



2200 Series End Drive Conveyors

Installation, Maintenance & Parts Manual



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IMPORTANT

Some illustrations may show guards removed. DO NOT operate equipment without guards.

Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

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

Dorner 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981, 6,422,382 and corresponding patents and patent applications in other countries.

Dorner reserves the right to make changes at any time without notice or obligation.

Warnings – General Safety

⚠ WARNING

The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.

⚠ DANGER



Climbing, sitting, walking or riding on conveyor will cause severe injury. **KEEP OFF CONVEYORS.**

⚠ DANGER



DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

⚠ WARNING



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

⚠ WARNING



Gearmotors may be **HOT**. **DO NOT TOUCH** Gearmotors.

⚠ WARNING



Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.

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.

⚠ WARNING



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.

Product Description

Refer to Figure 1 for typical components.

1	Conveyor
2	Gearmotor Mounting Package
3	Gearmotor
4	Guiding & Accessories
5	Mounting Brackets
6	Return Rollers
7	Support Stand
8	Variable Speed Controller
9	Drive End
10	Idler/Tension End

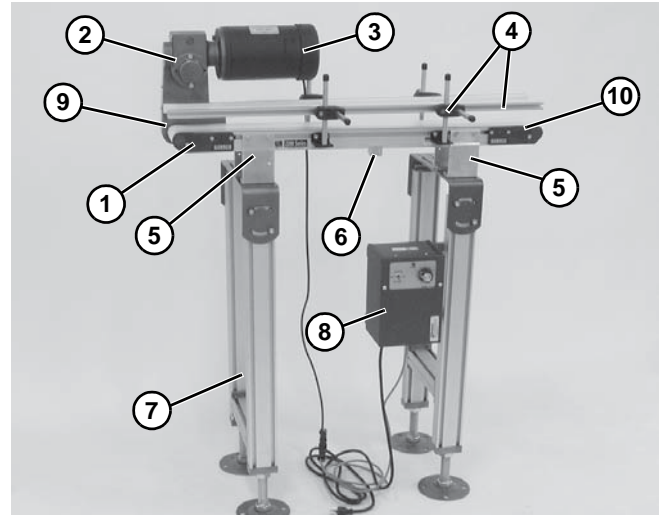


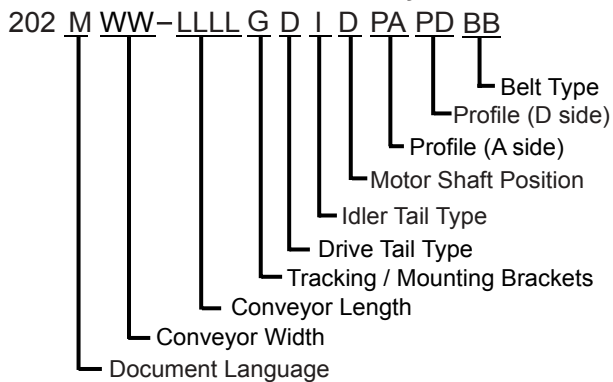
Figure 1

Specifications

Models:

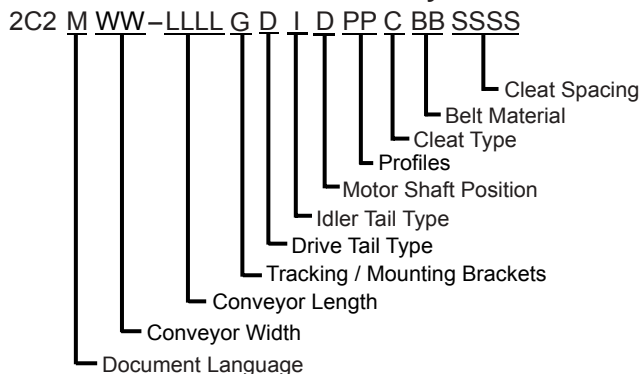
Flat Belt 2200 Series Conveyor

Flat Belt 2200 Series Conveyor



Cleated Belt 2200 Series Conveyor

Cleated Belt 2200 Series Conveyor



Conveyor Supports:

Maximum Distances:

1 = 18" (457 mm)**

2 = 6 ft (1829 mm)***

3 = 18" (457 mm)

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

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

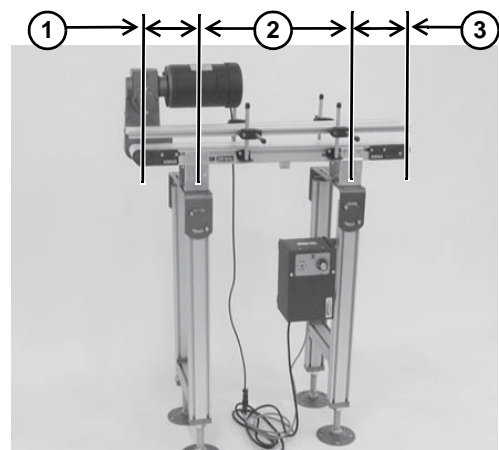


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	03	04	05	06	08	10	12	18	21	24
Conveyor Belt Width	1.75" (44mm)	2.75" (70mm)	3.75" (95mm)	5" (127mm)	6" (152mm)	8" (203mm)	10" (254mm)	12" (305mm)	18" (457mm)	21" (533mm)	24" (609mm)
Maximum Conveyor Load* (See NOTE Below)	30 lb (14kg)	35 lb (16kg)	42 lb (19kg)	50 lb (23kg)	60 lb (27kg)	70 lb (32kg)	80 lb (36kg)	80 lb (36kg)	80 lb (36kg)	80 lb (36kg)	80 lb (36kg)
Conveyor Startup Torque*	2 in-lb (0.5Nm)	3 in-lb (0.6Nm)	4 in-lb (0.7Nm)	6 in-lb (0.8Nm)	8 in-lb (0.9Nm)	10 in-lb (1.1Nm)	12 in-lb (1.4Nm)	14 in-lb (1.5Nm)	15 in-lb (1.7Nm)	18 in-lb (2.0Nm)	20 in-lb (2.3Nm)
Belt Travel	4.0" (88 mm) per revolution of pulley										
Maximum Belt Speed*	264 ft/minute (80.5 m/minute)										
Belt Takeup	0.38" (10 mm) of stroke = 0.75" (19 mm) of belt take-up										

Conveyor Length Reference (LL)	02	03	04	05	06	07	08	09	10	11	12	13**	14**	15**	16**	17**	18**
Conveyor Length Up to 18 ft in any length to nearest 0.12" (3 mm)	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)**

NOTE

Maximum conveyor loads based on:

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

* See Ordering and Specifications Catalog for details.

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

NOTE

Conveyor **MUST** be mounted straight, flat and level within confines of conveyor. Use a level (**Figure 3, item 1**) for setup.



Figure 3

Installation Component List

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

Required Tools

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

Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor (if required)
- Attach mounting brackets to conveyor
- Attach conveyor to stands
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 20 through page 44 of “Service Parts” section for details)

Conveyors Up to 12ft (3658mm)

No assembly is required. Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 8 and “Return Rollers” on page 9.

Conveyors Longer Than 12ft (3658mm)

1. Locate and arrange conveyor sections by section labels (**Figure 4, item 1**).

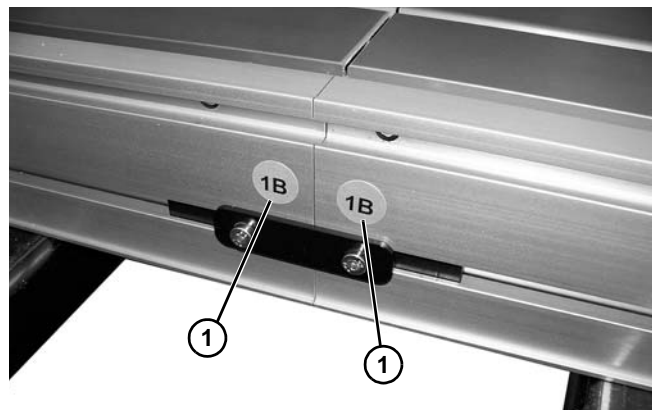



Figure 4

2. On tension end of the conveyor, identified with  a label (**Figure 5, item 1**), push in head plate assembly (**Figure 5, item 2**): On both sides of conveyor, loosen and move cam tracking assemblies (**Figure 5, item 3**) (if equipped) away from head plates, then loosen fastening screws (**Figure 5, item 4**) and push head plate assembly inward.

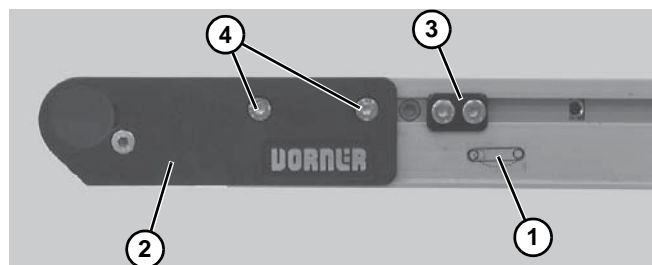


Figure 5

3. Roll out conveyor belt and place conveyor frame sections (**Figure 6, item 1**) into belt loop.

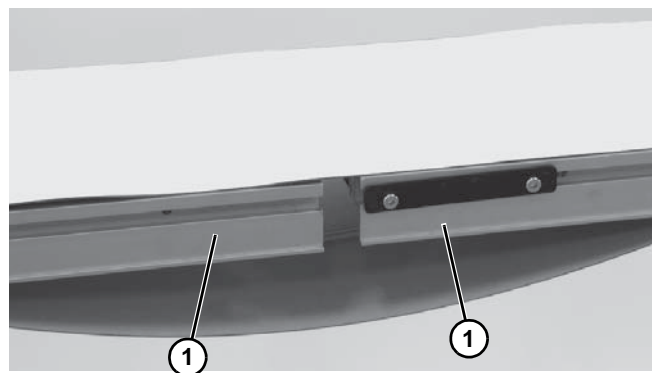


Figure 6

Installation

- Join conveyor sections and install frame connector plates (**Figure 7, item 1**) or connector/mount brackets (**Figure 7, item 2**) and screws (**Figure 7, item 3**) on both sides as indicated. Tighten screws to 60 in-lb (7 Nm).

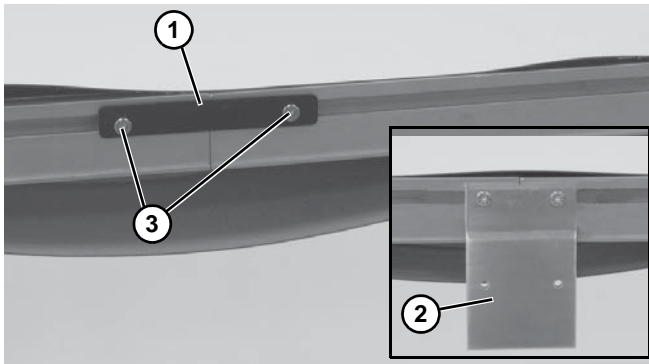


Figure 7

- With a 5 mm hex-key wrench, rotate pinion gear (**Figure 8, item 1**) to tension the conveyor belt. Tighten fastening screws (**Figure 8, item 2**) on both sides of conveyor to 80 in-lb (9 Nm). For proper tensioning, refer to “Conveyor Belt Tensioning” on page 13”.

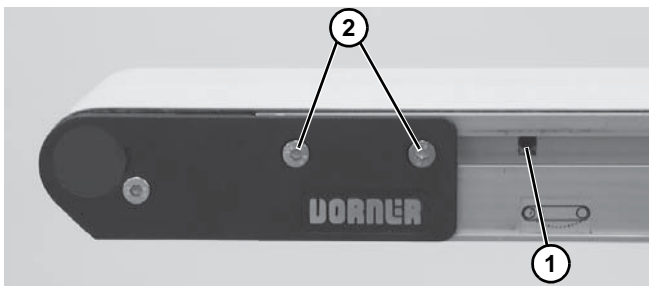


Figure 8

- Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 8 and “Return Rollers” on page 9.
- If equipped with cam tracking assemblies (**Figure 5, item 3**), reposition and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 14.
- If drive tail is equipped with tracking cam assemblies (**Figure 9, item 1**), remove 3rd head plate screw (**Figure 9, item 2**), from head plate with the output shaft.

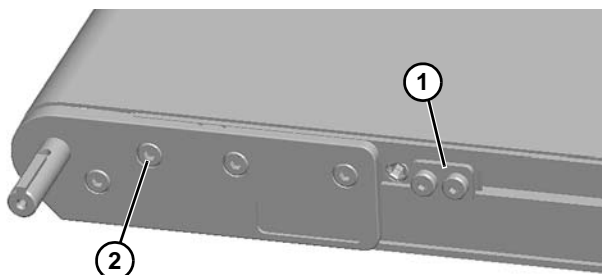


Figure 9

Mounting Brackets

- Locate brackets. Exploded views shown in Figure 10 & Figure 11.

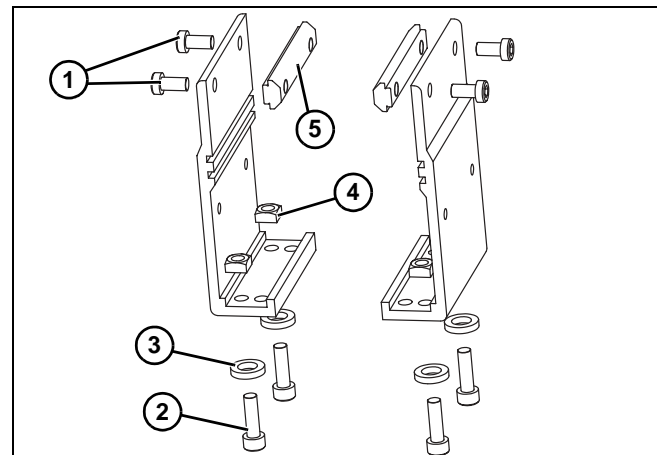


Figure 10

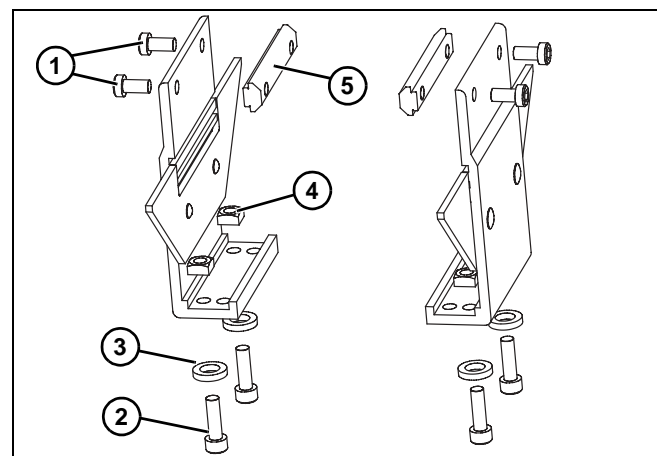


Figure 11

- Remove screws (**Figure 10, item 1 & 2**) & (**Figure 11, item 1 & 2**), washers (**Figure 10, item 3**), nuts (**Figure 10, item 4**) and T-bars (**Figure 10, item 5**) from brackets.
- Insert T-bars (**Figure 10, item 5**) & (**Figure 11, item 5**) into conveyor side slots (**Figure 12, item 1**). Fasten brackets (**Figure 12, item 2**) to conveyor with mounting screws (**Figure 12, item 3**).

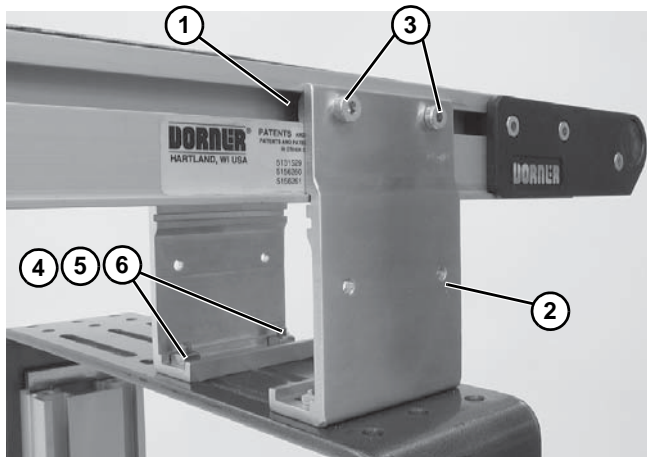


Figure 12

NOTE

Mounting brackets for flat belt conveyors shown.

- Fasten brackets to support stand with mounting screws (Figure 12, item 4), washers (Figure 12, item 5) and nuts (Figure 12, item 6).
- Tighten screws (Figure 12, item 3 & 4) to 60 in-lb (7 Nm).

Return Rollers

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

- Locate return rollers. Exploded views shown in Figure 13 & Figure 14.

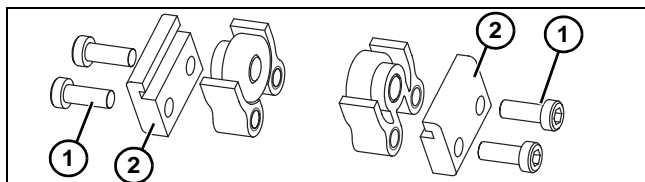


Figure 13

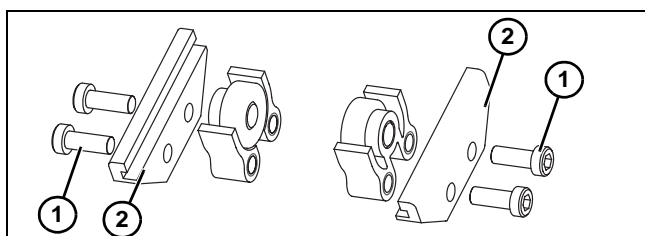


Figure 14

- Remove screws (Figure 13, item 1) & (Figure 13, item 1) and clips (Figure 13, item 2) from roller assembly.

- Install roller assemblies (Figure 15, item 1) as shown. Tighten screws (Figure 15, item 2) to 60 in-lb (7 Nm).

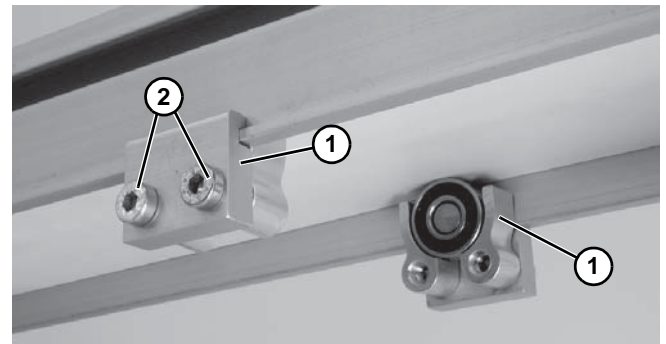


Figure 15

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

- Locate return rollers. Exploded view shown in Figure 16.

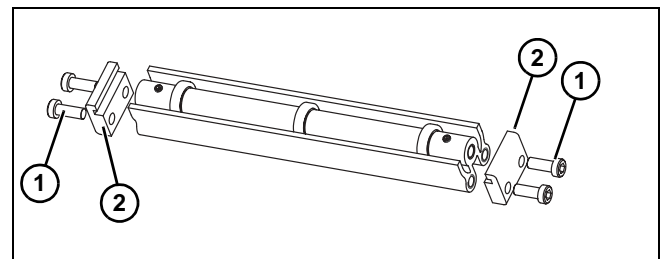


Figure 16

- Remove screws (Figure 16, item 1) and clips (Figure 16, item 2) from roller assembly.
- Install roller assembly as shown (Figure 17, item 1). Tighten screws (Figure 17, item 2) to 60 in-lb (7 Nm).

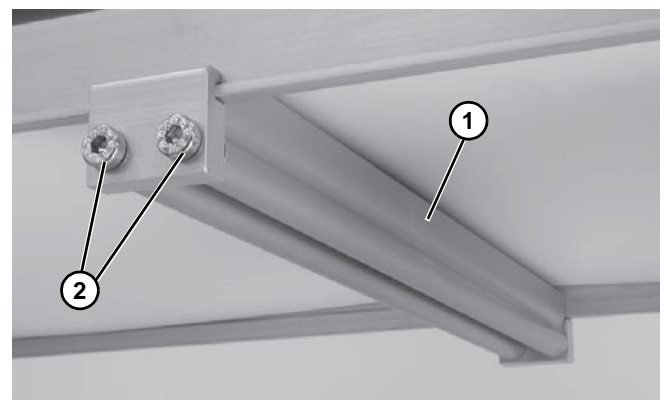


Figure 17

Preventive Maintenance and Adjustment

Required Tools

Standard Tools

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

Special Tools

- 807–1716 Bearing Puller Tool (or equivalent)
- 450293 Bearing Installation Tool (Bearing Pusher)
- 456063 Bearing Removal Tool

Checklist

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

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

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

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Improperly installed bottom wipers (if installed)
- Accumulated dirt in wipers (if installed)
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:

- Excessive load on belt
- Conveyor belt or drive timing belt are not properly tensioned
- Worn knurl or impacted dirt on drive pulley
- Intermittent jamming or drive train problems

Damage to V-guide indicates:

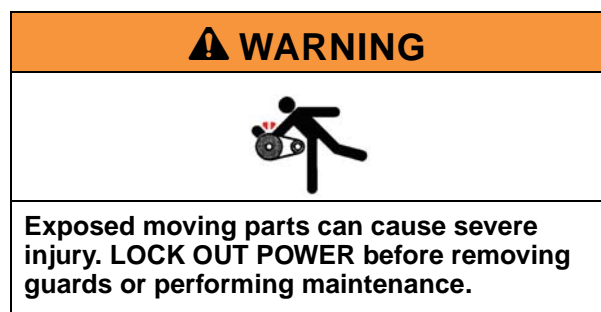
- Twisted or damaged conveyor frame
- Dirt impacted on pulleys
- Excessive or improper side loading

Cleaning

Use Dornier Belt Cleaner. Mild soap and water may also be used. Do not soak the belt.

For /05 woven polyester and /06 black anti-static belts, use a bristled brush to improve cleaning.

Conveyor Belt Replacement



Conveyor Belt Replacement Sequence

Remove old conveyor belt:

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

Preventive Maintenance and Adjustment

Belt Removal for Conveyor Without Stands or Gearmotor Mounting Package

1. If equipped, remove bottom wipers (**Figure 18, item 1**): Remove fastening screws (**Figure 18, item 2**) then remove wiper.

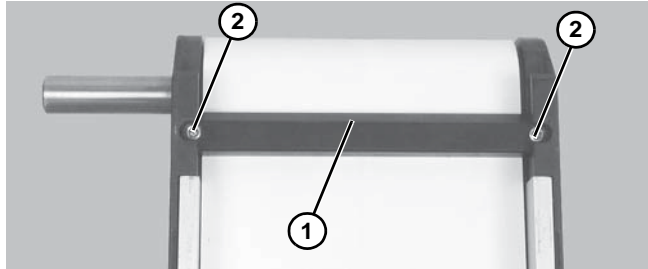



Figure 18

2. If equipped, remove return rollers and guiding and accessories from one side of conveyor.
3. On tension end of the conveyor, identified with a  label (**Figure 19, item 1**), push in head plate assembly (**Figure 19, item 2**): On both sides of conveyor, loosen and move cam tracking assemblies (**Figure 19, item 3**) (if equipped) away from head plates, then loosen fastening screws (**Figure 19, item 4**) and push head plate assembly inward.

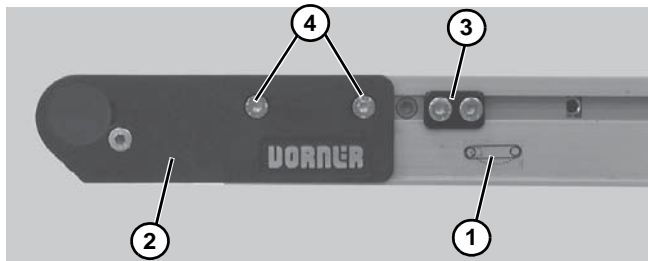



Figure 19

4. Remove conveyor belt.

Belt Removal for Conveyor With Stands and Gearmotor Mounting Package

⚠ WARNING

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

1. Place temporary support stands (**Figure 20, item 1**) at both ends of the conveyor. Place an additional support stand under the drive motor (**Figure 20, item 2**), if equipped. See WARNING.

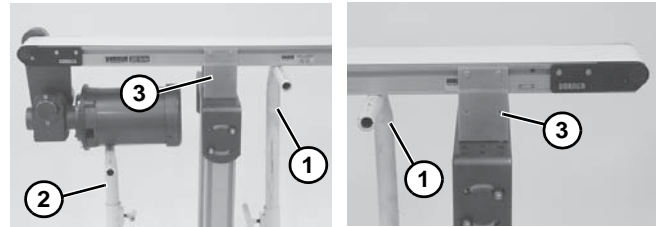


Figure 20

2. Remove mounting brackets (**Figure 20, item 3**) from one side of conveyor. (Reverse steps 3 & 4 of “Mounting Brackets” section beginning on page 8.) If equipped with heavy load drive package, remove brackets from side opposite drive cover (**Figure 21, item 1**).
3. If equipped, remove bottom wipers (**Figure 18, item 1**): Remove fastening screws (**Figure 18, item 2**) then remove wiper (**Figure 18, item 1**).
4. If equipped, remove return rollers, guiding and accessories from side opposite drive cover (**Figure 21, item 1**).

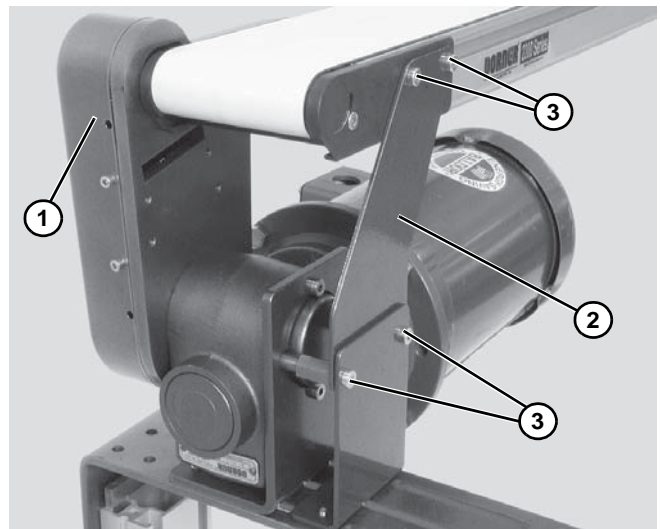



Figure 21

5. If equipped with heavy load drive package, remove drive support bracket (**Figure 21, item 2**): Remove bracket screws (**Figure 21, item 3**) then remove bracket (**Figure 21, item 2**).

Preventive Maintenance and Adjustment

- On tension end of the conveyor, identified with a  label (**Figure 22, item 1**), push in head plate assembly (**Figure 22, item 2**): On both sides of conveyor, loosen and move cam tracking assemblies (**Figure 22, item 3**) (if equipped) away from head plates, then loosen fastening screws (**Figure 22, item 4**) and push head plate assembly inward.

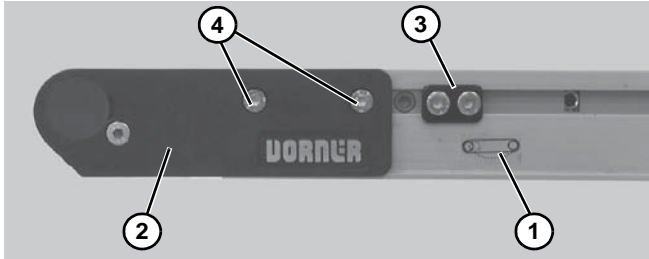


Figure 22

- Remove belt (**Figure 23, item 1**) from conveyor.



Figure 23

Belt Installation for Conveyor without Stands or Gearmotor Mounting Package

- Orient belt so splice leading fingers (**Figure 24, item 1**) point in the direction of belt travel as identified by the conveyor directional label (**Figure 24, item 2**).

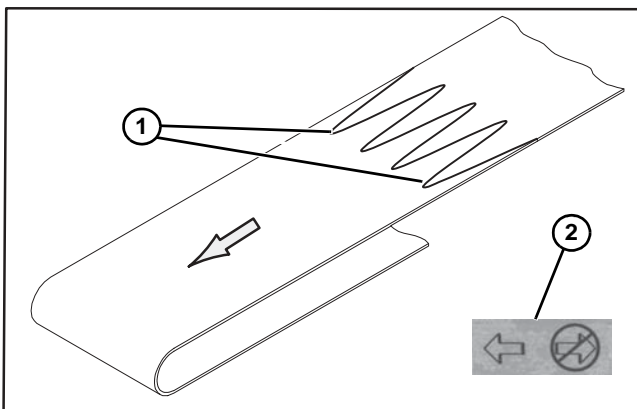



Figure 24

- Slide belt onto the conveyor frame assembly.
- Tension belt. Refer to “Conveyor Belt Tensioning” on page 13.
- If equipped, install wipers, return rollers and guiding.

Belt Installation for Conveyor with Stands and Gearmotor Mounting Package

⚠ WARNING



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

- Ensure temporary support stands (**Figure 20, item 1**) are placed at both ends of the conveyor. Place an additional support stand under the drive motor (**Figure 20, item 2**), if equipped. See WARNING.
- Orient belt so splice leading fingers (**Figure 24, item 1**) point in the direction of belt travel as identified by the conveyor directional label (**Figure 24, item 2**).
- Install belt (**Figure 25, item 1**) on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.




Figure 25


- Re-install conveyor mounting brackets. Refer “Mounting Brackets” beginning on page 8, steps 3 through 5.
- If equipped with a heavy load drive package, re-install drive support bracket (**Figure 21, item 2**).
- Tension belt. Refer to “Conveyor Belt Tensioning” on page 13
- If equipped, re-install wipers, return rollers and guiding.

Preventive Maintenance and Adjustment

Conveyor Belt Tensioning

⚠ WARNING

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

Conveyors with 1.25" (32 mm) Diameter Pulleys

1. On tension end of the conveyor, identified with a  label (**Figure 26, item 1**), adjust head plate assembly (**Figure 26, item 2**): On both sides of conveyor, loosen fastening screws (**Figure 26, item 3**) and rotate pinion gear (**Figure 26, item 4**) to adjust head plate assembly.

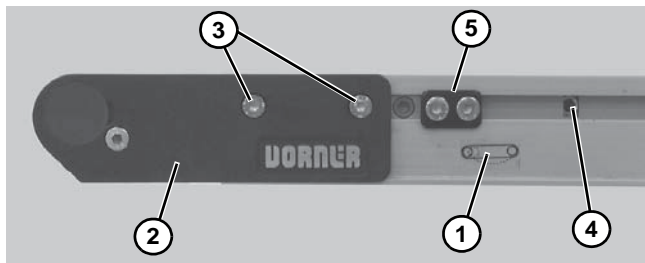


Figure 26

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks (**Figure 27, item 1 & 2**). Replace belt if proper tensioning can not be obtained while aligning the end of the conveyor frame with or between the tensioning marks. See NOTE.

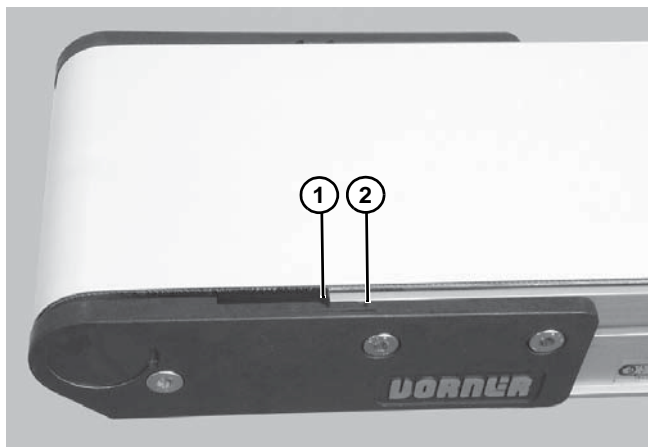



Figure 27

NOTE

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

3. After adjusting proper tensioning, tighten fastening screws (**Figure 26, item 3**) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (**Figure 26, item 5**), position against head plates and adjust belt tracking. Refer to "Conveyor Belt Tracking" on page 14.

Conveyors with Nose Bar Idlers

1. On tension end of the conveyor, identified with a  label (**Figure 28, item 1**), adjust head plate assembly (**Figure 28, item 2**): On both sides of conveyor, loosen fastening screws (**Figure 28, item 3**) and rotate pinion gear (**Figure 28, item 4**) to adjust head plate assembly.

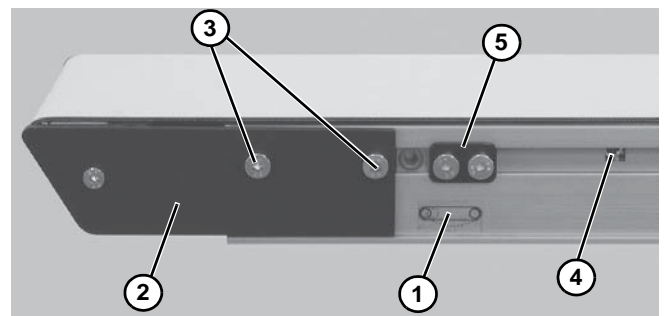


Figure 28

2. Adjust head plate assembly so the edge of the axle support plate (**Figure 29, item 1**) is separated from the end of the conveyor (**Figure 29, item 2**) by 1.125" (29 mm). Replace belt if proper tensioning can not be obtained within a distance of 1.50" (38 mm). See NOTE.

Preventive Maintenance and Adjustment

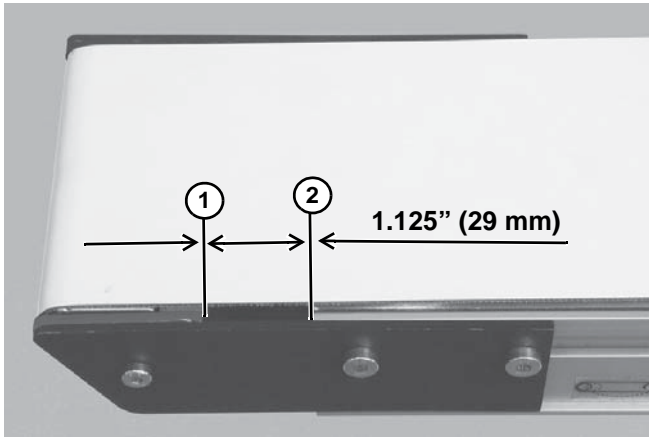


Figure 29

NOTE

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

3. After adjusting proper tensioning, tighten fastening screws (**Figure 28, item 3**) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (**Figure 28, item 5**) position against head plates and adjust belt tracking. Refer to "Conveyor Belt Tracking", next section.

Conveyor Belt Tracking

V-Guided Belts

V-guided belts do not require tracking adjustment.

Non V-Guided Belts

Non V-guided belt conveyors are equipped with belt tracking cam assemblies (**Figure 30, item 1**) for belt tracking adjustment.

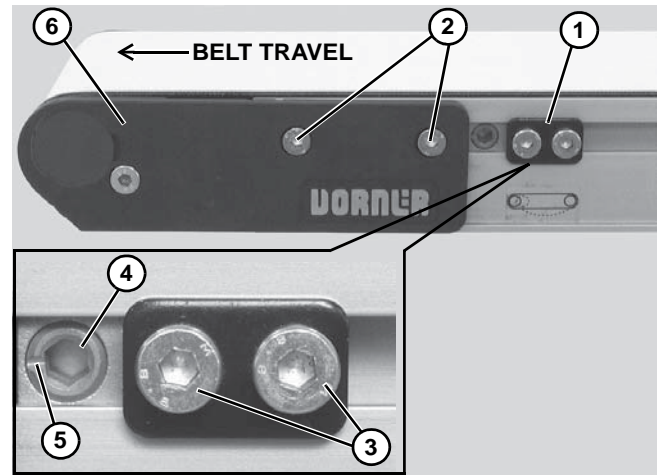



Figure 30

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

5. Ensure head plate fastening screws (**Figure 30, item 2**) on both sides of conveyor are tightened.
6. On both sides of conveyor, loosen two (2) cam fastening screws (**Figure 30, item 3**). Adjust cams (**Figure 30, item 4**) until indicator slots (**Figure 30, item 5**) are horizontal and facing end of conveyor. Then slide cam assemblies against head plates (**Figure 30, item 6**) and re-tighten cam fastening screws (**Figure 30, item 3**) to 60 in-lb (7 Nm).
7. On the side toward which the belt is tracking, loosen head plate fastening screws (**Figure 30, item 2**).
8. With the conveyor running, use a 5 mm hex-key wrench to rotate the tracking cam (**Figure 30, item 4**) in small increments until the belt tracks in the center of the conveyor. Then while holding the cam in position, re-tighten the head plate fastening screws (**Figure 30, item 2**) with a 4 mm hex-key wrench to 60 in-lb (7 Nm).

Preventive Maintenance and Adjustment

Pulley Removal

⚠ WARNING

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

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

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

A – Idler Pulley Removal

1. On one side of the conveyor, loosen two (2) head plate fastening screws (**Figure 31, item 1**) and remove them.

NOTE
<i>To prevent damage to the head plates and pulley, be sure to remove them slowly because they are not attached to pulley.</i>

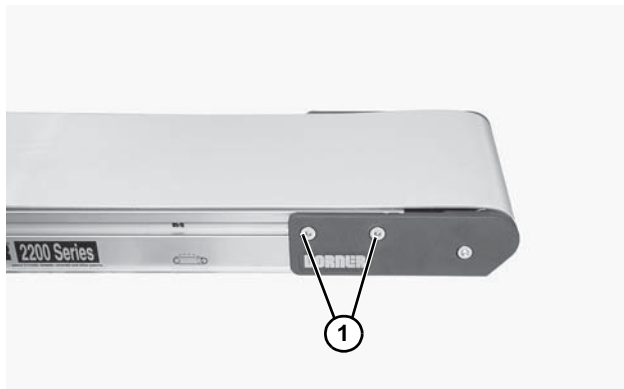


Figure 31

2. Remove the head plate (**Figure 32, item 1**) from the conveyor frame.

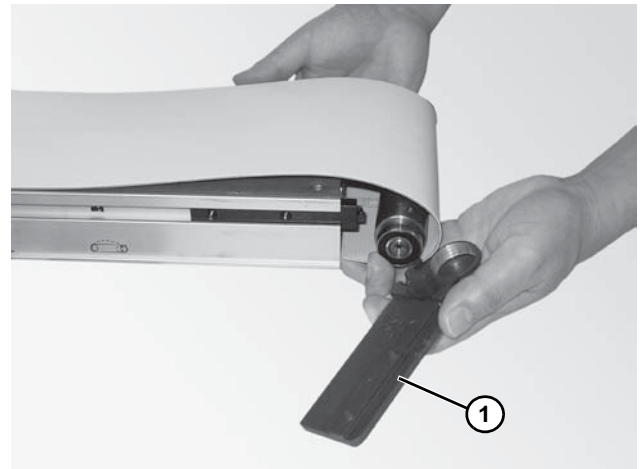


Figure 32

3. Pulley will slide out of opposite head plate and drop into slack of belt (**Figure 33**).



Figure 33

4. Slide spindle out of the belt loop.

Preventive Maintenance and Adjustment

B – Drive Pulley Removal

⚠ WARNING



Drive shaft keyway may be sharp. **HANDLE WITH CARE.**

1. On one side of the conveyor, loosen two (2) head plate fastening screws (**Figure 34, item 1**) and remove.

NOTE

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

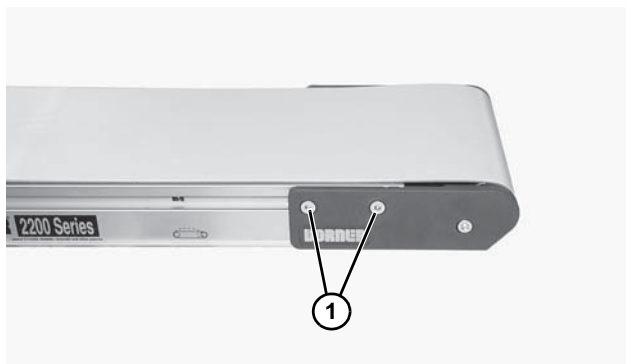


Figure 34

2. Remove the head plate (**Figure 35, item 1**) from the conveyor frame.

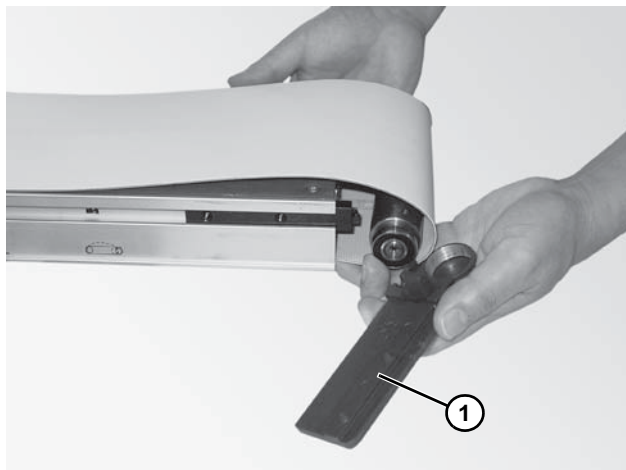


Figure 35

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

Bearing Removal & Replacement

Removal

IMPORTANT

Do not use any removed bearings. Replace them.

1. Place bearing removal tool part #456063 (**Figure 36, item 1**) below bearing (**Figure 36, item 2**) with lip (**Figure 36, item 3**) located in gap (**Figure 36, item 4**) between bearing and spindle hub (**Figure 36, item 5**) as shown.

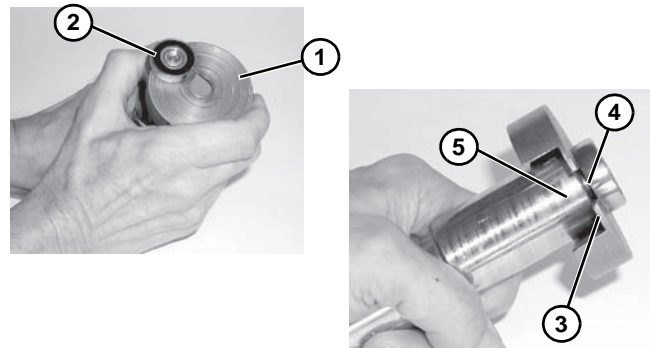


Figure 36

2. Using a puller part #807-1716 (**Figure 37, item 1**), remove and discard bearing.

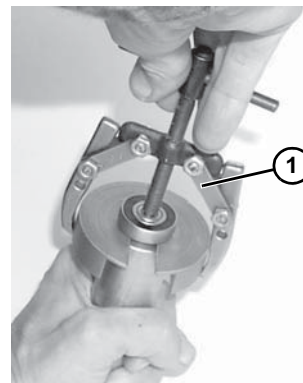


Figure 37

Preventive Maintenance and Adjustment

Replacement

1. Inspect the head plates bearing seating surface (**Figure 38, item 1**). If they are worn or damaged, replace. See “Service Parts” on page 20.

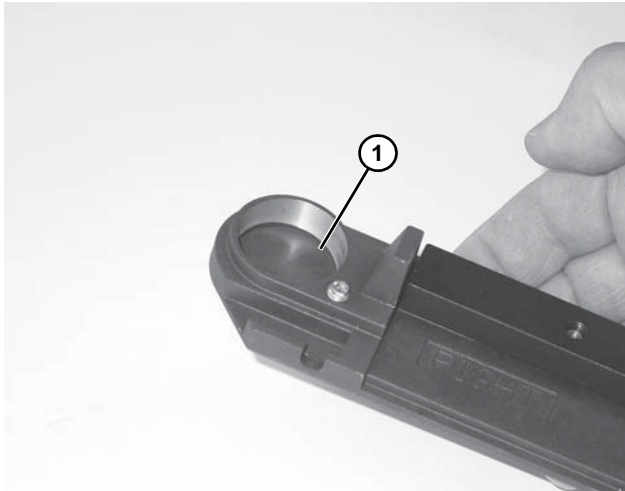


Figure 38

2. Inspect spindle (**Figure 39, item 1**). Replace if worn.
3. Slide bearing (**Figure 39, item 2**) onto spindle.

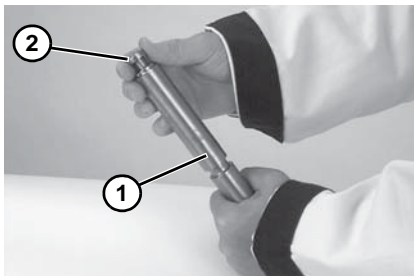


Figure 39

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

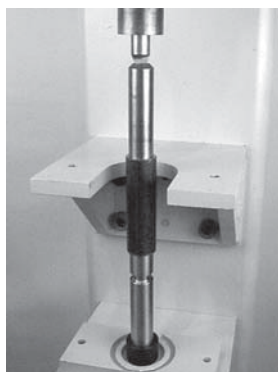


Figure 40

5. Repeat steps 1 through 4 for each bearing.

Drive Pulley and Idler Pulley Installation

Drive Pulley Installation

1. With opposite head plate installed, position the drive pulley through the loop of the belt, into the opposite head plate.
2. Place the head plate (**Figure 41, item 1**) and attach the head plate to the conveyor frame with the two (2) screws removed. Tighten screws 60 in-lb (7 Nm).

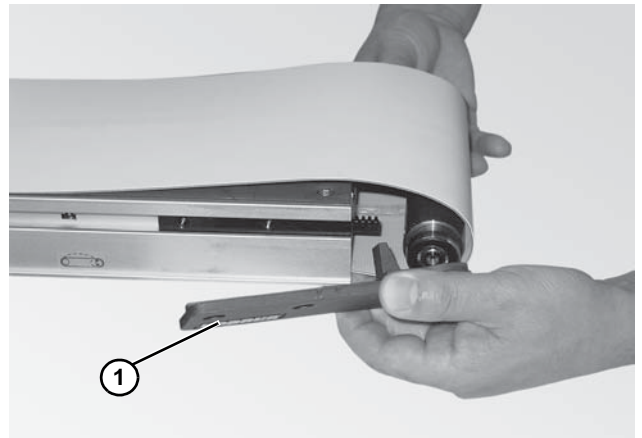


Figure 41

Idler Pulley Installation

1. With opposite head plate installed, position the idler pulley through the loop of the belt, into the opposite head plate.
2. Place the head plate (**Figure 42, item 1**) and attach the head plate to the conveyor frame with the two (2) screws removed and hand tighten.

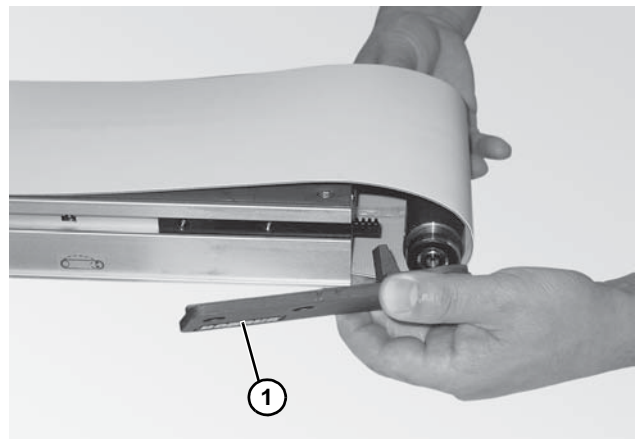


Figure 42

Preventive Maintenance and Adjustment

Nose Bar Bearing Replacement

1. On both sides of conveyor, use a 4 mm hex-key wrench to loosen cam fastening screws (**Figure 43, item 1**) and slide cam assemblies toward the center of the conveyor.

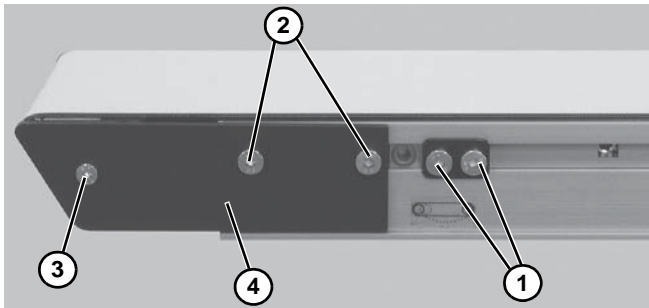


Figure 43

2. On both sides of conveyor, use a 4 mm hex-key wrench to loosen head plate fastening screws (**Figure 43, item 2**) to remove belt tension. Then remove belt from end of conveyor.
3. On one side of conveyor, use a 3 mm and 4 mm hex-key wrench to remove head plate fastening screws (**Figure 43, item 3**) & (**Figure 43, item 2**) and remove head plate (**Figure 43, item 4**).
4. Slide bearing rods (**Figure 44, item 1**) out side of conveyor and replace bearings (**Figure 44, item 2**) as necessary.

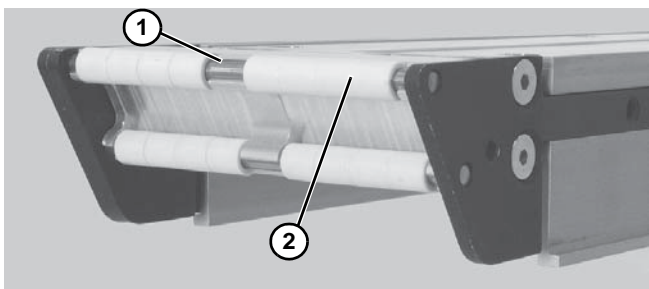



Figure 44

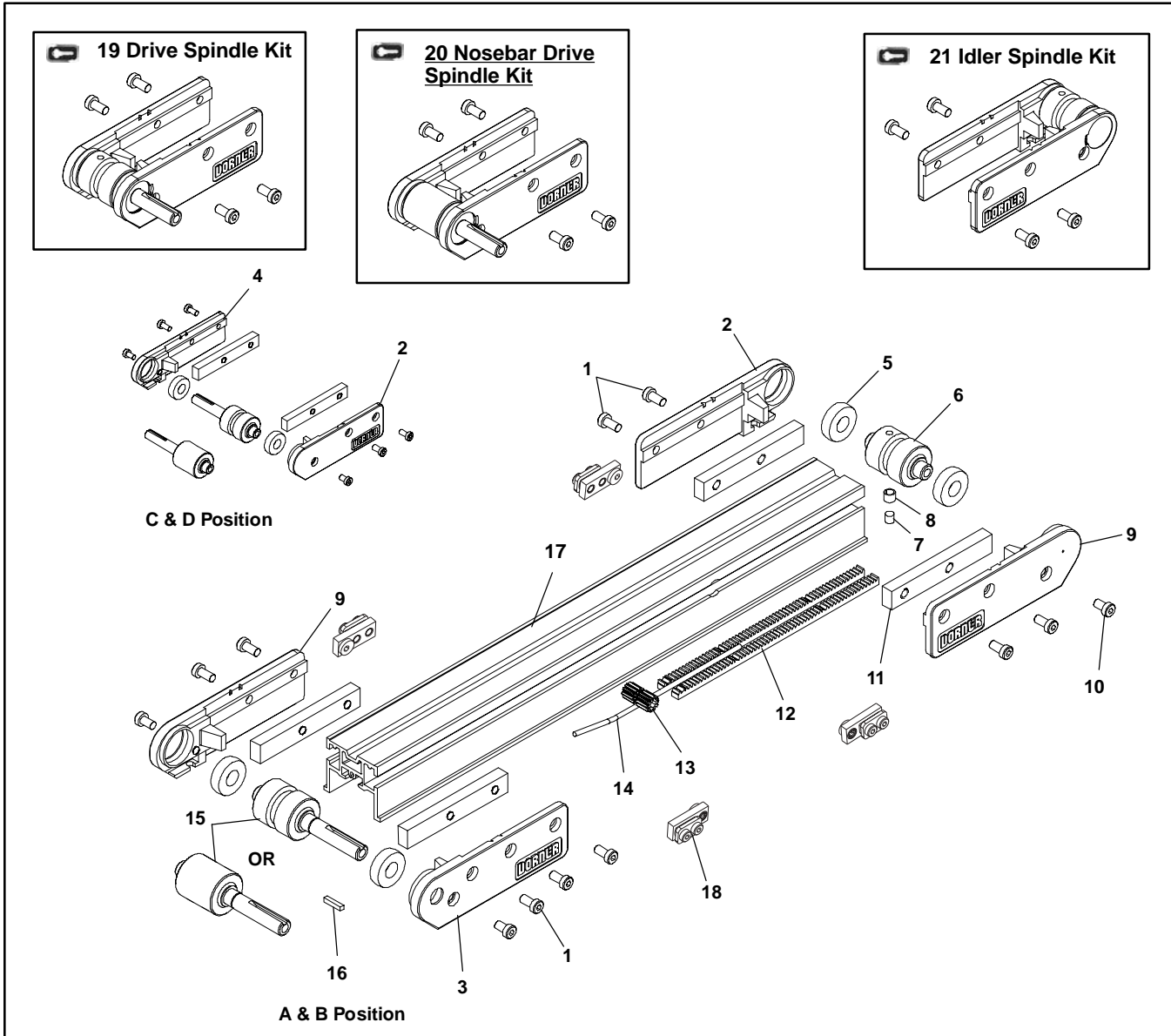
5. After replacing bearings, re-install head plate (**Figure 43, item 4**). Use a 3 mm hex-key wrench to tighten one (1) fastening screw (**Figure 43, item 3**) to 30 in-lb (3.4 Nm). Leave two (2) fastening screws (**Figure 43, item 2**) loose for belt tensioning.
6. Re-install belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 13.
7. Re-position the cam assemblies against the head plates and adjust belt tracking. See “Conveyor Belt Tracking” on page 14.

Service Parts

NOTE

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

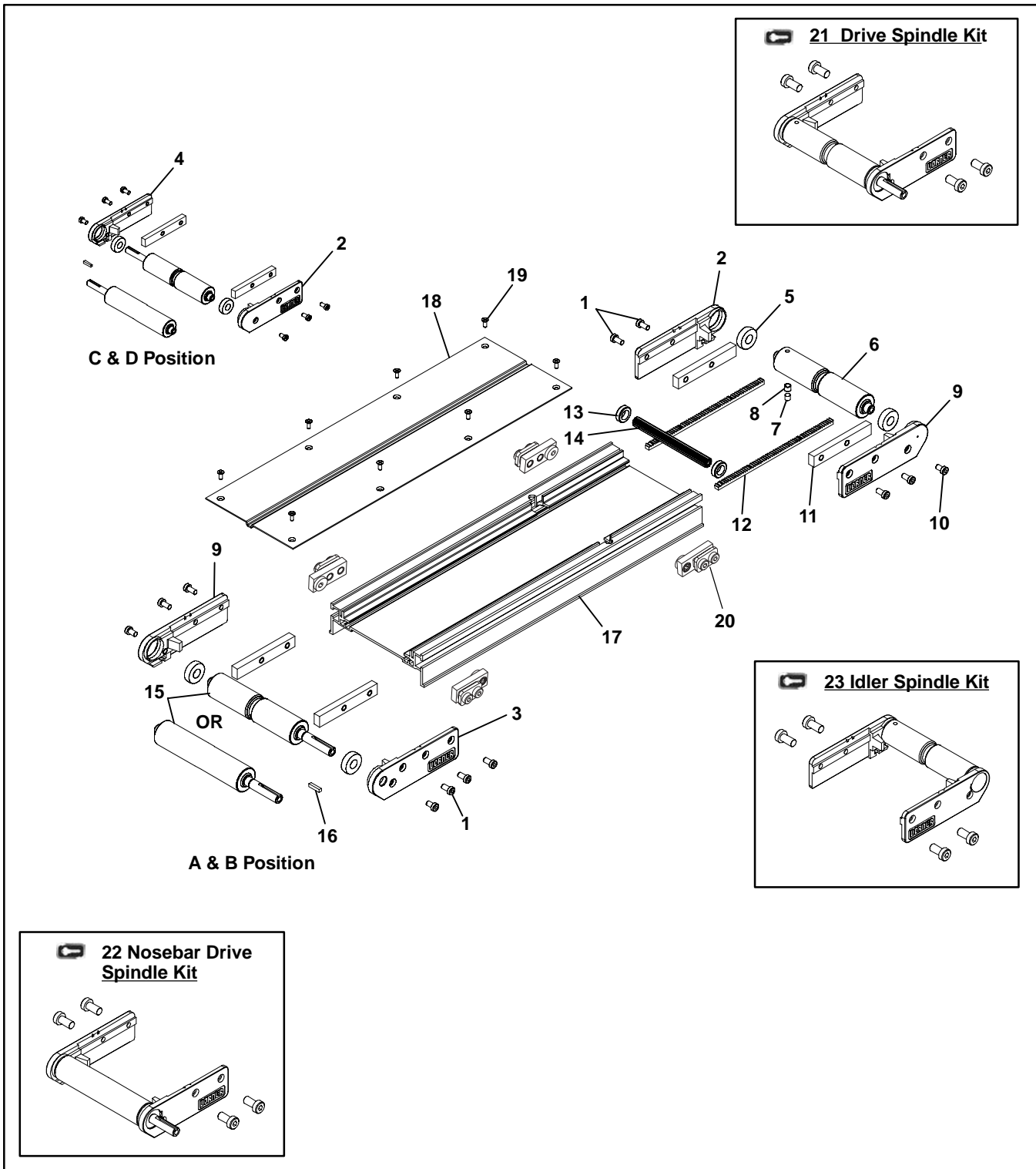
2" (51 mm) Wide Conveyor



Item	Part Number	Description
1	950612M	Low Head Cap Screw, M6 x 12 mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	22BK2	Bearing Kit (x2)
	22BK4	Bearing Kit (x4)
6	247302	Idler Spindle, 2" (51mm)
7	808-020	Magnet, 0.25" Dia. x 0.25" long Sleeve, 0.25"
8	450226SSP	Magnet Stainless Steel
9	240426	Head Plate, RH
10	950610M	Low Head Cap Screw, M6 x 10 mm
11	240329	Tension Slide Bar
12	240420	Rack Gear, 14.5 Degree PA x 24 P
13	240423	Pinion, 2" (51 mm)
14	240422	Pinion Pin
15	456402	Drive Spindle, 2" (51 mm)
	247602	Nosebar Drive Spindle, Lagged 2" (51mm)
16	980422M	Square Key, 4 mm x 22 mm
17	240402-LLLLL	2" (51mm) Frame
18	240025	Cam Mounting Assembly
19	22A-02	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 15)
	22D-02	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 15)
20	22NA-02	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 15)
	22ND-02	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1,2, 4, 5, 9 and 15)
21	22T-02	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)
LLLLL = part length in inches with 2 decimal places		
Example: Part Length = 55.08" LLLLL = 05508		

Service Parts

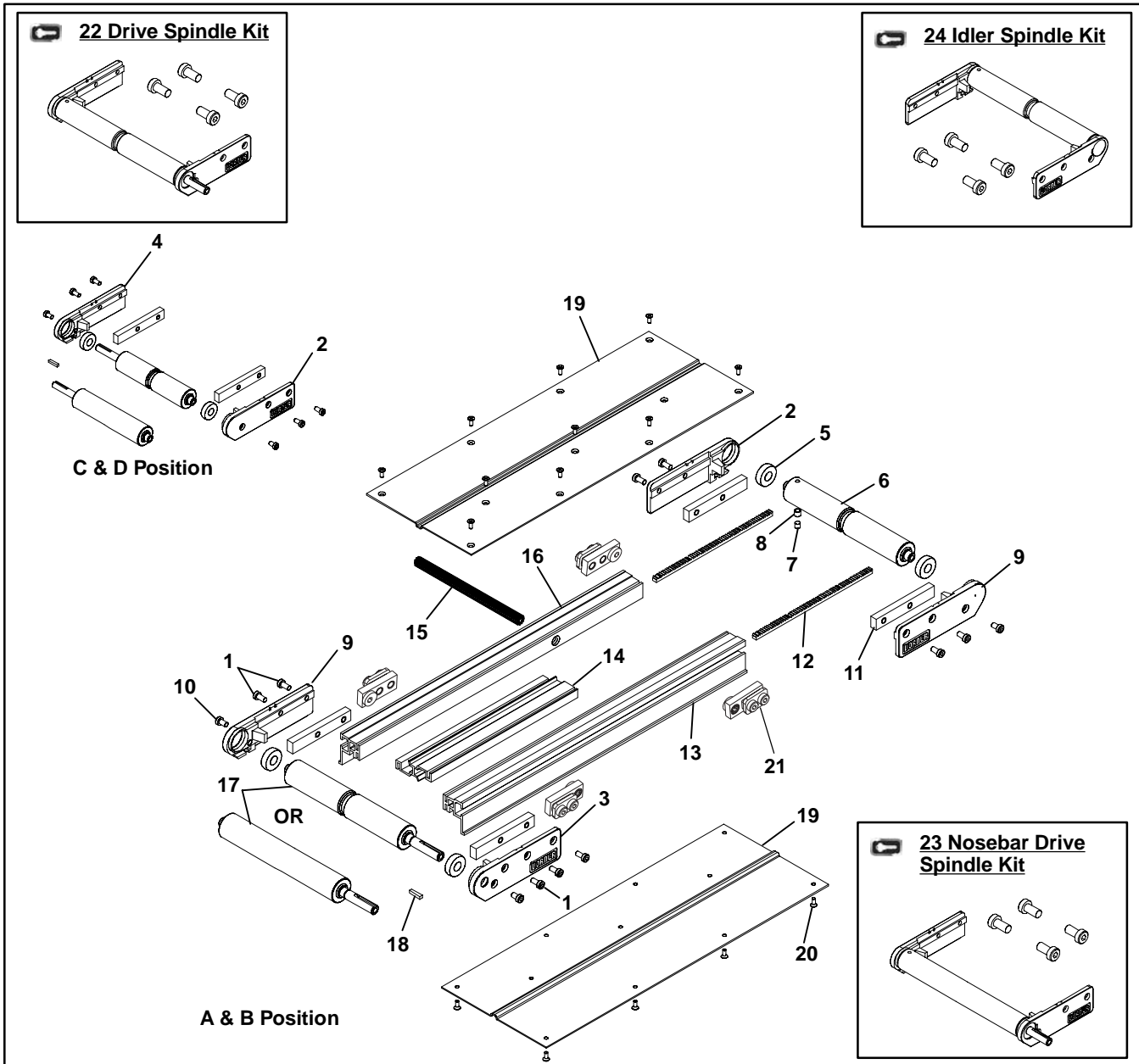
3" (76 mm) to 6" (152 mm) Wide Conveyor



Item	Part Number	Description
1	950612M	Low Head Cap Screw, M6 x 12 mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	22BK2	Bearing Kit (x2)
	22BK4	Bearing Kit (x4)
6	2473 WW	Idler Spindle
7	808-020	Magnet, 0.25" Dia. x 0.25" long
8	450226SSP	Sleeve, 0.25" Magnet (Stainless Steel)
9	240426	Head Plate RH
10	950610M	Low Head Cap Screw, M6 x 10 mm
11	240329	Tension Slide Bar
12	240420	Rack Gear, 14.5 Degree PA x 24P
13	240421	Pinion Bushing
14	2030 WW M	Pinion Gear
15	4564 WW	Drive Spindle
	2476 WW	Nosebar Drive Spindle, Lagged
16	980422M	Square Key, 4 mm x 22 mm
17	2404 WW - LLLL	Conveyor Frame
18	2405 WW - LLLL	Conveyor Bed Plate
19	807-1105	Flat Head Torx Screw, M6 x 10 mm
20	240025	Cam Mounting Assembly
21	22A- WW	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1,2, 3, 5, 9 and 15)
	22D- WW	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 15)
22	22NA- WW	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 15)
	22ND- WW	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 15)
23	22T- WW	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)
WW = Conveyor width reference: 03, 04, 05, 06		
LLLL = part length in inches with 2 decimal places		
Example: Part Length = 55.08" LLLL = 05508		

Service Parts

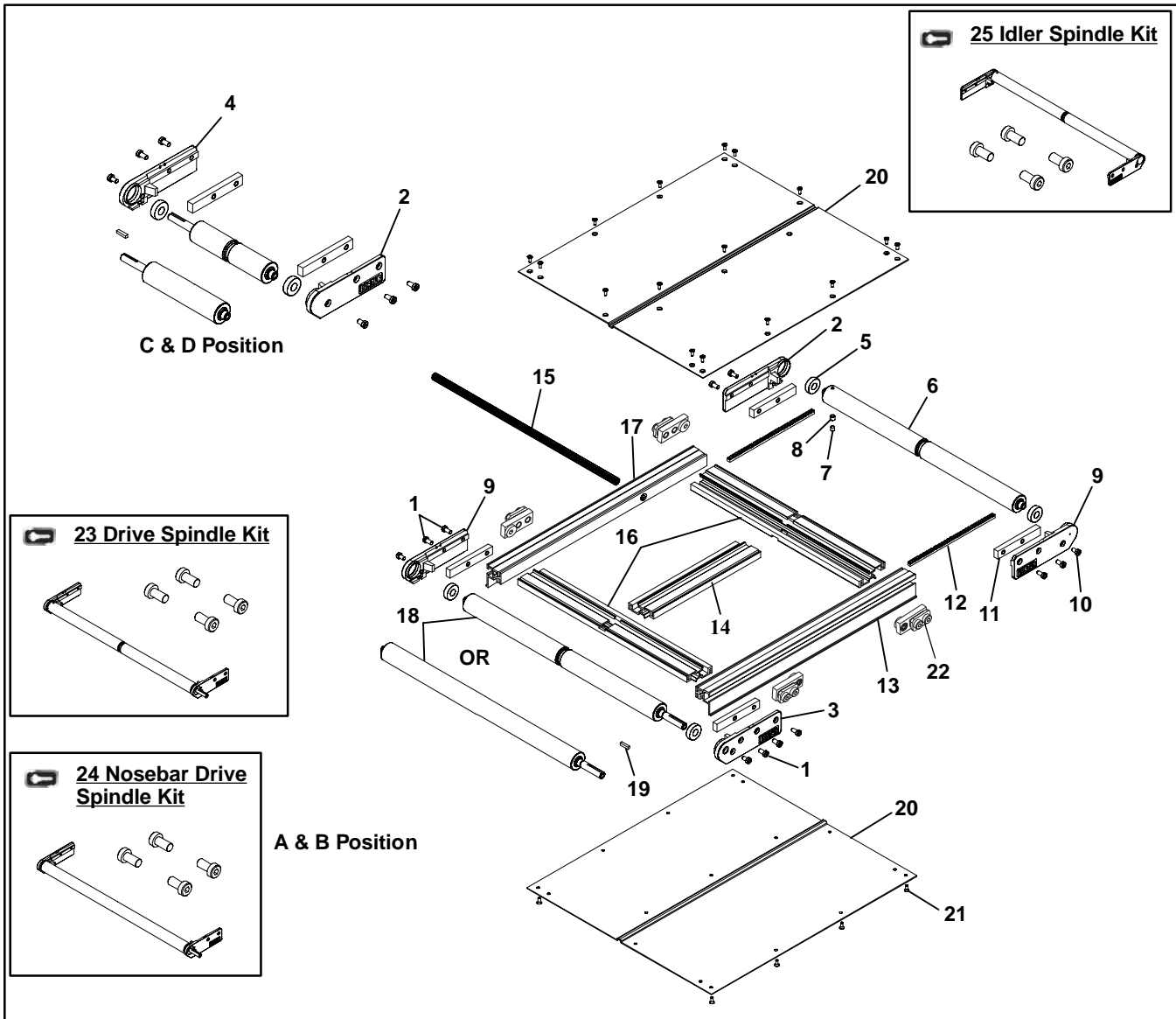
8" (203 mm) to 12" (305 mm) Wide Conveyor



Item	Part Number	Description
1	950612M	Low Head Cap Screw, M6 x 12 mm
2	240425	Head Plate, LH
3	240427	Head Plate, LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	22BK2	Bearing Kit (x2)
	22BK4	Bearing Kit (x4)
6	2473 WW	Idler Spindle
7	808-020	Magnet, 0.25" Dia. x 0.25" long
8	450226SSP	Sleeve, 0.25" Magnet Stainless Steel
9	240426	Head Plate RH
10	950610M	Low Head Cap Screw, M6 x 10 mm
11	240329	Tension Slide Bar
12	240420	Rack Gear, 14.5 Degree PA x 24P
13	240412- LLLL	Side Rail, LH
14	240414- LLLL	Center Rail
15	2030 WWM	Pinion Gear
16	240413- LLLL	Side Rail, RH
17	4564 WW	Drive Spindle
	2476 WW	Nosebar Drive Spindle, Lagged
18	980422M	Square Key, 4 mm x 22 mm
19	2405 WW-LLLL	Side Rail RH
20	807-1105	Flat Head Torx Screw, M6 x 10 mm
21	240025	Cam Mounting Assembly
22	22A- WW	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 17)
	22D- WW	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 17)
23	22NA- WW	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 17)
	22ND- WW	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 17)
24	22T- WW	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)
WW = Conveyor width reference: 08, 10, 12		
LLLL = part length in inches with 2 decimal places		
Example: Part Length = 55.08" LLLL = 05508		

Service Parts

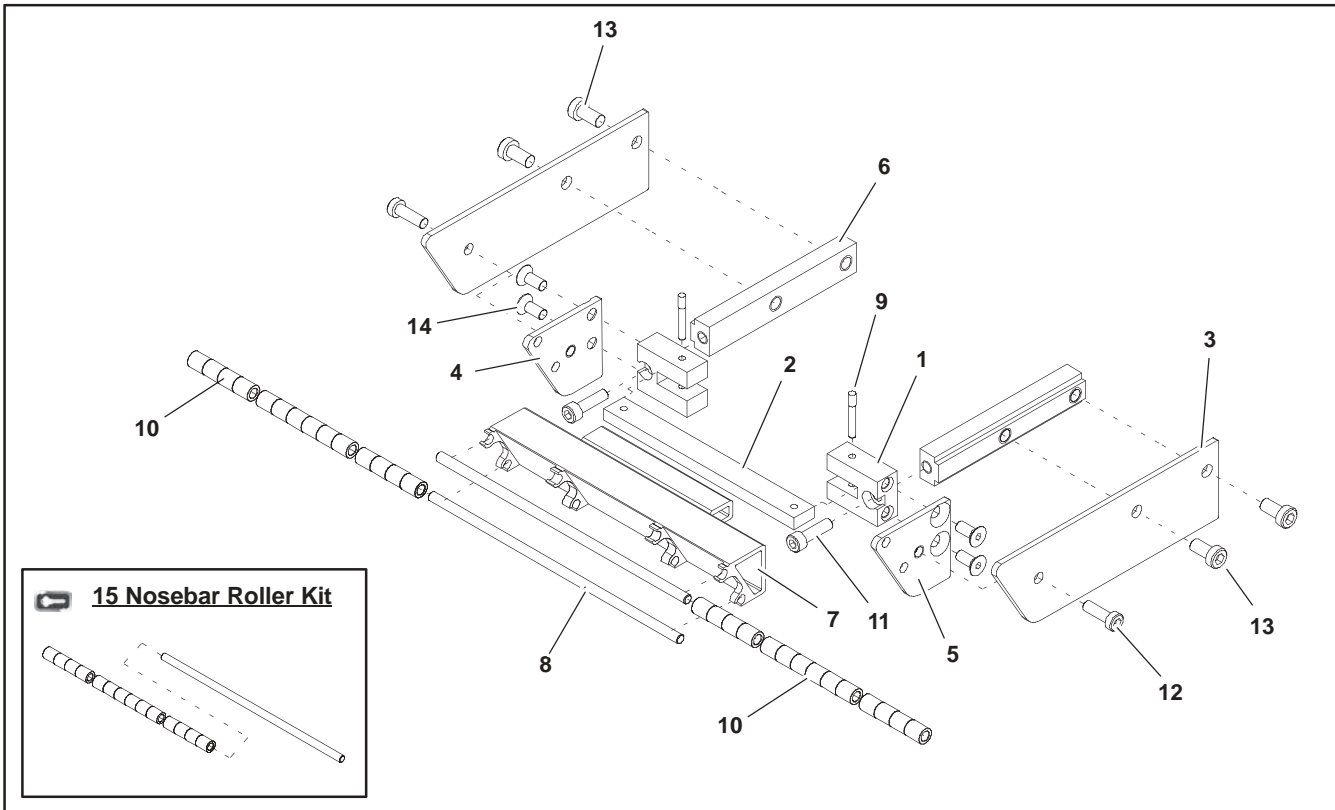
18" (457 mm) to 24" (610 mm) Wide Conveyor



Item	Part Number	Description
1	950612M	Low Head Cap Screw, M6 x 12 mm
2	240425	Head Plate, LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate, RH Drive Side, Position C and D
5	22BK2	Bearing Kit (x2)
	22BK4	Bearing Kit (x4)
6	2473 WW	Idler Spindle
7	808-020	Magnet, 0.25" Dia. x 0.25" long
8	450226SSP	Sleeve, 0.25" Magnet Stainless Steel
9	240426	Head Plate, RH
10	950610M	Low Head Cap Screw, M6 x 10 mm
11	240329	Tension Slide Bar
12	240420	Rack Gear, 14.5 Degree PA x 24 P
13	24012- LLLLL	Side Rail, LH
14	24014- LLLLL	Center Rail
15	2030 WW M	Pinion Gear
16	240417	Center Rail Cross Support, 18" (457 mm)
	240418	Center Rail Cross Support, 21" (533 mm)
	240419	Center Rail Cross Support, 24" (610 mm)
17	24013- LLLLL	Side Rail, RH
18	4564 WW	Drive Spindle
	2476 WW	Nosebar Drive Spindle, Lagged
19	980422M	Square Key, 4 mm x 22 mm
20	2405 WW - LLLLL	Conveyor Bed Plate
21	807-1105	Flat Head Torx Screw, M6 x 1 mm
22	240025	Cam Mounting Assembly
23	22A- WW	Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 18)
	22D- WW	Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 18)
24	22NA- WW	Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 18)
	22ND- WW	Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 18)
25	22T- WW	Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)
WW = Conveyor width reference: 18, 21, 24		
LLLLL = part length in inches with 2 decimal places		
Example: Part Length = 55.08" LLLLL = 05508		

Service Parts

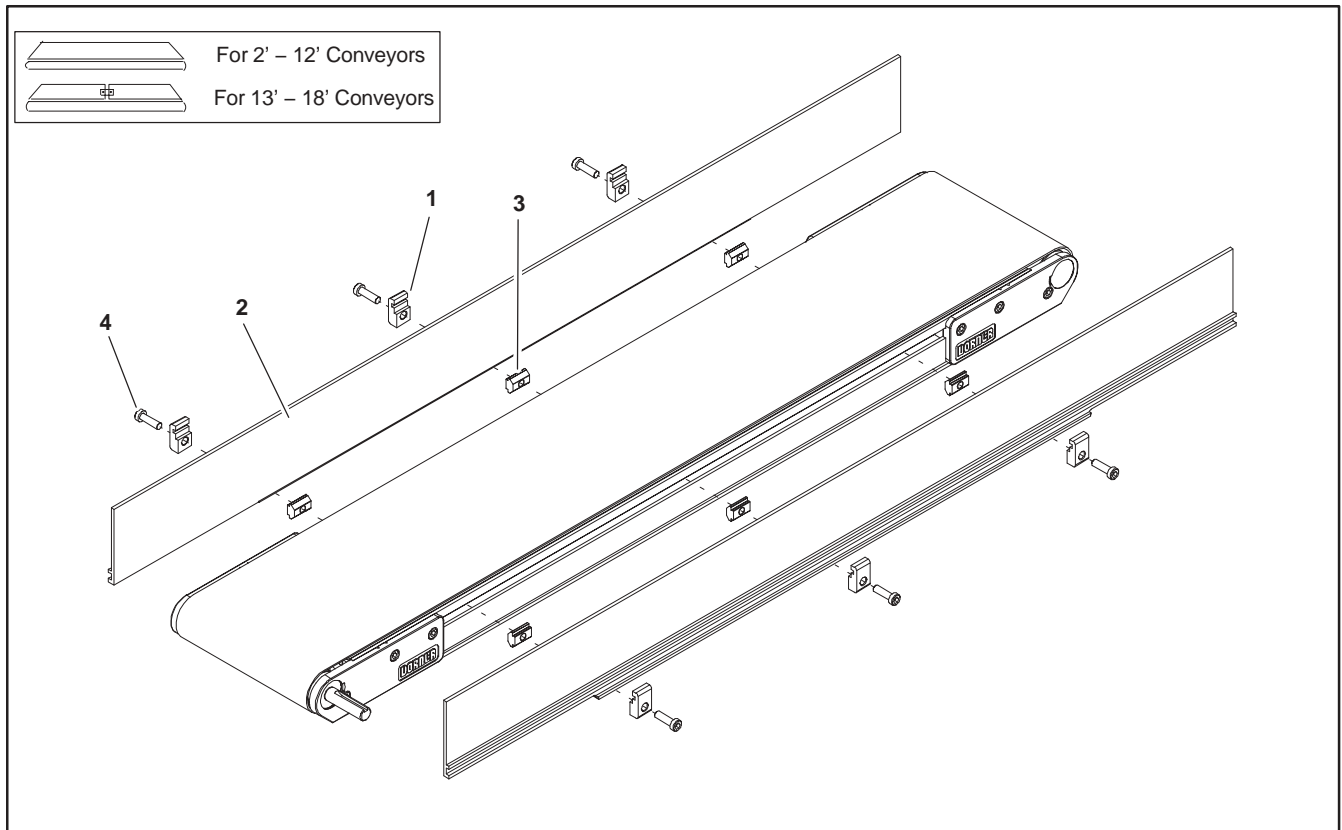
Nosebar End Assembly



Item	Part Number	Description
1	201965M	Mounting Block, PLT Spindle
2	2076 WW	Flex-Link Bar
3	241125	Outer Side Plate
4	241126	Inner Side Plate, LH
5	241127	Inner Side Plate, RH
6	241128	Head Plate Bar
7	2412 WW	Nosebar
8	2413 WW	Nosebar Rod
9	200695P	Knurl Pin, 0.125" DIA x 0.937" Lg
10	801-122	Nose Bar Roller
11	920518M	Socket Head Screw, M5 x 18 mm
12	950516M	Low Head Cap Screw, M5 x 16 mm
13	950612M	Low Head Cap Screw, M6 x 12 mm
14	930512M	Flat Head Screw, M5 x 12 mm
15	22N- WW	Nosebar Roller Kit (Includes Items 8 and 10)

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

-04 3" (76 mm) Aluminum Side



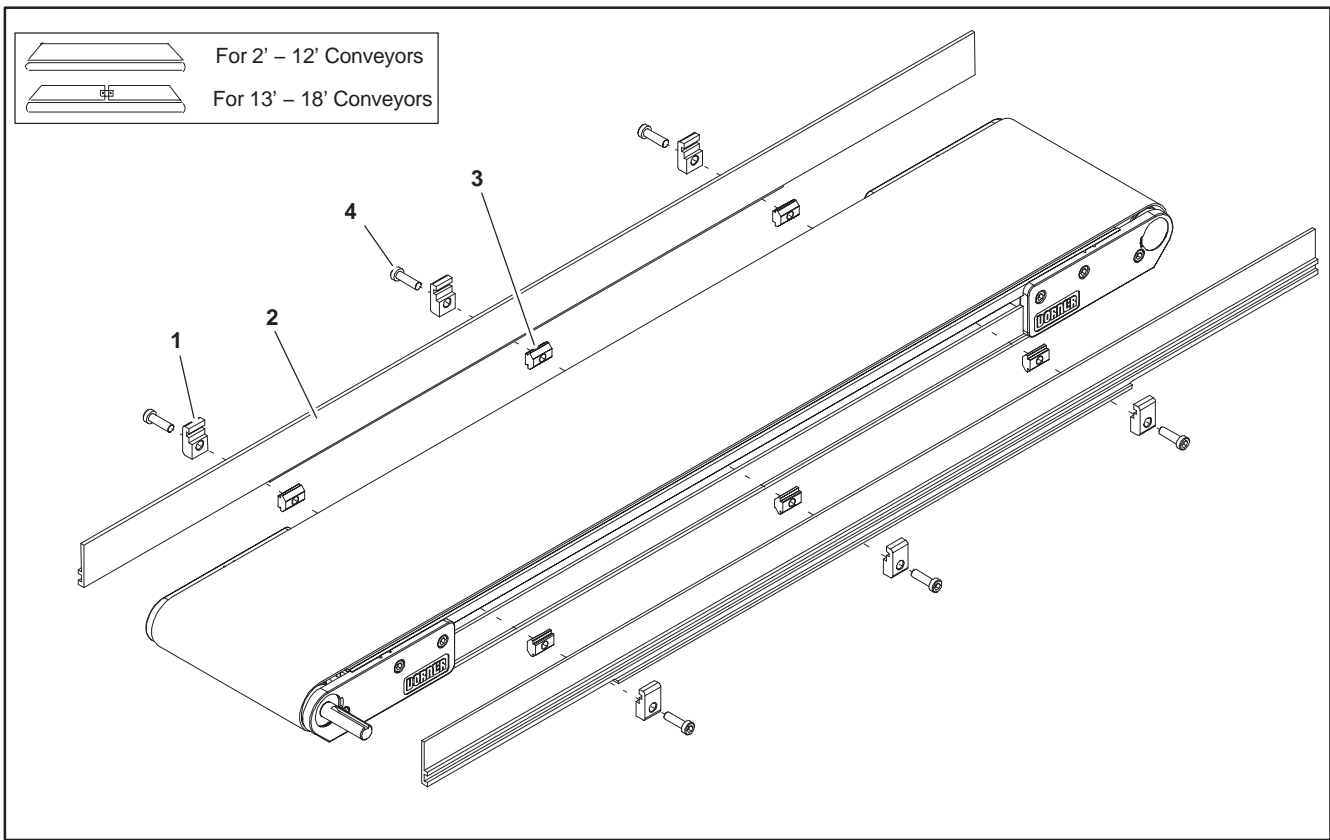
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 3" (76mm) HS
3	639971MK10	Single Drop-in Tee Bar (x10)
4	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide 3" (76mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280403-02400	N/A
	Right Hand	280403-02400	N/A
3' (914mm)	Left Hand	280403-03600	N/A
	Right Hand	280403-03600	N/A
4' (1219mm)	Left Hand	280403-04800	N/A
	Right Hand	280403-04800	N/A
5' (1524mm)	Left Hand	280403-06000	N/A
	Right Hand	280403-06000	N/A
6' (1829mm)	Left Hand	280403-07200	N/A
	Right Hand	280403-07200	N/A
7' (2134mm)	Left Hand	280403-08400	N/A
	Right Hand	280403-08400	N/A
8' (2438mm)	Left Hand	280403-09600	N/A
	Right Hand	280403-09600	N/A
9' (2743mm)	Left Hand	280403-10800	N/A
	Right Hand	280403-10800	N/A
10' (3048mm)	Left Hand	280403-12000	N/A
	Right Hand	280403-12000	N/A

Item 2: 2200 Guide 3" (76mm) HS			
Length		End Guide	End Guide
11' (3353mm)	Left Hand	280403-13200	N/A
	Right Hand	280403-13200	N/A
12' (3658mm)	Left Hand	280403-14400	N/A
	Right Hand	280403-14400	N/A
13' (3962mm)	Left Hand	280401-07500	280401-08100
	Right Hand	280402-07500	280402-08100
14' (4267mm)	Left Hand	280401-07500	280401-09300
	Right Hand	280402-07500	280402-09300
15' (4572mm)	Left Hand	280401-07500	280401-10500
	Right Hand	280402-07500	280402-10500
16' (4877mm)	Left Hand	280401-07500	280401-11700
	Right Hand	280402-07500	280402-11700
17' (5182mm)	Left Hand	280401-07500	280401-12900
	Right Hand	280402-07500	280402-12900
18' (5486mm)	Left Hand	280401-07500	280401-14100
	Right Hand	280402-07500	280402-14100

Service Parts

-05 1.5" (38mm) Aluminum Side

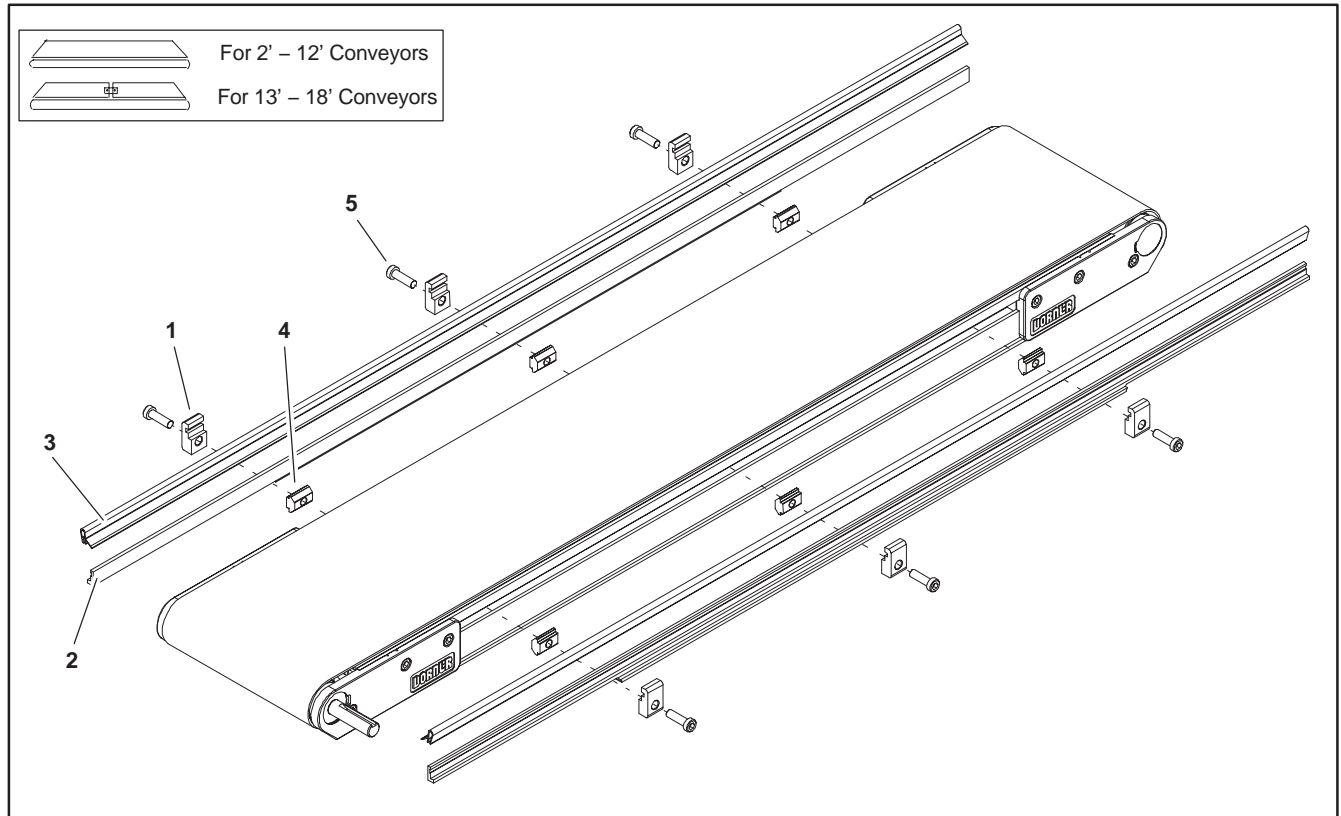


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 1.5" (38mm) HS
3	639971MK10	Single Drop-in Tee Bar (x10)
4	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide 1.5" (38mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280503-02400	N/A
	Right Hand	280503-02400	N/A
3' (914mm)	Left Hand	280503-03600	N/A
	Right Hand	280503-03600	N/A
4' (1219mm)	Left Hand	280503-04800	N/A
	Right Hand	280503-04800	N/A
5' (1524mm)	Left Hand	280503-06000	N/A
	Right Hand	280503-06000	N/A
6' (1829mm)	Left Hand	280503-07200	N/A
	Right Hand	280503-07200	N/A
7' (2134mm)	Left Hand	280503-08400	N/A
	Right Hand	280503-08400	N/A
8' (2438mm)	Left Hand	280503-09600	N/A
	Right Hand	280503-09600	N/A
9' (2743mm)	Left Hand	280503-10800	N/A
	Right Hand	280503-10800	N/A
10' (3048mm)	Left Hand	280503-12000	N/A
	Right Hand	280503-12000	N/A
11' (3353mm)	Left Hand	280503-13200	N/A
	Right Hand	280503-13200	N/A

Item 2: 2200 Guide 1.5" (38mm) HS			
Length		End Guide	End Guide
12' (3658mm)	Left Hand	280503-14400	N/A
	Right Hand	280503-14400	N/A
13' (3962mm)	Left Hand	280501-07500	280501-08100
	Right Hand	280502-07500	280502-08100
14' (4267mm)	Left Hand	280501-07500	280501-09300
	Right Hand	280502-07500	280502-09300
15' (4572mm)	Left Hand	280501-07500	280501-10500
	Right Hand	280502-07500	280502-10500
16' (4877mm)	Left Hand	280501-07500	280501-11700
	Right Hand	280502-07500	280502-11700
17' (5182mm)	Left Hand	280501-07500	280501-12900
	Right Hand	280502-07500	280502-12900
18' (5486mm)	Left Hand	280501-07500	280501-14100
	Right Hand	280502-07500	280502-14100

-07 Low to Side Wiper



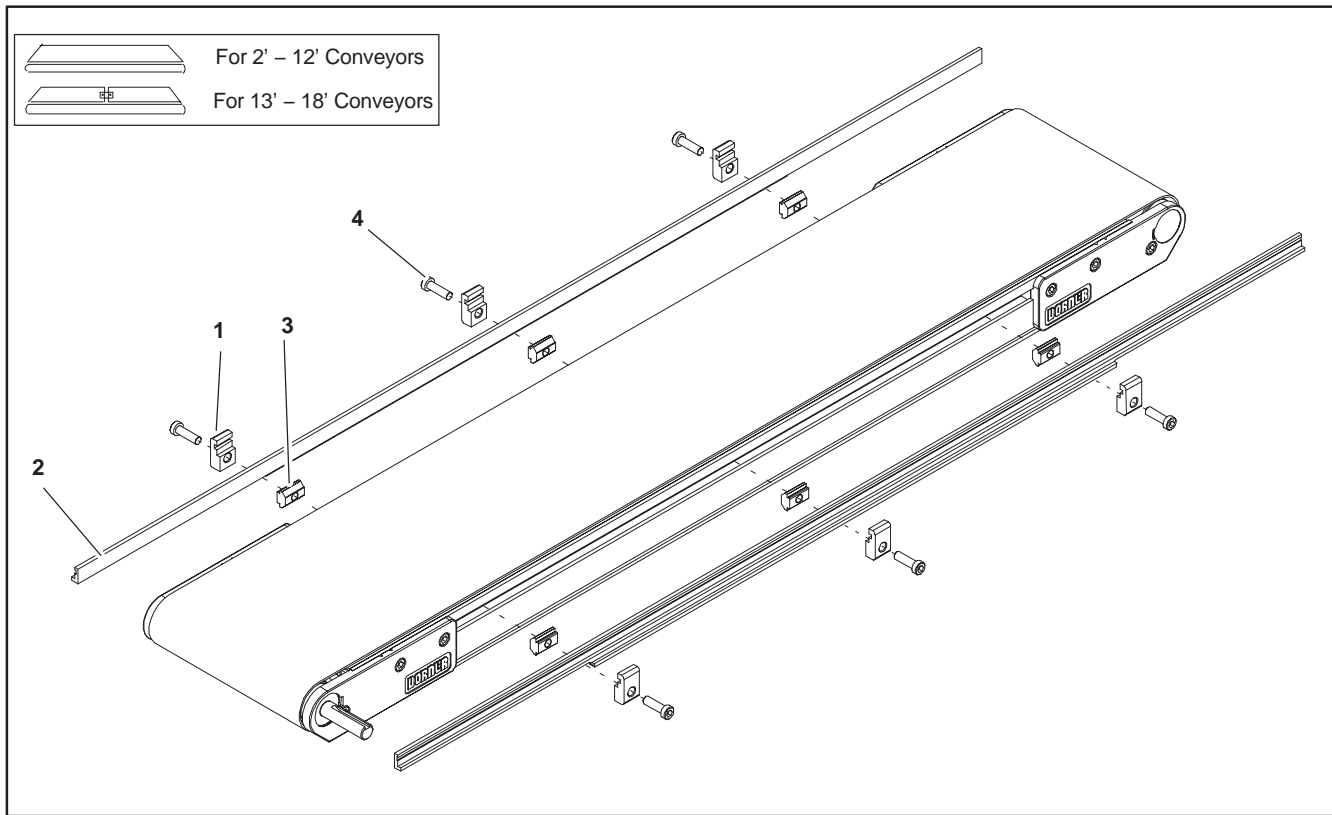
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 0.5" (13mm) HS
3	41-00-24	Side Wiper Nylatron (per foot)
4	639971MK10	Single Drop-in Tee Bar (x10)
5	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280903-02400	N/A
	Right Hand	280903-02400	N/A
3' (914mm)	Left Hand	280903-03600	N/A
	Right Hand	280903-03600	N/A
4' (1219mm)	Left Hand	280903-04800	N/A
	Right Hand	280903-04800	N/A
5' (1524mm)	Left Hand	280903-06000	N/A
	Right Hand	280903-06000	N/A
6' (1829mm)	Left Hand	280903-07200	N/A
	Right Hand	280903-07200	N/A
7' (2134mm)	Left Hand	280903-08400	N/A
	Right Hand	280903-08400	N/A
8' (2438mm)	Left Hand	280903-09600	N/A
	Right Hand	280903-09600	N/A
9' (2743mm)	Left Hand	280903-10800	N/A
	Right Hand	280903-10800	N/A
10' (3048mm)	Left Hand	280903-12000	N/A
	Right Hand	280903-12000	N/A

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
11' (3353mm)	Left Hand	280903-13200	N/A
	Right Hand	280903-13200	N/A
12' (3658mm)	Left Hand	280903-14400	N/A
	Right Hand	280903-14400	N/A
13' (3962mm)	Left Hand	280901-07500	280901-08100
	Right Hand	280902-07500	280902-08100
14' (4267mm)	Left Hand	280901-07500	280901-09300
	Right Hand	280902-07500	280902-09300
15' (4572mm)	Left Hand	280901-07500	280901-10500
	Right Hand	280902-07500	280902-10500
16' (4877mm)	Left Hand	280901-07500	280901-11700
	Right Hand	280902-07500	280902-11700
17' (5182mm)	Left Hand	280901-07500	280901-12900
	Right Hand	280902-07500	280902-12900
18' (5486mm)	Left Hand	280901-07500	280901-14100
	Right Hand	280902-07500	280902-14100

Service Parts

-09 Low to High Side

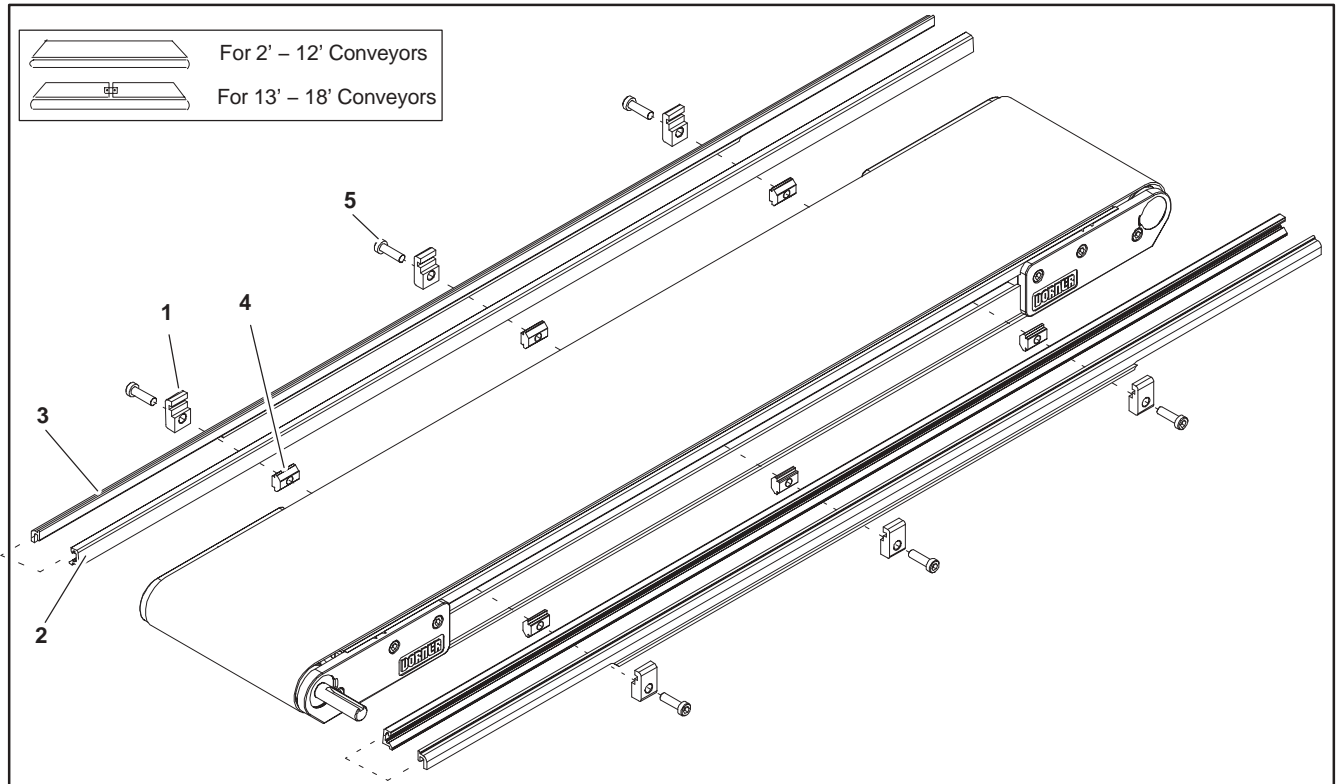


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 0.5" (13mm) HS
3	639971MK10	Single Drop-in Tee Bar (x10)
4	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	280903-02400	N/A
	Right Hand	280903-02400	N/A
3' (914mm)	Left Hand	280903-03600	N/A
	Right Hand	280903-03600	N/A
4' (1219mm)	Left Hand	280903-04800	N/A
	Right Hand	280903-04800	N/A
5' (1524mm)	Left Hand	280903-06000	N/A
	Right Hand	280903-06000	N/A
6' (1829mm)	Left Hand	280903-07200	N/A
	Right Hand	280903-07200	N/A
7' (2134mm)	Left Hand	280903-08400	N/A
	Right Hand	280903-08400	N/A
8' (2438mm)	Left Hand	280903-09600	N/A
	Right Hand	280903-09600	N/A
9' (2743mm)	Left Hand	280903-10800	N/A
	Right Hand	280903-10800	N/A
10' (3048mm)	Left Hand	280903-12000	N/A
	Right Hand	280903-12000	N/A
11' (3353mm)	Left Hand	280903-13200	N/A
	Right Hand	280903-13200	N/A

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
12' (3658mm)	Left Hand	280903-14400	N/A
	Right Hand	280903-14400	N/A
13' (3962mm)	Left Hand	280901-07500	280901-08100
	Right Hand	280902-07500	280902-08100
14' (4267mm)	Left Hand	280901-07500	280901-09300
	Right Hand	280902-07500	280902-09300
15' (4572mm)	Left Hand	280901-07500	280901-10500
	Right Hand	280902-07500	280902-10500
16' (4877mm)	Left Hand	280901-07500	280901-11700
	Right Hand	280902-07500	280902-11700
17' (5182mm)	Left Hand	280901-07500	280901-12900
	Right Hand	280902-07500	280902-12900
18' (5486mm)	Left Hand	280901-07500	280901-14100
	Right Hand	280902-07500	280902-14100

-10 0.5" (13mm) Extruded Plastic



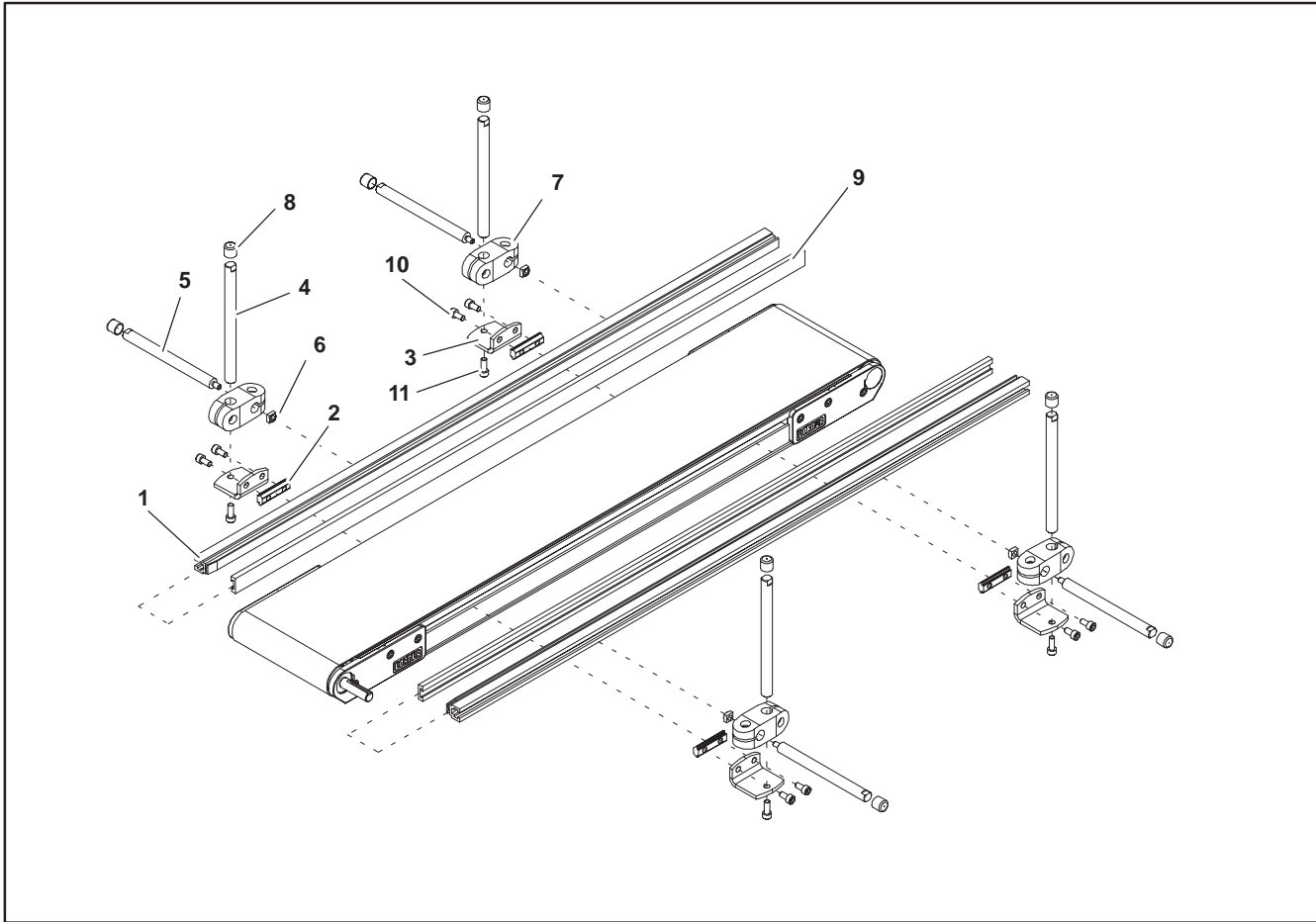
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	200054P	Snap-On Guide (per foot)
3	See Chart Below	2200 Guide
4	639971MK10	Single Drop-in Tee Bar (x10)
5	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
12' (3658mm)	Left Hand	281003-14400	N/A
	Right Hand	281003-14400	N/A
13' (3962mm)	Left Hand	281001-07500	281001-08100
	Right Hand	281002-07500	281002-08100
14' (4267mm)	Left Hand	281001-07500	281001-09300
	Right Hand	281002-07500	281002-09300
15' (4572mm)	Left Hand	281001-07500	281001-10500
	Right Hand	281002-07500	281002-10500
16' (4877mm)	Left Hand	281001-07500	281001-11700
	Right Hand	281002-07500	281002-11700
17' (5182mm)	Left Hand	281001-07500	281001-12900
	Right Hand	281002-07500	281002-12900
18' (5486mm)	Left Hand	281001-07500	281001-14100
	Right Hand	281002-07500	281002-14100

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	281003-02400	N/A
	Right Hand	281003-02400	N/A
3' (914mm)	Left Hand	281003-03600	N/A
	Right Hand	281003-03600	N/A
4' (1219mm)	Left Hand	281003-04800	N/A
	Right Hand	281003-04800	N/A
5' (1524mm)	Left Hand	281003-06000	N/A
	Right Hand	281003-06000	N/A
6' (1829mm)	Left Hand	281003-07200	N/A
	Right Hand	281003-07200	N/A
7' (2134mm)	Left Hand	281003-08400	N/A
	Right Hand	281003-08400	N/A
8' (2438mm)	Left Hand	281003-09600	N/A
	Right Hand	281003-09600	N/A
9' (2743mm)	Left Hand	281003-10800	N/A
	Right Hand	281003-10800	N/A
10' (3048mm)	Left Hand	281003-12000	N/A
	Right Hand	281003-12000	N/A
11' (3353mm)	Left Hand	281003-13200	N/A
	Right Hand	281003-13200	N/A

Service Parts

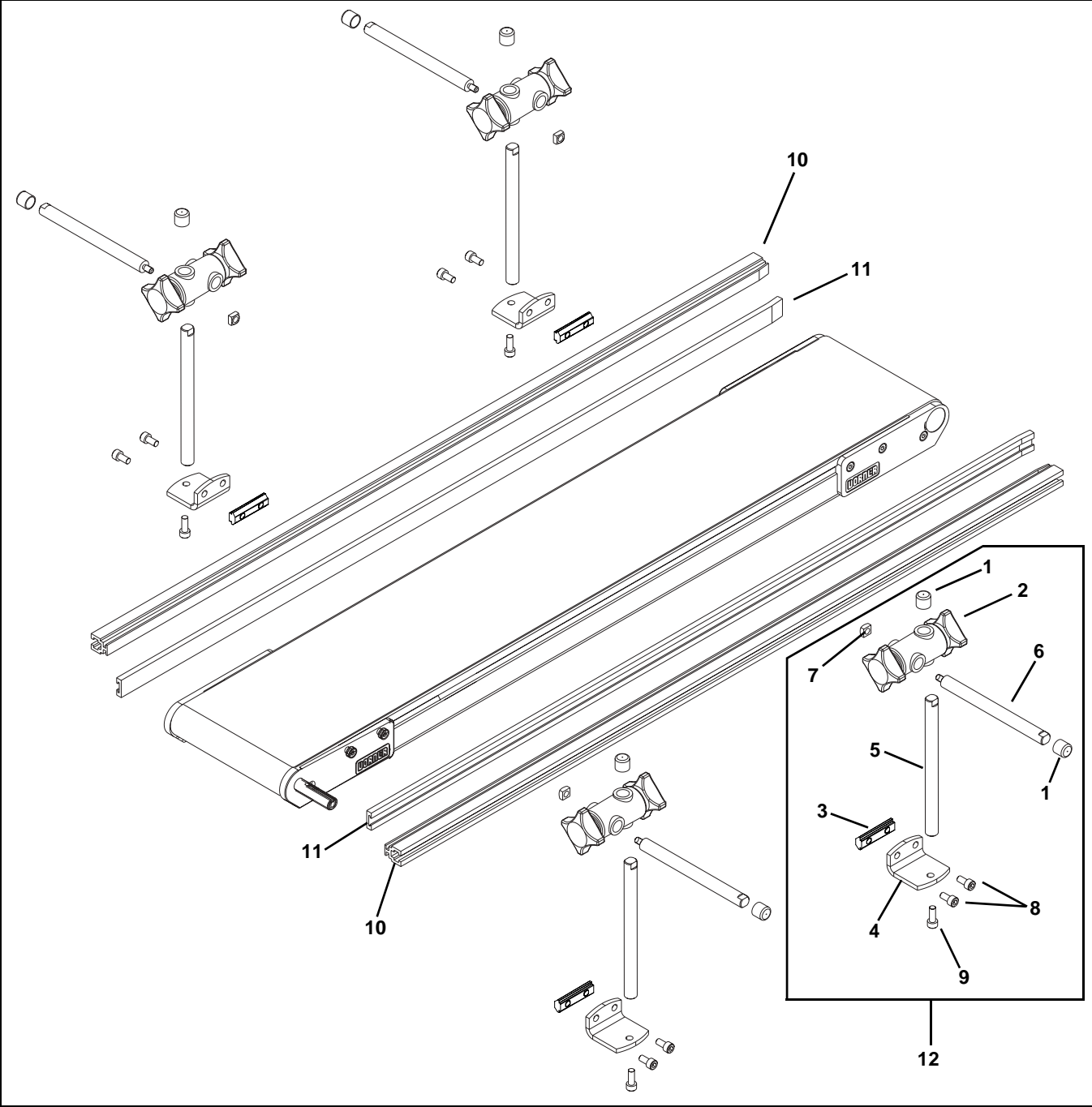
-13 Adjustable Guiding



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

Item	Part Number	Description
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 12 mm
11	920616M	Socket Head Screw M6 x 16 mm

-14 Tool-Less Adjustable Guiding



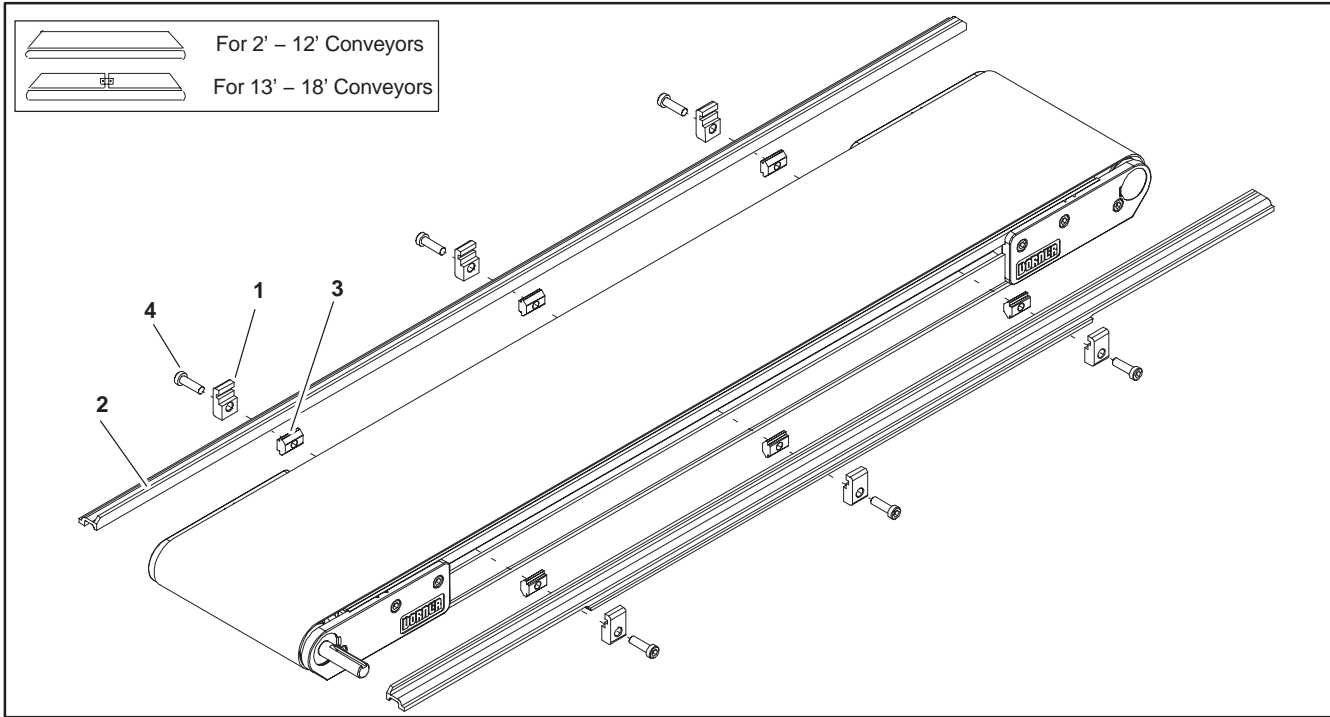
Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	200830M	Drop-In Tee Bar
4	202004M	Mounting Bracket
5	202027M	Vertical Mounting Guide Shaft
6	202028M	Horizontal Mounting Guide Shaft
7	674175MP	Square Nut, M6-1.00

Item	Part Number	Description
8	920612M	Socket Head Screw, M6-1.00 x 12 mm
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	460063-LLLLL	Aluminum Profile Guide
11	614068P-LLLLL	Extruded Guide
12	352056	Tool-Less Guiding Assembly (Includes items 1 thru 9)

LLLLL = Length in inches with 2 decimal places.
 Length Example: Length = 95.25" LLLLL = 09525

Service Parts

0.5" (13mm) Cleated Belt Guiding

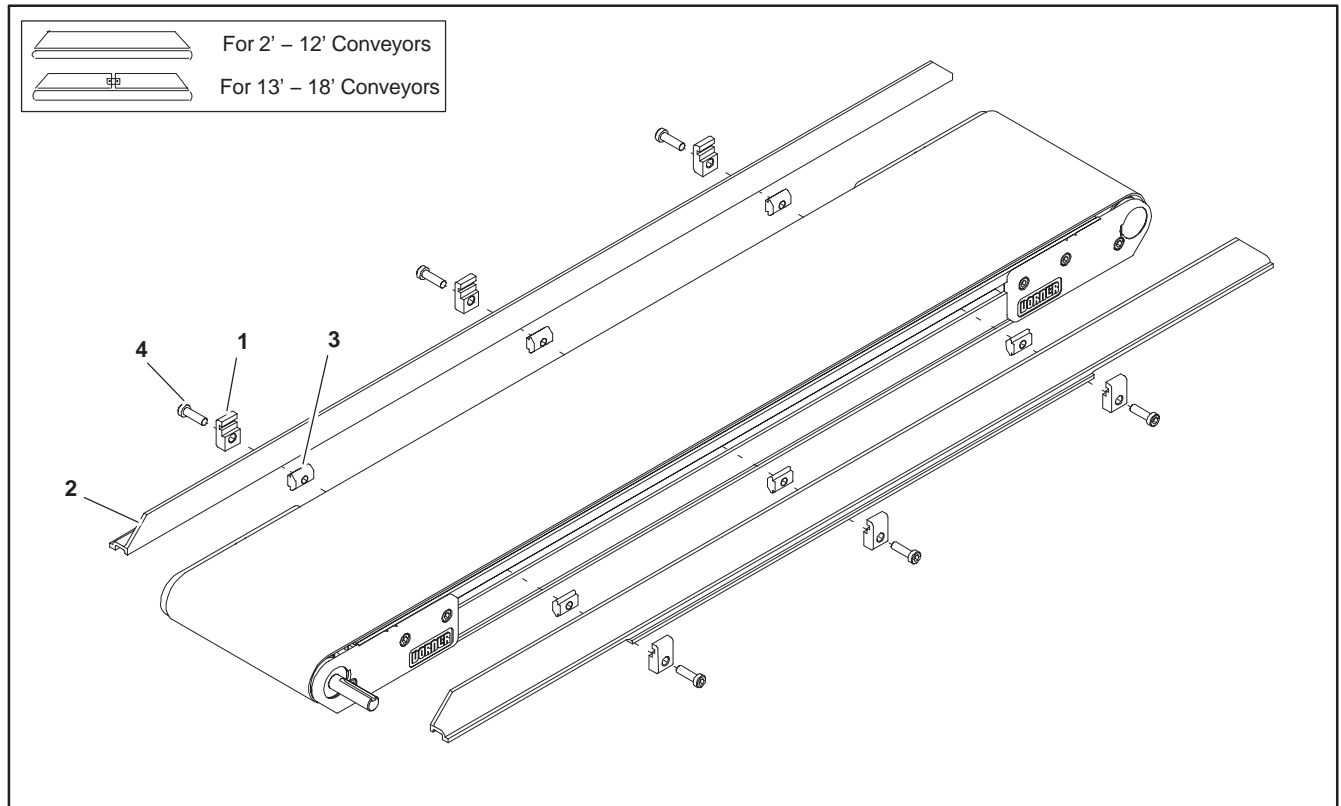


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide, 0.47" (13mm) Cleated
3	639971MK10	Drop-In Tee Bar (x10)
4	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
2' (610mm)	Left Hand	281603-02256	N/A
	Right Hand	281603-02256	N/A
3' (914mm)	Left Hand	281603-03456	N/A
	Right Hand	281603-03456	N/A
4' (1219mm)	Left Hand	281603-04656	N/A
	Right Hand	281603-04656	N/A
5' (1524mm)	Left Hand	281603-05856	N/A
	Right Hand	281603-05856	N/A
6' (1829mm)	Left Hand	281603-07056	N/A
	Right Hand	281603-07056	N/A
7' (2134mm)	Left Hand	281603-08256	N/A
	Right Hand	281603-08256	N/A
8' (2438mm)	Left Hand	281603-09456	N/A
	Right Hand	281603-09456	N/A
9' (2743mm)	Left Hand	281603-10656	N/A
	Right Hand	281603-10656	N/A
10' (3048mm)	Left Hand	281603-11856	N/A
	Right Hand	281603-11856	N/A
11' (3353mm)	Left Hand	281603-13056	N/A
	Right Hand	281603-13056	N/A
12' (3658mm)	Left Hand	281603-14256	N/A
	Right Hand	281603-14256	N/A

Item 2: 2200 Guide 0.5" (13mm) HS			
Length		End Guide	End Guide
13' (3962mm)	Left Hand	281601-07428	281601-08028
	Right Hand	281602-07428	281602-08028
14' (4267mm)	Left Hand	281601-07428	281601-09228
	Right Hand	281602-07428	281602-09228
15' (4572mm)	Left Hand	281601-07428	281601-10428
	Right Hand	281602-07428	281602-10428
16' (4877mm)	Left Hand	281601-07428	281601-11628
	Right Hand	281602-07428	281602-11628
17' (5182mm)	Left Hand	281601-07428	281601-12828
	Right Hand	281602-07428	281602-12828
18' (5486mm)	Left Hand	281601-07428	281601-14028
	Right Hand	281602-07428	281602-14028

1" (25mm) Cleated Belt Guiding



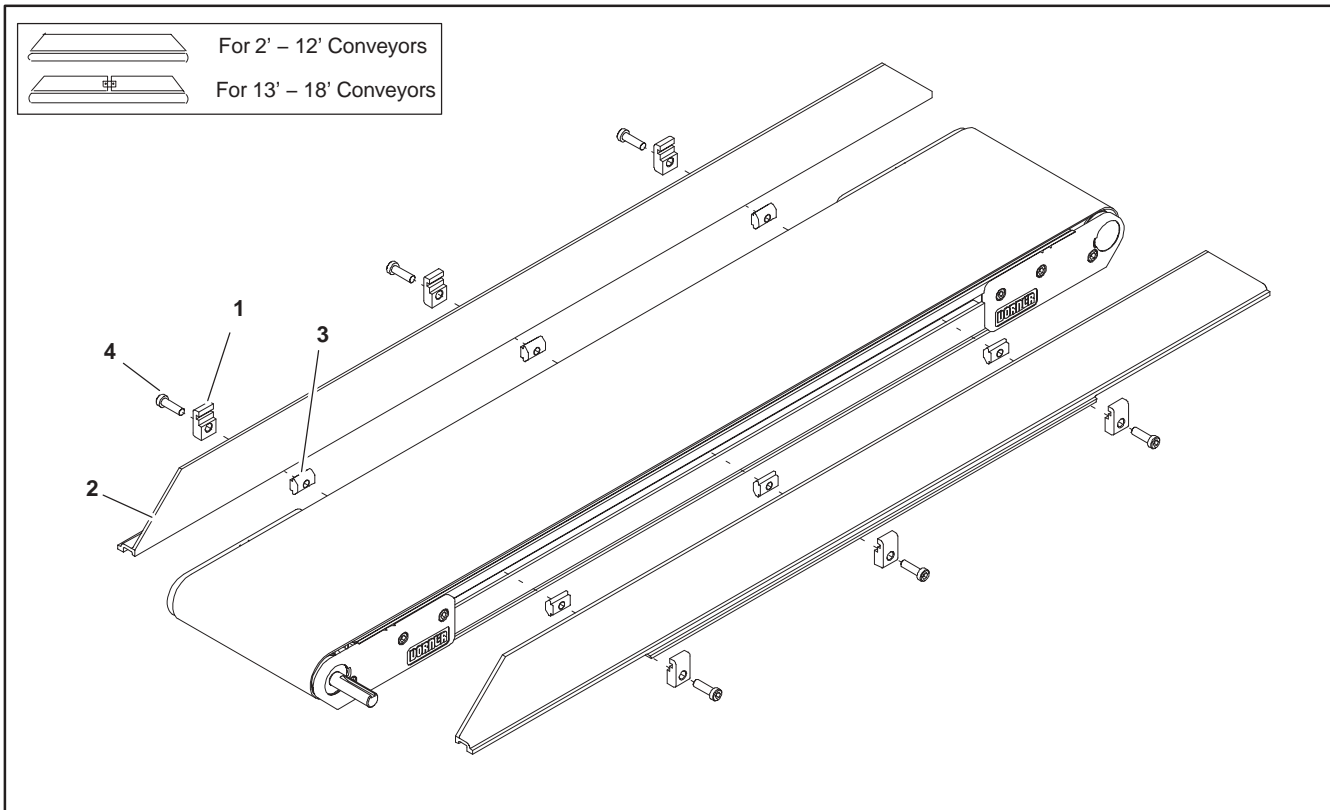
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 1" (25mm) Cleated
3	639971MK10	Drop-In Tee Bar (x10)
4	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
2' (610mm)	Left Hand	281703-02256	N/A
	Right Hand	281703-02256	N/A
3' (914mm)	Left Hand	281703-03456	N/A
	Right Hand	281703-03456	N/A
4' (1219mm)	Left Hand	281703-04656	N/A
	Right Hand	281703-04656	N/A
5' (1524mm)	Left Hand	281703-05856	N/A
	Right Hand	281703-05856	N/A
6' (1829mm)	Left Hand	281703-07056	N/A
	Right Hand	281703-07056	N/A
7' (2134mm)	Left Hand	281703-08256	N/A
	Right Hand	281703-08256	N/A
8' (2438mm)	Left Hand	281703-09456	N/A
	Right Hand	281703-09456	N/A
9' (2743mm)	Left Hand	281703-10656	N/A
	Right Hand	281703-10656	N/A
10' (3048mm)	Left Hand	281703-11856	N/A
	Right Hand	281703-11856	N/A
11' (3353mm)	Left Hand	281703-13056	N/A
	Right Hand	281703-13056	N/A

Item 2: 2200 Guide			
Length		End Guide	End Guide
12' (3658mm)	Left Hand	281703-14256	N/A
	Right Hand	281703-14256	N/A
13' (3962mm)	Left Hand	281701-07428	281701-08028
	Right Hand	281702-07428	281702-08028
14' (4267mm)	Left Hand	281701-07428	281701-09228
	Right Hand	281702-07428	281702-09228
15' (4572mm)	Left Hand	281701-07428	281701-10428
	Right Hand	281702-07428	281702-10428
16' (4877mm)	Left Hand	281701-07428	281701-11628
	Right Hand	281702-07428	281702-11628
17' (5182mm)	Left Hand	281701-07428	281701-12828
	Right Hand	281702-07428	281702-12828
18' (5486mm)	Left Hand	281701-07428	281701-14028
	Right Hand	281702-07428	281702-14028

Service Parts

2" (51mm) Cleated Belt Guiding

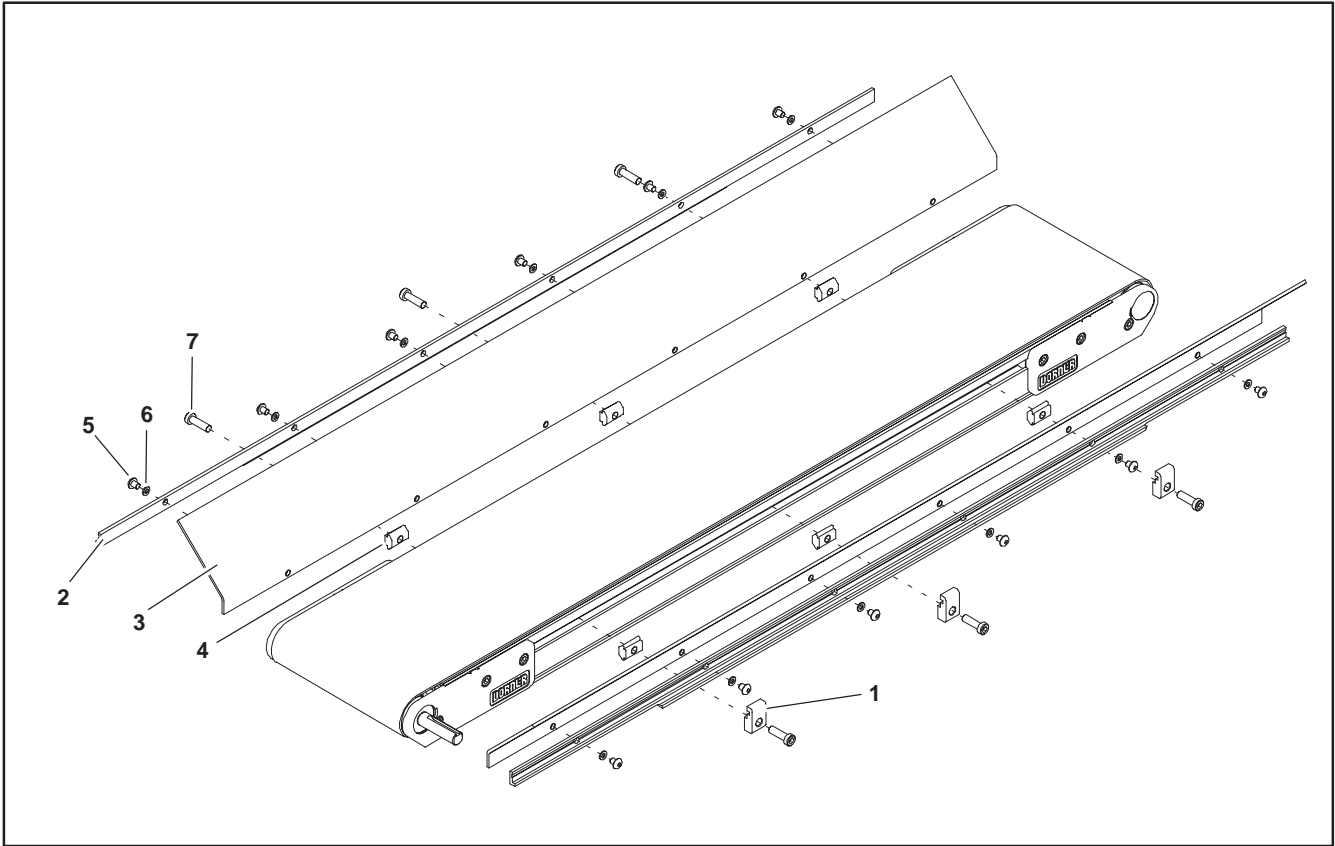


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2200 Guide 2.3" Cleated
3	639971MK10	Drop-In Tee Bar (x10)
4	950620M	Low Head Cap Screw M6 x 20 mm

Item 2: 2200 Guide			
Length		End Guide	End Guide
2' (610mm)	Left Hand	281903-02256	N/A
	Right Hand	281903-02256	N/A
3' (914mm)	Left Hand	281903-03456	N/A
	Right Hand	281903-03456	N/A
4' (1219mm)	Left Hand	281903-04656	N/A
	Right Hand	281903-04656	N/A
5' (1524mm)	Left Hand	281903-05856	N/A
	Right Hand	281903-05856	N/A
6' (1829mm)	Left Hand	281903-07056	N/A
	Right Hand	281903-07056	N/A
7' (2134mm)	Left Hand	281903-08256	N/A
	Right Hand	281903-08256	N/A
8' (2438mm)	Left Hand	281903-09456	N/A
	Right Hand	281903-09456	N/A
9' (2743mm)	Left Hand	281903-10656	N/A
	Right Hand	281903-10656	N/A
10' (3048mm)	Left Hand	281903-11856	N/A
	Right Hand	281903-11856	N/A
11' (3353mm)	Left Hand	281903-13056	N/A
	Right Hand	281903-13056	N/A

Item 2: 2200 Guide			
Length		End Guide	End Guide
12' (3658mm)	Left Hand	281903-14256	N/A
	Right Hand	281903-14256	N/A
13' (3962mm)	Left Hand	281901-07428	281901-08028
	Right Hand	281902-07428	281902-08028
14' (4267mm)	Left Hand	281901-07428	281901-09228
	Right Hand	281902-07428	281902-09228
15' (4572mm)	Left Hand	281901-07428	281901-10428
	Right Hand	281902-07428	281902-10428
16' (4877mm)	Left Hand	281901-07428	281901-11628
	Right Hand	281902-07428	281902-11628
17' (5182mm)	Left Hand	281901-07428	281901-12828
	Right Hand	281902-07428	281902-12828
18' (5486mm)	Left Hand	281901-07428	281901-14028
	Right Hand	281902-07428	281902-14028

Flared Side Guiding

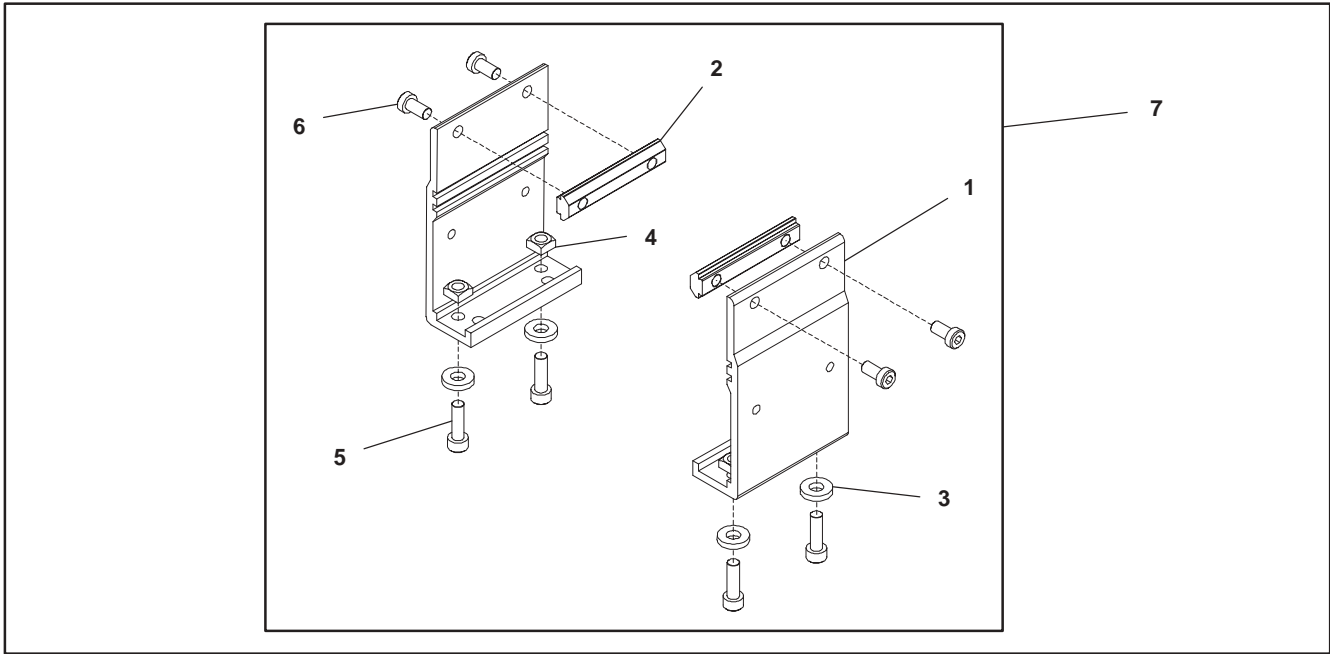


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	202212	Side-Flare Mounting Guide 2' (610mm)
	202213	Side-Flare Mounting Guide 3' (914mm)
	202214	Side-Flare Mounting Guide 4' (1219mm)
	202215	Side-Flare Mounting Guide 5' (1524mm)
	202216	Side-Flare Mounting Guide 6' (1829mm)

Item	Part Number	Description
3	202522M	Flared Guide 45° 2' (610mm)
	202523M	Flared Guide 45° 3' (914mm)
	202523M	Flared Guide 45° 4' (1219mm)
	202523M	Flared Guide 45° 5' (1524mm)
	202523M	Flared Guide 45° 6' (1829mm)
4	639971M	Drop-In Tee Bar
5	910506M	Button Head Screw M5 x 6 mm
6	911-512	Washer
7	950620M	Low Head Cap Screw M6 x 20 mm

Service Parts

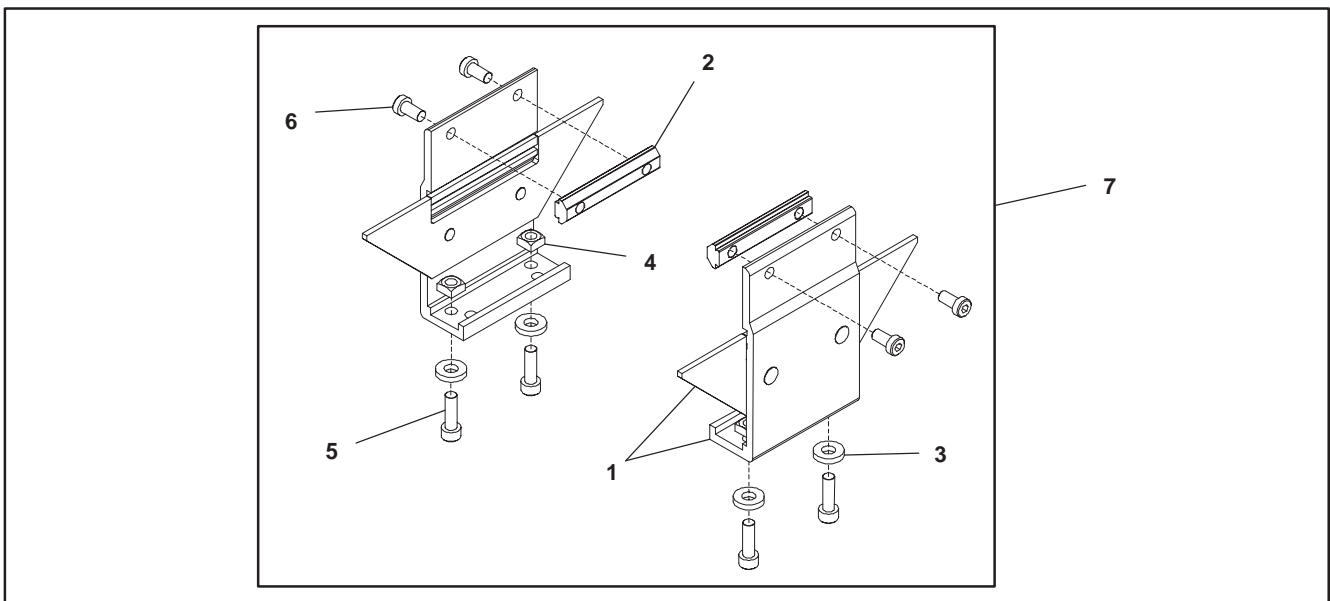
Flat Belt Stand Mount Assembly



Item	Part Number	Description
1	240831	Stand Mount
2	300150MK4	Drop-In Tee Bar (x4)
3	605279P	Washer
4	807-920	Square Nut M6

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20 mm
6	950612M	Low Head Cap Screw M6 x 12 mm
7	240839	Flat Belt Stand Mount Assembly

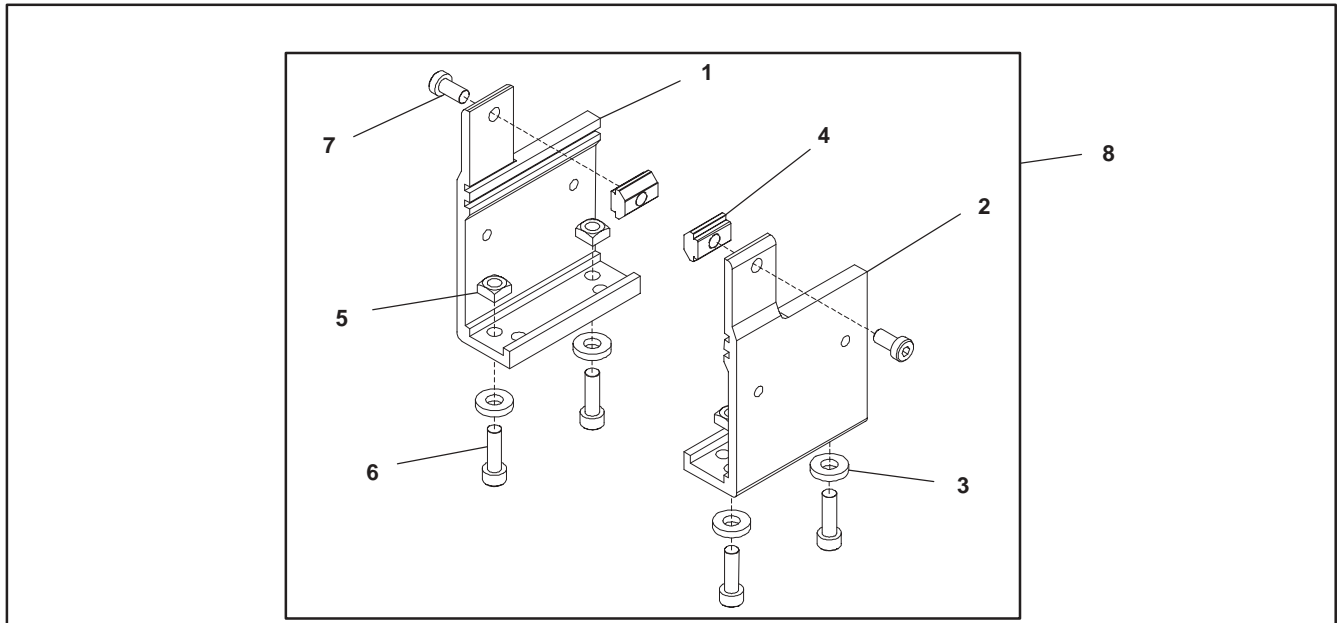
Cleated Belt Stand Mount Assembly



Item	Part Number	Description
1	240836	Cleated Mount Assembly
2	300150MK4	Drop-In Tee Bar (x4)
3	605279P	Washer
4	807-920	Square Nut M6

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20 mm
6	950612M	Low Head Cap Screw M6x12 mm
7	240838	Cleated Stand Mount Assembly

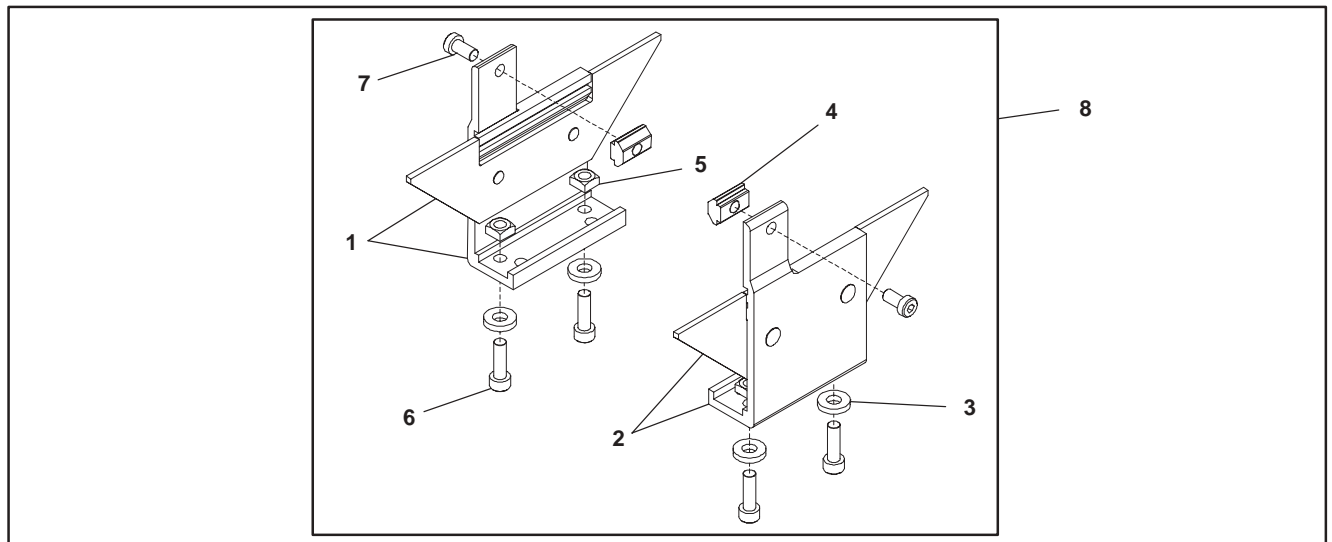
Flat Belt Stand Mount Assembly for 2' (610mm) Conveyors



Item	Part Number	Description
1	240833	Stand Mount, LH 2' (610mm)
2	240834	Stand Mount, RH 2' (610mm)
3	605279P	Washer
4	639971MK10	Drop-In Tee Bar (x10)

Item	Part Number	Description
5	807-920	Square Nut M6
6	920620M	Socket Head Screw M6 x 20 mm
7	950612M	Low Head Cap Screw M6 x 12 mm
8	240847	Flat Belt Stand Mount Assembly for 2' (610mm) Conveyors

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

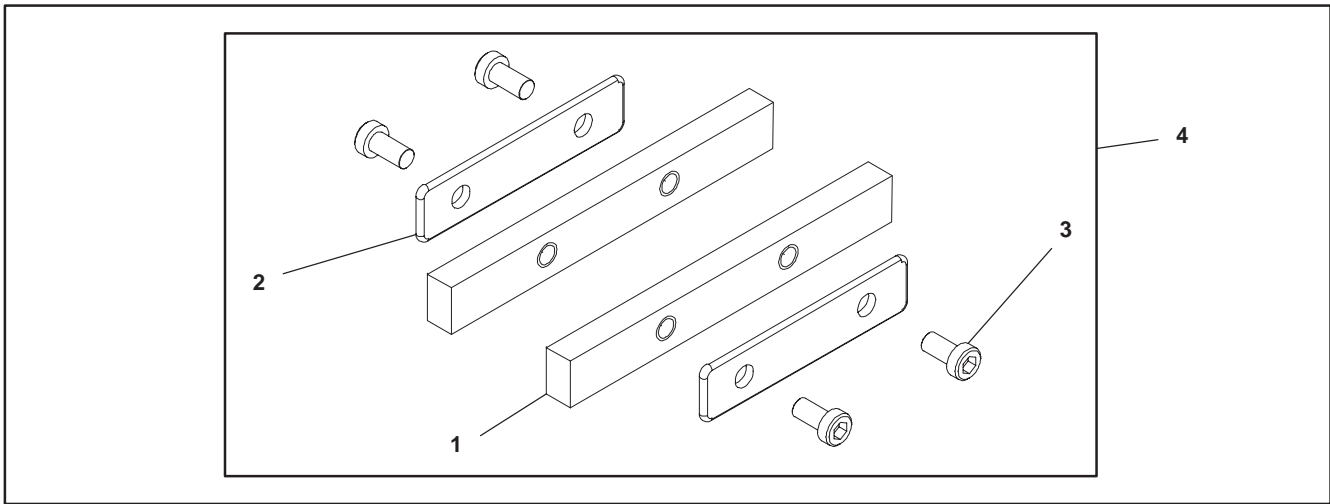


Item	Part Number	Description
1	240852	Cleated Stand Bracket Assembly LH 2' (610mm) Conveyor
2	240853	Cleated Stand Bracket Assembly RH 2' (610mm) Conveyor
3	605279P	Washer
4	639971MK10	Drop-In Tee Bar (x10)

Item	Part Number	Description
5	807-920	Square Nut M6
6	920620M	Socket Head Screw M6 x 20 mm
7	950612M	Low Head Cap Screw M6 x 12 mm
8	240851	Cleated Belt Stand Mount Assembly for 2' (610mm) Conveyors

Service Parts

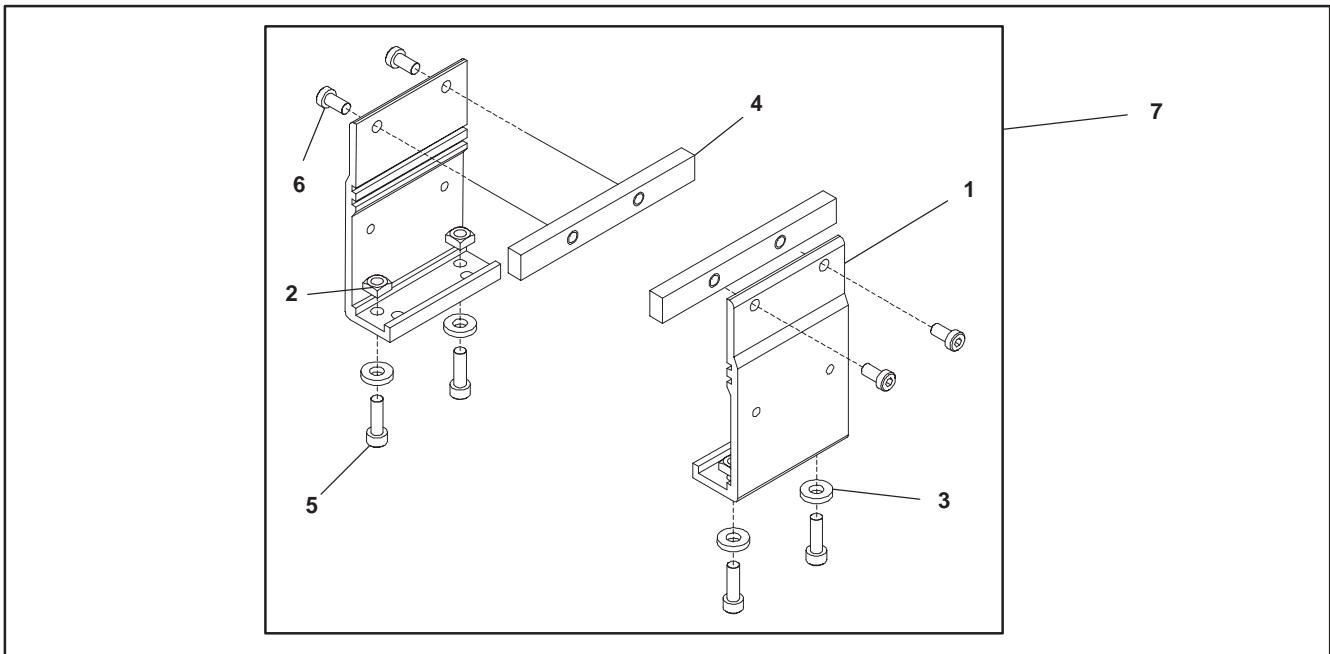
Connecting Assembly without Stand Mount



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

Item	Part Number	Description
3	950612M	Low Head Cap Screw M6 x 12 mm
4	240861	Connecting Assembly without Stand Mounts

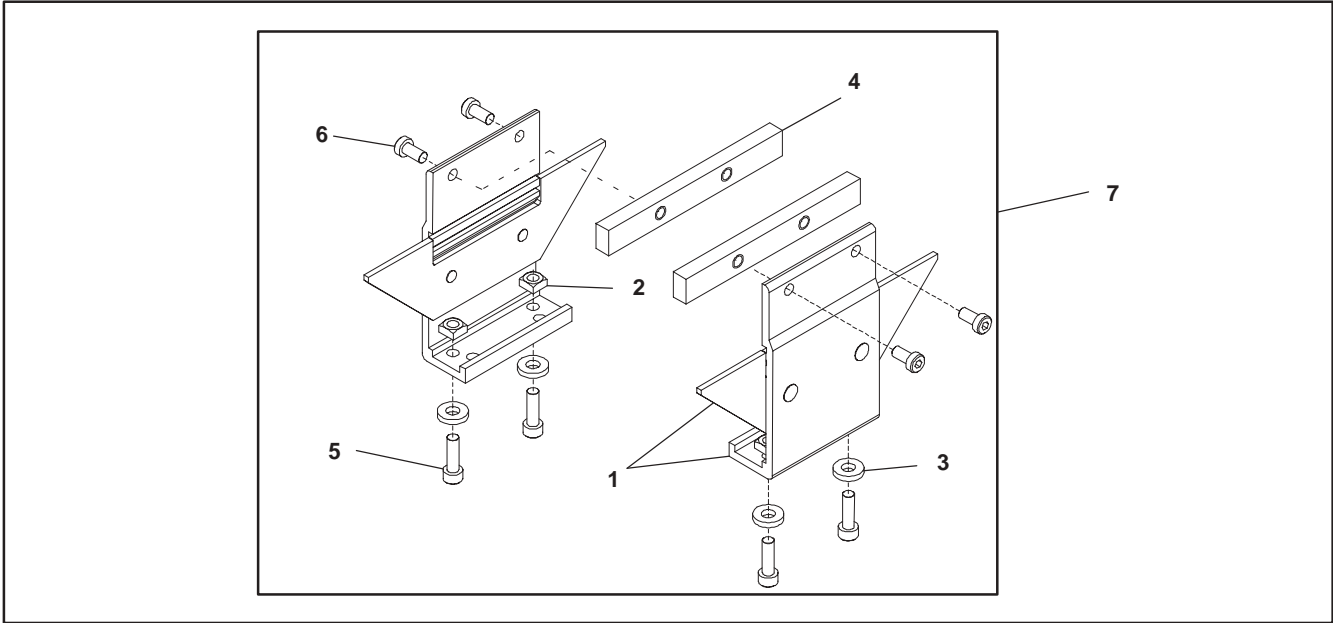
Flat Belt Connecting Assembly with Stand Mount



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

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20 mm
6	950616M	Low Head Cap Screw M6 x 16 mm
7	240860	Flat Belt Connecting Assembly with Stand Mounts

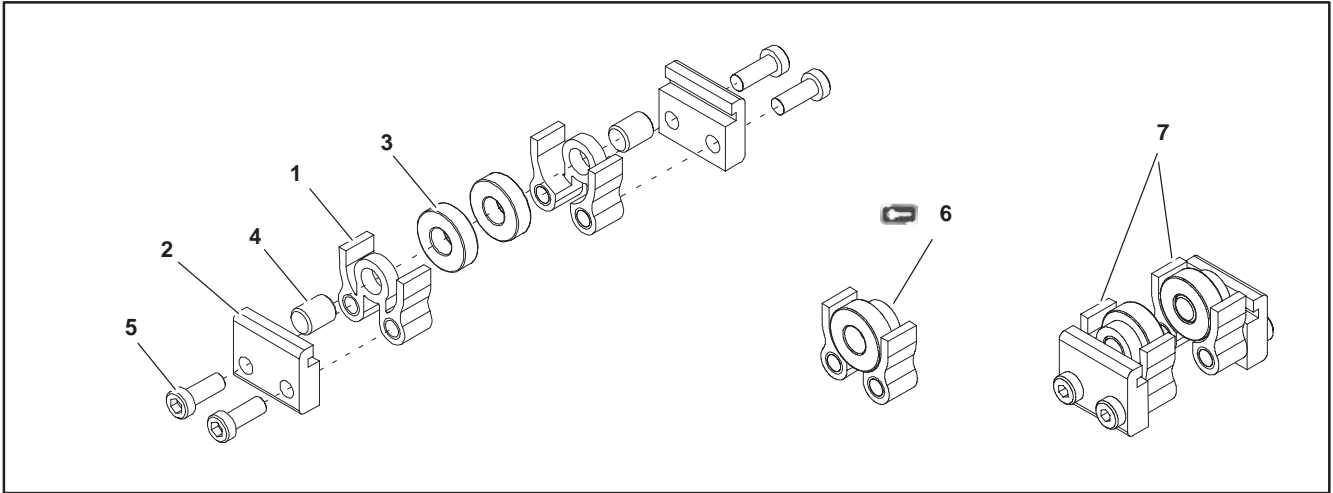
Cleated Belt Connecting Assembly with Stand Mount



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

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20 mm
6	950616M	Low Head Cap Screw M6 x 16 mm
7	240863	Cleated Belt Connecting Assembly with Stand Mounts

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

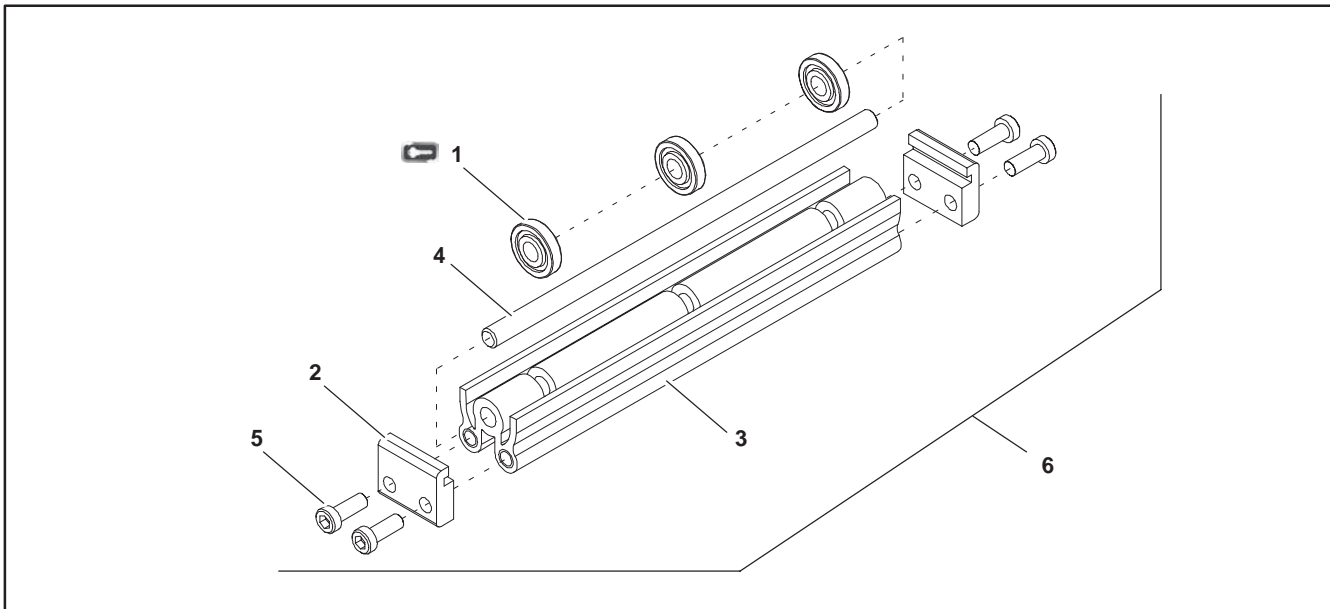


Item	Part Number	Description
1	240825	Return Roller Guard – Short
2	240827	Return Roller Clip
3	802-027	Bearing
4	913-100	Dowel Pin

Item	Part Number	Description
5	950616M	Low Head Cap Screw M6 x 16 mm
6	240840	Roller Assembly (Includes Items 1, 3 and 4)
7	240830	2" (51mm) to 6" (152mm) Flat Belt Return Roller Assembly

Service Parts

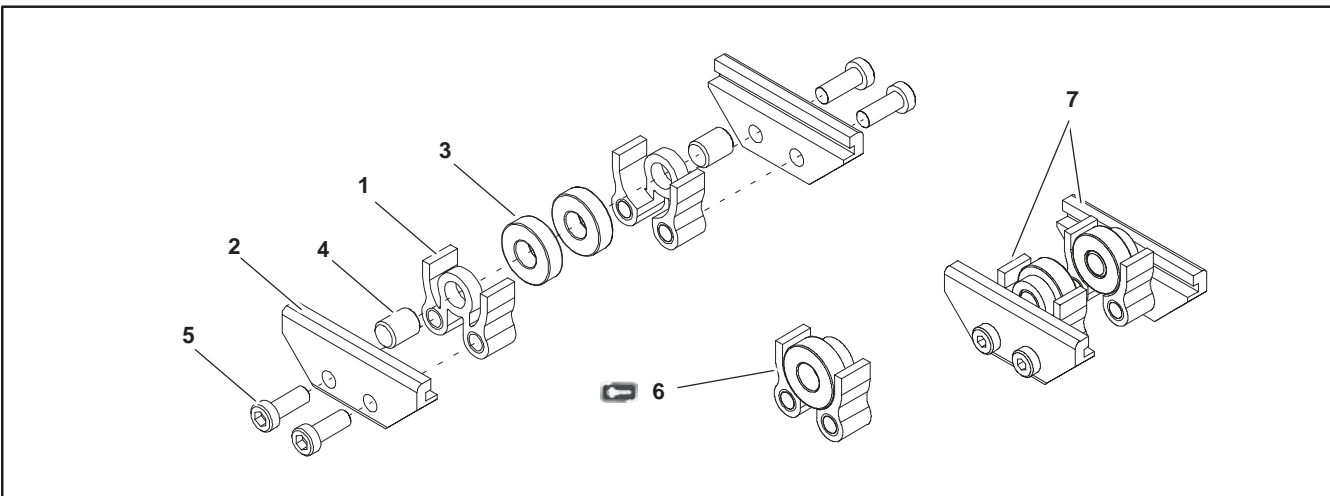
8" (203mm) to 24" (610mm) Flat Belt Return Roller



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

Item	Part Number	Description
5	950616M	Low Head Cap Screw M6 x 16 mm
6	2408 WW	8" (203mm) to 24" (610mm) Flat Belt Return Roller Assembly
WW . = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24		

Cleated Belt Return Roller



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

Item	Part Number	Description
5	950616M	Low Head Cap Screw M6 x 16 mm
6	240840	Roller Assembly (Includes Items 1, 3 and 4)
7	240832	Cleated Belt Return Roller Assembly

Conveyor Belt Part Number Configuration

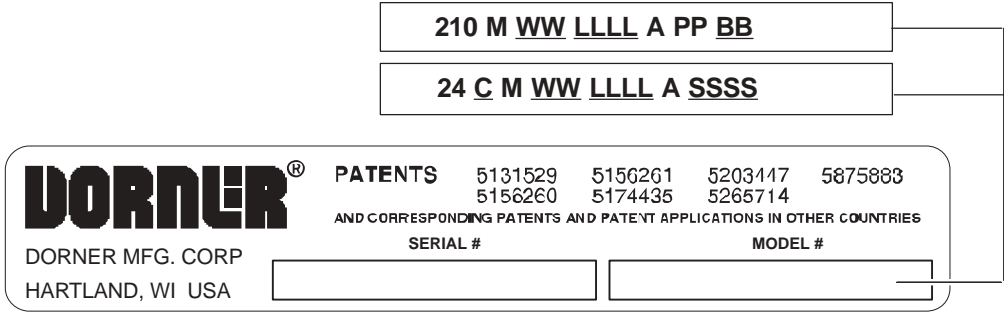


Figure 45

Flat Belt Part Number Configuration

Refer to Dorner patent plate (Figure 45). From the model number, determine conveyor width (“WW”), length (“LLLL”) and belt type (“BB”). Use data to configure belt part number as indicated below. *Add “V” for V-guided belts.

22 - WW LLLL / BB V *

22 - _____ / ____ V*

(Fill In)

Cleated Belt Part Number Configuration

Refer to Dorner patent plate (Figure 45). From the model number, determine conveyor type (“T”), width (“WW”), length (“LLLL”), cleat type (“C”) and cleat spacing (“SSSS”). Use data to configure belt part number as indicated below. *Add “V” for V-guided belts.

2T - WW LLLL C SSSS V *

2 - _____ / _____ V*

(Fill In)

Return Policy

Returns must have prior written factory authorization or they will not be accepted. Items that are returned to Dorner without authorization will not be credited nor returned to the original sender. 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. Dorner part number(s) of 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 (if available, part serial number).

A representative will discuss action to be taken on the returned items and provide a Returned Goods Authorization (RMA) number for reference. RMA will automatically close 30 days after being issued. To get credit, items must be new and undamaged. There will be a return charge on all items returned for credit, where Dorner was not at fault. It is the customer's responsibility to prevent damage during return shipping. Damaged or modified items will not be accepted. The customer is responsible for return freight.


Product Type									
Standard Products									Engineered to order parts
Product Line	Conveyors	Gearmotors & Mounting Packages	Support Stands	Accessories	Spare Parts (non-belt)	Spare Belts - Standard Flat Fabric	Spare Belts - Cleated & Specialty Fabric	Spare Belts - Plastic Chain	All equipment and parts
1100	30% return fee for all products except: 50% return fee for conveyors with modular belt, cleated belt or specialty belts						non-returnable		case-by-case
2200									
2200 Modular Belt									
2200 Precision Move									
2300									
2300 Modular Belt									
3200									
3200 LPZ									
3200 Precision Move									
4100									
5200									
5300									
6200									
Controls									
7200 / 7300	50% return fee for all products								
7350	non-returnable								
7360									
7400									
7600									

Returns will not be accepted after 60 days from original invoice date. The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components 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. Contact Dorner for the name of your local representative. Our Customer Service Team will gladly help with your questions on Dorner products.

For a copy of Dorner's 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.

 <p>Dorner Mfg. Corp. reserves the right to change or discontinue products without notice. All products and services are covered in accordance with our standard warranty. All rights reserved. © Dorner Mfg. Corp. 2015</p>	<p>DORNER MFG. CORP. 975 Cottonwood Ave., PO Box 20 Hartland, WI 53029-0020 USA TEL 1-800-397-8664 (USA) FAX 1-800-369-2440 (USA) Internet: www.dorner.com</p>	<p>Outside the USA: TEL 1-262-367-7600 FAX 1-262-367-5827</p>
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