



# 2300 Series DustPruf End Drive Conveyors

Installation, Maintenance and Parts Manual



Featuring: *SmartSlot*<sup>™</sup>

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<b>IMPORTANT</b>
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<i>Some illustrations may show guards removed. DO NOT operate equipment without guards.</i>
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Upon receipt of shipment:

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

Dorner's Limited Warranty applies.

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

Dorner 2300 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981, 6,422,382 and corresponding patents and patent applications in other countries.

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

# Warnings - General Safety

## ⚠ WARNING

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

## ⚠ DANGER



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

## ⚠ DANGER



**DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.**

## ⚠ WARNING



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

## ⚠ WARNING



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

## ⚠ WARNING



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

When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, **CHECK FOR POTENTIAL PINCH POINTS** and other mechanical hazards before system start-up.

## ⚠ WARNING



Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.

**SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.**

# Product Description

Refer to Figure 1 for typical components.

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

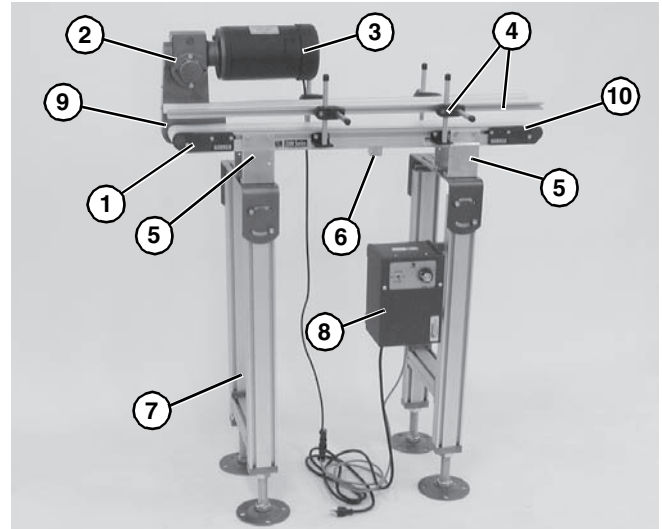
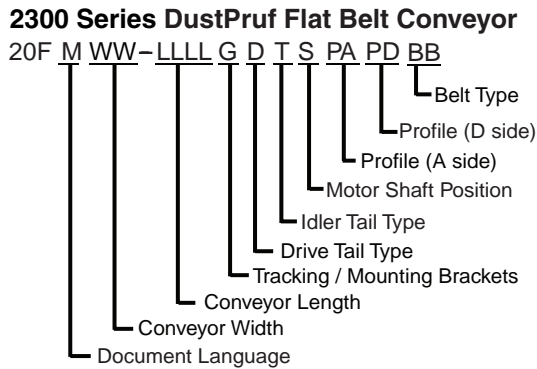


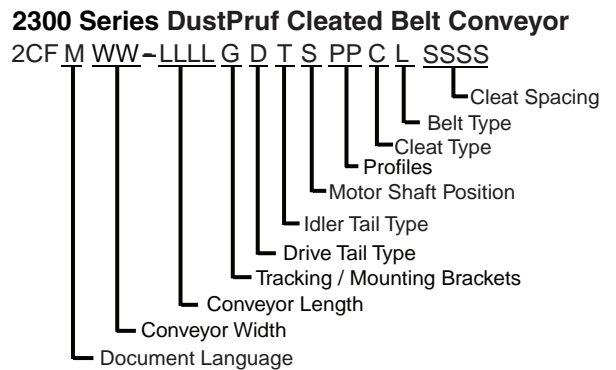
Figure 1

# Specifications

## 2300 Series DustPruf Flat Belt Conveyor



## 2300 Series DustPruf Cleated Belt Conveyor



# Specifications

## Conveyor Supports

### Maximum Distances:

1 = 18" (457 mm)\*\*

2 = 6 ft (1829 mm)\*\*\*

3 = 18" (457 mm)

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

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

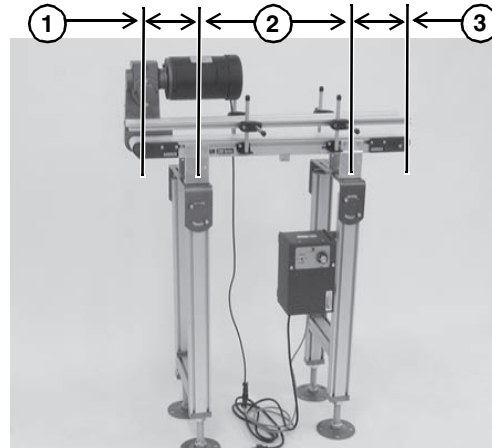


Figure 2

## Specifications

Conveyor Width Reference (WW)	02	04	06	08	12	18	24
Conveyor Belt Width	1.75" (44mm)	3.75" (95mm)	6" (152mm)	8" (203mm)	12" (305mm)	18" (457mm)	24" (609mm)
Maximum Conveyor Load* (See NOTE Below)	36 lb (16kg)	50 lb (23kg)	72 lb (33kg)	84 lb (38kg)	96 lb (44kg)	96 lb (44kg)	96 lb (44kg)
Conveyor Startup Torque*	2 in-lb (0.5Nm)	4 in-lb (0.7Nm)	8 in-lb (0.9Nm)	10 in-lb (1.1Nm)	14 in-lb (1.5Nm)	15 in-lb (1.7Nm)	20 in-lb (2.3Nm)
Belt Travel	4.0" (88 mm) per revolution of pulley						
Maximum Belt Speed*	264 ft/minute (80.5 m/minute)						
Belt Takeup	0.38" (10 mm) of stroke = 0.75" (19 mm) of belt take-up						
Conveyor Length Reference (LLLL)	1.5 ft (457 mm) to 18 ft (5486 mm) in 0.12" (3 mm) increments**						

### NOTE

Maximum conveyor loads based on:

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

\* See Ordering and Specifications Catalog for details.

\*\* Conveyors longer than 12' (3658mm) are only available in 6" (152mm) wide or wider.

## NOTE

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



**Figure 3**

### Installation Component List

Conveyor frame (two sections if longer than 8 ft)  
 Conveyor brackets  
 Return rollers (for longer conveyors)

### Required Tools

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

### Recommended Installation Sequence

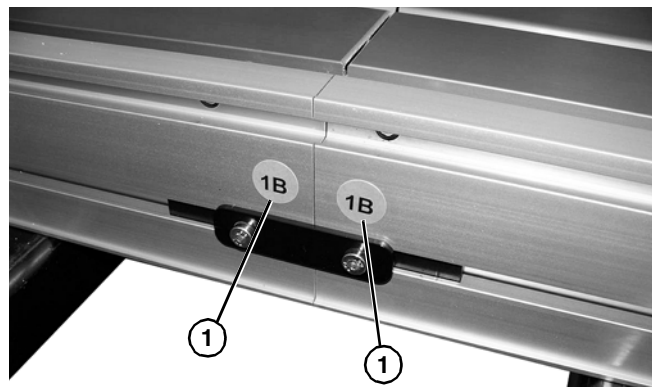
- Assemble conveyor (if required)
- Attach mounting brackets to conveyor
- Attach conveyor to stands (see accessory instructions)
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 22 through page 42 of “Service Parts” section for details)

### Conveyors Up to 8 ft (2438 mm)


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

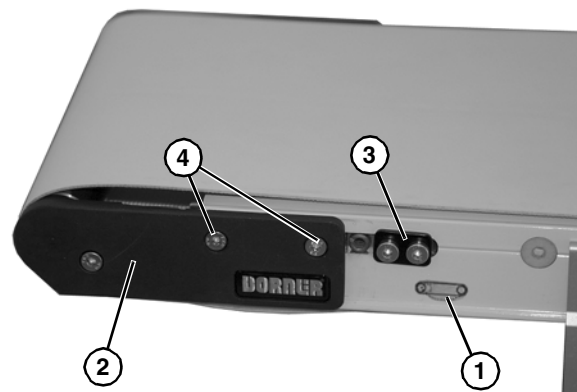
### Conveyors Longer Than 8 ft (2438 mm)

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



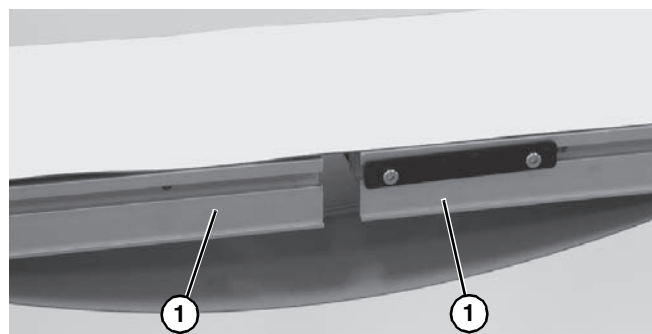
**Figure 4**

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



**Figure 5**

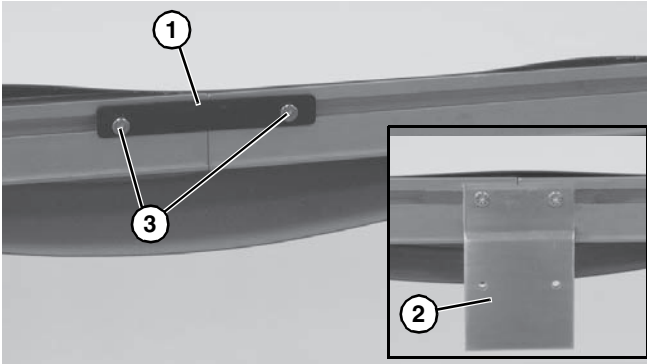
3. Roll out conveyor belt and place conveyor frame sections (**Figure 6, item 1**) into belt loop.



**Figure 6**

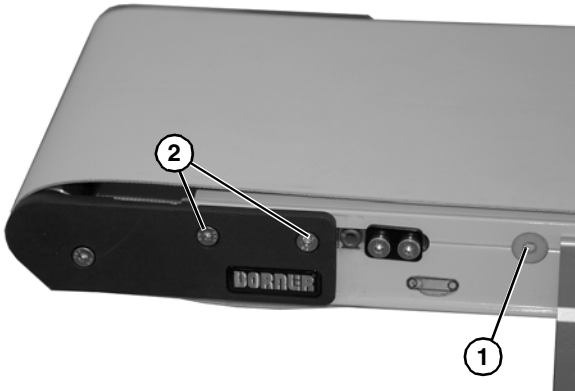
# Installation

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



**Figure 7**

- With a 5 mm hex-key wrench, rotate pinion gear (**Figure 8, item 1**) to tension the conveyor belt. Tighten fastening screws (**Figure 8, item 2**) on both sides of conveyor to 80 in-lb (9 Nm). For proper tensioning, refer to “Conveyor Belt Tensioning” on page 15”.



**Figure 8**

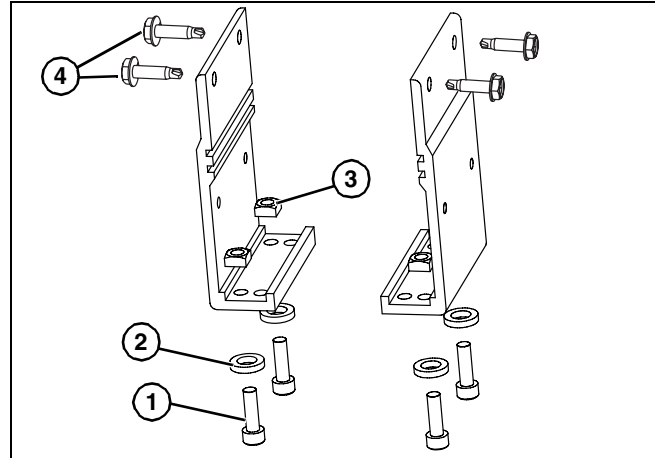
- Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 8 and “Return Rollers” on page 9.
- If equipped with cam tracking assemblies (**Figure 5, item 3**), reposition and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 16.

## Mounting Brackets

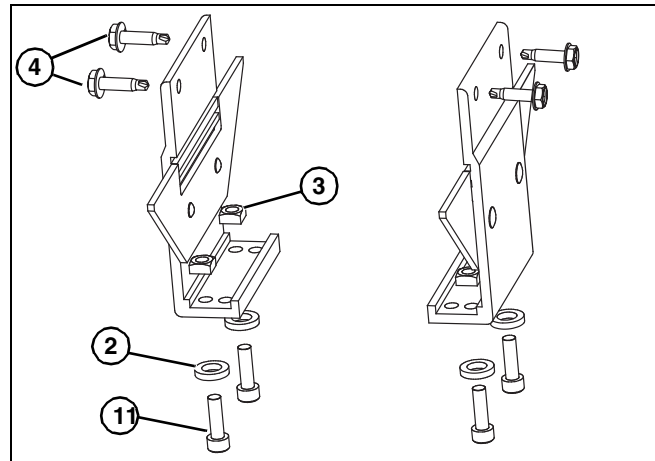
- Locate brackets. Exploded views shown in Figure 9 for flat belt & Figure 10 for a cleated belt.

**⚠ WARNING**

**Installing self-drilling screws into the DustPruf side rail requires substantial force. Failure to properly support the conveyor while installing self-drilling screws may cause the operator or conveyor to slip, causing severe injury. SUPPORT CONVEYOR FRAMES WHILE INSTALLING SELF-DRILLING SCREWS.**



**Figure 9**



**Figure 10**

- Remove screws (**Figure 9, item 1**) or (**Figure 10, item 1**), washers (**Figure 9, item 2**) or (**Figure 10, item 2**), nuts (**Figure 9, item 3**) or (**Figure 10, item 3**) from brackets.

**IMPORTANT**

*For proper methods of attachment to conveyor side rail see page 10.*

- Locate and retain self-drilling screws (**Figure 9, item 4**).



## NOTE

For maximum support distance see page 6.

4. Measure an equal distance (**Figure 11, item 1**) from end of head plate (on both sides of conveyor) and mark placement of mounting brackets (**Figure 11, item 2**). Fasten mounting brackets to conveyor with mounting screws (**Figure 11, item 3**) following proper methods of attachment instructions on page 10.

## NOTE

Mounting brackets for flat belt conveyors shown.

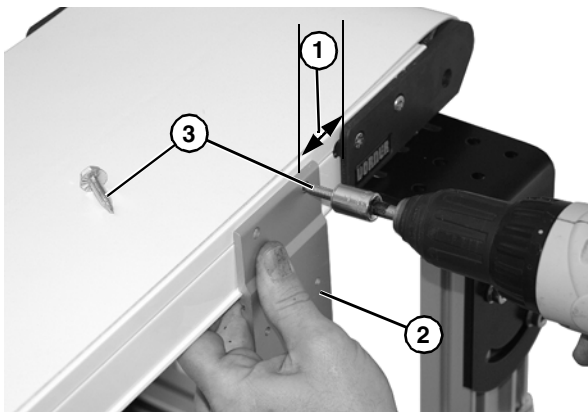


Figure 11

5. Fasten brackets (**Figure 12, item 1**) to support stand (**Figure 12, item 2**) with mounting screws (**Figure 12, item 3**), washers (**Figure 12, item 4**) and nuts (**Figure 12, item 5**).

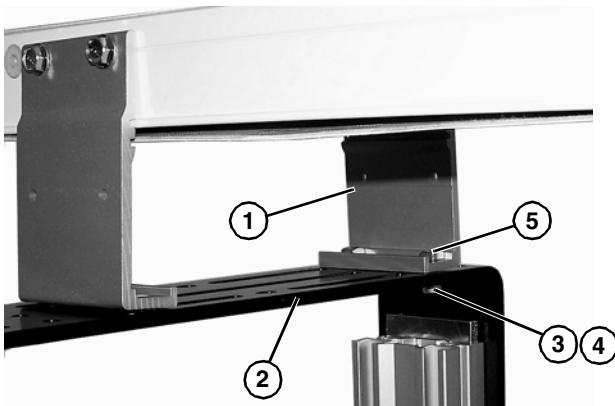


Figure 12

## Return Rollers

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

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

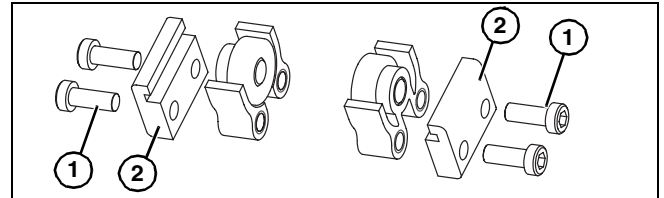


Figure 13

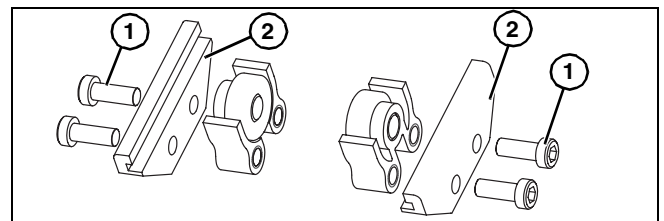


Figure 14

2. Remove screws (**Figure 13, item 1**) & (**Figure 13, item 1**) and clips (**Figure 13, item 2**) from roller assembly.
3. Install roller assemblies (**Figure 15, item 1**) as shown. Tighten screws (**Figure 15, item 2**) to 60 in-lb (7 Nm).

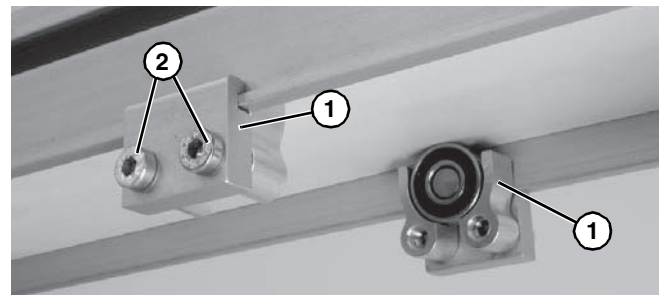


Figure 15

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

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

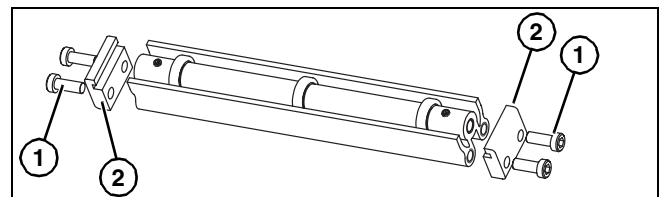
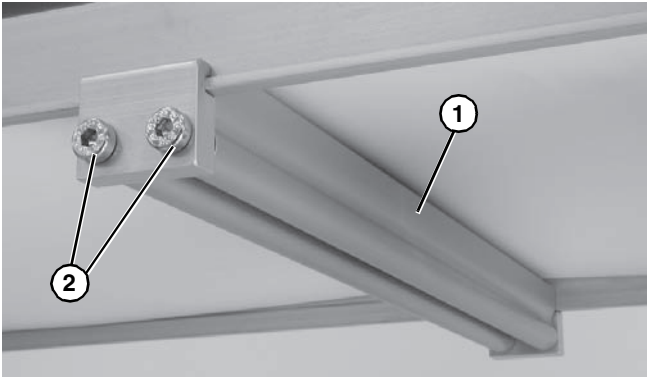


Figure 16

2. Remove screws (**Figure 16, item 1**) and clips (**Figure 16, item 2**) from roller assembly.

# Installation

3. Install roller assembly as shown (**Figure 17, item 1**). Tighten screws (**Figure 17, item 2**) to 60 in-lb (7 Nm).



**Figure 17**

## Proper Methods of Attachment to Side Rails

### **⚠ WARNING**

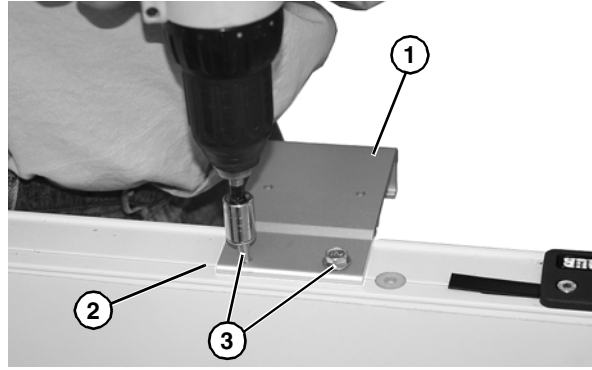
Installing self-drilling screws into the dustpruf side rail requires substantial force. Failure to properly support the conveyor while installing self-drilling screws may cause the operator or conveyor to slip, causing severe injury. **SUPPORT CONVEYOR FRAMES WHILE INSTALLING SELF-DRILLING SCREWS.**

The 2300 DustPruf side rail is designed for self-drilling attachment of brackets and accessories. This can be done in two methods: self-drilling screws or pre-drill for standard screws.

### Self-Drilling Screws

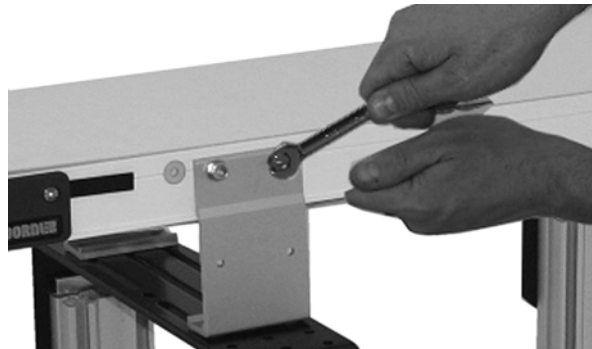
All Dorner accessories are provided with 1/4-20 self-drilling screws.

1. Locate and hold bracket (**Figure 18, item 1**) to side rail. Hole should line up with notch (**Figure 18, item 2**) in side rail.



**Figure 18**

2. With a cordless drill or equivalent install self-drilling screws (**Figure 18, item 3**). Use high speed setting to drill through side wall. Once the tap portion is started switch drill power to a lower speed. Do not fully tighten with drill.
3. Hand tighten the screws to secure (**Figure 19**). Recommended torque is 150 in.lbs (17 Nm).

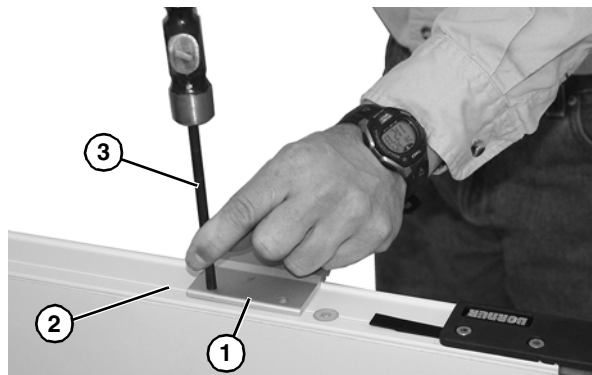


**Figure 19**

### Pre-Drill for Standard Screws

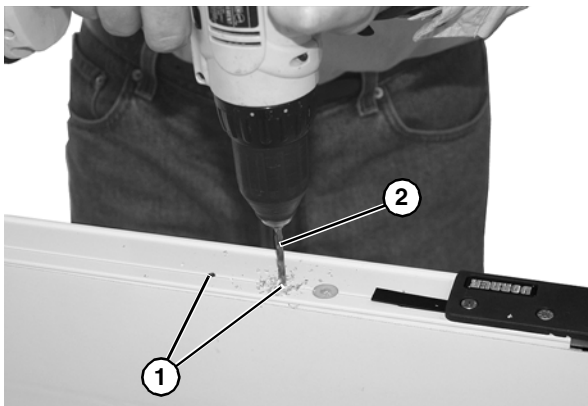
The DustPruf side rail will also accept standard screws. M6-1.0 and 1/4-20 are acceptable. Strength grade 8 is recommended.

1. Locate and hold bracket (**Figure 20, item 1**) to side rail. Hole should line up with notch (**Figure 20, item 2**) in side rail. Mark the hole locations with a center punch (**Figure 20, item 3**) and remove the bracket.



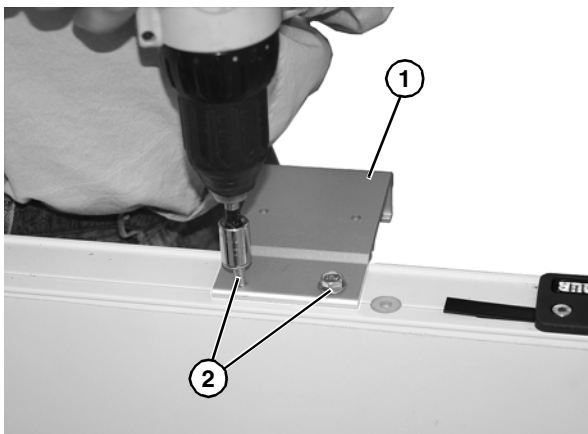
**Figure 20**

2. Drill the hole locations (**Figure 21, item 1**) with a 3/16" drill bit (**Figure 21, item 2**).



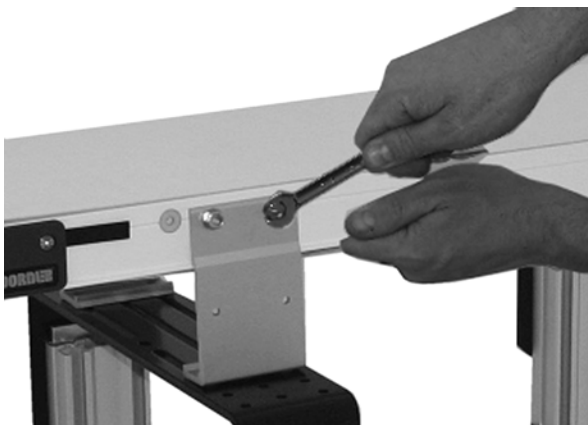
**Figure 21**

3. Position and hold bracket (**Figure 22, item 1**) to side rail. With a standard M6-1.0 or 1/4-20 screw, install screws (**Figure 22, item 2**) with cordless drill or equivalent. Do not fully tighten with drill.



**Figure 22**

4. Hand tighten the screws to secure (**Figure 23**). Recommended torque is 150 in.lbs (17 Nm).



**Figure 23**

## Guiding

### ⚠ WARNING

Installing self-drilling screws into the DustPruf side rail requires substantial force. Failure to properly support the conveyor while installing self-drilling screws may cause the operator or conveyor to slip, causing severe injury.

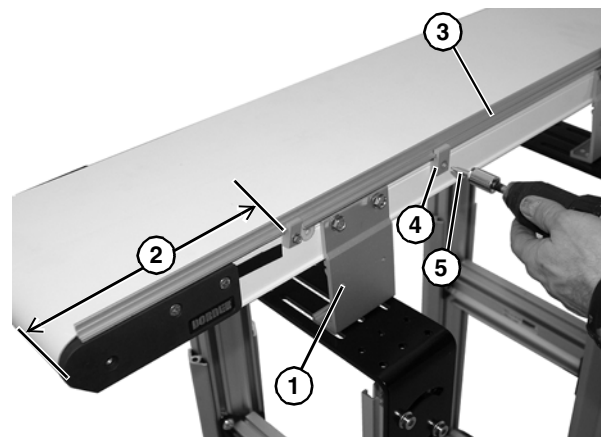
**SUPPORT CONVEYOR FRAMES WHILE INSTALLING SELF-DRILLING SCREWS.**

Due to the DustPruf construction ALL guiding must be located and installed by the end user. Take care in locating retaining clips prior to final installation.

1. Lay out retaining clip (**Figure 24, item 1**) locations. The end clips should be no greater than 12" (**Figure 24, item 2**) from end of the conveyor.

### NOTE

*Profile -09, Low to High Side shown below. For other guide profile layouts see pages page 27 thru page 37.*



**Figure 24**

2. Hold guide (**Figure 24, item 3**) and retaining clips (**Figure 24, item 4**) to conveyor side rail. Install self-drilling screws (**Figure 24, item 5**) following the "Proper Methods of Attachment to Side Rails" on page 10 procedure.

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# Preventive Maintenance and Adjustment

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## Required Tools

### Standard Tools

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

### Special Tools

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

## Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner (part # 625619)
- Clean entire conveyor and knurled pulley while disassembled
- Replace worn or damaged parts

## Lubrication

No lubrication is required. Replace bearings if worn.

## Maintaining Conveyor Belt

### Troubleshooting

Inspect conveyor belt for:

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

Surface cuts and wear indicate:

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

Stalling or slipping indicates:

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

Damage to V-guide indicates:

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

## Cleaning

### IMPORTANT

*Do not use belt cleaners that contain alcohol, acetone, Methyl Ethyl Ketone (MEK) or other harsh chemicals.*

Use Dorner Belt Cleaner (part # 625619). Mild soap and water may also be used. Do not soak the belt.

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

## Conveyor Belt Replacement

### WARNING



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

## Conveyor Belt Replacement Sequence

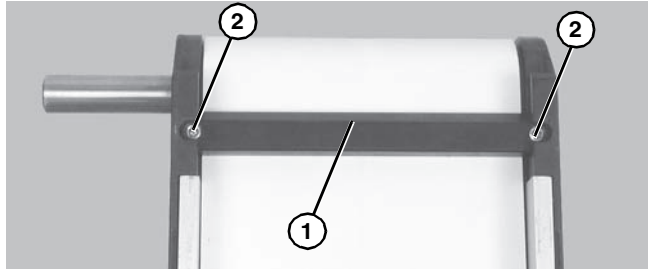
Remove old conveyor belt:

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


# Preventive Maintenance and Adjustment

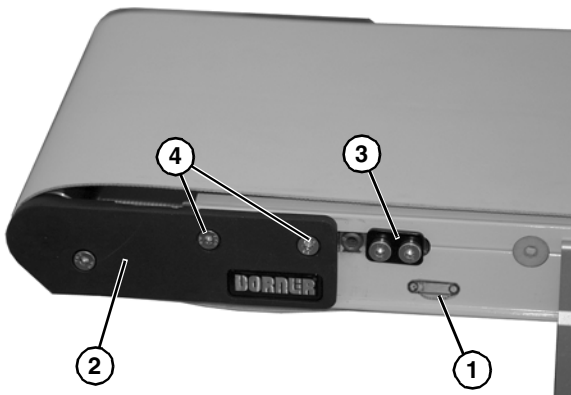
## Belt Removal for Conveyor Without Stands or Gearmotor Mounting Package

1. If equipped, remove bottom wipers (**Figure 25, item 1**): Remove fastening screws (**Figure 25, item 2**) then remove wiper.



**Figure 25**


2. If equipped, remove return rollers and guiding and accessories from one side of conveyor.
3. On tension end of the conveyor, identified with a  label (**Figure 26, item 1**), push in head plate assembly (**Figure 26, item 2**): On both sides of conveyor, loosen and move cam tracking assemblies (**Figure 26, item 3**) (if equipped) away from head plates, then loosen fastening screws (**Figure 26, item 4**) and push head plate assembly inward.



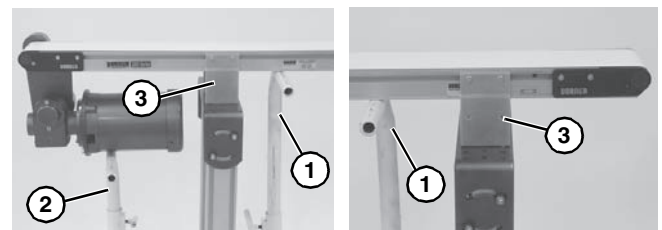
**Figure 26**

4. Remove conveyor belt.

## Belt Removal for Conveyor With Stands and Gearmotor Mounting Package

<b>⚠ WARNING</b>

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

1. Place temporary support stands (**Figure 27, item 1**) at both ends of the conveyor. Place an additional support stand under the drive motor (**Figure 27, item 2**), if equipped. See WARNING.

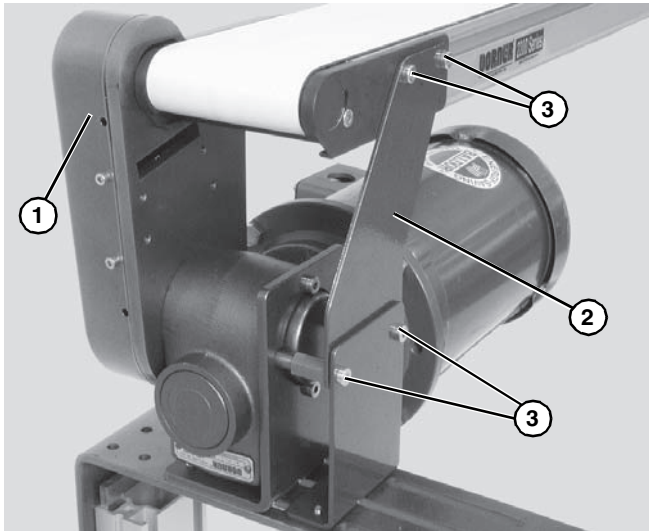


**Figure 27**


2. Remove mounting brackets (**Figure 27, item 3**) from one side of conveyor. (Reverse steps 3 & 4 of “Mounting Brackets” section beginning on page 8.) If equipped with heavy load drive package, remove brackets from side opposite drive cover (**Figure 28, item 1**).
3. If equipped, remove bottom wipers (**Figure 25, item 1**): Remove fastening screws (**Figure 25, item 2**) then remove wiper (**Figure 25, item 1**).

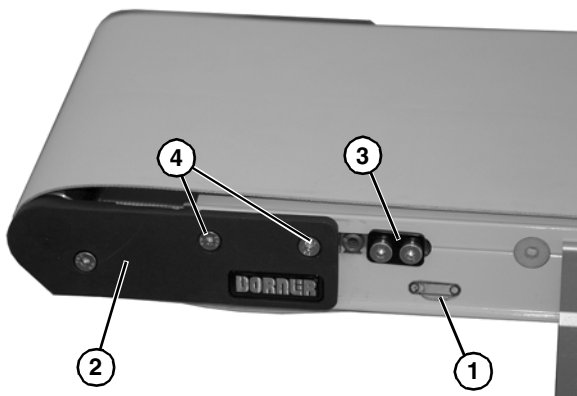
# Preventive Maintenance and Adjustment

- If equipped, remove return rollers, guiding and accessories from side opposite drive cover (**Figure 28, item 1**).



**Figure 28**

- If equipped with heavy load drive package, remove drive support bracket (**Figure 28, item 2**): Remove bracket screws (**Figure 28, item 3**) then remove bracket (**Figure 28, item 2**).
- On tension end of the conveyor, identified with a  label (**Figure 29, item 1**), push in head plate assembly (**Figure 29, item 2**): On both sides of conveyor, loosen and move cam tracking assemblies (**Figure 29, item 3**) (if equipped) away from head plates, then loosen fastening screws (**Figure 29, item 4**) and push head plate assembly inward.



**Figure 29**

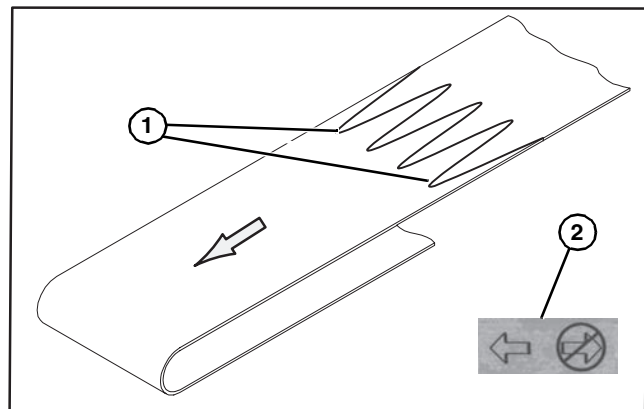
- Remove belt (**Figure 30, item 1**) from conveyor.



**Figure 30**

## Belt Installation for Conveyor without Stands or Gearmotor Mounting Package


- Orient belt so splice leading fingers (**Figure 31, item 1**) point in the direction of belt travel as identified by the conveyor directional label (**Figure 31, item 2**).



**Figure 31**

- Slide belt onto the conveyor frame assembly.
- Tension belt. Refer to “Conveyor Belt Tensioning” on page 15.
- If equipped, install wipers, return rollers and guiding.

## Belt Installation for Conveyor with Stands and Gearmotor Mounting Package

<b>⚠ WARNING</b>

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

# Preventive Maintenance and Adjustment


1. Ensure temporary support stands (**Figure 27, item 1**) are placed at both ends of the conveyor. Place an additional support stand under the drive motor (**Figure 27, item 2**), if equipped. See WARNING.
2. Orient belt so splice leading fingers (**Figure 31, item 1**) point in the direction of belt travel as identified by the conveyor directional label (**Figure 31, item 2**).
3. Install belt (**Figure 32, item 1**) on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.




**Figure 32**

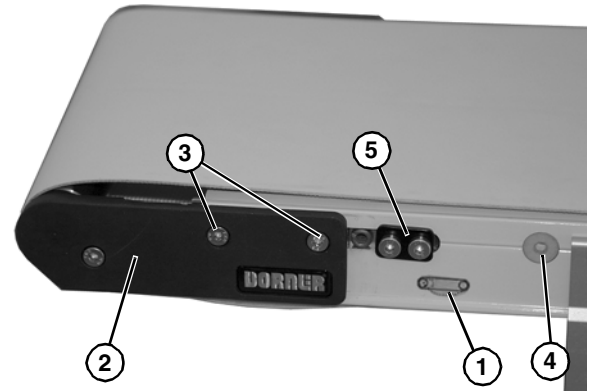
4. Re-install conveyor mounting brackets. Refer to “Mounting Brackets” beginning on page 8, steps 3 through 5.
5. If equipped with a heavy load drive package, re-install drive support bracket (**Figure 28, item 2**).
6. Tension belt. Refer to “Conveyor Belt Tensioning” on page 15
7. If equipped, re-install wipers, return rollers and guiding.

## Conveyor Belt Tensioning

<b>⚠ WARNING</b>

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

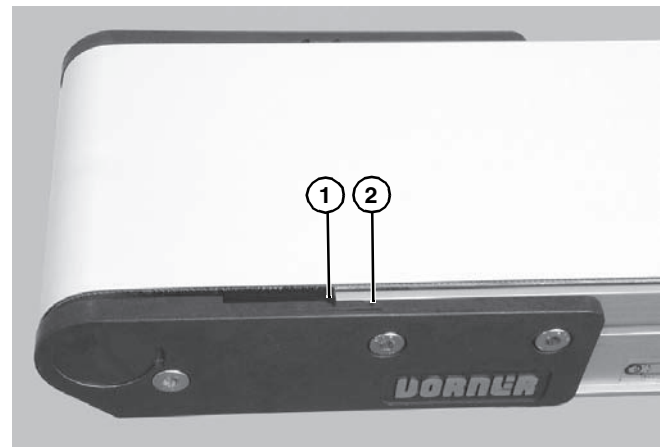
### Conveyors with 1.25" (32 mm) Diameter Pulleys

1. On tension end of the conveyor, identified with a  label (**Figure 33, item 1**), adjust head plate assembly (**Figure 33, item 2**): On both sides of conveyor, loosen fastening screws (**Figure 33, item 3**) and rotate pinion gear (**Figure 33, item 4**) to adjust head plate assembly.



**Figure 33**

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks (**Figure 34, item 1 & 2**). Replace belt if proper tensioning can not be obtained while aligning the end of the conveyor frame with or between the tensioning marks. See NOTE.




**Figure 34**

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

3. After adjusting proper tensioning, tighten fastening screws (**Figure 33, item 3**) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (**Figure 33, item 5**), position against head plates and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 16.

# Preventive Maintenance and Adjustment

## Conveyors with Nose Bar Idlers

1. On tension end of the conveyor, identified with a  label (**Figure 35, item 1**), adjust head plate assembly (**Figure 35, item 2**): On both sides of conveyor, loosen fastening screws (**Figure 35, item 3**) and rotate pinion gear (**Figure 35, item 4**) to adjust head plate assembly.

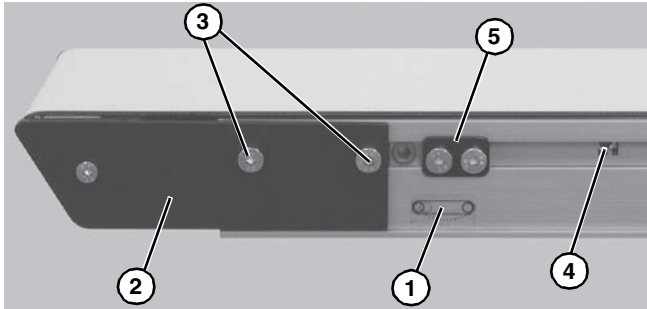


Figure 35

2. Adjust head plate assembly so the edge of the axle support plate (**Figure 36, item 1**) is separated from the end of the conveyor (**Figure 36, item 2**) by 1.125" (29 mm). Replace belt if proper tensioning can not be obtained within a distance of 1.50" (38 mm). See NOTE.

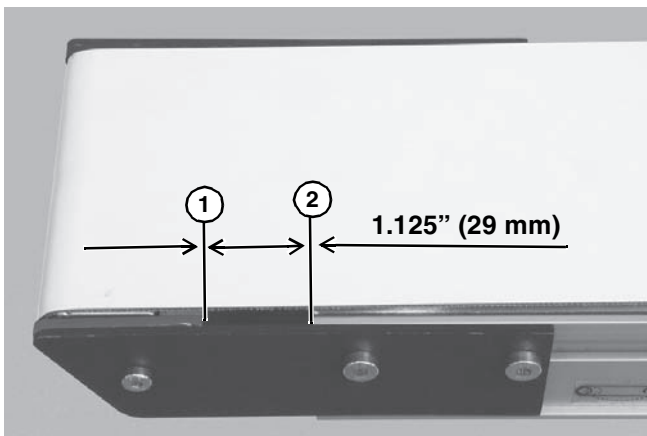


Figure 36

### NOTE

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

3. After adjusting proper tensioning, tighten fastening screws (**Figure 35, item 3**) on both sides of conveyor to 60 in-lb (7 Nm).

4. If equipped with cam tracking assemblies (**Figure 35, item 5**) position against head plates and adjust belt tracking. Refer to "Conveyor Belt Tracking", next section.

## Conveyor Belt Tracking

### V-Guided Belts

V-guided belts do not require tracking adjustment.

### Non V-Guided Belts

Non V-guided belt conveyors are equipped with belt tracking cam assemblies (**Figure 37, item 1**) for belt tracking adjustment.

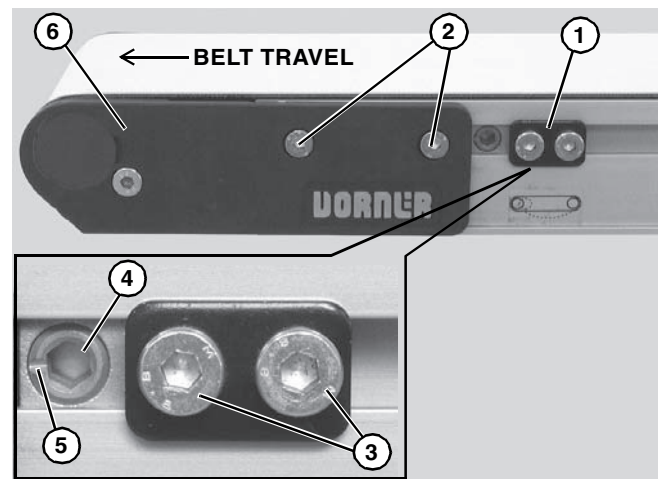


Figure 37


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

1. Ensure head plate fastening screws (**Figure 37, item 2**) on both sides of conveyor are tightened.
2. On both sides of conveyor, loosen two (2) cam fastening screws (**Figure 37, item 3**). Adjust cams (**Figure 37, item 4**) until indicator slots (**Figure 37, item 5**) are horizontal and facing end of conveyor. Then slide cam assemblies against head plates (**Figure 37, item 6**) and re-tighten cam fastening screws (**Figure 37, item 3**) to 60 in-lb (7 Nm).
3. On the side toward which the belt is tracking, loosen head plate fastening screws (**Figure 37, item 2**).
4. With the conveyor running, use a 5 mm hex-key wrench to rotate the tracking cam (**Figure 37, item 4**) in small increments until the belt tracks in the center of the conveyor. Then while holding the cam in position, re-tighten the head plate fastening screws (**Figure 37, item 2**) with a 4 mm hex-key wrench to 60 in-lb (7 Nm).



# Preventive Maintenance and Adjustment

## Pulley Removal

<b>⚠ WARNING</b>

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

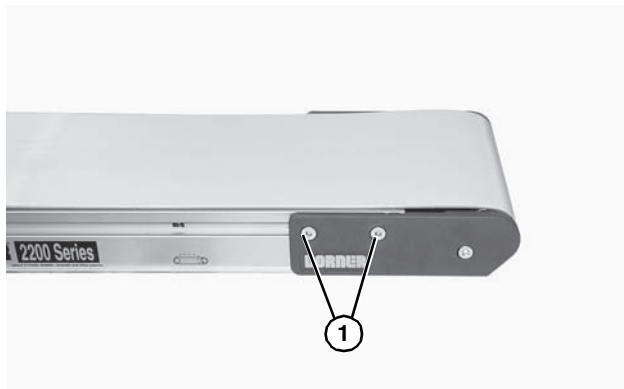
Leaving the conveyor belt in place, remove the desired pulley following the corresponding instructions below:

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

### A - Idler Pulley Removal

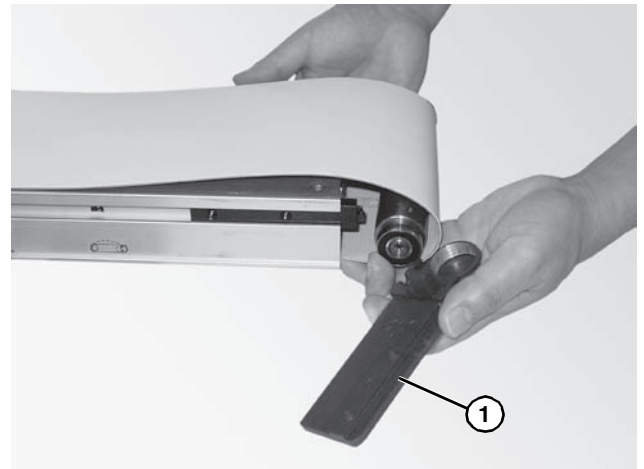
1. On one side of the conveyor, loosen two (2) head plate fastening screws (**Figure 38, item 1**) and remove them.

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



**Figure 38**

2. Remove the head plate (**Figure 39, item 1**) from the conveyor frame.



**Figure 39**

3. Pulley will slide out of opposite head plate and drop into slack of belt (**Figure 40**).



**Figure 40**

4. Slide spindle out of the belt loop.

# Preventive Maintenance and Adjustment

## B - Drive Pulley Removal

### ⚠ WARNING



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

1. On one side of the conveyor, loosen two (2) head plate fastening screws (Figure 41, item 1) and remove.

### NOTE

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

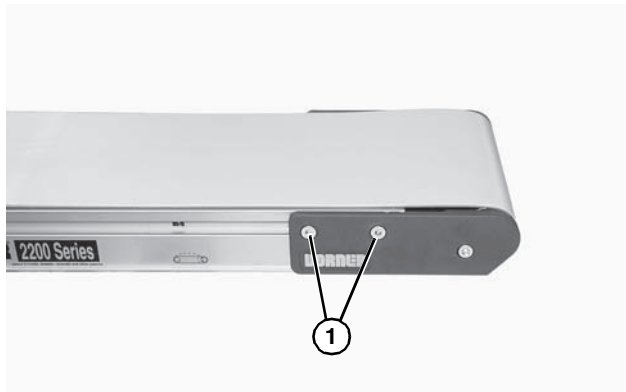


Figure 41

2. Remove the head plate (Figure 42, item 1) from the conveyor frame.

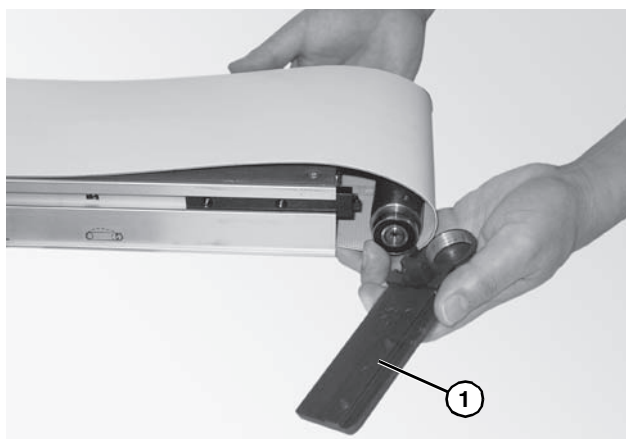


Figure 42

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

## Bearing Removal & Replacement

### Removal

### IMPORTANT

Do not use any removed bearings. Replace them.

1. Place bearing removal tool part #456063 (Figure 43, item 1) below bearing (Figure 43, item 2) with lip (Figure 43, item 3) located in gap (Figure 43, item 4) between bearing and spindle hub (Figure 43, item 5) as shown.

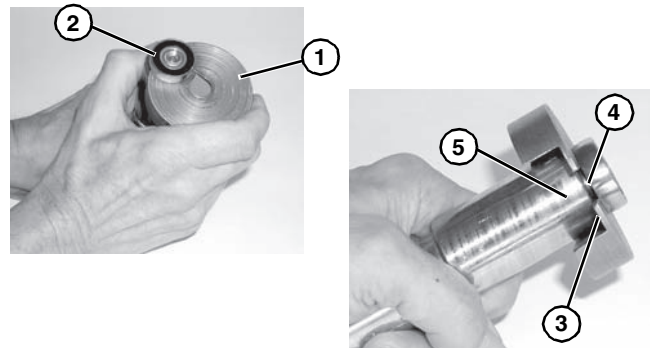


Figure 43

2. Using puller part #807-1716 (Figure 44, item 1), remove and discard bearing.

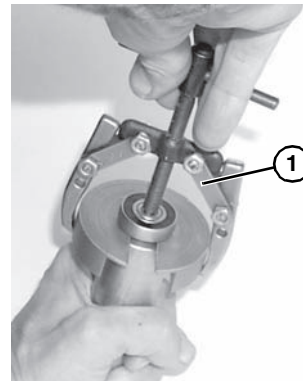
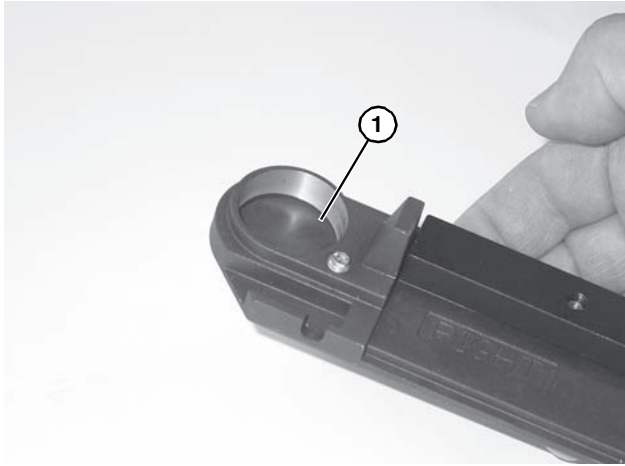


Figure 44

# Preventive Maintenance and Adjustment

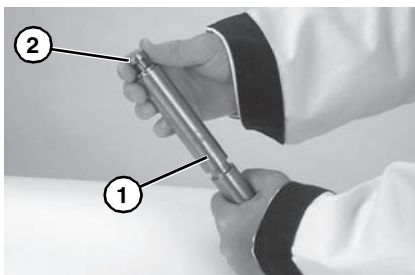
## Replacement

1. Inspect the head plates bearing seating surface (**Figure 45, item 1**). If they are worn or damaged, replace. See “Service Parts” on page 22.



**Figure 45**

2. Inspect spindle (**Figure 46, item 1**). Replace if worn.
3. Slide bearing (**Figure 46, item 2**) onto spindle.



**Figure 46**

4. Using an arbor press or similar device, press bearing onto pulley shaft (**Figure 47**).



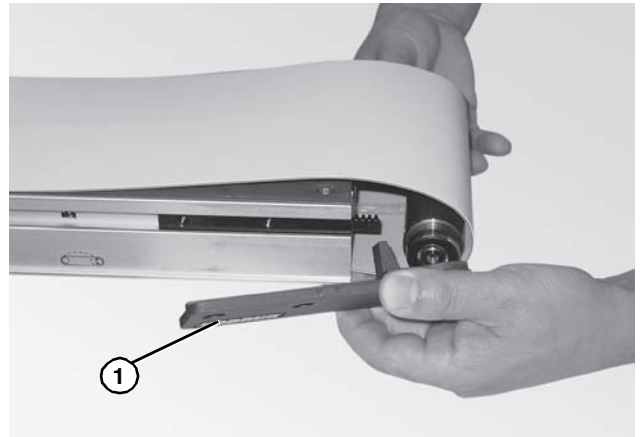
**Figure 47**

5. Repeat steps 1 through 4 for each bearing.

## Drive Pulley and Pulley Installation

### Drive Pulley Installation

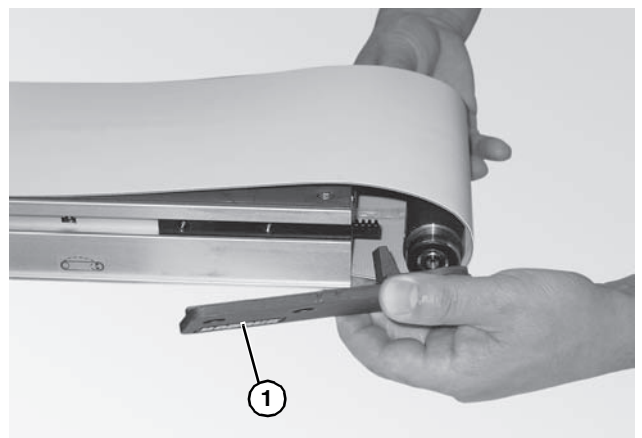
1. With opposite head plate installed, position the drive pulley through the loop of the belt, into the opposite head plate.
2. Place the head plate (**Figure 48, item 1**) and attach the head plate to the conveyor frame with the two (2) screws removed. Tighten screws 60 in-lb (7 Nm).



**Figure 48**

### Idler Pulley Installation

1. With opposite head plate installed, position the idler pulley through the loop of the belt, into the opposite head plate.
2. Place the head plate (**Figure 49, item 1**) and attach the head plate to the conveyor frame with the two (2) screws removed and hand tighten.



**Figure 49**

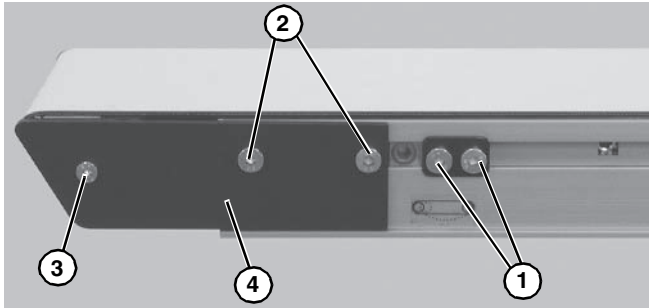
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# Preventive Maintenance and Adjustment

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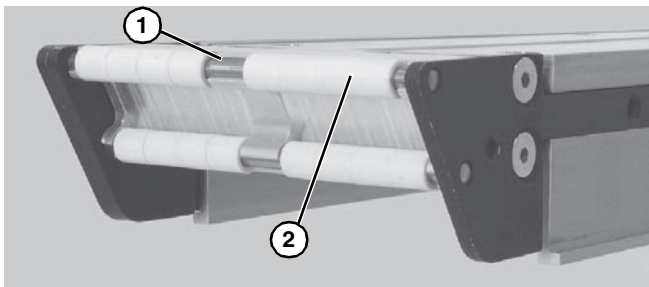
## Nose Bar Bearing Replacement

1. On both sides of conveyor, use a 4 mm hex-key wrench to loosen cam fastening screws (**Figure 50, item 1**) and slide cam assemblies toward the center of the conveyor.



**Figure 50**

2. On both sides of conveyor, use a 4 mm hex-key wrench to loosen head plate fastening screws (**Figure 50, item 2**) to remove belt tension. Then remove belt from end of conveyor.
3. On one side of conveyor, use a 3 mm and 4 mm hex-key wrench to remove head plate fastening screws (**Figure 50, item 3**) & (**Figure 50, item 2**) and remove head plate (**Figure 50, item 4**).
4. Slide bearing rods (**Figure 51, item 1**) out side of conveyor and replace bearings (**Figure 51, item 2**) as necessary.




**Figure 51**

5. After replacing bearings, re-install head plate (**Figure 50, item 4**). Use a 3 mm hex-key wrench to tighten one (1) fastening screw (**Figure 50, item 3**) to 30 in-lb (3.4 Nm). Leave two (2) fastening screws (**Figure 50, item 2**) loose for belt tensioning.
6. Re-install belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 15.
7. Re-position the cam assemblies against the head plates and adjust belt tracking. See “Conveyor Belt Tracking” on page 16.

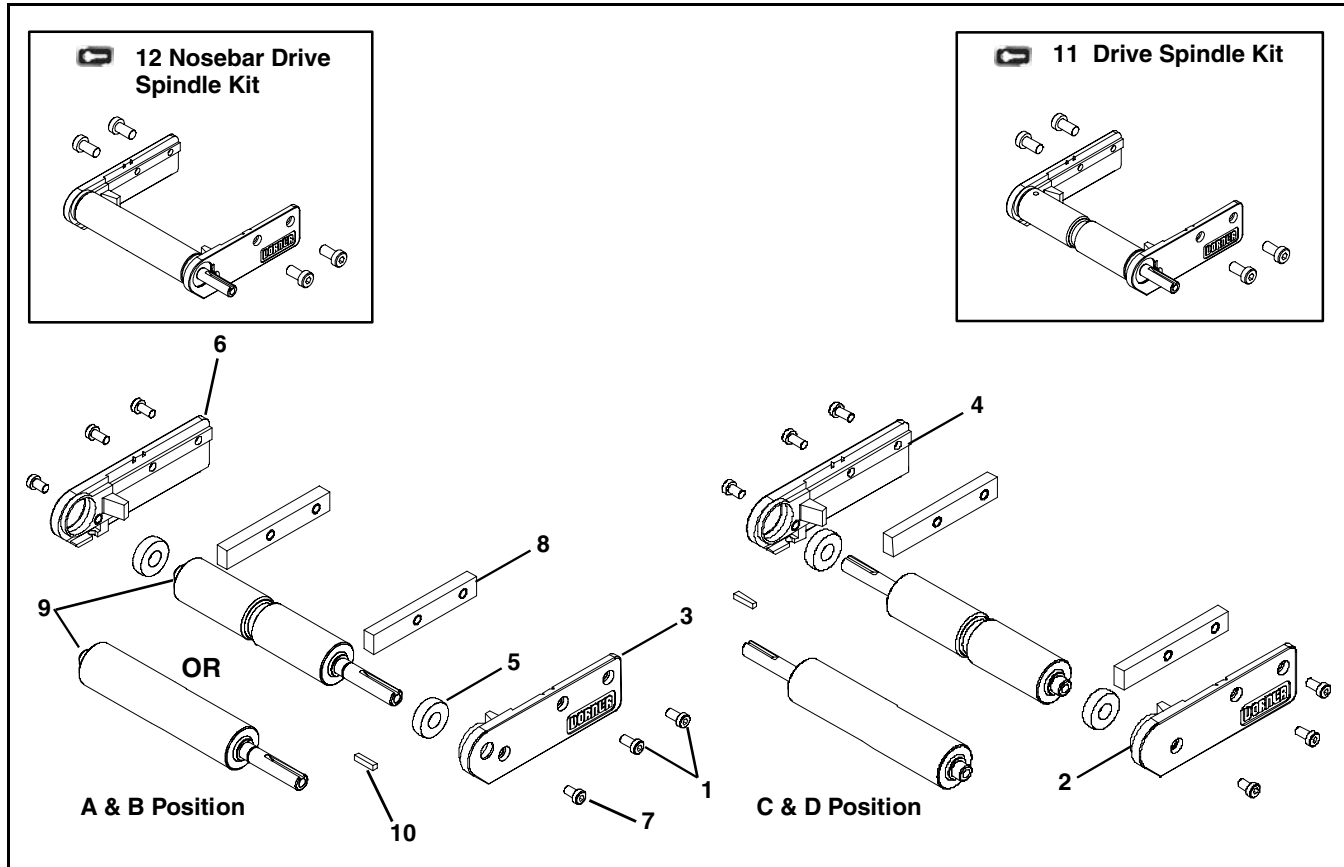


# Service Parts

## 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 Tail

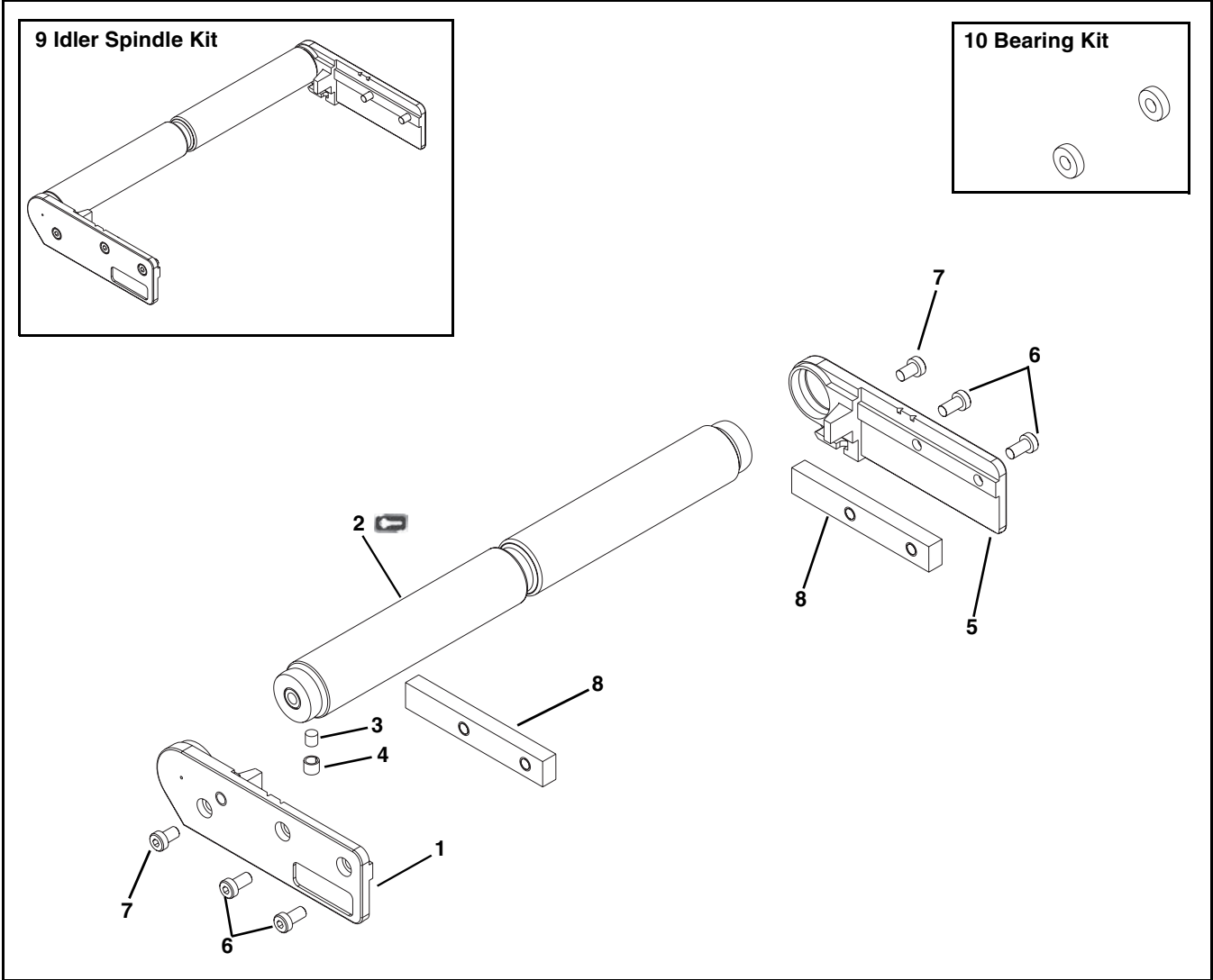


Item	Part Number	Description
1	920692M	Socket Head Screw, M6 x 12 mm
2	240425	Head Plate LH
3	240427	Head Plate LH Drive Side, Position A and B
4	240428	Head Plate RH Drive Side, Position C and D
5	22BK2	Bearing Kit (x2)
	22BK4	Bearing Kit (x4)
6	240426	Head Plate RH
7	920691M	Socket Head Screw, M6 x 10 mm
8	712016	Tension Slide Bar
9	4564WW	Drive Spindle
	2476WW	Nosebar Drive Spindle, Lagged
	7152WW	Dual Output Drive Spindle
10	980422MS	Square Key, 4 mm x 22 mm

Item	Part Number	Description
11	22A-WW	Drive Spindle Kit, Position A and B - Grooved (Includes Items 1, 3, 5, 6 and 9)
	22D-WW	Drive Spindle Kit, Position C and D - Grooved (Includes Items 1, 2, 4, 5, and 9)
12	22NA-WW	Nosebar Drive Spindle Kit, Position A and B - Lagged, Smooth (Includes Items 1, 3, 5, 6 and 9)
	22ND-WW	Nosebar Drive Spindle Kit, Position C and D - Lagged, Smooth (Includes Items 1, 2, 4, 5, and 9)

WW = Conveyor width reference: 02, 04, 06, 08, 12, 18 & 24

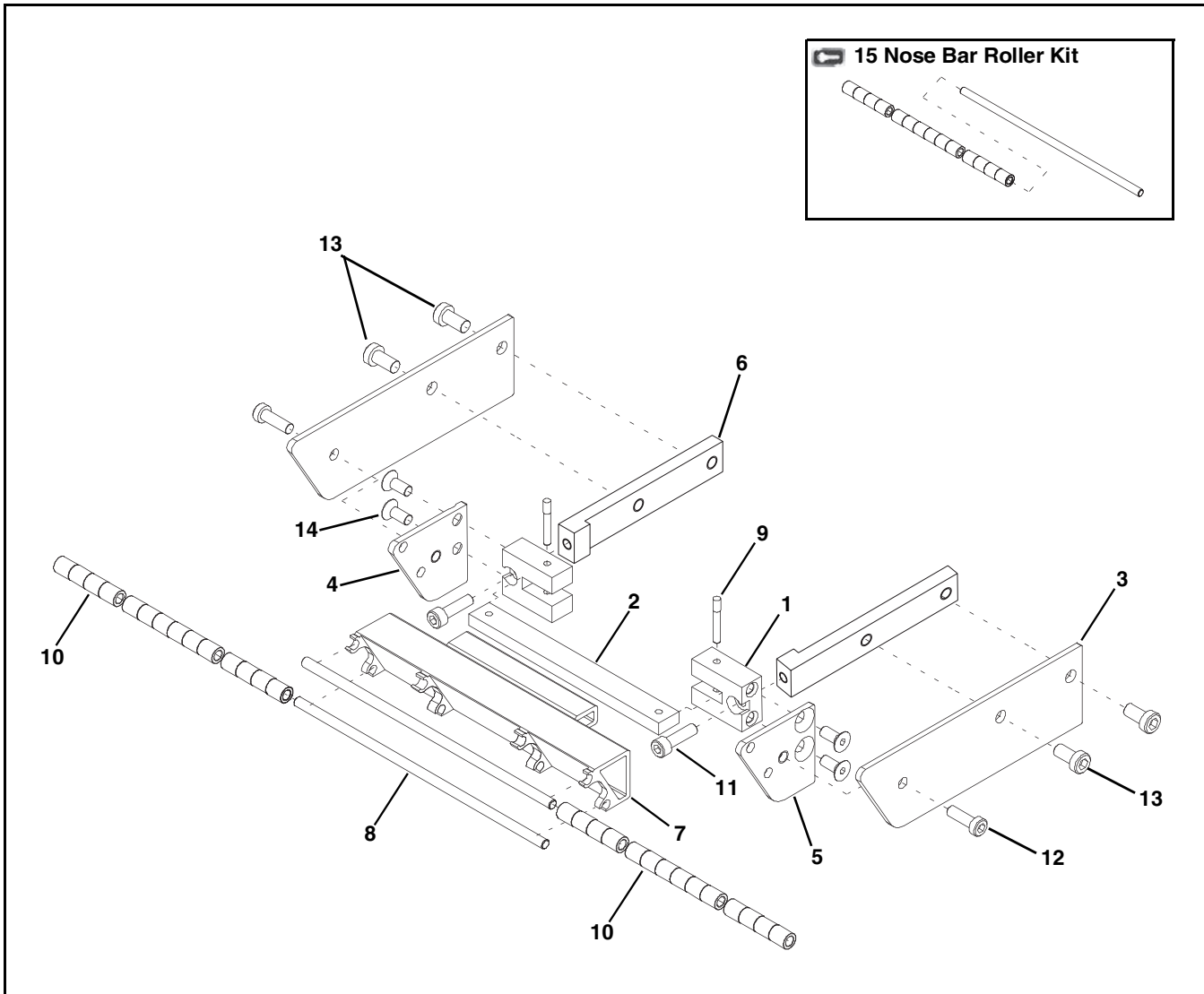
## Idler Tail



Item	Part Number	Description
1	240425	Head Plate, Left Hand
2	201273- <u>WW</u>	Spindle Kit with Bearings
3	808-020	Magnet, 0.25" diameter x 0.25" long
4	450226SSP	Sleeve
5	240426	Head Plate, Right Hand
6	920692M	Socket Head Screw, M6 x 12 mm
7	920691M	Socket Head Screw, M6 x 10 mm
8	712016	Tension Slide Bar
9	22T- <u>WW</u>	Idler Spindle Kit, (Includes Items 1 through 7)
10	22BK2	Bearing Kit (2 pack)
	22BK4	Bearing Kit (4 pack)
<u>WW</u> = Conveyor width reference: 02, 04, 06, 08, 12, 18 & 24		

# Service Parts

## Nose Bar Idler End



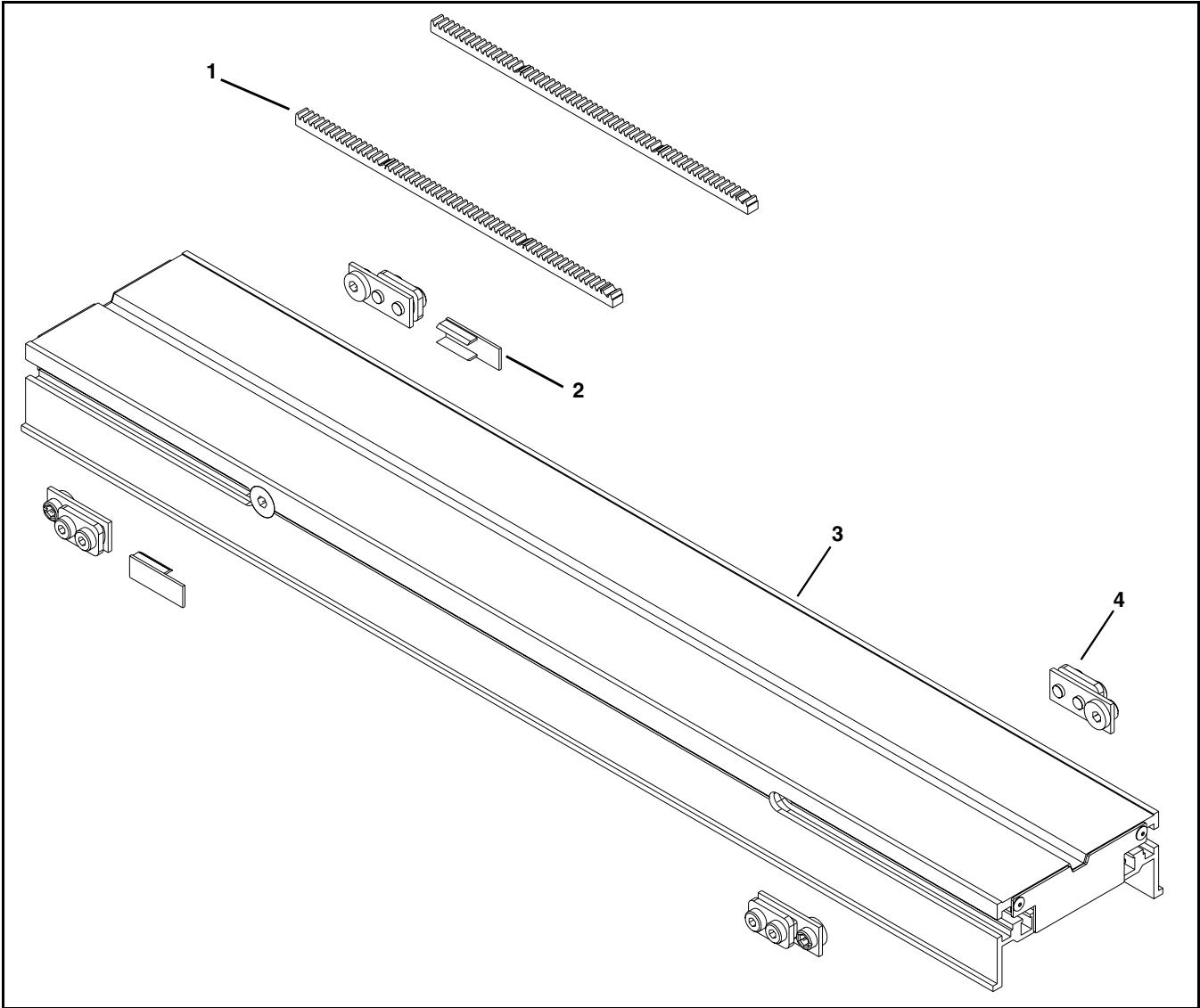
Item	Part Number	Description
1	201965	Mounting Block, PLT Spindle
	200659	Mounting Block, for 2" (51mm) wide conveyor
2	2076WW	Flex-Link Bar,
	201472	Flex-Link Bar, for 2" (51mm) wide conveyor
3	241 125	Outer Side Plate
4	241 126	Inner Side Plate, LH
5	241 127	Inner Side Plate, RH
6	712052	Head Plate Bar

Item	Part Number	Description
7	2412WW	Nosebar
8	2413WW	Nosebar Rod
9	200695P	Knurl Pin, 0.125" DIA x 0.937" Lg
10	801 -122	Nose Bar Roller
11	920516M	Socket Head Screw, M5 x 16 mm
12	920593M	Low Head Socket Head Screw, M5 x 16 mm
13	920692M	Socket Head Screw, M6 x 12 mm
14	930512M	Flat Head Screw, M5 x 12 mm
15	22N-WW	Nosebar Roller Kit (Includes Items 8 and 10)

WW = Conveyor width reference: 02, 04, 06, 08, 12, 18 & 24



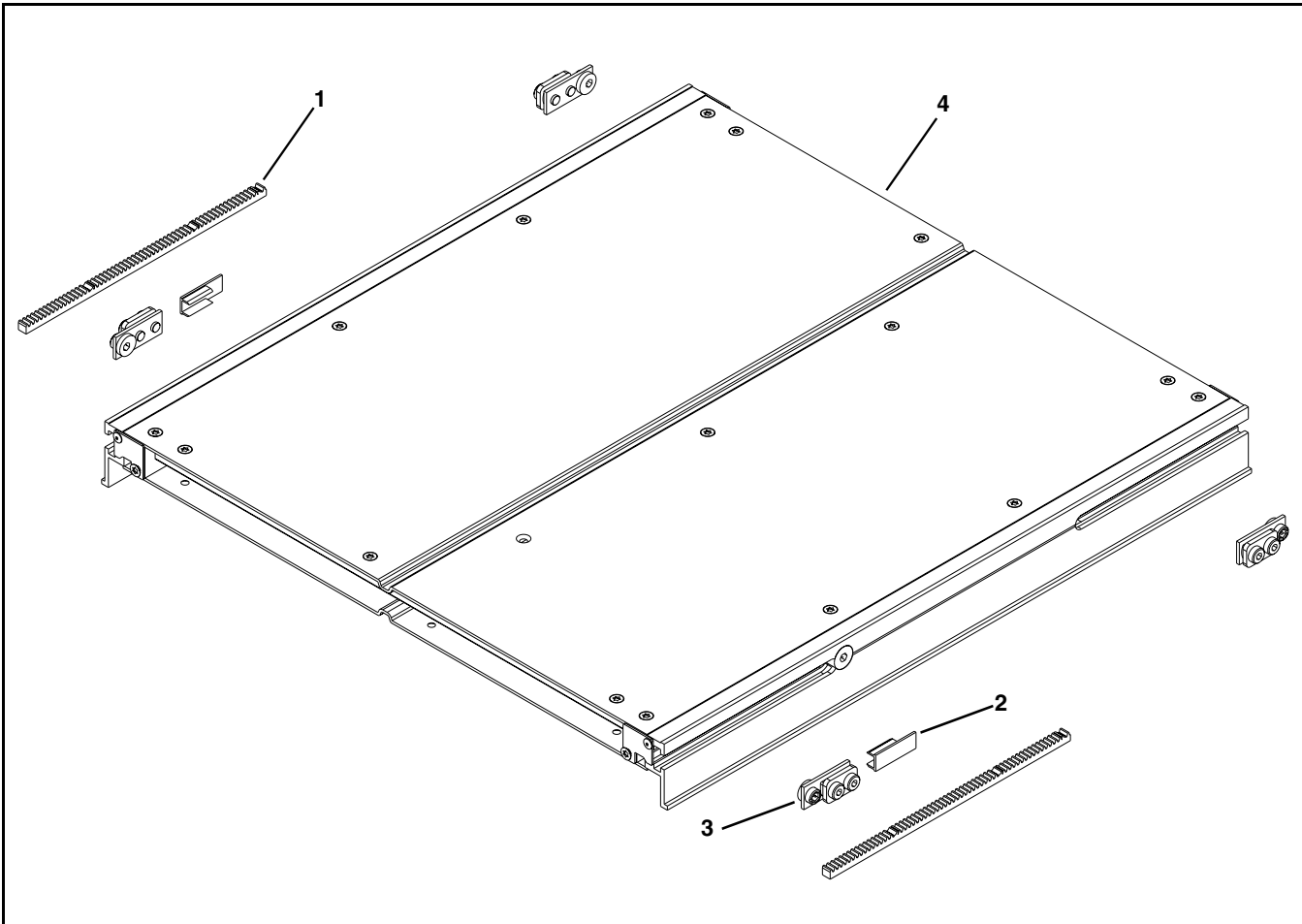
**2" (51mm) and 12" (305mm) Wide Frame Assembly**



Item	Part Number	Description
1	240420	Rack Gear, 14.5° PA x 24P
2	712024	T-Slot Cover
3	Consult Factory	Frame Assembly
4	712029	Cam Mounting Assembly for Conveyors with Tracking Cams

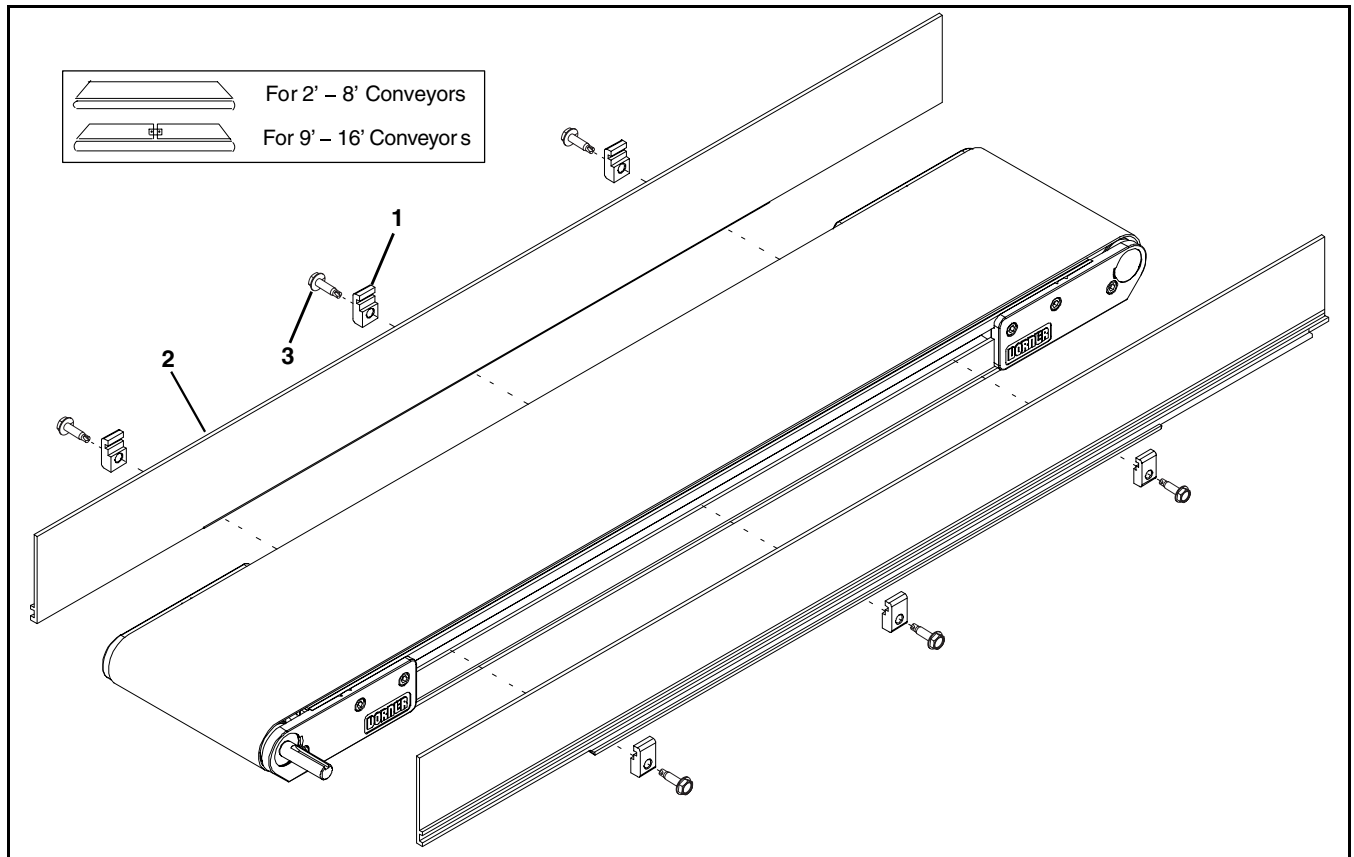
# Service Parts

## 18" (457mm) and 24" (610mm) Wide Frame Assembly



Item	Part Number	Description
1	240420	Rack Gear 14.5° PA x 24P
2	712024	T-Slot Cover
3	712029	Cam Mounting Assembly for Conveyors with Tracking Cams
4	Consult Factory	Frame Assembly

## -04 3" (76 mm) Aluminum Side



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2300 Guide 3" (76mm) HS
3	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

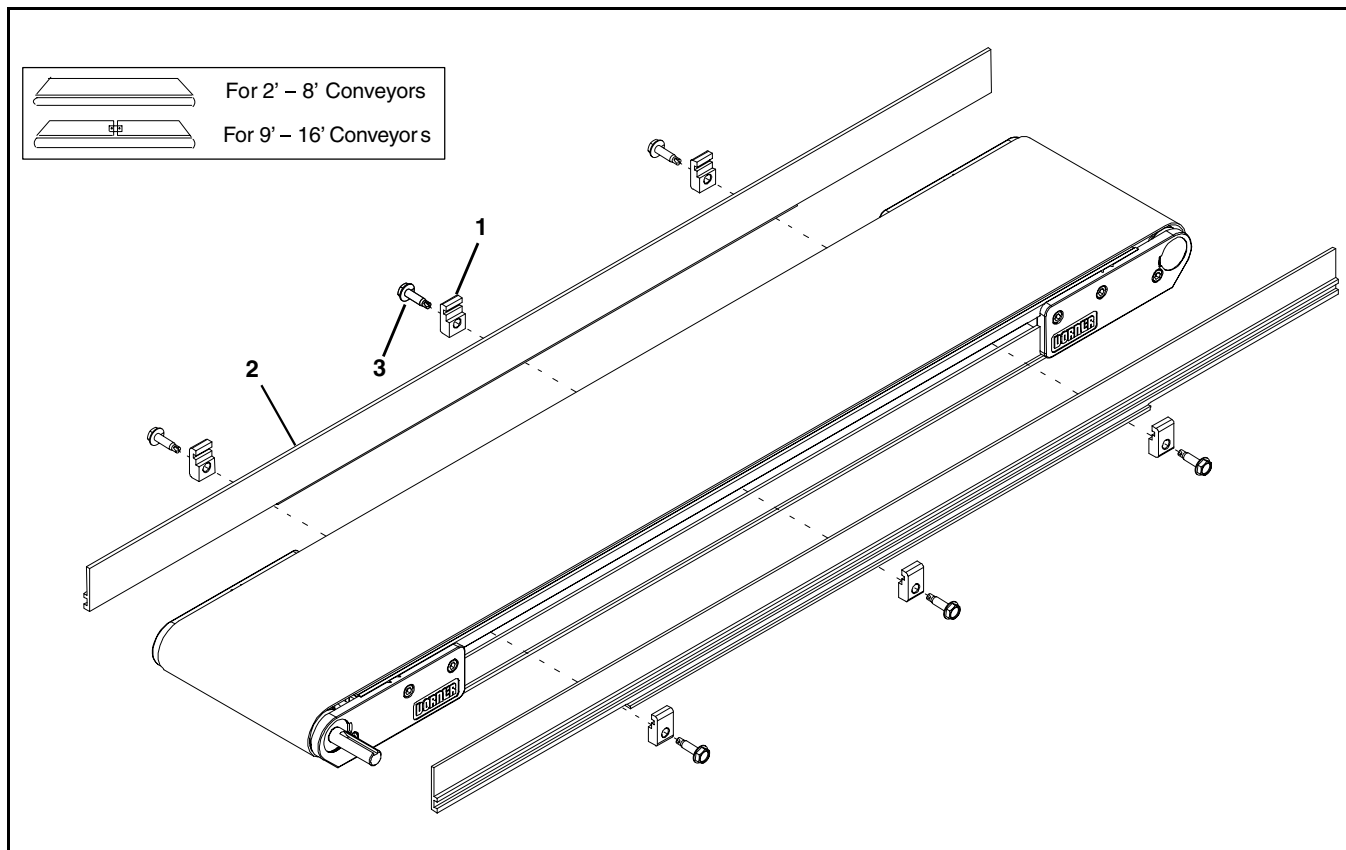
Item 2: 2300 Guide 3" (76mm) HS		
Length		End Guide
2' (610mm)	Left Hand	280403-02400
	Right Hand	280403-02400
3' (914mm)	Left Hand	280403-03600
	Right Hand	280403-03600
4' (1219mm)	Left Hand	280403-04800
	Right Hand	280403-04800
5' (1524mm)	Left Hand	280403-06000
	Right Hand	280403-06000
6' (1829mm)	Left Hand	280403-07200
	Right Hand	280403-07200
7' (2134mm)	Left Hand	280403-08400
	Right Hand	280403-08400
8' (2438mm)	Left Hand	280403-09600
	Right Hand	280403-09600
9' (2743mm)	Left Hand	280401-05400 (x2)
	Right Hand	280402-05400 (x2)
10' (3048mm)	Left Hand	280401-06000 (x2)
	Right Hand	280402-06000 (x2)

Item 2: 2300 Guide 3" (76mm) HS		
Length		End Guide
11' (3353mm)	Left Hand	280401-06600 (x2)
	Right Hand	280402-06600 (x2)
12' (3658mm)	Left Hand	280401-07200 (x2)
	Right Hand	280402-07200 (x2)
13' (3962mm)	Left Hand	280401-07800 (x2)
	Right Hand	280402-07800 (x2)
14' (4267mm)	Left Hand	280401-08400 (x2)
	Right Hand	280402-08400 (x2)
15' (4572mm)	Left Hand	280401-09000 (x2)
	Right Hand	280402-09000 (x2)
16' (4877mm)	Left Hand	280401-09600 (x2)
	Right Hand	280402-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

# Service Parts

## -05 1.5" (38mm) Aluminum Side



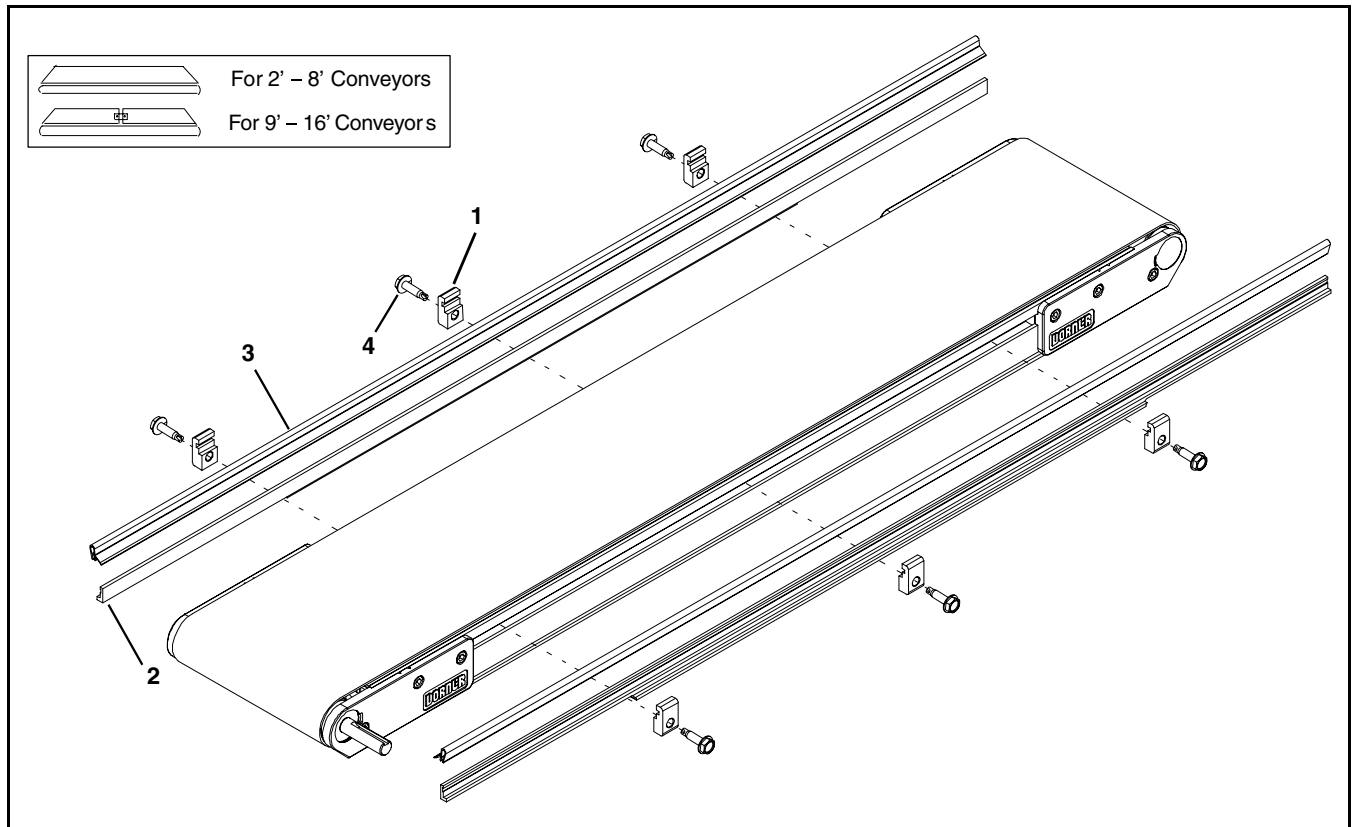
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2300 Guide 3" (76mm) HS
3	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
2' (610mm)	Left Hand	280503-02400
	Right Hand	280503-02400
3' (914mm)	Left Hand	280503-03600
	Right Hand	280503-03600
4' (1219mm)	Left Hand	280503-04800
	Right Hand	280503-04800
5' (1524mm)	Left Hand	280503-06000
	Right Hand	280503-06000
6' (1829mm)	Left Hand	280503-07200
	Right Hand	280503-07200
7' (2134mm)	Left Hand	280503-08400
	Right Hand	280503-08400
8' (2438mm)	Left Hand	280503-09600
	Right Hand	280503-09600
9' (2743mm)	Left Hand	280501-05400 (x2)
	Right Hand	280502-05400 (x2)
10' (3048mm)	Left Hand	280501-06000 (x2)
	Right Hand	280502-06000 (x2)
11' (3353mm)	Left Hand	280501-06600 (x2)
	Right Hand	280502-06600 (x2)

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
12' (3658mm)	Left Hand	280501-07200 (x2)
	Right Hand	280502-07200 (x2)
13' (3962mm)	Left Hand	280501-07800 (x2)
	Right Hand	280502-07800 (x2)
14' (4267mm)	Left Hand	280501-08400 (x2)
	Right Hand	280502-08400 (x2)
15' (4572mm)	Left Hand	280501-09000 (x2)
	Right Hand	280502-09000 (x2)
16' (4877mm)	Left Hand	280501-09600 (x2)
	Right Hand	280502-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

## -07 Low to Side Wiper



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2300 Guide 3" (76mm) HS
3	41-00-24	Side Wiper Nylatron (per foot)
4	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

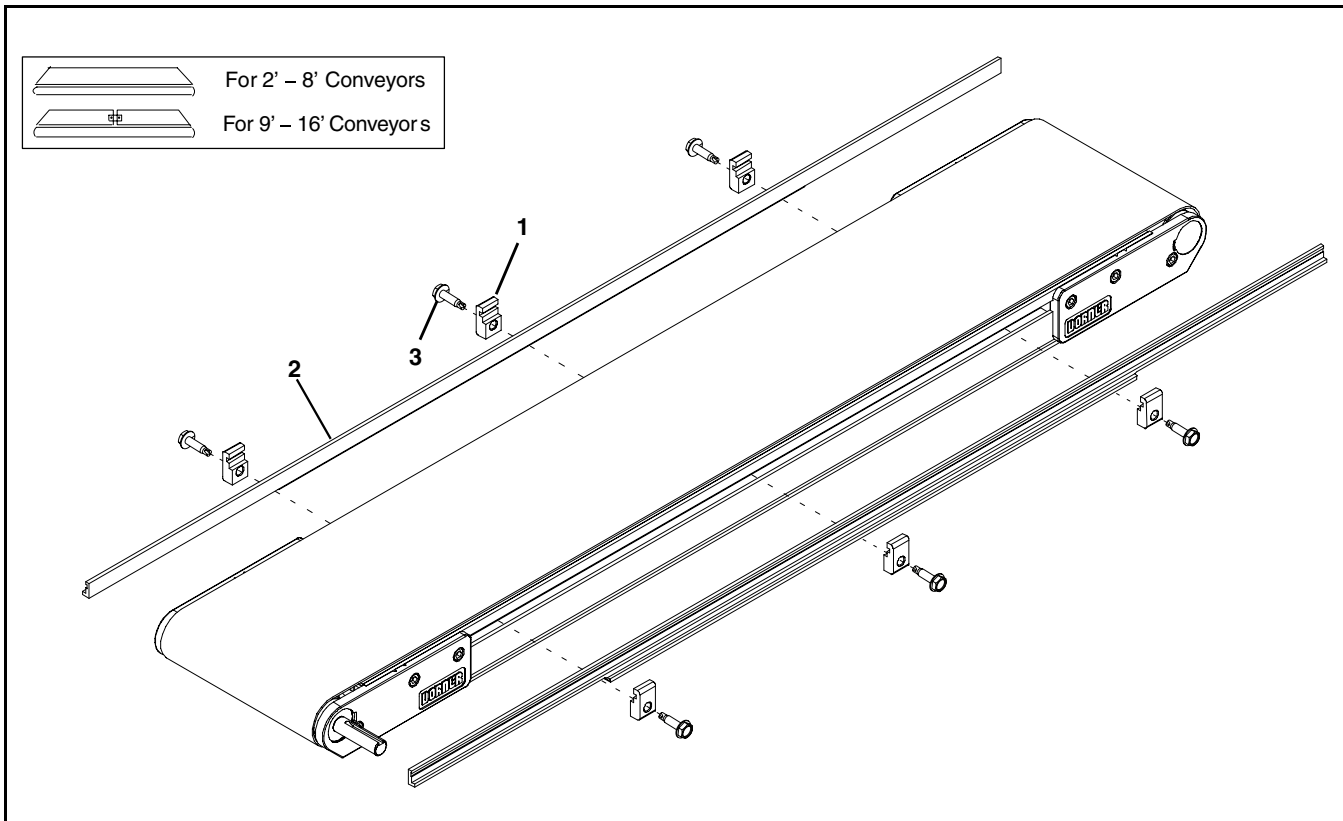
Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
2' (610mm)	Left Hand	280903-02400
	Right Hand	280903-02400
3' (914mm)	Left Hand	280903-03600
	Right Hand	280903-03600
4' (1219mm)	Left Hand	280903-04800
	Right Hand	280903-04800
5' (1524mm)	Left Hand	280903-06000
	Right Hand	280903-06000
6' (1829mm)	Left Hand	280903-07200
	Right Hand	280903-07200
7' (2134mm)	Left Hand	280903-08400
	Right Hand	280903-08400
8' (2438mm)	Left Hand	280903-09600
	Right Hand	280903-09600
9' (2743mm)	Left Hand	280901-05400 (x2)
	Right Hand	280902-05400 (x2)
10' (3048mm)	Left Hand	280901-06000 (x2)
	Right Hand	280902-06000 (x2)
11' (3353mm)	Left Hand	280901-06600 (x2)
	Right Hand	280902-06600 (x2)

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
12' (3658mm)	Left Hand	280901-07200 (x2)
	Right Hand	280902-07200 (x2)
13' (3962mm)	Left Hand	280901-07800 (x2)
	Right Hand	280902-07800 (x2)
14' (4267mm)	Left Hand	280901-08400 (x2)
	Right Hand	280902-08400 (x2)
15' (4572mm)	Left Hand	280901-09000 (x2)
	Right Hand	280902-09000 (x2)
16' (4877mm)	Left Hand	280901-09600 (x2)
	Right Hand	280902-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

# Service Parts

## -09 Low to High Side



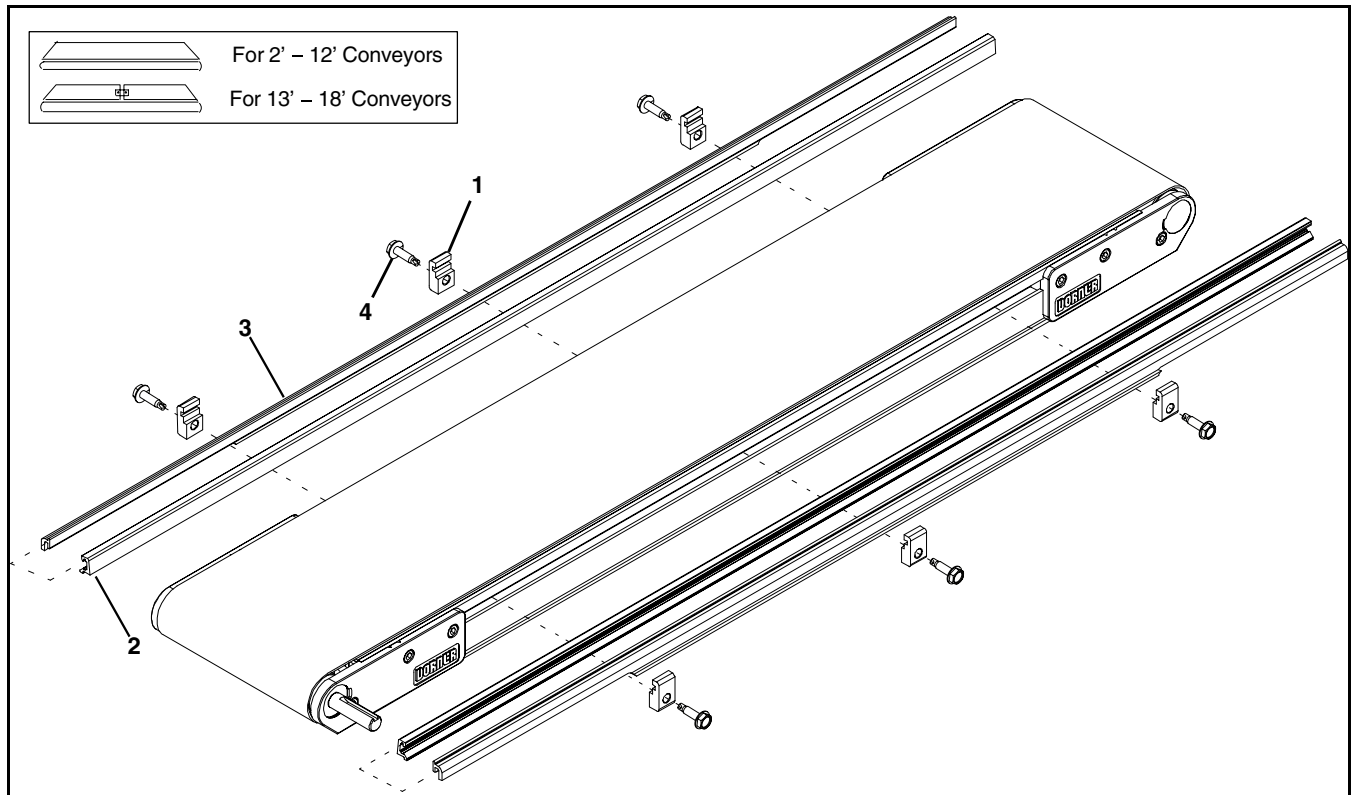
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2300 Guide 3" (76mm) HS
3	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
2' (610mm)	Left Hand	280903-02400
	Right Hand	280903-02400
3' (914mm)	Left Hand	280903-03600
	Right Hand	280903-03600
4' (1219mm)	Left Hand	280903-04800
	Right Hand	280903-04800
5' (1524mm)	Left Hand	280903-06000
	Right Hand	280903-06000
6' (1829mm)	Left Hand	280903-07200
	Right Hand	280903-07200
7' (2134mm)	Left Hand	280903-08400
	Right Hand	280903-08400
8' (2438mm)	Left Hand	280903-09600
	Right Hand	280903-09600
9' (2743mm)	Left Hand	280901-05400 (x2)
	Right Hand	280902-05400 (x2)
10' (3048mm)	Left Hand	280901-06000 (x2)
	Right Hand	280902-06000 (x2)
11' (3353mm)	Left Hand	280901-06600 (x2)
	Right Hand	280902-06600 (x2)

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
12' (3658mm)	Left Hand	280901-07200 (x2)
	Right Hand	280902-07200 (x2)
13' (3962mm)	Left Hand	280901-07800 (x2)
	Right Hand	280902-07800 (x2)
14' (4267mm)	Left Hand	280901-08400 (x2)
	Right Hand	280902-08400 (x2)
15' (4572mm)	Left Hand	280901-09000 (x2)
	Right Hand	280902-09000 (x2)
16' (4877mm)	Left Hand	280901-09600 (x2)
	Right Hand	280902-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

## -10.5" (13mm) Extruded Plastic



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	200054P	Snap-On Guide (per foot)
3	See Chart Below	2300 Guide
4	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

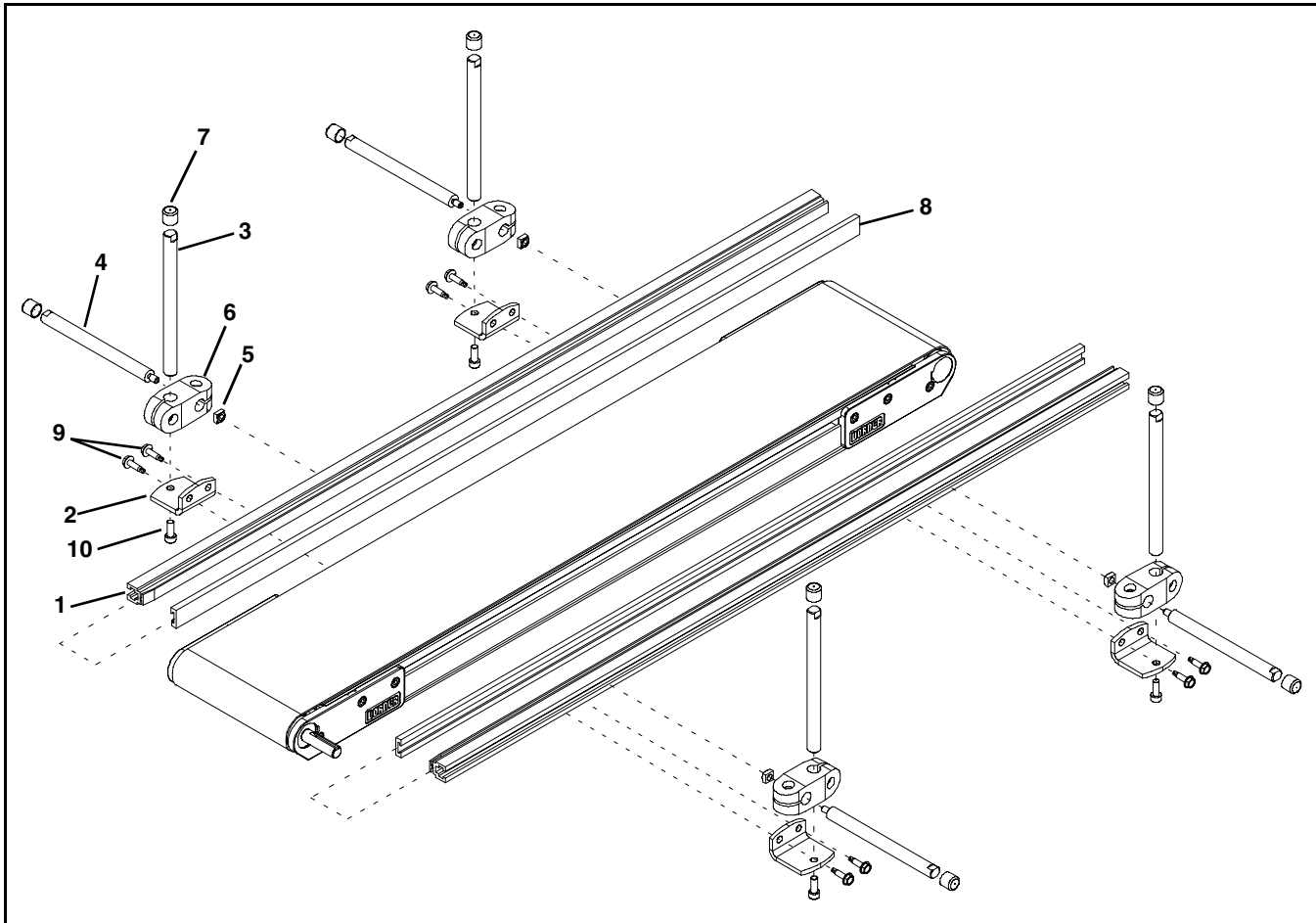
Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
2' (610mm)	Left Hand	281003-02400
	Right Hand	281003-02400
3' (914mm)	Left Hand	281003-03600
	Right Hand	281003-03600
4' (1219mm)	Left Hand	281003-04800
	Right Hand	281003-04800
5' (1524mm)	Left Hand	281003-06000
	Right Hand	281003-06000
6' (1829mm)	Left Hand	281003-07200
	Right Hand	281003-07200
7' (2134mm)	Left Hand	281003-08400
	Right Hand	281003-08400
8' (2438mm)	Left Hand	281003-09600
	Right Hand	281003-09600
9' (2743mm)	Left Hand	281001-05400 (x2)
	Right Hand	281002-05400 (x2)
10' (3048mm)	Left Hand	281001-06000 (x2)
	Right Hand	281002-06000 (x2)
11' (3353mm)	Left Hand	281001-06600 (x2)
	Right Hand	281002-06600 (x2)

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
12' (3658mm)	Left Hand	281001-07200 (x2)
	Right Hand	281002-07200 (x2)
13' (3962mm)	Left Hand	281001-07800 (x2)
	Right Hand	281002-07800 (x2)
14' (4267mm)	Left Hand	281001-08400 (x2)
	Right Hand	281002-08400 (x2)
15' (4572mm)	Left Hand	281001-09000 (x2)
	Right Hand	281002-09000 (x2)
16' (4877mm)	Left Hand	281001-09600 (x2)
	Right Hand	281002-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

# Service Parts

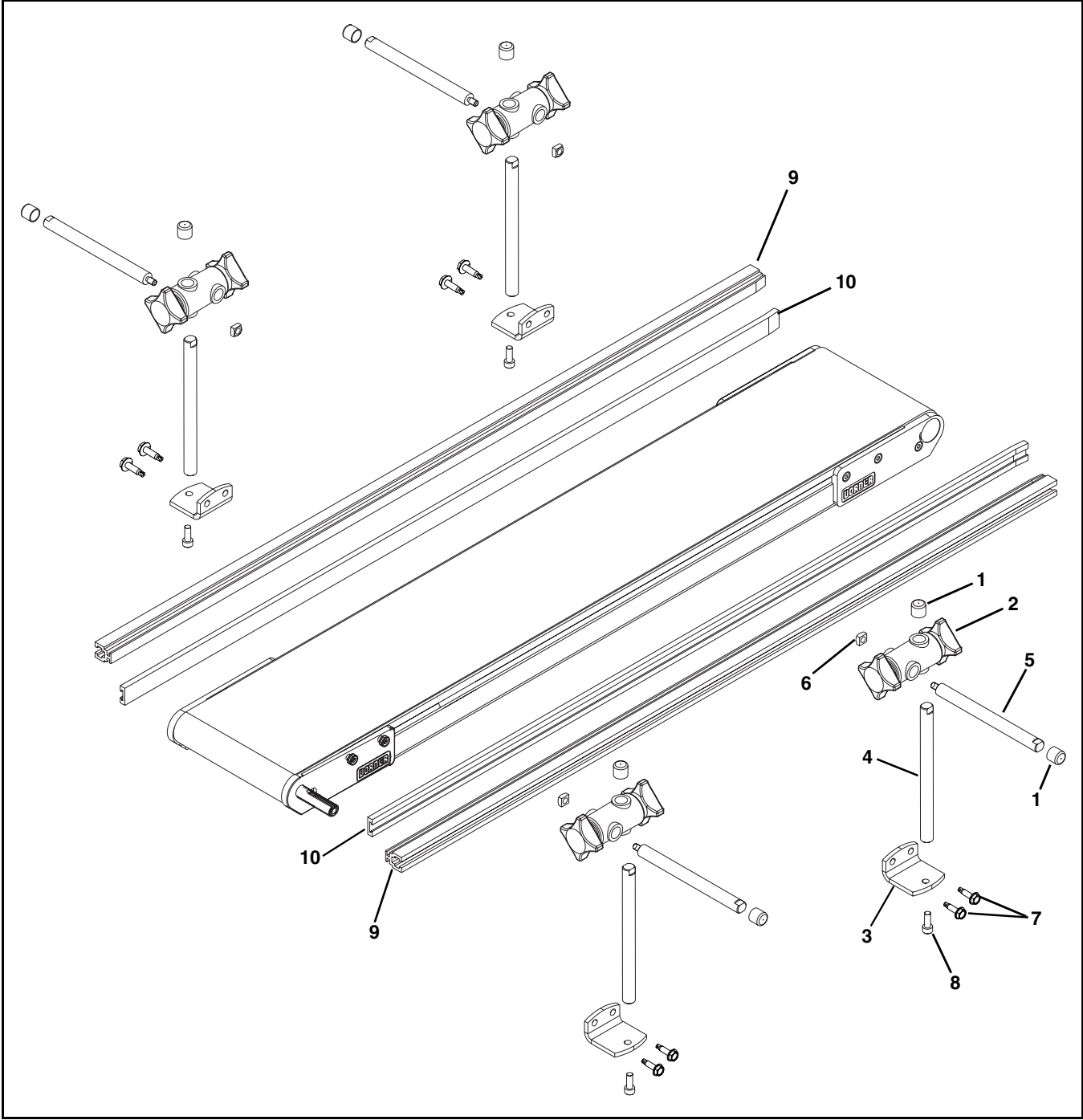
## -13 Adjustable Guiding



Item	Part Number	Description
1	202983	Aluminum Profile Guide 2' (610mm)
	202984	Aluminum Profile Guide 3' (914mm)
	202985	Aluminum Profile Guide 4' (1219mm)
	202986	Aluminum Profile Guide 5' (1524mm)
	202987	Aluminum Profile Guide 6' (1829mm)
	202988	Aluminum Profile Guide 7' (2134mm)
	202989	Aluminum Profile Guide 8' (2438mm)
	202990	Aluminum Profile Guide 9' (2743mm)
	202991	Aluminum Profile Guide 10' (3048mm)
	202992	Aluminum Profile Guide 11' (3353mm)
	202993	Aluminum Profile Guide 12' (3658mm)
	202994	Aluminum Profile Guide 13' (3962mm)
	2	202004
3	202027M	Guide Mounting Shaft Vertical
4	202028M	Guide Mounting Shaft Horizontal
5	674175MP	Square Nut
6	807-652	Cross Block
7	807-948	Vinyl Shaft Cap
8	614068P	Flat Extruded Guide (per foot)
9	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"
10	920616M	Socket Head Screw M6 x 16mm



## -14 Tool-Less Adjustable Guiding

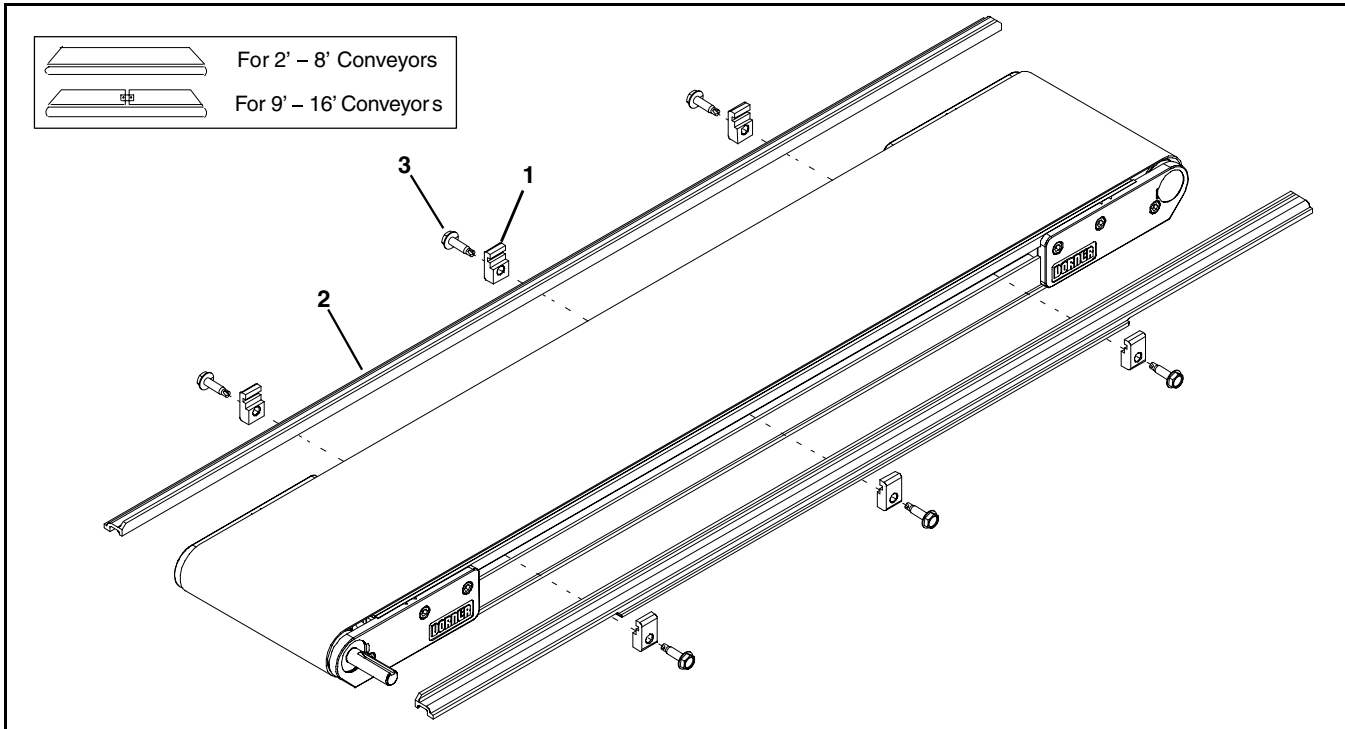


Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	202004M	Mounting Bracket
4	202027M	Vertical Mounting Guide Shaft
5	202028M	Horizontal Mounting Guide Shaft
6	674175MP	Square Nut, M6-1.00

Item	Part Number	Description
7	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"
8	920616M	Socket Head Screw, M6-1.00 x 16 mm
9	460063-LLLLL	Aluminum Profile Guide
10	614068P-LLLLL	Extruded Guide
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

## 0.5" (13mm) Cleated Belt Guiding



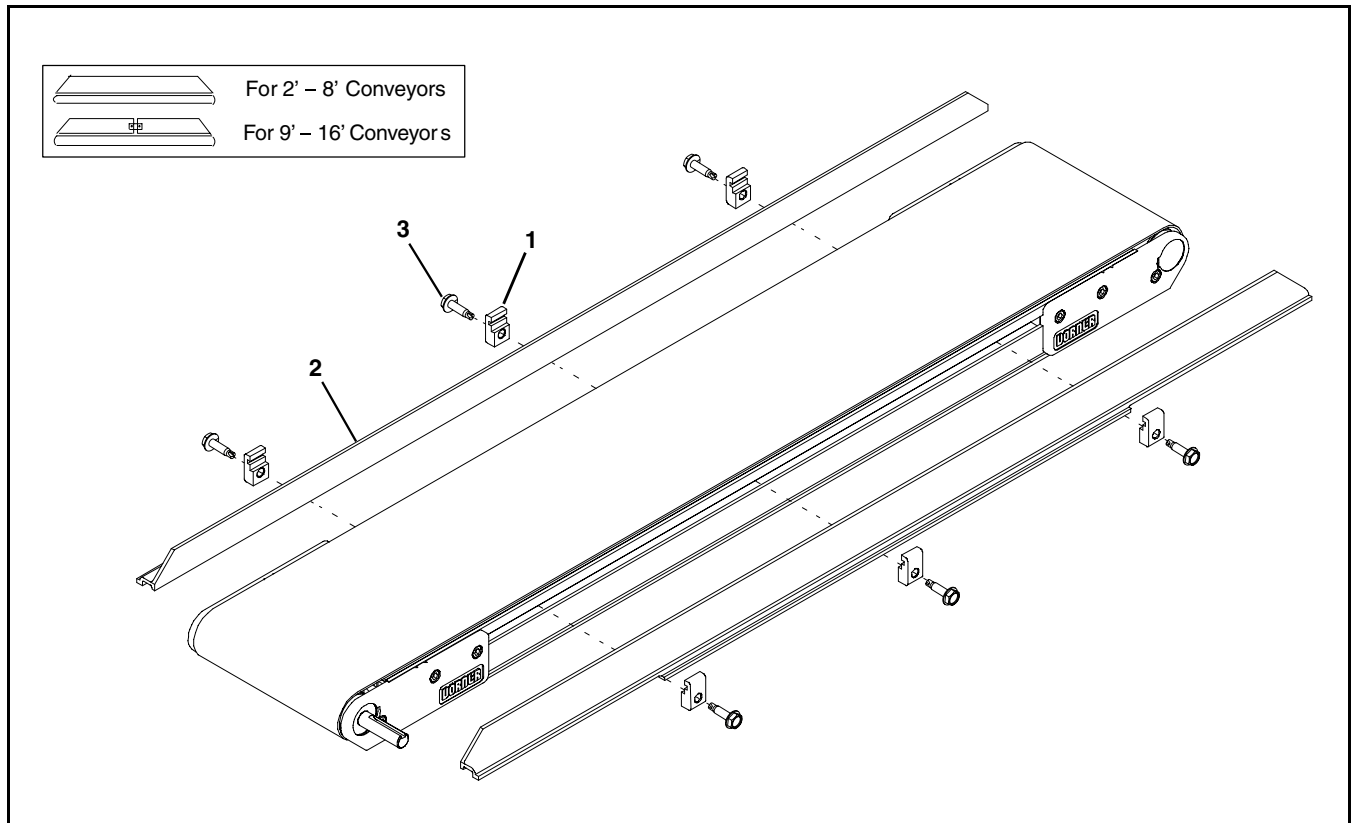
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2300 Guide, 0.47" (13mm) Cleated
3	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
2' (610mm)	Left Hand	281603-02256
	Right Hand	281603-02256
3' (914mm)	Left Hand	281603-03456
	Right Hand	281603-03456
4' (1219mm)	Left Hand	281603-04656
	Right Hand	281603-04656
5' (1524mm)	Left Hand	281603-05856
	Right Hand	281603-05856
6' (1829mm)	Left Hand	281603-07056
	Right Hand	281603-07056
7' (2134mm)	Left Hand	281603-08256
	Right Hand	281603-08256
8' (2438mm)	Left Hand	281603-09456
	Right Hand	281603-09456
9' (2743mm)	Left Hand	281601-05400 (x2)
	Right Hand	281602-05400 (x2)
10' (3048mm)	Left Hand	281601-06000 (x2)
	Right Hand	281602-06000 (x2)
11' (3353mm)	Left Hand	281601-06600 (x2)
	Right Hand	281602-06600 (x2)
12' (3658mm)	Left Hand	281601-07200 (x2)
	Right Hand	281602-07200 (x2)

Item 2: 2300 Guide 0.5" (13mm) HS		
Length		End Guide
13' (3962mm)	Left Hand	281601-07800 (x2)
	Right Hand	281602-07800 (x2)
14' (4267mm)	Left Hand	281601-08400 (x2)
	Right Hand	281602-08400 (x2)
15' (4572mm)	Left Hand	281601-09000 (x2)
	Right Hand	281602-09000 (x2)
16' (4877mm)	Left Hand	281601-09600 (x2)
	Right Hand	281602-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

## 1" (25mm) Cleated Belt Guiding



Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2300 Guide 1" (25mm) Cleated
3	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

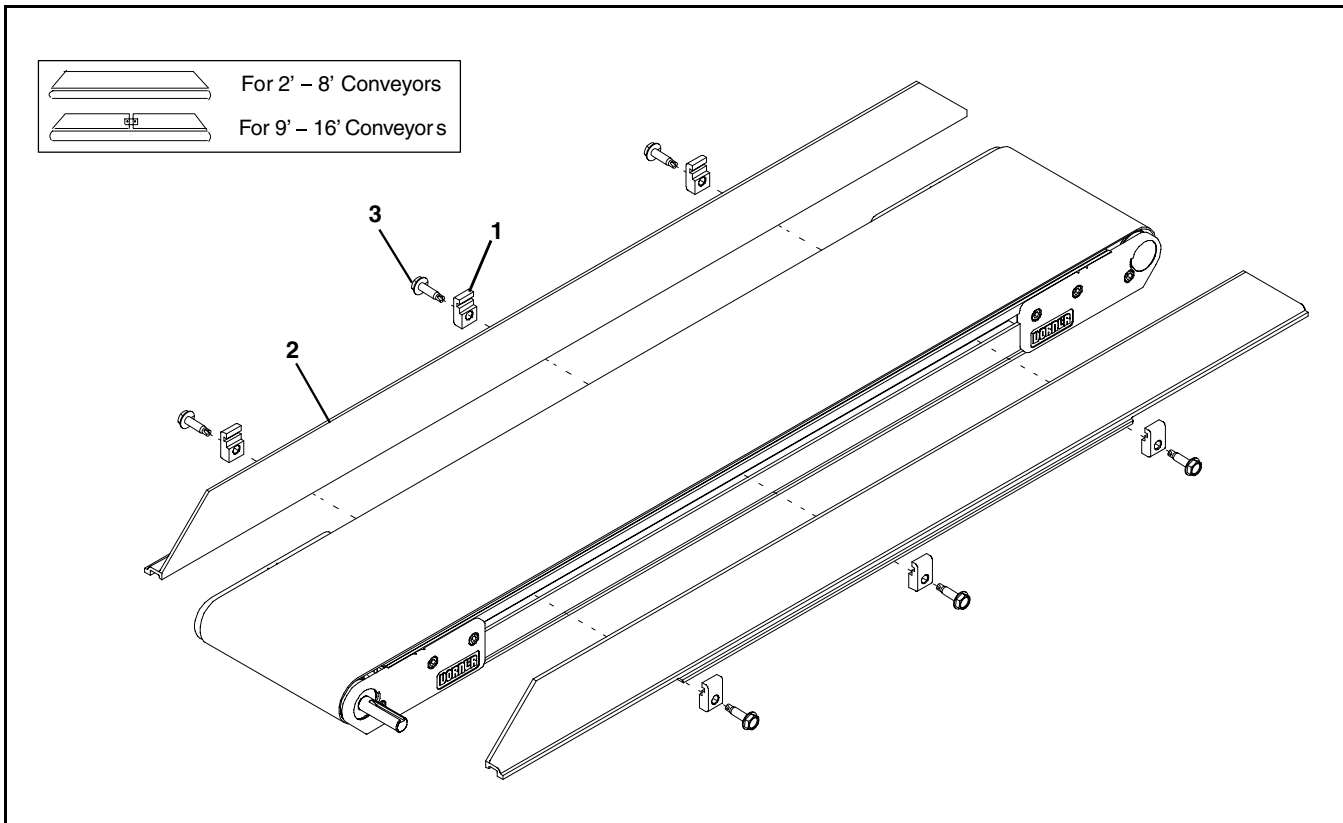
Item 2: 2300 Guide		
Length		End Guide
2' (610mm)	Left Hand	281703-02256
	Right Hand	281703-02256
3' (914mm)	Left Hand	281703-03456
	Right Hand	281703-03456
4' (1219mm)	Left Hand	281703-04656
	Right Hand	281703-04656
5' (1524mm)	Left Hand	281703-05856
	Right Hand	281703-05856
6' (1829mm)	Left Hand	281703-07056
	Right Hand	281703-07056
7' (2134mm)	Left Hand	281703-08256
	Right Hand	281703-08256
8' (2438mm)	Left Hand	281703-09456
	Right Hand	281703-09456
9' (2743mm)	Left Hand	281701-05400 (x2)
	Right Hand	281702-05400 (x2)
10' (3048mm)	Left Hand	281701-06000 (x2)
	Right Hand	281702-06000 (x2)
11' (3353mm)	Left Hand	281701-06600 (x2)
	Right Hand	281702-06600 (x2)

Item 2: 2300 Guide		
Length		End Guide
12' (3658mm)	Left Hand	281701-07200 (x2)
	Right Hand	281702-07200 (x2)
13' (3962mm)	Left Hand	281701-07800 (x2)
	Right Hand	281702-07800 (x2)
14' (4267mm)	Left Hand	281701-08400 (x2)
	Right Hand	281702-08400 (x2)
15' (4572mm)	Left Hand	281701-09000 (x2)
	Right Hand	281702-09000 (x2)
16' (4877mm)	Left Hand	281701-09600 (x2)
	Right Hand	281702-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

# Service Parts

## 2" (51mm) Cleated Belt Guiding



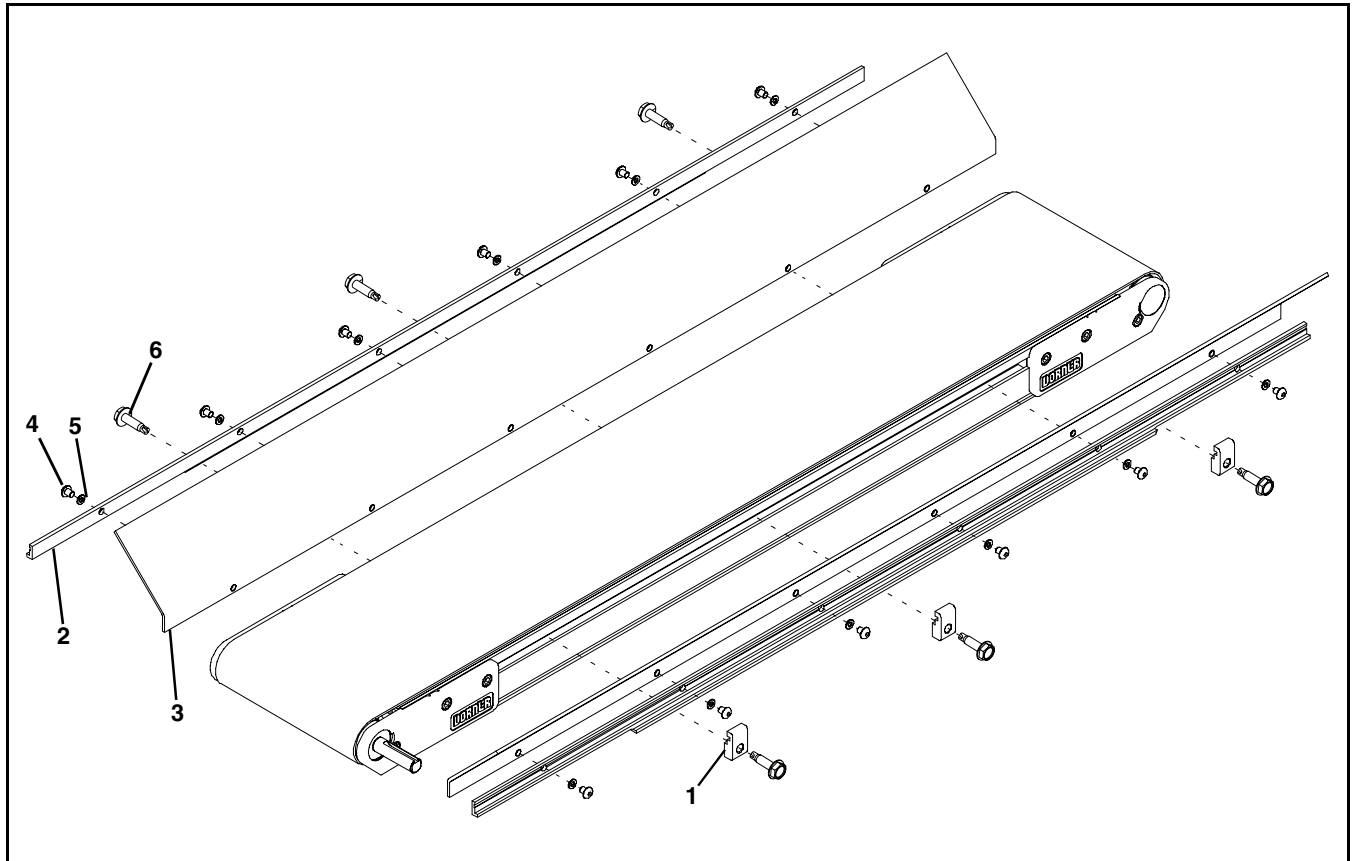
Item	Part Number	Description
1	200121	Guide Retaining Clip
2	See Chart Below	2300 Guide 2.3" Cleated
3	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

Item 2: 2300 Guide		
Length		End Guide
2' (610mm)	Left Hand	281903-02256
	Right Hand	281903-02256
3' (914mm)	Left Hand	281903-03456
	Right Hand	281903-03456
4' (1219mm)	Left Hand	281903-04656
	Right Hand	281903-04656
5' (1524mm)	Left Hand	281903-05856
	Right Hand	281903-05856
6' (1829mm)	Left Hand	281903-07056
	Right Hand	281903-07056
7' (2134mm)	Left Hand	281903-08256
	Right Hand	281903-08256
8' (2438mm)	Left Hand	281903-09456
	Right Hand	281903-09456
9' (2743mm)	Left Hand	281901-05400 (x2)
	Right Hand	281902-05400 (x2)
10' (3048mm)	Left Hand	281901-06000 (x2)
	Right Hand	281902-06000 (x2)
11' (3353mm)	Left Hand	281901-06600 (x2)
	Right Hand	281902-06600 (x2)

Item 2: 2300 Guide		
Length		End Guide
12' (3658mm)	Left Hand	281901-07200 (x2)
	Right Hand	281902-07200 (x2)
13' (3962mm)	Left Hand	281901-07800 (x2)
	Right Hand	281902-07800 (x2)
14' (4267mm)	Left Hand	281901-08400 (x2)
	Right Hand	281902-08400 (x2)
15' (4572mm)	Left Hand	281901-09000 (x2)
	Right Hand	281902-09000 (x2)
16' (4877mm)	Left Hand	281901-09600 (x2)
	Right Hand	281902-09600 (x2)

For conveyor lengths between even foot increments or longer than 16' (4877 mm) consult factory.

## Flared Side Guiding

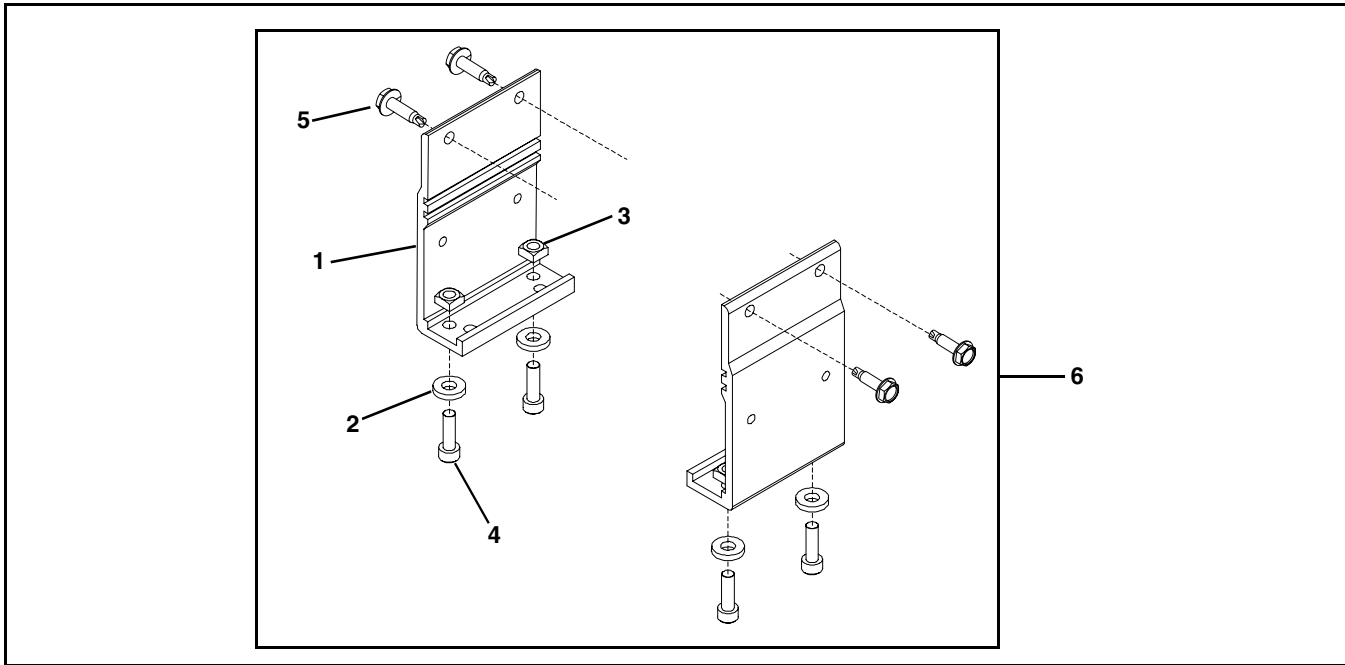


Item	Part Number	Description
1	200121	Guide Retaining Clip
2	202212	Side-Flare Mounting Guide 2' (610mm)
	202213	Side-Flare Mounting Guide 3' (914mm)
	202214	Side-Flare Mounting Guide 4' (1219mm)
	202215	Side-Flare Mounting Guide 5' (1524mm)
	202216	Side-Flare Mounting Guide 6' (1829mm)

Item	Part Number	Description
3	202522M	Flared Guide 45° 2' (610mm)
	202523M	Flared Guide 45° 3' (914mm)
	202523M	Flared Guide 45° 4' (1219mm)
	202523M	Flared Guide 45° 5' (1524mm)
	202523M	Flared Guide 45° 6' (1829mm)
4	910506M	Button Head Screw M5 x 6mm
5	911-512	Washer
6	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"

# Service Parts

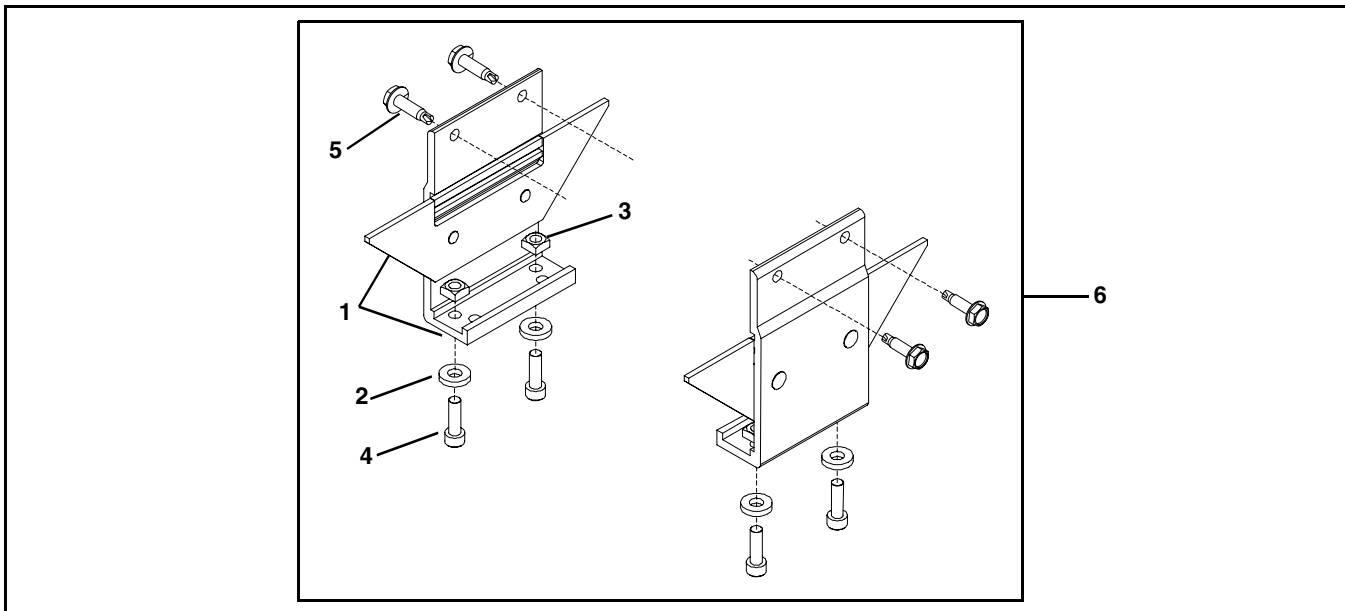
## Flat Belt Stand Mount Assembly



Item	Part Number	Description
1	240831	Stand Mount
2	605279P	Washer
3	807-920	Square Nut M6

Item	Part Number	Description
4	920620M	Socket Head Screw M6 x 20mm
5	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"
6	715642	Flat Belt Stand Mount Assembly

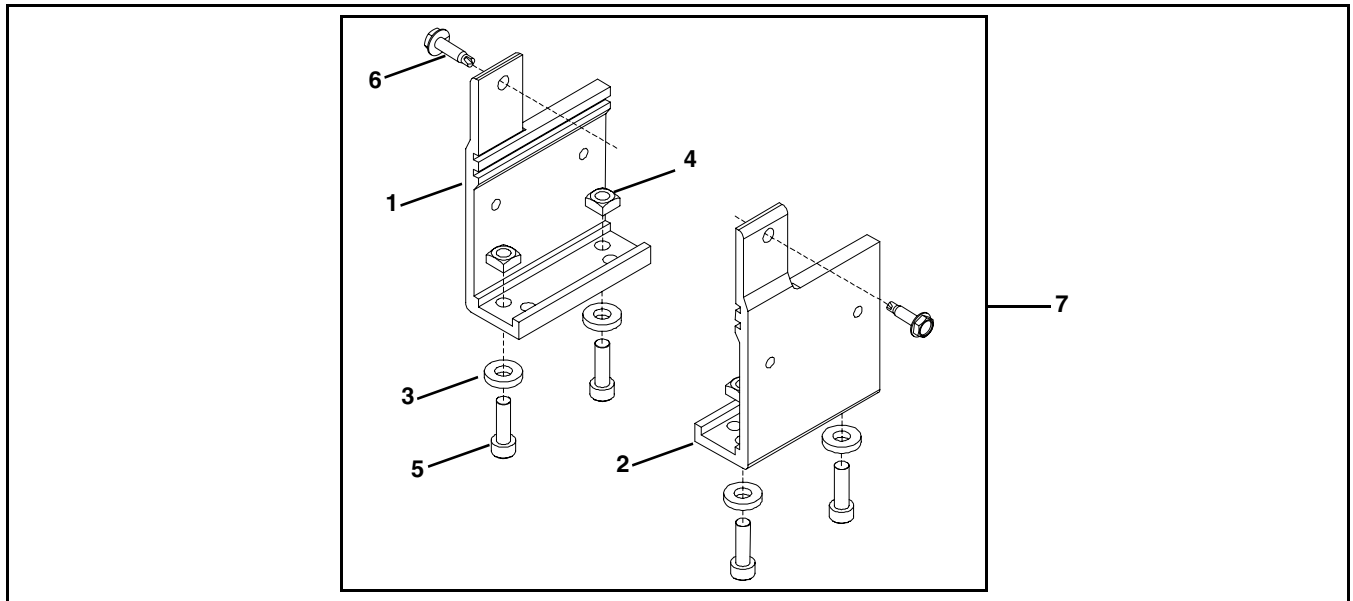
## Cleated Belt Stand Mount Assembly



Item	Part Number	Description
1	240836	Cleated Mount Assembly
2	605279P	Washer
3	807-920	Square Nut M6
4	920620M	Socket Head Screw M6 x 20mm

Item	Part Number	Description
5	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"
6	714645	Cleated Stand Mount Assembly

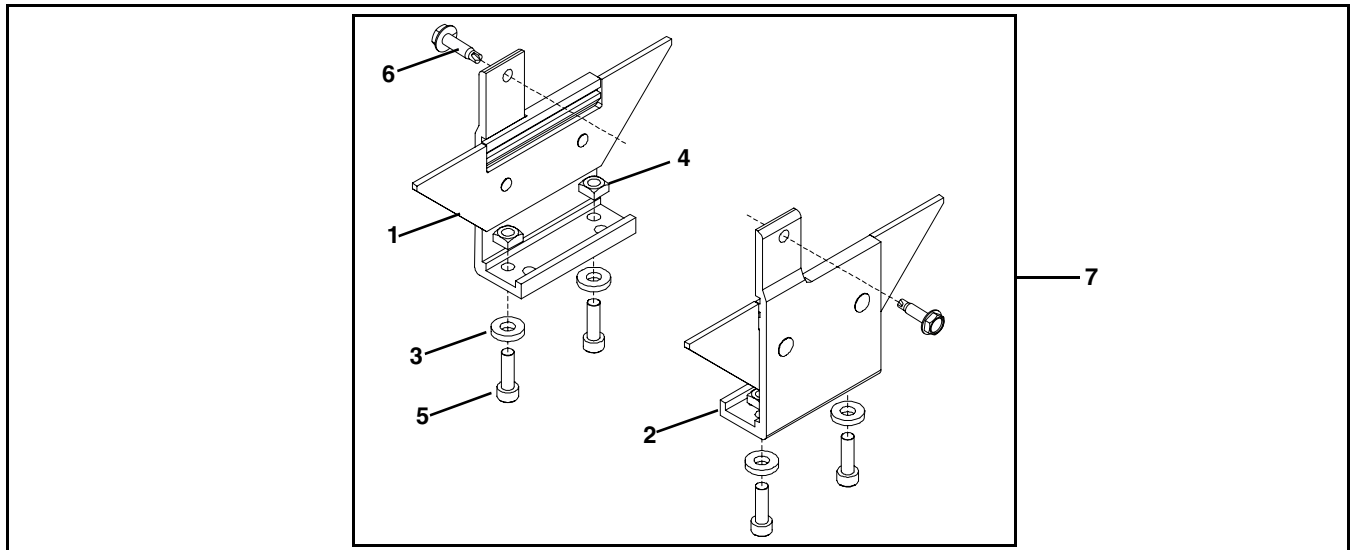
## Flat Belt Stand Mount Assembly for 2' (610mm) Long Conveyors



Item	Part Number	Description
1	240833	Stand Mount, LH 2' (610mm)
2	240834	Stand Mount, RH 2' (610mm)
3	605279P	Washer
4	807-920	Square Nut M6
5	920620M	Socket Head Screw M6 x 20mm

Item	Part Number	Description
6	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"
7	240847	Flat Belt Stand Mount Assembly, for Idler End up to 2' (610mm) Conveyors
	715644-DR	Flat Belt Stand Mount Assembly, for Drive End up to 2' (610mm) Conveyors

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

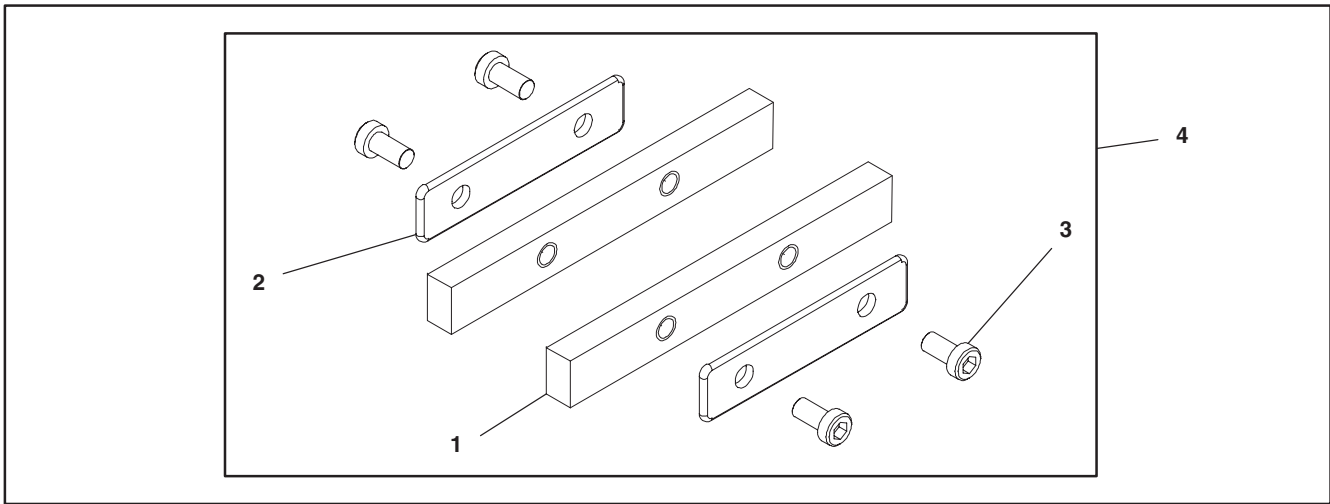


Item	Part Number	Description
1	240852	Cleated Stand Bracket Assembly LH 2' (610mm) Conveyor
2	240853	Cleated Stand Bracket Assembly RH 2' (610mm) Conveyor
3	605279P	Washer

Item	Part Number	Description
4	807-920	Square Nut M6
5	920620M	Socket Head Screw M6 x 20mm
6	807-1937	Self-Drilling Hex Head Screw, 1/4-20x1"
7	240851	Cleated Belt Stand Mount Assembly for Idler end up to 2' (610mm) Conveyors
	715647-DR	Cleated Belt Stand Mount Assembly for Drive End up to 2' (610mm) Conveyors

# Service Parts

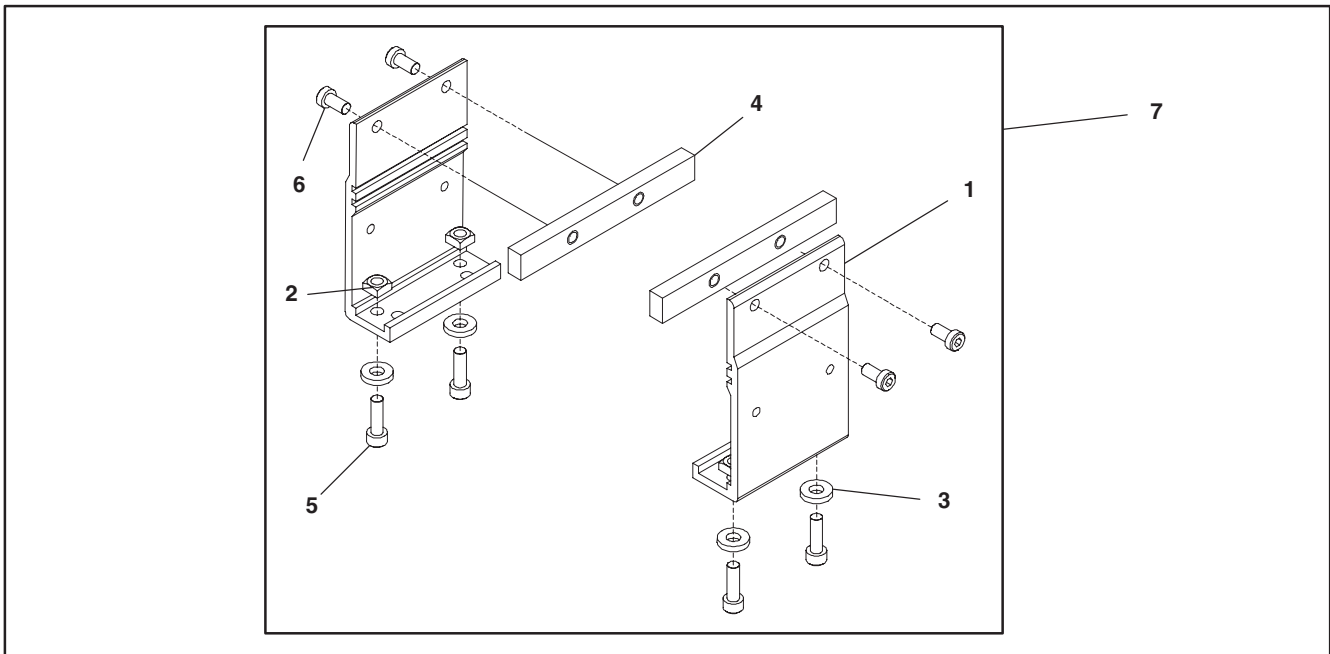
## Connecting Assembly without Stand Mount



Item	Part Number	Description
1	712033	Frame Connector Bar
2	240859	Frame Connector Plate

Item	Part Number	Description
3	920692M	Socket Low Head Screw M6x12mm
4	715641	Connecting Assembly without Stand Mounts

## Flat Belt Connecting Assembly with Stand Mount

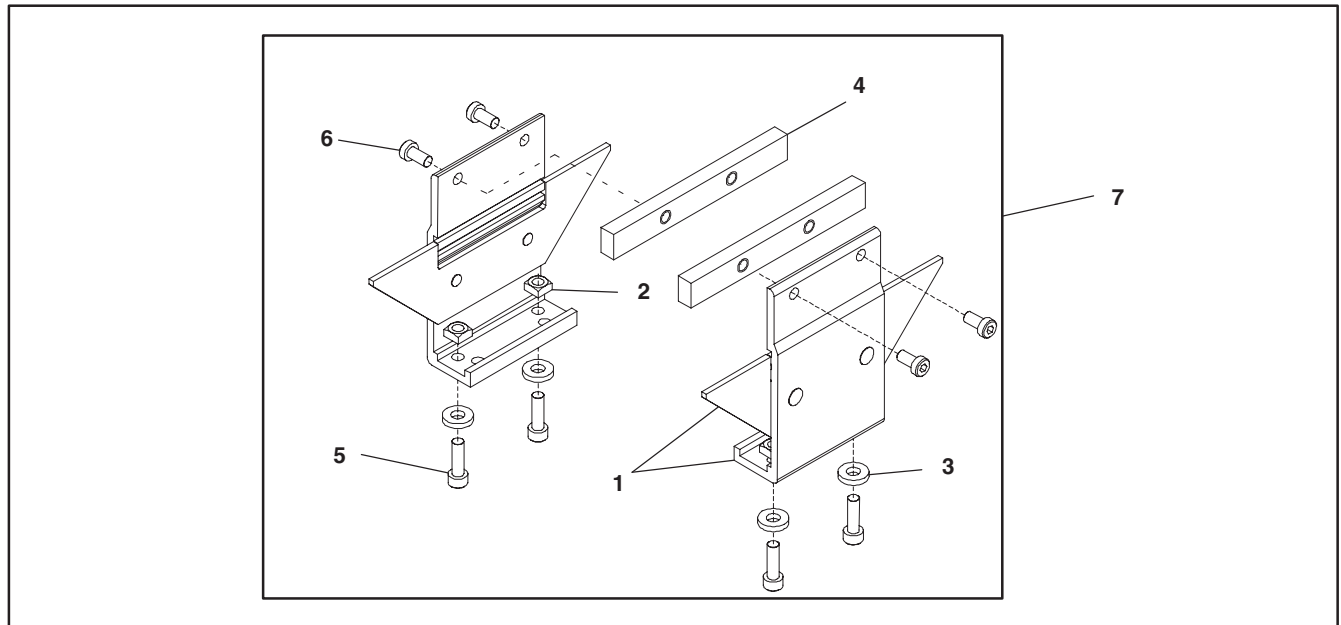


Item	Part Number	Description
1	240831	Stand Mount
2	807-920	Square Nut M6 5mm x 10mm
3	605279P	Washer
4	712033	Frame Connector Bar

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20mm
6	920693M	Socket Low Head Screw M6x12mm
7	715643	Flat Belt Connecting Assembly with Stand Mounts



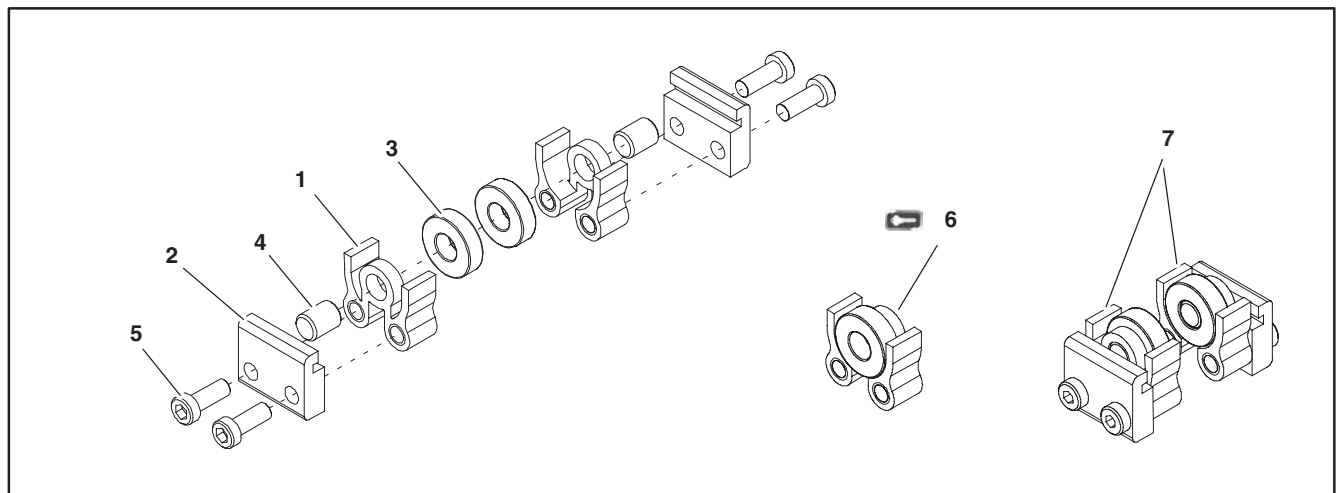
## Cleated Belt Connecting Assembly with Stand Mount



Item	Part Number	Description
1	240836	Cleated Stand Bracket
2	807-920	Square Nut M6 5mm x 10mm
3	605279P	Washer
4	712033	Frame Connector Bar

Item	Part Number	Description
5	920620M	Socket Head Screw M6 x 20mm
6	920693M	Socket Low Head Screw M6 x 16mm
7	715646	Cleated Belt Connecting Assembly with Stand Mounts

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

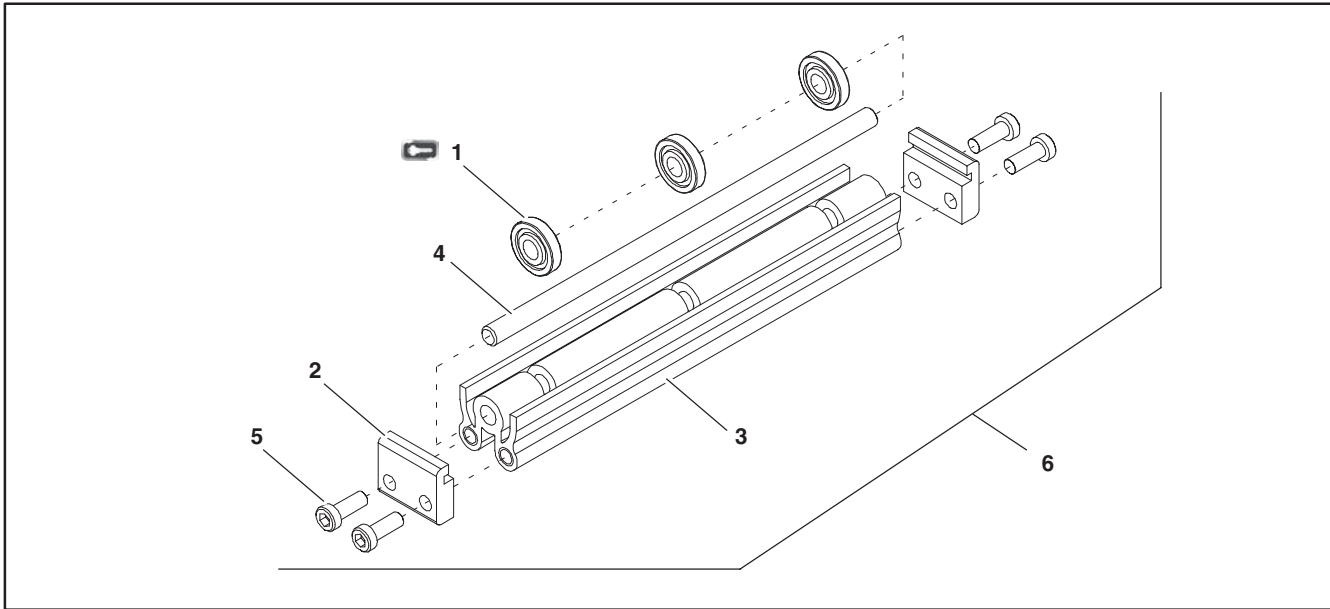


Item	Part Number	Description
1	240825	Return Roller Guard - Short
2	240827	Return Roller Clip
3	802-027	Bearing
4	913-100	Dowel Pin

Item	Part Number	Description
5	920693M	Socket Low Head Screw M6 x 16mm
6	240840	Roller Assembly (Includes Items 1, 3 and 4)
7	240830	2" (51mm) to 6" (152mm) Flat Belt Return Roller Assembly

# Service Parts

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

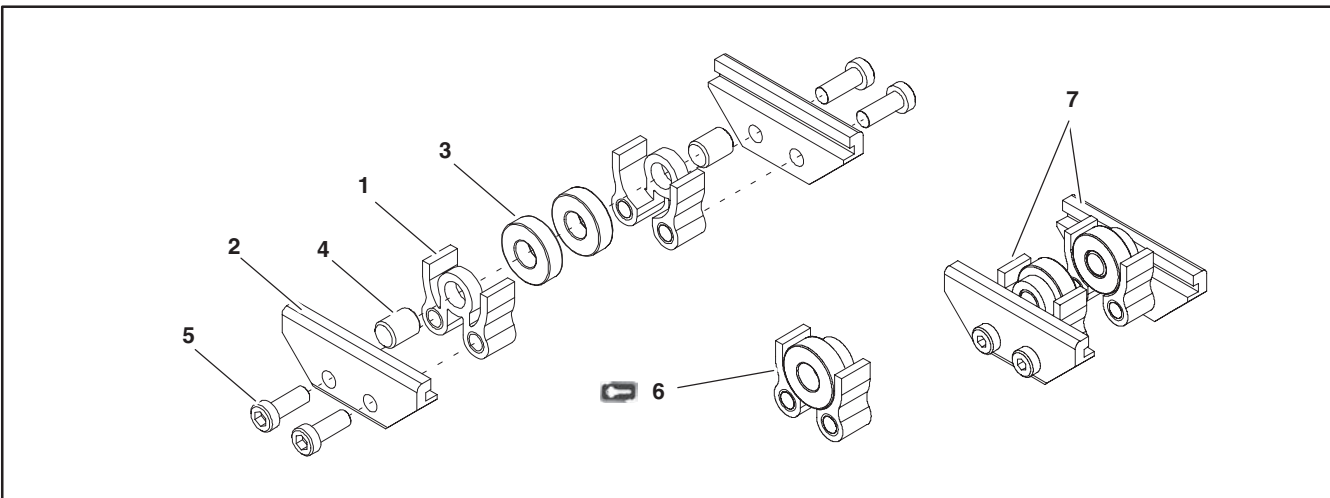


Item	Part Number	Description
1	240826	Return Roller
2	240827	Return Roller Clip
3	2409WW	Return Roller Guard
4	2410WW	Return Roller Rod

Item	Part Number	Description
5	920693M	Socket Low Head Screw M6 x 16mm
6	2408WW	8" (203mm) to 24" (610mm) Flat Belt Return Roller Assembly

WW = Conveyor width reference: 08, 12, 18 & 24

## Cleated Belt Return Roller



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

Item	Part Number	Description
5	920693M	Socket Low Head Screw M6 x 16mm
6	240840	Roller Assembly (Includes Items 1, 3 and 4)
7	240832	Cleated Belt Return Roller Assembly

Conveyor Belt Part Number Configuration

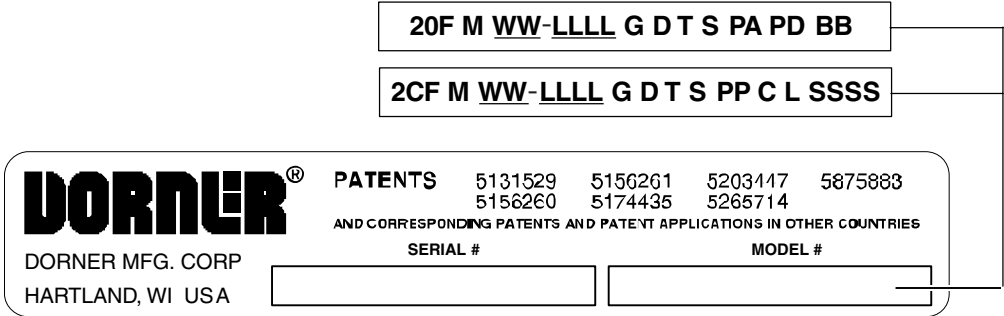


Figure 52

Flat Belt Part Number Configuration

Refer to Dorner patent plate (Figure 52). From the model number, determine conveyor width (“WW”), length (“LLLL”) and belt type (“BB”). Use data to configure belt part number as indicated below. \*Add “V” for V-guided belts.

22 - WW LLLL / BB V \*

22 - \_\_\_\_\_ / \_\_\_\_ V\*

(Fill In)

Cleated Belt Part Number Configuration

Refer to Dorner patent plate (Figure 52). From the model number, determine conveyor type (“T”), width (“WW”), length (“LLLL”), cleat type (“C”) and cleat spacing (“SSSS”). Use data to configure belt part number as indicated below. \*Add “V” for V-guided belts.

2T - WW LLLL C SSSS V \*

2 - \_\_\_\_\_ / \_\_\_\_\_ V\*

(Fill In)

# Return Policy

Returns must have prior written factory authorization or they will not be accepted. Items that are returned to Dorner without authorization will not be credited nor returned to the original sender. When calling for authorization, please have the following information ready for the Dorner factory representative or your local distributor:

1. Name and address of customer.
2. Dorner part number(s) of item(s) being returned.
3. Reason for return.
4. Customer's original order number used when ordering the item(s).
5. Dorner or distributor invoice number (if available, part serial number).

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

### Conveyors and conveyor accessories

Standard catalog conveyors	30%
MPB, 7200, 7300 Series, cleated and specialty belt	50%
AquaGuard & 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](http://www.dorner.com).

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



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