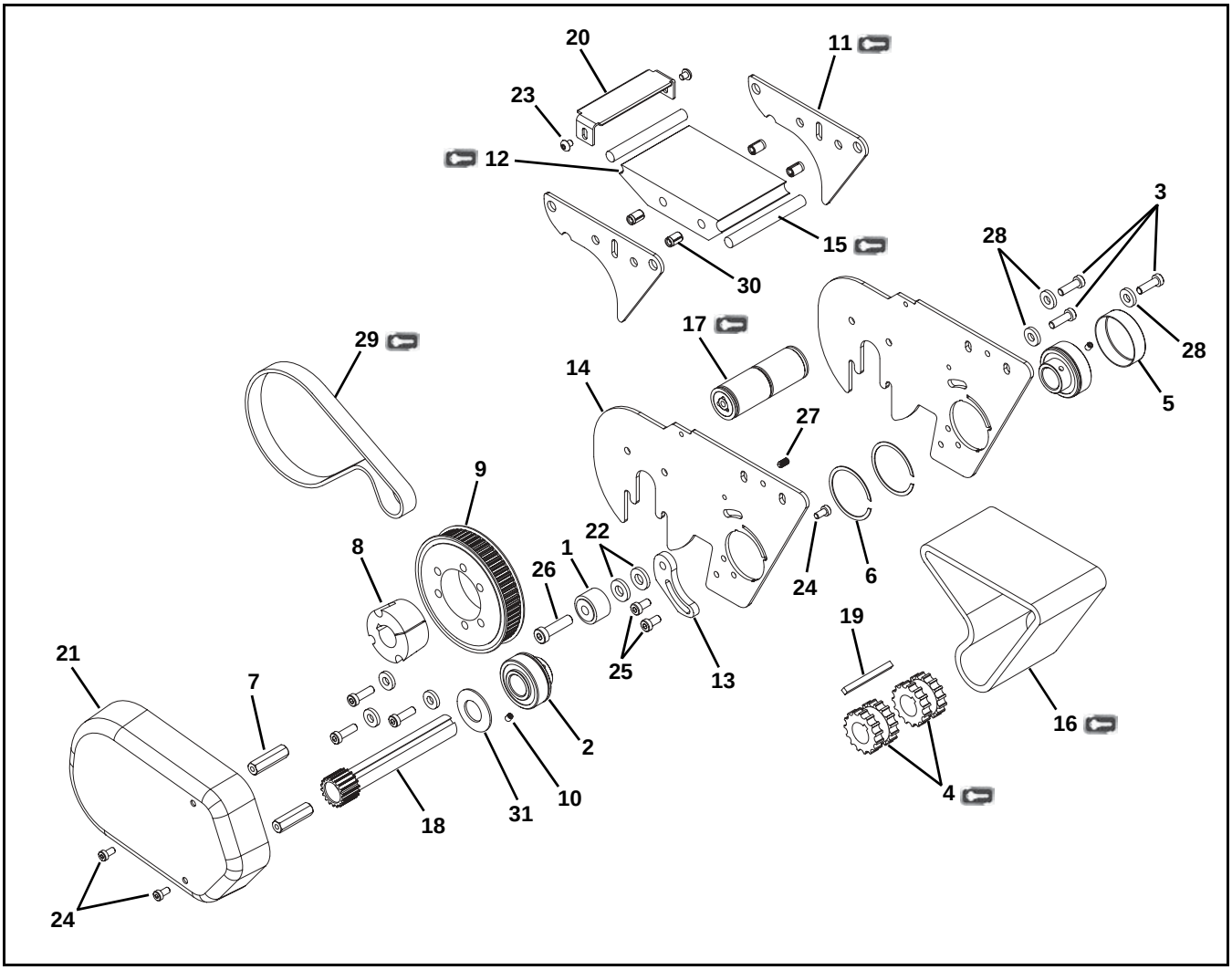
#17 & #18 - Puck / Pallet Guiding



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	834-FASN-M8	Slide-In Nut, M8
3	205129	Clip
4	960882M	Hex Head Flange Screw, M8 x 12 mm
5	990812M	Hex Nut, M8-1.25
6	460055	Guide Rail (per foot)
7	203825	Clip On Wear Strip (per foot)

Service Parts

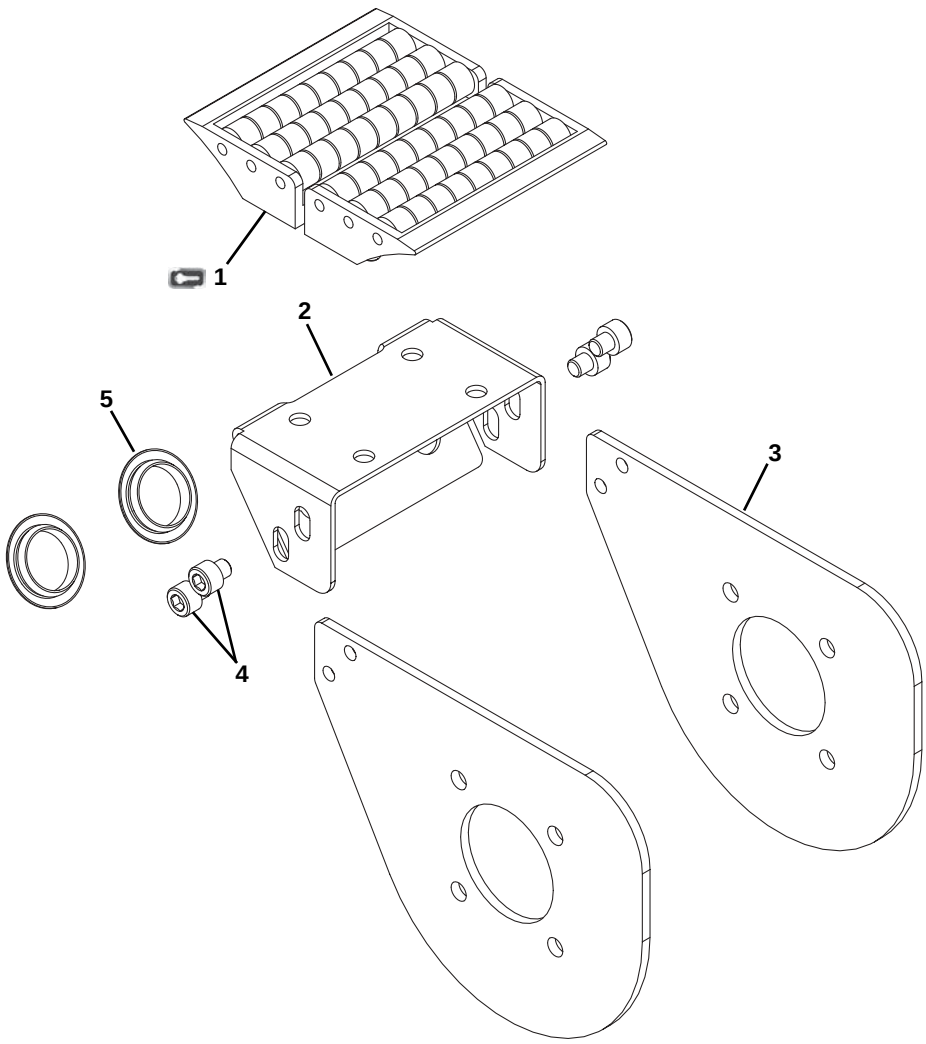
Power Transfer



Item	Part Number	Description
1	802-046	Cam Bearing
2	802-110	Bearing
3	950620M	Low Head Cap Screw, M6-1.00 x 20 mm
4	807-2009	Sprocket
5	807-2285	Cover
6	807-2286	Retaining Ring
7	807-2287	Hex Post
8	811-289	Bushing
9	811-559	Pulley
10	907-115	Socket Head Set Screw, #10-32 x 0.19
11	203229	Side Guide Plate
12	205711-WWW	Wear Bar
13	203231	Timing Belt Tensioner
14	203243	Side Plate for 65 width Conveyors
	205710-WWW	Side Plate for 85 width Conveyors
	203244	Side Plate for 105 & 150 width Conveyors
15	205726-WWW	Wear Rod

Item	Part Number	Description
16	203249-WWW	Power Transfer Belt
17	205725-WWW	Tensioner Assembly
18	203264-WWW	Shaft Assembly
19	203267-WWW	Square Key, 3/16” x 105 mm
20	205727-WWW	Tensioner Plate
21	350505	Power Transfer Cover
22	605280P	Washer
23	910506M	Button Head Screw, M5-0.80 x 6 mm
24	950510M	Low Head Cap Screw, M5-0.80 x 10 mm
25	950612M	Low Head Cap Screw, M6-1.00 x 12 mm
26	950830M	Low Head Cap Screw, M8-1.25 x 30 mm
27	970510M	Socket Head Set Screw, M5-0.80 x 10 mm
28	605279P	Washer
29	814-097	Timing Belt 5 mm x 15 mm
30	990621M	Insert
31	807-2277	Washer
WWW= Conveyor width reference: 065, 085, 105, 150		

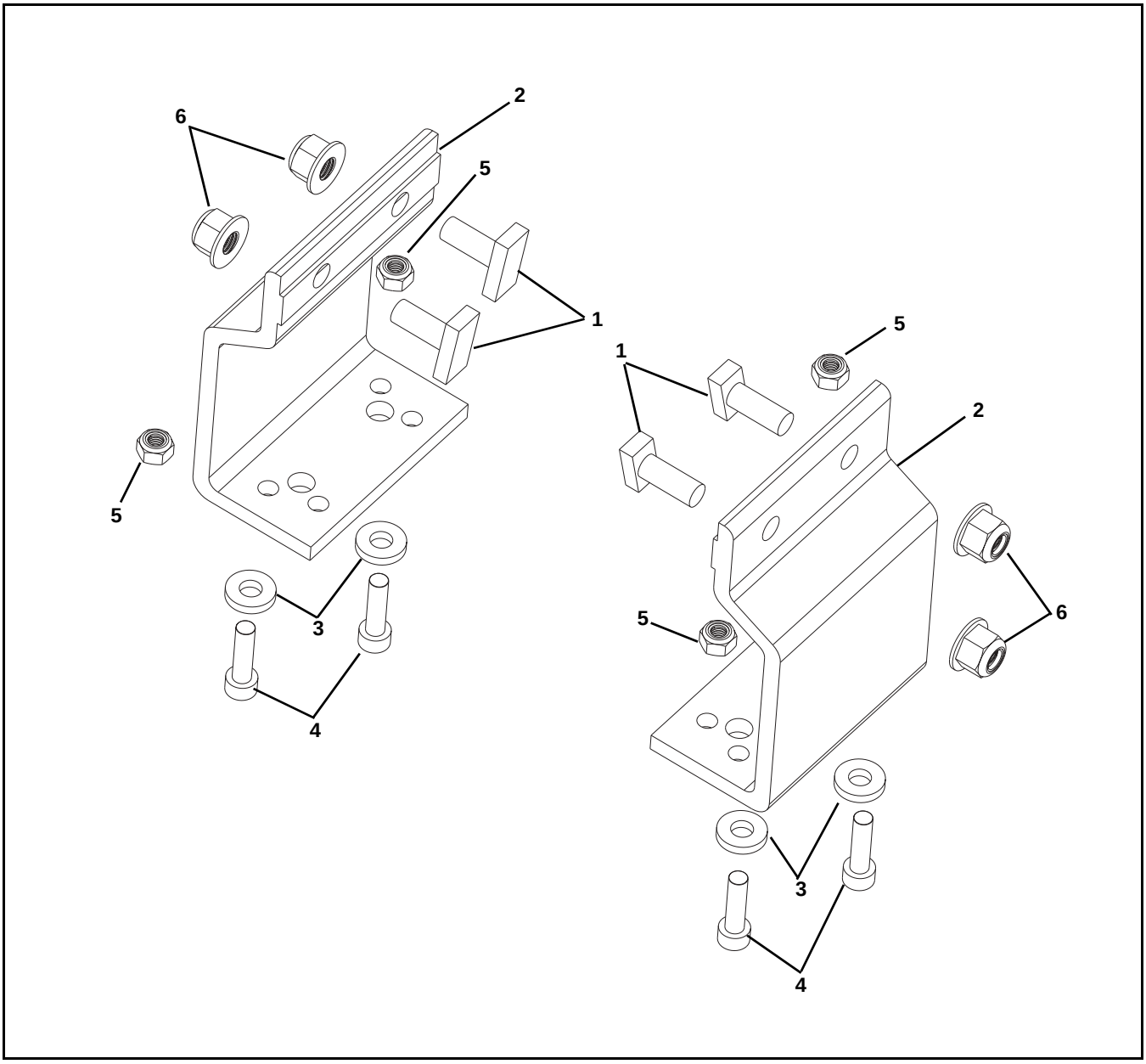
Transfer Roller



Item	Part Number	Description
1	807-1829	Transfer Roller for 65 & 85 Width Conveyors (2x)
	807-1830	Transfer Roller for 105 Width Conveyors (2x)
	807-1829	Transfer Roller for 150 Width Conveyors (4x)
2	206195-WWW	Bracket
3	206172	Side Plate
4	920606M	Socket Head Screw, M6-1.00 x 6 mm
5	807-3118	Plug
WWW= Conveyor width reference: 065, 085, 105, 150		

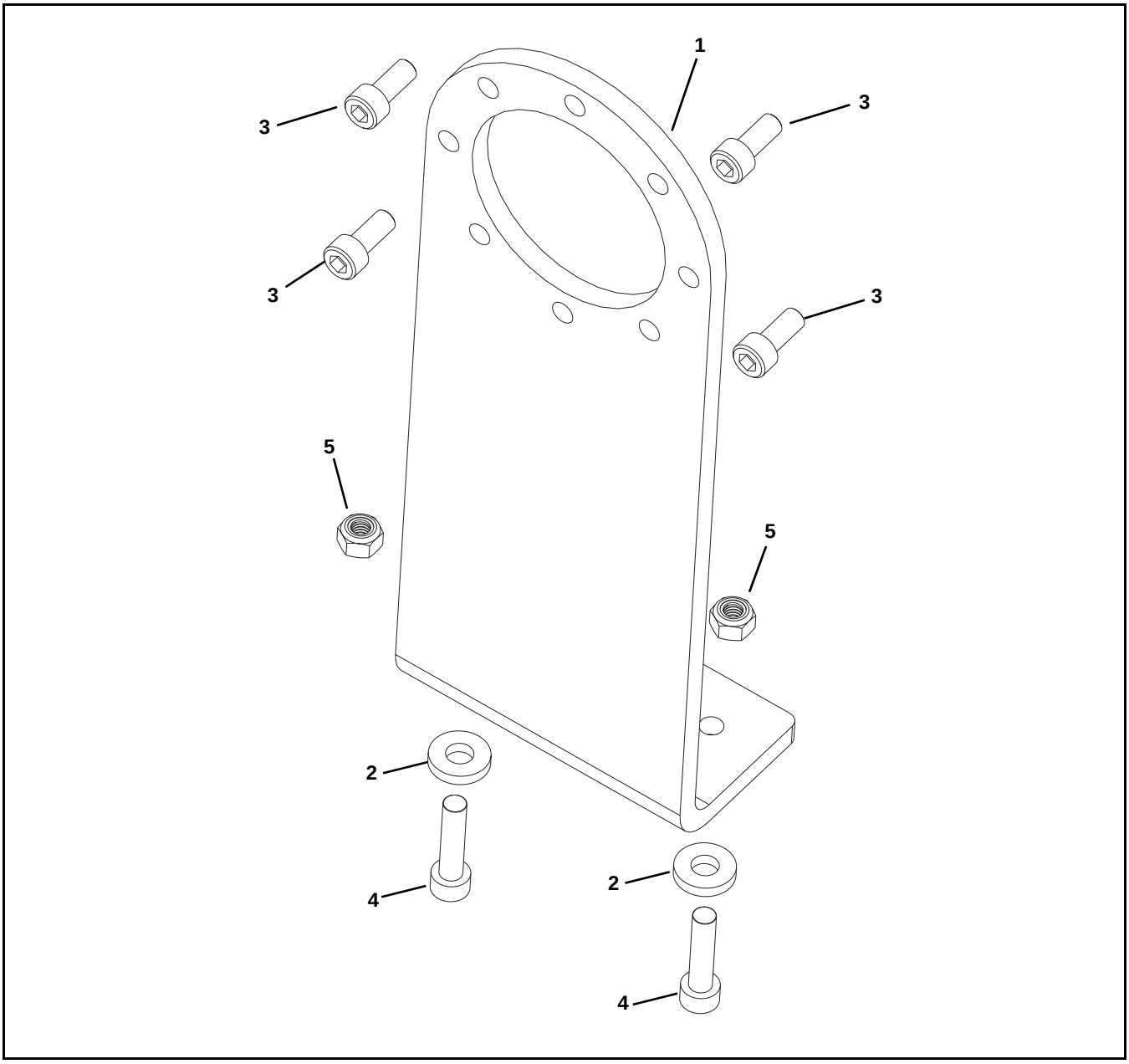
Service Parts

Mounting Brackets



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	834-FAHBS-80SPL	Mounting Bracket
3	605279P	Washer
4	920622M	Socket Head Screw, M6-1.00 x 22 mm
5	990602M	Hex Nut, M6-1.00
6	990812M	Flanged Hex Nut, M8-1.25

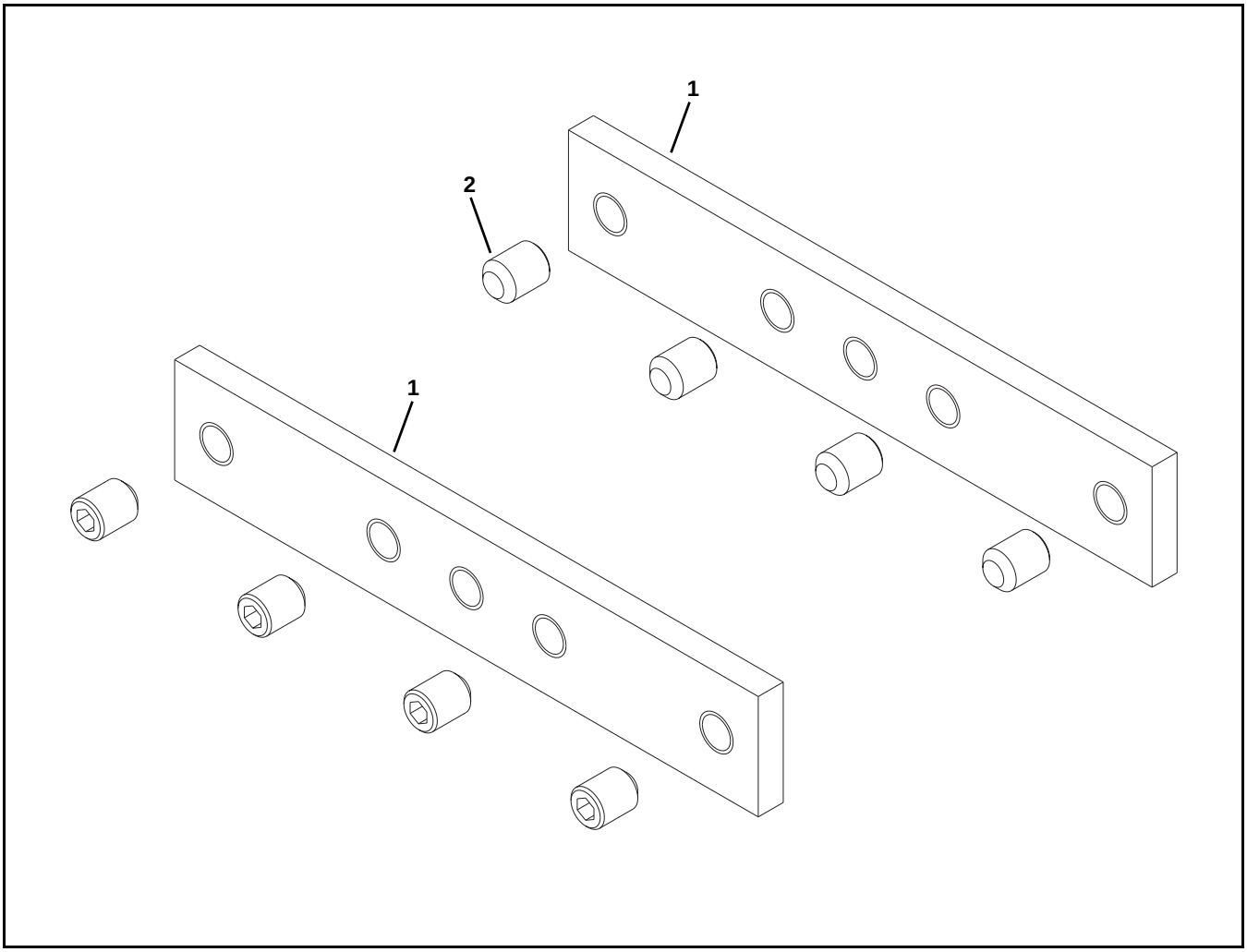
Motor Mounting Assembly



Item	Part Number	Description
1	203166	Motor Mounting Bracket
2	605279P	Washer
3	920614M	Socket Head Screw, M6-1.00 x 14 mm
4	920625M	Socket Head Screw, M6-1.00 x 25 mm
5	990602M	Hex Nut, M6-1.00

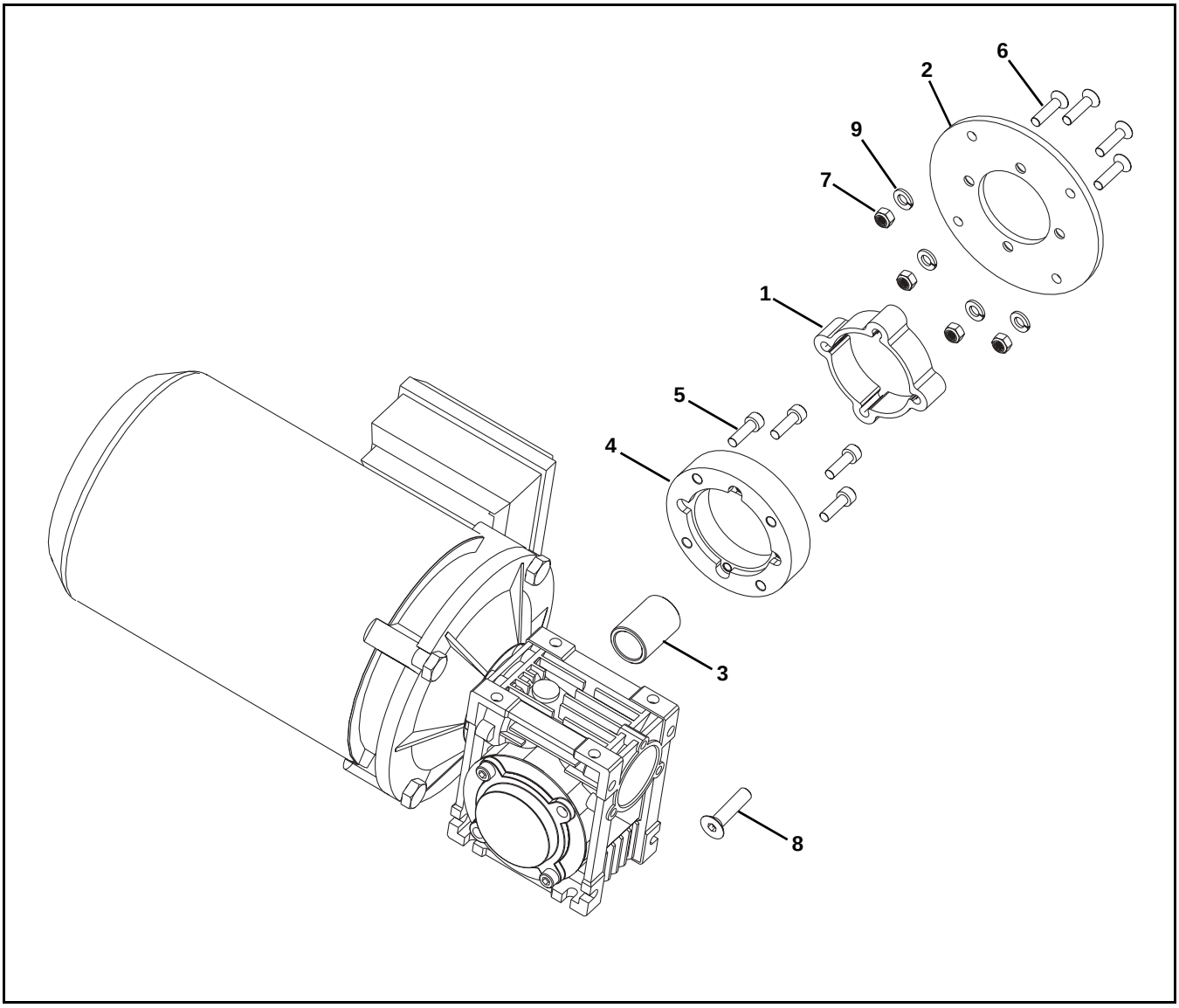
Service Parts

Connecting Assembly



Item	Part Number	Description
1	834-FACS-25x140A	Connecting Bracket
2	970810M	Set Screw, M8-1.25 x 10 mm

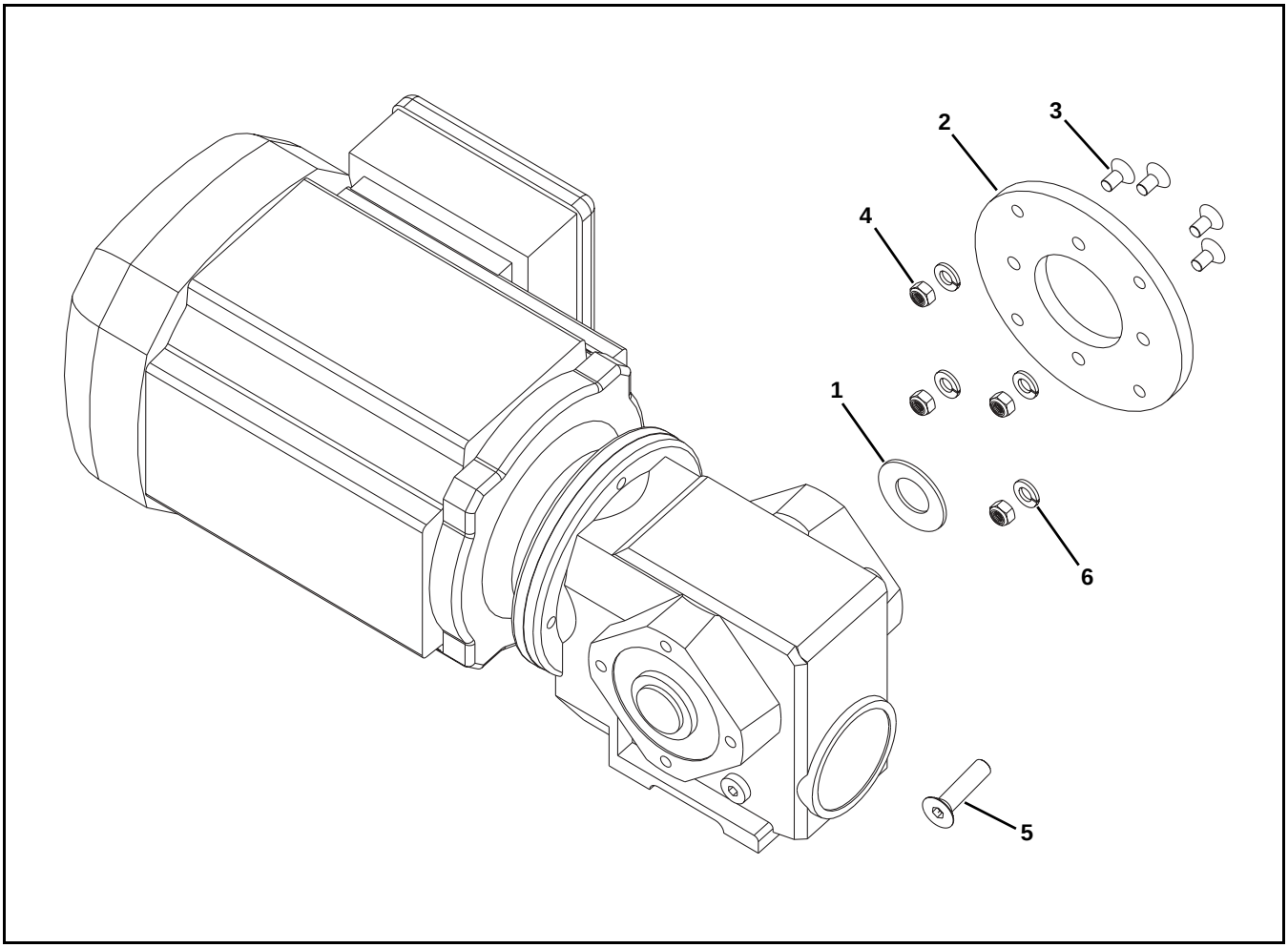
E-Drive and CE Gearmotor Mounting Package



Item	Part Number	Description
1	202270-00075	Extrusion
2	202971	Drive Plate
3	203065	Drive Spacer
4	350115	Adapter Ring
5	920620M	Socket Head Screw, M6-1.00 x 20 mm
6	930625M	Flat Head Screw, M6-1.00 x 25 mm
7	990601M	Hex Nut, M6-1.00
8	931025M	Flat Head Screw, M10-1.50 x 25 mm
9	911-108	Washer

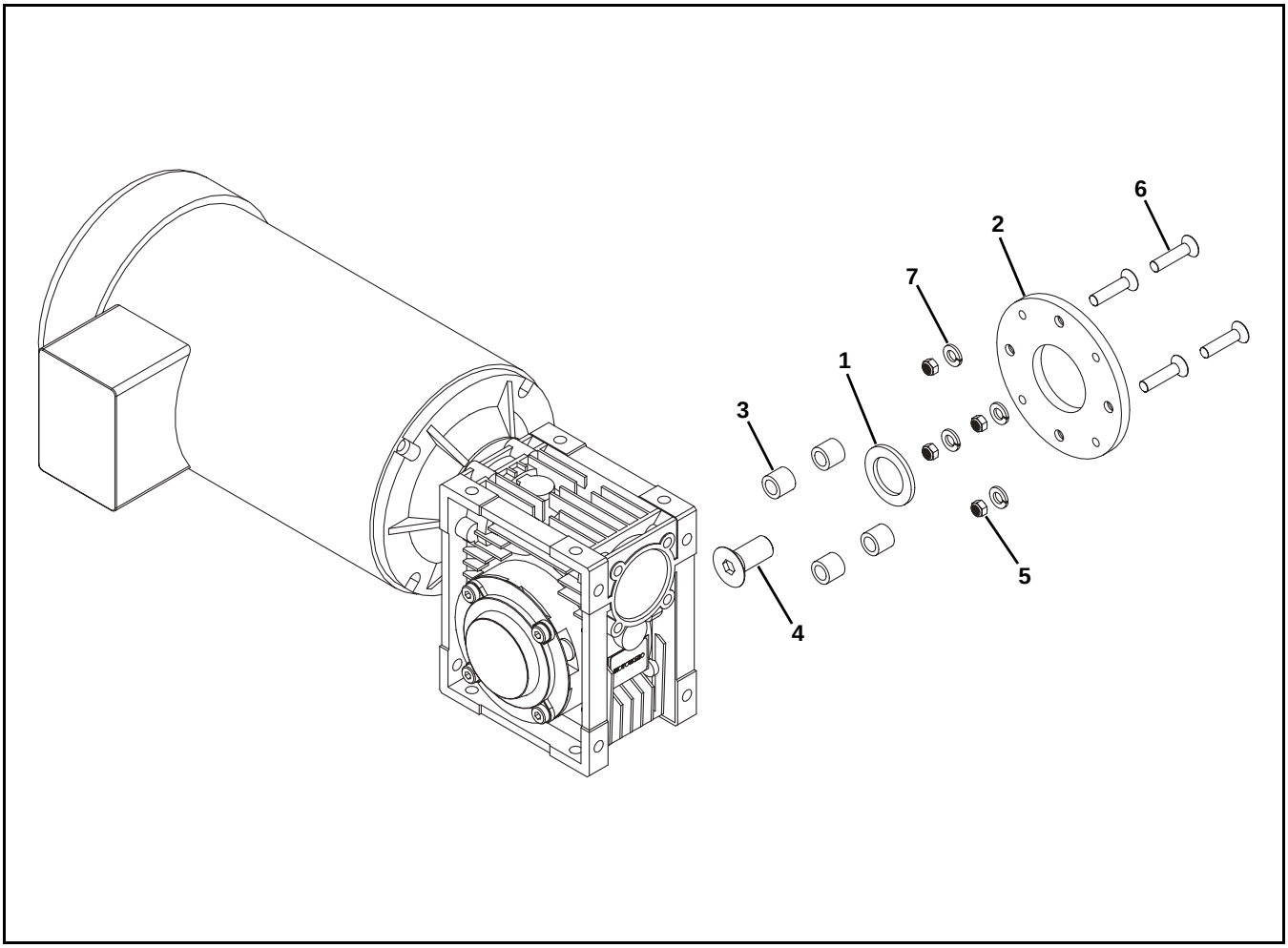
Service Parts

SEW Gearmotor Mounting Package



Item	Part Number	Description
1	807-3104	Shim
2	203043	Drive Plate
3	930612M	Flat Head Screw, M6-1.00 x 12 mm
4	990601M	Hex Nut, M6-1.00
5	931025M	Flat Head Screw, M10-1.50 x 25 mm
6	911-108	Washer

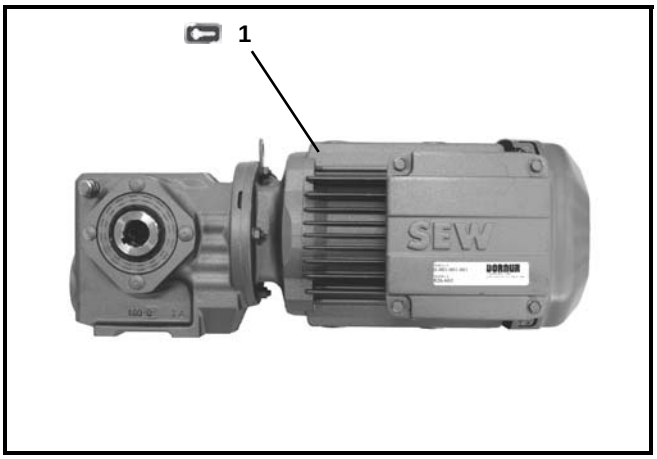
Heavy Load Gearmotor Mounting Package



Item	Part Number	Description
1	203844	Shim
2	203846	Drive Plate
3	352314	Spacer
4	931640M	Flat Head Screw, M16-2.0 x 40 mm
5	990601M	Hex Nut, M6-1.00
6	930835M	Flat Head Screw, M8-1.25 x 35 mm
7	911-108	Washer

Service Parts

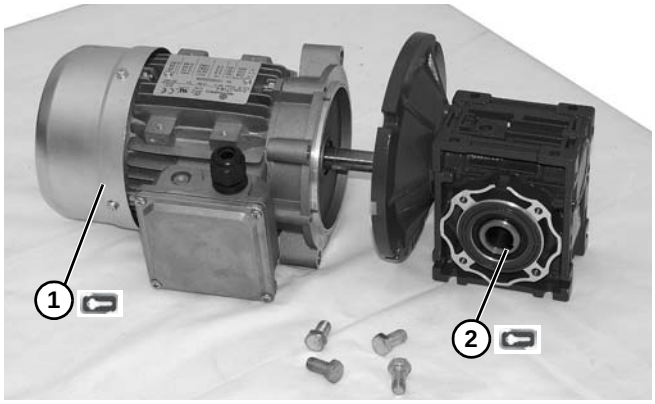
90° SEW Gearmotors



Item	Part Number	Description
1	32M038WS423EN	Gearmotor, 0.80 Hp (0.37 Kw), 230/460 Volts, 37.7:1
	32M013WS423EN	Gearmotor, 0.75 Hp (0.56 Kw), 230/460 Volts, 13.4:1
	32M007WS423EN	Gearmotor, 1.00 Hp (0.75 Kw), 230/460 Volts, 6.8:1

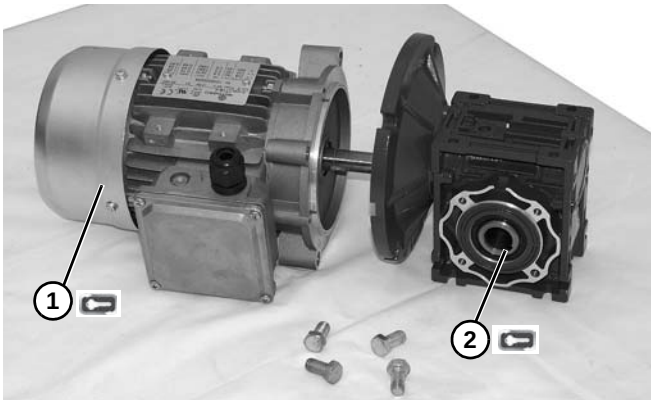
Standard Load 90° Industrial Gearmotors

U.S. Version



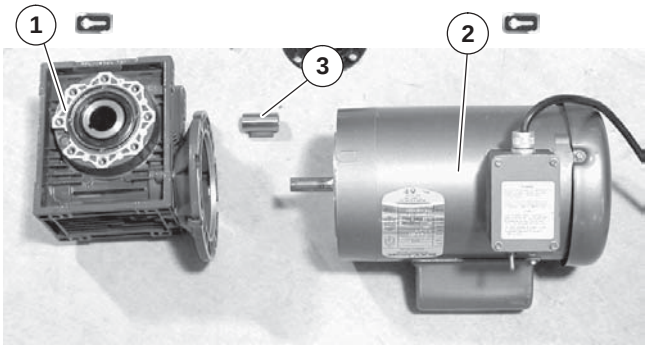
Item	Part No.	Description
1	62MES411FN	Motor, 0.25hp (0.19Kw), 115/230 Volts, 60 Hz, 1-Phase
	62MES423FN	Motor, 0.25hp (0.19Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	22MSD3DEN	Motor, 0.25hp (0.19Kw), 130 VDC
	62MEH411FN	Motor, 0.5hp (0.37Kw), 115/230 Volts, 60Hz, 1–Phase
	32MES423FN	Motor, 0.5hp (0.37Kw) 208–230/460 Volts, 60Hz, 3 Phase
	62MHD9DEN	Motor, 0.5hp (0.37Kw), 90 VDC
	32MES423EN	Motor, 0.5hp (0.37Kw), 230 Volts, 3 Phase Inverter Duty
	32MHD9DEN	Motor, 0.75 hp, (0.56Kw), 90 VDC
2	32M005EL	Gear Reducer, 5:1, NEMA 42CZ
	32M010EL	Gear Reducer, 10:1, NEMA 42CZ
	32M020EL	Gear Reducer, 20:1, NEMA 42CZ
	32M040EL	Gear Reducer, 40:1, NEMA 42CZ
	32M060EL	Gear Reducer, 60:1, NEMA 42CZ
	32M005ES	Gear Reducer, 5:1, NEMA 56C
	32M010ES	Gear Reducer, 10:1, NEMA 56C
	32M020ES	Gear Reducer, 20:1, NEMA 56C
	32M040ES	Gear Reducer, 40:1, NEMA 56C
	32M060ES	Gear Reducer, 60:1, NEMA 56C
	32M010EH	Gear Reducer, 10:1, NEMA 140 TC

CE Version



Item	Part No.	Description
1	826-281	Motor, 0.19 kW 230 Volts, 1400 RPM 50 Hz, 1-Phase
	826-282	Motor, 0.37 kW 230 Volts, 1400 RPM 50 Hz, 1-Phase
	826-284	Motor, 0.19 kW 230/400 Volts, 1400 RPM 50 Hz, 3-Phase
	826-285	Motor, 0.37 kW 230/400 Volts, 1400 RPM 50 Hz, 3-Phase
2	62Z005ES	Gear Reducer, 5:1, 63 B5
	62Z010ES	Gear Reducer, 10:1, 63 B5
	62Z020ES	Gear Reducer, 20:1, 63 B5
	62Z040ES	Gear Reducer, 40:1, 63 B5
	62Z060ES	Gear Reducer, 60:1, 63 B5
	32Z005ES	Gear Reducer, 5:1, 71 B5
	32Z010ES	Gear Reducer, 10:1, 71 B5
	32Z020ES	Gear Reducer, 20:1, 71 B5

Heavy Load 90° Industrial Gearmotors



Item	Part No.	Part Description
1	32M008HH	Gear Reducer, 7.5:1 NEMA 140TC
	32M010HH	Gear Reducer, 10:1 NEMA 140TC
	32M015HH	Gear Reducer, 15:1 NEMA 140TC
	32M020HH	Gear Reducer, 20:1 NEMA 140TC
	32M025HH	Gear Reducer, 25:1 NEMA 140TC
	32M030HH	Gear Reducer, 30:1 NEMA 140TC
	32M040HH	Gear Reducer, 40:1 NEMA 140TC
	32M050HH	Gear Reducer, 50:1 NEMA 140TC
	32M060HH	Gear Reducer, 60:1 NEMA 56C
	32M080HH	Gear Reducer, 80:1 NEMA 56C
	32M100HH	Gear Reducer, 100:1 NEMA 56C
2	62MS411FN	Motor, 0.25hp (0.19Kw), 115/230 Volts, 60 Hz, 1-Phase
	62MH411	Motor, 0.5hp (0.37Kw), 115/230 Volts, 60Hz, 1–Phase
	62MH423	Motor, 0.5hp (0.37Kw) 208–230/460 Volts, 60Hz, 3 Phase
	32MHH423FN10	Motor, 1 hp (0.75Kw), 230 Volts, 3 Phase
	32MS423EN	Motor, 0.5hp (0.37Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423EN10	Motor, 1hp (0.75Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423EN15	Motor, 1.5hp (1.1Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423FN15	Motor, 1.5hp (1.1Kw), 230 Volts, 3 Phase
	62MHD9DEN	Motor, 0.5hp (0.37Kw), 90 Volts DC,
	62MHD9DEN75	Motor, 0.75hp (0.56Kw), 90 Volts DC,
	32MHH423EN20	Motor, 2.0hp (1.5Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423FN20	Motor, 2.0hp (1.5Kw), 230 Volts, 3 Phase
	32MHH411EC10	Motor, 1.0hp (0.75Kw), 115 Volts, Integrated Controller
	32MHH411EC15	Motor, 0.5hp (0.37Kw), 115 Volts, Integrated Controller
3	820–329	Bushing Shaft Adapter, 56C to 140TC

Service Parts

Wear Strip

Item	Part No.	Description
1	834-FASR-25U	Standard Low Friction UHMW (sold per foot)
	834-FASR-25A	Special Conductive (sold per foot)
	834-FASR-25X	Special HI Speed (sold per foot)
	834-FASR-25P	Special Abrasive Resistant (sold per foot)

Ordering a Replacement Chain

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

Example:

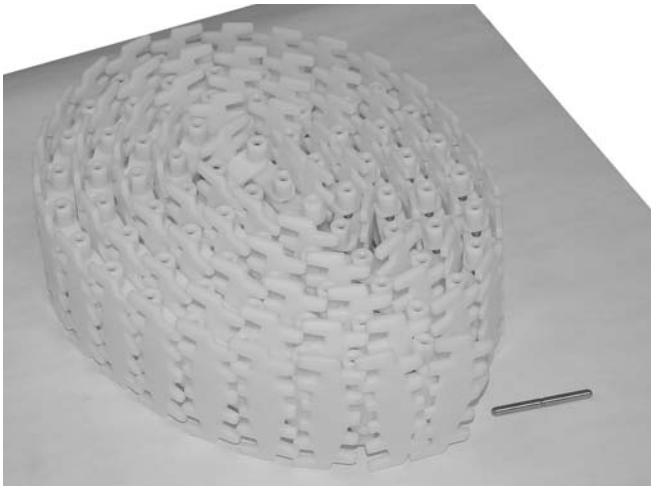
Overall chain length = 42' 5" (round up to 43')

Order Qty (43) of 834-F2PC-5

W = Width (S=065, M=085, C=105, L=150)

CT = Chain type (PC=Low Friction, FT=Friction Insert Chains)

CD = Static Conductive (Leave blank if not applicable)



Item	Part Number	Description
1	834-FW CT-5CD	Chain Repair Kit (Includes 1 ft (305 mm) of chain and assembly pins)
W = Width (S=065, M=085, C=105, L=150)		
CT = Chain type (PC=Low Friction, FT=Friction Insert Chains)		

Belt Removal Tool

Item	Part Number	Description
1	203480	Belt Removal Tool

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 (if available, part serial number).

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization (RMA) number for reference. RMA will automatically close 30 days after being issued. To get credit, items must be new and undamaged. There will be a return charge on all items returned for credit, where Dorner was not at fault. It is the customer's responsibility to prevent damage during return shipping. Damaged or modified items will not be accepted. The customer is responsible for return freight.

<table>
<tr><th></th><th colspan="8">Product Type</th></tr>
<tr><th></th><th colspan="7">Standard Products</th><th>Engineered to order parts</th></tr>
<tr><th>Product Line</th><th>Conveyors</th><th>Gearmotors & Mounting Packages</th><th>Support Stands</th><th>Accessories</th><th>Spare Parts (non-belt)</th><th>Spare Belts - Standard Flat Fabric</th><th>Spare Belts - Cleated & Specialty Fabric</th><th>Spare Belts - Plastic Chain</th><th>All equipment and parts</th></tr>
<tr><td>1100</td><td colspan="6" rowspan="14">30% return fee for all products except:
50% return fee for conveyors with modular belt, cleated belt or specialty belts</td><td colspan="2" rowspan="15">non-returnable</td><td rowspan="15">case-by-case</td></tr>
<tr><td>2200</td></tr>
<tr><td>2200 Modular Belt</td></tr>
<tr><td>2200 Precision Move</td></tr>
<tr><td>2300</td></tr>
<tr><td>2300 Modular Belt</td></tr>
<tr><td>3200</td></tr>
<tr><td>3200 LPZ</td></tr>
<tr><td>3200 Precision Move</td></tr>
<tr><td>4100</td></tr>
<tr><td>5200</td></tr>
<tr><td>5300</td></tr>
<tr><td>6200</td></tr>
<tr><td>Controls</td></tr>
<tr><td>7200 / 7300</td><td colspan="6">50% return fee for all products</td></tr>
<tr><td>7350</td><td colspan="9" rowspan="4">non-returnable</td></tr>
<tr><td>7360</td></tr>
<tr><td>7400</td></tr>
<tr><td>7600</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 factory, distributor, service center or visit our website at www.dorner.com.

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

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