

MPB Series End Drive Conveyors

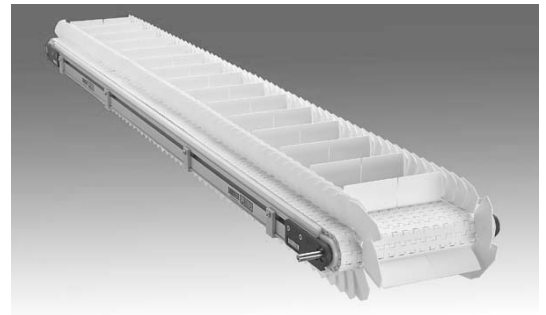
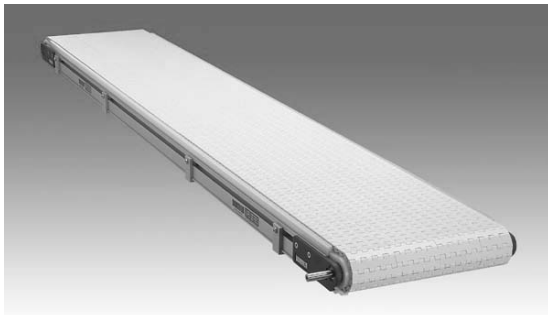
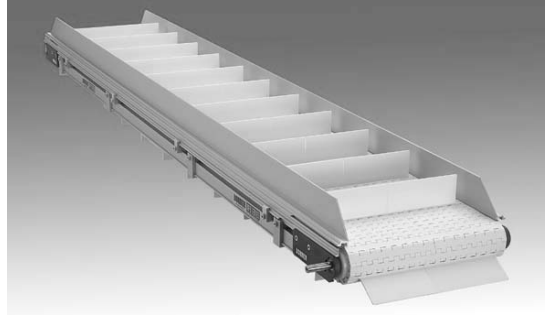


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Warnings – General Safety

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

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

| | |
|---|----------------|
| | WARNING |
| <p>MPB Series Conveyors are not reversible. Reversing creates pinch points which can cause severe injury. DO NOT REVERSE MPB SERIES CONVEYORS.</p> | |

| | |
|---|----------------|
| | WARNING |
| <p>For MPB Series Flat and Cleated Belt Conveyors, Top and Bottom Mount Gearmotors must be mounted as shown below. Failure to do so creates pinch points which can cause severe injury.</p> | |
| | |
| <p>Flat Belt Bottom Mount Cleated Belt Top Mount</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> | |

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 MPB & 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981 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 | Support Stand |
| H | Drive End |
| I | Idler/Tension End |

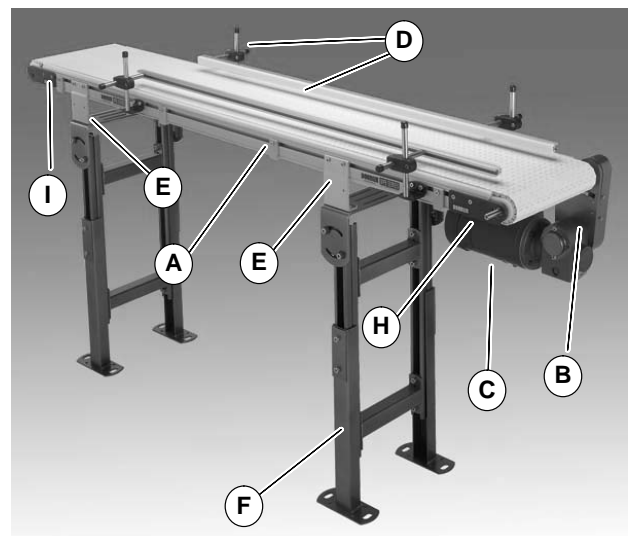


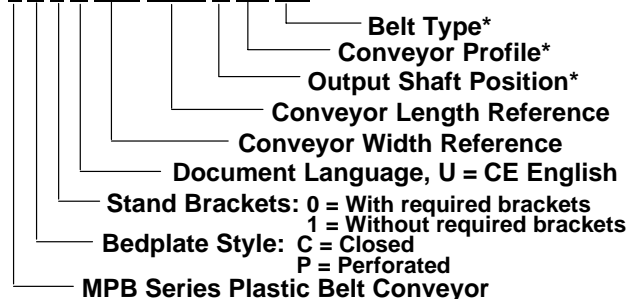
Figure 1

Specifications

Models:

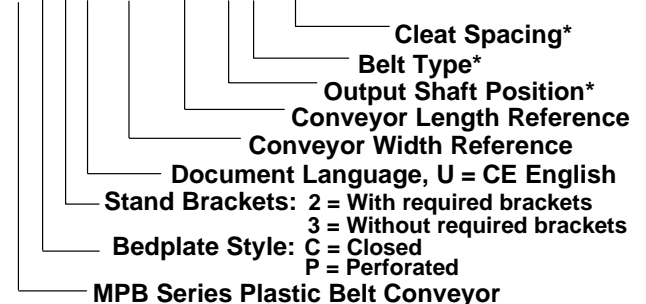
Flat Belt MPB Series Conveyor

2 P 0 U WW LLLL A PP BB



Cleated Belt MPB Series Conveyor

2 P 2 U WW LLLL A BB SS



* See Ordering and Specifications Catalog for details.

Specifications

Conveyor Supports:

Maximum Distances:

J = 18" (457 mm)**

K = 6 ft (1829 mm)***

L = 18" (457 mm)

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

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

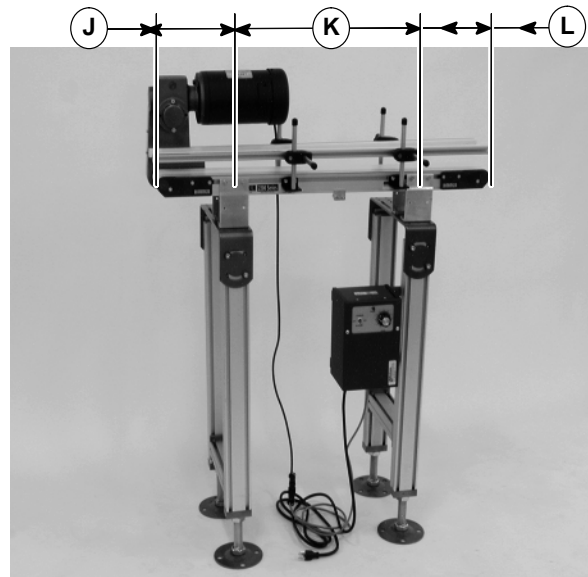


Figure 2

Specifications:

| | | | | | |
|--------------------------------|---|---------------|----------------|----------------|----------------|
| Conveyor Width Reference (WW) | 04 | 06 | 12 | 18 | 24 |
| Conveyor Belt Width | 3.0" (76mm) | 5.25" (133mm) | 11.25" (286mm) | 17.25" (438mm) | 23.25" (591mm) |
| Conveyor Length Reference (LL) | 0200 to 3000 in 0002 increments | | | | |
| Conveyor Length | 2 ft (610mm) to 30 ft (9144mm) in 0.24" (6mm) increments | | | | |
| Belt Travel | 8.1" (209 mm) per revolution of pulley | | | | |
| Maximum Belt Speed* | 250 ft/minute (76.2 m/minute) for flat belt models 150 ft/minute (45.7 m/minute) for cleated belt models | | | | |
| Belt Takeup | 1.5" (38 mm) of stroke = 3" (76 mm) of belt take-up | | | | |

No Load Torque

NOTES:

1. No Load torques are for Flat Belt conveyors only. For No Load torques on Cleated and Sidewall Cleated Conveyors contact the factory.
2. The torque required to overcome the conveyor's

- initial startup inertia may temporarily exceed the average "no load" torque by a factor of 2 to 3 times.
3. Stated torques are average values based on Dorner standard belts running at 50' (15meters) per minute.

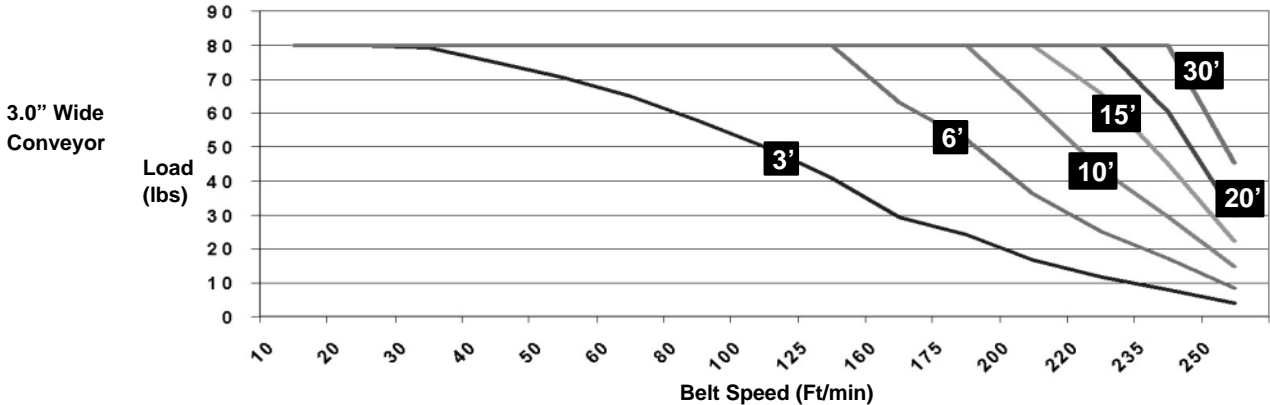
No Load Torque Data

| Length (feet) | Width | | | | | | | | | |
|------------------|-------------|-----|---------------|-----|----------------|-----|----------------|-----|----------------|-----|
| | 3.0" (76mm) | | 5.25" (133mm) | | 11.25" (286mm) | | 17.25" (438mm) | | 23.25" (591mm) | |
| | in-lbs | N-m | in-lbs | N-m | in-lbs | N-m | in-lbs | N-m | in-lbs | N-m |
| 2 | 5 | 0.6 | 6 | 0.6 | 6 | 0.7 | 7 | 0.8 | 7 | 0.8 |
| 3 | 5 | 0.6 | 6 | 0.7 | 7 | 0.8 | 8 | 0.9 | 8 | 1.0 |
| 4 | 6 | 0.6 | 6 | 0.7 | 7 | 0.8 | 8 | 1.0 | 10 | 1.1 |
| 5 | 6 | 0.7 | 6 | 0.7 | 8 | 0.9 | 9 | 1.0 | 11 | 1.2 |
| 6 | 6 | 0.7 | 7 | 0.7 | 8 | 0.9 | 10 | 1.1 | 12 | 1.3 |
| 7 | 6 | 0.7 | 7 | 0.8 | 9 | 1.0 | 11 | 1.2 | 13 | 1.5 |
| 8 | 6 | 0.7 | 7 | 0.8 | 9 | 1.1 | 12 | 1.3 | 14 | 1.6 |
| 9 | 6 | 0.7 | 7 | 0.8 | 10 | 1.1 | 13 | 1.4 | 15 | 1.7 |
| 10 | 7 | 0.7 | 8 | 0.9 | 11 | 1.2 | 14 | 1.5 | 16 | 1.9 |
| 11 | 7 | 0.8 | 8 | 0.9 | 11 | 1.3 | 14 | 1.6 | 18 | 2.0 |
| 12 | 7 | 0.8 | 8 | 0.9 | 12 | 1.3 | 15 | 1.7 | 19 | 2.1 |
| 13 | 7 | 0.8 | 8 | 0.9 | 12 | 1.4 | 16 | 1.8 | 20 | 2.3 |
| 14 | 7 | 0.8 | 9 | 1.0 | 13 | 1.4 | 17 | 1.9 | 21 | 2.4 |
| 15 | 7 | 0.8 | 9 | 1.0 | 13 | 1.5 | 18 | 2.0 | 22 | 2.5 |
| 16 | 8 | 0.9 | 9 | 1.0 | 14 | 1.6 | 19 | 2.1 | 23 | 2.6 |
| 17 | 8 | 0.9 | 9 | 1.1 | 14 | 1.6 | 19 | 2.2 | 25 | 2.8 |
| 18 | 8 | 0.9 | 10 | 1.1 | 15 | 1.7 | 20 | 2.3 | 26 | 2.9 |
| 19 | 8 | 0.9 | 10 | 1.1 | 16 | 1.8 | 21 | 2.4 | 27 | 3.0 |
| 20 | 8 | 0.9 | 10 | 1.2 | 16 | 1.8 | 22 | 2.5 | 28 | 3.2 |
| 21 | 8 | 0.9 | 10 | 1.2 | 17 | 1.9 | 23 | 2.6 | 29 | 3.3 |
| 22 | 9 | 1.0 | 11 | 1.2 | 17 | 1.9 | 24 | 2.7 | 30 | 3.4 |
| 23 | 9 | 1.0 | 11 | 1.2 | 18 | 2.0 | 25 | 2.8 | 31 | 3.6 |
| 24 | 9 | 1.0 | 11 | 1.3 | 18 | 2.1 | 25 | 2.9 | 33 | 3.7 |
| 25 | 9 | 1.0 | 11 | 1.3 | 19 | 2.1 | 26 | 3.0 | 34 | 3.8 |
| 26 | 9 | 1.0 | 12 | 1.3 | 19 | 2.2 | 27 | 3.1 | 35 | 3.9 |
| 27 | 9 | 1.1 | 12 | 1.4 | 20 | 2.3 | 28 | 3.2 | 36 | 4.1 |
| 28 | 9 | 1.1 | 12 | 1.4 | 21 | 2.3 | 29 | 3.3 | 37 | 4.2 |
| 29 | 10 | 1.1 | 13 | 1.4 | 21 | 2.4 | 30 | 3.4 | 38 | 4.3 |
| 30 | 10 | 1.1 | 13 | 1.4 | 22 | 2.5 | 31 | 3.5 | 39 | 4.5 |

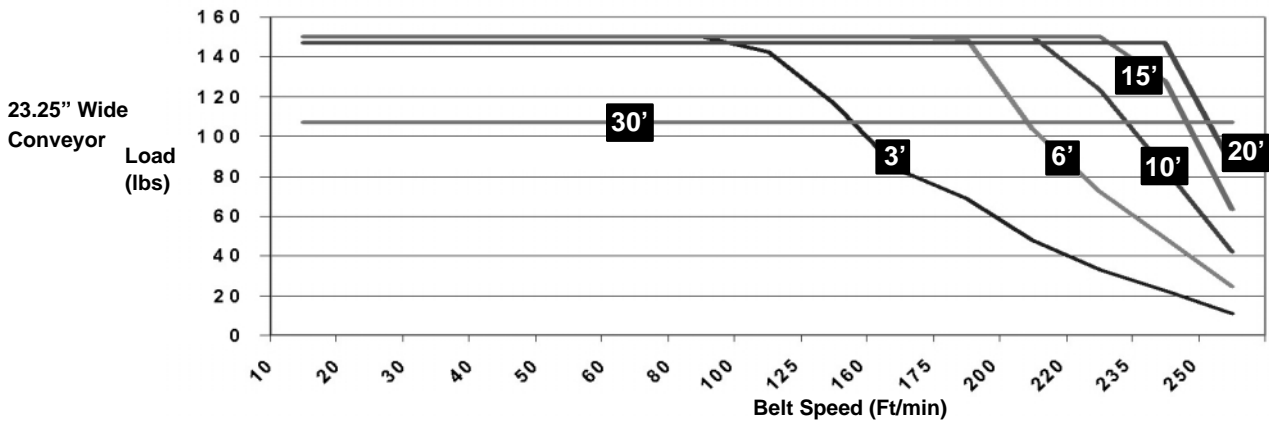
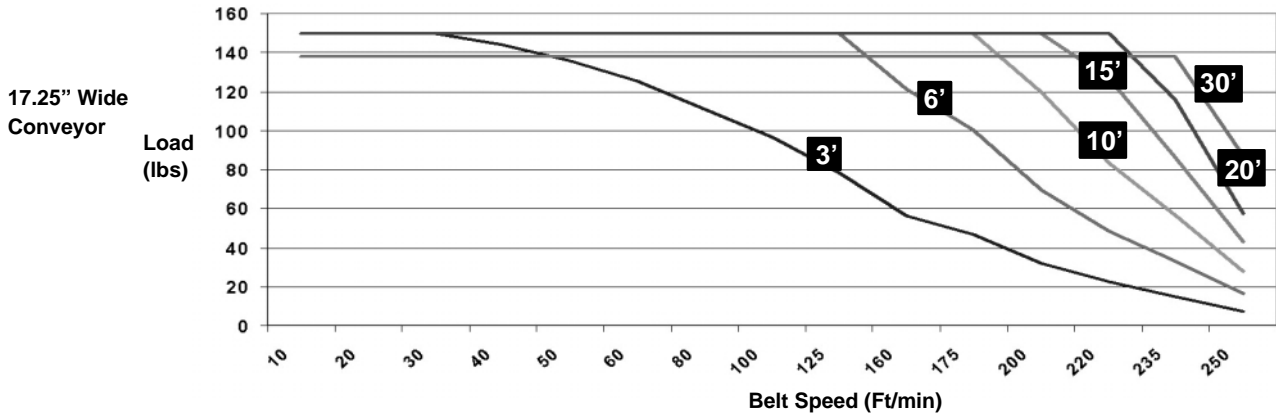
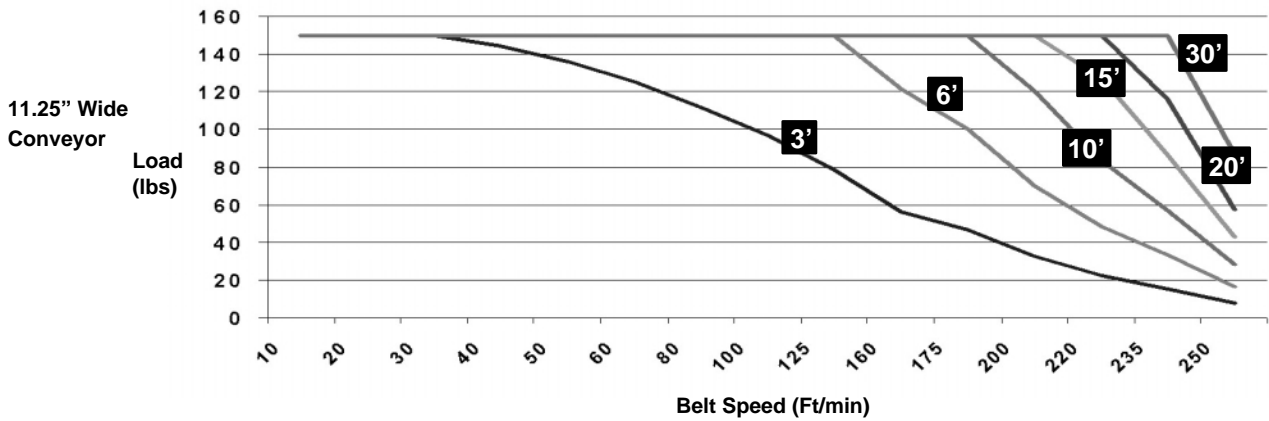
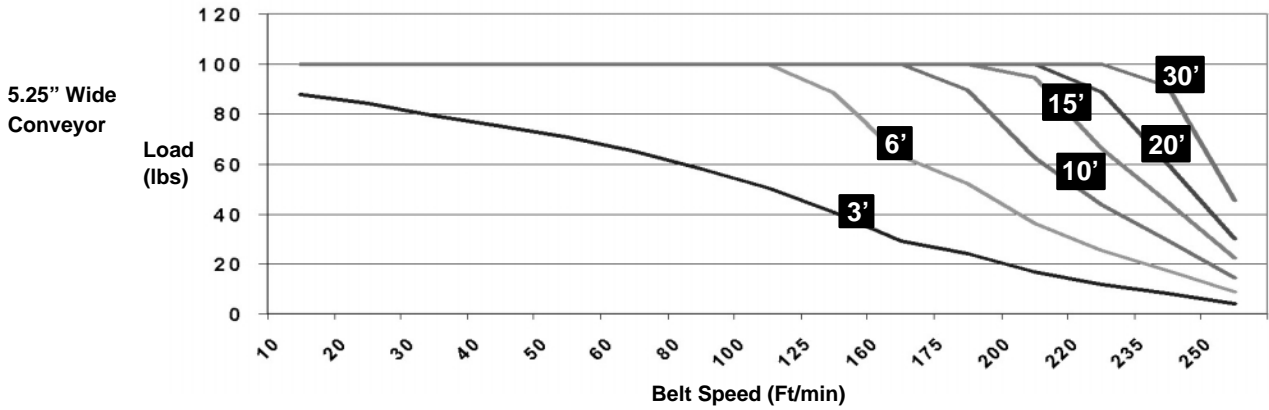
Load vs. Speed vs Conveyor Length Per Width

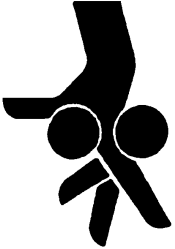
NOTE: Maximum conveyor loads based on:

- Non-accumulating product
- Product moving towards gearmotor
- Conveyor being mounted horizontal



Specifications






WARNING

MPB Series Conveyors are not reversible. Reversing creates pinch points which can cause severe injury.

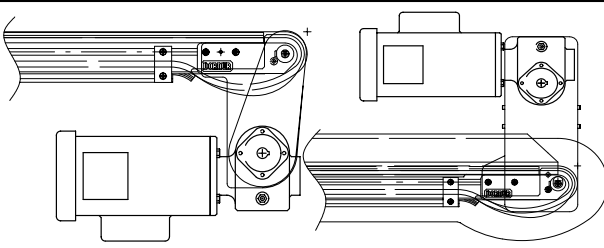
DO NOT REVERSE MPB SERIES CONVEYORS.



WARNING

For MPB Series Flat and Cleated Belt Conveyors, Top and Bottom Mount Gearmotors must be mounted as shown below.

Failure to do so creates pinch points which can cause severe injury.



Flat Belt Bottom Mount Cleated Belt Top Mount

NOTE: Conveyor MUST be mounted straight, flat and level within confines of conveyor. Use a level (M of Figure 3) for setup.

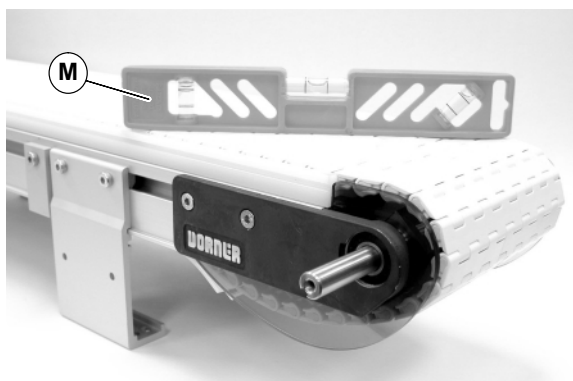


Figure 3

Required Tools

- Hex-key wrenches:
4 mm, 5 mm
- Level
- Torque wrench
- 3/32" (2.4 mm) wide Flat Blade screwdriver

Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor frame(if required)(page 7)
- Attach mounting brackets to conveyor frame and stands (page 8)
- Install Belt (page 9)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 31 through 35 of "Service Parts" section for details)

Conveyors Up to 13 ft (3962 mm)

No assembly is required. Install mounting brackets. Refer to "Mounting Brackets" on page 8.

Conveyors Longer Than 13 ft (3962 mm)

NOTE: Conveyors shipped in multiple sections will have a return wearstrip extending from the end of the conveyor. See Figure 4.

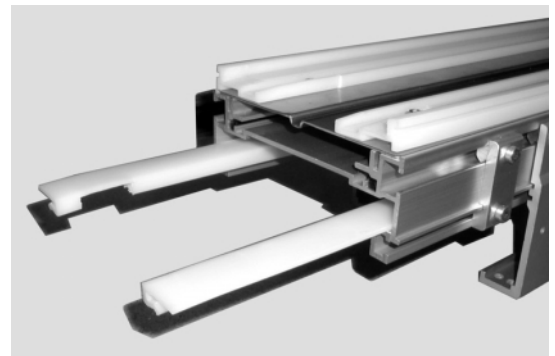


Figure 4

1. Locate conveyor sections (N Figure 5)

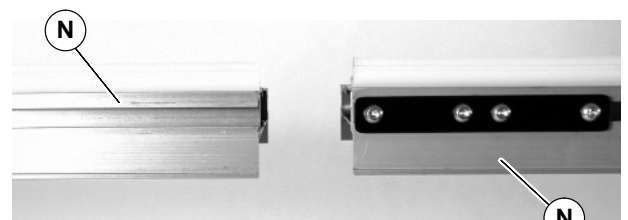


Figure 5

Installation

- Join conveyor sections and install connector brackets (O of Figure 6) or connector/mount brackets (Q) and screws (P) on both sides as indicated.

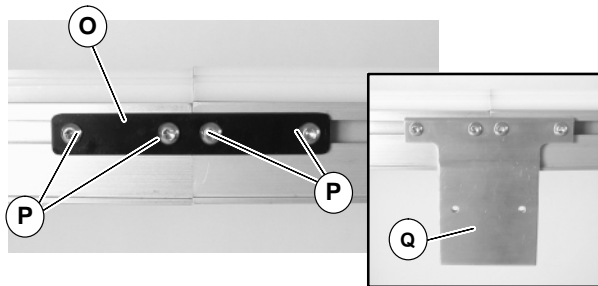


Figure 6

- Snap the protruding return wear strip to the extrusion on the opposite side (R of Figure 7).

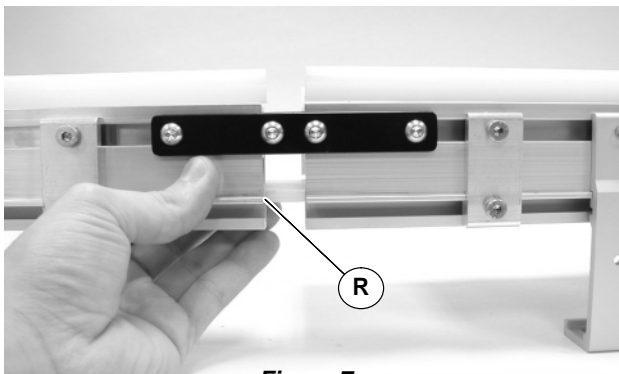
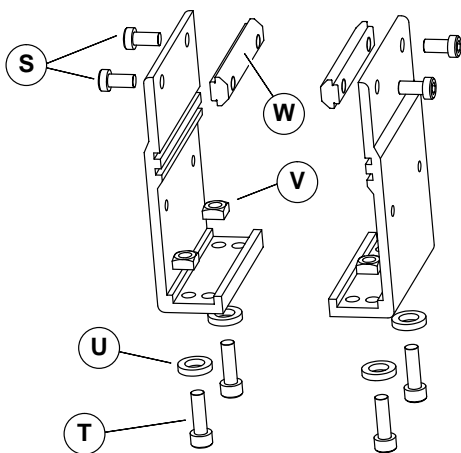


Figure 7

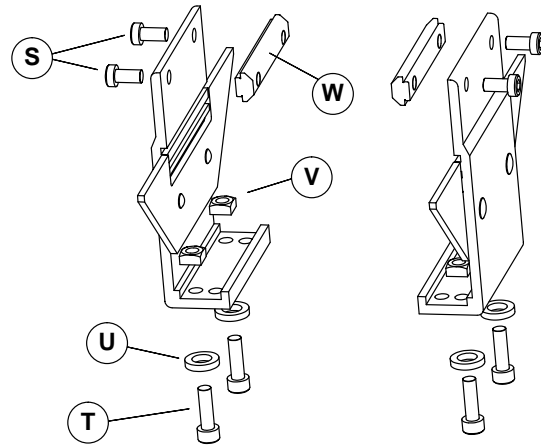
- Tighten screw (P of Figure 6) to 60in-lb (7 N-m) on both sides of conveyor.

Mounting Brackets

- Locate brackets. Exploded views shown in Figures 8 & 9.



Mounting Brackets for Flat Belt Conveyor
Figure 8



Mounting Brackets for Cleated Belt Conveyor
Figure 9

- Remove screws (S & T of Figures 8 & 9), washers (U), nuts (V) and T-bars (W) from brackets.
- Insert T-bars (W of Figures 8 & 9) into conveyor side slots (X of Figure 10). Fasten brackets (Y of Figure 10) to conveyor with mounting screws (S).

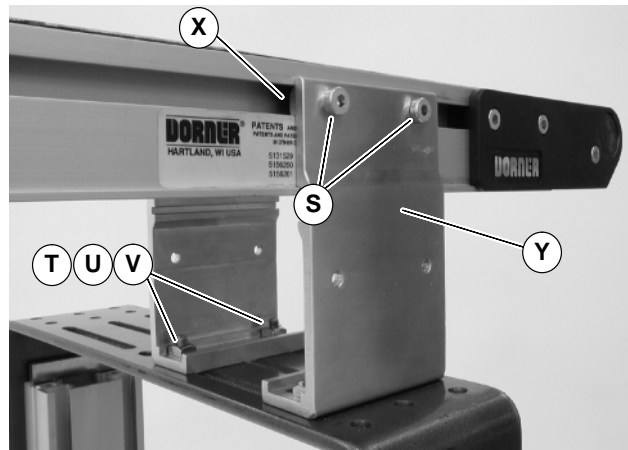


Figure 10

NOTE: Mounting brackets for flat belt conveyors shown.

- Fasten brackets to support stand with mounting screws (T of Figure 10), washers (U) and nuts (V).
- Tighten screws (S & T of Figure 10) to 60 in-lb (7 N-m).

Installing Plastic Belt

NOTE: 17.25" and 23.25" wide plastic belt will correctly operate in one direction only. Ensure the belt is installed in the correct orientation. Refer to step 2 below for details.

1. Locate the conveyor belt retaining rod (Z of Figure 11) and belt end caps (AA).

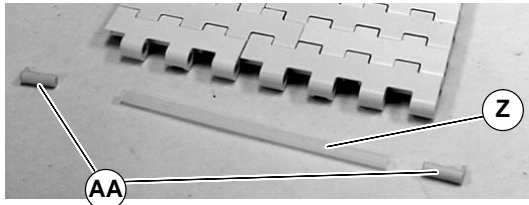


Figure 11

2. For 17.25" wide and 23.25" wide belts, align the belt to the retained center sprocket (AB of Figure 12) on the drive end of the conveyor.

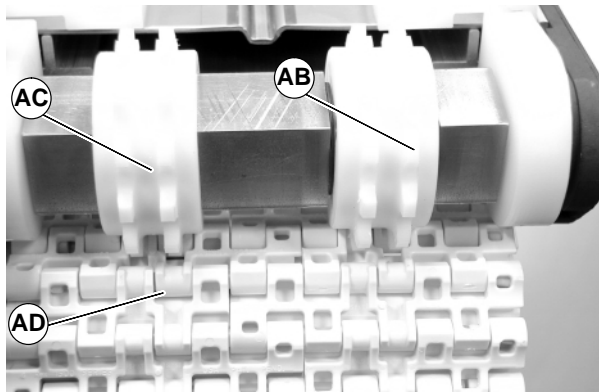


Figure 12

3. Feed belt into bottom wear strips (AE of Figure 13) and pull through to the far end.

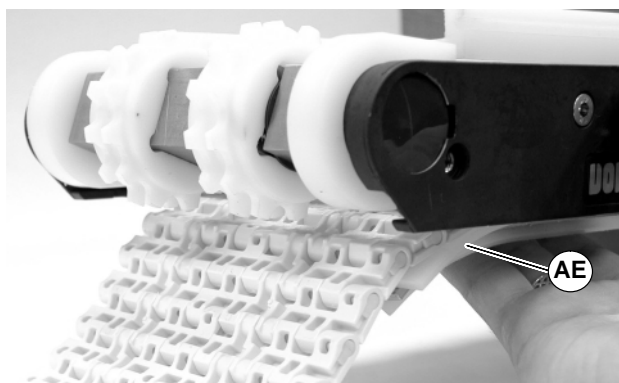


Figure 13

4. Aligning free moving sprocket(s) (AC of figure 12) to the drive pocket(s) (AD). Wrap belt around sprockets and pull towards idler end.
5. Repeat step 4 for the idler end of conveyor.
6. Splice the belt together by pushing the plastic rod (AF of Figure 14) through the side hole.

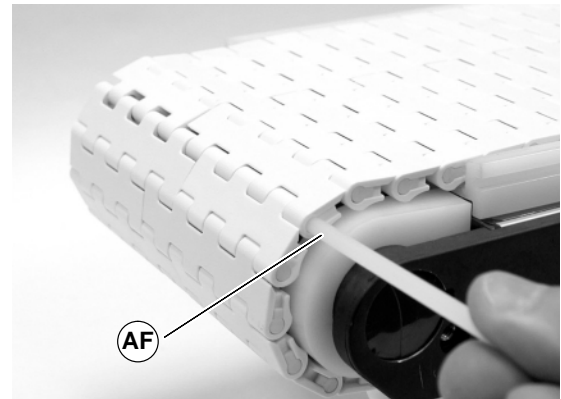


Figure 14

7. Insert rod retaining end caps (AG of figure 15) on both sides of belt.

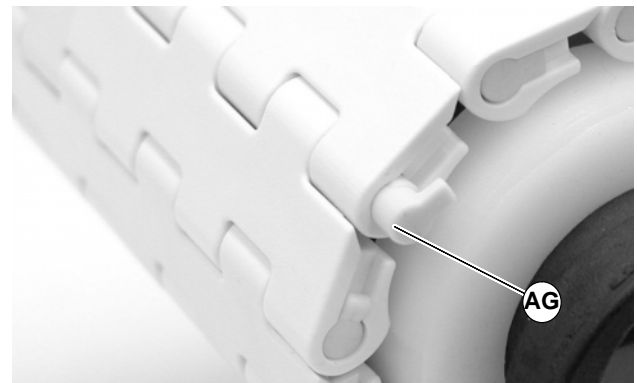


Figure 15

8. See "Conveyor Belt Tensioning" section on page 11 for details on belt tension.

Preventive Maintenance and Adjustment

Required Tools

Standard Tools

- Hex-key wrenches:
2.5 mm, 4 mm, 5 mm
- 3/32" (2.4 mm) wide Flat Blade screw driver
- Arbor press
- Adjustable wrench to 1" (25 mm) wide

Special Tools

- 807-1078 Sealed Bearing Removal Tool
- 450292 Sealed Bearing Installation Tool

Checklist

- Keep service parts on hand (see "Service Parts" section for recommendations)
- Keep supply of belt cleaner (part # 625619)
- Clean entire conveyor 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
- Tooth skipping
- Loose links

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or skipping belt indicates:

- Belt stretching
- Conveyor belt or drive timing belt are not properly tensioned
- Worn sprocket or impacted dirt on drive pulley
- Intermittent jamming or drive train problems

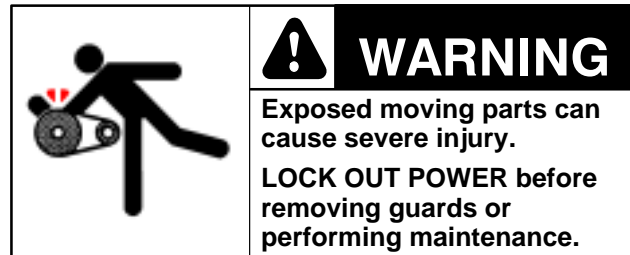
NOTE: Visit www.dorner.com for complete list of troubleshooting solutions.

Cleaning

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

Use Dorner Belt Cleaner (part # 625619). Mild soap and water may also be used. Do not soak the belt.


Conveyor Belt Replacement



Conveyor Belt Replacement Sequence

- Remove old conveyor belt
- Install new conveyor belt
- Tension conveyor belt

Belt Removal

1. On idler end of the conveyor identified with a  label (AH of figure 16), loosen fastening screws (AI of figure 16) on both sides of conveyor. Push head plate assembly (AJ) inward.

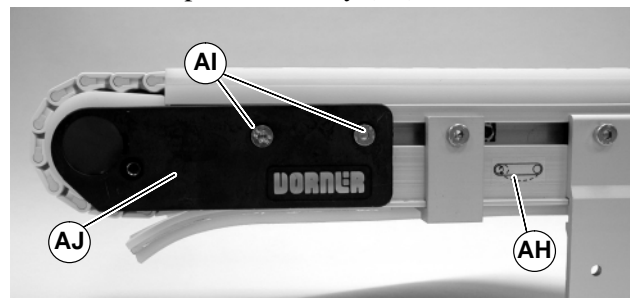


Figure 16

2. Choose one link on the idler end of chain to remove endcaps. With a 3/32" (2.4 mm) flat blade screwdriver, pry under tab of end caps (AK of Figure 17) and remove end cap. Repeat for opposite side of conveyor.



Figure 17

Preventive Maintenance and Adjustment

3. Insert screwdriver (AL of figure 18) into one side of belt, pushing rod (AM) out. Remove rod and separate belt.

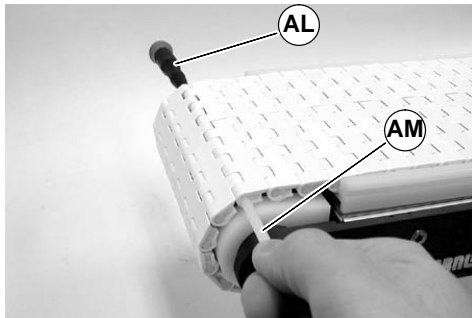


Figure 18

4. Pull back topside of belt to the drive end of the conveyor. See figure 19.

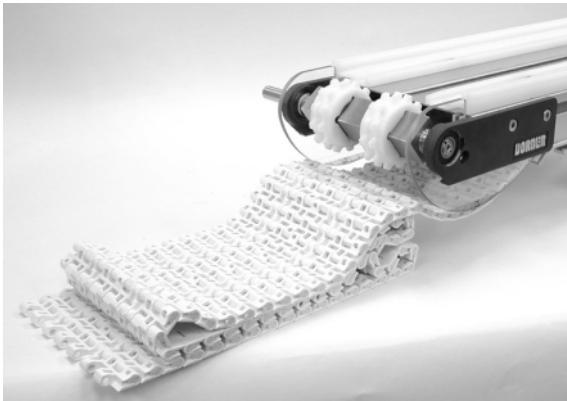


Figure 19

5. Remove belt by pulling belt out of bottom wear strips. See figure 20.

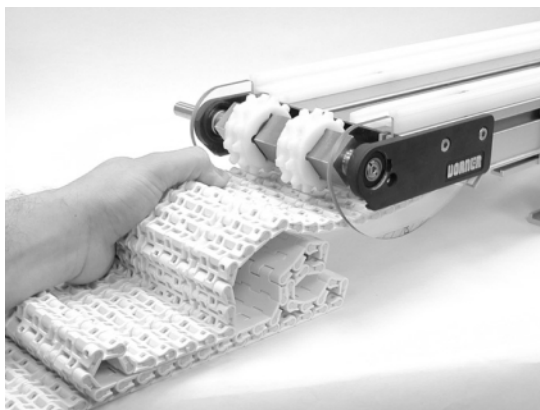


Figure 20

Belt Installation

1. See "Installing Plastic Belt" page 9.

Conveyor Belt Tensioning



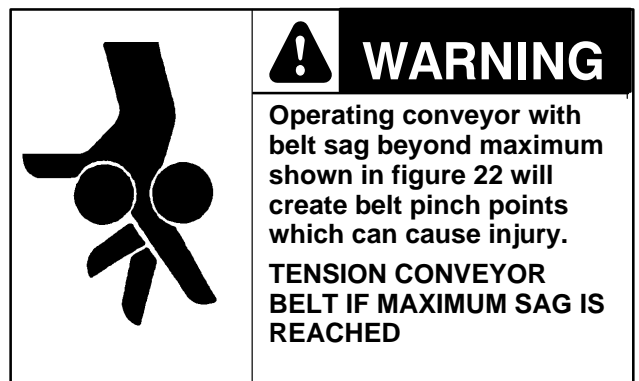
NOTE: The MPB Series Plastic Belt Conveyor is designed to operate with minimal belt tension. The belt sag guard (AN of figure 21) provides information to the proper belt tension. Figure 21 indicates minimum belt sag. Figure 22 indicates maximum belt sag. Belt sag beyond that indicated in Figure 22 must be tensioned see below for details.



Figure 21



Figure 22




Preventive Maintenance and Adjustment

Belt tensioning may be done by two methods:

- A – Extending idler end
- B – Removal of belt links

A – Extending Idler End

1. On tension end of the conveyor, identified with a  label (AH of Figure 23), on both sides of conveyor, loosen fastening screws (AI). Insert 5mm Hex wrench into pinion gear (AO) and rotate to extend head plate assembly(AH).

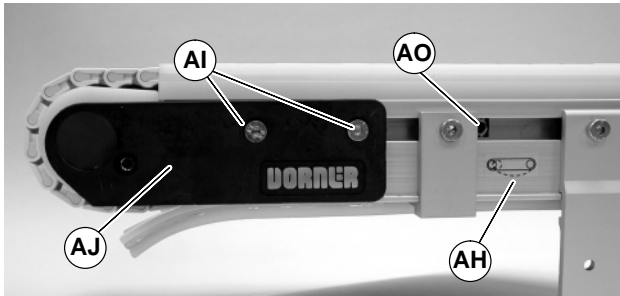


Figure 23

2. Extend head plate assembly so belt sag is between minimum shown in figure 21 and maximum shown in figure 22. If proper tensioning cannot be obtained before (AP of Figure 24) is even with the end of the conveyor frame (AQ), belt links must then be removed. See section “B Removal of Belt Links”.

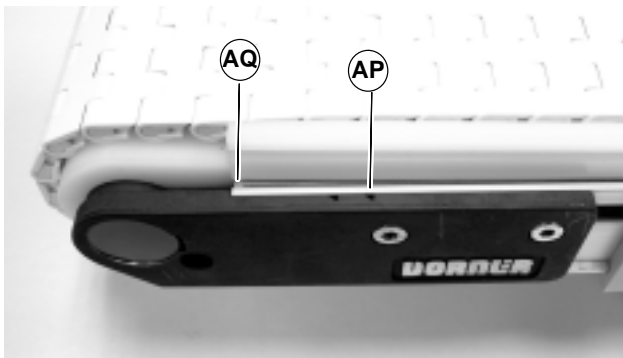


Figure 24

3. After adjusting proper tensioning, tighten fastening screws (AI of Figure 23) on both sides of conveyor to 60 in-lb (7 N-m).

B – Removal of Belt Links

1. Choose one link on the idler end of chain to remove endcaps. With a 3/32” (2.4 mm) flat blade screwdriver, pry under tab of end caps (AK of Figure 25) and remove end cap. Repeat for opposite side of conveyor.



Figure 25

2. Insert screwdriver (AR of figure 26) into one side of belt, pushing rod (AS) out. Remove rod and separate belt.

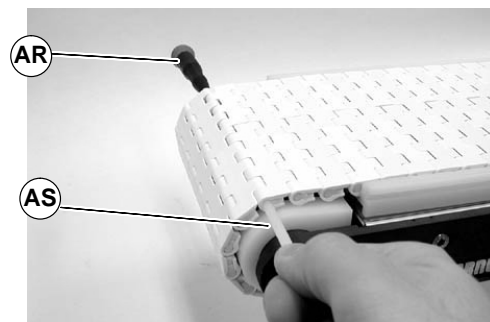


Figure 26

3. Determine the number of links to be removed. Start with 1 link and progress if additional tensioning is required repeat steps 1 and 2.
4. Splice the belt together by pushing the plastic rod (AF of Figure 27) through the side hole.

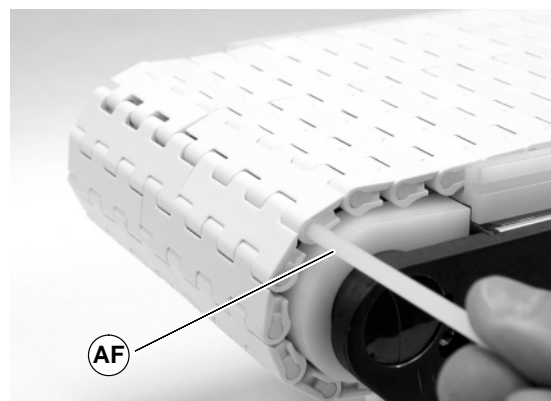


Figure 27

5. Insert rod retaining end caps (AG of figure 28) on both sides of belt.

Preventive Maintenance and Adjustment



Figure 28

6. Review belt sag at drive end to ensure it is between minimum shown in figure 21 and maximum shown in figure 22. If additional tensioning is required repeat steps 1 through 5.

Pulley and Sprockets Removal

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

Remove conveyor belt to access pulley(s). See “Conveyor Belt Replacement” on page 10. Remove the desired pulley following the corresponding instructions below:

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

A – Idler Pulley and Sprockets Removal

1. On both sides of conveyor, loosen two (2) fastening screws (AI of Figure 29). Then slide idler pulley assembly out from the conveyor frame.

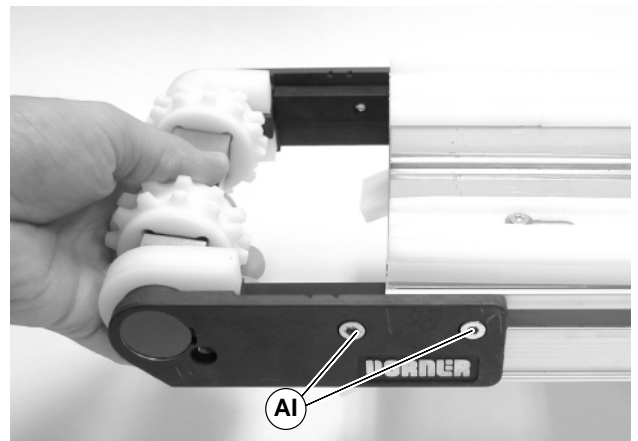


Figure 29

2. Remove bearing covers (AT of Figure 30).

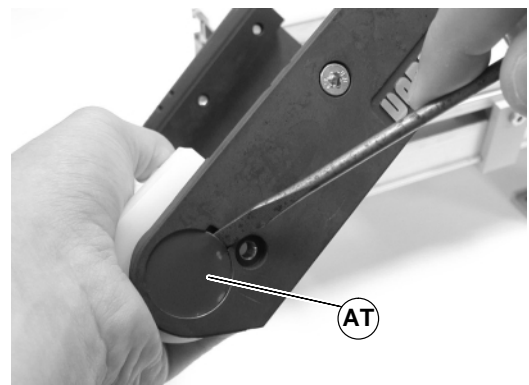


Figure 30

Preventive Maintenance and Adjustment

3. With 4mm hex-key wrench, loosen pulley taper screw (AU of Figure 31). Steady pulley (AV) with adjustable wrench (AW). Repeat procedure for opposite side of pulley.

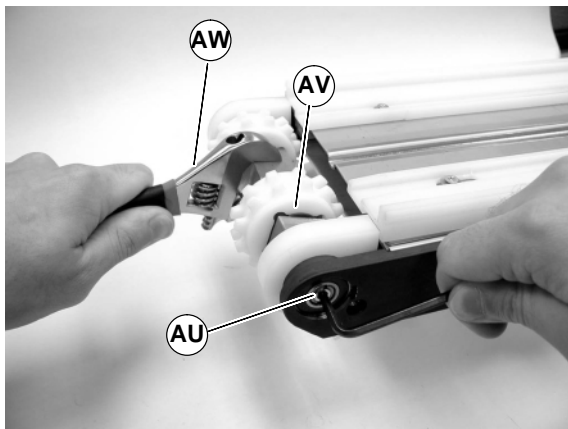


Figure 31

4. Remove head plates with bearings from the pulley.
5. Slide idler end guard (AX of Figure 32) from ends of pulley (AY).

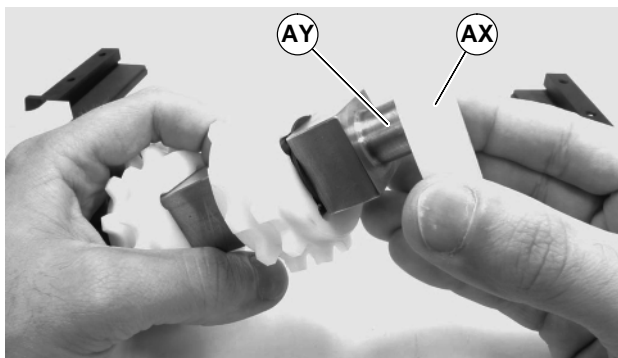


Figure 32

6. Slide free moving sprocket(s) (AZ of Figure 33) off the end of pulley (BA).

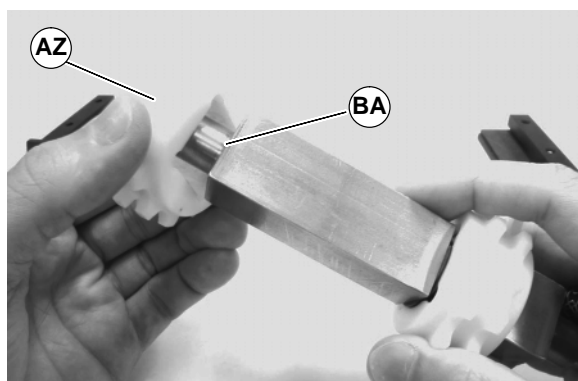


Figure 33

7. Remove snap rings (BB of Figure 34). Slide drive sprocket (BC) off the end of pulley (BD).

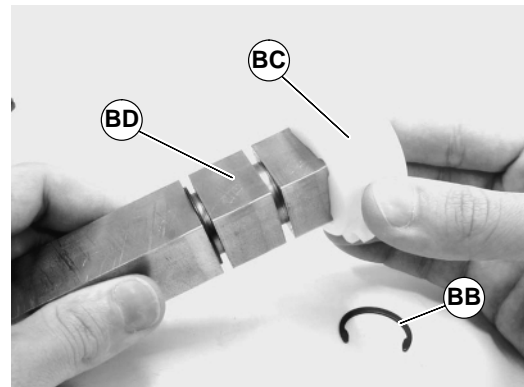


Figure 34

B – Drive Pulley and Sprockets Removal

| | |
|--|--|
|  |  WARNING Drive shaft keyway may be sharp. HANDLE WITH CARE. |
|--|--|

1. On both sides of conveyor, loosen two (2) fastening screws (BE of Figure 35). Then slide drive pulley assembly out from the conveyor frame.

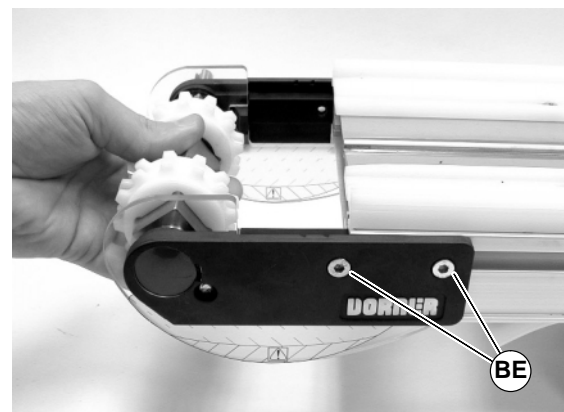


Figure 35

2. Remove bearing cover (AT of Figure 36) from side opposite of drive shaft.

Preventive Maintenance and Adjustment

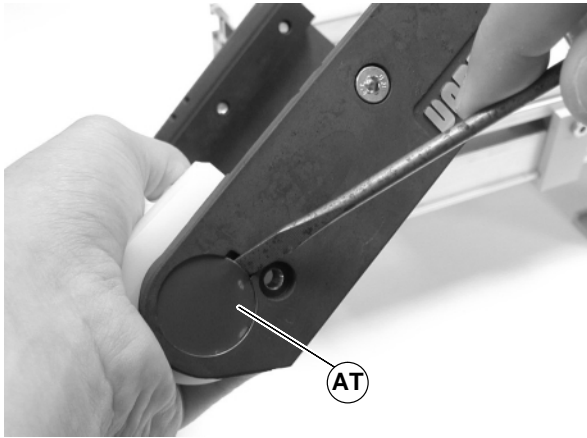


Figure 36

3. On side opposite of drive shaft, loosen pulley taper screw (AU of Figure 37) with 4mm hex-key wrench. Steady pulley (AV) with adjustable wrench (AW).

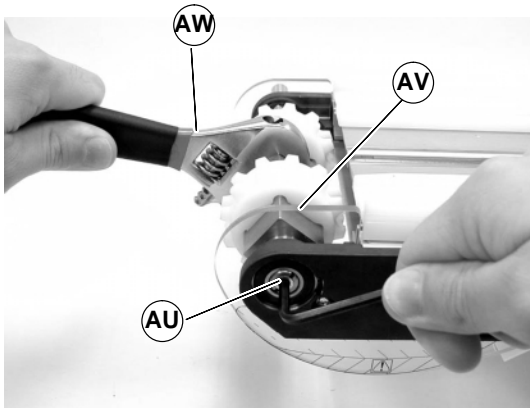


Figure 37

4. On side opposite of drive shaft, pull head plate with bearings off from the pulley.
5. With bearing removal tool, (BF of Figure 38), part number 807-1078, remove head plate from drive shaft side of pulley. Connect tool jaws at indicated points (BG).

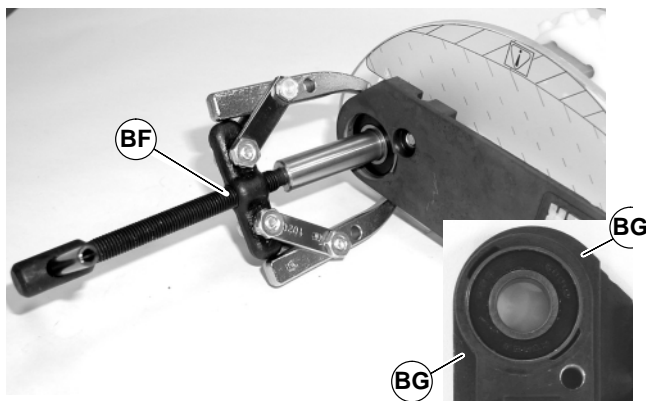


Figure 38

6. Slide free moving sprocket(s) (AZ of Figure 39) off the end of pulley (BA).

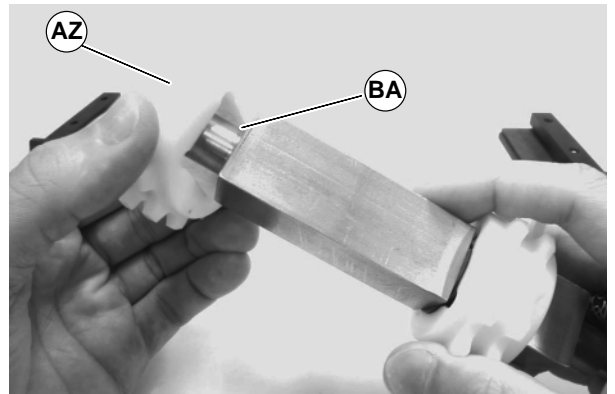


Figure 39

7. Remove snap rings (BB of Figure 40). Slide drive sprocket (BC) off the end of pulley (BD).

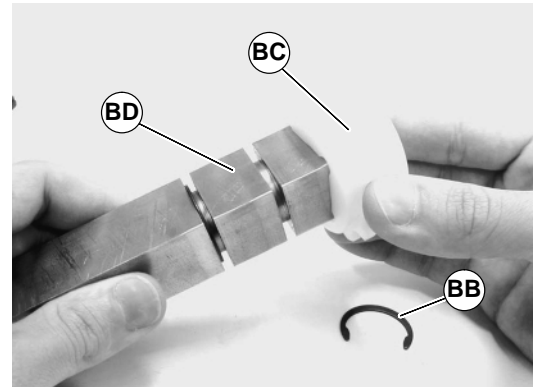
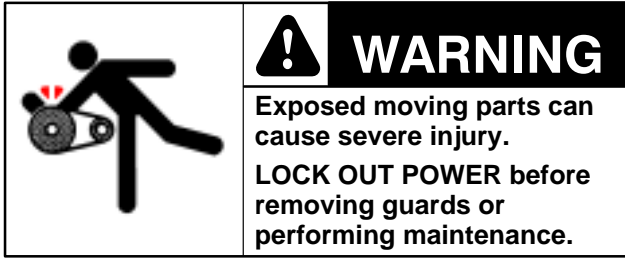


Figure 40

Preventive Maintenance and Adjustment

Bearing Removal & Replacement



Removal

1. Remove idler pulley or drive pulley. For idler pulley see section “A – Idler Pulley and Sprockets Removal”, steps 1 through 4. For drive pulley see section “B – Drive Pulley and Sprockets Removal”, steps 1 through 5.
2. For drive end head plates, remove screw (BH of Figure 41) and remove belt sag guard (BI).

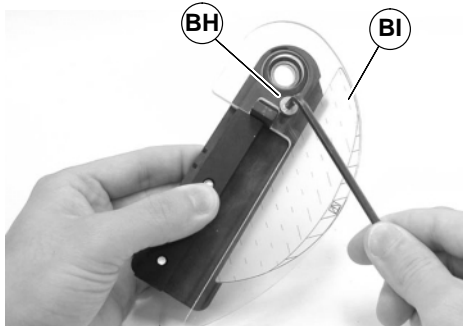


Figure 41

3. Turn bearing (BJ of Figure 42) to align with slots (BK) in head plate. Then remove bearing.

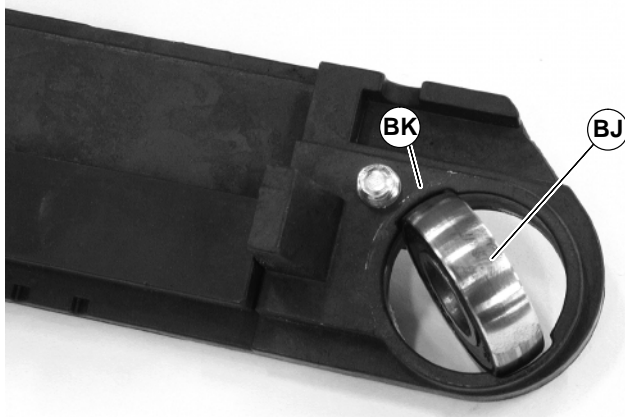


Figure 42

Replacement

1. Inspect head plate bearing surface. If worn or damaged, replace head plate. See “Service Parts” on page 20.
2. Insert bearing (BJ of Figure 43) into head plate slot and twist bearing to fit into bearing enclosure.

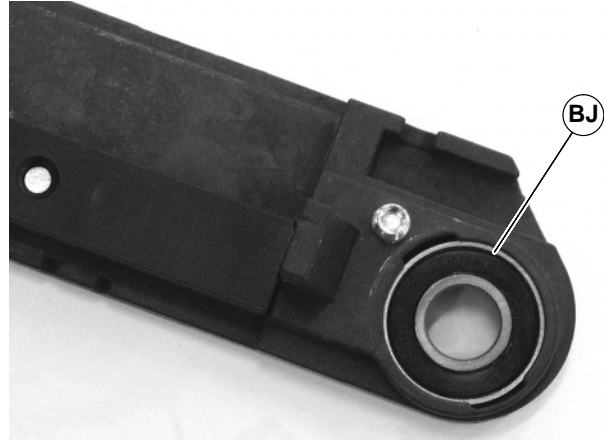


Figure 43

Pulley and Sprockets Replacement

Drive Pulley and Sprockets

1. Install sag guard (BI of Figure 44) to headplate (BL) with screw (BH). Repeat for opposite headplate.

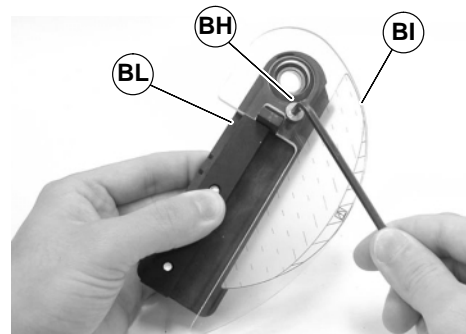


Figure 44

2. Install drive sprocket (BC of Figure 45) with snap rings (BB) to pulley (BD).

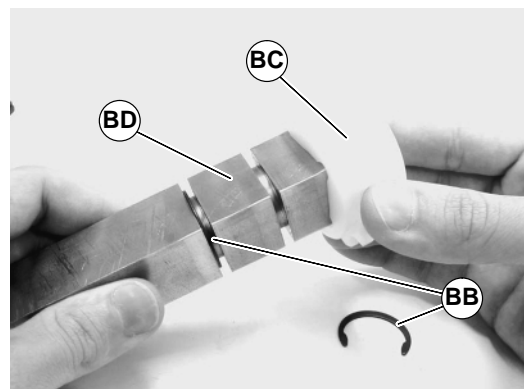


Figure 45

Preventive Maintenance and Adjustment

3. As required, install free moving sprockets as per Figure 46, items in bold are the fixed drive sprockets.

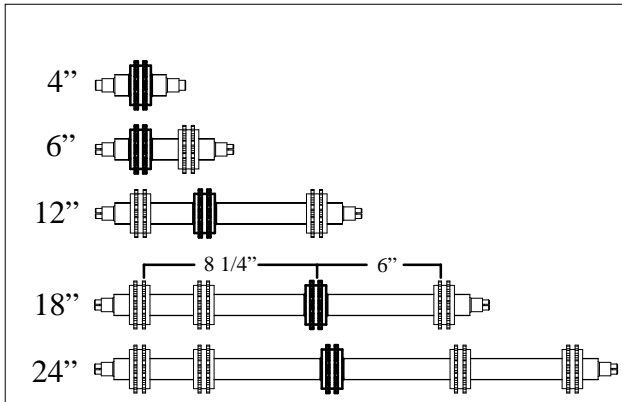


Figure 46

4. With bearing installed in head plate, use a bearing installation tool, (BM of Figure 47), part number 450292, to press the bearing onto the drive shaft.

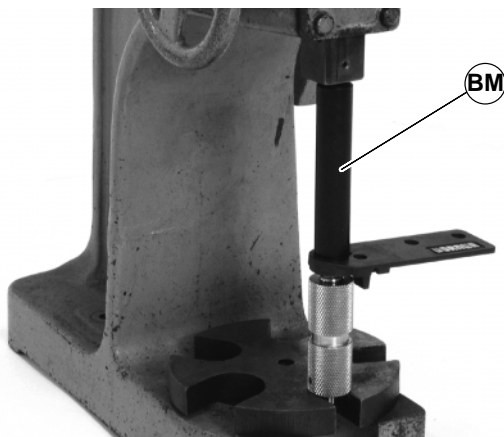


Figure 47

5. With bearing installed in head plate, press bearing on to non-drive shaft (BN of Figure 48) of pulley.

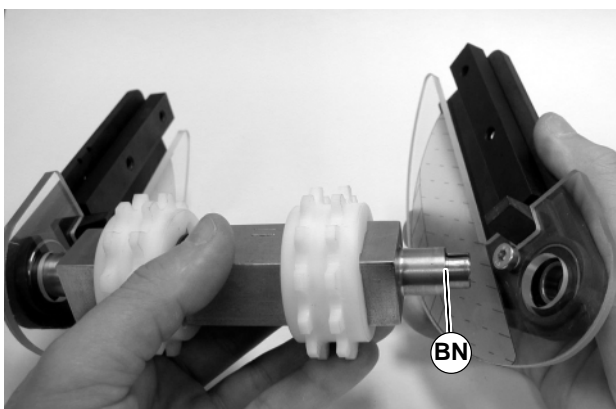


Figure 48

NOTE: DO NOT tighten non-drive shaft bearing taper screws at this time.

6. Install pulley assembly on conveyor. On both sides of conveyor tighten fastening screws (BE of Figure 49) to 60 in-lb (7 N-m).



Figure 49

7. With 4mm hex-key wrench, tighten pulley taper screw (AU of Figure 50) to 75 in-lb (8.5 N-m). Steady pulley (AV) with wrench (AW).

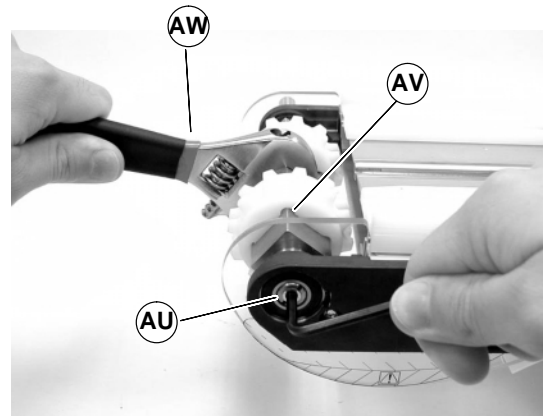


Figure 50

8. Install bearing cover (AT of Figure 51).

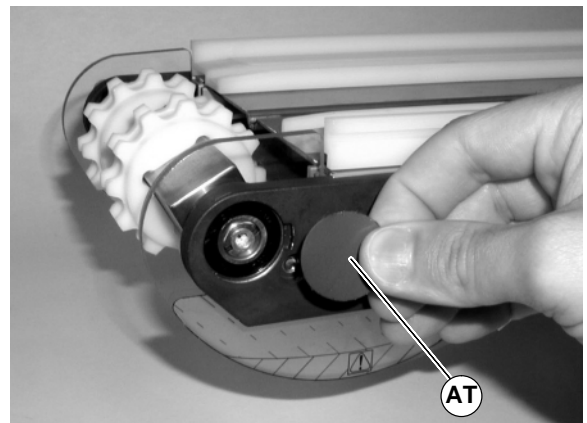


Figure 51

Preventive Maintenance and Adjustment

Idler Pulley and Sprockets

1. Install drive sprocket (BC of Figure 45) with snap rings (BB) to pulley (BD).

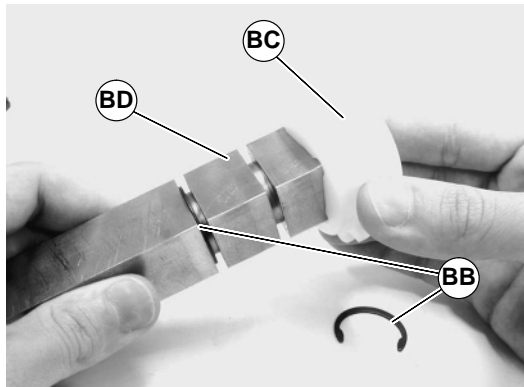


Figure 52

2. As required, install free moving sprockets as per Figure 46, items in bold are the fixed drive sprockets.

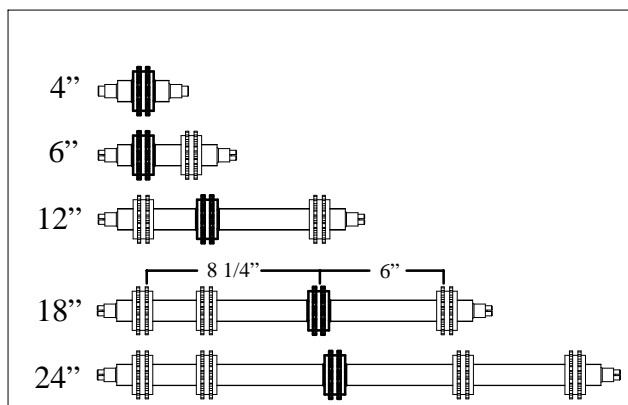


Figure 53

3. Install idler guard (BO of Figure 54) on the end of pulley (BN). With bearing installed in head plate, press bearing on to shaft (BN) of pulley.

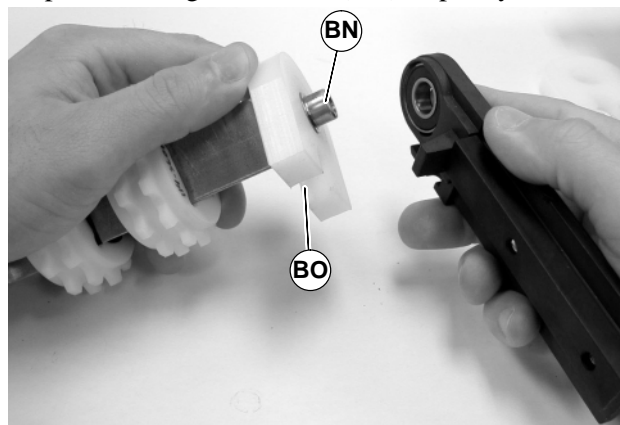


Figure 54

NOTE: DO NOT tighten shaft bearing taper screws at this time.

4. Repeat step 1 on opposite side of pulley.
5. Install pulley assembly on conveyor. On both sides of conveyor, tighten screws (BE of Figure 55) to 60 in-lb (7 N-m).

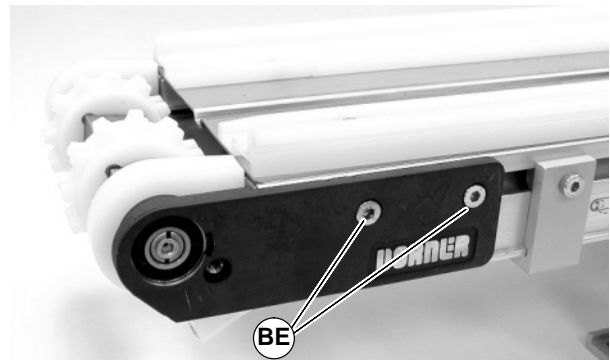


Figure 55

6. On both sides of pulley, use a 4mm hex-key wrench to tighten pulley taper screw (AU of Figure 56) to 75 in-lb (8.5 N-m). Steady pulley (AV) with wrench (AW).

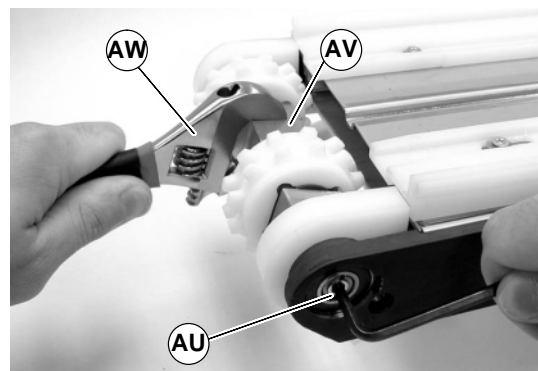


Figure 56

7. Install bearing covers (AT of Figure 57).

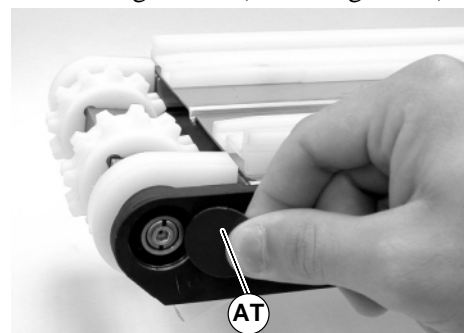
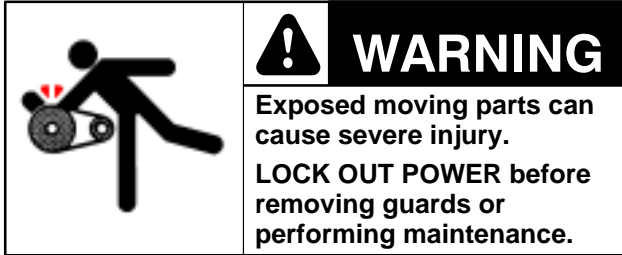


Figure 57

Preventive Maintenance and Adjustment

Upper Wear Strip Replacement



1. Remove conveyor belt. See “Belt Removal” section on page 10.
2. With a T-20 Torx head wrench, remove screw (BP of Figure 58) and bushings (BQ). Remove old wear strip.

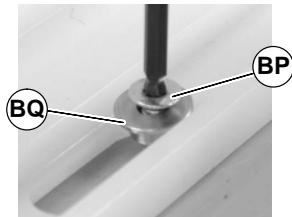


Figure 58

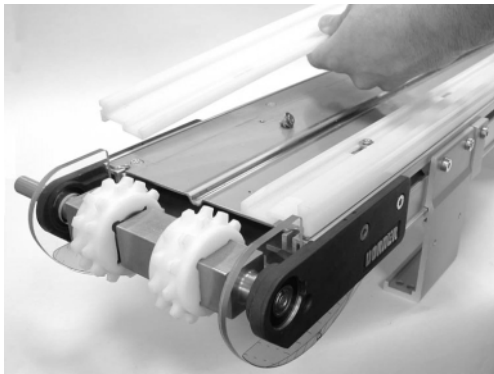


Figure 59

3. Install new wear strip, with bushings (BQ) and screws (BP). Tighten screws to 25 in-lb (2.8 N-m).

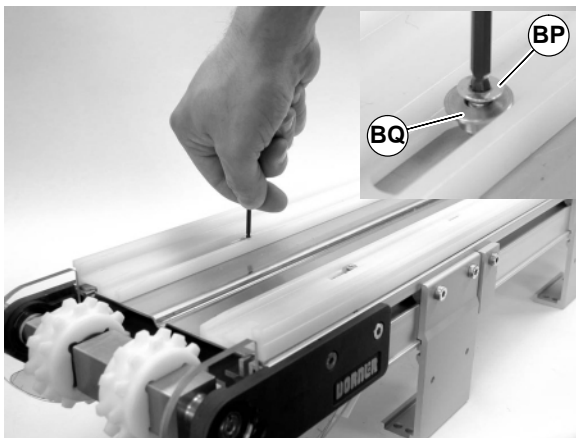
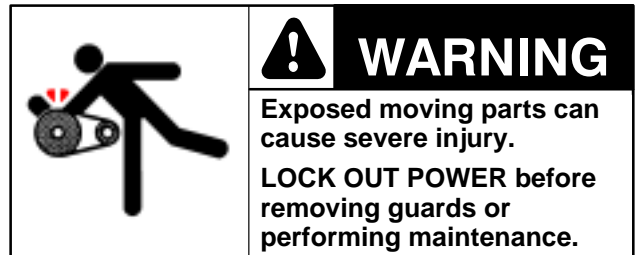


Figure 60

Return Wear Strip Replacement



1. Remove old wear strip (BR) by sliding off of support extrusion (BS of Figure 61).

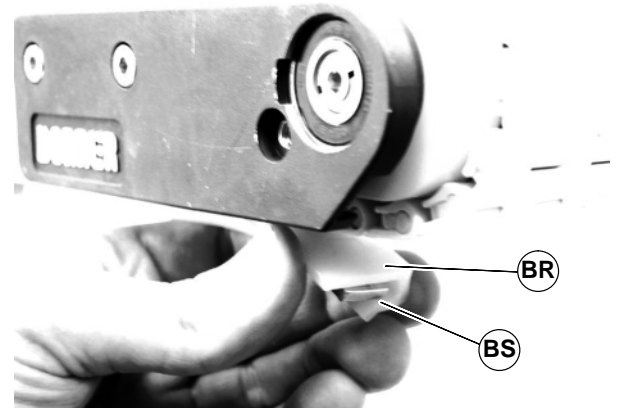


Figure 61

2. Install new wearstrip onto support extrusion (BS).

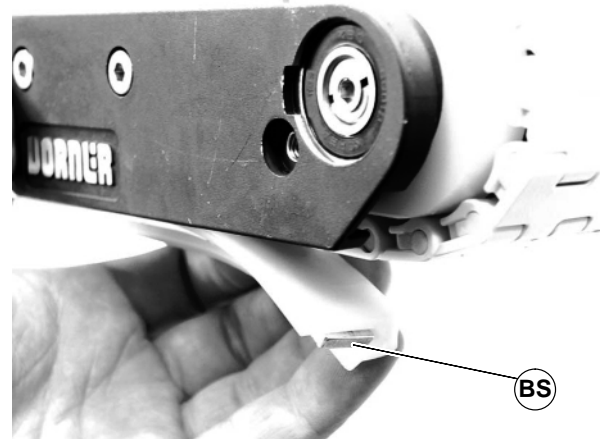
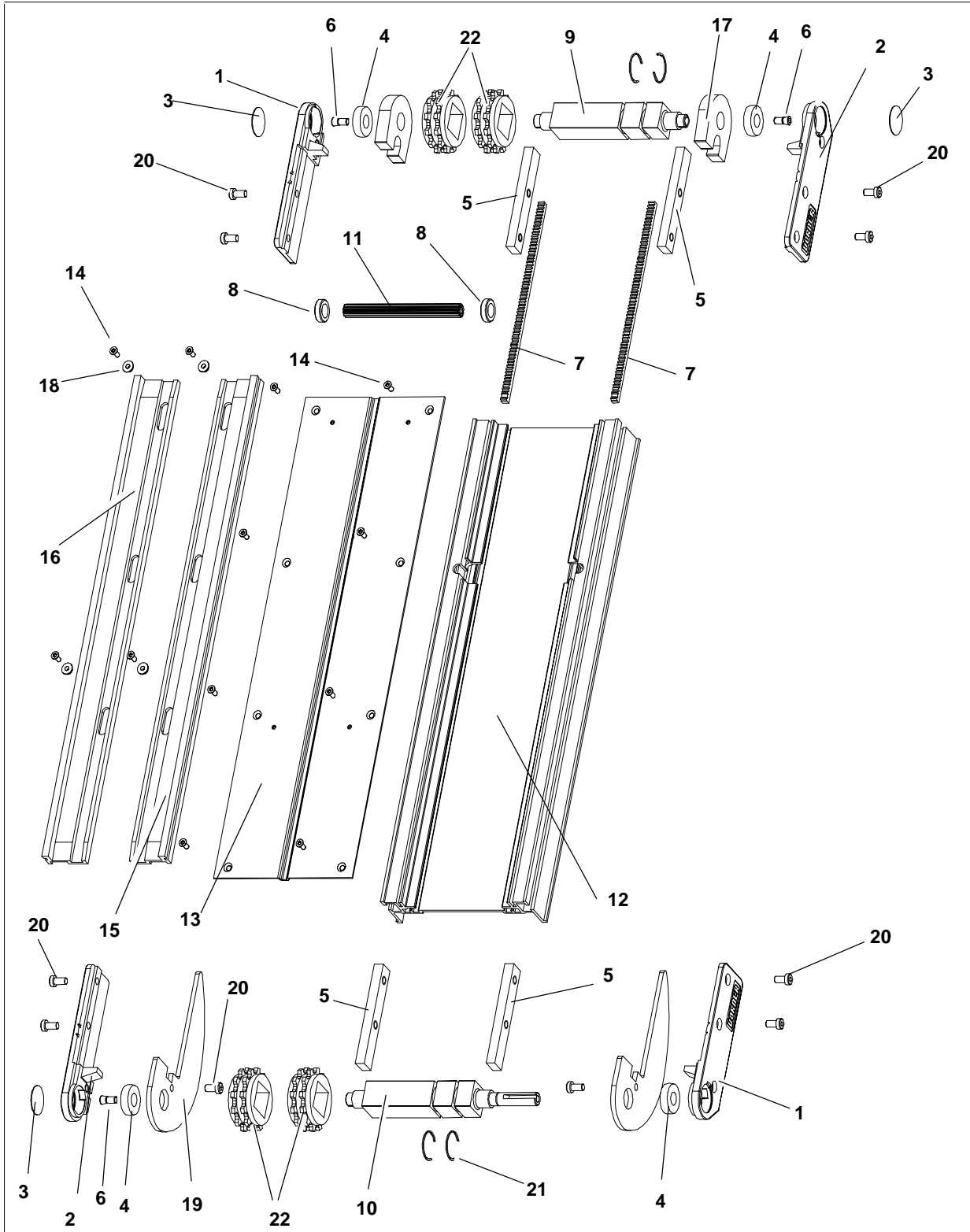


Figure 62

Service Parts

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

4" (102mm) and 6" (152mm) Wide Conveyor Assembly



| Item | Part Number | Description |
|------|-----------------|--------------------------------|
| 1 | 240325 | Head Plate LH |
| 2 | 240326 | Head Plate RH |
| 3 | 240327 | Bearing Cover Disk |
| 4 | 240328 | Bearing |
| 5 | 240329 | Tension Slide Bar |
| 6 | 240330 | Taper Screw |
| 7 | 240420 | Rack Gear 14.5 PA x 24 P |
| 8 | 240421 | Pinion Bushing |
| 9 | 245504 | 4" MPB Idler Spindle |
| | 245506 | 6" MPB Idler Spindle |
| 10 | 245704 | 4" MPB Drive Spindle |
| | 245706 | 6" MPB Drive Spindle |
| 11 | 203004M | Gear Pinion 4" (102mm) |
| | 203006M | Gear Pinion 6" (152mm) |
| 12 | See Chart Below | Conveyor Frame |
| 13 | See Chart Below | Bed Plate |
| 14 | 807-1105 | Torx, Flat Head M4 x 10mm |
| 15 | 245827-LLLL | LH Outer Wear Strip – UHMW |
| | 245828-LLLL | LH Outer Wear Strip – Antistat |
| 16 | 245829-LLLL | RH Outer Wear Strip – UHMW |
| | 245830-LLLL | RH Outer Wear Strip – Antistat |
| 17 | 245850 | Pinch Guard Block |
| 18 | 245854 | Screw Sleeve |
| 19 | 245858 | Sag Guard |
| 20 | 920692M | Socket Head Screw M6 x 12mm |
| 21 | 807-1108 | Retaining Ring |
| 22 | 807-1106 | MPB Spindle Sprocket |

Item 12: Conveyor Frame

| Length | Part Number |
|--------------|---------------------------|
| 2' (610mm) | 2404WW-01900 |
| 3' (914mm) | 2404WW-03100 |
| 4' (1219mm) | 2404WW-04300 |
| 5' (1524mm) | 2404WW-05500 |
| 6' (1829mm) | 2404WW-06700 |
| 7' (2134mm) | 2404WW-07900 |
| 8' (2438mm) | 2404WW-09100 |
| 9' (2743mm) | 2404WW-10300 |
| 10' (3048mm) | 2404WW-11500 |
| 11' (3353mm) | 2404WW-12700 |
| 12' (3658mm) | 2404WW-13900 |
| 13' (3962mm) | 2404WW-07200 2404WW-07900 |
| 14' (4267mm) | 2404WW-07200 2404WW-09100 |
| 15' (4572mm) | 2404WW-07200 2404WW-10300 |

| | |
|--------------|---|
| 16' (4877mm) | 2404WW-07200 2404WW-11500 |
| 17' (5182mm) | 2404WW-07200 2404WW-12700 |
| 18' (5486mm) | 2404WW-07200 2404WW-13900 |
| 19' (5791mm) | 2404WW-07900 2404WW-14400 |
| 20' (6096mm) | 2404WW-09100 2404WW-14400 |
| 21' (6401mm) | 2404WW-10300 2404WW-14400 |
| 22' (6706mm) | 2404WW-11500 2404WW-14400 |
| 23' (7010mm) | 2404WW-12700 2404WW-14400 |
| 24' (7315mm) | 2404WW-13900 2404WW-14400 |
| 25' (7620mm) | 2404WW-07900 2404WW-07200 2404WW-14400 |
| 26' (7925mm) | 2404WW-09100 2404WW-07200 2404WW-14400 |
| 27' (8230mm) | 2404WW-10300 2404WW-07200 2404WW-14400 |
| 28' (8534mm) | 2404WW-11500 2404WW-07200 2404WW-14400 |
| 29' (8839mm) | 2404WW-12700 2404WW-07200 2404WW-14400 |
| 30' (9144mm) | 2404WW-13900 2404WW-07200 2404WW-14400 |

WW = Conveyor width reference: 04, 06

Item 13: Bed Plate

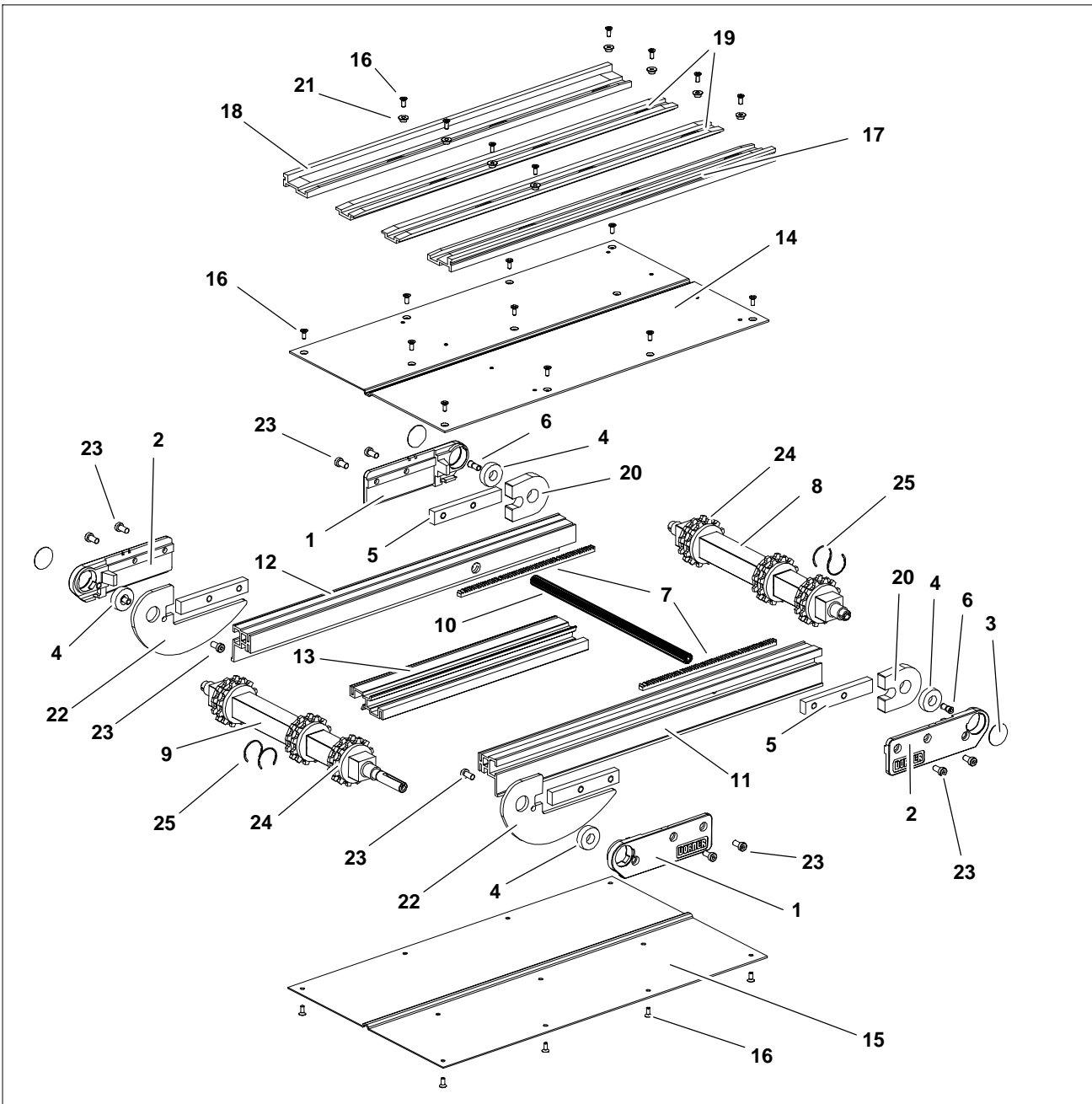
| Length | Part Number |
|--------------|---------------------------|
| 2' (610mm) | 2452WW-01892 |
| 3' (914mm) | 2452WW-03092 |
| 4' (1219mm) | 2452WW-04292 |
| 5' (1524mm) | 2452WW-05492 |
| 6' (1829mm) | 2452WW-06692 |
| 7' (2134mm) | 2452WW-07892 |
| 8' (2438mm) | 2452WW-09092 |
| 9' (2743mm) | 2452WW-10292 |
| 10' (3048mm) | 2452WW-11492 |
| 11' (3353mm) | 2452WW-12692 |
| 12' (3658mm) | 2452WW-13892 |
| 13' (3962mm) | 2452WW-07196 2452WW-07892 |
| 14' (4267mm) | 2452WW-07196 2452WW-09092 |
| 15' (4572mm) | 2452WW-07196 2452WW-10292 |
| 16' (4877mm) | 2452WW-07196 2452WW-11492 |
| 17' (5182mm) | 2452WW-07196 2452WW-12692 |
| 18' (5486mm) | 2452WW-07196 2452WW-13892 |
| 19' (5791mm) | 2452WW-07892 2452WW-14396 |
| 20' (6096mm) | 2452WW-09092 2452WW-14396 |
| 21' (6401mm) | 2452WW-10292 2452WW-14396 |
| 22' (6706mm) | 2452WW-11492 2452WW-14396 |
| 23' (7010mm) | 2452WW-12692 2452WW-14396 |
| 24' (7315mm) | 2452WW-13892 2452WW-14396 |

Service Parts

| | | |
|--------------|------------------------------|--------------|
| 25' (7620mm) | 2452WW-07892 2452WW-07196 | 2452WW-14396 |
| 26' (7925mm) | 2452WW-09092 2452WW-07196 | 2452WW-14396 |
| 27' (8230mm) | 2452WW-10292 2452WW-07196 | 2452WW-14396 |
| 28' (8534mm) | 2452WW-11492 2452WW-07196 | 2452WW-14396 |

| | | |
|---------------------------------------|------------------------------|--------------|
| 29' (8839mm) | 2452WW-12692 2452WW-07196 | 2452WW-14396 |
| 30' (9144mm) | 2452WW-13892 2452WW-07196 | 2452WW-14396 |
| WW = Conveyor Width reference: 04, 06 | | |

12" (305mm) Wide Conveyor Assembly



| Item | Part Number | Description |
|------|-------------|--------------------|
| 1 | 240325 | Head Plate LH |
| 2 | 240326 | Head Plate RH |
| 3 | 240327 | Bearing Cover Disk |
| 4 | 240328 | Bearing |
| 5 | 240329 | Tension Slide Bar |

| | | |
|----|---------|--------------------------|
| 6 | 240330 | Taper Screw |
| 7 | 240420 | Rack Gear 14.5 PA x 24 P |
| 8 | 245512 | 12" MPB Idler Spindle |
| 9 | 245712 | 12" MPB Drive Spindle |
| 10 | 203012M | Gear Pinion 12" (605mm) |

| | | |
|----|-----------------|--------------------------------|
| 11 | See Chart Below | Conveyor Frame |
| 12 | See Chart Below | Conveyor Frame |
| 13 | See Chart Below | Center Rail |
| 14 | See Chart Below | Bed Plate Top |
| 15 | See Chart Below | Bed Plate Bottom |
| 16 | 807-1105 | Torx, Flat Head M4 x 10mm |
| 17 | 245827-LLLL | LH Outer Wear Strip – UHMW |
| | 245828-LLLL | LH Outer Wear Strip – Antistat |
| 18 | 245829-LLLL | RH Outer Wear Strip – UHMW |
| | 245830-LLLL | RH Outer Wear Strip – Antistat |
| 19 | 245831-LLLL | Center Wear Strips – UHMW |
| | 245832-LLLL | Center Wear Strips – Antistat |
| 20 | 245850 | Pinch Guard Block |
| 21 | 245854 | Screw Sleeve |
| 22 | 245858 | Sag Guard |
| 23 | 920692M | Socket Head Screw M6 x 12mm |
| 24 | 807-1106 | MPB Spindle Sprocket |
| 25 | 807-1108 | Retaining Ring |

| Item 11: Side Rail RH 12" Wide (305mm) | |
|--|---------------------------|
| Length | Part Number |
| 2' (610mm) | 240412-01900 |
| 3' (914mm) | 240412-03100 |
| 4' (1219mm) | 240412-04300 |
| 5' (1524mm) | 240412-05500 |
| 6' (1829mm) | 240412-06700 |
| 7' (2134mm) | 240412-07900 |
| 8' (2438mm) | 240412-09100 |
| 9' (2743mm) | 240412-10300 |
| 10' (3048mm) | 240412-11500 |
| 11' (3353mm) | 240412-12700 |
| 12' (3658mm) | 240412-13900 |
| 13' (3962mm) | 240412-07200 240412-07900 |
| 14' (4267mm) | 240412-07200 240412-09100 |
| 15' (4572mm) | 240412-07200 240412-10300 |
| 16' (4877mm) | 240412-07200 240412-11500 |
| 17' (5182mm) | 240412-07200 240412-12700 |
| 18' (5486mm) | 240412-07200 240412-13900 |
| 19' (5791mm) | 240412-07900 240412-14400 |
| 20' (6096mm) | 240412-09100 240412-14400 |
| 21' (6401mm) | 240412-10300 240412-14400 |
| 22' (6706mm) | 240412-11500 240412-14400 |
| 23' (7010mm) | 240412-12700 240412-14400 |

| | |
|--------------|---|
| 24' (7315mm) | 240412-13900 240412-14400 |
| 25' (7620mm) | 240412-07900 240412-07200 240412-14400 |
| 26' (7925mm) | 240412-09100 240412-07200 240412-14400 |
| 27' (8230mm) | 240412-10300 240412-07200 240412-14400 |
| 28' (8534mm) | 240412-11500 240412-07200 240412-14400 |
| 29' (8839mm) | 240412-12700 240412-07200 240412-14400 |
| 30' (9144mm) | 240412-13900 240412-07200 240412-14400 |

| Item 12: Side Rail LH 12" Wide (305mm) | |
|--|---|
| Length | Part Number |
| 2' (610mm) | 240413-01900 |
| 3' (914mm) | 240413-03100 |
| 4' (1219mm) | 240413-04300 |
| 5' (1524mm) | 240413-05500 |
| 6' (1829mm) | 240413-06700 |
| 7' (2134mm) | 240413-07900 |
| 8' (2438mm) | 240413-09100 |
| 9' (2743mm) | 240413-10300 |
| 10' (3048mm) | 240413-11500 |
| 11' (3353mm) | 240413-12700 |
| 12' (3658mm) | 240413-13900 |
| 13' (3962mm) | 240413-07200 240413-07900 |
| 14' (4267mm) | 240413-07200 240413-09100 |
| 15' (4572mm) | 240413-07200 240413-10300 |
| 16' (4877mm) | 240413-07200 240413-11500 |
| 17' (5182mm) | 240413-07200 240413-12700 |
| 18' (5486mm) | 240413-07200 240413-13900 |
| 19' (5791mm) | 240413-07900 240413-14400 |
| 20' (6096mm) | 240413-09100 240413-14400 |
| 21' (6401mm) | 240413-10300 240413-14400 |
| 22' (6706mm) | 240413-11500 240413-14400 |
| 23' (7010mm) | 240413-12700 240413-14400 |
| 24' (7315mm) | 240413-13900 240413-14400 |
| 25' (7620mm) | 240413-07900 240413-07200 240413-14400 |
| 26' (7925mm) | 240413-09100 240413-07200 240413-14400 |
| 27' (8230mm) | 240413-10300 240413-07200 240413-14400 |
| 28' (8534mm) | 240413-11500 240413-07200 240413-14400 |
| 29' (8839mm) | 240413-12700 240413-07200 240413-14400 |
| 30' (9144mm) | 240413-13900 240413-07200 240413-14400 |

Service Parts

| Item 13: Center Rail 12" Wide (305mm) | |
|---------------------------------------|---|
| Length | Part Number |
| 2' (610mm) | 240414-01273 |
| 3' (914mm) | 240414-02473 |
| 4' (1219mm) | 240414-03673 |
| 5' (1524mm) | 240414-04873 |
| 6' (1829mm) | 240414-06073 |
| 7' (2134mm) | 240414-07273 |
| 8' (2438mm) | 240414-08473 |
| 9' (2743mm) | 240414-09673 |
| 10' (3048mm) | 240414-10873 |
| 11' (3353mm) | 240414-12073 |
| 12' (3658mm) | 240414-13273 |
| 13' (3962mm) | 240414-07200 240414-07273 |
| 14' (4267mm) | 240414-07200 240414-08473 |
| 15' (4572mm) | 240414-07200 240414-09673 |
| 16' (4877mm) | 240414-07200 240414-10873 |
| 17' (5182mm) | 240414-07200 240414-12073 |
| 18' (5486mm) | 240414-07200 240414-13273 |
| 19' (5791mm) | 240414-07273 240414-14400 |
| 20' (6096mm) | 240414-08473 240414-14400 |
| 21' (6401mm) | 240414-09673 240414-14400 |
| 22' (6706mm) | 240414-10873 240414-14400 |
| 23' (7010mm) | 240414-12073 240414-14400 |
| 24' (7315mm) | 240414-13273 240414-14400 |
| 25' (7620mm) | 240414-07273 240414-07200 240414-14400 |
| 26' (7925mm) | 240414-08473 240414-07200 240414-14400 |
| 27' (8230mm) | 240414-09673 240414-07200 240414-14400 |
| 28' (8534mm) | 240414-10873 240414-07200 240414-14400 |
| 29' (8839mm) | 240414-12073 240414-07200 240414-14400 |
| 30' (9144mm) | 240414-13273 240414-07200 240414-14400 |

| Item 14: Bed Plate Top | |
|------------------------|--------------|
| Length | Part Number |
| 2' (610mm) | 2452WW-01892 |
| 3' (914mm) | 2452WW-03092 |
| 4' (1219mm) | 2452WW-04292 |
| 5' (1524mm) | 2452WW-05492 |
| 6' (1829mm) | 2452WW-06692 |
| 7' (2134mm) | 2452WW-07892 |
| 8' (2438mm) | 2452WW-09092 |
| 9' (2743mm) | 2452WW-10292 |
| 10' (3048mm) | 2452WW-11492 |

| | |
|-----------------------------------|---|
| 11' (3353mm) | 2452WW-12692 |
| 12' (3658mm) | 2452WW-13892 |
| 13' (3962mm) | 2452WW-07196 2452WW-07892 |
| 14' (4267mm) | 2452WW-07196 2452WW-09092 |
| 15' (4572mm) | 2452WW-07196 2452WW-10292 |
| 16' (4877mm) | 2452WW-07196 2452WW-11492 |
| 17' (5182mm) | 2452WW-07196 2452WW-12692 |
| 18' (5486mm) | 2452WW-07196 2452WW-13892 |
| 19' (5791mm) | 2452WW-07892 2452WW-14396 |
| 20' (6096mm) | 2452WW-09092 2452WW-14396 |
| 21' (6401mm) | 2452WW-10292 2452WW-14396 |
| 22' (6706mm) | 2452WW-11492 2452WW-14396 |
| 23' (7010mm) | 2452WW-12692 2452WW-14396 |
| 24' (7315mm) | 2452WW-13892 2452WW-14396 |
| 25' (7620mm) | 2452WW-07892 2452WW-07196 2452WW-14396 |
| 26' (7925mm) | 2452WW-09092 2452WW-07196 2452WW-14396 |
| 27' (8230mm) | 2452WW-10292 2452WW-07196 2452WW-14396 |
| 28' (8534mm) | 2452WW-11492 2452WW-07196 2452WW-14396 |
| 29' (8839mm) | 2452WW-12692 2452WW-07196 2452WW-14396 |
| 30' (9144mm) | 2452WW-13892 2452WW-07196 2452WW-14396 |
| WW = Conveyor Width reference: 12 | |

| Item 15: Bed Plate Bottom | |
|---------------------------|---------------------------|
| Length | Part Number |
| 2' (610mm) | 2405WW-01892 |
| 3' (914mm) | 2405WW-03092 |
| 4' (1219mm) | 2405WW-04292 |
| 5' (1524mm) | 2405WW-05492 |
| 6' (1829mm) | 2405WW-06692 |
| 7' (2134mm) | 2405WW-07892 |
| 8' (2438mm) | 2405WW-09092 |
| 9' (2743mm) | 2405WW-10292 |
| 10' (3048mm) | 2405WW-11492 |
| 11' (3353mm) | 2405WW-12692 |
| 12' (3658mm) | 2405WW-13892 |
| 13' (3962mm) | 2405WW-07196 2405WW-07892 |
| 14' (4267mm) | 2405WW-07196 2405WW-09092 |
| 15' (4572mm) | 2405WW-07196 2405WW-10292 |
| 16' (4877mm) | 2405WW-07196 2405WW-11492 |
| 17' (5182mm) | 2405WW-07196 2405WW-12692 |
| 18' (5486mm) | 2405WW-07196 2405WW-13892 |
| 19' (5791mm) | 2405WW-07892 2405WW-14396 |
| 20' (6096mm) | 2405WW-09092 2405WW-14396 |

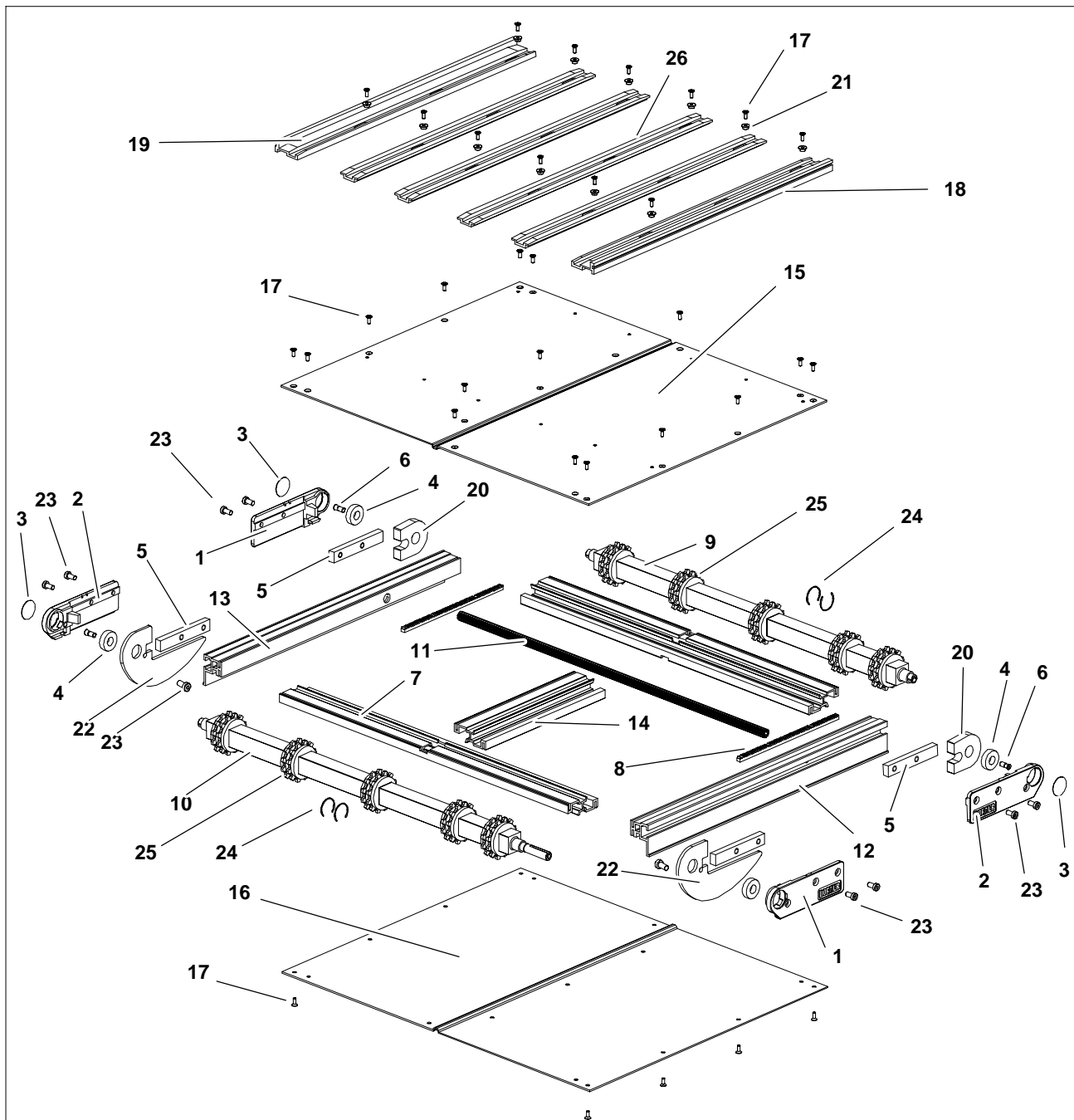
Service Parts

| | | |
|--------------|------------------------------|--------------|
| 21' (6401mm) | 2405WW-10292 | 2405WW-14396 |
| 22' (6706mm) | 2405WW-11492 | 2405WW-14396 |
| 23' (7010mm) | 2405WW-12692 | 2405WW-14396 |
| 24' (7315mm) | 2405WW-13892 | 2405WW-14396 |
| 25' (7620mm) | 2405WW-07892 2405WW-07196 | 2405WW-14396 |
| 26' (7925mm) | 2405WW-09092 2405WW-07196 | 2405WW-14396 |

| | | |
|-----------------------------------|------------------------------|--------------|
| 27' (8230mm) | 2405WW-10292 2405WW-07196 | 2405WW-14396 |
| 28' (8534mm) | 2405WW-11492 2405WW-07196 | 2405WW-14396 |
| 29' (8839mm) | 2405WW-12692 2405WW-07196 | 2405WW-14396 |
| 30' (9144mm) | 2405WW-13892 2405WW-07196 | 2405WW-14396 |
| WW = Conveyor Width reference: 12 | | |

Service Parts

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



| Item | Part Number | Description |
|------|-------------|---------------------------------------|
| 1 | 240325 | Head Plate LH |
| 2 | 240326 | Head Plate RH |
| 3 | 240327 | Bearing Cover Disk |
| 4 | 240328 | Bearing |
| 5 | 240329 | Tension Slide Bar |
| 6 | 240330 | Taper Screw |
| 7 | 240417 | Center Rail Cross Support 18" (457mm) |
| | 240419 | Center Rail Cross Support 24" (610mm) |
| 8 | 240420 | Rack Gear 14.5 PA x 24 P |

| | | |
|----|-----------------|-------------------------------------|
| 9 | 245518 | 18" MPB Idler Spindle |
| | 245524 | 24" MPB Idler Spindle |
| 10 | 245718 | 18" MPB Drive Spindle |
| | 245724 | 24" MPB Drive Spindle |
| 11 | 203018M | Pinion Gear 18" (457mm) |
| | 203024M | Pinion Gear 24" (610mm) |
| 12 | See Chart Below | Side Rail RH 8–24" Wide (203–610mm) |
| 13 | See Chart Below | Side Rail LH 8–24" Wide (203–610mm) |
| 14 | See Chart Below | Center Rail 8–12" Wide (203–305mm) |

| | | |
|----|-----------------|--------------------------------|
| 15 | See Chart Below | Bed Plate Top |
| 16 | See Chart Below | Bed Plate Bottom |
| 17 | 807-1105 | Torx, Flat Head M4 x 10mm |
| 18 | 245827-LLLL | LH Outer Wear Strip – UHMW |
| | 245828-LLLL | LH Outer Wear Strip – Antistat |
| 19 | 245829-LLLL | RH Outer Wear Strip – UHMW |
| | 245830-LLLL | RH Outer Wear Strip – Antistat |
| 20 | 245850 | Pinch Guard |
| 21 | 245854 | Screw Sleeve |
| 22 | 245858 | Sag Guard |
| 23 | 920692M | Socket Head Screw M6 x 12mm |
| 24 | 807-1108 | Retaining Ring |
| 25 | 807-1106 | MPB Spindle Sprocket |
| 26 | 245831-LLLL | Center Wear Strips – UHMW |
| | 245832-LLLL | Center Wear Strips – Antistat |

| Item 12: Side Rail RH 18" and 24" Wide (457mm & 610mm) | |
|--|---|
| Length | Part Number |
| 2' (610mm) | 240412-01900 |
| 3' (914mm) | 240412-03100 |
| 4' (1219mm) | 240412-04300 |
| 5' (1524mm) | 240412-05500 |
| 6' (1829mm) | 240412-06700 |
| 7' (2134mm) | 240412-07900 |
| 8' (2438mm) | 240412-09100 |
| 9' (2743mm) | 240412-10300 |
| 10' (3048mm) | 240412-11500 |
| 11' (3353mm) | 240412-12700 |
| 12' (3658mm) | 240412-13900 |
| 13' (3962mm) | 240412-07200 240412-07900 |
| 14' (4267mm) | 240412-07200 240412-09100 |
| 15' (4572mm) | 240412-07200 240412-10300 |
| 16' (4877mm) | 240412-07200 240412-11500 |
| 17' (5182mm) | 240412-07200 240412-12700 |
| 18' (5486mm) | 240412-07200 240412-13900 |
| 19' (5791mm) | 240412-07900 240412-13900 |
| 20' (6096mm) | 240412-09100 240412-13900 |
| 21' (6401mm) | 240412-10300 240412-13900 |
| 22' (6706mm) | 240412-11500 240412-13900 |
| 23' (7010mm) | 240412-12700 240412-13900 |
| 24' (7315mm) | 240412-13900 240412-13900 |
| 25' (7620mm) | 240412-07900 240412-07200 240412-13900 |
| 26' (7925mm) | 240412-09100 240412-07200 240412-13900 |
| 27' (8230mm) | 240412-10300 240412-07200 240412-13900 |

| | |
|--------------|---|
| 28' (8534mm) | 240412-11500 240412-07200 240412-13900 |
| 29' (8839mm) | 240412-12700 240412-07200 240412-13900 |
| 30' (9144mm) | 240412-13900 240412-07200 240412-13900 |

| Item 13: Side Rail LH 18" and 24" Wide (457mm & 610mm) | |
|--|---|
| Length | Part Number |
| 2' (610mm) | 240413-01900 |
| 3' (914mm) | 240413-03100 |
| 4' (1219mm) | 240413-04300 |
| 5' (1524mm) | 240413-05500 |
| 6' (1829mm) | 240413-06700 |
| 7' (2134mm) | 240413-07900 |
| 8' (2438mm) | 240413-09100 |
| 9' (2743mm) | 240413-10300 |
| 10' (3048mm) | 240413-11500 |
| 11' (3353mm) | 240413-12700 |
| 12' (3658mm) | 240413-13900 |
| 13' (3962mm) | 240413-07200 240413-07900 |
| 14' (4267mm) | 240413-07200 240413-09100 |
| 15' (4572mm) | 240413-07200 240413-10300 |
| 16' (4877mm) | 240413-07200 240413-11500 |
| 17' (5182mm) | 240413-07200 240413-12700 |
| 18' (5486mm) | 240413-07200 240413-13900 |
| 19' (5791mm) | 240413-07900 240413-13900 |
| 20' (6096mm) | 240413-09100 240413-13900 |
| 21' (6401mm) | 240413-10300 240413-13900 |
| 22' (6706mm) | 240413-11500 240413-13900 |
| 23' (7010mm) | 240413-12700 240413-13900 |
| 24' (7315mm) | 240413-13900 240413-13900 |
| 25' (7620mm) | 240413-07900 240413-07200 240413-13900 |
| 26' (7925mm) | 240413-09100 240413-07200 240413-13900 |
| 27' (8230mm) | 240413-10300 240413-07200 240413-13900 |
| 28' (8534mm) | 240413-11500 240413-07200 240413-13900 |
| 29' (8839mm) | 240413-12700 240413-07200 240413-13900 |
| 30' (9144mm) | 240413-13900 240413-07200 240413-13900 |

| Item 14: Center Rail 18" and 24" Wide (457mm-610mm) | |
|---|--------------|
| Length | Part Number |
| 2' (610mm) | 240414-00990 |
| 3' (914mm) | 240414-02190 |
| 4' (1219mm) | 240414-03390 |
| 5' (1524mm) | 240414-04490 |
| 6' (1829mm) | 240414-05790 |

Service Parts

| | |
|--------------|---|
| 7' (2134mm) | 240414-06990 |
| 8' (2438mm) | 240414-08190 |
| 9' (2743mm) | 240414-09390 |
| 10' (3048mm) | 240414-10590 |
| 11' (3353mm) | 240414-11790 |
| 12' (3658mm) | 240414-12990 |
| 13' (3962mm) | 240414-06700 240414-06990 |
| 14' (4267mm) | 240414-06700 240414-08190 |
| 15' (4572mm) | 240414-06700 240414-09390 |
| 16' (4877mm) | 240414-06700 240414-10590 |
| 17' (5182mm) | 240414-06700 240414-11790 |
| 18' (5486mm) | 240414-06700 240414-12990 |
| 19' (5791mm) | 240414-06990 240414-13900 |
| 20' (6096mm) | 240414-08190 240414-13900 |
| 21' (6401mm) | 240414-09390 240414-13900 |
| 22' (6706mm) | 240414-10590 240414-13900 |
| 23' (7010mm) | 240414-11790 240414-13900 |
| 24' (7315mm) | 240414-12990 240414-13900 |
| 25' (7620mm) | 240414-06990 240414-06700 240414-13900 |
| 26' (7925mm) | 240414-08190 240414-06700 240414-13900 |
| 27' (8230mm) | 240414-09390 240414-06700 240414-13900 |
| 28' (8534mm) | 240414-10590 240414-06700 240414-13900 |
| 29' (8839mm) | 240414-11790 240414-06700 240414-13900 |
| 30' (9144mm) | 240414-12990 240414-06700 240414-13900 |

| Item 15: Bed Plate Top | |
|------------------------|---------------------------|
| Length | Part Number |
| 2' (610mm) | 2452WW-01892 |
| 3' (914mm) | 2452WW-03092 |
| 4' (1219mm) | 2452WW-04292 |
| 5' (1524mm) | 2452WW-05492 |
| 6' (1829mm) | 2452WW-06692 |
| 7' (2134mm) | 2452WW-07892 |
| 8' (2438mm) | 2452WW-09092 |
| 9' (2743mm) | 2452WW-10292 |
| 10' (3048mm) | 2452WW-11492 |
| 11' (3353mm) | 2452WW-12692 |
| 12' (3658mm) | 2452WW-13892 |
| 13' (3962mm) | 2452WW-07196 2452WW-07892 |
| 14' (4267mm) | 2452WW-07196 2452WW-09092 |
| 15' (4572mm) | 2452WW-07196 2452WW-10292 |
| 16' (4877mm) | 2452WW-07196 2452WW-11492 |
| 17' (5182mm) | 2452WW-07196 2452WW-12692 |

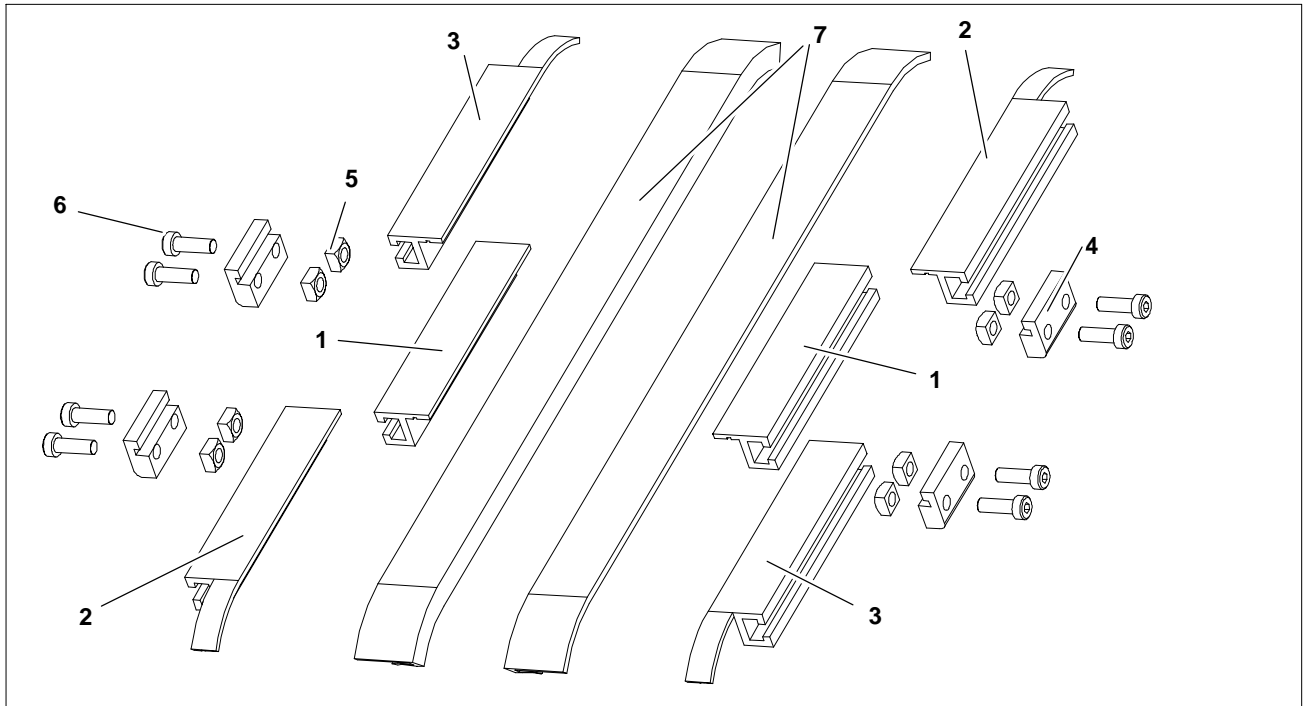
| | |
|---------------------------------------|---|
| 18' (5486mm) | 2452WW-07196 2452WW-13892 |
| 19' (5791mm) | 2452WW-07892 2452WW-14396 |
| 20' (6096mm) | 2452WW-09092 2452WW-14396 |
| 21' (6401mm) | 2452WW-10292 2452WW-14396 |
| 22' (6706mm) | 2452WW-11492 2452WW-14396 |
| 23' (7010mm) | 2452WW-12692 2452WW-14396 |
| 24' (7315mm) | 2452WW-13892 2452WW-14396 |
| 25' (7620mm) | 2452WW-07892 2452WW-07196 2452WW-14396 |
| 26' (7925mm) | 2452WW-09092 2452WW-07196 2452WW-14396 |
| 27' (9230mm) | 2452WW-10292 2452WW-07196 2452WW-14396 |
| 28' (8534mm) | 2452WW-11492 2452WW-07196 2452WW-14396 |
| 29' (8839mm) | 2452WW-12692 2452WW-07196 2452WW-14396 |
| 30' (9144mm) | 2452WW-13892 2452WW-07196 2452WW-14396 |
| WW = Conveyor Width reference: 18, 24 | |

| Item 16: Bed Plate Bottom | |
|---------------------------|---|
| Length | Part Number |
| 2' (610mm) | 2405WW-01892 |
| 3' (914mm) | 2405WW-03092 |
| 4' (1219mm) | 2405WW-04292 |
| 5' (1524mm) | 2405WW-05492 |
| 6' (1829mm) | 2405WW-06692 |
| 7' (2134mm) | 2405WW-07892 |
| 8' (2438mm) | 2405WW-09092 |
| 9' (2743mm) | 2405WW-10292 |
| 10' (3048mm) | 2405WW-11492 |
| 11' (3353mm) | 2405WW-12692 |
| 12' (3658mm) | 2405WW-13892 |
| 13' (3962mm) | 2405WW-07196 2405WW-07892 |
| 14' (4267mm) | 2405WW-07196 2405WW-09092 |
| 15' (4572mm) | 2405WW-07196 2405WW-10292 |
| 16' (4877mm) | 2405WW-07196 2405WW-11492 |
| 17' (5182mm) | 2405WW-07196 2405WW-12692 |
| 18' (5486mm) | 2405WW-07196 2405WW-13892 |
| 19' (5791mm) | 2405WW-07892 2405WW-14396 |
| 20' (6096mm) | 2405WW-09092 2405WW-14396 |
| 21' (6401mm) | 2405WW-10292 2405WW-14396 |
| 22' (6706mm) | 2405WW-11492 2405WW-14396 |
| 23' (7010mm) | 2405WW-12692 2405WW-14396 |
| 24' (7315mm) | 2405WW-13892 2405WW-14396 |
| 25' (7620mm) | 2405WW-07892 2405WW-07196 2405WW-14396 |

| | |
|--------------|---|
| 26' (7925mm) | 2405WW-09092 2405WW-07196 2405WW-14396 |
| 27' (9230mm) | 2405WW-10292 2405WW-07196 2405WW-14396 |
| 28' (8534mm) | 2405WW-11492 2405WW-07196 2405WW-14396 |

| | |
|---------------------------------------|---|
| 29' (8839mm) | 2405WW-12692 2405WW-07196 2405WW-14396 |
| 30' (9144mm) | 2405WW-13892 2405WW-07196 2405WW-14396 |
| WW = Conveyor Width reference: 18, 24 | |

Return Wear Strip Assembly – 2' (610mm) and 3' (914mm) Long

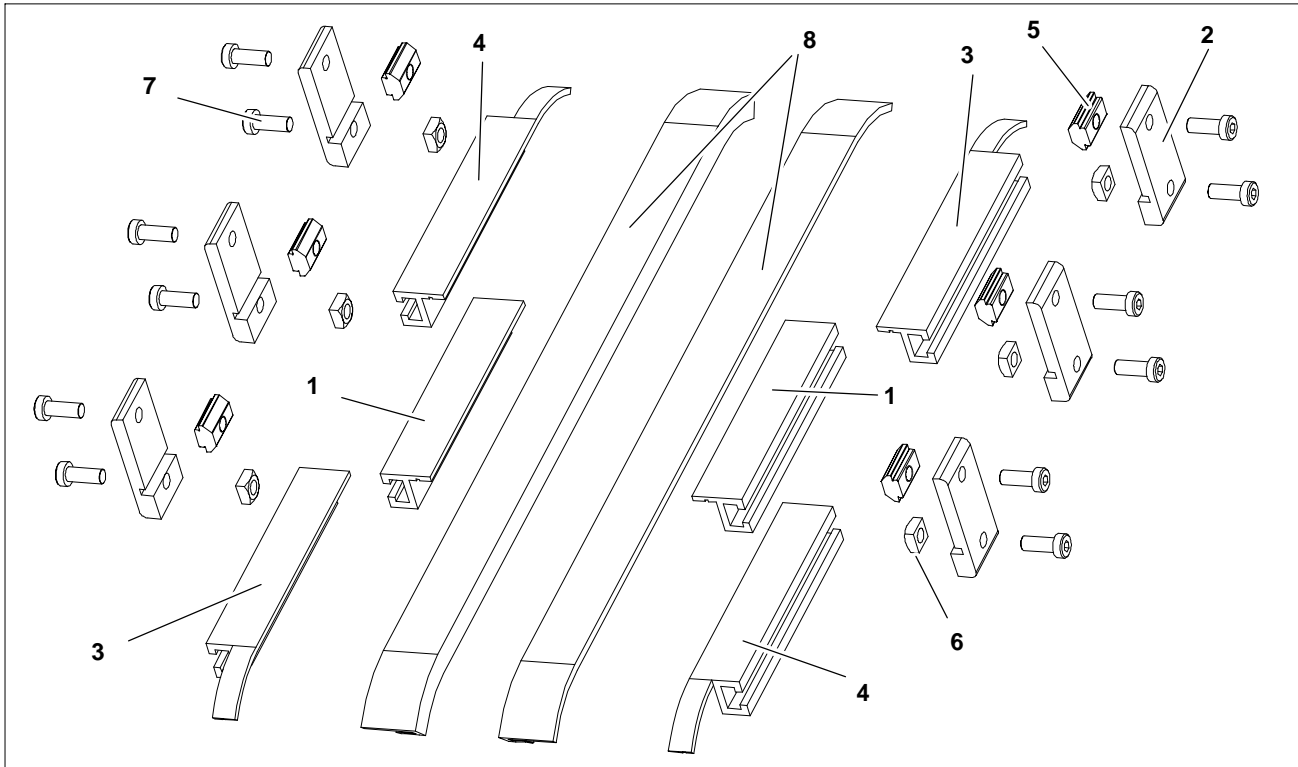


| Item | Part Number | Description |
|------|--------------|-------------------------------------|
| 1 | 246075-00425 | 2' (610mm) Return Support Extrusion |
| | 246075-01625 | 3' (914mm) Return Support Extrusion |
| 2 | 246078 | LH Lead-in Return Support |
| 3 | 246079 | RH Lead-in Return Support |
| 4 | 246080 | MPB Return Connector Clip |

| | | |
|------------------------------------|--------------|-------------------------------|
| 5 | 807-920 | M6 Square Nut |
| 6 | 920693M | Scr, Cap Low Head M6 1.0x16mm |
| 7 | 246082-LLLLL | Bottom Wear Strip – UHMW |
| | 246083-LLLLL | Bottom Wear Strip – Antistat |
| LLLLL = Wearstrip Length Reference | | |

Service Parts

Return Wear Strip Assembly – 4' (1219mm) to 30' (9144mm) Length

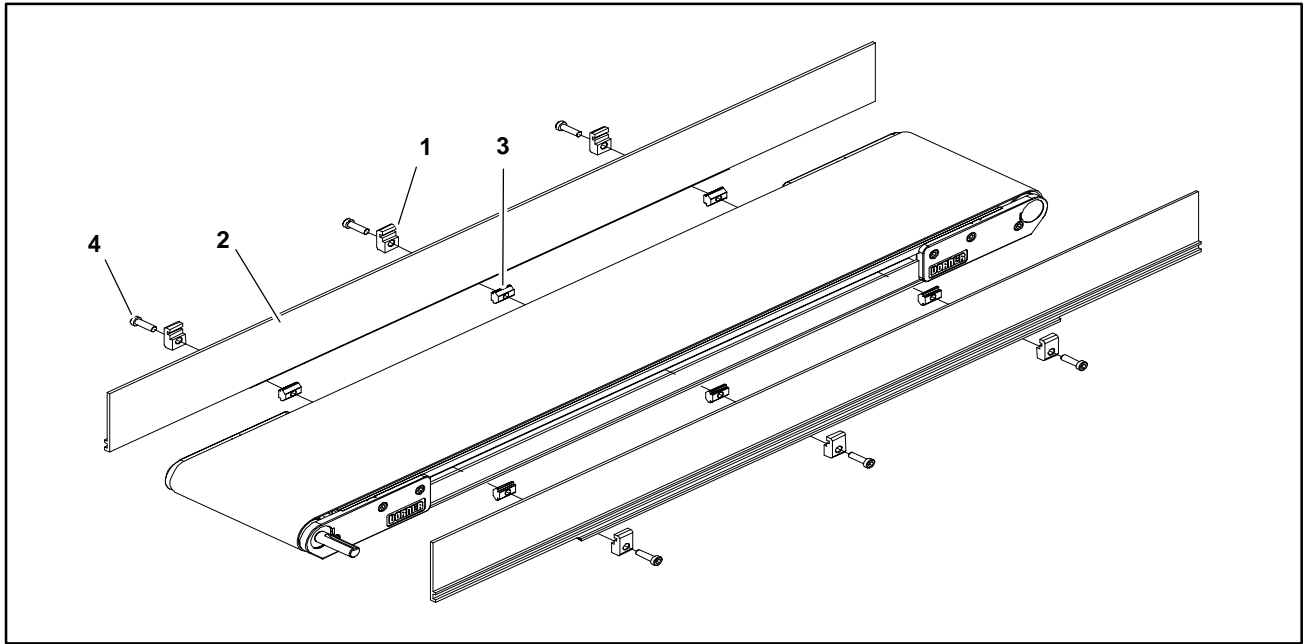


| Item | Part Number | Description |
|------------------------------------|-----------------|-------------------------------|
| 1 | See Chart Below | Return Support Extrusion |
| 2 | 246076 | MPB Return Clip |
| 3 | 246078 | LH Lead-in Return Support |
| 4 | 246079 | RH Lead-in Return Support |
| 5 | 639971M | M6 Drop In Tee Bar |
| 6 | 807-920 | M6 Square Nut |
| 7 | 920693M | Scr, Cap Low Head M6 1.0x16mm |
| 8 | 246082-LLLLL | Bottom Wear Strip – UHMW |
| 9 | 246083-LLLLL | Bottom Wear Strip – Antistat |
| LLLLL = Wearstrip Length Reference | | |

| Item 1: MPB Return Support Extrusion | |
|--------------------------------------|--------------|
| Length | Part Number |
| 4' (1219mm) | 246075-02825 |
| 5' (1524mm) | 246075-04025 |
| 6' (1829mm) | 246075-05225 |
| 7' (2134mm) | 246075-06425 |
| 8' (2438mm) | 246075-07625 |
| 9' (2743mm) | 246075-08825 |

| | |
|--------------|--|
| 10' (3048mm) | 246075-10025 |
| 11' (3353mm) | 246075-11225 |
| 12' (3658mm) | 246075-12425 |
| 13' (3962mm) | 246075-07387; 246075-0519 |
| 14' (4267mm) | 246075-08587; 246075-0519 |
| 15' (4572mm) | 246075-09787; 246075-0519 |
| 16' (4877mm) | 246075-10987; 246075-0519 |
| 17' (5182mm) | 246075-12187; 246075-0519 |
| 18' (5486mm) | 246075-13387; 246075-0519 |
| 19' (5791mm) | 246075-07387; 246075-1119 |
| 20' (6096mm) | 246075-08587; 246075-1119 |
| 21' (6401mm) | 246075-09787; 246075-1119 |
| 22' (6706mm) | 246075-10987; 246075-1119 |
| 23' (7011mm) | 246075-12187; 246075-1119 |
| 24' (7315mm) | 246075-13387; 246075-1119 |
| 25' (7620mm) | 246075-07387; 246075-0519; 246075-1200 |
| 26' (7925mm) | 246075-08587; 246075-0519; 246075-1201 |
| 27' (8230mm) | 246075-09787; 246075-0519; 246075-1202 |
| 28' (8534mm) | 246075-10987; 246075-0519; 246075-1203 |
| 29' (8839mm) | 246075-12187; 246075-0519; 246075-1204 |
| 30' (9144mm) | 246075-13387; 246075-0519; 246075-1205 |

-04 2.3" (60mm) Aluminum Side



| Item | Part Number | Description |
|------|-----------------|-----------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | See Chart Below | MPB Guide 2.3" (60mm) HS |
| 3 | 200695P | Single Drop-in Tee Bar |
| 4 | 920694M | Socket Head Screw M6 x 20mm |

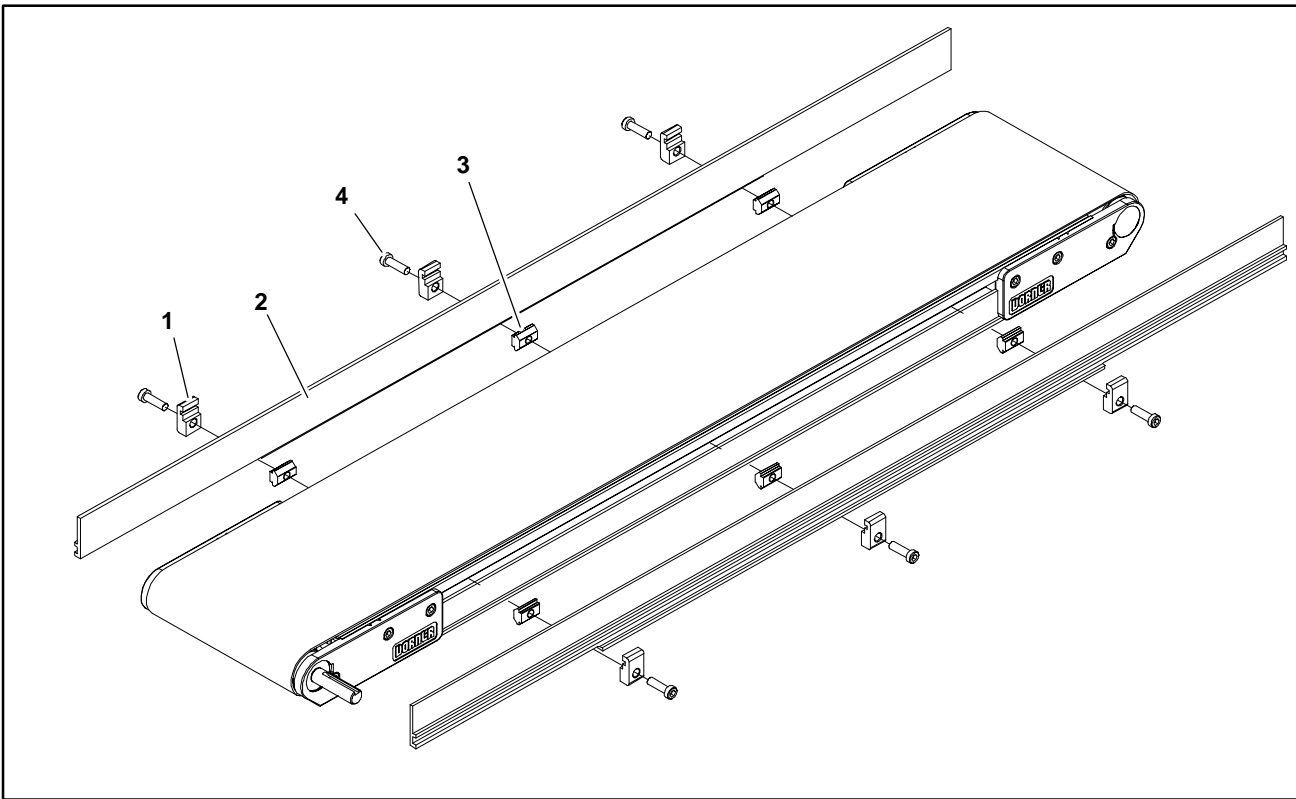
| Item 2: MPB Guide 2.3"(60mm) HS 2'(610mm) to 24'(7315mm) | | | |
|--|------------|--------------|-----------|
| Length | | End Guide | End Guide |
| 2' (610mm) | Left Hand | 280403-02400 | N/A |
| | Right Hand | 280403-02400 | N/A |
| 3' (914mm) | Left Hand | 280403-03600 | N/A |
| | Right Hand | 280403-03600 | N/A |
| 4' (1219mm) | Left Hand | 280403-04800 | N/A |
| | Right Hand | 280403-04800 | N/A |
| 5' (1524mm) | Left Hand | 280403-06000 | N/A |
| | Right Hand | 280403-06000 | N/A |
| 6' (1829mm) | Left Hand | 280403-07200 | N/A |
| | Right Hand | 280403-07200 | N/A |
| 7' (2134mm) | Left Hand | 280403-08400 | N/A |
| | Right Hand | 280403-08400 | N/A |
| 8' (2438mm) | Left Hand | 280403-09600 | N/A |
| | Right Hand | 280403-09600 | N/A |
| 9' (2743mm) | Left Hand | 280403-10800 | N/A |
| | Right Hand | 280403-10800 | N/A |
| 10' (3048mm) | Left Hand | 280403-12000 | N/A |
| | Right Hand | 280403-12000 | N/A |
| 11' (3353mm) | Left Hand | 280403-13200 | N/A |

| | | | |
|--------------|------------|--------------|--------------|
| 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 |
| 19' (5791mm) | Right Hand | 280402-07500 | 280402-14100 |
| | Left Hand | 280401-14700 | 280401-08100 |
| 20' (6096mm) | Right Hand | 280402-14700 | 280402-08100 |
| | Left Hand | 280401-14700 | 280401-09300 |
| 21' (6401mm) | Right Hand | 280402-14700 | 280402-09300 |
| | Left hand | 280401-14700 | 280401-10500 |
| 22' (6706mm) | Right Hand | 280402-14700 | 280402-10500 |
| | Left Hand | 280401-14700 | 280401-11700 |
| 23' (7010mm) | Right Hand | 280402-14700 | 280402-11700 |
| | Left Hand | 280401-14700 | 280401-12900 |
| 24' (7315mm) | Right Hand | 280402-14700 | 280402-12900 |
| | Left Hand | 280401-14700 | 280401-14100 |
| | Right Hand | 280402-14700 | 280402-14100 |

Service Parts

| Item 2: MPB Guide 2.3" (60mm) HS 25' (7620mm) to 30' (9144mm) | | | | |
|---|------------|--------------|--------------|---------------|
| Length | | End Guide | End Guide | Center |
| 25' (7620mm) | Left Hand | 280401-07500 | 280401-08100 | 200601P-14400 |
| | Right Hand | 280402-07500 | 280402-08100 | 200601P-14400 |
| 26' (7925mm) | Left Hand | 280401-07500 | 280401-09300 | 200601P-14400 |
| | Right Hand | 280402-07500 | 280402-09300 | 200601P-14400 |
| 27' (8230mm) | Left Hand | 280401-07500 | 280401-10500 | 200601P-14400 |
| | Right Hand | 280402-07500 | 280402-10500 | 200601P-14400 |
| 28' (8534mm) | Left Hand | 280401-07500 | 280401-11700 | 200601P-14400 |
| | Right Hand | 280402-07500 | 280402-11700 | 200601P-14400 |
| 29' (8839mm) | Left Hand | 280401-07500 | 280401-12900 | 200601P-14400 |
| | Right Hand | 280402-07500 | 280402-12900 | 200601P-14400 |
| 30' (9144mm) | Left Hand | 280401-07500 | 280401-14100 | 200601P-14400 |
| | Right Hand | 280402-07500 | 280402-14100 | 200601P-14400 |

-05 1.5" (38mm) Aluminum Side



| Item | Part Number | Description |
|------|-----------------|-----------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | See Chart Below | MPB 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 | 280503-0240 0 | N/A |
| | Right Hand | 280503-0240 0 | N/A |

| | | | |
|-------------|------------|------------------|-----|
| 3' (914mm) | Left Hand | 280503-0360 0 | N/A |
| | Right Hand | 280503-0360 0 | N/A |
| 4' (1219mm) | Left Hand | 280503-0480 0 | N/A |
| | Right Hand | 280503-0480 0 | N/A |
| 5' (1524mm) | Left Hand | 280503-0600 0 | N/A |
| | Right Hand | 280503-0600 0 | N/A |
| 6' (1829mm) | Left Hand | 280503-0720 0 | N/A |

Service Parts

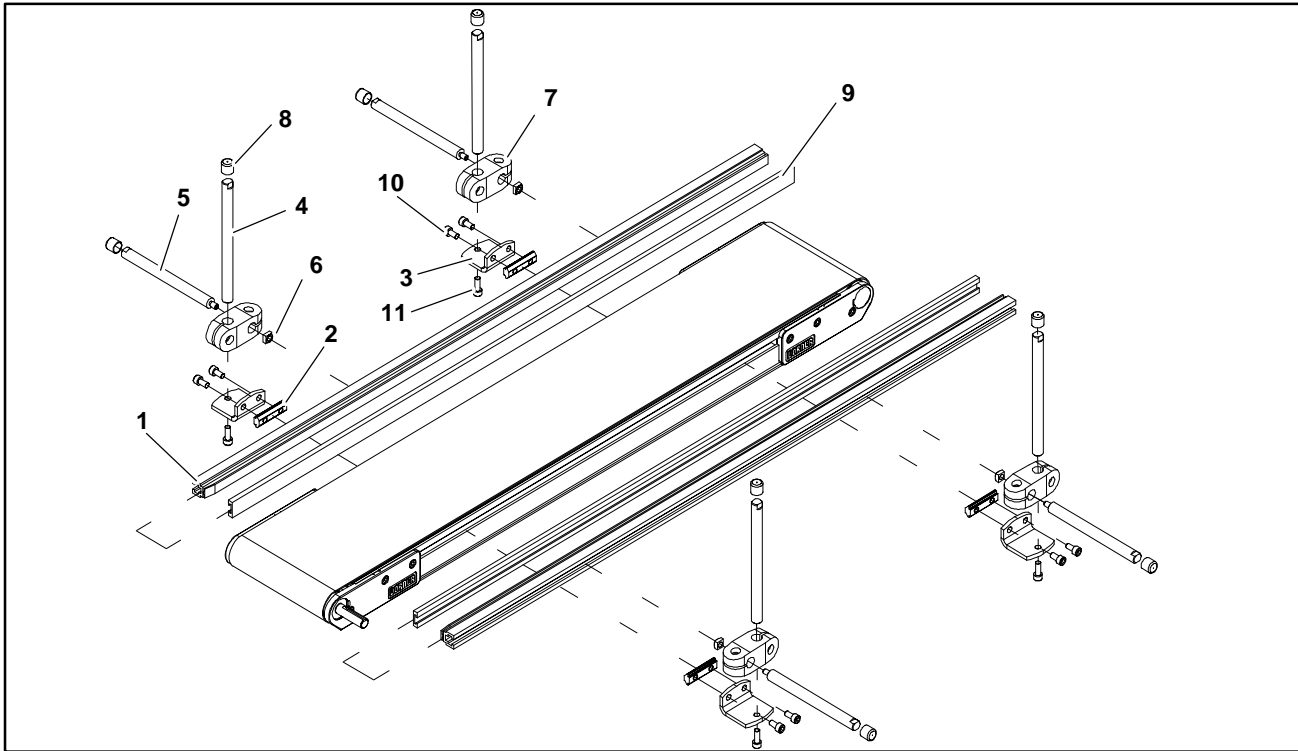
| | | | |
|--------------|------------|------------------|------------------|
| | Right Hand | 280503-0720 0 | N/A |
| 7' (2134mm) | Left Hand | 280503-0840 0 | N/A |
| | Right Hand | 280503-0840 0 | N/A |
| 8' (2438mm) | Left Hand | 280503-0960 0 | N/A |
| | Right Hand | 280503-0960 0 | N/A |
| 9' (2743mm) | Left Hand | 280503-1080 0 | N/A |
| | Right Hand | 280503-1080 0 | N/A |
| 10' (3048mm) | Left Hand | 280503-1200 0 | N/A |
| | Right Hand | 280503-1200 0 | N/A |
| 11' (3353mm) | Left Hand | 280503-1320 0 | N/A |
| | Right Hand | 280503-1320 0 | N/A |
| 12' (3658mm) | Left Hand | 280503-1440 0 | N/A |
| | Right Hand | 280503-1440 0 | N/A |
| 13' (3962mm) | Left Hand | 280501-0750 0 | 280501-0810 0 |
| | Right Hand | 280502-0750 0 | 280502-0810 0 |
| 14' (4267mm) | Left Hand | 280501-0750 0 | 280501-0930 0 |
| | Right Hand | 280502-0750 0 | 280502-0930 0 |
| 15' (4572mm) | Left hand | 280501-0750 0 | 280501-1050 0 |
| | Right Hand | 280502-0750 0 | 280502-1050 0 |

| | | | |
|--------------|------------|------------------|------------------|
| 16' (4877mm) | Left Hand | 280501-0750 0 | 280501-1170 0 |
| | Right Hand | 280502-0750 0 | 280502-1170 0 |
| 17' (5182mm) | Left Hand | 280501-0750 0 | 280501-1290 0 |
| | Right Hand | 280502-0750 0 | 280502-1290 0 |
| 18' (5486mm) | Left Hand | 280501-0750 0 | 280501-1410 0 |
| | Right Hand | 280502-0750 0 | 280502-1410 0 |
| 19' (mm) | Left Hand | 280501-1470 0 | 280501-0810 0 |
| | Right Hand | 280502-1470 0 | 280502-0810 0 |
| 20' (mm) | Left Hand | 280501-1470 0 | 280501-0930 0 |
| | Right Hand | 280502-1470 0 | 280502-0930 0 |
| 21' (mm) | Left hand | 280501-1470 0 | 280501-1050 0 |
| | Right Hand | 280502-1470 0 | 280502-1050 0 |
| 22' (mm) | Left Hand | 280501-1470 0 | 280501-1170 0 |
| | Right Hand | 280502-1470 0 | 280502-1170 0 |
| 23' (mm) | Left Hand | 280501-1470 0 | 280501-1290 0 |
| | Right Hand | 280502-1470 0 | 280502-1290 0 |
| 24' (mm) | Left Hand | 280501-1470 0 | 280501-1410 0 |
| | Right Hand | 280502-1470 0 | 280502-1410 0 |

| Item 2: MPB Guide .5" (13mm) HS 25' (7620mm) to 30' (9144mm) | | | | |
|--|------------|--------------|--------------|---------------|
| Length | | End Guide | End Guide | Center |
| 25' (7620mm) | Left Hand | 280501-07500 | 280501-08100 | 200750P-14400 |
| | Right Hand | 280502-07500 | 280502-08100 | 200750P-14400 |
| 26' (7925mm) | Left Hand | 280501-07500 | 280501-09300 | 200750P-14400 |
| | Right Hand | 280502-07500 | 280502-09300 | 200750P-14400 |
| 27' (8230mm) | Left Hand | 280501-07500 | 280501-10500 | 200750P-14400 |
| | Right Hand | 280502-07500 | 280502-10500 | 200750P-14400 |
| 28' (8534mm) | Left Hand | 280501-07500 | 280501-11700 | 200750P-14400 |
| | Right Hand | 280502-07500 | 280502-11700 | 200750P-14400 |
| 29' (8839mm) | Left Hand | 280501-07500 | 280501-12900 | 200750P-14400 |
| | Right Hand | 280502-07500 | 280502-12900 | 200750P-14400 |
| 30' (9144mm) | Left Hand | 280501-07500 | 280501-14100 | 200750P-14400 |
| | Right Hand | 280502-07500 | 280502-14100 | 200750P-14400 |

Service Parts

-13 Adjustable Guiding

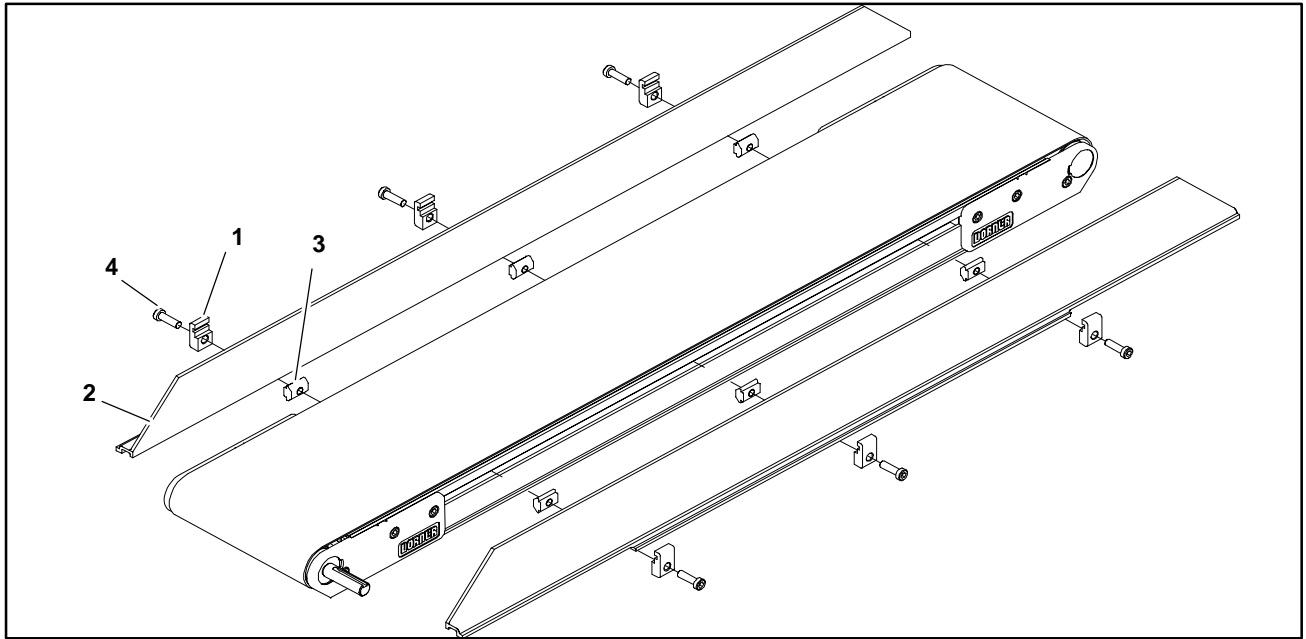


| Item | Part Number | Description |
|------|-----------------|---------------------------------|
| 1 | See Chart Below | Aluminum Profile Guide |
| 2 | 200830M | Drop-In Tee Bar |
| 3 | 202004 | Mounting Bracket |
| 4 | 202027M | Guide Mounting Shaft Vertical |
| 5 | 202028M | Guide Mounting Shaft Horizontal |
| 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 |

| Item 2: MPB Aluminum Profile Guide | | | |
|------------------------------------|-----------|--------------|-----------|
| Length | End Guide | Middle Guide | End Guide |
| 2' (610mm) | 202983 | N/A | N/A |
| 3' (914mm) | 202984 | N/A | N/A |
| 4' (1219mm) | 202985 | N/A | N/A |
| 5' (1524mm) | 202986 | N/A | N/A |
| 6' (1829mm) | 202987 | N/A | N/A |
| 7' (2134mm) | 202988 | N/A | N/A |
| 8' (2438mm) | 202989 | N/A | N/A |

| | | | |
|--------------|--------|--------|--------|
| 9' (2743mm) | 202990 | N/A | N/A |
| 10' (3048mm) | 202991 | N/A | N/A |
| 11' (3353mm) | 202992 | N/A | N/A |
| 12' (3658mm) | 202993 | N/A | N/A |
| 13' (3962mm) | 202988 | 202987 | N/A |
| 14' (4267mm) | 202989 | 202987 | N/A |
| 15' (4572mm) | 202990 | 202987 | N/A |
| 16' (4877mm) | 202991 | 202987 | N/A |
| 17' (5182mm) | 202992 | 202987 | N/A |
| 18' (5486mm) | 202993 | 202987 | N/A |
| 19' (5791mm) | 202988 | 202993 | N/A |
| 20' (6096mm) | 202989 | 202993 | N/A |
| 21' (6401mm) | 202990 | 202993 | N/A |
| 22' (6706mm) | 202991 | 202993 | N/A |
| 23' (7010mm) | 202992 | 202993 | N/A |
| 24' (7315mm) | 202993 | 202993 | N/A |
| 25' (7620mm) | 202988 | 202993 | 202987 |
| 26' (7925mm) | 202989 | 202993 | 202987 |
| 27' (8230mm) | 202990 | 202993 | 202987 |
| 28' (8534mm) | 202991 | 202993 | 202987 |
| 29' (8839mm) | 202992 | 202993 | 202987 |
| 30' (9144mm) | 202993 | 202993 | 202987 |

2" (51mm) Cleated Guiding



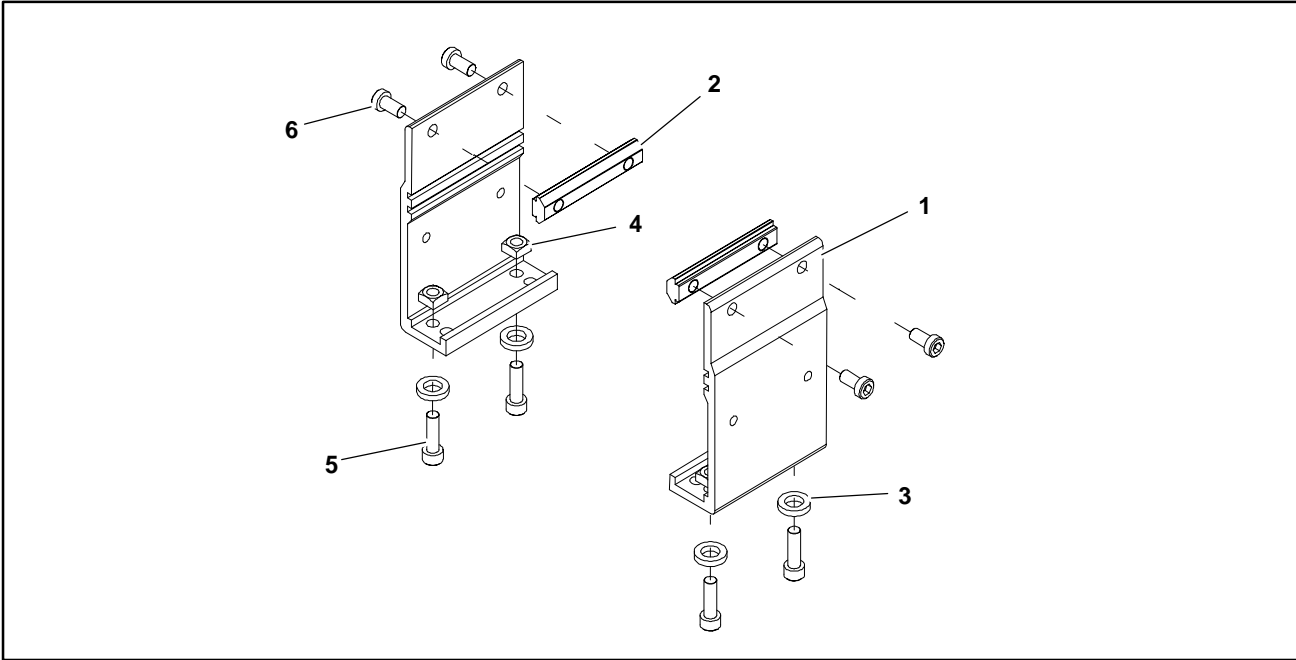
| Item | Part Number | Description |
|------|-----------------|-----------------------------|
| 1 | 200121 | Guide Retaining Clip |
| 2 | See Chart Below | 2200 Guide 2.3" Cleated |
| 3 | 639971M | Drop-In Tee Bar |
| 4 | 920694M | Socket Head Screw M6 x 20mm |

| Item 2: MPB Cleated Guide | | | |
|---------------------------|--------------|------------------------------|--------------|
| Length | End Guide | Middle Guide | End Guide |
| 2' (610mm) | 246051-01070 | N/A | 246052-01070 |
| 3' (914mm) | 246051-01670 | N/A | 246052-01670 |
| 4' (1219mm) | 246051-02270 | N/A | 246052-02270 |
| 5' (1524mm) | 246051-02870 | N/A | 246052-02870 |
| 6' (1829mm) | 246051-03470 | N/A | 246052-03470 |
| 7' (2134mm) | 246051-04070 | N/A | 246052-04070 |
| 8' (2438mm) | 246051 | N/A | 246052 |
| 9' (2743mm) | 246051-03513 | 246050-03513 | 246052-03513 |
| 10' (3048mm) | 246051-03913 | 246050-03913 | 246052-03913 |
| 11' (3353mm) | 246051 | 246050-03600 | 246052 |
| 12' (3658mm) | 246051 | 246050-04800 | 246052 |
| 13' (3962mm) | 246051 | 246050-03300 246050-02700 | 246052 |
| 14' (4267mm) | 246051 | 246050-04500 246050-02700 | 246052 |
| 15' (4572mm) | 246051 | 246050-05700 246050-02700 | 246052 |
| 16' (4877mm) | 246051 | 246050-06900 246050-02700 | 246052 |

| | | | |
|--------------|--------|--|--------|
| 17' (5182mm) | 246051 | 246050-08100 246050-02700 | 246052 |
| 18' (5486mm) | 246051 | 246050-09300 246050-02700 | 246052 |
| 19' (5791mm) | 246051 | 246050-03300 246050-09900 | 246052 |
| 20' (6096mm) | 246051 | 246050-04500 246050-09900 | 246052 |
| 21' (6401mm) | 246051 | 246050-05700 246050-09900 | 246052 |
| 22' (6706mm) | 246051 | 246050-06900 246050-09900 | 246052 |
| 23' (7010mm) | 246051 | 246050-08100 246050-09900 | 246052 |
| 24' (7315mm) | 246051 | 246050-09300 246050-09900 | 246052 |
| 25' (7620mm) | 246051 | 246050-09300 246050-09900 246050-02700 | 246052 |
| 26' (7925mm) | 246051 | 246050-03300 246050-14400 246050-02700 | 246052 |
| 27' (8230mm) | 246051 | 246050-04500 246050-14400 246050-02700 | 246052 |
| 28' (8534mm) | 246051 | 246050-05700 246050-14400 246050-02700 | 246052 |
| 29' (8839mm) | 246051 | 246050-06900 246050-14400 246050-02700 | 246052 |
| 30' (9144mm) | 246051 | 246050-08100 246050-14400 246050-02700 | 246052 |

Service Parts

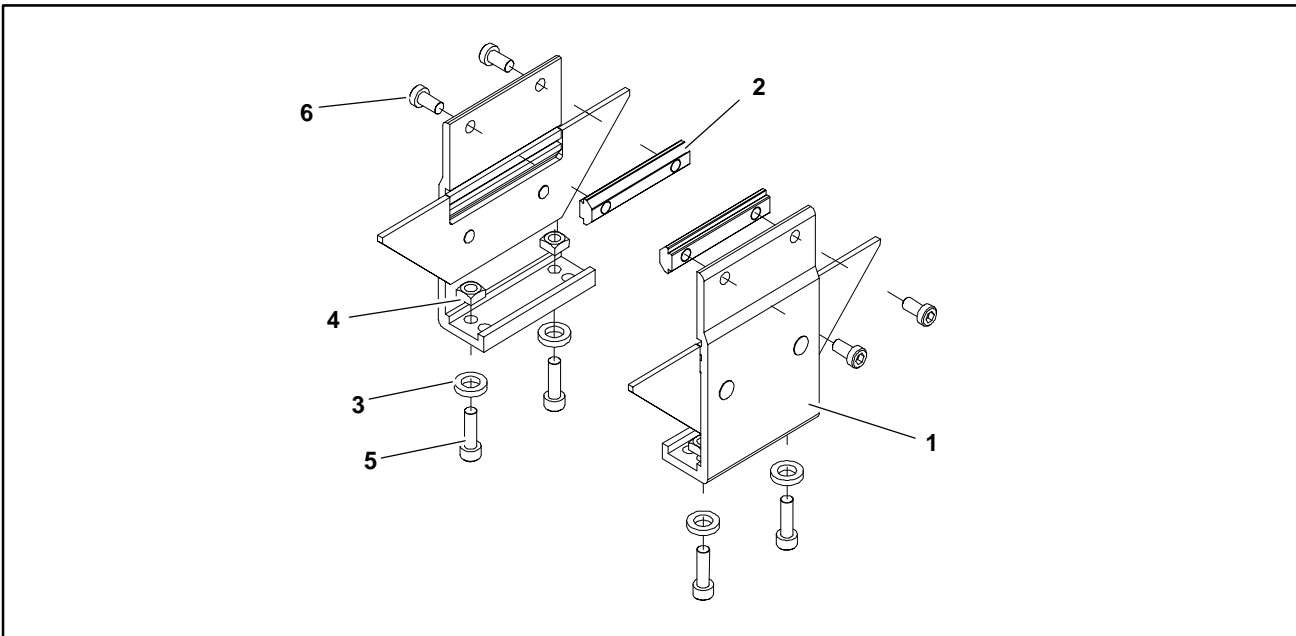
Flat Belt Mounting Brackets



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

| | | |
|---|---------|-----------------------------|
| 4 | 807-920 | Square Nut M6 5mm x 10mm |
| 5 | 920620M | Socket Head Screw M6 x 20mm |
| 6 | 920692M | Socket Head Screw M6 x 12mm |

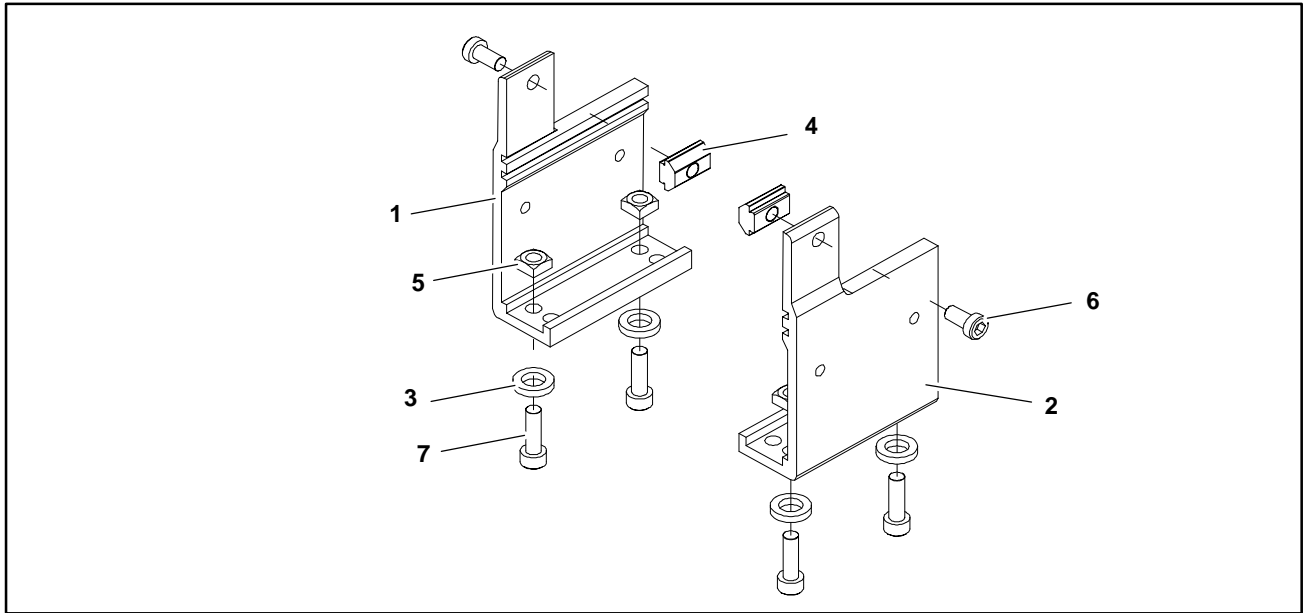
Cleated Belt Mounting Brackets



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

| | | |
|---|---------|-----------------------------|
| 4 | 807-920 | Square Nut M6 5mm x 10mm |
| 5 | 920620M | Socket Head Screw M6 x 20mm |
| 6 | 920692M | Socket Head Screw M6 x 12mm |

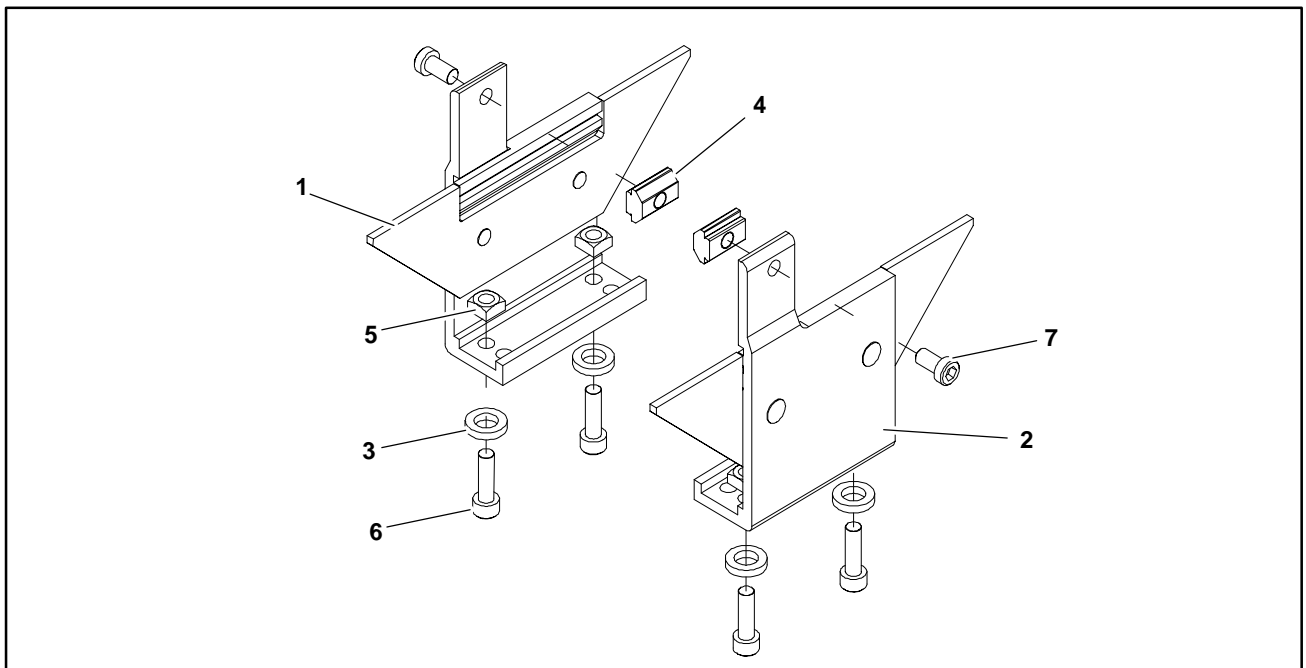
Flat Belt Mounting Brackets for 2' (610mm) Conveyors



| 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 5mm x 10mm |
| 6 | 920620M | Socket Head Screw M6 x 20mm |
| 7 | 920692M | Socket Head Screw M6 x 12mm |

Cleated Belt Mounting Brackets for 2' (610mm) Conveyors

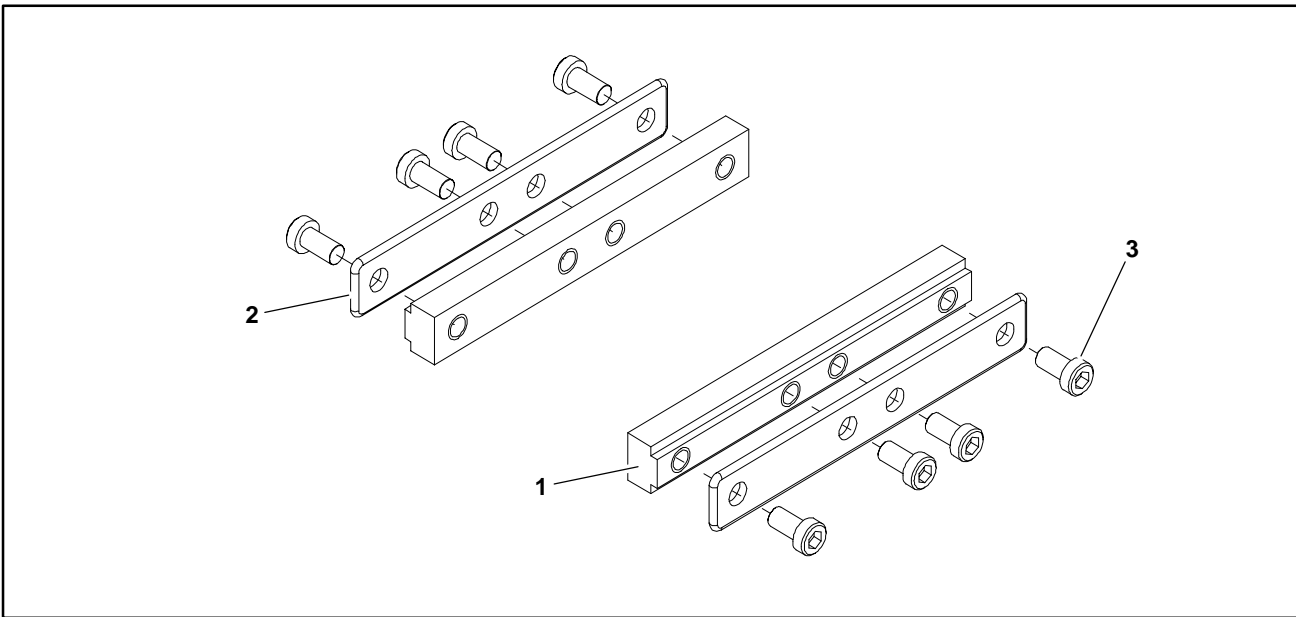


| Item | Part Number | Description |
|------|-------------|---|
| 1 | 240852 | Cleated Stand Bracket Assembly LH 2' (610mm) Conveyor |
| 2 | 240853 | Cleated Stand Bracket Assembly RH 2' (610mm) Conveyor |
| 3 | 605279P | Washer |

| | | |
|---|---------|-----------------------------|
| 4 | 639971M | Drop-In Tee Bar |
| 5 | 807-920 | Square Nut M6 5mm x 10mm |
| 6 | 920620M | Socket Head Screw M6 x 20mm |
| 7 | 920692M | Socket Head Screw M6 x 12mm |

Service Parts

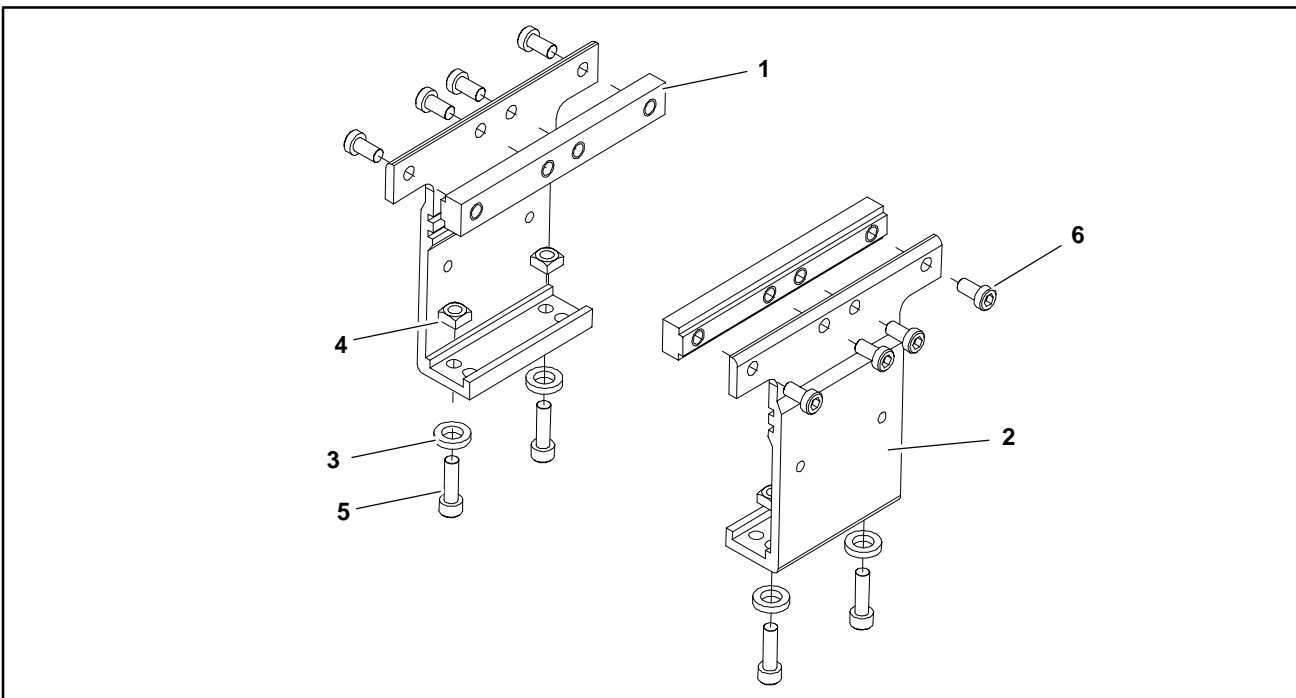
Connecting Assembly without Stand Mount



| Item | Part Number | Description |
|------|-------------|---------------------|
| 1 | 240331 | Frame Bar Connector |

| | | |
|---|---------|-----------------------------|
| 2 | 300153M | Intermediate Clamp Plate |
| 3 | 920692M | Socket Head Screw M6 x 12mm |

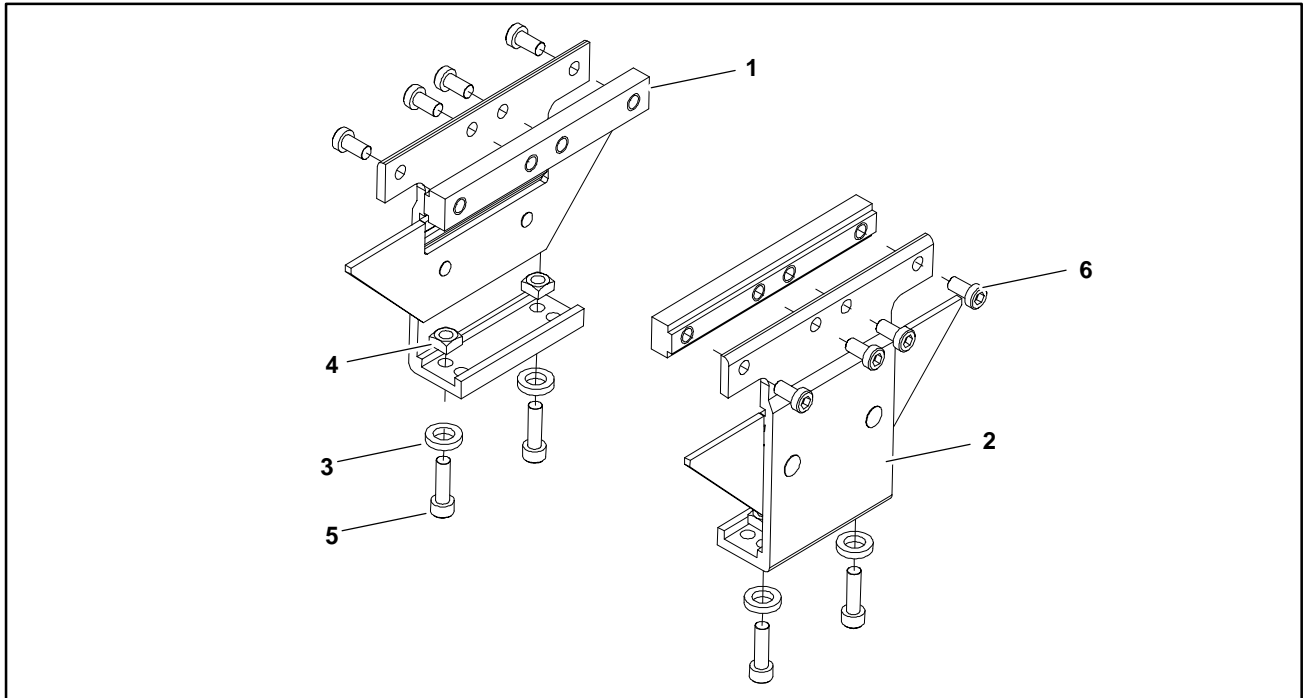
Flat Belt Connecting Assembly with Stand Mount



| Item | Part Number | Description |
|------|-------------|---------------------|
| 1 | 240331 | Frame Connector Bar |
| 2 | 240837 | Stand Mount Joint |
| 3 | 605279P | Washer |

| | | |
|---|---------|-----------------------------|
| 4 | 807-920 | Square Nut M6 5mm x 10mm |
| 5 | 920620M | Socket Head Screw M6 x 20mm |
| 6 | 920692M | Socket Head Screw M6 x 12mm |

Cleated Belt Connecting Assembly with Stand Mount



| Item | Part Number | Description |
|------|-------------|------------------------------|
| 1 | 240331 | Frame Connector Bar |
| 2 | 240846 | Cleat Stand Bracket Assembly |
| 3 | 605279P | Washer |

| | | |
|---|---------|-----------------------------|
| 4 | 807-920 | Square Nut M6 5mm x 10mm |
| 5 | 920620M | Socket Head Screw M6 x 20mm |
| 6 | 920692M | Socket Head Screw M6 x 12mm |

Service Parts

Conveyor Belting

A – Complete Conveyor Belt

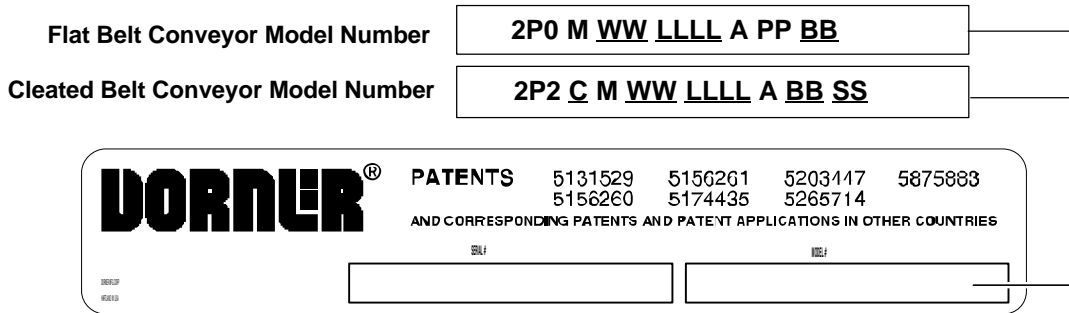
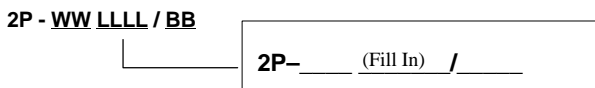


Figure 63

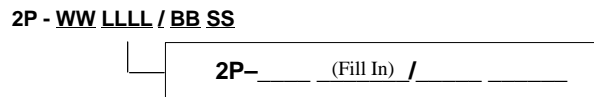
Flat Belt Part Number Configuration

Refer to Dorner patent plate (Figure 63). From the model number, determine conveyor width (“WW”), length (“LLLL”) and belt type (“BB”). Use data to configure belt part number as indicated below.



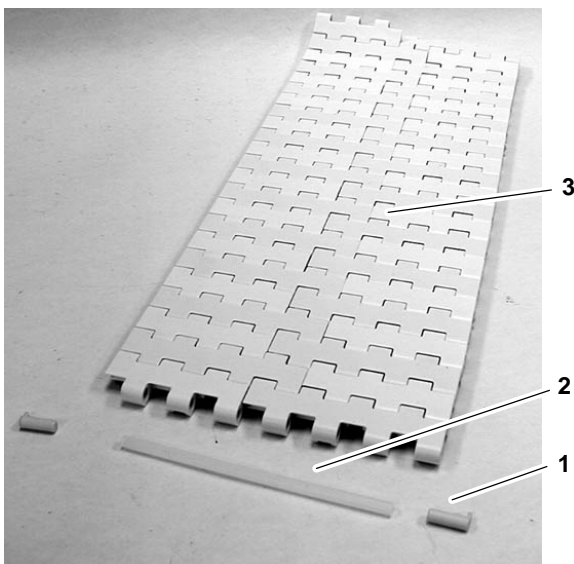
Cleated Belt Part Number Configuration

Refer to Dorner patent plate (Figure 63). From the model number, determine conveyor width (“WW”), length (“LLLL”), belt type (“BB”) and cleat spacing (“SS”). Use data to configure belt part number as indicated below.



B – Belting Per Foot (305mm)

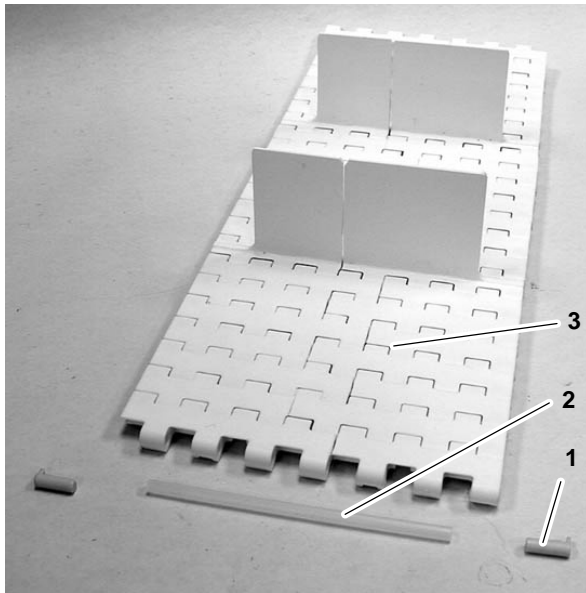
Flat Belts



| Item | Part Number | Description |
|------|-------------|--|
| 1 | 807-1118 | Retaining Pin |
| 2 | 807-1113 | 4" Belt Rod |
| | 807-1114 | 6" Belt Rod |
| | 807-1115 | 12" Belt Rod |
| | 807-1116 | 18" Belt Rod |
| | 807-1119 | 24" Belt Rod |
| 3 | 2P - WW/BB | Belting per 1ft (305mm) WW=Width: 04,06,12,18,24; BB=Belt Type (See Table Below) |

| Belt Type BB = | |
|----------------|-------------------------------------|
| 30 | Accumulation, Open Mesh |
| 31 | Chemical Resistant, Open Mesh |
| 32 | Heat Resistant, Open Mesh |
| 33 | ESD, Open Mesh (Class II Charges) |
| 40 | Accumulation, Closed Mesh |
| 41 | Chemical Resistant, Closed Mesh |
| 42 | Heat Resistant, Closed Mesh |
| 43 | ESD, Closed Mesh (Class II Charges) |

Cleated Belts

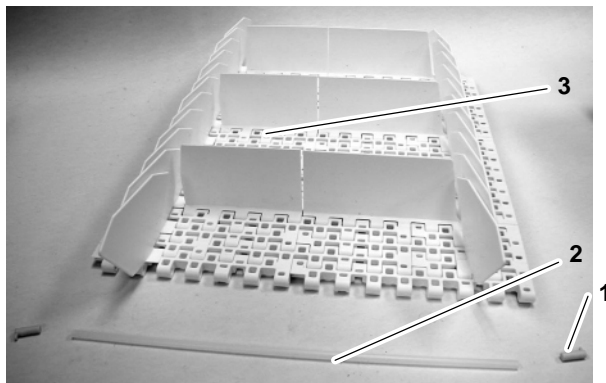


| Item | Part Number | Description |
|------|--------------|---|
| 1 | 807-1118 | Retaining Pin |
| 2 | 807-1113 | 4" Belt Rod |
| | 807-1114 | 6" Belt Rod |
| | 807-1115 | 12" Belt Rod |
| | 807-1116 | 18" Belt Rod |
| | 807-1119 | 24" Belt Rod |
| 3 | 2P - WW/BBSS | Belting per 1ft (305mm) WW=Width: 04,06,12,18,24; BB=Belt Type (See Table Below); SS=Cleat Spacing (Links) |

Belt Type BB =

| | |
|----|---------------------------------|
| 34 | General Purpose, Open Mesh |
| 35 | Chemical Resistant, Open Mesh |
| 36 | Heat Resistant, Open Mesh |
| 44 | General Purpose, Closed Mesh |
| 45 | Chemical Resistant, Closed Mesh |
| 46 | Heat Resistant, Closed Mesh |

Sidewall Cleated Belts



| Item | Part Number | Description |
|------|--------------|---|
| 1 | 807-1118 | Retaining Pin |
| 2 | 807-1113 | 4" Belt Rod |
| | 807-1114 | 6" Belt Rod |
| | 807-1115 | 12" Belt Rod |
| | 807-1116 | 18" Belt Rod |
| | 807-1119 | 24" Belt Rod |
| 3 | 2P - WW/BBSS | Belting per 1ft (305mm) WW=Width: 12,18,24; BB=Belt Type (See Table Below) SS=Cleat Spacing (links) |

Belt Type BB =

| | |
|----|---------------------------------|
| 37 | General Purpose, Open Mesh |
| 38 | Chemical Resistant, Open Mesh |
| 47 | General Purpose, Closed Mesh |
| 48 | Chemical Resistant, Closed Mesh |

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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