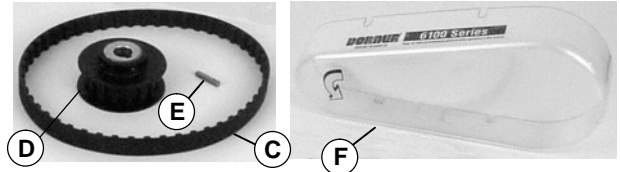
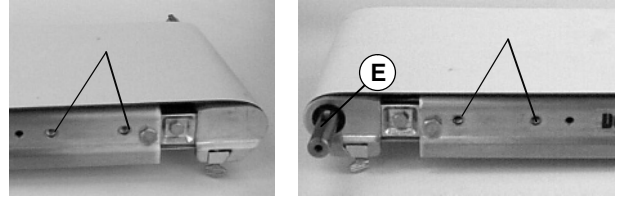




Completed Bottom Mount Package, position "A" shown (Cleated Belt Conveyor Mounting Similar)



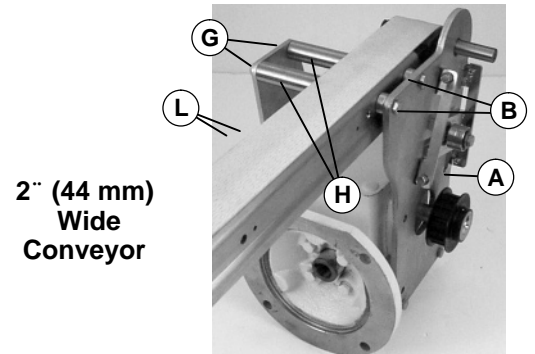
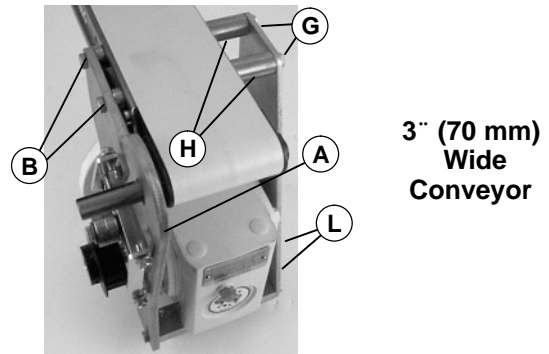
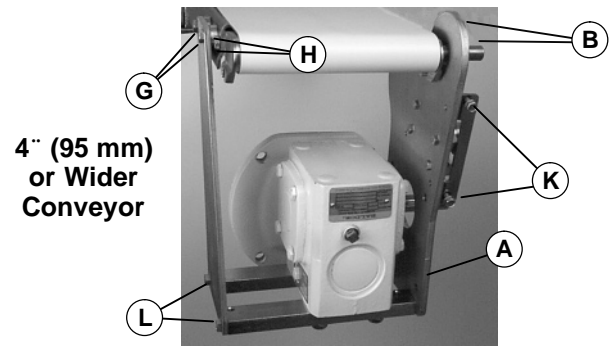
Step 1: Remove drive cover (F) & items (C, D & E).



Step 2: Remove screws from both sides of the conveyor where indicated. Install square key (E) into conveyor drive shaft.

**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 3: Loosen (but do not remove) hardware (L). Loosely attach bottom mounting package (A) to conveyor. Tightly secure screws (B), (G) and (L) with 92 in-lb (10.4 Nm) of torque.

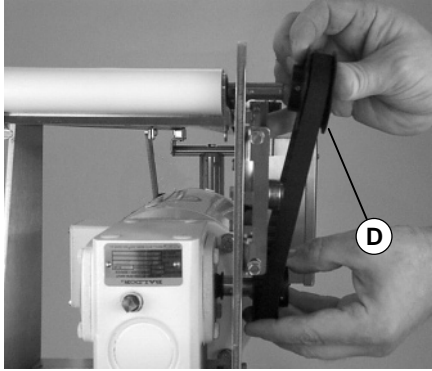
<continued on next page>

Illustration References	
A	Bottom Mounting Package Assembly
B	Drive Plate Mounting Screws, (2) M6 x 30 mm, Hexagon Head
C	Timing Belt
D	Driven Pulley
E	Square Key, 4 mm
F	Drive Cover
G	Support Plate Mounting Screws, (2) M6 x 70 mm, Hexagon Head [for 2" (44 mm)] or (2) M6 x 45 mm, Hexagon Head [for 3" (70 mm)] or (2) M6 x 30 mm, Hexagon Head [for All Others]
H	(2) Spacers [for 2" (44 mm)] or (2) Spacers [for 3" (70 mm)] or (2) Spacers [for all others]
I	Motor Key,
J	Motor Mounting Screws & Washers (4 furnished with motor)
K	Cover Mounting Screws, (4) M5 x 10 mm, Hexagon Washer Head
L	Mounting Bar Attaching Hardware, M6 x 16 mm
M	Set Screws (2 furnished with Pulley)
N	Timing Belt Tensioner
O	Mid-point of Timing Belt

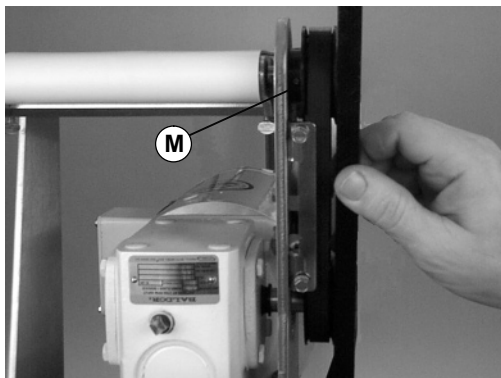
**Bottom Drive, Sanitary Mounting Package for a Heavy Load, 90° Sanitary Gearmotor for a 6100 Series Sanitary Conveyor**



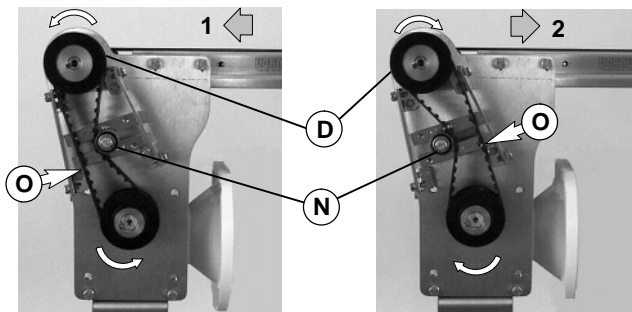
**Assembly Instructions**



**Step 4: Wrap timing belt around driven pulley (D) and install pulley onto conveyor shaft with square key (E) installed.**

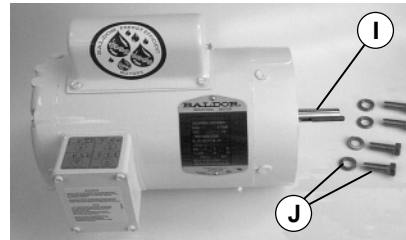


**Step 5: Align driven pulley (on conveyor shaft) with drive pulley (on gear reducer shaft) using a straight edge as shown. Once aligned, tighten both pulley set screws (M).**



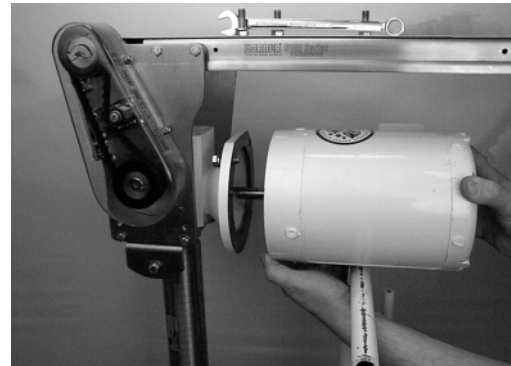
**Step 6: Assemble drive components as shown. Depending on conveyor belt travel (direction 1 or 2), locate timing belt tensioner (N) as shown. Tension timing belt to obtain 1/8" (3 mm) deflection when applying 1 lb (4.3 N) of force at the timing belt mid-point (O). Tighten tensioner with 38 ft-lb (51 Nm) of torque.**

**Step 7: Attach drive cover (F) and tightly secure the cover screws (K) with 35 in-lb (4 Nm) of torque.**



**Step 8: Locate motor, key (I) and lock washers & mounting screws (J).**

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



**Step 9: With key in keyway of motor shaft, align motor shaft with gear reducer input coupling and slide motor and gear reducer together. Secure the (4) mounting screws and lock washers (J) using 32 ft-lb (41 Nm) of torque.**

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

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