



7400 Series End Drive Conveyors

Installation, Maintenance and Parts Manual



Flat Belt Conveyor



Cleated Belt Conveyor

DORNER MFG. CORP.
P.O. Box 20 • 975 Cottonwood Ave.
Hartland, WI 53029-0020 USA

INSIDE THE USA
TEL: 1-800-397-8664
FAX: 1-800-369-2440

OUTSIDE THE USA
TEL: 262-367-7600
FAX: 262-367-5827

For other service manuals visit our website at:
www.dorner.com/service_manuals.asp

Table of Contents

Introduction	2	Standard Belts	18
Warnings – General Safety	3	Replacing a Section of Belt	18
Product Description	4	Replacing the Entire Belt	19
Specifications	5	Specialty Intralox 1100 Series Belts	19
Flat Belt 7400 Series Conveyor	5	Replacing a Section of Belt	19
Cleated Belt 7400 Series Conveyor	5	Replacing the Entire Belt	19
Flat Belt 7400 Series LPZ Conveyor	5	Specialty Intralox 1600 Series Belts	20
Cleated Belt 7400 Series LPZ Conveyor	5	Replacing a Section of Belt	20
Conveyor Supports	6	Replacing the Entire Belt	20
Specifications	6	Conveyor Belt Tensioning	20
Installation	7	Sprocket and Puck Removal	21
Required Tools	7	A - Drive Sprocket Removal	21
Recommended Installation Sequence	7	B - Idler Puck Removal	22
Conveyors Longer than 10 ft (3048 mm)	7	C - Nose Bar Puck Removal	23
LPZ Conveyors	8	Reassembling Tail Assemblies	23
Knuckles	8	Nose Bar Idler	23
Belt	8	Idler Tail	24
Guides	9	Drive Tail	24
All Conveyors	9	Bearing Replacement	25
Stand Installation	9	LPZ Knuckles	25
Tail Assembly Installation	10	Wearstrips and Belt Returns	25
Drive Tail	10	Service Parts	26
Tip Up Assembly	10	Drive End Components	26
Idler Tail	11	Tension End Components	29
Nose Bar Idler Tail	12	Nose Bar Tension End	30
Lifter Installation	13	Conveyor Frame and Extension	31
Wear Strip Installation	13	Upper Knuckle for 5° - 15°	32
Belt Installation	14	Upper Knuckle for 30° - 60°	33
Belt Return Installation	15	Lower Knuckle for 5° - 15°	34
Preventive Maintenance and Adjustment	16	Lower Knuckle for 30° - 60°	35
Required Tools	16	3" (76 mm) High Sides	36
Checklist	16	Cleated 1" (25 mm) Guides	37
Cleaning	16	Cleated 3" (76 mm) Guides	38
Routine Cleaning	16	Flat Belt Returns	39
Periodic Cleaning	17	Cleated Belt Returns	39
Lubrication	17	Flat Belt	40
Conveyor Bearings	17	Cleated Belt	40
Wearstrips and Belt Returns	17	Ordering a Replacement Chain	40
Maintaining the Conveyor Belt	17	Belt Removal Tool	40
Troubleshooting	17	Configuring Conveyor Part Number	41
Conveyor Belt Replacement	18	Return Policy	42
Conveyors with Guides	18		

Introduction

CAUTION

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.

The Dorner Limited Warranty applies.

Dorner 7400 Series conveyors have patents pending.

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

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 .

Intralox is a registered trademark of Laitram L.L.C. in the United States and / or other countries.

Warnings – General Safety


⚠ DANGER



SEVERE HAZARD!

KEEP OFF CONVEYORS. Climbing, sitting, walking or riding on conveyor will result in death or serious injury.


⚠ DANGER



EXPLOSION HAZARD!

- **DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.** The electric gearmotor generates heat and could ignite combustible vapors.
- Failure to comply will result in death or serious injury.

⚠ WARNING



CRUSH HAZARD!

- **DO NOT** place hands or fingers inside the conveyor while it is running.
- **DO NOT** wear loose garments while operating the conveyor. Loose garments can become caught up in the conveyor.
- Failure to comply could result in serious injury.

⚠ WARNING



CRUSH HAZARD!

- **SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.**
- Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing serious injury.

⚠ WARNING



SEVERE HAZARD!

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


⚠ WARNING



BURN HAZARD!

DO NOT TOUCH the motor while operating, or shortly after being turned off. Motors may be **HOT** and can cause serious burn injuries.


⚠ WARNING



PUNCTURE HAZARD!

Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.

⚠ WARNING



SEVERE HAZARD!

- 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.
- Failure to comply could result in serious injury.

Product Description

Refer to **(Figure 1)** for typical conveyor components.

Typical Components	
1	Conveyor
2	Gearmotor
3	Belt (Flat Belt Shown)
4	Return
5	Support Stands
6	Motor Controller
7	Drive End
8	Tension End

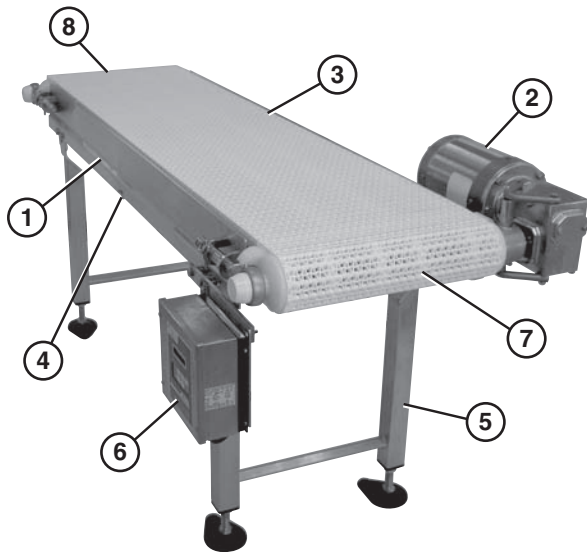
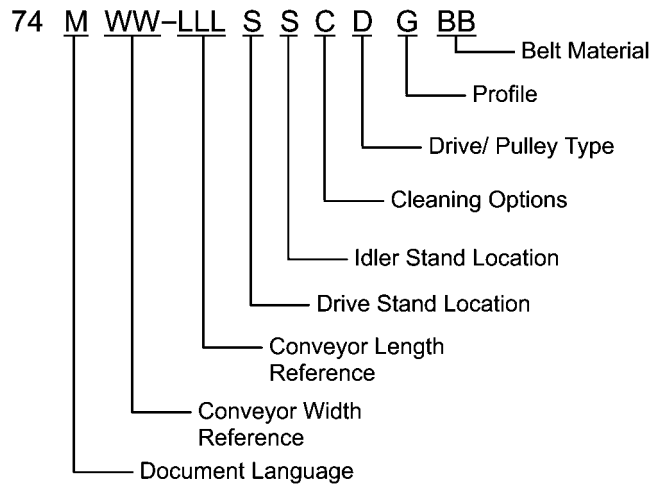


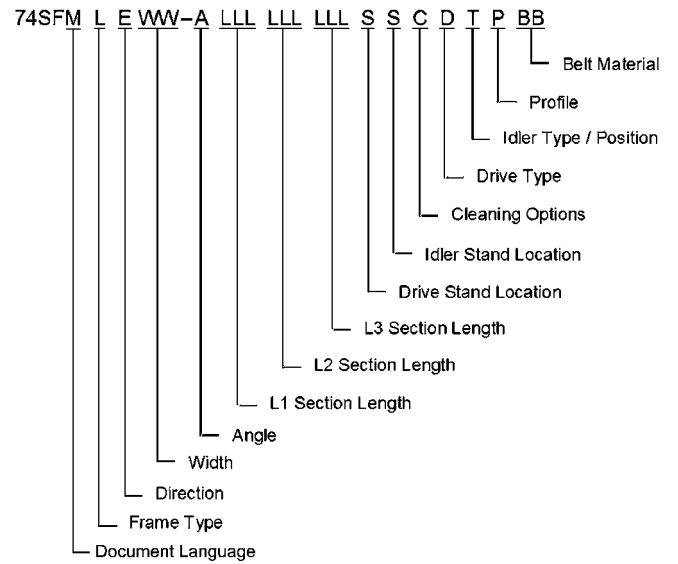
Figure 1

Specifications

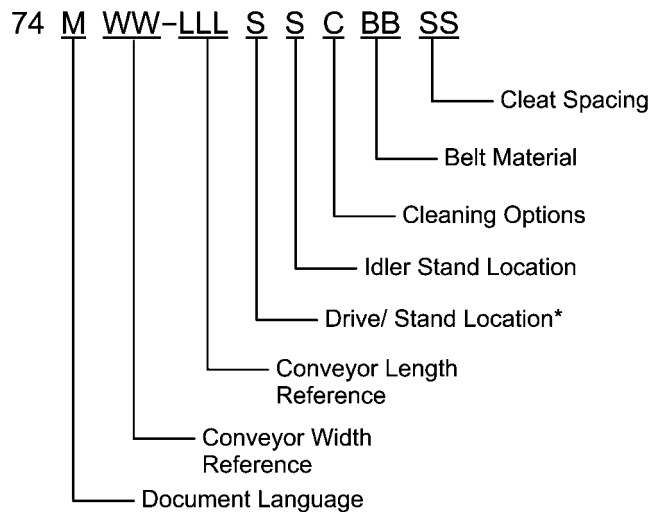
Flat Belt 7400 Series Conveyor



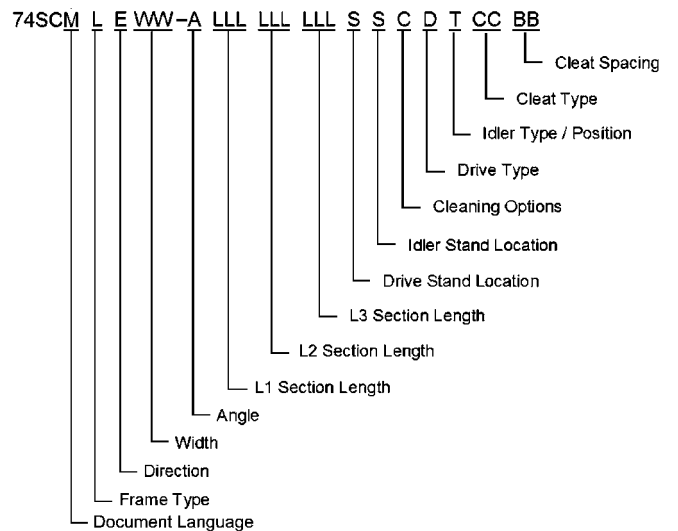
Flat Belt 7400 Series LPZ Conveyor



Cleated Belt 7400 Series Conveyor



Cleated Belt 7400 Series LPZ Conveyor



Specifications

Conveyor Supports

Maximum Distances:

1 = 3 ft (914 mm)

2 = 8 ft (2438 mm)**

3 = 3 ft (914 mm)

** For conveyors longer than 10 ft (3.05 m),
install support at frame joint.

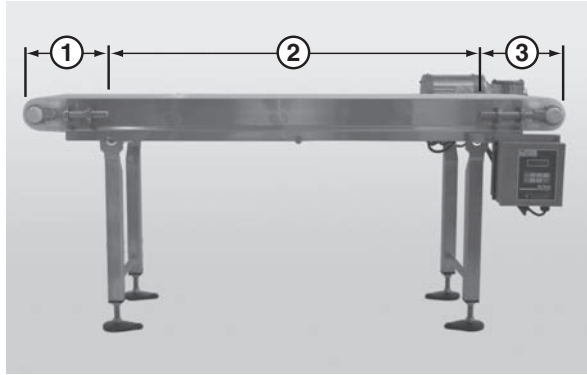


Figure 2

Specifications

Conveyor Width Reference (<u>WW</u>)	06 – 60 in 02 increments
Conveyor Belt Width	6" (152 mm) – 60" (1524 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lb / ft ² (97 kg / m ²) with a maximum of 1000 lb / ft ² (4882 kg / m ²)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	233 ft / minute (71 m / minute)
Belt Take-up	2" (51 mm)

Conveyor Length Reference (<u>LLL</u>)	036 – 999 in 001 increments
Conveyor Length	36" (914 mm) – 999" (25.4 m) in 1" (25 mm) increments
LPZ Section Lengths (<u>LLL</u>)	024 – 252 in 001 increments
LPZ Section Length	24" (610 mm) – 252" (6401 mm) in 1" (25 mm) increments
Total LPZ Conveyor Length	(L1 + L2 + L3) = Maximum 38' (11.6 m) long conveyor

IMPORTANT

Maximum conveyor loads are based on:

- Non-accumulating product
- Product moving toward gearmotor
- Conveyor being mounted horizontally
- Conveyor being located in a dry environment
- Conveyor equipped with standard belt only

⚠ CAUTION

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

⚠ CAUTION

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

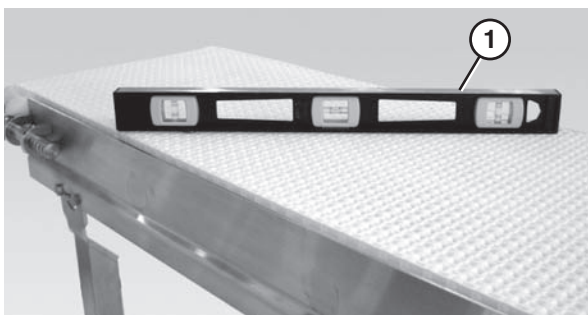


Figure 3

Required Tools

- 17 mm wrench (for hexagonal head fasteners)
- 4 mm hex wrench (for bearing shaft assembly fasteners)
- Level
- Torque wrench

Recommended Installation Sequence

1. Attach the stands to the conveyor. Refer to “Stand Installation” on page 9.
2. Attach the tail assemblies to the frame. Refer to “Tail Assembly Installation” on page 10.
3. Attach the lifters, if applicable. Refer to “Lifter Installation” on page 13.
4. Install the gearmotor, if applicable. Refer to the “7400 Series Drive Package Installation, Maintenance and Parts Manual.”
5. Attach the wear strips. Refer to “Wear Strip Installation” on page 13.
6. Install the belt. Refer to “Belt Installation” on page 14.
7. Attach the belt returns. Refer to “Belt Return Installation” on page 15.
8. Attach any guides / accessories. Refer to the "Service Parts" section starting on page 26.

Conveyors Longer than 10 ft (3048 mm)

Typical Connection Components (Figure 4).

- | | |
|---|---------------------------------------|
| 1 | M10 x 1.5 mm hex head cap screws (x4) |
| 2 | Connector hex rods (x2) |
| 3 | Conveyor frames |

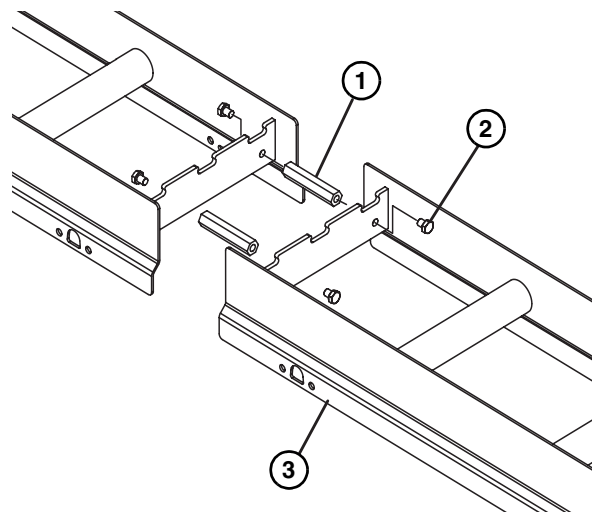


Figure 4

1. Locate the section number sequence etched on each section of frame (Figure 5, item 1).

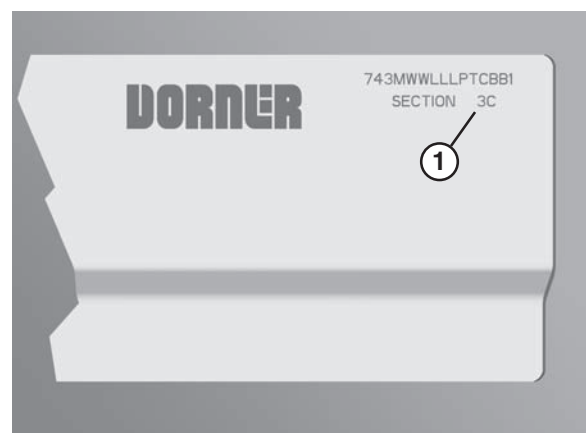


Figure 5

2. Position the frame sections in the correct order.

Installation

3. Connect the frame sections by bolting the hex post connectors (Figure 6, item 1) the sections of frame.

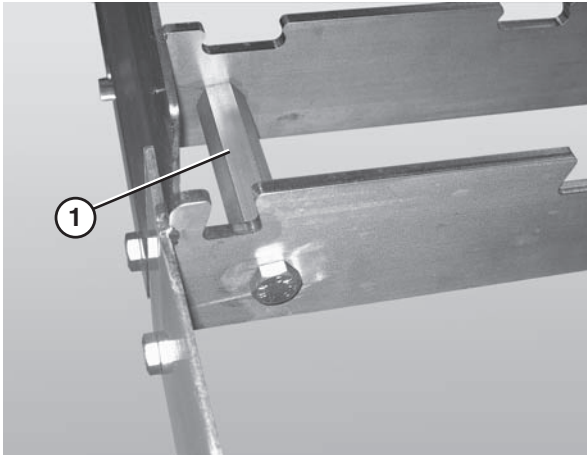


Figure 6

LPZ Conveyors

Knuckles

1. Attach upper knuckle (Figure 7, item 1) to frame (Figure 7, item 2) with hex rods (Figure 7, item 3) and bolts (Figure 7, item 4).

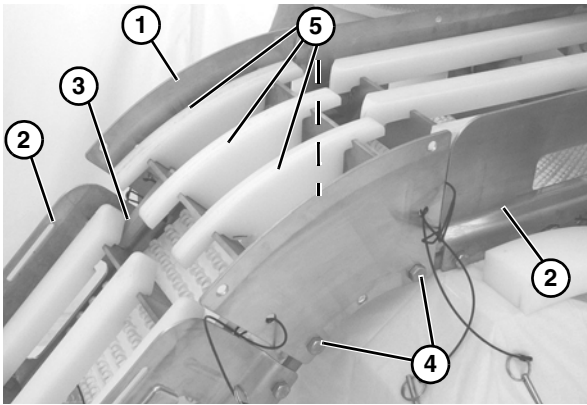


Figure 7

2. Install wear strips (Figure 7, item 5).

3. Attach lower knuckle (Figure 8, item 1) to frame (Figure 8, item 2) with hex rods (Figure 8, item 3) and bolts (Figure 8, item 4).

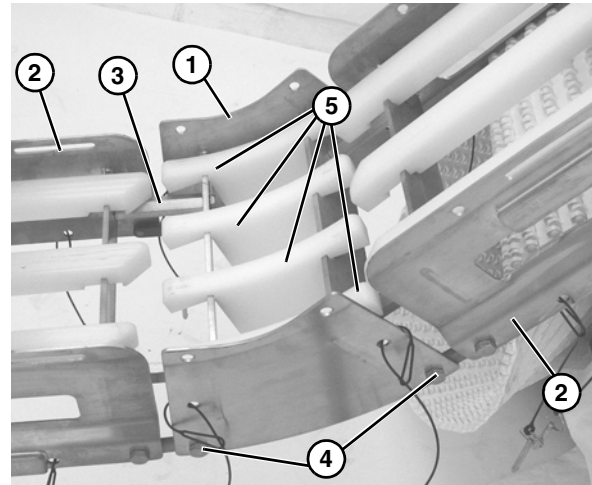


Figure 8

4. Install wear strips (Figure 8, item 5).

Belt

1. Slide belt (Figure 9, item 1) over knuckles on top of the wear strips.



Figure 9

Guides

1. Slide guides (**Figure 10, item 1**) on to the knuckle frame, and secure with pull pins (**Figure 10, item 2**).

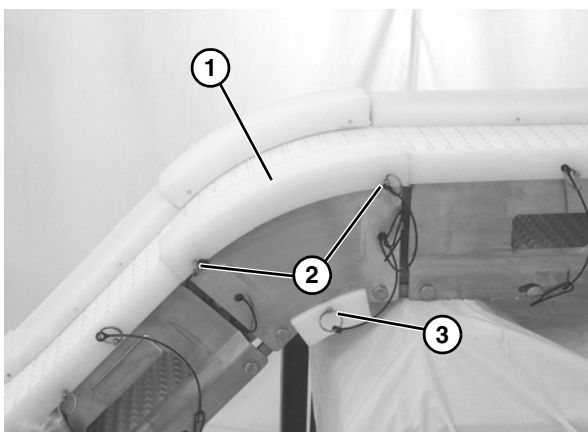


Figure 10

2. Install return guides and secure with pull pin (**Figure 10, item 3**).
3. Slide guides (**Figure 11, item 1**) onto lower knuckle frame, and secure with pull pins (**Figure 11, item 2**).

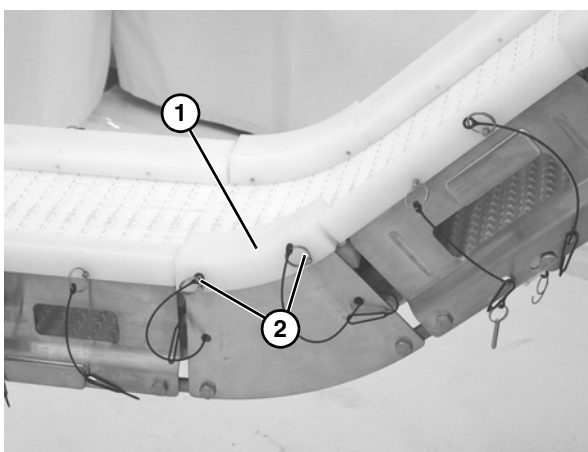


Figure 11

All Conveyors

Stand Installation

Typical Stand Components (**Figure 12**)

1	Conveyor frame
2	Stand
3	M10 - 1.5 x 12 mm hex head cap screws (x4)

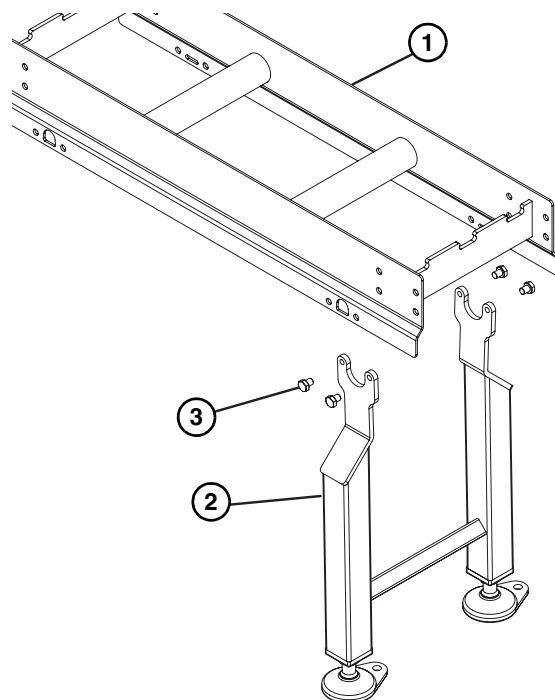


Figure 12

1. Position the stands on a flat, level surface.
2. Attach the stands to the frame (**Figure 13**).



Figure 13

Installation

Tail Assembly Installation

Drive Tail

Typical Drive Tail Components (Figure 14).

1	Drive tail assembly
2	Bolt (x4)
3	Conveyor frame

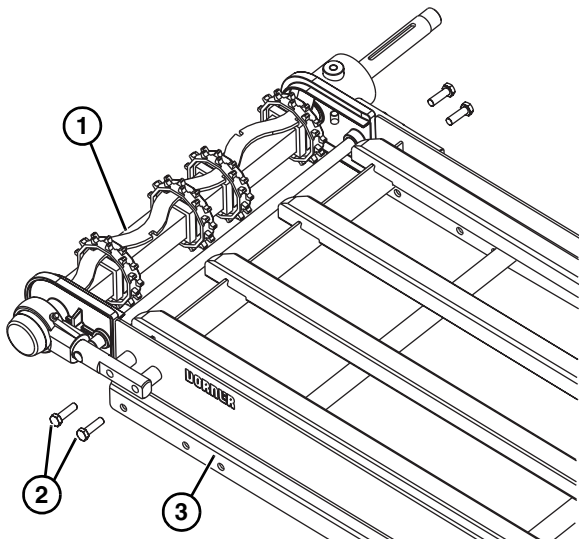


Figure 14

CAUTION

To avoid injury and damage to parts, have an assistant hold opposite end of drive tail when removing or installing it.

1. Install drive tail assembly (Figure 15, item 1) onto the mounting posts (Figure 15, item 2) and secure with two bolts (Figure 15, item 3) on each side.

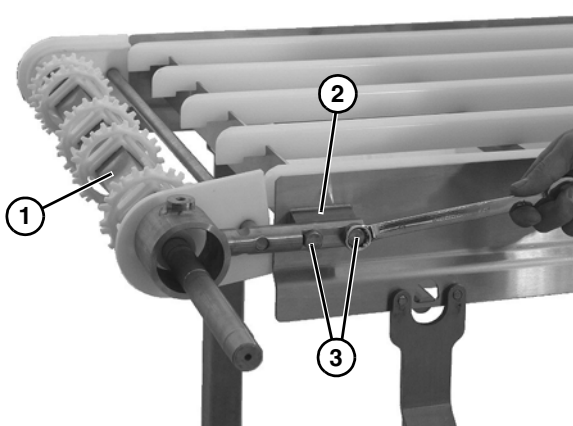


Figure 15

2. Install the drive package, if applicable. Refer to the "7400 Series Drive Package Installation, Maintenance and Parts Manual."

Tip Up Assembly

Typical Tip Up Assembly Components (Figure 16)

1	Hex Bar
2	Stop Key (x2)
3	Tip Up Sleeve (x2)

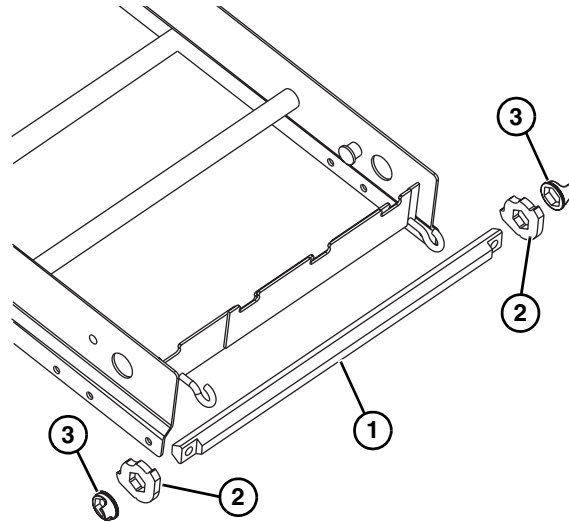


Figure 16

1. Slide stop keys (Figure 17, item 1) and tip up sleeves (Figure 17, item 2) onto hex shaft (Figure 17, item 3). The tabs on the tip up sleeves face outward and align with the slotted ends of the hex shaft as shown.

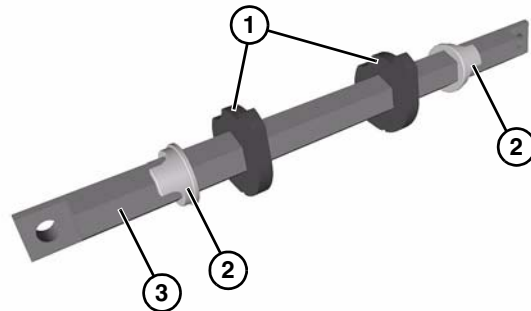


Figure 17

- Place hex shaft assembly (**Figure 18, item 1**) through the conveyor frame tip up holes (**Figure 18, item 2**) and center with conveyor.

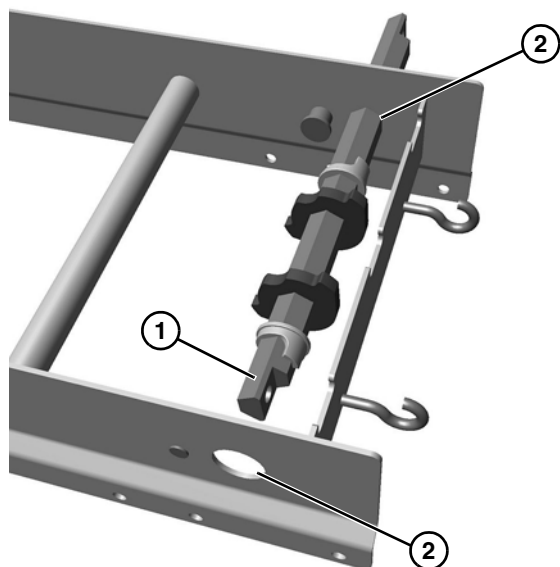


Figure 18

- Hex shaft assembly will need to be rotated (**Figure 19**) for stop keys (**Figure 19, item 1**) to pass by the frame stops (**Figure 19, item 2**).

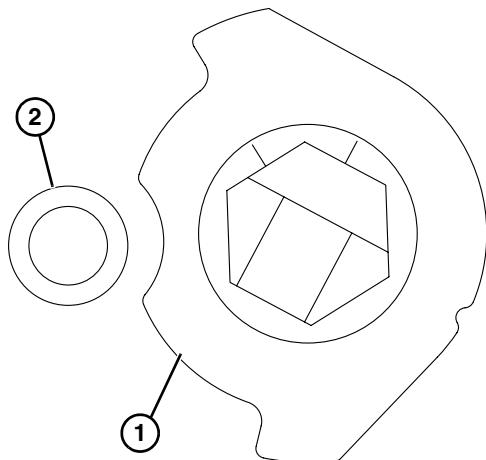


Figure 19

- Slide the tip up sleeves (**Figure 20, item 1**) and stop keys (**Figure 20, item 2**) outward on hex shaft assembly (**Figure 20, item 3**) until the sleeves seat in the holes of the frame and stop keys are seated against frame stops (**Figure 20, item 4**).

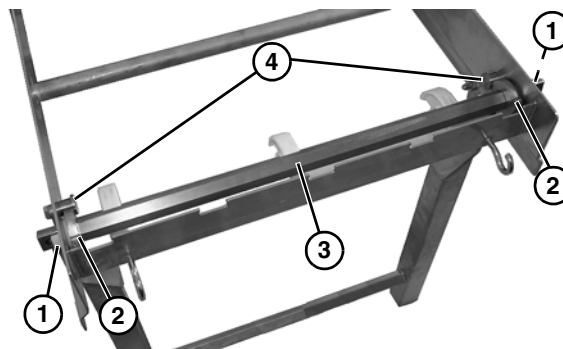


Figure 20

Idler Tail

Typical Idler Tail Components (**Figure 21**)

1	Conveyor Frame
2	Bolt (x2)
3	Idler tail assembly

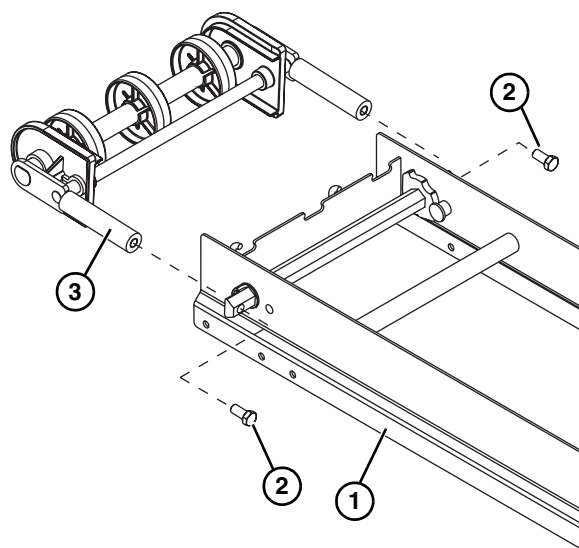


Figure 21

Installation

⚠ CAUTION

To avoid injury and damage to parts, have an assistant hold opposite end of idler tail when removing or installing it.

1. Place the idler tail assembly (Figure 22, item 1) against the holes in the tip up hex shaft assembly (Figure 22, item 2) and secure with a bolt (Figure 22, item 3) on each side.

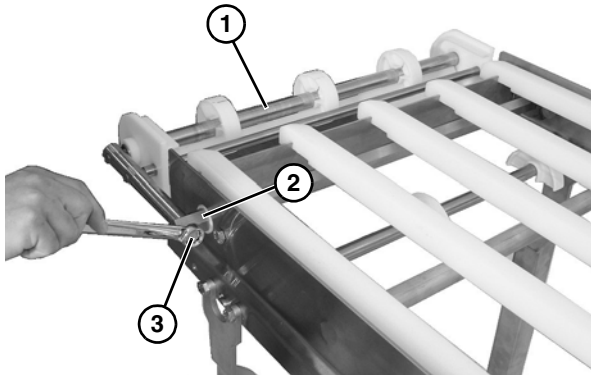


Figure 22

Nose Bar Idler Tail

Typical Nose Bar Idler Tail Components (Figure 23)

- | | |
|---|------------------------------|
| 1 | Nose bar idler tail assembly |
| 2 | Bolt (x2) |
| 3 | Conveyor frame |

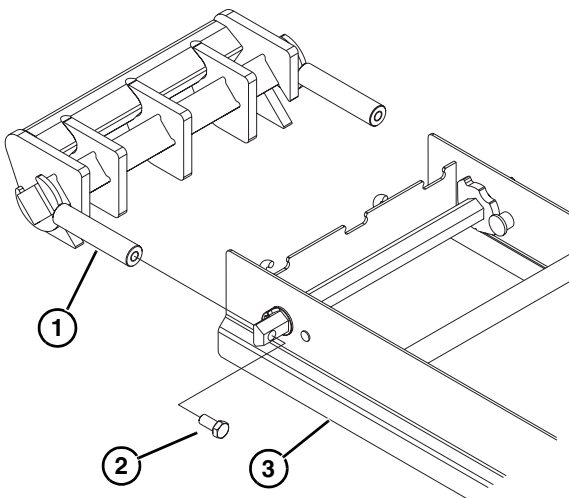


Figure 23

1. Place the nose bar idler shafts (Figure 24, item 1) against the holes in the hex shaft assembly (Figure 24, item 2) and secure each with a bolt (Figure 24, item 3).

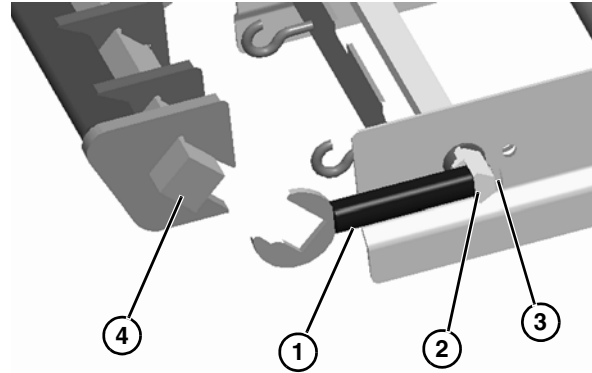


Figure 24

2. Attach the nose bar transfer post (Figure 24, item 4) to the nose bar idler shafts.
3. Ensure that the nose bar pucks (Figure 25, item 1) are in line with the conveyor frame (Figure 25, item 2).

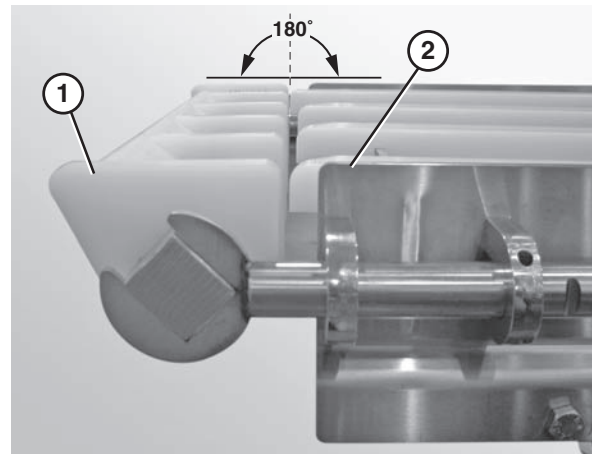


Figure 25

Lifter Installation

Typical Lifter Components (Figure 26)

1	Belt lift pivot bar
2	Lifter bars
3	Belt lift handle
4	M8 - 1.25 x 16 mm hex head cap screw

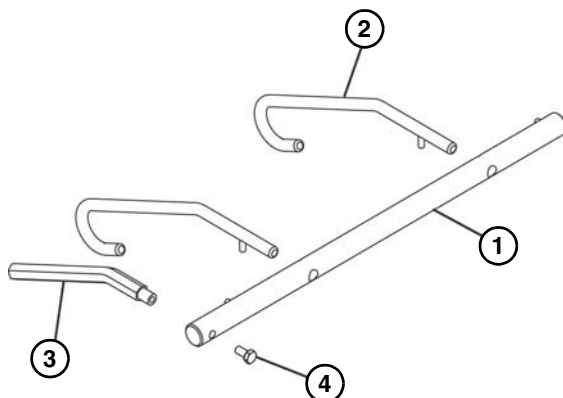


Figure 26

1. Slide the belt lift pivot bar (Figure 27, item 1) through the designated holes in the frame.

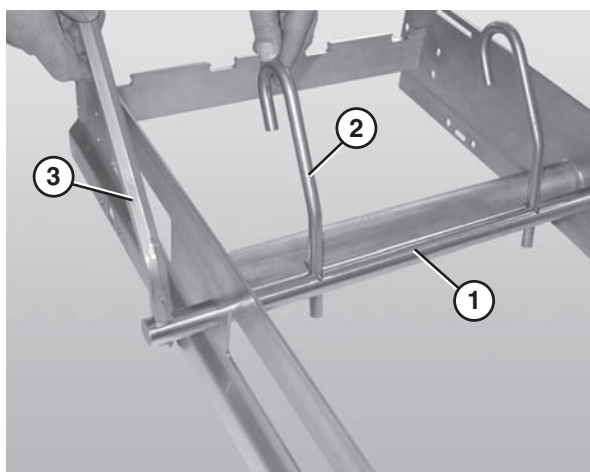


Figure 27

2. Attach the lifter bars (Figure 27, item 2) to the belt lift pivot bar (Figure 27, item 1). Make sure the hooked ends of the lifter bars are facing down when resting against the frame.
3. Attach the lifter handle (Figure 27, item 3) to the belt lift pivot rod.

Wear Strip Installation

Typical Wear Strip Components (Figure 28)

1	Wear strip
---	------------

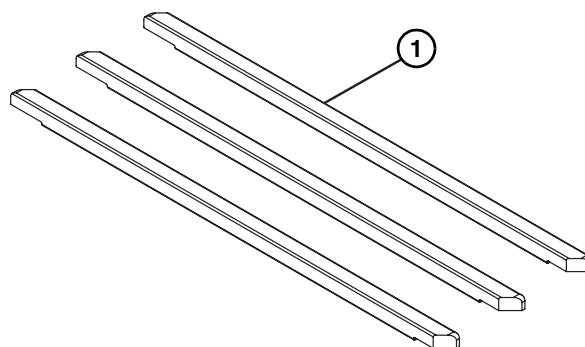


Figure 28

1. Position the wear strips (Figure 29, item 1) on the frame.

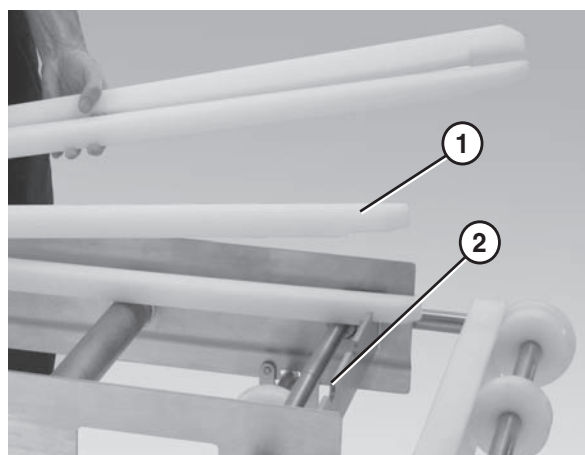


Figure 29

2. Make sure the wear strips are situated securely in the frame slots (Figure 29, item 2).

Installation

Belt Installation

Typical Belt Components (Figure 30)

1	Chain belt
2	Belt rod

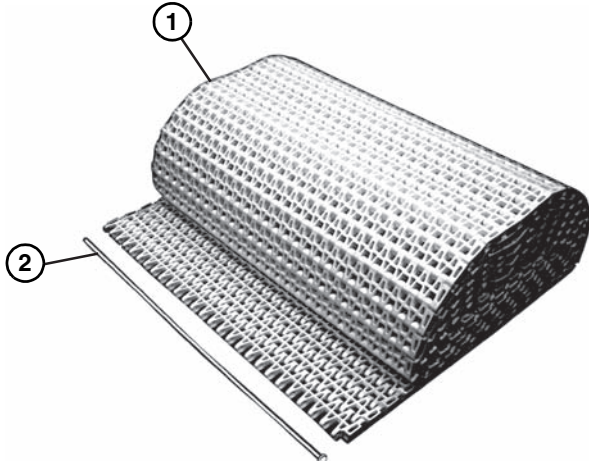


Figure 30

1. Position the belt on the conveyor frame (Figure 31).



Figure 31

2. Wrap the belt around the conveyor, making sure the sprocket teeth have engaged the belt.

3. Bring the ends of the belt together (Figure 32).



Figure 32

4. Insert the belt rod (Figure 33, item 1).

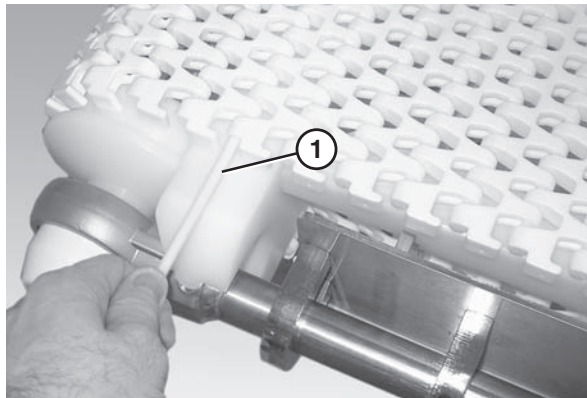


Figure 33

5. Push the belt rod in as far as possible.
6. Lightly tap the head of the rod with a hammer until it snaps into position.
7. Check belt sag by measuring from the top of the return (Figure 34).

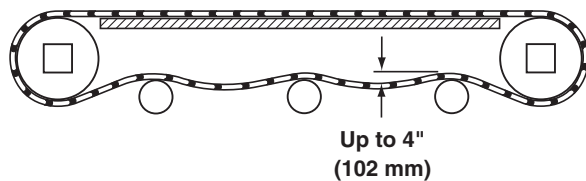


Figure 34

CAUTION

Belt sag should not exceed 4" (102 mm) from the top of the returns.

Belt Return Installation

Typical Belt Return Components (Figure 35)

1	Return shaft
2	Chain return shoe

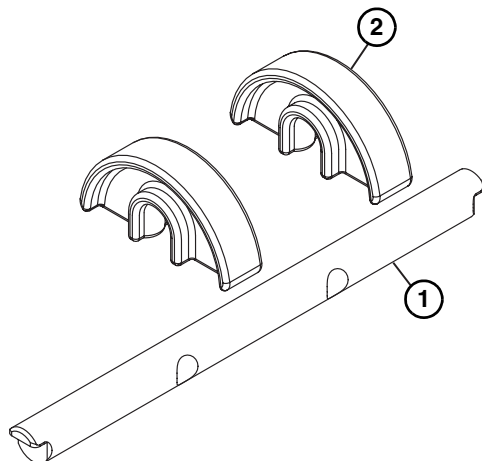


Figure 35

1. Attach the chain return shoes (Figure 36, item 1) to the return shaft (Figure 36, item 2).

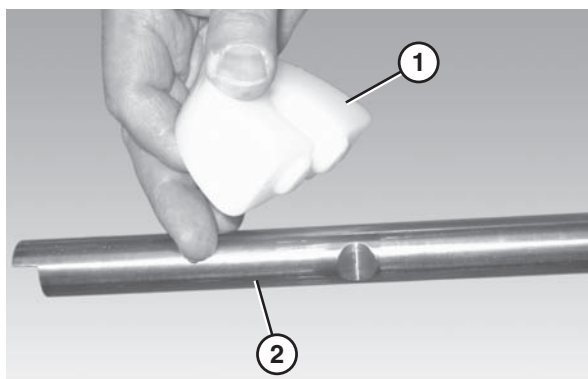


Figure 36

2. Slide the return shaft (Figure 37, item 1) up and through the large slot (Figure 37, item 2) in the frame (picture shown without the belt or wear strips).

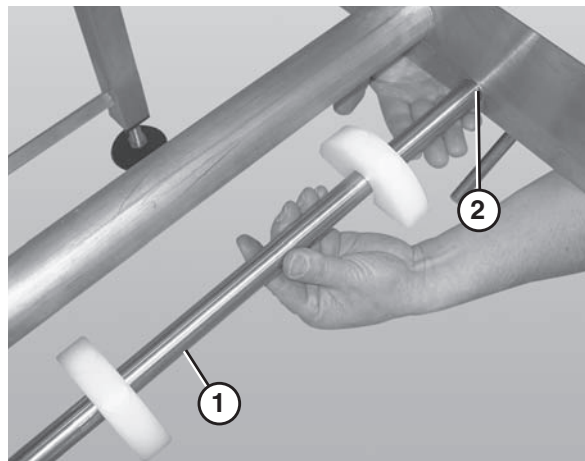


Figure 37

3. Push up on the return shaft (Figure 37, item 1) and slide the notched end of the shaft through the small slot on the opposite side of the frame.
4. See Step 7 of Belt Installation to check for proper belt sag.

Preventive Maintenance and Adjustment

Required Tools

- 17 mm wrench (or adjustable wrench)
- 4 mm hex wrench (for bearing shaft assembly fasteners)
- 3 mm hex wrench
- Punch and hammer (to remove belt rod)

Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 26 for recommendations.
- Replace any worn
- or damaged parts.

Cleaning

NOTE

Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.

CAUTION

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

Routine Cleaning

WARNING



SEVERE HAZARD!

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

Dorner recommends cleaning the inside and the outside of the conveyor on a daily basis. Refer to the following steps to access the inside of the conveyor.

1. Remove the guides, if applicable, by removing the pull pins (**Figure 38, item 1**) that connect the guide (**Figure 38, item 2**) to the frame.

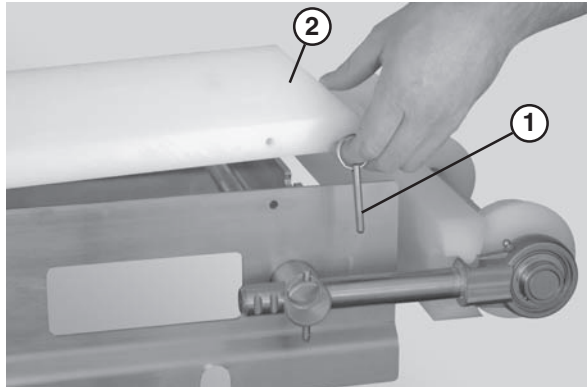


Figure 38

2. Use the lifter handle (**Figure 39, item 1**) to raise the lifters (**Figure 39, item 2**) if applicable, and raise the tip up tail (**Figure 39, item 3**).

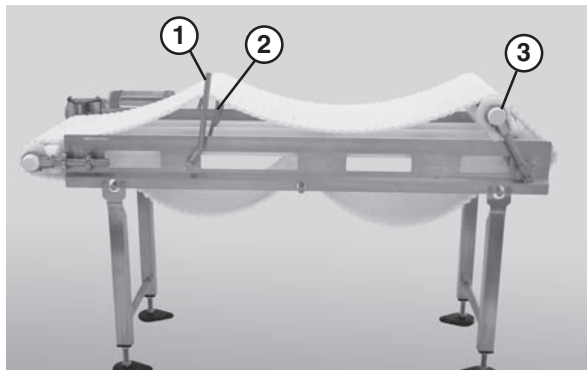


Figure 39

3. If conveyor does not have belt lifters, lift up on belt manually (**Figure 40**).

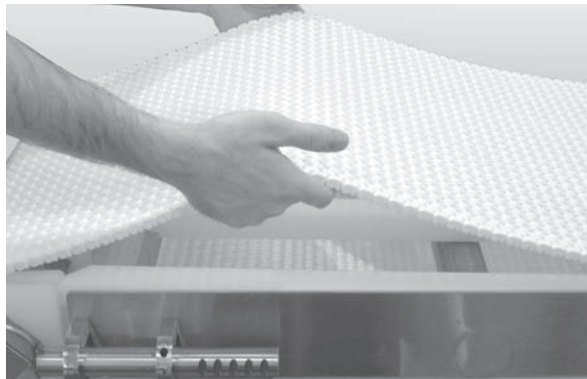


Figure 40

CAUTION

DO NOT submerge or soak bearing assemblies. This will reduce the life of the bearing.

Preventive Maintenance and Adjustment

Periodic Cleaning

Dorner recommends complete disassembly of the conveyor periodically for thorough cleaning.

For conveyor disassembly and reassembly instructions:

- Refer to “Conveyor Belt Replacement” on page 18.
- Refer to “Sprocket and Puck Removal” on page 21.
- Refer to “Slide the nose bar pucks (Figure 63, item 1) off the nose bar shaft (Figure 63, item 2).” on page 23.

Lubrication

Conveyor Bearings

Conveyor bearing lubrication is required. Dorner recommends using an H-1 food grade grease.

NOTE

Although bearings are sealed, re-greasing is recommended to increase bearing life. An H-1 food grade grease is recommended. The frequency of bearing re-greasing is dependent upon the application in which the conveyor is being used. Frequency of re-greasing will increase with the frequency of conveyor washing.

1. Add grease to the bearing using the zerk fitting (**Figure 41, item 1**) on the exterior of the bearing shaft assembly.

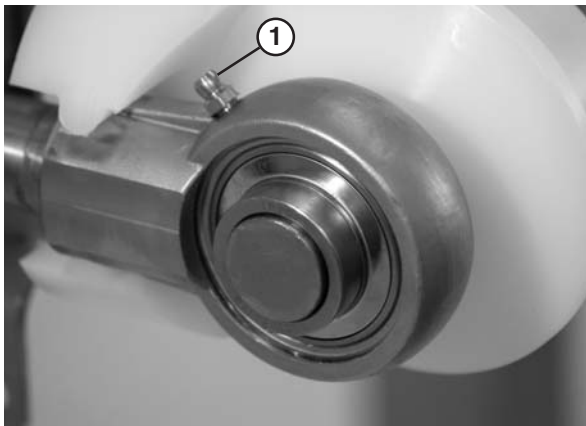


Figure 41

2. Replace the bearings if they become worn.

Wearstrips and Belt Returns

Replace the wearstrips and belt returns if they become worn.

For wearstrip and belt return installation instructions:

- Refer to “Wear Strip Installation” on page 13.
- Refer to “Belt Return Installation” on page 15.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

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

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

Damage to belt links or rods, surface cuts and / or wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories

Skipping indicates:

- Excessive load on belt
- Worn sprockets or impacted dirt on drive pulley

Damage to belt links or rods indicate:

- Excessive load on belt
- Dirt impacted on sprockets
- Excessive or improper side loading
- Improperly positioned accessories

Preventive Maintenance and Adjustment

Conveyor Belt Replacement

⚠ WARNING

SEVERE HAZARD!
LOCK OUT POWER before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

Conveyors with Guides

1. Remove the pull pins (Figure 42, item 1) that connect the guide (Figure 42, item 2) to the frame.

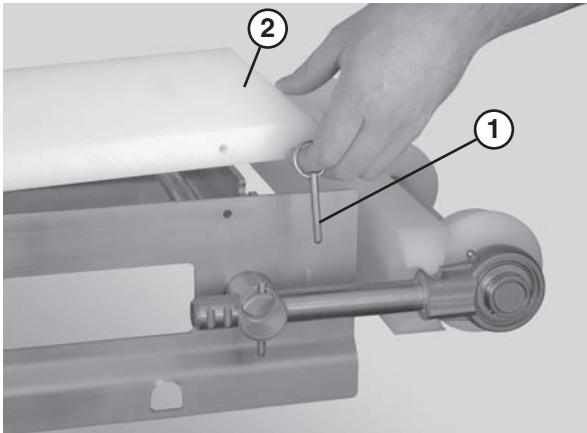


Figure 42

2. Remove the guide (Figure 43, item 1).

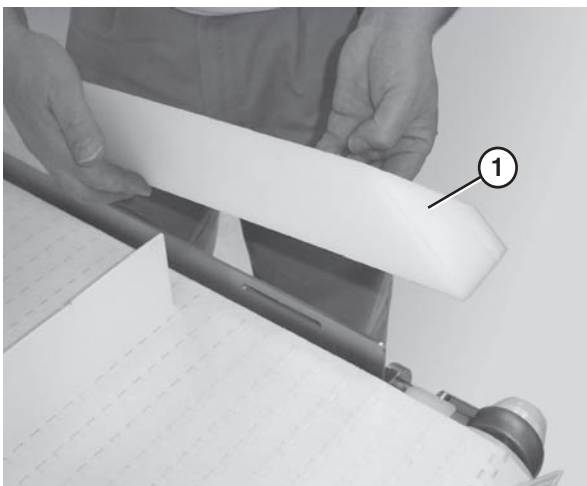


Figure 43

3. Follow the belt replacement procedures described in “Standard Belts” on page 18, “Specialty Intralox 1100 Series Belts” on page 19, or “Specialty Intralox 1600 Series Belts” on page 20.

Standard Belts

Replacing a Section of Belt

⚠ CAUTION
Secure the retaining head side of the belt prior to removing a belt rod in order to prevent damaging the belt.

1. Secure the retaining head side of the belt. Use the belt removal tool (Figure 44, item 1) for 1" pitch belts. For all other belts, position the section of belt so that it is braced by the flanged puck (Figure 44, item 2).

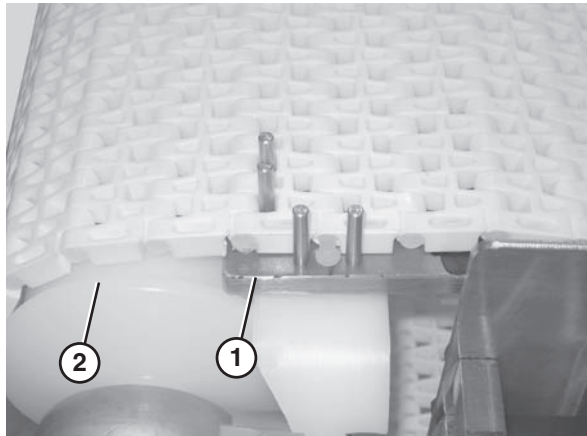


Figure 44

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head (Figure 45).



Figure 45

3. Remove the belt rods on both sides of the section of belt being replaced.
4. Replace the old section with a new section of belt.

⚠ CAUTION
DO NOT reuse belt rods that are damaged or show signs of wear.

Preventive Maintenance and Adjustment

Replacing the Entire Belt

1. Remove the belt returns by pushing up on the return shaft (**Figure 46, item 1**) and sliding it through the large hole (**Figure 46, item 2**) in the frame.

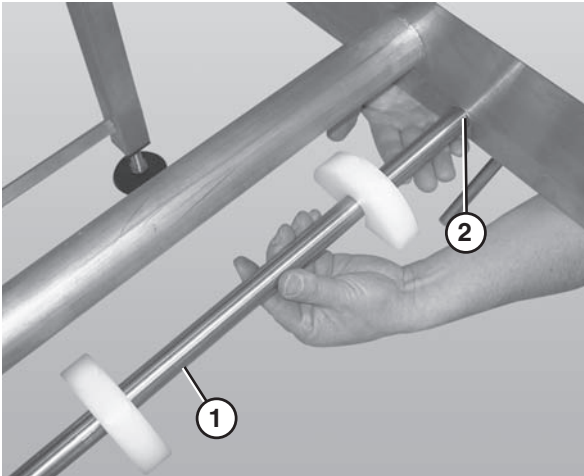


Figure 46

2. Lower the opposite end of the return shaft (**Figure 46, item 1**) and slide it out of the frame.
3. Follow steps 1 – 3 in "Standard Belts: Replacing a Section of Belt" on page 18.
4. Remove the belt.
5. Replace the damaged or worn belt. Refer to "Belt Installation" on page 14 and "Belt Return Installation" on page 15.

Specialty Intralox 1100 Series Belts

Replacing a Section of Belt

1. Place the edge of a flat head screwdriver between the two belt links and turn clockwise (**Figure 47**).

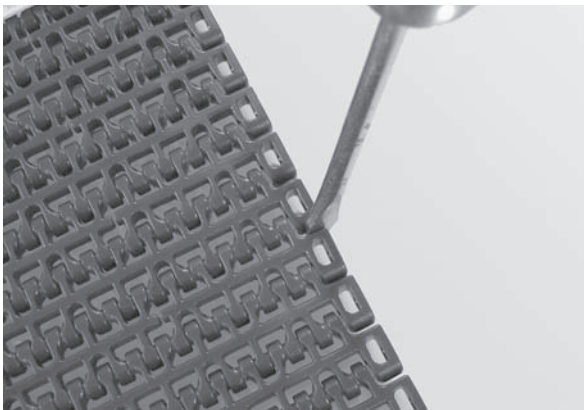


Figure 47

2. Use a second belt rod of the same size to push on the opposite end of the belt rod. (**Figure 48**).

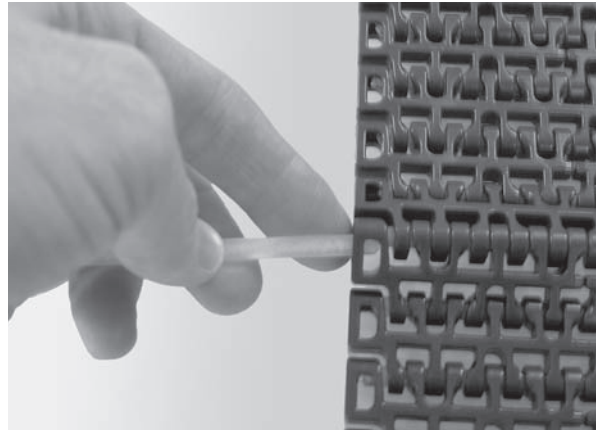


Figure 48

3. Remove the belt rods on both sides of the section of belt being replaced.
4. Replace the old section with a new section of belt.

CAUTION

DO NOT reuse belt rods that are damaged or show signs of wear.

Replacing the Entire Belt

1. Remove the belt returns by pushing up on the return shaft (**Figure 49, item 1**) and sliding it through the large hole (**Figure 49, item 2**) in the frame.

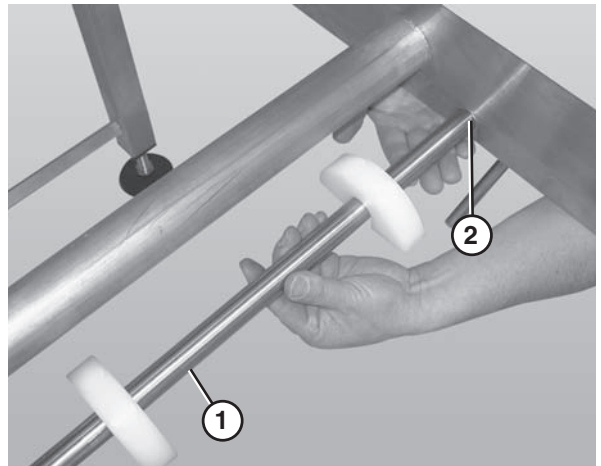


Figure 49

2. Lower the opposite end of the return shaft (**Figure 49, item 1**) and slide it out of the frame.
3. Follow steps 1 – 2 in "Specialty Intralox 1100 Series Belts: Replacing a Section of Belt" on page 19.
4. Remove the belt.
5. Replace the damaged or worn belt. Refer to "Belt Installation" on page 14 and "Belt Return Installation" page 15.

Preventive Maintenance and Adjustment

Specialty Intralox 1600 Series Belts

Replacing a Section of Belt

1. Lift up on the belt to gain access to the underside.
2. Use a flat head screwdriver to raise the end of the belt rod above the retention lip (Figure 50).

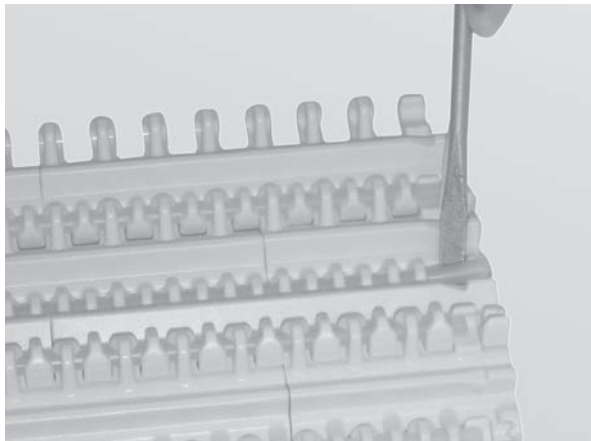


Figure 50

3. Remove the belt rod by gripping the end with a set of pliers and pulling (Figure 51).

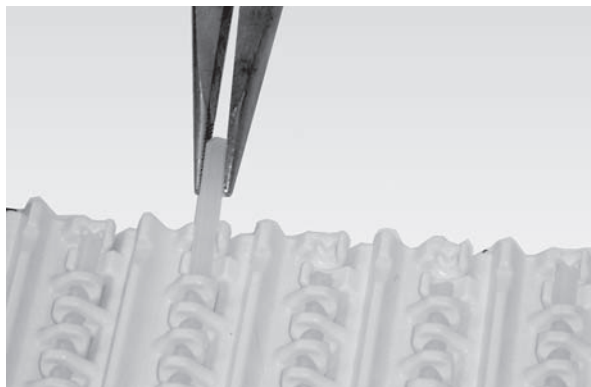


Figure 51

4. Remove the belt rods on both sides of the section of belt being replaced.
5. Replace the old section with a new section of belt.

CAUTION

DO NOT reuse belt rods that are damaged or show signs of wear.

Replacing the Entire Belt

1. Remove the belt returns by pushing up on the return shaft (Figure 52, item 1) and sliding it through the large hole (Figure 52, item 2) in the frame.

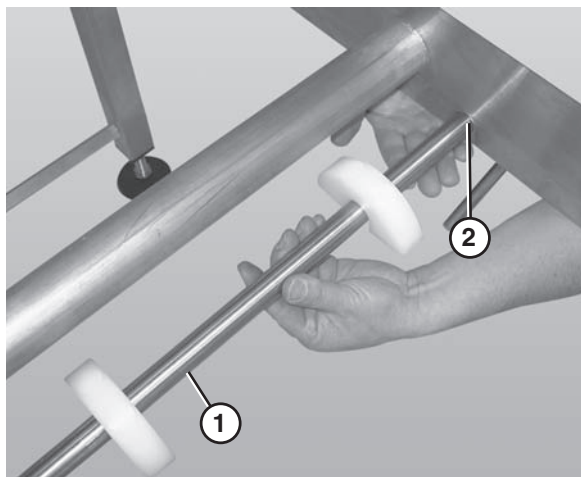


Figure 52

2. Lower the opposite end of the return shaft (Figure 52, item 1) and slide it out of the frame.
3. Follow steps 1 – 2 in "Specialty Intralox 1600 Series Belts: Replacing a Section of Belt" on page page 20.
4. Remove the belt.
5. Replace the damaged or worn belt. Refer to "Belt Installation" on page 14 and "Belt Return Installation" page 15.

Conveyor Belt Tensioning

WARNING



SEVERE HAZARD!

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

CAUTION

Belt sag should not exceed 4" (102 mm) from the top of the returns.

1. Check belt for proper sag. Refer to step 7 of "Belt Installation" on page 14.
2. If belt has excessive sag, remove one or more belt links to take up the tension. Refer to "Replacing a Section of Belt" on page 18.

Preventive Maintenance and Adjustment



Sprocket and Puck Removal

 WARNING

SEVERE HAZARD! LOCK OUT POWER before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

1. Remove the conveyor belt to access the sprockets / pucks. Refer to “Conveyor Belt Replacement” on page 18.
2. Remove the desired sprocket / puck by following these instructions:
 - A - Drive Sprocket Removal
 - B - Idler Puck Removal
 - C - Nose Bar Puck Removal

A - Drive Sprocket Removal

 WARNING

PUNCTURE HAZARD! Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.

1. Remove the bolts that connect the motor to the drive assembly (**Figure 53, item 3**).

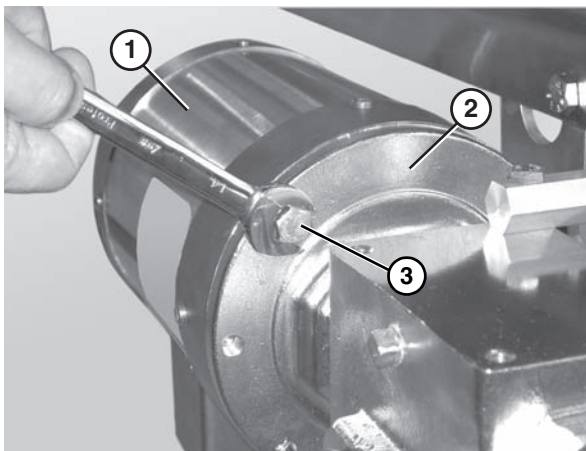


Figure 53

2. Remove the motor (**Figure 53, item 1**) from the drive assembly (**Figure 53, item 2**).

3. Using a hex wrench, loosen the allen head screws (**Figure 54, item 1**) that connect the gearmotor to the drive spindle. Repeat on opposite side of gearmotor.

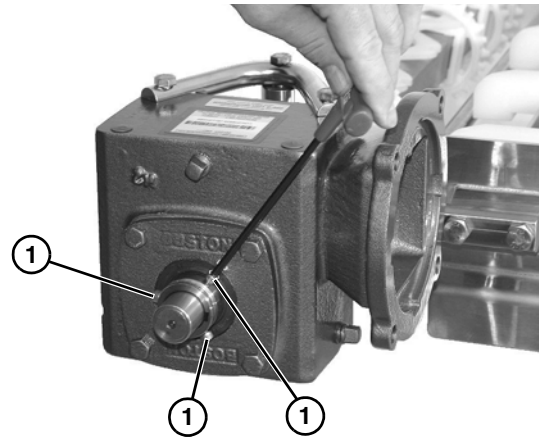


Figure 54

4. Remove top bolt (**Figure 55, item 1**) and spacer (**Figure 55, item 2**) holding the bracket (**Figure 55, item 3**) to the drive assembly.

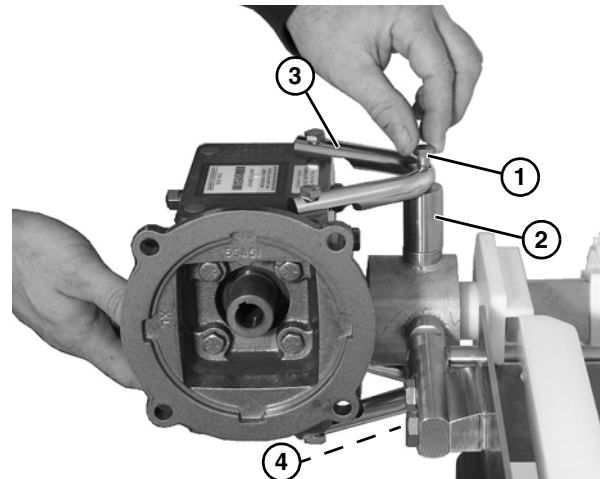


Figure 55

5. Remove bottom bolt (**Figure 55, item 4**).
6. Slide assembly off the bearing spindle (**Figure 56**). Remove the key (**Figure 56, item 1**).

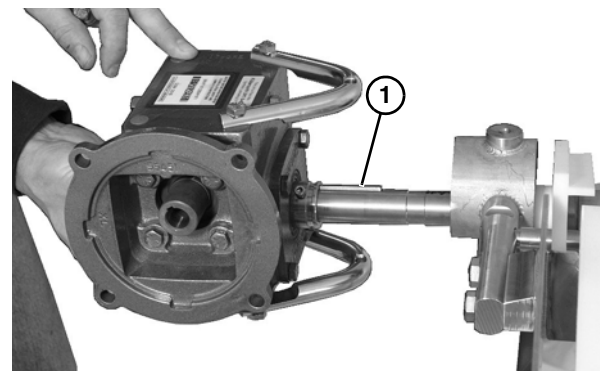


Figure 56

Preventive Maintenance and Adjustment

- Remove two bolts (**Figure 57, item 1**) on each side, and slide the drive tail assembly (**Figure 57, item 2**) off the mounting posts (**Figure 57, item 3**).

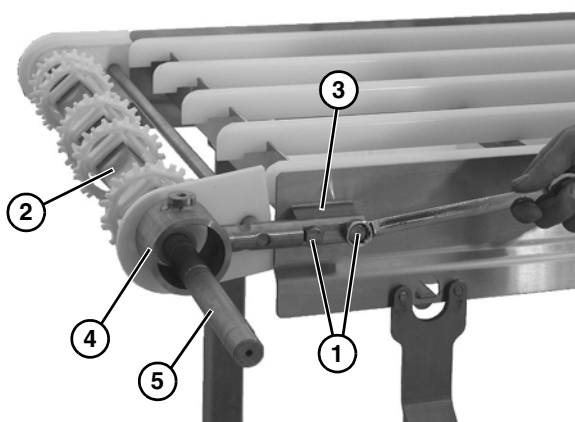


Figure 57

- Slide the motor support bracket (**Figure 57, item 4**) off the drive spindle shaft (**Figure 57, item 5**).
- Remove the bearing cover from bearing shaft assembly (**Figure 58, item 1**).

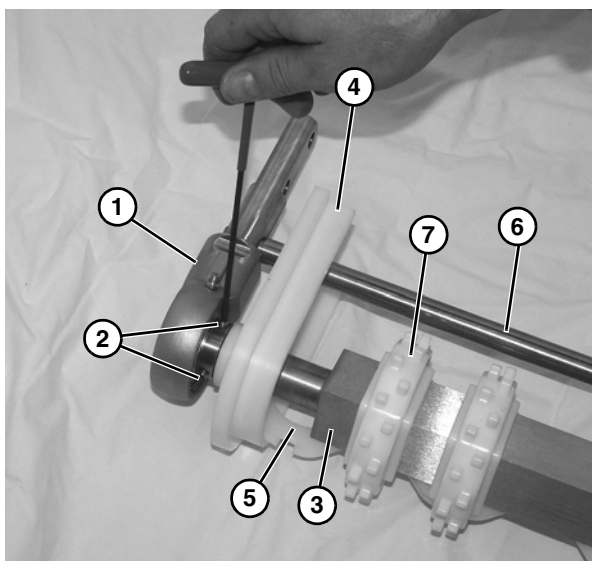


Figure 58

- Use a hex wrench to loosen two set screws (**Figure 58, item 2**) on the bearing shaft assembly (**Figure 58, item 1**).
- Slide the bearing shaft assembly off of the drive spindle (**Figure 58, item 3**). Slide bearing shaft assembly off the drive spindle on opposite side.
- Remove pinch guard (**Figure 58, item 4**) on each side.
- Remove sprocket alignment bar (**Figure 58, item 5**), and pinch guard shaft (**Figure 58, item 6**).
- Remove the sprockets (**Figure 58, item 7**).

B - Idler Puck Removal

- Remove bolt (**Figure 59, item 1**) from each side, and remove idler tail assembly (**Figure 59, item 2**) from take up blocks (**Figure 59, item 3**).

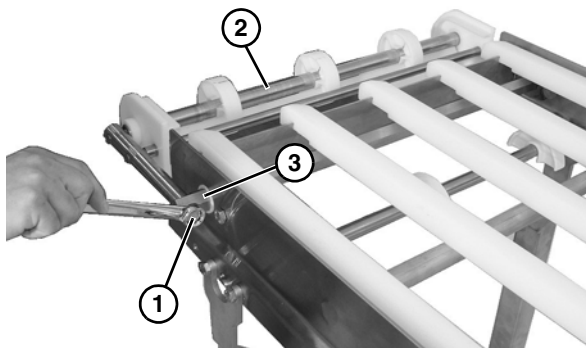


Figure 59

- Remove the bearing end rod (**Figure 60, item 1**) from idler shaft (**Figure 60, item 2**) and pinch guard shaft (**Figure 60, item 3**).

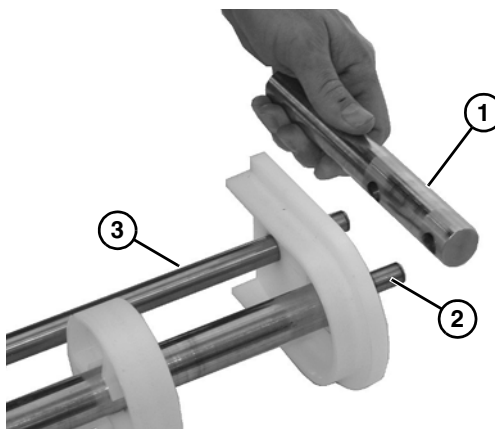


Figure 60

- Remove pinch guard (**Figure 61, item 1**) from idler shaft (**Figure 61, item 2**) and pinch guard shaft (**Figure 61, item 3**).

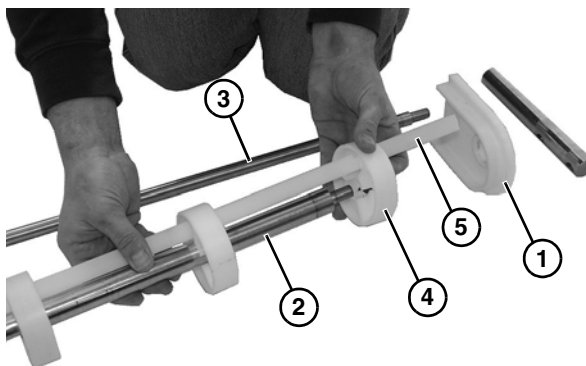


Figure 61

- Slide the pucks (**Figure 61, item 4**) and alignment bar (**Figure 61, item 5**) off the idler shaft (**Figure 61, item 2**).

Preventive Maintenance and Adjustment

C - Nose Bar Puck Removal

1. Slide the nose bar drive or transfer post (**Figure 62, item 1**) out of the nose bar drive weldment or idler hands (**Figure 62, item 2**).

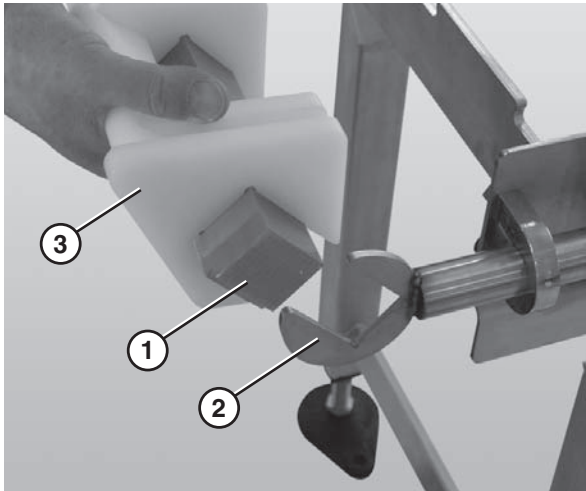


Figure 62

2. Remove the nose bar tracking pucks (**Figure 62, item 3**), if applicable.
3. Remove the nose bar wear strip (**Figure 63, item 3**).

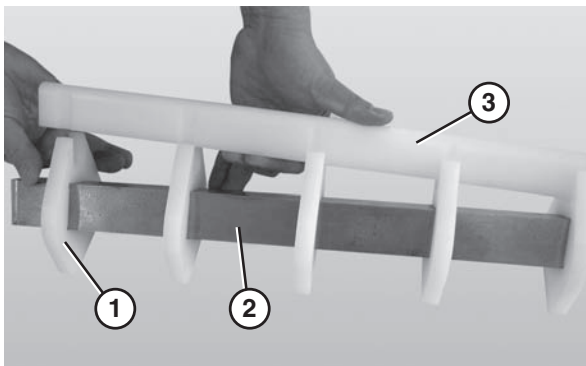


Figure 63

4. Slide the nose bar pucks (**Figure 63, item 1**) off the nose bar shaft (**Figure 63, item 2**).

Reassembling Tail Assemblies

Refer to the "Service Parts" section starting on page 26 for complete diagrams and lists of all tail assembly components.

Nose Bar Idler

1. Slide the nose bar pucks (**Figure 64, item 1**) onto the nose bar drive post (**Figure 64, item 2**).

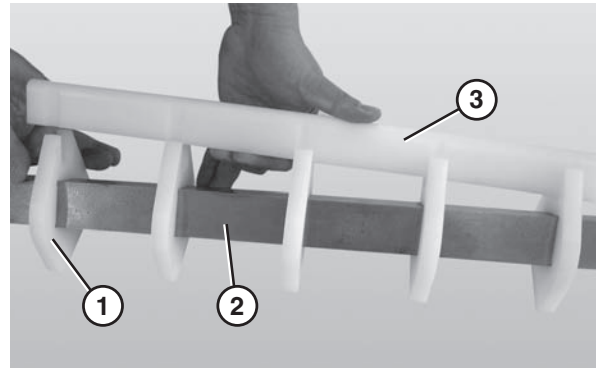


Figure 64

2. Attach the nose bar wear strip (**Figure 64, item 3**).
3. Attach the nose bar tracking pucks (**Figure 65, item 1**) to the nose bar drive post (**Figure 65, item 2**).

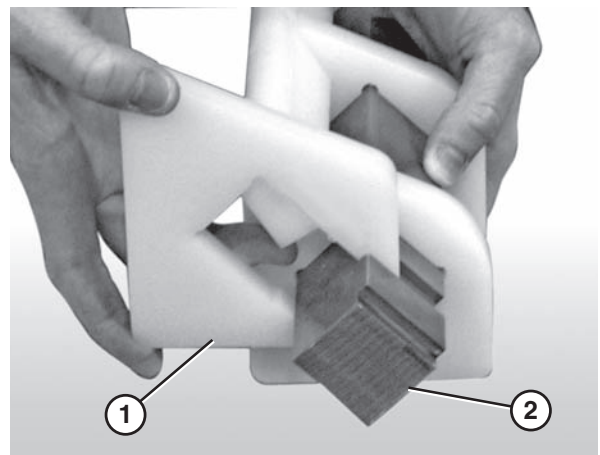


Figure 65

4. After all tracking pucks (**Figure 66, item 3**) are installed, slide the nose bar drive or transfer post (**Figure 66, item 1**) into the nose bar drive weldment or idler hands (**Figure 66, item 2**).

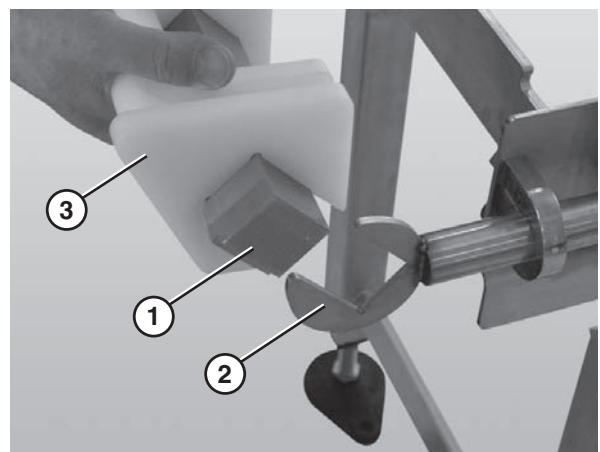


Figure 66

Preventive Maintenance and Adjustment

Idler Tail

1. Place the pucks (Figure 67, item 1) into the slots (Figure 67, item 2) of alignment bar (Figure 67, item 3), and install onto the idler shaft (Figure 67, item 4).

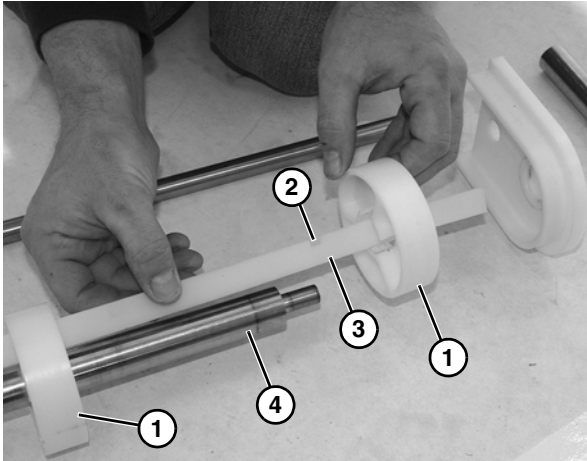


Figure 67

2. Slide all the idler pucks (Figure 68, item 1) along with alignment bar onto idler shaft (Figure 68, item 2).

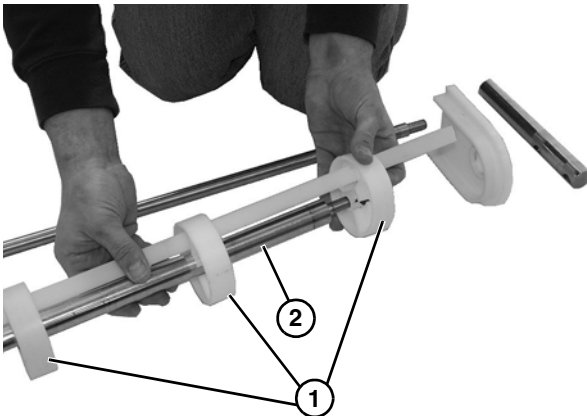


Figure 68

3. Install the pinch guard (Figure 69, item 1) to each side onto idler shaft (Figure 69, item 2) and pinch guard shaft (Figure 69, item 3).

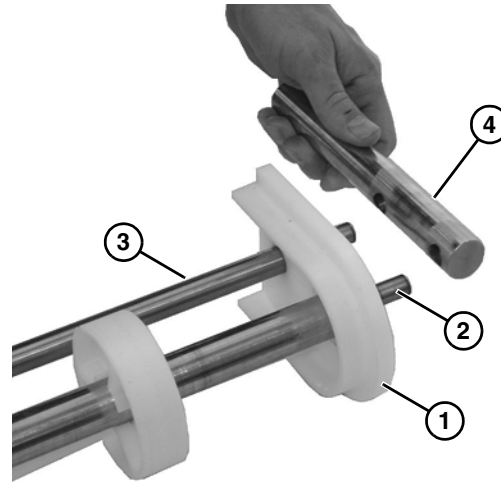


Figure 69

4. Install the bearing end rod (Figure 69, item 4) onto idler shaft (Figure 69, item 2) and rod (Figure 69, item 3).

Drive Tail

1. Assemble sprockets (Figure 70, item 1) to the slots (Figure 70, item 2) of alignment bar (Figure 70, item 3), and install assembly onto drive spindle (Figure 70, item 4).

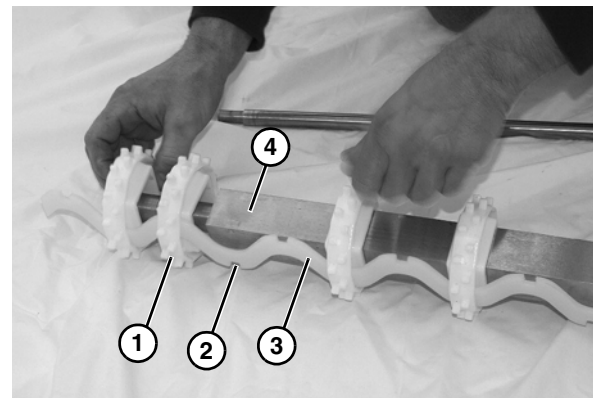


Figure 70

2. Slide the entire assembly onto the drive spindle (Figure 71).

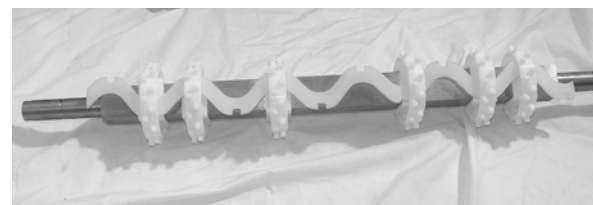


Figure 71

Preventive Maintenance and Adjustment

3. Install pinch guard shaft (**Figure 72, item 1**) onto pinch guard (**Figure 72, item 2**).

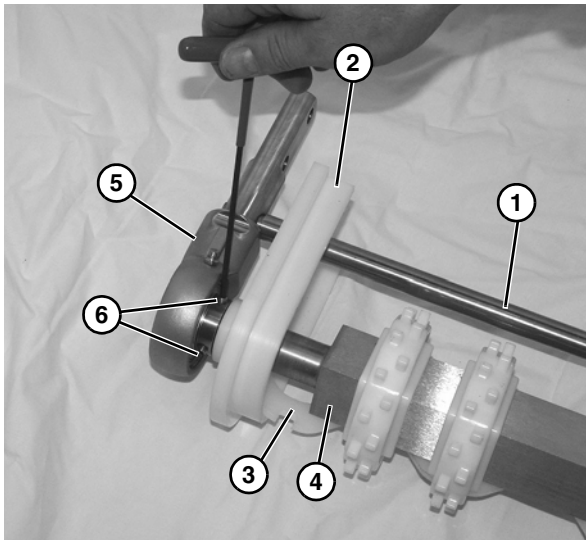


Figure 72

4. Install pinch guard (**Figure 72, item 2**) onto alignment bar (**Figure 72, item 3**), and onto each side of drive spindle (**Figure 72, item 4**).
5. Install bearing shaft assembly (**Figure 72, item 5**) onto rod (**Figure 72, item 1**) and drive spindle (**Figure 72, item 4**). Slide bearing shaft assembly onto the drive spindle on opposite side.
6. Use a hex wrench to install the two set screws (**Figure 72, item 6**). Use a torque wrench to tighten them to 54 in•lbs (6 N•m). Check after 24 hours of conveyor use.
7. Attach the bearing cover onto bearing shaft assembly (**Figure 72, item 5**).

Bearing Replacement

1. Secure the bearing shaft in the take up blocks.
2. Insert the rod end of a second bearing shaft through the bearing (**Figure 73**).



Figure 73

3. Apply lateral pressure to the rod until the bearing comes loose.
4. Remove the worn or damaged bearing (**Figure 74**).

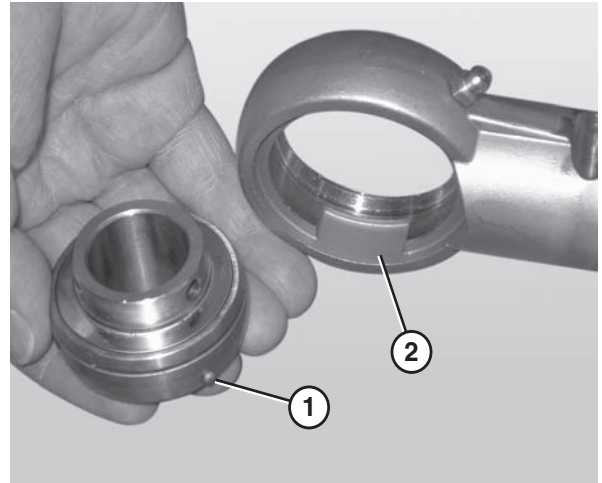


Figure 74

5. Replace the bearing.

NOTE

*When inserting the new bearing, make sure the anti-rotation notch (**Figure 74, item 1**) on the bearing lines up with the groove inside the housing (**Figure 74, item 2**).*

LPZ Knuckles

Wearstrips and Belt Returns


Replace the wearstrips and belt returns if they become worn.

For wearstrip and belt return installation instructions:

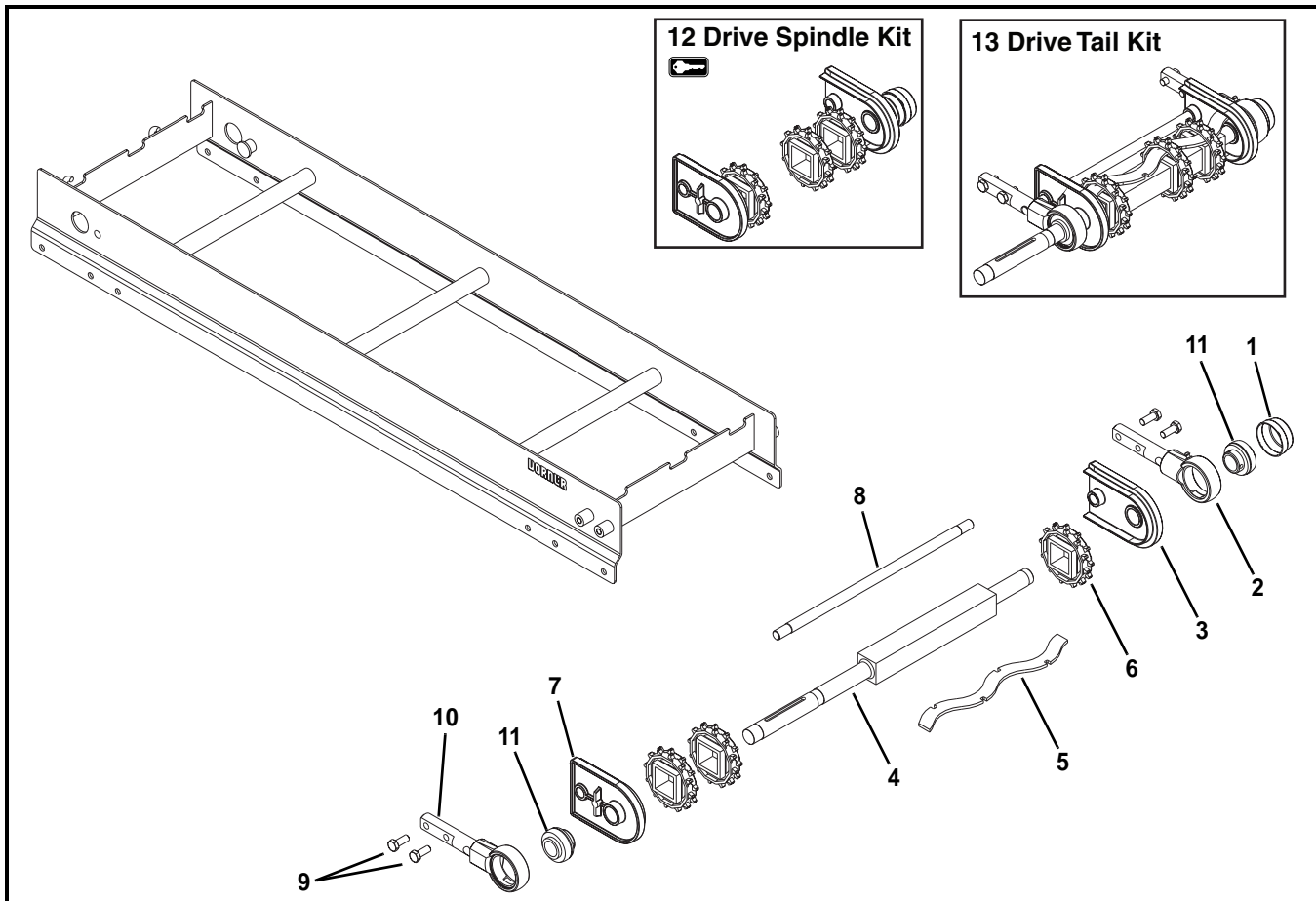
- For wearstrips, replace as needed, making sure wear strips are situated securely in the frame slots.
- For belt returns, Refer to “Belt Return Installation” on page 15.

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.

Drive End Components



Item	Part Number	Description
1	807-1454	Bearing Cover
2	506365	Shaft Assembly with Bearing
3	506326- <u>WW</u>	Tracking Plate for Standard Belt
	506331- <u>WW</u>	Tracking Plate for Specialty Intralox Belt
4	5015 <u>WW</u>	Drive Spindle for Standard Belt
	5070 <u>WW</u>	Drive Spindle for Specialty Intralox Belt
	5295 <u>WW</u>	CE Drive Spindle for Standard Belt
	5294 <u>WW</u>	CE Drive Spindle for Specialty Intralox Belt

Item	Part Number	Description
5	5085 <u>WW</u>	Sprocket Alignment Bar for Standard 1.00" Pitch Belt
	5087 <u>WW</u>	Sprocket Alignment Bar for Specialty Intralox .60" Pitch Belt
	5088 <u>WW</u>	Sprocket Alignment Bar for Specialty Intralox 1.00" Pitch Belt
6	807-1444	Sprocket for Standard 1.00" Pitch Belt
	807-1446	Sprocket for Specialty Intralox .60" Pitch Belt
	807-1445	Sprocket for Specialty Intralox 1.00" Pitch Belt

Service Parts

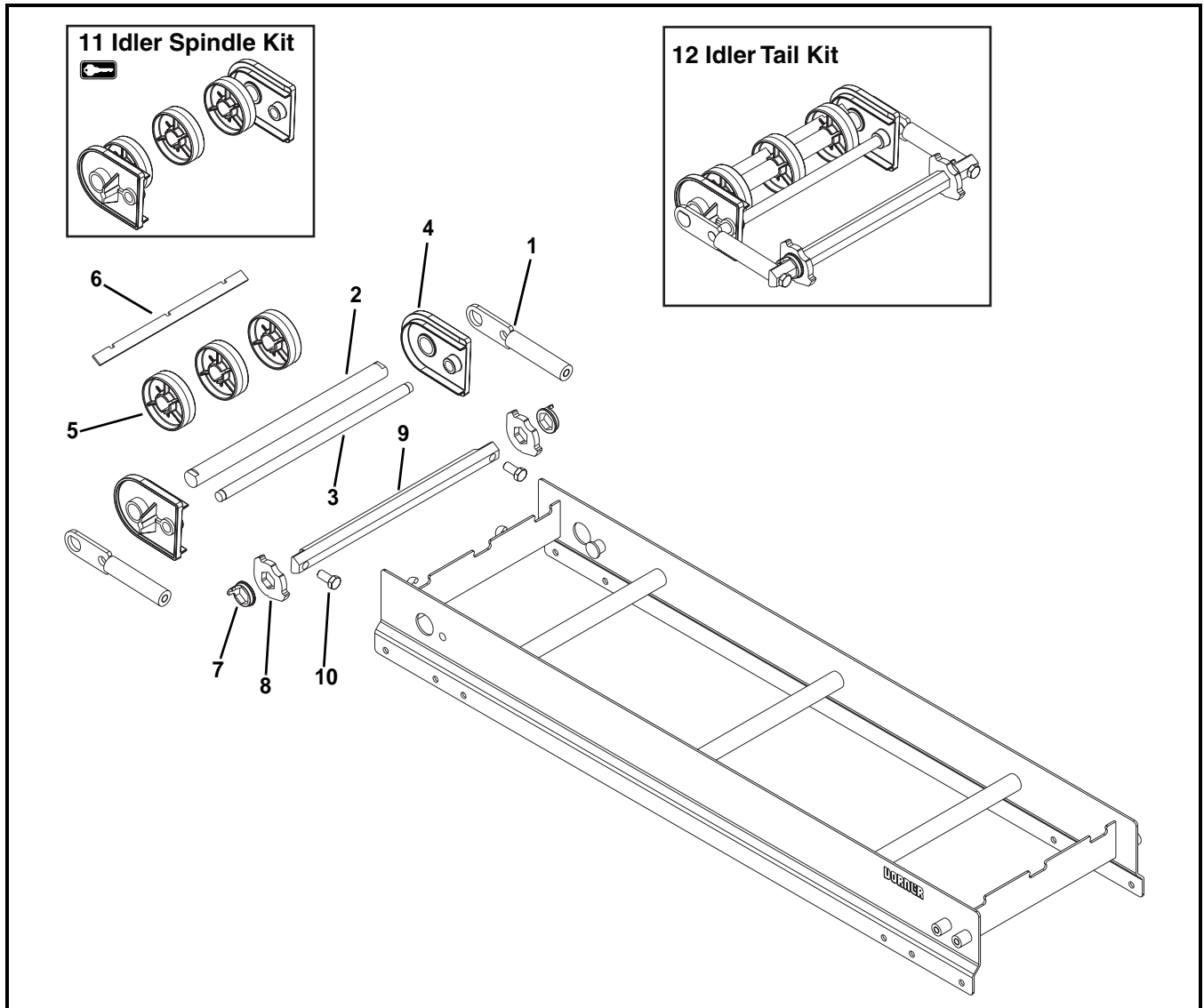
Item	Part Number	Description
7	506330- <u>WW</u>	Drive Side Tracking Plate for Standard Belt when Conveyor is ordered with a Dorner Gearmotor Mounting Package
	506326- <u>WW</u>	Drive Side Tracking Plate for Standard Belt when Conveyor is ordered without a Dorner Gearmotor Mounting Package
	506333- <u>WW</u>	Drive Side Tracking Plate for Specialty Intralox Belt when Conveyor is ordered with a Dorner Gearmotor Mounting Package
	506331- <u>WW</u>	Drive Side Tracking Plate for Specialty Intralox Belt when Conveyor is ordered without a Dorner Gearmotor Mounting Package
8	506358- <u>WW</u>	Pinch Guard Shaft
9	961025MSS	Hex Head Cap Screw M10-1.50 x 25mm
10*	506365	Shaft Assembly with Bearing
11	802-162	Bearing
12	74DD25X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1, 3, 6, 7 and 11)
	74DD11X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1, 3, 6, 7 and 11)
	74DD16X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1, 3, 6, 7 and 11)
	74DC25X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1, 3, 6, 7 and 11)
	74DC11X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1, 3, 6, 7 and 11)
	74DC16X- <u>WW</u>	Drive Spindle Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1, 3, 6, 7 and 11)

Item	Part Number	Description
13**	74DDCT25X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1 through 10)
	74DDCT11X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1 through 10)
	74DDCT16X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1 through 10)
	74DDDT25X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Standard Belt (Includes Items 1 through 10)
	74DDDT11X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Belt (Includes Items 1 through 10)
	74DDDT16X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Belt (Includes Items 1 through 10)
<u>WW</u> = Conveyor width ref: 06 - 60 in 02 increments		
* When the conveyor is ordered with a Dorner gearmotor mounting package the shaft assembly is replaced with a gearmotor mounting bracket.		
** Drive Tail Kits are not available for CE conveyors.		

Service Parts

Sprocket Quantity (Item 6)	
Width	Sprocket Quantity
6" (152 mm)	2
8" (203 mm)	2
10" (254 mm)	3
12" (305 mm)	3
14" (356 mm)	4
16" (406 mm)	4
18" (457 mm)	5
20" (508 mm)	5
22" (559 mm)	6
24" (610 mm)	6
26" (660 mm)	7
28" (711 mm)	7
30" (762 mm)	8
32" (813 mm)	8
34" (864 mm)	9
36" (914 mm)	9
38" (965 mm)	10
40" (1016 mm)	10
42" (1067 mm)	11
44" (1118 mm)	11
46" (1168 mm)	12
48" (1219 mm)	12
50" (1270 mm)	13
52" (1321 mm)	13
54" (1372 mm)	14
56" (1422 mm)	14
58" (1473 mm)	15
60" (1524 mm)	15

Tension End Components



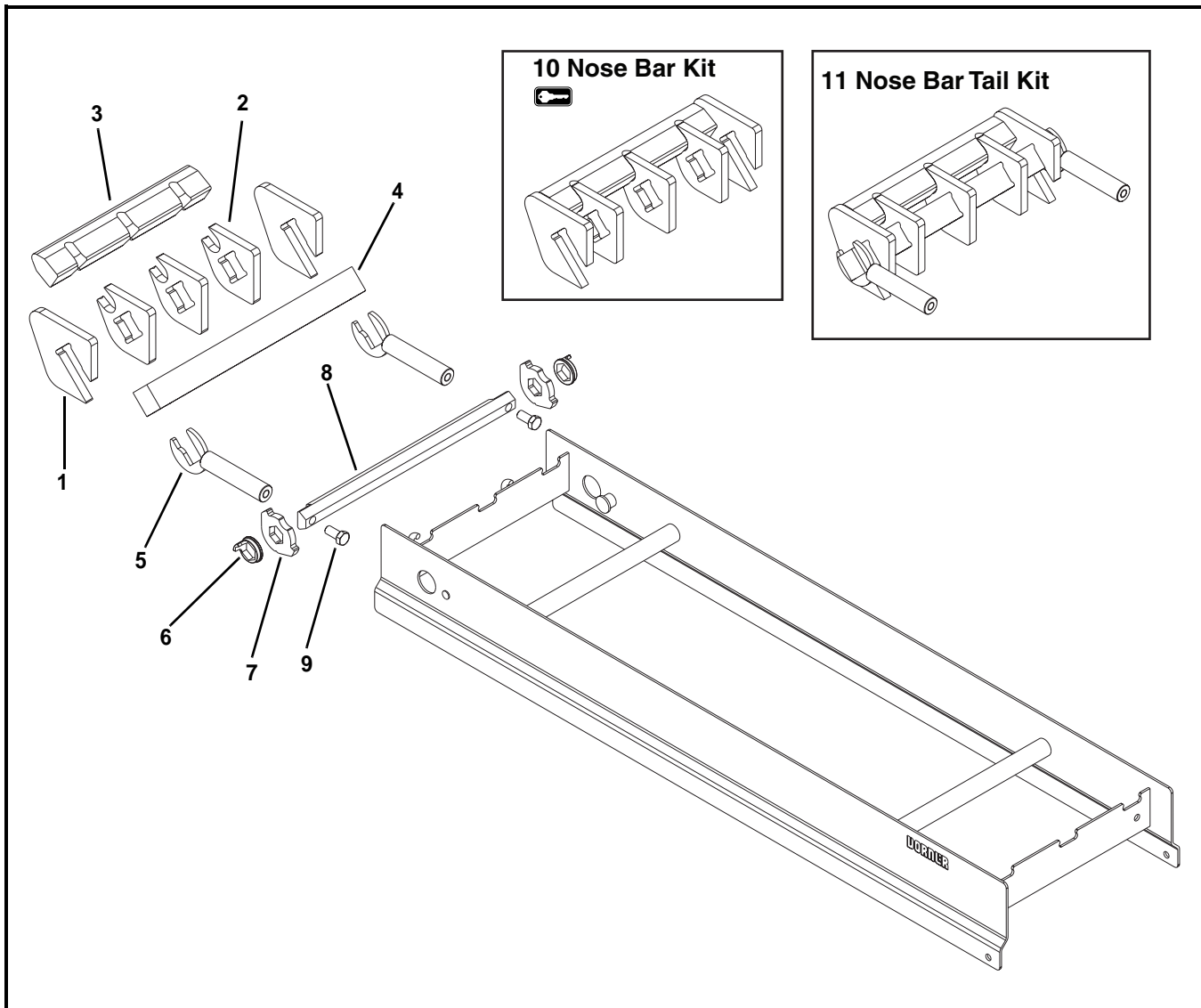
Item	Part Number	Description
1	506801	Shaft Assembly
2	506397- <u>WW</u>	Idler Shaft
3	506396- <u>WW</u>	Pinch Guard Shaft
4	506327- <u>WW</u>	Tracking Plate for Standard Belt
	506332- <u>WW</u>	Tracking Plate for Specialty Intralox Belt
5	506297	Idler Puck
6	506313- <u>WW</u>	Alignment Bar for Standard Belt
	506314- <u>WW</u>	Alignment Bar for Specialty Intralox Belt

Item	Part Number	Description
7	506307	Tip Up Sleeve
8	506356	Stop Key
9	506328- <u>WW</u>	Hex Bar
10	961225MSS	Hex Head Cap Screw M12-1.75 x 25mm
11	74IX- <u>WW</u>	Idler Spindle Tail Kit for Standard Belt (Includes Items 4 and 5)
	74ISX- <u>WW</u>	Idler Spindle Tail Kit for Specialty Intralox Belt (Includes Items 4 and 5)
12	74ITX- <u>WW</u>	Idler Tail Kit for Standard Belt (Includes Items 1 through 10)
	74ITSX- <u>WW</u>	Idler Tail Kit for Specialty Intralox Belt (Includes Items 1 through 10)

WW = Conveyor width ref: 06 - 60 in 02 increments

Service Parts

Nose Bar Tension End

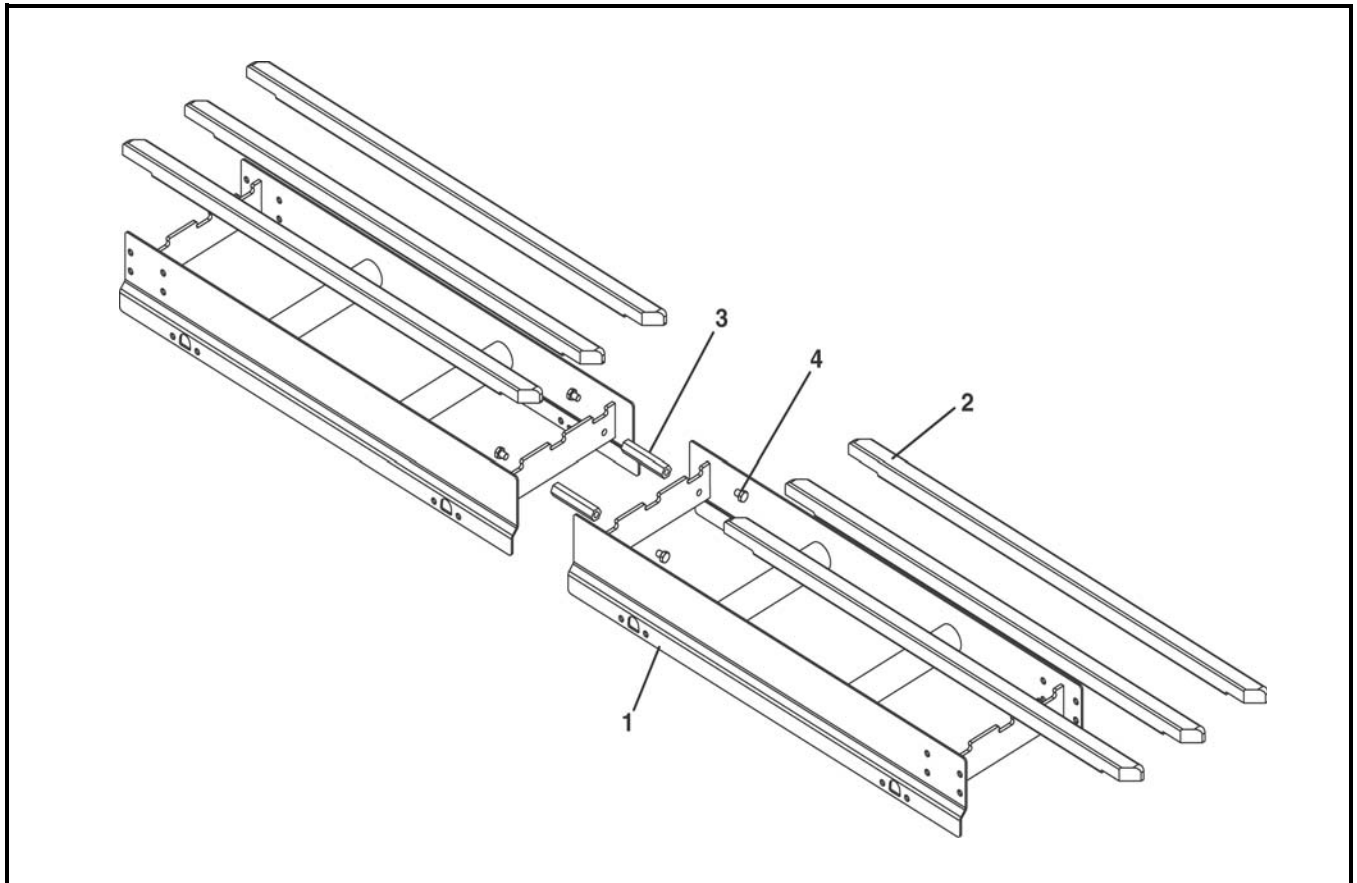


Item	Part Number	Description
1	500490	Nose Bar Tracking Puck
2	500278	Nose Bar Puck
3	5056WW	.5" Pitch Nose Bar Wear Strip
	5058WW	1" Pitch Nose Bar Wear Strip
4	5037WW	Nose Bar Transfer Post for Standard Belt
	5076WW	Nose Bar Transfer Post for Specialty Intralox Belt
5	506363	Nose Bar Idler Shaft
6	506307	Tip Up Sleeve
7	506356	Stop Key
8	506328-WW	Hex Bar
9	961225MSS	Hex Head Cap Screw M12-1.75 x 25mm

Item	Part Number	Description
10	74NB5X-WW	.5" Nose Bar Kit (Includes Items 1 through 3)
	74NB1X-WW	1" Nose Bar Kit (Includes Items 1 through 3)
11	74NBT5X-WW	.5" Nose Bar Tail Kit, for Standard Belt (Includes Items 1 through 5)
	74NBT1X-WW	1" Nose Bar Tail Kit, for Standard Belt (Includes Items 1 through 5)
	74NBT5X-WW	.5" Nose Bar Tail Kit, for Specialty Intralox Belt (Includes Items 1 through 5)
	74NBT1SX-WW	1" Nose Bar Tail Kit, for Specialty Intralox Belt (Includes Items 1 through 5)

WW = Conveyor width ref: 06 - 60 in 02 increments

Conveyor Frame and Extension



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	501800-LLL	Straight Wear Strip
3	500193	Hex Post Connector
4	961016MSS	Hex Head Cap Screw M10-1.5x16mm

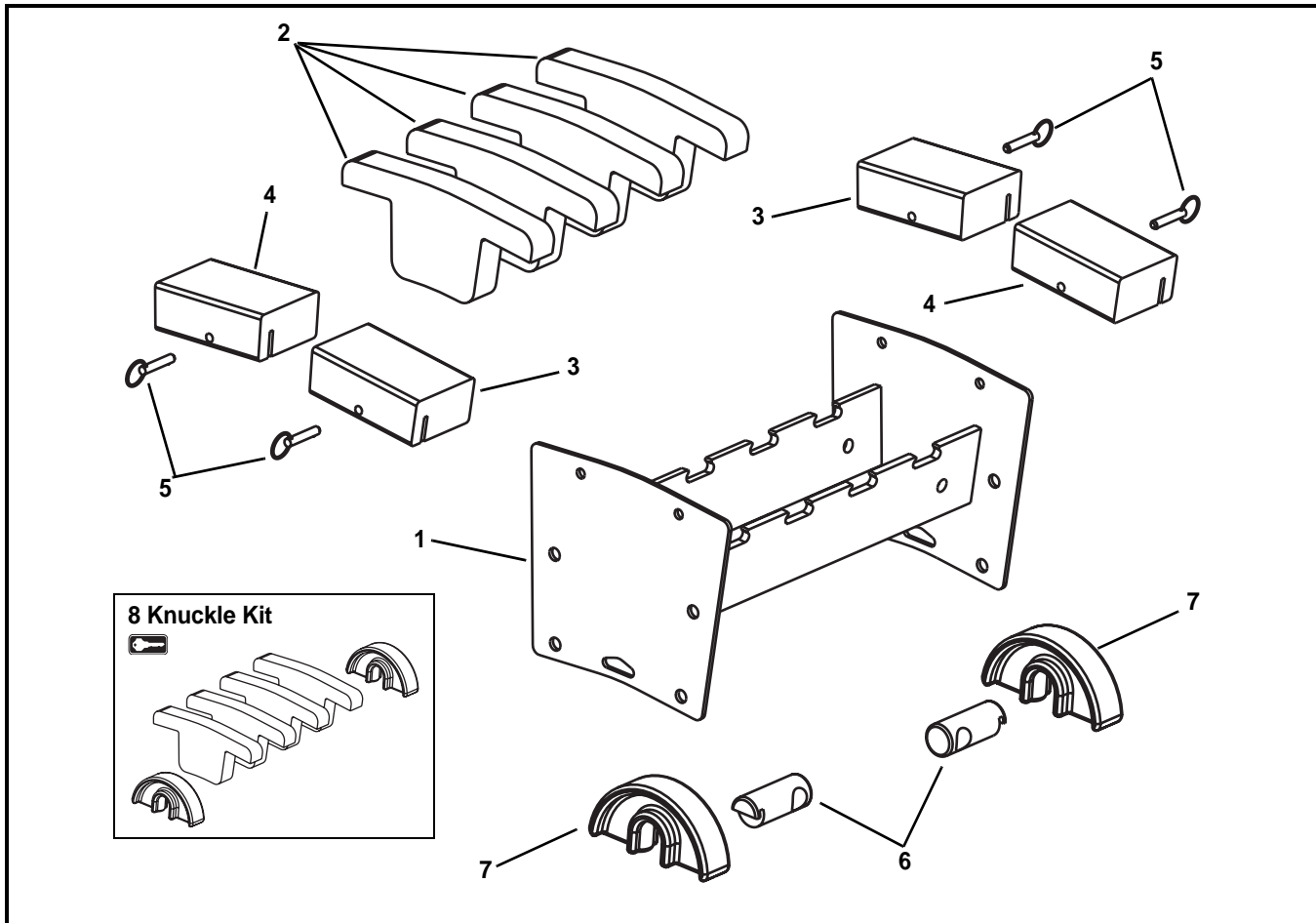
LLL = Conveyor length ref: 036 - 999 in 001 increments

		Wear Strip Quantity (Item 2)							
		Conveyor Length (LLL)							
		036-132	133-252	253-372	373-492	493-612	613-732	733-852	853-999
Conveyor Width (WWW)	06	2	4	6	8	10	12	14	16
	08	2	4	6	8	10	12	14	16
	10	3	6	9	12	15	18	21	24
	12	3	6	9	12	15	18	21	24
	14	3	6	9	12	15	18	21	24
	16	4	8	12	16	20	24	28	32
	18	4	8	12	16	20	24	28	32
	20	5	10	15	20	25	30	35	40
	22	5	10	15	20	25	30	35	40
	24	5	10	15	20	25	30	35	40

		Wear Strip Quantity (Item 2)							
		Conveyor Length (LLL)							
		036-132	133-252	253-372	373-492	493-612	613-732	733-852	853-999
Conveyor Width (WWW)	26	6	12	18	24	30	36	42	48
	28	6	12	18	24	30	36	42	48
	30	6	12	18	24	30	36	42	48
	32	7	14	21	28	35	42	49	56
	34	7	14	21	28	35	42	49	56
	36	8	16	24	32	40	48	56	64
	38	8	16	24	32	40	48	56	64
	40	8	16	24	32	40	48	56	64
	42	9	18	27	36	45	54	63	72
	44	9	18	27	36	45	54	63	72
	46	9	18	27	36	45	54	63	72
	48	10	20	30	40	50	60	70	80
	50	10	20	30	40	50	60	70	80
	52	11	22	33	44	55	66	77	88
	54	11	22	33	44	55	66	77	88
	56	11	22	33	44	55	66	77	88
58	12	24	36	48	60	72	84	96	
60	12	24	36	48	60	72	84	96	

Service Parts

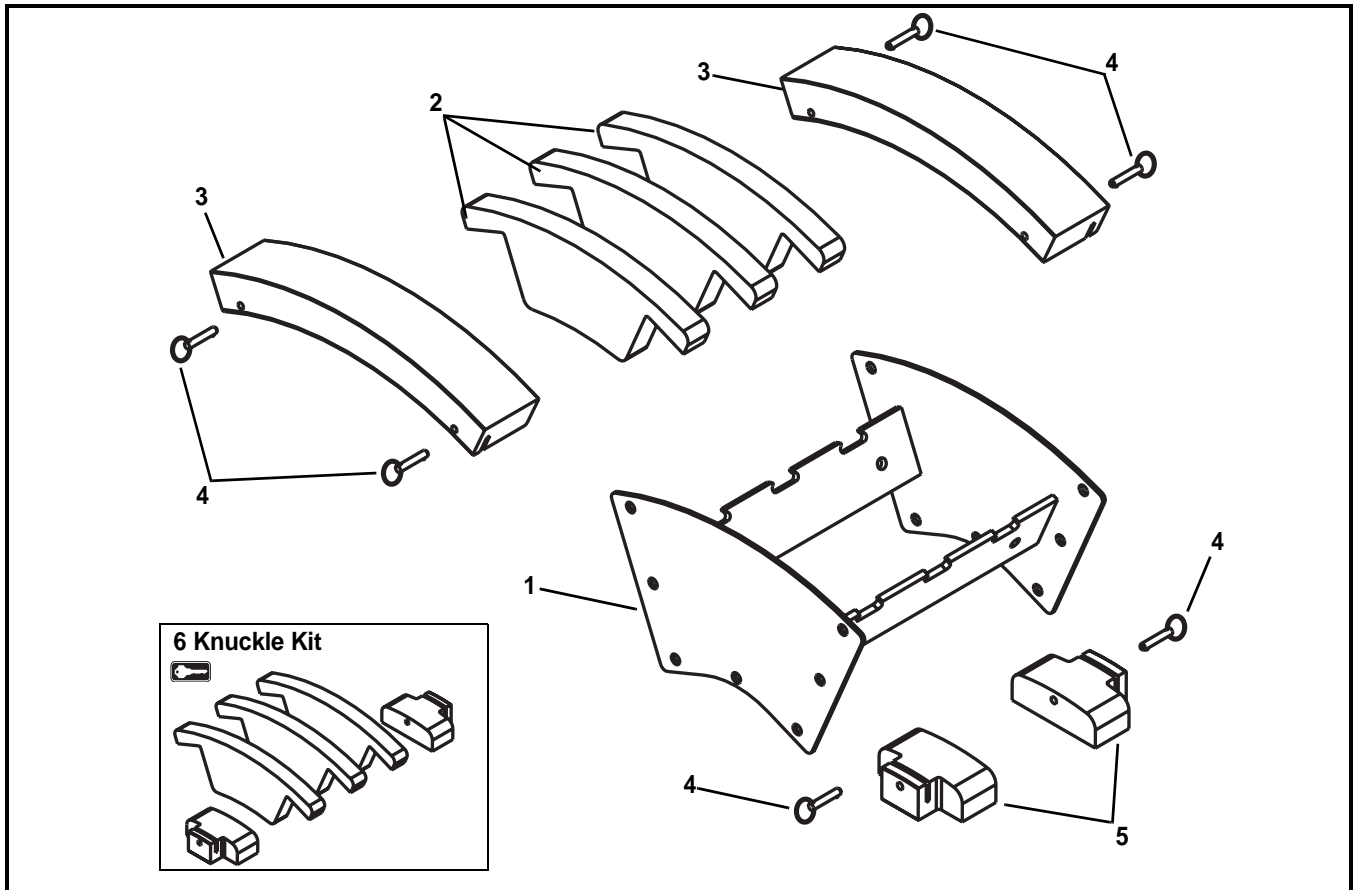
Upper Knuckle for 5° - 15°



Item	Part Number	Description
1	5224WW	Frame Assembly for 5° Knuckle
	5225WW	Frame Assembly for 10° Knuckle
	5226WW	Frame Assembly for 15° Knuckle
2	501695-AA	Wear Strips for 5° - 15° Knuckle
3	501893-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Right Hand 6"-16" wide
	501685-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Right Hand 18"-24" wide
	501883-AA	3" Hold Down Guide for 5° - 15° Knuckle Right Hand 6"-16" wide
	501684-AA	3" Hold Down Guide for 5° - 15° Knuckle Right Hand 18"-24" wide

Item	Part Number	Description
4	501699-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Left Hand 6"-16" wide
	501687-AA	1.5" Hold Down Guide for 5° - 15° Knuckle Left Hand 18"-24" wide
	501698-AA	3" Hold Down Guide for 5° - 15° Knuckle Left Hand 6"-16" wide
	501686-AA	3" Hold Down Guide for 5° - 15° Knuckle Left Hand 18"-24" wide
5	807-1553	Pull Pin
6	500196	Return Shaft
7	500075	Return Shoe
8	74UKL-WW-AA	Upper Knuckle Kit (Includes items 2 and 7)
WW = Conveyor width ref: 06 - 24 in 02 increments		
AA = Angle 05, 10 or 15		

Upper Knuckle for 30° - 60°

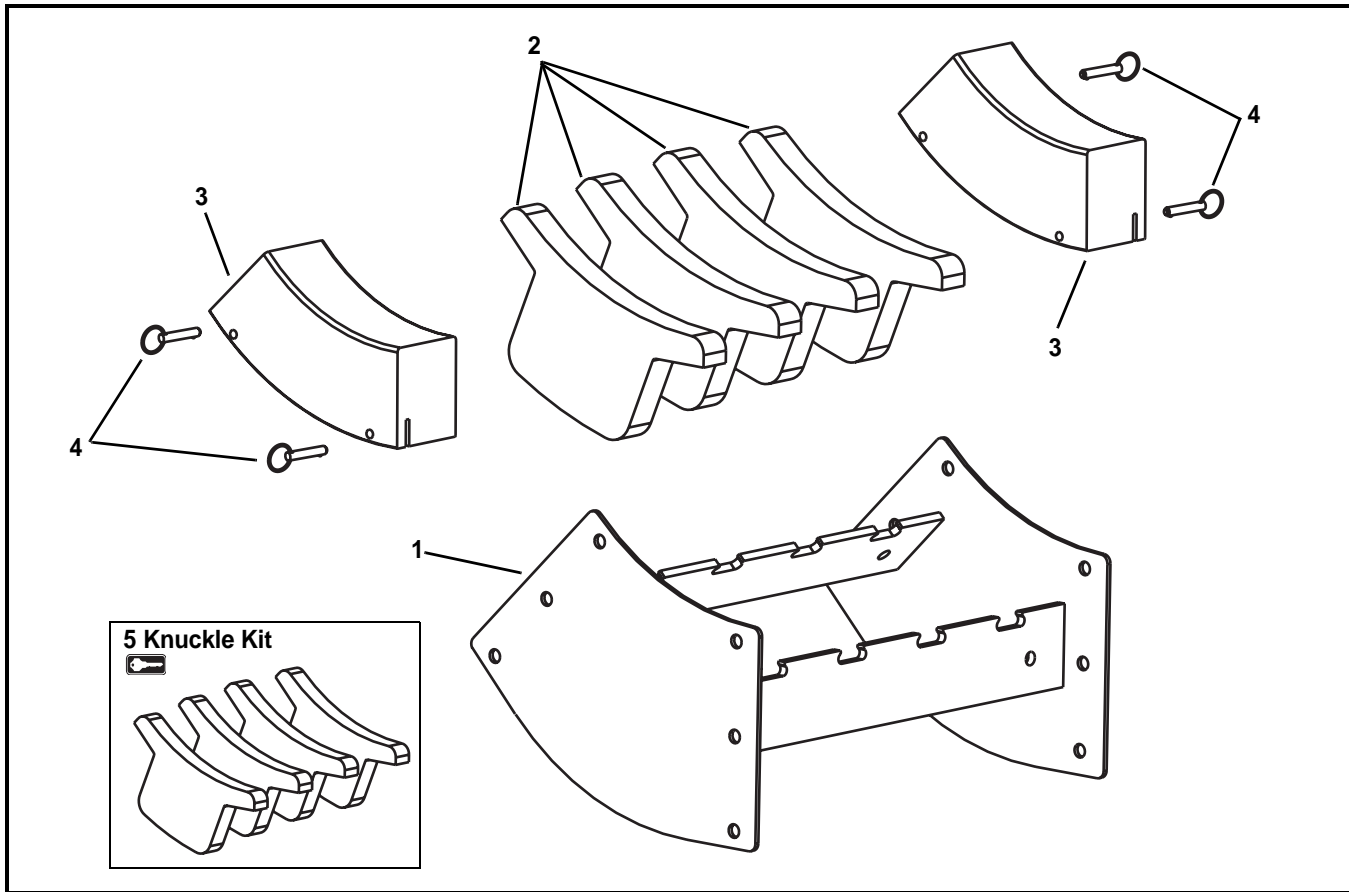


Item	Part Number	Description
1	5227 WW	Frame Assembly for 30° Knuckle
	5228 WW	Frame Assembly for 45° Knuckle
	5229 WW	Frame Assembly for 60° Knuckle
2	501693- AA	Wear Strips for 30° - 60° Knuckle
3	501697- AA	1.5" Hold Down Guide for 30° - 60° Knuckle
	501879- AA	3" Hold Down Guide for 30° - 60° Knuckle

Item	Part Number	Description
4	807-1553	Pull Pin
5	501683	Return Guide
6	74UKH- WW-AA	Upper Knuckle Kit (Includes items 2 and 5)
WW = Conveyor width ref: 06 - 24 in 02 increments		
AA = Angle 30, 45 or 60		

Service Parts

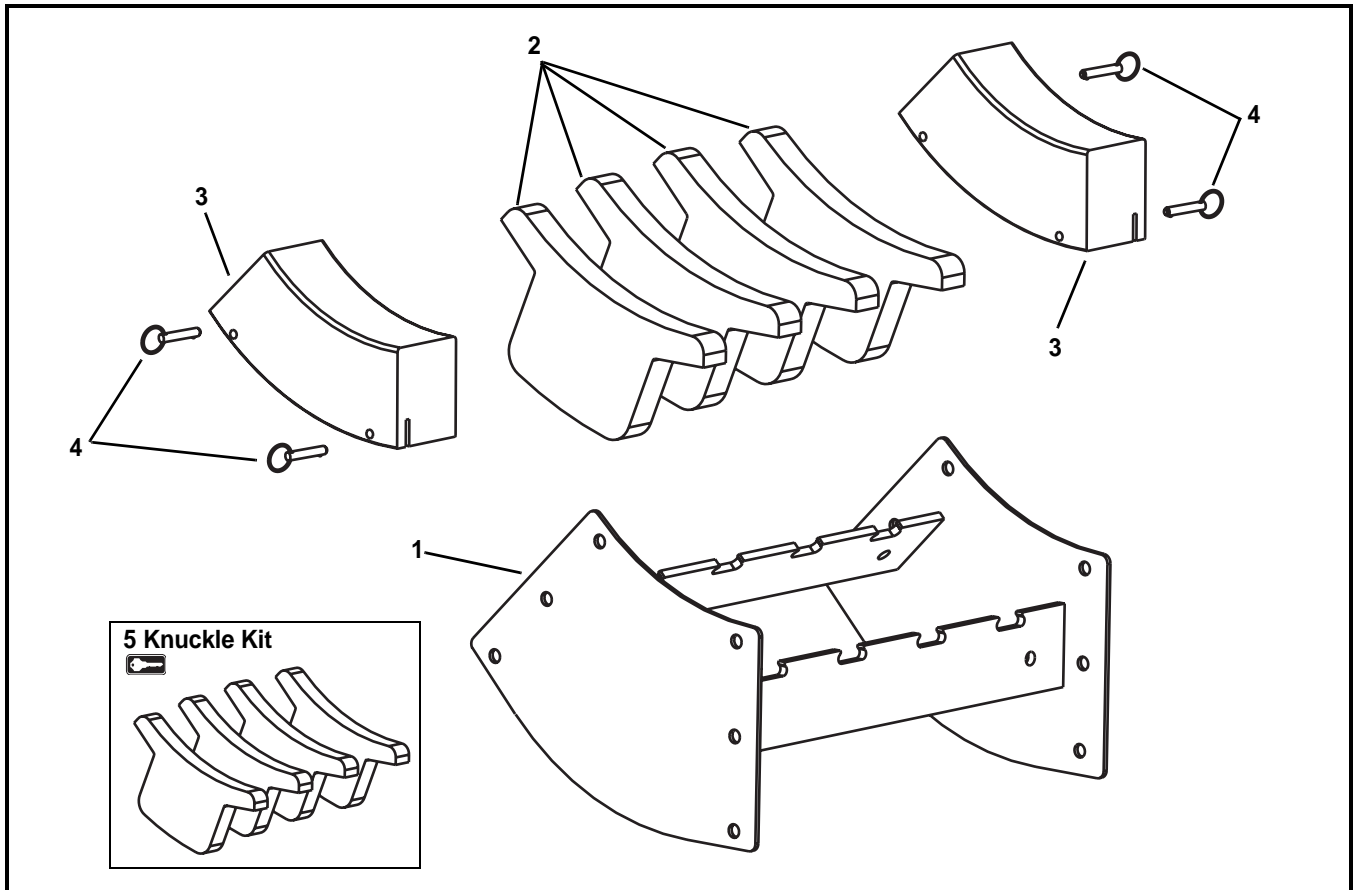
Lower Knuckle for 5° - 15°



Item	Part Number	Description
1	5218 <u>WW</u>	Frame Assembly for 5° Knuckle
	5219 <u>WW</u>	Frame Assembly for 10° Knuckle
	5220 <u>WW</u>	Frame Assembly for 15° Knuckle
2	501694- <u>AA</u>	Wear Strips for 5° - 15° Knuckle
3	501692- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle 6"-16" wide
	501974- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle 18"-24" wide
	501878- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle 6"-16" wide
	501973- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle 18"-24" wide

Item	Part Number	Description
4	807-1553	Pull Pin
5	74LKL- <u>WW</u> - <u>AA</u>	Lower Knuckle Kit (Includes item 2)
<u>WW</u> = Conveyor width ref: 06 - 24 in 02 increments		
<u>AA</u> = Angle 05, 10 or 15		

Lower Knuckle for 30° - 60°

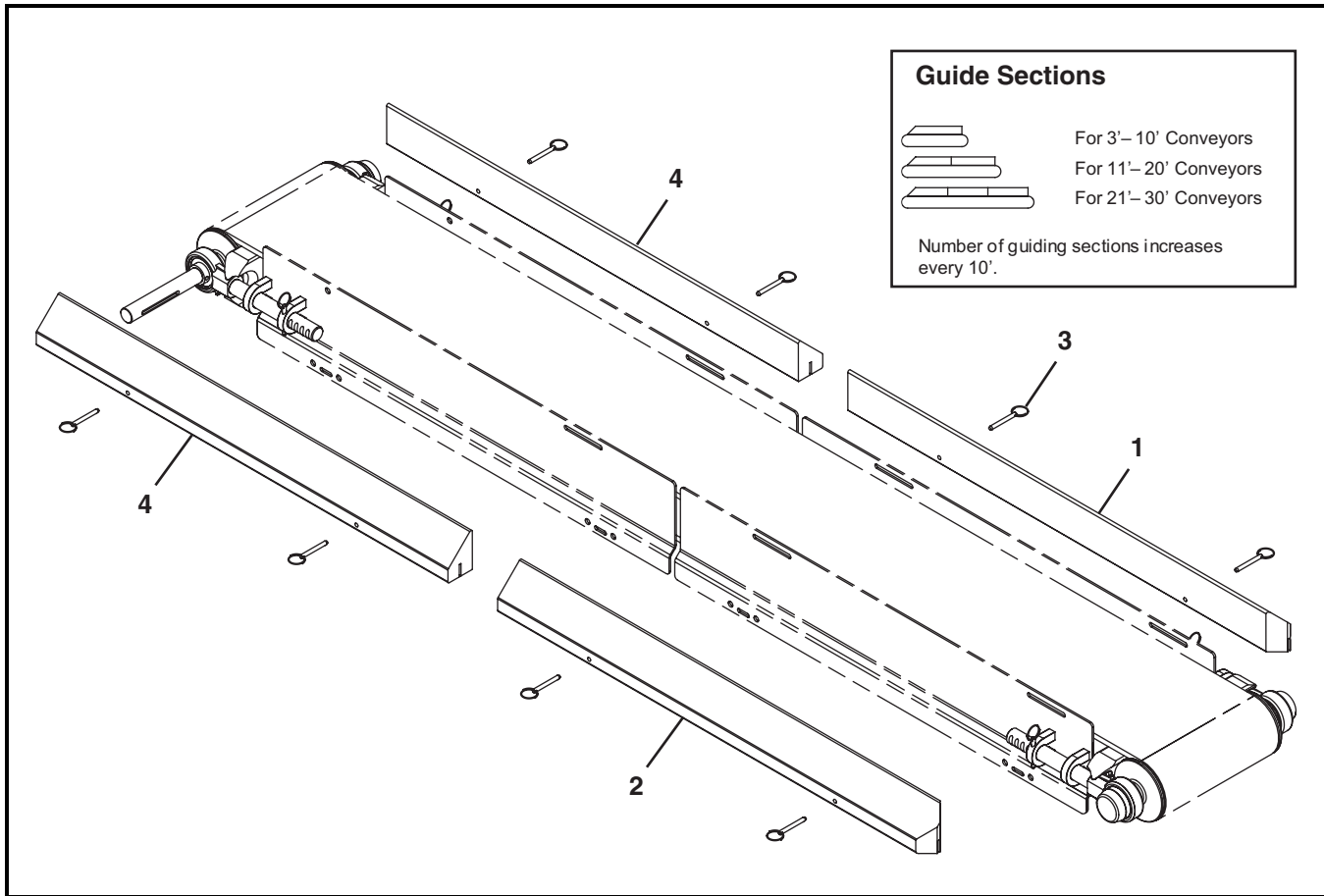


Item	Part Number	Description
1	5221 WW	Frame Assembly for 30° Knuckle
	5222 WW	Frame Assembly for 45° Knuckle
	5223 WW	Frame Assembly for 60° Knuckle
2	501691- AA	Wear Strips for 30° - 60° Knuckle
3	501692- AA	1.5" Hold Down Guide for 30° - 60° Knuckle
	501878- AA	3" Hold Down Guide for 30° - 60° Knuckle

Item	Part Number	Description
4	807-1553	Pull Pin
5	74LKH- WW-AA	Lower Knuckle Kit (Includes item 2)
WW = Conveyor width ref: 06 - 24 in 02 increments		
AA = Angle 30, 45 or 60		

Service Parts

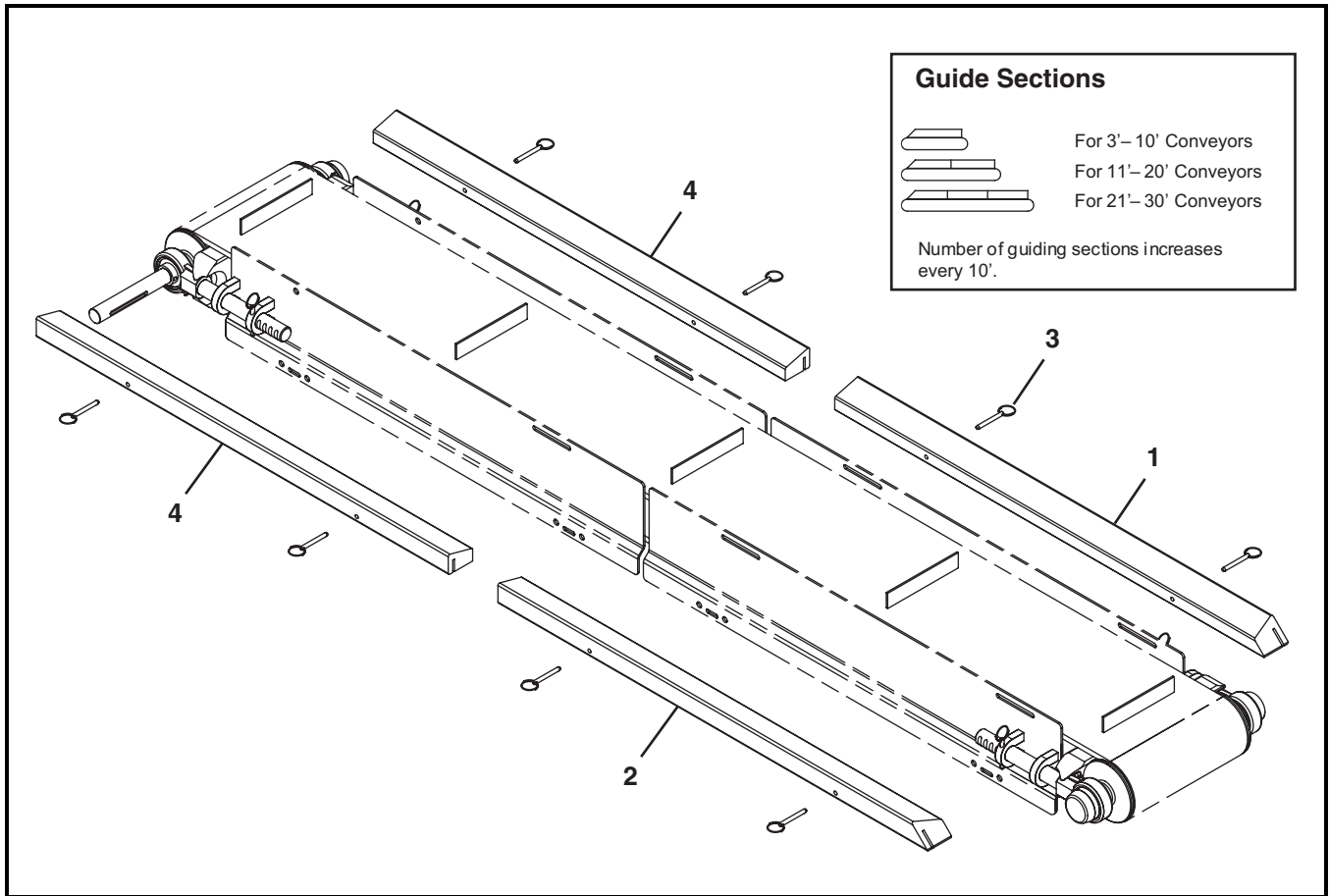
3" (76 mm) High Sides



Item	Part Number	Description
1	503501- <u>LLLLL</u>	Right Hand High Side Guide
2	503601- <u>LLLLL</u>	Left Hand High Side Guide
3	807-1553	Pull Pin

Item	Part Number	Description
4	503401- <u>LLLLL</u>	Square End High Side Guide
<u>LLLLL</u> = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" <u>LLLLL</u> = 09525		

Cleated 1" (25 mm) Guides

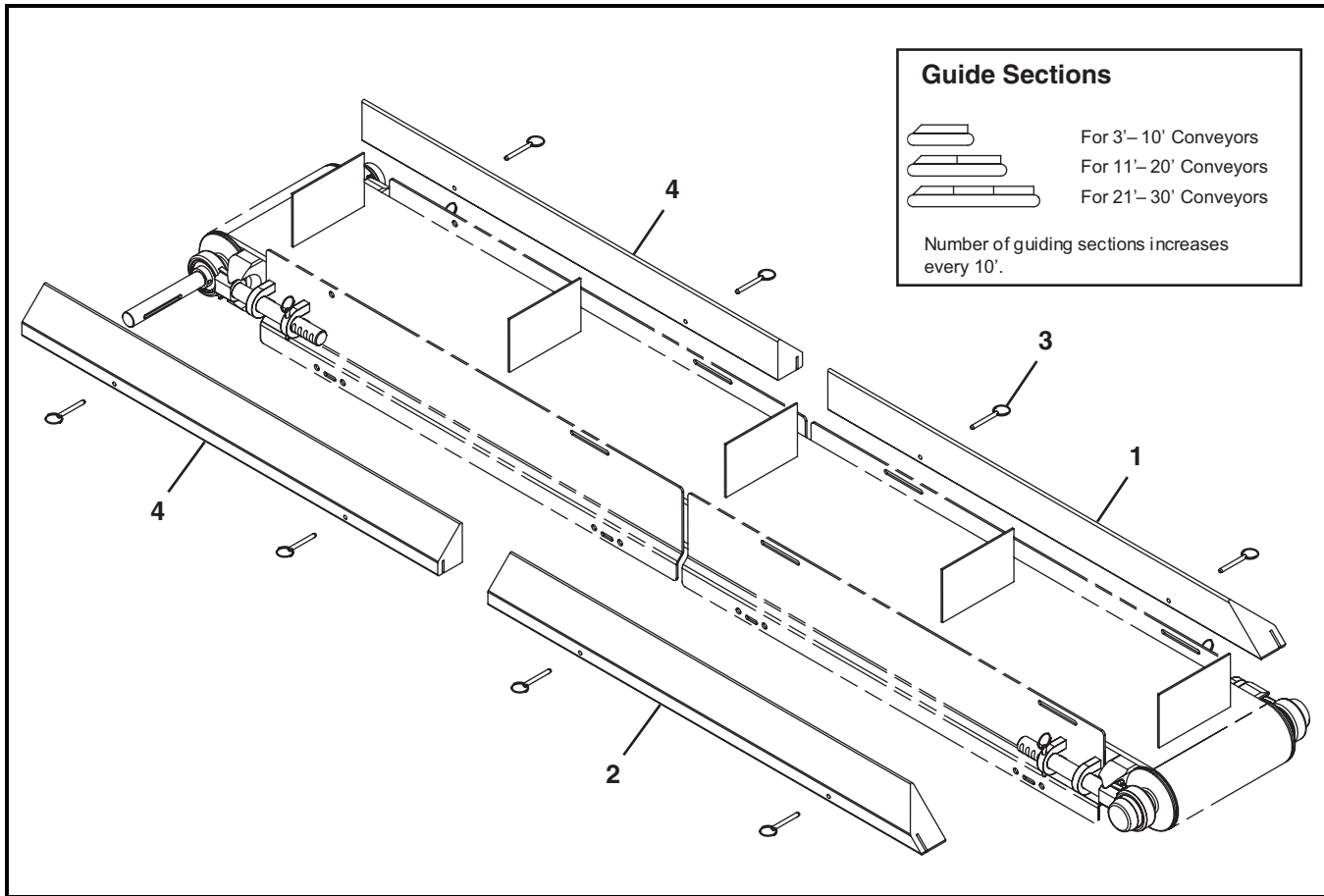


Item	Part Number	Description
1	502401-LLLLL	1" Cleated Right Hand Guide (6" - 16" wide conveyors)
	502402-LLLLL	1" Cleated Right Hand Guide (18" - 24" wide conveyors)
2	502501-LLLLL	1" Cleated Left Hand Guide (6" - 16" wide conveyors)
	502502-LLLLL	1" Cleated Left Hand Guide (18" - 24" wide conveyors)

Item	Part Number	Description
3	807-1553	Pull Pin
4	502301-LLLLL	1" Cleated Guide Square End (6" - 16" wide conveyors)
	502302-LLLLL	1" Cleated Guide Square End (18" - 24" wide conveyors)
LLLLL = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

Service Parts

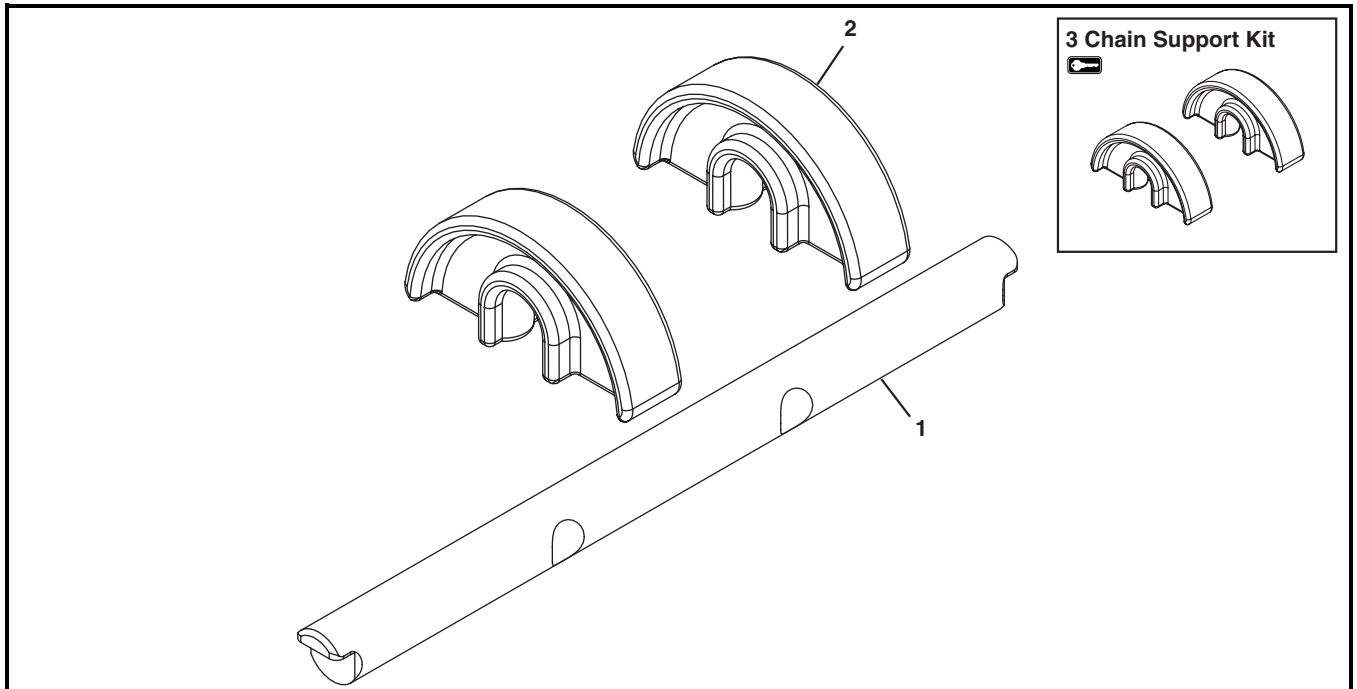
Cleated 3" (76 mm) Guides



Item	Part Number	Description
1	502701-LLLLL	3" Cleated Right Hand Guide (6" - 16" wide conveyors)
	502702-LLLLL	3" Cleated Right Hand Guide (18" - 24" wide conveyors)
2	502801-LLLLL	3" Cleated Left Hand Guide (6" - 16" wide conveyors)
	502802-LLLLL	3" Cleated Left Hand Guide (18" - 24" wide conveyors)

Item	Part Number	Description
3	807-1553	Pull Pin
4	502601-LLLLL	3" Cleated Guide Square End (6" - 16" wide conveyors)
	502602-LLLLL	3" Cleated Guide Square End (18" - 24" wide conveyors)
LLLLL = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" LLLLL = 09525		

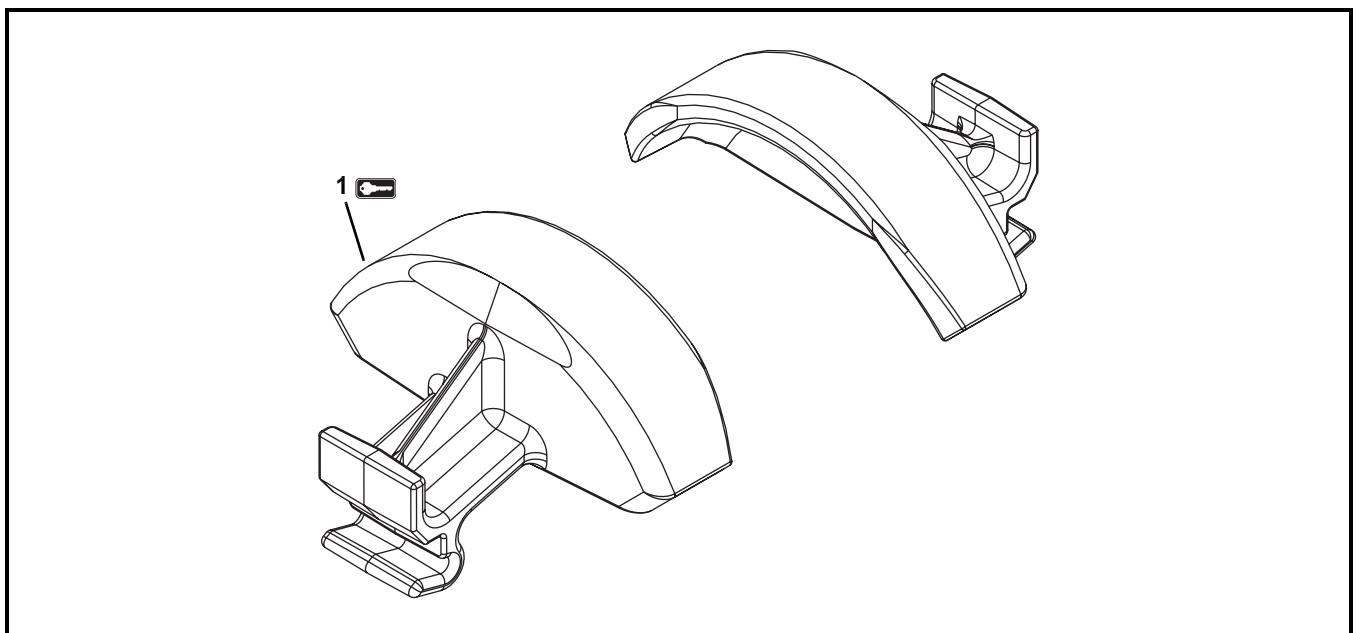
Flat Belt Returns



Item	Part Number	Description
1	5032WW	Return Shaft
2	500075	Chain Return Shoe

Item	Part Number	Description
3	74R-WW	Chain Support Kit (Includes Item 2)
WW = Conveyor width ref: 06 - 60 in 02 increments		

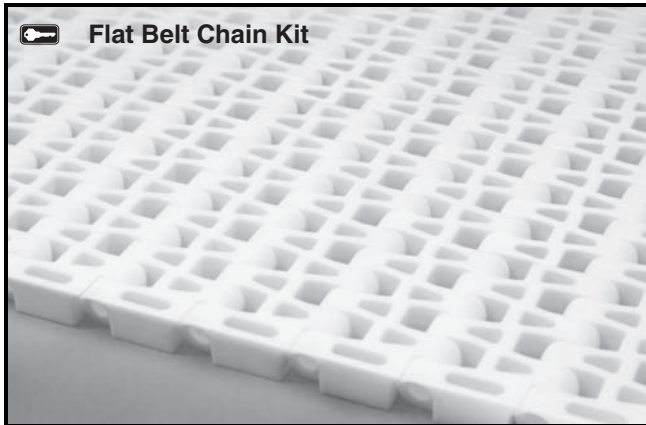
Cleated Belt Returns



Item	Part Number	Description
1	532224	Cleated Return Shoe

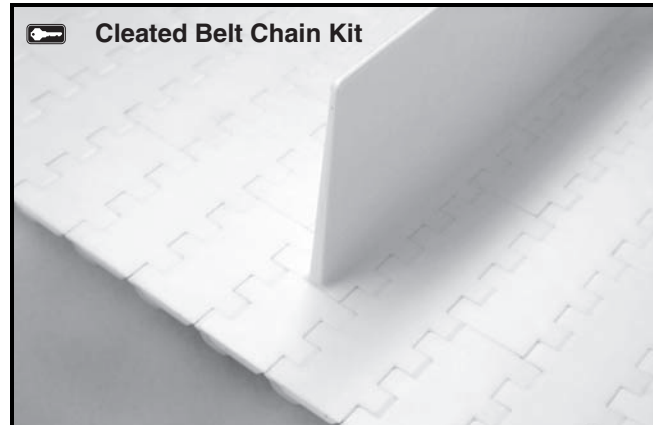
Service Parts

Flat Belt



Item	Part Number	Description
1	74BB-WW	Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
BB = Chain Reference Number		
WW = Conveyor width ref: 06 - 60 in 02 increments		

Cleated Belt



Item	Part Number	Description
1	74BB-WW-SS	Cleated Belt Chain Repair Kit (Includes 1 cleat centered on a cleat spacing length of chain and assembly pins)
BB = Chain Reference Number		
WW = Conveyor width ref: 06 - 60 in 02 increments		
SS = Cleat Spacing		

Ordering a Replacement Chain

Determine the length of chain required for the conveyor and round up to the nearest foot length. Order the proper number of chain repair kits (1' long each) for your conveyor. Dorner will ship chain kits that are of a reasonable length fully assembled.

Example:

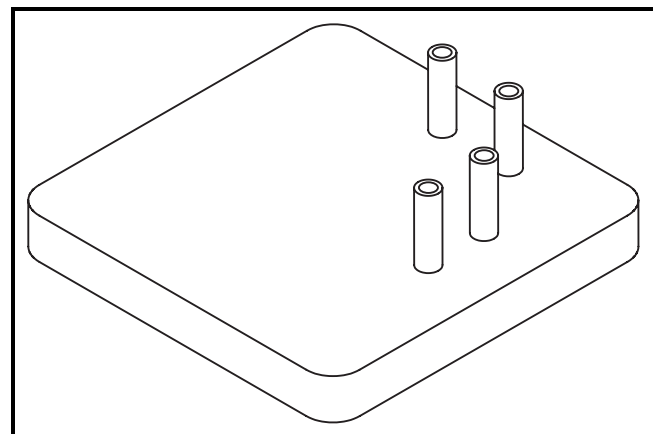
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 74BB-WW

BB = Chain reference number

WW = Conveyor width ref: 06-60 in 02 increments

Belt Removal Tool



Item	Part Number	Description
1	500582	Tool Rod Removal for 1" Pitch Flush Grid Belt
	500494	Tool Rod Removal for 1/2" Pitch Flush Grid Belt

Configuring Conveyor Part Number

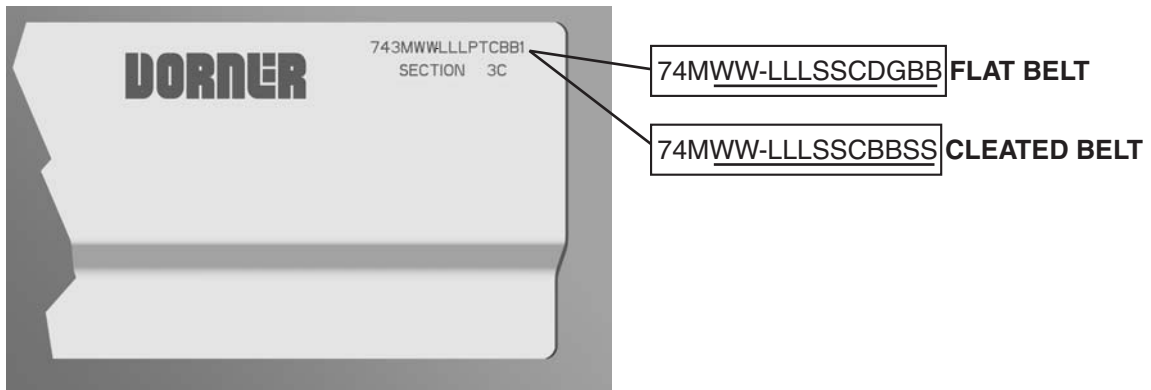


Figure 75

Flat Belt Conveyor

Refer to the model number on the conveyor frame (**Figure 75**). From the model number, determine conveyor width (WW), length (LLL), drive stand location (S), idler stand location (S), cleaning options (C), drive/pulley type (D), profile (G) and belt material (BB).

Example:

74M12-072CC111MA

7400 Series end drive, flat belt conveyor, 12" (305 mm) wide x 72" (1829 mm) long, stands located 18" (457 mm) from each end, frame cutout cleaning option, side drive with standard pulleys on each end, low side profiles, and MA belt material.

Cleated Belt Conveyor

Refer to the model number on the conveyor frame (**Figure 75**). From the model number, determine conveyor width (WW), length (LLL), drive stand location (S), idler stand location (S), cleaning options (C), cleated belt material (BB) and cleat spacing (SS).

Example:

74M12-072CC1NA10

7400 Series end drive, cleated belt conveyor, 12" (305 mm) wide x 72" (1829 mm) long, stands located 18" (457 mm) from each end, frame cutout cleaning option, NA cleated belt material, side drive with standard pulleys on each end, and 10 link spacing for cleats.

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.

Conveyors and conveyor accessories

Standard catalog conveyors	30%
MPB, 7200, 7300 Series, cleated and specialty belt	50%
AquaGard & AquaPruf Series conveyors	non-returnable items
Engineered to order products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

Parts

Standard stock parts	30%
Plastic chain, cleated and specialty belts	non-returnable items

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.



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. 2009

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

Outside the USA:
TEL 1-262-367-7600
FAX 1-262-367-5827