



2200 Series Gang Drive Conveyors

Installation, Maintenance & Parts Manual



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Introduction


IMPORTANT

Some illustrations may show guards removed. DO NOT operate equipment without guards.

Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

Dorner 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.

Dorner 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981, 6,422,382 and corresponding patents and patent applications in other countries.

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.

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 | Drive End |
| C | Tension End |
| D | Belt |
| E | Hex Drive Shaft |

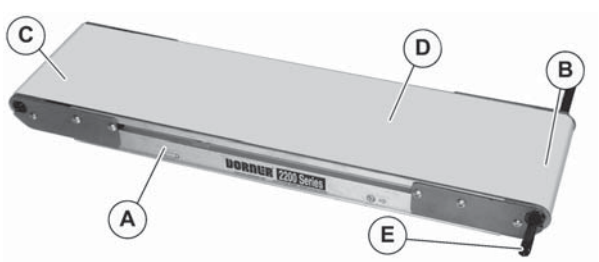


Figure 1

Specifications

Model:

2200 Series Gang Drive Conveyor

| 2200 Series Gang Drive Conveyors | | | | | | | | | | | | |
|----------------------------------|---|----|-------|---|---|---|---|----|----|----|--|------------------------------|
| 202 | M | WW | -LLLL | G | D | I | D | PA | PD | BB | | |
| | | | | | | | | | | | | Belt Type |
| | | | | | | | | | | | | Profile (D side) |
| | | | | | | | | | | | | Profile (A side) |
| | | | | | | | | | | | | Motor Shaft Position |
| | | | | | | | | | | | | Idler Tail Type |
| | | | | | | | | | | | | Drive Tail Type |
| | | | | | | | | | | | | Tracking / Mounting Brackets |
| | | | | | | | | | | | | Conveyor Length |
| | | | | | | | | | | | | Conveyor Width |
| | | | | | | | | | | | | Document Language |

* See Ordering and Specifications Catalog for details.

Specifications

| | | | | | | | | | | | |
|---|---|--------------------|--------------------|--------------------|--------------------|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|
| Conveyor Width Reference (WW) | 02 | 03 | 04 | 05 | 06 | 08 | 10 | 12 | 18 | 21*** | 24*** |
| Conveyor Belt Width | 1.75" (44mm) | 2.75" (70mm) | 3.75" (95mm) | 5" (127mm) | 6" (152mm) | 8" (203mm) | 10" (254mm) | 12" (305mm) | 18" (457mm) | 21" (533mm) | 24" (609mm) |
| Maximum Conveyor Load* (See NOTE Below) | 30 lb (14kg) | 35 lb (16kg) | 42 lb (19kg) | 50 lb (23kg) | 60 lb (27kg) | 70 lb (32kg) | 80 lb (36kg) | 80 lb (36kg) | 80 lb (36kg) | 80 lb (36kg) | 80 lb (36kg) |
| Conveyor Startup Torque* | 2 in-lb (0.5Nm) | 3 in-lb (0.6Nm) | 4 in-lb (0.7Nm) | 6 in-lb (0.8Nm) | 8 in-lb (0.9Nm) | 10 in-lb (1.1Nm) | 12 in-lb (1.4Nm) | 14 in-lb (1.5Nm) | 15 in-lb (1.7Nm) | 18 in-lb (2.0Nm) | 20 in-lb (2.3Nm) |
| Belt Travel | 4.0" (88 mm) per revolution of pulley | | | | | | | | | | |
| Maximum Belt Speed* | 264 ft/minute (80.5 m/minute) | | | | | | | | | | |
| Belt Takeup | 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 Up to 18 ft in any length to nearest 0.12" (3mm) | 2-ft (610 mm) | 3-ft (914 mm) | 4-ft (1219 mm) | 5-ft (1524 mm) | 6-ft (1829 mm) | 7-ft (2134 mm) | 8-ft (2438 mm) | 9-ft (2743 mm) | 10-ft (3048 mm) | 11-ft (3353 mm) | 12-ft (3658 mm) | 13-ft (3962 mm)** | 14-ft (4267 mm)** | 15-ft (4572 mm)** | 16-ft (4877 mm)** | 17-ft (5182 mm)** | 18-ft (5486 mm)** |

NOTE

Maximum conveyor loads based on:

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

* See Ordering and Specifications Catalog for details.

** Lengths available only in 6" (152 mm) and wider conveyors.

*** V-guide tracking belt not available on 21" (533 mm) or 24" (610 mm) wide gang drive conveyors.

Installation

Required Tools

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

Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor (if required)
- Attach mounting brackets to conveyor
- Attach conveyor to stands
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 19 through page 28 of “Service Parts” section for details)

Conveyors Up to 12 ft (3658 mm)

No assembly is required. Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 7 and “Return Rollers” on page 7.

Conveyors Longer Than 12 ft (3658 mm)

1. Locate and arrange conveyor sections (Figure 2) by section labels.



Figure 2

NOTE

Tension end of conveyor is identified with a label (Figure 3, item G).

2. At tension end on both sides of conveyor, loosen and move cam tracking assemblies (I) (if equipped) away from head plates.

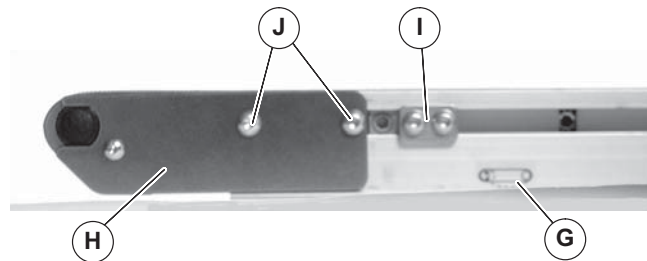


Figure 3

3. Loosen two screws (J) on both sides of conveyor and then push tail assembly (H) inward.
4. Roll out conveyor belt and place conveyor frame sections (Figure 4, item F) into belt loop.



Figure 4

5. Join conveyor sections and install connector brackets (Figure 5, item K) or connector/mount brackets (KA) and screws (L) on both sides as indicated. Tighten screws to 60 in-lb (7 Nm).

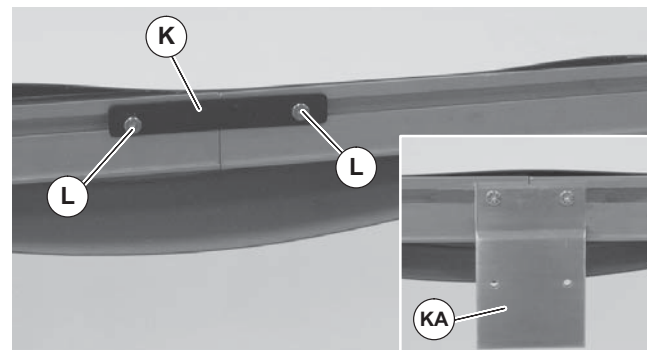


Figure 5

6. With a 5 mm hex-key wrench, rotate pinion gear (Figure 6, item M) to tension the conveyor belt. Tighten two screws (J) on both sides of conveyor to 80 in-lb (9 Nm). For proper tensioning, refer to “Conveyor Belt Tensioning” on page 10.

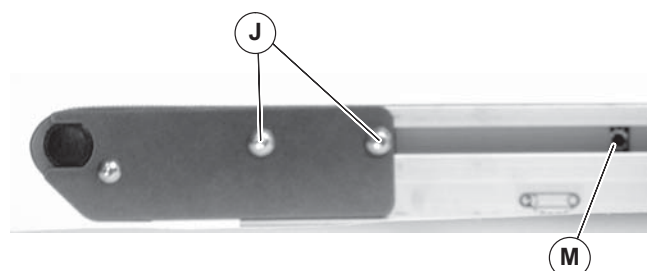


Figure 6

7. Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 7 and “Return Rollers” on page 7.
8. If equipped with cam tracking assemblies (Figure 3, item I), reposition and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 10.

Mounting Brackets

1. Locate mounting bracket assemblies. Exploded views are shown in Figure 7.

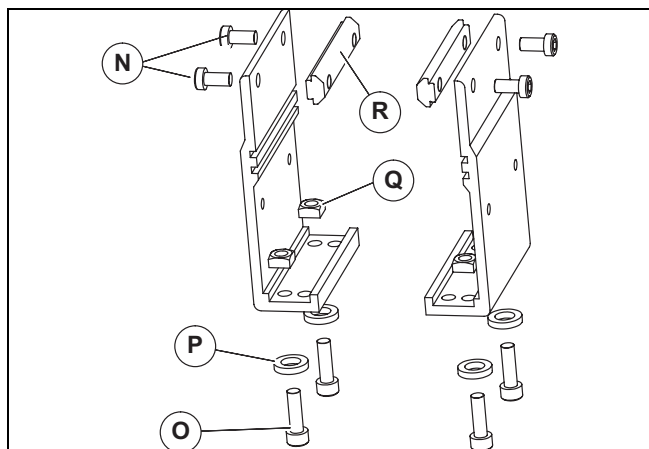


Figure 7

2. Remove screws (Figure 7, item N and O), washers (P), nuts (Q) and T-bars (R) from brackets.
3. Insert T-bars (Figure 7, item R) into conveyor side slots (Figure 8, item S). Fasten brackets (T) to conveyor and T-bars (R) with mounting screws (N).

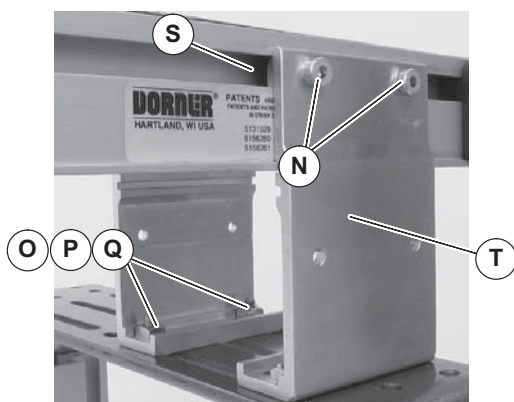


Figure 8

4. Fasten brackets to support stand with mounting screws (O), washers (P) and nuts (Q).
5. Tighten screws (N and O) to 60 in-lb (7 Nm).

Return Rollers

2" (51mm) through 6" (152mm) Wide Conveyors

1. Locate return roller assemblies. Exploded views are shown in Figure 9.

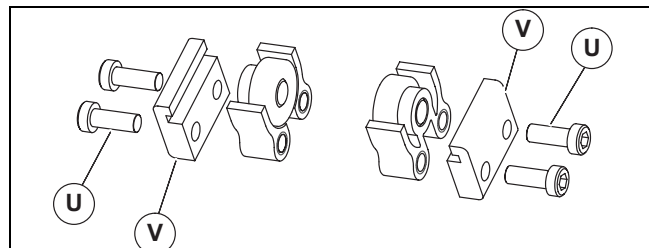


Figure 9

2. Remove screws (Figure 9, item U) and clips (V) from roller assembly.
3. Install roller assemblies (Figure 10, item W) as shown. Tighten screws (U) to 60 in-lb (7 Nm).

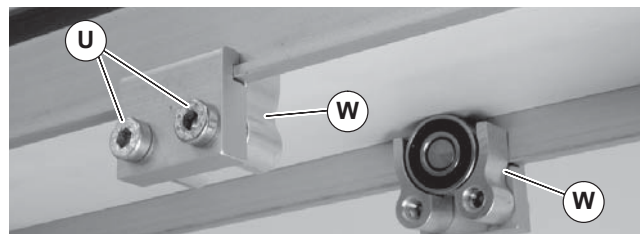


Figure 10

8" (203mm) through 24" (610mm) Wide Conveyors

1. Locate return roller(s). Exploded view is shown in Figure 11.

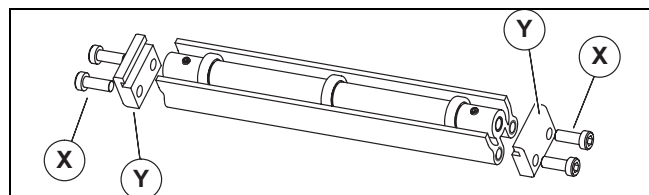


Figure 11

2. Remove screws (X) and clips (Y) from roller assembly.
3. Install roller assembly (Figure 12, item Z) as shown. On each side of conveyor, tighten screws (X) to 60 in-lb (7 Nm).



Figure 12

Preventive Maintenance and Adjustment

Required Tools

Standard Tools

- Hex-key wrenches:
2.5 mm, 4 mm, 5 mm
- Arbor press

Special Tools

- 807–1078 Bearing Puller Tool
- 450292 Sealed Bearing Installation Tool
- 2500M Tool Kit for Gang Drive Bearings

Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner (part # 625619)
- Clean entire conveyor and knurled pulley while disassembled
- Replace worn or damaged parts

Lubrication

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 wipers (if installed)
- Accumulated dirt in wipers (if installed)
- 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

| IMPORTANT |
|--|
| <i>Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.</i> |

Use Dorner Belt Cleaner (part # 625619). Mild soap and water may also be used. Do not soak the belt.


For /05 woven polyester and /06 black anti-static belts, use a bristled brush to improve cleaning.

Preventive Maintenance and Adjustment

Conveyor Belt Replacement

Belt Removal for Conveyor Without Stands or Gearmotor Mounting Package

NOTE

Tension end of conveyor is identified with a  label (Figure 3, item G).

1. At tension end on both sides of conveyor, loosen belt tracking cam assemblies (Figure 13, item I) (if equipped) and slide them toward middle of conveyor.

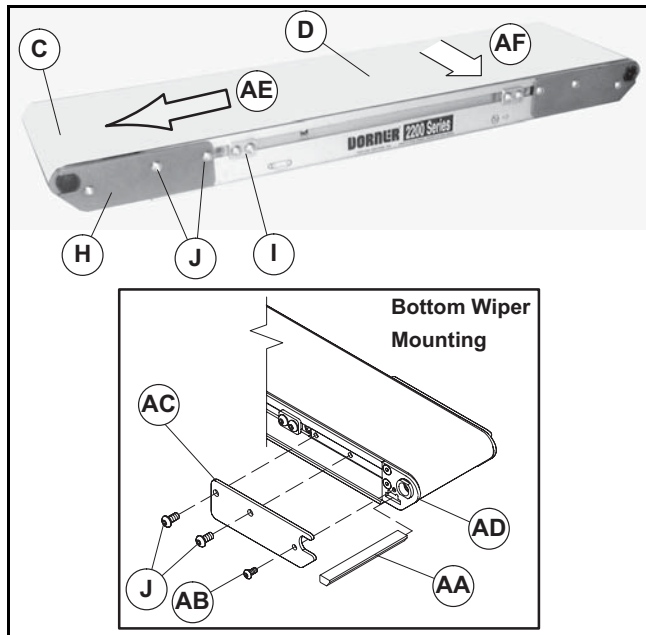


Figure 13

2. At tension end (C) on both sides of conveyor, loosen two tail cover plate screws (J).
3. Push tail assembly (H) into conveyor frame. This will loosen belt sufficiently for removal.
4. If installed, remove bottom wiper (AA) at discharge end of conveyor as follows: Remove three tail cover plate screws (J and AB) on one side of conveyor. Remove tail cover plate (AC) and slide out bottom wiper (AA) through hole in head plate (AD).
5. Slide old belt (D) sideways (AF) off of conveyor.

Belt Installation for Conveyor Without Stands or Gearmotor Mounting Package

1. Orient replacement belt so belt splice leading fingers (Figure 14, item AG) point in direction of belt travel (AE) and that outside fingers (AH) are positioned as shown.

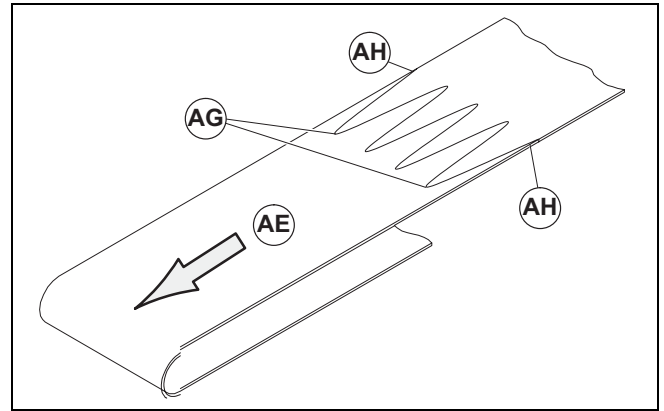


Figure 14

2. Slide new belt sideways onto conveyor frame assembly
3. If removed, slide bottom wiper (Figure 13, item AA) into slot in head plate (AD).
4. Install tail cover plate (AC) and three screws (J and AB) to secure bottom wiper at discharge end of conveyor. Securely tighten screws.
5. Refer to "Conveyor Belt Tensioning" on page 10, and set conveyor belt tension.
6. At tension end on both sides of conveyor, slide belt tracking cam assemblies (I) (if equipped) until tight against tail assembly (H).
7. Refer to "Conveyor Belt Tracking Adjustment" on page 10 to adjust belt tracking after start-up.

Preventive Maintenance and Adjustment

Conveyor Belt Tensioning

1. Locate tension end (Figure 15, item C) of conveyor, identified with a label (G).

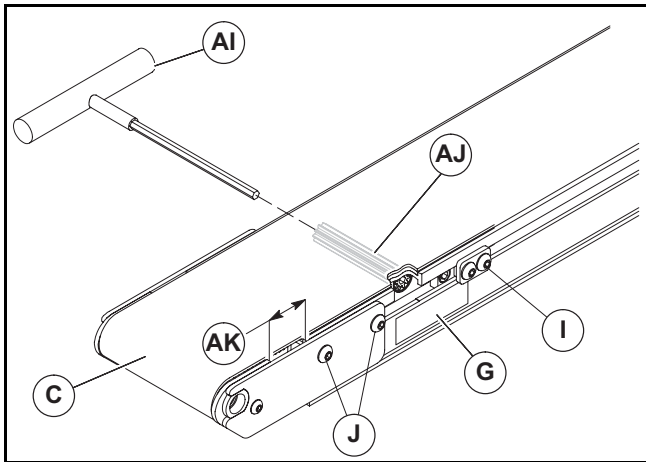


Figure 15

2. If equipped, loosen and slide belt tracking cam assemblies (I) towards center of conveyor on both sides of tension end (C).
3. Loosen tail cover plate screws (J) on both sides of tension end (C).
4. Insert a hex key wrench (AI) into either end of pinion (AJ).
5. Rotate pinion (AJ) to extend tensioning end until gap (AK) between pulley plate and conveyor frame measures 1.19" (30 mm) for a new belt or as required to stop belt slippage on drive pulley.

NOTE

Over-tensioning adds unnecessary loading to the pulley bearings.

6. While holding pinion (AJ) in tensioned position, tighten cover plate screws (J) on both sides of conveyor. Torque screws to 18 in/lb (2 Nm).
7. Position belt tracking cam against the slide bar while making sure groove is correctly oriented. See Figure 16, below.

Conveyor Belt Tracking

V-Guided Belts

V-guided belts do not require tracking adjustment.

Non V-Guided Belts

Non V-guided belt conveyors are equipped with belt tracking cam assemblies (Figure 16, item I) for belt tracking adjustment.

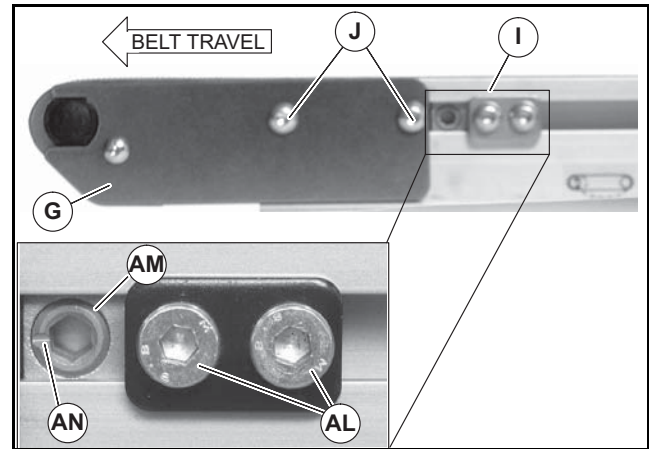


Figure 16

When adjusting belt tracking, always adjust the discharge end of the conveyor first. To adjust belt tracking:

1. Ensure tail cover plate screws (Figure 16, item J) on both sides of conveyor are tight.
2. On both sides of conveyor, loosen two cam fastening screws (AL). Adjust cams (AM) until indicator slots (AN) are horizontal and facing end of conveyor. Then slide cam assemblies against head plates (G) and re-tighten cam fastening screws (AL) to 60 in-lb (7 Nm).
3. On the side toward which the belt is tracking, loosen head plate fastening screws (J).
4. With conveyor running, use a 5 mm hex-key wrench to rotate tracking cam (AM) in small increments until belt tracks in center of conveyor. Then while holding cam in position, tighten head plate fastening screws (J) to 60 in-lb (7 Nm).

Preventive Maintenance and Adjustment

Pulley Replacement

Pulley Removal

1. Remove conveyor belt. Refer to the “Conveyor Belt Replacement” topic beginning on page 9.
2. Remove tail cover plate screws (Figure 17, item J and AB) and tail cover plates (AC) on both sides of the conveyor.

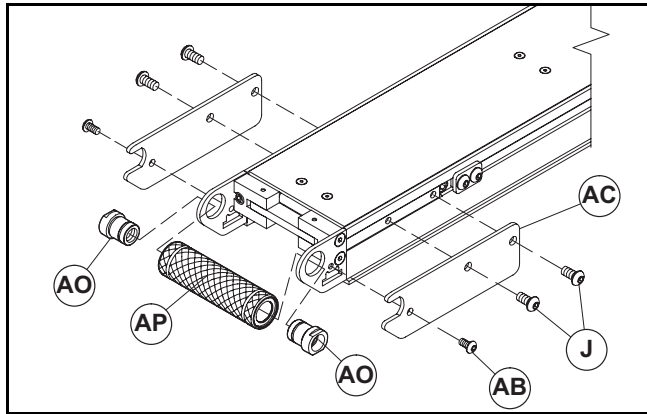


Figure 17

3. Remove the retaining sleeves (AO) and pulley (AP). If retaining sleeves are frozen, continue with the next step.
4. All non-driven positions have a plastic plug (Figure 18, item AQ) installed into ends of pulley retaining sleeves (AO). Use a small flat screwdriver to remove these plugs.

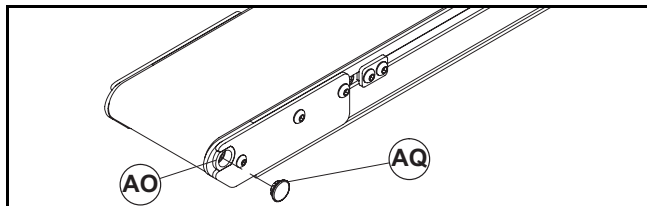


Figure 18

5. Position bearing anvil/sleeve removal tool (Figure 19, item AR), part number §25-09, over retaining sleeve (Figure 17, item AO) and (Figure 19, item AO).

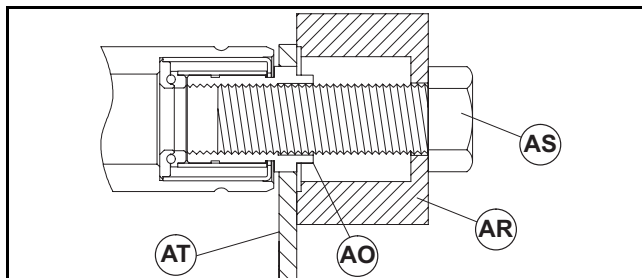


Figure 19

6. Insert special threaded bolt (Figure 19, item AS), part number §906-278, through bearing anvil/sleeve removal tool (AR) and thread into retaining sleeve (AO).

7. Tighten bolt (AS) until retaining sleeve (AO) is free of spindle tail plate (AT).
8. Remove retaining sleeve (AT) from the bolt (AS).
9. Repeat steps 5 through 8 for the other side.
10. Remove pulley (AR) from conveyor frame.

§- Part of Tool Kit, Part Number 2500M.

α - Shipped with conveyors wider than 12" (305 mm).

Pulley Installation

1. Insert pulley (Figure 17, item AP) between the spindle tail plates (AT).
2. Slide the retaining sleeves (AO) through openings in the spindle tail plates and into the pulley on each side.
3. Install the plastic plug (Figure 18, item AQ) into the ends of the pulley retaining sleeves (AO).
4. Secure the tail cover plates (Figure 17, item AC) to the conveyor with screws (J and AB).
5. Install conveyor belt. Refer to the “Belt Installation (No Stands or Gearmotor Mounting Package)” topic beginning on page 9.

Pulley Bearing Replacement

Bearings in the pulleys on the 2" (44 mm) wide conveyor cannot be replaced. If the bearings are worn, the entire pulley must be replaced. Refer to Spindle chart on page 7 for the correct part number for your conveyor.

Bearings in pulleys on the 3" (70 mm) and wider conveyors can be removed with Dorner Bearing Removal Tool (Figure 20, item AU), part number §25-05.

§- Part of Tool Kit, Part Number 2500M.

Bearing Removal

Use procedure below to remove pulley bearings:

NOTE

To ensure bearing removal tool (Figure 20, item AU) will fit into bearing, make sure that the flair (AV) on bearing removal tool is completely closed.

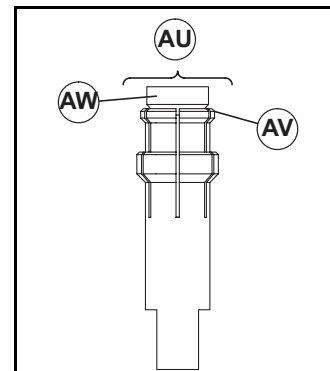


Figure 20

Preventive Maintenance and Adjustment

1. Using hex key wrench extension tool (Figure 21, item AX), either part number §25-08 or ¢25-08A, loosen tapered screw (Figure 20, item AW) on bearing removal tool (AU) to compress flair (AV) until flair is completely closed.

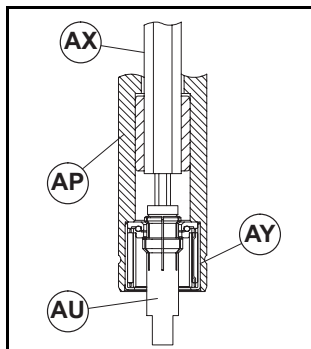


Figure 21

2. Insert bearing removal tool (Figure 21, item AU) into pulley (AP) through bearing (AY).
3. While holding hex key wrench extension tool (Figure 22, item AX), rotate bearing removal tool using flats (AZ) to tighten bearing removal tool's tapered screw (AW) until flair (AV) of tool is completely spread open inside bearing (AY).

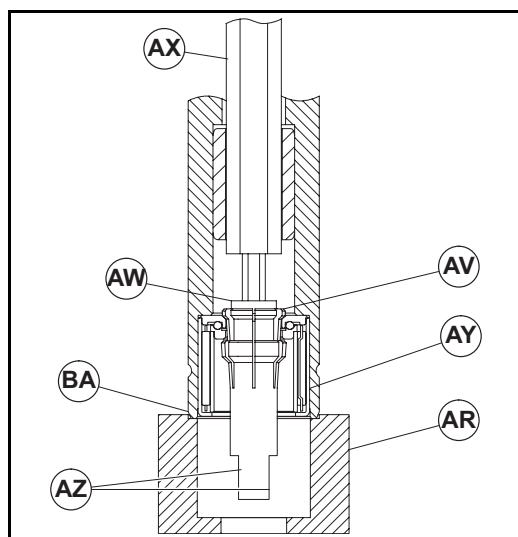


Figure 22

4. Support pulley end (BA) with bearing anvil/sleeve removal tool (Figure 19, item AR) and (Figure 22, item AR), part number §25-09. Using an arbor press, push bearing (AY) out of the pulley into bearing anvil/sleeve removal tool (AR).

IMPORTANT

Heavy tapping or hammering will damage the hex key wrench extension tool (AX) and/or bearing (AY).

§- Part of Tool Kit, Part Number 2500M.

¢ - Shipped with conveyors wider than 12" (305 mm).

Bearing Installation

Use the following procedure to install pulley bearings (Figure 23, item AY).

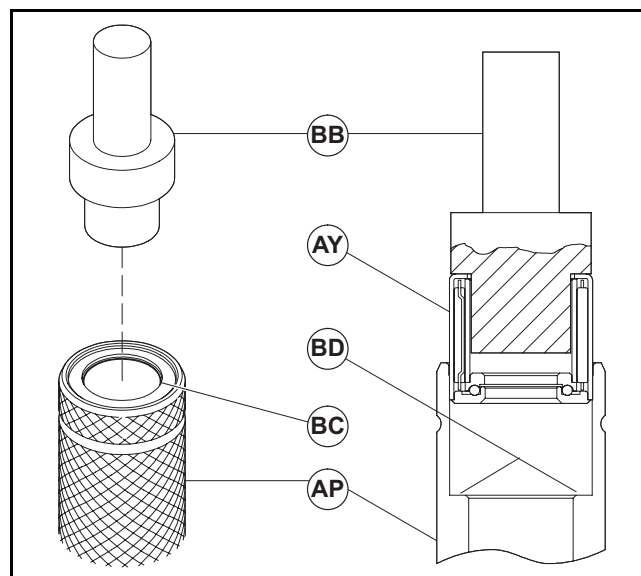


Figure 23

1. Support pulley (AP) in an upright position with "V" blocks or other means. Support bottom end of pulley using bearing anvil/sleeve removal tool (Figure 22, item AR).
2. Install bearing insertion tool (Figure 23, item BB), part number §25-10 in an arbor press.
3. Align bearing insertion tool (BB) with pulley bore (BC).
4. Slide bearing (AY) onto bearing insertion tool.

NOTE


Keep bearings (AY) and pulley (AP) aligned when installing. Misalignment tilts bearing and may result in bearing damage.

5. Press bearing (AY) firmly and slowly into pulley (AP) until it bottoms out on pulley shoulder (BD). If bearing fits too loosely in the pulley bore (BC) or if the bore is out of round, the pulley must be replaced.

§- Part of Tool Kit, Part Number 2500M.

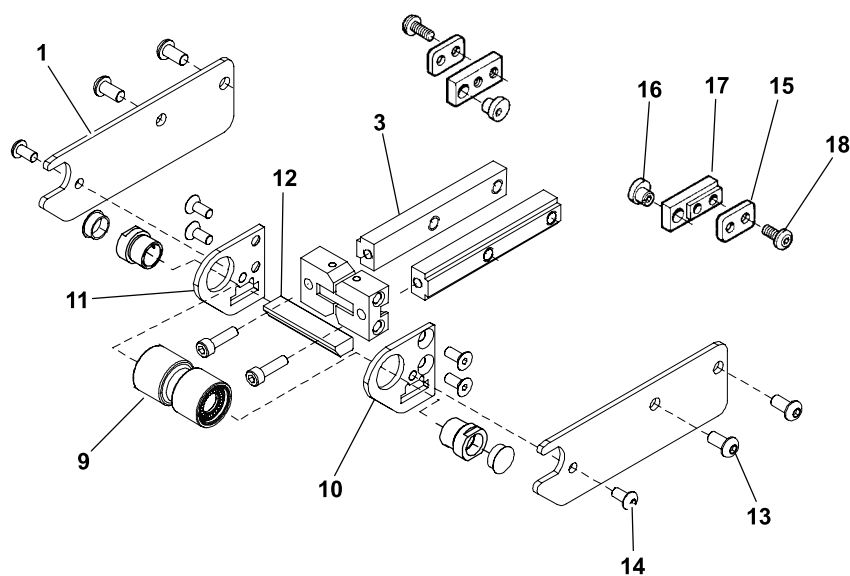
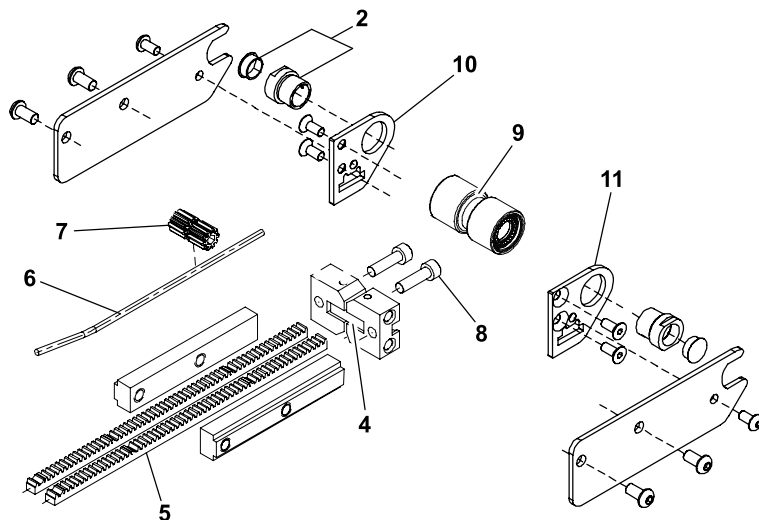
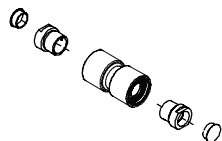
Service Parts

NOTE

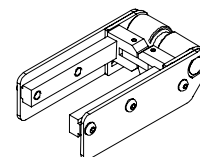
For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory. Key Service Parts and Kits are identified by the Performance Parts Kits logo . Dorner recommends keeping these parts on hand.

2" (51mm) Wide Conveyor Ends

19 Gang Drive Spindle Kit



20 Gang Drive Tail Kit



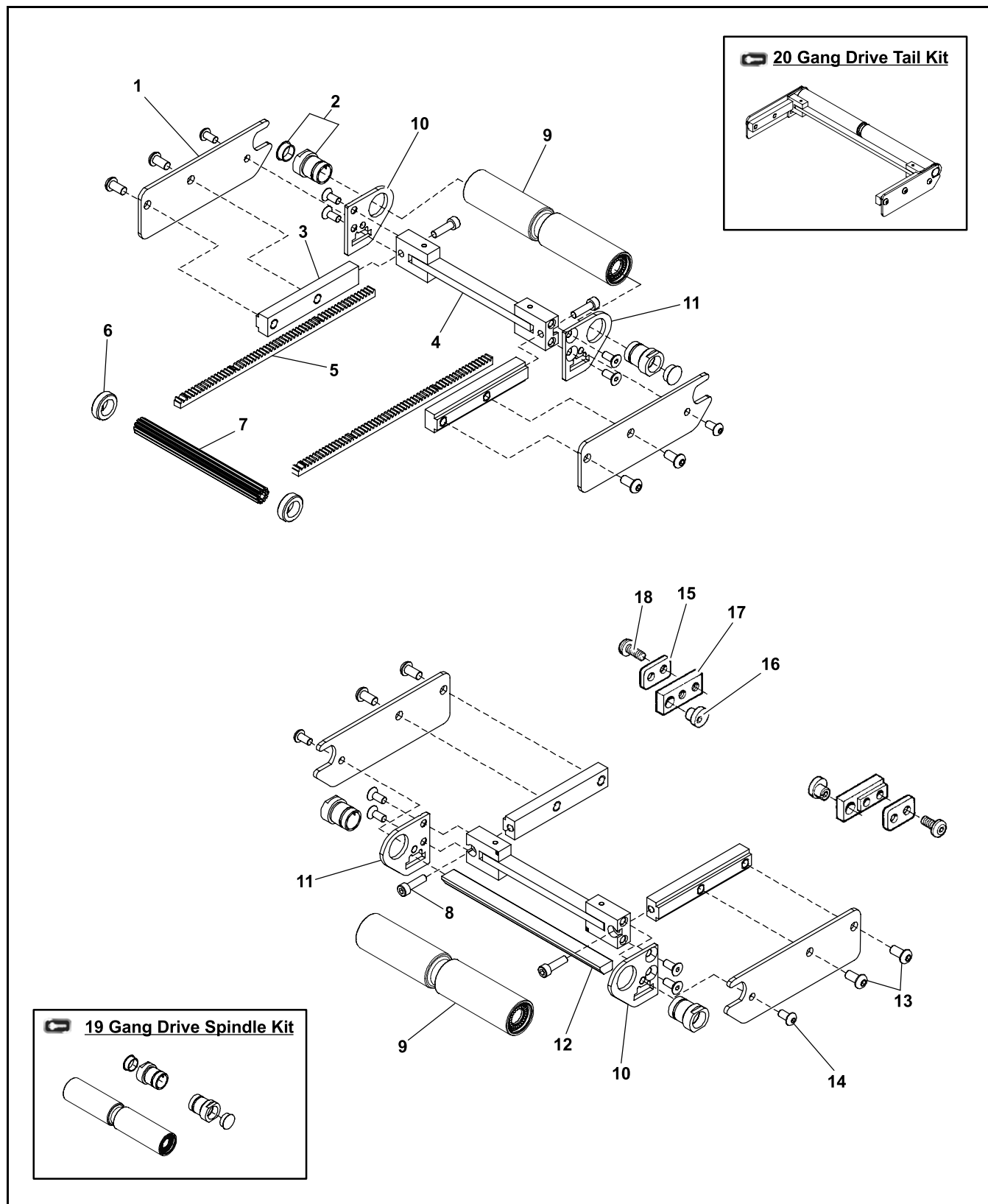
Service Parts

| Item | Part Number | Description |
|------|-------------|------------------------------|
| 1 | 200030M | Cover Plate |
| 2 | 22GDSK2 | 2" Bearing Sleeve Kit (x2) |
| 3 | 241128 | Head Plate Bar |
| 4 | 201337-02 | Articulating Bar Assembly |
| 5 | 240420 | Rack Gear 14.5 PA x 24 P |
| 6 | 240422 | Pinion Pin |
| 7 | 240423 | Pinion 2" (51mm) |
| 8 | 920518M | Socket Head Screw M5 x 18mm |
| 9 | 454702 | Spindle w/Bearings 2" (51mm) |
| 10 | 200027M | Tail Plate, RH |
| 11 | 200028M | Tail Plate, LH |
| 12 | 203502 | Bottom Wiper |

| Item | Part Number | Description |
|------|-------------|---|
| 13 | 910612M | Button Head Screw M6 x 12mm |
| 14 | 910510M | Button Head Screw M5 x 10mm |
| 15 | 200038 | Cam Clamping Plate |
| 16 | 200039P | Belt Tracking Cam |
| 17 | 200341M | Cam Retaining Block |
| 18 | 920692M | Socket Low Head Cap Screw M6 x 12mm |
| 19 | 22GD-02 | Gang Drive Spindle Kit (Includes Items 2 and 9) |
| 20 | 22GDTA-02 | Gang Drive Tail Kit (Includes Items 1 through 4, 8 through 11, and 13) A Position |
| | 22GDTD-02 | Gang Drive Tail Kit (Includes Items 1 through 4, 8 through 11, and 13) D Position |

Service Parts

3" (76mm) to 24" (610mm) Wide Conveyor Ends

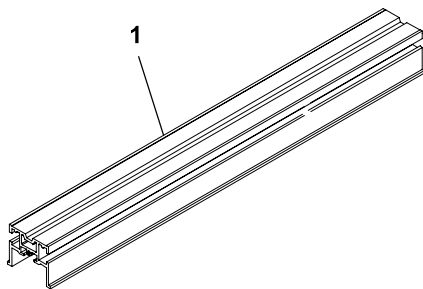


Service Parts

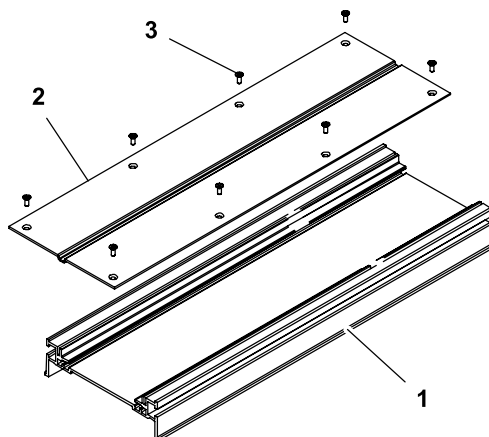
| Item | Part Number | Description |
|--|-------------------|--|
| 1 | 200030M | Cover Plate |
| 2 | 22GDSK | Bearing Sleeve Kit (x2) |
| 3 | 241128 | Head Plate Bar |
| 4 | 201337- <u>WW</u> | Articulating Bar Assembly |
| 5 | 240420 | Rack Gear 14.5 PA x 24 P |
| 6 | 240421 | Pinion Bushing [3" (76mm) through 6" (152mm) Wide Conveyors Only] |
| 7 | 2030 <u>WW</u> M | Pinion |
| 8 | 920518M | Socket Head Cap Screw M5 x 18mm |
| 9 | See Spindle chart | Spindle Assembly |
| 10 | 200027M | Tail Plate, RH |
| 11 | 200028M | Tail Plate, LH |
| 12 | 2035 <u>WW</u> | Bottom Wiper |
| 13 | 910612M | Button Head Screw M6 x 12mm |
| 14 | 910510M | Button Head Screw M5 x 10mm |
| 15 | 200038 | Cam Clamping Plate |
| 16 | 200039P | Belt Tracking Cam |
| 17 | 200341M | Cam Retaining Block |
| 18 | 920692M | Socket Low Head Cap Screw M6 x 12mm |
| 19  | 22GD- <u>WW</u> | Gang Drive Spindle Kit (Includes Items 2 and 12) |
| 20  | 22GDT- <u>WW</u> | Gang Drive Tail Kit (Includes Items 1 through 6, 10 through 13, 15 and 16) |
| <u>WW</u> = Conveyor width reference: 03, 04, 05, 06, 08, 10, 12, 18, 21, 24 * = 6" (152mm) and wider conveyors, only | | |

| Item 12: Spindle | | | |
|------------------|--------------------------------|--------------------------|---------------|
| Spindle Width | Spindle assembly with bearings | Spindle without bearings | Bearings (2x) |
| 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 |
| 21" (533mm) | 204821 | 204721 | 41-33 |
| 24" (610mm) | 204824 | 204724 | 41-33 |

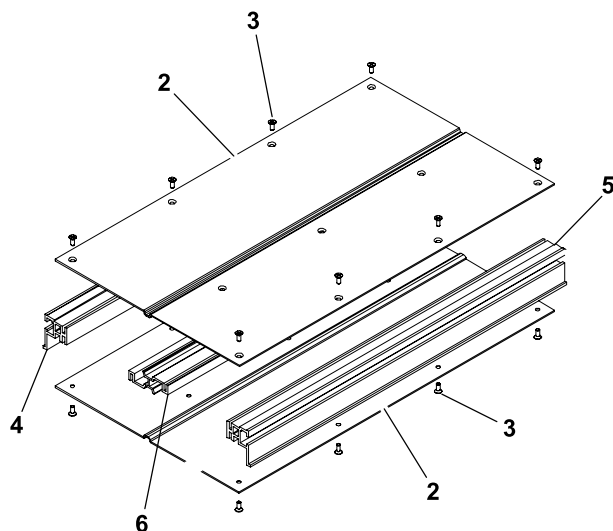
Conveyor Frames



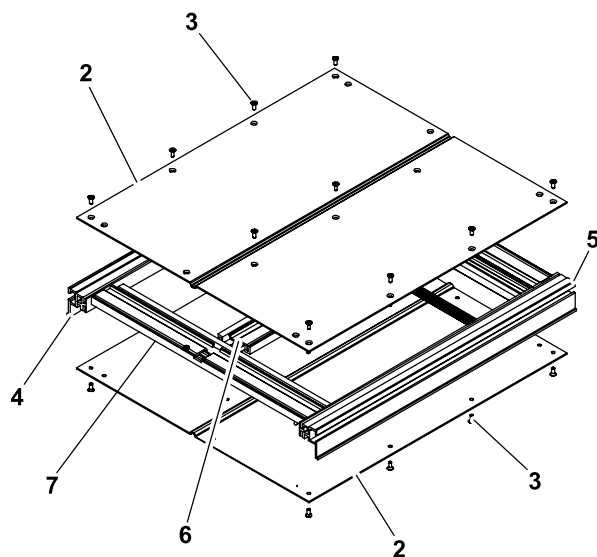
2" (51mm) Wide Frame



3" (76mm) to 6" (152mm) Wide Frame



8" (203mm) to 12" (305mm) Wide Frame

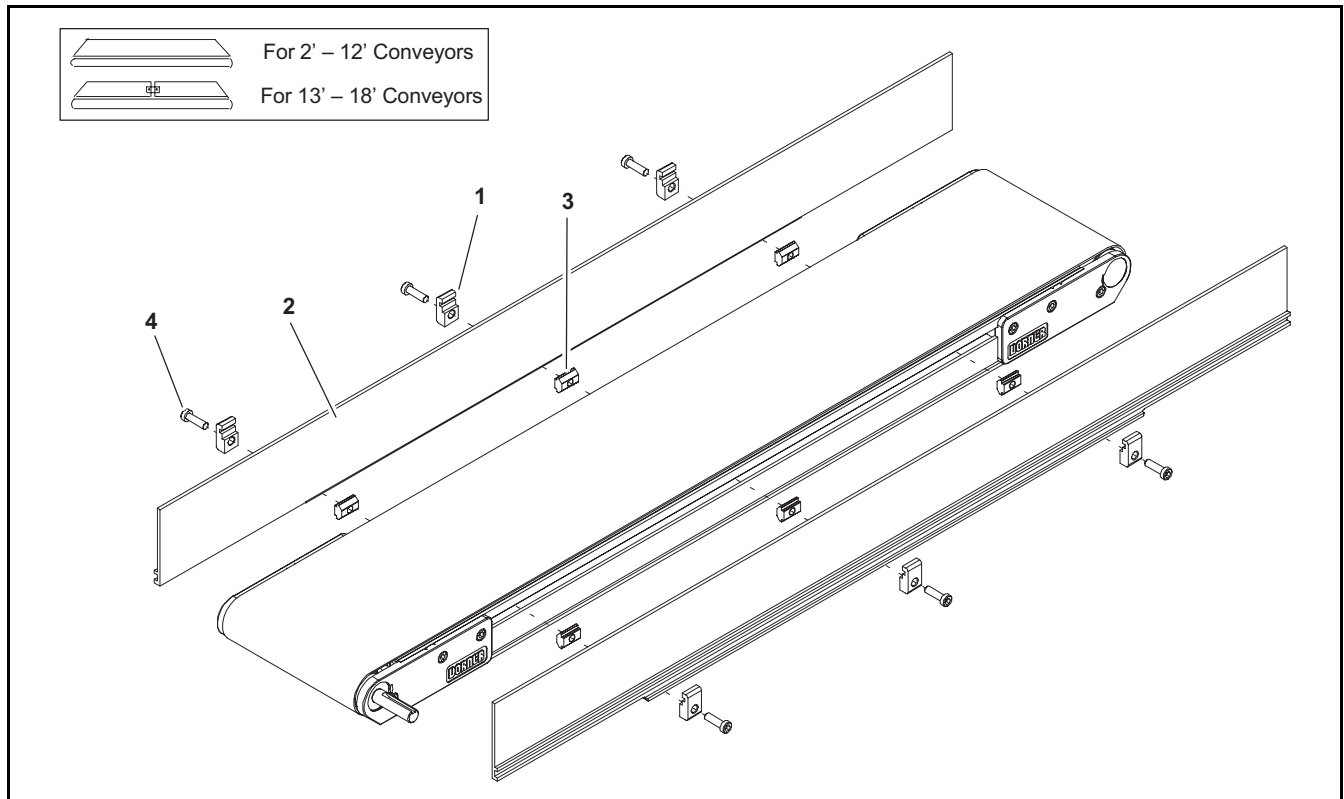


18" (457mm) to 24" (610mm) Wide Frame

| Item | Part Number | Description |
|--|---------------------|---------------------------------------|
| 1 | 2404 <u>WW-LLLL</u> | Frame |
| 2 | 2405 <u>WW-LLLL</u> | Bed Plate |
| 3 | 807-1074 | Flat Head Torx Screw M4 x 10mm |
| 4 | 240412- <u>LLLL</u> | Side Rail LH |
| 5 | 240413- <u>LLLL</u> | Side Rail RH |
| 6 | 240414- <u>LLLL</u> | Center Rail 8" (203mm) to 12" (305mm) |
| 7 | 240417 | Center Rail Cross Support 18" (457mm) |
| | 240419 | Center Rail Cross Support 21" (533mm) |
| | 240418 | Center Rail Cross Support 24" (610mm) |
| <u>WW</u> = Conveyor Width reference: 03, 04, 05, 06, 08, 10, 12, 18, 21, 24 | | |

| Item | Part Number | Description |
|---|-------------|-------------|
| <p><u>LLLLL</u> = Part length in inches with 2 decimal places Example: Part Length = 55.08" <u>LLLLL</u> = 05508</p> | | |

-04 3" (76mm) Aluminum Side



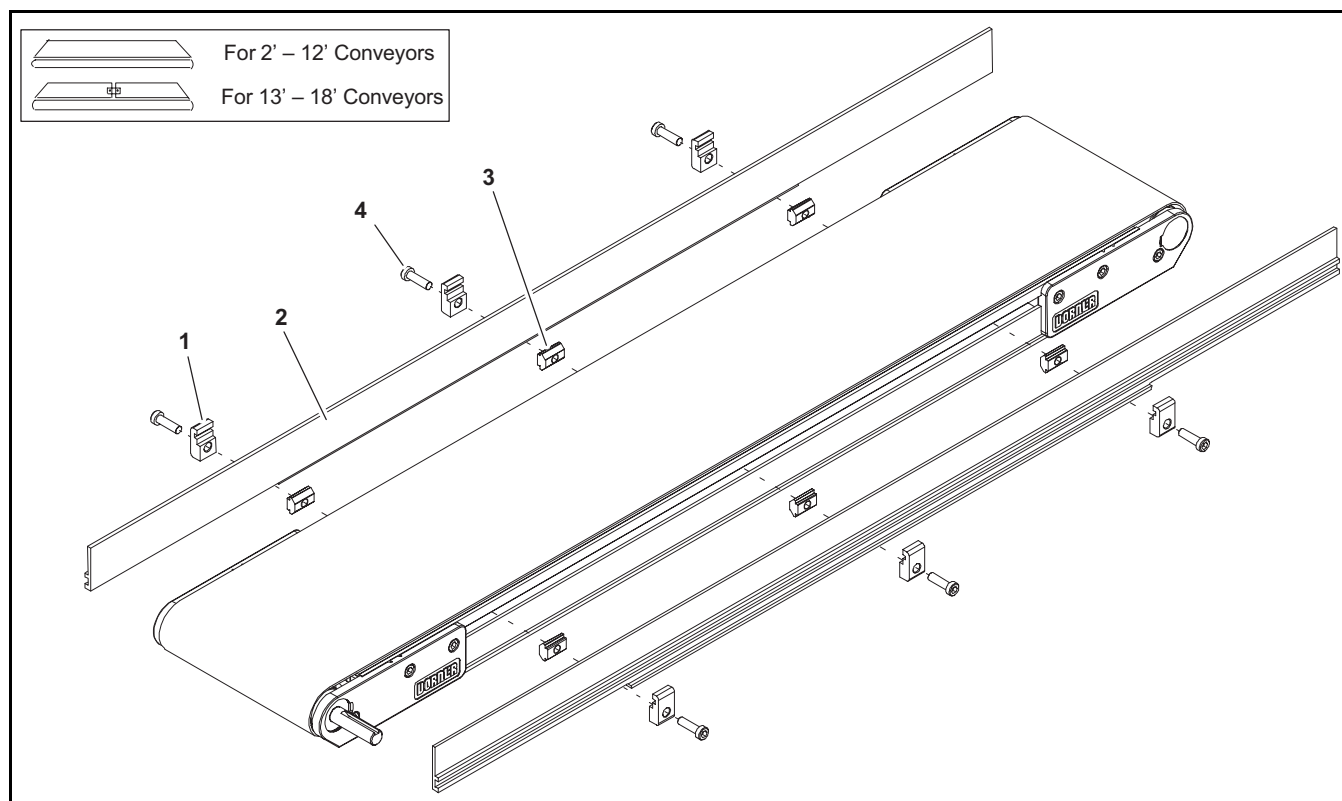
| Item | Part Number | Description |
|------|-----------------|-----------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | See Chart Below | 2200 Guide 3" (76mm) HS |
| 3 | 639971M | Single Drop-in Tee Bar |
| 4 | 920694M | Socket Head Screw M6 x 20mm |

| Item 2: 2200 Guide 3" (76mm) HS | | | |
|---------------------------------|------------|--------------|-----------|
| Length | | End Guide | End Guide |
| 2' (610mm) | Left Hand | 280403-02400 | N/A |
| | Right Hand | 280403-02400 | N/A |
| 3' (914mm) | Left Hand | 280403-03600 | N/A |
| | Right Hand | 280403-03600 | N/A |
| 4' (1219mm) | Left Hand | 280403-04800 | N/A |
| | Right Hand | 280403-04800 | N/A |
| 5' (1524mm) | Left Hand | 280403-06000 | N/A |
| | Right Hand | 280403-06000 | N/A |
| 6' (1829mm) | Left Hand | 280403-07200 | N/A |
| | Right Hand | 280403-07200 | N/A |
| 7' (2134mm) | Left Hand | 280403-08400 | N/A |
| | Right Hand | 280403-08400 | N/A |
| 8' (2438mm) | Left Hand | 280403-09600 | N/A |
| | Right Hand | 280403-09600 | N/A |
| 9' (2743mm) | Left Hand | 280403-10800 | N/A |
| | Right Hand | 280403-10800 | N/A |
| 10' (3048mm) | Left Hand | 280403-12000 | N/A |
| | Right Hand | 280403-12000 | N/A |
| 11' (3353mm) | Left Hand | 280403-13200 | N/A |
| | Right Hand | 280403-13200 | N/A |
| 12' (3658mm) | Left Hand | 280403-14400 | N/A |
| | Right Hand | 280403-14400 | N/A |

| Item 2: 2200 Guide 3" (76mm) HS | | | |
|---------------------------------|------------|--------------|--------------|
| Length | | End Guide | End Guide |
| 13' (3962mm) | Left Hand | 280401-07500 | 280401-08100 |
| | Right Hand | 280402-07500 | 280402-08100 |
| 14' (4267mm) | Left Hand | 280401-07500 | 280401-09300 |
| | Right Hand | 280402-07500 | 280402-09300 |
| 15' (4572mm) | Left Hand | 280401-07500 | 280401-10500 |
| | Right Hand | 280402-07500 | 280402-10500 |
| 16' (4877mm) | Left Hand | 280401-07500 | 280401-11700 |
| | Right Hand | 280402-07500 | 280402-11700 |
| 17' (5182mm) | Left Hand | 280401-07500 | 280401-12900 |
| | Right Hand | 280402-07500 | 280402-12900 |
| 18' (5486mm) | Left Hand | 280401-07500 | 280401-14100 |
| | Right Hand | 280402-07500 | 280402-14100 |

Service Parts

–05 1.5” (38mm) Aluminum Side

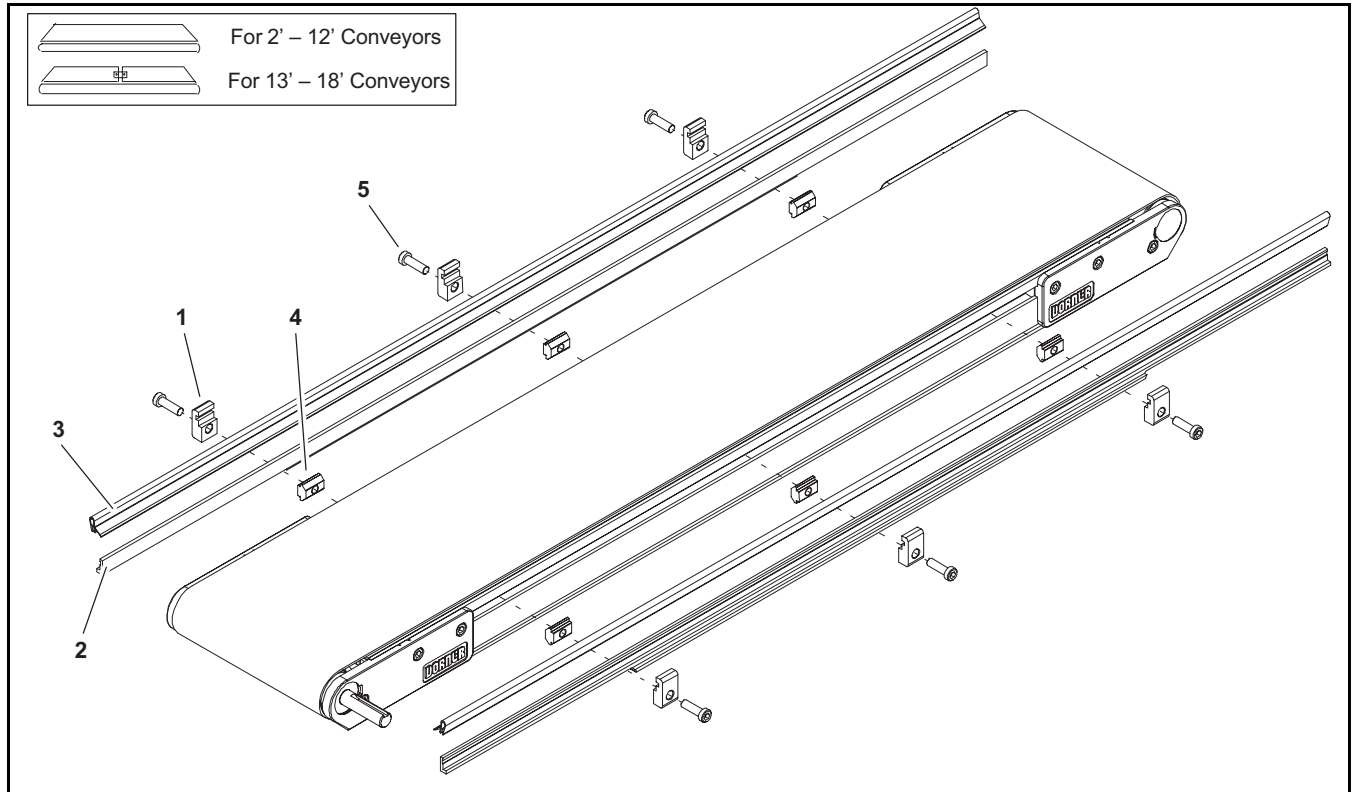


| Item | Part Number | Description |
|------|-----------------|------------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | See Chart Below | 2200 Guide .5" (13mm) HS |
| 3 | 639971MK10 | Single Drop-in Tee Bar (x10) |
| 4 | 920694M | Socket Head Screw M6 x 20mm |

| Item 2: 2200 Guide .5" (13mm) HS | | | |
|----------------------------------|------------|--------------|-----------|
| Length | | End Guide | End Guide |
| 2' (610mm) | Left Hand | 280503–02400 | N/A |
| | Right Hand | 280503–02400 | N/A |
| 3' (914mm) | Left Hand | 280503–03600 | N/A |
| | Right Hand | 280503–03600 | N/A |
| 4' (1219mm) | Left Hand | 280503–04800 | N/A |
| | Right Hand | 280503–04800 | N/A |
| 5' (1524mm) | Left Hand | 280503–06000 | N/A |
| | Right Hand | 280503–06000 | N/A |
| 6' (1829mm) | Left Hand | 280503–07200 | N/A |
| | Right Hand | 280503–07200 | N/A |
| 7' (2134mm) | Left Hand | 280503–08400 | N/A |
| | Right Hand | 280503–08400 | N/A |
| 8' (2438mm) | Left Hand | 280503–09600 | N/A |
| | Right Hand | 280503–09600 | N/A |
| 9' (2743mm) | Left Hand | 280503–10800 | N/A |
| | Right Hand | 280503–10800 | N/A |
| 10' (3048mm) | Left Hand | 280503–12000 | N/A |
| | Right Hand | 280503–12000 | N/A |
| 11' (3353mm) | Left Hand | 280503–13200 | N/A |
| | Right Hand | 280503–13200 | N/A |

| Item 2: 2200 Guide .5" (13mm) HS | | | |
|----------------------------------|------------|--------------|--------------|
| Length | | End Guide | End Guide |
| 12' (3658mm) | Left Hand | 280503–14400 | N/A |
| | Right Hand | 280503–14400 | N/A |
| 13' (3962mm) | Left Hand | 280501–07500 | 280501–08100 |
| | Right Hand | 280502–07500 | 280502–08100 |
| 14' (4267mm) | Left Hand | 280501–07500 | 280501–09300 |
| | Right Hand | 280502–07500 | 280502–09300 |
| 15' (4572mm) | Left Hand | 280501–07500 | 280501–10500 |
| | Right Hand | 280502–07500 | 280502–10500 |
| 16' (4877mm) | Left Hand | 280501–07500 | 280501–11700 |
| | Right Hand | 280502–07500 | 280502–11700 |
| 17' (5182mm) | Left Hand | 280501–07500 | 280501–12900 |
| | Right Hand | 280502–07500 | 280502–12900 |
| 18' (5486mm) | Left Hand | 280501–07500 | 280501–14100 |
| | Right Hand | 280502–07500 | 280502–14100 |

-07 Low to Side Wiper



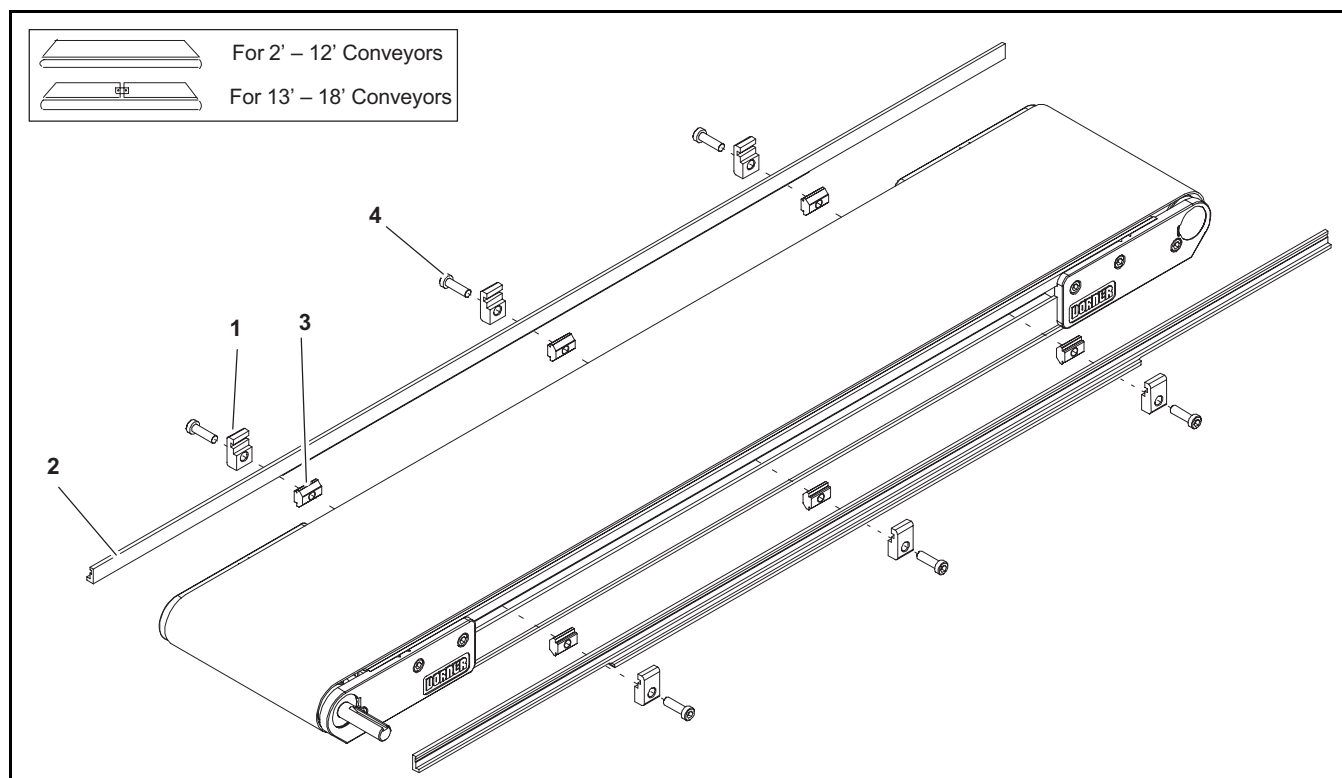
| Item | Part Number | Description |
|------|-----------------|--------------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | See Chart Below | 2200 Guide .5" (13mm) HS |
| 3 | 41-00-24 | Side Wiper Nylatron (per foot) |
| 4 | 639971MK10 | Single Drop-in Tee Bar (x10) |
| 5 | 920694M | Socket Head Screw M6 x 20mm |

| Item 2: 2200 Guide .5" (13mm) HS | | | |
|----------------------------------|------------|--------------|-----------|
| Length | | End Guide | End Guide |
| 2' (610mm) | Left Hand | 280903-02400 | N/A |
| | Right Hand | 280903-02400 | N/A |
| 3' (914mm) | Left Hand | 280903-03600 | N/A |
| | Right Hand | 280903-03600 | N/A |
| 4' (1219mm) | Left Hand | 280903-04800 | N/A |
| | Right Hand | 280903-04800 | N/A |
| 5' (1524mm) | Left Hand | 280903-06000 | N/A |
| | Right Hand | 280903-06000 | N/A |
| 6' (1829mm) | Left Hand | 280903-07200 | N/A |
| | Right Hand | 280903-07200 | N/A |
| 7' (2134mm) | Left Hand | 280903-08400 | N/A |
| | Right Hand | 280903-08400 | N/A |
| 8' (2438mm) | Left Hand | 280903-09600 | N/A |
| | Right Hand | 280903-09600 | N/A |
| 9' (2743mm) | Left Hand | 280903-10800 | N/A |
| | Right Hand | 280903-10800 | N/A |
| 10' (3048mm) | Left Hand | 280903-12000 | N/A |
| | Right Hand | 280903-12000 | N/A |
| 11' (3353mm) | Left Hand | 280903-13200 | N/A |
| | Right Hand | 280903-13200 | N/A |

| Item 2: 2200 Guide .5" (13mm) HS | | | |
|----------------------------------|------------|--------------|--------------|
| Length | | End Guide | End Guide |
| 12' (3658mm) | Left Hand | 280903-14400 | N/A |
| | Right Hand | 280903-14400 | N/A |
| 13' (3962mm) | Left Hand | 280901-07500 | 280901-08100 |
| | Right Hand | 280902-07500 | 280902-08100 |
| 14' (4267mm) | Left Hand | 280901-07500 | 280901-09300 |
| | Right Hand | 280902-07500 | 280902-09300 |
| 15' (4572mm) | Left Hand | 280901-07500 | 280901-10500 |
| | Right Hand | 280902-07500 | 280902-10500 |
| 16' (4877mm) | Left Hand | 280901-07500 | 280901-11700 |
| | Right Hand | 280902-07500 | 280902-11700 |
| 17' (5182mm) | Left Hand | 280901-07500 | 280901-12900 |
| | Right Hand | 280902-07500 | 280902-12900 |
| 18' (5486mm) | Left Hand | 280901-07500 | 280901-14100 |
| | Right Hand | 280902-07500 | 280902-14100 |

Service Parts

–09 Low to High Side

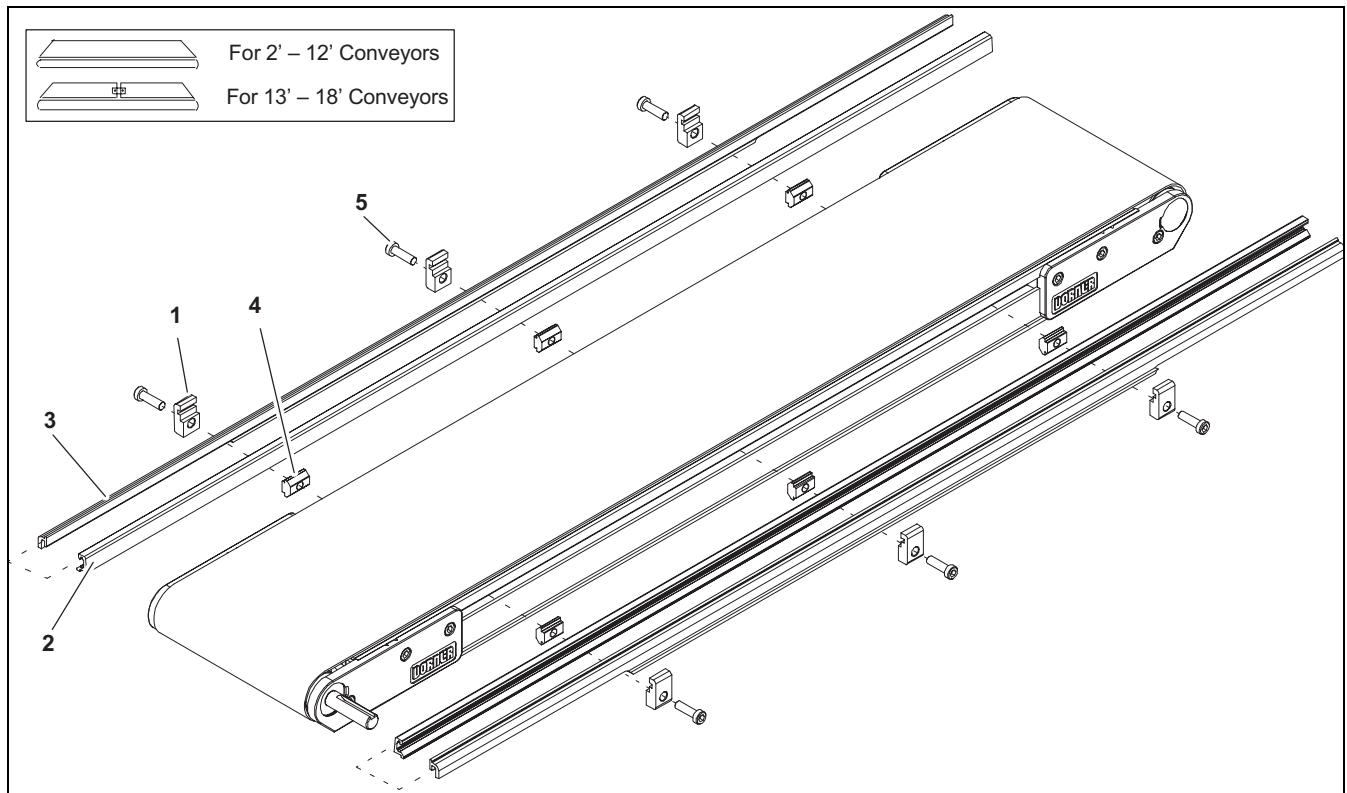


| Item | Part Number | Description |
|------|-----------------|------------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | See Chart Below | 2200 Guide .5" (13mm) HS |
| 3 | 639971MK10 | Single Drop-in Tee Bar (x10) |
| 4 | 920694M | Socket Head Screw M6 x 20mm |

| Item 2: 2200 Guide .5" (13mm) HS | | | |
|----------------------------------|------------|--------------|-----------|
| Length | | End Guide | End Guide |
| 2' (610mm) | Left Hand | 280903-02400 | N/A |
| | Right Hand | 280903-02400 | N/A |
| 3' (914mm) | Left Hand | 280903-03600 | N/A |
| | Right Hand | 280903-03600 | N/A |
| 4' (1219mm) | Left Hand | 280903-04800 | N/A |
| | Right Hand | 280903-04800 | N/A |
| 5' (1524mm) | Left Hand | 280903-06000 | N/A |
| | Right Hand | 280903-06000 | N/A |
| 6' (1829mm) | Left Hand | 280903-07200 | N/A |
| | Right Hand | 280903-07200 | N/A |
| 7' (2134mm) | Left Hand | 280903-08400 | N/A |
| | Right Hand | 280903-08400 | N/A |
| 8' (2438mm) | Left Hand | 280903-09600 | N/A |
| | Right Hand | 280903-09600 | N/A |
| 9' (2743mm) | Left Hand | 280903-10800 | N/A |
| | Right Hand | 280903-10800 | N/A |
| 10' (3048mm) | Left Hand | 280903-12000 | N/A |
| | Right Hand | 280903-12000 | N/A |
| 11' (3353mm) | Left Hand | 280903-13200 | N/A |
| | Right Hand | 280903-13200 | N/A |
| 12' (3658mm) | Left Hand | 280903-14400 | N/A |
| | Right Hand | 280903-14400 | N/A |

| Item 2: 2200 Guide .5" (13mm) HS | | | |
|----------------------------------|------------|--------------|--------------|
| Length | | End Guide | End Guide |
| 13' (3962mm) | Left Hand | 280901-07500 | 280901-08100 |
| | Right Hand | 280902-07500 | 280902-08100 |
| 14' (4267mm) | Left Hand | 280901-07500 | 280901-09300 |
| | Right Hand | 280902-07500 | 280902-09300 |
| 15' (4572mm) | Left Hand | 280901-07500 | 280901-10500 |
| | Right Hand | 280902-07500 | 280902-10500 |
| 16' (4877mm) | Left Hand | 280901-07500 | 280901-11700 |
| | Right Hand | 280902-07500 | 280902-11700 |
| 17' (5182mm) | Left Hand | 280901-07500 | 280901-12900 |
| | Right Hand | 280902-07500 | 280902-12900 |
| 18' (5486mm) | Left Hand | 280901-07500 | 280901-14100 |
| | Right Hand | 280902-07500 | 280902-14100 |

-10 .5" (13mm) Extruded Plastic



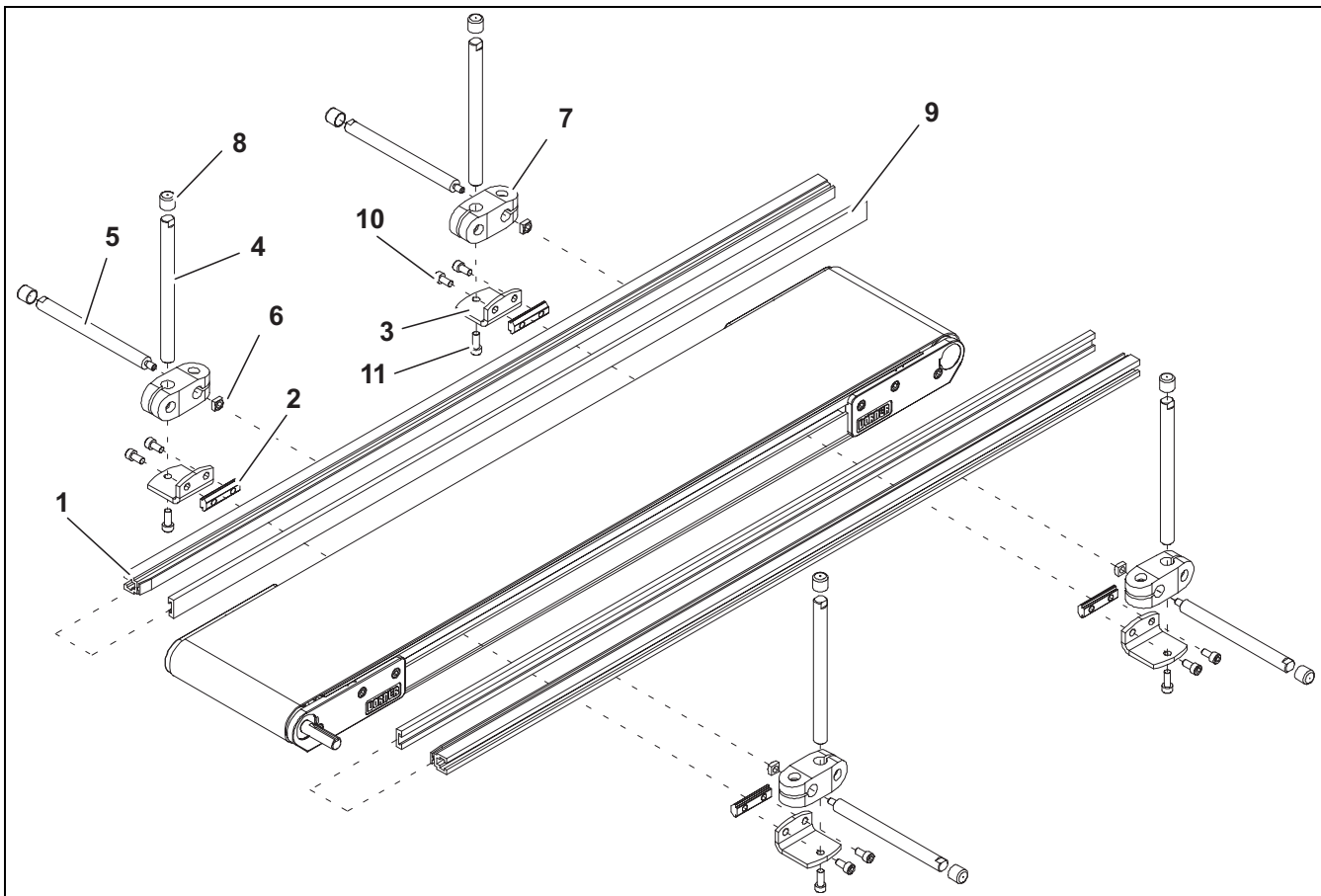
| Item | Part Number | Description |
|------|-----------------|------------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | 200054P | Snap-On Guide (per foot) |
| 3 | See Chart Below | 2200 Guide |
| 4 | 639971MK10 | Single Drop-in Tee Bar (x10) |
| 5 | 920694M | Socket Head Screw M6 x 20mm |

| Item 3: 2200 Guide | | | |
|--------------------|------------|--------------|-----------|
| Length | | End Guide | End Guide |
| 2' (610mm) | Left Hand | 281003-02400 | N/A |
| | Right Hand | 281003-02400 | N/A |
| 3' (914mm) | Left Hand | 281003-03600 | N/A |
| | Right Hand | 281003-03600 | N/A |
| 4' (1219mm) | Left Hand | 281003-04800 | N/A |
| | Right Hand | 281003-04800 | N/A |
| 5' (1524mm) | Left Hand | 281003-06000 | N/A |
| | Right Hand | 281003-06000 | N/A |
| 6' (1829mm) | Left Hand | 281003-07200 | N/A |
| | Right Hand | 281003-07200 | N/A |
| 7' (2134mm) | Left Hand | 281003-08400 | N/A |
| | Right Hand | 281003-08400 | N/A |
| 8' (2438mm) | Left Hand | 281003-09600 | N/A |
| | Right Hand | 281003-09600 | N/A |
| 9' (2743mm) | Left Hand | 281003-10800 | N/A |
| | Right Hand | 281003-10800 | N/A |
| 10' (3048mm) | Left Hand | 281003-12000 | N/A |
| | Right Hand | 281003-12000 | N/A |
| 11' (3353mm) | Left Hand | 281003-13200 | N/A |
| | Right Hand | 281003-13200 | N/A |

| Item 3: 2200 Guide | | | |
|--------------------|------------|--------------|--------------|
| Length | | End Guide | End Guide |
| 12' (3658mm) | Left Hand | 281003-14400 | N/A |
| | Right Hand | 281003-14400 | N/A |
| 13' (3962mm) | Left Hand | 281001-07500 | 281001-08100 |
| | Right Hand | 281002-07500 | 281002-08100 |
| 14' (4267mm) | Left Hand | 281001-07500 | 281001-09300 |
| | Right Hand | 281002-07500 | 281002-09300 |
| 15' (4572mm) | Left Hand | 281001-07500 | 281001-10500 |
| | Right Hand | 281002-07500 | 281002-10500 |
| 16' (4877mm) | Left Hand | 281001-07500 | 281001-11700 |
| | Right Hand | 281002-07500 | 281002-11700 |
| 17' (5182mm) | Left Hand | 281001-07500 | 281001-12900 |
| | Right Hand | 281002-07500 | 281002-12900 |
| 18' (5486mm) | Left Hand | 281001-07500 | 281001-14100 |
| | Right Hand | 281002-07500 | 281002-14100 |

Service Parts

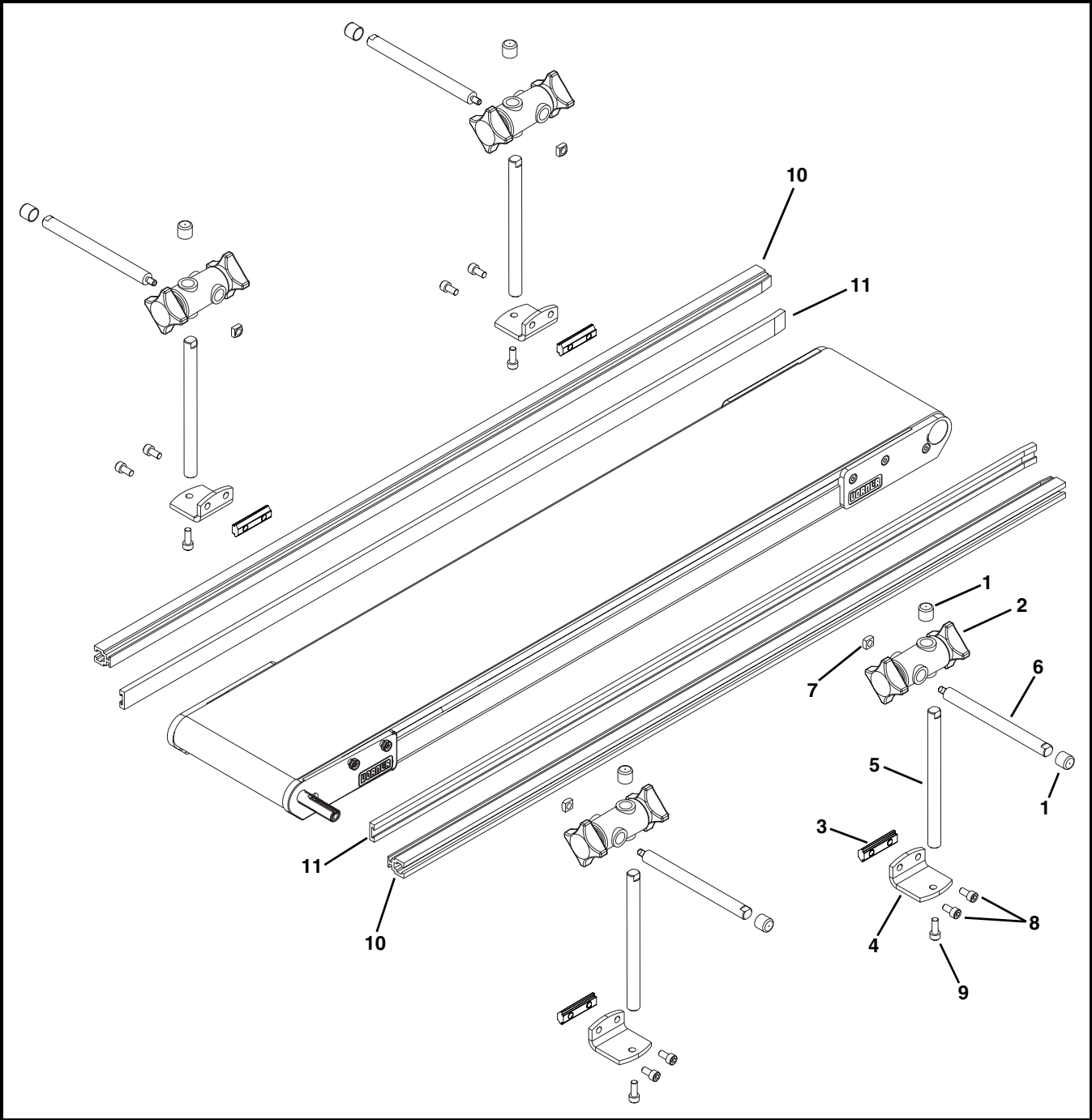
–13 Adjustable Guiding



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

| Item | Part Number | Description |
|------|-------------|---------------------------------|
| 2 | 200830M | Drop-In Tee Bar |
| 3 | 202004 | Mounting Bracket |
| 4 | 202027M | Guide Mounting Shaft Vertical |
| 5 | 202028M | Guide Mounting Shaft Horizontal |
| 6 | 674175MP | Square Nut |
| 7 | 807-652 | Cross Block |
| 8 | 807-948 | Vinyl Shaft Cap |
| 9 | 614068P | Flat Extruded Guide (per foot) |
| 10 | 920612M | Socket Head Screw M6 x 12mm |
| 11 | 920616M | Socket Head Screw M6 x 16mm |

-14 Tool-Less Adjustable Guiding

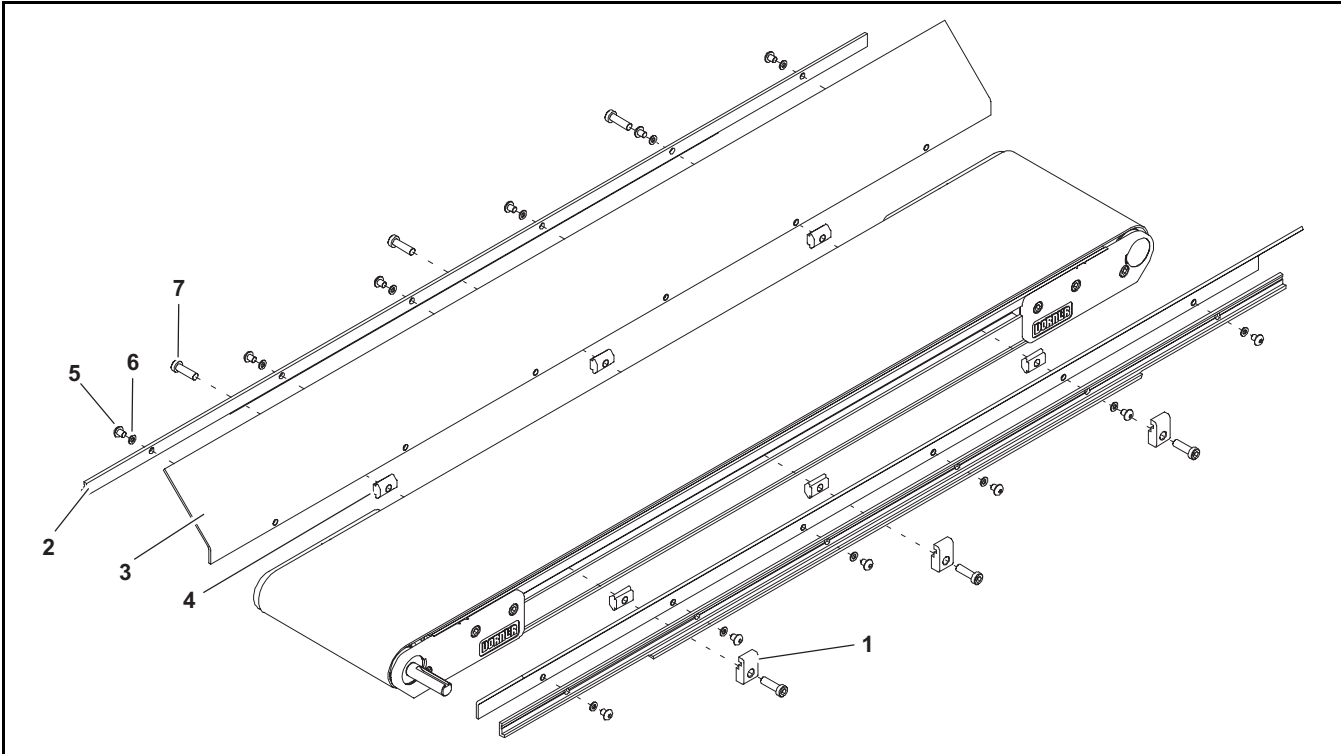


| Item | Part Number | Description |
|------|-------------|------------------------------------|
| 1 | 807-948 | Shaft Cap |
| 2 | 807-1470 | Cross Block |
| 3 | 200830M | Drop-In Tee Bar (2200 Series Only) |
| 4 | 202004M | Mounting Bracket |
| 5 | 202027M | Vertical Mounting Guide Shaft |
| 6 | 202028M | Horizontal Mounting Guide Shaft |

| Item | Part Number | Description |
|------|---------------|---|
| 7 | 674175MP | Square Nut, M6-1.00 |
| 8 | 920612M | Socket Head Screw, M6-1.00 x 12 mm (2200 Series) |
| | 807-1937 | Self-Drilling Hex Head Screw, 1/4-20x1" (2300 Series) |
| 9 | 920616M | Socket Head Screw, M6-1.00 x 16 mm |
| 10 | 460063-LLLLL | Aluminum Profile Guide |
| 11 | 614068P-LLLLL | Extruded Guide |
| | | LLLLL = Length in inches with 2 decimal places. |
| | | Length Example: Length = 95.25" LLLLL = 09525 |

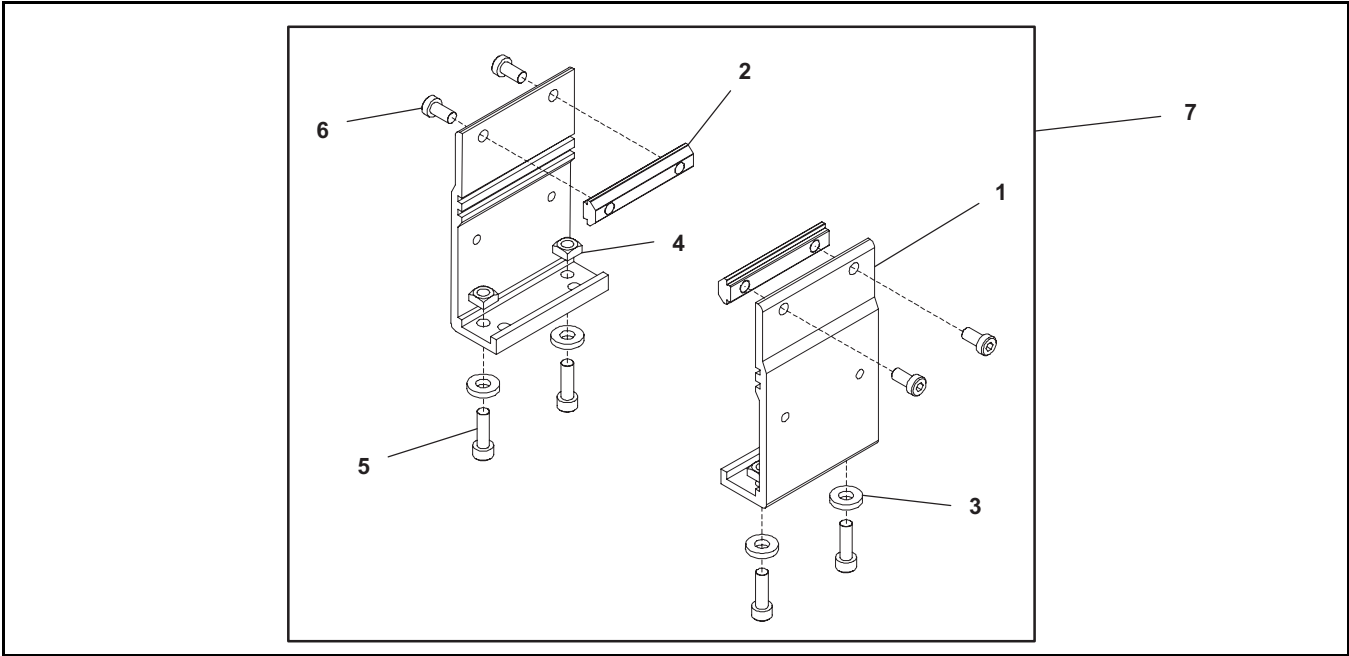
Service Parts

Flared Side Guiding



| Item | Part Number | Description |
|------|-------------|---------------------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | 202212 | Side-Flare Mounting Guide 2' (610mm) |
| | 202213 | Side-Flare Mounting Guide 3' (914mm) |
| | 202214 | Side-Flare Mounting Guide 4' (1219mm) |
| | 202215 | Side-Flare Mounting Guide 5' (1524mm) |
| | 202216 | Side-Flare Mounting Guide 6' (1829mm) |
| 3 | 202522M | Flared Guide 45° 2' (610mm) |
| | 202523M | Flared Guide 45° 3' (914mm) |
| | 202523M | Flared Guide 45° 4' (1219mm) |
| | 202523M | Flared Guide 45° 5' (1524mm) |
| | 202523M | Flared Guide 45° 6' (1829mm) |
| 4 | 639971M | Drop-In Tee Bar |
| 5 | 910506M | Button Head Screw M5 x 6mm |
| 6 | 911-512 | Washer |
| 7 | 920694M | Cap Low-Head Screw M6 x 20mm |

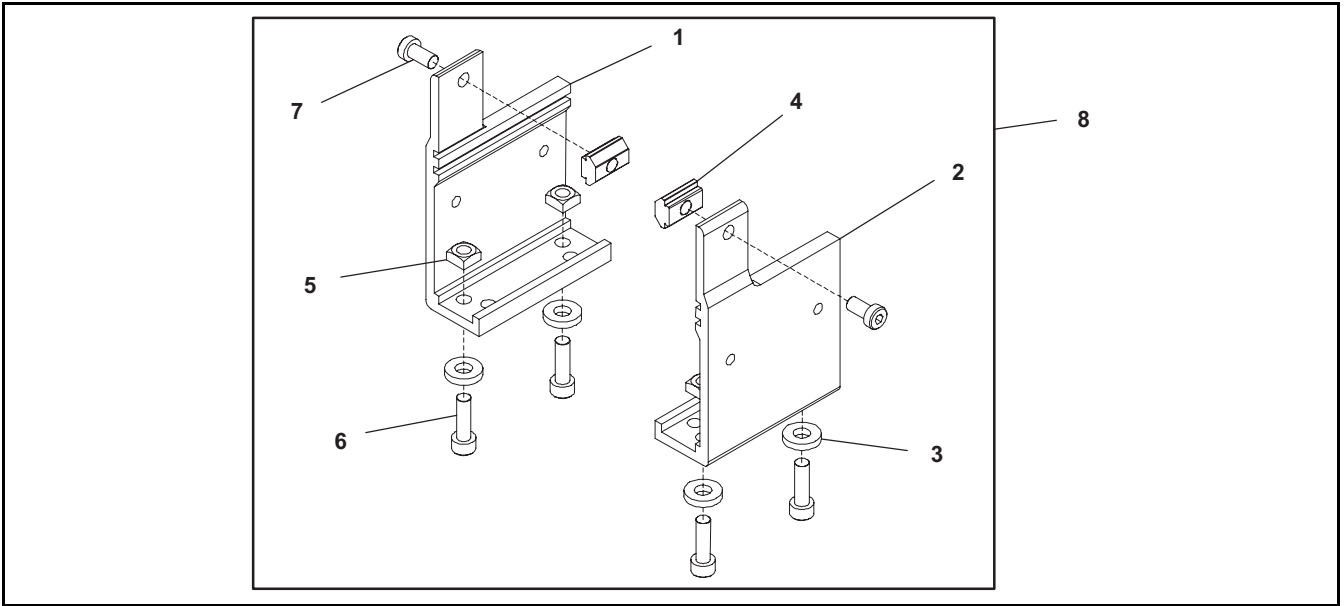
Flat Belt Stand Mount Assembly



| Item | Part Number | Description |
|------|-------------|-----------------|
| 1 | 240831 | Stand Mount |
| 2 | 300150M | Drop-In Tee Bar |
| 3 | 605279P | Washer |
| 4 | 807-920 | Square Nut M6 |

| Item | Part Number | Description |
|------|-------------|--------------------------------|
| 5 | 920620M | Socket Head Screw M6 x 20mm |
| 6 | 920692M | Socket Low Head Screw M6x12mm |
| 7 | 240839 | Flat Belt Stand Mount Assembly |

Flat Belt Stand Mount Assembly for 2' (610mm) Conveyors

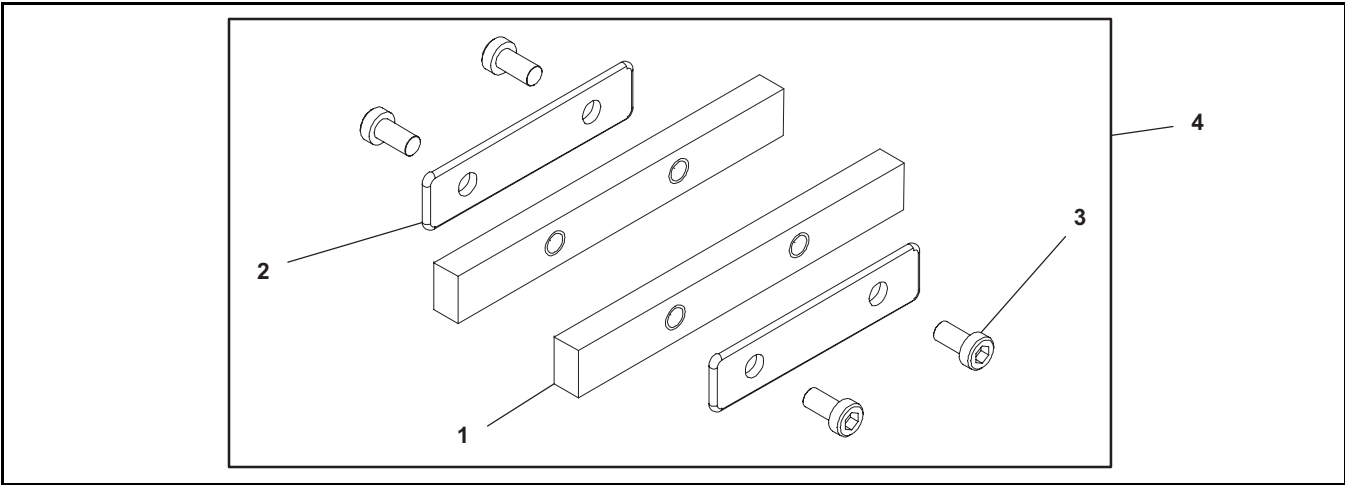


| Item | Part Number | Description |
|------|-------------|----------------------------|
| 1 | 240833 | Stand Mount, LH 2' (610mm) |
| 2 | 240834 | Stand Mount, RH 2' (610mm) |
| 3 | 605279P | Washer |
| 4 | 639971M | Drop-In Tee Bar |

| Item | Part Number | Description |
|------|-------------|---|
| 5 | 807-920 | Square Nut M6 |
| 6 | 920620M | Socket Head Screw M6 x 20mm |
| 7 | 920692M | Socket Low Head Screw M6x12mm |
| 8 | 240847 | Flat Belt Stand Mount Assembly for 2' (610mm) Conveyors |

Service Parts

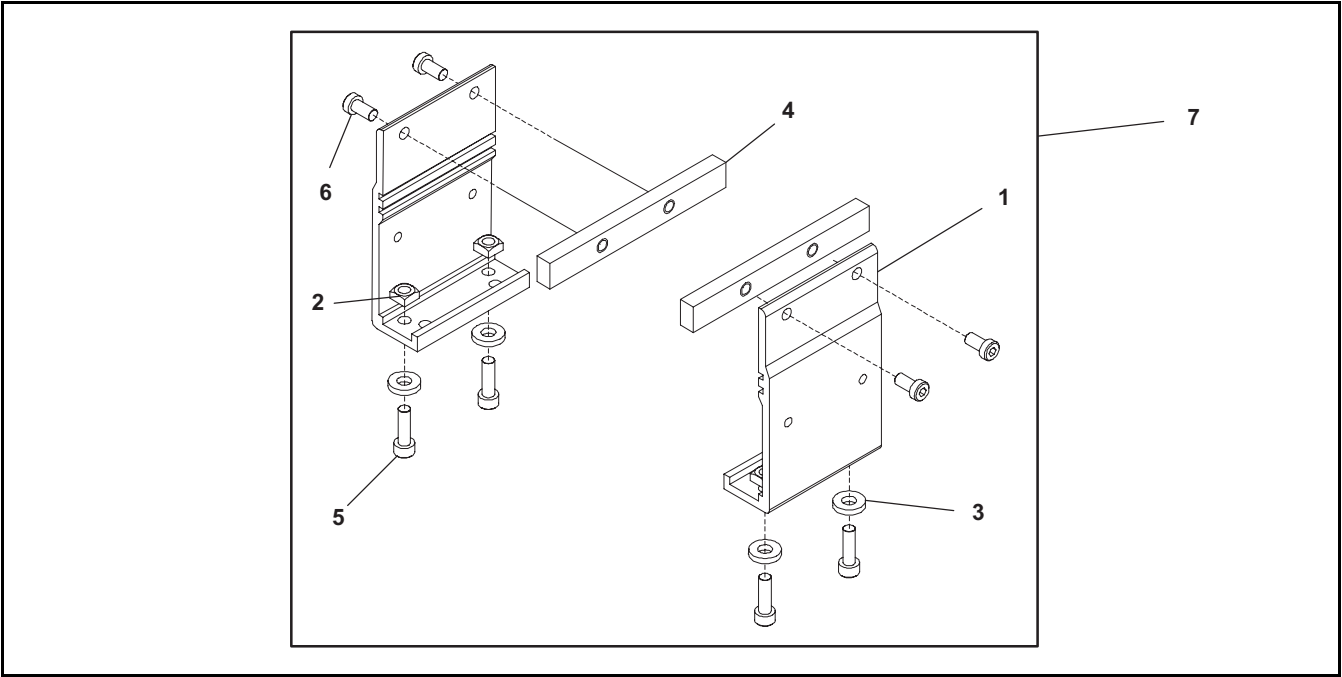
Connecting Assembly without Stand Mount



| Item | Part Number | Description |
|------|-------------|-----------------------|
| 1 | 240858 | Frame Connector Bar |
| 2 | 240859 | Frame Connector Plate |

| Item | Part Number | Description |
|------|-------------|--|
| 3 | 920692M | Socket Low Head Screw M6x12mm |
| 4 | 240861 | Connecting Assembly without Stand Mounts |

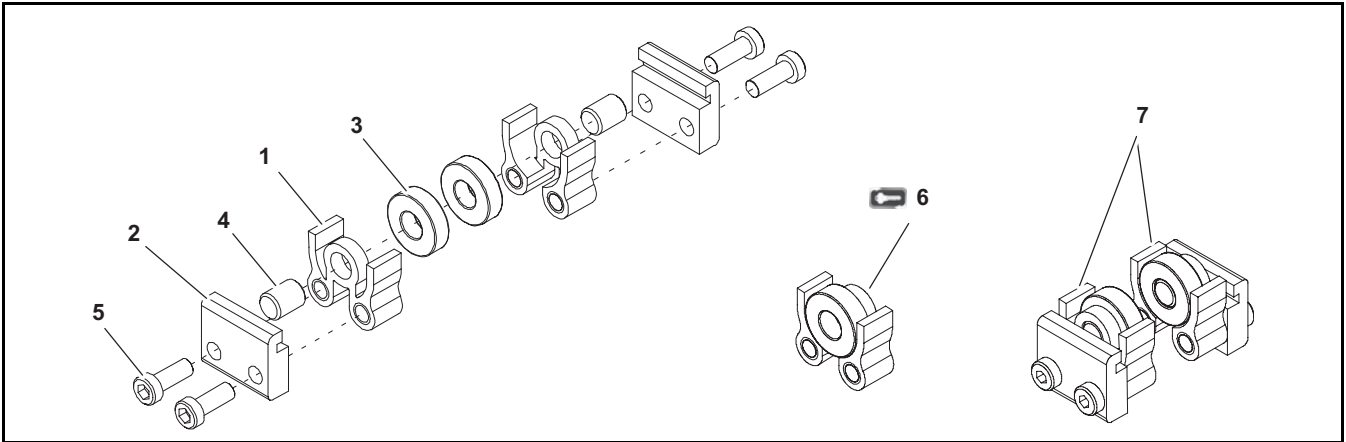
Flat Belt Connecting Assembly with Stand Mount



| Item | Part Number | Description |
|------|-------------|--------------------------|
| 1 | 240831 | Stand Mount |
| 2 | 807-920 | Square Nut M6 5mm x 10mm |
| 3 | 605279P | Washer |
| 4 | 240858 | Frame Connector Bar |

| Item | Part Number | Description |
|------|-------------|---|
| 5 | 920620M | Socket Head Screw M6 x 20mm |
| 6 | 920693M | Socket Low Head Screw M6 x 16mm |
| 7 | 240860 | Flat Belt Connecting Assembly with Stand Mounts |

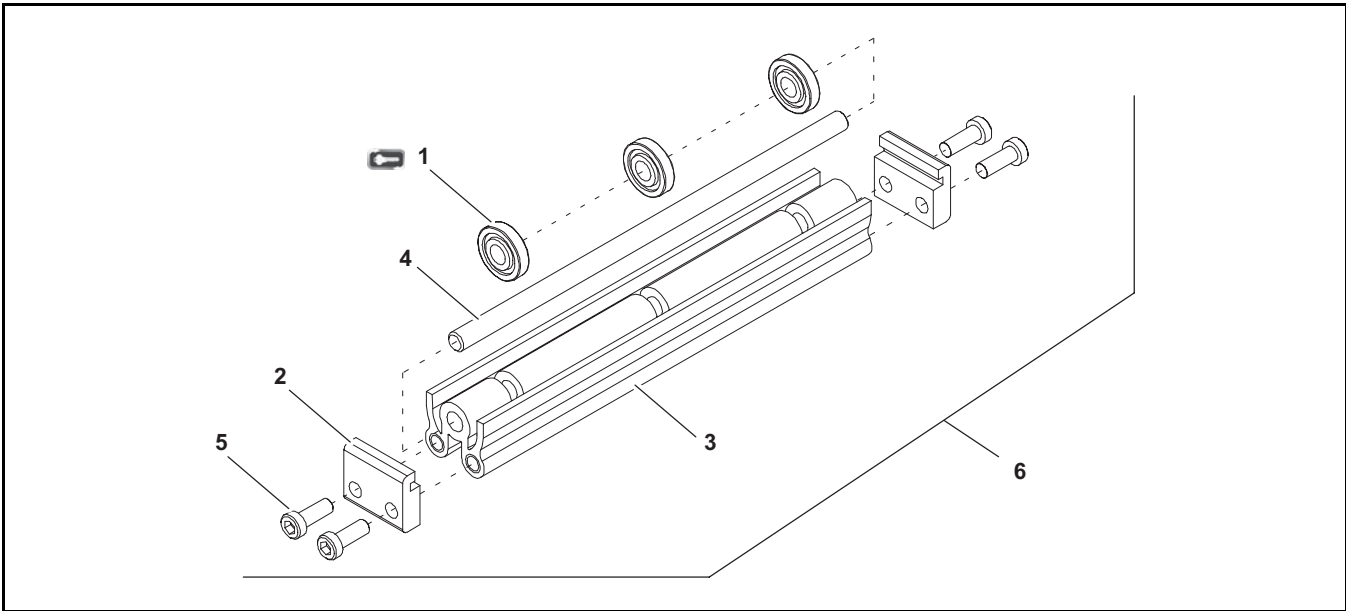
2” (51mm) to 6” (152mm) Flat Belt Return Roller



| Item | Part Number | Description |
|------|-------------|---------------------------------|
| 1 | 240825 | Return Roller Guard – Short |
| 2 | 240827 | Return Roller Clip |
| 3 | 802–027 | Bearing |
| 4 | 913–100 | Dowel Pin |
| 5 | 920693M | Socket Low Head Screw M6 x 16mm |

| Item | Part Number | Description |
|------|-------------|--|
| 6 | 240840 | Roller Assembly (Includes Items 1, 3 and 4) |
| 7 | 240830 | 2” (51mm) to 6” (152mm) Flat Belt Return Roller Assy |

8” (203mm) to 24” (610mm) Flat Belt Return Roller



| Item | Part Number | Description |
|------|-------------|---------------------|
| 1 | 240826 | Return Roller |
| 2 | 240827 | Return Roller Clip |
| 3 | 2409WW | Return Roller Guard |
| 4 | 2410WW | Return Roller Rod |

| Item | Part Number | Description |
|--|-------------|--|
| 5 | 920693M | Socket Low Head Screw M6 x 16mm |
| 6 | 2408WW | 8” (203mm) to 24” (610mm) Flat Belt Return Roller Assembly |
| WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24 | | |

Conveyor Belt Part Number Configuration



21 - _____ / _____ **V***
(Fill In)

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.

Conveyors and conveyor accessories

| | |
|--|----------------------|
| Standard catalog conveyors | 30% |
| MPB, 7200, 7300 Series, cleated and specialty belt | 50% |
| AquaGard & AquaPruf Series conveyors | non-returnable items |
| Engineered to order products | case by case |
| Drives and accessories | 30% |
| Sanitary stand supports | non-returnable items |

Parts

| | |
|--|----------------------|
| Standard stock parts | 30% |
| Plastic chain, cleated and specialty belts | non-returnable items |

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. 2010

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