

2100 Series Center Drive Conveyors

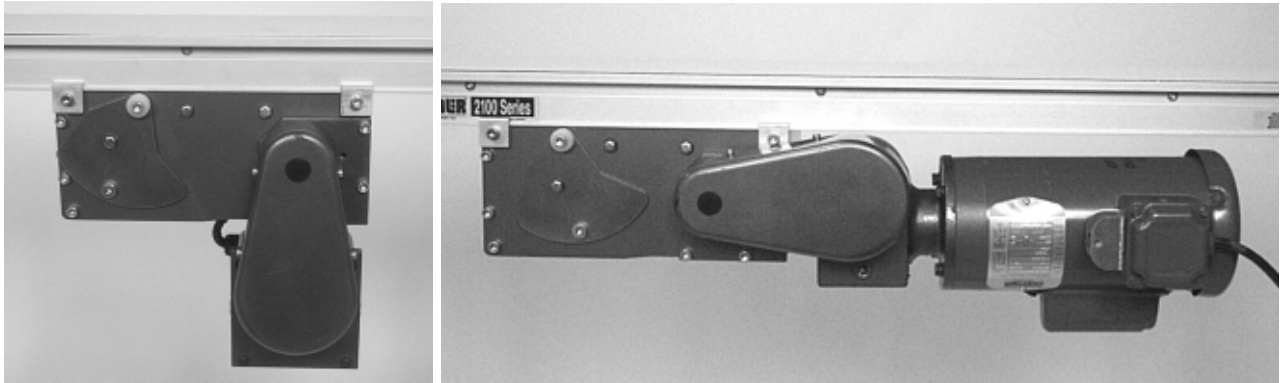




Table of Contents

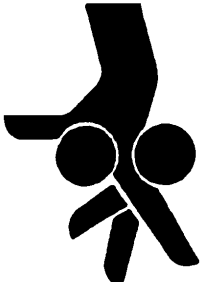

Warnings – General Safety	2	Conveyor Belt Replacement	8
Introduction	2	Conveyor Belt Replacement Sequence	8
Product Description	3	Belt Removal for Conveyor Without	
Specifications	3	Gearmotor Mounting Package or Stands	8
Installation	4	Belt Removal for Conveyor With Stands	
Required Tools	5	and/or Gearmotor Mounting Package	9
Standard Tools	5	Center Drive Module Removal	11
Recommended Installation Sequence	5	Belt Removal from Center Drive Module	11
Conveyors Up to 3962 mm	5	Installing a New Conveyor Belt	12
Conveyors Longer Than 3962 mm	5	Conveyor Belt Tensioning	14
Mounting Brackets with Return Rollers	6	Pulley Removal	14
44 mm to 152 mm Wide		A – End Pulley Removal	14
Flat Belt Conveyors	6	B – Drive Pulley Removal	15
Preventative Maintenance & Adjustment	7	C – Idler Pulley Removal	15
Required Tools	7	Bearing Replacement End Pulleys	16
Standard Tools	7	Bearing Removal	16
Special Tools	7	Bearing Installation	17
Checklist	7	Bearing Replacement for Drive Pulley	18
Lubrication	7	Bearing Removal	18
End Pulley Bearings	7	Bearing Installation	18
Drive Module Idler Pulley Bearings	7	Bearing Replacement for Idler Pulleys	18
Drive Module Drive Pulley Bearings	7	Pulley Replacement	18
Mounting Brackets with Return Rollers	7	Service Parts	19
Maintaining Conveyor Belt	8	Pulleys & Bearings	19
Troubleshooting	8	Configuring Conveyor Belt Part Number	20
Cleaning	8	Return Policy	22

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

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 2100 Series conveyors are covered by Patent No. 5,174,435, 5,131,529 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	Center Drive Module
C	Gearmotor Mounting Package
D	Guiding & Accessories
E	Gearmotor
F	Mounting Brackets with Return Rollers
G	Support Stands
H	Variable Speed Controller
I	Fixed End
J	Tension End

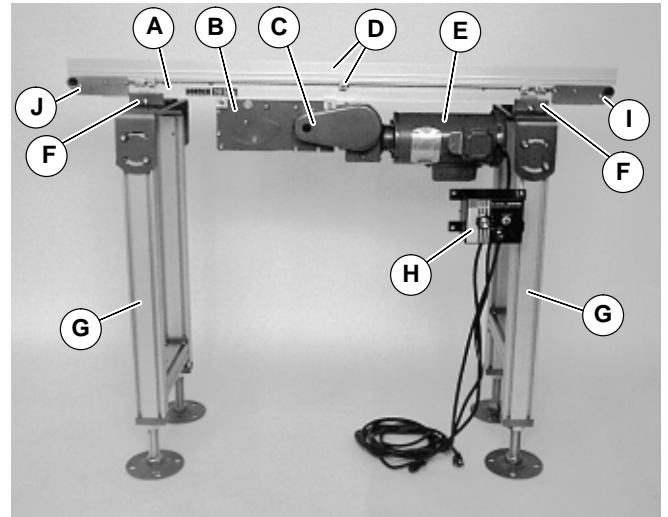
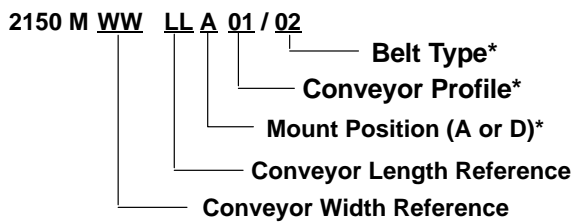


Figure 1

Specifications

Models:

2100 Series Center Drive Conveyor



* See "Ordering and Specifications" Catalog for details.

Conveyor Supports:

Maximum Distances:

K = 457 mm

L = 1829 mm**

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

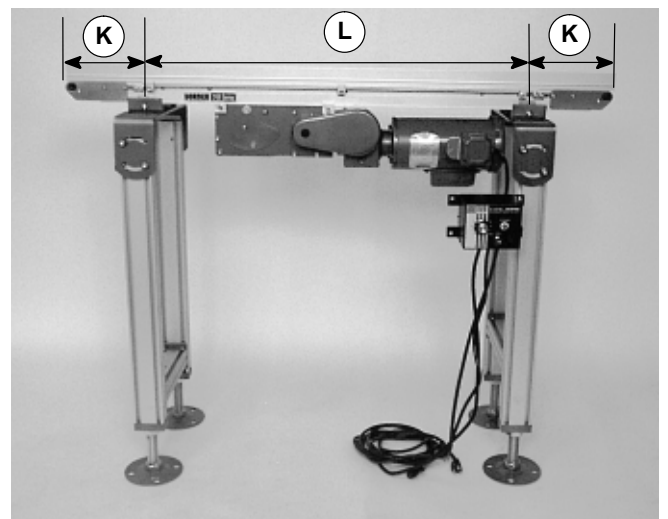


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12
Conveyor Belt Width	44 mm	70 mm	95 mm	127 mm	152 mm	203 mm	254 mm	305 mm
Maximum Conveyor Load* (See NOTE Below)	18 kg	23 kg	27 kg	34 kg	41 kg	47 kg	54 kg	54 kg
Conveyor Start-up Torque*	1.0 Nm	1.1 Nm	1.2 Nm	1.4 Nm	1.7 Nm	2.3 Nm	2.6 Nm	2.8 Nm
Belt Travel	88 mm per revolution of pulley							
Maximum Belt Speed*	72 meters/minute							
Belt Take-up	25 mm of stroke = 51 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	19	20	21	22	23	24
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	5791 mm	6096 mm	6401 mm	6706 mm	7010 mm	7315 mm

* See "Ordering and Specifications" Catalog for details.

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.

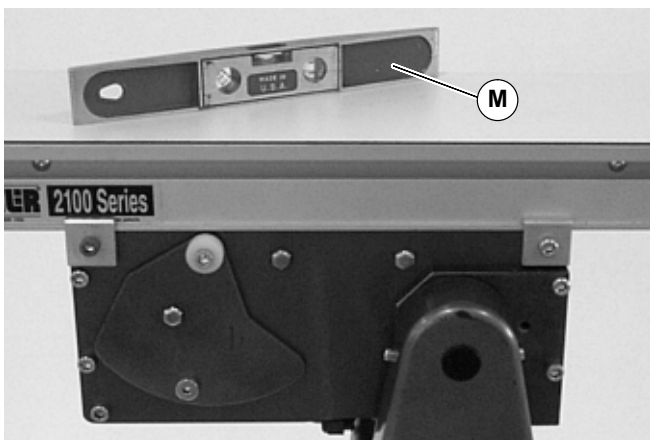


Figure 3

Installation Component List

N	Conveyor frame without belt
O	Conveyor frame with belt
P	Connector Strips (2x) (Attached to conveyor section)
Q	Mounting bracket with return roller
Z	Roller guards (2x)
AA	Mounting bracket end block (2x)

Required Tools

Standard Tools

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

Recommended Installation Sequence

NOTE: See Table of Contents for beginning page numbers of following procedures.

- Assemble conveyor (if required)
- Attach mounting bracket(s) with return roller to conveyor
- Install stands (see accessory instructions)
- Attach conveyor to stands
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see accessory instructions)

Conveyors Up to 3962 mm

No additional assembly is required.

Conveyors Longer Than 3962 mm

1. Typical components (Figure 4)

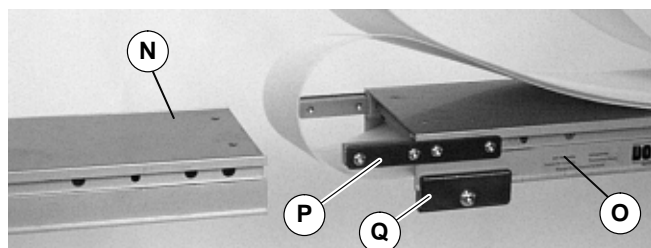



Figure 4

2. On tension end of the conveyor, identified with  label (R of Figure 5), loosen tracking cam assemblies (S) and cover plate screws (T) on both sides of the conveyor.

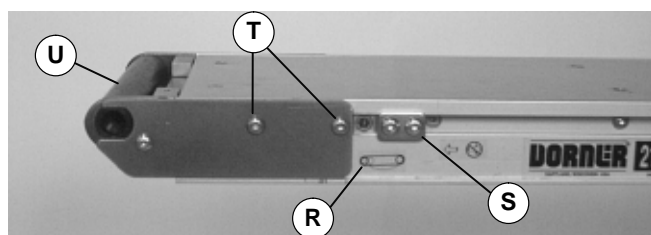


Figure 5

3. Slide the cam assemblies toward the center of the conveyor and push the end (U of Figure 5) into the conveyor frame.
4. Roll out conveyor belt.
5. Place conveyor frame (N of Figure 6) into belt loop.

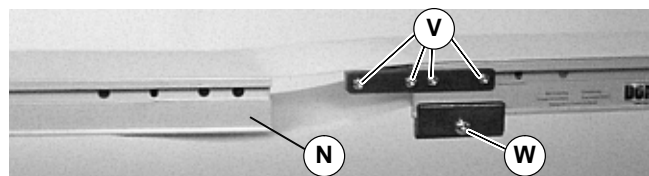


Figure 6

6. Loosen connector strip screws (V) and mounting bracket screws (W) on both sides of the conveyor.
7. Join conveyor sections (N and O of Figure 7). Position mounting bracket (P and Q) across conveyor sections.

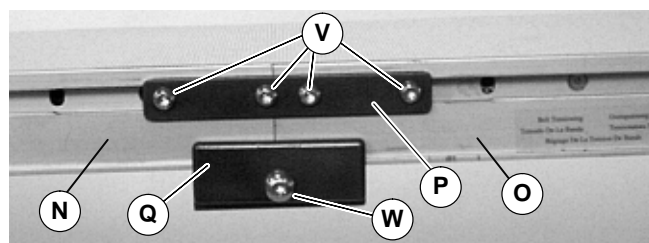


Figure 7

8. Tighten connector strip screws (V) to 2 Nm. Tighten bracket screws (W) to 9 Nm.
9. Insert a 5 mm hex key wrench into either end of the pinion gear (X of Figure 8). Rotate the pinion gear to extend the tensioning end gap (Y) to 30 mm.

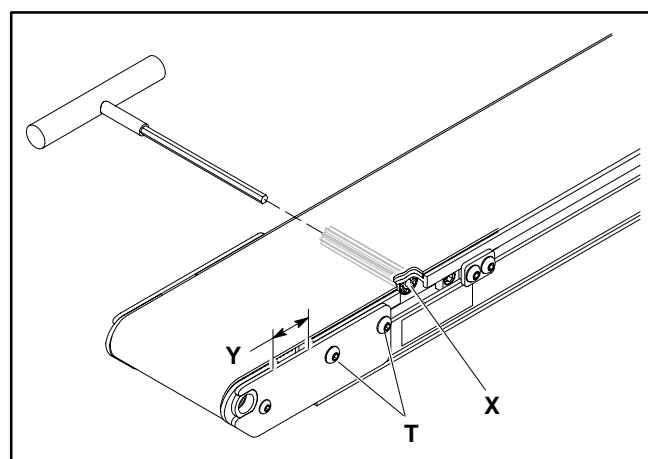


Figure 8

10. While holding the pinion gear (X), tighten cover plate screws (T) to 2 Nm.

Installation

Mounting Brackets with Return Rollers

44 mm to 305 mm Wide Flat Belt Conveyors

1. Typical components (Figure 9). Roller guards (Z) are shipped fastened to one end block (AA). Do NOT fasten to other block.

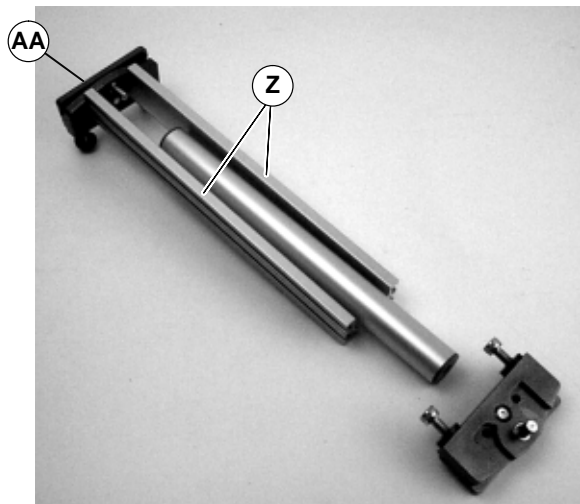


Figure 9

2. Loosen screws (AC of Figure 10) and remove screws and washers (AD).

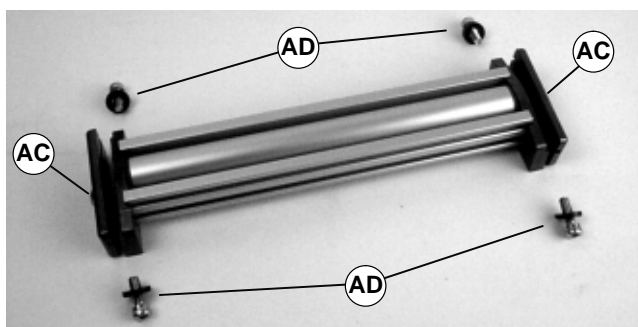


Figure 10

3. Attach clamp plates on each side of conveyor (Figure 11). Tighten the screws (AC) to 9 Nm.

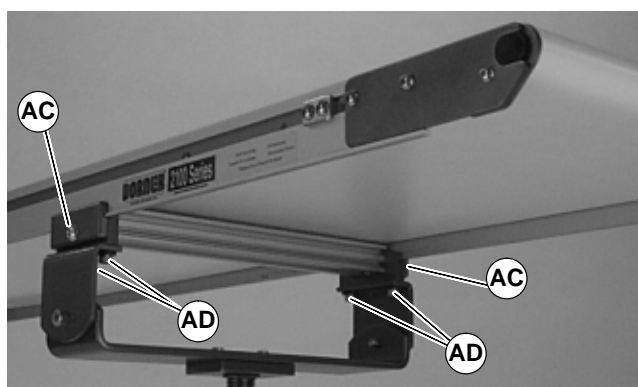


Figure 11

4. Attach to support stand. Tighten screws (AD) to 9 Nm. Make sure belt is free to move.

Preventive Maintenance and Adjustment

Required Tools

Standard Tools

- Hex key wrenches
 - 2 mm
 - 2.5 mm
 - 3 mm
 - 4 mm
 - 5 mm
 - 6 mm
- Small flat blade screwdriver
- Adjustable wrench
- Arbor press

Special Tools

- 2500M-ENG, 2100 Tool Kit
- 450282, Sealed Bearing Installation Tool

Checklist

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

Lubrication



Pulley Bearings

NOTE:

Optional permanent grease fittings (part number 200398M) may be installed.

NOTE:

44 mm wide conveyors use shielded ball bearings and do not require lubrication.

1. With a small flat-bladed screwdriver, remove plug (AE of Figure 12) from retainer (AF).

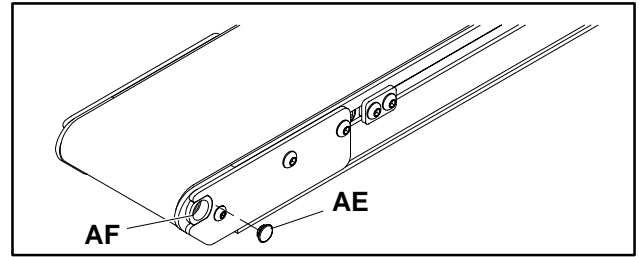


Figure 12

2. Install Dorner greasing adapter (AG of Figure 13), part number 200046M. Make sure the adapter shoulder is seated against the conveyor tail plate.

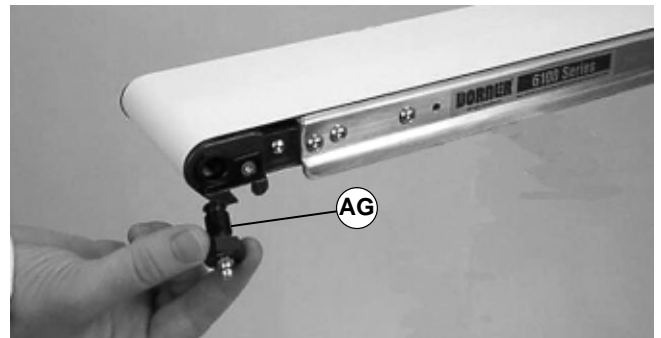


Figure 13

3. Use Dorner red grease, 397 gram cartridge (part # 829-002) or 397 gram can (part number 829-003). Lubricate pulley bearing every 750 hours or more frequently, depending on operating conditions.

NOTE: Lubricate pulley bearing every 750 hours or more frequently, depending on operating conditions. When lubricating pulley bearings, use a conventional hand grease gun with a maximum of one pump per application. *Do not over-lubricate.* Do not use a power grease gun.

4. Grease bearing with one (1) pump from a manual grease gun. Do not over-lubricate.
5. Remove grease adapter and install on opposite side of pulley. Repeat steps 2 and 4.

Drive Module Idler Pulley Bearings

No lubrication is required. Replace pulley if worn.

Drive Module Drive Pulley Bearings

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

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Improperly installed bottom wiper
- Accumulated dirt in wiper
- 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


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

Cleaning

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

Use Dorner Belt Cleaner (part number 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

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

NOTE: See Table of Contents for beginning page numbers of following procedures.

- Remove old conveyor belt
 - Conveyor without Gearmotor Mounting Package or Stands
 - Conveyor with Stands and/or Gearmotor Mounting Package
- Center Drive Module Removal
- Conveyor Belt Removal from Center Drive Module
- Install New Conveyor Belt
- Tension Conveyor Belt

Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands

1. From the discharge end, remove tail cover plate screws (AJ of Figure 14) from one side of the conveyor.

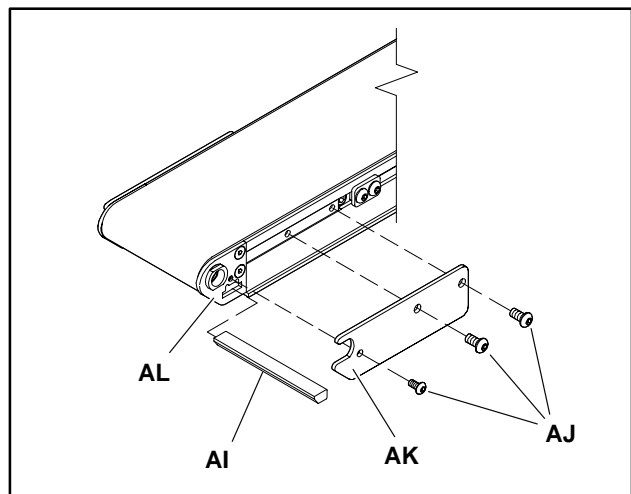


Figure 14

2. Remove tail cover plate (AK).
3. Slide bottom wiper (AI) through side slot of tail plate (AL).
4. If the conveyor is equipped with guiding and accessories, remove them from one side.

Preventive Maintenance and Adjustment

5. Loosen corner screws (AN of Figure 15), on each side of the center drive module (AO).

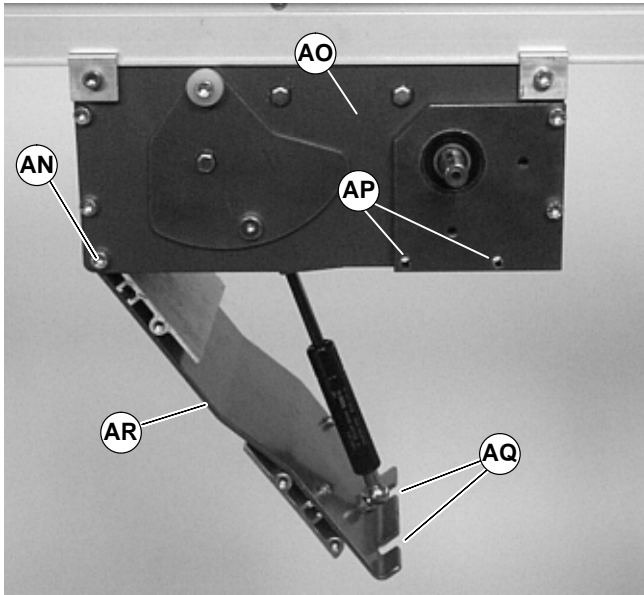



Figure 15

6. Remove tension door screws (AP) on each side of the center drive module.
7. Using finger grip holes (AQ), open the tension door (AR) to release conveyor belt tension.
8. On tension end of the conveyor, identified with  label (AS of Figure 16), loosen tracking cam assemblies (AT) and cover plate screws (AU) on both sides of the conveyor.

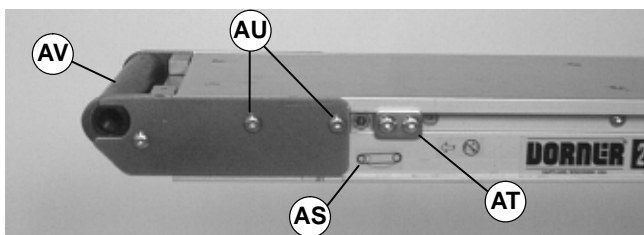


Figure 16

9. Slide the cam assemblies toward the center of the conveyor and push the end (AV) into the conveyor frame.

NOTE: On 1219 mm and shorter by 203 mm and wider conveyors, it will be necessary to remove the center drive module at the same time the conveyor belt is removed. See “Center Drive Module Removal” on page 11.

10. Remove conveyor belt.
11. Proceed to “Center Drive Module Removal” on page 11.

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

1. From the discharge end, remove tail cover plate screws (AJ of Figure 14) from one side of the conveyor.
2. Remove tail cover plate (AK).
3. Slide bottom wiper (AI) through side slot of tail plate (AL).
4. If the conveyor is equipped with guiding and accessories, remove them from one side.

NOTE: Figures 17 & 18 show a vertical mount in the A position with a parallel shaft gearmotor. Horizontal mount, D position and/or 90° gearmotor are similar.

5. Remove cover screws (AV of Figure 17) and remove cover (AW).

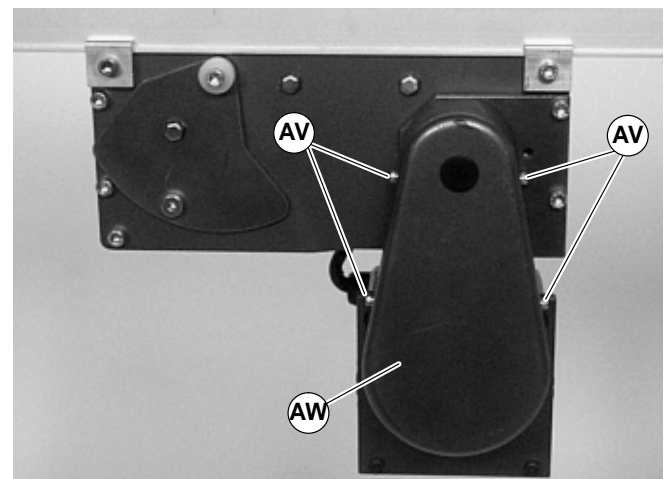


Figure 17

Preventive Maintenance and Adjustment

- Loosen belt tensioner (AX of Figure 18) then remove the belt (AY).

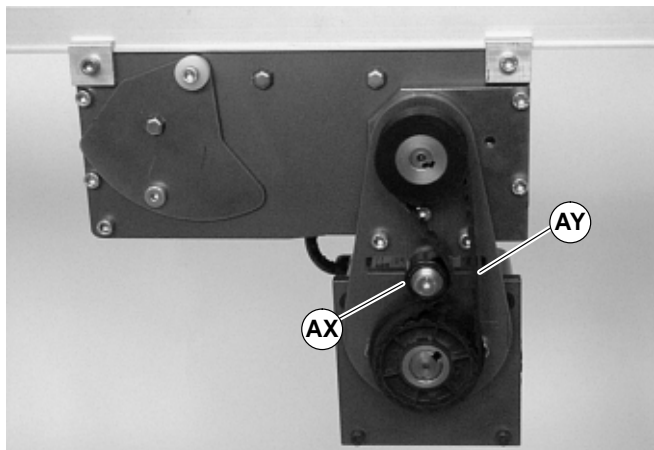


Figure 18

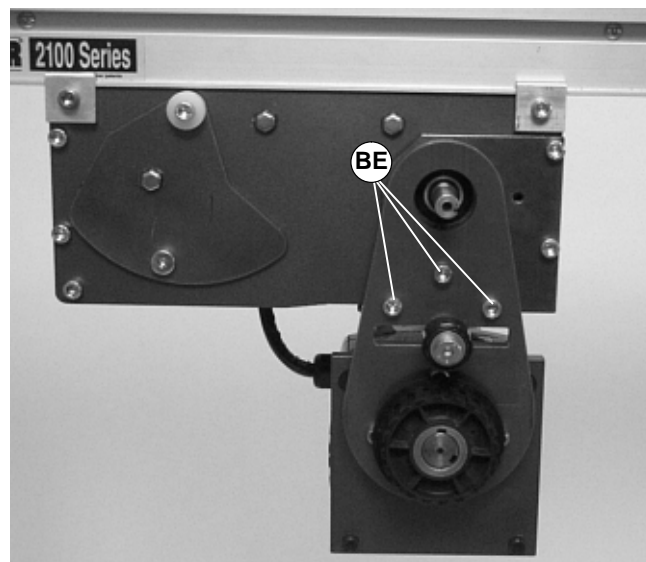


Figure 20

NOTE: If the timing belt does not slide over the pulley flange, loosen the driven pulley set screws (AZ of Figure 19) and remove the pulley (BA) with the belt (BB).

- Loosen corner screws (AN of Figure 15), on each side of the center drive module (AO).
- Remove tension door screws (AP) on each side of the center drive module.

NOTE: With vertical mounts, two cover screws (BE of Figure 20) were removed in step 7.

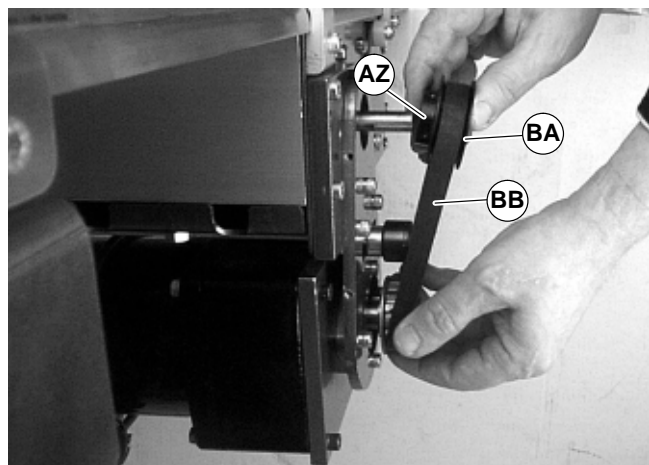



Figure 19

- Remove three mounting screws (BE of Figure 20) and remove gearmotor package.

- Using finger grip holes (AQ), open the tension door (AR) to release conveyor belt tension.
- On tension end of the conveyor, identified with  label (AS of Figure 16), loosen tracking cam assemblies (AT) and cover plate screws (AU) on both sides of the conveyor.
- Slide the cam assemblies toward the center of the conveyor and push the end (AV) into the conveyor frame.

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

Preventive Maintenance and Adjustment

NOTE: On 1219 mm and shorter by 203 mm and wider conveyors, it will be necessary to remove the center drive module at the same time the conveyor belt is removed. See “Center Drive Module Removal” (next section).

NOTE: To remove the belt, complete steps 13 & 14, at each stand location.

13. Loosen the mounting clamp plates (BF of Figure 21) on both sides of the conveyor. Raise the conveyor and remove the belt.

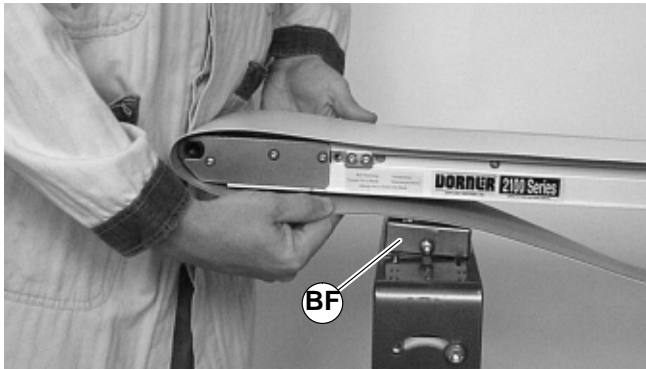


Figure 21

14. With the belt removed, secure the conveyor with clamp plates (BF).
15. Proceed to “Center Drive Module Removal”, (next section).

Center Drive Module Removal

	WARNING	
Before loosening clamps (BG of Figure 22), provide a support (BH) under center drive module.		

NOTE: If desired, mark center drive module location on conveyor.

1. Loosen clamp screws (BG of Figure 22) in each corner of the module.

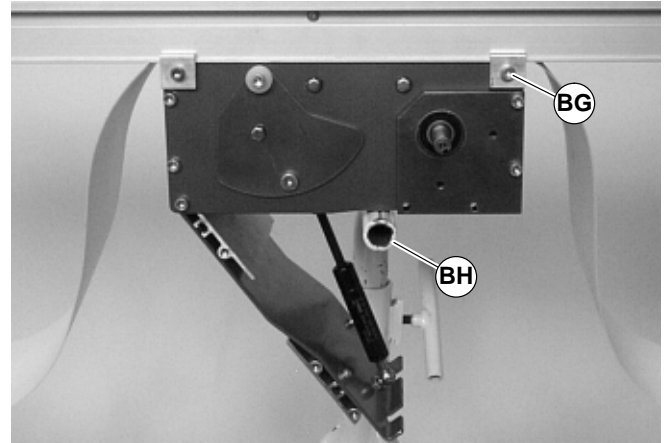


Figure 22

2. Remove the module.

Belt Removal from Center Drive Module

1. Remove drive plate screws (BI of Figure 23). Remove the tension drive plate (BJ).

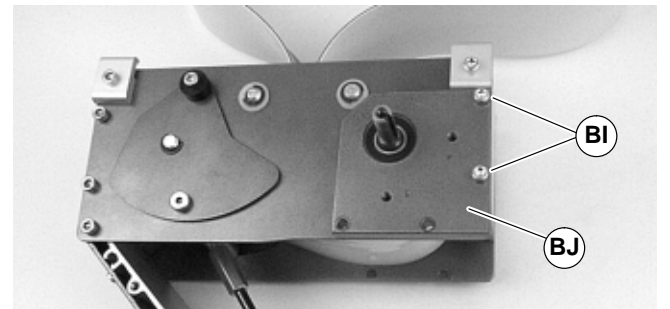


Figure 23

2. Remove drive pulley (BK of Figure 24).

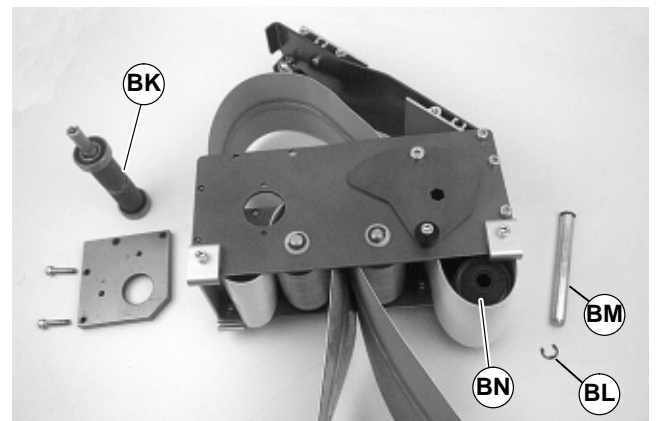


Figure 24

Preventive Maintenance and Adjustment

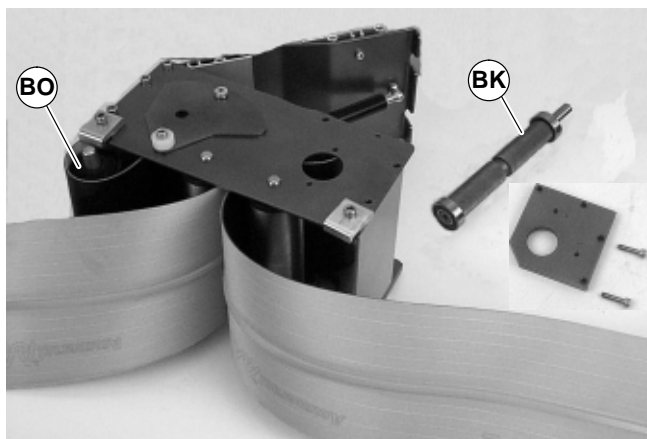


Figure 25

3. Remove grooved idler pulley:

- For 44 mm, 70 mm or 95 mm wide conveyor, detach E-ring clip (BL of Figure 24). Remove pulley shaft (BM) and remove pulley (BN).
 - For 127 mm or wider conveyor, depress both sides of spring-loaded shaft and remove pulley (BO of Figure 25).
4. Remove the conveyor belt.

Installing a New Conveyor Belt

IMPORTANT: On a center drive conveyors, belt travel direction is identified by an arrow decal on the side of the conveyor (BP of Figures 26 & 27).



Figure 26

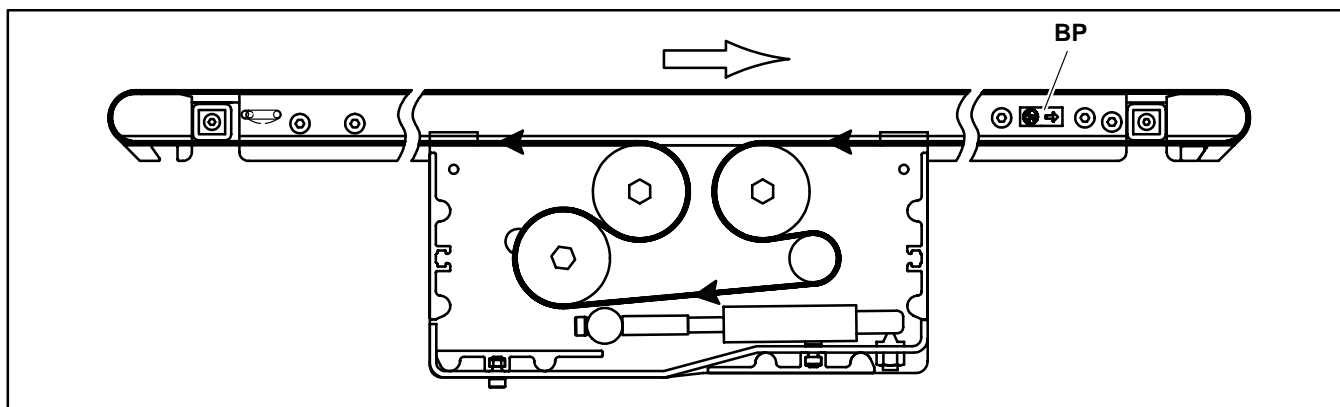


Figure 27

1. Orient the conveyor belt so that the splice leading fingers (BQ of Figure 28) point in the direction of belt travel as identified by the label (BP of Figure 26).

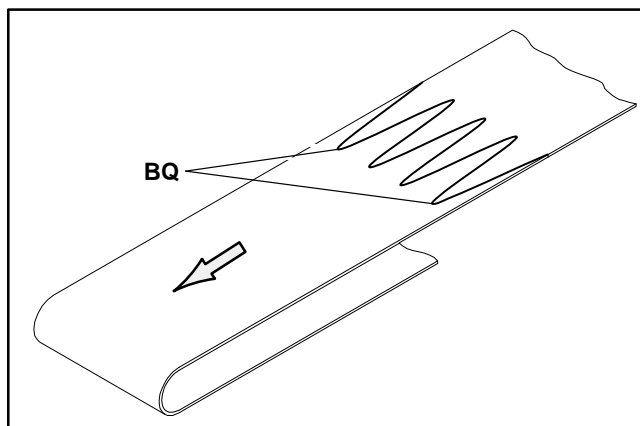


Figure 28

2. Place loop of belt into the drive module (Figure 29).

Preventive Maintenance and Adjustment

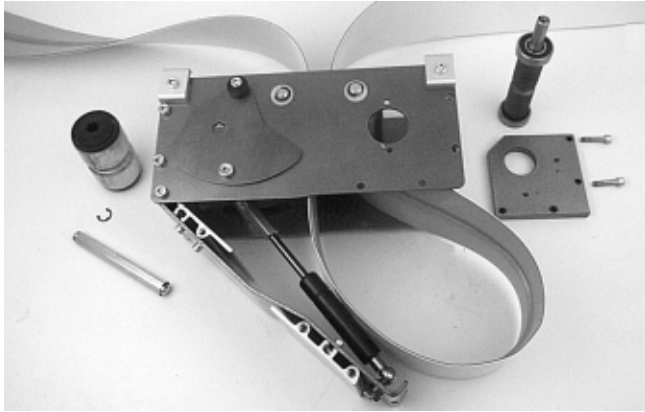


Figure 29

3. Place grooved idler pulley (BN of Figure 24 or BO of Figure 25) into the belt loop and install it in the drive module. Refer to “Belt Removal from Center Drive Module” on page 12 and reverse step 3.
4. Place drive pulley (BK of Figure 24 or 25) into the belt loop and install it in the drive module. Refer to “Belt Removal from Center Drive Module” on page 11 and reverse steps 1 and 2. Tighten screws (BI of Figure 23) to 9 Nm.

NOTE: On 1219 mm and shorter by 203 mm and wider conveyors, it will be necessary to replace the center drive module at the same time the conveyor belt is replaced.

5. Replace the center drive module onto the conveyor and attach clamps (BG of Figure 22) in each corner. Tighten screws to 9 Nm.

NOTE: On conveyor with stands, complete steps 6, 7 & 8 at each stand location.

6. Loosen the mounting clamp plates (BF of Figure 21), on both sides of the conveyor. Raise the conveyor and replace the belt.
7. Lower the conveyor onto the mounting blocks. Use care not to pinch belt.
8. Tighten clamp plate screws to 9 Nm.
9. Insert a 5 mm hex key wrench into either end of the pinion gear (BR of Figure 30). Rotate the pinion gear to extend the tensioning end gap (BU) to 30 mm.

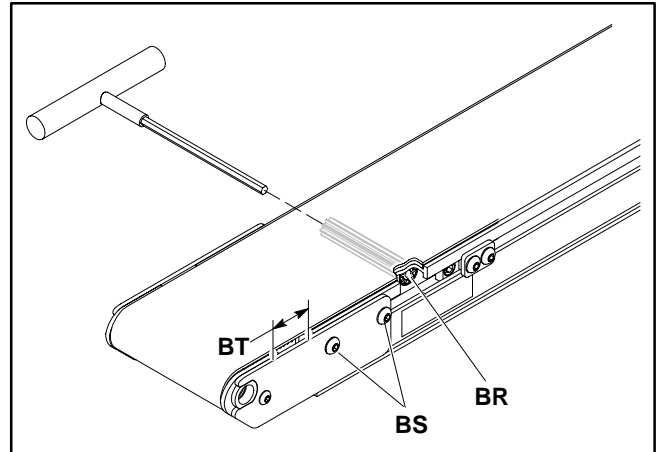


Figure 30

10. While holding the pinion gear (BR), tighten cover plate screws (BS) to 2 Nm.

	WARNING
	Tension door closes quickly, may cause injury. KEEP FINGERS CLEAR OF TENSION DOOR.

11. Carefully close the tension door (BU of Figure 31).

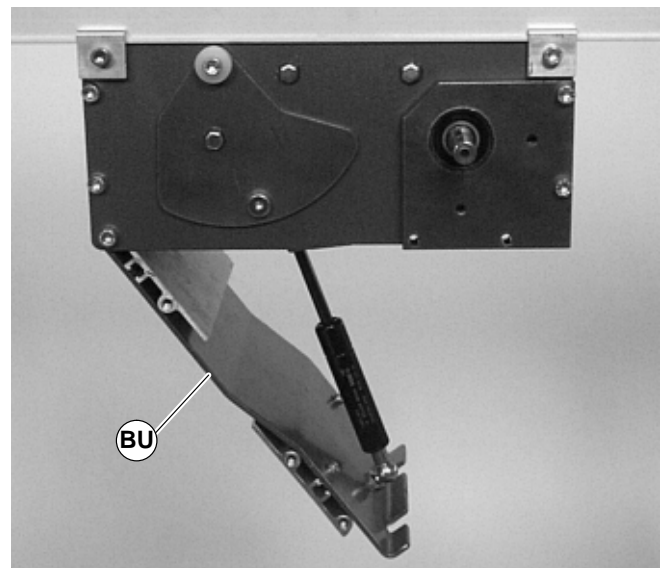


Figure 31

Preventive Maintenance and Adjustment

12. Tighten corner screws (BU of Figure 32) on each side of the drive module to 9 Nm.

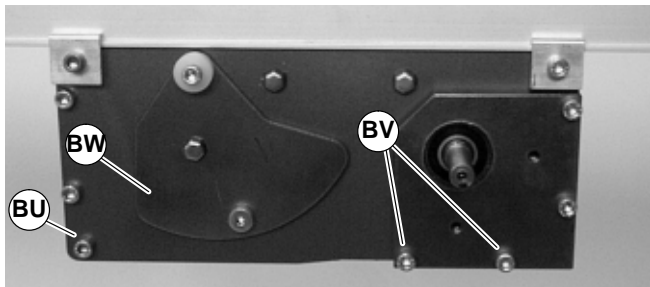


Figure 32

NOTE: If equipped with gearmotor mounting package, replace by completing in reverse order steps 3 through 5 of “Belt Removal for Conveyor With Stands and/or Gearmotor Mounting Package” on page 9.

13. Re-install tension door screws (BV of Figure 32) on each side of the module. Tighten screws to 9 Nm.
14. Re-install discharge bottom wiper (AI of Figure 14): Reverse steps 1 through 3 of “Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands”, page 8.
15. Replace guiding, if applicable.

Conveyor Belt Tensioning

NOTE: For a new belt, the tension plate will be in position indicated in Figure 32 (BW). When the tension plate extends to position indicated in Figure 33 (BW), the conveyor belt must be replaced.

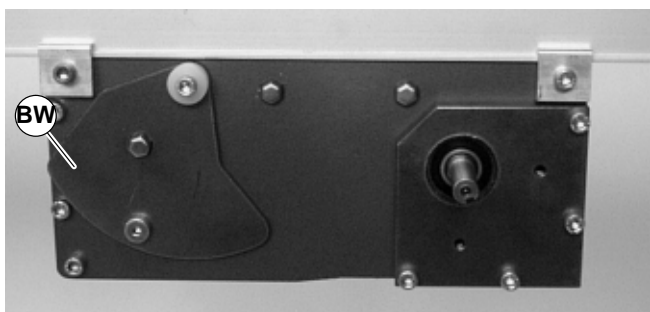


Figure 33

The conveyor is equipped with an automatic tensioning cylinder. No tensioning adjustment is required.

Pulley Removal



Remove the conveyor belt to access the pulley(s). Perform the indicated steps of one of the following procedures:

- “Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands”, page 8, steps 1 through 10.
- “Belt Removal for Conveyor With Stands and/or Gearmotor Mounting Package”, page 9, steps 1 through 14.

Remove the desired pulley following procedures A, B or C:

- A – End Pulley Removal
- B – Drive Pulley Removal
- C – Idler Pulley Removal

A – End Pulley Removal

NOTE: Bearing removal tools (part numbers 25-09 and 906-278 included in Tool Kit 2500M-ENG) are required to remove end pulleys.

1. With a small flat bladed screwdriver, remove plug (BX of Figure 34) from retainer (BY).

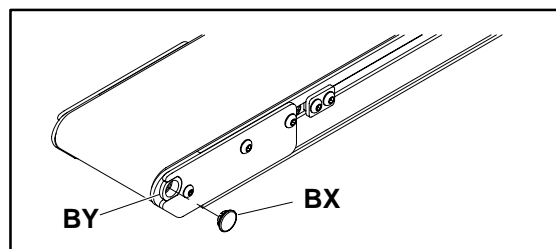


Figure 34

- Remove the tail cover plate screws (BZ of Figure 35) and tail cover plates (CA) on both sides of the conveyor.

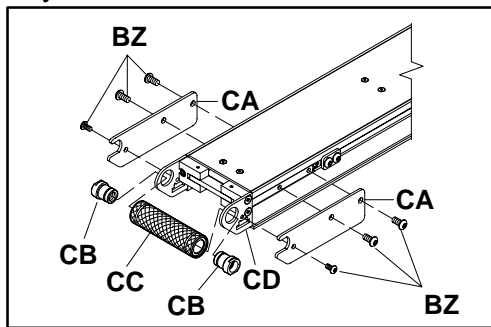


Figure 35

- Position bearing anvil/sleeve removal tool (CJ of Figure 36), part number 25-09, over the retaining sleeve (CB of Figure 35 or Figure 36).

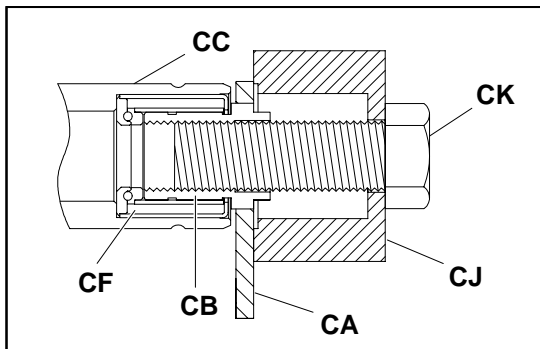


Figure 36

- Insert threaded bolt (CK of Figure 36), part number 906-278, through the bearing anvil/sleeve removal tool (CJ) and into the retaining sleeve (CB).
- Tighten the bolt (CK) until the retaining sleeve (CB) is free of the tail pulley plate (CA).
- Remove the retaining sleeve (CB) from the bolt (CK) and repeat for the other side.
- Remove the pulley (CC).

B – Drive Pulley Removal

- Remove the gearmotor drive package. Refer to “Belt Removal for Conveyor With Stands and/or Gearmotor Mounting Package”, page 9, steps 5 through 7.

- Remove the drive pulley. Refer to “Belt Removal from Center Drive Module”, page 11, steps 1 and 2.

C – Idler Pulley Removal

- Remove the gearmotor drive package. Refer to “Belt Removal for Conveyor With Stands and/or Gearmotor Mounting Package”, page 9, steps 5 through 7.
- Detach the center drive module. Refer to “Center Drive Module Removal”, page 11.
- Remove the grooved idler pulley. Refer to “Belt Removal from Center Drive Module”, step 3, page 12.
- Remove smooth idler pulleys:
 - For 44 mm, 70 mm or 95 mm wide conveyor, detach E-ring clips and remove washers (CL of Figure 37). Remove pulley shafts (CM) and pulleys (CN).

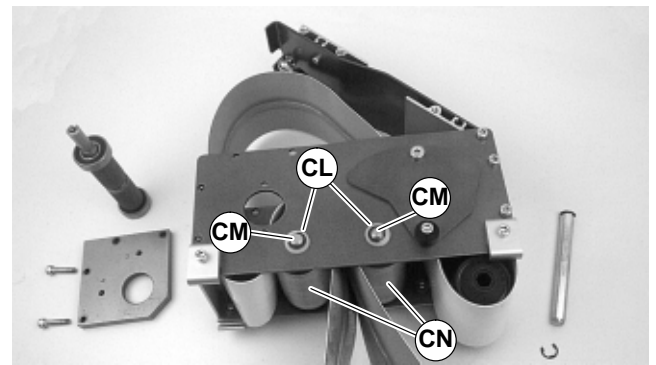


Figure 37

- For 127 mm or wider conveyor, depress both sides of each spring-loaded shaft (CO of Figure 38). Remove pulleys (CP).

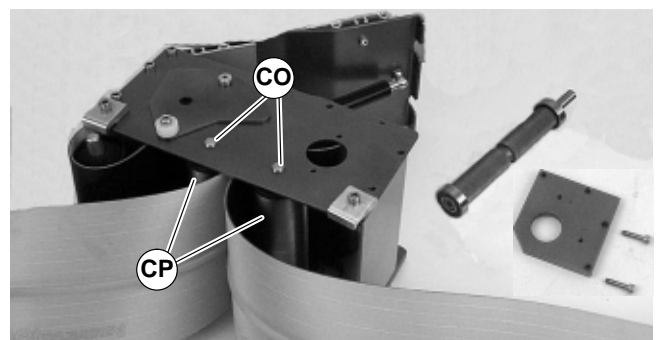


Figure 38

Preventive Maintenance and Adjustment

Bearing Replacement for End Pulleys

IMPORTANT: Once removed, do not re-use bearings.

NOTE: Bearing removal and installation tools (part numbers 25-05, 25-08, 25-09 and 25-10 included in Tool Kit 2500M-ENG) are required to remove and install bearings.

Bearing Removal

NOTE: The bearings of a 44 mm wide gang drive pulley cannot be replaced. Order pulley assembly (part number 204002).

1. Insert bearing removal tool (CQ of Figure 39), part number 25-05, into the pulley (CR) until shoulder (CS) seats against bottom of bearing (CT).

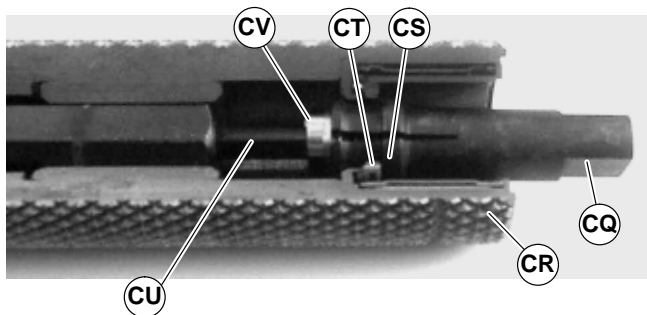


Figure 39

2. While holding bearing removal tool (CQ) in position, insert extension tool (CU), part number 25-08, into opposite end of pulley (CR). Rotate bearing removal tool (CQ) to engage hex tip of extension tool (CU) into screw (CV) of bearing removal tool.

3. While maintaining extension tool (CU) position, use a wrench (CW of Figure 40) to rotate the bearing removal tool (CQ) to expand the flare end of the tool.

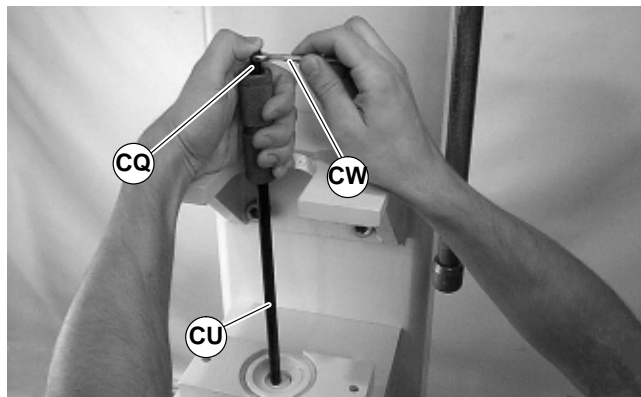


Figure 40

4. Orient bearing anvil/sleeve removal tool (CX of Figure 41), part number 25-09, with cavity facing up and place pulley (CR) onto tool.

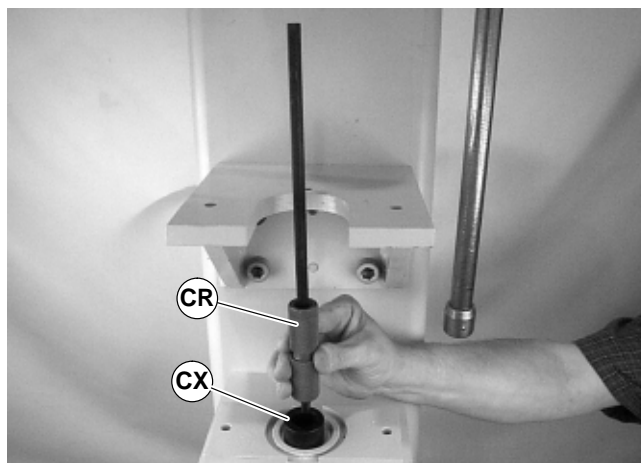


Figure 41

Preventive Maintenance and Adjustment

5. With arbor press (CY of Figure 42) or similar device, press bearing out of pulley (CR).

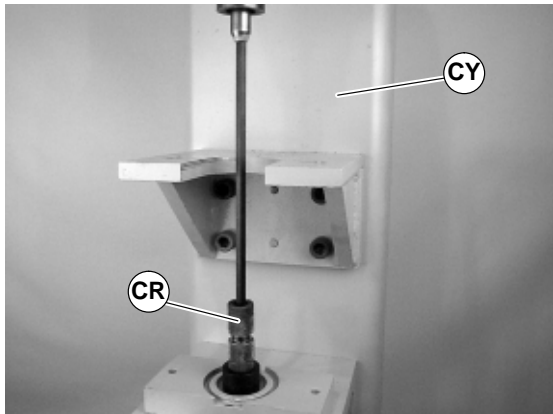


Figure 42

3. Place and hold bearing (CT of Figure 45), part number 21–33, onto insertion tool (CZ) in position over pulley (CR).

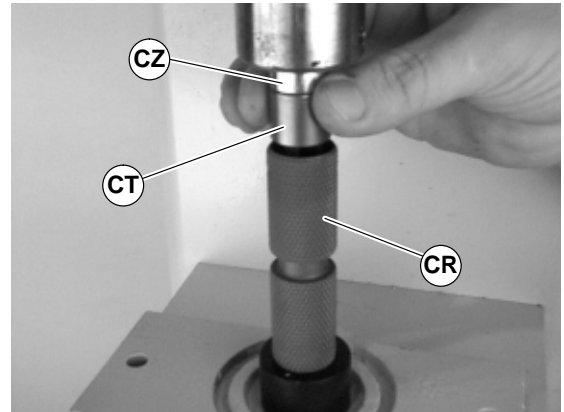


Figure 45

NOTE: If a severely worn bearing breaks apart during removal, pulley must be replaced.

Bearing Installation

1. Orient bearing anvil/sleeve removal tool (CX of Figure 43), part number 25–09, with cavity facing up and place pulley (CR) onto tool.

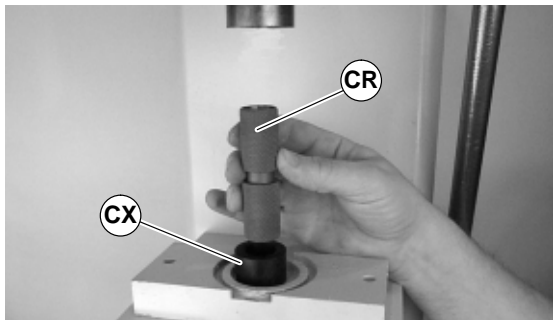


Figure 43

2. Install bearing insertion tool (CZ of Figure 44), part number 25–10, into arbor press (CY) or similar device.

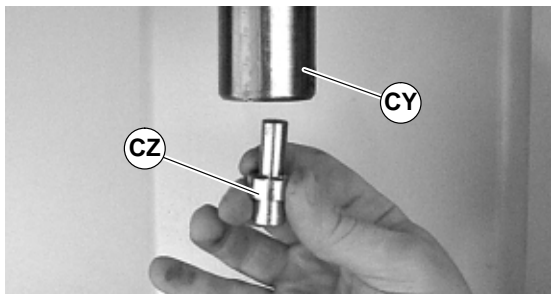


Figure 44

IMPORTANT: Bearing and pulley alignment is critical.

4. Press bearing (CT of Figure 46) into pulley (CR) until seated.

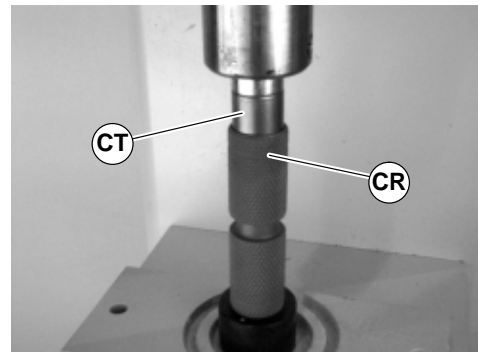


Figure 46

Preventive Maintenance and Adjustment

Bearing Replacement for Drive Pulley

IMPORTANT: Once removed, do not re-use bearings.

Bearing Removal

1. Position the drive pulley (DA of Figure 47) in a standard bearing separator (DB) as shown.

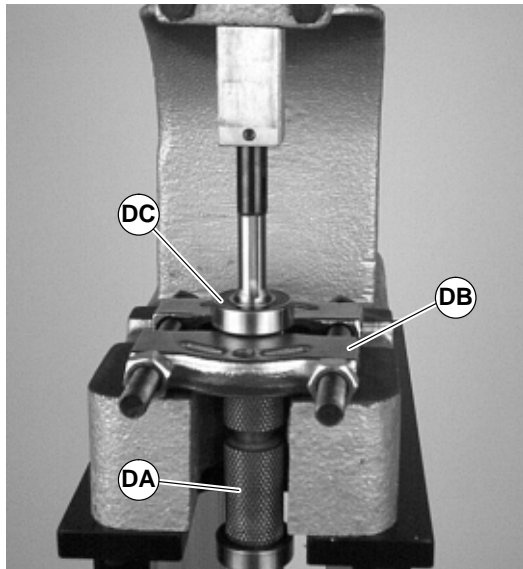


Figure 47

2. Using an arbor press or similar device, press-off the bearing (DC).

Bearing Installation

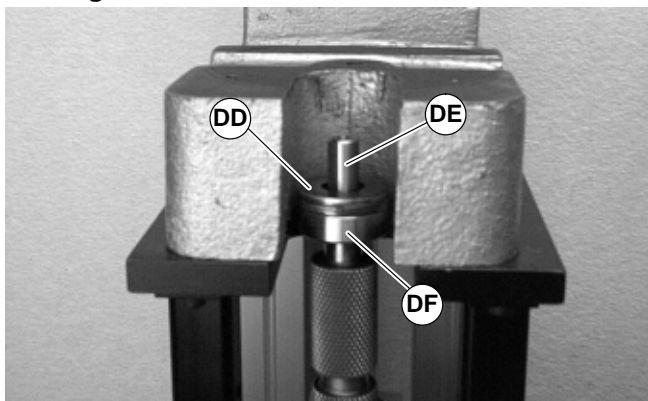


Figure 48

3. Place the shaft of the tool (part number 450282) (DG of Figure 49) over pulley shaft (DH).

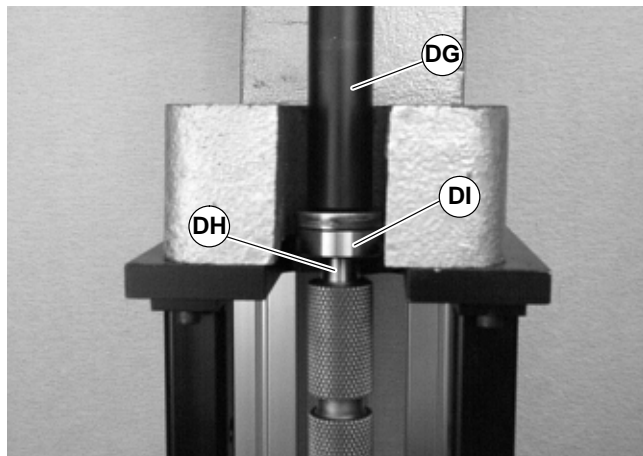


Figure 49

4. Using an arbor press or similar device, press the bearing (DI) onto pulley shaft as shown.

Bearing Replacement for Idler Pulleys

NOTE: Bearings can not be removed from idler pulleys. Replace entire pulley, when worn. See "Service Parts", page 19.

Pulley Replacement

End Pulleys

Reverse removal procedure "A" (see page 14).

Drive Pulley

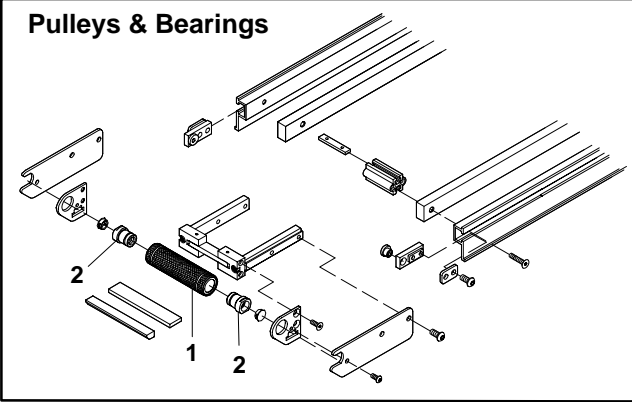
Reverse removal procedure "B" (see page 15).

Idler Pulley

Reverse removal procedure "C" (see page 15).

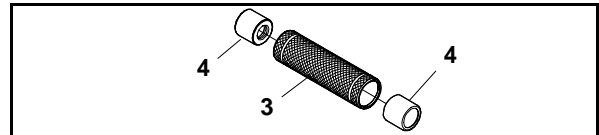
NOTE: For replacement parts other than those shown in this document, contact an authorized Dorner Service Center or the factory.

Pulleys & Bearings



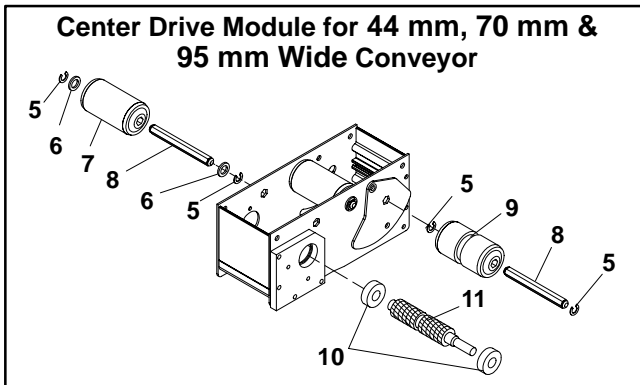
Item	Part No.	Part Description
1	See Chart	Pulley Assembly
2	200035	Pulley Retaining Sleeve

25 mm Diameter Drive/Idler Pulley Assembly (1)



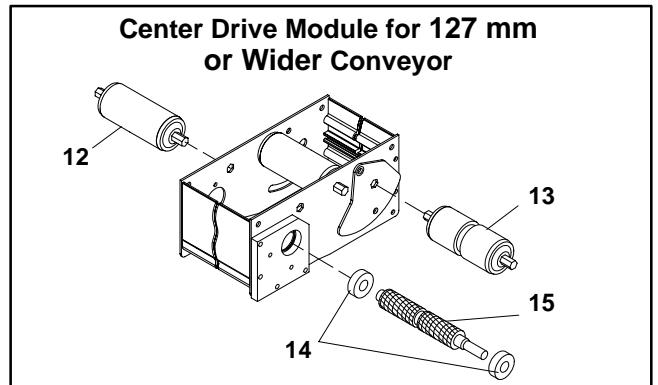
Nominal Conveyor Width	Part Number	
	Drive/Idler Pulley Assembly (1) with 21-33 Bearings (4)	Drive/Idler Pulley Only (3)
44 mm	204802	Not Applicable
70 mm	204803	204703
95 mm	204804	204704
127 mm	204805	204705
152 mm	204806	204706
178 mm	204807	204707
203 mm	204808	204708
254 mm	204810	204710
305 mm	204812	204712

Center Drive Module for 44 mm, 70 mm & 95 mm Wide Conveyor



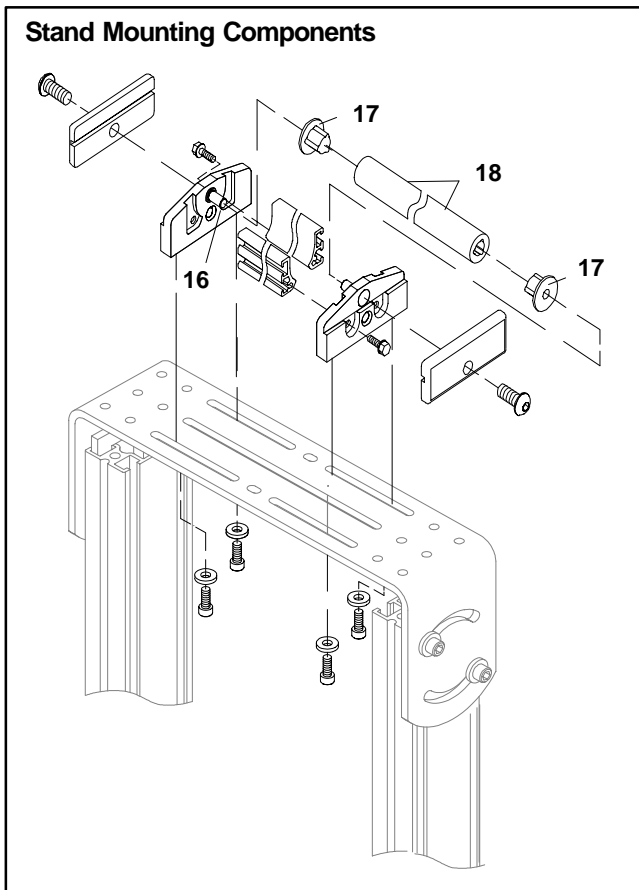
Item	Part No.	Part Description
5	915-215	E-Ring Clip (0.44 diameter)
6	801-115	Washer
7	463046	Idler Pulley, 44 mm
	807-1007	Idler Pulley, 70 mm
	807-1008	Idler Pulley, 95 mm
8	463402	Pulley Shaft, 44 mm
	463403	Pulley Shaft, 70 mm
	463404	Pulley Shaft, 5 mm
	463044	Grooved Idler Pulley, 44 mm
9	463045	Grooved Idler Pulley, 70 mm
	807-1001	Grooved Idler Pulley, 95 mm
	802-124	Pulley Bearings
11	463102M	Drive Pulley, 44 mm
	463103M	Drive Pulley, 70 mm
	463104M	Drive Pulley, 95 mm

Center Drive Module for 127 mm or Wider Conveyor



Item	Part No.	Part Description
12	807-1009	Idler Pulley, 127 mm
	807-1010	Idler Pulley, 152 mm
	807-1011	Idler Pulley, 203 mm
	807-1012	Idler Pulley, 254 mm
	807-1013	Idler Pulley, 305 mm
13	807-1002	Grooved Idler Pulley, 127 mm
	807-1003	Grooved Idler Pulley, 152 mm
	807-1004	Grooved Idler Pulley, 203 mm
	807-1005	Grooved Idler Pulley, 254 mm
	807-1006	Grooved Idler Pulley, 305 mm
	802-124	Pulley Bearings
15	463105M	Drive Pulley, 127 mm
	463106M	Drive Pulley, 152 mm
	463108M	Drive Pulley, 203 mm
	463110M	Drive Pulley, 254 mm
	463112M	Drive Pulley, 305 mm

Service Parts



Item	Part No.	Part Description
16	202348P	Bearing Pin
17	202311P	Return Roller Bearing
18	207702	Return Roller Tube, 44 mm Long
	207703	Return Roller Tube, 70 mm Long
	207704	Return Roller Tube, 95 mm Long
	207705	Return Roller Tube, 127 mm Long
	207706	Return Roller Tube, 152 mm Long
	207708	Return Roller Tube, 203 mm Long
	207710	Return Roller Tube, 254 mm Long
	207712	Return Roller Tube, 305 mm Long
	207718	Return Roller Tube, 457 mm Long
	207724	Return Roller Tube, 610 mm Long

Configuring Conveyor Belt Part Number

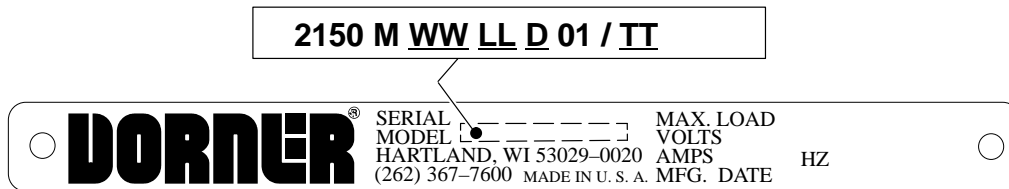


Figure 50

Conveyor Belt

Refer to serial and model number plate (Figure 50). Determine conveyor length (“LL”), width (“WW”) and belt type (“TT”).

25 - WW LL / TT

25- _____ / _____
(Fill In)

Return Policy

No returns will be accepted without prior written factory authorization. When calling for authorization, please have the following information ready for the Dornier 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. Dornier 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 Dornier 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.

Dornier has representatives throughout the world. Feel free to contact Dornier for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dornier products.

For a copy of Dornier's Limited Warranty, contact factory, distributor, service center or visit our website @ www.dornier.com

**For replacement parts, contact an authorized
Dornier Service Center or the factory.**

DORNER®

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