6200 Series Industrial End Drive Conveyors

Installation, Maintenance & Parts Manual

Featuring: Wedge-Lok® Technology

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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 6200 Series conveyors are covered by Patent Nos. 5174435, 6109427, 6298981, 6685009 and corresponding patents and patent applications in other countries.

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

Dorner has convenient, pre–configured kits of Key Service Parts for all conveyor products. These time saving kits are easy to order, designed for fast installation, and guarantee you will have what you need when you need it. Key Parts and Kits are marked in the Service Parts section of this manual with the Performance Parts Kits logo .

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.

Product Description

Refer to Figure 1 for typical conveyor components.

A	Conveyor
B	Gearmotor
C	Belt (Cleated Belt Shown)
D	Mounting Plates
E	Stand Mounting Brackets
F	Support Stands
G	Variable Speed Controller
H	Drive End
I	Idler/Tension End

Figure 1

Specifications

Models:

Flat Belt 6200 Series Industrial Conveyor

Flat Belt 6200 Series Industrial Conveyor

6 D B M WW LLLL P GG BB

- **BB** – Belt Type*
- **GG** – Conveyor Profile*
- **P** – Output Shaft Position*
- **LLLL** – Conveyor Length Reference
- **WW** – Conveyor Width Reference
- **M** – Document Language, M = English
- **B** – 1= No wiper − with mounting bracket; 2 = No wiper − no mounting bracket; 3 = End wiper − with mounting bracket; 4 = End wiper − no mounting bracket; 5 = Dual wiper − with mounting bracket; 6 = Dual wiper − no mounting Bracket
- **D** – 2 = End drive; 3 = Gang drive

Cleated Belt 6200 Series Industrial Conveyor

Cleated Belt 6200 Series Industrial Conveyor

6 D B M WW LLLL P SSSS

- **SSSS** – Cleat Spacing*
- **P** – Output Shaft Position*
- **LLLL** – Conveyor Length Reference
- **WW** – Conveyor Width Reference
- **M** – Document Language, M = English
- **B** – 7= Low Friction Cleated − with mounting bracket; 8 = Low Friction Cleated − no mounting bracket
- **D** – Cleat type (A−J)*

* See “Ordering and Specifications” Catalog for details.

Specifications

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:

NOTE

Maximum conveyor loads based on:

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

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¨ (95mm)	5¨ (127 mm)	6¨ (152mm)	8¨ (203mm)	10¨ (254mm)	12¨ (305mm)	18¨ (457mm)
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)**

* See “Ordering and Specifications” Catalog for details.

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

NOTE

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

Figure 3

Required Tools

- Hex key wrenches: 4 mm, 5 mm
- 10 mm open–end wrench
- Level
- Torque wrench

Recommended Installation Sequence

- Assemble conveyor (if required)
- Attach mounting brackets to conveyor (see page 8)
- Install stands (see accessory instructions)
- Attach conveyor to stands
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see "Service Parts" section, page 23)

Conveyors Up to 13 ft (3962 mm)

No assembly is required. Install mounting brackets and return rollers. Refer to "Mounting Brackets" on page 8 and "Return Rollers" on page 9.

Conveyors Longer Than 13 ft (3962 mm)

1. Typical components (Figure 4)

N	Conveyor frame without belt
O	M6 x 10 mm Low–Head Screws (6x) (shipped loose)
P	Connector Strips (2x) (Attached to conveyor section)
Q	Conveyor frame with belt

Figure 4

2. Compress tension end (Figure 5). Refer to steps 3 and 4 under the "Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands" on page 13.

Figure 5

3. Roll out conveyor belt.
4. Place conveyor frame (Figure 6, item N) into belt loop.

Figure 6

5. Join conveyor sections (Figure 7, item N and Q). Install screws (O) through frame and into connector bar (P) on both sides. Tighten screws to 60 in-lb (7 Nm).

Figure 7

6. Tension conveyor belt. Refer to “Conveyor Belt Tensioning” on page 15.

Mounting Brackets

1. Typical mounting bracket components (Figure 8)

R	M6 x 12 mm Socket Head Screws (4x)
S	M6 x 20 mm Socket Head Screws (4x)
T	Hard Washer (4x)
U	M6 Square Nut (4x)
V	Stand Mounting Bracket (2x)
W	Mounting Plate, Flat Belt (2x) or
X	Mounting Plate, Cleated Belt (2x)

Figure 8

2. Attach clamp plate (Figure 8, item W or X) to stand mounting bracket (V) with two screws (R). Do not tighten screws.

3. Attach stand mounting bracket (Figure 9, item V) to bottom of conveyor (Y). Snug–up screws (R).

Figure 9

4. Repeat steps 2 and 3 for other stand mounting bracket(s).
5. Position conveyor (Figure 10, item Y) on stands (Z).

Figure 10

6. Attach stand mounting bracket (Figure 11, item V) to stand (Z) with two screws (S), hard washers (T) and square nuts (U). Tighten screws (S) to 80 in-lb (9 Nm).

Figure 11

7. Repeat step 6 for other stand mounting bracket(s).
8. Tighten all screws (R) to 80 in-lb (9 Nm).

Return Rollers

2¨ to 6¨ (44 mm to 152 mm) Wide Conveyor

NOTE

No return rollers are required on conveyor lengths up to 7 ft (2134 mm). Use one pair of rollers centered between the idler and drive spindles on 8–15 ft (2438–4572 mm) conveyors. Use two pairs of rollers at one third distances between the idler and drive spindles on 16–18 ft (4877–5486 mm) conveyors.

1. Typical return roller components (Figure 12)

AA	Return Roller Guard
AB	Return Roller Clip (Flat Belt)
AC	Low–Head Cap Screw M6–1.00 x 20mm (2)
AD	Return Roller Clip (Cleated Belt)

Figure 12

2. Loosely attach clip (Figure 13, item AB or AD) on guard (AA) with two screws (AC). Do not tighten screws.

Figure 13

3. Attach return roller assembly (Figure 14, item AE) on each side of conveyor (Y). Tighten screws (AC) to 80 in-lb (9 Nm).

Figure 14

4. On 8–18 ft (2338–5486 mm) conveyor, repeat step 3 as necessary for other return rollers.

8" to 18" (203 mm to 457 mm) Wide Flat Belt Conveyors

NOTE

No return rollers are required on conveyor lengths up to 7 ft (2134 mm). Use one roller centered between the idler and drive spindles on 8–15 ft (2438–4572 mm) conveyors. Use two rollers at one third distances between the idler and drive spindles on 16–18 ft (4877–5486 mm) conveyors.

1. Typical return roller components (Figure 15)

AF	Return Roller and Guard Assembly
AG	Return Roller Clip (2x)
AH	Low–Head Cap Screw M6–1.00 x 20mm (4x)

Figure 15

2. Loosely attach two clips (Figure 16, item AG) on roller and guard assembly (AF) with four screws (AH). Do not tighten screws.

Figure 16

3. Attach return roller assembly (Figure 17, item AI) on conveyor (Y). Tighten screws (Figure 16, item AH) to 80 in-lb (9 Nm).

Figure 17

4. On 16–18 ft (4877–5486 mm) conveyor, repeat step 3 for other return roller.

Required Tools

Standard Tools

- Hex key wrenches:
  2 mm, 2.5 mm, 3 mm, 4 mm, 5 mm and 6 mm
- Manual grease gun
- Adjustable wrench
- Arbor press

Special Tools

- 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
- 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.

NOTE

Only drive pulley bearings require lubrication (refer to the following steps). For all other bearings, replace if worn.

1. Disassemble support (Figure 18, item AJ) and remove hex shaft and shaft guard sections (AK).

Figure 18

NOTE

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

2. Install Dorner greasing adapter (part # 200046M) (Figure 19, item AL). Make sure the adapter shoulder is seated against the conveyor tail plate.

Figure 19

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 (Figure 18, item T).

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

Cleaning

Use Dorner Belt Cleaner. 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. If installed, remove and retain bottom wiper(s) (Figure 20, item AM).

Figure 20

2. If conveyor is equipped with guiding and accessories or return rollers, remove them as necessary.
3. On tension end of the conveyor identified with a label (Figure 21, item AN) and (Figure 22, item AN), loosen four M6 socket head cap screws (AO).

Figure 21

4. Retract idler spindle assembly (Figure 22, item AP) by pushing in on it or by turning M6 pinion screw (Figure 22, item AQ) and (Figure 23, item AQ) clockwise.

Figure 22

5. Remove conveyor belt (Figure 23, item AR).

Figure 23

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

NOTE

For conveyor with a Heavy Load Bottom or Top Mount Package, bracket (Figure 24, item AT) must be removed.

- *Remove two M6x16 mm socket head screws (AS).*
- *Remove two M6x12 mm socket head screws (AU).*
- *Remove bracket (AT).*

Figure 24

1. If installed, remove and retain bottom wiper(s) (Figure 20, item AM).
2. If conveyor is equipped with guiding and accessories or return rollers, remove them as necessary.
3. On tension end of the conveyor identified with a label (Figure 21, item AN) and (Figure 22, item AN), loosen four M6 socket head cap screws (AO).
4. Retract idler spindle assembly (Figure 22, item AP) by pushing it in or by turning M6 pinion screw (Figure 22, item AQ) and (Figure 23, item AQ) clockwise.

⚠ 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 (Figure 25, item AV) underneath the gearmotor while changing the belt.

5. Place a temporary support (Figure 25, item AV) under gearmotor mounting package.

Figure 25

6. Loosen two mounting plate screws (Figure 25, item R). Remove two screws (S), hard washers (T) and square nuts (U). Slide stand mounting bracket (V) off stand (Z) and remove from conveyor (Y).
7. Repeat step 6 for remaining stand mounting brackets on same side of conveyor.
8. Remove conveyor belt (Figure 26, item AR).

Figure 26

9. If a new belt will not be installed immediately, secure conveyor with mounting plate(s) and stand mounting bracket(s) (Figure 25, item V).

Belt Removal for Conveyor With Optional Gang Drive Pulley

1. Disassemble support (Figure 18, item AJ) and remove the hex shaft and shaft guard sections (AK).
2. If installed, remove and retain bottom wiper(s) (Figure 20, item AM).
3. If conveyor is equipped with guiding and accessories or return rollers, remove them as necessary.
4. On tension end of the conveyor identified with a label (Figure 21, item AN) and (Figure 22, item AN), loosen four M6 socket head cap screws (AO).
5. Retract idler spindle assembly (Figure 22, item AP) by pushing it in or by turning M6 pinion screw (Figure 22, item AQ) and (Figure 23, item AQ) clockwise.
6. Remove conveyor belt (Figure 23, item AR).

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 (Figure 27, item AW). With a reversing gearmotor, a second bottom wiper must be installed on opposite end.

Figure 27

1. Orient the conveyor belt so that the splice leading fingers (Figure 28, item AX) point in the direction of belt travel (AY) as identified by the label (Figure 27, item AW).

Figure 28

2. Slide belt (Figure 23, item AR) onto the conveyor frame assembly.
3. On a flat belt conveyor, install bottom wiper(s) (Figure 20, item AM). Center set screws in frame and tighten to 33 in-lb (3.7 Nm).
4. Tension belt. Refer to “Conveyor Belt Tensioning” on page 15.
5. Where applicable, install return rollers, guiding and accessories.

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

1. Orient conveyor belt so that the splice leading fingers (Figure 28, item AX) point in the direction of belt travel (AY) as identified by the label (Figure 27, item AW).
2. Slide belt (Figure 23, item AR) onto conveyor frame assembly.
3. Install stand mounting bracket (Figure 25, item V) onto stand (Z) and conveyor (Y). Refer to “Mounting Brackets” on page 8.
4. Repeat step 3 for remaining stand mounting brackets on same side of conveyor.
5. If removed, install bottom wiper(s) (Figure 20, item W). 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 (Figure 24, item AT).
7. Tension belt. Refer to “Conveyor Belt Tensioning” on page 15.
8. Where applicable, install return rollers, guiding and accessories.

Belt Installation for Conveyor With Optional Gang Drive Pulley

1. Orient the conveyor belt so that the splice leading fingers (Figure 28, item AX) point in the direction of belt travel (AY) as identified by the label (Figure 27, item AW).
2. Slide belt (Figure 23, item AR) onto the conveyor frame assembly.
3. If removed, install bottom wiper(s) (Figure 20, item W). Center set screws in frame and tighten to 33 in-lb (3.7 Nm).
4. Tension belt. Refer to “Conveyor Belt Tensioning” on page 15.
5. Where applicable, install return rollers, guiding and accessories.
6. Re-assemble hex shaft with guards sections (Figure 18, item AK). Re-assemble support (AJ).

Conveyor Belt Tensioning

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

1. On tension end of the conveyor identified with a label (Figure 21, item AN) and (Figure 22, item AN), loosen four M6 low head screws (AO).

NOTE

The M6 low head screw (Figure 29, item AZ), which is used for extending the idler spindle assembly to tension the belt, has a yellow colored head.

Do not exceed a torque of 25 in-lb (2.8 Nm) for 2¨ to 12¨ (44 mm to 305 mm) wide conveyors or 40 in-lb (4.5 Nm) for an 18¨ (457 mm) wide conveyor on this screw. Over-tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

2. Idler spindle assembly
   a. For an existing belt, extend idler spindle assembly (Figure 29, item AP) by turning M6 low head screw (AZ) clockwise to sufficiently tension belt to handle conveyor load.
   b. For a new belt, extend idler spindle assembly

(Figure 29, item AP) 1¨ (25 mm) (BA) by turning M6 low head screw (AZ) clockwise.

Figure 29

3. Tighten four M6 low head screws (Figure 21, item AO), (Figure 22, item AO) and (Figure 29, item AO) to 40 in-lb (4.5 Nm) to secure idler spindle assembly (AP).

NOTE

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

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 12. Remove the desired pulley following instructions:

- A – Drive Pulley with Standard 0.47¨ (12 mm) Diameter Output Shaft
- B – Idler Pulley
- C – 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, remove key (Figure 30, item BB) and two M5 low head screws (BC) to remove outboard bearing (BD).

Figure 30

NOTE

Two screws (Figure 30, item BF) were removed in step 1.

3. Remove screw (BE) on drive shaft side of conveyor.
4. Remove three (3) screws (Figure 31, item BG) on side opposite of drive shaft.
5. Remove drive spindle assembly (BH).

Figure 31

6. Remove screw (Figure 32, item BI).
7. Remove headplate (BJ).
8. Remove pulley (BK).

Figure 32

B – Idler Pulley Removal

1. Remove two screws (Figure 33, item AO) on each side of conveyor.

Figure 33

2. Loosen two screws (Figure 34, item AQ and AZ).

Figure 34

3. Remove two screws (Figure 35, item AQ and AZ) and sleeves (BL) from conveyor (Y) and hex pinion (BM).

Figure 35

4. Remove two pinion ends (Figure 36, item BN), Wedge-Lok® clamp blocks (BO), hex pinion (BM) and tail assembly (BP) from conveyor (Y).

Figure 36

NOTE
Note which side of conveyor magnet (Figure 37, item BQ) is located.

5. Locate magnet (Figure 37, item BQ) on spindle and bearing assembly (BR).

Figure 37

6. Remove screw (BS), headplate (BT), and spindle and bearing assembly (BR).

C – Gang Drive Pulley Removal

* - Parts required from Tool Kit, part number 2500M.

1. Remove two M5 low head screws (Figure 38, item BU) and clip (BV) from head plate (BW).

Figure 38

2. Repeat step 1 for opposite side.
3. Install bolt (part # 906-278*) (Figure 39, item BY) into retaining sleeve (BX). Pull out on bolt to remove retaining sleeve.

Figure 39

4. Repeat step 3 for opposite side.

NOTE

If retaining sleeve(s) (Figure 38, item BX) and (Figure 39, item BX) does not slide out::

- *Remove tail assembly following steps 3, 4 and 5 of Removal of Drive Pulley with Standard 0.47¨ (12 mm) Diameter Output Shaft on page 16*
- *Assemble removal tool (part # 25-09*) (Figure 40, item BZ) and bolt (part # 906-278*) (BY) on spindle (CA), as shown*
- *Tighten bolt (BY) to remove bearing sleeve (Figure 38, item BX) and (Figure 39, item BX) from spindle (Figure 40, item CA).*

Figure 40

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) (Figure 41, item CC) over bearing (CD) with lip (CE) located in gap (CF) between bearing and spindle (CB) as shown.

Figure 41

2. Using 3/16¨ hex key wrench (Figure 42, item CG), tighten bearing removal tool.

Figure 42

3. Using a puller (Figure 43, item CH), remove and discard bearing(s).

Figure 43

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) (Figure 44, item CI) onto pulley shaft.

Figure 44

3. Slide the sleeve of tool (part # 450282) (Figure 45, item CK) over bearing.

Figure 45

4. Place open end of shaft (Figure 46, item CL) into sleeve.

Figure 46

5. Using arbor press or similar device, press bearing onto pulley shaft (Figure 47).

Figure 47

6. Repeat steps 1 through 5 for each bearing.

Bearing Replacement for Gang Drive Pulley

* - Parts required from Tool Kit, part number 2500M.

IMPORTANT
Once removed, do not re-use bearings.

Bearing Removal

NOTE
The bearings of a 2¨ (51 mm) wide gang drive pulley cannot be replaced. Order pulley assembly (part # 454702).

1. Insert bearing removal tool (part # 25-05*) (Figure 48, item CN) into the pulley (CQ) until shoulder (CM) seats against bottom of bearing (CR).

Figure 48

2. While holding bearing removal tool (CN) in position, insert extension tool (part # 25-08*) (CO) into opposite end of pulley (CQ). Rotate bearing removal tool (CN) to engage hex tip of extension tool (CO) into screw (CP).
3. While maintaining extension tool (CO) position, use a wrench to rotate bearing removal tool (CN) to expand flare.

Figure 49

4. Orient bearing anvil/sleeve removal tool (part # 25-09*) (Figure 50, item CS) with cavity facing up and place pulley onto tool.

Figure 50

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

5. Press bearing out of pulley.

Figure 51

Bearing Installation

1. Orient bearing anvil/sleeve removal tool (part # 25-09*) (Figure 52, item CS) with cavity facing up and place pulley (CQ) onto tool.

Figure 52

2. Install bearing insertion tool (part # 25-10*) (Figure 53, item CT) into arbor press or similar device.

Figure 53

3. Place and hold bearing (part # 21-33) (CR) onto tool (CT).

Figure 54

IMPORTANT
Bearing and pulley alignment is critical.

4. Press bearing (Figure 55, item CR) into pulley (CQ) until seated.

Figure 55

Pulley Replacement

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

1. Reverse the removal procedure “A” (see page 16).

Idler Pulley Replacement

IMPORTANT
On a tension tail assembly, orient both pinion ends (Figure 56, item BN) so they engage the same tooth positions on their respective racks.

Figure 56

1. Reverse the removal procedure “B” (see page 17).

Gang Drive Pulley Replacement

IMPORTANT
When installing clips (Figure 57, item BV), ensure step (CU) is toward head plate (BW).

Figure 57

1. Reverse the removal procedure “C” (see page 18).

NOTE

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

Drive End Components

Item	Part Number	Description
1	456021	Head Plate LH 2–3” (51–76mm) Wide
	456022	Head Plate LH 4–18” (102–457mm) Wide
2	807–1022	Low–Head Pilot Screw M5–.8x12mm
3	62BK4	Ball Bearing 12mm Bore x 21mm OD (x4)
4	980422M	Square Key 4mm x 22mm
5	4531WWM	Drive Spindle
6	456025	Head Plate RH 2–3” (51–76mm) Wide
	456026	Head Plate RH 4–18” (102–457mm) Wide
7	807–963	Plastic Snap–Out Plug
8	4536WWM	Support Tension/Fixed
9	950612M	Low–Head Cap Screw M6–1.0x12mm
10	802–148	Ball Bearing 12mm Bore x 24mm OD (used on 10” (254mm), 12” (305mm) and 18” (457mm) conveyors, only)
11	456032	Outboard Bearing Plate (used on 10” (254mm), 12” (305mm) and 18” (457mm) conveyors, only)

Item	Part Number	Description
12	807–1022	Low–Head Pilot Screw M5–.8x12mm
13	62DTA–WW	Drive Tail Kit – A & B Positions (Includes Items 1 through 11)
	62DTD–WW	Drive Tail Kit – C & D Positions (Includes Items 1 through 11)
14	62D–WW	Drive Spindle Kit (Includes Items 2 through 5, and if applicable, 10, 11 and 12)
15	4527WWM	Bottom Wiper
16	970508M	Cup–Point Set Screw M5–.80 x 8mm
17	4525WWM	Frame Support Post
18	807–1022	Low–Head Pilot Screw M5–.8x12mm
19	456033	Outboard Bearing Assembly (includes items 10 & 11)
WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18		

Service Parts

Tension End Components

Item	Part Number	Description
1	950612M	Description Low–Head Cap Screw M6 x 12mm
2	4525WWM	Frame Support Post
3	950625M	Low–Head Cap Screw M6 x 25mm
4	950620M	Low–Head Cap Screw M6 x 20mm
5	807–1022	Low–Head Pilot Screw M5 x 12mm
6	456011	Head Plate Tension RH 2–3” (51–76mm) Wide
	456012	Head Plate Tension RH 4–18” (102–457mm) Wide
7	62BK4	Ball Bearing 12mm Bore x 21mm OD (x4)
8	4530WW	Idler Spindle (includes ref. 16 & 17)
9	456014	Head Plate Tension LH 2–3” (51–76mm) Wide
	456015	Head Plate Tension LH 4–18” (102–457mm) Wide

Item	Part Number	Description
10	456049	Sleeve .312 OD x .035 Wall
11	456045	Pinion End
12	456041	Wedge-Lok® Clamp Block
13	4563WW	Hex Pinion
14	4536WW	Support Tension/Fixed
15	808–020	Magnet .25 x .25
16	450226SSP	SS Sleeve .25 Magnet
17	807–1317	Low–Head Cap Screw M6 x 12mm (Yellow)
18	62TT–WW	Tensioning Tail Kit (Includes Items 3 through 17)
19	62T–WW	Tensioning Spindle Kit (Includes Items 7, 8, 15 and 16)
WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18		

Conveyor Frame and Extensions

Item	Part Number	Description
1	450160M	Bar Connecting Frame
2	950610M	Low–Head Cap Screw M6–1.0x10mm

Item	Part Number	Description
3	See Conveyor Frame chart	Conveyor Frame
4	See Conveyor Frame chart	Conveyor Frame Extension

Items 3 and 4: Conveyor Frame		
Length	**Frame Part Number**	**Frame Extension Part Number**
2’ (610mm)	4720WW–01860	n/a
3’ (914mm)	4720WW–03060	n/a
4’ (1219mm)	4720WW–04260	n/a
5’ (1524mm)	4720WW–05460	n/a
6’ (1829mm)	4720WW–06660	n/a
7’ (2134mm)	4720WW–07860	n/a
8’ (2438mm)	4720WW–09060	n/a
9’ (2743mm)	4720WW–10260	n/a
10’ (3048mm)	4720WW–11460	n/a
11’ (3353mm)	4720WW–12660	n/a
12’ (3658mm)	4720WW–13860	n/a

Items 3 and 4: Conveyor Frame		
Length	**Frame Part Number**	**Frame Extension Part Number**
13’ (3962mm)	4720WW–07860	4740WW
14’ (4267mm)	4720WW–09060	4740WW
15’ (4572mm)	4720WW–10260	4740WW
16’ (4877mm)	4720WW–11460	4740WW
17’ (5182mm)	4720WW–12660	4740WW
18’ (5486mm)	4720WW–13860	4740WW
19’ (5791mm)	4720WW–07860	4741WW
20’ (6096mm)	4720WW–09060	4741WW
21’ (6401mm)	4720WW–10260	4741WW
22’ (6706mm)	4720WW–11460	4741WW
23’ (7011mm)	4720WW–12660	4741WW
24’ (7316mm)	4720WW–13860	4741WW
WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18		

Service Parts

Gang Drive Thru–Shaft Option

Item	Part Number	Description
1	62GDSK	Bearing Sleeve Kit (x2)
2	See Drive Spindle chart	Drive Spindle
3	950612M	Low–Head Cap Screw M6–1.0x12mm
4	456027	Fixed Plate RH
5	4536WWM	Tension Support Fixed
6	456023	Fixed Plate LH
7	62GDTA–WW	Gang Drive Tail Kit (Includes Items 1 through 6) A Position
	62GDTD–WW	Gang Drive Tail Kit (Includes Items 1 through 6) D Position
8	62GD–WW	Gang Drive Spindle Kit (Includes Items 1 through 4)
9	4527WWM	Thick Bottom Wiper 0.4970 Thick *
	4528WWM	Thin Bottom Wiper 0.4538 Thick **

Item	Part Number	Description
10	970508M	Socket Head Set Screw M5–.80 x 8mm

WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18
* Use with belts /01, /02, /05, /06, /54, /56, /57, /59, /60, /61, /63, /66
** Use with belts /03, /08, /55, /64

Item 4: 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 0.5” (13mm) Bolt–On High Side Guides

Item	Part Number	Description
1	See chart below	6200 Guide .5” (13mm) HS
2	460058	Spacer Guide Clip
3	460059	Clip Guide .75” long
4	460060	Guide Clip Spacer
5	460250K10	Clip Mounting Guide (x10)
6	807–1359	Low Head Pilot Screw, M5–.80 x 25mm
7	950610M	Low Head Cap Screw, M6–1.00 x 10mm
8	950616M	Low Head Cap Screw, M6–1.00 x 16mm

6200 Guide .5” (13mm) HS			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	460055–02400	N/A
	Right Hand	460055–02400	N/A
3’ (914mm)	Left Hand	460055–03600	N/A
	Right Hand	460055–03600	N/A
4’ (1219mm)	Left Hand	460055–04800	N/A
	Right Hand	460055–04800	N/A
5’ (1524mm)	Left Hand	460055–06000	N/A
	Right Hand	460055–06000	N/A
6’ (1829mm)	Left Hand	460055–07200	N/A
	Right Hand	460055–07200	N/A
7’ (2134mm)	Left Hand	460055–08400	N/A
	Right Hand	460055–08400	N/A

6200 Guide .5” (13mm) HS			
Length		End Guide	End Guide
8’ (2438mm)	Left Hand	460055–09600	N/A
	Right Hand	460055–09600	N/A
9’ (2743mm)	Left Hand	460055–10800	N/A
	Right Hand	460055–10800	N/A
10’ (3048mm)	Left Hand	460055–12000	N/A
	Right Hand	460055–12000	N/A
11’ (3353mm)	Left Hand	460055–13200	N/A
	Right Hand	460055–13200	N/A
12’ (3658mm)	Left Hand	460055–14400	N/A
	Right Hand	460055–14400	N/A
13’ (3962mm)	Left Hand	460255–08139	460255–07460
	Right Hand	460155–08139	460155–07460
14’ (4267mm)	Left Hand	460255–09339	460255–07460
	Right Hand	460155–09339	460155–07460
15’ (4572mm)	Left Hand	460255–10539	460255–07460
	Right Hand	460155–10539	460155–07460
16’ (4877mm)	Left Hand	460255–11739	460255–07460
	Right Hand	460155–11739	460155–07460
17’ (5182mm)	Left Hand	460255–12939	460255–07460
	Right Hand	460155–12939	460155–07460
18’ (5486mm)	Left Hand	460255–14139	460255–07460
	Right Hand	460155–14139	460155–07460

Service Parts

–03 Bolt–On Side Wipers

Item	Part Number	Description
1	See chart below	6200 Guide .5” (13mm) HS
2	41–00–24	Wiper Side Nylatron (per foot)
3	460058	Spacer Guide Clip
4	460059	Clip Guide .75” long
5	460060	Guide Clip Spacer
6	460250K10	Clip Mounting Guide (x10)
7	807–1359	Low Head Pilot Screw, M5–.80 x 25mm
8	950610M	Low Head Cap Screw, M6–1.00 x 10mm
9	950616M	Low Head Cap Screw, M6–1.00 x 16mm

6200 Guide .5” (13mm) HS			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	460055–02400	N/A
	Right Hand	460055–02400	N/A
3’ (914mm)	Left Hand	460055–03600	N/A
	Right Hand	460055–03600	N/A
4’ (1219mm)	Left Hand	460055–04800	N/A
	Right Hand	460055–04800	N/A
5’ (1524mm)	Left Hand	460055–06000	N/A
	Right Hand	460055–06000	N/A
6’ (1829mm)	Left Hand	460055–07200	N/A
	Right Hand	460055–07200	N/A
7’ (2134mm)	Left Hand	460055–08400	N/A
	Right Hand	460055–08400	N/A

6200 Guide .5” (13mm) HS			
Length		End Guide	End Guide
8’ (2438mm)	Left Hand	460055–09600	N/A
	Right Hand	460055–09600	N/A
9’ (2743mm)	Left Hand	460055–10800	N/A
	Right Hand	460055–10800	N/A
10’ (3048mm)	Left Hand	460055–12000	N/A
	Right Hand	460055–12000	N/A
11’ (3353mm)	Left Hand	460055–13200	N/A
	Right Hand	460055–13200	N/A
12’ (3658mm)	Left Hand	460055–14400	N/A
	Right Hand	460055–14400	N/A
13’ (3962mm)	Left Hand	460255–08139	460255–07460
	Right Hand	460155–08139	460155–07460
14’ (4267mm)	Left Hand	460255–09339	460255–07460
	Right Hand	460155–09339	460155–07460
15’ (4572mm)	Left Hand	460255–10539	460255–07460
	Right Hand	460155–10539	460155–07460
16’ (4877mm)	Left Hand	460255–11739	460255–07460
	Right Hand	460155–11739	460155–07460
17’ (5182mm)	Left Hand	460255–12939	460255–07460
	Right Hand	460155–12939	460155–07460
18’ (5486mm)	Left Hand	460255–14139	460255–07460
	Right Hand	460155–14139	460155–07460

–04 3” (76 mm) Bolt – On High Side Guides

Item	Part Number	Description
1	See chart below	6200 Guide 3” (76mm) HS
2	460058	Spacer Guide Clip
3	460059	Clip Guide .75” long
4	460060	Guide Clip Spacer
5	460250K10	Clip Mounting Guide (x10)
6	807–1359	Low Head Pilot Screw, M5–.80 x 25mm
7	950610M	Low Head Cap Screw, M6–1.00 x 10mm
8	950616M	Low Head Cap Screw, M6–1.00 x 16mm

6200 Guide 3” (76mm) HS			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	460057–02400	N/A
	Right Hand	460057–02400	N/A
3’ (914mm)	Left Hand	460057–03600	N/A
	Right Hand	460057–03600	N/A
4’ (1219mm)	Left Hand	460057–04800	N/A
	Right Hand	460057–04800	N/A
5’ (1524mm)	Left Hand	460057–06000	N/A
	Right Hand	460057–06000	N/A
6’ (1829mm)	Left Hand	460057–07200	N/A
	Right Hand	460057–07200	N/A
7’ (2134mm)	Left Hand	460057–08400	N/A
	Right Hand	460057–08400	N/A

6200 Guide 3” (76mm) HS			
Length		End Guide	End Guide
8’ (2438mm)	Left Hand	460057–09600	N/A
	Right Hand	460057–09600	N/A
9’ (2743mm)	Left Hand	460057–10800	N/A
	Right Hand	460057–10800	N/A
10’ (3048mm)	Left Hand	460057–12000	N/A
	Right Hand	460057–12000	N/A
11’ (3353mm)	Left Hand	460057–13200	N/A
	Right Hand	460057–13200	N/A
12’ (3658mm)	Left Hand	460057–14400	N/A
	Right Hand	460057–14400	N/A
13’ (3962mm)	Left Hand	460257–08139	460257–07460
	Right Hand	460157–08139	460157–07460
14’ (4267mm)	Left Hand	460257–09339	460257–07460
	Right Hand	460157–09339	460157–07460
15’ (4572mm)	Left Hand	460257–10539	460257–07460
	Right Hand	460157–10539	460157–07460
16’ (4877mm)	Left Hand	460257–11739	460257–07460
	Right Hand	460157–11739	460157–07460
17’ (5182mm)	Left Hand	460257–12939	460257–07460
	Right Hand	460157–12939	460157–07460
18’ (5486mm)	Left Hand	460257–14139	460257–07460
	Right Hand	460157–14139	460157–07460

Service Parts

–05 1.5” (38mm) Bolt–On High Side Guides

Item	Part Number	Description
1	See chart below	6200 Guide 1.5” (38mm) HS
2	460058	Spacer Guide Clip
3	460059	Clip Guide .75” long
4	460060	Guide Clip Spacer
5	460250K10	Clip Mounting Guide (x10)
6	807–1359	Low Head Pilot Screw, M5–.80 x 25mm
7	950610M	Low Head Cap Screw, M6–1.00 x 10mm
8	950616M	Low Head Cap Screw, M6–1.00 x 16mm

6200 Guide 3” (76mm) HS			
Length		End Guide	End Guide
2’ (610mm)	Left Hand	460056–02400	N/A
	Right Hand	460056–02400	N/A
3’ (914mm)	Left Hand	460056–03600	N/A
	Right Hand	460056–03600	N/A
4’ (1219mm)	Left Hand	460056–04800	N/A
	Right Hand	460056–04800	N/A
5’ (1524mm)	Left Hand	460056–06000	N/A
	Right Hand	460056–06000	N/A
6’ (1829mm)	Left Hand	460056–07200	N/A
	Right Hand	460056–07200	N/A
7’ (2134mm)	Left Hand	460056–08400	N/A
	Right Hand	460056–08400	N/A

6200 Guide 3” (76mm) HS			
Length		End Guide	End Guide
8’ (2438mm)	Left Hand	460056–09600	N/A
	Right Hand	460056–09600	N/A
9’ (2743mm)	Left Hand	460056–10800	N/A
	Right Hand	460056–10800	N/A
10’ (3048mm)	Left Hand	460056–12000	N/A
	Right Hand	460056–12000	N/A
11’ (3353mm)	Left Hand	460056–13200	N/A
	Right Hand	460056–13200	N/A
12’ (3658mm)	Left Hand	460056–14400	N/A
	Right Hand	460056–14400	N/A
13’ (3962mm)	Left Hand	460256–08139	460256–07460
	Right Hand	460156–08139	460156–07460
14’ (4267mm)	Left Hand	460256–09339	460256–07460
	Right Hand	460156–09339	460156–07460
15’ (4562mm)	Left Hand	460256–10539	460256–07460
	Right Hand	460156–10539	460156–07460
16’ (4877mm)	Left Hand	460256–11739	460256–07460
	Right Hand	460156–11739	460156–07460
17’ (5182mm)	Left Hand	460256–12939	460256–07460
	Right Hand	460156–12939	460156–07460
18’ (5486mm)	Left Hand	460256–14139	460256–07460
	Right Hand	460156–14139	460156–07460

–13 Fully Adjustable UHMW Guides

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)

Item	Part Number	Description
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 M6–1.0 x 8mm
10	920655M	Socket Head Cap Screw M6–1.0 x 55mm

–20 Adjustable Width UHMW Guides

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)

Item	Part Number	Description
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 M6–1.0 x 12mm
8	920620M	Socket Head Cap Screw M6–1.0 x 20mm
9	970620M	Socket Head Set Screw M6–1.0 x 20mm

1” (25mm) Cleated Belt Conveyor Guides

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	950610M	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

Conveyor Length		End Guide	Center Guide	End Guide
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’ (4562mm)	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

Service Parts

2” (51mm) Cleated Belt Conveyor Guides

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	950610M	M6–1.0 x 10mm Low Head Screw
6	910506M	M5–0.8 x 6mm Button Head Screw
7	990508MSS	M5 Acorn Nut

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

Length		End Guide	Center Guide	End Guide
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’ (4562mm)	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

2” (51mm) Through 6” (152mm) Flat Belt and Cleated Belt Return Roller

Item	Part Number	Description
1	802–027	Sealed Ball Bearing
2	913–103	Dowel Pin
3	450598	Return Roller Guard

Item	Part Number	Description
4	950620M	Low–Head Cap Screw M6–1.0 x 20mm
5	450599	Return Roller Clip Flat Belt
6	450597	Return Roller Clip Cleated Belt
7	240840	Roller Assy.

8” (203mm) Through 18” (457mm) Flat Belt Return Roller

Item	Part Number	Description
1	240826	Return Roller
2	950616M	Low–Head Cap Screw M6–1.0 x 16mm
3	450599	Return Roller Clip Flat Belt

Item	Part Number	Description
4	4511WW	Return Roller Guard
5	2410WW	Return Roller Rod
WW = Conveyor width ref.: 08, 10, 12, 18		

Service Parts

Conveyor Mounting Brackets

Item	Part Number	Description
1	920620M	Socket Head Cap Screw M6–1.0 x 20mm
2	605279P	Hard Washer
3	807–920	Square Nut M6–1.0
4	920612M	Socket Head Cap Screw M6–1.0 x 12mm

Item	Part Number	Description
5	456031	Stand/Conveyor Mounting Bracket
6	450588	Mount Plate – Flat Belt
7	450586	Mount Plate – Cleated Belt

Configuring Conveyor Belt Part Number

Figure 58

Flat Belt

Refer to your serial and model number plate (Figure 58). From the model number, determine conveyor width (WW), length (LLLL), and belt type (BB). Use data to configure belt part number as indicated below.

6D–WWLLLL/BBV

62–__ __ __ __ __ __ / __ __ V

(Fill In)

Cleated Belt

Refer to your serial and model number plate (Figure 58). From the model number, determine conveyor type (D), width (WW), length (LLLL), belt cleat type (B) and cleat spacing (SSSS). Use data to configure belt part number as indicated below.

6D–WWLLLLBSSSSV

6__ – __ __ __ __ __ __ __ __ __ __ V

(Fill In)

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 (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.

<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 & Specialty Fabric</th><th>Spare Belts - Plastic Chain</th><th>All equipment and parts</th></tr>
<tr><td>1100</td><td colspan="6" rowspan="13">30% return fee for all products except:
50% return fee for conveyors with modular belt, cleated belt or specialty belts</td><td colspan="2" rowspan="13">non-returnable</td><td rowspan="13">case-by-case</td></tr>
<tr><td>2200</td></tr>
<tr><td>2200 Modular Belt</td></tr>
<tr><td>2200 Precision Move</td></tr>
<tr><td>2300</td></tr>
<tr><td>2300 Modular Belt</td></tr>
<tr><td>3200</td></tr>
<tr><td>3200 LPZ</td></tr>
<tr><td>3200 Precision Move</td></tr>
<tr><td>4100</td></tr>
<tr><td>5200</td></tr>
<tr><td>5300</td></tr>
<tr><td>6200</td></tr>
<tr><td>Controls</td></tr>
<tr><td>7200 / 7300</td><td colspan="6">50% return fee for all products</td></tr>
<tr><td>7350</td><td colspan="9" rowspan="4">non-returnable</td></tr>
<tr><td>7360</td></tr>
<tr><td>7400</td></tr>
<tr><td>7600</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 factory, distributor, service center or visit our website at www.dorner.com.

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

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. 2015

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