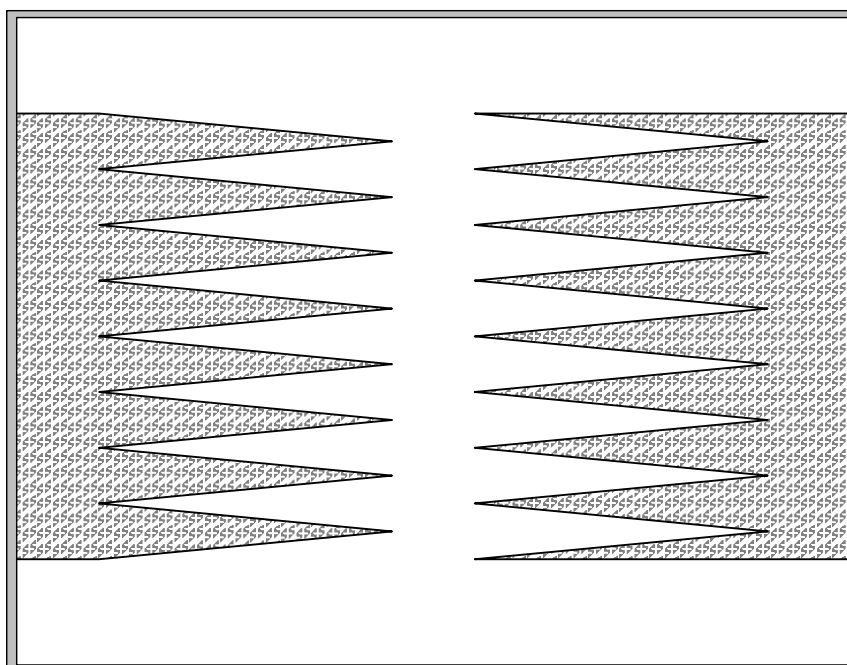




Operating Instructions for 7000 Series Finger Splice Cutter



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

Table of Contents

Specifications	2	Return Policy.....	6
Instructions for Cutting Dorner Belting	2		
Blade Removal & Sharpening (Figure 2)	5		

Specifications

Model	7002	7003
Overall Dimensions		
Height x Width x Length in " (mm)	6 x 24 x 33 (152) x (610) x (838)	6 x 24 x 57 (152) x (610) x (1,448)
Weight in pounds (kilograms)	85 (39)	120 (54)
Maximum Width of Cut in " (mm)	24.5 (622)	42.5 (1080)
Maximum Cutting Depth in " (mm)	0.125 (3)	
Size of "V" Cut in " (mm)	0.5 (13) x 2.6 (66)	

Instructions for Cutting Dorner Belting

1. Move the arm assembly (Figure 1, item A) to the right end (B) of the pivot tube (C) by lifting up on the pivot handle (D) and pushing on the bearing block (E), moving it to the right. Rotate the arm assembly (A) over the pivot tube (C) and out of the way of the cutting area.

WARNING

Very sharp blades are located under the spring loaded blade shields (F). NEVER manually press down on the blade shields or injury could occur.

2. Raise both the front clamp bar (G) and the rear clamp bar (H) by turning the respective clamp screws (I) counter clockwise until at least 1/4" gap exists under the clamp bars, or until the bars release from the hold down magnets.
3. Load the belt into the cutter by feeding it from the back (J), under the pivot tube (C) and under the rear and front clamp bars (H & G) until the leading belt edge is protruding from under the front clamp bar (G). Align the side of the belt with the front and rear edge guides (K).
4. Secure the belt by lowering the rear clamp bar (H) with the clamp screw (I) on each end. Keeping the belt taut, lower the front clamp bar (G). Tighten the clamp screws on both clamp bars until resistance is felt, then back off 1/4 turn, on the handle, to release tension, allowing magnets to secure the belt. If handles are pointing towards the belt, lift and turn them away from the cutting area.
5. Rotate the arm assembly (A) back over so the cutter head (L) is over the zig-zag cut area. Lifting the arm assembly (A) at the pivot handle (D), push near the bearing block (E) to slide along the pivot tube (C) until the cutter head (L) is located approximately 1" away from the right edge of the belt. Lower the pivot handle (D) so the cutter head (L) is aligned over the guide pins (M).
6. Start cutting sequence as follows:
 - a. Lift the pivot handle (D) to rotate the arm assembly (A) up while applying sideways pressure to the left until the tips of the guide pins (M) can be seen under the cutter head (L).
 - b. Lower the pivot handle (D) while still applying left sideways pressure until the cutting blades contact the belt surface. The cutter head (L) should have moved 1/2" from the previous cut. If there was not enough sideways pressure applied or the arm assembly (A) was not rotated high enough, the cutter will not advance to the next "V" cut location. If too much sideways pressure was applied or the arm assembly (A) rotated too high, the cutter head (L) will skip over a "V" cut.
 - c. Once the cutter head (L) is located over the correct location, press down on the pivot handle (D), forcing the blades through the belt until the cutter head (L) bottoms out.
 - d. Continue to repeat this cutting sequence until the bearing block (E) is at the left end of the pivot tube (C).
 - e. Inspect the belt to ensure all cut ends overlap each other and no "V" cuts have been missed. If necessary, reposition the cutting head (L) over the insufficiently cut area and cut again.
 - f. When cutting is complete, move the arm assembly (A) out of the way, as in step 1.
7. Mark the belt location by placing a small pen line or piece of adhesive tape at the front edge of the rear clamp bar (H). Raise the front clamp bar (G) with the clamp screws (I) to remove and discard the narrow piece of belt. Raise the rear clamp bar (H) and pull the belt under the front clamp bar (G).
8. Advance the belt out of the operator side of the cutter until the length of the belt exposed is longer than the loop length of the belt to be made. Carefully measure the loop length of the belt, to be cut, starting at the pen mark or tape mark near the "V" cuts. Place a new mark,

Instructions for Cutting Dorner Belting

with a pen or adhesive tape, at the desired loop length. Pull the belt backwards, through the cutter, until the new mark is aligned with the front edge of the rear clamp bar (H). Align the side of the belt with the edge guides (K), while keeping the mark lined up with the rear clamp bar (H) edge. Repeat steps 4, 5 and 6.

9. Raise the front clamp bar (G) and remove the belt. The belt is now ready for bonding together. The remaining portion of the belting can be used for the next belt loop required by repeating step 3 through step 8, using the “V” cuts and the mark that already exists for one end of the belt.
10. If the need arises to cut an endless loop apart, remove both the front clamp bar (G) and the rear clamp bar (H), by unscrewing the clamp screws (I) all the way out. Then, unscrew the knob (N), on each end, and remove the pivot tube (C).

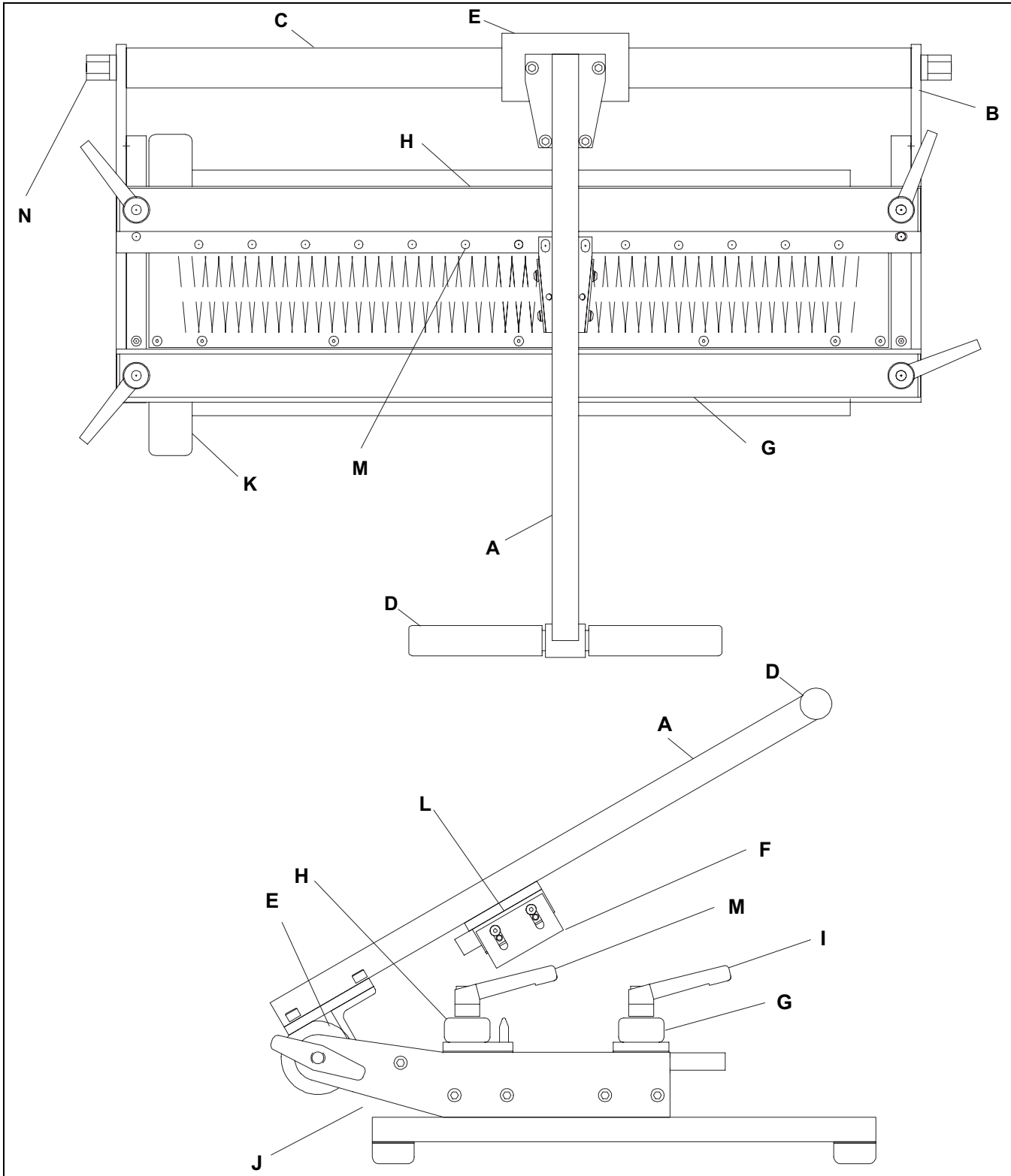
IMPORTANT

Strong magnets, located under the friction strips, create powerful forces on the clamp bars. Take care to ensure the clamp bars are not brought too close to the magnets, until the clamp screws are started in their respective threaded holes. Replace the clamp bars and tighten down the clamp screws, as in step 4, to secure the belt. Replace the pivot tube, ensuring the arm assembly is in the correct orientation, and then, secure it with the pivot tube knobs. The belt can now be cut apart following step 6.

NOTE

Both clamp screws, on each clamp bar, must be turned simultaneously to prevent possible binding. Unscrew the pivot tube knobs and remove the pivot tube with the arm assembly. Exercise care, when putting down the arm assembly, so that the blades do not contact a hard surface and dull the cutting edges or so that the blades do not contact another surface and damage it. Place the belt over the backup mat and against the edge guides.

Instructions for Cutting Dornier Belting



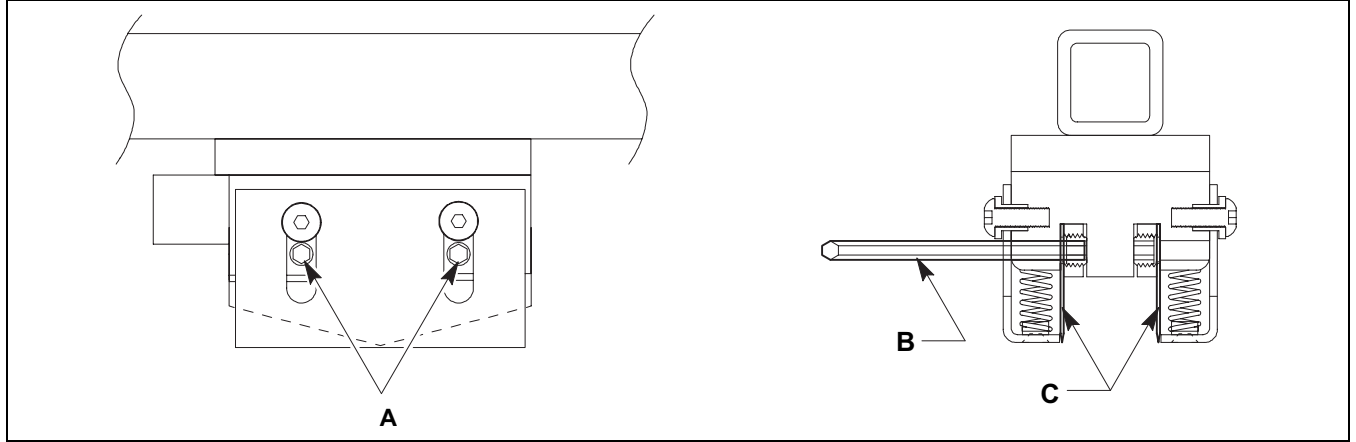
Cutter (Top View) Showing Handle Side as Operator Side & (Bottom View) Showing End View from Left Side

Figure 1

Instructions for Cutting Dorner Belting

Blade Removal & Sharpening (Figure 2)

When cutting performance begins to deteriorate, the blades should be sharpened. To remove blades, unscrew the jackscrews (Figure 1, item A) with 5/32" hex key wrench (B). Carefully slide blades out. Sharpen blades (C) by honing on an oilstone at a 10° angle. Replace blades in the cutter head and tighten jackscrews. Replacement blade sets are available by ordering part number 665190.



Blade Removal & Sharpening Detail

Figure 2

Dorner Belt Splicing Equipment is covered by patents 5,499,565 and 5,562,796

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.

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

There will be a return charge on all new undamaged items returned for credit where Dorner was not at fault. Dorner is not responsible for return freight on such items.

Conveyors and conveyor accessories	
Standard catalog conveyors	30%
MPB Series, cleated and specialty belt conveyors	50%
7400 & 7600 Series conveyors	non-returnable items
Engineered special products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

Parts	
Standard stock parts	30%
MPB, 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 Technical Sales, Catalog Sales and Service Teams 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. 2006

DORNER MFG. CORP.

975 Cottonwood Ave., PO Box 20
Hartland, WI 53029-0020 USA
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