



Fully Adjustable Stands

Installation, Maintenance & Parts Manual



DORNER MFG. CORP.
P.O. Box 20 • 975 Cottonwood Ave.
Hartland, WI 53029-0020 USA

INSIDE THE USA
TEL: 1-800-397-8664
FAX: 1-800-369-2440

OUTSIDE THE USA
TEL: 262-367-7600
FAX: 262-367-5827

For other service manuals visit our website at:
www.dorner.com/service_manuals.asp

Table of Contents

Introduction	2	Preventive Maintenance and Adjustment	9
Warnings - General Safety	3	Stand Height Adjustment	9
Product Description	4	Required Tools.....	9
Specifications	4	Conveyor Angle Adjustment.....	10
Installation	5	Required Tools.....	10
Recommended Installation Sequence	5	Notes	11
Assembly	5	Service Parts.....	12
Stands Shipped Partially Assembled.....	5	Fully Adjustable Stand w/Feet or Casters	12
Required Tools.....	5	Return Policy.....	14
Stands Shipped Fully Assembled.....	8		

Introduction

IMPORTANT

<i>Some illustrations may show guards removed. DO NOT operate equipment without guards.</i>

Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

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

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.

⚠ DANGER



Supports marked with this symbol must be anchored to the floor. Supports not anchored to floor will tip, causing severe injury or death.
SUPPORT MUST BE ANCHORED TO FLOOR.

⚠ WARNING



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

⚠ 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.

⚠ 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.

Product Description

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

1	Support Stand Pivot Bracket
2	Leg Support Bracket
3	Leg Assembly
4	Crossmember*
5	Optional Casters
6	Angle Adjustment Point
7	Height Adjustment Point

* (Not used on 0719 or 1219 Height Models)



Figure 1

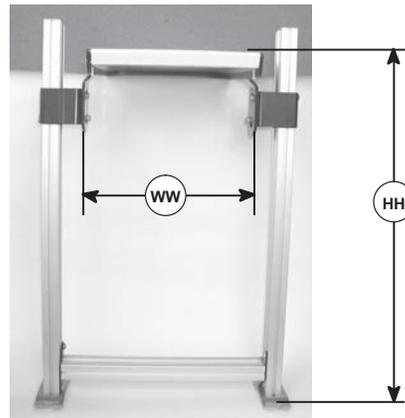
Specifications

Fixed and Adjustable Stand Models

39	M	TT	WW	HH	HH	F	
							Floor Interface
							F = Fixed Foot Pad
							C = Total Lock Swivel Caster
							Max Height
							From Floor to Top of Belt
							Min Height
							From Floor to Top of Belt
							Width
							02 (51mm) to 48 (1219mm)
							Stand Type
							FA = Fully Adjustable Height
							Language Code
							M = U.S. English
H Style Stand							
39 = 2200, 3200, 4100 & 6200 Series							
59 = 5200 Series							
39H = 3200 Modular Belt							
Conveyors with Standard Chain							
39R = 3200 Modular Belt							
Conveyors with High Strength Chain							

Example: 39MFA12-1267FA

Fully adjustable height, H style stand for a 12" (305mm) wide conveyor with a minimum height of 12" (305mm) and a maximum height of 67" (1702mm) with fixed foot pads. It comes fully assembled and has U.S. English documentation.



⚠ DANGER



Supports marked with this symbol must be anchored to the floor. Supports not anchored to floor will tip, causing severe injury or death.
SUPPORT MUST BE ANCHORED TO FLOOR.

⚠ WARNING



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

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

- Assemble stand(s), if required
- Attach stand(s) to conveyor
- Attach optional diagonal bracing (see Diagonal Brace Kit Manual)
- Adjust stand height and angle (see Adjustment section, page 9)

Assembly

Stands Shipped Partially Assembled

Required Tools

- 5 mm Hex Key Wrench
- 6 mm Hex Key Wrench
- 17 mm Open-End Wrench (stands with casters, only)

1. Typical components (Figure 2).

- | | |
|---|--|
| 1 | Leg Support Bracket (2x) |
| 2 | Hardware Pack, Crossmember (quantity as required) |
| 3 | Hardware Pack, Fully Adjustable Stand |
| 4 | Pivot Bracket (2x) |
| 5 | Crossmember (no crossmember on 7"–19" (178mm–483mm) high stand with feet or 12"–19" (305–483mm) high stand with casters) |
| 6 | Plastic Tree Rivet (4x) |
| 7 | Tube End Cover (2x) |
| 8 | Stand Leg/Foot Assembly (2x) (used on stands with feet) or Stand Leg Assembly (2x) (used on stands with casters) |
| 9 | Caster Kit (2x) (used on stands with casters) |

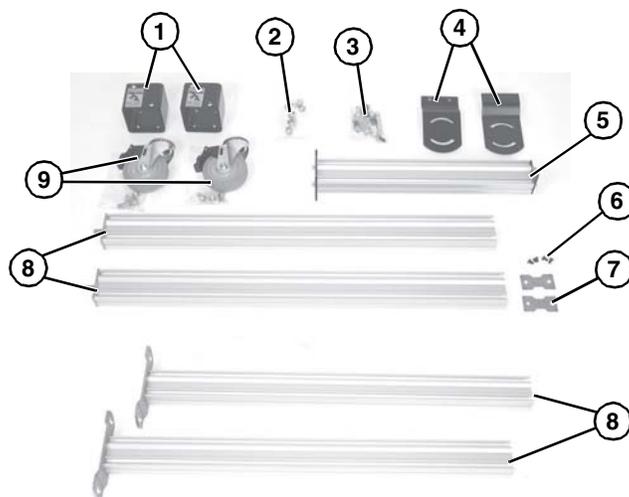


Figure 2

NOTE

7"–19" (178mm–483mm) high stands with feet and 12"–19" (305–483mm) high stands with casters do not use a crossmember. For assembly of these stands, continue with step 7.

2. Open crossmember hardware pack (Figure 2, item 2).

Installation

3. Install four button head screws (**Figure 3, item 1**) and hex nuts (**Figure 3, item 2**) on crossmember (**Figure 3, item 3**). Do not tighten screws.

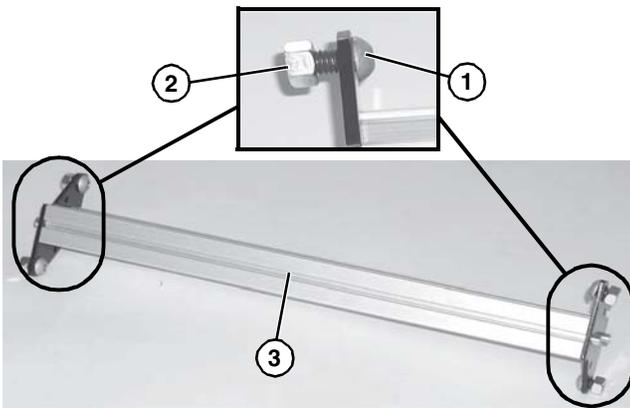


Figure 3

4. Align hex nuts (**Figure 4, item 1**) on crossmember (**Figure 4, item 2**) to t-slots (**Figure 4, item 3**) at top of stand leg (**Figure 4, item 4**). Slide crossmember to bottom of stand leg. Do not tighten screws.

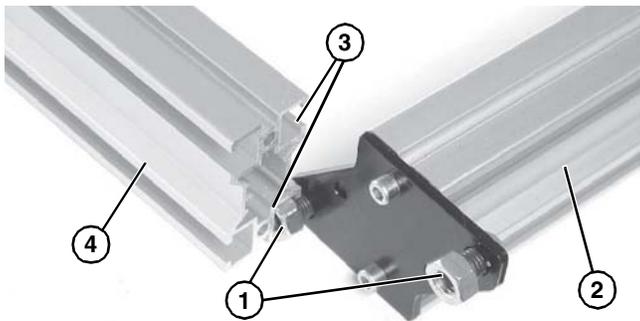


Figure 4

5. Repeat step 4 for opposite stand leg.
6. Tighten four button head screws (**Figure 5, item 1**) to 150 in-lb (17 N-m).

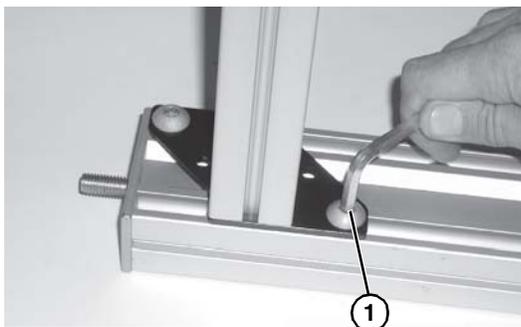


Figure 5

NOTE

Steps 7 and 8 apply to stands with casters only. For stands with feet, go to step 9.

Caster Kit (**Figure 2, item 9**) Components:

- | | |
|---|----------|
| 1 | Caster |
| 4 | Lock Nut |
- (Discard enclosed carriage bolt)

7. Open caster kit (**Figure 2, item 9**). Install caster (**Figure 6, item 1**) over bolt (**Figure 6, item 2**). Bolt is pre-assembled on stand leg (**Figure 6, item 3**). Secure caster with lock nut (**Figure 6, item 4**).

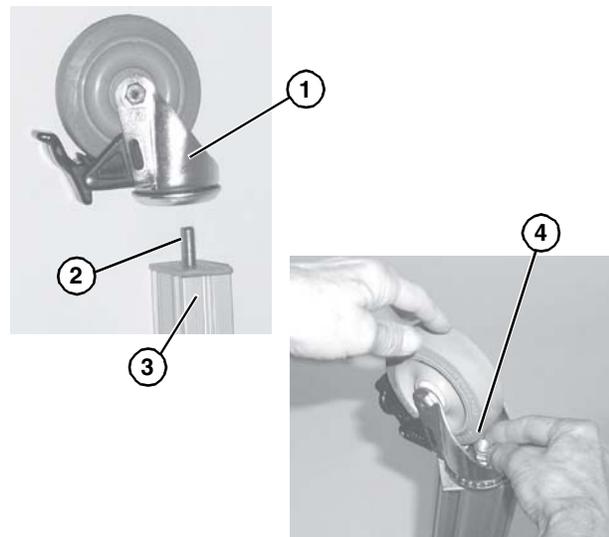


Figure 6

8. Tighten lock nut (**Figure 7, item 1**) to 30 ft-lb (40 N-m).

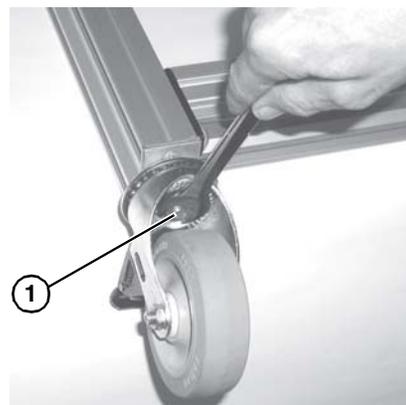


Figure 7

NOTE

Pivot bracket (**Figure 8, item 1**) must be installed on side of leg support (**Figure 8, item 2**) opposite of warning label (**Figure 8, item 3**). When installed, round end of pivot bracket will be down and warning label will be upright, as shown.

Screws (**Figure 8, item 4**) for attaching pivot brackets (**Figure 8, item 1**) to support legs (**Figure 8, item 2**) must be installed in opposite set of holes on opposite support leg to properly attach pivot brackets to conveyor.

- Open fully adjustable stand hardware pack (**Figure 2, item 3**). Attach pivot bracket (**Figure 8, item 1**) to leg support (**Figure 8, item 2**) with two flange socket head screws (**Figure 8, item 4**). Do not tighten screws.

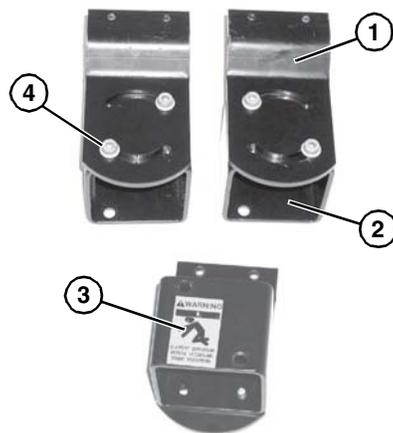


Figure 8

- Repeat step 9 for opposite pivot bracket (see note, above).
- Install two button head screws (**Figure 9, item 1**) and hex nuts (**Figure 9, item 2**) on leg support (**Figure 9, item 3**). Do not tighten screws.

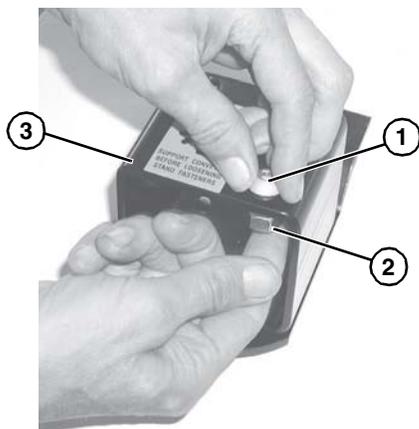


Figure 9

- Repeat step 11 for opposite leg support.

- Align hex nuts (**Figure 10, item 1**) on leg support (**Figure 10, item 2**) to t-slots at top, outside of stand leg (**Figure 10, item 3**). Slide leg support down stand leg until conveyor mounting holes (**Figure 10, item 4**) on pivot bracket (**Figure 10, item 5**) are approximately the same height as the lower t-slots on conveyor. Tighten button head screws (**Figure 10, item 6**) just enough to keep leg support in position.

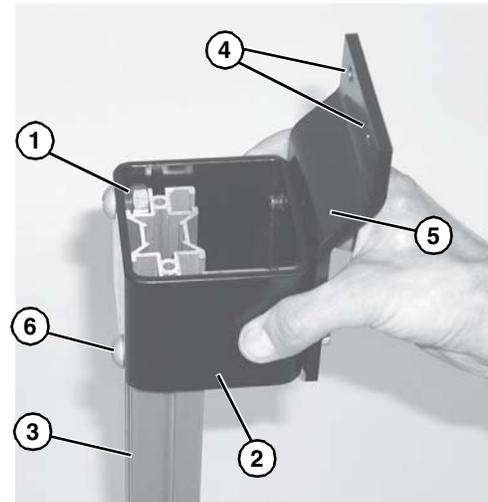


Figure 10

- Repeat step 13 for opposite stand leg.
- Install one t-bar (**Figure 11, item 1**) in bottom t-slot on each side of conveyor (**Figure 11, item 2**).

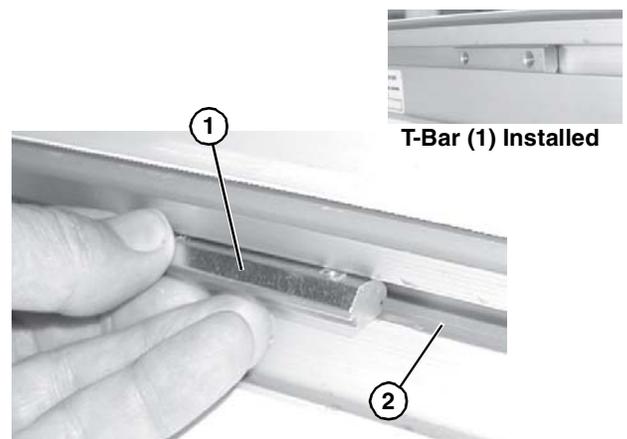


Figure 11

Installation

⚠ WARNING

<p>Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.</p> <p>SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.</p>
NOTE
<p><i>Make sure conveyor section is properly supported and at the proper height and angle before attaching stand.</i></p>

16. Attach pivot bracket (**Figure 12, item 1**) to t-bar (**Figure 11, item 1**) with two socket head screws (**Figure 12, item 2**). Do not tighten screws.

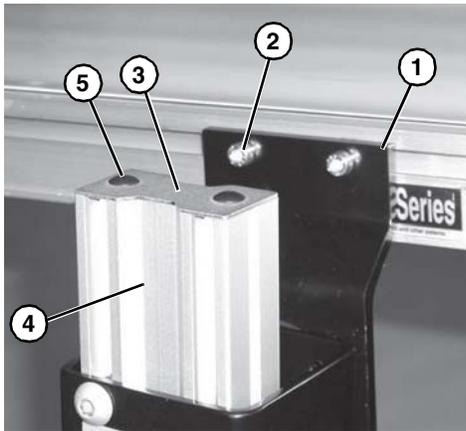


Figure 12

17. Repeat step 16 for opposite stand leg.

⚠ WARNING

<p>Failure to secure screws (Figure 10, item 6) may cause conveyor sections to drop down causing severe injury.</p> <p>TIGHTEN SCREWS (Figure 10, item 6) AFTER ADJUSTMENT.</p>

18. Tighten four socket head screws (**Figure 12, item 2**) to 124 in-lb (14 N-m).

19. Tighten four flange socket head screws (**Figure 8, item 4**) to 24 ft-lb (33 N-m).
20. Tighten four button head screws (**Figure 10, item 6**) to 17 ft-lb (22.5 N-m).
21. For final height and angle adjustments see page 10.
22. Attach tube end cover (**Figure 12, item 3**) on stand leg (**Figure 12, item 4**) with two plastic tree rivets (**Figure 12, item 5**).
23. Repeat step 22 for opposite stand leg.

Stands Shipped Fully Assembled

1. No stand assembly is required.
2. To attach stand to conveyor, see steps 15 through 18 starting on page 7.
3. For final height and angle adjustments see page 10.

Preventive Maintenance and Adjustment

Stand Height Adjustment

Required Tools

- 6 mm Hex Key Wrench

⚠ WARNING

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

⚠ WARNING

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

1. Support conveyor section (**Figure 13, item 1**).
2. Loosen two flange socket head screws (**Figure 13, item 2**) on each pivot bracket (**Figure 13, item 3**).
3. Loosen two button head screws (**Figure 13, item 4**) on each leg support (**Figure 13, item 5**).
4. Slide both leg supports (**Figure 13, item 5**) up or down on stand legs (**Figure 13, item 6**) to the required height. If necessary, adjust height of each leg support until conveyor is level from side to side.

⚠ WARNING

Failure to secure screws (Figure 13, item 4) may cause conveyor sections to drop down causing severe injury. TIGHTEN SCREWS (Figure 13, item 4) AFTER ADJUSTMENT.

5. Tighten four button head screws (**Figure 13, item 4**) to 17 ft-lb (22.5 N-m).
6. Tighten four flange socket head screws (**Figure 13, item 2**) to 24 ft-lb (33 N-m).



Figure 13

Preventive Maintenance and Adjustment

Conveyor Angle Adjustment

Required Tools

- 6 mm Hex Key Wrench

⚠ WARNING

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

1. Loosen two flange socket head screws (**Figure 14, item 1**) on both sides of stand.



Figure 14

2. Adjust conveyor to desired angle.

⚠ WARNING

<p>Failure to secure screws (Figure 14, item 1) may cause conveyor sections to drop down, causing severe injury.</p> <p>TIGHTEN SCREWS (Figure 14, item 1) AFTER ADJUSTMENT.</p>

3. Secure flange socket screws (**Figure 14, item 1**) to 24 ft-lb (18 Nm).

4. If conveyor is equipped with diagonal bracing (**Figure 15, item 1**), socket head screw (**Figure 15, item 2**) must be loosened to adjust conveyor angle. Secure screw to 100 in-lb (11 N-m) after angle adjustment.

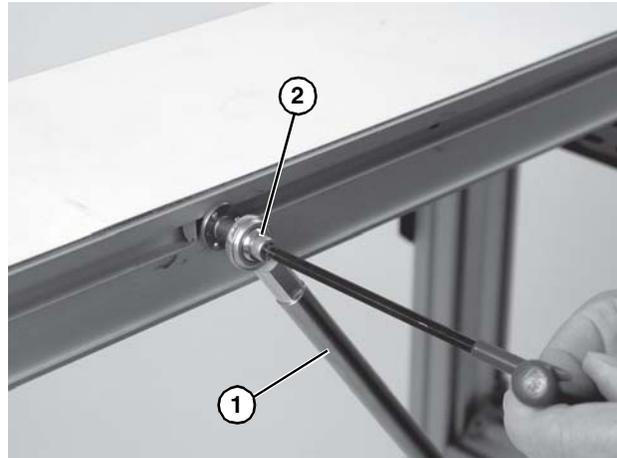


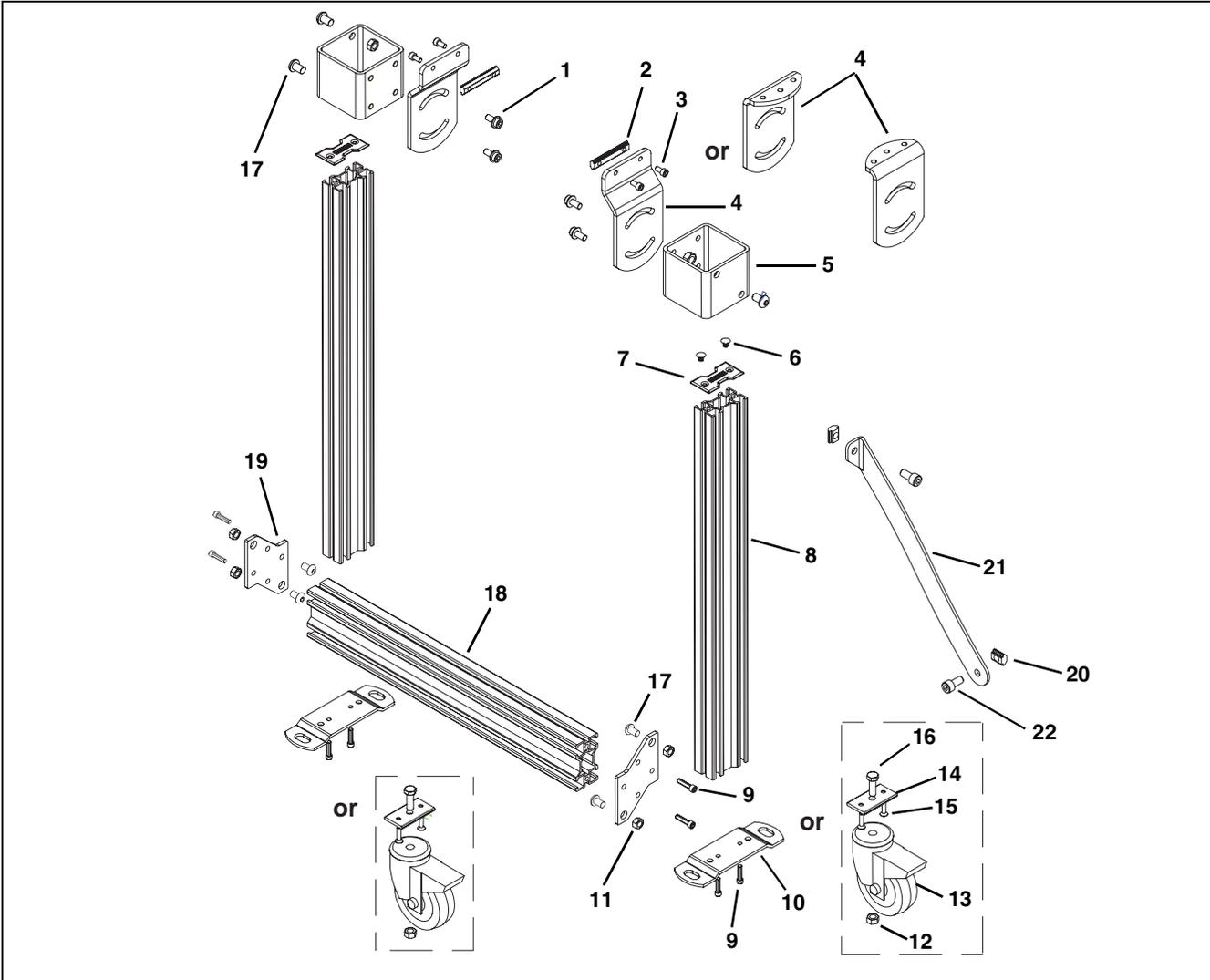
Figure 15

Service Parts

NOTE

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

Fully Adjustable Stand w/Feet or Casters



Item	Part Number	Description
1	960883M	Flange Socket Head Screw, M8-1.50x16MM
2	300150M	Bar, Tee, Drop-In, 1.88 CD Metric
3	920616M	Socket Head Screw, M6-1.00 x 16mm
4	300825M	Stand Bracket for 2200, 3200, 4100, and 6200 Series Conveyors
	352318	Stand Bracket for 5200 Series 8"-10" Wide
	352310	Stand Bracket for 5200 Series 12" Wide and Over
	300825M	Stand Bracket for 5200 Series Height Range 7"-19" for Fixed Foot Stands and 12"-19" for Caster Stands and for 3200 Modular Belt
5	710016	Bracket, Leg Support
6	807-1289	Rivet, Tree, 0.22 Dia. x 0.75 Long
7	710003	Cover, Tube End, Stand
8	710211-LLLLL	Leg, Stand
9	708180P	Socket Head Screw, M6-1.00 x 25mm
10	710004	Foot, Stand, Floor Mounting
11	991001M	Nut, Hex, Full M10-1.50
12	807-1303	Nut, Lock, Nylon M10-1.50
13	807-640	Caster, 4"
14	710221	Plate, Caster Mounting
15	930625M	Screw, Flat, Metric M6-1.0x25MM
16	961030M	Screw, Cap, HD-Hex M10-1.5x30MM
17	911016M	Screw, Button, Metric M10-1.50x16MM
18	710210-LLLLL	Crossmember
19	710006	Plate, End, Crossmember Stand
20	202390M	Cam Follower Nut, for Stands 20" wide and wider
21	734056	Angle Brace, for Stands 20" wide and wider
22	920816M	Socket Head Screw, M8-1.25 x 16mm, for Stands 20" wide and wider
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

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 (if available, part serial number).

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

Product Type									
Product Line	Standard Products								Engineered to order parts
	Conveyors	Gearmotors & Mounting Packages	Support Stands	Accessories	Spare Parts (non-belt)	Spare Belts - Standard Flat Fabric	Spare Belts - Cleated & Specialty Fabric	Spare Belts - Plastic Chain	All equipment and parts
1100	30% return fee for all products except: 50% return fee for conveyors with modular belt, cleated belt or specialty belts						non-returnable		case-by-case
2200									
2200 Modular Belt									
2200 Precision Move									
2300									
2300 Modular Belt									
3200									
3200 LPZ									
3200 Precision Move									
4100									
5200									
5300									
6200									
Controls									
7200 / 7300	50% return fee for all products								
7350	non-returnable								
7360									
7400									
7600									

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 factory, distributor, service center or visit our website at www.dorner.com.

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

 <p>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. 2014</p>	<p>DORNER MFG. CORP. 975 Cottonwood Ave., PO Box 20 Hartland, WI 53029-0020 USA TEL 1-800-397-8664 (USA) FAX 1-800-369-2440 (USA) Internet: www.dorner.com</p>	<p>Outside the USA: TEL 1-262-367-7600 FAX 1-262-367-5827</p>
---	--	---