

## 2200 Series End Drive Conveyors



## Table of Contents

|   |    |   |    |
|---|----|---|----|
| Warnings – General Safety .....                     | 2  | Pulley Removal .....                                    | 13 |
| Introduction .....                                  | 2  | A – Idler Pulley Removal .....                          | 13 |
| Product Description .....                           | 3  | B – Drive Pulley Removal .....                          | 14 |
| Specifications .....                                | 3  | Bearing Removal & Replacement .....                     | 14 |
| Installation .....                                  | 4  | Removal .....   | 14 |
| Required Tools .....                                | 4  | Replacement .....                                       | 15 |
| Recommended Installation Sequence .....             | 5  | Drive Pulley and Pulley Installation .....              | 15 |
| Conveyors Up to 12 ft (3658 mm) .....               | 5  | Drive Pulley Installation .....                         | 15 |
| Conveyors Longer Than 12 ft (3658 mm) .....         | 5  | Idler Pulley Installation .....                         | 15 |
| Mounting Brackets .....                             | 6  | Nose Bar Bearing Replacement .....                      | 16 |
| Return Rollers .....                                | 7  | Service Parts .....                                     | 18 |
| Cleated Belt and 2 – 6” (51 – 152 mm) Wide .....    |    | 2” (51mm) Wide Conveyor .....                           | 18 |
| Flat Belt Conveyors .....                           | 7  | 3” (76mm) to 6” (152mm) Wide Conveyor .....             | 20 |
| 8 – 24” (203 – 610 mm) Wide .....                   |    | 8” (203mm) to 12” (305mm) Wide Conveyor .....           | 22 |
| Flat Belt Conveyors .....                           | 7  | 18” (457mm) to 24” (610mm) Wide Conveyor .....          | 25 |
| Preventative Maintenance & Adjustment .....         | 8  | Nosebar End Assembly .....                              | 28 |
| Required Tools .....                                | 8  | –04 3” (76mm) Aluminum Side .....                       | 29 |
| Standard Tools .....                                | 8  | –05 1.5” (38mm) Aluminum Side .....                     | 30 |
| Special Tools .....                                 | 8  | –07 Low to Side Wiper .....                             | 31 |
| Checklist .....                                     | 8  | –09 Low to High Side .....                              | 32 |
| Lubrication .....                                   | 8  | –10 .5” (13mm) Extruded Plastic .....                   | 33 |
| Maintaining Conveyor Belt .....                     | 8  | –13 Adjustable Guiding .....                            | 34 |
| Troubleshooting .....                               | 8  | .5” (13mm) Cleated Belt Guiding .....                   | 35 |
| Cleaning .....                                      | 8  | 1” (25mm) Cleated Belt Guiding .....                    | 36 |
| Conveyor Belt Replacement .....                     | 8  | 2” (51mm) Cleated Belt Guiding .....                    | 37 |
| Conveyor Belt Replacement Sequence .....            | 8  | Flared Side Guiding .....                               | 38 |
| Belt Removal for Conveyor Without .....             |    | Flat Belt Stand Mount Assembly .....                    | 39 |
| Stands or Gearmotor Mounting Package .....          | 9  | Cleated Belt Stand Mount Assembly .....                 | 39 |
| Belt Removal for Conveyor With .....                |    | Flat Belt Stand Mount Assembly for 2’ (610mm) .....     |    |
| Stands and Gearmotor Mounting Package .....         | 9  | Conveyors .....   | 40 |
| Belt Installation for Conveyor Without .....        |    | Cleated Belt Stand Mount Assembly for 2’ (610mm) .....  |    |
| Stands or Gearmotor Mounting Package .....          | 10 | Conveyors .....   | 40 |
| Belt Installation for Conveyor With .....           |    | Connecting Assembly without Stand Mount .....           | 41 |
| Stands and Gearmotor Mounting Package .....         | 10 | Flat Belt Connecting Assembly with Stand Mount .....    | 41 |
| Conveyor Belt Tensioning .....                      | 11 | Cleated Belt Connecting Assembly with Stand Mount ..... | 42 |
| Conveyors with 1.25” (32 mm) Diameter Pulleys ..... | 11 | 2” (51mm) to 6” (152mm) Flat Belt Return Roller .....   | 42 |
| Conveyors with Nose Bar Idlers .....                | 12 | 8” (203mm) to 24” (610mm) Flat Belt Return Roller ..... | 43 |
| Conveyor Belt Tracking .....                        | 12 | Cleated Belt Return Roller .....                        | 43 |
| V–Guided Belts .....                                | 12 | Conveyor Belt Part Number Configuration .....           | 44 |
| Non V–Guided Belts .....                            | 12 | Return Policy .....                                     | 46 |

# 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.<br/><b>KEEP OFF CONVEYORS.</b></p> |               |

|   |               |
|---|---------------|
|   | <b>DANGER</b> |
| <p><b>DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.</b></p> |               |

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

|  |                |
|--|----------------|
|  | <b>WARNING</b> |
| <p>Gearmotors may be <b>HOT</b>.<br/><b>DO NOT TOUCH Gearmotors.</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>Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.<br/><b>SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.</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's Limited Warranty applies.

Dorner has convenient, pre-configured kits of Key Service Parts for all conveyor products. These time saving kits are easy to order, designed for fast installation, and guarantee you will have what you need when you need it. Key Parts and Kits are marked in the Service Parts section of this manual with the Performance Parts Kits logo

Dorner 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981, 6,422,382 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                  | Gearmotor Mounting Package |
| C                  | Gearmotor                  |
| D                  | Guiding & Accessories      |
| E                  | Mounting Brackets          |
| F                  | Return Rollers             |
| G                  | Support Stand              |
| H                  | Variable Speed Controller  |
| I                  | Drive End                  |
| J                  | Idler/Tension End          |

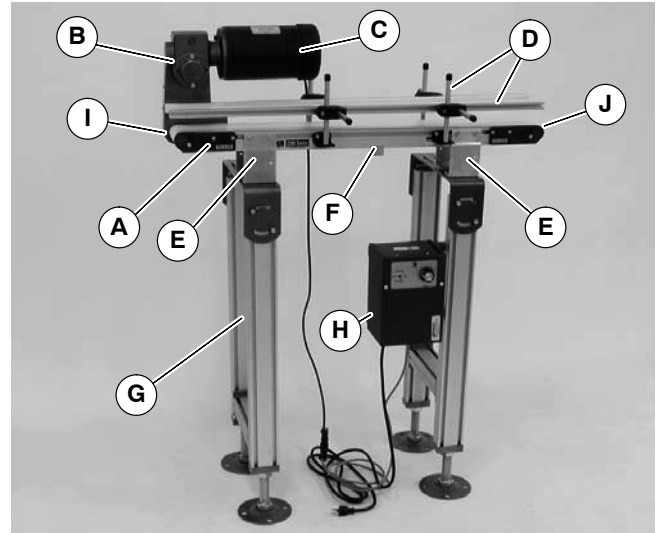


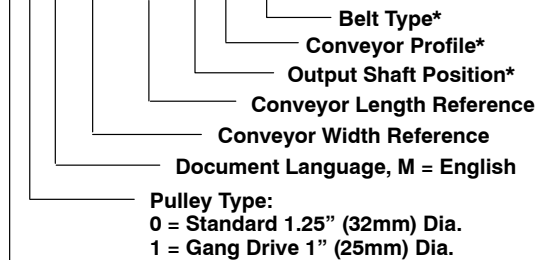
Figure 1

## Specifications

### Models:

#### Flat Belt 2200 Series Conveyor

2 1 0 M WW LLLL A PP BB

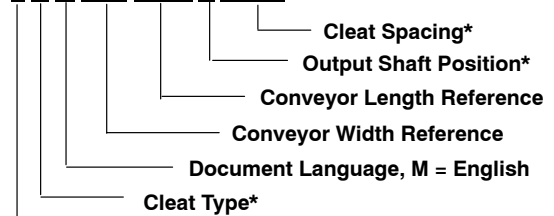


- 1 = with belt tracking cams and mounting brackets
- 2 = with V-guide tracking and mounting brackets
- 3 = with nosebar transfer tail and mounting brackets
- 4 = with V-guide tracking and no mounting brackets
- 5 = with belt tracking cams and no mounting brackets
- 6 = with nosebar transfer tail and no mounting brackets

\* See Ordering and Specifications Catalog for details.

#### Cleated Belt 2200 Series Conveyor

2 4 C M WW LLLL A SSSS



- 0 = with V-guide tracking and no mounting brackets
- 4 = with V-guide tracking and mounting brackets
- 5 = with belt tracking cams and mounting brackets
- 9 = with belt tracking cams and no mounting brackets

### Conveyor Supports:

#### Maximum Distances:

K = 18" (457 mm)\*\*

L = 6 ft (1829 mm)\*\*\*

M = 18" (457 mm)

\*\* For Heavy Load Bottom Mount Package, mount support under gear head.

\*\*\* For conveyors longer than 12 ft (3658 mm), install support at joint.

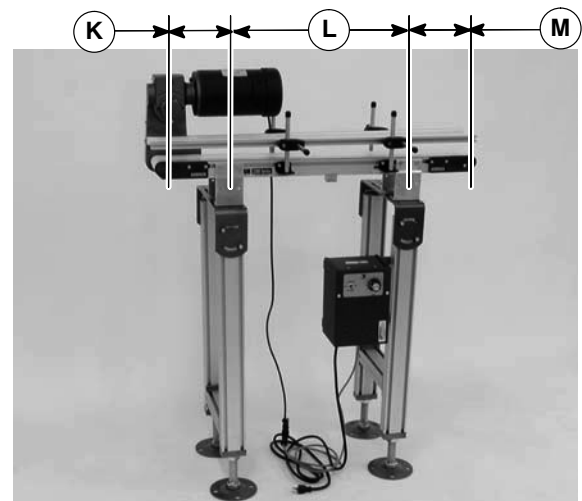


Figure 2

# Specifications

## Specifications:

| Conveyor Width Reference (WW)              | 02  | 03                 | 04                 | 05                 | 06                 | 08                  | 10                  | 12                  | 18                  | 21                  | 24                  |
|--|---|--------------------|--------------------|--------------------|--------------------|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|
| Conveyor Belt Width                        | 1.75"<br>(44mm)   | 2.75"<br>(70mm)    | 3.75"<br>(95mm)    | 5"<br>(127mm)      | 6"<br>(152mm)      | 8"<br>(203mm)       | 10"<br>(254mm)      | 12"<br>(305mm)      | 18"<br>(457mm)      | 21"<br>(533mm)      | 24"<br>(609mm)      |
| Maximum Conveyor Load*<br>(See NOTE Below) | 30 lb<br>(14kg)   | 35 lb<br>(16kg)    | 42 lb<br>(19kg)    | 50 lb<br>(23kg)    | 60 lb<br>(27kg)    | 70 lb<br>(32kg)     | 80 lb<br>(36kg)     | 80 lb<br>(36kg)     | 80 lb<br>(36kg)     | 80 lb<br>(36kg)     | 80 lb<br>(36kg)     |
| Conveyor Startup Torque*                   | 2 in-lb<br>(0.5Nm)                                      | 3 in-lb<br>(0.6Nm) | 4 in-lb<br>(0.7Nm) | 6 in-lb<br>(0.8Nm) | 8 in-lb<br>(0.9Nm) | 10 in-lb<br>(1.1Nm) | 12 in-lb<br>(1.4Nm) | 14 in-lb<br>(1.5Nm) | 15 in-lb<br>(1.7Nm) | 18 in-lb<br>(2.0Nm) | 20 in-lb<br>(2.3Nm) |
| Belt Travel                                | 4.0" (88 mm) per revolution of pulley                   |                    |                    |                    |                    |                     |                     |                     |                     |                     |                     |
| Maximum Belt Speed*                        | 264 ft/minute (80.5 m/minute)                           |                    |                    |                    |                    |                     |                     |                     |                     |                     |                     |
| Belt Takeup                                | 0.38" (10 mm) of stroke = 0.75" (19 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**                 |
|--|------------------|------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|--------------------|--------------------|--------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|
| Conveyor Length<br>Up to 18 ft in any length<br>to nearest 0.12" (3mm) | 2-ft<br>(610 mm) | 3-ft<br>(914 mm) | 4-ft<br>(1219 mm) | 5-ft<br>(1524 mm) | 6-ft<br>(1829 mm) | 7-ft<br>(2134 mm) | 8-ft<br>(2438 mm) | 9-ft<br>(2743 mm) | 10-ft<br>(3048 mm) | 11-ft<br>(3353 mm) | 12-ft<br>(3658 mm) | 13-ft<br>(3962 mm)** | 14-ft<br>(4267 mm)** | 15-ft<br>(4572 mm)** | 16-ft<br>(4877 mm)** | 17-ft<br>(5182 mm)** | 18-ft<br>(5486 mm)** |

\* See Ordering and Specifications Catalog for details.

\*\* Lengths available only in 6" (152 mm) & wider conveyors.

**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 (N of Figure 3) for setup.



Figure 3

### Installation Component List

- O Conveyor frame (two sections if longer than 12ft)
- P Conveyor brackets (4x)
- Q Return rollers (for longer conveyors)

### Required Tools

- Hex-key wrenches:  
4 mm, 5 mm
- Level
- Torque wrench

## Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor (if required)
- Attach mounting brackets to conveyor
- Attach conveyor to stands
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 29 through 37 of “Service Parts” section for details)

### Conveyors Up to 12 ft (3658 mm)

No assembly is required. Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 6 and “Return Rollers” on page 7.

### Conveyors Longer Than 12ft (3658 mm)

1. Locate conveyor sections (O Figure 4)

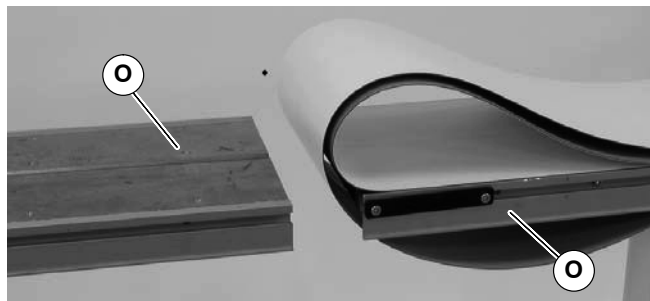



Figure 4

2. On tension end of the conveyor, identified with a  label (R of Figure 5), push in head plate assembly (S): On both sides of conveyor, loosen and move cam tracking assemblies (T) (if equipped) away from head plates, then loosen fastening screws (U) and push head plate assembly inward.

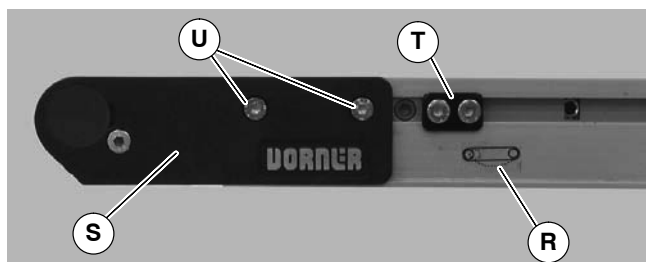


Figure 5

3. Roll out conveyor belt and place conveyor frame sections (O of Figure 6) into belt loop.

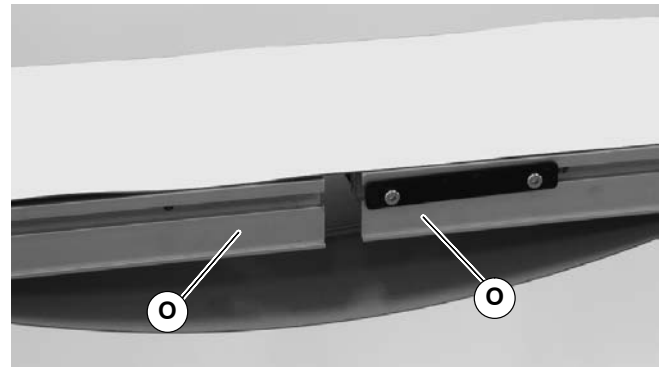


Figure 6

4. Join conveyor sections and install frame connector plates (V of Figure 7) or connector/mount brackets (VA) and screws (W) on both sides as indicated. Tighten screws to 60 in-lb (7 Nm).

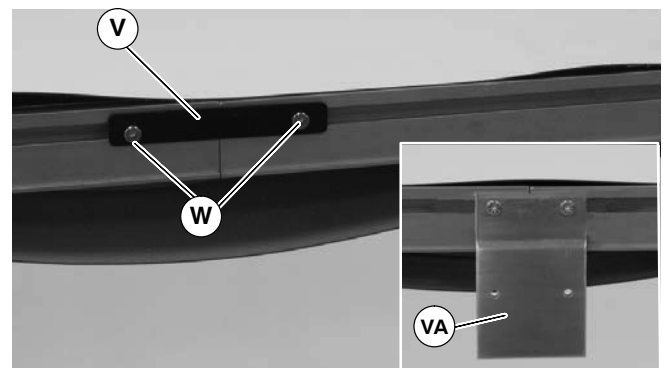


Figure 7

5. With a 5 mm hex-key wrench, rotate pinion gear (X of Figure 8) to tension the conveyor belt. Tighten fastening screws (U) on both sides of conveyor to 80 in-lb (9 Nm). For proper tensioning, refer to “Conveyor Belt Tensioning” on page 11.

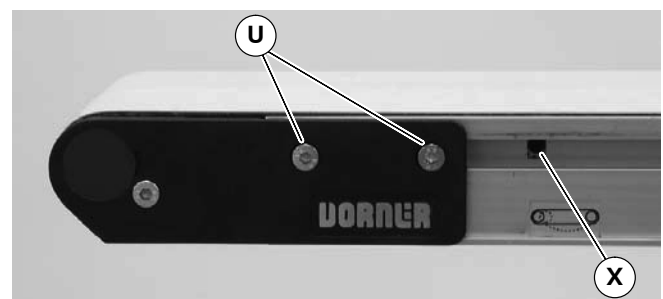


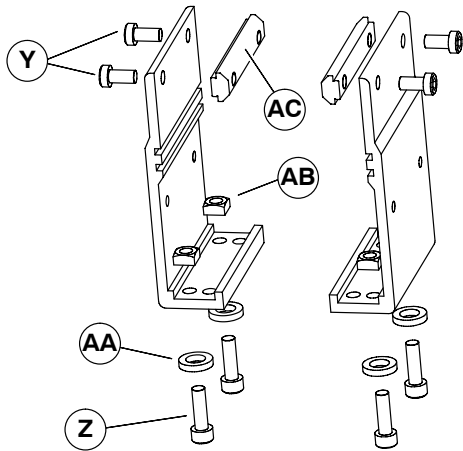
Figure 8

6. Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 6 and “Return Roller” on page 7.
7. If equipped with cam tracking assemblies (T of Figure 5), reposition and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 12.

# Installation

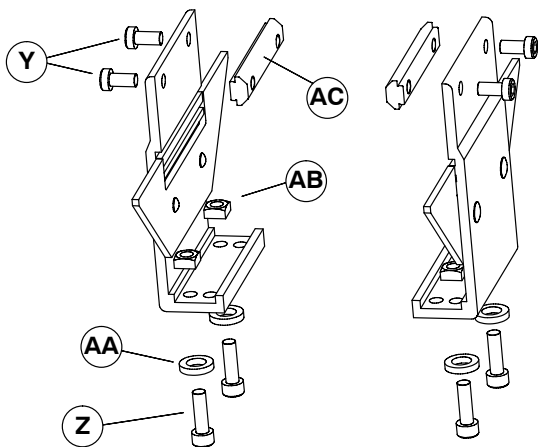
## Mounting Brackets

1. Locate brackets. Exploded views shown in Figures 9 & 10.



Mounting Brackets for Flat Belt Conveyor

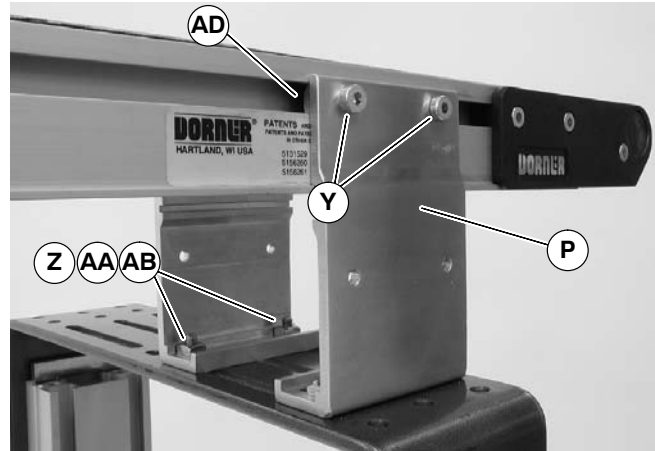
**Figure 9**



Mounting Brackets for Cleated Belt Conveyor

**Figure 10**

2. Remove screws (Y & Z of Figures 9 & 10), washers (AA), nuts (AB) and T-bars (AC) from brackets.
3. Insert T-bars (AC of Figures 9 & 10) into conveyor side slots (AD of Figure 11). Fasten brackets (P of Figure 11) to conveyor with mounting screws (Y).



**Figure 11**

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**NOTE:** Mounting brackets for flat belt conveyors shown.

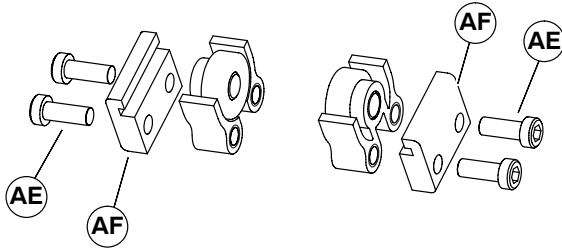
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4. Fasten brackets to support stand with mounting screws (Z of Figure 11), washers (AA) and nuts (AB).
5. Tighten screws (Y & Z of Figure 11) to 60 in-lb (7 Nm).

## Return Rollers

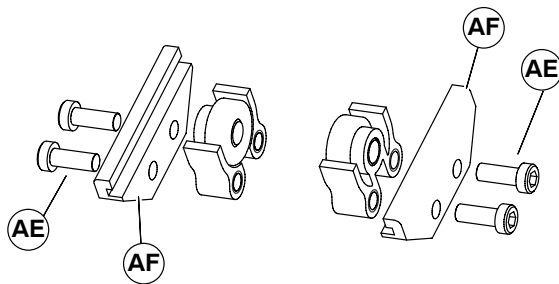
### Cleated Belt and 2–6" (51–152 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded views shown in Figures 12 & 13.



Return Rollers for Flat Belt Conveyor

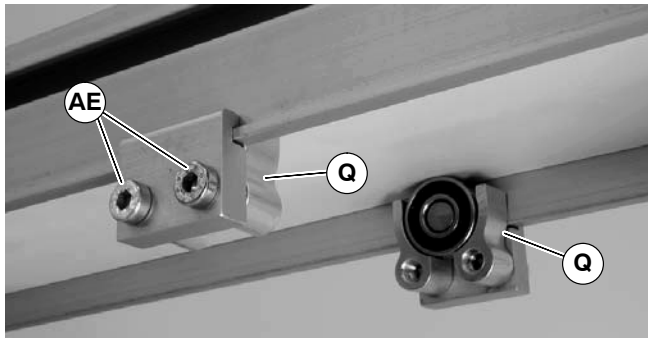
**Figure 12**



Return Rollers for Cleated Belt Conveyor

**Figure 13**

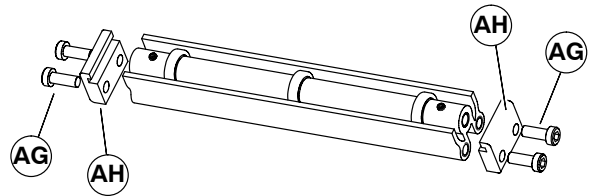
2. Remove screws (AE of Figures 12 & 13) and clips (AF) from roller assembly.
3. Install roller assemblies (Q of Figure 14) as shown. Tighten screws (AE) to 60 in-lb (7 Nm).



**Figure 14**

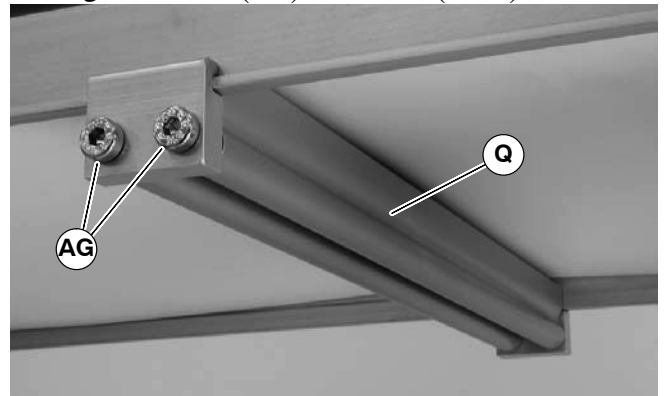
### 8–24" (203–610 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded view shown in Figure 15.



**Figure 15**

2. Remove screws (AG of Figure 15) and clips (AH) from roller assembly.
3. Install roller assembly as shown (Q of Figure 16). Tighten screws (AG) to 60 in-lb (7 Nm).



**Figure 16**

# Preventive Maintenance and Adjustment

## Required Tools

### Standard Tools

- Hex-key wrenches:  
2.5 mm, 4 mm, 5 mm
- Arbor press

### Special Tools

- 807–1078 Bearing Puller Tool (or equivalent)
- 450292 Bearing Installation Tool
- 456070 Bearing Removal Tool

## Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner (part # 625619)
- Clean entire conveyor and knurled pulley while disassembled
- Replace worn or damaged parts

## Lubrication

No lubrication is required. Replace bearings if worn.

## Maintaining Conveyor Belt

### Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear
- Stalling or slipping
- Damage to V-guide

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Improperly installed bottom wipers (if installed)
- Accumulated dirt in wipers (if installed)
- 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

Damage to V-guide indicates:

- Twisted or damaged conveyor frame
- Dirt impacted on pulleys
- Excessive or improper side loading

**NOTE: Visit [www.dorner.com](http://www.dorner.com) for complete list of troubleshooting solutions.**

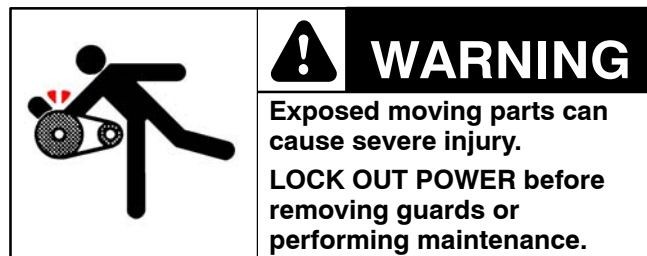
## Cleaning

**IMPORTANT: Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.**

Use Dorner Belt Cleaner (part # 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



### Conveyor Belt Replacement Sequence

- Remove old conveyor belt:
  - Conveyor without Stands or Gearmotor Mounting Package
  - Conveyor with Stands and Gearmotor Mounting Package
- Install new conveyor belt
- Tension conveyor belt



# Preventive Maintenance and Adjustment

## Belt Removal for Conveyor Without Stands or Gearmotor Mounting Package

1. If equipped, remove bottom wipers (AJ of Figure 17): Remove fastening screws (AI) then remove wiper (AJ).

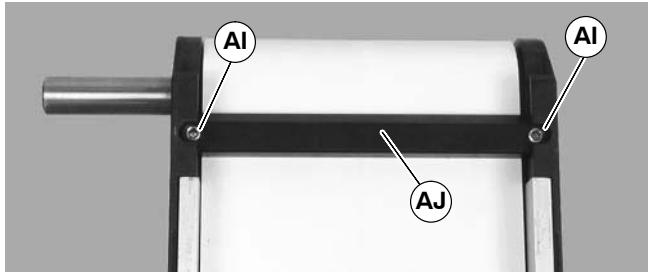



Figure 17

2. If equipped, remove return rollers and guiding and accessories from one side of conveyor.
3. On tension end of the conveyor, identified with a  label (R of Figure 18), push in head plate assembly (S): On both sides of conveyor, loosen and move cam tracking assemblies (T) (if equipped) away from head plates, then loosen fastening screws (U) and push head plate assembly inward.

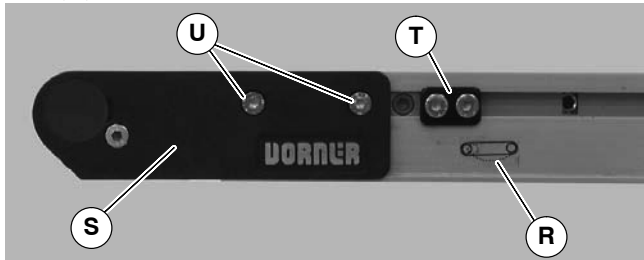


Figure 18

4. Remove conveyor belt.

## Belt Removal for Conveyor With Stands and Gearmotor Mounting Package

|   |  |
|---|--|
|  | <p><b>! WARNING</b></p> <p>Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.</p> <p><b>PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT</b></p> |
|---|--|

1. Place temporary support stands (AK of Figure 19) at both ends of the conveyor. Place an additional support stand under the drive motor (AL), if equipped. See **WARNING**.

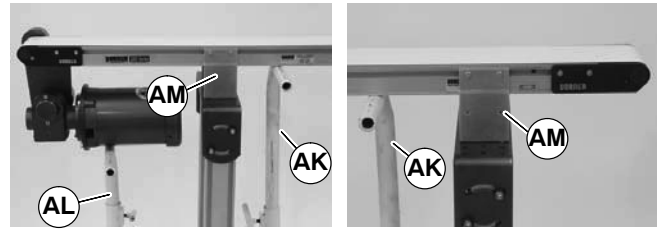


Figure 19

2. Remove mounting brackets (AM of Figure 19) from one side of conveyor. (Reverse steps 3 & 4 of “Mounting Brackets” section on page 6.) If equipped with heavy load drive package, remove brackets from side opposite drive cover (AN of Figure 20).
3. If equipped, remove bottom wipers (AJ of Figure 17): Remove fastening screws (AI) then remove wiper (AJ).
4. If equipped, remove return rollers, guiding and accessories from side opposite drive cover (AN of Figure 20).

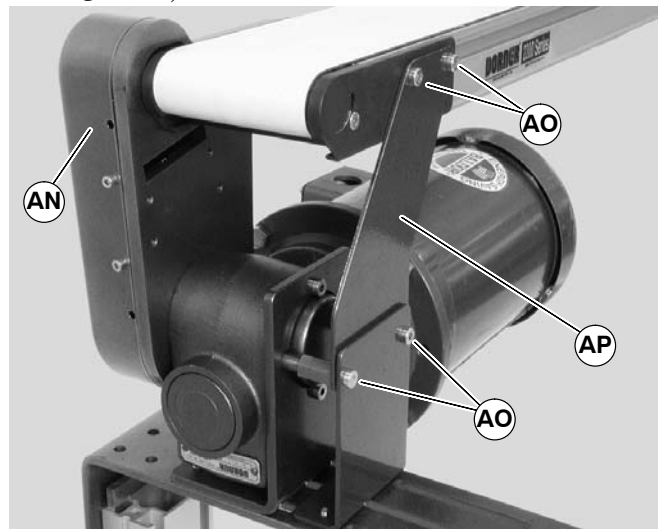



Figure 20

5. If equipped with heavy load drive package, remove drive support bracket (AP of Figure 20): Remove bracket screws (AO) then remove bracket (AP).

# Preventive Maintenance and Adjustment

- On tension end of the conveyor, identified with a  label (R of Figure 21), push in head plate assembly (S): On both sides of conveyor, loosen and move cam tracking assemblies (T) (if equipped) away from head plates, then loosen fastening screws (U) and push head plate assembly inward.

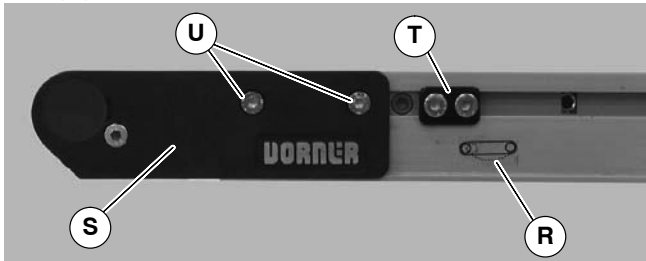


Figure 21

- Remove belt (AQ of Figure 22) from conveyor.



Figure 22

## Belt Installation for Conveyor without Stands or Gearmotor Mounting Package

- Orient belt so splice leading fingers (AR of Figure 23) point in the direction of belt travel as identified by the conveyor directional label (AS).

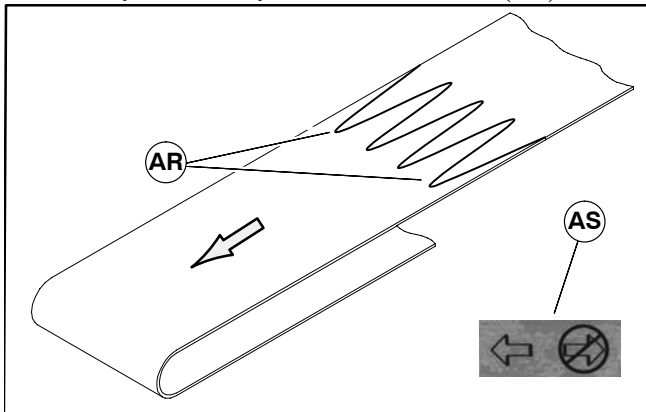


Figure 23

- Slide belt onto the conveyor frame assembly.
- Tension belt. Refer to “Conveyor Belt Tensioning” on page 11.
- If equipped, install wipers, return rollers and guiding.

## Belt Installation for Conveyor with Stands and Gearmotor Mounting Package



- Ensure temporary support stands (AK of Figure 19) are placed at both ends of the conveyor. Place an additional support stand under the drive motor (AL), if equipped. See WARNING.
- Orient belt so splice leading fingers (AR of Figure 23) point in the direction of belt travel as identified by the conveyor directional label (AS).
- Install belt (AQ of Figure 24) on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.



Figure 24


- Re-install conveyor mounting brackets. Refer “Mounting Brackets” on page 6, steps 3 through 5.
- If equipped with a heavy load drive package, re-install drive support bracket (AP of Figure 20).
- Tension belt. Refer to “Conveyor Belt Tensioning” on page 11.
- If equipped, re-install wipers, return rollers and guiding.

# Preventive Maintenance and Adjustment

## Conveyor Belt Tensioning



### Conveyors with 1.25" (32 mm) Diameter Pulleys

1. On tension end of the conveyor, identified with a  label (R of Figure 25), adjust head plate assembly (S): On both sides of conveyor, loosen fastening screws (U) and rotate pinion gear (X) to adjust head plate assembly.

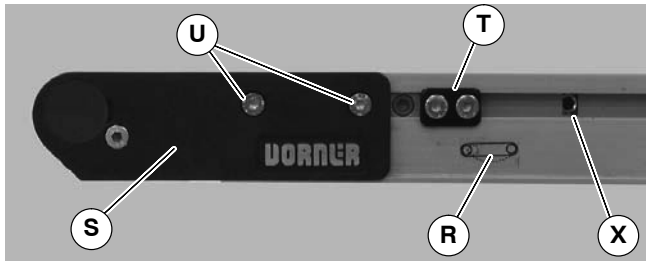


Figure 25

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks (AT & AU of Figure 26). Replace belt if proper tensioning can not be obtained while aligning

the end of the conveyor frame with or between the tensioning marks. See **NOTE**.

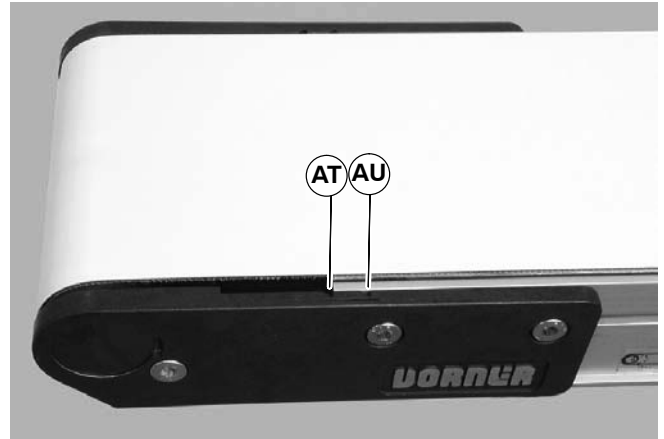



Figure 26

**NOTE:** On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12" (44 – 305mm) wide conveyors and 50 in-lb (4.5 Nm) for an 18 – 24" (457 – 610mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten fastening screws (U of Figure 25) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (T of Figure 25), position against head plates and adjust belt tracking. Refer to "Conveyor Belt Tracking" on page 12.

# Preventive Maintenance and Adjustment

## Conveyors with Nose Bar Idlers

1. On tension end of the conveyor, identified with a  label (R of Figure 27), adjust head plate assembly (S): On both sides of conveyor, loosen fastening screws (U) and rotate pinion gear (X) to adjust head plate assembly.

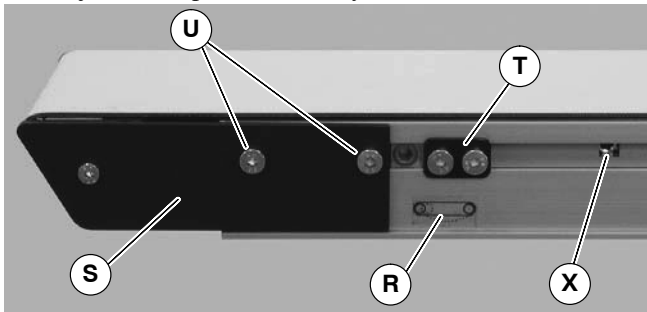


Figure 27

2. Adjust head plate assembly so the edge of the axle support plate (AV of Figure 28) is separated from the end of the conveyor (AW) by 1.125" (29 mm). Replace belt if proper tensioning can not be obtained within a distance of 1.50" (38 mm). See **NOTE**.

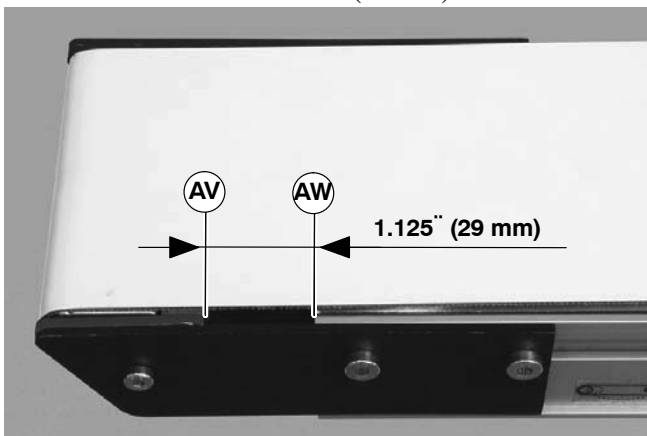


Figure 28

**NOTE:** On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12" (44 – 305mm) wide conveyors or 50 in-lb (4.5 Nm) for an 18 – 24" (457 – 610mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten fastening screws (U of Figure 27) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (T of Figure 27) position against head plates and adjust belt tracking. Refer to "Conveyor Belt Tracking", next section.

## Conveyor Belt Tracking

### V-Guided Belts

V-guided belts do not require tracking adjustment.

### Non V-Guided Belts

Non V-guided belt conveyors are equipped with belt tracking cam assemblies (T of Figure 29) for belt tracking adjustment.

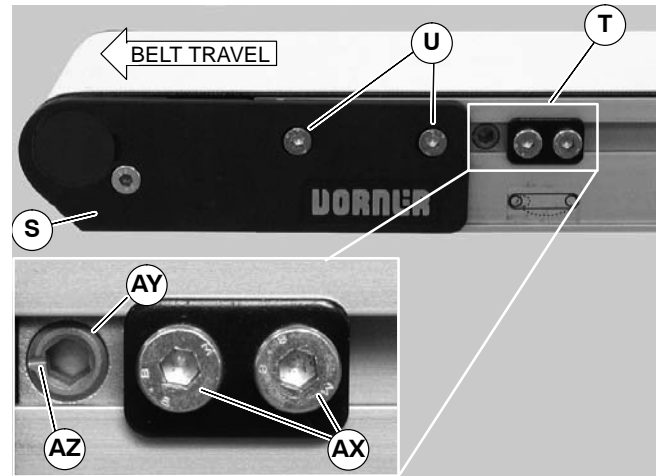


Figure 29

When adjusting belt tracking, always adjust the discharge end of the conveyor first. To adjust belt tracking:

1. Ensure head plate fastening screws (U of Figure 29) on both sides of conveyor are tightened.
2. On both sides of conveyor, loosen two (2) cam fastening screws (AX). Adjust cams (AY) until indicator slots (AZ) are horizontal and facing end of conveyor. Then slide cam assemblies against head plates (S) and re-tighten cam fastening screws (AX) to 60 in-lb (7 Nm).
3. On the side toward which the belt is tracking, loosen head plate fastening screws (U).
4. With the conveyor running, use a 5 mm hex-key wrench to rotate the tracking cam (AY) in small increments until the belt tracks in the center of the conveyor. Then while holding the cam in position, re-tighten the head plate fastening screws (U) with a 4 mm hex-key wrench to 60 in-lb (7 Nm).

# Preventive Maintenance and Adjustment

## Pulley Removal



Leaving the conveyor belt in place, remove the desired pulley following the corresponding instructions below:

- A – Idler Pulley Removal
- B – Drive Pulley Removal

### A – Idler Pulley Removal

1. On one side of the conveyor, loosen two (2) head plate fastening screws (U of Figure 30) and remove them.

---

**NOTE:** To prevent damage to the head plates and pulley, be sure to remove them slowly because they are not attached to pulley.

---



Figure 30

2. Remove the head plate (BA of Figure 31) from the conveyor frame.

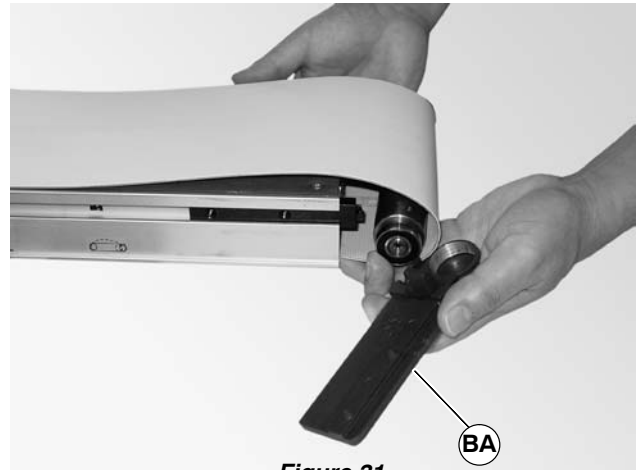


Figure 31

3. Pulley will slide out of opposite head plate and drop into slack of belt (Figure 32).



Figure 32

4. Slide spindle out of the belt loop.

## B – Drive Pulley Removal



1. On one side of the conveyor, loosen two (2) head plate fastening screws (U of Figure 33) and remove.

**NOTE:** To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.



Figure 33

2. Remove the head plate (BA of Figure 34) from the conveyor frame.

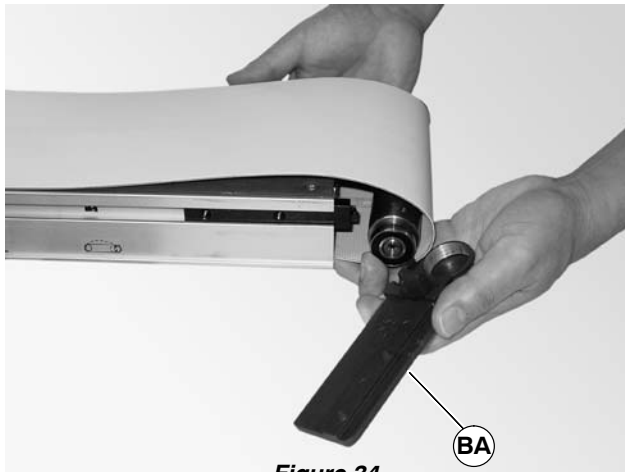


Figure 34

3. Drive pulley will slide out of opposite head and drop into slack of belt.
4. Slide the drive pulley out of the belt loop.

## Bearing Removal & Replacement

### Removal

**IMPORTANT:** Do not use any removed bearings. Replace them.

1. Use a bearing removal tool, (BD of Figure 35, 36), part number 807-1078, or equivalent and remove both bearings from the pulley and the drive pulley.

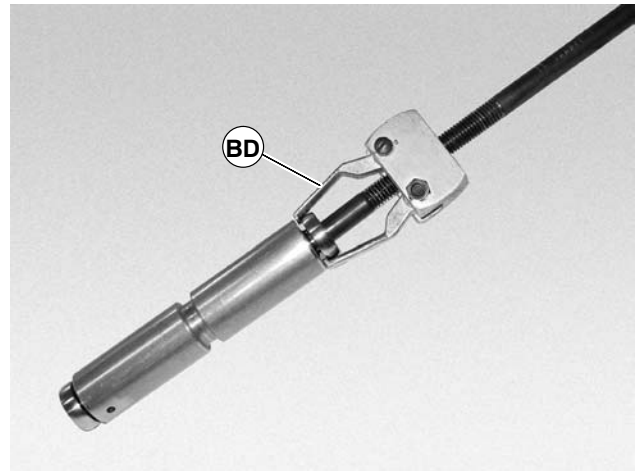


Figure 35 – Conveyor Pulley

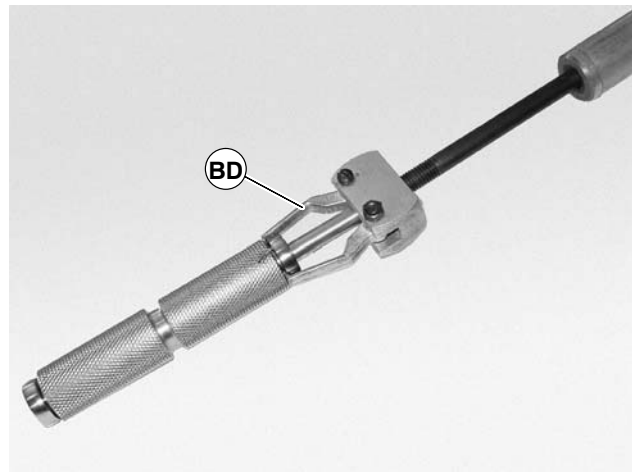


Figure 36 – Drive Pulley

## Replacement

1. Inspect the head plates bearing seating surface (BC of Figure 37). If they are worn or damaged, replace the head. See "Service Parts" on Page 20.

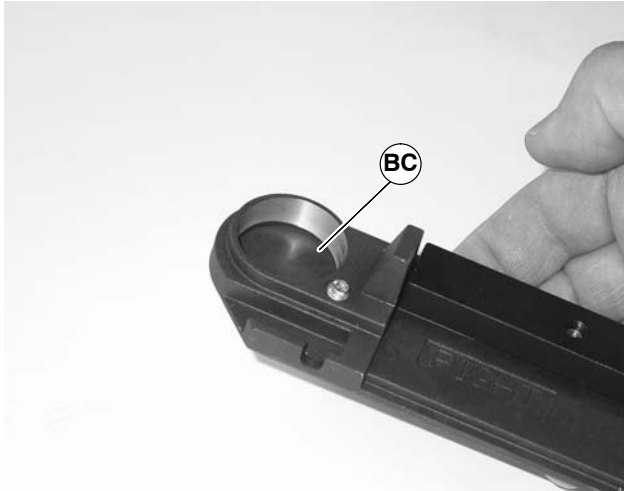


Figure 37

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**NOTE:** Two washers may be required when installing the bearing over the drive shaft on the drive pulley, if the bearing installation tool is not long enough to fit the length of the drive shaft.

---

2. Use a bearing installation tool, (BE of Figure 38), part number 450292 or equivalent and press bearings onto the pulley and drive pulley.

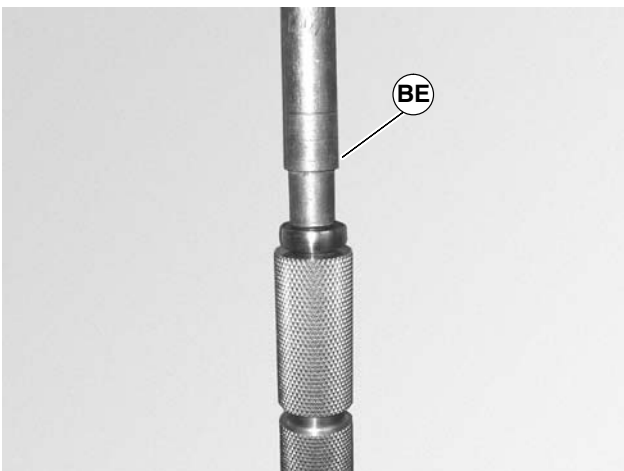


Figure 38

## Drive Pulley and Pulley Installation

### Drive Pulley Installation

1. With opposite head plate installed, position the drive pulley through the loop of the belt, into the opposite head plate.



Figure 39

2. Place the head plate (BA of Figure 39) and attach the head plate to the conveyor frame with the two (2) screws removed. Tighten screws 60 in-lb (7Nm).

### Idler Pulley Installation

1. With opposite head plate installed, position the idler pulley through the loop of the belt, into the opposite head plate.

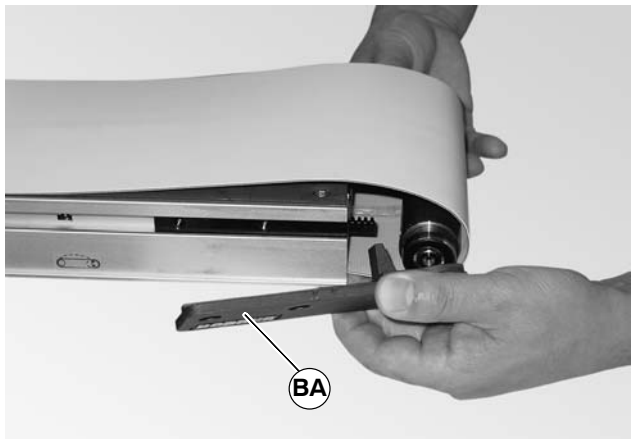


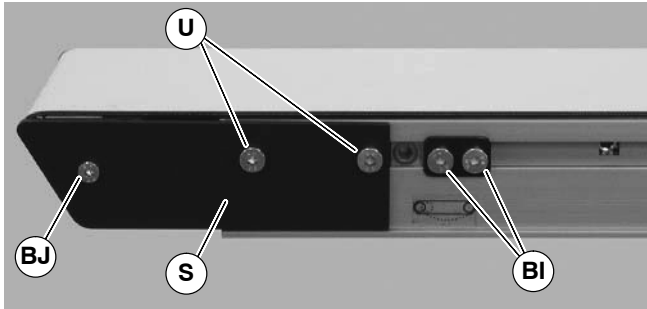
Figure 40

2. Place the head plate (BA of Figure 40) and attach the head plate to the conveyor frame with the two (2) screws removed and hand tighten.

# Preventive Maintenance and Adjustment

## Nose Bar Bearing Replacement

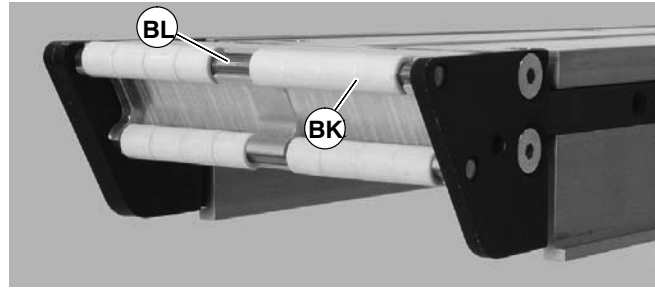
1. On both sides of conveyor, use a 4 mm hex-key wrench to loosen cam fastening screws (BI of Figure 41) and slide cam assemblies toward the center of the conveyor.



**Figure 41**

2. On both sides of conveyor, use a 4 mm hex-key wrench to loosen head plate fastening screws (U) to remove belt tension. Then remove belt from end of conveyor.
3. On one side of conveyor, use a 3 mm and 4 mm hex-key wrench to remove head plate fastening screws (BJ & U) and remove head plate (S).

4. Slide bearing rods (BL of Figure 42) out side of conveyor and replace bearings (BK) as necessary.




**Figure 42**

5. After replacing bearings, re-install head plate (S of Figure 41). Use a 3 mm hex-key wrench to tighten one (1) fastening screw (BL) to 30 in-lb (3.4 Nm). Leave two (2) fastening screws (U) loose for belt tensioning.
6. Re-install belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 11.
7. Re-position the cam assemblies against the head plates and adjust belt tracking. See “Conveyor Belt Tracking” on page 12.

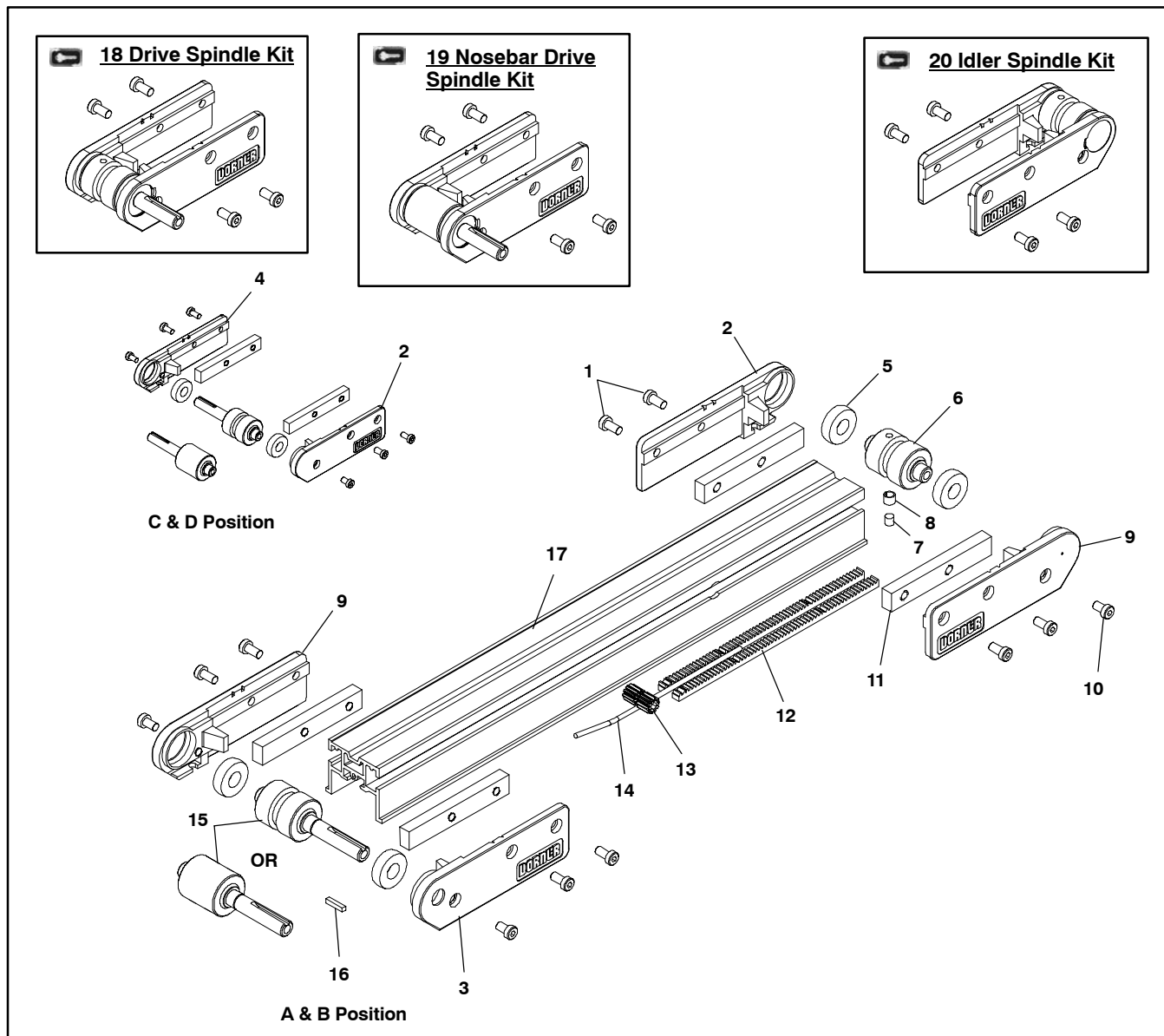




# Service Parts

**NOTE:** For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory. Key Service Parts and Kits are identified by the Performance Parts Kits logo . Dorner recommends keeping these parts on hand.

## 2" (51mm) Wide Conveyor

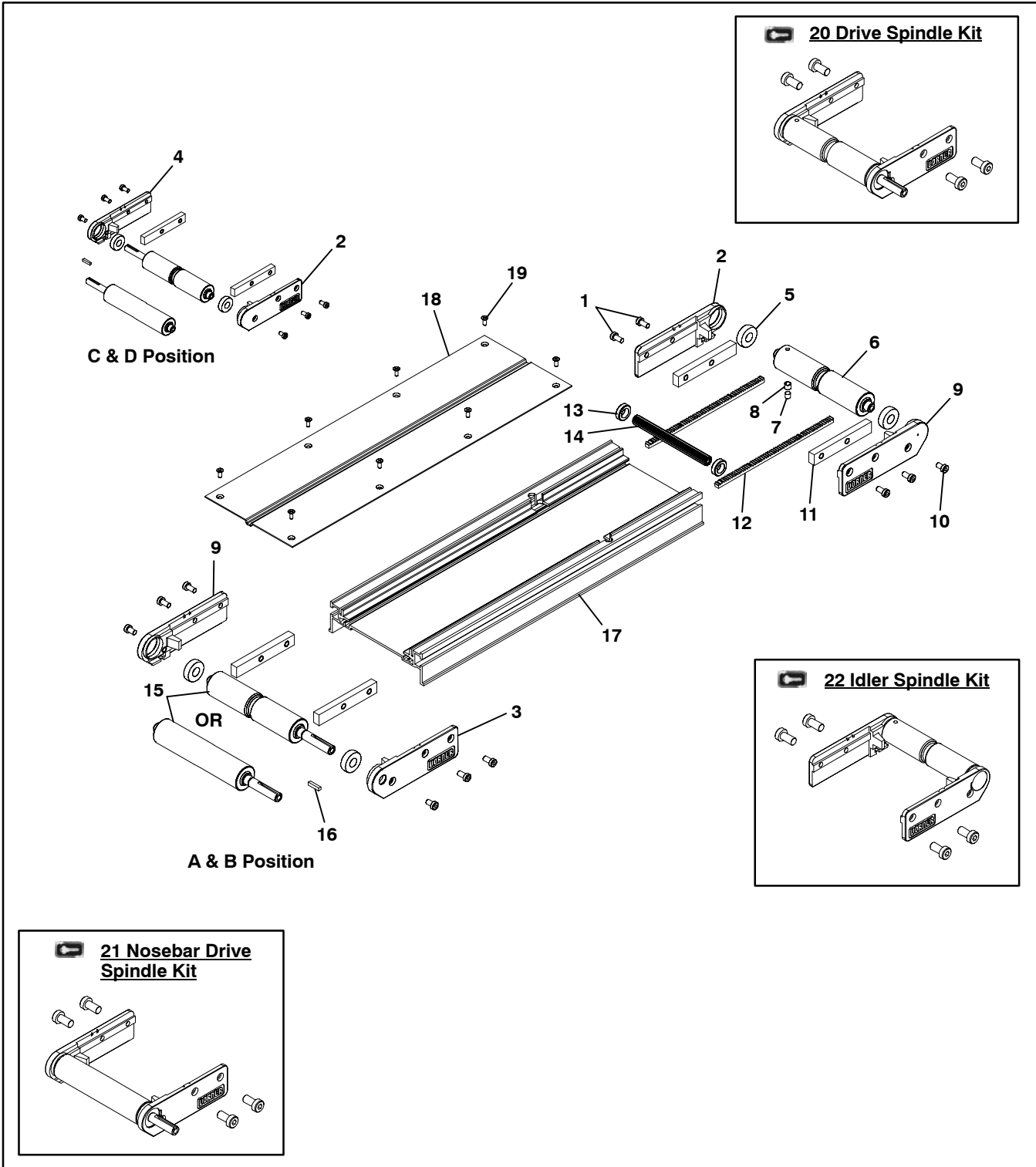


| Item | Part Number     | Description  |
|------|-----------------|--|
| 1    | 920692M         | Socket Head Screw M6 x 12mm  |
| 2    | 240425          | Head Plate LH  |
| 3    | 240427          | Head Plate LH Drive Side, Position A and B   |
| 4    | 240428          | Head Plate RH Drive Side, Position C and D   |
| 5    | 240328          | Bearing  |
| 6    | 247302          | Idler Spindle 2" (51mm)  |
| 7    | 808-020         | Magnet .25" Dia. x .25" long   |
| 8    | 450226SSP       | Sleeve, .25" Magnet Stainless Steel  |
| 9    | 240426          | Head Plate RH  |
| 10   | 920691M         | Socket Head Screw M6 x 10mm  |
| 11   | 240329          | Tension Slide Bar  |
| 12   | 240420          | Rack Gear 14.5 Degree PA x 24 P  |
| 13   | 240423          | Pinion 2" (51mm)   |
| 14   | 240422          | Pinion Pin   |
| 15   | 456402          | Drive Spindle 2" (51mm)  |
|      | 247602          | Nosebar Drive Spindle Lagged 2" (51mm)   |
| 16   | 980422M         | Square Key 4mm x 22mm  |
| 17   | See Frame Chart | 2" (51mm) Frame  |
| 18   | 22A-02          | Drive Spindle Kit, Position A and B - Grooved (Includes Items 1, 2, 3, 5, 9 and 15)                |
|      | 22D-02          | Drive Spindle Kit, Position C and D - Grooved (Includes Items 1, 2, 4, 5, 9 and 15)                |
| 19   | 22NA-02         | Nosebar Drive Spindle Kit, Position A and B - Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 15) |
|      | 22ND-02         | Nosebar Drive Spindle Kit, Position C and D - Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 15) |
| 20   | 22T-02          | Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)   |

| Item 17: 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 |

# Service Parts

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



# Service Parts

| Item | Part Number         | Description  |
|------|---------------------|--|
| 1    | 920692M             | Socket Head Screw M6 x 12mm  |
| 2    | 240425              | Head Plate LH  |
| 3    | 240427              | Head Plate LH Drive Side, Position A and B   |
| 4    | 240428              | Head Plate RH Drive Side, Position C and D   |
| 5    | 240328              | Bearing  |
| 6    | 2473WW              | Idler Spindle  |
| 7    | 808-020             | Magnet .25" Dia. x .25" long   |
| 8    | 450226SSP           | Sleeve, .25" Magnet Stainless Steel  |
| 9    | 240426              | Head Plate RH  |
| 10   | 920691M             | Socket Head Screw M6 x 10mm  |
| 11   | 240329              | Tension Slide Bar  |
| 12   | 240420              | Rack Gear 14.5 Degree PA x 24P   |
| 13   | 240421              | Pinion Bushing   |
| 14   | 2030WWW             | Pinion Gear  |
| 15   | 4564WW              | Drive Spindle 2" (51mm)  |
|      | 2476WW              | Nosebar Drive Spindle Lagged 2" (51mm)   |
| 16   | 980422M             | Square Key 4mm x 22mm  |
| 17   | See Frame Chart     | Conveyor Frame   |
| 18   | See Bed Plate Chart | Conveyor Bed Plate   |
| 19   | 807-1105            | Flat Head Torx Screw M6 x 10mm   |
| 20   | 22A-WW              | Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 15)                |
|      | 22D-WW              | Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 15)                |
| 21   | 22NA-WW             | Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 15) |
|      | 22ND-WW             | Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 15) |
| 22   | 22T-WW              | Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)   |

WW = Conveyor width reference: 03, 04, 05, 06

| Item 17: 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-07200 | 2404WW-07908* |
| 14' (4267mm)            | 2404WW-07200 | 2404WW-09108* |
| 15' (4572mm)            | 2404WW-07200 | 2404WW-10308* |
| 16' (4877mm)            | 2404WW-07200 | 2404WW-11508* |
| 17' (5182mm)            | 2404WW-07200 | 2404WW-12708* |
| 18' (5486mm)            | 2404WW-07200 | 2404WW-13908* |

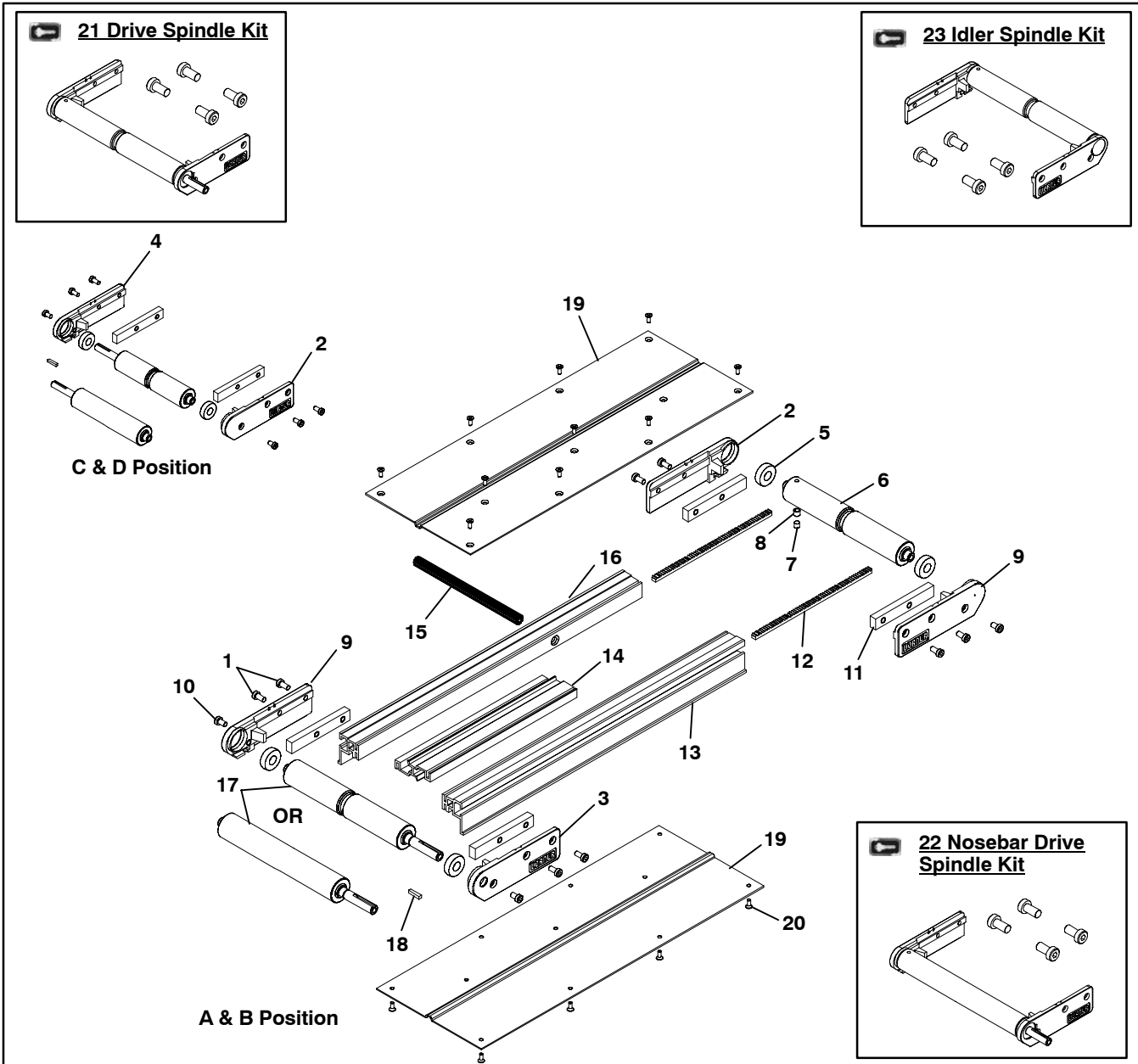
WW = Conveyor width reference: 03, 04, 05, 06  
\* = 6" (152mm) and wider conveyors, only

| Item 18: Bed Plate |              |               |
|--------------------|--------------|---------------|
| Length             | Part Number  |               |
| 2' (610mm)         | 2405WW-01900 |               |
| 3' (914mm)         | 2405WW-03100 |               |
| 4' (1219mm)        | 2405WW-04300 |               |
| 5' (1524mm)        | 2405WW-05500 |               |
| 6' (1829mm)        | 2405WW-06700 |               |
| 7' (2134mm)        | 2405WW-07900 |               |
| 8' (2438mm)        | 2405WW-09100 |               |
| 9' (2743mm)        | 2405WW-10300 |               |
| 10' (3048mm)       | 2405WW-11500 |               |
| 11' (3353mm)       | 2405WW-12700 |               |
| 12' (3658mm)       | 2405WW-13900 |               |
| 13' (3962mm)       | 2405WW-07196 | 2405WW-07900* |
| 14' (4267mm)       | 2405WW-07196 | 2405WW-09100* |
| 15' (4572mm)       | 2405WW-07196 | 2405WW-10300* |
| 16' (4877mm)       | 2405WW-07196 | 2405WW-11500* |
| 17' (5182mm)       | 2405WW-07196 | 2405WW-12700* |
| 18' (5486mm)       | 2405WW-07196 | 2405WW-13900* |

WW = Conveyor Width reference: 03, 04, 05, 06  
\* = 6" (152mm) and wider conveyors, only

# Service Parts

## 8" (203mm) to 12" (305mm) Wide Conveyor



| Item | Part Number | Description                                |
|------|-------------|--|
| 1    | 920692M     | Socket Head Screw M6 x 12mm                |
| 2    | 240425      | Head Plate LH                              |
| 3    | 240427      | Head Plate LH Drive Side, Position A and B |
| 4    | 240428      | Head Plate RH Drive Side, Position C and D |
| 5    | 240328      | Bearing                                    |
| 6    | 2473WW      | Idler Spindle                              |
| 7    | 808-020     | Magnet .25" Dia. x .25" long               |
| 8    | 450226SSP   | Sleeve, .25" Magnet Stainless Steel        |
| 9    | 240426      | Head Plate RH                              |

|    |           |  |
|----|-----------|--|
| 10 | 920691M   | Socket Head Screw M6 x 10mm            |
| 11 | 240329    | Tension Slide Bar                      |
| 12 | 240420    | Rack Gear 14.5 Degree PA x 24P         |
| 13 | See Chart | Side Rail RH                           |
| 14 | See Chart | Center Rail                            |
| 15 | 2030WWM   | Pinion Gear                            |
| 16 | See Chart | Side Rail LH                           |
| 17 | 4564WW    | Drive Spindle 2" (51mm)                |
|    | 2476WW    | Nosebar Drive Spindle Lagged 2" (51mm) |
| 18 | 980422M   | Square Key 4mm x 22mm                  |

|  |                 |  |
|--|-----------------|--|
| 19   | See Chart       | Conveyor Bed Plate   |
| 20   | 807-1105        | Flat Head Torx Screw M6 x 10mm   |
| 21   | 22A- <u>WW</u>  | Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 17)                |
|  | 22D- <u>WW</u>  | Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 17)                |
| 22   | 22NA- <u>WW</u> | Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 17) |
|  | 22ND- <u>WW</u> | Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 17) |
| 23   | 22T- <u>WW</u>  | Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)   |
| <u>WW</u> = Conveyor width reference: 08, 10, 12 |                 |  |

| Item 13: Side Rail RH |                           |
|-----------------------|---------------------------|
| 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 |

| Item 14: Center Rail |                           |
|----------------------|---------------------------|
| 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 |

# Service Parts

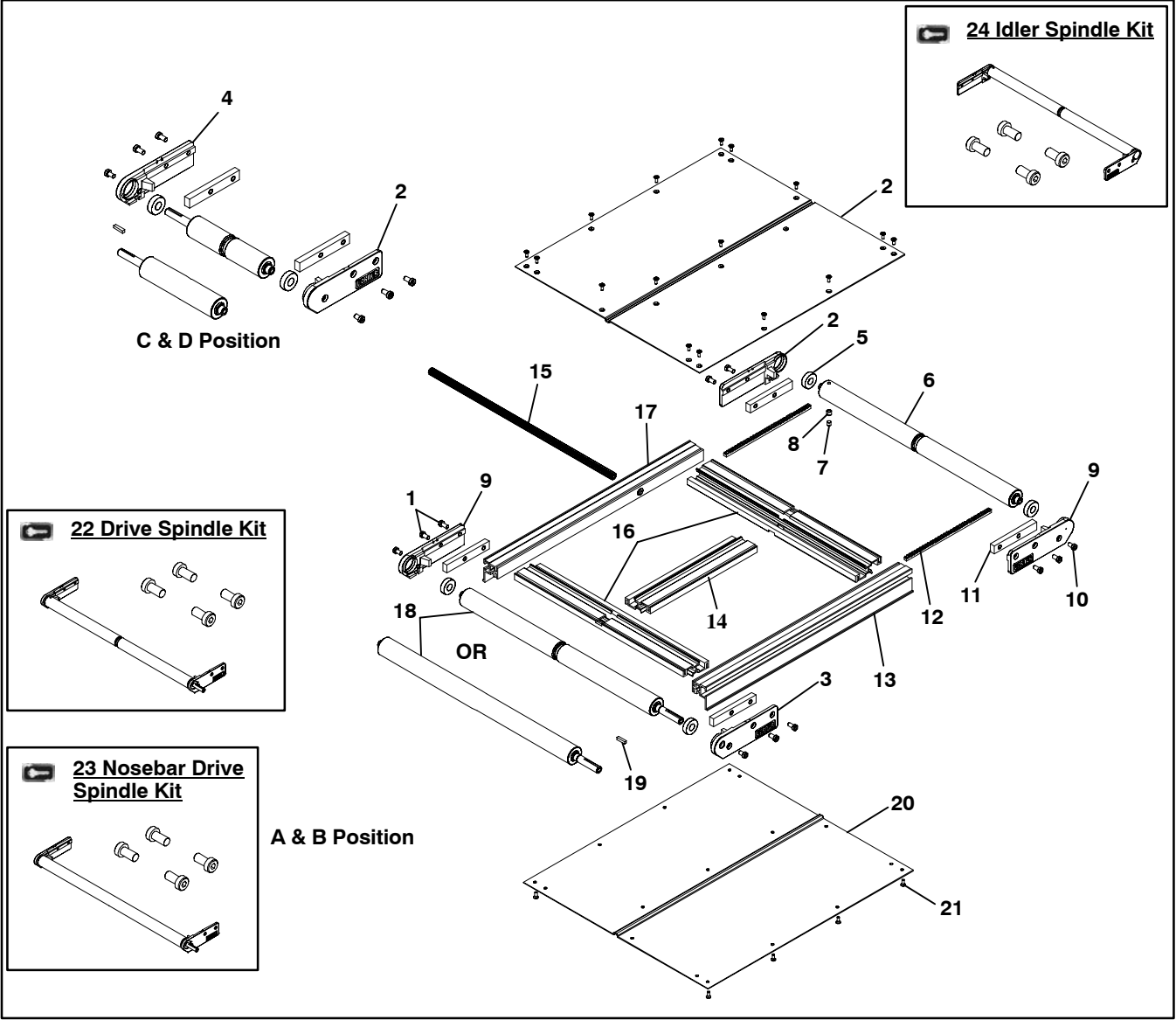
| Item 16: Side Rail LH |                           |
|-----------------------|---------------------------|
| Length                | Part Number               |
| 2' (610mm)            | 240413-01908              |
| 3' (914mm)            | 240413-03108              |
| 4' (1219mm)           | 240413-04308              |
| 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 |

| Item 17: Bed Plate |                           |
|--------------------|---------------------------|
| Length             | Part Number               |
| 2' (610mm)         | 2405WW-01900              |
| 3' (914mm)         | 2405WW-03100              |
| 4' (1219mm)        | 2405WW-04300              |
| 5' (1524mm)        | 2405WW-05500              |
| 6' (1829mm)        | 2405WW-06700              |
| 7' (2134mm)        | 2405WW-07900              |
| 8' (2438mm)        | 2405WW-09100              |
| 9' (2743mm)        | 2405WW-10300              |
| 10' (3048mm)       | 2405WW-11500              |
| 11' (3353mm)       | 2405WW-12700              |
| 12' (3658mm)       | 2405WW-13900              |
| 13' (3962mm)       | 2405WW-07196 2405WW-07900 |
| 14' (4267mm)       | 2405WW-07196 2405WW-09100 |
| 15' (4572mm)       | 2405WW-07196 2405WW-10300 |
| 16' (4877mm)       | 2405WW-07196 2405WW-11500 |
| 17' (5182mm)       | 2405WW-07196 2405WW-12700 |
| 18' (5486mm)       | 2405WW-07196 2405WW-13900 |

WW = Conveyor Width reference: 08, 10, 12



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



| Item | Part Number | Description                                |
|------|-------------|--|
| 1    | 920692M     | Socket Head Screw M6 x 12mm                |
| 2    | 240425      | Head Plate LH                              |
| 3    | 240427      | Head Plate LH Drive Side, Position A and B |
| 4    | 240428      | Head Plate RH Drive Side, Position C and D |
| 5    | 240328      | Bearing                                    |
| 6    | 2473WW      | Idler Spindle                              |
| 7    | 808-020     | Magnet .25" Dia. x .25" long               |
| 8    | 450226SSP   | Sleeve, .25" Magnet Stainless Steel        |
| 9    | 240426      | Head Plate RH                              |
| 10   | 920691M     | Socket Head Screw M6 x 10mm                |

|    |           |  |
|----|-----------|--|
| 11 | 240329    | Tension Slide Bar                      |
| 12 | 240420    | Rack Gear 14.5 Degree PA x 24 P        |
| 13 | See Chart | Side Rail RH                           |
| 14 | See Chart | Center Rail                            |
| 15 | 2030WWM   | Pinion Gear                            |
| 16 | 240417    | Center Rail Cross Support 18" (457mm)  |
|    | 240418    | Center Rail Cross Support 21" (533mm)  |
|    | 240419    | Center Rail Cross Support 24" (610mm)  |
| 17 | See Chart | Side Rail LH                           |
| 18 | 4564WW    | Drive Spindle 2" (51mm)                |
|    | 2476WW    | Nosebar Drive Spindle Lagged 2" (51mm) |
| 19 | 980422M   | Square Key 4mm x 22mm                  |

# Service Parts

|  |                 |  |
|--|-----------------|--|
| 20   | See Chart       | Conveyor Bed Plate   |
| 21   | 807-1105        | Flat Head Torx Screw M6 x 10mm   |
| 22   | 22A- <u>WW</u>  | Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 18)                |
|  | 22D- <u>WW</u>  | Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 18)                |
| 23   | 22NA- <u>WW</u> | Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 18) |
|  | 22ND- <u>WW</u> | Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 18) |
| 24   | 22T- <u>WW</u>  | Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)   |
| <u>WW</u> = Conveyor width reference: 18, 21, 24 |                 |  |

| Item 13: Side Rail RH |                           |
|-----------------------|---------------------------|
| 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 |

| Item 14: Center Rail |                           |
|----------------------|---------------------------|
| Length               | Part Number               |
| 2' (610mm)           | 240414-00998              |
| 3' (914mm)           | 240414-02198              |
| 4' (1219mm)          | 240414-03398              |
| 5' (1524mm)          | 240414-04598              |
| 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)         | 240414-06600 240414-06998 |
| 14' (4267mm)         | 240414-06600 240414-08198 |
| 15' (4572mm)         | 240414-06600 240414-09398 |
| 16' (4877mm)         | 240414-06600 240414-10598 |
| 17' (5182mm)         | 240414-06600 240414-11798 |
| 18' (5486mm)         | 240414-06600 240414-12998 |

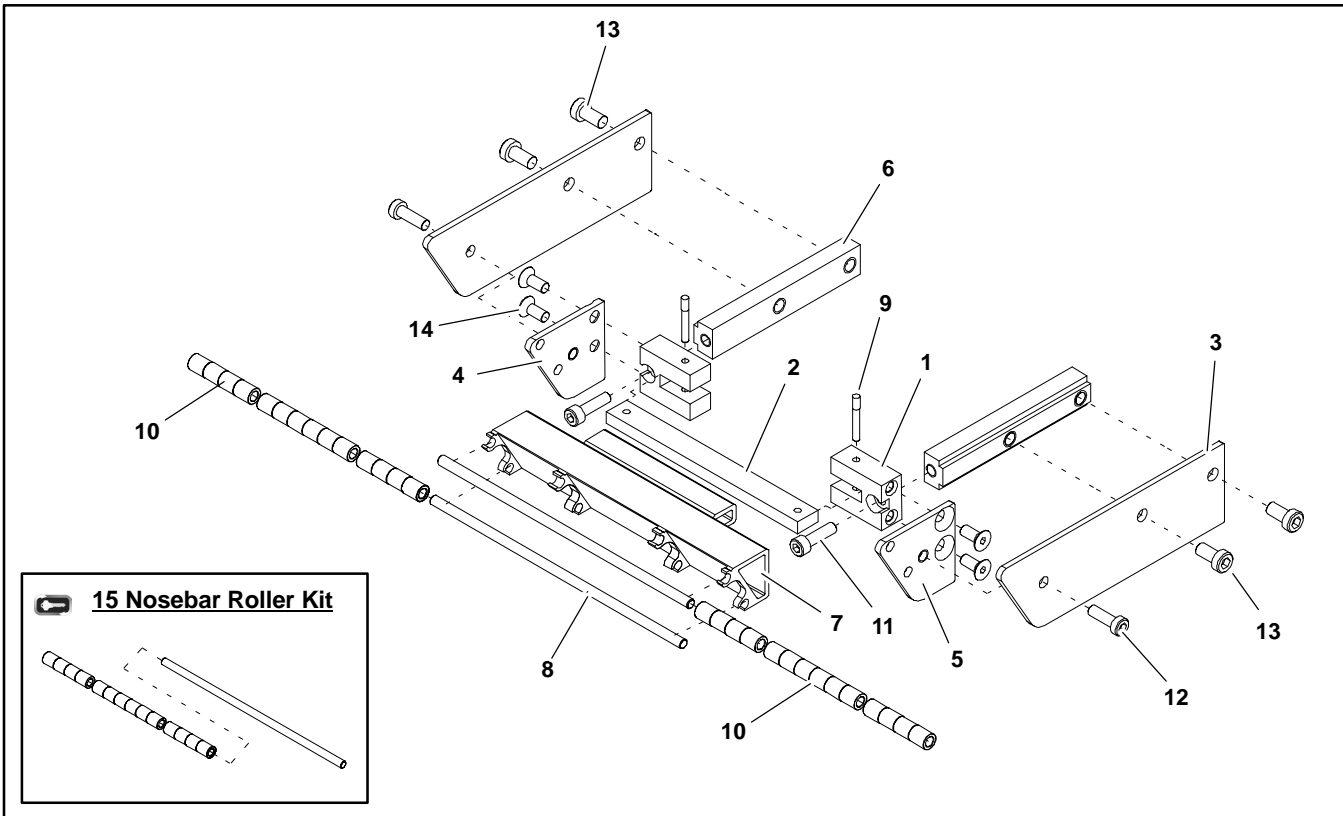
# Service Parts

| Item 16: Side Rail LH |                           |
|-----------------------|---------------------------|
| 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 |

| Item 17: Bed Plate                        |                           |
|---|---------------------------|
| Length                                    | Part Number               |
| 2' (610mm)                                | 2405WW-01900              |
| 3' (914mm)                                | 2405WW-03100              |
| 4' (1219mm)                               | 2405WW-04300              |
| 5' (1524mm)                               | 2405WW-05500              |
| 6' (1829mm)                               | 2405WW-06700              |
| 7' (2134mm)                               | 2405WW-07900              |
| 8' (2438mm)                               | 2405WW-09100              |
| 9' (2743mm)                               | 2405WW-10300              |
| 10' (3048mm)                              | 2405WW-11500              |
| 11' (3353mm)                              | 2405WW-12700              |
| 12' (3658mm)                              | 2405WW-13900              |
| 13' (3962mm)                              | 2405WW-07196 2405WW-07900 |
| 14' (4267mm)                              | 2405WW-07196 2405WW-09100 |
| 15' (4572mm)                              | 2405WW-07196 2405WW-10300 |
| 16' (4877mm)                              | 2405WW-07196 2405WW-11500 |
| 17' (5182mm)                              | 2405WW-07196 2405WW-12700 |
| 18' (5486mm)                              | 2405WW-07196 2405WW-13900 |
| WW = Conveyor Width reference: 18, 21, 24 |                           |

# Service Parts

## Nosebar End Assembly

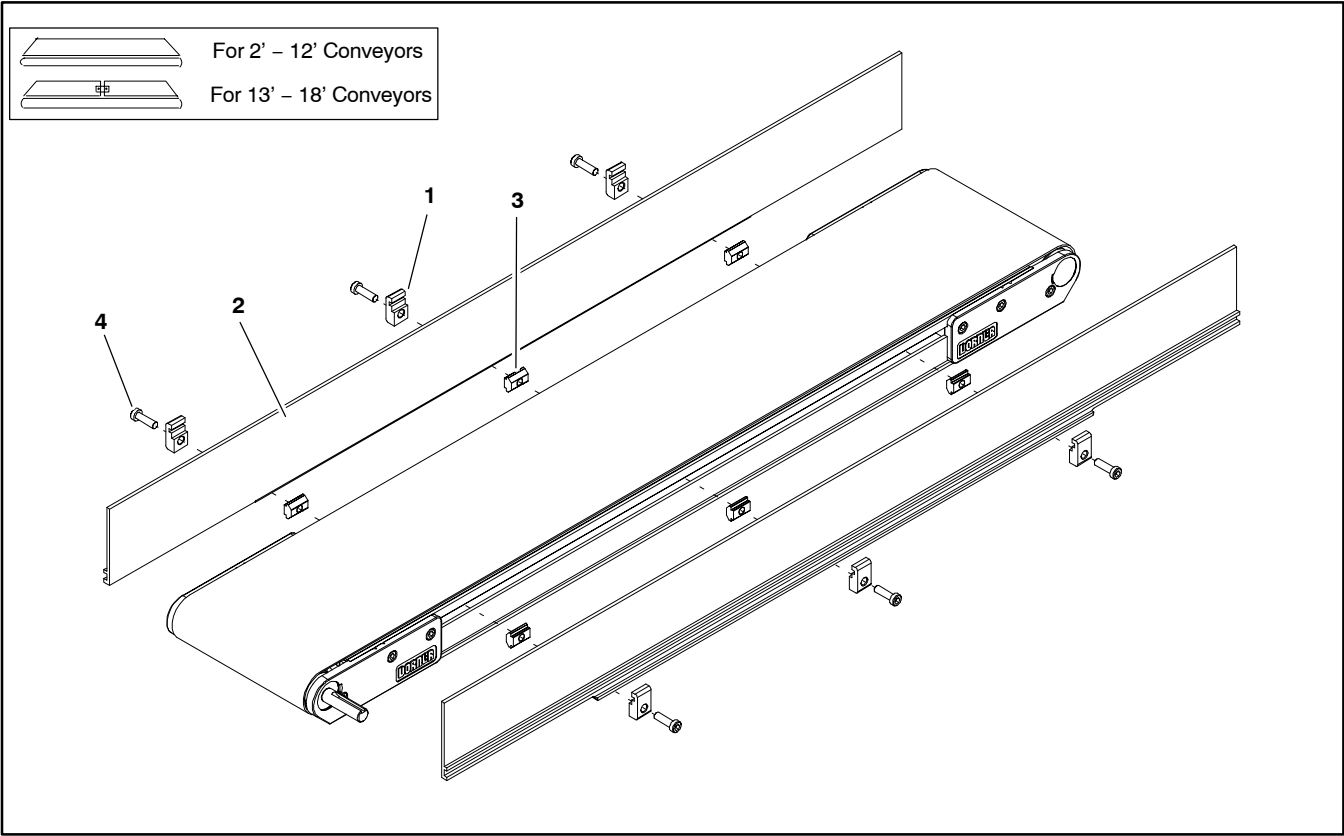


| Item | Part Number | Description                    |
|------|-------------|--------------------------------|
| 1    | 201965M     | Mounting Block, PLT Spindle    |
| 2    | 2076WW      | Flex-Link Bar                  |
| 3    | 241125      | Outer Side Plate               |
| 4    | 241126      | Inner Side Plate LH            |
| 5    | 241127      | Inner Side Plate RH            |
| 6    | 241128      | Head Plate Bar                 |
| 7    | 2412WW      | Nosebar                        |
| 8    | 2413WW      | Nosebar Rod                    |
| 9    | 200695P     | Knurl Pin .125" DIA x .937" Lg |

|    |         |  |
|----|---------|--|
| 10 | 801-122 | Nose Bar Roller                              |
| 11 | 920518M | Socket Head Screw M5 x 18mm                  |
| 12 | 920593M | Socket Head Screw M5 x 16mm                  |
| 13 | 920692M | Socket Head Screw M6 x 12mm                  |
| 14 | 930512M | Flat Head Screw M5 x 12mm                    |
| 15 | 22N-WW  | Nosebar Roller Kit (Includes Items 8 and 10) |

WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24

**-04 3" (76mm) Aluminum Side**



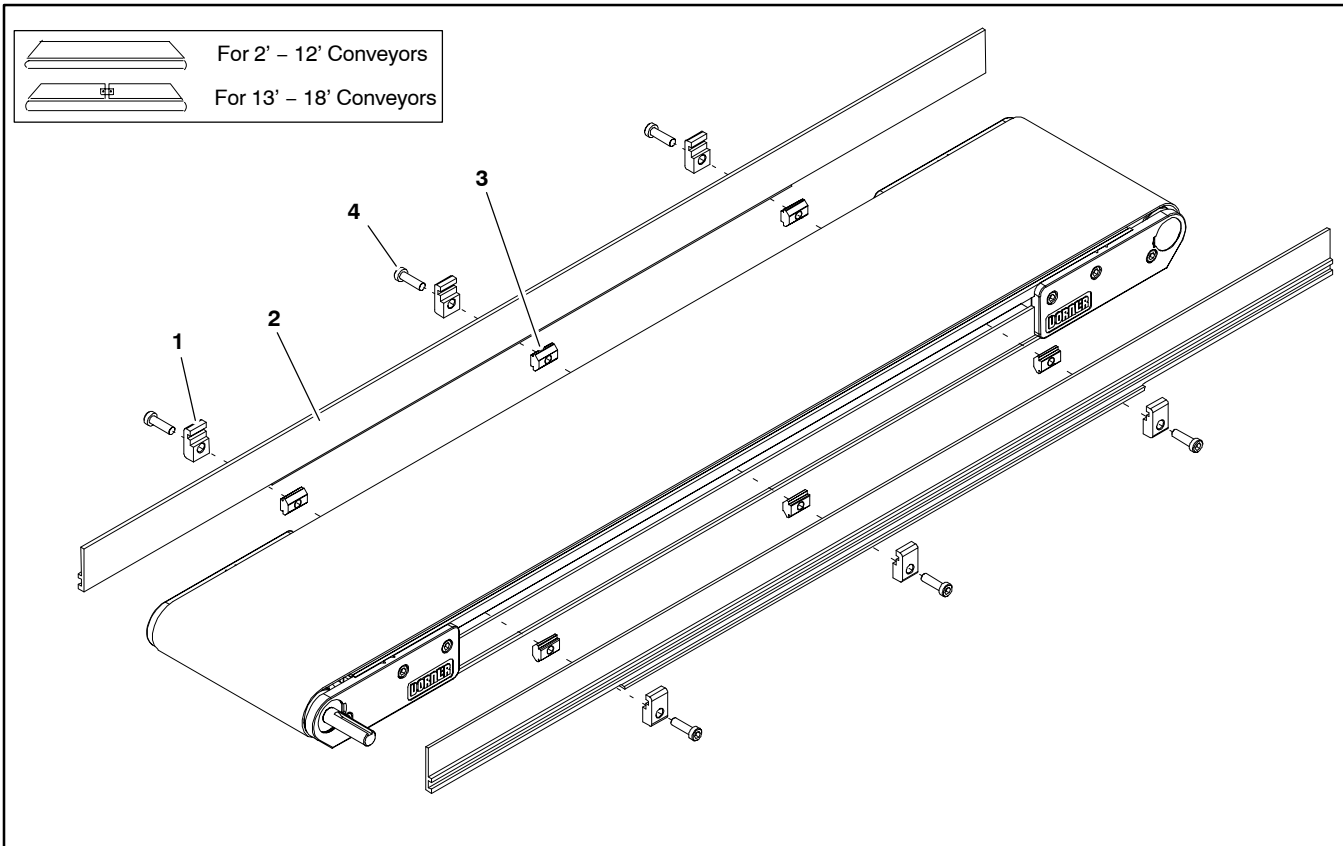
| Item | Part Number     | Description                 |
|------|-----------------|-----------------------------|
| 1    | 200121          | Guide Retaining Clip        |
| 2    | See Chart Below | 2200 Guide 3" (76mm) HS     |
| 3    | 200695P         | Single Drop-in Tee Bar      |
| 4    | 920694M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

|              |            |              |              |
|--------------|------------|--------------|--------------|
| 9' (2743mm)  | Right Hand | 280403-09600 | N/A          |
|              | Left Hand  | 280403-10800 | N/A          |
| 10' (3048mm) | Right Hand | 280403-10800 | N/A          |
|              | Left Hand  | 280403-12000 | N/A          |
| 11' (3353mm) | Right Hand | 280403-12000 | N/A          |
|              | Left Hand  | 280403-13200 | N/A          |
| 12' (3658mm) | Right Hand | 280403-13200 | N/A          |
|              | Left Hand  | 280403-14400 | N/A          |
| 13' (3962mm) | Right Hand | 280403-14400 | N/A          |
|              | Left Hand  | 280401-07500 | 280401-08100 |
| 14' (4267mm) | Right Hand | 280402-07500 | 280402-08100 |
|              | Left Hand  | 280401-07500 | 280401-09300 |
| 15' (4572mm) | Right Hand | 280402-07500 | 280402-09300 |
|              | Left hand  | 280401-07500 | 280401-10500 |
| 16' (4877mm) | Right Hand | 280402-07500 | 280402-10500 |
|              | Left Hand  | 280401-07500 | 280401-11700 |
| 17' (5182mm) | Right Hand | 280402-07500 | 280402-11700 |
|              | Left Hand  | 280401-07500 | 280401-12900 |
| 18' (5486mm) | Right Hand | 280402-07500 | 280402-12900 |
|              | Left Hand  | 280401-07500 | 280401-14100 |
|              | Right Hand | 280402-07500 | 280402-14100 |
|              | Left Hand  | 280401-07500 | 280401-14100 |

# Service Parts

## -05 1.5" (38mm) Aluminum Side

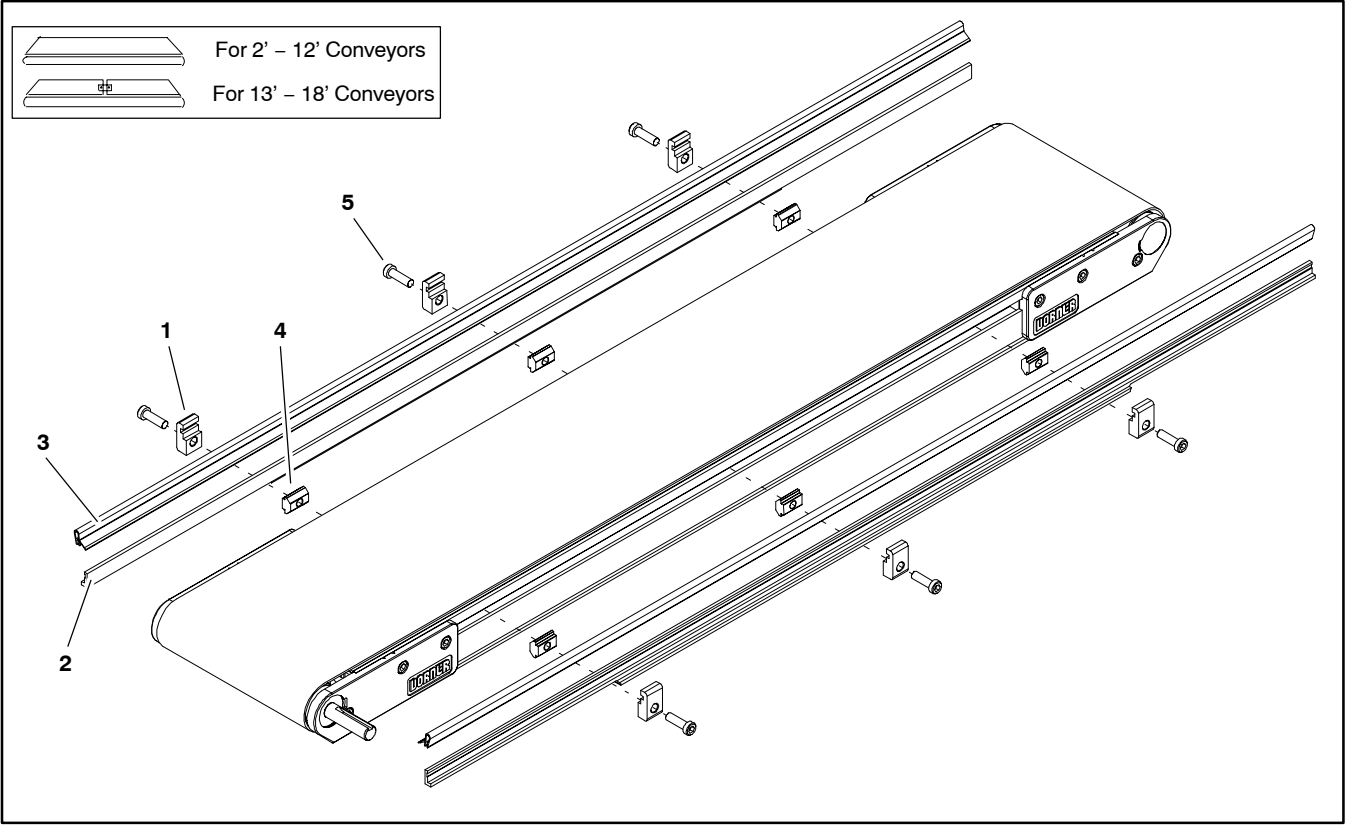


| Item | Part Number     | Description                 |
|------|-----------------|-----------------------------|
| 1    | 200121          | Guide Retaining Clip        |
| 2    | See Chart Below | 2200 Guide .5" (13mm) HS    |
| 3    | 639971M         | Single Drop-in Tee Bar      |
| 4    | 920694M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

|              |            |              |              |
|--------------|------------|--------------|--------------|
| 9' (2743mm)  | Right Hand | 280503-09600 | N/A          |
|              | Left Hand  | 280503-10800 | N/A          |
| 10' (3048mm) | Right Hand | 280503-10800 | N/A          |
|              | Left Hand  | 280503-12000 | N/A          |
| 11' (3353mm) | Right Hand | 280503-12000 | N/A          |
|              | Left Hand  | 280503-13200 | N/A          |
| 12' (3658mm) | Right Hand | 280503-13200 | N/A          |
|              | Left Hand  | 280503-14400 | N/A          |
| 13' (3962mm) | Right Hand | 280503-14400 | N/A          |
|              | Left Hand  | 280501-07500 | 280501-08100 |
| 14' (4267mm) | Right Hand | 280502-07500 | 280502-08100 |
|              | Left Hand  | 280501-07500 | 280501-09300 |
| 15' (4572mm) | Right Hand | 280502-07500 | 280502-09300 |
|              | Left hand  | 280501-07500 | 280501-10500 |
| 16' (4877mm) | Right Hand | 280502-07500 | 280502-10500 |
|              | Left Hand  | 280501-07500 | 280501-11700 |
| 17' (5182mm) | Right Hand | 280502-07500 | 280502-11700 |
|              | Left Hand  | 280501-07500 | 280501-12900 |
| 18' (5486mm) | Right Hand | 280502-07500 | 280502-12900 |
|              | Left Hand  | 280501-07500 | 280501-14100 |
|              | Right Hand | 280502-07500 | 280502-14100 |
|              | Left Hand  | 280501-07500 | 280501-14100 |

## -07 Low to Side Wiper



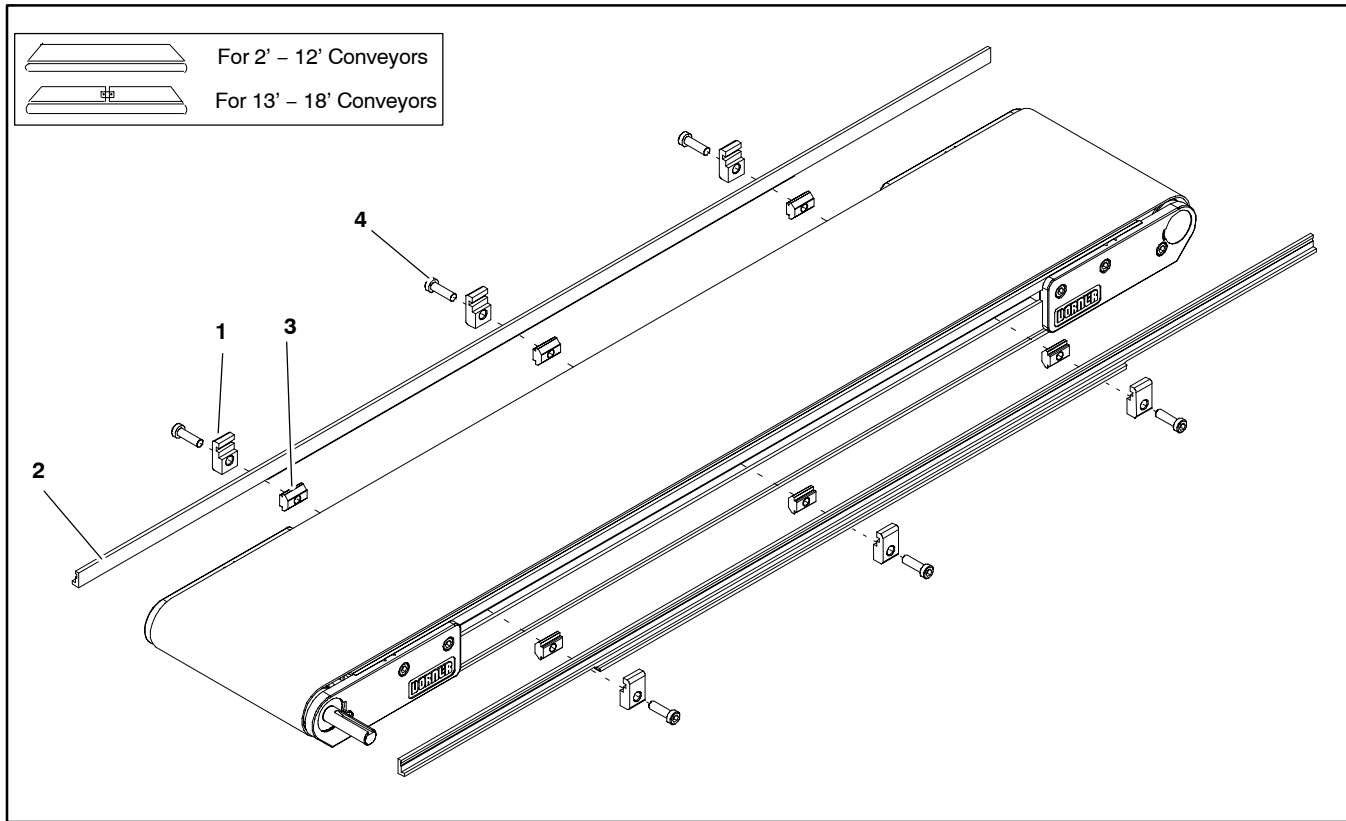
| Item | Part Number     | Description                    |
|------|-----------------|--------------------------------|
| 1    | 200121          | Guide Retaining Clip           |
| 2    | See Chart Below | 2200 Guide .5" (13mm) HS       |
| 3    | 41-00-24        | Side Wiper Nylatron (per foot) |
| 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       |

|              |            |              |              |
|--------------|------------|--------------|--------------|
| 9' (2743mm)  | Right Hand | 280903-09600 | N/A          |
|              | Left Hand  | 280903-10800 | N/A          |
| 10' (3048mm) | Right Hand | 280903-10800 | N/A          |
|              | Left Hand  | 280903-12000 | N/A          |
| 11' (3353mm) | Right Hand | 280903-12000 | N/A          |
|              | Left Hand  | 280903-13200 | N/A          |
| 12' (3658mm) | Right Hand | 280903-13200 | N/A          |
|              | Left Hand  | 280903-14400 | N/A          |
| 13' (3962mm) | Right Hand | 280903-14400 | N/A          |
|              | Left Hand  | 280901-07500 | 280901-08100 |
| 14' (4267mm) | Right Hand | 280902-07500 | 280902-08100 |
|              | Left Hand  | 280901-07500 | 280901-09300 |
| 15' (4572mm) | Right Hand | 280902-07500 | 280902-09300 |
|              | Left hand  | 280901-07500 | 280901-10500 |
| 16' (4877mm) | Right Hand | 280902-07500 | 280902-10500 |
|              | Left Hand  | 280901-07500 | 280901-11700 |
| 17' (5182mm) | Right Hand | 280902-07500 | 280902-11700 |
|              | Left Hand  | 280901-07500 | 280901-12900 |
| 18' (5486mm) | Right Hand | 280902-07500 | 280902-12900 |
|              | Left Hand  | 280901-07500 | 280901-14100 |
|              | Right Hand | 280902-07500 | 280902-14100 |

# Service Parts

## -09 Low to High Side



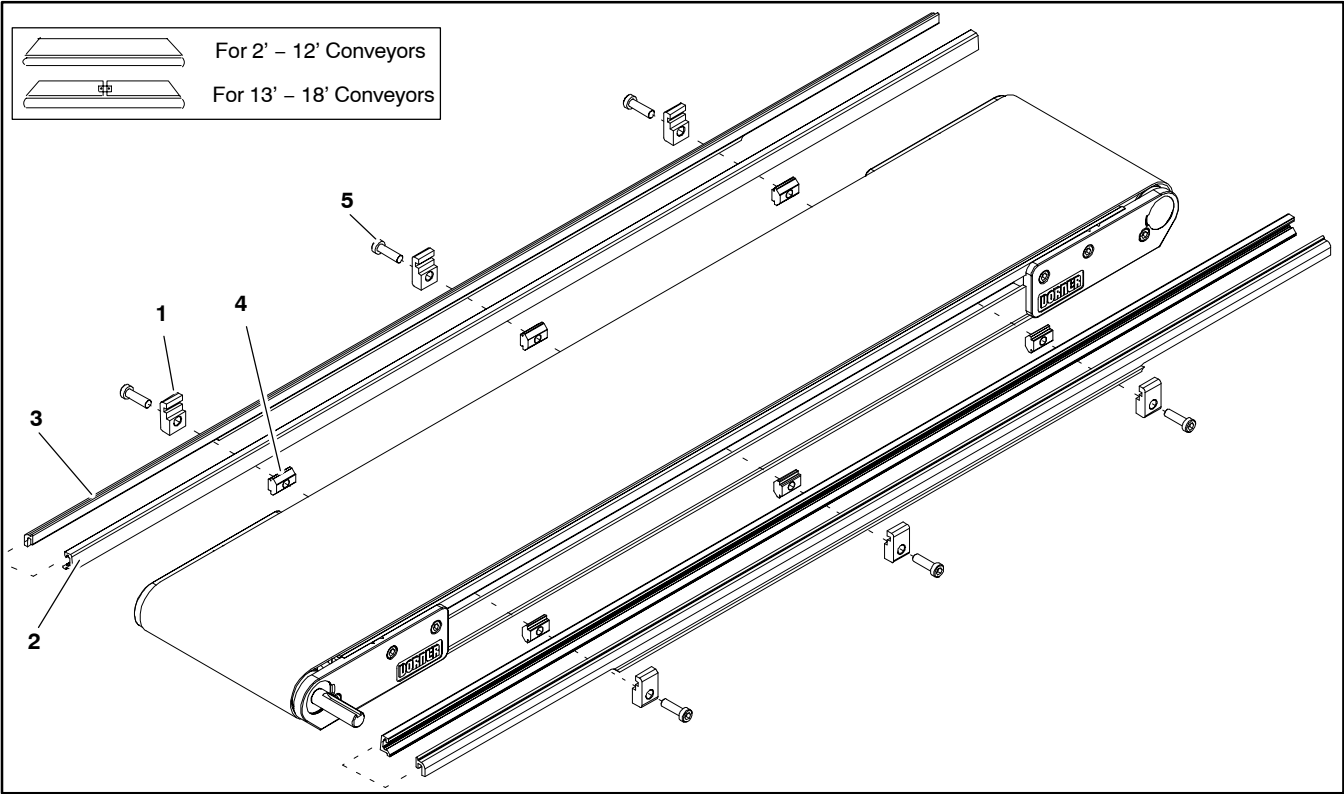
| Item | Part Number     | Description                 |
|------|-----------------|-----------------------------|
| 1    | 200121          | Guide Retaining Clip        |
| 2    | See Chart Below | 2200 Guide .5" (13mm) HS    |
| 3    | 639971M         | Single Drop-in Tee Bar      |
| 4    | 920694M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

|              |            |              |              |
|--------------|------------|--------------|--------------|
| 9' (2743mm)  | Right Hand | 280903-09600 | N/A          |
|              | Left Hand  | 280903-10800 | N/A          |
| 10' (3048mm) | Right Hand | 280903-10800 | N/A          |
|              | Left Hand  | 280903-12000 | N/A          |
| 11' (3353mm) | Right Hand | 280903-12000 | N/A          |
|              | Left Hand  | 280903-13200 | N/A          |
| 12' (3658mm) | Right Hand | 280903-13200 | N/A          |
|              | Left Hand  | 280903-14400 | N/A          |
| 13' (3962mm) | Right Hand | 280903-14400 | N/A          |
|              | Left Hand  | 280901-07500 | 280901-08100 |
| 14' (4267mm) | Right Hand | 280902-07500 | 280902-08100 |
|              | Left Hand  | 280901-07500 | 280901-09300 |
| 15' (4572mm) | Right Hand | 280902-07500 | 280902-09300 |
|              | Left hand  | 280901-07500 | 280901-10500 |
| 16' (4877mm) | Right Hand | 280902-07500 | 280902-10500 |
|              | Left Hand  | 280901-07500 | 280901-11700 |
| 17' (5182mm) | Right Hand | 280902-07500 | 280902-11700 |
|              | Left Hand  | 280901-07500 | 280901-12900 |
| 18' (5486mm) | Right Hand | 280902-07500 | 280902-12900 |
|              | Left Hand  | 280901-07500 | 280901-14100 |
| 18' (5486mm) | Right Hand | 280902-07500 | 280902-14100 |
|              | Left Hand  | 280901-07500 | 280901-14100 |



**-10 .5" (13mm) Extruded Plastic**



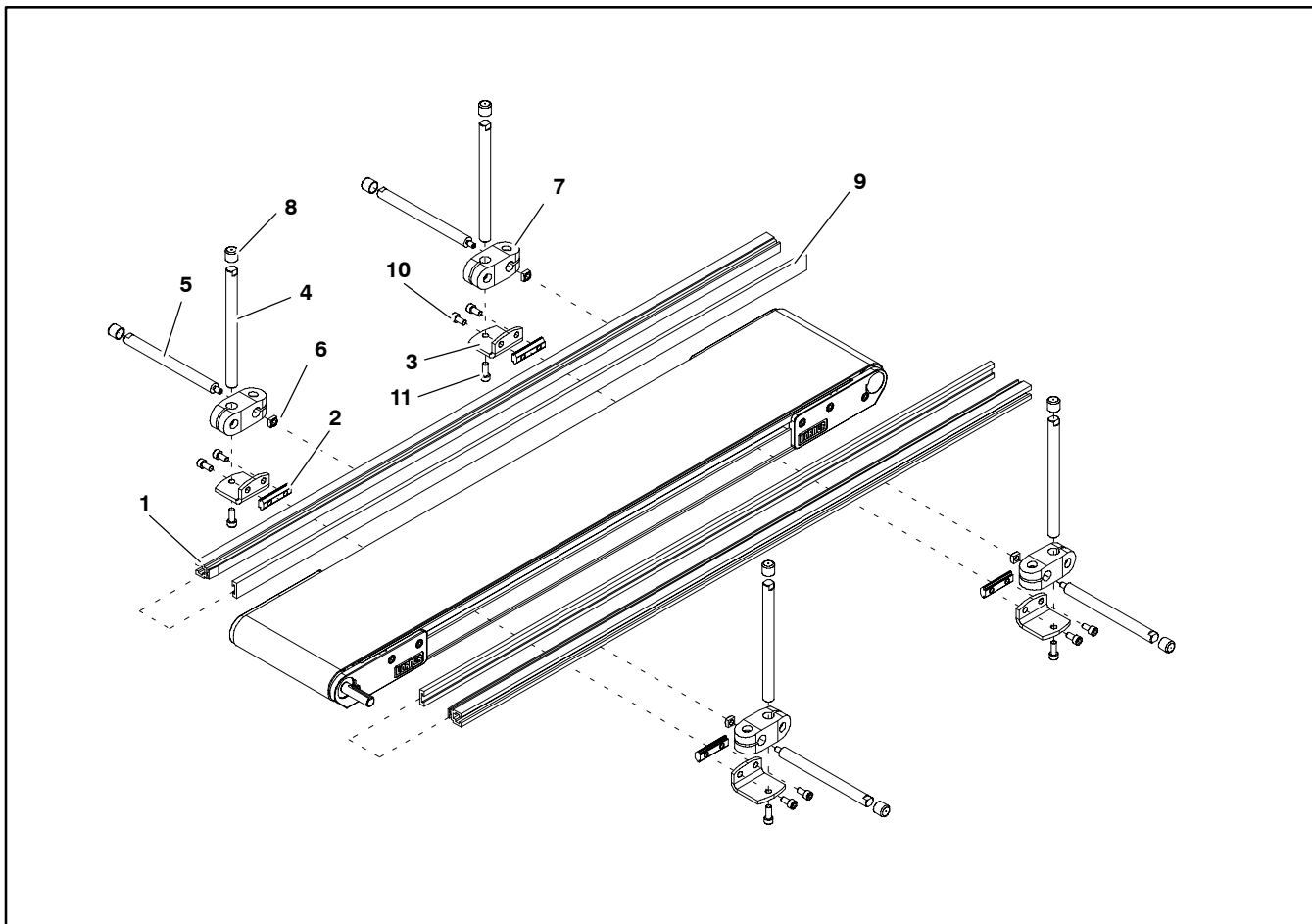
| Item | Part Number     | Description                 |
|------|-----------------|-----------------------------|
| 1    | 200121          | Guide Retaining Clip        |
| 2    | 200054P         | Snap-On Guide (per foot)    |
| 3    | See Chart Below | 2200 Guide                  |
| 4    | 639971M         | 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 |

# Service Parts

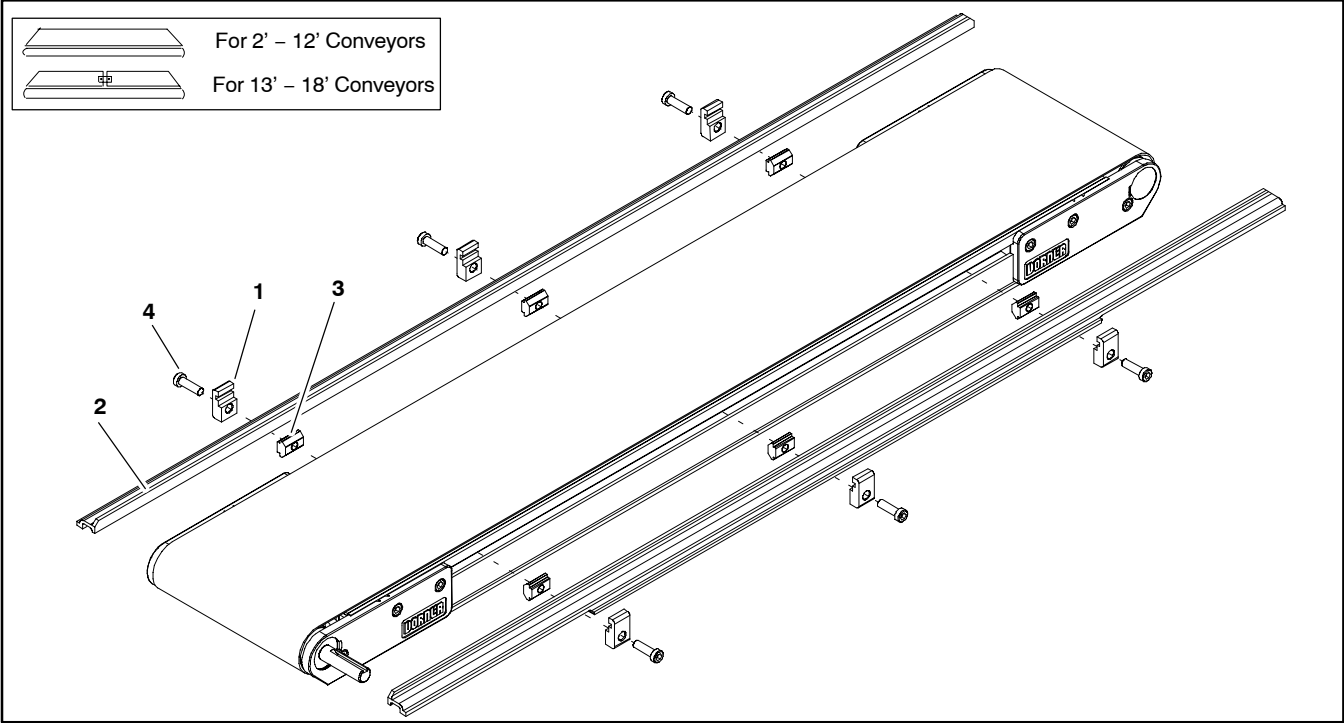
## -13 Adjustable Guiding



| 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     |

## 0.5" (13mm) Cleated Belt Guiding



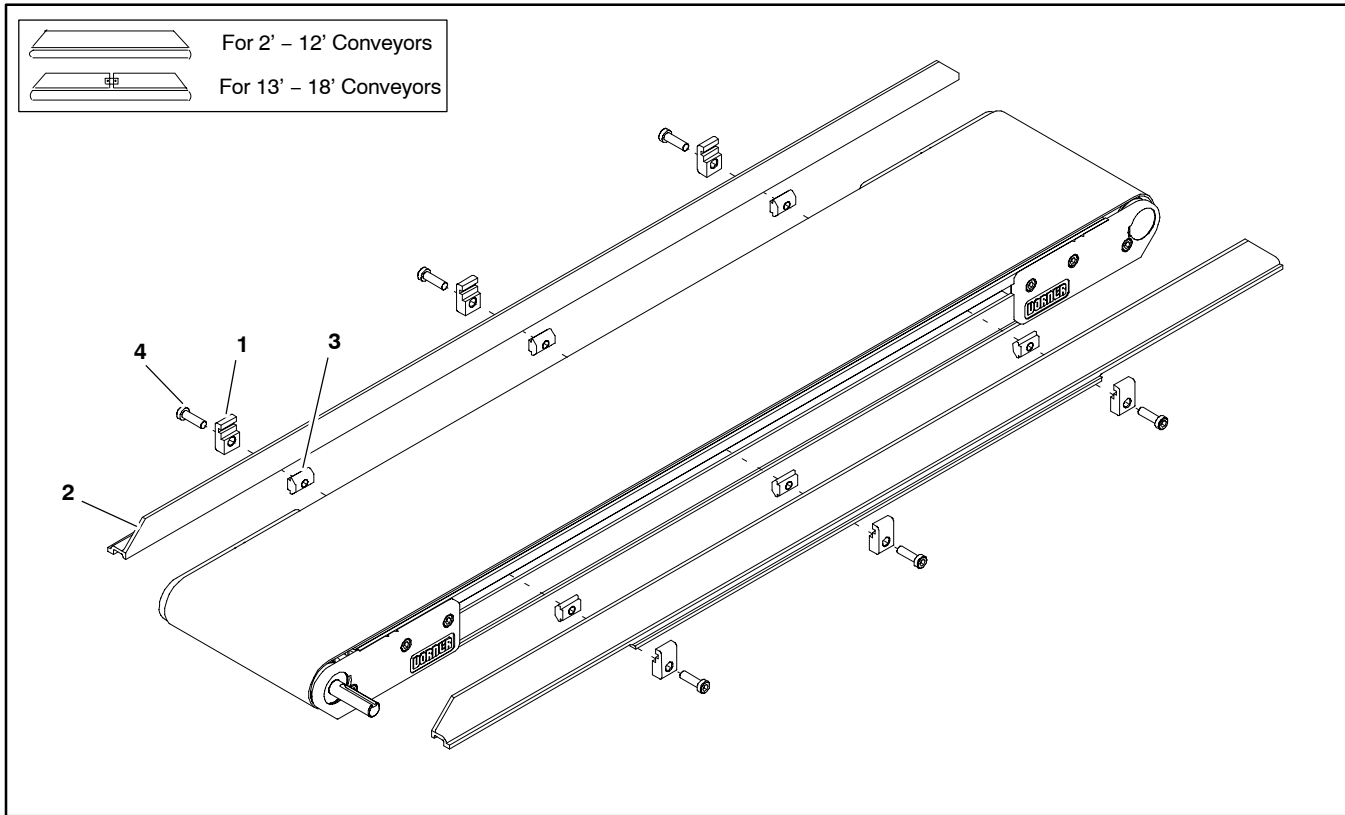
| Item | Part Number     | Description                    |
|------|-----------------|--------------------------------|
| 1    | 200121          | Guide Retaining Clip           |
| 2    | See Chart Below | 2200 Guide .47" (13mm) Cleated |
| 3    | 639971M         | Drop-In Tee Bar                |
| 4    | 920694M         | Socket Head Screw M6 x 20mm    |

| Item 2: 2200 Guide |            |              |           |
|--------------------|------------|--------------|-----------|
| Length             |            | End Guide    | End Guide |
| 2' (610mm)         | Left Hand  | 281603-02256 | N/A       |
|                    | Right Hand | 281603-02256 | N/A       |
| 3' (914mm)         | Left Hand  | 281603-03456 | N/A       |
|                    | Right Hand | 281603-03456 | N/A       |
| 4' (1219mm)        | Left Hand  | 281603-04656 | N/A       |
|                    | Right Hand | 281603-04656 | N/A       |
| 5' (1524mm)        | Left Hand  | 281603-05856 | N/A       |
|                    | Right Hand | 281603-05856 | N/A       |
| 6' (1829mm)        | Left Hand  | 281603-07056 | N/A       |
|                    | Right Hand | 281603-07056 | N/A       |
| 7' (2134mm)        | Left Hand  | 281603-08256 | N/A       |
|                    | Right Hand | 281603-08256 | N/A       |
| 8' (2438mm)        | Left Hand  | 281603-09456 | N/A       |

|              |            |              |              |
|--------------|------------|--------------|--------------|
| 9' (2743mm)  | Right Hand | 281603-09456 | N/A          |
|              | Left Hand  | 281603-10656 | N/A          |
| 10' (3048mm) | Right Hand | 281603-10656 | N/A          |
|              | Left Hand  | 281603-11856 | N/A          |
| 11' (3353mm) | Right Hand | 281603-11856 | N/A          |
|              | Left Hand  | 281603-13056 | N/A          |
| 12' (3658mm) | Right Hand | 281603-13056 | N/A          |
|              | Left Hand  | 281603-14256 | N/A          |
| 13' (3962mm) | Right Hand | 281603-14256 | N/A          |
|              | Left Hand  | 281601-07428 | 281601-08028 |
| 14' (4267mm) | Right Hand | 281602-07428 | 281602-08028 |
|              | Left Hand  | 281601-07428 | 281601-09228 |
| 15' (4572mm) | Right Hand | 281602-07428 | 281602-09228 |
|              | Left hand  | 281601-07428 | 281601-10428 |
| 16' (4877mm) | Right Hand | 281602-07428 | 281602-10428 |
|              | Left Hand  | 281601-07428 | 281601-11628 |
| 17' (5182mm) | Right Hand | 281602-07428 | 281602-11628 |
|              | Left Hand  | 281601-07428 | 281601-12828 |
| 18' (5486mm) | Right Hand | 281602-07428 | 281602-12828 |
|              | Left Hand  | 281601-07428 | 281601-14028 |
|              | Right Hand | 281602-07428 | 281602-14028 |

# Service Parts

## 1" (25mm) Cleated Belt Guiding

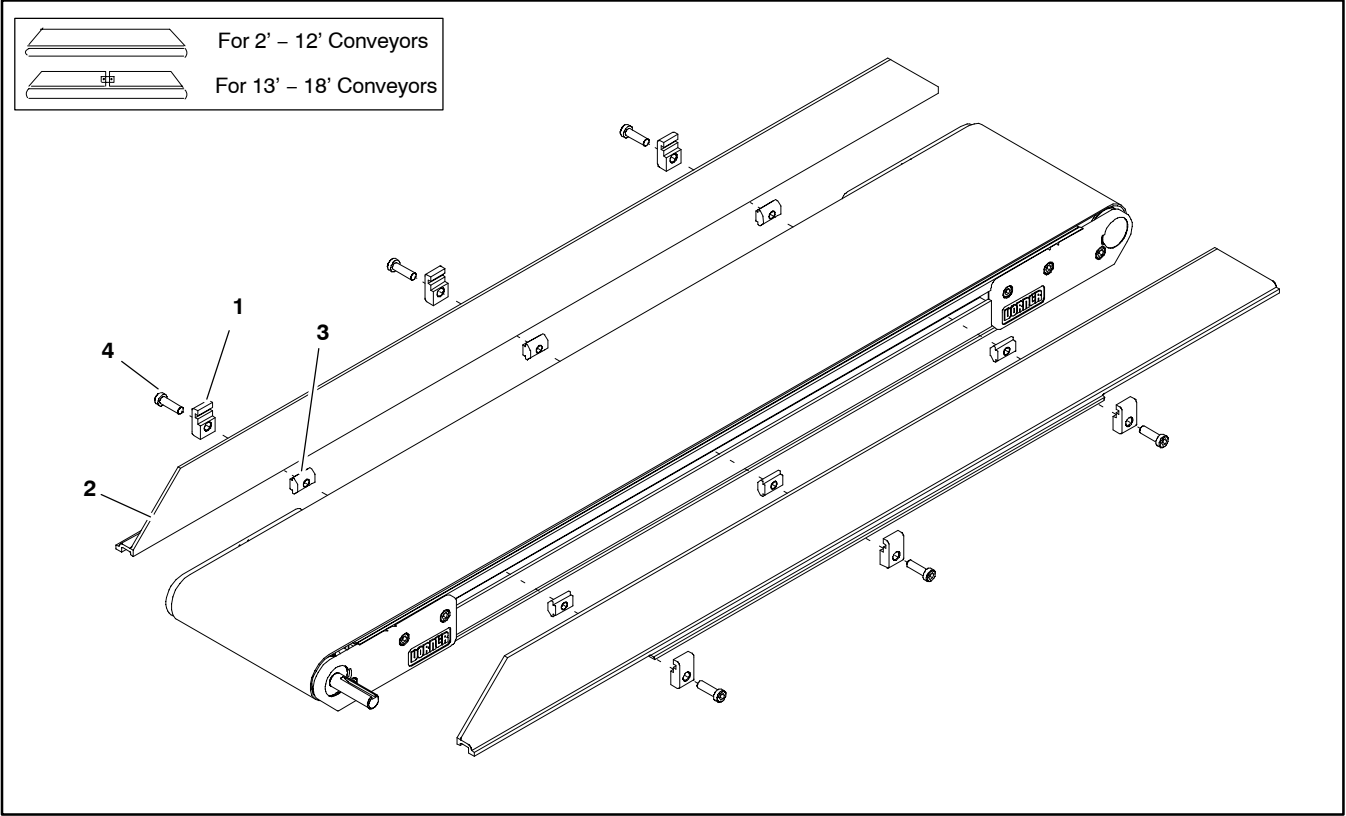


| Item | Part Number     | Description                  |
|------|-----------------|------------------------------|
| 1    | 200121          | Guide Retaining Clip         |
| 2    | See Chart Below | 2200 Guide 1" (25mm) Cleated |
| 3    | 639971M         | Drop-In Tee Bar              |
| 4    | 920694M         | Socket Head Screw M6 x 20mm  |

| Item 2: 2200 Guide |            |              |           |
|--------------------|------------|--------------|-----------|
| Length             |            | End Guide    | End Guide |
| 2' (610mm)         | Left Hand  | 281703-02256 | N/A       |
|                    | Right Hand | 281703-02256 | N/A       |
| 3' (914mm)         | Left Hand  | 281703-03456 | N/A       |
|                    | Right Hand | 281703-03456 | N/A       |
| 4' (1219mm)        | Left Hand  | 281703-04656 | N/A       |
|                    | Right Hand | 281703-04656 | N/A       |
| 5' (1524mm)        | Left Hand  | 281703-05856 | N/A       |
|                    | Right Hand | 281703-05856 | N/A       |
| 6' (1829mm)        | Left Hand  | 281703-07056 | N/A       |
|                    | Right Hand | 281703-07056 | N/A       |
| 7' (2134mm)        | Left Hand  | 281703-08256 | N/A       |
|                    | Right Hand | 281703-08256 | N/A       |
| 8' (2438mm)        | Left Hand  | 281703-09456 | N/A       |

|              |            |              |              |
|--------------|------------|--------------|--------------|
| 9' (2743mm)  | Right Hand | 281703-09456 | N/A          |
|              | Left Hand  | 281703-10656 | N/A          |
| 10' (3048mm) | Right Hand | 281703-10656 | N/A          |
|              | Left Hand  | 281703-11856 | N/A          |
| 11' (3353mm) | Right Hand | 281703-11856 | N/A          |
|              | Left Hand  | 281703-13056 | N/A          |
| 12' (3658mm) | Right Hand | 281703-13056 | N/A          |
|              | Left Hand  | 281703-14256 | N/A          |
| 13' (3962mm) | Right Hand | 281703-14256 | N/A          |
|              | Left Hand  | 281701-07428 | 281701-08028 |
| 14' (4267mm) | Right Hand | 281702-07428 | 281702-08028 |
|              | Left Hand  | 281701-07428 | 281701-09228 |
| 15' (4572mm) | Right Hand | 281702-07428 | 281702-09228 |
|              | Left hand  | 281701-07428 | 281701-10428 |
| 16' (4877mm) | Right Hand | 281702-07428 | 281702-10428 |
|              | Left Hand  | 281701-07428 | 281701-11628 |
| 17' (5182mm) | Right Hand | 281702-07428 | 281702-11628 |
|              | Left Hand  | 281701-07428 | 281701-12828 |
| 18' (5486mm) | Right Hand | 281702-07428 | 281702-12828 |
|              | Left Hand  | 281701-07428 | 281701-14028 |
| 19' (5791mm) | Right Hand | 281702-07428 | 281702-14028 |
|              | Left Hand  | 281701-07428 | 281701-15228 |

## 2" (51mm) Cleated Belt Guiding



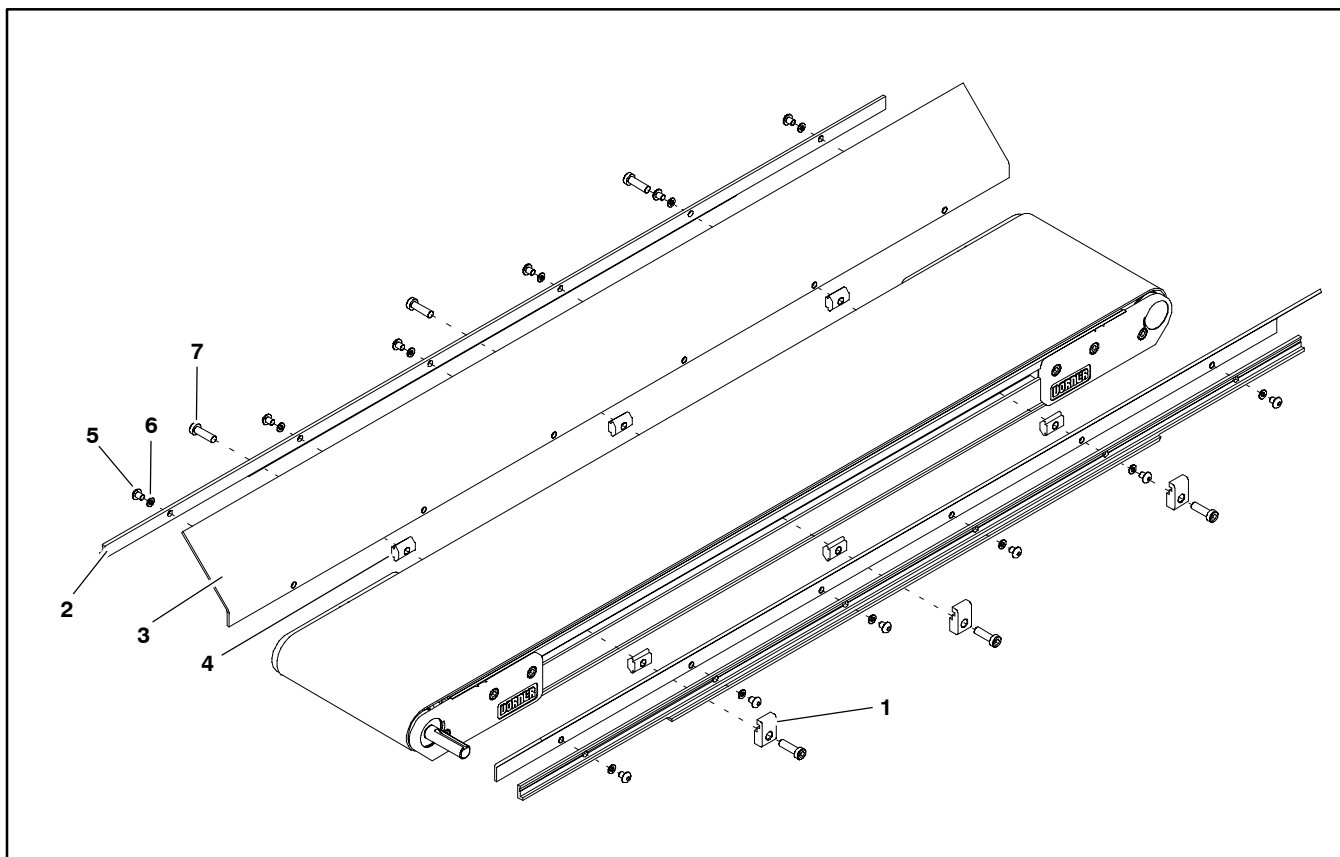
| Item | Part Number     | Description                 |
|------|-----------------|-----------------------------|
| 1    | 200121          | Guide Retaining Clip        |
| 2    | See Chart Below | 2200 Guide 2.3" Cleated     |
| 3    | 639971M         | Drop-In Tee Bar             |
| 4    | 920694M         | Socket Head Screw M6 x 20mm |

| Item 2: 2200 Guide |            |              |           |
|--------------------|------------|--------------|-----------|
| Length             |            | End Guide    | End Guide |
| 2' (610mm)         | Left Hand  | 281903-02256 | N/A       |
|                    | Right Hand | 281903-02256 | N/A       |
| 3' (914mm)         | Left Hand  | 281903-03456 | N/A       |
|                    | Right Hand | 281903-03456 | N/A       |
| 4' (1219mm)        | Left Hand  | 281903-04656 | N/A       |
|                    | Right Hand | 281903-04656 | N/A       |
| 5' (1524mm)        | Left Hand  | 281903-05856 | N/A       |
|                    | Right Hand | 281903-05856 | N/A       |
| 6' (1829mm)        | Left Hand  | 281903-07056 | N/A       |
|                    | Right Hand | 281903-07056 | N/A       |
| 7' (2134mm)        | Left Hand  | 281903-08256 | N/A       |
|                    | Right Hand | 281903-08256 | N/A       |
| 8' (2438mm)        | Left Hand  | 281903-09456 | N/A       |

|              |            |              |              |
|--------------|------------|--------------|--------------|
| 9' (2743mm)  | Right Hand | 281903-09456 | N/A          |
|              | Left Hand  | 281903-10656 | N/A          |
|              | Right Hand | 281903-10656 | N/A          |
|              | Left Hand  | 281903-11856 | N/A          |
| 10' (3048mm) | Right Hand | 281903-11856 | N/A          |
|              | Left Hand  | 281903-13056 | N/A          |
| 11' (3353mm) | Right Hand | 281903-13056 | N/A          |
|              | Left Hand  | 281903-14256 | N/A          |
| 12' (3658mm) | Right Hand | 281903-14256 | N/A          |
|              | Left Hand  | 281901-07428 | 281901-08028 |
| 13' (3962mm) | Right Hand | 281902-07428 | 281902-08028 |
|              | Left Hand  | 281901-07428 | 281901-09228 |
| 14' (4267mm) | Right Hand | 281902-07428 | 281902-09228 |
|              | Left hand  | 281901-07428 | 281901-10428 |
| 15' (4572mm) | Right Hand | 281902-07428 | 281902-10428 |
|              | Left Hand  | 281901-07428 | 281901-11628 |
| 16' (4877mm) | Right Hand | 281902-07428 | 281902-11628 |
|              | Left Hand  | 281901-07428 | 281901-12828 |
| 17' (5182mm) | Right Hand | 281902-07428 | 281902-12828 |
|              | Left Hand  | 281901-07428 | 281901-14028 |
| 18' (5486mm) | Right Hand | 281902-07428 | 281902-14028 |

# Service Parts

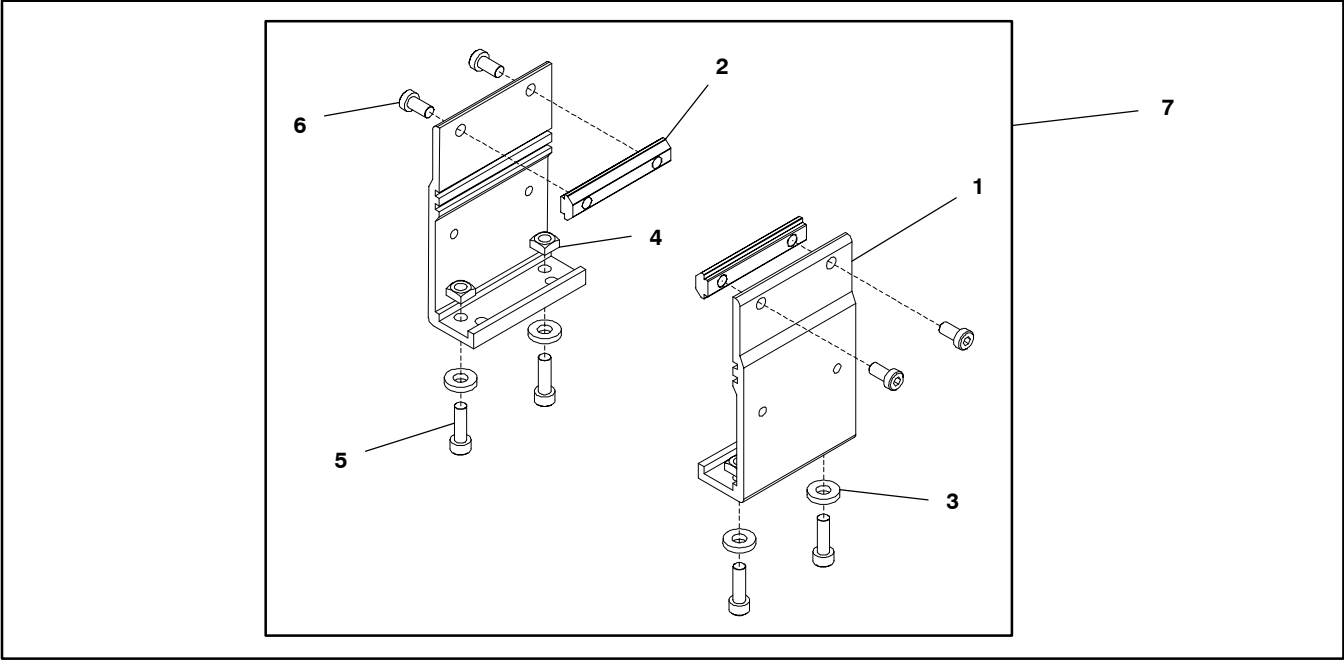
## Flared Side Guiding



| 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 |

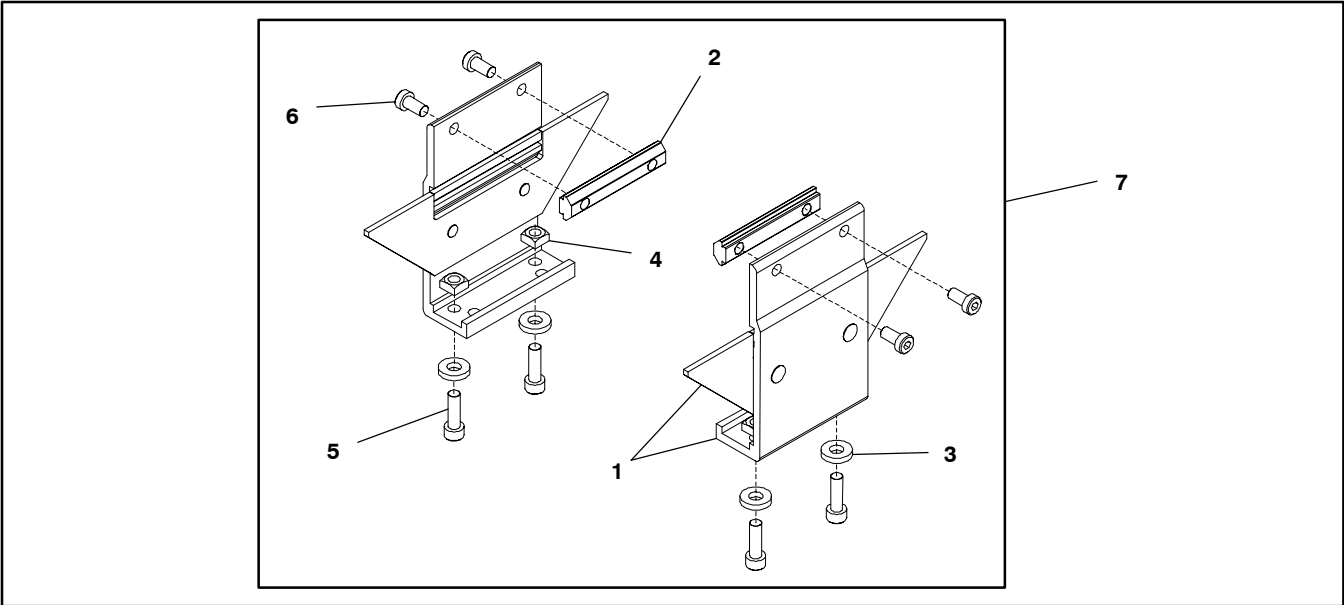
## Flat Belt Stand Mount Assembly



| Item | Part Number | Description     |
|------|-------------|-----------------|
| 1    | 240831      | Stand Mount     |
| 2    | 300150M     | Drop-In Tee Bar |
| 3    | 605279P     | Washer          |

|   |         |                                |
|---|---------|--------------------------------|
| 4 | 807-920 | Square Nut M6                  |
| 5 | 920620M | Socket Head Screw M6 x 20mm    |
| 6 | 920692M | Socket Low Head Screw M6x12mm  |
| 7 | 240839  | Flat Belt Stand Mount Assembly |

## Cleated Belt Stand Mount Assembly

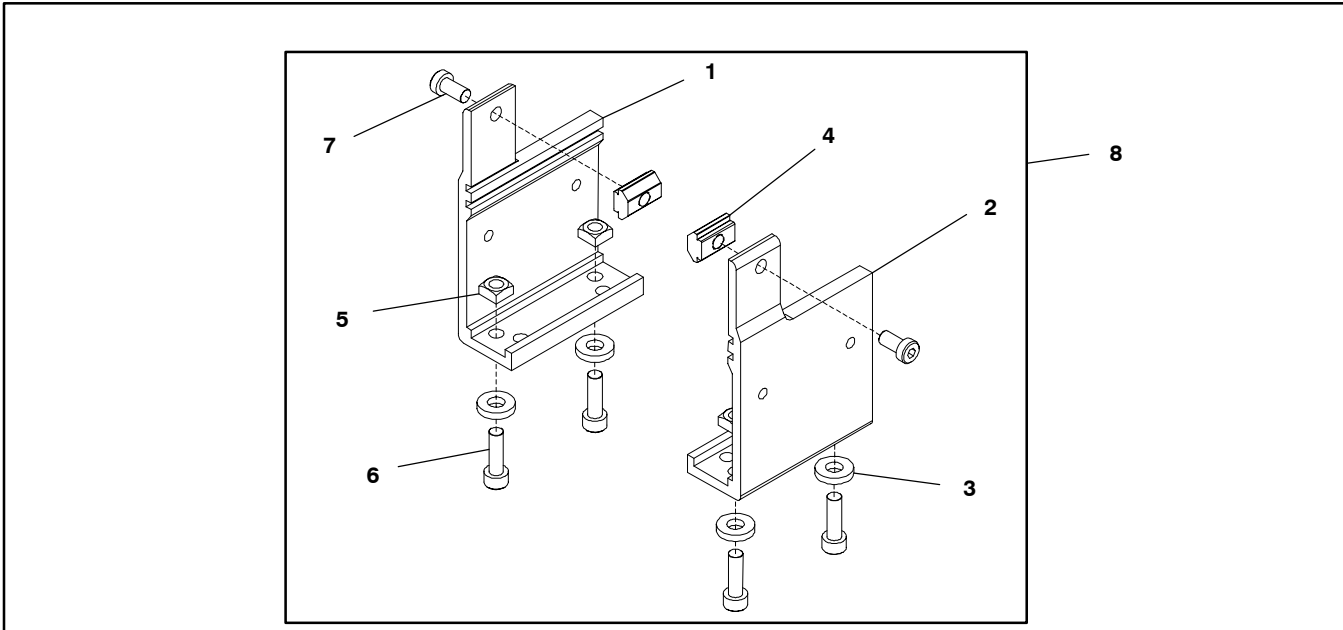


| Item | Part Number | Description            |
|------|-------------|------------------------|
| 1    | 240836      | Cleated Mount Assembly |
| 2    | 300150M     | Drop-In Tee Bar        |
| 3    | 605279P     | Washer                 |

|   |         |                               |
|---|---------|-------------------------------|
| 4 | 807-920 | Square Nut M6                 |
| 5 | 920620M | Socket Head Screw M6 x 20mm   |
| 6 | 920692M | Socket Low Head Screw M6x12mm |
| 7 | 240838  | Cleated Stand Mount Assembly  |

# Service Parts

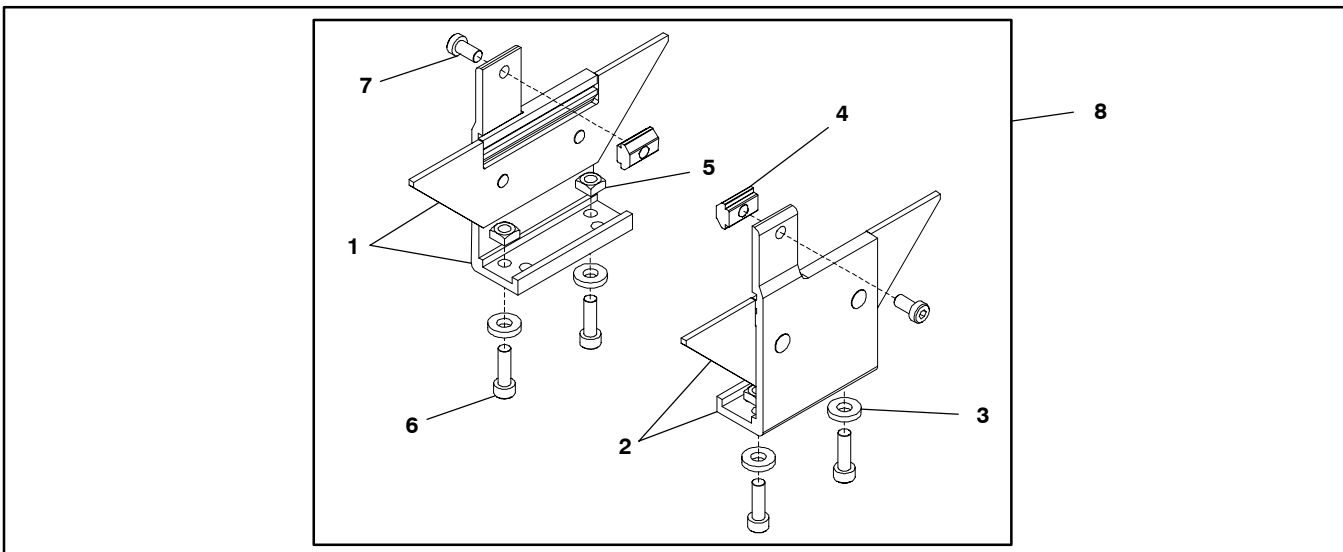
## Flat Belt Stand Mount Assembly for 2' (610mm) Conveyors



| Item | Part Number | Description                |
|------|-------------|----------------------------|
| 1    | 240833      | Stand Mount, LH 2' (610mm) |
| 2    | 240834      | Stand Mount, RH 2' (610mm) |
| 3    | 605279P     | Washer                     |
| 4    | 639971M     | Drop-In Tee Bar            |

|   |         |   |
|---|---------|---|
| 5 | 807-920 | Square Nut M6   |
| 6 | 920620M | Socket Head Screw M6 x 20mm                             |
| 7 | 920692M | Socket Low Head Screw M6x12mm                           |
| 8 | 240847  | Flat Belt Stand Mount Assembly for 2' (610mm) Conveyors |

## Cleated Belt Stand Mount Assembly for 2' (610mm) Conveyors

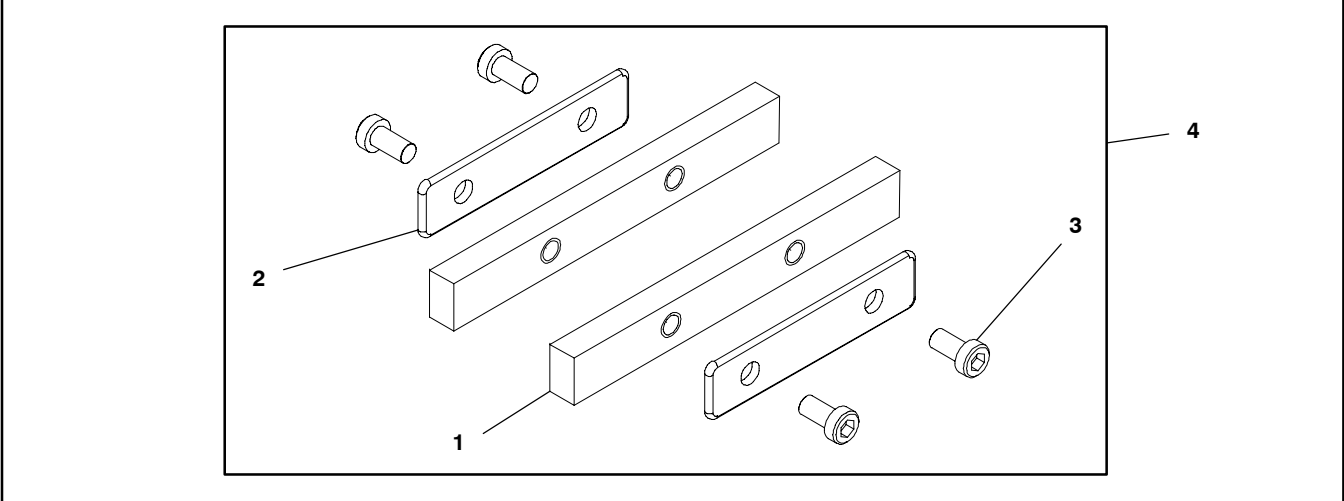


| Item | Part Number | Description   |
|------|-------------|---|
| 1    | 240852      | Cleated Stand Bracket Assembly LH 2' (610mm) Conveyor |
| 2    | 240853      | Cleated Stand Bracket Assembly RH 2' (610mm) Conveyor |
| 3    | 605279P     | Washer  |
| 4    | 639971M     | Drop-In Tee Bar                                       |

|   |         |  |
|---|---------|--|
| 5 | 807-920 | Square Nut M6  |
| 6 | 920620M | Socket Head Screw M6 x 20mm                                |
| 7 | 920692M | Socket Low Head Screw M6x12mm                              |
| 8 | 240851  | Cleated Belt Stand Mount Assembly for 2' (610mm) Conveyors |



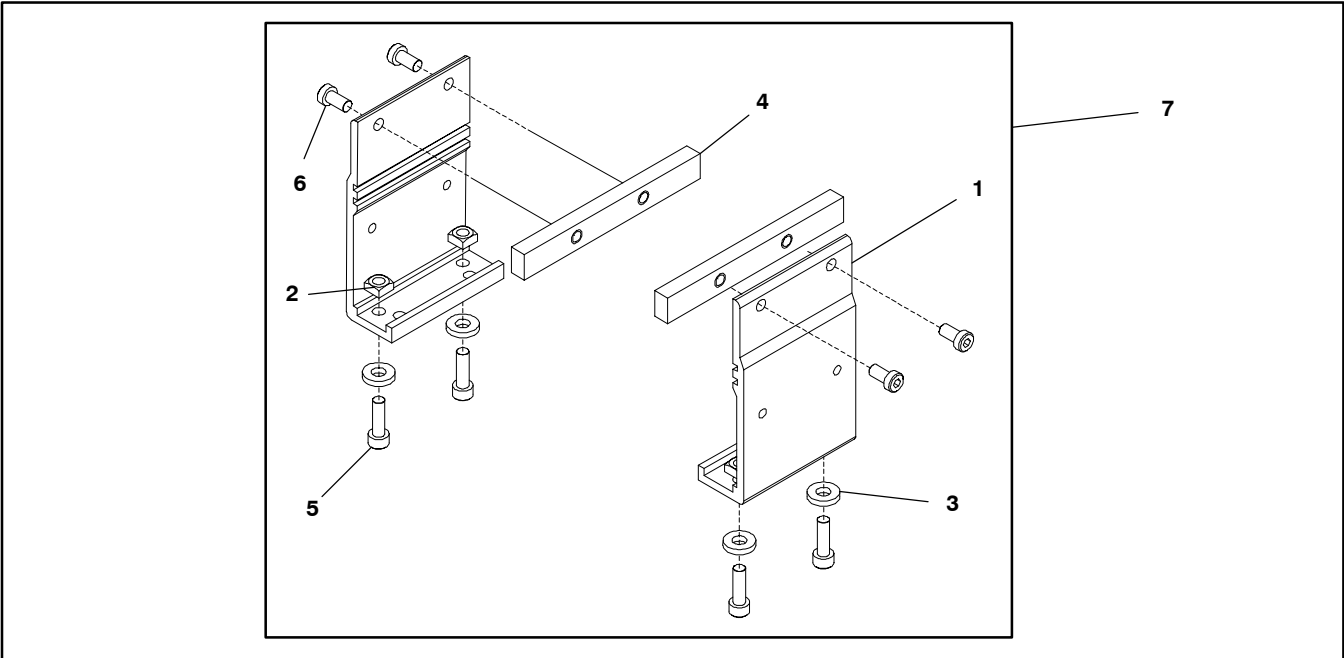
## Connecting Assembly without Stand Mount



| Item | Part Number | Description           |
|------|-------------|-----------------------|
| 1    | 240858      | Frame Connector Bar   |
| 2    | 240859      | Frame Connector Plate |

|   |         |  |
|---|---------|--|
| 3 | 920692M | Socket Low Head Screw M6x12mm            |
| 4 | 240861  | Connecting Assembly without Stand Mounts |

## Flat Belt Connecting Assembly with Stand Mount

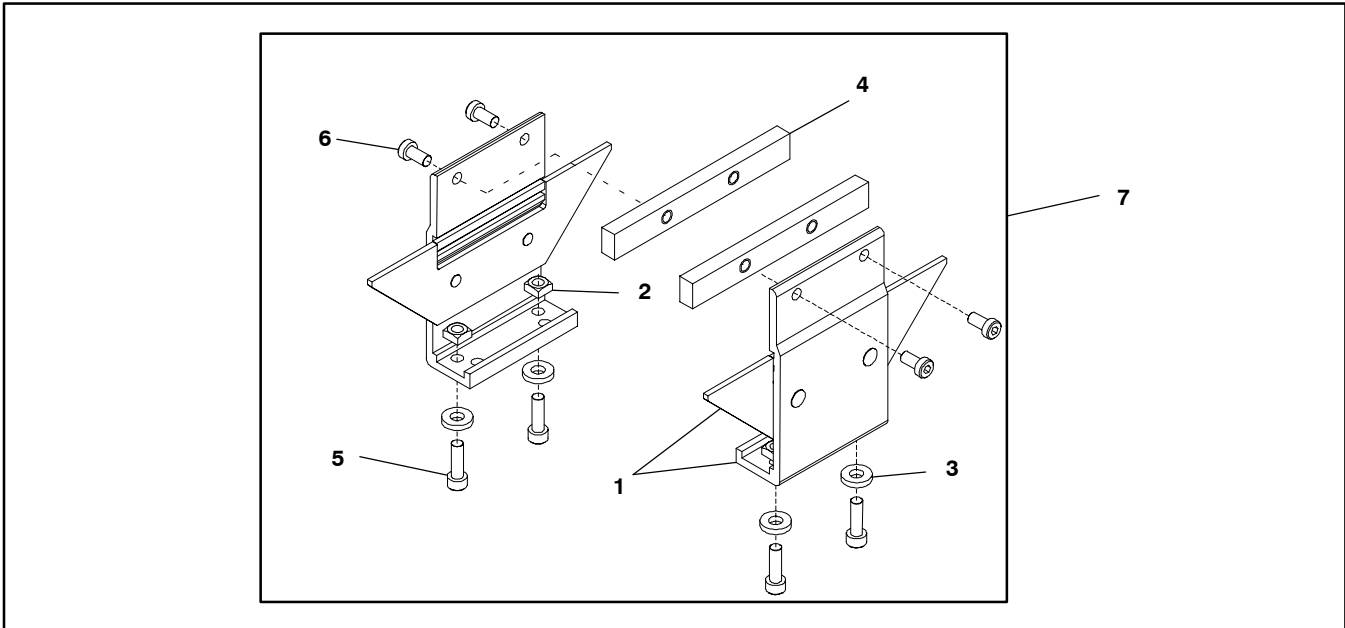


| Item | Part Number | Description              |
|------|-------------|--------------------------|
| 1    | 240831      | Stand Mount              |
| 2    | 807-920     | Square Nut M6 5mm x 10mm |
| 3    | 605279P     | Washer                   |
| 4    | 240858      | Frame Connector Bar      |

|   |         |   |
|---|---------|---|
| 5 | 920620M | Socket Head Screw M6 x 20mm                     |
| 6 | 920693M | Socket Low Head Screw M6 x 16mm                 |
| 7 | 240860  | Flat Belt Connecting Assembly with Stand Mounts |

# Service Parts

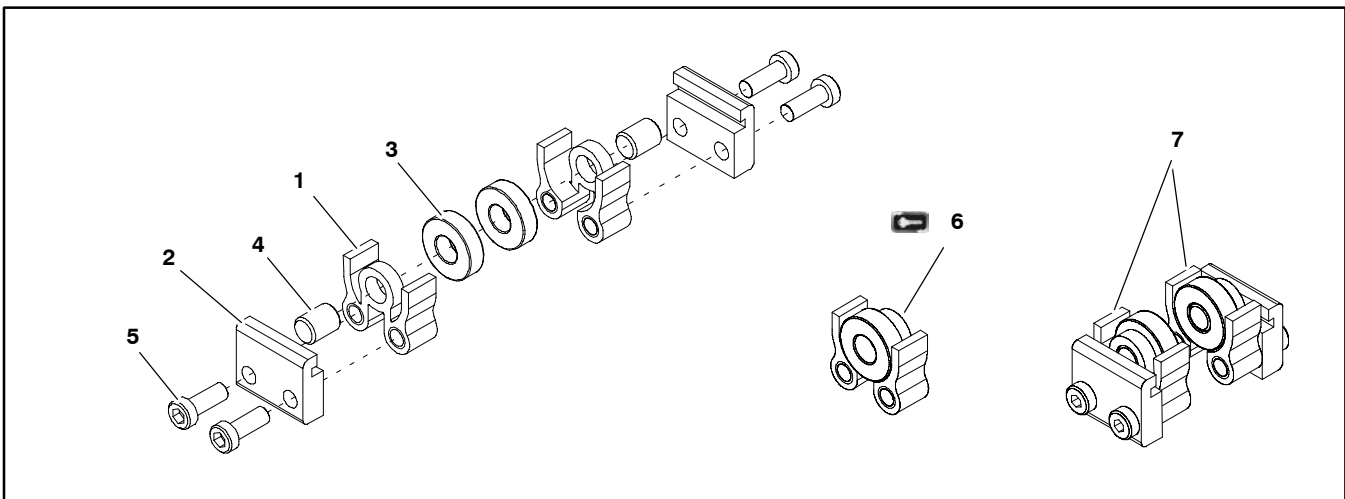
## Cleated Belt Connecting Assembly with Stand Mount



| Item | Part Number | Description              |
|------|-------------|--------------------------|
| 1    | 240836      | Cleated Stand Bracket    |
| 2    | 807-920     | Square Nut M6 5mm x 10mm |
| 3    | 605279P     | Washer                   |
| 4    | 240858      | Frame Connector Bar      |

|   |         |  |
|---|---------|--|
| 5 | 920620M | Socket Head Screw M6 x 20mm                        |
| 6 | 920693M | Socket Low Head Screw M6 x 16mm                    |
| 7 | 240863  | Cleated Belt Connecting Assembly with Stand Mounts |

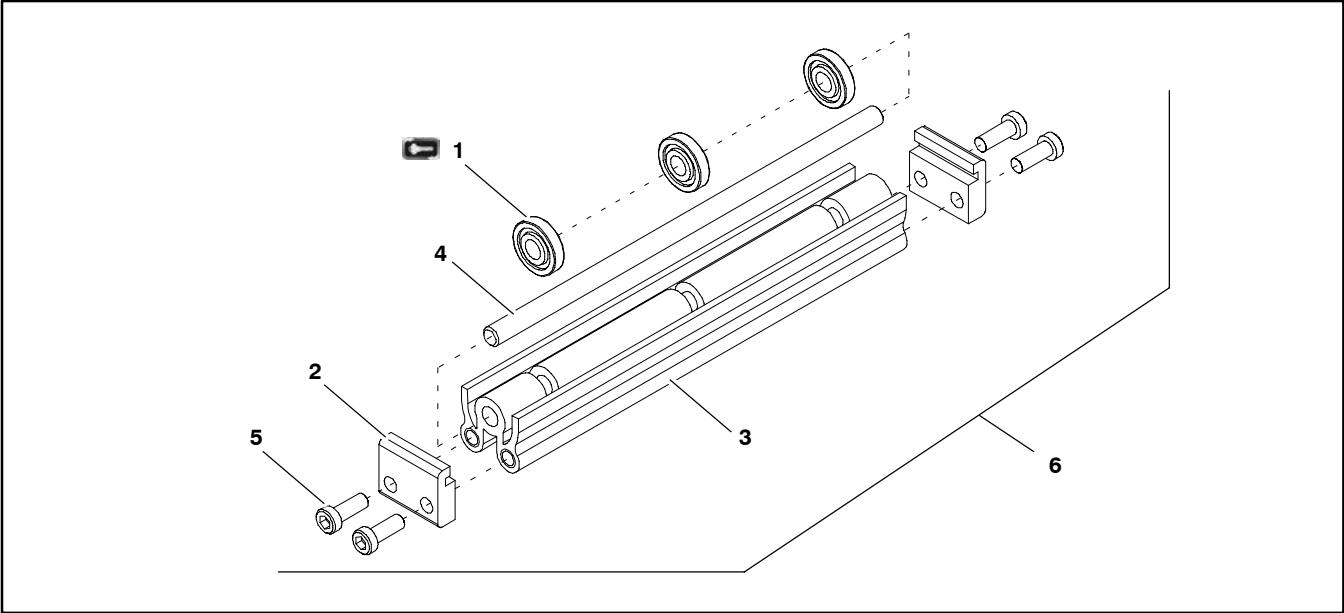
## 2" (51mm) to 6" (152mm) Flat Belt Return Roller



| Item | Part Number | Description                 |
|------|-------------|-----------------------------|
| 1    | 240825      | Return Roller Guard - Short |
| 2    | 240827      | Return Roller Clip          |
| 3    | 802-027     | Bearing                     |
| 4    | 913-100     | Dowel Pin                   |

|   |         |  |
|---|---------|--|
| 5 | 920693M | Socket Low Head Screw M6 x 16mm                      |
| 6 | 240840  | Roller Assembly (Includes Items 1, 3 and 4)          |
| 7 | 240830  | 2" (51mm) to 6" (152mm) Flat Belt Return Roller Assy |

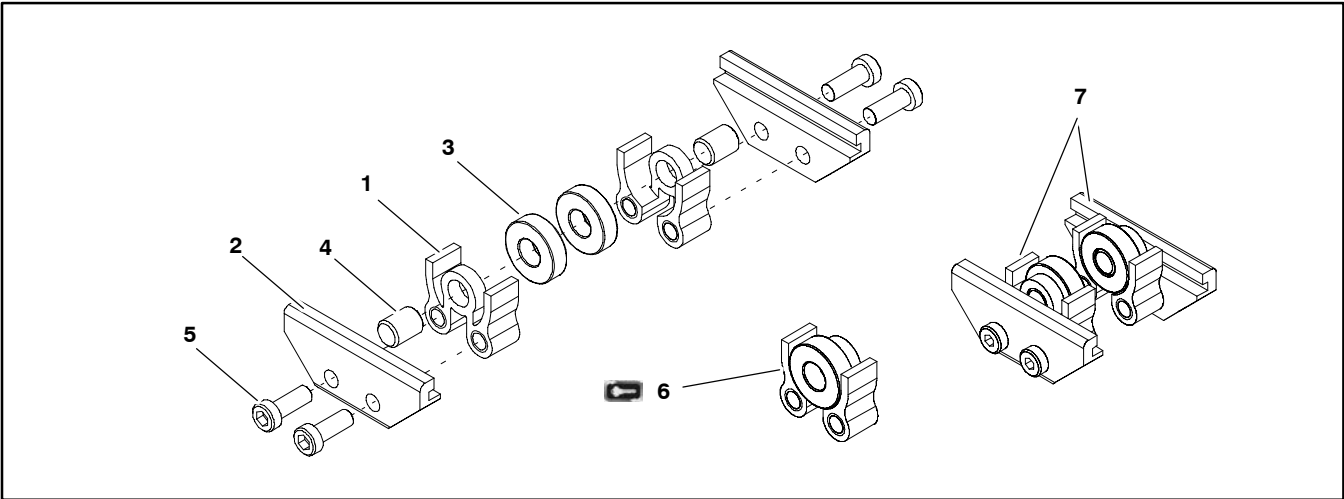
## 8" (203mm) to 24" (610mm) Flat Belt Return Roller



| Item | Part Number | Description         |
|------|-------------|---------------------|
| 1    | 240826      | Return Roller       |
| 2    | 240827      | Return Roller Clip  |
| 3    | 2409WW      | Return Roller Guard |
| 4    | 2410WW      | Return Roller Rod   |

|  |         |  |
|--|---------|--|
| 5  | 920693M | Socket Low Head Screw M6 x 16mm                            |
| 6  | 2408WW  | 8" (203mm) to 24" (610mm) Flat Belt Return Roller Assembly |
| WW.= Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24 |         |  |

## Cleated Belt Return Roller



| Item | Part Number | Description                 |
|------|-------------|-----------------------------|
| 1    | 240825      | Return Roller Guard - Short |
| 2    | 240828      | Cleated Return Roller Clip  |
| 3    | 802-027     | Bearing                     |
| 4    | 913-100     | Dowel Pin                   |

|   |         |   |
|---|---------|---|
| 5 | 920693M | Socket Low Head Screw M6 x 16mm             |
| 6 | 240840  | Roller Assembly (Includes Items 1, 3 and 4) |
| 7 | 240832  | Cleated Belt Return Roller Assembly         |

# Service Parts

## Conveyor Belt Part Number Configuration

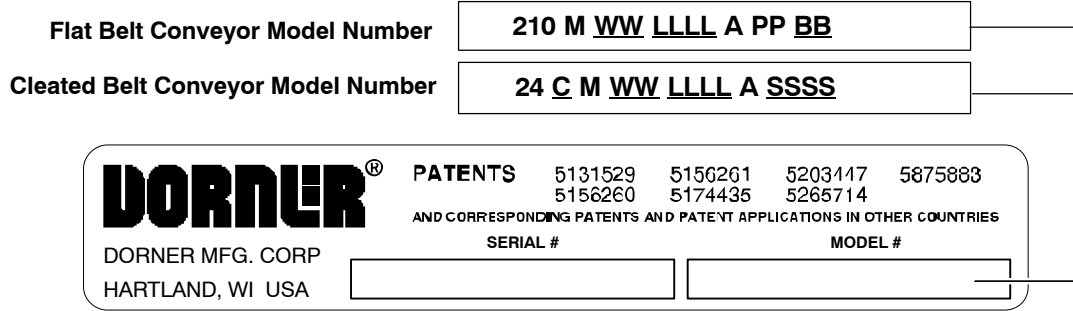


Figure 43

### Flat Belt Part Number Configuration

Refer to Dorner patent plate (Figure 43). From the model number, determine conveyor width (“WW”), length (“LLLL”) and belt type (“BB”). Use data to configure belt part number as indicated below. \*Add “V” for V-guided belts.

22 - WW LLLL / BB V \*

22 - \_\_\_\_\_ / \_\_\_\_ V\*

(Fill In)

### Cleated Belt Part Number Configuration

Refer to Dorner patent plate (Figure 43). From the model number, determine conveyor type (“T”), width (“WW”), length (“LLLL”), cleat type (“C”) and cleat spacing (“SSSS”). Use data to configure belt part number as indicated below. \*Add “V” for V-guided belts.

2T - WW LLLL C SSSS V \*

2 \_ - \_\_\_\_\_ / \_\_\_\_\_ V\*

(Fill In)



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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®**

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