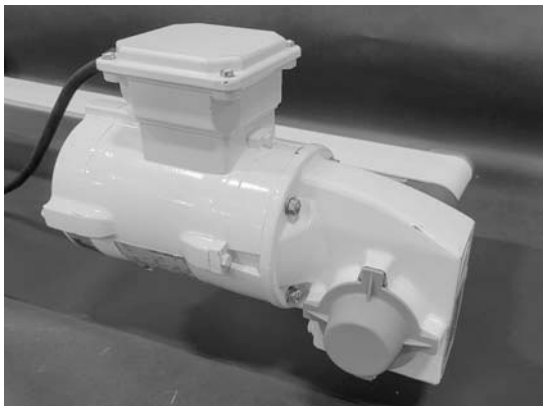
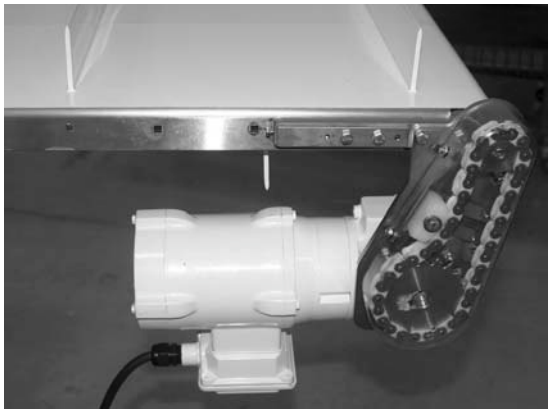
AquaGard® LP Gearmotor Mounting Packages

Installation, Maintenance & Parts Manual



Side 90°



Bottom 90°

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

CE

Original Instructions

Record Conveyor Serial Number Here

851-968-EU Rev. B

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

SEVERE HAZARD!

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

⚠ WARNING

Gearmotors may be HOT.

DO NOT TOUCH Gearmotors.

⚠ WARNING

Exposed moving parts can cause severe injury.

REPLACE ALL GUARDS BEFORE RUNNING CONVEYOR.

⚠ 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

Drive shaft keyway may be sharp.

HANDLE WITH CARE.

Product Description

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

1	Mounting Plate
2	Gearmotor
3	Motor Control

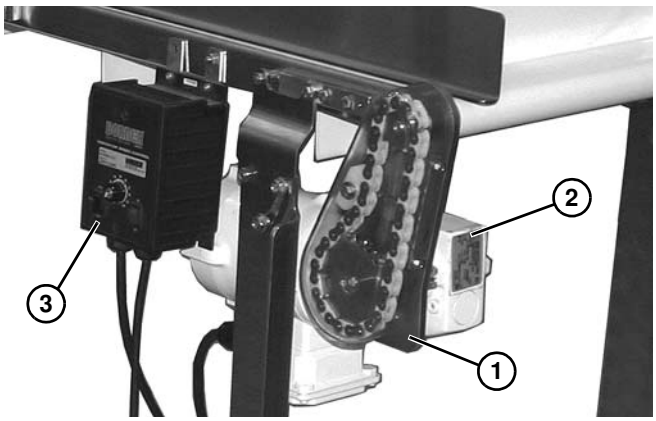
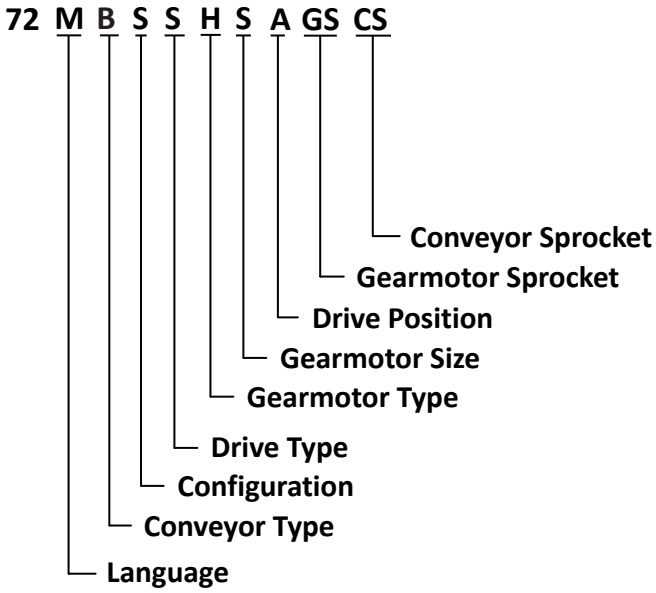


Figure 1

Specifications

Gearmotor Mounting Package



Fastener Torque Specifications

	Hex Head		Set Screw	
	Hex Size	**Torque**	**Hex Size**	**Torque**
M3 x 0.5	5.5 mm	0.9 Nm (8 in lbs)	2 mm	0.2 Nm (1.7 in lbs)
M4 x 0.7	7 mm	2.3 Nm (20 in lbs)	2 mm	0.7 Nm (6 in lbs)
M5 x 0.8	8 mm	4.6 Nm (40 in lbs)	2.5 mm	1.5 Nm (13 in lbs)
M6 x 1.0	10 mm	7.8 Nm (69 in lbs)	3 mm	2.5 Nm (22 in lbs)
M8 x 1.25	13 mm	19.0 Nm (169 in lbs)	4 mm	6.0 Nm (53 in lbs)
M10 x 1.5	16 mm	38.0 Nm (335 in lbs)	5 mm	12.0 Nm (106 in lbs)

Dorner recommends FDA approved grease on all threaded stainless steel fasteners.

Installation

Drive Package Types

Identify your drive package type:

- Side Drive Package
- Bottom 90° Drive Package
- Bottom Parallel Shaft Drive Package

Side Drive Package

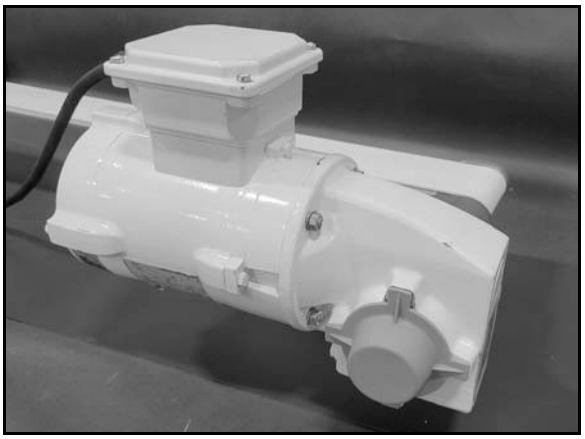


Figure 2

Typical Side Drive Package Components **(Figure 3)**.

1	Side Mounting
2	Coupling
3	Gearmotor
4	Screw (2x)
5	Guard

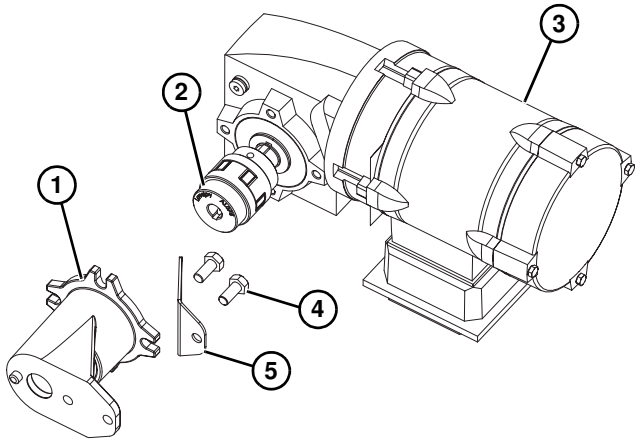


Figure 3

NOTE

Gearmotor may be operated in positions 1 through 4 ***(Figure 4)****.*

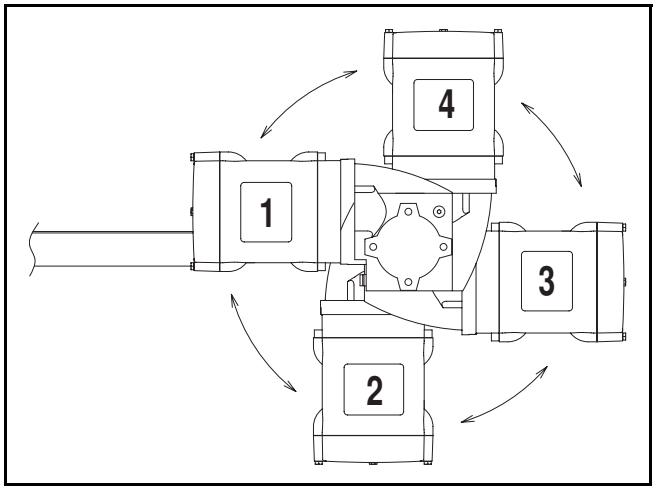


Figure 4

Bottom 90° Drive Package

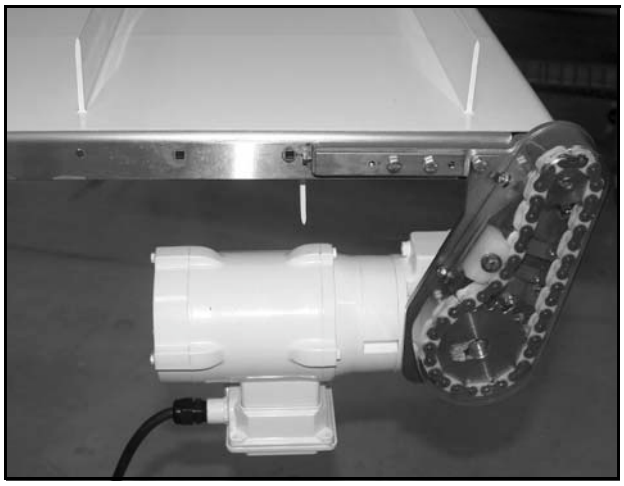


Figure 5

Typical Bottom 90° Drive Package components **(Figure 6)**.

1	Cover
2	Screw (2x)
3	Mounting Plate
4	Gearmotor
5	Key
6	Screw and Washer (4x)
7	Driven Pulley
8	Drive Pulley
9	Timing Belt
10	Screw (x4)

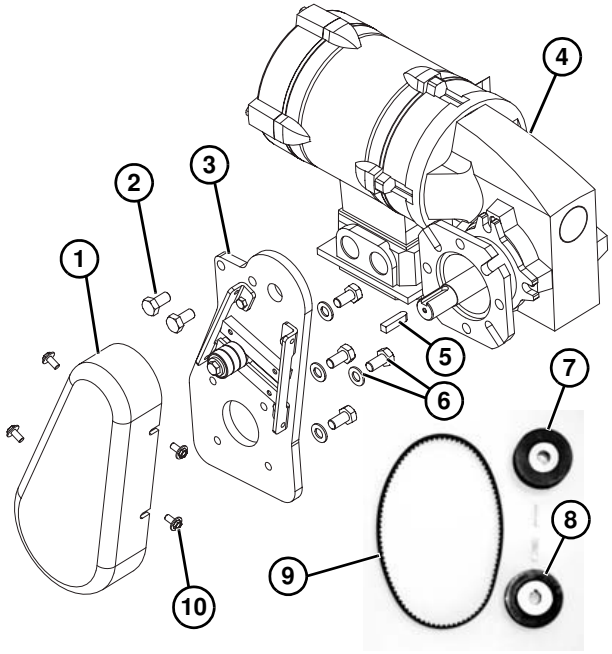


Figure 6

NOTE

Gearmotor may be operated in positions 1 through 3 ***(Figure 7)****.*

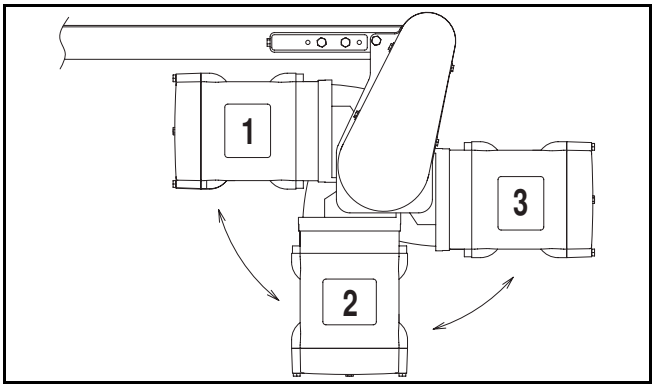


Figure 7

Drive Package Installation

- Side Mount
- Bottom 90° Mount
- Bottom Parallel Shaft Mount

Required Tools

- 2.5 mm hex wrench
- 7 mm wrench
- 8 mm wrench
- 10 mm wrench
- 13 mm wrench
- Straight edge
- Torque wrench

Side Mount End Drive Package

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

1. Install mounting bracket **(Figure 8, item 1)** onto drive end of conveyor with screw **(Figure 8, item 2)**, making sure the stud **(Figure 9, item 1)** on the back of the mounting bracket seats into the notch in the tail plate **(Figure 9, item 2)**.

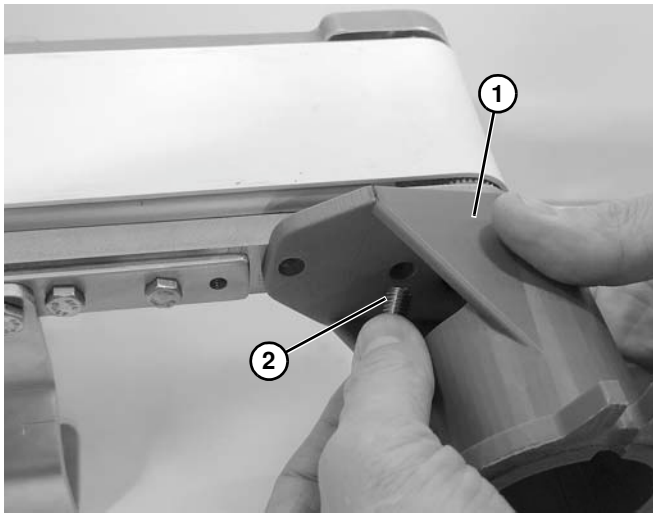


Figure 8

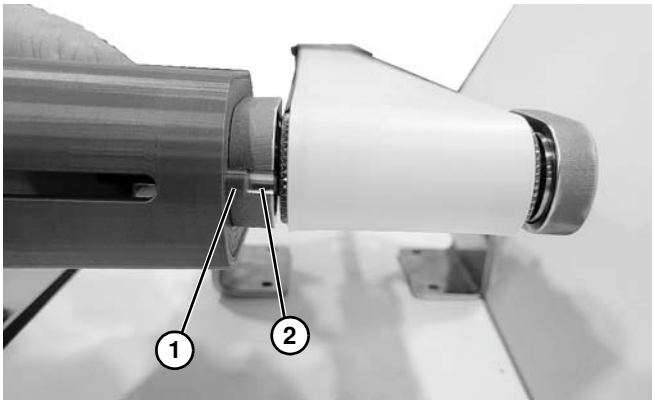


Figure 9

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

2. Insert 3 jaw coupling **(Figure 10, item 1)** onto conveyor shaft. The end of the shaft should be flush with the end of the coupling. Secure with set screw **(Figure 11, item 1)**.

Figure 10

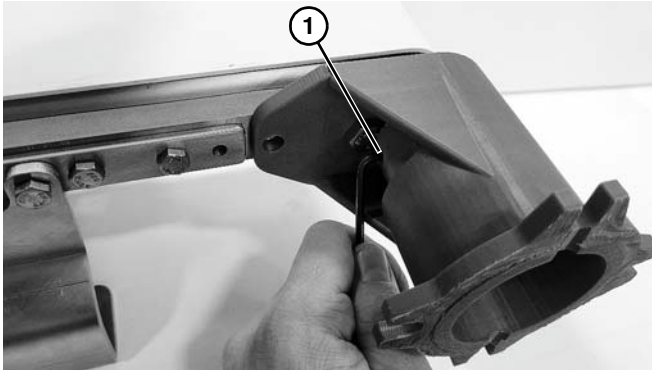


Figure 11

3. Insert spider **(Figure 12, item 1)** into 3 jaw coupling.

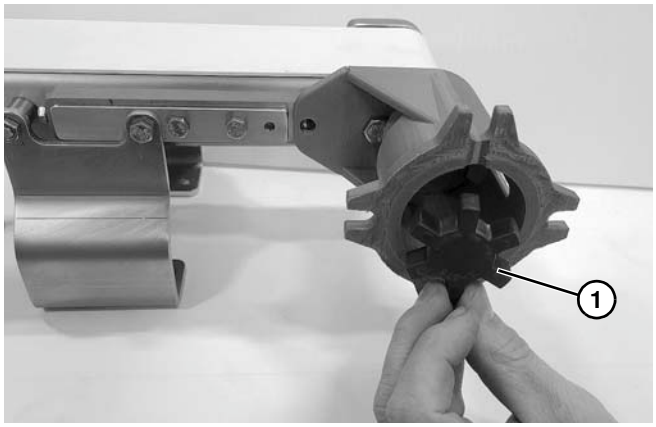


Figure 12

4. Attach angle guard **(Figure 13, item 1)** to mounting bracket **(Figure 13, item 2)** with screw **(Figure 13, item 3)**.

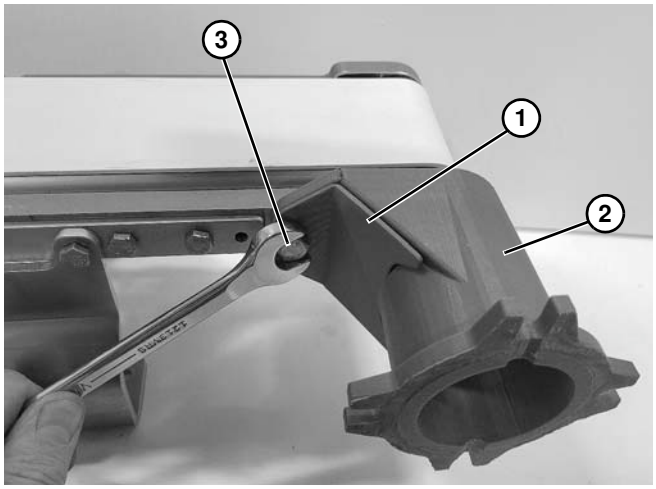


Figure 13

5. Install motor with 3 jaw coupling **(Figure 14, item 1)** onto shaft, making sure the couplings are engaged.

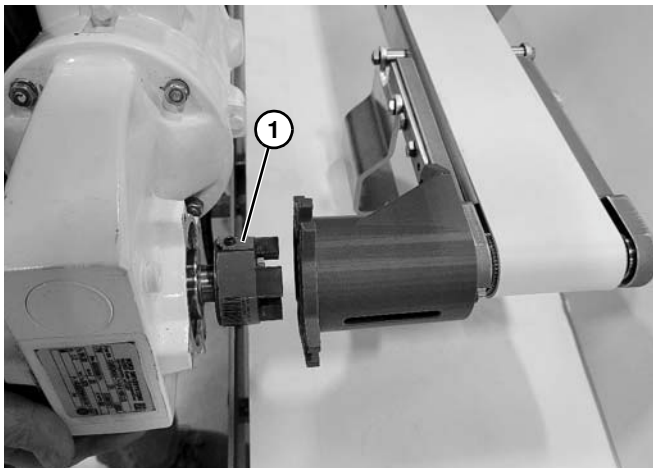


Figure 14

6. Secure gearmotor **(Figure 15, item 1)** with four screws **(Figure 15, item 2)**.

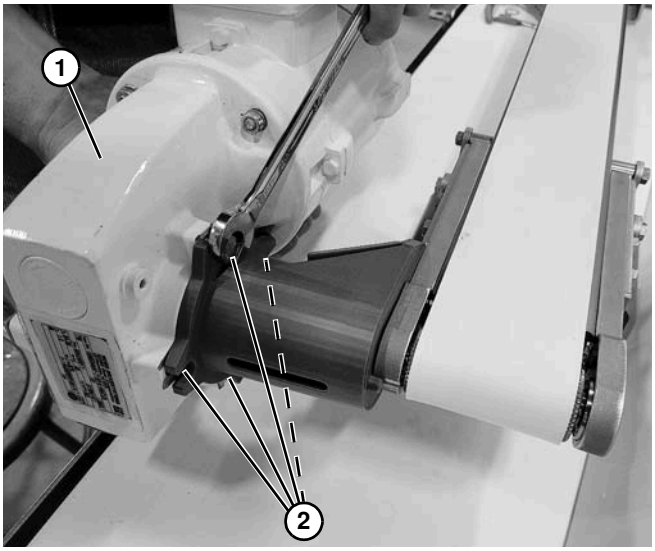


Figure 15

Side Mount Mid Drive Package

⚠ WARNING

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

1. Install mounting bracket **(Figure 16, item 1)** onto mid drive module with screw **(Figure 16, item 2)**, making sure the stud **(Figure 17, item 1)** on the back of the mounting bracket seats into the notch in the adapter plate **(Figure 17, item 2)**.

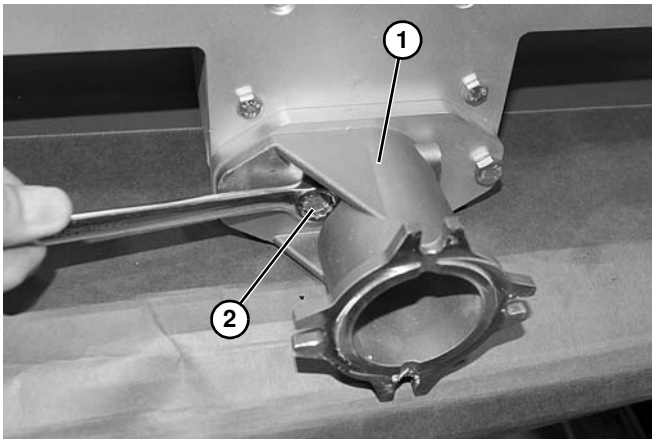


Figure 16

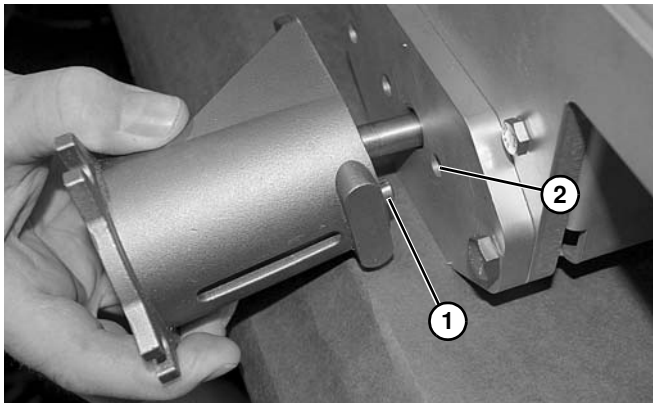


Figure 17

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

2. Insert 3 jaw coupling **(Figure 18, item 1)** onto conveyor shaft. The end of the shaft should be flush with the end of the coupling. Secure with set screw **(Figure 19, item 1)**.

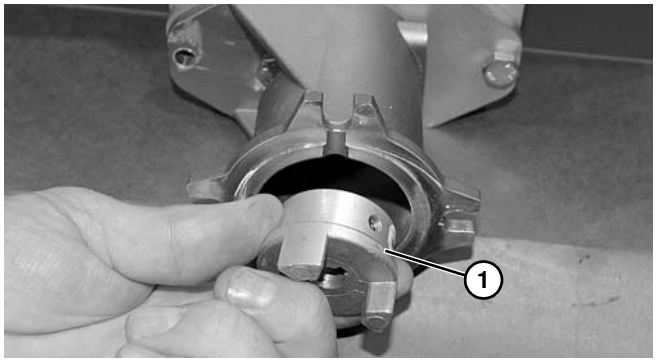


Figure 18

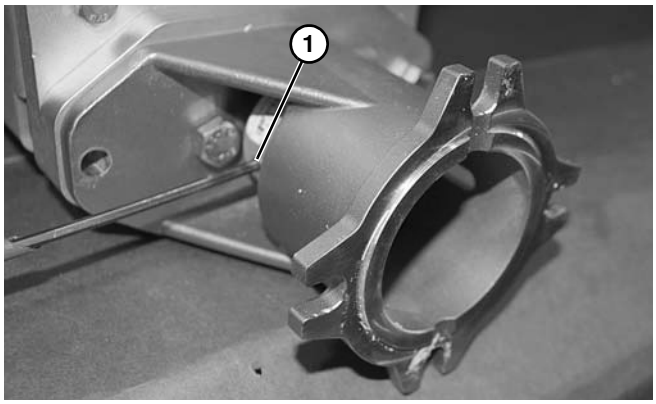


Figure 19

3. Insert spider **(Figure 20, item 1)** into 3 jaw coupling.

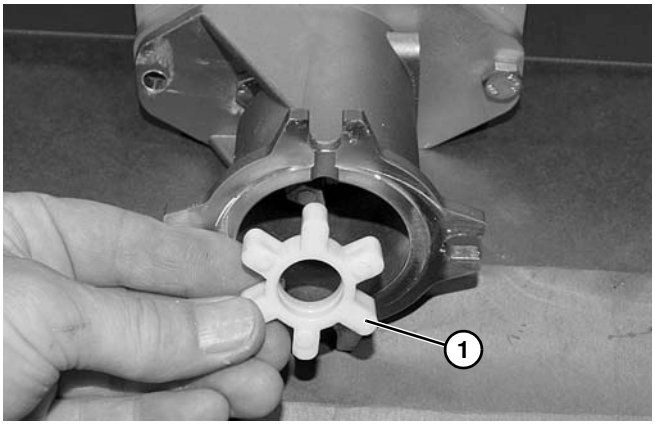


Figure 20

4. Attach angle guard **(Figure 21, item 1)** to mounting bracket **(Figure 21, item 2)** with screw **(Figure 21, item 3)**.

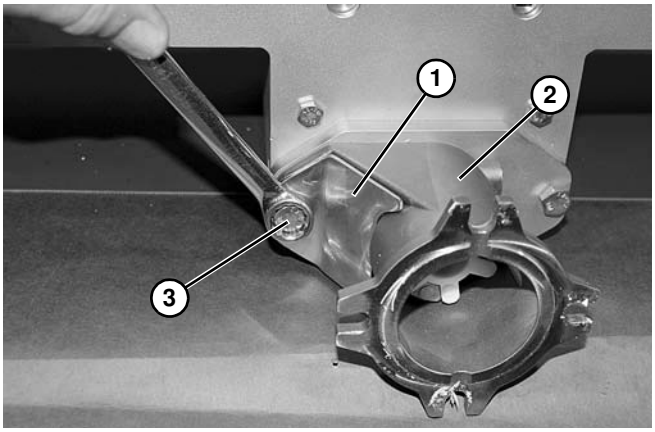


Figure 21

5. Install motor with 3 jaw coupling **(Figure 22, item 1)** onto shaft, making sure the couplings are engaged.

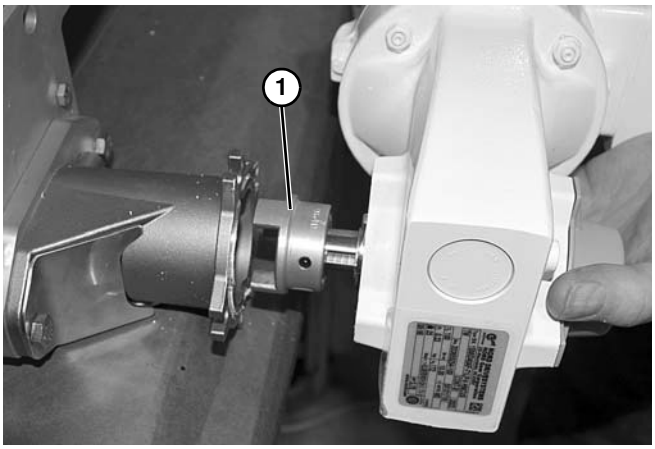


Figure 22

6. Secure gearmotor **(Figure 23, item 1)** with four screws **(Figure 23, item 2)**.

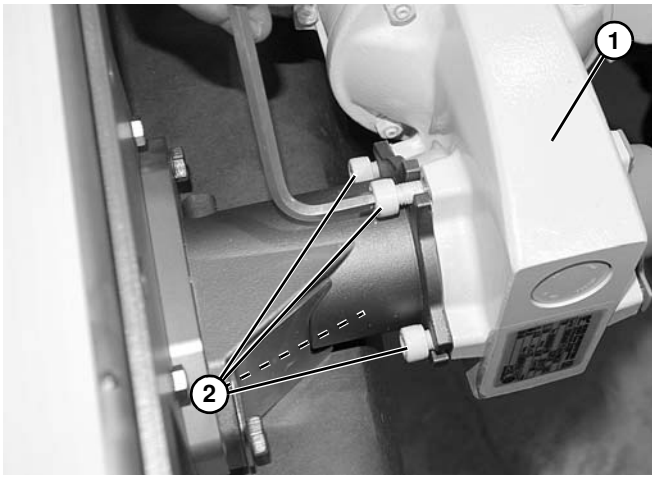


Figure 23

Bottom Mount End Drive Package

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

Drive shaft keyway may be sharp.

HANDLE WITH CARE.

1. Install mounting plate **(Figure 24, item 1)** onto drive end of conveyor with two screws **(Figure 25, item 1)**.

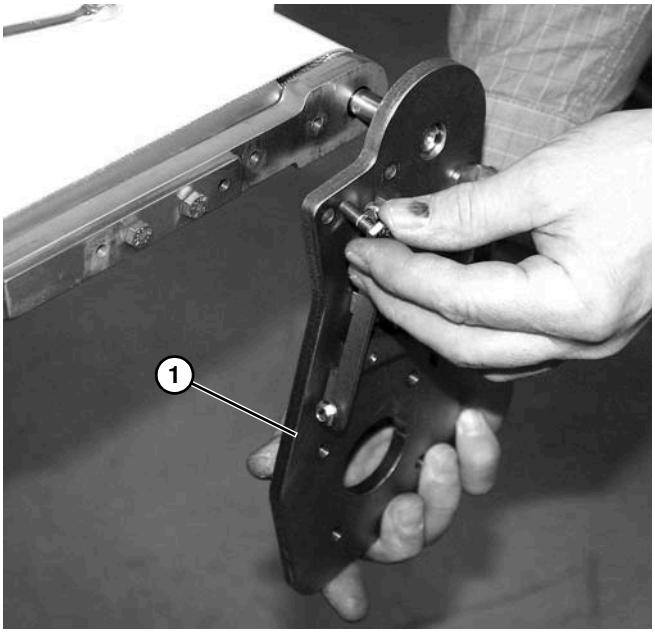


Figure 24

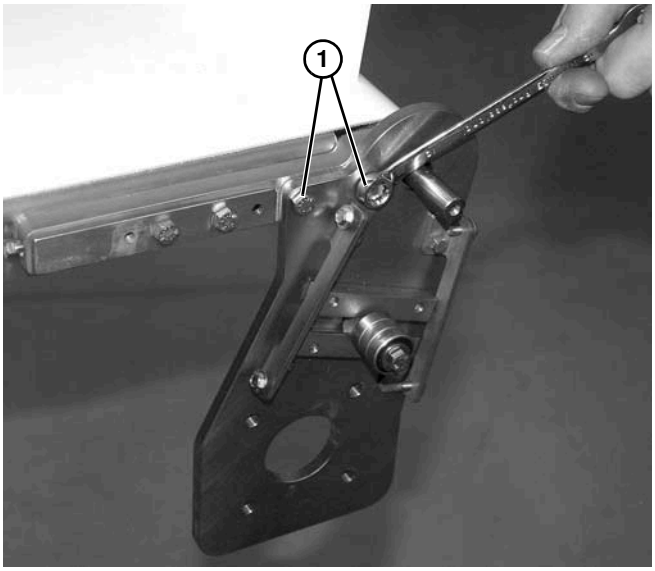


Figure 25

NOTE

*Bottom 90° mount gearmotors should be oriented with the gear head up **(Figure 26)** for flat belt conveyors, and gear head down **(Figure 27)** for cleated belt conveyors.*

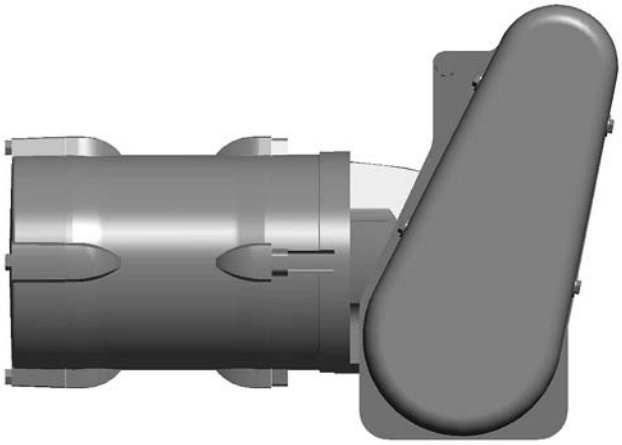


Figure 26

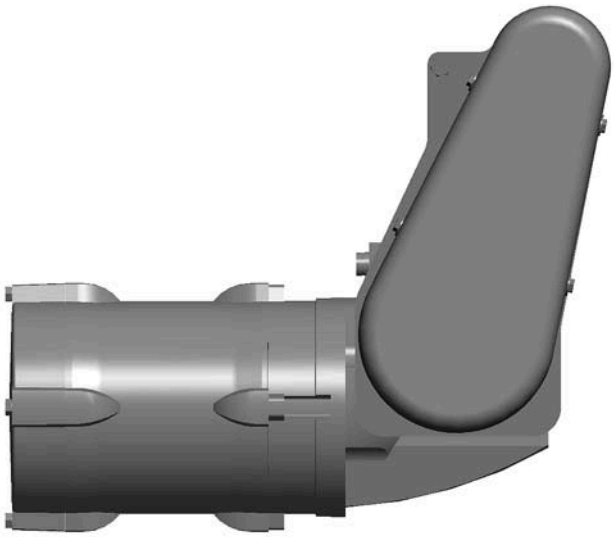


Figure 27

2. Install gearmotor **(Figure 28, item 1)** onto mounting plate **(Figure 28, item 2)** with four screws and washers **(Figure 29, item 1)**.

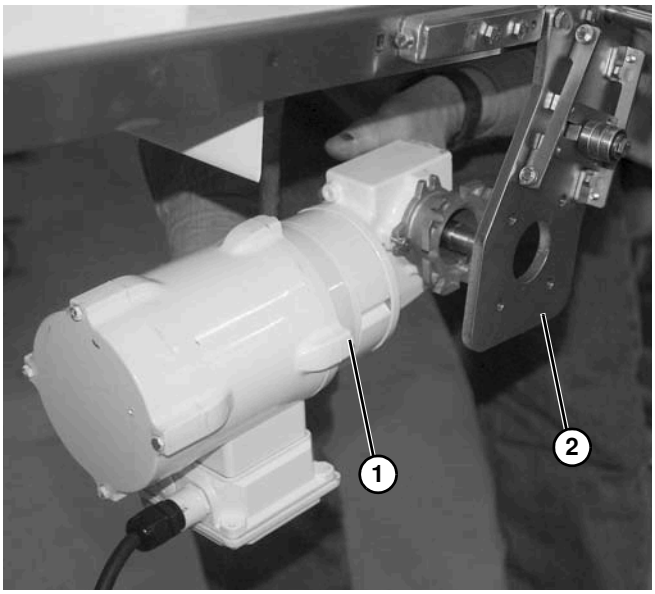


Figure 28

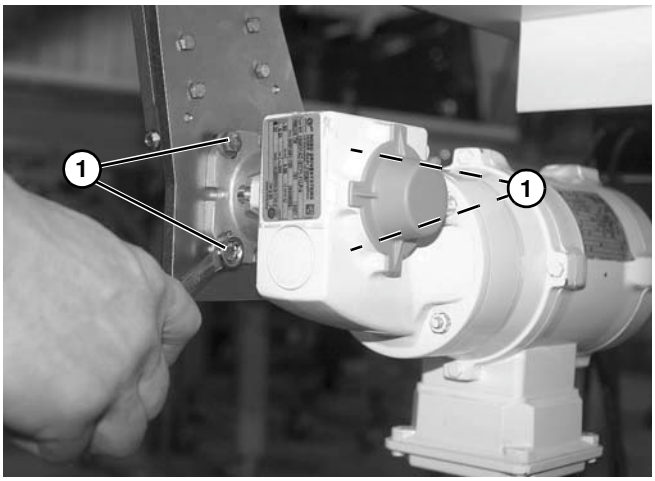


Figure 29

3. Install timing belt or timing chain, see "Timing Belt" on page 11 or "Timing Chain" on page 13.

Bottom Mount Mid Drive Package

⚠ WARNING

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

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

1. Install mounting plate **(Figure 30, item 1)** onto drive end of conveyor with two screws **(Figure 30, item 2)**.

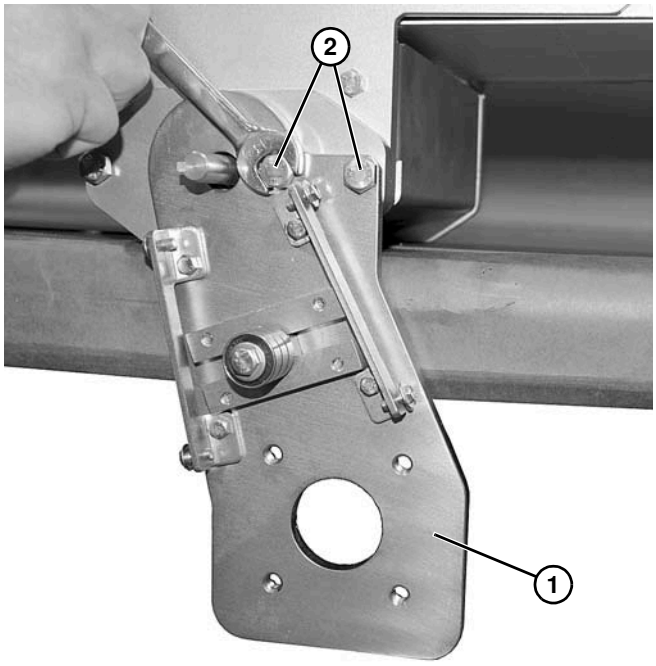


Figure 30

2. Install gearmotor **(Figure 31, item 1)** onto mounting plate **(Figure 31, item 2)** with four screws and washers **(Figure 32, item 1)**.

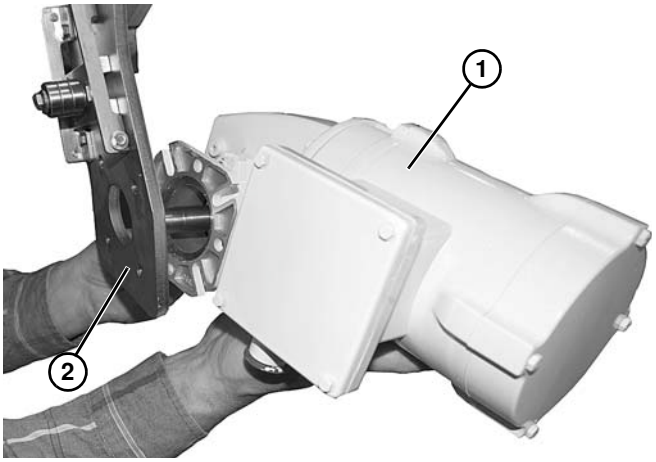


Figure 31

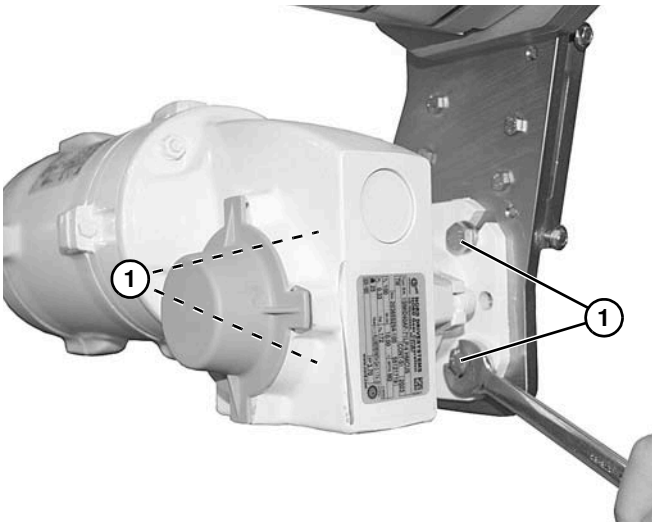


Figure 32

3. Install timing belt or timing chain, see "Timing Belt" on page 11 or "Timing Chain" on page 13.

Timing Belt

NOTE

*Make sure sprocket keys are installed on conveyor input shaft **(Figure 33, item 4)** and gearmotor output shaft **(Figure 33, item 5)**.*

1. Install timing belt **(Figure 33, item 1)** over drive sprocket **(Figure 33, item 2)** and driven sprocket **(Figure 33, item 3)**. Install timing belt and sprockets on conveyor input shaft **(Figure 33, item 4)** and gearmotor output shaft **(Figure 33, item 5)**. Do not tighten sprocket set screws.

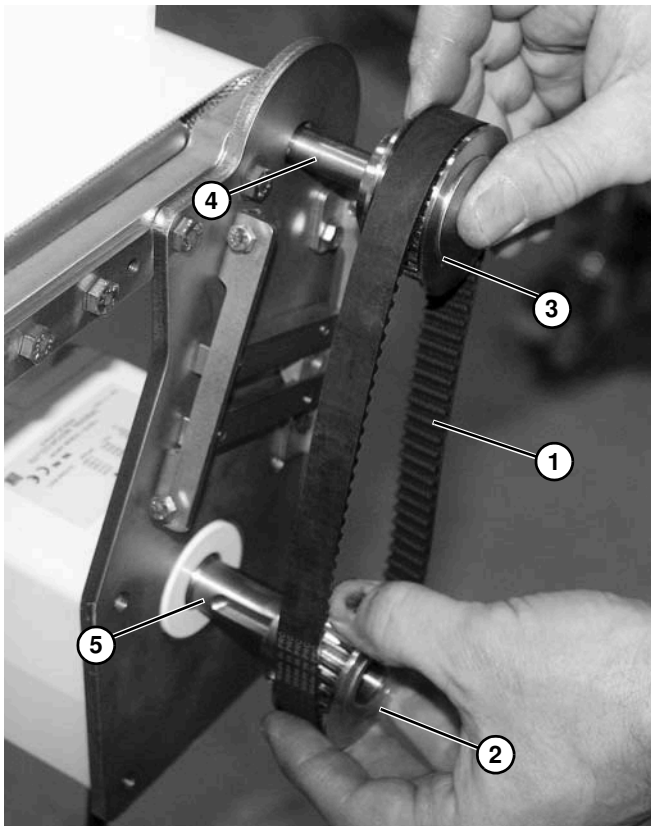


Figure 33

IMPORTANT

*Using a straight edge **(Figure 34, item 1)**, make sure drive sprocket **(Figure 34, item 2)** aligns with driven sprocket **(Figure 34, item 3)**. Tighten drive and driven sprocket set screws.*

- *If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.*
- *If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.*

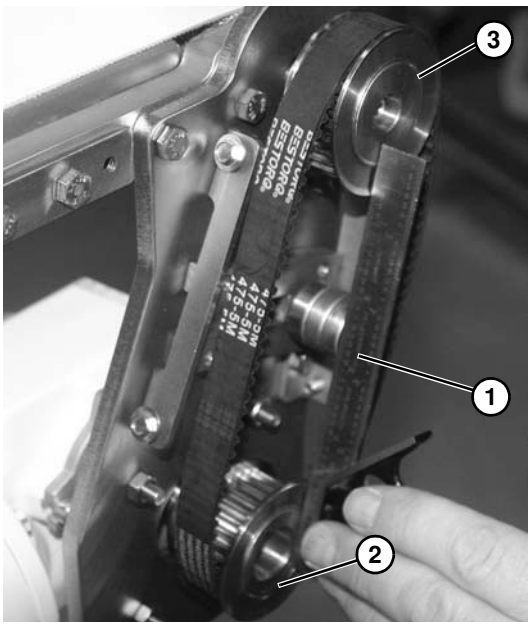


Figure 34

2. Depending on conveyor belt travel (direction A or B of **Figure 35**), locate timing belt tensioner **(Figure 35, item 1)** as shown. Do not tighten tensioner screw. Tension timing belt to obtain 3 mm (1/8") deflection for 4.3 N (1.0 lb) of force at timing belt mid-point **(Figure 35, item 2)**. Tighten tensioner screw **(Figure 36, item 1)**.

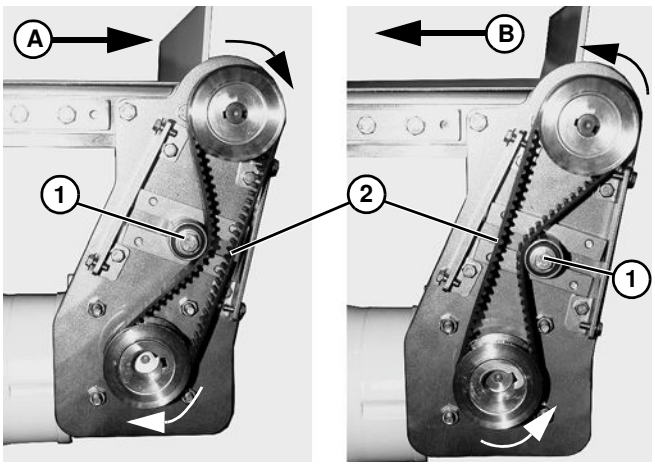


Figure 35

Figure 36

NOTE

*Do not over-tighten screws **(Figure 37, item 2)**.*

3. Install cover **(Figure 37, item 1)** and tighten four screws **(Figure 37, item 2)**.

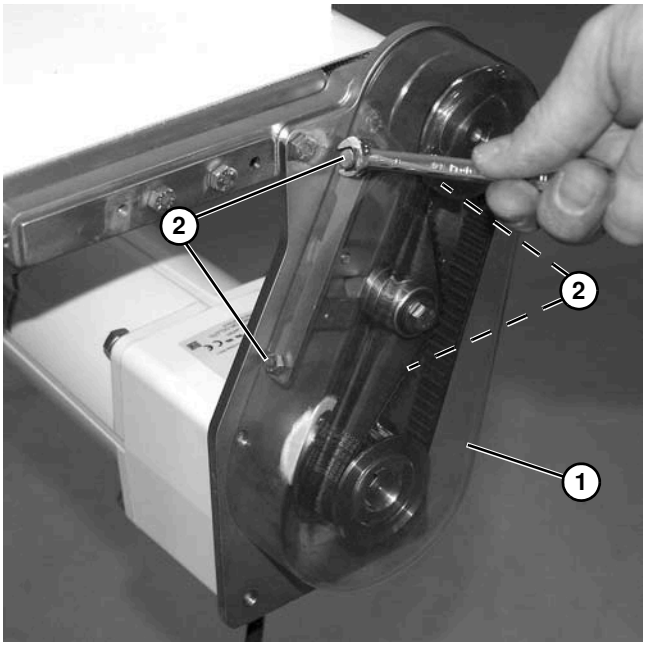


Figure 37

Timing Chain

NOTE

*Make sure sprocket keys are installed on conveyor input shaft **(Figure 38, item 4)** and gearmotor output shaft **(Figure 38, item 5)**.*

1. Install timing chain **(Figure 38, item 1)** over drive sprocket **(Figure 38, item 2)** and driven sprocket **(Figure 38, item 3)**. Install timing chain and sprockets on conveyor input shaft **(Figure 38, item 4)** and gearmotor output shaft **(Figure 38, item 5)**. Do not tighten sprocket set screws.

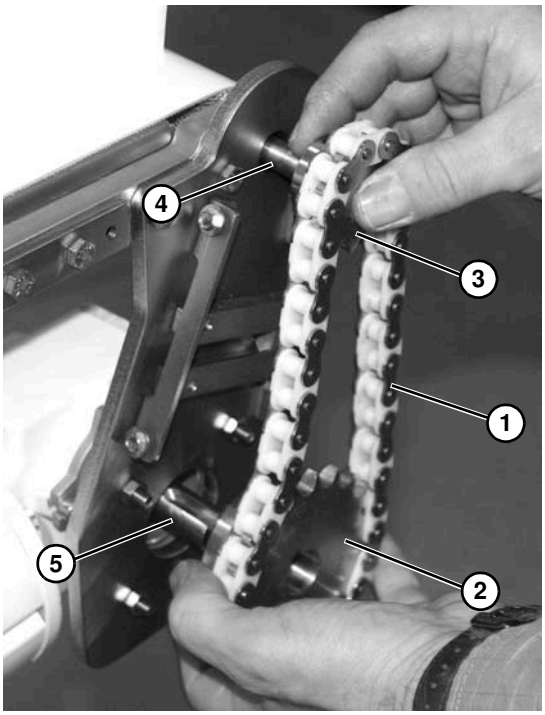


Figure 38

IMPORTANT

*Using a straight edge **(Figure 39, item 1)**, make sure drive sprocket **(Figure 39, item 2)** aligns with driven sprocket **(Figure 39, item 3)**. Tighten drive and driven sprocket set screws **(Figure 40, item 1)**.*

- *If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.*
- *If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.*

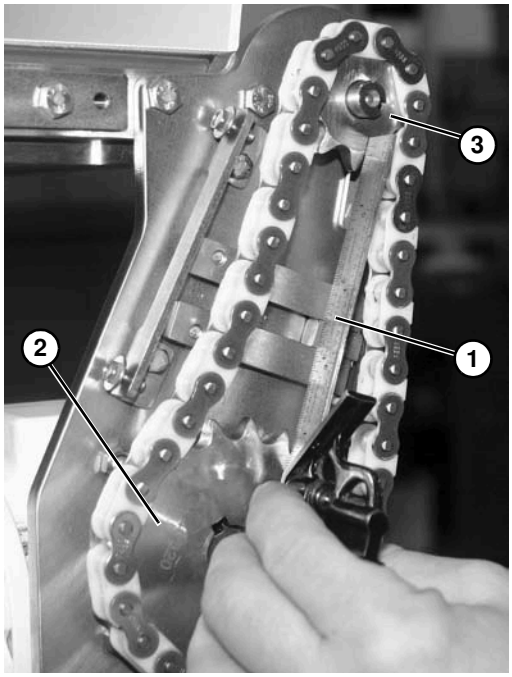


Figure 39

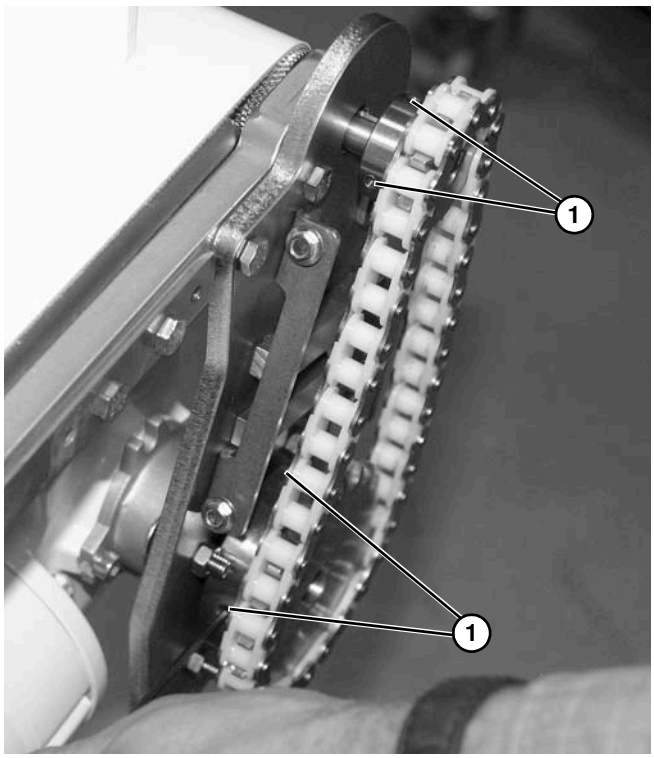


Figure 40

2. Depending on conveyor belt travel (direction A or B of **Figure 41**), locate timing chain tensioner **(Figure 41, item 1)** as shown. Do not tighten tensioner screw.

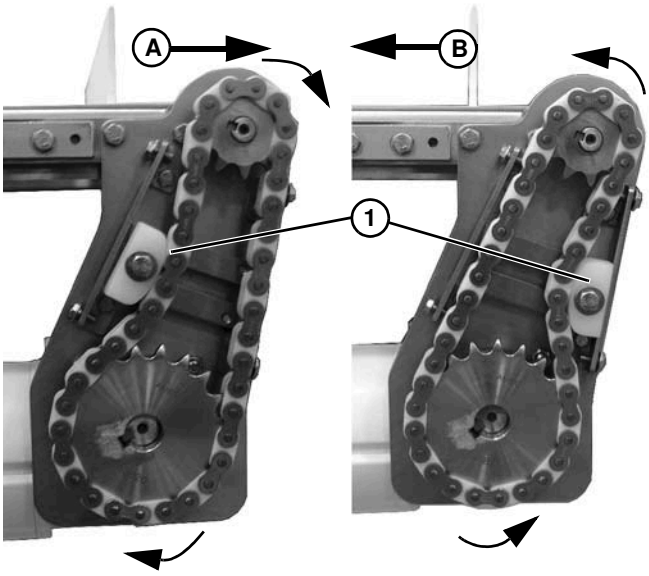


Figure 41

3. Install screw and washer **(Figure 42, item 1)**, timing chain tensioner **(Figure 42, item 2)**, and spacer **(Figure 42, item 3)** onto drive mounting bracket.

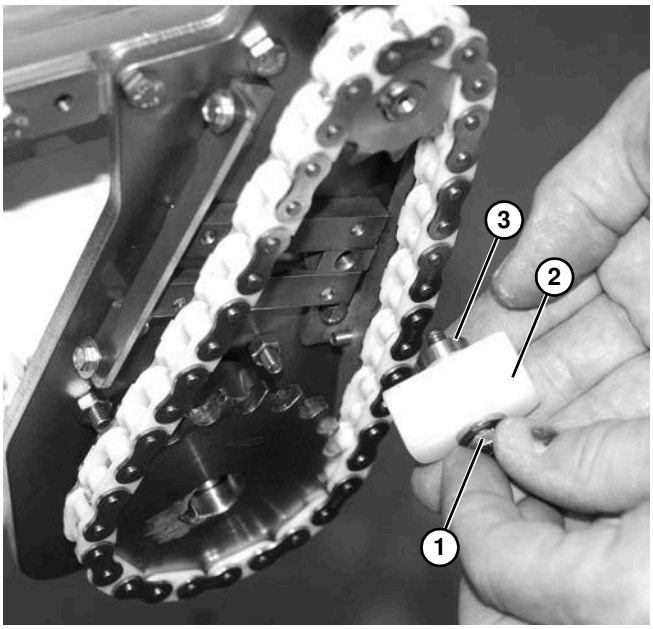


Figure 42

NOTE
Do not overtension chain. Only tension chain until slack is removed.

4. Slide chain tensioner **(Figure 43, item 1)** to take up chain slack. Tighten chain tensioner screw **(Figure 43, item 2)**.

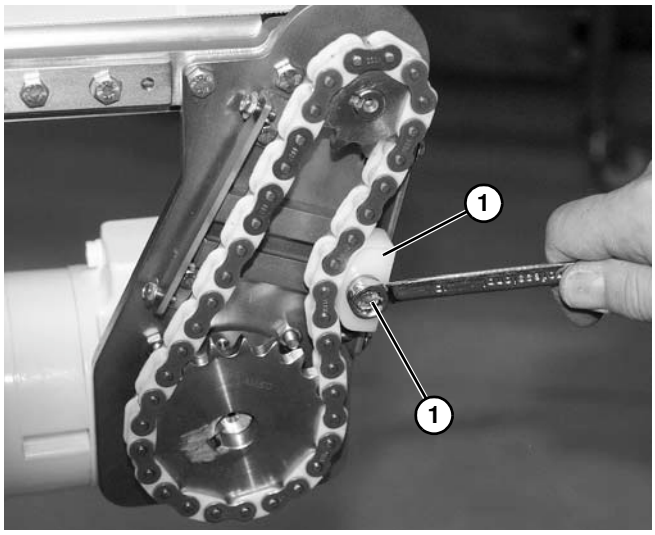


Figure 43

NOTE
*Do not over-tighten screws **(Figure 44, item 2)**.*

5. Install cover **(Figure 44, item 1)** and tighten four screws **(Figure 44, item 2)**.

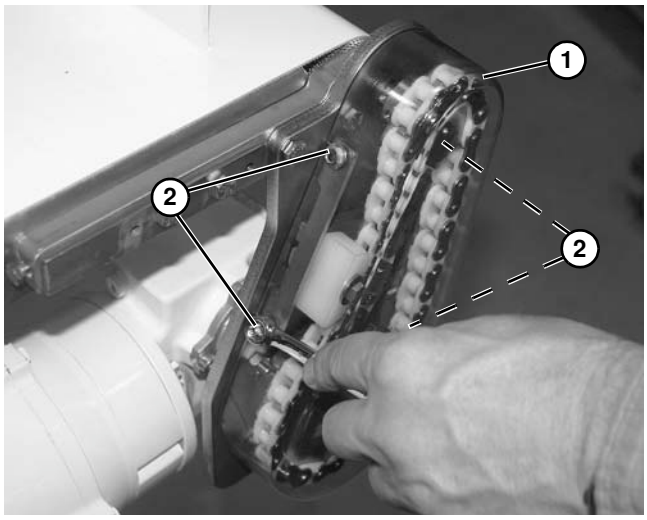


Figure 44

Required Tools

- 2.5 mm hex wrench
- 7 mm wrench
- 8 mm wrench
- 10 mm wrench
- 13 mm wrench
- Straight edge
- Torque wrench

Check List

- Keep critical service parts on hand. Refer to "Service Parts" on page 25 for recommendations.
- Replace any worn or damaged parts.

Timing Belt or Chain Replacement

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Replace timing belt or chain following instructions:

- A – Timing Belt Replacement
- B – Timing Chain Replacement

A – Timing Belt Replacement

1. Loosen four screws **(Figure 45, item 1)** securing cover **(Figure 45, item 2)**.

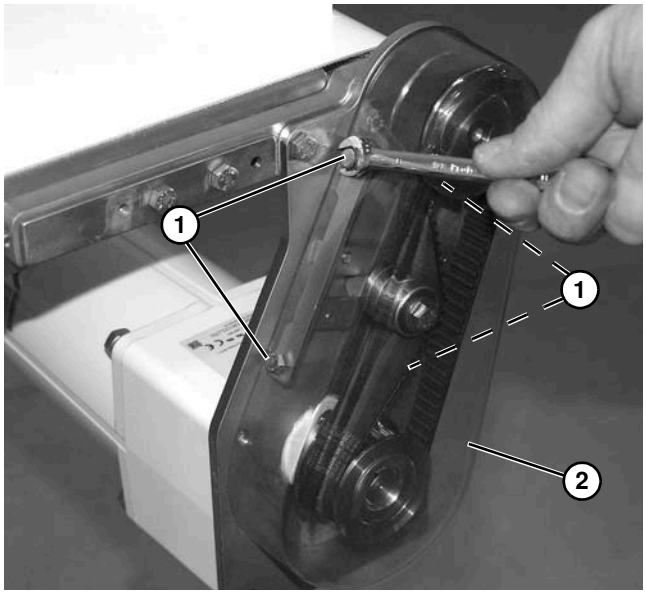


Figure 45

2. Remove cover **(Figure 45, item 1)**.
3. Loosen tensioner **(Figure 46, item 1)**.

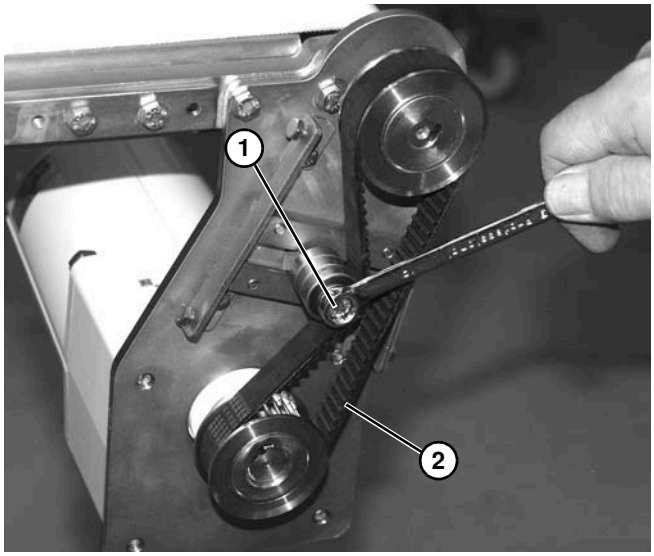


Figure 46

4. Remove timing belt **(Figure 46, item 2)**.

NOTE

*If timing belt does not slide over pulley flange, loosen two drive pulley set screws **(Figure 47, item 1)** and driven pulley set screws **(Figure 47, item 2)**, and remove both pulleys with belt **(Figure 48)**. Make sure to retain sprocket keys.*

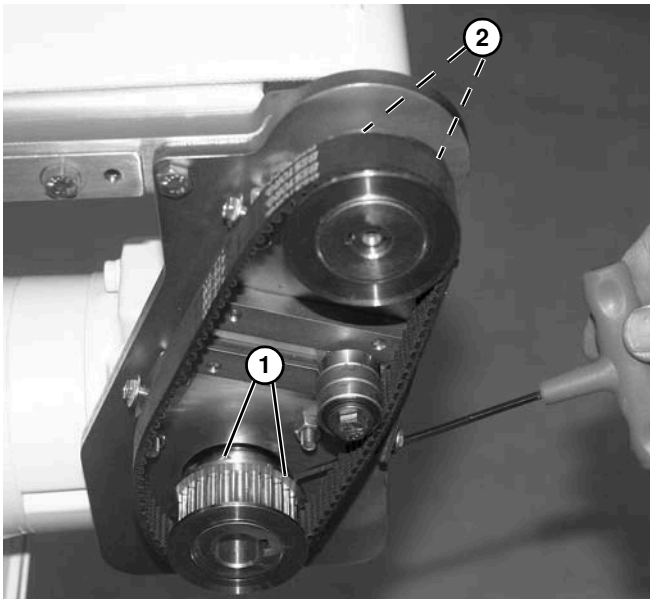


Figure 47

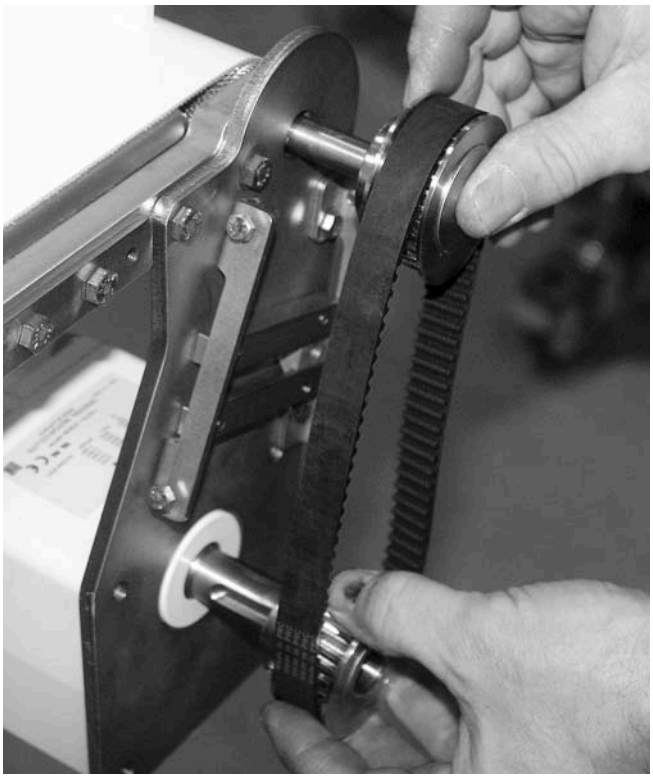


Figure 48

5. Replace components, as needed **(Figure 49)**.

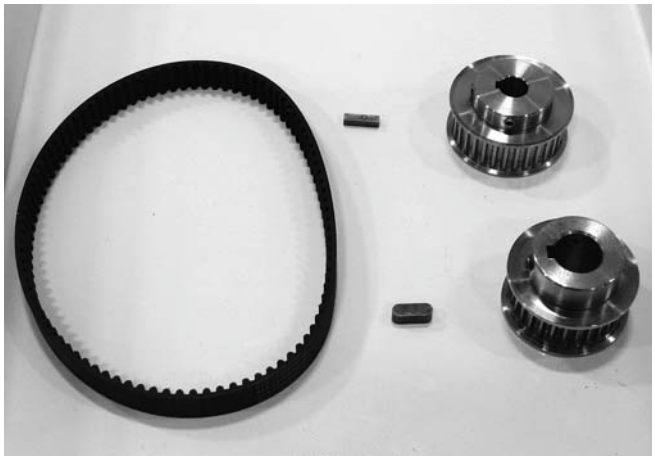


Figure 49

NOTE

*Make sure sprocket keys are installed on conveyor input shaft **(Figure 50, item 4)** and gearmotor output shaft **(Figure 50, item 5)**.*

6. Install new timing belt **(Figure 50, item 1)** over drive sprocket **(Figure 50, item 2)** and driven sprocket **(Figure 50, item 3)**. Install timing belt and sprockets on conveyor input shaft **(Figure 50, item 4)** and gearmotor output shaft **(Figure 50, item 5)**. Do not tighten sprocket set screws.

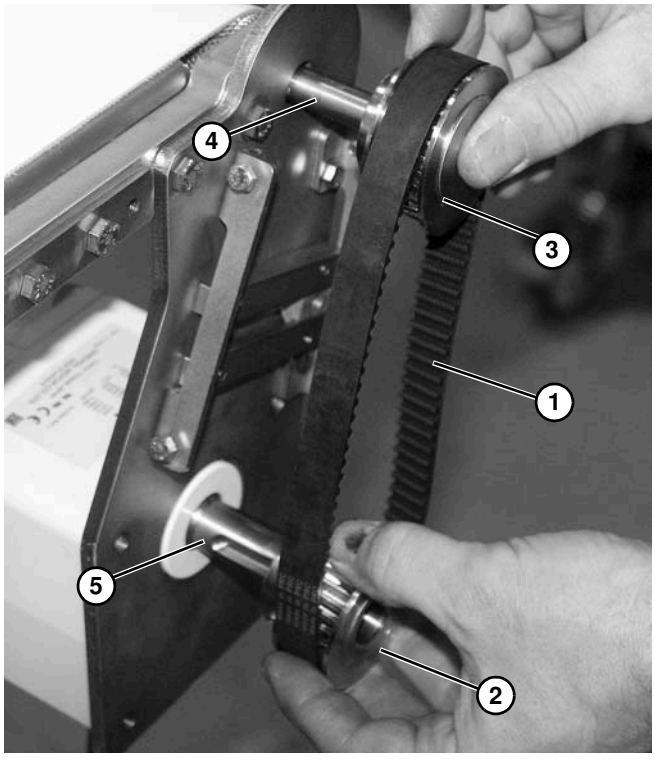


Figure 50

IMPORTANT

*Using a straight edge **(Figure 51, item 1)**, make sure drive sprocket **(Figure 51, item 2)** aligns with driven sprocket **(Figure 51, item 3)**. Tighten drive and driven sprocket set screws.*

- *If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.*
- *If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.*

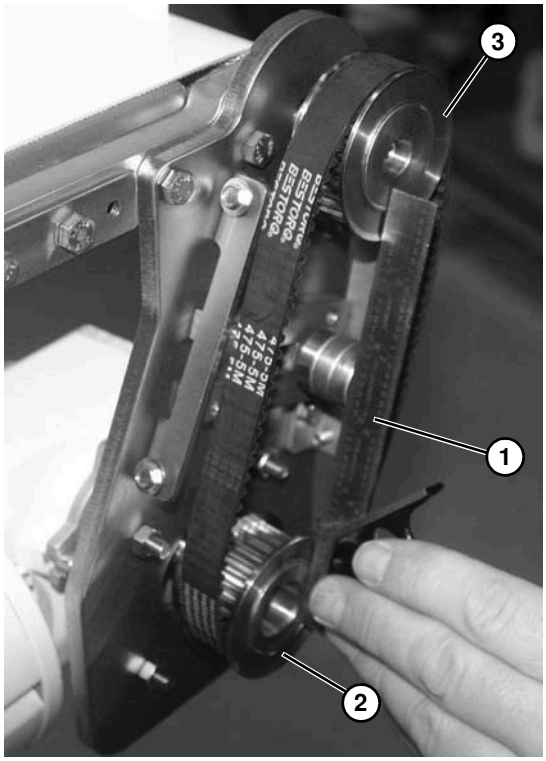


Figure 51

7. Depending on conveyor belt travel (direction A or B of **Figure 52**), locate timing belt tensioner **(Figure 52, item 1)** as shown. Tension timing belt to obtain 3 mm (1/8") deflection for 4.3 N (1.0 lb) of force at timing belt mid-point **(Figure 52, item 2)**. Tighten tensioner screw **(Figure 53, item 1)**.

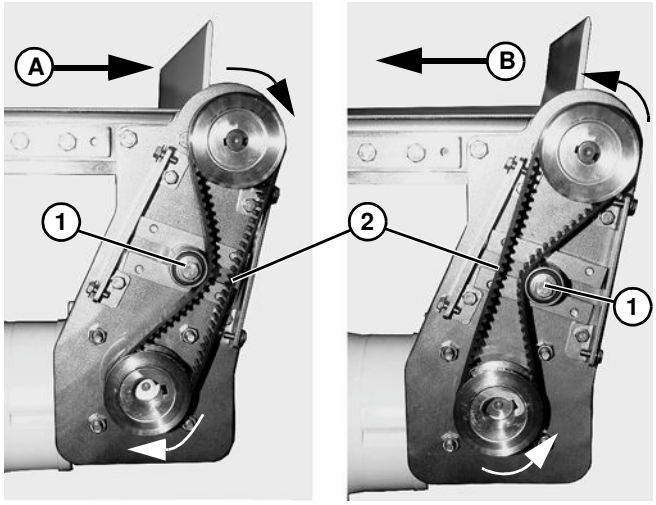


Figure 52

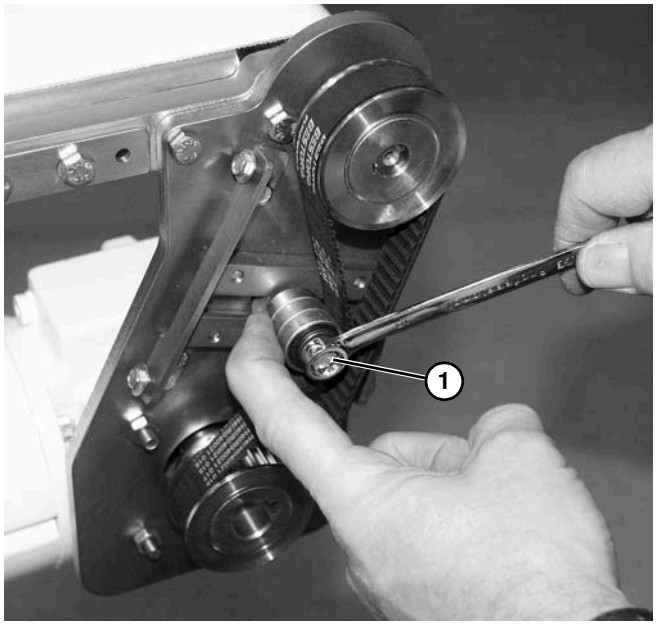


Figure 53

NOTE

Do not over-tighten screws ***(Figure 54, item 2)****.*

8. Install cover **(Figure 54, item 1)** and tighten four screws **(Figure 54, item 2)**.

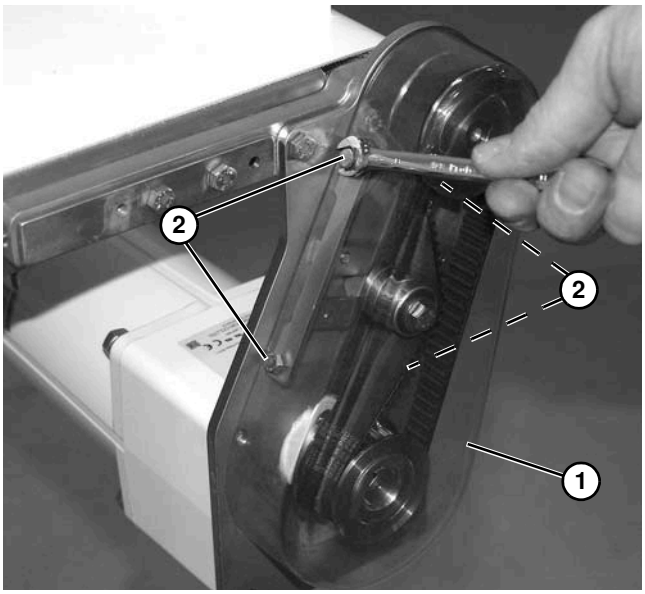


Figure 54

B – Timing Chain Replacement

1. Loosen four screws **(Figure 55, item 1)** securing cover **(Figure 55, item 2)**.

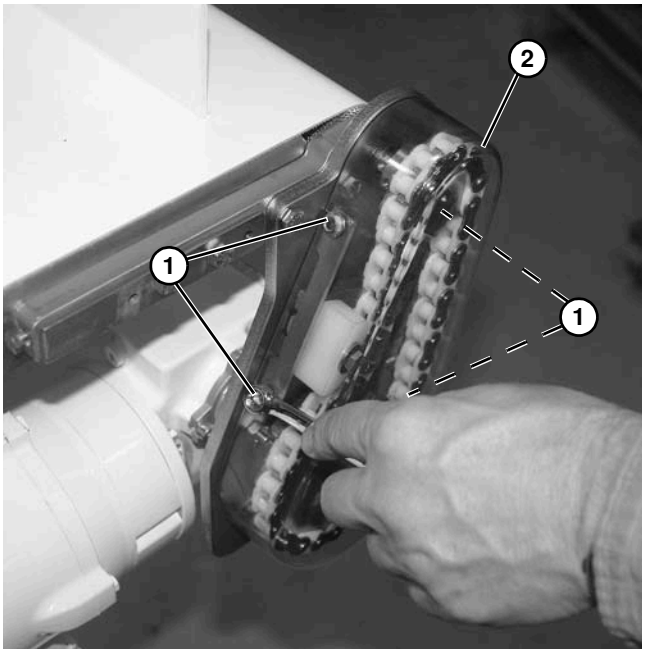


Figure 55

2. Remove cover **(Figure 56, item 1)**.

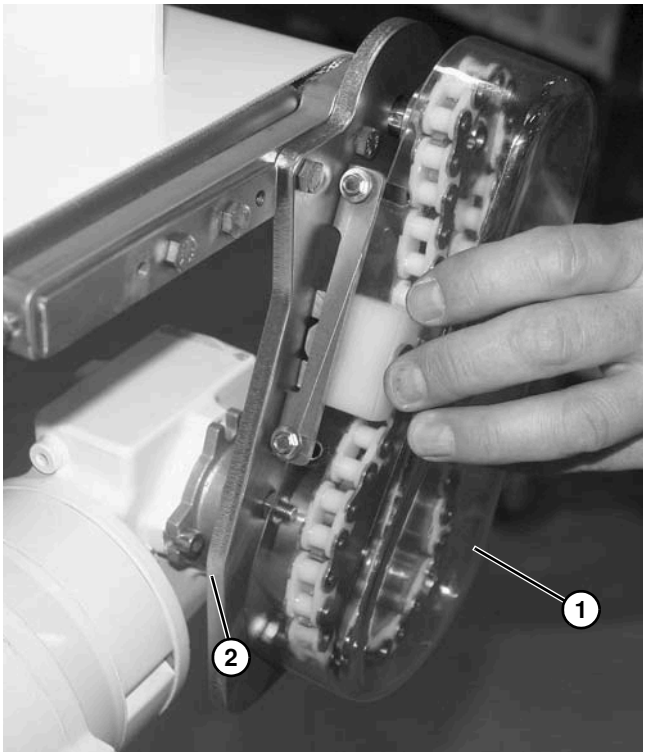


Figure 56

3. Remove timing chain tensioner screw **(Figure 57, item 1)**.

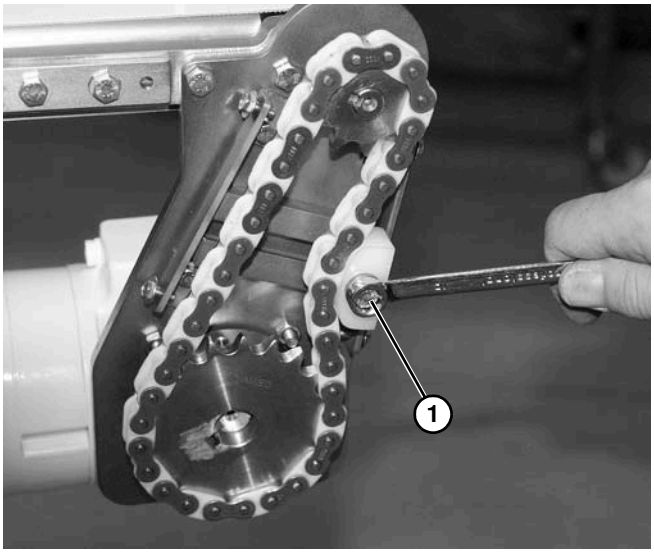


Figure 57

4. Remove screw and washer **(Figure 58, item 1)**, timing chain tensioner **(Figure 58, item 2)**, and spacer **(Figure 58, item 3)** from drive mounting bracket.

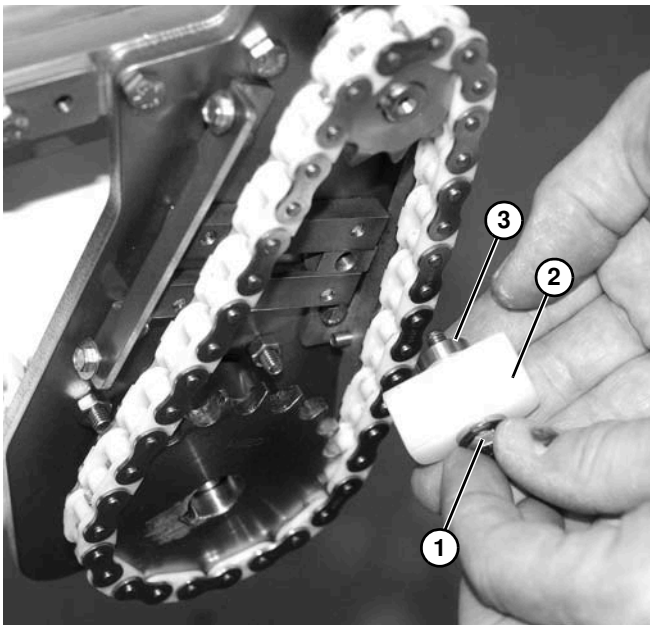


Figure 58

5. Loosen four set screws **(Figure 59, item 1)**.

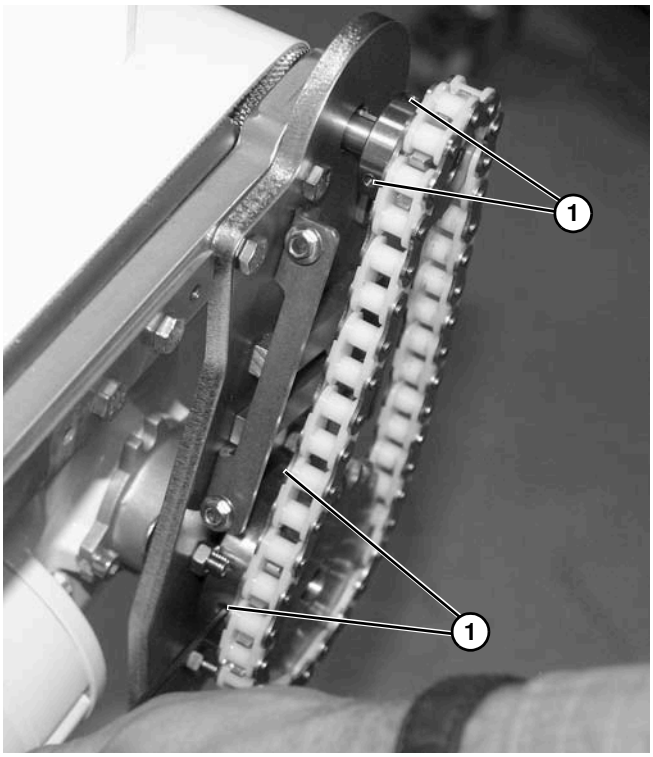


Figure 59

6. Remove timing chain **(Figure 60, item 1)** along with drive sprocket **(Figure 60, item 2)** and driven sprocket **(Figure 60, item 3)** from conveyor input shaft **(Figure 60, item 4)** and gearmotor output shaft **(Figure 60, item 5)**. Make sure to retain sprocket keys.

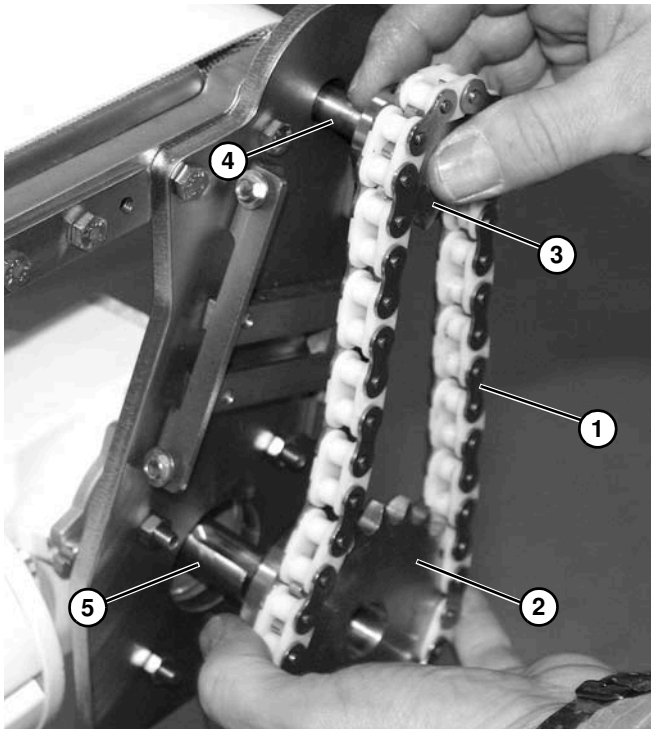


Figure 60

7. Replace components, as needed **(Figure 61)**.

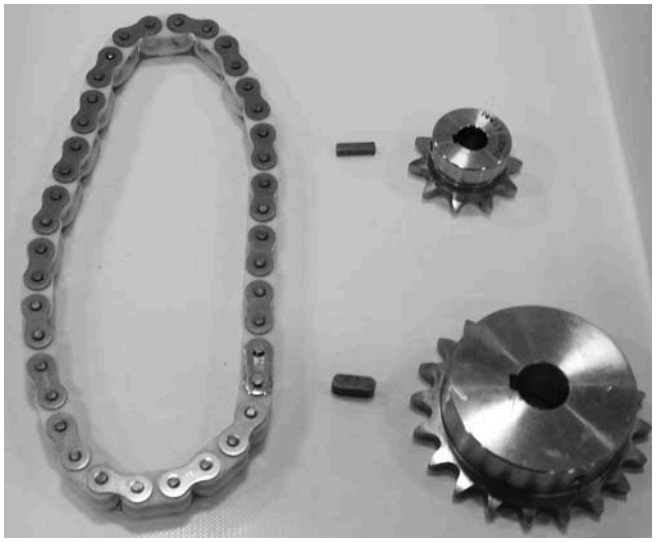


Figure 61

NOTE

*Make sure sprocket keys are installed on conveyor input shaft **(Figure 62, item 4)** and gearmotor output shaft **(Figure 62, item 5)**.*

8. Install new timing chain **(Figure 62, item 1)** over drive sprocket **(Figure 62, item 2)** and driven sprocket **(Figure 62, item 3)**. Install timing chain and sprockets on conveyor input shaft **(Figure 62, item 4)** and gearmotor output shaft **(Figure 62, item 5)**. Do not tighten sprocket set screws.

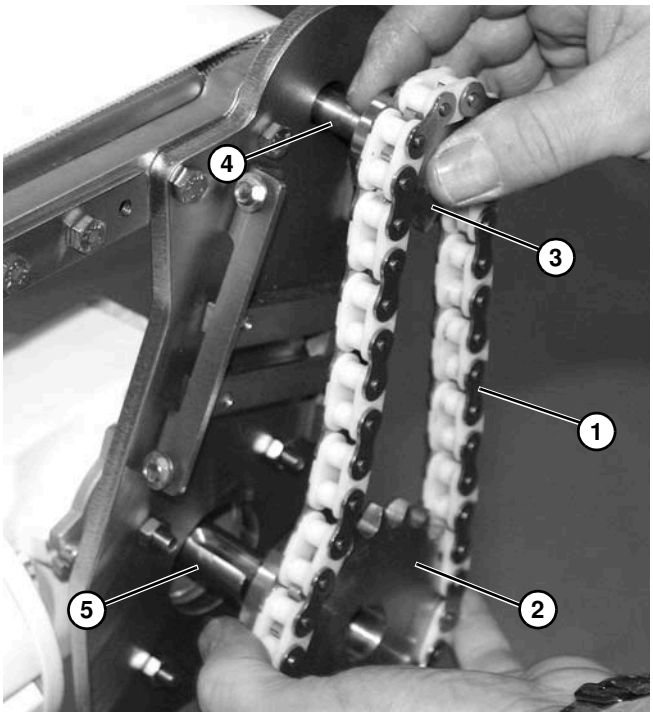


Figure 62

IMPORTANT

*Using a straight edge **(Figure 63, item 1)**, make sure drive sprocket **(Figure 63, item 2)** aligns with driven sprocket **(Figure 63, item 3)**. Tighten drive and driven sprocket set screws.*

- *If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.*
- *If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.*

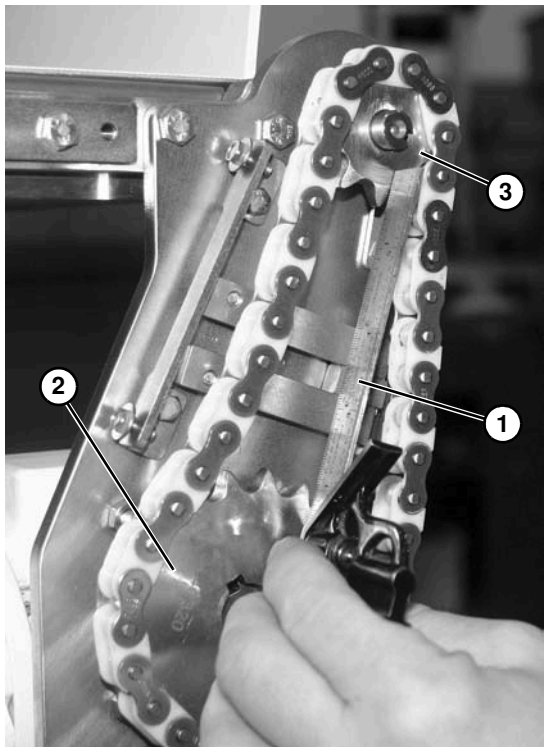


Figure 63

9. Depending on conveyor belt travel (direction A or B of **Figure 64**), locate timing chain tensioner **(Figure 64, item 1)** as shown. Do not tighten tensioner screw.

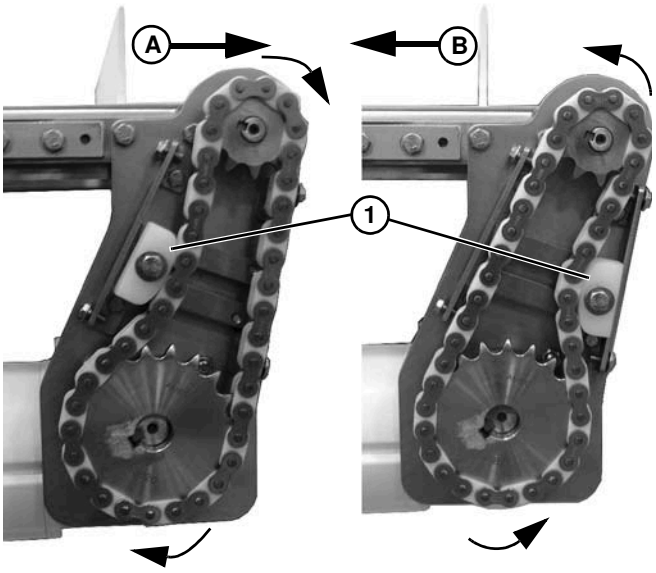


Figure 64

10. Install screw and washer **(Figure 65, item 1)**, timing chain tensioner **(Figure 65, item 2)**, and spacer **(Figure 65, item 3)** onto drive mounting bracket.

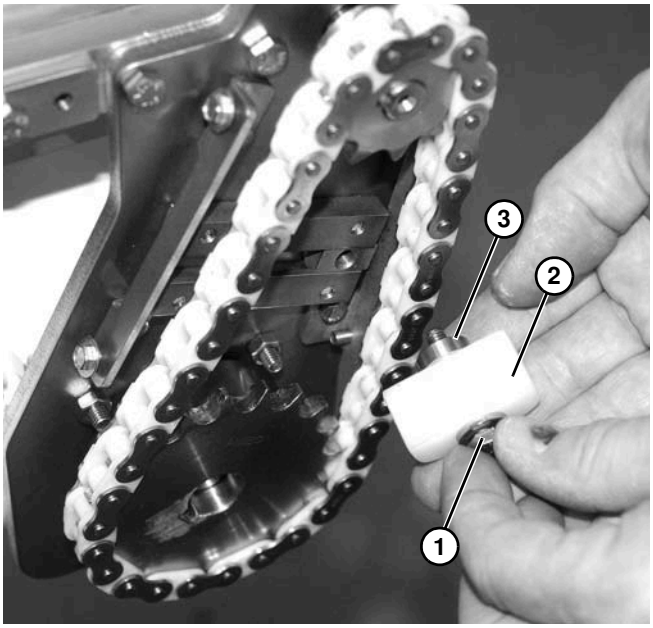


Figure 65

NOTE

Do not overtension chain. Only tension chain until slack is removed.

11. Slide chain tensioner **(Figure 66, item 1)** to take up chain slack. Tighten chain tensioner screw **(Figure 66, item 2)**.

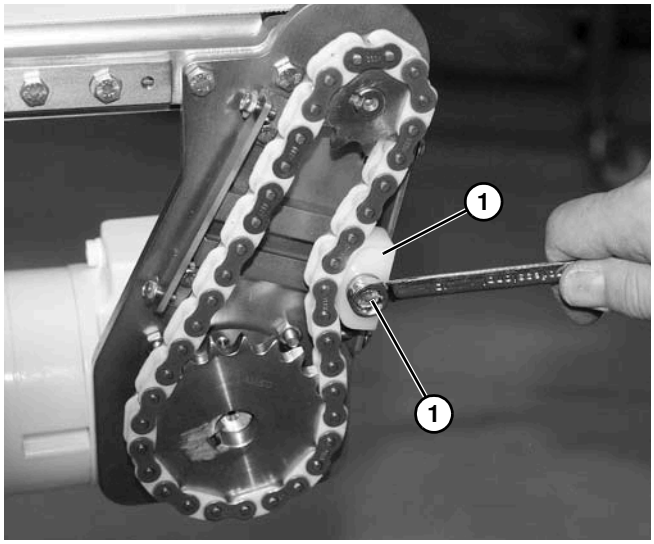


Figure 66

NOTE

Do not over-tighten screws ***(Figure 67, item 2)****.*

12. Install cover **(Figure 67, item 1)** and tighten four screws **(Figure 67, item 2)**.

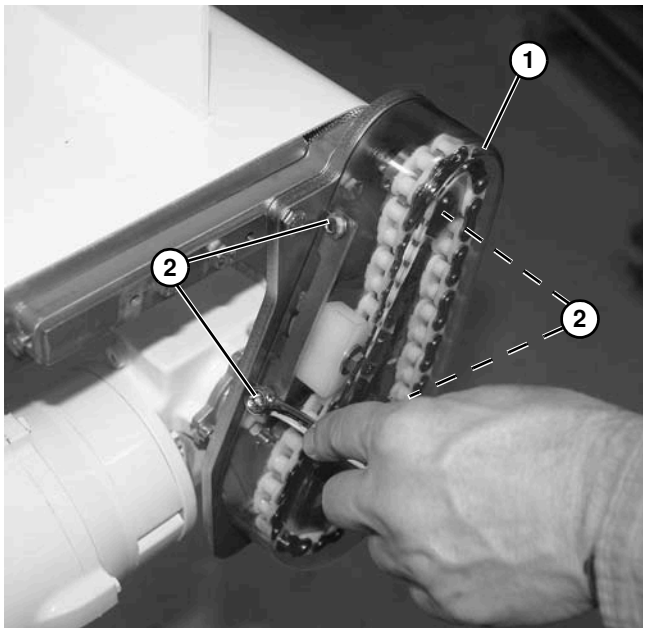


Figure 67

Timing Belt or Chain Tensioning

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

NOTE

Figure 68 *through* ***Figure 71*** *shows tensioning procedure for a timing belt. Tensioning a timing chain is similar except as noted.*

1. Loosen four (4) screws **(Figure 68, item 1)** and remove cover **(Figure 68, item 2)**.

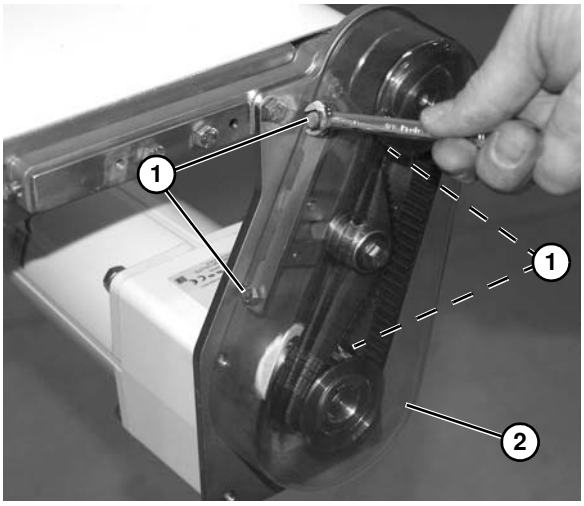


Figure 68

2. Loosen tensioner **(Figure 69, item 1)**.

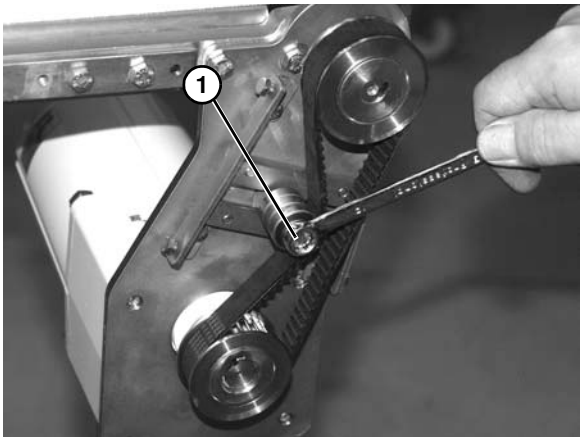


Figure 69

3. Depending on direction of conveyor belt travel (A or B of **Figure 70**), position belt tensioner **(Figure 70, item 1)** as shown.

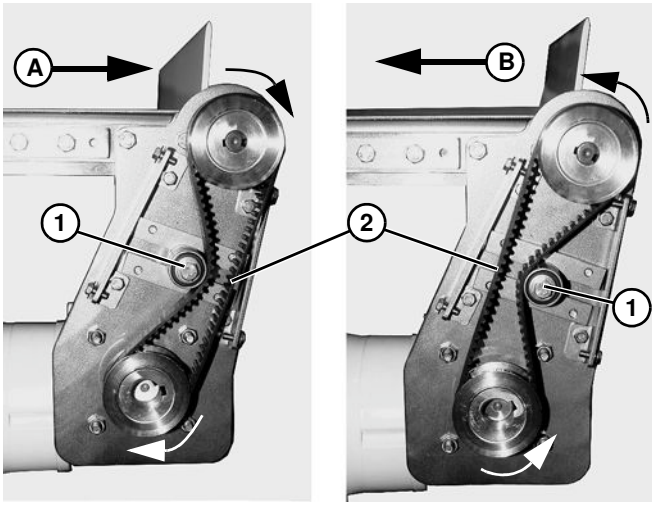


Figure 70

Figure 71

4. Tension belt or chain:

   a. Tension belt to obtain 3 mm (1/8") deflection for 4.3 N (1.0 lb) of force at belt mid-point **(Figure 70, item 2)**. Tighten tensioner screw **(Figure 71, item 1)**.

NOTE

*Do not overtension chain **(Figure 72, item 3)**. Only tension chain until slack is removed.*

b. Slide chain tensioner **(Figure 72, item 1)** to take up chain slack. Tighten chain tensioner screw **(Figure 72, item 2)**.

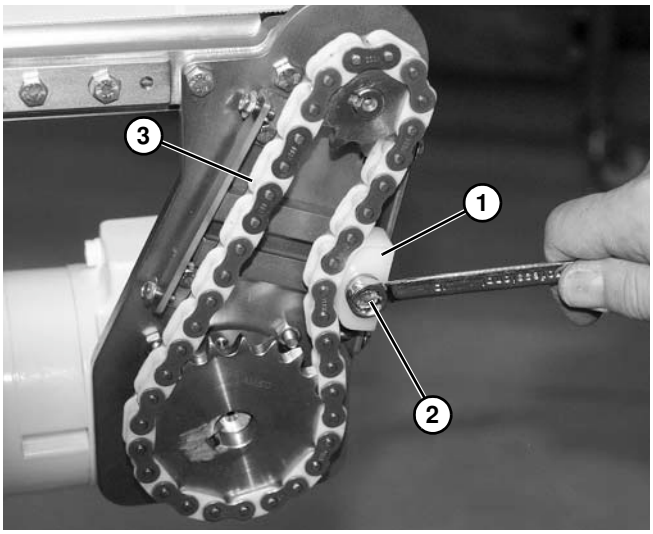


Figure 72

NOTE

*Do not over-tighten screws **(Figure 73, item 2)**.*

5. Attach cover **(Figure 73, item 1)** with four (4) screws **(Figure 73, item 2)**. Tighten screws.

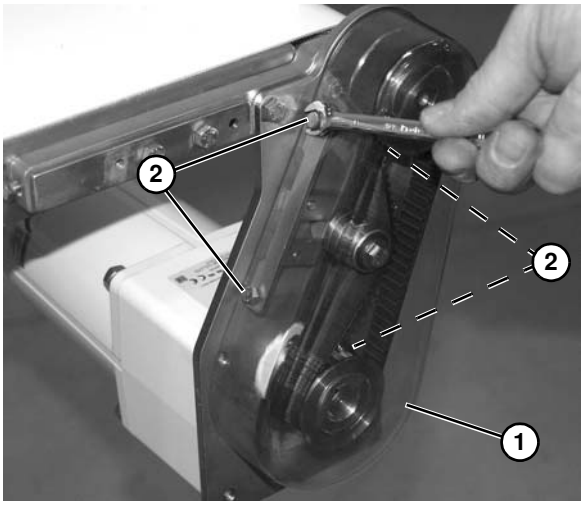


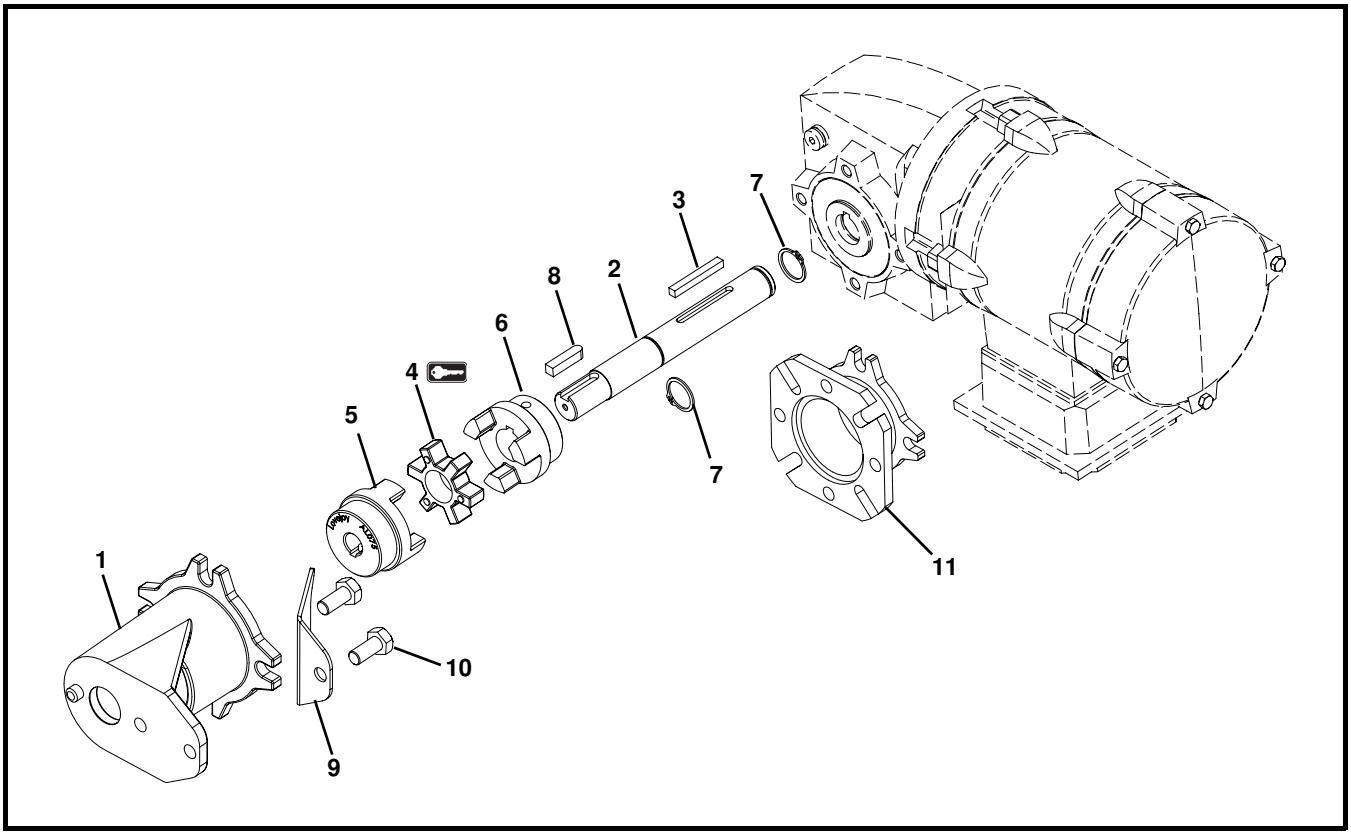
Figure 73

Notes

NOTE

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

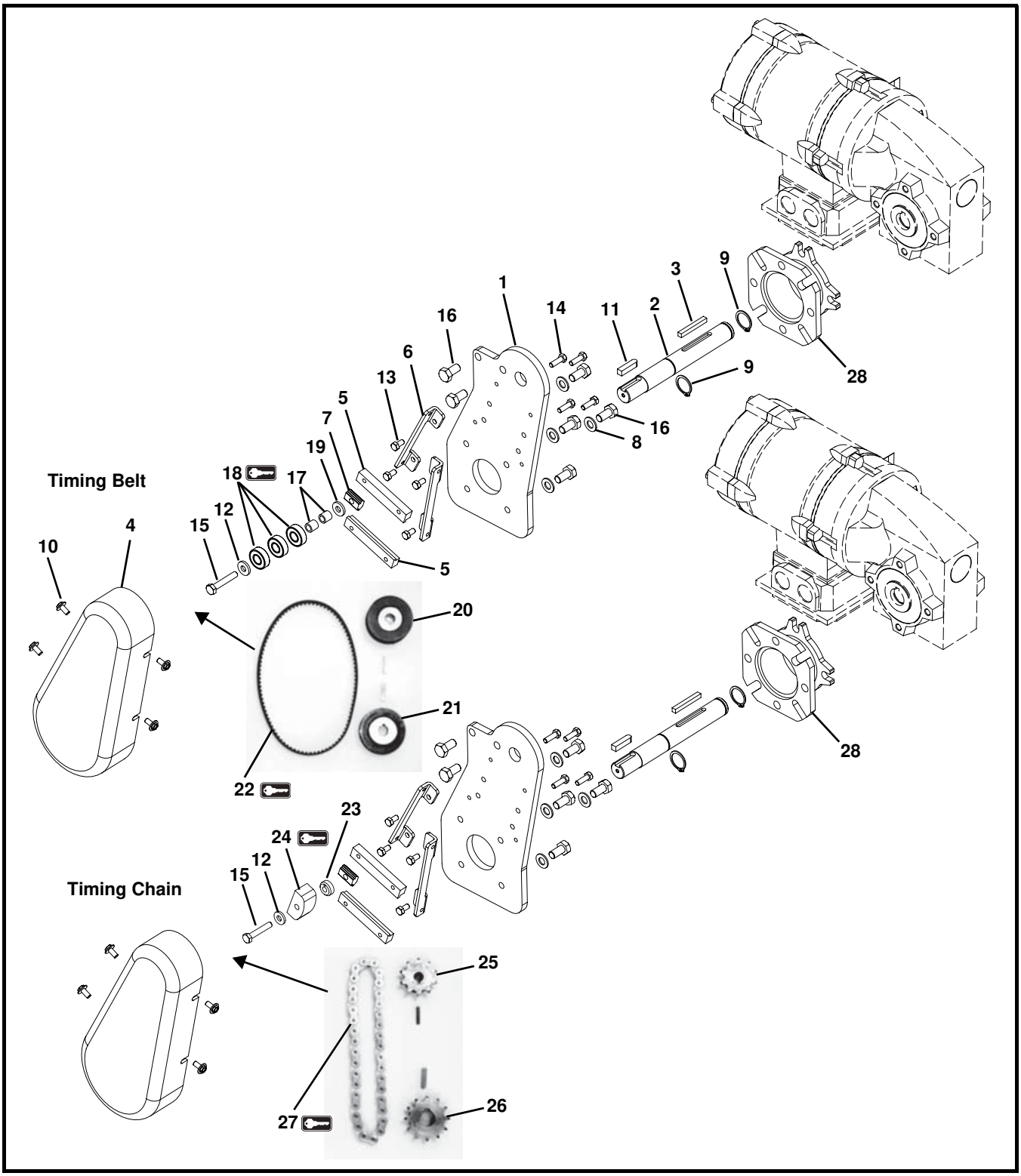
Side Mount Package



Item	Part Number	Description
1	531121-M	Side Mounting Bracket
2	531123	Motor Shaft for 60Hz Gearmotors
	531490	Motor Shaft for 50Hz Gearmotors
3	205561-00250	Key for 60Hz Gearmotors
	711634-00150	Key for 50Hz Gearmotors
4	807-1143	3 Jaw Spider
5	807-5191	3 Jaw Coupling, 1.75 dia. x 12 mm
6	807-5190	3 Jaw Coupling, 1.75 dia. x .75"
7	807-2710	Retaining Ring for 60Hz Gearmotors
	915-028	Retaining Ring for 50Hz Gearmotors
8	205561-00125	Key
9	531164	Angle Guard
10	960818MSS	Hex Head Cap Screw, M8-1.25 x 18 mm
11	KT201181	Flange for Industrial 50Hz Gearmotors only

Service Parts

90° Bottom Mount Package



Item	Part Number	Description
1	531109	Mounting Plate
2	531127	Motor Shaft for 60Hz Gearmotors
	531371	Motor Shaft for 50Hz Gearmotors
3	205561-00150	Key for 60Hz Gearmotors
	711634-00150	Key for 50Hz Gearmotors
4	450028P	Cover
5	450178MSS	Slide Bar, Tensioner
6	450181MSS	Cover Mounting Bracket
7	639971MSS	Drop-In Tee Bar
8	807-1951	Washer, M8
9	807-2710	Retaining Ring for 60Hz Gearmotors
	915-028	Retaining Ring for 50Hz Gearmotors
10	807-968	Flange Hex Screw, M5-0.80 x 10 mm
11	826-318	Key
12	911-201	Washer, 1/4"
13	960510MSS	Hex Head Cap Screw, M5-0.80 x 10 mm
14	960516MSS	Hex Head Cap Screw, M5-0.80 x 16 mm
15	960635MSS	Hex Head Cap Screw, M6-1.00 x 35 mm
16	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
17	801-139	Nylon Bearing for Timing Belt only
18	802-123	Bearing for Timing Belt only
19	911-201	Washer, 1/4" for Timing Belt only
20	450102	Driven Pulley, 22 Tooth, 12 mm Bore for Timing Belt only
	450103	Driven Pulley, 28 Tooth, 12 mm Bore for Timing Belt only
	450104	Driven Pulley, 32 Tooth, 12 mm Bore for Timing Belt only
21	450392M	Drive Pulley, 28 Tooth, 18 mm Bore for Timing Belt only
	450393M	Drive Pulley, 32 Tooth, 18 mm Bore for Timing Belt only
	450394M	Drive Pulley, 44 Tooth, 18 mm Bore for Timing Belt only
	450395M	Drive Pulley, 48 Tooth, 18 mm Bore for Timing Belt only
22	814-104	Timing Belt, 15 mm x 405 mm Long
	814-065	Timing Belt, 15 mm x 475 mm Long
	814-101	Timing Belt, 15 mm x 500 mm Long
	814-108	Timing Belt, 15 mm x 520 mm Long
	814-064	Timing Belt, 15 mm x 535 mm Long

Item	Part Number	Description
23	450182SS	Spacer for Timing Chain only
24	456048	Chain Tensioner for Timing Chain only
25	811-296	Driven Sprocket, 10 Tooth, 12 mm Bore for Timing Chain only
26	811-302	Drive Sprocket, 12 Tooth, 18 mm Bore for Timing Chain only
	811-304	Drive Sprocket, 16 Tooth, 18 mm Bore for Timing Chain only
	811-305	Drive Sprocket, 18 Tooth, 18 mm Bore for Timing Chain only
	811-306	Drive Sprocket, 20 Tooth, 18 mm Bore for Timing Chain only
27	456050	Timing Chain, 35 Pitch Length
	456052	Timing Chain, 37 Pitch Length
	456053	Timing Chain, 39 Pitch Length
28	826-1919	Flange for 60Hz Gearmotors
	826-1919	Flange for 50Hz Gearmotors
	KT201177	Flange for Industrial 50Hz Gearmotors

Timing Belt Combinations

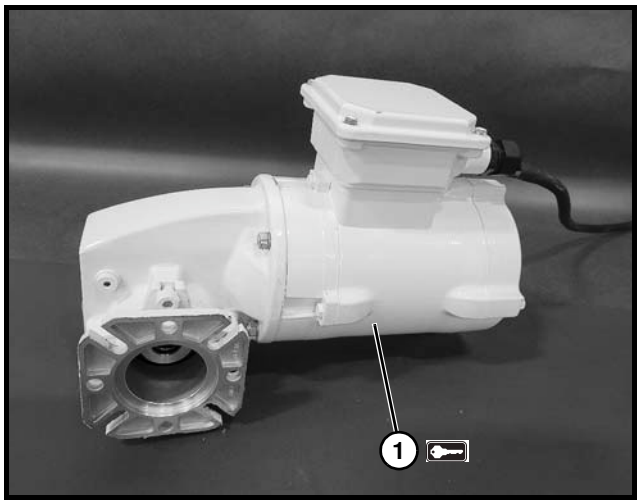
Drive Pulley Teeth	Driven Pulley Teeth	Belt Length
28	32	475 mm
32	22	405 mm
32	28	475 mm
32	32	475 mm
44	22	500 mm
44	28	500 mm
44	32	520 mm
48	22	500 mm
48	28	535 mm
48	32	535 mm

Timing Chain Combinations

Drive Sprocket Teeth	Driven Sprocket Teeth	Pitch Length
12	10	35
16	10	37
18	10	39
20	10	39

Service Parts

90° Gearmotor



Item	Part Number	Description
1	826-1666	Motor, 0.11 kW (0.16 Hp), 230/460 Volts, 58 RPM, 60 Hz, 3 Phase
	826-1665	Motor, 0.24 kW (0.33 Hp), 230/460 Volts, 172 RPM, 60 Hz, 3 Phase
	826-1664	Motor, 0.24 kW (0.33 Hp), 230/460 Volts, 344 RPM, 60 Hz, 3 Phase
	826-1683	Motor, 0.12 kW (0.16 Hp), 230/400 Volts, 47 RPM, 50 Hz, 3 Phase
	826-1682	Motor, 0.25 kW (0.33 Hp), 230/400 Volts, 142 RPM, 50 Hz, 3 Phase
	826-1681	Motor, 0.25 kW (0.33 Hp), 230/400 Volts, 280 RPM, 50 Hz, 3 Phase
	KT201180	Industrial Motor, 0.12 kW (0.16 Hp), 230/400 Volts, 47 RPM, 50 Hz, 3 Phase
	KT201179	Industrial Motor, 0.25 kW (0.33 Hp), 230/400 Volts, 142 RPM, 50 Hz, 3 Phase
	KT201176	Industrial Motor, 0.25 kW (0.33 Hp), 230/400 Volts, 280 RPM, 50 Hz, 3 Phase

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="11">non-returnable</td><td rowspan="11">case-by-case</td></tr>
<tr><td>2200 Series</td></tr>
<tr><td>3200 Series</td></tr>
<tr><td>Pallet Systems</td></tr>
<tr><td>FlexMove/SmartFlex</td></tr>
<tr><td>GAL Series</td></tr>
<tr><td>All Electrical</td></tr>
<tr><td>7100 Series</td><td colspan="6" rowspan="4">50% return fee for all products</td></tr>
<tr><td>7200/7300 Series</td></tr>
<tr><td>AquaGard 7350 Series Version 2</td></tr>
<tr><td>GES Series</td></tr>
<tr><td>AquaGard 7350/7360 Series</td><td colspan="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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