

2200 Series End Drive Conveyors





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Warnings – General Safety

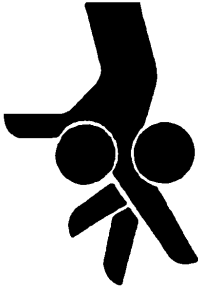

	WARNING	
<p>The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.</p>		



	 DANGER
<p>Climbing, sitting, walking or riding on conveyor will cause severe injury. KEEP OFF CONVEYORS.</p>	

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

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

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

	 WARNING
<p>Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.</p> <p>When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, CHECK FOR POTENTIAL PINCH POINTS and other mechanical hazards before system start-up.</p>	

	 WARNING
<p>Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury. SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.</p>	


Introduction

IMPORTANT: Some illustrations may show guards removed. Do NOT operate equipment without guards.

Upon receipt of shipment:

- Compare shipment with packing slip. Contact factory regarding discrepancies.
- Inspect packages for shipping damage. Contact carrier regarding damage.
- Accessories may be shipped loose. See accessory instructions for installation.

Dorner's Limited Warranty applies.

Dorner 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

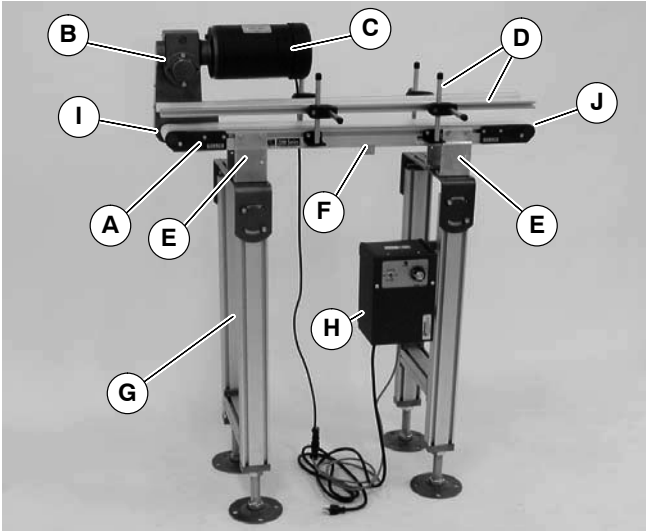
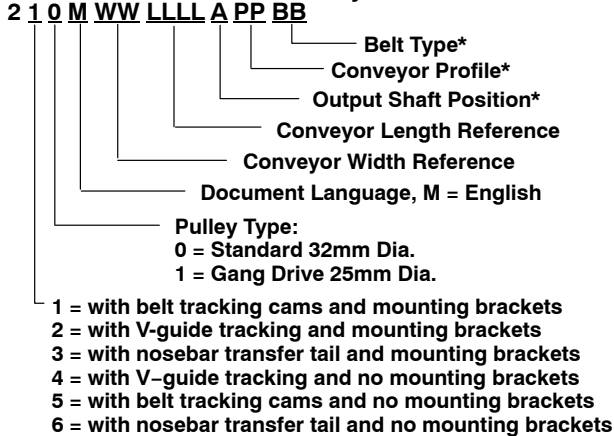


Figure 1

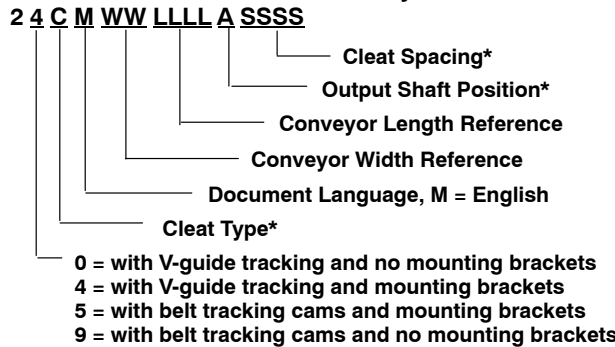
Specifications

Models:

Flat Belt 2200 Series Conveyor



Cleated Belt 2200 Series Conveyor



* See Ordering and Specifications Catalog for details.

Conveyor Supports:

Maximum Distances:

- K = 457 mm**
- L = 1829 mm***
- M = 457 mm

- ** For Heavy Load Bottom Mount Package, mount support under gear head.
- *** For conveyors longer than 3658 mm, install support at joint.

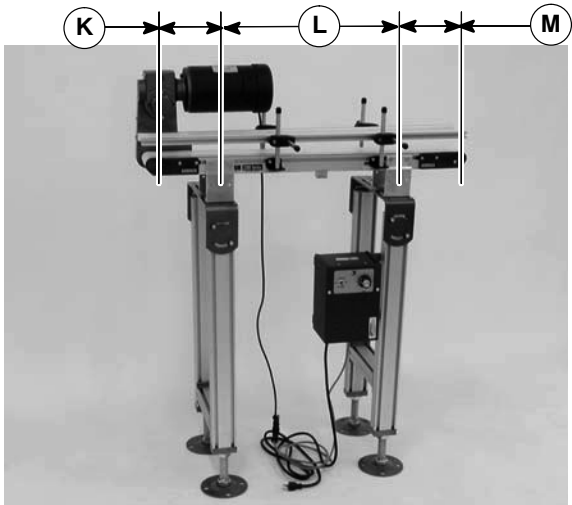


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18	21	24
Conveyor Belt Width	44mm	70mm	95mm	127mm	152mm	203mm	254mm	305mm	457mm	533mm	609mm
Maximum Conveyor Load* (See NOTE Below)	14kg	16kg	19kg	23kg	27kg	32kg	36kg	36kg	36kg	36kg	36kg
Conveyor Startup Torque*	0.5Nm	0.6Nm	0.7Nm	0.8Nm	0.9Nm	1.1Nm	1.4Nm	1.5Nm	1.7Nm	2.0Nm	2.3Nm
Belt Travel	88 mm per revolution of pulley										
Maximum Belt Speed*	80.5 m/minute										
Belt Takeup	10 mm of stroke = 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 Up to 5486 mm in any length to nearest 3mm	610 mm	914 mm	1219 mm	1524 mm	1829 mm	2134 mm	2438 mm	2743 mm	3048 mm	3353 mm	3658 mm	3962 mm**	4267 mm**	4572 mm**	4877 mm**	5182 mm**	5486 mm**

* See Ordering and Specifications Catalog for details.

** Lengths available only in 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.

Installation Component List

- O Conveyor frame (two sections if longer than 3658 mm)
- P Conveyor brackets (4x)
- Q Return rollers (for longer conveyors)



Figure 3

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 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 3658 mm

1. Locate conveyor sections (O Figure 4)

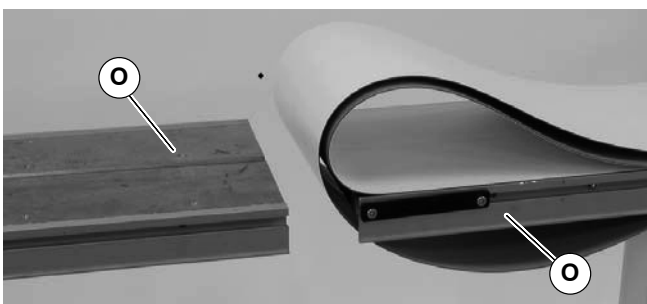



Figure 4

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.

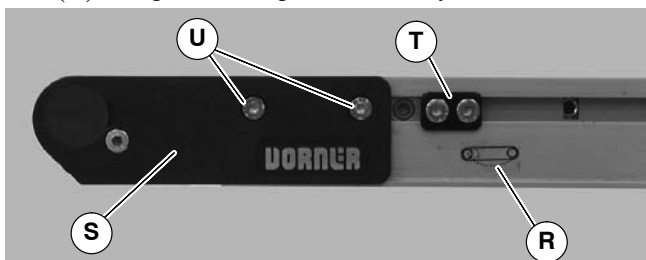


Figure 5

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

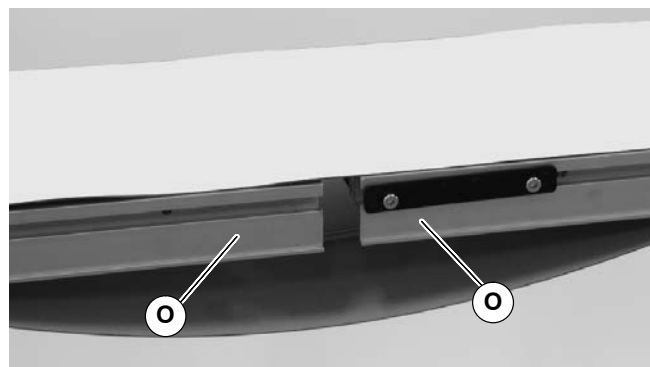


Figure 6

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 7 Nm.

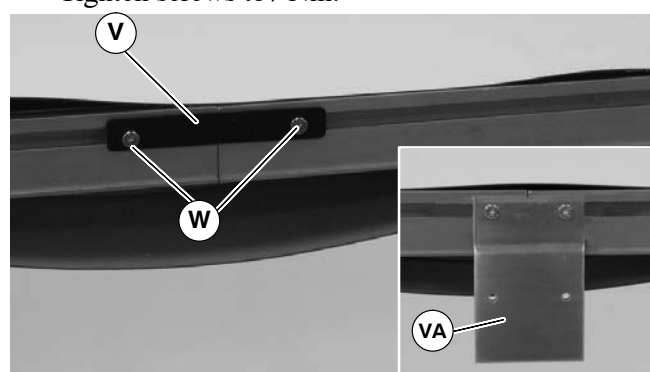


Figure 7

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 9 Nm. For proper tensioning, refer to “Conveyor Belt Tensioning” on page 11.

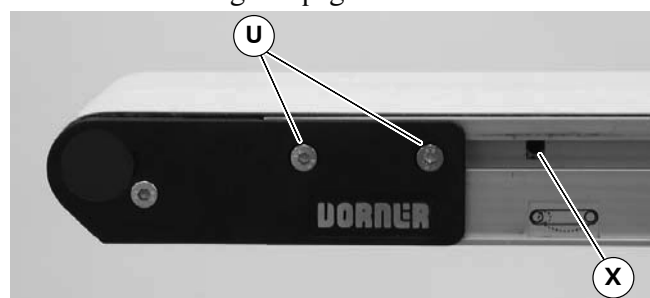


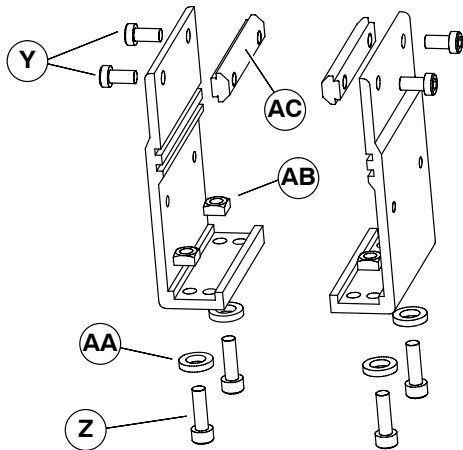
Figure 8

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

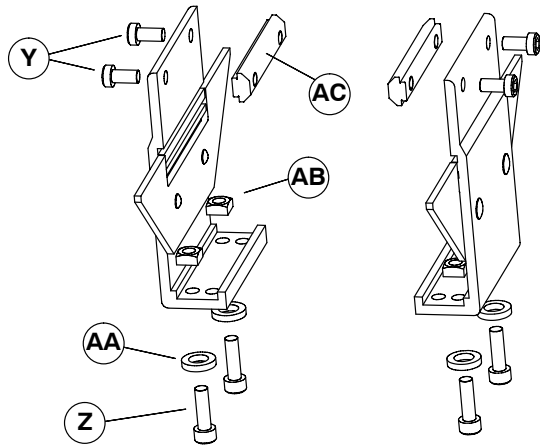
Mounting Brackets

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).

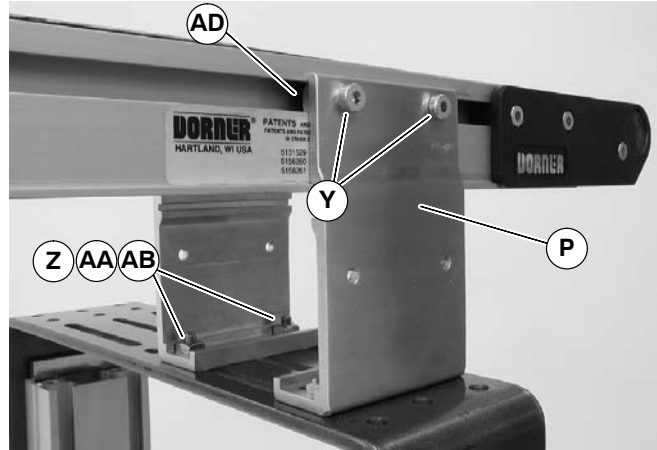


Figure 11

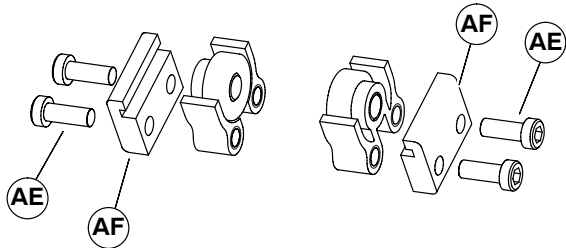
NOTE: Mounting brackets for flat belt conveyors shown.

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 7 Nm.

Return Rollers

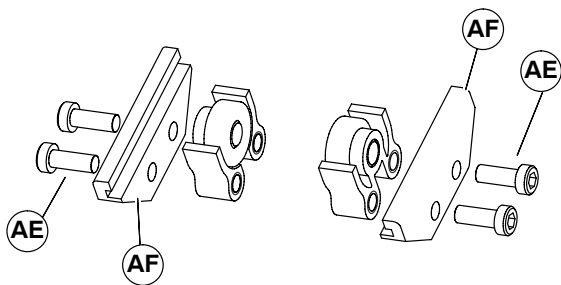
Cleated Belt and 51–152 mm Wide Flat Belt Conveyors

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 7 Nm.

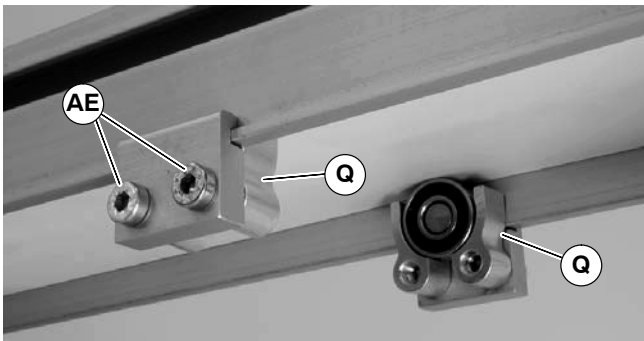


Figure 14

203–610 mm Wide Flat Belt Conveyors

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

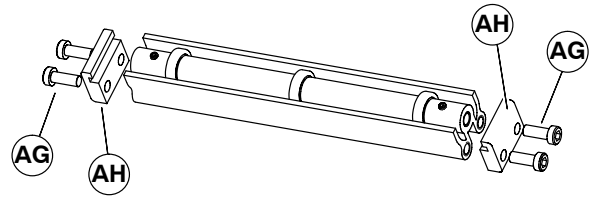


Figure 15

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 7 Nm.

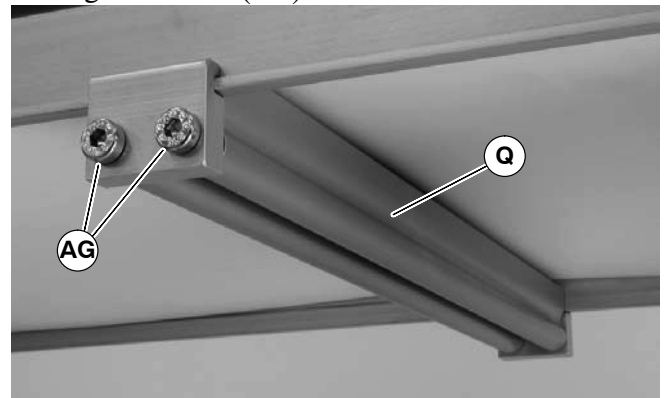


Figure 16

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 for complete list of troubleshooting solutions.

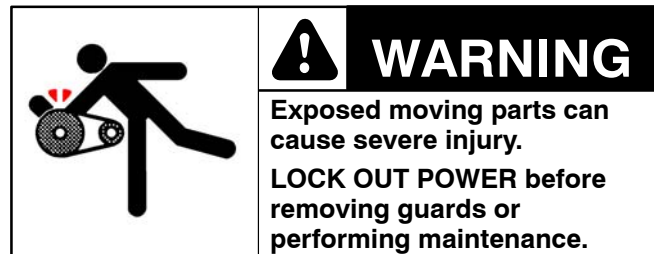
Cleaning

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).

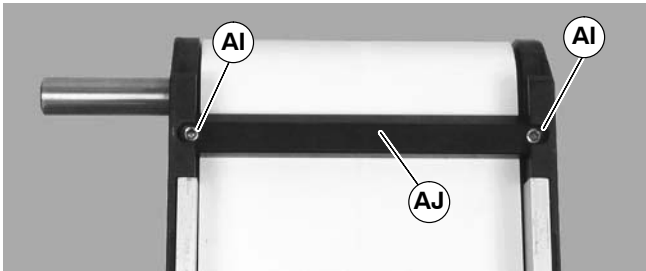



Figure 17

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.

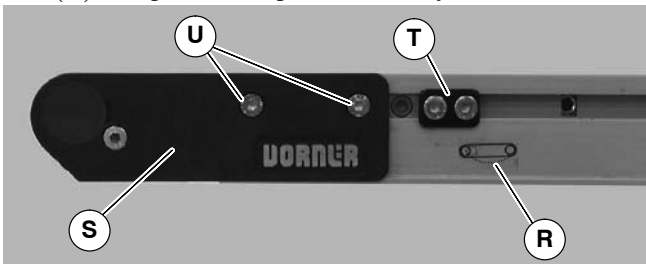


Figure 18

4. Remove conveyor belt.

Belt Removal for Conveyor With Stands and Gearmotor Mounting Package

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

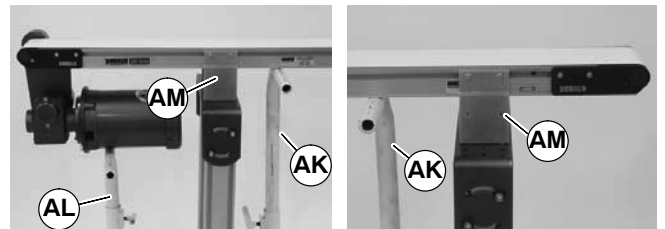


Figure 19

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).

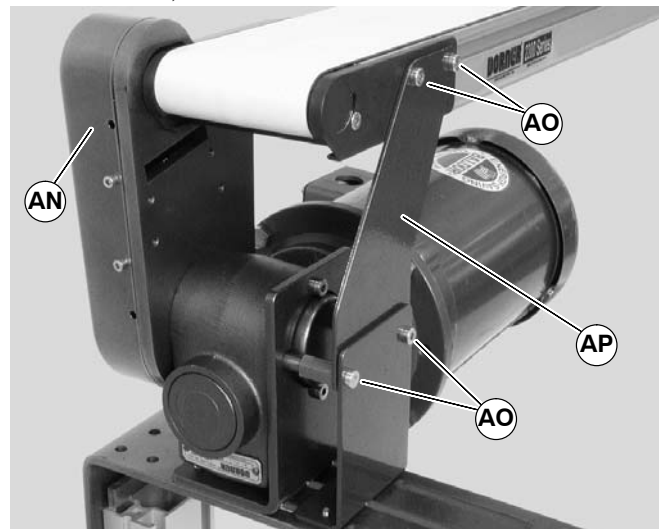



Figure 20

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.

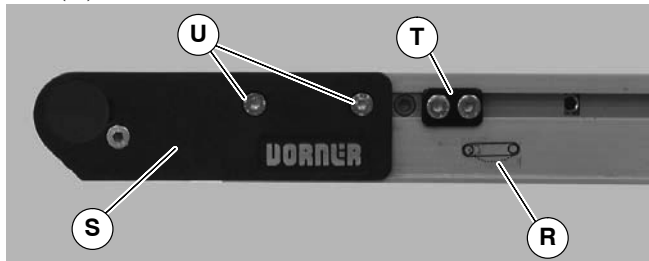


Figure 21

- 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).

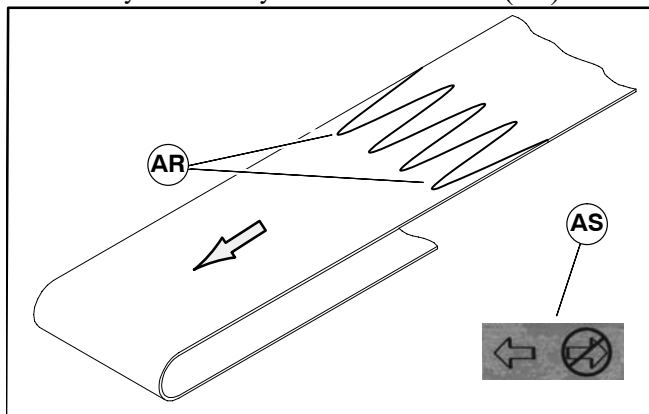


Figure 23

- 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 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.

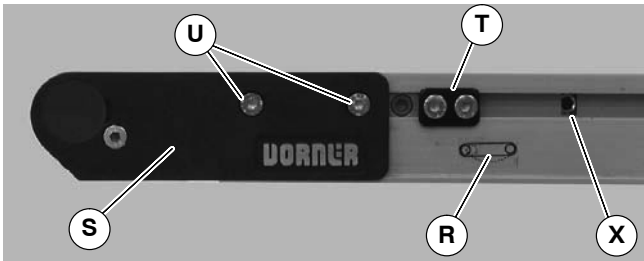


Figure 25

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**.

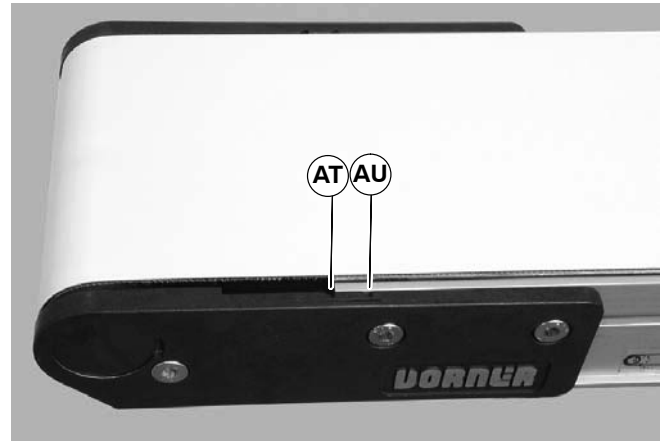



Figure 26

NOTE: On pinion gear, do not exceed a torque of 2.8 Nm for 44 – 305 mm wide conveyors and 4.5 Nm for a 457 – 610 mm 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 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.

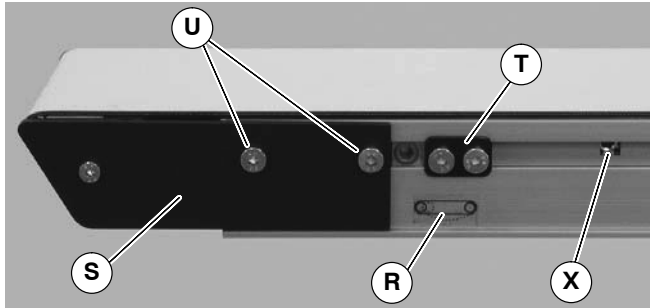


Figure 27

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 29 mm. Replace belt if proper tensioning can not be obtained within a distance of 38 mm. See **NOTE**.

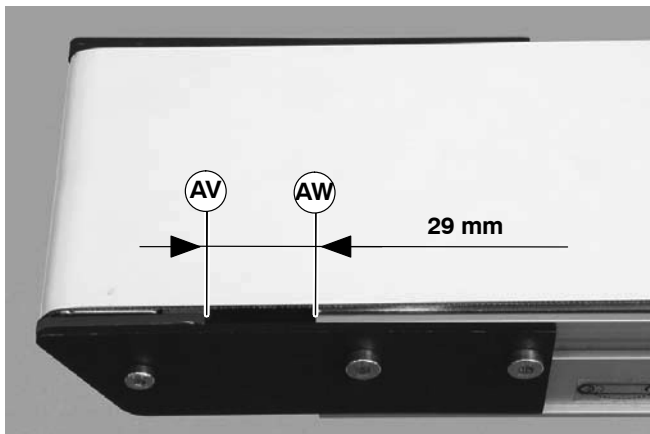


Figure 28

NOTE: On pinion gear, do not exceed a torque of 2.8 Nm for 44 – 305 mm wide conveyors or 4.5 Nm for a 457 – 610 mm 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 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.

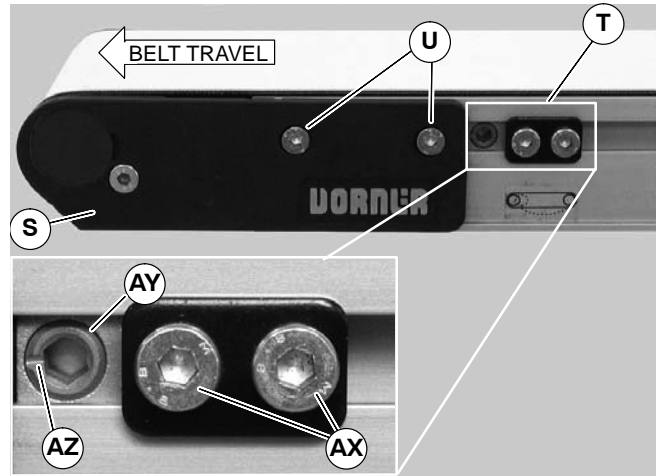


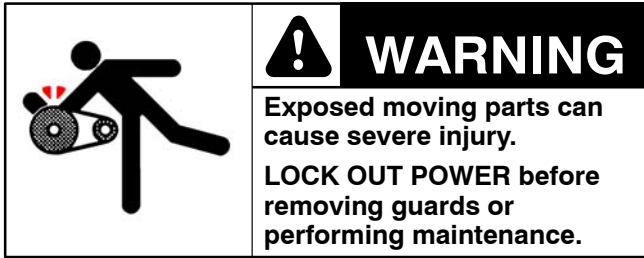
Figure 29

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 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 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.

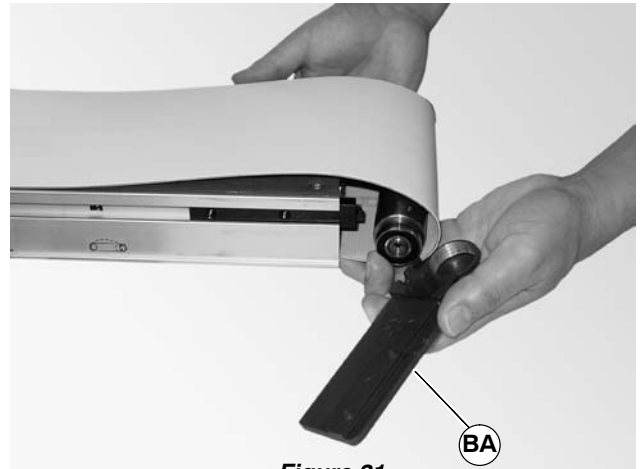


Figure 31

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.

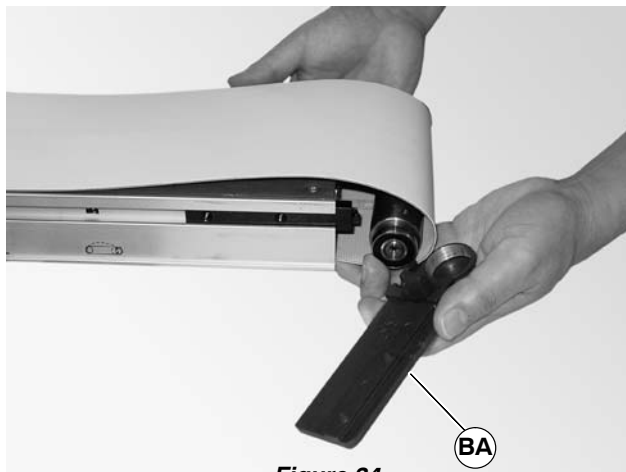


Figure 34

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.

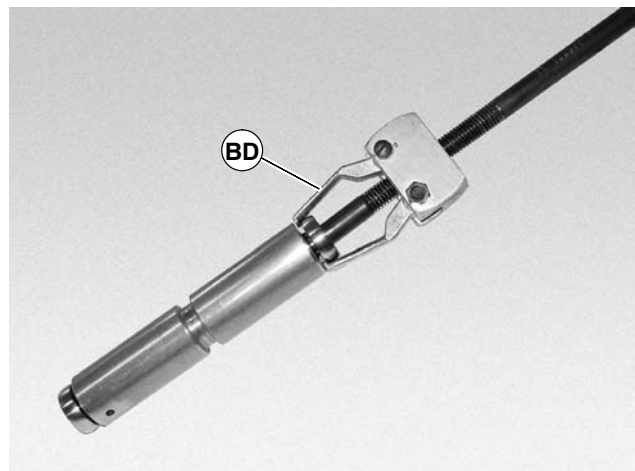


Figure 35 – Conveyor Pulley

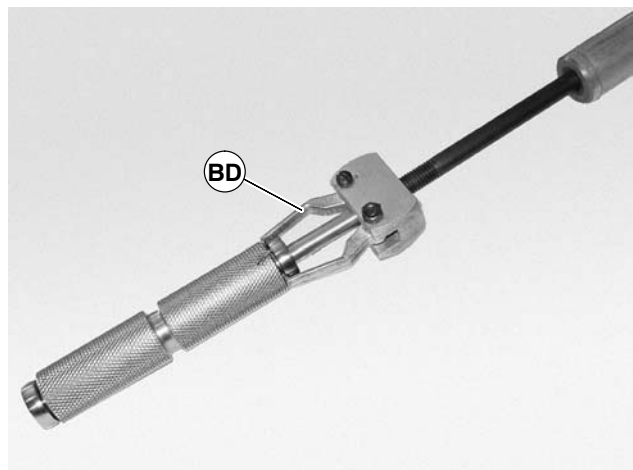


Figure 36 – Drive Pulley

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.

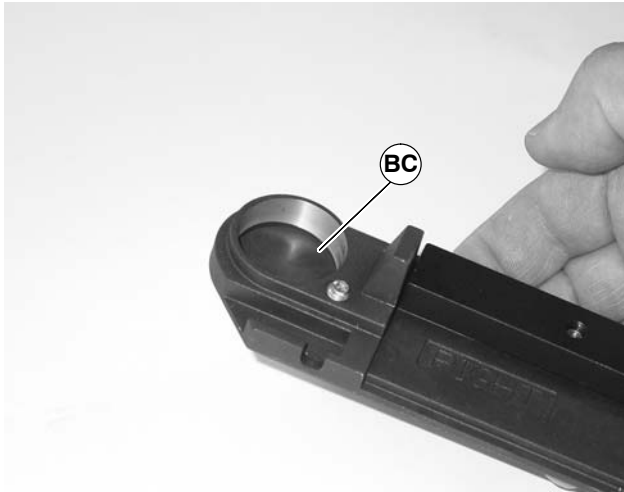


Figure 37

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.

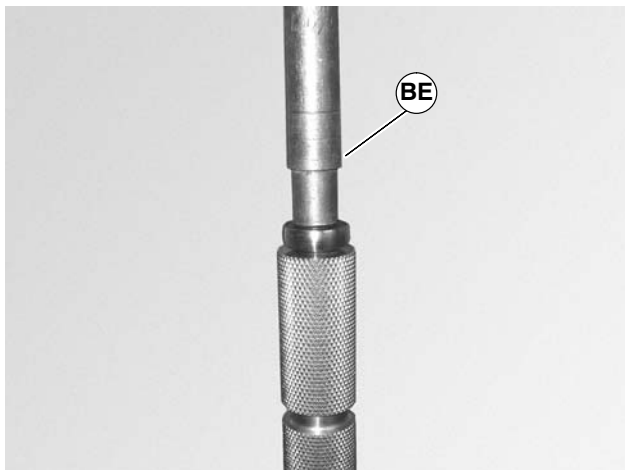


Figure 38

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.

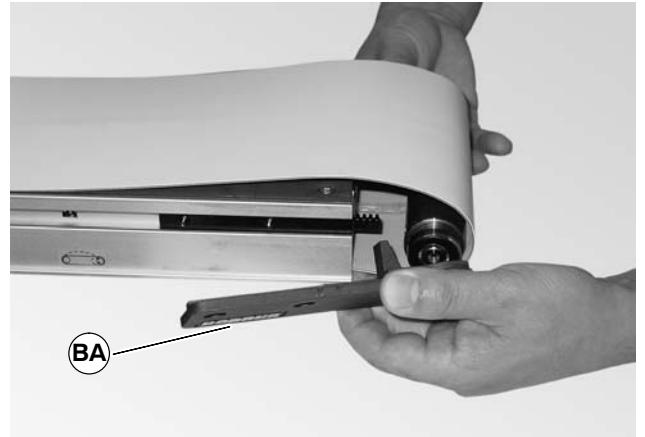


Figure 39

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 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.

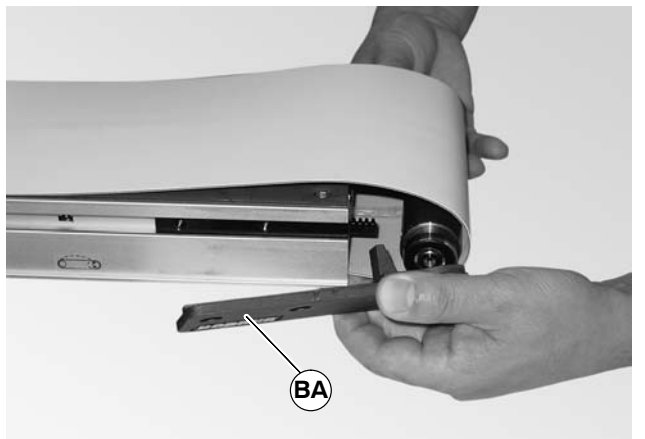


Figure 40

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.

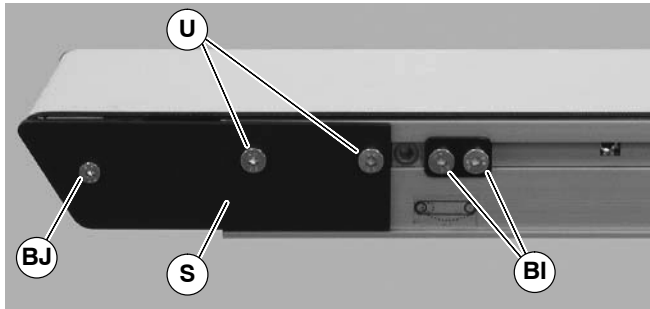


Figure 41

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.

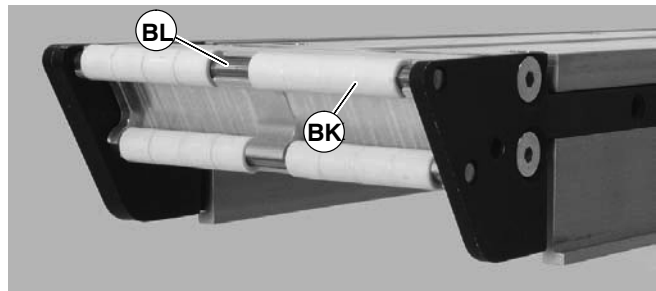



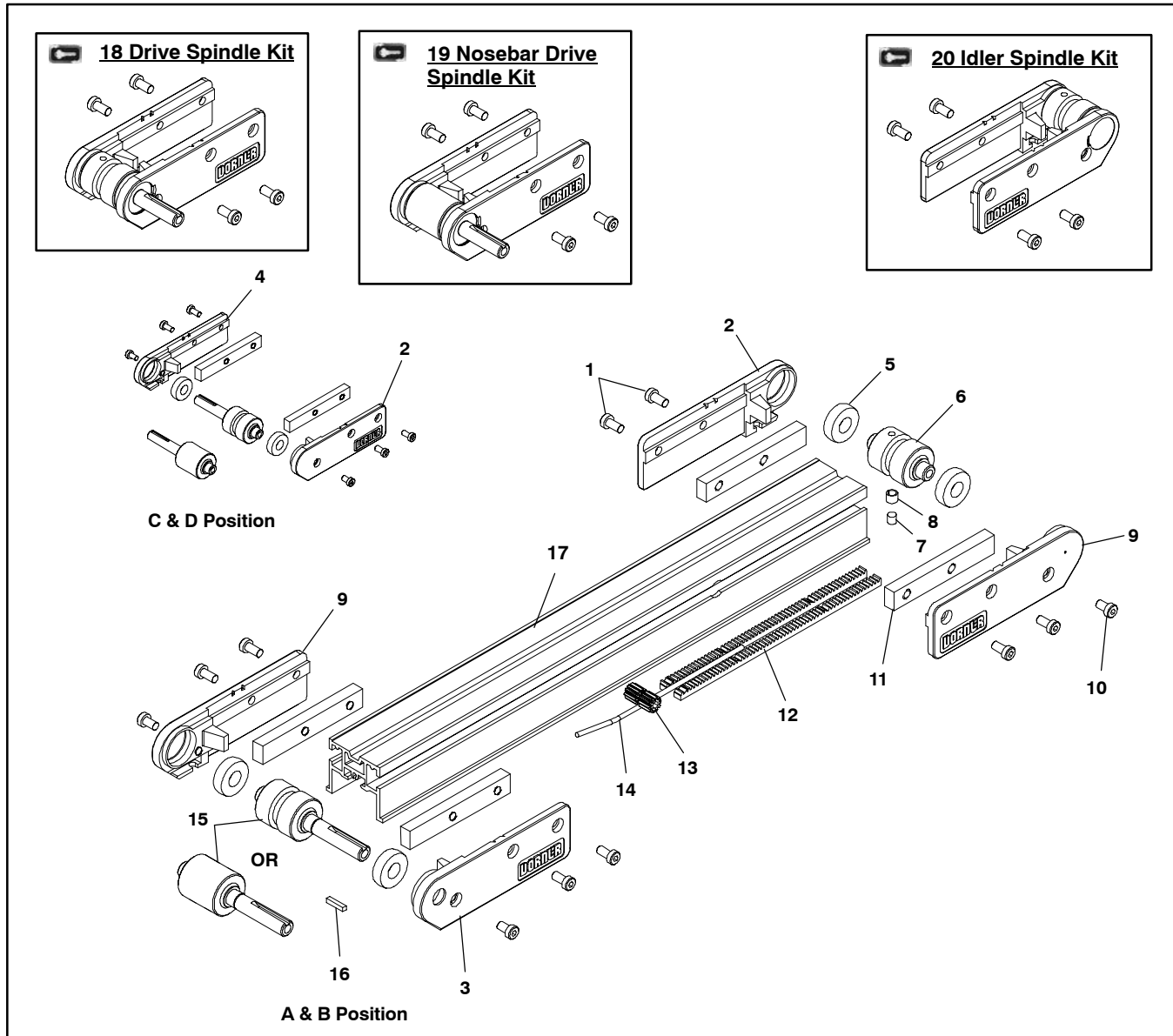
Figure 42

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 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.

51mm Wide Conveyor

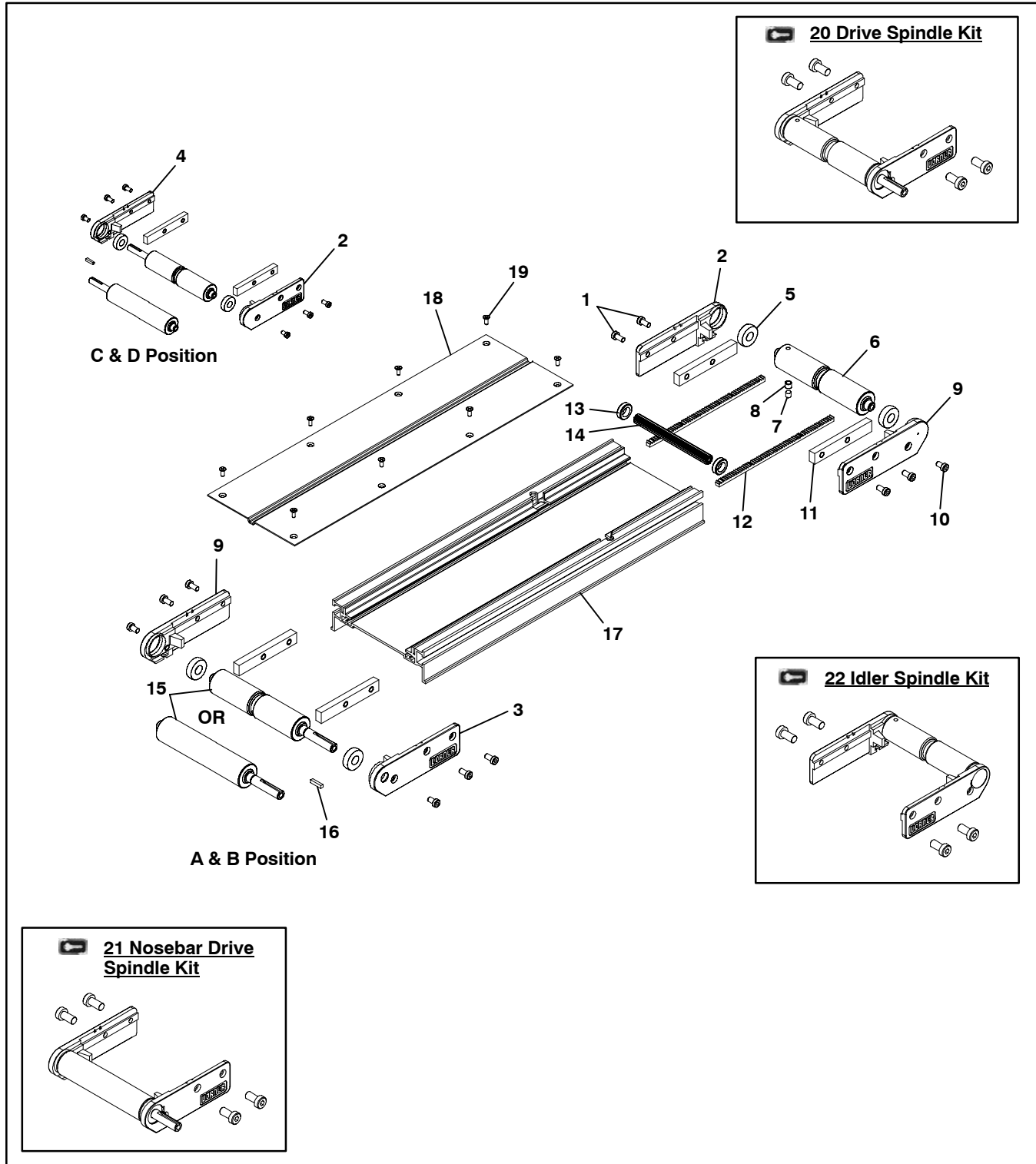


Item	Part Number	Description
1	920692M	Socket Head Screw M6 x 12mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	240328	Bearing
6	247302	Idler Spindle 51mm
7	808-020	Magnet 6.35mm Dia. x 6.35mm long
8	450226SSP	Sleeve, 6.35mm 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 51mm
14	240422	Pinion Pin
15	456402	Drive Spindle 51mm
	247602	Nosebar Drive Spindle Lagged 51mm
16	980422M	Square Key 4mm x 22mm
17	See Frame Chart	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: 51mm Conveyor Frame	
Length	Part Number
610mm	240402-01908
914mm	240402-03108
1219mm	240402-04308
1524mm	240402-05508
1829mm	240402-06708
2134mm	240402-07908
2438mm	240402-09108
2743mm	240402-10308
3048mm	240402-11508
3353mm	240402-12708
3658mm	240402-13908

Service Parts

76mm to 152mm 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 6mm Dia. x 6mm long
8	450226SSP	Sleeve, 6mm 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 51mm
	2476WW	Nosebar Drive Spindle Lagged 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	
610mm	2404WW-01908	
914mm	2404WW-03108	
1219mm	2404WW-04308	
1524mm	2404WW-05508	
1829mm	2404WW-06708	
2134mm	2404WW-07908	
2438mm	2404WW-09108	
2743mm	2404WW-10308	
3048mm	2404WW-11508	
3353mm	2404WW-12708	
3658mm	2404WW-13908	
3962mm	2404WW-07200	2404WW-07908*
4267mm	2404WW-07200	2404WW-09108*
4572mm	2404WW-07200	2404WW-10308*
4877mm	2404WW-07200	2404WW-11508*
5182mm	2404WW-07200	2404WW-12708*
5486mm	2404WW-07200	2404WW-13908*

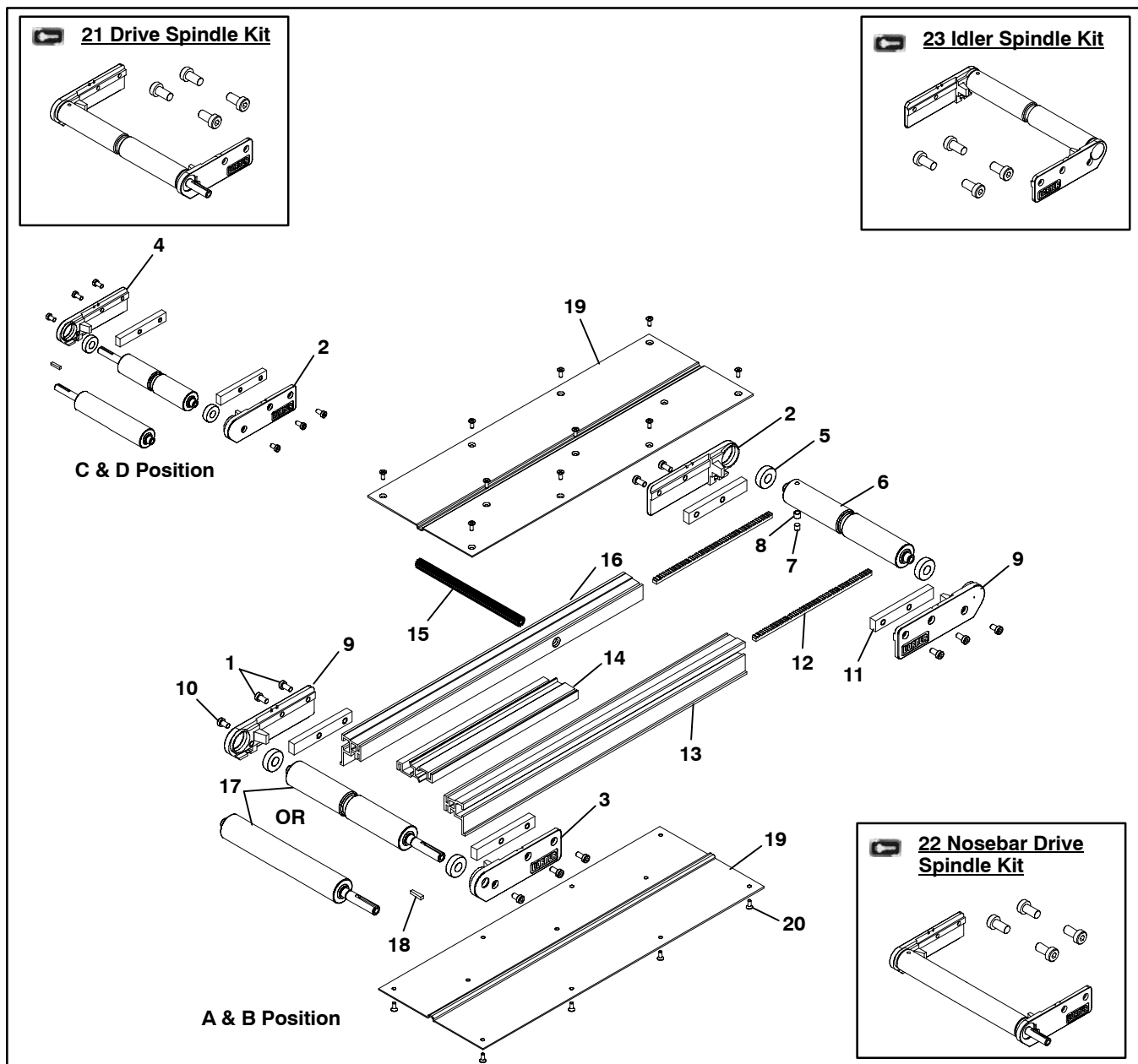
WW = Conveyor width reference: 03, 04, 05, 06
* = 152mm and wider conveyors, only

Item 18: Bed Plate		
Length	Part Number	
610mm	2405WW-01900	
914mm	2405WW-03100	
1219mm	2405WW-04300	
1524mm	2405WW-05500	
1829mm	2405WW-06700	
2134mm	2405WW-07900	
2438mm	2405WW-09100	
2743mm	2405WW-10300	
3048mm	2405WW-11500	
3353mm	2405WW-12700	
3658mm	2405WW-13900	
3962mm	2405WW-07196	2405WW-07900*
4267mm	2405WW-07196	2405WW-09100*
4572mm	2405WW-07196	2405WW-10300*
4877mm	2405WW-07196	2405WW-11500*
5182mm	2405WW-07196	2405WW-12700*
5486mm	2405WW-07196	2405WW-13900*

WW = Conveyor Width reference: 03, 04, 05, 06
* = 152mm and wider conveyors, only

Service Parts

203mm to 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 6mm Dia. x 6mm long
8	450226SSP	Sleeve, 6mm 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	2030WWW	Pinion Gear
16	See Chart	Side Rail LH
17	4564WW	Drive Spindle 51mm
	2476WW	Nosebar Drive Spindle Lagged 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, 3, 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)
WW = Conveyor width reference: 08, 10, 12		

Item 13: Side Rail RH	
Length	Part Number
610mm	240412-01908
914mm	240412-03108
1219mm	240412-04308
1524mm	240412-05508
1829mm	240412-06708
2134mm	240412-07908
2438mm	240412-09108
2743mm	240412-10308
3048mm	240412-11508
3353mm	240412-12708
3658mm	240412-13908
3962mm	240412-07200 240412-07908
4267mm	240412-07200 240412-09108
4572mm	240412-07200 240412-10308
4877mm	240412-07200 240412-11508
5182mm	240412-07200 240412-12708
5486mm	240412-07200 240412-13908

Item 14: Center Rail	
Length	Part Number
610mm	240414-01273
914mm	240414-02473
1219mm	240414-03673
1524mm	240414-04873
1829mm	240414-06073
2134mm	240414-07273
2438mm	240414-08473
2743mm	240414-09673
3048mm	240414-10873
3353mm	240414-12073
3658mm	240414-13273
3962mm	240414-07200 240414-07273
4267mm	240414-07200 240414-08473
4572mm	240414-07200 240414-09673
4877mm	240414-07200 240414-10873
5182mm	240414-07200 240414-12073
5486mm	240414-07200 240414-13273

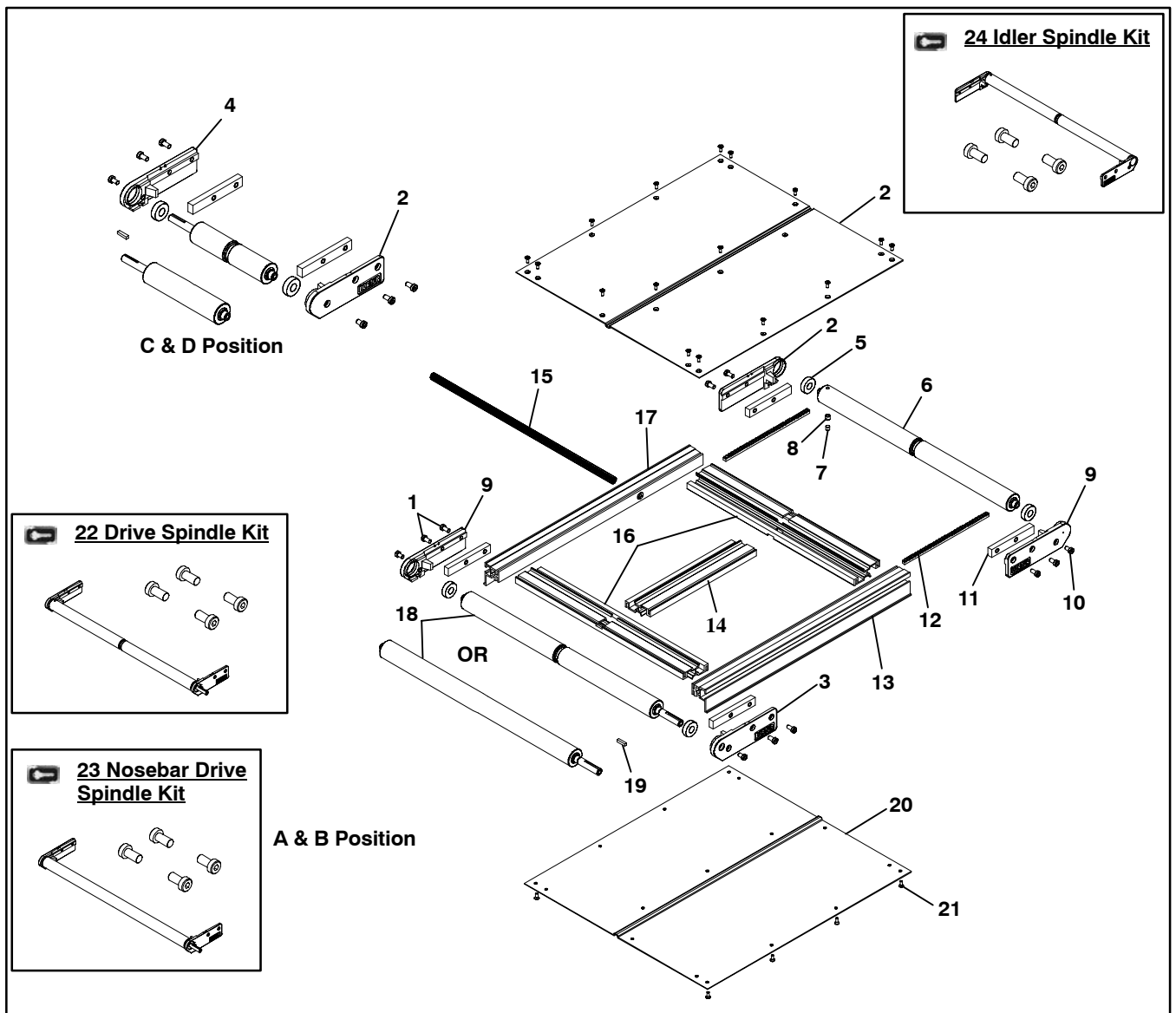
Service Parts

Item 16: Side Rail LH	
Length	Part Number
610mm	240413-01908
914mm	240413-03108
1219mm	240413-04308
1524mm	240413-05508
1829mm	240413-06708
2134mm	240413-07908
2438mm	240413-09108
2743mm	240413-10308
3048mm	240413-11508
3353mm	240413-12708
3658mm	240413-13908
3962mm	240413-07200 240413-07908
4267mm	240413-07200 240413-09108
4572mm	240413-07200 240413-10308
4877mm	240413-07200 240413-11508
5182mm	240413-07200 240413-12708
5486mm	240413-07200 240413-13908

Item 17: Bed Plate	
Length	Part Number
610mm	2405WW-01900
914mm	2405WW-03100
1219mm	2405WW-04300
1524mm	2405WW-05500
1829mm	2405WW-06700
2134mm	2405WW-07900
2438mm	2405WW-09100
2743mm	2405WW-10300
3048mm	2405WW-11500
3353mm	2405WW-12700
3658mm	2405WW-13900
3962mm	2405WW-07196 2405WW-07900
4267mm	2405WW-07196 2405WW-09100
4572mm	2405WW-07196 2405WW-10300
4877mm	2405WW-07196 2405WW-11500
5182mm	2405WW-07196 2405WW-12700
5486mm	2405WW-07196 2405WW-13900

WW = Conveyor Width reference: 08, 10, 12

457mm to 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 6mm Dia. x 6mm long
8	450226SSP	Sleeve, 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 457mm
	240418	Center Rail Cross Support 533mm
	240419	Center Rail Cross Support 610mm
17	See Chart	Side Rail LH
18	4564WW	Drive Spindle 51mm
	2476WW	Nosebar Drive Spindle Lagged 51mm
19	980422M	Square Key 4mm x 22mm
20	See Chart	Conveyor Bed Plate
21	807-1105	Flat Head Torx Screw M6 x 10mm

Service Parts

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)
WW = Conveyor width reference: 18, 21, 24		

Item 13: Side Rail RH	
Length	Part Number
610mm	240412-01908
914mm	240412-03108
1219mm	240412-04308
1524mm	240412-05508
1829mm	240412-06708
2134mm	240412-07908
2438mm	240412-09108
2743mm	240412-10308
3048mm	240412-11508
3353mm	240412-12708
3658mm	240412-13908
3962mm	240412-07200 240412-07908
4267mm	240412-07200 240412-09108
4572mm	240412-07200 240412-10308
4877mm	240412-07200 240412-11508
5182mm	240412-07200 240412-12708
5486mm	240412-07200 240412-13908

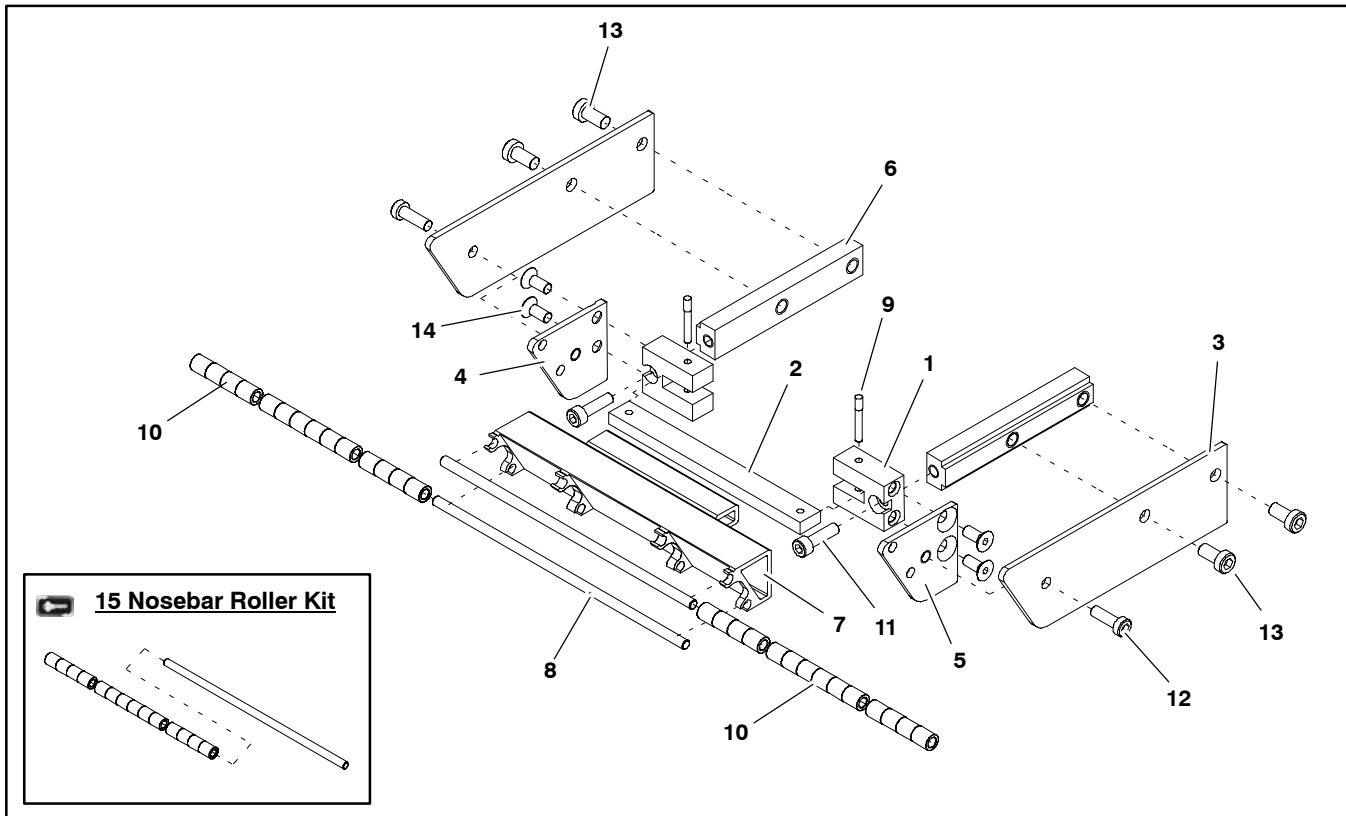
Item 14: Center Rail	
Length	Part Number
610mm	240414-00998
914mm	240414-02198
1219mm	240414-03398
1524mm	240414-04598
1829mm	240414-05798
2134mm	240414-06998
2438mm	240414-08198
2743mm	240414-09398
3048mm	240414-10598
3353mm	240414-11798
3658mm	240414-12998
3962mm	240414-06600 240414-06998
4267mm	240414-06600 240414-08198
4572mm	240414-06600 240414-09398
4877mm	240414-06600 240414-10598
5182mm	240414-06600 240414-11798
5486mm	240414-06600 240414-12998

Item 16: Side Rail LH	
Length	Part Number
610mm	240413-01908
914mm	240413-03108
1219mm	240413-04308
1524mm	240413-05508
1829mm	240413-06708
2134mm	240413-07908
2438mm	240413-09108
2743mm	240413-10308
3048mm	240413-11508
3353mm	240413-12708
3658mm	240413-13908
3962mm	240413-07200 240413-07908
4267mm	240413-07200 240413-09108
4572mm	240413-07200 240413-10308
4877mm	240413-07200 240413-11508
5182mm	240413-07200 240413-12708
5486mm	240413-07200 240413-13908

Item 17: Bed Plate	
Length	Part Number
610mm	2405WW-01900
914mm	2405WW-03100
1219mm	2405WW-04300
1524mm	2405WW-05500
1829mm	2405WW-06700
2134mm	2405WW-07900
2438mm	2405WW-09100
2743mm	2405WW-10300
3048mm	2405WW-11500
3353mm	2405WW-12700
3658mm	2405WW-13900
3962mm	2405WW-07196 2405WW-07900
4267mm	2405WW-07196 2405WW-09100
4572mm	2405WW-07196 2405WW-10300
4877mm	2405WW-07196 2405WW-11500
5182mm	2405WW-07196 2405WW-12700
5486mm	2405WW-07196 2405WW-13900
WW = Conveyor Width reference: 18, 21, 24	

Service Parts

Nosebar End Assembly

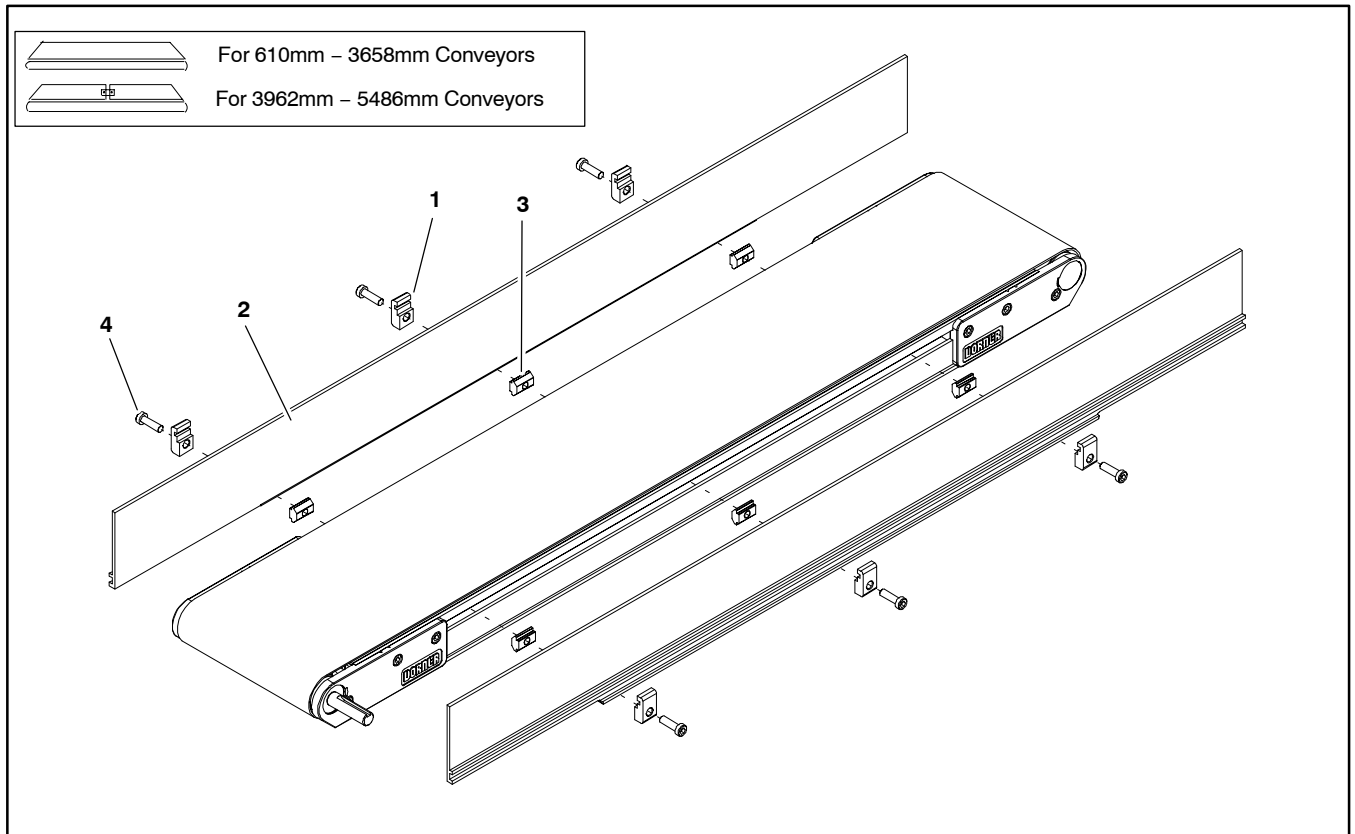


Item	Part Number	Description
1	201965	Mounting Block, PLT Spindle
2	2076WW	Flex-Link Bar
3	241125	Outer Side Plate
4	241126	Inner Side Plate LH
5	241127	Inner Side Plate RH
6	241128	Head Plate Bar
7	2412WW	Nosebar
8	2413WW	Nosebar Rod
9	200695P	Knurl Pin 3mm Dia x 24mm Lg

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 76mm Aluminum Side



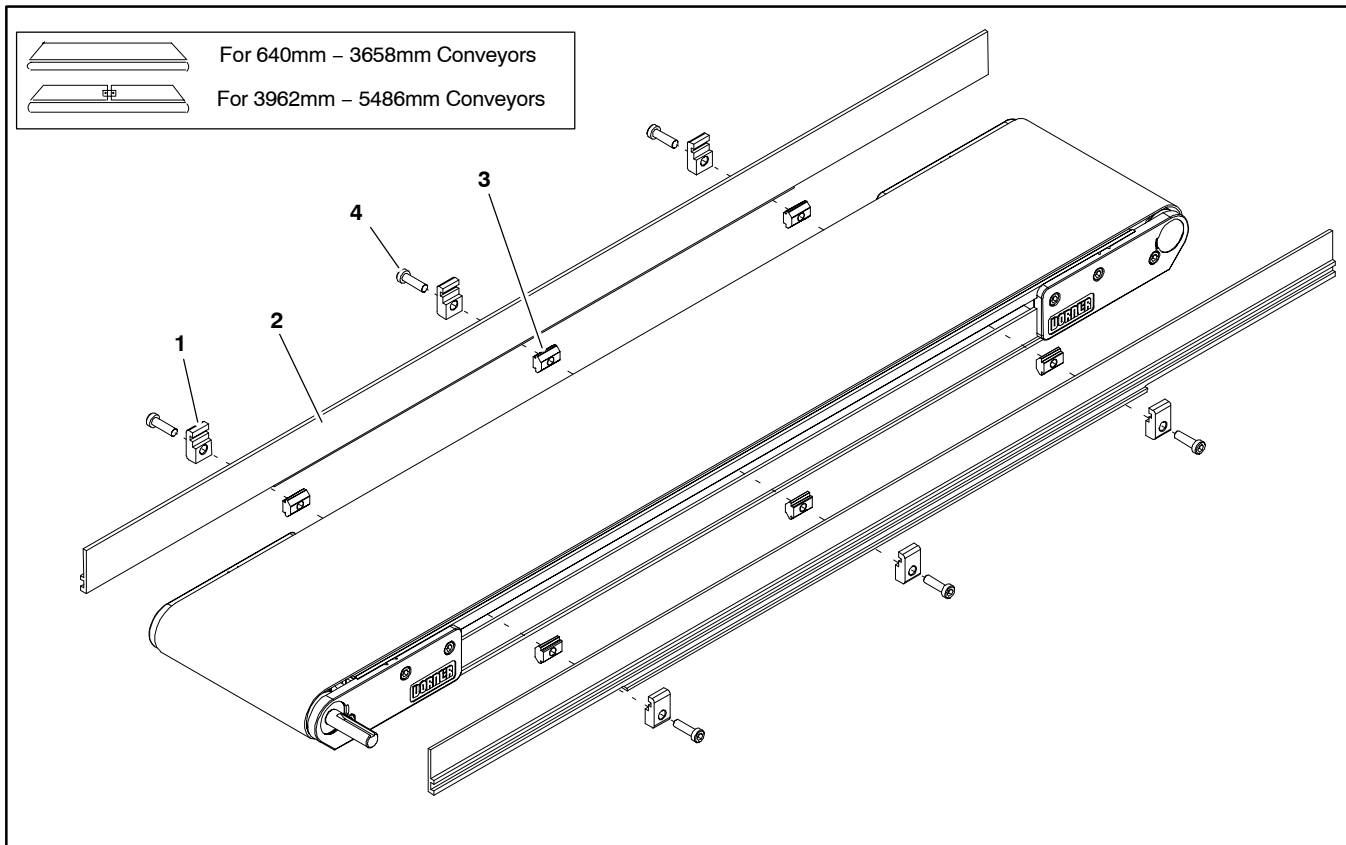
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 76mm HS
3	200695P	Single Drop-in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide 76mm HS			
Length		End Guide	End Guide
610mm	Left Hand	280403-02400	N/A
	Right Hand	280403-02400	N/A
914mm	Left Hand	280403-03600	N/A
	Right Hand	280403-03600	N/A
1219mm	Left Hand	280403-04800	N/A
	Right Hand	280403-04800	N/A
1524mm	Left Hand	280403-06000	N/A
	Right Hand	280403-06000	N/A
1829mm	Left Hand	280403-07200	N/A
	Right Hand	280403-07200	N/A
2134mm	Left Hand	280403-08400	N/A
	Right Hand	280403-08400	N/A
2438mm	Left Hand	280403-09600	N/A

2743mm	Right Hand	280403-09600	N/A
	Left Hand	280403-10800	N/A
3048mm	Right Hand	280403-10800	N/A
	Left Hand	280403-12000	N/A
3353mm	Right Hand	280403-12000	N/A
	Left Hand	280403-13200	N/A
3658mm	Right Hand	280403-13200	N/A
	Left Hand	280403-14400	N/A
3962mm	Left Hand	280401-07500	280401-08100
	Right Hand	280402-07500	280402-08100
4267mm	Left Hand	280401-07500	280401-09300
	Right Hand	280402-07500	280402-09300
4572mm	Left hand	280401-07500	280401-10500
	Right Hand	280402-07500	280402-10500
4877mm	Left Hand	280401-07500	280401-11700
	Right Hand	280402-07500	280402-11700
5182mm	Left Hand	280401-07500	280401-12900
	Right Hand	280402-07500	280402-12900
5486mm	Left Hand	280401-07500	280401-14100
	Right Hand	280402-07500	280402-14100

Service Parts

-05 38mm Aluminum Side

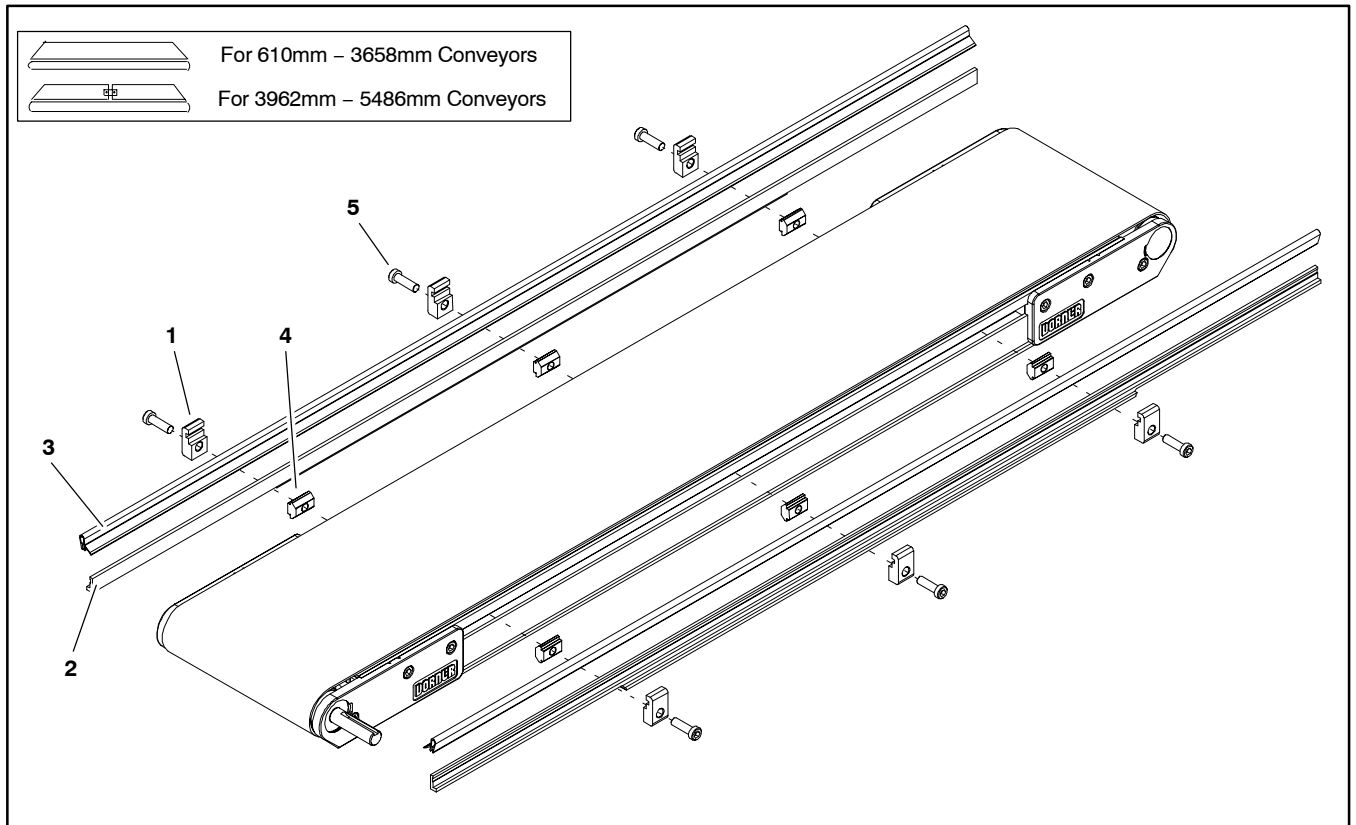


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 13mm HS
3	639971M	Single Drop-in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide 13mm HS			
Length		End Guide	End Guide
610mm	Left Hand	280503-02400	N/A
	Right Hand	280503-02400	N/A
914mm	Left Hand	280503-03600	N/A
	Right Hand	280503-03600	N/A
1219mm	Left Hand	280503-04800	N/A
	Right Hand	280503-04800	N/A
1524mm	Left Hand	280503-06000	N/A
	Right Hand	280503-06000	N/A
1829mm	Left Hand	280503-07200	N/A
	Right Hand	280503-07200	N/A
2134mm	Left Hand	280503-08400	N/A
	Right Hand	280503-08400	N/A
2438mm	Left Hand	280503-09600	N/A

2743mm	Right Hand	280503-09600	N/A
	Left Hand	280503-10800	N/A
3048mm	Right Hand	280503-10800	N/A
	Left Hand	280503-12000	N/A
3353mm	Right Hand	280503-12000	N/A
	Left Hand	280503-13200	N/A
3658mm	Right Hand	280503-13200	N/A
	Left Hand	280503-14400	N/A
3962mm	Right Hand	280503-14400	N/A
	Left Hand	280501-07500	280501-08100
4267mm	Right Hand	280502-07500	280502-08100
	Left Hand	280501-07500	280501-09300
4572mm	Right Hand	280502-07500	280502-09300
	Left hand	280501-07500	280501-10500
4877mm	Right Hand	280502-07500	280502-10500
	Left Hand	280501-07500	280501-11700
5182mm	Right Hand	280502-07500	280502-11700
	Left Hand	280501-07500	280501-12900
5486mm	Right Hand	280502-07500	280502-12900
	Left Hand	280501-07500	280501-14100
	Right Hand	280502-07500	280502-14100

-07 Low to Side Wiper



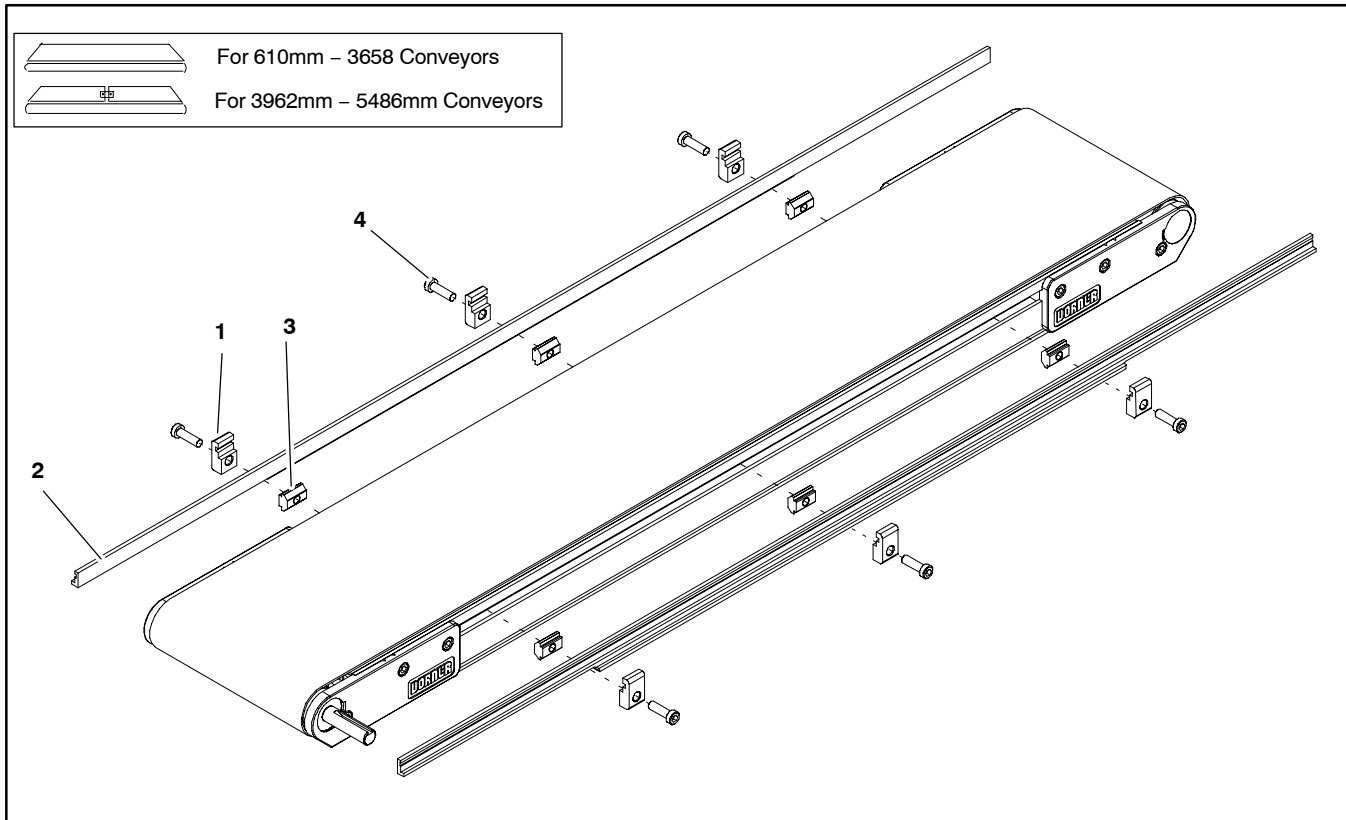
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 13mm HS
3	41-00-24	Side Wiper Nylatron (per foot)
4	639971M	Single Drop-in Tee Bar
5	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide 13mm HS			
Length		End Guide	End Guide
610mm	Left Hand	280903-02400	N/A
	Right Hand	280903-02400	N/A
914mm	Left Hand	280903-03600	N/A
	Right Hand	280903-03600	N/A
1219mm	Left Hand	280903-04800	N/A
	Right Hand	280903-04800	N/A
1524mm	Left Hand	280903-06000	N/A
	Right Hand	280903-06000	N/A
1829mm	Left Hand	280903-07200	N/A
	Right Hand	280903-07200	N/A
2134mm	Left Hand	280903-08400	N/A
	Right Hand	280903-08400	N/A
2438mm	Left Hand	280903-09600	N/A

2743mm	Right Hand	280903-09600	N/A
	Left Hand	280903-10800	N/A
3048mm	Right Hand	280903-10800	N/A
	Left Hand	280903-12000	N/A
3353mm	Right Hand	280903-12000	N/A
	Left Hand	280903-13200	N/A
3658mm	Right Hand	280903-13200	N/A
	Left Hand	280903-14400	N/A
3962mm	Right Hand	280903-14400	N/A
	Left Hand	280901-07500	280901-08100
4267mm	Right Hand	280902-07500	280902-08100
	Left Hand	280901-07500	280901-09300
4572mm	Right Hand	280902-07500	280902-09300
	Left hand	280901-07500	280901-10500
4877mm	Right Hand	280902-07500	280902-10500
	Left Hand	280901-07500	280901-11700
5182mm	Right Hand	280902-07500	280902-11700
	Left Hand	280901-07500	280901-12900
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

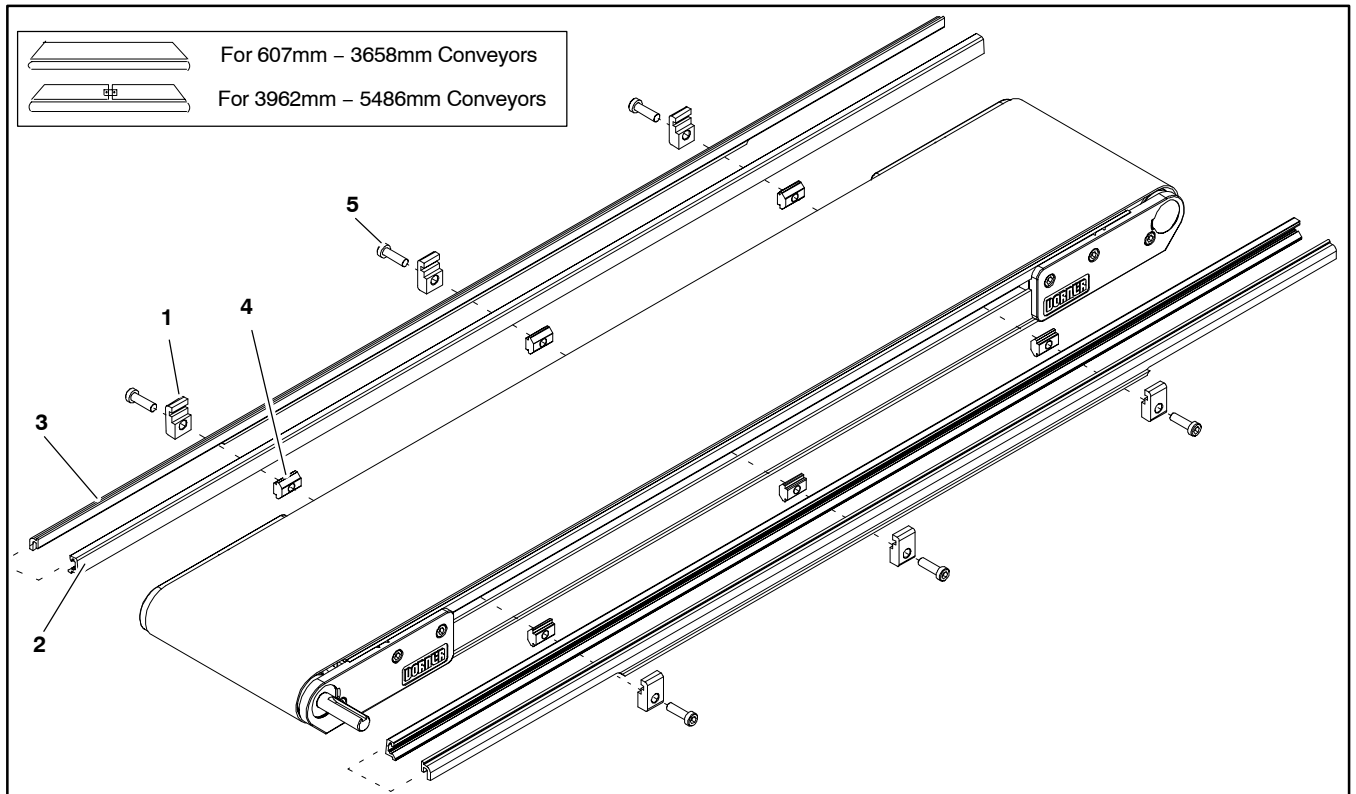


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 13mm HS
3	639971M	Single Drop-in Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide 13mm HS			
Length		End Guide	End Guide
610mm	Left Hand	280903-02400	N/A
	Right Hand	280903-02400	N/A
914mm	Left Hand	280903-03600	N/A
	Right Hand	280903-03600	N/A
1219mm	Left Hand	280903-04800	N/A
	Right Hand	280903-04800	N/A
1524mm	Left Hand	280903-06000	N/A
	Right Hand	280903-06000	N/A
1829mm	Left Hand	280903-07200	N/A
	Right Hand	280903-07200	N/A
2134mm	Left Hand	280903-08400	N/A
	Right Hand	280903-08400	N/A
2438mm	Left Hand	280903-09600	N/A

2743mm	Right Hand	280903-09600	N/A
	Left Hand	280903-10800	N/A
3048mm	Right Hand	280903-10800	N/A
	Left Hand	280903-12000	N/A
3353mm	Right Hand	280903-12000	N/A
	Left Hand	280903-13200	N/A
3658mm	Right Hand	280903-13200	N/A
	Left Hand	280903-14400	N/A
3962mm	Right Hand	280903-14400	N/A
	Left Hand	280901-07500	280901-08100
4267mm	Right Hand	280902-07500	280902-08100
	Left Hand	280901-07500	280901-09300
4572mm	Right Hand	280902-07500	280902-09300
	Left hand	280901-07500	280901-10500
4877mm	Right Hand	280902-07500	280902-10500
	Left Hand	280901-07500	280901-11700
5182mm	Right Hand	280902-07500	280902-11700
	Left Hand	280901-07500	280901-12900
5486mm	Right Hand	280902-07500	280902-12900
	Left Hand	280901-07500	280901-14100
	Right Hand	280902-07500	280902-14100

-10 13mm Extruded Plastic



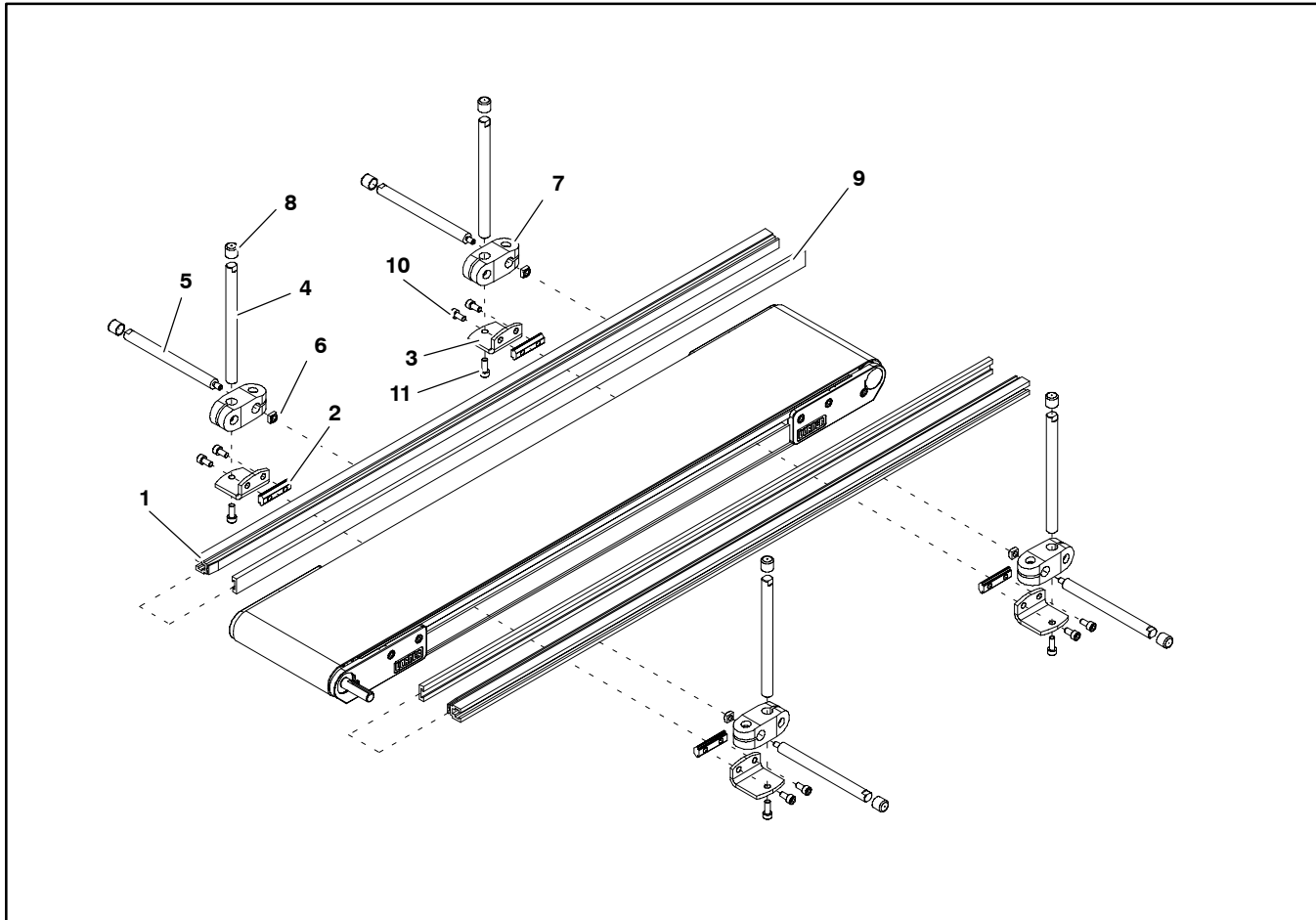
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	200054P	Snap-On Guide (per foot)
3	See Chart Below	2200 Guide
4	639971M	Single Drop-in Tee Bar
5	920694M	Socket Head Screw M6 x 20mm

Item 3: 2200 Guide			
Length		End Guide	End Guide
610mm	Left Hand	281003-02400	N/A
	Right Hand	281003-02400	N/A
914mm	Left Hand	281003-03600	N/A
	Right Hand	281003-03600	N/A
1219mm	Left Hand	281003-04800	N/A
	Right Hand	281003-04800	N/A
1524mm	Left Hand	281003-06000	N/A
	Right Hand	281003-06000	N/A
1829mm	Left Hand	281003-07200	N/A
	Right Hand	281003-07200	N/A
2134mm	Left Hand	281003-08400	N/A
	Right Hand	281003-08400	N/A
2438mm	Left Hand	281003-09600	N/A

2743mm	Right Hand	281003-09600	N/A
	Left Hand	281003-10800	N/A
3048mm	Right Hand	281003-10800	N/A
	Left Hand	281003-12000	N/A
3353mm	Right Hand	281003-12000	N/A
	Left Hand	281003-13200	N/A
3658mm	Right Hand	281003-13200	N/A
	Left Hand	281003-14400	N/A
3962mm	Right Hand	281003-14400	N/A
	Left Hand	281001-07500	281001-08100
4267mm	Right Hand	281002-07500	281002-08100
	Left Hand	281001-07500	281001-09300
4572mm	Right Hand	281002-07500	281002-09300
	Left hand	281001-07500	281001-10500
4877mm	Right Hand	281002-07500	281002-10500
	Left Hand	281001-07500	281001-11700
5182mm	Right Hand	281002-07500	281002-11700
	Left Hand	281001-07500	281001-12900
5486mm	Right Hand	281002-07500	281002-12900
	Left Hand	281001-07500	281001-14100
	Right Hand	281002-07500	281002-14100

Service Parts

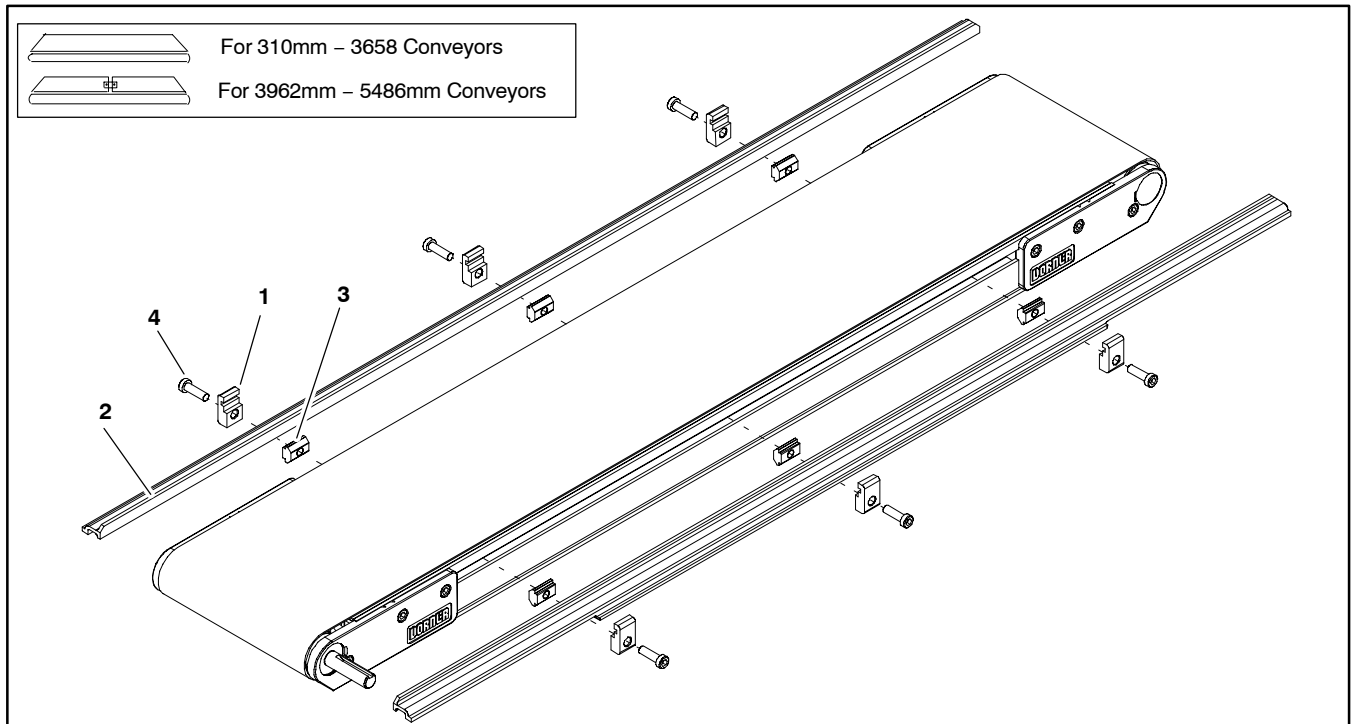
-13 Adjustable Guiding



Item	Part Number	Description
1	202983	Aluminum Profile Guide 610mm
	202984	Aluminum Profile Guide 914mm
	202985	Aluminum Profile Guide 1219mm
	202986	Aluminum Profile Guide 1524mm
	202987	Aluminum Profile Guide 1829mm
	202988	Aluminum Profile Guide 2134mm
	202989	Aluminum Profile Guide 2438mm
	202990	Aluminum Profile Guide 2743mm
	202991	Aluminum Profile Guide 3048mm
	202992	Aluminum Profile Guide 3353mm
	202993	Aluminum Profile Guide 3658mm
	202994	Aluminum Profile Guide 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

13mm Cleated Belt Guiding



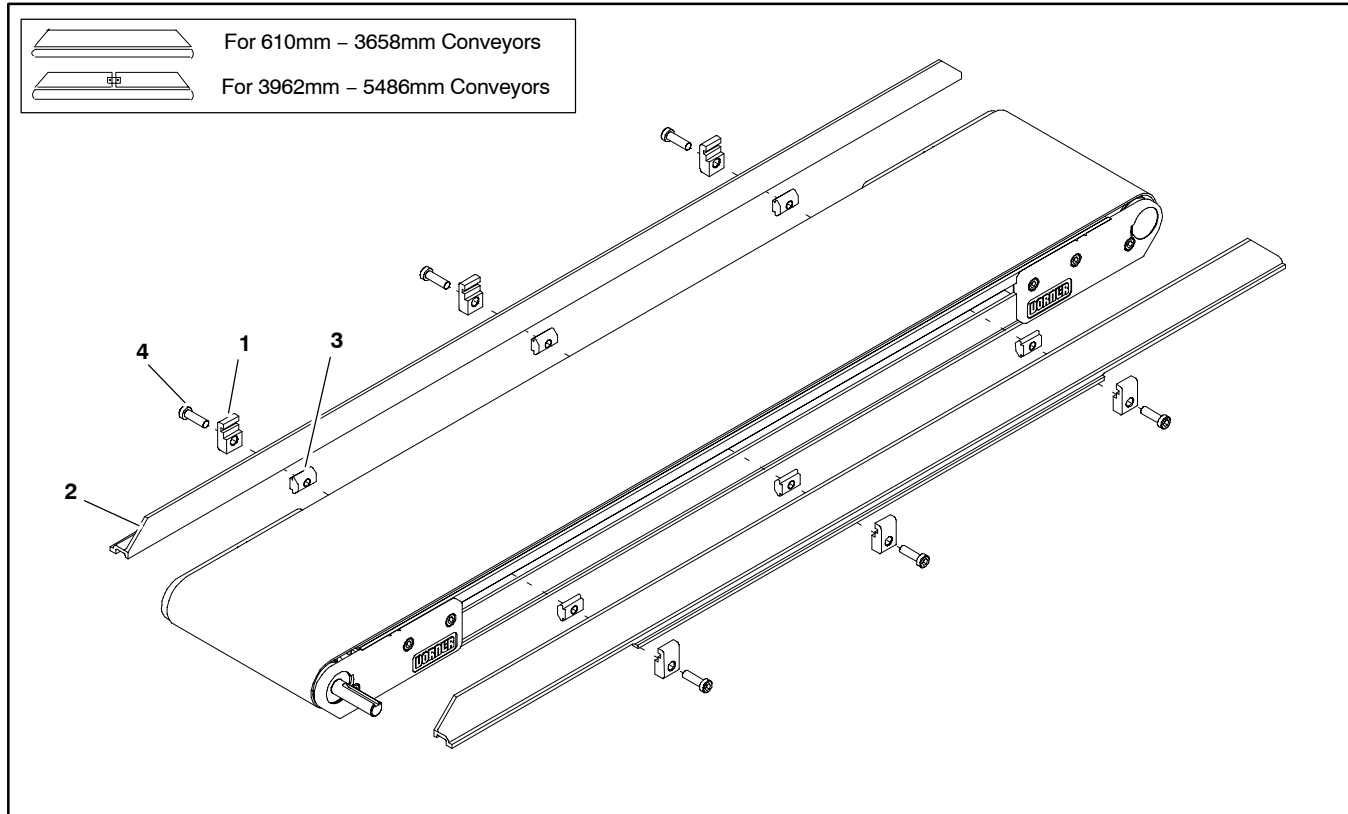
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 13mm Cleated
3	639971M	Drop-In Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
610mm	Left Hand	281603-02256	N/A
	Right Hand	281603-02256	N/A
914mm	Left Hand	281603-03456	N/A
	Right Hand	281603-03456	N/A
1219mm	Left Hand	281603-04656	N/A
	Right Hand	281603-04656	N/A
1524mm	Left Hand	281603-05856	N/A
	Right Hand	281603-05856	N/A
1829mm	Left Hand	281603-07056	N/A
	Right Hand	281603-07056	N/A
2134mm	Left Hand	281603-08256	N/A
	Right Hand	281603-08256	N/A
2438mm	Left Hand	281603-09456	N/A

2743mm	Right Hand	281603-09456	N/A
	Left Hand	281603-10656	N/A
3048mm	Right Hand	281603-10656	N/A
	Left Hand	281603-11856	N/A
3353mm	Right Hand	281603-11856	N/A
	Left Hand	281603-13056	N/A
3658mm	Right Hand	281603-13056	N/A
	Left Hand	281603-14256	N/A
3962mm	Right Hand	281603-14256	N/A
	Left Hand	281601-07428	281601-08028
4267mm	Right Hand	281602-07428	281602-08028
	Left Hand	281601-07428	281601-09228
4572mm	Right Hand	281602-07428	281602-09228
	Left hand	281601-07428	281601-10428
4877mm	Right Hand	281602-07428	281602-10428
	Left Hand	281601-07428	281601-11628
5182mm	Right Hand	281602-07428	281602-11628
	Left Hand	281601-07428	281601-12828
5486mm	Right Hand	281602-07428	281602-12828
	Left Hand	281601-07428	281601-14028
	Right Hand	281602-07428	281602-14028

Service Parts

25mm Cleated Belt Guiding

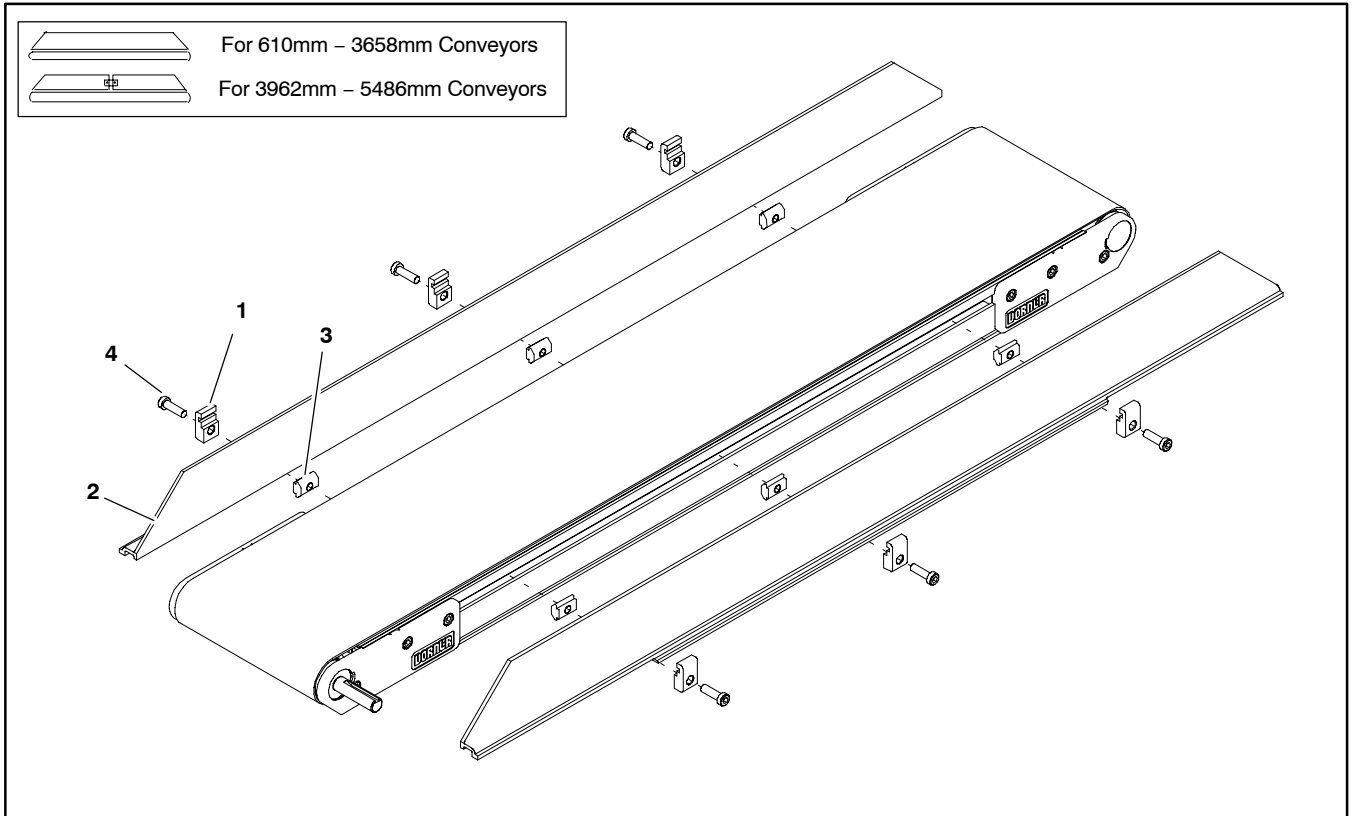


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 25mm Cleated
3	639971M	Drop-In Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
610mm	Left Hand	281703-02256	N/A
	Right Hand	281703-02256	N/A
914mm	Left Hand	281703-03456	N/A
	Right Hand	281703-03456	N/A
1219mm	Left Hand	281703-04656	N/A
	Right Hand	281703-04656	N/A
1524mm	Left Hand	281703-05856	N/A
	Right Hand	281703-05856	N/A
1829mm	Left Hand	281703-07056	N/A
	Right Hand	281703-07056	N/A
2134mm	Left Hand	281703-08256	N/A
	Right Hand	281703-08256	N/A
2438mm	Left Hand	281703-09456	N/A

	Right Hand	281703-09456	N/A
2743mm	Left Hand	281703-10656	N/A
	Right Hand	281703-10656	N/A
3048mm	Left Hand	281703-11856	N/A
	Right Hand	281703-11856	N/A
3353mm	Left Hand	281703-13056	N/A
	Right Hand	281703-13056	N/A
3658mm	Left Hand	281703-14256	N/A
	Right Hand	281703-14256	N/A
3962mm	Left Hand	281701-07428	281701-08028
	Right Hand	281702-07428	281702-08028
4267mm	Left Hand	281701-07428	281701-09228
	Right Hand	281702-07428	281702-09228
4572mm	Left hand	281701-07428	281701-10428
	Right Hand	281702-07428	281702-10428
4877mm	Left Hand	281701-07428	281701-11628
	Right Hand	281702-07428	281702-11628
5182mm	Left Hand	281701-07428	281701-12828
	Right Hand	281702-07428	281702-12828
5486mm	Left Hand	281701-07428	281701-14028
	Right Hand	281702-07428	281702-14028

51mm Cleated Belt Guiding



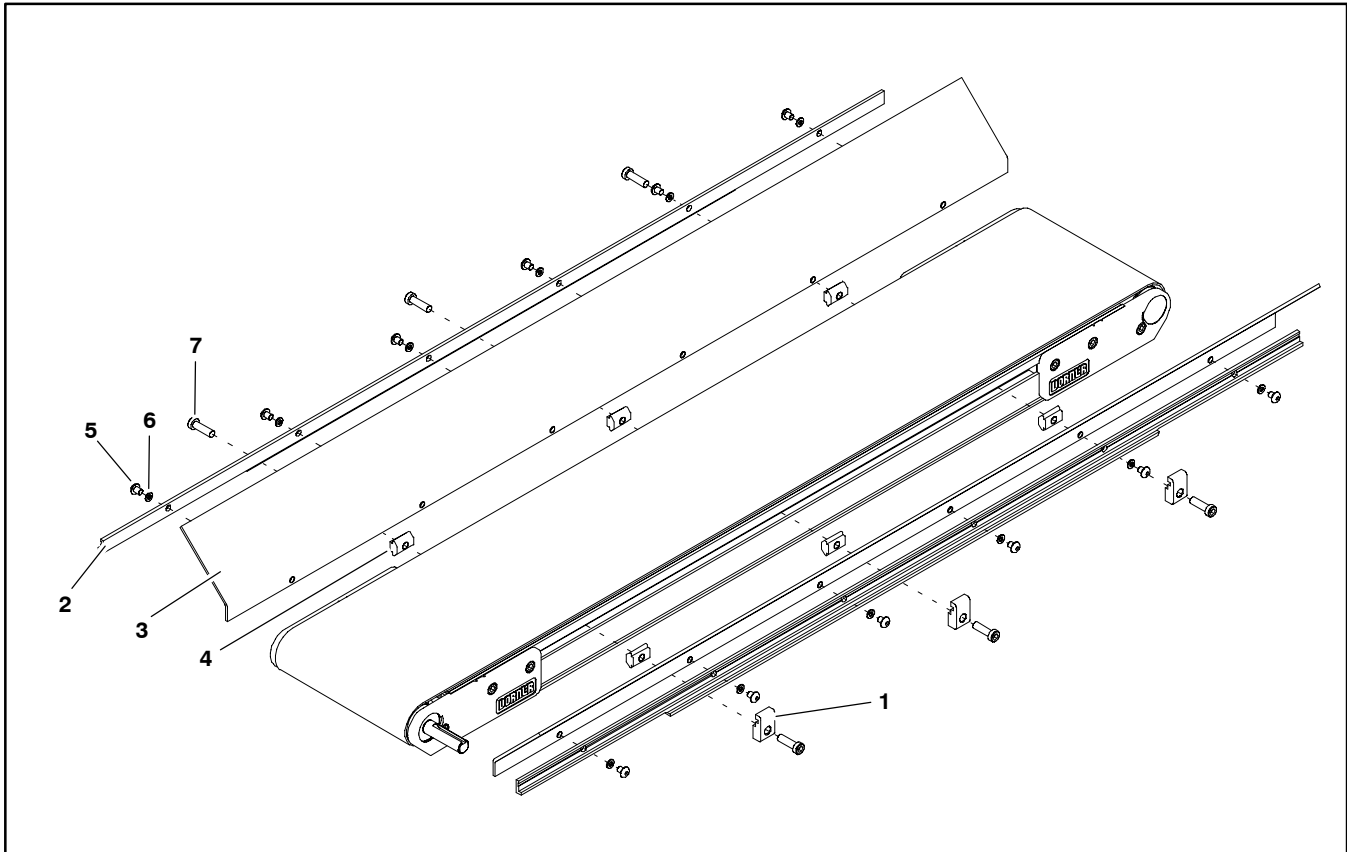
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 58mm Cleated
3	639971M	Drop-In Tee Bar
4	920694M	Socket Head Screw M6 x 20mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
610mm	Left Hand	281903-02256	N/A
	Right Hand	281903-02256	N/A
914mm	Left Hand	281903-03456	N/A
	Right Hand	281903-03456	N/A
1219mm	Left Hand	281903-04656	N/A
	Right Hand	281903-04656	N/A
1524mm	Left Hand	281903-05856	N/A
	Right Hand	281903-05856	N/A
1829mm	Left Hand	281903-07056	N/A
	Right Hand	281903-07056	N/A
2134mm	Left Hand	281903-08256	N/A
	Right Hand	281903-08256	N/A
2438mm	Left Hand	281903-09456	N/A

	Right Hand	281903-09456	N/A
2743mm	Left Hand	281903-10656	N/A
	Right Hand	281903-10656	N/A
3048mm	Left Hand	281903-11856	N/A
	Right Hand	281903-11856	N/A
3353mm	Left Hand	281903-13056	N/A
	Right Hand	281903-13056	N/A
3658mm	Left Hand	281903-14256	N/A
	Right Hand	281903-14256	N/A
3962mm	Left Hand	281901-07428	281901-08028
	Right Hand	281902-07428	281902-08028
4267mm	Left Hand	281901-07428	281901-09228
	Right Hand	281902-07428	281902-09228
4572mm	Left hand	281901-07428	281901-10428
	Right Hand	281902-07428	281902-10428
4877mm	Left Hand	281901-07428	281901-11628
	Right Hand	281902-07428	281902-11628
5182mm	Left Hand	281901-07428	281901-12828
	Right Hand	281902-07428	281902-12828
5486mm	Left Hand	281901-07428	281901-14028
	Right Hand	281902-07428	281902-14028

Service Parts

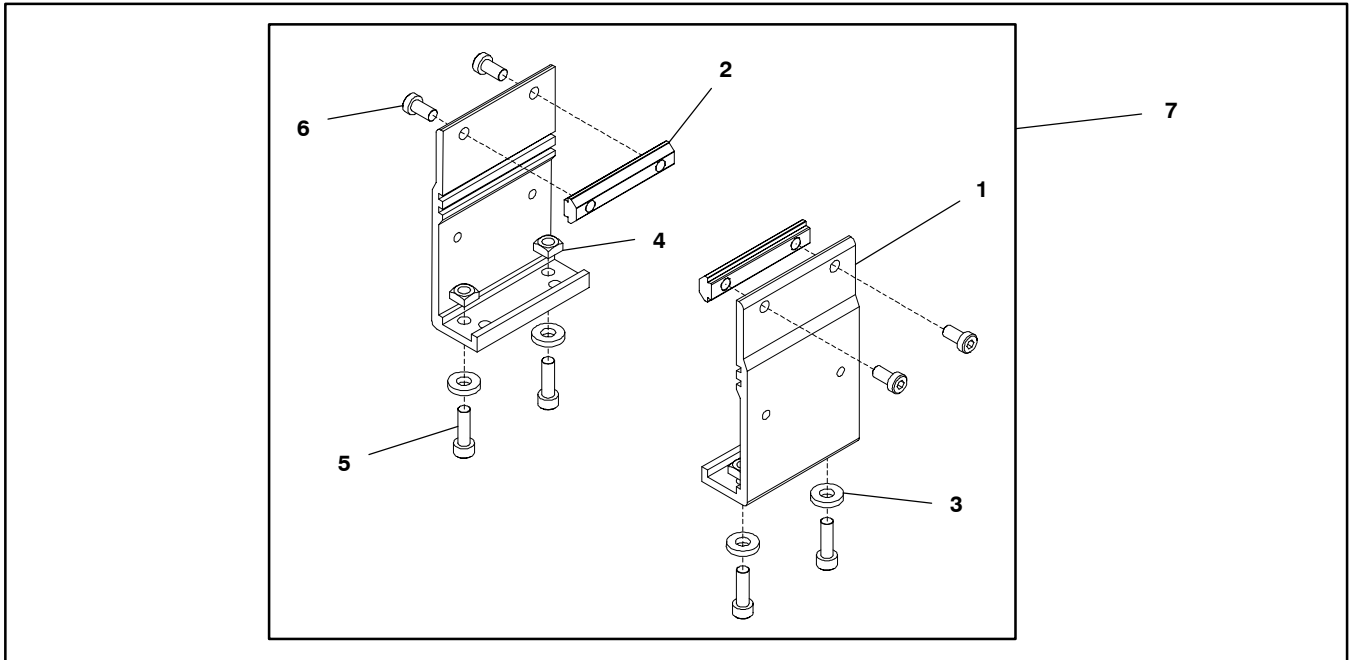
Flared Side Guiding



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	202212	Side-Flare Mounting Guide 610mm
	202213	Side-Flare Mounting Guide 914mm
	202214	Side-Flare Mounting Guide 1219mm
	202215	Side-Flare Mounting Guide 1524mm
	202216	Side-Flare Mounting Guide 1829mm
3	202522M	Flared Guide 45° 610mm

	202523M	Flared Guide 45° 914mm
	202523M	Flared Guide 45° 1219mm
	202523M	Flared Guide 45° 1524mm
	202523M	Flared Guide 45° 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

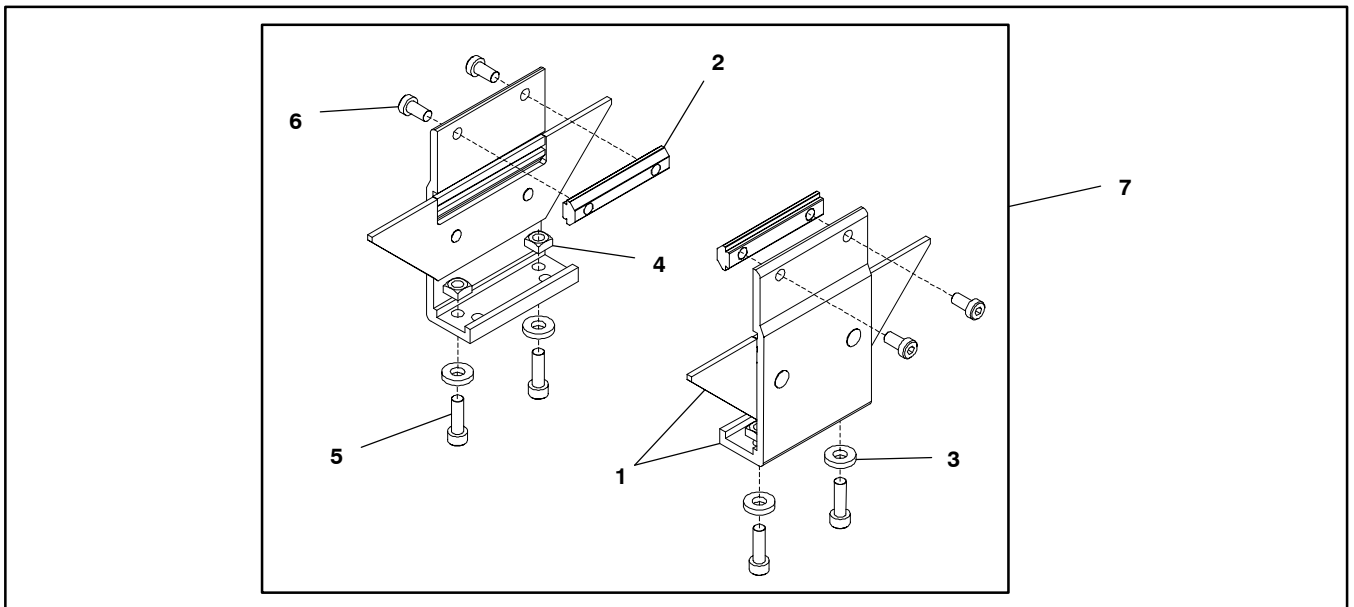
Flat Belt Stand Mount Assembly



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

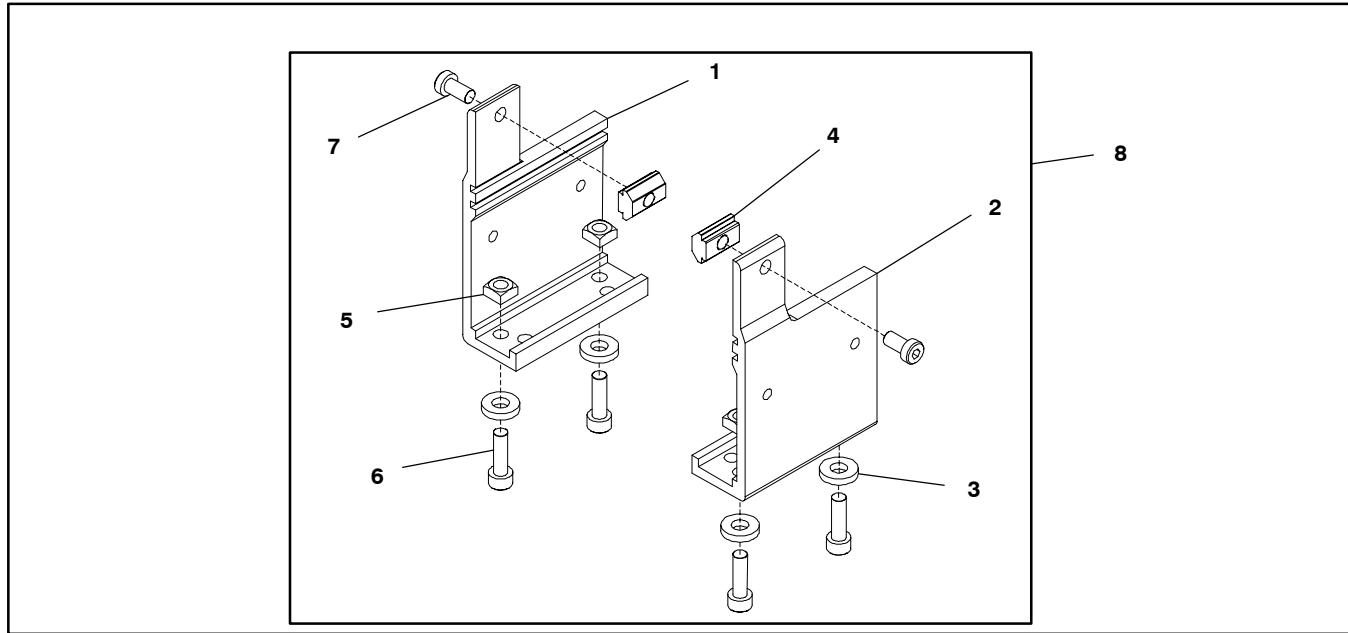


Item	Part Number	Description
1	240836	Cleated Mount Assembly
2	300150M	Drop-In Tee Bar
3	605279P	Washer

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

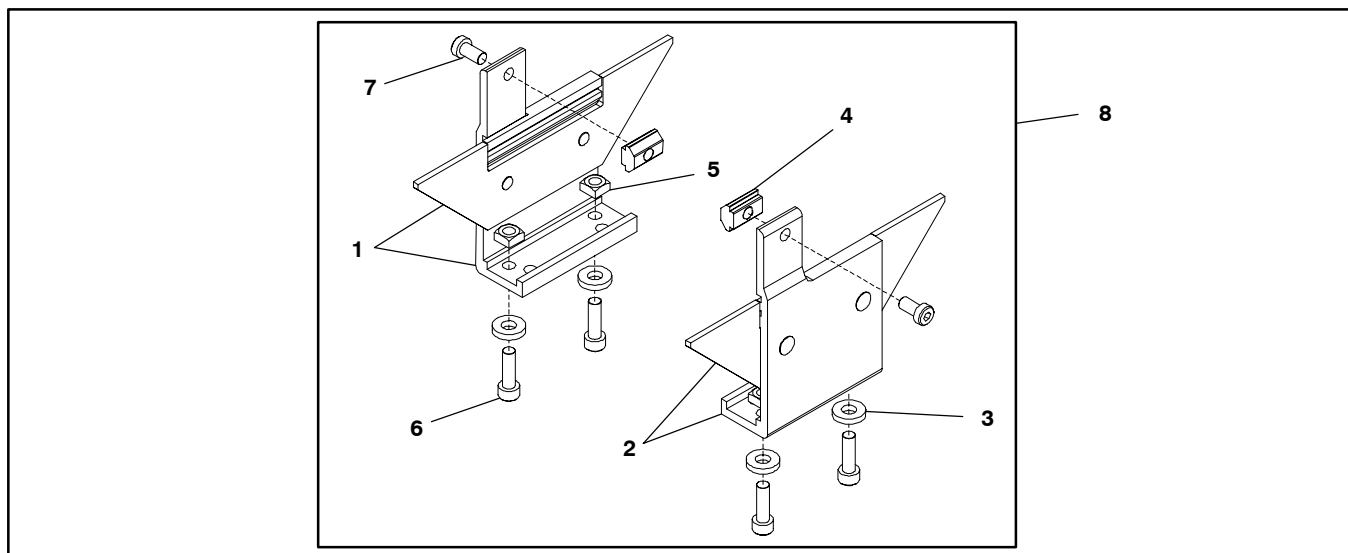
Flat Belt Stand Mount Assembly for 610mm Conveyors



Item	Part Number	Description
1	240833	Stand Mount, LH 610mm
2	240834	Stand Mount, RH 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 610mm Conveyors

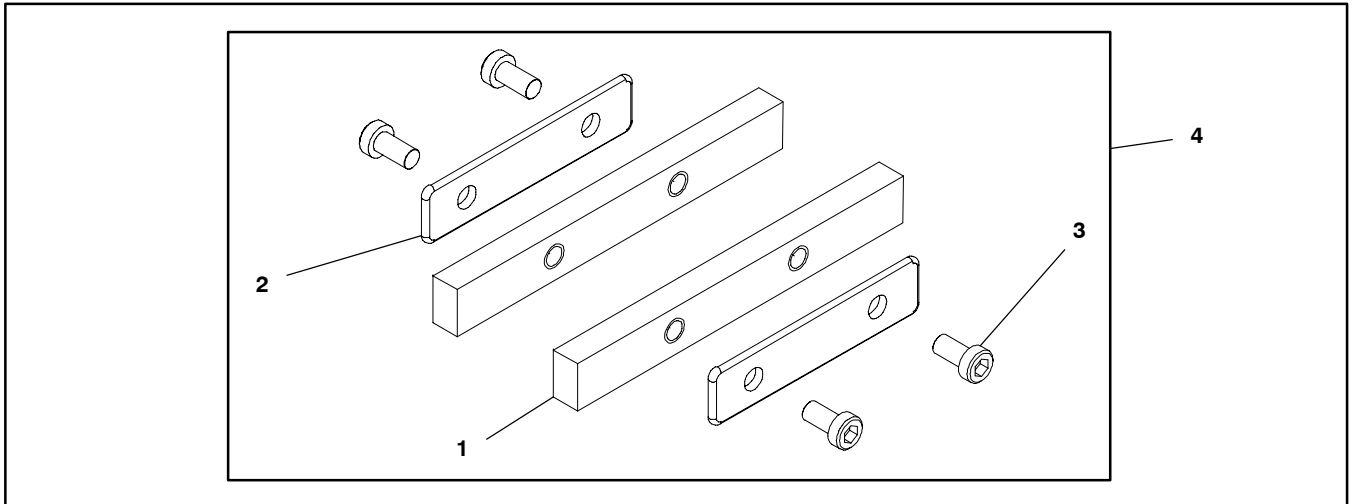
Cleated Belt Stand Mount Assembly for 610mm Conveyors



Item	Part Number	Description
1	240852	Cleated Stand Bracket Assembly LH 610mm Conveyor
2	240853	Cleated Stand Bracket Assembly RH 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 610mm Conveyors

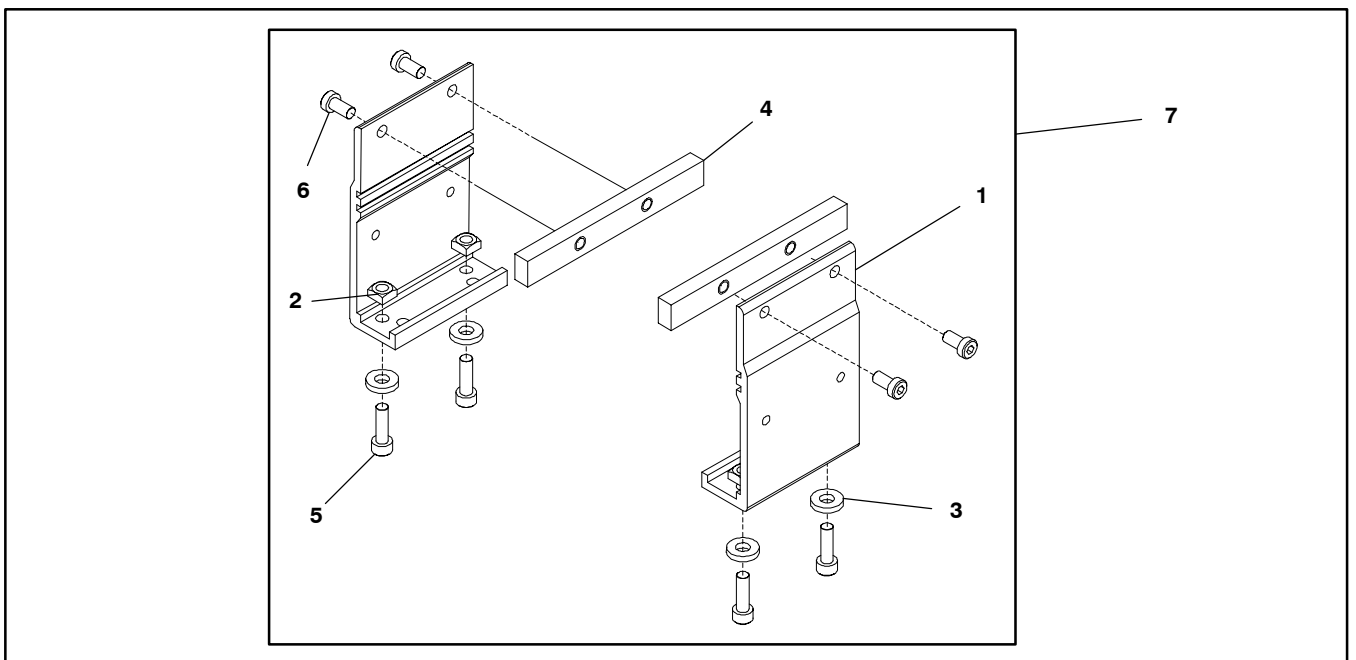
Connecting Assembly without Stand Mount



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

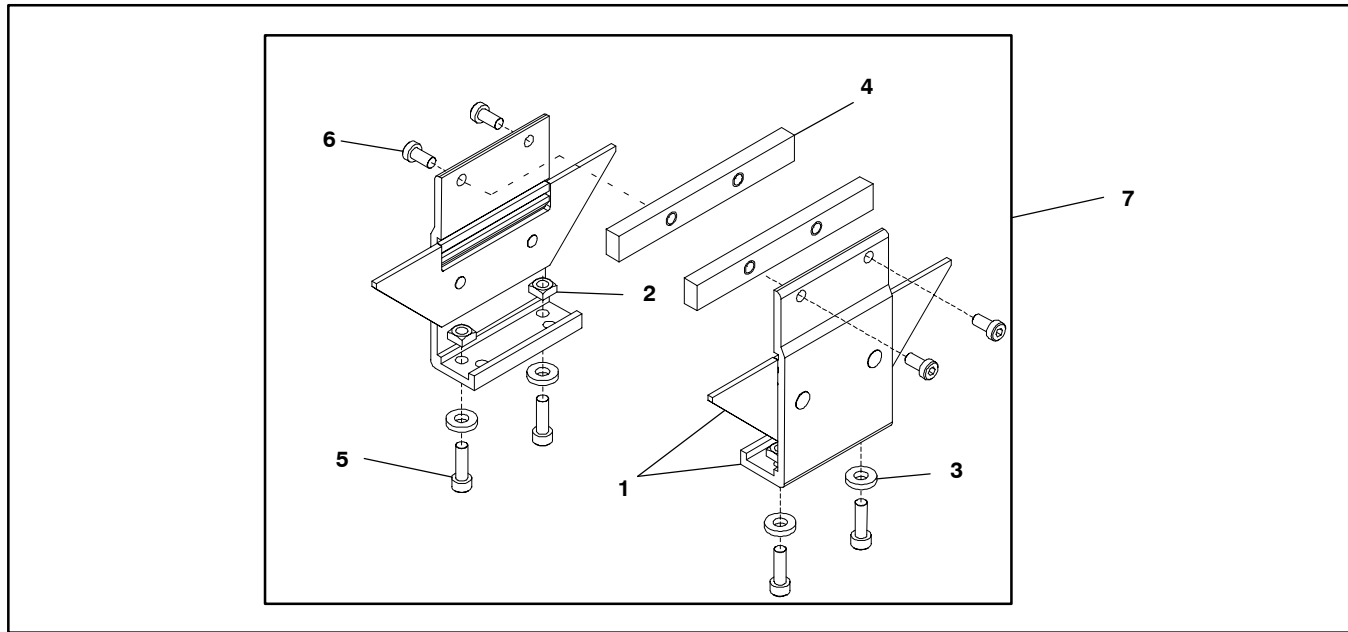


Item	Part Number	Description
1	240831	Stand Mount
2	807-920	Square Nut M6 5mm x 10mm
3	605279P	Washer
4	240858	Frame Connector Bar

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

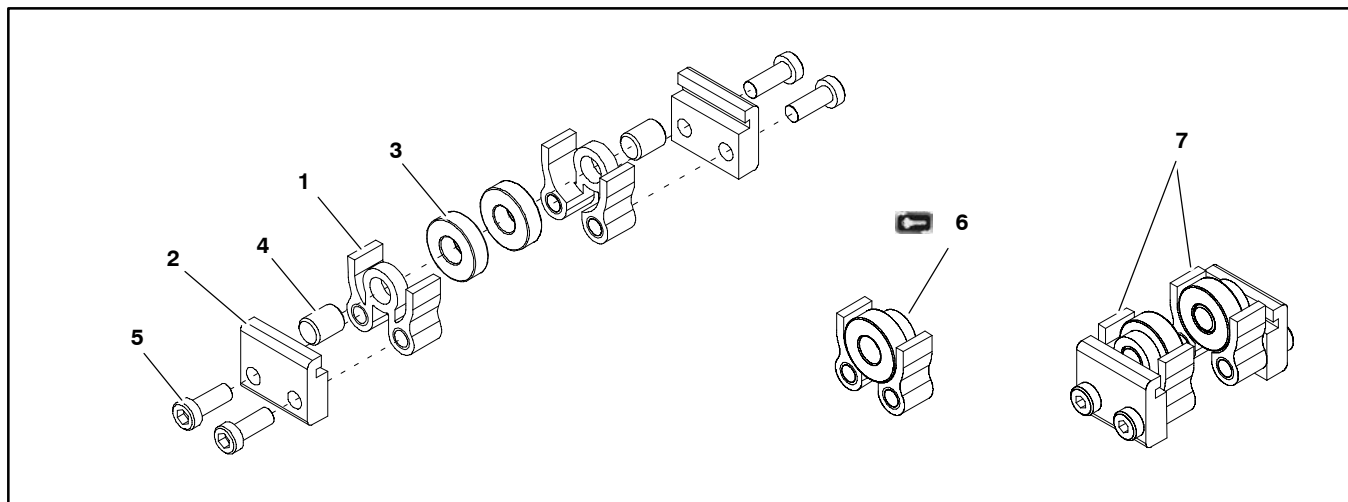
Cleated Belt Connecting Assembly with Stand Mount



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

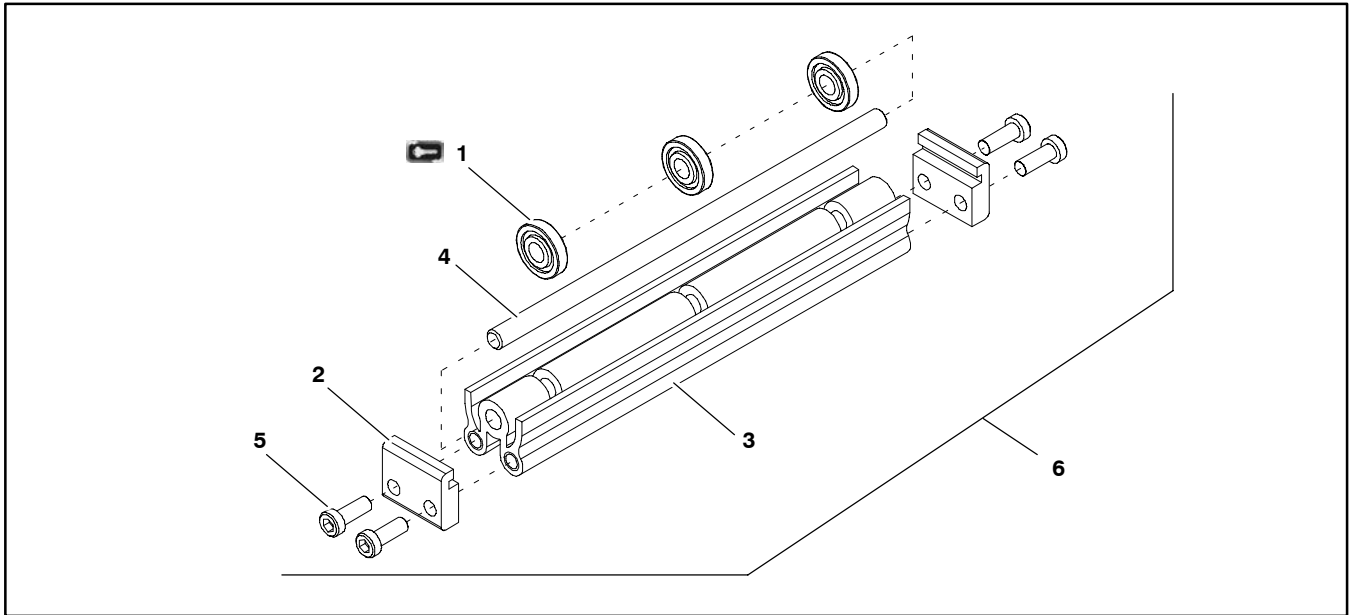
51mm to 152mm Flat Belt Return Roller



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	51mm to 152mm Flat Belt Return Roller Assy

203mm to 610mm Flat Belt Return Roller

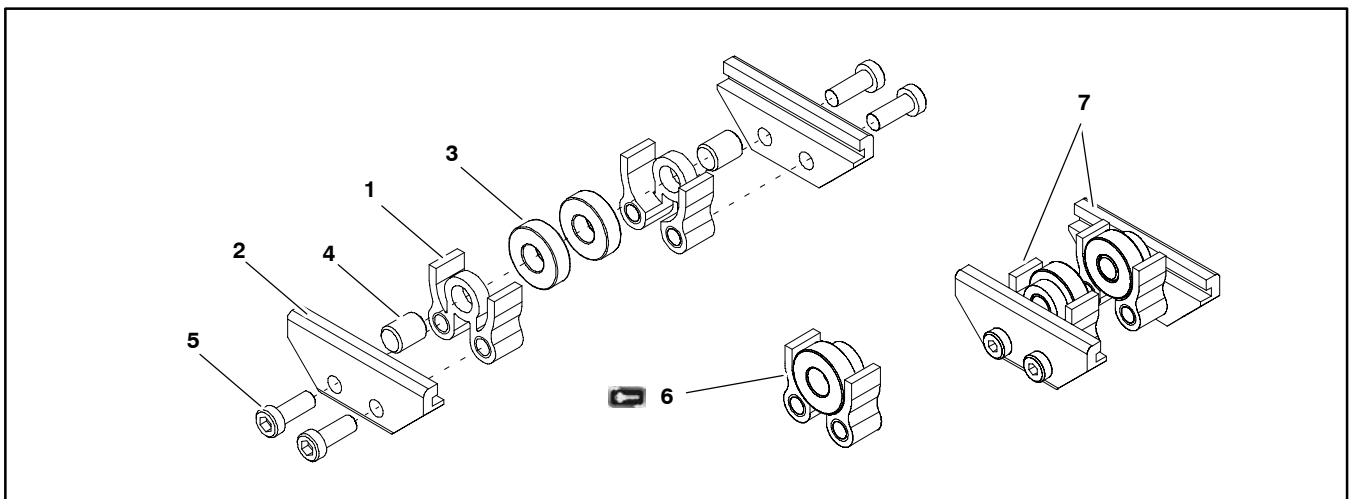


Item	Part Number	Description
1	240826	Return Roller
2	240827	Return Roller Clip
3	2409WW	Return Roller Guard
4	2410WW	Return Roller Rod

5	920693M	Socket Low Head Screw M6 x 16mm
6	2408WW	203mm to 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

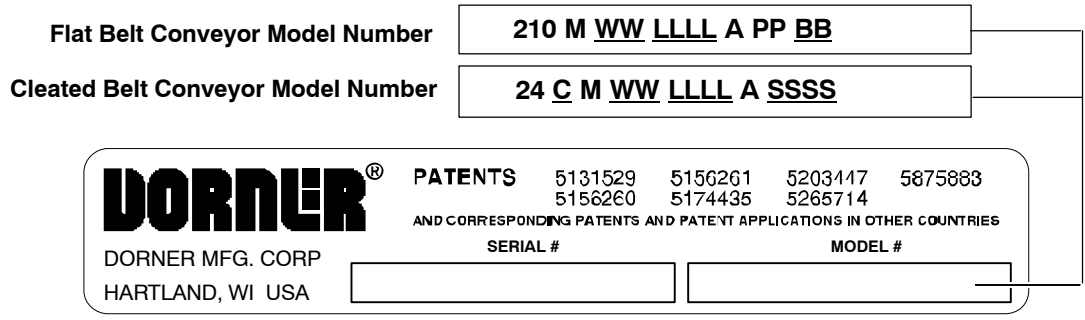


Figure 43

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)

Return Policy

No returns will be accepted without prior written factory authorization. When calling for authorization, please have the following information ready for the Dorner Factory representative or your local distributor:

1. Name and address of customer.
2. Item(s) being returned.
3. Reason for return.
4. Customer's original order number used when ordering the item(s).
5. Dorner or distributor invoice number.

A representative will discuss action to be taken on the Returned items and provide a Returned Goods Authorization Number to reference.

There will be a 15% restocking charge on all new items returned for credit where Dorner was not at fault. These will not be accepted after 60 days from original invoice date. The restocking charge covers inspection, cleaning, disassembly, and reissuing to inventory.

If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Feel free to contact Dorner for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dorner products.

For a copy of Dorner's Limited Warranty, contact factory, distributor, service center or visit our website at www.dorner.com.

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

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