

DORNER®

AquaPruf® ULTIMATE

7400 Ultimate Series End Drive Conveyors

Installation, Maintenance and Parts Manual



Flat Belt Conveyor



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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.

NOTE

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

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	Belt (Flat Belt Shown)
3	Return
4	Support Stands
5	Drive End
6	Tension End

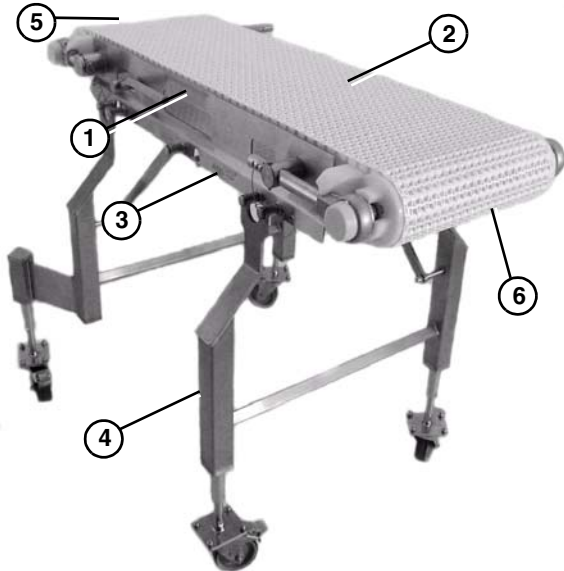
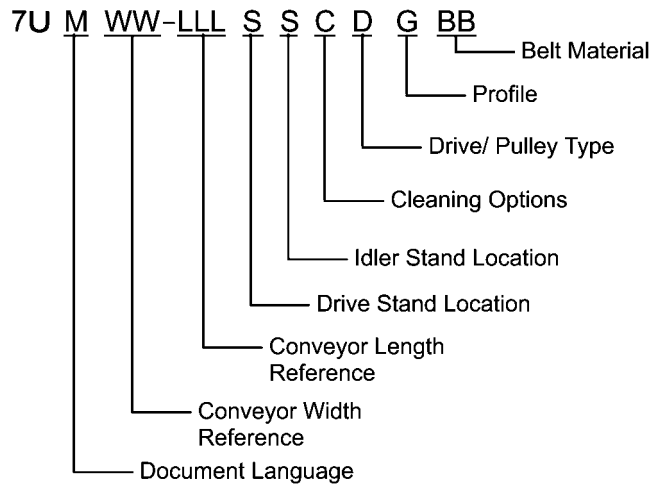


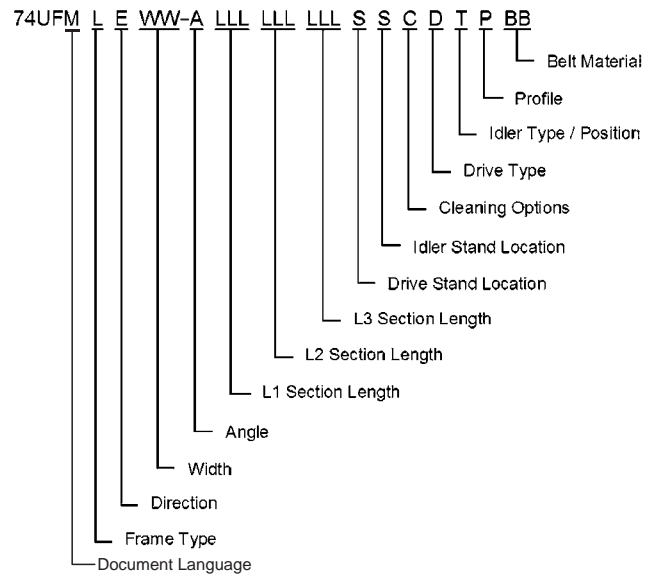
Figure 1

Specifications

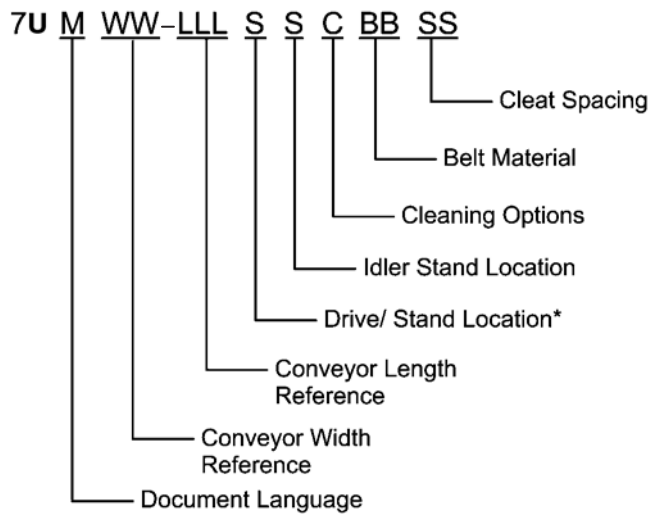
Flat Belt 7400 Series Conveyor



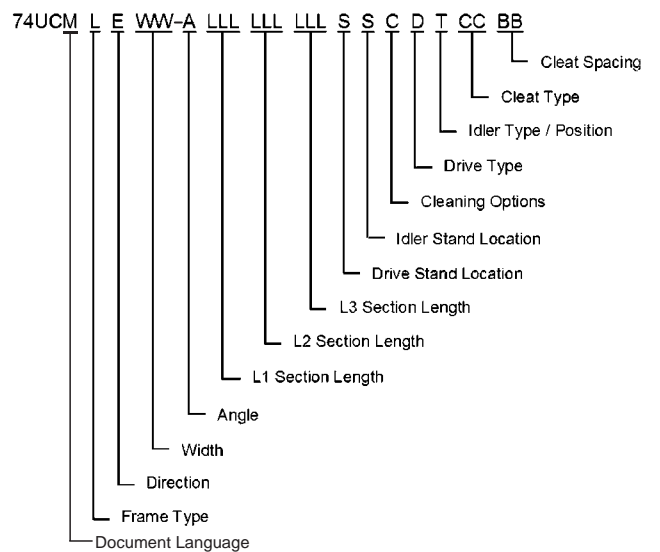
Flat Belt 7400 Series LPZ Conveyor



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.

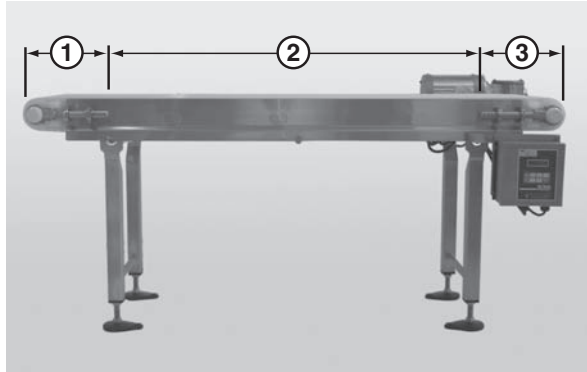


Figure 2

Specifications

Conveyor Width Reference (<u>WW</u>)	06 – 36 in 02 increments
Conveyor Belt Width	6" (152 mm) – 36" (914 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

Donner 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.

NOTE

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

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 frame |
| 4 | O-rings (x8) |

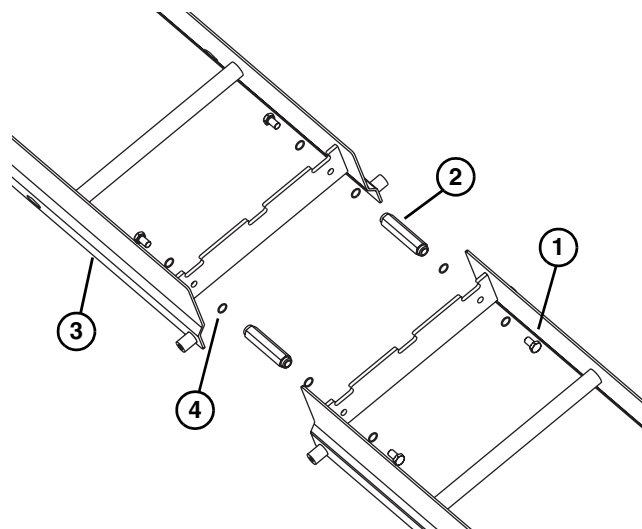


Figure 4

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

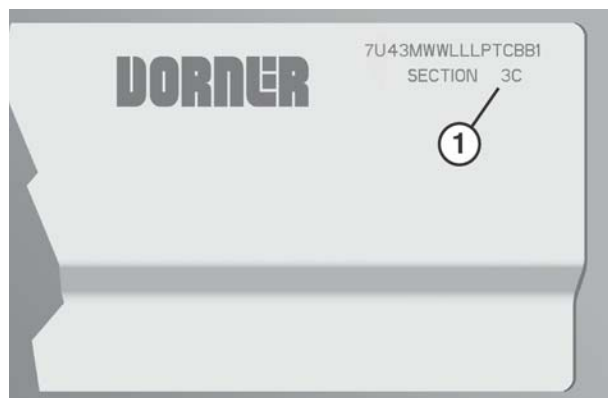


Figure 5

Installation

2. Position the frame sections in the correct order.

⚠ CAUTION

Avoid damage to O-rings. Be careful not to pinch or cut them.

3. Connect the frame sections by bolting the hex post connectors (**Figure 6, item 1**) between frame sections. Be sure O-rings are seated properly on hex post and hex screws prior to tightening of screws to avoid damage to O-rings.

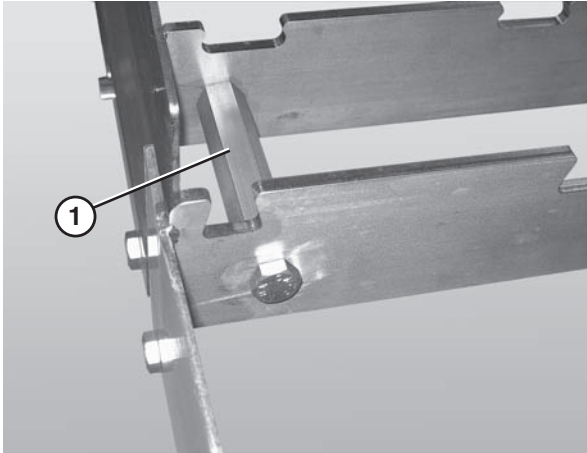


Figure 6

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**).

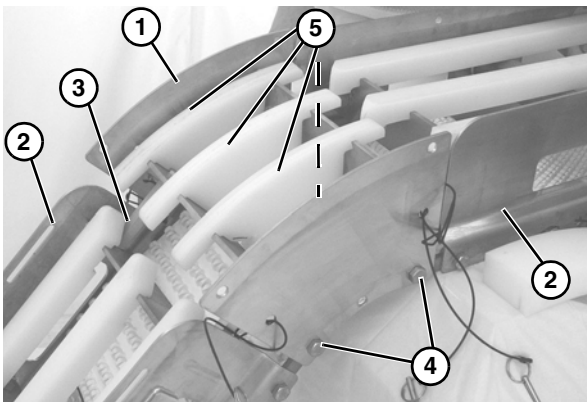


Figure 7

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**).

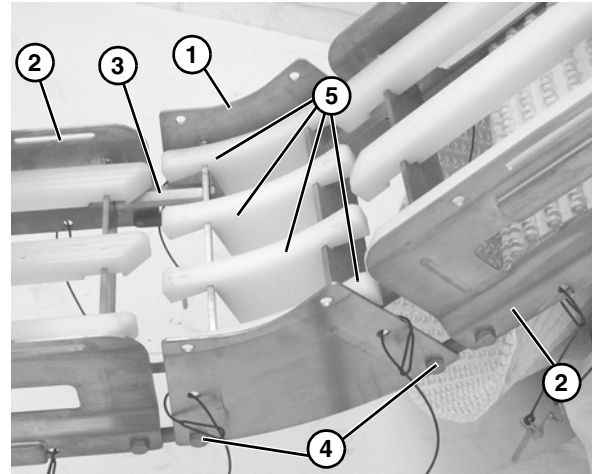


Figure 8

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**).

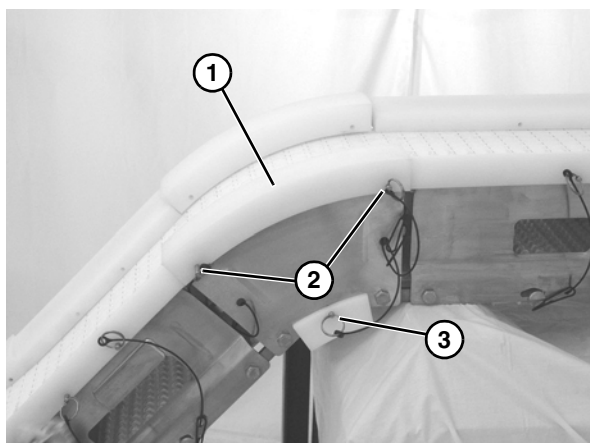


Figure 10

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**).

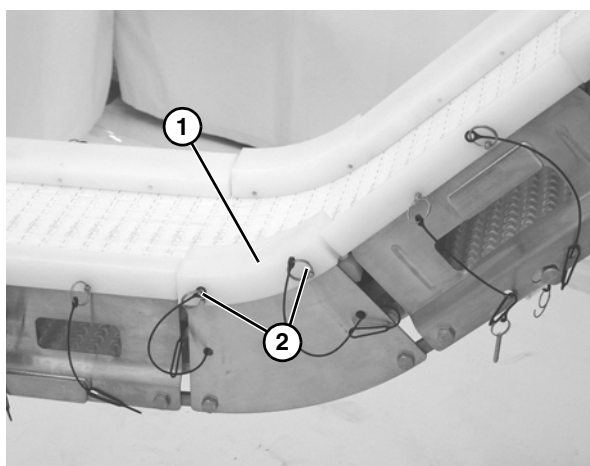


Figure 11

All Conveyors

Stand Installation

Typical Stand Components (**Figure 12**).

- | | |
|---|--|
| 1 | Conveyor frame |
| 2 | Stand |
| 3 | M10 - 1.5 x 16 mm hex head cap screws (x4) |

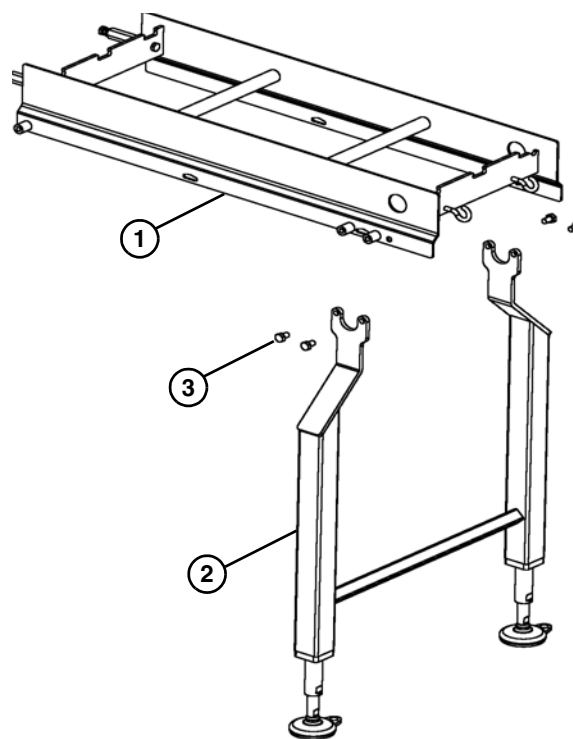


Figure 12

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

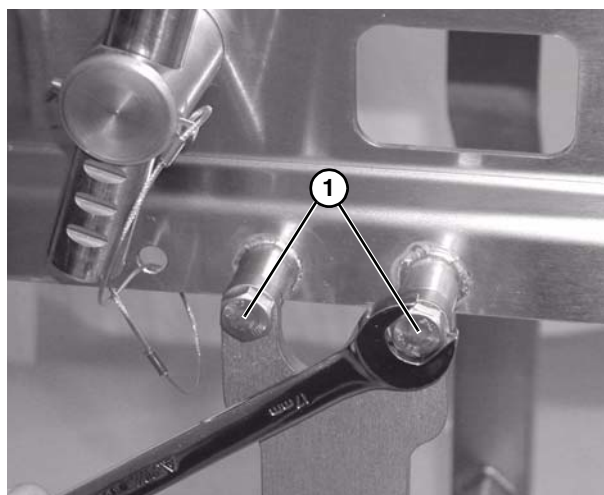


Figure 13

3. Tighten hex screws (**Figure 13, item 1**).

Installation

Tail Assembly Installation

Drive Tail

Typical Drive Tail Components (Figure 14)

1	Drive tail assembly
2	Pull pin (x2)
3	Conveyor frame

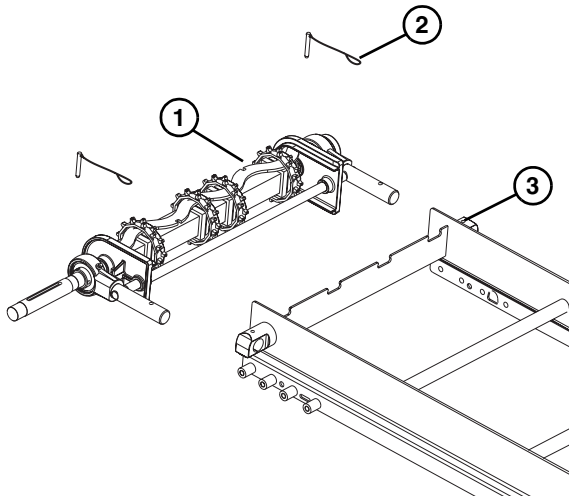


Figure 14

1. Slide the bearing shafts (Figure 15, item 1) into the take up blocks (Figure 15, item 2).

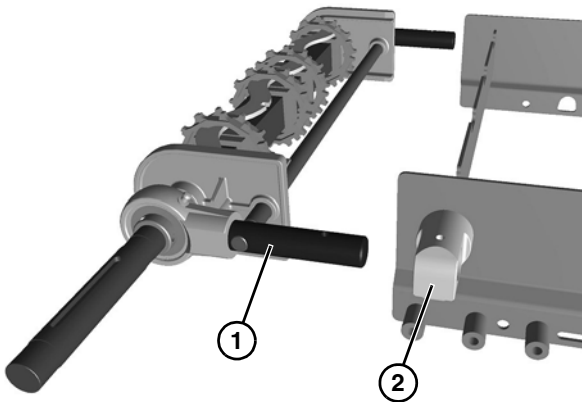


Figure 15

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

3. Insert the pull pins (Figure 16, item 1).

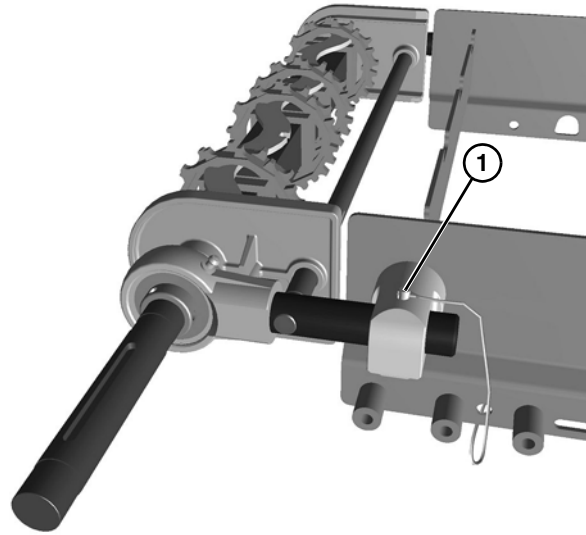


Figure 16

Tip Up Assembly

Typical Tip Up Assembly Components (Figure 17)

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

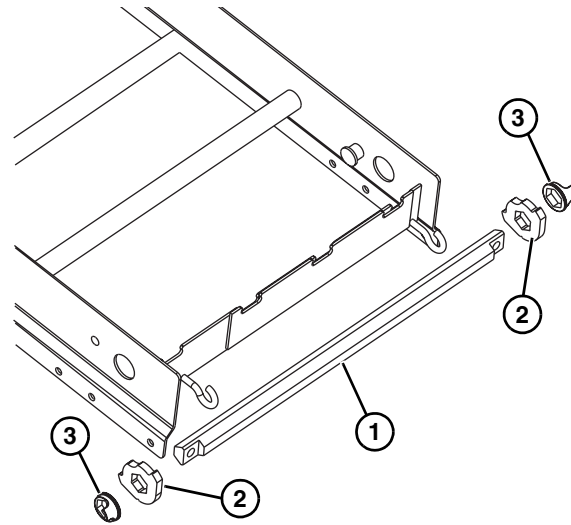


Figure 17

1. Slide stop keys (**Figure 18, item 1**) and tip up sleeves (**Figure 18, item 2**) onto hex shaft (**Figure 18, item 3**). The tabs on the tip up sleeves face outward and align with the slotted ends of the hex shaft as shown.

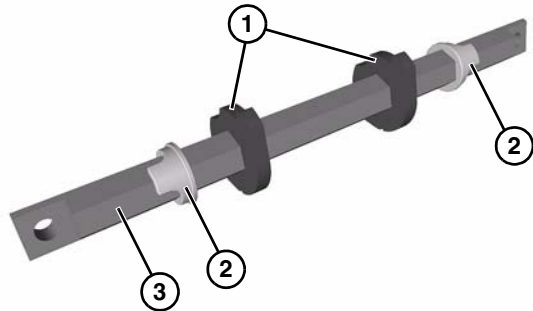


Figure 18

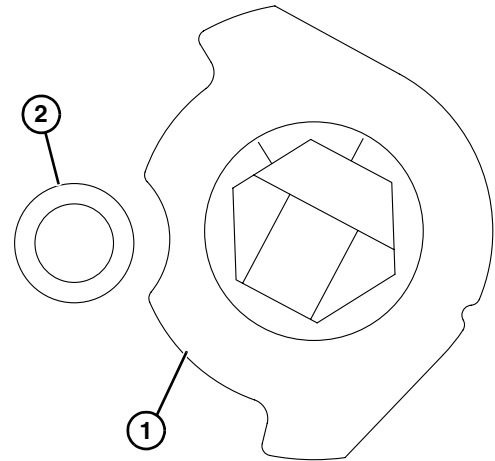


Figure 20

2. Place hex shaft assembly (**Figure 19, item 1**) through the conveyor frame tip up holes (**Figure 19, item 2**) and center with conveyor.

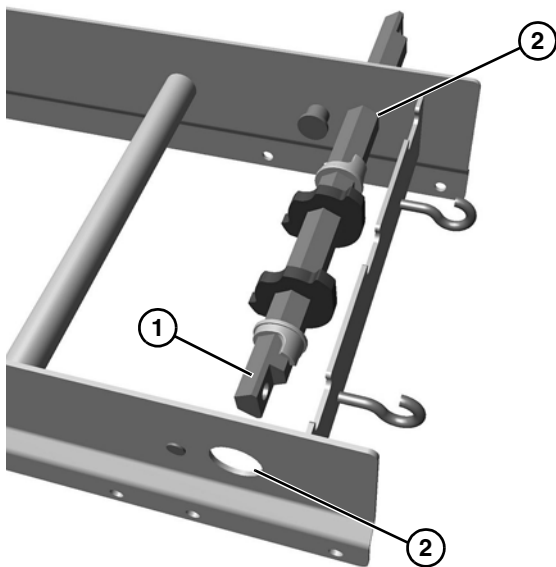


Figure 19

4. Slide the tip up sleeves (**Figure 21, item 1**) and stop keys (**Figure 21, item 1**) outward on hex shaft assembly (**Figure 21, item 3**) until the sleeves seat in the holes of the frame and stop keys are seated against frame stops (**Figure 21, item 4**).

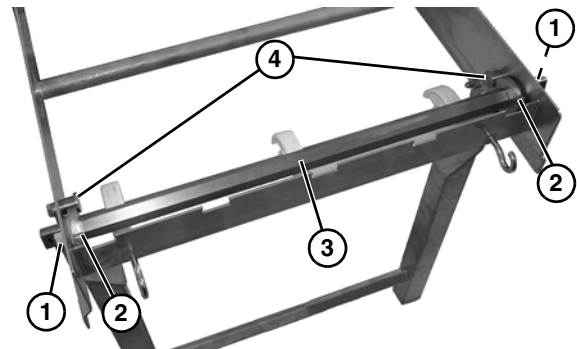


Figure 21

3. Hex shaft assembly will need to be rotated (**Figure 20**) for stop keys (**Figure 20, item 1**) to pass by the frame stops (**Figure 20, item 2**).

Idler Tail

Typical Idler Tail Components (**Figure 22**).

1	Tip up tail assembly
2	Pull pin (x2)
3	Conveyor frame

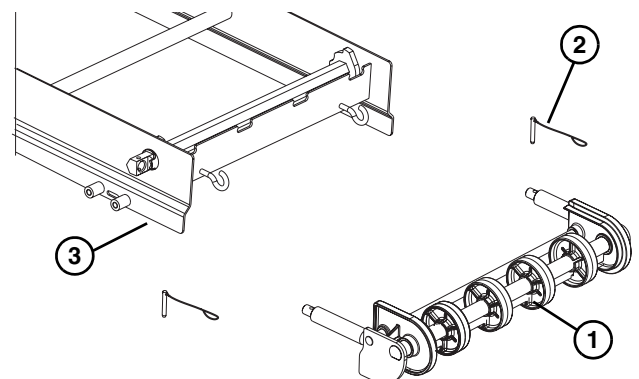


Figure 22

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 23, item 1) against the holes in the tip up hex shaft assembly (Figure 23, item 2) and secure with a pull pin (Figure 23, item 3) on each side.

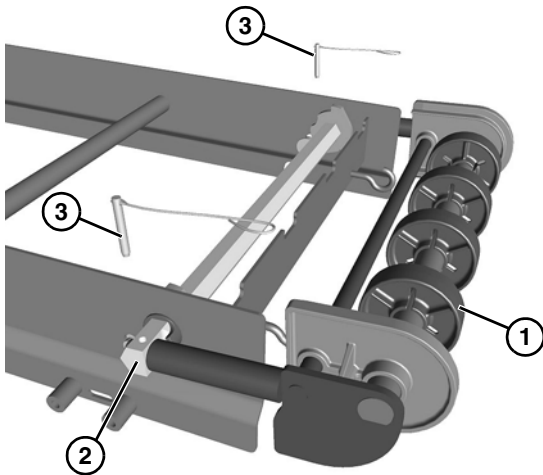


Figure 23

Nose Bar Idler Tail

Typical Nose Bar Tip Up Tail Components (Figure 24).

- | | |
|---|----------------------|
| 1 | Tip up tail assembly |
| 2 | Pull pin (x2) |
| 3 | Conveyor frame |

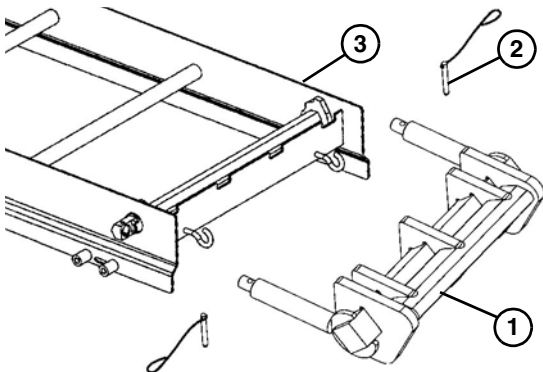


Figure 24

2. Attach nose bar idler shaft hands (Figure 25, item 1) to the tip up shaft (Figure 25, item 2) with a pull pin (Figure 25, item 3).

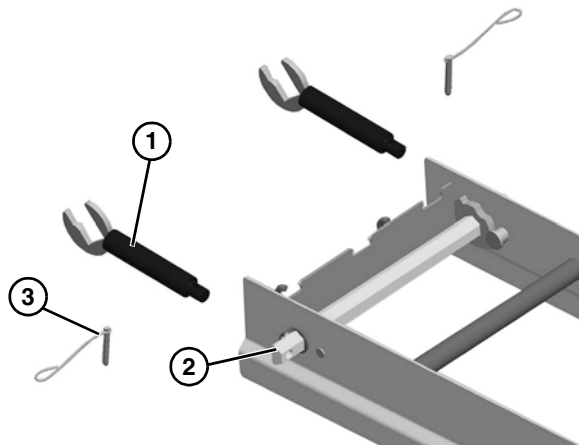


Figure 25

3. Attach the nose bar transfer post (Figure 26, item 1) to the nose bar idler shaft hands (Figure 26, item 2).

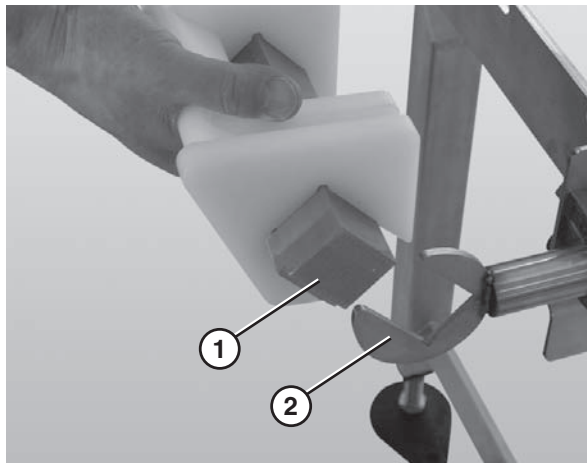


Figure 26

4. Ensure that the nose bar pucks (Figure 27, item 1) are in line with the conveyor frame (Figure 27, item 2).

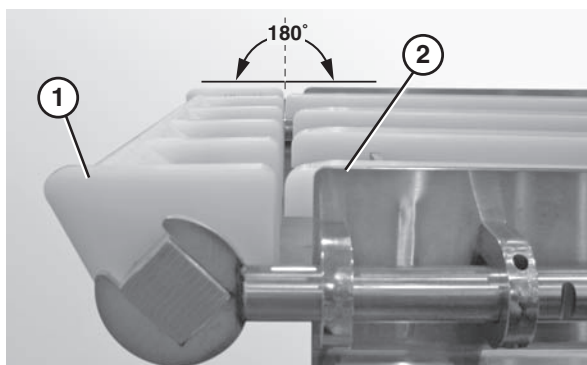


Figure 27

Lifter Installation

Typical Lifter Components (**Figure 28**).

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

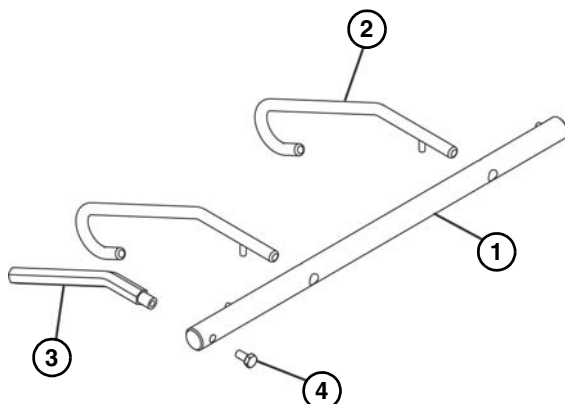


Figure 28

1. Slide the belt lift pivot bar (**Figure 29, item 1**) through the designated holes in the frame. The pins on the pivot bar should be located to the inside of the frame side rails.

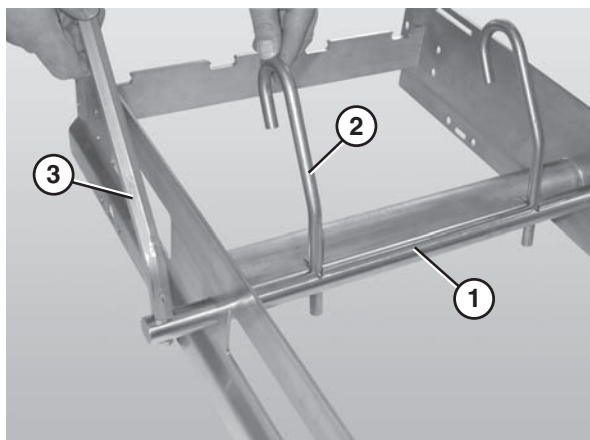


Figure 29

2. Attach the lifter bars (**Figure 29, item 2**) to the belt lift pivot bar (**Figure 29, 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 29, item 3**) to the belt lift pivot rod.

Wear Strip Installation

Typical Wear Strip Components (**Figure 30**).

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

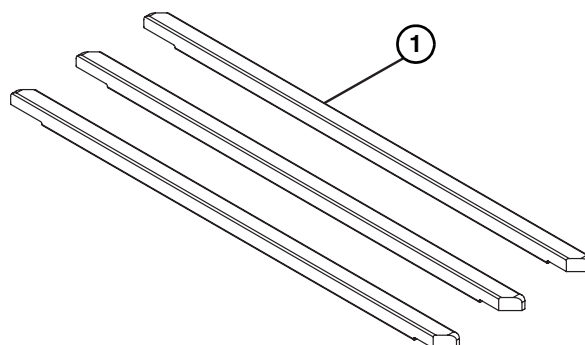


Figure 30

1. Position the wear strips (**Figure 31, item 1**) on the frame.

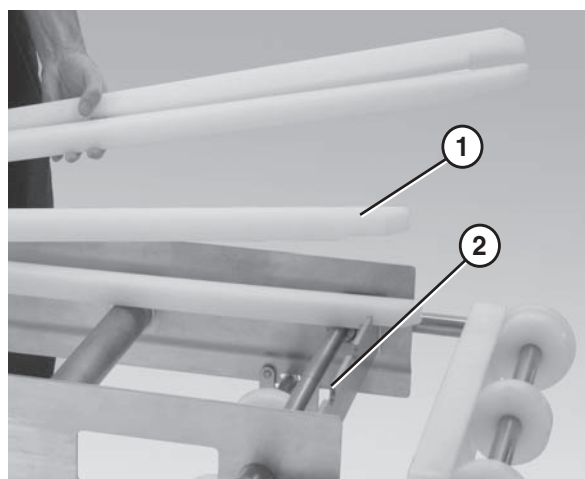


Figure 31

2. Make sure the wear strips are situated securely in the frame slots (**Figure 31, item 2**).

Installation

Belt Installation

Typical Belt Components (Figure 32).

1	Chain belt
2	Belt rod

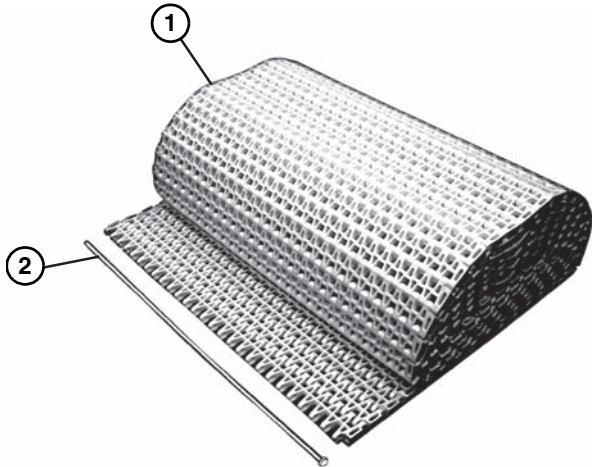


Figure 32

1. Position the belt on the conveyor frame (Figure 33).



Figure 33

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 34).



Figure 34

4. Insert the belt rod (Figure 35, item 1).

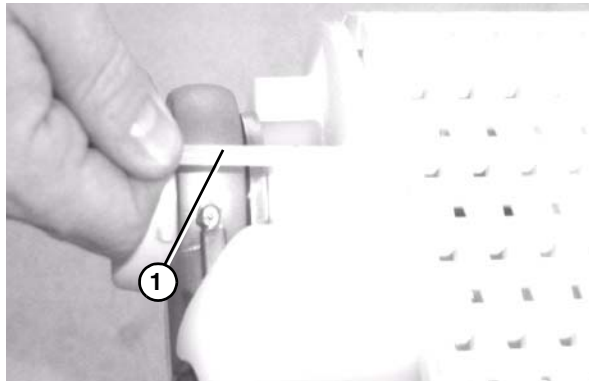


Figure 35

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 36).

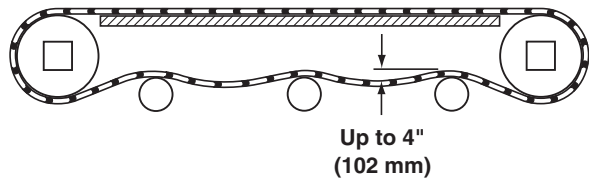


Figure 36

⚠ CAUTION

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

Belt Return Installation

Typical Belt Return Components (Figure 37).

1	Return shaft
2	Chain return shoe

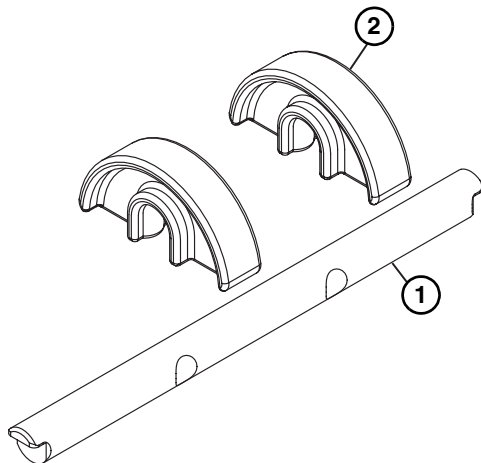


Figure 37

1. Attach the chain return shoes (Figure 38, item 1) to the return shaft (Figure 38, item 2).

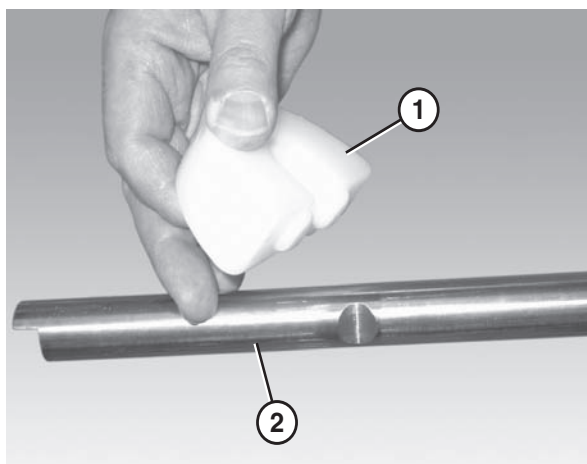


Figure 38

2. Slide the return shaft (Figure 39, item 1) up and through the large slot (Figure 39, item 2) in the frame (picture shown without the belt or wear strips).

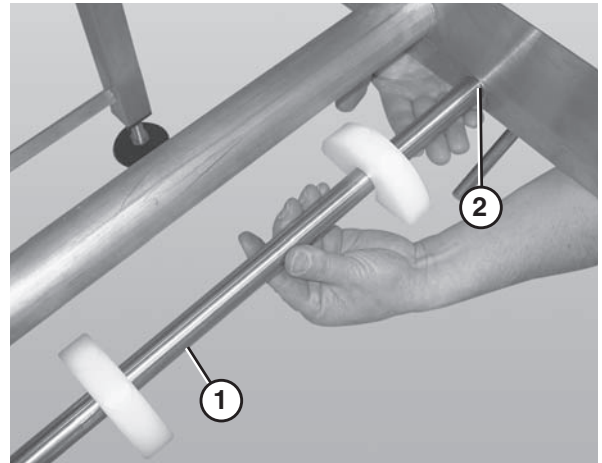


Figure 39

3. Push up on the return shaft (Figure 39, item 1) and slide the notched end of the shaft through the small slot on the opposite side of the frame.
4. Check belt sag by measuring from the top of the return (Figure 40). Belt sag should not exceed 4" (102 mm). Follow steps 7 – 9 in the "Belt Installation" section on page 14 to remove slack from the belt.

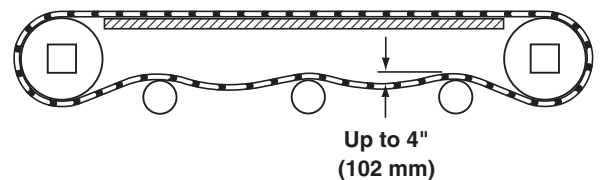


Figure 40

⚠ CAUTION

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

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.

Standard Conveyors

1. Remove the guides, if applicable, by removing the pull pins (**Figure 41, item 1**) that connect the guide (**Figure 41, item 2**) to the frame.

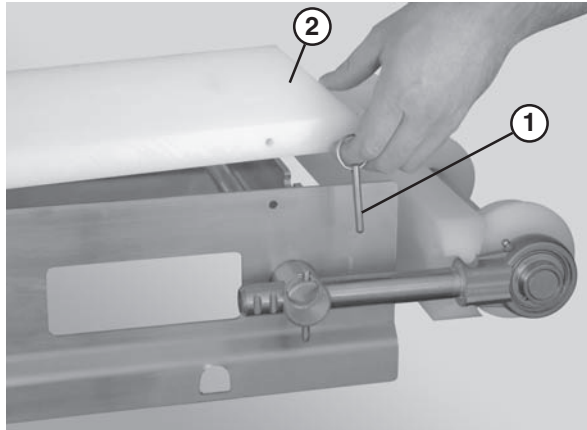


Figure 41

2. Tip up idler tail assembly (**Figure 42**).

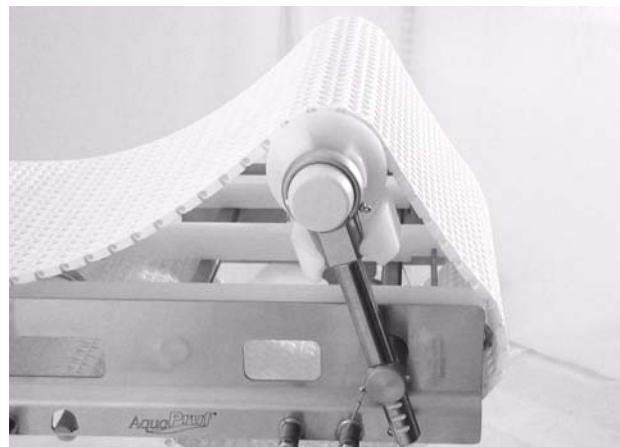


Figure 42

3. Lift up on the belt (**Figure 43**).



Figure 43

Preventive Maintenance and Adjustment

Conveyors with Tip Up Tails and Lifters

1. Remove the guides, if applicable, by removing the pull pins (Figure 41, item 1) that connect the guide (Figure 41, item 2) to the frame.
2. Use the lifter handle (Figure 44, item 1) to raise the lifters (Figure 44, item 2) and raise the tip up tail (Figure 44, item 3).

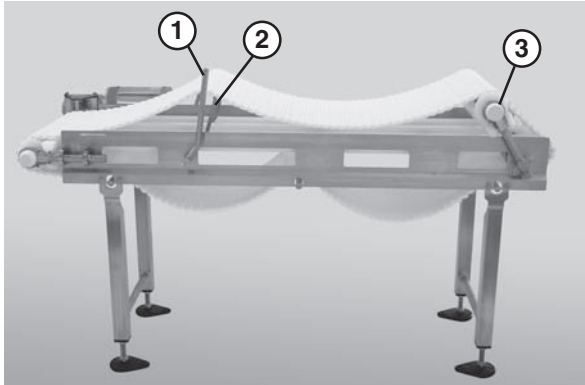


Figure 44

CAUTION

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

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 “Reassembling Tail Assembly” on page 24.

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 45, item 1) on the exterior of the bearing shaft assembly.

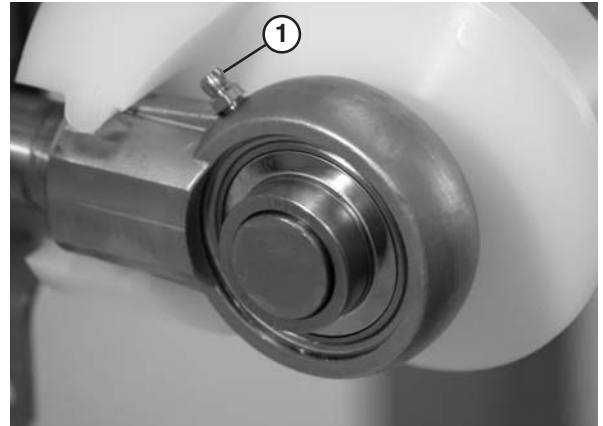


Figure 45

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

Preventive Maintenance and Adjustment

Damage to belt links or rods indicate:

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

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 46, item 1) that connect the guide (Figure 46, item 2) to the frame.

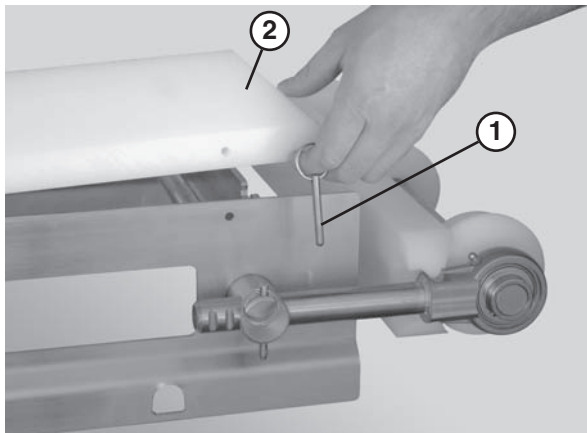


Figure 46

2. Remove the guide (Figure 47, item 1).

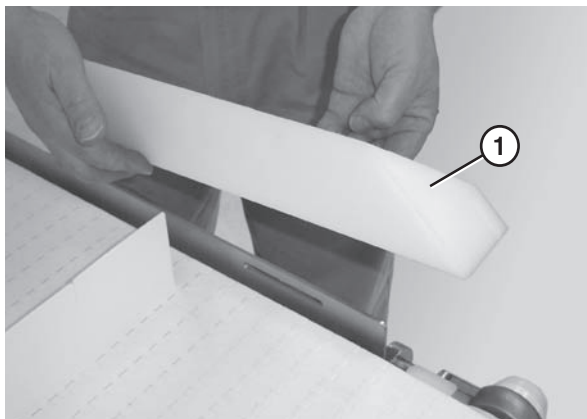


Figure 47

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

1. Tip up idler tail assembly (Figure 48).

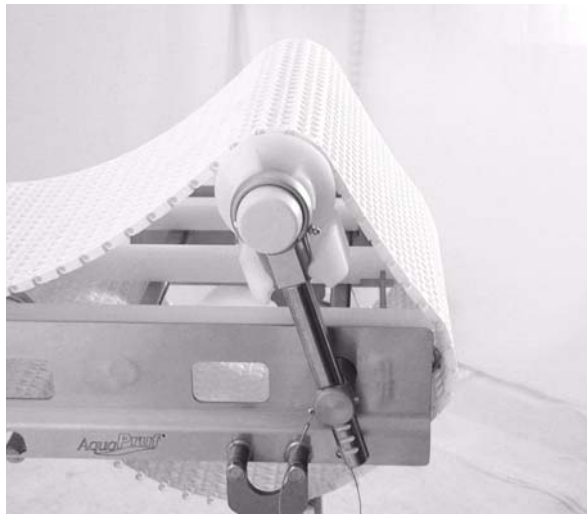


Figure 48

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

2. Secure the retaining head side of the belt. Use the belt removal tool (Figure 49, 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 49, item 2).

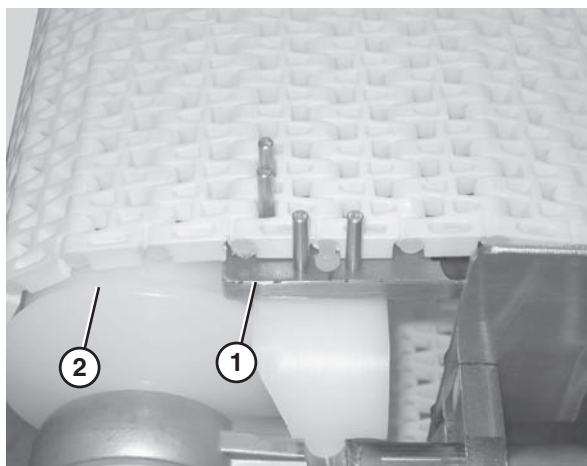


Figure 49

Preventive Maintenance and Adjustment

3. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head (Figure 50).



Figure 50

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 51, item 1) and sliding it through the large hole (Figure 51, item 2) in the frame.

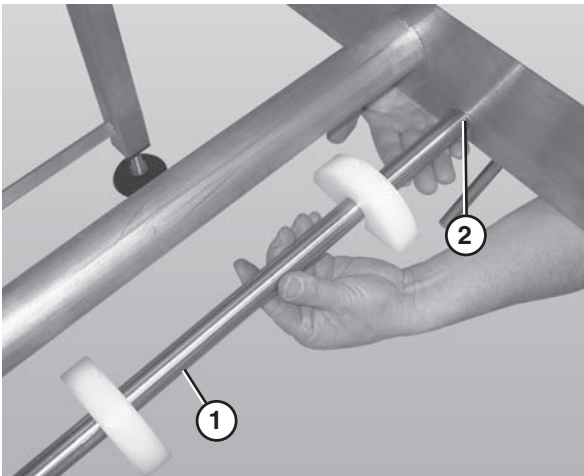


Figure 51

2. Lower the opposite end of the return shaft (Figure 51, 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 52).

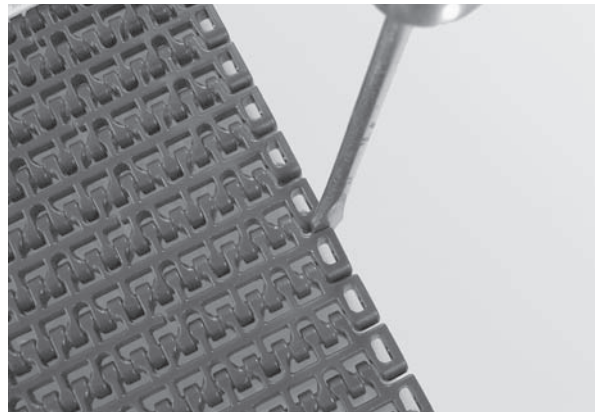


Figure 52

2. Use a second belt rod of the same size to push on the opposite end of the belt rod. (Figure 53).

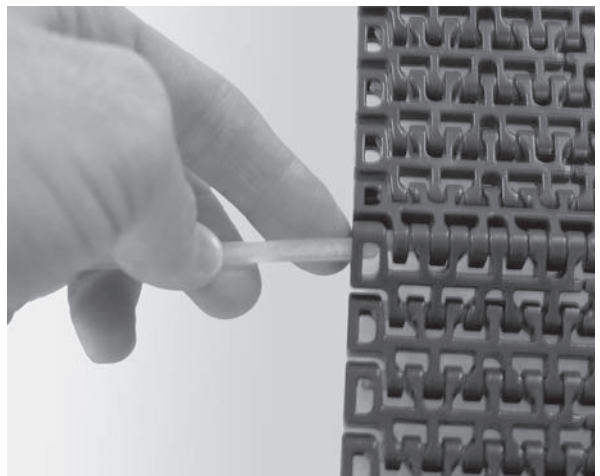


Figure 53

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 54, item 1**) and sliding it through the large hole (**Figure 54, item 2**) in the frame.

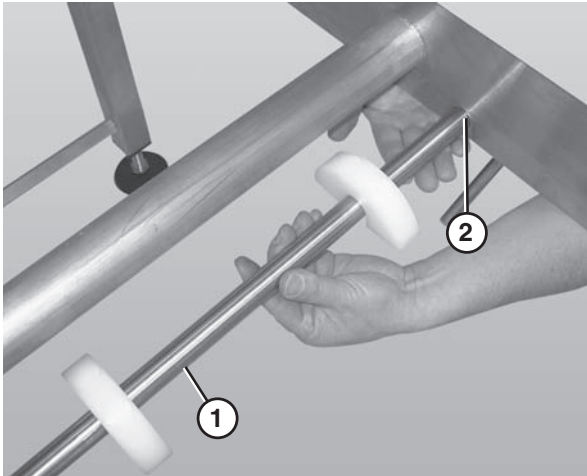


Figure 54

2. Lower the opposite end of the return shaft (**Figure 54, 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.

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 55**).

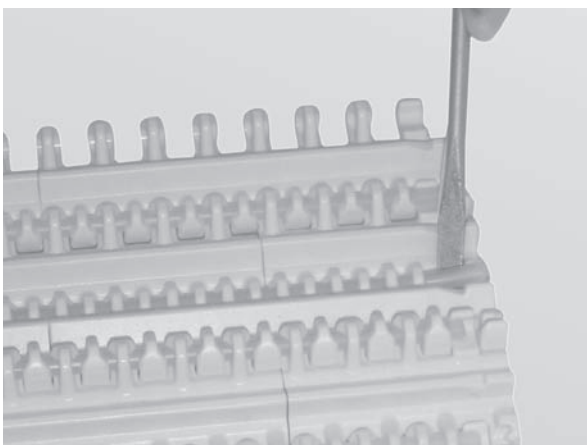


Figure 55

3. Remove the belt rod by gripping the end with a set of pliers and pulling (**Figure 56**).

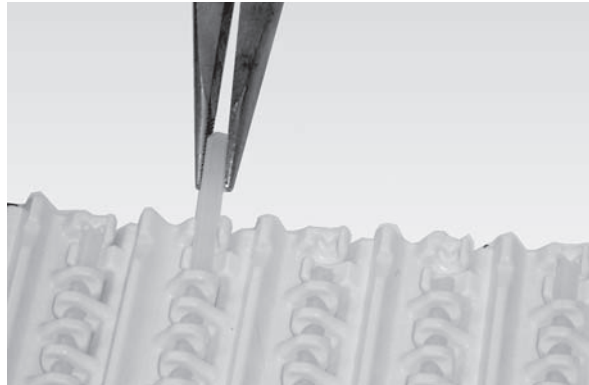


Figure 56

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 57, item 1**) and sliding it through the large hole (**Figure 57, item 2**) in the frame.

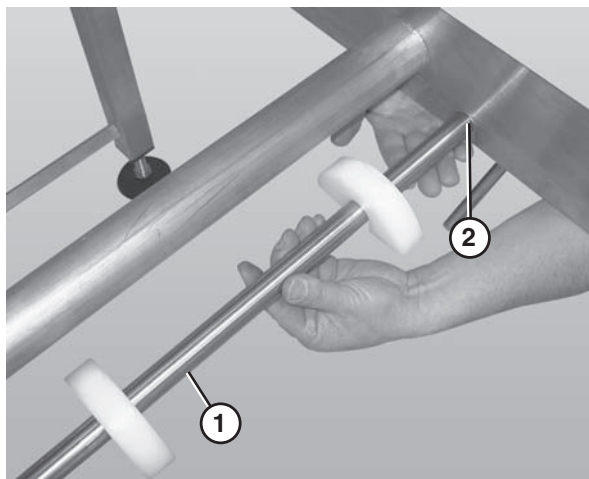


Figure 57

2. Lower the opposite end of the return shaft (**Figure 57, 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.

Preventive Maintenance and Adjustment

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.

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. Loosen the button head screws (**Figure 58, item 1**) that connect the gearmotor to the drive spindle.

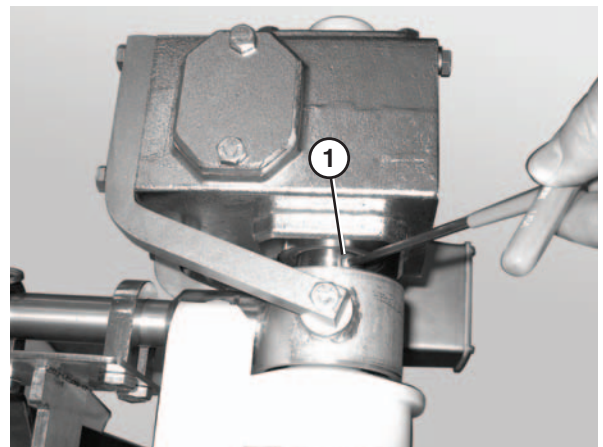


Figure 58

2. Remove the bolts that connect the motor to the drive assembly (**Figure 59**).
3. Remove the motor (**Figure 59, item 1**) from the drive assembly (**Figure 59, item 2**).

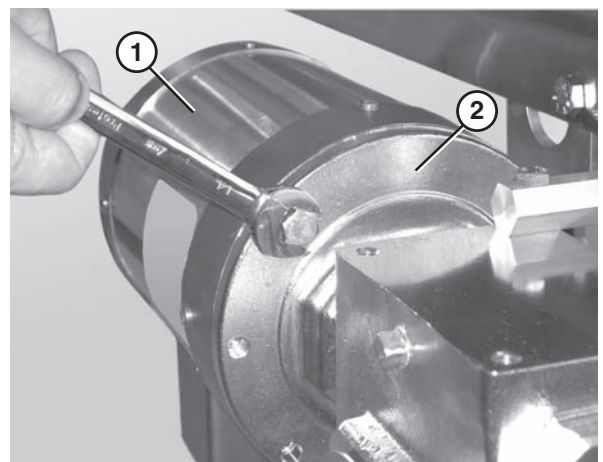


Figure 59

Preventive Maintenance and Adjustment

- Unbolt the drive assembly and slide it off the bearing spindle (**Figure 60, item 1**). Retain key from spindle keyway.

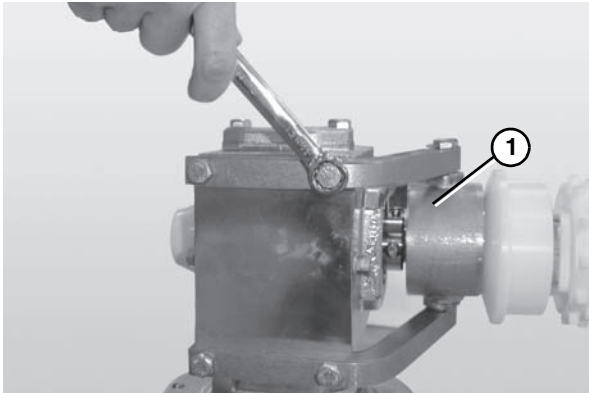


Figure 60

- Remove the pull pin (**Figure 61, item 1**).

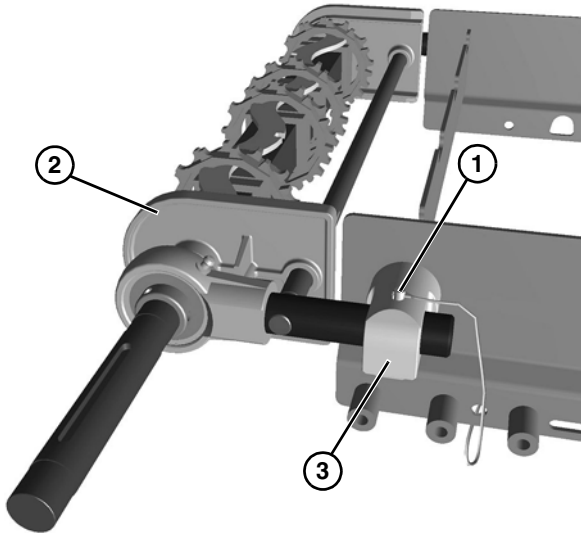


Figure 61

- Slide the drive tail assembly (**Figure 61, item 2**) out of the take up blocks (**Figure 61, item 3**).
- Use a hex wrench to loosen two set screws (**Figure 62, item 1**) on the bearing shaft assembly.

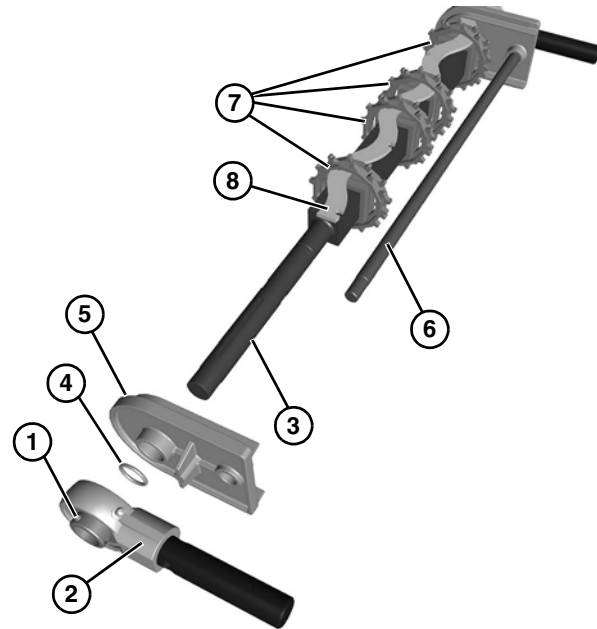


Figure 62

- Slide the bearing shaft assembly (**Figure 62, item 2**) off the drive spindle (**Figure 62, item 3**).

NOTE

*When removing tracking plate, be certain not to lose O-ring (**Figure 62, item 4**).*

- Slide the tracking plate (**Figure 62, item 5**) off the drive spindle.
- Remove pinch guard shaft (**Figure 62, item 6**).
- Remove the sprockets (**Figure 62, item 7**) and alignment bar (**Figure 62, item 8**).

B - Idler Puck Removal

- Remove the pull pins (**Figure 63, item 1**) from tip up hex shaft assembly (**Figure 63, item 2**).

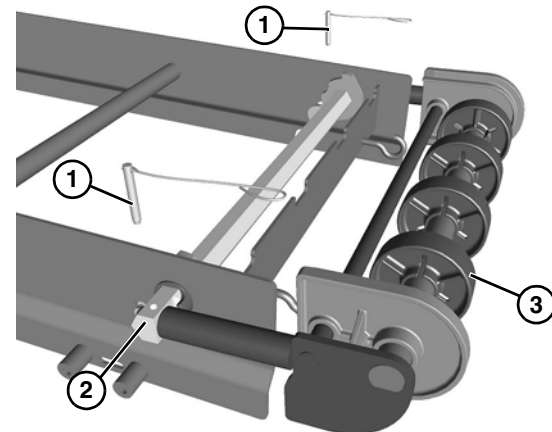


Figure 63

- Slide the idler tail assembly (**Figure 63, item 3**) out of the tip up hex shaft assembly.

Preventive Maintenance and Adjustment

3. Remove the shaft assembly (**Figure 64, item 1**) from idler shaft (**Figure 64, item 2**) and pinch guard shaft (**Figure 64, item 3**).

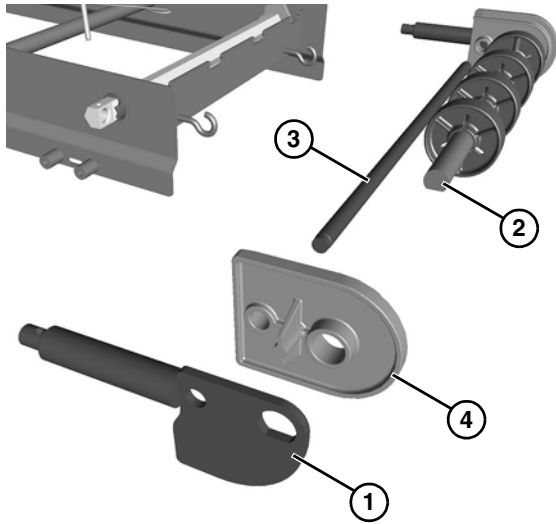


Figure 64

4. Remove tracking plate (**Figure 64, item 4**) from idler shaft and pinch guard shaft.
5. Remove pinch guard shaft (**Figure 64, item 2**).
6. Slide the pucks (**Figure 65, item 1**) and alignment bar (**Figure 65, item 2**) off the idler shaft (**Figure 65, item 3**).

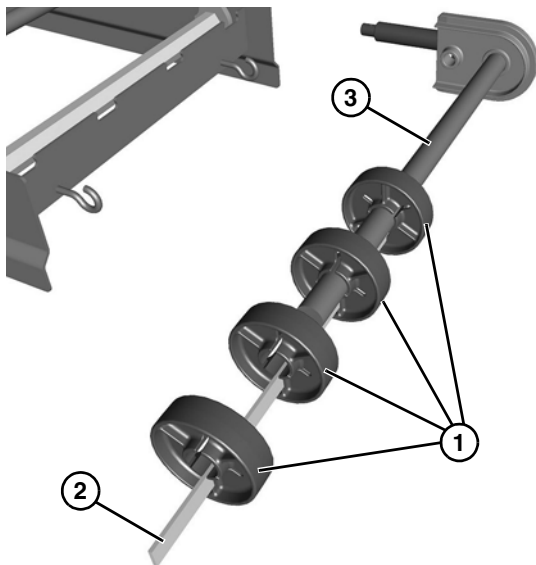


Figure 65

C - Nose Bar Puck Removal

1. Slide the nose bar drive or transfer post (**Figure 66, item 1**) out of the nose bar drive weldment or idler hands (**Figure 66, item 2**).

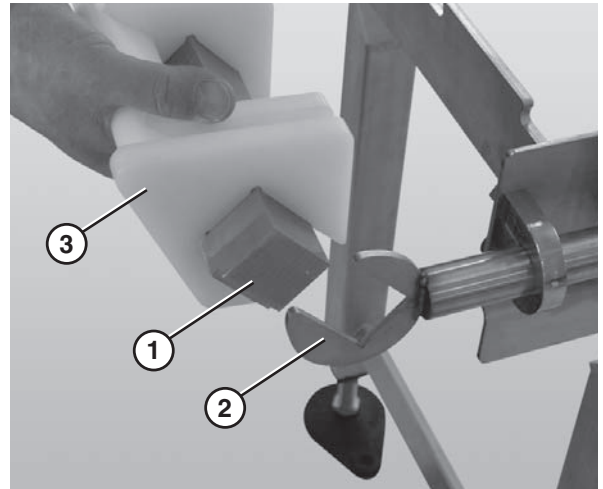


Figure 66

2. Remove the nose bar tracking pucks (**Figure 66, item 3**), if applicable.
3. Remove the nose bar wear strip (**Figure 67, item 3**).

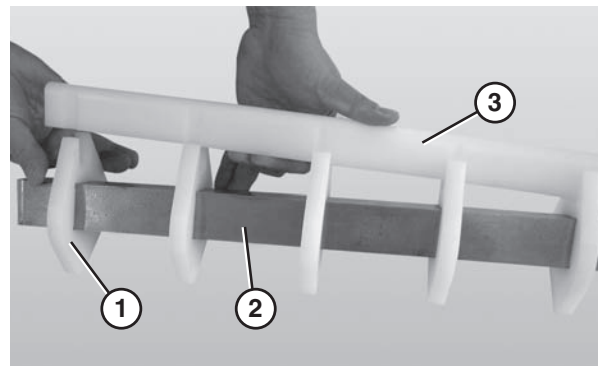


Figure 67

4. Slide the nose bar pucks (**Figure 67, item 1**) off the nose bar shaft (**Figure 67, item 2**).

Preventive Maintenance and Adjustment

Reassembling Tail Assembly

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

Idler Tail

1. Place the pucks (Figure 68, item 1) onto the alignment bar (Figure 68, item 2), and install onto the idler shaft (Figure 68, item 3).

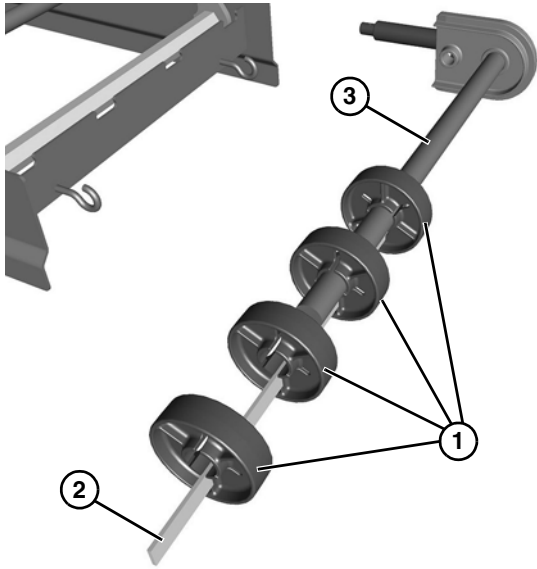


Figure 68

2. Slide all the idler pucks (Figure 68, item 1) along with alignment bar onto idler shaft (Figure 68, item 3).
3. Install the tracking plate (Figure 69, item 1) to each side onto idler shaft (Figure 69, item 2) and pinch guard shaft (Figure 69, item 3).

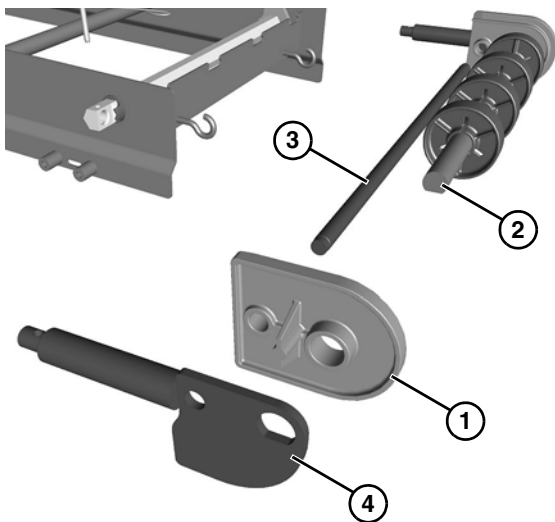


Figure 69

4. Install the shaft assembly (Figure 69, item 4).

Drive Tail

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

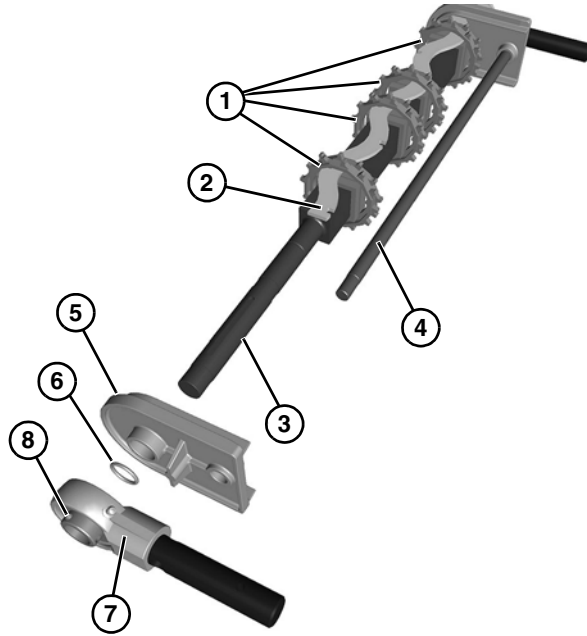


Figure 70

2. Install pinch guard shaft (Figure 70, item 4).
3. Slide the tracking plate (Figure 70, item 5) onto the drive spindle and pinch guard shaft.

NOTE

When installing tracking plate, be certain O-ring (Figure 70, item 6) is installed.

4. Slide the shaft assembly (Figure 70, item 7) onto the drive spindle and tighten set screws (Figure 70, item 8) on bearing.

Nose Bar Idler

1. Slide the nose bar pucks (Figure 71, item 1) onto the nose bar drive post (Figure 71, item 2).

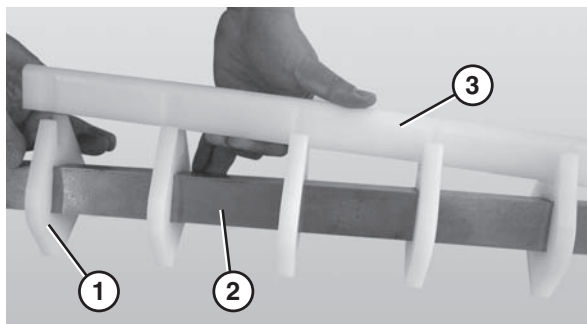


Figure 71

Preventive Maintenance and Adjustment

2. Attach the nose bar wear strip (**Figure 71, item 3**).
3. Attach the nose bar tracking pucks (**Figure 72, item 1**) to the nose bar drive post (**Figure 72, item 2**).

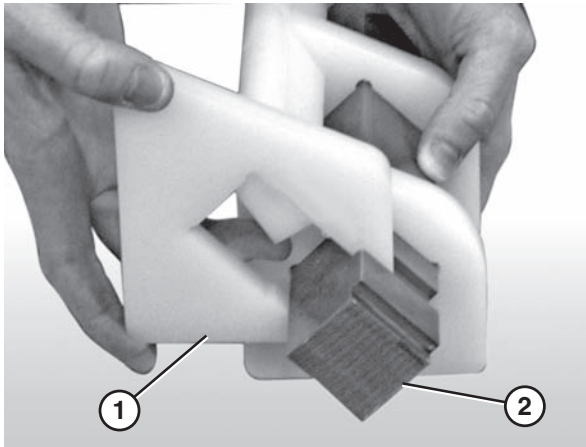


Figure 72

4. After all tracking pucks (**Figure 73, item 3**) are installed, slide the nose bar drive or transfer post (**Figure 73, item 1**) into the nose bar drive weldment or idler hands (**Figure 73, item 2**).

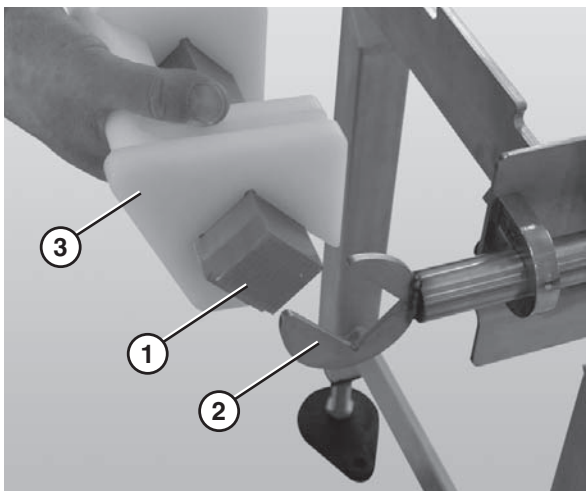


Figure 73

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 74**).

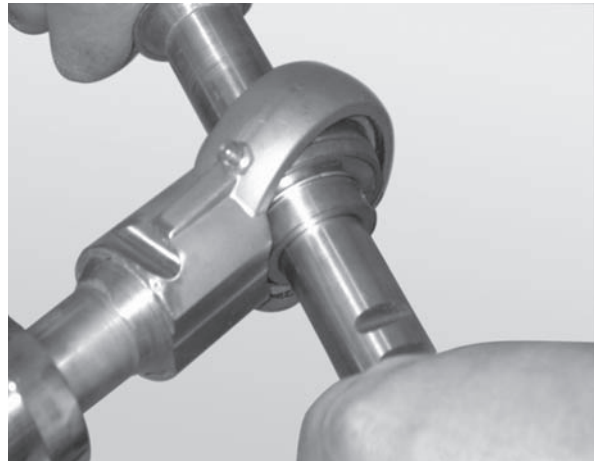


Figure 74

3. Apply lateral pressure to the rod until the bearing comes loose.
4. Remove the worn or damaged bearing (**Figure 75**).

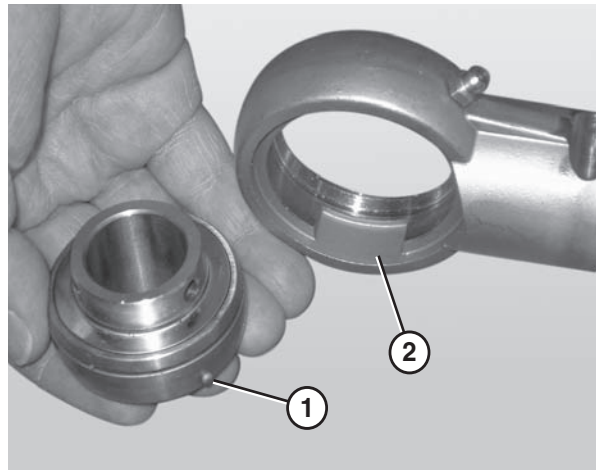


Figure 75

5. Replace the bearing. Reference (**Figure 75**).

NOTE

When inserting the new bearing, make sure the anti-rotation notch (**Figure 75, item 1**) on the bearing lines up with the groove inside the housing (**Figure 75, 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:

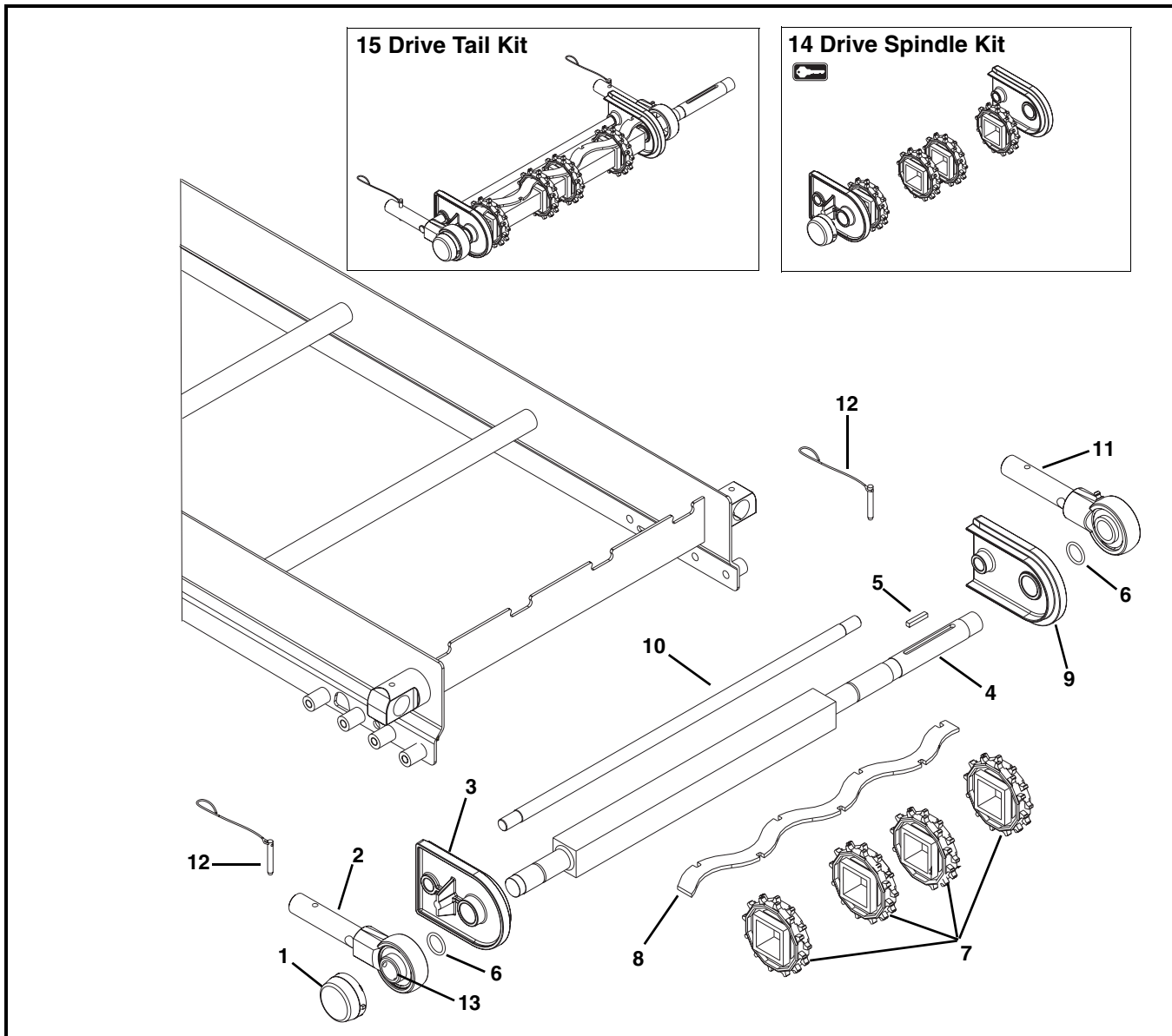
- For wearstrips, replace as needed, making sure wear strips are situated securely in the frame slots.
- For belt returns, Refer to “Belt Return Installation” on page 15.

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	506394	Shaft Assembly, with Bearing
3	506334- <u>WW</u>	Tracking Plate for Standard Belt
	506336- <u>WW</u>	Tracking Plate, for Specialty Intralox Belt
4	506308- <u>WW</u>	Drive Spindle
	506310- <u>WW</u>	CE Drive Spindle

Item	Part Number	Description
5	912-111SS	Square Key, 0.25 x 2.50"
6	807-1588	O-Ring
7	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

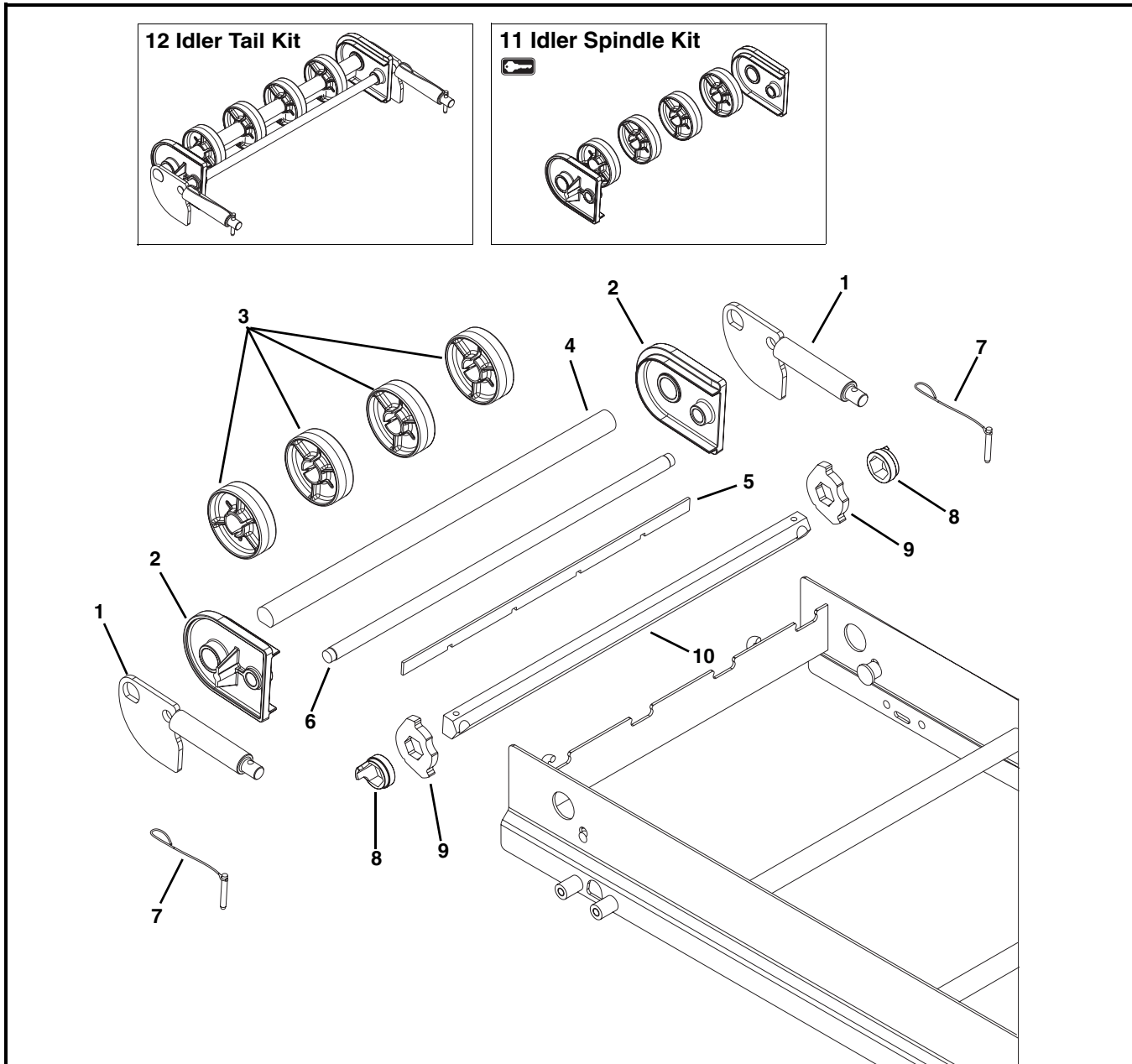
Item	Part Number	Description
8	5160 <u>WW</u>	Sprocket Alignment Bar, for Standard 1.00" Pitch Belt
	5163 <u>WW</u>	Sprocket Alignment Bar, for Specialty Intralox .60" Pitch Belt
	5164 <u>WW</u>	Sprocket Alignment Bar for Specialty Intralox 1.00" Pitch Belt
9	506335- <u>WW</u>	Drive End Tracking Plate, for Standard Belt
	506387- <u>WW</u>	Drive End Tracking Plate, for Specialty Intralox Belt
10	506359- <u>WW</u>	Pinch Guard Shaft
11 *	506394	Shaft Assembly with Bearing
12	501489	Pin Assembly
13	802-162	Bearing
14	74DDU25X- <u>WW</u>	Drive Spindle Kit, for Flat Belt Conveyor when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Standard 1.00" Pitch Belt (Includes Items 1, 3, 6, 7, 9 and 13)
	74DDU16X- <u>WW</u>	Drive Spindle Kit, for Flat Belt Conveyor when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Pitch Belt (Includes Items 1, 3, 6, 7, 9 and 13)
	74DDU11X- <u>WW</u>	Drive Spindle Kit, for Flat Belt Conveyor when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Pitch Belt (Includes Items 1, 3, 6, 7, 9 and 13)
	74DCU25X- <u>WW</u>	Drive Spindle Kit, for Flat Belt Conveyor when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Standard 1.00" Pitch Belt (Includes Items 1, 3, 6, 7, 9 and 13)
	74DCU16X- <u>WW</u>	Drive Spindle Kit, for Flat Belt Conveyor when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Pitch Belt (Includes Items 1, 3, 6, 7, 9 and 13)
	74DCU11X- <u>WW</u>	Drive Spindle Kit, for Flat Belt Conveyor when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Pitch Belt (Includes Items 1, 3, 6, 7, 9 and 13)

Item	Part Number	Description
15**	74DDDTU25X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Standard 1.00" Pitch Belt (Includes Items 1 through 12)
	74DDDTU16X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Pitch Belt (Includes Items 1 through 12)
	74DDDTU11X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered with a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Pitch Belt (Includes Items 1 through 12)
	74DDCTU25X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Standard 1.00" Pitch Belt (Includes Items 1 through 12)
	74DDCTU16X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox .60" Pitch Belt (Includes Items 1 through 12)
	74DDCTU11X- <u>WW</u>	Drive Tail Kit when Conveyor is ordered without a Dorner Gearmotor Mounting Package for Specialty Intralox 1.00" Pitch Belt (Includes Items 1 through 12)
<u>WW</u> = Conveyor width ref: 06 - 36 in 02 increments		
* When conveyor is ordered with a Dorner gearmotor mounting package a shaft assembly is replaced with a gearmotor mounting bracket.		
** Drive Tail Kits are not available for CE conveyors.		

Sprocket Quantity (Item 7)	
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

Service Parts

Tip Up Idler End

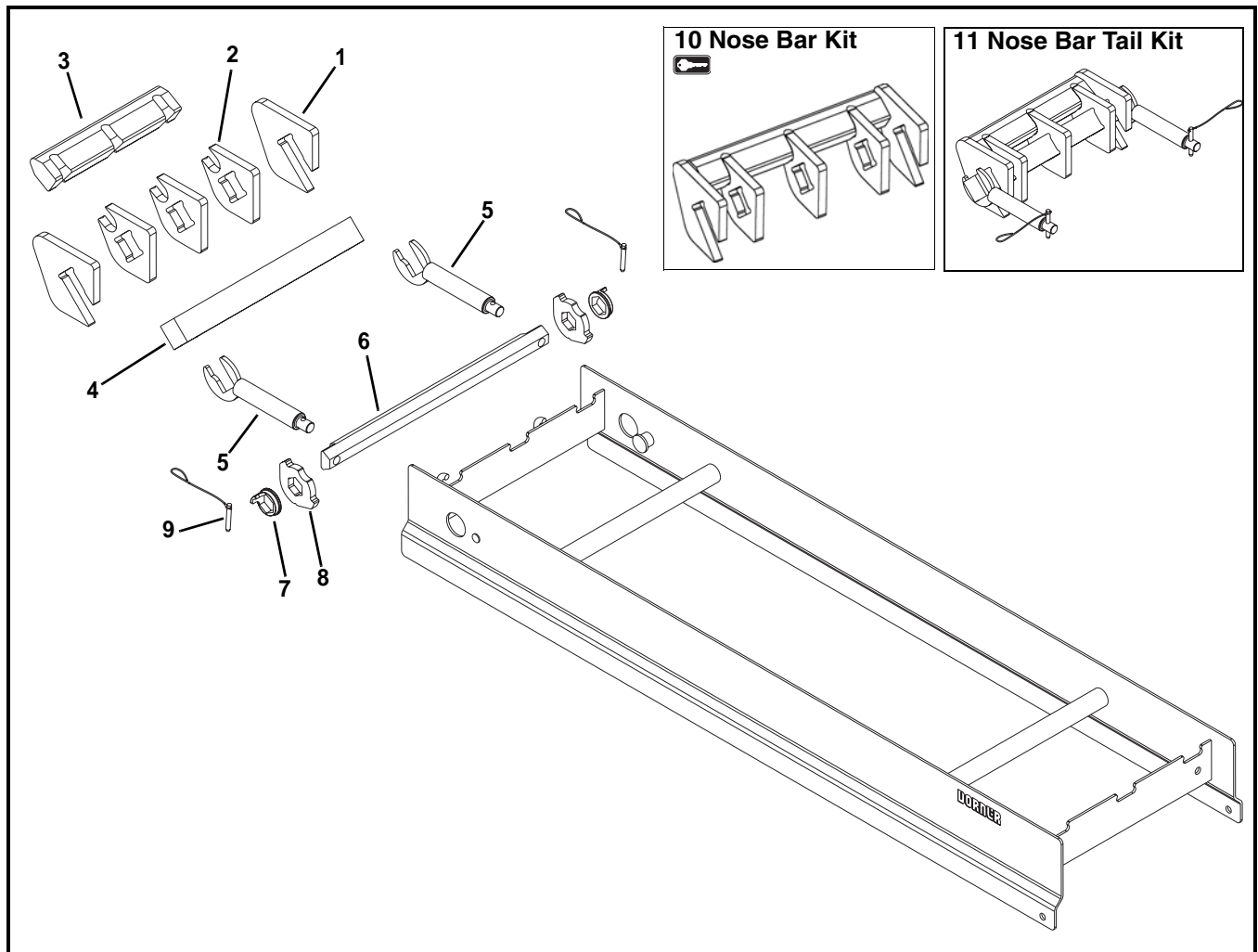


Item	Part Number	Description
1	506802	Idler Shaft Assembly
2	506327- <u>WW</u>	Tracking Plate for Standard Belt
	506332- <u>WW</u>	Tracking Plate for Specialty Intralox Belt
3	506297	Idler Puck
4	501189	Idler Shaft
5	506313- <u>WW</u>	Alignment Bar for Standard Belt
	506314- <u>WW</u>	Alignment Bar, for Specialty Intralox Belt
6	506396- <u>WW</u>	Pinch Guard Shaft
7	501489	Pin Assembly

Item	Part Number	Description
8	506307	Tip Up Sleeve
9	506356	Stop Key
10	506391- <u>WW</u>	Hex Bar
	74UIX- <u>WW</u>	Idler Spindle Kit for Standard Belt (Includes Items 2 and 3)
11	74UISX- <u>WW</u>	Idler Spindle Kit for Specialty Intralox Belt (Includes Items 2 and 3)
	74UITX- <u>WW</u>	Idler Tail Kit for Standard Belt (Includes Items 1 through 7)
12	74UITSX- <u>WW</u>	Idler Tail Kit for Specialty Intralox Belt (Includes Items 1 through 7)

WW = Conveyor width ref: 06 - 36 in 02 increments

Nose Bar Tip Up Idler End



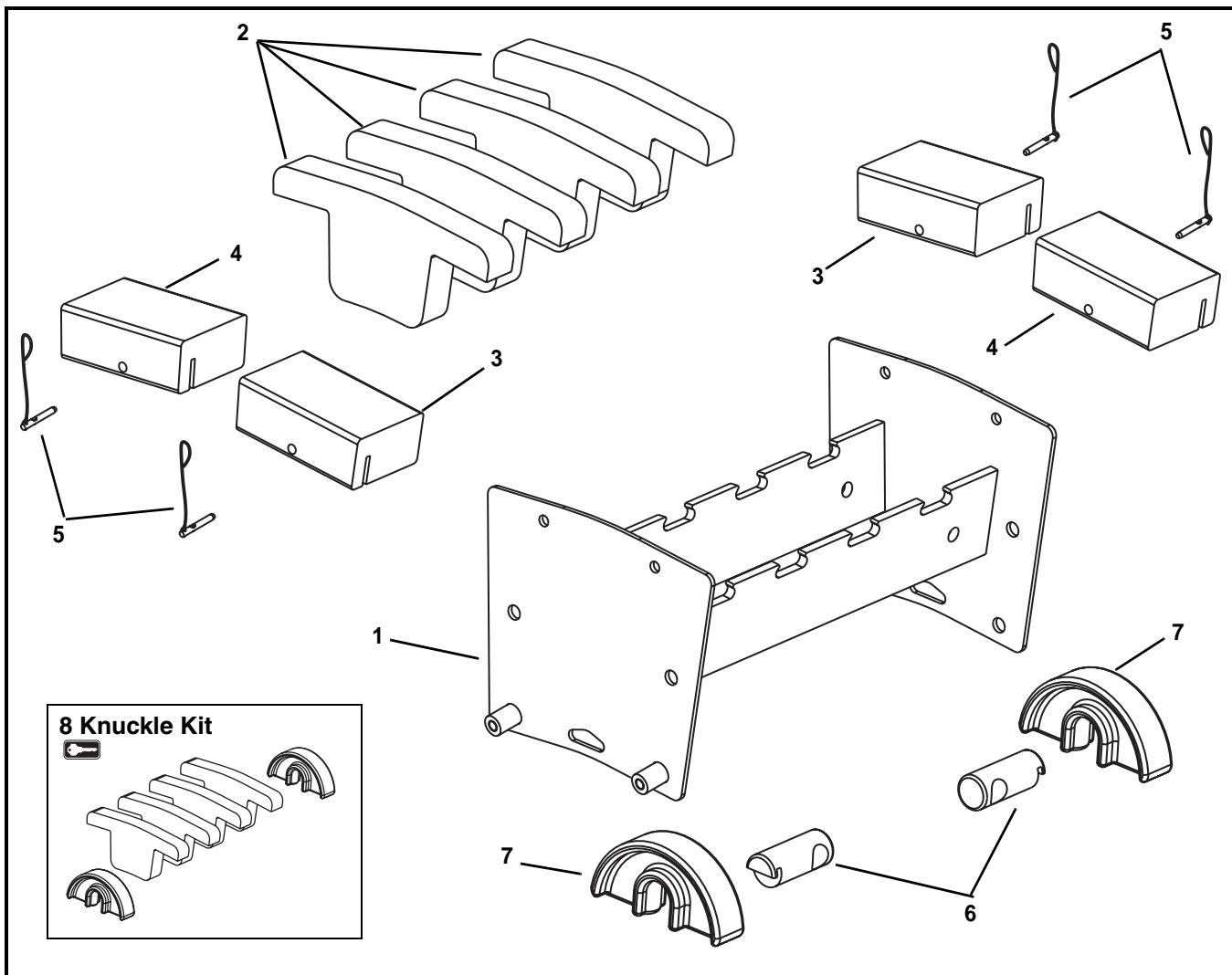
Item	Part Number	Description
1	500490	Nose Bar Tracking Puck
2	500278	Nose Bar Puck
3	5056WW	Wear Strip
4	5037WW	Nose Bar Transfer Post for Standard Belt
	5076WW	Nose Bar Transfer Post for Specialty Intralox Belt
5	509805	Nose Bar Idler Shaft
6	506391-WW	Hex Bar

Item	Part Number	Description
7	506307	Tip Up Sleeve
8	506356	Stop Key
9	501489	Pin Assembly
10	74UNB5X-WW	Nose Bar Kit (Includes Items 1 through 3)
11	74UNBT5X-WW	Nose Bar Tail Kit for Standard Belt (Includes Items 1 through 5 and 9)
	74UNBT5SX-WW	Nose Bar Tail Kit for Specialty Intralox Belt (Includes Items 1 through 5 and 9)

WW = Conveyor width ref: 06 - 36 in 02 increments

Service Parts

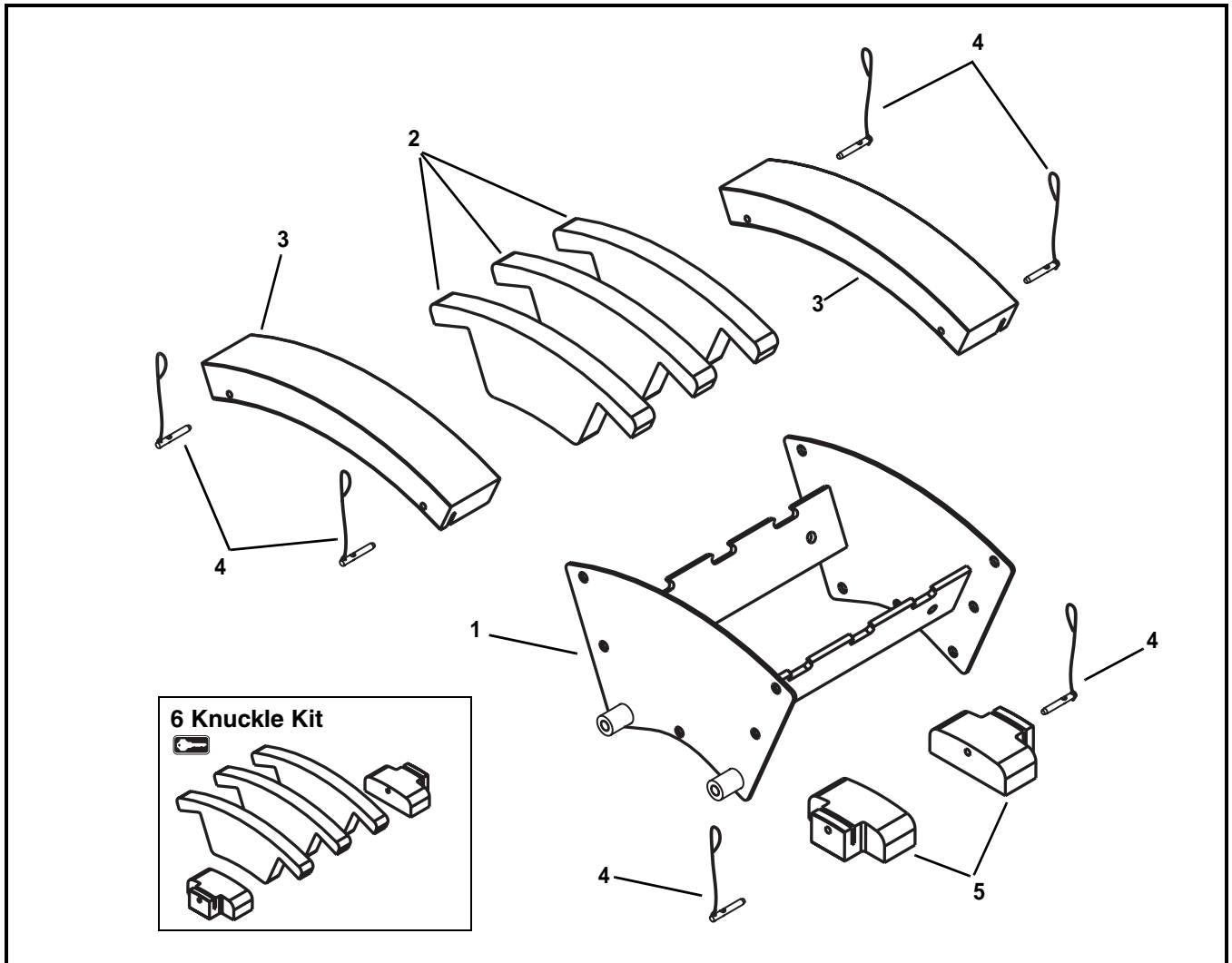
Upper Knuckle for 5° - 15°



Item	Part Number	Description
1	5236 <u>WW</u>	Frame Assembly for 5° Knuckle
	5237 <u>WW</u>	Frame Assembly for 10° Knuckle
	5238 <u>WW</u>	Frame Assembly for 15° Knuckle
2	501695- <u>AA</u>	Wear Strips for 5° - 15° Knuckle
3	501893- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle Right Hand 6"-16" wide
	501685- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle Right Hand 18"-24" wide
	501883- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle Right Hand 6"-16" wide
	501684- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle Right Hand 18"-24" wide

Item	Part Number	Description
4	501699- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle Left Hand 6"-16" wide
	501687- <u>AA</u>	1.5" Hold Down Guide for 5° - 15° Knuckle Left Hand 18"-24" wide
	501698- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle Left Hand 6"-16" wide
	501686- <u>AA</u>	3" Hold Down Guide for 5° - 15° Knuckle Left Hand 18"-24" wide
5	501676	Pull Pin
6	500196	Return Shaft
7	500075	Return Shoe
8	74UKL- <u>WW</u> - <u>AA</u>	Upper Knuckle Kit (Includes Items 2 and 7)
		<u>WW</u> = Conveyor width ref: 06 - 24 in 02 increments
		<u>AA</u> = Angle 05, 10 or 15

Upper Knuckle for 30° - 60°

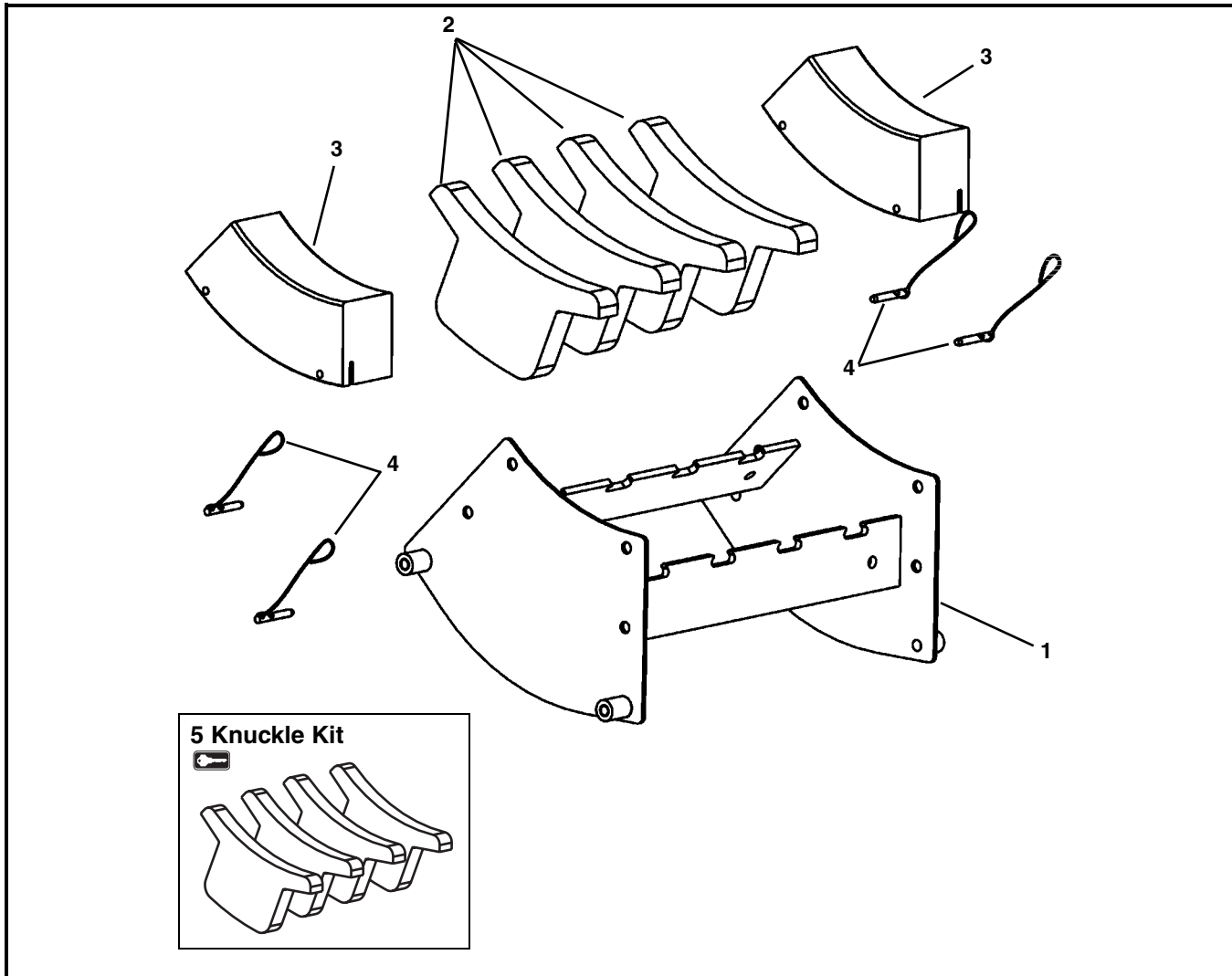


Item	Part Number	Description
1	5239 \underline{WW}	Frame Assembly for 30° Knuckle
	5240 \underline{WW}	Frame Assembly for 45° Knuckle
	5241 \underline{WW}	Frame Assembly for 60° Knuckle
2	501693- \underline{AA}	Wear Strips for 30° - 60° Knuckle
3	501697- \underline{AA}	1.5" Hold Down Guide for 30° Knuckle
	501879- \underline{AA}	3" Hold Down Guide for 30° Knuckle

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

Service Parts

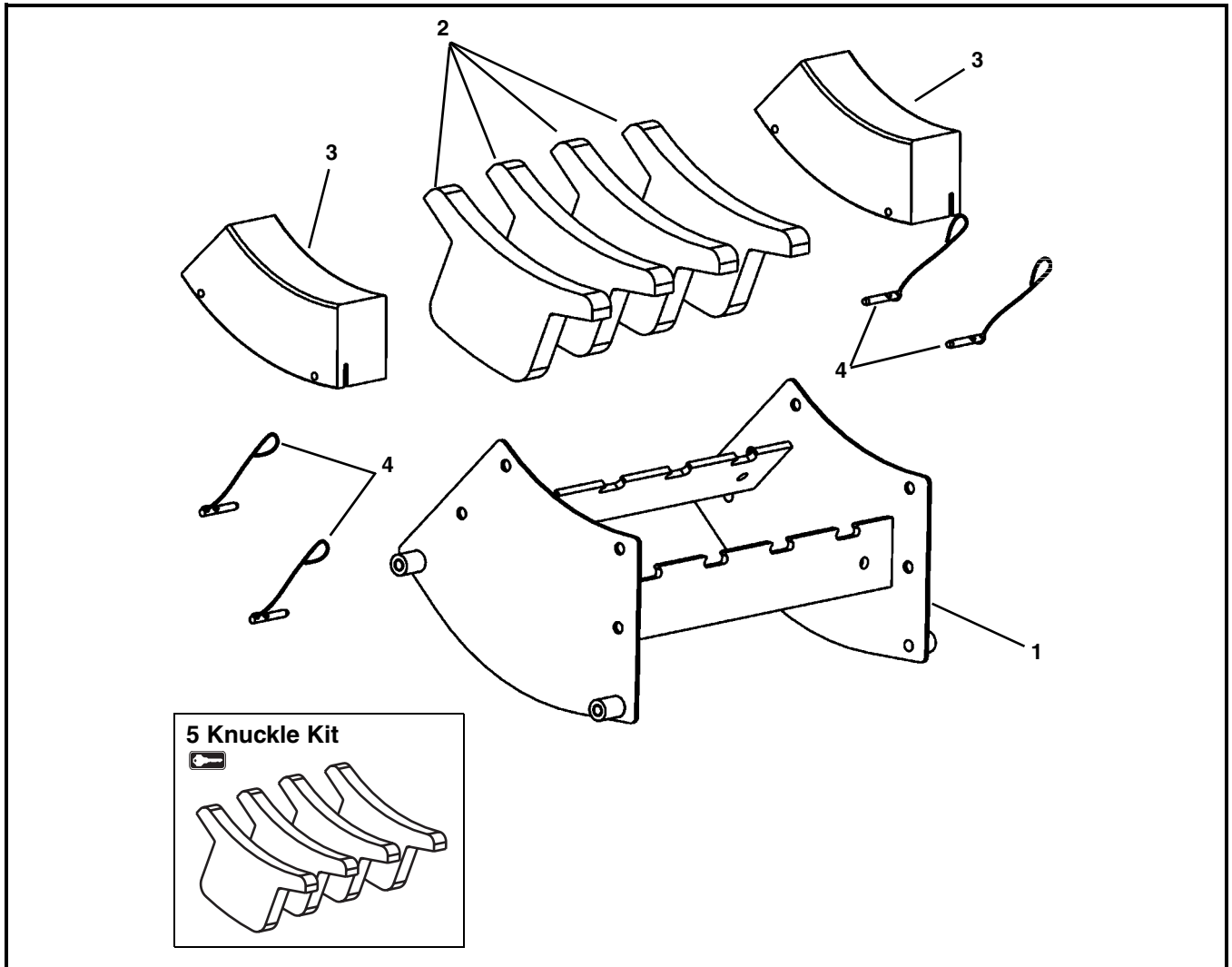
Lower Knuckle for 5° - 15°



Item	Part Number	Description
1	5230 \underline{WW}	Frame Assembly for 5° Knuckle
	5231 \underline{WW}	Frame Assembly for 10° Knuckle
	5232 \underline{WW}	Frame Assembly for 15° Knuckle
2	501694- \underline{AA}	Wear Strips for 5° - 15° Knuckle
3	501692- \underline{AA}	1.5" Hold Down Guide for 5° - 15° Knuckle 6"-16" wide
	501974- \underline{AA}	1.5" Hold Down Guide for 5° - 15° Knuckle 18"-24" wide
	501878- \underline{AA}	3" Hold Down Guide for 5° - 15° Knuckle 6"-16" wide
	501973- \underline{AA}	3" Hold Down Guide for 5° - 15° Knuckle 18"-24" wide

Item	Part Number	Description
4	501676	Pull Pin
5	74LKL- \underline{WW} - \underline{AA}	Lower Knuckle Kit (Includes Item 2)
\underline{WW} = Conveyor width ref: 06 - 24 in 02 increments		
\underline{AA} = Angle 05, 10 or 15		

Lower Knuckle for 30° - 60°

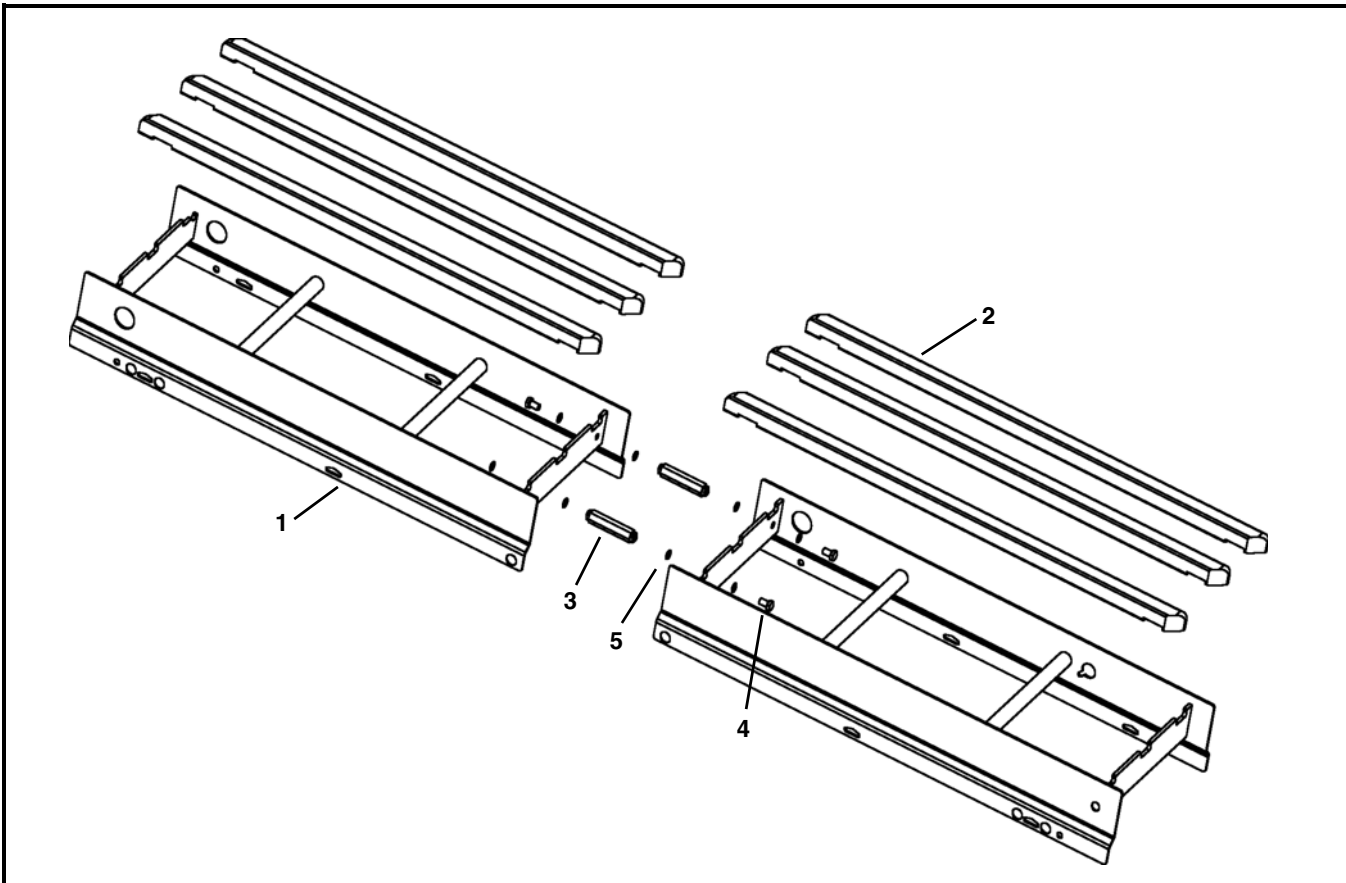


Item	Part Number	Description
1	5233 <u>WW</u>	Frame Assembly for 30° Knuckle
	5234 <u>WW</u>	Frame Assembly for 45° Knuckle
	5235 <u>WW</u>	Frame Assembly for 60° Knuckle
2	501691- <u>AA</u>	Wear Strips for 30° - 60° Knuckle
3	501692- <u>AA</u>	1.5" Hold Down Guide for 30° - 60° Knuckle
	501878- <u>AA</u>	3" Hold Down Guide for 30° - 60° Knuckle

Item	Part Number	Description
4	501676	Pin Assembly
5	74LKH- <u>WW-AA</u>	Lower Knuckle Kit (Includes Item 2)
<u>WW</u> = Conveyor width ref: 06 - 24 in 02 increments		
<u>AA</u> = Angle 30, 45 or 60		

Service Parts

Conveyor Frame and Extension

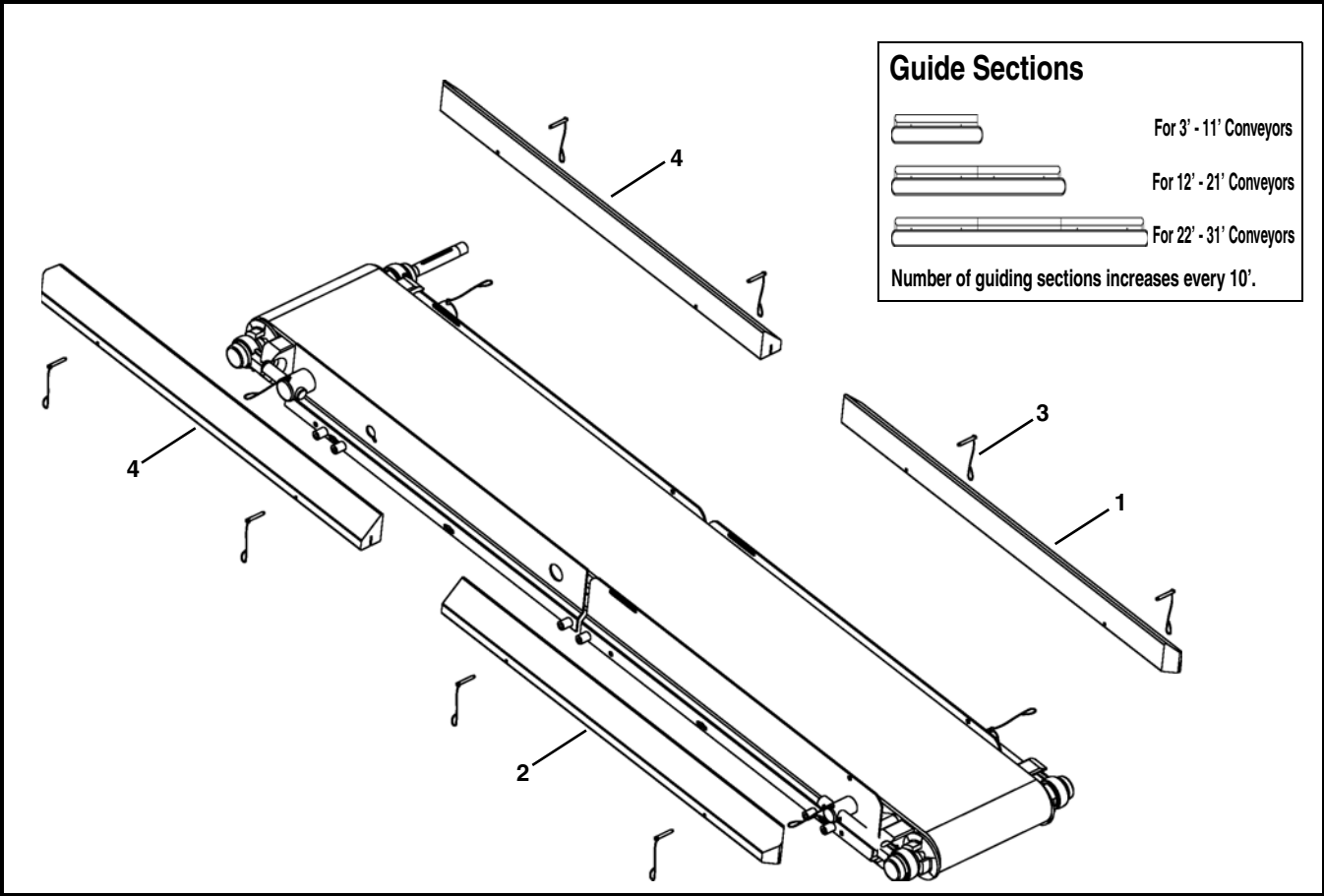


Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	501800-LLL	Straight Wear Strip
3	501190	Hex Post Connector
4	961016MSS	Hex Head Cap Screw M10-1.5 x 16mm
5	807-1616	O-Ring

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
	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	

3" (76 mm) High Sides

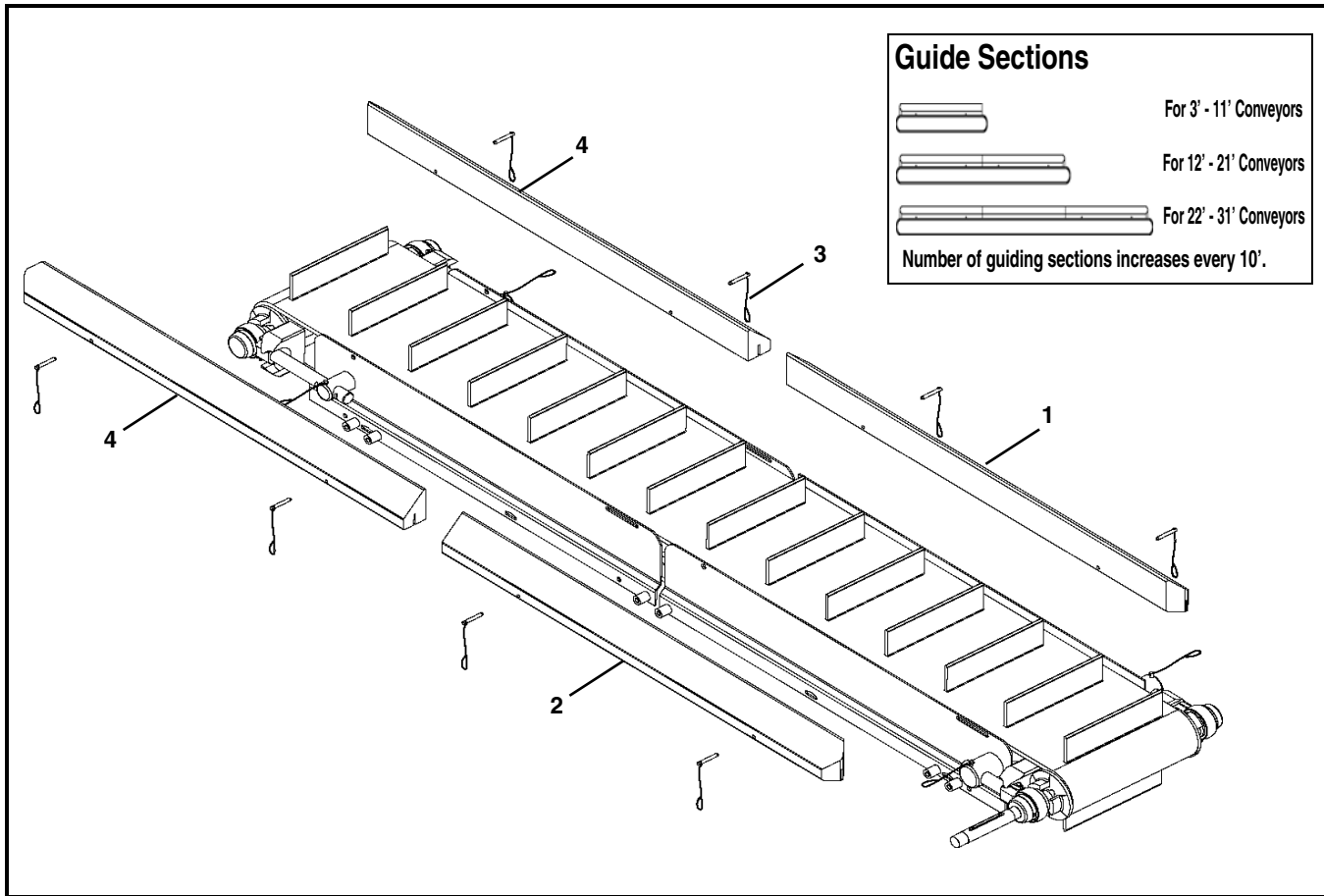


Item	Part Number	Description
1	503501- <u>LLLLL</u>	Right Hand High Side Guide
2	503601- <u>LLLLL</u>	Left Hand High Side Guide
3	501676	Pin Assembly

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		

Service Parts

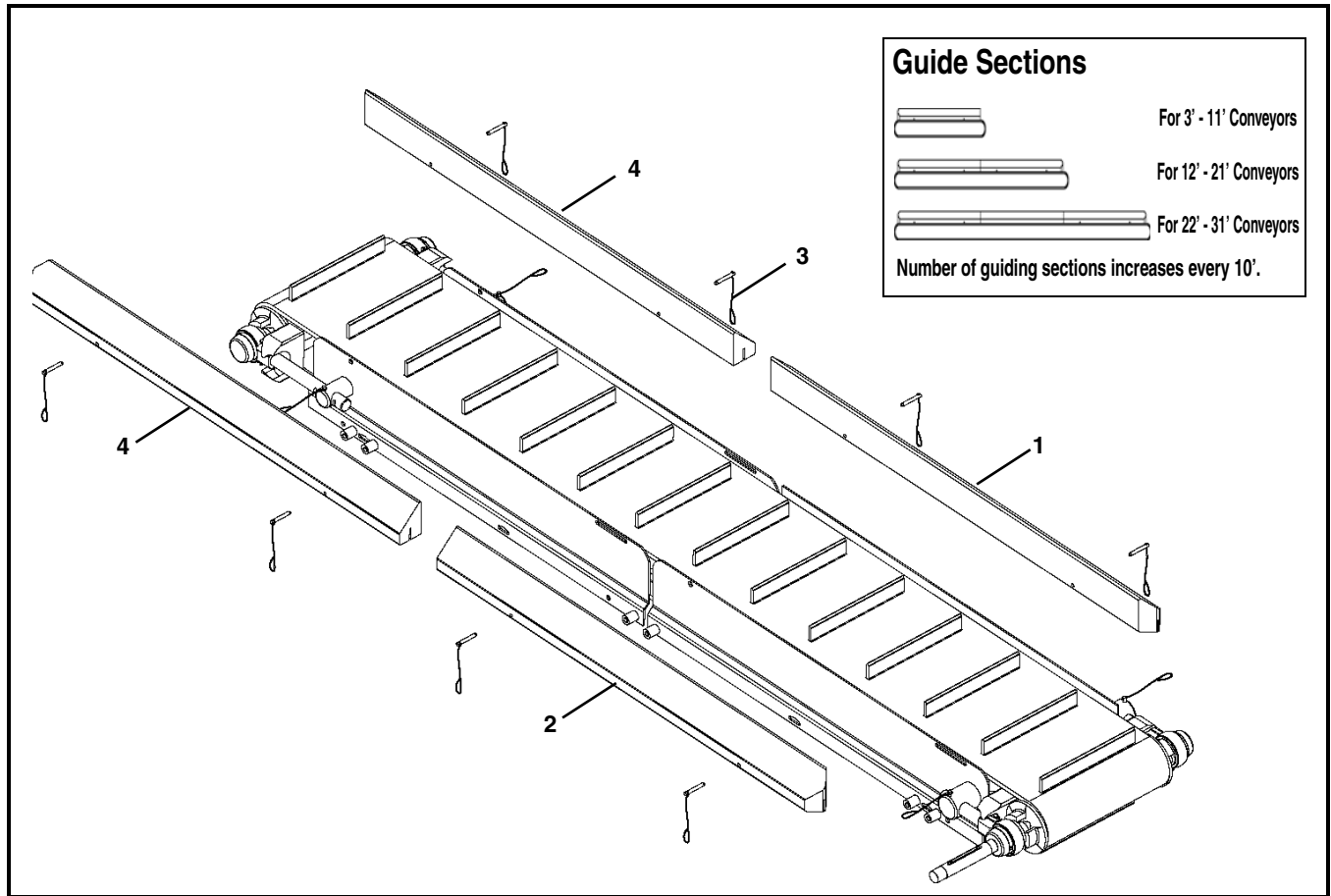
Cleated 1" (25 mm) Guides



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

Item	Part Number	Description
3	501676	Pin Assembly
4	502301- <u>LLLLL</u>	1" Cleated Guide Square End (6" - 16" wide conveyors)
	502302- <u>LLLLL</u>	1" Cleated Guide Square End (18" - 24" wide conveyors)
<u>LLLLL</u> = Guide Length in inches with 2 decimal places.		
Example: Guide Length = 95.25" <u>LLLLL</u> = 09525		

Cleated 3" (76 mm) Guides

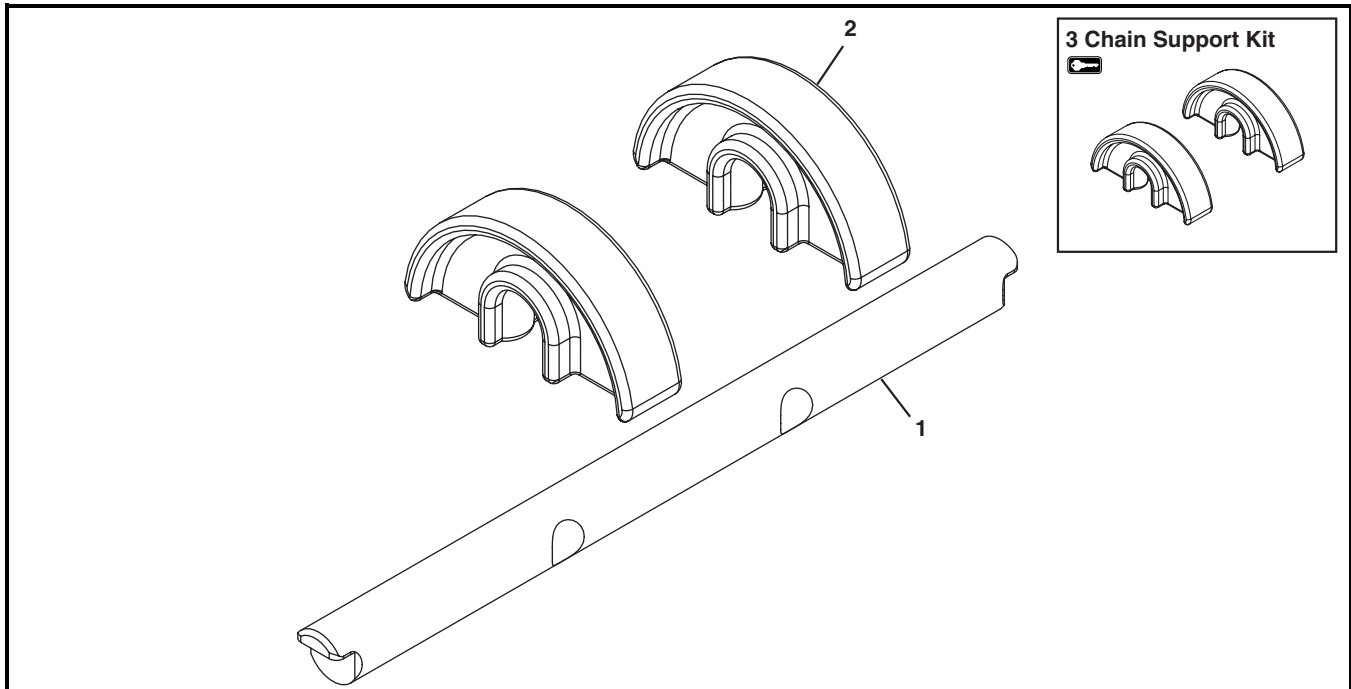


Item	Part Number	Description
1	502701-LLLLL	3" Cleated Right Hand Guide (6" - 16" wide conveyors)
	502702-LLLLL	3" Cleated Right Hand Guide (18" - 24" wide conveyors)
2	502801-LLLLL	3" Cleated Left Hand Guide (6" - 16" wide conveyors)
	502802-LLLLL	3" Cleated Left Hand Guide (18" - 24" wide conveyors)

Item	Part Number	Description
3	501676	Pin Assembly
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		

Service Parts

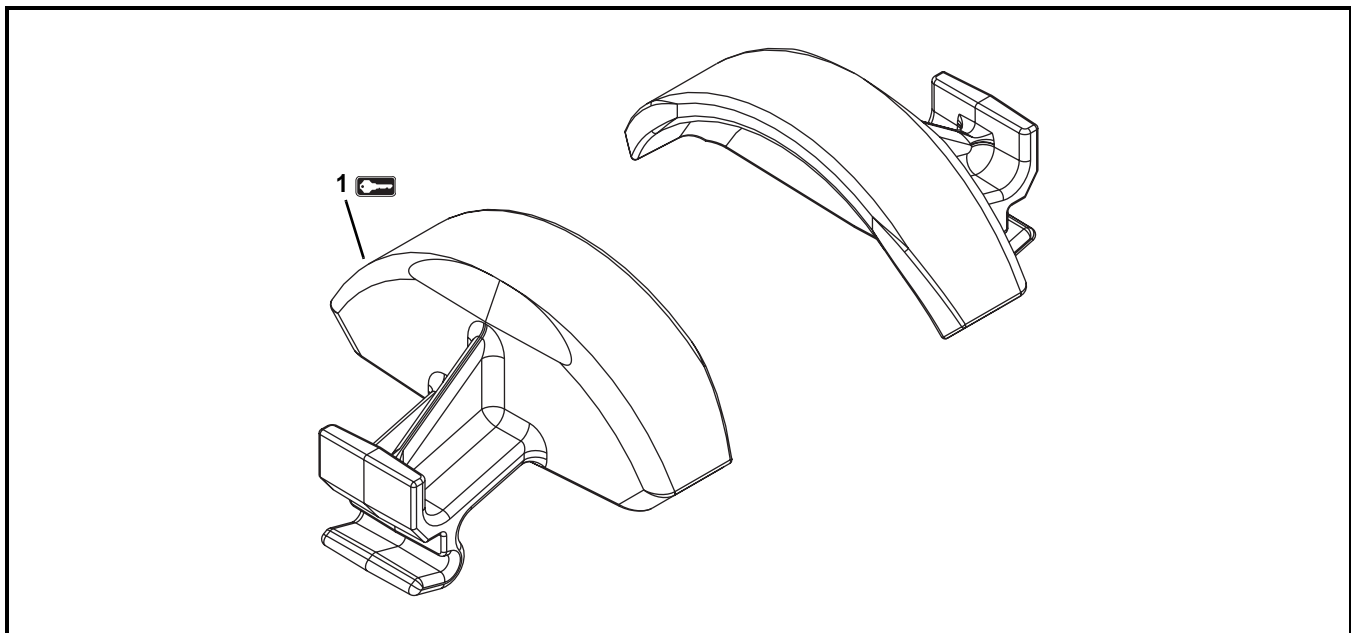
Flat Belt Returns



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

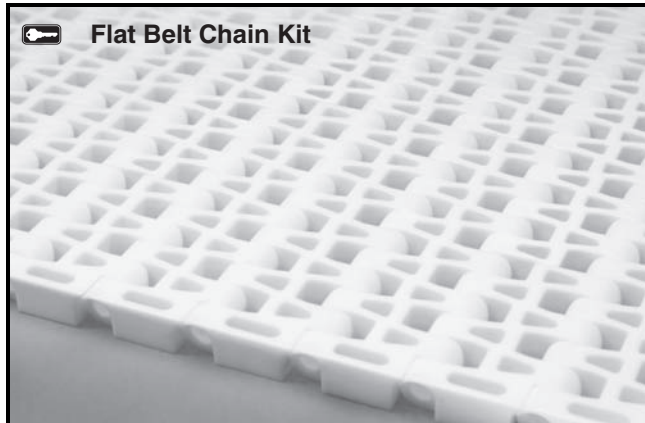
Item	Part Number	Description
3	74R-WW	Chain Support Kit (Includes Item 2)
WW = Conveyor width ref: 06 - 36 in 02 increments		

Cleated Belt Returns



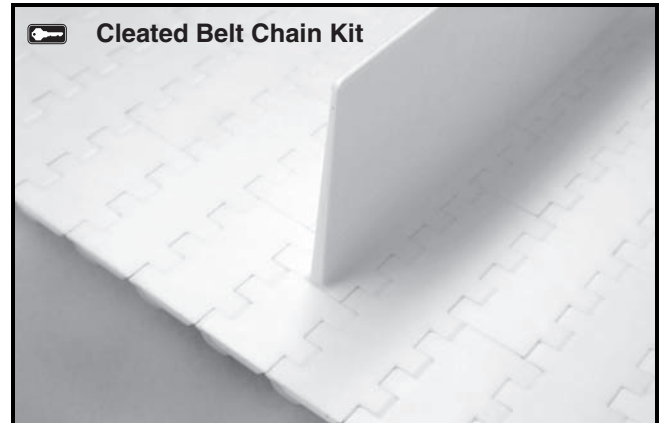
Item	Part Number	Description
1	532224	Cleated Return Shoe

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 - 36 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 - 36 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:

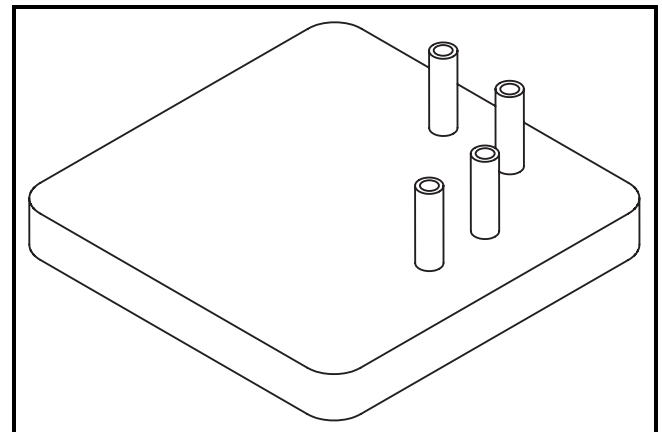
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 74BB-WW

BB = Chain reference number

WW = Conveyor width ref: 06-36 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

Service Parts

Configuring Conveyor Part Number

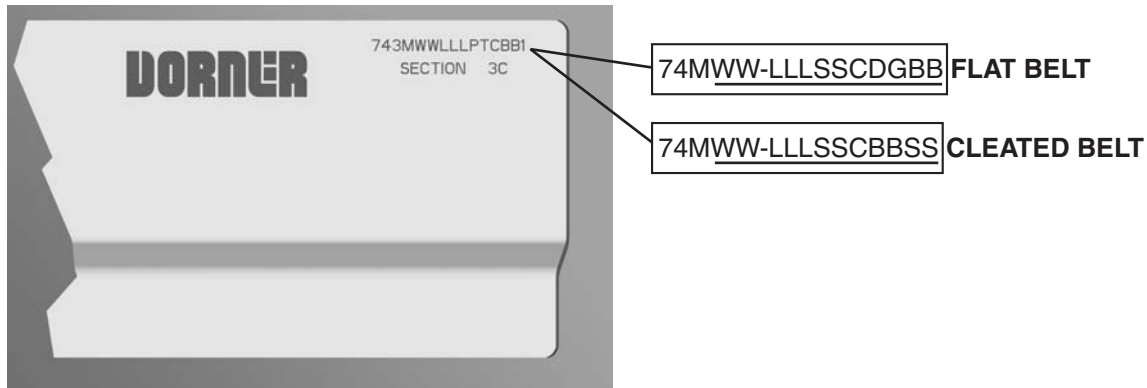


Figure 76

Flat Belt Conveyor

Refer to the model number on the conveyor frame (**Figure 76**). 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:

7UM12-072CC111MA

7400 Ultimate Series end drive, flat belt conveyor, 12" (305mm) wide x 72" (1829mm) long, stands located 18" (457mm) 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 76**). 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:

7UM12-072CC1NA10

7400 Ultimate Series end drive, cleated belt conveyor, 12" (305mm) wide x 72" (1829mm) long, stands located 18" (457mm) 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.



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