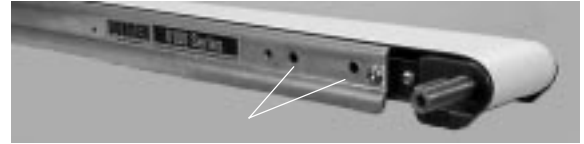




**Completed Bottom Mount Package,
position "D" shown (Cleated Belt Conveyor
Mounting Similar)**



**Step 2: Locate drive output shaft and remove original
factory-installed screws, where indicated.**

Illustration References

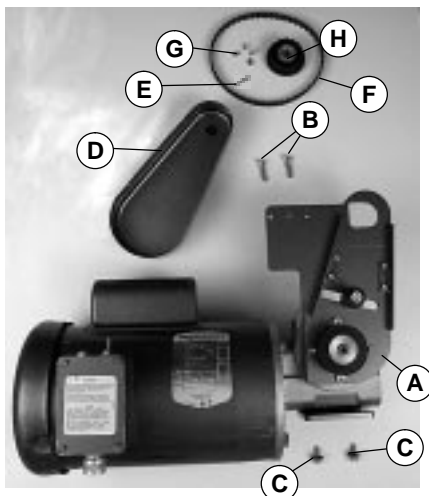
- A Bottom Mounting Package Sub-assembly
- B Drive Plate Mounting Screws,
(2) M6 x 25 mm, Socket Head
- C Gearbox Support Mounting Screws,
(2) M6 x 16, Socket Head and (2) Hard Washers
- D Drive Cover
- E Square Key, 4 mm
- F Timing Belt
- G Cover Mounting Screws,
(4) M4 x 6 mm, Socket Head
- H Driven Pulley
- I Temporary Gearmotor Support
- J Timing Belt Tensioner
- K Mid-point of Timing Belt
- L Set Screws (2 furnished with Pulley)



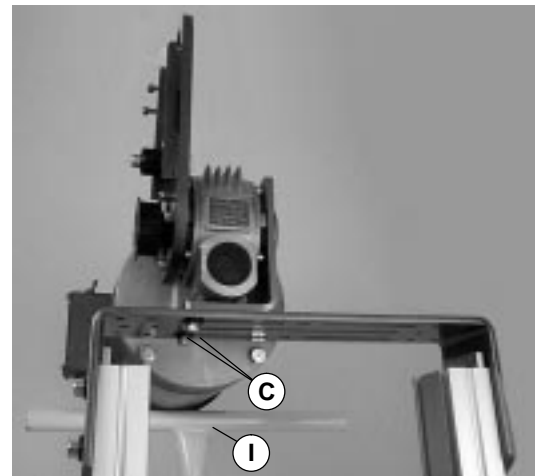
WARNING



To prevent injury, make sure all electrical power sources have been disconnected and locked-out before you perform any assembly or adjustments. NEVER operate equipment without guards or other protective devices properly secured in place. In addition, keyway on conveyor drive shaft may be sharp! Exercise caution when mounting pulley.




**Step 1: Unpack and layout the sub-assembly and
loose components as shown.**




**Step 3: Temporarily support gearmotor (I) and at-
tach drive sub-assembly to stand bracket as
shown. Tighten the M6 x 16 mm mounting
screws (C) with 88 in-lb (9.9 Nm) of torque.**

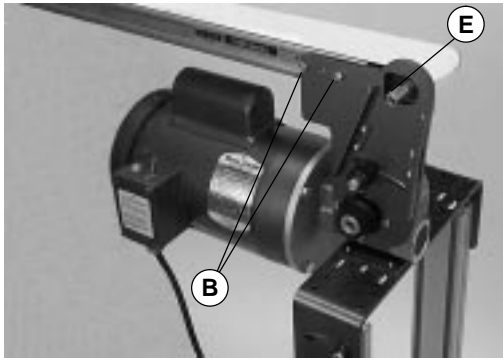
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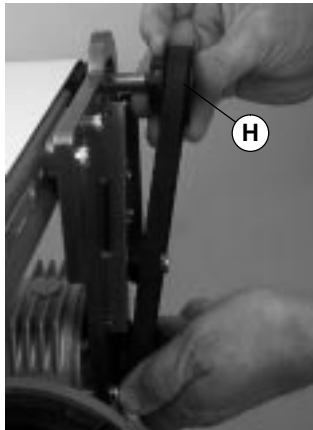
WARNING



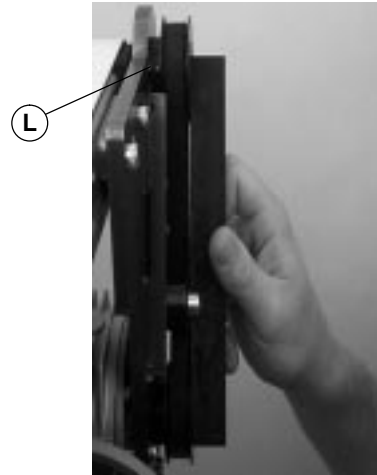
To prevent injury, make sure non-drive end of conveyor is safely and properly supported while drive end is being attached to the drive plate in the following step 4.



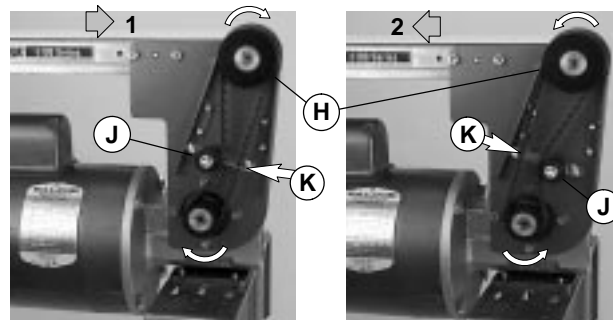
Step 4: Squarely align and attach conveyor to the bottom mount package sub-assembly as shown. Tighten the M6 x 25 mm drive plate mounting screws (B) with 88 in-lb (9.9 Nm) of torque. Then, install square key (E) into conveyor drive shaft.



Step 5: Wrap timing belt around driven pulley (H). Next, align and install pulley onto conveyor shaft (with key installed).



Step 6: Align driven pulley (on conveyor shaft) with drive pulley (on gearmotor shaft) using a straight edge. Once aligned, tighten both pulley set screws (L).



Step 7: Assemble drive components as shown. Depending on conveyor belt travel (direction 1 or 2), locate timing belt tensioner (J) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection when applying 1 lb (4.3 N) of force at the timing belt mid-point (K).

Step 8: Attach drive cover (D) with screws (G).

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



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