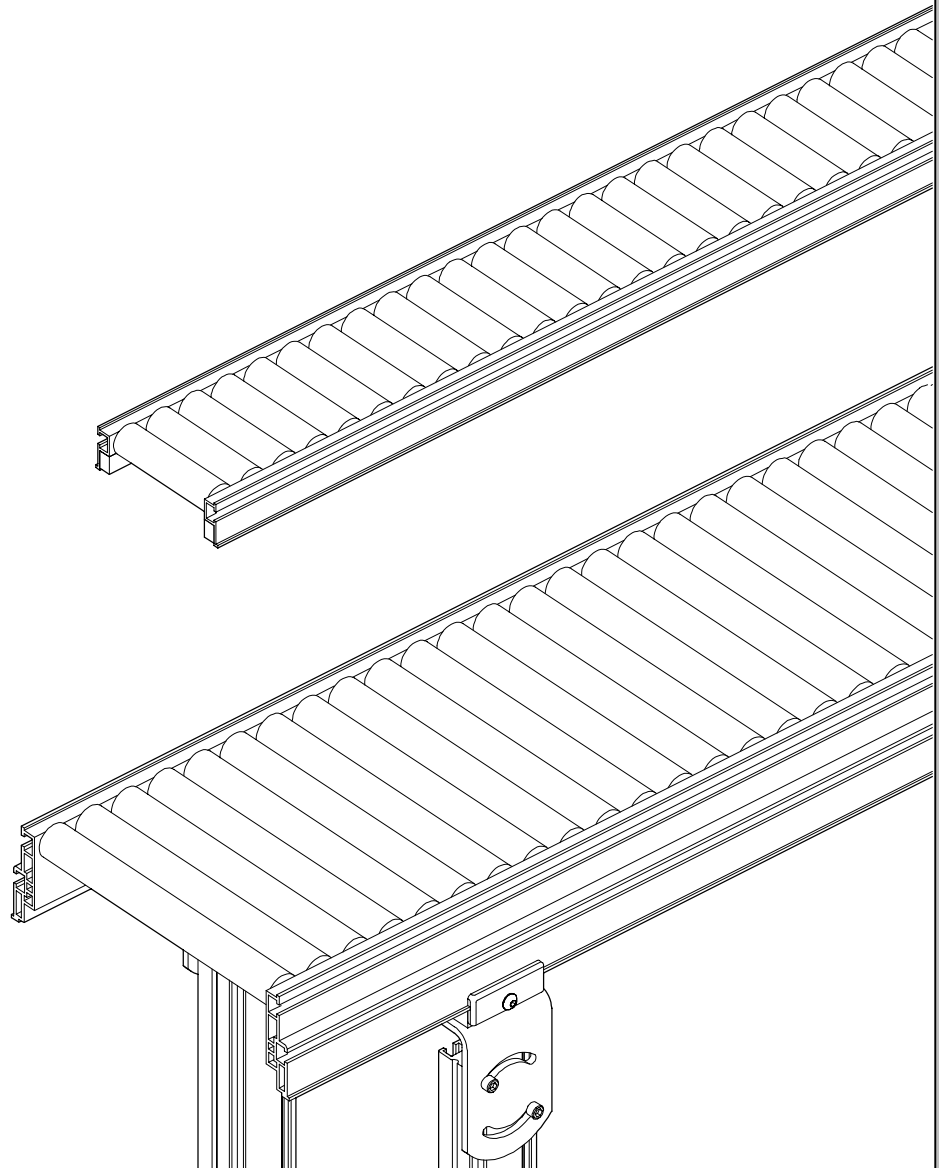


# Gravity Roller Conveyors

## Service Parts and Assembly Manual





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## Replacement Parts

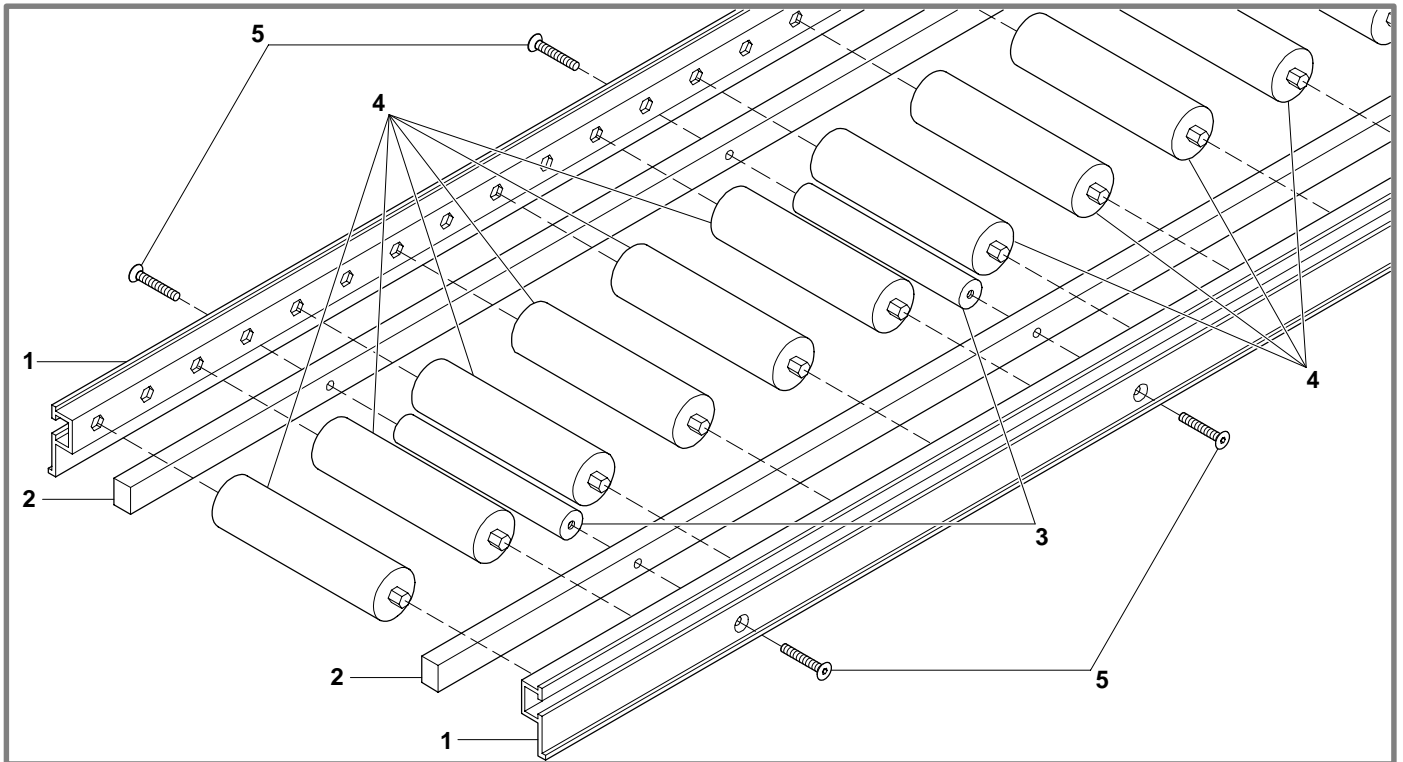
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	<h1>WARNING</h1>	
<ul style="list-style-type: none"><li>●The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.</li><li>●Standing on a conveyor or transporting people is prohibited.</li><li>●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. Because Dorner Mfg. Corp. cannot control the physical installation and applications of multiple conveyor systems, taking protective measures is the responsibility of the user.</li><li>●Operating Dorner conveyors in an explosive environment is prohibited.</li><li>●After installing guiding and before using conveyor, be sure to eliminate any potential pinch points that may have been created. To prevent injury, keep fingers and hands away from pinch point areas while the conveyor is being used.</li><li>●Due to the wide variety of conveyor and stand options, along with possible configurations, stability of the final setup is the responsibility of the end user.</li></ul>		

## Low Profile Conveyor Components

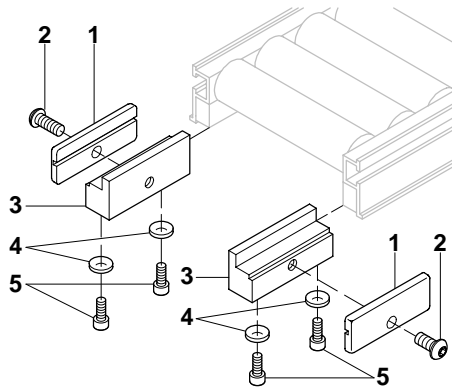


Item	Part No.	Description
1	208802	Side Rail, 2 ft (610 mm)
	208803	Side Rail, 3 ft (915 mm)
	208804	Side Rail, 4 ft (1220 mm)
	208805	Side Rail, 5 ft (1525 mm)
	208806	Side Rail, 6 ft (1830 mm)
2	209002	Inside Support Rail, 2 ft (610 mm)
	209003	Inside Support Rail, 3 ft (915 mm)
	209004	Inside Support Rail, 4 ft (1220 mm)
	209005	Inside Support Rail, 5 ft (1525 mm)
	209006	Inside Support Rail, 6 ft (1830 mm)

Item	Part No.	Description
3	209106M	Center Post, 6" (152 mm)
	209112M	Center Post, 12" (305 mm)
	209118M	Center Post, 18" (457 mm)
	209124M	Center Post, 24" (610 mm)
4	308306P	Roller Assembly, 6" (152 mm)
	308312P	Roller Assembly, 12" (305 mm)
	308318P	Roller Assembly, 18" (457 mm)
	308324P	Roller Assembly, 24" (610 mm)
5	930525M	Flat Head Cap Screw, M5-0.8 x 25 mm

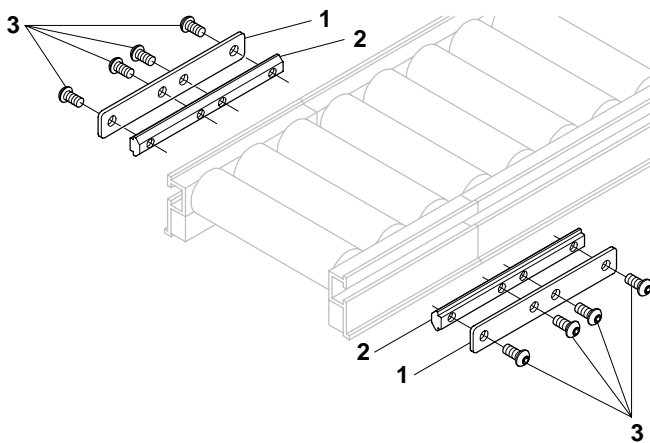
**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

## Stand Mounting Bracket



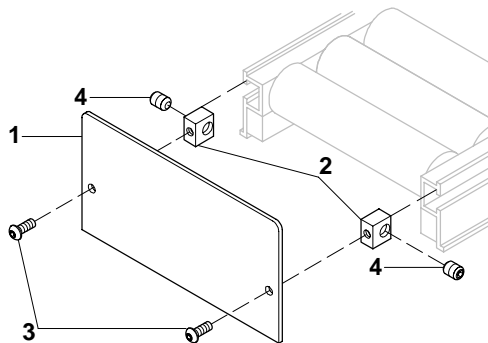
Item	Part No.	Description
1	200022M	Clamp Plate
2	910820M	Button Head Cap Screw, M8-1.25 x 20 mm
3	210021M	Stand Mounting Block
4	605279P	Hard Washer
5	920620M	Socket Head Cap Screw, M6-1.0 x 20 mm

## Connecting Hardware, Conveyors Longer than 6 ft (1830 mm)



Item	Part No.	Description
1	300153M	Intermediate Clamp Plate
2	300429M	Intermediate T-bar
3	910612M	Button Head Cap Screw, M6-1.0 x 12 mm

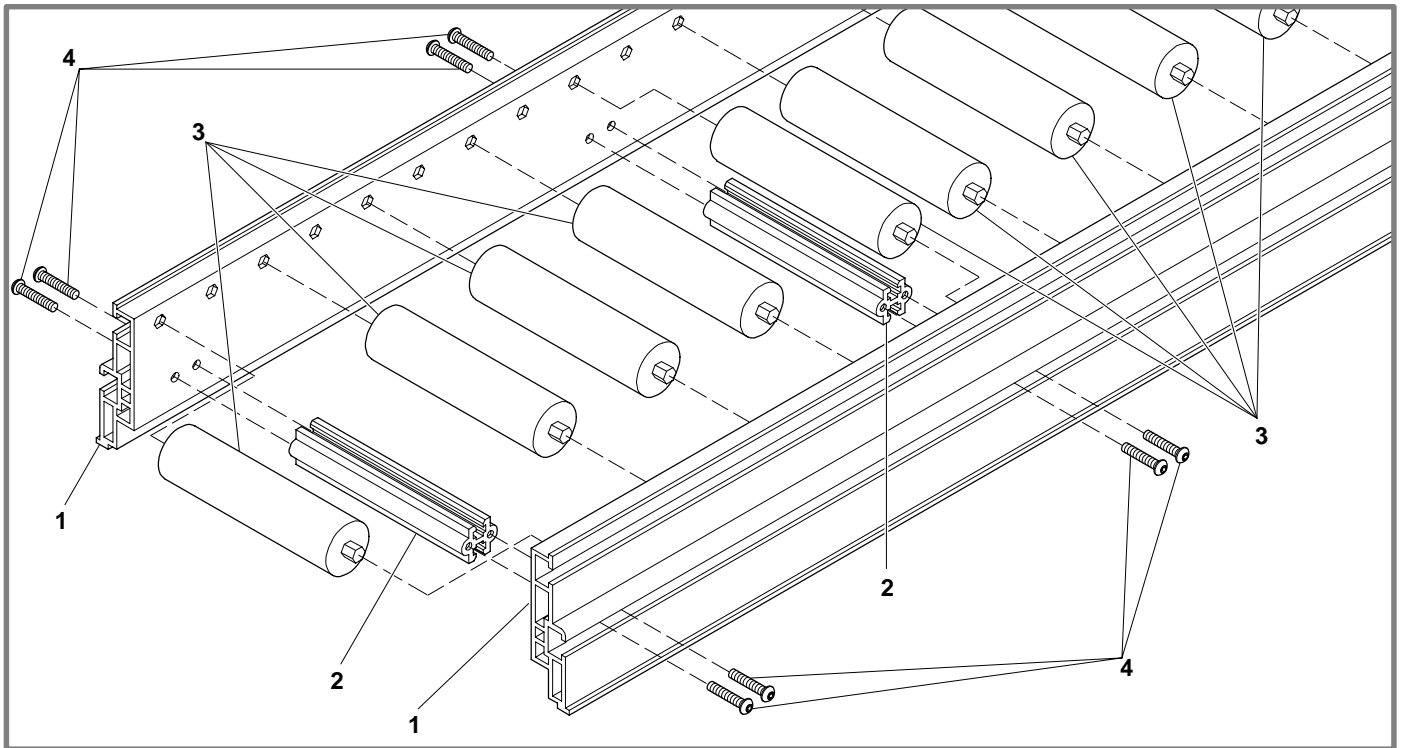
## Fixed End Stop



Item	Part No.	Description
1	208706M	Stop Plate, 6" (152 mm)
	208712M	Stop Plate, 12" (305 mm)
	208718M	Stop Plate, 18" (457 mm)
	208724M	Stop Plate, 24" (610 mm)
2	650064M	End Nut Bar
3	910506M	Button Head Cap Screw, M5-0.80 x 6 mm
4	970810M	Socket Head Set Screw, M8-1.25 x 10 mm

**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

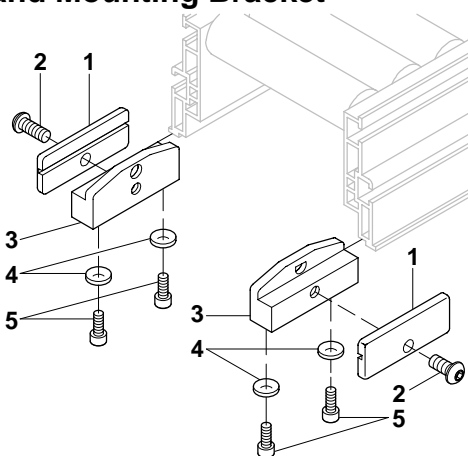
## Heavy Duty Conveyor Components



Item	Part No.	Description
1	308802	Side Rail, 2 ft (610 mm)
	308803	Side Rail, 3 ft (915 mm)
	308804	Side Rail, 4 ft (1220 mm)
	308805	Side Rail, 5 ft (1525 mm)
	308806	Side Rail, 6 ft (1830 mm)
	308810	Side Rail, 10 ft (3050 mm)

Item	Part No.	Description
2	202806M	Center Rail, 6" (152 mm)
	202812M	Center Rail, 12" (305 mm)
	202818M	Center Rail, 18" (457 mm)
	202824M	Center Rail, 24" (610 mm)
	308306P	Roller Assembly, 6" (152 mm)
3	308312P	Roller Assembly, 12" (305 mm)
	308318P	Roller Assembly, 18" (457 mm)
	308324P	Roller Assembly, 24" (610 mm)
4	910525M	Button Head Cap Screw, M5-0.80 x 25 mm

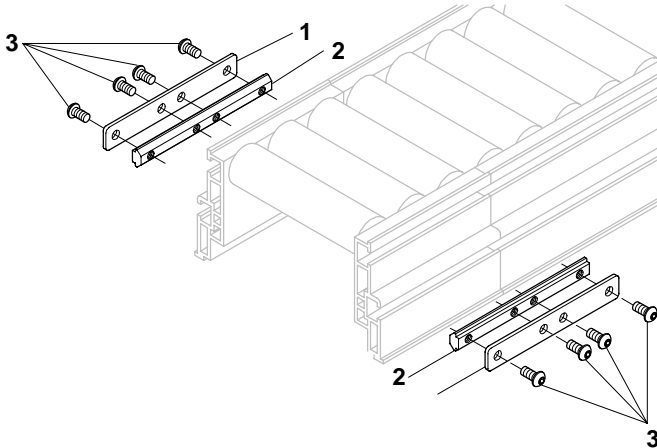
### Stand Mounting Bracket



Item	Part No.	Description
1	200022M	Clamp Plate
2	910820M	Button Head Cap Screw, M8-1.25 x 20 mm
3	300551M	Stand Mounting Block
4	605279P	Hard Washer
5	920620M	Socket Head Cap Screw, M6-1.0 x 20 mm

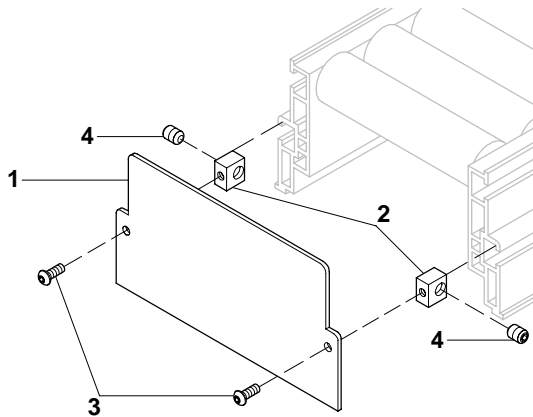
**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

## Connecting Hardware, Conveyors Longer than 10 ft (3050 mm)



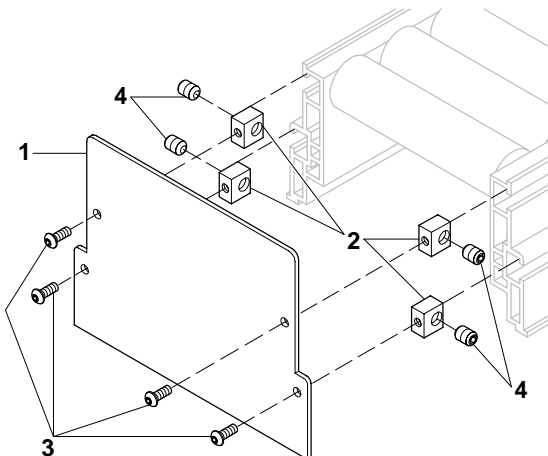
Item	Part No.	Description
1	300153M	Intermediate Clamp Plate
2	300429M	Intermediate T-bar
3	910612M	Button Head Cap Screw, M6-1.0 x 12 mm

## End Plate



Item	Part No.	Description
1	308506M	End Plate, 6" (152 mm)
	308512M	End Plate, 12" (305 mm)
	308518M	End Plate, 18" (457 mm)
	308524M	End Plate, 24" (610 mm)
2	650064M	End Nut Bar
3	910506M	Button Head Cap Screw, M5-0.80 x 6 mm
4	970810M	Socket Head Set Screw, M8-1.25 x 10 mm

## Fixed End Stop

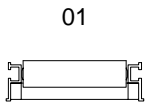


Item	Part No.	Description
1	308706M	Stop Plate, 6" (152 mm)
	308712M	Stop Plate, 12" (305 mm)
	308718M	Stop Plate, 18" (457 mm)
	308724M	Stop Plate, 24" (610 mm)
2	650064M	End Nut Bar
3	910506M	Button Head Cap Screw, M5-0.80 x 6 mm
4	970810M	Socket Head Set Screw, M8-1.25 x 10 mm

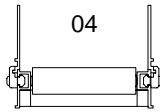
**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

Profiles

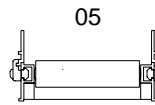
2160/3160 Series



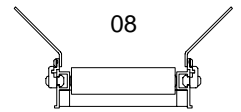
01  
Low Side  
(Standard)



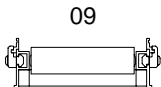
04  
3" (75 mm) Aluminum Side  
(See Page 8)



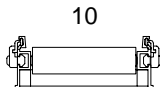
05  
1.5" (38 mm) Aluminum Side  
(See Page 8)



08  
Steel Flared High Side  
(See Page 9)



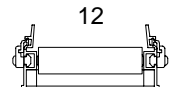
09  
0.5" (12 mm) Aluminum Side  
(See Page 8)



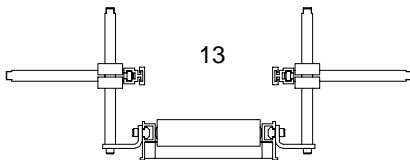
10  
0.5" (12 mm) UHMW Guide  
(See Page 10)



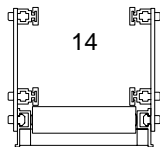
11  
0.63" (14 mm) UHMW Guide  
(See Page 10)



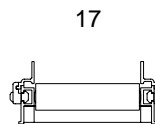
12  
Reverse Angle UHMW  
(See Page 10)



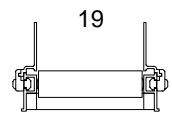
13  
Fully Adjustable UHMW  
(See Page 7)



14  
Adjustable Height  
(See Page 12)

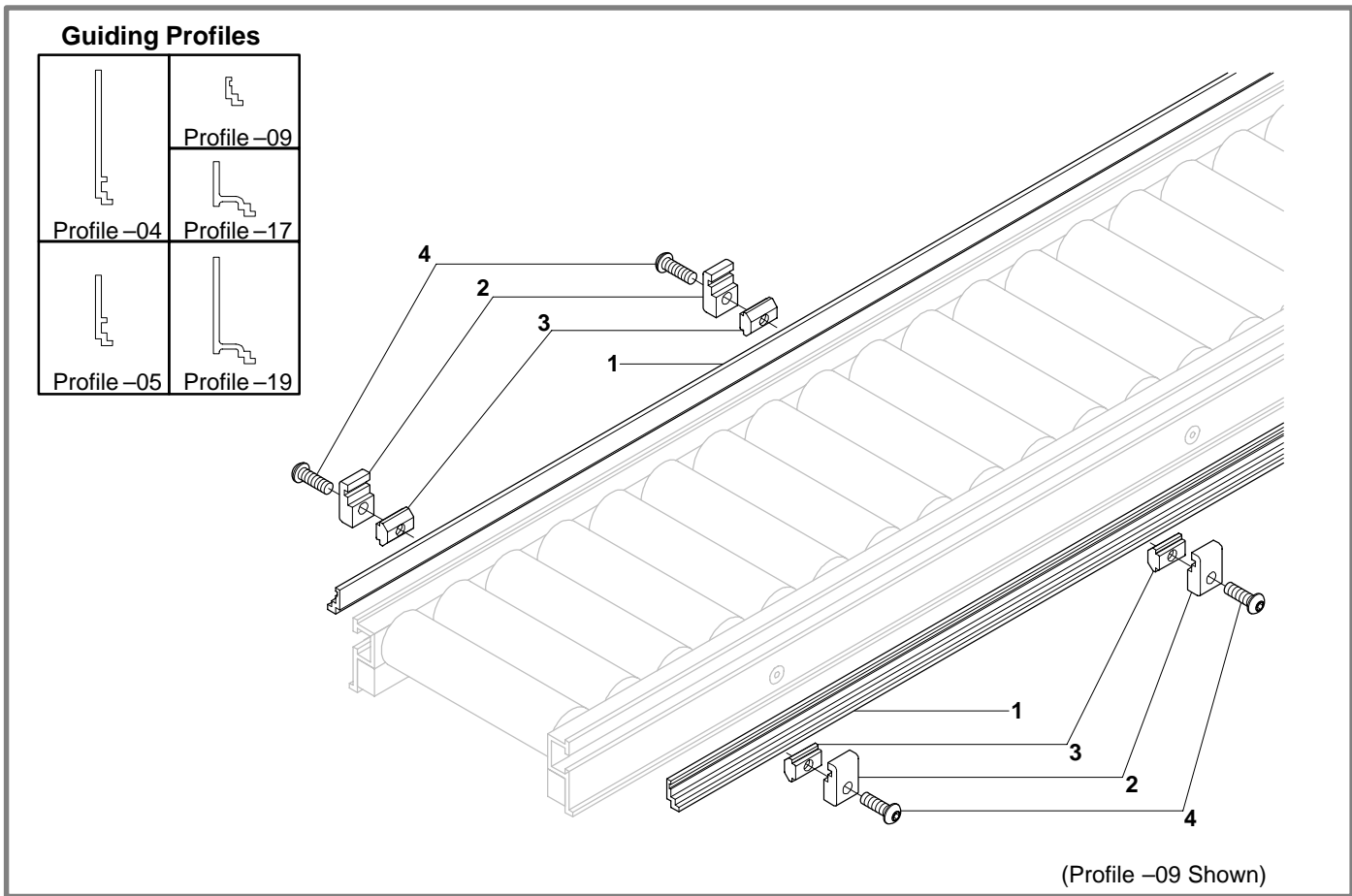


17  
1" (25 mm) High Inset  
(See Page 8)



19  
2.25" (57 mm) High Inset  
(See Page 8)

## Bolt-On Aluminum Sides



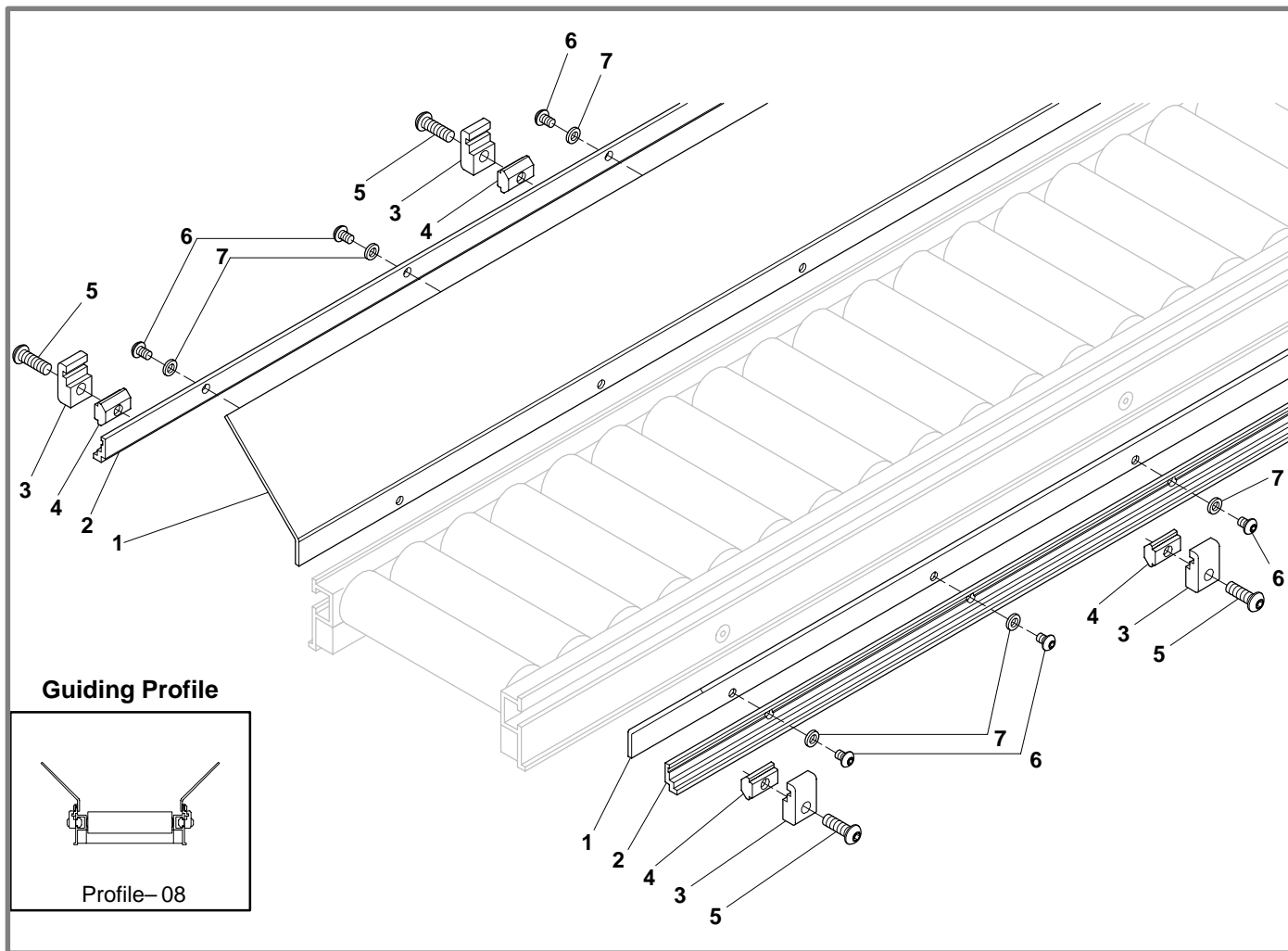
Item	Part No.	Description
1	380422	<b>Profile -04 - 3" (76 mm) Aluminum Guide -</b> 2 ft (610 mm)
	380423	3 ft (915 mm)
	380424	4 ft (1220 mm)
	380425	5 ft (1525 mm)
	380426	6 ft (1830 mm)
	380430	10 ft (3050 mm)
	380522	<b>Profile -05 - 1.5" (38 mm) Aluminum Guide -</b> 2 ft (610 mm)
	380523	3 ft (915 mm)
	380524	4 ft (1220 mm)
	380525	5 ft (1525 mm)
	380526	6 ft (1830 mm)
	380530	10 ft (3050 mm)
	380922	<b>Profile -09 - 0.5" (12 mm ) Aluminum Guide-</b> 2 ft (610 mm)
	380923	3 ft (915 mm)
	380924	4 ft (1220 mm)
	380925	5 ft (1525 mm)
	380926	6 ft (1830 mm)
	380930	10 ft (3050 mm)

Item	Part No.	Description
1 (cont.)	381722	<b>Profile -17 - 1" (25 mm) High Inset -</b> 2 ft (610 mm)
	381723	3 ft (915 mm)
	381724	4 ft (1220 mm)
	381725	5 ft (1525 mm)
	381726	6 ft (1830 mm)
	381730	10 ft (3050 mm)
	381922	<b>Profile -19 - 2.25" (57 mm) High Inset -</b> 2 ft (610 mm)
	381923	3 ft (915 mm)
381924	4 ft (1220 mm)	
381925	5 ft (1525 mm)	
381926	6 ft (1830 mm)	
381930	10 ft (3050 mm)	
2	200121	Retaining Clip
3	639971M	T-bar
4	910618M	Button Head Cap Screw, M6-1.0 x 18 mm

**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.



Steel Flared High Sides

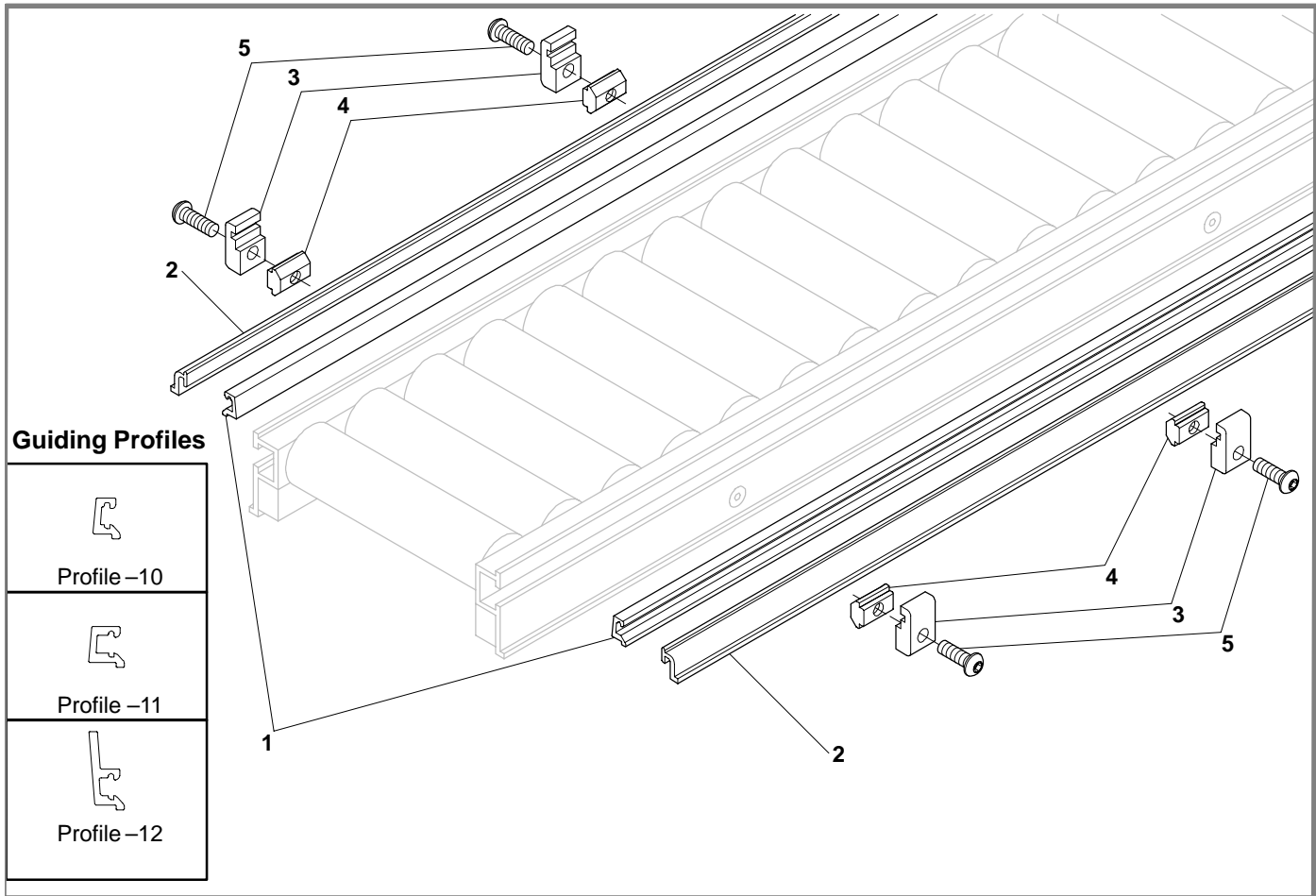


Item	Part No.	Description
1	202522M	Profile -08 - Flared Side - 2 ft (610 mm)
	202523M	Profile -08 - Flared Side - 3 ft (915 mm)
	202524M	Profile -08 - Flared Side - 4 ft (1220 mm)
	202525M	Profile -08 - Flared Side - 5 ft (1525 mm)
	202526M	Profile -08 - Flared Side - 6 ft (1830 mm)
	2	380822
380823		Guide Support, 3 ft (915 mm)
380824		Guide Support, 4 ft (1220 mm)
380825		Guide Support, 5 ft (1525 mm)
380826		Guide Support, 6 ft (1830 mm)
380830		Guide Support, 10 ft (3050 mm)

Item	Part No.	Description
3	200121	Retaining Clip
4	639971M	T-bar
5	910618M	Button Head Cap Screw, M6-1.0 x 18 mm
6	910506M	Button Head Cap Screw, M5-0.80 x 6 mm
7	911-512	Washer

**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

## UHMW Guides

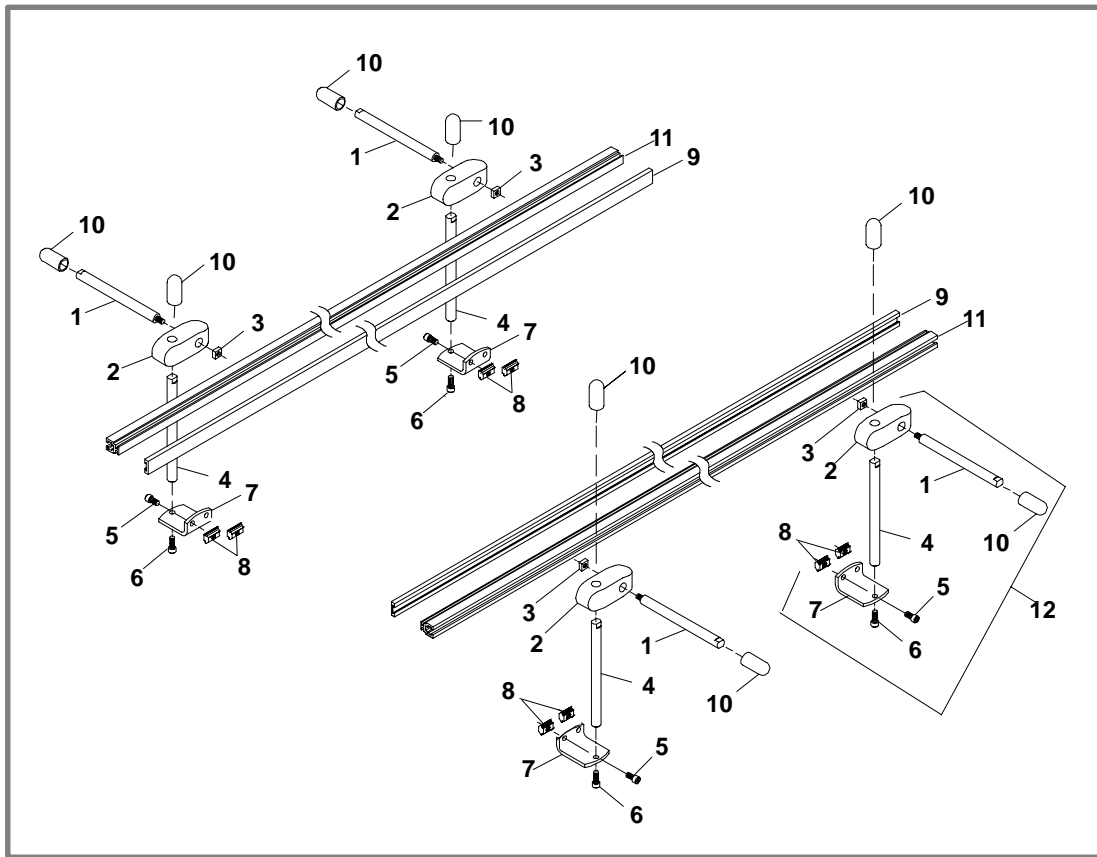


Item	Part No.	Description
1	200054P	<b>Profile -10 - 0.5" (12 mm) UHMW Guide -</b>
		2 ft (610 mm) ..... Specify Quantity
		3 ft (915 mm) ..... Specify Quantity
		4 ft (1220 mm) ..... Specify Quantity
		5 ft (1525 mm) ..... Specify Quantity
		6 ft (1830 mm) ..... Specify Quantity
	200053P	10 ft (3050 mm) ..... Specify Quantity
		<b>Profile -11 - 0.63" (14 mm) UHMW Guide -</b>
		2 ft (610 mm) ..... Specify Quantity
		3 ft (915 mm) ..... Specify Quantity
		4 ft (1220 mm) ..... Specify Quantity
		5 ft (1525 mm) ..... Specify Quantity
200052P	6 ft (1830 mm) ..... Specify Quantity	
	10 ft (3050 mm) ..... Specify Quantity	
	<b>Profile -12 - Reverse Angle UHMW Guide -</b>	
	2 ft (610 mm) ..... Specify Quantity	
	3 ft (915 mm) ..... Specify Quantity	
	4 ft (1220 mm) ..... Specify Quantity	
5 ft (1525 mm) ..... Specify Quantity		
6 ft (1830 mm) ..... Specify Quantity		
10 ft (3050 mm) ..... Specify Quantity		

Item	Part No.	Description
2	381022	Guide Mounting Rail, 2 ft (610 mm)
	381023	Guide Mounting Rail, 3 ft (915 mm)
	381024	Guide Mounting Rail, 4 ft (1220 mm)
	381025	Guide Mounting Rail, 5 ft (1525 mm)
	381026	Guide Mounting Rail, 6 ft (1830 mm)
	381030	Guide Mounting Rail, 10 ft (3050 mm)
	3	200121
4	639971M	T-bar
5	910618M	Button Head Cap Screw, M6-1.0 x 18

**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

Fully Adjustable Guide



Item	Part No.	Part Description
1	202028M	Guide Horizontal Mounting Shaft
2	807-652	Rod Cross Block
3	674175MP	Square Nut M6-1.0
4	202027M	Guide Vertical Mounting Shaft
5	920612M	Socket Head Cap Screw M6-1.0 x 12 mm
6	920616M	Socket Head Cap Screw M6-1.0 x 16 mm
7	202004M	Conveyor to Shaft Mounting Bracket
8	639971M	Drop-in T-Bar
9	614068P	Profile 13 Guide*

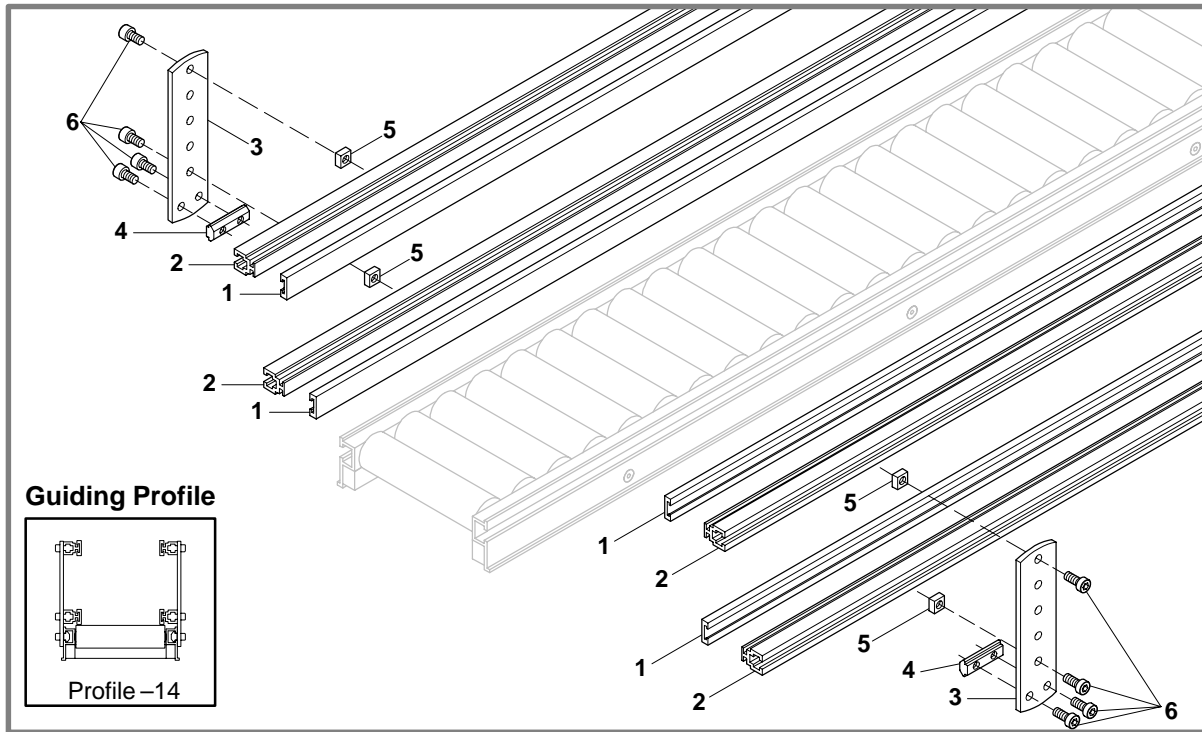
Item	Part No.	Part Description
10	807-948	Vinyl Shaft Cap
11	202983	Guide Mounting Rail 2 ft (610 mm)**
	202984	Guide Mounting Rail 3 ft (915 mm)**
	202985	Guide Mounting Rail 4 ft (1220 mm)**
	202986	Guide Mounting Rail 5 ft (1525 mm)**
	202987	Guide Mounting Rail 6 ft (1830 mm)**
	202991	Guide Mounting Rail 10 ft (3050 mm)**
12	382300M	Guide Mounting Support Assembly

\*Ordered in 1 ft (305 mm) increments.

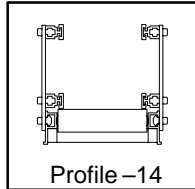
\*\* Nominal Conveyor Length.

**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

## Adjustable Height Guide



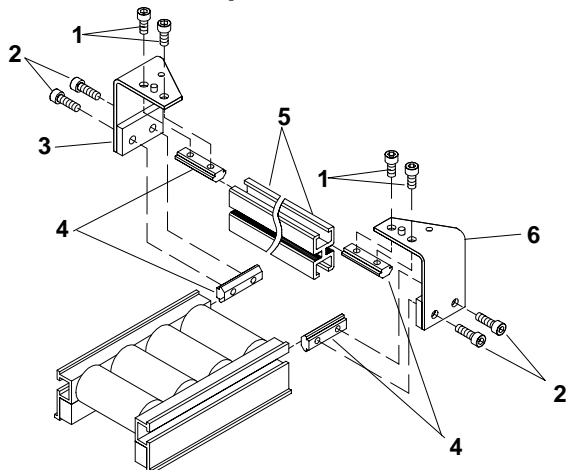
**Guiding Profile**



Item	Part No.	Description
1	614068P	<b>Profile -14 - Guide -</b>
		2 ft (610 mm) ..... Specify Quantity
		3 ft (915 mm) ..... Specify Quantity
		4 ft (1220 mm) ..... Specify Quantity
		5 ft (1525 mm) ..... Specify Quantity
		6 ft (1830 mm) ..... Specify Quantity
		10 ft (3050 mm) ..... Specify Quantity

Item	Part No.	Description
2	202983	Guide Mounting Rail, 2 ft (610 mm)
	202984	Guide Mounting Rail, 3 ft (915 mm)
	202985	Guide Mounting Rail, 4 ft (1220 mm)
	202986	Guide Mounting Rail, 5 ft (1525 mm)
	202987	Guide Mounting Rail, 6 ft (1830 mm)
	202991	Guide Mounting Rail, 10 ft (3050 mm)
3	661090M	Universal Guide Plate
4	643874M	T-bar
5	674175MP	Square Nut, M6-1.0
6	920616M	Socket Head Cap Screw, M6-1.0 X 16 mm

## Adjustable End Stop

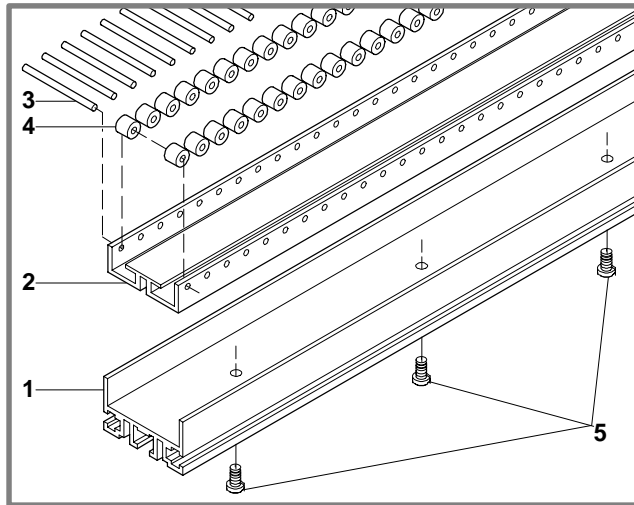


Item	Part No.	Description
1	920620M	Socket Head Cap Screw, M6-1.0 x 20 mm
2	920612M	Socket Head Cap Screw, M6-1.0 x 12 mm
3	202446M*	Right Adjustable Mounting Bracket
4	200626M	Drop-in T-bar
5	677721	End Stop, 6" (152 mm)
	677725	End Stop, 12" (305 mm)
	677727	End Stop, 18" (457 mm)
	677729	End Stop, 24" (610 mm)
6	202445M*	Left Adjustable Mounting Bracket

\* The same "M" part is also used for End Stops with SAE fasteners.

**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

**Mini Roller Conveyor Components (Two-Roller Assembly )**

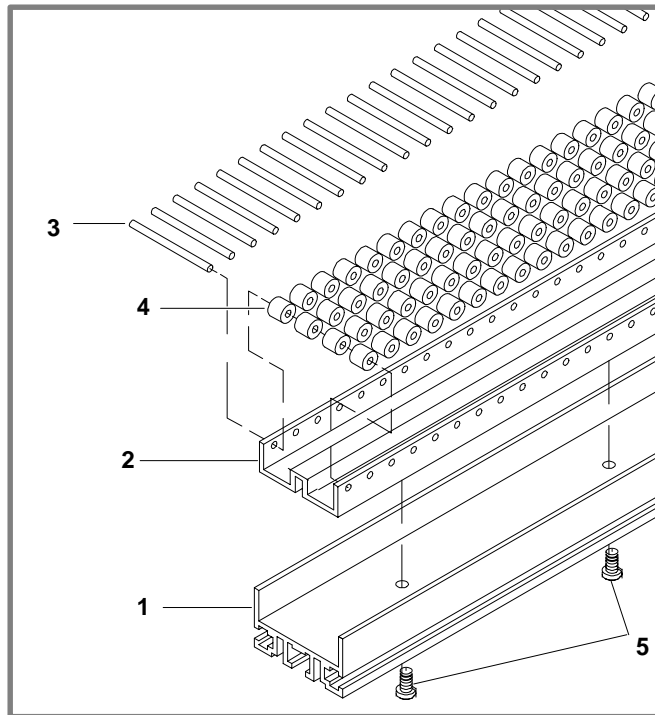


Item	Part No.	Description
1	661192	Outer Shell, 2 ft (610 mm)
	661194	Outer Shell, 4 ft (1220 mm)
	661196	Outer Shell, 6 ft (1830 mm)
2	640723	Inner Shell* - 2 Roller Style (above)
	672926	Inner Shell* - 4 Roller Style (below)
		2 ft (610 mm) ..... Specify Quantity of 1
		4 ft (1220 mm) ..... Specify Quantity of 2
		6 ft (1830 mm) ..... Specify Quantity of 3

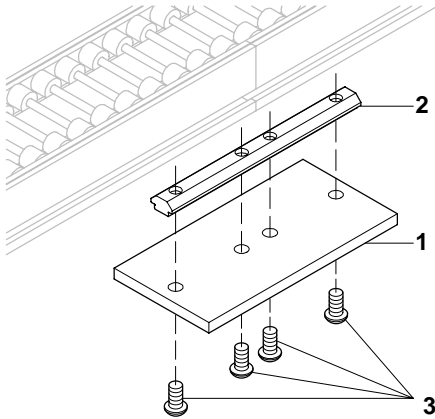
Item	Part No.	Description
3	637845P	Roller Shaft
4	637844P	Roller
5	925612MSS	Low Head Cap Screw, M6-1.0 x 12 mm

\* Sold in 2-ft (610 mm) sections

**Mini Roller Conveyor Components (Four-Roller Assembly )**



## Connecting Assembly for a Conveyor Longer Than 6 ft (1830 mm)



Item	Part No.	Description
1	661084M	Mounting Plate
2	300429M	T-bar
3	910612M	Button Head Cap Screw, M6-1.0 x 12 mm

**NOTE:** Metric parts listed. For SAE parts, other than fasteners, drop the "M" suffix. SAE equivalent fasteners are identified in the table on page 14.

## Metric to SAE Hardware Conversion Table

Metric Part No.	Hardware Name	Metric Size	Pages Appearing On	Equiv. SAE Part No.	Equiv. SAE Size
674175MP	Nut, Square	M6-1.0	11,12	910-190	1/4-20
910506M	Button Head Cap Screw	M5-0.80 x 6 mm	4,6	901-079	#10-32 x 0.25
910612M	Button Head Cap Screw	M6-1.0 x 12 mm	4,6,13 (bottom)	901-129	1/4-20 x 0.50
910820M	Button Cap Set Screw	M8-1.25 x 20 mm	4,5,6	901-183	5/16-18 x 0.75
910506M	Button Head Cap Screw	M5-0.80 x 6 mm	9	901-105	#10-32 x 0.25
910525M	Button Head Cap Screw	M5-0.80 x 25 mm	5	901-116	#10-32 x 1.0
910618M	Button Head Cap Screw	M6-1.0 x 18 mm	8,9,10	901-133	1/4-20 x 0.75
920612M	Socket Head Cap Screw	M6-1.0 x 12 mm	11,12	902-128	1/4 x 0.5
920616M	Socket Head Cap Screw	M6-1.0 x 16 mm	11,12	902-130	1/4 x 0.63
920620M	Socket Head Cap Screw	M6-1.0 x 20 mm	4, 5,6,12,13	902-132	1/4-20 x 0.75
925612MSS	Low Head Socket Head Cap Screw	M6-1.0 x 12 mm	13 (top)	905-129	1/4-20 x 0.50
930525M	Flat Socket Head Cap Screw	M5-0.80 x 25 mm	3	903-116	#10-32 x 1"
970810M	Socket Head Set Screw	M8-1.25 x 10 mm	4,6	907-152	5/16-18 x 0.38"

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## RETURN POLICY

No returns will be accepted without prior written factory authorization. When calling for authorization, please have the following information ready for the Dornier 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. Dornier 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 Dornier 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.

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

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



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