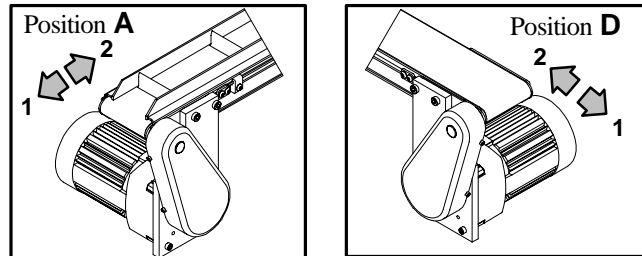


Mounting Package Assembly Instructions

2100 Bottom Mounting Packages 2375M or 2675M

This mounting package can be setup in either one of two positions (A or D, Figure 1).



**Figure 1: Cleated Belt (left) & Flat Belt (right);
Three-phase Motor shown**

In addition, the conveyor belt can be driven in either one of two directions (1 or 2, Figure 2). Arrows show belt travel direction.

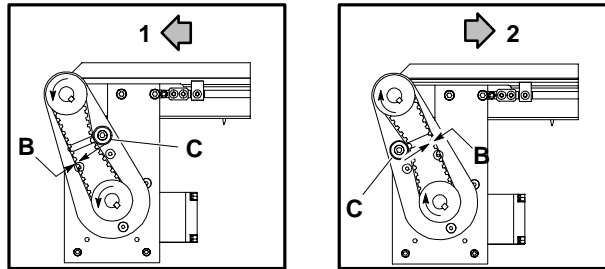


Figure 2

NOTE:

Item numbers, shown below, correspond with those shown in Figure 3 and on backside of instruction sheet.

1. Remove and discard the original two tail plate screws (E) from the outboard shaft side of the conveyor assembly.
2. The gearmotor and mounting plate (5) are shipped already assembled. Attach the assembly to the conveyor using the 8 mm x 12 mm socket head shoulder screws (22).

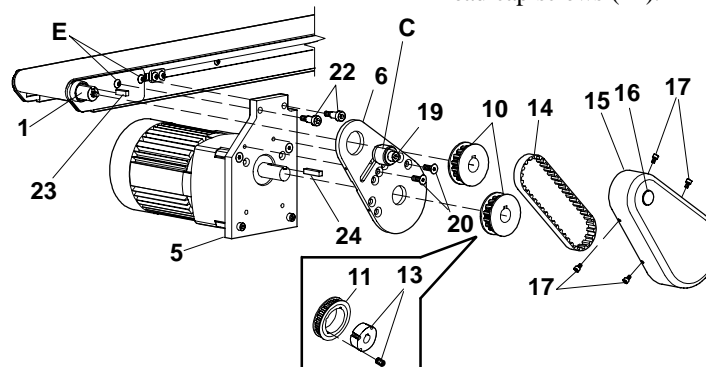


Figure 3: Sample Flat Belt Bottom Drive

NOTE:

Be sure to tighten socket head shoulder screws with 80 in-lb (9 Nm) torque.

3. Attach back guard plate (6) to the mounting plate using two M6-1.0 x 18 mm flat head cap screws (20).
4. Assemble drive and driven pulleys (10 or 11) and timing belt (14). Place a square key (23) into the keyway of the outboard shaft assembly (1) and a square key (24) in the keyway of the gearmotor. Install pulleys so that timing belt is centered on the belt tensioning roller assembly pulleys are in line with each other. Tighten the pulley set screws or Taper Lock® bushing screws (13), which fasten pulleys to the shafts. Determine which direction the conveyor belt is traveling and position the tensioning roller assembly (C) (Figure 2) accordingly.
5. Adjust timing belt tension by loosening the M8 x 40 mm socket head cap screw (19) and sliding the belt tensioning roller assembly (C) against the belt. Tension should be measured at mid-point (B) on the tension side of the timing belt. As a starting point for the tensioning process, there should be 1/8" (3 mm) deflection with 1 lb (500 g or 4.3 N) of force.
6. Every timing belt application exhibits its own individual operating characteristics. The optimum timing belt tension should be determined experimentally.

If necessary, continue to slide the tensioning bearing assembly against the timing belt until the belt is tensioned so as to prevent jumping of teeth under the most severe conditions which the drive will encounter. Tighten M8 x 40 mm socket head cap screw after tension requirements are achieved.

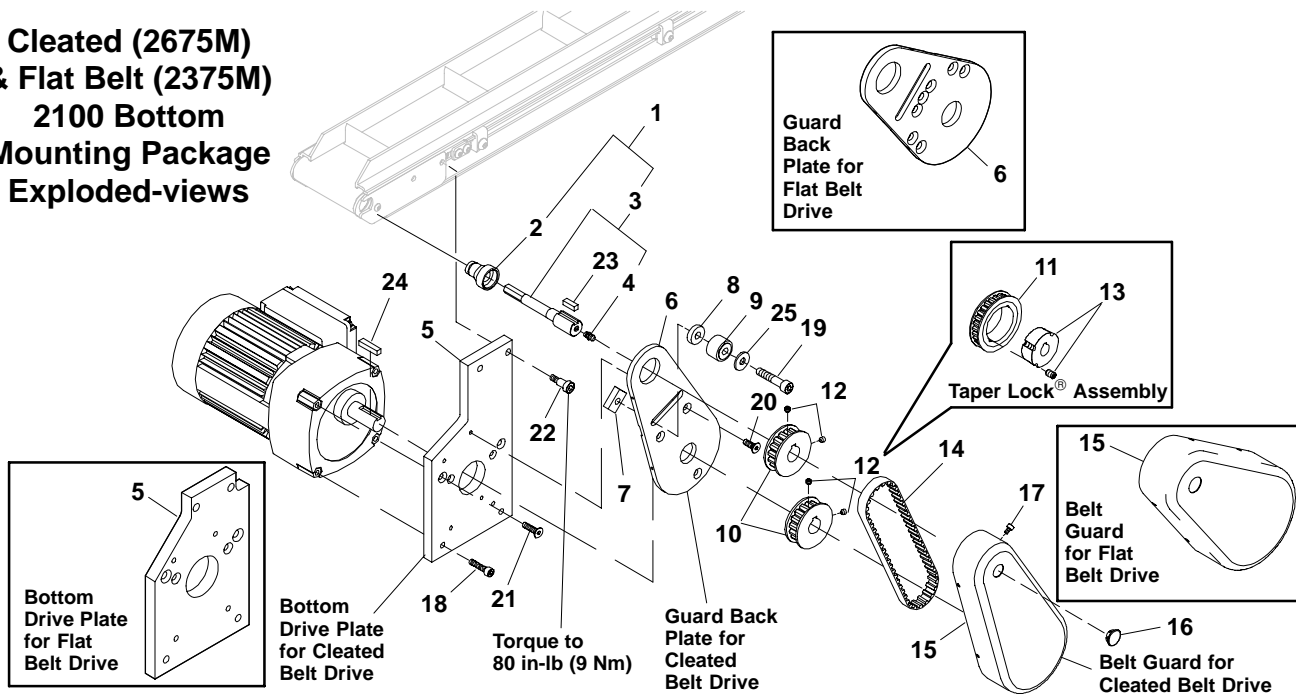
IMPORTANT:

Do not over tension the timing belt. Over tensioning may cause reduced belt life or bearing and drive damage.

7. Attach belt guard (15) using four (4) M4 x 6 mm socket head cap screws (17).

Mounting Package Assembly Instructions

Cleated (2675M) & Flat Belt (2375M) 2100 Bottom Mounting Package Exploded-views



Item	Part No.	Part Description
1	204003M	Outboard Shaft Ass'y 2" (44 mm)
	204004M	Outboard Shaft Ass'y 3" (70 mm)
	204005M	Outboard Shaft Ass'y 4 to 24" (95 to 610 mm)
2	200223	Outboard Bearing Retaining Sleeve
3	204732M	Drive Shaft Ass'y 2" (44 mm)
	204733M	Drive Shaft Ass'y 3" (70 mm)
	204734M	Drive Shaft Ass'y 4 to 24" (95 to 610 mm)
4	810-292	Grease Fitting, M6-1.0 Straight [All Sizes Except 2" (44 mm)]
5	210037M	Bottom Drive Plate (for Flat Belt Drive)
	210045M	Bottom Drive Plate (for Cleated Belt Drive)
6	200375M	Guard Back Plate (for Flat Belt Drive)
	200378M	Guard Back Plate (for Cleated Belt Drive)
7	609424M	Tensioning Bearing Nut
8	609425	Cam Follower Spacer
9	802-046	Tensioning Bearing
10	603394M	Pulley, 12 Tooth, 19 mm Bore
	613391M	Pulley, 14 Tooth, 19 mm Bore
	605222M	Pulley, 16 Tooth, 19 mm Bore
11	811-101	Pulley, 18 Tooth, Taper Lock®-TL1108
	811-103	Pulley, 20 Tooth, Taper Lock®-TL1008
	811-115	Pulley, 22 Tooth, Taper Lock®-TL1008
	611934	Pulley, 26 Tooth, Taper Lock®-TL1210
	611935	Pulley, 28 Tooth, Taper Lock®-TL1610
	611936	Pulley, 30 Tooth, Taper Lock®-TL1610
12	970405M	Cup Set Screw, M4-0.70 x 5 mm
	970605M	Cup Set Screw, M6-1.0 x 5 mm

Item	Part No.	Part Description
13	611929M	Taper Lock® Bushing- TL1210, 19 mm Bore
	611932M	Taper Lock® Bushing- TL-1610, 19 mm Bore
	811-203	Taper Lock® Bushing- TL1008, 19 mm Bore
	811-204	Taper Lock® Bushing- TL1108, 19 mm Bore
14	814-021	Timing Belt, 15.00" (381.00 mm) Long
	814-052	Timing Belt, 15.75" (400.05 mm) Long
	814-044	Timing Belt, 16.50" (419.10 mm) Long
	814-053	Timing Belt, 17.25" (438.15 mm) Long
	814-054	Timing Belt, 17.63" (447.80 mm) Long
	814-022	Timing Belt, 18.75" (476.25 mm) Long
	814-051	Timing Belt, 19.50" (495.30 mm) Long
	814-023	Timing Belt, 21.00" (533.40 mm) Long
15	814-055	Timing Belt, 21.75" (552.45 mm) Long
15	200376M	Timing Belt Guard (for Flat Belt Drive)
	200377M	Timing Belt Guard (for Cleated Belt Drive)
16	807-226	Plastic Plug
17	920406M	Socket Head Cap Screw, M4-0.70 x 6 mm
18	920625M	Socket Head Cap Screw, M6-1.0 x 25 mm
19	920840M	Socket Head Cap Screw, M8-1.25 x 40 mm
20	930618M	Flat Head Cap Screw, M6-1.0 x 18 mm
21	930625M	Flat Head Cap Screw, M5-1.0 x 25 mm
22	940812M	Socket Head Shoulder Screw, 8 mm x 12 mm
23	980018M	Square Key (Undersized), 6 mm x 18 mm
24	980625M	Square Key, 6 mm x 25 mm
25	911-008	SAE Flat Washer 5/16"

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