ERT® 150 Conveyor

Installation, Maintenance & Parts Manual

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

Record Conveyor Serial Number Here

851-960 Rev. A

Table of Contents

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.

Warnings – General Safety

⚠ WARNING

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

⚠ DANGER

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

⚠ DANGER

DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

⚠ WARNING

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

⚠ WARNING

Gearmotors may be HOT.

DO NOT TOUCH Gearmotors.

⚠ WARNING

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

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

⚠ WARNING

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

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

Product Description

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

1	Conveyor
2	Gearmotor
3	Controller
4	Support Stand

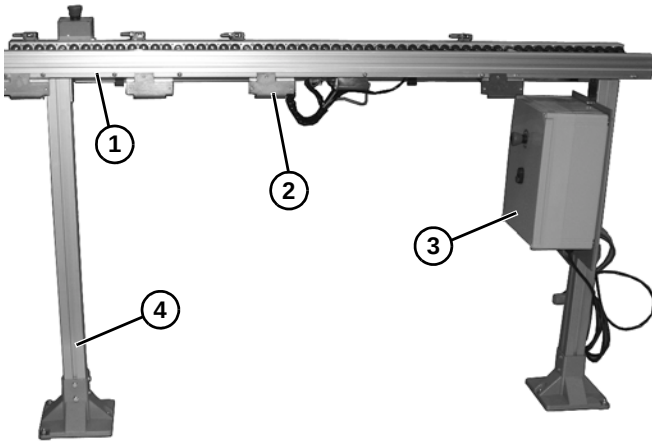


Figure 1

Specifications

Models:

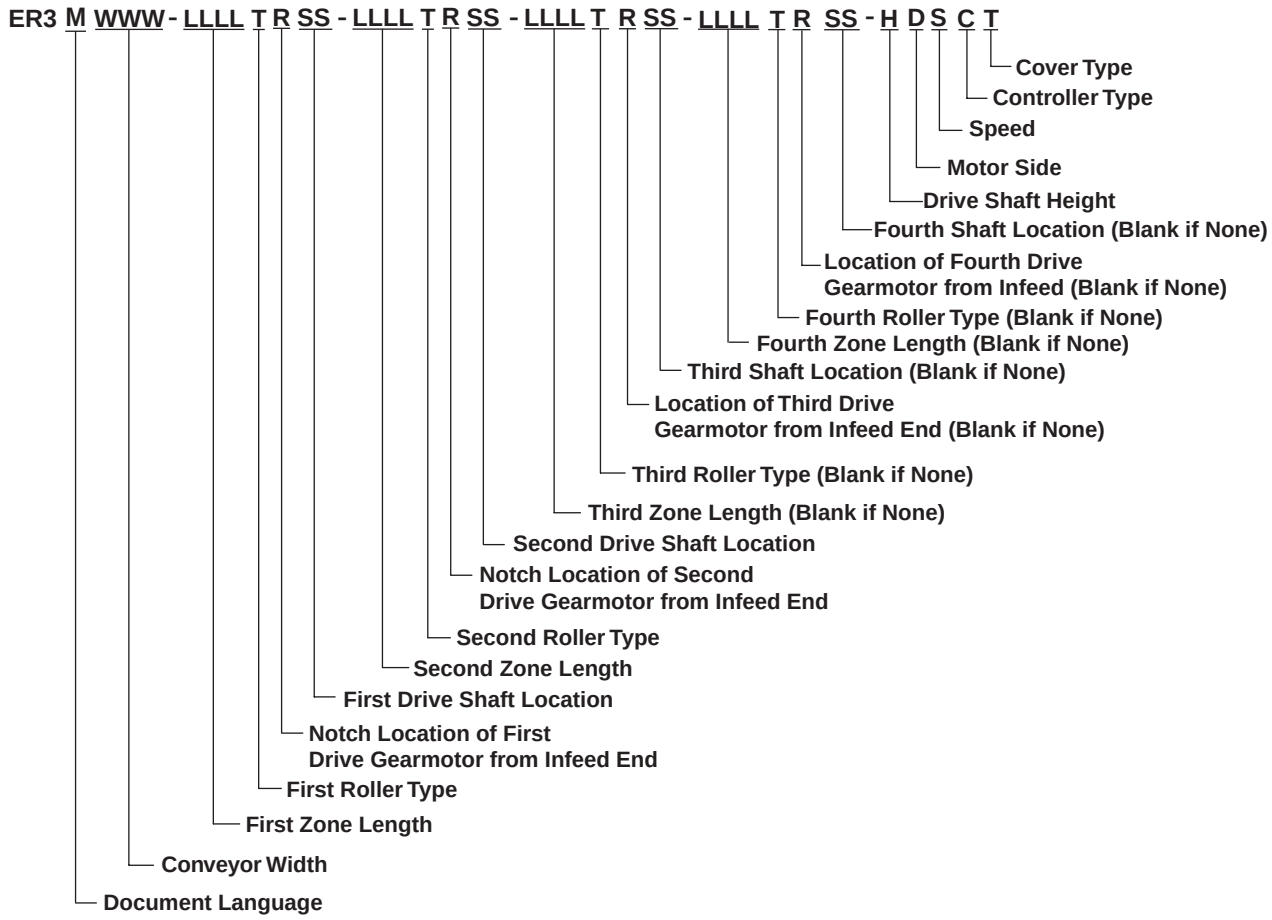
Single Zone Conveyor

ER3 M WWW - LLLL T R SS R SS - H D S C T

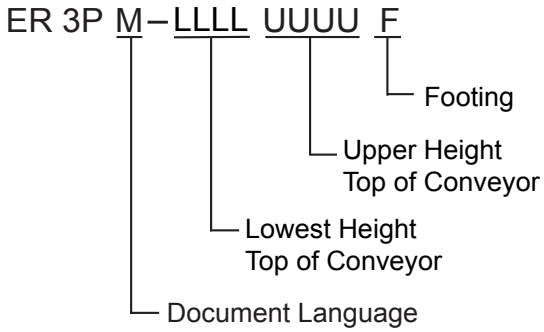
- **Cover Type**
- **Controller Type**
- **Speed**
- **Motor Side**
- **Drive Shaft Height**
- **Second Drive Shaft Location (Blank if None)**
- **Location of Second Drive Gearmotor from Split (Blank if None)**
- **First Drive Shaft Location**
- **Location of First Drive Gearmotor from Infeed End**
- **Roller Type**
- **Conveyor Length**
- **Conveyor Width**
- **Document Language**

Specifications

Multiple Zone Conveyor



Support Stands



Conveyor Supports:

Maximum Distances:

1 = 457 mm (18")

2 = 2400 mm (95")

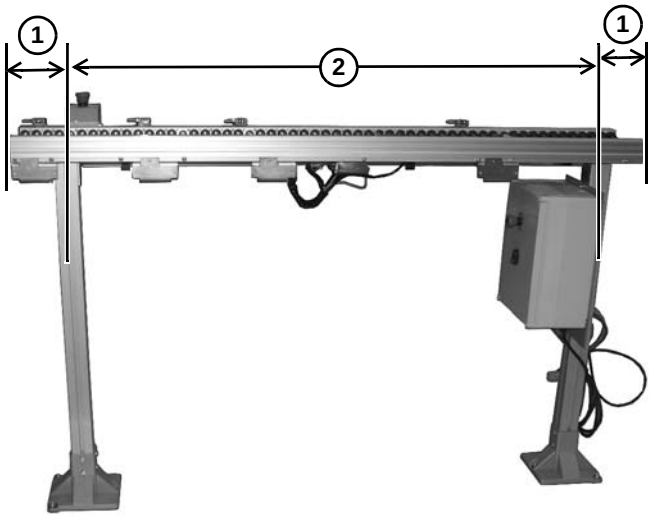


Figure 2

Specifications

Conveyor Width Reference (WWW)	80	120	160	200	240	280	320	360	400	440	480
Conveyor Width	80 mm (3.15")	120 mm (4.72")	160 mm (6.30")	200 mm (7.87")	240 mm (9.45")	280 mm (11.02")	320 mm (12.60")	360 mm (14.17")	400 mm (15.75")	440 mm (17.32")	480 mm (18.9")
Maximum Load	16 Kg (35 lbs) per pallet, 7 Kg (15 lbs) per roller in contact with pallet										
Maximum Speed	37 M/min (121 ft/min)										
Conveyor Length Reference	0128 - 2432 in 0064 increments										
Conveyor Length	128 mm - 2432 mm (5.04" - 95.75") in 64 mm (2.56") increments										

Specifications

Table 1: Gearmotor Specifications

Item	Standard Load Gearmotors
Output Power	50 watt
Input Voltage	24 VDC
Input Currents	2.5 amp Running 3.0 amp Starting
Gearmotor Ratio	See Below
Protection Rating	IP 54 ingress rating

Table 2: Pallet Speed for Standard Load Fixed Speed Gearmotors

Part Number	RPM (Nominal)	N-m	In-Lb	Pallet Speed	
				M/min	Ft/min
826-984	10	4.4	39.1	1 - 10	3.4 - 34
826-985	15	3.0	26.2	1.5 - 15	5.0 - 50
826-986	20	2.2	19.2	2.1 - 21	6.9 - 69
826-987	25	1.8	15.7	2.6 - 26	8.4 - 84
826-988	37	1.2	10.6	3.8 - 38	12.4 -124

Table 3: 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)

NOTE

Conveyor MUST be mounted straight, flat and level within confines of conveyor. Use a level for setup.

Required Tools

- 4 mm Hex Wrench
- 5 mm Hex Wrench
- 6 mm Hex Wrench
- 13 mm Wrench
- Small Pick

Recommended Installation Sequence

- Attach conveyor to stands

Attach Conveyor to Stands

NOTE

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

1. Install support bracket **(Figure 3, item 1)** onto leg **(Figure 3, item 2)** with two bolts **(Figure 3, item 3)** and slide-in nuts.

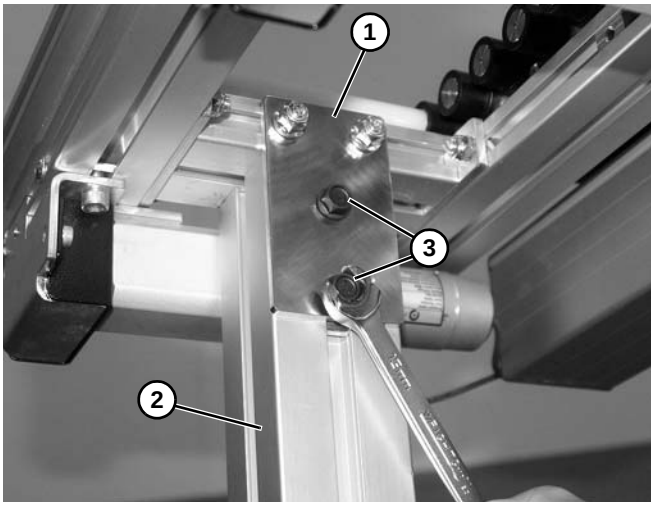


Figure 3

2. Insert two T-bolts into horizontal stand channel, and secure bracket **(Figure 4, item 1)** to conveyor **(Figure 4, item 2)** with two nuts **(Figure 4, item 3)**.

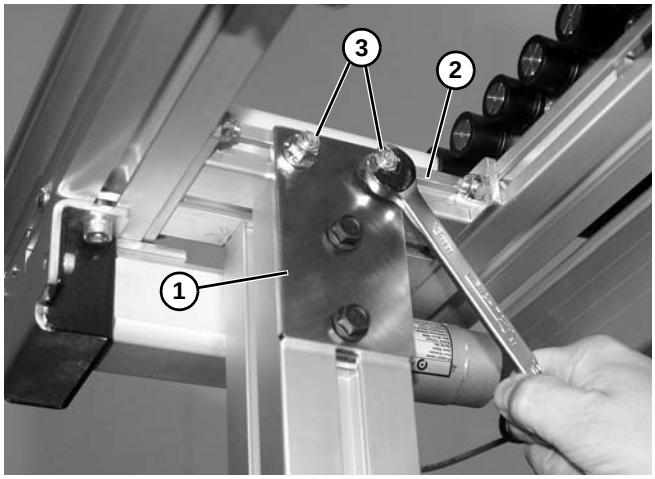


Figure 4

NOTE

*Be certain that slots **(Figure 5, item 1)** on each T-bolt is close to vertical when finished tightening nut.*

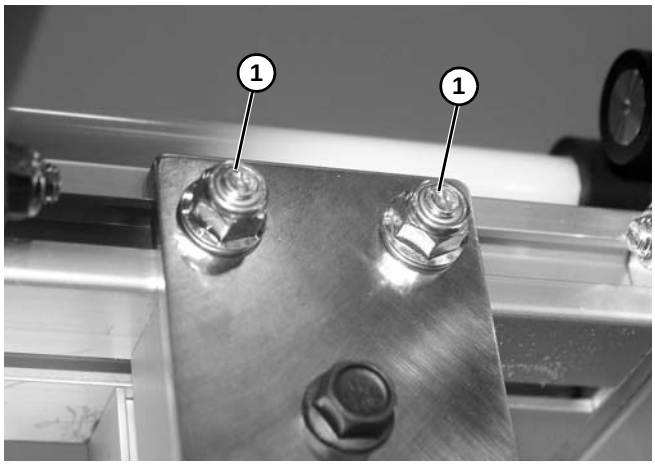


Figure 5

3. Repeat for remaining stands.

Installation and Adjustment

Connecting Multiple Frame Sections

1. Arrange conveyor sections in proper order.
2. Join conveyor frames **(Figure 6, item 1)** and install conveyor tie brackets **(Figure 6, item 2)** in bottom slots **(Figure 6, item 3)** on both sides of the conveyor.

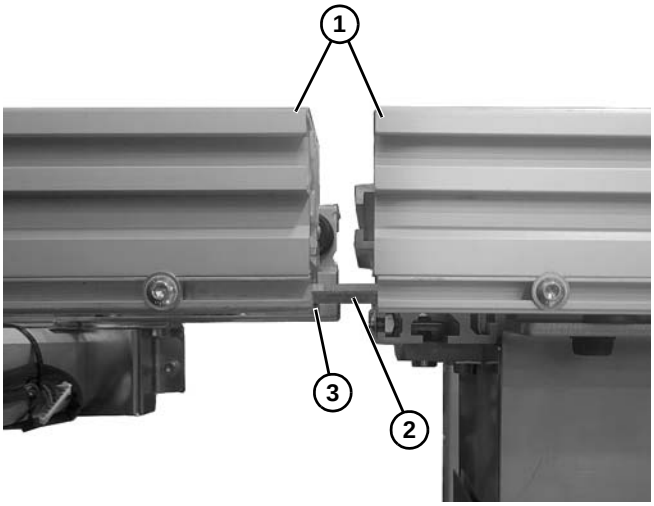


Figure 6

3. Secure tie brackets with screws **(Figure 7, item 1)**.

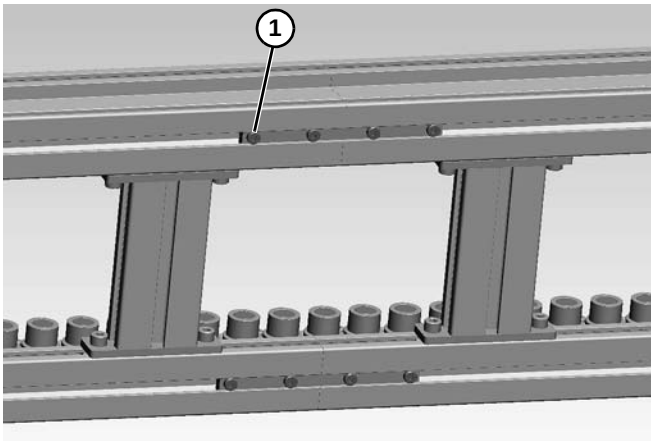


Figure 7

Drive Shaft Relocation (If Needed)

1. Remove drive shaft. (See “Drive Shaft Roller” on page 14.)
2. Remove rollers at new drive shaft location. (See “Roller Replacement” on page 13.)
3. Replace components in reverse order of removal.

Adjust Stands

⚠ 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.

1. Support the conveyor.
2. Loosen four screws **(Figure 8, item 1)** on conveyor foot assembly.

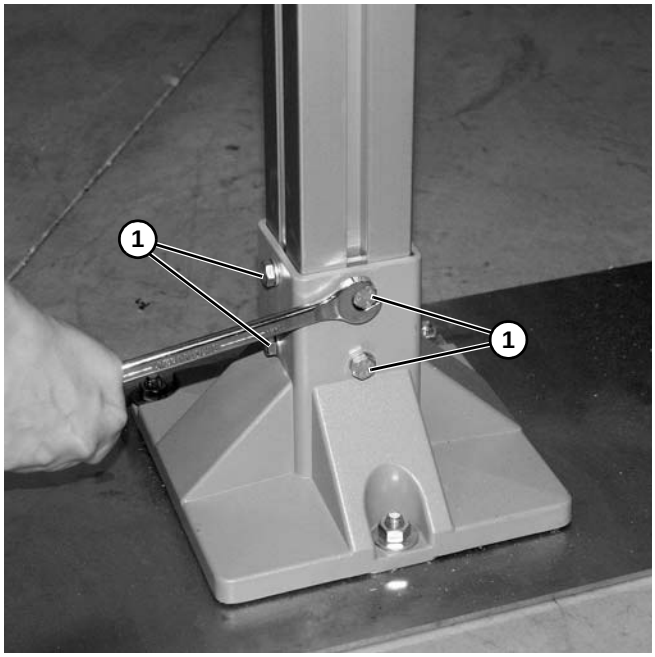


Figure 8

3. Raise or lower stand leg.

⚠ WARNING

Failure to secure screws may cause conveyor sections to drop down causing severe injury.
TIGHTEN SCREWS AFTER ADJUSTMENT.

4. Making sure conveyor is level **(Figure 9)**, tighten all four screws.

Figure 9

Conveyor Startup

1. See ERT Wiring and Control Installation, Programming and Parts Manual **851-927**.

Required Tools

- 2 mm Hex Wrench
- 3 mm Hex Wrench
- 4 mm Hex Wrench
- 5 mm Hex Wrench
- 6 mm Hex Wrench
- 13 mm Wrench
- Torx Head Wrench
- Small Punch
- Pliers
- No-Mar Hammer
- Sprocket Removal Tool (Dorner Part number 400571)

Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Clean entire conveyor while disassembled
- Replace worn or damaged parts

Lubrication

No lubrication is required. Replace roller assemblies if worn.

Side Cover Removal and Installation

1. Remove screws **(Figure 10, item 1)** holding side cover **(Figure 10, item 2)**. onto conveyor frame.

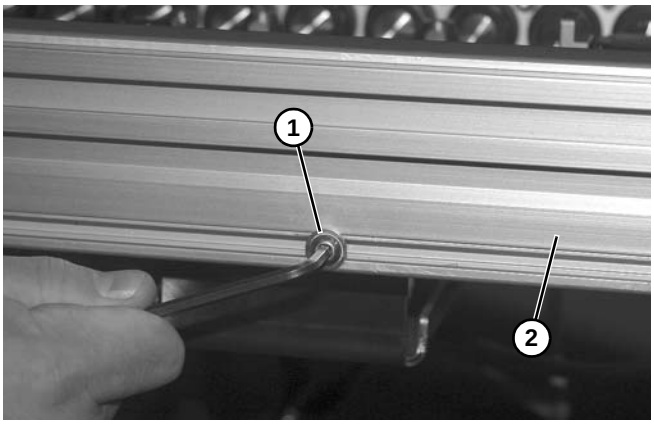


Figure 10

2. Rotate and remove side cover **(Figure 11, item 1)** from conveyor frame

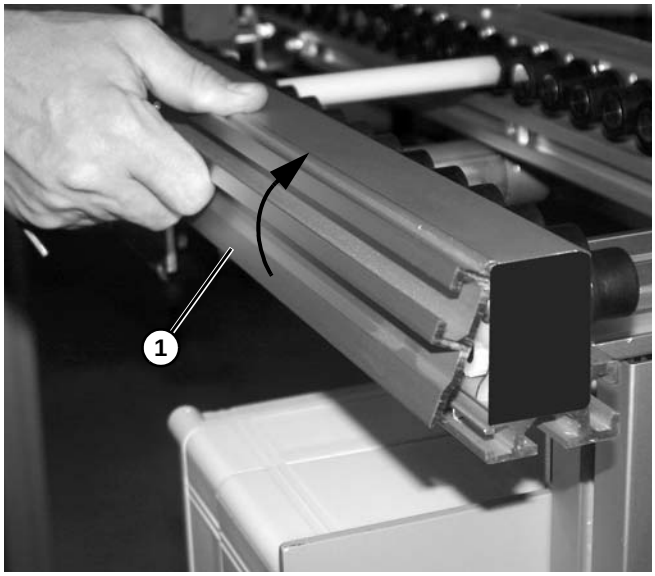


Figure 11

3. To install side cover **(Figure 12, item 1)**, place upper channel **(Figure 12, item 2)** of side cover into top flange of conveyor frame. Lower cover, mating lower flange **(Figure 12, item 2)** of side cover into lower channel of conveyor frame.

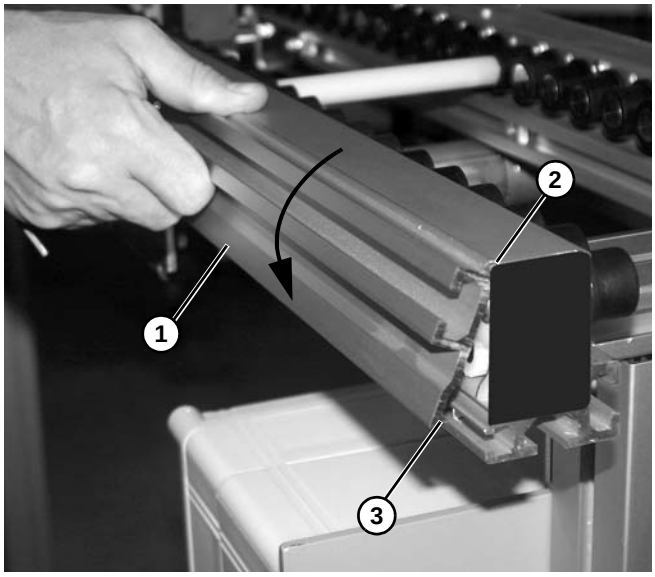


Figure 12

4. Secure cover with screws **(Figure 13, item 1)**.

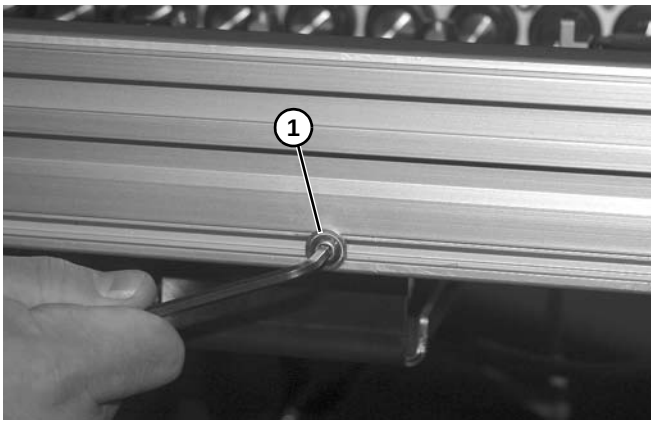


Figure 13

5. Tighten screws securing cover, making sure the cover is fully seated onto channel of conveyor frame. (See **(Figure 14)** for example of correct installation.)

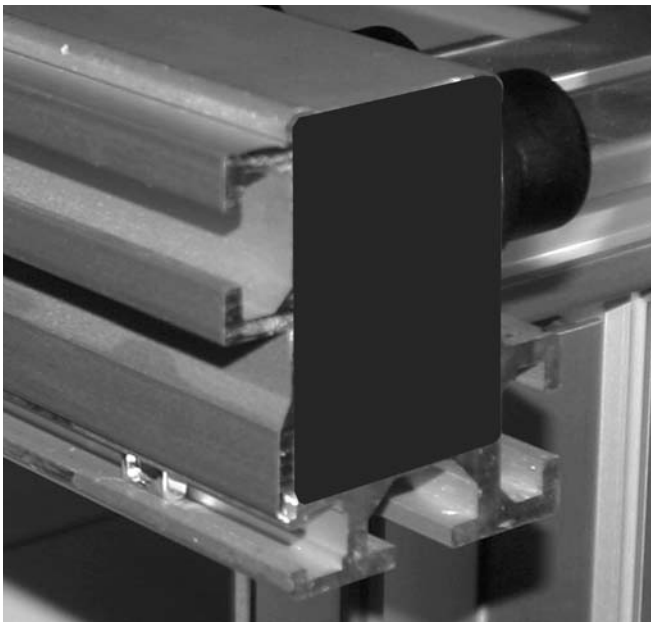


Figure 14

Roller Replacement

Driven or Slip Roller

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 12.)
2. Install sprocket removal tool, part number 400571 **(Figure 15, item 1)** between gears.

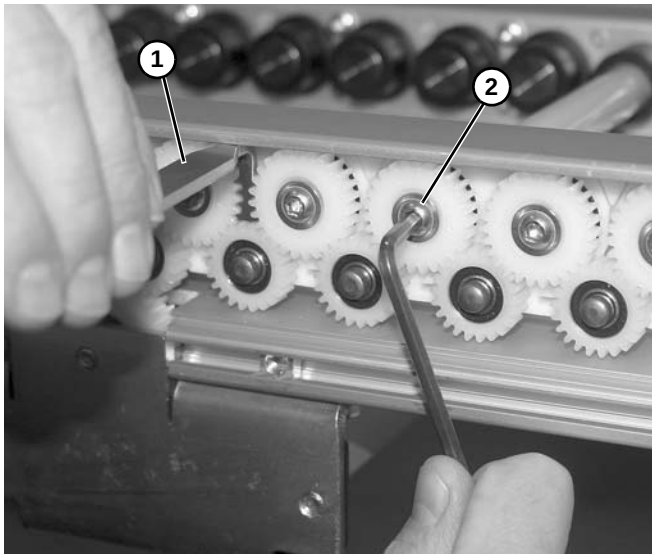


Figure 15

3. Remove screw **(Figure 15, item 2)** holding gear onto roller shaft.
4. Use a small pick **(Figure 16, item 1)** to pry gear **(Figure 16, item 2)** from roller shaft. Make note of the notches **(Figure 16, item 3)** in the gear and roller shaft.

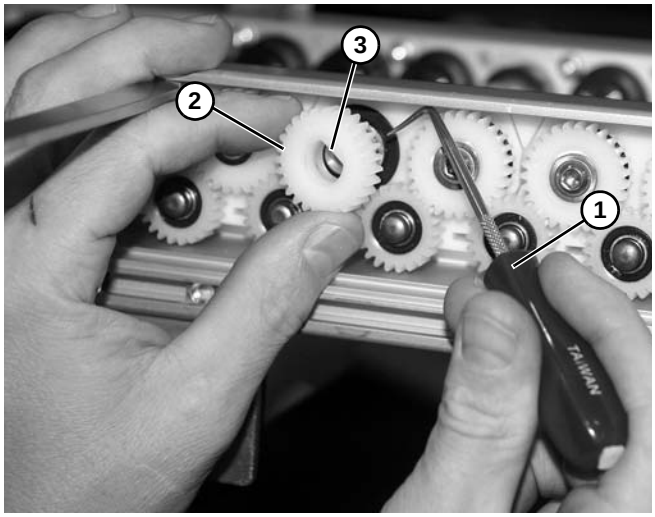


Figure 16

NOTE

*Keep strict attention to roller type. To differentiate and correctly install the two different style rollers: Driven rollers have a dot **(Figure 17, item 1)** in the center, and slip rollers **(Figure 17, item 2)** do not.*

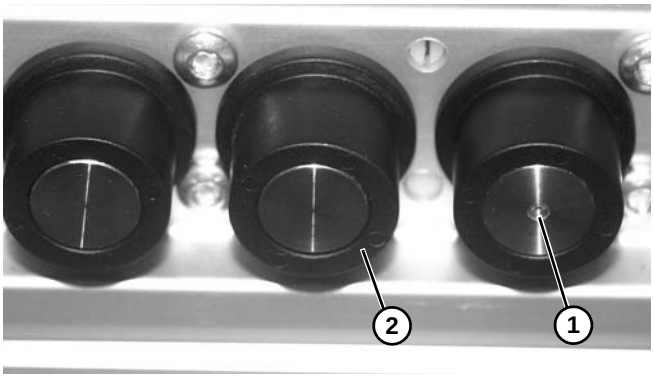


Figure 17

5. Remove roller assembly **(Figure 18, item 1)** from the conveyor frame.

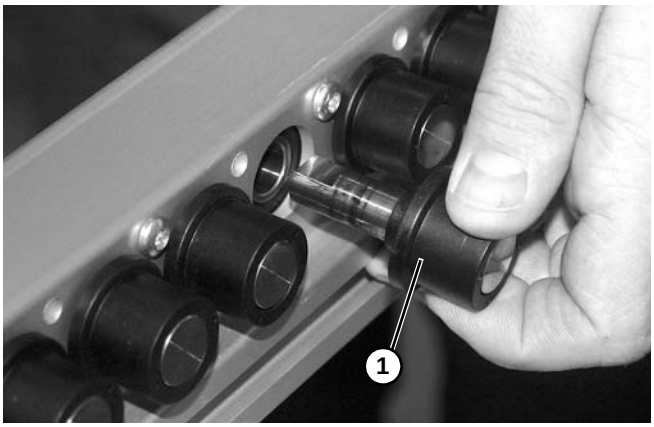


Figure 18

6. Remove roller **(Figure 19, item 1)** from roller shaft **(Figure 19, item 2)**. Note: If driven roller, roller will be fixed to shaft.

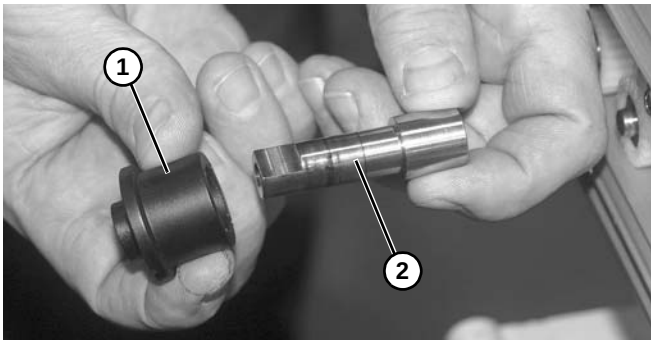


Figure 19

7. Install new roller components in reverse order of removal.

NOTE

*Keep strict attention to roller type. To differentiate and correctly install the two different style rollers: Driven rollers have a dot **(Figure 20, item 1)** in the center, and slip rollers **(Figure 20, item 2)** do not.*

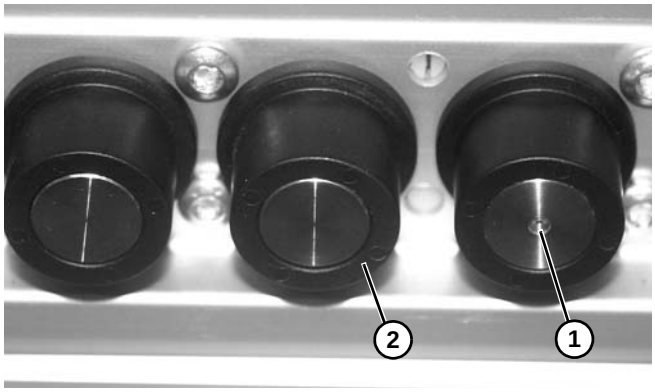


Figure 20

Drive Shaft Roller

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 12.)
2. Determine which slip bearing rollers next to the fixed bearing roller you are replacing. (See "Driven or Slip Roller" on page 13 to differentiate the different types of rollers.)
3. Before removing gear verify the location of the correct bearing housing assembly **(Figure 21, item 1)** to remove.

NOTE

*You can verify each end of the bearing housing assembly **(Figure 21, item 1)** by noting the vertical edges **(Figure 21, item 2)**.*

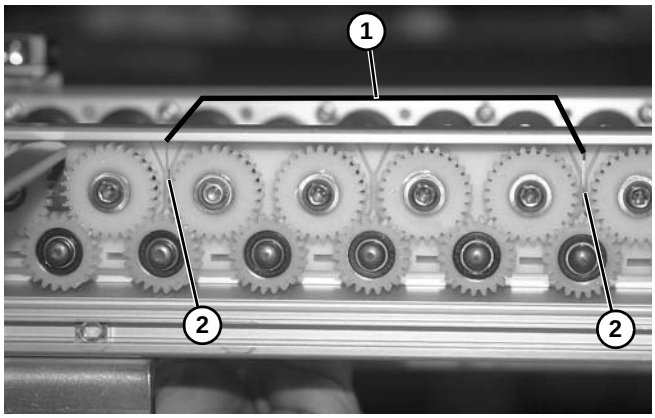


Figure 21

4. Install sprocket removal tool, part number 400571 **(Figure 22, item 1)** between gears.

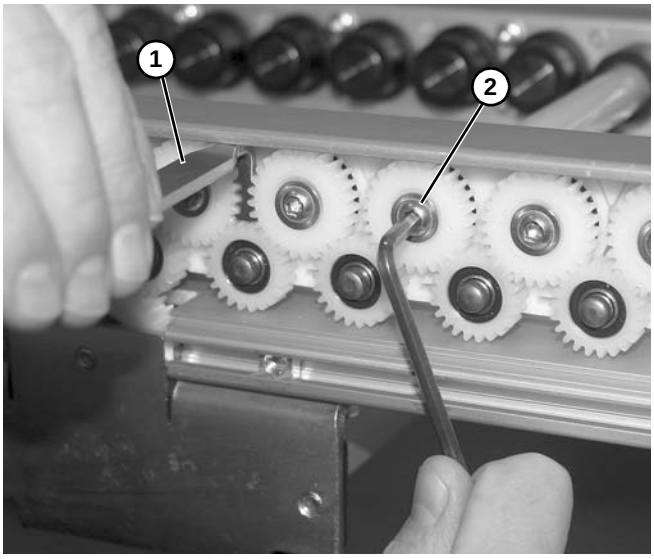


Figure 22

5. Remove screw **(Figure 22, item 2)** holding gear onto roller shaft.
6. Use a small pick **(Figure 23, item 1)** to pry gear **(Figure 23, item 2)** from roller shaft. Make note of the notches **(Figure 23, item 3)** in the gear and roller shaft. Repeat on opposite side of conveyor.

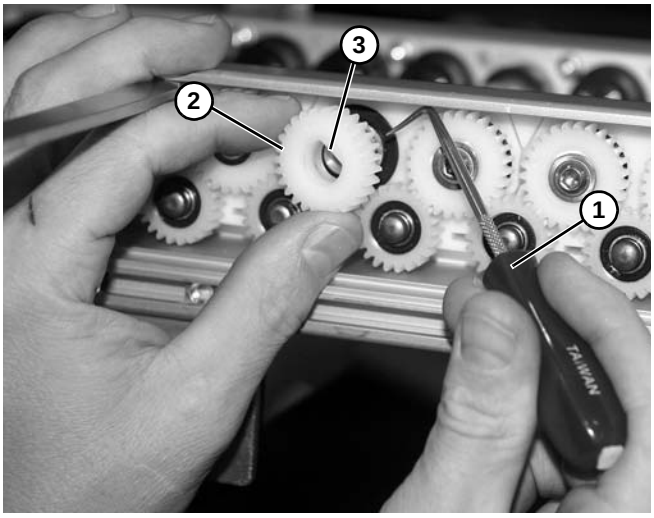


Figure 23

7. Repeat for removing remaining three gears **(Figure 24, item 1)** from three shafts **(Figure 24, item 2)** of bearing housing assembly.

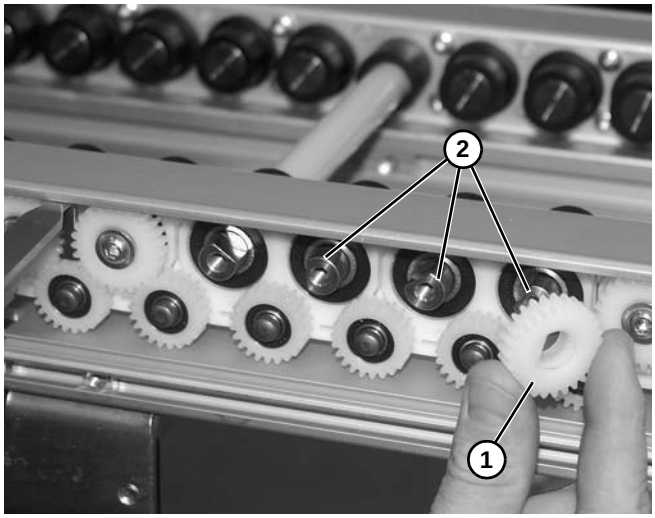


Figure 24

NOTE

*Keep strict attention to roller type. To differentiate and correctly install the two different style rollers: Driven rollers have a dot **(Figure 25, item 1)** in the center, and slip rollers **(Figure 25, item 2)** do not.*

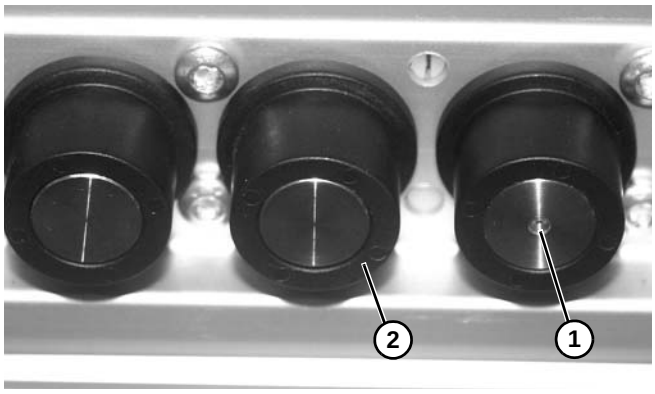


Figure 25

8. Remove roller assembly **(Figure 26, item 1)** from the conveyor frame.

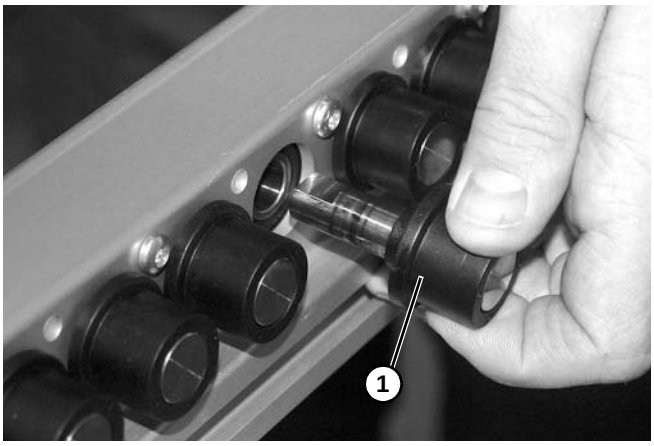


Figure 26

9. Remove roller **(Figure 27, item 1)** from roller shaft **(Figure 27, item 2)**. Note: If driven roller, roller will be fixed to shaft.

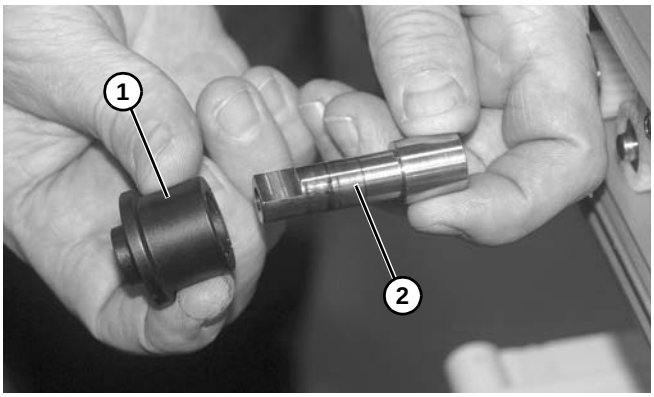


Figure 27

10. Repeat for remaining three roller assemblies.
11. Remove four screws **(Figure 28, item 1)** securing the bearing housing assembly to conveyor frame.

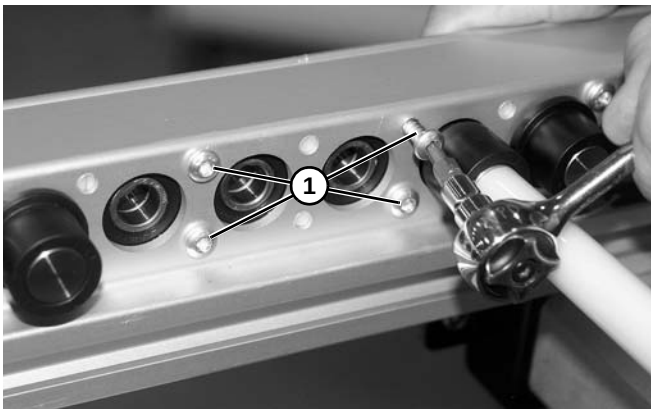


Figure 28

12. Remove the bearing housing assembly **(Figure 29, item 1)** from shaft assembly **(Figure 29, item 2)** and from the conveyor frame.

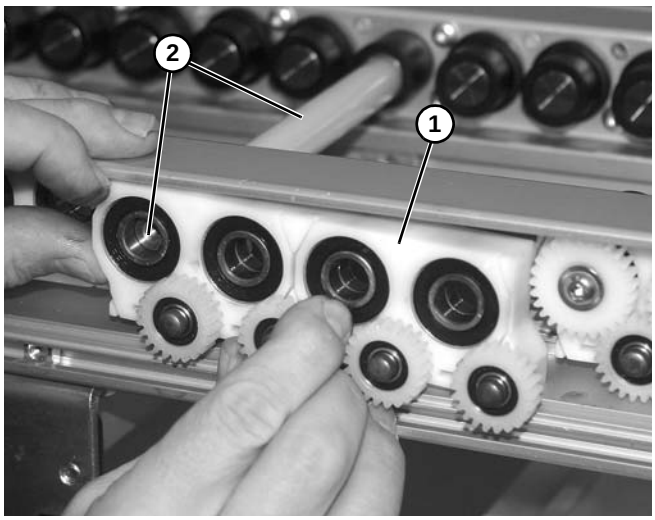


Figure 29

13. Start to push bushing and shaft assembly **(Figure 30, item 1)** through hole in conveyor frame **(Figure 30, item 2)**.

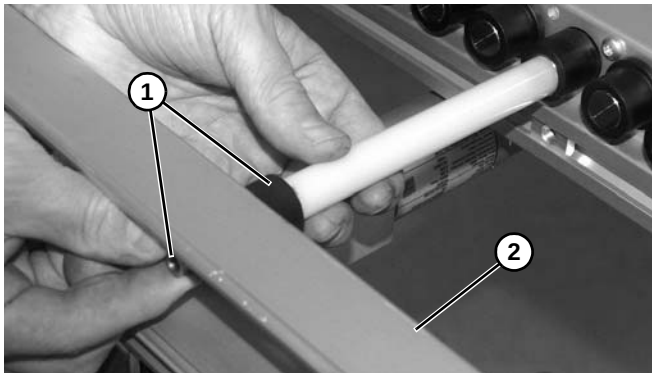


Figure 30

14. Pull shaft with shaft cover **(Figure 31, item 1)** through conveyor frame, and remove bushing and shaft assembly **(Figure 31, item 2)** from end of shaft.

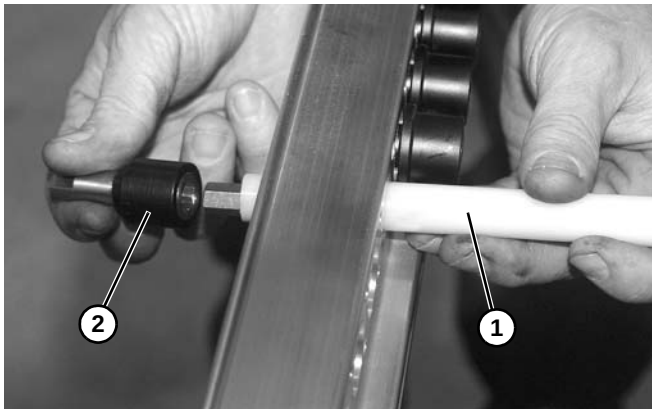


Figure 31

15. Remove shaft cover **(Figure 32, item 1)** and shaft **(Figure 32, item 2)** from the conveyor frame.

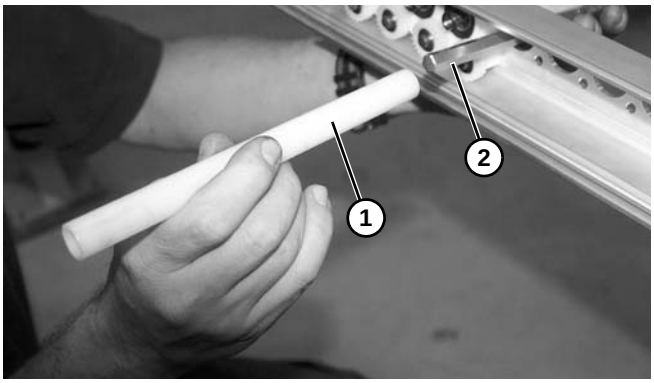


Figure 32

16. Replace components, as needed **(Figure 33)**.

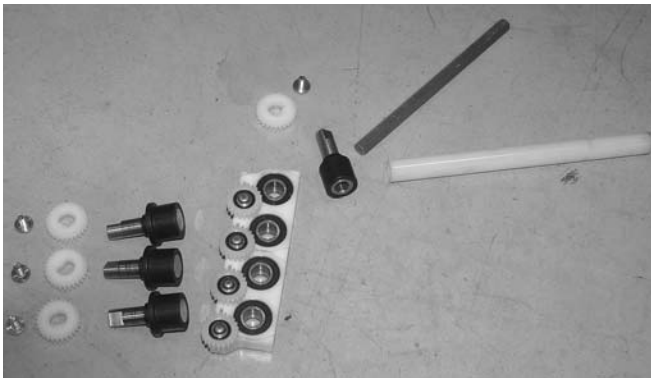


Figure 33

NOTE

*Keep strict attention to roller type. To differentiate and correctly install the two different style rollers: Driven rollers have a dot **(Figure 34, item 1)** in the center, and slip rollers **(Figure 34, item 2)** do not.*

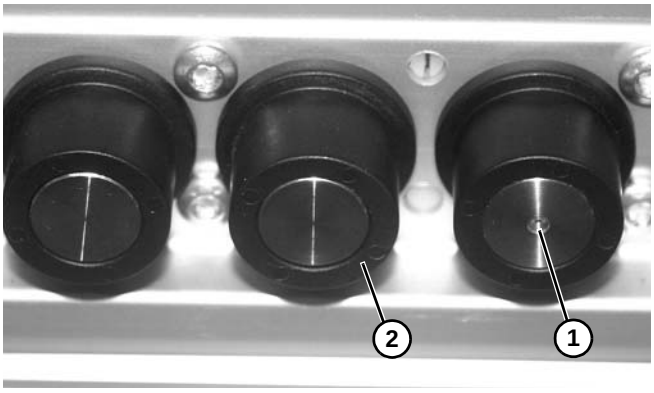


Figure 34

17. Install new roller components in reverse order of removal.

Gear Replacement

Upper Gear Replacement

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 12.)
2. Install sprocket removal tool, part number 400571 **(Figure 35, item 1)** between gears.

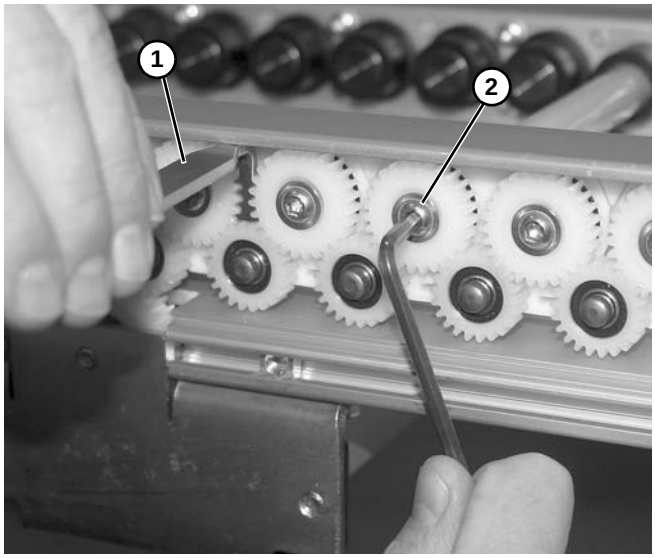


Figure 35

3. Remove screw **(Figure 35, item 2)** holding gear onto roller shaft.
4. Use a small pick **(Figure 36, item 1)** to pry gear **(Figure 36, item 2)** from roller shaft. Make note of the notches **(Figure 36, item 3)** in the gear and roller shaft.

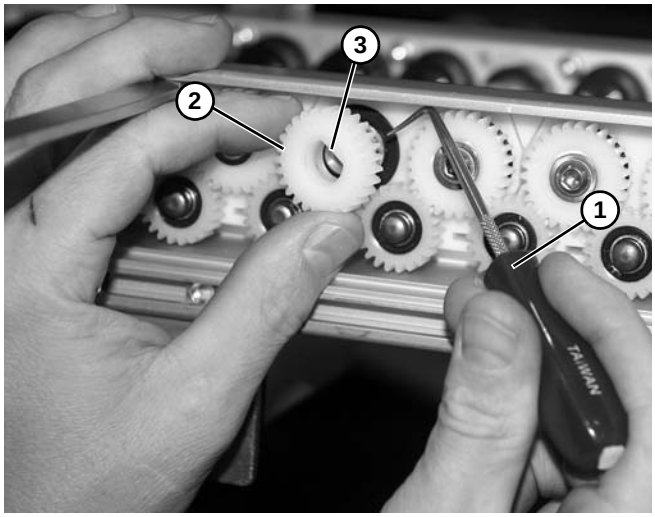


Figure 36

5. Install new gear in reverse order of removal.
6. Torque screw to 10 N-m (88 in-lbs).

Lower Gear Replacement

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 12.)
2. Before removing gear, verify the location of the correct bearing housing assembly **(Figure 37, item 1)** to remove.

> **NOTE**
>
> *You can verify each end of the bearing housing assembly **(Figure 37, item 1)** by noting the vertical edges **(Figure 37, item 2)**.*

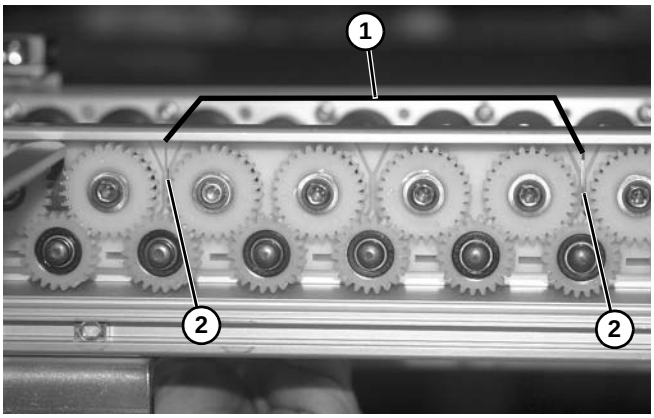


Figure 37

3. Install sprocket removal tool, part number 400571 **(Figure 38, item 1)** between gears.

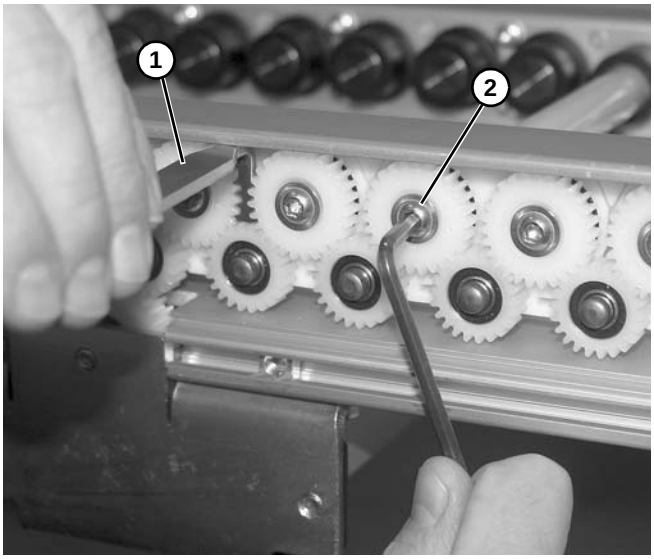


Figure 38

4. Remove screw **(Figure 38, item 2)** holding gear onto roller shaft.
5. Use a small pick **(Figure 39, item 1)** to pry gear **(Figure 39, item 2)** from roller shaft. Make note of the notches **(Figure 39, item 3)** in the gear and roller shaft.

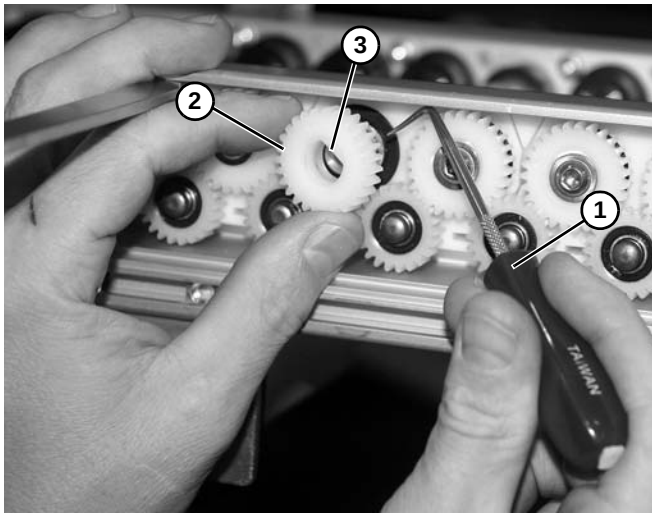


Figure 39

6. Repeat for removing remaining three gears **(Figure 40, item 1)** from three shafts **(Figure 40, item 2)** of bearing housing assembly.

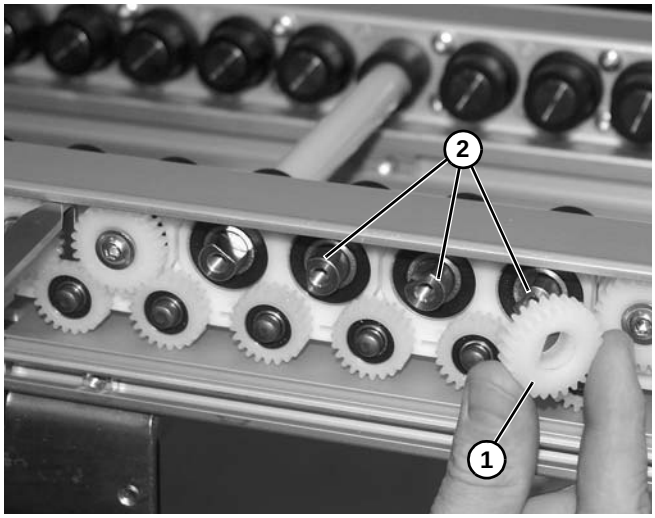


Figure 40

NOTE

*Keep strict attention to roller type. To differentiate and correctly install the two different style rollers: Driven rollers have a dot **(Figure 41, item 1)** in the center, and slip rollers **(Figure 41, item 2)** do not.*

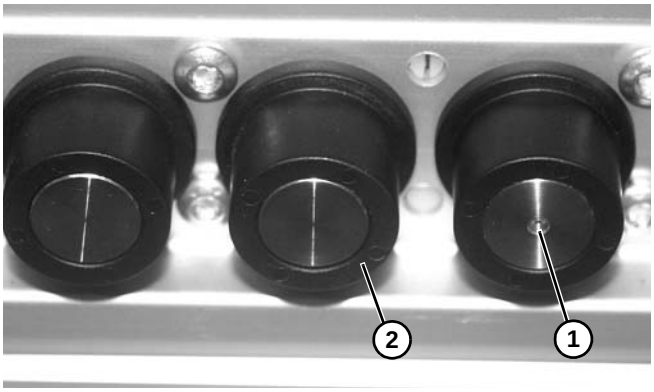


Figure 41

7. Remove roller assembly **(Figure 42, item 1)** from the conveyor frame.

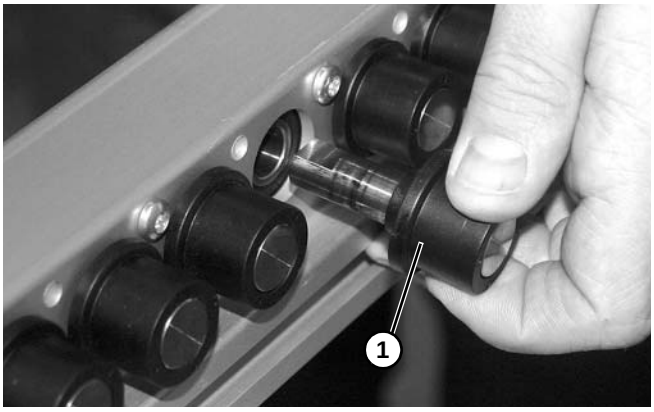


Figure 42

8. Repeat for remaining three roller assemblies.
9. Remove four screws **(Figure 43, item 1)** securing the bearing housing assembly to conveyor frame.

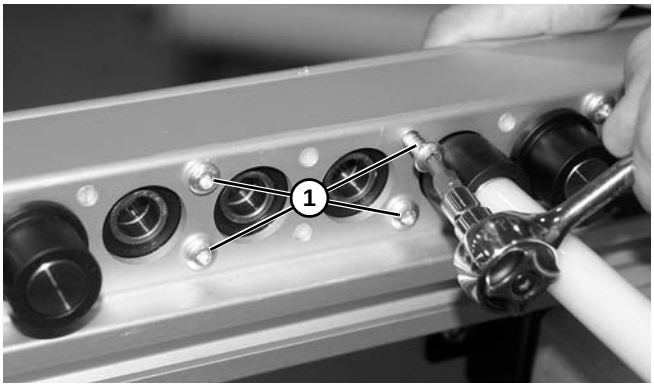


Figure 43

10. Remove the bearing housing assembly **(Figure 44, item 1)** from shaft assembly **(Figure 44, item 2)** and from the conveyor frame.

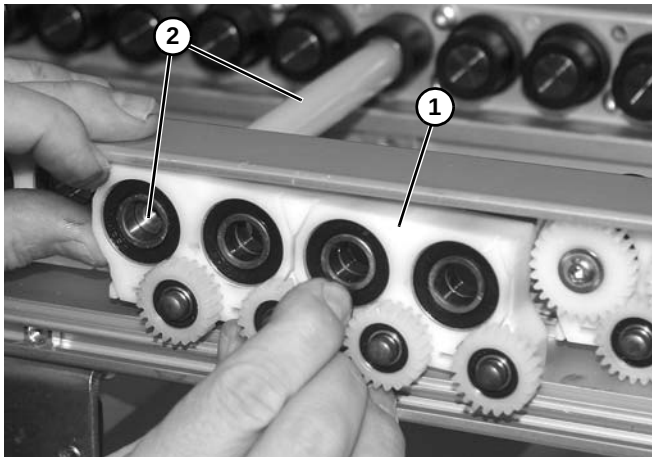


Figure 44

11. Place the bearing housing assembly **(Figure 45, item 1)** into a vice. Use a no-mar hammer and center punch **(Figure 45, item 2)** to remove gear from bearing assembly.

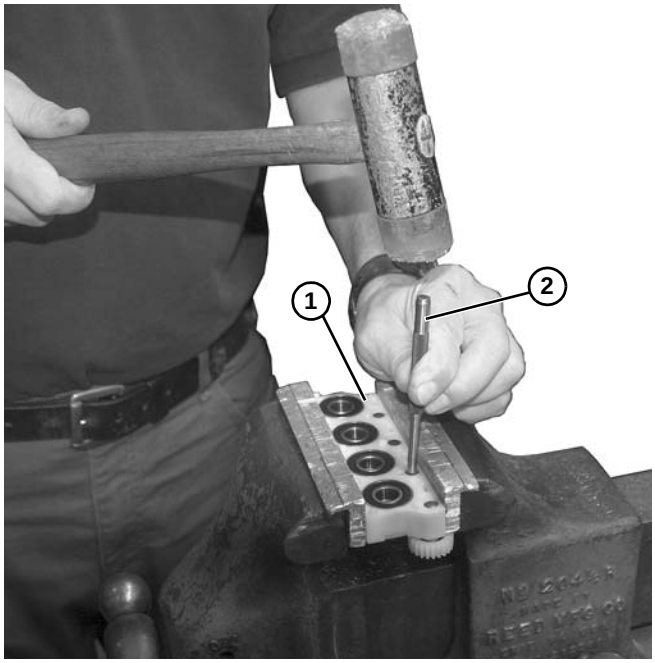


Figure 45

12. Continue using a no-mar hammer and center punch to push gear assembly **(Figure 46, item 1)** from bearing housing assembly **(Figure 46, item 2)**.

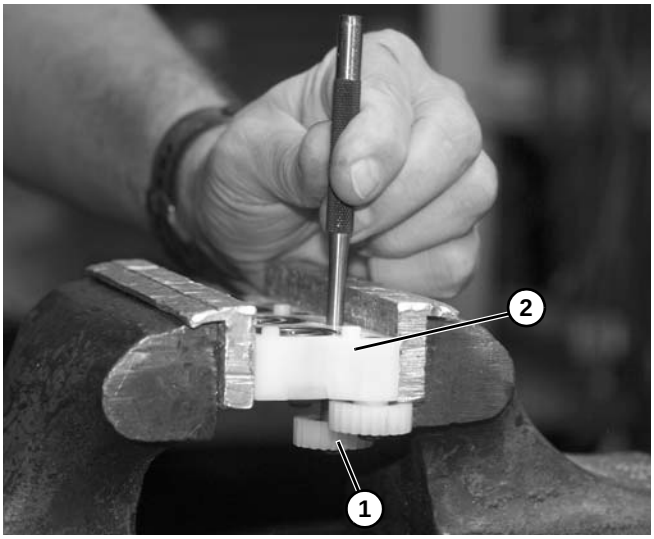


Figure 46

13. Remove gear assembly **(Figure 47, item 1)** from bearing housing assembly **(Figure 47, item 2)**.

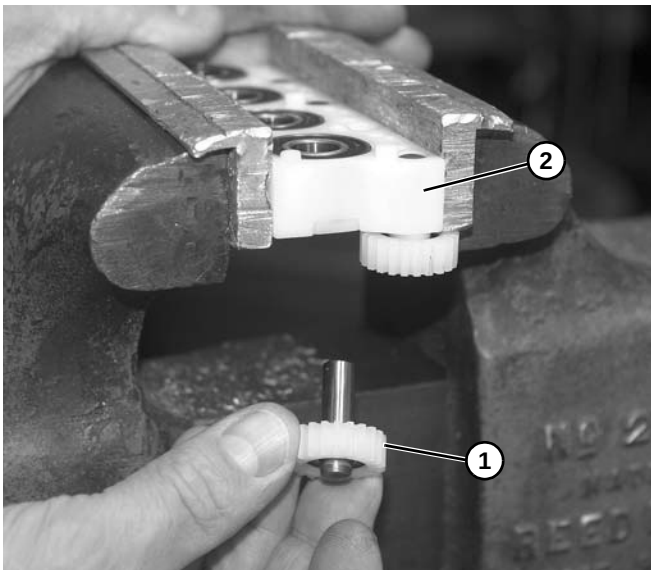


Figure 47

14. Install new pin and bearing assembly in reverse order of removal.

Motor Idler Gear Replacement

Inside Mounted Motor

⚠ WARNING

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

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 12.)
2. Remove screws **(Figure 48, item 1)** connecting the motor to the spring nuts **(Figure 48, item 2)** in the conveyor frame.

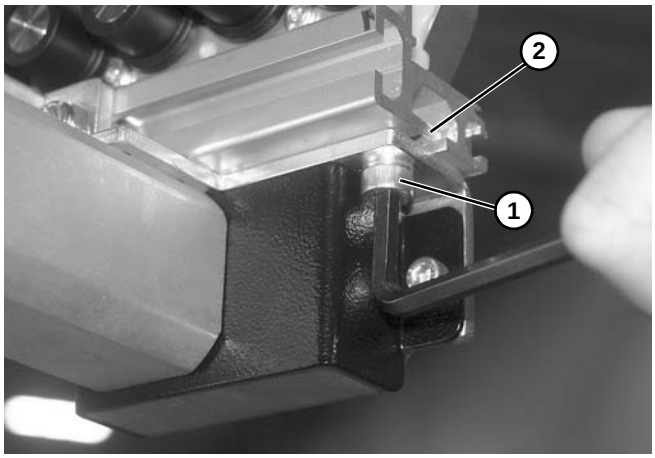


Figure 48

3. Lower and remove motor **(Figure 49, item 1)** from conveyor frame.

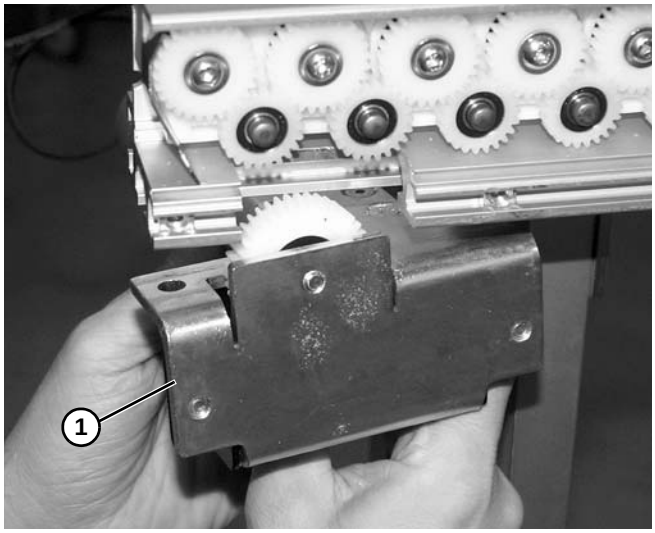


Figure 49

4. Remove flat head screw **(Figure 50, item 1)** holding idler gear **(Figure 50, item 2)** onto motor mounting bracket.

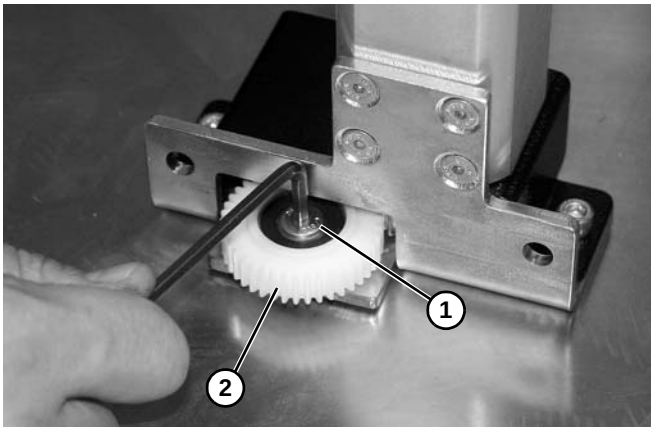


Figure 50

5. Remove spacer **(Figure 51, item 1)** from idler gear.

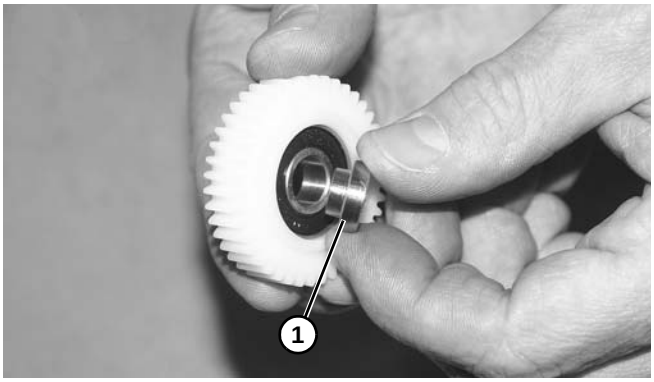


Figure 51

6. Install components in reverse order of removal. Tighten flat head screw to 12 Nm (106 in-lbs).

Outside Mounted Motor

⚠ WARNING

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

1. Remove side cover from conveyor. (See “Side Cover Removal and Installation” on page 12.)

2. Remove screws **(Figure 52, item 1)** connecting the motor to the spring nuts **(Figure 52, item 2)** in the conveyor frame.

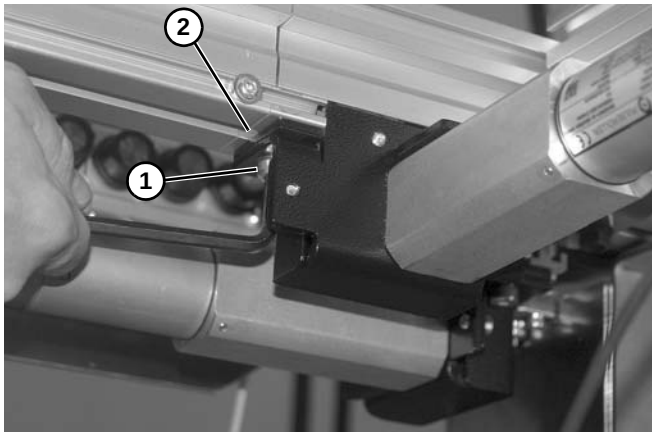


Figure 52

3. Lower and remove motor **(Figure 53, item 1)** from conveyor frame.

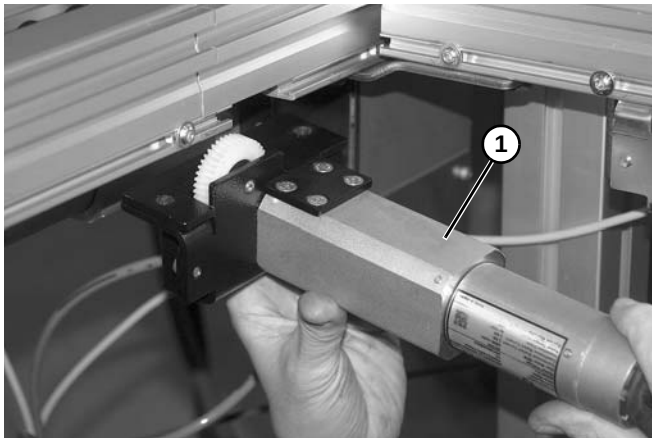


Figure 53

4. Remove flat head screw **(Figure 54, item 1)** holding idler gear **(Figure 54, item 2)** onto motor mounting bracket.

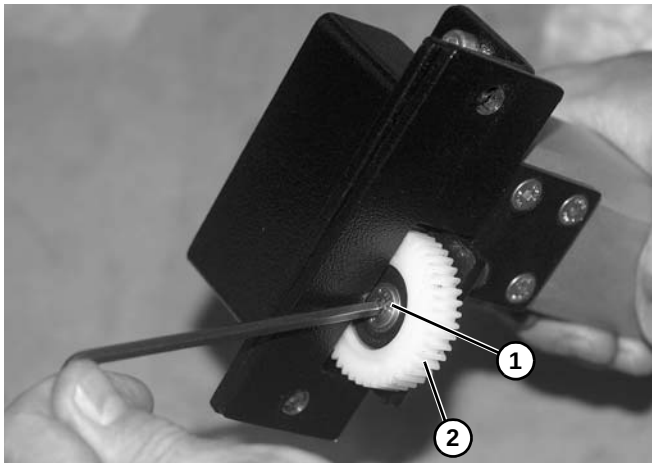


Figure 54

5. Remove spacer **(Figure 55, item 1)** from idler gear.

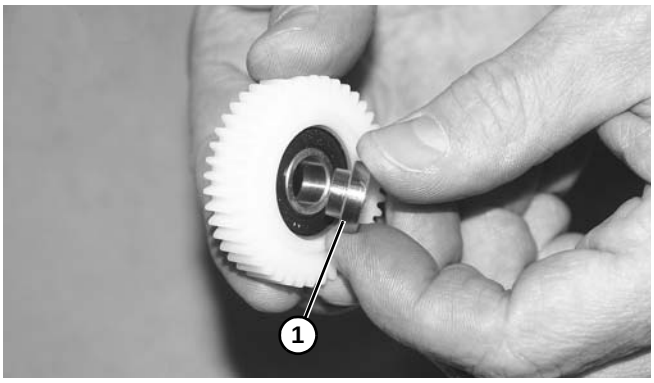


Figure 55

6. Install components in reverse order of removal. Tighten flat head screw to 12 Nm (106 in-lbs).

Motor Replacement

Inside Mounted Motor

⚠ WARNING

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

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 12.)
2. Remove screws **(Figure 56, item 1)** connecting the motor to the spring nuts **(Figure 56, item 2)** in the conveyor frame.

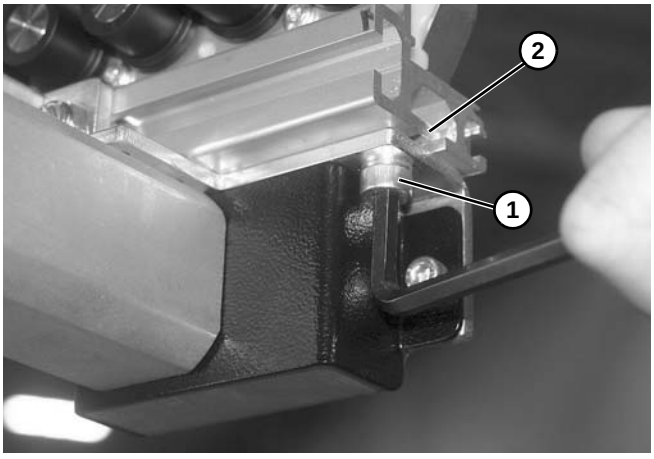


Figure 56

3. Lower and remove motor **(Figure 57, item 1)** from conveyor frame.

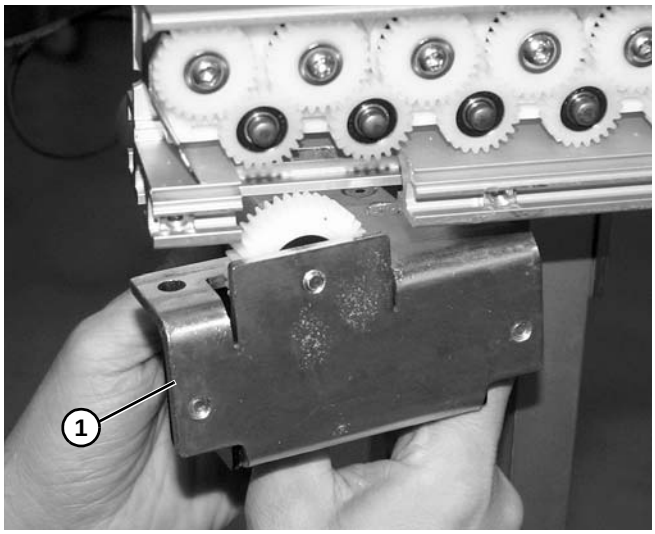


Figure 57

4. Remove two screws **(Figure 58, item 1)** holding drive cover **(Figure 58, item 2)** to motor mounting bracket.

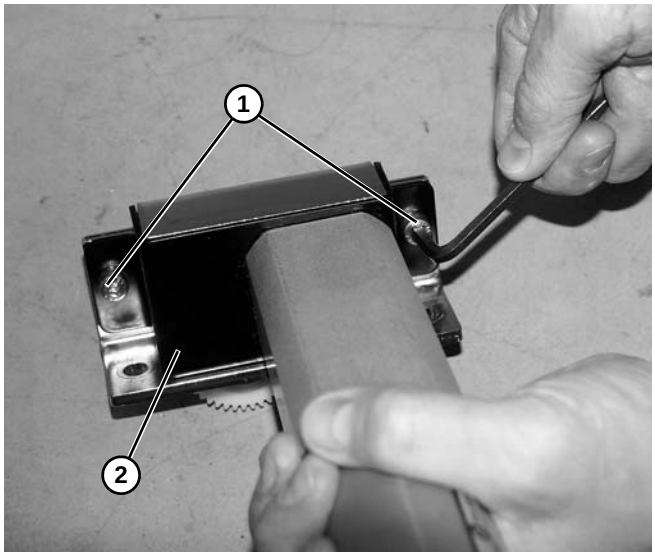


Figure 58

5. Remove the cover **(Figure 59, item 1)** from motor mounting bracket **(Figure 59, item 2)**.

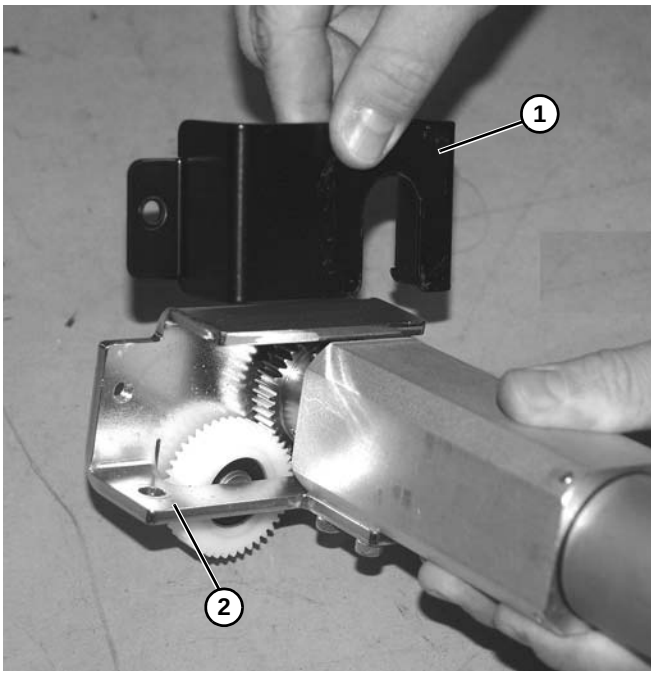


Figure 59

6. Remove four screws **(Figure 60, item 1)** and remove motor mounting bracket **(Figure 60, item 2)** from motor **(Figure 60, item 3)**.

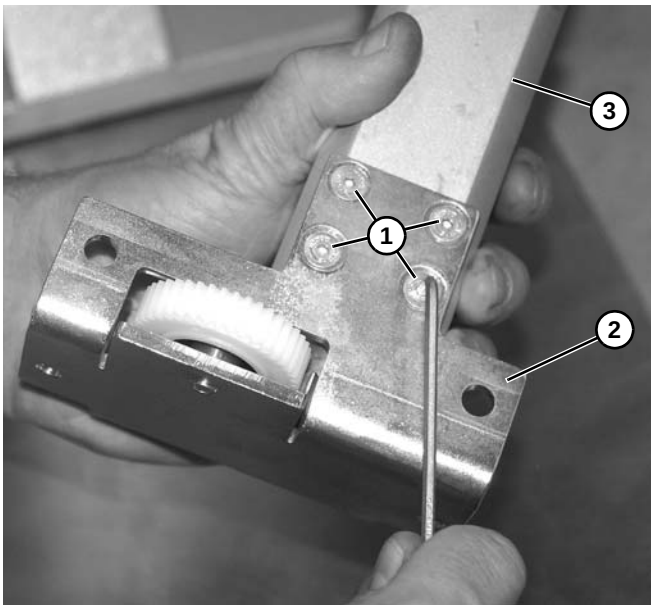


Figure 60

7. Loosen two set screws **(Figure 61, item 1)** on gear.

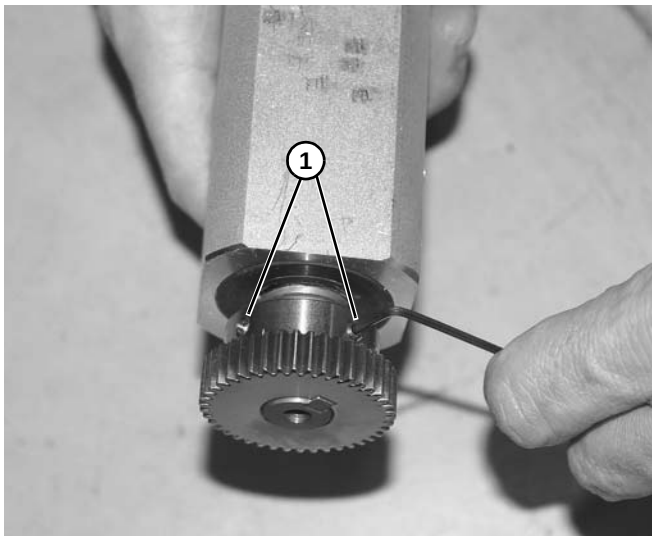


Figure 61

8. Remove gear **(Figure 62, item 1)** from motor shaft **(Figure 62, item 2)**.

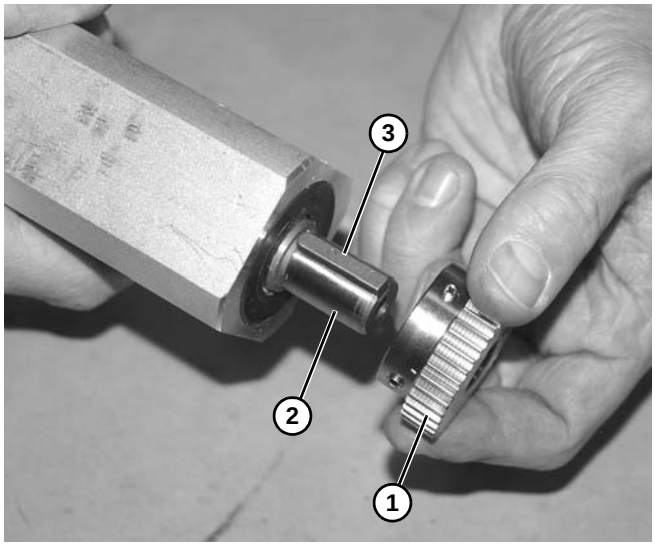


Figure 62

9. Remove key **(Figure 62, item 3)** from end of motor shaft.
10. Place key and gear onto new motor. Tighten set screws to 4 Nm (35 in-lbs).
11. Install remaining components in reverse order of removal.

Outside Mounted Motor

⚠ WARNING

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

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 12.)
2. Remove screws **(Figure 63, item 1)** connecting the motor to the spring nuts **(Figure 63, item 2)** in the conveyor frame.

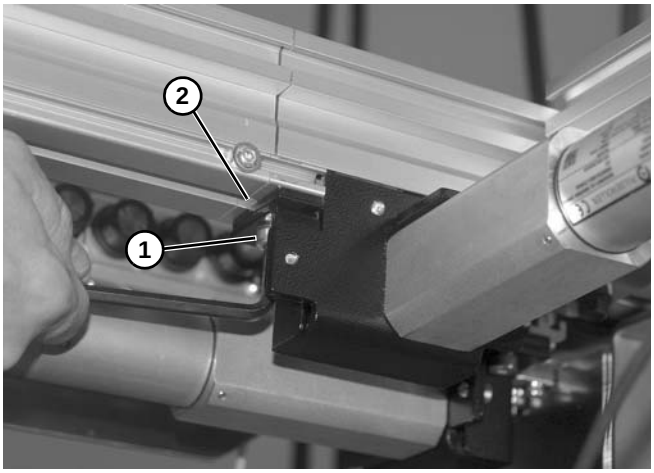


Figure 63

3. Lower and remove motor **(Figure 64, item 1)** from conveyor frame.

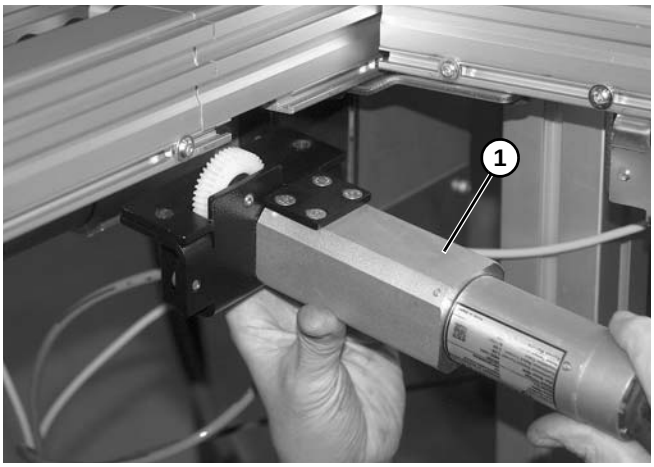


Figure 64

4. Remove two screws **(Figure 65, item 1)** holding drive cover to gear mounting bracket.

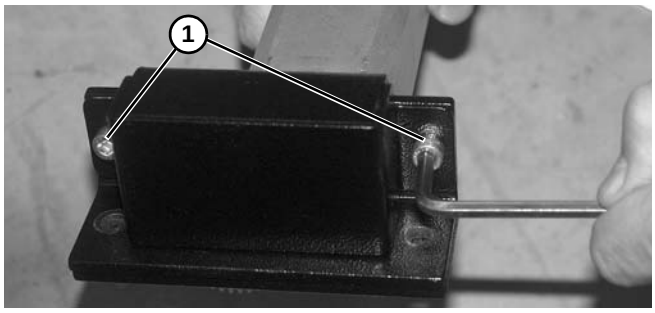


Figure 65

5. Remove the drive cover **(Figure 66, item 1)** from gear mounting bracket **(Figure 66, item 2)**.

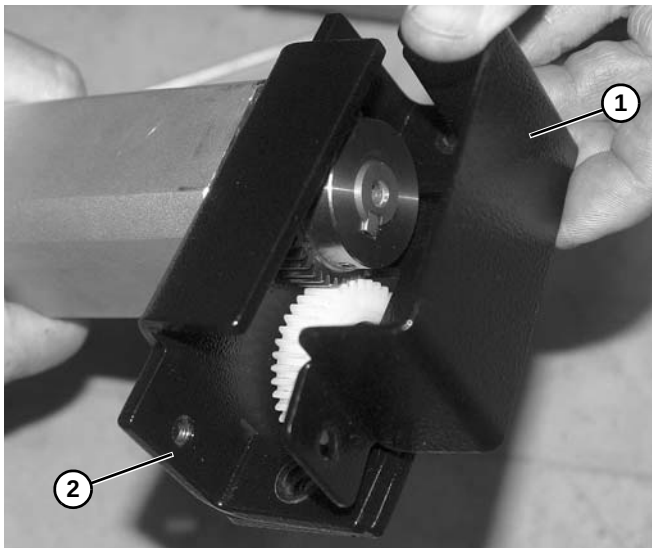


Figure 66

6. Remove four screws **(Figure 67, item 1)** and remove motor mounting bracket **(Figure 67, item 2)** from motor **(Figure 67, item 3)**.

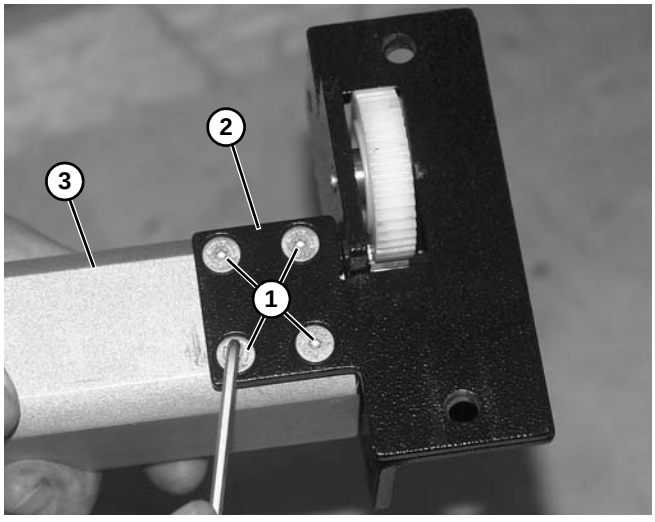


Figure 67

7. Remove the motor mounting bracket **(Figure 68, item 1)** and gear mounting bracket **(Figure 68, item 2)** from motor **(Figure 68, item 3)**.

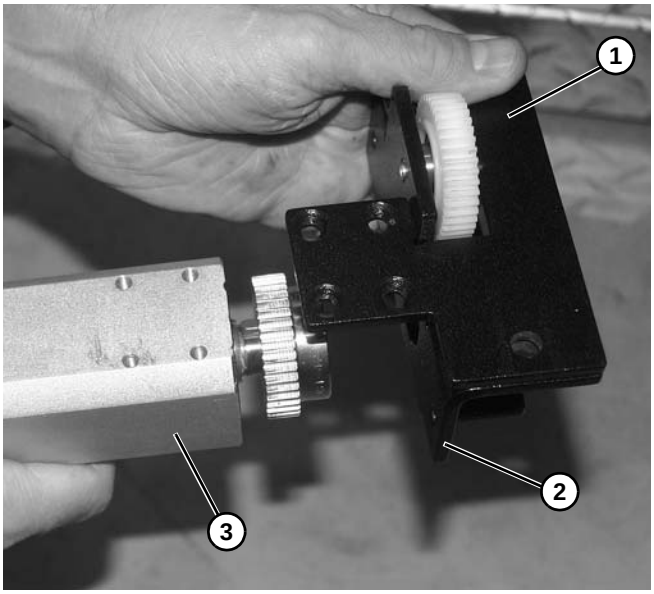


Figure 68

8. Remove the motor mounting bracket **(Figure 69, item 1)** from gear mounting bracket **(Figure 69, item 2)**.

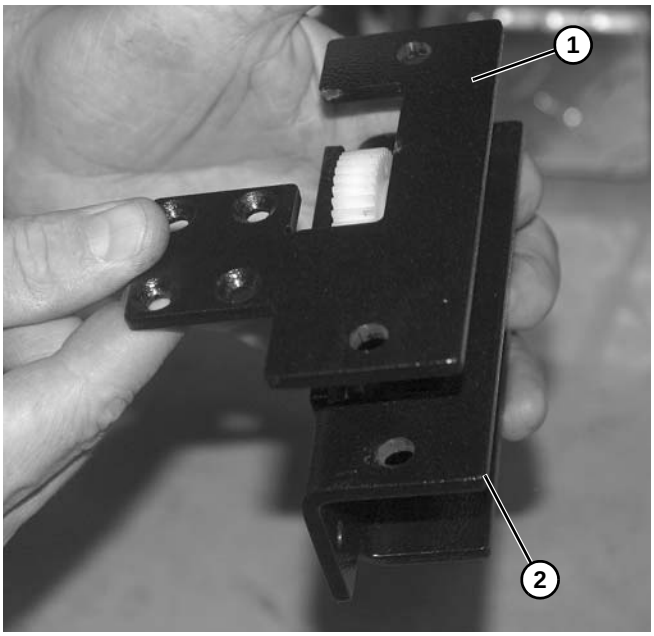


Figure 69

9. Loosen two set screws **(Figure 70, item 1)** on gear.

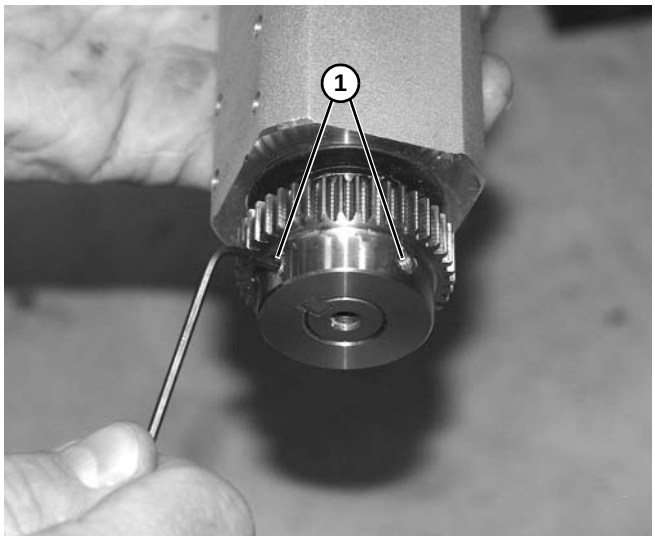


Figure 70

10. Remove gear **(Figure 71, item 1)** from motor shaft **(Figure 71, item 2)**.

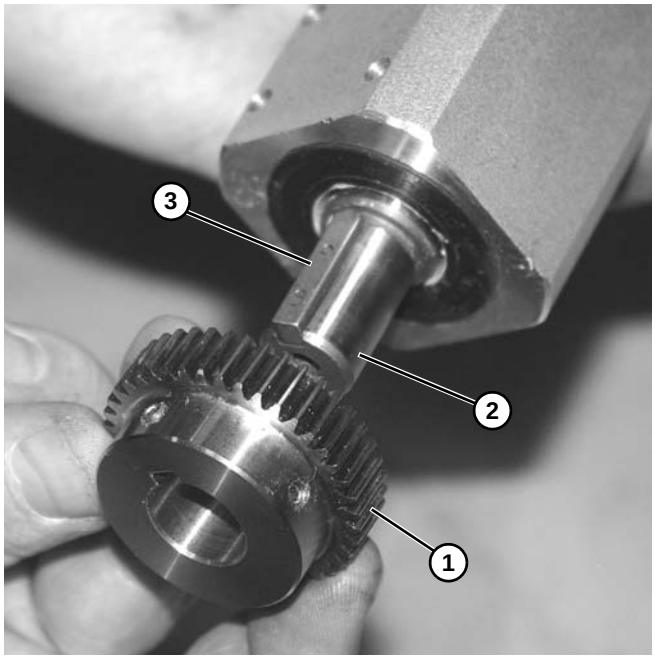


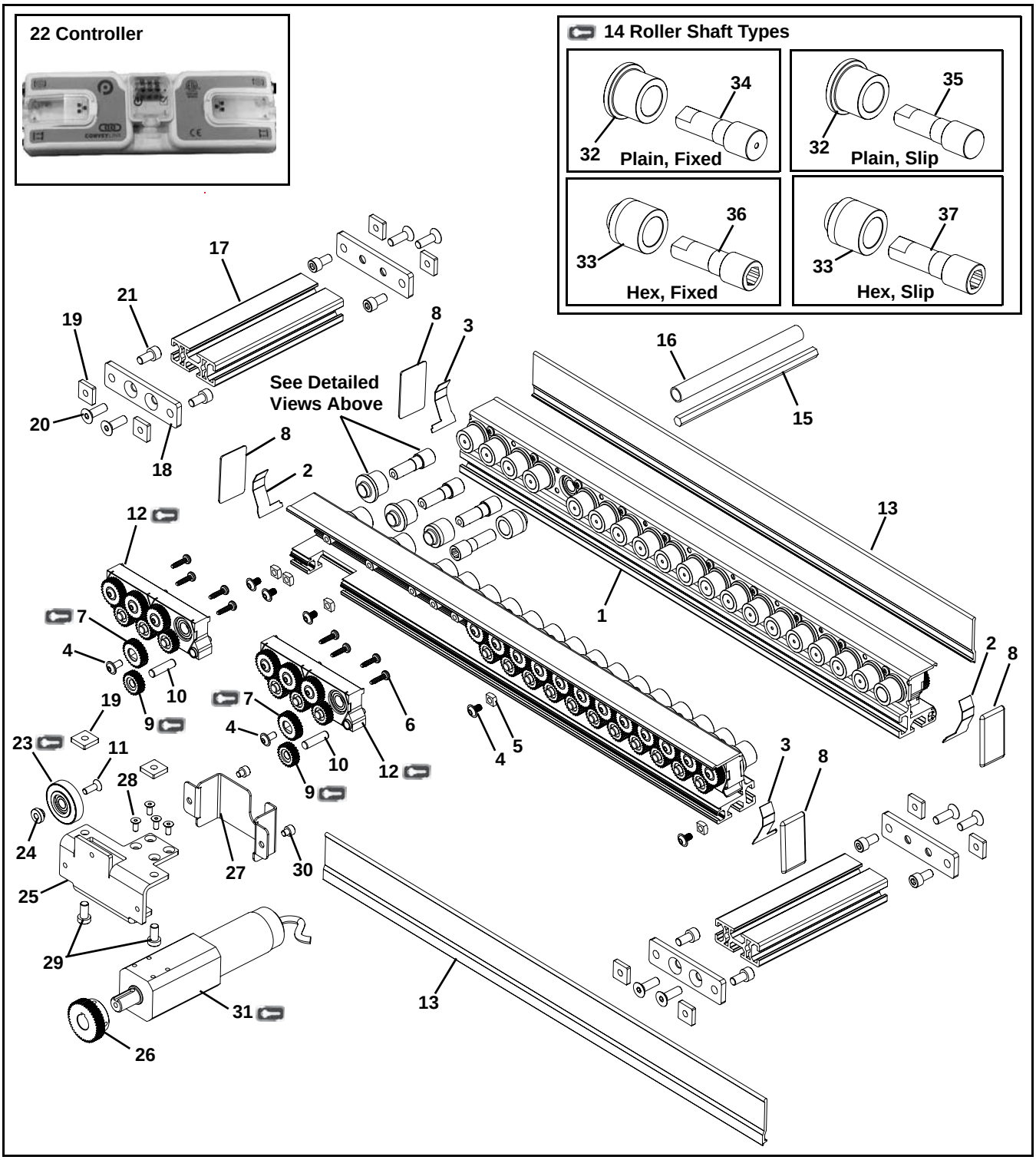
Figure 71

11. Remove key **(Figure 71, item 3)** from end of motor shaft.
12. Place key and gear onto new motor. Tighten set screws to 4 Nm (35 in-lbs).
13. Install remaining components in reverse order of removal.

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.

ERT 150 Conveyor



Item	Part Number	Description
1	----------	Consult Factory for Side Rail Part Number
2	400383-LH	Extrusion End Plate, Left Hand
3	400383-RH	Extrusion End Plate, Right Hand
4	910610MF	Flanged Button Head Screw, M6-1.00 x 10 mm
5	990603M	Square Nut
6	807-4277	Torx Pan Head Screw, #10 x .75"
7	400339	Upper Gear
8	400573	End Decal
9	400332	Lower Gear
10	913-521	Pin
11	930618M	Flat Head Screw, M6-1.00 x 18 mm
12	400436-2B	2 Bearing Housing, End Position (Also includes items 9 and 10)
	400436-3C	3 Bearing Housing, Center Position (Also includes items 9 and 10)
	400436-4B	4 Bearing Housing, End Position (Also includes items 9 and 10)
	400436-4C	4 Bearing Housing, Center Position (Also includes items 9 and 10)
13	400424-LLLLL-M	Flush Cover
	400375-LLLLL-M	T-Slot Cover
14	400341-PF	Plain, Fixed Roller Shaft Assembly
	400341-PS	Plain, Slip Roller Shaft Assembly
	400341-HF	Hex, Fixed Roller Shaft Assembly
	400341-HS	Hex, Slip Roller Shaft Assembly
15	400323-WWW	Shaft
16	400324-WWW	Shaft Cover
17	400326-LLLLL	Crossmember
18	400327	Crossmember Plate
19	FASN-M8	Square Nut
20	807-4142	Flat Head Screw, M8-1.25 x 25 mm
21	920816M	Socket Head Screw, M8-1.25 x 16 mm
22	826-999	Controller
23	400075	Bearing, Idler Gear
24	400076	Bearing Spacer
25	400365	Motor Mounting Bracket
26	400085	Motor Gear
27	400366	Drive Cover
28	930512M	Flat Head Screw, M5-.80 x 12 mm
29	950816M	Low Head Cap Screw, M8-1.25 x 16 mm
30	920606M	Socket Head Screw, M6-1.00 x 6mm
31	826-984	Motor, Speed = 10 Mpm, Gear Ratio = 67:1, RPM = 8.7-87
	826-985	Motor, Speed = 15 Mpm, Gear Ratio = 45:1, RPM = 12.9-129
	826-986	Motor, Speed = 20 Mpm, Gear Ratio = 33:1, RPM = 17.6-176
	826-987	Motor, Speed = 25 Mpm, Gear Ratio = 27:1, RPM = 21.5-215
	826-988	Motor, Speed = 37 Mpm, Gear Ratio = 18:1, RPM = 31.7-317
32	400320	Roller
33	400559	Hex Roller
34	400321-F	Fixed Shaft
35	400321-S	Slip Shaft
36	400321-D	Hex Fixed Shaft
37	400321-H	Hex Slip Shaft

WWW = Conveyor width reference: 80-480 in 40 mm increments

LLLLL = Part Length in mm with one decimal place.

Length Example: Length = 4850 mm LLLLL = 04850

See Specifications chart on page 7 for conveyor belt widths and lengths.

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

#12 Bearing Housing Details (See **Figure 72**.)

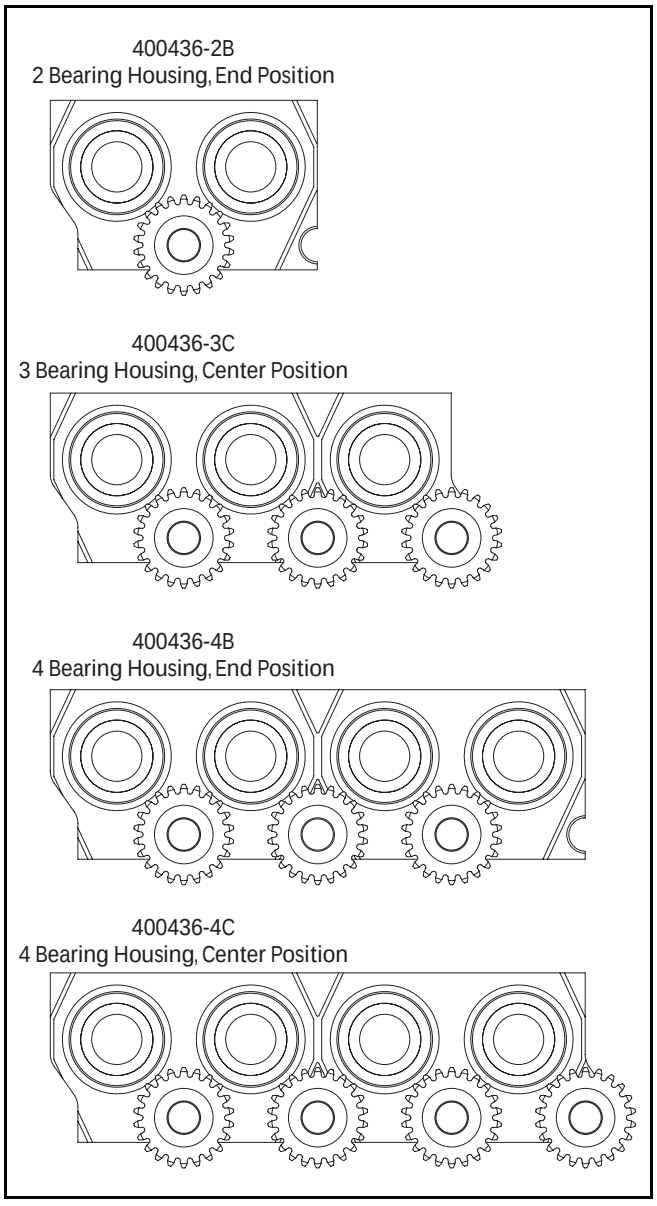
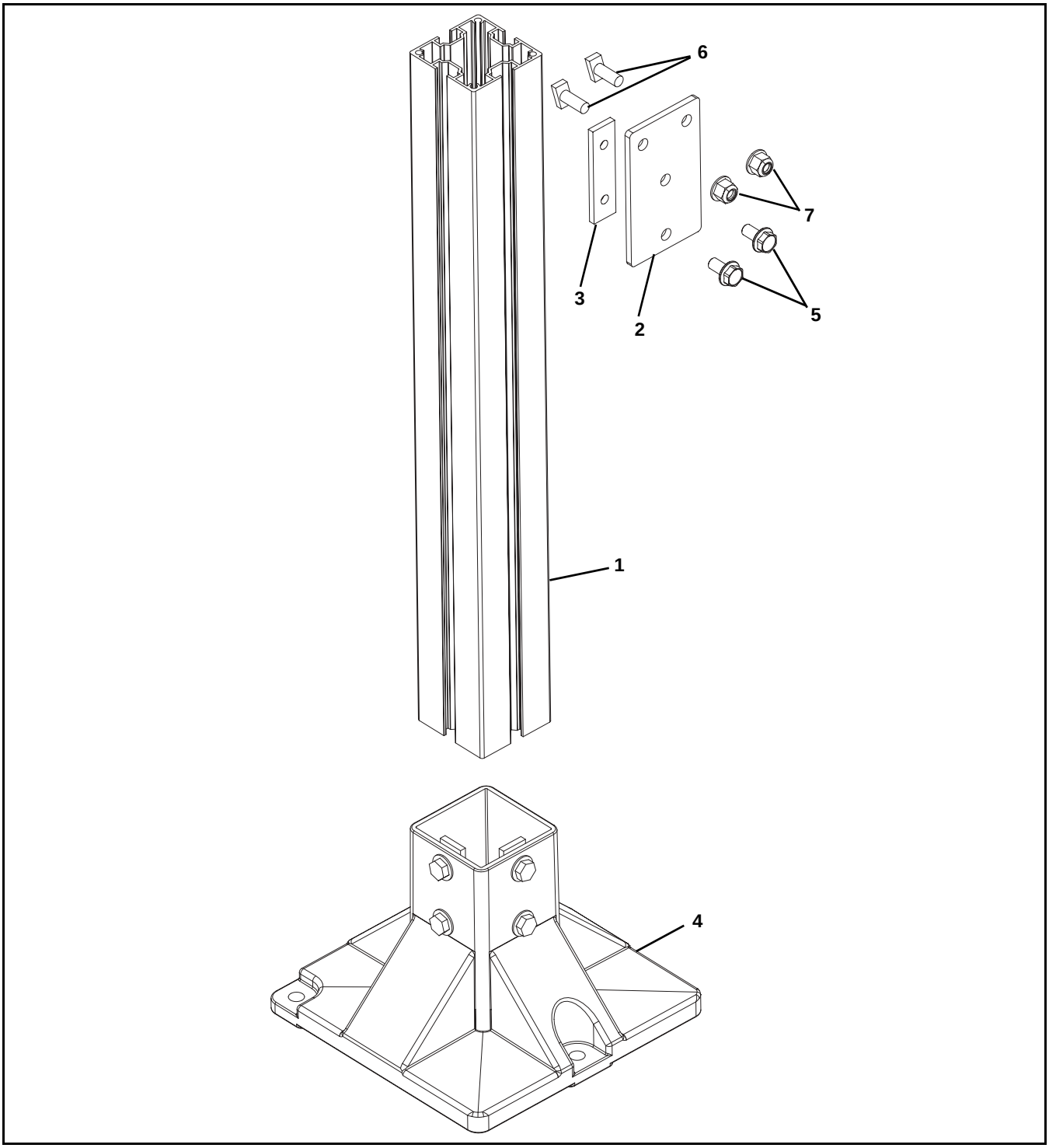


Figure 72

Service Parts

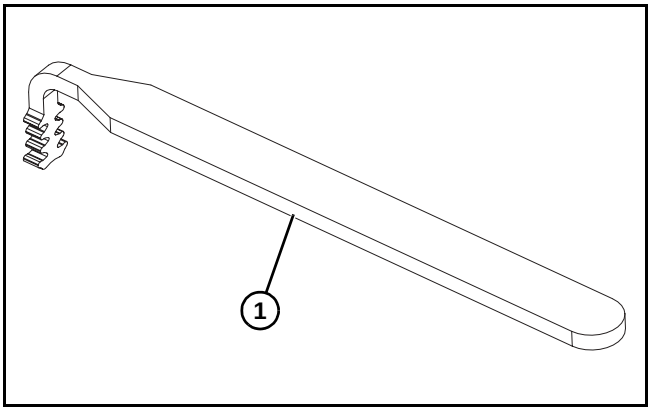
Support Stand



Item	Part Number	Description
1	FBSB-64X64-LLLLL-M	Support Beam
2	400453	Top Plate
3	FBCS-20X76	Connecting Strip
4	FBFT-64	Foot Assembly
5	960816MFY	Flanged Hex Head Cap Screw, M8-1.25 x 16 mm
6	FATB-20	Twist-In Stud, M8-20 mm

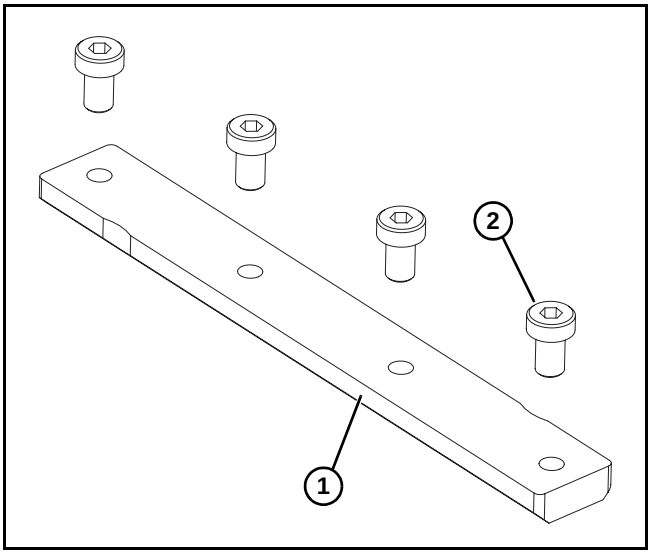
Item	Part Number	Description
7	990812M	Lock Nut
LLLLL = Part length in mm with one decimal place.		
Length Example: Length = 485 mm LLLLL = 04850		
See Specifications chart on page 8 for conveyor belt lengths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Sprocket Removal Tool



Item	Part Number	Description
1	400571	Sprocket Removal Tool
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Conveyor Tie Bracket



Item	Part Number	Description
1	206520	Frame Connecting Bar
2	950612M	Low Head Cap Screw, M6-1.00 x 12 mm
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Return Policy

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

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

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

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

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

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

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

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

www.dorner.com

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