

**2100, 4100, 6100 Series  
Bottom Mount Drive Package  
for Heavy Load 90° Industrial 60 Hz Gearmotors**





**Table of Contents**



Warnings – General Safety .....	2	Preventative Maintenance & Adjustment .....	8
Introduction .....	2	Required Tools .....	8
Product Description .....	3	Timing Belt Tensioning .....	8
Specifications .....	3	Timing Belt Replacement .....	8
Installation .....	5	Drive or Driven Pulley Replacement .....	9
Required Tools .....	5	Gear Reducer Replacement .....	9
Mounting .....	5	Service Parts .....	12
		Return Policy .....	14

## Warnings – General Safety

	<b>WARNING</b>	
The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.		



		<b>WARNING</b>
Gearmotors may be HOT. <b>DO NOT TOUCH</b> Gearmotors.		

		<b>DANGER</b>
Climbing, sitting, walking or riding on conveyor will cause severe injury. <b>KEEP OFF CONVEYORS.</b>		

		<b>WARNING</b>
Exposed moving parts can cause severe injury. <b>REPLACE ALL GUARDS BEFORE RUNNING CONVEYOR.</b>		

		<b>DANGER</b>
Do NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.		

		<b>WARNING</b>
Exposed moving parts can cause severe injury. <b>LOCK OUT POWER</b> before removing guards or performing maintenance.		

		<b>WARNING</b>
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, <b>CHECK FOR POTENTIAL PINCH POINTS</b> and other mechanical hazards before system start-up.		

## 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 2100 Series conveyors are covered by the following patent numbers: 5131529, 5174435, and corresponding patents and patent applications in other countries.

Dorner 4100 Series conveyors are covered by patent number 3923148 and corresponding patents and patent applications in other countries.

Dorner 6100 Series conveyors are covered by patent number 5174435 and corresponding patents and patent applications in other countries.

Dorner's Limited Warranty applies.

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

# Product Description

Refer to Figure 1 for typical components.

Typical Components	
A	Conveyor
B	Mounting Bracket
C	Gearmotor
D	Timing Belt Tensioner
E	Cover
F	Timing Belt
G	Drive Pulley
H	Driven Pulley

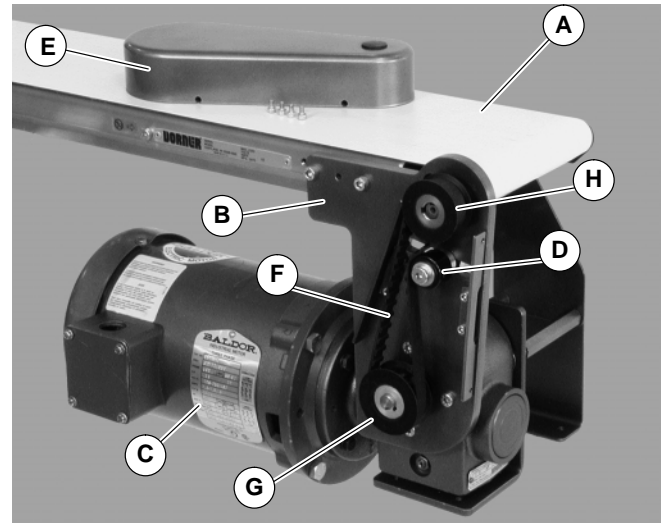


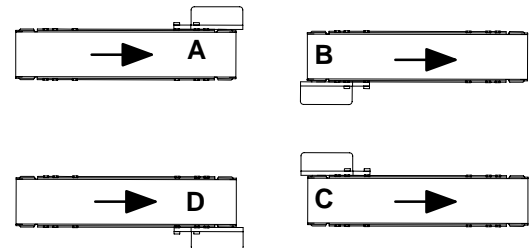
Figure 1

# Specifications

## Gearmotor Mounting Package Models:

### Example:

**2 M B H H W W A - 32 32**  
 — Driven Pulley (see Tables 2, 3 & 4)  
 — Drive Pulley (see Tables 2, 3 & 4)  
 — Belt Type ( - = flat belt, A through J = cleated belt )  
 — Mount Position = A, B, C or D (see detail to the right)  
 — Conveyor Width Reference\*  
 — Gearmotor Type = Heavy Load, Industrial  
 — Output Shaft Type = 90° Industrial  
 — Mount Style = Bottom Mount  
 — Language Code = U.S. English  
 2 = 2100 Series Conveyor  
 4 = 4100 Series Conveyor  
 6 = 6100 Series Conveyor



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

Table 1: Gearmotor Specifications

	Single Phase	Three Phase	DC Variable Speed	VFD Variable Speed
Output Power	0.50 hp (0.37 kw)			
Input Voltage	115 VAC	208– 230 / 460 VAC	90 VDC	230 VAC
Input Frequency	60 Hz		N/A	10 – 60 Hz
Input Current	7.4 Amperes	2.1 – 2/ 1 Amperes	5.0 Amperes	1.6 Amperes
Motor RPM	1725		2500	1725
Gearmotor Ratios	5:1, 10:1, 20:1, 40:1, 60:1			
Frame Size	NEMA 56C			
Motor Type	Totally enclosed, Fan-cooled			

# Specifications

**Table 2: Belt Speeds for Heavy Load Fixed Speed 90° 60 Hz Gearmotors**

Gearmotors				Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HS4(vp)FN	29	226	25.5	5	1.5	19	32
32M060HS4(vp)FN	29	226	25.5	8	2.4	32	32
32M040HS4(vp)FN	43	247	27.9	12	3.7	32	32
32M040HS4(vp)FN	43	247	27.9	18	5.5	48	32
32M020HS4(vp)FN	86	248	27.9	25	7.6	32	32
32M020HS4(vp)FN	86	248	27.9	37	11.3	48	32
32M010HS4(vp)FN	173	156	17.6	49	14.9	32	32
32M010HS4(vp)FN	173	156	17.6	74	22.6	48	32
32M005HS4(vp)FN	345	81	9.1	99	30.3	32	32
32M005HS4(vp)FN	345	81	9.1	145	45.1	48	32
32M005HS4(vp)FN	345	81	9.1	169	51.5	48	28
32M005HS4(vp)FN	345	81	9.1	197	60	44	22
32M005HS4(vp)FN	345	81	9.1	215	65	48	22
32M005HS4(vp)FN	345	81	9.1	249	76	48	19

(vp) = voltage and phase (n) = reversing capability  
 11 = 115 V, 1-phase N = no reversing switch  
 23 = 208-230/460 V, 3-phase R = with reversing switch  
 (115V, 1 phase only)

**Table 3: Belt Speeds for Heavy Load Variable Speed 90° DC Gearmotors**

Gearmotors				Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HSD9DEN	42	198	22.4	0.8 – 7.0	0.3 – 2.2	19	32
32M060HSD9DEN	42	198	22.4	1.4 – 12	0.4 – 3.6	32	32
32M040HSD9DEN	63	215	24.3	2.1 – 18	0.7 – 5.4	32	32
32M020HSD9DEN	125	196	22.1	4.3 – 36	1.3 – 11	32	32
32M010HSD9DEN	250	108	12.2	9.0 – 71	2.6 – 22	32	32
32M005HSD9DEN	500	56	6.3	17 – 143	5.2 – 43	32	32
32M005HSD9DEN	500	56	6.3	26 – 214	7.8 – 65	48	32
32M005HSD9DEN	500	56	6.3	29 – 245	9.0 – 75	48	28

**Table 4: Belt Speeds for Heavy Load Variable Speed 90° VFD Gearmotors**

Gearmotors				Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HS423EN	29	226	25.5	0.5 – 5.0	0.1 – 1.5	19	32
32M060HS423EN	29	226	25.5	0.8 – 8.2	0.3 – 2.5	32	32
32M040HS423EN	43	247	27.9	1.2 – 12	0.4 – 3.8	32	32
32M020HS423EN	86	248	27.9	2.5 – 25	0.8 – 7.5	32	32
32M010HS423EN	173	156	17.6	4.9 – 49	1.5 – 15	32	32
32M005HS423EN	345	81	9.1	9.9 – 99	3.0 – 30	32	32
32M005HS423EN	345	81	9.1	14 – 148	4.5 – 45	48	32
32M005HS423EN	345	81	9.1	19 – 197	6.0 – 60	44	22
32M005HS423EN	345	81	9.1	24 – 249	7.6 – 76	48	19

**NOTE:** For belt speed other than those listed, contact factory for details.

## Required Tools

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

## Mounting



**WARNING**

Exposed moving parts can cause severe injury.

**LOCK OUT POWER** before removing guards or performing maintenance.

Installation Component List	
I	Bottom Mount Assembly
J	Drive Pulley
K	Cover
L	M4 Socket Head Screws (4x)
M	Driven Pulley
N	Key
O	Timing Belt
P	M6 Socket Head Screws (2x)
Q	M6 Socket-Head Screws & Washers (4x)
R	End Support Bracket
S	Hex Support Posts (2x)
T	Conveyor/Gearhead Support Plate
U	Support Plate Spacer
V	M6 Socket Head Screws (2x)
W	M6 Socket Head Screws (2x)

### 1. Typical components (Figure 2)

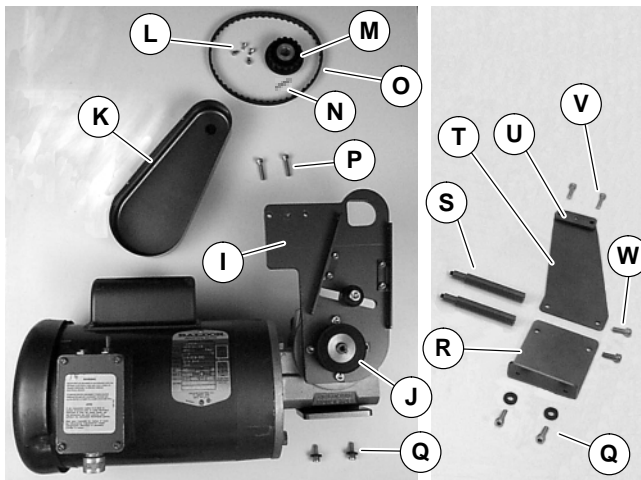


Figure 2

**NOTE:** 2100 and 6100 2" & 3" (44mm & 70mm) and 4100 1" through 6" (25mm – 52mm) conveyors do not include parts R through W of Figure 2.

**NOTE:** Gearmotor may be operated in positions 1 & 3 (Figure 3).

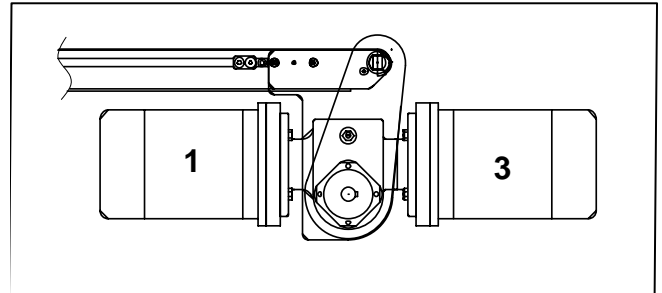


Figure 3

2. If required, change gearmotor position by removing four (4) screws (X of Figure 4) from bottom mount assembly and two (2) screws (Y of Figure 5) from gear reducer support. Rotate gearmotor to other position and replace screws. Tighten to 103 in-lb (12 Nm).

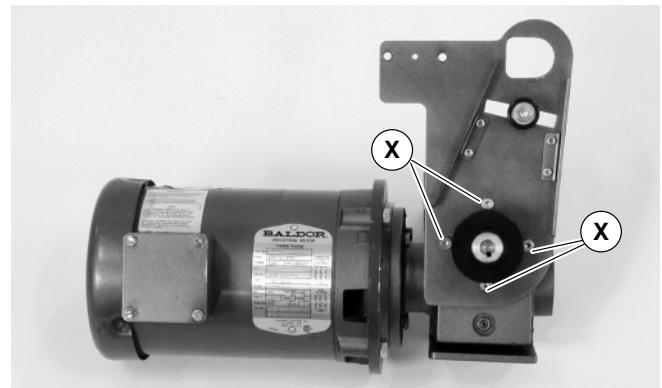


Figure 4

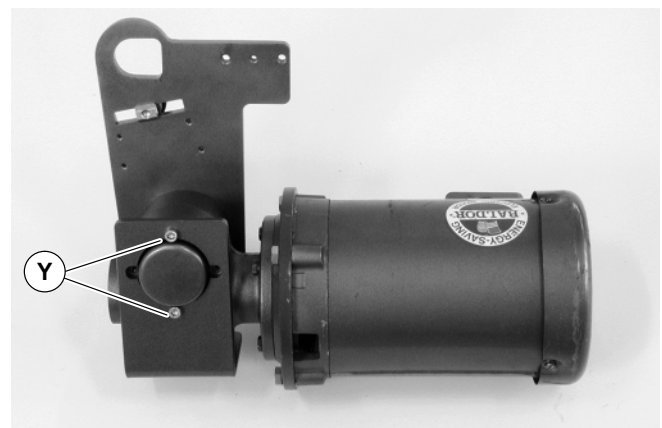
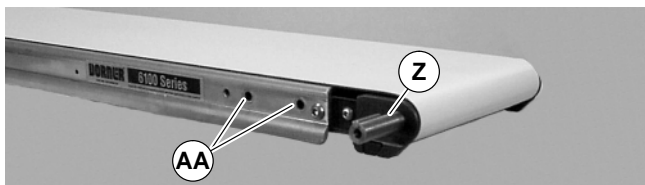


Figure 5

# Installation

**NOTE: 6100 conveyor shown, 2100 & 4100 similar.**

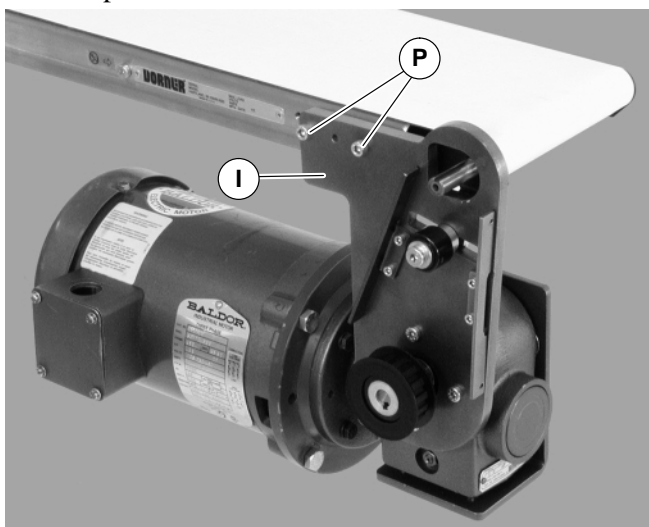
3. Locate drive output shaft (Z of Figure 6) and remove two (2) screws (AA).



**Figure 6**

**For 2100 and 6100 2" & 3" and 4100 1" through 6" wide conveyors**

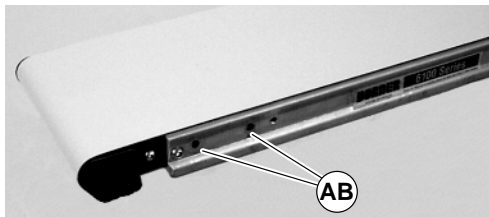
- 4a. Attach mounting assembly (I of Figure 7) with screws (P). Tighten to 80 in-lb (9 Nm). Proceed to step 8.



**Figure 7**

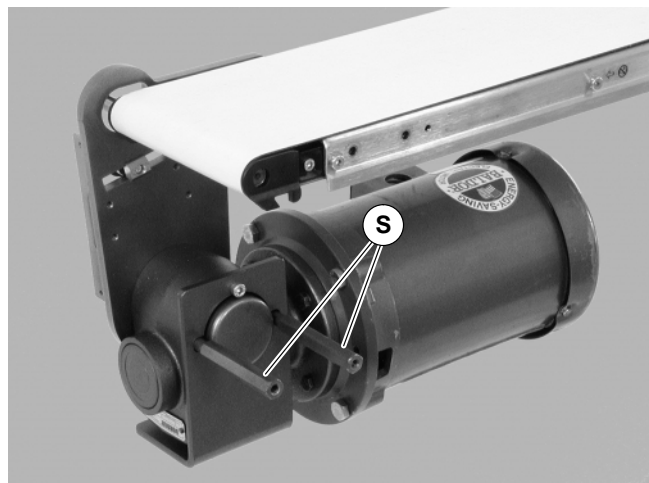
**For 2100 and 6100 4"-and-wider and 4100 8"-and-wider conveyors**

- 4b. On side opposite drive output shaft, remove original factory-installed screws (AB of Figure 8).



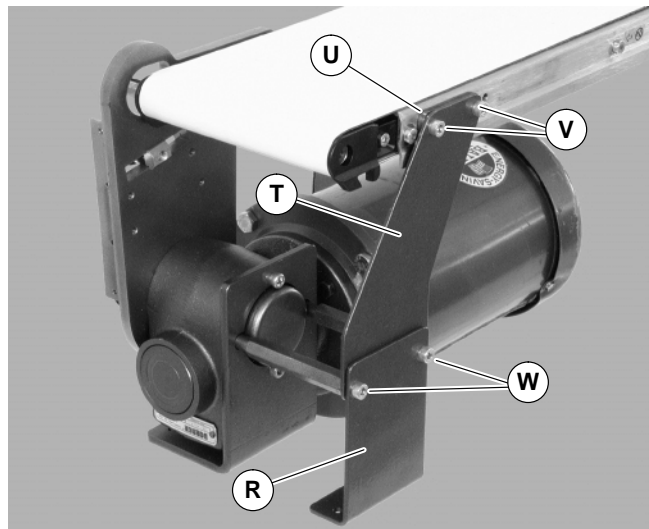
**Figure 8**

- 5b. Attach mounting assembly (I of Figure 7) with screws (O). Tighten to 80 in-lb (9 Nm).
- 6b. Install hex support posts (S of Figure 9). Tighten posts to 80 in-lb (9 Nm).

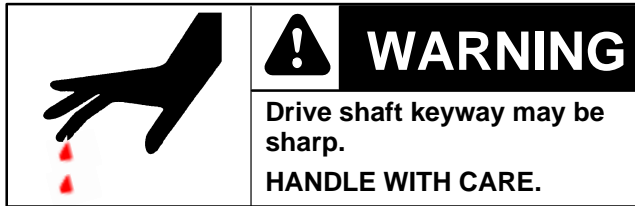


**Figure 9**

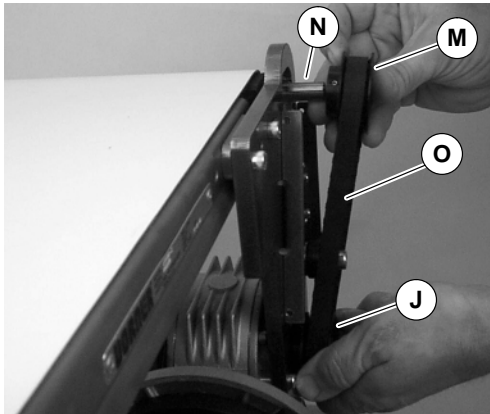
- 7b. Install spacer (U of Figure 10) and support plate (T) with screws (V). Install support bracket (R) with screws (W). Tighten screws (V & W) to 80 in-lb (9 Nm). Proceed to step 8.



**Figure 10**

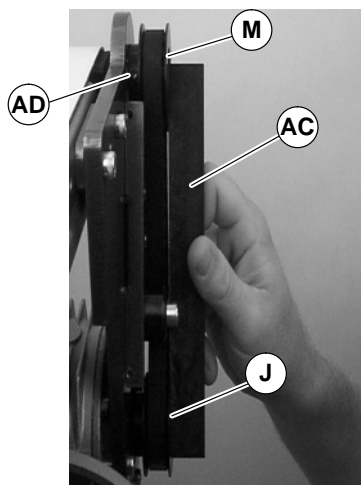


8. Install key (N of Figure 11).



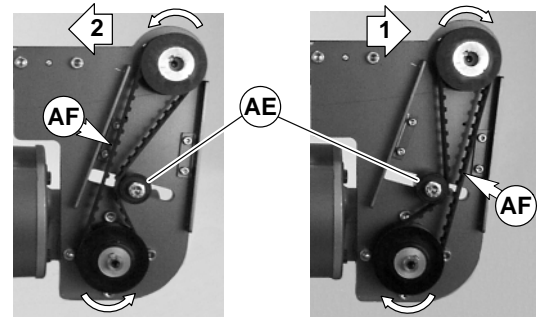
**Figure 11**

9. Wrap timing belt (O) around driven pulley (M) and drive pulley (J). Install driven pulley (M) onto conveyor shaft.
10. Using a straight edge (AC of Figure 12), align driven pulley (M) with drive pulley (J). Tighten driven pulley set screws (AD).



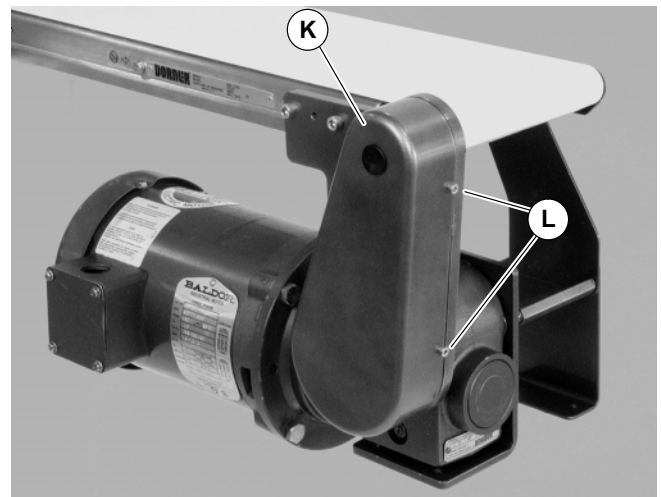
**Figure 12**

11. Depending on direction of conveyor belt travel (1 or 2 of Figure 13), position belt tensioner (AE) as shown. Tension belt to obtain 0.125" (3 mm) deflection for 1.0 lb (456 grams) of force at belt mid-point (AF). Tighten tensioner screw to 103 in-lb (12 Nm).



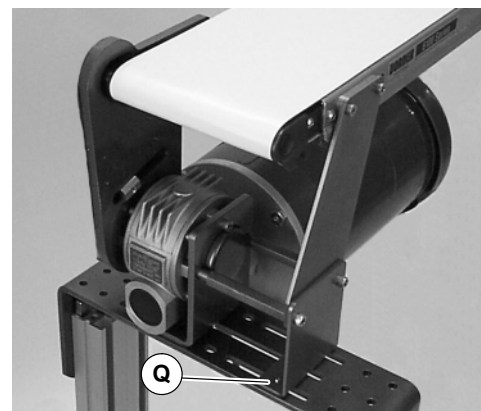
**Figure 13**

12. Install cover (K of Figure 14) with four (4) screws (L). Tighten to 35 in-lb (4 Nm).



**Figure 14**

13. Mount assembly to support structure with four (4) screws (Q of Figure 15). Tighten to 80 in-lb (9 Nm).



**Figure 15**

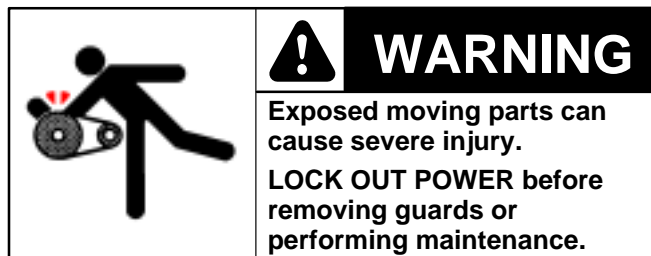


# Preventive Maintenance and Adjustment

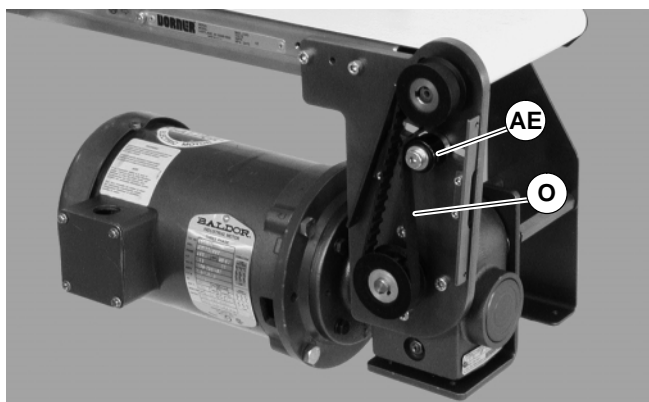
## Required Tools

- Hex key wrenches:  
2 mm, 2.5 mm, 3 mm, 5 mm
- Adjustable wrench (for hexagon head screws)
- Straight edge
- Torque wrench

## Timing Belt Tensioning



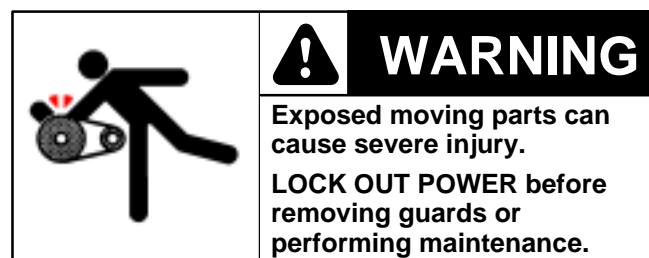
1. Remove four (4) screws (L of Figure 14) and remove cover (K).
2. Loosen tensioner (AE of Figure 16).



**Figure 16**

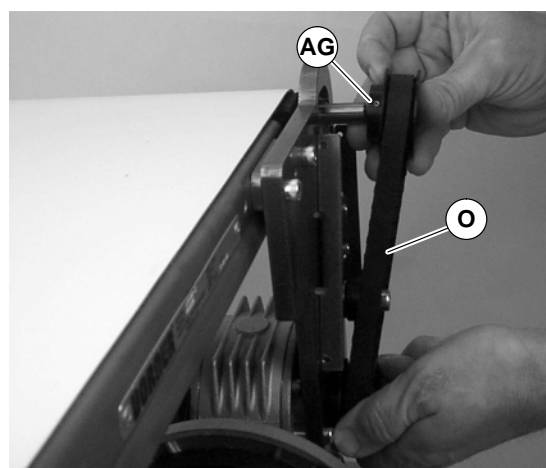
3. Depending on direction of conveyor belt travel (1 or 2 of Figure 13), position belt tensioner (AE) as shown. Tension belt to obtain 0.125" (3 mm) deflection for 1.0 lb (456 grams) of force at belt mid-point (AF). Tighten tensioner screw to 103 in-lb (12 Nm).
4. Install cover (K of Figure 14) with four (4) screws (L). Tighten to 35 in-lb (4 Nm).

## Timing Belt Replacement



1. Remove four (4) screws (L of Figure 14) and remove cover (K).
2. Loosen tensioner (AE of Figure 16).
3. Remove timing belt (O of Figure 17).

**NOTE:** If timing belt does not slide over pulley flange, loosen driven pulley set screws (AG of Figure 17) and remove pulley with belt (O). For re-installation, see steps 9 and 10 on page 7.



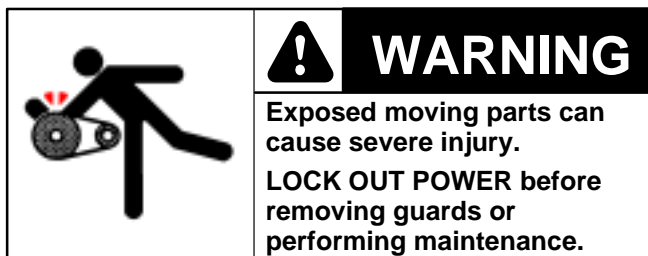
**Figure 17**

4. Install new timing belt.
5. Depending on direction of conveyor belt travel (1 or 2 of Figure 13), position belt tensioner (AE) as shown. Tension belt to obtain 0.125" (3 mm) deflection for 1.0 lb (456 grams) of force at belt mid-point (AF). Tighten tensioner screw to 103 in-lb (12 Nm).
6. Install cover (K of Figure 14) with four (4) screws (L). Tighten to 35 in-lb (4 Nm).



# Preventive Maintenance and Adjustment

## Drive or Driven Pulley Replacement

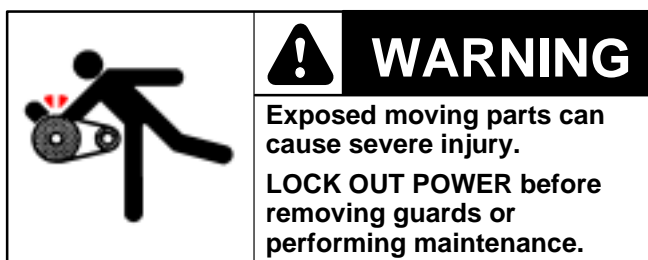


1. Complete steps 1 through 3 of “Timing Belt Replacement” section on page 8.
2. Loosen set screws and remove drive or driven pulley.

**NOTE:** If drive pulley (J of Figure 18) is replaced, wrap timing belt around drive pulley and complete step 3.

3. Complete steps 9 through 12 of “Installation” section on page 7.

## Gear Reducer Replacement



1. Remove four (4) screws (L of Figure 14) and remove cover (K).
2. Loosen tensioner (AE of Figure 16).
3. Loosen drive pulley set screws (AG of Figure 18). Remove drive pulley (J) and timing belt (O).

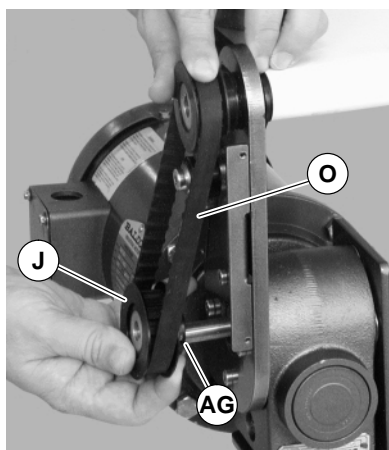


Figure 18

4. Remove screws (V & W of Figure 19) and remove support bracket (R), support plate (T) and spacer (U).

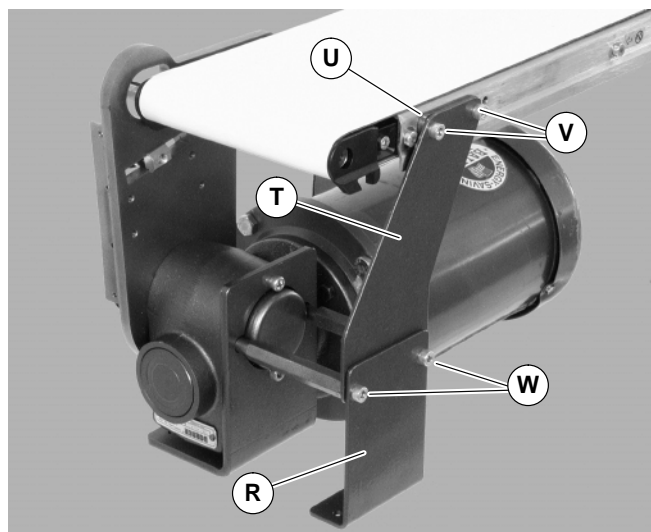


Figure 19

5. Remove hex support posts (S of Figure 20).

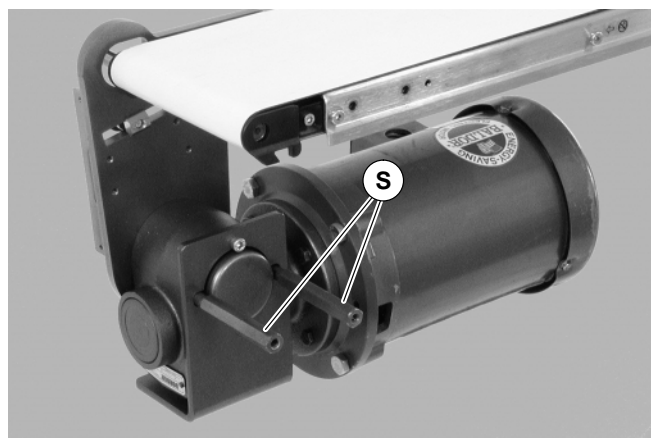


Figure 20

6. Remove two (2) bracket screws (AH of Figure 21) and remove bracket (AI).



Figure 21

# Preventive Maintenance and Adjustment

7. Remove four (4) gear reducer mounting screws (AJ of Figure 22). Remove gearmotor.

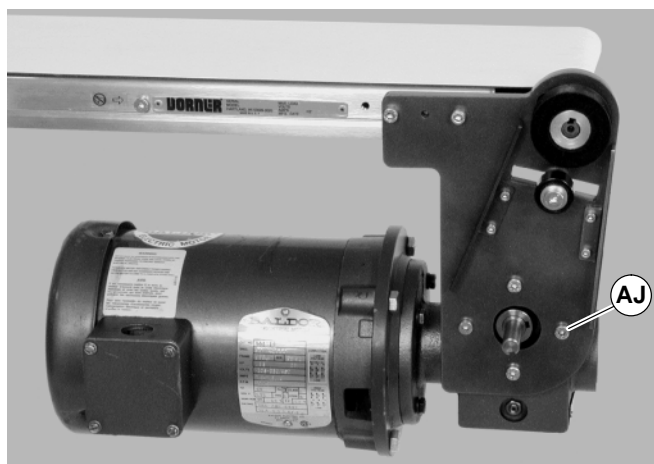


Figure 22

8. Remove four screws (AK of Figure 23). Detach motor (AL) from gear reducer (AM). Retain motor output shaft key (AN).

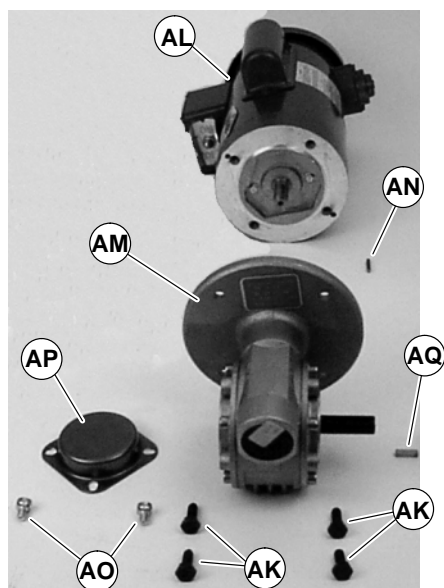


Figure 23

9. Remove two (2) screws (AO) and detach output shaft cover (AP).
10. Remove gear reducer output shaft key (AQ).
11. Loosen six (6) set screws (AR of Figure 24). Remove drive shaft (AS) and key (AT).

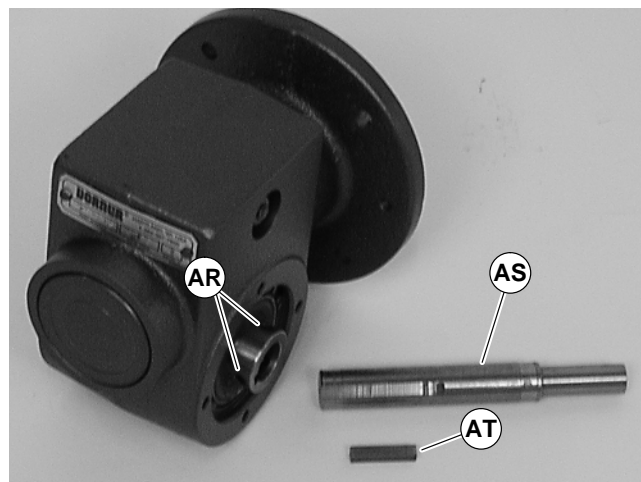


Figure 24

12. Apply grease (AU of Figure 25) to shaft.

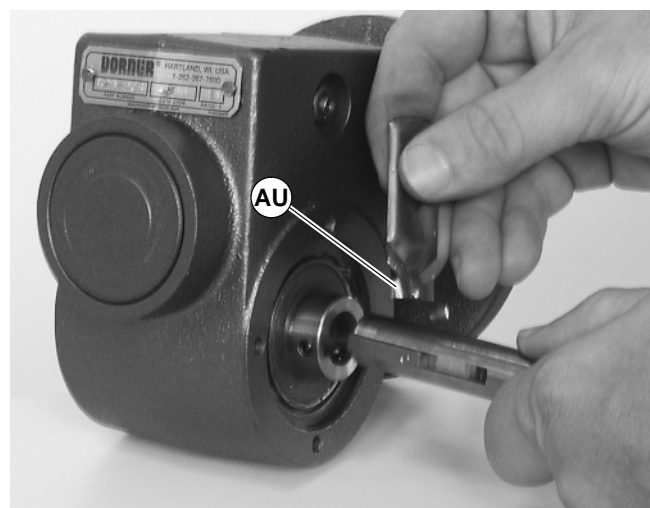


Figure 25

13. Replace the original shaft components into new gear reducer (see Figure 24). Tighten set screws (AR) to 26 in-lb (3 Nm).

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**IMPORTANT:** Be extremely careful when coupling motor to gear reducer. Avoid misalignment and forcing the connection causing possible permanent gear reducer seal damage.

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14. With key (AN of Figure 23) in keyway, slide motor (AL) and gear reducer (AM) together. Install screws (AK) and tighten.



# Preventive Maintenance and Adjustment

15. Reverse steps 4 through 7 beginning on page 9.

**NOTE:** Drive pulley (J of Figure 18) is removed. Wrap timing belt around drive pulley and complete step 16.

16. Complete steps 9 through 13 of “Installation” section on page 7.

## Motor Replacement

	<p><b>! WARNING</b></p> <p>Exposed moving parts can cause severe injury.</p> <p><b>LOCK OUT POWER</b> before removing guards or performing maintenance.</p>
	<p><b>! DANGER</b></p> <p>Hazardous voltage will cause severe injury or death.</p> <p><b>LOCKOUT POWER BEFORE</b> wiring.</p>

1. For single phase motor, unplug power cord from outlet.
2. For three phase and VFD variable speed motor:
  - a. Loosen terminal box screws (AV of Figure 26) and remove cover (AW).

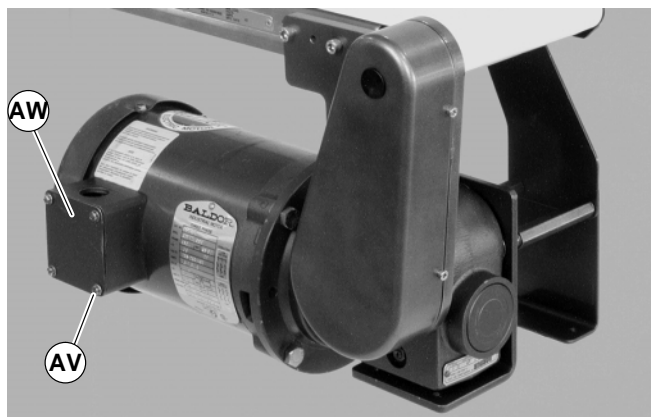


Figure 26

- b. Record wire colors on terminals 1, 2 and 3. Loosen wire nuts and remove wires 1, 2 and 3.
  - c. Loosen cord grip and remove cord.
3. For DC variable speed motor, unplug motor cord at disconnect (AX of Figure 27).

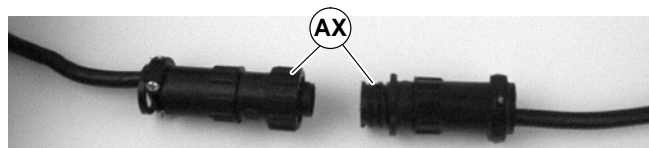


Figure 27

4. Remove four screws (AK of Figure 28). Detach motor (AL) from gear reducer (AM). Retain motor output shaft key (AN).

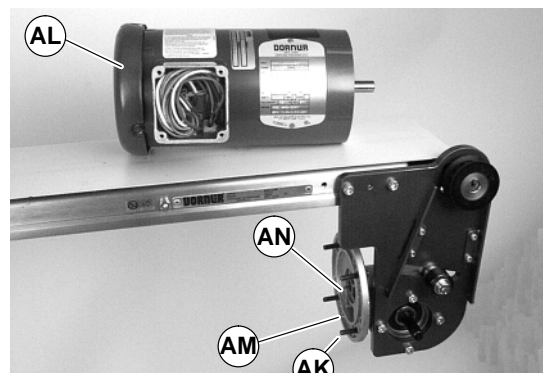


Figure 28

**IMPORTANT:** Be extremely careful when coupling motor to gear reducer. Avoid misalignment and forcing the connection causing possible permanent gear reducer seal damage.

5. With key (AN of Figure 29) in keyway, slide motor and gear reducer together. Install screws (AK) and tighten.

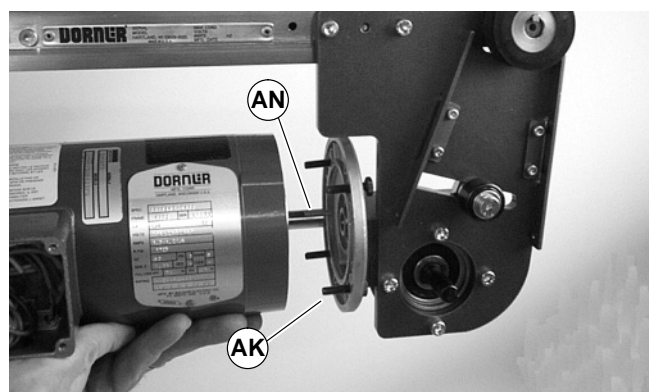


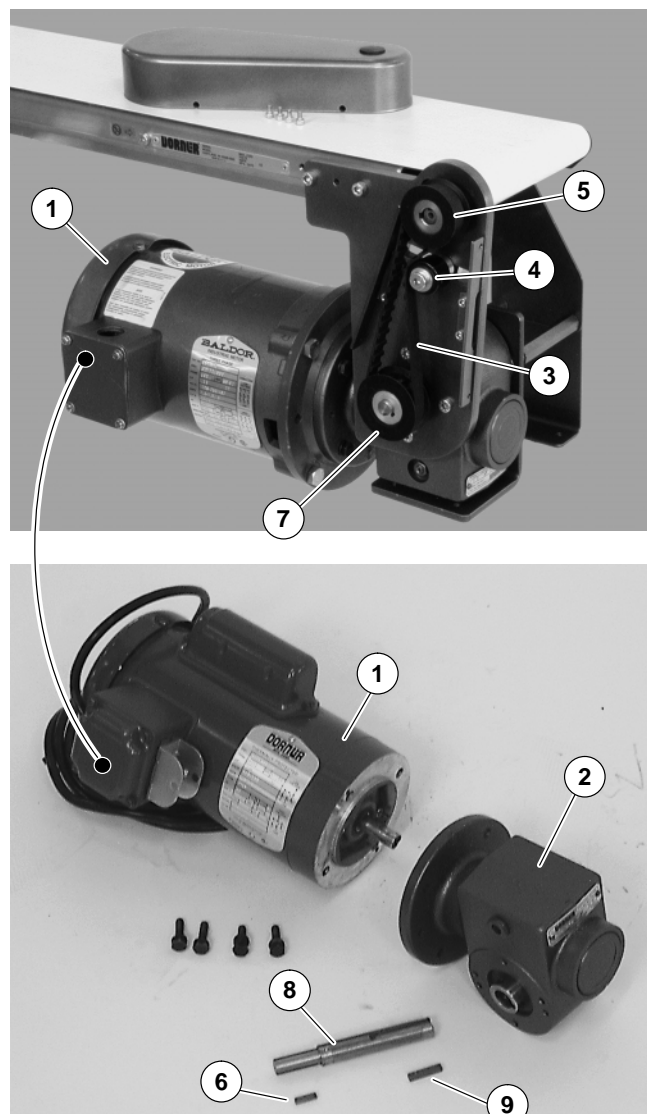
Figure 29

6. Replace wiring:
  - For a single phase motor, reverse step 1 on this page.
  - For a three phase and VFD variable speed motor, reverse step 2, on this page.
  - For a DC variable speed motor, reverse step 3 on this page.

# Service Parts

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

Item	Part No.	Part Description
1	826-017	Motor, 0.5 hp (0.37 Kw) 115/230 Volts, 60 Hz, 1-Phase
	826-025	Motor, 0.5 hp (0.37 Kw) 208–230/460 Volts, 60 Hz, 3-Phase
	826-333	Motor, 0.5 hp (0.37 Kw) 90 Volts DC
	826-249	Motor, 0.5 hp (0.37 Kw) 230V, 10– 60Hz, Inverter Duty, 3 Phase
2	32M005HS	Gear Reducer, 5:1, 56C
	32M010HS	Gear Reducer, 10:1, 56C
	32M020HS	Gear Reducer, 20:1, 56C
	32M040HS	Gear Reducer, 40:1, 56C
	32M060HS	Gear Reducer, 60:1, 56C
3	814-104	Timing Belt, 15mm W x 450mm L
	814-105	Timing Belt, 15mm W x 460mm L
	814-065	Timing Belt, 15mm W x 475mm L
	814-112	Timing Belt, 15mm W x 495mm L
	814-101	Timing Belt, 15mm W x 500mm L
	814-108	Timing Belt, 15mm W x 520mm L
	814-064	Timing Belt, 15mm W x 535mm L
	814-099	Timing Belt, 15mm W x 565mm L
4	802-046	Tensioner Bearing
5	450365MP	Driven Pulley, 19Tooth
	450366MP	Driven Pulley, 22Tooth
	450367MP	Driven Pulley, 28Tooth
	450368MP	Driven Pulley, 32Tooth
6	980422M	Square Key, 4 mm x 22 mm (2x)
7	450365MP	Drive Pulley, 19Tooth
	450366MP	Drive Pulley, 22Tooth
	450367MP	Drive Pulley, 28Tooth
	450368MP	Drive Pulley, 32Tooth
	450369MP	Drive Pulley, 44Tooth
	450370MP	Drive Pulley, 48Tooth
	450371MP	Drive Pulley, 60Tooth
8	450444M	Gear Reducer Shaft
9	912–084	Key, Square, 0.188" x 1.5" L



**Figure 30**



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## Return Policy

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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 at [www.dorner.com](http://www.dorner.com)

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

**DORNER<sup>®</sup>**

Dorner Mfg. Corp. reserves the right to change or discontinue products without notice. All products and services are covered in accordance with our standard warranty. All rights reserved. ©Dorner Mfg. Corp. 2000

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