

6100 Series Corrosion Resistant End Drive Conveyors

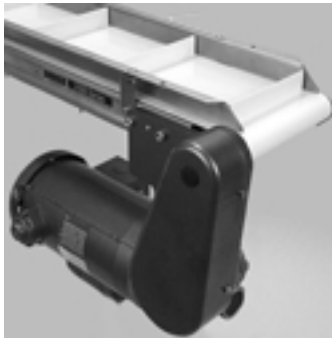
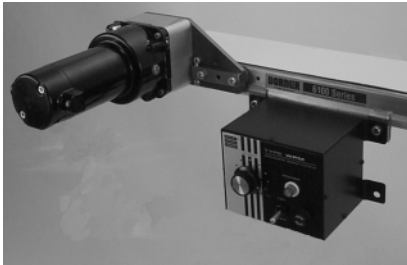




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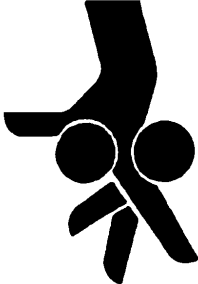

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Warnings – General Safety



	WARNING	
<p>The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.</p>		



		WARNING
<p>Gearmotors may be HOT. DO NOT TOUCH Gearmotors.</p>		

		DANGER
<p>Climbing, sitting, walking or riding on conveyor will cause severe injury. KEEP OFF CONVEYORS.</p>		

		WARNING
<p>Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.</p> <p>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.</p>		

		DANGER
<p>DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.</p>		

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

		WARNING
<p>Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.</p>		

Introduction

IMPORTANT: Some illustrations may show guards removed. Do NOT operate equipment without guards.

Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

Dorner 6100 Series conveyors are covered by Patent Nos. 5174435, 6109472 and corresponding patents and patent applications in other countries.

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

Product Description

Refer to Figure 1 for typical conveyor components.

Typical Components	
A	Conveyor
B	Gearmotor Mounting Package
C	Gearmotor
D	Guiding & Accessories
E	Mounting Brackets with Return Rollers
F	Support Stands
G	Variable Speed Controller
H	Drive End
I	Idler/Tension End

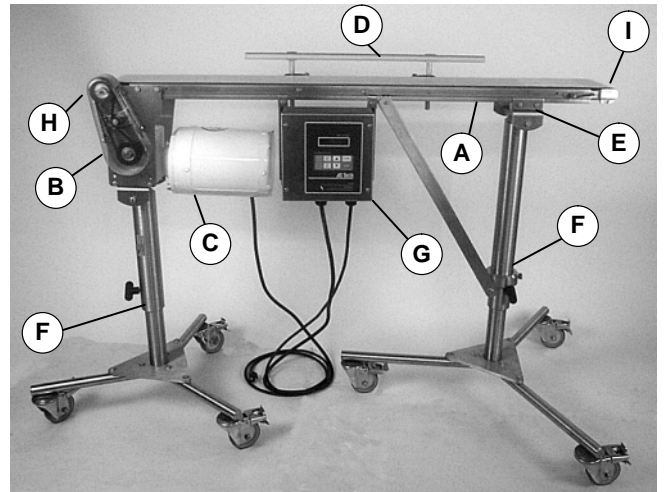
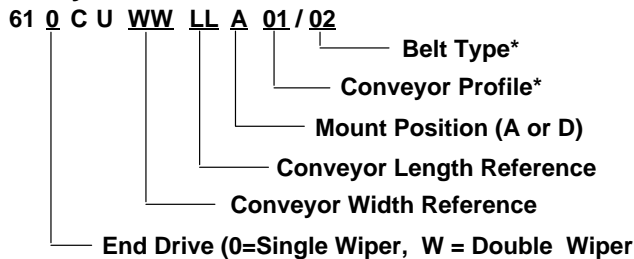


Figure 1

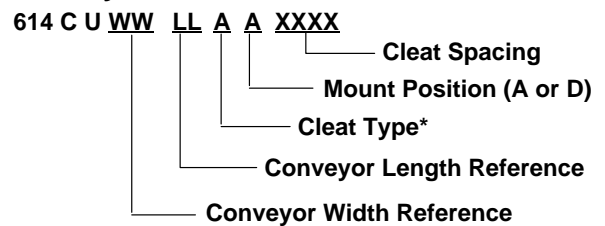
Specifications

Models:

Flat Belt 6100 Series Corrosion Resistant Conveyor



Cleated Belt 6100 Series Corrosion Resistant Conveyor



* See "Ordering and Specifications" Catalog for details.

Conveyor Supports:

Maximum Distances:

J = 457 mm**

K = 1829 mm***

L = 457 mm

** For Heavy Load Bottom Mount Package, mount support under gear head.

*** For conveyors longer than 3962 mm, install support at joint.

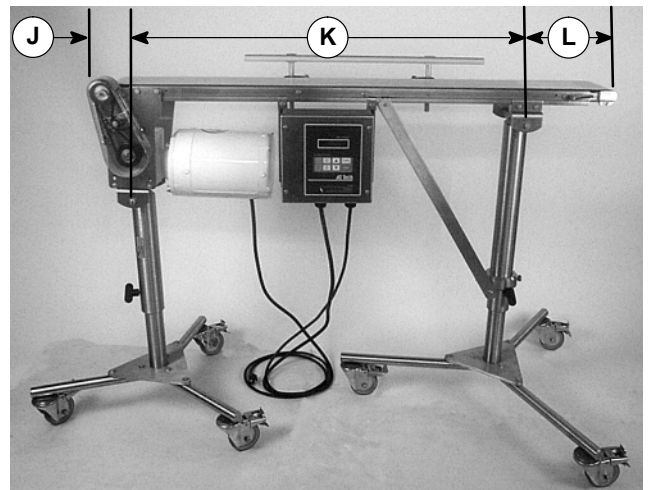


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18
Conveyor Belt Width	44 mm	70 mm	95 mm	127 mm	152 mm	203 mm	254 mm	305 mm	457 mm
Maximum Conveyor Load* (See NOTE Below)	14 kg	16 kg	19 kg	23 kg	27 kg	27 kg	27 kg	27 kg	27 kg
Conveyor Start-up Torque*	0.5 Nm	0.6 Nm	0.7 Nm	0.8 Nm	0.9 Nm	1.1 Nm	1.4 Nm	1.5 Nm	1.7 Nm
Belt Travel	88 mm per revolution of pulley								
Maximum Belt Speed*	72 meters/minute								
Belt Take-up	10 mm of stroke = 19 mm of belt take-up								

Conveyor Length Reference (LL)	02	03	04	05	06	07	08	09	10	11	12	13**	14**	15**	16**	17**	18**
Conveyor Length	610 mm	914 mm	1219 mm	1524 mm	1829 mm	2134 mm	2438 mm	2743 mm	3048 mm	3353 mm	3658 mm	3962 mm**	4267 mm**	4572 mm**	4877 mm**	5182 mm**	5486 mm**

* See "Ordering and Specifications" Catalog for details.

** Lengths available only in 152 mm & wider conveyors.

NOTE: Maximum conveyor loads based on:

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

Installation

NOTE: Conveyor **MUST** be mounted straight, flat and level within confines of conveyor. Use a level (M of Figure 3) for set-up.

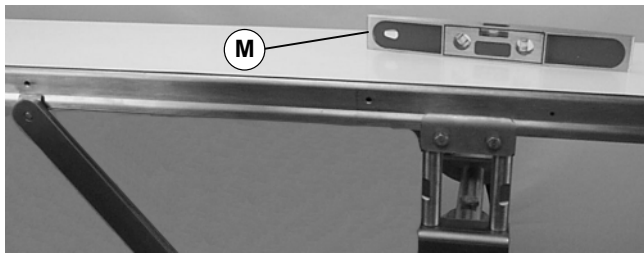


Figure 3

Illustration References

M	Level
N	Conveyor frame without belt
O	M6 x 10 mm Hex Head Socket Head Screws (6x) (shipped loose)
P	Connector Strips (2x) (Attached to conveyor section)
Q	Conveyor frame with belt
R	M6 x 12 mm Hex Head Screws (4x)
S	M6 x 16 mm Hex Head Screws & Hard Washers (4x)

Required Tools

Standard Tools

- 10 mm wrench (for hexagon head fasteners)
- 5 mm hex key wrench
- Level
- Torque wrench

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

- Assemble conveyor (if required)
- Attach mounting bracket(s) with return roller to conveyor (see pages 6 and 7)
- Install stands (see accessory instructions)
- Attach conveyor to stands
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see “Service Parts” section, pages 16 through 30)

Conveyors Up to 3962 mm

No additional assembly is required.

Conveyors Longer Than 3962 mm

1. Typical components (Figure 4)

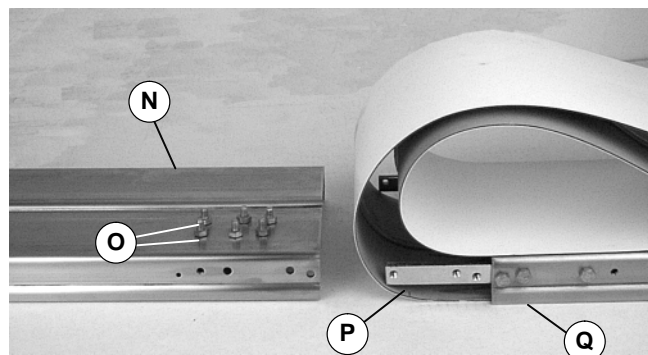


Figure 4

2. Compress tension end (Figure 5). Refer to steps 3, 4 & 5 under the “Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands” on page 9.



Figure 5

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

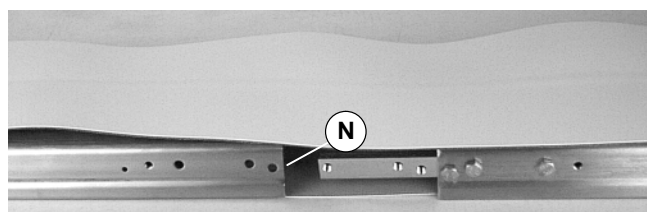


Figure 6

5. Join conveyor sections (N and Q of Figure 7). Install screws (O) on both sides. Tighten to 10.4 Nm.

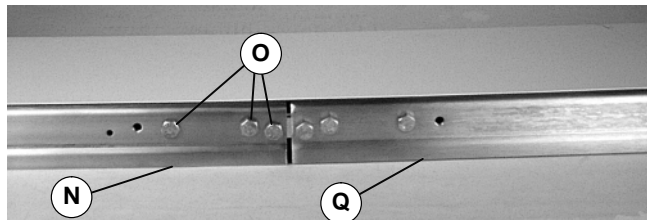


Figure 7

6. Tension conveyor belt. Refer to “Conveyor Belt Tensioning” on page 11.

Installation

Mounting Brackets with Return Rollers Cleated Belt Conveyors

1. Typical components (Figure 8)

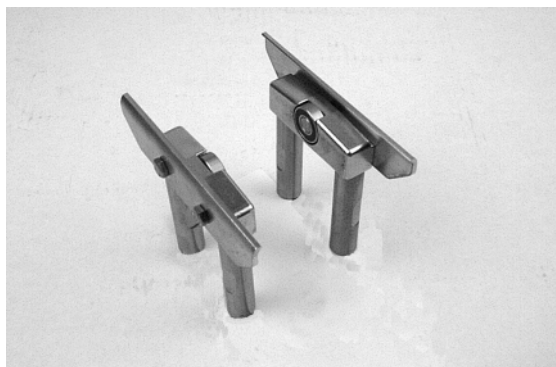


Figure 8

2. Loosen screws (R of Figure 9) and remove screws and washers (S).

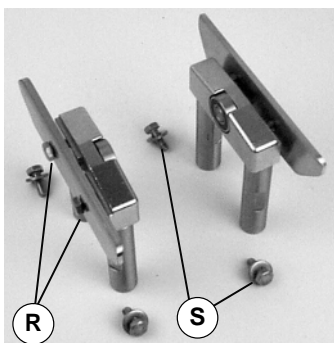


Figure 9

3. Attach clamp plates on each side of conveyor (Figure 10). Tighten the screws (R) to 10.4 Nm.

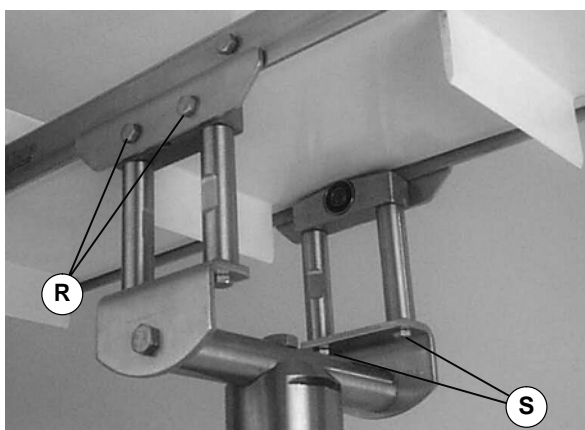


Figure 10

4. Attach to support stand. Tighten screws (S) to 10.4 Nm. Make sure belt is free to move.

44 mm to 152 mm Wide Flat Belt Conveyors

1. Typical components (Figure 11)

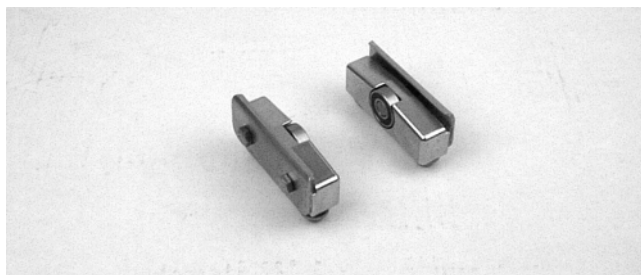


Figure 11

2. Loosen screws (R of Figure 12) and remove screws and washers (S).

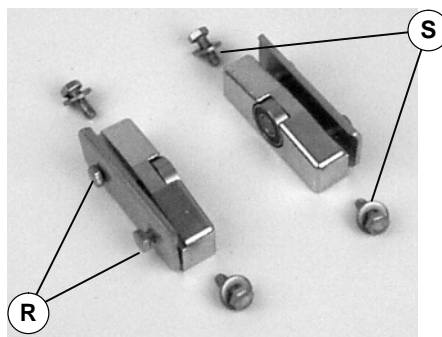


Figure 12

3. Attach clamp plates on each side of conveyor (Figure 13). Tighten the screws (R) to 10.4 Nm.

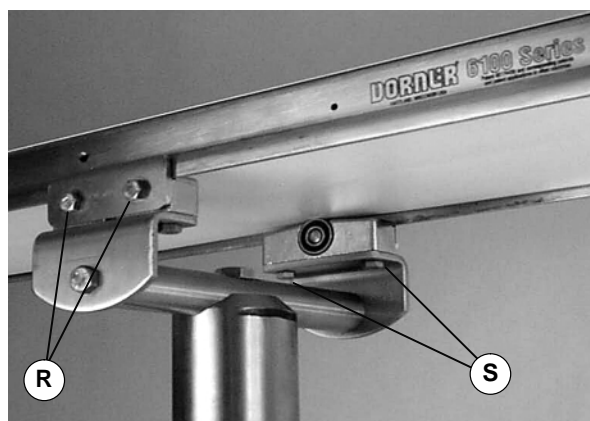


Figure 13

4. Attach to support stand. Tighten screws (S) to 10.4 Nm. Make sure belt is free to move.

203 mm & Wider Flat Belt Conveyors

1. Typical components (Figure 14)

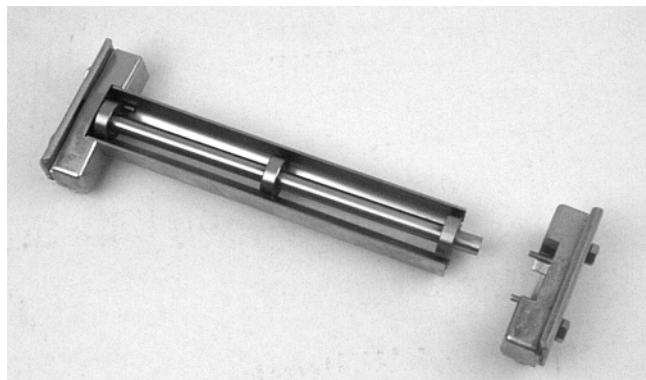


Figure 14

2. Loosen screws (R of Figure 15) and remove screws and washers (S).

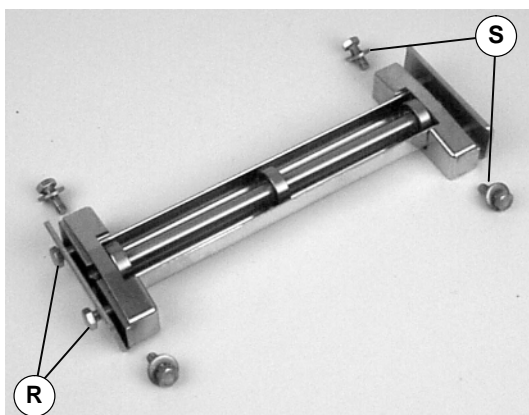


Figure 15

3. Attach clamp plates on each side of conveyor (Figure 16). Tighten the screws (R) to 10.4 Nm.

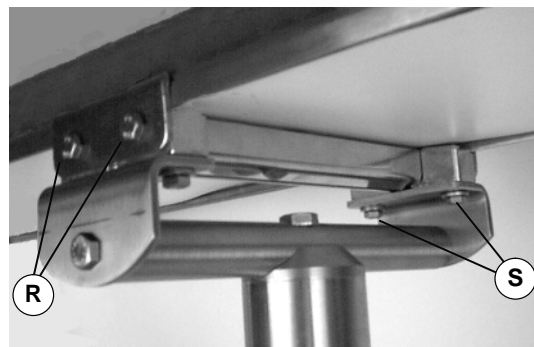


Figure 16

4. Attach to support stand. Tighten screws (S) to 10.4 Nm. Make sure belt is free to move.

Preventative Maintenance & Adjustment

Required Tools

Standard Tools

- Wrenches (for hexagon head fasteners)
 - 8 mm & 10 mm
- 5 mm hex key wrench
- Narrow blade screwdriver
- Arbor press

Special Tools

- 450281 Sealed Bearing Removal Tool
- 450282 Sealed Bearing Installation Tool

Checklist

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

Lubrication

Conveyor with Standard 12 mm Diameter Output Shaft

No lubrication is required. Replace bearings if worn.

Mounting Brackets with Return Rollers

No lubrication is required. Replace bearings if worn.

Preventive Maintenance and Adjustment

Maintaining Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Stalling or slipping
- Damage to V-guide

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Improperly installed bottom wiper(s)
- Accumulated dirt in wiper(s)
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:

- Excessive load on belt
- Conveyor belt or drive timing belt are not properly tensioned
- Worn knurl or impacted dirt on drive pulley
- Intermittent jamming or drive train problems

Damage to V-guide indicates:

- Twisted or damaged conveyor frame
- Dirt impacted on pulleys
- Excessive or improper side loading

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

Cleaning Conveyor Belt

IMPORTANT: Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.

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

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

Conveyor Belt Replacement



Conveyor Belt Replacement Sequence (see Table of Contents for page number)

- Remove old conveyor belt
 - Conveyor without Gearmotor Mounting Package or Stands
 - Conveyor with Stands and/or Gearmotor Mounting Package
- Install new conveyor belt
- Tension conveyor belt

Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands

1. For a flat belt conveyor, remove and retain the bottom wiper(s) (T of Figure 17).

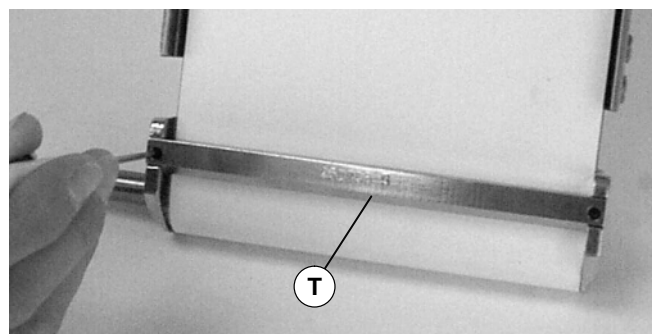



Figure 17

2. If conveyor is equipped with guiding and accessories, remove them from one side.

Preventive Maintenance and Adjustment

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

3. On tension end of the conveyor identified with a  label (U Figures 18 & 19), insert a 5 mm hex key wrench to engage pinion gear (V of Figure 18).

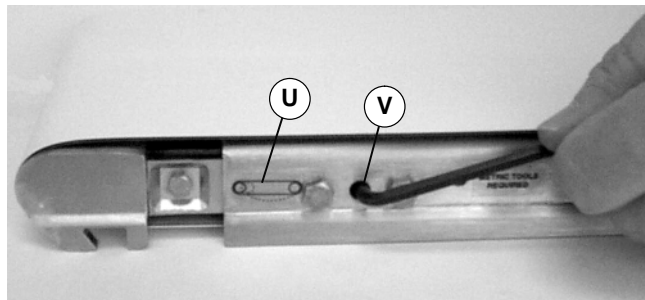


Figure 18

4. With pinion gear engaged, place a 10 mm wrench on lock screw (W of Figure 19).

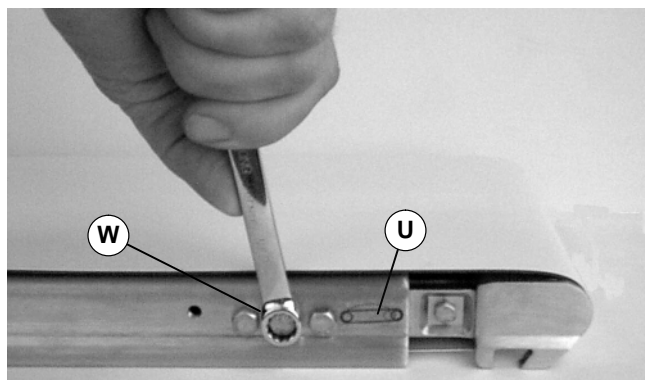


Figure 19

5. While maintaining tension on pinion gear (V of Figure 20) loosen lock screw (W). Rotate pinion gear (V) clockwise to release conveyor belt tension.

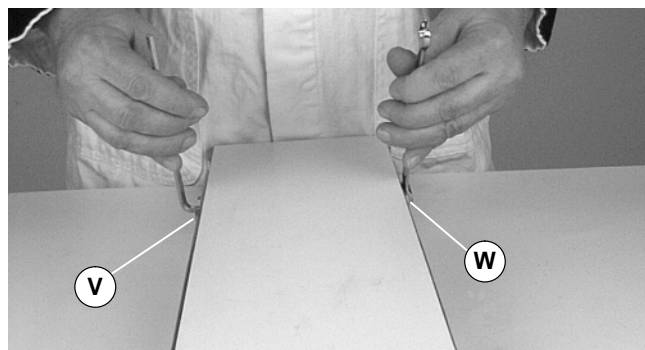


Figure 20

6. Remove conveyor belt.

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

NOTE: For conveyor with a Heavy Load Bottom or Top Mount Package, bracket (AA of Figure 21) must be removed.

- Remove two (2) M6 x 30 mm cap screws (AB).
- Remove two (2) M6 x 16 mm cap screws (AC).
- Remove bracket (AA).

NOTE: Bottom Mount Drive Package for Heavy Load Sanitary Gearmotor shown. Package for Industrial Gearmotor similar. For Industrial Gearmotor, screws (AB) are M6 x 16 mm socket heads and screws (AC) are M6 x 12 mm socket heads.

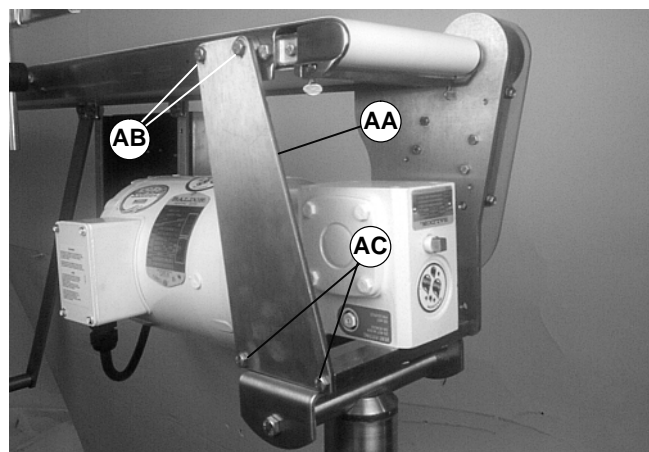



Figure 21

1. For a flat belt conveyor, remove and retain the bottom wiper(s) (T of Figure 17).
2. If conveyor is equipped with guiding and accessories, remove them from one side.

NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

3. On tension end of the conveyor identified with a  label (U Figures 18 & 19), insert a 5 mm hex key wrench to engage pinion gear (V of Figure 18).
4. With pinion gear engaged, place a 10 mm wrench on lock screw (W of Figure 19).
5. While maintaining tension on pinion gear (V of Figure 20) loosen lock screw (W). Rotate pinion gear (V) clockwise to release conveyor belt tension.

Preventive Maintenance and Adjustment



WARNING



The weight of the gearmotor is all on one end of the conveyor which could cause it to tip off the stands when the mounting clamp plates are loosened. Be sure to provide support (AD of Figure 22) underneath the gearmotor while changing the belt.

- Temporarily support conveyor at gearmotor mounting package (AD of Figure 22).

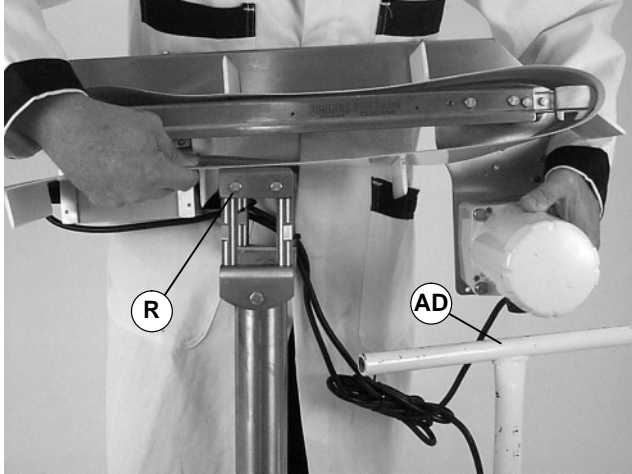


Figure 22

NOTE: To remove belt, complete steps 7 & 8, at each stand location.



WARNING



To prevent injury from the support stand tipping-over when conveyor is uncoupled, anchor stand to floor or otherwise stabilize the stand.

- Loosen the mounting clamp plates (R of Figures 22 and 23), on both sides of the conveyor. Raise the conveyor and remove the belt.

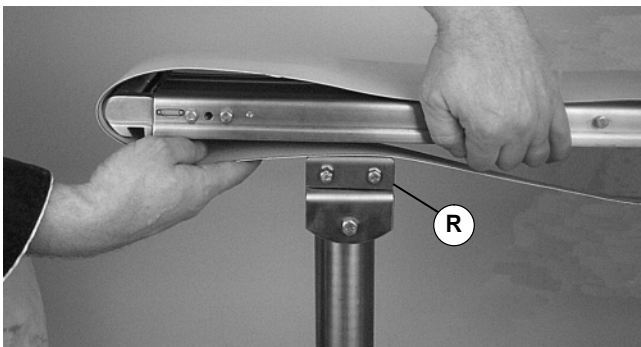


Figure 23

- With belt removed, secure conveyor with clamp plates (R).

Belt Installation for Conveyor without Gearmotor Mounting Package or Stands

IMPORTANT: On a flat belt conveyor, the wiper is installed on discharge end. Belt travel direction is identified by an arrow decal on the side of the conveyor (AG of Figure 24). With a reversing gearmotor, a second bottom wiper must be installed on opposite end.

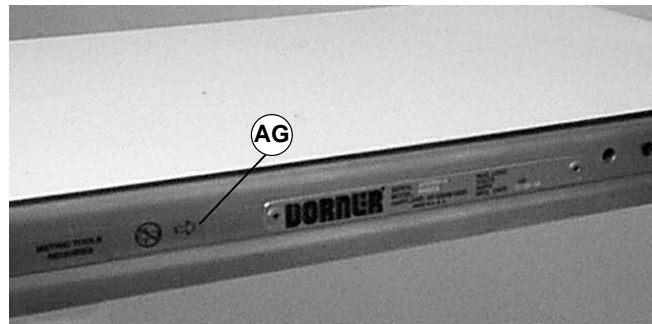


Figure 24

- Orient the conveyor belt so that the splice leading fingers (AE of Figure 25) point in the direction of belt travel (AF) as identified by the label (AG of Figure 24).

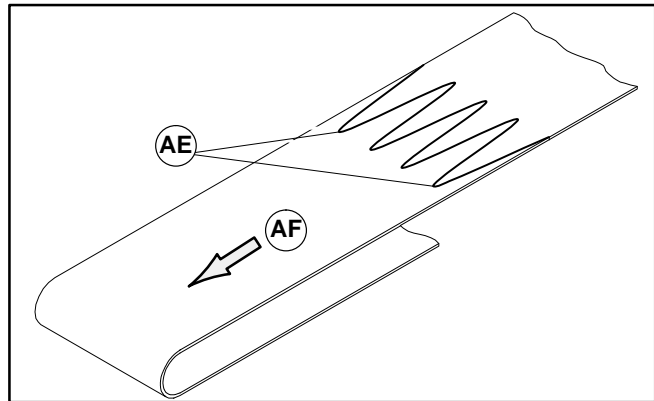


Figure 25

- Slide belt onto the conveyor frame assembly.
- On a flat belt conveyor, install bottom wiper(s) (T of Figure 17). Center set screws in frame and tighten to 3.7 Nm.
- Tension belt. Refer to "Conveyor Belt Tensioning" on page 11.
- Where applicable, replace guiding.

Preventive Maintenance and Adjustment

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

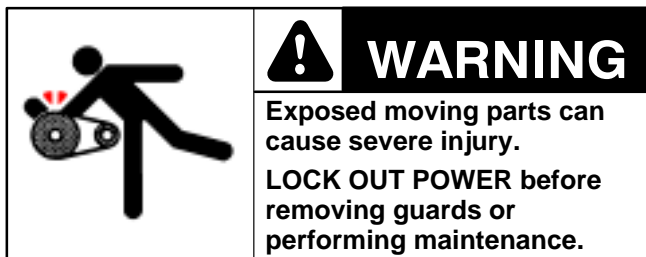
IMPORTANT: On a flat belt conveyor, the wiper is installed on discharge end. Belt travel direction is identified by an arrow decal on the side of the conveyor (AG of Figure 24). With a reversing gearmotor, a second bottom wiper must be installed on opposite end.

1. Orient the conveyor belt so that the splice leading fingers (AE of Figure 25) point in the direction of belt travel (AF) as identified by the label (AG of Figure 24).


NOTE: To install belt, complete steps 2, 3 & 4, at each stand location.

2. Loosen the mounting clamp plates (R of Figures 22 and 23), on both sides of the conveyor. Raise the conveyor and replace the belt.
3. Lower the conveyor onto the mounting blocks being careful not to pinch belt.
4. Tighten clamp plates screws (R) to 10.4 Nm.
5. On a flat belt conveyor, install bottom wiper(s) (T of Figure 17). Center set screws in frame and tighten to 3.7 Nm.
6. Tension belt. Refer to the “Conveyor Belt Tensioning” topic on this page.
7. Where applicable, replace guiding.

Conveyor Belt Tensioning



NOTE: If conveyor is equipped with optional Tool-less Belt Release, sequence is the same and no tools are required.

1. On tension end of the conveyor identified with a  label (U Figures 18 & 19), insert a 5 mm hex key wrench to engage pinion gear (V of Figure 18).
2. With pinion gear engaged, place a 10 mm wrench on lock screw (W of Figure 19).

NOTE: On pinion gear (V of Figure 18), do not exceed of 2.8 Nm for 44 mm to 305 mm wide conveyors and 4.5 Nm for an 457 mm wide conveyor. Over-tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. Loosen lock screw (W of Figure 20).
- 4a. For existing belt:
With V-guide seated in pulley, rotate the pinion gear (V) counter-clockwise to sufficiently tension the belt to handle the conveyor load.

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

- 4b. For a new belt:
With V-guide seated in pulley, rotate the pinion gear (V) counter-clockwise to a distance of 25 mm (AH of Figure 26).

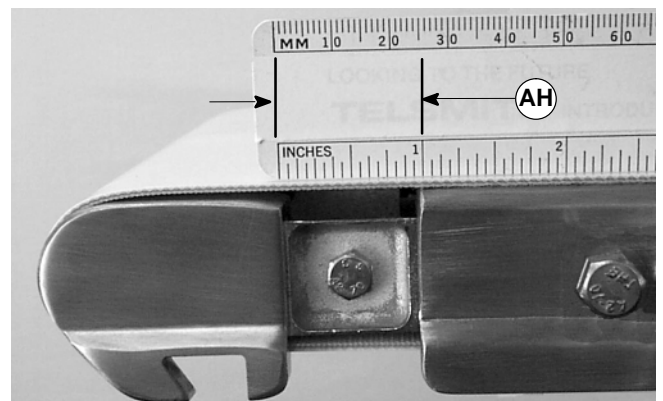
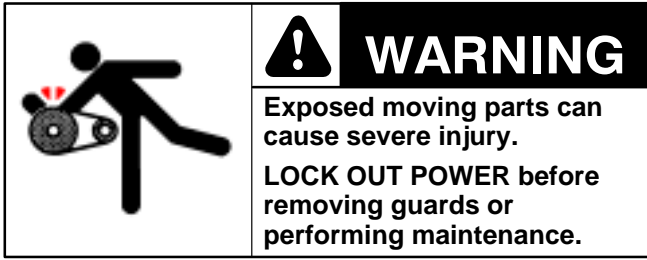


Figure 26

5. Secure lock screw (W of Figure 19) to 4.5 Nm.

Preventive Maintenance and Adjustment

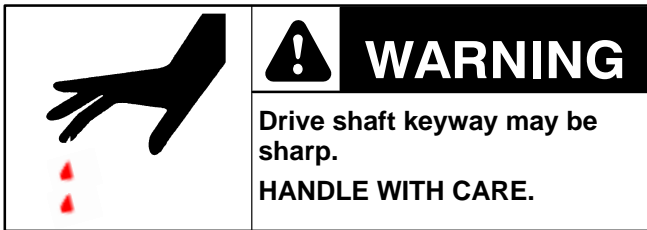
Pulley Removal



Remove conveyor belt to access pulley(s). See “Conveyor Belt Replacement” on page 8. Remove the desired pulley following instructions:

- A – Drive Pulley with Standard 12 mm Diameter Output Shaft
- B – Idler Pulley
- C – Idler Pulley with Tool-less Belt Release

A – Removal of Drive Pulley with Standard 12 mm Diameter Output Shaft



1. Remove the gearmotor mounting package. See accessory instructions.
2. Remove screw (AI).

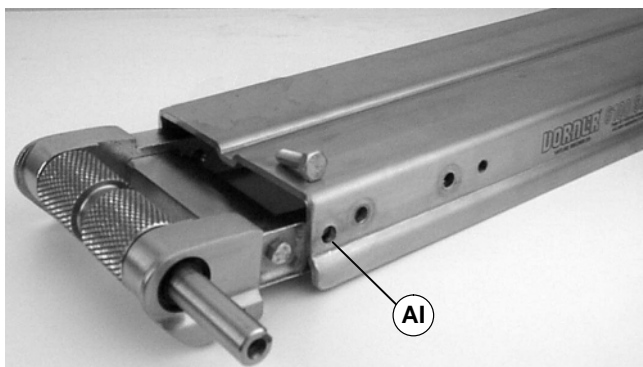


Figure 27

NOTE: With a Heavy Load Mount Package, two (2) screws (AB of Figure 21) were removed in step 1.

3. Remove three (3) screws (AJ of Figure 28) on the side opposite the drive shaft.

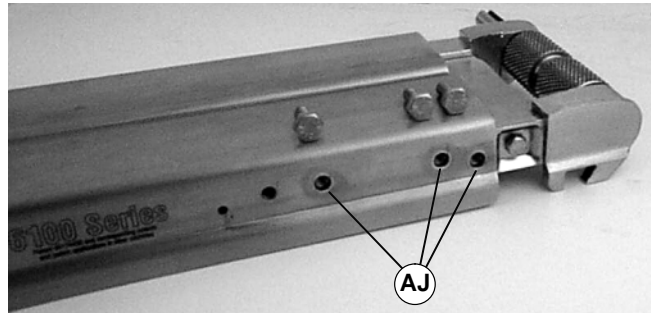


Figure 28

4. Remove the drive tail assembly.
5. Remove screw (AK of Figure 29).

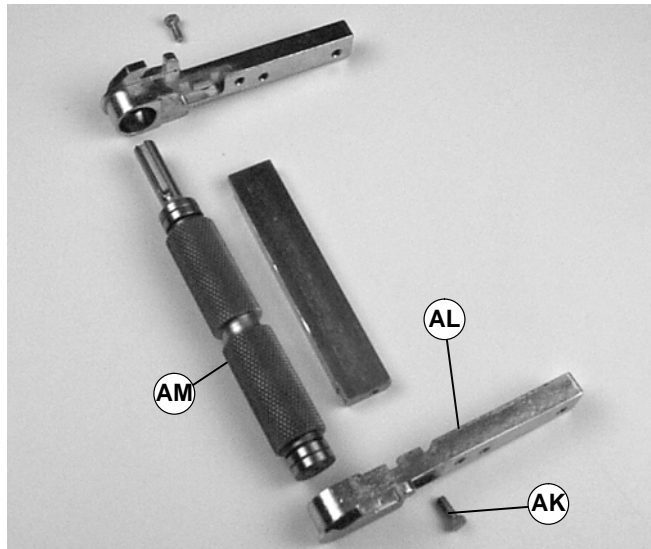


Figure 29

6. Remove headplate (AL).
7. Remove pulley (AM).

B – Idler Pulley Removal

1. Remove screw (W of Figure 30).
2. Remove four (4) tail plate mounting screws (AN of Figures 30 & 31).

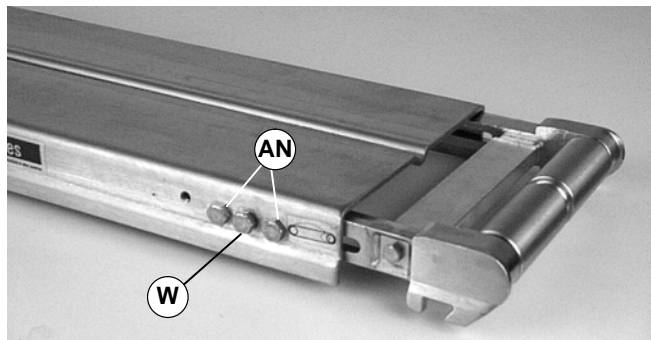


Figure 30

Preventive Maintenance and Adjustment

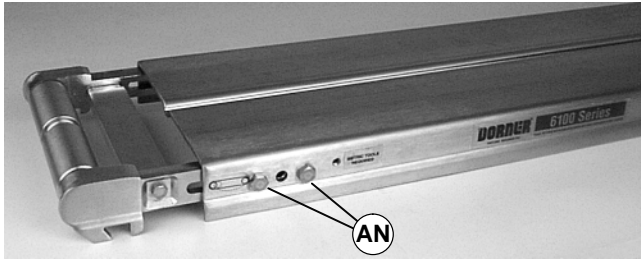


Figure 31

3. Remove tail assembly.
4. Remove screw (AK of Figure 32).

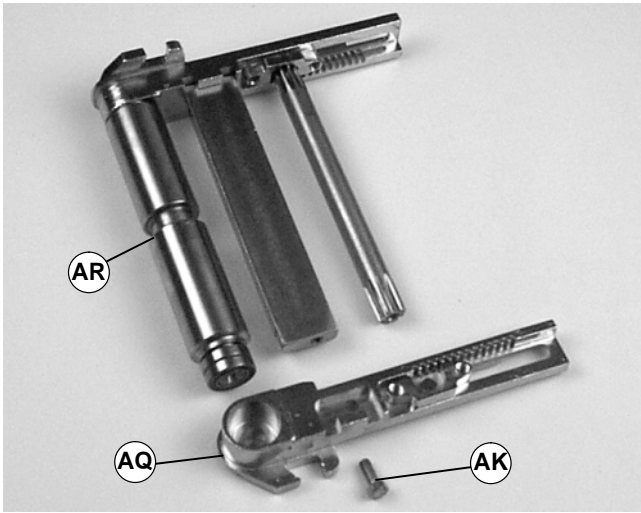


Figure 32

5. Remove headplate (AQ).
6. Remove pulley (AR).

C – Removal of Idler Pulley with Tool-less Belt Release

1. Remove handle (AO of Figure 33).

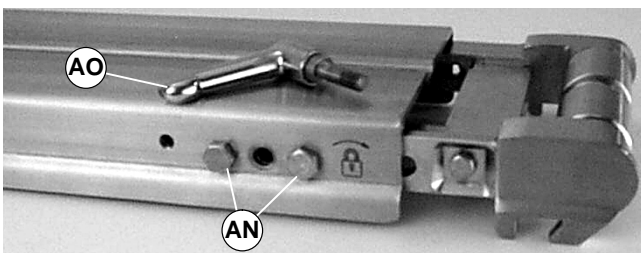


Figure 33

2. Remove two (2) screws (AN of Figure 33).

3. Remove two (2) screws (AN of Figure 34). Remove handle assembly (AP).

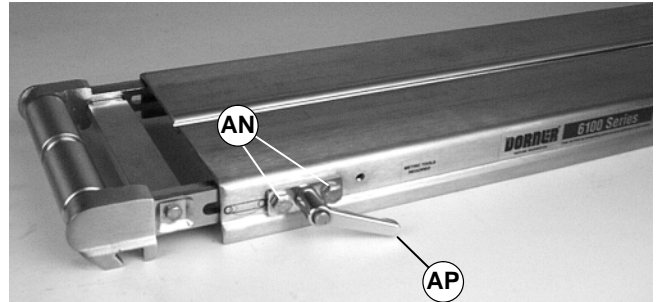


Figure 34

4. Remove tail assembly.
5. Remove screw (AK of Figure 32).
6. Remove headplate (AQ).
7. Remove pulley (AR).

Bearing Replacement

Bearing Removal

1. Place bearing removal tool (part # 450281) over bearing(s) with lip (AS of Figure 35) located in Bearing gap (AT) as shown.

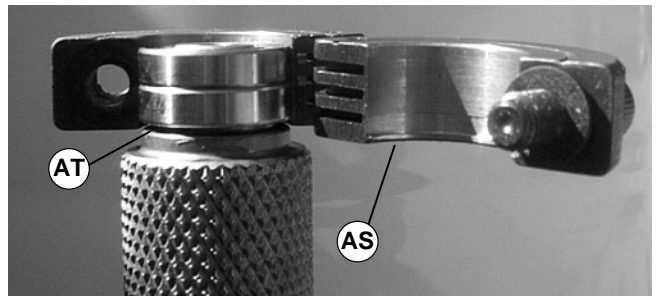


Figure 35

2. Using 3/16" hex key wrench (AU of Figure 36), tighten tool.

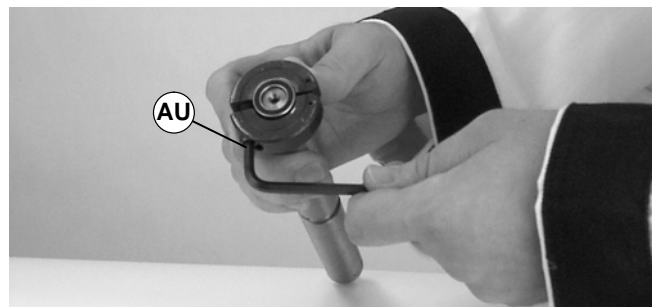


Figure 36

Preventive Maintenance and Adjustment

- Using a puller (AV of Figure 37), remove and discard bearing(s).

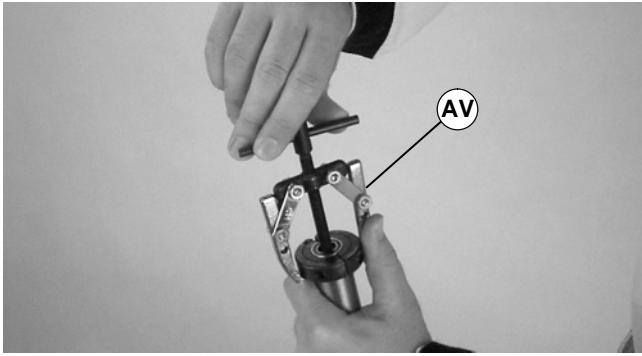


Figure 37

- Place open end of shaft (AY of Figure 40) into sleeve.

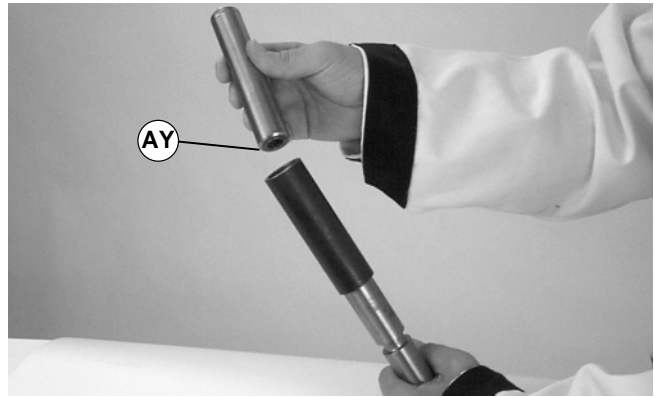


Figure 40

Bearing Installation

IMPORTANT: Install bearings one at a time.

- Inspect seating surface(s) for damage. Replace if damaged.
- Slide bearing (part # 802-120) (AW of Figure 38) onto pulley shaft.



Figure 38

- Slide the sleeve of tool (part # 450282) (AX of Figure 39) over bearing.

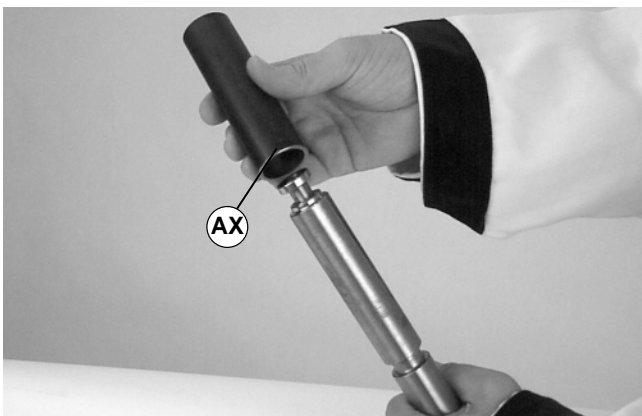


Figure 39

- Using arbor press or similar device, press bearing onto pulley shaft (see Figure 41).



Figure 41

- Repeat steps 1 through 5 for each bearing.

Preventive Maintenance and Adjustment

Drive Pulley Shaft Seal Replacement

1. Remove drive pulley from headplate. See “Pulley Removal” topic on page 12.
2. Push-out and discard old seal.
3. Install new seal (part # 807-1016) with grooved surface (AZ of Figure 42) facing out.

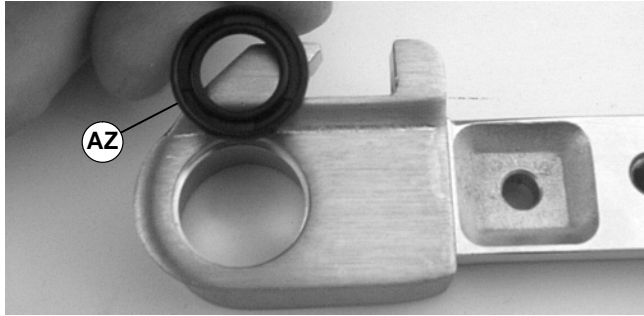


Figure 42

4. Apply a small bead of food grade grease around entire edge of shaft hole in seal (BA).

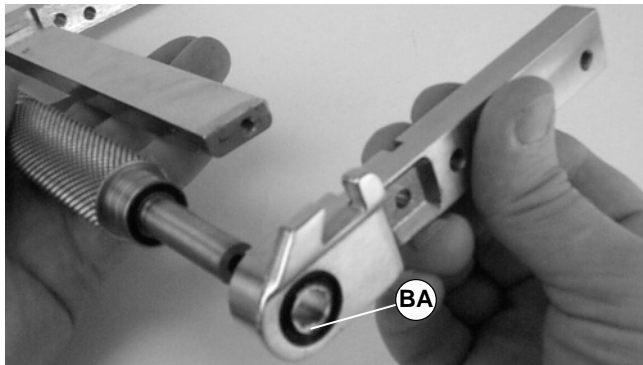


Figure 43

5. Re-install drive pulley per the following topic.

Pulley Replacement

Drive Pulley with Standard 12 mm Diameter Output Shaft

1. Reverse the removal procedure “A” (see page 12).

Idler Pulley

IMPORTANT: On tension tail, be sure to correctly orient components to match the factory orientation. Orient threaded hole side of pinion (BB of Figure 44) so it is toward detached tail plate as shown. Be sure both pinion housings (BC) engage the same tooth positions of racks as shown.

1. Reverse the removal procedure “B” (see page 12).

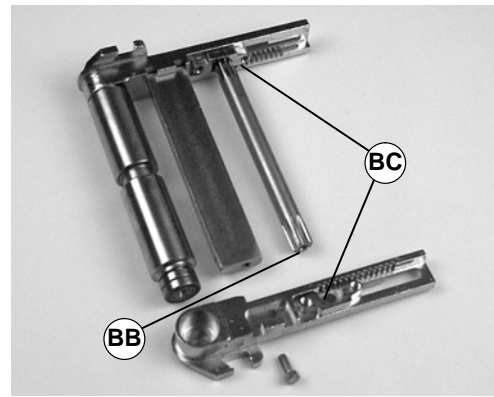


Figure 44

Idler Pulley with Tool-less Belt Release

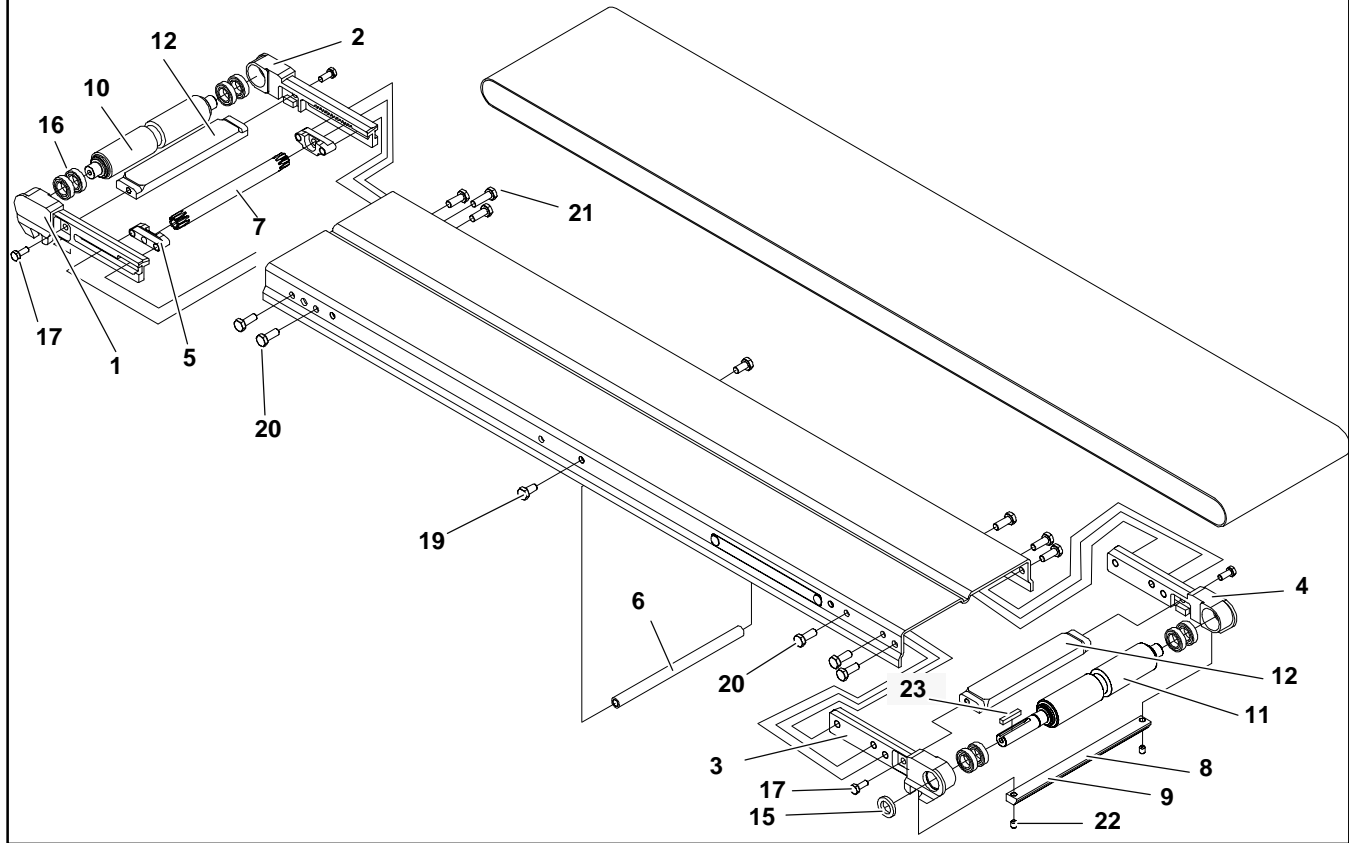
IMPORTANT: On tension tail, be sure to correctly orient components to match the factory orientation. Orient threaded hole side of pinion (BB of Figure 44) so it is toward detached tail plate as shown. Be sure both pinion housings (BC) engage the same tooth positions of racks as shown.

1. Reverse the removal procedure “C” (see page 13).

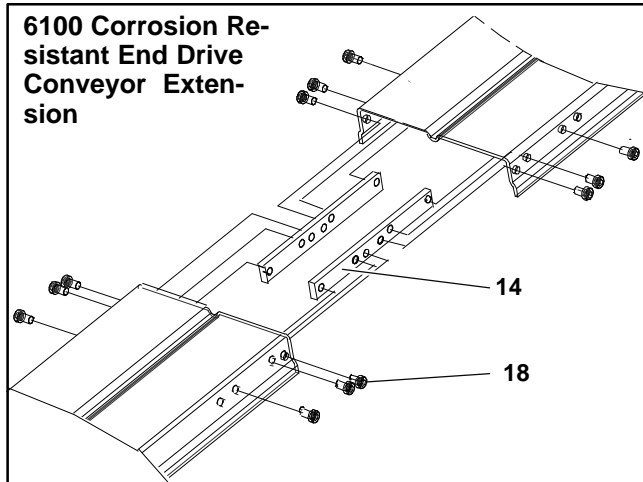
Service Parts

NOTE: For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory.

6100 Corrosion Resistant End Drive Conveyor



6100 Corrosion Resistant End Drive Conveyor Extension



Item	Part Number	Description
1	450231MSS	Tension Plate RH 51–76mm Wide
	450031MSS	Tension Plate RH 102–457mm Wide
2	450232MSS	Tension Plate LH 51–76mm Wide
	450032MSS	Tension Plate LH 102–457mm Wide
3	450233MSS	Fixed Plate, No Shaft, RH 51–76mm Wide
	450033MSS	Fixed Plate, No Shaft, RH 102–457mm Wide
	450243MSS	Fixed Plate, Shaft, RH 51–76mm Wide

	450043MSS	Fixed Plate, Shaft, RH 102–457mm Wide
4	450234MSS	Fixed Plate, No Shaft, LH 51–76mm Wide
	450034MSS	Fixed Plate, No Shaft, LH 102–457mm Wide
	450244MSS	Fixed Plate, Shaft, LH 51–76mm Wide
	450044MSS	Fixed Plate, Shaft, LH 102–457mm Wide
5	450039MSS	Pinion Retainer Block
6	452502MSS	Frame Support Post 51mm
	452503MSS	Frame Support Post 76mm
	452504MSS	Frame Support Post 102mm
	452505MSS	Frame Support Post 127mm
	452506MSS	Frame Support Post 152mm
	452508MSS	Frame Support Post 203mm
	452510MSS	Frame Support Post 254mm
	452512MSS	Frame Support Post 305mm
	452518MSS	Frame Support Post 457mm
7	453702MSS	Pinion 51mm
	453703MSS	Pinion 76mm
	453704MSS	Pinion 102mm
	453705MSS	Pinion 127mm
	453706MSS	Pinion 152mm
	453708MSS	Pinion 203mm

Service Parts

	453710MSS	Pinion 254mm
	453712MSS	Pinion 305mm
	453718MSS	Pinion 457mm
8	452702MSS	Bottom Wiper 51mm
	452703MSS	Bottom Wiper 76mm
	452704MSS	Bottom Wiper 102mm
	452705MSS	Bottom Wiper 127mm
	452706MSS	Bottom Wiper 152mm
	452708MSS	Bottom Wiper 203mm
	452710MSS	Bottom Wiper 254mm
	452712MSS	Bottom Wiper 305mm
	452718MSS	Bottom Wiper 457mm
9	452802MSS	Bottom Bar 51mm
	452803MSS	Bottom Bar 76mm
	452804MSS	Bottom Bar 102mm
	452805MSS	Bottom Bar 127mm
	452806MSS	Bottom Bar 152mm
	452808MSS	Bottom Bar 203mm
	452810MSS	Bottom Bar 254mm
	452812MSS	Bottom Bar 305mm
	452818MSS	Bottom Bar 457mm
10	452902SS	Idler Spindle 51mm
	452903SS	Idler Spindle 76mm
	452904SS	Idler Spindle 102mm
	452905SS	Idler Spindle 127mm
	452906SS	Idler Spindle 152mm
	452908SS	Idler Spindle 203mm
	452910SS	Idler Spindle 254mm
	452912SS	Idler Spindle 305mm
	452918SS	Idler Spindle 457mm
11	453102MSS	Drive Spindle 51mm
	453103MSS	Drive Spindle 76mm
	453104MSS	Drive Spindle 102mm
	453105MSS	Drive Spindle 127mm
	453106MSS	Drive Spindle 152mm
	453108MSS	Drive Spindle 203mm
	453110MSS	Drive Spindle 254mm
	453112MSS	Drive Spindle 305mm
	453118MSS	Drive Spindle 457mm
12	453802MSS	Fixed Tension Support 51mm
	453803MSS	Fixed Tension Support 76mm
	453804MSS	Fixed Tension Support 102mm

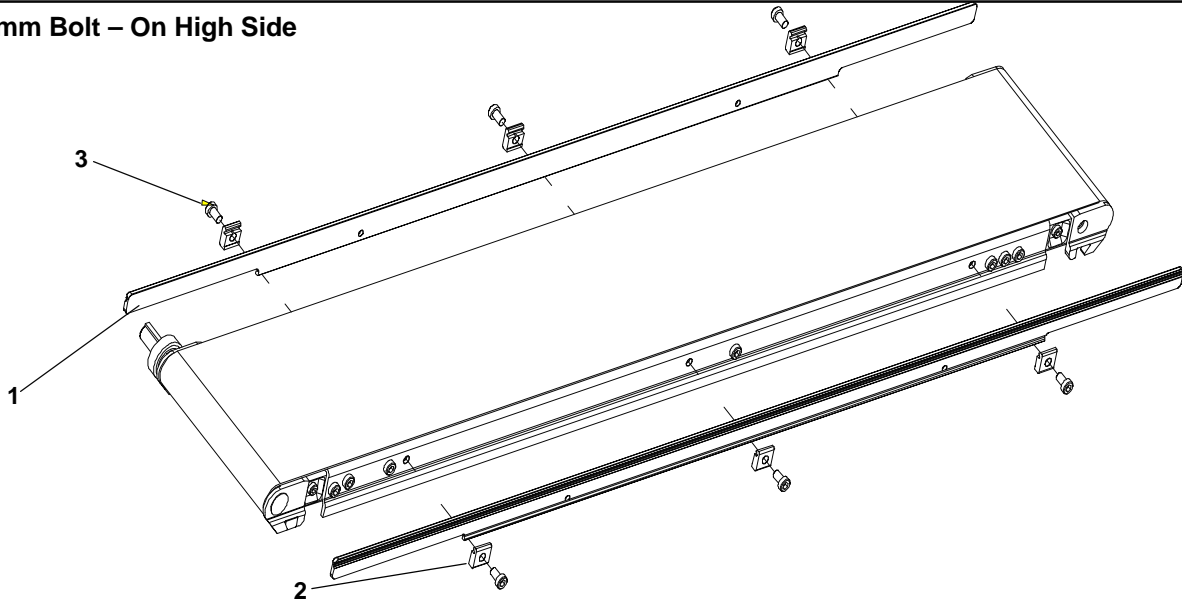
	453805MSS	Fixed Tension Support 127mm
	453806MSS	Fixed Tension Support 152mm
	453808MSS	Fixed Tension Support 203mm
	453810MSS	Fixed Tension Support 254mm
	453812MSS	Fixed Tension Support 305mm
	453818MSS	Fixed Tension Support 457mm
13	See chart below	6100 Conveyor Frame
14	450160MSS	Bar Connecting Frame
15	807-1016	Lip Seal
16	802-120	Ball Bearing 12mm (Bore) x 21mm (OD)
17	960512MSS	Hex Head Screw M5-.80 x 12mm
18	960610MSS	Hex Head Screw M6-1.0 x 10mm
19	960612MSS	Hex Head Screw M6-1.0 x 12mm
20	960616MSS	Hex Head Screw M6-1.0 x 16mm
21	960620MSS	Hex Head Screw M6-1.0 x 20mm
22	907-159	Socket Head Set Screw #10-32 x .25"
23	980422M	Key Square 4mm x 22mm

Item 13: 6100 Conveyor Frame	
Length	Part Number(s)
610mm	47 WW 02M
914mm	47 WW 03M
1219mm	47 WW 04M
1524mm	47 WW 05M
1829mm	47 WW 06M
2134mm	47 WW 07M
2438mm	47 WW 08M
2743mm	47 WW 09M
3048mm	47 WW 10M
3353mm	47 WW 11M
3658mm	47 WW 12M
3962mm	47 WW 07M 47 WW 13M
4267mm	47 WW 08M 47 WW 13M
4572mm	47 WW 09M 47 WW 13M
4877mm	47 WW 09M 47 WW 13M
5182mm	47 WW 09M 47 WW 13M
5486mm	47 WW 09M 47 WW 13M
5791mm	47 WW 09M 47 WW 13M
6096mm	47 WW 09M 47 WW 13M
6401mm	47 WW 09M 47 WW 13M
6706mm	47 WW 09M 47 WW 13M
7011mm	47 WW 09M 47 WW 13M
7316mm	47 WW 09M 47 WW 13M

~~WW~~ = frame width reference: 02, 03, 04, 05, 06, 08, 10, 12, 18

Service Parts

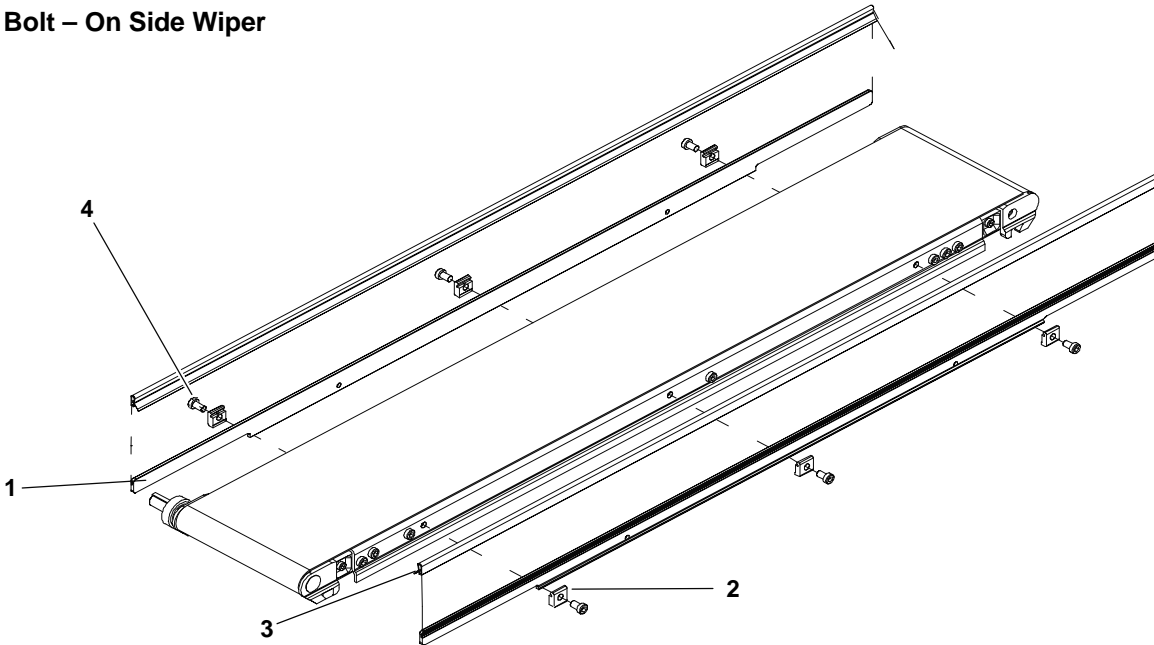
-02 13mm Bolt – On High Side



Item	Part Number	Description
1	460232	Rail Guide 13mm HS x 610mm
	460233	Rail Guide 13mm HS x 914mm
	460234	Rail Guide 13mm HS x 1219mm
	460235	Rail Guide 13mm HS x 1524mm
	460236	Rail Guide 13mm HS x 1829mm

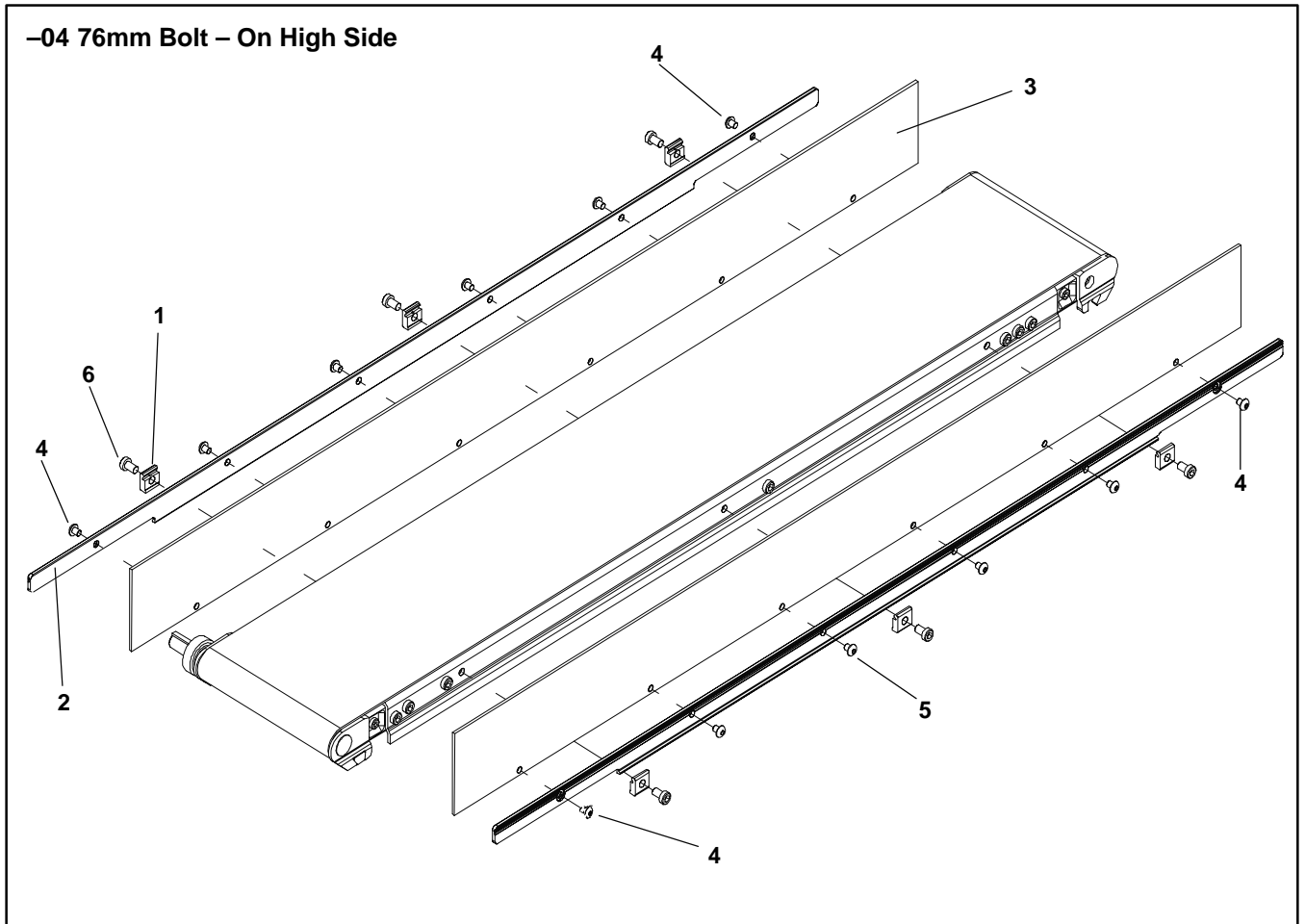
2	460250	Clip Mounting Guide
3	920691M	Socket Head Cap Screw (Metric) Low M6–1.00 x 10mm

-03 Bolt – On Side Wiper



Item	Part Number	Description
1	460232	Rail Guide 13mm HS x 610mm
	460233	Rail Guide 13mm HS x 914mm
	460234	Rail Guide 13mm HS x 1219mm
	460235	Rail Guide 13mm HS x 1524mm
	460236	Rail Guide 13mm HS x 1829mm

2	460250	Clip Mounting Guide
3	41-00-24	Wiper Side Nylatron (per foot)
4	920691M	Socket Head Cap Screw (Metric) M6–1.0 x 10mm

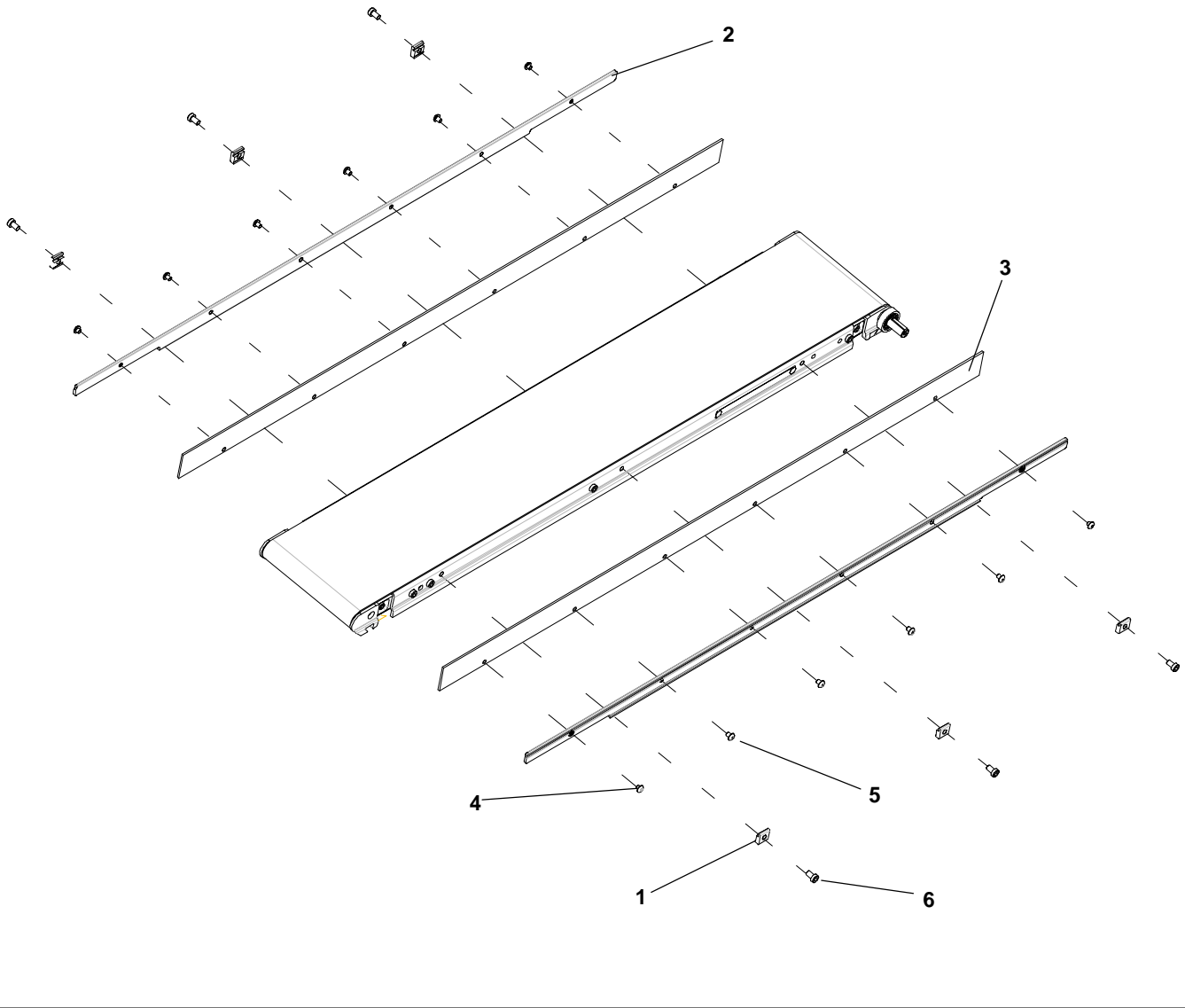


Item	Part Number	Description
1	460250	Clip Mounting Guide
2	460432	Rail guide 13mm HS w/holes 610mm
	460433	Rail guide 13mm HS w/holes 914mm
	460434	Rail guide 13mm HS w/holes 1219mm
	460435	Rail guide 13mm HS w/holes 1524mm
	460436	Rail guide 13mm HS w/holes 1829mm
3	460452M	Guide Side #4 – 610mm
	460453M	Guide Side #4 – 914mm
	460454M	Guide Side #4 – 1219mm
	460455M	Guide Side #4 – 1524mm
	460456M	Guide Side #4 – 1829mm

4	910504M	Socket Head Cap Screw Button (Metric) M5 – .80 x 4mm
5	910506M	Socket Head Cap Screw Button (Metric) M5-.80 x 6mm
6	920691M	Socket Head Cap Screw (Metric) M6-1.0 x 10MM

Service Parts

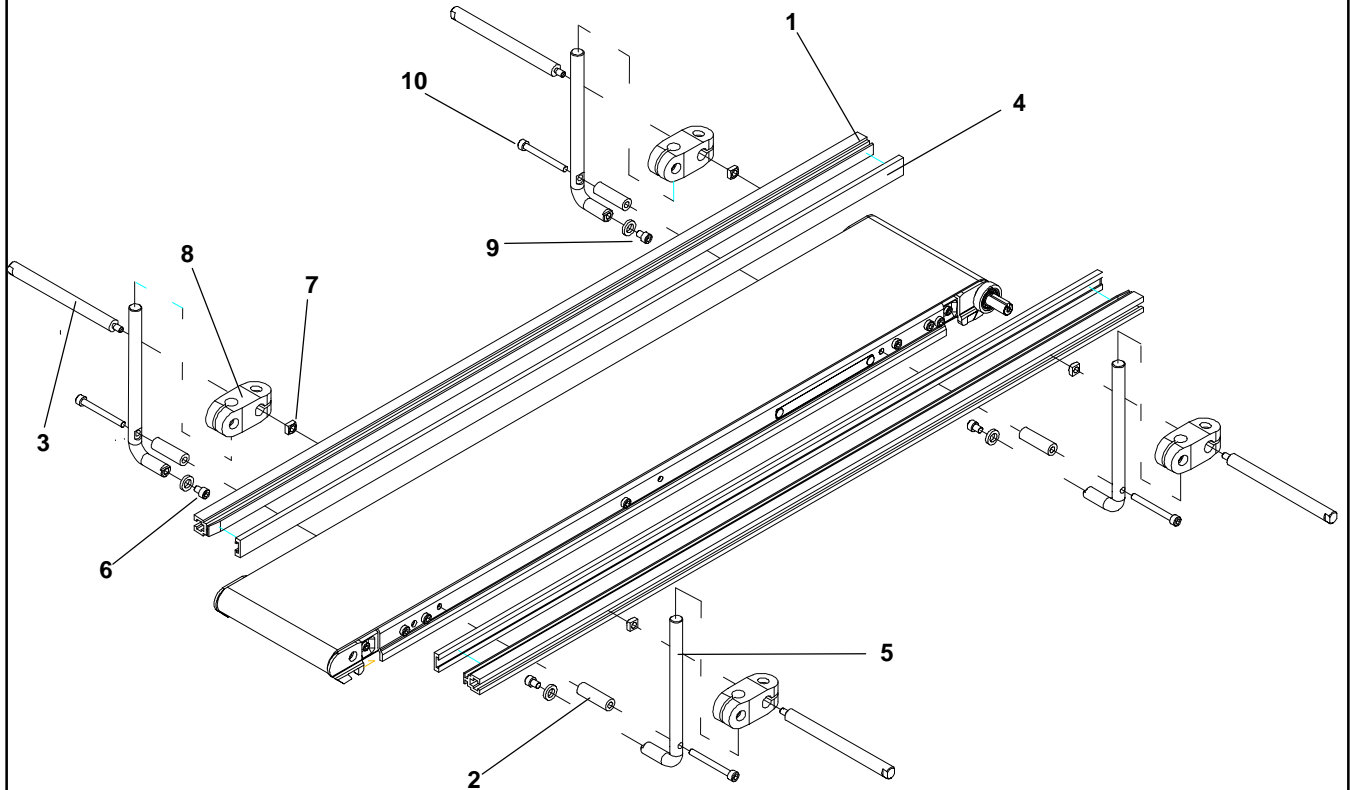
-05 38mm Bolt – On High Side



Item	Part Number	Description
1	460250	Guide Mounting Clip
2	460432	Rail guide 13mm HS w/holes 610mm
	460433	Rail guide 13mm HS w/holes 914mm
	460434	Rail guide 13mm HS w/holes 1219mm
	460435	Rail guide 13mm HS w/holes 1524mm
	460436	Rail guide 13mm HS w/holes 1829mm
3	460452M	Guide Side #4 – 610mm
	460453M	Guide Side #4 – 914mm
	460454M	Guide Side #4 – 1219mm
	460455M	Guide Side #4 – 1524mm
	460456M	Guide Side #4 – 1829mm

4	910504M	Socket Head Cap Screw Button (Metric) M5-.80 x 4mm
5	910506M	Socket Head Cap Screw Button (Metric) M5-.80 x 6mm
6	920691M	Socket Head Cap Screw (Metric) Low M6-1.0 x 10mm

-13 Fully Adjustable UHMW Guide

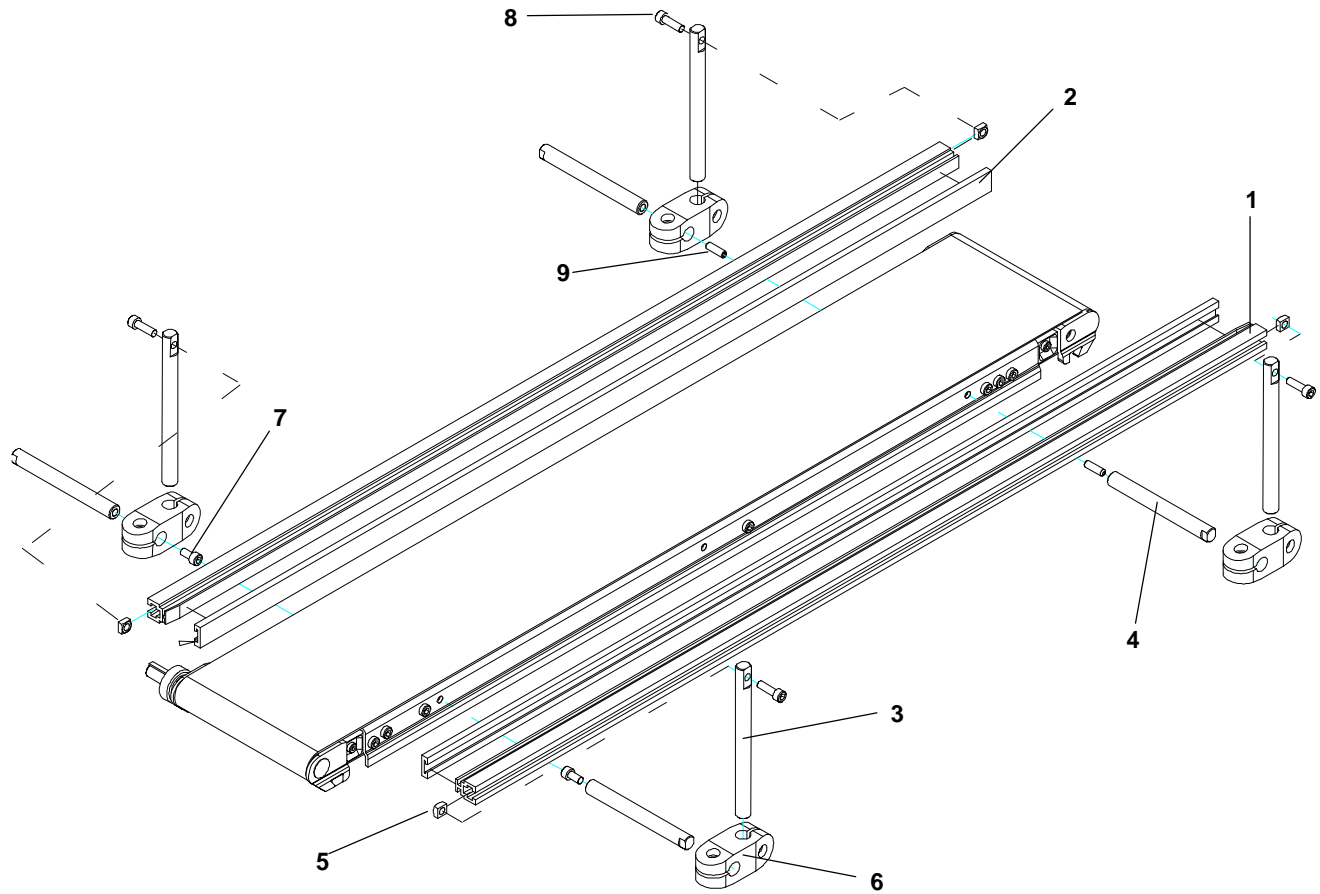


Item	Part Number	Description
1	202983	Guide Mounting Rail 610mm
	202984	Guide Mounting Rail 914mm
	202985	Guide Mounting Rail 1219mm
	202986	Guide Mounting Rail 1524mm
	202987	Guide Mounting Rail 1829mm
	202988	Guide Mounting Rail 2134mm
	202989	Guide Mounting Rail 2438mm
	202990	Guide Mounting Rail 2743mm
	202991	Guide Mounting Rail 3053mm
	202992	Guide Mounting Rail 3353mm
	202993	Guide Mounting Rail 3658mm
	202994	Guide Mounting Rail 3962mm

2	461351	Shaft Brace
3	202028M	Horizontal Shaft Mounting Guide
4	614068	Guide Extruded Flat (per foot)
5	461350M	Vertical Shaft Adj Guide
6	605279M	Hard washer
7	674175MP	Square Nut M6-1.0 w/1/4-20
8	807-652	Cross Block
9	920608M	Socket Head Cap Screw (Metric) M6-1.0 x 8mm
10	920655M	Socket Head Cap Screw (Metric) M6-1.0 x 55mm

Service Parts


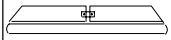
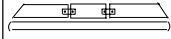
-20 Adjustable Width UHMW Guide

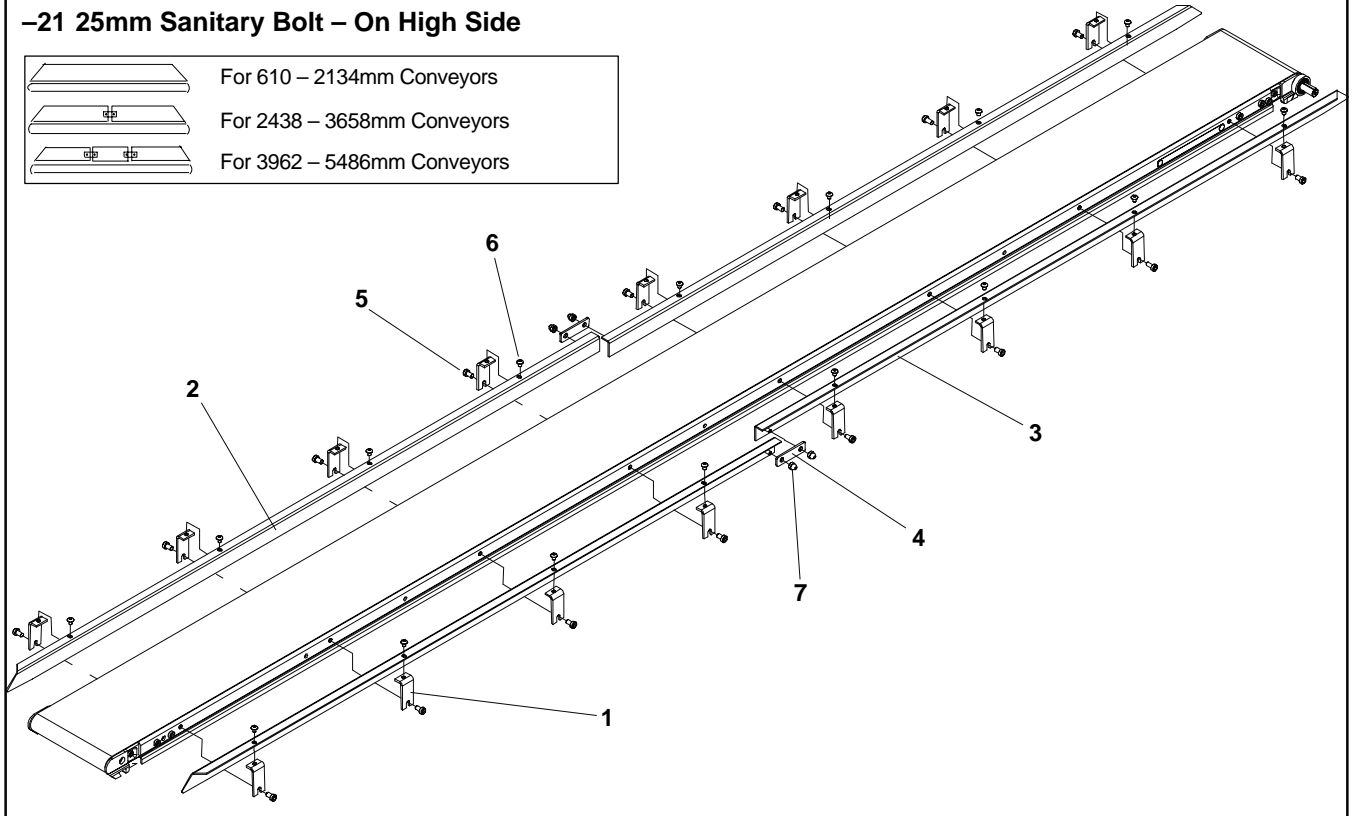


Item	Part Number	Description
1	202983	Guide Mounting Rail 610mm
	202984	Guide Mounting Rail 914mm
	202985	Guide Mounting Rail 1219mm
	202986	Guide Mounting Rail 1524mm
	202987	Guide Mounting Rail 1829mm
	202988	Guide Mounting Rail 2134mm
	202989	Guide Mounting Rail 2438mm
	202990	Guide Mounting Rail 2743mm
	202991	Guide Mounting Rail 3048mm
	202992	Guide Mounting Rail 3353mm
	202993	Guide Mounting Rail 3658mm
	202994	Guide Mounting Rail 3962mm

2	614068	Guide extruded flat (per foot)
3	462050M	Vertical Shaft Gullwing Guide
4	462052M	Horizontal Shaft Gullwing Guide
5	674175MP	Square Nut M6-1.0 w/1/4-20
6	807-652	Cross Block
7	920612M	Socket Head Cap Screw (Metric) M6-1.0 x 12mm
8	920620M	Socket Head Cap Screw (Metric) M6-1.0 x 20mm
9	970620M	Socket Head Set Screw (Metric) M6-1.0 x 20mm

-21 25mm Sanitary Bolt – On High Side

	For 610 – 2134mm Conveyors
	For 2438 – 3658mm Conveyors
	For 3962 – 5486mm Conveyors



Item	Part Number	Description
1	462150MSS	25mm Guide Mounting Bracket
2	See chart below	25mm Guide RH
3	See chart below	25mm Guide LH
4	450188SS	Guide Tie Plate
5	960608MSS	M6-1.0 x 8mm Hex Head Screw
6	960506MSS	M5-0.8 x 6mm Hex Head Screw
7	990508MSS	M5 Acorn Nut

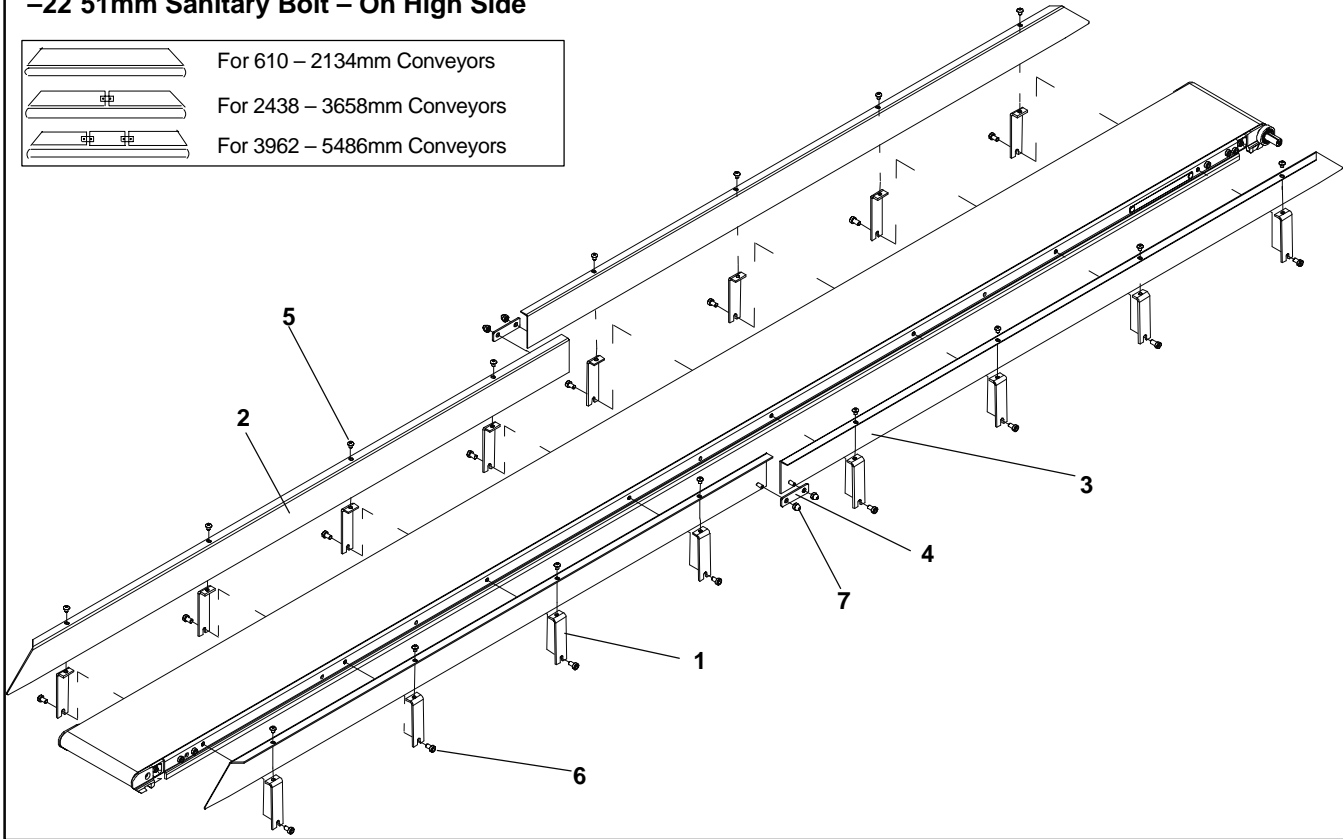
Conveyor Length		End Guide	Center Guide	End Guide
610mm	Right Hand	462132SSP	N/A	N/A
	Left Hand	462132SSP	N/A	N/A
914mm	Right Hand	462133SSP	N/A	N/A
	Left Hand	462133SSP	N/A	N/A
1219mm	Right Hand	462134SSP	N/A	N/A
	Left Hand	462134SSP	N/A	N/A
1524mm	Right Hand	462135SSP	N/A	N/A
	Left Hand	462135SSP	N/A	N/A
1829mm	Right Hand	462136SSP	N/A	N/A
	Left Hand	462136SSP	N/A	N/A
2134mm	Right Hand	462137SSP	N/A	N/A
	Left Hand	462137SSP	N/A	N/A

2438mm	Right Hand	462144SSP	N/A	462154SSP
	Left Hand	462154SSP	N/A	462144SSP
2743mm	Right Hand	462144SSP	N/A	462154SSP
	Left Hand	462145SSP	N/A	462155SSP
3048mm	Right Hand	462155SSP	N/A	462145SSP
	Left Hand	462145SSP	N/A	462155SSP
3353mm	Right Hand	462146SSP	N/A	462156SSP
	Left Hand	462145SSP	N/A	462155SSP
3658mm	Right Hand	462146SSP	N/A	462156SSP
	Left Hand	462156SSP	N/A	462146SSP
3962mm	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462144SSP	462163SSP	462154SSP
4267mm	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462145SSP	462163SSP	462155SSP
4572mm	Right Hand	462146SSP	462163SSP	462156SSP
	Left Hand	462156SSP	462163SSP	462146SSP
4877mm	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462144SSP	462166SSP	462154SSP
5182mm	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462145SSP	462166SSP	462155SSP
5486mm	Right Hand	462146SSP	462166SSP	462156SSP
	Left Hand	462156SSP	462166SSP	462146SSP

Service Parts

-22 51mm Sanitary Bolt – On High Side

	For 610 – 2134mm Conveyors
	For 2438 – 3658mm Conveyors
	For 3962 – 5486mm Conveyors

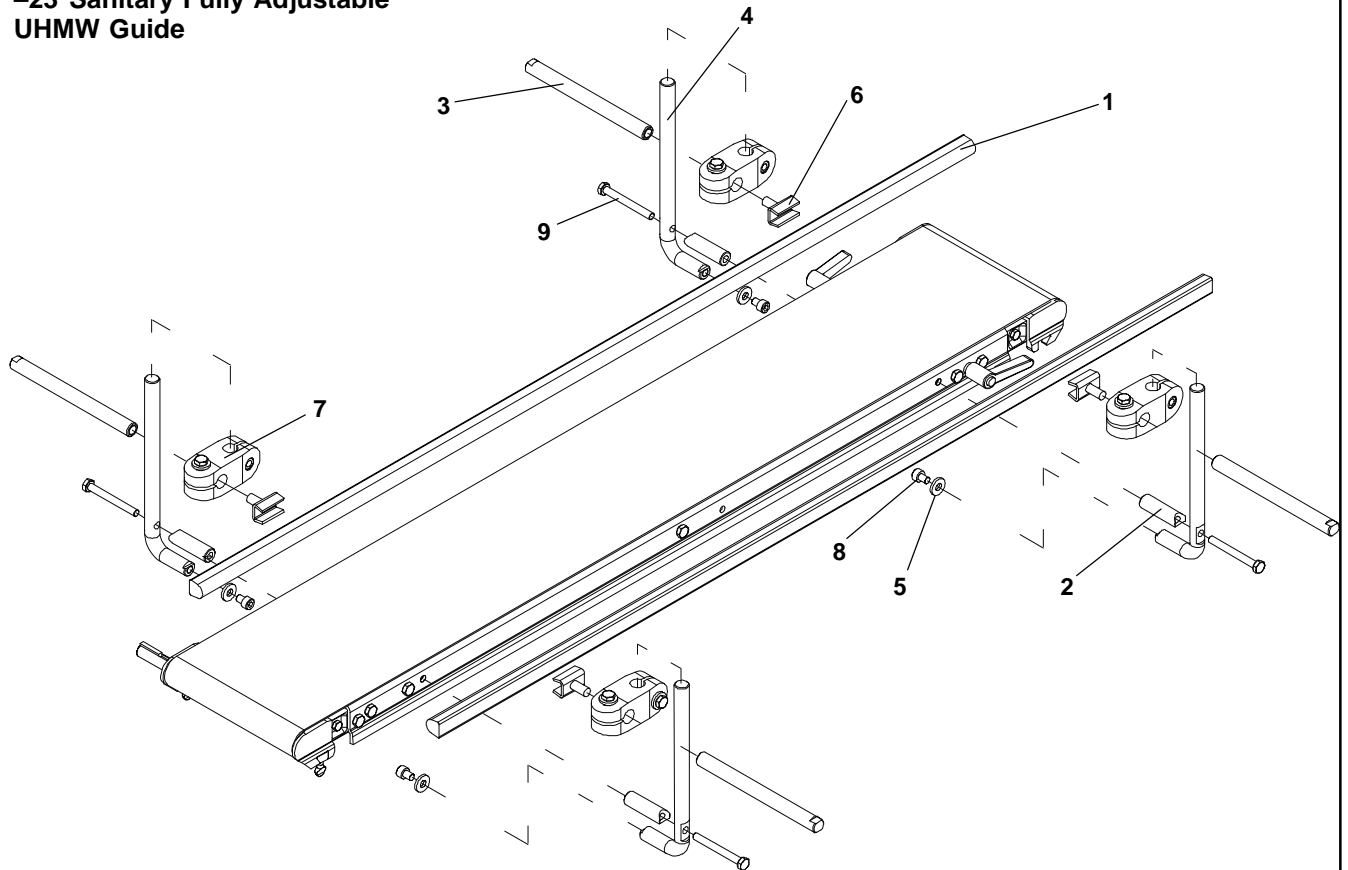


Item	Part Number	Description
1	462250MSS	51mm Guide Mounting Bracket
2	See chart below	51mm Guide RH
3	See chart below	51mm Guide LH
4	450188SS	Guide Tie Plate
5	960608MSS	M6–1.0 x 10mm Hex Head Screw
6	960506MSS	M5–0.8 x 6mm Hex Head Screw
7	990508MSS	M5 Acorn Nut

Conveyor Length		End Guide	Center Guide	End Guide
610mm	Right Hand	462232SSP	N/A	N/A
	Left Hand	462232SSP	N/A	N/A
914mm	Right Hand	462233SSP	N/A	N/A
	Left Hand	462233SSP	N/A	N/A
1219mm	Right Hand	462234SSP	N/A	N/A
	Left Hand	462234SSP	N/A	N/A
1524mm	Right Hand	462235SSP	N/A	N/A
	Left Hand	462235SSP	N/A	N/A
1829mm	Right Hand	462236SSP	N/A	N/A
	Left Hand	462236SSP	N/A	N/A
2134mm	Right Hand	462237SSP	N/A	N/A
	Left Hand	462237SSP	N/A	N/A

2438mm	Right Hand	462244SSP	N/A	462254SSP
	Left Hand	462254SSP	N/A	462244SSP
2743mm	Right Hand	462244SSP	N/A	462254SSP
	Left Hand	462245SSP	N/A	462255SSP
3048mm	Right Hand	462255SSP	N/A	462245SSP
	Left Hand	462245SSP	N/A	462255SSP
3353mm	Right Hand	462246SSP	N/A	462256SSP
	Left Hand	462245SSP	N/A	462255SSP
3658mm	Right Hand	462246SSP	N/A	462256SSP
	Left Hand	462256SSP	N/A	462246SSP
3962mm	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462244SSP	462263SSP	462254SSP
4267mm	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462245SSP	462263SSP	462255SSP
4572mm	Right Hand	462246SSP	462263SSP	462256SSP
	Left Hand	462256SSP	462263SSP	462246SSP
4877mm	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462244SSP	462266SSP	462254SSP
5182mm	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462245SSP	462266SSP	462255SSP
5486mm	Right Hand	462246SSP	462266SSP	462256SSP
	Left Hand	462256SSP	462266SSP	462246SSP

-23 Sanitary Fully Adjustable UHMW Guide

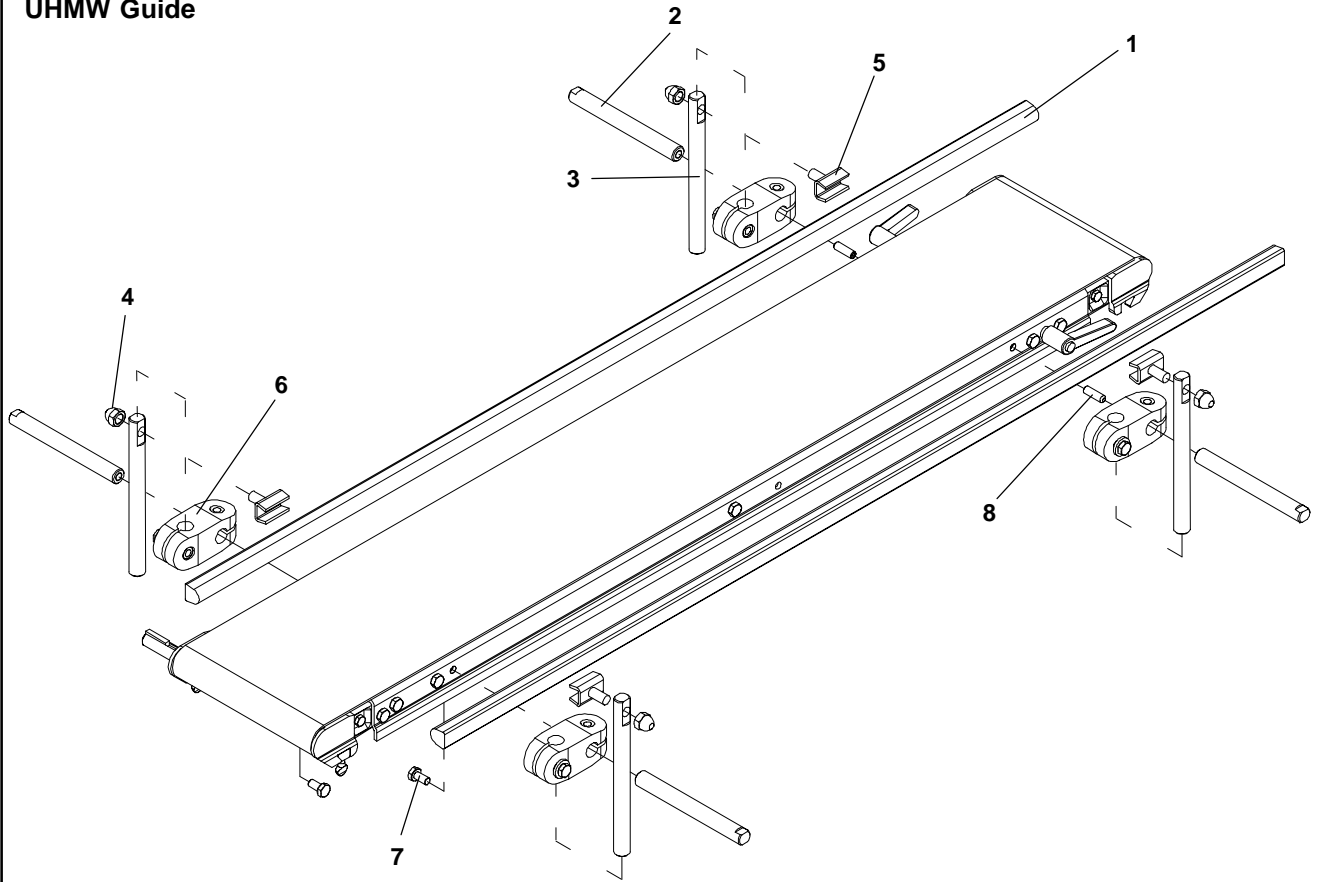


Item	Part Number(s)	Description
1	462332	Guide Mounting Rail 610mm
	462333	Guide Mounting Rail 914mm
	462334	Guide Mounting Rail 1219mm
	462335	Guide Mounting Rail 1524mm
	462336	Guide Mounting Rail 1829mm
	462337	Guide Mounting Rail 2134mm
	462338	Guide Mounting Rail 2438mm
	462339	Guide Mounting Rail 2743mm
	462340	Guide Mounting Rail 3053mm
	462341	Guide Mounting Rail 3353mm
	462342	Guide Mounting Rail 3658mm
	462337 462336	Guide Mounting Rail 3962mm
	462337 462337	Guide Mounting Rail 4267mm
	462338 462337	Guide Mounting Rail 4572mm
	462338 462338	Guide Mounting Rail 4877mm
	462339 462338	Guide Mounting Rail 5182mm
	462339 462339	Guide Mounting Rail 5486mm

2	462351MSS	Shaft Brace
3	462352MSS	Horizontal Shaft Mounting Guide
4	462350MSS	Vertical Shaft Adjustable Guide
5	911-201	Flat Washer
6	807-978	Guide Clamp
7	450787MSS	Cross Block
8	960608MSS	Hex Head Screw (Metric) M6-1.0 x 8mm
9	960655MSS	Hex Head Screw (Metric) M6-1.0 x 55mm

Service Parts

-24 Sanitary Adjustable Width UHMW Guide



Item	Part Number(s)	Description
1	462332	Guide Mounting Rail 610mm
	462333	Guide Mounting Rail 914mm
	462334	Guide Mounting Rail 1219mm
	462335	Guide Mounting Rail 1524mm
	462336	Guide Mounting Rail 1829mm
	462337	Guide Mounting Rail 2134mm
	462338	Guide Mounting Rail 2438mm
	462339	Guide Mounting Rail 2743mm
	462340	Guide Mounting Rail 3053mm
	462341	Guide Mounting Rail 3353mm
	462342	Guide Mounting Rail 3658mm
	462337 462336	Guide Mounting Rail 3962mm
	462337 462337	Guide Mounting Rail 4267mm
	462338 462337	Guide Mounting Rail 4572mm
	462338 462338	Guide Mounting Rail 4877mm
	462339 462338	Guide Mounting Rail 5182mm
	462339 462339	Guide Mounting Rail 5486mm

2	462452MSS	Horizontal Shaft Gullwing Guide
3	462450MSS	Vertical Shaft Gullwing Guide
4	807-977	Acorn Nut
5	807-978	Guide Clamp
6	450187MSS	Cross Block
7	960612MSS	Hex Head Cap Screw (Metric) M6-1.0 x 12mm
8	970620MSS	Socket Head Set Screw (Metric) M6-1.0 x 20mm

Configuring Conveyor Belt Part Number

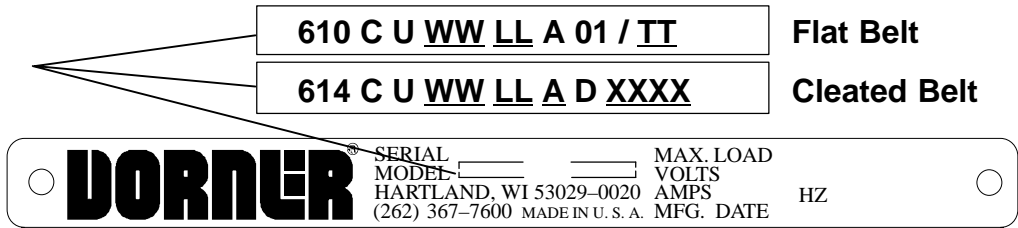


Figure 45

Flat Belt Conveyor

Refer to your serial and model number plate (Figure 45). Determine conveyor length ("LL"), width ("WW") and belt type ("TT").

61 - WW LL / TT

61- _____ / _____
(Fill In)

Cleated Belt Conveyor

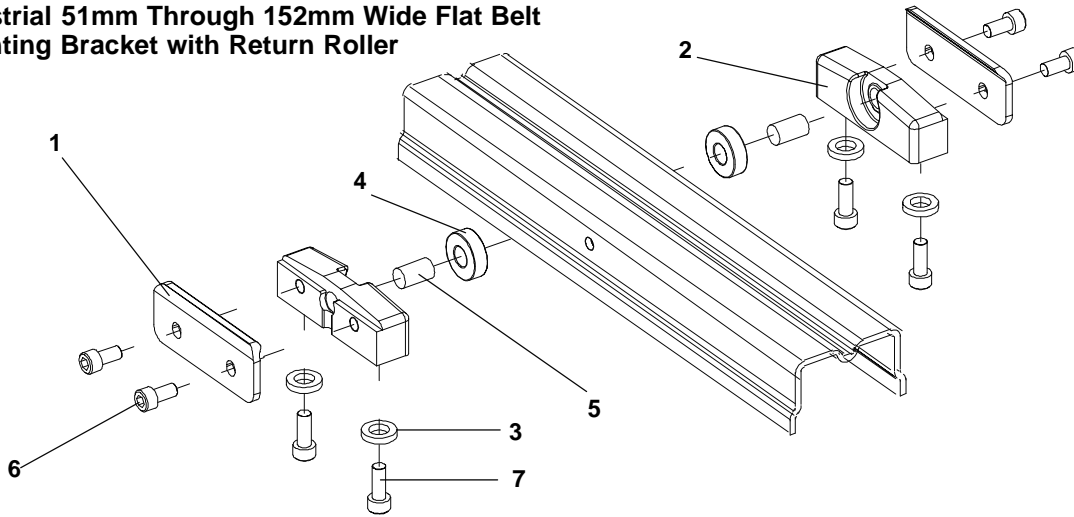
Refer to your serial and model number plate (Figure 45). Determine conveyor length ("LL"), width ("WW"), cleat type ("AA") and cleat spacing ("XXXX").

64 - WW LL AA XXXX

64 - _____
(Fill In)

Service Parts

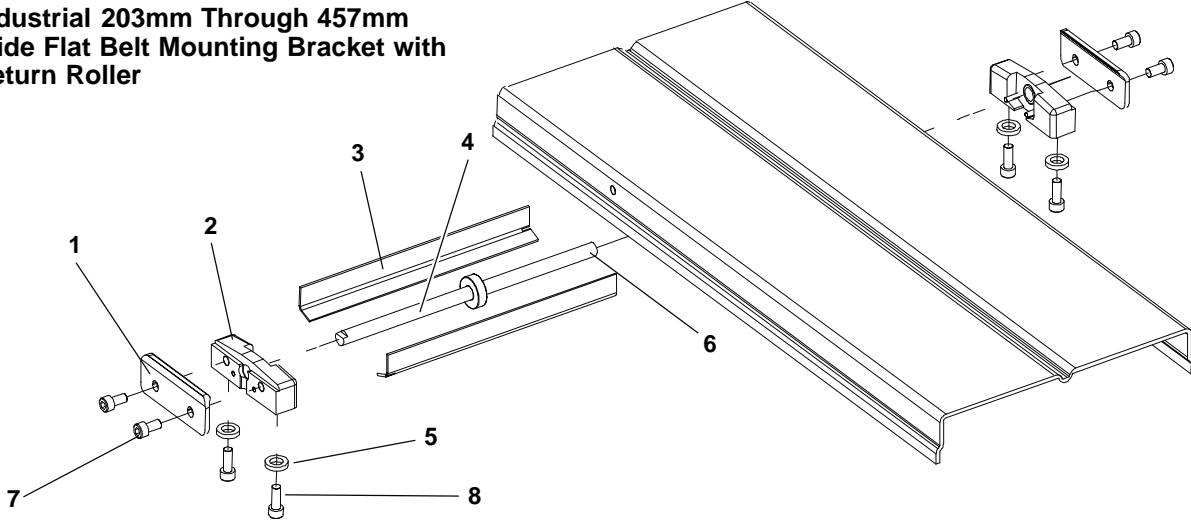
Industrial 51mm Through 152mm Wide Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492564M	Clamp Plate
2	493026M	Mounting Block
3	605279P	Washer
4	802-123	Bearing

5	913-103	Dowel Pin
6	920612M	Socket Head Cap Screw (Metric) M6 - 1.0 x 12mm
7	920616M	Socket Head Cap Screw (Metric) M5-.8 x 16mm

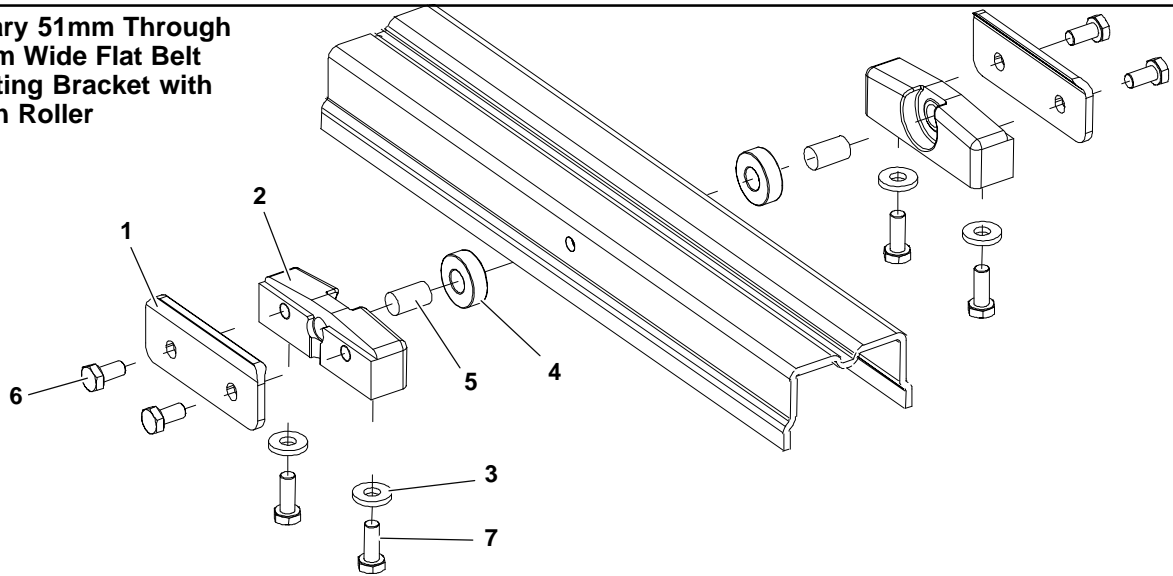
Industrial 203mm Through 457mm Wide Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492564M	Clamp Plate
2	492571M	Mounting Block
3	493108SSP	Bottom Roller Guard 203mm
	493110SSP	Bottom Roller Guard 254mm
	493112SSP	Bottom Roller Guard 305mm
	493118SSP	Bottom Roller Guard 457mm

4	493308SS	Shaft Assembly Belt Support 203mm
	493310SS	Shaft Assembly Belt Support 254mm
	493312SS	Shaft Assembly Belt Support 305mm
	493318SS	Shaft Assembly Belt Support 457mm
5	605279P	Hard Washer
6	807-1019	Groove Pin
7	920612M	Socket Head Cap Screw (Metric) M6-1.0 x 12mm
8	920616M	Socket Head Cap Screw (Metric) M6-1.0 x 16mm

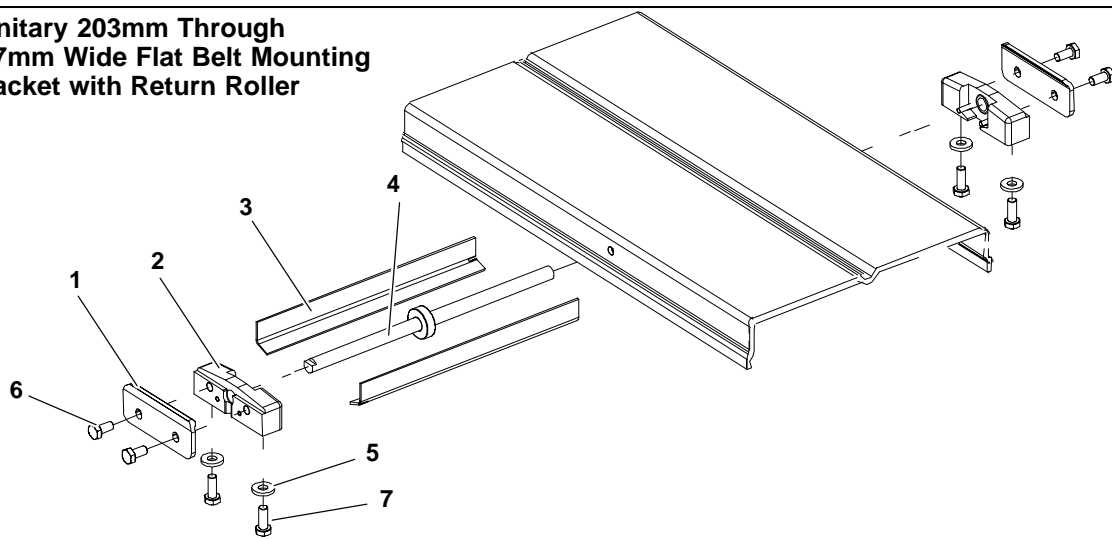
Sanitary 51mm Through 152mm Wide Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492564SS	Clamp Plate
2	493026MSS	Mounting Block
3	911-201	Washer
4	802-123	Bearing

5	913-103	Dowel Pin
6	960612MSS	Hex Head Screw (Metric) M6 – 1.0 x 12mm
7	960616MSS	Hex Head Screw (Metric) M6-1.0 x 16mm

Sanitary 203mm Through 457mm Wide Flat Belt Mounting Bracket with Return Roller

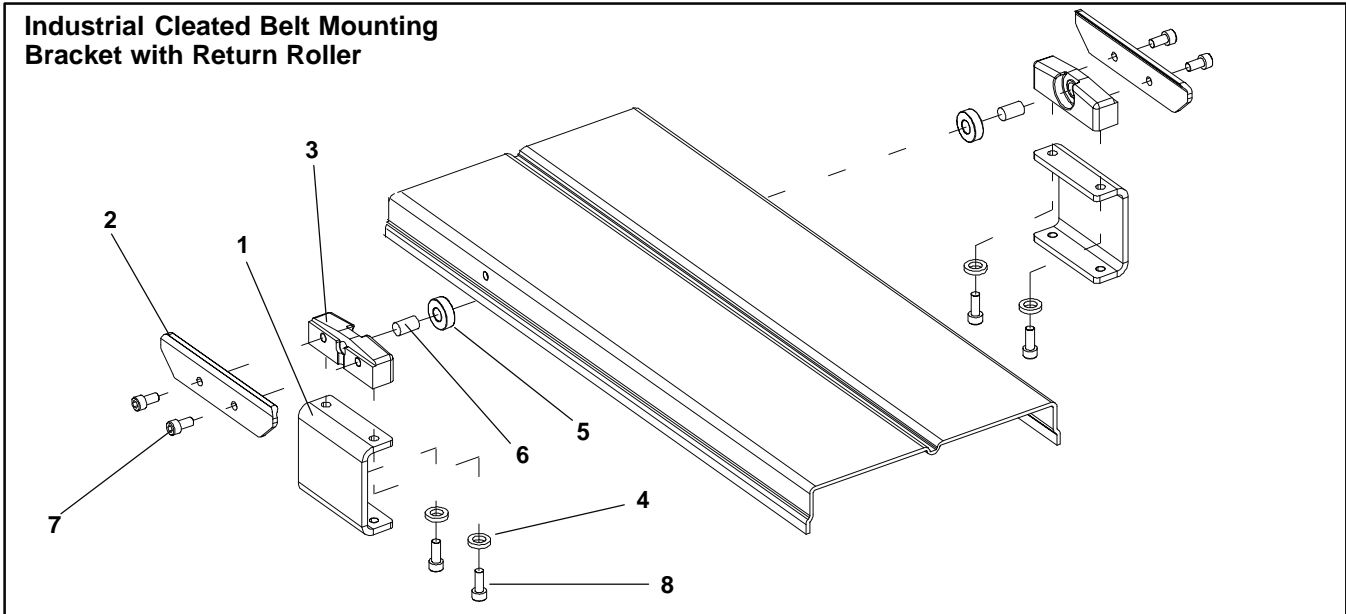


Item	Part Number	Description
1	492564SS	Clamp Plate
2	492571MSS	Mounting Block
3	493108SS	Bottom Roller Guard 203mm
	493110SS	Bottom Roller Guard 254mm
	493112SS	Bottom Roller Guard 305mm
	493118SS	Bottom Roller Guard 457mm

4	493308SS	Shaft Assembly Belt Support 203mm
	493310SS	Shaft Assembly Belt Support 254mm
	493312SS	Shaft Assembly Belt Support 305mm
	493318SS	Shaft Assembly Belt Support 457mm
5	911-201	Hard Washer
6	960612MSS	Hex Head Screw (Metric) M6-1.0 x 12mm
7	960616MSS	Hex Head Screw (Metric) M6-1.0 x 16mm

Service Parts

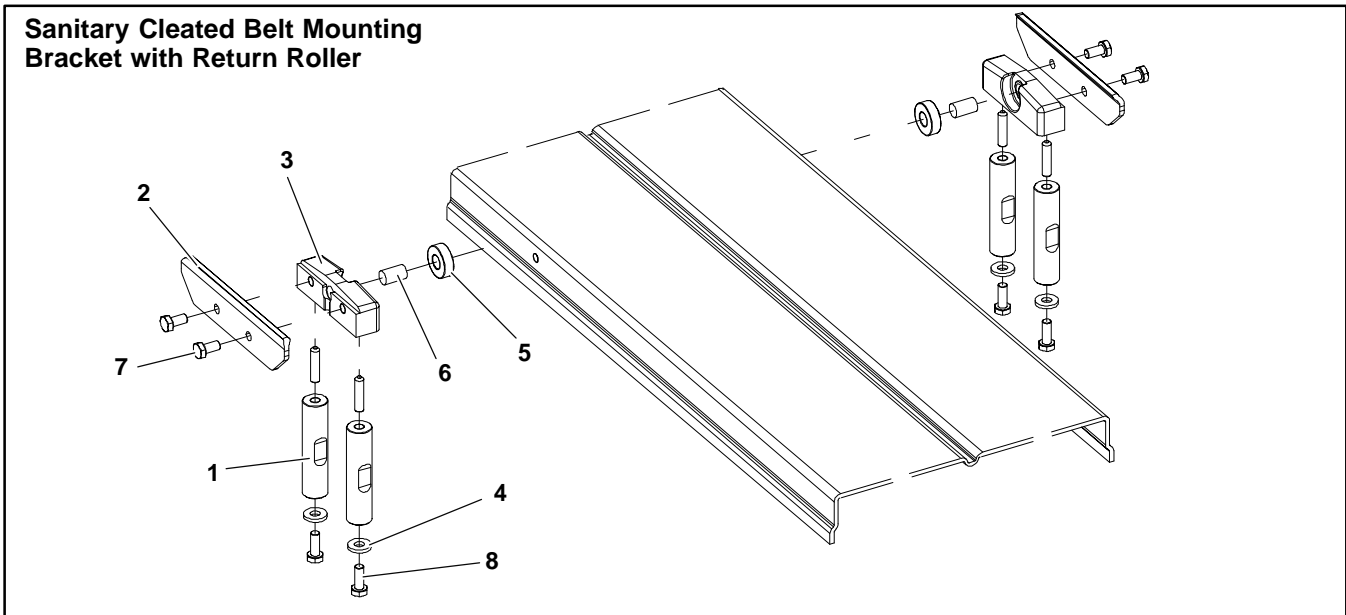
Industrial Cleated Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492565M	Bracket Riser Cleated Stand
2	492566M	Clamp Plate
3	493026M	Mounting Block
4	605279P	Washer

5	802-123	Bearing
6	913-103	Dowel Pin
7	920612M	Socket Head Cap Screw (Metric) M6-1.0 x 12mm
8	920616M	Socket Head Cap Screw (Metric) M6-1.0 x 16mm

Sanitary Cleated Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	492563MSS	Standoff Post
2	492566SS	Clamp Plate
3	493026MSS	Mounting Block
4	911-201	Washer
5	802-123	Bearing

6	913-103	Dowel Pin
7	960612MSS	Hex Head Screw (Metric) M6-1.0 x 12mm
8	970625MSS	Socket Head Set Screw (Metric) M6-1.0 x 25mm

Return Policy

No returns will be accepted without prior written factory authorization. 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. 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.

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

There will be a 15% restocking charge on all new items returned for credit where Dorner was not at fault. These will not be accepted after 60 days from original invoice date. The restocking charge covers inspection, cleaning, disassembly, and reissuing 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. Feel free to contact Dorner for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dorner products.

For a copy of Dorner's Limited Warranty, contact factory, distributor, service center or visit our website at www.dorner.com.

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