

2100 Series Center Drive Conveyors

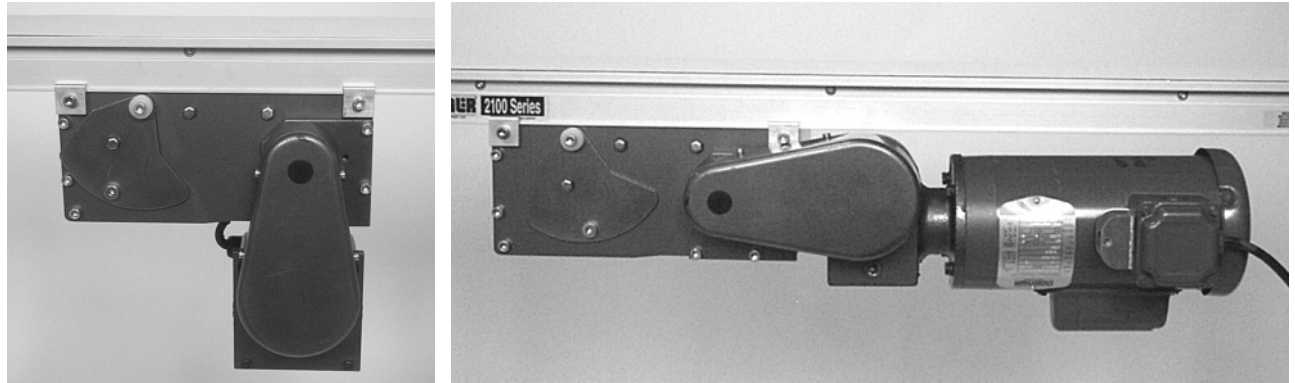





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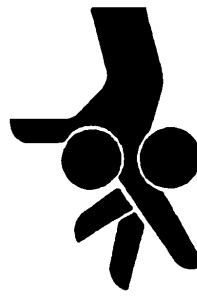

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Warnings – General Safety



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

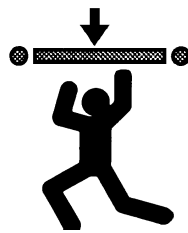

		WARNING
<p>Gearmotors may be HOT. DO NOT TOUCH Gearmotors.</p>		

		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

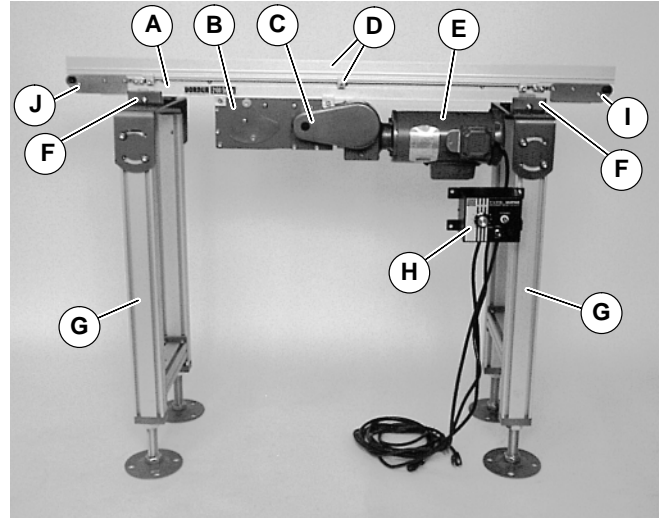
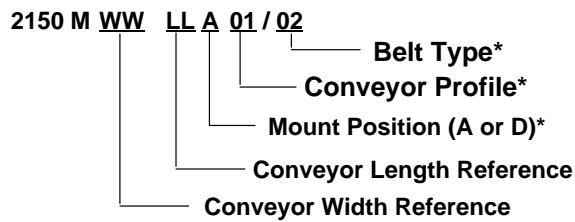


Figure 1

Specifications

Models:

2100 Series Center Drive Conveyor



* See "Ordering and Specifications" Catalog for details.

Conveyor Supports:

Maximum Distances:

K = 18" (457 mm)

L = 6 ft (1829 mm)**

** For conveyors longer than 13 ft (3962 mm), install support at joint.

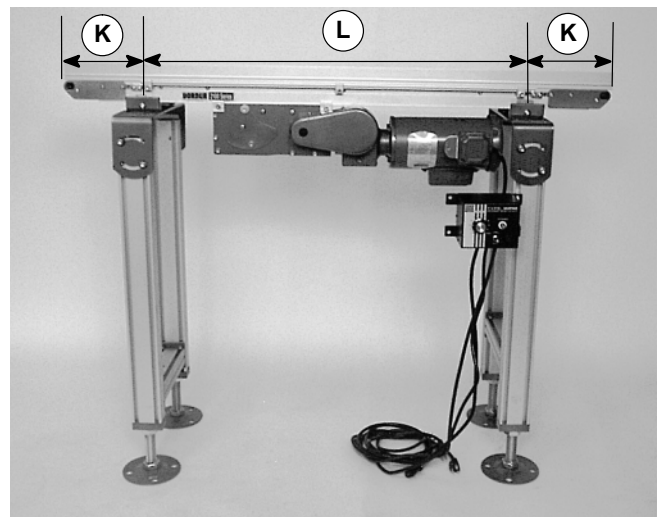


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12
Conveyor Belt Width	1.75" (44 mm)	2.75" (70 mm)	3.75" (95 mm)	5" (127 mm)	6" (152 mm)	8" (203 mm)	10" (254 mm)	12" (305 mm)
Maximum Conveyor Load* (See NOTE Below)	40 lb (18 kg)	50 lb (23 kg)	60 lb (27 kg)	75 lb (34 kg)	90 lb (41 kg)	105 lb (47 kg)	120 lb (54 kg)	120 lb (54 kg)
Conveyor Start-up Torque*	9 in-lb (1.0 Nm)	10 in-lb (1.1 Nm)	11 in-lb (1.2 Nm)	12 in-lb (1.4 Nm)	15 in-lb (1.7 Nm)	20 in-lb (2.3 Nm)	23 in-lb (2.6 Nm)	25 in-lb (2.8 Nm)
Belt Travel	3.5" (88 mm) per revolution of pulley							
Maximum Belt Speed*	235 feet/minute (72 meters/minute)							
Belt Take-up	1" (25 mm) of stroke = 2" (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	2-ft (610 mm)	3-ft (914 mm)	4-ft (1219 mm)	5-ft (1524 mm)	6-ft (1829 mm)	7-ft (2134 mm)	8-ft (2438 mm)	9-ft (2743 mm)	10-ft (3048 mm)	11-ft (3353 mm)	12-ft (3658 mm)	13-ft (3962 mm)	14-ft (4267 mm)	15-ft (4572 mm)	16-ft (4877 mm)	17-ft (5182 mm)	18-ft (5486 mm)	19-ft (5791 mm)	20-ft (6096 mm)	21-ft (6401 mm)	22-ft (6706 mm)	23-ft (7010 mm)	24-ft (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.

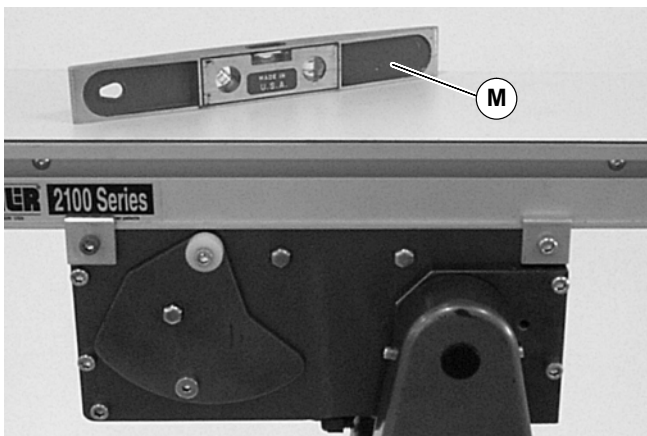


Figure 3

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 13 ft (3962 mm)

No additional assembly is required.

Conveyors Longer Than 13 ft (3962 mm)

1. Typical components (Figure 4)

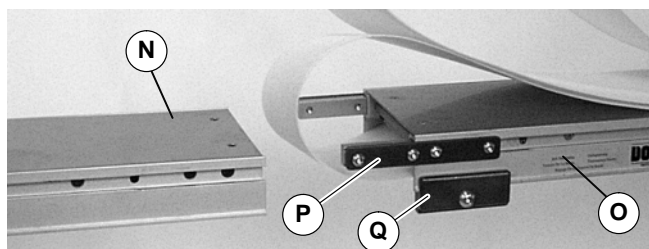



Figure 4

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.

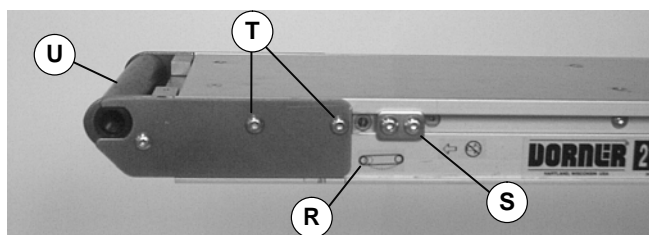


Figure 5

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.

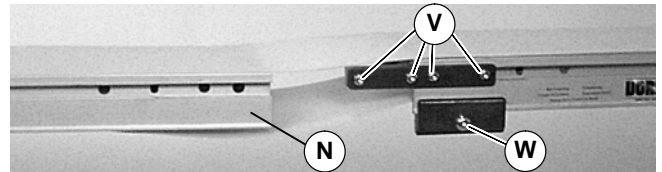


Figure 6

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 or sections.

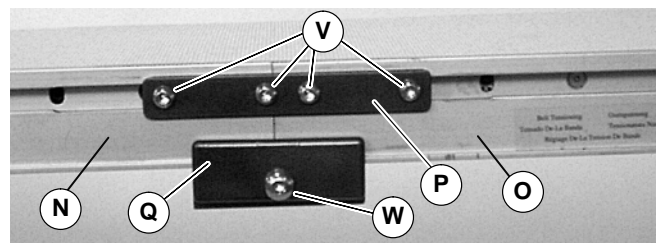


Figure 7

8. Tighten connector strip screws (V) to 18 in-lb (2 Nm). Tighten bracket screws (W) to 80 in-lb (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 1.19" (30 mm).

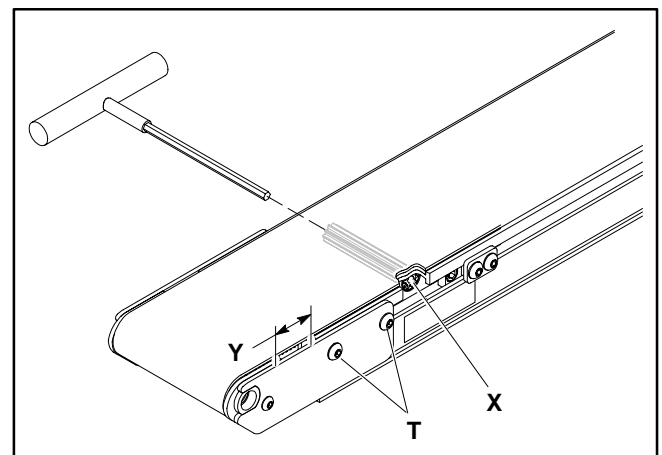


Figure 8

10. While holding the pinion gear (X), tighten cover plate screws (T) to 18 in-lb (2 Nm).

Installation

Mounting Brackets with Return Rollers 2" to 12" (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.

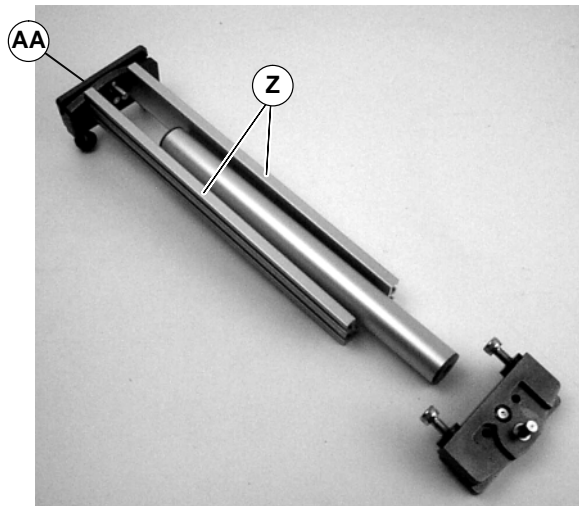


Figure 9

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

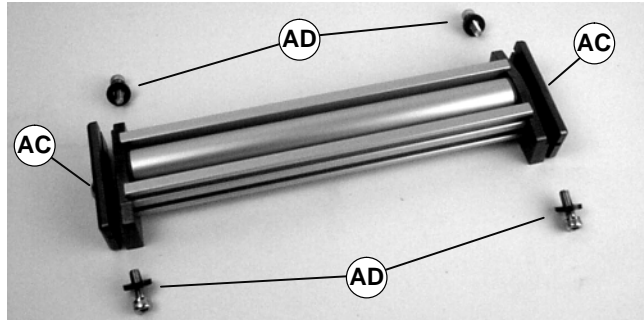


Figure 10

3. Attach clamp plates on each side of conveyor (Figure 11). Tighten the screws (AC) to 80 in-lb (9 Nm).

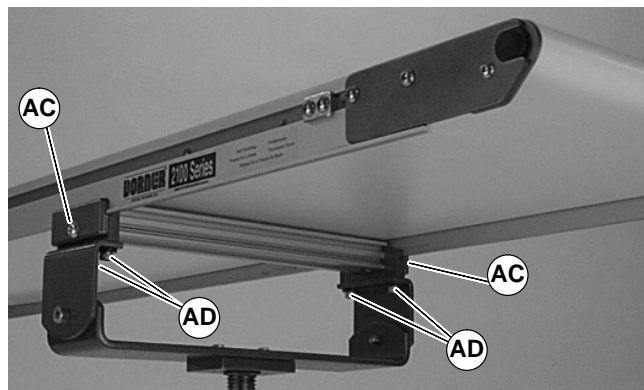


Figure 11

4. Attach to support stand. Tighten screws (AD) to 80 in-lb (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

	<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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Pulley Bearings

NOTE:

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

NOTE:

2" (44 mm) wide conveyors use shielded ball bearings and do not require lubrication.

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

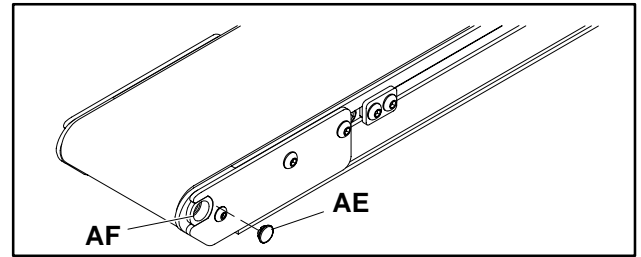


Figure 12

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

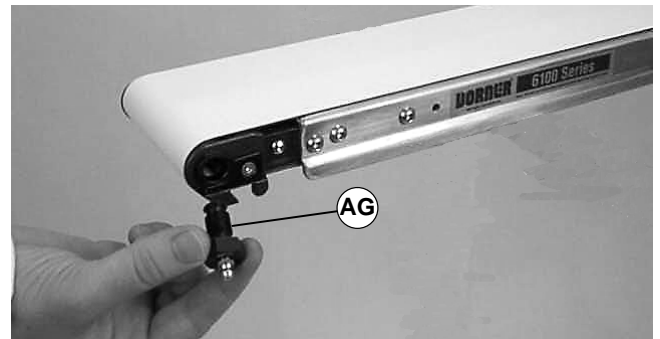


Figure 13

3. Use Dorner red grease, 14 oz (397 gram) cartridge (part # 829-002) or 14 oz (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

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

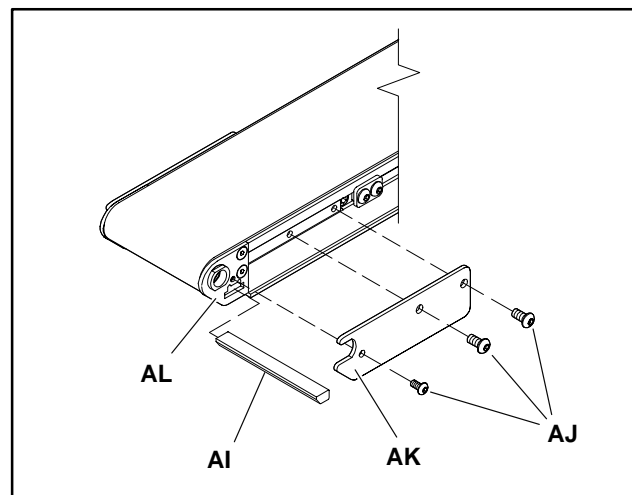


Figure 14

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

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

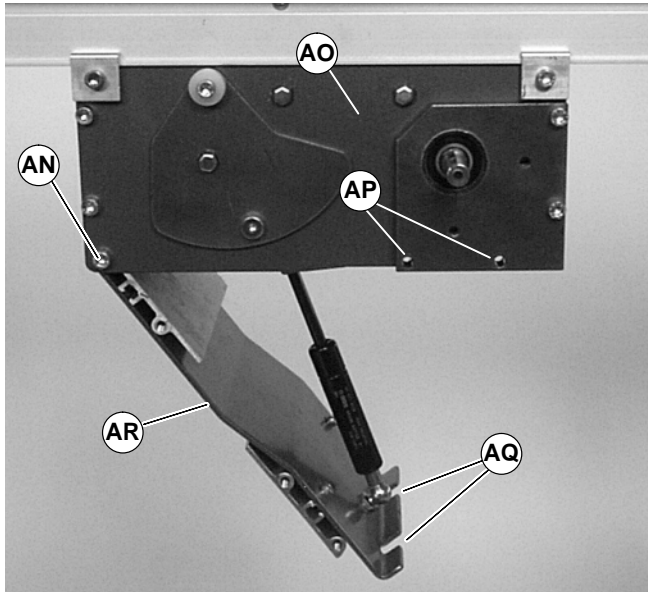



Figure 15

- Remove tension door screws (AP) on each side of the center drive module.
- 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.

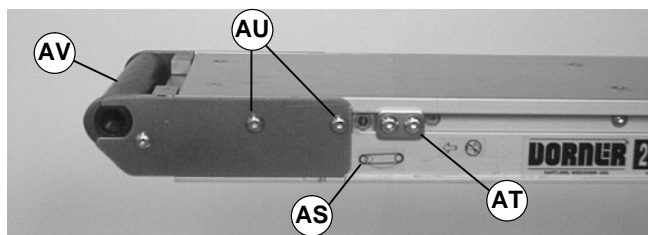


Figure 16

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

NOTE: On 4-ft (1219 mm) and shorter by 8" (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.

- Remove conveyor belt.
- Proceed to "Center Drive Module Removal" on page 11.

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

- From the discharge end, remove tail cover plate screws (AJ of Figure 14) from one side of the conveyor.
- Remove tail cover plate (AK).
- Slide bottom wiper (AI) through side slot of tail plate (AL).
- 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.

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

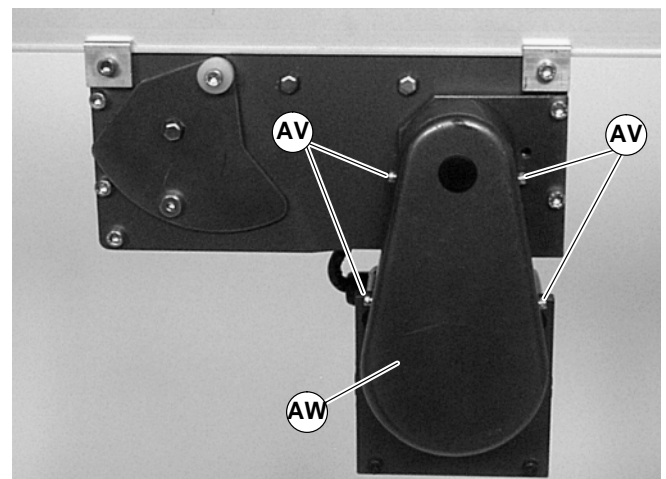


Figure 17

Preventive Maintenance and Adjustment

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

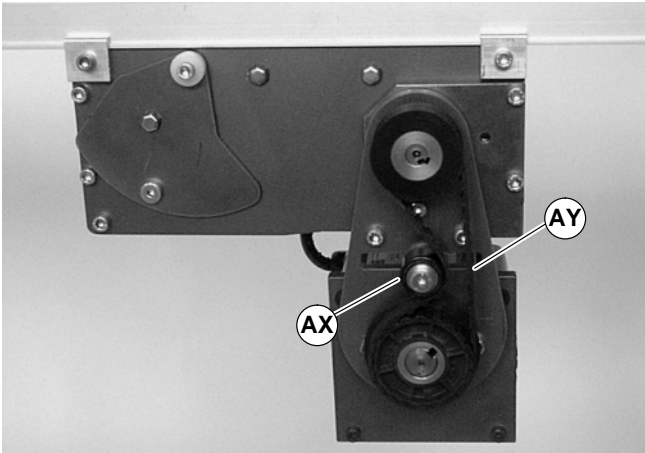


Figure 18

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).

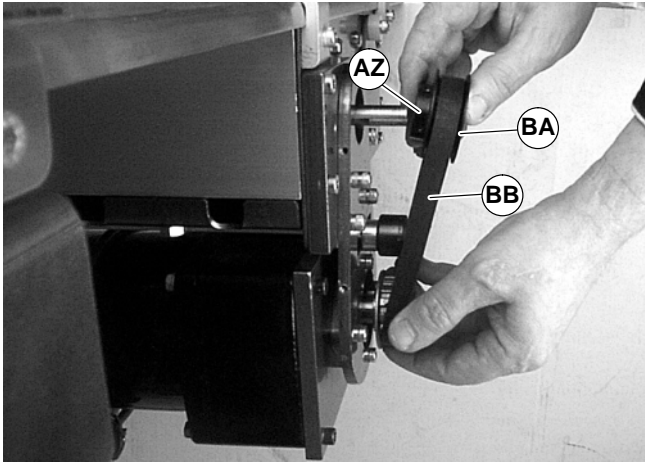


Figure 19

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

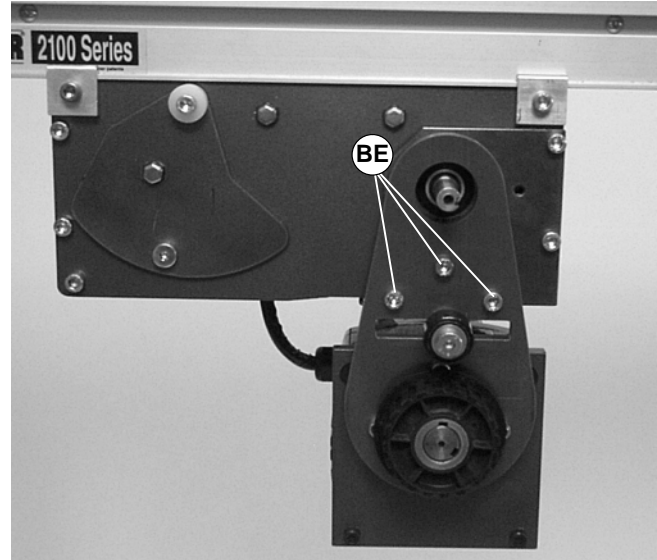



Figure 20

- 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.

- 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 4-foot (1219 mm) and shorter by 8" (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.

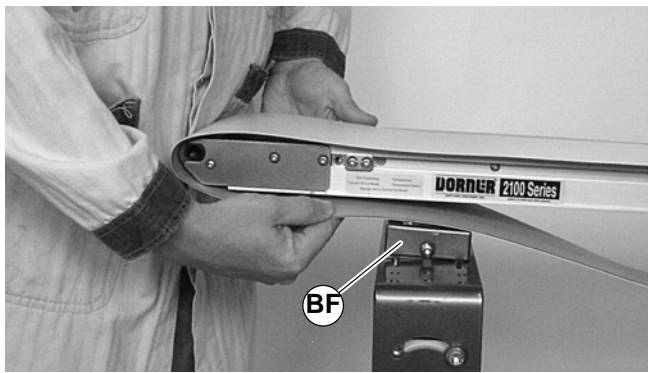


Figure 21

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	
<p>Before loosening clamps (BG of Figure 22), provide a support (BH) under center drive module.</p>		

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

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

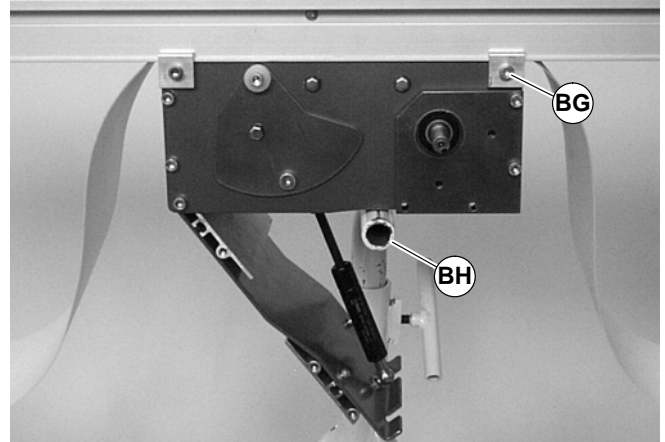


Figure 22

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).

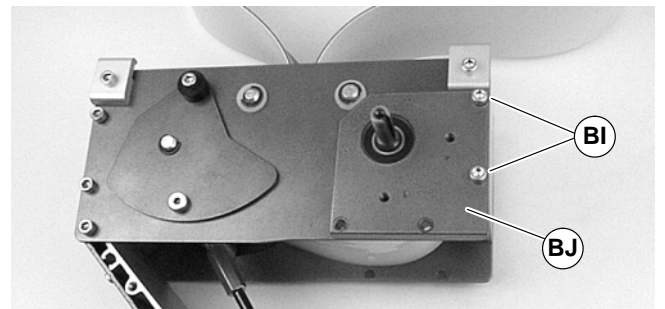


Figure 23

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

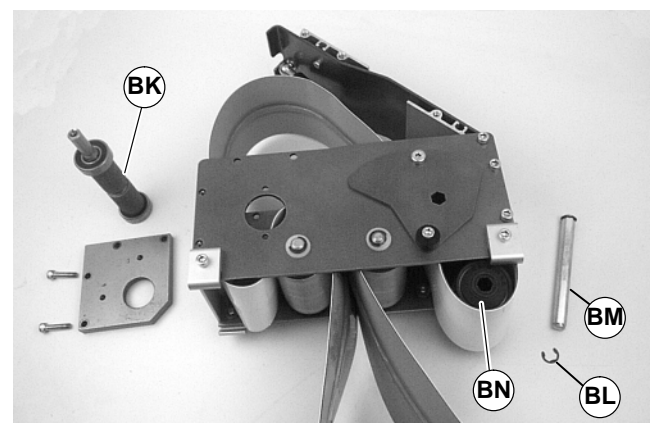


Figure 24

Preventive Maintenance and Adjustment

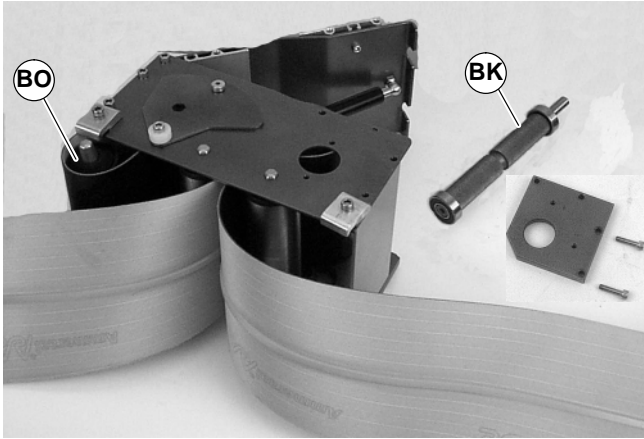


Figure 25

3. Remove grooved idler pulley:
 - For 2" (44 mm), 3" (70 mm) or 4" (95 mm) wide conveyor, detach E-ring clip (BL of Figure 24). Remove pulley shaft (BM) and remove pulley (BN).
 - For 5" (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

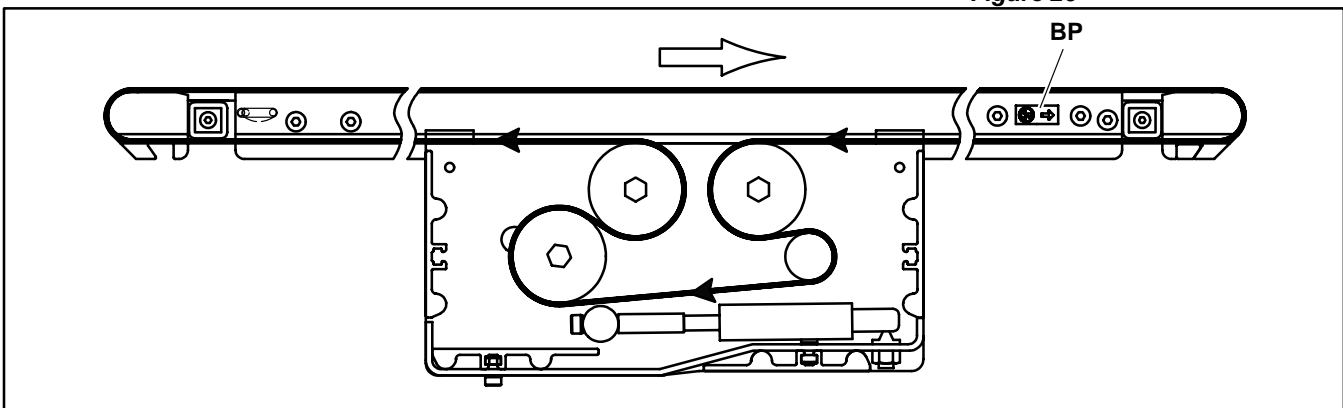


Figure 27

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).

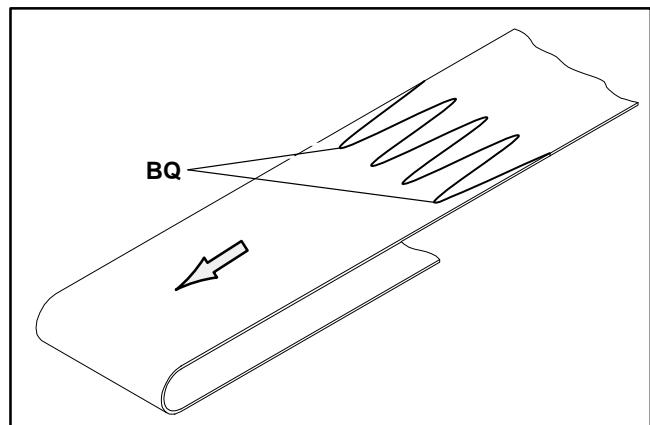


Figure 28

Preventive Maintenance and Adjustment

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

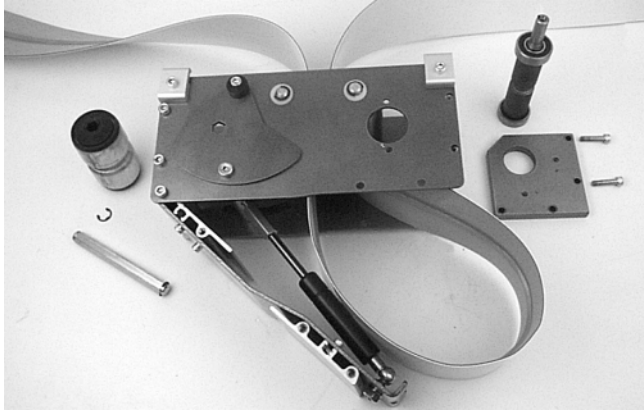


Figure 29

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 80 in-lb (9 Nm).

NOTE: On 4-foot (1219 mm) and shorter by 8” (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 80 in-lb (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 80 in-lb (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 1.19” (30 mm).

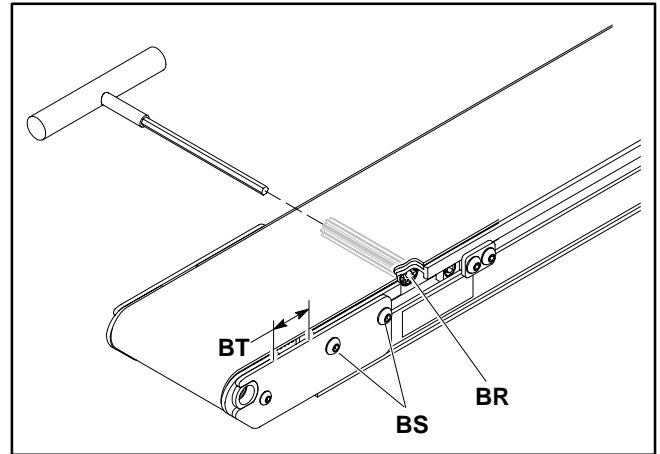


Figure 30

10. While holding the pinion gear (BR), tighten cover plate screws (BS) to 18 in-lb (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).

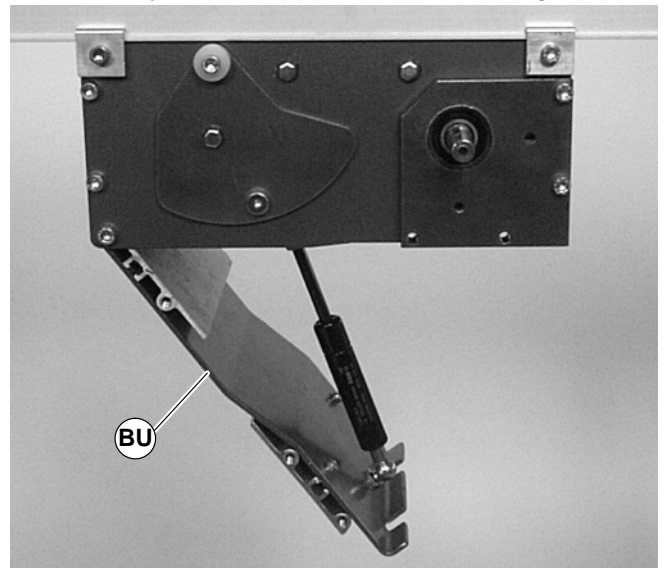


Figure 31

Preventive Maintenance and Adjustment

12. Tighten corner screws (BU of Figure 32) on each side of the drive module to 80 in-lb (9 Nm).

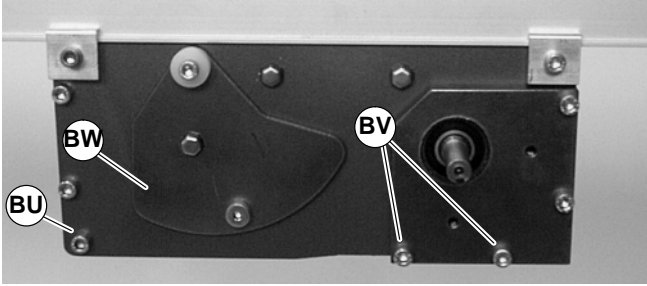


Figure 32

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 80 in-lb (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.

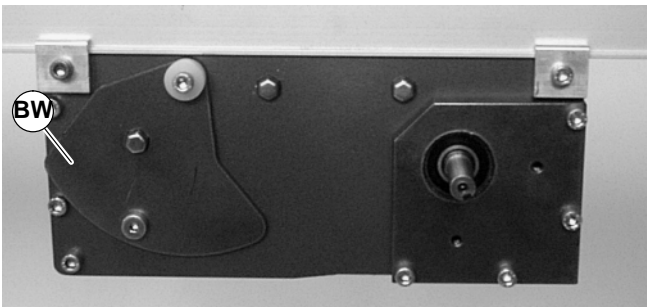


Figure 33

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 blade screwdriver, remove plug (BX of Figure 34) from retainer (BY).

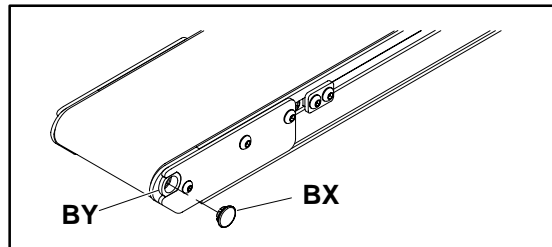


Figure 34

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

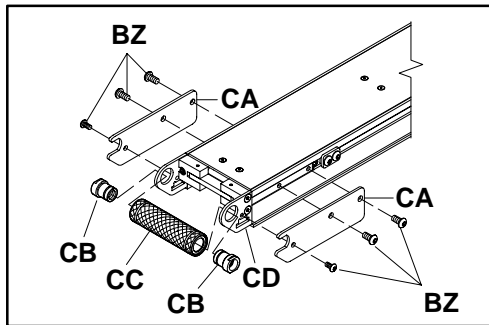


Figure 35

3. 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).

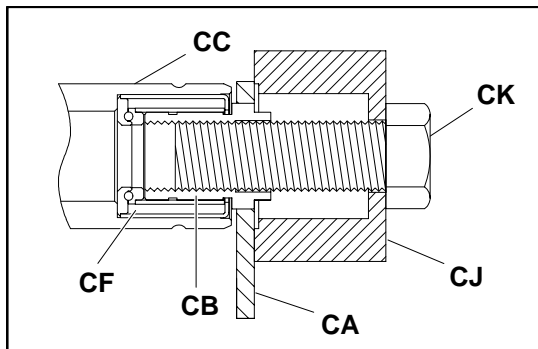


Figure 36

4. 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).
5. Tighten the bolt (CK) until the retaining sleeve (CB) is free of the tail pulley plate (CA).
6. Remove the retaining sleeve (CB) from the bolt (CK) and repeat for the other side.
7. Remove the pulley (CC).

B – Drive Pulley Removal

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

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

C – Idler Pulley Removal

1. Remove the gearmotor drive package. Refer to “Belt Removal for Conveyor With Stands and/or Gearmotor Mounting Package”, page 9, steps 5 through 7.
2. Detach the center drive module. Refer to “Center Drive Module Removal”, page 11.
3. Remove the grooved idler pulley. Refer to “Belt Removal from Center Drive Module”, step 3, page 12.
4. Remove smooth idler pulleys:
 - For 2” (44 mm), 3” (70 mm) or 4” (95 mm) wide conveyor, detach E-ring clips and remove washers (CL of Figure 37). Remove pulley shafts (CM) and pulleys (CN).

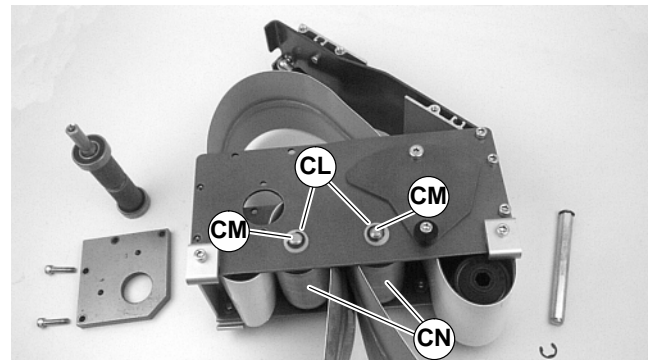


Figure 37

- For 5” (127 mm) or wider conveyor, depress both sides of each spring-loaded shaft (CO of Figure 38). Remove pulleys (CP).

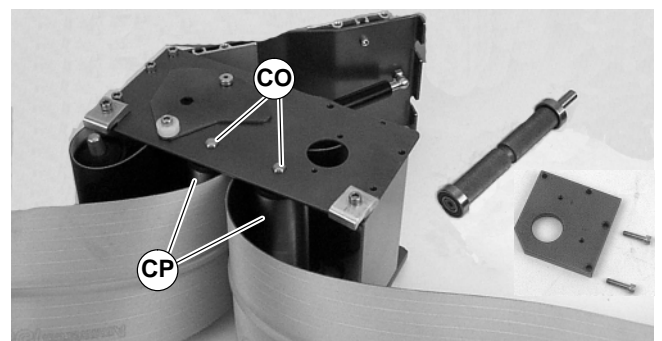


Figure 38

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 2" (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).

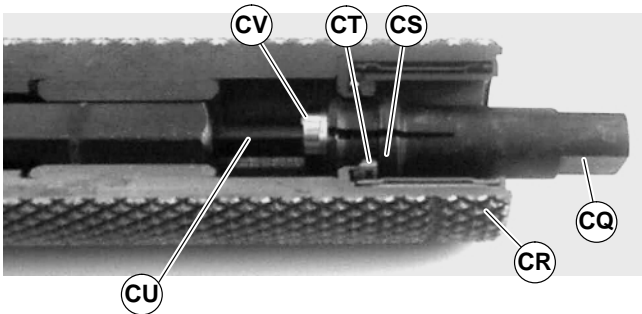


Figure 39

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.

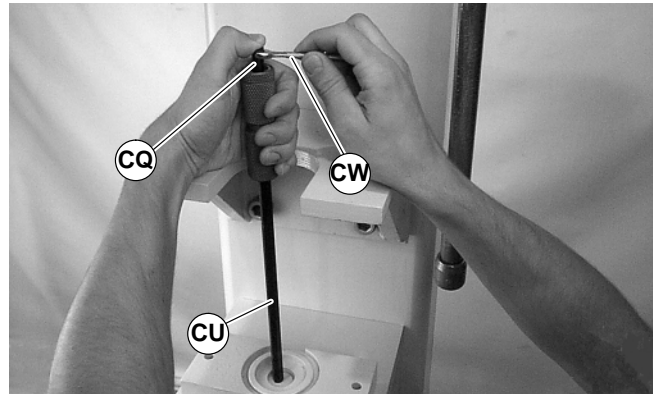


Figure 40

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.

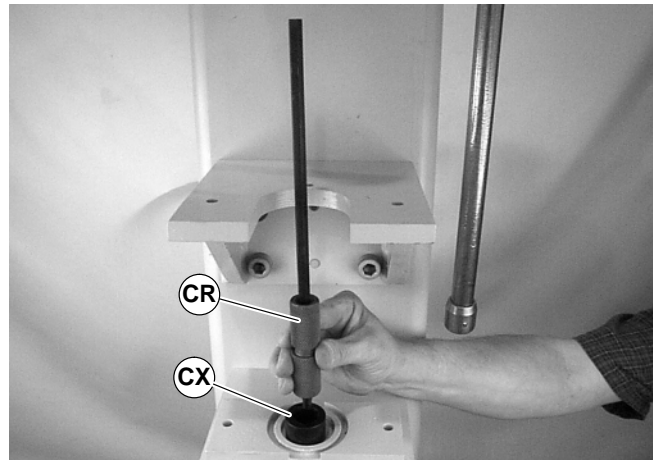


Figure 41

Preventive Maintenance and Adjustment

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

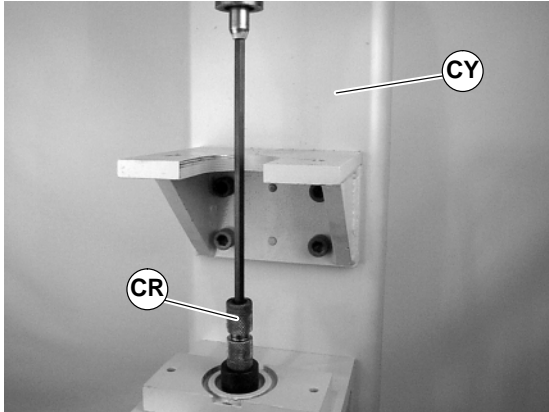


Figure 42

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

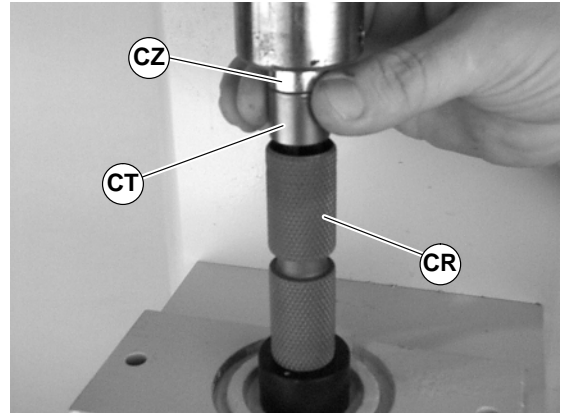


Figure 45

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

IMPORTANT: Bearing and pulley alignment is critical.

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.

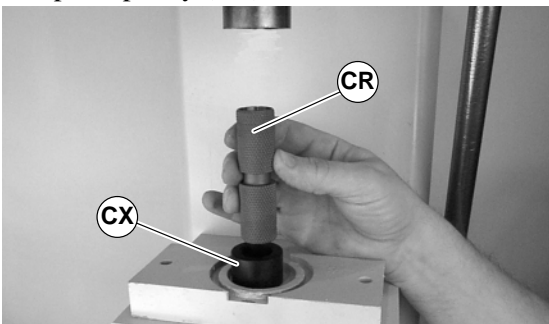


Figure 43

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

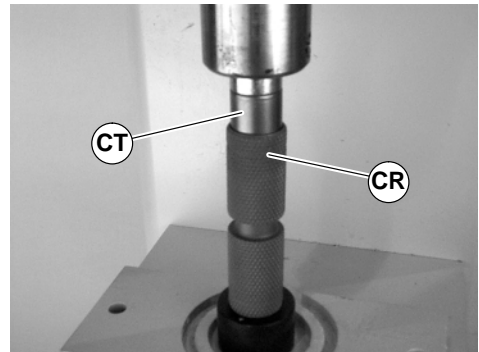


Figure 46

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

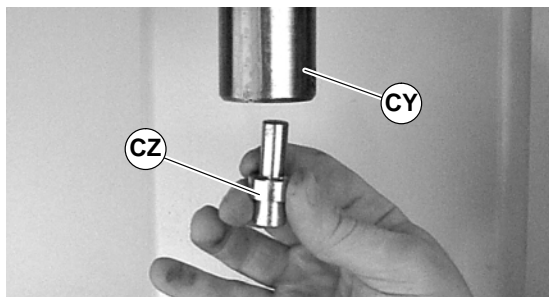


Figure 44

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.

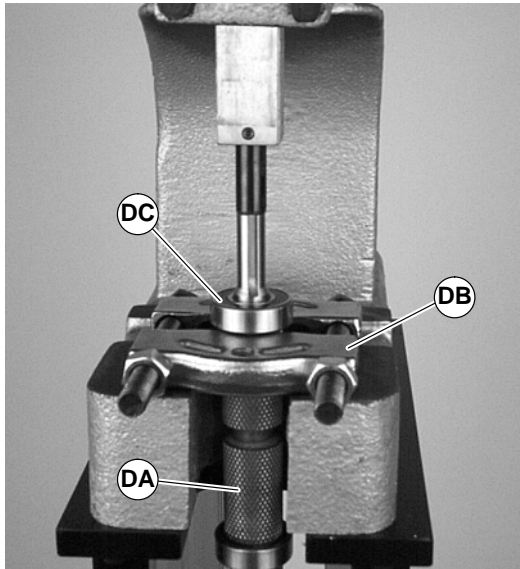


Figure 47

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

Bearing Installation

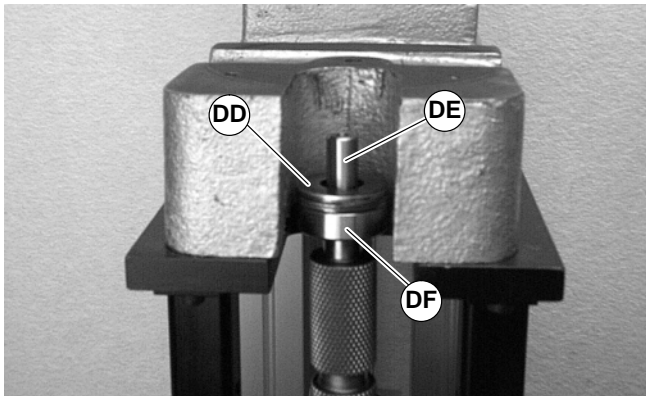


Figure 48

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

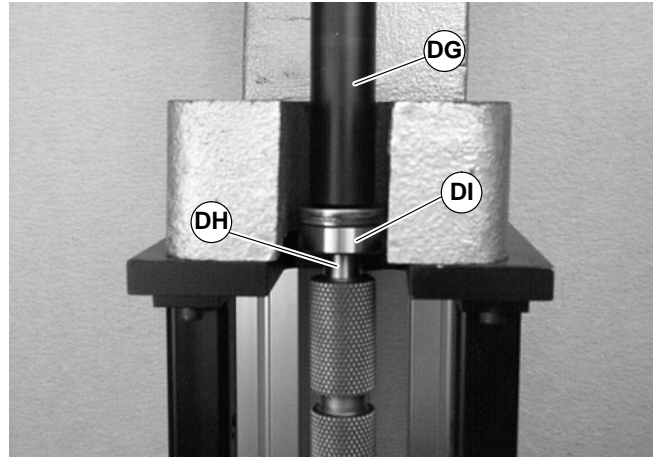


Figure 49

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 20.

Pulley Replacement

End Pulleys

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

Drive Pulley

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

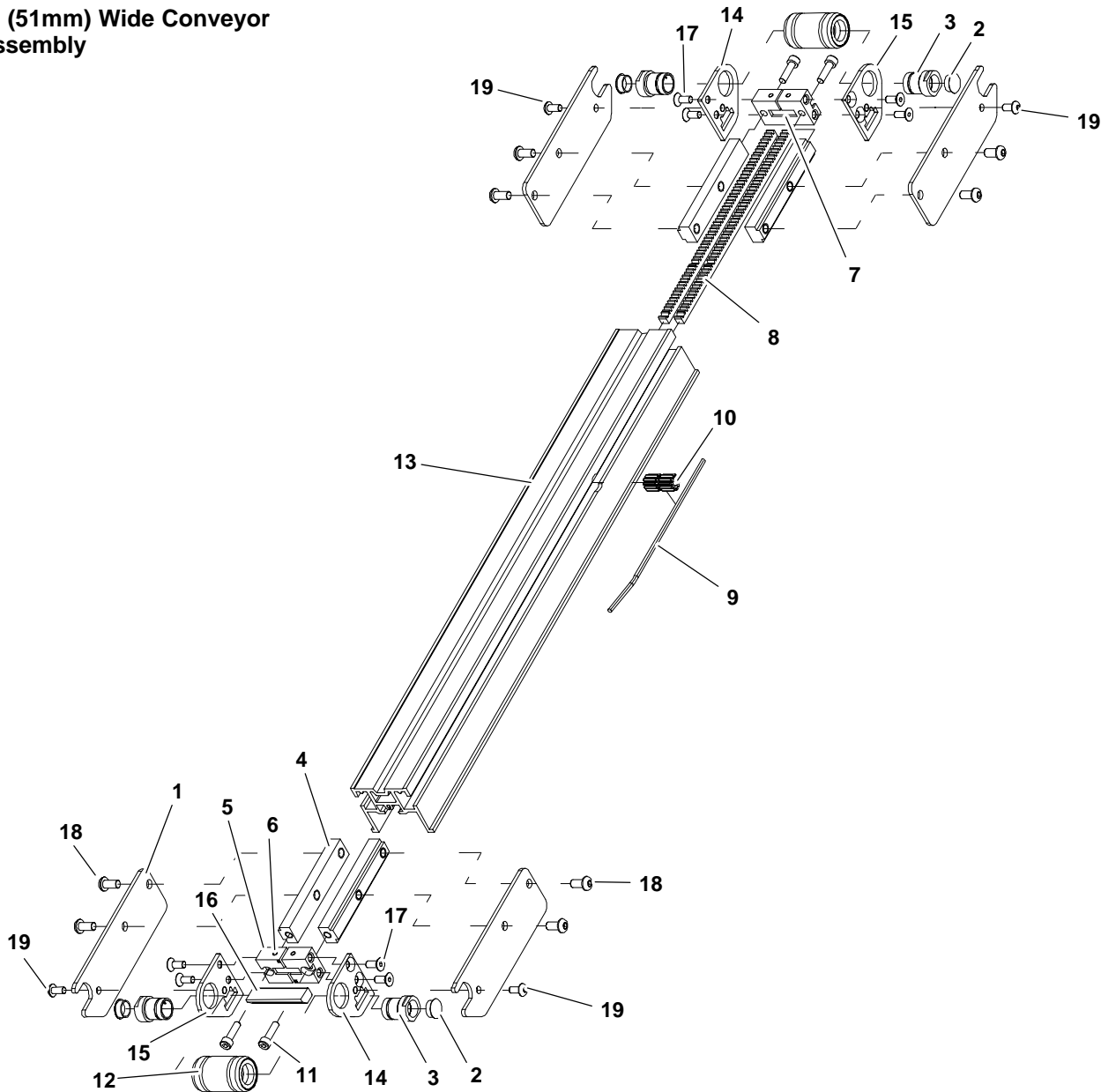
Idler Pulley

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

Service Parts

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

2" (51mm) Wide Conveyor Assembly



Service Parts

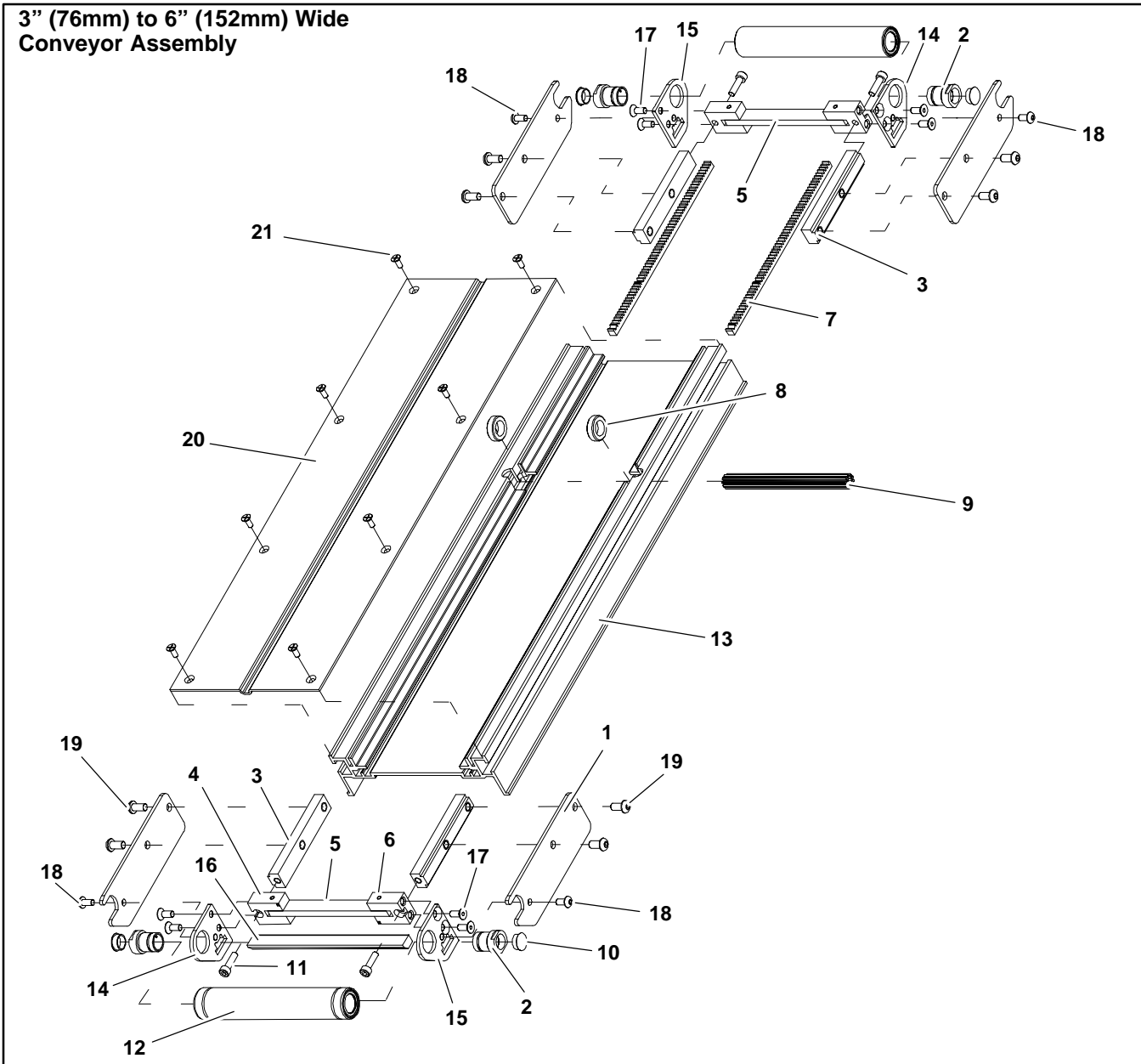
Item	Part Number	Description
1	200030	Cover Plate, SAE
	200030M	Cover Plate, Metric
	200351	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), SAE
	200351M	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), Metric
2	807-784	Plastic Plug
3	200035	Pulley Spindle Retaining Sleeve
4	241129	Tension Slide Bar, SAE
	241128	Tension Slide Bar, Metric
5	200659	Mounting Block SAE
	200659M	Mounting Block Metric
6	200695P	Knurl Pin
7	201472	Flex Link Bar
8	240420	Rack Gear 14.5 PA x 24 P
9	240422	Pinion Pin
10	240423	Pinion 2" (51mm)
11	902-112	Socket Head Screw #10-32 x .75"
	920518M	Socket Head Screw M5 x 18mm
12	303102	Spindle 2" (51mm)
13	See Chart Below	2" (51mm) Frame
14	200027	Tail Plate, SAE, RH
	200027M	Tail Plate, Metric, RH
15	200028	Tail Plate, SAE, LH
	200028M	Tail Plate, Metric, LH
16	203502	Bottom Wiper
17	903-108	Flat Head Screw #10-32 x .50"
	930512M	Flat Head Screw M5 x 12mm

18	901-129	Button Head Screw 1/4-20 x .50"
	910612M	Button Head Screw M6 x 12mm
19	901-106	Button Head Screw #10-32 x .38"
	910510M	Button Head Screw M5 x 10mm

Item 13: 2" (51mm) Conveyor Frame		
Length	Part Number	
2' (610mm)	240402-01908	
3' (914mm)	240402-03108	
4' (1219mm)	240402-04308	
5' (1524mm)	240402-05508	
6' (1829mm)	240402-06708	
7' (2134mm)	240402-07908	
8' (2438mm)	240402-09108	
9' (2743mm)	240402-10308	
10' (3048mm)	240402-11508	
11' (3353mm)	240402-12708	
12' (3658mm)	240402-13908	
13' (3962mm)	240402-07908	240402-07200
14' (4267mm)	240402-09108	240402-07200
15' (4572mm)	240402-10308	240402-07200
16' (4877mm)	240402-11508	240402-07200
17' (5182mm)	240402-12708	240402-07200
18' (5486mm)	240402-13908	240402-07200
19' (5791mm)	240402-07908	240402-14400
20' (6096mm)	240402-09108	240402-14400
21' (6401mm)	240402-10308	240402-14400
22' (6706mm)	240402-11508	240402-14400
23' (7010mm)	240402-12708	240402-14400
24' (7315mm)	240402-13908	240402-14400

Service Parts

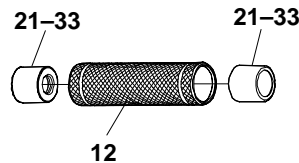
3" (76mm) to 6" (152mm) Wide Conveyor Assembly



Item	Part Number	Description
1	200030	Cover Plate, SAE
	200030M	Cover Plate, Metric
	200351	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), SAE
	200351M	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), Metric
2	200035	Pulley Spindle Retaining Sleeve
3	241129	Tension Slide Bar, SAE
	241128	Tension Slide Bar, Metric
4	200659	Mounting Block, SAE
	200659M	Mounting Block, Metric
5	207603	Flex-Link Bar 3" (76mm)
	207604	Flex-Link Bar 4" (102mm)

	207605	Flex-Link Bar 5" (127mm)
	207606	Flex-Link Bar 6" (152mm)
6	200695P	Knurl Pin
7	240420	Rack Gear 14.5 PA x 24 P
8	240421	Pinion Bushing
9	203003M	Gear Pinion 3" (76mm)
	203004M	Gear Pinion 4" (102mm)
	203005M	Gear Pinion 5" (127mm)
	203006M	Gear Pinion 6" (152mm)
10	807-784	Plastic Plug
11	902-112	Socket Head Cap Screw #10-32 x .75"
	920518M	Socket Head Cap Screw M5 x 18mm

12	See chart below	Spindle Assembly
13	See chart below	Conveyor Frame
14	200028	Tail Plate, SAE, LH
	200028M	Tail Plate, Metric, LH
15	200027	Tail Plate, SAE, RH
	200027M	Tail Plate, Metric, RH
16	203503	Bottom Wiper 3" (76mm)
	203504	Bottom Wiper 4" (102mm)
	203505	Bottom Wiper 5" (127mm)
	203506	Bottom Wiper 6" (152mm)
17	903-108	Flat Head Screw #10-32 x .50"
	930512M	Flat Head Screw M5 x 12mm
18	901-106	Button Head Screw #10-32 x .38"
	910510M	Button Head Screw M5 x 10mm
19	901-129	Button Head Screw 1/4-20 x .50"
	910612M	Button Head Screw M6 x 12mm
20	See chart below	Bed Plate
21	807-1074	Flat Head Screw M4 x 10mm



Item 12: Spindle Assembly		
Width	With Bearings (21-33)	Without Bearings
3" (76mm)	303103	303203
4" (102mm)	303104	303204
5" (127mm)	303105	303205
6" (152mm)	303106	303206

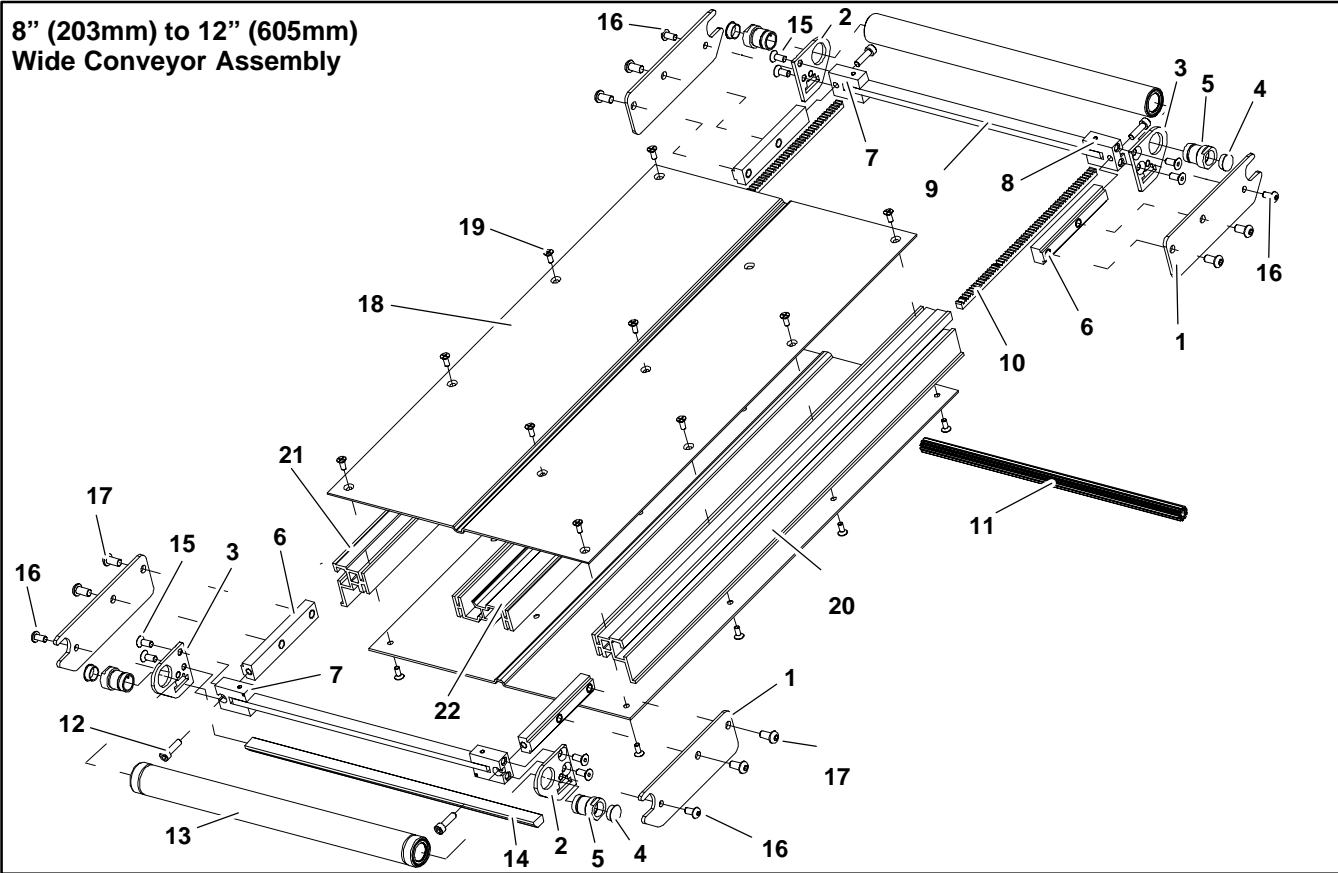
Item 13: Conveyor Frame	
Length	Part Number
2' (610mm)	2404WW-01908
3' (914mm)	2404WW-03108
4' (1219mm)	2404WW-04308
5' (1524mm)	2404WW-05508
6' (1829mm)	2404WW-06708
7' (2134mm)	2404WW-07908
8' (2438mm)	2404WW-09108
9' (2743mm)	2404WW-10308
10' (3048mm)	2404WW-11508

11' (3353mm)	2404WW-12708
12' (3658mm)	2404WW-13908
13' (3962mm)	2404WW-06708 2404WW-07908
14' (4267mm)	2404WW-06708 2404WW-09108
15' (4572mm)	2404WW-06708 2404WW-10308
16' (4877mm)	2404WW-06708 2404WW-11508
17' (5182mm)	2404WW-06708 2404WW-12708
18' (5486mm)	2404WW-06708 2404WW-13908
19' (5791mm)	2404WW-07908 2404WW-14400
20' (6096mm)	2404WW-09108 2404WW-14400
21' (6401mm)	2404WW-10308 2404WW-14400
22' (6706mm)	2404WW-11508 2404WW-14400
23' (7010mm)	2404WW-12708 2404WW-14400
24' (7315mm)	2404WW-13908 2404WW-14400
WW = Conveyor width reference: 03, 04, 05, 06	

Item 20: Bed Plate	
Length	Part Number
2' (610mm)	2405WW-01904
3' (914mm)	2405WW-03104
4' (1219mm)	2405WW-04304
5' (1524mm)	2405WW-05504
6' (1829mm)	2405WW-06704
7' (2134mm)	2405WW-07904
8' (2438mm)	2405WW-09104
9' (2743mm)	2405WW-10304
10' (3048mm)	2405WW-11504
11' (3353mm)	2405WW-12704
12' (3658mm)	2405WW-13904
13' (3962mm)	2405WW-07196 2404WW-07904
14' (4267mm)	2405WW-07196 2404WW-09104
15' (4572mm)	2405WW-07196 2404WW-10304
16' (4877mm)	2405WW-07196 2404WW-11504
17' (5182mm)	2405WW-07196 2404WW-12704
18' (5486mm)	2405WW-07196 2404WW-13904
19' (5791mm)	2405WW-07908 2405WW-14400
20' (6096mm)	2405WW-09108 2405WW-14400
21' (6401mm)	2405WW-10308 2405WW-14400
22' (6706mm)	2405WW-11508 2405WW-14400
23' (7010mm)	2405WW-12708 2405WW-14400
24' (7315mm)	2405WW-13908 2405WW-14400
WW = Conveyor Width reference: 03, 04, 05, 06	

Service Parts

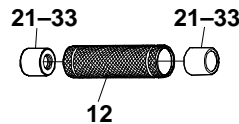
8" (203mm) to 12" (605mm) Wide Conveyor Assembly



Item	Part Number	Description
1	200030	Cover Plate, SAE
	200030M	Cover Plate, Metric
	200351	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), SAE
	200351M	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), Metric
2	200027	Tail Plate, SAE, RH
	200027M	Tail Plate, Metric, RH
3	200028	Tail Plate, SAE, LH
	200028M	Tail Plate, Metric, LH
4	807-784	Plastic Plug
	200035	Pulley Spindle Retaining Sleeve
6	241128	Tension Slide Bar, Metric
	241129	Tension Slide Bar, SAE
7	200659	Mounting Block, SAE
	200659M	Mounting Block, Metric
8	200695P	Knurl Pin
9	207608	Flex-Link Bar 8" (203mm)
	207610	Flex-Link Bar 10" (254mm)
	207612	Flex-Link Bar 12" (305mm)
10	240420	Rack Gear 14.5 PA x 24 P
11	203008M	Gear Pinion 8" (203mm)
	203010M	Gear Pinion 10" (254mm)
	203012M	Gear Pinion 12" (305mm)
12	902-112	Socket Head Cap Screw #10-32 x .75"

	920518M	Socket Head Cap Screw M5 x 18mm
13	See chart below	Spindle Assembly
14	203508	Bottom Wiper 8" (203mm)
	203510	Bottom Wiper 10" (254mm)
	203512	Bottom Wiper 12" (305mm)
15	903-108	Flat Head Screw #10-32 x .50"
	930512M	Flat Head Screw M5 x 12
16	901-106	Button Head Screw #10-32 x .38"
	910510M	Button Head Screw M5 x 10mm
	910612M	Button Head Screw M6 x 12mm
17	901-129	Button Head Screw 1/4-20 x .50"
18	See chart below	Bed Plate
19	807-1074	Flat Head Screw M4 x 10mm
20	See chart below	Side Rail RH 8-24" (203-610mm) Wide
21	See chart below	Side Rail LH 8-24" (203-610mm) Wide
22	See chart below	Center Rail 8-12" (203-305mm) Wide

Item 13: Spindle Assembly		
Width	With Bearings (21-33)	Without Bearings
8" (76mm)	303108	303208
10" (102mm)	303110	303210
12" (127mm)	303112	303212



Service Parts

Item 11: Side Rail RH 8–24" (203–610mm) Wide		
Length	Part Number	
2' (610mm)	240412-01908	
3' (914mm)	240412-03108	
4' (1219mm)	240412-04308	
5' (1524mm)	240412-05508	
6' (1829mm)	240412-06708	
7' (2134mm)	240412-07908	
8' (2438mm)	240412-09108	
9' (2743mm)	240412-10308	
10' (3048mm)	240412-11508	
11' (3353mm)	240412-12708	
12' (3658mm)	240412-13908	
13' (3962mm)	240412-07200	240412-07908
14' (4267mm)	240412-07200	240412-09108
15' (4572mm)	240412-07200	240412-10308
16' (4877mm)	240412-07200	240412-11508
17' (5182mm)	240412-07200	240412-12708
18' (5486mm)	240412-07200	240412-13908
19' (5791mm)	240412-07908	240412-14400
20' (6096mm)	240412-09108	240412-14400
21' (6401mm)	240412-10308	240412-14400
22' (6706mm)	240412-11508	240412-14400
23' (7010mm)	240412-12708	240412-14400
24' (7315mm)	240412-13908	240412-14400

Item 12: Side Rail LH 8–24" (203–610mm) Wide		
Length	Part Number	
2' (610mm)	240413-01908	
3' (914mm)	240413-03108	
4' (1219mm)	240413-04308	
5' (1524mm)	240413-05508	
6' (1829mm)	240413-06708	
7' (2134mm)	240413-07908	
8' (2438mm)	240413-09108	
9' (2743mm)	240413-10308	
10' (3048mm)	240413-11508	
11' (3353mm)	240413-12708	
12' (3658mm)	240413-13908	
13' (3962mm)	240413-07200	240413-07908
14' (4267mm)	240413-07200	240413-09108
15' (4572mm)	240413-07200	240413-10308
16' (4877mm)	240413-07200	240413-11508
17' (5182mm)	240413-07200	240413-12708
18' (5486mm)	240413-07200	240413-13908
19' (5791mm)	240413-07908	240413-14400
20' (6096mm)	240413-09108	240413-14400
21' (6401mm)	240413-10308	240413-14400
22' (6706mm)	240413-11508	240413-14400
23' (7010mm)	240413-12708	240413-14400
24' (7315mm)	240413-13908	240413-14400

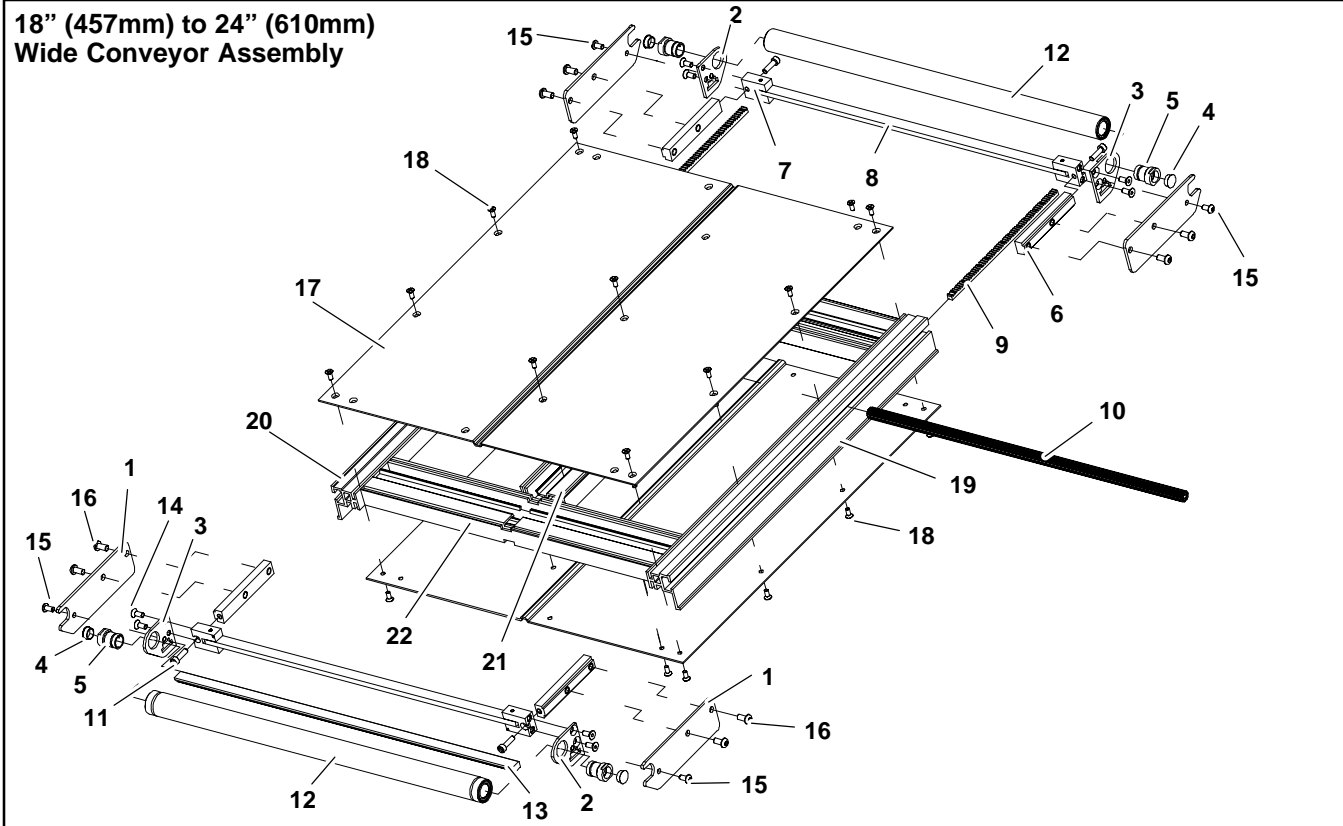
Item 13: Center Rail 8–12" (203–305mm) Wide		
Length	Part Number	
2' (610mm)	240414-01273	
3' (914mm)	240414-02473	
4' (1219mm)	240414-03673	
5' (1524mm)	240414-04873	
6' (1829mm)	240414-06073	
7' (2134mm)	240414-07273	
8' (2438mm)	240414-08473	
9' (2743mm)	240414-09673	
10' (3048mm)	240414-10873	
11' (3353mm)	240414-12073	
12' (3658mm)	240414-13273	
13' (3962mm)	240414-07200	240414-07273
14' (4267mm)	240414-07200	240414-08473
15' (4572mm)	240414-07200	240414-09673
16' (4877mm)	240414-07200	240414-10873
17' (5182mm)	240414-07200	240414-12073
18' (5486mm)	240414-07200	240414-13273
19' (5791mm)	240414-06998	240414-14400
20' (6096mm)	240414-08198	240414-14400
21' (6401mm)	240414-09398	240414-14400
22' (6706mm)	240414-10598	240414-14400
23' (7010mm)	240414-11798	240414-14400
24' (7315mm)	240414-12998	240414-14400

Item 14: Bed Plate		
Length	Part Number	
2' (610mm)	2405WW-01904	
3' (914mm)	2405WW-03104	
4' (1219mm)	2405WW-04304	
5' (1524mm)	2405WW-05504	
6' (1829mm)	2405WW-06704	
7' (2134mm)	2405WW-07904	
8' (2438mm)	2405WW-09104	
9' (2743mm)	2405WW-10304	
10' (3048mm)	2405WW-11504	
11' (3353mm)	2405WW-12704	
12' (3658mm)	2405WW-13904	
13' (3962mm)	2405WW-07196	2405WW-07904
14' (4267mm)	2405WW-07196	2405WW-09104
15' (4572mm)	2405WW-07196	2405WW-10304
16' (4877mm)	2405WW-07196	2405WW-11504
17' (5182mm)	2405WW-07196	2405WW-12704
18' (5486mm)	2405WW-07196	2405WW-13904
19' (5791mm)	2405WW-07908	2405WW-14396
20' (6096mm)	2405WW-09108	2405WW-14396
21' (6401mm)	2405WW-10308	2405WW-14396
22' (6706mm)	2405WW-11508	2405WW-14396
23' (7010mm)	2405WW-12708	2405WW-14396
24' (7315mm)	2405WW-13908	2405WW-14396

WW = Conveyor Width reference: 08, 10, 12

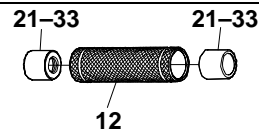
Service Parts

18" (457mm) to 24" (610mm) Wide Conveyor Assembly



Item	Part Number	Description
1	200030	Cover Plate, SAE
	200030M	Cover Plate, Metric
	200351	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), SAE
	200351M	Cover Plate, Notched (Only 2' (610mm) Long Conveyor), Metric
2	200027	Tail Plate, SAE, RH
	200027M	Tail Plate, Metric, RH
3	200028	Tail Plate, SAE, LH
	200028M	Tail Plate, Metric, LH
4	807-784	Plastic Plug
5	200035	Pulley Spindle Retaining Sleeve
6	241129	Tension Slide Bar, SAE
	241128	Tension Slide Bar, Metric
7	200659	Mounting Block, SAE
	200659M	Mounting Block, Metric
8	207618	Flex-Link Bar 18" (457mm)
	207621	Flex-Link Bar 21" (533mm)
	207624	Flex-Link Bar 24" (610mm)
9	240420	Rack Gear 14.5 PA x 24 P
10	203018M	Gear Pinion 18" (457mm)
	203021M	Gear Pinion 21" (533mm)
	203024M	Gear Pinion 24" (610mm)
11	902-112	Socket Head Cap Screw #10-32 x .75"
12	See chart below	Spindle Assembly
13	203518	Bottom Wiper 18" (457mm)

	203521	Bottom Wiper 21" (533mm)
	203524	Bottom Wiper 24" (610mm)
14	903-108	Flat Head Screw #10-32 x .50"
	930512M	Flat Head Screw M5 x 12mm
15	901-106	Button Head Screw #10-32 x .38"
	910510M	Button Head Screw M5 x 10mm
16	901-129	Button Head Screw 1/4-20 x .50"
	910612M	Button Head Screw M6 x 12mm
17	See chart below	Bed Plate
18	807-1074	Flat Head Screw M4 x 10mm
19	See chart below	Side Rail RH 8-24" (203-610mm) Wide
20	See chart below	Side Rail LH 8-24" (203-610mm) Wide
21	See chart below	Center Rail 8-12" (203-305mm) Wide
	240417	Center Rail Cross Support 18" (457mm)
	240419	Center Rail Cross Support 21" (533mm)
	240418	Center Rail Cross Support 24" (610mm)
23	200223	Outboard Bearing Retaining Sleeve



Item 12: Spindle Assembly

Width	With Bearings (21-33)	Without Bearings
18" (457mm)	303118	303218
21" (533mm)	303121	303221
24" (610mm)	303124	303224

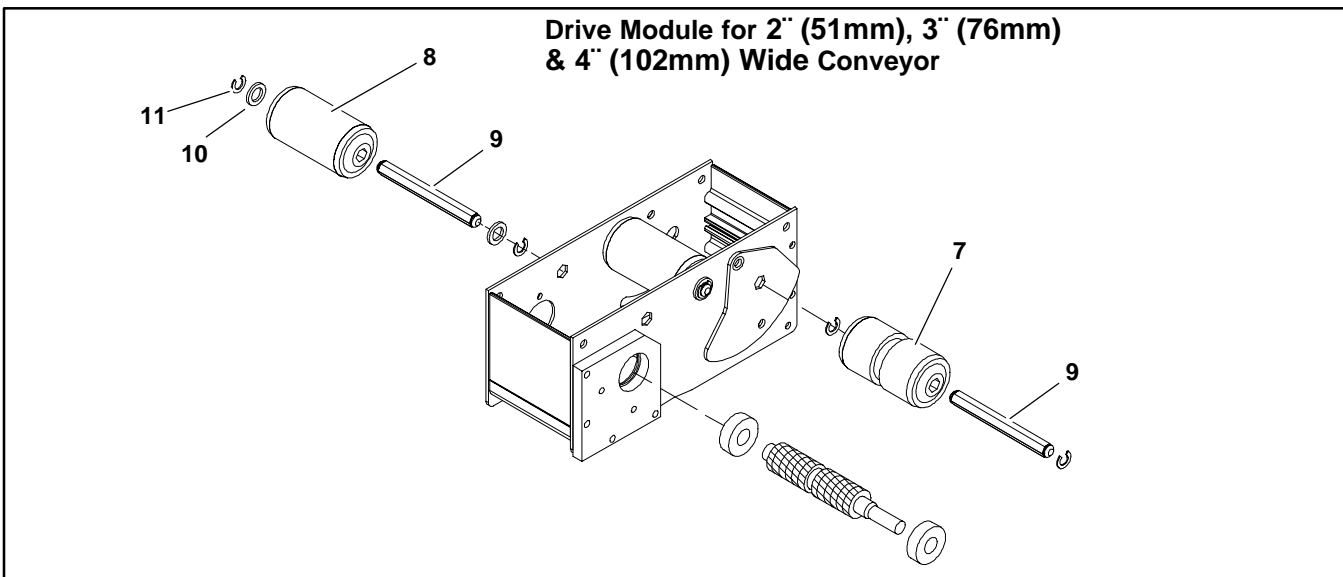
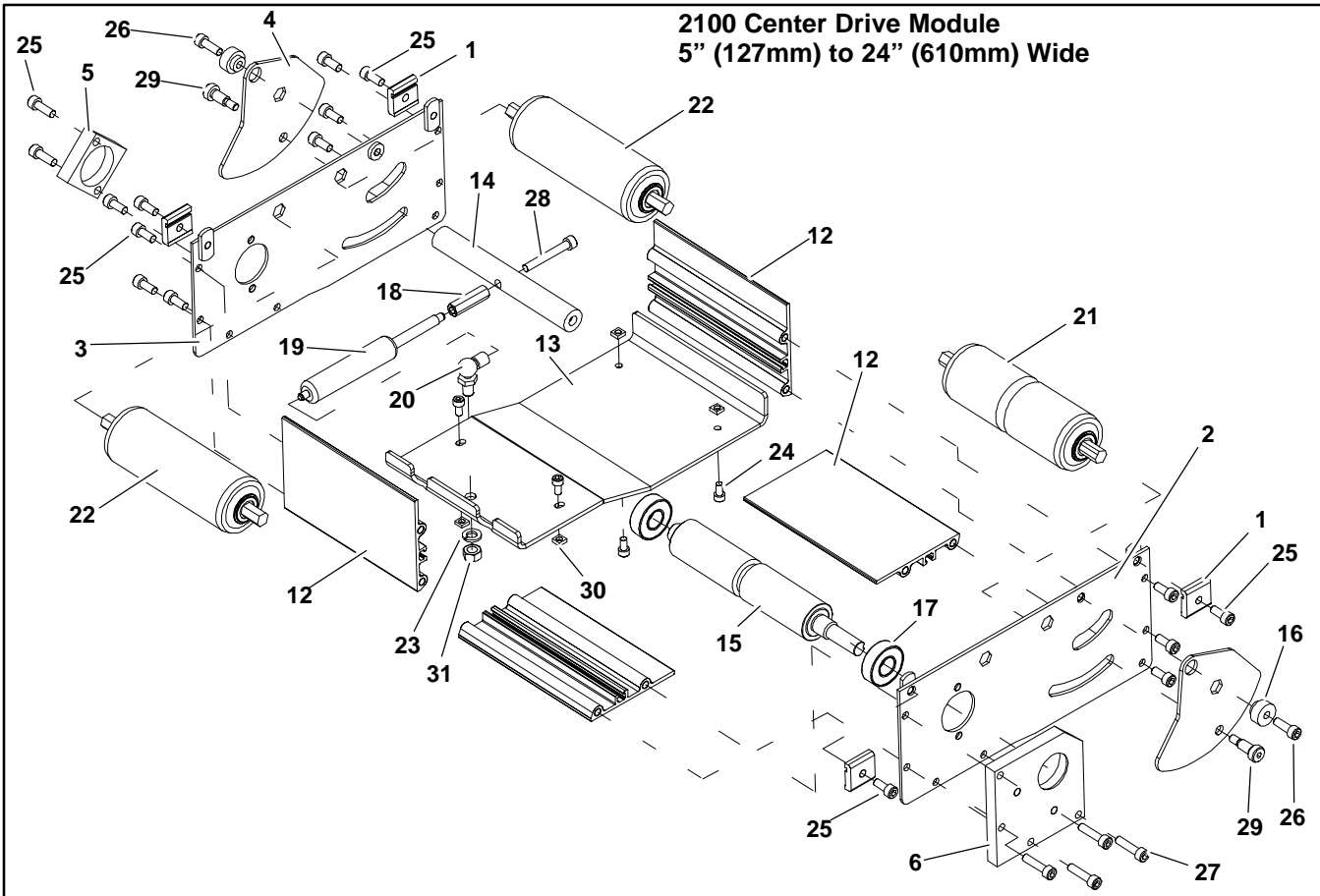
Item 17: Bed Plate		
Length	Part Number	
2' (610mm)	2405WW-01904	
3' (914mm)	2405WW-03104	
4' (1219mm)	2405WW-04304	
5' (1524mm)	2405WW-05504	
6' (1829mm)	2405WW-06704	
7' (2134mm)	2405WW-07904	
8' (2438mm)	2405WW-09104	
9' (2743mm)	2405WW-10304	
10' (3048mm)	2405WW-11504	
11' (3353mm)	2405WW-12704	
12' (3658mm)	2405WW-13904	
13' (3962mm)	2405WW-07196	2405WW-07904
14' (4267mm)	2405WW-07196	2405WW-09104
15' (4572mm)	2405WW-07196	2405WW-10304
16' (4877mm)	2405WW-07196	2405WW-11504
17' (5182mm)	2405WW-07196	2405WW-12704
18' (5486mm)	2405WW-07196	2405WW-13904
19' (5791mm)	2405WW-07908	2405WW-14396
20' (6096mm)	2405WW-09108	2405WW-14396
21' (6401mm)	2405WW-10308	2405WW-14396
22' (6706mm)	2405WW-11508	2405WW-14396
23' (7010mm)	2405WW-12708	2405WW-14396
24' (7315mm)	2405WW-13908	2405WW-14396
WW = Conveyor Width reference: 18, 21, 24		

Item 19: Side Rail RH 8–24" (203–610mm) Wide		
Length	Part Number	
2' (610mm)	240412-01908	
3' (914mm)	240412-03108	
4' (1219mm)	240412-04308	
5' (1524mm)	240412-05508	
6' (1829mm)	240412-06708	
7' (2134mm)	240412-07908	
8' (2438mm)	240412-09108	
9' (2743mm)	240412-10308	
10' (3048mm)	240412-11508	
11' (3353mm)	240412-12708	
12' (3658mm)	240412-13908	
13' (3962mm)	240412-07200	240412-07908
14' (4267mm)	240412-07200	240412-09108
15' (4572mm)	240412-07200	240412-10308
16' (4877mm)	240412-07200	240412-11508
17' (5182mm)	240412-07200	240412-12708
18' (5486mm)	240412-07200	240412-13908
19' (5791mm)	240412-07908	240412-14400
20' (6096mm)	240412-09108	240412-14400
21' (6401mm)	240412-10308	240412-14400
22' (6706mm)	240412-11508	240412-14400
23' (7010mm)	240412-12708	240412-14400
24' (7315mm)	240412-13908	240412-14400

Item 20: Side Rail LH 8–24" (203–610mm) Wide		
Length	Part Number	
2' (610mm)	240413-01908	
3' (914mm)	240413-03108	
4' (1219mm)	240413-04308	
5' (1524mm)	240413-05508	
6' (1829mm)	240413-06708	
7' (2134mm)	240413-07908	
8' (2438mm)	240413-09108	
9' (2743mm)	240413-10308	
10' (3048mm)	240413-11508	
11' (3353mm)	240413-12708	
12' (3658mm)	240413-13908	
13' (3962mm)	240413-07200	240413-07908
14' (4267mm)	240413-07200	240413-09108
15' (4572mm)	240413-07200	240413-10308
16' (4877mm)	240413-07200	240413-11508
17' (5182mm)	240413-07200	240413-12708
18' (5486mm)	240413-07200	240413-13908
19' (5791mm)	240413-07908	240413-14400
20' (6096mm)	240413-09108	240413-14400
21' (6401mm)	240413-10308	240413-14400
22' (6706mm)	240413-11508	240413-14400
23' (7010mm)	240413-12708	240413-14400
24' (7315mm)	240413-13908	240413-14400

Item 21: Center Rail 8–12" (203–305mm) Wide		
Length	Part Number	
2' (610mm)	240414-00998	
3' (914mm)	240414-02198	
4' (1219mm)	240414-03398	
5' (1524mm)	240414-04498	
6' (1829mm)	240414-05798	
7' (2134mm)	240414-06998	
8' (2438mm)	240414-08198	
9' (2743mm)	240414-09398	
10' (3048mm)	240414-10598	
11' (3353mm)	240414-11798	
12' (3658mm)	240414-12998	
13' (3962mm)	240414-06700	240414-06998
14' (4267mm)	240414-06700	240414-08198
15' (4572mm)	240414-06700	240414-09398
16' (4877mm)	240414-06700	240414-10598
17' (5182mm)	240414-06700	240414-11798
18' (5486mm)	240414-06700	240414-12998
19' (5791mm)	240414-06998	240414-13900
20' (6096mm)	240414-08198	240414-13900
21' (6401mm)	240414-09398	240414-13900
22' (6706mm)	240414-10598	240414-13900
23' (7010mm)	240414-11798	240414-13900
24' (7315mm)	240414-12998	240414-13900

Service Parts



Item	Part Number	Description
1	204566	Module Mounting Clip
2	202633M	Side Plate LH
3	202634M	Side Plate RH
4	463026	Pivot Tension Plate
5	463028M	Bearing Mounting Block
6	463029M	Bearing-Drive Mounting Plate

7	463044	Roller 1.9" .44hex Grv 2" (51mm)
	463045	Roller 1.9" .44hex Grv 3" (76mm)
	807-1001	Roller 1.9" .44hex Grv 4" (102mm)
8	463046	Roller 1.9" .44hex SS Flat 2" (51mm)
	807-1007	Roller 1.9" .44hex SS Flat 3" (76mm)
	807-1008	Roller 1.9" .44hex SS Flat 4" (102mm)

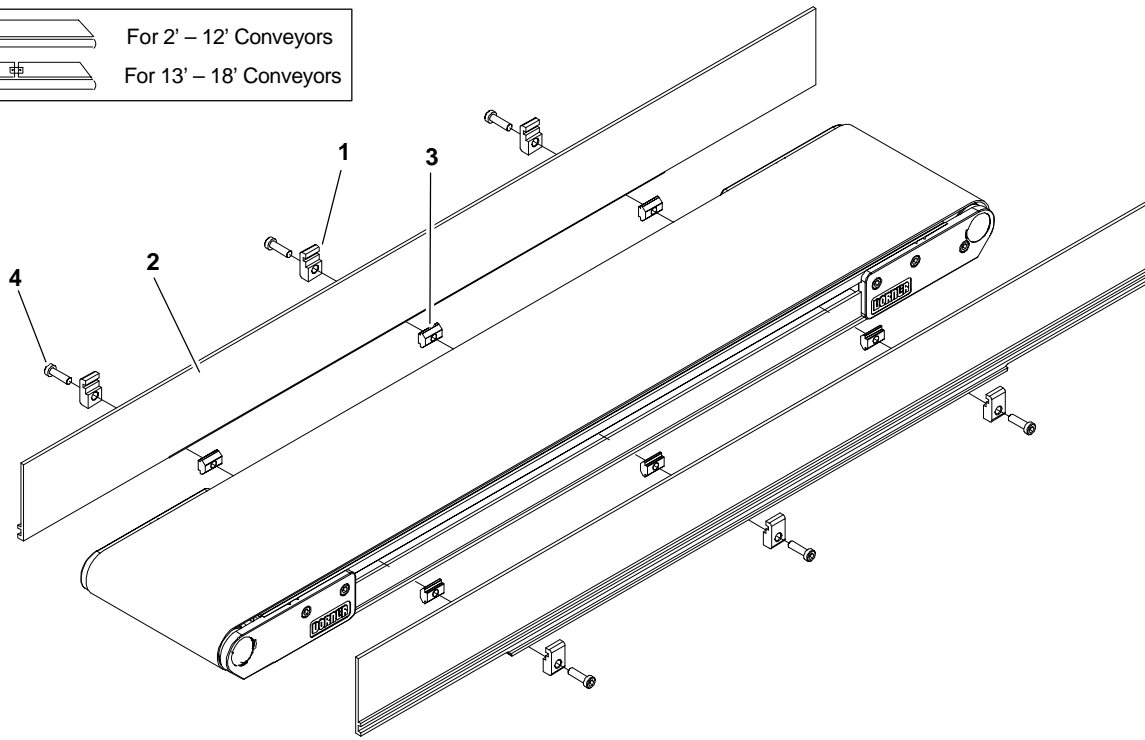
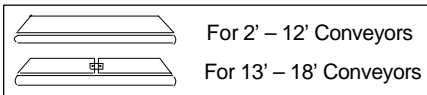
Service Parts

9	915-215	E-Ring Clip (0.44 diameter)
10	801-115	Washer
11	463402	Pulley Shaft 2" (51mm)
	463403	Pulley Shaft 3" (76mm)
	463404	Pulley Shaft 4" (102mm)
12	463802	Center Drive Rail 2" (51mm)
	463803	Center Drive Rail 3" (76mm)
	463804	Center Drive Rail 4" (102mm)
	463805	Center Drive Rail 5" (127mm)
	463806	Center Drive Rail 6" (152mm)
	463808	Center Drive Rail 8" (203mm)
	463810	Center Drive Rail 10" (254mm)
	463812	Center Drive Rail 12" (305mm)
	463818	Center Drive Rail 18" (457mm)
	463821	Center Drive Rail 21" (533mm)
	463824	Center Drive Rail 24" (610mm)
13	463202M	Center Dr Bottom Cover 2" (51mm)
	463203M	Center Dr Bottom Cover 3" (76mm)
	463204M	Center Dr Bottom Cover 4" (102mm)
	463205M	Center Dr Bottom Cover 5" (127mm)
	463206M	Center Dr Bottom Cover 6" (152mm)
	463208M	Center Dr Bottom Cover 8" (203mm)
	463210M	Center Dr Bottom Cover 10" (254mm)
	463212M	Center Dr Bottom Cover 12" (305mm)
	463218M	Center Dr Bottom Cover 18" (457mm)
	463205M 463208M 463208M	Center Dr Bottom Cover 21" (533mm)
	463212M 463212M	Center Dr Bottom Cover 24" (610mm)
14	463302M	Center Dr Tensioning Rod 2" (51mm)
	463303M	Center Dr Tensioning Rod 3" (76mm)
	463304M	Center Dr Tensioning Rod 4" (102mm)
	463305M	Center Dr Tensioning Rod 5" (127mm)
	463306M	Center Dr Tensioning Rod 6" (152mm)
	463308M	Center Dr Tensioning Rod 8" (203mm)
	463310M	Cntr Dr Tensioning Rod 10" (254mm)
	463312M	Cntr Dr Tensioning Rod 12" (305mm)
	463318M	Cntr Dr Tensioning Rod 18" (457mm)
	463321M	Cntr Dr Tensioning Rod 21" (533mm)
	463324M	Cntr Dr Tensioning Rod 24" (610mm)
15	463702M	Center Drive Spindle 2" (51mm)
	463703M	Center Drive Spindle 3" (76mm)
	463704M	Center Drive Spindle 4" (102mm)
	463705M	Center Drive Spindle 5" (127mm)

	463706M	Center Drive Spindle 6" (152mm)
	463708M	Center Drive Spindle 8" (203mm)
	463710M	Center Drive Spindle 10" (254mm)
	463712M	Center Drive Spindle 12" (305mm)
	463718M	Center Drive Spindle 18" (457mm)
	463721M	Center Drive Spindle 21" (533mm)
	463724M	Center Drive Spindle 24" (610mm)
16	801-117	Nylon Bushing
17	802-124	Ball Bearing
18	807-983	Hex Standoff 13mm x 35mm LG M6
19	807-1040	Gas Spring 8mm DIA x 1.97 ST 2" (51mm) Wide
	807-986	Gas Spring 8mm DIA x 1.97 ST 3" (76mm) Wide
	807-985	Gas Spring 8mm DIA x 1.97 ST 4-6" (102-152mm) Wide
	807-984	Gas Spring 8mm DIA x 1.97 ST 8-12" (203-305mm) Wide
	807-985 807-985	Gas Spring 8mm DIA x 1.97 ST 18-24" (457-610mm) Wide
20	807-987	Steel Ball Joint M6 x M8
21	807-1002	Roller 1.9" .44 Hex Grv 5" (127mm)
	807-1003	Roller 1.9" .44 Hex Grv 6" (152mm)
	807-1004	Roller 1.9" .44 Hex Grv 8" (203mm)
	807-1005	Roller 1.9" .44 Hex Grv 10" (203mm)
	807-1006	Roller 1.9" .44 Hex Grv 12" (305mm)
	807-1091	Roller 1.9" .44 Hex Grv 18" (457mm)
	807-1092	Roller 1.9" .44 Hex Grv 21" (533mm)
	807-1093	Roller 1.9" .44 Hex Grv 24" (610mm)
22	807-1009	Roller 1.9" .44 Hex Flat 5" (51mm)
	807-1010	Roller 1.9" .44 Hex Flat 6" (152mm)
	807-1011	Roller 1.9" .44 Hex Flat 8" (203mm)
	807-1012	Roller 1.9" .44 Hex Flat 10" (203mm)
	807-1013	Roller 1.9" .44 Hex Flat 12" (305mm)
	807-1088	Roller 1.9" .44 Hex Flat 18" (457mm)
	807-1089	Roller 1.9" .44 Hex Flat 21" (533mm)
	807-1090	Roller 1.9" .44 Hex Flat 24" (610mm)
23	911-120	Spring Lock Washer
24	920510M	Socket Head Screw M5 x 10mm
25	920614M	Socket Head Screw M6 x 14mm
26	920618M	Socket Head Screw M6 x 18mm
27	920625M	Socket Head Screw M6 x 25mm
28	920645M	Socket Head Screw M6 x 45mm
29	940812M	SHLD Screw 8mm DIA x 12mm
30	990503M	hex Nut, Full M5 - .8
31	990801M	Hex Nut, Full M8 - 1.25

Service Parts

-04 3" (76mm) Aluminum Side

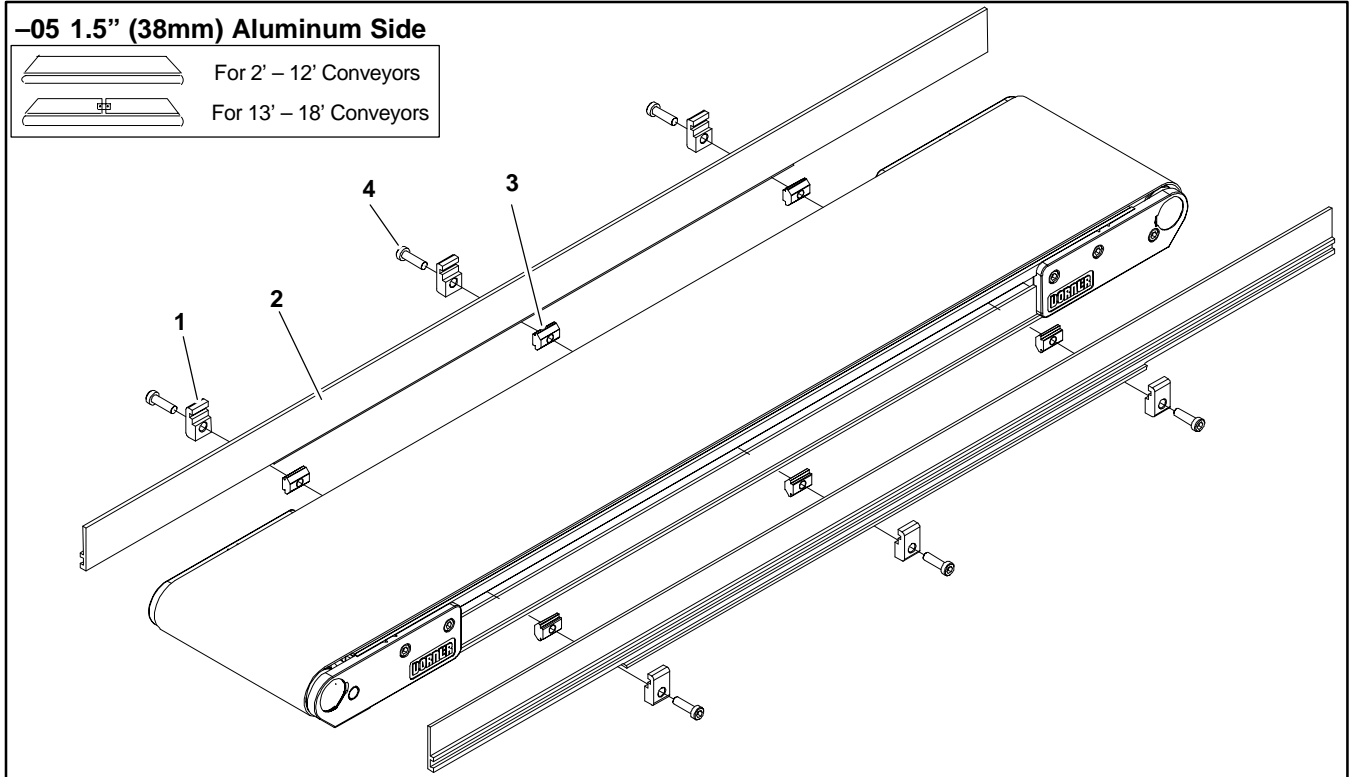


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 3" (76mm) HS
3	200695P	Single Drop-in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide 3" (76mm) HS

Length		End Guide	End Guide
2' (610mm)	Left Hand	280403-02400	N/A
	Right Hand	280403-02400	N/A
3' (914mm)	Left Hand	280403-03600	N/A
	Right Hand	280403-03600	N/A
4' (1219mm)	Left Hand	280403-04800	N/A
	Right Hand	280403-04800	N/A
5' (1524mm)	Left Hand	280403-06000	N/A
	Right Hand	280403-06000	N/A
6' (1829mm)	Left Hand	280403-07200	N/A
	Right Hand	280403-07200	N/A
7' (2134mm)	Left Hand	280403-08400	N/A
	Right Hand	280403-08400	N/A
8' (2438mm)	Left Hand	280403-09600	N/A
	Right Hand	280403-09600	N/A
9' (2743mm)	Left Hand	280403-10800	N/A
	Right Hand	280403-10800	N/A
10' (3048mm)	Left Hand	280403-12000	N/A
	Right Hand	280403-12000	N/A
11' (3353mm)	Left Hand	280403-13200	N/A
	Right Hand	280403-13200	N/A

12' (3658mm)	Left Hand	280403-14400	N/A
	Right Hand	280403-14400	N/A
13' (3962mm)	Left Hand	280401-07500	280401-08100
	Right Hand	280402-07500	280402-08100
14' (4267mm)	Left Hand	280401-07500	280401-09300
	Right Hand	280402-07500	280402-09300
15' (4572mm)	Left hand	280401-07500	280401-10500
	Right Hand	280402-07500	280402-10500
16' (4877mm)	Left Hand	280401-07500	280401-11700
	Right Hand	280402-07500	280402-11700
17' (5182mm)	Left Hand	280401-07500	280401-12900
	Right Hand	280402-07500	280402-12900
18' (5486mm)	Left Hand	280401-07500	280401-14100
	Right Hand	280402-07500	280402-14100
19' (5791mm)	Left Hand	280401-08100	280401-14700
	Right Hand	280402-08100	280402-14700
20' (6096mm)	Left Hand	280401-09300	280401-14700
	Right Hand	280402-09300	280402-14700
21' (6401mm)	Left Hand	280401-10500	280401-14700
	Right Hand	280402-10500	280402-14700
22' (6706mm)	Left Hand	280401-11700	280401-14700
	Right Hand	280402-11700	280402-14700
23' (7010mm)	Left Hand	280401-12900	280401-14700
	Right Hand	280402-12900	280402-14700
24' (7315mm)	Left Hand	280401-14100	280401-14700
	Right Hand	280402-14100	280402-14700

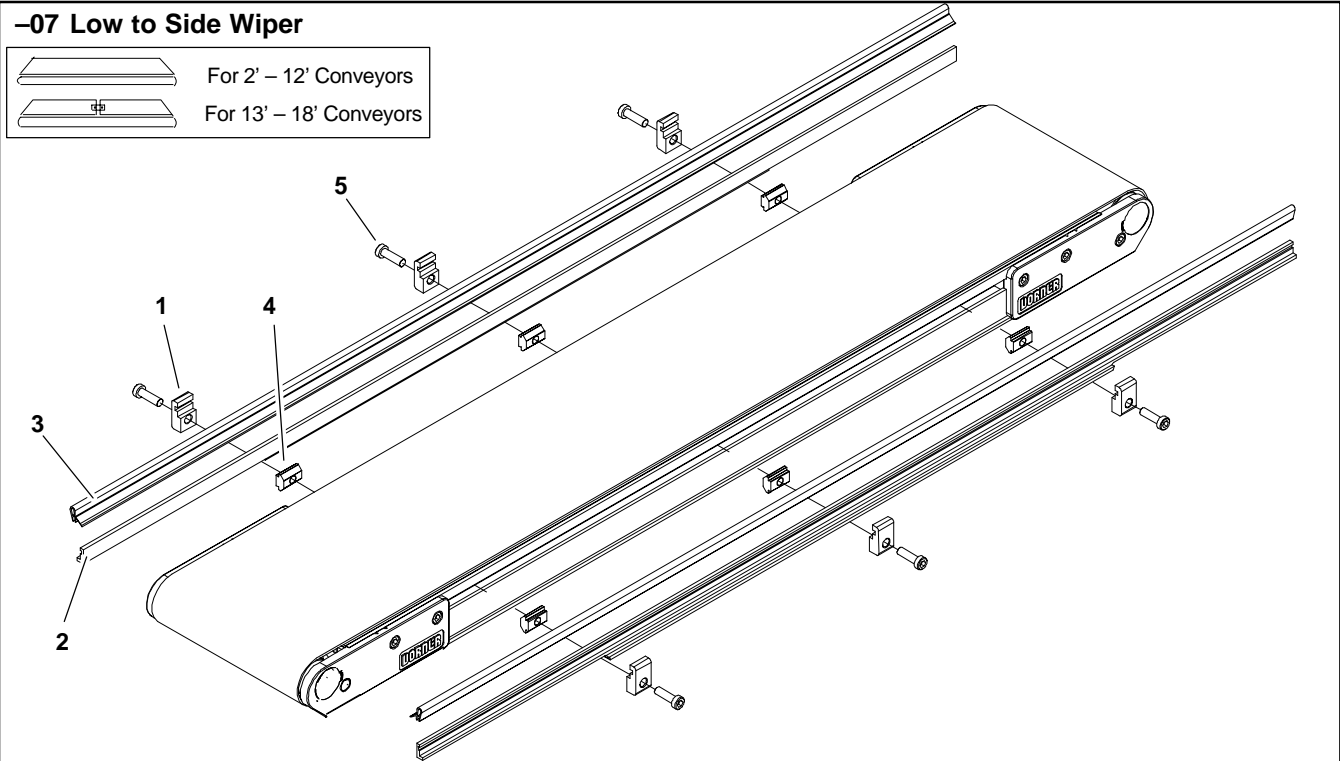


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide .5" (13mm) HS
3	639971M	Single Drop-in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide .5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280503-02400	N/A
	Right Hand	280503-02400	N/A
3' (914mm)	Left Hand	280503-03600	N/A
	Right Hand	280503-03600	N/A
4' (1219mm)	Left Hand	280503-04800	N/A
	Right Hand	280503-04800	N/A
5' (1524mm)	Left Hand	280503-06000	N/A
	Right Hand	280503-06000	N/A
6' (1829mm)	Left Hand	280503-07200	N/A
	Right Hand	280503-07200	N/A
7' (2134mm)	Left Hand	280503-08400	N/A
	Right Hand	280503-08400	N/A
8' (2438mm)	Left Hand	280503-09600	N/A
	Right Hand	280503-09600	N/A
9' (2743mm)	Left Hand	280503-10800	N/A
	Right Hand	280503-10800	N/A
10' (3048mm)	Left Hand	280503-12000	N/A
	Right Hand	280503-12000	N/A
11' (3353mm)	Left Hand	280503-13200	N/A

	Right Hand	280503-13200	N/A
12' (3658mm)	Left Hand	280503-14400	N/A
	Right Hand	280503-14400	N/A
13' (3962mm)	Left Hand	280501-07500	280501-08100
	Right Hand	280502-07500	280502-08100
14' (4267mm)	Left Hand	280501-07500	280501-09300
	Right Hand	280502-07500	280502-09300
15' (4572mm)	Left hand	280501-07500	280501-10500
	Right Hand	280502-07500	280502-10500
16' (4877mm)	Left Hand	280501-07500	280501-11700
	Right Hand	280502-07500	280502-11700
17' (5182mm)	Left Hand	280501-07500	280501-12900
	Right Hand	280502-07500	280502-12900
18' (5486mm)	Left Hand	280501-07500	280501-14100
	Right Hand	280502-07500	280502-14100
19' (5791mm)	Left Hand	280501-08100	280501-14700
	Right Hand	280502-08100	280502-14700
20' (6096mm)	Left Hand	280501-09300	280501-14700
	Right Hand	280502-09300	280502-14700
21' (6401mm)	Left Hand	280501-10500	280501-14700
	Right Hand	280502-10500	280502-14700
22' (6706mm)	Left Hand	280501-11700	280501-14700
	Right Hand	280502-11700	280502-14700
23' (7010mm)	Left Hand	280501-12900	280501-14700
	Right Hand	280502-12900	280502-14700
24' (7315mm)	Left Hand	280501-14100	280501-14700
	Right Hand	280502-14100	280502-14700

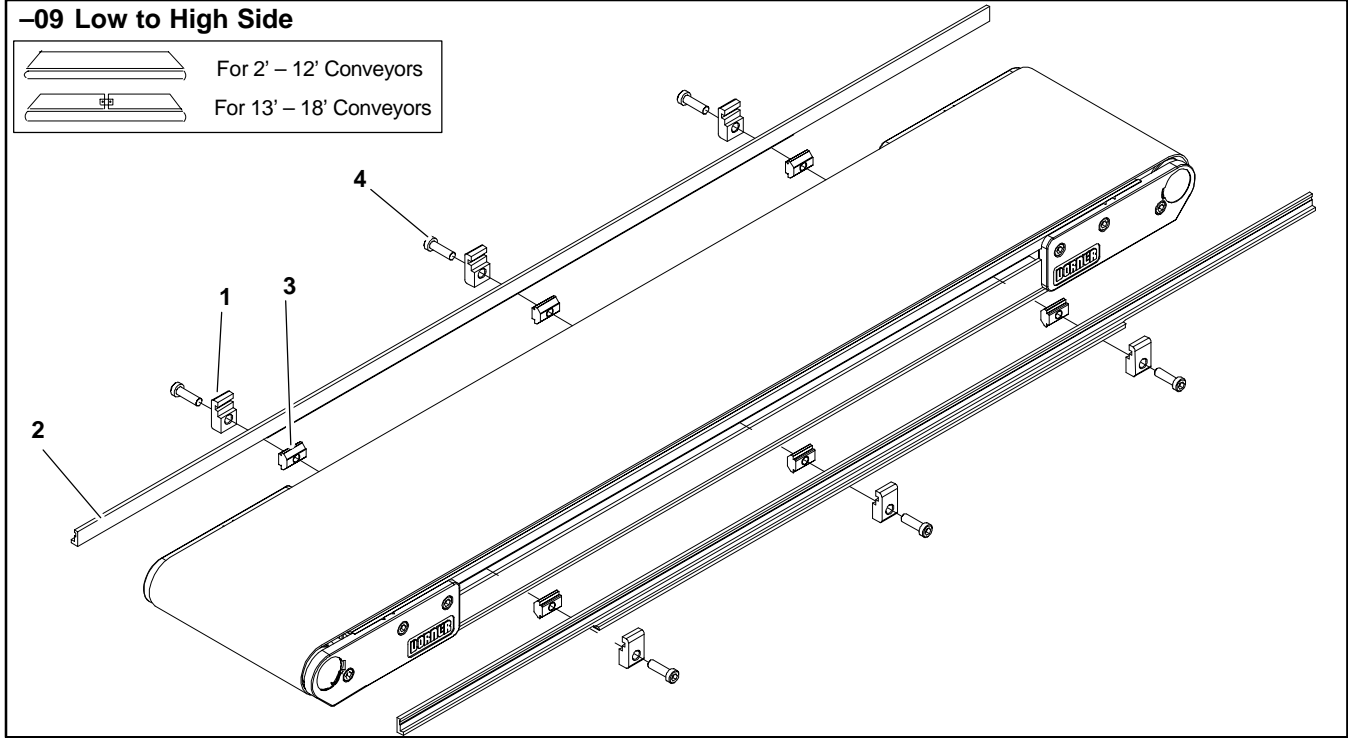
Service Parts



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide .5" (13mm) HS
3	41-00-24	Side Wiper Nylatron (per foot)
4	639971M	Single Drop-in Tee Bar
5	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide .5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280903-02400	N/A
	Right Hand	280903-02400	N/A
3' (914mm)	Left Hand	280903-03600	N/A
	Right Hand	280903-03600	N/A
4' (1219mm)	Left Hand	280903-04800	N/A
	Right Hand	280903-04800	N/A
5' (1524mm)	Left Hand	280903-06000	N/A
	Right Hand	280903-06000	N/A
6' (1829mm)	Left Hand	280903-07200	N/A
	Right Hand	280903-07200	N/A
7' (2134mm)	Left Hand	280903-08400	N/A
	Right Hand	280903-08400	N/A
8' (2438mm)	Left Hand	280903-09600	N/A
	Right Hand	280903-09600	N/A
9' (2743mm)	Left Hand	280903-10800	N/A
	Right Hand	280903-10800	N/A
10' (3048mm)	Left Hand	280903-12000	N/A
	Right Hand	280903-12000	N/A
11' (3353mm)	Left Hand	280903-13200	N/A
	Right Hand	280903-13200	N/A

12' (3658mm)	Left Hand	280903-14400	N/A
	Right Hand	280903-14400	N/A
13' (3962mm)	Left Hand	280901-07500	280901-08100
	Right Hand	280902-07500	280902-08100
14' (4267mm)	Left Hand	280901-07500	280901-09300
	Right Hand	280902-07500	280902-09300
15' (4572mm)	Left hand	280901-07500	280901-10500
	Right Hand	280902-07500	280902-10500
16' (4877mm)	Left Hand	280901-07500	280901-11700
	Right Hand	280902-07500	280902-11700
17' (5182mm)	Left Hand	280901-07500	280901-12900
	Right Hand	280902-07500	280902-12900
18' (5486mm)	Left Hand	280901-07500	280901-14100
	Right Hand	280902-07500	280902-14100
19' (5791mm)	Left Hand	280901-08100	280901-14700
	Right Hand	280902-08100	280902-14700
20' (6096mm)	Left Hand	280901-09300	280901-14700
	Right Hand	280902-09300	280902-14700
21' (6401mm)	Left Hand	280901-10500	280901-14700
	Right Hand	280902-10500	280902-14700
22' (6706mm)	Left Hand	280901-11700	280901-14700
	Right Hand	280902-11700	280902-14700
23' (7010mm)	Left Hand	280901-12900	280901-14700
	Right Hand	280902-12900	280902-14700
24' (7315mm)	Left Hand	280901-14100	280901-14700
	Right Hand	280902-14100	280902-14700



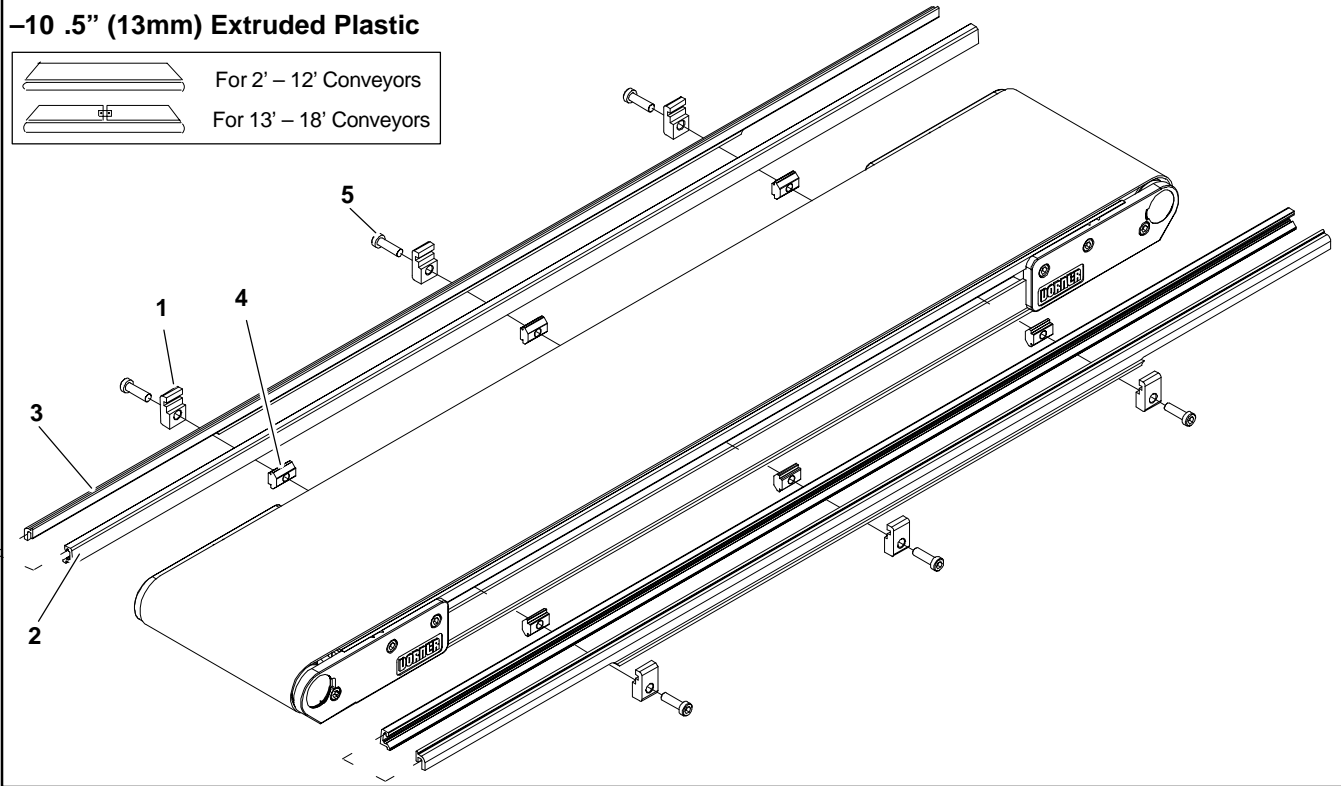
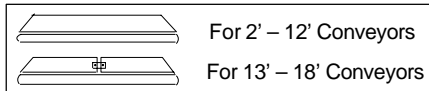
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide .5" (13mm) HS
3	639971M	Single Drop-in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide .5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280903-02400	N/A
	Right Hand	280903-02400	N/A
3' (914mm)	Left Hand	280903-03600	N/A
	Right Hand	280903-03600	N/A
4' (1219mm)	Left Hand	280903-04800	N/A
	Right Hand	280903-04800	N/A
5' (1524mm)	Left Hand	280903-06000	N/A
	Right Hand	280903-06000	N/A
6' (1829mm)	Left Hand	280903-07200	N/A
	Right Hand	280903-07200	N/A
7' (2134mm)	Left Hand	280903-08400	N/A
	Right Hand	280903-08400	N/A
8' (2438mm)	Left Hand	280903-09600	N/A
	Right Hand	280903-09600	N/A
9' (2743mm)	Left Hand	280903-10800	N/A
	Right Hand	280903-10800	N/A
10' (3048mm)	Left Hand	280903-12000	N/A
	Right Hand	280903-12000	N/A
11' (3353mm)	Left Hand	280903-13200	N/A
	Right Hand	280903-13200	N/A

12' (3658mm)	Left Hand	280903-14400	N/A
	Right Hand	280903-14400	N/A
13' (3962mm)	Left Hand	280901-07500	280901-08100
	Right Hand	280902-07500	280902-08100
14' (4267mm)	Left Hand	280901-07500	280901-09300
	Right Hand	280902-07500	280902-09300
15' (4572mm)	Left hand	280901-07500	280901-10500
	Right Hand	280902-07500	280902-10500
16' (4877mm)	Left Hand	280901-07500	280901-11700
	Right Hand	280902-07500	280902-11700
17' (5182mm)	Left Hand	280901-07500	280901-12900
	Right Hand	280902-07500	280902-12900
18' (5486mm)	Left Hand	280901-07500	280901-14100
	Right Hand	280902-07500	280902-14100
19' (5791mm)	Left Hand	280901-08100	280901-14700
	Right Hand	280902-08100	280902-14700
20' (6096mm)	Left Hand	280901-09300	280901-14700
	Right Hand	280902-09300	280902-14700
21' (6401mm)	Left Hand	280901-10500	280901-14700
	Right Hand	280902-10500	280902-14700
22' (6706mm)	Left Hand	280901-11700	280901-14700
	Right Hand	280902-11700	280902-14700
23' (7010mm)	Left Hand	280901-12900	280901-14700
	Right Hand	280902-12900	280902-14700
24' (7315mm)	Left Hand	280901-14100	280901-14700
	Right Hand	280902-14100	280902-14700

Service Parts

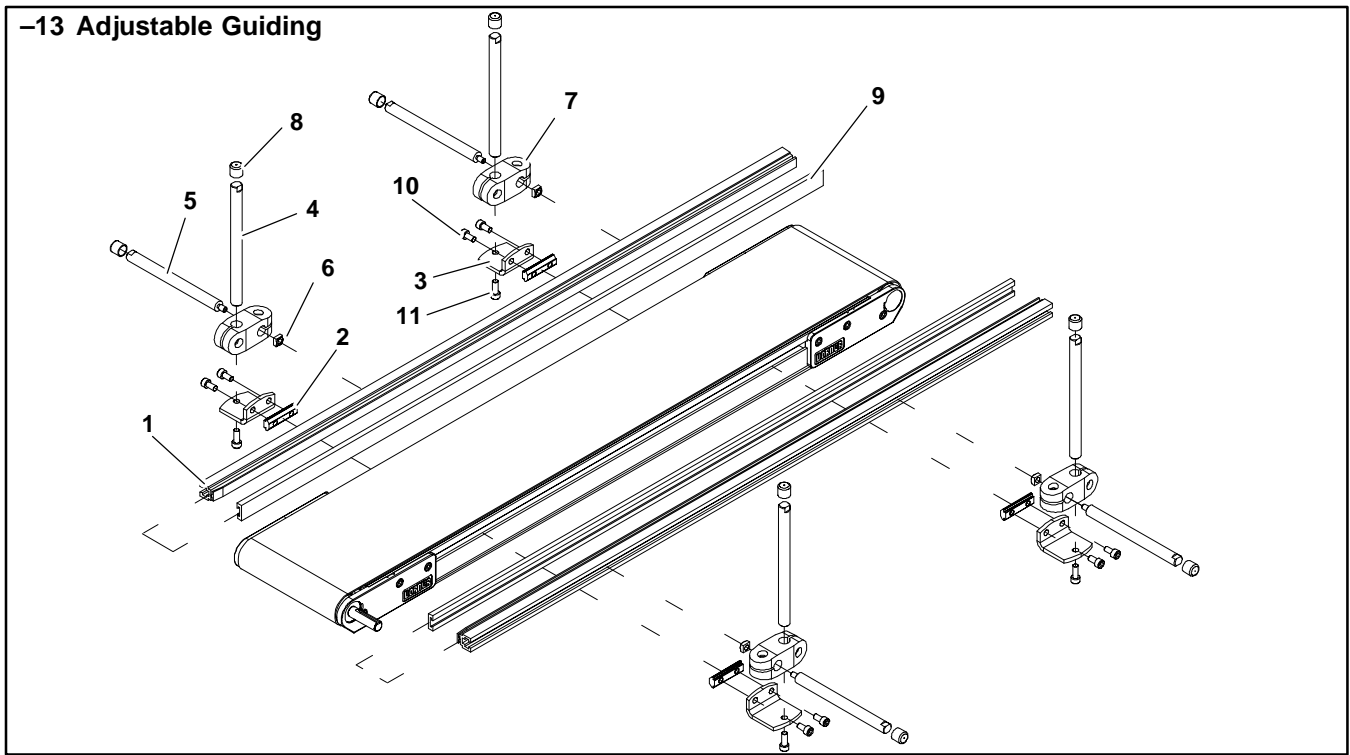
-10 .5" (13mm) Extruded Plastic



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	200054P	Snap-On Guide (per foot)
3	See Chart Below	2200 Guide
4	639971M	Single Drop-in Tee Bar
5	920694M	Socket Head Screw M6 x 20mm

Item 3: 2200 Guide			
Length		End Guide	End Guide
2' (610mm)	Left Hand	281003-02400	N/A
	Right Hand	281003-02400	N/A
3' (914mm)	Left Hand	281003-03600	N/A
	Right Hand	281003-03600	N/A
4' (1219mm)	Left Hand	281003-04800	N/A
	Right Hand	281003-04800	N/A
5' (1524mm)	Left Hand	281003-06000	N/A
	Right Hand	281003-06000	N/A
6' (1829mm)	Left Hand	281003-07200	N/A
	Right Hand	281003-07200	N/A
7' (2134mm)	Left Hand	281003-08400	N/A
	Right Hand	281003-08400	N/A
8' (2438mm)	Left Hand	281003-09600	N/A
	Right Hand	281003-09600	N/A
9' (2743mm)	Left Hand	281003-10800	N/A
	Right Hand	281003-10800	N/A
10' (3048mm)	Left Hand	281003-12000	N/A
	Right Hand	281003-12000	N/A
11' (3353mm)	Left Hand	281003-13200	N/A
	Right Hand	281003-13200	N/A

12' (3658mm)	Left Hand	281003-14400	N/A
	Right Hand	281003-14400	N/A
13' (3962mm)	Left Hand	281001-07500	281001-08100
	Right Hand	281002-07500	281002-08100
14' (4267mm)	Left Hand	281001-07500	281001-09300
	Right Hand	281002-07500	281002-09300
15' (4572mm)	Left hand	281001-07500	281001-10500
	Right Hand	281002-07500	281002-10500
16' (4877mm)	Left Hand	281001-07500	281001-11700
	Right Hand	281002-07500	281002-11700
17' (5182mm)	Left Hand	281001-07500	281001-12900
	Right Hand	281002-07500	281002-12900
18' (5486mm)	Left Hand	281001-07500	281001-14100
	Right Hand	281002-07500	281002-14100
19' (5791mm)	Left Hand	281001-08100	281001-14700
	Right Hand	281002-08100	281002-14700
20' (6096mm)	Left Hand	281001-09300	281001-14700
	Right Hand	281002-09300	281002-14700
21' (6401mm)	Left Hand	281001-10500	281001-14700
	Right Hand	281002-10500	281002-14700
22' (6706mm)	Left Hand	281001-11700	281001-14700
	Right Hand	281002-11700	281002-14700
23' (7010mm)	Left Hand	281001-12900	281001-14700
	Right Hand	281002-12900	281002-14700
24' (7315mm)	Left Hand	281001-14100	281001-14700
	Right Hand	281002-14100	281002-14700

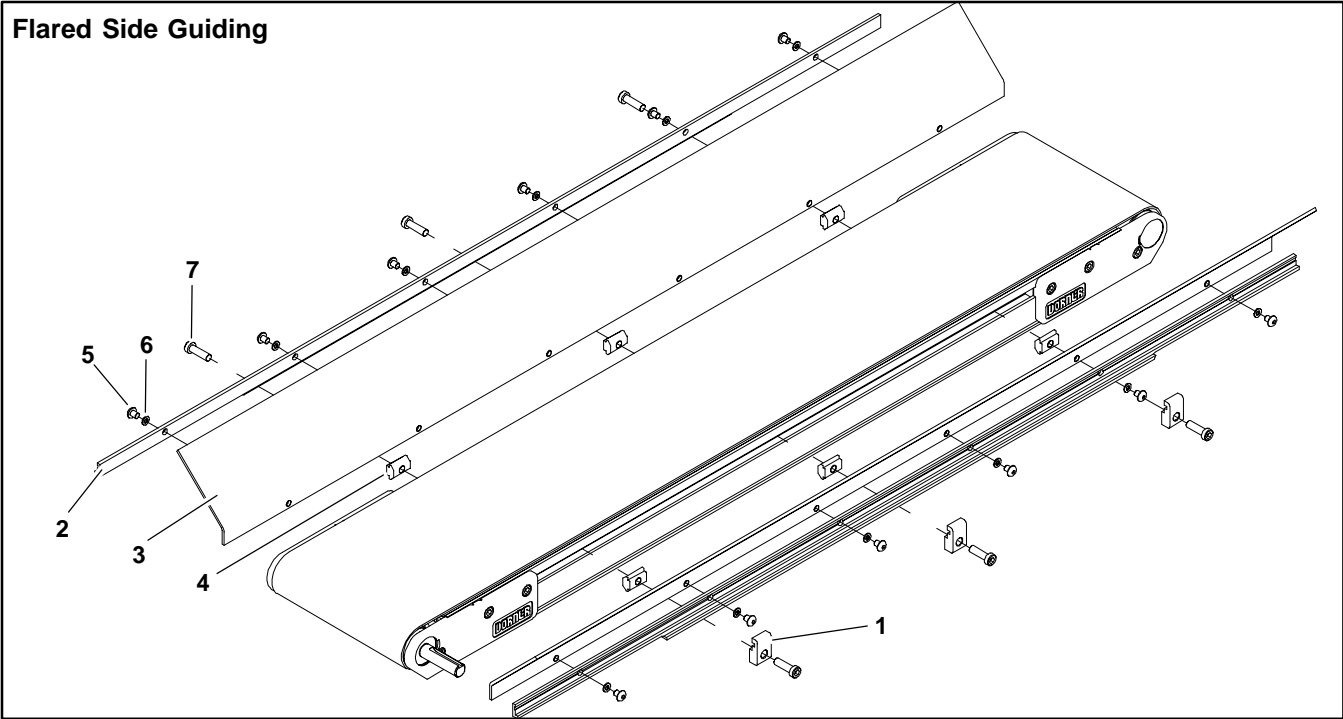


Item	Part Number	Description
1	202983	Aluminum Profile Guide 2' (610mm)
	202984	Aluminum Profile Guide 3' (914mm)
	202985	Aluminum Profile Guide 4' (1219mm)
	202986	Aluminum Profile Guide 5' (1524mm)
	202987	Aluminum Profile Guide 6' (1829mm)
	202988	Aluminum Profile Guide 7' (2134mm)
	202989	Aluminum Profile Guide 8' (2438mm)
	202990	Aluminum Profile Guide 9' (2743mm)
	202991	Aluminum Profile Guide 10' (3048mm)
	202992	Aluminum Profile Guide 11' (3353mm)
	202993	Aluminum Profile Guide 12' (3658mm)
	202994	Aluminum Profile Guide 13' (3962mm)

2	200830M	Drop-In Tee Bar
3	202004	Mounting Bracket
4	202027M	Guide Mounting Shaft Vertical
5	202028M	Guide Moutning Shaft Horizontal
6	674175MP	Square Nut
7	807-652	Cross Block
8	807-948	Vinyl Shaft Cap
9	614068P	Flat Extruded Guide (per foot)
10	920612M	Socket Head Screw M6 x 12mm
11	920616M	Socket Head Screw M6 x 16mm

Service Parts

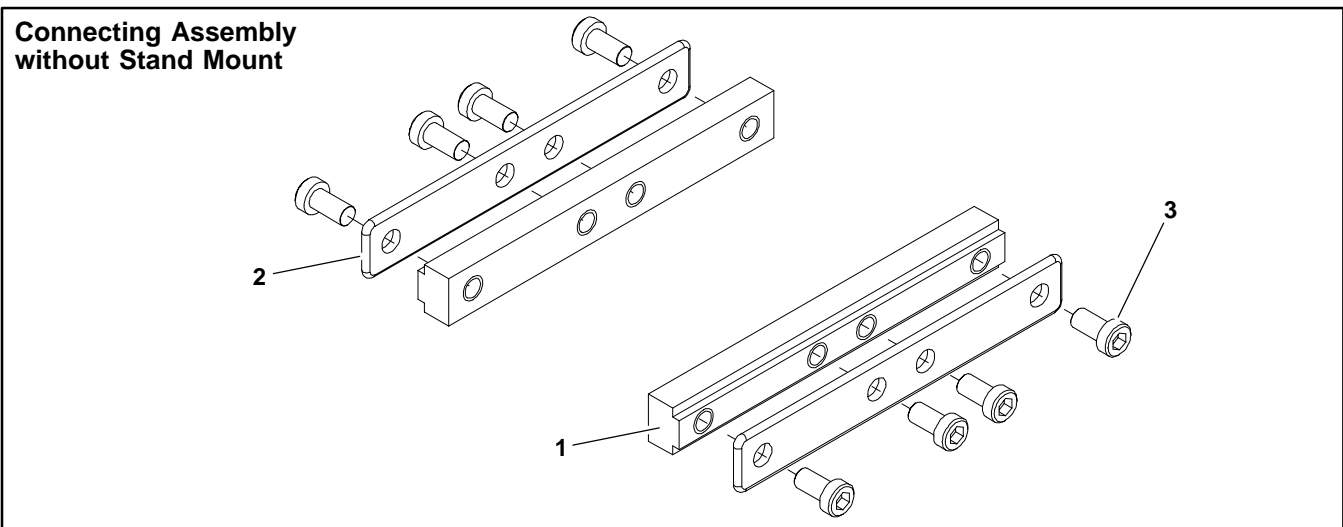
Flared Side Guiding



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	202212	Side-Flare Mounting Guide 2' (610mm)
	202213	Side-Flare Mounting Guide 3' (914mm)
	202214	Side-Flare Mounting Guide 4' (1219mm)
	202215	Side-Flare Mounting Guide 5' (1524mm)
	202216	Side-Flare Mounting Guide 6' (1829mm)

3	202522M	Flared Guide 45° 2' (610mm)
	202523M	Flared Guide 45° 3' (914mm)
	202523M	Flared Guide 45° 4' (1219mm)
	202523M	Flared Guide 45° 5' (1524mm)
	202523M	Flared Guide 45° 6' (1829mm)
4	639971	Drop-In Tee Bar
5	910506M	Button Head Screw M5 x 6mm
6	911-512	Washer
7	920694M	Cap Low-Head Screw M6 x 20mm

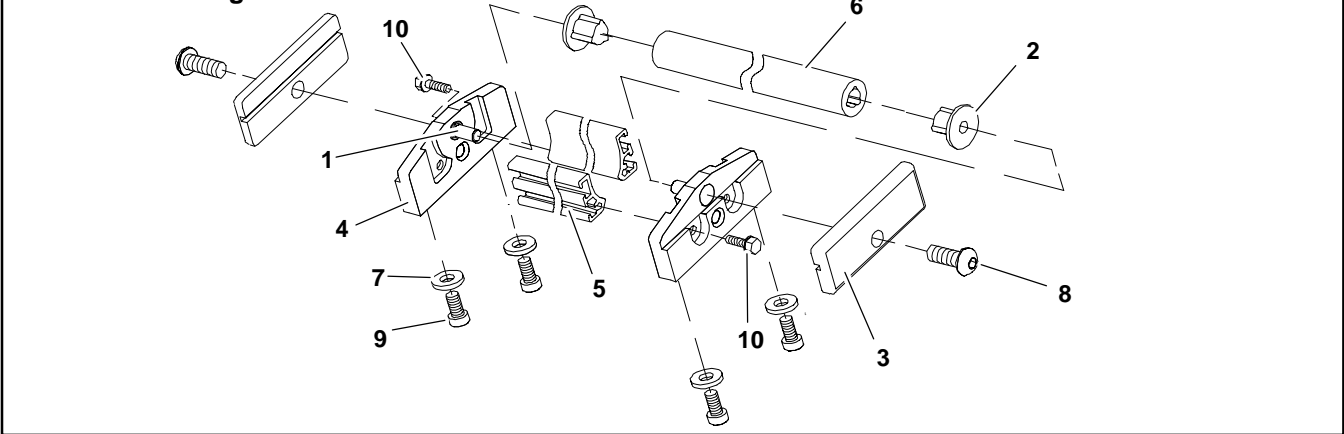
Connecting Assembly without Stand Mount



Item	Part Number	Description
1	240849	Frame Bar Connector, SAE
	240331	Frame Bar Connector, Metric

2	300153M	Intermediate Clamp Plate
3	901-129	Button Head Screw 1/4-20 x .50"
	920692M	Socket Head Screw M6 x 12mm

Flat Belt Mounting Bracket with Return Roller



Item	Part Number	Description
1	202348P	Bearing Pin
2	202311P	Return Roller Bearing
3	200022	Stand Clamp Plate, SAE
	200022M	Stand Clamp Plate, Metric
4	202351	Return Roller Mounting Block, SAE
	202351M	Return Roller Mounting Block, Metric
5	207802	Return Roller Guard 2" (44mm)
	207803	Return Roller Guard 3" (70mm)
	207804	Return Roller Guard 4" (95mm)
	207805	Return Roller Guard 5" (127mm)
	207806	Return Roller Guard 6" (152mm)
	207808	Return Roller Guard 8" (203mm)
	207810	Return Roller Guard 10" (254mm)
	207812	Return Roller Guard 12" (305mm)
	207818	Return Roller Guard 18" (457mm)
	207821	Return Roller Guard 21" (533mm)
	207824	Return Roller Guard 24" (610mm)

6	207702	Return Roller Tube, 2" (44mm)
	207703	Return Roller Tube, 3" (70mm)
	207704	Return Roller Tube, 4" (95mm)
	207705	Return Roller Tube, 5" (127mm)
	207706	Return Roller Tube, 6" (152mm)
	207708	Return Roller Tube, 8" (203mm)
	207710	Return Roller Tube, 10" (254mm)
	207712	Return Roller Tube, 12" (305mm)
	207718	Return Roller Tube, 18" (457mm)
	207721	Return Roller Tube, 21" (533mm)
	207724	Return Roller Tube, 24" (610mm)
7	605279P	Hard Washer .281 x .620 x .120
8	901-181	Button Head Screw 5/16 x .62"
	910816M	Button Head Screw M8 x 16mm
9	902-132	Socket Head Screw 1/4 x .75"
	920618M	Socket Head Screw M6 x 18mm
10	960498M	Hex Head Screw M/4 x 12mm

Conveyor Belt Part Number Configuration

Flat Belt Conveyor Model Number

2150 M WW LL A PP / BB

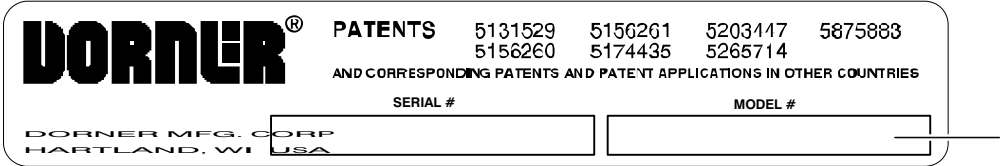


Figure 50

Flat Belt Part Number Configuration

Refer to Dornier patent plate (Figure 50). From the model number, determine conveyor width (“WW”), length (“LL”) and belt type (“BB”). Use data to configure belt part number as indicated below.

21 - WW LL / BB

21 - ___ (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 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.

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

DORNER[®]

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