AquaPruf®
Positive Drive Conveyors

Installation, Maintenance and Parts Manual

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

Record Conveyor Serial Number Here

851-946 Rev. A

Table of Contents

⚠ CAUTION

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

Upon receipt of shipment:

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

The Dorner Limited Warranty applies.

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

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

Warnings – General Safety

⚠ WARNING

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

⚠ DANGER

SEVERE HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

BURN HAZARD!

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

⚠ WARNING

PUNCTURE HAZARD!

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

⚠ DANGER

EXPLOSION HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

- **Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.**
- **When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, CHECK FOR POTENTIAL PINCH POINTS and other mechanical hazards before system start-up.**
- **Failure to comply could result in serious injury.**

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

1	Conveyor
2	Guides (If Equipped)
3	Belt
4	Support Stands
5	Drive End
6	Idler End
7	Controller
8	Gearmotor

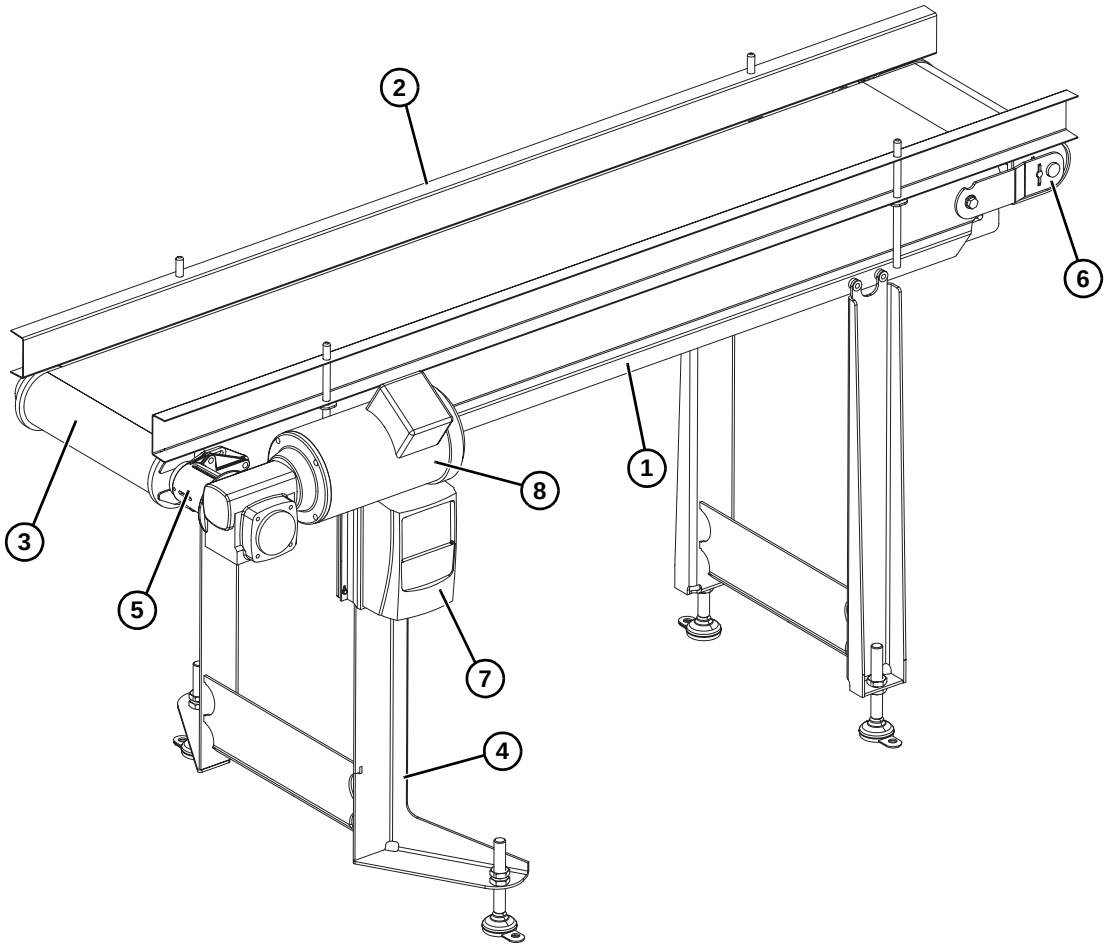
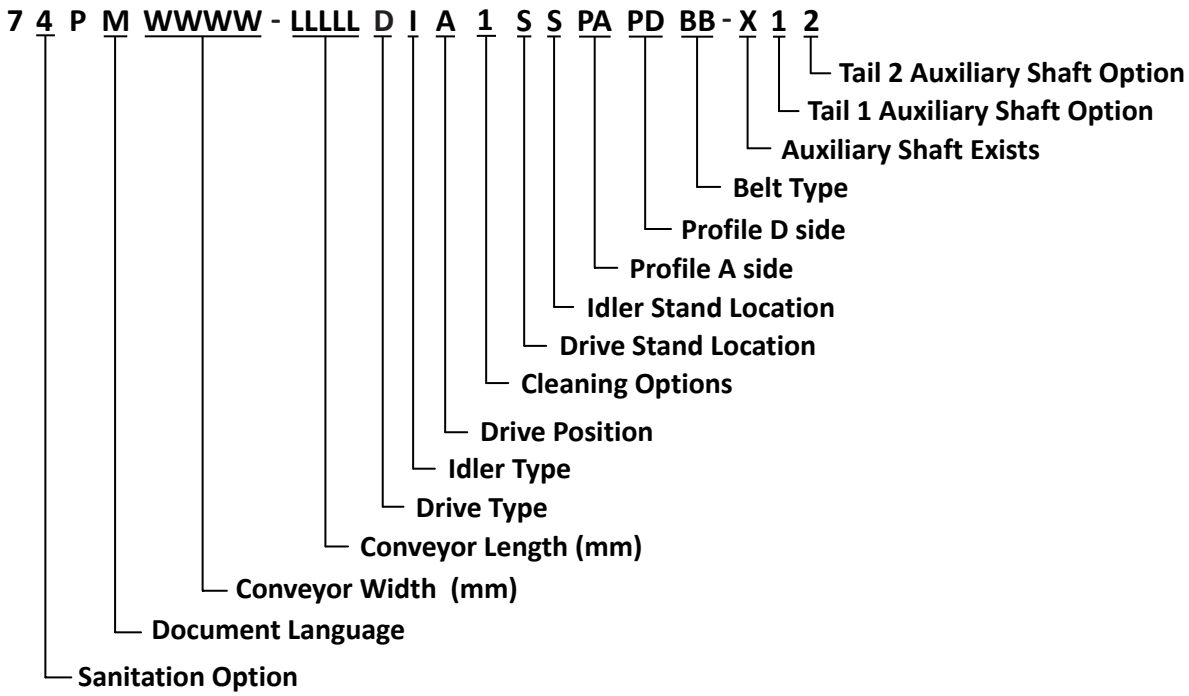


Figure 1

Specifications

Positive Drive Conveyors



Conveyor Supports

Maximum Distances:

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

2 = Between Support Stands = 2997 mm (118")**

3 = Support Stand on Idler End = 762 mm (30")

** For conveyors longer than 3048 mm (10 ft), install stand mount kit at frame joint.

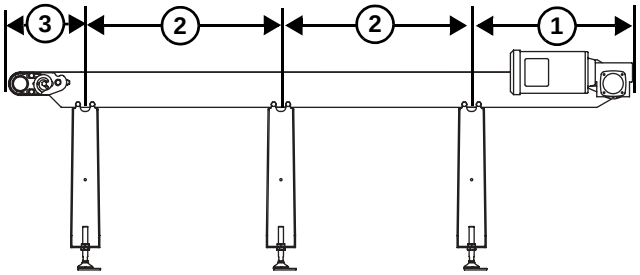


Figure 2

Specifications

Conveyor Width Reference (WWWW)	0152, 0203, 0254, 0305, 0356, 0406, 0457, 0508, 0559, 0610, 0660, 0711, 0762, 0813, 0864, 0914, 0965, 1016, 1067, 1118, 1168, 1219
Conveyor Belt Width	152 mm (6") 203 mm (8"), 254 mm (10"), 305 mm (12"), 356 mm (14"), 406 mm (16"), 457 mm (18"), 508 mm (20"), 559 mm (22"), 610 mm (24"), 660 mm (26"), 711 mm (28"), 762 mm (30"), 813 mm (32"), 864 mm (34"), 914 mm (36"), 965 (38"), 1016 (40"), 1067 (42"), 1118 (44"), 1168 (46"), 1219 (48")
Maximum Conveyor Load (See NOTE Below)	97 kg/ m^2 (20 lbs. / ft^2) with a maximum of 227 kg (500 lbs.)
Belt Travel	305 mm (12") per revolution of pulley
Maximum Belt Speed	91 m/minute (300 ft/minute)
Conveyor Length Reference (LLLLL)	00915 - 12190 in 00005 increments
Conveyor Length	915 mm (36") - 12190 mm (480") in 5 mm (.20") increments

NOTE

Maximum conveyor loads are based on:

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

Torque Specifications

	Flat Head		Socket Head		Button/Low Head		Set Screw	
	Size	**Torque**	**Size**	**Torque**	**Size**	**Torque**	**Size**	**Torque**
M4 x 0.7	2.5 mm	3.4 Nm (30 in lbs)	3 mm	5.9 Nm (52 in lbs)	2.5 mm	2.9 Nm (26 in lbs)	2 mm	2.1 Nm (19 in lbs)
M5 x 0.8	3 mm	6.9 Nm (61 in lbs)	4 mm	12.0 Nm (106 in lbs)	3 mm	5.9 Nm (52 in lbs)	2.5 mm	4.7 Nm (42 in lbs)
M6 x 1.0	4 mm	12.0 Nm (106 in lbs)	5 mm	20.3 Nm (180 in lbs)	4 mm	10.0 Nm (89 in lbs)	3 mm	7.7 Nm (68 in lbs)
M8 x 1.25	5 mm	28.0 Nm (248 in lbs)	6 mm	48.8 Nm (432 in lbs)	5 mm	24.0 Nm (212 in lbs)	4 mm	17.8 Nm (158 in lbs)
M10 x 1.5	6 mm	56.0 Nm (496 in lbs)	8 mm	97.5 Nm (863 in lbs)	6 mm	48.0 Nm (425 in lbs)	5 mm	35.0 Nm (310 in lbs)

Installation

⚠ CAUTION

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

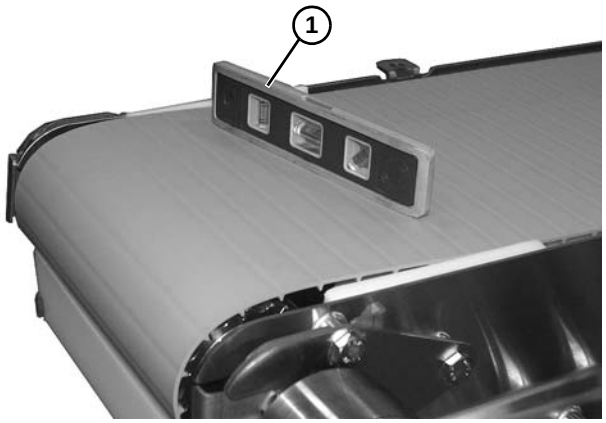


Figure 3

Required Tools

- Level
- 6 mm hex wrench
- 8 mm hex wrench
- 10 mm wrench
- 13 mm wrench

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to "Conveyors Longer than 3048 mm (10 ft)" on page 8.
2. Attach the stands. Refer to "Stand Installation" on page 9.
3. Install the belt. Refer to "Belt Installation" on page 9.
4. Install belt returns. Refer to "Belt Returns" on page 11.
5. Install the gearmotor. Refer to "Drive Package Installation" on page 13.

NOTE

For 3-A compliance, a conveyor cover or shield must be installed over the conveyor that is easily cleaned, self-draining, and located to prevent liquid or other contaminants from draining or dropping into the container or product, or onto the conveyor belt. Multiple covers can be used if necessary, with overlapping edges. Cover(s) should be fabricated from stainless steel or FDA certified plastic material, and the bottom of the cover(s) must be smooth, with no crevices or exposed threads.

Conveyors Longer than 3048 mm (10 ft)

Connecting Components

Typical connecting components **(Figure 4)**.

1	Connector (x2)
2	Hex Head Cap Screw (x4)
3	Conveyor Frames

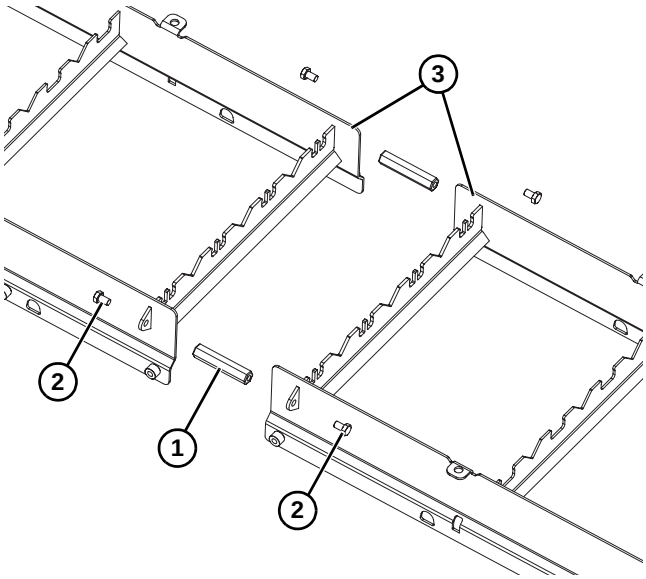


Figure 4

1. Locate and arrange conveyor sections by section labels **(Figure 5, item 1)**.

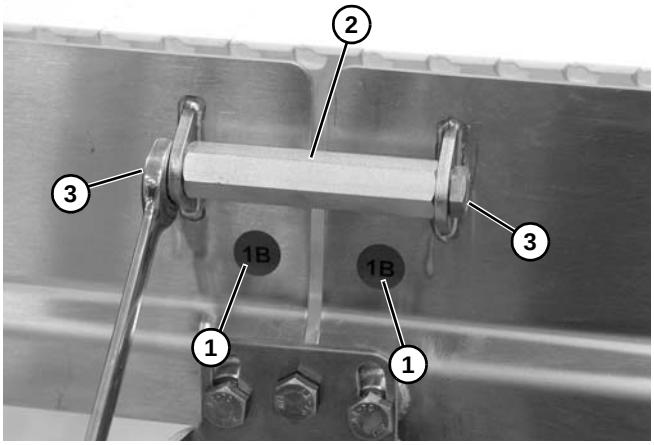


Figure 5

2. Join both conveyor sections and install connector **(Figure 5, item 2)** with two screws **(Figure 5, item 3)**. Repeat on opposite side. Tighten screws to 28-32 Nm (20-24 ft-lbs).

Stand Installation

NOTE

For detailed assembly instructions, please see support stand manual 851-948.

Typical stand components **(Figure 6)**.

1	Conveyor Frame
2	Stand
3	Screw (x4)

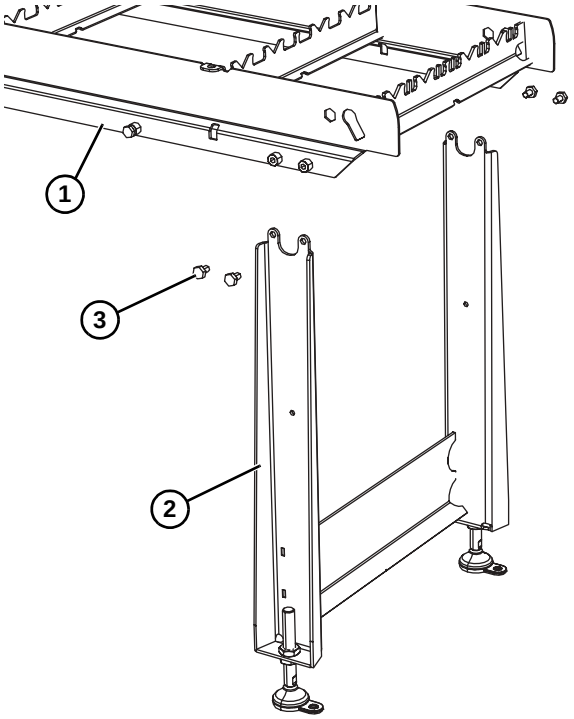


Figure 6

1. Position the stands on a flat, level surface.
2. Attach the stands **(Figure 7, item 1)** to the frame. Tighten screws to 28-32 Nm (20-24 ft-lbs).

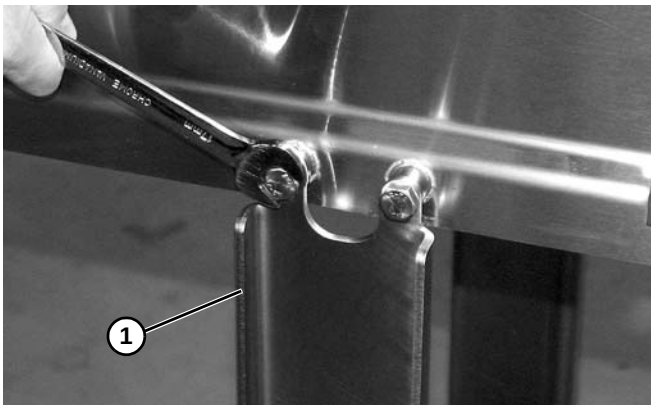


Figure 7

Belt Installation

⚠ WARNING

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

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.

1. Place temporary support stands **(Figure 8, item 1)** at both ends of the conveyor. Place an additional support stand under the drive motor, if equipped. See WARNING.

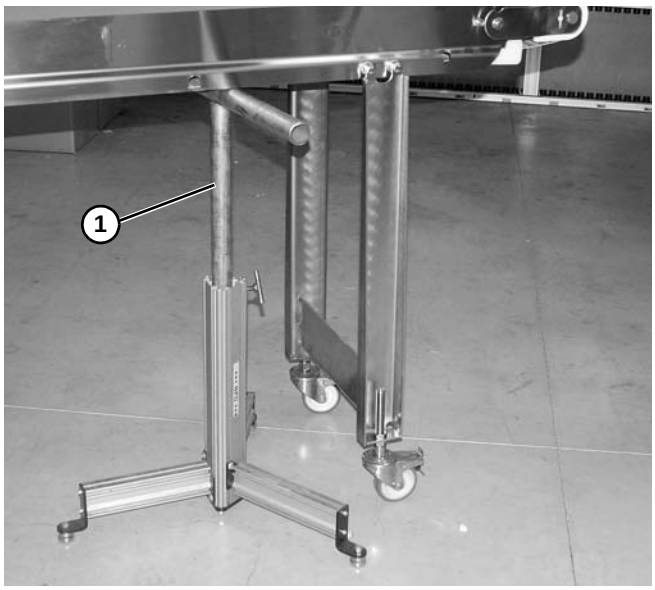


Figure 8

2. Remove two screws **(Figure 9, item 1)** securing the stand brackets from one side of the conveyor.

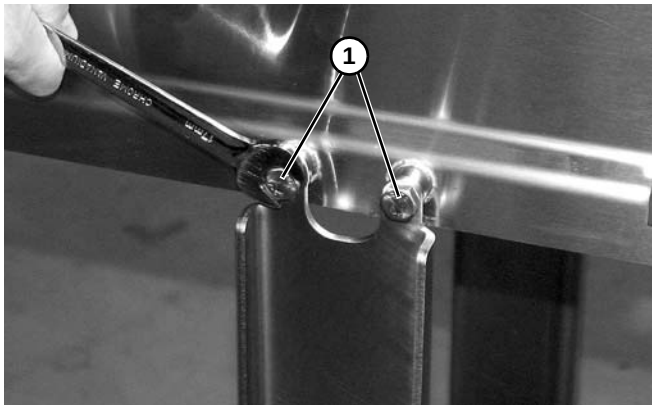


Figure 9

3. Rotate tip-up idler tail **(Figure 10, item 1)** upward as shown.

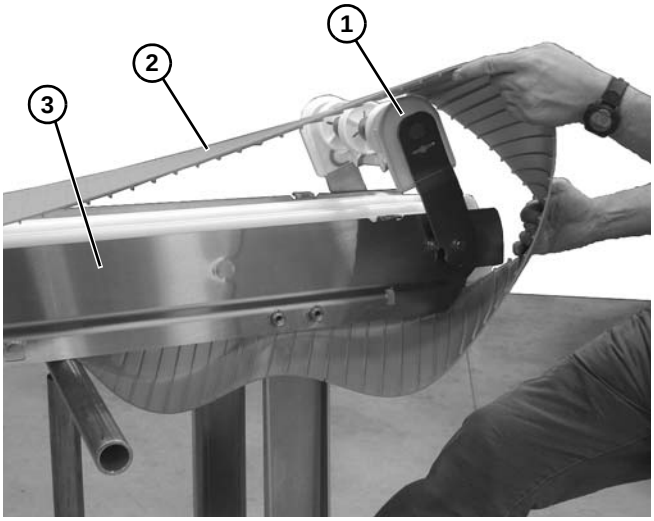


Figure 10

4. Position the belt **(Figure 10, item 2)** onto the conveyor **(Figure 10, item 3)**.
5. Repeat procedure for the opposite end of the conveyor to fully install the belt.
6. Install stand brackets to conveyor with fasteners.
7. Lower tip-up idler tail.
8. Tension conveyor belt, if required. If tensioning belt is necessary, refer to “Conveyor Belt Tracking” on page 19.
9. Track conveyor belt, if required. If belt tracking is necessary, refer to “Conveyor Belt Tracking” on page 19.

Limiter

Typical limiter components **(Figure 11)**.

1	Limiter Bar
2	Bracket (2x)
3	Screw (4x)

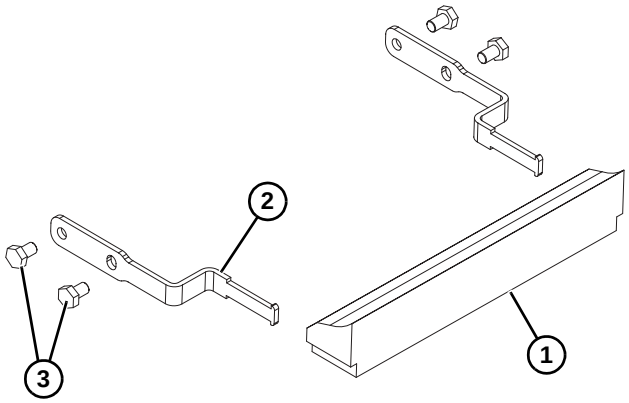


Figure 11

1. Attach one bracket **(Figure 12, item 1)** to each side of the conveyor loosely with two screws **(Figure 12, item 2)**.

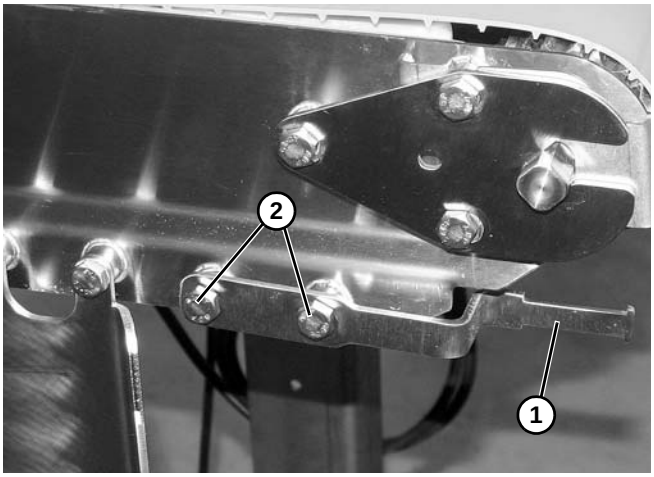


Figure 12

2. Insert limiter bar **(Figure 13, item 1)**.

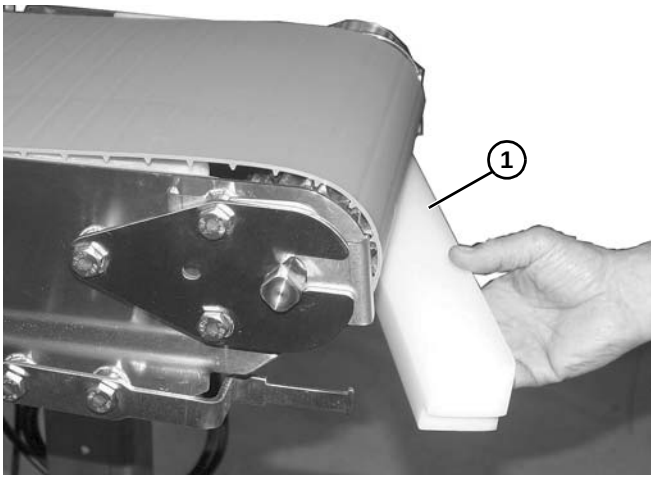


Figure 13

3. Adjust bracket to engage curved end of limiter toward belt, leaving a small gap as shown. Tighten screws **(Figure 14, item 1)**.

Figure 14

Belt Returns

Belt Returns 660 mm Wide and Wider

Typical belt return components (660 mm wide and wider) **(Figure 15)**.

1	Shaft
2	Retaining Plate
3	Puck

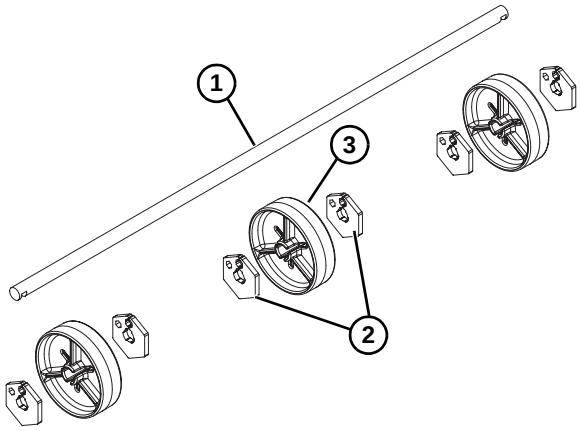


Figure 15

1. Install pucks with retainer plates on both sides.
   a. Insert an 8 mm **(Figure 16, item 1)** and 6 mm **(Figure 16, item 2)** hex wrench into the retainer plate.

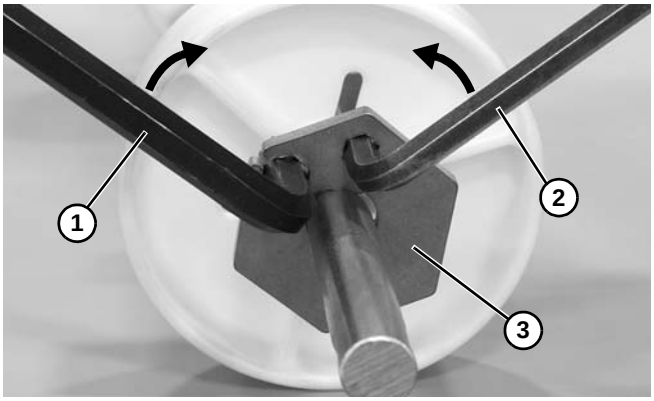


Figure 16

   b. Move wrenches toward each other to open the retainer plate **(Figure 16, item 3)** and install onto the shaft. Position retainer plate where needed.
   c. To lock the retainer plate **(Figure 17, item 1)** in place, move the wrenches **(Figure 17, item 2)** away from each other.

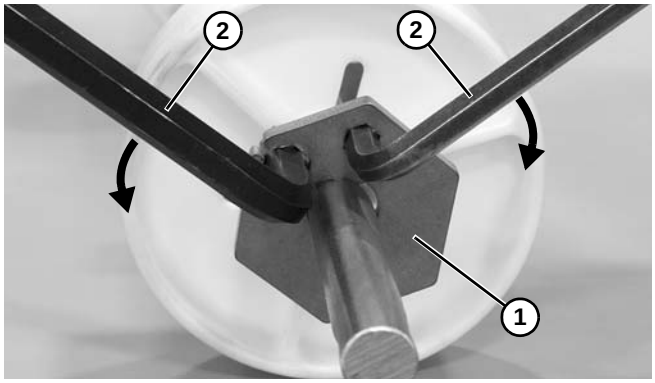


Figure 17

2. Repeat step 1 as needed.

NOTE

*When assembling pucks **(Figure 18, item 1)** with retainer plates **(Figure 18, item 2)**, make certain that there is a minimum of 38 mm (1.5") of clearance **(Figure 18, item 3)** on each end.*

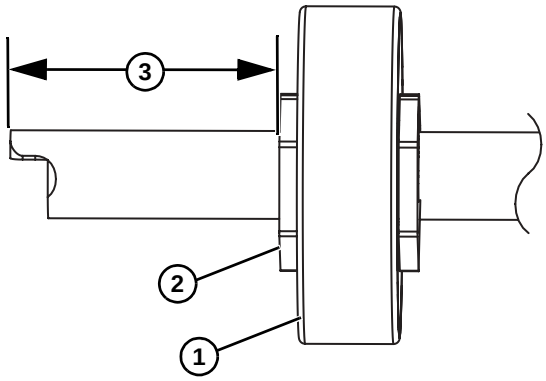


Figure 18

3. Install belt return assembly **(Figure 19, item 1)** onto the slotted holes **(Figure 19, item 2)** on each side of conveyor frame.

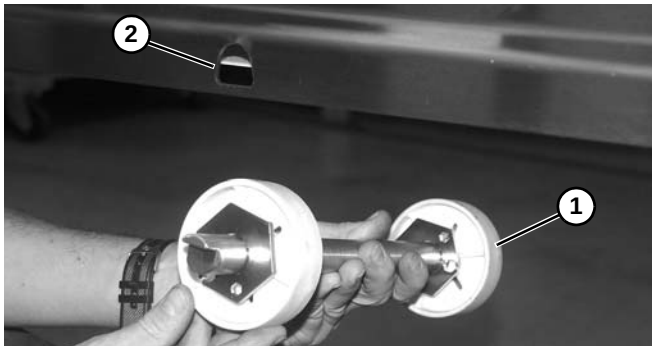


Figure 19

Installation

Belt Returns Under 660 mm Wide

Typical belt return components (under 660 mm wide) **(Figure 20)**.

1	Spacer
2	Puck
3	Stub Shaft
4	O-Ring

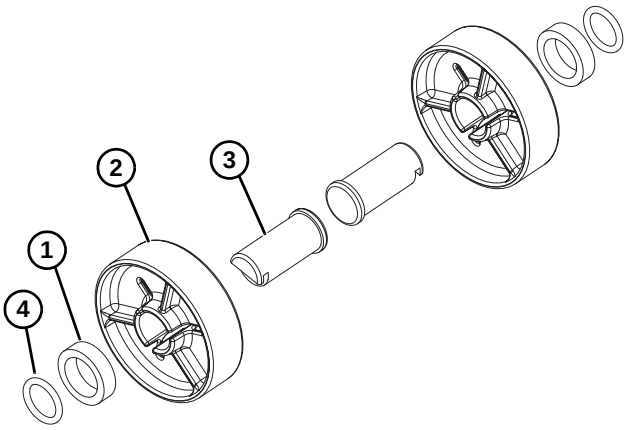


Figure 20

1. Insert the notched end of the return shaft **(Figure 21, item 1)** through the small hole **(Figure 21, item 2)** in the inside of the conveyor frame.

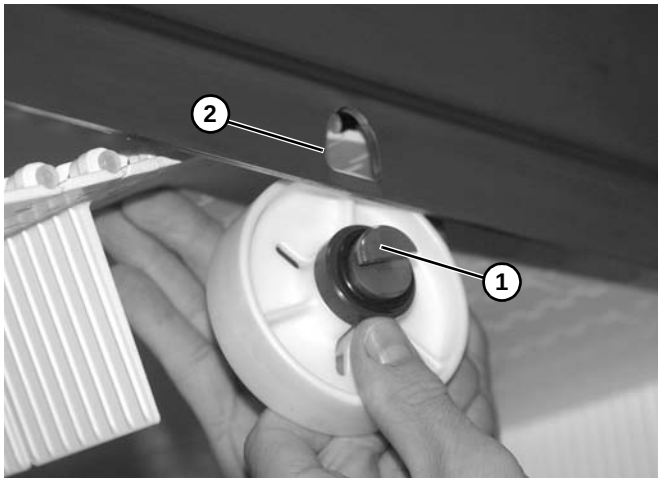


Figure 21

2. Repeat the procedure for all other belt returns.

Guide Installation

Fixed Guides

1. Install guide post **(Figure 22, item 1)** through conveyor side frame tab **(Figure 22, item 2)**, making sure slotted portion **(Figure 22, item 3)** of post is fully seated into the bottom **(Figure 22, item 4)** of frame. Tap to lock in place.

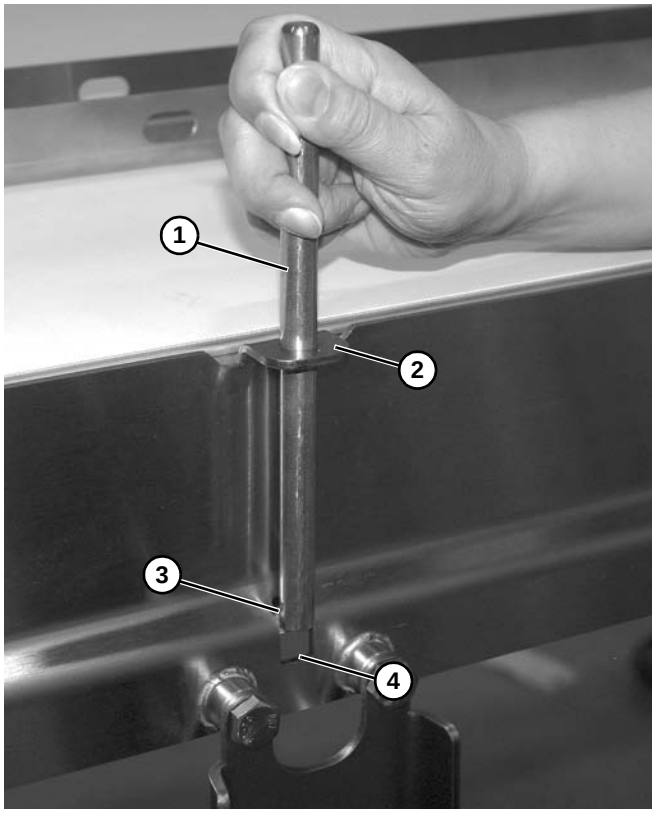


Figure 22

2. Repeat for remaining guide posts required for your conveyor size.
3. Install guide **(Figure 23, item 1)** onto the guide posts **(Figure 23, item 2)**.

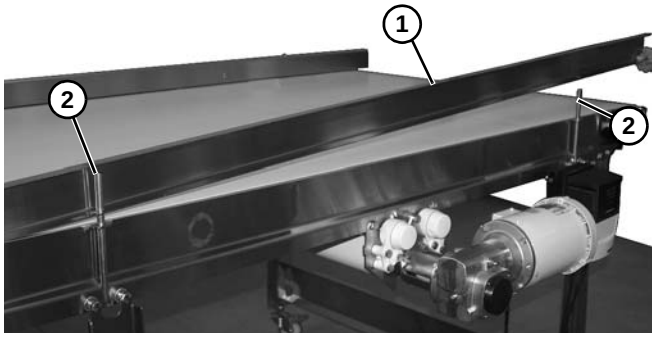


Figure 23

NOTE

*For UHMW guides, install guides with horizontal side **(Figure 24, item 1)** down.*

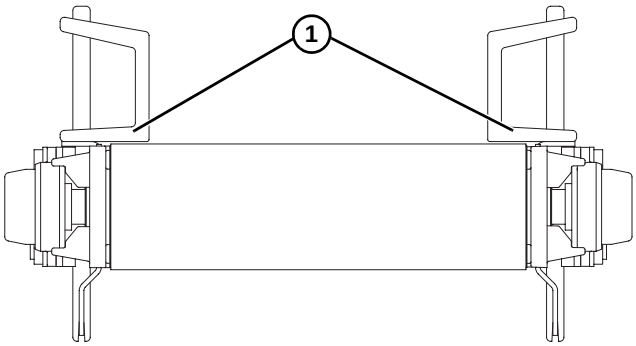


Figure 24

NOTE

*To remove guide posts, tap from underneath with a hammer to release from conveyor frame **(Figure 25)**.*

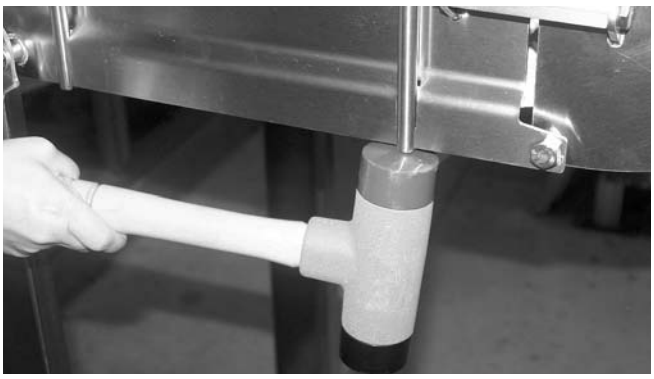


Figure 25

4. Repeat on the opposite side of conveyor.

Adjustable Guides

1. Install guide rail **(Figure 26, item 1)** onto brackets **(Figure 26, item 2)**. Tighten screw **(Figure 26, item 3)** to secure.

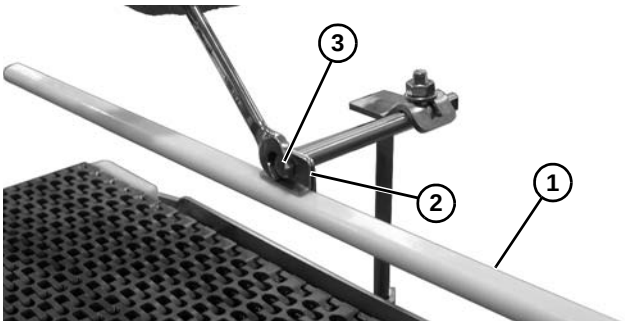


Figure 26

2. Loosen nut **(Figure 27, item 1)**, and adjust the guide post **(Figure 27, item 2)** height, as needed. Tighten nut.

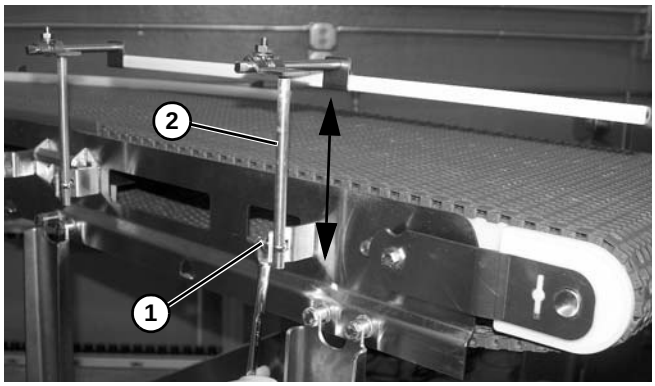


Figure 27

3. Loosen nut **(Figure 28, item 1)**, and adjust the horizontal guide post **(Figure 28, item 2)** and guide rail, as needed. Tighten nut.

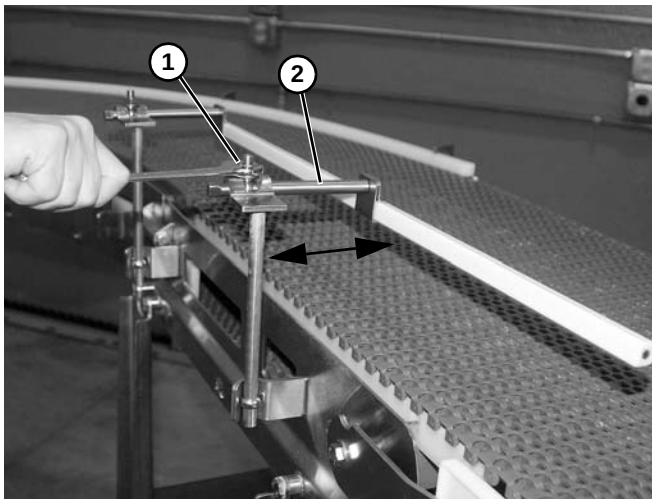


Figure 28

4. Repeat, as needed for remaining guiding brackets.

Drive Package Installation

NOTE

For detailed assembly instructions, please see drive packages manual 851-947.

Preventive Maintenance and Adjustment

Required Tools

- 1/8" hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 10 mm wrench
- 13 mm wrench
- 17 mm wrench
- Flat blade screwdriver
- Breaker bar

Checklist

- Keep critical service parts on hand. Refer to the "Service Parts" section starting on page 28 for recommendations.
- Replace any worn or damaged parts.

Cleaning

For detailed cleaning instructions, refer to the 851-950 AquaPruf Cleaning manual.

NOTE

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

⚠ CAUTION

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

⚠ WARNING

SEVERE HAZARD!

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

Lubrication

Conveyor Bearings

Conveyor bearing lubrication is required. Dorner recommends using an H-1 food grade grease.

NOTE

Although bearings are sealed, re-greasing is recommended to increase bearing life. An H-1 food grade grease is recommended. The frequency of bearing re-greasing is dependent upon the application in which the conveyor is being used. Frequency of re-greasing will increase with the frequency of conveyor washing.

1. Add grease to the bearing using the zerk fitting **(Figure 29, item 1)** on the exterior of the bearing housing.

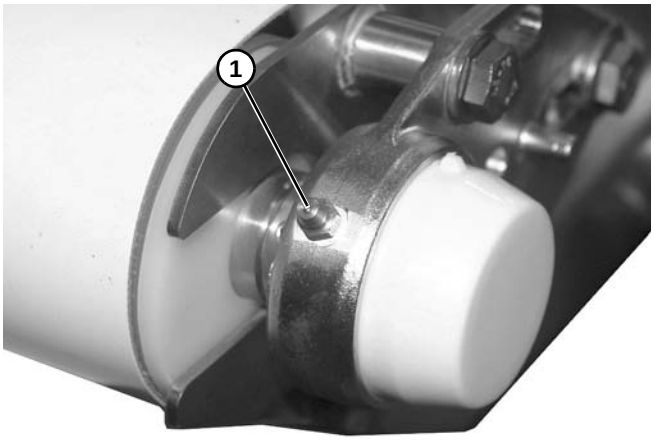


Figure 29

2. Replace the bearings if they become worn.

Maintaining the Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear

Damage to the belt, surface cuts and/or wear indicates:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories
- Excessive load on belt
- Dirt impacted on spindle
- Excessive or improper side loading
- Improper tracking

Skipping indicates:

- Excessive load on belt
- Worn spindle or impacted dirt on drive spindle
- Improper tracking
- Worn limiter

Limiter Replacement

1. Loosen two screws **(Figure 30, item 1)** on bracket **(Figure 30, item 2)** to be able lower bracket slightly for removing limiter bar **(Figure 30, item 3)**.

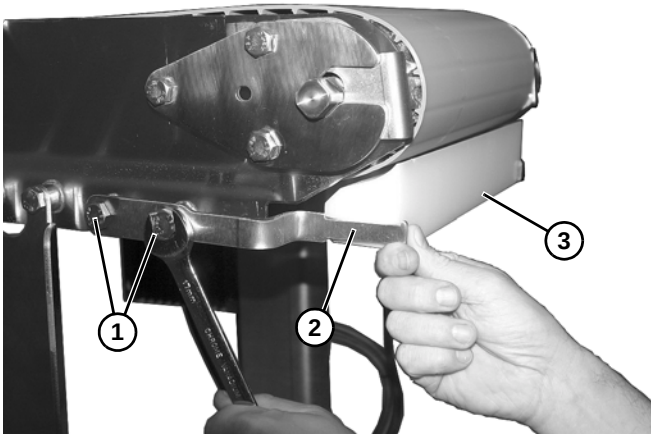


Figure 30

2. Remove limiter bar **(Figure 31, item 1)**.

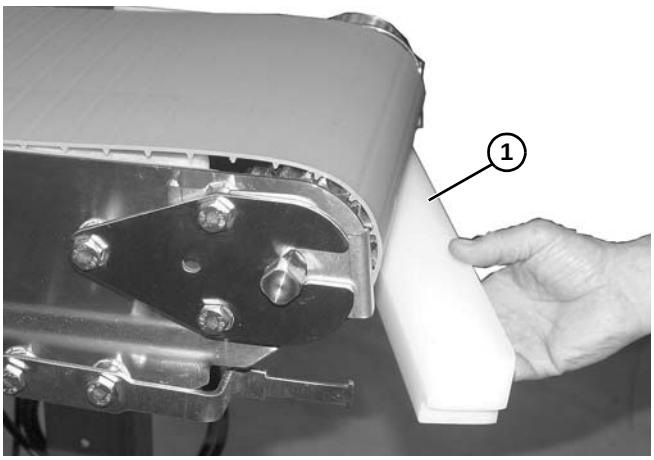


Figure 31

3. Adjust bracket to engage curved end of limiter toward belt, leaving a small gap **(Figure 32, item 1)** as shown. Tighten screws **(Figure 32, item 2)**.

Figure 32

Conveyor Belt Replacement

⚠ WARNING

SEVERE HAZARD!

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

1. Remove guides **(Figure 33, item 1)** when required.

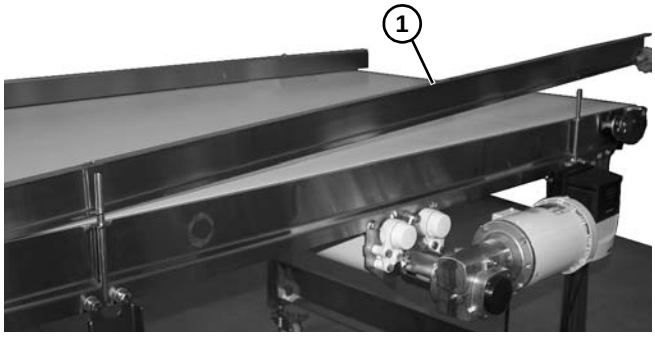


Figure 33

2. Remove belt returns:
   a. For returns 660 mm wide and wider, refer to “Belt Returns 660 mm Wide and Wider” on page 26. Follow step 1.
   b. For returns under 660 mm wide, refer to “Belt Returns Under 660 mm Wide” on page 27. Follow step 1.

⚠ WARNING

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

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.

3. Place temporary support stands **(Figure 34, item 1)** at both ends of the conveyor. Place an additional support stand under the drive motor, if equipped. See WARNING.

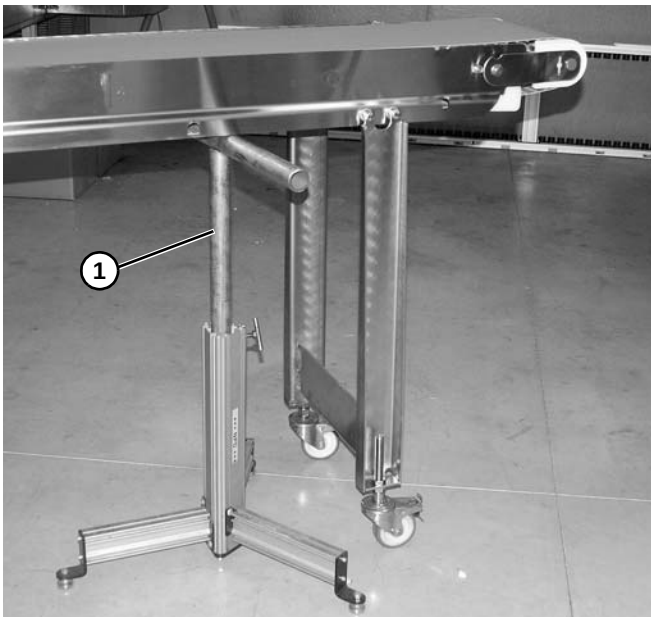


Figure 34

4. Rotate tip-up idler tail **(Figure 35, item 1)** upward as shown.

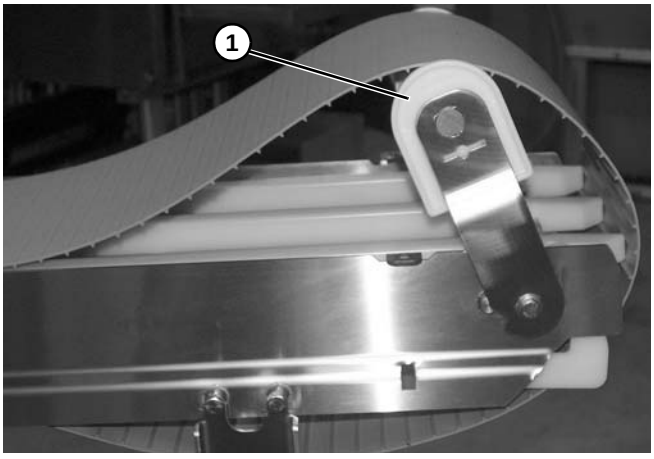


Figure 35

5. Remove two screws **(Figure 36, item 1)** securing the stand brackets from one side of the conveyor.

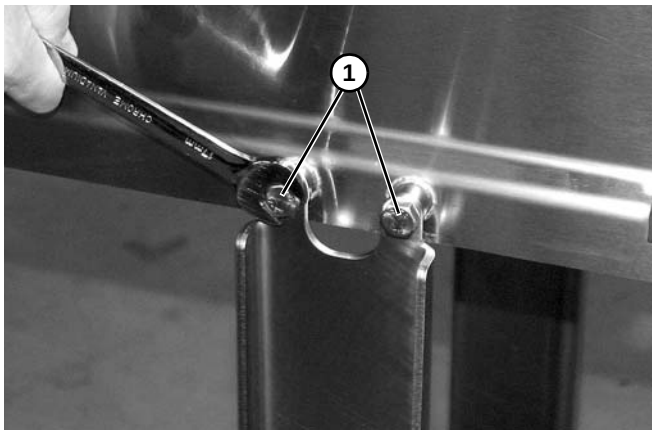


Figure 36

6. Remove the belt **(Figure 37, item 1)** from the conveyor **(Figure 37, item 2)**.

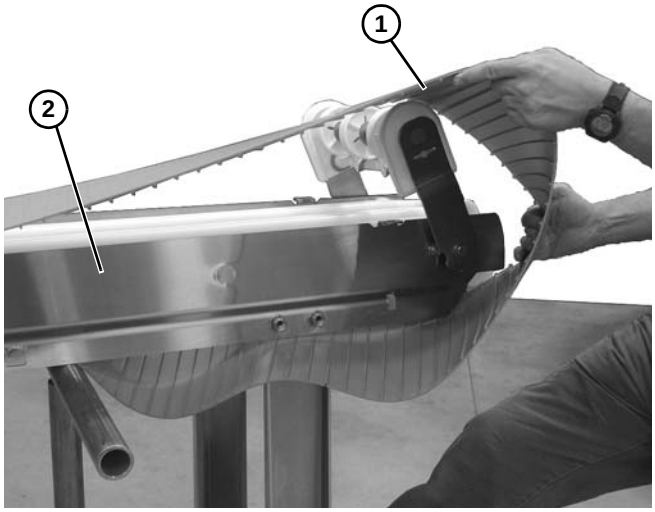


Figure 37

7. Repeat procedure for the opposite end of the conveyor to fully remove the belt.
8. Replace the belt. Refer to “Belt Installation” on page 9.

Wear Strips, Guard Pucks, and Belt Guides

Replace the wear strips, guard pucks, and belt guides if they become worn.

Typical standard wear strips, guard pucks, and belt guides **(Figure 38)**.

1	Wear Strips
2	Guard Pucks, Drive Tail
3	Belt Guides, Drive Tail (Motorized Pulley)
4	Return Guides, Idler Tail

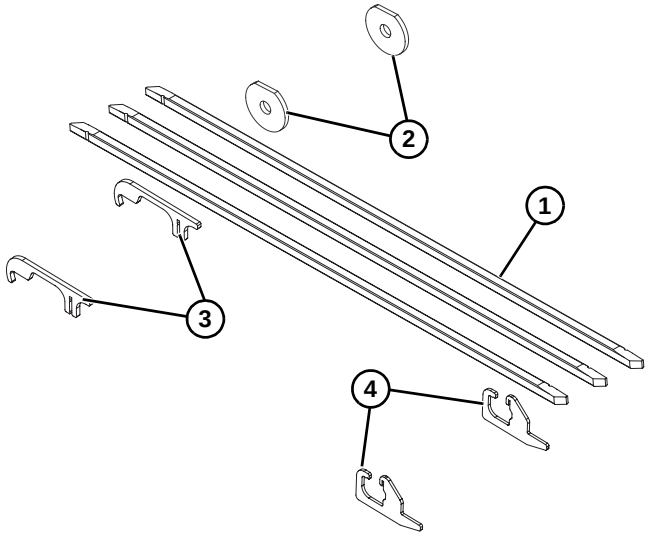


Figure 38

Wear Strip Replacement

1. Remove conveyor belt. Refer to "Conveyor Belt Replacement" on page 15.
2. Remove worn wear strips **(Figure 39, item 1)** from the frame notches **(Figure 39, item 2)**.

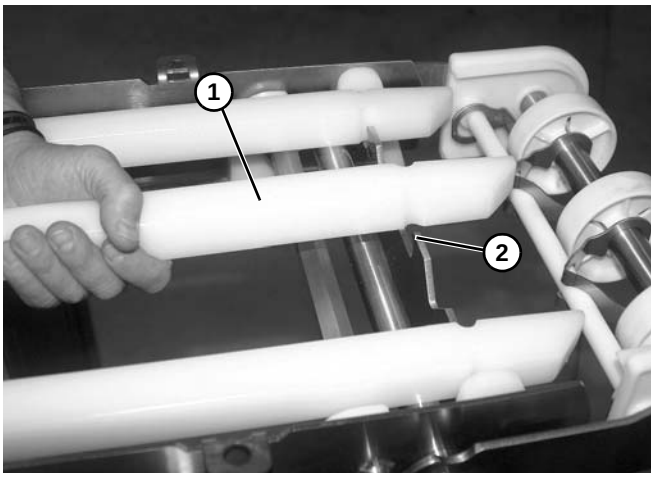


Figure 39

3. Attach new wear strips by installing the slotted area **(Figure 40, item 1)** on wear strip over the tab **(Figure 40, item 2)** on the crossmember.

NOTE
Angled end of the wear strip must face up.

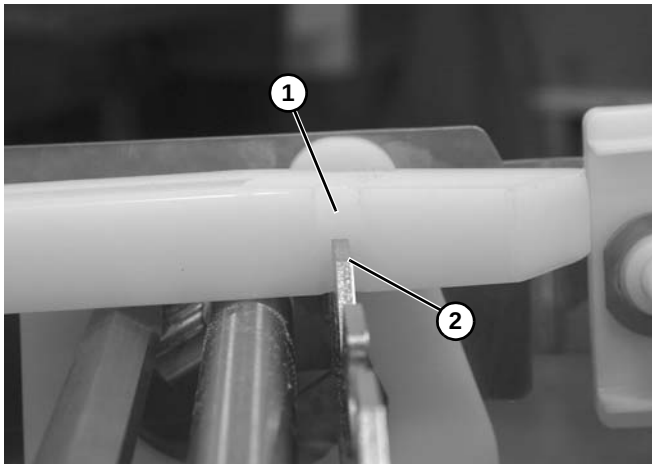


Figure 40

Drive Tail Guard Puck Replacement

1. Remove drive end of conveyor. (See "Drive Replacement" on page 20.)
2. Replace guard pucks **(Figure 41, item 1)**, as needed.

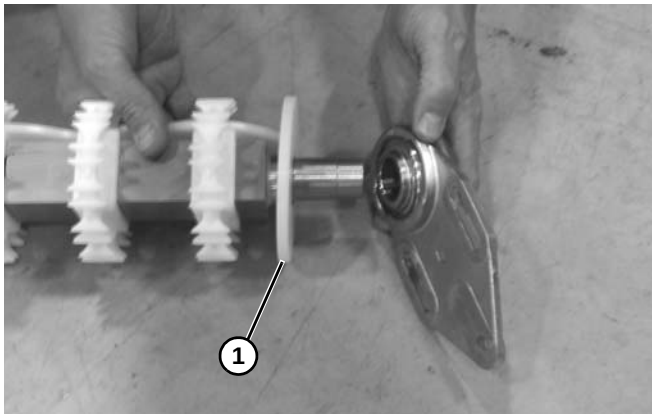


Figure 41

3. Install parts in reverse order of removal.

Motorized Drive Tail Belt Guide Replacement

1. Remove the drive tail belt guides **(Figure 42, item 1)** from the frame rail. Repeat on opposite side.

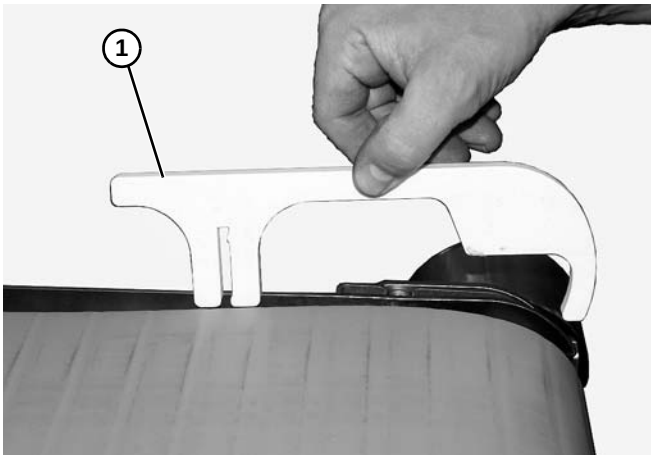


Figure 42

2. Replace with new belt guides, as needed.

Idler Tail Return Guide Replacement

NOTE

*Before removing, make note of the orientation of idler tail return guides as they are shown in the installed position **(Figure 43)**.*

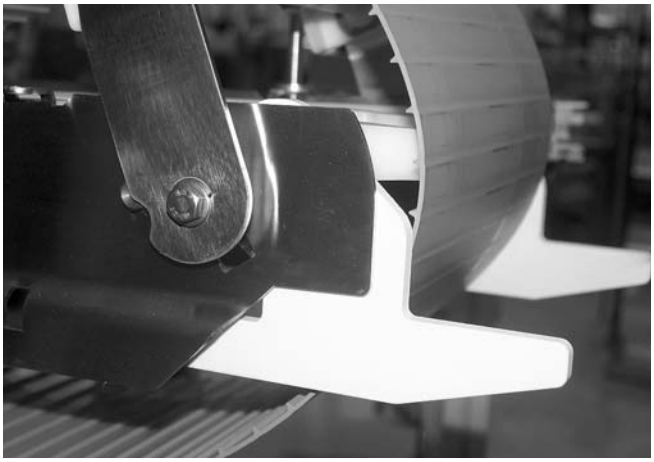


Figure 43

1. Rotate idler tail **(Figure 44, item 1)** upward, as shown. Remove the idler end return guide **(Figure 44, item 2)** from the frame rail. Repeat on opposite side.

Figure 44

2. Replace with new belt guide. Install and rotate return guide **(Figure 45, item 1)**, installing so that handle end **(Figure 45, item 2)** is rotated toward the top when installed.

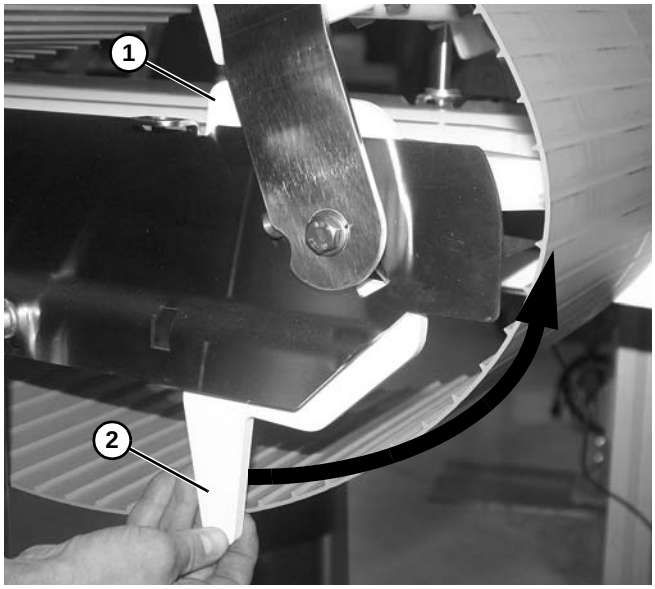


Figure 45

3. Push down to fully seat return guide **(Figure 46, item 1)** so slotted end **(Figure 46, item 2)** is fully seated onto conveyor frame rail **(Figure 47)**.

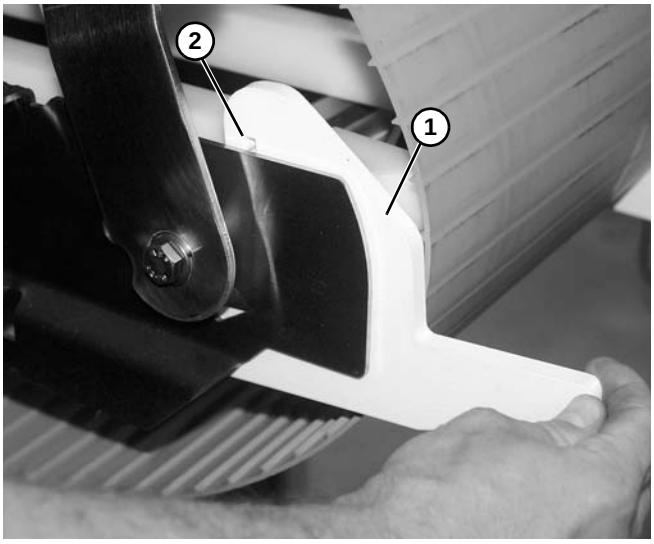


Figure 46

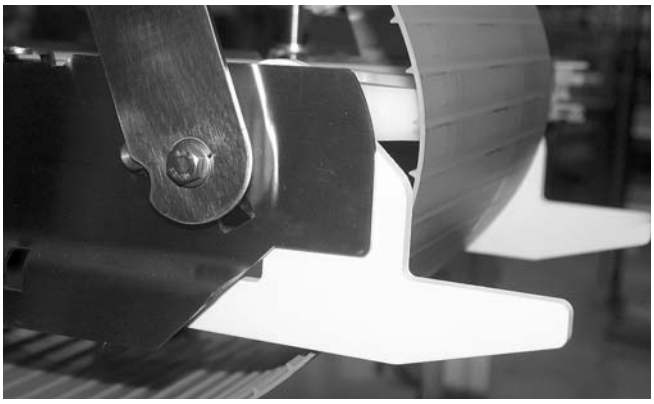


Figure 47

Conveyor Belt Tracking

⚠ WARNING

SEVERE HAZARD!

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

Tracking should be done on the exit end of the conveyor. Two different tracking procedures are listed below:

- Drive End with Standard Gearmotor
- Drive End with Motorized Pulley

Drive End with Standard Gearmotor

1. To adjust tracking, loosen three screws **(Figure 48, item 1)** on each side of conveyor.

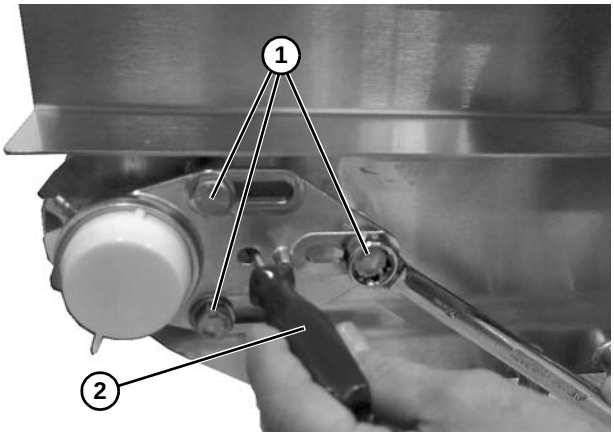


Figure 48

2. Tension each end with a bar **(Figure 48, item 2)**, as needed for tracking. While applying tension, tighten three screws **(Figure 48, item 1)**.

Drive End with Motorized Pulley

1. To adjust tracking, loosen three screws **(Figure 49, item 1)** on each side of conveyor.

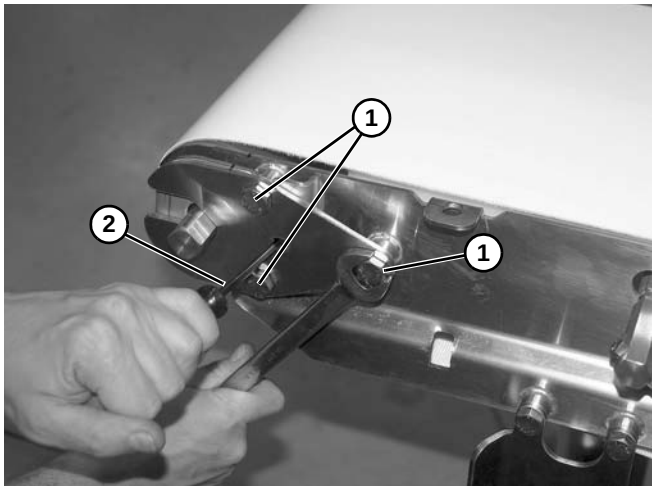


Figure 49

2. Tension each end with a bar **(Figure 49, item 2)**, as needed for tracking. While applying tension, tighten three screws **(Figure 49, item 1)**.

Tail Height Adjustment

⚠ WARNING

SEVERE HAZARD!

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

1. To adjust tail height: rotate idler tail

- Rotate idler end so that hex bar **(Figure 50, item 1)** fits into notched area **(Figure 50, item 2)**.
- Adjust dimpled side **(Figure 50, item 3)** of hex bar into one of four locations **(Figure 50, item 4)** (labeled 1-4 on conveyor).

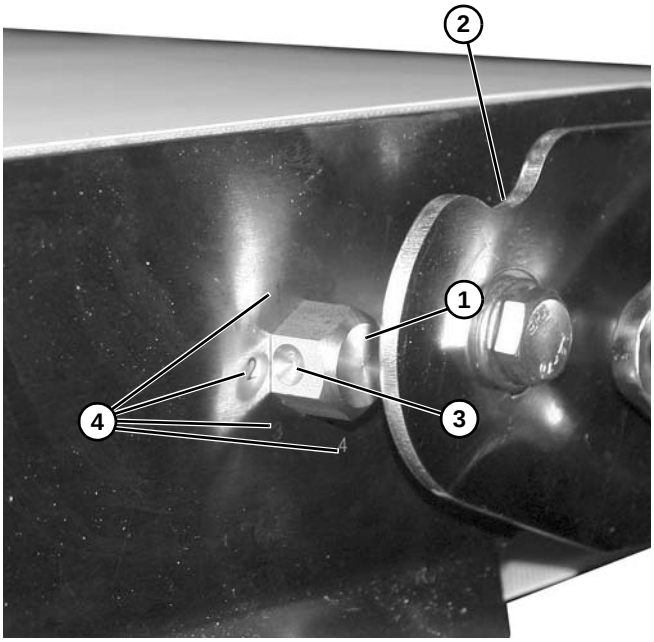


Figure 50

NOTE

Each rotation of hex bar is approximately 2.5 mm (0.10") of elevation change of tail.

*The elevation of change of tail is as follows **(Figure 50)**:*

- *Dimple at position labeled 4 = TAIL AT HIGHEST*
- *Dimple at position labeled 1 = TAIL AT LOWEST*

2. Rotate idler tail **(Figure 51, item 1)** up as shown. Pull out and rotate dimpled end of hex bar **(Figure 51, item 2)** into one of four locations **(Figure 51, item 3)** marked on the side of conveyor frame.

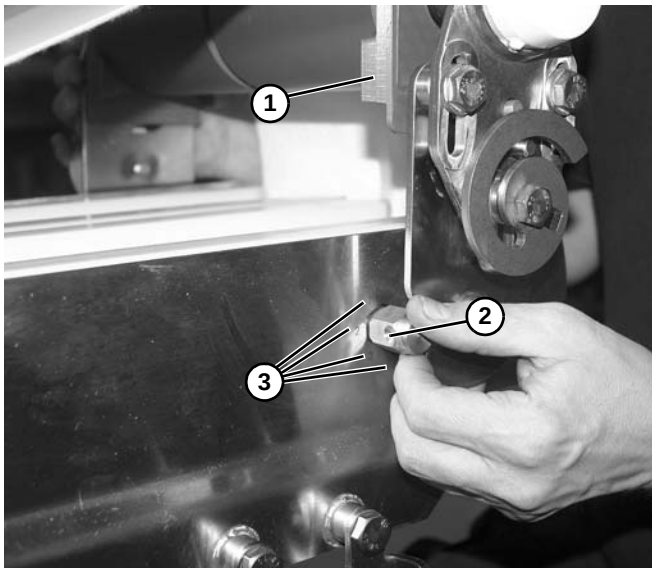


Figure 51

3. Lower idler end and verify proper adjustment.

Drive Replacement

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

PUNCTURE HAZARD!

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

Standard Drive Tail

1. Loosen the four screws **(Figure 52, item 1)**. Rotate and remove the gearmotor. (For further detailed instructions, refer to drive package manual 851-947.)

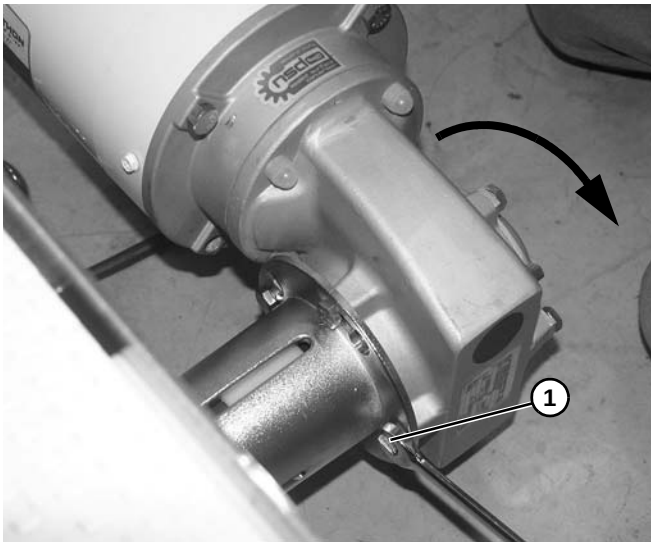


Figure 52

2. Remove limiter. Refer to "Limiter Replacement" on page 15.
3. Remove conveyor belt. Refer to "Conveyor Belt Replacement" on page 15.
4. Remove the headplate screws **(Figure 53, item 1)** on both sides of the conveyor.

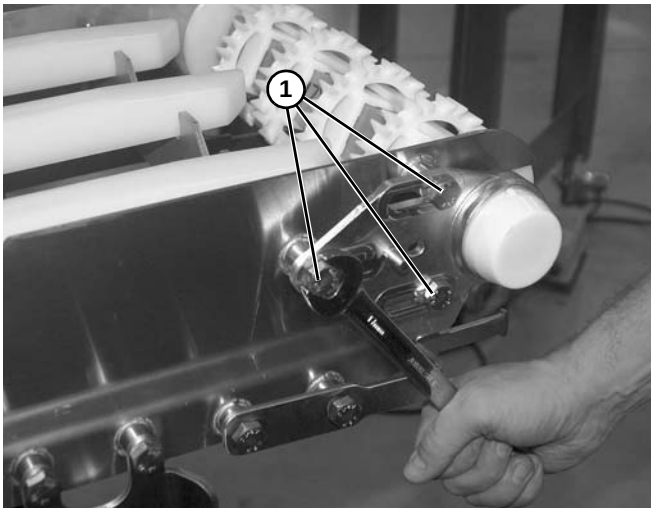


Figure 53

5. Remove drive tail assembly **(Figure 54, item 1)**.

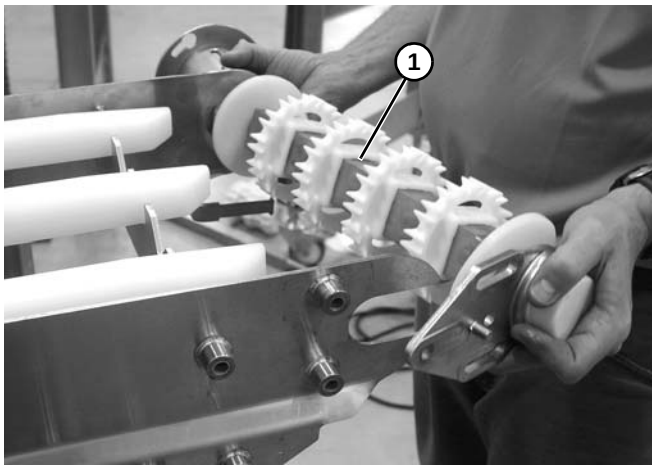


Figure 54

6. Remove bearing cover **(Figure 55, item 1)**.

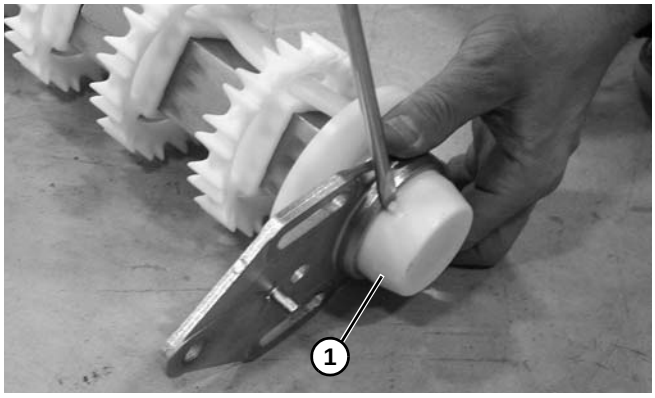


Figure 55

7. Loosen two set screws **(Figure 56, item 1)**.

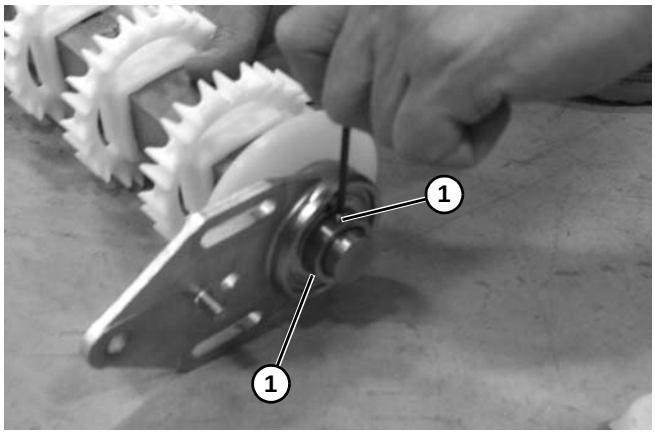


Figure 56

8. Slide the headplate with bearing **(Figure 57, item 1)** off the shaft. Replace bearing if worn. Refer to "Bearing Replacement" on page 25.

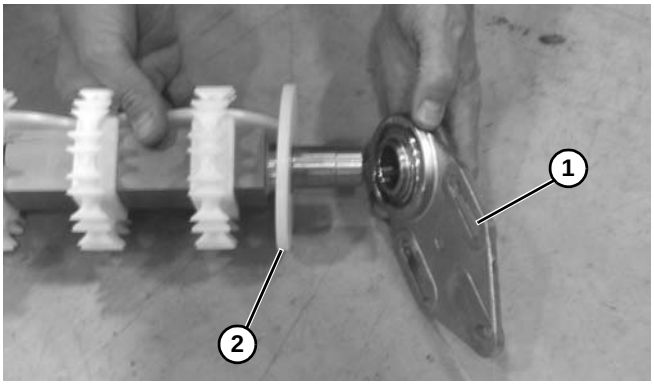


Figure 57

9. Remove guard puck **(Figure 57, item 2)** from end of drive spindle.
10. Slide entire sprocket assembly slightly outward, and remove the first sprocket **(Figure 58, item 1)** off the drive spindle and alignment key **(Figure 58, item 2)**.

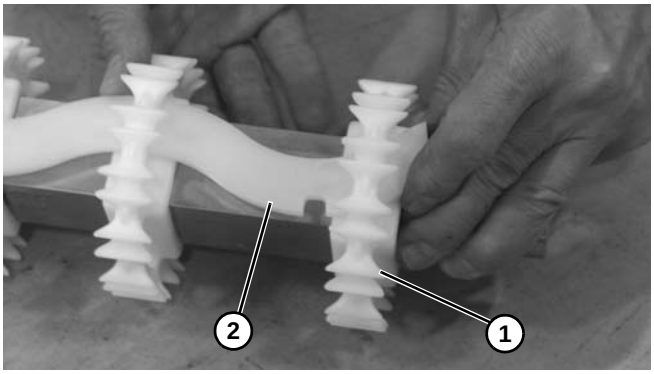


Figure 58

11. Remove remaining sprockets **(Figure 59, item 1)** off the alignment key **(Figure 59, item 2)** while sliding the entire assembly off the drive spindle **(Figure 59, item 3)**.

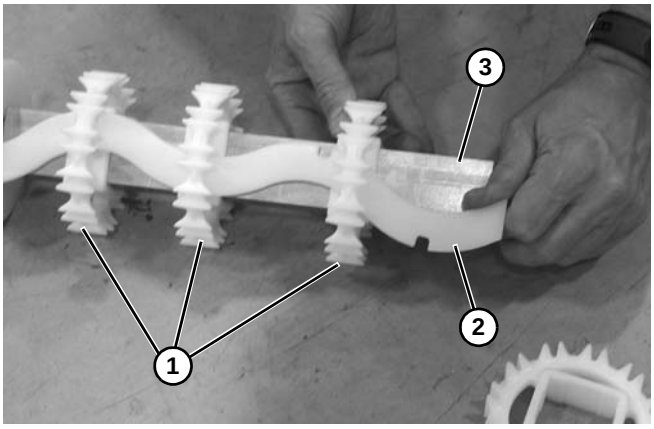


Figure 59

12. Replace components, as needed **(Figure 60)**.

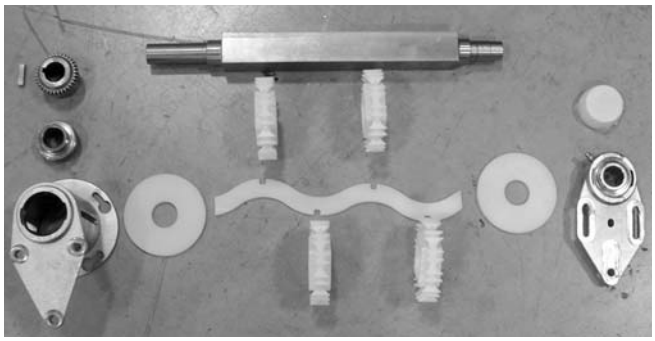


Figure 60

13. Install parts in reverse order of removal.

NOTE
To reassemble please note the placement of the sprockets on the alignment key.

Motorized Pulley Drive Tail

1. Remove limiter. Refer to "Limiter Replacement" on page 15.
2. Remove conveyor belt. Refer to "Conveyor Belt Replacement" on page 15.
3. Lift each locking plate **(Figure 61, item 1)** on each side, as shown, on drive end **(Figure 61, item 2)**.

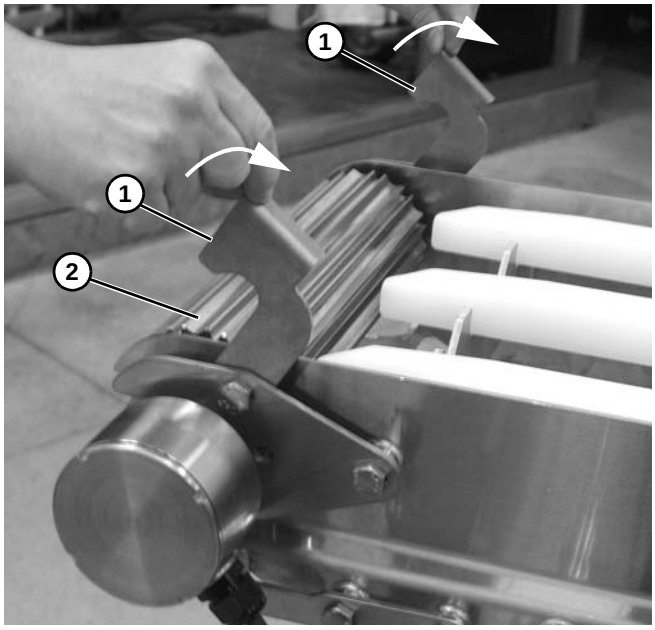


Figure 61

NOTE

*Note the square end **(Figure 62, item 1)** of drive spindle orientation in slotted brackets **(Figure 62, item 2)** as you are moving the drive assembly from conveyor.*

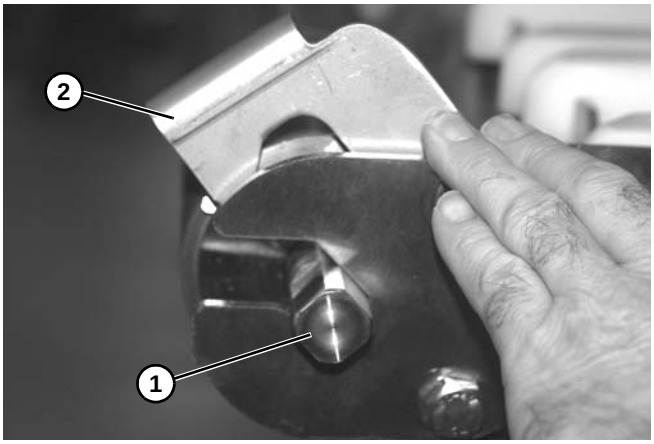


Figure 62

4. Rotate and remove the drive spindle assembly **(Figure 63, item 1)** off the drive tail blocks **(Figure 63, item 2)**.

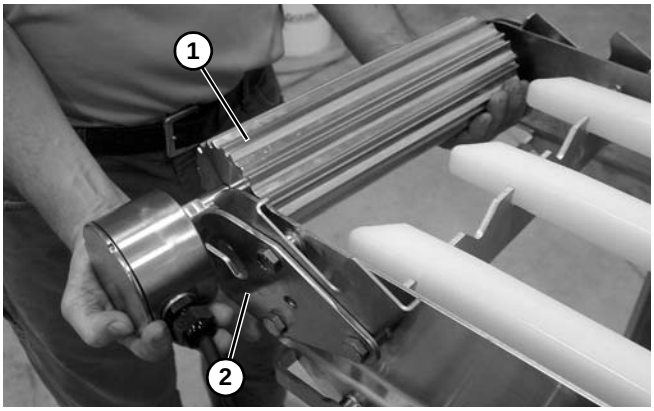


Figure 63

5. Replace entire drive assembly.
6. Install parts in reverse order of removal.

Idler Puck and Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

NOTE

Idler tails are equipped with plain bushing pucks. Replace when worn.

1. Open conveyor belt. Refer to "Conveyor Belt Replacement" on page 15.
2. Remove screw **(Figure 64, item 1)** and washer **(Figure 64, item 2)** on each side of idler end.

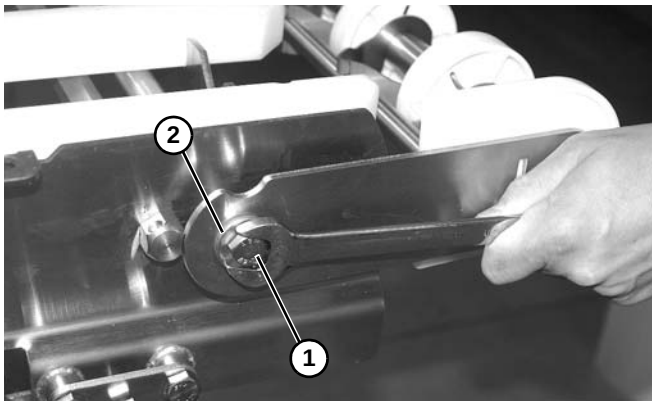


Figure 64

NOTE

*Make note of curved notch **(Figure 65, item 1)** and notched end **(Figure 65, item 2)** of each tail plate before removing assembly.*

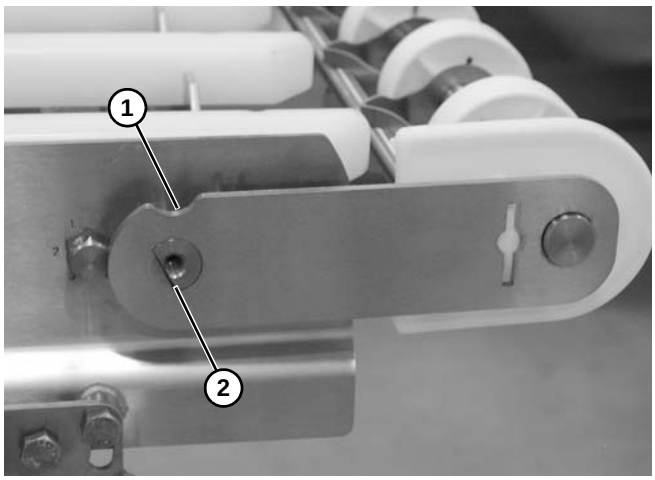


Figure 65

3. Remove idler assembly **(Figure 66, item 1)** from each end of tip up assembly **(Figure 66, item 2)** on conveyor frame.

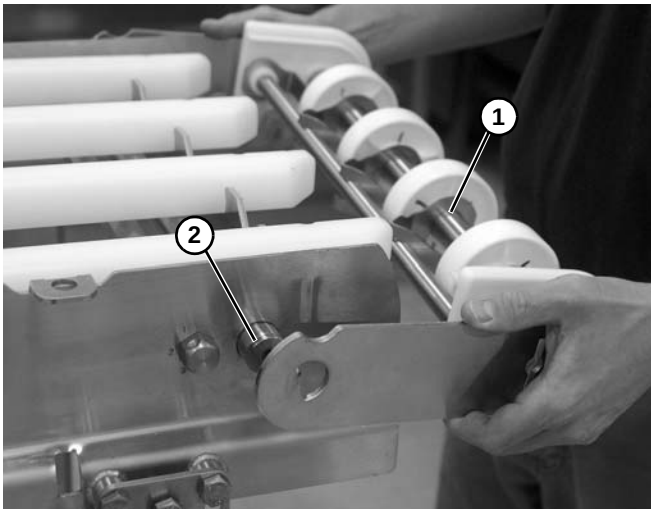


Figure 66

4. Place entire assembly on work surface **(Figure 67)**.

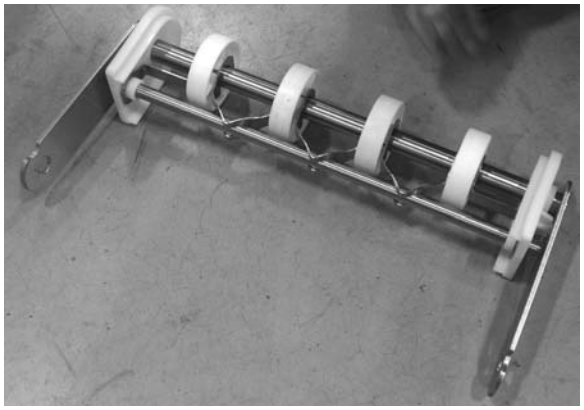


Figure 67

5. Remove tail plate **(Figure 68, item 1)** from assembly, making note of orientation of tab **(Figure 68, item 2)** and mating surfaces of puck rod **(Figure 68, item 3)** and tail plate.

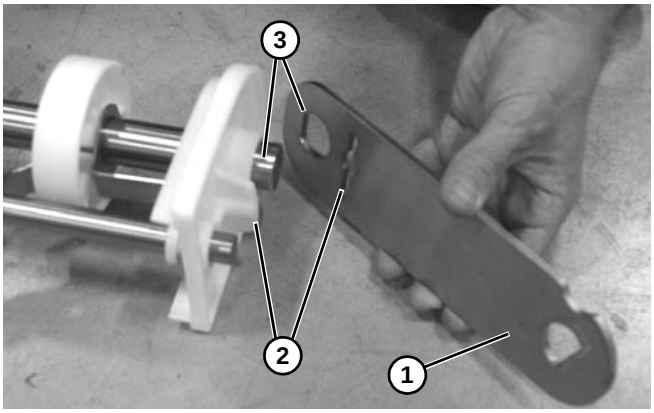


Figure 68

6. Remove tracking plate **(Figure 69, item 1)** from puck rod **(Figure 69, item 2)** and idler shaft **(Figure 69, item 3)**.

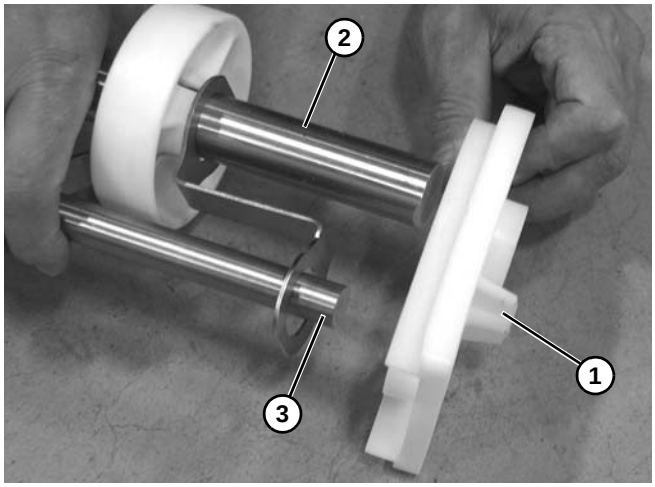


Figure 69

7. Remove outside idler puck end spacer **(Figure 70, item 1)**.

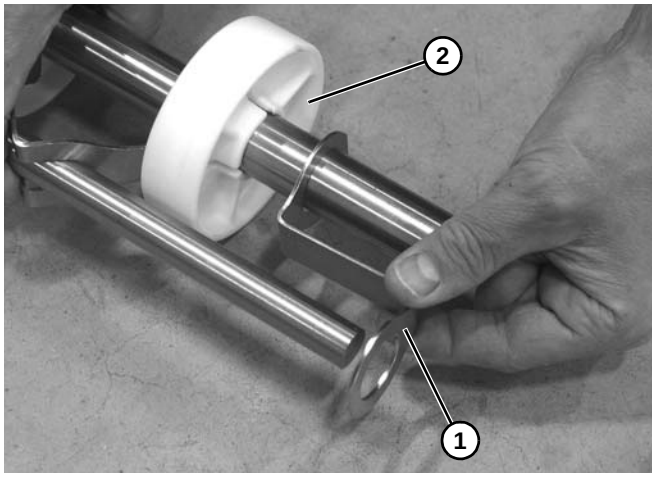


Figure 70

8. Slide off the puck **(Figure 70, item 2)** from the puck rod.
9. Remove inside puck U-spacer **(Figure 71, item 1)** from puck rod and idler shaft.

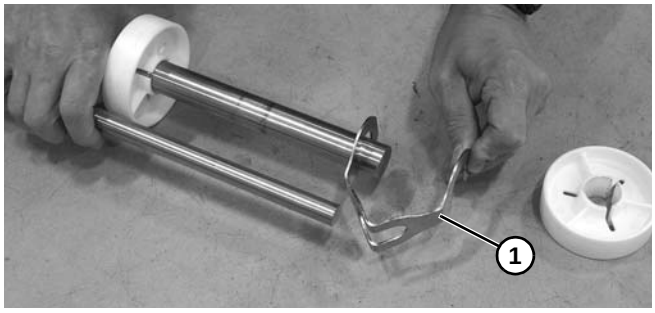


Figure 71

10. Repeat as needed to remove remaining pucks.

11. Replace components, as needed **(Figure 72)**.

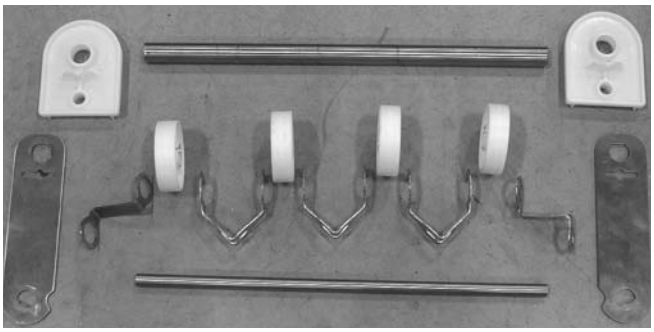


Figure 72

12. Install parts in reverse order of removal.

NOTE
To reassemble please note the placement of the inside U-spacers and outside end spacers between pucks.

Bearing Replacement

⚠ WARNING

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

Drive Tail Bearing Replacement

⚠ WARNING

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

1. Remove bearing housing. refer to “Standard Drive Tail” on page 21. Follow steps 1 through 6.
2. Turn bearing **(Figure 73, item 1)** to align with slots **(Figure 73, item 2)** and anti-rotation nub **(Figure 73, item 3)**, as shown, in bearing housing. Then remove bearing.

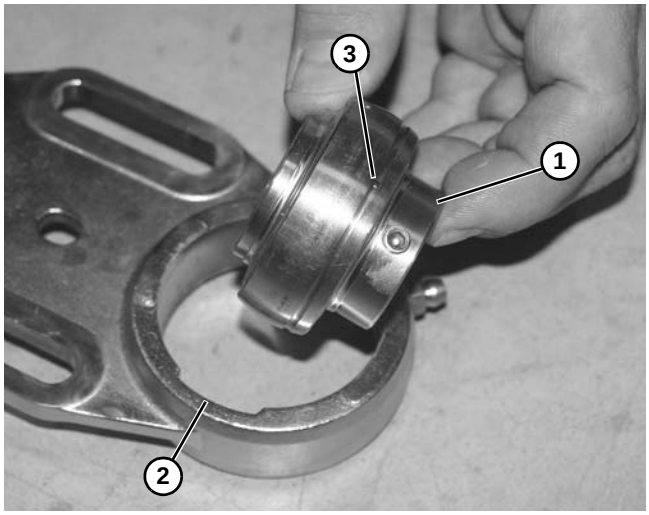


Figure 73

3. Inspect bearing housing bearing surface. Replace if worn or damaged. Refer to “Service Parts” on page 28.
4. Insert bearing **(Figure 73, item 1)** into housing slot. Locate anti-rotation nub **(Figure 73, item 3)** to align with slot **(Figure 73, item 2)** and twist bearing into housing.

Belt Return Maintenance

WARNING

SEVERE HAZARD!

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

Belt Returns 660 mm Wide and Wider

1. Remove belt return assembly **(Figure 74, item 1)** from slotted holes **(Figure 74, item 2)** on each side of conveyor frame.

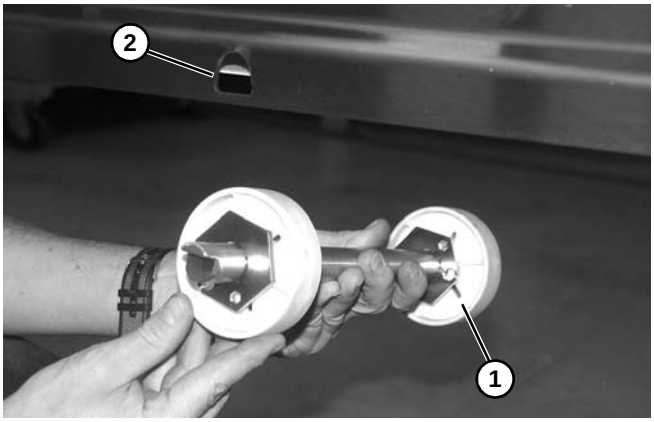


Figure 74

2. Insert an 8 mm **(Figure 75, item 1)** and 6 mm **(Figure 75, item 2)** hex wrench into the retainer plate.

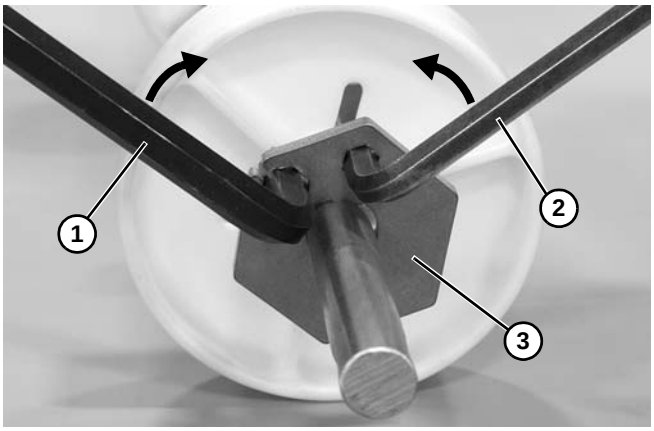


Figure 75

3. Move wrenches toward each other to unlock the retainer plate **(Figure 75, item 3)** and remove from the shaft.
4. Remove puck **(Figure 76, item 1)** from the shaft.

Figure 76

5. Repeat steps 3 through 5 as needed.
6. Install new pucks with retainer plates on both sides.
   a. Insert an 8 mm **(Figure 77, item 1)** and 6 mm **(Figure 77, item 2)** hex wrench into the retainer plate.

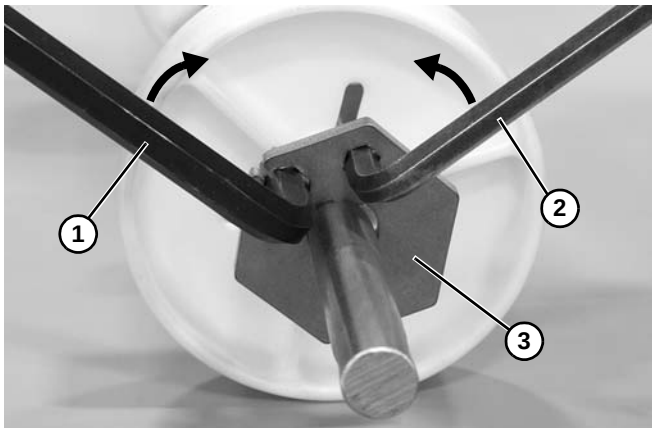


Figure 77

   b. Move wrenches toward each other to open the retainer plate **(Figure 77, item 3)** and install onto the shaft. Position retainer plate where needed.
   c. To lock the retainer plate **(Figure 78, item 1)** in place, move the wrenches **(Figure 78, item 2)** away from each other.

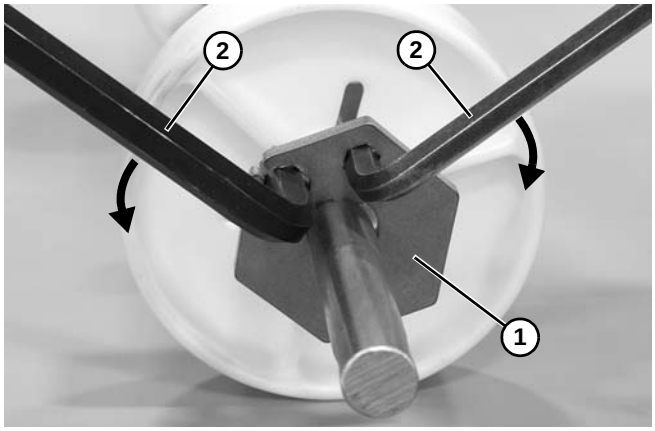


Figure 78

NOTE

*When assembling pucks **(Figure 79, item 1)** with retainer plates **(Figure 79, item 2)**, make certain that there is a minimum of 38 mm (1.5") of clearance **(Figure 79, item 3)** on each end.*

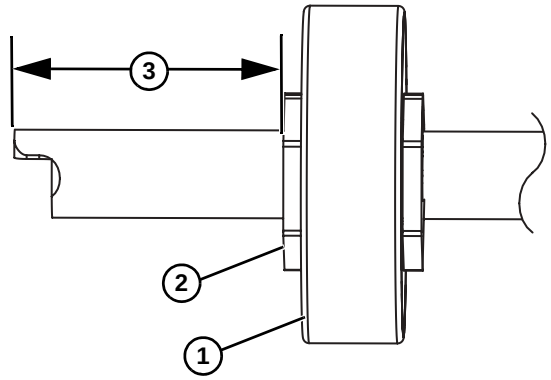


Figure 79

7. Install belt return assembly in reverse order of removal.

Belt Returns Under 660 mm Wide

1. Remove the notched end of the return shaft **(Figure 80, item 1)** from the small hole **(Figure 80, item 2)** in the inside of the conveyor frame.

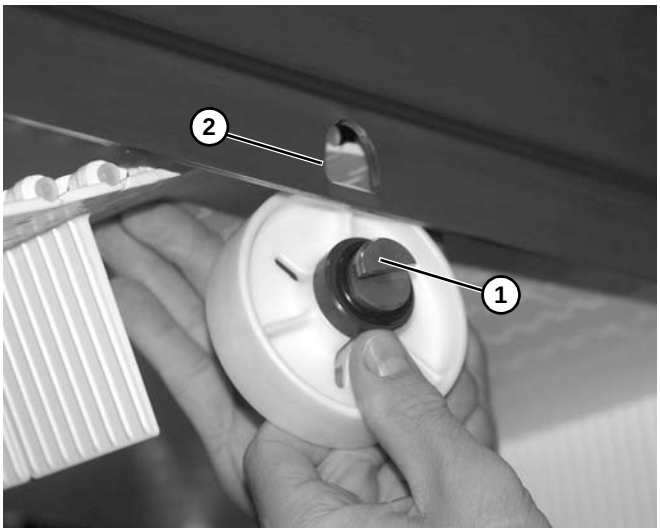


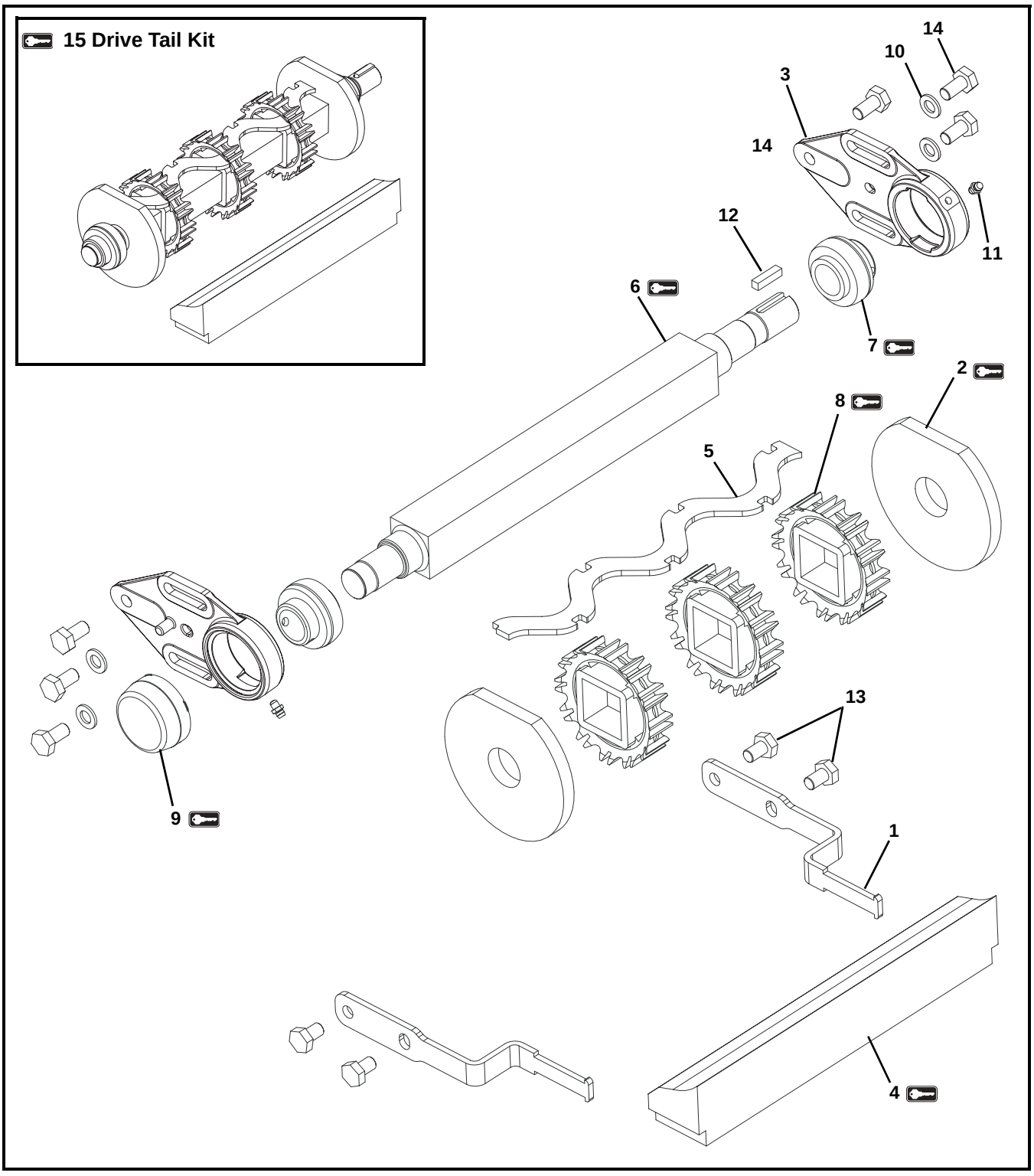
Figure 80

2. Repeat the procedure for all other belt returns.
3. Remove puck from stub shaft.
4. Replace worn or damaged parts.
5. Install parts in reverse order of removal.

Service Parts

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

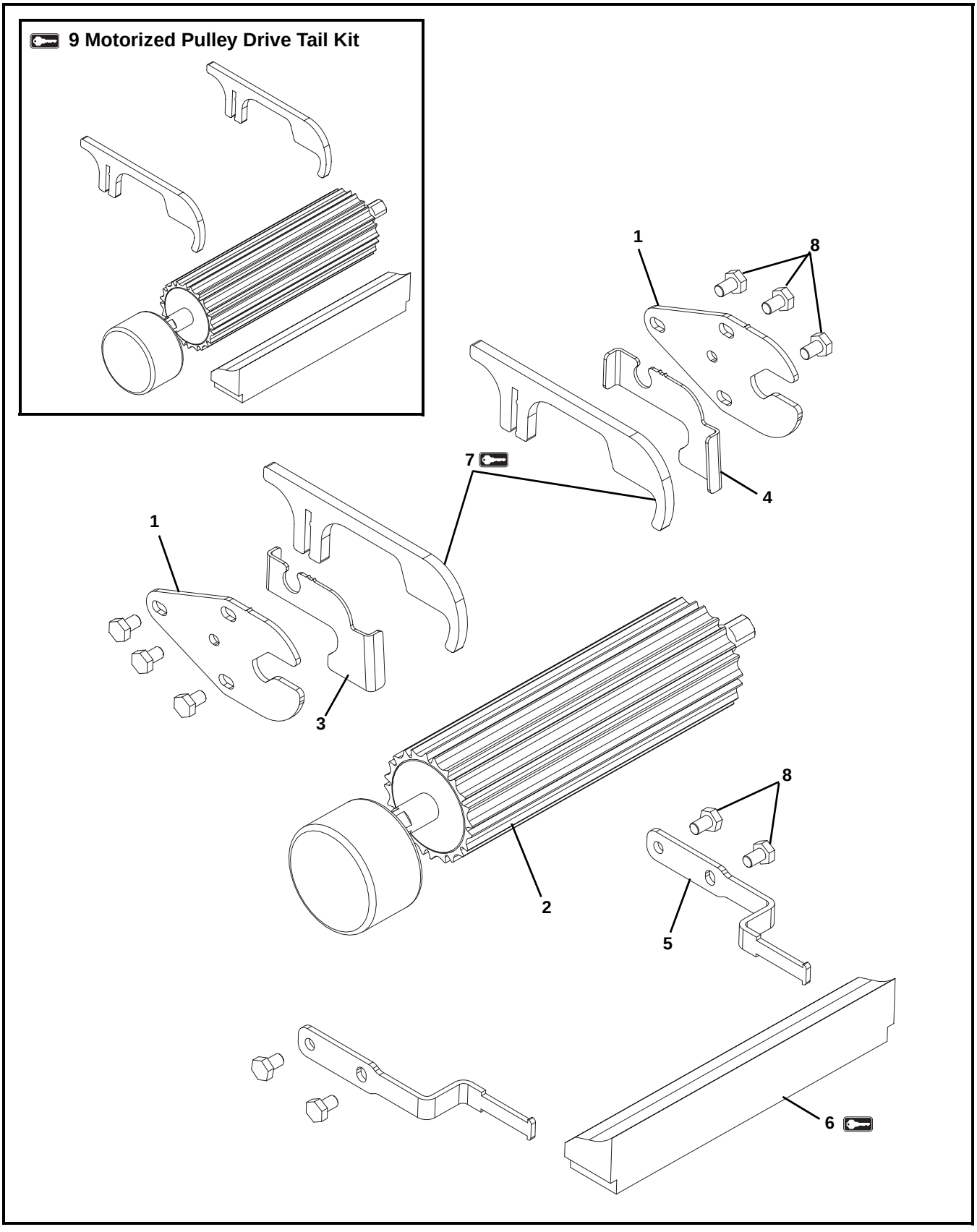
Drive Tail



Item	Part Number	Description
1	530567	Limiter Bracket
2	530486	Guard Puck
	530781	Guard Puck for Conveyors with High Sides
3	529901-M	Bearing Housing
4	530566-WWWW-M	Limiter Bar
5	530578-WWWW-M	Sprocket Alignment Key
6	530742-KB-WWWWN	Drive Spindle for Standard Conveyors
	530742-KB-WWWWY	Drive Spindle for Ultimate 3A Conveyors
	530742-KK-WWWWN	Dual Shaft Drive Spindle for Standard Conveyors
	530742-KK-WWWWY	Dual Shaft Drive Spindle for Ultimate 3A Conveyors
7	802-162	Bearing
8	807-1445	Sprocket
9	807-1454	Bearing Cap
10	807-1880	Washer
11	810-187	Grease Fitting
12	912-108SS	Square Key, .25" x 1.00"
13	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
14	961020MSS	Hex Head Cap Screw, M10-1.50 x 20 mm
15	530879-WWWWN	Drive Tail Kit for Standard Conveyors (Includes items 2, 4, 5, 6, 7, 8, and 12)
	530879-WWWWY	Drive Tail Kit for Ultimate 3A Conveyors (Includes items 2, 4, 5, 6, 7, 8, and 12)
	530880-WWWWN	Dual Drive Tail Kit for Standard Conveyors (Includes items 2, 4, 5, 6, 7, 8, and 12)
	530880-WWWWY	Dual Drive Tail Kit for Ultimate 3A Conveyors (Includes items 2, 4, 5, 6, 7, 8, and 12)
WWWW = Conveyor width reference in mm 0152 - 1219		
See Specifications chart on page 7 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

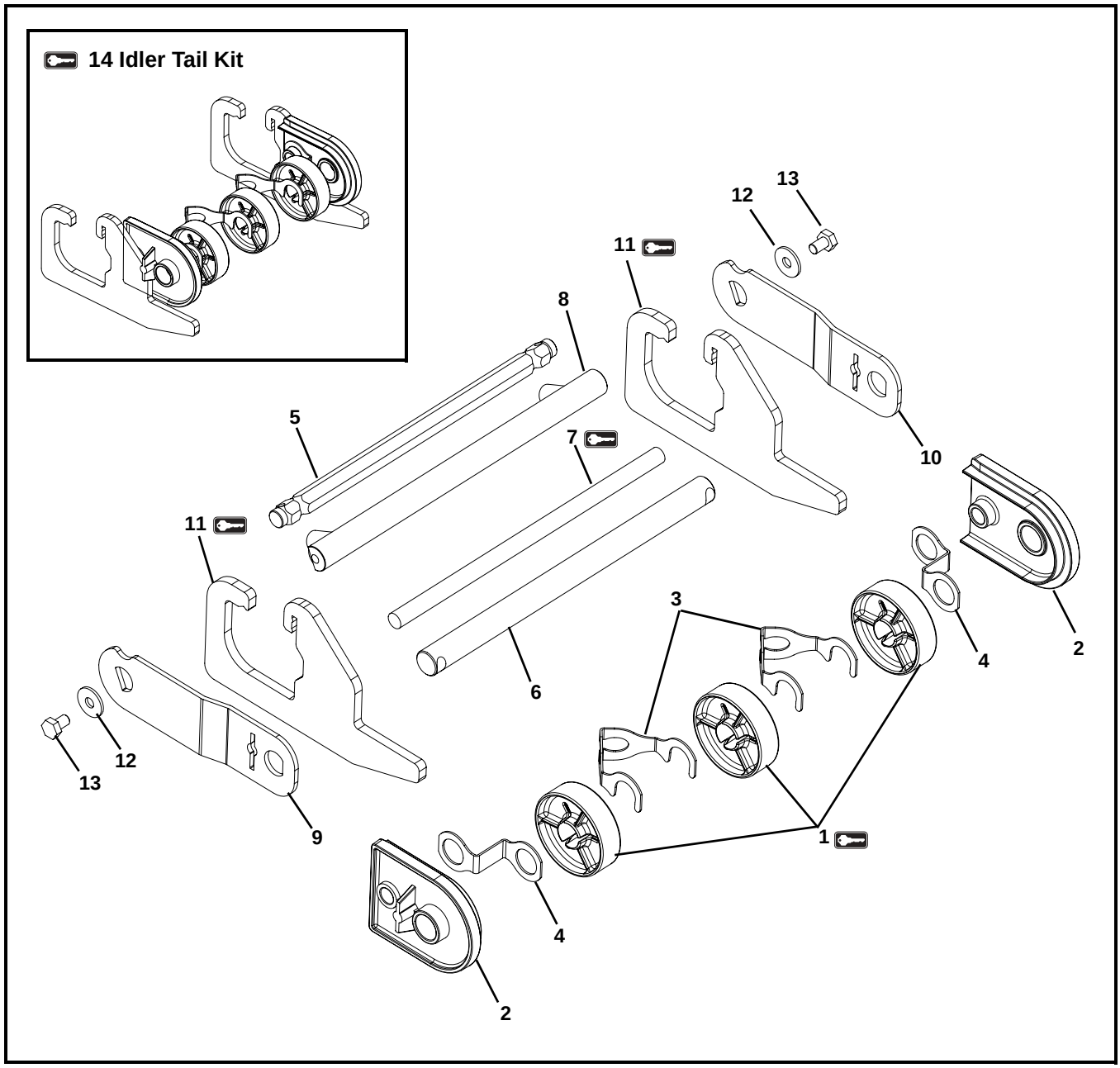
Motorized Pulley Drive Tail



Item	Part Number	Description
1	529895	Mount Plate
2	530390-WWWW-M	Motorized Pulley
3	530375-LH	Spindle Guard, Left Hand
4	530375-RH	Spindle Guard, Right Hand
5	530567	Limiter Bracket
6	530566-WWWW-M	Limiter Bar
7	530743	Belt Guide
	530753	Belt Guide for Conveyors with High Sides
8	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
9	530881-WWWWN	Motorized Pulley Drive Tail Kit (Includes items 2, 6, and 7)
WWWW = Conveyor width reference in mm 0152 - 1219		
See Specifications chart on page 7 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

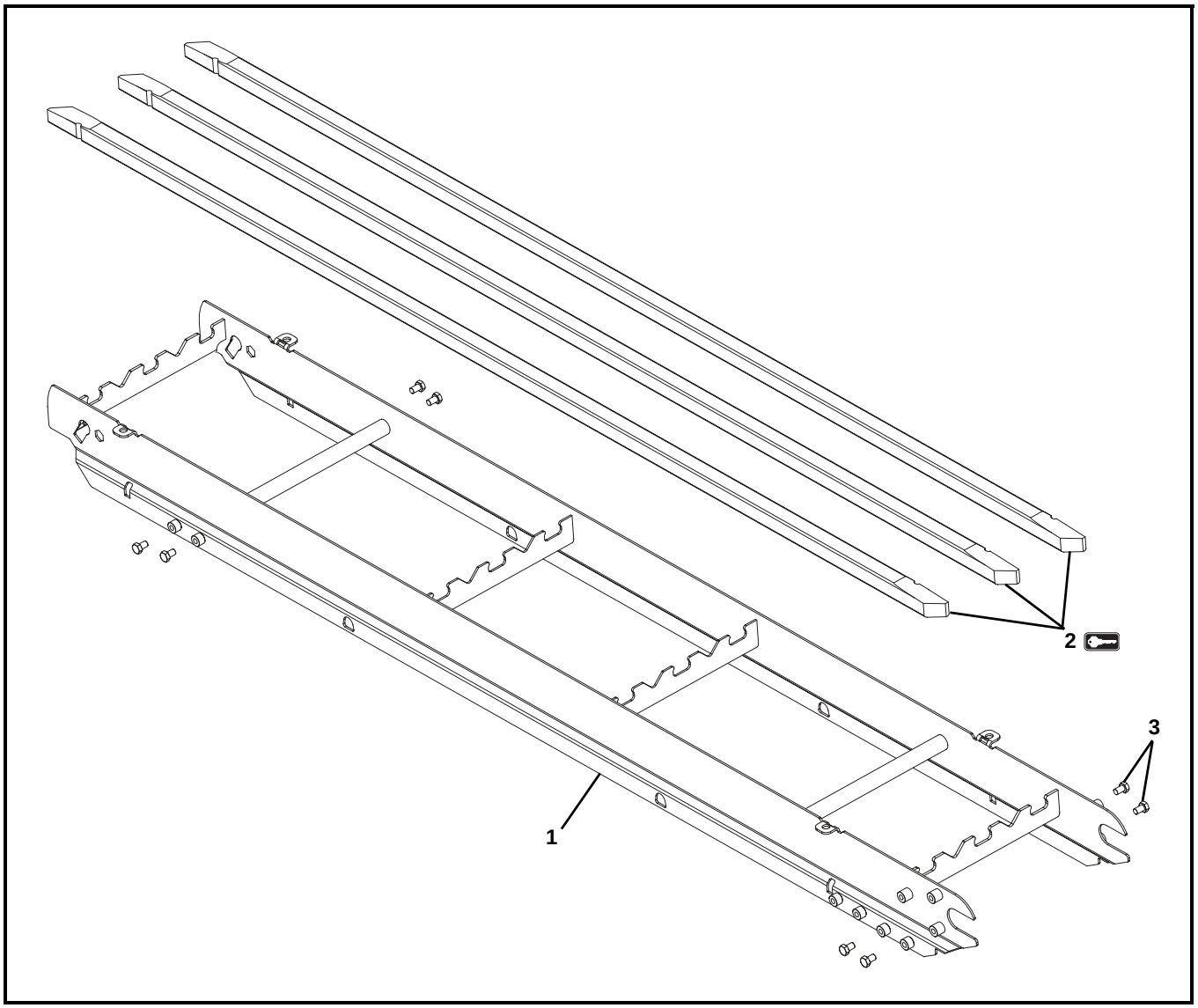
Idler Tail



Item	Part Number	Description
1	506297	Idler Puck
2	529898	Tracking Plate
3	530387	U-Spacer for Standard Conveyors
	530933-WW	U-Spacer for Ultimate 3A Conveyors
4	530388-A	End Spacer, 39 mm wide
	530388-B	End Spacer, 64 mm wide
	530388-C	End Spacer, 15 mm wide
	530993-WW	End Spacer for Ultimate 3A Conveyors
	532251-00056	End Spacer for Ultimate 3A Conveyors (0152, 0457, 0559, 0660, 0686, 0762, and 0864 widths only)
5	530465-WWWWN	Hex Bar Stop for Standard Conveyors
	530465-WWWWY	Hex Bar Stop for Ultimate 3A Conveyors
6	530466-WWWW-M	Puck Rod
7	530467-WWWWN	Idler Shaft for Standard Conveyors
	530467-WWWWY	Idler Shaft for Ultimate 3A Conveyors
8	530468-WWWW-M	Tip Up Assembly
9	530498-LH	Tail Plate, Left Hand
10	530498-RH	Tail Plate, Right Hand
11	530744	Return Guide
12	911-723	Washer
13	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
14	530899-WWWWN	Idler Tail Kit for Standard Conveyors (Includes items 1, 2, 3, 4, and 11)
	530899-WWWWY	Idler Tail Kit for Ultimate 3A Conveyors (Includes items 1, 2, 3, 4, and 11)
WW = Part length in mm.		
Example: Part length = 28 mm WW = 28		
WWWW = Conveyor width reference in mm 0152 - 1219		
See Specifications chart on page 7 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

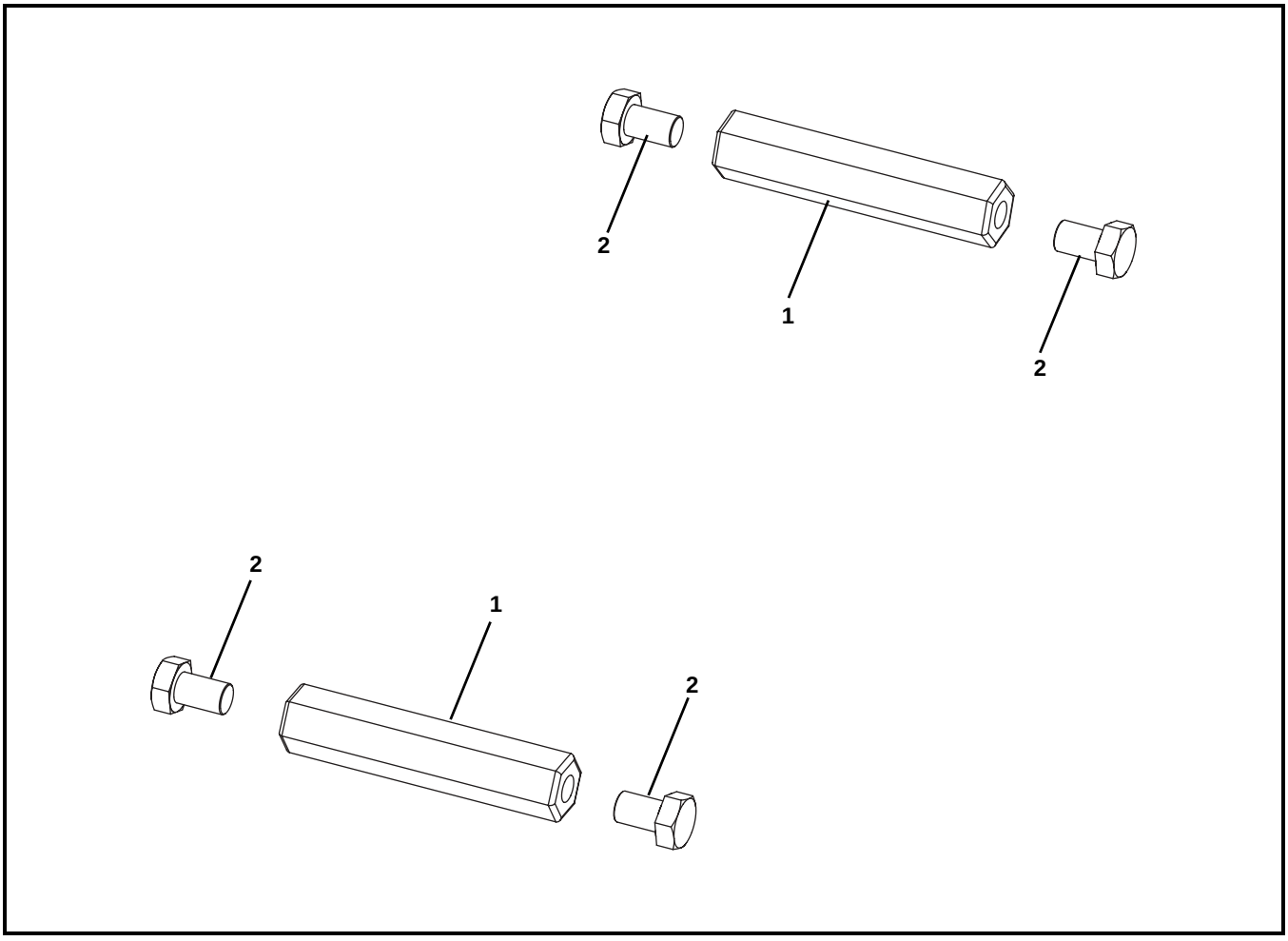
Service Parts

Frame



Item	Part Number	Description
1	----------	Consult Factory for Frame Part Number
2	530569-B-LLLLL-M	Wear Strip for Single Piece Frames
	530569-C-LLLLL-M	Wear Strip for Multiple Piece Frames
3	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
LLLLL = Part length in mm.		
Example: Part length = 1000 mm LLLLL = 01000		
WWWW = Conveyor width reference in mm 0152 - 1219		
See Specifications chart on page 7 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

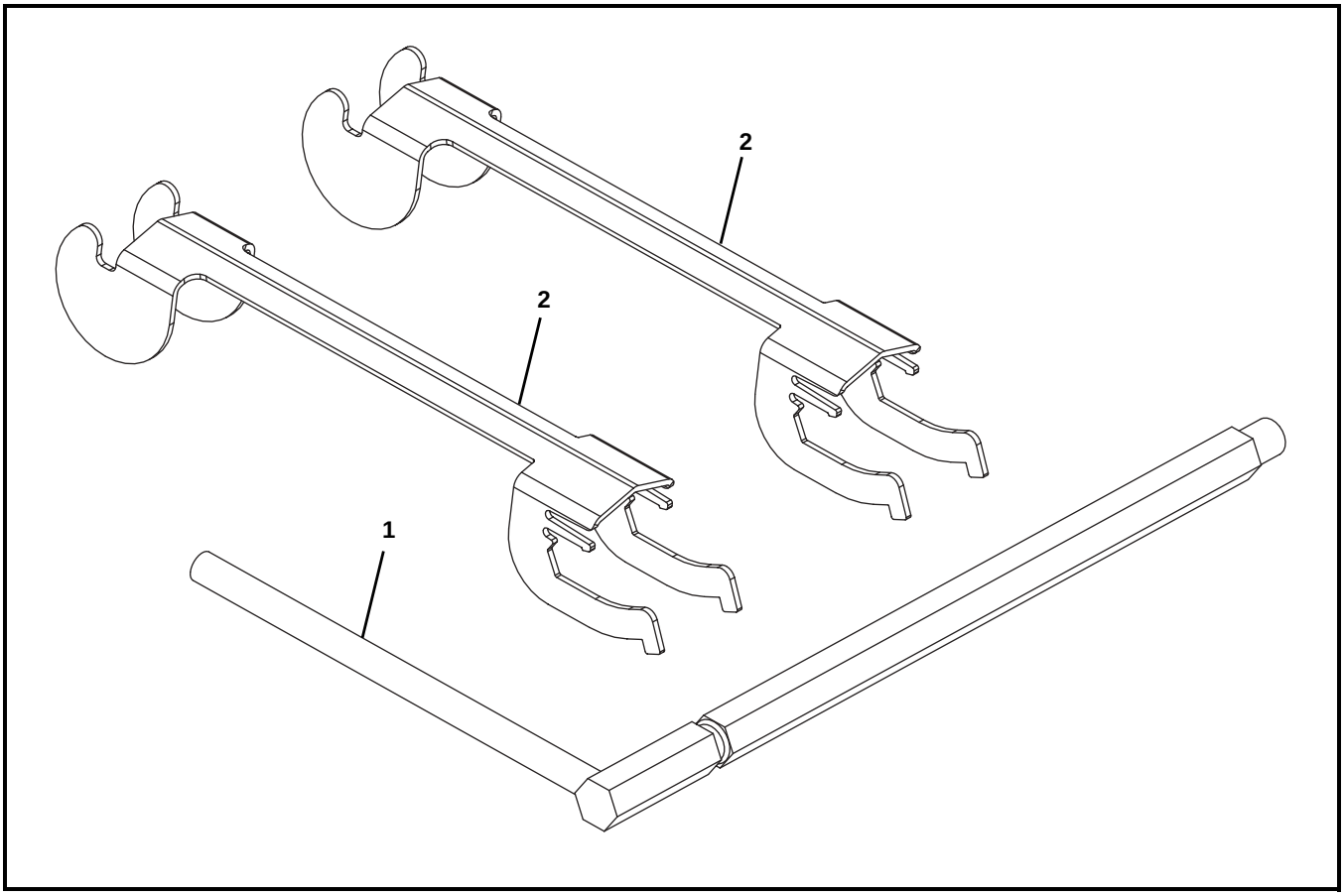
Connecting Assembly



Item	Part Number	Description
1	500193	Connectors
2	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

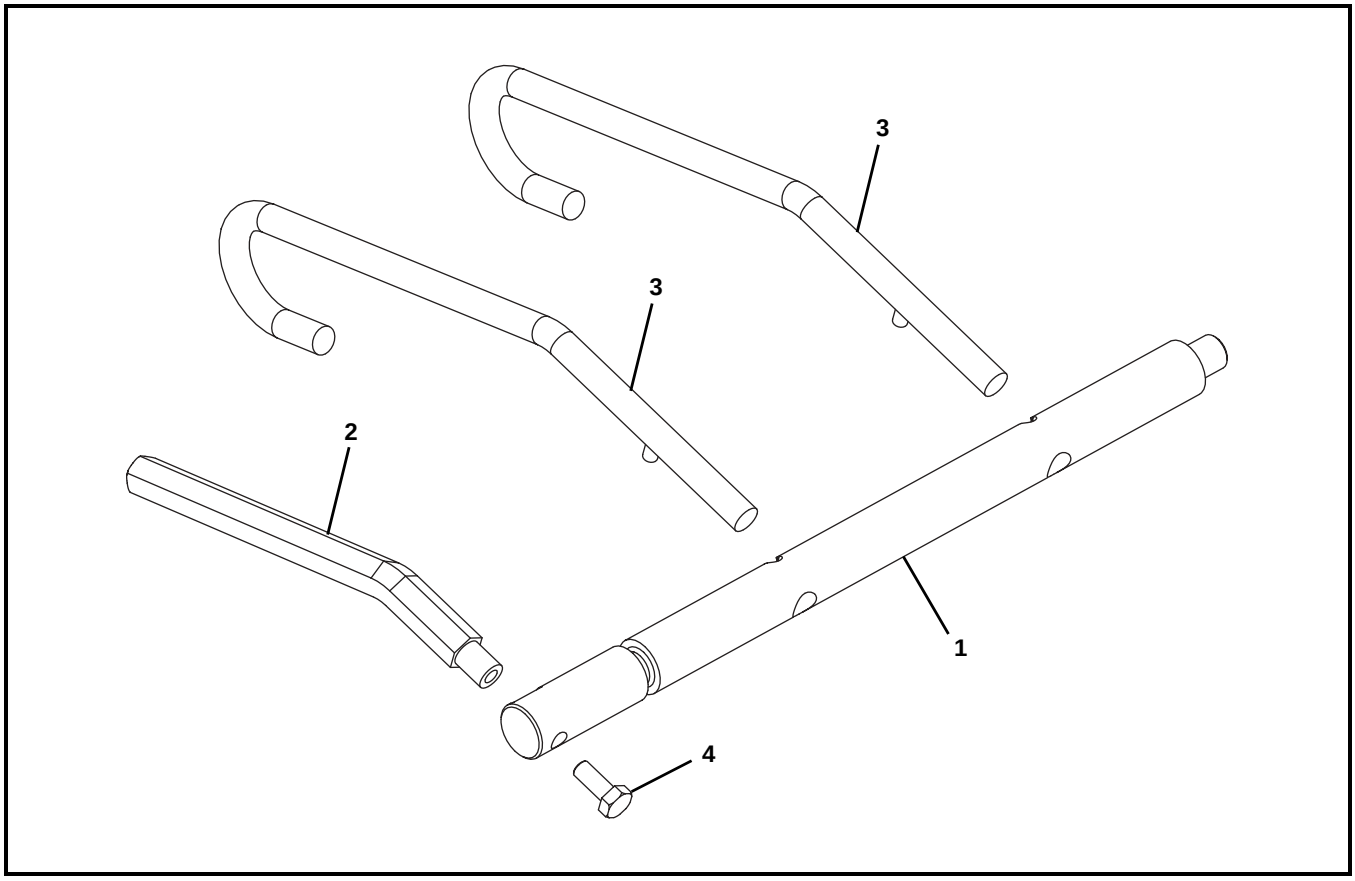
Service Parts

Belt Lifters for Standard Conveyors



Item	Part Number	Description
1	530768-WWWWN	Lifter Bar
2	530605	Lifter
WWWW = Conveyor width reference in mm 0152 - 1219 increments		
See Specifications chart on page 8 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

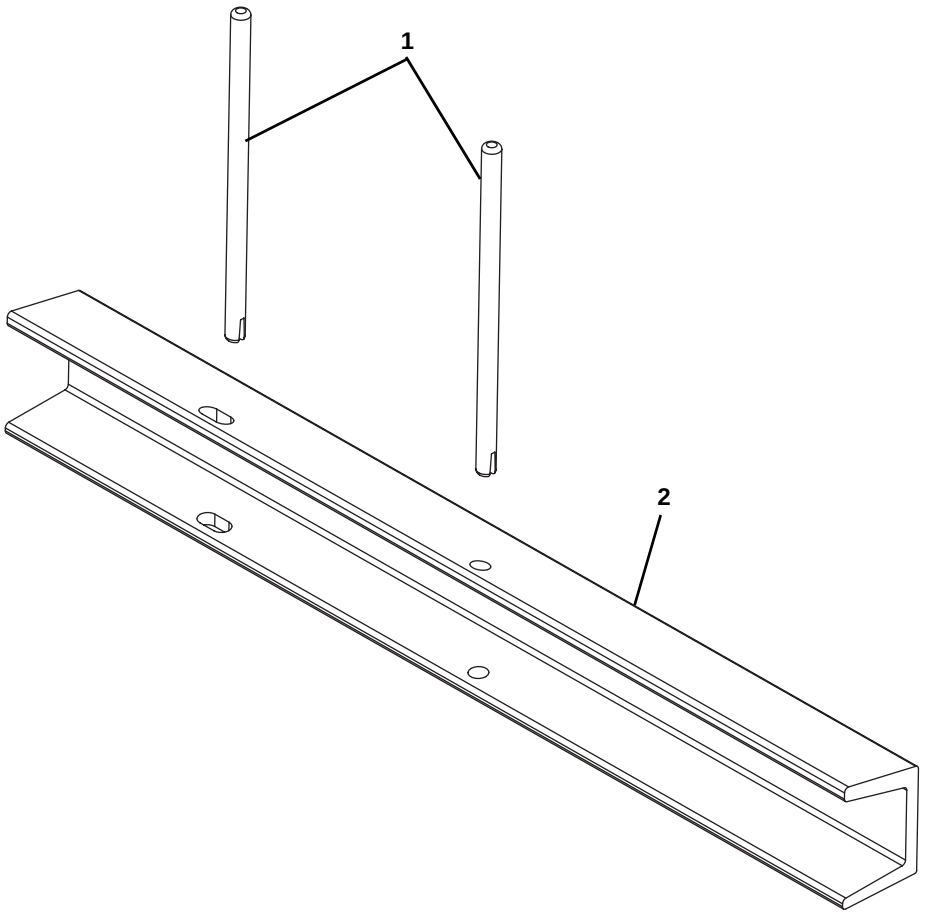
Belt Lifters for Ultimate 3A Conveyors



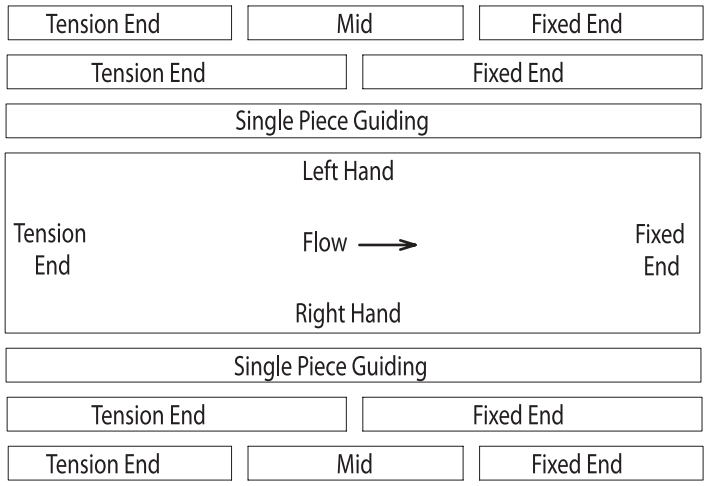
Item	Part Number	Description
1	530097-WWWWY	Lifter Bar
2	500491	Lifter Handle
3	501376	Lifter
4	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
WWWW = Conveyor width reference in mm 0152 - 1219 increments		
See Specifications chart on page 8 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

75 mm Tall UHMW High Sides



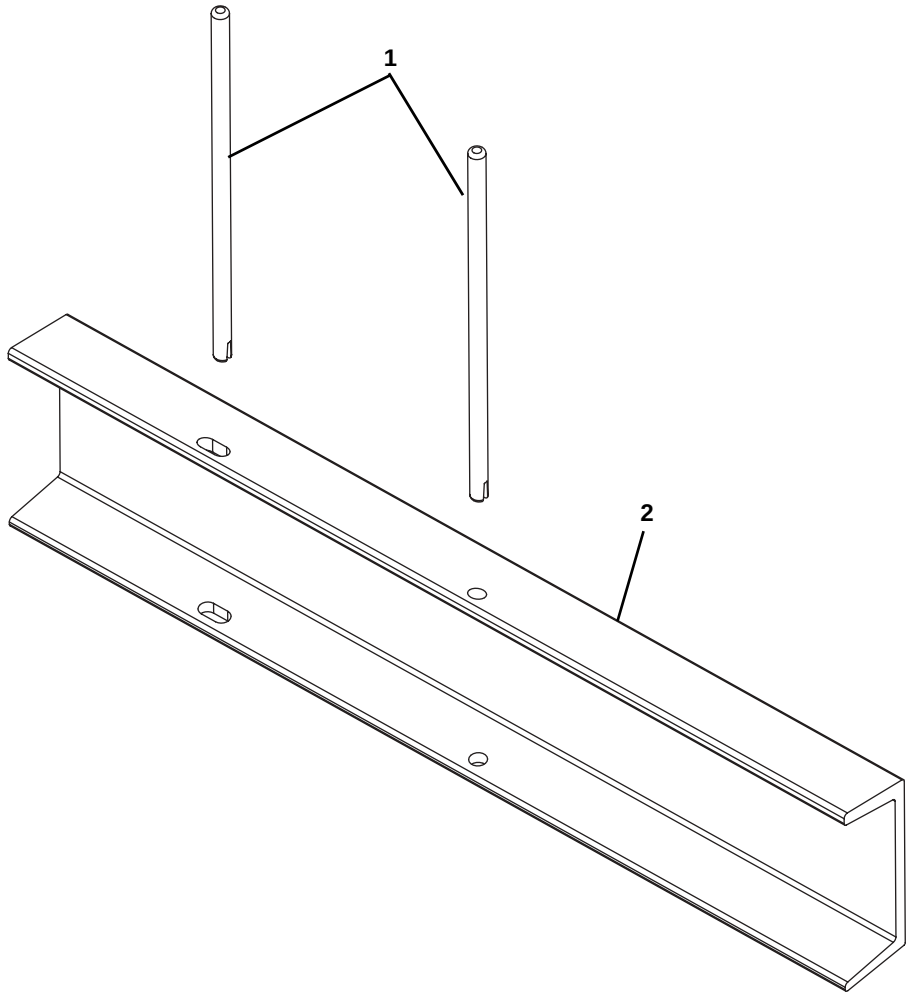
Item 2 Guide Section Description



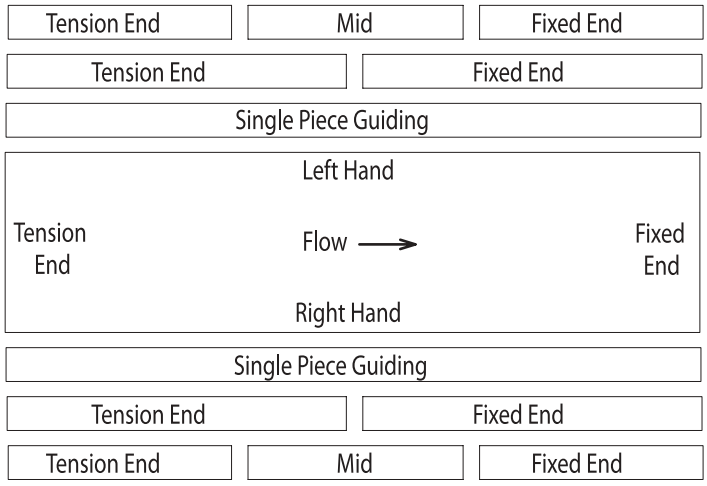
Item	Part Number	Description
1	529796-02480-M	Guide Post
2	530666-EE-7ALLLLL	Single Piece Guiding for Flat Belt Conveyors, Left Hand
	530666-EE-7DLLLLL	Single Piece Guiding for Flat Belt Conveyors, Right Hand
	530666-FE-7ALLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530666-EF-7DLLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530666-FF-7ALLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530666-FF-7DLLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530666-EF-7ALLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530666-FE-7DLLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530686-EA-7ALLLLL	Single Piece Guiding for Cleated Belt Conveyors, Left Hand
	530686-AE-7DLLLLL	Single Piece Guiding for Cleated Belt Conveyors, Right Hand
	530686-FA-7ALLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530686-AF-7DLLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530686-FF-7ALLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530686-FF-7DLLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530686-EF-7ALLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530686-FE-7DLLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
LLLLL = Part length in mm.		
Example: Part length = 1000 mm LLLLL = 01000		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

152 mm Tall UHMW High Sides



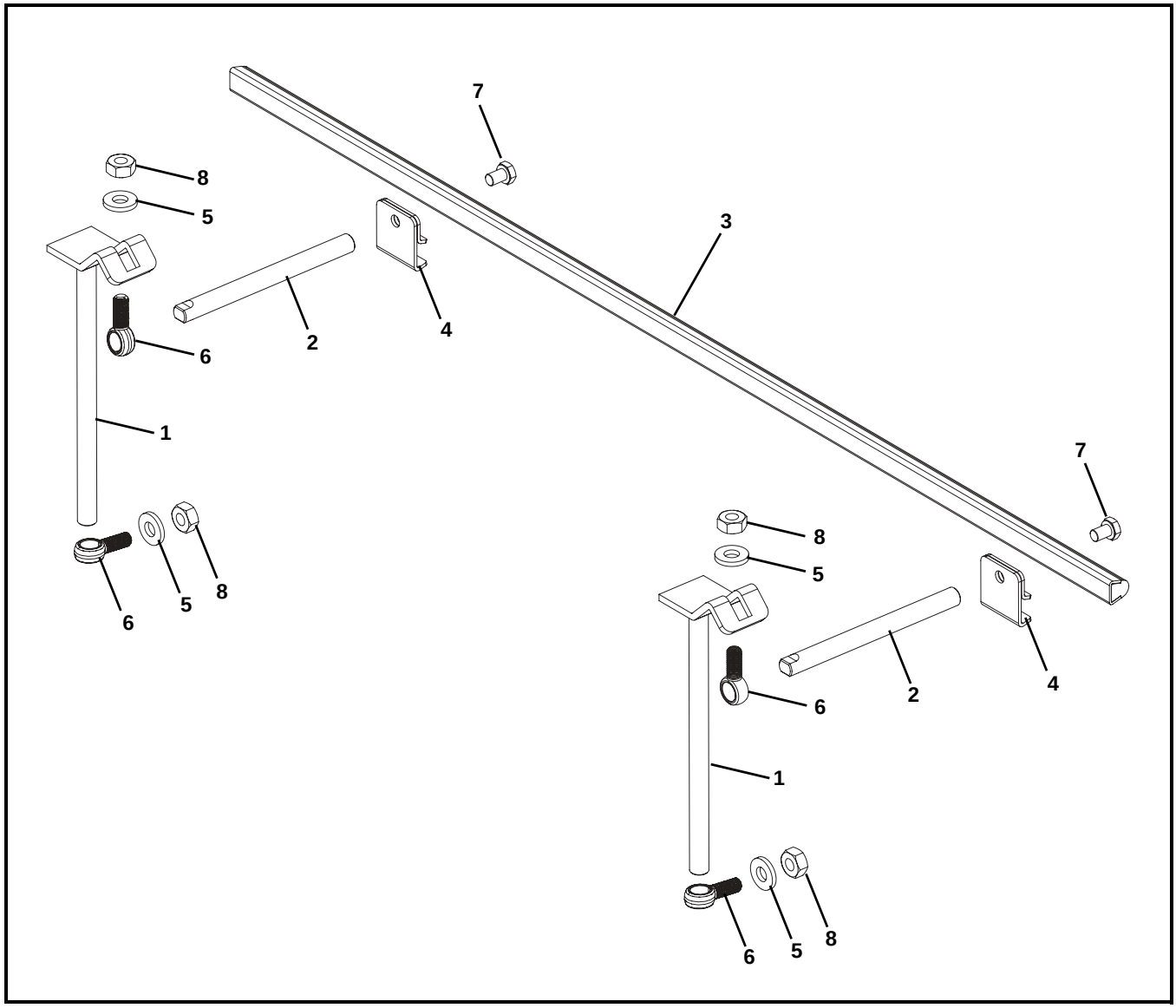
Item 2
Guide
Section
Description



Item	Part Number	Description
1	529796-03250-M	Guide Post
2	530666-EE-8ALLLLL	Single Piece Guiding for Flat Belt Conveyors, Left Hand
	530666-EE-8DLLLLL	Single Piece Guiding for Flat Belt Conveyors, Right Hand
	530666-FE-8ALLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530666-EF-8DLLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530666-FF-8ALLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530666-FF-8DLLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530666-EF-8ALLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530666-FE-8DLLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530686-EA-8ALLLLL	Single Piece Guiding for Cleated Belt Conveyors, Left Hand
	530686-AE-8DLLLLL	Single Piece Guiding for Cleated Belt Conveyors, Right Hand
	530686-FA-8ALLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530686-AF-8DLLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530686-FF-8ALLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530686-FF-8DLLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530686-EF-8ALLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530686-FE-8DLLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
LLLLL = Part length in mm.		
Example: Part length = 1000 mm LLLLL = 01000		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

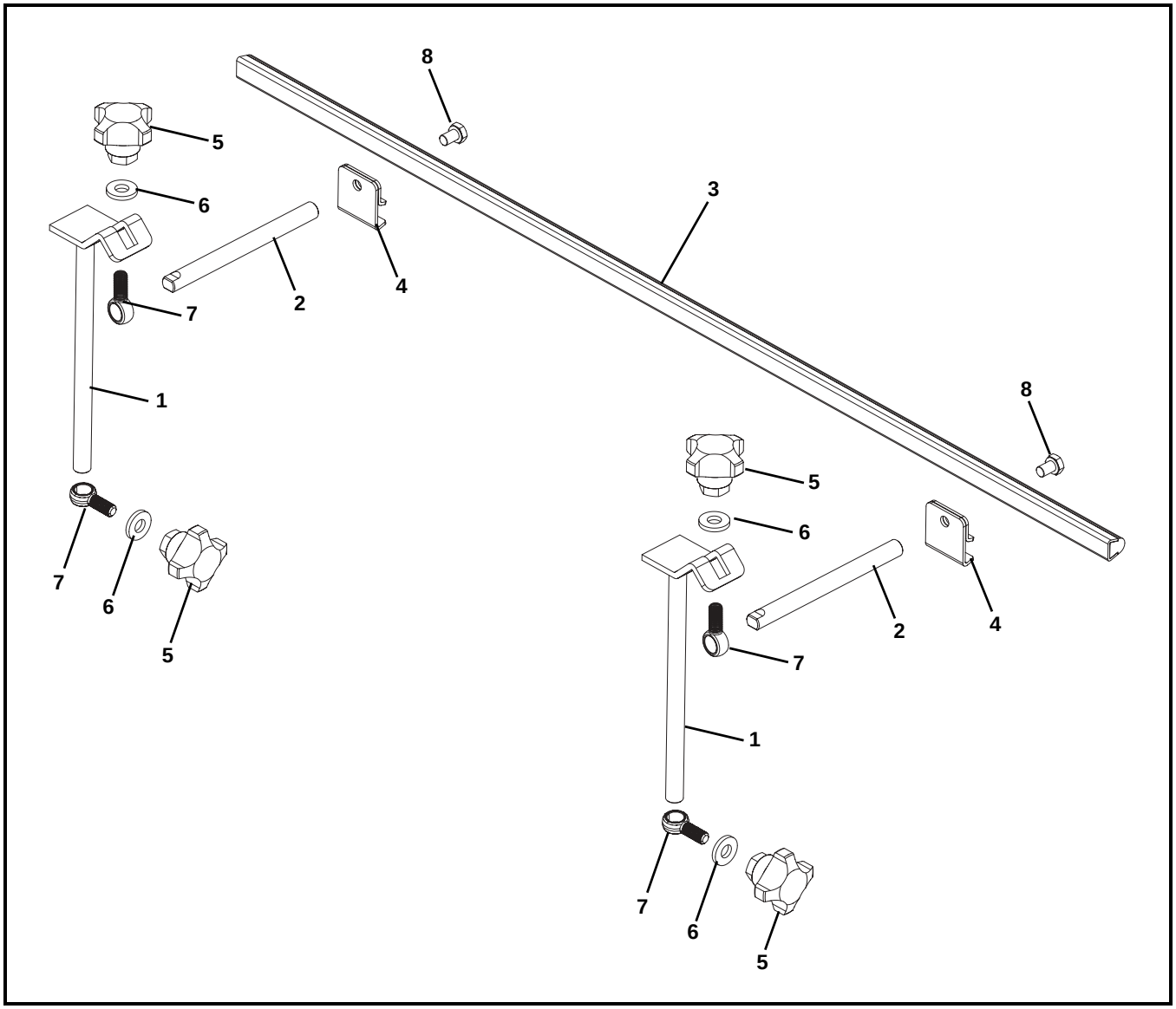
Service Parts

Fully Adjustable Round Guides



Item	Part Number	Description
1	509876	Vertical Post Assembly
2	532300	Guide Post
3	532167-LLLLL	Round Guide Rail
4	807-015	Rail Clamp
5	807-1821	Washer
6	807-1994	Eye Bolt, M10 x 1.50
7	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
8	991001MSS	Hex Nut, M10 - 1.50
LLLLL = Part length in mm.		
Example: Part length = 1000 mm LLLLL = 01000		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

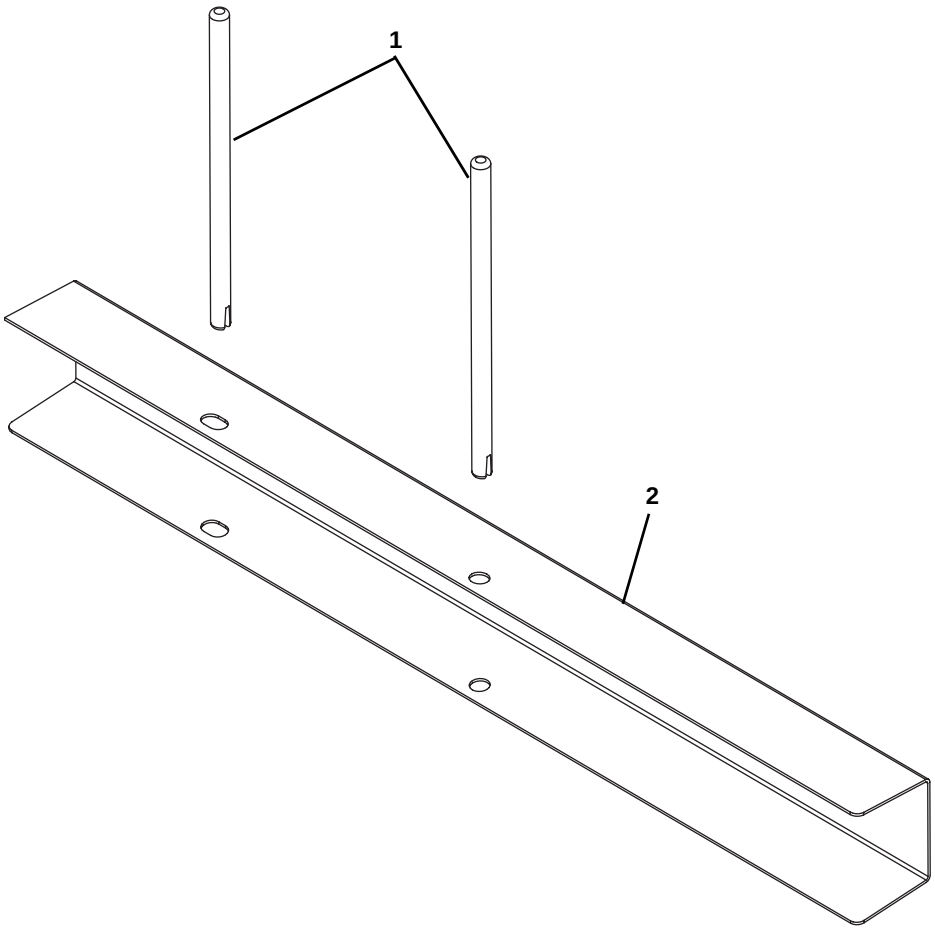
Tool-Less Fully Adjustable Round Guides



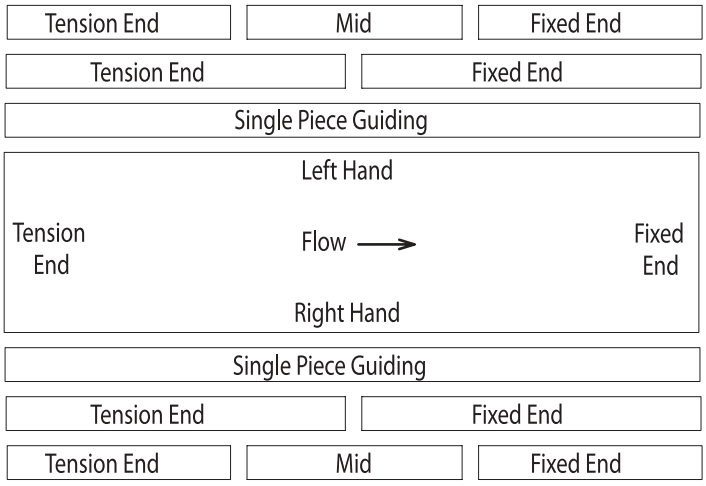
Item	Part Number	Description
1	509876	Vertical Post Assembly
2	532300	Guide Post
3	532167-LLLLL	Round Guide Rail
4	807-015	Rail Clamp
5	807-1057	Handle
6	807-1821	Washer
7	807-1994	Eye Bolt, M10 x 1.50
8	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
LLLLL = Part length in mm.		
Example: Part length = 1000 mm LLLLL = 01000		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

75 mm Tall Stainless Steel High Sides



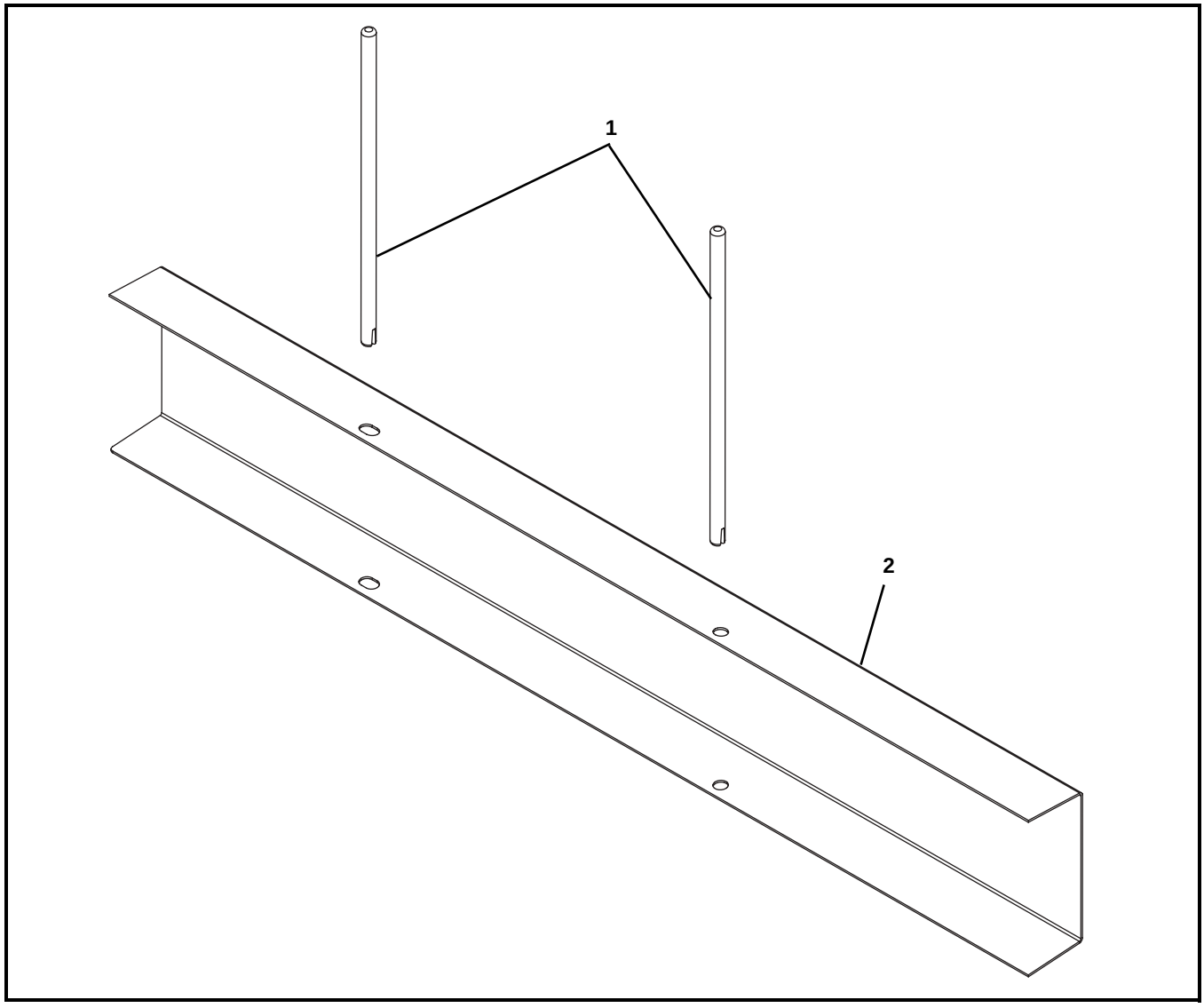
Item 2
Guide
Section
Description



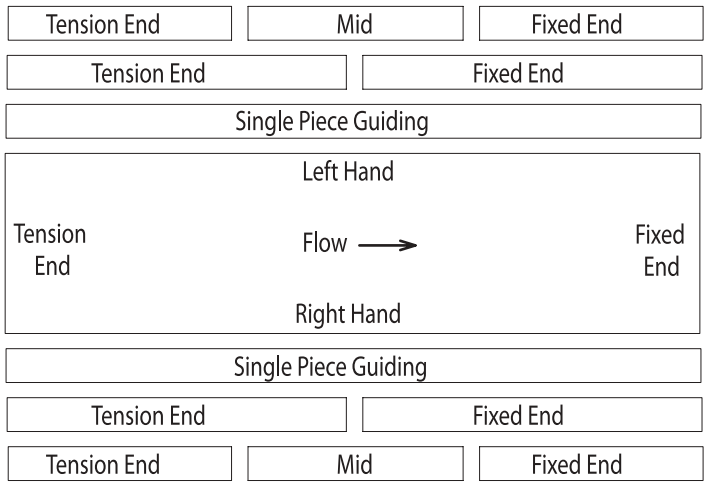
Item	Part Number	Description
1	529796-02480-M	Guide Post
2	530364-EE-7ALLLLL	Single Piece Guiding for Flat Belt Conveyors, Left Hand
	530364-EE-7DLLLLL	Single Piece Guiding for Flat Belt Conveyors, Right Hand
	530364-FE-7ALLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530364-EF-7DLLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530364-FF-7ALLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530364-FF-7DLLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530364-EF-7ALLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530364-FE-7DLLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530627-EA-7ALLLLL	Single Piece Guiding for Cleated Belt Conveyors, Left Hand
	530627-AE-7DLLLLL	Single Piece Guiding for Cleated Belt Conveyors, Right Hand
	530627-FA-7ALLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530627-AF-7DLLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530627-FF-7ALLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530627-FF-7DLLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530627-EF-7ALLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530627-FE-7DLLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
LLLLL = Part length in mm.		
Example: Part length = 1000 mm LLLLL = 01000		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

152 mm Tall Stainless Steel High Sides



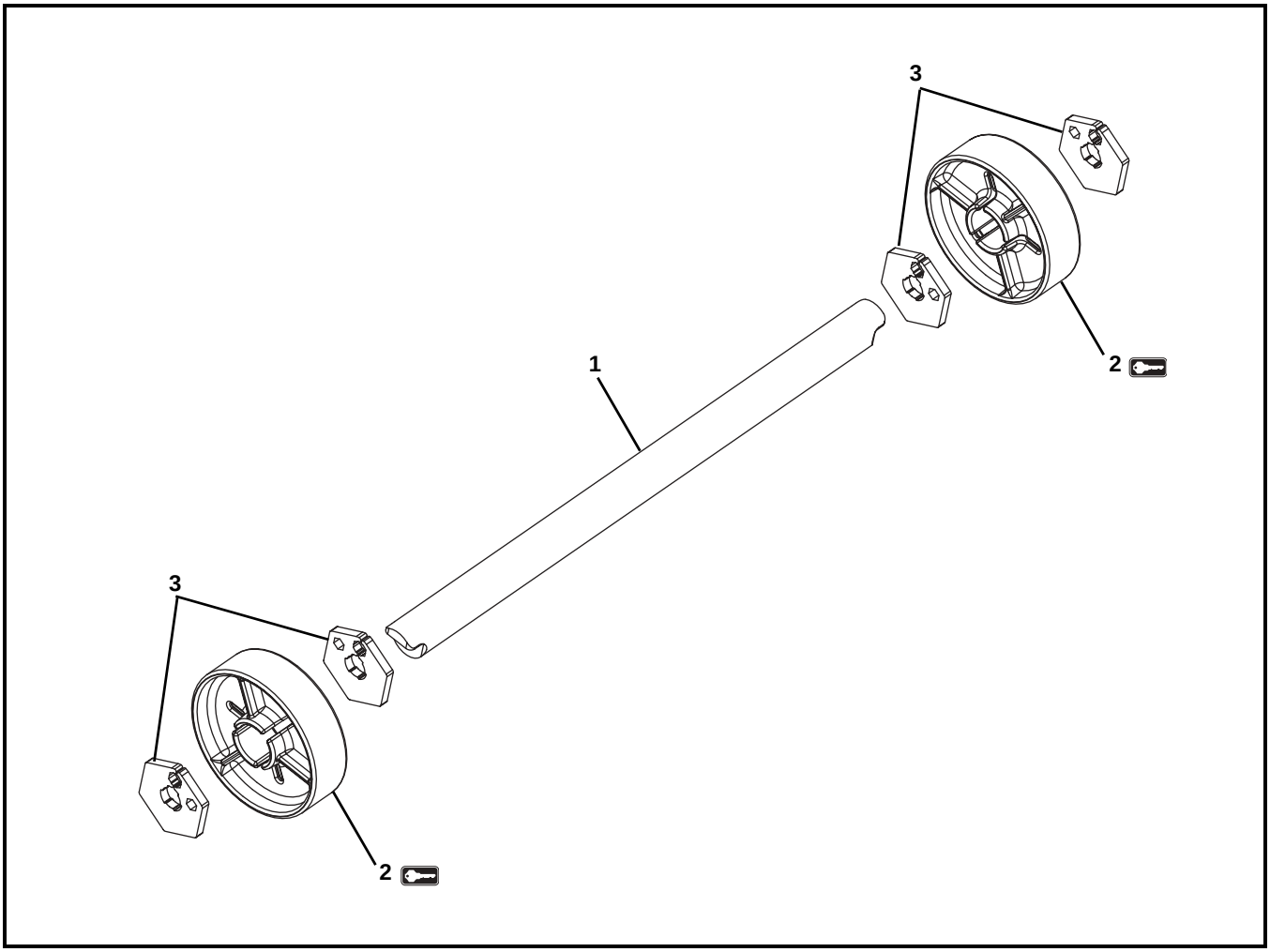
Item 2
Guide
Section
Description



Item	Part Number	Description
1	529796-03250-M	Guide Post
2	530364-EE-8ALLLLL	Single Piece Guiding for Flat Belt Conveyors, Left Hand
	530364-EE-8DLLLLL	Single Piece Guiding for Flat Belt Conveyors, Right Hand
	530364-FE-8ALLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530364-EF-8DLLLLL	Tension End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530364-FF-8ALLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530364-FF-8DLLLLL	Mid Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530364-EF-8ALLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Left Hand
	530364-FE-8DLLLLL	Fixed End Guiding for Flat Belt Multi Section Conveyors, Right Hand
	530627-EA-8ALLLLL	Single Piece Guiding for Cleated Belt Conveyors, Left Hand
	530627-AE-8DLLLLL	Single Piece Guiding for Cleated Belt Conveyors, Right Hand
	530627-FA-8ALLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530627-AF-8DLLLLL	Tension End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530627-FF-8ALLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530627-FF-8DLLLLL	Mid Guiding for Cleated Belt Multi Section Conveyors, Right Hand
	530627-EF-8ALLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Left Hand
	530627-FE-8DLLLLL	Fixed End Guiding for Cleated Belt Multi Section Conveyors, Right Hand
LLLLL = Part length in mm.		
Example: Part length = 1000 mm LLLLL = 01000		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

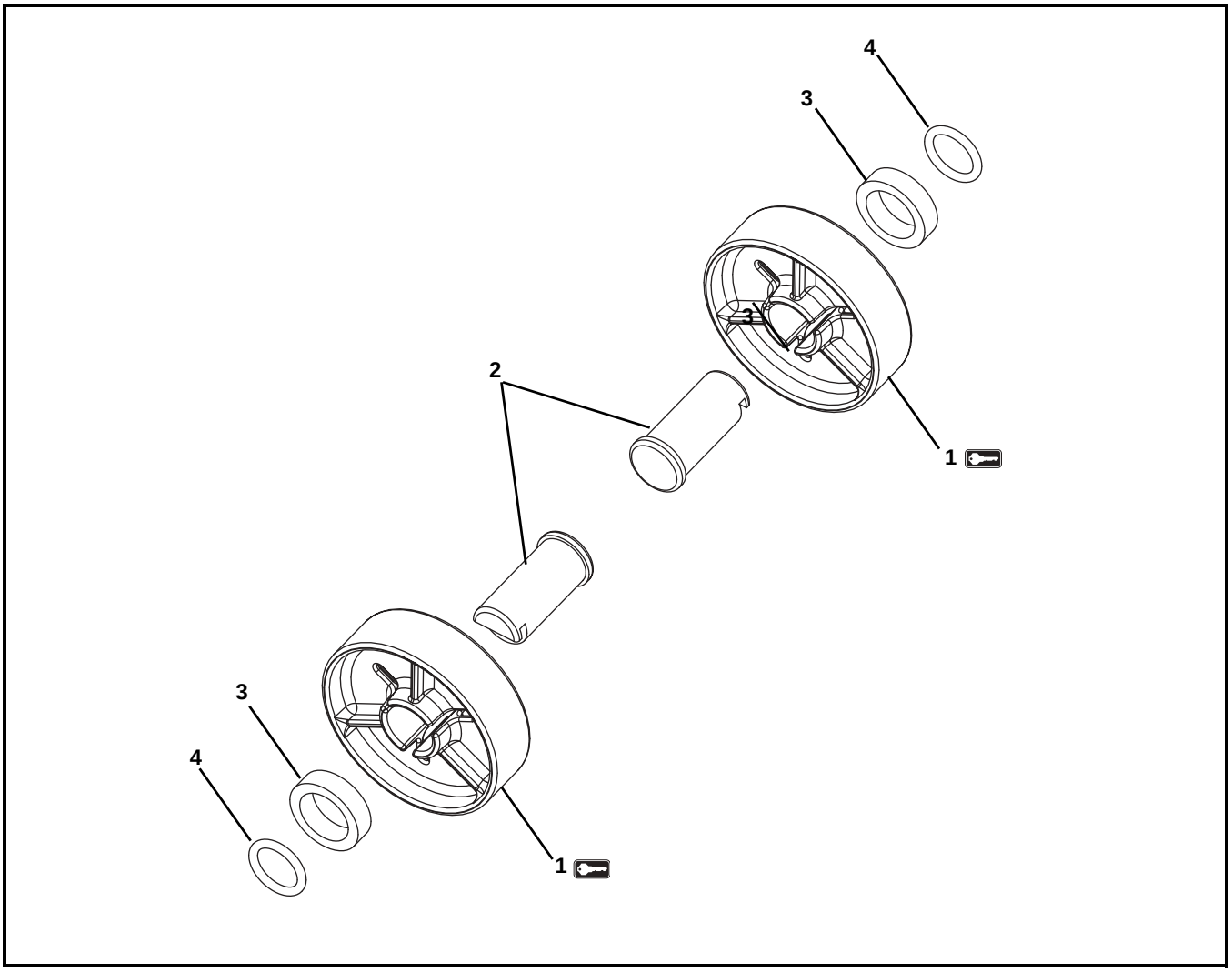
Service Parts

Belt Returns 660 mm Wide and Wider



Item	Part Number	Description
1	530177-WWWW-M	Return Shaft
2	506296	Puck
3	517575	Retaining Plate
WWWW = Conveyor width reference in mm 0660 - 1219		
See Specifications chart on page 8 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Belt Returns Under 660 mm Wide



Item	Part Number	Description
1	506296	Puck
2	501097	Shaft
3	530273	Spacer
4	812-107	O-Ring
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

Configuring Conveyor Belt Part Number

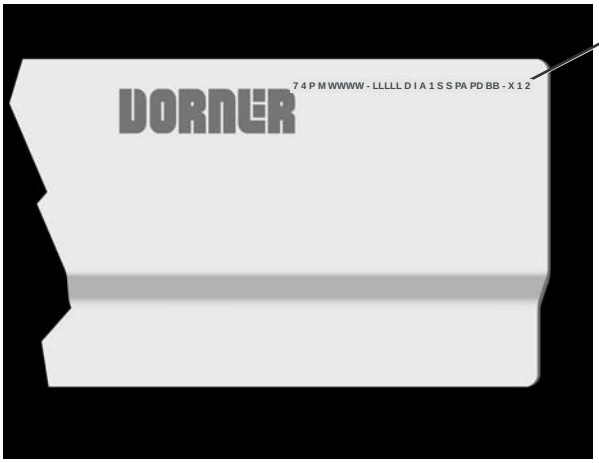


Figure 81

Flat Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 81)**. From the model number determine the conveyor width (WWWW), length (LLLLL) and belt type (BB). Use data to configure belt part number as indicated below.

76P1-WWWW-LLLLL / BB

76P1- _____ **-** _____ **/** ___

(Fill In)

Notes

Return Policy

Returns must have prior written factory authorization or they will not be accepted. Items that are returned to Dorner without authorization will not be credited nor returned to the original sender. When calling for authorization, please have the following information ready for the Dorner factory representative or your local distributor:

1. Name and address of customer.
2. Dorner part number(s) of item(s) being returned.
3. Reason for return.
4. Customer's original order number used when ordering the item(s).
5. Dorner or distributor invoice number. Include part serial number if available.

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

<table>
<tr><th></th><th colspan="9">Product Type</th></tr>
<tr><th></th><th colspan="8">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 & Spec. Fabric</th><th>Spare Belts - Plastic Chain</th><th>All equipment and parts</th></tr>
<tr><td>1100 Series</td><td colspan="6" rowspan="7">30% return fee for all products except:
50% return fee for conveyors with modular belt, cleated belt or speciality belts

All Electrical items are assigned original manufacturers return policy.</td><td colspan="2" rowspan="13">non-returnable</td><td rowspan="13">case-by-case</td></tr>
<tr><td>2200 Series</td></tr>
<tr><td>3200 Series</td></tr>
<tr><td>Pallet Systems</td></tr>
<tr><td>FlexMove/SmartFlex</td></tr>
<tr><td>GAL Series</td></tr>
<tr><td>All Electrical</td></tr>
<tr><td>7100 Series</td><td colspan="6" rowspan="4">50% return fee for all products</td></tr>
<tr><td>7200/7300 Series</td></tr>
<tr><td>AquaGard 7350 Series Version 2</td></tr>
<tr><td>GES Series</td></tr>
<tr><td>AquaGard 7350/7360 Series</td><td colspan="8" rowspan="2">non-returnable</td></tr>
<tr><td>AquaPruf Series</td></tr>
</table>

Returns will not be accepted after 60 days from original invoice date. The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components to inventory. If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Customer Service Team will gladly help with your questions on Dorner products.

For a copy of Dorner's Warranty, contact Dorner, an authorized sales channel or visit our website: www.dorner.com.

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

www.dorner.com

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