

### 2100, 2200, 4100, 6100, MPB Series Top Mount Drive Package for Standard Load 90° Industrial 60 Hz Gearmotors



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# Warnings – General Safety

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

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

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

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

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

		<b>WARNING</b>
<p>Exposed moving parts can cause severe injury. <b>REPLACE ALL GUARDS BEFORE RUNNING CONVEYOR.</b></p>		

		<b>WARNING</b>
<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, <b>CHECK FOR POTENTIAL PINCH POINTS</b> and other mechanical hazards before system start-up.</p>		

		<b>WARNING</b>
<p>MPB Series Conveyors are not reversible. Reversing creates pinch points which can cause severe injury. <b>DO NOT REVERSE MPB SERIES CONVEYORS.</b></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 2100 Series conveyors are covered by the following patent numbers: 5131529, 5174435, and corresponding patents and patent applications in other countries.

Dorner 4100 Series conveyors are covered by patent number 3923148 and corresponding patents and patent applications in other countries.

Dorner 2200, 6100 & MPB Series conveyors are covered by patent number 5174435 and corresponding patents and patent applications in other countries.

Dorner's Limited Warranty applies.

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

# Product Description

Refer to Figure 1 for typical components.

Typical Components	
A	Conveyor
B	Mounting Bracket
C	Gearmotor
D	Timing Belt Tensioner
E	Cover
F	Timing Belt
G	Drive Pulley
H	Driven Pulley

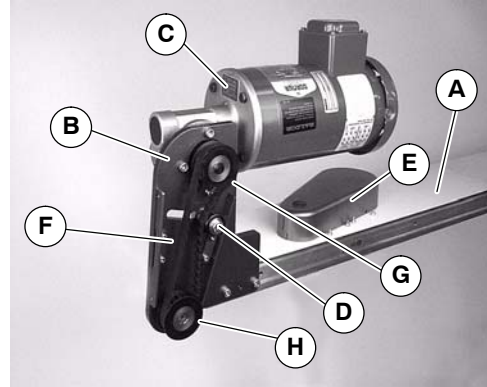


Figure 1

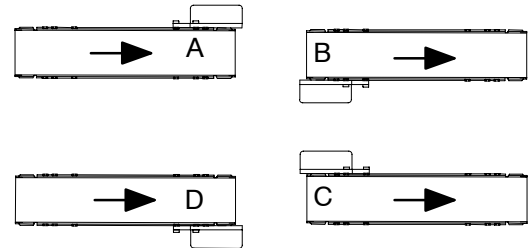
# Specifications

## Gearmotor Mounting Package Models:

### Example:

**22 M T H S WW A - 32 32**

- 22 = 2100 Series Conveyor
- 22 = 2200 & MPB Series Conveyor
- 4 = 4100 Series Conveyor
- 6 = 6100 Series Conveyor
- 2P = MPB Series Conveyor
- M = Mount Style = Top Mount
- T = Output Shaft Type = 90° Industrial
- H = Gearmotor Type = Standard Load, Industrial
- S = Mount Position = A, B, C or D (see detail to the right)
- WW = Conveyor Width Reference\*
- A = Belt Type: - = flat belt, A through J = cleated belt
- 32 = Drive Pulley (see Table 2 & 3)
- 32 = Driven Pulley (see Table 2 & 3)



\* See "Ordering and Specifications" Catalog for details.

Table 1: Gearmotor Specifications

	Single Phase	Three Phase	DC Variable Speed
Output Power	0.25 hp (0.19 kw)		
Input Voltage	115 Volts A.C.	208 to 230/460 Volts A.C.	130 Volts D.C.
Input Frequency	60 Hz		N/A
Input Current	5.0 Amperes	1.2 /0.6 Amperes	2.2 Amperes
Motor RPM	1725		2500
Gearmotor Ratios	5:1, 10:1, 20:1, 40:1, 60:1		
Frame Size	NEMA 42 CZ		
Motor Type	Totally Enclosed, Fan-cooled		

# Specifications

**NOTE:** For belt speed other than those listed in Tables 2 – 7, contact factory for details.

**Table 2: Belt Speeds for Standard Load Fixed Speed 90° 60 Hz Gearmotors on 2200 Series Conveyors**

Gearmotors				Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HL4(vp)F(n)	29	226	25.5	6	1.8	19	32
32M060HL4(vp)F(n)	29	226	25.5	10	3.0	28	28
32M060HL4(vp)F(n)	29	226	25.5	16	4.9	44	28
32M040HL4(vp)F(n)	43	237	26.8	15	4.6	28	28
32M040HL4(vp)F(n)	43	237	26.8	24	7.3	44	28
32M020HL4(vp)F(n)	86	142	16.0	30	9.1	28	28
32M020HL4(vp)F(n)	86	142	16.0	48	14.6	44	28
32M010HL4(vp)F(n)	173	78	8.8	61	18.6	28	28
32M010HL4(vp)F(n)	173	78	8.8	95*	29.0*	44	28
32M010HL4(vp)F(n)	173	78	8.8	104*	31.7*	48	28
32M005HL4(vp)F(n)	345	41	4.6	121*	36.9*	28	28
32M005HL4(vp)F(n)	345	41	4.6	138*	42.1*	32	28
32M005HL4(vp)F(n)	345	41	4.6	176*	53.6*	32	22
32M005HL4(vp)F(n)	345	41	4.6	208*	63.4*	48	28
32M005HL4(vp)F(n)	345	41	4.6	242*	73.8*	44	22
32M005HL4(vp)F(n)	345	41	4.6	264*	80.5*	48	22

(vp) = voltage and phase                      (n) = Reversing Capability  
 11 = 115 V, 1-phase                              N = No Reversing switch  
 23 = 208–230/460 V, 3-phase                R = With reversing switch

\* = Nosebar transfers operate at maximum 77 Ft/min (23.5 M/min) belt speed

**Table 3: Belt Speeds for Standard Load Variable Speed 90° DC Gearmotors on 2200 Series Conveyors**

Gearmotors				Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HLD3DEN	42	198	22.4	1.8 – 14.0	0.5 – 4.6	28	28
32M060HLD3DEN	42	198	22.4	2.8 – 23.0	0.8 – 7.0	44	28
32M040HLD3DEN	63	163	18.4	2.6 – 22.0	0.8 – 6.7	28	28
32M020HLD3DEN	125	98	11.1	5.3 – 44.0	1.6 – 13.0*	28	28
32M010HLD3DEN	250	54	6.1	10.0 – 88.0*	3.2 – 27.0*	28	28
32M010HLD3DEN	250	54	6.1	17.0 – 138.0*	5.0 – 42.0*	44	28
32M005HLD3DEN	500	28	3.2	21.0 – 176.0*	6.4 – 54.0*	28	28
32M005HLD3DEN	500	28	3.2	33.0 – 276.0*	10.0 – 84.0*	44	28

\* = Nosebar transfers operate at maximum 77 Ft/min (23.5 M/min) belt speed

**Table 4: Belt Speeds for Standard Load Fixed Speed 90° 60 Hz Gearmotors on 2100 4100 & 6100 Series Conveyors**

Gearmotors		Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	Ft/min	M/min		
32M060HL4(vp)F(n)	29	6	1.8	19	32
32M060HL4(vp)F(n)	29	10	3.0	28	28
32M060HL4(vp)F(n)	29	16	4.9	44	28
32M040HL4(vp)F(n)	43	15	4.6	28	28
32M040HL4(vp)F(n)	43	24	7.3	44	28
32M020HL4(vp)F(n)	86	30	9.1	28	28
32M020HL4(vp)F(n)	86	48	14.6	44	28
32M010HL4(vp)F(n)	173	61	18.6	28	28
32M010HL4(vp)F(n)	173	95*	29.0*	44	28
32M010HL4(vp)F(n)	173	104*	31.7*	48	28
32M005HL4(vp)F(n)	345	121*	36.9*	28	28
32M005HL4(vp)F(n)	345	138*	42.1*	32	28
32M005HL4(vp)F(n)	345	176*	53.6*	32	22
32M005HL4(vp)F(n)	345	208*	63.4*	48	28
32M005HL4(vp)F(n)	345	242*	73.8*	44	22
32M005HL4(vp)F(n)	345	264*	80.5*	48	22

(vp) = voltage and phase  
 11 = 115 V, 1-phase  
 23 = 208-230/460 V, 3-phase  
 (n) = Reversing Capability  
 N = No Reversing switch  
 R = With reversing switch

**Table 5: Belt Speeds for Standard Load Variable Speed 90° DC Gearmotors on 2100 4100 & 6100 Series Conveyors**

Gearmotors				Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HLD3DEN	42	198	22.4	1.8 – 14.0	0.5 – 4.6	28	28
32M060HLD3DEN	42	198	22.4	2.8 – 23.0	0.8 – 7.0	44	28
32M040HLD3DEN	63	163	18.4	2.6 – 22.0	0.8 – 6.7	28	28
32M020HLD3DEN	125	98	11.1	5.3 – 44.0	1.6 – 13.0*	28	28
32M010HLD3DEN	250	54	6.1	10.0 – 88.0*	3.2 – 27.0*	28	28
32M010HLD3DEN	250	54	6.1	17.0 – 138.0*	5.0 – 42.0*	44	28
32M005HLD3DEN	500	28	3.2	21.0 – 176.0*	6.4 – 54.0*	28	28
32M005HLD3DEN	500	28	3.2	33.0 – 276.0*	10.0 – 84.0*	44	28

# Specifications

**Table 6: Belt Speeds for Standard Load Fixed Speed 90° 60 Hz Gearmotors on MPB Series Conveyors**

Gearmotors						Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HL4(vp)FN	29	226	25.5	13	4.1	22	32
32M060HL4(vp)FN	29	226	25.5	20	6.0	28	28
32M040HL4(vp)FN	43	237	26.8	29	8.9	28	28
32M040HL4(vp)FN	43	237	26.8	44	13.4	48	32
32M020HL4(vp)FN	86	142	16.0	59	17.9	28	28

(vp) = voltage and phase

(n) = Reversing Capability

11 = 115 V, 1-phase

N = No Reversing switch

23 = 208-230/460 V, 3-phase

R = With reversing switch

**Table 7: Belt Speeds for Standard Load Variable Speed 90° DC Gearmotors on MPB Series Conveyors**

Gearmotors				Belt Speed		Drive Pulley	Driven Pulley
Part Number	RPM	In-lb	N-m	Ft/min	M/min		
32M060HLD3DEN	42	198	22.4	2.3-19	0.7-5.9	22	32
32M060HLD3DEN	42	198	22.4	3.4-28	1-8.6	22	32
32M060HLD3DEN	42	198	22.4	5.3-44	1.6-13	44	28
32M040HLD3DEN	63	163	18.4	5.1-42	1.6-12.9	28	28
32M020HLD3DEN	125	98	11.1	10-85	3-26	28	28
32M020HLD3DEN	125	98	11.1	15-127	4.7-39	48	32
32M010HLD3DEN	250	54	6.1	20-170*	6-52*	28	28
32M010HLD3DEN	250	54	6.1	31-255*	9-77*	48	32

\* = Cleated and Sidewall Cleated belts operate at a maximum of 150 ft/min (45.7 m/min)

## Required Tools

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

## Mounting

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

	 <b>WARNING</b>
	<p>MPB Series Conveyors are not reversible. Reversing creates pinch points which can cause severe injury.</p> <p><b>DO NOT REVERSE MPB SERIES CONVEYORS.</b></p>

	 <b>WARNING</b>
	<p>Gearmotors must be mounted as shown in Figures 2 and 3.</p> <p>Failure to do so creates pinch points which can cause severe injury.</p>

**NOTE:** Gearmotor position on Flat Belt conveyors shown in Figure 2. Gearmotor position on Cleated Belt and MPB Series conveyors shown in Figure 3.

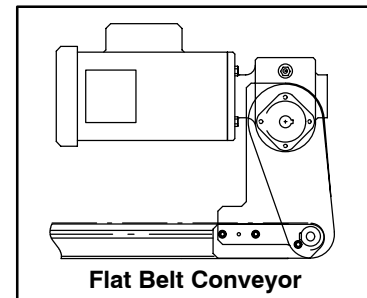


Figure 2

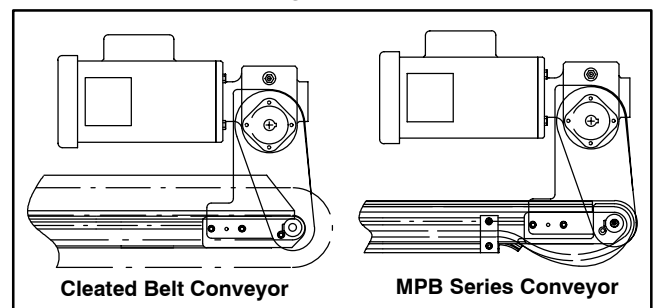


Figure 3

### Installation Component List

I	Top Mount Assembly
J	Drive Pulley
K	Cover
L	M4 Socket Head Screws (4x)
M	Driven Pulley
N	Key
O	M6 Socket Head Screws (2x)
P	Timing Belt

### 1. Typical gearmotor components (Figure 4)

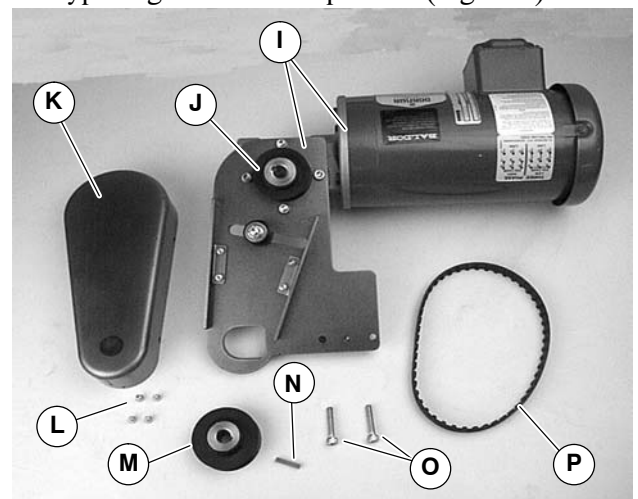


Figure 4

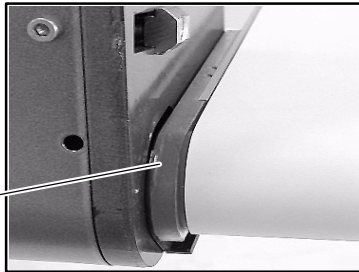
# Installation

**NOTE:** Flat belt mounting package shown above (Figure 4), cleated belt mounting package similar.

2. For your reference, the following figures show gearmotor mounting configurations for various conveyor series.

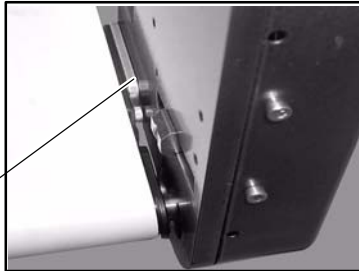
**Figure 5 – 2200 Series**

Gearmotor is mounted to Head Plate



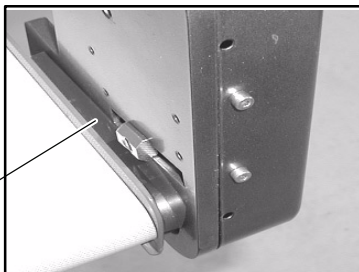
**Figure 6 – 6100 Series**

Gearmotor is mounted to Drive Spacer



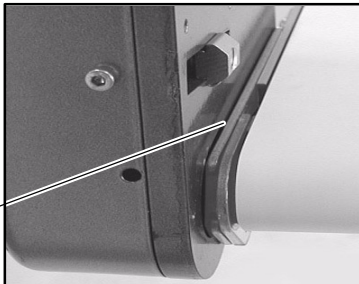
**Figure 7 – 4100 Series**

Gearmotor is mounted to Drive Adapter Plate



**Figure 8 – 2100 Series**

Gearmotor is mounted to Head Plate

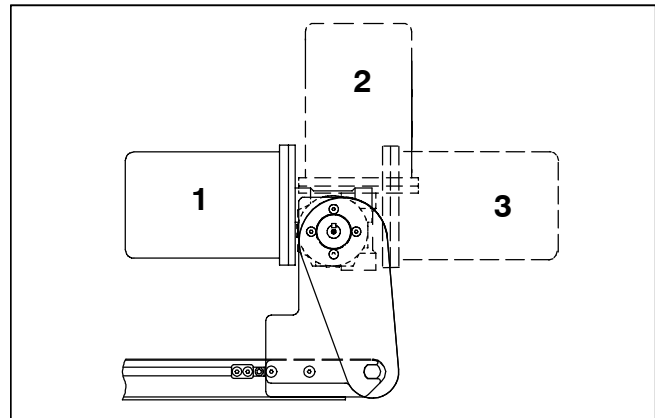


**Figure 9 – MPB Series**

Gearmotor is mounted to Head Plate

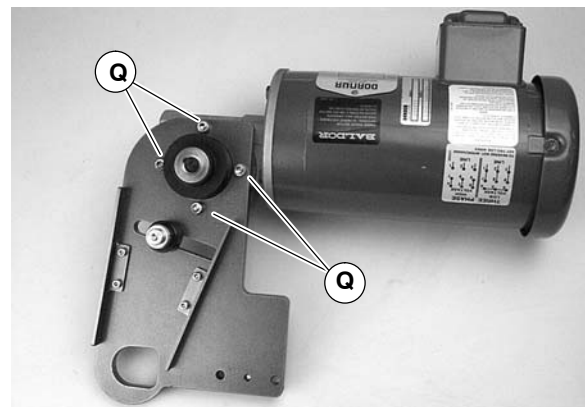


**NOTE:** Gearmotor may be operated in positions 1, 2 or 3 (Figure 10). Dependent on conveyor belt speed and gearmotor type, position 2 may require a vibration dampening bracket. Order 7018WW for 2200 and MPB conveyors or 7019WW for 2100 and 6100 conveyors. (WW = conveyor width). 4100 conveyors do not require brackets.



**Figure 10**

3. If required, change gearmotor position by removing four (4) screws (Q of Figure 11). Rotate gearmotor to other position and replace screws (Q). Tighten to 103 in-lb (12 N-m).



**Figure 11**



**NOTE:** 6100 conveyor shown, 2100, 2200, 4100 & MPB similar.

4. Locate drive output shaft (R of Figure 12) and remove two (2) screws (S).

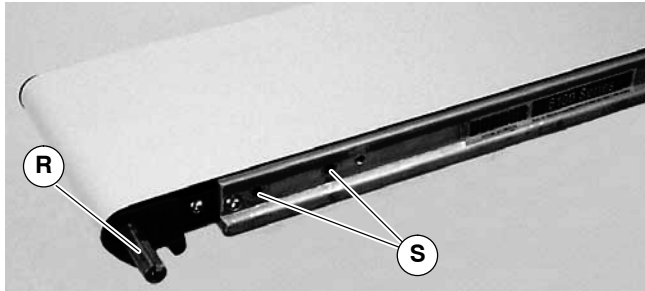


Figure 12

5. Attach mount assembly (I of Figure 13) with screws (O). Tighten to 80 in-lb (9 N-m).

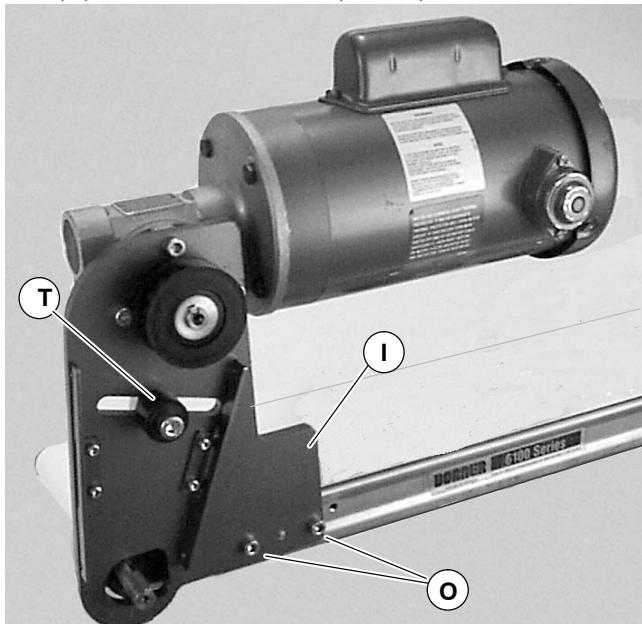


Figure 13

6. Install key (N of Figure 14).
7. Wrap timing belt (P) around driven pulley (M) and drive pulley (J). Install driven pulley (M) onto conveyor shaft.

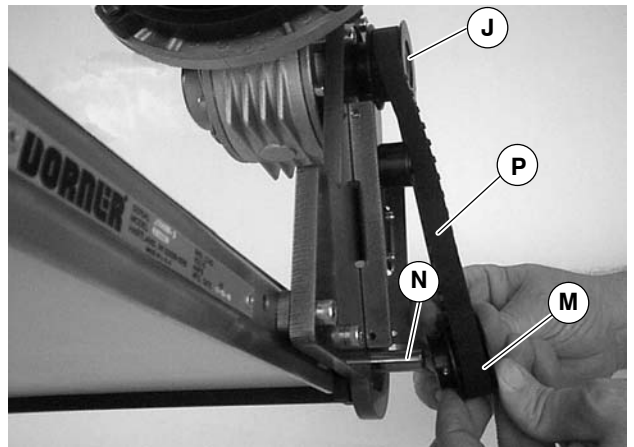


Figure 14

8. Remove cam bearing and spacer (T of Figure 13). Place the cam bearing and spacer (T of Figure 13) next to the driven pulley (M). Ensure the flanges of the driven pulley are aligned with the cam bearing. Tighten driven pulley set screws (U). This will allow for proper belt alignment while conveyor is in use. Replace cam bearing and spacer (T).

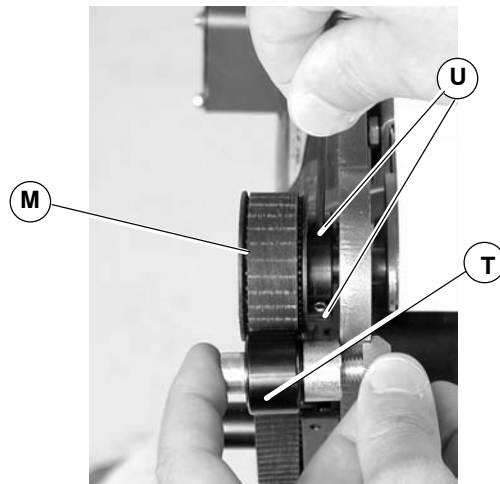


Figure 15

	 <b>WARNING</b> Drive shaft keyway may be sharp. HANDLE WITH CARE.
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# Installation

9. Depending on conveyor belt travel (direction 1 or 2 on Figure 16), locate timing belt tensioner (V of Figure 16) as shown. Tension timing belt to obtain 0.125" (3 mm) deflection for 1.0 lb (456 grams) of force at timing belt mid-point (W). Tighten tensioner screw to 103 in-lb (12 N-m).

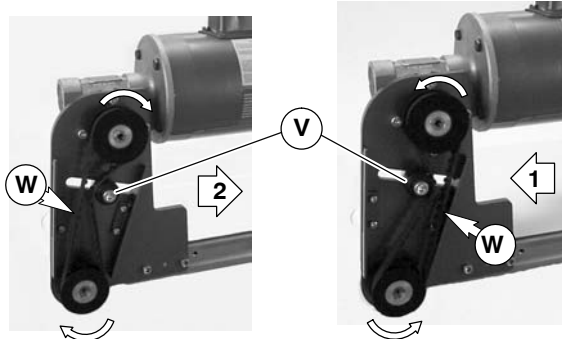


Figure 16

10. Install cover (K of Figure Figure 17) with four (4) screws (L). Tighten to 35 in-lb (4 N-m).

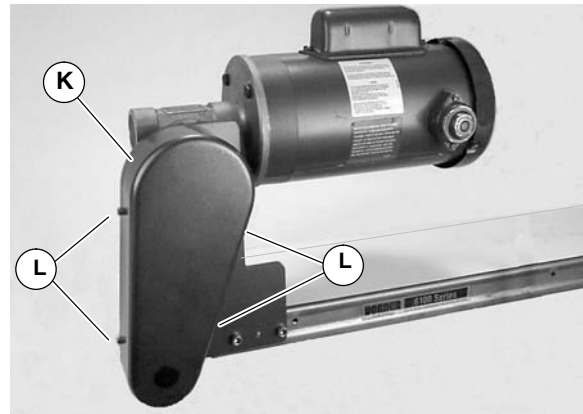




Figure 17

## Preventive Maintenance and Adjustment

### Required Tools

- Hex key wrenches
  - 2 mm, 2.5 mm, 3 mm & 5 mm
- Adjustable wrench (for hexagon head screws)
- Straight edge
- Torque wrench

### Timing Belt Tensioning

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

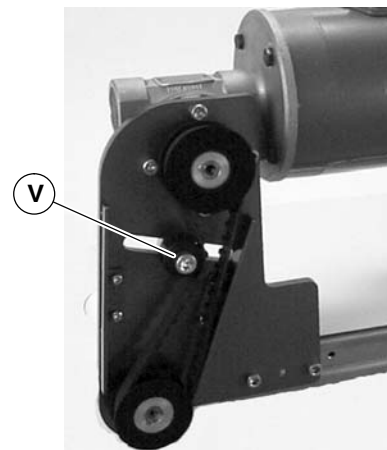


Figure 18

1. Remove four (4) screws (L of Figure 17) and remove cover (K).
2. Loosen tensioner (V of Figure 18).
3. Depending on conveyor belt travel (direction 1 or 2 on Figure 16), locate timing belt tensioner (V of Figure 16) as shown. Tension timing belt to obtain 0.125" (3 mm) deflection for 1.0 lb (456 grams) of force at timing belt mid-point (W). Tighten tensioner screw to 103 in-lb (12 N-m).
4. Install cover (K of Figure 17) with four (4) screws (L). Tighten to 35 in-lb (4 N-m).

# Preventive Maintenance and Adjustment

## Timing Belt Replacement



1. Remove four (4) screws (L of Figure 17) and remove cover (K).
2. Loosen tensioner (V of Figure 18).
3. Remove timing belt (P of Figure 19).

**NOTE:** If timing belt does not slide over pulley flange, loosen driven pulley set screws (U of Figure 19) and remove pulley with belt (P). For re-installation, see steps 7 and 8 on page 9.

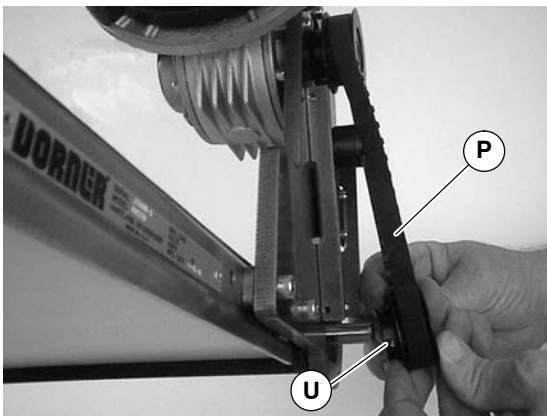
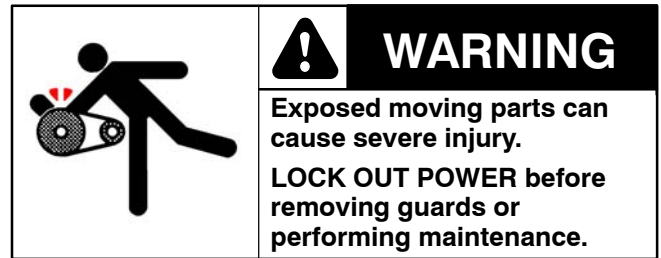


Figure 19

4. Install new timing belt.
5. Depending on conveyor belt travel (direction 1 or 2 on Figure 16), locate timing belt tensioner (V of Figure 16) as shown. Tension timing belt to obtain 0.125" (3 mm) deflection for 1.0 lb (456 grams) of force at timing belt mid-point (W). Tighten tensioner screw to 103 in-lb (12 N-m).
6. Install cover (K of Figure 17) with four (4) screws (L). Tighten to 35 in-lb (4 N-m).

## Drive or Driven Pulley Replacement



1. Complete steps 1 through 3 of "Timing Belt Replacement" section on page 11.
2. Loosen set screws and remove drive or driven pulley.

**NOTE:** If drive pulley (J of Figure 20) is replaced, wrap timing belt around drive pulley and complete step 3.

3. Complete steps 7 through 10 of "Installation" section on pages 9 and 10.

## Gear Reducer Replacement



1. Remove four (4) screws (L of Figure 17) and remove cover (K).
2. Loosen tensioner (V of Figure 18).
3. Loosen drive pulley set screws (X of Figure 20). Remove drive pulley (J) and timing belt (P).

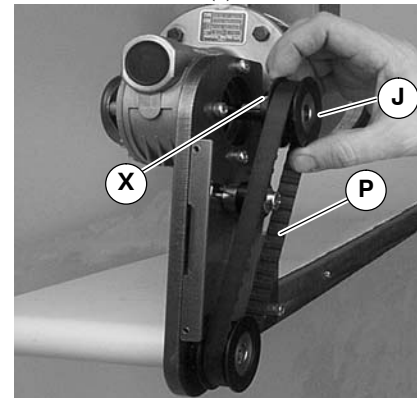


Figure 20

# Preventive Maintenance and Adjustment

- Remove four (4) gear reducer mounting screws (Q of Figure 21). Remove gearmotor.

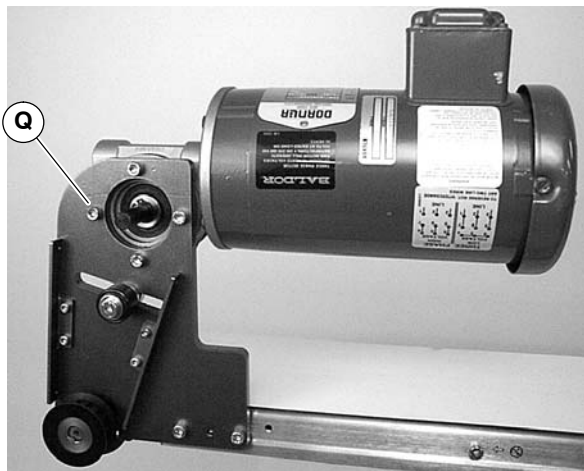


Figure 21

- Remove four screws (Y of Figure 22). Detach motor (Z) from gear reducer (AA). Retain motor output shaft key (AB).

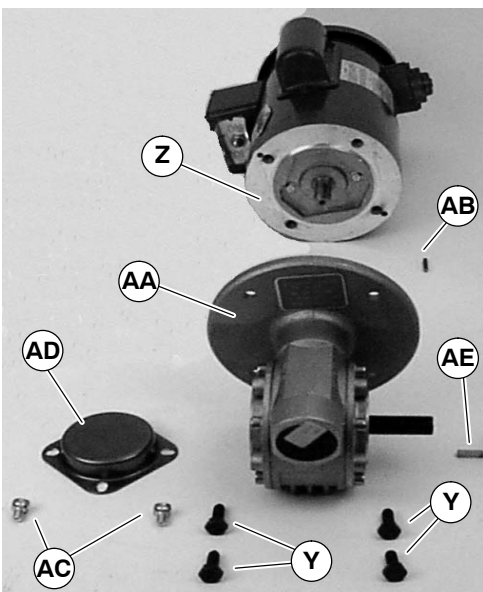


Figure 22

- Remove two (2) screws (AC) and detach output shaft cover (AD).
- Remove gear reducer output shaft key (AE).
- Loosen six (6) set screws (AF of Figure 23). Remove drive shaft (AG) and key (AH).

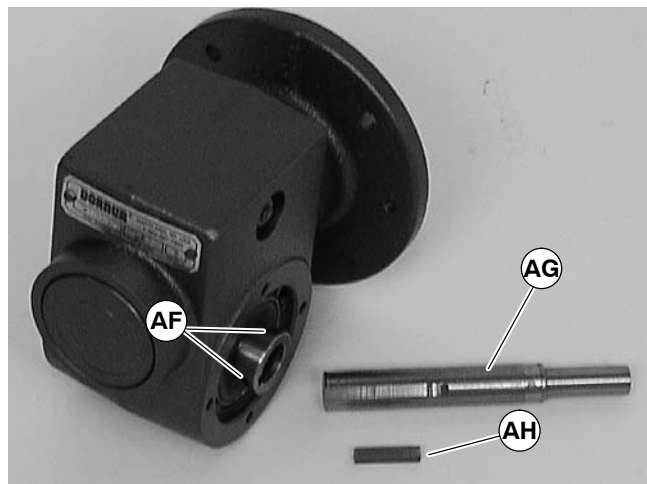


Figure 23

- Apply grease (AI of Figure 24) to shaft.

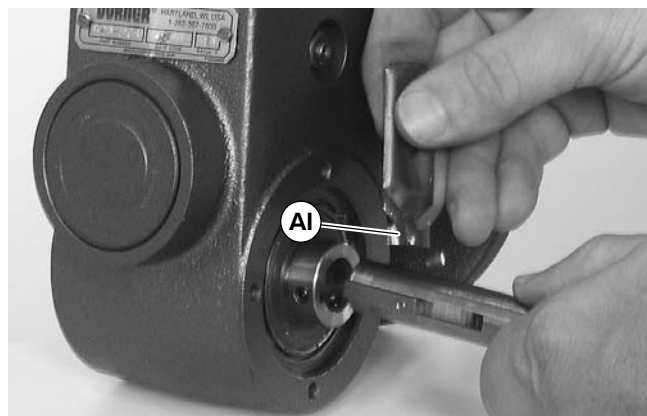


Figure 24

- Replace the original shaft components into new gear reducer (see Figure 23).

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**IMPORTANT:** Be extremely careful when coupling motor to gear reducer. Avoid misalignment and forcing the connection causing possible permanent gear reducer seal damage.

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- With key (AE of Figure 22) in keyway, slide motor (Z) and gear reducer (AA) together. Install screws (Y) and tighten.

# Preventive Maintenance and Adjustment

**NOTE:** Gearmotor position on Flat Belt conveyors shown in Figure 25. Gearmotor position on Cleated Belt and MPB Series conveyors shown in Figure 26.

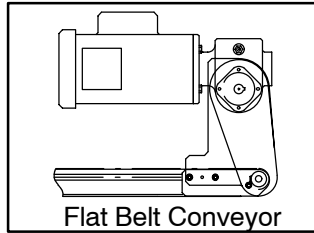


Figure 25

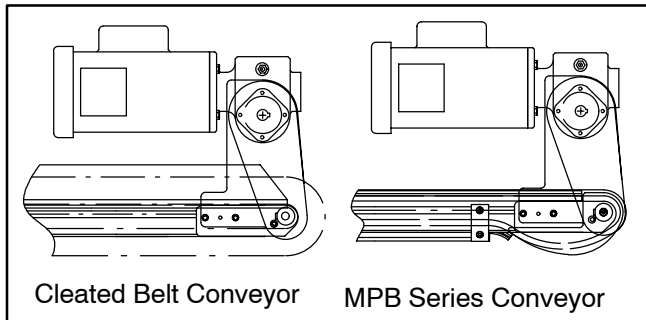


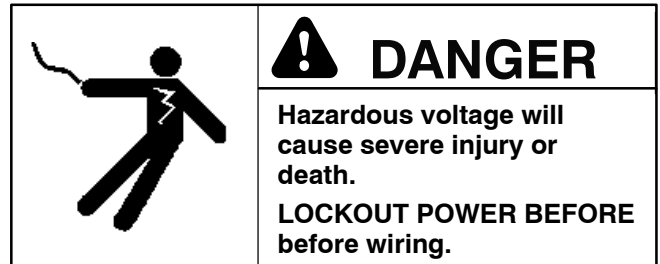
Figure 26

12. Install gearmotor to mounting bracket and tighten screws (Q of Figure 21) to 103 in-lb (12 N-m).

**NOTE:** Drive pulley (J of Figure 20) is removed. Wrap timing belt around drive pulley and complete step 13.

13. Complete steps 7 through 10 of “Installation” section on pages 9 and 10.

## Motor Replacement



1. For single phase motor, unplug power cord from outlet.
2. For three phase motor:
  - a. Loosen terminal box screws (AJ of Figure 27) and remove cover (AK).

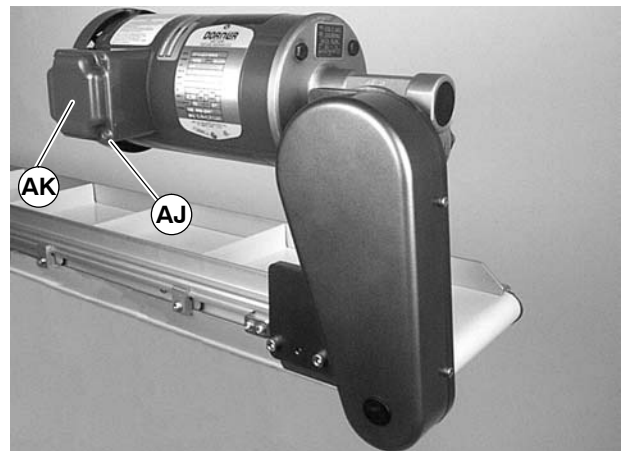


Figure 27

- b. Record wire colors connecting to wires 1, 2 and 3. Loosen wire nuts and remove wires 1, 2 and 3.
- c. Loosen cord grip and remove cord.

# Preventive Maintenance and Adjustment

3. For DC variable speed motor, unplug motor cord at disconnect (AL of Figure 28).

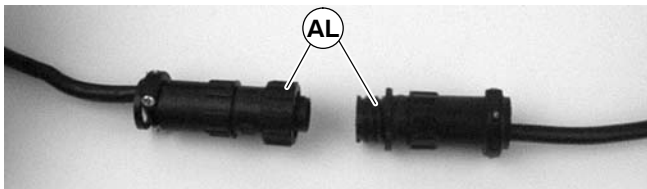


Figure 28

4. Remove four screws (Y of Figure 29). Detach motor (Z) from gear reducer (AA). Retain motor output shaft key (AB).

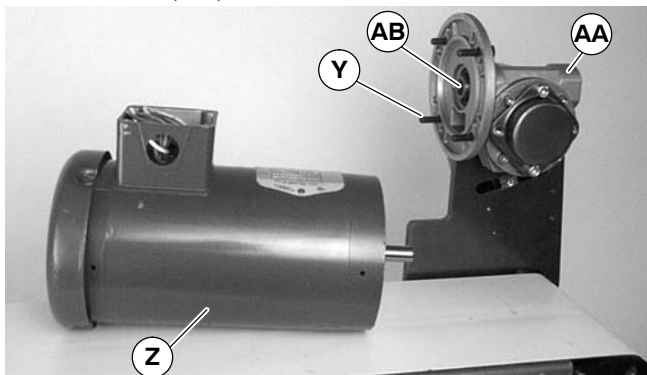


Figure 29

5. With key (AB of Figure 30) in keyway, slide motor and gear reducer together. Install screws (Y) and tighten.

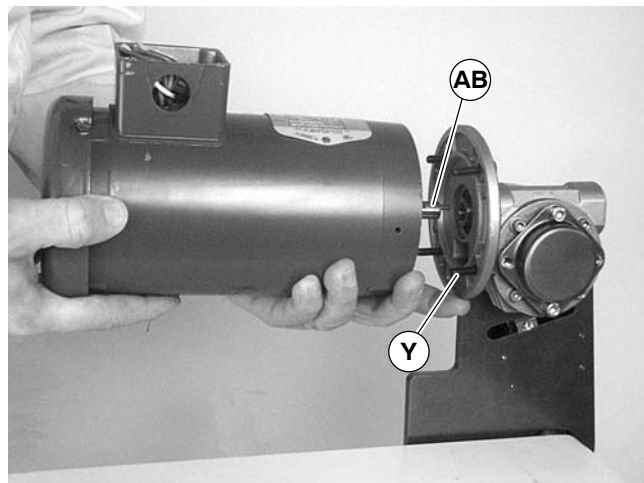


Figure 30

6. Replace wiring:

- For a single phase motor, reverse step 1 on page 13..
- For a three phase motor, reverse step 2, on pages 13 and 14..
- For a DC variable speed motor, reverse step 3 on this page..

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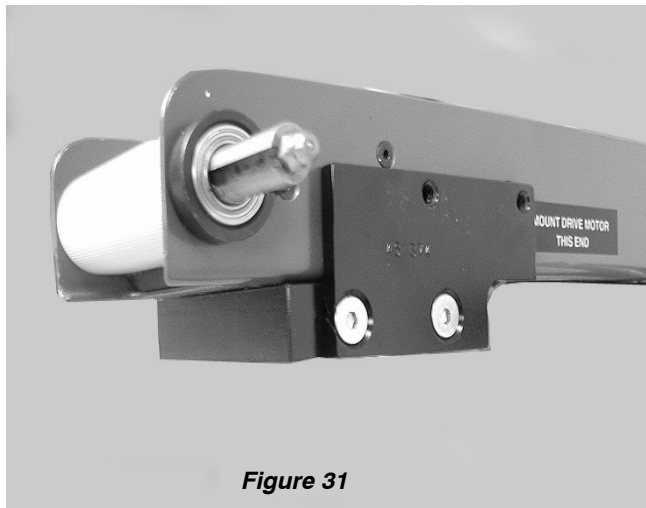
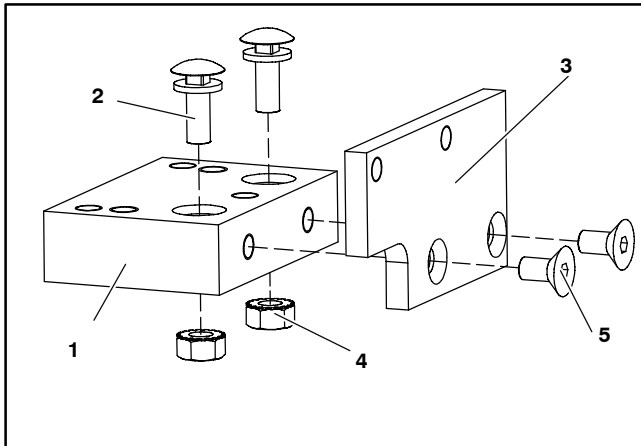
**IMPORTANT:** Be extremely careful when coupling motor to gear reducer. Avoid misalignment and forcing the connection causing possible permanent gear reducer seal damage.

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# Service Parts

## 4100 Mounting Package

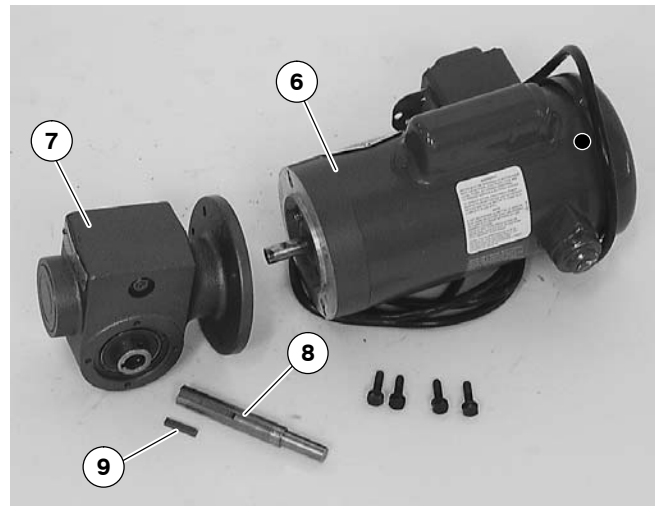


**Figure 31**

Mounting Package attached to a 4100 series conveyor.

Item	Part Number	Part Description
1	609486	Mounting Block 1" (25mm)
	609487	Mounting Block 2" (51mm)
	609488	Mounting Block 3" (76mm)
	609479	Mounting Block 4" (102mm)
	609480	Mounting Block 5" (127mm)
	609481	Mounting Block 6" (152mm)
	609482	Mounting Block 7" (178mm)
	609483	Mounting Block 8" (203mm)
	609484	Mounting Block 10" (254mm)
	609485	Mounting Block 12" (305mm)
2	613602P	Bolt & Flat Washer Assembly
3	450374	Drive Adapter Plate
4	910-126	Hex Nut with Lock Washer
5	930612M	Flat Head Screw M6 x 12mm

## Gearmotors



Item	Part Number	Part Description
6	826-328	Motor, 0.25 hp (0.19 Kw) 115/230 Volts, 60 Hz, 1-Phase
	826-337	Motor, 0.25 hp (0.19 Kw) 115/230 Volts, 60 Hz, 1-Phase with Reversing
	826-330	Motor, 0.25 hp (0.19 Kw) 208-230/460 Volts, 60 Hz, 3-Phase
	826-332	Motor, 0.25 hp (0.19 Kw) 130 Volts DC
7	32M005HL	Gear Reducer, 5:1, 42 CZ
	32M010HL	Gear Reducer, 10:1, 42 CZ
	32M020HL	Gear Reducer, 20:1, 42 CZ
	32M040HL	Gear Reducer, 40:1, 42 CZ
	32M060HL	Gear Reducer, 60:1, 42 CZ
8	450444M	Gear Reducer Shaft
9	912-084	Key, Square, 0.188" x 1.5" L





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## Return Policy

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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](http://www.dorner.com)

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

**DORNER<sup>®</sup>**

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