



# 7400 Series End Drive Conveyors

Installation, Maintenance and Parts Manual



Flat Belt Conveyor



Cleated Belt Conveyor

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## Introduction

### CAUTION

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.

The Dorner Limited Warranty applies.

Dorner 7400 series conveyors are covered by Patent Numbers 7,246,697, 7,207,435, 7,549,531 B2, 7,681,719 B2, 7,383,944, 8,042,682 B2 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 .

Intralox is a registered trademark of Laitram L.L.C. in the United States and / or other countries.

# Warnings – General Safety

**⚠ DANGER**



**SEVERE HAZARD!**  
**KEEP OFF CONVEYORS.** Climbing, sitting, walking or riding on conveyor will result in death or serious injury.

**⚠ DANGER**



**EXPLOSION HAZARD!**

- **DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.** The electric gearmotor generates heat and could ignite combustible vapors.
- Failure to comply will result in death or serious injury.

**⚠ WARNING**



**CRUSH HAZARD!**

- **DO NOT** place hands or fingers inside the conveyor while it is running.
- **DO NOT** wear loose garments while operating the conveyor. Loose garments can become caught up in the conveyor.
- Failure to comply could result in serious injury.

**⚠ WARNING**



**CRUSH HAZARD!**

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

**⚠ WARNING**



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

**⚠ WARNING**



**BURN HAZARD!**  
**DO NOT TOUCH** the motor while operating, or shortly after being turned off. Motors may be **HOT** and can cause serious burn injuries.

**⚠ WARNING**



**PUNCTURE HAZARD!**  
Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.

**⚠ WARNING**



**SEVERE HAZARD!**

- 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.
- Failure to comply could result in serious injury.

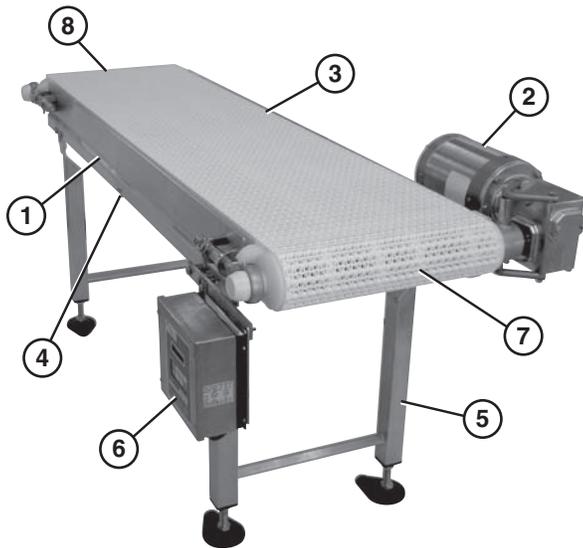
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# Product Description

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Refer to **(Figure 1)** for typical conveyor components.

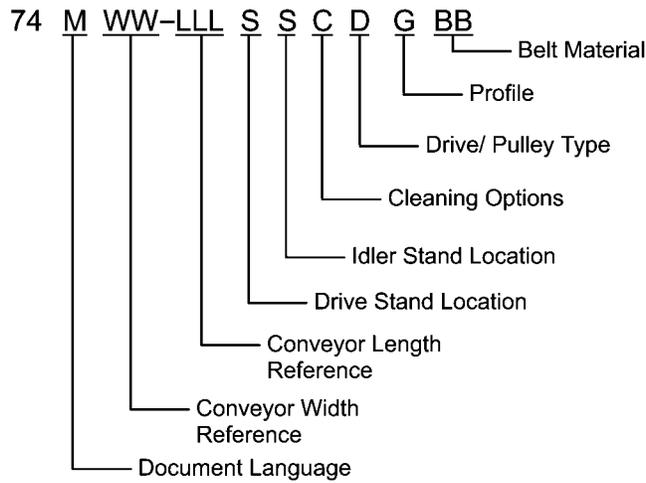
Typical Components	
1	Conveyor
2	Gearmotor
3	Belt (Flat Belt Shown)
4	Return
5	Support Stands
6	Motor Controller
7	Drive End
8	Tension End



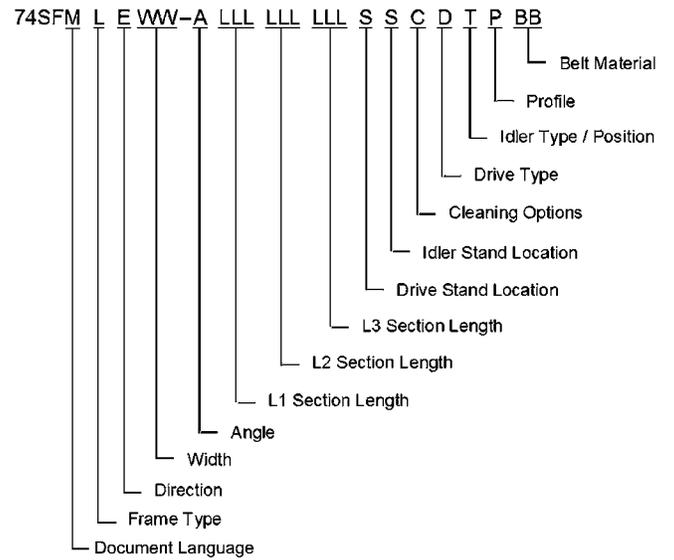
**Figure 1**

# Specifications

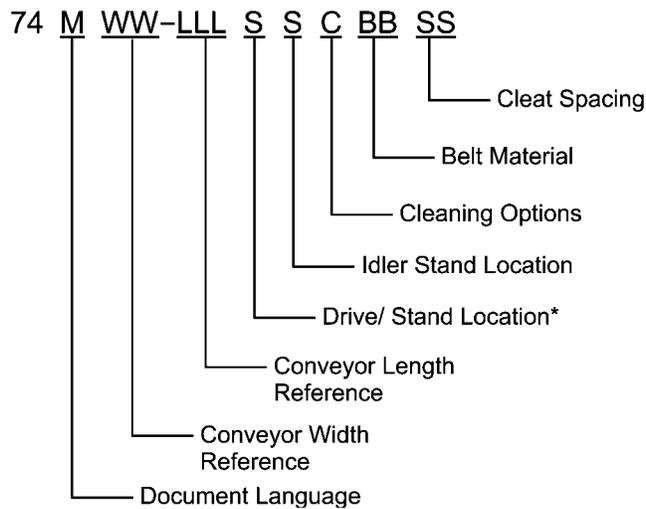
## Flat Belt 7400 Series Conveyor



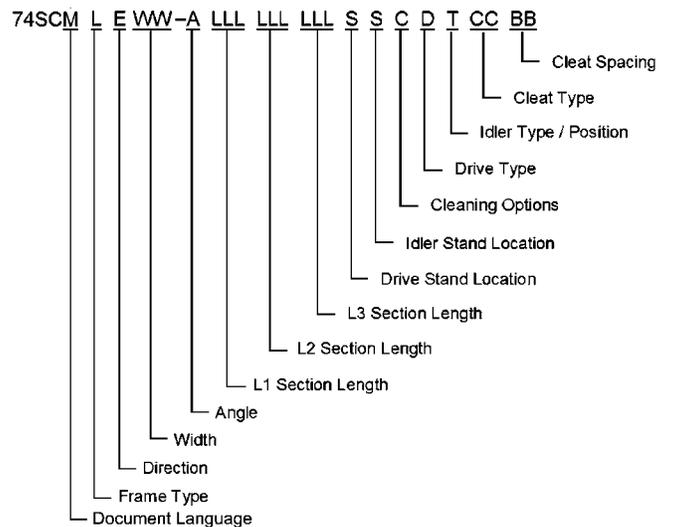
## Flat Belt 7400 Series LPZ Conveyor



## Cleated Belt 7400 Series Conveyor



## Cleated Belt 7400 Series LPZ Conveyor



# Specifications

## Conveyor Supports

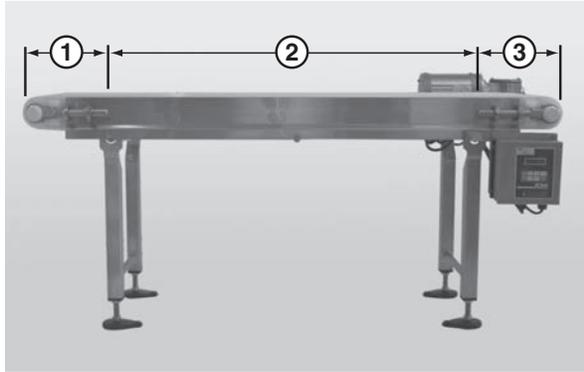
### Maximum Distances:

1 = 3 ft (914 mm)

2 = 8 ft (2438 mm)\*\*

3 = 3 ft (914 mm)

\*\* For conveyors longer than 10 ft (3.05 m),  
install support at frame joint.



**Figure 2**

## Specifications

<b>Conveyor Width Reference (WW)</b>	06 – 60 in 02 increments
<b>Conveyor Belt Width</b>	6" (152 mm) – 60" (1524 mm) in 2" (51 mm) increments
<b>Maximum Conveyor Load</b>	20 lb / ft <sup>2</sup> (97 kg / m <sup>2</sup> ) with a maximum of 1000 lb / ft <sup>2</sup> (4882 kg / m <sup>2</sup> )
<b>Belt Travel</b>	12" (305 mm) per revolution of pulley
<b>Maximum Belt Speed</b>	233 ft / minute (71 m / minute)
<b>Belt Take-up</b>	2" (51 mm)

<b>Conveyor Length Reference (LLL)</b>	036 – 999 in 001 increments
<b>Conveyor Length</b>	36" (914 mm) – 999" (25.4 m) in 1" (25 mm) increments
<b>LPZ Section Lengths (LLL)</b>	024 – 252 in 001 increments
<b>LPZ Section Length</b>	24" (610 mm) – 252" (6401 mm) in 1" (25 mm) increments
<b>Total LPZ Conveyor Length</b>	(L1 + L2 + L3) = Maximum 38' (11.6 m) long conveyor

### IMPORTANT

*Maximum conveyor loads are based on:*

- *Non-accumulating product*
- *Product moving toward gearmotor*
- *Conveyor being mounted horizontally*
- *Conveyor being located in a dry environment*
- *Conveyor equipped with standard belt only*

## ⚠ CAUTION

Dorner recommends cleaning all the “food zones” prior to placing conveyor into service. Ensure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.

## ⚠ CAUTION

Conveyor **MUST** be mounted straight, flat, and level within confines of conveyor. Use a level (Figure 3, item 1), during setup.

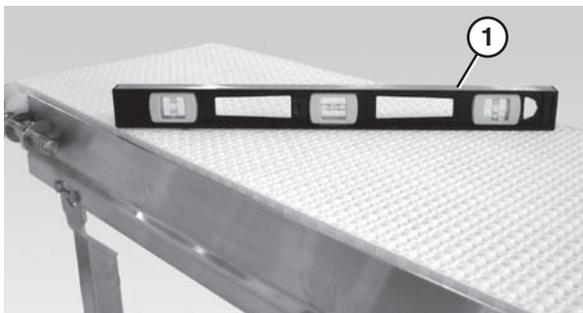


Figure 3

## Required Tools

- 17 mm wrench (for hexagonal head fasteners)
- 4 mm hex wrench (for bearing shaft assembly fasteners)
- Level
- Torque wrench

## Recommended Installation Sequence

1. Attach the stands to the conveyor. Refer to “Stand Installation” on page 9.
2. Attach the tail assemblies to the frame. Refer to “Tail Assembly Installation” on page 10.
3. Attach the lifters, if applicable. Refer to “Lifter Installation” on page 13.
4. Install the gearmotor, if applicable. Refer to the “7400 Series Drive Package Installation, Maintenance and Parts Manual.”
5. Attach the wear strips. Refer to “Wear Strip Installation” on page 13.
6. Install the belt. Refer to “Belt Installation” on page 14.
7. Attach the belt returns. Refer to “Belt Return Installation” on page 15.
8. Attach any guides / accessories. Refer to the "Service Parts" section starting on page 26.

## Conveyors Longer than 10 ft (3048 mm)

Typical Connection Components (Figure 4).

- |   |                                       |
|---|---------------------------------------|
| 1 | Connector hex rods (x2)               |
| 2 | M10 x 1.5 mm hex head cap screws (x4) |
| 3 | Conveyor frames                       |

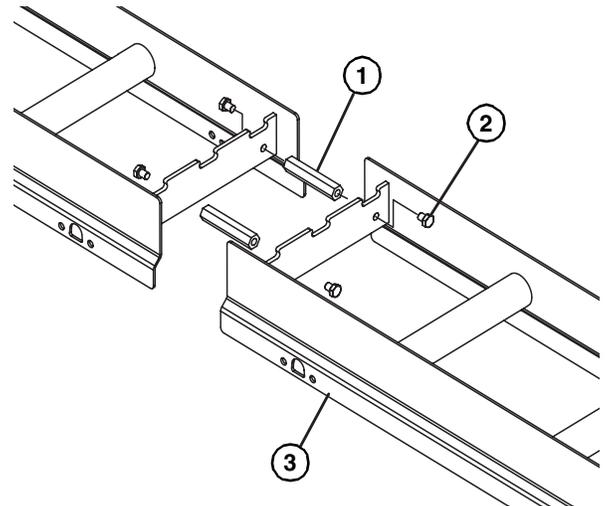


Figure 4

1. Locate and arrange conveyor sections by section labels (Figure 5, item 1).

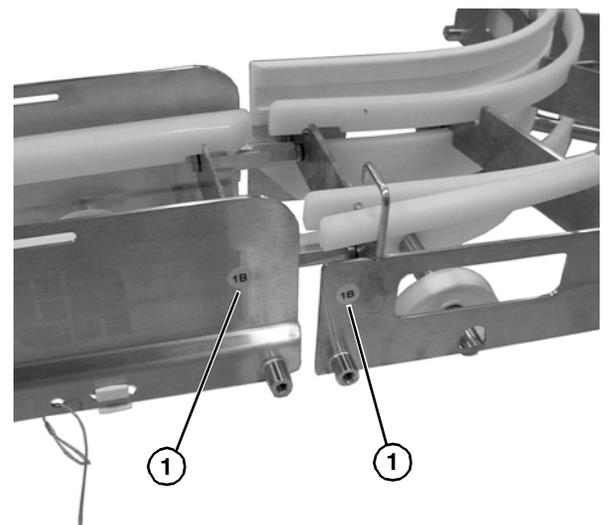


Figure 5

2. Position the frame sections in the correct order.

# Installation

3. Connect the frame sections by bolting the hex post connectors (Figure 6, item 1) the sections of frame.

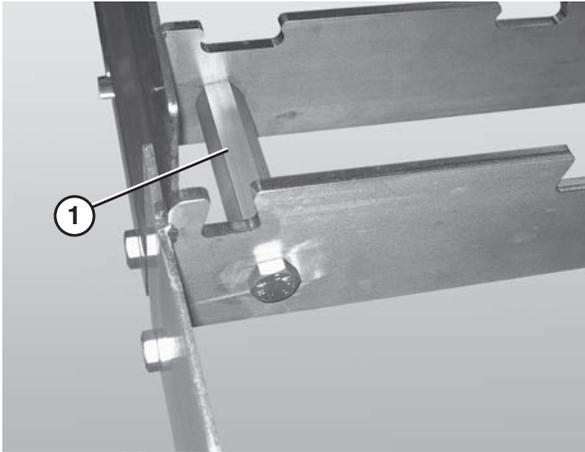


Figure 6

## LPZ Conveyors

### Knuckles

1. Attach upper knuckle (Figure 7, item 1) to frame (Figure 7, item 2) with hex rods (Figure 7, item 3) and bolts (Figure 7, item 4).

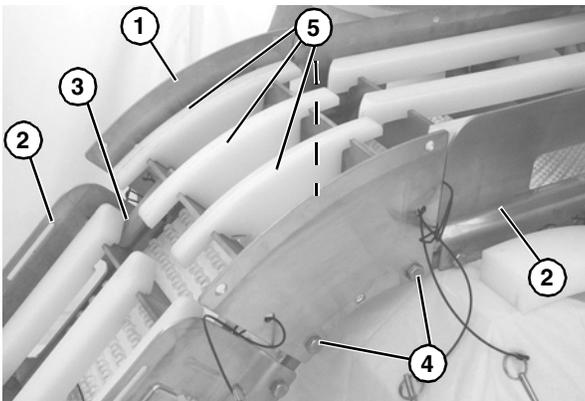


Figure 7

2. Install wear strips (Figure 7, item 5).

3. Attach lower knuckle (Figure 8, item 1) to frame (Figure 8, item 2) with hex rods (Figure 8, item 3) and bolts (Figure 8, item 4).

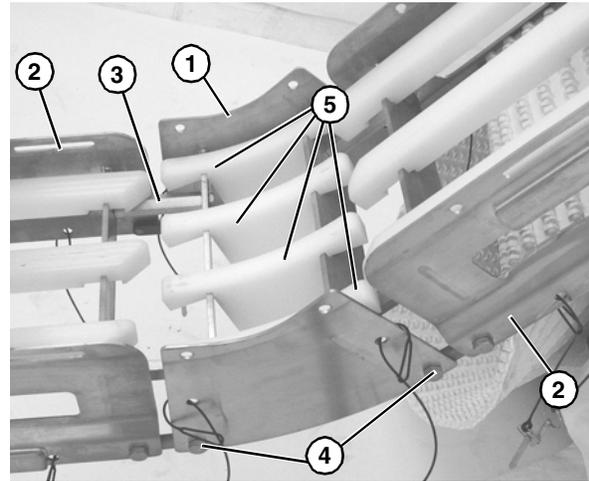


Figure 8

4. Install wear strips (Figure 8, item 5).

### Belt

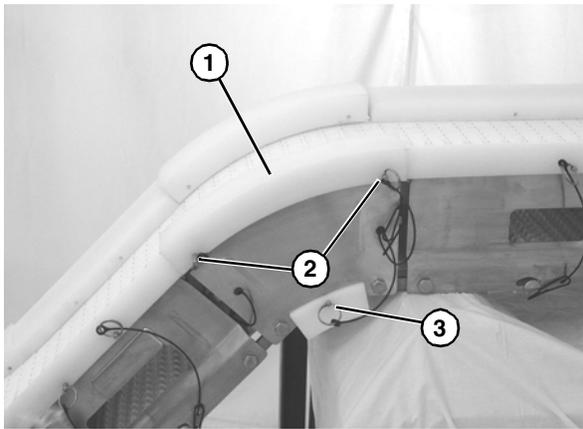
1. Slide belt (Figure 9, item 1) over knuckles on top of the wear strips.



Figure 9

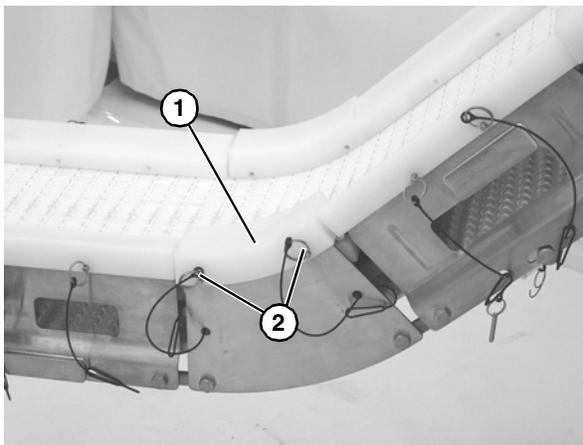
## Guides

1. Slide guides (**Figure 10, item 1**) on to the knuckle frame, and secure with pull pins (**Figure 10, item 2**).



**Figure 10**

2. Install return guides and secure with pull pin (**Figure 10, item 3**).
3. Slide guides (**Figure 11, item 1**) onto lower knuckle frame, and secure with pull pins (**Figure 11, item 2**).



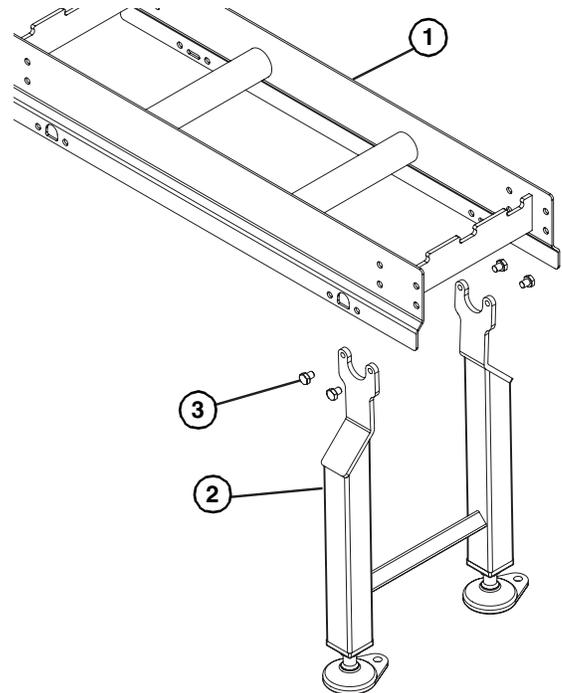
**Figure 11**

## All Conveyors

### Stand Installation

Typical Stand Components (**Figure 12**)

1	Conveyor frame
2	Stand
3	M10 - 1.5 x 12 mm hex head cap screws (x4)



**Figure 12**

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame (**Figure 13**).



**Figure 13**

# Installation

## Tail Assembly Installation

### Drive Tail

Typical Drive Tail Components (Figure 14).

1	Drive tail assembly
2	Bolt (x4)
3	Conveyor frame

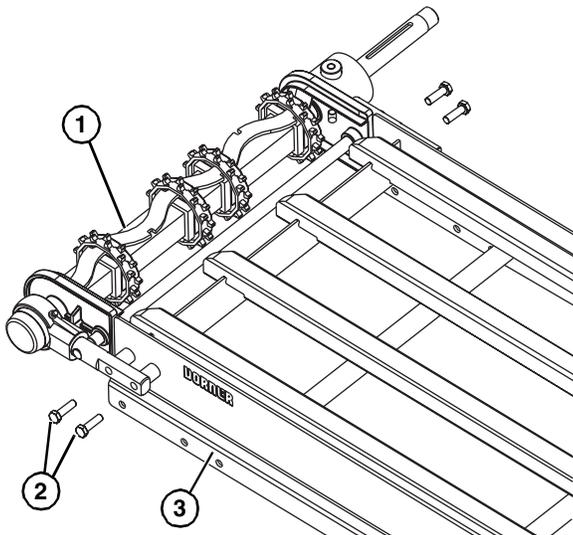


Figure 14

### ⚠ CAUTION

To avoid injury and damage to parts, have an assistant hold opposite end of drive tail when removing or installing it.

1. Install drive tail assembly (Figure 15, item 1) onto the mounting posts (Figure 15, item 2) and secure with two bolts (Figure 15, item 3) on each side.

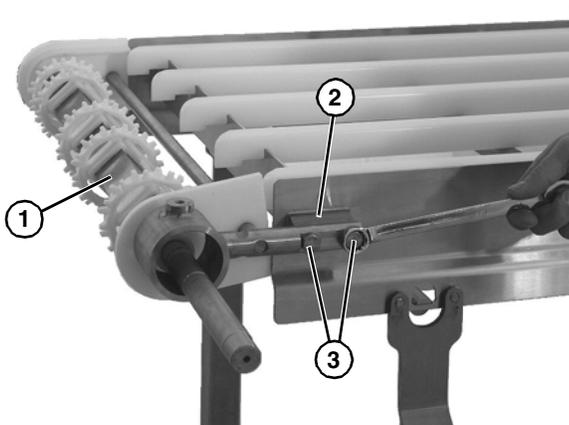


Figure 15

2. Install the drive package, if applicable. Refer to the "7400 Series Drive Package Installation, Maintenance and Parts Manual."

## Tip Up Assembly

Typical Tip Up Assembly Components (Figure 16)

1	Hex Bar
2	Stop Key (x2)
3	Tip Up Sleeve (x2)

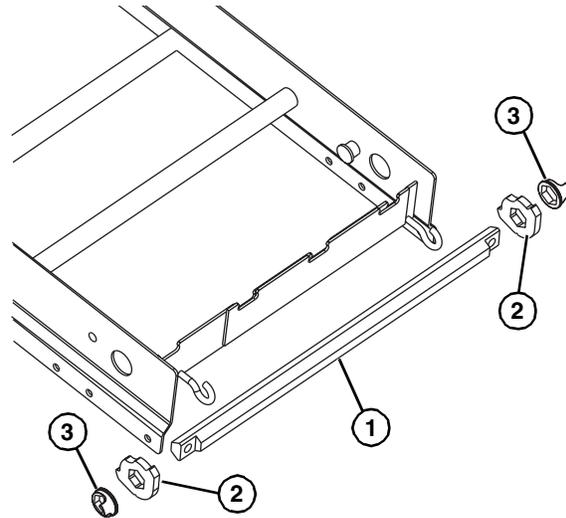


Figure 16

1. Slide stop keys (Figure 17, item 1) and tip up sleeves (Figure 17, item 2) onto hex shaft (Figure 17, item 3). The tabs on the tip up sleeves face outward and align with the slotted ends of the hex shaft as shown.

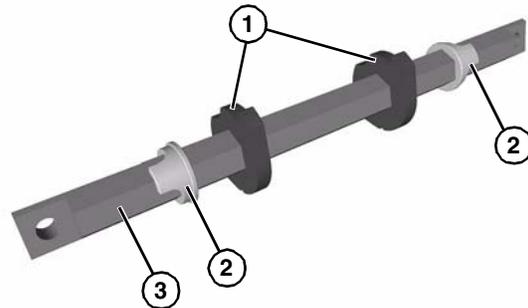
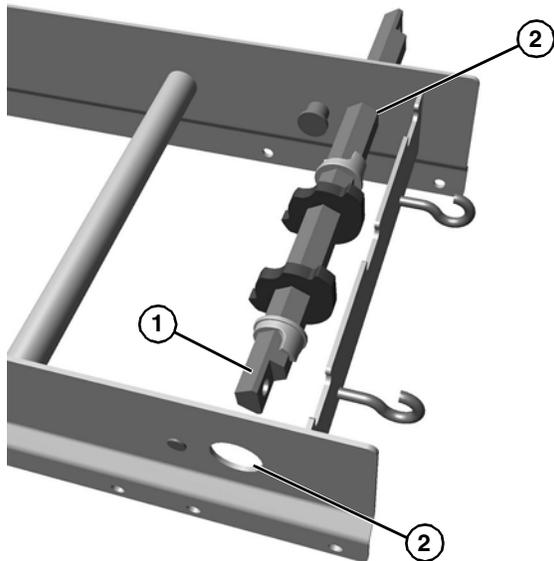


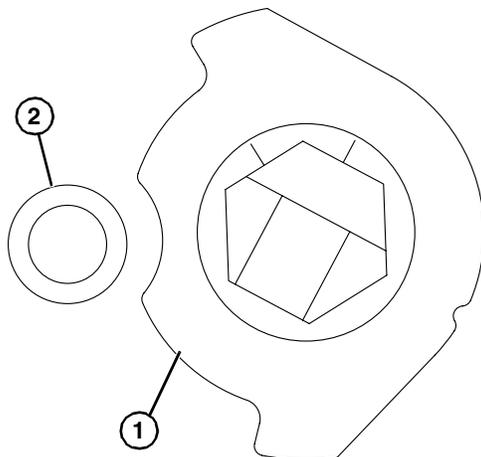
Figure 17

- Place hex shaft assembly (**Figure 18, item 1**) through the conveyor frame tip up holes (**Figure 18, item 2**) and center with conveyor.



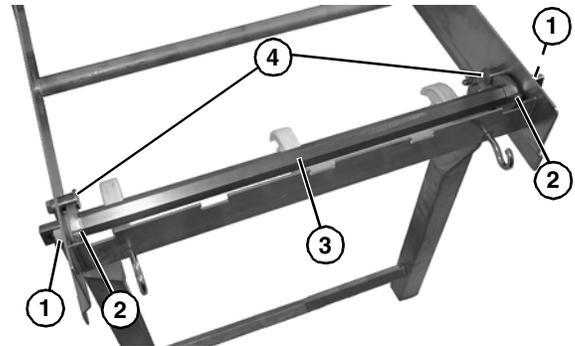
**Figure 18**

- Hex shaft assembly will need to be rotated (**Figure 19**) for stop keys (**Figure 19, item 1**) to pass by the frame stops (**Figure 19, item 2**).



**Figure 19**

- Slide the tip up sleeves (**Figure 20, item 1**) and stop keys (**Figure 20, item 2**) outward on hex shaft assembly (**Figure 20, item 3**) until the sleeves seat in the holes of the frame and stop keys are seated against frame stops (**Figure 20, item 4**).

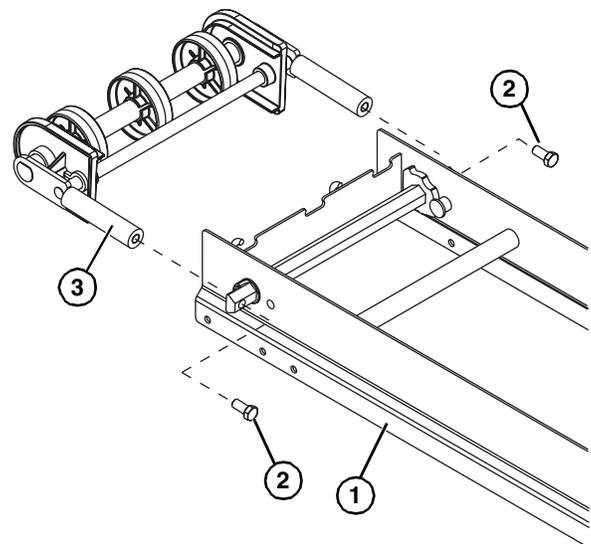


**Figure 20**

## Idler Tail

Typical Idler Tail Components (**Figure 21**)

1	Conveyor Frame
2	Bolt (x2)
3	Idler tail assembly



**Figure 21**

# Installation

## ⚠ CAUTION

To avoid injury and damage to parts, have an assistant hold opposite end of idler tail when removing or installing it.

1. Place the idler tail assembly (Figure 22, item 1) against the holes in the tip up hex shaft assembly (Figure 22, item 2) and secure with a bolt (Figure 22, item 3) on each side.

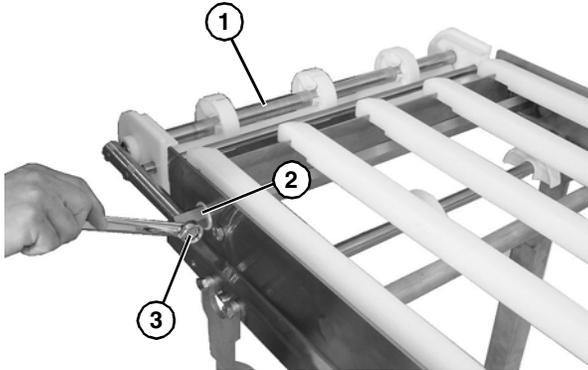


Figure 22

### Nose Bar Idler Tail

Typical Nose Bar Idler Tail Components (Figure 23)

- |   |                              |
|---|------------------------------|
| 1 | Nose bar idler tail assembly |
| 2 | Bolt (x2)                    |
| 3 | Conveyor frame               |

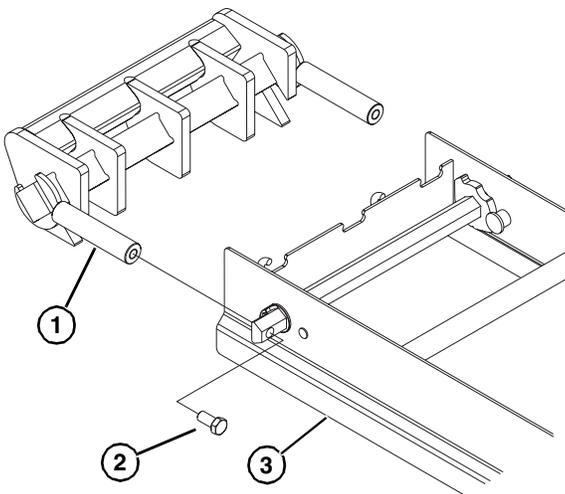


Figure 23

1. Place the nose bar idler shafts (Figure 24, item 1) against the holes in the hex shaft assembly (Figure 24, item 2) and secure each with a bolt (Figure 24, item 3).

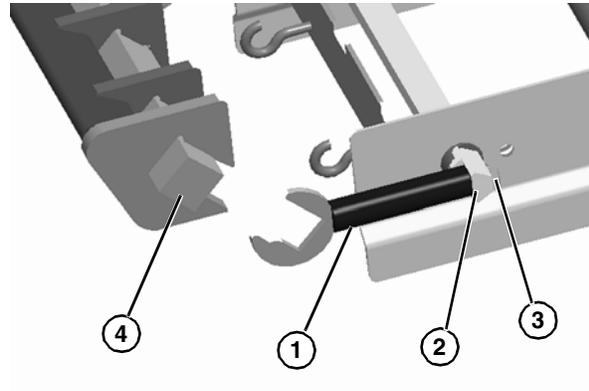


Figure 24

2. Attach the nose bar transfer post (Figure 24, item 4) to the nose bar idler shafts.
3. Ensure that the nose bar pucks (Figure 25, item 1) are in line with the conveyor frame (Figure 25, item 2).

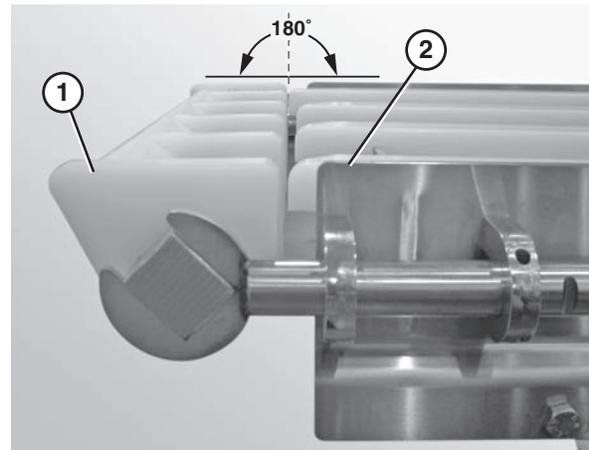


Figure 25

## Lifter Installation

Typical Lifter Components (Figure 26)

1	Belt lift pivot bar
2	Lifter bars
3	Belt lift handle
4	M8 - 1.25 x 16 mm hex head cap screw

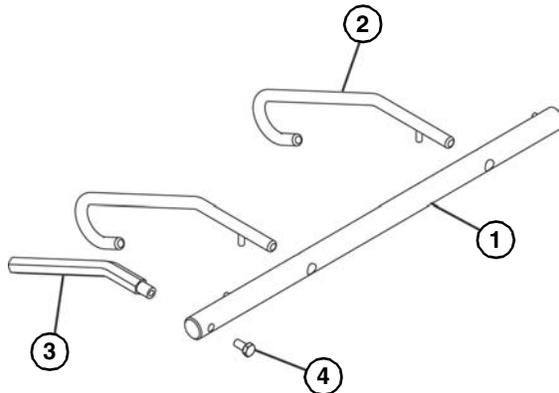


Figure 26

1. Slide the belt lift pivot bar (Figure 27, item 1) through the designated holes in the frame.

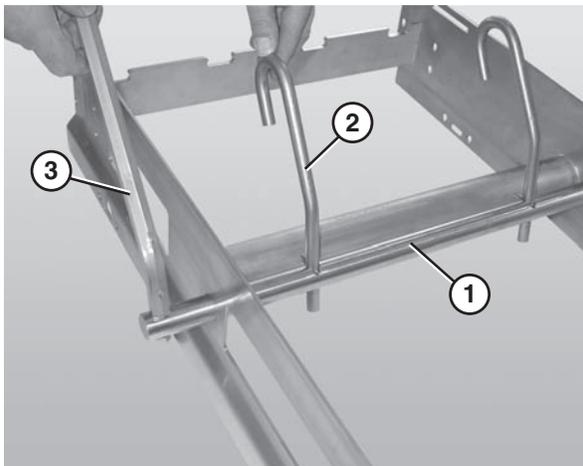


Figure 27

2. Attach the lifter bars (Figure 27, item 2) to the belt lift pivot bar (Figure 27, item 1). Make sure the hooked ends of the lifter bars are facing down when resting against the frame.
3. Attach the lifter handle (Figure 27, item 3) to the belt lift pivot rod.

## Wear Strip Installation

Typical Wear Strip Components (Figure 28)

1	Wear strip
---	------------

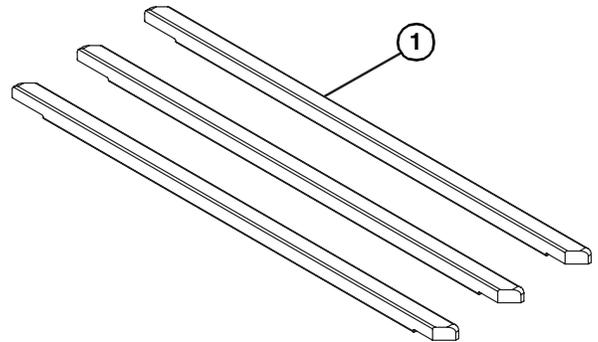


Figure 28

1. Position the wear strips (Figure 29, item 1) on the frame.

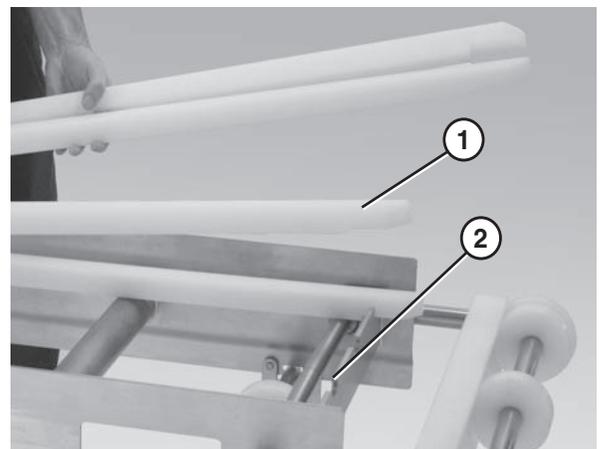


Figure 29

2. Make sure the wear strips are situated securely in the frame slots (Figure 29, item 2).

# Installation

## Belt Installation

Typical Belt Components (Figure 30)

1	Chain belt
2	Belt rod

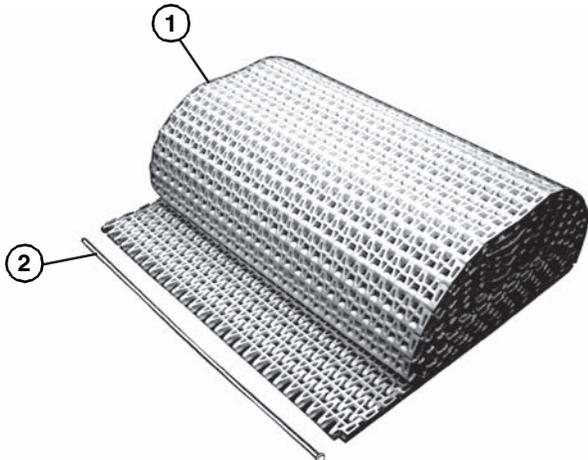


Figure 30

1. Position the belt on the conveyor frame (Figure 31).



Figure 31

2. Wrap the belt around the conveyor, making sure the sprocket teeth have engaged the belt.

3. Bring the ends of the belt together (Figure 32).



Figure 32

4. Insert the belt rod (Figure 33, item 1).

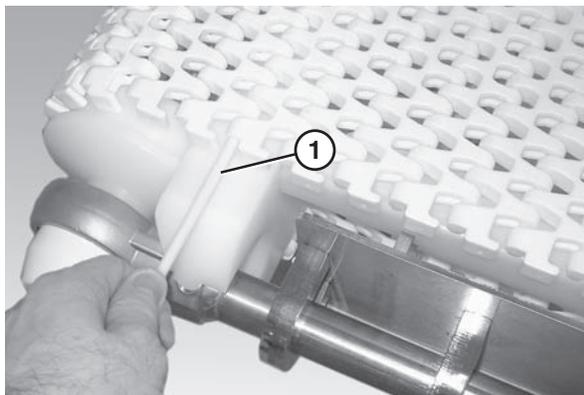


Figure 33

5. Push the belt rod in as far as possible.
6. Lightly tap the head of the rod with a hammer until it snaps into position.
7. Check belt sag by measuring from the top of the return (Figure 34).

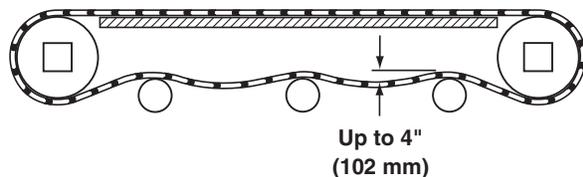


Figure 34

### **CAUTION**

Belt sag should not exceed 4" (102 mm) from the top of the returns.

## Belt Return Installation

Typical Belt Return Components (Figure 35)

1	Return shaft
2	Chain return shoe

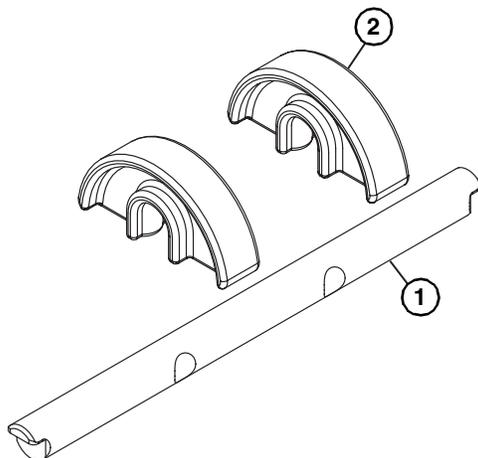


Figure 35

1. Attach the chain return shoes (Figure 36, item 1) to the return shaft (Figure 36, item 2).

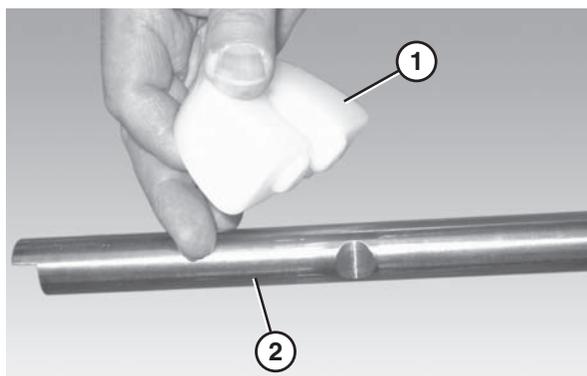


Figure 36

2. Slide the return shaft (Figure 37, item 1) up and through the large slot (Figure 37, item 2) in the frame (picture shown without the belt or wear strips).

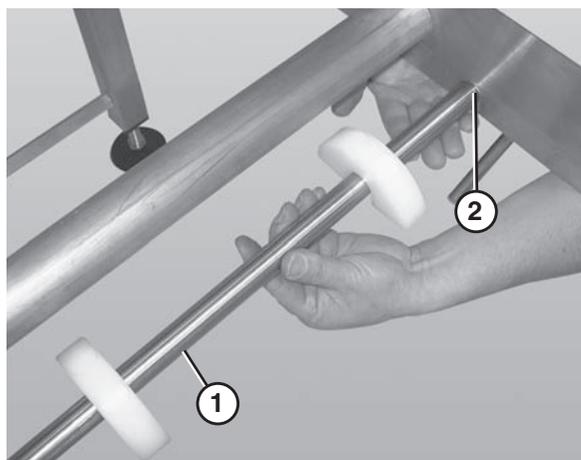


Figure 37

3. Push up on the return shaft (Figure 37, item 1) and slide the notched end of the shaft through the small slot on the opposite side of the frame.
4. See Step 7 of Belt Installation to check for proper belt sag.

## Mounting Block Installation

1. Clamp mounting block (Figure 38, item 1) to frame (Figure 38, item 2).
2. Tighten bolt to 20 in-lb (2 Nm) to secure (Figure 38, item 3).

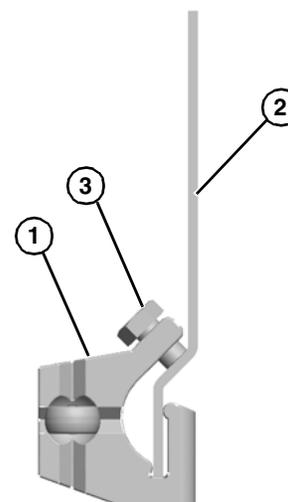


Figure 38

### **⚠ CAUTION**

Do not over tighten bolt. Over tightening may cause the mounting block to deform.

# Preventive Maintenance and Adjustment

## Required Tools

- 17 mm wrench (or adjustable wrench)
- 1/8" hex wrench (for bearing shaft assembly fasteners)
- 3 mm hex wrench
- Punch and hammer (to remove belt rod)

## Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 26 for recommendations.
- Replace any worn
- or damaged parts.

## Cleaning

### NOTE

*Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.*

### CAUTION

Dorner recommends cleaning all the "food zones" prior to placing conveyor into service. Ensure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.

## Routine Cleaning

### WARNING

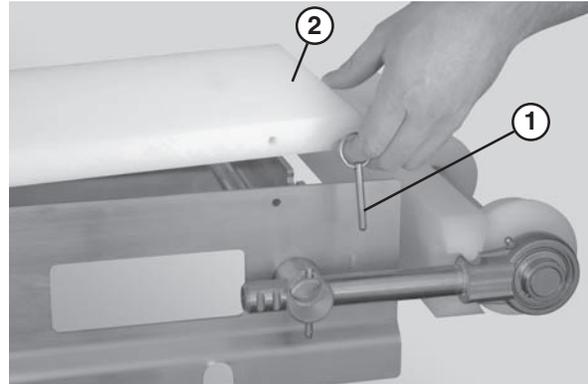


### SEVERE HAZARD!

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

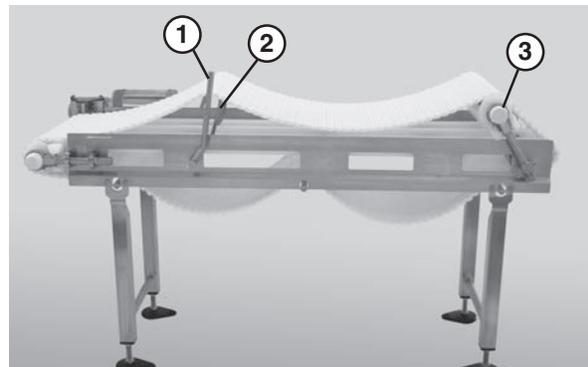
Dorner recommends cleaning the inside and the outside of the conveyor on a daily basis. Refer to the following steps to access the inside of the conveyor.

1. Remove the guides, if applicable, by removing the pull pins (**Figure 39, item 1**) that connect the guide (**Figure 39, item 2**) to the frame.



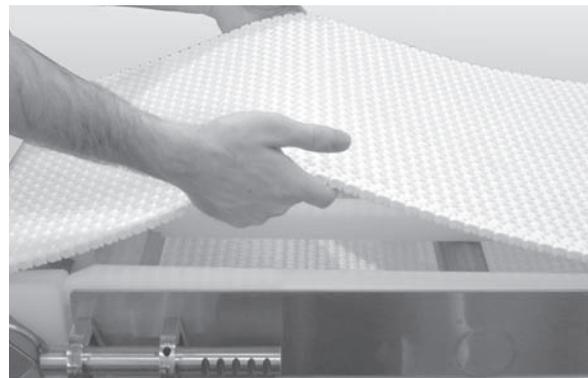
**Figure 39**

2. Use the lifter handle (**Figure 40, item 1**) to raise the lifters (**Figure 40, item 2**) if applicable, and raise the tip up tail (**Figure 40, item 3**).



**Figure 40**

3. If conveyor does not have belt lifters, lift up on belt manually (**Figure 41**).



**Figure 41**

### CAUTION

**DO NOT submerge or soak bearing assemblies. This will reduce the life of the bearing.**

# Preventive Maintenance and Adjustment

## Periodic Cleaning

Dorner recommends complete disassembly of the conveyor periodically for thorough cleaning.

For conveyor disassembly and reassembly instructions:

- Refer to “Conveyor Belt Replacement” on page 18.
- Refer to “Sprocket and Puck Removal” on page 21.
- Refer to “Slide the nose bar pucks (Figure 64, item 1) off the nose bar shaft (Figure 64, item 2).” on page 23.

## Lubrication

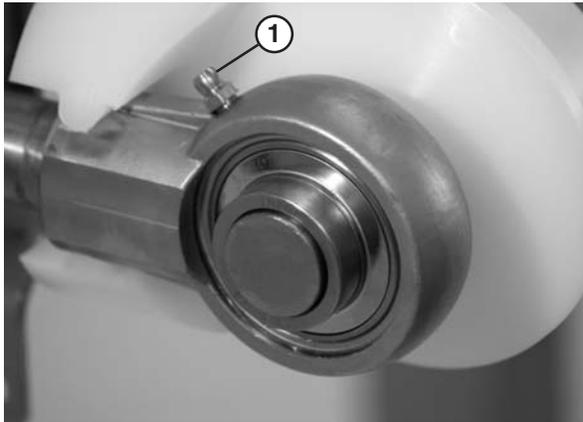
### Conveyor Bearings

Conveyor bearing lubrication is required. Dorner recommends using an H-1 food grade grease.

#### NOTE

*Although bearings are sealed, re-greasing is recommended to increase bearing life. An H-1 food grade grease is recommended. The frequency of bearing re-greasing is dependent upon the application in which the conveyor is being used. Frequency of re-greasing will increase with the frequency of conveyor washing.*

1. Add grease to the bearing using the zerk fitting (Figure 42, item 1) on the exterior of the bearing shaft assembly.



**Figure 42**

2. Replace the bearings if they become worn.

## Wearstrips and Belt Returns

Replace the wearstrips and belt returns if they become worn.

For wearstrip and belt return installation instructions:

- Refer to “Wear Strip Installation” on page 13.
- Refer to “Belt Return Installation” on page 15.

## Maintaining the Conveyor Belt

### Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

Damage to belt links or rods, surface cuts and / or wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories

Skipping indicates:

- Excessive load on belt
- Worn sprockets or impacted dirt on drive pulley

Damage to belt links or rods indicate:

- Excessive load on belt
- Dirt impacted on sprockets
- Excessive or improper side loading
- Improperly positioned accessories

# Preventive Maintenance and Adjustment

## Conveyor Belt Replacement

<b>⚠ WARNING</b>

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

### Conveyors with Guides

1. Remove the pull pins (Figure 43, item 1) that connect the guide (Figure 43, item 2) to the frame.

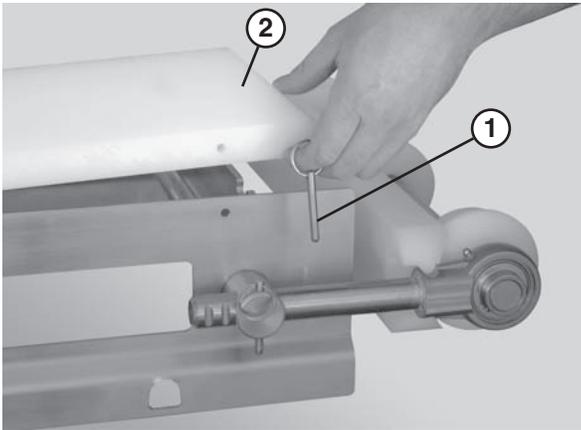


Figure 43

2. Remove the guide (Figure 44, item 1).

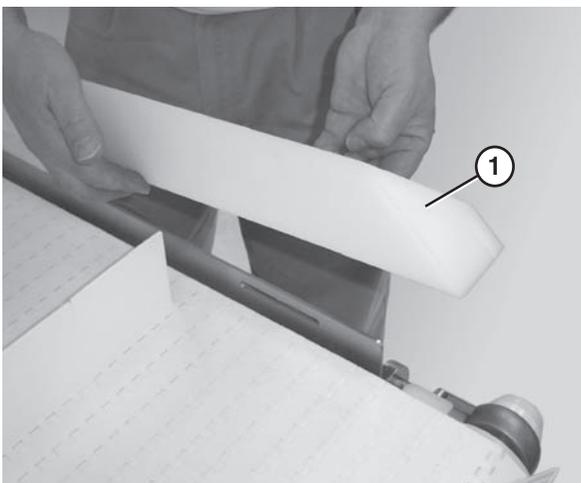


Figure 44

3. Follow the belt replacement procedures described in “Standard Belts” on page 18, “Specialty Intralox 1100 Series Belts” on page 19, or “Specialty Intralox 1600 Series Belts” on page 20.

## Standard Belts

### Replacing a Section of Belt

<b>⚠ CAUTION</b>
<b>Secure the retaining head side of the belt prior to removing a belt rod in order to prevent damaging the belt.</b>

1. Secure the retaining head side of the belt. Use the belt removal tool (Figure 45, item 1) for 1" pitch belts. For all other belts, position the section of belt so that it is braced by the flanged puck (Figure 45, item 2).

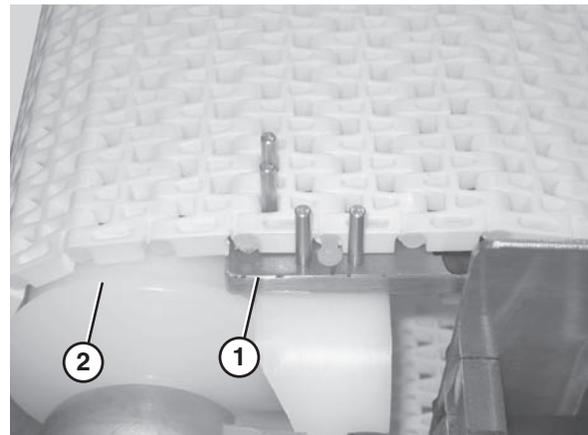


Figure 45

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head (Figure 46).



Figure 46

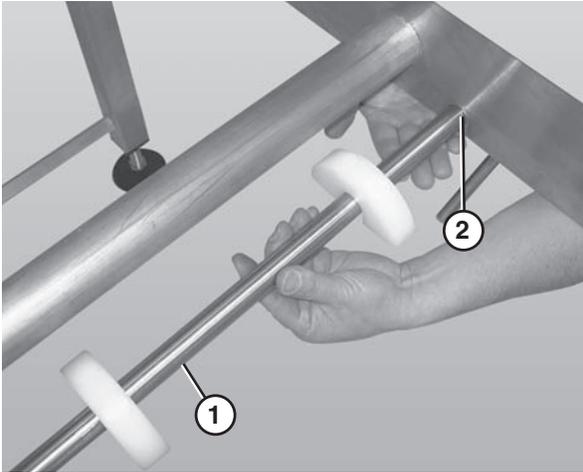
3. Remove the belt rods on both sides of the section of belt being replaced.
4. Replace the old section with a new section of belt.

<b>⚠ CAUTION</b>
<b>DO NOT reuse belt rods that are damaged or show signs of wear.</b>

# Preventive Maintenance and Adjustment

## Replacing the Entire Belt

1. Remove the belt returns by pushing up on the return shaft (**Figure 47, item 1**) and sliding it through the large hole (**Figure 47, item 2**) in the frame.



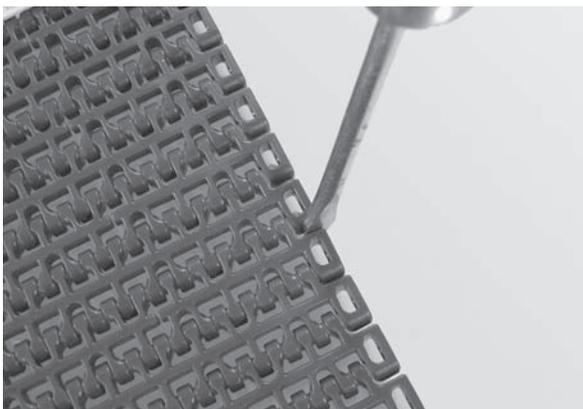
**Figure 47**

2. Lower the opposite end of the return shaft (**Figure 47, item 1**) and slide it out of the frame.
3. Follow steps 1 – 3 in "Standard Belts: Replacing a Section of Belt" on page 18.
4. Remove the belt.
5. Replace the damaged or worn belt. Refer to "Belt Installation" on page 14 and "Belt Return Installation" on page 15.

## Specialty Intralox 1100 Series Belts

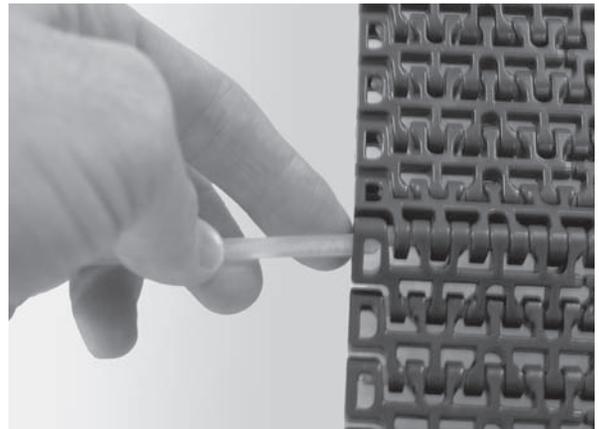
### Replacing a Section of Belt

1. Place the edge of a flat head screwdriver between the two belt links and turn clockwise (**Figure 48**).



**Figure 48**

2. Use a second belt rod of the same size to push on the opposite end of the belt rod. (**Figure 49**).



**Figure 49**

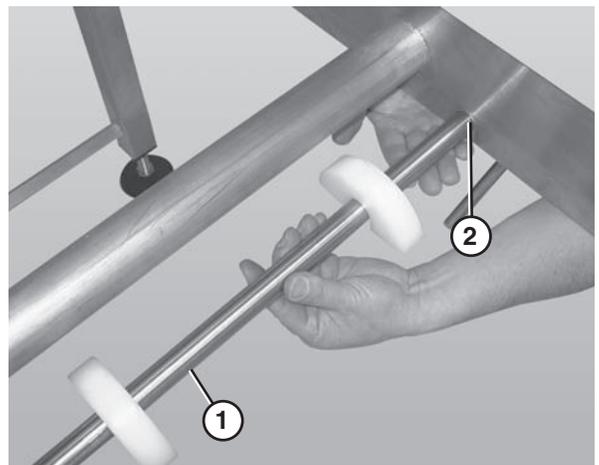
3. Remove the belt rods on both sides of the section of belt being replaced.
4. Replace the old section with a new section of belt.

### **CAUTION**

**DO NOT reuse belt rods that are damaged or show signs of wear.**

## Replacing the Entire Belt

1. Remove the belt returns by pushing up on the return shaft (**Figure 50, item 1**) and sliding it through the large hole (**Figure 50, item 2**) in the frame.



**Figure 50**

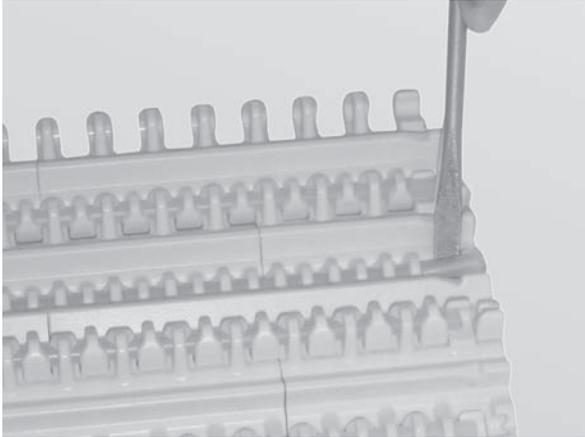
2. Lower the opposite end of the return shaft (**Figure 50, item 1**) and slide it out of the frame.
3. Follow steps 1 – 2 in "Specialty Intralox 1100 Series Belts: Replacing a Section of Belt" on page 19.
4. Remove the belt.
5. Replace the damaged or worn belt. Refer to "Belt Installation" on page 14 and "Belt Return Installation" page 15.

# Preventive Maintenance and Adjustment

## Specialty Intralox 1600 Series Belts

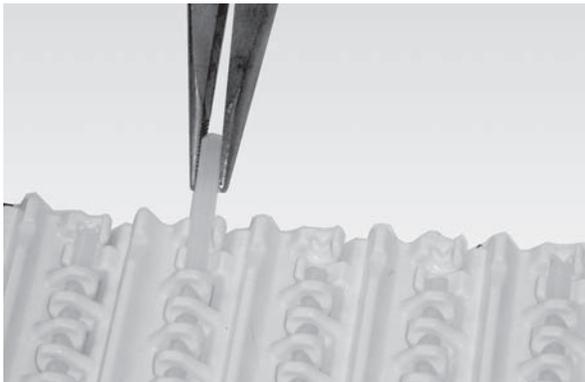
### Replacing a Section of Belt

1. Lift up on the belt to gain access to the underside.
2. Use a flat head screwdriver to raise the end of the belt rod above the retention lip (**Figure 51**).



**Figure 51**

3. Remove the belt rod by gripping the end with a set of pliers and pulling (**Figure 52**).



**Figure 52**

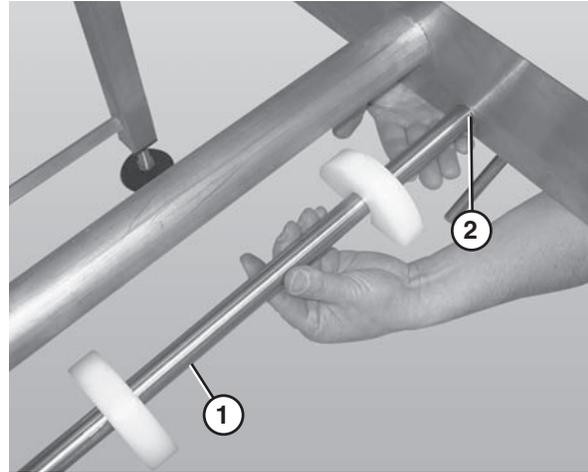
4. Remove the belt rods on both sides of the section of belt being replaced.
5. Replace the old section with a new section of belt.

#### **⚠ CAUTION**

**DO NOT** reuse belt rods that are damaged or show signs of wear.

### Replacing the Entire Belt

1. Remove the belt returns by pushing up on the return shaft (**Figure 53, item 1**) and sliding it through the large hole (**Figure 53, item 2**) in the frame.



**Figure 53**

2. Lower the opposite end of the return shaft (**Figure 53, item 1**) and slide it out of the frame.
3. Follow steps 1 – 2 in "Specialty Intralox 1600 Series Belts: Replacing a Section of Belt" on page page 20.
4. Remove the belt.
5. Replace the damaged or worn belt. Refer to "Belt Installation" on page 14 and "Belt Return Installation" page 15.

### Conveyor Belt Tensioning

#### **⚠ WARNING**



#### **SEVERE HAZARD!**

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

#### **⚠ CAUTION**

**Belt sag** should not exceed 4" (102 mm) from the top of the returns.

1. Check belt for proper sag. Refer to step 7 of "Belt Installation" on page 14.
2. If belt has excessive sag, remove one or more belt links to take up the tension. Refer to "Replacing a Section of Belt" on page 18.

# Preventive Maintenance and Adjustment

## Sprocket and Puck Removal

 <b>WARNING</b>

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

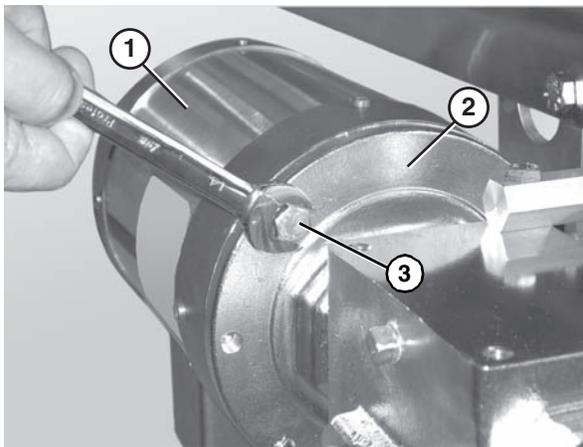
1. Remove the conveyor belt to access the sprockets / pucks. Refer to “Conveyor Belt Replacement” on page 18.
2. Remove the desired sprocket / puck by following these instructions:
  - A - Drive Sprocket Removal
  - B - Idler Puck Removal
  - C - Nose Bar Puck Removal

### A - Drive Sprocket Removal

 <b>WARNING</b>

<b>PUNCTURE HAZARD!</b> <b>Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.</b>

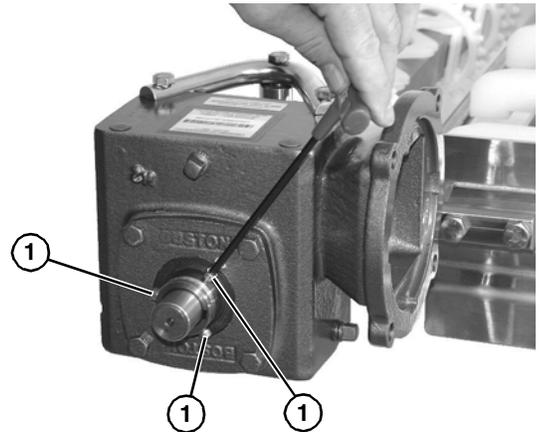
1. Remove the bolts that connect the motor to the drive assembly (**Figure 54, item 3**).



**Figure 54**

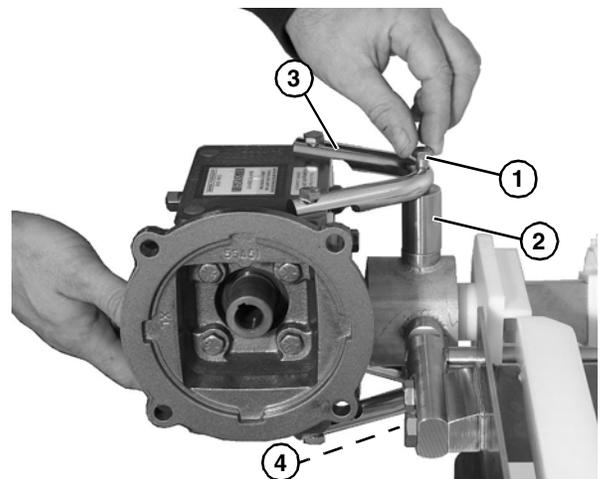
2. Remove the motor (**Figure 54, item 1**) from the drive assembly (**Figure 54, item 2**).

3. Using a hex wrench, loosen the allen head screws (**Figure 55, item 1**) that connect the gearmotor to the drive spindle. Repeat on opposite side of gearmotor.



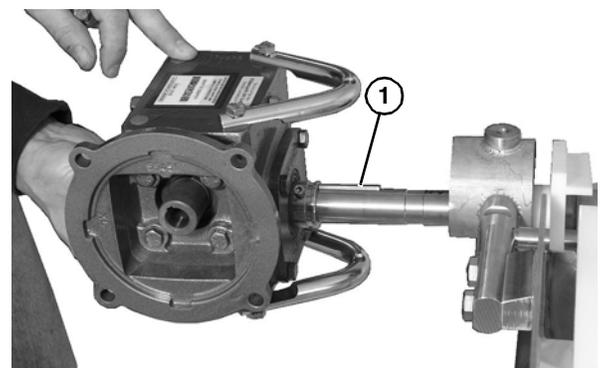
**Figure 55**

4. Remove top bolt (**Figure 56, item 1**) and spacer (**Figure 56, item 2**) holding the bracket (**Figure 56, item 3**) to the drive assembly.



**Figure 56**

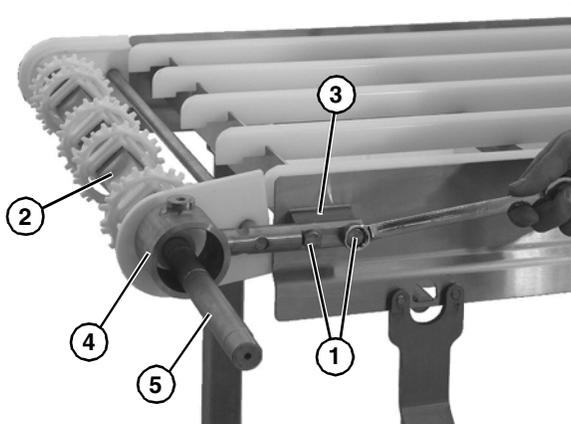
5. Remove bottom bolt (**Figure 56, item 4**).
6. Slide assembly off the bearing spindle (**Figure 57**). Remove the key (**Figure 57, item 1**).



**Figure 57**

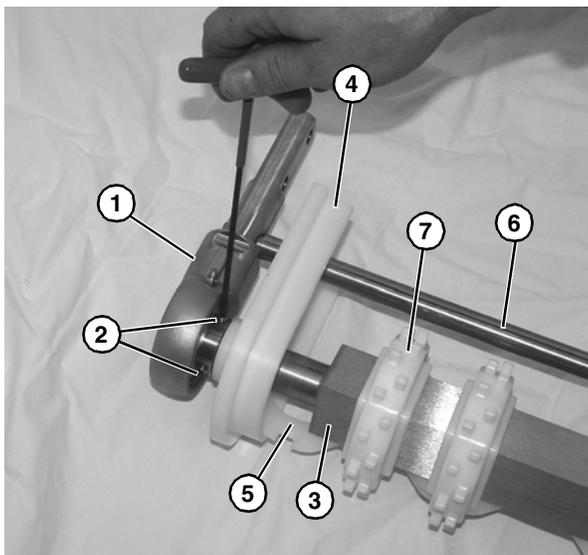
# Preventive Maintenance and Adjustment

- Remove two bolts (**Figure 58, item 1**) on each side, and slide the drive tail assembly (**Figure 58, item 2**) off the mounting posts (**Figure 58, item 3**).



**Figure 58**

- Slide the motor support bracket (**Figure 58, item 4**) off the drive spindle shaft (**Figure 58, item 5**).
- Remove the bearing cover from bearing shaft assembly (**Figure 59, item 1**).

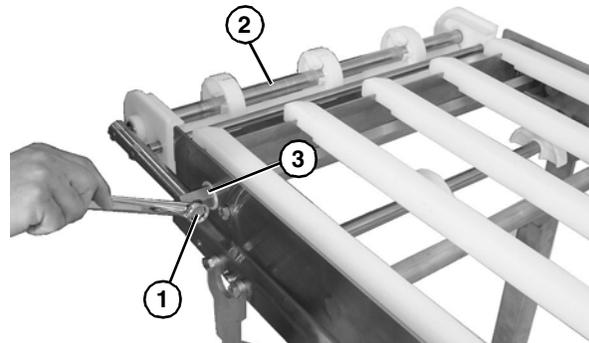


**Figure 59**

- Use a hex wrench to loosen two set screws (**Figure 59, item 2**) on the bearing shaft assembly (**Figure 59, item 1**).
- Slide the bearing shaft assembly off of the drive spindle (**Figure 59, item 3**). Slide bearing shaft assembly off the drive spindle on opposite side.
- Remove pinch guard (**Figure 59, item 4**) on each side.
- Remove sprocket alignment bar (**Figure 59, item 5**), and pinch guard shaft (**Figure 59, item 6**).
- Remove the sprockets (**Figure 59, item 7**).

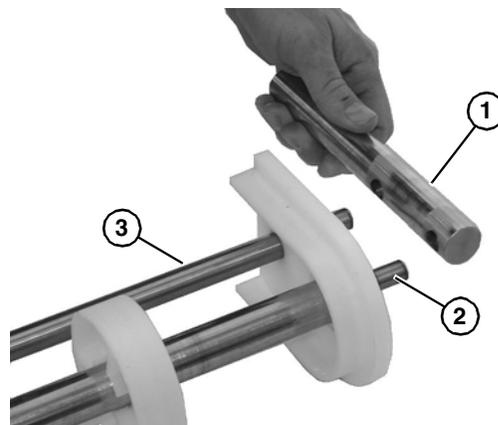
## B - Idler Puck Removal

- Remove bolt (**Figure 60, item 1**) from each side, and remove idler tail assembly (**Figure 60, item 2**) from take up blocks (**Figure 60, item 3**).



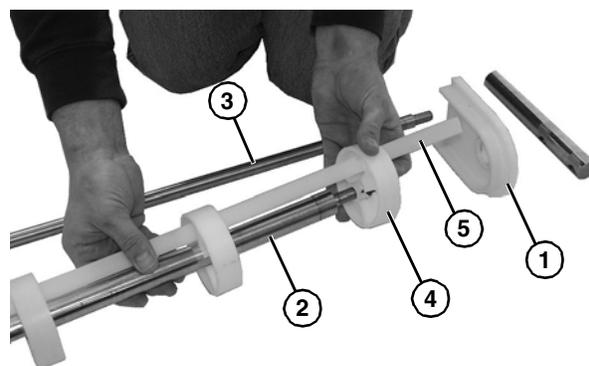
**Figure 60**

- Remove the bearing end rod (**Figure 61, item 1**) from idler shaft (**Figure 61, item 2**) and pinch guard shaft (**Figure 61, item 3**).



**Figure 61**

- Remove pinch guard (**Figure 62, item 1**) from idler shaft (**Figure 62, item 2**) and pinch guard shaft (**Figure 62, item 3**).



**Figure 62**

- Slide the pucks (**Figure 62, item 4**) and alignment bar (**Figure 62, item 5**) off the idler shaft (**Figure 62, item 2**).

# Preventive Maintenance and Adjustment

## C - Nose Bar Puck Removal

1. Slide the nose bar drive or transfer post (Figure 63, item 1) out of the nose bar drive weldment or idler hands (Figure 63, item 2).

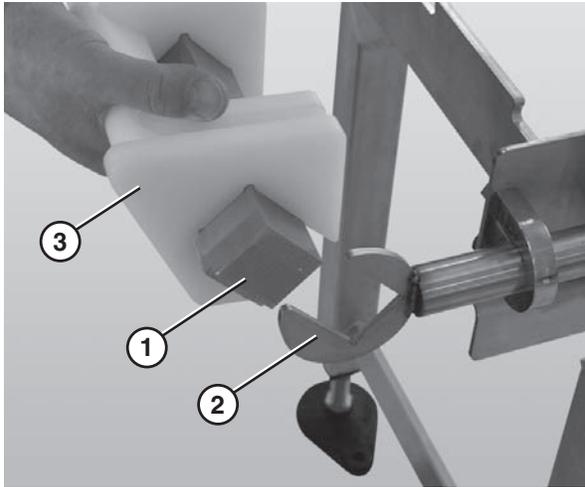


Figure 63

2. Remove the nose bar tracking pucks (Figure 63, item 3), if applicable.
3. Remove the nose bar wear strip (Figure 64, item 3).

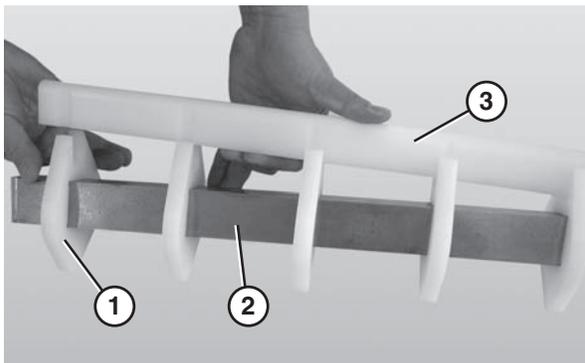


Figure 64

4. Slide the nose bar pucks (Figure 64, item 1) off the nose bar shaft (Figure 64, item 2).

## Reassembling Tail Assemblies

Refer to the "Service Parts" section starting on page 26 for complete diagrams and lists of all tail assembly components.

### Nose Bar Idler

1. Slide the nose bar pucks (Figure 65, item 1) onto the nose bar drive post (Figure 65, item 2).

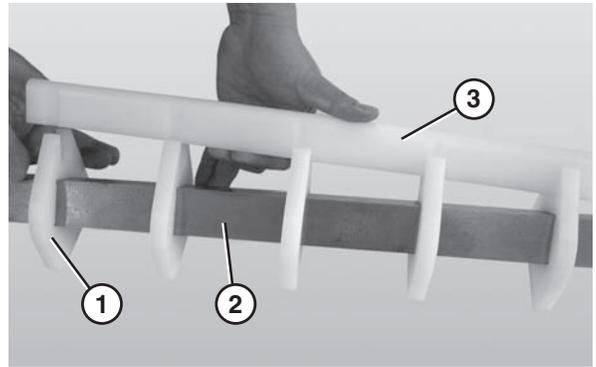


Figure 65

2. Attach the nose bar wear strip (Figure 65, item 3).
3. Attach the nose bar tracking pucks (Figure 66, item 1) to the nose bar drive post (Figure 66, item 2).

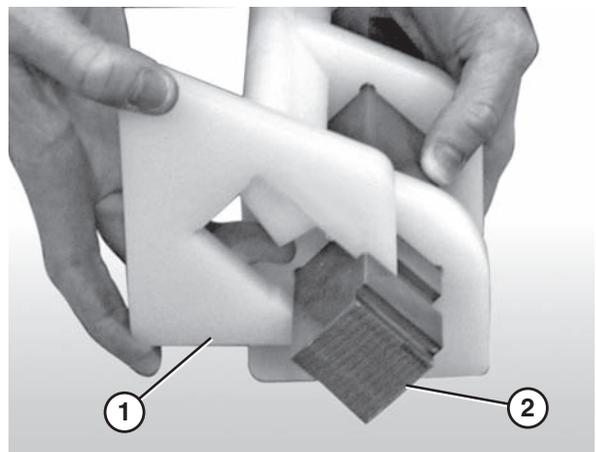


Figure 66

4. After all tracking pucks (Figure 67, item 3) are installed, slide the nose bar drive or transfer post (Figure 67, item 1) into the nose bar drive weldment or idler hands (Figure 67, item 2).

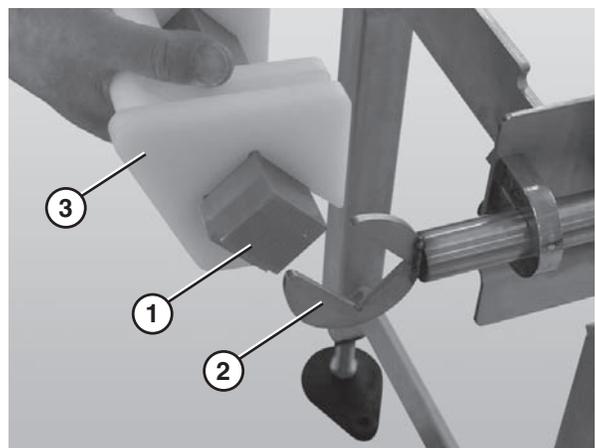


Figure 67

# Preventive Maintenance and Adjustment

## Idler Tail

1. Place the pucks (Figure 68, item 1) into the slots (Figure 68, item 2) of alignment bar (Figure 68, item 3), and install onto the idler shaft (Figure 68, item 4).

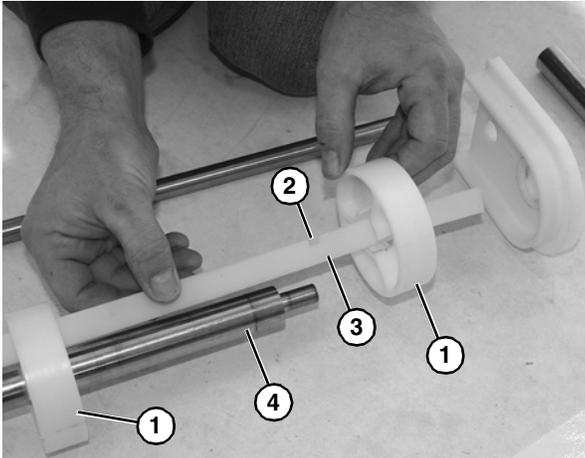


Figure 68

2. Slide all the idler pucks (Figure 69, item 1) along with alignment bar onto idler shaft (Figure 69, item 2).

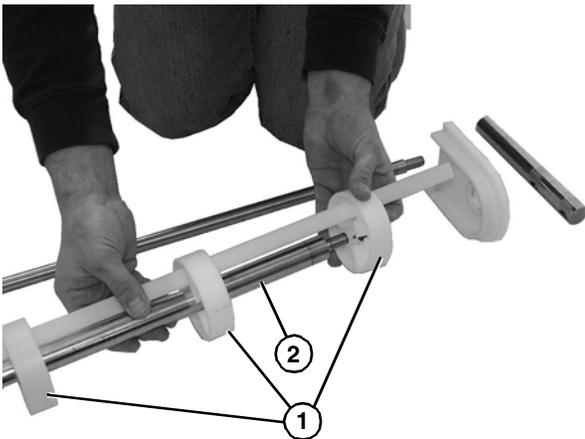


Figure 69

3. Install the pinch guard (Figure 70, item 1) to each side onto idler shaft (Figure 70, item 2) and pinch guard shaft (Figure 70, item 3).

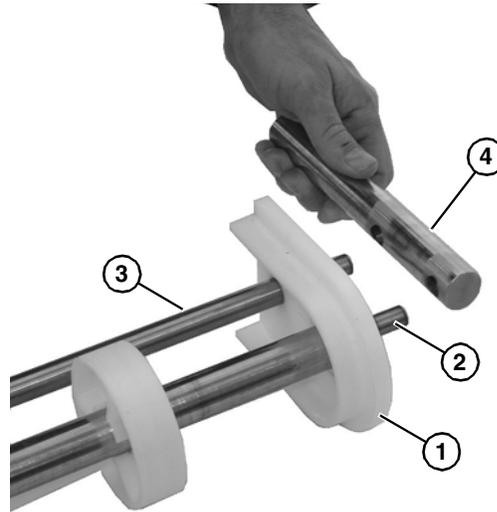


Figure 70

4. Install the bearing end rod (Figure 70, item 4) onto idler shaft (Figure 70, item 2) and rod (Figure 70, item 3).

## Drive Tail

1. Assemble sprockets (Figure 71, item 1) to the slots (Figure 71, item 2) of alignment bar (Figure 71, item 3), and install assembly onto drive spindle (Figure 71, item 4).

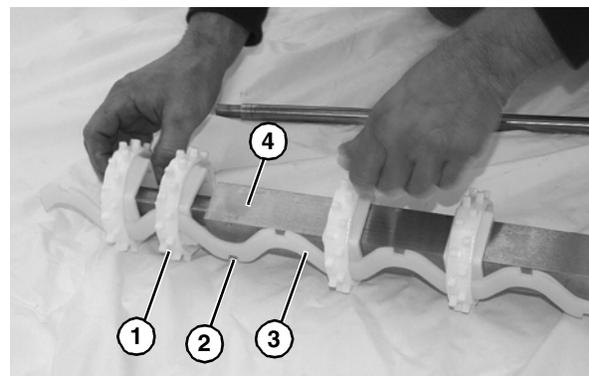
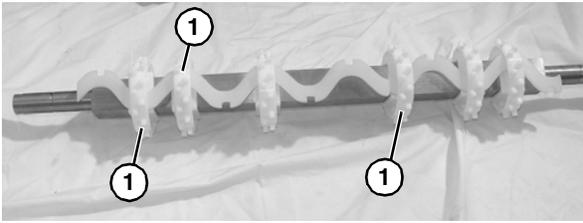


Figure 71

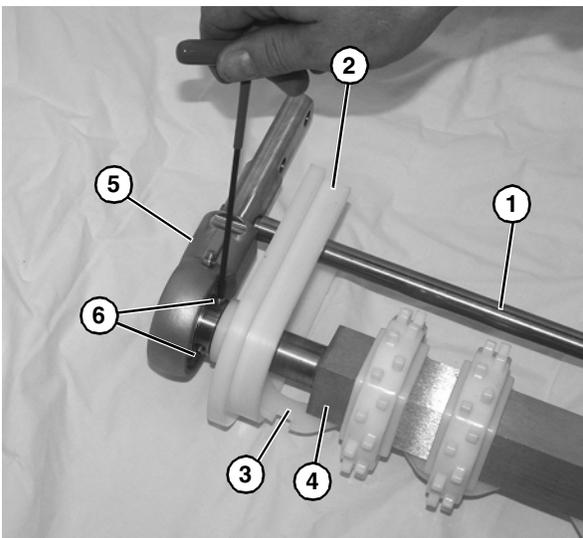
# Preventive Maintenance and Adjustment

- Slide the entire assembly onto the drive spindle. Be sure that at least three sprockets (**Figure 72, item 1**) are positioned such that they are on alternate opposing locations on alignment bar.



**Figure 72**

- Install pinch guard shaft (**Figure 73, item 1**) onto pinch guard (**Figure 73, item 2**).

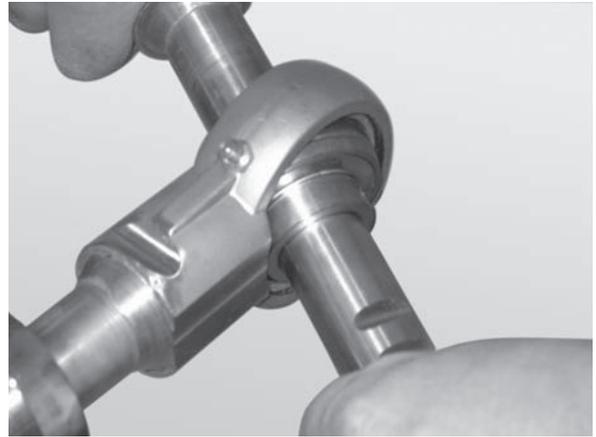


**Figure 73**

- Install pinch guard (**Figure 73, item 2**) onto alignment bar (**Figure 73, item 3**), and onto each side of drive spindle (**Figure 73, item 4**).
- Install bearing shaft assembly (**Figure 73, item 5**) onto rod (**Figure 73, item 1**) and drive spindle (**Figure 73, item 4**). Slide bearing shaft assembly onto the drive spindle on opposite side.
- Use a hex wrench to install the two set screws (**Figure 73, item 6**). Use a torque wrench to tighten them to 54 in•lbs (6 N•m). Check after 24 hours of conveyor use.
- Attach the bearing cover onto bearing shaft assembly (**Figure 73, item 5**).

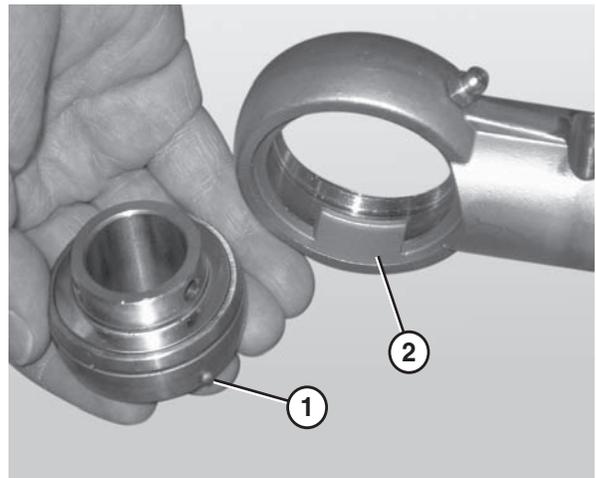
## Bearing Replacement

- Secure the bearing shaft in the take up blocks.
- Insert the rod end of a second bearing shaft through the bearing (**Figure 74**).



**Figure 74**

- Apply lateral pressure to the rod until the bearing comes loose.
- Remove the worn or damaged bearing (**Figure 75**).



**Figure 75**

- Replace the bearing.

### NOTE

When inserting the new bearing, make sure the anti-rotation notch (**Figure 75, item 1**) on the bearing lines up with the groove inside the housing (**Figure 75, item 2**).

## LPZ Knuckles

### Wearstrips and Belt Returns

Replace the wearstrips and belt returns if they become worn.

For wearstrip and belt return installation instructions:

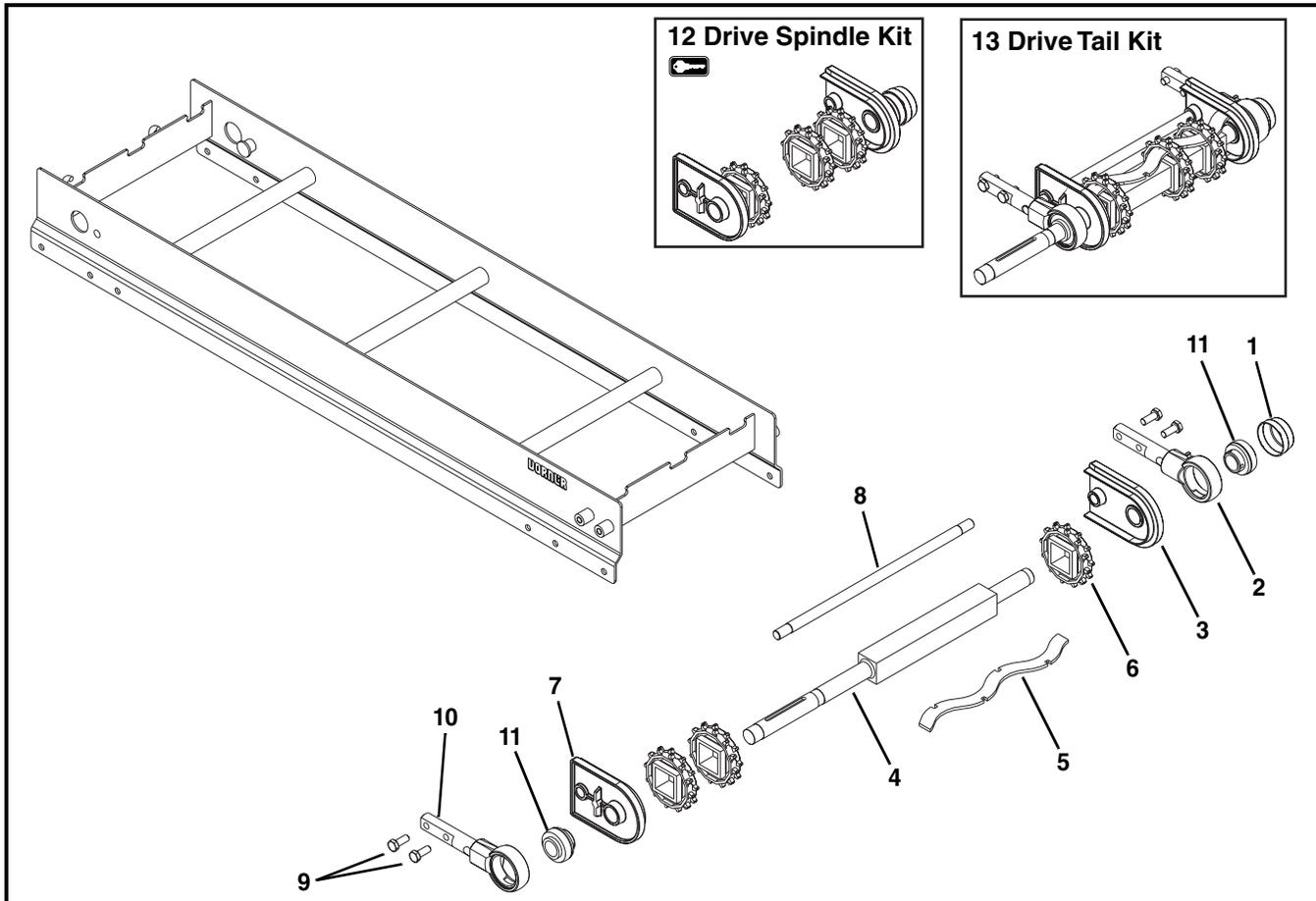
- For wearstrips, replace as needed, making sure wear strips are situated securely in the frame slots.
- For belt returns, Refer to “Belt Return Installation” on page 15.

# 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.

## Drive End Components



Item	Part Number	Description
1	807-1454	Bearing Cover
2	506365	Shaft Assembly with Bearing
3	506326- <u>WW</u>	Tracking Plate for Standard Belt
	506331- <u>WW</u>	Tracking Plate for Specialty Intralox Belt
4	5015 <u>WW</u>	Drive Spindle for Standard Belt
	5070 <u>WW</u>	Drive Spindle for Specialty Intralox Belt
	5295 <u>WW</u>	CE Drive Spindle for Standard Belt
	5294 <u>WW</u>	CE Drive Spindle for Specialty Intralox Belt

Item	Part Number	Description
5	5085 <u>WW</u>	Sprocket Alignment Bar for Standard 1.00" Pitch Belt
	5087 <u>WW</u>	Sprocket Alignment Bar for Specialty Intralox .60" Pitch Belt
	5088 <u>WW</u>	Sprocket Alignment Bar for Specialty Intralox 1.00" Pitch Belt
6	807-1444	Sprocket for Standard 1.00" Pitch Belt
	807-1446	Sprocket for Specialty Intralox .60" Pitch Belt
	807-1445	Sprocket for Specialty Intralox 1.00" Pitch Belt

# Service Parts

Item	Part Number	Description
7	506330- <u>WW</u>	Drive Side Tracking Plate for Standard Belt when Conveyor is ordered with a Dorner Gearmotor Mounting Package
	506326- <u>WW</u>	Drive Side Tracking Plate for Standard Belt when Conveyor is ordered without a Dorner Gearmotor Mounting Package
	506333- <u>WW</u>	Drive Side Tracking Plate for Specialty Intralox Belt when Conveyor is ordered with a Dorner Gearmotor Mounting Package
	506331- <u>WW</u>	Drive Side Tracking Plate for Specialty Intralox Belt when Conveyor is ordered without a Dorner Gearmotor Mounting Package
8	506358- <u>WW</u>	Pinch Guard Shaft
9	961025MSS	Hex Head Cap Screw M10-1.50 x 25mm
10*	506365	Shaft Assembly with Bearing
11	802-162	Bearing
12	74DD25X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1, 3, 6, 7 and 11)
	74DD11X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1, 3, 6, 7 and 11)
	74DD16X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1, 3, 6, 7 and 11)
	74DC25X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1, 3, 6, 7 and 11)
	74DC11X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1, 3, 6, 7 and 11)
	74DC16X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1, 3, 6, 7 and 11)

Item	Part Number	Description
13**	74DDCT25X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1 through 10)
	74DDCT11X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1 through 10)
	74DDCT16X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1 through 10)
	74DDDT25X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1 through 10)
	74DDDT11X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1 through 10)
	74DDDT16X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1 through 10)
<u>WW</u> = Conveyor width ref: 06 - 60 in 02 increments		
* When the conveyor is ordered with a Dorner gearmotor mounting package the shaft assembly is replaced with a gearmotor mounting bracket.		
** Drive Tail Kits are not available for CE conveyors.		

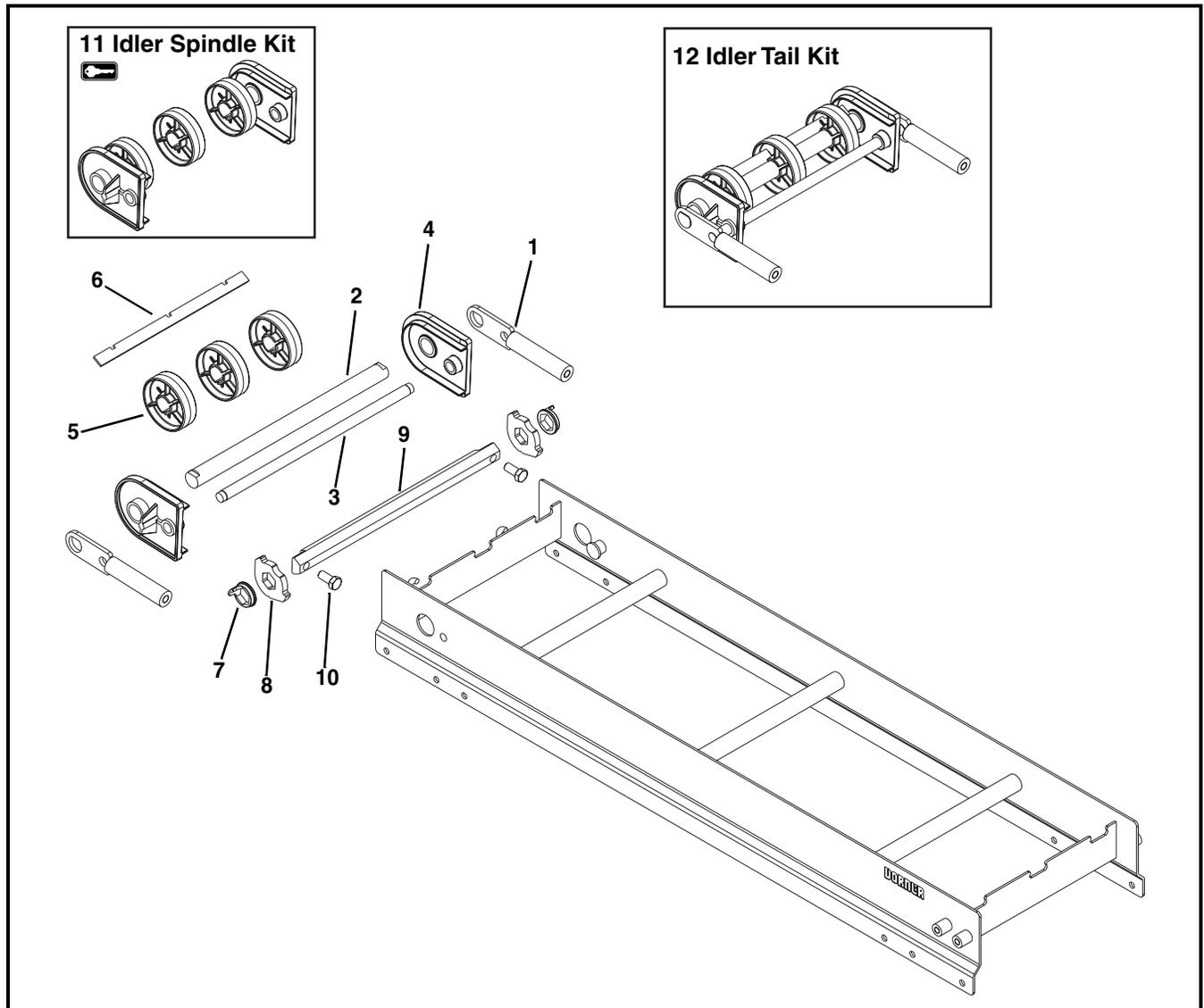
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# Service Parts

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Sprocket Quantity (Item 6)	
Width	Sprocket Quantity
6" (152 mm)	2
8" (203 mm)	2
10" (254 mm)	3
12" (305 mm)	3
14" (356 mm)	4
16" (406 mm)	4
18" (457 mm)	5
20" (508 mm)	5
22" (559 mm)	6
24" (610 mm)	6
26" (660 mm)	7
28" (711 mm)	7
30" (762 mm)	8
32" (813 mm)	8
34" (864 mm)	9
36" (914 mm)	9
38" (965 mm)	10
40" (1016 mm)	10
42" (1067 mm)	11
44" (1118 mm)	11
46" (1168 mm)	12
48" (1219 mm)	12
50" (1270 mm)	13
52" (1321 mm)	13
54" (1372 mm)	14
56" (1422 mm)	14
58" (1473 mm)	15
60" (1524 mm)	15

## Tension End Components



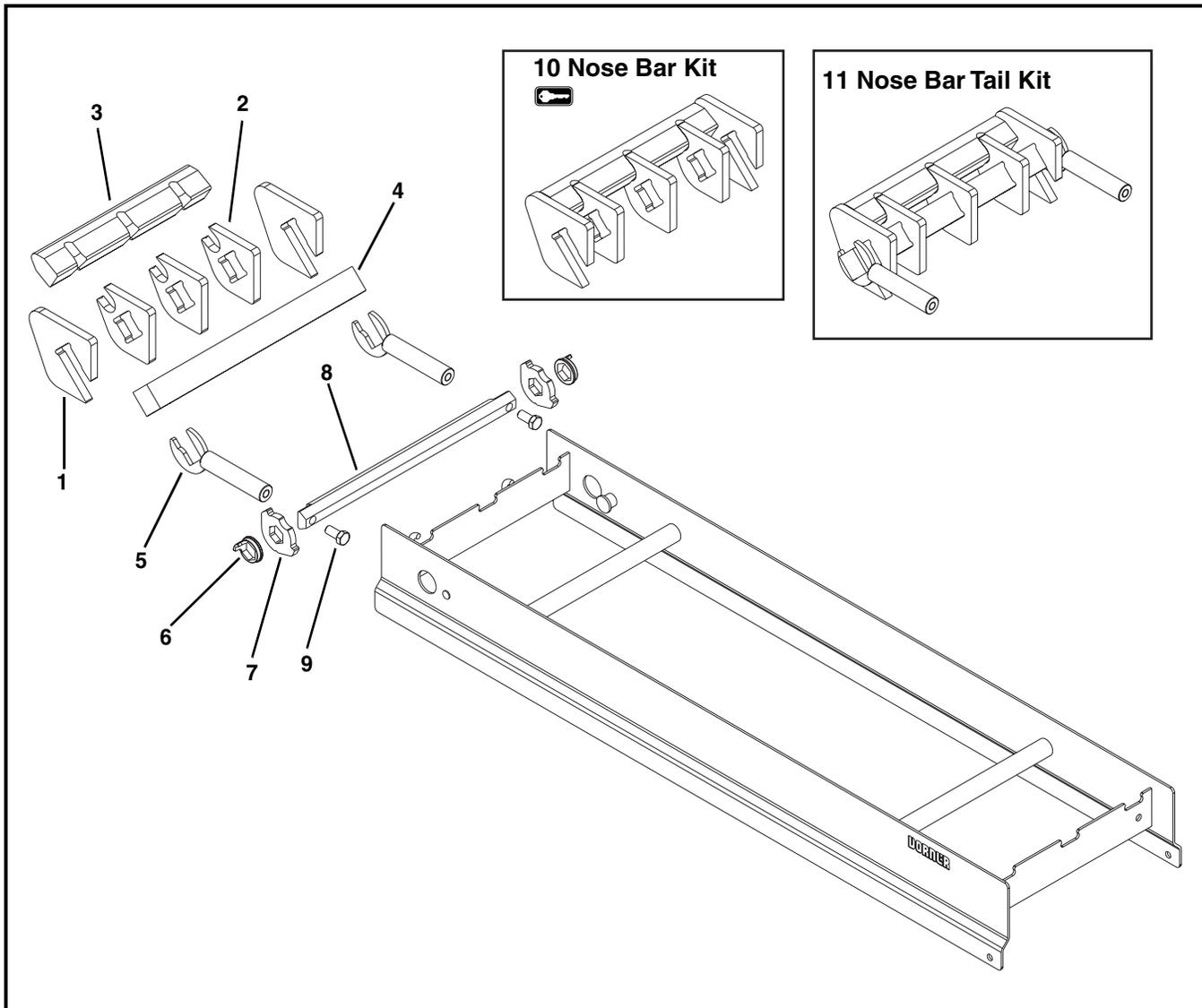
Item	Part Number	Description
1	506801	Shaft Assembly
2	506397- <u>WW</u>	Idler Shaft
3	506396- <u>WW</u>	Pinch Guard Shaft
4	506327- <u>WW</u>	Tracking Plate for Standard Belt
	506332- <u>WW</u>	Tracking Plate for Specialty Intralox Belt
5	506297	Idler Puck
6	506313- <u>WW</u>	Alignment Bar for Standard Belt
	506314- <u>WW</u>	Alignment Bar for Specialty Intralox Belt

Item	Part Number	Description
7	514387	Tip Up Sleeve
8	506356	Stop Key
9	506328- <u>WW</u>	Hex Bar
10	961225MSS	Hex Head Cap Screw M12-1.75 x 25mm
11	74IX- <u>WW</u>	Idler Spindle Tail Kit for Standard Belt (Includes Items 4 and 5)
	74ISX- <u>WW</u>	Idler Spindle Tail Kit for Specialty Intralox Belt (Includes Items 4 and 5)
12	74ITX- <u>WW</u>	Idler Tail Kit for Standard Belt (Includes Items 1 through 6)
	74ITSX- <u>WW</u>	Idler Tail Kit for Specialty Intralox Belt (Includes Items 1 through 6)

WW = Conveyor width ref: 06 - 60 in 02 increments

# Service Parts

## Nose Bar Tension End

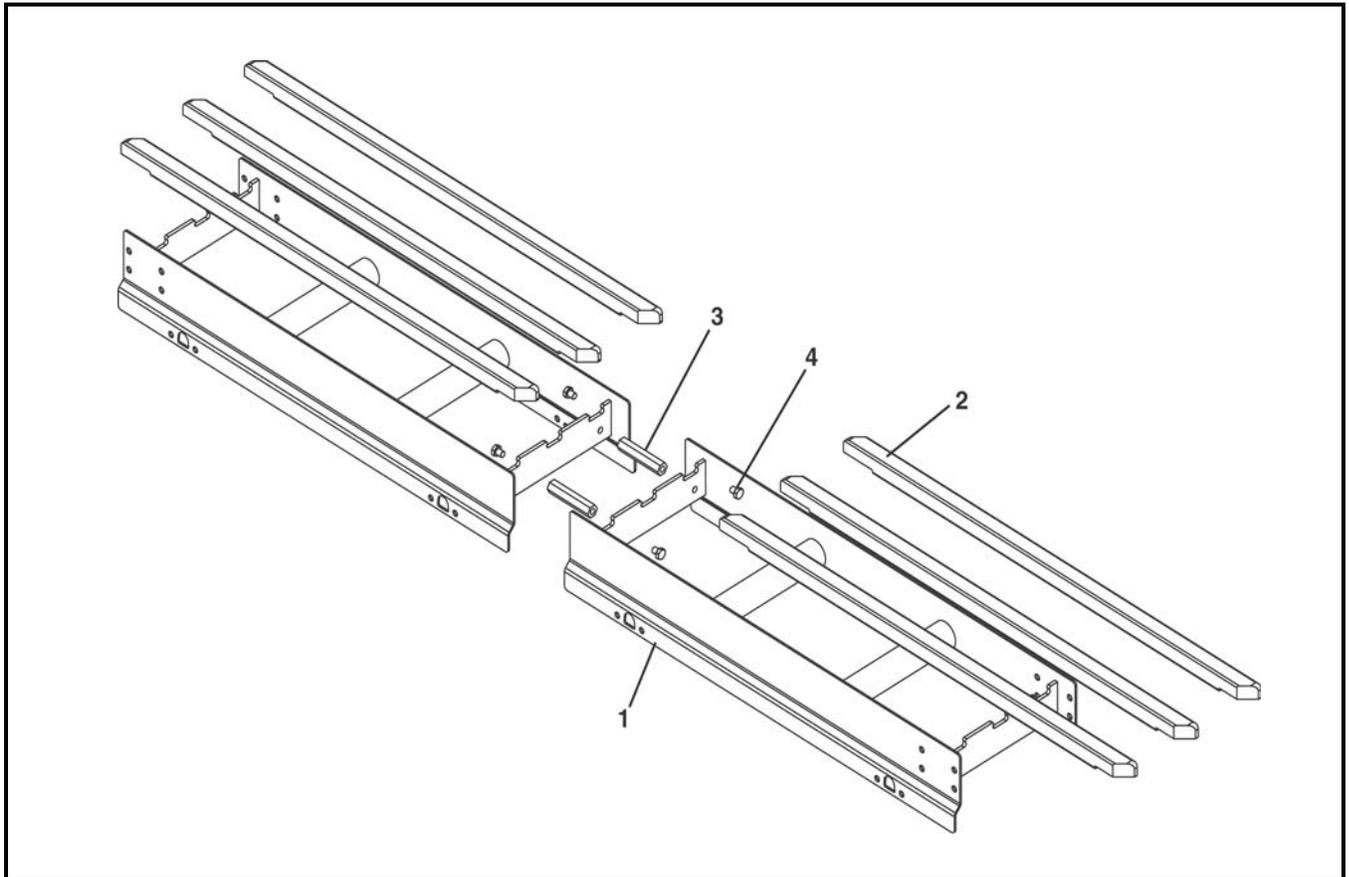


Item	Part Number	Description
1	500490	Nose Bar Tracking Puck
2	500278	Nose Bar Puck
3	5056WW	.5" Pitch Nose Bar Wear Strip
	5058WW	1" Pitch Nose Bar Wear Strip
4	5037WW	Nose Bar Transfer Post for Standard Belt
	5076WW	Nose Bar Transfer Post for Specialty Intralox Belt
5	506363	Nose Bar Idler Shaft
6	514387	Tip Up Sleeve
7	506356	Stop Key
8	506328-WW	Hex Bar
9	961225MSS	Hex Head Cap Screw M12-1.75 x 25mm

Item	Part Number	Description
10	74NB5X-WW	.5" Nose Bar Kit (Includes Items 1 through 3)
	74NB1X-WW	1" Nose Bar Kit (Includes Items 1 through 3)
11	74NBT5X-WW	.5" Nose Bar Tail Kit, for Standard Belt (Includes Items 1 through 5)
	74NBT1X-WW	1" Nose Bar Tail Kit, for Standard Belt (Includes Items 1 through 5)
	74NBT5SX-WW	.5" Nose Bar Tail Kit, for Specialty Intralox Belt (Includes Items 1 through 5)
	74NBT1SX-WW	1" Nose Bar Tail Kit, for Specialty Intralox Belt (Includes Items 1 through 5)

WW = Conveyor width ref: 06 - 60 in 02 increments

## Conveyor Frame and Extension



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	501800-LLL	Straight Wear Strip
3	500193	Hex Post Connector
4	961016MSS	Hex Head Cap Screw M10-1.5x16mm

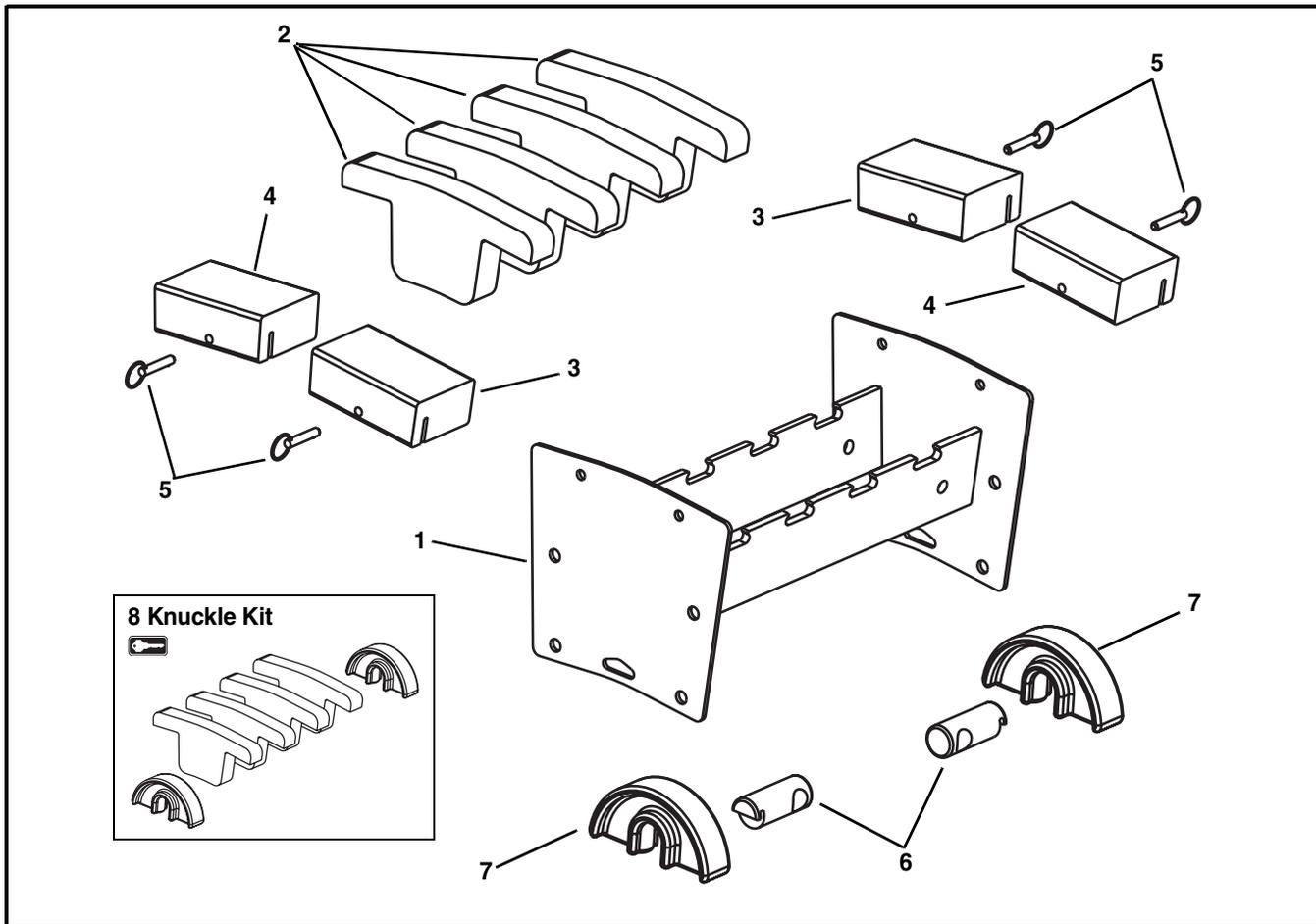
LLL = Conveyor length ref: 036 - 999 in 001 increments  
 WW = Conveyor width ref: 06 - 60 in 02 increments

		Wear Strip Quantity (Item 2)							
		Conveyor Length (LLL)							
		036-132	133-252	253-372	373-492	493-612	613-732	733-852	853-999
Conveyor Width (WW)	06	2	4	6	8	10	12	14	16
	08	2	4	6	8	10	12	14	16
	10	3	6	9	12	15	18	21	24
	12	3	6	9	12	15	18	21	24
	14	3	6	9	12	15	18	21	24
	16	4	8	12	16	20	24	28	32
	18	4	8	12	16	20	24	28	32
	20	5	10	15	20	25	30	35	40
	22	5	10	15	20	25	30	35	40
	24	5	10	15	20	25	30	35	40

		Wear Strip Quantity (Item 2)							
		Conveyor Length (LLL)							
		036-132	133-252	253-372	373-492	493-612	613-732	733-852	853-999
Conveyor Width (WW)	26	6	12	18	24	30	36	42	48
	28	6	12	18	24	30	36	42	48
	30	6	12	18	24	30	36	42	48
	32	7	14	21	28	35	42	49	56
	34	7	14	21	28	35	42	49	56
	36	8	16	24	32	40	48	56	64
	38	8	16	24	32	40	48	56	64
	40	8	16	24	32	40	48	56	64
	42	9	18	27	36	45	54	63	72
	44	9	18	27	36	45	54	63	72
	46	9	18	27	36	45	54	63	72
	48	10	20	30	40	50	60	70	80
	50	10	20	30	40	50	60	70	80
	52	11	22	33	44	55	66	77	88
	54	11	22	33	44	55	66	77	88
56	11	22	33	44	55	66	77	88	
58	12	24	36	48	60	72	84	96	
60	12	24	36	48	60	72	84	96	

# Service Parts

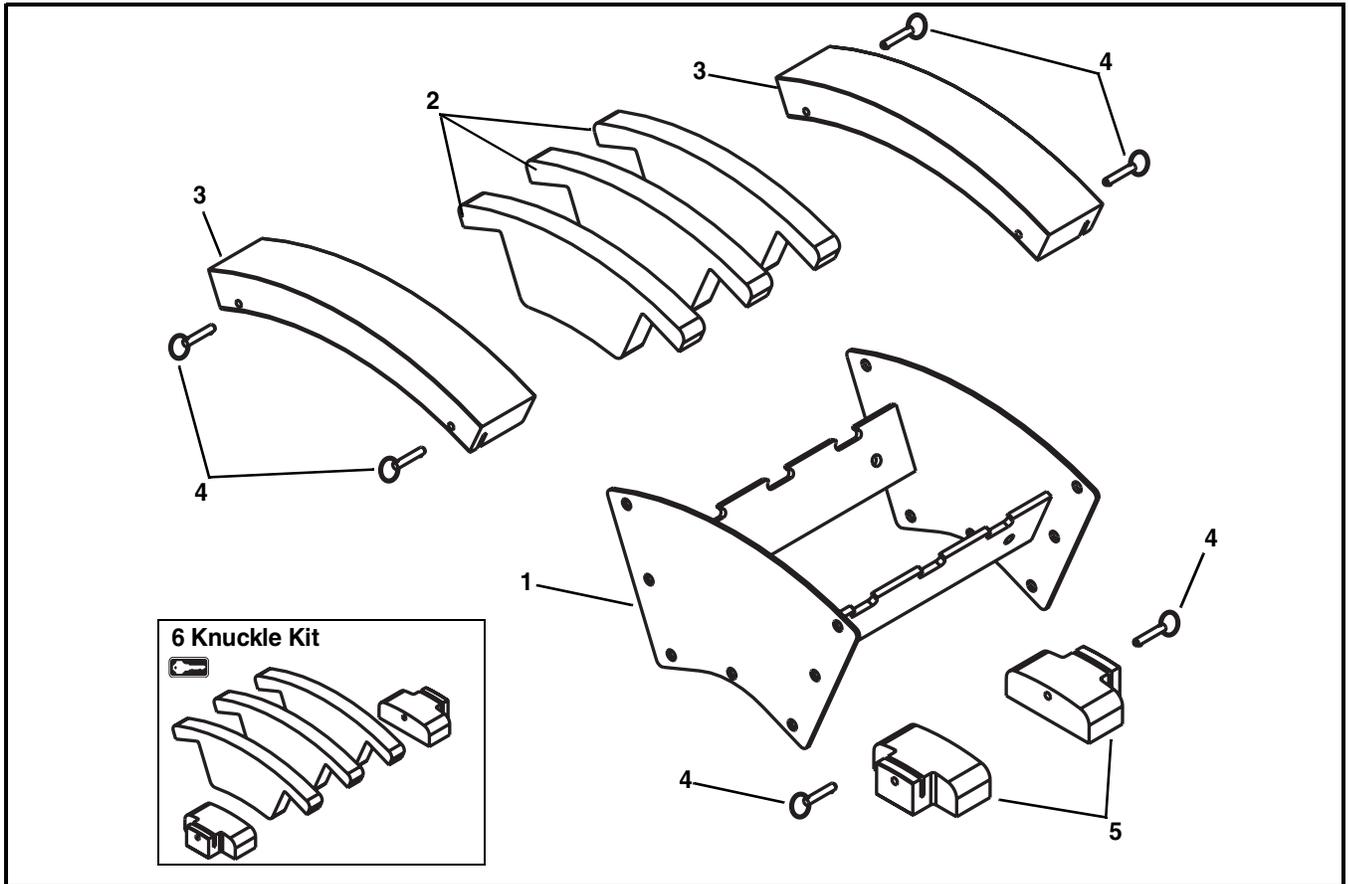
## Upper Knuckle for 5° - 15°



Item	Part Number	Description
1	5224WW	Frame Assembly for 5° Knuckle
	5225WW	Frame Assembly for 10° Knuckle
	5226WW	Frame Assembly for 15° Knuckle
2	501695-AA	Wear Strips for 5° - 15° Knuckle
3	501893-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Right Hand 6"-16" wide
	501685-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Right Hand 18"-24" wide
	501883-AA	3" Hold Down Guide for 5° - 15° Knuckle Right Hand 6"-16" wide
	501684-AA	3" Hold Down Guide for 5° - 15° Knuckle Right Hand 18"-24" wide

Item	Part Number	Description
4	501699-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Left Hand 6"-16" wide
	501687-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Left Hand 18"-24" wide
	501698-AA	3" Hold Down Guide for 5° - 15° Knuckle Left Hand 6"-16" wide
	501686-AA	3" Hold Down Guide for 5° - 15° Knuckle Left Hand 18"-24" wide
5	807-1553	Pull Pin
6	500196	Return Shaft
7	500075	Return Shoe
8	74UKL-WW-AA	Upper Knuckle Kit (Includes items 2 and 7)
WW = Conveyor width ref: 06 - 24 in 02 increments		
AA = Angle 05, 10 or 15		

## Upper Knuckle for 30° - 60°

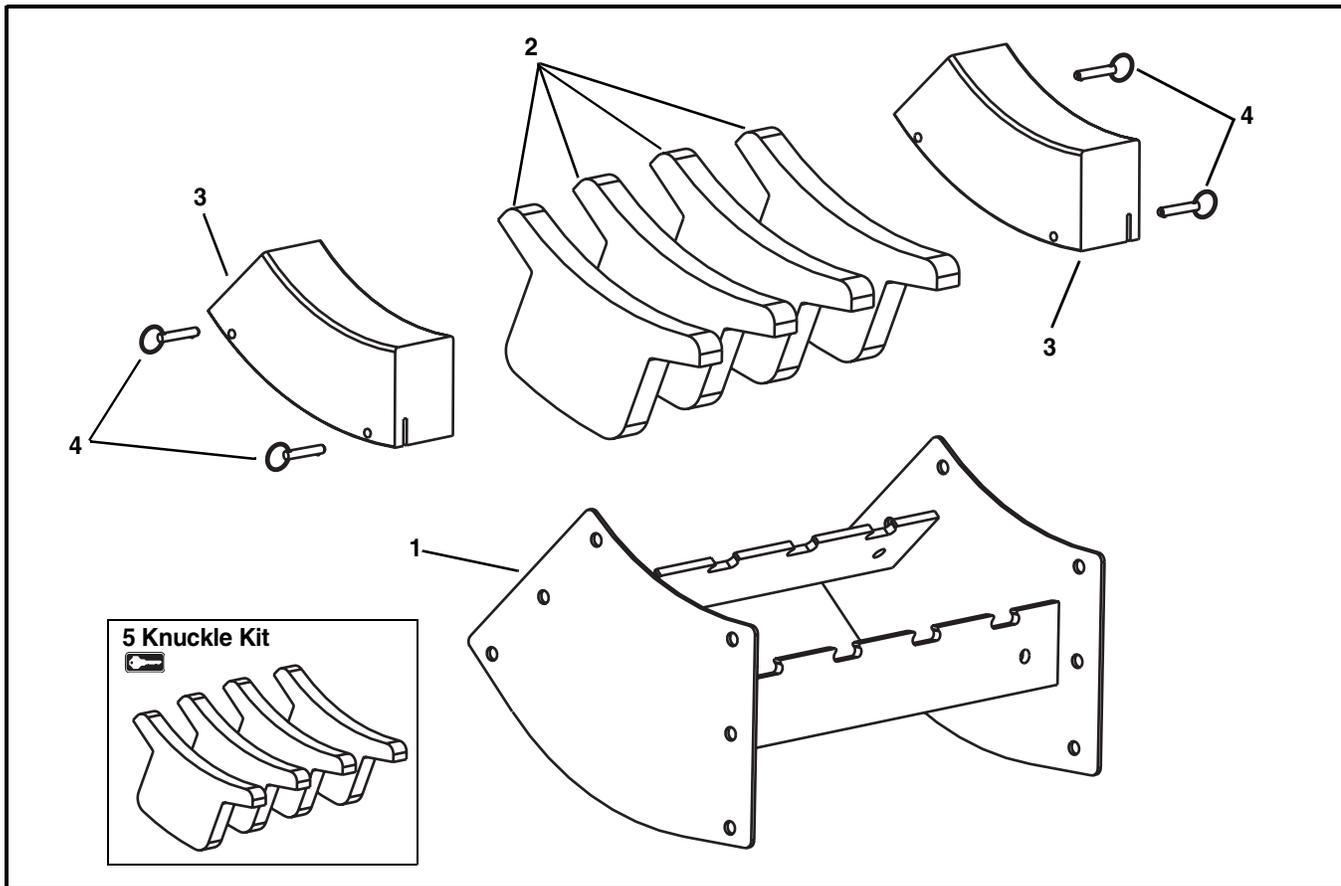


Item	Part Number	Description
1	5227WW	Frame Assembly for 30° Knuckle
	5228WW	Frame Assembly for 45° Knuckle
	5229WW	Frame Assembly for 60° Knuckle
2	501693-AA	Wear Strips for 30° - 60° Knuckle
3	501697-AA	1.5" Hold Down Guide for 30° - 60° Knuckle
	501879-AA	3" Hold Down Guide for 30° - 60° Knuckle

Item	Part Number	Description
4	807-1553	Pull Pin
5	501683	Return Guide
6	74UKH-WW-AA	Upper Knuckle Kit (Includes items 2 and 5)
WW = Conveyor width ref: 06 - 24 in 02 increments		
AA = Angle 30, 45 or 60		

# Service Parts

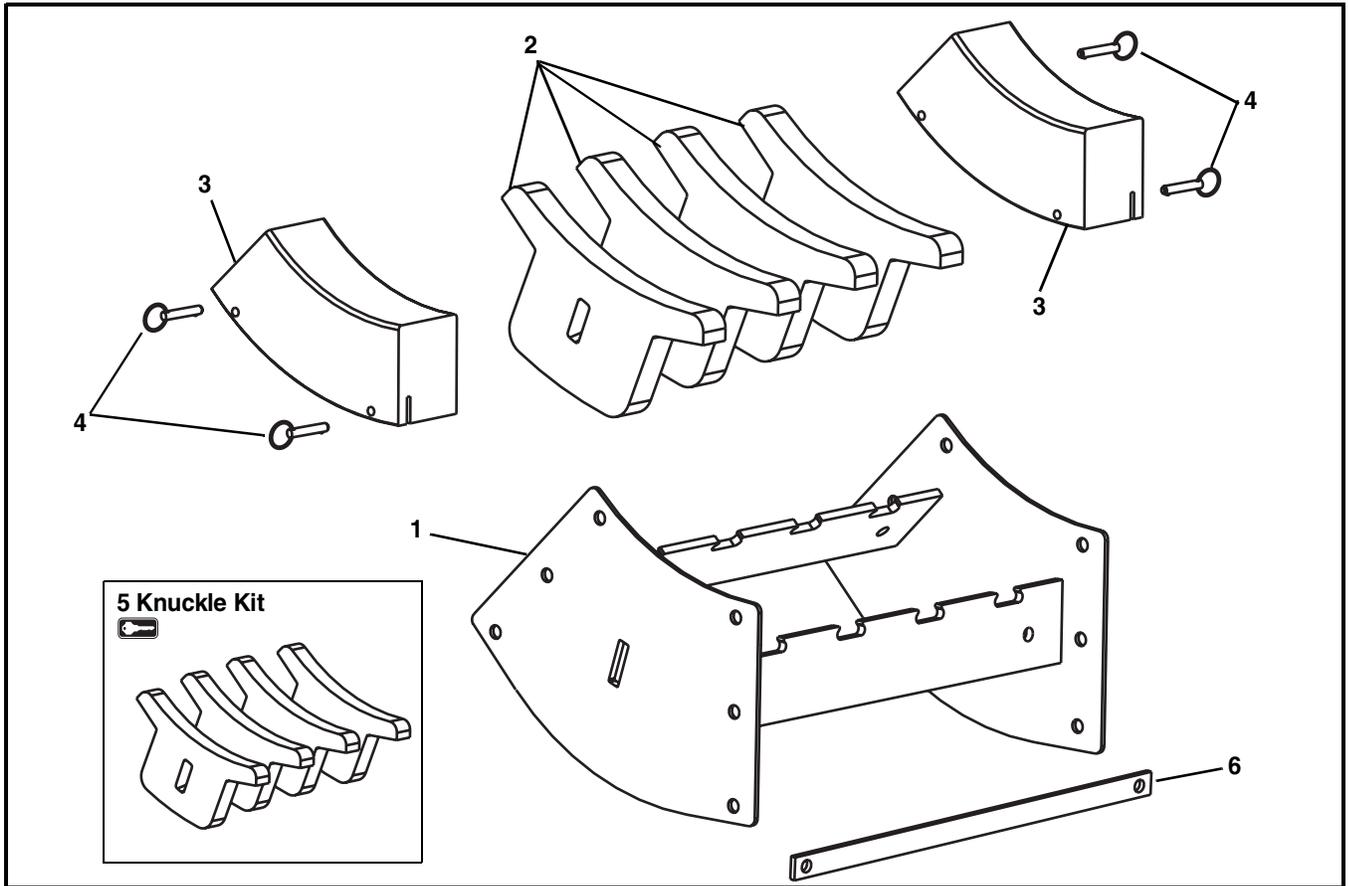
## Lower Knuckle for 5° - 15°



Item	Part Number	Description
1	5218 <u>WW</u>	Frame Assembly for 5° Knuckle
	5219 <u>WW</u>	Frame Assembly for 10° Knuckle
	5220 <u>WW</u>	Frame Assembly for 15° Knuckle
2	501694- <u>AA</u>	Wear Strips for 5° - 15° Knuckle
3	501692- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle 6"-16" wide
	501974- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle 18"-24" wide
	501878- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle 6"-16" wide
	501973- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle 18"-24" wide

Item	Part Number	Description
4	807-1553	Pull Pin
5	74LKL- <u>WW</u> - <u>AA</u>	Lower Knuckle Kit (Includes item 2)
<u>WW</u> = Conveyor width ref: 06 - 24 in 02 increments		
<u>AA</u> = Angle 05, 10 or 15		

## Lower Knuckle for 30° - 60°

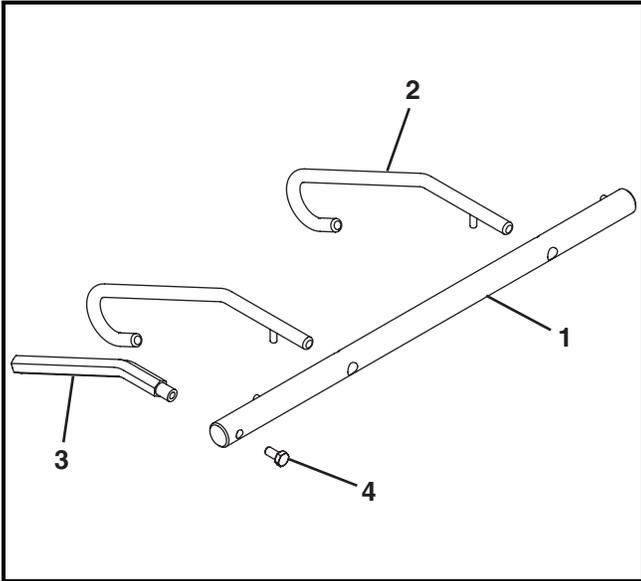


Item	Part Number	Description
1	5221 <del>WW</del>	Frame Assembly for 30° Knuckle
	5222 <del>WW</del>	Frame Assembly for 45° Knuckle
	5223 <del>WW</del>	Frame Assembly for 60° Knuckle
2	501691- <del>AA</del>	Wear Strips for 30° - 60° Knuckle
	501692- <del>AA</del>	1.5" Hold Down Guide for 30° - 60° Knuckle
3	501878- <del>AA</del>	3" Hold Down Guide for 30° - 60° Knuckle

Item	Part Number	Description
4	807-1553	Pull Pin
5	74LKH- <del>WW-AA</del>	Lower Knuckle Kit (Includes item 2)
6	506254- <del>WW</del>	Wearstrip Retention Bar
<del>WW</del> = Conveyor width ref: 06 - 24 in 02 increments		
<del>AA</del> = Angle 30, 45 or 60		

# Service Parts

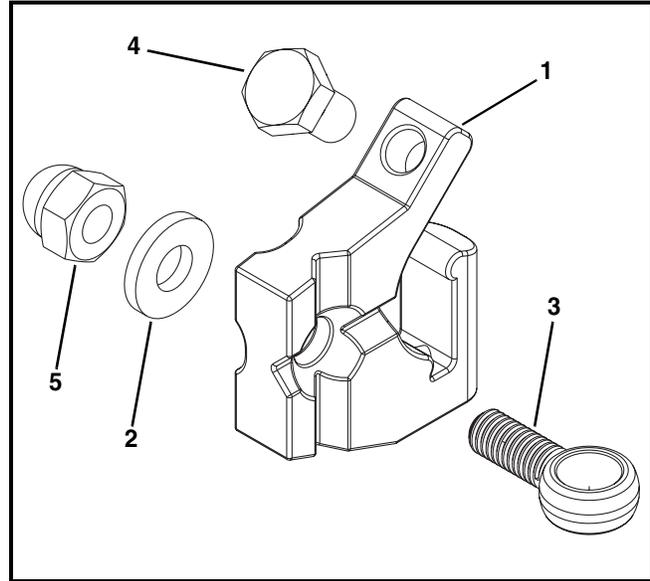
## Lifters



Item	Part Number	Description
1	5054 <u>WW</u>	Belt Lifter Shaft
2	501376	Belt Lifter
3	500491	Belt Lifter Handle
4	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

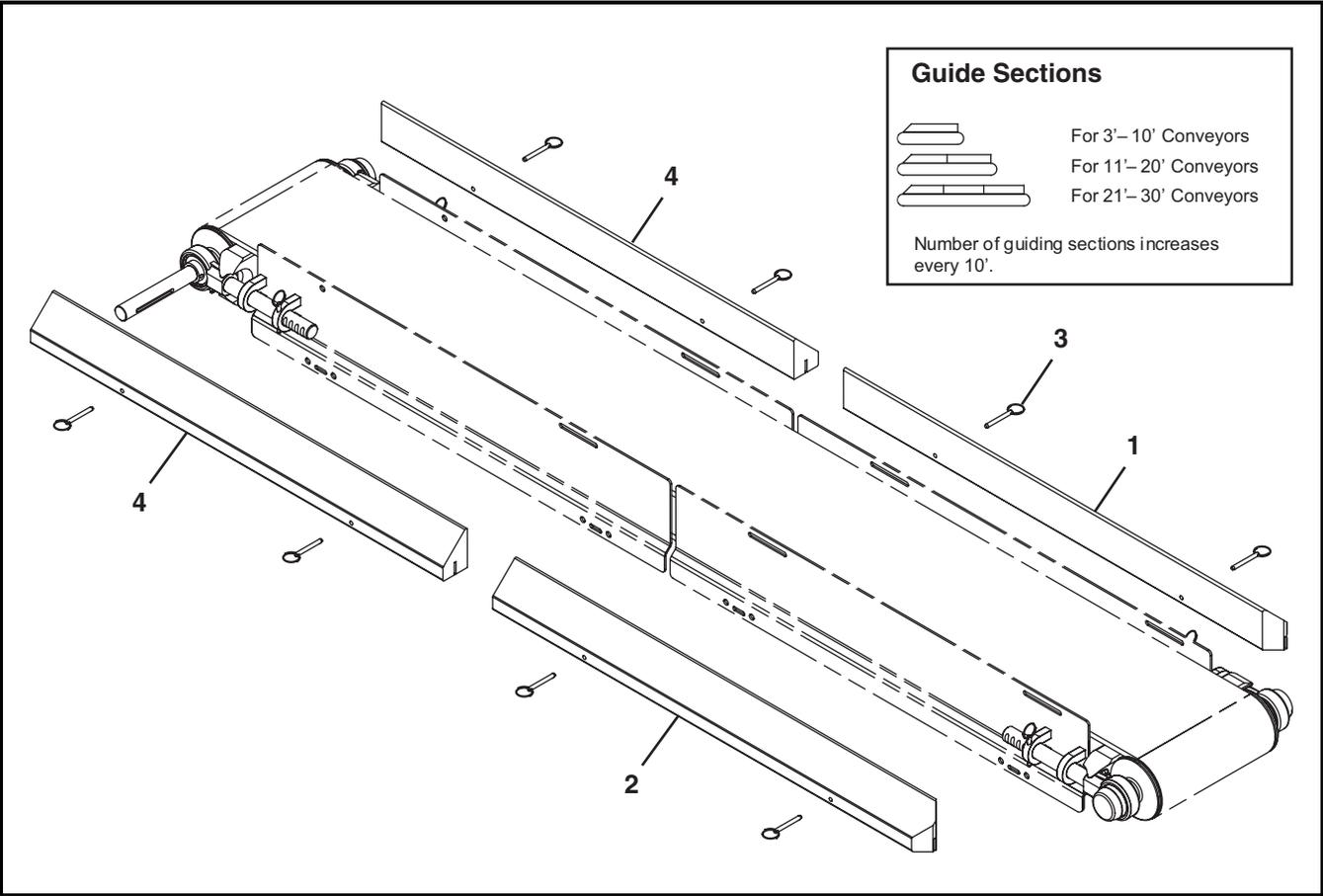
WW = Conveyor width ref: 06 - 60 in 02 increments

## Mounting Block



Item	Part Number	Description
1	509868	Mounting Block
2	807-1821	Washer
3	807-1994	Eyebolt, M10 x 1.50 mm
4	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
5	991008MSS	Hex Nut, M10 - 1.50 mm

## 3" (76 mm) High Sides

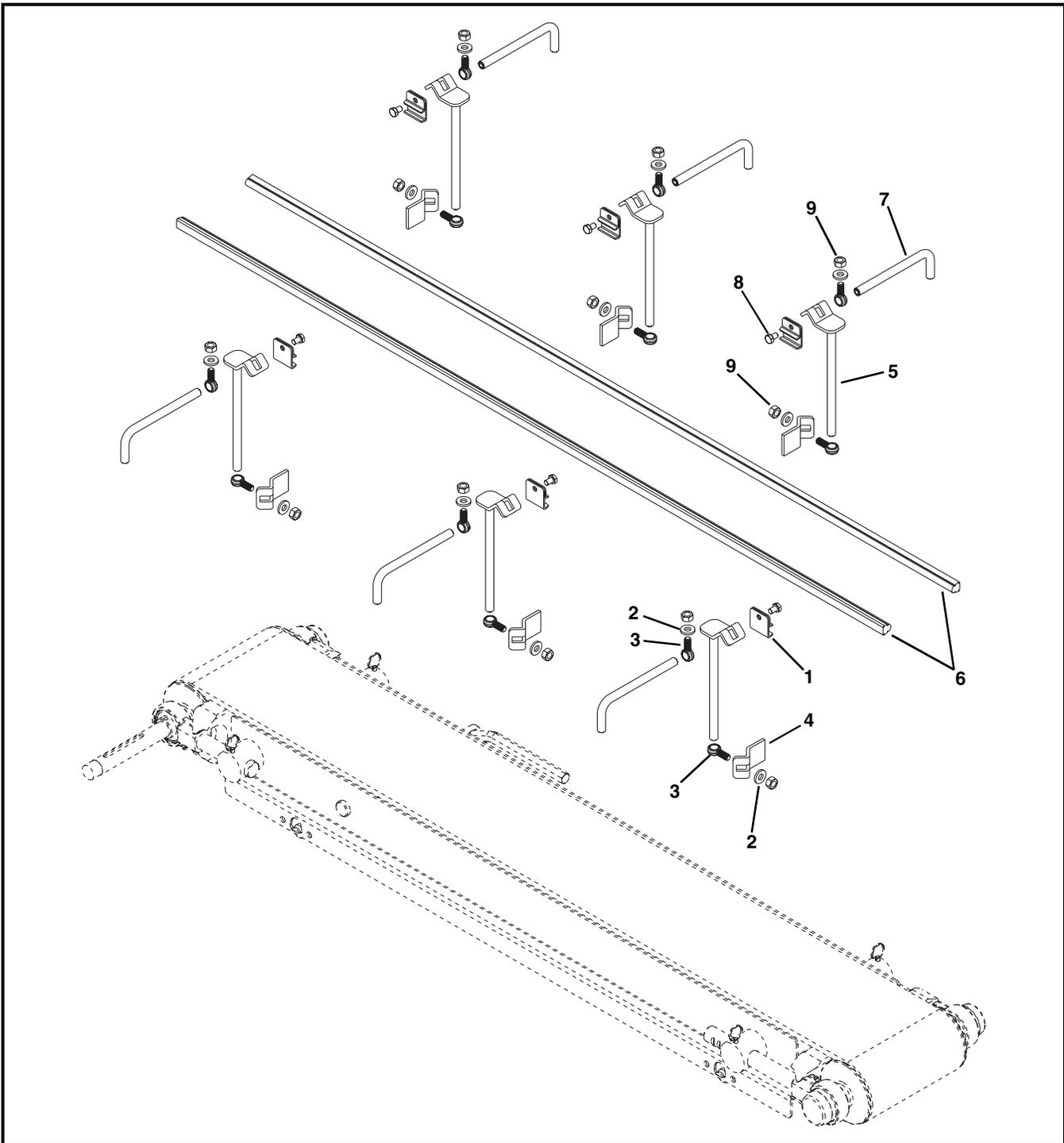


Item	Part Number	Description
1	503501- <u>LLLLL</u>	Right Hand High Side Guide
2	503601- <u>LLLLL</u>	Left Hand High Side Guide
3	807-1553	Pull Pin

Item	Part Number	Description
4	503401- <u>LLLLL</u>	Square End High Side Guide
<u>LLLLL</u> = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" <u>LLLLL</u> = 09525		

# Service Parts

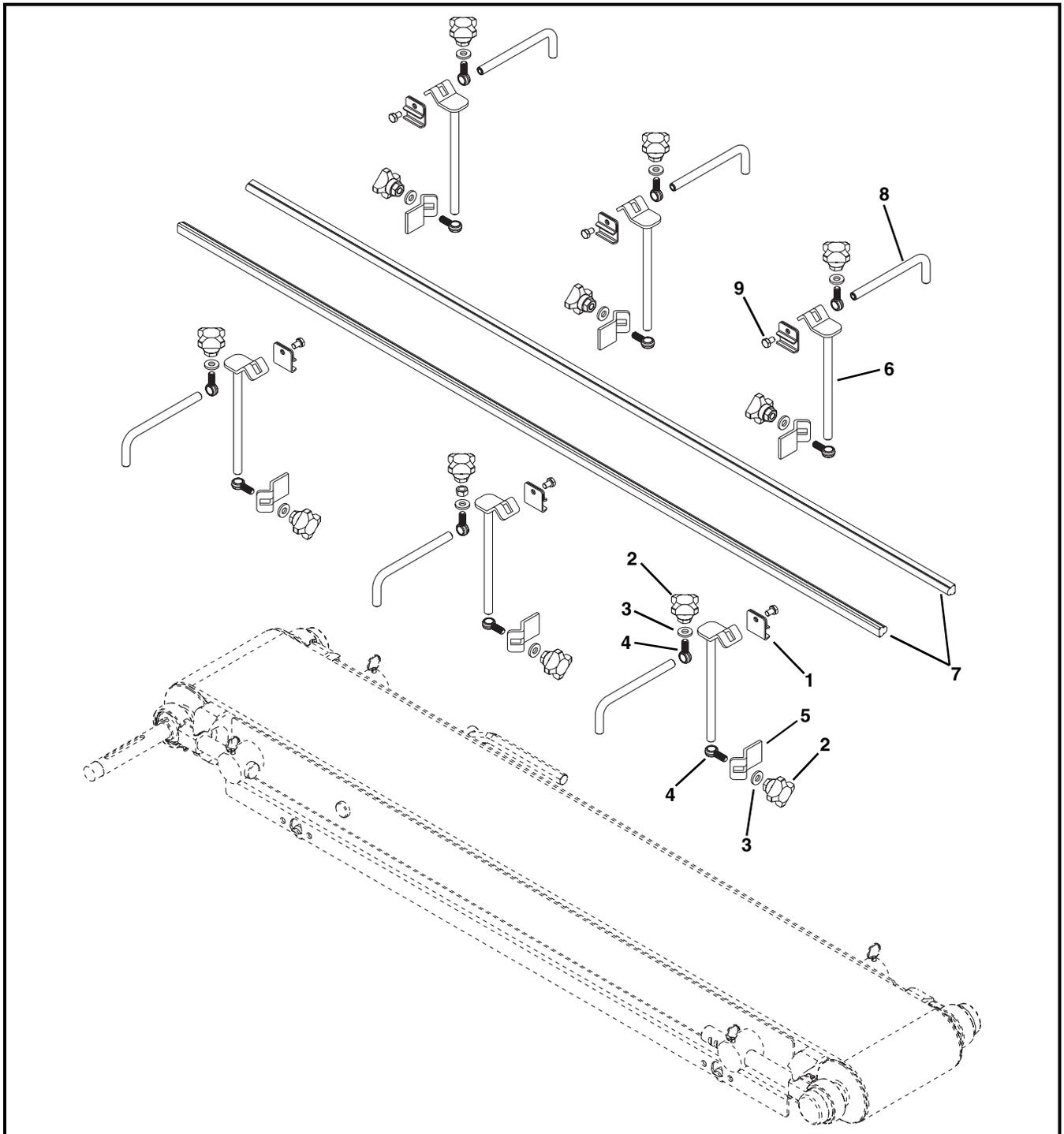
## Adjustable Guiding



Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1821	Washer
3	807-1994	Eye Bolt M10 x 1.50 mm
4	509875	Mounting Bracket
5	509876	Vertical Post Assembly
6	532167- <u>LLLLL</u>	Round Guide Rail

Item	Part Number	Description
7	532300	Guide Post
8	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
9	991001MSS	Hex Nut, M10 - 1.50 mm
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

## Tool-Less Adjustable Guiding

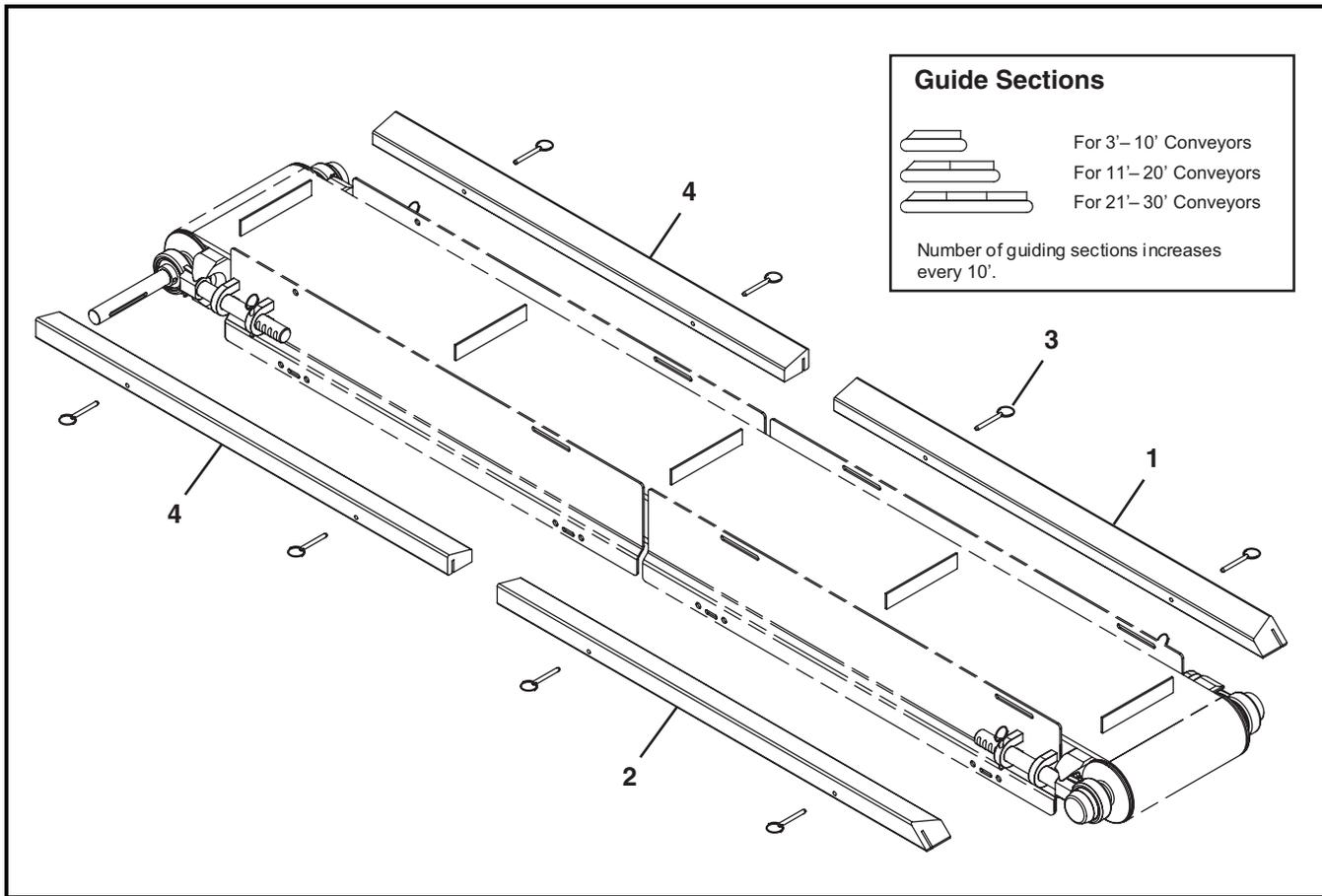


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1057	Handle
3	807-1821	Washer
4	807-1994	Eye Bolt M10 x 1.50 mm
5	509875	Mounting Bracket
6	509876	Vertical Post Assembly

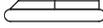
Item	Part Number	Description
7	532167-LLLLL	Round Guide Rail
8	532300	Guide Post
9	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

## Cleated 1" (25 mm) Guides



**Guide Sections**

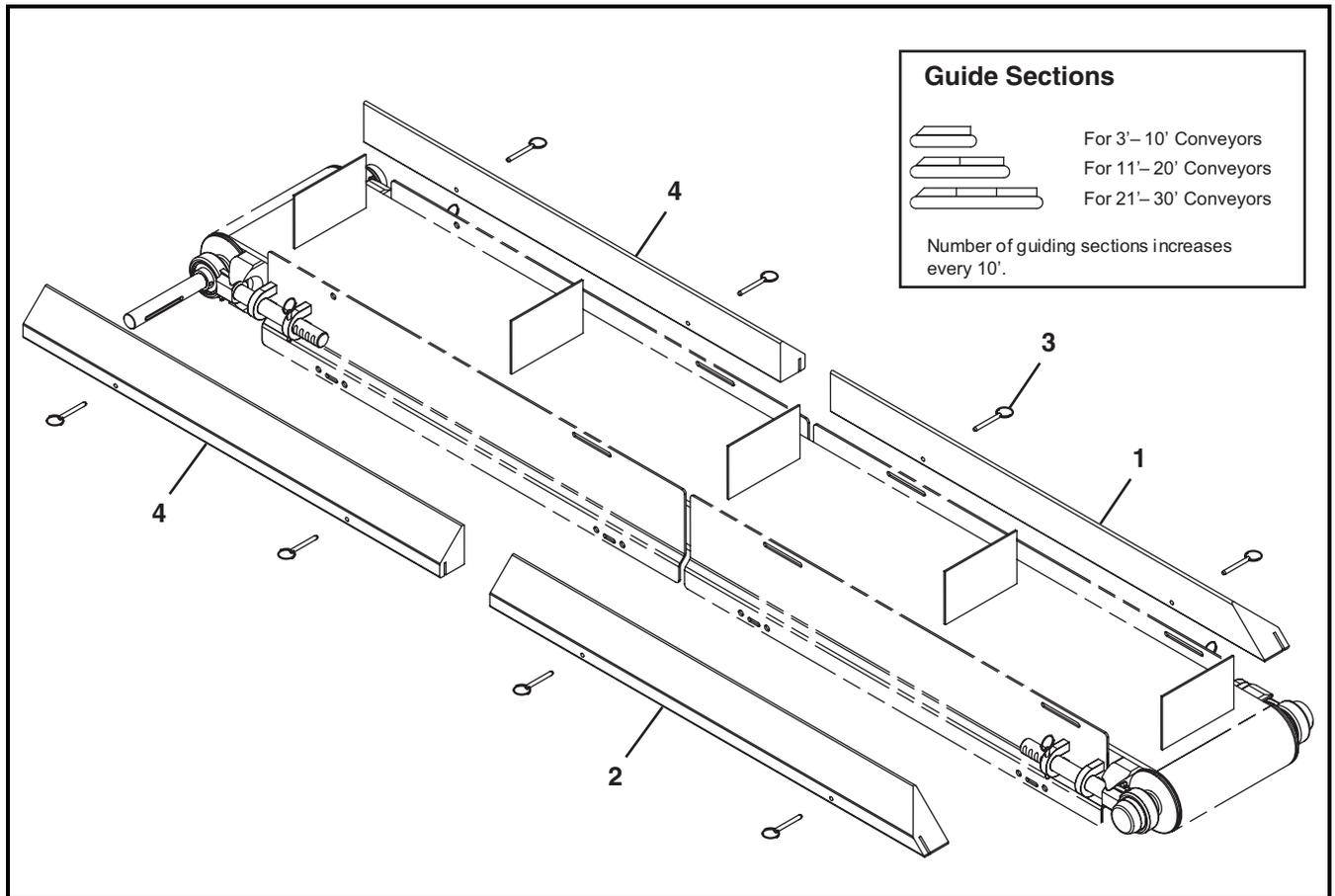
 For 3'- 10' Conveyors  
 For 11'- 20' Conveyors  
 For 21'- 30' Conveyors

Number of guiding sections increases every 10'.

Item	Part Number	Description
1	502401-LLLLL	1" Cleated Right Hand Guide (6" - 16" wide conveyors)
	502402-LLLLL	1" Cleated Right Hand Guide (18" - 24" wide conveyors)
2	502501-LLLLL	1" Cleated Left Hand Guide (6" - 16" wide conveyors)
	502502-LLLLL	1" Cleated Left Hand Guide (18" - 24" wide conveyors)

Item	Part Number	Description
3	807-1553	Pull Pin
4	502301-LLLLL	1" Cleated Guide Square End (6" - 16" wide conveyors)
	502302-LLLLL	1" Cleated Guide Square End (18" - 24" wide conveyors)
LLLLL = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

## Cleated 3" (76 mm) Guides

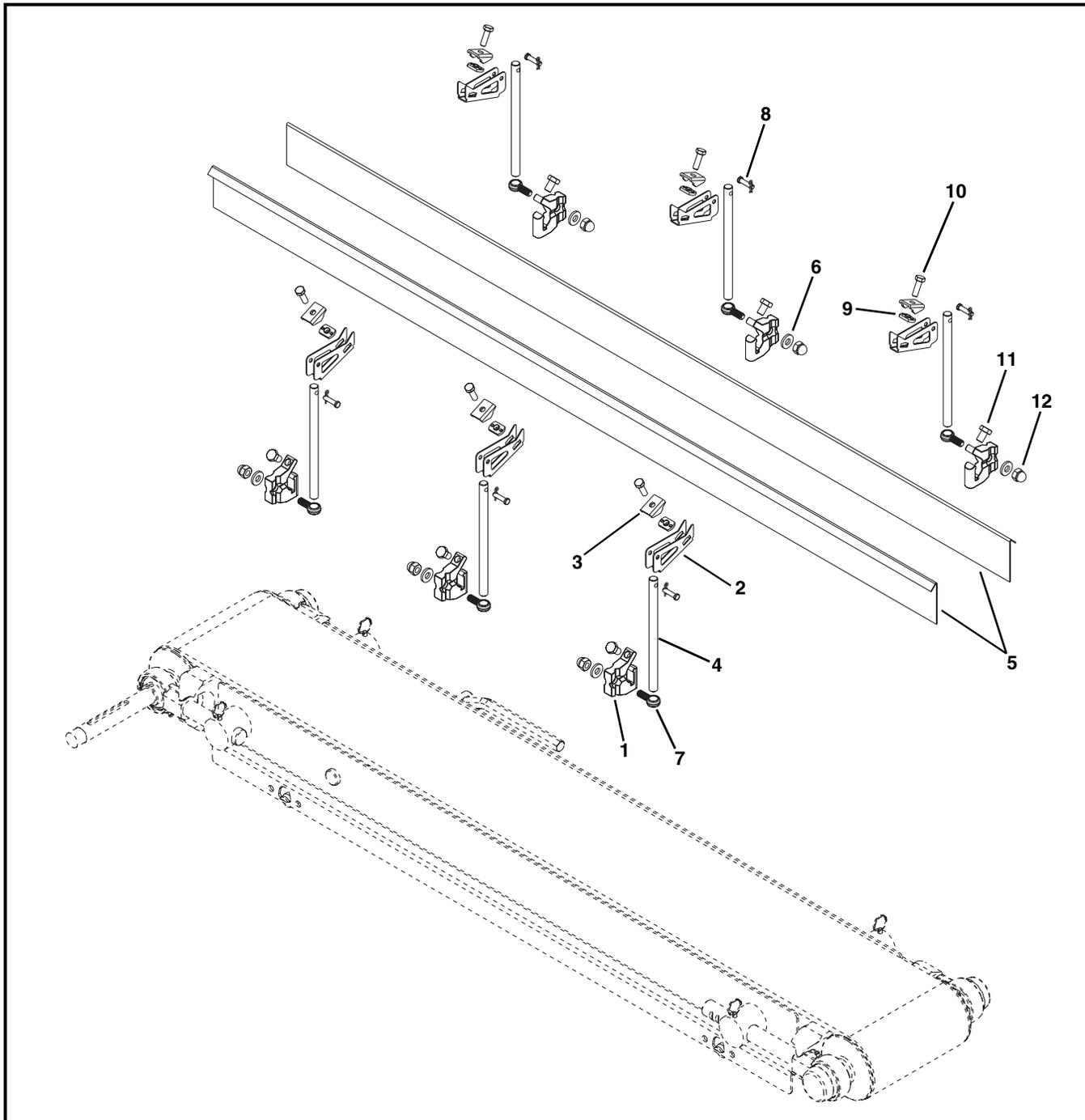


Item	Part Number	Description
1	502701-LLLLL	3" Cleated Right Hand Guide (6" - 16" wide conveyors)
	502702-LLLLL	3" Cleated Right Hand Guide (18" - 24" wide conveyors)
2	502801-LLLLL	3" Cleated Left Hand Guide (6" - 16" wide conveyors)
	502802-LLLLL	3" Cleated Left Hand Guide (18" - 24" wide conveyors)

Item	Part Number	Description
3	807-1553	Pull Pin
4	502601-LLLLL	3" Cleated Guide Square End (6" - 16" wide conveyors)
	502602-LLLLL	3" Cleated Guide Square End (18" - 24" wide conveyors)
LLLLL = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

# Service Parts

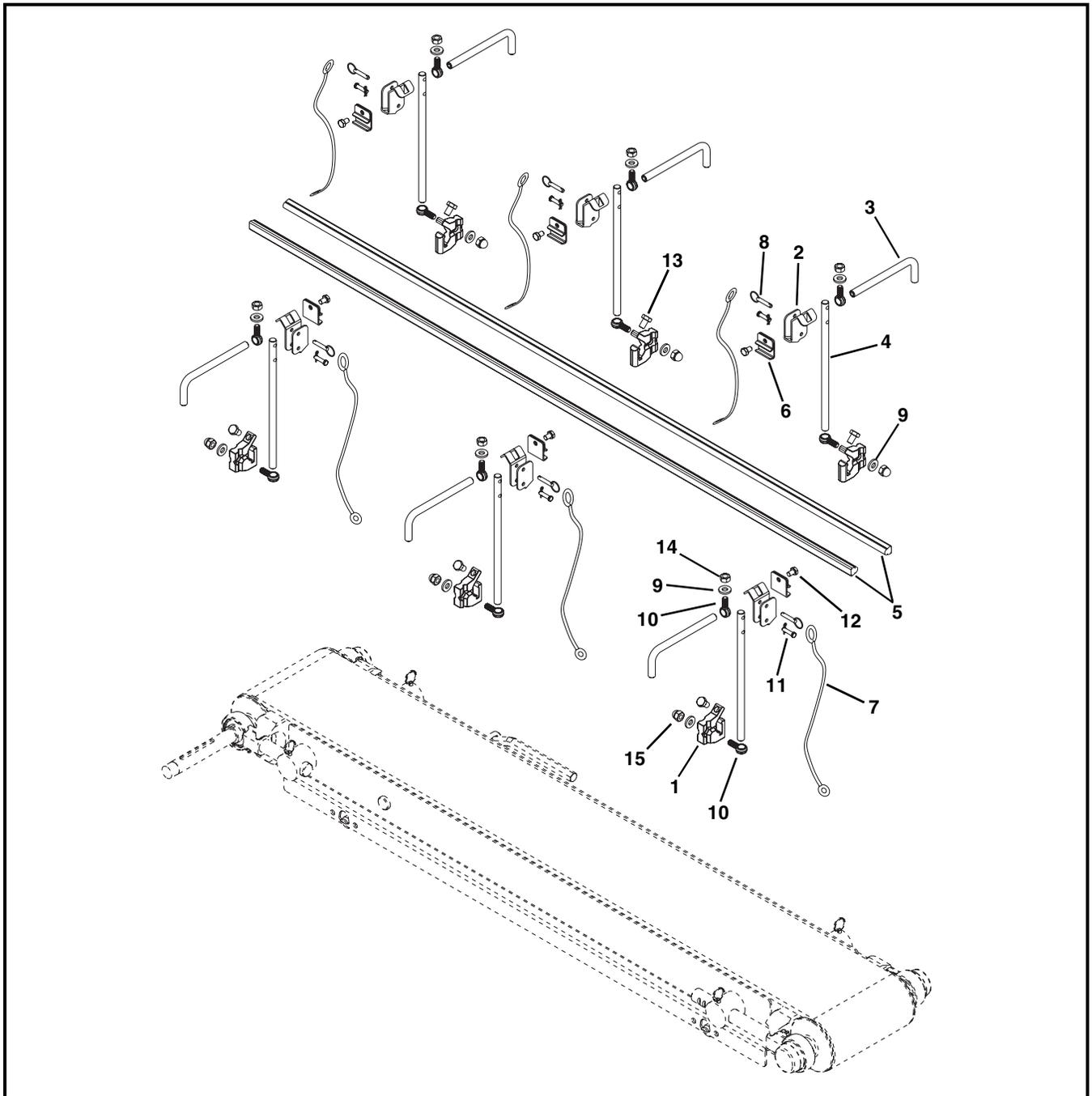
## Hinged Guides



Item	Part Number	Description
1	509868	Mounting Block
2	509870	Pivot Guide Mounting Bracket
3	509871	Guide Clamp Bracket
4	509872-PH-0800	Mounting Guide Shaft for 3" Guides
	509872-PH-1100	Mounting Guide Shaft for 6" Guides
5	532172-LLLLL	Guiding for 3" Guides
	509890-LLLLL	Guiding for 6" Guides
6	807-1821	Washer
7	807-1994	Eyebolt M10 x 1.50 mm

Item	Part Number	Description
8	807-1995	Cotter Pin
9	807-1075SS	Weld Nut, M8 x 1.25 mm
10	960825MSS	Hex Head Cap Screw, M8 - 1.25 x 25 mm
11	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
12	991008MSS	Hex Nut, M10 - 1.50 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

## Adjustable Hinged Guides



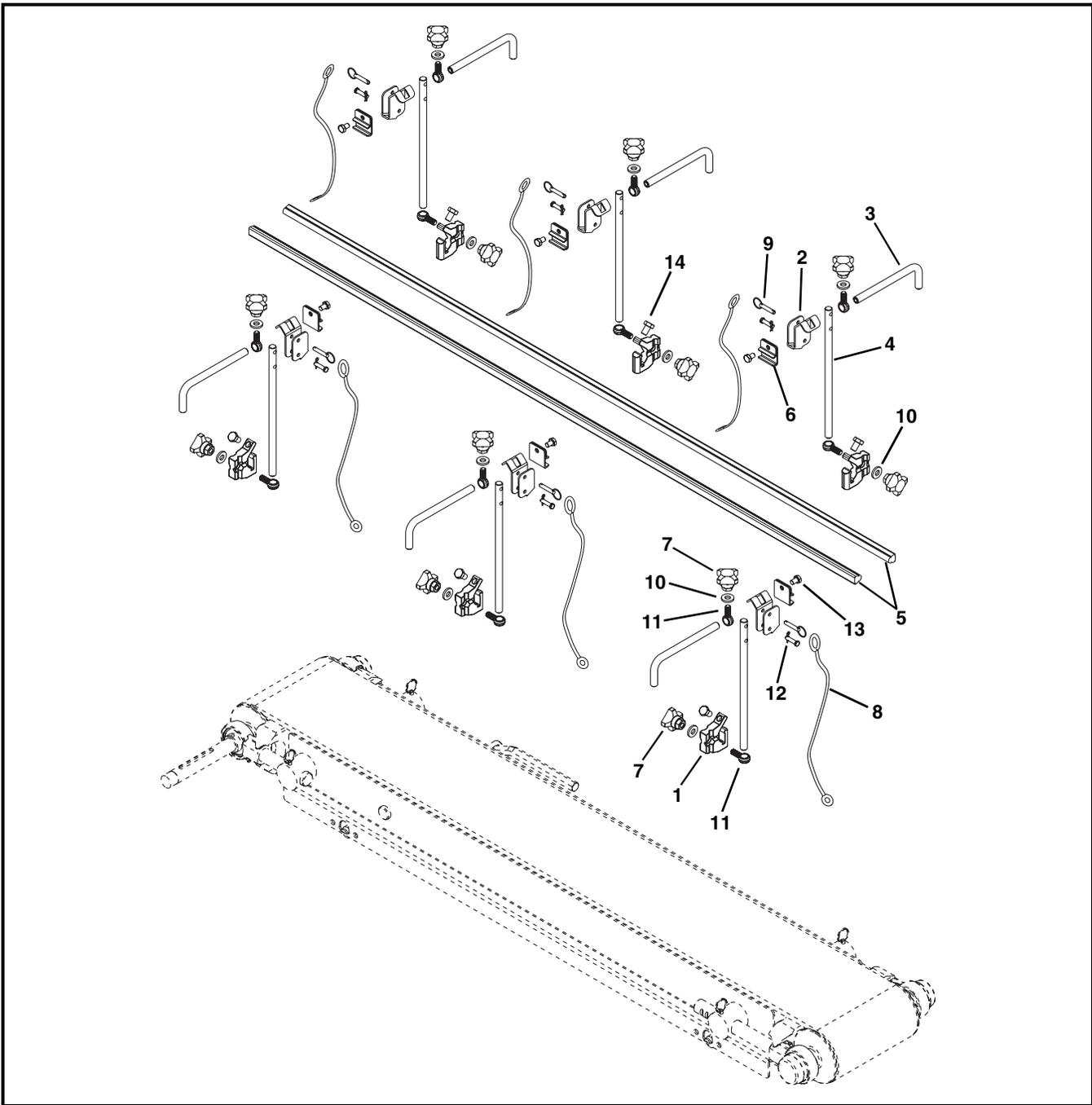
Item	Part Number	Description
1	509868	Mounting Block
2	509883	Pivot Guide Bracket
3	532300	Guide Post
4	509872-DH-1100	Adjustable Guide Shaft
5	532167-LLLLL	Guiding
6	807-015	Clamp Rail
7	807-1448	Lanyard
8	807-1553	Pin
9	807-1821	Washer
10	807-1994	Eyebolt M10 x 1.50

Item	Part Number	Description
11	807-1995	Cotter Pin
12	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
13	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
14	991001MSS	Hex Nut, M10 - 1.50
15	991008MSS	Hex Nut, M10 - 1.50

LLLLL = Length in inches with 2 decimal places.  
 Length Example: Length = 95.25" LLLLL = 09525

# Service Parts

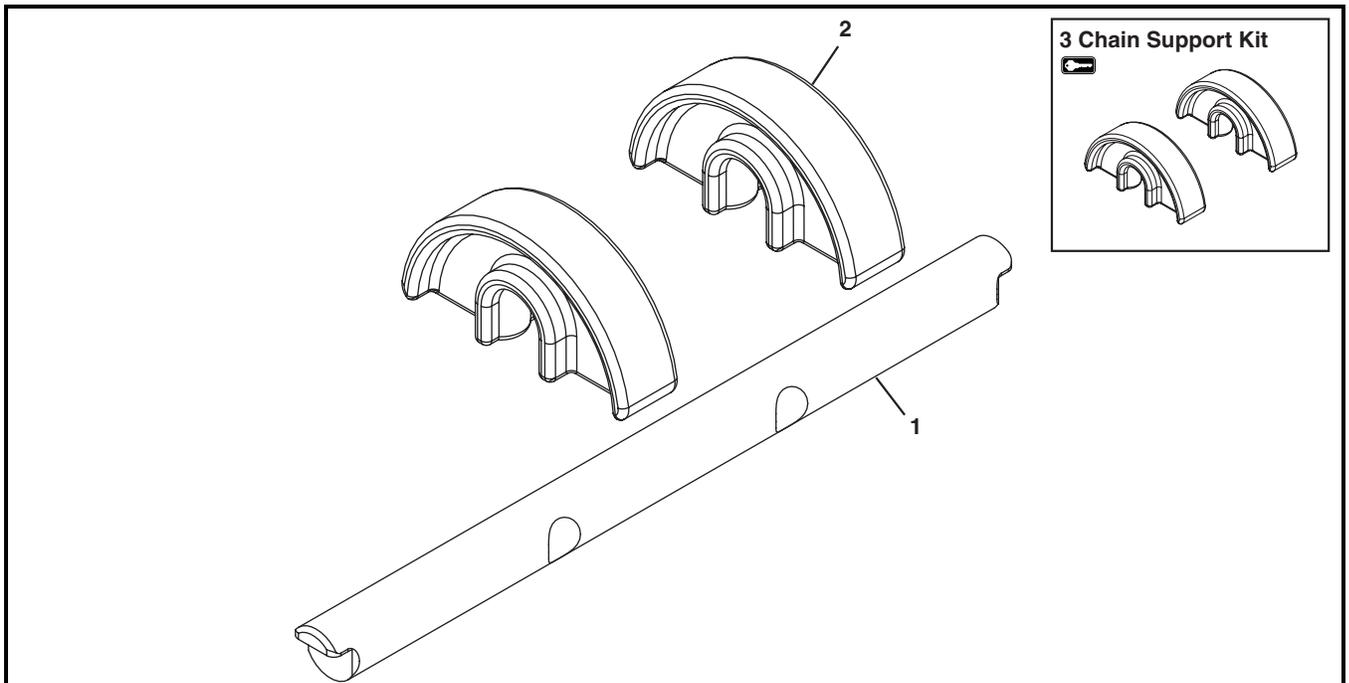
## Tool-Less Adjustable Hinged Guides



Item	Part Number	Description
1	509868	Mounting Block
2	509883	Pivot Guide Bracket
3	532300	Guide Post
4	509872-DH-1100	Adjustable Guide Shaft
5	532167-LLLLL	Guiding
6	807-015	Clamp Rail
7	807-1057	Handle
8	807-1448	Lanyard
9	807-1553	Pin

Item	Part Number	Description
10	807-1821	Washer
11	807-1994	Eyebolt M10 x 1.50/
12	807-1995	Cotter Pin
13	960812MSS	Hex Head Cap Screw, M8 - 1.25 x 12 mm
14	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

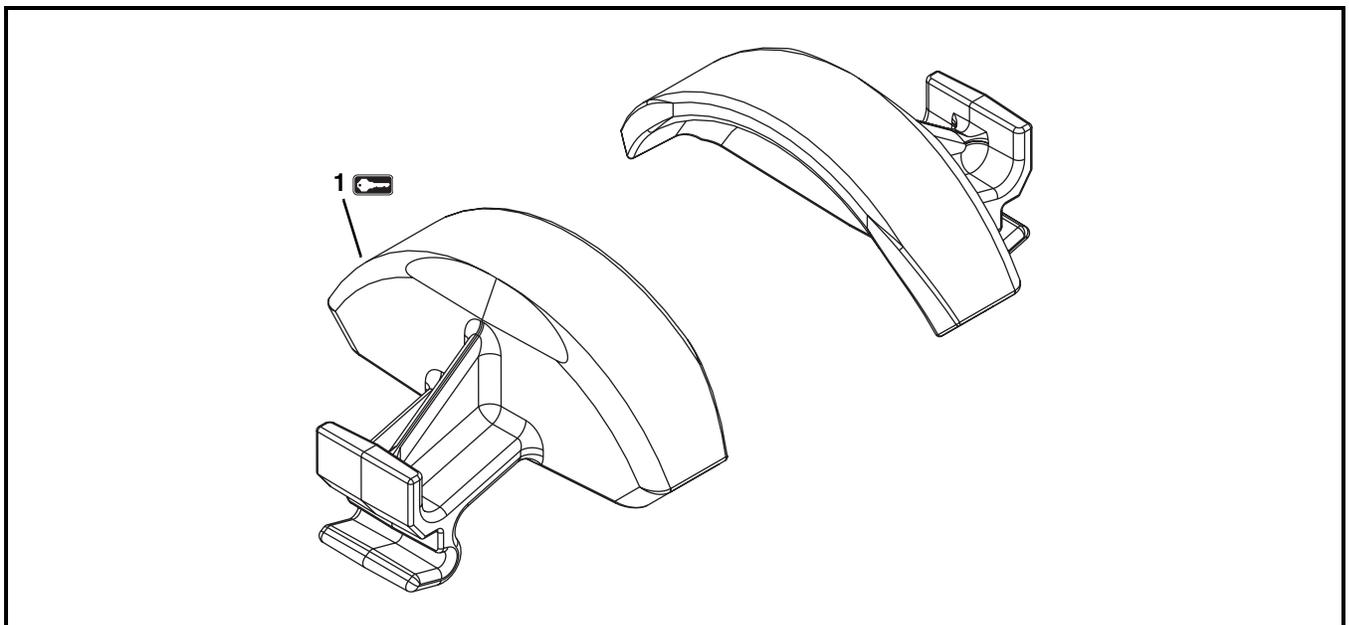
## Returns for Flat Belt Conveyors 26" (660 mm) and Wider



Item	Part Number	Description
1	5032WW	Return Shaft
2	500075	Chain Return Shoe

Item	Part Number	Description
3	74R-WW	Chain Support Kit ( Includes Item 2)
WW = Conveyor width ref: 26 - 60 in 02 increments		

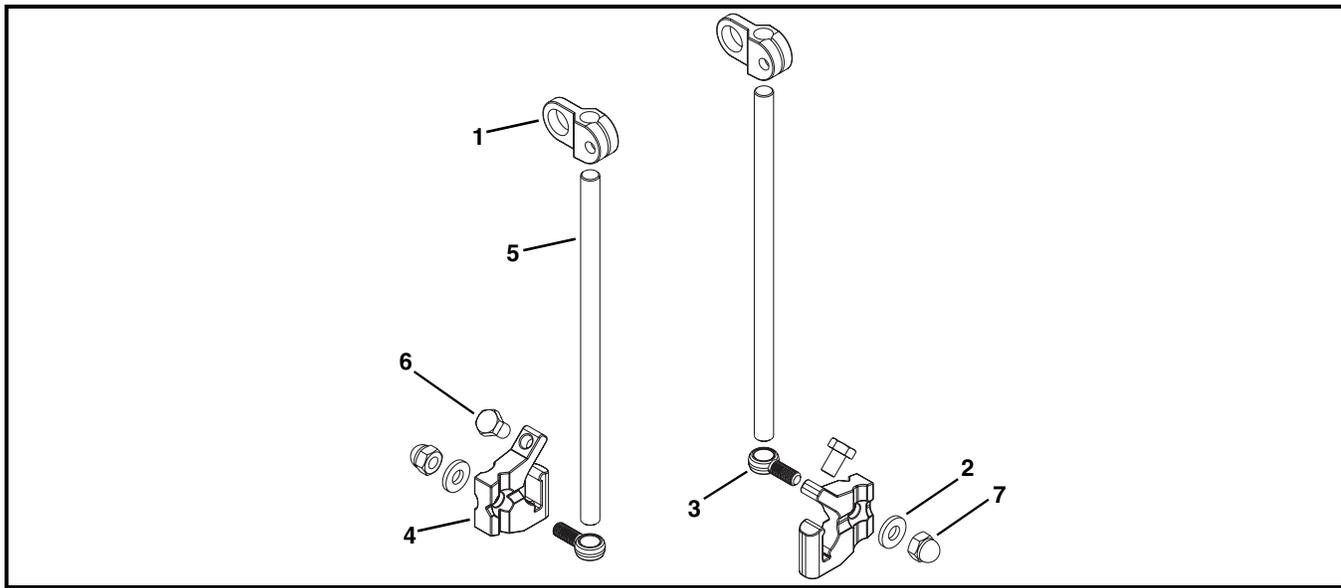
## Returns for Flat Belt Conveyors up to 24" (610 mm) Wide and Cleated Belt Conveyors



Item	Part Number	Description
1	532224	Cleated Return Shoe

# Service Parts

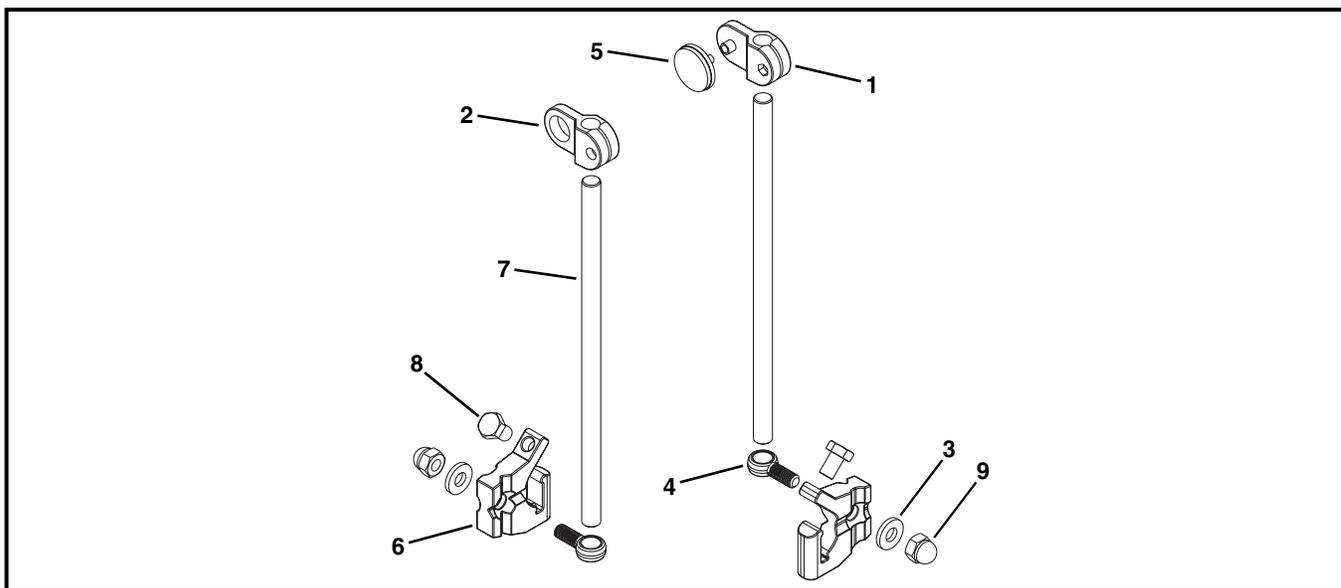
## Opposed (Thru Beam) Photo Eye Mount



Item	Part Number	Description
1	807-1391	Mount Clamp
2	807-1821	Washer
3	807-1994	Eyebolt, M10 x 1.50
4	509868	Mounting Block

Item	Part Number	Description
5	509872-NH-1100	Mounting Shaft
6	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
7	991008MSS	Hex Nut, M10 - 1.50

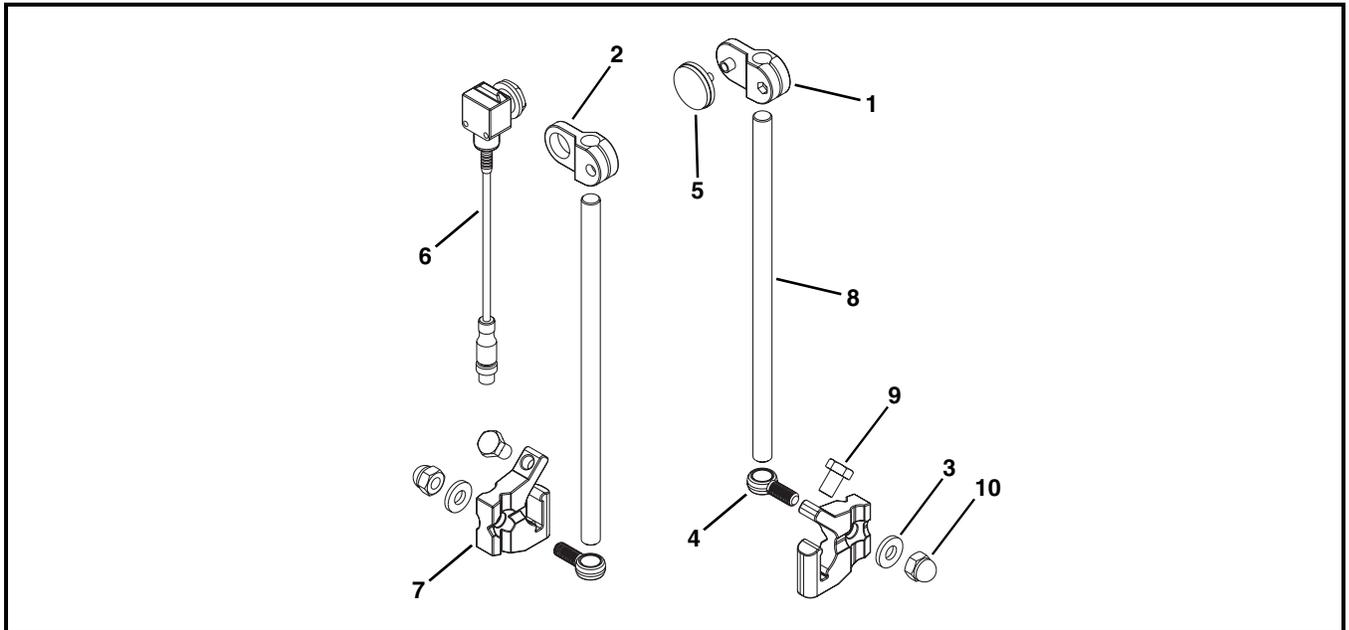
## Reflective Photo Eye Mount



Item	Part Number	Description
1	807-1390	Reflector Mount Clamp
2	807-1391	Photo Eye Mount Clamp
3	807-1821	Washer
4	807-1994	Eyebolt, M10 x 1.50
5	809-289	Reflector
6	509868	Mounting Block

Item	Part Number	Description
7	509872-NH-1100	Mounting Shaft
8	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
9	991008MSS	Hex Nut, M10 - 1.50

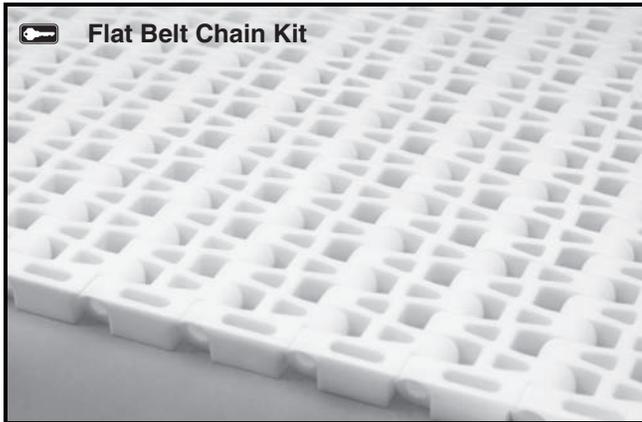
## Reflective Photo Eye Kit



Item	Part Number	Description
1	807-1390	Reflector Mount Clamp
2	807-1391	Photo Eye Mount Clamp
3	807-1821	Washer
4	807-1994	Eyebolt, M10 x 1.50
5	809-289	Reflector
6	809-315	Photo Eye Sensor
7	509868	Mounting Block
8	509872-NH-1100	Mounting Shaft
9	961016MSS	Hex Head Cap Screw, M10 - 1.50 x 16 mm
10	991008MSS	Hex Nut, M10 - 1.50

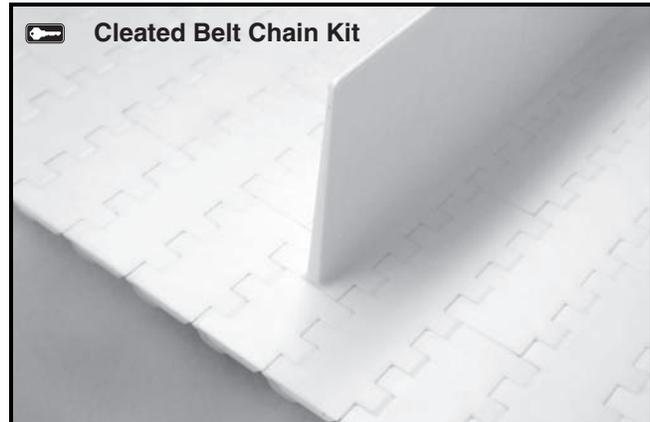
# Service Parts

## Flat Belt



Item	Part Number	Description
1	74BB-WW	Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
BB = Chain Reference Number		
WW = Conveyor width ref: 06 - 60 in 02 increments		

## Cleated Belt



Item	Part Number	Description
1	74BB-WW	Cleated Belt Chain Repair Kit (Includes 1 cleat centered on a cleat spacing length of chain and assembly pins)
BB = Chain Reference Number		
WW = Conveyor width ref: 06 - 60 in 02 increments		

## Ordering a Replacement Chain

Determine the length of chain required for the conveyor and round up to the nearest foot length. Order the proper number of chain repair kits (1' long each) for your conveyor. Dorner will ship chain kits that are of a reasonable length fully assembled.

### Example:

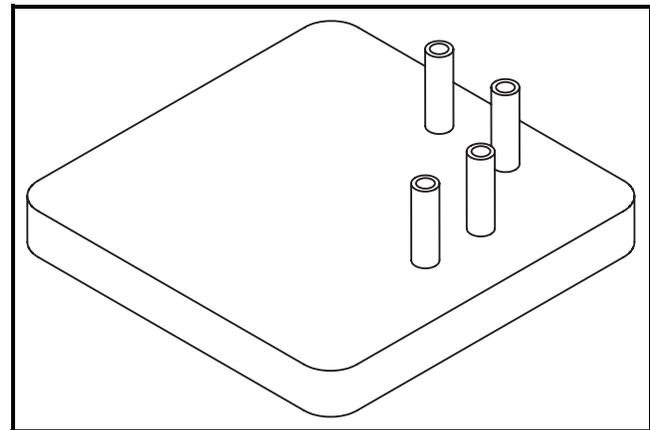
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 74BB-WW

BB = Chain reference number

WW = Conveyor width ref: 06-60 in 02 increments

## Belt Removal Tool



Item	Part Number	Description
1	500582	Tool Rod Removal for 1" Pitch Flush Grid Belt
	500494	Tool Rod Removal for 1/2" Pitch Flush Grid Belt

## Configuring Conveyor Part Number

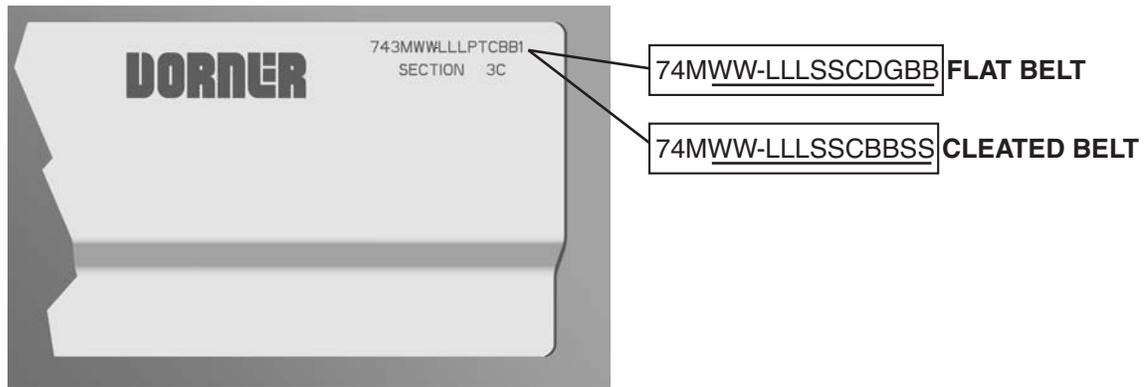


Figure 76

### Flat Belt Conveyor

Refer to the model number on the conveyor frame (**Figure 76**). From the model number, determine conveyor width (WW), length (LLL), drive stand location (S), idler stand location (S), cleaning options (C), drive/pulley type (D), profile (G) and belt material (BB).

**Example:**  
**74M12-072CC111MA**

7400 Series end drive, flat belt conveyor, 12" (305 mm) wide x 72" (1829 mm) long, stands located 18" (457 mm) from each end, frame cutout cleaning option, side drive with standard pulleys on each end, low side profiles, and MA belt material.

### Cleated Belt Conveyor

Refer to the model number on the conveyor frame (**Figure 76**). From the model number, determine conveyor width (WW), length (LLL), drive stand location (S), idler stand location (S), cleaning options (C), cleated belt material (BB) and cleat spacing (SS).

**Example:**  
**74M12-072CC1NA10**

7400 Series end drive, cleated belt conveyor, 12" (305 mm) wide x 72" (1829 mm) long, stands located 18" (457 mm) from each end, frame cutout cleaning option, NA cleated belt material, side drive with standard pulleys on each end, and 10 link spacing for cleats.

# Return Policy

Returns must have prior written factory authorization or they will not be accepted. Items that are returned to Dorner without authorization will not be credited nor returned to the original sender. When calling for authorization, please have the following information ready for the Dorner factory representative or your local distributor:

1. Name and address of customer.
2. Dorner part number(s) of item(s) being returned.
3. Reason for return.
4. Customer's original order number used when ordering the item(s).
5. Dorner or distributor invoice number (if available, part serial number).

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization (RMA) number for reference. RMA will automatically close 30 days after being issued. To get credit, items must be new and undamaged. There will be a return charge on all items returned for credit, where Dorner was not at fault. It is the customer's responsibility to prevent damage during return shipping. Damaged or modified items will not be accepted. The customer is responsible for return freight.

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

Returns will not be accepted after 60 days from original invoice date. The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components to inventory. If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Customer Service Team will gladly help with your questions on Dorner products.

For a copy of Dorner's Warranty, contact factory, distributor, service center or visit our website at [www.dorner.com](http://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. 2013

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