7360 Series Center Drive Conveyors

Installation, Maintenance and Parts Manual

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

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

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

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

851-709 Rev. A

Table of Contents

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 7360 Series conveyors have patents pending.

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 .

⚠ 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.**

Product Description

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

Typical Components	
1	Conveyor
2	Gearmotor
3	Belt
4	Support Stands
5	Drive End
6	Idler End
7	Center Drive

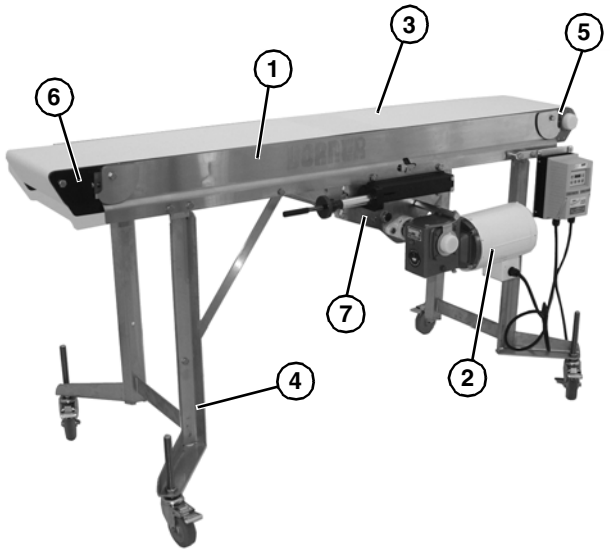
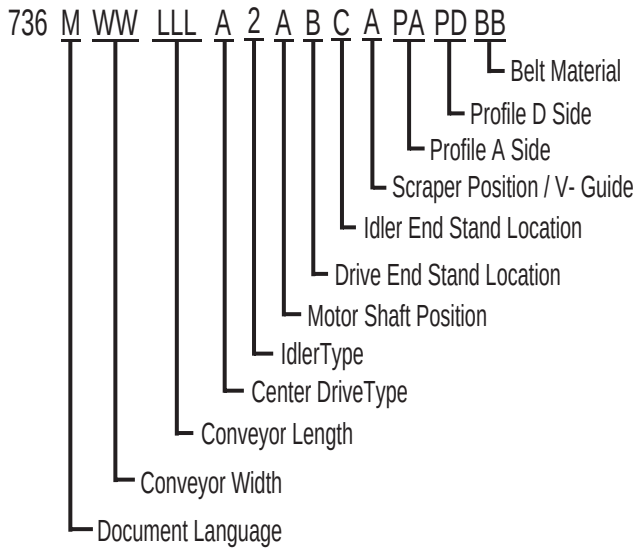


Figure 1

7360 Series Center Drive Conveyor



Maximum Distances:

1 = Support Stand on Drive End = 24" (610 mm)

2 = Between Support Stands = 8 ft (2438 mm)**

3 = Support Stand on Idler End = 30" (762 mm)

** For conveyors longer than 10 ft (3048 mm), install stand mount kit at frame joint.

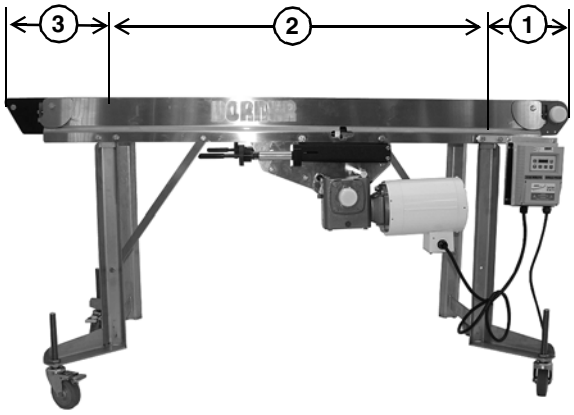


Figure 2

Conveyor Supports Specifications

Conveyor Width Reference (WW)	04 – 52 in 02 increments
Conveyor Belt Width	4" (102 mm) - 52" (1321 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft^2 (97 kg/ m^2) with a maximum of 500 lbs. (228 kg)
Belt Travel	11" (279 mm) per revolution of pulley
Maximum Belt Speed	300 ft/minute (91 m/minute)

Conveyor Length Reference (LLL)	068 – 999 in 001 increments
Conveyor Length	68" (1727 mm) - 999" (25,375 mm) in 1" (25 mm) increments

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

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

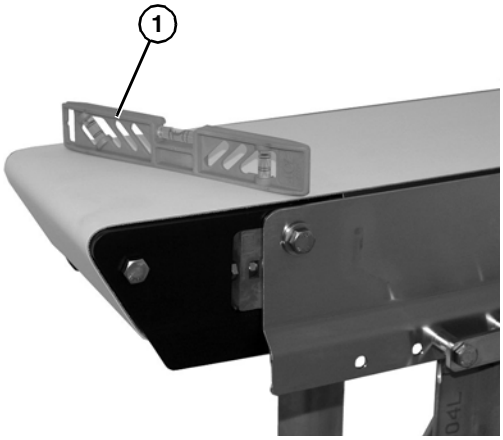


Figure 3

Required Tools

- Level
- Torque wrench
- 5/32” hex wrench (for bearings)
- 13 mm wrench (for tail assemblies)
- 14 mm wrench (for motor mounts)
- 17 mm wrench (for stands)

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to “Conveyors Longer than 10 ft (3048 mm)” on page 6.
2. Attach the stands. Refer to “Stand Installation” on page 7.
3. Install the belt. Refer to “Belt Installation” on page 8.
4. Install belt returns. Refer to “Belt Returns” on page 8.
5. Install the gearmotor. Refer to “Gearmotor Installation” on page 11.

Conveyors Longer than 10 ft (3048 mm)

Connecting Components

Typical Connecting Components **(Figure 4)**.

1	Connector Plate (x2)
2	Hex Head Cap Screw M10-1.50 x 12mm (x4)
3	Conveyor Frames

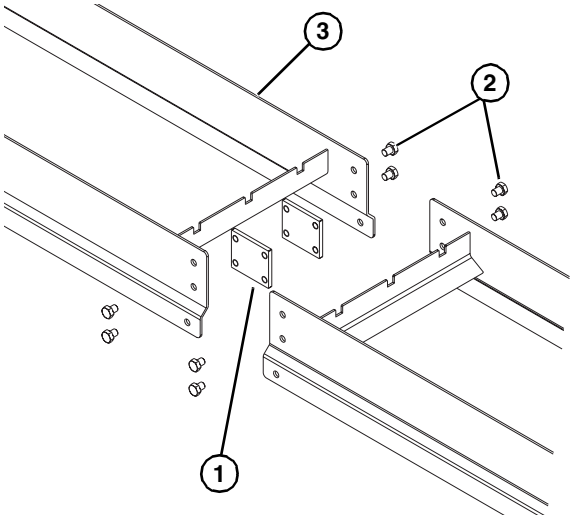


Figure 4

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

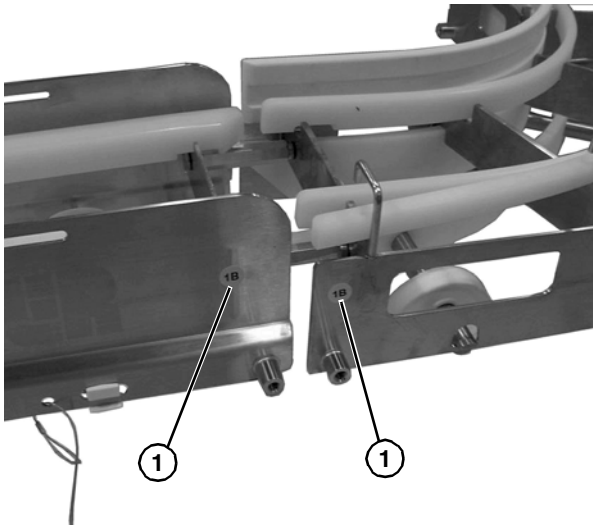


Figure 5

2. Join both conveyor sections, and install plate frame connectors **(Figure 4, item 1)**, and secure with M10x12 hex head cap screws **(Figure 4, item 2)** on both sides.

All Conveyors

Stand Installation

NOTE

For detailed assembly instructions, please see support stand manual.

Typical stand components **(Figure 6)**

1	Conveyor Frame
2	Stand
3	M10 - 1.5 x 16 mm hex head cap screws (x4)

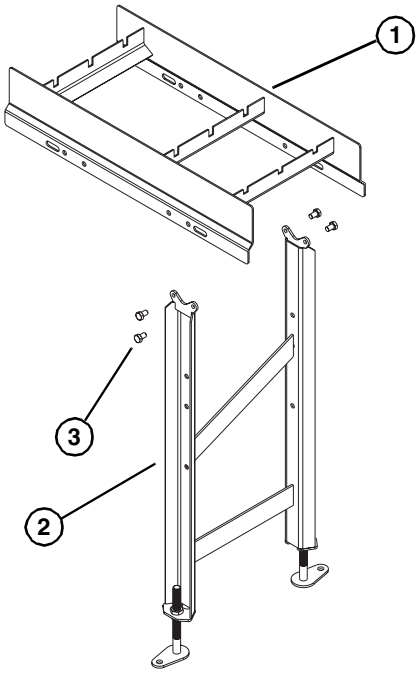


Figure 6

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame with two cap screws **(Figure 7, item 1)**.

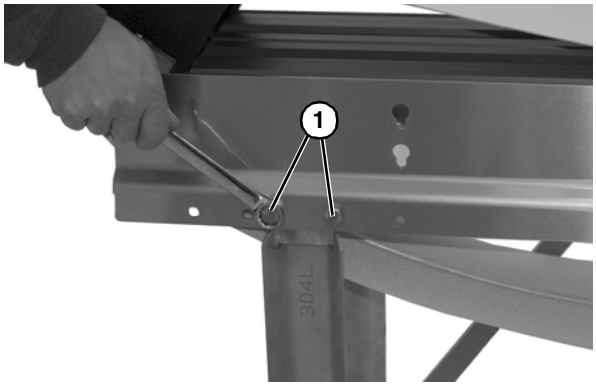


Figure 7

Bed Rail Installation

NOTE

If bed rails fall off during shipping, install as follows.

1. Install two outer bed rails **(Figure 8, item 1)** and inner bed rails **(Figure 8, item 2)**, making certain that bed rails notched area **(Figure 9, item 3)** cradles frame clip **(Figure 9, item 4)**.

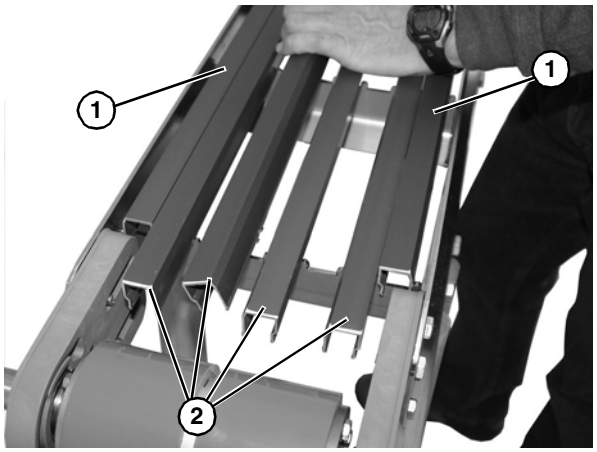


Figure 8

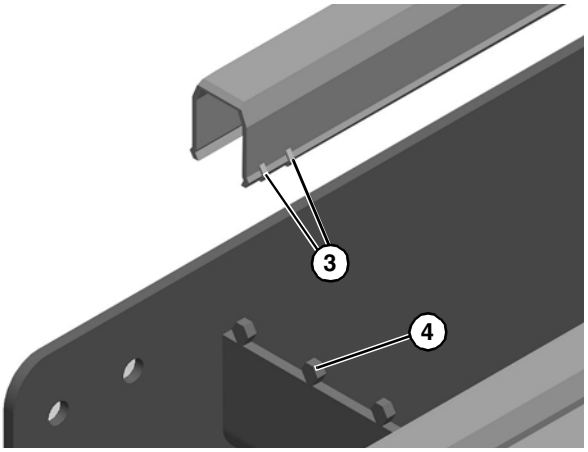


Figure 9

Installation

Belt Installation

1. Remove two cap screws **(Figure 10, item 1)** holding stand to conveyor.

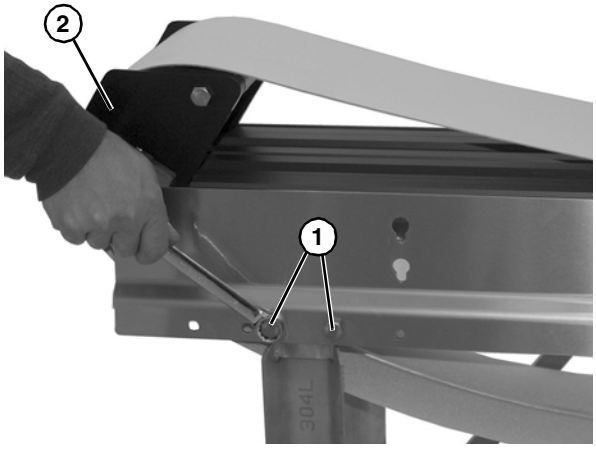


Figure 10

2. Rotate idler end **(Figure 10, item 2)** upward.
3. Position the belt under the stand **(Figure 11, item 1)** on the conveyor **(Figure 11, item 2)**.

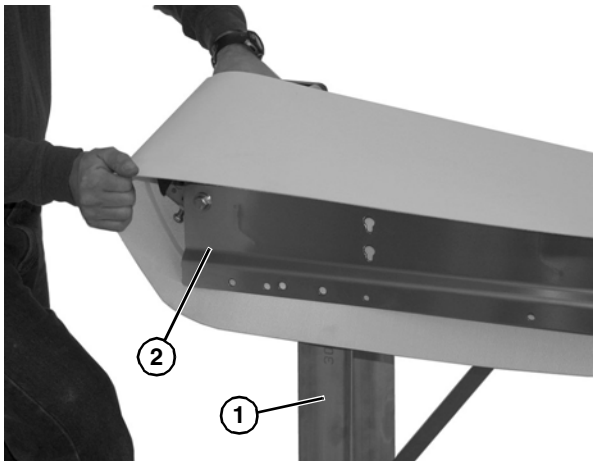


Figure 11

4. Reinstall two cap screws holding conveyor to stand.
5. Repeat procedure for opposite end of conveyor to fully install belt.

Belt Returns

Typical flat return components **(Figure 12)**

1	Cap Screw, M10-1.50 x 16 mm
2	Return Shaft Bracket
3	Clamp
4	Return Disk
5	Shaft

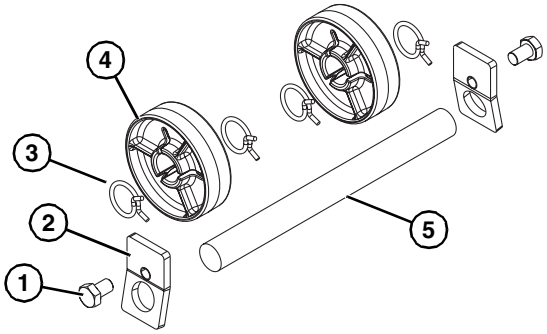


Figure 12

1. Install return disks **(Figure 13, item 1)** onto shaft **(Figure 13, item 2)**, and secure with clamps **(Figure 13, item 3)**.

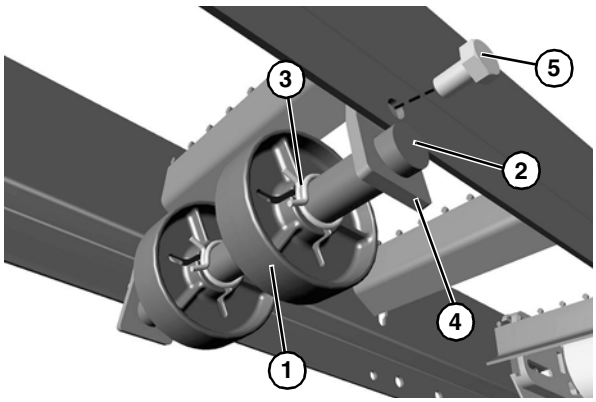


Figure 13

2. Install belt return assembly onto frame with return shaft brackets **(Figure 13, item 4)** and cap screws **(Figure 13, item 5)** on the outside of conveyor.

Guide Installation

1. Insert carriage bolts with spacers **(Figure 14, item 1)** into slotted holes in conveyor side.

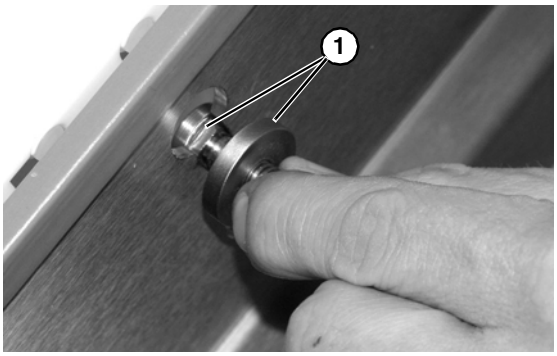


Figure 14

2. Attach the guide mounting brackets **(Figure 15, item 1)** to the conveyor with hex nuts **(Figure 15, item 2)**. Hand tighten only at this time.

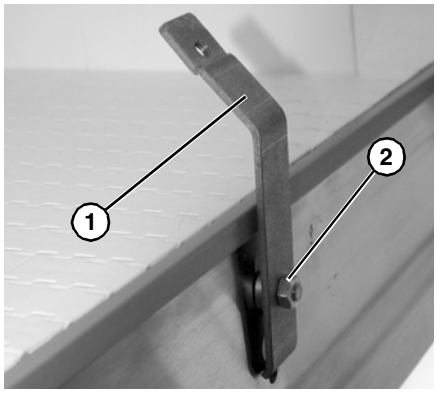


Figure 15

3. Attach guide **(Figure 16, item 1)** to the mounting brackets with hex bolts and spacers **(Figure 16, item 2)**. Hand tighten only at this time.

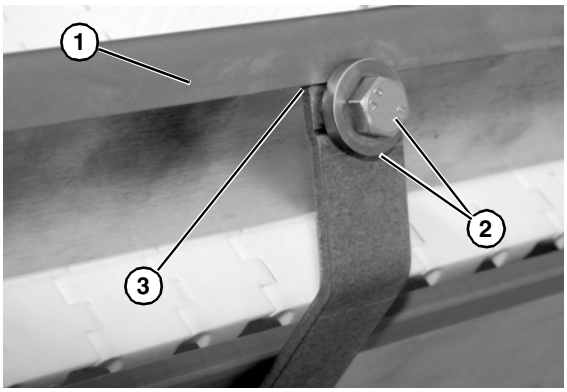


Figure 16

4. Ensure that nose of bracket slips under the lip of guide **(Figure 16, item 3)**.

NOTE

*When installing guides, be sure that the angled end of guide is installed on the idler end of conveyor **(Figure 17, item 1)**.*

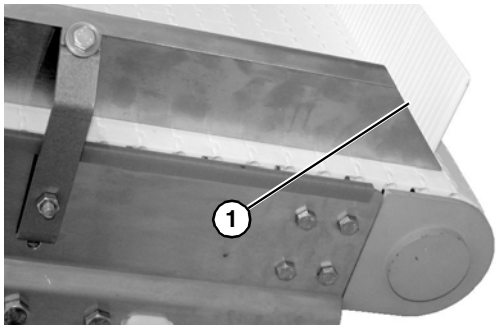


Figure 17

5. Tighten all mounting hardware.

Scraper Installation

Typical Scraper Components **(Figure 18)**

1	Scraper adjust plate
2	Scraper shaft
3	Scraper bar holder
4	UHMW scraper
5	Scraper mount plate
6	Pull pin
7	Handle
8	M10-1.50 hex head cap screws (x4)

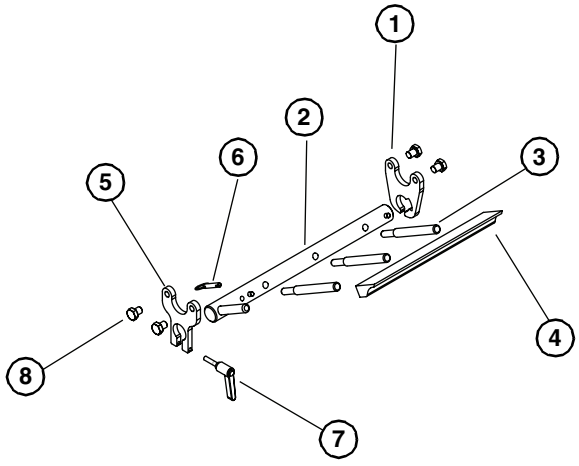


Figure 18

1. Attach the scraper adjust plate **(Figure 18, item 1)** and the scraper mount plate **(Figure 18, item 5)** to the frame using four M10-1.5 x 12mm hex head cap screws.

2. Slide the notched end of the scraper shaft **(Figure 19, item 1)** through the adjustment plate **(Figure 19, item 2)**.

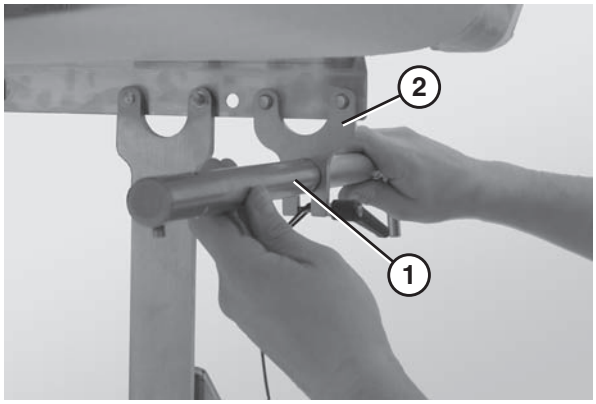


Figure 19

3. Insert the notched end of the scraper shaft **(Figure 20, item 1)** so that it is situated within the groove in the mounting plate **(Figure 20, item 2)**.

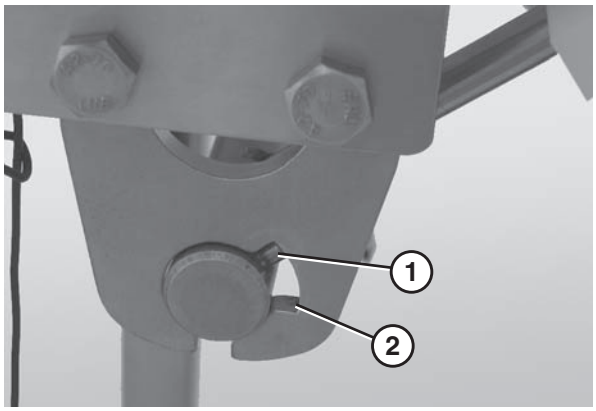


Figure 20

4. Attach the scraper bar holders **(Figure 21, item 1)** to the scraper shaft **(Figure 21, item 2)**.

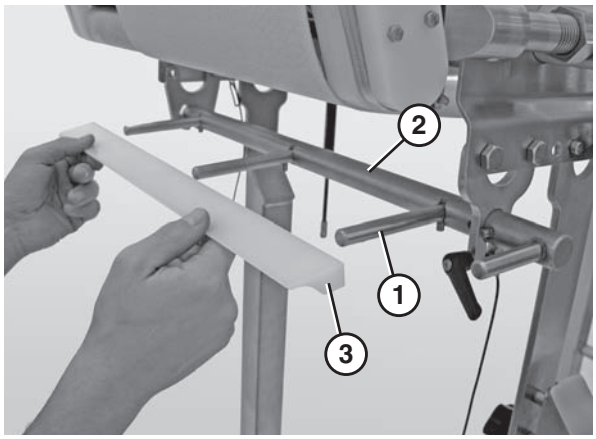


Figure 21

5. Attach the UWHM scraper **(Figure 21, item 3)** to the scraper bar holders **(Figure 21, item 1)**.

6. Insert the pin **(Figure 22, item 1)** to lock the scraper bar in place **(Figure 22, item 2)**.

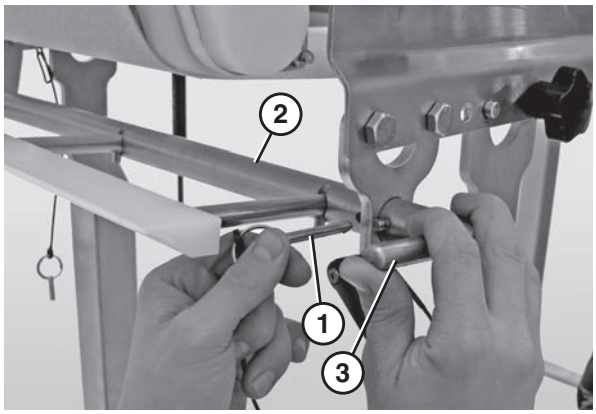


Figure 22

7. Adjust the scraper to the desired position using the scraper bar handle **(Figure 22, item 3)**.

⚠ CAUTION

Apply minimal pressure between the scraper (Figure 23, item 1) and the belt (Figure 23, item 2).

Positioning the scraper so that it is digging into the belt will increase resistance, cause unnecessary strain on the motor and lead to premature belt failure.

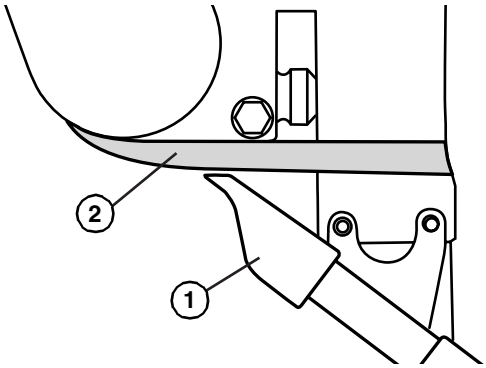


Figure 23

8. Secure the scraper by tightening the handle **(Figure 24, item 1)**.

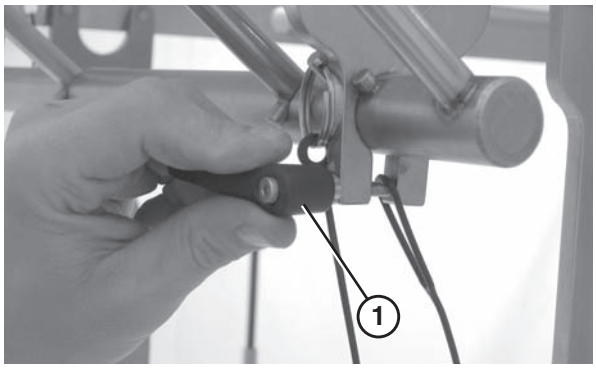


Figure 24

Gearmotor Installation

Required Tools

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

Mounting

⚠ WARNING

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

1. Locate components of Figure 25.

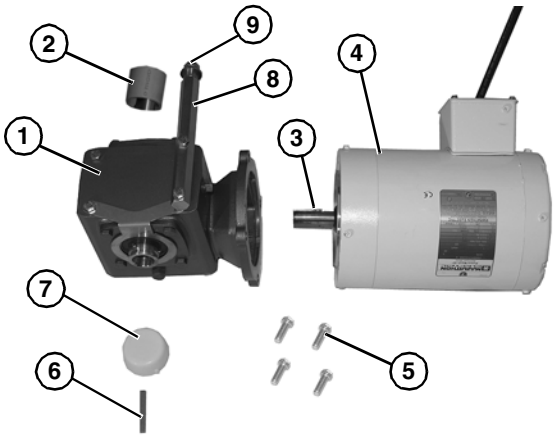


Figure 25

Gearmotor Installation Component List	
1	Gear Reducer
2	Spacer
3	Motor Key
4	Motor
5	Motor Mount Bolts
6	Gear Reducer Key
7	Cover
8	Mounting Post
9	Hex Head Cap Screws

2. Install mounting post **(Figure 26, item 1)** onto conveyor frame with bolt.

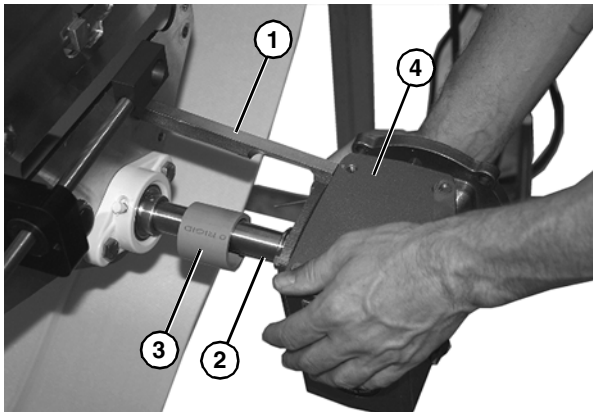


Figure 26

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

3. Install key **(Figure 26, item 2)** on drive shaft.
4. Install spacer **(Figure 26, item 3)** onto shaft.
5. Install gear reducer **(Figure 26, item 4)** onto shaft.

6. Secure gear reducer to mounting post with two screws **(Figure 27, item 1)**. Tighten mounting screws to 200 in-lbs (22.5 N m).

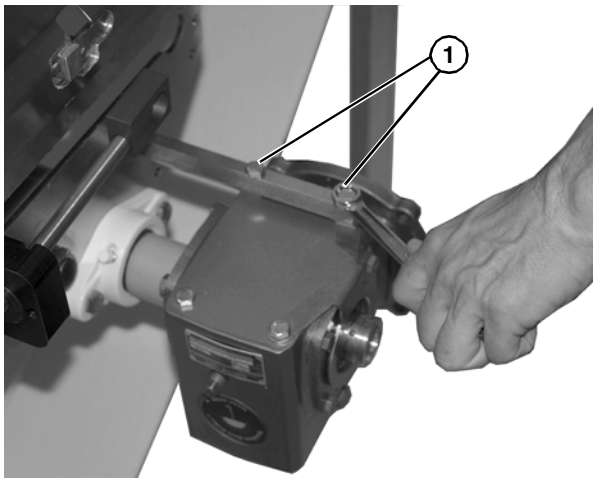


Figure 27

7. Rotate spacer, as needed, and tighten set screws **(Figure 28, item 1)** on inner gearmotor bearing.

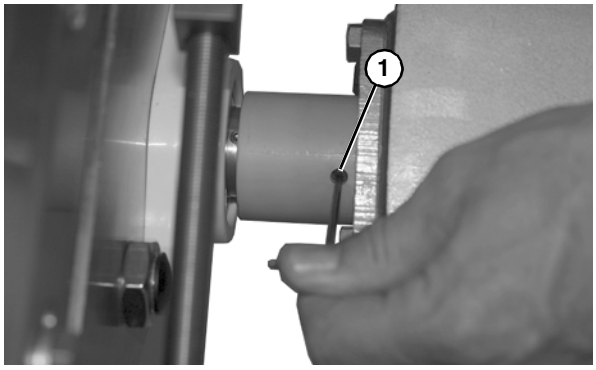


Figure 28

8. Tighten set screws **(Figure 29, item 1)** on outer gearmotor bearing.

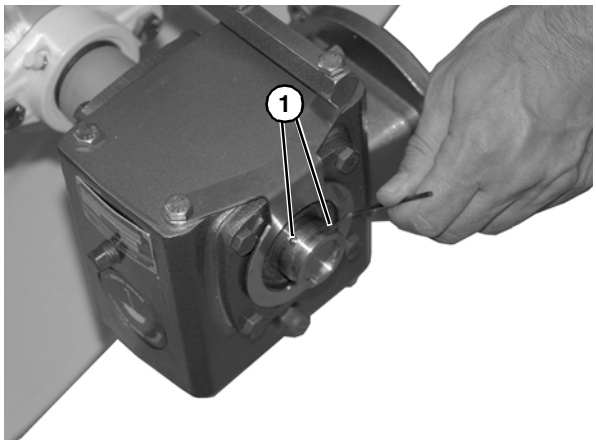


Figure 29

9. Install bearing cover **(Figure 30, item 1)**.

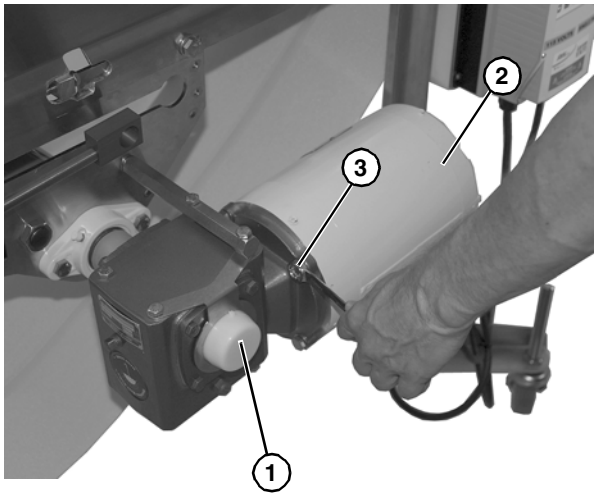


Figure 30

10. Attach the motor **(Figure 30, item 2)** to the gear reducer with four bolts **(Figure 30, item 3)**.

Required Tools

- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 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 30 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.

⚠ WARNING

SEVERE HAZARD!

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

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

Visit www.dorner.com for complete list of troubleshooting solutions.

Inspect conveyor belt for:

- Surface cuts or wear

Damage to the belt, surface cuts and/or wear indicates:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories
- Excessive load on belt
- Dirt impacted on spindle
- Excessive or improper side loading
- Improper tracking

Skipping indicates:

- Excessive load on belt
- Worn spindle or impacted dirt on drive spindle
- Improper tracking

Conveyor Belt Replacement

⚠ WARNING

SEVERE HAZARD!

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

Belt Removal

1. Remove guides (**Figure 31, item 1**) when required.

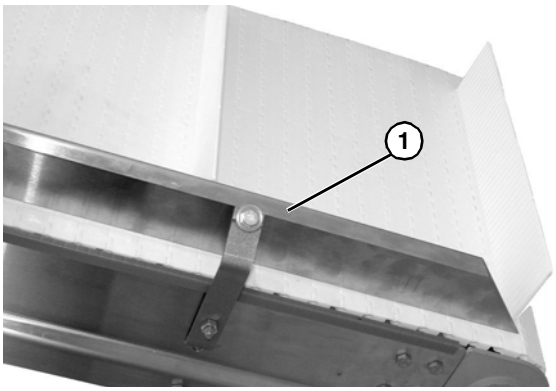


Figure 31

2. Remove air supply and remove hose **(Figure 32, item 1)** from center drive.

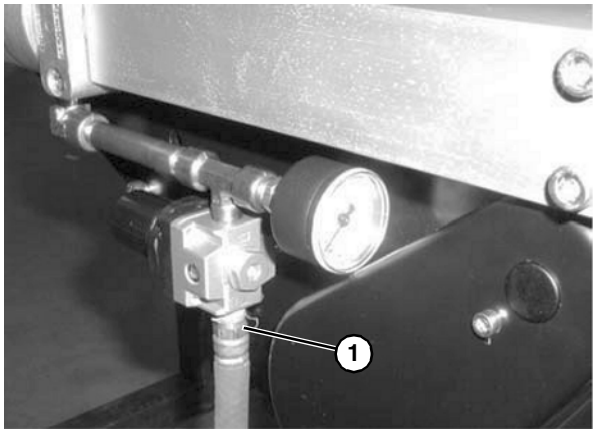


Figure 32

3. Rotate tensioning nut **(Figure 33, item 1)** on each side of center drive unit counterclockwise to remove all tension on belt.

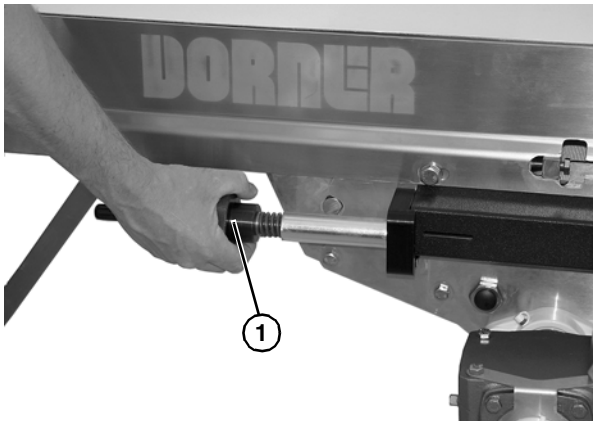


Figure 33

4. Remove two bolts **(Figure 34, item 1)** from cover **(Figure 34, item 2)**.

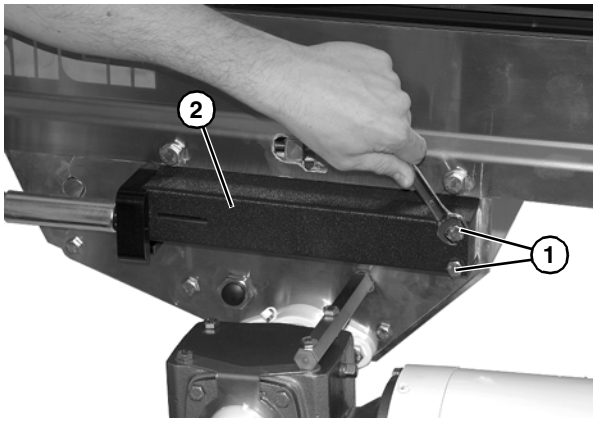


Figure 34

5. Remove cover **(Figure 35, item 1)** and spacer **(Figure 35, item 2)** from conveyor frame.

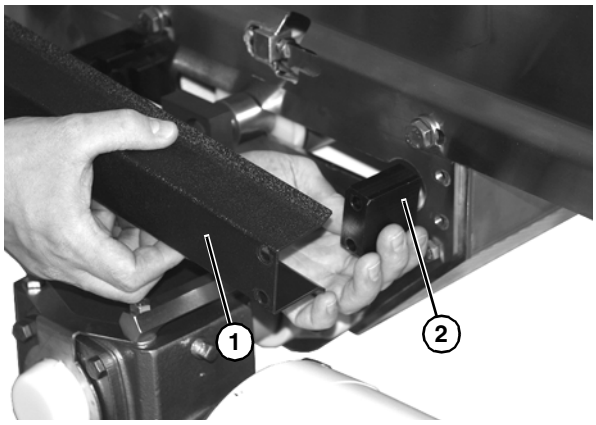


Figure 35

6. Remove two screws **(Figure 36, item 1)** from each side of center drive and remove stationary guard assembly **(Figure 36, item 2)**.

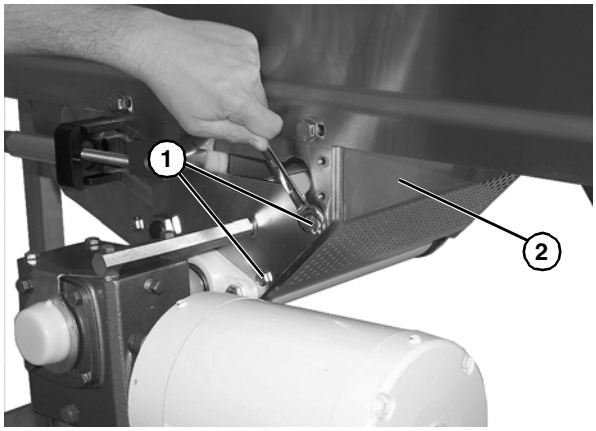


Figure 36

7. Remove screw **(Figure 37, item 1)** from each side of center drive from idler guard assembly.

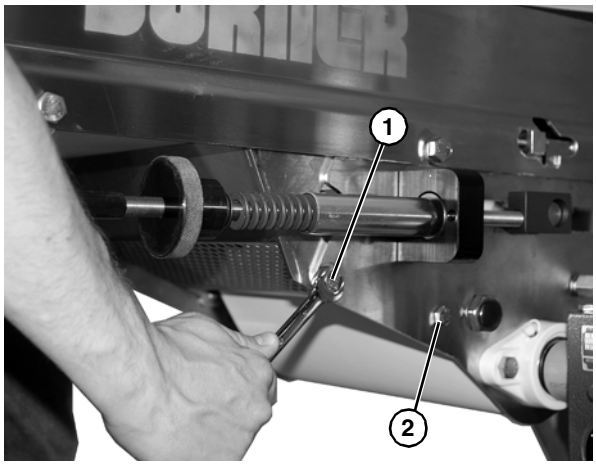


Figure 37

8. Loosen screw **(Figure 37, item 2)** from each side.

9. Swing down idler guard assembly **(Figure 38, item 1)**. Remove idler pulley **(Figure 38, item 2)**.

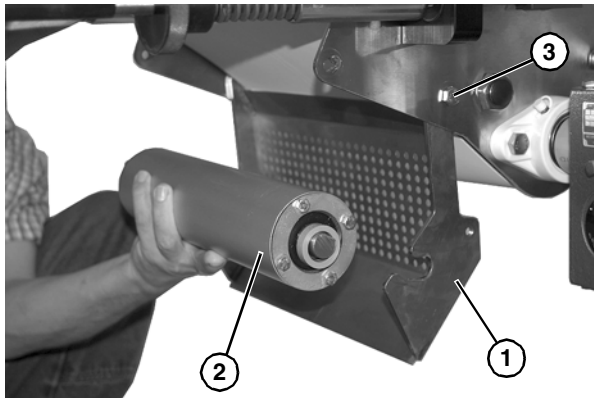


Figure 38

10. Remove screw **(Figure 38, item 3)** from each side of center drive and remove idler guard assembly **(Figure 38, item 1)**.
11. Loosen tension nut **(Figure 39, item 1)** on each side of center drive unit so that tensioner assembly shaft **(Figure 39, item 2)** aligns with hole **(Figure 39, item 3)**.

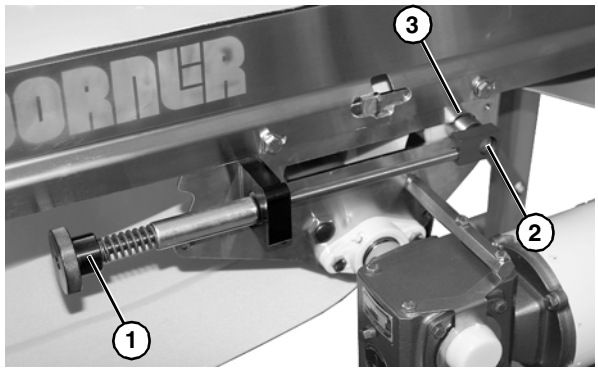


Figure 39

12. Loosen set screw **(Figure 40, item 1)** on locking collar **(Figure 40, item 2).**

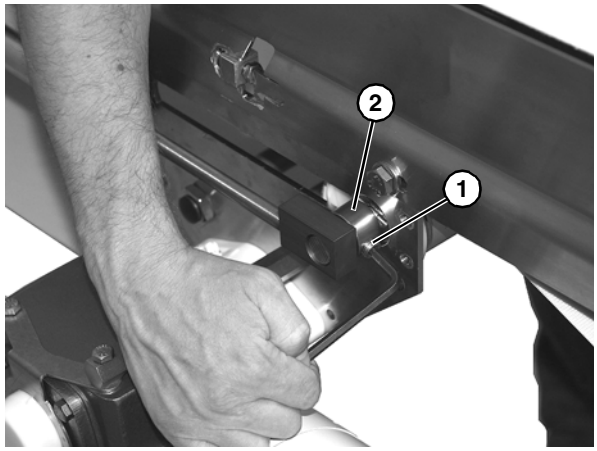


Figure 40

13. Slide in shaft **(Figure 41, item 1)** into locking collar **(Figure 41, item 2)** and remove tension block **(Figure 41, item 3)** from tensioner assembly shaft.

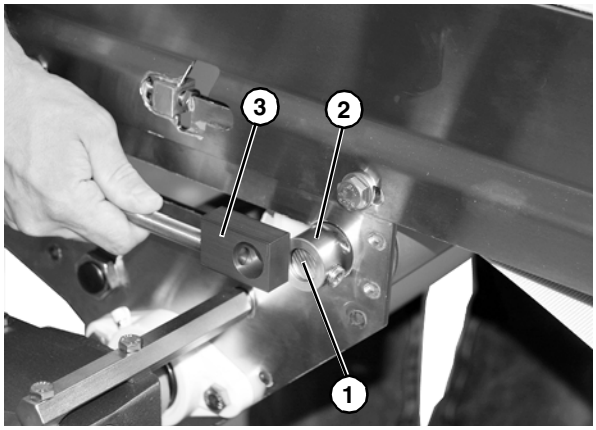


Figure 41

14. Remove locking collar **(Figure 42, item 1)** from tensioner assembly shaft **(Figure 42, item 2)**.

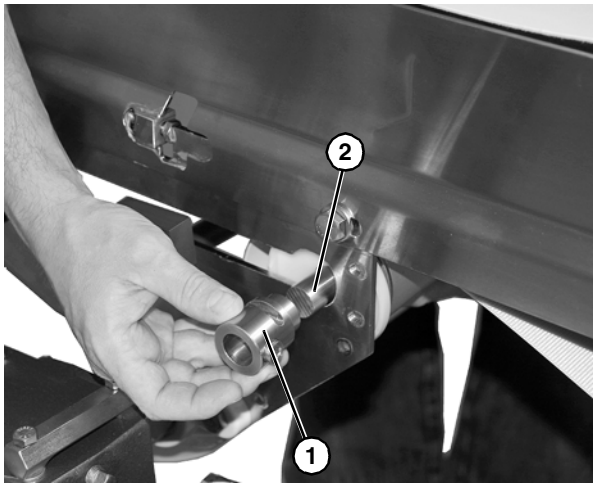


Figure 42

15. Slide shaft **(Figure 43, item 1)** into tensioner pulley **(Figure 43, item 2)**, and remove spacer plate **(Figure 43, item 3).**

NOTE

*When removing components, be sure to note the orientation of spacer plate **(Figure 43, item 3)** on each end of conveyor.*

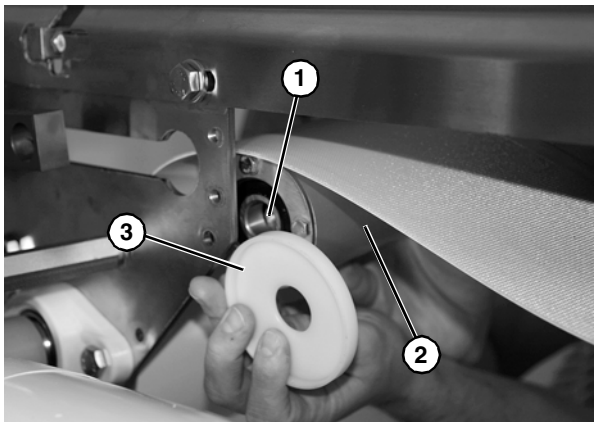


Figure 43

16. Remove tensioner pulley **(Figure 43, item 2)** and remaining spacer plate.
17. Remove belt **(Figure 44, item 1)** from center drive module **(Figure 44, item 2)**.

⚠ WARNING

Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT

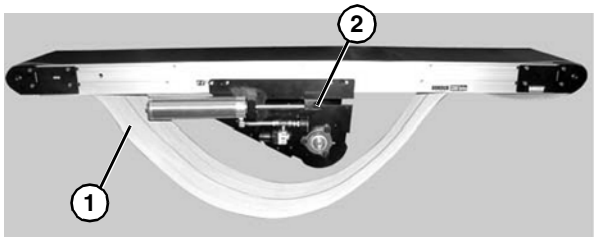


Figure 44

18. Place temporary support stands at both ends of the conveyor. See WARNING.
19. Remove two cap screws **(Figure 45, item 1)** holding stand to conveyor.

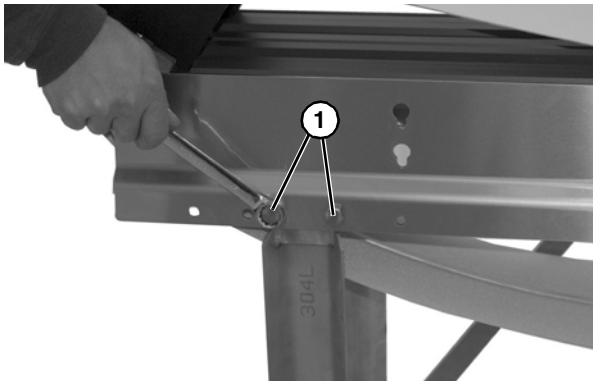


Figure 45

20. Repeat procedure for opposite end of conveyor.
21. Remove the belt from under the stand **(Figure 46, item 1)** and from the conveyor **(Figure 46, item 2)** on both ends.

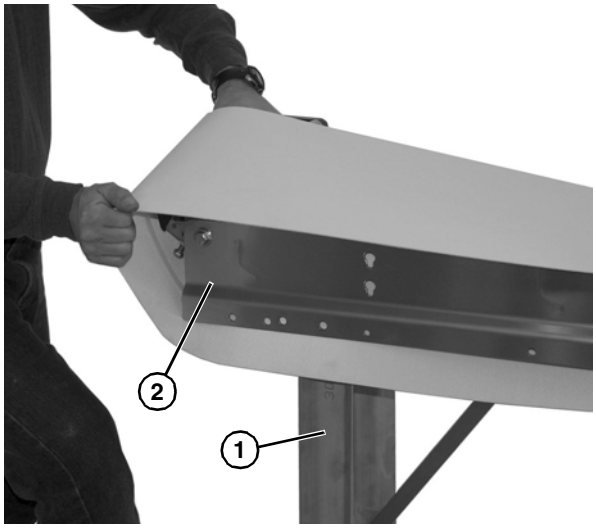


Figure 46

22. Replace the old belt with a new one.

Belt Installation

WARNING

Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT

1. Ensure temporary support stands are placed at both ends of the conveyor. See WARNING.
2. Orient belt so splice leading fingers **(Figure 47, item 1)** point in the direction of belt travel as identified by the conveyor directional label **(Figure 47, item 2)**.

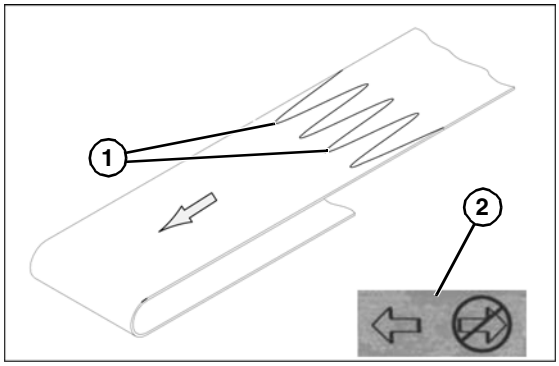


Figure 47

3. Install belt **(Figure 48, item 1)** on conveyor. Lift conveyor **(Figure 48, item 2)** slightly to avoid pinching belt on temporary support stands.

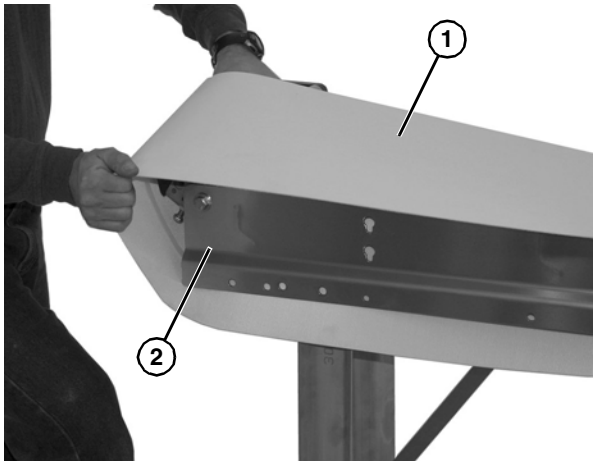


Figure 48

4. Reverse steps 1 thru 16 of the “Belt Removal” on page 13”.
5. If equipped, reinstall guiding.
6. Reattach air supply **(Figure 49, item 1)** to center drive. Refer to “Conveyor Belt Tensioning” on page 17” for more information.

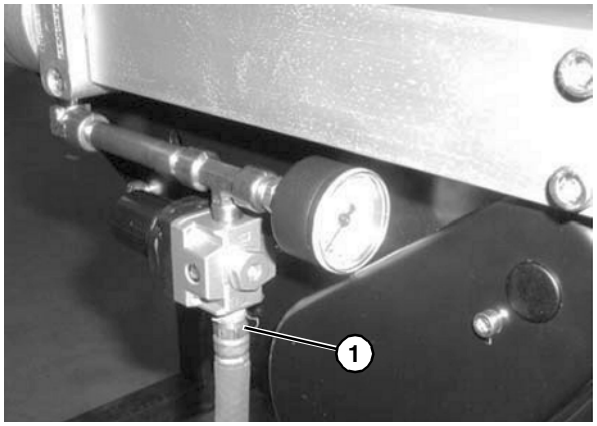


Figure 49

7. Track drive and conveyor if required. See “Center Drive Module Tracking” on page 19 and “Conveyor Belt Tracking” on page 19”.

Conveyor Belt Tensioning

WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

A - With Pneumatic Tensioning

1. Connect air supply **(Figure 50, item 1)** to regulator **(Figure 50, item 2)**.
2. Adjust regulator knob **(Figure 50, item 3)** until gage reads the appropriate pressure. Adjust regulator starting at 15 psi sufficiently to keep belt from slipping up to the maximum shown in the following table.

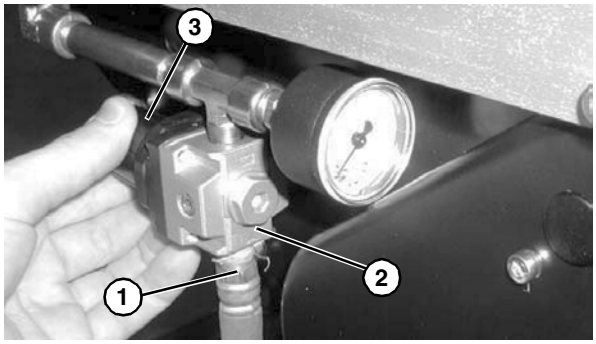


Figure 50

Suggested Maximum Tensioning Air Pressure for Center Drive Conveyors	
Width	**Pressure**
4” (95 mm)	20 psi (138 kPa)
6” (152 mm)	30 psi (207 kPa)
8” (203 mm)	40 psi (276 kPa)
10” (254 mm)	50 psi (345 kPa)
14” (356 mm)	60 psi (414 kPa)
18” (457 mm)	70 psi (483 kPa)
24” (610 mm) & wider	80 psi (552 kPa)

3. If proper belt tension cannot be achieved before the out of tension indicator **(Figure 51, item 1)** begins to turn red, the belt must be replaced.

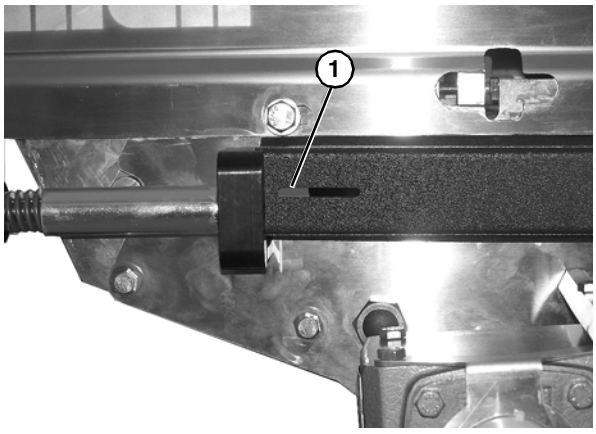


Figure 51

4. If belt tracking is necessary, refer to “Conveyor Belt Tracking” on page 19 and “Center Drive Module Tracking” on page 19.

B - With Manual Tensioning

⚠ WARNING

Threaded rod end may be sharp. Cover with guard while adjusting tension knob.
HANDLE WITH CARE.

1. Turn knurled knob **(Figure 52, item 1)** on each side of center drive unit clockwise until tensioning spring **(Figure 52, item 2)** is completely behind spring cover **(Figure 52, item 3)**. There should be approximately 1/8” gap **(Figure 53, item 1)** between hand knob and spring cover.

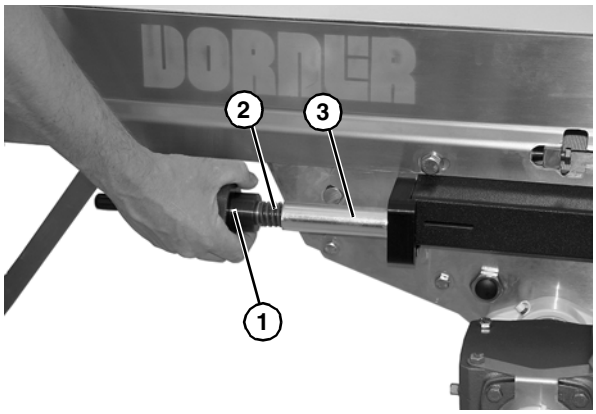


Figure 52

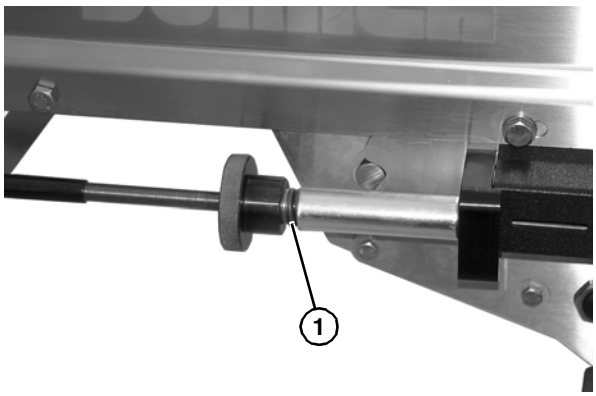


Figure 53

2. As normal belt stretch occurs over time, the spring **(Figure 52, item 2)** will be exposed out of the spring cover **(Figure 52, item 3)**. When the spring is exposed over 1/2” or if conveyor belt slippage occurs, retighten knurled hand knob **(Figure 52, item 1)** on each side of center drive unit clockwise until tensioning spring is completely behind spring cover.

3. If proper belt tension cannot be achieved before the out of tension indicator **(Figure 51, item 1)** begins to turn red, the belt must be replaced.
4. If belt tracking is necessary, refer to "Conveyor Belt Tracking" on page 19" and "Center Drive Module Tracking" on page 19".

Conveyor Belt Tracking

1. Tighten or loosen bolts **(Figure 54, item 1)** on each side to correct tracking. (Align the same arrows **(Figure 54, item 2)** and marks **(Figure 54, item 3)** on each side of the conveyor as a starting point for tracking the belt.)

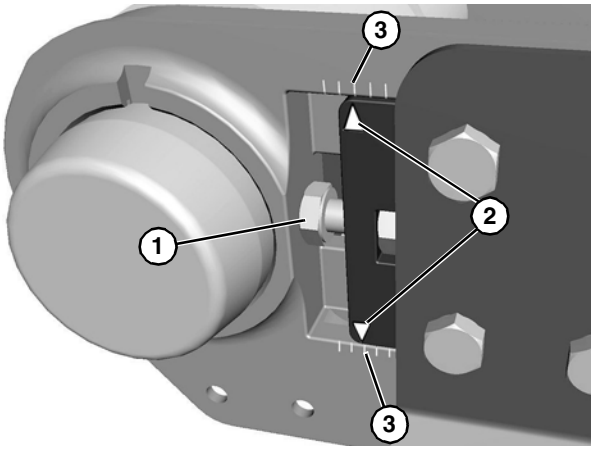


Figure 54

Center Drive Module Tracking

V-Guided Belts

V-guided belts do not require tracking adjustment.

Non V-Guided Belts

Non V-guided belt center drives are equipped with tracking bolts.

To adjust center drive tracking, with the conveyor running:

1. Inspect belt as it exits the center drive:

- Normally tracked belt, do nothing
- Tracking necessary, adjust tight side cam

2. If necessary, adjust the tracking bolt: loosen the center drive fastening screws **(Figure 55, item 1)** on the side of center drive to be tracked.

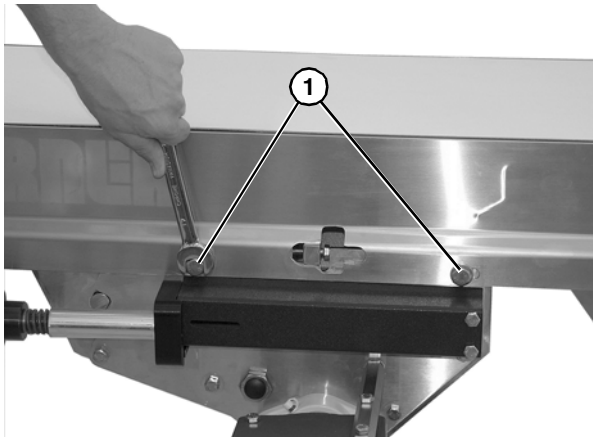


Figure 55

3. Rotate the tracking bolt **(Figure 56, item 1)** in small increments, each time inspecting the belt as it exits the center drive. Continue to rotate the tracking cam until conveyor belt is tracking normally.

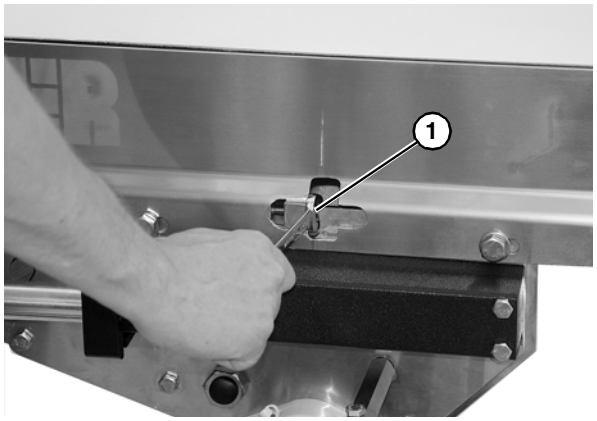


Figure 56

4. Tighten the center drive fastening screws **(Figure 55, item 1)** to 146 in-lbs (16.5 N m).

End Pulley Removal

⚠ WARNING

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

⚠ WARNING

Exposed moving parts can cause severe injury.
REMOVE COMPRESSED AIR SUPPLY before removing guards or performing maintenance.

1. Remove air supply and remove hose **(Figure 57, item 1)** from center drive.

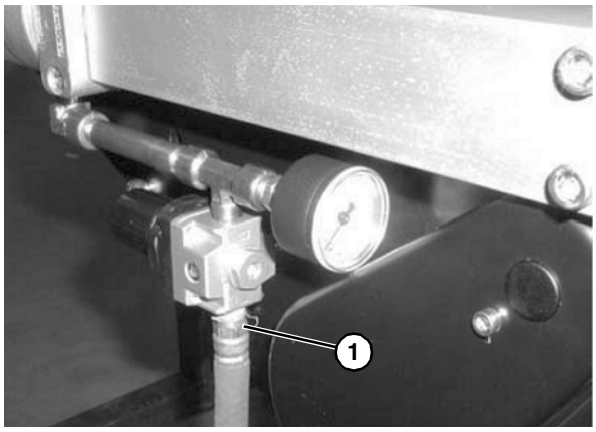


Figure 57

2. Remove screw **(Figure 58, item 1)** from each side of center drive from idler guard assembly.

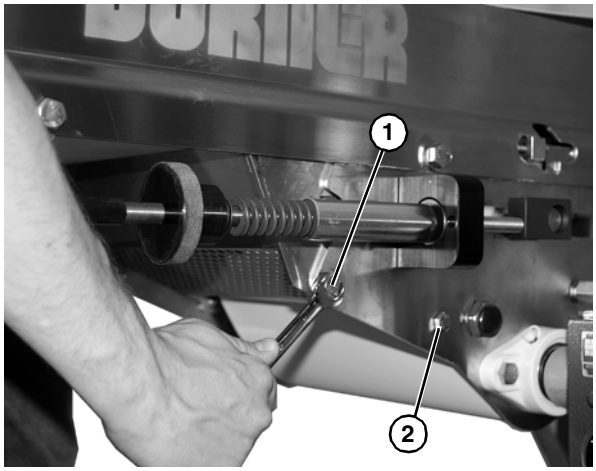


Figure 58

3. Loosen screw **(Figure 58, item 2)** from each side.
4. Swing down idler guard assembly **(Figure 59, item 1)**.

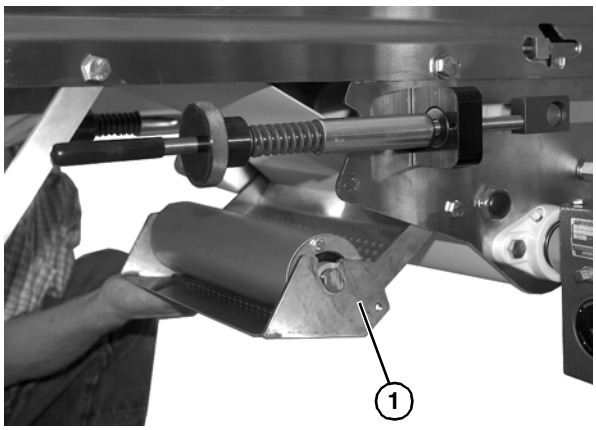


Figure 59

5. Remove the desired pulley following the corresponding instructions below:

- A - 3" Idler Pulley Removal
- B - Transfer Tail Pulley Removal

A – Idler Pulley Removal

⚠ WARNING

SEVERE HAZARD!

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

1. Remove conveyor belt. See “Conveyor Belt Replacement” on page 13.
2. Loosen the head plate bolt **(Figure 60, item 1)** so that bolt **(Figure 61, item 1)** is flush with pivot tail block **(Figure 61, item 2)**. Repeat on opposite side of the conveyor.

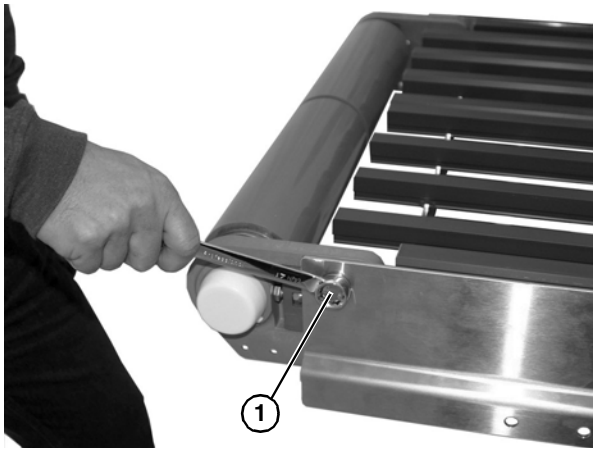


Figure 60

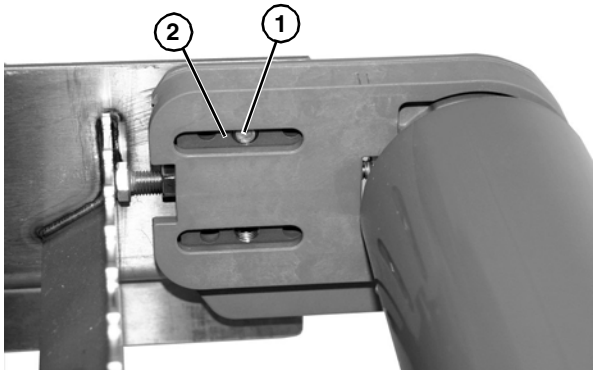


Figure 61

3. Slide the idler spindle assembly **(Figure 62, item 1)** off the pivot tail blocks **(Figure 62, item 2)**.

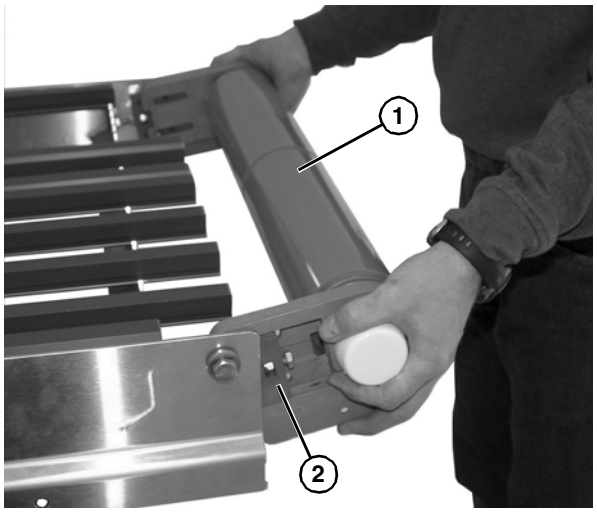


Figure 62

4. Remove the bearing cover **(Figure 63, item 1)**. Repeat on opposite side.

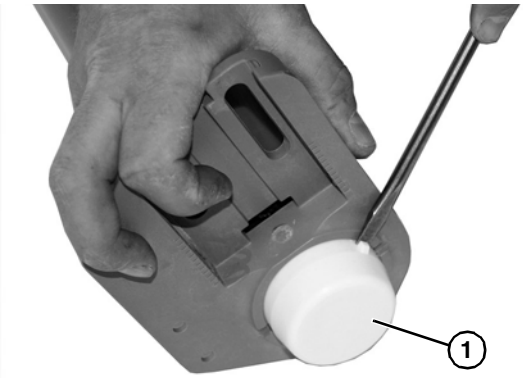


Figure 63

5. Loosen two set screws **(Figure 64, item 1)**.

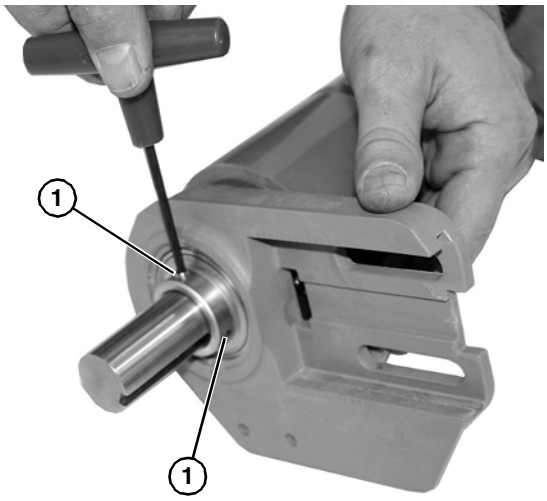


Figure 64

6. Slide the head plate with bearing **(Figure 65, item 1)** off the shaft **(Figure 65, item 2)**.

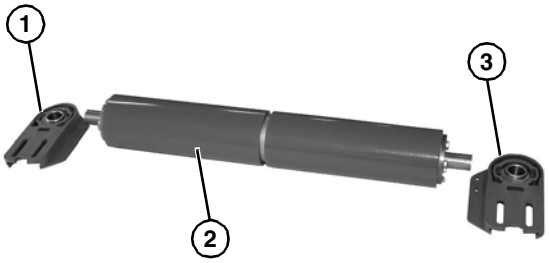


Figure 65

7. Repeat for opposite side head plate **(Figure 65, item 3)**.
8. If necessary, see "Bearing Replacement" on page 28 for replacing bearing in each head plate.
9. Install components in reverse order of removal.
10. Check level of head plate by placing a bed rail **(Figure 66, item 1)** onto top of conveyor frame and head plate.

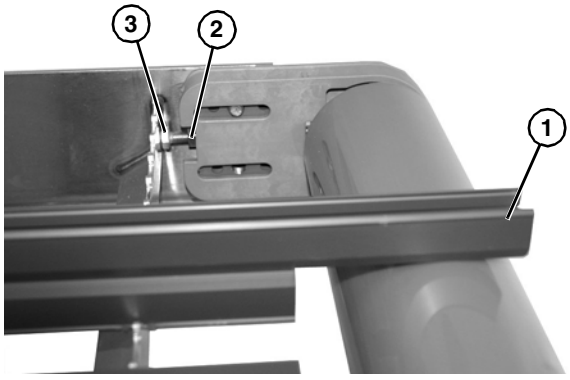


Figure 66

11. Loosen nut **(Figure 66, item 2)** and tighten or loosen bolt **(Figure 66, item 3)** to move head plate up or down to level with conveyor bed rail.

B – Transfer Tail Pulley Removal

⚠ WARNING

SEVERE HAZARD!

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

1. Remove conveyor belt. See "Conveyor Belt Replacement" on page 13.
2. Slide the transfer tail **(Figure 67, item 1)** off the pivot tail blocks **(Figure 67, item 2)**.

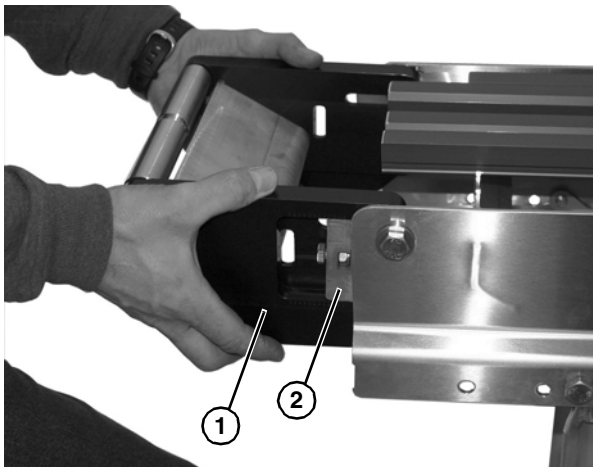


Figure 67

3. Remove head plate bolt **(Figure 68, item 1)** from each side.

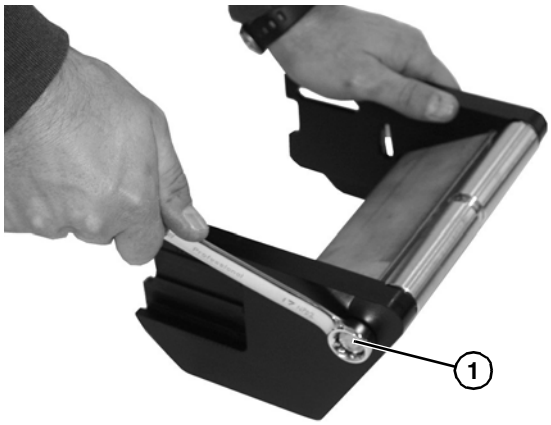


Figure 68

4. Slide off end plate **(Figure 69, item 1)**.

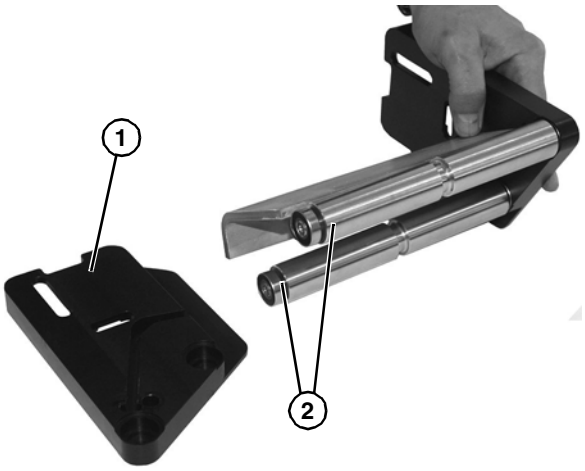


Figure 69

5. Remove idler roller bearing assemblies **(Figure 69, item 2)** from each end plate.

Center Drive Pulleys Removal

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

⚠ WARNING

Exposed moving parts can cause severe injury.

REMOVE COMPRESSED AIR SUPPLY before removing guards or performing maintenance.

- A - Tensioner Pulley Removal
- B - Idler Pulley Removal
- C - Drive Pulley Removal

A - Tensioner Pulley Removal

1. Remove air supply and remove hose **(Figure 70, item 1)** from center drive.

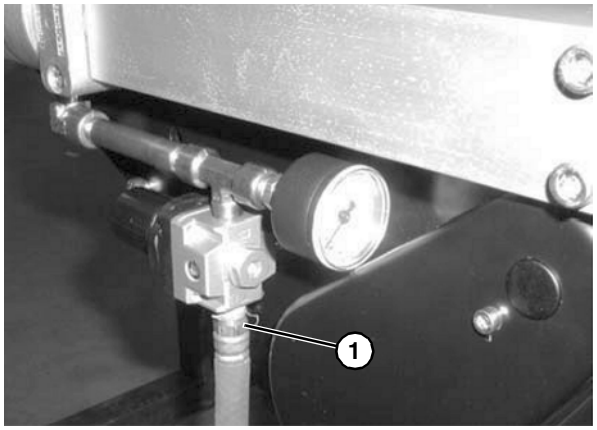


Figure 70

2. Rotate tensioning nut **(Figure 71, item 1)** on each side of center drive unit counterclockwise to remove all tension on belt.

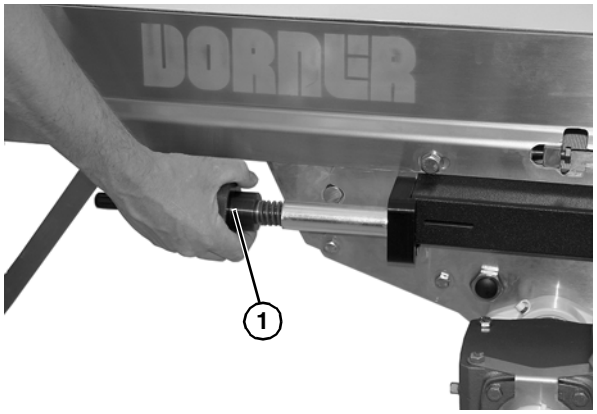


Figure 71

3. Remove two bolts **(Figure 72, item 1)** from cover **(Figure 72, item 2)**.

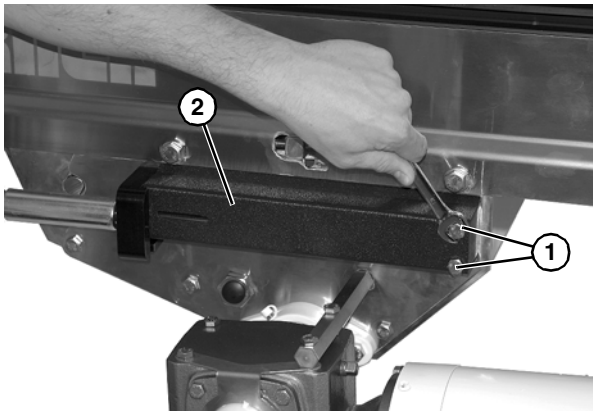


Figure 72

4. Remove cover **(Figure 73, item 1)** and spacer **(Figure 73, item 2)** from conveyor frame.

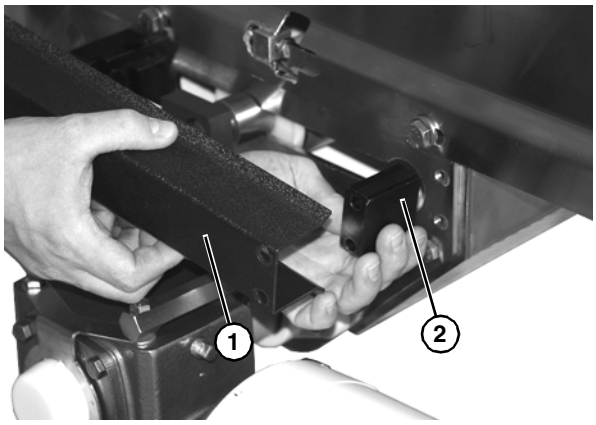


Figure 73

5. Remove two screws **(Figure 74, item 1)** from each side of center drive and remove stationary guard assembly **(Figure 74, item 2)**.

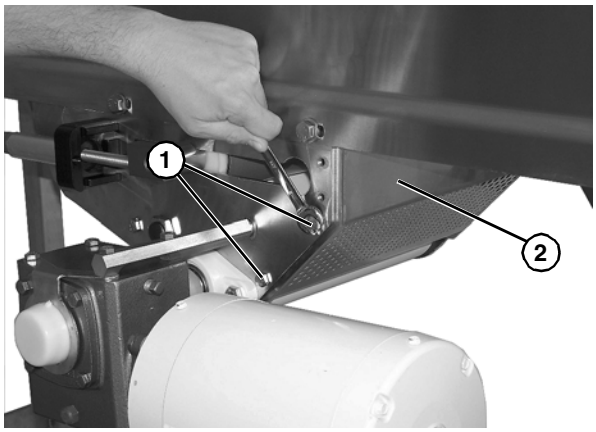


Figure 74

6. Loosen tension nut **(Figure 75, item 1)** on each side of center drive unit so that tensioner assembly shaft **(Figure 75, item 2)** aligns with hole **(Figure 75, item 3)**.

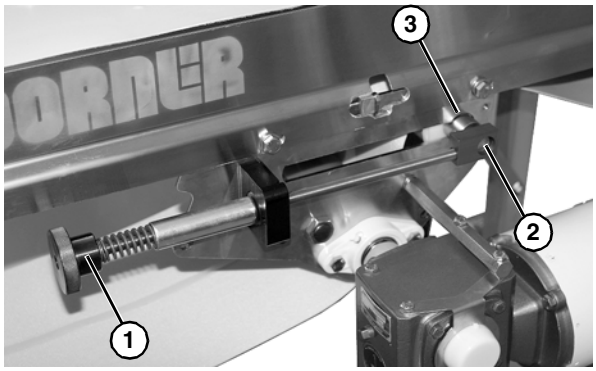


Figure 75

7. Loosen set screw **(Figure 76, item 1)** on locking collar **(Figure 76, item 2).**

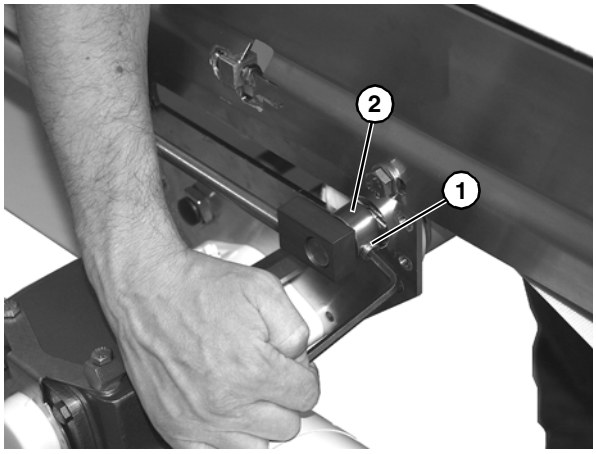


Figure 76

8. Slide in shaft **(Figure 77, item 1)** into locking collar **(Figure 77, item 2)** and remove tension block **(Figure 77, item 3)** from tensioner assembly shaft.

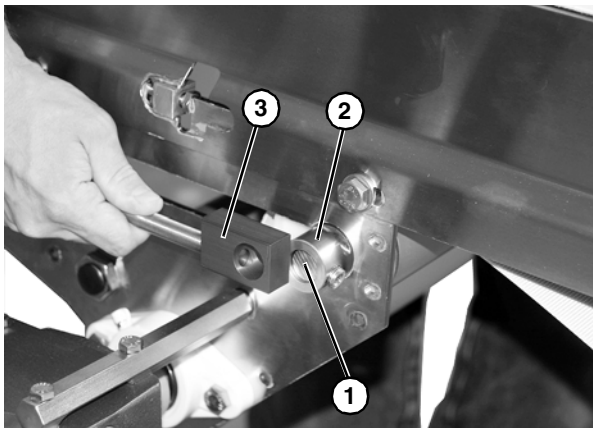


Figure 77

9. Remove locking collar **(Figure 78, item 1)** from tensioner assembly shaft **(Figure 78, item 2)**.

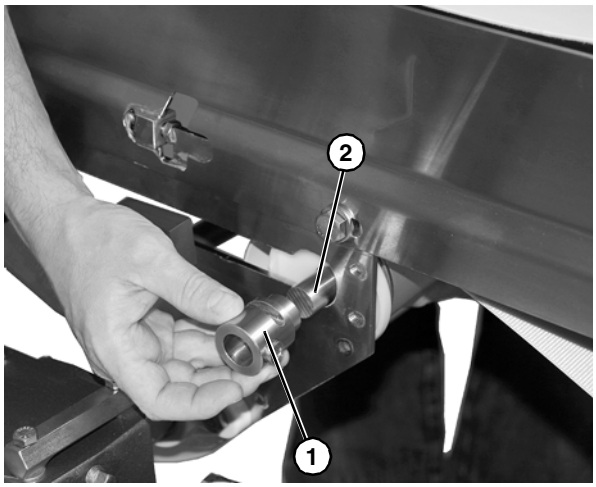


Figure 78

10. Slide shaft **(Figure 79, item 1)** into tensioner pulley **(Figure 79, item 2)**, and remove spacer plate **(Figure 79, item 3).**

NOTE

*When removing components, be sure to note the orientation of spacer plate **(Figure 79, item 3)** on each end of conveyor.*

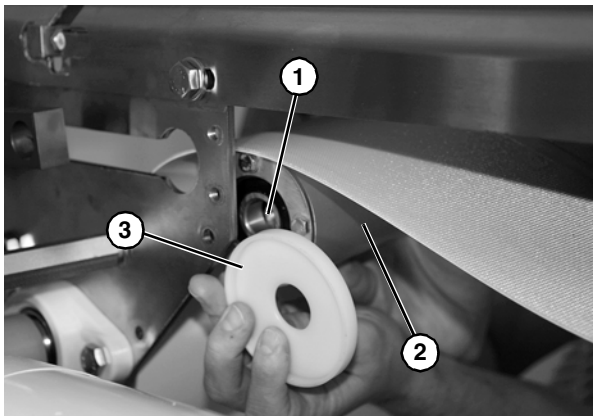


Figure 79

11. Remove tensioner pulley **(Figure 79, item 2)** and remaining spacer plate.
12. Remove shaft **(Figure 80, item 1)** from tensioner pulley **(Figure 80, item 2)**.

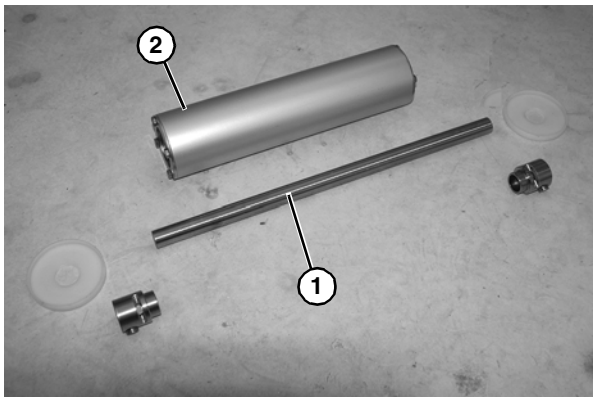


Figure 80

B - Idler Pulley Removal

1. Remove air supply and remove hose **(Figure 81, item 1)** from center drive.

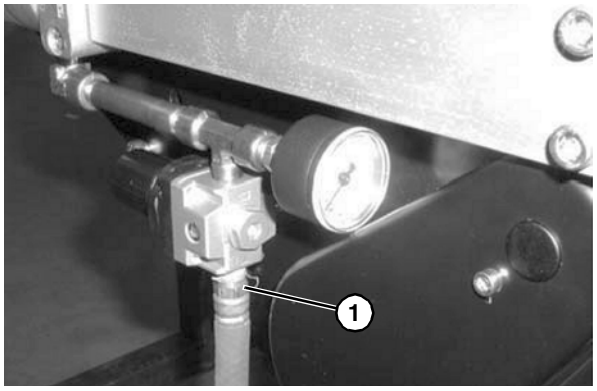


Figure 81

2. Rotate tensioning nut **(Figure 83, item 1)** on each side of center drive unit counterclockwise to remove all tension on belt

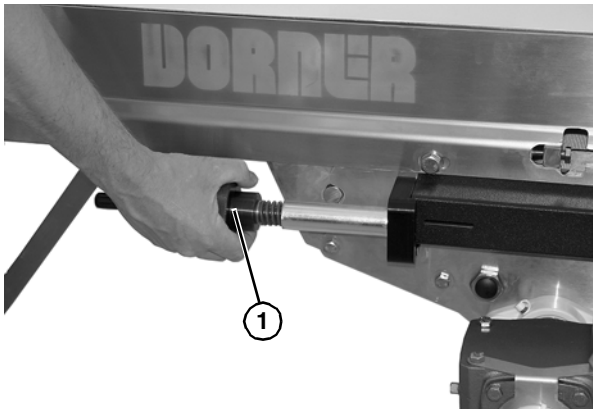


Figure 82

3. Remove screw **(Figure 83, item 1)** from each side of center drive from tension guard assembly.

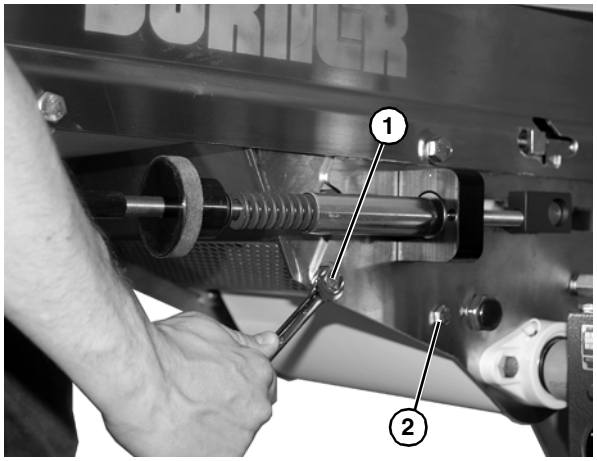


Figure 83

4. Loosen screw **(Figure 83, item 2)** from each side.

5. Swing down tension guard assembly **(Figure 84, item 1)**. Remove tensioner pulley **(Figure 84, item 2)**.

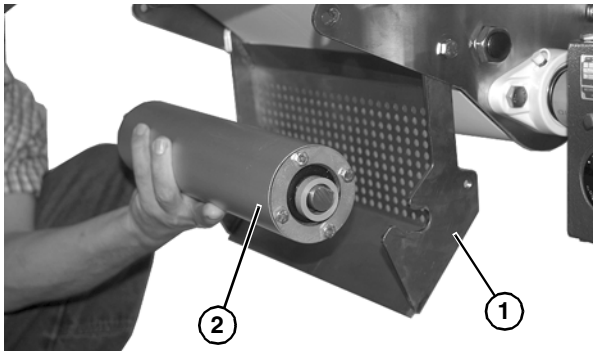


Figure 84

6. Remove the tension pulley spacers **(Figure 85, item 1)**, and pulley shaft **(Figure 85, item 2)** from the roller pulley shaft assembly **(Figure 85, item 3)**.

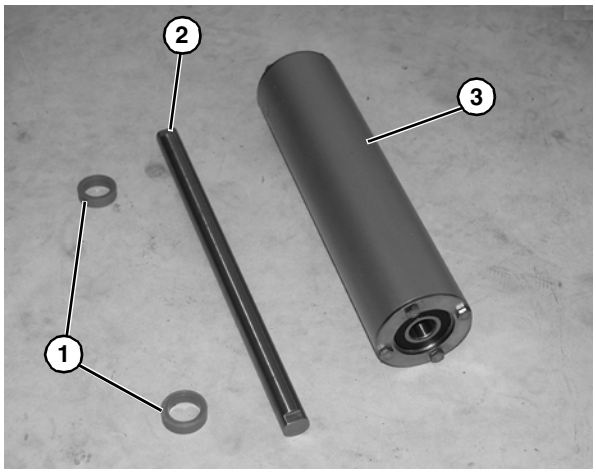


Figure 85

C – Drive Pulley Removal

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

1. Remove air supply and remove hose **(Figure 86, item 1)** from center drive.

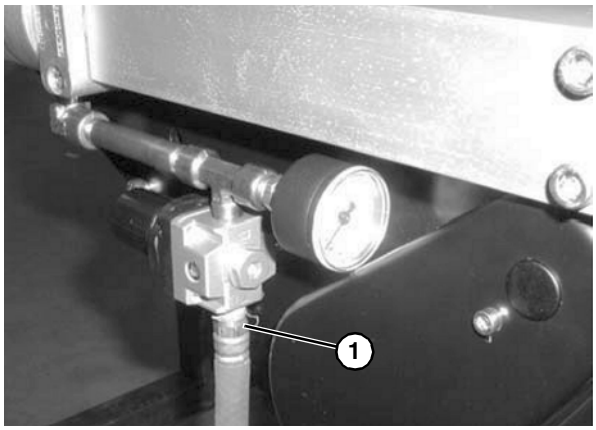


Figure 86

2. Rotate tensioning nut **(Figure 87, item 1)** on each side of center drive unit counterclockwise to remove all tension on belt.

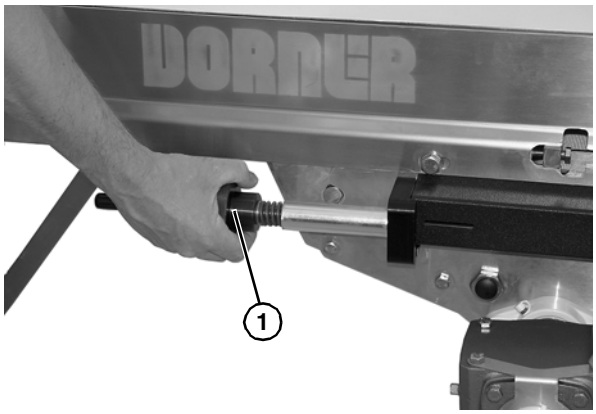


Figure 87

3. Reverse steps 4 thru 16 of the “Belt Removal” on page 13.

4. Loosen two set screws on outer gearmotor bearing **(Figure 88, item 1)** and through spacer **(Figure 88, item 2)** for inner gearmotor bearing.

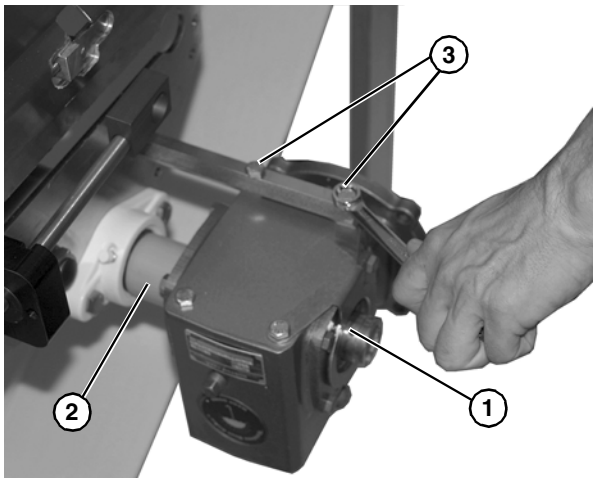


Figure 88

5. Remove two screws **(Figure 88, item 3)**, and remove gearmotor. (Gearhead shown with motor removed for clarity, motor can remain attached to gearhead.)

NOTE
Gearhead shown with motor removed for clarity, motor can remain attached to gearhead.

6. Loosen bearing set screw **(Figure 89, item 1)**.

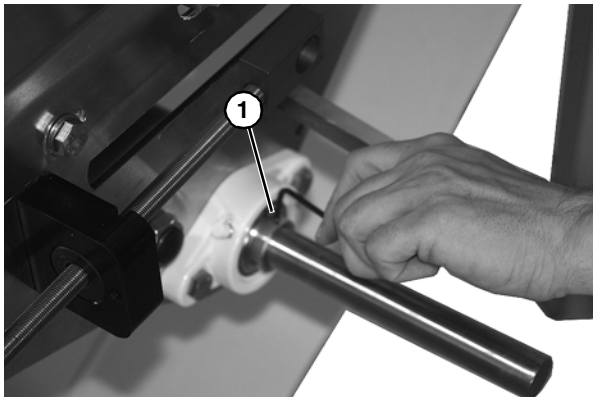


Figure 89

7. Remove two bolts **(Figure 90, item 1)** from retainer **(Figure 90, item 2)**.

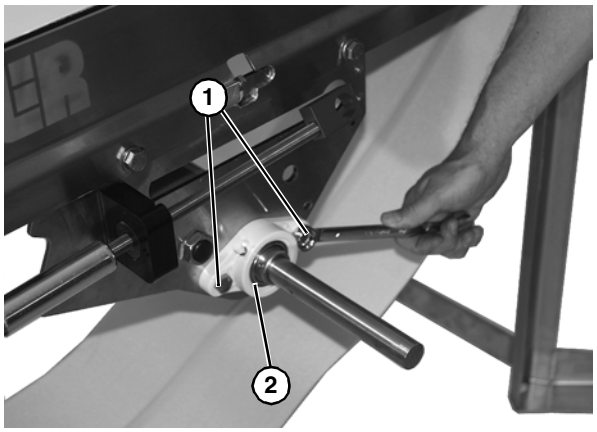


Figure 90

8. Remove key **(Figure 91, item 1)** and remove bearing collar **(Figure 91, item 2)**.

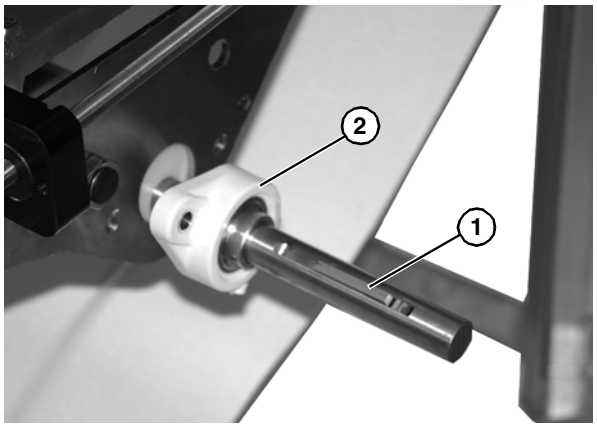


Figure 91

9. Remove nut **(Figure 92, item 1)**.

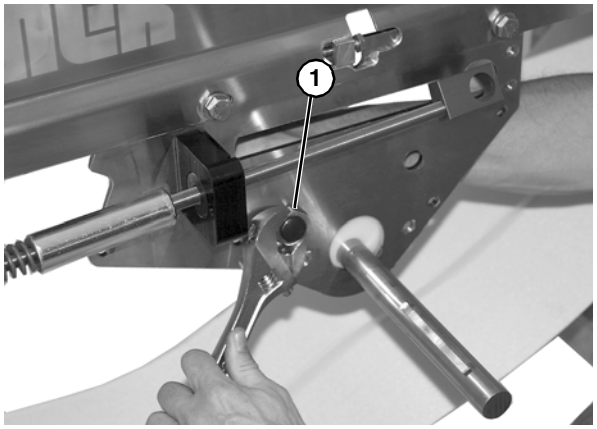


Figure 92

10. Remove nut **(Figure 93, item 1)**, and plug **(Figure 93, item 2)** from crosstube **(Figure 93, item 3)**.

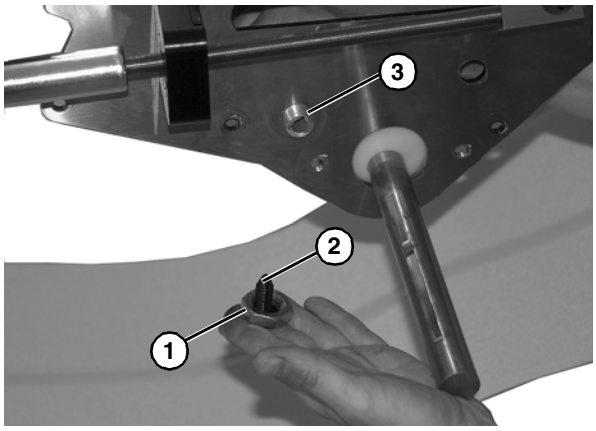


Figure 93

11. Remove two bolts **(Figure 94, item 1)** holding plate assembly **(Figure 94, item 2)** to conveyor.

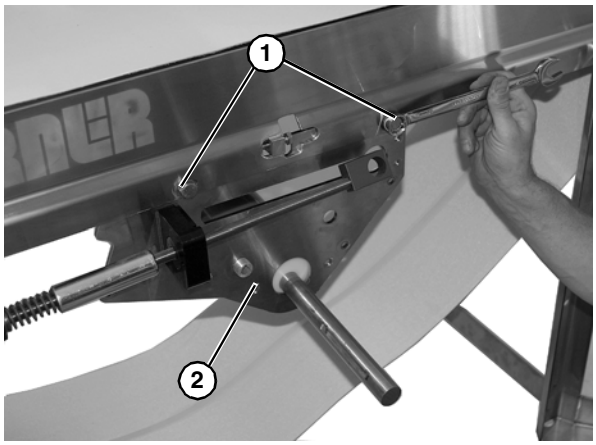


Figure 94

12. Remove plate assembly **(Figure 95, item 1)** from conveyor.

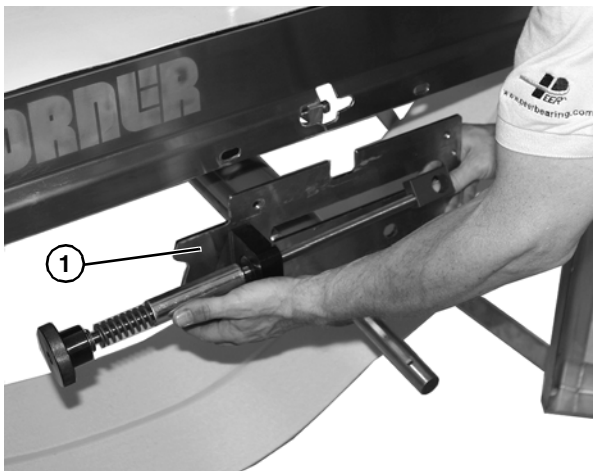


Figure 95

13. Slide drive pulley **(Figure 96, item 1)** out of remaining attached side plate.

NOTE

When removing components, be sure to note the orientation of spacer plate ***(Figure 96, item 2)*** *on each end of conveyor.*

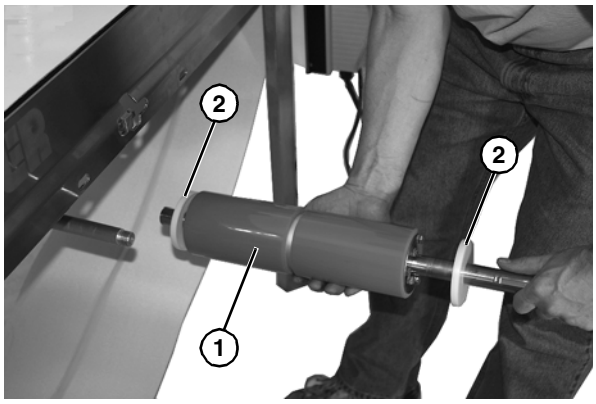


Figure 96

Bearing Replacement

⚠ WARNING

Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

⚠ WARNING

Exposed moving parts can cause severe injury.

REMOVE COMPRESSED AIR SUPPLY before removing guards or performing maintenance.

- A - Idler Bearing
- B - Drive Bearing
- C - Transfer Tail Bearing

⚠ WARNING

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

A - Idler Bearing Replacement

1. See "A - Idler Pulley Removal" on page 21. Follow steps 1 through 7.
2. Using a bearing removal tool **(Figure 97, item 1)** remove the bearing **(Figure 97, item 2)**.

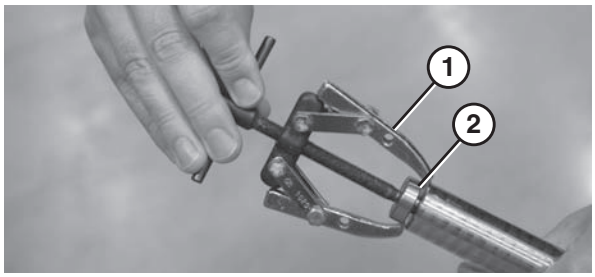


Figure 97

3. Press on new bearing.

⚠ CAUTION

Press on inner race only, pressing on outer race could damage bearing.

B - Transfer Bearing Replacement

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. See "B - Transfer Tail Pulley Removal" on page 22. Follow steps 1 through 5.
2. Turn bearing **(Figure 98, item 1)** to align with slots **(Figure 98, item 2)** in bearing housing. Then remove bearing.

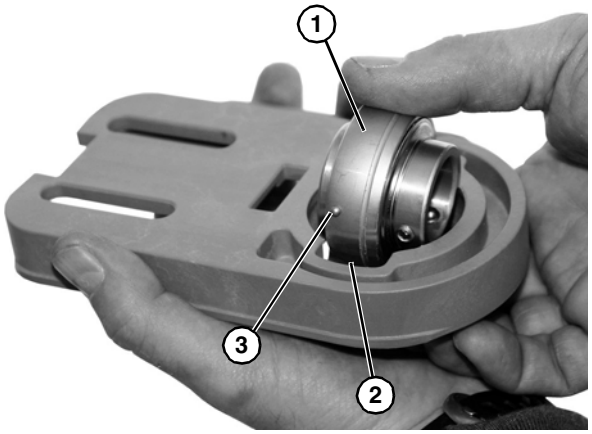


Figure 98

3. Inspect bearing housing bearing surface. If worn or damaged, replace. See "Service Parts" on page 30.
4. Insert bearing **(Figure 98, item 1)** into housing slot: Locate anti-rotation nub **(Figure 98, item 3)** to align with slot **(Figure 98, item 2)**, and twist bearing into housing.

C - Center Drive Bearing Replacement

The bearings in a 7360 Series Center Drive Assemblies can not be removed. Replace the entire pulley assembly when worn.

Pulley Replacement

Idler Pulley

To replace the idler pulley, reverse the "A - Idler Pulley Removal" on page 21 procedure.

Transfer Pulley

To replace the drive pulley, reverse the "B - Transfer Tail Pulley Removal" on page 22 procedure.

Center Drive Pulley

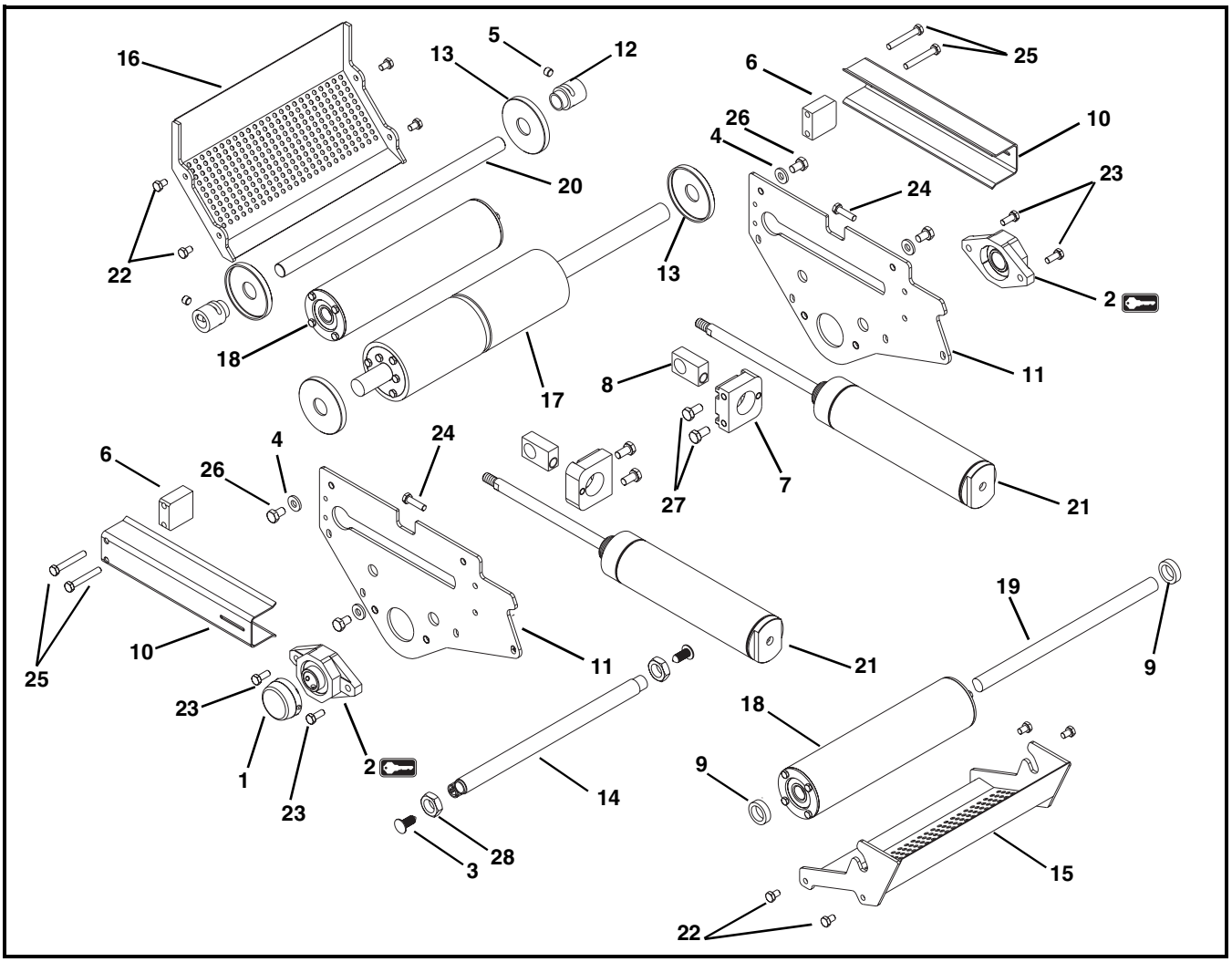
To replace the transfer tail pulley, reverse the "Center Drive Pulleys Removal" on page 23 procedure.

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.

Center Drive Components

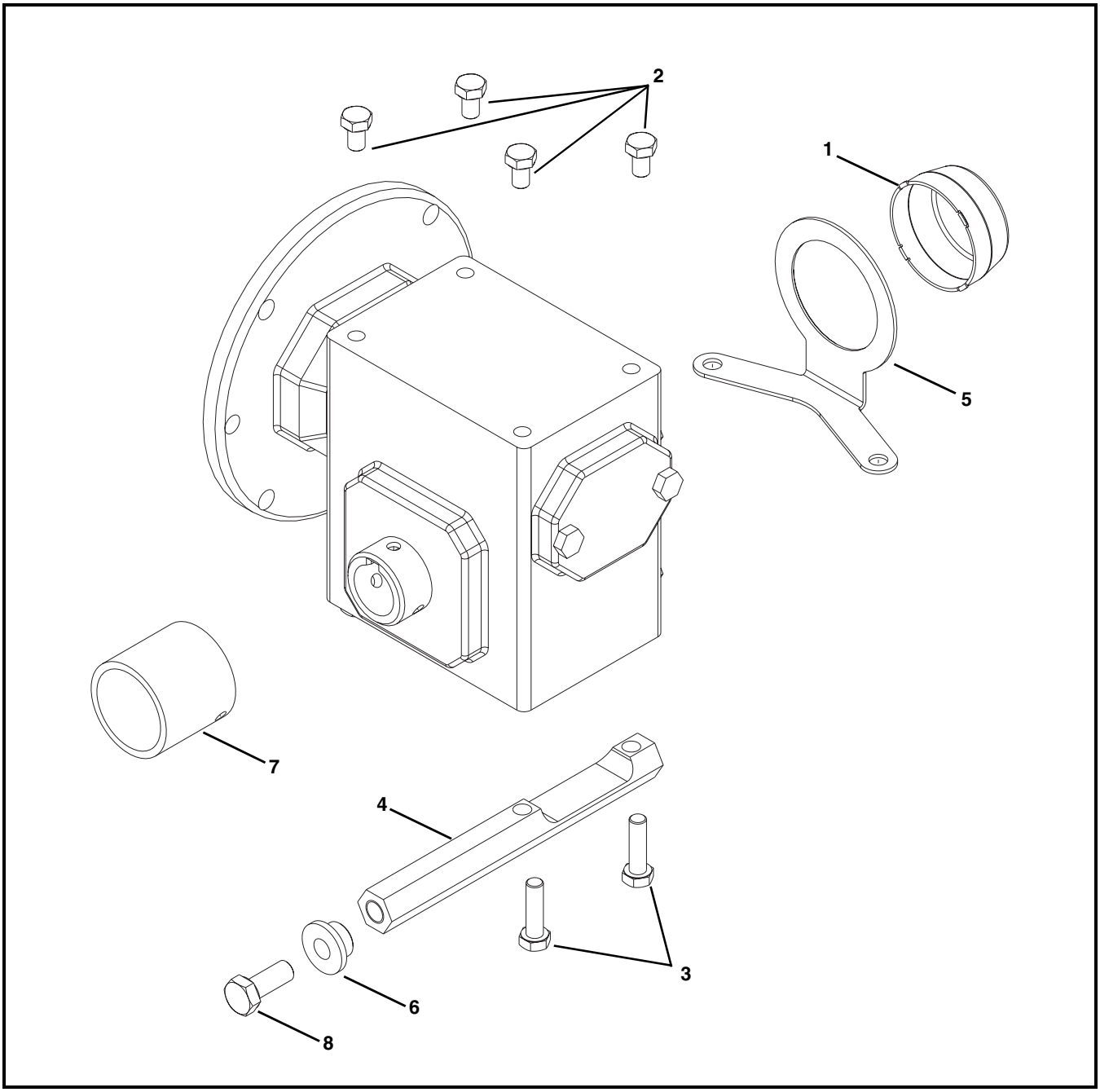


Item	Part Number	Description
1	807-1454	Cover
2	802-192	Bearing Assembly
3	807-1292	Rivet
4	807-1821	Washer
5	825-160	Plug
6	301216	Cylinder Guard Mounting Block
7	301355	Cylinder Mounting Block
8	301356	Cylinder Rod Mounting Block
9	532379	Spacer
10	532419	Rod Guard
11	532422	Side Plate
12	532426	Spacer
13	532427	Spindle Cover
14	532428-WW	Crosstube
15	514159-WW	Stationary Guard

Item	Part Number	Description
16	514160-WW	Tension Guard
17	532088-WW	Center Drive Spindle Assembly
18	532089-WW	Idler Spindle Assembly
19	532409-WW	Idler Shaft
20	532425-WW	Axle Shaft
21	301213	Pneumatic Tension Kit
	325906	Spring Tension Kit
22	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
23	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
24	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
25	960855MSS	Hex Head Cap Screw, M8-1.25 x 55 mm
26	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
27	961020MSS	Hex Head Cap Screw, M10-1.50 x 20 mm
28	992010MSS	Hex Nut, M20-2.50

WW = Conveyor width reference: 04 - 52 in 02 increments

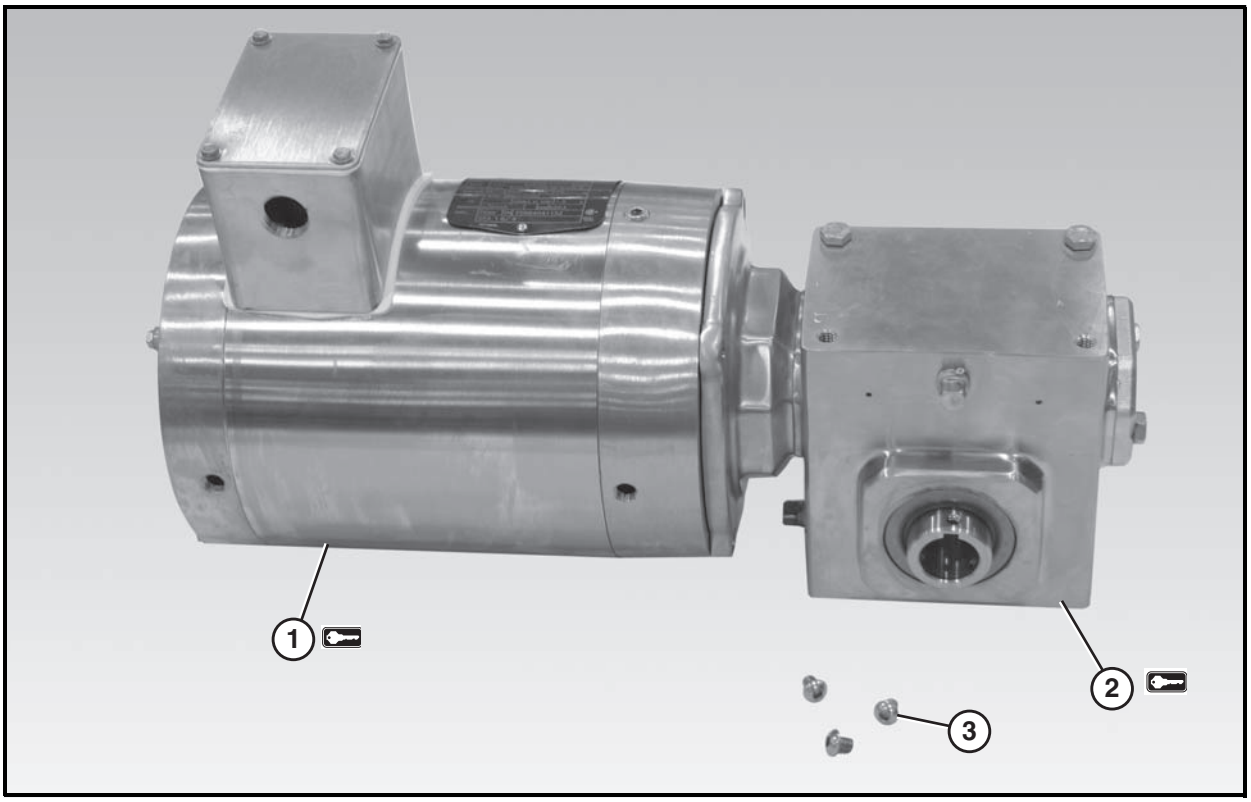
Center Drive Gearmotor Mounting Package



Item	Part Number	Description
1	807-1454	Cover
2	906-067SS	Hex Head Cap Screw, 5/16-18 x 0.50
3	908-070SS	Hex Head Cap Screw, 5/16-18 x 1.12
4	500485	Mounting Post
5	500492	Cover Bracket
6	532346	Bushing
7	532430	Shaft Guard
8	961025MSS	Hex Head Cap Screw, M10-1.50 x 25 mm

Service Parts

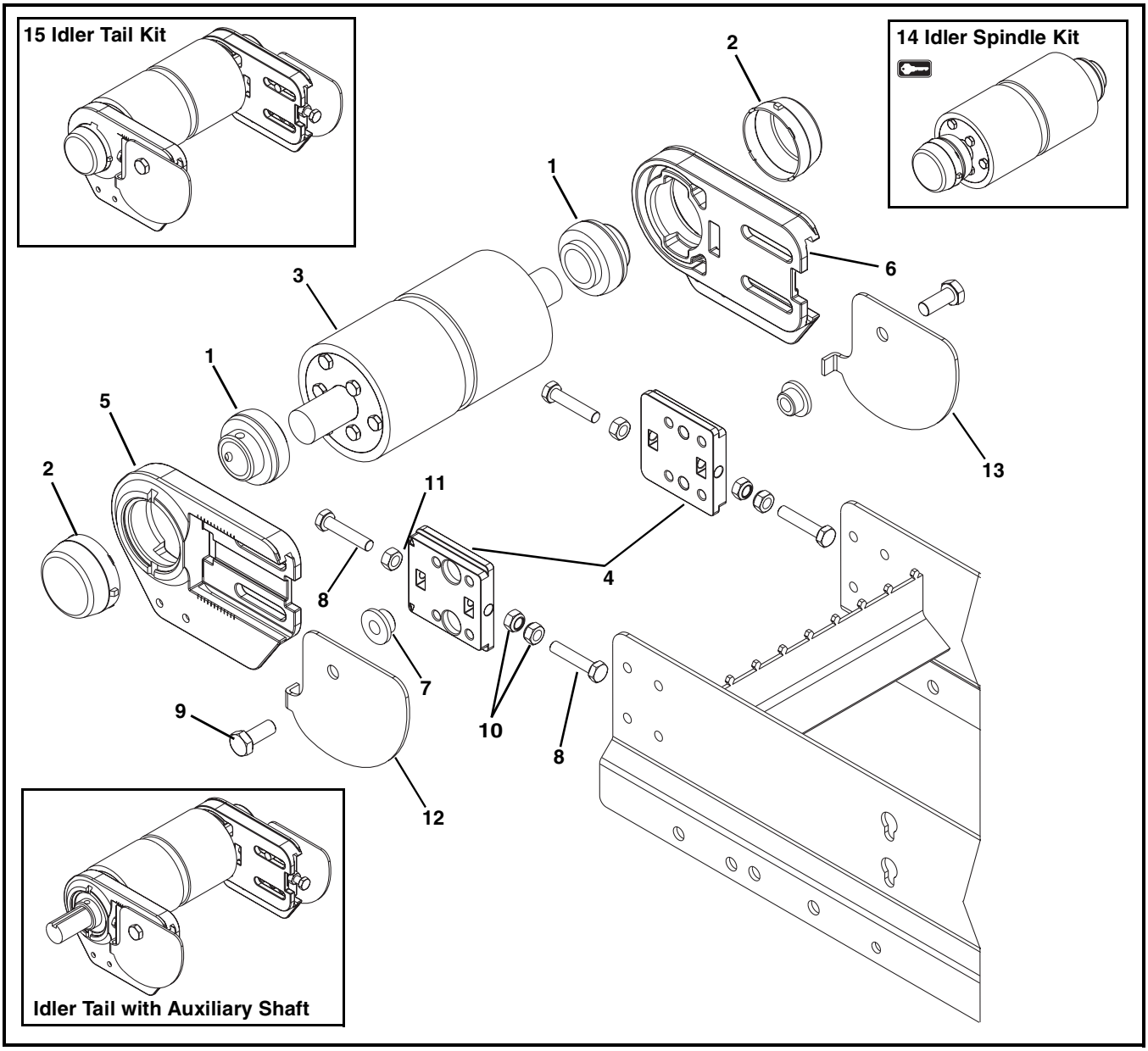
Gearmotor Assembly



Item	Part Number	Description
1	62MZ411	Painted Motor, 0.50 Hp (0.37Kw) 115 Volts, 60Hz, 1 Phase
	62MZ423	Painted Motor, 0.50 Hp (0.37Kw) 208-230/460 Volts, 6 to 60Hz, 3 Phase
	74MHS423-10	Painted Motor, 1.00 Hp (0.74Kw) 208-230/460 Volts, 6 to 60Hz, 3 Phase
	74MHS423-15	Painted Motor, 1.50 Hp (1.11Kw) 208-230/460 Volts, 6 to 60Hz, 3 Phase
	62MZS423	Stainless Steel Motor, 0.50 Hp (0.37Kw) 208-230/460 Volts, 6 to 60Hz, 3 Phase
	74MZS423-10	Stainless Steel Motor, 1.00 Hp (0.74Kw) 208-230/460 Volts, 6 to 60Hz, 3 Phase
	74MZS423-15	Stainless Steel Motor, 1.50 Hp (1.11Kw) 208-230/460 Volts, 6 to 60Hz, 3 Phase

Item	Part Number	Description
2	74M005HS	Painted Gear Reducer, 5:1, 56C
	74M007HS	Painted Gear Reducer, 7:1, 56C
	74M010HS	Painted Gear Reducer, 10:1, 56C
	74M015HS	Painted Gear Reducer, 15:1, 56C
	74M020HS	Painted Gear Reducer, 20:1, 56C
	74M030HS	Painted Gear Reducer, 30:1, 56C
	74M040HS	Painted Gear Reducer, 40:1, 56C
	74M060HS	Painted Gear Reducer, 60:1, 56C
	74M080HS	Painted Gear Reducer, 80:1, 56C
	74M005HZ	Stainless Steel Gear Reducer, 5:1, 56C
	74M007HZ	Stainless Steel Gear Reducer, 7:1, 56C
	74M010HZ	Stainless Steel Gear Reducer, 10:1, 56C
	74M015HZ	Stainless Steel Gear Reducer, 15:1, 56C
	74M020HZ	Stainless Steel Gear Reducer, 20:1, 56C
	74M030HZ	Stainless Steel Gear Reducer, 30:1, 56C
	74M040HZ	Stainless Steel Gear Reducer, 40:1, 56C
	74M060HZ	Stainless Steel Gear Reducer, 60:1, 56C
	74M080HZ	Stainless Steel Gear Reducer, 80:1, 56C
3	917-104	Stainless Steel Socket Head Cap Screw 10-32 x 0.25 for Painted Gearmotor
	916-126	Stainless Steel Button Head Cap Screw 1/4-20 x 0.31 for Stainless Steel Gearmotor

Idler End Components

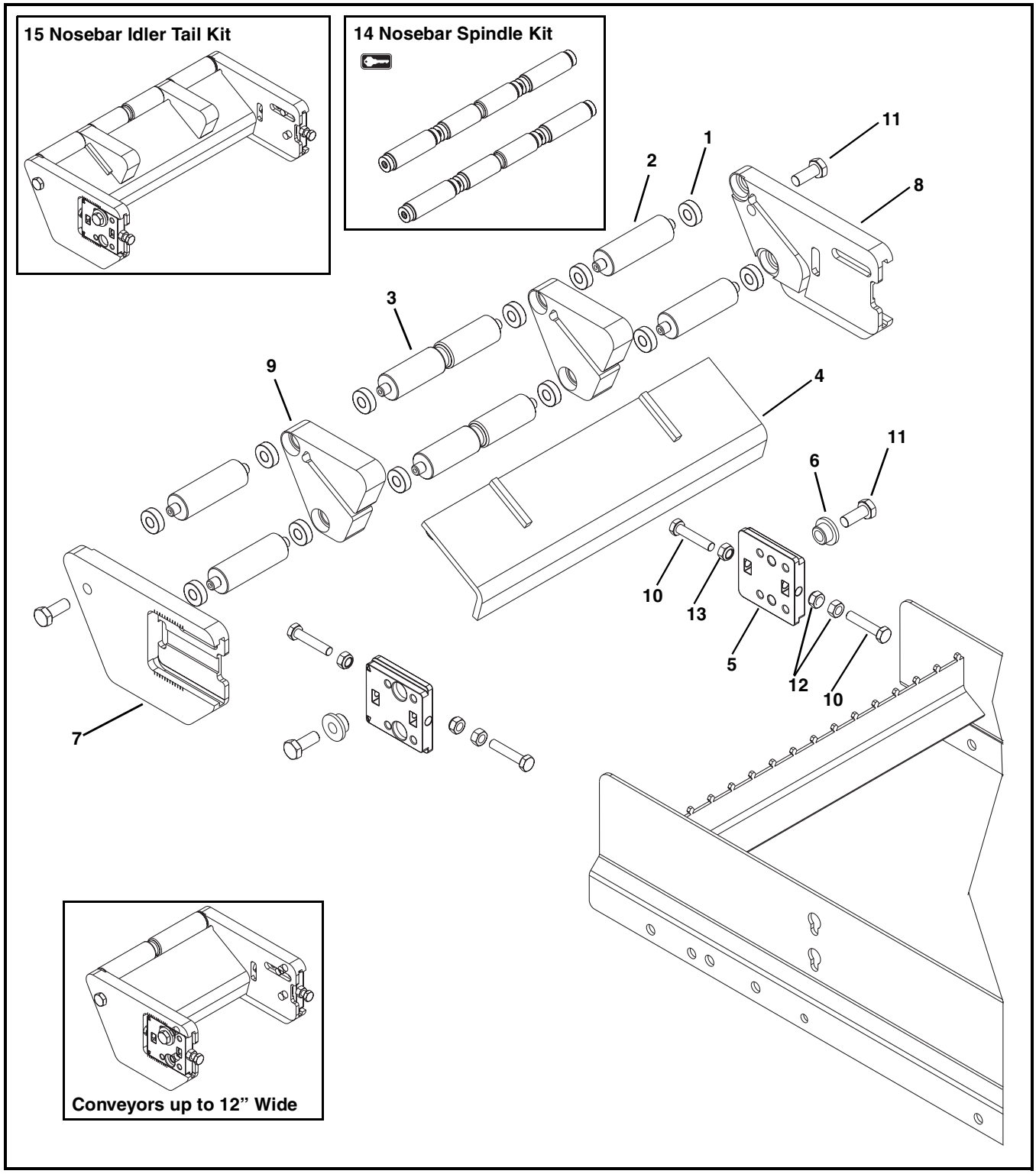


Item	Part Number	Description
1	802-161	Bearing
2	807-1454	Bearing Cover
3	532090-WW	Spindle Assembly
	532091-WW	Spindle Assembly with Auxiliary Shaft
4	532295	Pivot Tail Block
5	532298	Headplate for A and C Position
6	532299	Headplate for B and D Position
7	532346	Pivot Bushing
8	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
9	961030MSS	Hex Head Cap Screw, M10-1.50 x 30 mm
10	990801MSS	Hex Nut, M8-1.25

Item	Part Number	Description
11	990802MSS	Hex Nut, M8-1.25
12	532393	Pinch Guard, for Tip Up Tail A and C Position
13	532394	Pinch Guard, for Tip Up Tail B and D Position
14	736TS3-WW	Idler Spindle Kit (Includes Items 1 through 3)
	736TS3A-WW	Idler Spindle with Auxiliary Shaft Kit (Includes Items 1 through 3)
15	736TK3-WW	Idler Tail Kit (Includes Items 1 through 13)
	736TK3A-WW	Idler Tail with Auxiliary Shaft Kit (Includes Items 1 through 13)
WW = Conveyor width reference: 04 - 52 in 02 increments		

Service Parts

Nose Bar Idler End Components



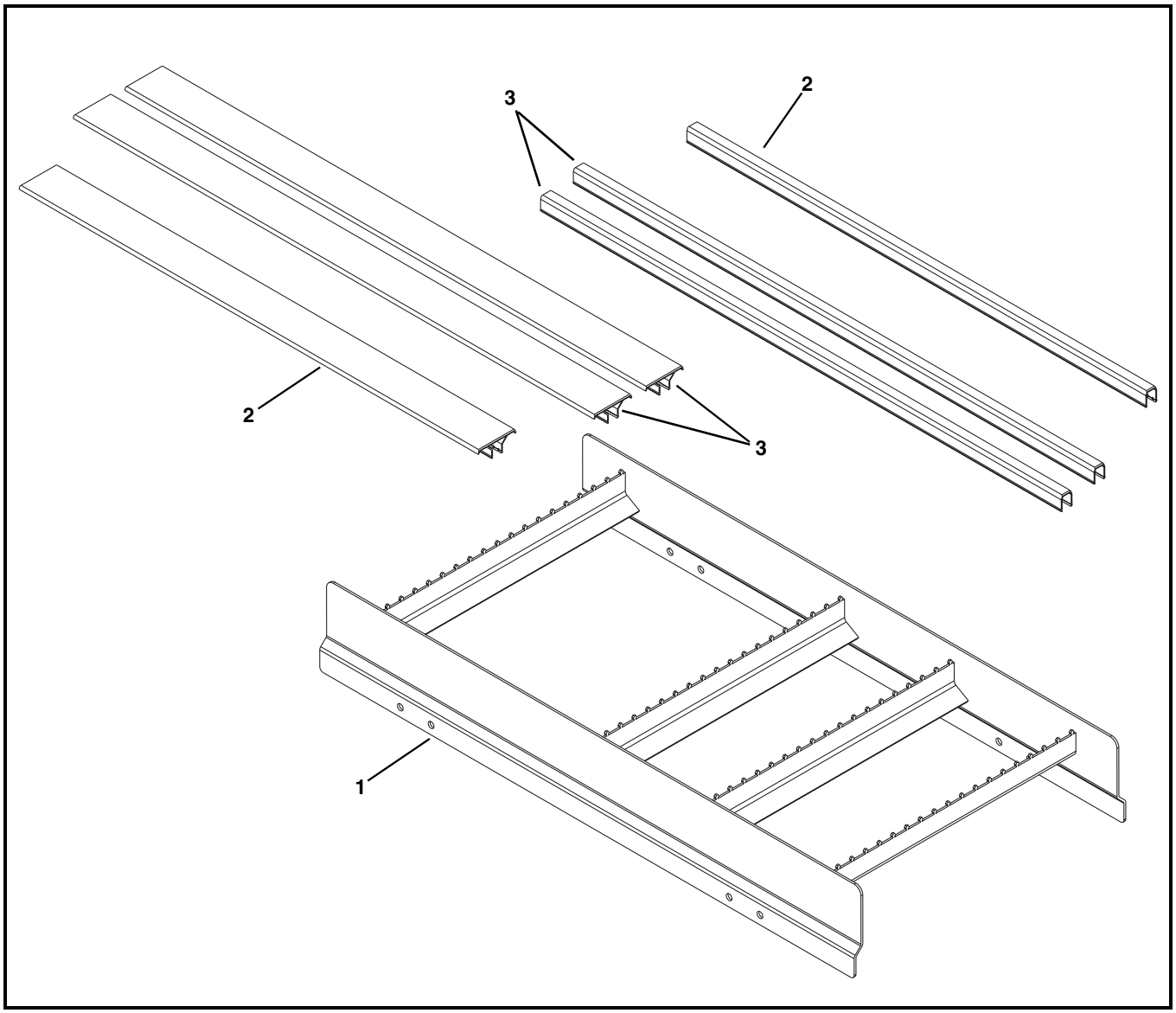
Item	Part Number	Description
1	802-123	Bearing
2	See Spindle Chart	Nosebar Spindle (for conveyors 14" wide and wider)
3	See V-Guide Spindle Chart	Center V-Guide Nosebar Spindle
4	532092-WW	Support Assembly
5	532295	Pivot Block
6	532346	Pivot Bushing
7	532347	Nosebar Headplate for A and C Position
8	532348	Nosebar Headplate for B and D Position
9	532349	Nosebar Puck (for conveyors 14" wide and wider)
10	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
11	961025MSS	Hex Head Cap Screw, M10-1.50 x 25 mm
12	990801MSS	Hex Nut, M8-1.25
13	990802MSS	Hex Nut, M8-1.25
14	736TS1-WW	Nosebar Idler Spindle Kit (Includes Items 1 through 3)
15	736TK1-WW	Nosebar Idler Tail Kit (Includes Items 1 through 13)
WW = Conveyor width reference: 04 – 52 in 02 increments		

Spindle Chart	
Conveyor Width	**Spindle**
4" (102 mm)	N/A
6" (152 mm)	N/A
8" (203 mm)	N/A
10" (254 mm)	N/A
12" (305 mm)	N/A
14" (356 mm)	505103
16" (406 mm)	505103
18" (457 mm)	505103
20" (508 mm)	505103
22" (559 mm)	505104
24" (610 mm)	505104
26" (660 mm)	505104
28" (711 mm)	505104
30" (762 mm)	505106
32" (813 mm)	505106
34" (864 mm)	505106
36" (914 mm)	505106
38" (965 mm)	505104
40" (1016 mm)	505104
42" (1067 mm)	505104
44" (1118 mm)	505104
46" (1168 mm)	505105
48" (1219 mm)	505105
50" (1270 mm)	505105
52" (1321 mm)	505105

V- Guide Spindle Chart	
Conveyor Width	**Spindle**
4" (102 mm)	532413
6" (152 mm)	505107
8" (203 mm)	505108
10" (254 mm)	505109
12" (305 mm)	505110
14" (356 mm)	505107
16" (406 mm)	505108
18" (457 mm)	505109
20" (508 mm)	505110
22" (559 mm)	505107
24" (610 mm)	505108
26" (660 mm)	505109
28" (711 mm)	505110
30" (762 mm)	505107
32" (813 mm)	505108
34" (864 mm)	505109
36" (914 mm)	505110
38" (965 mm)	505107
40" (1016 mm)	505108
42" (1067 mm)	505109
44" (1118 mm)	505110
46" (1168 mm)	505107
48" (1219 mm)	505108
50" (1270 mm)	505109
52" (1321 mm)	505110

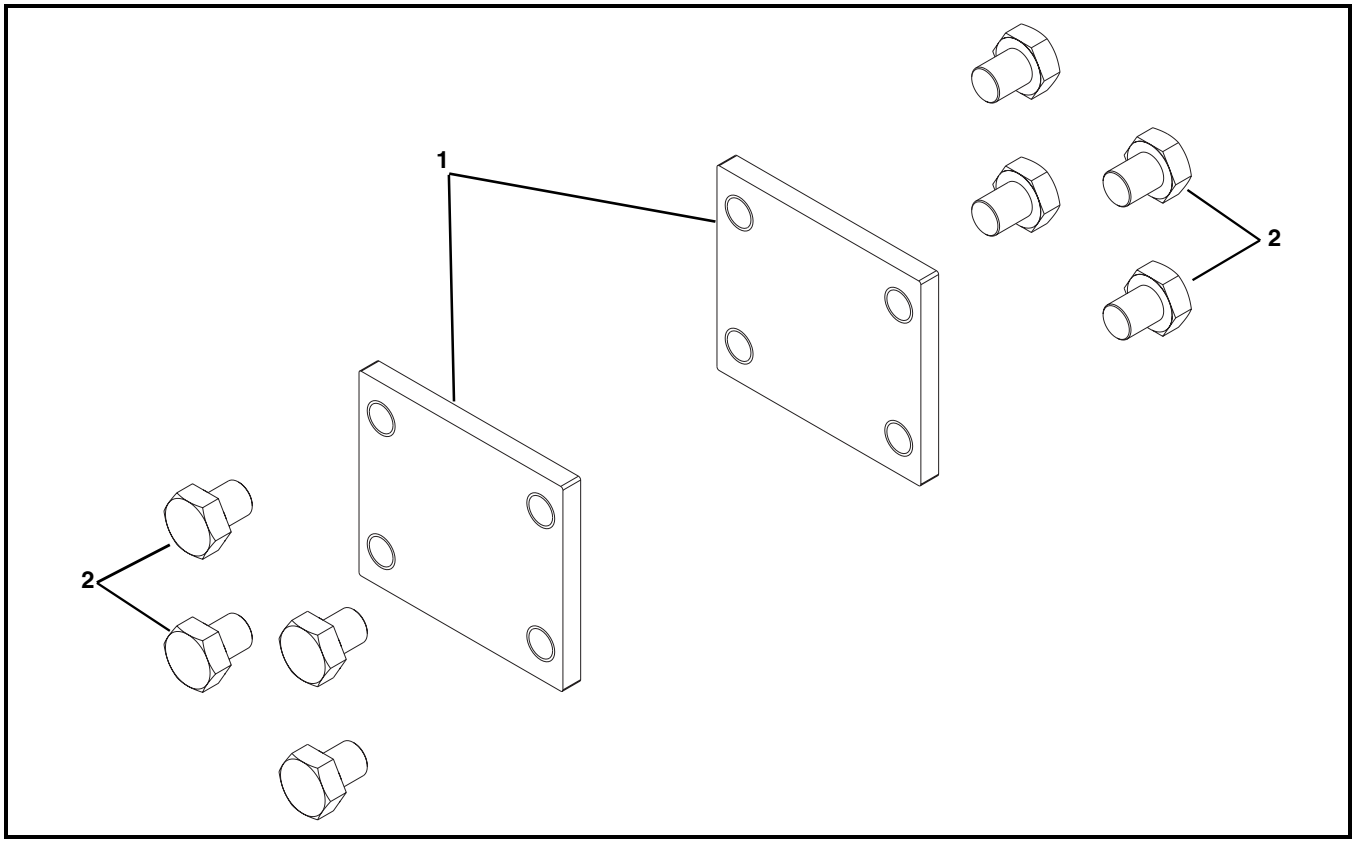
Service Parts

Frame Assembly



Item	Part Number	Description
1	----------	Consult Factory for Frame Part Number
2	532311-LLLLL-025	Outer Bed Rail
	532312-LLLLL-025	3" Wide Outer Bed Rail
3	532311-LLLLL-250	Center Bed Rail for Straight Conveyors and Z-Frame Conveyors less than 30°
	532312-LLLLL-250	3" Center Bed Rail for Straight Conveyors and Z-Frame Conveyors less than 30°
	532311-LLLLL-350	Center Bed Rail for Z-Frame Conveyors 30° and greater
	532312-LLLLL-350	3" Center Bed Rail for Z-Frame Conveyors 30° and greater
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 36.25" LLLLL = 03625		

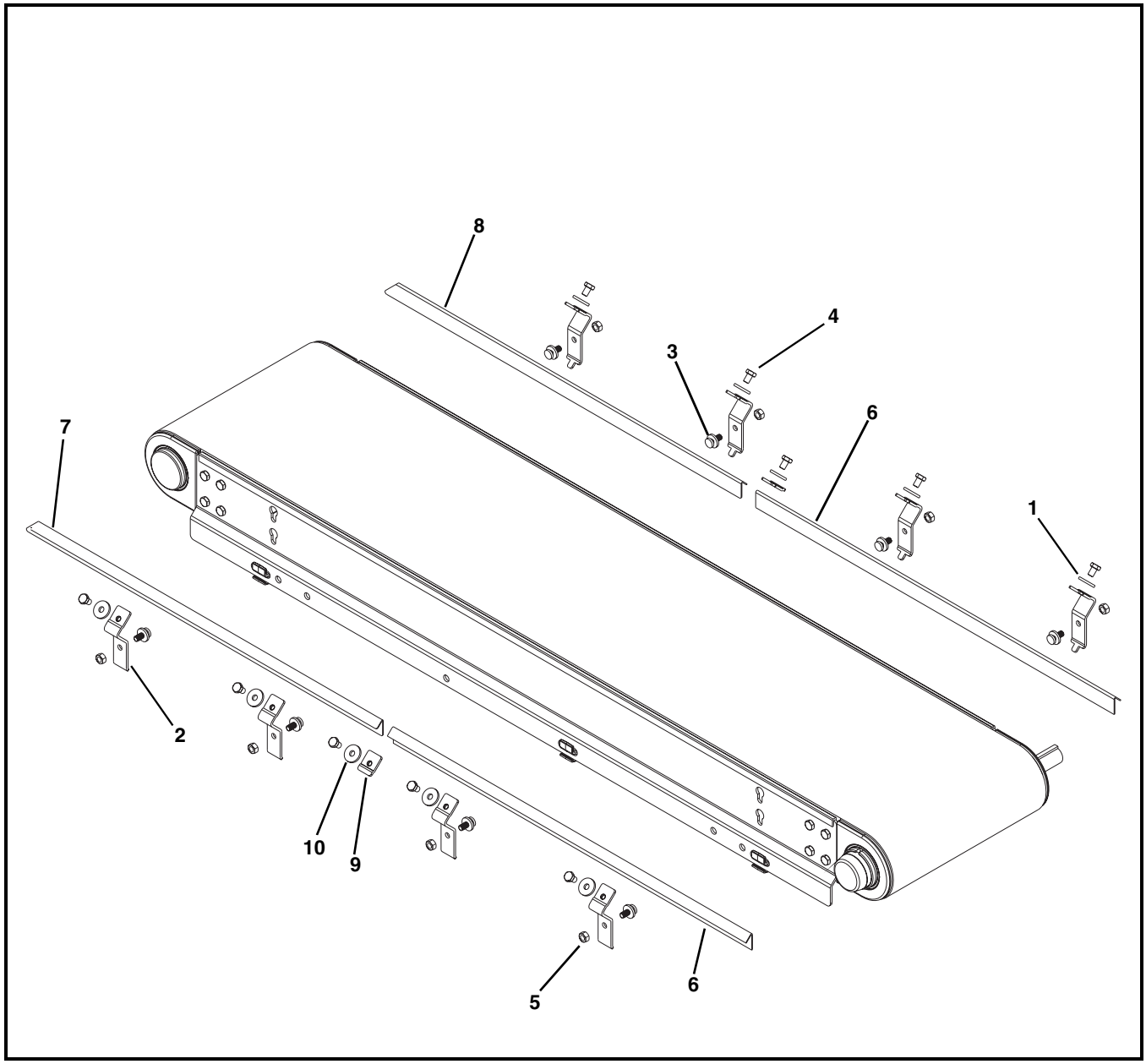
Connecting Assembly



Item	Part Number	Description
1	532157	Connector Plate
2	961012MSS	Hex Head Cap Screw, M10-1.50 x 12 mm

Service Parts

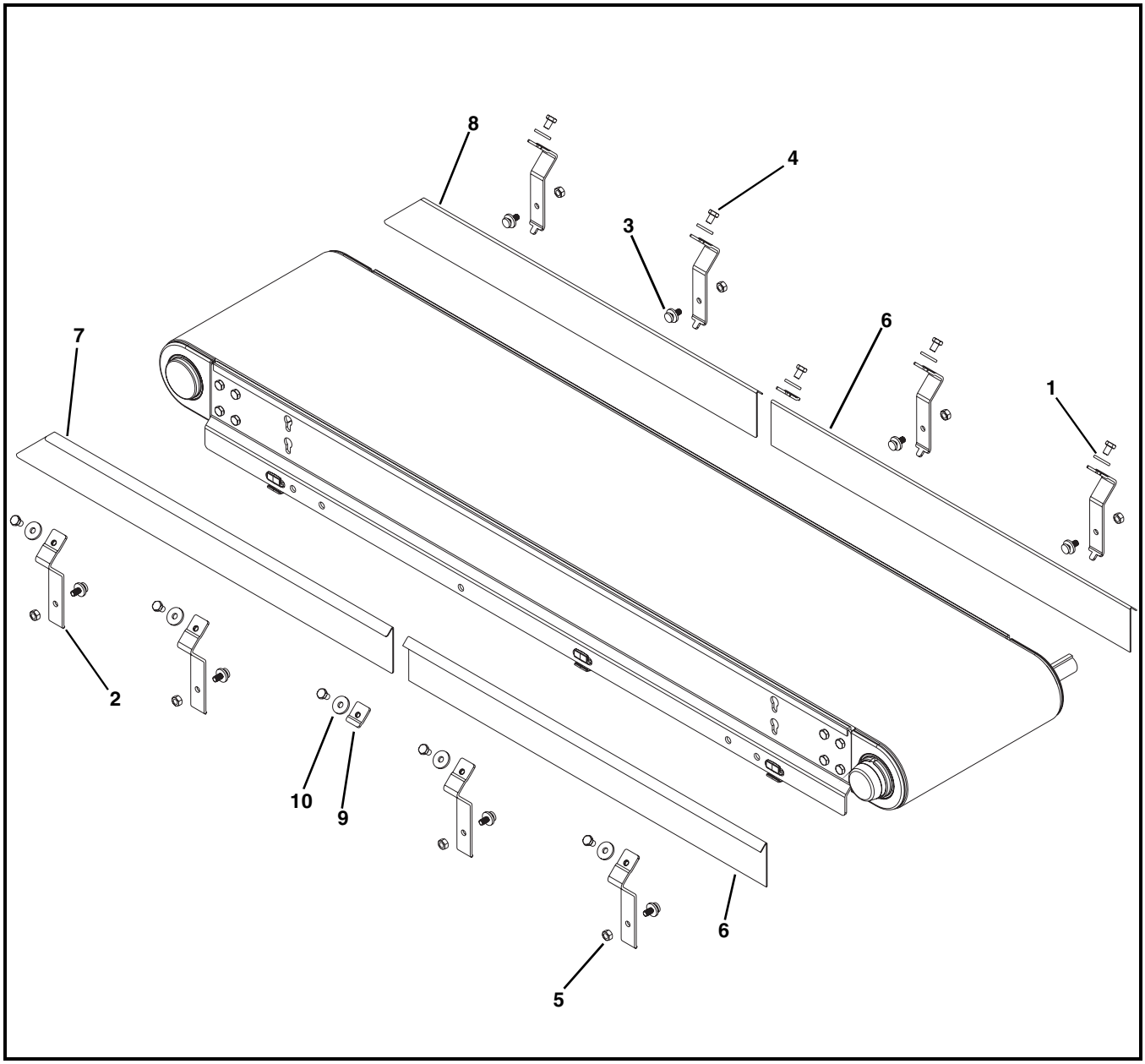
1" (25 mm) High Sides



Item	Part Number	Description
1	807-1821	Washer
2	532183	1" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532175-LLLLL	Guiding Straight

Item	Part Number	Description
7	532176-LLLLL	Guiding Left Hand
8	532177-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

3" (76 mm) High Sides

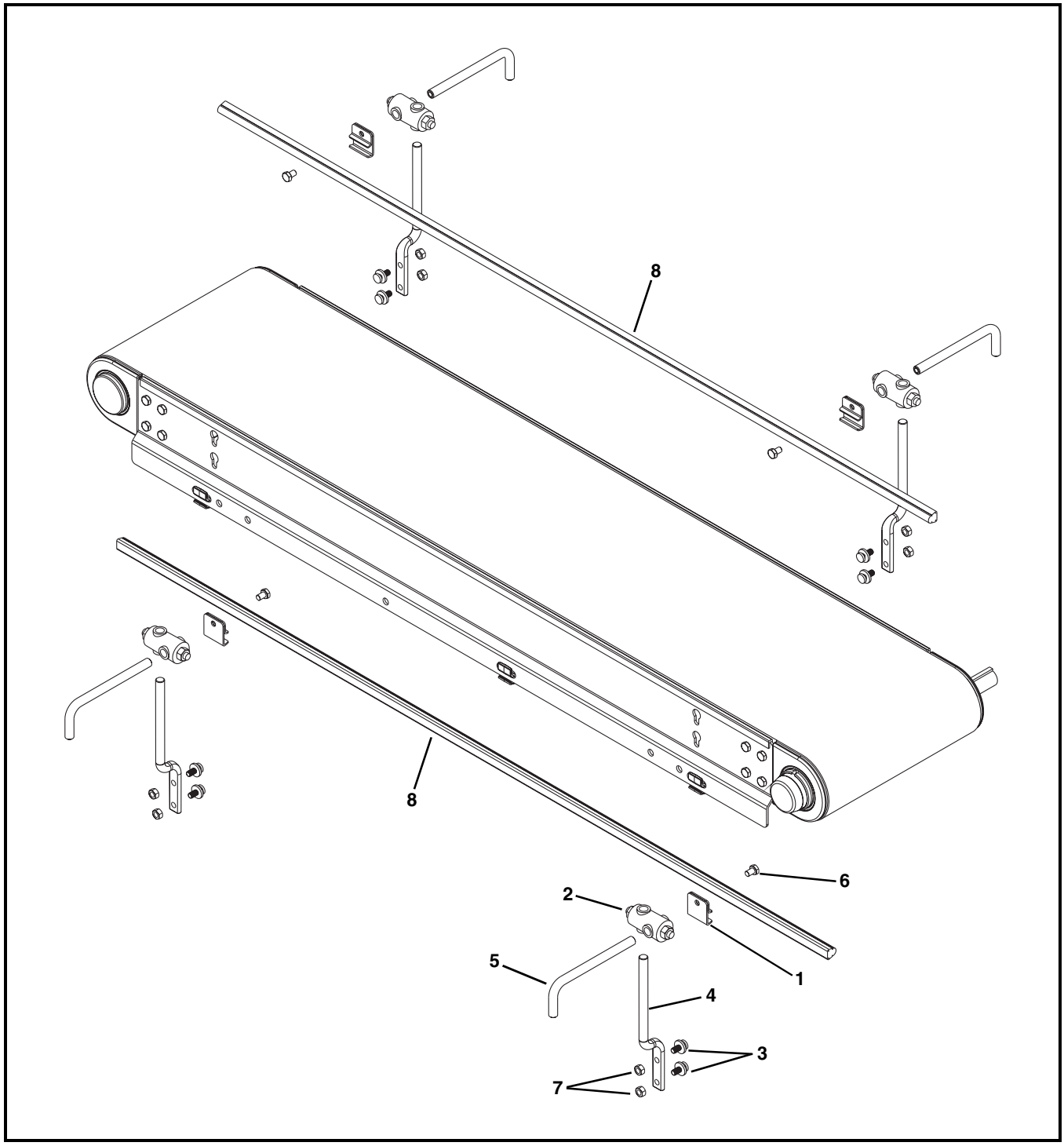


Item	Part Number	Description
1	807-1821	Washer
2	532185	3" Bracket
3	532191	Carriage Bolt, M8 x 20 mm
4	960812M	Hex Head Cap Screw, M8-1.25 x 12 mm
5	990801MSS	Hex Nut
6	532172-LLLLL	Guiding Straight

Item	Part Number	Description
7	532173-LLLLL	Guiding Left Hand
8	532174-LLLLL	Guiding Right Hand
9	532196	Connecting Clip
10	807-1838	Washer
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

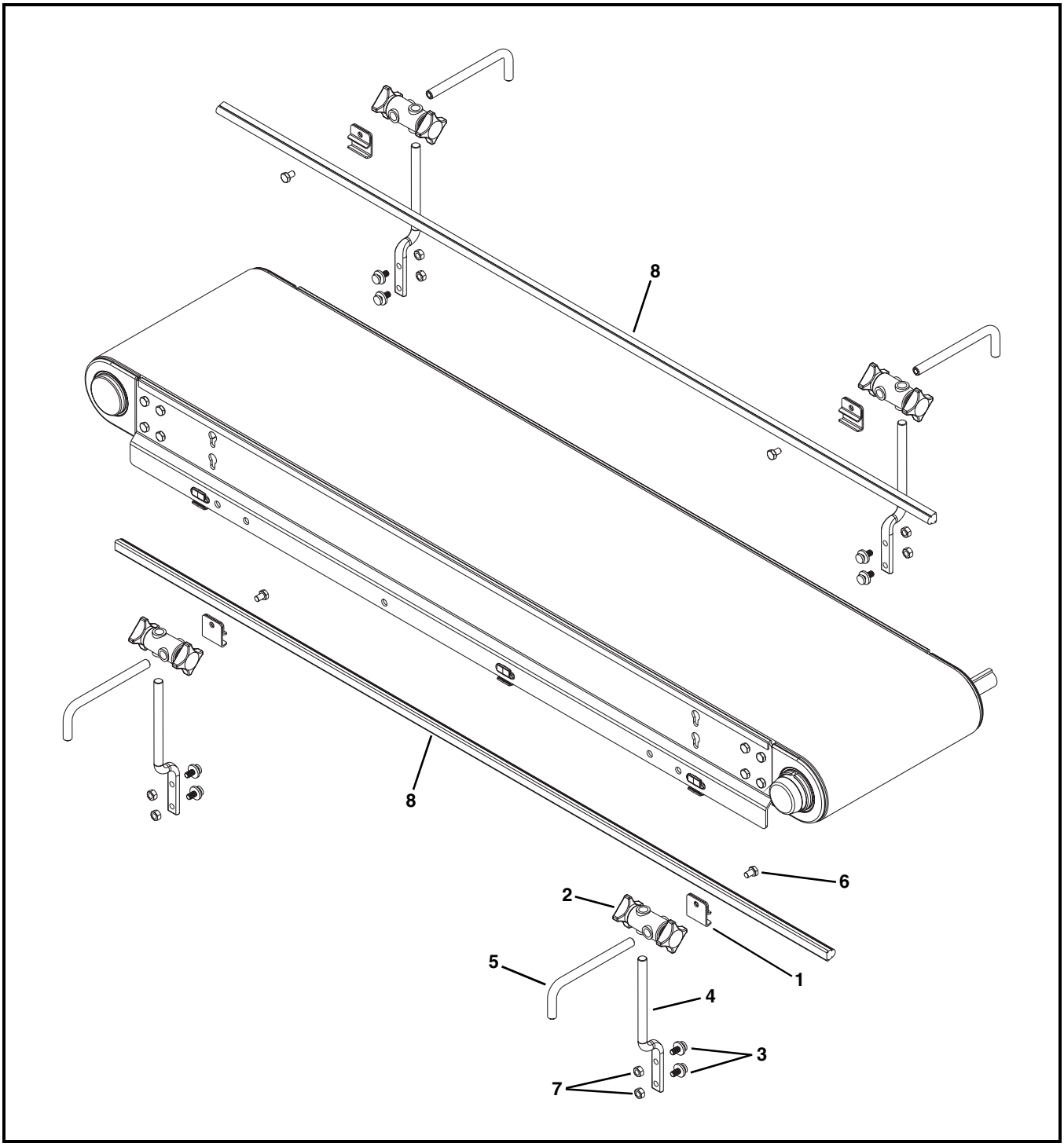
Fully Adjustable Round Guides



Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Fully Adjustable Round Guides

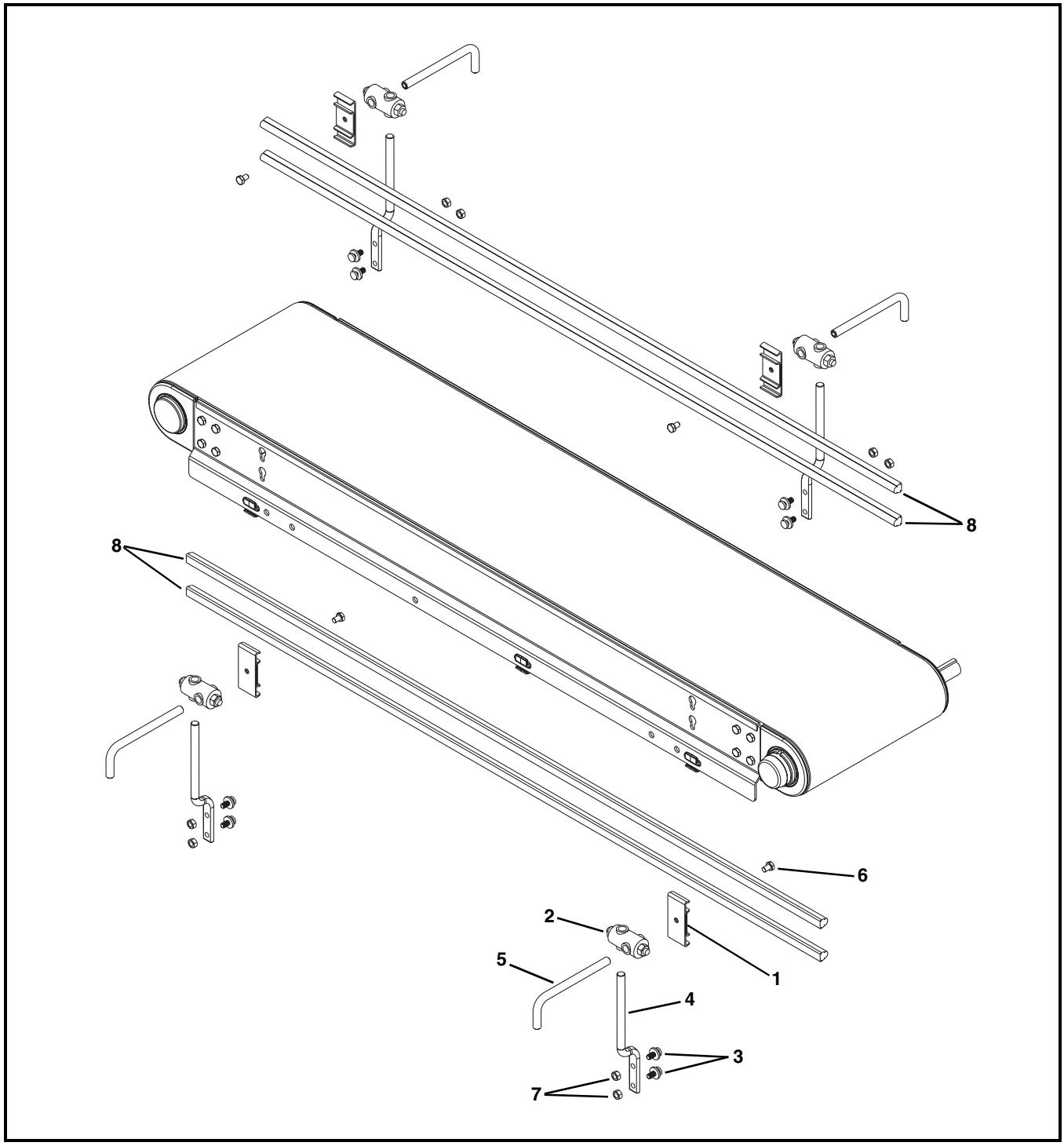


Item	Part Number	Description
1	807-015	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

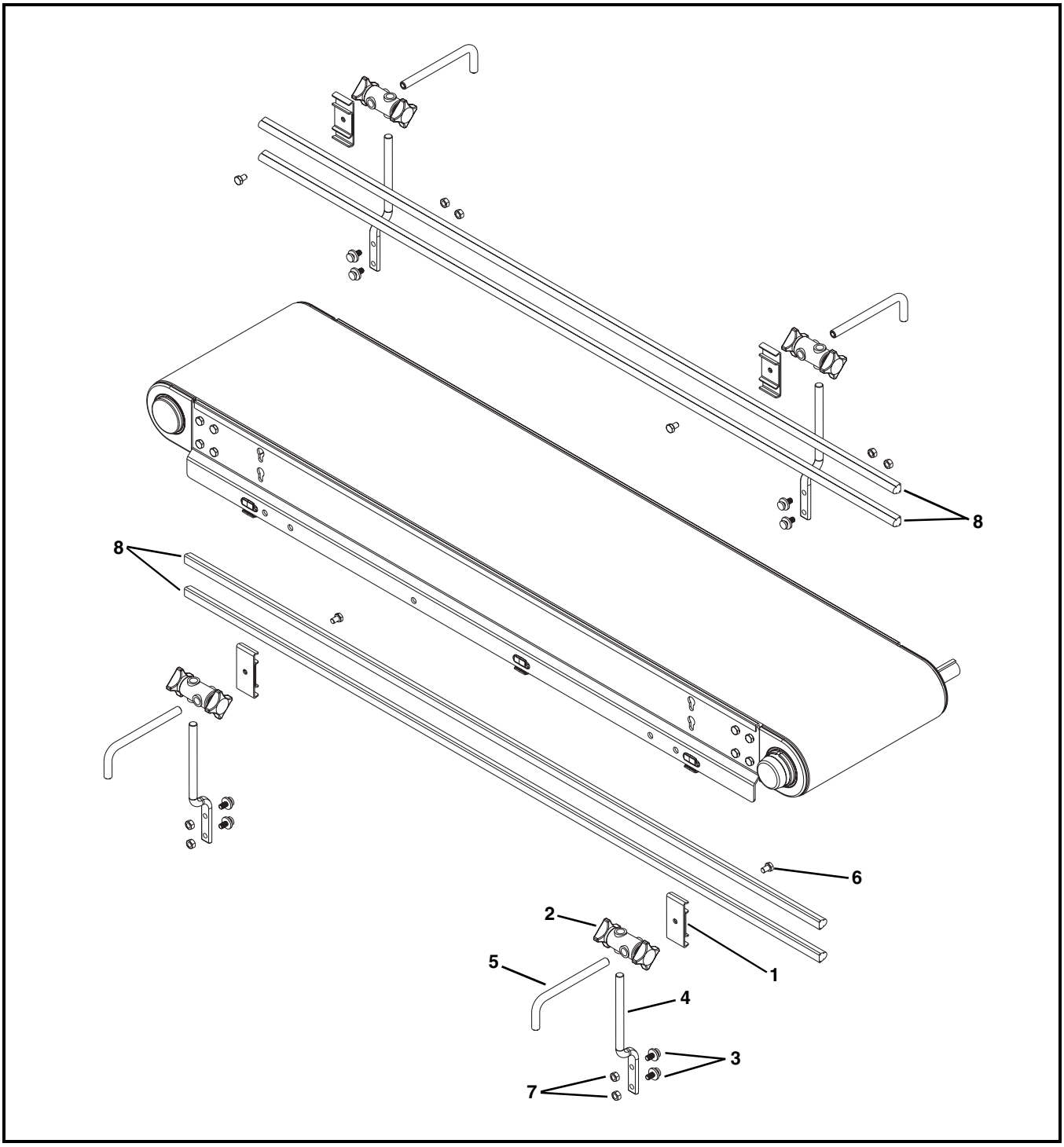
Twin Rail Adjustable Round Guides



Item	Part Number	Description
1	901414	Rail Clamp
2	807-1387	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Twin Rail Adjustable Round Guides

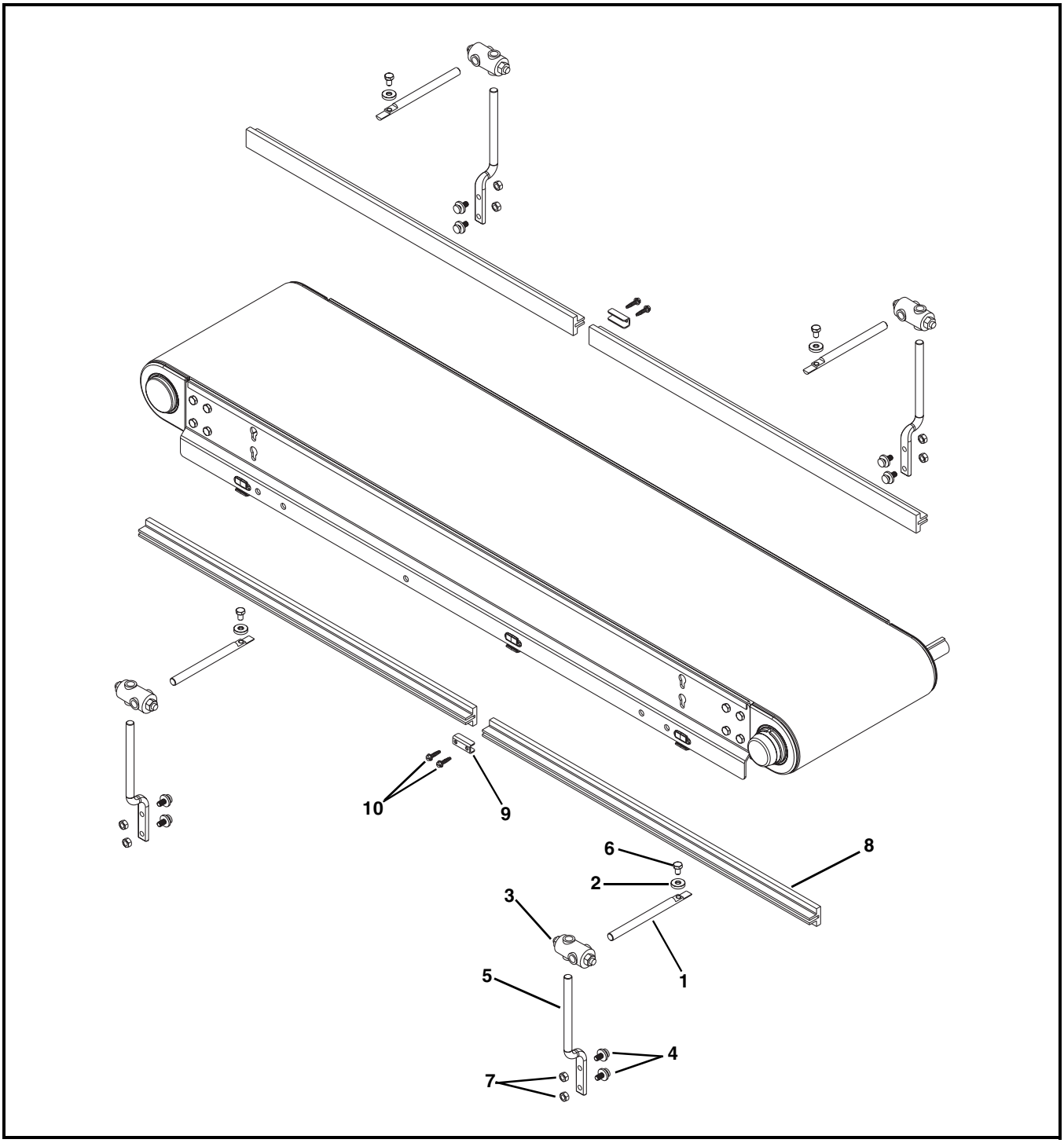


Item	Part Number	Description
1	901414	Rail Clamp
2	807-1470	Cross Block Clamp
3	532191	Carriage Bolt, M8 x 20 mm
4	532192	Offset Guide Post
5	532300	Post Guide

Item	Part Number	Description
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
7	990801MSS	Hex Nut
8	532167-LLLLL	Round Guide Rail
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

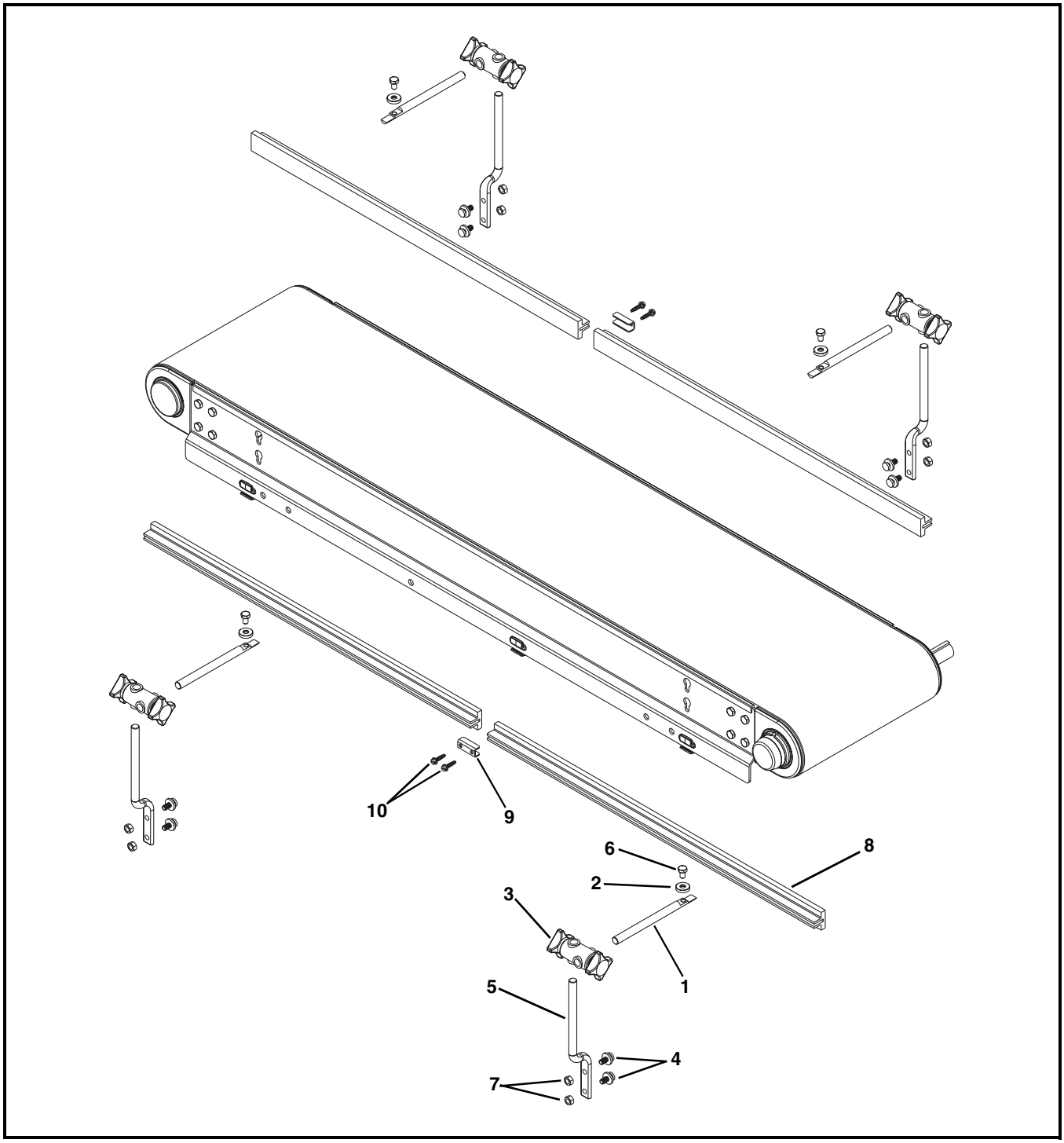
Fully Adjustable 1" (25 mm) Flat Guides



Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1387	Cross Block Clamp
4	532191	Carriage Bolt, M8 x 20 mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532170-LLLLL	Round Guide Rail
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Tool-Less Fully Adjustable 1" (25 mm) Flat Guides

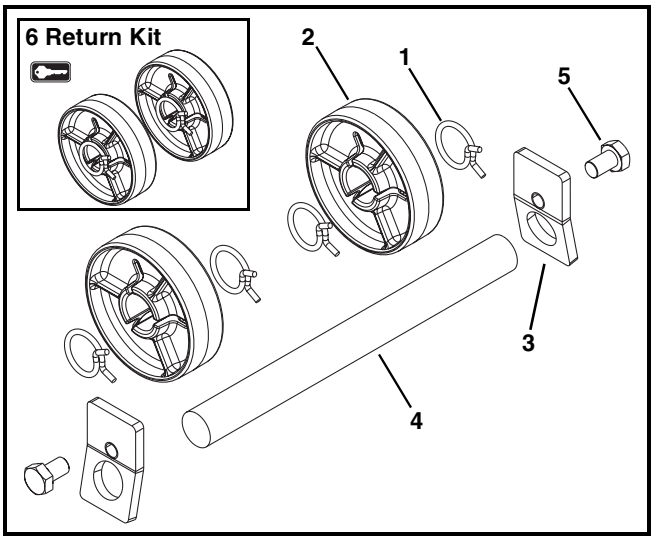


Item	Part Number	Description
1	532178	Rod Clamp
2	532179	Washer
3	807-1470	Cross Block Clamp
4	532191	Carriage Bolt, M8 x 20 mm
5	532192	Offset Guide Post
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	990801MSS	Hex Nut
8	532170-LLLLL	Round Guide Rail
9	532195	Guide Connecting Clip
10	807-1840	Hex Head Washer Screw
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

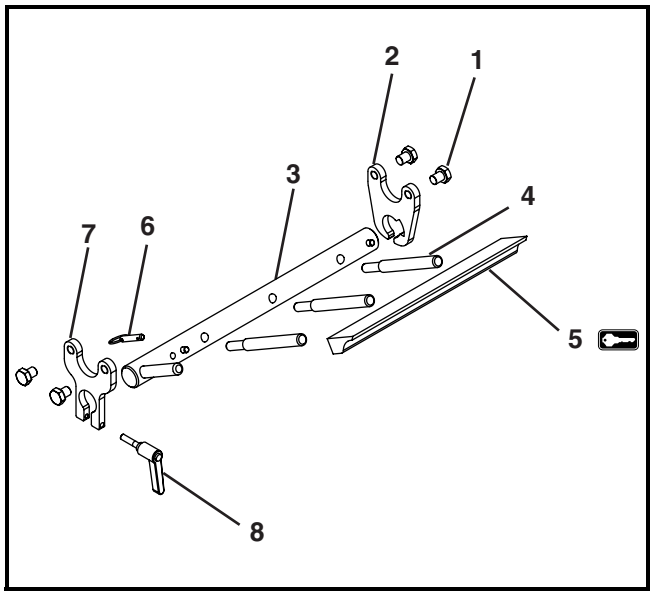
Service Parts

Returns



Item	Part Number	Description
1	807-1551	Clamp
2	506296	Return Disk
3	532307	Return Shaft Bracket
4	532375-WW	Shaft
5	961016MSS	Hex Head Cap Screw, M10-1.50 x 16 mm
6	736RRF-WW	Return Kit (Includes items 1 and 2)
WW = Conveyor width reference: 04 - 52 in 02 increments		

Scraper



Item	Part Number	Description
1	961012MSS	Hex Head Cap Screw M10-1.50 x 12 mm
2	500878	Scraper Adjust Plate
3	5102WW	Scraper Shaft Assembly
4	500881	Scraper Holder Bar
5	5047WW	Scraper Wear Bar
6	807-1553	Pull Pin
7	500879	Scraper Mount Plate
8	807-1559	Handle
WW = Conveyor width ref: 04 - 52 in 02 increments		

Configuring Conveyor Belt Part Number

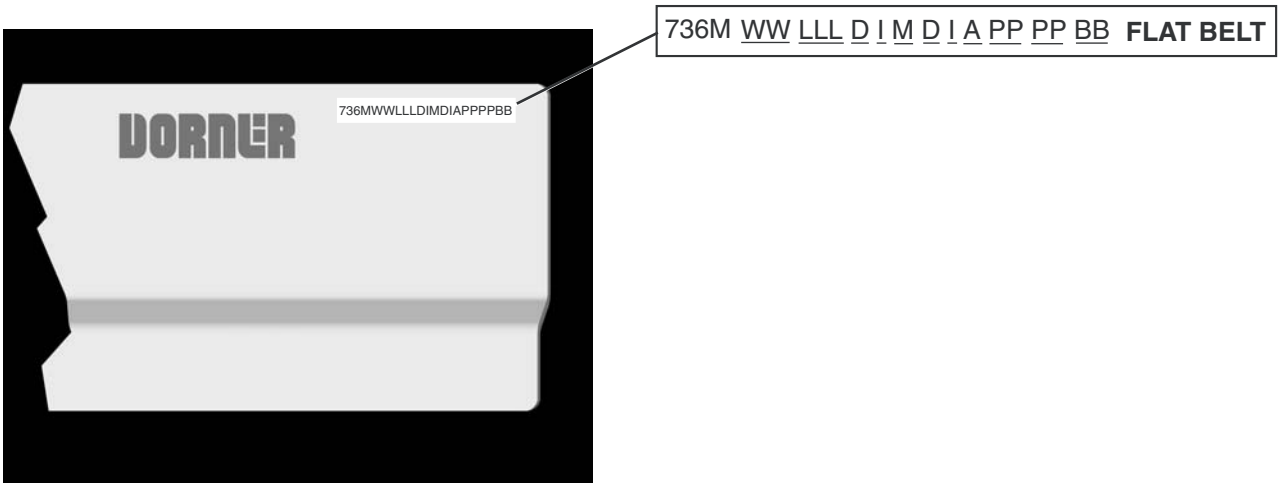


Figure 99

Flat Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 99)**. From the model number determine the conveyor width (WW), length (LLL), drive/tail types (A) and belt type (BB). Use data to configure belt part number as indicated below. *Add "V" for v-guided belts.

736-WW LLL A / BB V*

736-___ ___ __ / ___ 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. 2012

DORNER MFG. CORP.
975 Cottonwood Ave., PO Box 20
Hartland, WI 53029-0020 USA
TEL 1-800-397-8664 (USA)
FAX 1-800-369-2440 (USA)
Internet: www.dorner.com

Outside the USA:
TEL 1-262-367-7600
FAX 1-262-367-5827

851-709 Rev. A

Printed in U.S.A.