DORNER
By Columbus McKinnon

DCMove

DCMove® Series Conveyors

Installation, Maintenance & Parts Manual

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

Record Conveyor Serial Number Here

851-980 Rev. A

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Introduction

IMPORTANT

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

Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

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

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 .

⚠ WARNING

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

⚠ DANGER

SEVERE HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

BURN HAZARD!

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

⚠ WARNING

PUNCTURE HAZARD!

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

⚠ DANGER

EXPLOSION HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

CRUSH HAZARD!

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

⚠ WARNING

SEVERE HAZARD!

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

Product Description

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

1	Conveyor
2	Gearmotor Mounting Package
3	Gearmotor
4	Support Stand
5	Drive End
6	Idler/Tension End

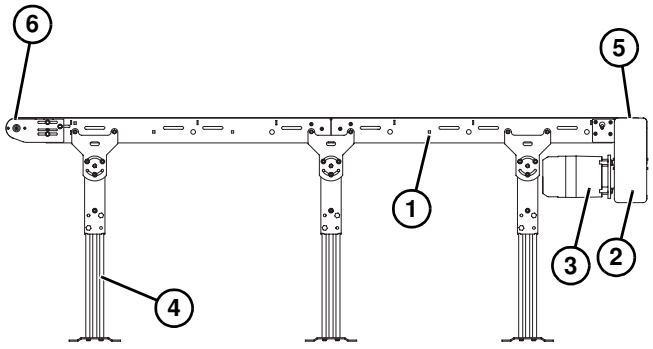
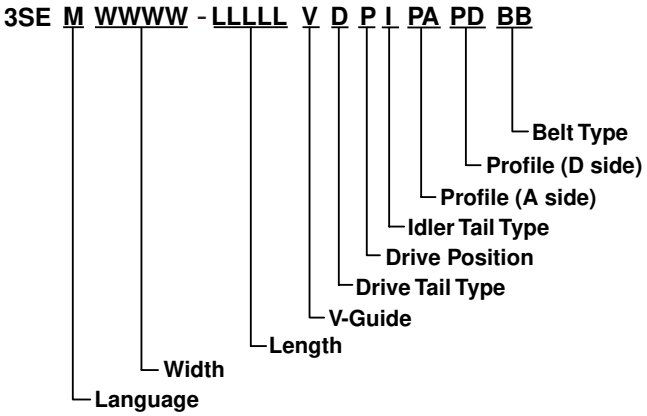


Figure 1

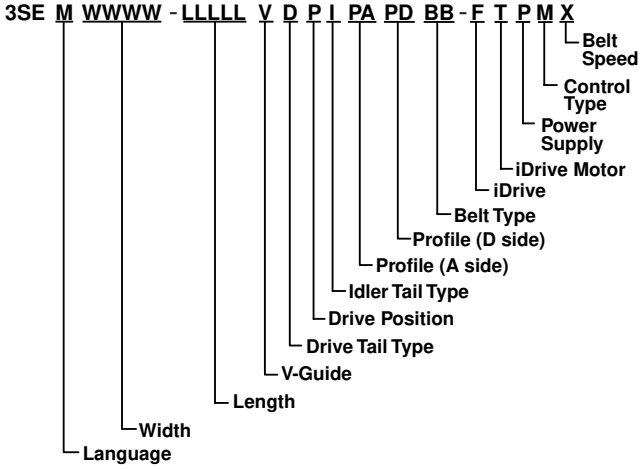
Specifications

Models:

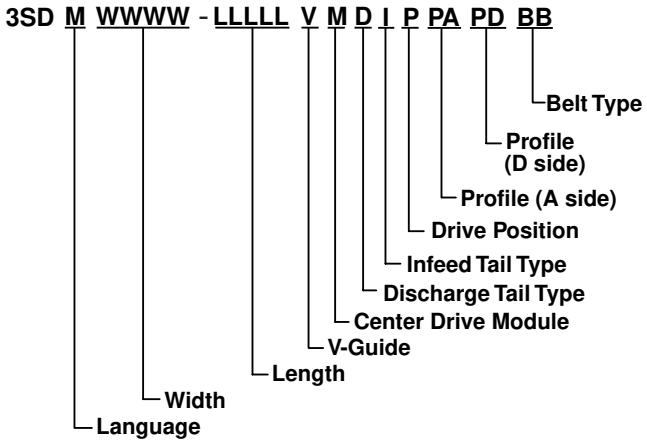
Flat Belt DCMove End Drive Conveyor



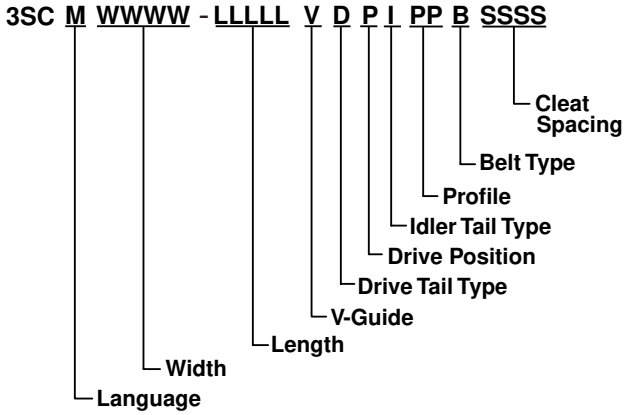
Flat Belt DCMove iDrive Conveyor



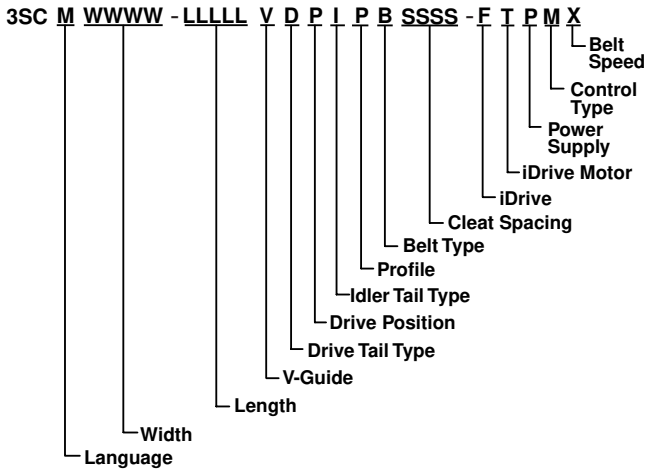
Flat Belt DCMove Center Drive Conveyor



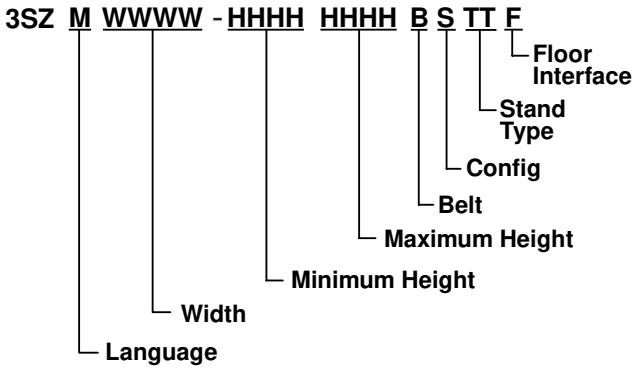
Cleated Belt DCMove End Drive Conveyor



Cleated Belt DCMove iDrive Conveyor



DCMove Support Stands



Conveyor Supports

Maximum Distances:

A = 610 mm (24") (Drive End)

B = 914 mm (36") (Idler End)

C = 3658 mm (12 ft)

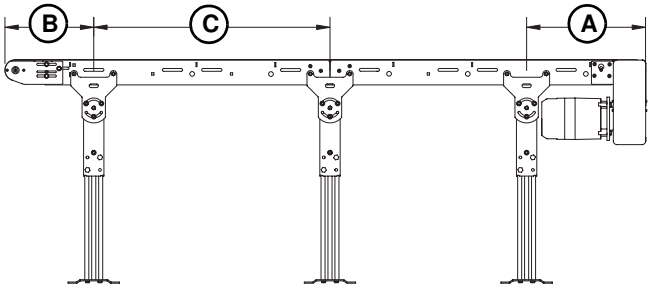


Figure 2

End Drive Conveyor Specifications

Conveyor Width Reference (WWWW)	0254, 0305, 0356, 0406, 0457, 0508, 0559, 0610, 0660, 0711, 0762, 0813, 0864, 0914, 0965, 1016, 1067, 1118, 1168, 1219
Conveyor Belt Width	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 mm (38"), 1016 mm (38"), 1067 mm (40"), 1118 mm (44"), 1168 mm (46"), 1219 mm (48")
Maximum Conveyor Load* (See NOTE Below)	181 kg (400 lbs)
Conveyor Length Reference (LLLLL)	00960 to 12000 in 00005 increments
Conveyor Length	960 mm (37.80") to 12,000 mm (472.44") in 5 mm (0.20") increments
Belt Travel	246 mm (9.7") per revolution of pulley
Maximum Belt Speed*	183 m/minute (600 ft/minute)
Belt Take-up	33 mm (1.30") of belt take-up

* See Engineering manual for details.

Specifications

Center Drive Conveyor Specifications

Conveyor Width Reference (WWWW)	0254, 0305, 0356, 0406, 0457, 0508, 0559, 0610, 0660, 0711, 0762, 0813, 0864, 0914, 0965, 1016, 1067, 1118, 1168, 1219
Conveyor Belt Width	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 mm (38"), 1016 mm (38"), 1067 mm (40"), 1118 mm (44"), 1168 mm (46"), 1219 mm (48")
Maximum Conveyor Load* (See NOTE Below)	455 kg (1,000 lbs)
Conveyor Length Reference (LLLLL)	01510 to 30000 in 00005 increments
Conveyor Length	1510 mm (60") to 30,000 mm (1181.10") in 5 mm (0.20") increments
Belt Travel	479 mm (18.8") per revolution of pulley
Maximum Belt Speed*	183 m/minute (600 ft/minute)
Belt Take-up	406 mm (16") of belt take-up

* See Engineering manual for details.

iDrive Conveyor Specifications

Conveyor Width Reference (WWWW)	0254, 0305, 0356, 0406, 0457, 0508, 0559, 0610, 0660, 0711, 0762, 0813, 0864, 0914
Conveyor Belt Width	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")
Maximum Conveyor Load* (See NOTE Below)	80 kg (176 lbs)
Conveyor Length Reference (LLLLL)	001010 to 03022 in 00005 increments
Conveyor Length	1010 mm (37.80") to 3022 mm (472.44") in 5 mm (0.20") increments
Belt Travel	246 mm (9.7") per revolution of pulley
Maximum Belt Speed*	46 m/minute (150 ft/minute)
Belt Take-up	33 mm (1.30") of belt take-up

* See Engineering manual for details.

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*

iDrive Motor Specifications

Output Power	50 watt
Input Power	24 VDC
Input Currents	3.5 amp Running 5.0 amp Starting
Protection Rating	IP 54 ingress rating

iDrive Gearmotor Specifications

Belt Speed	RPM (Nominal)	N-m	In-lb	Speed	
				M/min	Ft/min
G	87	4.4	39.1	1-10.4	3.3-34
F	129	3	26.2	1.5-15.4	4.9-51
E	176	2.2	19.2	2.1-21.1	6.9-69
D	215	1.8	15.7	2.6-25.7	8.5-84
C	317	1.2	10.6	3.8-37.9	12.5-124
P	62.7	12.9	113.76	0.8-7.5	2.6-25
N	93.3	8.6	76.32	1.1-11.2	3.6-37
M	127.5	6.3	55.84	1.5-15.3	4.9-50
L	155.6	5.2	45.76	1.9-18.6	6.2-61
K	229.5	3.5	31.04	2.8-27.5	9.2-90
J	280	2.9	25.44	3.4-33.5	11.2-110
H	382.5	2.1	18.56	4.6-45.8	15.1-150

Fastener 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

NOTE

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

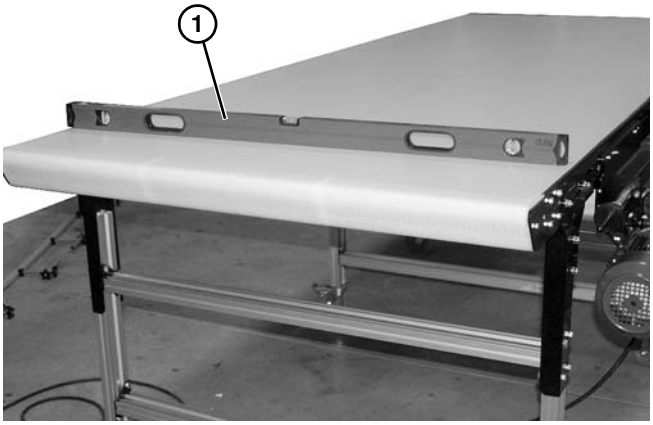


Figure 3

Required Tools

- Hex-key wrenches:
  - 4 mm, 5 mm, 6 mm
- 13 mm wrench
- Level
- Torque wrench

Recommended Installation Sequence

- Assemble conveyor (if required)
- Attach conveyor to stands
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (See accessory instructions)
- Attach guides/accessories

Single Piece Frame Conveyors

No assembly is required. Install stands, return rollers, and guiding. Refer to “Stand Installation” on page 11, “Return Rollers” on page 13, and “Guide Installation” on page 21.

Multi Piece Frame Conveyors

Installation Component List:

1	Conveyor frame
2	Section Label

1. Locate and arrange conveyor sections **(Figure 4, item 1)** by section labels **(Figure 4, item 2)**.

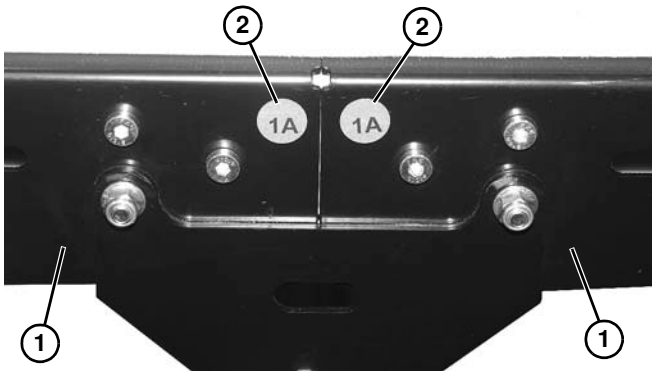


Figure 4

2. On tension end of the conveyor, identified by the pinion access slot **(Figure 5, item 1)**, loosen the four tail clamp screws **(Figure 5, item 2)** on both sides of the conveyor, and push head plate assembly **(Figure 5, item 3)** inward.

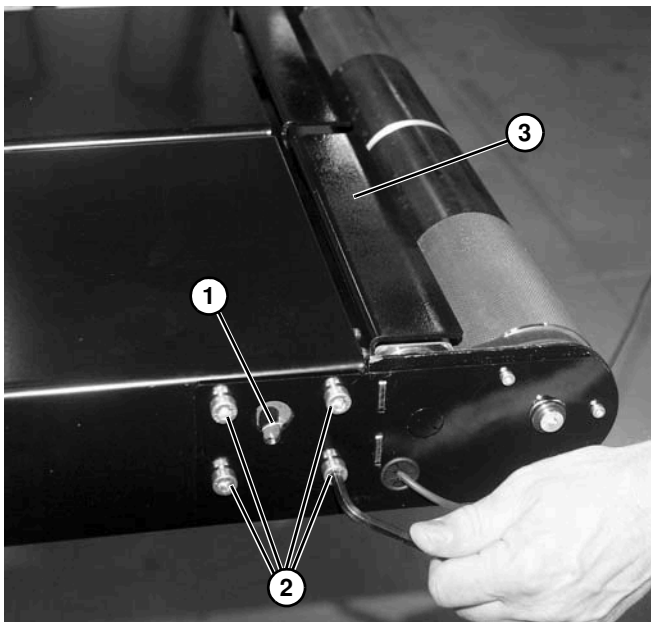


Figure 5

3. Place temporary support stands **(Figure 6, item 1)** at both ends of the conveyor.

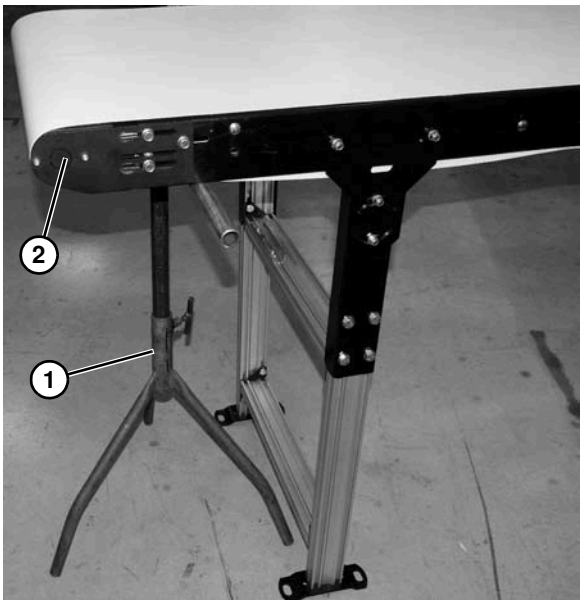


Figure 6

⚠ WARNING

SUPPORT CONVEYOR SECTIONS PRIOR TO CONNECTING FRAME SECTIONS.

4. Roll out conveyor belt and place conveyor frame sections **(Figure 6, item 2)** into belt loop.
5. Join conveyor sections and install connector brackets **(Figure 7, item 1)** and screws **(Figure 7, item 2)** on both sides as indicated. Tighten screws to 7 Nm (60 in lbs).

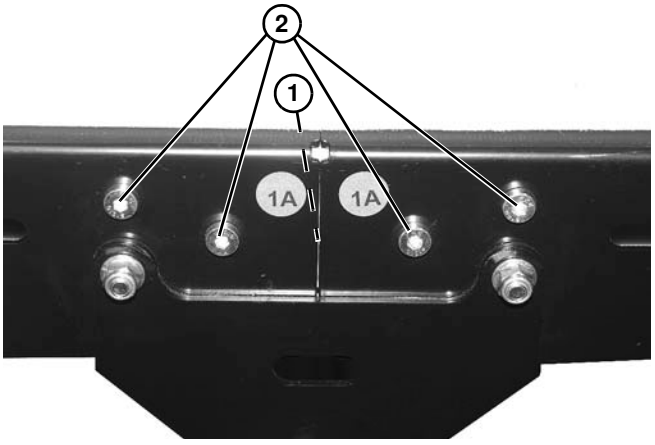


Figure 7

6. Tighten conveyor belt, refer to "Conveyor Belt Tensioning" on page 33.
7. Install stand and return rollers. Refer to "Stand Installation" on page 11 and "Return Rollers" on page 13.

Stand Installation

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Place stand assembly **(Figure 8, item 1)** into position on conveyor frame.

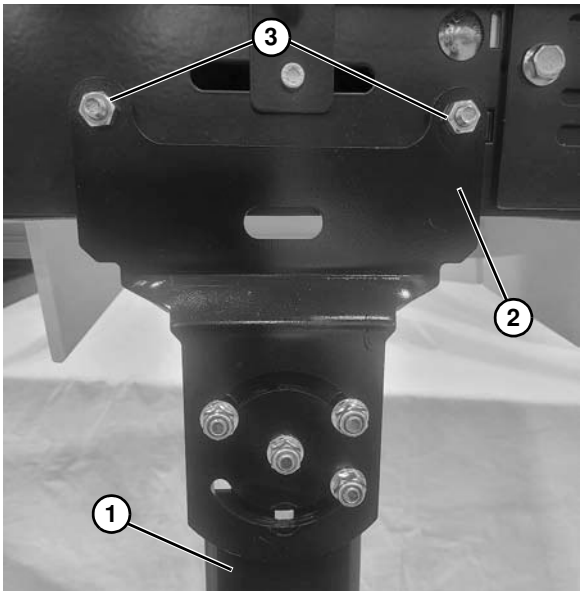


Figure 8

3. Install two carriage bolts through the inside of conveyor frame and through stand bracket **(Figure 8, item 2)**. Secure with two nuts **(Figure 8, item 3).**
4. Repeat on the opposite side of conveyor.

Installation

Stand Height Adjustment

1. To adjust height, loosen two screws **(Figure 9, item 1)** on upper bracket **(Figure 9, item 2)** on both sides of stand.

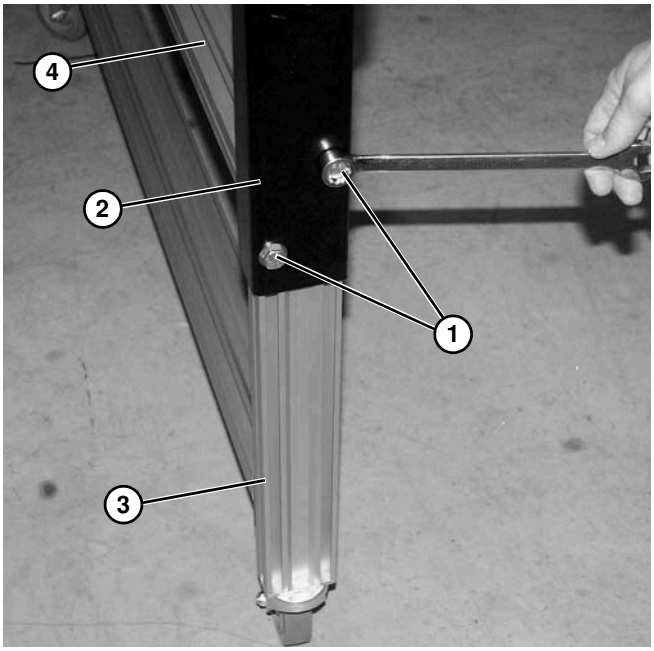


Figure 9

2. Raise or lower stand leg **(Figure 9, item 3)** to the required height. Level stand from side to side by using a level on crossmember **(Figure 9, item 4)**.

⚠ WARNING

Failure to secure screws (Figure 9, item 1) may cause conveyor sections to drop down causing severe injury.

TIGHTEN SCREWS (Figure 9, item 1) AFTER ADJUSTMENT.

3. When correct height on each stand leg **(Figure 9, item 3)** is reached, tighten screws **(Figure 9, item 1)** on both sides of stand.

Conveyor Angle Adjustment

NOTE

*Please note of the two different fastener locations for horizontal conveyors **(Figure 10)** and angled conveyors **(Figure 11)**.*

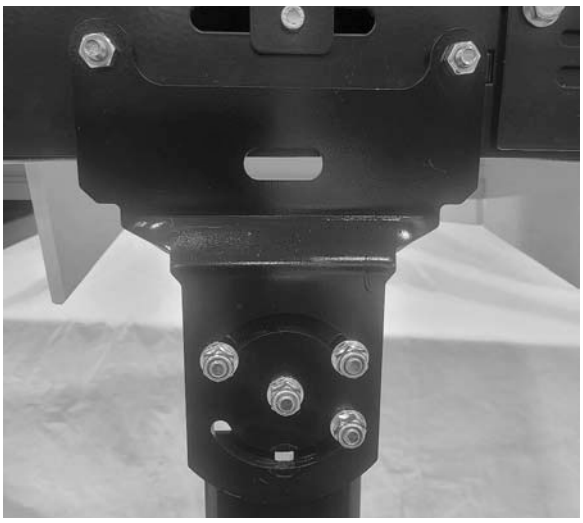


Figure 10

Figure 11

1. To adjust conveyor angle, loosen center nut **(Figure 12, item 1)** on bracket **(Figure 12, item 2)** on both sides of stand.

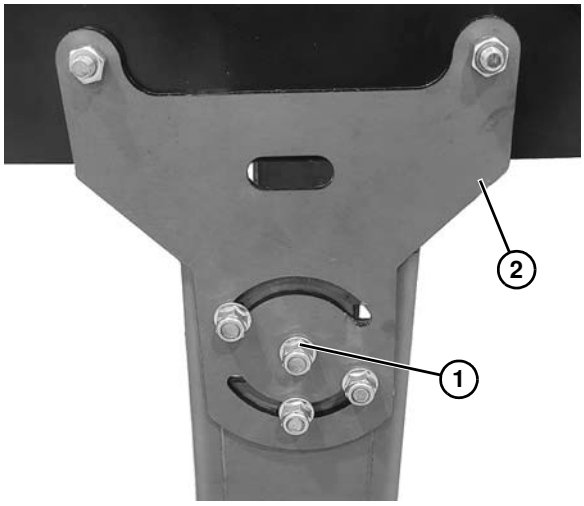


Figure 12

2. Loosen three nuts **(Figure 13, item 1)**, and adjust conveyor along with bracket **(Figure 13, item 2)** on both sides of stand.

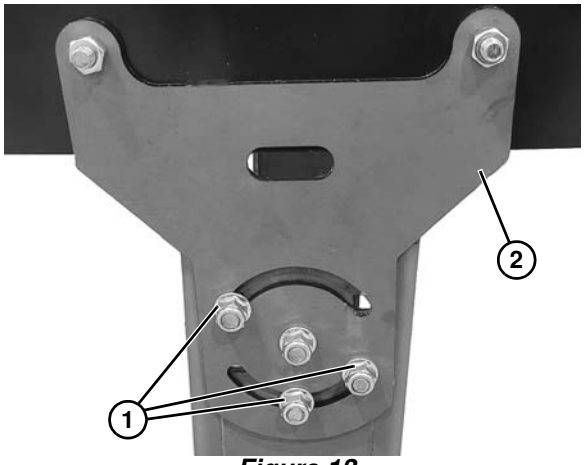


Figure 13

⚠ WARNING

Failure to secure nuts (Figure 12, item 1) and (Figure 13, item 1) may cause conveyor sections to drop down causing severe injury.

TIGHTEN NUTS (Figure 12, item 1) AND (Figure 13, item 1) AFTER ADJUSTMENT.

3. When correct angle is reached, tighten three nuts **(Figure 13, item 1)** and center nut **(Figure 12, item 1)** on both sides of stand.

Return Rollers

Cleated Belt Conveyors

1. Locate return rollers. Exploded view shown in **(Figure 14)**.

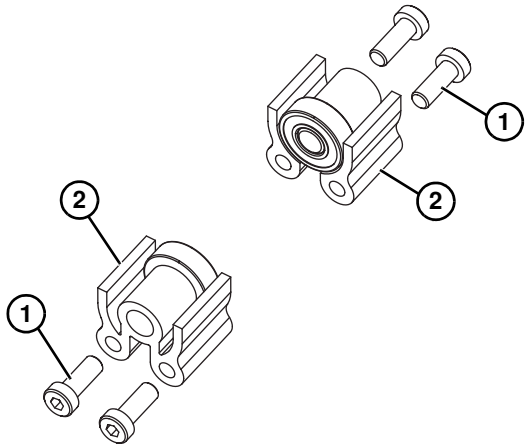


Figure 14

2. Remove two screws **(Figure 14, item 1)** and roller assembly **(Figure 14, item 2)**.
3. Install roller assemblies **(Figure 15, item 1)** as shown. Install and tighten two screws **(Figure 15, item 2)** to 7 Nm (60 in lbs).

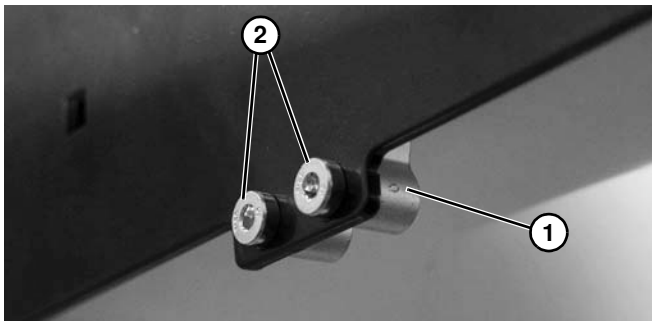


Figure 15

Flat Belt Conveyors

1. Locate return rollers. Exploded view shown in **(Figure 16)**.

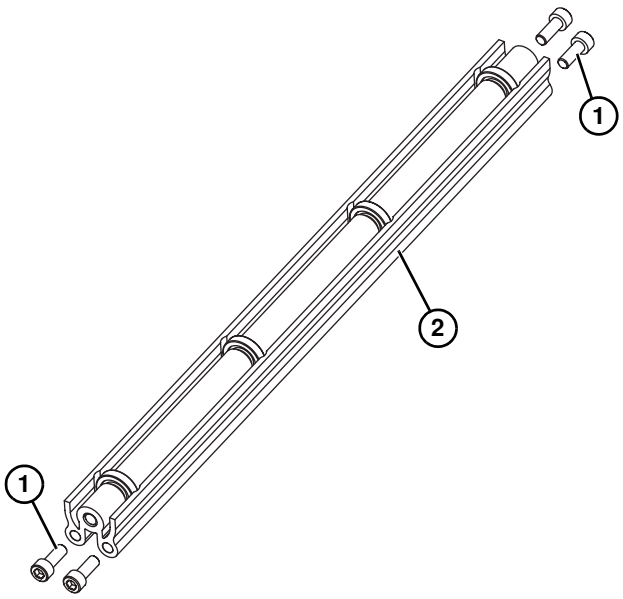


Figure 16

2. Remove screws **(Figure 16, item 1)** and roller assembly **(Figure 16, item 2)**.
3. Install roller assembly as shown **(Figure 17, item 1)**. Tighten screws **(Figure 17, item 2)** to 7 Nm (60 in lbs).

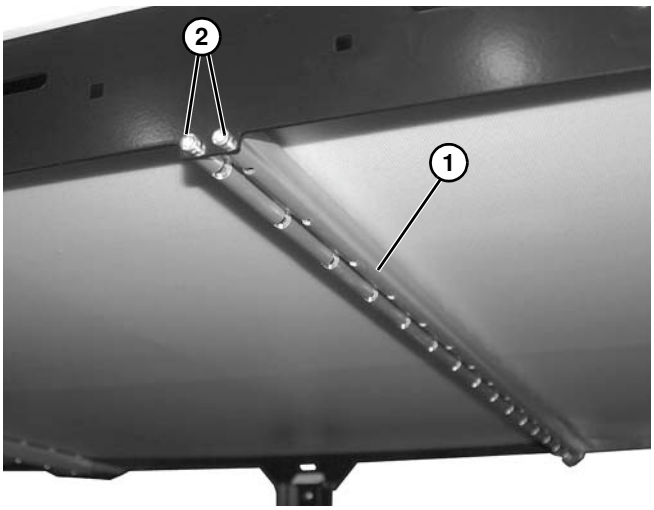


Figure 17

iDrive Controller

⚠ WARNING

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

The DCMove series iDrive is available in 2 models:

- Single iDrive Controller
- Dual iDrive Controller

Single iDrive Controller

⚠ WARNING

Motor may start immediately once power is supplied. Exposed moving parts can cause severe injury. LOCK OUT POWER before wiring to avoid accidental startup.

Assembly

1. Release belt tension. (Refer to “Conveyor Belt Tensioning” on page 33.)
2. Attach end **(Figure 18, item 1)** of motor wiring to threaded end **(Figure 18, item 2)** on controller.

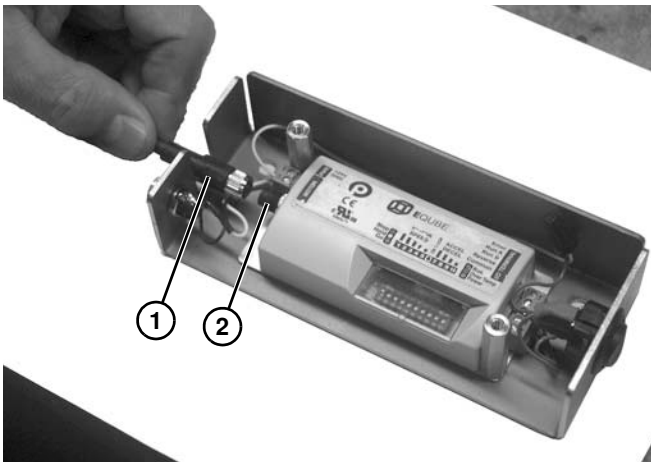


Figure 18

3. Install tee bar **(Figure 19, item 1)**, and secure mounting bracket **(Figure 20, item 1)** with two screws **(Figure 20, item 2)**.

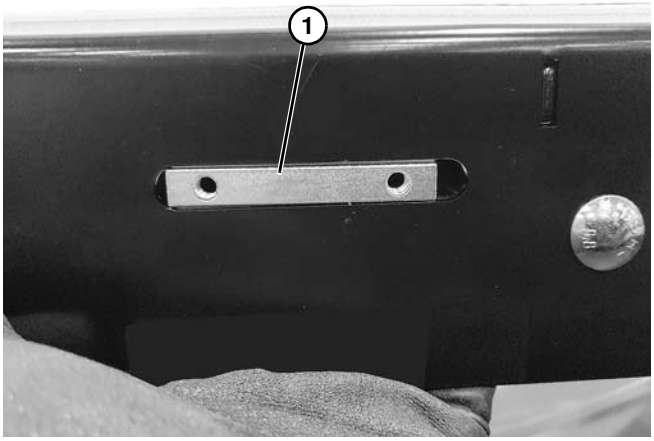


Figure 19

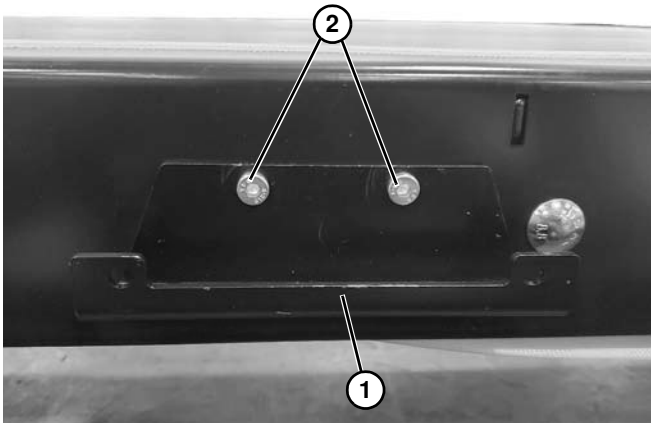


Figure 20

4. Secure controller assembly **(Figure 21, item 1)** onto mounting bracket **(Figure 20, item 1)** with two screws **(Figure 21, item 2)** and nuts **(Figure 21, item 3)**.

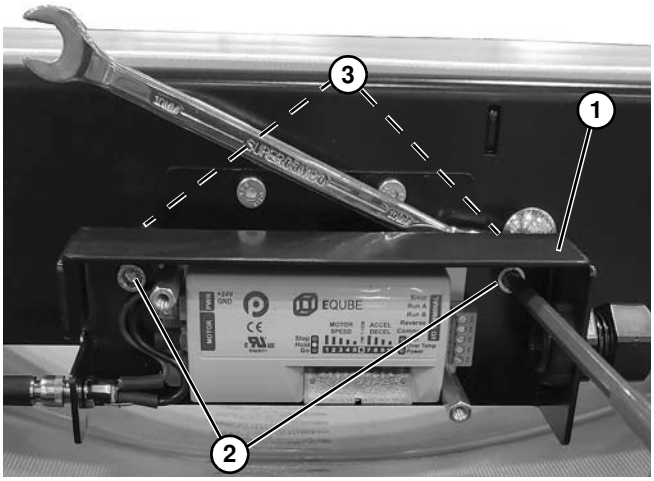


Figure 21

5. Install cover **(Figure 22, item 1)** with two screws **(Figure 22, item 2)**.

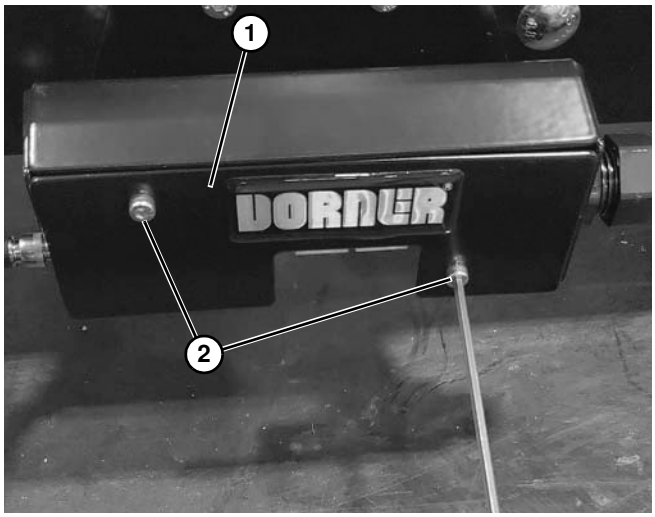


Figure 22

Installation

Setup

1. Conveyor speed is controlled by DIP switch settings. Use the single motor chart below to determine your maximum speed.

Single Motor Chart	
Motor	**Speed Range**
G	1 to 10.4 M/min (3.3 to 34 ft/min)
F	1.5 to 15.4 M/min (4.9 to 51 ft/min)
E	2.1 to 21.1 M/min (6.9 to 69 ft/min)
D	2.6 to 25.7 M/min (8.5 to 84 ft/min)
C	3.8 to 37.9 M/min (12.5 to 124 ft/min)

2. To set the conveyor maximum speed, use the DIP switch settings shown.

- Speed: DIP Switches 1-5 **(Figure 23, item 1)**. and switch settings chart **(Figure 24)**.

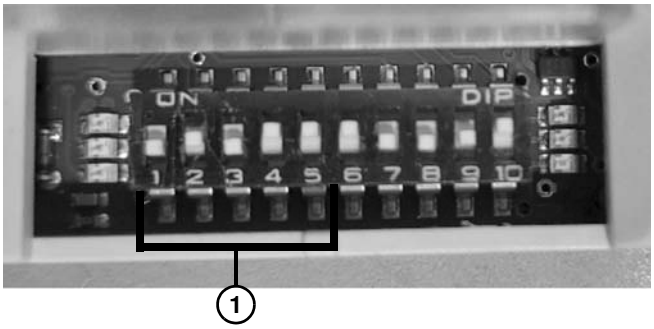


Figure 23

Switch 1	Switch 2	Switch 3	Switch 4	Switch 5	Frequency	Motor RPM	% of Max. Speed
Off	Off	Off	Off	Off	49	580	10.0%
Off	Off	Off	Off	On	67	800	14.0%
Off	Off	Off	On	Off	84	1000	17.0%
Off	Off	Off	On	On	100	1200	20.5%
Off	Off	On	Off	Off	117	1400	24.0%
Off	Off	On	Off	On	134	1600	27.5%
Off	Off	On	On	Off	150	1800	31.0%
Off	Off	On	On	On	167	2000	34.5%
Off	On	Off	Off	Off	184	2200	38.0%
Off	On	Off	Off	On	200	2400	41.5%
Off	On	Off	On	Off	217	2600	45.0%
Off	On	Off	On	On	234	2800	48.5%
Off	On	On	Off	Off	280	3000	51.5%
Off	On	On	Off	On	267	3200	55.0%
Off	On	On	On	Off	284	3400	58.5%
Off	On	On	On	On	300	3600	62.0%
On	Off	Off	Off	Off	317	3800	65.5%
On	Off	Off	Off	On	334	4000	69.0%
On	Off	Off	On	Off	350	4200	72.5%
On	Off	Off	On	On	367	4400	76.0%
On	Off	On	Off	Off	384	4600	79.5%
On	Off	On	Off	On	400	4800	83.0%
On	Off	On	On	Off	409	4900	84.5%
On	Off	On	On	On	417	5000	86.0%
On	On	Off	Off	Off	425	5100	88.0%
On	On	Off	Off	On	434	5200	89.5%
On	On	Off	On	Off	442	5300	91.5%
On	On	Off	On	On	450	5400	93.0%
On	On	On	Off	Off	459	5500	95.0%
On	On	On	Off	On	467	5600	96.5%
On	On	On	On	Off	475	5700	98.5%
On	On	On	On	On	484	5800	100.0%

Figure 24

- Direction: DIP Switch 6 **(Figure 25, item 1)**, and switch settings chart **(Figure 26)**.

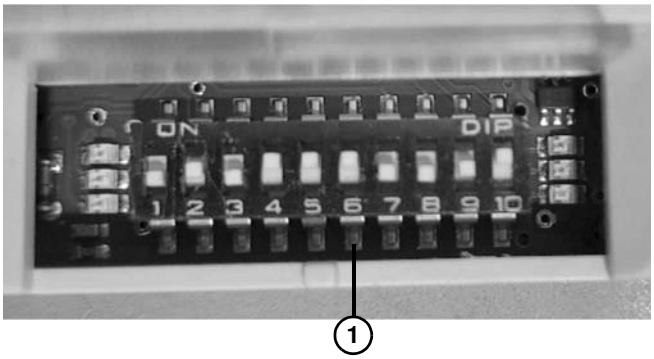


Figure 25

Switch	Function	Off	On
6	Direction of Rotation	CW	CCW

Figure 26

- Acceleration/Deceleration: DIP Switches 7-10 **(Figure 27, item 1)**, and switch settings chart **(Figure 28)**.

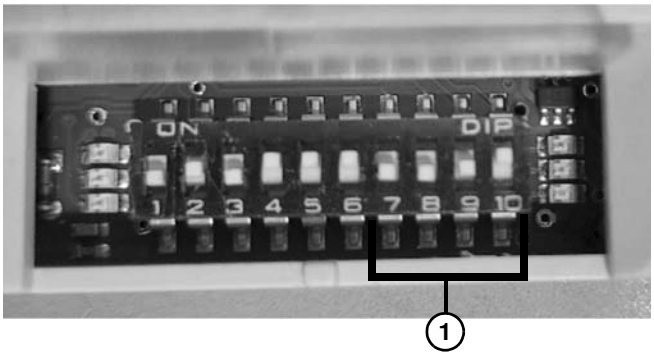


Figure 27

Switch 7	Switch 8	Switch 9	Switch 10	Accel/Decel Time (sec)
Off	Off	Off	Off	0.050
Off	Off	Off	On	0.100
Off	Off	On	Off	0.500
Off	Off	On	On	0.300
Off	On	Off	Off	0.400
Off	On	Off	On	0.500
Off	On	On	Off	0.600
Off	On	On	On	0.700
On	Off	Off	Off	.0.800
On	Off	Off	On	1.000
On	Off	On	Off	1.200
On	Off	On	On	1.400
On	On	Off	Off	1.600
On	On	Off	On	1.800
On	On	On	Off	2.000
On	On	On	On	2.500

Figure 28

3. The toggle switch **(Figure 29, item 1)** on the side of the controller provides additional controls.

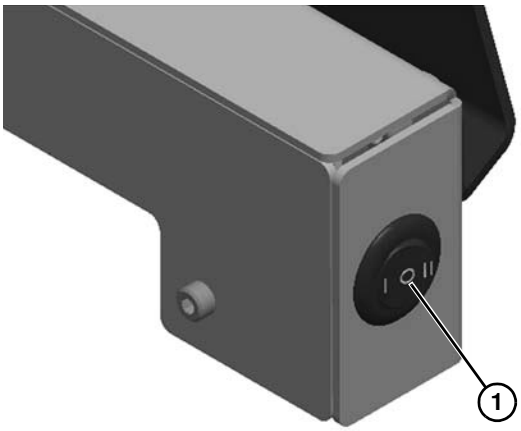


Figure 29

- **Position I** = half of the set speed
- **Position O** = off
- **Position II** = full set speed

4. For remote controls, a cord grip **(Figure 30, item 1)** is provided to accommodate 4.3 - 11.4 mm (0.17 - 0.45") diameter cords.

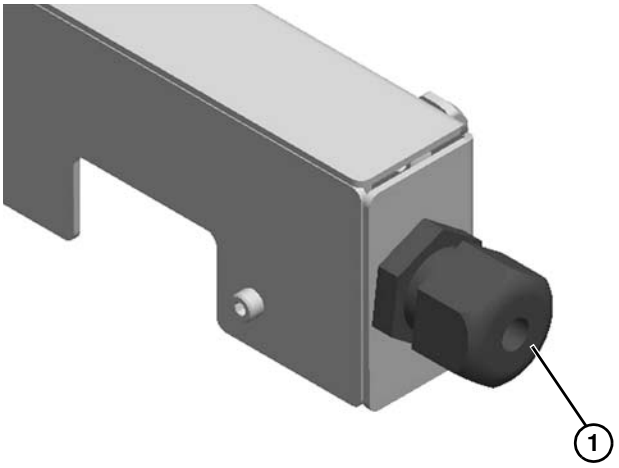


Figure 30

- Wiring diagram **(Figure 31)**:

Figure 31

Dual iDrive Controller

⚠ WARNING

Motor may start immediately once power is supplied. Exposed moving parts can cause severe injury. LOCK OUT POWER before wiring to avoid accidental startup.

Assembly

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Attach end **(Figure 32, item 1)** of motor wiring to threaded end **(Figure 32, item 2)** on controller.

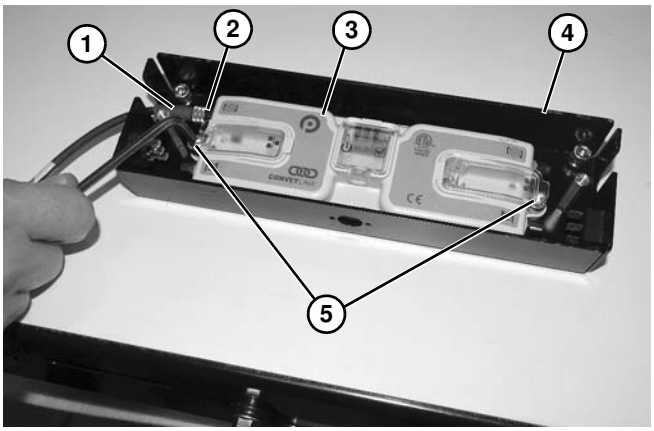


Figure 32

3. Install controller **(Figure 32, item 3)** onto bracket **(Figure 32, item 4)** with two screws **(Figure 32, item 5)**.

4. Install tee bar **(Figure 33, item 1)**, and secure mounting bracket **(Figure 34, item 1)** with two screws **(Figure 34, item 2)**.

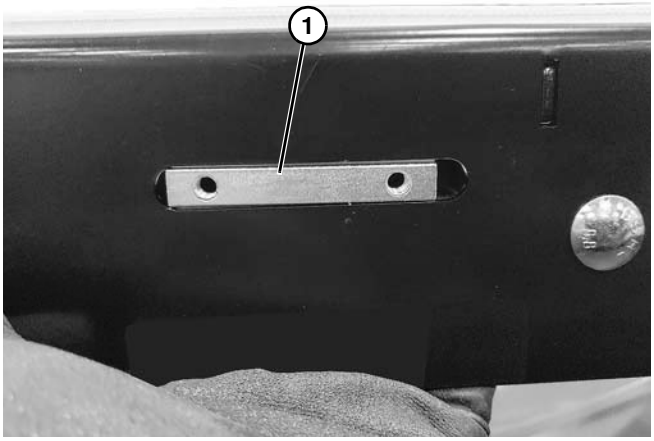


Figure 33

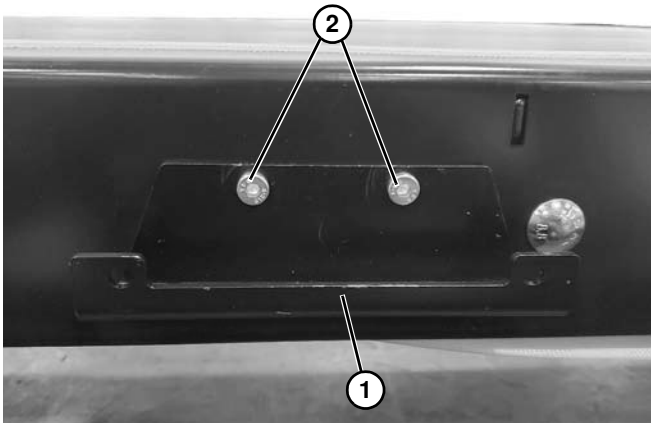


Figure 34

5. Secure controller assembly **(Figure 35, item 1)** onto mounting bracket **(Figure 34, item 1)** with two screws **(Figure 35, item 2)** and nuts **(Figure 35, item 3)**.

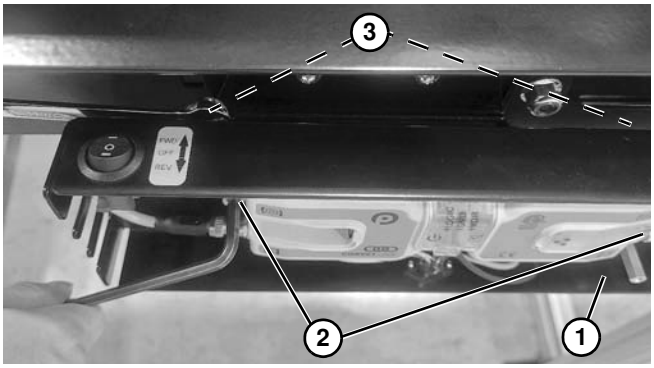


Figure 35

6. Install cover **(Figure 36, item 1)** with two screws **(Figure 36, item 2)**.

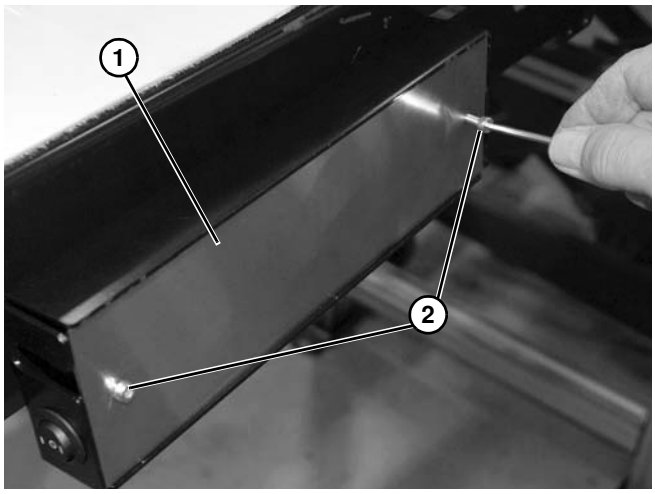


Figure 36

Speed Control

1. Conveyor speed is controlled by the speed control button **(Figure 37, item 1)** on the top of the controller.

Figure 37

2. To set the conveyor speed push and hold button up to speed up the conveyor. Push and hold the button down to slow down the conveyor.

Installation

Center Drive Gearmotor Installation

Required Tools

- Hex key wrenches: 2 mm, 2.5 mm, 3 mm, 5 mm
- Torque wrench

Mounting

⚠ WARNING

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

1. Typical components **(Figure 38)**.

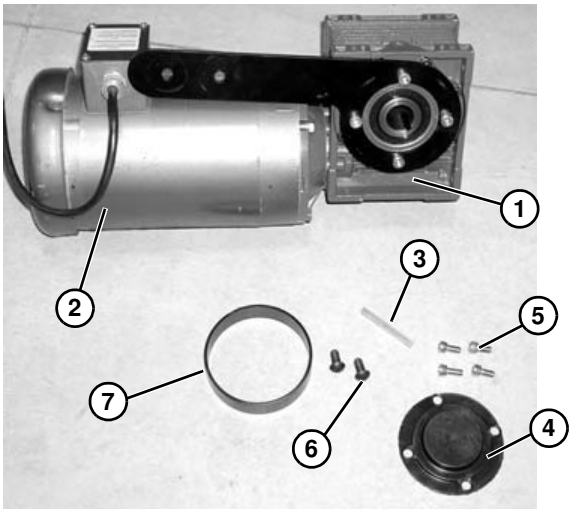


Figure 38

Gearmotor Installation Component List	
1	Gearhead with mounting bracket
2	Motor
3	Gear Reducer Key
4	Cover
5	Cover Screws
6	Motor Mount Screws
7	Spacer Ring

NOTE

Gearmotor may be operated in positions 1, 3 or 4 ***(Figure 39)****.*

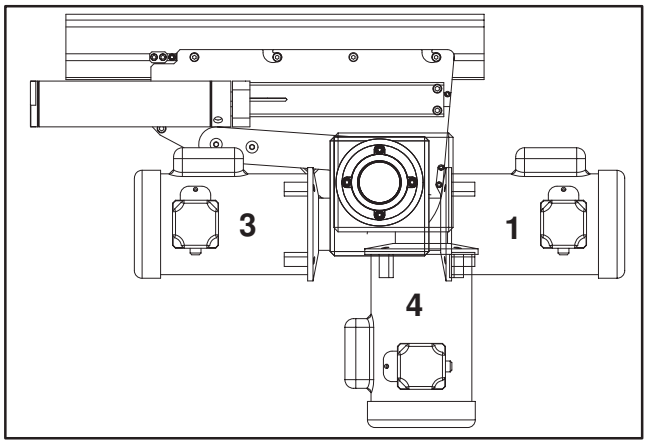


Figure 39

2. If required, change gearmotor position by removing four screws **(Figure 40, item 1)**. Rotate gearmotor mounting plate to other position and replace screws. Tighten to 22.5 Nm (200 in lbs).

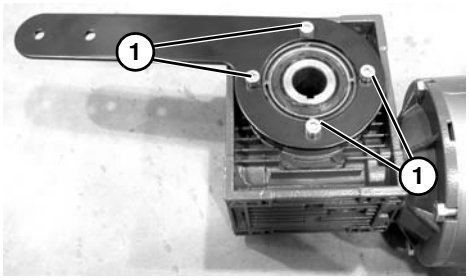


Figure 40

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

3. Install key **(Figure 41, item 1)** on drive shaft **(Figure 41, item 2)**. Install cover **(Figure 41, item 3)** over bearing housing **(Figure 41, item 4)**.

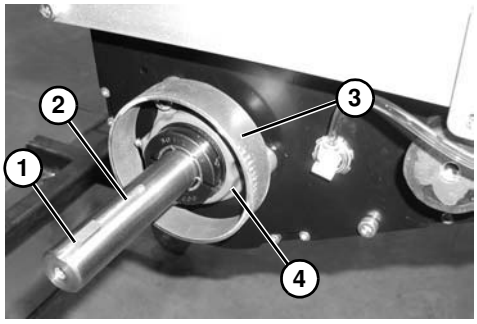


Figure 41

4. Install cover **(Figure 42, item 1)** with four screws **(Figure 42, item 2)**.

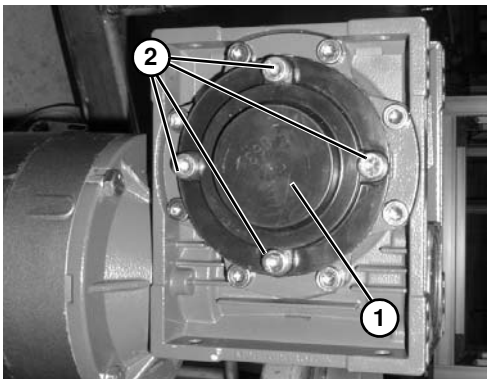


Figure 42

5. Slide gearmotor assembly **(Figure 43, item 1)** on to drive shaft **(Figure 41, item 2)**. Tighten mounting screws **(Figure 43, item 2)** to 22.5 Nm (200 in lbs).

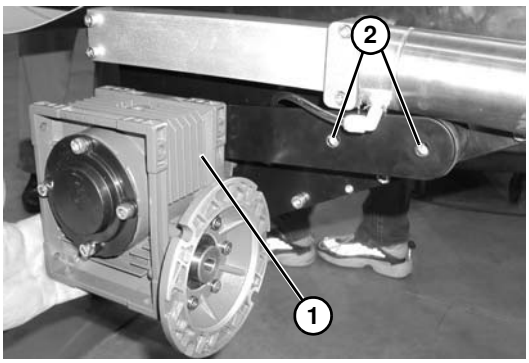


Figure 43

Guide Installation

High Sides

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Install carriage bolt **(Figure 44, item 1)** through inside conveyor frame, and loosely install nut onto carriage bolt.

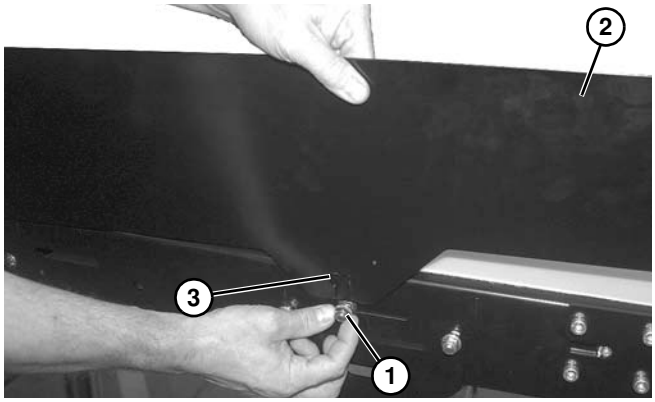


Figure 44

3. Install high side guide **(Figure 44, item 2)** onto carriage bolt and seat into notch **(Figure 44, item 3)** in guide.
4. Install guide **(Figure 45, item 1)** onto remaining hardware and tighten nuts **(Figure 45, item 2)**.

Figure 45

Fully Adjustable

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Locate position of first adjustable guide mounting bracket **(Figure 46, item 1)**, and (from inside conveyor frame) install tee bar **(Figure 46, item 2)** into conveyor frame slot **(Figure 46, item 3)**.

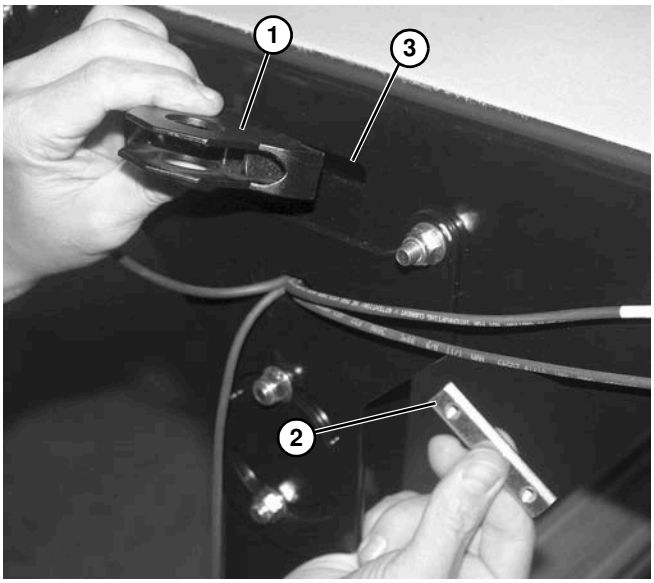


Figure 46

3. Position mounting bracket **(Figure 47, item 1)** onto tee bar **(Figure 47, item 2)**.

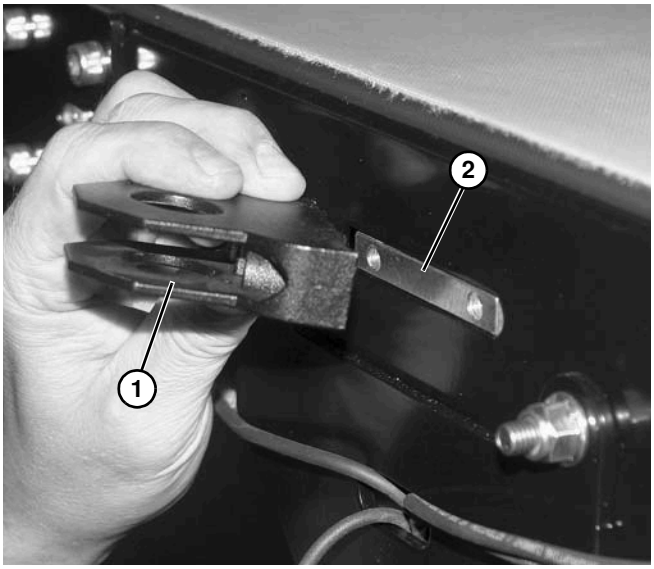


Figure 47

4. Secure mounting bracket **(Figure 48, item 1)** onto tee bar with two screws **(Figure 48, item 2)**.

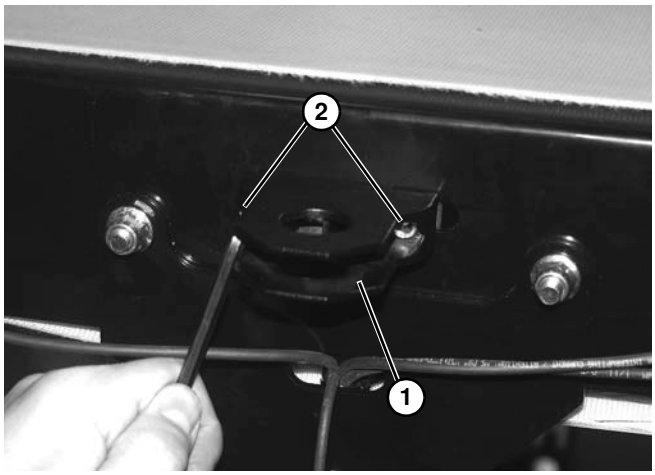


Figure 48

5. Repeat for remaining mounting brackets needed.
6. Secure adjustable clamp assembly **(Figure 49, item 1)** onto mounting bracket **(Figure 49, item 2)**, with bottom clamp **(Figure 49, item 3)** installed into slotted area **(Figure 49, item 4)** of mounting bracket.

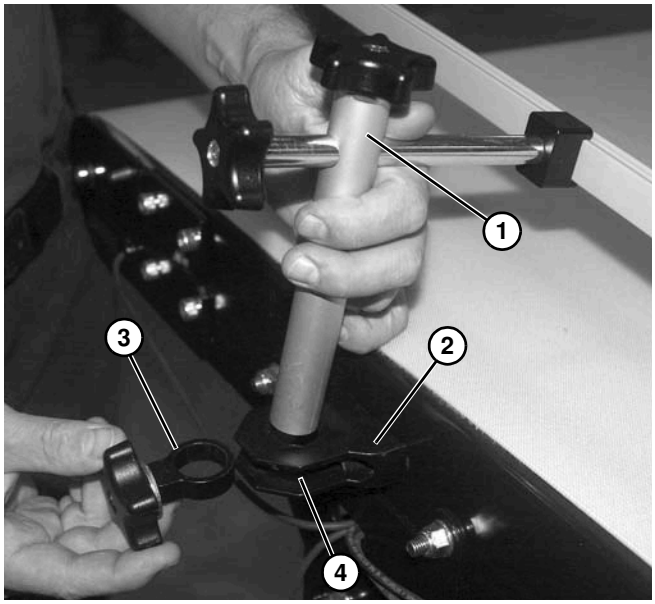


Figure 49

7. Adjust height of guide mounting shaft **(Figure 50, item 1)** and tighten lower knob **(Figure 50, item 2)**.

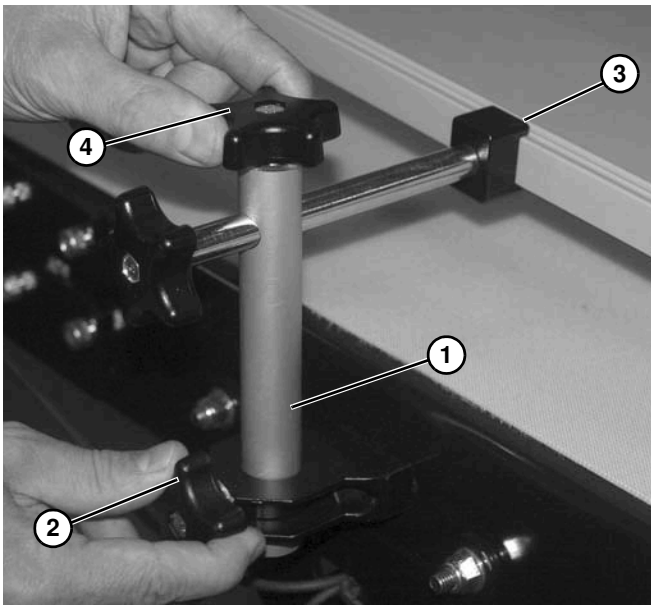


Figure 50

8. Adjust horizontal position of rail **(Figure 50, item 3)** on conveyor and tighten upper knob **(Figure 50, item 4).**
9. Repeat adjustment for remaining clamp assemblies.

Cleated

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Locate slot **(Figure 51, item 1)** on conveyor frame for installing tee bar **(Figure 51, item 2)**.

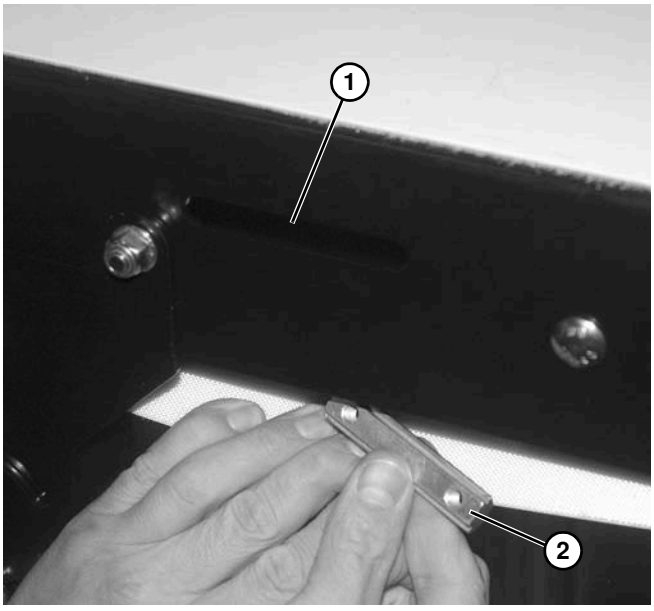


Figure 51

3. Fully seat tee bar **(Figure 52, item 1)** into slot.

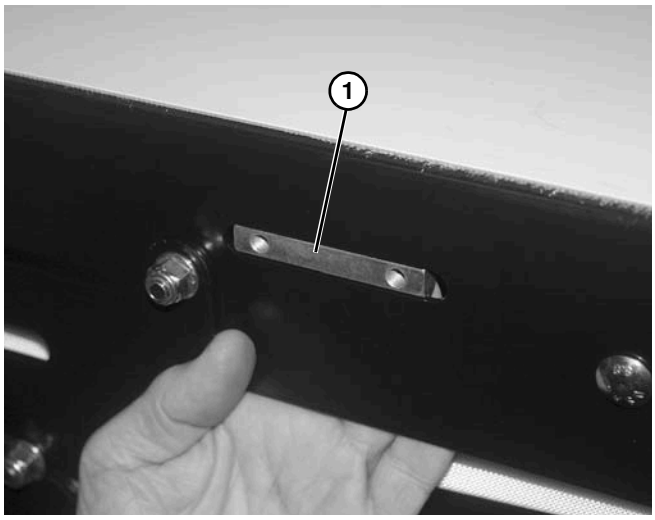


Figure 52

4. While holding tee bar **(Figure 53, item 1)** in position from inside the conveyor frame, loosely install mounting bracket **(Figure 53, item 2)** with screws **(Figure 53, item 3)**.

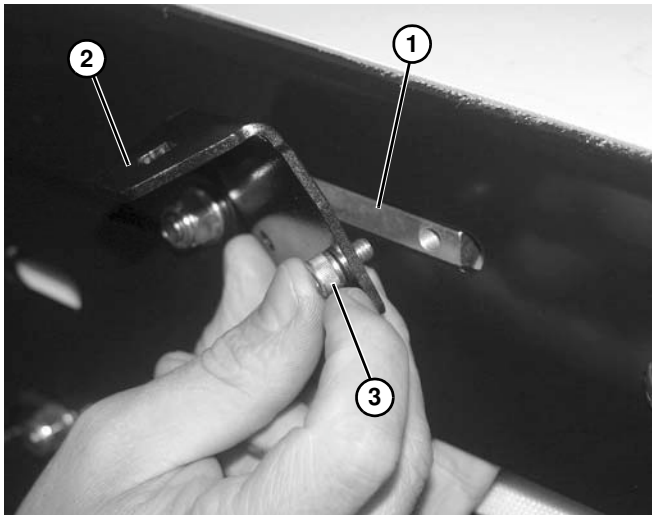


Figure 53

5. With mounting bracket **(Figure 54, item 1)** level with conveyor, tighten screws **(Figure 54, item 2)**.

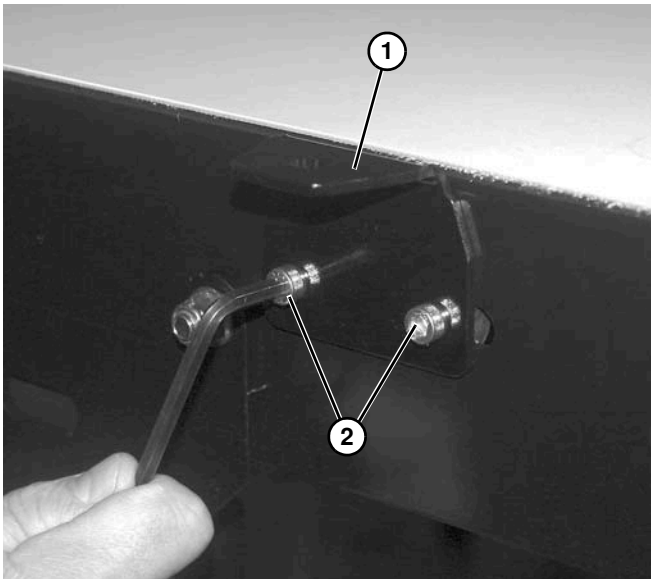


Figure 54

6. Repeat for remaining mounting brackets needed.
7. Install cleated guiding **(Figure 55, item 1)** onto mounting bracket **(Figure 55, item 2)** with carriage bolt **(Figure 55, item 3)** and nut **(Figure 55, item 4)**.

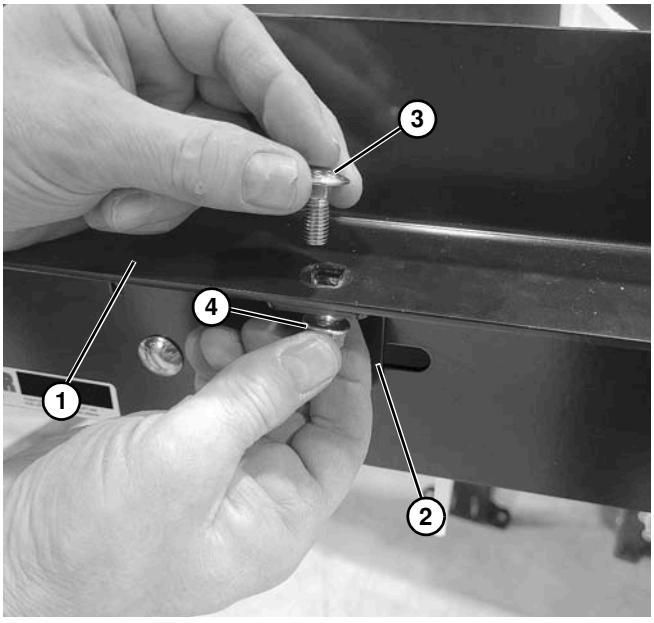


Figure 55

NOTE

*When installing guiding, verify that angled cut end **(Figure 56, item 1)** of guiding is on the infeed end **(Figure 56, item 2)** of conveyor belt.*

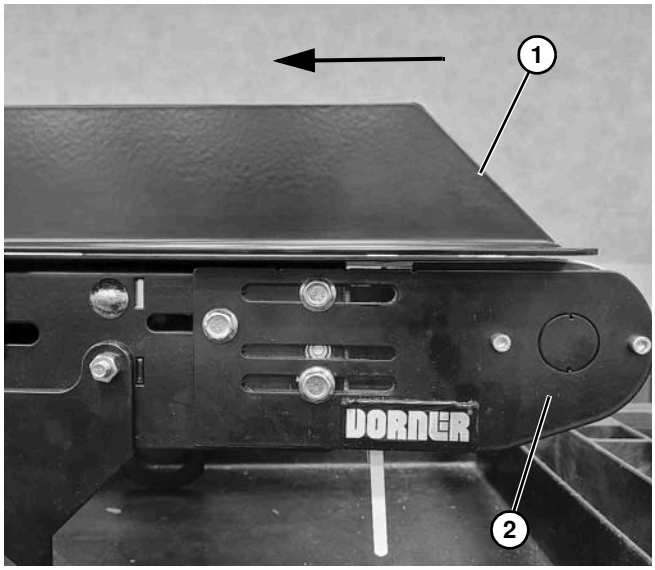


Figure 56

8. Repeat to install remaining carriage bolts and nuts to secure guiding.
9. Tighten carriage bolts and nuts **(Figure 57, item 1)**.

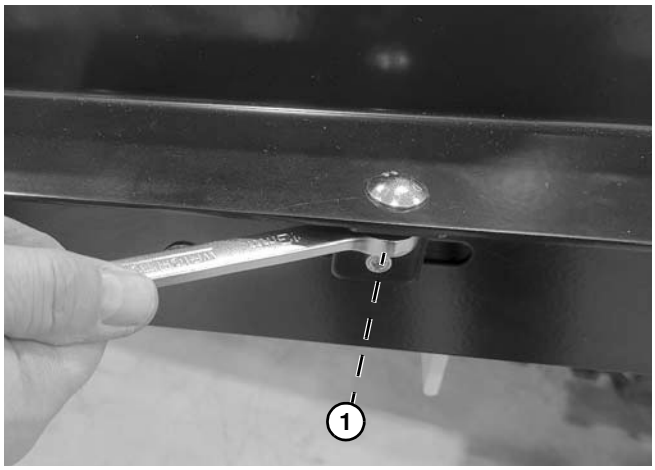


Figure 57

Tall Cleated Belt Return Support

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Loosely install two spacers **(Figure 58, item 1)** with screws **(Figure 58, item 2)** and weld nuts **(Figure 58, item 3)** onto cross support **(Figure 58, item 4)**.

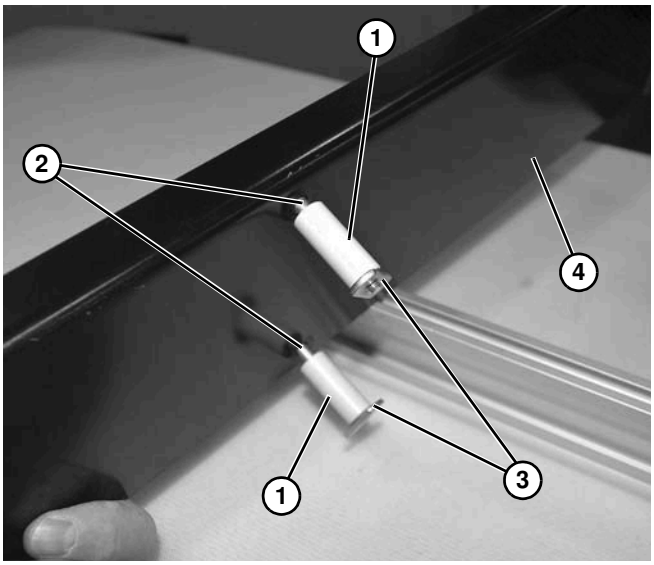


Figure 58

3. Install first weld nut **(Figure 59, item 1)** into slotted channel **(Figure 59, item 2)** of return support.

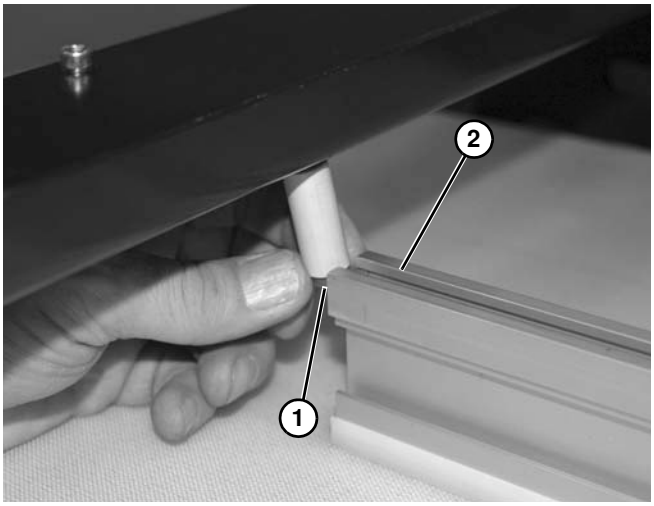


Figure 59

4. Continue to slide first weld nut in channel, and install second weld nut **(Figure 60, item 1)**.

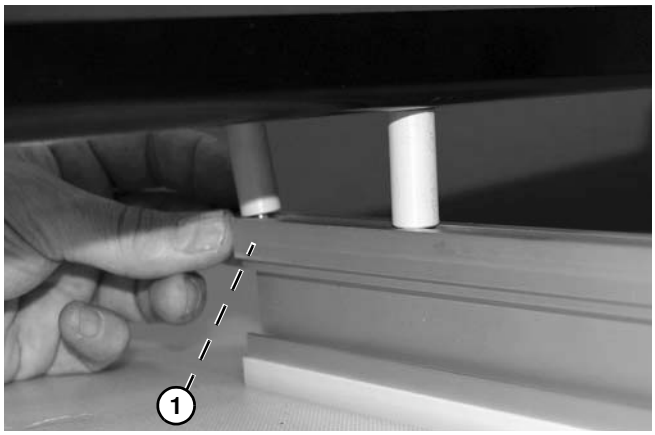


Figure 60

5. Position cross support **(Figure 61, item 1)** on return support **(Figure 61, item 2)**, and secure with two screws **(Figure 61, item 3)**. Do not fully tighten at this time.

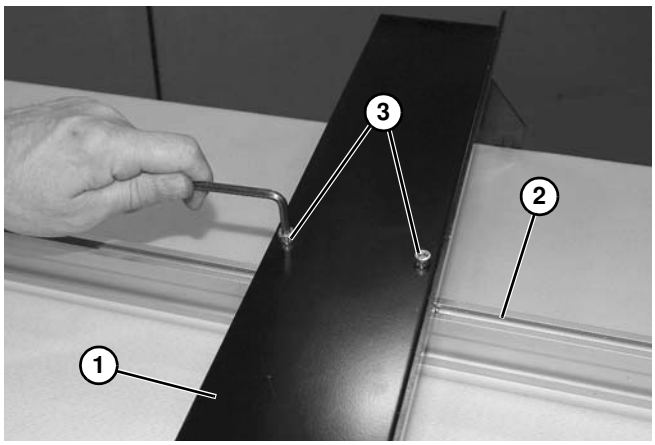


Figure 61

6. Repeat steps 2-5 to install additional cross supports, as needed.
7. Install wear strips **(Figure 62, item 1)** on return support.

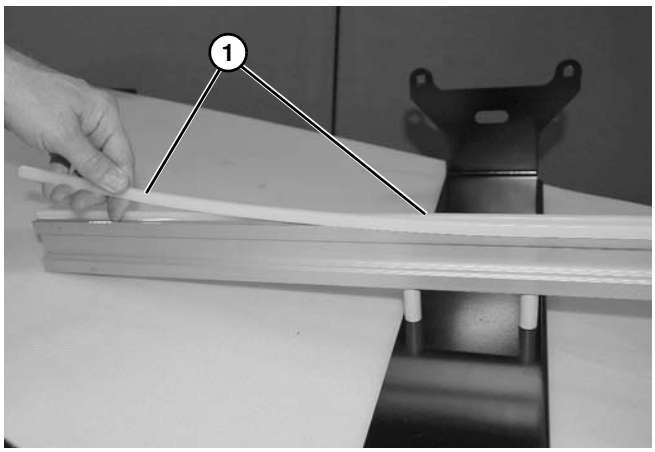


Figure 62

8. Install end cap guard **(Figure 63, item 1)** onto return support **(Figure 63, item 2)** with two roll pins **(Figure 63, item 3)**.

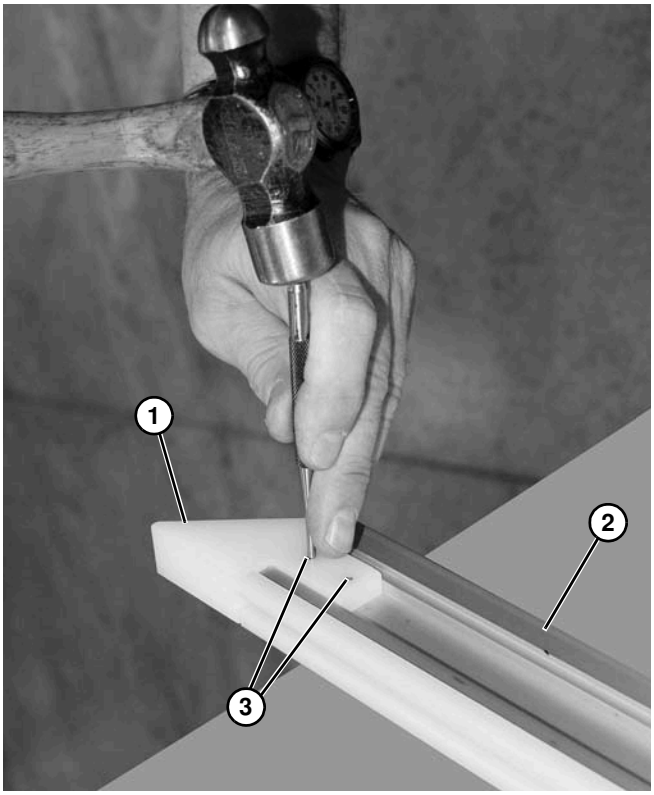


Figure 63

IMPORTANT

Assembly can be heavy. Use an assistant to help install belt guides, as needed.

9. Install cross support onto conveyor frame with two carriage bolts **(Figure 64, item 1)** and nuts **(Figure 64, item 2)**.

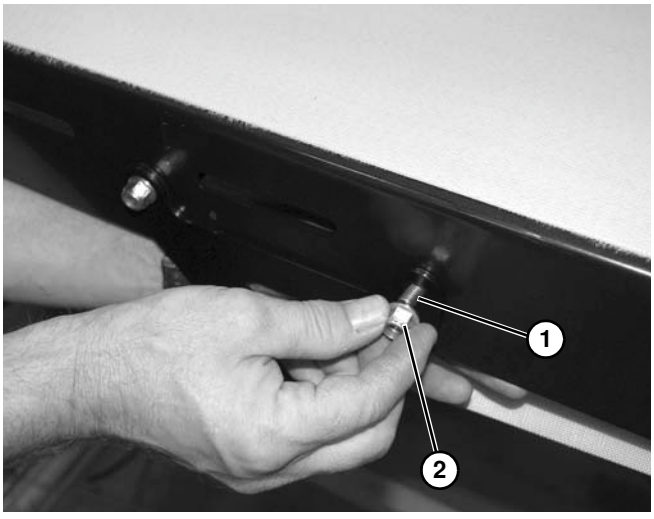


Figure 64

10. Repeat to install remaining cross supports onto conveyor frame, as needed.
11. Align end cap guard **(Figure 65, item 1)** on return support with end of conveyor **(Figure 65, item 2)**, and tighten screws **(Figure 63, item 3)**. Tighten remaining screws on cross supports, as needed.

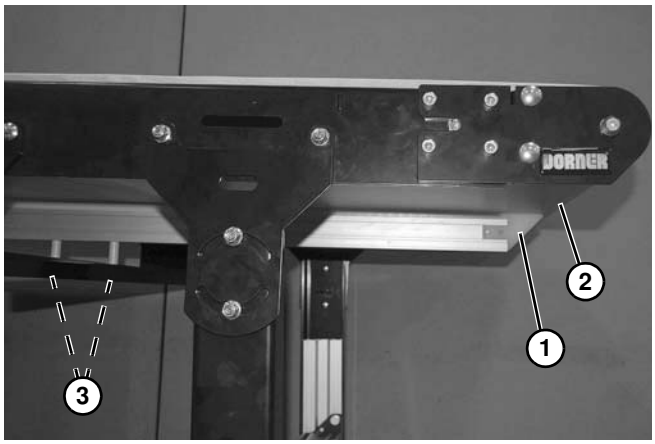


Figure 65

Required Tools

Standard Tools

- Hex-key wrenches:
  - 2.5 mm, 3 mm, 4 mm, 5 mm, 6 mm
- 13 mm wrench
- Torque wrench

Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner
- Clean entire conveyor and knurled pulley while disassembled
- Replace worn or damaged parts

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Stalling or slipping
- Damage to V-guide

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Improperly installed bottom wipers (if installed)
- Accumulated dirt in wipers (if installed)
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:

- Excessive load on belt
- Conveyor belt or drive timing belt are not properly tensioned
- Worn knurl or impacted dirt on drive pulley
- Intermittent jamming or drive train problems

Damage to V-guide indicates:

- Twisted or damaged conveyor frame
- Dirt impacted on pulleys
- Excessive or improper side loading

Cleaning

Use mild soap and water. Do not soak the belt.

For /05 woven polyester and /06 black anti-static belts, use a bristled brush to improve cleaning.

Conveyor Belt Replacement

⚠ WARNING

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

Conveyor Belt Replacement Sequence

- Release tension
- Remove old conveyor belt
- Install new conveyor belt
- Tension conveyor belt

Belt Removal

End Drive and iDrive Conveyors

⚠ WARNING

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

PROVIDE SUPPORT UNDERNEATH THE CONVEYOR WHEN CHANGING THE BELT.

1. If equipped, remove return rollers and guiding and accessories from one side of conveyor.

2. Place temporary support stands **(Figure 66, item 1)** at both ends of the conveyor.

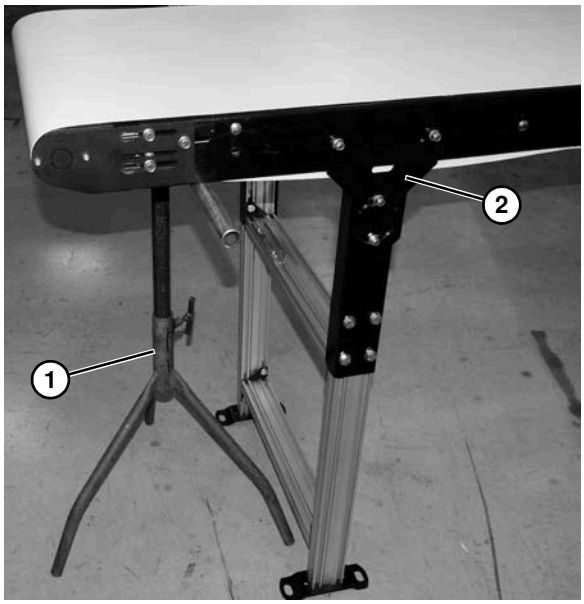


Figure 66

3. Remove mounting brackets **(Figure 66, item 2)** from one side of conveyor.
4. On tension end of the conveyor, loosen the three screws **(Figure 67, item 1)** on each side of the conveyor.

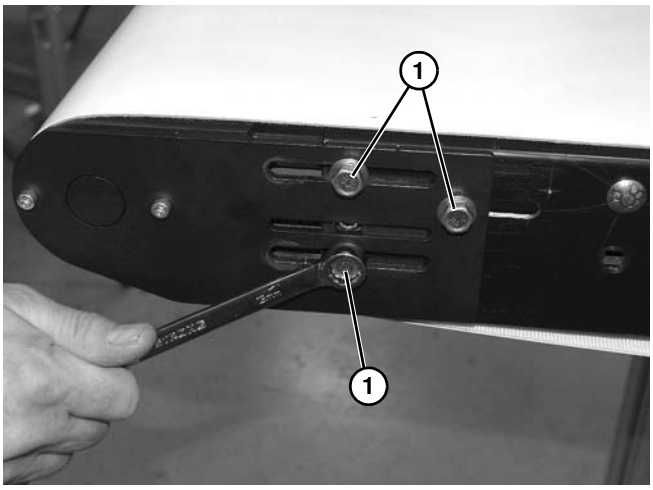


Figure 67

5. Loosen the tensioner screw **(Figure 68, item 1)** on each side of conveyor to move the tension head plate assembly **(Figure 68, item 2)** inward and fully release tension on belt.

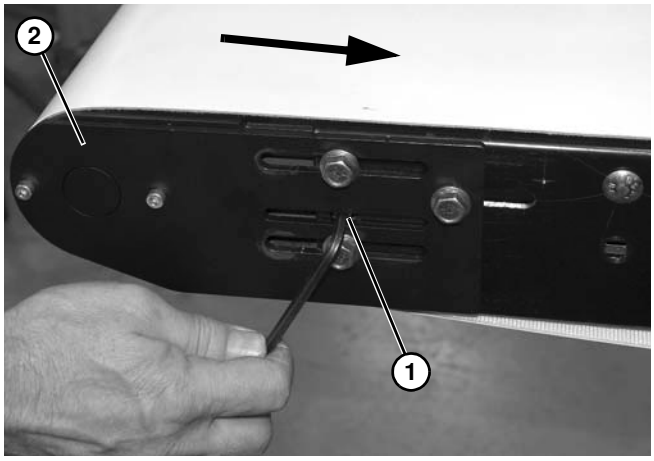


Figure 68

6. On drive end of conveyor, loosen the four screws **(Figure 69, item 1)** on each side of conveyor.

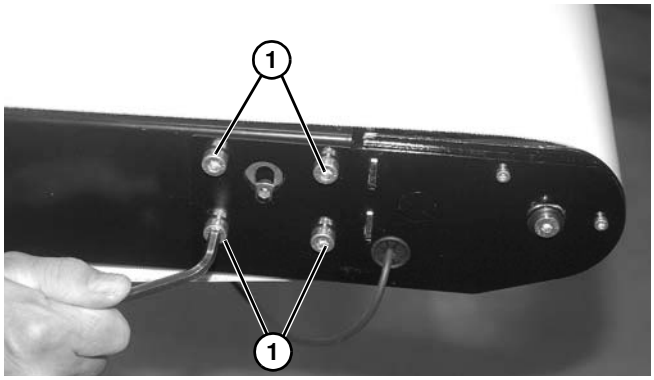


Figure 69

7. Loosen the tracking cam **(Figure 70, item 1)** on each side of conveyor to move the drive head plate assembly **(Figure 70, item 2)** inward.

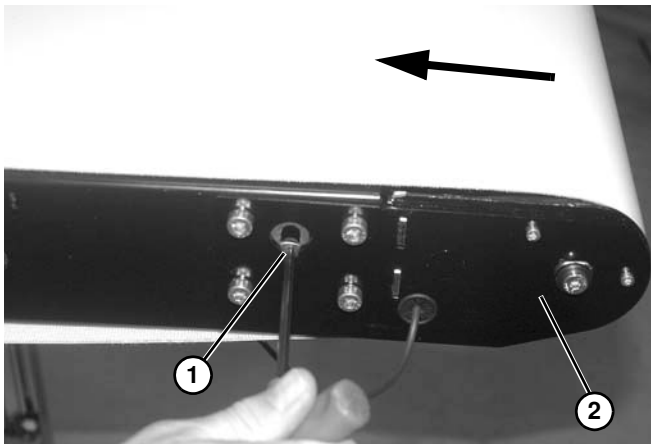


Figure 70

8. Remove belt **(Figure 71, item 1)** from conveyor, one stand at a time. Start on one end of conveyor and work down to opposite end.

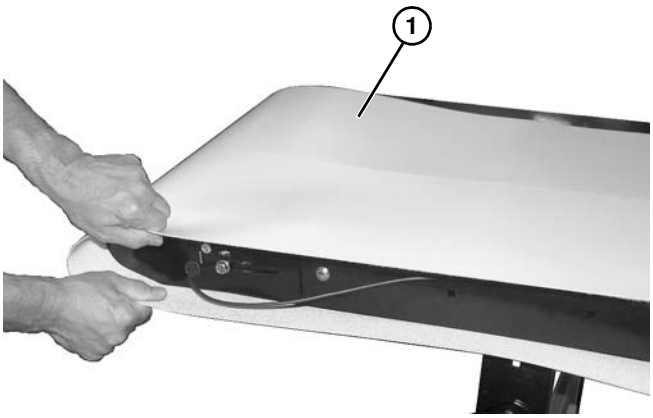


Figure 71

Center Drive Conveyors

⚠ WARNING

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

PROVIDE SUPPORT UNDERNEATH THE CONVEYOR WHEN CHANGING THE BELT.

1. Place temporary support stands **(Figure 72, item 1)** at both ends of the conveyor.

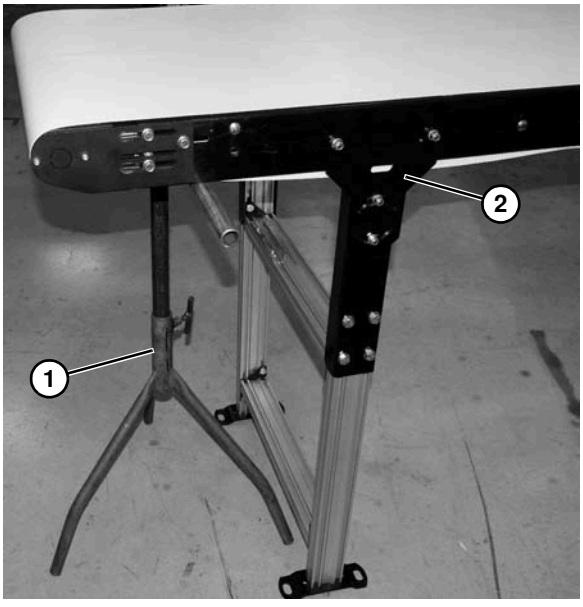


Figure 72

2. Remove mounting brackets **(Figure 72, item 2)** from one side of conveyor.
3. If equipped, remove return rollers, guiding and accessories from one side of conveyor.
4. Remove two screws **(Figure 73, item 1)** and tensioning guard **(Figure 73, item 2)** from each side of center drive.

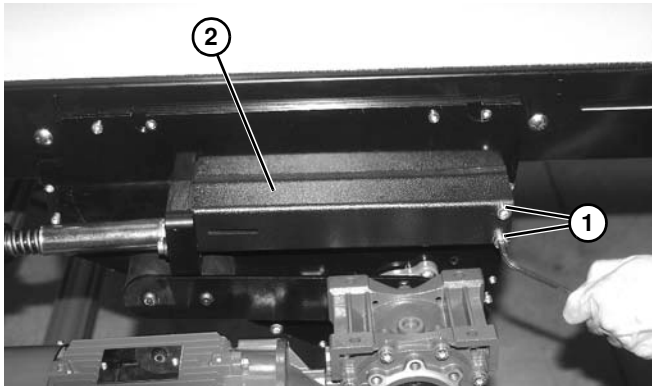


Figure 73

5. Loosen tension on drive belt by rotating tensioning knob **(Figure 74, item 1)** counterclockwise on both sides of conveyor.

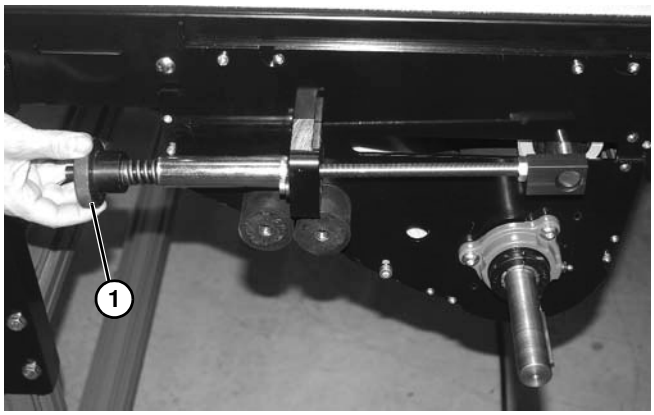


Figure 74

6. Temporarily support idler guard assembly **(Figure 75, item 1)**. Remove screws **(Figure 75, item 2)**.

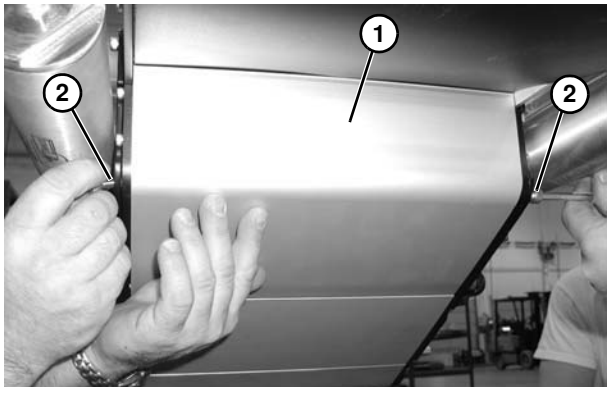


Figure 75

7. Swing down idler guard assembly **(Figure 76, item 1)**. Remove screw **(Figure 76, item 2)** from both sides of center drive and remove idler guard assembly **(Figure 76, item 1)**.

Figure 76

8. Temporarily support the tensioning roller guard **(Figure 77, item 1)**. Remove screw **(Figure 77, item 2)** on each side of center drive and remove tensioning roller guard **(Figure 77, item 1)** and **(Figure 78, item 2)**.

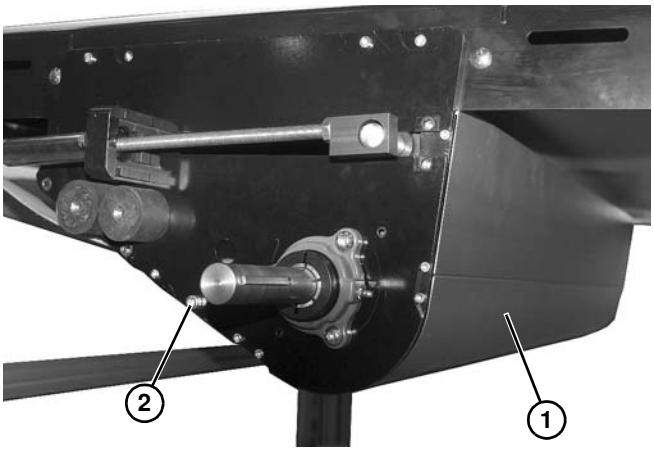


Figure 77

9. Loosen tensioning roller set screws **(Figure 78, item 1)**.

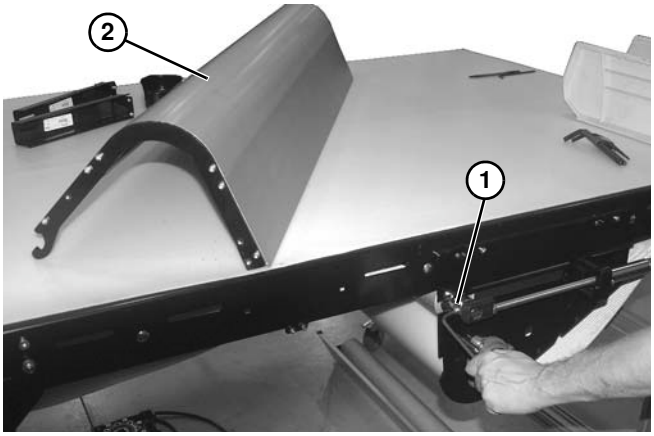


Figure 78

10. Push shaft **(Figure 79, item 1)** through block **(Figure 79, item 2)**, and slide block towards base end **(Figure 79, item 3)** of tensioner.

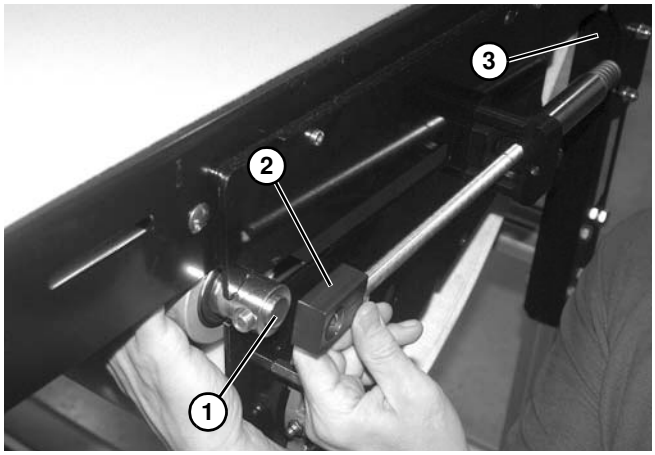


Figure 79

11. Push shaft **(Figure 80, item 1)** through block **(Figure 80, item 2)** on opposite side of center drive, and slide block toward air cylinder **(Figure 80, item 3)**.

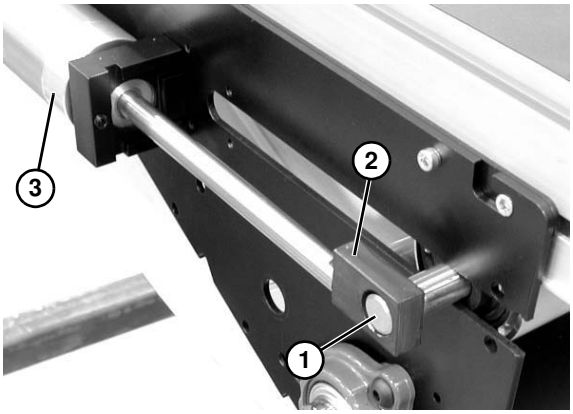


Figure 80

IMPORTANT

Use caution when removing components. Pulleys can be very heavy. Use an assistant to help remove pulley, as needed.

12. Remove locking collar **(Figure 81, item 1)**, and slide out tensioning pulley **(Figure 81, item 2)**.

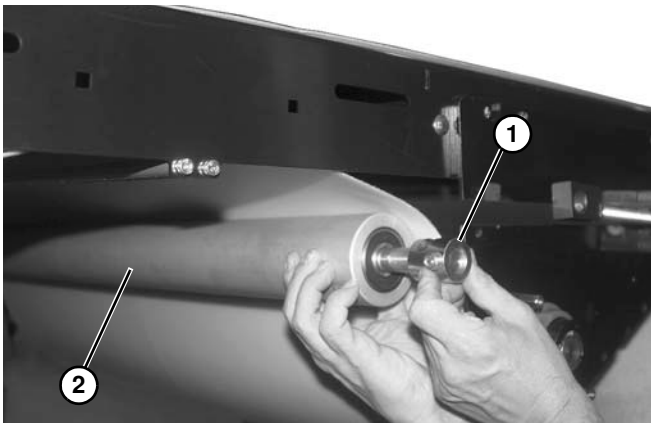


Figure 81

13. Remove belt **(Figure 82, item 1)** from conveyor, one stand at a time. Start on one end of conveyor and work down to opposite end.

Figure 82

14. Remove belt **(Figure 83, item 1)** from center drive module **(Figure 83, item 2)** and conveyor.

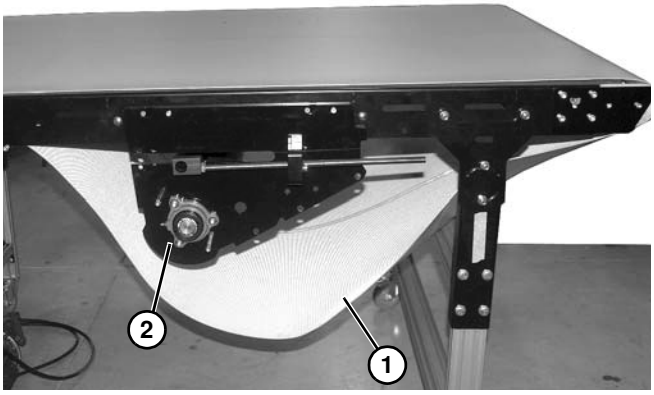


Figure 83

Belt Installation

End Drive and iDrive Conveyors

⚠ WARNING

Removing stands without support will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE CONVEYOR WHEN CHANGING THE BELT.

1. Ensure a temporary support stand **(Figure 84, item 1)** is placed at both ends of the conveyor.

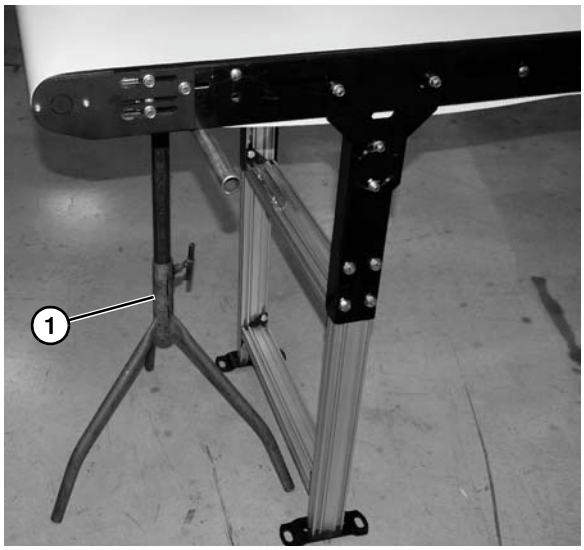


Figure 84

2. Orient belt so splice outer fingers **(Figure 85, item 1)** point in the direction of belt travel as identified by the conveyor directional label **(Figure 85, item 2)**.

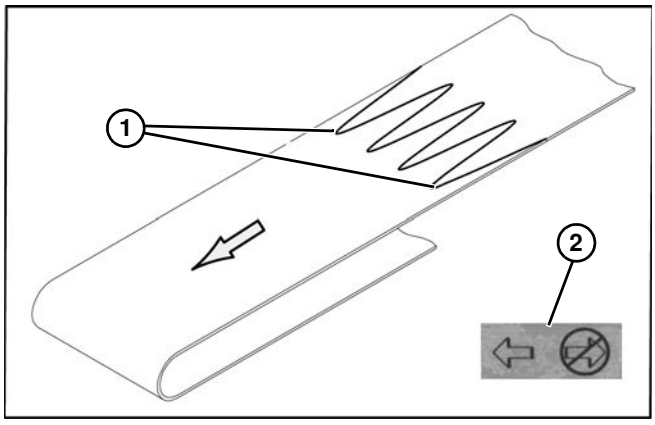


Figure 85

3. Install belt **(Figure 86, item 1)** on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands **(Figure 86, item 2)**.

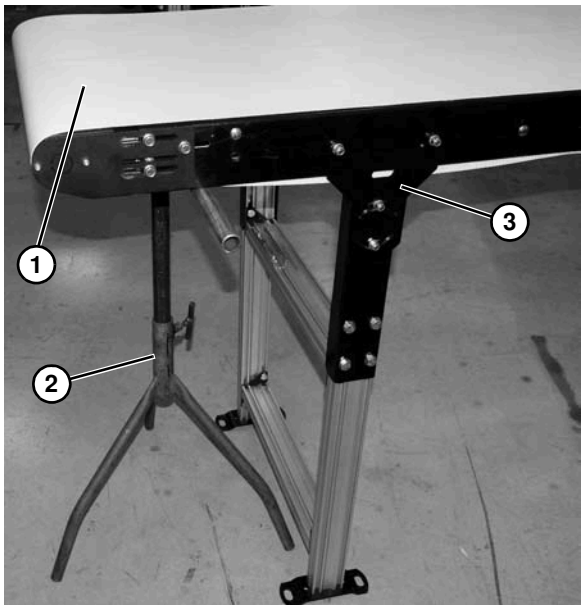


Figure 86

4. Re-install conveyor mounting brackets **(Figure 86, item 3)** and secure with screws.
5. Tension belt. Refer to "Conveyor Belt Tensioning" on page 33.
6. If equipped, install return rollers and guiding.

Center Drive Conveyors

⚠ WARNING

Removing stands without support will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE CONVEYOR WHEN CHANGING THE BELT.

1. Ensure a temporary support stand **(Figure 87, item 1)** is placed at both ends of the conveyor.

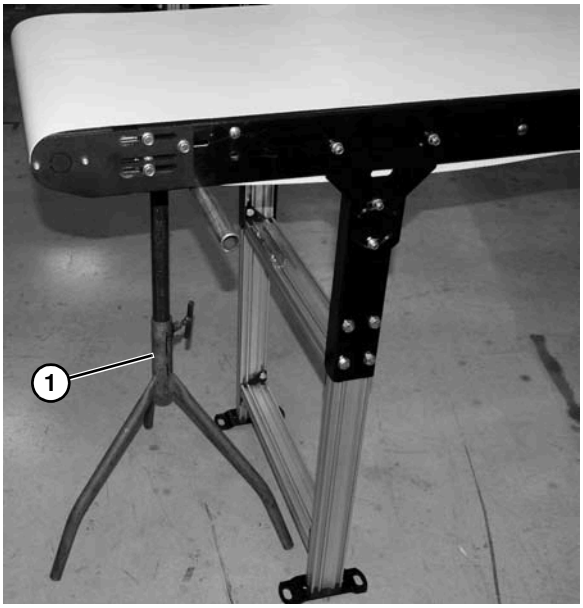


Figure 87

2. Orient belt so splice outer fingers **(Figure 88, item 1)** point in the direction of belt travel as identified by the conveyor directional label **(Figure 88, item 2)**.

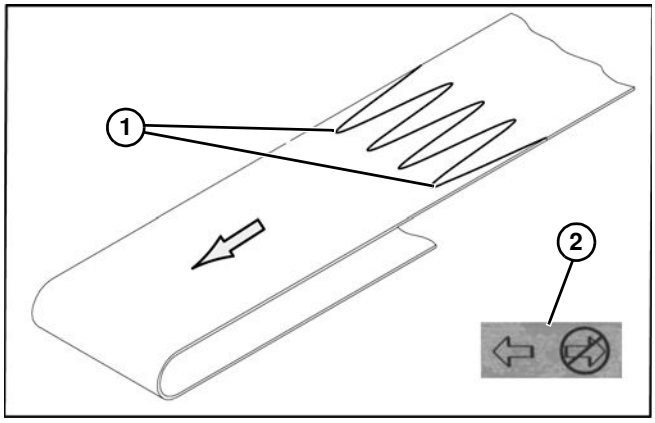


Figure 88

3. Install belt **(Figure 89, item 1)** on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands **(Figure 89, item 2)**.

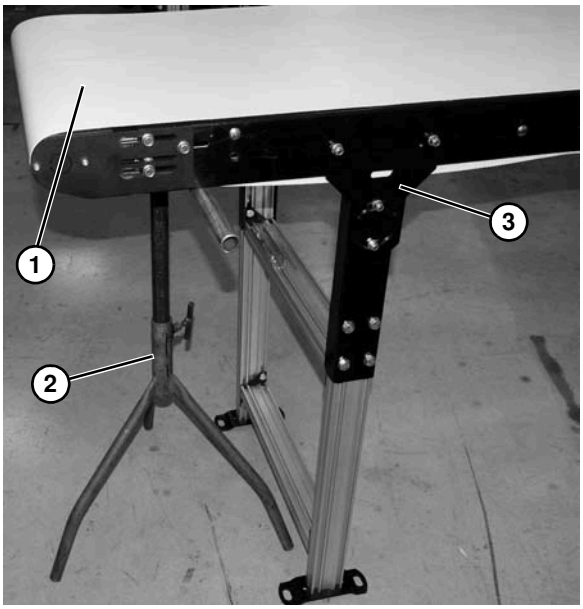


Figure 89

4. Reverse steps 1 thru 12 of the "Belt Removal - Center Drive Conveyors" section on page 29.
5. Re-install conveyor mounting brackets **(Figure 89, item 3)** and secure with screws.
6. If equipped, install return rollers and guiding.
7. Adjust tensioning knob **(Figure 90, item 1)** clockwise on each side of conveyor to apply tension to the belt. Refer to "Conveyor Belt Tensioning" section on page 33 for more information.

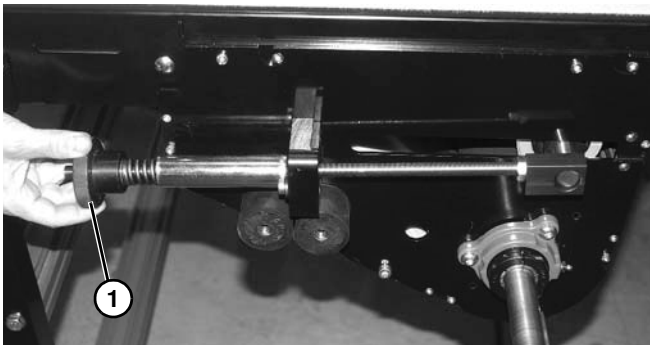


Figure 90

8. Install tensioning guard **(Figure 91, item 1)** and secure with two screws **(Figure 91, item 2)**. Repeat on opposite side.

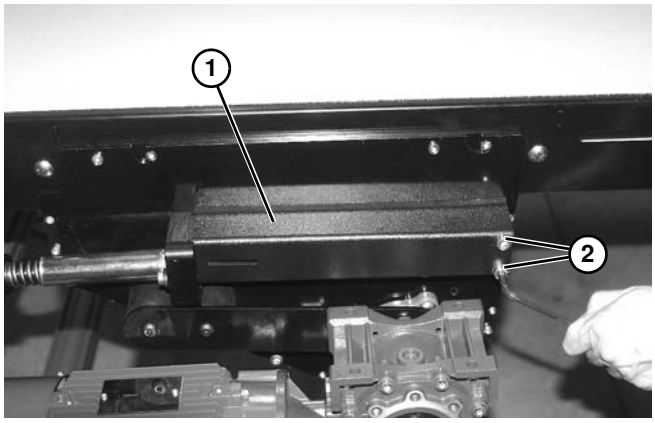


Figure 91

Conveyor Belt Tensioning

⚠ WARNING

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

End Drive Conveyors

1. On tension end of conveyor, loosen the three screws **(Figure 92, item 1)** on each side of conveyor.

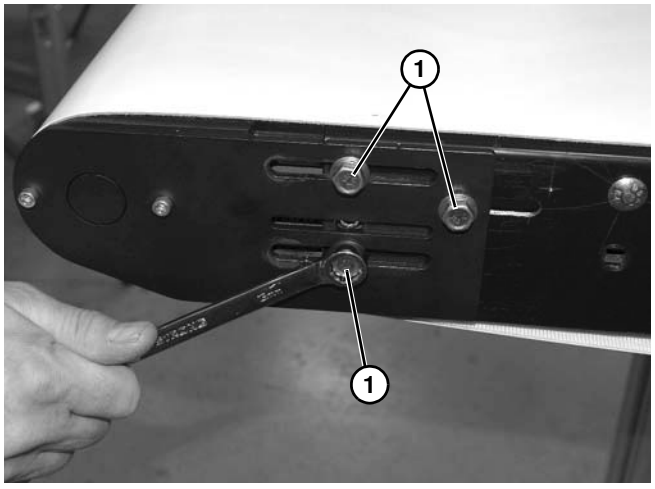


Figure 92

2. Tighten the tensioner screw **(Figure 93, item 1)** on each side of conveyor to move the tension head plate assembly **(Figure 93, item 2)** outward, or loosen to move head plate assembly inward.

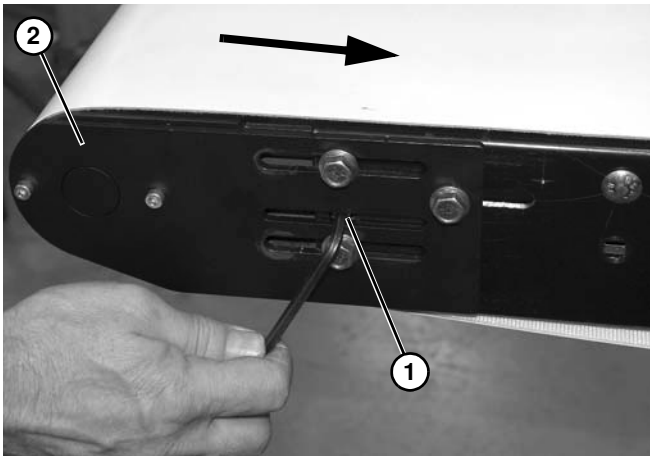


Figure 93

NOTE

Bowing of the belt may occur if excessive tension is applied to the belt. Do not over tension the belt.

NOTE

On pinion gear, do not exceed a torque of 11.3 Nm (100 in lbs). Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten three screws **(Figure 92, item 1)** on both sides of conveyor to 16.5 Nm (146 in lbs).
4. If belt tracking is necessary, refer to "Conveyor Belt Tracking" on page 35.

Center Drive Conveyors

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

NOTE

For the longest belt and bearing life, tension applied should be the minimum required to move loaded conveyor.

⚠ WARNING

Threaded rod end may be sharp. Cover with guard while adjusting tension knob.

HANDLE WITH CARE.

1. To tension belt, turn knurled knob **(Figure 94, item 1)** on each side of center drive unit clockwise until tensioning spring **(Figure 94, item 2)** is exposed only 12 mm (1/2"). Test conveyor with a load and if slippage occurs, turn knurled knob **(Figure 94, item 1)** on each side of center drive unit clockwise until tensioning spring **(Figure 94, item 2)** is completely behind spring cover **(Figure 94, item 3)**. There should be a minimum 3 mm (1/8") gap between hand knob **(Figure 94, item 1)** and spring cover **(Figure 94, item 3)**.

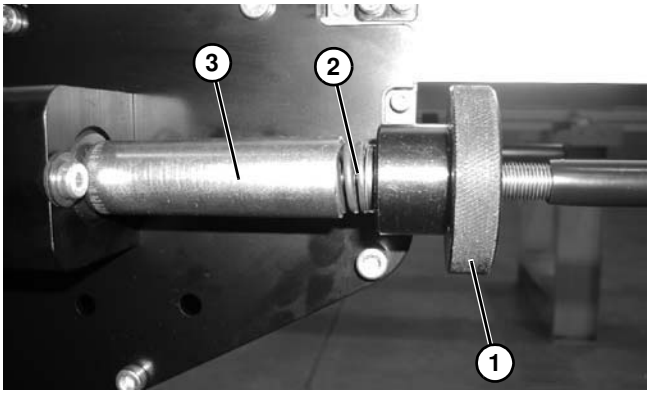


Figure 94

2. As normal belt stretch occurs over time, additional spring length **(Figure 94, item 2)** will be exposed out of the spring cover **(Figure 94, item 3)**. When the spring exposed exceeds 12 mm (1/2") from the original setting or if conveyor belt slippage occurs, retighten knurled hand knob **(Figure 94, item 1)** on each side of center drive unit clockwise to the original setting.

3. If proper belt tension cannot be achieved before the out of tension indicator **(Figure 95, item 1)** begins to turn red, the belt must be replaced.

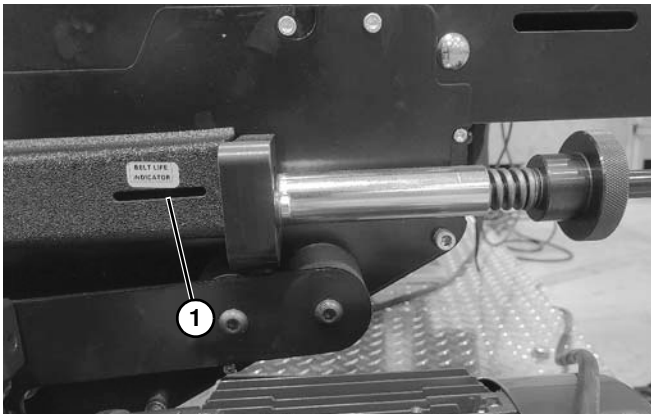


Figure 95

4. If belt tracking is necessary, refer to "Conveyor Belt Tracking" on page 35.

Conveyor Belt Tracking

V-Guided Belts

V-guides on belts help maintain proper belt tracking. Track as needed to reduce belt bulge from center of belt **(Figure 96)**. See steps below in "Non V-guided Belts" procedure for adjusting for any belt bulging. Belt bulge will be minimal when belt is properly tracked.

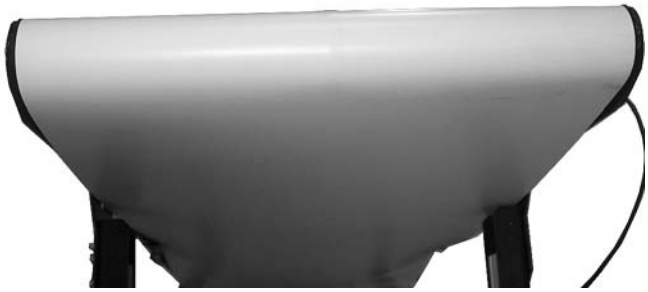


Figure 96

Non V-Guided Belts

Non V-guided belt conveyors are equipped with belt tracking assemblies for belt tracking adjustment.

When adjusting belt tracking, always adjust the discharge end of the conveyor first. To adjust belt tracking:

1. On tension end of the conveyor, identified by the pinion access slot **(Figure 97, item 1)**, loosen the two tail screws **(Figure 97, item 2)** on both sides of the conveyor securing push head plate assembly **(Figure 97, item 3)**.

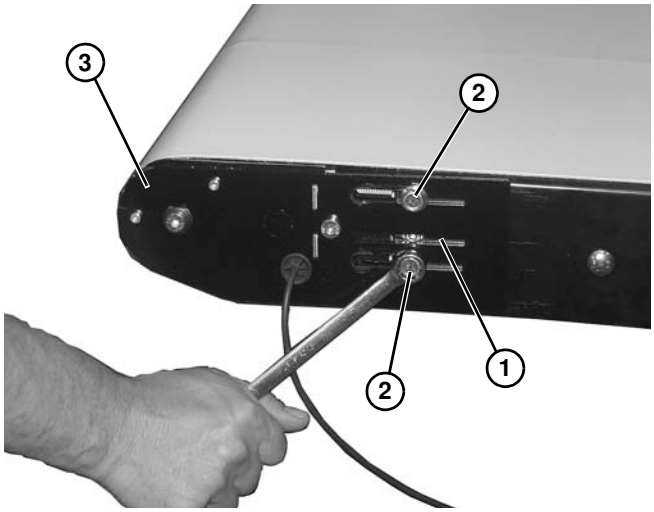


Figure 97

2. With the conveyor running, use a 5 mm hex-key wrench to rotate the tracking cam **(Figure 98, item 1)** in small increments until the belt tracks in the center of the conveyor. Then while holding the cam in position, re-tighten the two head plate fastening screws **(Figure 98, item 2)**.

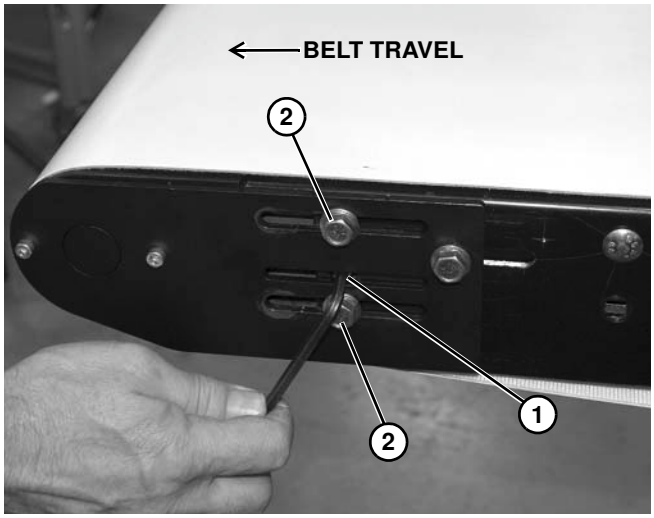


Figure 98

Pulley Removal

⚠ WARNING

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

Remove conveyor belt to access pulley(s). See "Conveyor Belt Replacement" on page 27. Remove the desired pulley following the corresponding instructions below:

- **A** – Tension Tail Pulley Removal
- **B** – Drive Tail Pulley Removal
- **C** – Nose Bar Tail Pulley Removal
- **D** – iDrive Tension End Pulley Removal

A – Tension Tail Pulley Removal

1. On tension tail end of conveyor, loosen the three screws **(Figure 99, item 1)** on each side of conveyor.

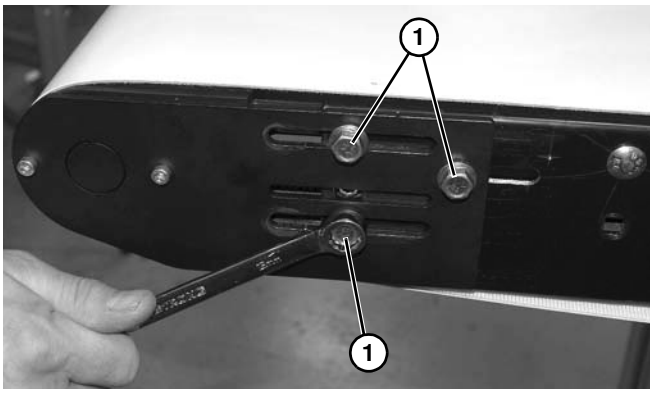


Figure 99

2. Loosen the tensioner screw **(Figure 100, item 1)** on each side of conveyor to move the tension head plate assembly **(Figure 100, item 2)** inward and fully release tension on belt.

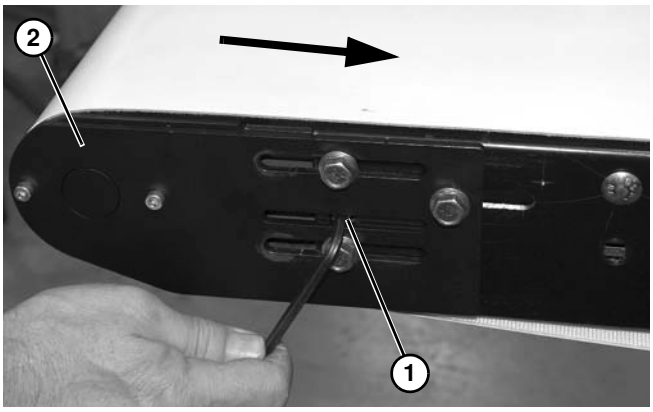


Figure 100

NOTE

Support the tension tail end of conveyor before removing screws.

3. Remove two screws **(Figure 101, item 1)** and tensioner assembly **(Figure 102, item 1)** from tension tail end of conveyor.

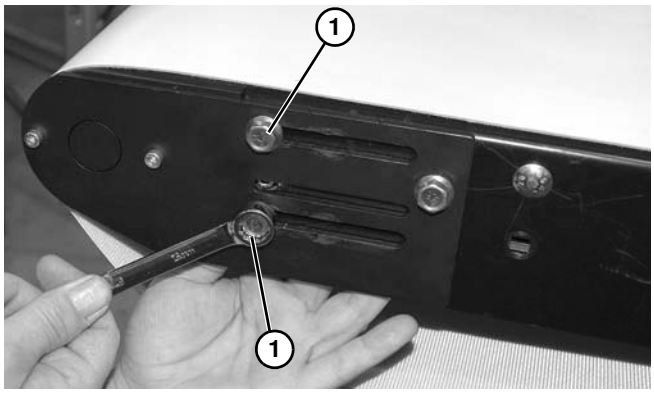


Figure 101

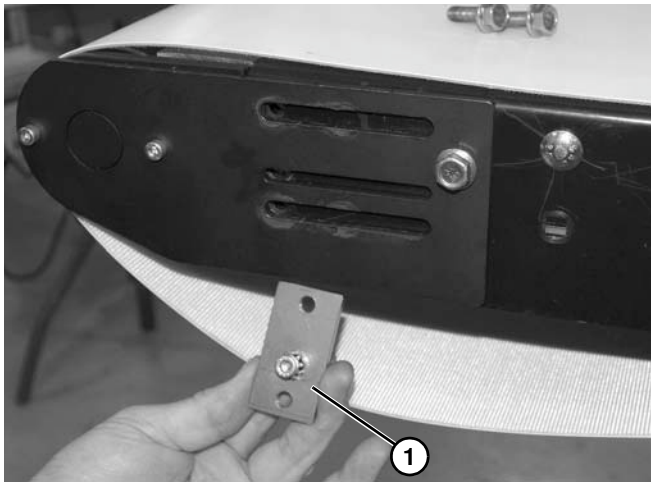


Figure 102

4. Repeat on the opposite side of tension tail end.
5. Remove remaining screw **(Figure 103, item 1)** on each side.

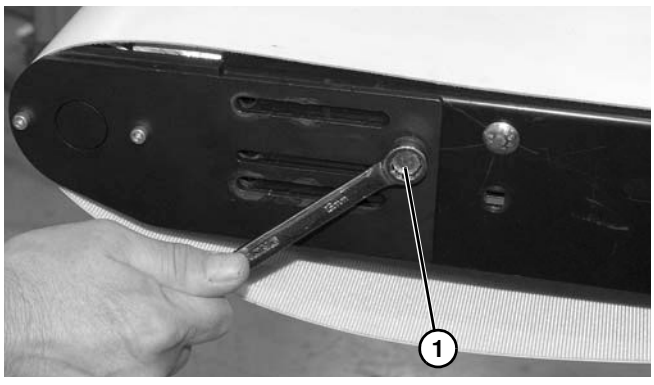


Figure 103

6. Pull tension tail end **(Figure 104, item 1)** outward to release tension tail plate **(Figure 105, item 1)** from slot **(Figure 105, item 2)** on conveyor frame, and remove tension tail end **(Figure 105, item 3)** from conveyor.

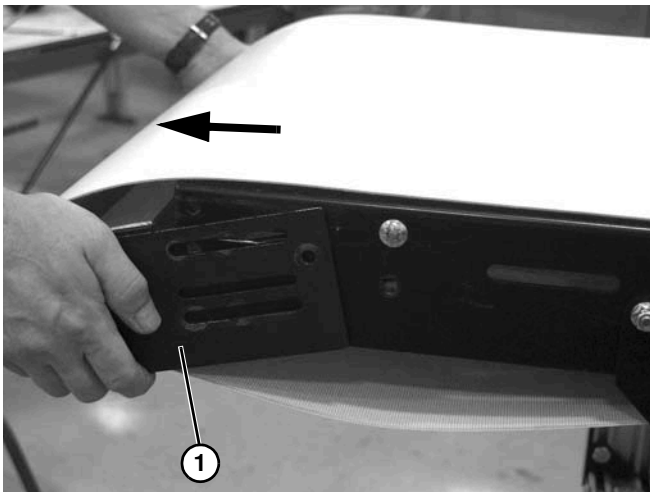


Figure 104

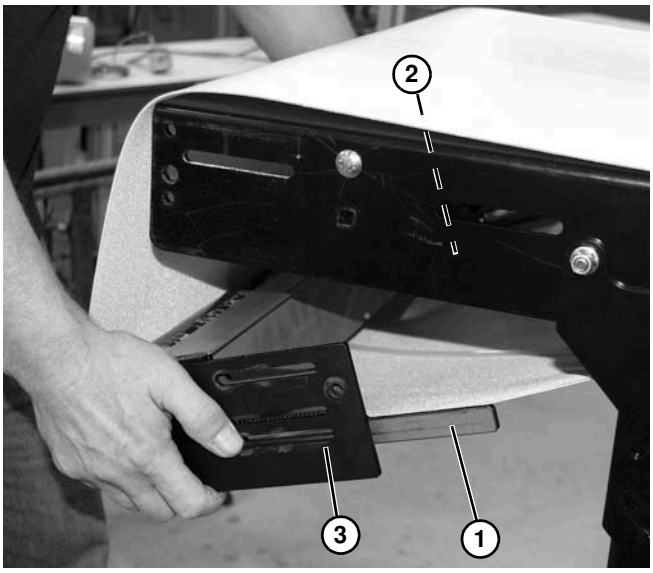


Figure 105

7. Remove two screws **(Figure 106, item 1)** securing cover plate from tension tail assembly.

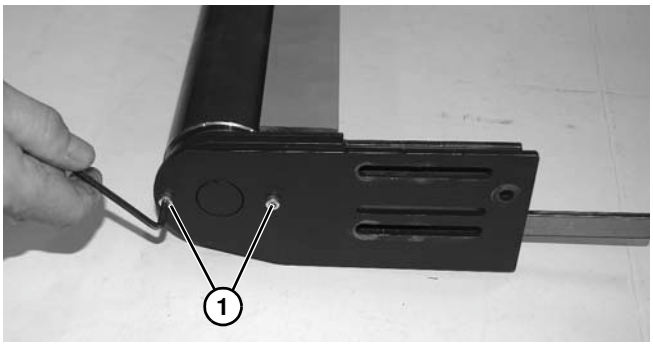


Figure 106

8. Remove cover plate **(Figure 107, item 1)** from tension tail assembly.

Figure 107

9. Remove bearing housing **(Figure 108, item 1)** from tension tail assembly.

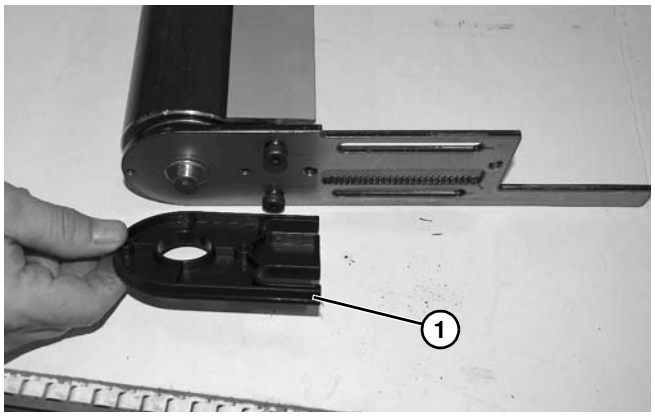


Figure 108

10. Remove two shoulder screws **(Figure 109, item 1)** and filler bracket **(Figure 110, item 1)** from tension tail assembly.

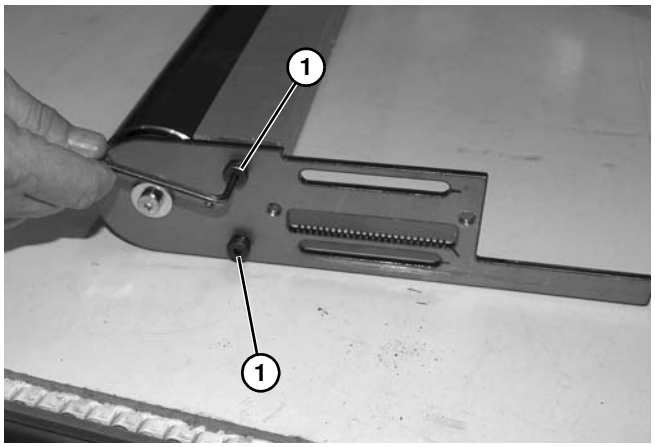


Figure 109

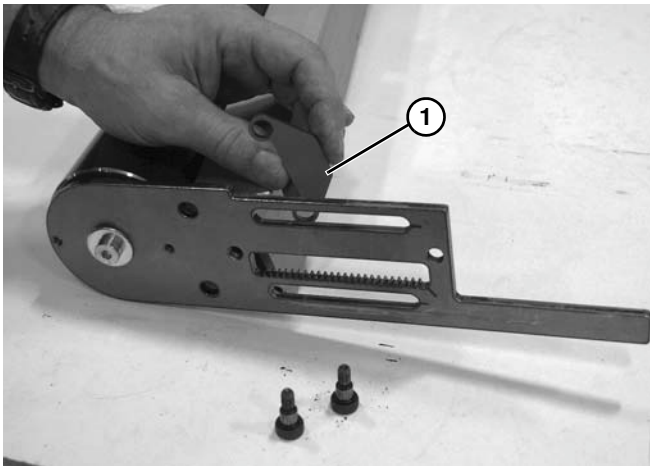


Figure 110

11. Remove screw **(Figure 111, item 1)** and washer **(Figure 111, item 2)** securing tension tail plate **(Figure 111, item 3)** onto pulley.

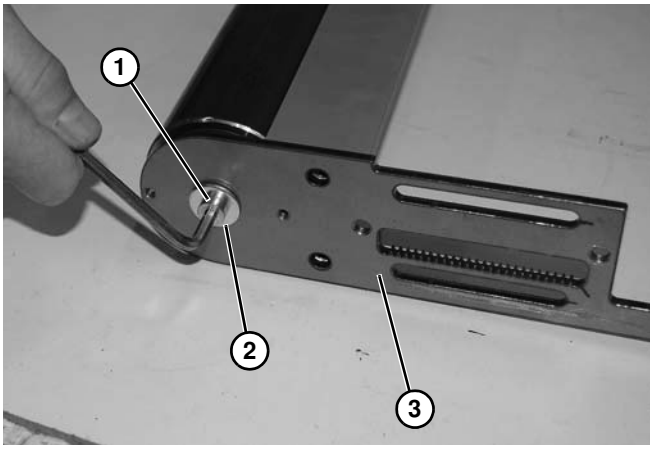


Figure 111

12. Remove tension tail plate **(Figure 112, item 1)** from pulley **(Figure 112, item 2)**.

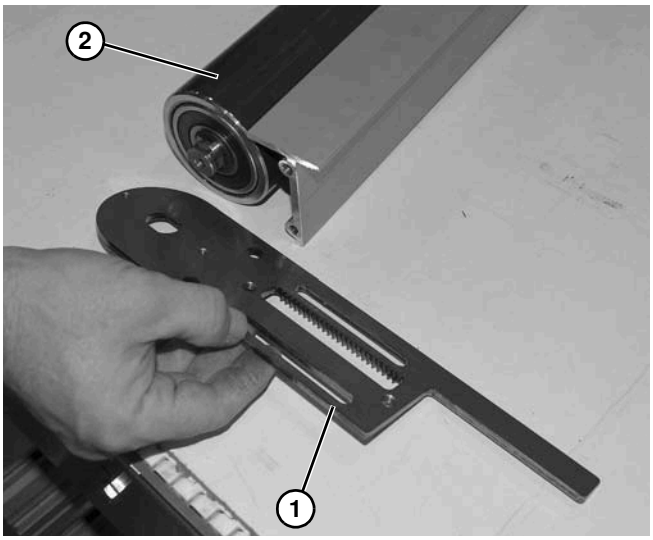


Figure 112

13. On opposite end, remove screw and washer **(Figure 113, item 1)**, and remove pulley **(Figure 113, item 2)** from remaining tension tail plate **(Figure 113, item 3)**.

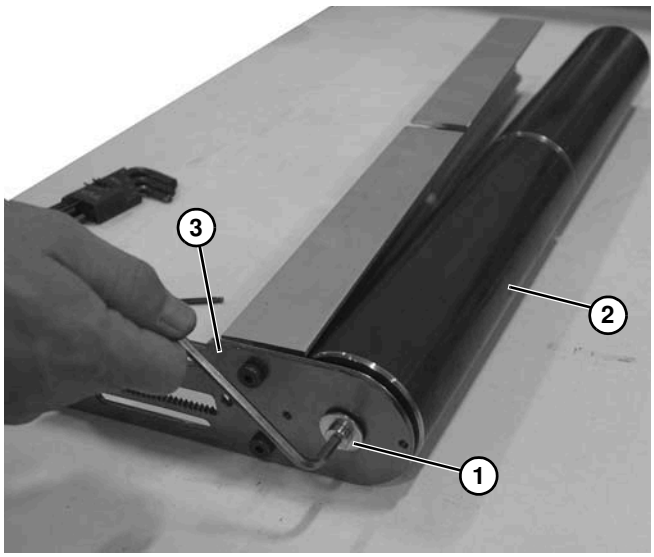


Figure 113

14. Remove two screws **(Figure 114, item 1)** and remove tension tail plate **(Figure 114, item 2)** from articulation bar **(Figure 114, item 3)**.

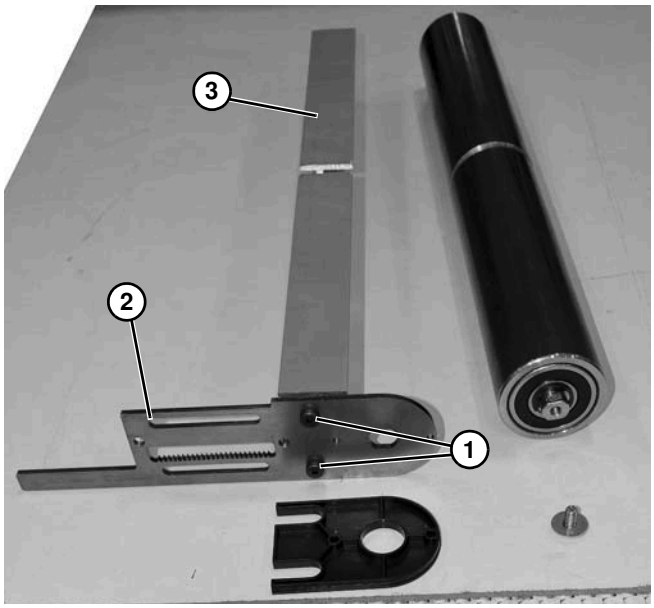


Figure 114

15. Replace components, as needed.
16. Install in reverse order of removal.

B – Drive Tail Pulley Removal

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

1. Remove the gearmotor mounting package.
2. Loosen four screws **(Figure 115, item 1)** on both sides of conveyor.

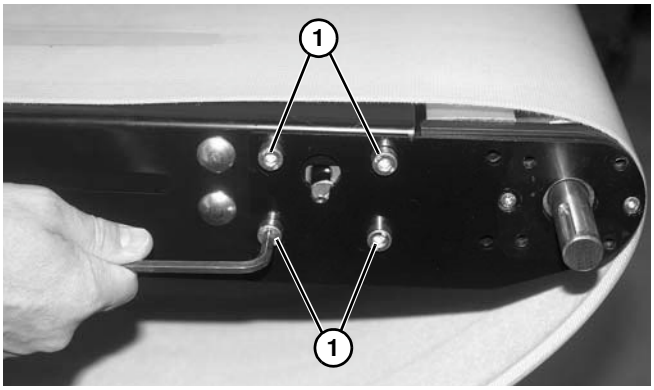


Figure 115

3. Remove tracking cam **(Figure 116, item 1)** by rotating so that the arrow **(Figure 116, item 2)** is facing directly up, and remove from conveyor.

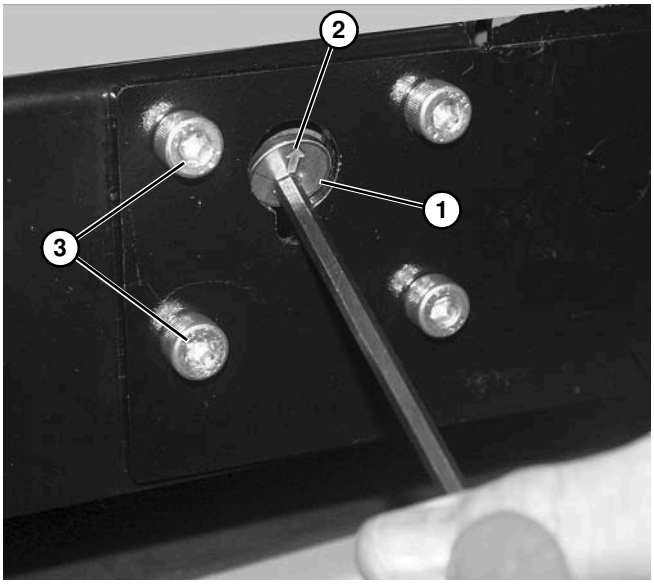


Figure 116

4. Remove two screws **(Figure 116, item 3)**.
5. Remove drive tail end from conveyor frame by further loosening two screws **(Figure 117, item 1)** on both sides of conveyor.

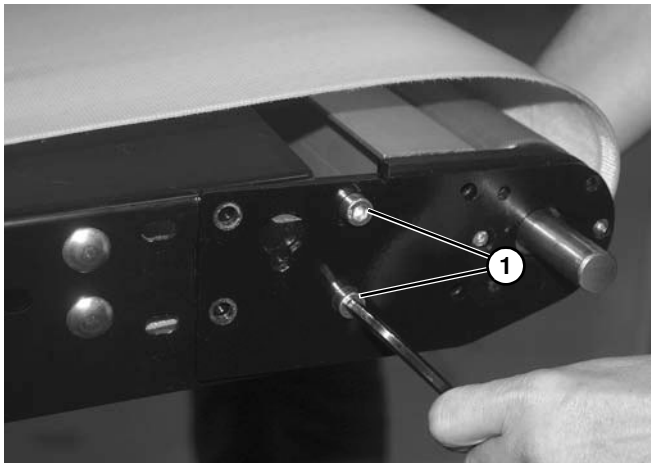


Figure 117

IMPORTANT

Use caution when removing components. Drive tail can be very heavy. Use an assistant to help remove drive tail assembly, as needed.

6. Remove drive tail end cover plate **(Figure 118, item 1)** from conveyor frame **(Figure 118, item 2)** on both sides of conveyor.

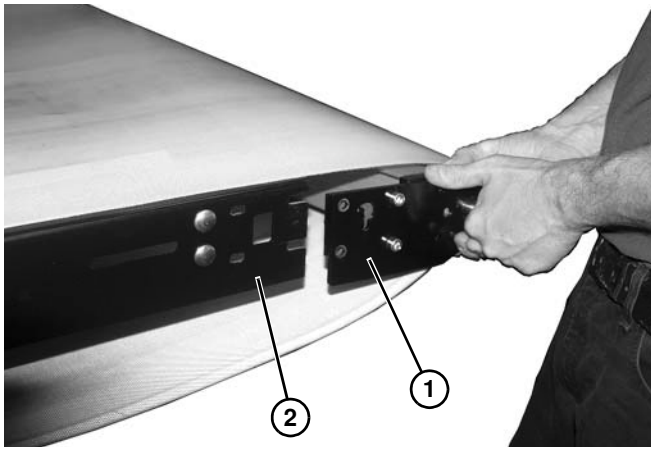


Figure 118

7. Remove drive tail end **(Figure 119, item 1)**.

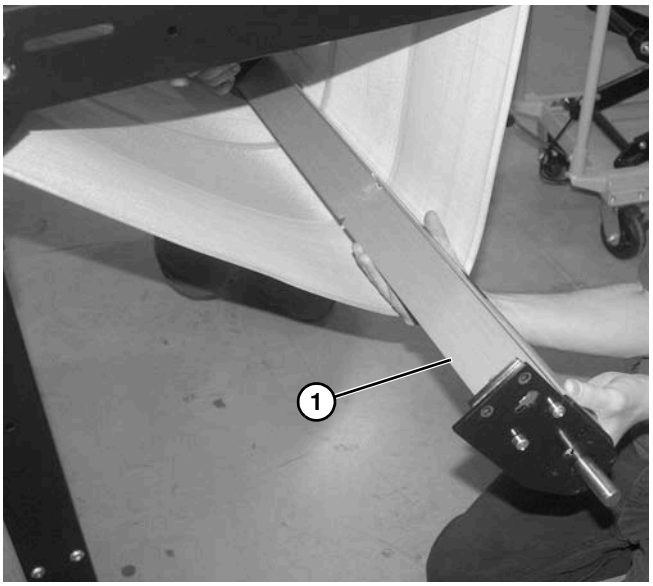


Figure 119

8. With tail assembly on an open work surface, remove the two screws **(Figure 120, item 1)** from cover plate.

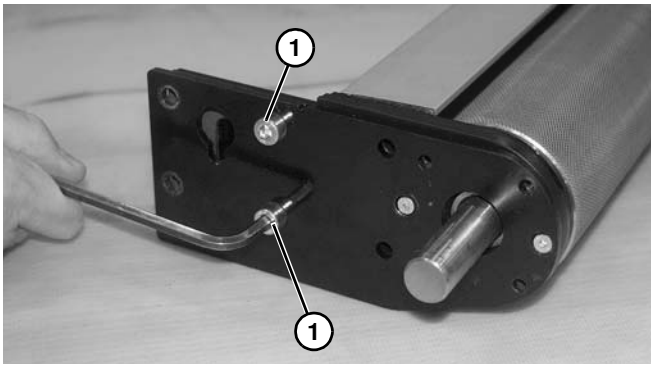


Figure 120

9. Remove the two screws **(Figure 121, item 1)** on the drive shaft side.

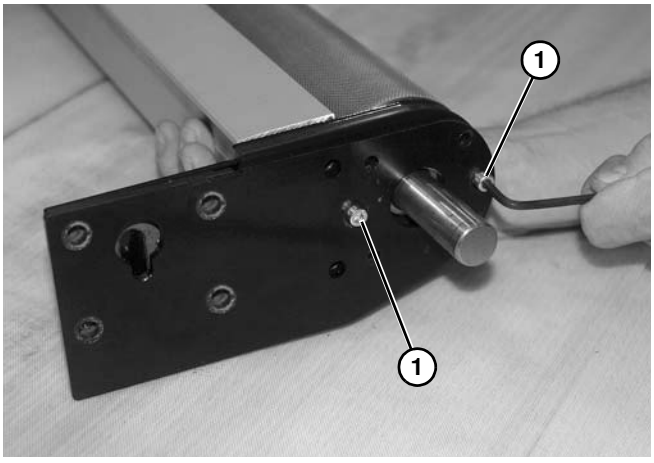


Figure 121

10. Remove cover plate **(Figure 122, item 1)**.

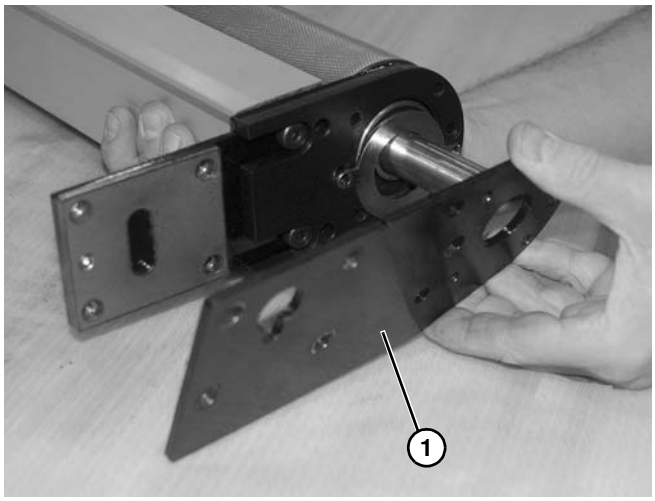


Figure 122

11. Remove bearing stop plate **(Figure 123, item 1)**.

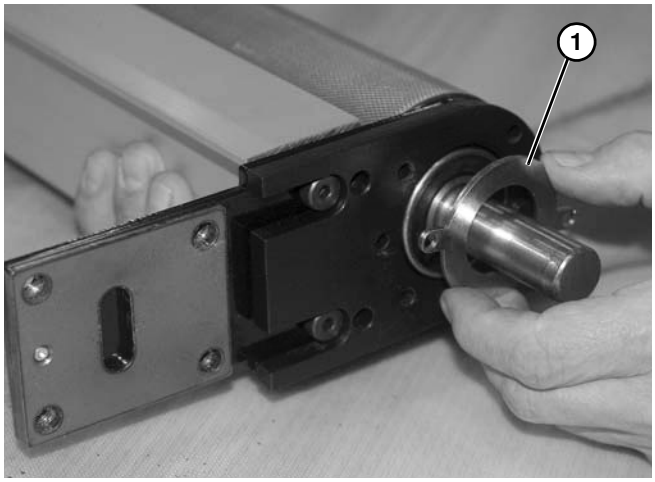


Figure 123

12. Remove bearing housing **(Figure 124, item 1)**.

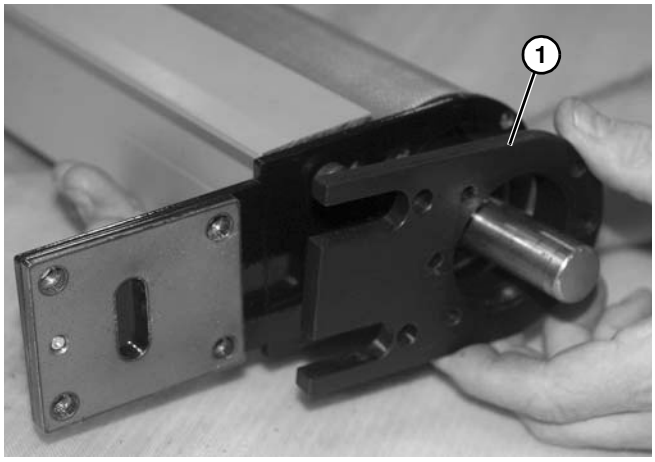


Figure 124

13. Remove shoulder screws **(Figure 125, item 1)** securing backing plate **(Figure 125, item 2)**.

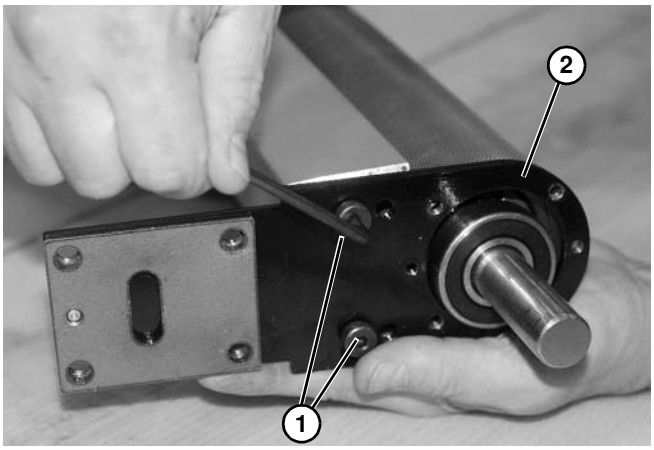


Figure 125

14. Remove backing plate **(Figure 126, item 1)** from articulation bar **(Figure 126, item 2)**.

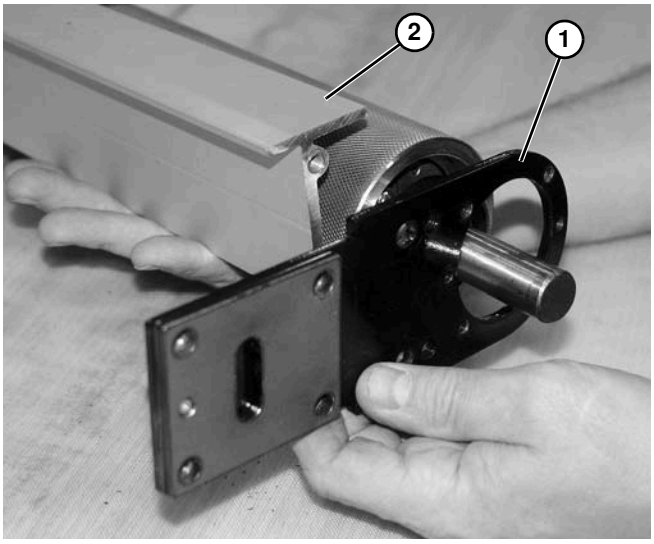


Figure 126

15. On opposite end, remove drive spindle assembly with spindle bearing **(Figure 127, item 1)** from recessed pocket **(Figure 127, item 2)** on bearing housing **(Figure 127, item 3)**.

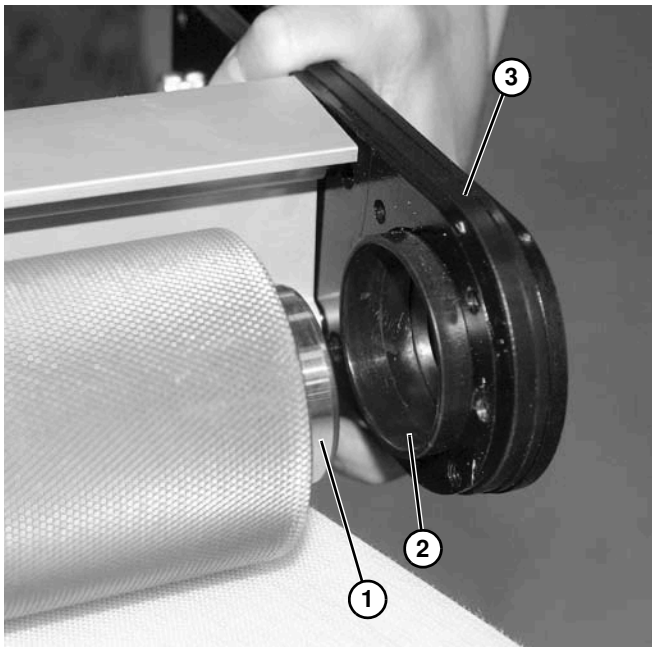


Figure 127

16. Replace components, as needed.
17. Install in reverse order of removal.

C – Nose Bar Tail Pulley Removal

1. Temporarily support the nose bar tail assembly.
2. Remove two screws **(Figure 128, item 1)** from nose bar tail **(Figure 128, item 2)** on both sides of conveyor.

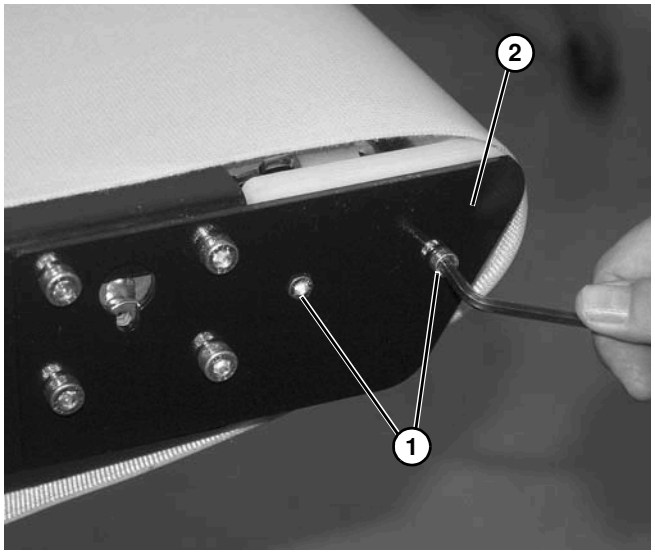


Figure 128

3. Remove four screws **(Figure 129, item 1)** and nose bar tail cover plate **(Figure 129, item 2)**. Repeat on the opposite side of conveyor.

NOTE

*The tracking cam **(Figure 129, item 3)** may fall out when cover plate is removed. Retain tracking cam for the next step.*

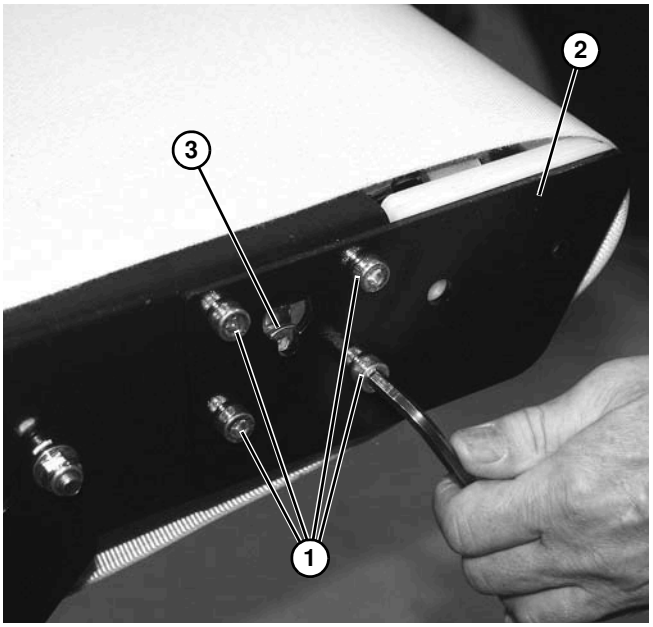


Figure 129

4. Rotate tracking cam **(Figure 130, item 1)** on both sides of conveyor to loosen belt tension and move nose bar tail **(Figure 130, item 2)** inward.

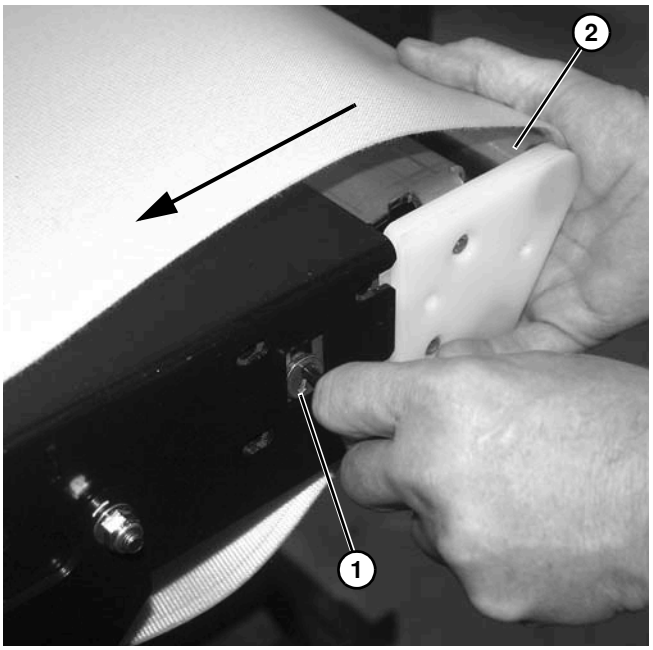


Figure 130

5. On opposite end of conveyor, loosen four screws **(Figure 131, item 1)**, and rotate tracking cam screw **(Figure 131, item 2)** to move nose bar tail **(Figure 131, item 3)** inward.

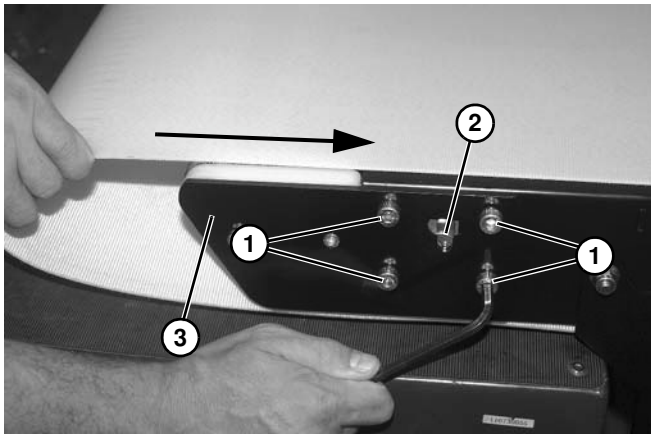


Figure 131

6. Remove four screws **(Figure 131, item 1)** and tracking cam **(Figure 131, item 2)**, and remove nose bar tail **(Figure 132, item 1)** from conveyor.

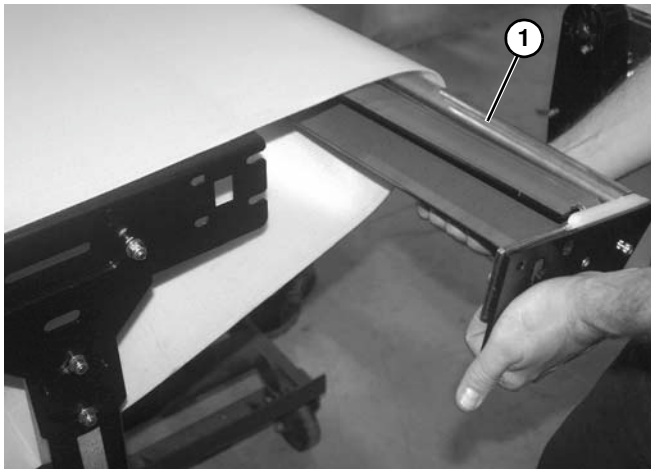


Figure 132

7. Remove screw **(Figure 133, item 1)** and screw **(Figure 133, item 2)** that holds spacer plate **(Figure 133, item 3)** in place.

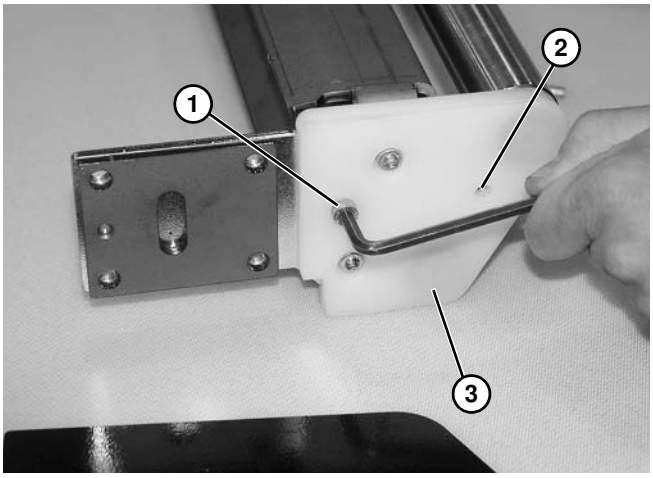


Figure 133

8. Remove spacer plate **(Figure 134, item 1)** from backing plate **(Figure 134, item 2)** and two roller bearings **(Figure 134, item 3)**.

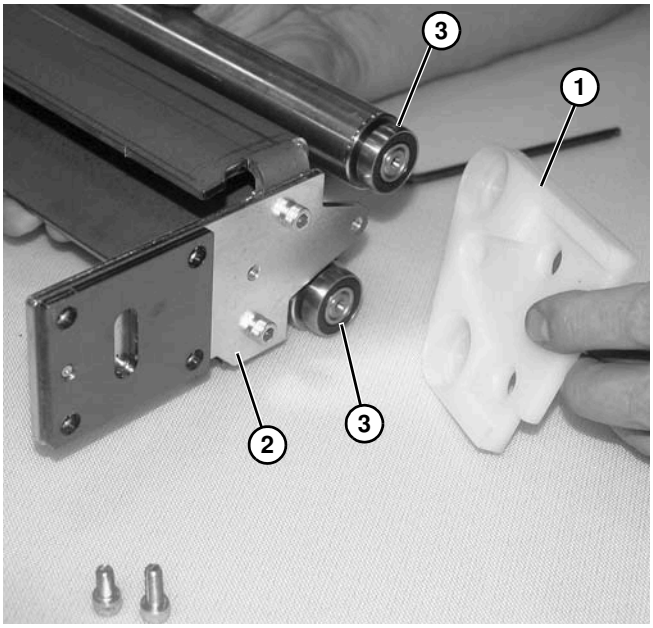


Figure 134

9. Remove upper and lower spindles **(Figure 135, item 1)** from nose bar puck **(Figure 135, item 2)**.

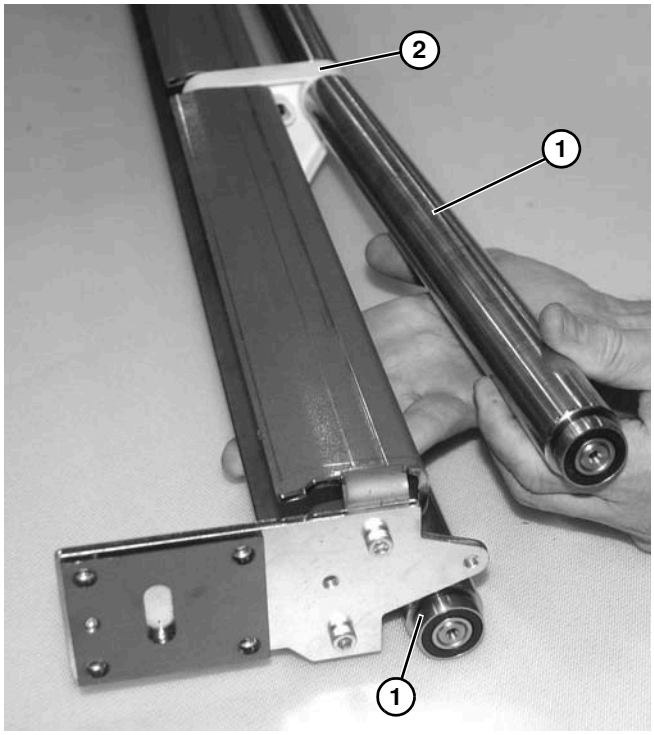


Figure 135

10. Continue removing nose bar pucks **(Figure 136, item 1)** and spindles **(Figure 136, item 2)** from crossmember bracket **(Figure 136, item 3)**.

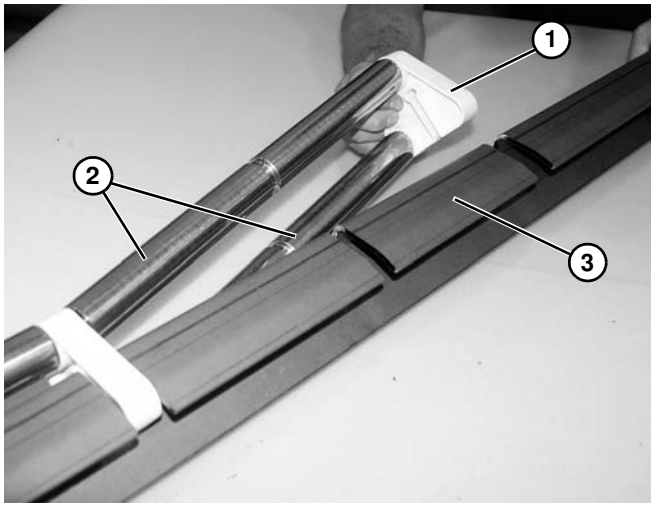


Figure 136

11. Replace components, as needed.

NOTE

*During reassembly, make certain that spindles with center mark **(Figure 137, item 1)** are aligned with cutout **(Figure 137, item 2)** in crossmember bracket.*

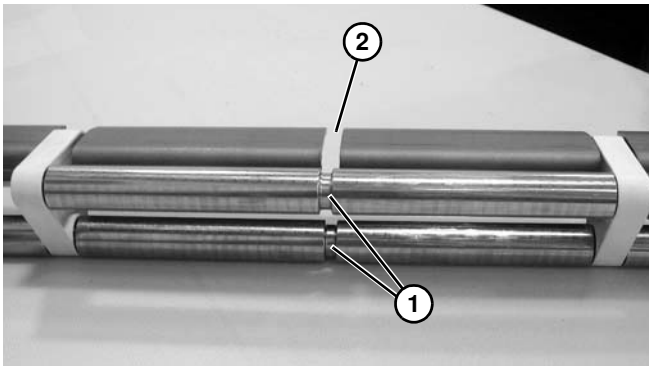


Figure 137

12. Install in reverse order of removal.

D –iDrive Tension End Pulley Removal

1. On tension end of conveyor, loosen two screws **(Figure 138, item 1)** on each side of conveyor.

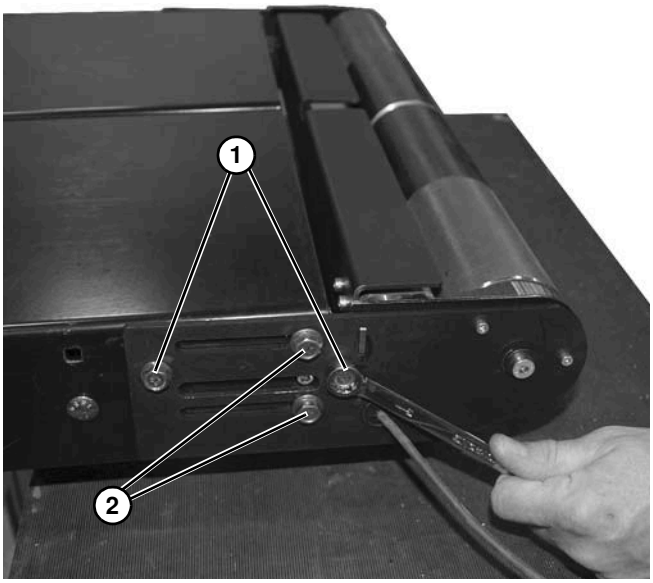


Figure 138

2. Remove two screws **(Figure 138, item 2)** and tensioner clamp plate **(Figure 139, item 1)** from tension end on each side of conveyor.

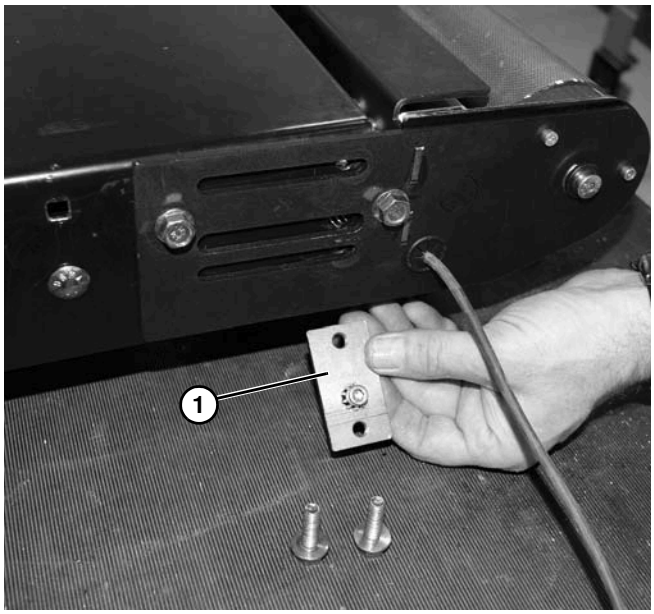


Figure 139

3. Remove screw **(Figure 140, item 1)** on each side of conveyor.

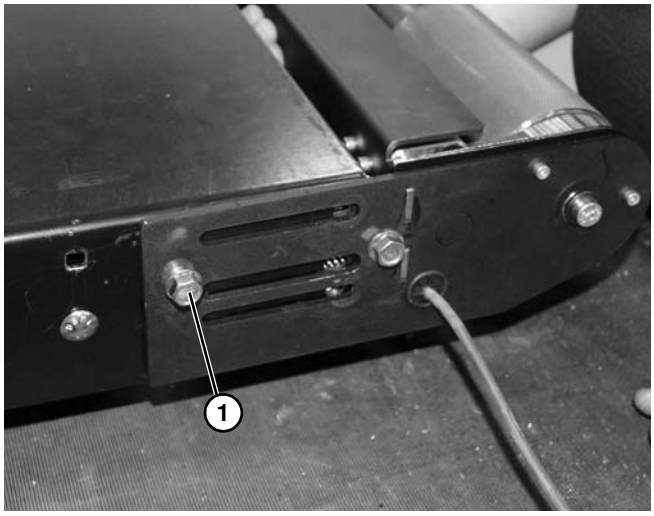


Figure 140

4. Pull each side of iDrive tension end **(Figure 141, item 1)** outward to release backing plate **(Figure 141, item 2)** from slot **(Figure 141, item 3)** on conveyor frame, and remove iDrive tension end **(Figure 142, item 1)** from conveyor.

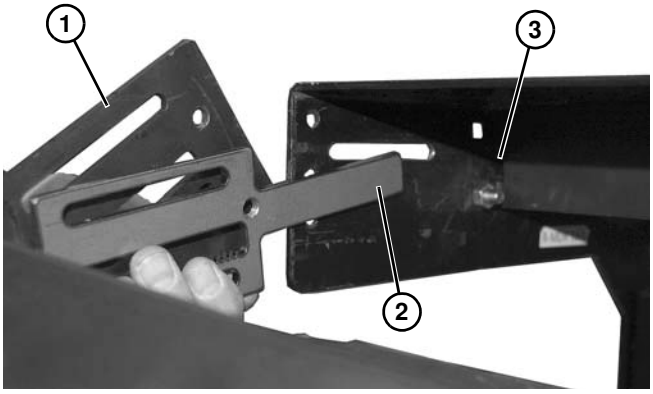


Figure 141

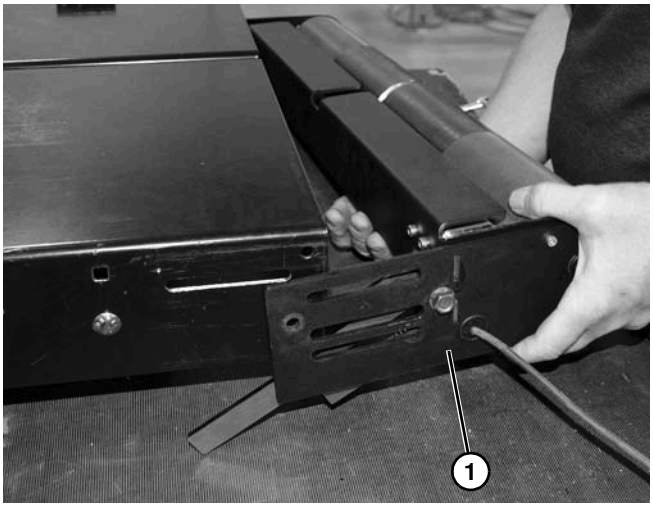


Figure 142

5. Remove two screws **(Figure 143, item 1)** and inner plate **(Figure 144, item 1)** from tension end.

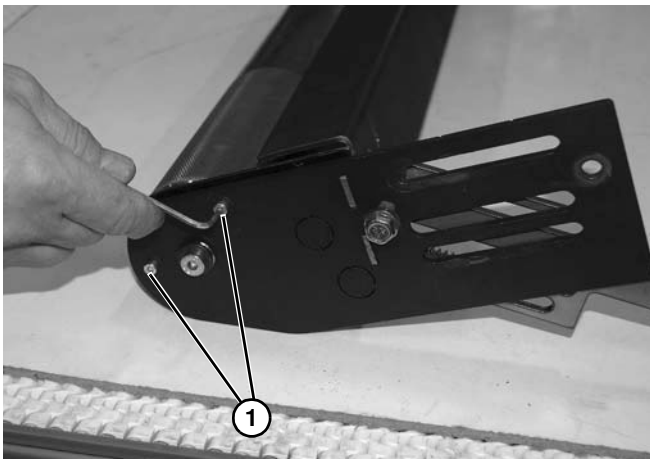


Figure 143

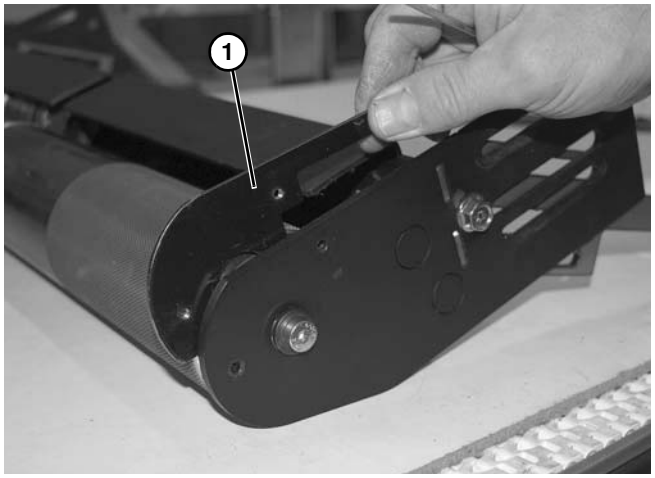


Figure 144

6. Remove screw and washer **(Figure 145, item 1)** securing cover plate **(Figure 145, item 2)** onto pulley **(Figure 145, item 3)**.

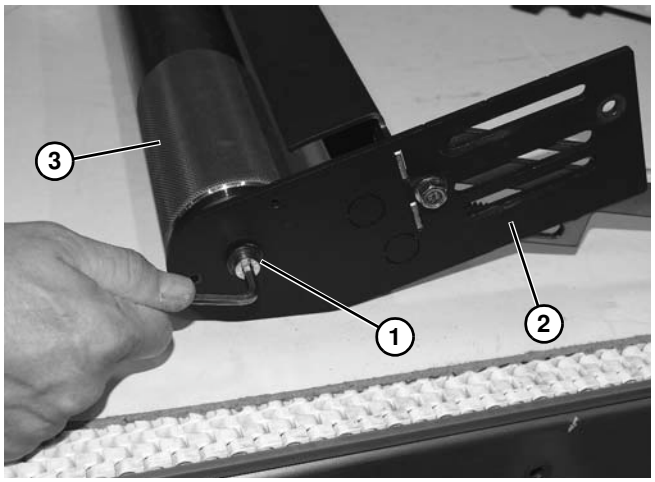


Figure 145

7. Remove cover plate **(Figure 146, item 1)** from pulley shaft **(Figure 146, item 2)**.

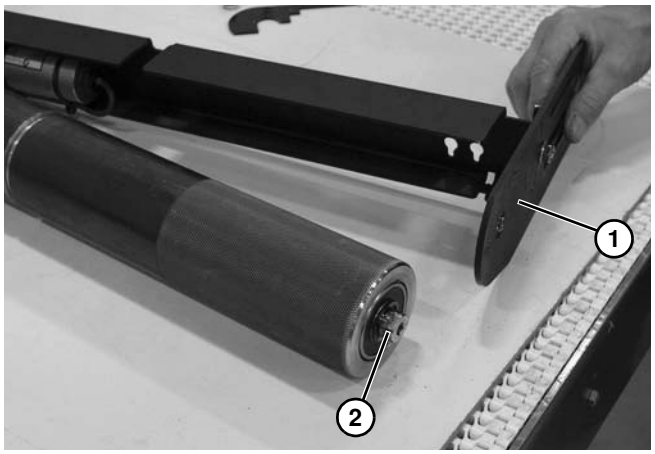


Figure 146

8. On opposite end, remove cover plate **(Figure 147, item 1)** from pulley shaft **(Figure 147, item 2)** and tabs **(Figure 147, item 3)** on crossmember.

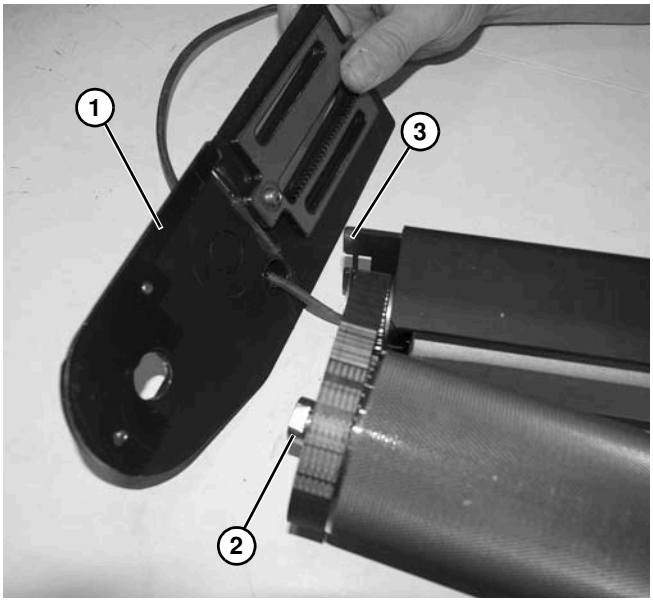


Figure 147

9. Remove pulley **(Figure 148, item 1)** from belt **(Figure 148, item 2)**.

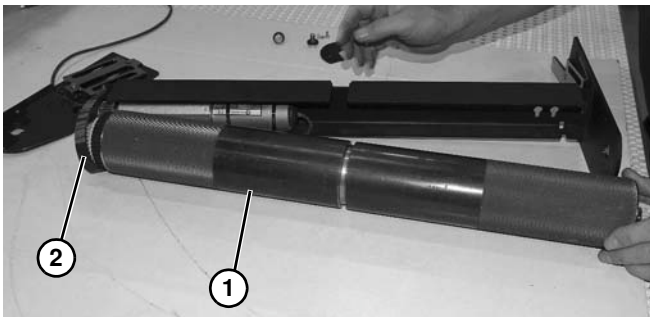


Figure 148

10. Replace components, as needed.
11. Install in reverse order of removal.

Center Drive Pulley Removal

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

⚠ WARNING

Exposed moving parts can cause severe injury.

REMOVE BELT TENSION before removing guards or performing maintenance.

- A – Tensioner Pulley Removal
- B – Idler Pulley Removal
- C – Drive Pulley Removal

A – Tensioner Pulley Removal

1. Remove two screws **(Figure 149, item 1)** and channel guard **(Figure 149, item 2)** from each side of center drive.

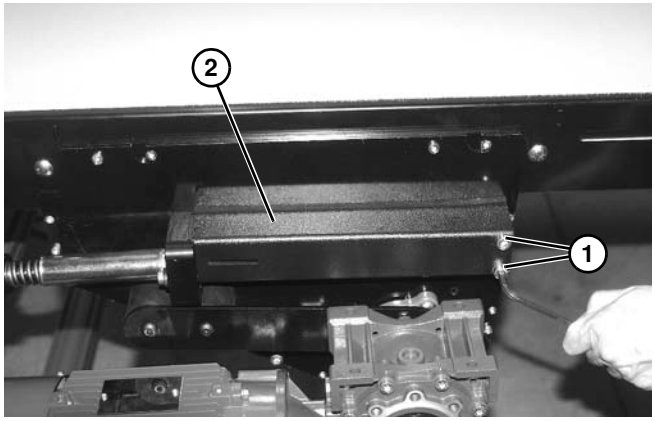


Figure 149

2. Loosen tension on drive belt by rotating tensioning knob **(Figure 150, item 1)** counterclockwise on both sides of conveyor.

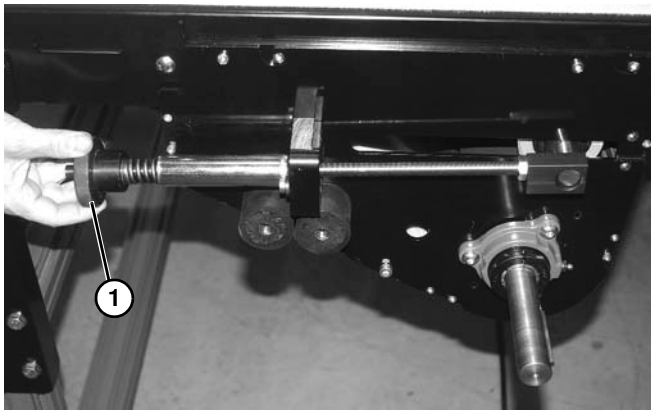


Figure 150

3. Temporarily support idler guard assembly **(Figure 151, item 1)**. Remove screws **(Figure 151, item 2)**.

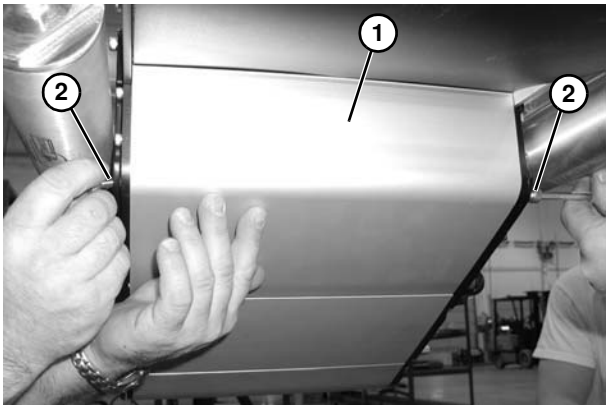


Figure 151

4. Swing down idler guard assembly **(Figure 152, item 1)**. Remove screw **(Figure 152, item 2)** from both sides of center drive and remove idler guard assembly **(Figure 152, item 1)**.

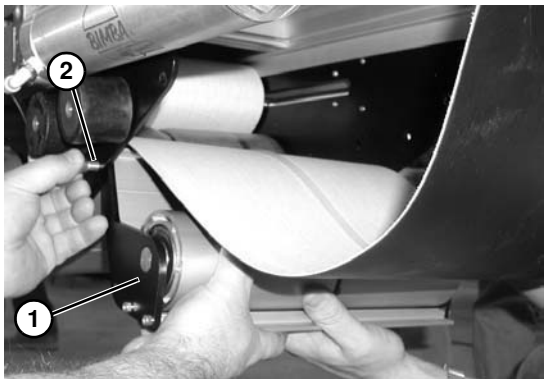


Figure 152

5. Temporarily support the tensioning roller guard **(Figure 153, item 1)**. Remove screw **(Figure 153, item 2)** on each side of center drive and remove tensioning roller guard **(Figure 153, item 1)** and **(Figure 154, item 2)**.

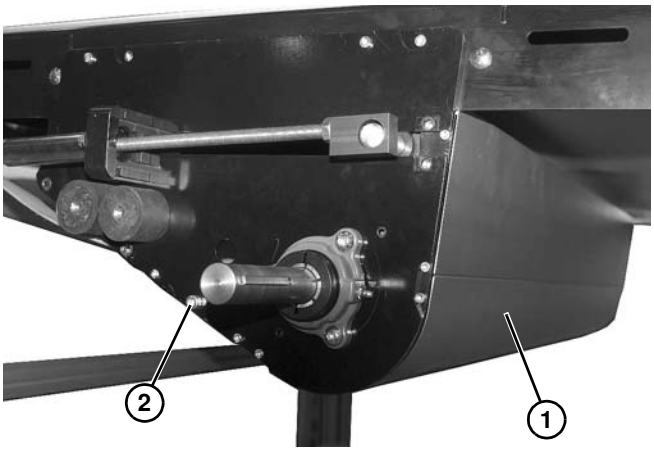


Figure 153

6. Loosen tensioning roller set screws **(Figure 154, item 1)**.

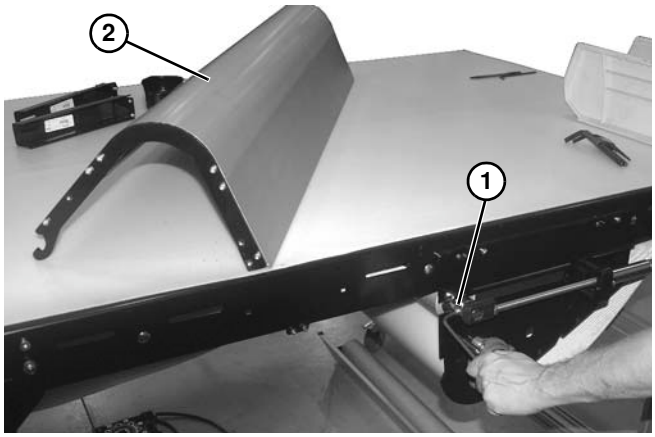


Figure 154

7. Push shaft **(Figure 155, item 1)** through block **(Figure 155, item 2)**, and slide block towards tensioner block **(Figure 155, item 3)**.

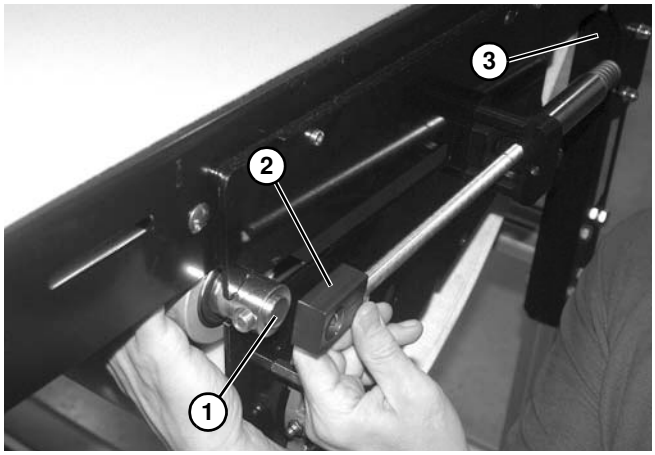


Figure 155

8. Push shaft **(Figure 156, item 1)** through block **(Figure 156, item 2)** on opposite side of center drive, and slide block toward air cylinder **(Figure 156, item 3)**.

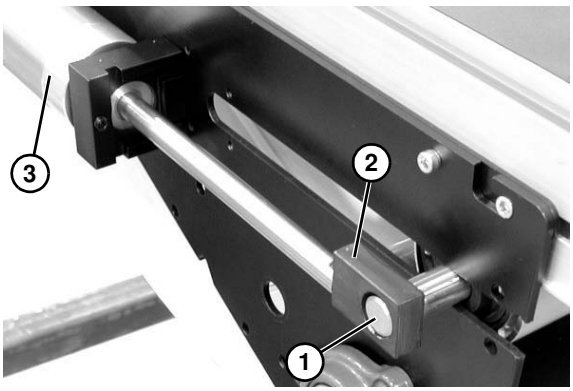


Figure 156

IMPORTANT

Use caution when removing components. Tensioning pulley can be very heavy. Use an assistant to help remove tensioning pulley, as needed.

9. Slide out tensioning pulley **(Figure 157, item 1)** along with locking collar **(Figure 157, item 2)**.

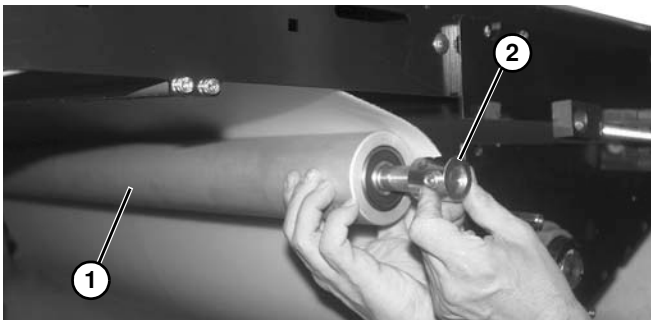


Figure 157

10. Remove the tension pulley locking collar **(Figure 158, item 1)**, spacer **(Figure 158, item 2)** and pulley shaft **(Figure 158, item 3)** from the roller pulley shaft assembly.

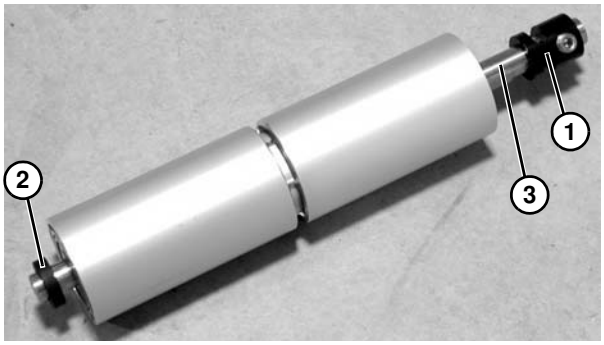


Figure 158

B – Idler Pulley Removal

1. Loosen tension on drive belt by rotating tensioning knob **(Figure 159, item 1)** counterclockwise on both sides of conveyor.

Figure 159

2. Temporarily support idler guard assembly **(Figure 160, item 1)**. Remove screws **(Figure 160, item 2)**.

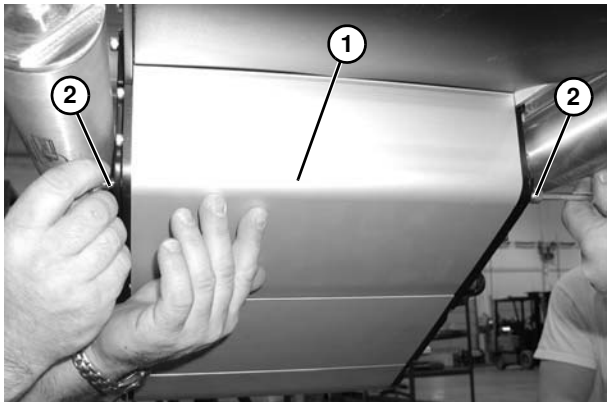


Figure 160

3. Swing down idler guard assembly **(Figure 161, item 1)**. Remove screw **(Figure 161, item 2)** from both sides of center drive and remove idler guard assembly **(Figure 161, item 1)**.

Figure 161

4. Remove screws **(Figure 162, item 1)** and idler guide side plate **(Figure 162, item 2)**.

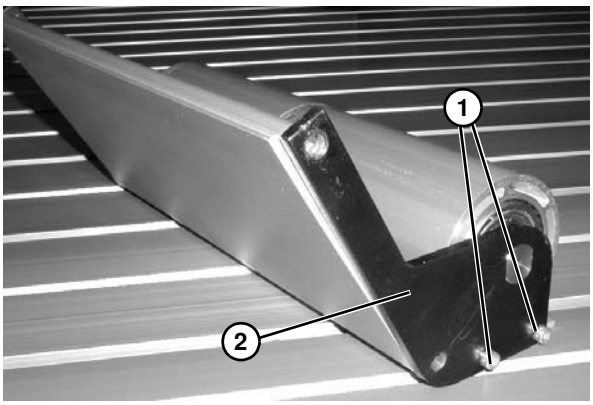


Figure 162

5. Slide the idler pulley assembly **(Figure 163, item 1)** out of the idler guide side plate on the opposite side.

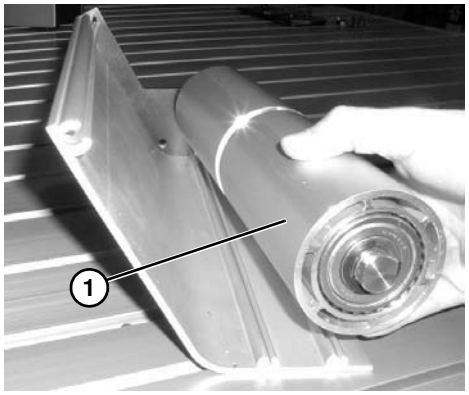


Figure 163

6. Remove the pulley shaft assembly: remove the clip ring **(Figure 164, item 1)** and washer **(Figure 164, item 2)** from one side of the pulley assembly.

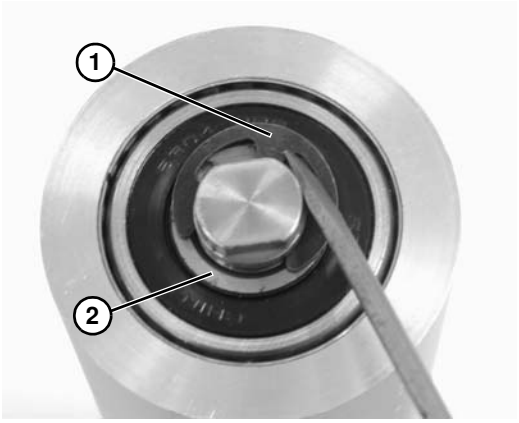


Figure 164

7. Slide the shaft assembly **(Figure 165, item 1)** out of the pulley **(Figure 165, item 2)**.

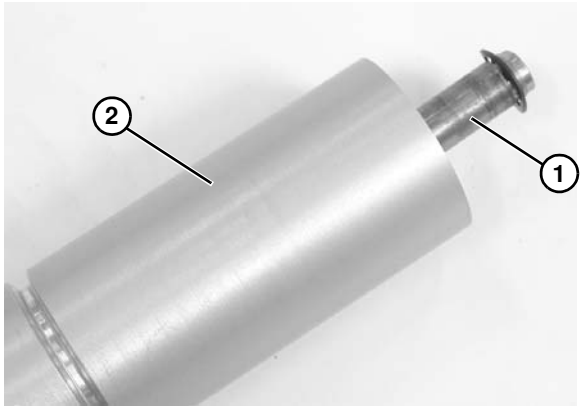


Figure 165

C – Drive Pulley Removal

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

1. Remove two screws **(Figure 166, item 1)** and channel guard **(Figure 166, item 2)** from each side of center drive.

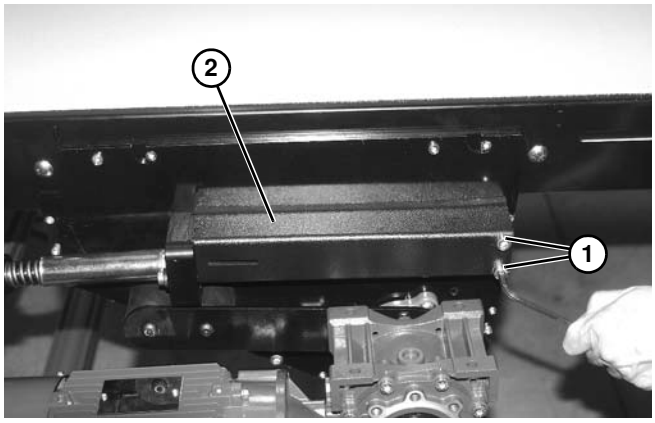


Figure 166

2. Loosen tension on drive belt by rotating tensioning knob **(Figure 167, item 1)** counterclockwise on both sides of conveyor.

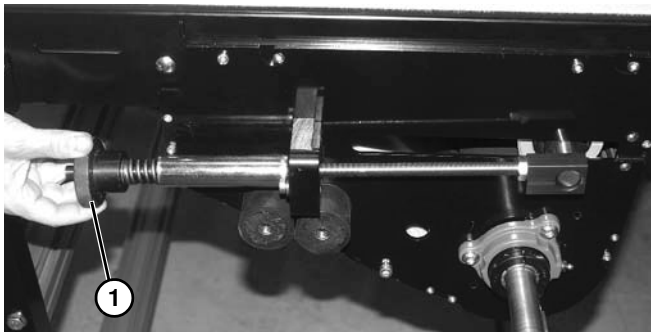


Figure 167

3. Remove screws **(Figure 168, item 1)** and remove gearmotor assembly **(Figure 168, item 2)** (gearhead shown with motor removed for clarity, motor can remain attached to gearhead).

NOTE

Gearhead shown with motor removed for clarity. Motor can remain attached to gearhead.

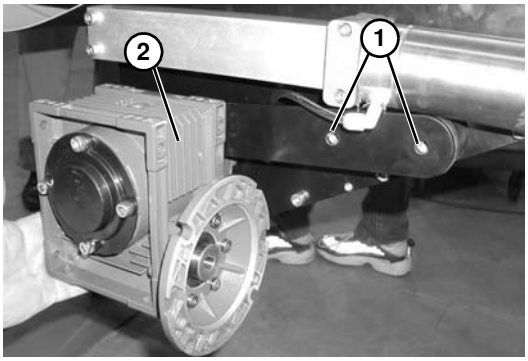


Figure 168

4. Remove spacer ring **(Figure 169, item 1)** and key **(Figure 169, item 2)**.

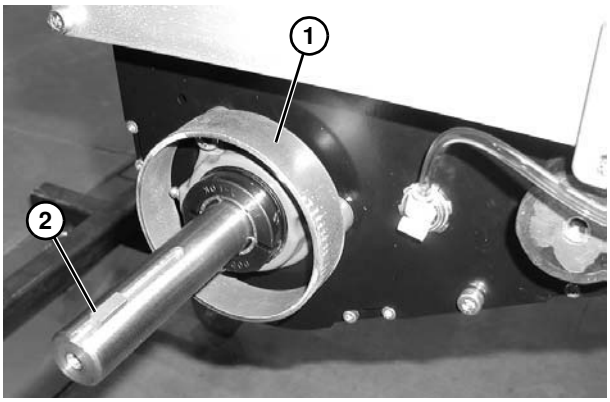


Figure 169

5. Reverse steps 6 thru 12 of the belt removal, “Center Drive Conveyors” on page 29.

6. Loosen clamp screw **(Figure 170, item 1)** and remove bearing collar **(Figure 170, item 2)**.

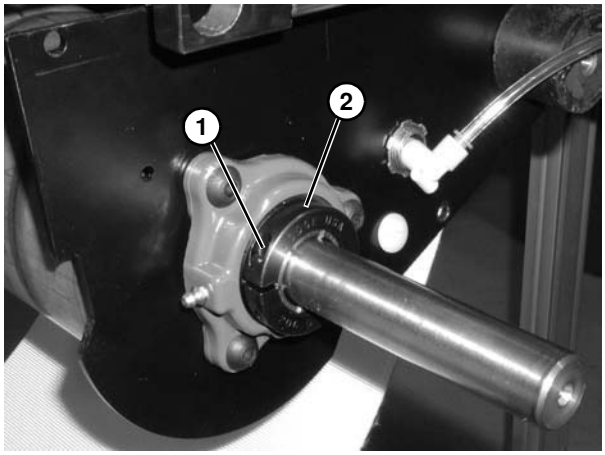


Figure 170

7. Disconnect flexible air hose **(Figure 171, item 1)** from fitting **(Figure 171, item 2)**.

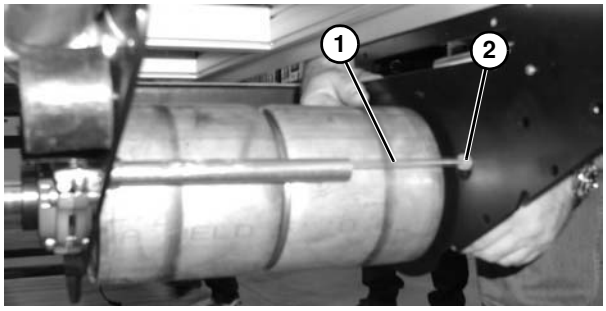


Figure 171

8. Temporarily support the drive pulley **(Figure 172, item 1)**.

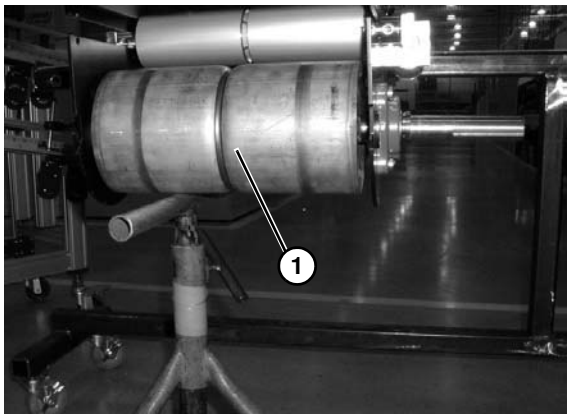


Figure 172

9. Loosen clamp screw **(Figure 173, item 1)** and remove bearing collar **(Figure 173, item 2)**.

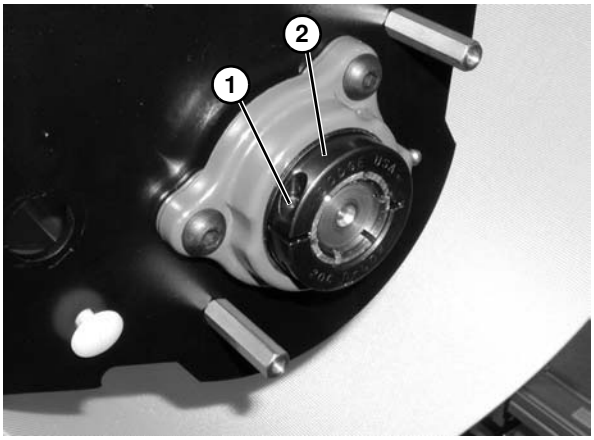


Figure 173

10. Remove screws **(Figure 174, item 1)** and pull side plate assembly **(Figure 174, item 2)** off conveyor.

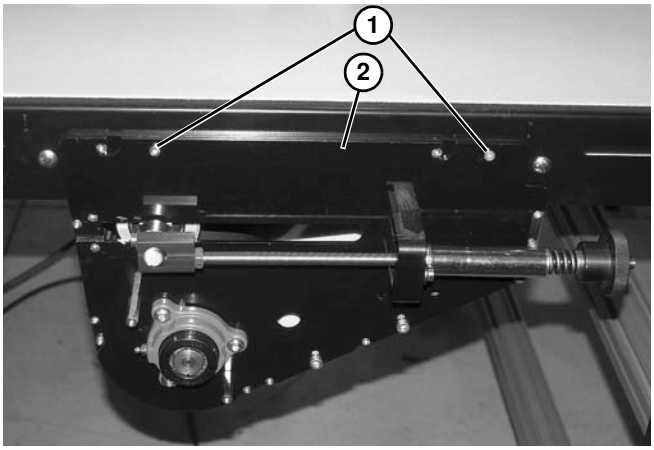


Figure 174

11. Slide drive pulley **(Figure 175, item 1)** out of attached side plate.

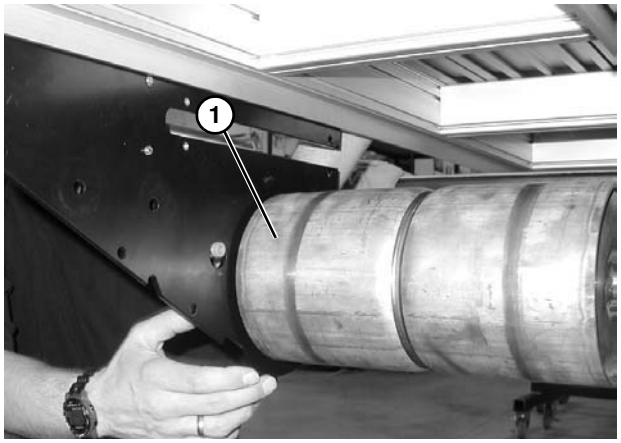


Figure 175

Center Drive Bearing Replacement

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

⚠ WARNING

Exposed moving parts can cause severe injury.

REMOVE BELT TENSION before removing guards or performing maintenance.

- A – Idler Bearing
- B – Drive Bearing
- C – Nose Bar Tail Bearing

A – Idler Bearing Replacement

The bearings in a DCMove Series Idler Pulley can not be removed. Replace the entire pulley assembly when worn.

B – Drive Bearing Removal and Replacement

⚠ WARNING

Drive shaft keyway may be sharp.

HANDLE WITH CARE.

Drive Side Bearing

1. Remove two screws **(Figure 176, item 1)** and channel guard **(Figure 176, item 2)** from each side of center drive.

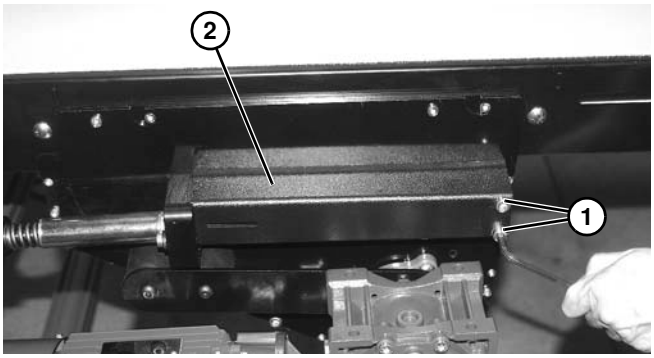


Figure 176

2. Loosen tension on drive belt by rotating tensioning knob **(Figure 177, item 1)** counterclockwise on both sides of conveyor.

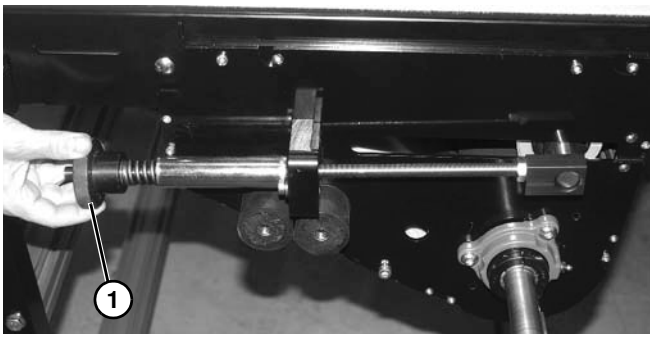


Figure 177

3. Remove screws **(Figure 178, item 1)** and remove gearmotor assembly **(Figure 178, item 2)** (gearhead shown with motor removed for clarity, motor can remain attached to gearhead).

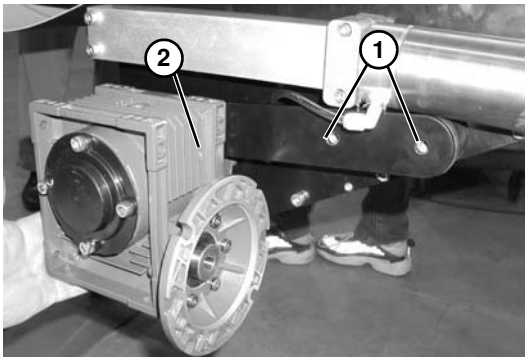


Figure 178

4. Remove spacer ring **(Figure 179, item 1)** and key **(Figure 179, item 2)**. Loosen clamp screw **(Figure 179, item 3)** and remove bearing collar **(Figure 179, item 4)**.

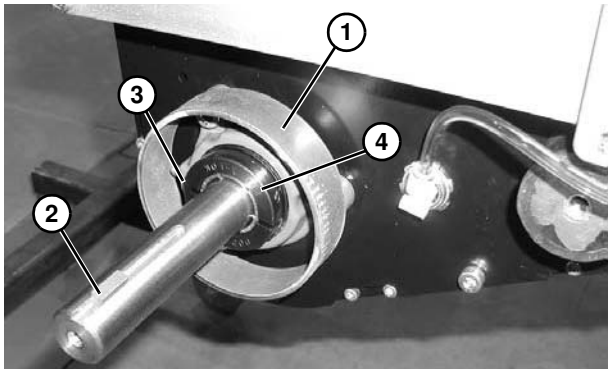


Figure 179

5. Remove the three mounting screws **(Figure 180, item 1)**.

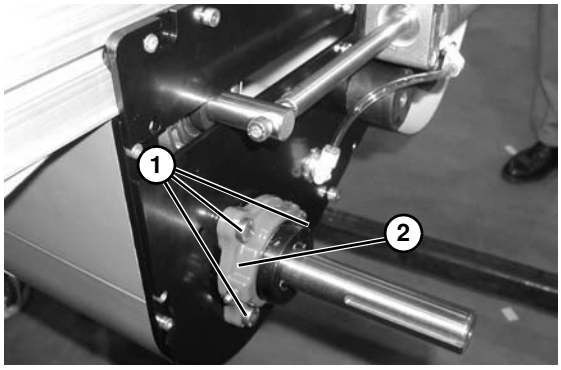


Figure 180

6. Remove and replace bearing housing assembly **(Figure 180, item 2)**.
7. Tighten three mounting screws **(Figure 181, item 1)** to 22.5 Nm (200 in lbs).

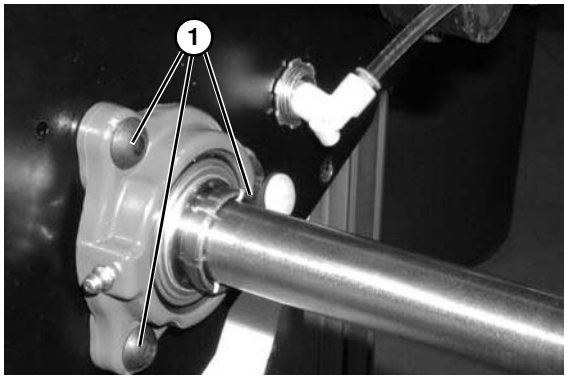


Figure 181

8. Reinstall bearing collar **(Figure 179, item 4)**. Tighten clamp screw **(Figure 179, item 3)** to 11 Nm (95 in lbs).
9. Reinstall key **(Figure 179, item 2)**.

10. Reinstall spacer ring **(Figure 182, item 1)** and gearmotor assembly **(Figure 182, item 2)**. Tighten screws **(Figure 178, item 1)** to 17 Nm (150 in lbs).

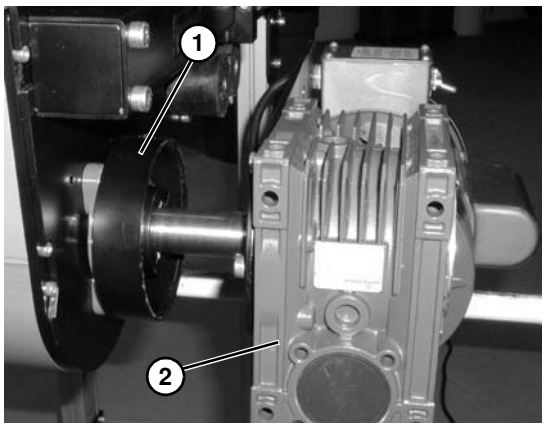


Figure 182

11. Reinstall channel guard **(Figure 176, item 2)**. Tighten screws **(Figure 176, item 1)** to 8 Nm (69 in lbs).

Idler Side Bearing

1. Remove two screws **(Figure 183, item 1)** and channel guard **(Figure 183, item 2)** from each side of center drive.

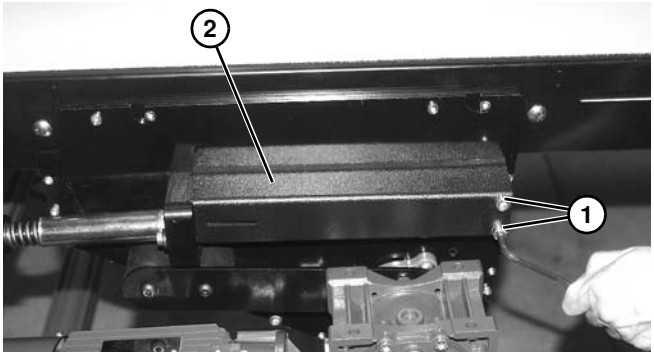


Figure 183

2. Loosen tension on drive belt by rotating tensioning knob **(Figure 184, item 1)** counterclockwise on both sides of conveyor.

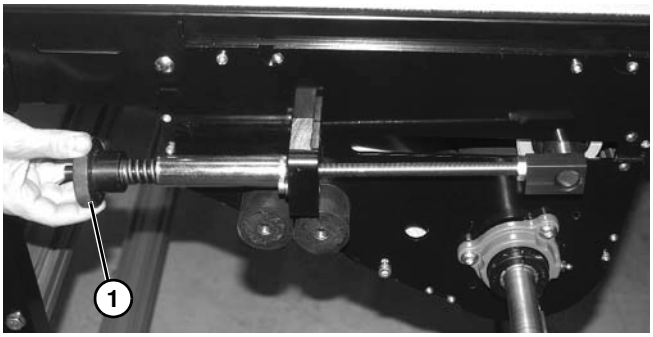


Figure 184

3. Loosen clamp screw **(Figure 185, item 1)** and remove bearing collar **(Figure 185, item 2)**.

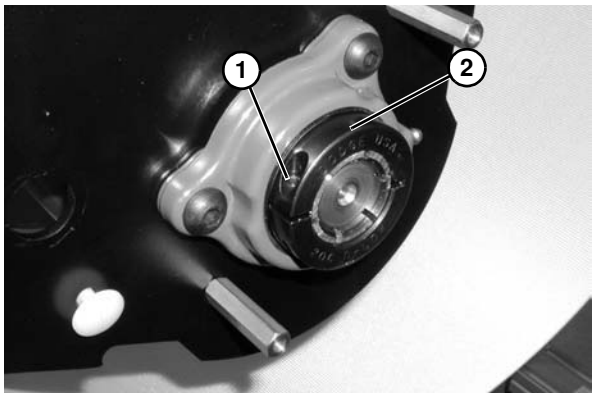


Figure 185

4. Remove the three (3) mounting screws **(Figure 186, item 1)**.

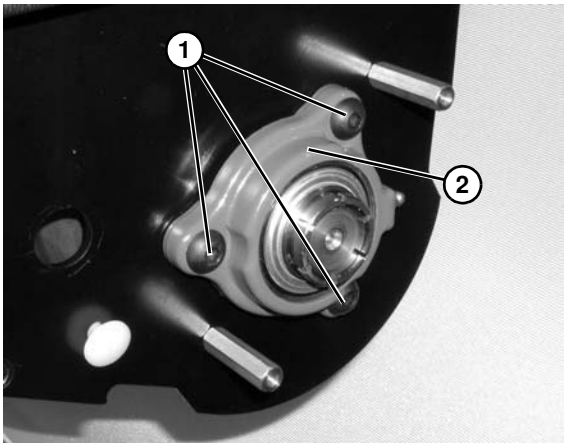


Figure 186

5. Remove and replace housing assembly **(Figure 186, item 2)**.

NOTE

*During reassembly, make certain that spindle housing assembly is oriented with zerk fitting **(Figure 187, item 1)** in location as shown.*

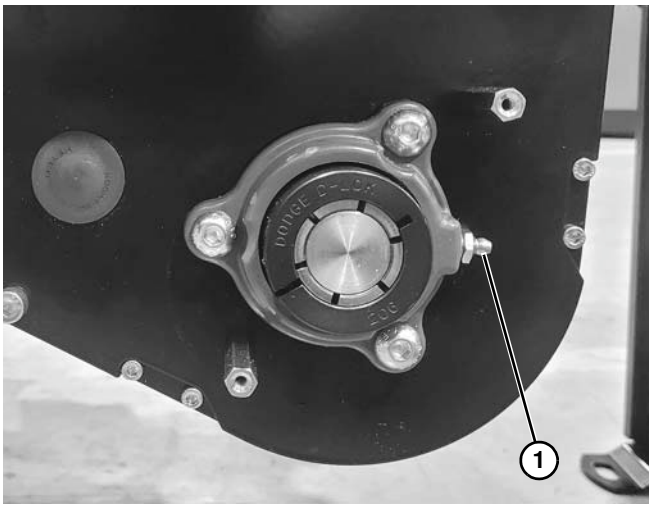


Figure 187

6. Tighten three (3) mounting screws **(Figure 186, item 1)** to 22.5 Nm (200 in lbs).
7. Reinstall bearing collar **(Figure 185, item 2)**. Tighten clamp screw **(Figure 185, item 1)** to 11 Nm (95 in lbs).
8. Reinstall channel guard **(Figure 183, item 2)**. Tighten screws **(Figure 183, item 1)** to 8 Nm (69 in lbs).

C – Nose Bar Tail Bearing Replacement

The bearings in a DCMove Series Nose Bar Tail Pulley can not be removed. Replace the entire pulley assembly when worn.

Pulley Replacement

Tension Tail Pulley

To replace the tension tail pulley, reverse the “Tension Tail Pulley Removal” procedure on page 36.

Drive Tail Pulley

To replace the drive tail pulley, reverse the “Drive Tail Pulley Removal” procedure on page 39.

Nose Bar Tail Pulley

To replace the nose bar tail pulley, reverse the “Nose Bar Tail Pulley Removal” procedure on page 41.

iDrive Spindle Removal and Replacement

⚠ WARNING

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

Removal

1. Remove belt. (See “Belt Removal” on page 27.)
2. On tension end of the conveyor, identified by the pinion access slot **(Figure 188, item 1)**, loosen the four tail clamp screws **(Figure 188, item 2)** on both sides of the conveyor head plate assembly **(Figure 188, item 3)**.

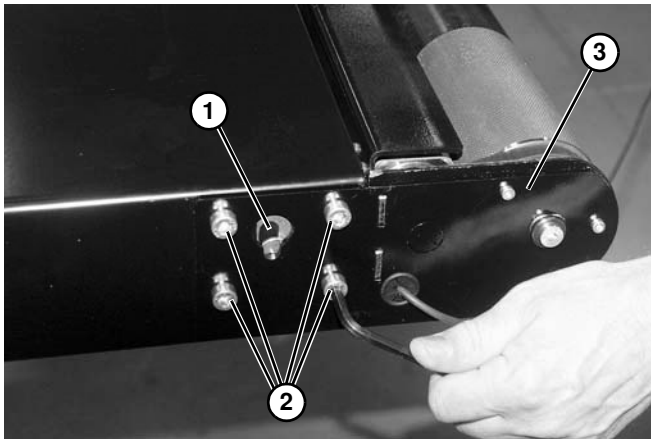


Figure 188

3. Remove tracking cam **(Figure 189, item 1)** by rotating so that the arrow **(Figure 189, item 2)** is facing directly up, and remove from conveyor.

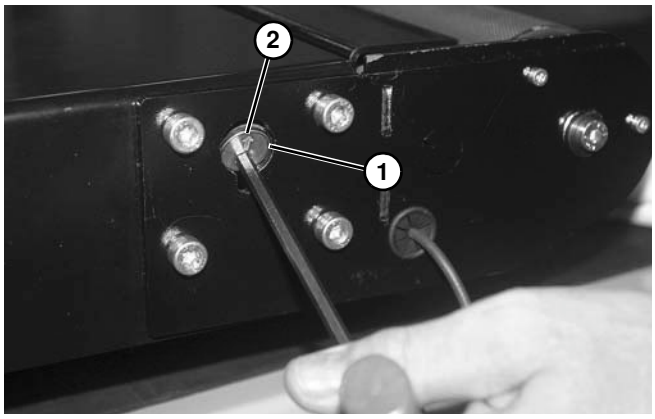


Figure 189

4. Loosen two screws **(Figure 190, item 1)** on each side and end of conveyor

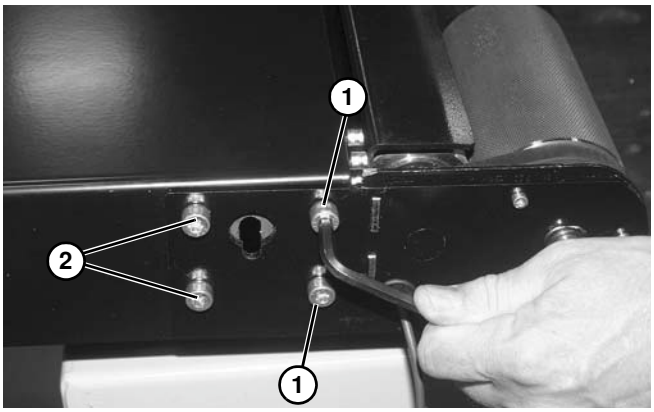


Figure 190

5. Remove two screws **(Figure 190, item 2)**.
6. Continue to loosen two screws **(Figure 191, item 1)** and remove backing plate **(Figure 191, item 2)** on each side of conveyor.

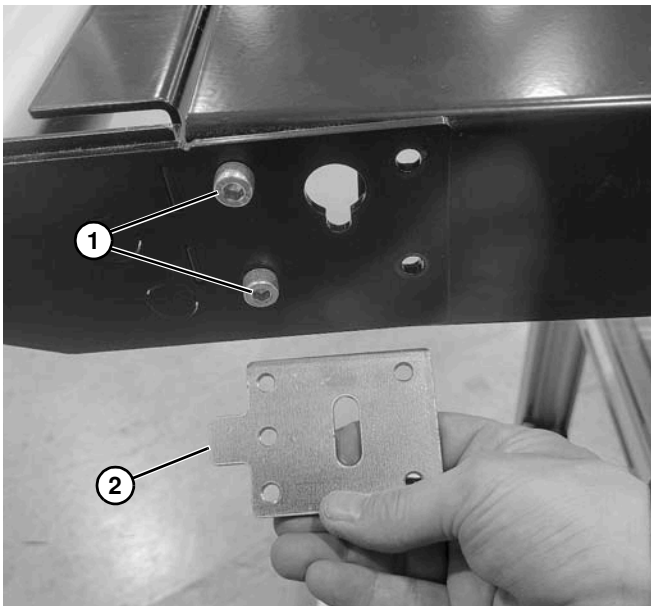


Figure 191

7. Remove two screws **(Figure 191, item 1)** on each side of conveyor and remove drive spindle assembly. Place onto work surface.

8. Remove cover plate **(Figure 192, item 1)** from crossmember **(Figure 192, item 2)** and spindle **(Figure 192, item 3)**.

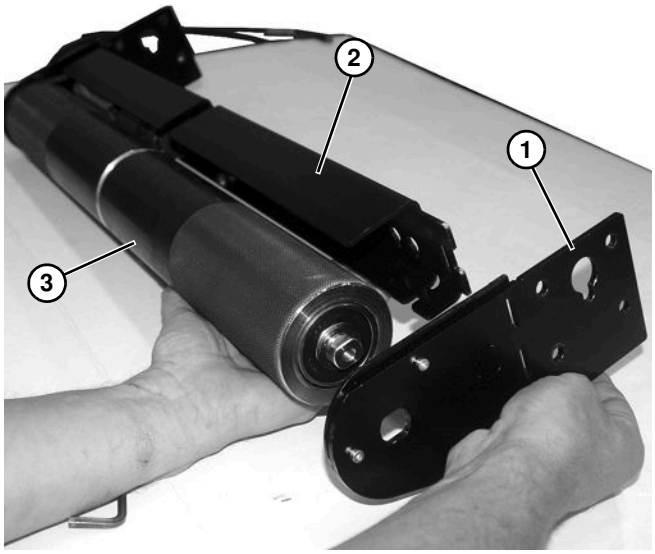


Figure 192

9. On motor mounted end, remove screw **(Figure 193, item 1)** securing cover plate **(Figure 193, item 2)** on spindle assembly.

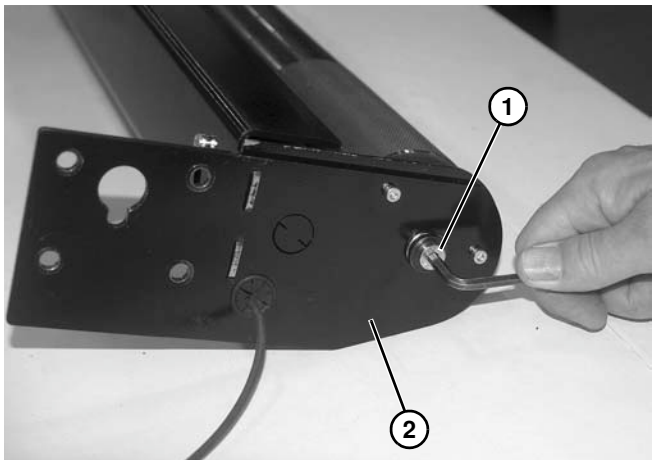


Figure 193

10. Remove cover plate **(Figure 194, item 1)** from spindle **(Figure 194, item 2)** and crossmember **(Figure 194, item 3)**.

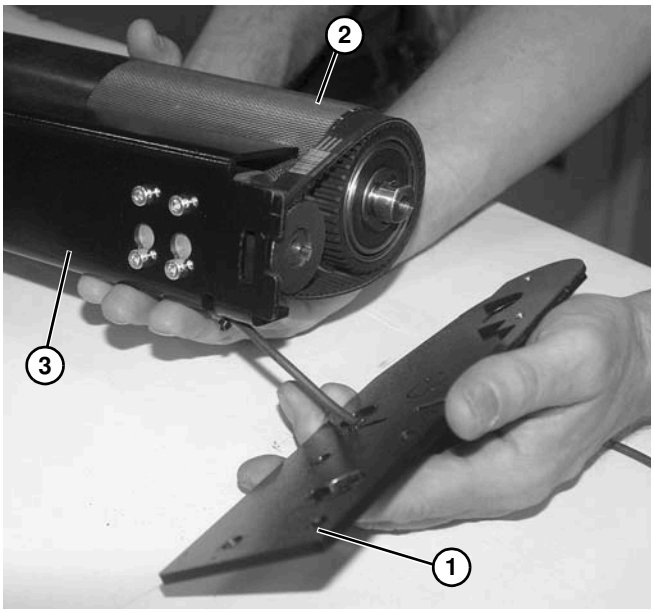


Figure 194

11. Remove timing belt **(Figure 195, item 1)** from drive spindle assembly **(Figure 195, item 2)** and motor drive gear **(Figure 195, item 3)**.

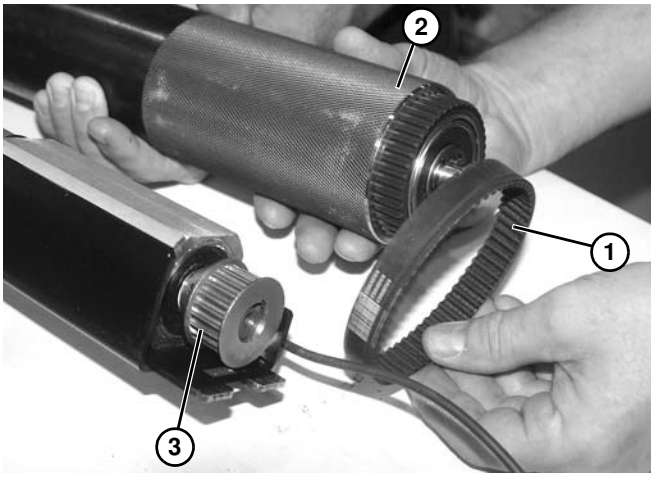


Figure 195

12. Remove drive spindle assembly **(Figure 195, item 2)** and replace.
13. Install in reverse order of removal.

iDrive Motor Removal and Replacement

⚠ WARNING

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

1. Remove belt. (See “Belt Removal” on page 27.)
2. On tension end of the conveyor, identified by the pinion access slot **(Figure 196, item 1)**, loosen the four tail clamp screws **(Figure 196, item 2)** on both sides of the conveyor head plate assembly **(Figure 196, item 3)**.

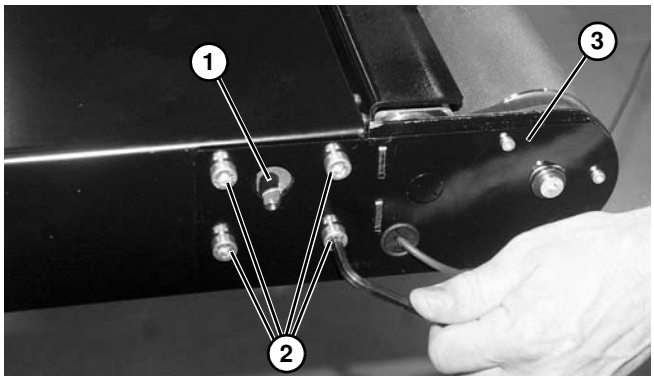


Figure 196

3. Remove tracking cam **(Figure 197, item 1)** by rotating so that the arrow **(Figure 197, item 2)** is facing directly up, and remove from conveyor.

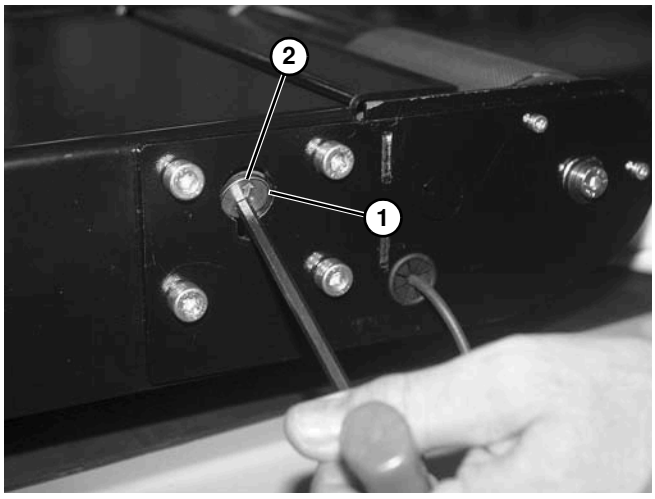


Figure 197

4. Loosen two screws **(Figure 198, item 1)** on each side and end of conveyor

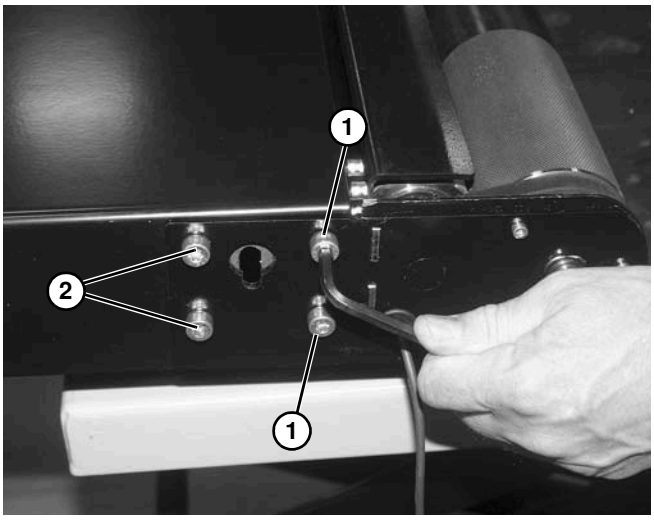


Figure 198

5. Remove two screws **(Figure 198, item 2)**.
6. Continue to loosen two screws **(Figure 199, item 1)** and remove backing plate **(Figure 199, item 2)** on each side of conveyor.

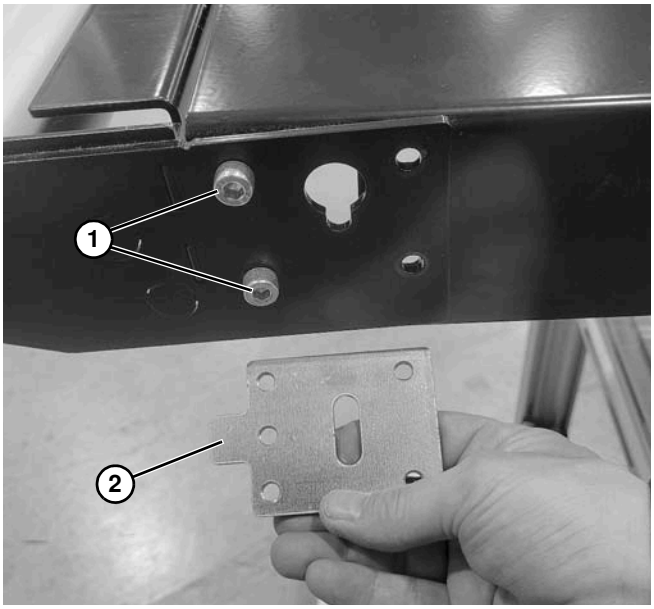


Figure 199

7. Remove two screws **(Figure 199, item 1)** on each side of conveyor and remove drive spindle assembly. Place onto work surface.
8. Remove cover plate **(Figure 200, item 1)** from crossmember **(Figure 200, item 2)** and spindle **(Figure 200, item 3)** on spindle assembly.

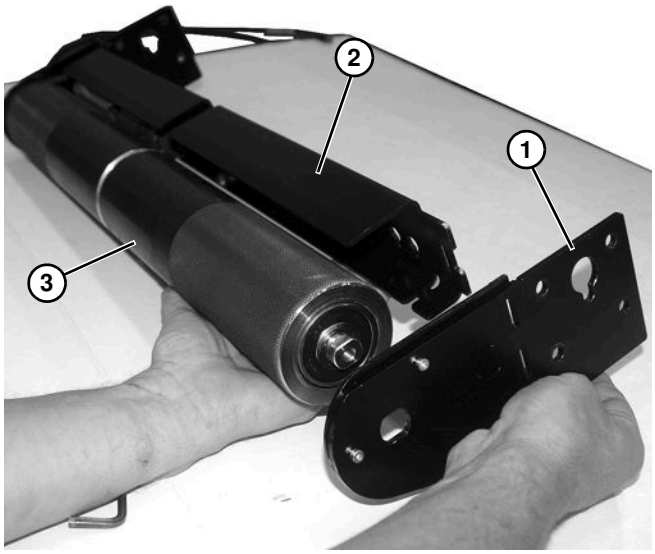


Figure 200

9. On motor mounted end, remove screw **(Figure 201, item 1)** securing cover plate **(Figure 201, item 2)** on spindle assembly.

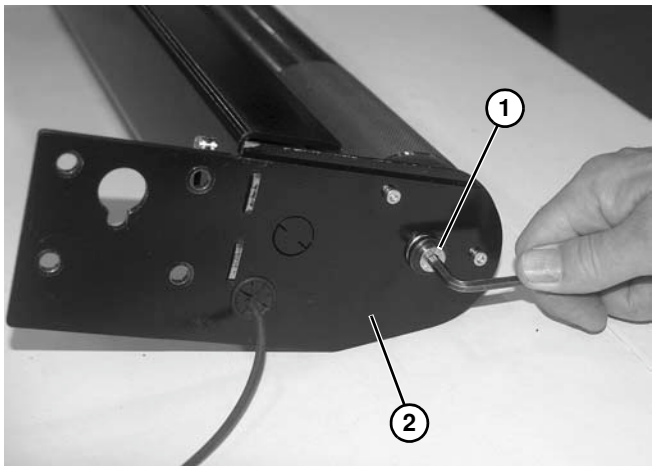


Figure 201

10. Remove cover plate **(Figure 202, item 1)** from spindle **(Figure 202, item 2)** and crossmember **(Figure 202, item 3)**.

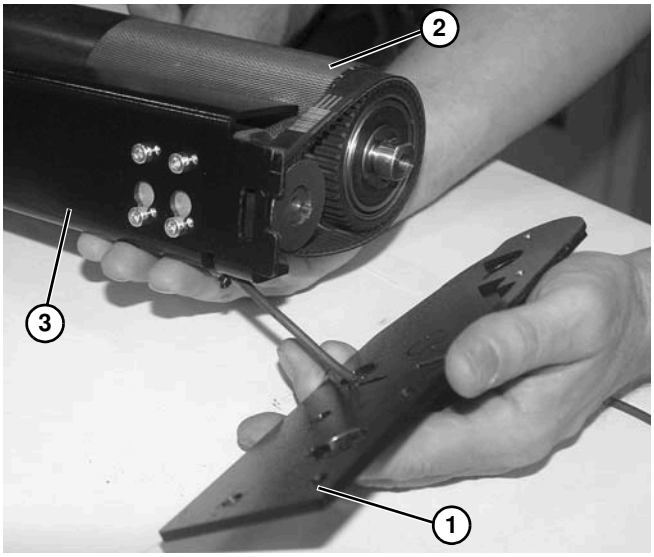


Figure 202

11. Remove timing belt **(Figure 203, item 1)** from drive spindle assembly **(Figure 203, item 2)** and motor drive gear **(Figure 203, item 3)**.

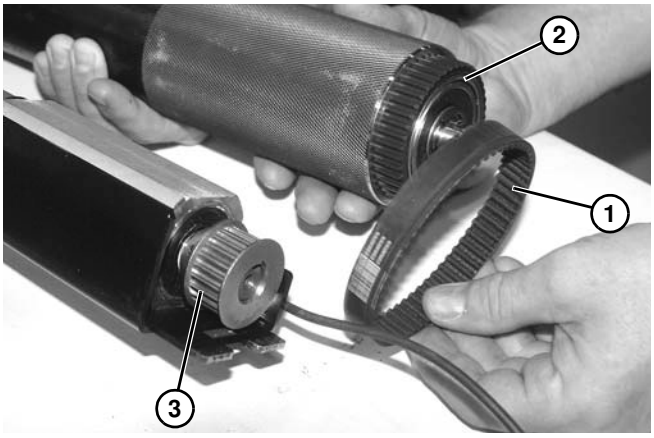


Figure 203

12. Cut tie strap **(Figure 204, item 1)** securing motor **(Figure 204, item 2)** onto crossmember **(Figure 204, item 3)**.

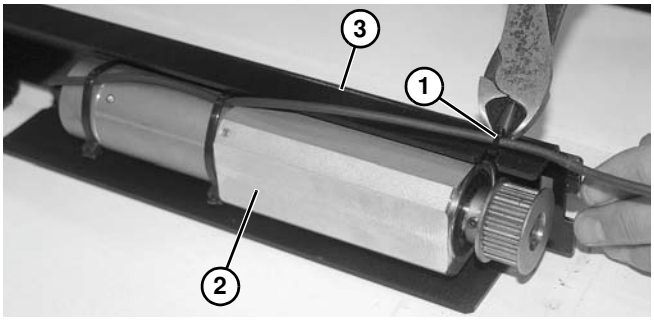


Figure 204

13. Loosen two screws **(Figure 205, item 1)**, and remove two screws **(Figure 205, item 2)** securing motor onto crossmember.

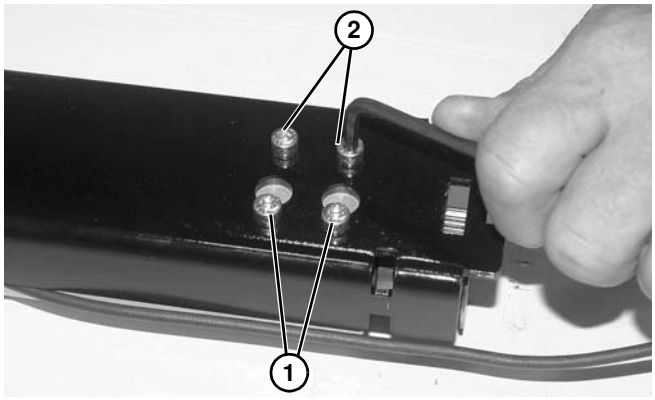


Figure 205

14. Slide motor **(Figure 206, item 1)** off of slotted holes **(Figure 206, item 2)** on crossmember.

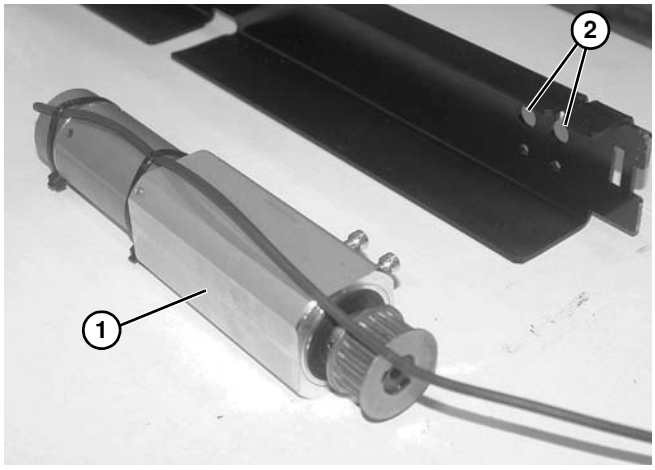


Figure 206

15. Remove end of wiring **(Figure 207, item 1)** through rubber grommet **(Figure 207, item 2)** on cover plate.

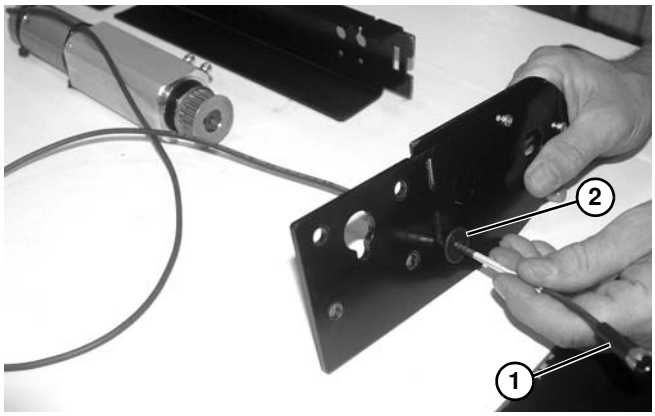


Figure 207

16. Replace drive motor assembly.
17. Install in reverse order of removal.

iDrive Controller Removal and Replacement

Single iDrive Controller

⚠ WARNING

Motor may start immediately once power is supplied. Exposed moving parts can cause severe injury. LOCK OUT POWER before wiring to avoid accidental startup.

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Install two screws **(Figure 208, item 1)** and cover **(Figure 208, item 2)**.

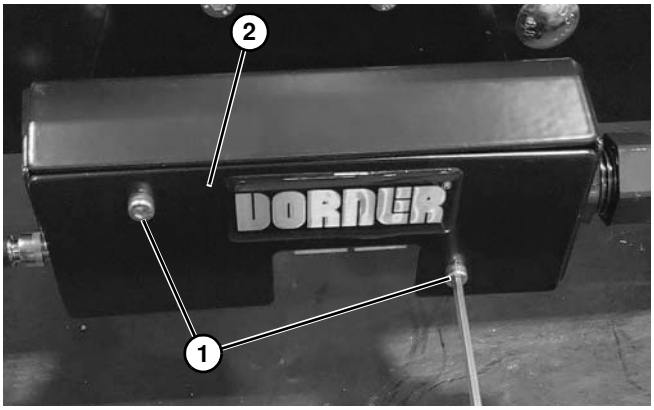


Figure 208

3. Remove two screws **(Figure 209, item 1)** and nuts **(Figure 209, item 2)** to remove controller assembly **(Figure 209, item 3)** from mounting bracket.

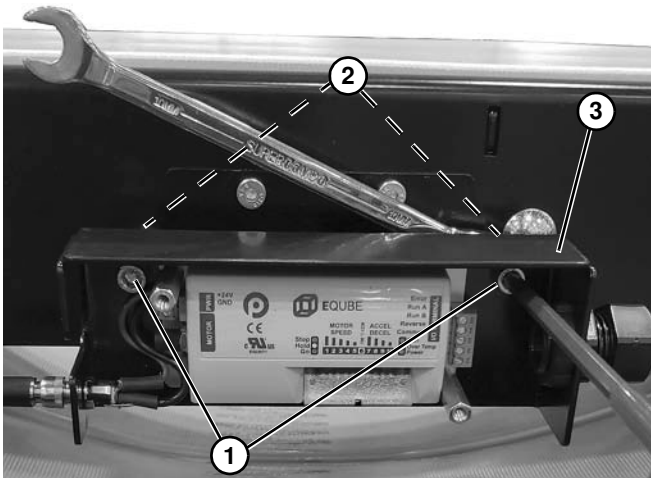


Figure 209

4. Disconnect end **(Figure 210, item 1)** of motor wiring from threaded end **(Figure 210, item 2)** on controller.

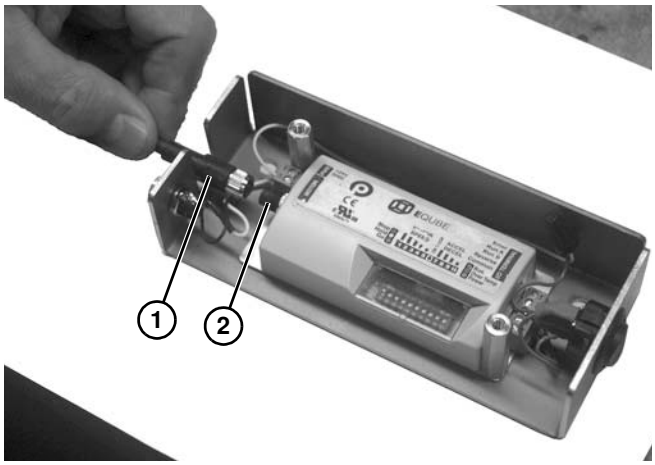


Figure 210

5. Replace controller.
6. Install in reverse order of removal.

Dual iDrive Controller

⚠ WARNING

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

1. Release belt tension. (Refer to "Conveyor Belt Tensioning" on page 33.)
2. Remove two screws **(Figure 211, item 1)** and cover **(Figure 211, item 2)**.

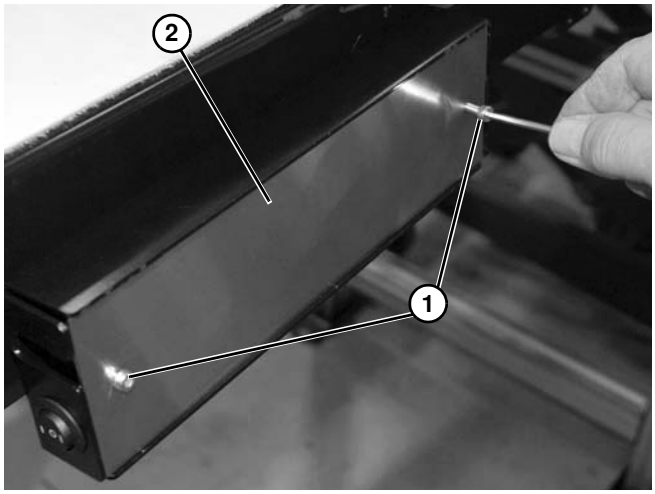


Figure 211

3. Remove two nuts **(Figure 212, item 1)** and screws **(Figure 212, item 2)** securing controller assembly **(Figure 212, item 3)** onto mounting bracket.

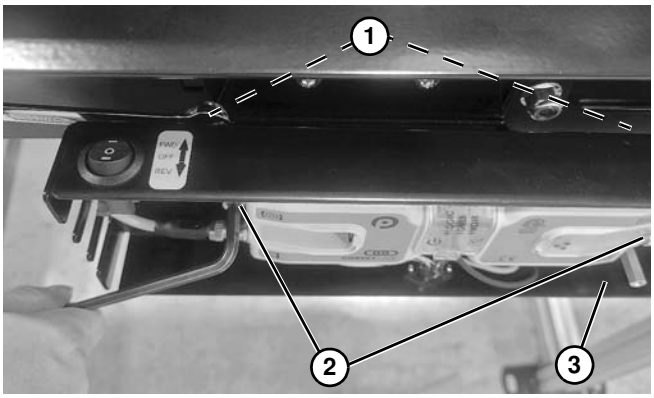


Figure 212

4. Remove two screws **(Figure 213, item 1)** holding controller **(Figure 213, item 2)** onto bracket assembly **(Figure 213, item 3)**.

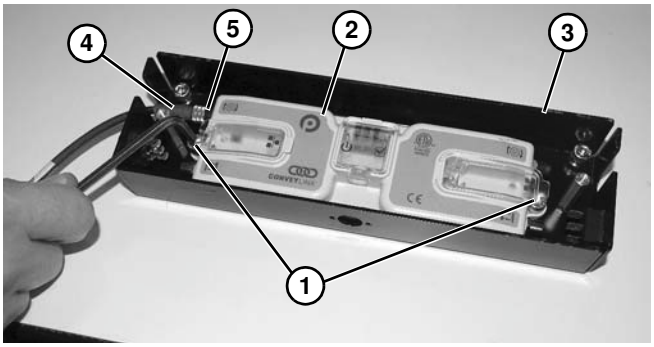


Figure 213

5. Remove end **(Figure 213, item 4)** of motor wiring from threaded end **(Figure 213, item 5)** on controller.
6. Replace controller.
7. Install in reverse order of removal.

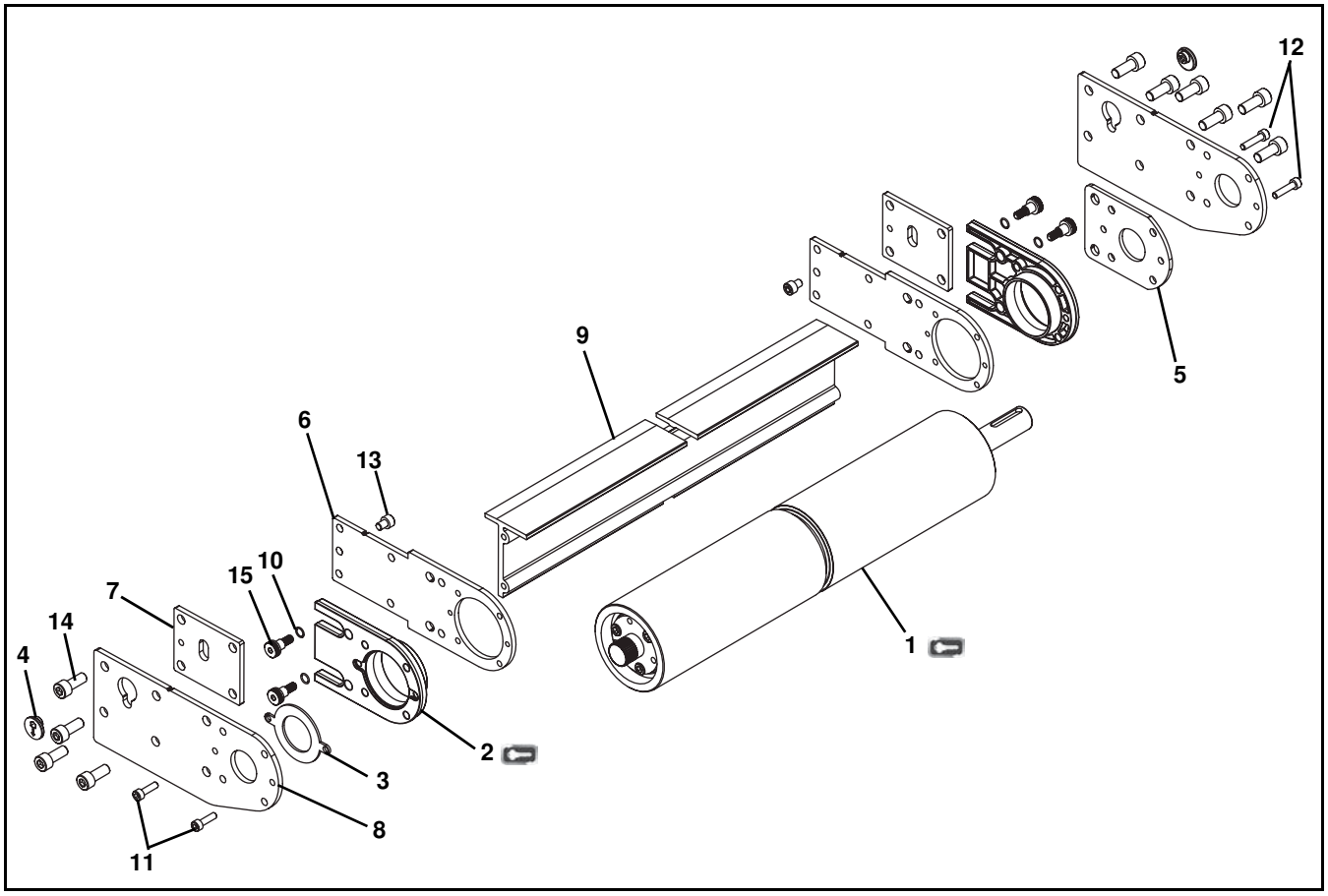
Notes

Service Parts

NOTE

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

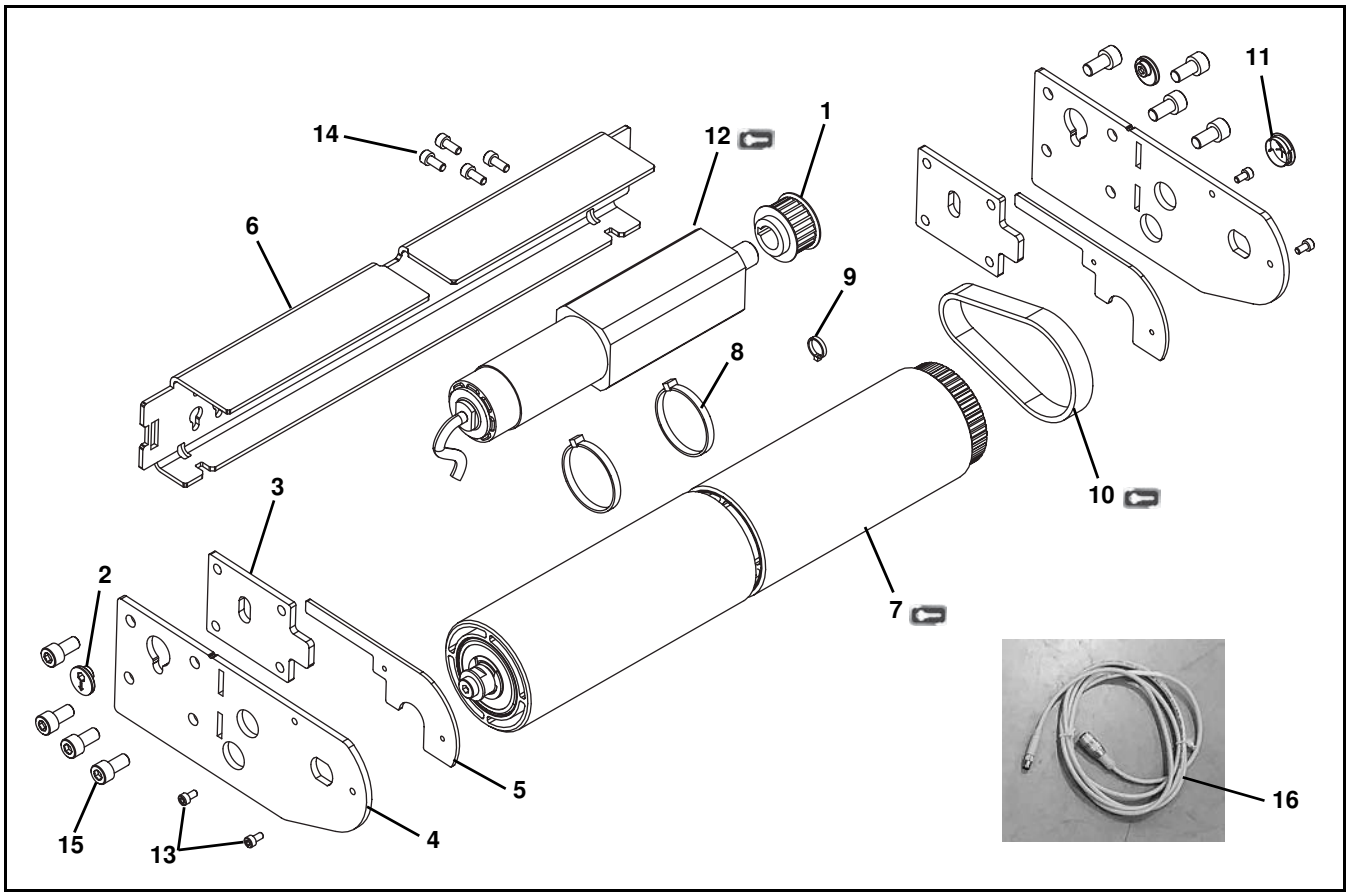
End Drive Fixed Tail Assembly



Item	Part Number	Description
1	3SDS-WWWW-M	Drive Spindle Kit
	3SDDS-WWWW-M	Dual Shaft Drive Spindle Kit
2	350312	Bearing Housing
3	350365	Bearing Stop Plate
4	350404	Tracking Cam
5	351145	Spacer Plate
6	351266	Backing Plate
7	351267	Frame Clamp Plate
8	351268	Cover Plate
9	351427-WWWW-M	Articulation Bar
10	812-100	O-Ring

Item	Part Number	Description
11	950518M	Low Head Cap Screw, M5-0.80 x 18 mm
12	920522M	Socket Head Screw, M5-0.80 x 22 mm
13	920608M	Socket Head Screw, M6-1.00 x 8 mm
14	920820M	Socket Head Screw, M8-1.25 x 20 mm
15	940808M	Shoulder Screw, 8 mm x 8 mm
WWWW = Conveyor width reference in mm 0254 - 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		

iDrive Tail Assembly



Item	Part Number	Description
1	208400	Pulley, 5 mm x 15 mm 22 tooth
2	350404	Tracking Cam
3	351343	Backing Plate
4	351414	Cover Plate
5	351420	Inner Plate
6	351396-WWWW-M	Crossmember
7	351397-WWWW-M	Spindle Assembly
8	805-064	Wire Tie, 11.5" long
9	805-1080	Wire Tie, 4" long
10	814-451	Timing Belt, 15 mm x 300 mm long
11	824-679	Grommet

Item	Part Number	Description
12	826-984	Motor, Type 'G'
	826-985	Motor, Type 'F'
	826-986	Motor, Type 'E'
	826-987	Motor, Type 'D'
	826-988	Motor, Type 'C'
	826-989	Motor, Type 'B'
	826-990	Motor, Type 'A'
13	920408M	Socket Head Screw, M4-0.70 x 8 mm
14	920512M	Socket Head Screw, M5-0.80 x 12 mm
15	920816M	Socket Head Screw, M8-1.25 x 16 mm
16	809-933	Cable

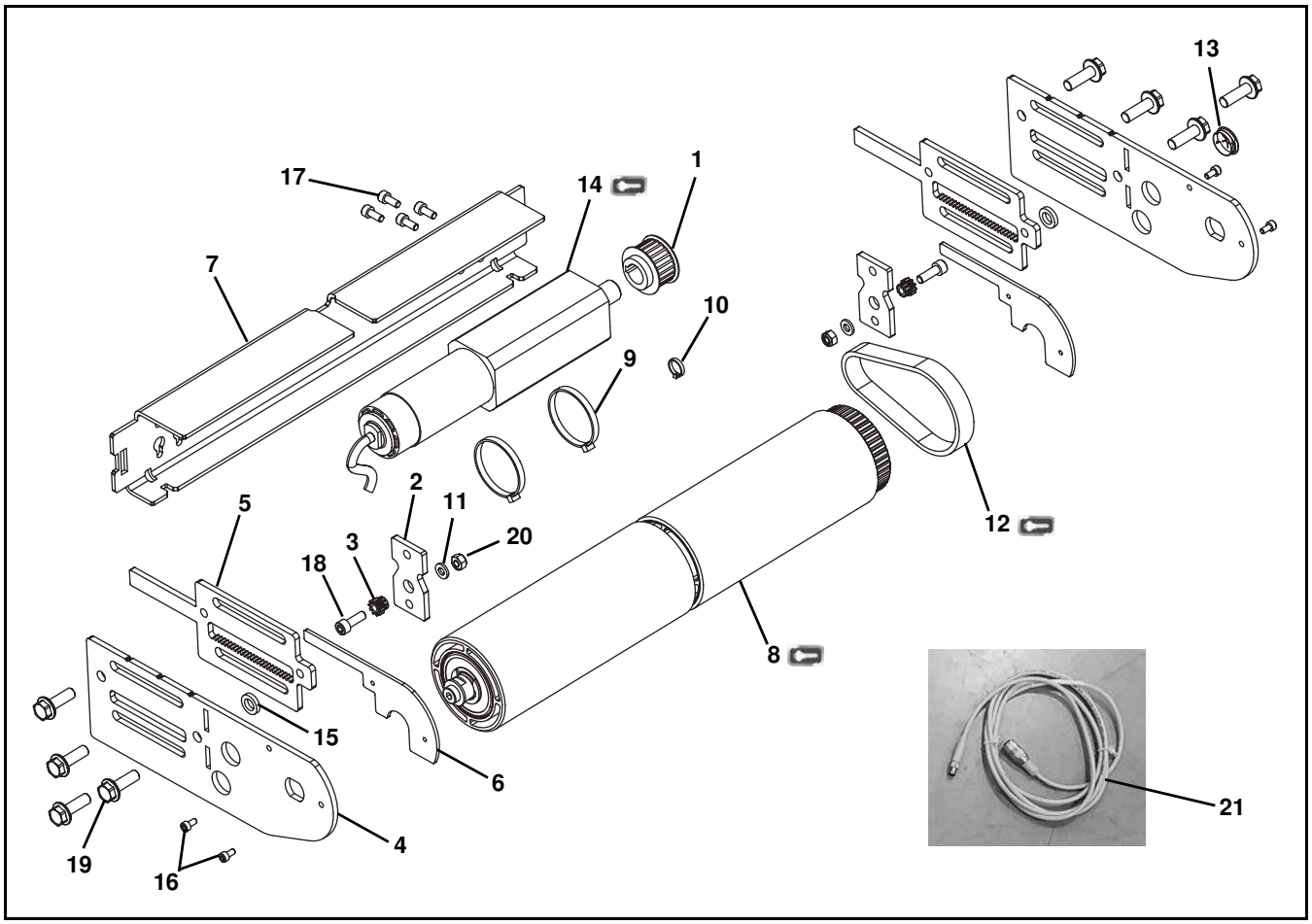
WWWW = Conveyor width reference in mm 0254 - 0914

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

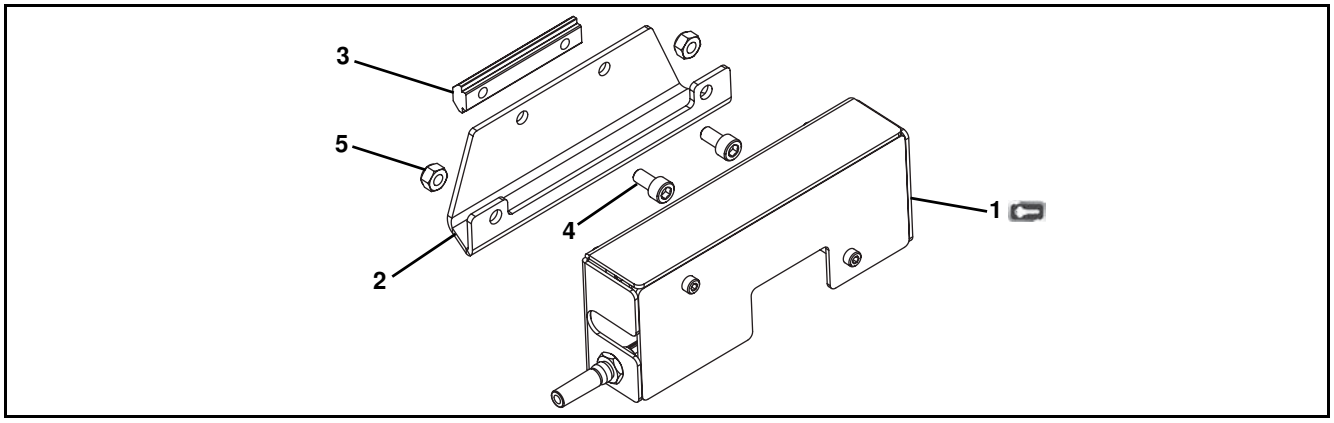
Dual Motor iDrive Tension Tail Assembly



Item	Part Number	Description
1	208400	Pulley, 5 mm x 15 mm 22 tooth
2	351261	Clamp Plate
3	351355	Gear Pinion
4	351393	Cover Plate
5	351395	Backing Plate
6	351420	Inner Plate
7	351396-WWWW-M	Crossmember
8	351397-WWWW-M	Spindle Assembly
9	805-064	Wire Tie, 11.5" long
10	805-1080	Wire Tie, 4" long
11	807-4280	Washer
12	814-451	Timing Belt, 15 mm x 300 mm long
13	824-679	Grommet
14	826-984	Motor, Type 'G'
	826-985	Motor, Type 'F'
	826-986	Motor, Type 'E'
	826-987	Motor, Type 'D'
	826-988	Motor, Type 'C'
	826-989	Motor, Type 'B'
	826-990	Motor, Type 'A'

Item	Part Number	Description
15	911-223	Washer
16	920408M	Shoulder Screw, 8 mm x 8 mm
17	920512M	Socket Head Screw, M5-0.80 x 12 mm
18	926018M	Socket Head Screw, M6-1.00 x 18 mm
19	960825MFY	Flanged Cap Screw, M8 x 25 mm
20	990602M	Lock Nut
21	809-933	Cable
WWWW = Conveyor width reference in mm 0254 - 0914		
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		

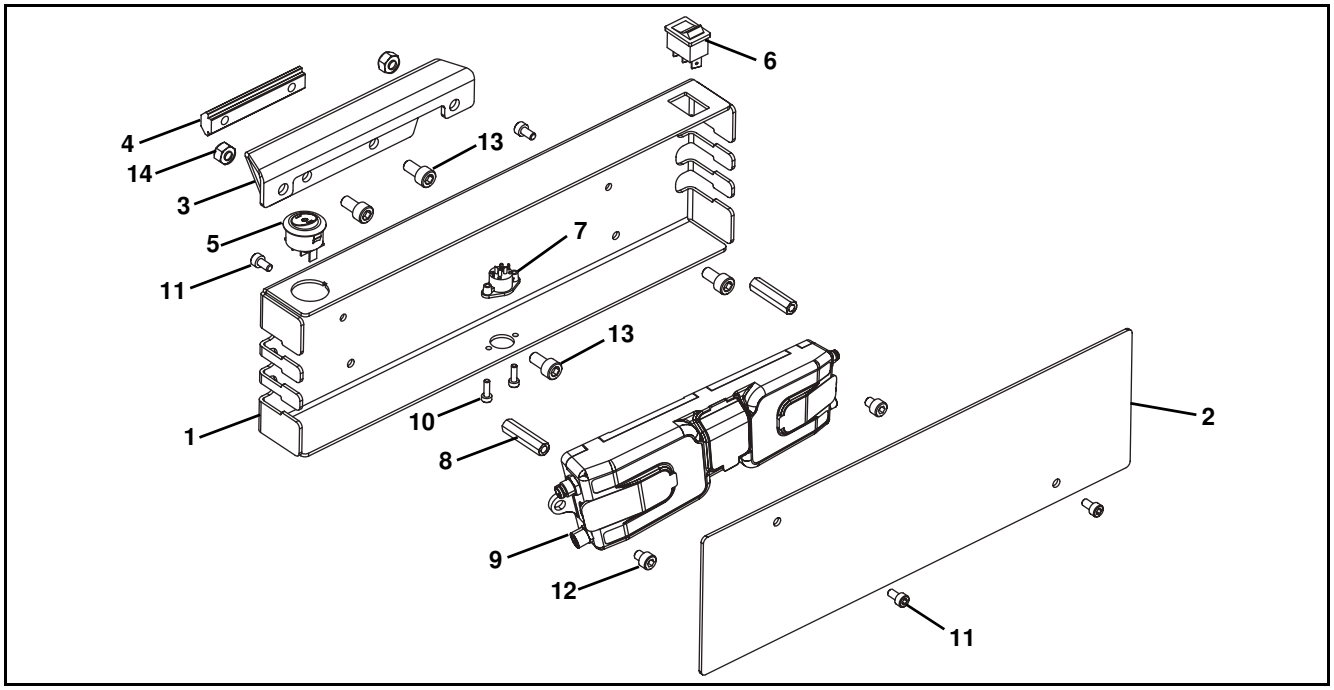
Single Motor iDrive Controller



Item	Part Number	Description
1	208451	Controller Assembly
2	351510	Mounting Bracket
3	300150M	Drop-In Tee Bar
4	920612M	Socket head Screw, M6-1.00 x 12 mm

Item	Part Number	Description
5	990602M	Lock Nut
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		

Dual Motor iDrive Controller

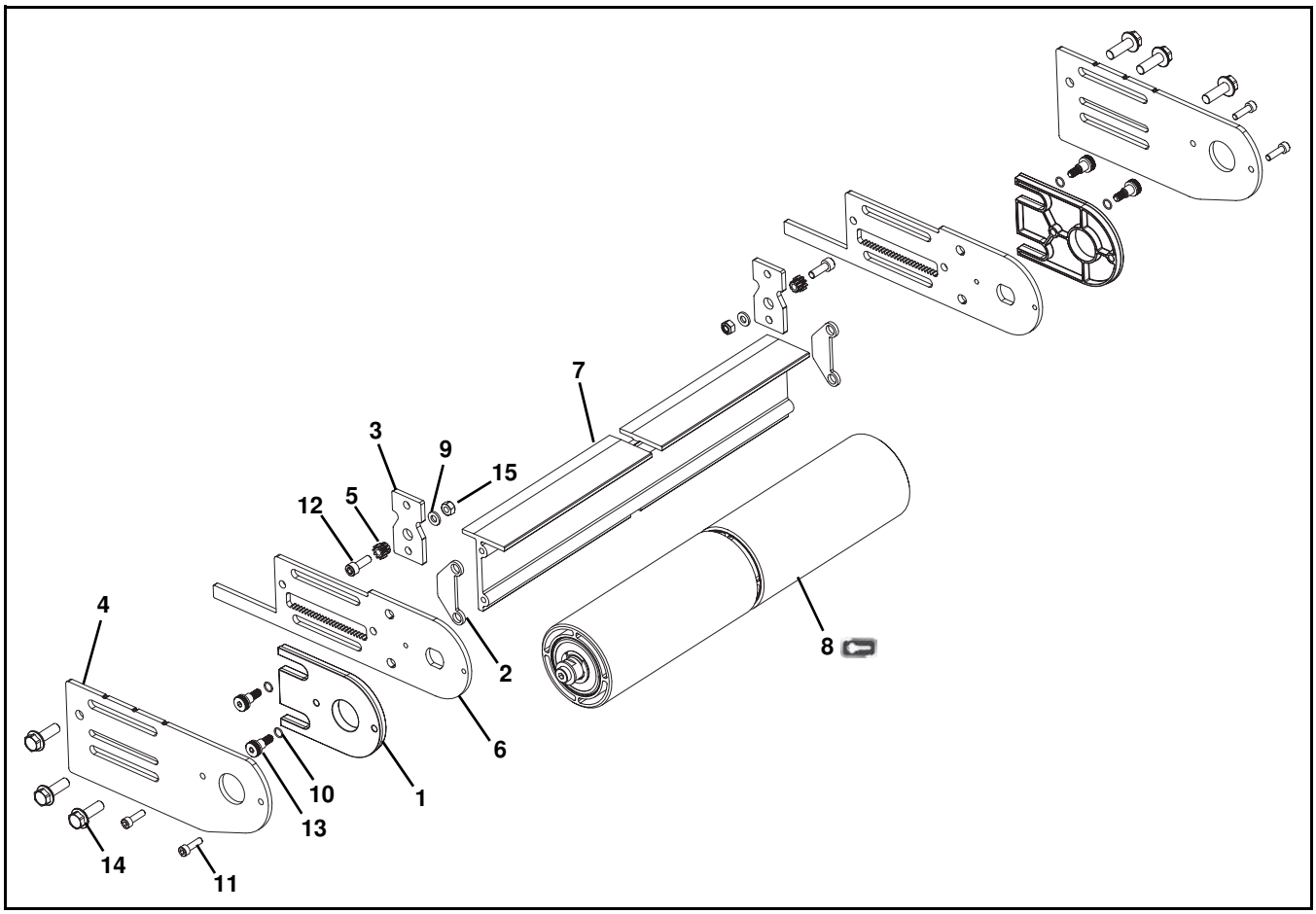


Item	Part Number	Description
1	351471	Controller Bracket
2	351472	Cover Plate
3	351510	Mounting Bracket
4	300150M	Drop-In Tee Bar
5	805-2606	Toggle Switch
6	805-2616	Toggle Switch
7	805-2618	4 Pin Connector
8	805-2619	Standoff
9	826-999	Controller

Item	Part Number	Description
10	920310M	Socket Head Screw, M3-0.50 x 10 mm
11	920408M	Socket Head Screw, M4-0.70 x 8 mm
12	920506M	Socket Head Screw, M5-0.80 x 6 mm
13	920612M	Socket Head Screw, M6-1.00 x 12 mm
14	990602M	Lock Nut
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		

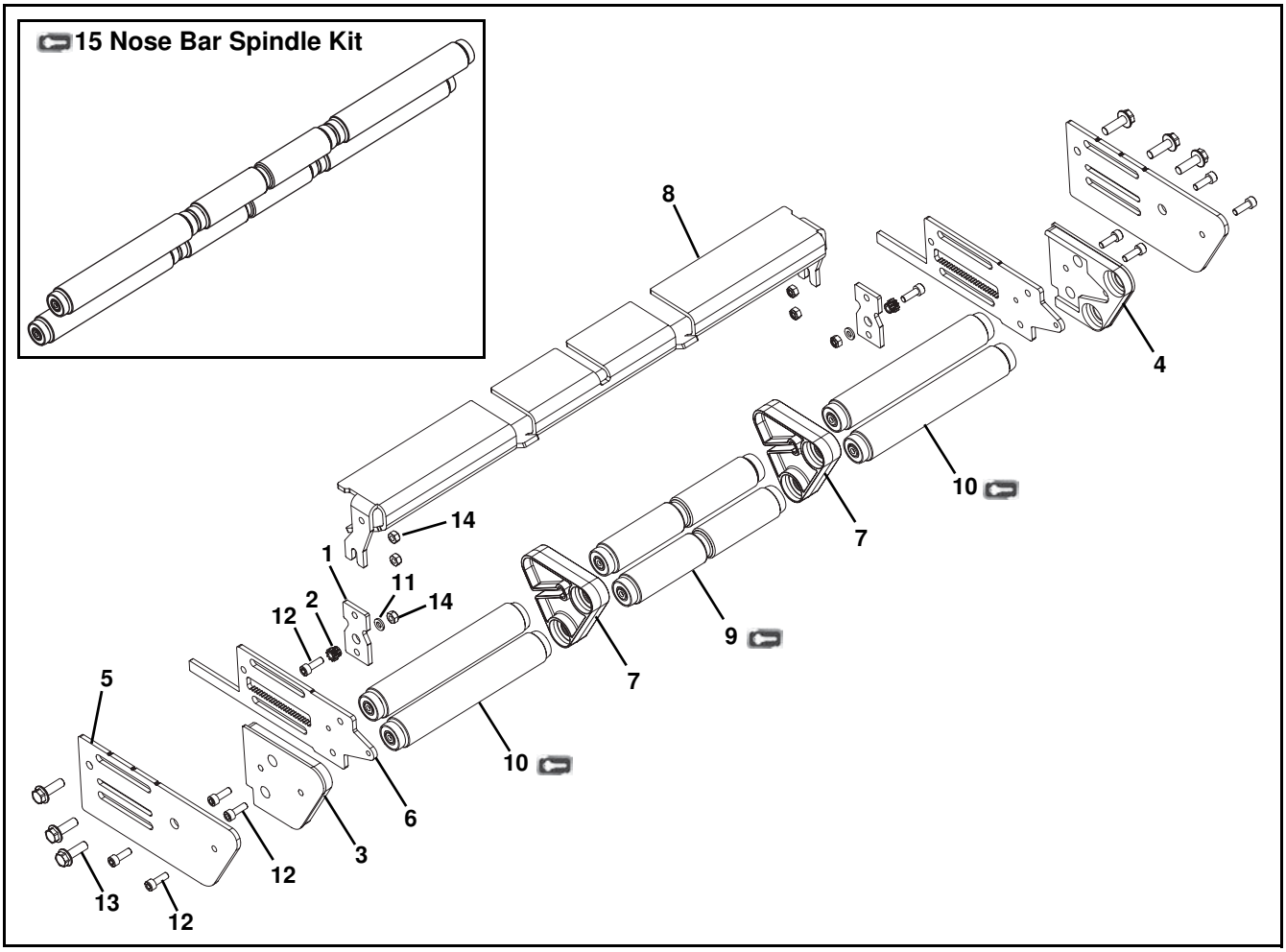
Service Parts

Tension Tail Assembly



Item	Part Number	Description
1	350314	Bearing Housing
2	351259	Filler Plate
3	351261	Clamp Plate
4	351318	Cover Plate
5	351355	Gear Pinion
6	351467	Tension Tail Plate
7	351427-WWWW-M	Articulation Bar
8	351428-WWWW-M	Spindle Assembly
9	807-4280	Washer
10	812-100	O-Ring
11	920518M	Socket Head Screw, M5-0.80 x 18 mm
12	920618M	Socket Head Screw, M6-1.00 x 18 mm
13	940808M	Shoulder Screw, 8 mm x 8 mm
14	960825MFY	Flanged Cap Screw, M8 x 25 mm
15	990602M	Lock Nut
WWWW = Conveyor width reference in mm 0254 - 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		

Nose Bar Tail Assembly

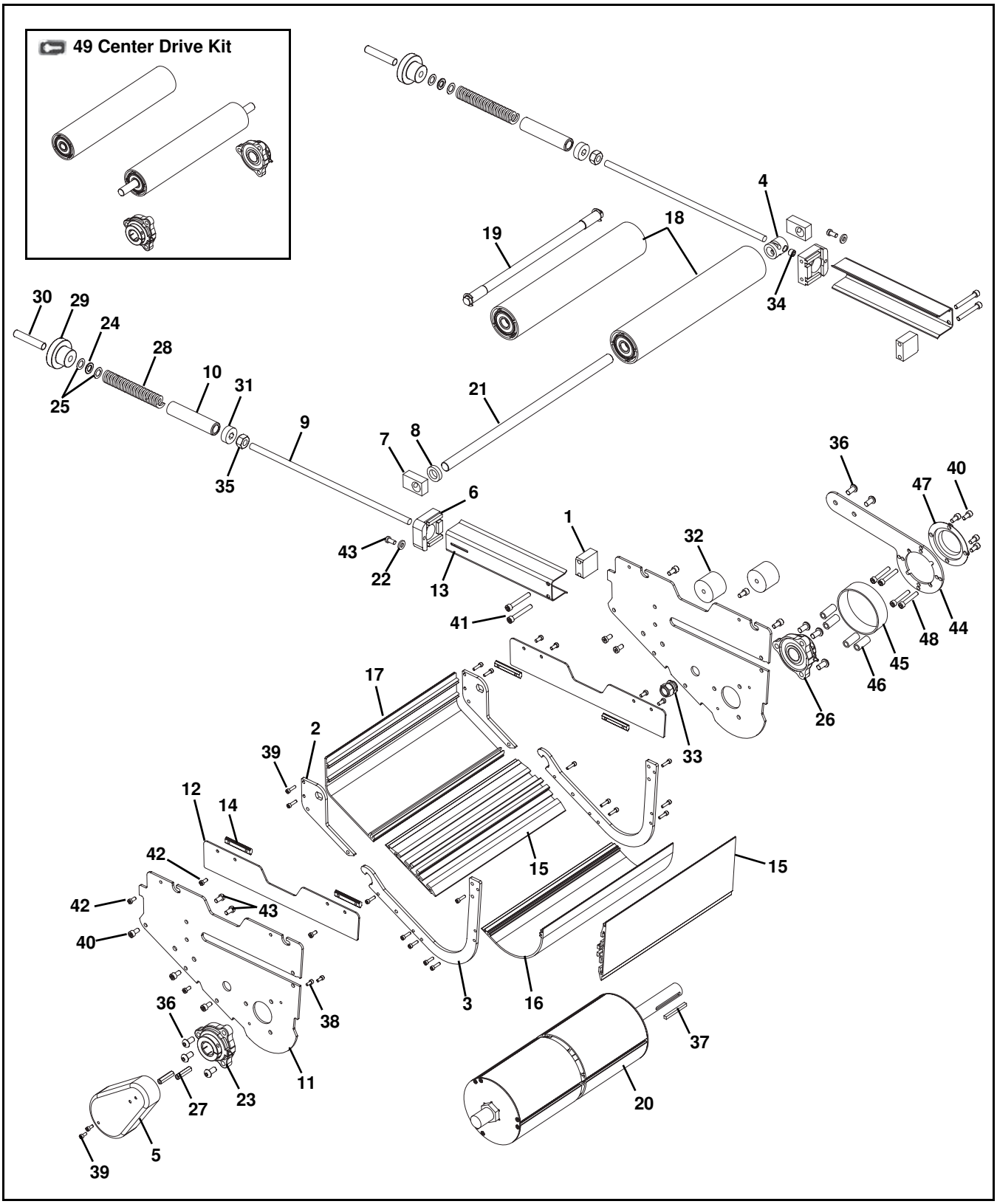


Item	Part Number	Description
1	351261	Clamp Plate
2	351355	Gear Pinion
3	351374	Spacer Plate, Right
4	351375	Spacer Plate, Left
5	351459	Cover Plate
6	351460	Backing Plate
7	516929	Nose Bar Puck
8	351378-WWWW-M	Crossmember Bracket
9	351519-WWWW-M	V-Groove Spindle Assembly
10	351520-WWWW-M	Spindle Assembly
11	807-4280	Washer
12	920618M	Socket Head Screw, M6-1.00 x 18 mm

Item	Part Number	Description
13	960825MFY	Flanged Cap Screw, M8 x 25 mm
14	990602M	Lock Nut
15	3SNTS-WWWW-M	Nose Bar Spindle Kit (Includes items 9 & 10)
WWWW = Conveyor width reference in mm 0254 - 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

Center Drive Assembly



Item	Part Number	Description
1	301216	Cylinder Guard Mounting Block
2	301220	End Roller Mounting Plate
3	301221	Horseshoe Guard Mounting Plate
4	301222	Center Drive Tension Pulley Spacer
5	301278	Center Drive Bearing Guard
6	301355	Cylinder Mounting Block
7	301356	Cylinder-Rod Mounting Block
8	301357	Tension Pulley Spacer
9	301410	Threaded Rod, 1/2" x 17" Long
10	3015WW	Spring Cage (10" though 22" Wide Conveyors)
	301524	Spring Cage (24" Wide and Wider Conveyors)
11	351296	Center Drive Side Plate
12	351298	Spacer Plate
13	532419	Channel Guard
14	300150M	Drop-In Tee Bar
15	See Table 1	Flat Guard
16	351406-WWWW-M	Bottom Corner Guard
17	351407-WWWW-M	Bottom End Guard
18	351413-WWWW-M	Idler Pulley
19	351440-WWWW-M	Wand Assembly
20	351451-WWWW-M	Center Drive Pulley
	351454-WWWW-M	Center Drive Pulley for SEW motors
21	351456-WWWW-M	Tension Pulley Shaft
22	605280P	Washer
23	802-138	3 Bolt Bearing
24	802-139	Thrust Bearing Cage
25	802-140	Thrust Bearing Washer
26	802-138	3 Bolt Bearing
	802-194	3 Bolt Bearing for SEW motors
27	807-1162	Hex Standoff
28	807-1183	Spring - Red (10" through 12" Wide Conveyors)
	807-1184	Spring - Bronze (14" through 48" Wide Conveyors)
29	807-1185	Knurled Knob
30	807-1186	End Cap
31	807-1189	Threaded Plug
32	812-061	Anti-Rotation Bushing
33	824-331	Connector
34	825-160	Plug
35	910-081	Hex Jam Nut, 1/2" - 20
36	911020M	Button Head Screw, M10-1.50 x 20 mm
37	912-111	Square Key, 0.25" x 2.50"
38	920512M	Socket Head Screw, M5-0.80 x 12 mm
39	920520M	Socket Head Screw, M5-0.80 x 20 mm
40	920816M	Socket Head Screw, M8-1.25 x 16 mm
41	920860M	Socket Head Screw, M8-1.25 x 60 mm
42	950614M	Low Head Cap Screw, M6-1.00 x 14 mm
43	950816M	Low Head Cap Screw, M8-1.25 x 16 mm
44	301217	Torsion Arm Plate
45	301281	Pipe Guard

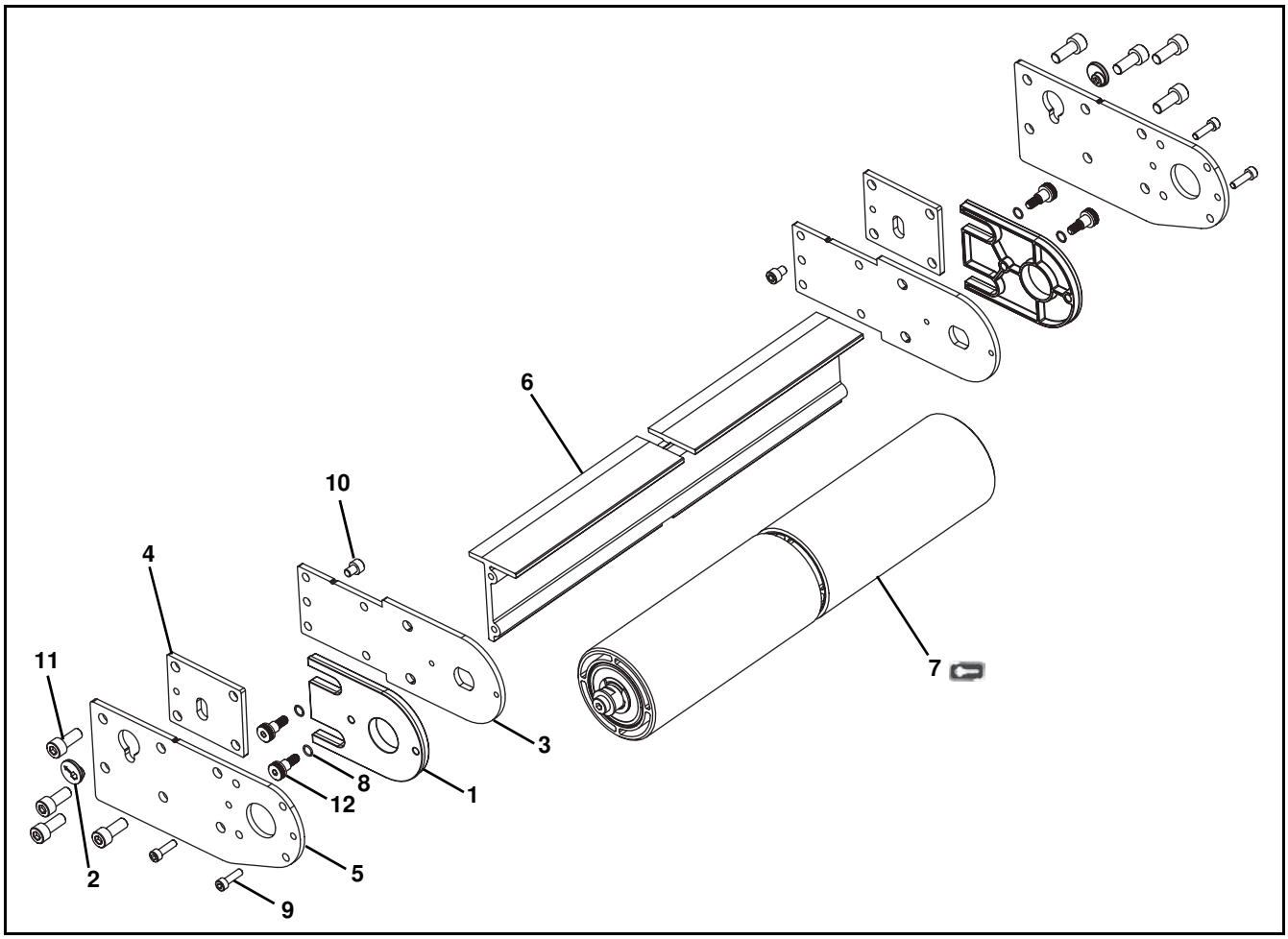
Item	Part Number	Description
46	201732	Spacer, for SEW Gearmotors
47	807-1167	Cover
48	920850M	Socket Head Screw, M8-1.25 x 50 mm
49	3SCD-WWWW-M	Center Drive Kit (Includes items 18, 19, 21, 23 & 26)
	3SCD5-WWWW-M	SEW Center Drive Kit (Includes items 18, 19, 21, 23 & 26)
WW = Conveyor width reference in inches 10 - 48		
WWWW = Conveyor width reference in mm 0254 - 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		

Table 1 – Part Number Per Conveyor Width

Conveyor Width (mm)	Item 15 – Flat Guard
0254	300895-009999
0305	300895-011999
0356	300895-013999
0406	300895-015999
0457	300895-017999
0508	300895-019999
0559	300895-021999
0610	300895-023999
0660	300895-025999
0711	300895-027999
0762	300895-029999
0813	300895-031999
0864	300895-033999
0914	300895-035999
0965	300895-037999
1016	300895-039999
1067	300895-041999
1118	300895-043999
1168	300895-045999
1219	300895-047999

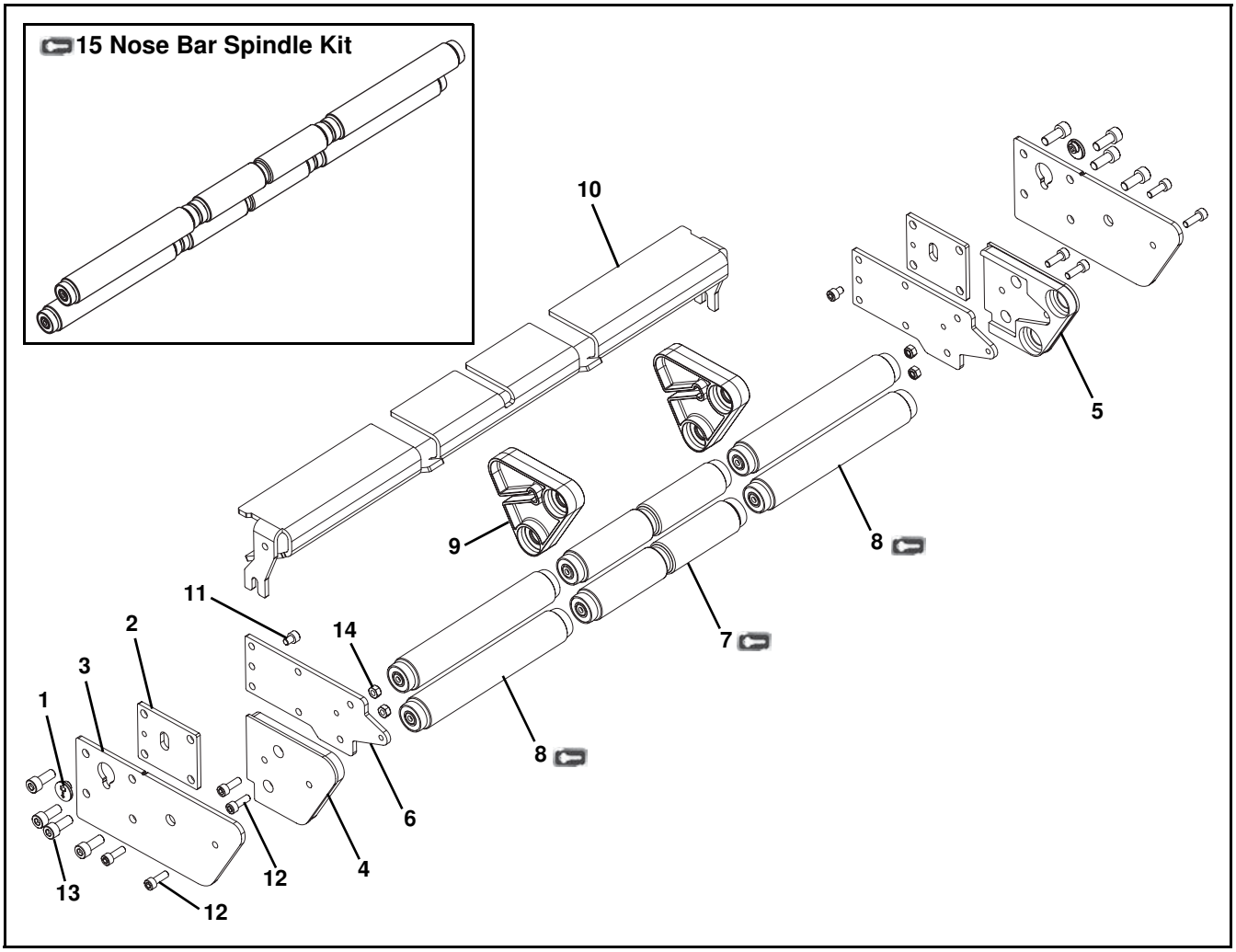
Service Parts

Center Drive Fixed Tail Assembly



Item	Part Number	Description
1	350314	Bearing Housing
2	350404	Tracking Cam
3	351264	Backing Plate
4	351267	Frame Clamp Plate
5	351268	Cover Plate
6	351427-WWWW-M	Articulation Bar
7	351428-WWWW-M	Spindle Assembly
8	812-100	O-Ring
9	920518M	Socket Head Screw, M5-0.80 x 18 mm
10	920608M	Socket Head Screw, M6-1.00 x 8 mm
11	920820M	Socket Head Screw, M8-1.25 x 20 mm
12	940808M	Shoulder Screw, 8 mm x 8 mm
WWWW = Conveyor width reference in mm 0254 - 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		

Center Drive Fixed Nose Bar Tail Assembly

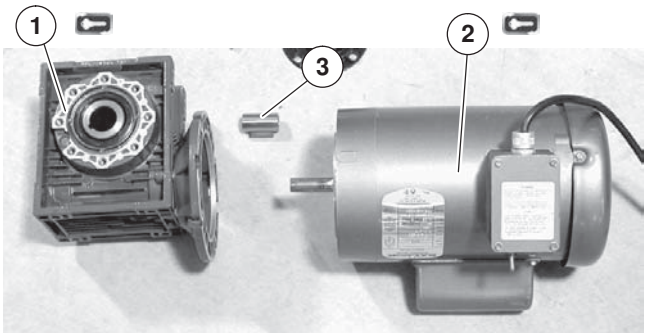


Item	Part Number	Description
1	350404	Tracking Cam
2	351267	Frame Clamp Plate
3	351366	Cover Plate
4	351374	Spacer Plate, Right
5	351375	Spacer Plate, Left
6	351376	Backing Plate
7	351519-WWWW-M	V-Groove Spindle Assembly
8	351520-WWWW-M	Spindle Assembly
9	516929	Nose Bar Puck
10	531378-WWWW-M	Crossmember

Item	Part Number	Description
11	920608M	Socket Head Screw, M6-1.00 x 8 mm
12	920618M	Socket Head Screw, M8-1.25 x 18 mm
13	920820M	Socket Head Screw, M8-1.25 x 20 mm
14	990602M	Lock Nut
15	3SNTS-WWWW-M	Nose Bar Spindle Kit (Includes items 7 & 8)
WWWW = Conveyor width reference in mm 0254 - 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		

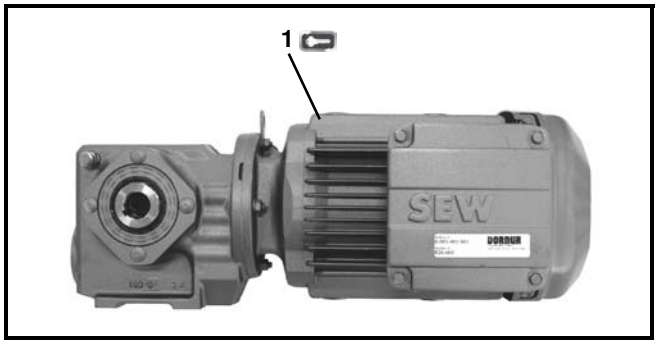
Service Parts

Center Drive 90° Gearmotors



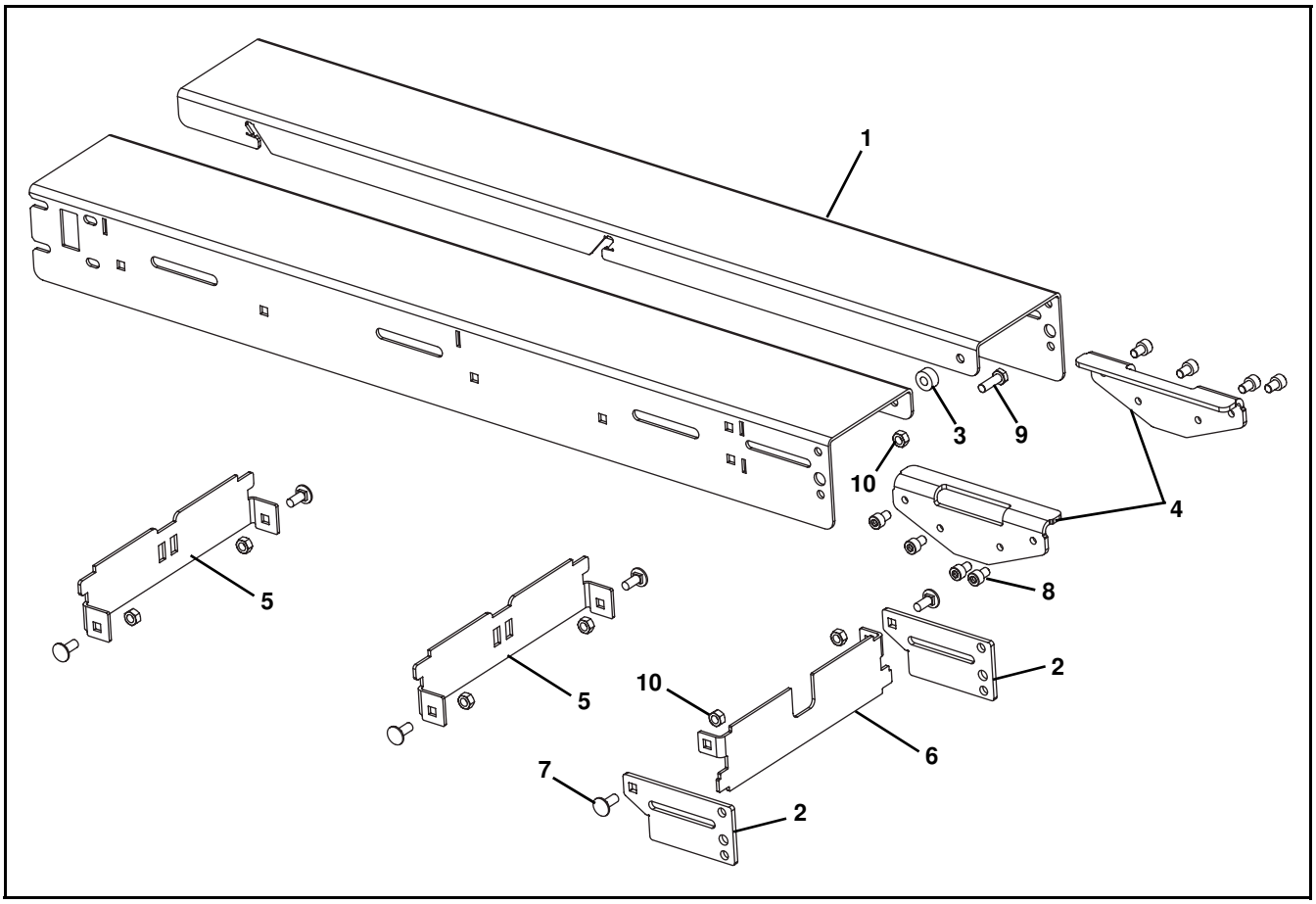
Item	Part No.	Part Description
1	32M008HH	Gear Reducer, 7.5:1 NEMA 140TC
	32M010HH	Gear Reducer, 10:1 NEMA 140TC
	32M015HH	Gear Reducer, 15:1 NEMA 140TC
	32M020HH	Gear Reducer, 20:1 NEMA 140TC
	32M025HH	Gear Reducer, 25:1 NEMA 140TC
	32M030HH	Gear Reducer, 30:1 NEMA 140TC
	32M040HH	Gear Reducer, 40:1 NEMA 140TC
	32M050HH	Gear Reducer, 50:1 NEMA 140TC
	32M060HH	Gear Reducer, 60:1 NEMA 56C
	32M080HH	Gear Reducer, 80:1 NEMA 56C
	32M100HH	Gear Reducer, 100:1 NEMA 56C
	52Z008HH	Gear Reducer, 7.5:1 NEMA 90B5
	52Z010HH	Gear Reducer, 10:1 NEMA 90B5
	52Z015HH	Gear Reducer, 15:1 NEMA 90B5
	52Z020HH	Gear Reducer, 20:1 NEMA 90B5
	52Z030HH	Gear Reducer, 30:1 NEMA 90B5
	52Z040HH	Gear Reducer, 40:1 NEMA 80B5
	52Z050HH	Gear Reducer, 50:1 NEMA 80B5
	52Z080HH	Gear Reducer, 80:1 NEMA 71B5
	52Z100HH	Gear Reducer, 100:1 NEMA 71B5
2	32MEH423FN10	Motor, 0.75 Kw (1 hp), 208–230/460 Volts, 60 Hz, 3 Phase
	32MEH423EN10	Motor, 0.75 Kw (1 hp), 230/460 Volts, 60 Hz, 3 Phase
	32MEH423FN15	Motor, 1.1 Kw (1.5 hp), 208–230/460 Volts, 60 Hz, 3 Phase
	32MEH423EN15	Motor, 1.1 Kw (1.5 hp), 230/460 Volts, 60 Hz, 3 Phase
	32MEH423FN20	Motor, 1.5 Kw (2 hp), 208–230/460 Volts, 60 Hz, 3 Phase
	32MEH423EN20	Motor, 1.5 Kw (2 hp), 230/460 Volts, 60 Hz, 3 Phase
	52ZHH423FN15	Motor, 1.5 Kw (2 hp), 208–230/460 Volts, 50 Hz, 3 Phase
3	820–329	Bushing Shaft Adapter, 56C to 140TC
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Center Drive SEW Gearmotors



Item	Part Number	Description
1	32M128WH423EN	Gearmotor, 0.25 Kw (0.33 hp), 230/460 Volts, 3 Phase
	32M044WH423EN	Gearmotor, 0.75 Kw (0.56 hp), 230/460 Volts, 3 Phase
	32M016WH423EN	Gearmotor, 1.12 Kw (1.50 hp), 230/460 Volts, 3 Phase
	32M008WH423EN	Gearmotor, 1.49 Kw (2.00 hp), 230/460 Volts, 3 Phase
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

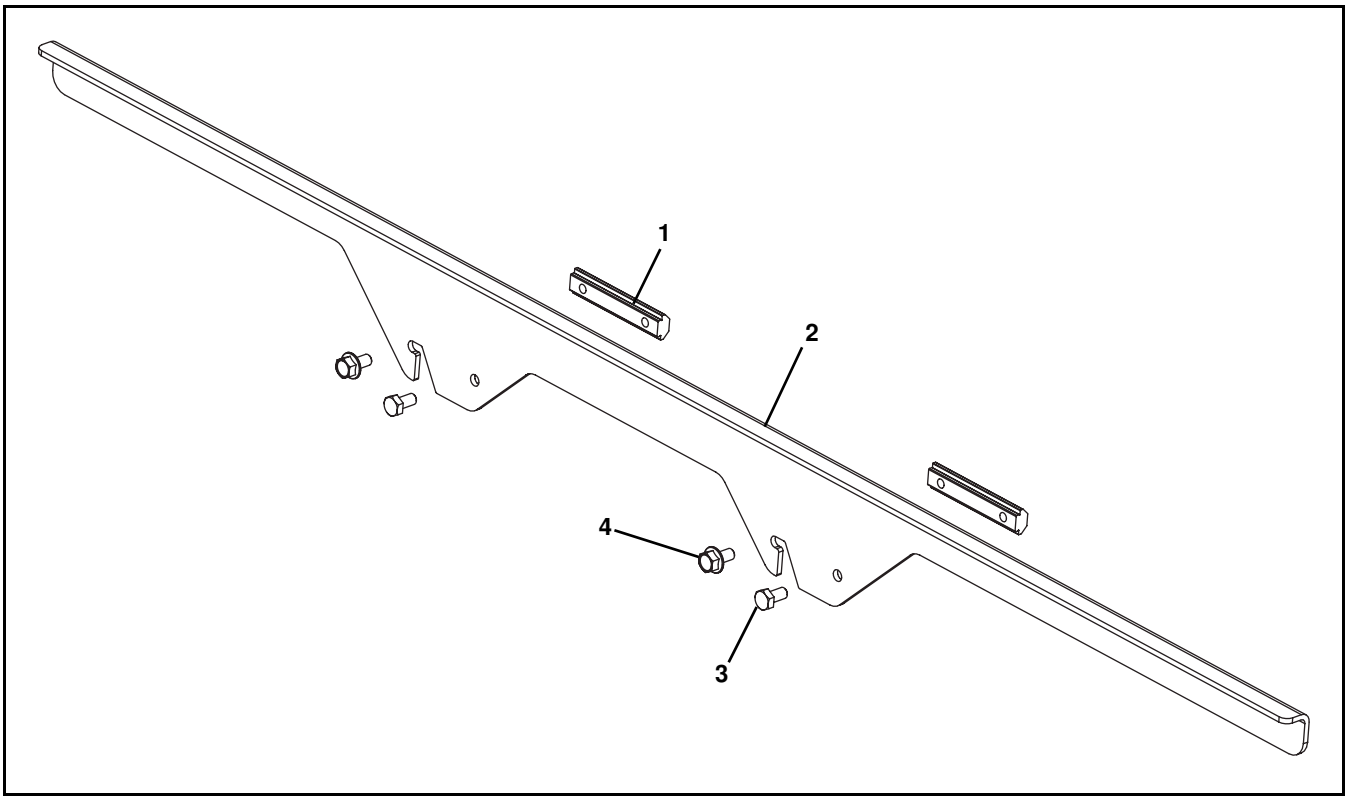
Frame Assembly



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	351252	Spacer Plate (not used on iDrive conveyors)
3	351274	Frame Spacer
4	351300	Connecting Bracket
5	351387-WWWW-M	Crossmember
6	351388-WWWW-M	Tension End Crossmember
	351469-WWWW-M	iDrive Tension End Crossmember
7	900820M	Carriage Bolt, M8 x 20 mm
8	920812M	Socket Head Screw, M8-1.25 x 12 mm
9	960825M	Hex Head Cap Screw, M8-1.25 x 25 mm
10	990801M	Hex Nut
WWWW = Conveyor width reference in mm 0254 - 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

High Sides



Item 2
Guide
Section
Description

(S) Discharge End (F) (F) Mid (F) (F) Infeed End (S or T)

(S) Discharge End (F) (F) Infeed End (S or T)

(S) Single Piece Guiding (T)

Right Hand

Discharge End ← Flow Infeed End

Left Hand

(S) Single Piece Guiding (T)

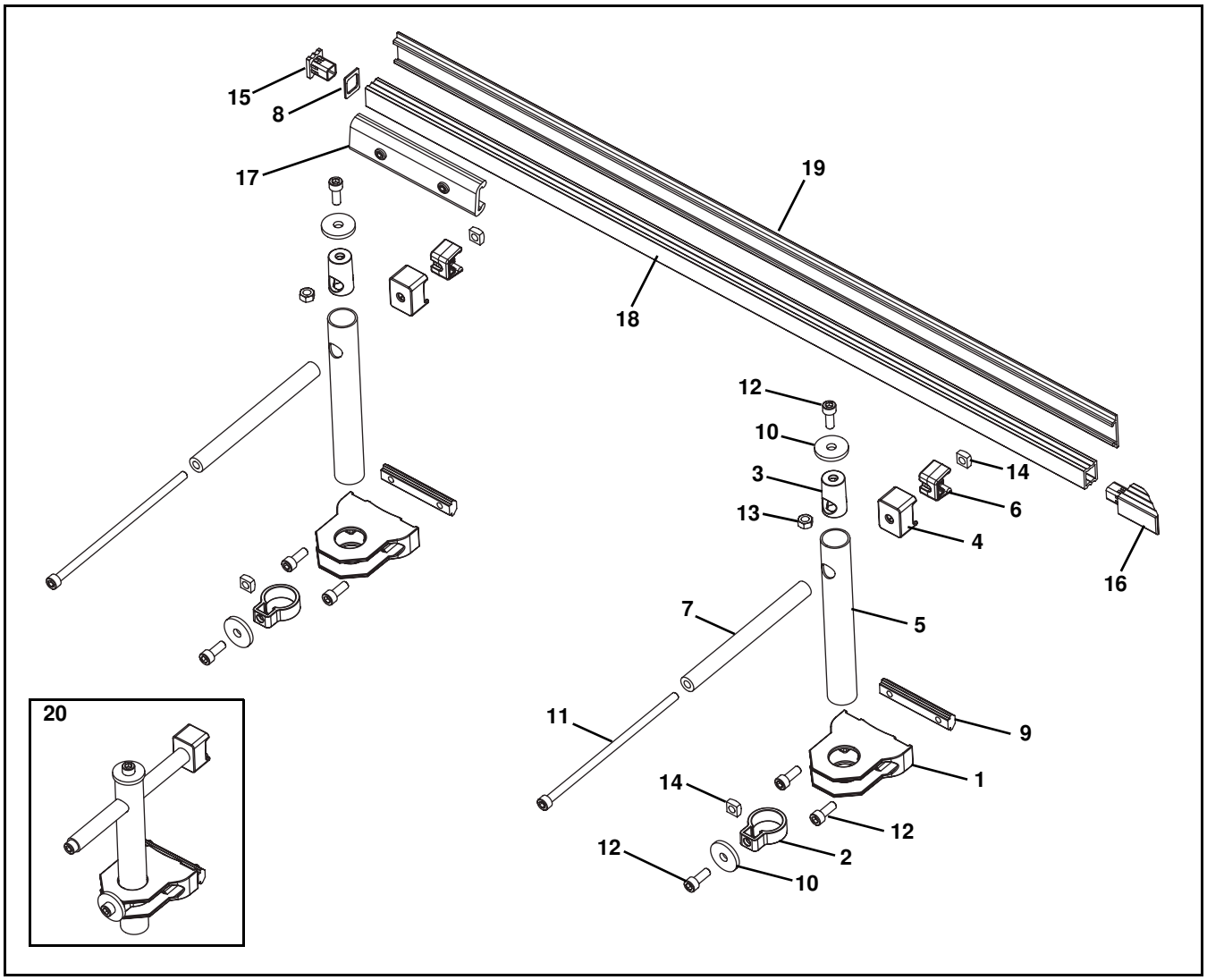
(S) Discharge End (F) (F) Infeed End (S or T)

(S) Discharge End (F) (F) Mid (F) (F) Infeed End (S or T)

Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	351493-LLLLL-M-STA	25 mm (1.00") Guiding for Single Piece Guiding
	351493-LLLLL-M-STB	75 mm (3.00") Guiding for Single Piece Guiding
	351493-LLLLL-M-STC	150 mm (6.00") Guiding for Single Piece Guiding
	351493-LLLLL-M-SFA	25 mm (1.00") Discharge End Guiding for Multi Piece Guiding
	351493-LLLLL-M-SFB	75 mm (3.00") Discharge End Guiding for Multi Piece Guiding
	351493-LLLLL-M-SFC	150 mm (6.00") Discharge End Guiding for Multi Piece Guiding
	351493-LLLLL-M-FTA	25 mm (1.00") Infeed Tension End Guiding for Multi Piece Guiding
	351493-LLLLL-M-FTB	75 mm (3.00") Infeed Tension End Guiding for Multi Piece Guiding
	351493-LLLLL-M-FTC	150 mm (6.00") Infeed Tension End Guiding for Multi Piece Guiding
	351493-LLLLL-M-FSA	25 mm (1.00") Infeed Fixed End Guiding for Multi Piece Guiding
	351493-LLLLL-M-FSB	75 mm (3.00") Infeed Fixed End Guiding for Multi Piece Guiding
	351493-LLLLL-M-FSC	150 mm (6.00") Infeed Fixed End Guiding for Multi Piece Guiding
	351493-LLLLL-M-FFA	25 mm (1.00") Mid Guiding for Multi Piece Guiding
	351493-LLLLL-M-FFB	75 mm (3.00") Mid Guiding for Multi Piece Guiding
	351493-LLLLL-M-FFC	150 mm (6.00") Mid Guiding for Multi Piece Guiding
3	960612M	Hex Head Cap Screw, M6-1.00 x 12 mm
4	960612MF	Flanged Cap Screw, M6 x 12 mm
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
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

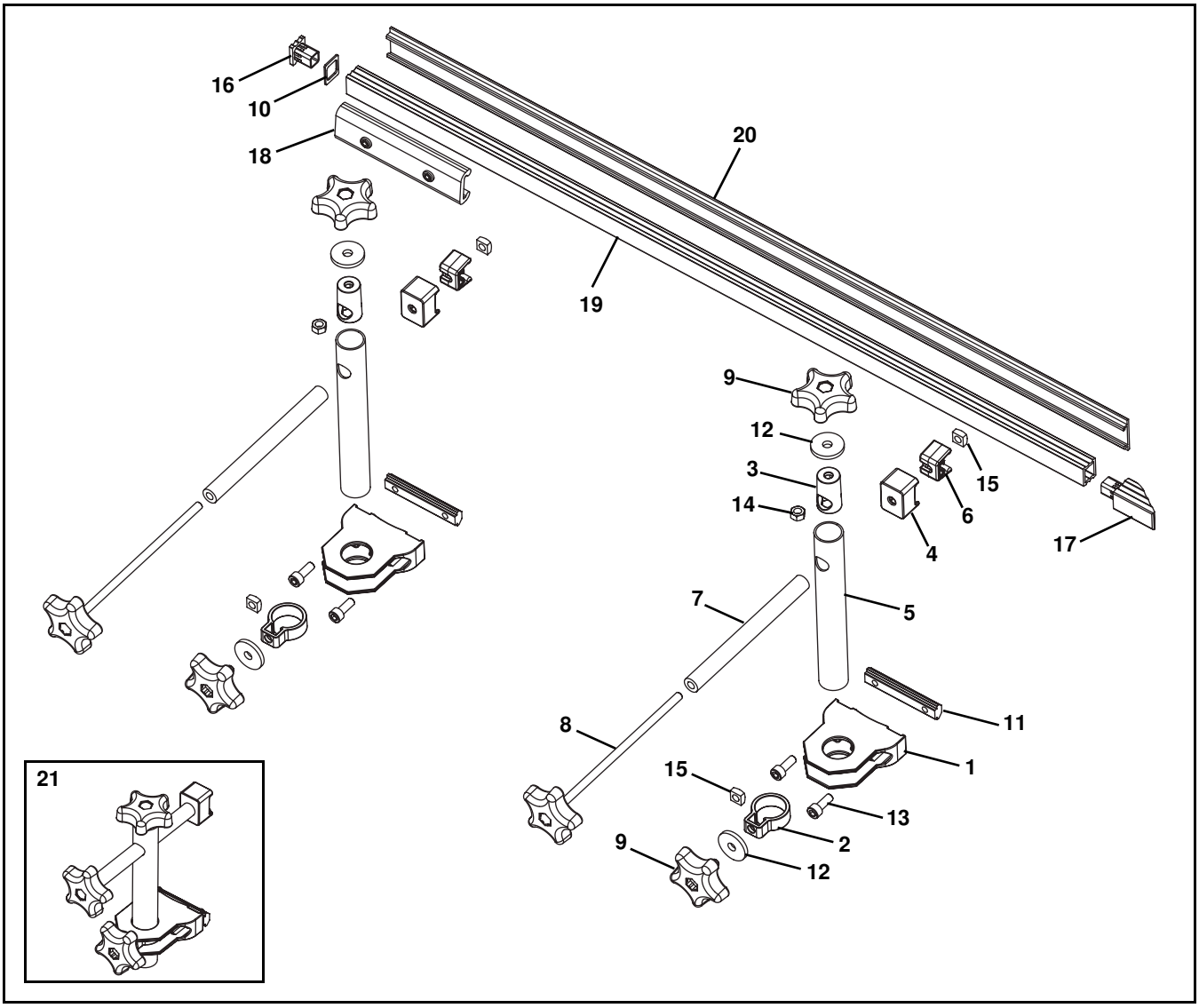
#13 & 43 Fully Adjustable Guides



Item	Part Number	Description
1	206380	Base
2	206381	Base Clamp
3	206382	Insert Clamp
4	206383	Guide Cup
5	206385	Tube
6	206397	Clip
7	206692	Guide Tube
8	207236	End Cap Spacer (Discharge End Only)
9	300150M	Drop-In Tee Bar
10	911-710	Washer
11	9206150M	Socket Head Screw, M6-1.00 x 150 mm
12	920616M	Socket Head Screw, M6-1.00 x 16 mm
13	990601M	Hex Nut
14	990603M	Square Nut
15	FGEC-15x20	End Cap (Discharge End Only)

Item	Part Number	Description
16	FGEC-30D	Lead In Cap (Infeed End Only)
17	FGRC-100	Connecting Rail
18	FGRR-15x20-LLLLL-M	Guide Rail
19	FGRT-3x33-LLLLL-M	1.3" Guide Rail Cover (for Profile 13 only)
20	351485	Adjustable Bracket Assembly (Includes Items 1 through 7 and 9 though 14)
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
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		

#14 & 44 Tool-Less Fully Adjustable Guides

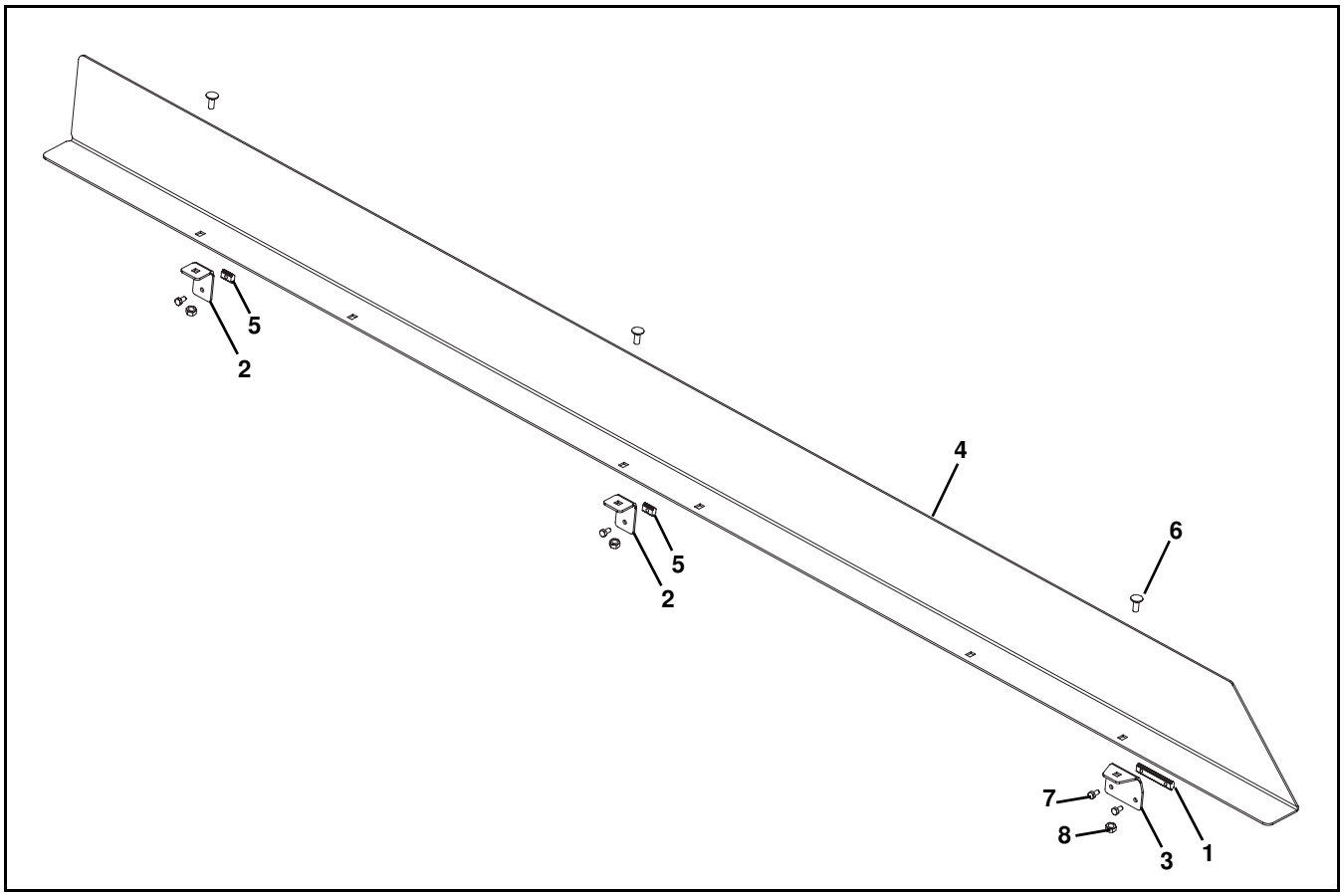


Item	Part Number	Description
1	206380	Base
2	206381	Base Clamp
3	206382	Insert Clamp
4	206383	Guide Cup
5	206385	Tube
6	206397	Clip
7	206692	Guide Tube
8	206697	Knob, 1502 mm
9	206698	Knob, 15 mm
10	207236	End Cap Spacer (Discharge End Only)
11	300150M	Drop-In Tee Bar
12	911-710	Washer
13	920616M	Socket Head Screw, M6-1.00 x 16 mm
14	990601M	Hex Nut
15	990603M	Square Nut
16	FGEC-15x20	End Cap (Discharge End Only)

Item	Part Number	Description
17	FGEC-30D	Lead In Cap (Infeed End Only)
18	FGRC-100	Connecting Rail
19	FGRR-15x20-LLLLL-M	Guide Rail
20	FGRT-3x33-LLLLL-M	1.3" Guide Rail Cover (for Profile 13 only)
21	351486	Adjustable Bracket Assembly (Includes Items 1 through 9 and 11 though 15)
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
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

Cleated High Side Guiding



Item 4
Guide
Section
Description

(S) Discharge End (F) (F) Mid (F) (F) Infeed End (S or T)

(S) Discharge End (F) (F) Infeed End (S or T)

(S) Single Piece Guiding (T)

Right Hand

Discharge End ← Flow Infeed End

Left Hand

(S) Single Piece Guiding (T)

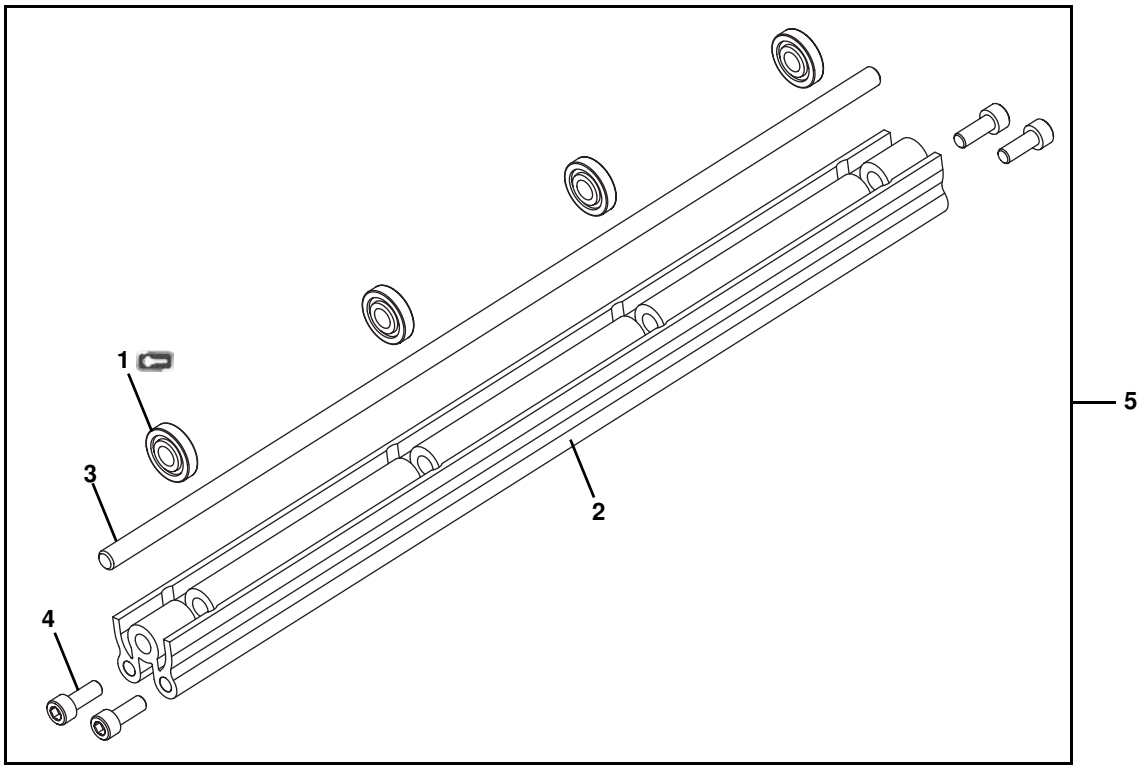
(S) Discharge End (F) (F) Infeed End (S or T)

(S) Discharge End (F) (F) Mid (F) (F) Infeed End (S or T)

Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	351404-A	Single Hole Bracket
3	351404-B	Dual Hole Bracket
4	351476-LLLLL-M-STAA	25 mm (1.00") Cleated Guiding for Single Piece Guiding, 'A' Side
	351476-LLLLL-M-STAD	25 mm (1.00") Cleated Guiding for Single Piece Guiding, 'D' Side
	351476-LLLLL-M-STBA	75 mm (3.00") Cleated Guiding for Single Piece Guiding, 'A' Side
	351476-LLLLL-M-STBD	75 mm (3.00") Cleated Guiding for Single Piece Guiding, 'D' Side
	351476-LLLLL-M-STCA	150 mm (6.00") Cleated Guiding for Single Piece Guiding, 'A' Side
	351476-LLLLL-M-STCD	150 mm (6.00") Cleated Guiding for Single Piece Guiding, 'D' Side
	351476-LLLLL-M-SFAA	25 mm (1.00") Discharge End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-SFAD	25 mm (1.00") Discharge End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-SFBA	75 mm (3.00") Discharge End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-SFBD	75 mm (3.00") Discharge End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-SFCA	150 mm (6.00") Discharge End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-SFCD	150 mm (6.00") Discharge End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FTAA	25 mm (1.00") Infeed Tension End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FTAD	25 mm (1.00") Infeed Tension End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FTBA	75 mm (3.00") Infeed Tension End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FTBD	75 mm (3.00") Infeed Tension End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FTCA	150 mm (6.00") Infeed Tension End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FTCD	150 mm (6.00") Infeed Tension End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FSAA	25 mm (1.00") Infeed Fixed End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FSAD	25 mm (1.00") Infeed Fixed End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FSBA	75 mm (3.00") Infeed Fixed End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FSBD	75 mm (3.00") Infeed Fixed End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FSCA	150 mm (6.00") Infeed Fixed End Cleated Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FSCD	150 mm (6.00") Infeed Fixed End Cleated Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FFAA	25 mm (1.00") Mid Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FFAD	25 mm (1.00") Mid Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FFBA	75 mm (3.00") Mid Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FFBD	75 mm (3.00") Mid Guiding for Multi Piece Guiding, 'D' Side
	351476-LLLLL-M-FFCA	150 mm (6.00") Mid Guiding for Multi Piece Guiding, 'A' Side
	351476-LLLLL-M-FFCD	150 mm (6.00") Mid Guiding for Multi Piece Guiding, 'D' Side
5	639971M	Drop-In Tee Bar
6	900820MY	Carriage Bolt, M8-1.25 x 25 mm
7	960612M	Hex Head Cap Screw, M6-1.00 x 12 mm
8	990812M	Lock Nut
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
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		

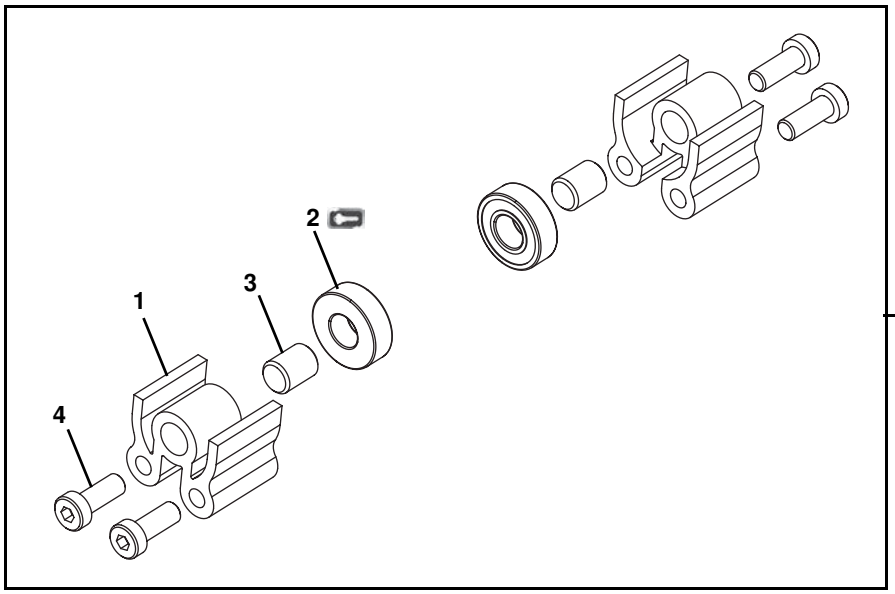
Service Parts

Flat Belt Return Roller



Item	Part Number	Description
1	240826	Return Roller Bearing
2	351391-WWWW-M	Return Roller Guard
3	351392-WWWW-M	Return Roller Rod
4	920616M	Socket Head Screw, M6-1.00 x 16 mm
5	351384-WWWW-M	Flat Belt Return Roller Assembly (Includes items 1 through 4)
WWWW = Conveyor width reference in mm 0254 - 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		

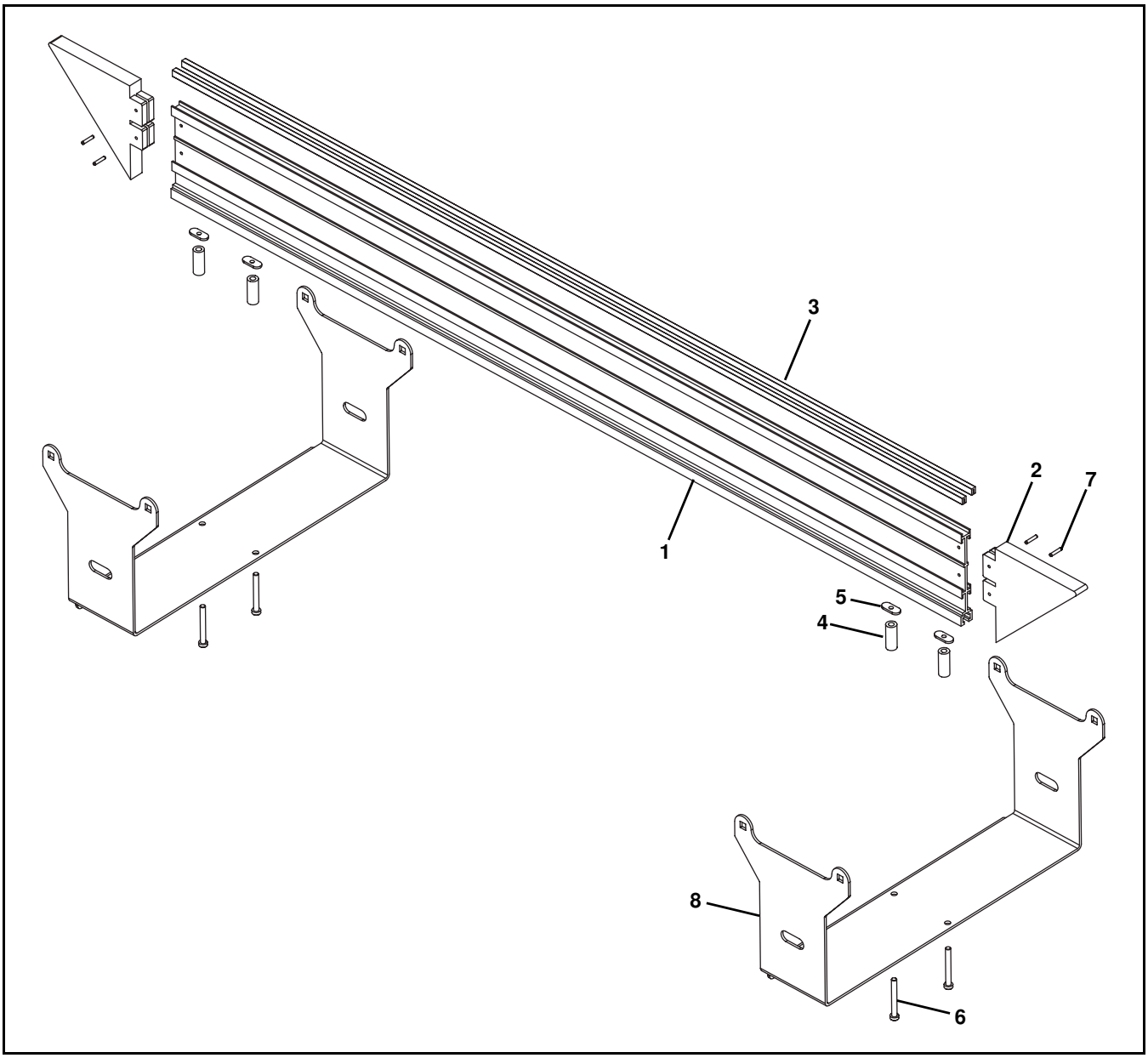
Cleated Belt Return Roller



Item	Part Number	Description
1	240825	Return Roller Guard
2	802–027	Bearing
3	913–100	Dowel Pin
4	950616M	Low Head Cap Screw M6-1.00 x 16 mm
5	351446	Cleated Belt Return Roller Assembly (Includes items 1 through 4)
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

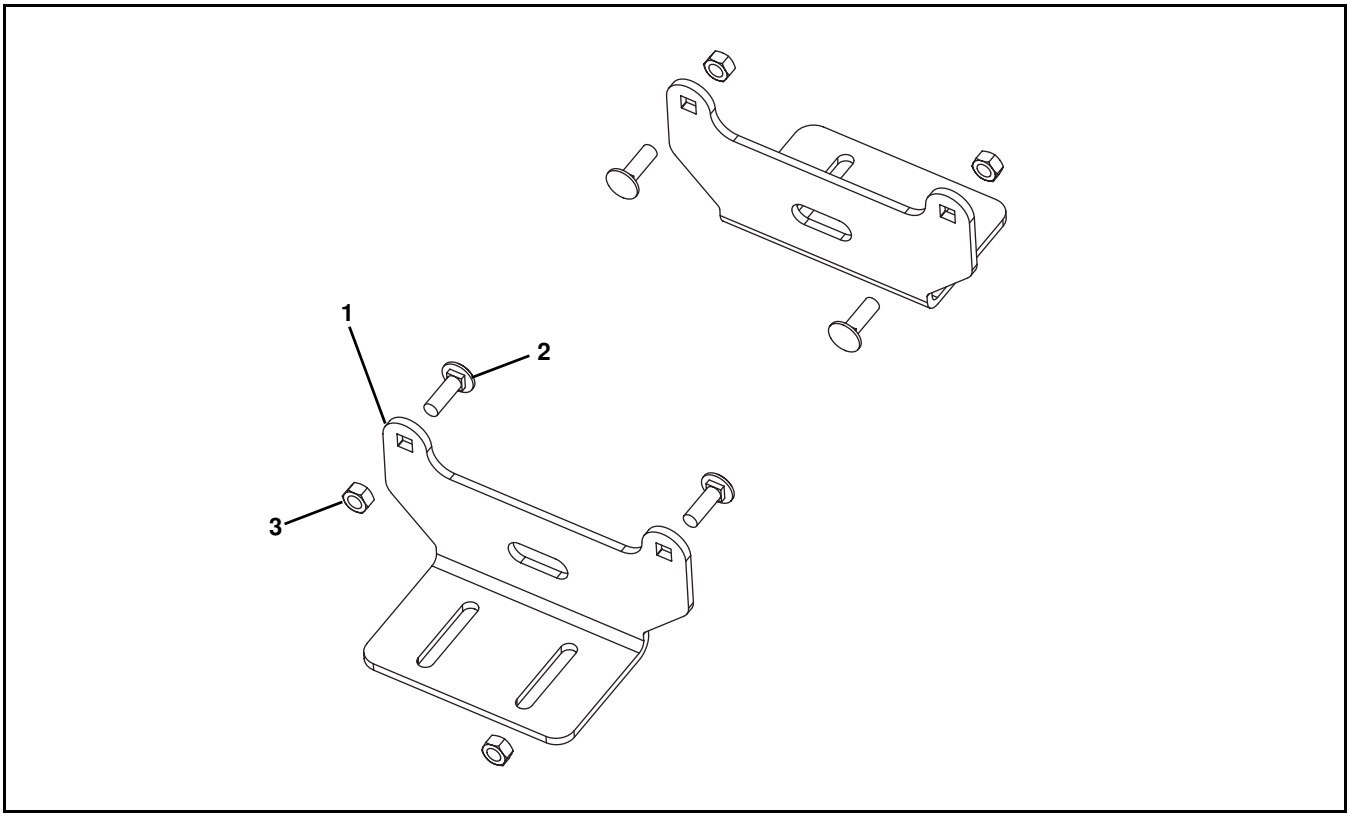
Tall Cleated Belt Return Support



Item	Part Number	Description
1	350426-LLLLL-M	Return Support for 75 mm Cleats
	350429-LLLLL-M	Return Support for 100 mm and 150 mm Cleats
2	350428	End Cap Guard, for 75 mm Cleats
	350427	End Cap Guard, for 100 mm and 150 mm Cleats
3	350633-LLLLL-M	Wear Strip
4	350635-1250	Spacer, for 75 mm and 150 mm Cleats
5	674175MP	Weld Nut
6	950650M	Low Head Cap Screw, M6-1.00 x 50 mm for 75 mm and 150 mm Cleats
	950616M	Low Head Cap Screw, M6-1.00 x 16 mm, for 100 mm Cleats

Item	Part Number	Description
7	913-997	Roll Pin
8	351475-WWWW-M-A	Cross Support for 75 mm Cleats
	351475-WWWW-M-B	Cross Support for 100 mm Cleats
	351475-WWWW-M-C	Cross Support for 150 mm Cleats
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
WWWW = Conveyor width reference in mm 0254 - 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		

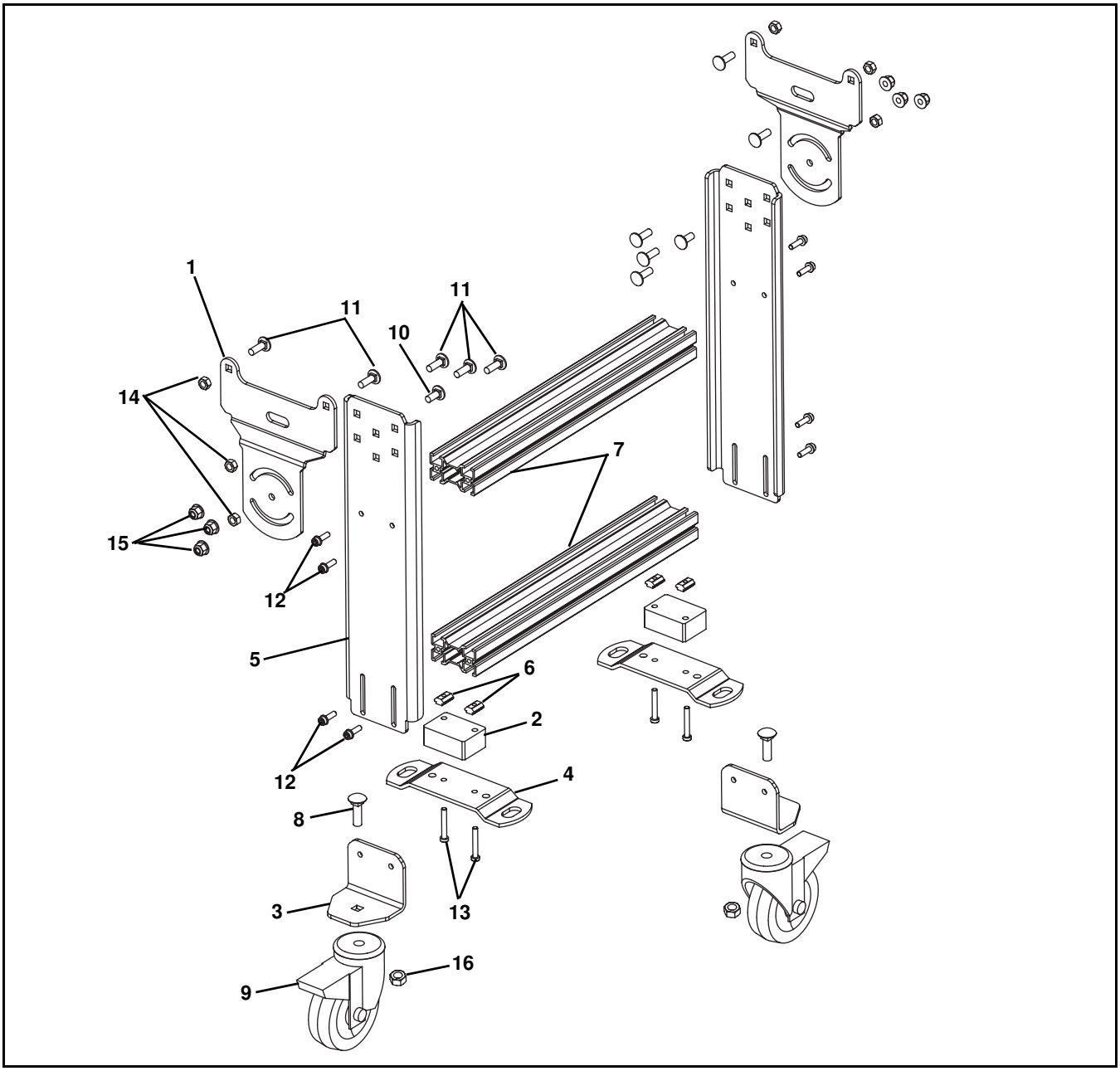
Table Top Mounting Brackets



Item	Part Number	Description
1	351517	Bracket
2	900825MY	Carriage Blot, M8-1.25 x 25 mm
3	990801M	Hex Nut, M8-1.25
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

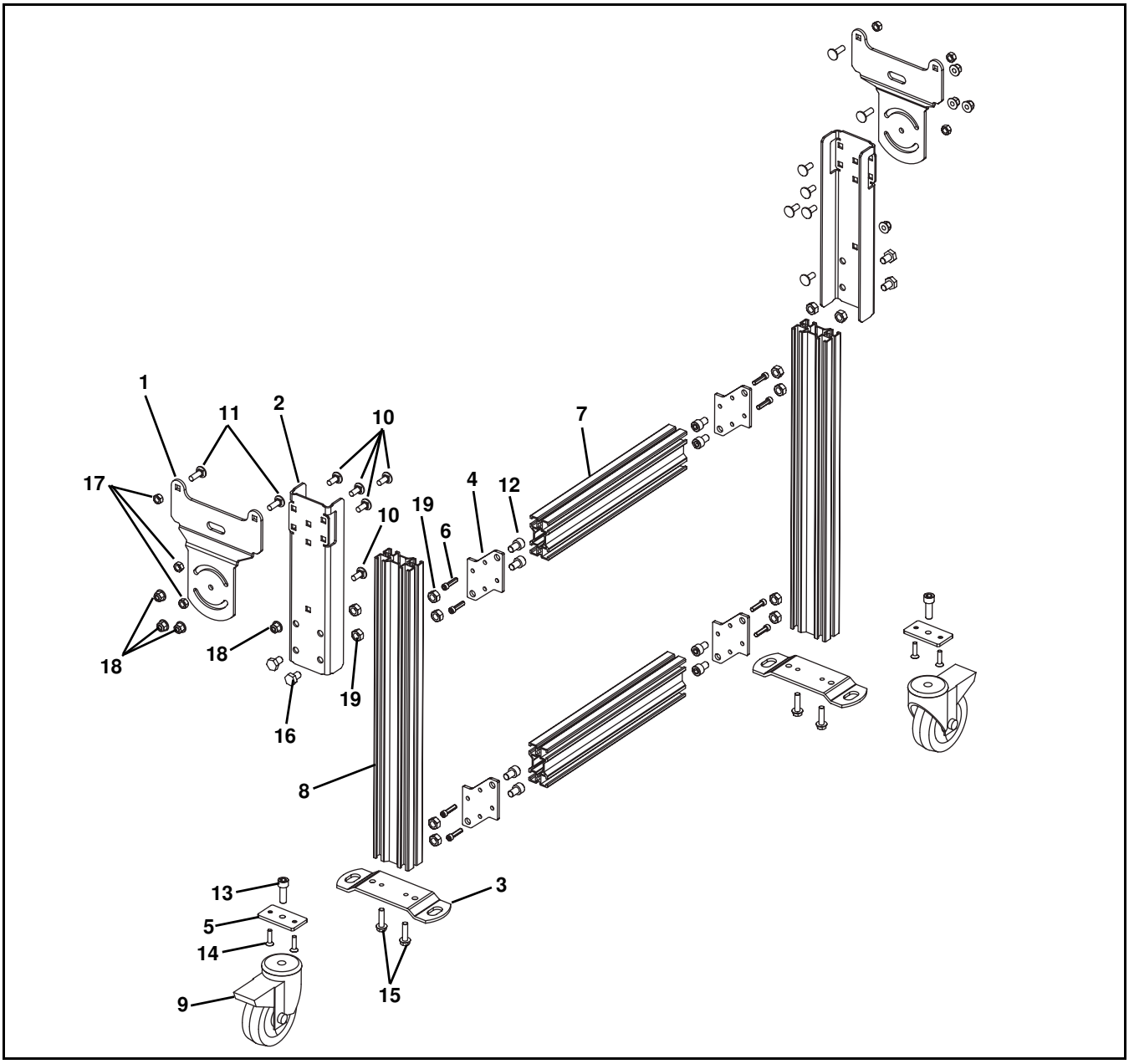
Short Support Stands



Item	Part Number	Description
1	351282	Mounting Bracket
2	351489	Spacer Block (for Stand Foot)
3	351490	Caster Bracket
4	710004	Stand Foot
5	351462-LLLLL-M	Stand Plate
6	639971M	Drop-In Tee Bar
7	710210-LLLLL-M	Crossmember
8	807-1286	Carriage Bolt, M10-1.50 x 35 mm
9	807-640	Caster
10	900820MY	Carriage Bolt, M8-1.25 x 20 mm
11	900825MY	Carriage Bolt, M8-1.25 x 25 mm

Item	Part Number	Description
12	920620MF	Flanged Socket Head Screw, M6-1.00 x 20 mm
13	950640M	Low Head Cap Screw, M6-1.00 x 40 mm
14	990801M	Hex Nut, M8-1.25
15	990812M	Lock Nut, M8-1.25
16	991011M	Hex Nut, M10-1.50
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
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		

Support Stands

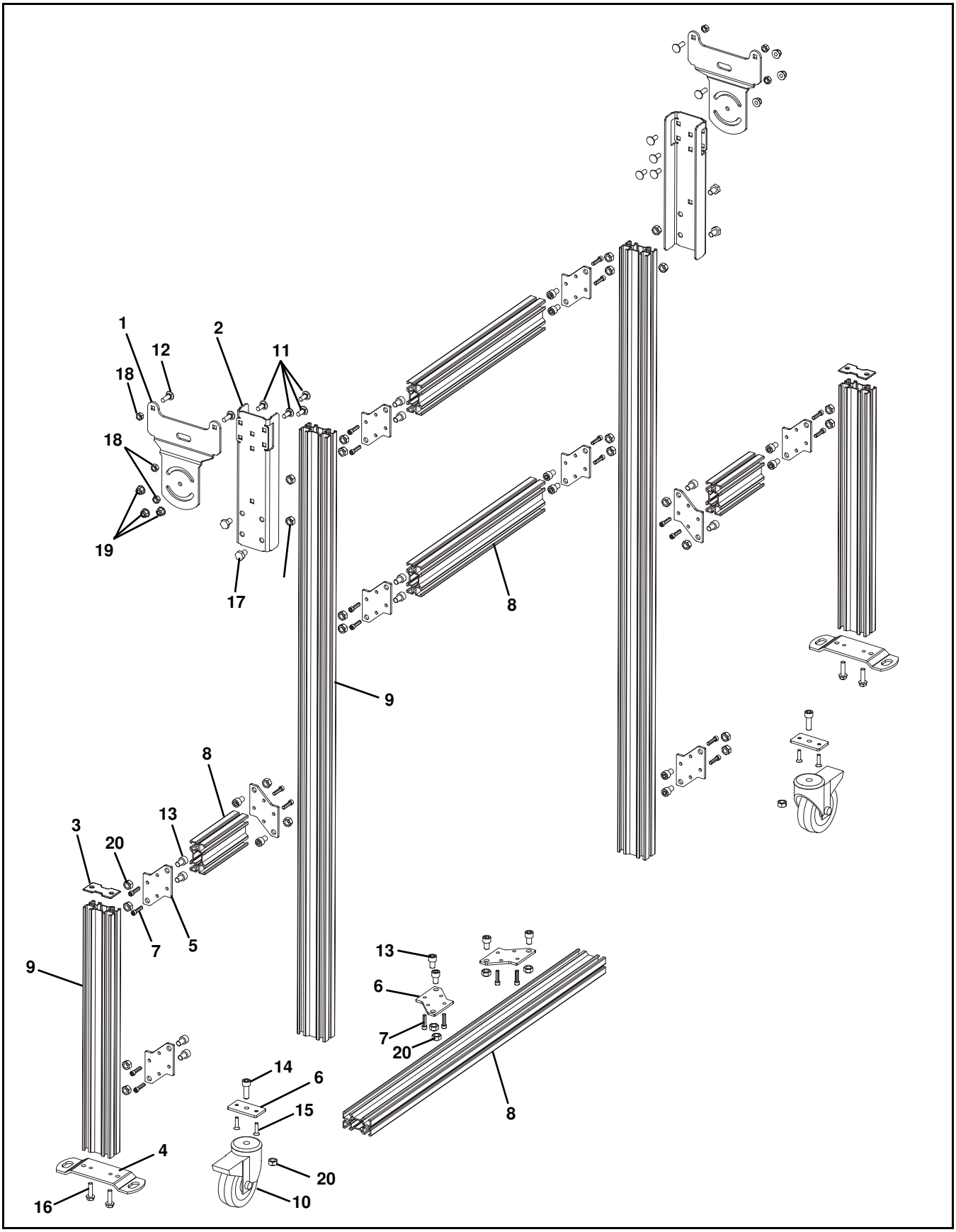


Item	Part Number	Description
1	351282	Mounting Bracket
2	351379	Channel Plate
3	710004	Stand Foot
4	710006	Crossmember Plate
5	710221	Caster Plate
6	708180P	Trilobe Screw, M6-1.00 x 25 mm
7	710210-LLLLL-M	Crossmember
8	710211-LLLLL-M	Stand Leg
9	807-640	Caster
10	900820MY	Carriage Bolt, M8-1.25 x 20 mm
11	900825MY	Carriage Bolt, M8-1.25 x 25 mm
12	921016M	Socket Head Screw, M10-1.50 x 16 mm
13	921030M	Socket Head Screw, M10-1.50 x 30 mm

Item	Part Number	Description
14	930625M	Flat Head Screw, M6-1.00 x 25 mm
15	960897M	Hex Head Cap Screw, M8-1.25 x 30 mm
16	961016M	Hex Head Cap Screw, M10-1.50 x 16 mm
17	990801M	Hex Nut, M8-1.25
18	990812M	Lock Nut, M8-1.25
19	991011M	Hex Nut, M10-1.50
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
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

Tall Support Stands



Item	Part Number	Description
1	351282	Mounting Bracket
2	351379	Channel Plate
3	710003	Tube Cover
4	710004	Stand Foot
5	710006	Crossmember Plate
6	710221	Caster Plate
7	708180P	Trilobe Screw, M6-1.00 x 25 mm
8	710210-LLLLL-M	Crossmember
9	710211-LLLLL-M	Stand Leg
10	807-640	Caster
11	900820MY	Carriage Bolt, M8-1.25 x 20 mm
12	900825MY	Carriage Bolt, M8-1.25 x 25 mm
13	921016M	Socket Head Screw, M10-1.50 x 16 mm
14	921030M	Socket Head Screw, M10-1.50 x 30 mm
15	930625M	Flat Head Screw, M6-1.00 x 25 mm
16	960897M	Hex Head Cap Screw, M8-1.25 x 30 mm
17	961016M	Hex Head Cap Screw, M10-1.50 x 16 mm
18	990801M	Hex Nut, M8-1.25
19	990812M	Lock Nut, M8-1.25
20	991011M	Hex Nut, M10-1.50
LLLLL = Part length in mm		
Example: Part length +1000 mm LLLLL = 01000		
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

Conveyor Belt Part Number Configuration

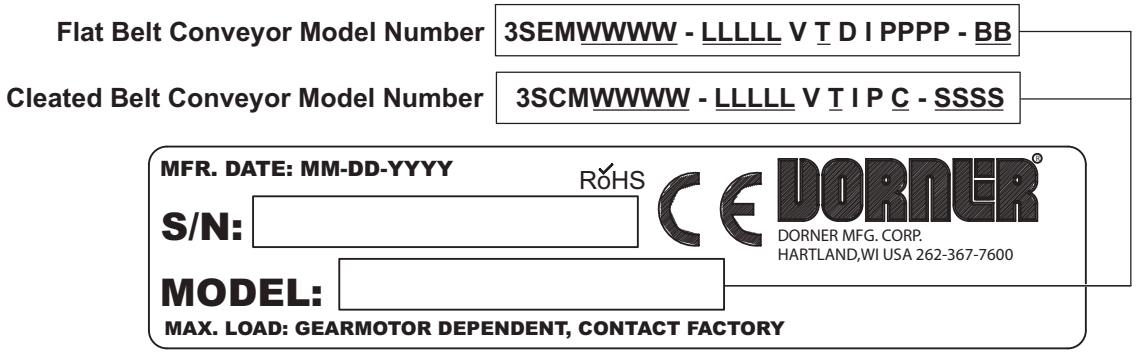


Figure 214

Flat Belt Part Number Configuration

Refer to Dorner patent plate **(Figure 214)**. From the model number, determine tail type ("T"), width ("WWWW"), length ("LLLLL") and belt type ("BB"). Use data to configure belt part number as indicated below. *Add "V" for V-guided belts.

3TM - WWWW LLLLL / BB V *

(Fill In)
3_ M– _____ _____ / __ V*

Cleated Belt Part Number Configuration

Refer to Dorner patent plate **(Figure 214)**. From the model number determine, width ("WWWW"), length ("LLLLL"), cleat type ("C"), and cleat spacing ("SSSS"). Use data to configure belt part number as indicated below. *Add "V" for V-guided belt.

3TM - WWWW LLLLL B SSSS V *

(Fill In)
3_ M– _____ _____ _ _____ V*

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="9" 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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