



Adjustable Tie Brackets

Set-up, Operation & Maintenance Manual



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Table of Contents

Introduction	2	Attachment to Conveyor	7
Warnings – General Safety	3	Preventive Maintenance and Adjustment	9
Product Description	4	Required Tools	9
Specifications	4	Tie Kit Length Adjustment	9
Installation	5	Return Policy.....	10
Required Tools.....	5		
Steel Stand Attachment Methods.....	5		
Aluminum Stand Attachment Methods	6		

Introduction

IMPORTANT

<i>Some illustrations may show guards removed. Do NOT operate equipment without guards.</i>

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 conveyors are covered by the following patent numbers: 5131529, 5156260, 5156261, 5174435, 5203447, 5265714, 5875883, 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.

Warnings – General Safety

WARNING

The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.

DANGER



Climbing, sitting, walking or riding on conveyor will cause severe injury. **KEEP OFF CONVEYORS.**

DANGER



DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

WARNING



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

WARNING



Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.
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.

WARNING



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.

Product Description

The adjustable tie bracket is a universal bracket compatible with Dorner conveyors and stands. Refer to Figure 1, Figure 2 & Figure 3 for some typical configurations.

- Conveyor (4100 Series not applicable) to stand mounting (Figure 1)
- Stand to stand mounting (Figure 2)
- 90° stand to stand mounting (Figure 3)

Typical Components:

A	Aluminum Stand
B	Adjustable Bar
C	T-slot of Conveyor
D	90° Bracket
E	Steel Stand

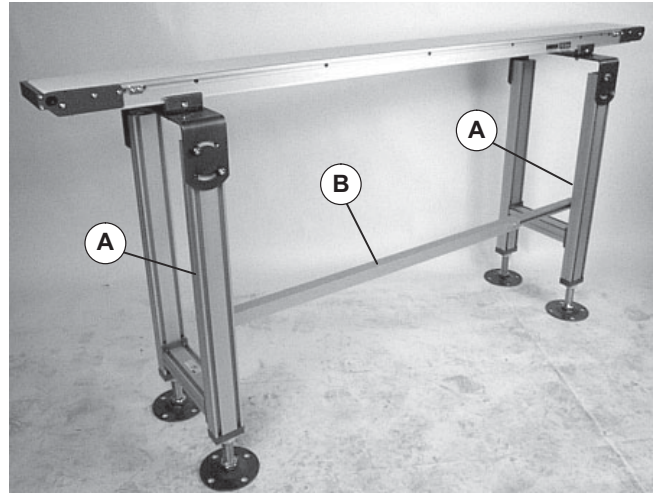


Figure 2

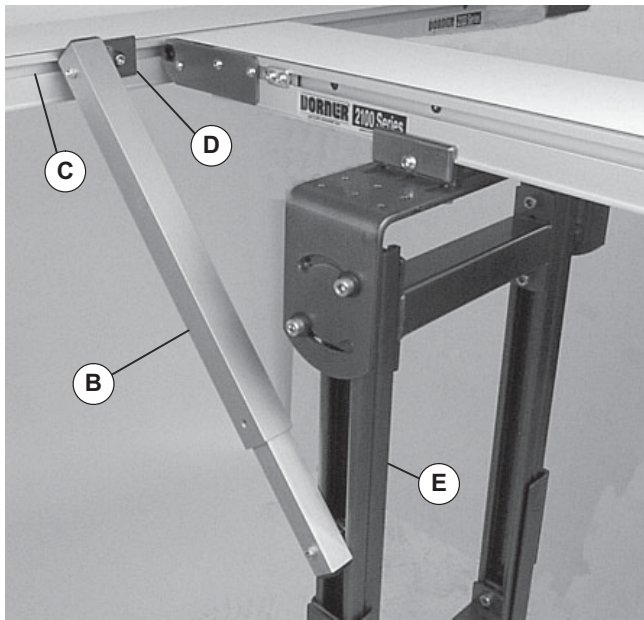


Figure 1

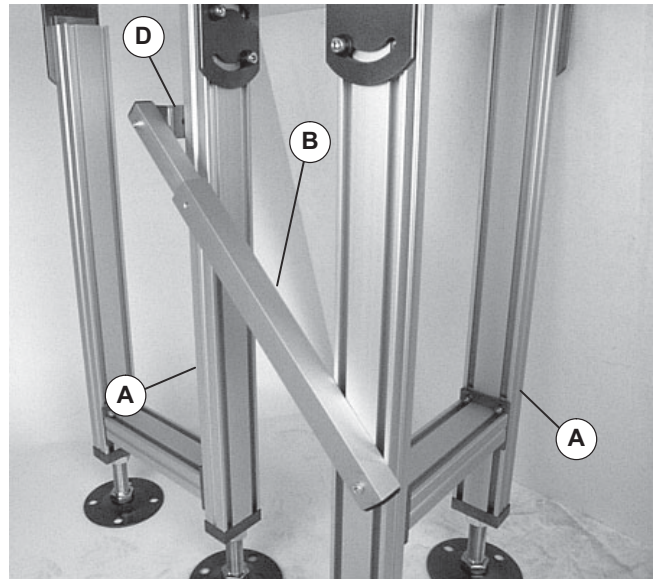



Figure 3

Specifications

Models:

Kit Number	Nominal Length	Length Range
27M400-02	2 ft 610 mm	16.25 to 27" 413 to 686 mm
27M400-03	3 ft 914 mm	28.25 to 39" 718 to 1295 mm
27M400-04	4 ft 1219 mm	40.25 to 51" 1022 to 1295 mm
27M400-05	5 ft 1524 mm	52.25 to 63" 1327 to 1600 mm
27M400-06	6 ft 1829 mm	64.25 to 75" 1632 to 1905 mm

⚠ WARNING



Exposed moving parts can cause severe injury.

LOCK OUT POWER before removing guards or performing maintenance.

Required Tools

- 5 mm hex key wrench
- Torque wrench

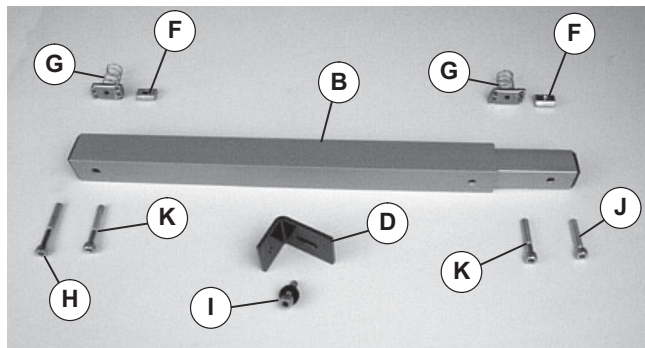


Figure 4

Illustration References:

B	Adjustable Bar
D	90° Bracket
F	M6 T-bars (2x)
G	M6 Spring Channel Nuts (2x)
H	M6 x 45 mm Socket Head Screw
I	M6 x 16 mm Socket Head Screw & Hard Washer
J	M6 x 35 mm Socket Head Screw
K	M6 x 40 mm Socket Head Screw (2x)

Steel Stand Attachment Methods

NOTE

For steel stands, parts (Figure 4, item F) and (Figure 4, item J) are not used; please discard.

1. Loosen screw (Figure 5, item L) of adjustable bar (B).

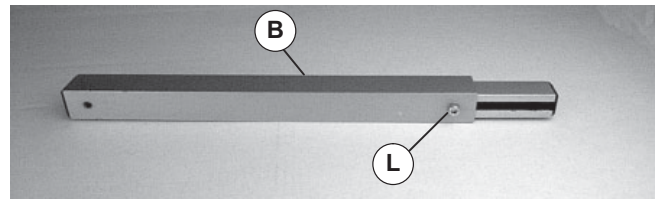


Figure 5

2. Install spring nut (Figure 6, item G) into steel stand channel.

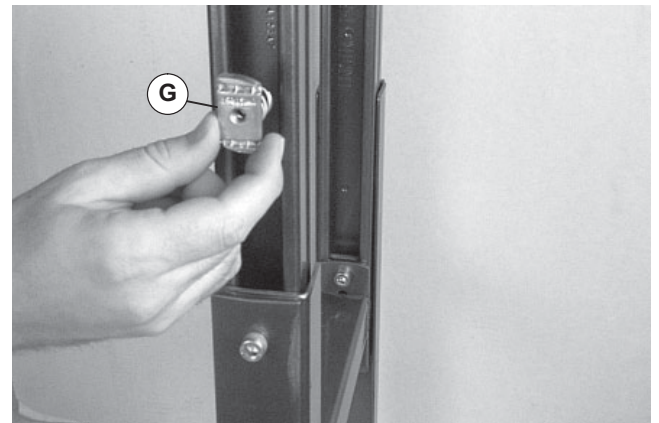


Figure 6

NOTE

For a 90° stand to stand mounting, loosely attach 90° bracket (Figure 7, item D) spring nut (G) using screw and washer (I).

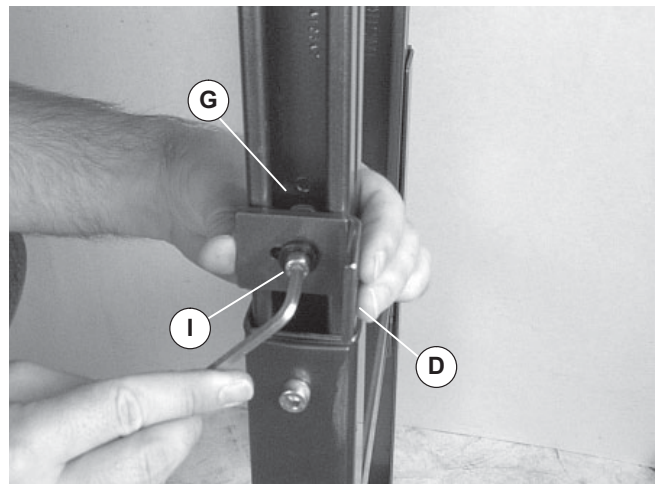


Figure 7

Installation

3. Loosely attach adjustable bar (Figure 8, item B) or (Figure 9, item B) to 90° bracket or steel stand channel as required.

- Attach outer tube end with screw (Figure 8, item H)

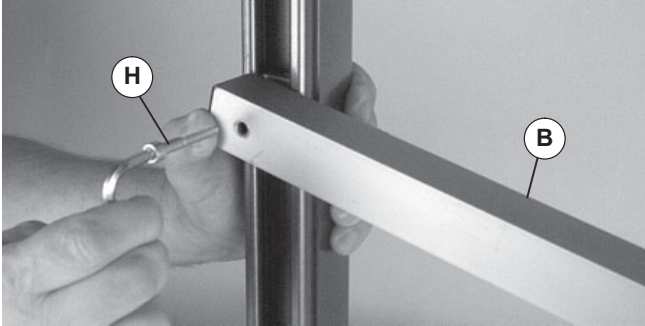


Figure 8

- Attach inner channel end with screw (Figure 9, item K)

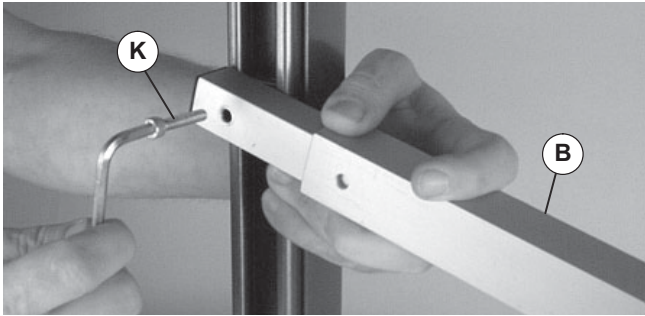


Figure 9

⚠ WARNING
<p>Failure to secure screws (H, K & L) may cause conveyor sections to drop down, causing severe injury. TIGHTEN SCREWS (H, K & L) AFTER ADJUSTMENT.</p>

4. Tighten screws (H, K & L) to 80 in-lb (9 Nm).

Aluminum Stand Attachment Methods

NOTE
<p>For aluminum stands, parts (Figure 4, item G & H) are not used; please discard.</p>

1. Loosen screw (Figure 10, item L) of adjustable bar (B).

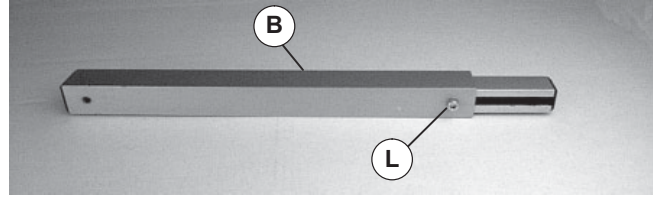


Figure 10

2. Install T-bar (Figure 11, item F) in T-slot.

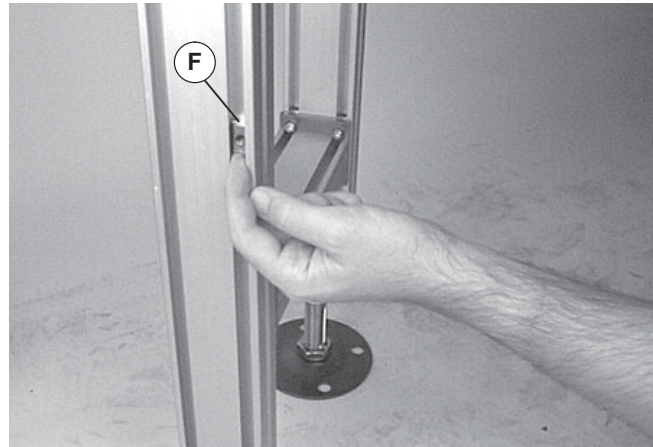


Figure 11

NOTE
<p>For a 90° stand to stand mounting, loosely attach 90° bracket (Figure 12, item D) to T-bar (F) using screw and washer (I).</p>

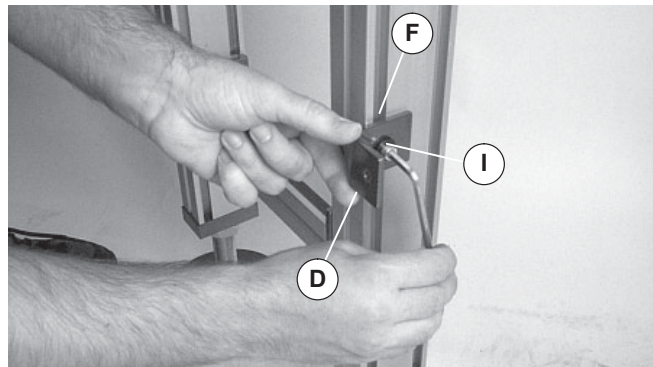


Figure 12

3. Loosely attach adjustable bar (Figure 13, item B) or (Figure 14, item B) to 90° bracket or aluminum stand T-slot as required.

- Attach outer tube end with screw (Figure 13, item K)

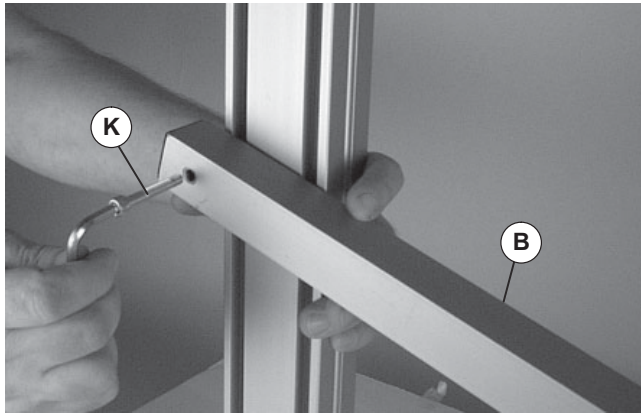


Figure 13

- Attach inner channel end with screw (Figure 14, item J)

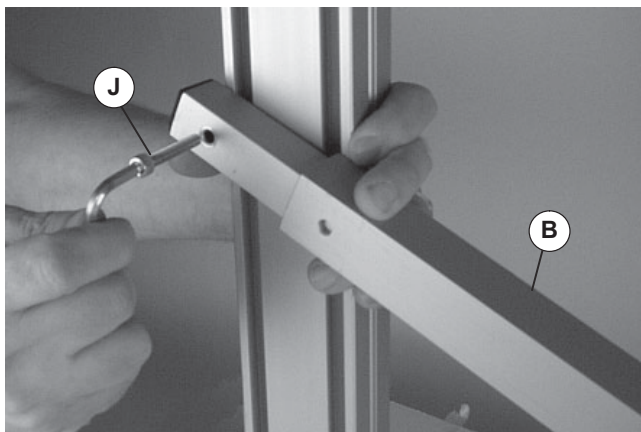


Figure 14

⚠ WARNING	
Failure to secure screws (J, K, & L) may cause conveyor sections to drop down, causing severe injury.	
TIGHTEN SCREWS (J, K & L) AFTER ADJUSTMENT.	

4. Tighten screws (J, K & L) to 80 in-lb (9 Nm).

Attachment to Conveyor

1. Loosen screw (Figure 15, item L) of adjustable bar (B).

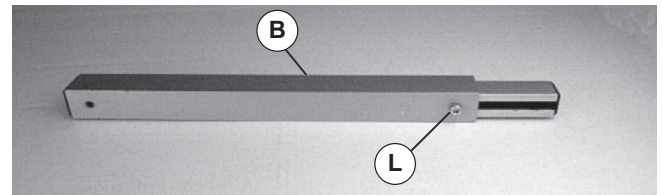


Figure 15

NOTE

For 6100 installation, order mounting clip 450186M.

2. Install T-bar (Figure 11, item F) in T-slot.



Figure 16

Installation

3. Loosely attach 90° bracket (Figure 17, item D) to T-bar (F) using screw and washer (I).

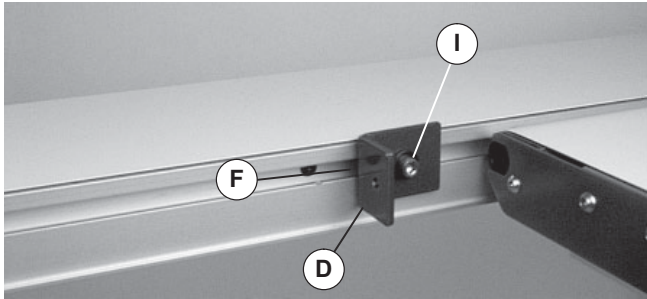


Figure 17

4. Loosely attach adjustable bar (Figure 18, item B) or (Figure 19, item B).

- Attach outer tube end with screw (Figure 18, item K)

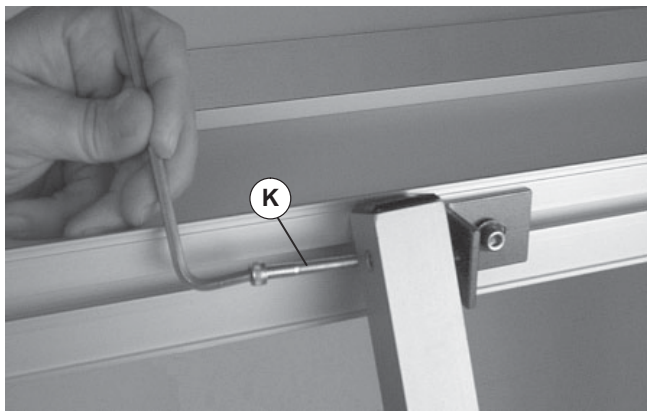


Figure 18

- Attach inner channel end with screw (Figure 19, item J)

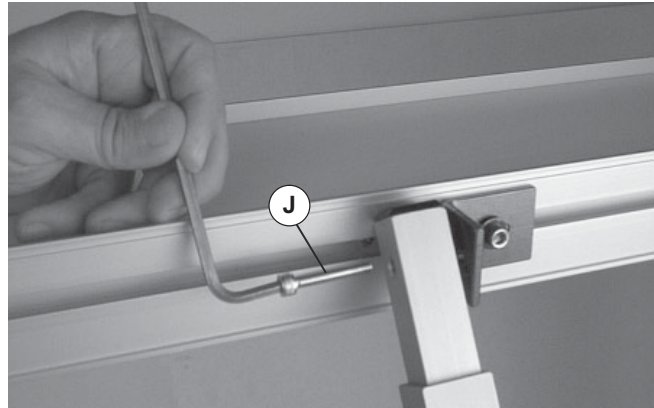



Figure 19

⚠ WARNING	
	
Failure to secure screws (J, K & L) may cause conveyor sections to drop down, causing severe injury.	
TIGHTEN SCREWS (J, K & L) AFTER ADJUSTMENT.	


5. Tighten screws (J, K & L) to 80 in-lb (9 Nm).

Preventive Maintenance and Adjustment

Required Tools

- 5 mm hex key wrench
- Torque wrench

Tie Kit Length Adjustment

⚠ WARNING	
	
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.	

1. Loosen screws (Figure 20, item M, N & O).

2. Shorten or lengthen adjustable bar as required.

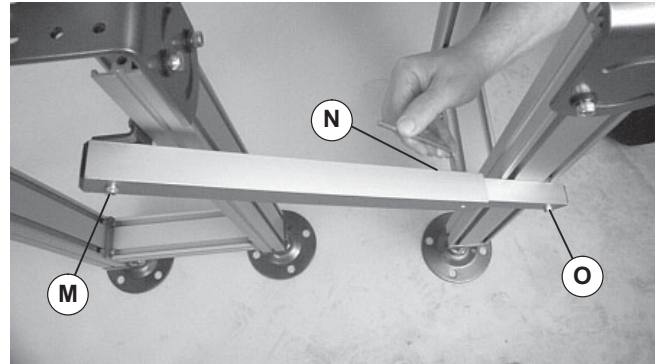



Figure 20

⚠ WARNING	
	
Failure to secure screws (M, N & O) may cause conveyor sections to drop down, causing severe injury. TIGHTEN SCREWS (M, N & O) AFTER ADJUSTMENT.	

3. Tighten screws (Figure 20, item M, N & O) to 80 in-lb (9 Nm).

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.



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