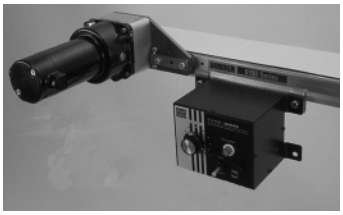
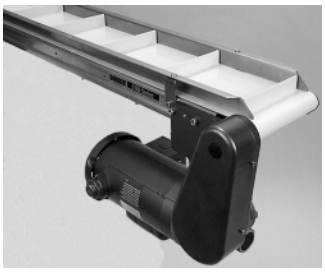
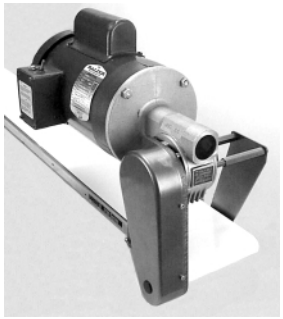
DORNER®

Installation, Maintenance & Parts Manual

6100 Series Industrial End Drive Conveyors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Warnings – General Safety

WARNING

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

DANGER

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

KEEP OFF CONVEYORS.

DANGER

DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

WARNING

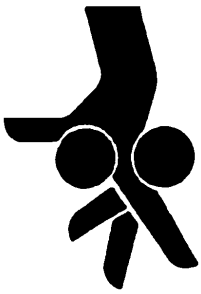
Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

WARNING

Gearmotors may be HOT.

DO NOT TOUCH Gearmotors.



WARNING

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

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

WARNING

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

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

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 6100 Series conveyors are covered by Patent Nos. 5174435, 6109427 and corresponding patents and patent applications in other countries.

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

Product Description

Refer to Figure 1 for typical conveyor components.

Typical Components	
A	Conveyor
B	Gearmotor Mounting Package
C	Gearmotor
D	Guiding & Accessories
E	Mounting Brackets with Return Rollers
F	Support Stands
G	Variable Speed Controller
H	Drive End
I	Idler/Tension End

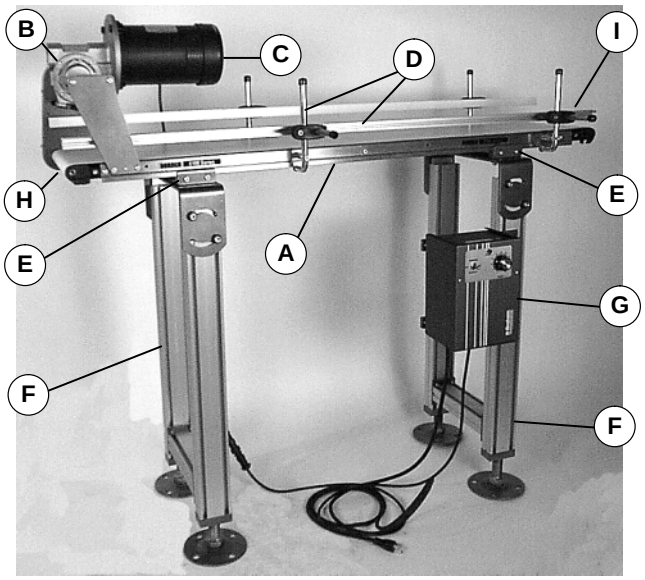


Figure 1

Specifications

Models:

Flat Belt 6100 Series Industrial Conveyor

6100 M WW LL A 01 / 02

- 02 — Belt Type*
- 01 — Conveyor Profile*
- A — Mount Position (–, A, or D)
- LL — Conveyor Length Reference
- WW — Conveyor Width Reference
- 6100 M — 1= Standard or G=Gang Drive

Cleated Belt 6100 Series Industrial Conveyor

6140 M WW LL A A XXXX

- XXXX — Cleat Spacing
- A — Mount Position (A or D)
- A — Cleat Type*
- LL — Conveyor Length Reference
- WW — Conveyor Width Reference
- 6140 M

*** See "Ordering and Specifications" Catalog for details.**

Conveyor Supports:

Maximum Distances:

J = 18¨ (457 mm)**

K= 6 ft (1829 mm)***

L= 18¨ (457 mm)

**** For Heavy Load Bottom Mount Package, mount support under gear head.**

***** For conveyors longer than 13 ft (3962 mm), install support at joint.**

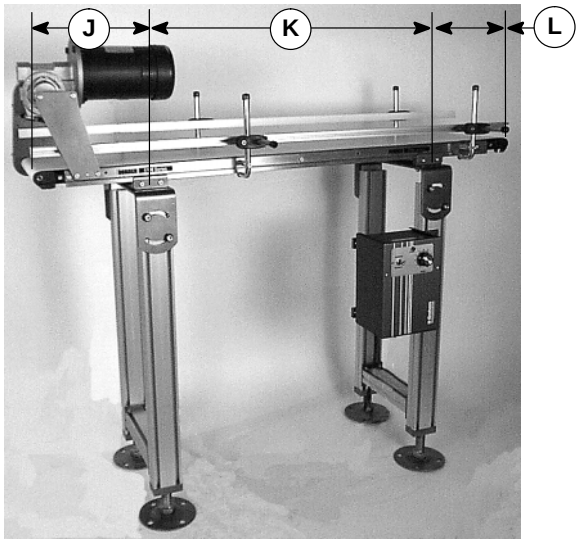


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18
Conveyor Belt Width	1.75¨ (44 mm)	2.75¨ (70 mm)	3.75¨ (95 mm)	5¨ (127 mm)	6¨ (152 mm)	8¨ (203 mm)	10¨ (254 mm)	12¨ (305 mm)	18¨ (457 mm)
Maximum Conveyor Load* (See NOTE Below)	30 lb (14 kg)	35 lb (16 kg)	42 lb (19 kg)	50 lb (23 kg)	60 lb (27 kg)	70 lb (32 kg)	80 lb (36 kg)	80 lb (36 kg)	80 lb (36 kg)
Conveyor Start-up Torque*	4 in-lb (0.5 Nm)	5 in-lb (0.6 Nm)	6 in-lb (0.7 Nm)	7 in-lb (0.8 Nm)	8 in-lb (0.9 Nm)	10 in-lb (1.1 Nm)	12 in-lb (1.4 Nm)	14 in-lb (1.5 Nm)	15 in-lb (1.7 Nm)
Belt Travel	3.5¨ (88 mm) per revolution of pulley								
Maximum Belt Speed*	235 feet/minute (72 meters/minute)								
Belt Take-up	0.38¨ (10 mm) of stroke = 0.75¨ (19 mm) of belt take-up								

Conveyor Length Reference (LL)	02	03	04	05	06	07	08	09	10	11	12	13**	14**	15**	16**	17**	18**
Conveyor Length	2-ft (610 mm)	3-ft (914 mm)	4-ft (1219 mm)	5-ft (1524 mm)	6-ft (1829 mm)	7-ft (2134 mm)	8-ft (2438 mm)	9-ft (2743 mm)	10-ft (3048 mm)	11-ft (3353 mm)	12-ft (3658 mm)	13-ft (3962 mm)**	14-ft (4267 mm)**	15-ft (4572 mm)**	16-ft (4877 mm)**	17-ft (5182 mm)**	18-ft (5486 mm)**

NOTE: Maximum conveyor loads based on:

- **Non-accumulating product**
- **Product moving towards gearmotor**
- **Conveyor being mounted horizontal**

*** See "Ordering and Specifications" Catalog for details.**

**** Lengths available only in 6¨ (152 mm) & wider conveyors.**

Installation

NOTE: Conveyor MUST be mounted straight, flat and level within confines of conveyor. Use a level (M of Figure 3) for set-up.

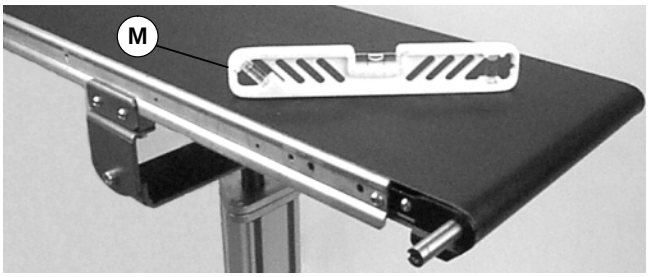


Figure 3

Illustration References

M	Level
N	Conveyor frame without belt
O	M6 x 10 mm Low Head Socket Head Screws (6x) (shipped loose)
P	Connector Strips (2x) (Attached to conveyor section)
Q	Conveyor frame with belt
R	M6 x 12 mm Socket Head Screws (4x)
S	M6 x 18 mm Socket Head Screw & Hard Washer Assemblies (4x)

Required Tools

Standard Tools

- Hex key wrenches
  - 4 mm
  - 5 mm
- Level
- Torque wrench

Recommended Installation Sequence (see Table of Contents for page number)

- Assemble conveyor (if required)
- Attach mounting bracket(s) with return roller to conveyor (see page 6)
- Install stands (see accessory instructions)
- Attach conveyor to stands
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see “Service Parts” section, pages 20 through 40)

Conveyors Up to 13 ft (3962 mm)

No additional assembly is required.

Conveyors Longer Than 13 ft (3962 mm)

1. Typical components (Figure 4)

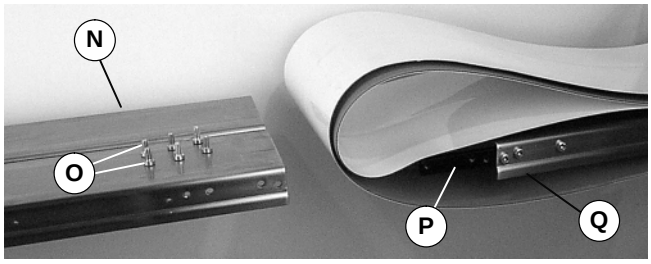


Figure 4

2. Compress tension end (Figure 5). Refer to steps 3, 4 & 5 under the “Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands” on page 9.

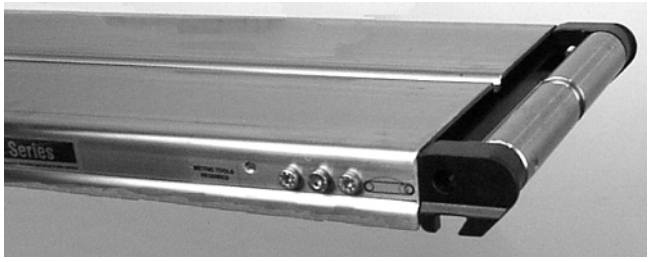


Figure 5

3. Roll out conveyor belt.

4. Place conveyor frame (N Figure 6) into belt loop.

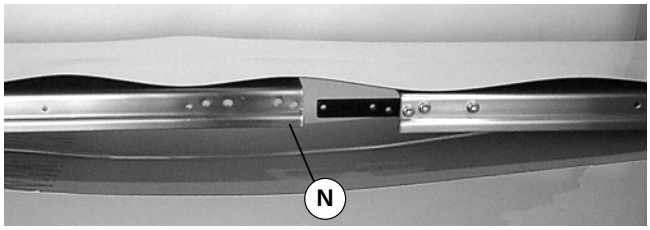


Figure 6

5. Join conveyor sections (N and Q of Figure 7). Install screws (O) on both sides. Tighten to 60 in-lb (7 Nm).

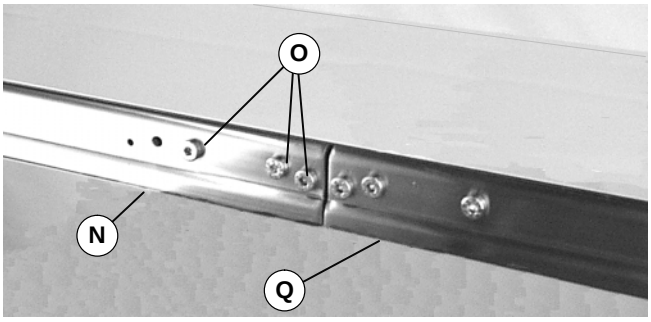


Figure 7

6. Tension conveyor belt. Refer to “Conveyor Belt Tensioning” on page 12.

Mounting Brackets with Return Rollers

Cleated Belt Conveyors

1. Typical components (Figure 8)

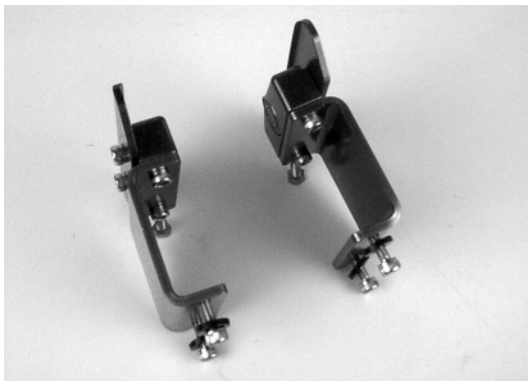


Figure 8

2. Loosen screws (R of Figure 9) and remove screws and washers (S).

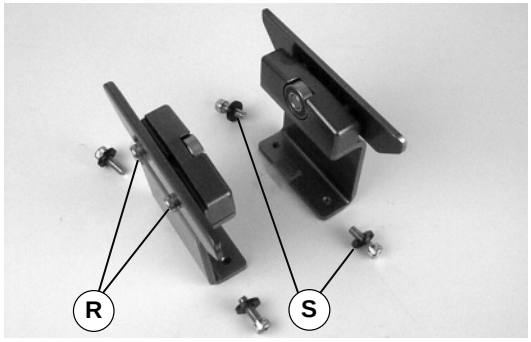


Figure 9

3. Attach clamp plates on each side of conveyor (Figure 10). Tighten the screws (R) to 80 in-lb (9 Nm).

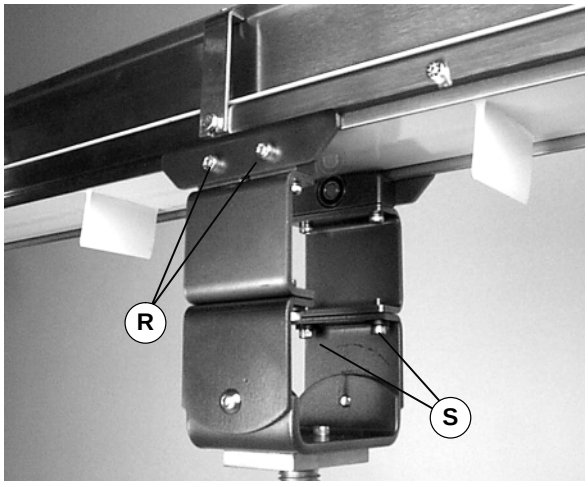


Figure 10

4. Attach to support stand. Tighten screws (S) to 80 in-lb (9 Nm). Make sure belt is free to move.

2¨ to 6¨ (44 mm to 152 mm) Wide Flat Belt Conveyors

1. Typical components (Figure 11)

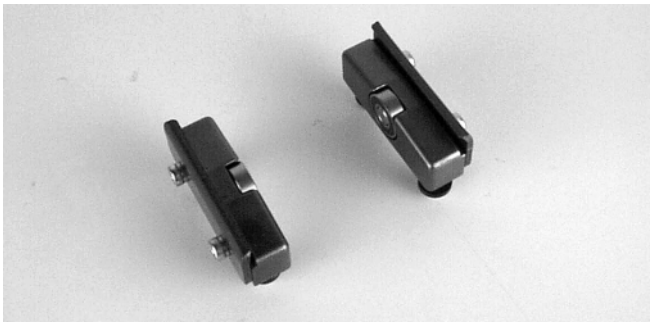


Figure 11

2. Loosen screws (R of Figure 12) and remove screws and washers (S).

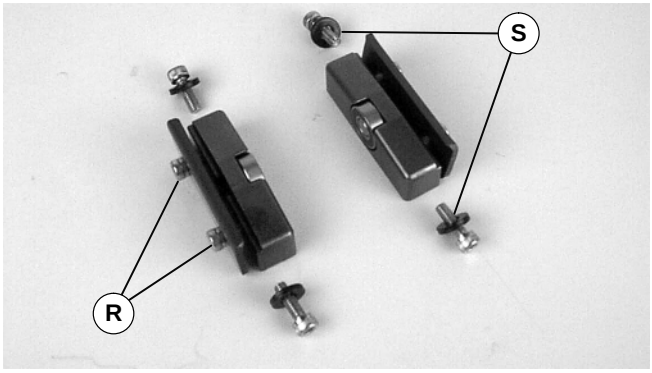


Figure 12

3. Attach clamp plates on each side of conveyor (Figure 13). Tighten the screws (R) to 80 in-lb (9 Nm).

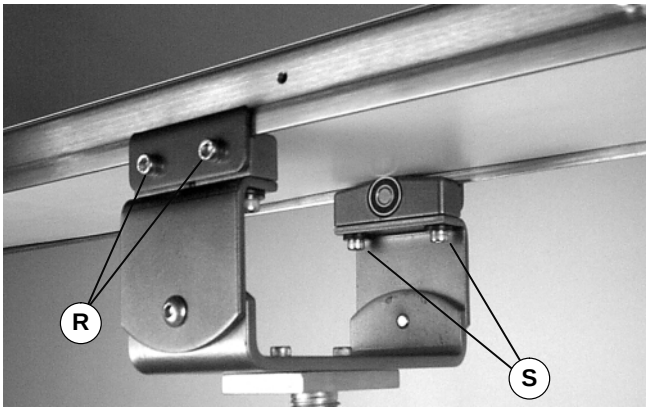


Figure 13

4. Attach to support stand. Tighten screws (S) to 80 in-lb (9 Nm). Make sure belt is free to move.

8¨ (203 mm) & Wider Flat Belt Conveyors

1. Typical components (Figure 14)

Figure 14

2. Loosen screws (R of Figure 15) and remove screws and washers (S).

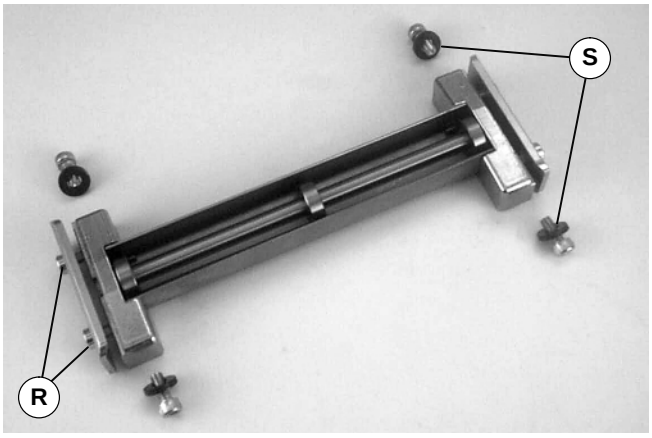


Figure 15

3. Attach clamp plates on each side of conveyor (Figure 16). Tighten the screws (R) to 80 in-lb (9 Nm).

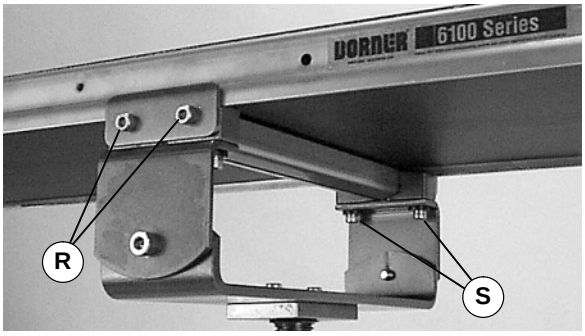


Figure 16

4. Attach to support stand. Tighten screws (S) to 80 in-lb (9 Nm). Make sure belt is free to move.

Preventative Maintenance & Adjustment

Required Tools

Standard Tools

- Hex key wrenches

– 2 mm	– 2.5 mm	– 3 mm
– 4 mm	– 5 mm	– 6 mm

- Manual grease gun
- Adjustable wrench
- Arbor press

Special Tools

- 807-1043 Narrow-headed 11/16¨ Wrench (supplied with conveyor)
- 450281 Sealed Bearing Removal Tool
- 450282 Sealed Bearing Installation Tool
- 2500M Tool Kit for Gang Drive Bearings

Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner (part # 625619)
- For optional gang-driven conveyors, keep supply of bearing grease [for 14 oz (397 gram) cartridge (part # 829-002)or for 14 oz (397 gram) can(part # 829-003)]
- Clean entire conveyor and knurled pulley while disassembled
- Replace worn or damaged parts

Lubrication

Conveyor with Standard 0.47¨ (12 mm) Diameter Output Shaft

No lubrication is required. Replace bearings if worn.

Conveyor with Optional Gang Drive Pulley

WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

- Only drive pulley bearings require lubrication. See steps that follow. All other bearings, replace if worn.

1. Disassemble the support (T of Figure 17) and remove the hex shaft and shaft guard sections (U).

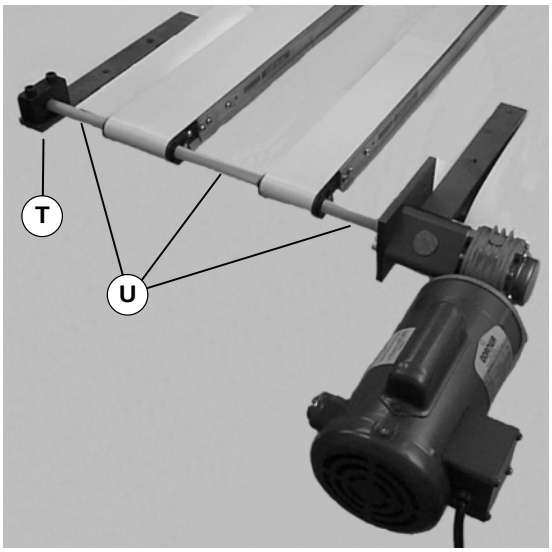


Figure 17

NOTE: Optional permanent grease fittings (part # 200398M) may be installed.

2. Install Dorner greasing adapter (part # 200046M) (V of Figure 18). Make sure the adapter shoulder is seated against the conveyor tail plate.

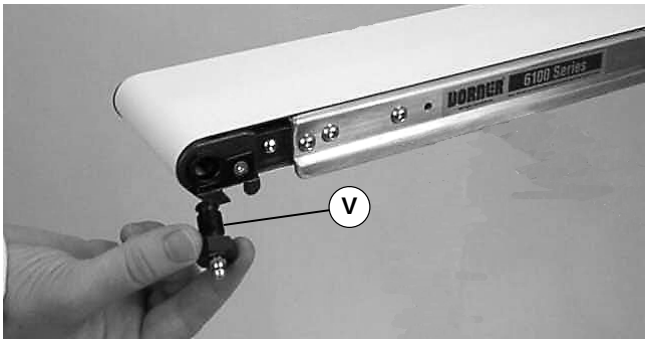


Figure 18

3. Use Dorner red grease, 14 oz (397 gram) cartridge (part #829-002) or 14 oz (397 gram) can (part # 829-003). Lubricate pulley bearing every 750 hours or more frequently, depending on operating conditions.

NOTE: Lubricate pulley bearing every 750 hours or more frequently, depending on operating conditions. When lubricating pulley bearings, use a conventional hand grease gun with a maximum of one pump per application. *Do not over-lubricate.* Do not use a power grease gun.

4. Grease bearing with one (1) pump from a manual grease gun. Do not over-lubricate.
5. Remove grease adapter and install on opposite side of pulley. Repeat steps 2 and 4.
6. Re-assemble hex shaft with guards and support (T of Figure 17).

Mounting Brackets with Return Rollers

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 wiper(s)
- Accumulated dirt in wiper(s)
- 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

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

Cleaning

IMPORTANT: Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.

Use Dorner Belt Cleaner (part # 625619). Mild soap and water may also be used. 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 (see Table of Contents for page number)

- Remove old conveyor belt
  - Conveyor without Gearmotor Mounting Package or Stands
  - Conveyor with Stands and/or Gearmotor Mounting Package
  - Conveyor with Optional Gang Drive Pulley
- Install new conveyor belt
- Tension conveyor belt

Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands

1. For a flat belt conveyor, remove and retain the bottom wiper(s) (W of Figure 19).

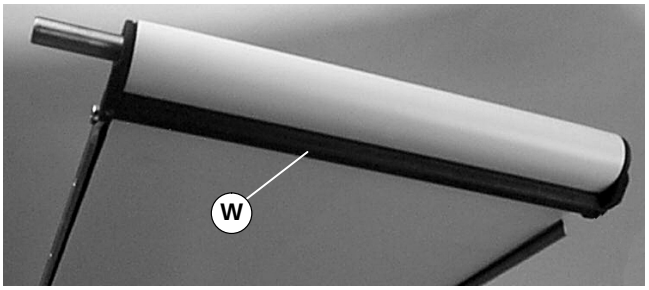


Figure 19

2. If conveyor is equipped with guiding and accessories, remove them from one side.

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

3. On tension end of the conveyor identified with a  label (X Figures 20 & 21), insert a 5 mm hex key wrench to engage pinion gear (Yof Figure 20).

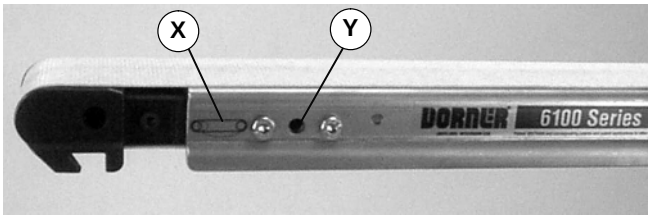


Figure 20

4. With pinion gear engaged, insert a 4 mm hex key wrench into lock screw (Z of Figure 21).

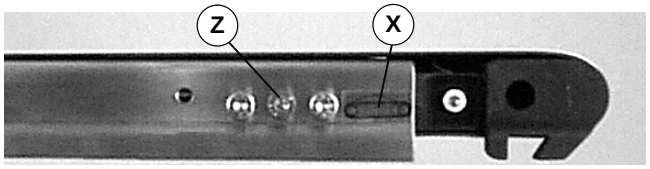


Figure 21

5. While maintaining tension on pinion gear (Y of Figure 22) loosen lock screw (Z). Rotate pinion gear (Y) clockwise to release conveyor belt tension.

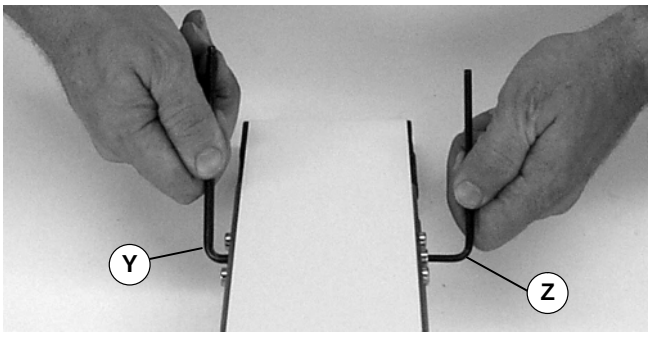


Figure 22

6. Remove conveyor belt.

Belt Removal for Conveyor With Stands and/or Gearmotor Mounting Package

NOTE: For conveyor with a Heavy Load Bottom or Top Mount Package, bracket (AB of Figure 23) must be removed.

- **Remove two (2) M6 x 16 mm socket head screws (AA).**
- **Remove two (2) M6 x 12 mm socket head screws (AC).**
- **Remove bracket (AB).**

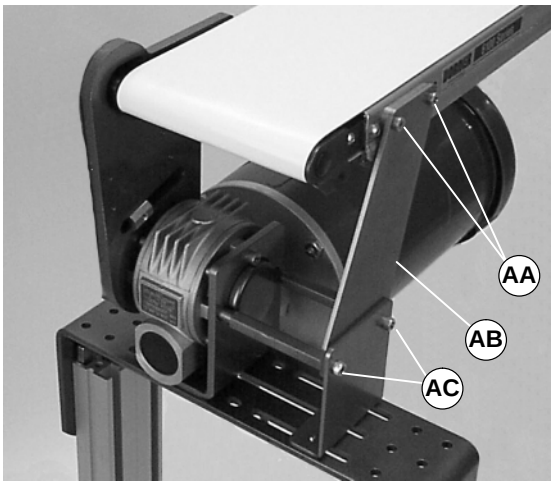


Figure 23

1. For a flat belt conveyor, remove and retain the bottom wiper(s) (W of Figure 19).

2. If conveyor is equipped with guiding and accessories, remove them from one side.

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

3. On tension end of the conveyor identified with a label (X Figures 20 & 21), insert a 5 mm hex key wrench to engage pinion gear (Yof Figure 20).

4. With pinion gear engaged, insert a 4 mm hex key wrench into lock screw (Z of Figure 21).

5. While maintaining tension on pinion gear (Y of Figure 22) loosen lock screw (Z). Rotate pinion gear (Y) clockwise to release conveyor belt tension.

WARNING

The weight of the gearmotor is all on one end of the conveyor which could cause it to tip off the stands when the mounting clamp plates are loosened. Be sure to provide support (AD of Figure 24) underneath the gearmotor while changing the belt.

6. Temporarily support conveyor at gearmotor mounting package (AD of Figure 24).

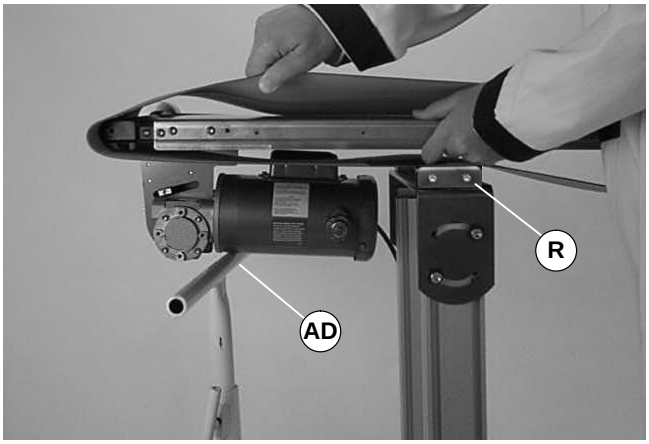


Figure 24

NOTE: To remove belt, complete steps 7 & 8, at each stand location.

WARNING

To prevent injury from the support stand tipping-over when conveyor is uncoupled, anchor stand to floor or otherwise stabilize the stand.

7. Loosen the mounting clamp plates (R of Figures 24 and 25), on both sides of the conveyor. Raise the conveyor and remove the belt.

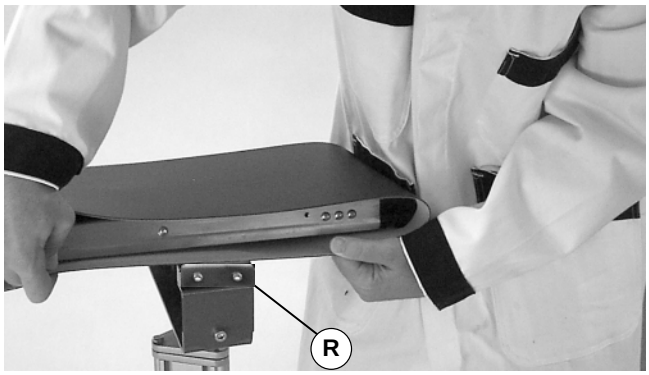


Figure 25

8. With belt removed, secure conveyor with clamp plates (R).

Belt Removal for Conveyor With Optional Gang Drive Pulley

1. Disassemble support (T of Figure 17) and remove the hex shaft and shaft guard sections (U).
2. Remove and retain the bottom wiper(s) (W of Figure 19).
3. If conveyor is equipped with guiding and accessories, remove them from one side.

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

4. On tension end of the conveyor identified with a label (X Figures 20 & 21), insert a 5 mm hex key wrench to engage pinion gear (Yof Figure 20).
5. With pinion gear engaged, insert a 4 mm hex key wrench into lock screw (Z of Figure 21).
6. While maintaining tension on pinion gear (Y of Figure 22) loosen lock screw (Z). Rotate pinion gear (Y) clockwise to release conveyor belt tension.
7. Remove conveyor belt.

Belt Installation for Conveyor without Gearmotor Mounting Package or Stands

IMPORTANT: On a flat belt conveyor, the wiper is installed on discharge end. Belt travel direction is identified by an arrow decal on the side of the conveyor (AE of Figure 26). With a reversing gearmotor, a second bottom wiper must be installed on opposite end.

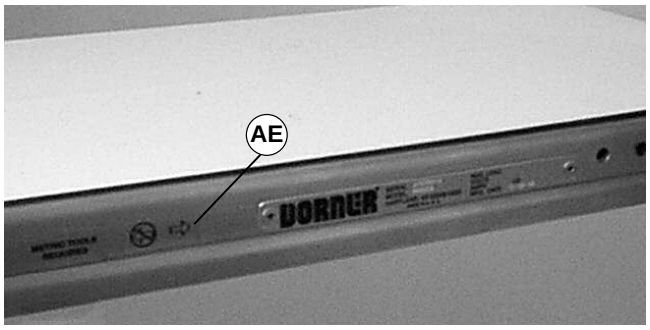


Figure 26

1. Orient the conveyor belt so that the splice leading fingers (AF of Figure 27) point in the direction of belt travel (AG) as identified by the label (AE of Figure 26).

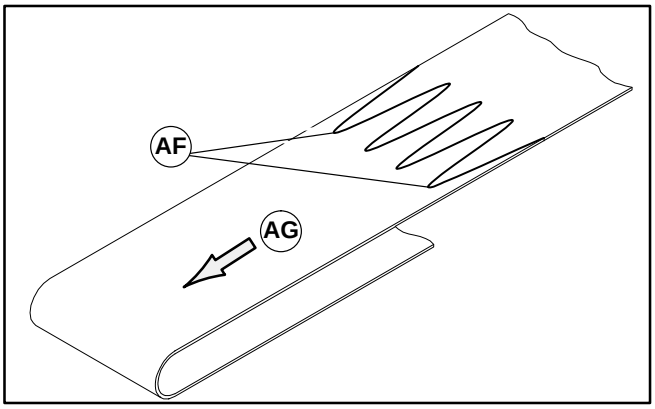


Figure 27

2. Slide belt onto the conveyor frame assembly.
3. On a flat belt conveyor, install bottom wiper(s) (W of Figure 19). Center set screws in frame and tighten to 33 in-lb (3.7 Nm).
4. Tension belt. Refer to “Conveyor Belt Tensioning” on page 12.
5. Where applicable, replace guiding.

Belt Installation for Conveyor with Gearmotor Mounting Package and/or Stands

1. Orient the conveyor belt so that the splice leading fingers (AF of Figure 27) point in the direction of belt travel (AG) as identified by the label (AE of Figure 26).

NOTE: To install belt, complete steps 2, 3 & 4, at each stand location.

2. Loosen the mounting clamp plates (R of Figures 24 and 25), on both sides of the conveyor. Raise the conveyor and replace the belt.
3. Lower the conveyor onto the mounting blocks being careful not to pinch belt.
4. Tighten clamp plates screws (R) to 80 in-lb (9 Nm).
5. On a flat belt conveyor, install bottom wiper(s) (W of Figure 19). Center set screws in frame and tighten to 33 in-lb (3.7 Nm).
6. For a conveyor with a Heavy Load Bottom or Top Mounting package, re-install bracket(AB of Figure 23).
7. Tension belt. Refer to "Conveyor Belt Tensioning" on page 12.
8. Where applicable, replace guiding.

Belt Installation for Conveyor With Optional Gang Drive Pulley

1. Orient the conveyor belt so that the splice leading fingers (AF of Figure 27) point in the direction of belt travel (AG) as identified by the label (AE of Figure 26).
2. Slide belt onto the conveyor frame assembly.
3. On a flat belt conveyor, install bottom wiper(s) (W of Figure 19). Center set screws in frame and tighten to 33 in-lb (3.7 Nm).
4. Tension belt. Refer to "Conveyor Belt Tensioning" on page 12.
5. Where applicable, replace guiding.
6. Re-assemble hex shaft with guards sections (U of Figure 17). Re-assemble support (T).

Conveyor Belt Tensioning

WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

1. On tension end of the conveyor identified with a  label (X Figures 20 & 21), insert a 5 mm hex key wrench to engage pinion gear (Yof Figure 20).
2. With pinion gear engaged, insert a 4 mm hex key wrench into lock screw (Z of Figure 22).

NOTE: On pinion gear (Yof Figure 20), do not exceed a torque of 25 in-lb (2.8 Nm) for 2¨ to 12¨ (44 mm to 305 mm) wide conveyors and 40 in-lb (4.5 Nm) for an 18¨ (457 mm) wide conveyor . Over-tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. Loosen lock screw (Z of Figure 22).

4a. For existing belt:
With V-guide seated in pulley, rotate the pinion gear (Y) counter-clockwise to sufficiently tension the belt to handle the conveyor load.

NOTE: If the maximum take-up stroke is achieved, replace the conveyor belt.

4b. For a new belt:
With V-guide seated in pulley, rotate the pinion gear (Y) counter-clockwise to a distance of 1¨ (25 mm) (AH of Figure 28).

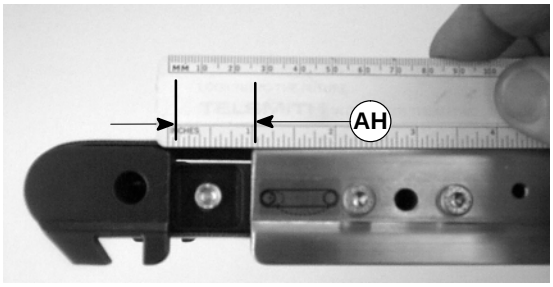


Figure 28

5. Secure lock screw (Z of Figure 22) to 40 in-lb (4.5 Nm).

Pulley Removal

WARNING

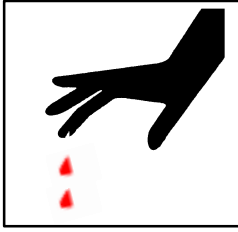
Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Remove conveyor belt to access pulley(s). See "Conveyor Belt Replacement" on page 9. Remove the desired pulley following instructions:

- A – Drive Pulley with Standard 0.47¨ (12 mm) Diameter Output Shaft
- B – Idler Pulley
- C – Idler Pulley with Tool-less Belt Release
- D – Gang Drive Pulley

A – Removal of Drive Pulley with Standard 0.47¨ (12 mm) Diameter Output Shaft



WARNING

Drive shaft keyway may be sharp.

HANDLE WITH CARE.

1. Remove the gearmotor mounting package. See accessory instructions.
2. For 10¨ (254 mm), 12¨ (305 mm) or 18¨ (457 mm) wide conveyors, use the narrow-headed 11/16¨ wrench (part # 807-1043) (AJ of Figure 29) to remove the outboard bearing (AK).
3. Remove screw (AI).

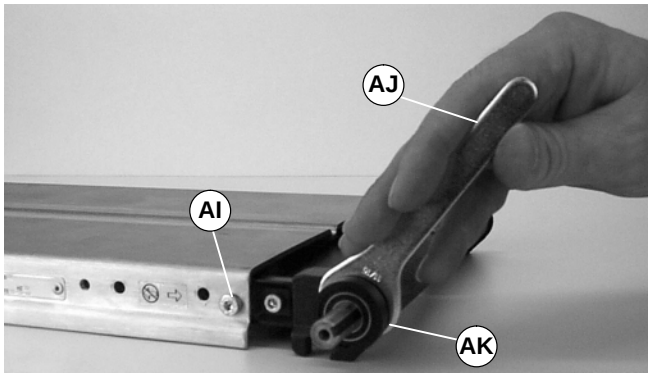


Figure 29

NOTE: With a Heavy Load Mount Package, two (2) screws (AA of Figure 23) were removed in step 1.

4. Remove three (3) screws (AL of Figure 30) on the side opposite the drive shaft.

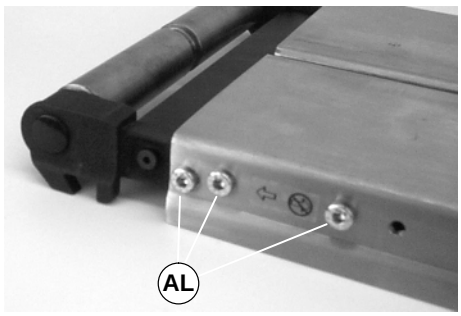


Figure 30

5. Remove the drive tail assembly.
6. Remove screw (AM of Figure 31).
7. Remove headplate (AN).
8. Remove pulley (AO).

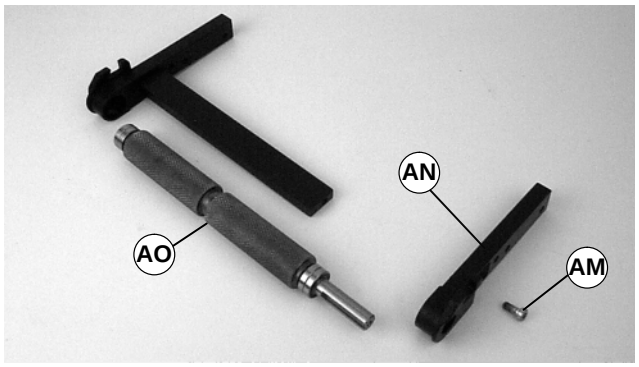


Figure 31

B – Idler Pulley Removal

1. Remove screw (Z of Figure 32).
2. Remove four (4) tail plate mounting screws (AP of Figures 32 & 33).

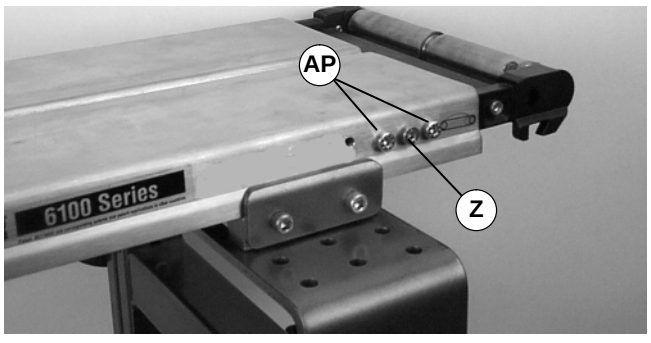


Figure 32

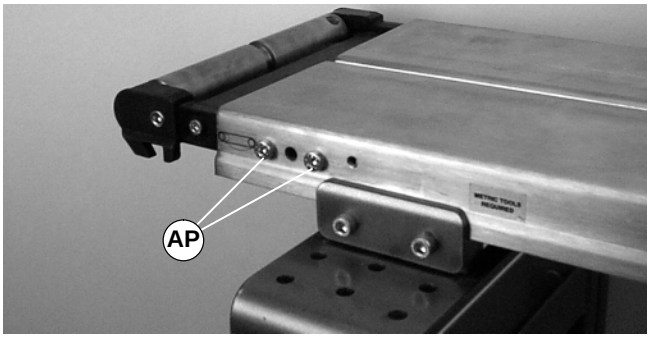


Figure 33

3. Remove tail assembly (AQ of Figure 34).

Figure 34

4. Locate magnet (AR of Figure 35). Remove screw (AM).

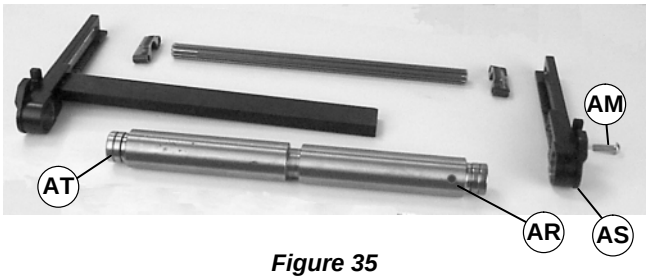


Figure 35

5. Remove headplate (AS).

6. Remove pulley (AT).

C – Removal of Idler Pulley with Tool-less Belt Release

1. Remove handle(AU of Figure 36).

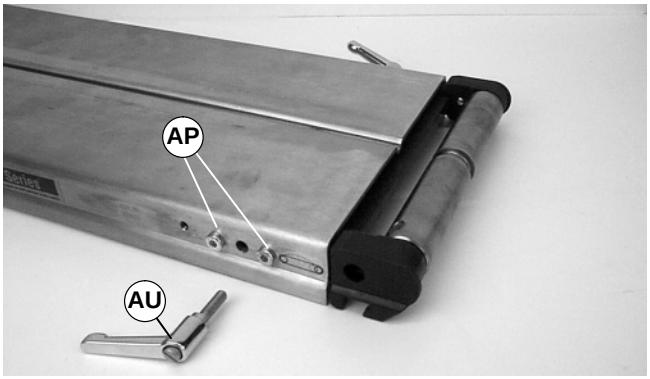


Figure 36

2. Remove two (2) screws (AP of Figure 36).

3. Remove two (2) screws (AP of Figure 37). Remove handle assembly (AV).

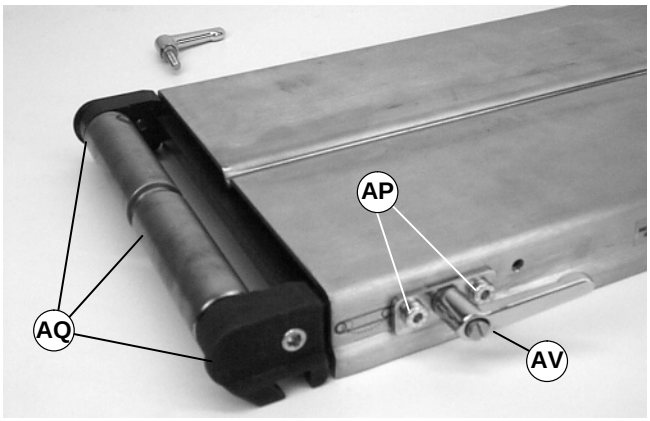


Figure 37

4. Remove tail assembly (AQ).

5. Locate magnet (AR of Figure 35). Remove screw (AM).

6. Remove headplate (AS).

7. Remove pulley (AT).

D – Gang Drive Pulley Removal

1. Remove the two (2) screws (AW of Figure 38).

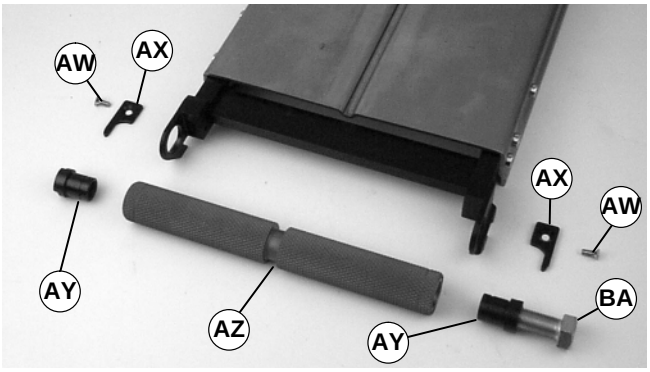


Figure 38

2. Remove two clips (AX).

3. Install bolt (part # 906-278☆) (BA of Figure 38) into bearing sleeve(s) (AY). Remove bearing sleeve(s) (AY).

NOTE: If retaining sleeve (AY of Figure 38) does not slide out:

- **Remove tail following steps 3, 4 & 5 of Removal of Drive Pulley with Standard 0.47¨ (12 mm) Diameter Output Shaft on page 13**
- **Assemble pulley (AZ of Figure 39), removal tool (part # 25-09☆) (BB), and bolt (part # 906-278☆) (BA), as shown**
- **Tighten bolt (BA) to remove bearing sleeve (AY)**

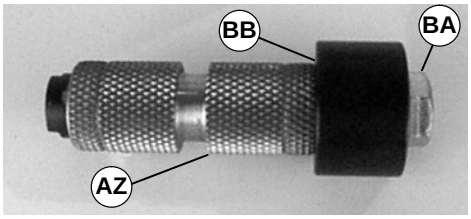


Figure 39

Bearing Replacement for Drive Pulley with Standard 0.47¨ (12 mm) Diameter Output Shaft or Idler Pulley

IMPORTANT: Once removed, do not re-use bearings.

Bearing Removal

1. Place bearing removal tool (part # 450281) over bearing(s) with lip (BD of Figure 40) located in Bearing gap (BE) as shown.

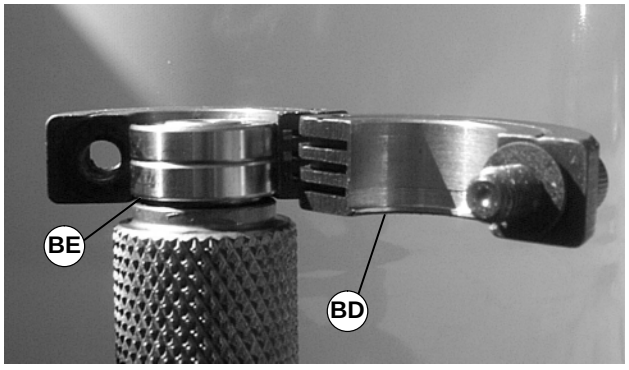


Figure 40

2. Using 3/16¨ hex key wrench (BC of Figure 41), tighten tool.

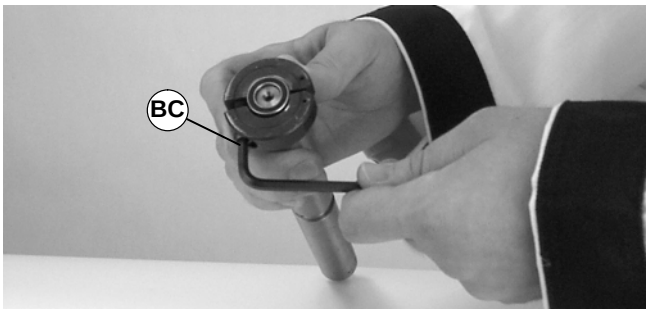


Figure 41

3. Using a puller (BF of Figure 42), remove and discard bearing(s).

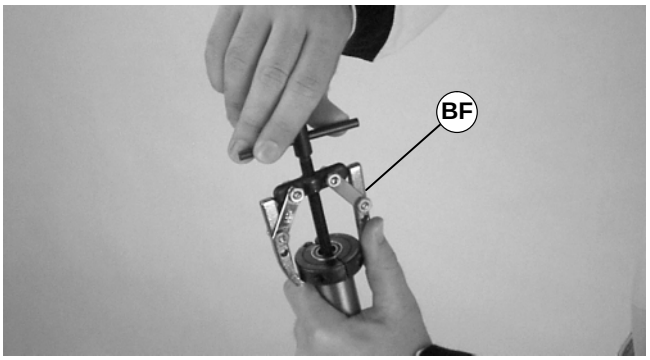


Figure 42

Bearing Installation

IMPORTANT: Install bearings one at a time.

1. Inspect seating surface(s) for damage. Replace if damaged.

2. Slide bearing (part # 802-121) (BG of Figure 43) onto pulley shaft.

Figure 43

☆ - Part of Tool Kit, part # 2500M.

3. Slide the sleeve of tool (part # 450282) (BH of Figure 44) over bearing.

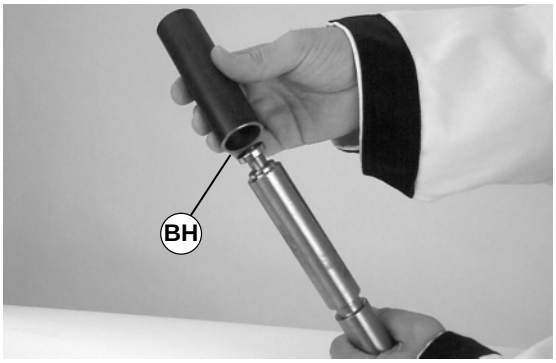


Figure 44

4. Place open end of shaft (BI of Figure 45) into sleeve.

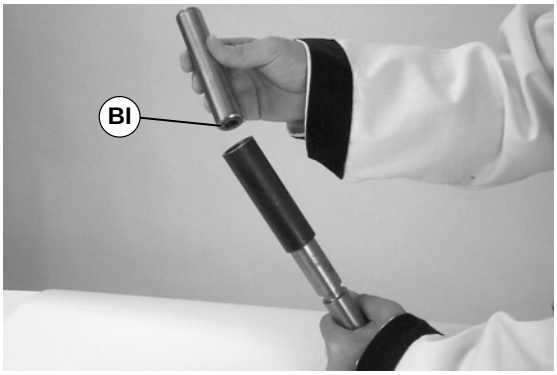


Figure 45

5. Using arbor press or similar device, press bearing onto pulley shaft (see Figure 46).

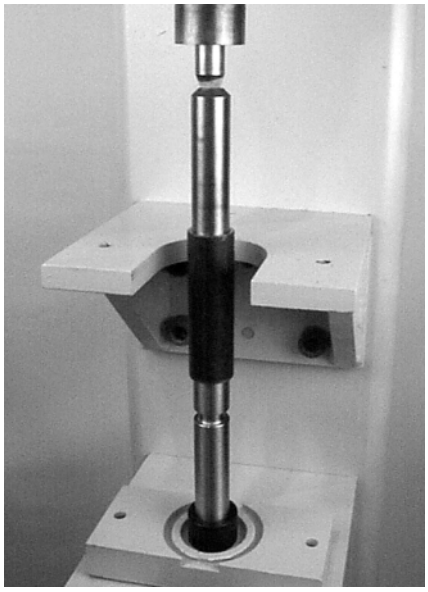


Figure 46

6. Repeat steps 1 through 5 for each bearing.

Bearing Replacement for Gang Drive Pulley

IMPORTANT: Once removed, do not re-use bearings.

Bearing Removal

NOTE: The bearings of a 2" (44 mm) wide gang drive pulley cannot be replaced. Order pulley assembly (part # 454702).

1. Insert bearing removal tool (part # 25-05☆) (BK of Figure 47) into the pulley (BN) until shoulder (BJ) seats against bottom of bearing (BO).

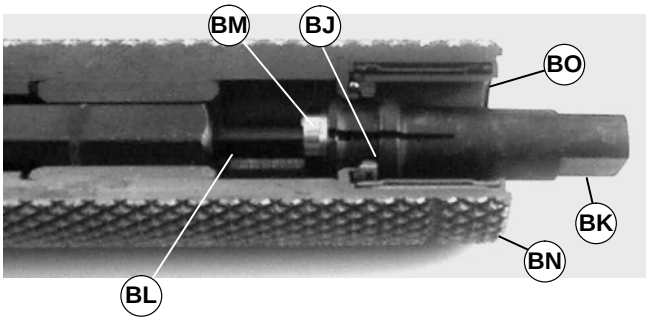


Figure 47

2. While holding bearing removal tool (BK) in position, insert extension tool (part # 25-08☆) (BL) into opposite end of pulley (BN). Rotate bearing removal tool (BK) to engage hex tip of extension tool (BL) into screw (BM).

3. While maintaining extension tool (BL) position, use a wrench to rotate bearing removal tool (BK) to expand flare.

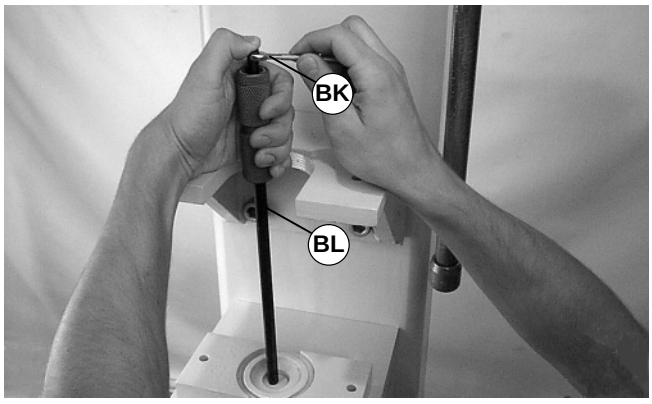


Figure 48

4. Orient bearing anvil/sleeve removal tool (part # 25-09☆) (BP of Figure 49) with cavity facing up and place pulley onto tool.

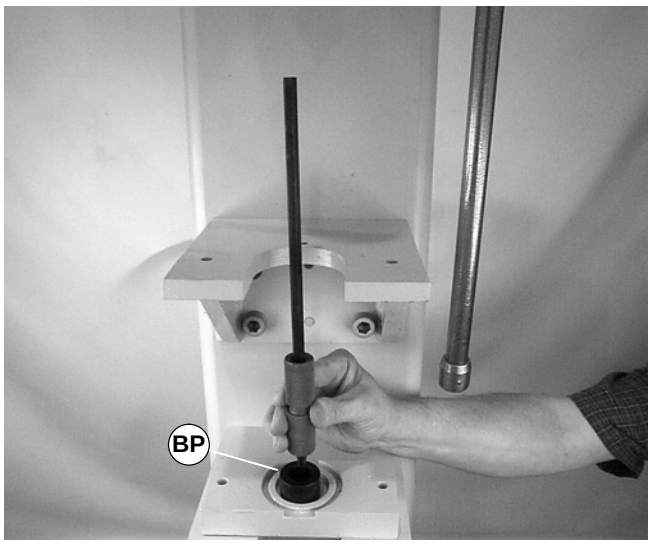


Figure 49

NOTE: If a severely worn bearing breaks apart during removal, pulley must be replaced.

5. Press bearing out of pulley.

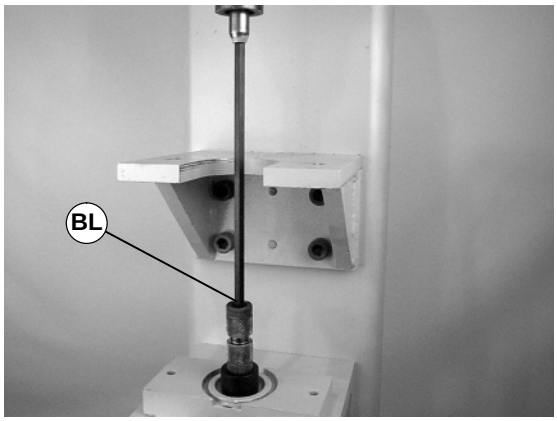


Figure 50

Bearing Installation

1. Orient bearing anvil/sleeve removal tool (part # 25-09☆) (BP of Figure 51) with cavity facing up and place pulley (BN) onto tool.

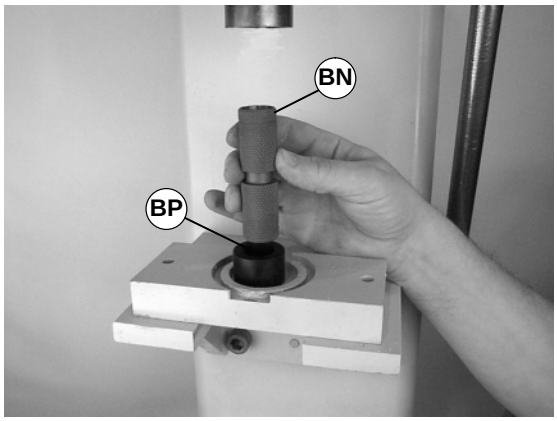


Figure 51

2. Install bearing insertion tool (part # 25-10☆) (BQ of Figure 52) into arbor press or similar device.

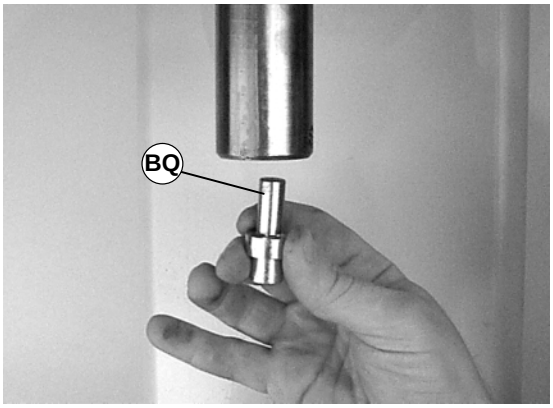


Figure 52

3. Place and hold bearing (part # 21-33) (BO) onto tool (BQ).

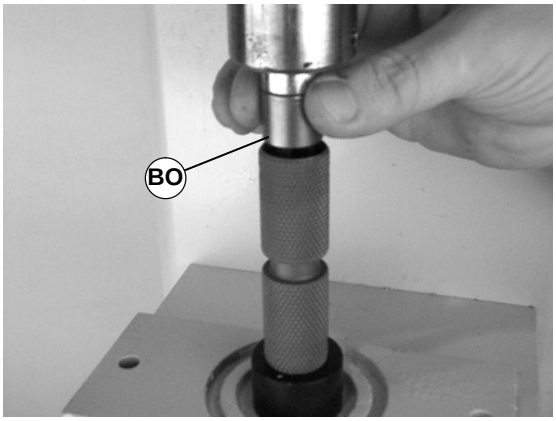


Figure 53

☆ - Part of Tool Kit, part # 2500M.

IMPORTANT: Bearing and pulley alignment is critical.

4. Press bearing (BO of Figure 54) into pulley (BN) until seated.

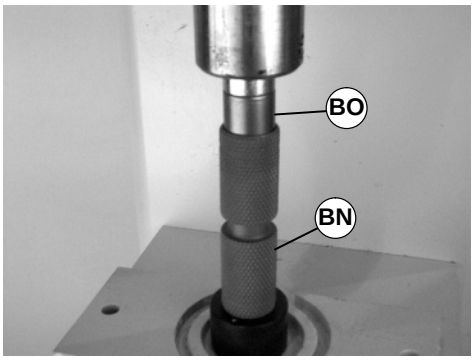


Figure 54

Pulley Replacement

Drive Pulley with Standard 0.47¨ (12 mm) Diameter Output Shaft Replacement

1. Reverse the removal procedure "A" (see page 13).

Idler Pulley Replacement

IMPORTANT: On a tension tail assembly, orient both pinion housings (BR of Figure 55) so they engage the same tooth positions on their respective racks.

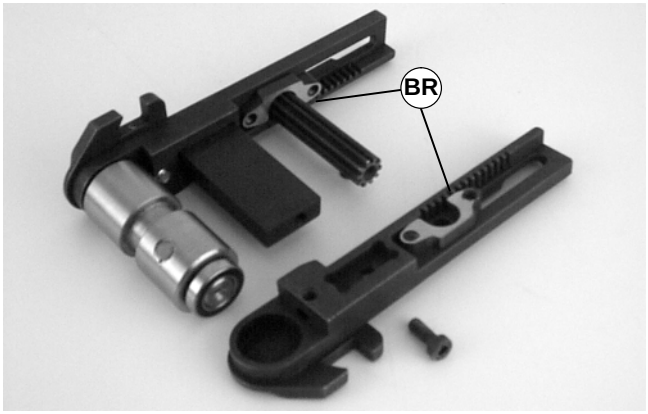


Figure 55

1. Reverse the removal procedure "B" (see page 13).

Idler Pulley with Tool-less Belt Release Replacement

IMPORTANT: On a tension tail assembly, orient both pinion housings (BR of Figure 55) so they engage the same tooth positions on their respective racks.

1. Reverse the removal procedure "C" (see page 14).

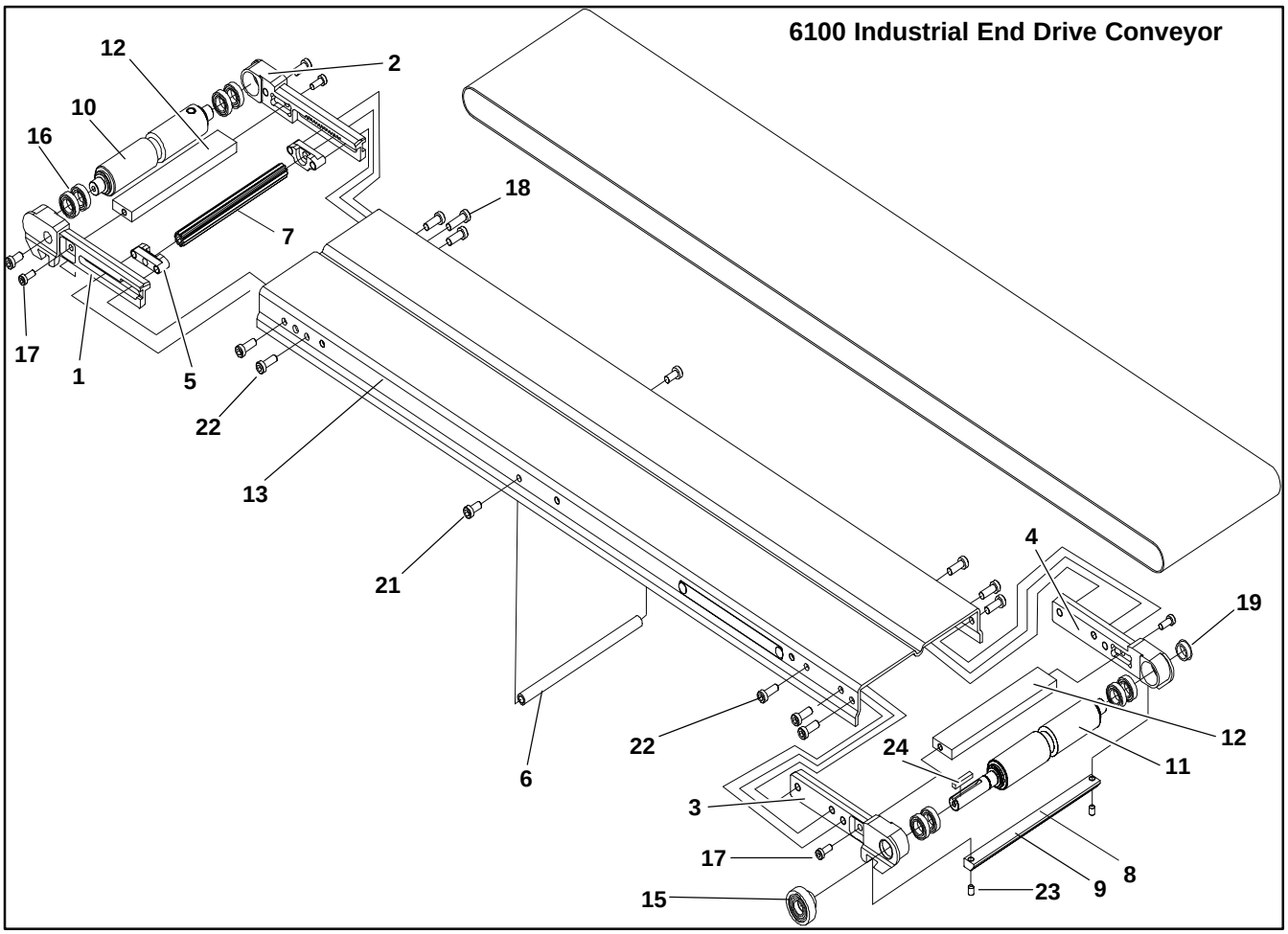
Gang Drive Pulley Replacement

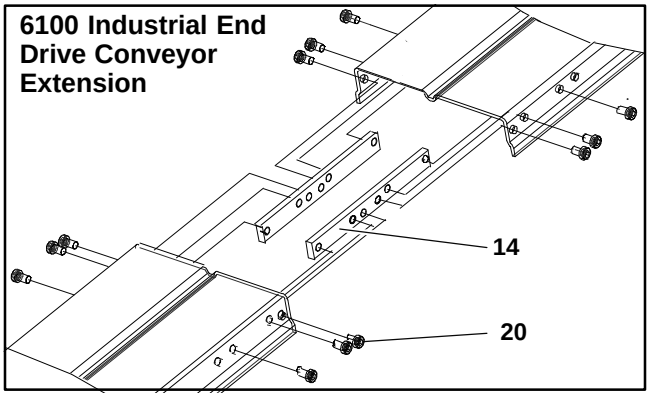
1. Reverse the removal procedure "D" (see page 14).

Notes

Service Parts

NOTE: For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory.





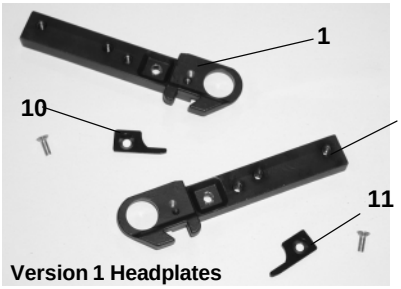
Item	Part Number	Description
1	450231M	Plate Tension RH 2–3” Wide
	450031M	Plate Tension RH 4–18” Wide
2	450232M	Plate Tension LH 2–3” Wide
	450032M	Plate Tension LH 4–18” Wide
3	450233M	Plate Fixed RH 2–3” Wide
	450355M	Plate Fixed RH 4–18” Wide
4	450234M	Plate Fixed LH 2–3” Wide
	450356M	Plate Fixed LH 4–18” Wide
5	450039M	Block Retainer Pinion
6	452502M	Post Support Frame 2” (51mm)
	452503M	Post Support Frame 3” (76mm)
	452504M	Post Support Frame 4” (102mm)
	452505M	Post Support Frame 5” (127mm)
	452506M	Post Support Frame 6” (152mm)
	452508M	Post Support Frame 8” (203mm)
	452510M	Post Support Frame 10” (254mm)
	452512M	Post Support Frame 12” (305mm)
	452518M	Post Support Frame 18” (457mm)
7	452602M	Pinion 2” (51mm)
	452603M	Pinion 3” (76mm)
	452604M	Pinion 4” (102mm)

	452605M	Pinion 5” (127mm)
	452606M	Pinion 6” (152mm)
	452608M	Pinion 8” (203mm)
	452610M	Pinion 10” (254mm)
	452612M	Pinion 12” (305mm)
	452618M	Pinion 18” (457mm)
8	452702M	Wiper Bottom 2” (51mm)
	452703M	Wiper Bottom 3” (76mm)
	452704M	Wiper Bottom 4” (102mm)
	452705M	Wiper Bottom 5” (127mm)
	452706M	Wiper Bottom 6” (152mm)
	452708M	Wiper Bottom 8” (203mm)
	452710M	Wiper Bottom10” (254mm)
	452712M	Wiper Bottom 12” (305mm)
	452718M	Wiper Bottom 18” (457mm)
9	452802M	Bar Bottom 2” (51mm)
	452803M	Bar Bottom 3” (76mm)
	452804M	Bar Bottom 4” (102mm)
	452805M	Bar Bottom 5” (127mm)
	452806M	Bar Bottom 6” (152mm)
	452808M	Bar Bottom 8” (203mm)
	452810M	Bar Bottom 10” (254mm)
	452812M	Bar Bottom 12” (305mm)
	452818M	Bar Bottom 18” (457mm)
10	453002	Spindle Assembly Idler 2” (51mm)
	453003	Spindle Assembly Idler 3” (76mm)
	453004	Spindle Assembly Idler 4” (102mm)
	453005	Spindle Assembly Idler 5” (127mm)
	453006	Spindle Assembly Idler 6” (152mm)
	453008	Spindle Assembly Idler 8” (203mm)
	453010	Spindle Assembly Idler 10” (254mm)
	453012	Spindle Assembly Idler 12” (305mm)
	453018	Spindle Assembly Idler 18” (457mm)
11	453102M	Drive Spindle 2” (51mm)
	453103M	Drive Spindle 3” (76mm)
	453104M	Drive Spindle 4” (102mm)
	453105M	Drive Spindle 5” (127mm)
	453106M	Drive Spindle 6” (152mm)
	453108M	Drive Spindle 8” (203mm)
	453110M	Drive Spindle 10” (254mm)
	453112M	Drive Spindle 12” (305mm)
	453118M	Drive Spindle 18” (457mm)
12	453602M	Support Tension Fixed 2” (51mm)
	453603M	Support Tension Fixed 3” (76mm)
	453604M	Support Tension Fixed 4” (102mm)
	453605M	Support Tension Fixed 5” (127mm)
	453606M	Support Tension Fixed 6” (152mm)
	453608M	Support Tension Fixed 8” (203mm)
	453610M	Support Tension Fixed 10” (254mm)
	453612M	Support Tension Fixed 12” (305mm)
	453618M	Support Tension Fixed 18” (457mm)
13	See chart below	6100 Conveyor Frame
14	450160M	Bar Connecting Frame
15	450359	Bearing Assembly Outboard (10”–18” Only)
16	802–121	Ball Bearing 12mm (Bore) x 21mm (OD)
17	807–1022	Socket Head Cap Screw (Metric) Low M5–.80x12mm
18	807–1031	Cap Screw (Metric) Low M6–1.0x20
19	807–963	Hole Plug 2” to 3” Wide
	807–1087	Hole Plug 4” To 18” Wide
20	920691M	Cap Screw (Metric) Low M6–1.0x10mm
21	920692M	Cap Screw (Metric) Low M6–1.0x12mm
22	920693M	Cap Screw (Metric) Low M6–1.0x16mm
23	970508M	Cap Screw (Metric) Cup M5– .80x8mm
24	980422M	Key Square 4mm x 22mm

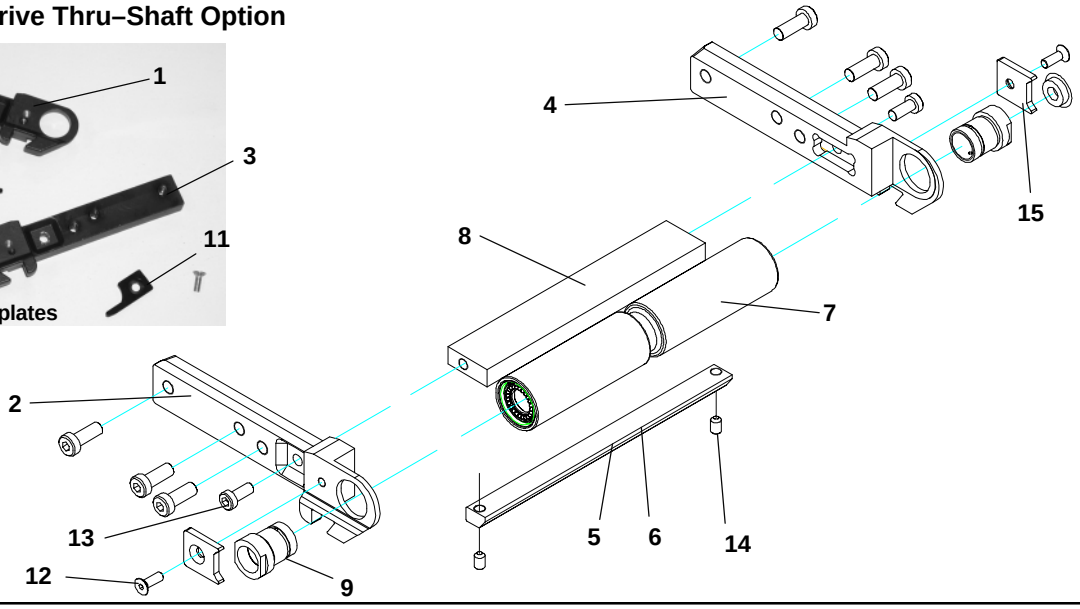
Item 13: 6100 Conveyor Frame	
Length	Part Number(s)
2’ (610mm)	47WW02M
3’ (914mm)	47WW03M
4’ (1219mm)	47WW04M
5’ (1524mm)	47WW05M
6’ (1829mm)	47WW06M
7’ (2134mm)	47WW07M
8’ (2438mm)	47WW08M
9’ (2743mm)	47WW09M
10’ (3048mm)	47WW10M
11’ (3353mm)	47WW11M
12’ (3658mm)	47WW12M
13’ (3962mm)	47WW07M 47WW13M
14’ (4267mm)	47WW08M 47WW13M
15’ (4572mm)	47WW09M 47WW13M
16’ (4877mm)	47WW09M 47WW13M
17’ (5182mm)	47WW09M 47WW13M
18’ (5486mm)	47WW09M 47WW13M
19’ (5791mm)	47WW09M 47WW13M
20’ (6096mm)	47WW09M 47WW13M
21’ (6401mm)	47WW09M 47WW13M
22’ (6706mm)	47WW09M 47WW13M
23’ (7011mm)	47WW09M 47WW13M
24’ (7316mm)	47WW09M 47WW13M
WW = frame width reference: 02, 03, 04, 05, 06, 08, 10, 12, 18	

Service Parts

6100 Gang Drive Thru–Shaft Option



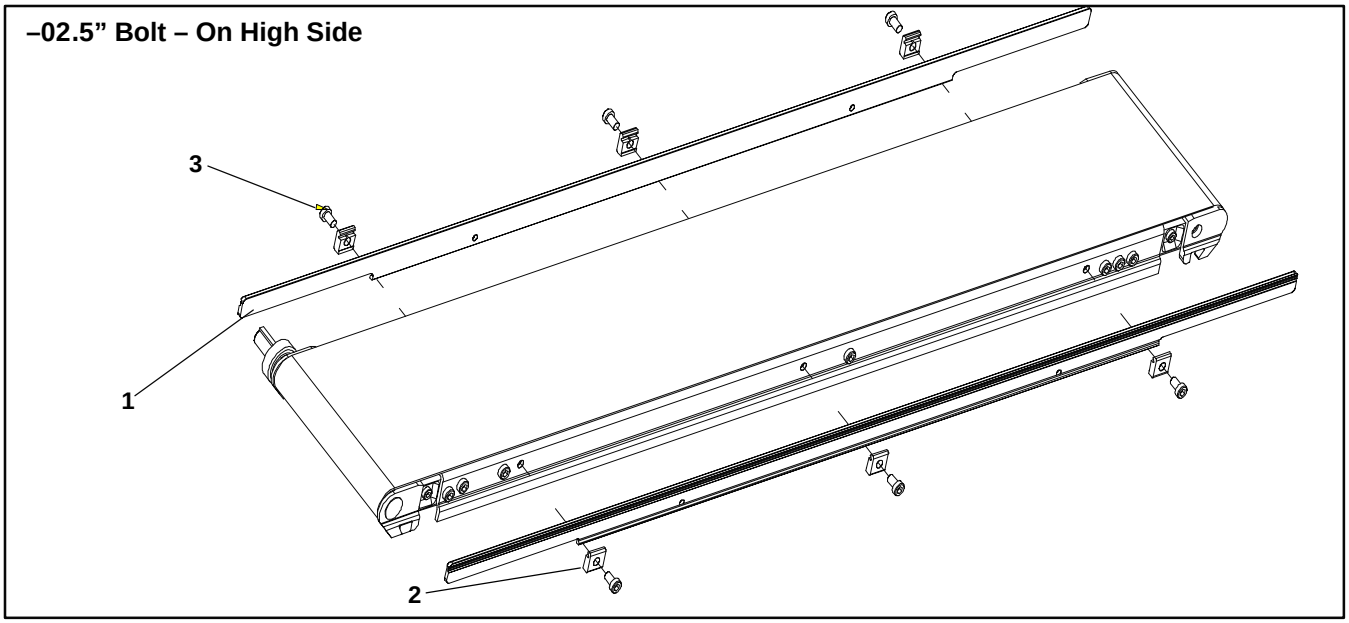
Version 1 Headplates



Item	Part Number	Description
1	450228M	Fixed Plate RH (Version 1)
2	450528M	Fixed Plate RH (Version 2)
3	450229M	Fixed Plate LH (Version 1)
4	450529M	Fixed Plate LH (Version 2)
5	452702M	Wiper Bottom 2” (51mm)
	452703M	Wiper Bottom 3” (76mm)
	452704M	Wiper Bottom 4” (102mm)
	452705M	Wiper Bottom 5” (127mm)
	452706M	Wiper Bottom 6” (152mm)
	452708M	Wiper Bottom 8” (203mm)
	452710M	Wiper Bottom 10” (254mm)
	452712M	Wiper Bottom 12” (305mm)
	452718M	Wiper Bottom 18” (457mm)
6	452802M	Bar Bottom 2” (51mm)
	452803M	Bar Bottom 3” (76mm)
	452804M	Bar Bottom 4” (102mm)
	452805M	Bar Bottom 5” (127mm)
	452806M	Bar Bottom 6” (152mm)
	452808M	Bar Bottom 8” (203mm)
	452810M	Bar Bottom 10” (254mm)
	452812M	Bar Bottom 12” (305mm)
	452818M	Bar Bottom 18” (457mm)
7	See chart below	Drive Spindle
8	453602M	Support Tension Fixed 2” (51mm)
	453603M	Support Tension Fixed 3” (76mm)
	453604M	Support Tension Fixed 4” (102mm)
	453605M	Support Tension Fixed 5” (127mm)
	453606M	Support Tension Fixed 6” (152mm)
	453608M	Support Tension Fixed 8” (203mm)
	453610M	Support Tension Fixed 10” (254mm)
	453612M	Support Tension Fixed 12” (305mm)
	453618M	Support Tension Fixed 18” (457mm)
9	200035	Retaining Sleeve (3”–18”)
	677330	Retaining Sleeve (2”)
10	450235	Retainer Clip RH
11	450236	Retainer Clip LH
12	930412M	Socket Head Cap Screw (Metric) Flat M4 x 22mm
13	807–1022	Socket Head Cap Screw (Metric) Low Pilot M5–.80 x 12mm
14	970508M	Socket Head Cap Screw (Metric) M5–.80 x 8mm
15	450381	Retaining Clip

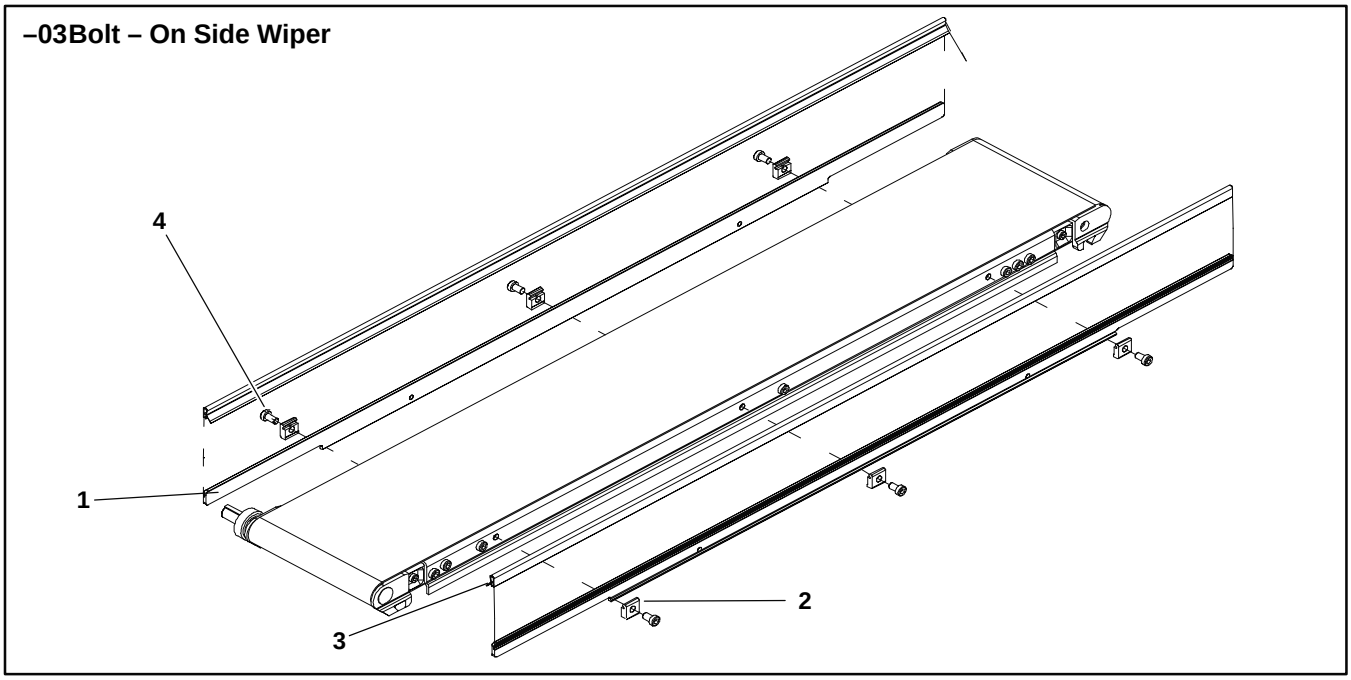
Item 5: Drive Spindle			
Spindle Width	Spindle assembly with bearings	Spindle without bearings	Bearings
2” (51mm)	454702	N/A	N/A
3” (76mm)	454703	454503	41–33
4” (102mm)	454704	454504	41–33
5” (127mm)	454705	454505	41–33
6” (152mm)	454706	454506	41–33
8” (203mm)	454708	454508	41–33
10” (254mm)	454710	454510	41–33
12” (305mm)	454712	454512	41–33
18” (457mm)	454718	454518	41–33

–02.5" Bolt – On High Side



Item	Part Number	Description
1	460232	Rail Guide .5" HS x 2' (610mm)
	460233	Rail Guide .5" HS x 3' (914mm)
	460234	Rail Guide .5" HS x 4' (1219mm)
	460235	Rail Guide .5" HS x 5' (1524mm)
	460236	Rail Guide .5" HS x 6' (1829mm)
2	460250	Clip Mounting Guide
3	920691M	Socket Head Cap Screw (Metric) Low M6–1.00 x 10mm

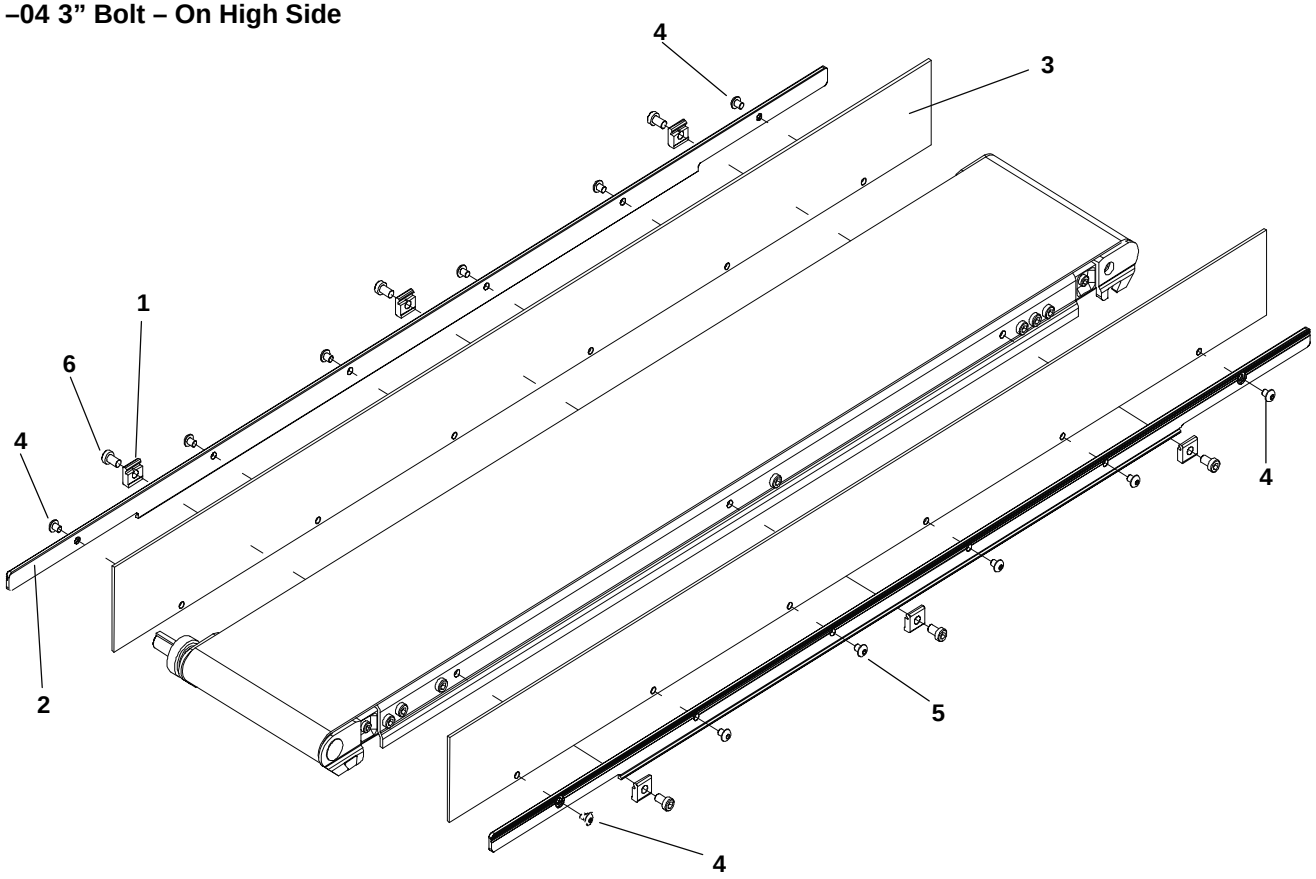
–03Bolt – On Side Wiper



Item	Part Number	Description
1	460232	Rail Guide .5" HS x 2' (610mm)
	460233	Rail Guide .5" HS x 3' (914mm)
	460234	Rail Guide .5" HS x 4' (1219mm)
	460235	Rail Guide .5" HS x 5' (1524mm)
	460236	Rail Guide .5" HS x 6' (1829mm)
2	460250	Clip Mounting Guide
3	41–00–24	Wiper Side Nylatron (per foot)
4	920691M	Socket Head Cap Screw (Metric) M6–1.0 x 10mm

Service Parts

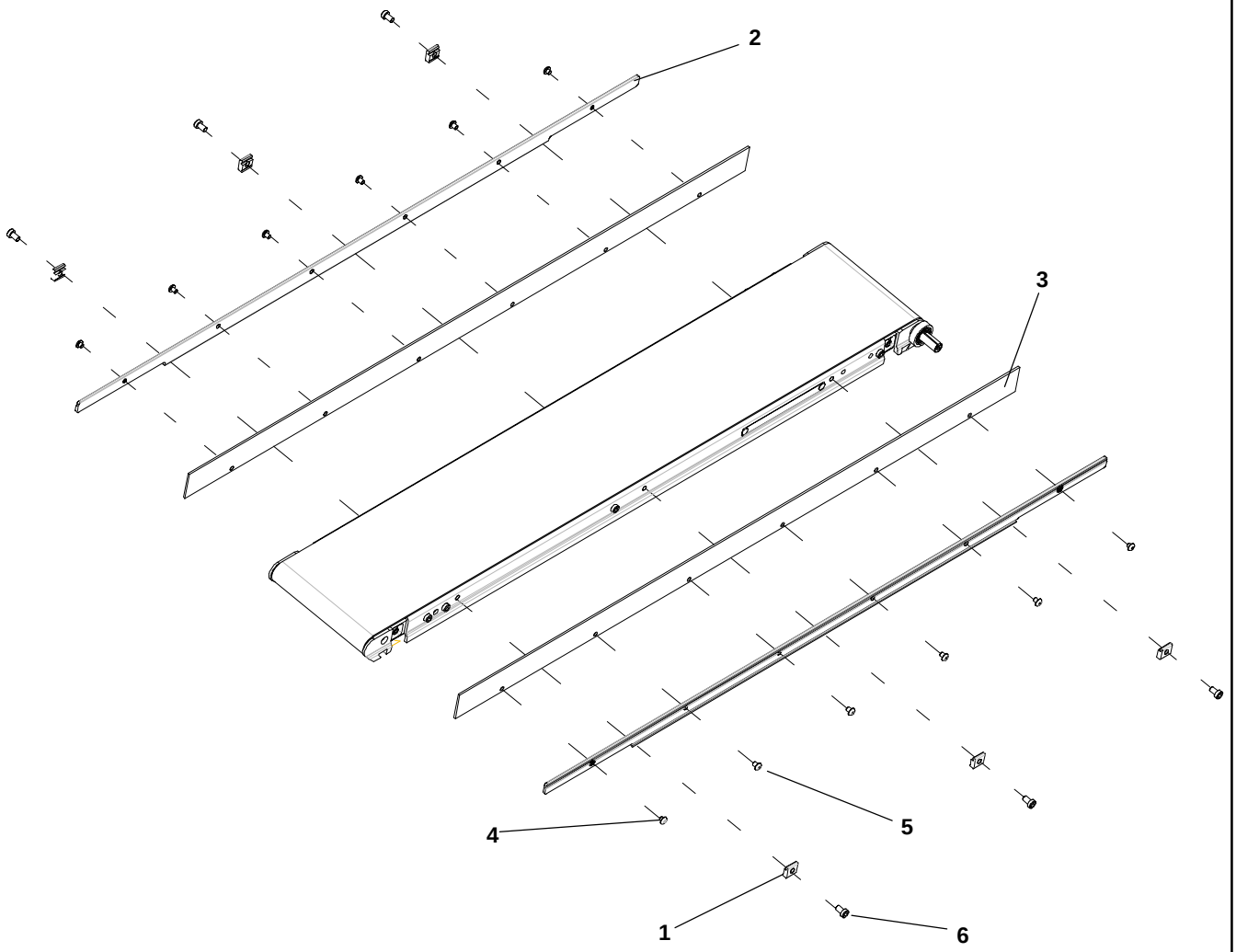
–04 3” Bolt – On High Side



Item	Part Number	Description
1	460250	Clip Mounting Guide
2	460432	Rail guide .5” HS w/holes 2’ (610mm)
	460433	Rail guide .5” HS w/holes 3’ (914mm)
	460434	Rail guide .5” HS w/holes 4’ (1219mm)
	460435	Rail guide .5” HS w/holes 5’ (1524mm)
	460436	Rail guide .5” HS w/holes 6’ (1829mm)
3	460452M	Guide Side #4 – 2’ (610mm)
	460453M	Guide Side #4 – 3’ (914mm)
	460454M	Guide Side #4 – 4’ (1219mm)
	460455M	Guide Side #4 – 5’ (1524mm)
	460456M	Guide Side #4 – 6’ (1829mm)

4	910504M	Socket Head Cap Screw Button (Metric) M5 – .80 x 4mm
5	910506M	Socket Head Cap Screw Button (Metric) M5–.80 x 6mm
6	920691M	Socket Head Cap Screw (Metric) M6–1.0 x 10MM

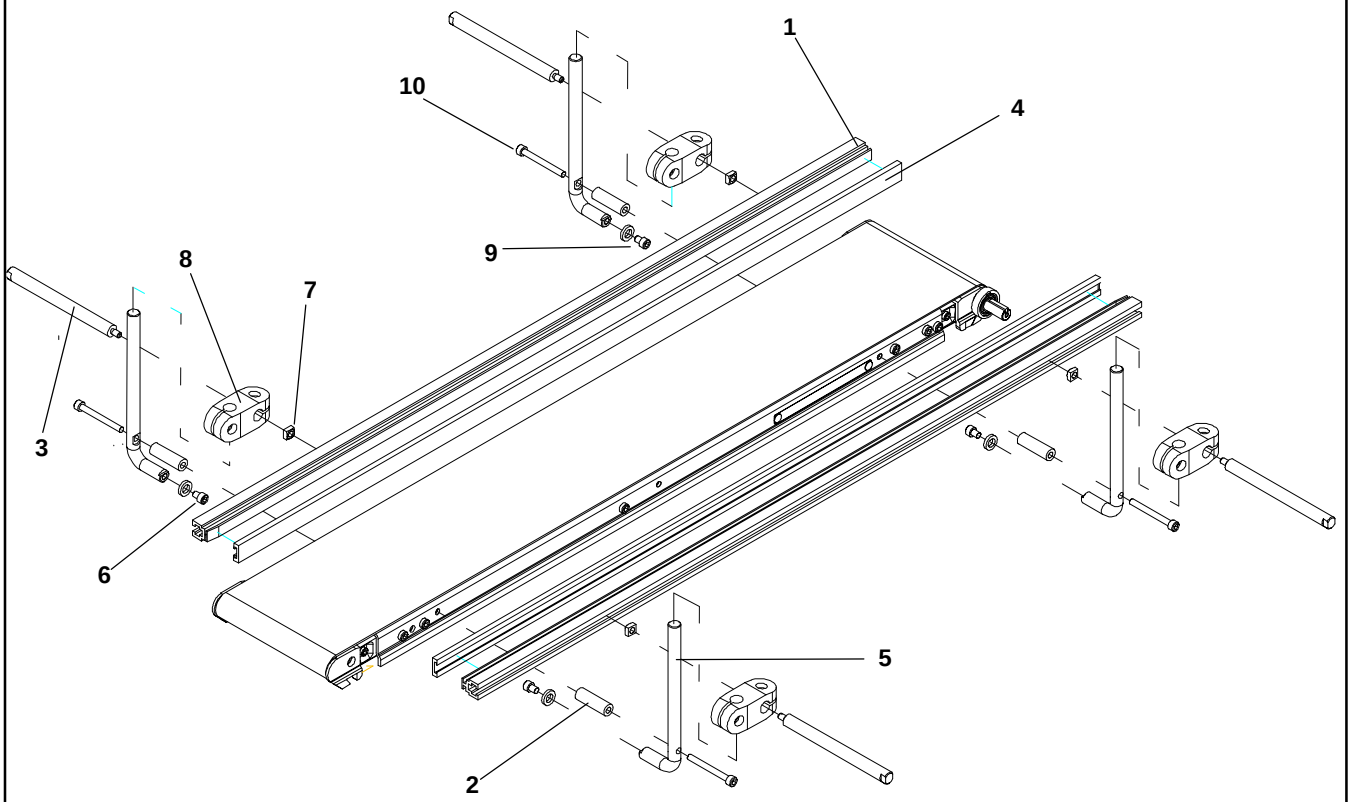
–05 1.5” Bolt – On High Side



Item	Part Number	Description
1	460250	Guide Mounting Clip
2	460432	Rail guide .5” HS w/holes 2’ (610mm)
	460433	Rail guide .5” HS w/holes 3’ (914mm)
	460434	Rail guide .5” HS w/holes 4’ (1219mm)
	460435	Rail guide .5” HS w/holes 5’ (1524mm)
	460436	Rail guide .5” HS w/holes 6’ (1829mm)
3	460452M	Guide Side #4 – 2’ (610mm)
	460453M	Guide Side #4 – 3’ (914mm)
	460454M	Guide Side #4 – 4’ (1219mm)
	460455M	Guide Side #4 – 5’ (1524mm)
	460456M	Guide Side #4 – 6’ (1829mm)

4	910504M	Socket Head Cap Screw Button (Metric) M5–.80 x 4mm
5	910506M	Socket Head Cap Screw Button (Metric) M5–.80 x 6mm
6	920691M	Socket Head Cap Screw (Metric) Low M6–1.0 x 10mm

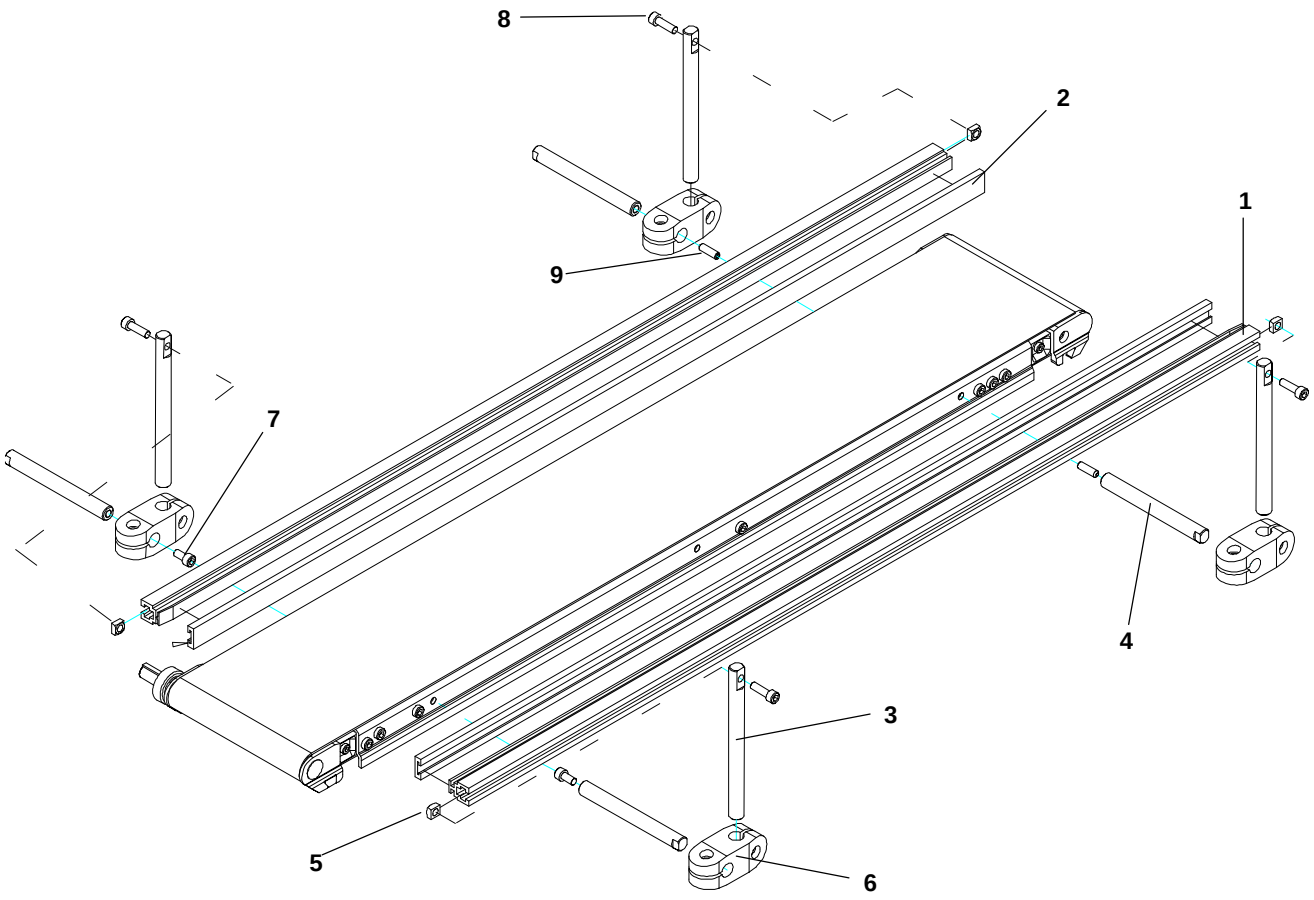
–13 Fully Adjustable UHMW Guide



Item	Part Number	Description
1	202983	Guide Mounting Rail 2’ (610mm)
	202984	Guide Mounting Rail 3’ (914mm)
	202985	Guide Mounting Rail 4’ (1219mm)
	202986	Guide Mounting Rail 5’ (1524mm)
	202987	Guide Mounting Rail 6’ (1829mm)
	202988	Guide Mounting Rail 7’ (2134mm)
	202989	Guide Mounting Rail 8’ (2438mm)
	202990	Guide Mounting Rail 9’ (2743mm)
	202991	Guide Mounting Rail 10’ (3053mm)
	202992	Guide Mounting Rail 11’ (3353mm)
	202993	Guide Mounting Rail 12’ (3658mm)
	202994	Guide Mounting Rail 13’ (3962mm)

2	461351	Shaft Brace
3	202028M	Horizontal Shaft Mounting Guide
4	614068	Guide Extruded Flat (per foot)
5	461350M	Shaft Vertical Adj Guide
6	605279M	Hard washer
7	674175MP	Square Nut M6–1.0 w/1/4–20
8	807–652	Cross Block
9	920608M	Socket Head Cap Screw (Metric) M6–1.0 x 8mm
10	920655M	Socket Head Cap Screw (Metric) M6–1.0 x 55mm

–20 Adjustable Width UHMW Guide

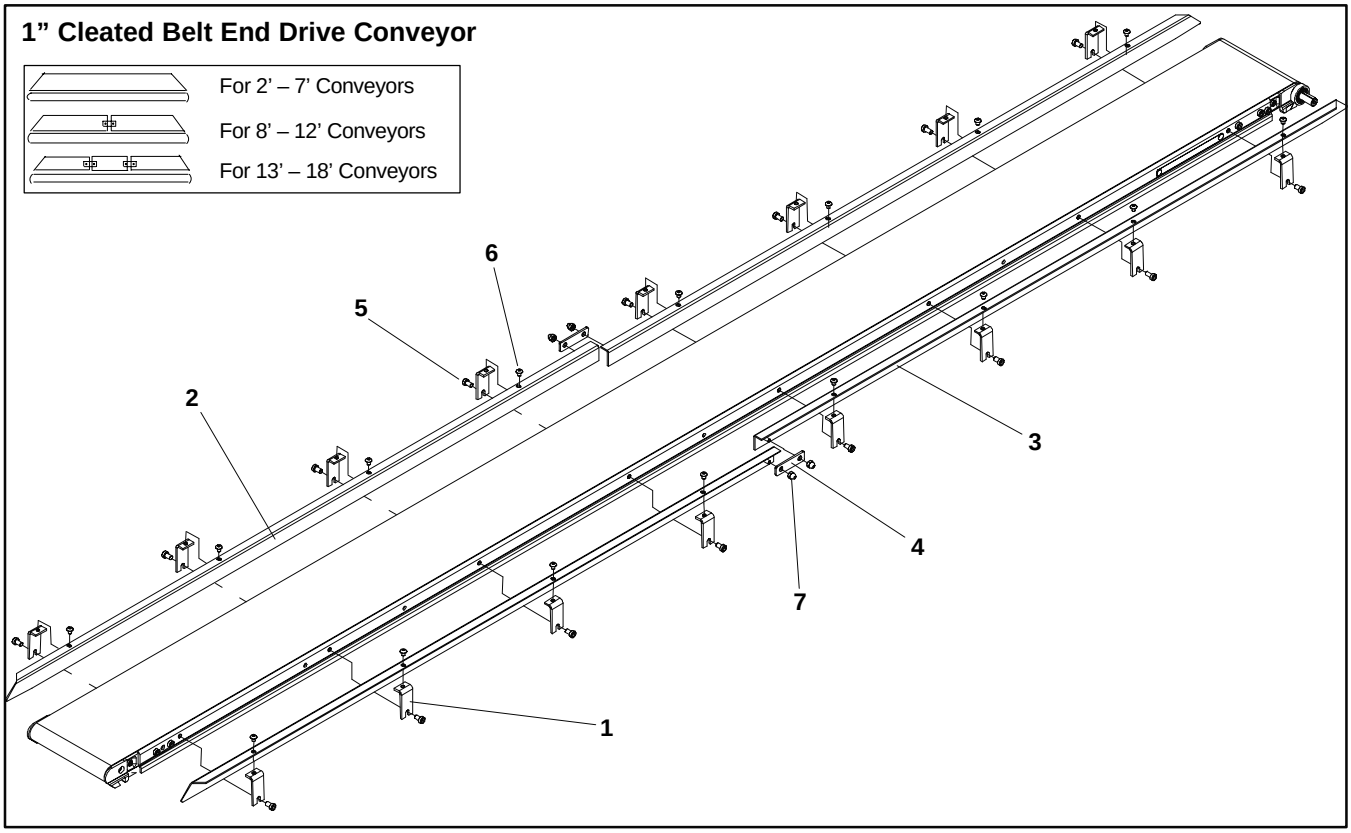


Item	Part Number	Description
1	202983	Guide Mounting Rail 2’ (610mm)
	202984	Guide Mounting Rail 3’ (914mm)
	202985	Guide Mounting Rail 4’ (1219mm)
	202986	Guide Mounting Rail 5’ (1524mm)
	202987	Guide Mounting Rail 6’ (1829mm)
	202988	Guide Mounting Rail 7’ (2134mm)
	202989	Guide Mounting Rail 8’ (2438mm)
	202990	Guide Mounting Rail 9’ (2743mm)
	202991	Guide Mounting Rail 10’ (3048mm)
	202992	Guide Mounting Rail 11’ (3353mm)
	202993	Guide Mounting Rail 12’ (3658mm)
	202994	Guide Mounting Rail 13’ (3962mm)

2	614068	Guide extruded flat (per foot)
3	462050M	Vertical Shaft Gullwing Guide
4	462052M	Horizontal Shaft Gullwing Guide
5	674175MP	Square Nut M6–1.0 w/1/4–20
6	807–652	Cross Block
7	920612M	Socket Head Cap Screw (Metric) M6–1.0 x 12mm
8	920620M	Socket Head Cap Screw (Metric) M6–1.0 x 20mm
9	970620M	Socket Head Set Screw (Metric) M6–1.0 x 20mm

Service Parts

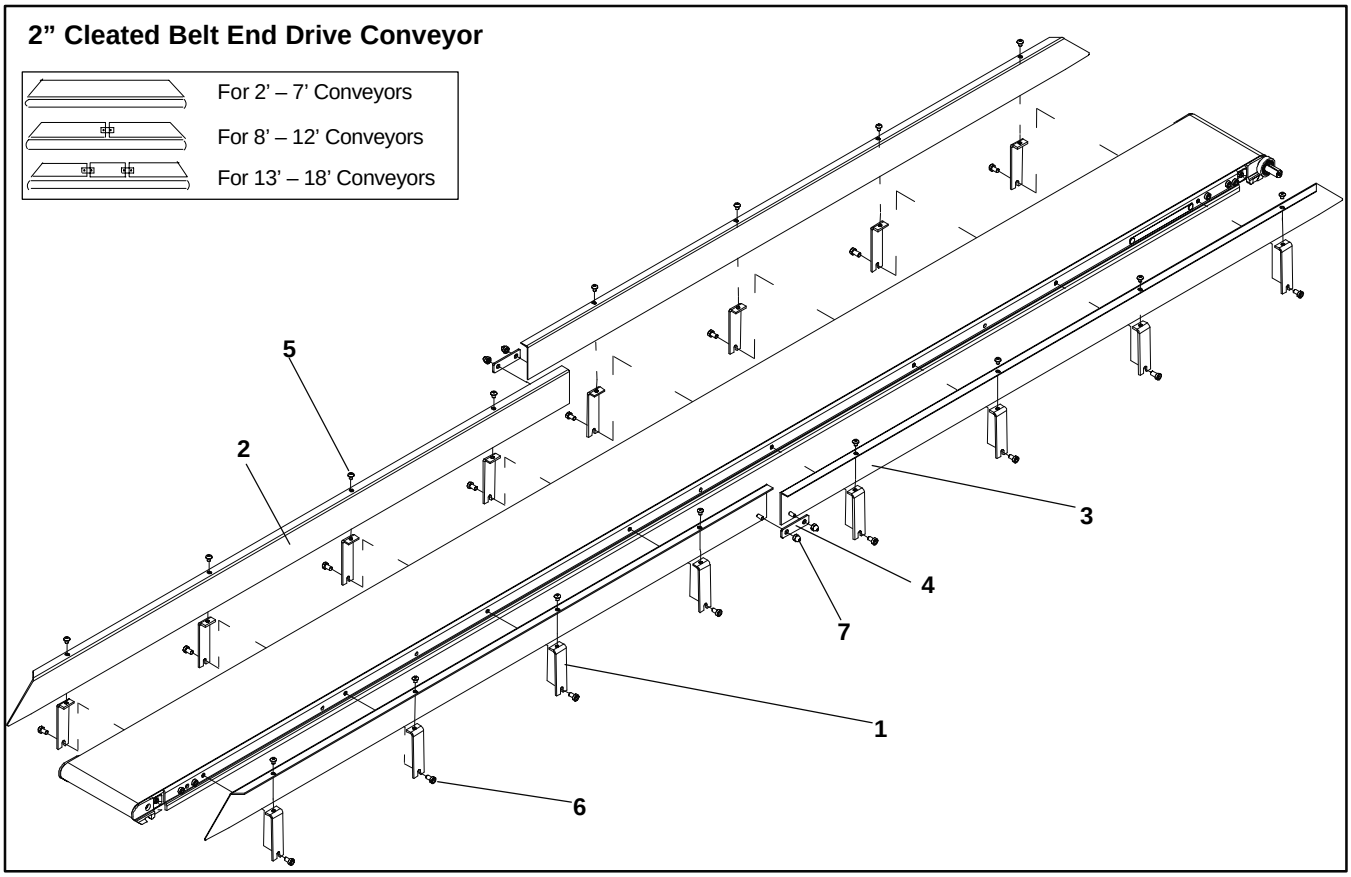
1" Cleated Belt End Drive Conveyor



Item	Part Number	Description
1	462150MSS	1" Guide Mounting Bracket
2	See chart below	1" Guide RH
3	See chart below	1" Guide LH
4	450188SS	Guide Tie Plate
5	920691M	M6–1.0 x 10mm Low Head Screw
6	910506M	M5–0.8 x 6mm Button Head Screw
7	990508MSS	M5 Acorn Nut

Conveyor Length		End Guide	Center Guide	End Guide
2' (610mm)	Right Hand	462132SSP	N/A	N/A
	Left Hand	462132SSP	N/A	N/A
3' (914mm)	Right Hand	462133SSP	N/A	N/A
	Left Hand	462133SSP	N/A	N/A
4' (1219mm)	Right Hand	462134SSP	N/A	N/A
	Left Hand	462134SSP	N/A	N/A
5' (1524mm)	Right Hand	462135SSP	N/A	N/A
	Left Hand	462135SSP	N/A	N/A
6' (1829mm)	Right Hand	462136SSP	N/A	N/A
	Left Hand	462136SSP	N/A	N/A
7' (2134mm)	Right Hand	462137SSP	N/A	N/A
	Left Hand	462137SSP	N/A	N/A
8' (2438mm)	Right Hand	462144SSP	N/A	462154SSP
	Left Hand	462154SSP	N/A	462144SSP
9' (2743mm)	Right Hand	462144SSP	N/A	462154SSP
	Left Hand	462145SSP	N/A	462155SSP
10' (3048mm)	Right Hand	462155SSP	N/A	462145SSP
	Left Hand	462145SSP	N/A	462155SSP
11' (3353mm)	Right Hand	462146SSP	N/A	462156SSP
	Left Hand	462145SSP	N/A	462155SSP
12' (3658mm)	Right Hand	462146SSP	N/A	462156SSP
	Left Hand	462156SSP	N/A	462146SSP
13' (3962mm)	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462144SSP	462163SSP	462154SSP
14' (4267mm)	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462145SSP	462163SSP	462155SSP
15' (4572mm)	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462156SSP	462163SSP	462146SSP
16' (4877mm)	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462144SSP	462166SSP	462154SSP
17' (5182mm)	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462145SSP	462166SSP	462155SSP
18' (5486mm)	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462156SSP	462166SSP	462146SSP

2” Cleated Belt End Drive Conveyor

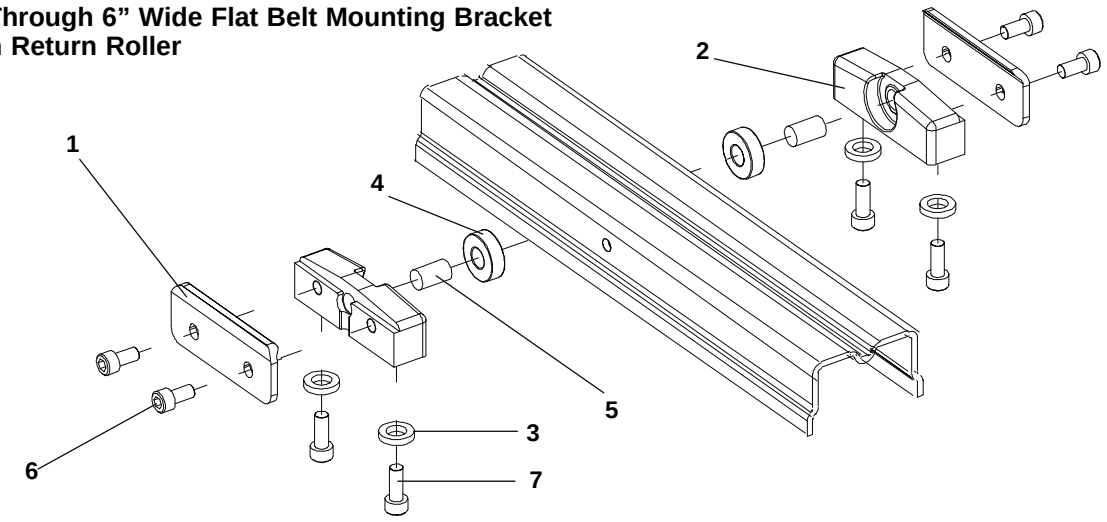


Item	Part Number	Description
1	462250MSS	2” Guide Mounting Bracket
2	See chart below	2” Guide RH
3	See chart below	2” Guide LH
4	450188SS	Guide Tie Plate
5	920691M	M6–1.0 x 10mm LowHead Screw
6	910506M	M5–0.8 x 6mm Button Head Screw
7	990508MSS	M5 Acorn Nut

Conveyor Length		End Guide	Center Guide	End Guide
2’ (610mm)	Right Hand	462232SSP	N/A	N/A
	Left Hand	462232SSP	N/A	N/A
3’ (914mm)	Right Hand	462233SSP	N/A	N/A
	Left Hand	462233SSP	N/A	N/A
4’ (1219mm)	Right Hand	462234SSP	N/A	N/A
	Left Hand	462234SSP	N/A	N/A
5’ (1524mm)	Right Hand	462235SSP	N/A	N/A
	Left Hand	462235SSP	N/A	N/A
6’ (1829mm)	Right Hand	462236SSP	N/A	N/A
	Left Hand	462236SSP	N/A	N/A
7’ (2134mm)	Right Hand	462237SSP	N/A	N/A
	Left Hand	462237SSP	N/A	N/A
8’ (2438mm)	Right Hand	462244SSP	N/A	462254SSP
	Left Hand	462254SSP	N/A	462244SSP
9’ (2743mm)	Right Hand	462244SSP	N/A	462254SSP
	Left Hand	462245SSP	N/A	462255SSP
10’ (3048mm)	Right Hand	462255SSP	N/A	462245SSP
	Left Hand	462245SSP	N/A	462255SSP
11’ (3353mm)	Right Hand	462246SSP	N/A	462256SSP
	Left Hand	462245SSP	N/A	462255SSP
12’ (3658mm)	Right Hand	462246SSP	N/A	462256SSP
	Left Hand	462256SSP	N/A	462246SSP
13’ (3962mm)	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462244SSP	462263SSP	462254SSP
14’ (4267mm)	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462245SSP	462263SSP	462255SSP
15’ (4572mm)	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462256SSP	462263SSP	462246SSP
16’ (4877mm)	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462244SSP	462266SSP	462254SSP
17’ (5182mm)	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462245SSP	462266SSP	462255SSP
18’ (5486mm)	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462256SSP	462266SSP	462246SSP

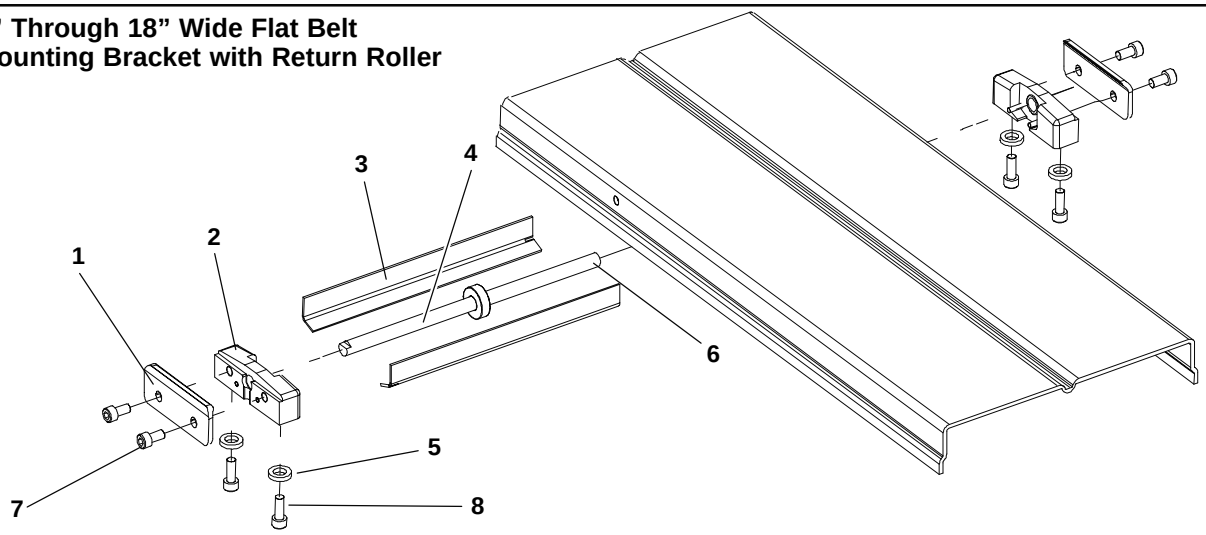
Service Parts

2” Through 6” Wide Flat Belt Mounting Bracket with Return Roller



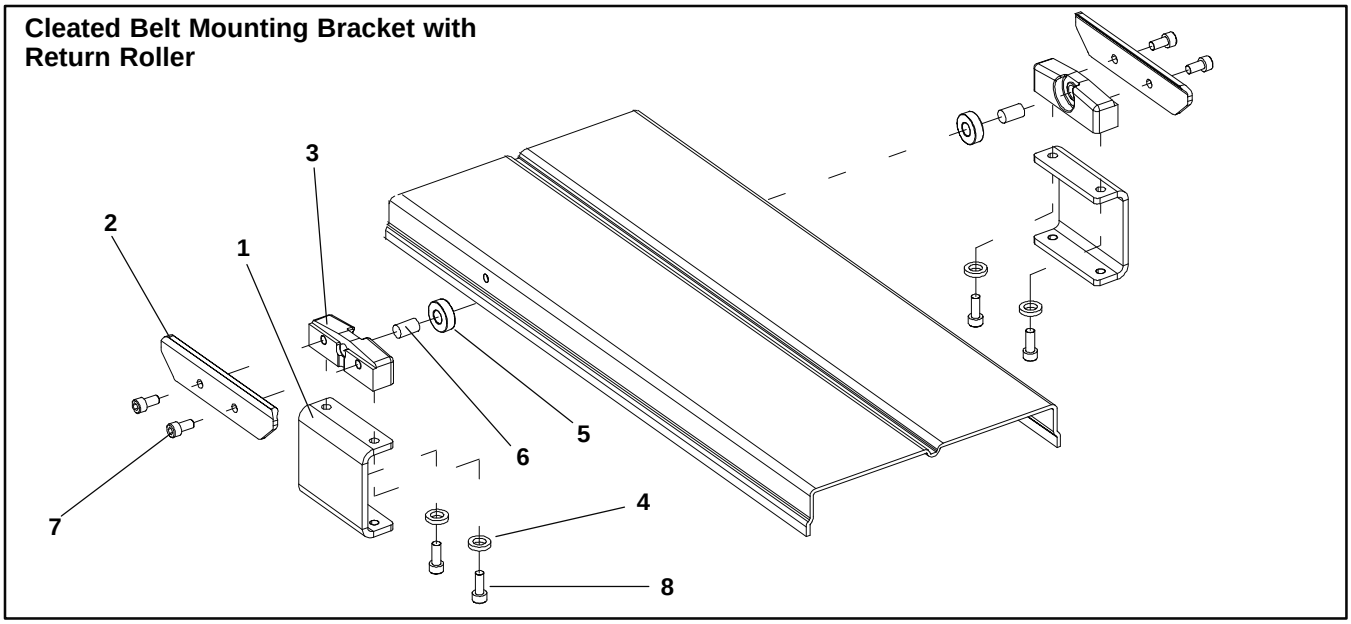
Item	Part Number	Description
1	492564M	Clamp Plate
2	493026M	Mounting Block
3	605279P	Washer
4	802–123	Bearing
5	913–103	Dowel Pin
6	920612M	Socket Head Cap Screw (Metric) M6 – 1.0 x 12mm
7	920616M	Socket Head Cap Screw (Metric) M5–.8 x 16mm

8” Through 18” Wide Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492564M	Clamp Plate
2	492571M	Mounting Block
3	493108SSP	Bottom Roller Guard 8” (203mm)
	493110SSP	Bottom Roller Guard 10” (254mm)
	493112SSP	Bottom Roller Guard 12” (305mm)
	493118SSP	Bottom Roller Guard 18” (457mm)
4	493308SS	Shaft Assembly Belt Support 8” (203mm)
	493310SS	Shaft Assembly Belt Support 10” (254mm)
	493312SS	Shaft Assembly Belt Support 12” (305mm)
	493318SS	Shaft Assembly Belt Support 18” (457mm)
5	605279P	Hard Washer
6	807–1019	Groove Pin
7	920612M	Socket Head Cap Screw (Metric) M6–1.0 x 12mm
8	920616M	Socket Head Cap Screw (Metric) M6–1.0 x 16mm

Cleated Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492565M	Bracket Riser Cleated Stand
2	492566M	Clamp Plate
3	493026M	Mounting Block
4	605279P	Washer
5	802–123	Bearing
6	913–103	Dowel Pin
7	920612M	Socket Head Cap Screw (Metric) M6–1.0 x 12mm
8	920616M	Socket Head Cap Screw (Metric) M6–1.0 x 16mm

Configuring Conveyor Belt Part Number

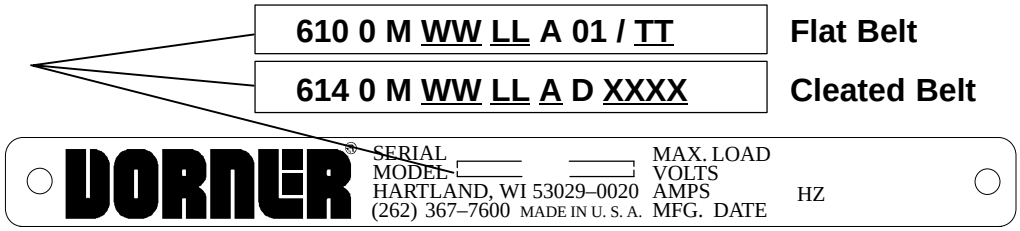


Figure 56

Flat Belt Conveyor

Refer to your serial and model number plate (Figure 56). Determine conveyor length ("LL"), width ("WW") and belt type ("TT").

61 – WW LL / TT

61- __ __ __ __ / __ __
(Fill In)

Cleated Belt Conveyor

Refer to your serial and model number plate (Figure 56). Determine conveyor length ("LL"), width ("WW"), cleat type ("AA") and cleat spacing ("XXXX").

64 – WW LL AA XXXX

64 - __ __ __ __ __ __ __ __ __ __
(Fill In)

Return Policy

No returns will be accepted without prior written factory authorization. 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. 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.

A representative will discuss action to be taken on the Returned items and provide a Returned Goods Authorization Number to reference.

There will be a 15% restocking charge on all new items returned for credit where Dorner was not at fault. These will not be accepted after 60 days from original invoice date. The restocking charge covers inspection, cleaning, disassembly, and reissuing 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. Feel free to contact Dorner for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dorner products.

For a copy of Dorner's Limited Warranty, contact factory, distributor, service center or visit our website @ www.dorner.com

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

DORNER®

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