

7200 Series Sanitary 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>		

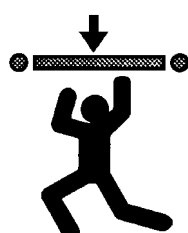

		WARNING
<p>Gearmotors may be HOT. DO NOT TOUCH Gearmotors.</p>		

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

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

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

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

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

Introduction

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

Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

Dorner 7200 Series conveyors are covered by Patent Nos. 5174435, 6109427 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
C	Belt (Flat Belt Shown)
D	Mounting Plates
E	Return Roller
F	Support Stands
G	Motor Controller
H	Drive End
I	Tensioning End

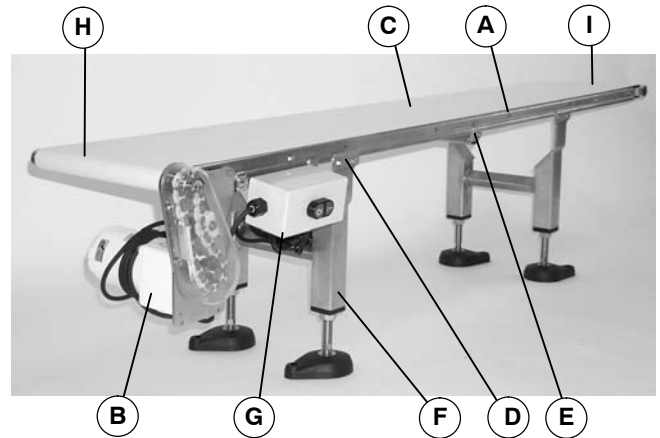


Figure 1

Specifications

Models:

Flat Belt 7200 Series Sanitary Conveyor

72	B	M	WW	LLLL	P	GG	BB	
								Belt Type*
								Conveyor Profile*
								Output Shaft Position*
								Conveyor Length Reference
								Conveyor Width Reference
								Document Language, M = USA English
								1 = No Wiper – with Mounting Brackets
								2 = No Wiper – without Mounting Brackets
								3 = End Wiper – with Mounting Brackets
								4 = End Wiper – without Mounting Brackets
								5 = Dual Wiper – with Mounting Brackets
								6 = Dual Wiper – without Mounting Brackets
								2 = Flat Belt End Drive Conveyor

Cleated Belt 7200 Series Sanitary Conveyor

7	D	B	M	WW	LLLL	P	SSSS	
								Cleat Spacing*
								Output Shaft Position*
								Conveyor Length Reference
								Conveyor Width Reference
								Document Language, M = USA English
								Cleat Type (A-J)*
								4 = Cleated Belt with Mounting Brackets
								5 = Cleated Belt without Mounting Brackets
								8 = Low Friction Cleated Belt with Mounting Brackets
								9 = Low Friction Cleated Belt without Mounting Brackets

* See “Ordering and Specifications” Catalog for details.

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 gearmotor.

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

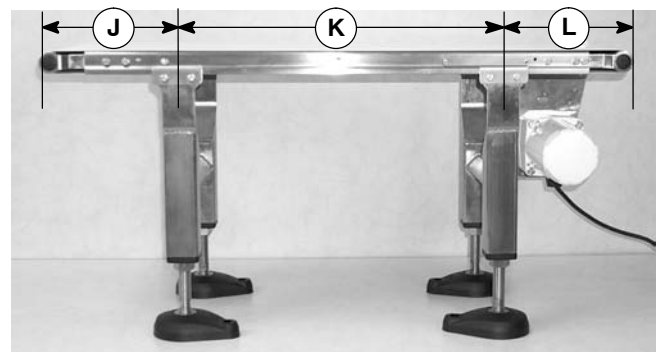


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18
Conveyor Belt Width	1.75" (44 mm)	2.75" (70 mm)	3.75" (95 mm)	5" (127 mm)	6" (152 mm)	8" (203 mm)	10" (254 mm)	12" (305 mm)	18" (457 mm)
Maximum Conveyor Load* (See NOTE Below)	30 lb (14 kg)	35 lb (16 kg)	42 lb (19 kg)	50 lb (23 kg)	60 lb (27 kg)	70 lb (32 kg)	80 lb (36 kg)	80 lb (36 kg)	80 lb (36 kg)
Conveyor Start-up Torque*	4 in-lb (0.5 Nm)	5 in-lb (0.6 Nm)	6 in-lb (0.7 Nm)	7 in-lb (0.8 Nm)	8 in-lb (0.9 Nm)	10 in-lb (1.1 Nm)	12 in-lb (1.4 Nm)	14 in-lb (1.5 Nm)	15 in-lb (1.7 Nm)
Belt Travel	4.3" (109 mm) per revolution of pulley								
Maximum Belt Speed*	235 feet/minute (72 meters/minute)								
Belt Take-up	0.38" (10 mm) of stroke = 0.75" (19 mm) of belt take-up								

Conveyor Length Reference (LL)	02	03	04	05	06	07	08	09	10	11	12	13**	14**	15**	16**	17**	18**
Conveyor Length	2-ft (610 mm)	3-ft (914 mm)	4-ft (1219 mm)	5-ft (1524 mm)	6-ft (1829 mm)	7-ft (2134 mm)	8-ft (2438 mm)	9-ft (2743 mm)	10-ft (3048 mm)	11-ft (3353 mm)	12-ft (3658 mm)	13-ft (3962 mm)**	14-ft (4267 mm)**	15-ft (4572 mm)**	16-ft (4877 mm)**	17-ft (5182 mm)**	18-ft (5486 mm)**

* See "Ordering and Specifications" Catalog for details.

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

NOTE: Maximum conveyor loads are based on:

- Non-accumulating product
- Product moving towards gearmotor
- Conveyor being mounted horizontal
- Conveyor being located in a dry environment
- Conveyor with standard belt only

Installation

NOTE: 7200 Series sanitary conveyors are shipped with a "belt travel direction" sticker (M of Figure 3) installed. After drive is installed and tested, remove sticker.

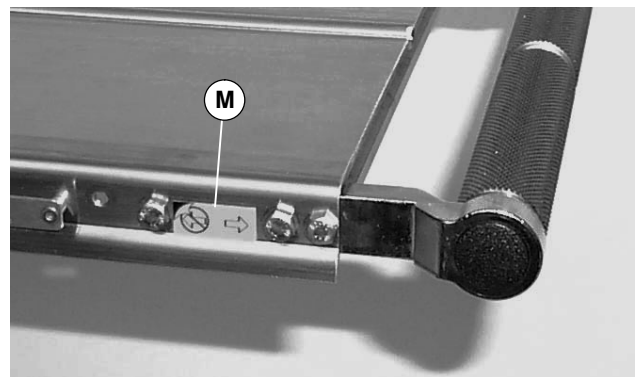


Figure 3

NOTE: Dorner recommends cleaning all the “food zones” prior to placing conveyor into service. Insure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.

NOTE: Conveyor **MUST** be mounted straight, flat, and level within confines of conveyor. Use a level (N of Figure 4) during setup.

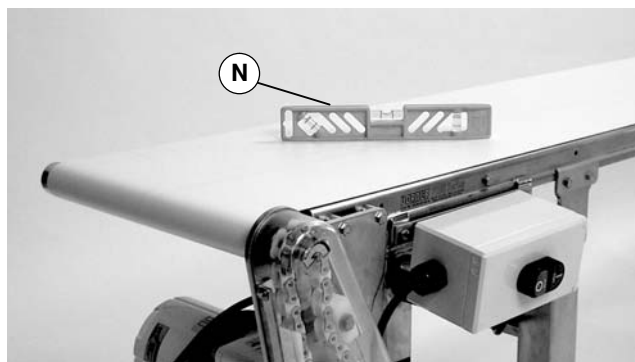


Figure 4

Required Tools

- 10 mm wrench (for hexagon head fasteners)
- Level
- Torque wrench

Recommended Installation Sequence

- Assemble conveyor (if required)
- Install stands (see accessory instructions)
- Attach stands/mounting brackets to conveyor (see page 6)
- Mount gearmotor mounting package (see accessory instructions)
- Attach return rollers (see page 7)
- Attach guides/accessories (see “Service Parts” section starting on page 16)

Conveyors Up to 12 ft (3658 mm)

No assembly is required. Install stands/mounting brackets and return rollers. Refer to “Attaching Conveyor to Stands or Mounting Brackets” on page 6 and “Return Rollers” on page 7.

Conveyors Longer Than 12 ft (3658 mm)

1. Typical components (Figure 5).

Frame Extension Components

- O Conveyor frame extension
- P M6 x 10 mm Hex Head Cap Screws (12x)
- Q Connector Strips (2x)
- R Conveyor frame

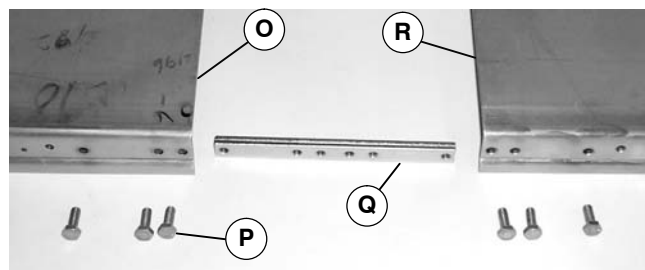


Figure 5

2. Compress tensioning end (Figure 6). Refer to steps 4 and 5 under the “Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands” on page 9.

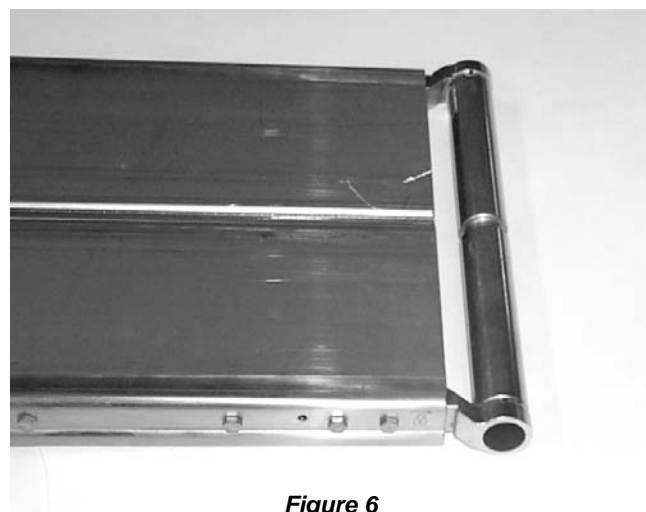


Figure 6

3. Install frame connecting bar (Q of Figure 7) on conveyor frame (R) with three screws (P). Do not tighten screws.

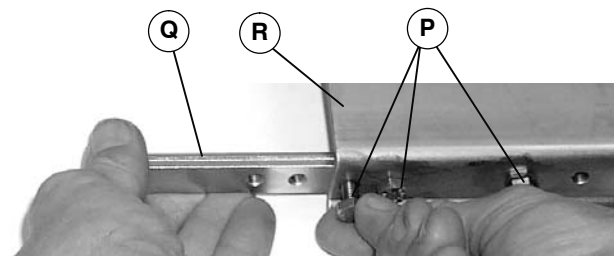


Figure 7

4. Repeat step 3 for other side of conveyor frame.

Installation

5. Install conveyor frame extension (O of Figure 8) on frame connecting bar (Q) with three screws (P). Install three screws (P) on opposite side. Tighten all screws to 92 in-lb (10.4 Nm).

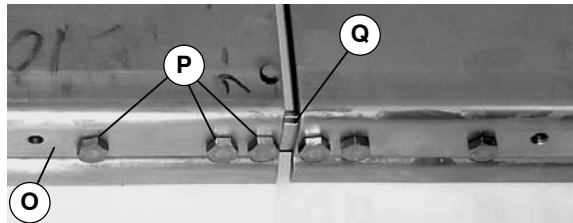


Figure 8

6. Install conveyor belt. Refer to steps 1 through 3 under “Belt Installation for Conveyor without Gear-motor Mounting Package or Stands” on page 11.
7. Tension conveyor belt. Refer to “Conveyor Belt Tensioning” on page 11.

Attaching Conveyor to Stands or Mounting Brackets

NOTE: Conveyor may be mounted using mounting brackets as shown in Figures 9 and 10 or directly to support stands. For direct support stand mounting, see stand manual.

1. Typical mounting bracket components (Figure 9).

Mounting Bracket Components (One Pair)

S	M6 x 10 mm Hex Head Cap Screw (4x)
T	M6 x 12 mm Hex Head Cap Screw (4x)
U	Stand/Conveyor Ear Mount Bracket (2x)
V	Clamp Plate, Flat Belt (2x)
	or
W	Clamp Plate, Cleated Belt (2x)

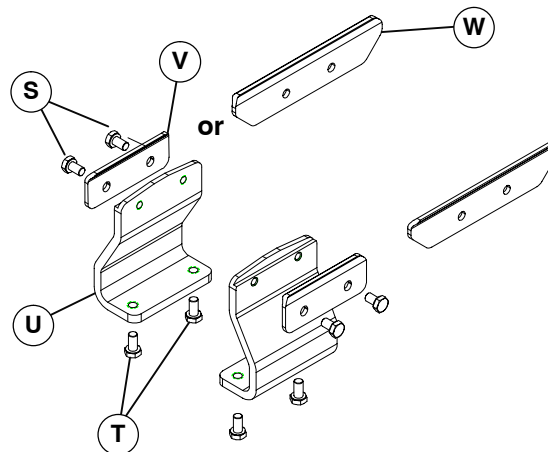


Figure 9

2. Attach clamp plate (V or W of Figure 9) to stand/conveyor ear mount bracket (U) with two screws (S). Do not tighten screws.
3. Attach stand/conveyor ear mount bracket (U of Figure 10) to bottom of conveyor (Z). Make sure notch (AA) on bracket straddles conveyor edge as shown. Snug-up two screws (S).

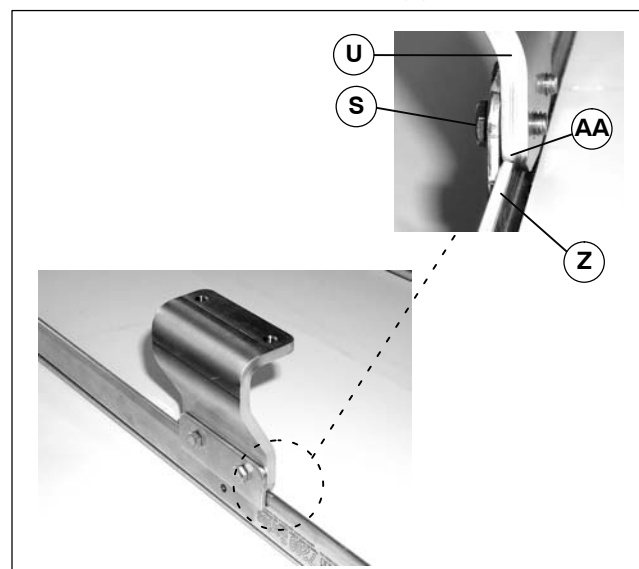


Figure 10

4. Repeat steps 2 and 3 for other mounting bracket(s). Tighten all screws (S) to 80 in-lb (9 Nm).

Return Rollers

2" to 6" (44 mm to 152 mm) Wide Conveyor

NOTE: No return rollers are required on conveyor lengths up to 7 ft (2134 mm). Use one pair of rollers centered between the tensioning and drive spindles on 8–15 ft (2438–4572 mm) conveyors. Use two pairs of rollers at one third distances between the tensioning and drive spindles on 16–18 ft (4877–5486 mm) conveyors.

1. Return roller components (Figure 11).

Return Roller Components	
AB	Mounting Block
AC	Clamp Plate
AD	Hex Head Cap Screw M6–1.0 x 12mm (2x)

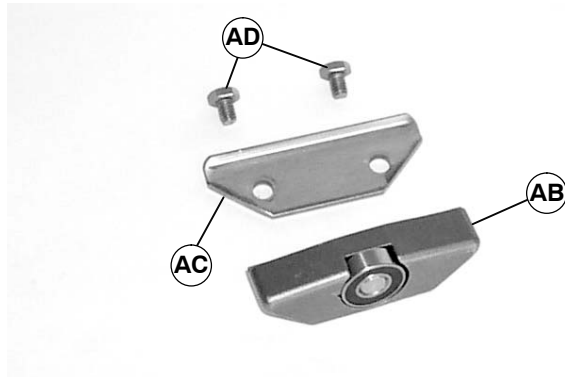


Figure 11

2. Loosely attach clamp plate (AC of Figure 12) on mounting block (AB) with two screws (AD). Do not tighten screws.

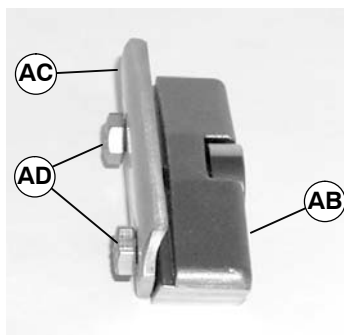


Figure 12

3. Attach return roller assembly (AE of Figure 13) on each side of conveyor (Z). Tighten screws (AD) to 80 in-lb (9 Nm).

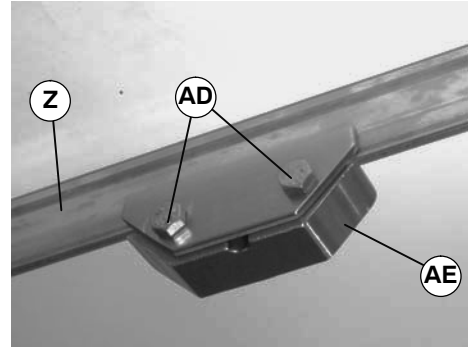


Figure 13

4. On 8–18 ft (2338–5486 mm) conveyor, repeat step 3 as necessary for other return rollers.

8" to 18" (203 mm to 457 mm) Wide Flat Belt Conveyors

NOTE: No return rollers are required on conveyor lengths up to 7 ft (2134 mm). Use one roller centered between the idler and drive spindles on 8–15 ft (2438–4572 mm) conveyors. Use two rollers at one third distances between the idler and drive spindles on 16–18 ft (4877–5486 mm) conveyors.

1. Typical return roller components (Figure 14)

Return Roller Components	
AF	Return Roller and Guard Assembly
AG	Return Roller Clamp Plate (2x)
AH	Hex Head Cap Screw M6–1.0 x 12mm (4x)

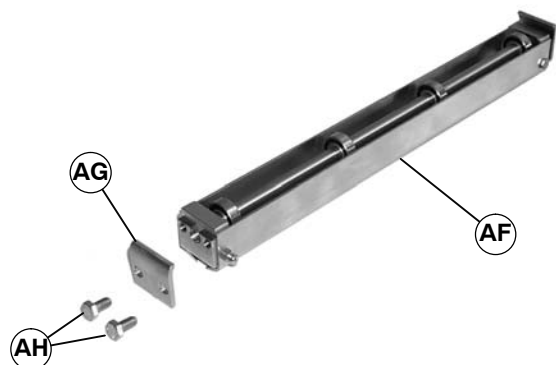


Figure 14

Installation

2. Loosely attach two clamp plates (AG of Figure 15) on roller and guard assembly (AF) with four screws (AH). Do not tighten screws.

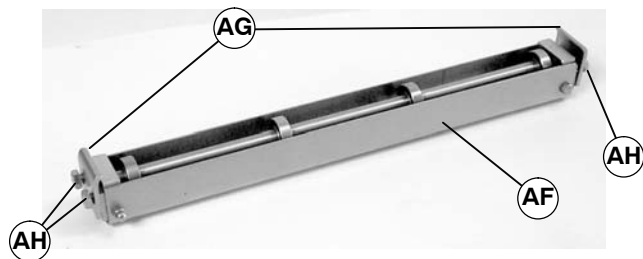


Figure 15

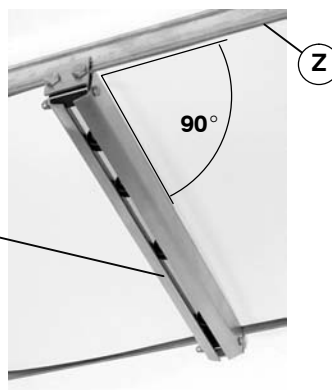


Figure 16

3. Attach return roller assembly (AI of Figure 16) on conveyor (Z). Make sure return roller assembly is perpendicular with conveyor frame as shown. Tighten screws (AH of Figure 15) to 80 in-lb (9 Nm).

4. On 16–18 ft (4877–5486 mm) conveyor, repeat step 3 for other return roller.

Preventive Maintenance and Adjustment

Required Tools

Standard Tools

- Wrenches: 8 mm, 10 mm, 3/8" (or an adjustable wrench)
- Small bearing puller
- Arbor press

Special Tools

- 456063 Bearing Removal Tool
- 456085 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 and knurled pulley while disassembled
- Replace worn or damaged parts

Lubrication

Conveyor Bearings

No lubrication is required. Replace bearings if worn.

Return Rollers

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 wiper(s)
- Accumulated dirt in wiper(s)
- 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.

Preventive Maintenance and Adjustment

Cleaning

NOTE: Dorner recommends cleaning all the “food zones” prior to placing conveyor into service. Insure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.

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 (see Table of Contents for page number)

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

A – Belt Removal for Conveyor Without Gearmotor Mounting Package or Stands

1. If installed, remove and retain two M5 hex head screws (AJ of Figure 17), bottom wiper (AK) and two sleeves (AL).

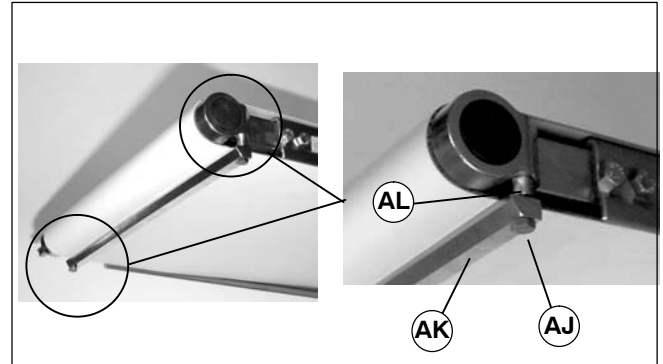


Figure 17

2. If installed, repeat step 1 for tension end wiper.
3. If conveyor is equipped with guiding and accessories or return rollers, remove and retain them as necessary.
4. Loosen four M6 hex head cap screws (AM of Figures 18 and 19).

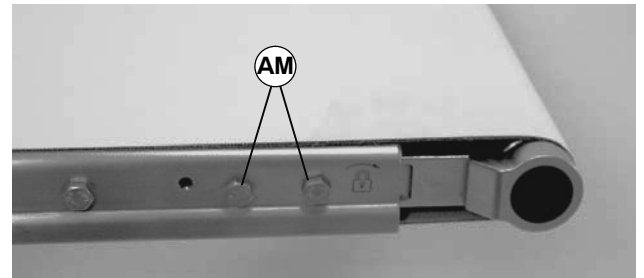


Figure 18

5. Retract idler spindle assembly (AN of Figure 19) by pushing in on it or by turning M6 hex head pinion screw (AO) clockwise.

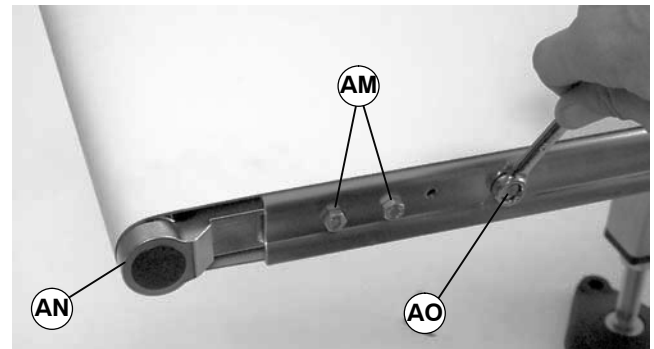


Figure 19

Preventive Maintenance and Adjustment

6. Remove conveyor belt (AP of Figure 20).



Figure 20

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

NOTE: For conveyor with a Heavy Load Bottom or Top Gearmotor Mounting Package, bracket (AR of Figure 21) must be removed.

- Remove two M6x30 mm hex head cap screws and spacers (AQ).
- Remove two M6x16 mm hex head cap screws (AS).
- Remove bracket (AR).

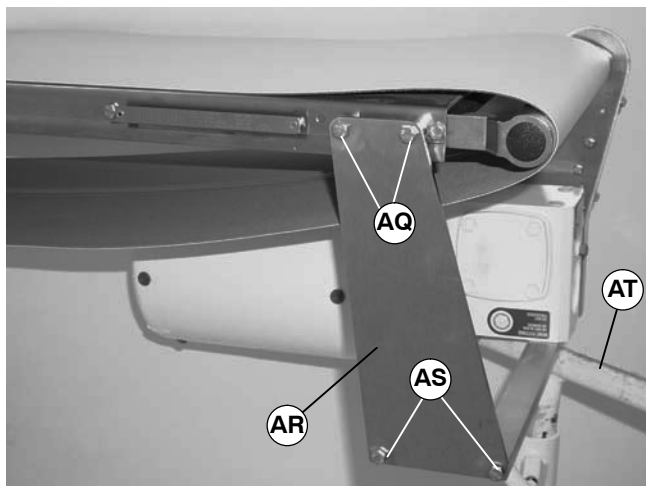




Figure 21

1. If installed, remove and retain two M5 hex head screws (AJ of Figure 17), bottom wiper (AK) and two sleeves (AL).
2. If installed, repeat step 1 for tension end wiper.
3. If conveyor is equipped with guiding and accessories or return rollers, remove and retain them as necessary.

4. Loosen four M6 x 20 mm hex head cap screws (AM of Figures 18 and 19).
5. Retract idler spindle assembly (AN of Figure 19) by pushing in on it or by turning M6 x 25 mm hex head pinion screw (AO of Figures 19 and 20) clockwise.

**WARNING**

The weight of the gearmotor is all on one end of the conveyor which could cause it to tip off the stands when the mounting clamp plates are loosened. Be sure to provide support (AT of Figures 21 and 22) underneath the gearmotor while changing the belt.

6. Place a temporary support (AT of Figures 21 and 22) under gearmotor mounting package.

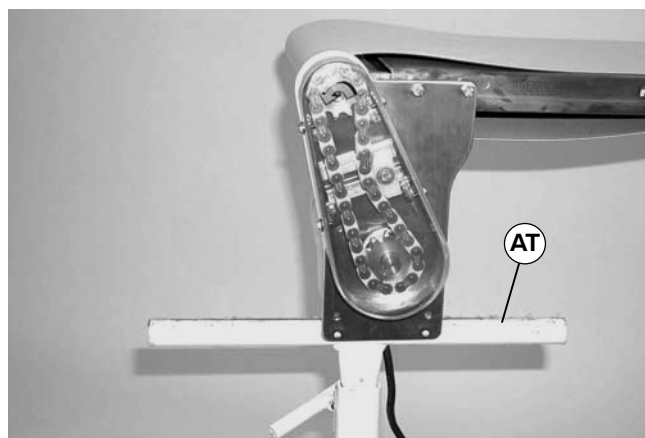


Figure 22

7. Loosen two clamp plate screws (S of Figure 23) on side of conveyor opposite drive motor.

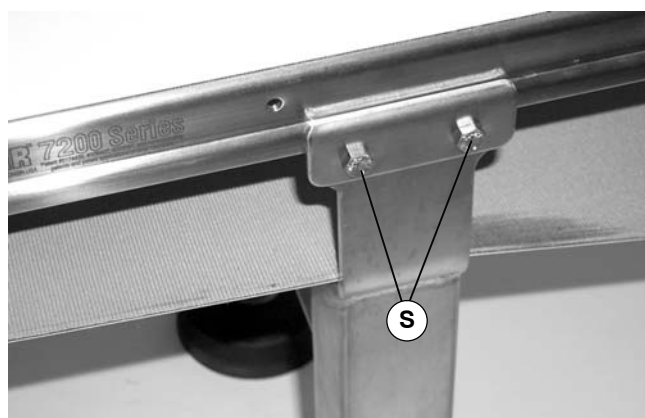


Figure 23

8. Repeat step 7 for remaining stand/conveyor ear mount brackets or stand assemblies on same side of conveyor.

Preventive Maintenance and Adjustment

9. Raise conveyor and remove conveyor belt (AP of Figure 24).



Figure 24

10. If a new belt will not be installed immediately, secure conveyor with stand/conveyor ear mount brackets or stand assemblies.

A – Belt Installation for Conveyor without Gearmotor Mounting Package or Stands

1. Orient conveyor belt so the splice leading fingers (AV of Figure 25) point in the direction of belt travel (AW) as identified by the label (AU of Figure 26).

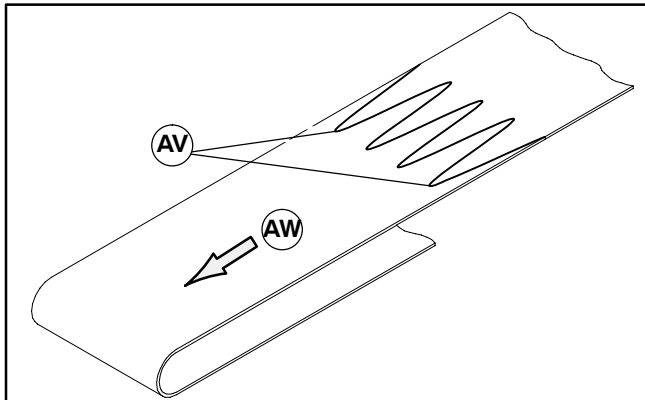


Figure 25

2. Slide belt (AP of Figure 20) onto the conveyor frame assembly.
3. If removed, install sleeves (AL of Figure 17), bottom wiper(s) (AK) and M5 hex head screws (AJ). Tighten screws to 33 in-lb (3.7 Nm).
4. Tension belt. Refer to “Conveyor Belt Tensioning” on page 11.
5. If removed, install return rollers, guiding and accessories.

B – Belt Installation for Conveyor with Gearmotor Mounting Package and/or Stands

IMPORTANT: On a flat belt conveyor, the wiper is installed on discharge end. Belt travel direction is identified by an arrow decal on the drive cover (AU of Figure 26).

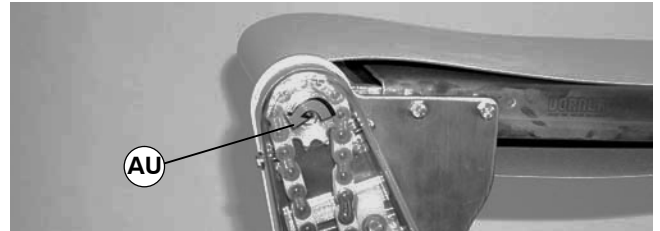




Figure 26

1. Orient conveyor belt so that the splice leading fingers (AV of Figure 25) point in the direction of belt travel (AW) as identified by the label (AU of Figure 26).
2. Slide belt (AP of Figure 24) onto conveyor frame assembly.
3. Tighten two clamp plate screws (S of Figure 23)
4. Repeat step 3 for remaining stand/conveyor ear mount brackets or stand assemblies.
5. If removed, install sleeves (AL of Figure 17), bottom wiper(s) (AK) and M5 hex head screws (AJ). Tighten screws to 33 in-lb (3.7 Nm).
6. For a conveyor with a Heavy Load Bottom or Top Mounting package, install bracket (AR of Figure 21).
7. Tension belt. Refer to “Conveyor Belt Tensioning” on page 11.
8. If removed, install return rollers, guiding and accessories.

Conveyor Belt Tensioning

	<div data-bbox="1133 1602 1515 1675"> WARNING</div> <div data-bbox="1133 1675 1515 1827"><p>Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.</p></div>
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Preventive Maintenance and Adjustment

1. On tension end of the conveyor, loosen two M6 hex head cap screws (AM of Figure 27) on each side of conveyor.

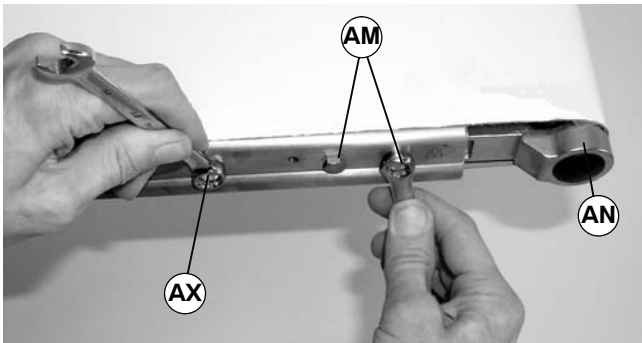


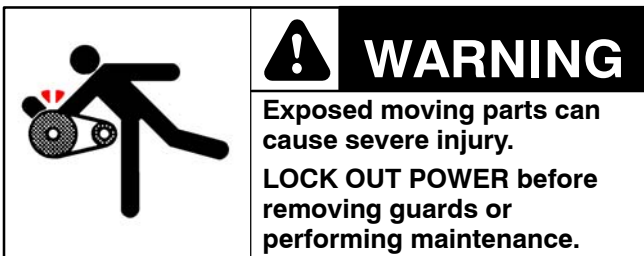
Figure 27

NOTE: Do not exceed a torque of 25 in-lb (2.8 Nm) for 2" through 12" (44 mm through 305 mm) wide conveyors or 40 in-lb (4.5 Nm) for an 18" (457 mm) wide conveyor on tensioning screw (AX). Over-tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

2. Extend idler spindle assembly (AN) by turning M6 hex head screw (AX) clockwise to sufficiently tension belt to handle conveyor load.
3. Tighten four M6 hex head screws (AM) to 40 in-lb (4.5 Nm) to secure idler spindle assembly (AN).

NOTE: If the maximum take-up stroke is achieved, replace the conveyor belt.

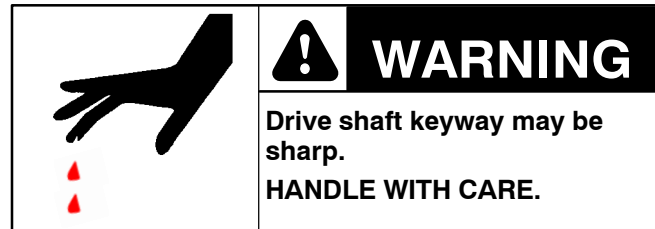
Pulley Removal



Remove conveyor belt to access pulley(s). See "Conveyor Belt Replacement" on page 9. Remove the desired pulley following instructions:

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

A – Drive Pulley Removal



1. Remove the gearmotor mounting package. See accessory instructions.

NOTE: Two screws (AY of Figure 28) were removed in step 1.

Cross support post (BC of Figure 30) will not be secure and may drop when screws (AZ of Figures 28 and 29) are removed.

2. Remove screw (AZ of Figures 28 and 29) from each side of conveyor.

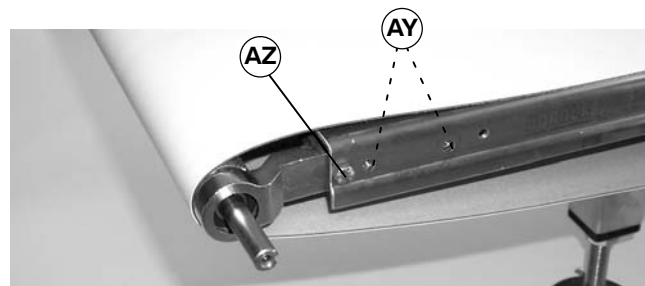


Figure 28

NOTE: For a conveyor with a Heavy Load Bottom or Top Gearmotor Mounting Package, the two screws (BA of Figure 29) were removed in step 1.

Drive spindle assembly (BB of Figure 29) will not be secure and may drop when screws (AZ and BA of Figures 28 and 29) are removed.

3. Remove two screws (BA of Figure 29) from side of conveyor opposite drive shaft.

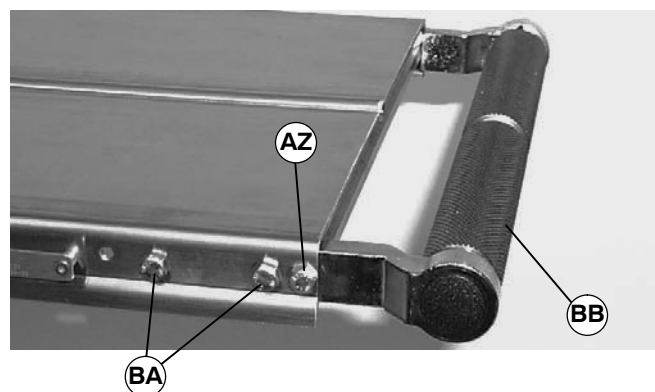


Figure 29

Preventive Maintenance and Adjustment

4. Remove drive spindle assembly (BB).
5. Remove cross support post (BC of Figure 30).
6. Remove two head plates (BD).
7. Remove drive pulley and bearing assembly (BE).

NOTE: If bearings require removal from drive pulley, see "Bearing Removal" on page 14.

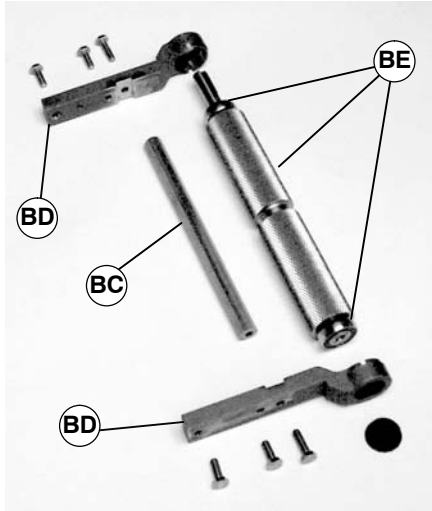


Figure 30

B – Idler Pulley Removal

1. While holding hex pinion (BF of Figure 31) with a 3/8" open-end wrench, loosen M6 hex head cap screw (AO).

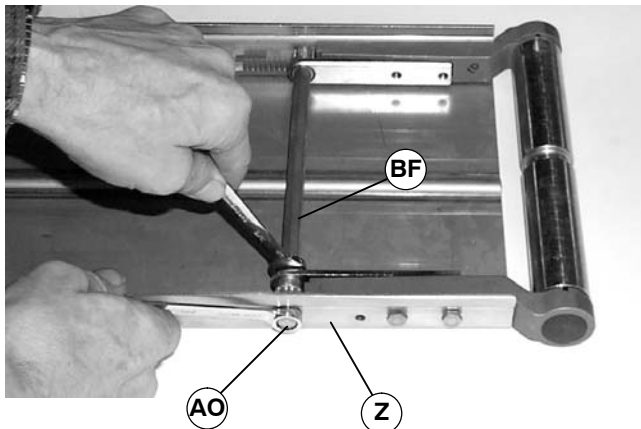


Figure 31

2. Remove M6 hex head cap screw (AO of Figure 32) and sleeve (BG) from conveyor (Z) and hex pinion (BF).

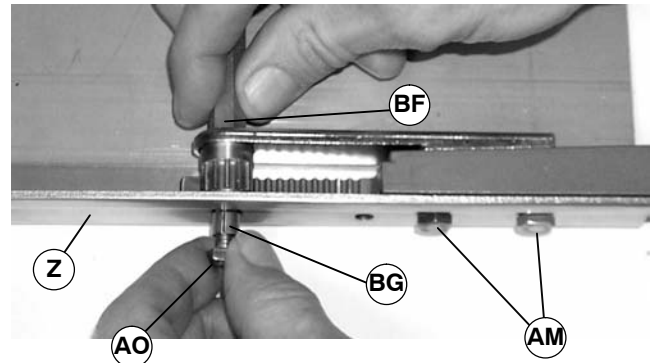


Figure 32

3. Repeat steps 1 and 2 for screw (AX of Figures 27 and 33) on opposite side of conveyor.
4. Remove two M6 hex head cap screws (AM) from each side of conveyor.
5. Remove two pinion ends (BH of Figure 33), clamp blocks (BI), hex pinion (BF), two spacers (BJ) and tail assembly (AN) from conveyor (Z).

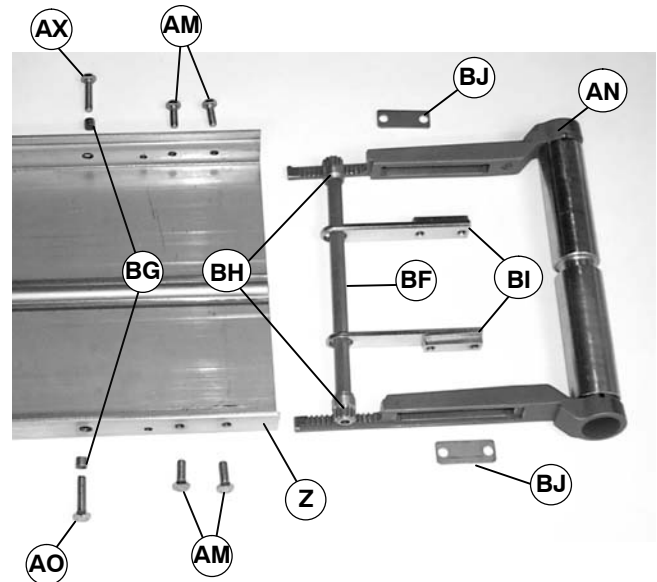


Figure 33

6. Remove two head plates (BK of Figure 34) from spindle and bearing assembly (BL).

Preventive Maintenance and Adjustment

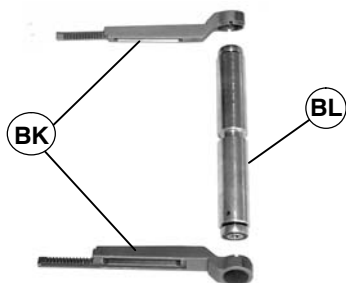


Figure 34

Bearing Replacement for Drive or Idler Pulley

IMPORTANT: Once removed, do not re-use bearings.

Bearing Removal

1. Place bearing removal tool (BM of Figure 35) (part # 456063) below bearing (BN) with lip (BO) located in gap (BP) between bearing and spindle hub (BQ) as shown.

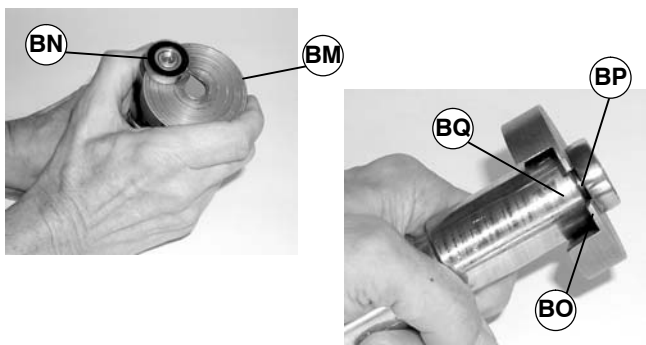


Figure 35

2. Using a puller (BR of Figure 36), remove and discard bearing.

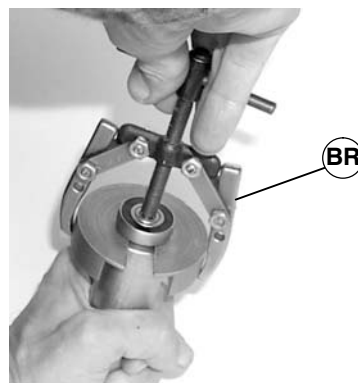


Figure 36

Bearing Installation

1. Inspect bearing seating surface(s) for damage. Replace spindle if damaged.
2. Slide bearing (part # 240338) (BN of Figure 37) onto spindle (BQ).

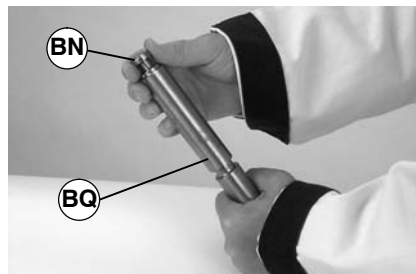


Figure 37

3. Slide sleeve (BU of Figure 38) of tool (part # 456085) over bearing.

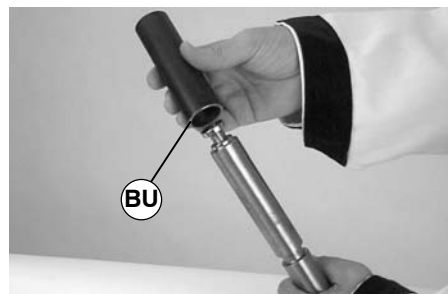


Figure 38

4. Place open end of pusher (BV of Figure 39) into sleeve.

Preventive Maintenance and Adjustment



Figure 39

5. Using an arbor press or similar device, press bearing onto pulley shaft (see Figure 40).



Figure 40

6. Repeat steps 1 through 5 for each bearing.

Pulley Installation

A – Drive Pulley Installation

1. Reverse the removal procedure “A” (see page 12).

B – Idler Pulley Installation

IMPORTANT: Loosely install two spacers (BJ of Figures 33 and 41) and four screws (AM) prior to installing idler tail assembly (AN) on conveyor.

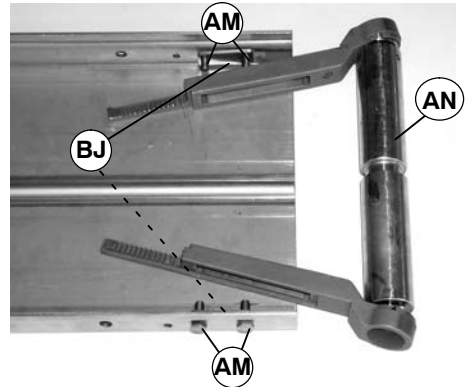


Figure 41

IMPORTANT: During idler pulley installation, orient both pinion ends (BH of Figure 42) so they engage the same tooth positions on their respective racks.

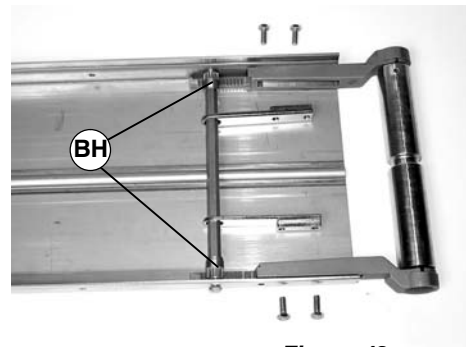


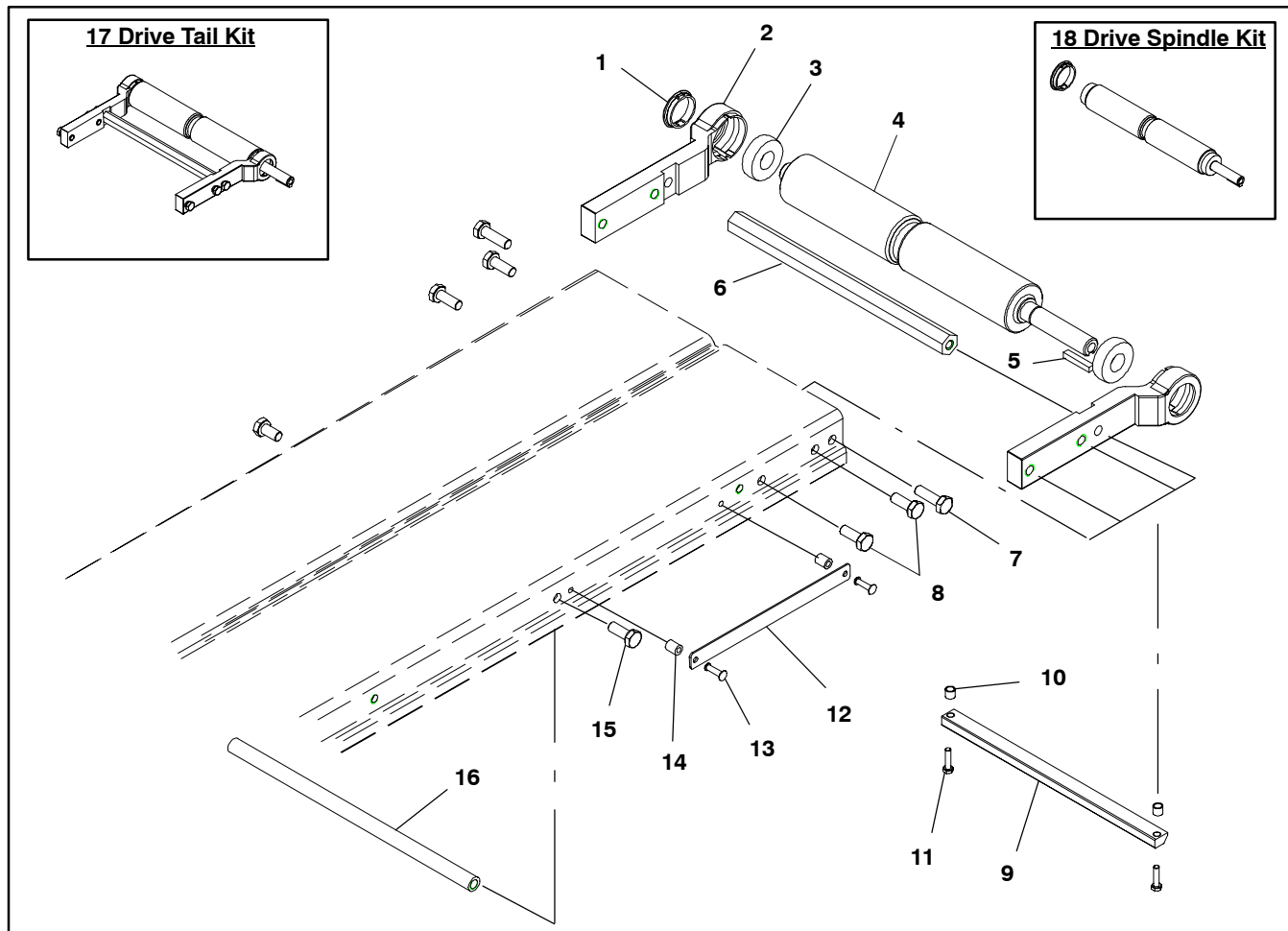
Figure 42

1. Reverse the removal procedure “B” (see page 12).

Service Parts

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

Drive End Components

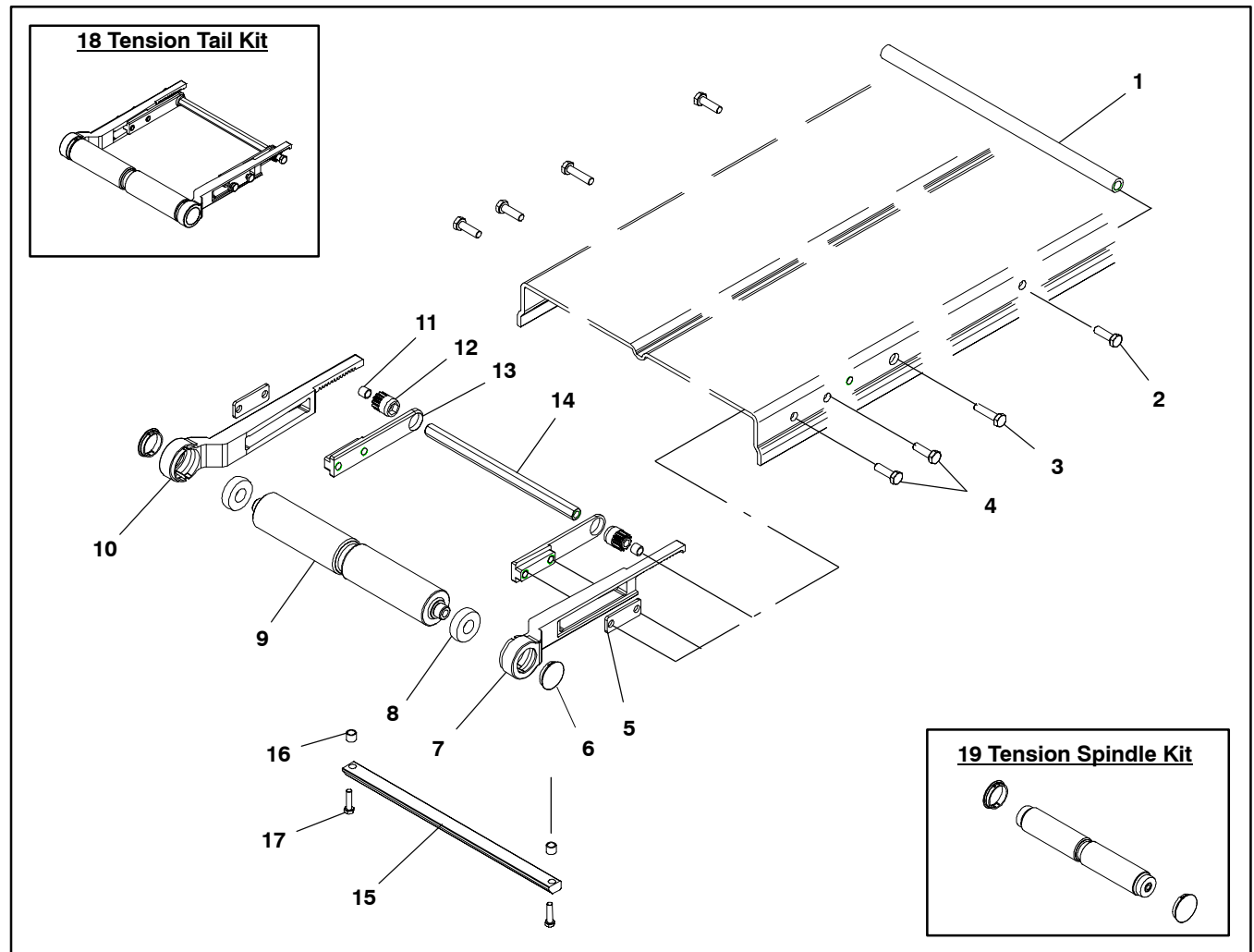


Item	Part Number	Description
1	807-1263	Plastic Hole Plug
2	456005	Head Plate Fixed w/o Wiper
	450646	Head Plate Fixed w/Wiper LH
	450647	Head Plate Fixed w/Wiper RH
3	240338	Bearing Spherical OD
4	4564WW	Drive Spindle
5	980422MSS	Square Key 4mm x 22mm
6	4588WW	Cross Support Post
7	960620MSS	Hex Head Cap Screw M6-1.0x20mm
8	960616MSS	Hex Head Cap Screw M6-1.0x16mm
9	4557WW	Washdown Wiper
10	456049	Sleeve
11	960520MSS	Hex Head Cap Screw M5-0.80 x 20mm

12	456034	Name Tag
13	914-008	Rivet
14	807-1301	Spacer
15	960612MSS	Hex Head Cap Screw M6-1.0x12mm
16	4525WWMSS	Frame Support Post
17	72DT-WWW	Drive Tail Kit w/o Wiper (Includes Items 1 through 8)
	72DTWA-WWW	Drive Tail Kit w/Wiper - Shaft Position A or B (Includes Items 1 through 11)
	72DTWD-WWW	Drive Tail Kit w/Wiper - Shaft Position C or D (Includes Items 1 through 11)
18	72DS-WWW	Drive Spindle Kit (Includes Items 1, 3, 4 and 5)

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

Tension End Components



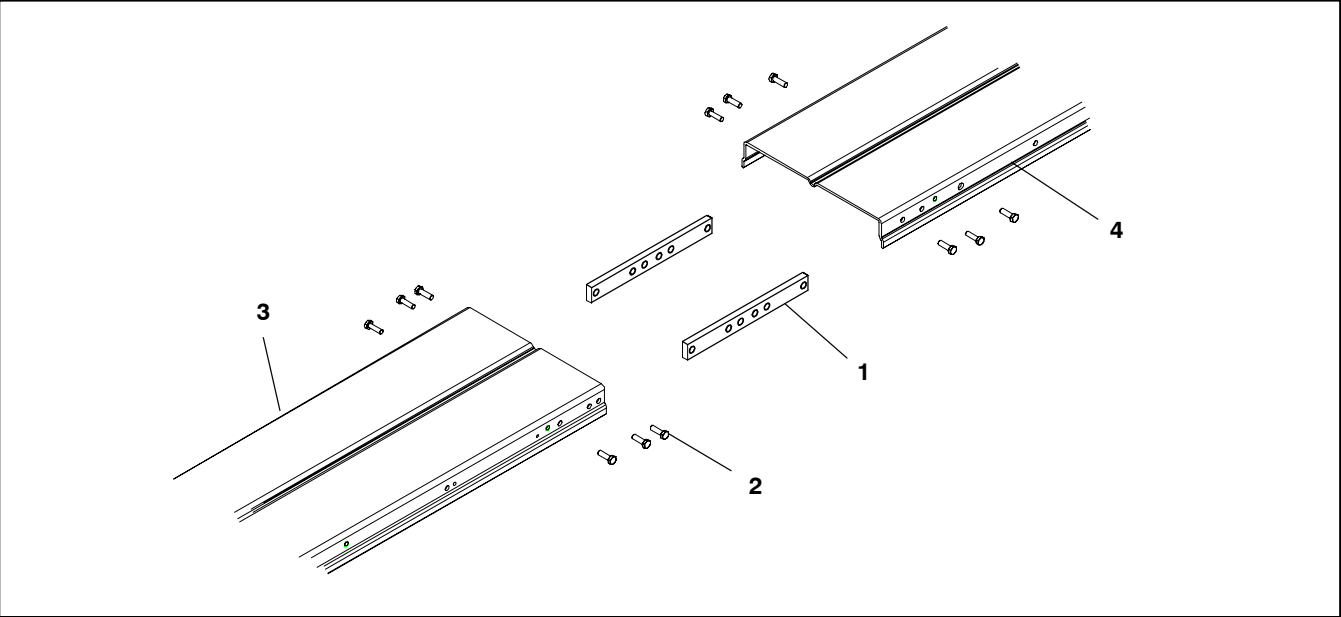
Item	Part Number	Description
1	4525WWSS	Frame Support Post
2	960612MSS	Hex Head Cap Screw M6-1.0x12mm
3	960625MSS	Hex Head Cap Screw M6-1.0x25mm
4	960620MSS	Hex Head Cap Screw M6-1.0x20mm
5	456064	Head Plate Spacer
6	807-1263	Plastic Hole Plug
7	456011	Head Plate Tension RH w/o Wiper
	450645	Head Plate Tension RH w/Wiper
8	240338	Bearing Spherical OD
9	4561WW	Idler Spindle
10	456002	Head Plate TensionLH w/o Wiper
	450644	Head Plate Tension LH w/Wiper

11	456049	Sleeve .312 OD x .035 Wall
12	456045	Pinion End
13	456041	Clamp Block
14	4563WW	Hex Pinion
15	4557WW	Washdown Wiper
16	456049	Sleeve
17	960520MSS	Hex Head Cap Screw M5-0.80 x 20mm
18	72TT-WW	Tension Tail Kit w/o Wiper (Includes Items 3 through 14)
	72TTW-WW	Tension Tail Kit w/Wiper (Includes Items 3 through 17)
19	72TS-WW	Tension Spindle Kit (Includes Items 6, 8 and 9)

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

Service Parts

Conveyor Frame and Extension



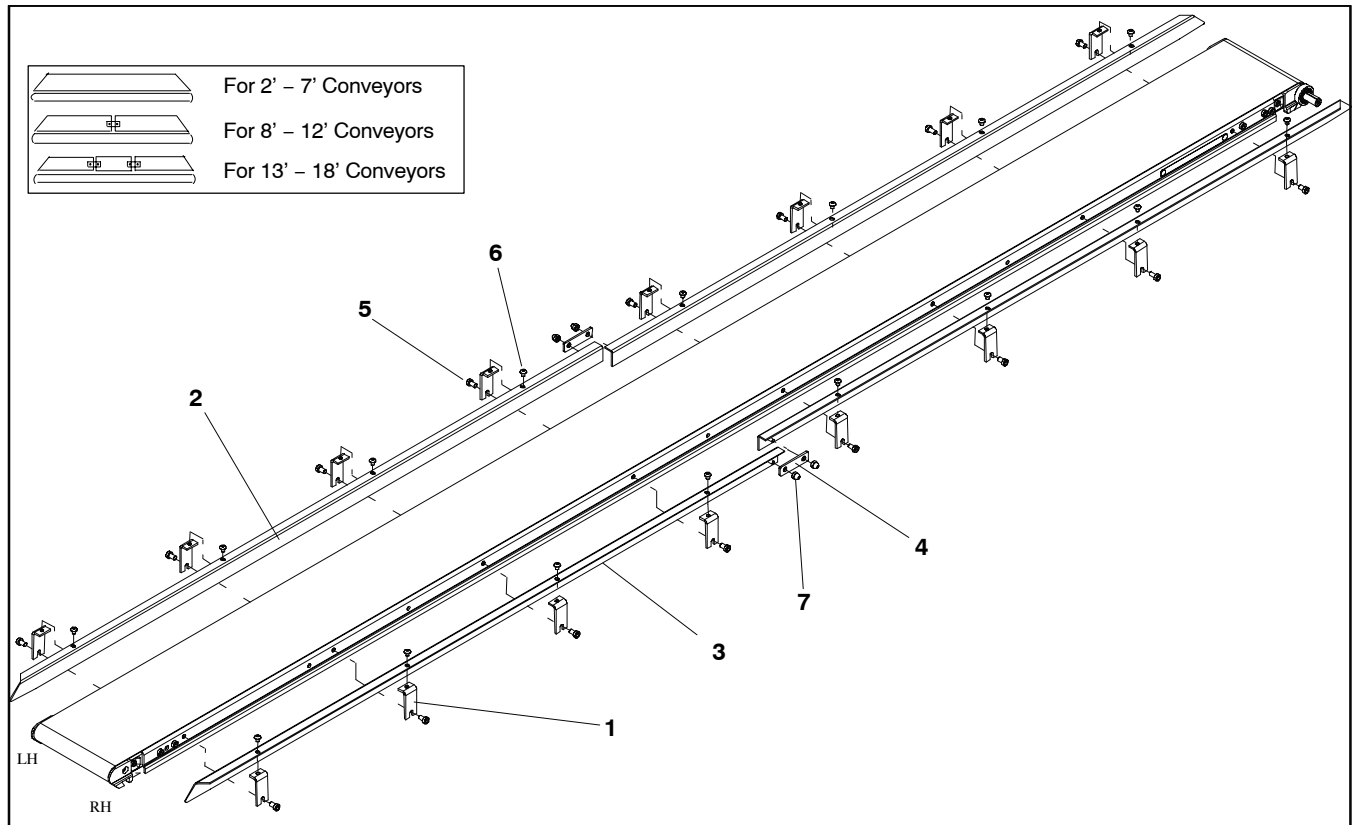
Item	Part Number	Description
1	456046	Frame Connecting Bar
2	960610MSS	Hex Head Cap Screw M6-1.0x10mm

3	See Conveyor Frame chart	Conveyor Frame
4	See Conveyor Frame chart	Conveyor Frame Extension

Items 3 and 4: Conveyor Frame		
Length	Frame Part Number	Frame Extension Part Number
2' (610mm)	4730WW-01860	n/a
3' (914mm)	4730WW-03060	n/a
4' (1219mm)	4730WW-04260	n/a
5' (1524mm)	4730WW-05460	n/a
6' (1829mm)	4730WW-06660	n/a
7' (2134mm)	4730WW-07860	n/a
8' (2438mm)	4730WW-09060	n/a

9' (2743mm)	4730WW-10260	n/a
10' (3048mm)	4730WW-11460	n/a
11' (3353mm)	4730WW-12660	n/a
12' (3658mm)	4730WW-13860	n/a
13' (3962mm)	4730WW-07860	4750WW
14' (4267mm)	4730WW-09060	4750WW
15' (4572mm)	4730WW-10260	4750WW
16' (4877mm)	4730WW-11460	4750WW
17' (5182mm)	4730WW-12660	4750WW
18' (5486mm)	4730WW-13860	4750WW

-21 1" (25mm) Sanitary Bolt-On High Sides



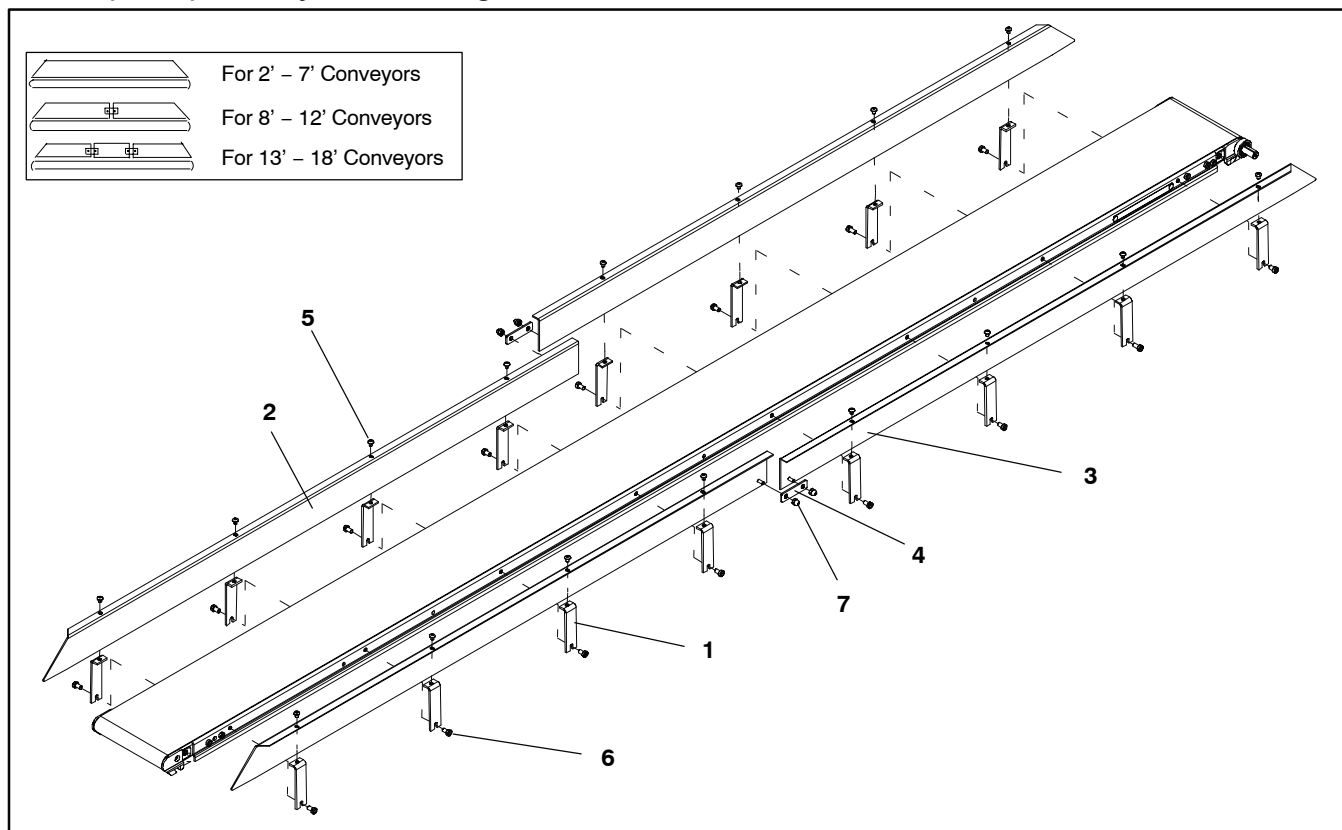
Item	Part Number	Description
1	462150MSS	1" Guide Mounting Bracket
2	See chart below	1" Guide LH
3	See chart below	1" Guide RH
4	450188SS	Guide Tie Plate
5	960608MSS	M6-1.0 x 8mm Hex Head Screw
6	960506MSS	M5-0.8 x 6mm Hex Head Screw
7	990508MSS	M5 Acorn Nut

Conveyor Length		Tail End Guide	Center Guide	Drive End Guide
2' (610mm)	Right Hand	462132SSP	N/A	N/A
	Left Hand	462132SSP	N/A	N/A
3' (914mm)	Right Hand	462133SSP	N/A	N/A
	Left Hand	462133SSP	N/A	N/A
4' (1219mm)	Right Hand	462134SSP	N/A	N/A
	Left Hand	462134SSP	N/A	N/A
5' (1524mm)	Right Hand	462135SSP	N/A	N/A
	Left Hand	462135SSP	N/A	N/A
6' (1829mm)	Right Hand	462136SSP	N/A	N/A
	Left Hand	462136SSP	N/A	N/A
7' (2134mm)	Right Hand	462137SSP	N/A	N/A
	Left Hand	462137SSP	N/A	N/A

8' (2438mm)	Right Hand	462154SSP	N/A	462144SSP
	Left Hand	462144SSP	N/A	462154SSP
9' (2743mm)	Right Hand	462155SSP	N/A	462144SSP
	Left Hand	462145SSP	N/A	462154SSP
10' (3048mm)	Right Hand	462155SSP	N/A	462145SSP
	Left Hand	462145SSP	N/A	462155SSP
11' (3353mm)	Right Hand	462156SSP	N/A	462145SSP
	Left Hand	462146SSP	N/A	462155SSP
12' (3658mm)	Right Hand	462156SSP	N/A	462146SSP
	Left Hand	462146SSP	N/A	462156SSP
13' (3962mm)	Right Hand	462156SSP	462163SSP	462144SSP
	Left Hand	462146SSP	462163SSP	462154SSP
14' (4267mm)	Right Hand	462156SSP	462163SSP	462145SSP
	Left Hand	462146SSP	462163SSP	462155SSP
15' (4572mm)	Right Hand	462156SSP	462163SSP	462146SSP
	Left Hand	462146SSP	462163SSP	462156SSP
16' (4877mm)	Right Hand	462156SSP	462166SSP	462144SSP
	Left Hand	462146SSP	462166SSP	462154SSP
17' (5182mm)	Right Hand	462156SSP	462166SSP	462145SSP
	Left Hand	462146SSP	462166SSP	462155SSP
18' (5486mm)	Right Hand	462156SSP	462166SSP	462146SSP
	Left Hand	462146SSP	462166SSP	462156SSP

Service Parts

-22 2" (51mm) Sanitary Bolt – On High Sides

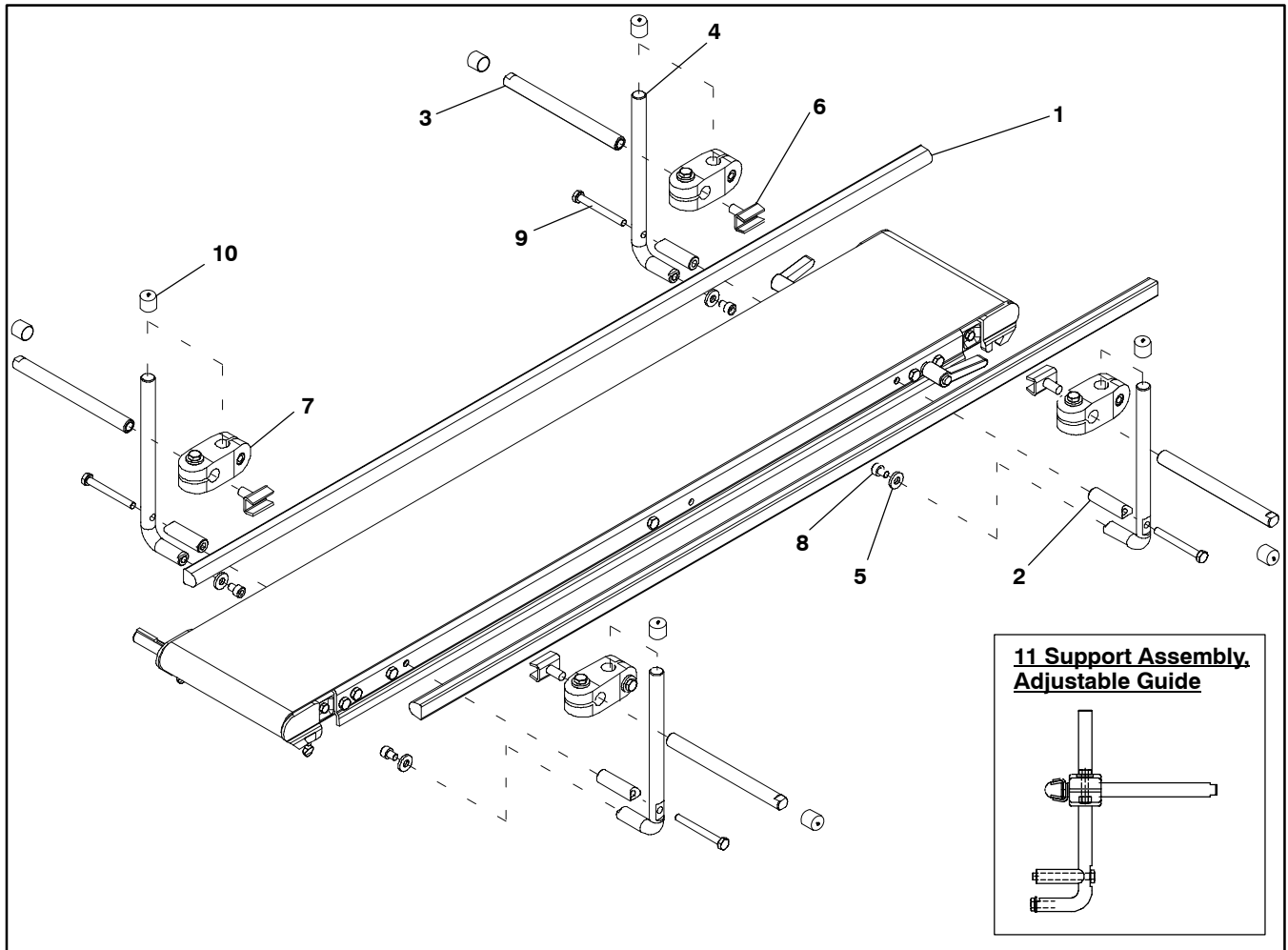


Item	Part Number	Description
1	462250MSS	2" Guide Mounting Bracket
2	See chart below	2" Guide LH
3	See chart below	2" Guide RH
4	450188SS	Guide Tie Plate
5	960608MSS	M6-1.0 x 10mm Hex Head Screw
6	960506MSS	M5-0.8 x 6mm Hex Head Screw
7	990508MSS	M5 Acorn Nut

Conveyor Length		End Guide	Center Guide	End Guide
2' (610mm)	Right Hand	462232SSP	N/A	N/A
	Left Hand	462232SSP	N/A	N/A
3' (914mm)	Right Hand	462233SSP	N/A	N/A
	Left Hand	462233SSP	N/A	N/A
4' (1219mm)	Right Hand	462234SSP	N/A	N/A
	Left Hand	462234SSP	N/A	N/A
5' (1524mm)	Right Hand	462235SSP	N/A	N/A
	Left Hand	462235SSP	N/A	N/A
6' (1829mm)	Right Hand	462236SSP	N/A	N/A
	Left Hand	462236SSP	N/A	N/A
7' (2134mm)	Right Hand	462237SSP	N/A	N/A
	Left Hand	462237SSP	N/A	N/A

8' (2438mm)	Right Hand	462254SSP	N/A	462244SSP
	Left Hand	462244SSP	N/A	462254SSP
9' (2743mm)	Right Hand	462255SSP	N/A	462244SSP
	Left Hand	462245SSP	N/A	462254SSP
10' (3048mm)	Right Hand	462255SSP	N/A	462245SSP
	Left Hand	462245SSP	N/A	462255SSP
11' (3353mm)	Right Hand	462256SSP	N/A	462245SSP
	Left Hand	462246SSP	N/A	462255SSP
12' (3658mm)	Right Hand	462256SSP	N/A	462246SSP
	Left Hand	462246SSP	N/A	462256SSP
13' (3962mm)	Right Hand	462256SSP	462263SSP	462244SSP
	Left Hand	462246SSP	462263SSP	462254SSP
14' (4267mm)	Right Hand	462256SSP	462263SSP	462245SSP
	Left Hand	462246SSP	462263SSP	462255SSP
15' (4572mm)	Right Hand	462256SSP	462263SSP	462246SSP
	Left Hand	462246SSP	462263SSP	462256SSP
16' (4877mm)	Right Hand	462256SSP	462266SSP	462244SSP
	Left Hand	462246SSP	462266SSP	462254SSP
17' (5182mm)	Right Hand	462256SSP	462266SSP	462245SSP
	Left Hand	462246SSP	462266SSP	462255SSP
18' (5486mm)	Right Hand	462256SSP	462266SSP	462246SSP
	Left Hand	462246SSP	462266SSP	462256SSP

-23 Sanitary Fully Adjustable UHMW Guide

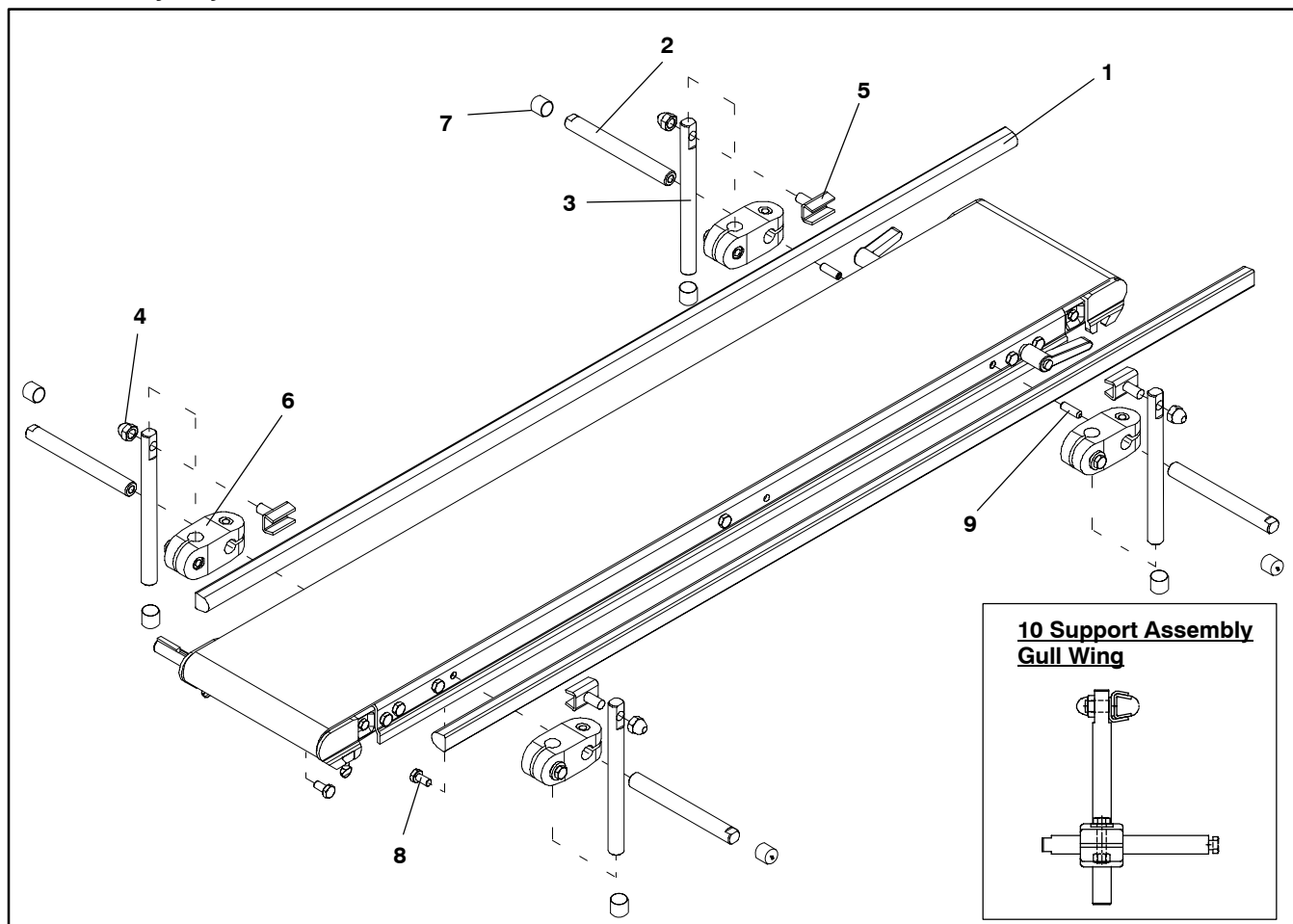


Item	Part Number(s)	Description
1	462332	Guide Mounting Rail 2' (610mm)
	462333	Guide Mounting Rail 3' (914mm)
	462334	Guide Mounting Rail 4' (1219mm)
	462335	Guide Mounting Rail 5' (1524mm)
	462336	Guide Mounting Rail 6' (1829mm)
	462337	Guide Mounting Rail 7' (2134mm)
	462338	Guide Mounting Rail 8' (2438mm)
	462339	Guide Mounting Rail 9' (2743mm)
	462340	Guide Mounting Rail 10' (3053mm)
	462341	Guide Mounting Rail 11' (3353mm)
	462342	Guide Mounting Rail 12' (3658mm)
	462337 462336	Guide Mounting Rail 13' (3962mm)
	462337 462337	Guide Mounting Rail 14' (4267mm)
	462338 462337	Guide Mounting Rail 15' (4572mm)
	462338 462338	Guide Mounting Rail 16' (4877mm)
	462339 462338	Guide Mounting Rail 17' (5182mm)
	462339 462339	Guide Mounting Rail 18' (5486mm)

2	462351MSS	Shaft Brace
3	462352SS	Horizontal Shaft Mounting Guide
4	462350MSS	Vertical Shaft Adjustable Guide
5	911-201	Flat Washer
6	807-978	Guide Clamp
7	450187MSS	Cross Block
8	960608MSS	Hex Head Screw (Metric) M6-1.0 x 8mm
9	960650MSS	Hex Head Screw (Metric) M6-1.0 x 50mm
10	807-948	Cap, Vinyl
11	462300MSS	Support Assembly, Adjustable Guide (Includes Items: 2 through 10)

Service Parts

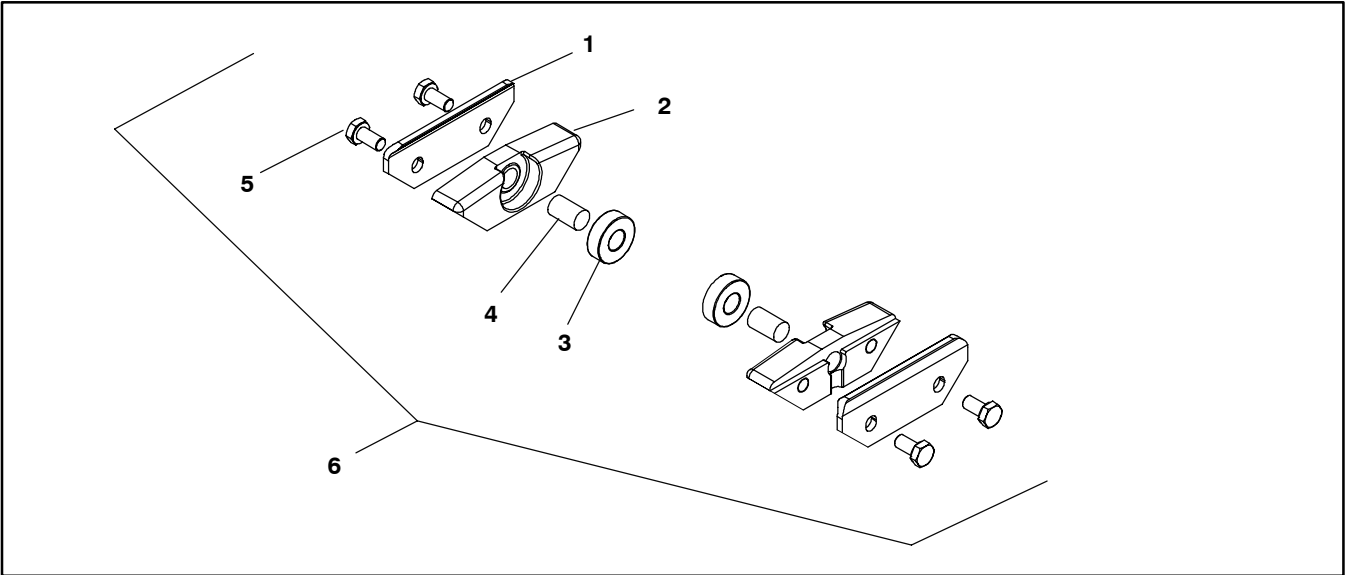
-24 Sanitary Adjustable Width UHMW Guides



Item	Part Number(s)	Description
1	462332	Guide Mounting Rail 2' (610mm)
	462333	Guide Mounting Rail 3' (914mm)
	462334	Guide Mounting Rail 4' (1219mm)
	462335	Guide Mounting Rail 5' (1524mm)
	462336	Guide Mounting Rail 6' (1829mm)
	462337	Guide Mounting Rail 7' (2134mm)
	462338	Guide Mounting Rail 8' (2438mm)
	462339	Guide Mounting Rail 9' (2743mm)
	462340	Guide Mounting Rail 10' (3053mm)
	462341	Guide Mounting Rail 11' (3353mm)
	462342	Guide Mounting Rail 12' (3658mm)
	462337 462336	Guide Mounting Rail 13' (3962mm)
	462337 462337	Guide Mounting Rail 14' (4267mm)
	462338 462337	Guide Mounting Rail 15' (4572mm)
	462338 462338	Guide Mounting Rail 16' (4877mm)
	462339 462338	Guide Mounting Rail 17' (5182mm)
	462339 462339	Guide Mounting Rail 18' (5486mm)

2	462452MSS	Horizontal Shaft Gullwing Guide
3	462450MSS	Vertical Shaft Gullwing Guide
4	807-977	Acorn Nut
5	807-978	Guide Clamp
6	450187MSS	Cross Block
7	807-948	Cap, Vinyl
8	960612MSS	Hex Head Cap Screw M6-1.0 x 12mm
9	970620MSS	Socket Head Set Screw M6-1.0 x 20mm
10	462400MSS	Support Assembly, Gull Wing (In- cludes Items: 2 through 7)

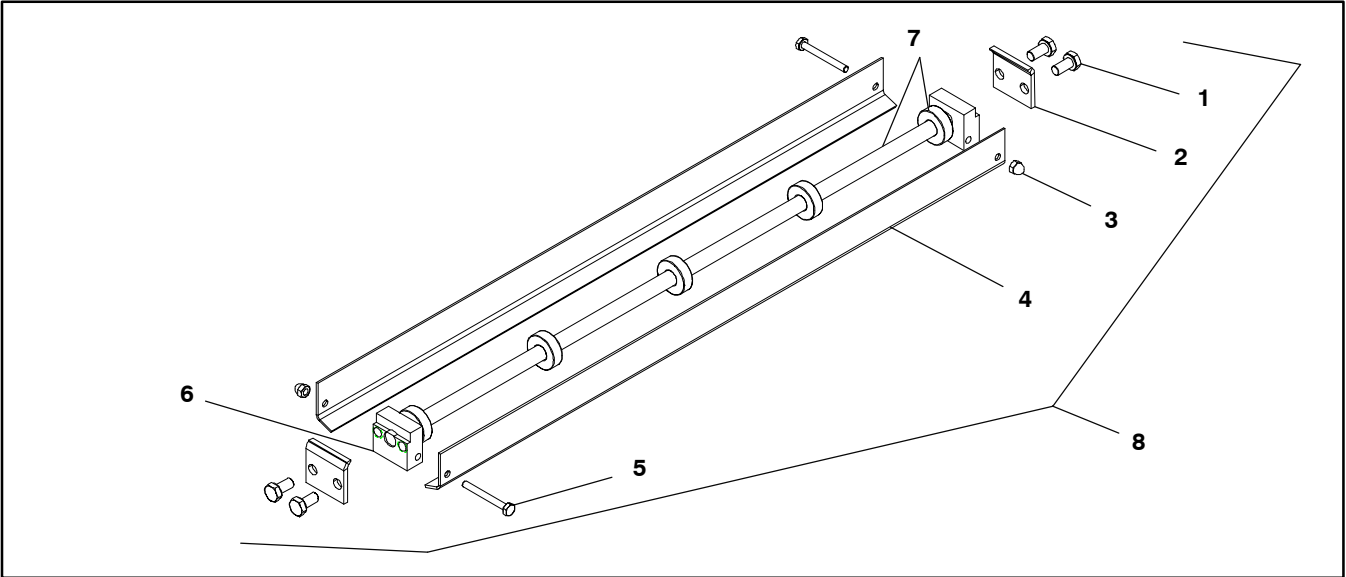
Sanitary 2” (51mm) Through 6” (152mm) Wide Flat or Cleated Belt Return Roller



Item	Part Number	Description
1	450593	Clamp Plate
2	450596	Mounting Block
3	802-123	Bearing

4	913-103	Dowel Pin
5	960612MSS	Hex Head Screw M6-1.0 x 12mm
6	450594	Return Roller Assembly

Sanitary 8” (203mm) Through 18” (457mm) Wide Flat Belt Return Roller

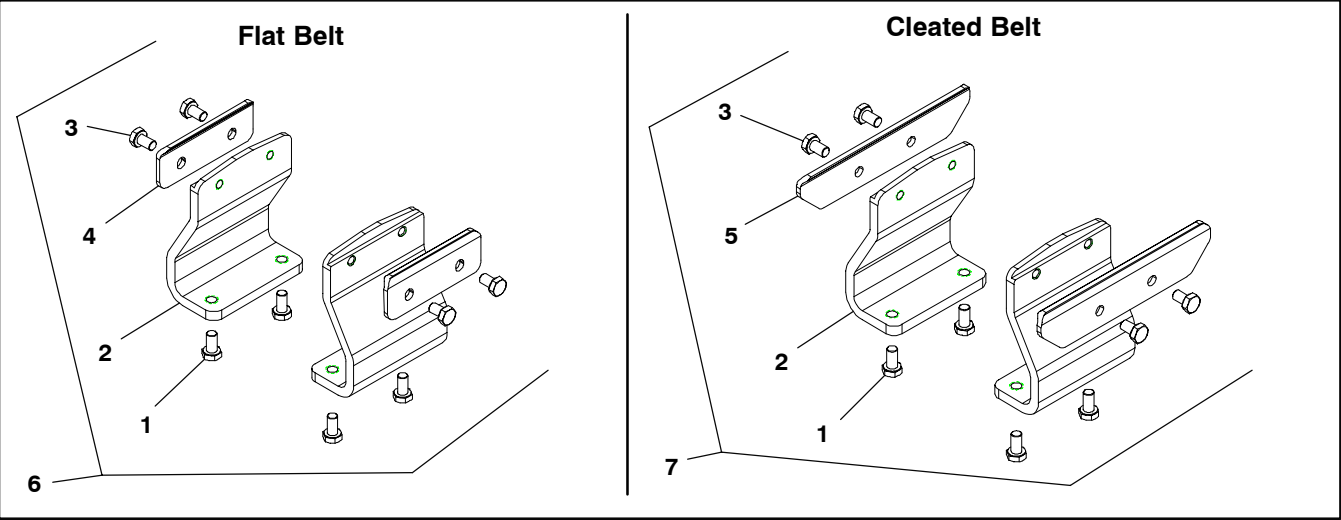


Item	Part Number	Description
1	960612MSS	Hex Head Cap Screw M6-1.0 x 12mm
2	450628	Clamp Plate
3	990408MSS	Acorn Nut M4-0.70
4	4516WW	Return Roller Guard

5	960435MSS	Hex Head Cap Screw M4-0.70 x 35mm
6	450626	Mounting Block
7	4517WW	Shaft/Bearing Assembly
8	4514WW	Return Roller Assembly
WW = Conveyor width ref.: 08, 10, 12, 18		

Service Parts

Conveyor Mounting Brackets



Item	Part Number	Description
1	960612MSS	Hex Head Cap Screw M6-1.0 x 12mm
2	450590	Stand/Conveyor Ear Mount Bracket
3	960610MSS	Hex Head Cap Screw M6-1.0 x 10mm

4	492564SS	Clamp Plate – Flat Belt
5	492566SS	Clamp Plate – Cleated Belt
6	492564SS	Mount Assembly – Flat Belt
7	492566SS	Mount Assembly – Cleated Belt

Configuring Conveyor Belt Part Number

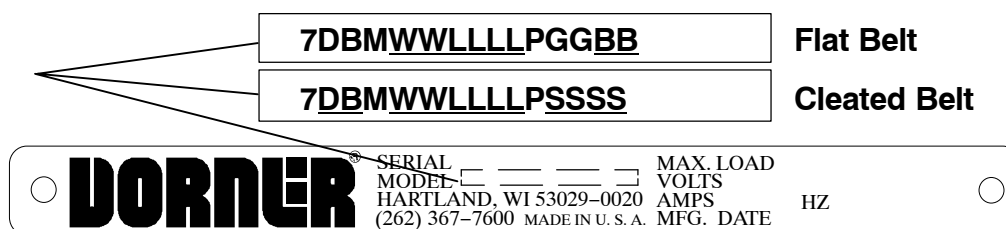


Figure 43

Flat Belt

Refer to your serial and model number 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.

7D-WWLLL / BBV

72-_____/____V
(Fill In)

EXAMPLE:

721M030200A0102 Conveyor

7200 Series end drive, flat belt conveyor with mounting brackets, USA English, 3" (76mm) wide x 2.0 ft (610mm) long, shaft position A, guide profile 01 and belt type /02 (general purpose)

72-030200/02V Belt

Cleated Belt

Refer to your serial and model number plate (Figure 43). From the model number, determine conveyor type (D), width (WW), length (LLLL), belt cleat type (B), and cleat spacing (SSSS). Use data to configure belt part number as indicated below.

7D-WWLLLLBSSSSV

7 - _____ V
(Fill In)

EXAMPLE:

74AM030200A0659 Conveyor

7200 Series standard cleated belt conveyor with mounting brackets, A-style cleat, USA English, 3" (76mm) wide x 2.0 ft (610mm) long, shaft position A, and 6.59 in (167.4mm) cleat spacing

74-030200A0659V Belt

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 @ www.dorner.com

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

DORNER®

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