



# Ready-To-Run Mini Conveyors

## Installation, Maintenance & Parts Manual



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|                  |
|------------------|
| <b>IMPORTANT</b> |
|------------------|

|   |
|---|
| <i>Some illustrations may show guards removed. DO NOT operate equipment without guards.</i> |
|---|

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 2200 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 | Drive End                  |
| 2 | Gearmotor Mounting Package |
| 3 | Guiding & Accessories      |
| 4 | Idler/Tension End          |
| 5 | Conveyor                   |
| 6 | Mounting Brackets          |
| 7 | Variable Speed Controller  |
| 8 | Support Stand              |
| 9 | Caster Wheels              |

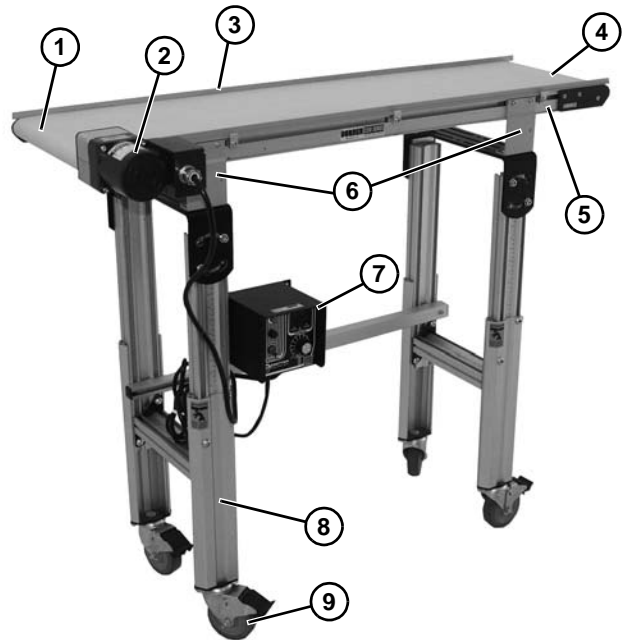


Figure 1

# Specifications

## Models:

### Conveyor Assembly Model Number:

#### Fixed Speed Control: 9 ft/min

| Length | 1.75"    | 3"       | 4"       | 6"       | 8"       | 12"      |
|--------|----------|----------|----------|----------|----------|----------|
| 3 foot | 75009199 | 75009203 | 75009207 | 75009211 | 75009215 | 75009219 |
| 5 foot | 75009223 | 75009227 | 75009231 | 75009235 | 75009239 | 75009243 |
| 8 foot | 75009247 | 75009251 | 75009255 | 75009259 | 75009263 | 75009267 |

#### Fixed Speed Control: 15 ft/min

| Length | 1.75"    | 3"       | 4"       | 6"       | 8"       | 12"      |
|--------|----------|----------|----------|----------|----------|----------|
| 3 foot | 75009200 | 75009204 | 75009208 | 75009212 | 75009216 | 75009220 |
| 5 foot | 75009224 | 75009228 | 75009232 | 75009236 | 75009240 | 75009244 |
| 8 foot | 75009248 | 75009252 | 75009256 | 75009260 | 75009264 | 75009268 |

#### Fixed Speed Control: 21 ft/min

| Length | 1.75"    | 3"       | 4"       | 6"       | 8"       | 12"      |
|--------|----------|----------|----------|----------|----------|----------|
| 3 foot | 75009201 | 75009205 | 75009209 | 75009213 | 75009217 | 75009221 |
| 5 foot | 75009225 | 75009229 | 75009233 | 75009237 | 75009241 | 75009245 |
| 8 foot | 75009249 | 75009253 | 75009257 | 75009261 | 75009265 | 75009269 |

# Specifications

## Fixed Speed Control: 35 ft/min

| Length | 1.75"    | 3"       | 4"       | 6"       | 8"       | 12"      |
|--------|----------|----------|----------|----------|----------|----------|
| 3 foot | 75009202 | 75009206 | 75009210 | 75009214 | 75009218 | 75009222 |
| 5 foot | 75009226 | 75009230 | 75009234 | 75009238 | 75009242 | 75009246 |
| 8 foot | 75009250 | 75009254 | 75009258 | 75009262 | 75009266 | 75009270 |

## Variable Speed Control: 3 to 15 ft/min

| Length | 1.75"    | 3"       | 4"       | 6"       | 8"       | 12"      |
|--------|----------|----------|----------|----------|----------|----------|
| 3 foot | 75009271 | 75009274 | 75009277 | 75009280 | 75009283 | 75009286 |
| 5 foot | 75009289 | 75009292 | 75009295 | 75009298 | 75009301 | 75009304 |
| 8 foot | 75009307 | 75009310 | 75009313 | 75009316 | 75009319 | 75009322 |

## Variable Speed Control: 6 to 35 ft/min

| Length | 1.75"    | 3"       | 4"       | 6"       | 8"       | 12"      |
|--------|----------|----------|----------|----------|----------|----------|
| 3 foot | 75009272 | 75009275 | 75009278 | 75009281 | 75009284 | 75009287 |
| 5 foot | 75009290 | 75009293 | 75009296 | 75009299 | 75009302 | 75009305 |
| 8 foot | 75009308 | 75009311 | 75009314 | 75009317 | 75009320 | 75009323 |

## Variable Speed Control: 10 to 58 ft/min

| Length | 1.75"    | 3"       | 4"       | 6"       | 8"       | 12"      |
|--------|----------|----------|----------|----------|----------|----------|
| 3 foot | 75009273 | 75009276 | 75009279 | 75009282 | 75009285 | 75009288 |
| 5 foot | 75009291 | 75009294 | 75009297 | 75009300 | 75009303 | 75009306 |
| 8 foot | 75009309 | 75009312 | 75009315 | 75009318 | 75009321 | 75009324 |

## Adjustable Height Stand Models:

| Height               |          |
|----------------------|----------|
| 24 to 36 inches high | 75009327 |
| 30 to 48 inches high | 75009328 |

(Note: The stand bracket and conveyor add 5" to Top of Belt Height.)

## Support Stand Cross Brace Models:

| Height               |          |
|----------------------|----------|
| For 3' Long Conveyor | 75009329 |
| For 5' Long Conveyor | 75009330 |
| For 8' Long Conveyor | 75009331 |

## Surface Mounting Bracket Models:

| Height                      |          |
|-----------------------------|----------|
| 2" to 3" Top of Belt Height | 75009325 |
| 3" to 5" Top of Belt Height | 75009326 |

# Specifications

## Conveyor Supports:

### Maximum Distances:

- 1 = 18" (457 mm)
- 2 = 6 ft (1829 mm)
- 3 = 18" (457 mm)

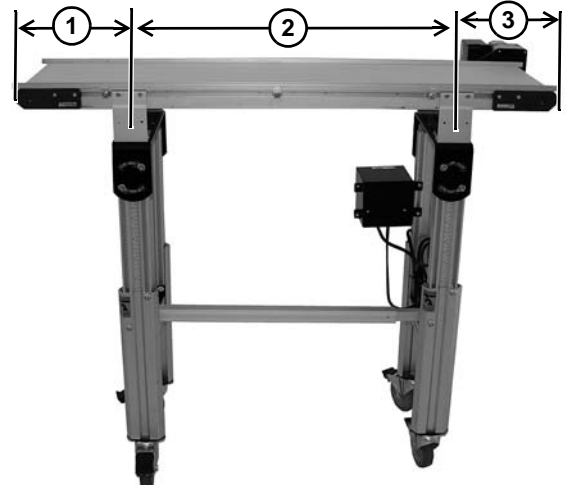


Figure 2

## Specifications:

Table 1: Conveyor Speed / Maximum Load Capacity

### Fixed Speed Gearmotors

| Load Capacity (lbs) | Belt Width (in) |    |    |    |    |    |
|---------------------|-----------------|----|----|----|----|----|
|                     | 1.75            | 3  | 4  | 6  | 8  | 12 |
| Speed (ft/min)      |                 |    |    |    |    |    |
| 9                   | 30              | 35 | 42 | 60 | 70 | 80 |
| 15                  | 30              | 35 | 42 | 60 | 70 | 80 |
| 21                  | 30              | 35 | 42 | 57 | 52 | 43 |
| 35                  | 30              | 35 | 34 | 29 | 24 | 14 |

### Variable Speed Motors

| Load Capacity (lbs) | Belt Width (in) |    |    |    |    |    |
|---------------------|-----------------|----|----|----|----|----|
|                     | 1.75            | 3  | 4  | 6  | 8  | 12 |
| Speed (ft/min)      |                 |    |    |    |    |    |
| 3 to 15             | 30              | 35 | 42 | 60 | 70 | 80 |
| 6 to 35             | 30              | 35 | 42 | 52 | 47 | 37 |
| 10 to 58            | 30              | 35 | 27 | 22 | 17 | 8  |

### NOTE

- Maximum conveyor loads based on:
- Non-accumulating product
  - Product moving towards gearmotor
  - Conveyor being mounted horizontal

Table 2: Gearmotor Specifications

| Part Number   | Output Hp | Input Volts | Input Phase | Input Hz | Amps FLA | Ratio | RPM | Torque in-lb |
|---------------|-----------|-------------|-------------|----------|----------|-------|-----|--------------|
| 62M060PL411FN | 0.03      | 115V        | 1           | 60       | 0.46     | 60    | 25  | 38           |
| 62M036PL411FN | 0.03      | 115V        | 1           | 60       | 0.46     | 36    | 42  | 26           |
| 62M025PL411FN | 0.03      | 115V        | 1           | 60       | 0.46     | 25    | 60  | 18           |
| 62M015PL411FN | 0.03      | 115V        | 1           | 60       | 0.46     | 15    | 100 | 12           |
| 62M036PL423EN | 0.03      | 230V        | 3           | 10 to 60 | 0.22     | 36    | 42  | 37           |
| 62M015PL423EN | 0.03      | 230V        | 3           | 10 to 60 | 0.22     | 15    | 100 | 16.8         |
| 62M009PL423EN | 0.03      | 230V        | 3           | 10 to 60 | 0.22     | 9     | 167 | 10.6         |

Table 3: Variable Speed Controller Specification

| Part Number | Input Volts | Input Phase | Input Hz | Output Volts | Output Phase | Output Hz | Max Amps |
|-------------|-------------|-------------|----------|--------------|--------------|-----------|----------|
| 22MV122BR   | 115V        | 1           | 60       | 230          | 3            | 10 to 60  | 2.4      |

# Installation

## 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

- |   |  |
|---|--|
| 1 | Conveyor with Gearmotor Mounting Package   |
| 2 | Variable Speed Controller (Optional)       |
| 3 | Support Stand (Optional)                   |
| 4 | Support Stand Mounting Brackets (Optional) |
| 5 | Adjustable Stand Cross Bracket (Optional)  |
| 6 | Surface Mount Brackets (Optional)          |

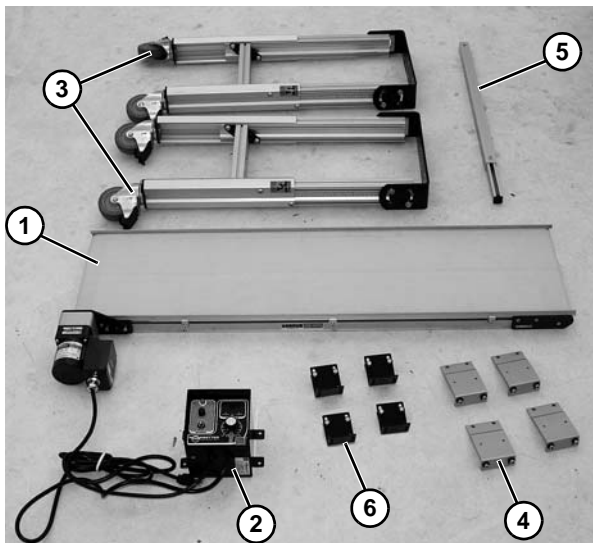


Figure 4

## Required Tools

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

## Recommended Installation Sequence

- Attach mounting brackets to conveyor (see “Support Stand Mounting Brackets” on page 8 for stand mounting brackets and see “Surface Mount Brackets” on page 9 for surface mounting brackets).
- Attach conveyor to stands (see “Stand Attachment” on page 10).
- Install stand cross brace
- Install variable speed controller

## Support Stand Mounting Brackets

1. Locate brackets. Exploded view shown in Figure 5.

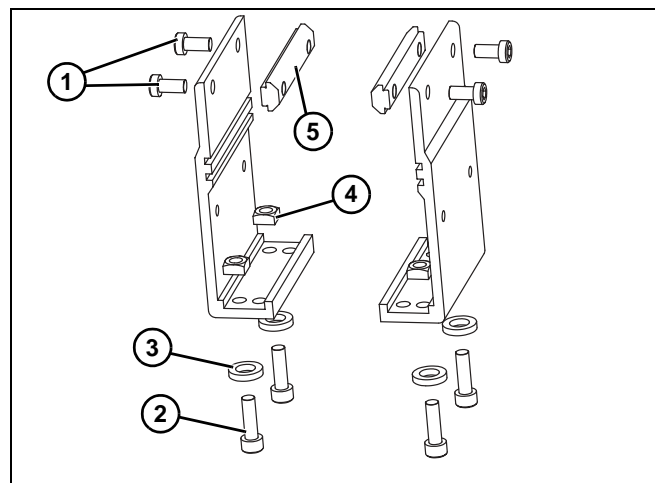


Figure 5

2. Remove screws (Figure 5, item 1 & 2), washers (Figure 5, item 3), nuts (Figure 5, item 4) and T-bars (Figure 5, item 5) from brackets.
3. Insert T-bars (Figure 5, item 5) into conveyor side slots (Figure 6, item 1). Fasten brackets (Figure 6, item 2) to conveyor with mounting screws (Figure 6, item 3).

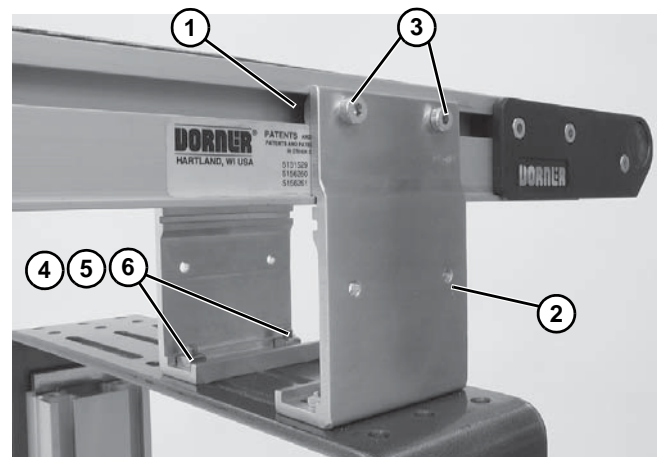


Figure 6



## NOTE

Mounting brackets for flat belt conveyors shown.

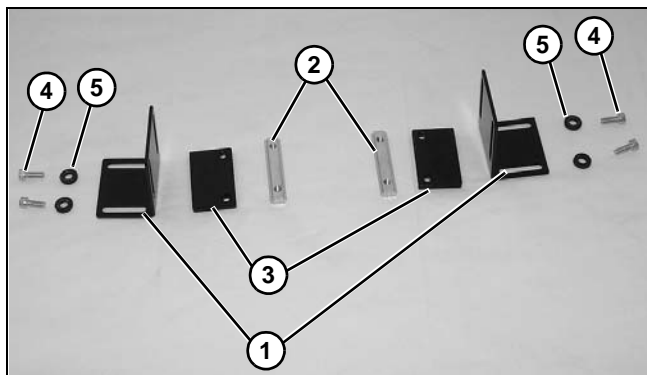
4. Fasten brackets to support stand with mounting screws (**Figure 6, item 4**), washers (**Figure 6, item 5**) and nuts (**Figure 6, item 6**).
5. Tighten screws (**Figure 6, item 3 & 4**) to 60 in-lb (7 Nm).
6. See “Stand Height Adjustment” on page 19 for stand height adjustment.

## Surface Mount Brackets

1. Locate brackets. Exploded view shown in Figure 8.

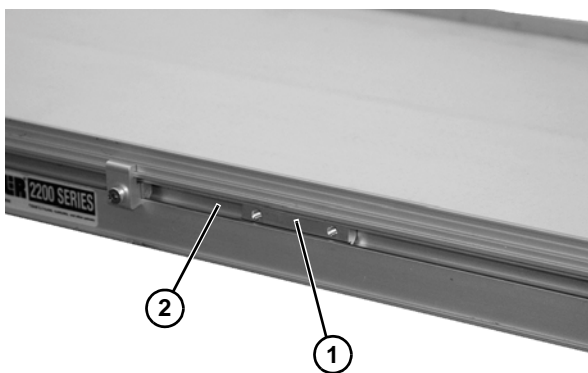
### Illustration References

- |   |                      |
|---|----------------------|
| 1 | Slotted Bracket (2x) |
| 2 | M6 T-Bar (2x)        |
| 3 | Spacer Plate (2x)    |
| 4 | M6 Screw (4x)        |
| 5 | M6 Washer (4x)       |



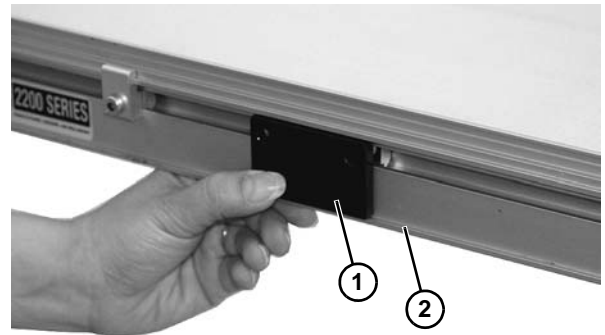
**Figure 7**

2. Install M6 T-bar (**Figure 8, item 1**) in T-slot (**Figure 8, item 2**).



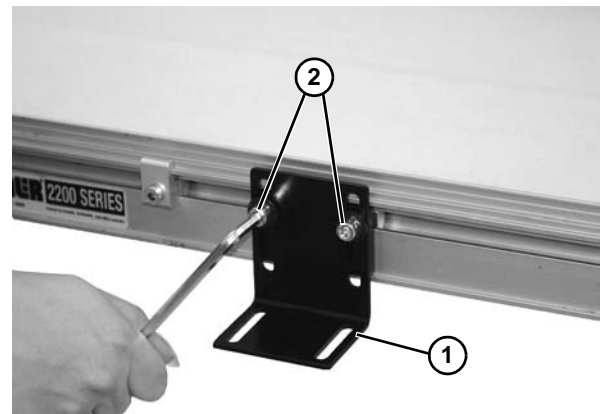
**Figure 8**

3. Set spacer (**Figure 9, item 1**) on conveyor lip (**Figure 9, item 2**).



**Figure 9**

4. Mount slotted bracket (**Figure 10, item 1**) to conveyor frame with M6 screws (**Figure 10, item 2**).




**Figure 10**

5. Adjust height as required. Tighten M6 screws to 80 in-lb (9 Nm).
6. Repeat for opposite side of conveyor.

# Installation

## Adjustable Cross Brace

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

### Required Tools

- 5 mm hex key wrench
- Torque wrench

### Illustration References:

|   |                                   |
|---|-----------------------------------|
| 1 | M6 T-Bar (2x)                     |
| 2 | Adjustable Bar                    |
| 3 | M6 x 40 mm Socket Head Screw (2x) |

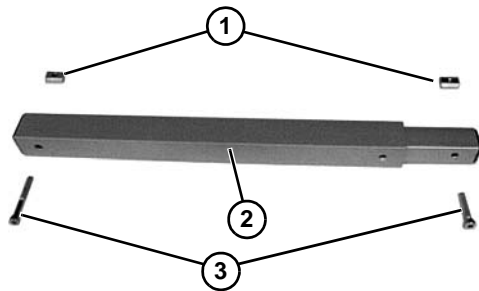


Figure 11

## Stand Attachment

1. Loosen screw (Figure 12, item 1) of adjustable bar (Figure 12, item 2).

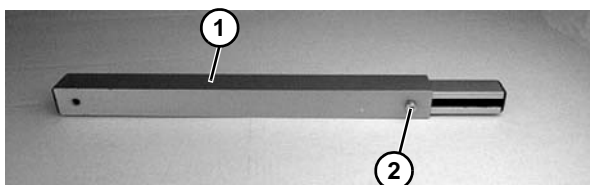


Figure 12

2. Install T-bar (Figure 13, item 1) in inner T-slot of stand leg (Figure 13, item 2).

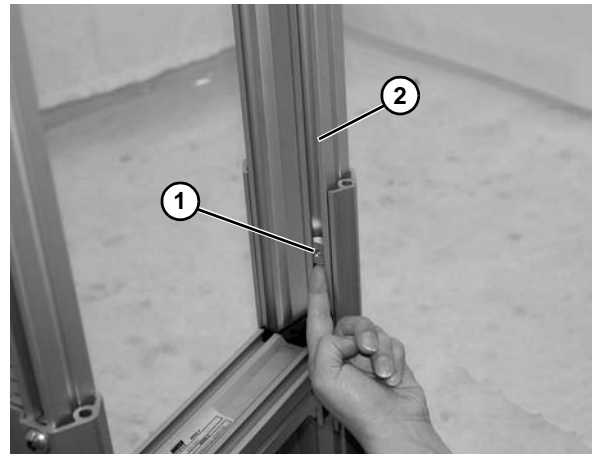


Figure 13

3. Loosely attach adjustable bar (Figure 14, item 1) or (Figure 15, item 1) to aluminum stand T-slot as required.
- Attach outer tube end with screw (Figure 14, item 2).

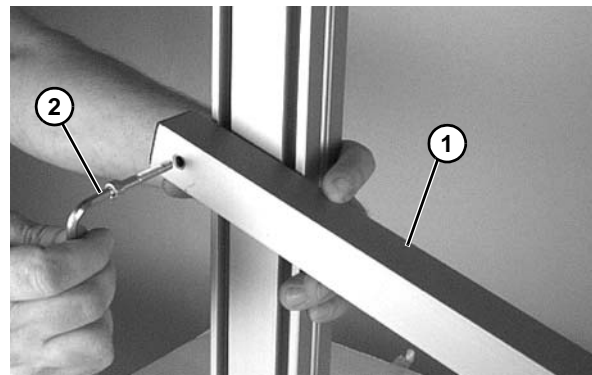


Figure 14

- Attach inner channel end with screw (Figure 15, item 2).

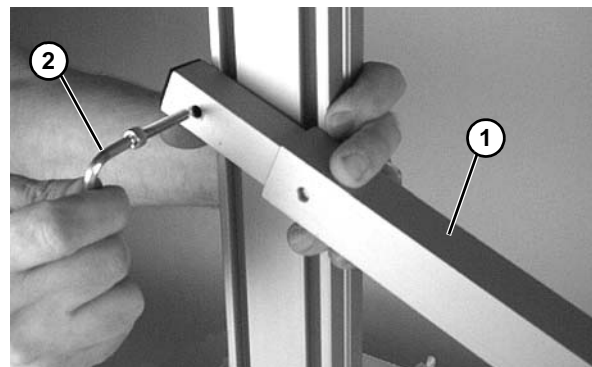



Figure 15

**⚠ WARNING**



**Failure to secure three screws (Figure 16, item 1), may cause conveyor sections to drop down, causing severe injury. TIGHTEN SCREWS AFTER ADJUSTMENT.**

4. Tighten three screws (Figure 16, item 1), to 80 in-lb (9 Nm).

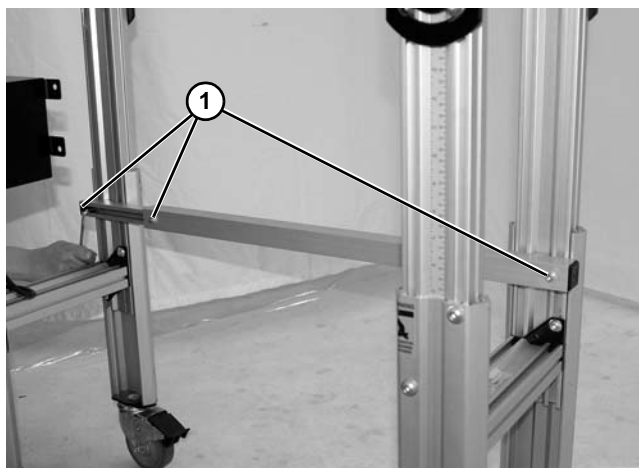


Figure 16

## Variable Speed Controller

### Variable Speed Controller Mounting to Conveyor

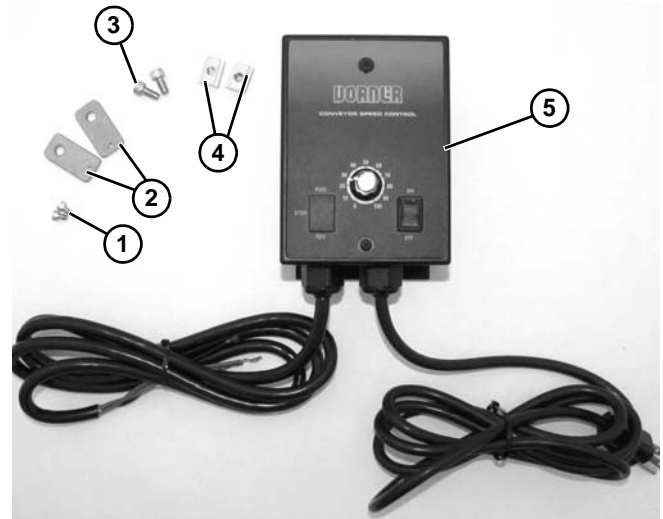


Typical Variable Speed Mounting on Conveyor

Figure 17

### Illustration References:


| Item | Part Number | Description                             |
|------|-------------|---|
| 1    | 920406M     | Socket Head Screw, M4-0.70 x 6 mm       |
| 2    | 202658      | Mounting Clip (x2)                      |
| 3    | 920612M     | Socket Head Screw, M6-1.00 x 12 mm (x2) |
| 4    | 639971M     | T-Bar, Single Drop-In (x2)              |
| 5    | 827-101     | Controller                              |
|      | 827-100     | Reversing Controller                    |



Shipping Package

Figure 18

**⚠ WARNING**



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

1. Assemble mounting clips (Figure 19, item 1) with screws (Figure 19, item 2) to the top of the controller.

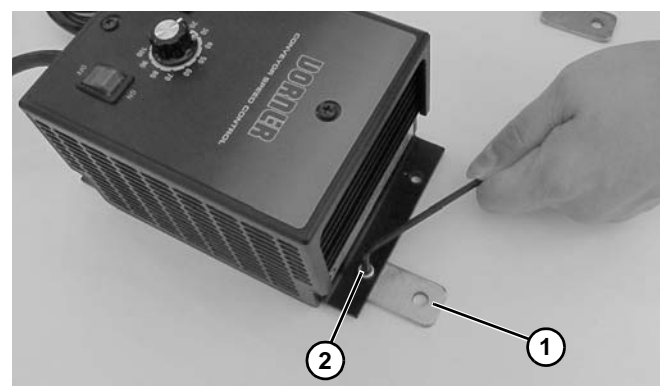


Figure 19

# Installation

2. Install T-bars (Figure 20, item 1) into T-slots of conveyor.

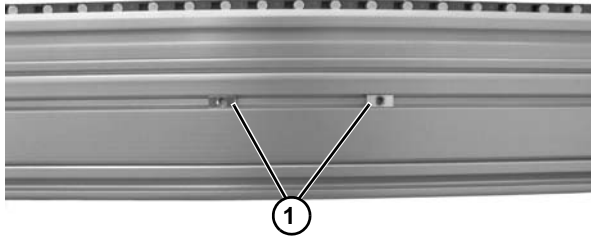


Figure 20

3. Attach controller to conveyor with two screws (Figure 21, item 1).

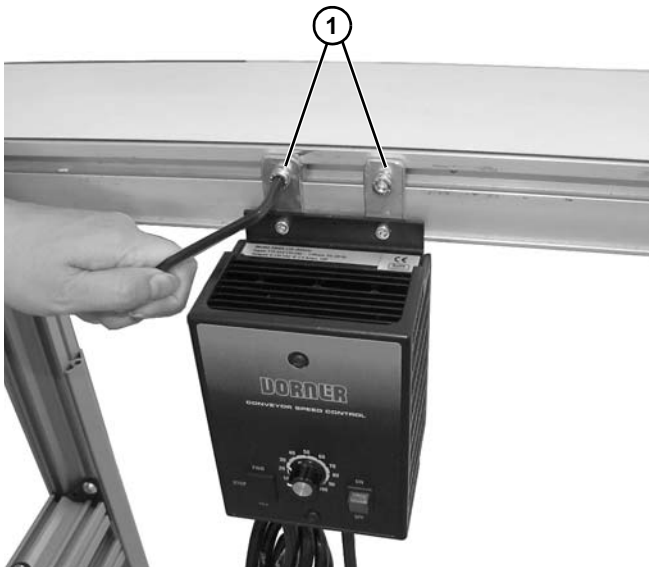


Figure 21

4. Slide controller to its desired mounting location along conveyor and tighten both screws.

## Variable Speed Controller Mounting to Stand Leg

### ⚠ WARNING



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

1. Assemble mounting clips (Figure 22, item 1) with screws (Figure 22, item 2) to the side of the controller.

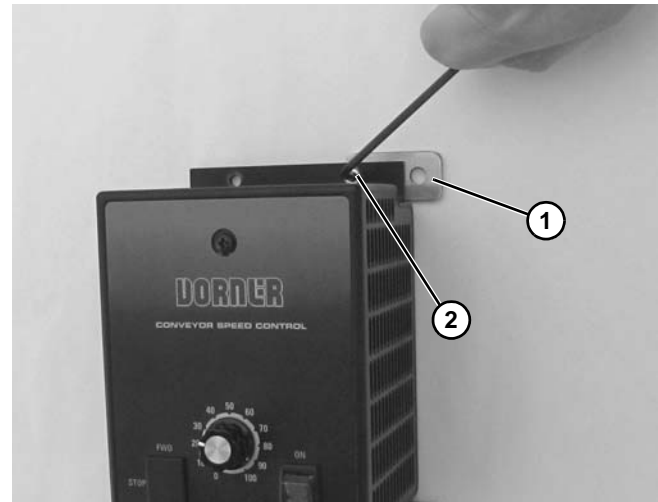


Figure 22

2. Install T-bars (Figure 23, item 1) into T-slots of stand leg.



Figure 23

3. Attach controller to stands with two screws (Figure 23, item 2).
4. Slide controller to its desired mounting location along conveyor and tighten both screws.

---

# Preventive Maintenance and Adjustment

---

## 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)
- 450292 Bearing Installation Tool (Pusher Sleeve)
- 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 with Stands and Gearmotor Mounting Package
- Install new conveyor belt
- Tension conveyor belt



# Preventive Maintenance and Adjustment

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

⚠ **WARNING**



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

1. Place temporary support stands (Figure 24, item 1) at both ends of the conveyor. Place an additional support stand (Figure 24, item 2) under the drive motor (Figure 24, item 3), if equipped. See WARNING.

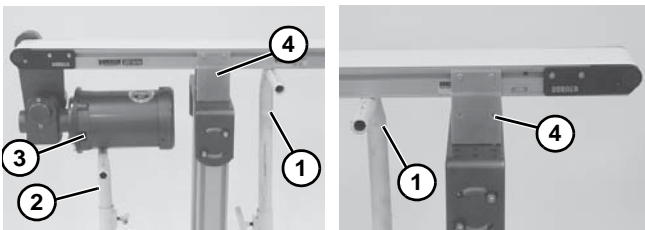


Figure 24

2. Remove mounting brackets (Figure 24, item 4) from one side of conveyor. (Reverse steps in “Support Stand Mounting Brackets” on page 8 or “Surface Mount Brackets” on page 9.) If equipped with heavy load drive package, remove brackets from side opposite drive (Figure 25, item 1).

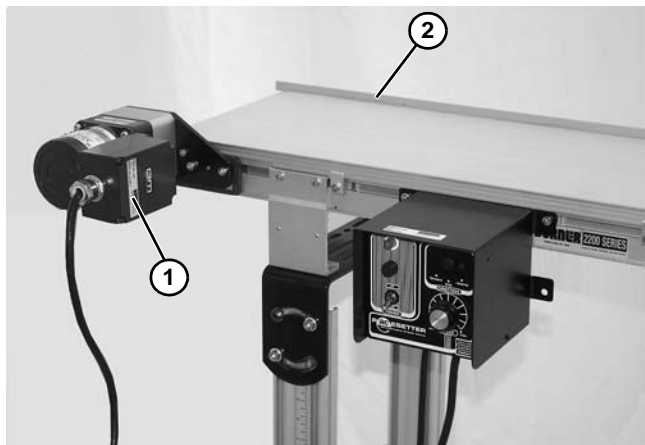



Figure 25

3. If equipped, remove return rollers, guiding (Figure 25, item 2) and accessories from side opposite drive (Figure 25, item 1).

4. 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.

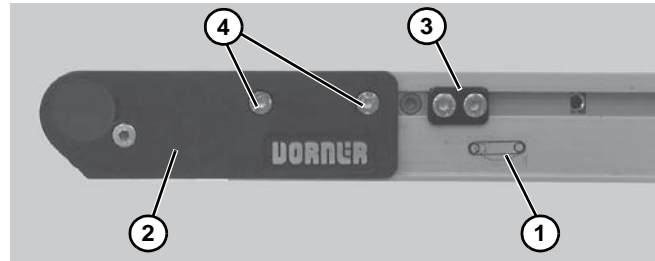


Figure 26


5. Remove belt (Figure 27, item 1) from conveyor.



Figure 27

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

⚠ **WARNING**



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

# Preventive Maintenance and Adjustment

1. Ensure temporary support stands (Figure 24, item 1) are placed at both ends of the conveyor. Place an additional support stand under the drive motor (Figure 24, item 3), if equipped. See WARNING.
2. Orient belt so splice leading fingers (Figure 28, item 1) point in the direction of belt travel as identified by the conveyor directional label (Figure 28, item 2).

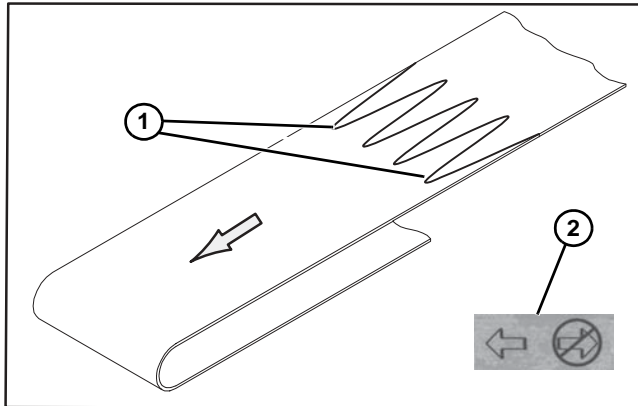


Figure 28

3. Install belt (Figure 29, item 1) on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.



Figure 29

4. Re-install conveyor mounting brackets. Refer to “Support Stand Mounting Brackets” on page 8 or “Surface Mount Brackets” on page 9.
5. Tension belt. Refer to “Conveyor Belt Tensioning” on page 15.
6. If equipped, re-install return rollers and guiding.

## Conveyor Belt Tensioning

**⚠ WARNING**

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

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

1. On tension end of the conveyor, identified with a label (Figure 30, item 1), adjust head plate assembly (Figure 30, item 2): On both sides of conveyor, loosen fastening screws (Figure 30, item 3) and rotate pinion gear (Figure 30, item 4) to adjust head plate assembly.

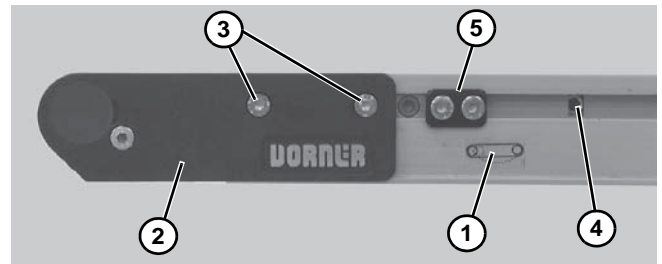


Figure 30

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks (Figure 31, 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.

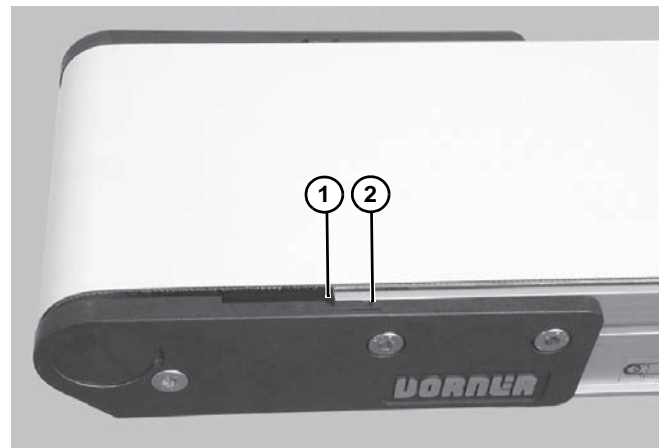


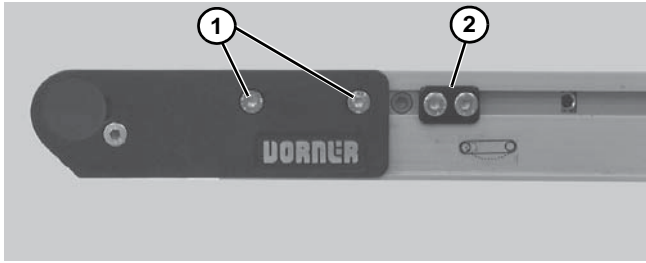
Figure 31

### NOTE

*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.*

# Preventive Maintenance and Adjustment

- After adjusting proper tensioning, tighten fastening screws (**Figure 32, item 1**) on both sides of conveyor to 60 in-lb (7 Nm).



**Figure 32**

- If equipped with cam tracking assemblies (**Figure 32, item 2**), position against head plates and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 16.

## Conveyor Belt Tracking

### V-Guided Belts

V-guided belts do not require tracking adjustment.

### Pulley Removal

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

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

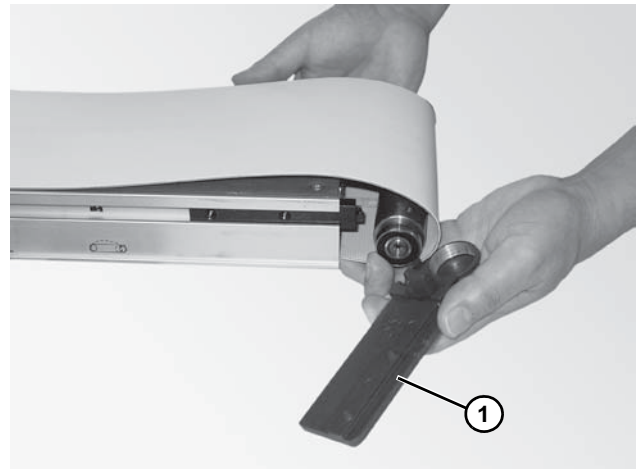
- On one side of the conveyor, loosen two (2) head plate fastening screws (**Figure 33, item 1**) and remove them.

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



**Figure 33**

- Remove the head plate (**Figure 34, item 1**) from the conveyor frame.



**Figure 34**

- Pulley will slide out of opposite head plate and drop into slack of belt (**Figure 35**).



**Figure 35**

- Slide spindle out of the belt loop.



# Preventive Maintenance and Adjustment

## B – Drive Pulley Removal

### ⚠ WARNING

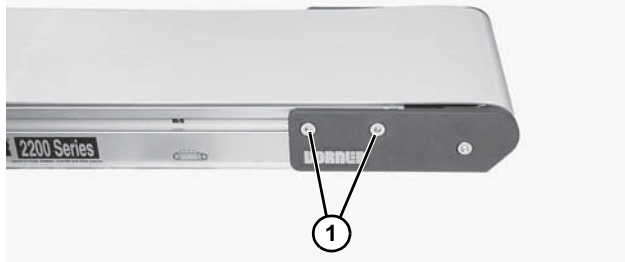


**Drive shaft keyway may be sharp. HANDLE WITH CARE.**

1. Remove gearmotor mounting package. See “Gearmotor Mounting Package Removal” on page 20.
2. On one side of the conveyor, loosen two (2) head plate fastening screws (**Figure 36, item 1**) and remove.

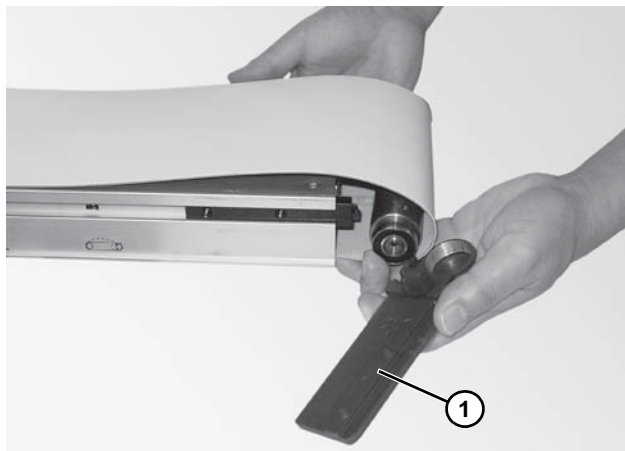
### NOTE

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



**Figure 36**

3. Remove the head plate (**Figure 37, item 1**) from the conveyor frame.



**Figure 37**

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

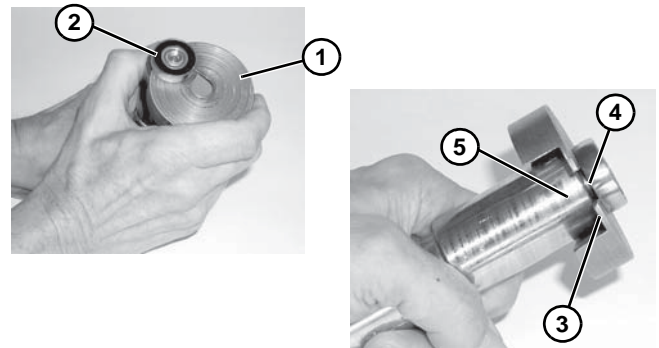
## Bearing Removal & Replacement

### Removal

### IMPORTANT

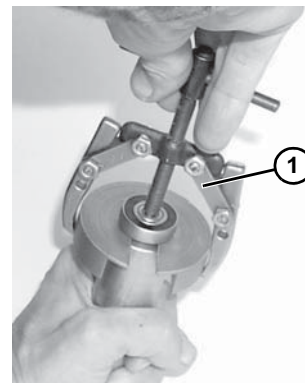
*Do not use any removed bearings. Replace them.*

1. Place bearing removal tool part #456063 (**Figure 38, item 1**) below bearing (**Figure 38, item 2**) with lip (**Figure 38, item 3**) located in gap (**Figure 38, item 4**) between bearing and spindle hub (**Figure 38, item 5**) as shown.



**Figure 38**

2. Using puller part #807-1716 (**Figure 39, item 1**), remove and discard bearing.

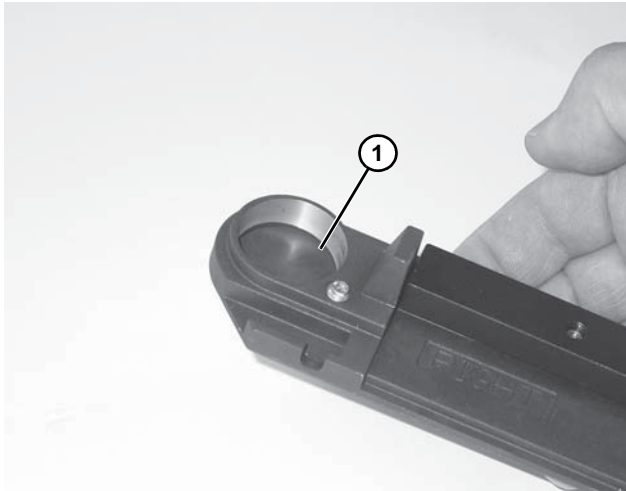


**Figure 39**

# Preventive Maintenance and Adjustment

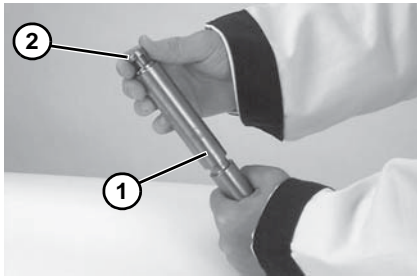
## Replacement

1. Inspect the head plates bearing seating surface (**Figure 40, item 1**). If they are worn or damaged, replace. See “Service Parts” on page 24.



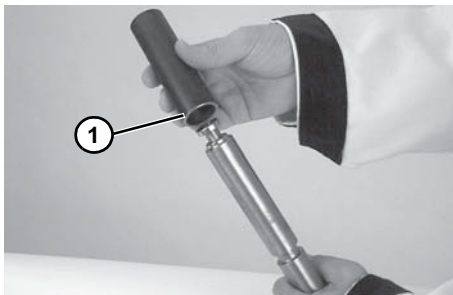
**Figure 40**

2. Inspect spindle (**Figure 41, item 1**). Replace if worn.
3. Slide bearing (**Figure 41, item 2**) onto spindle.



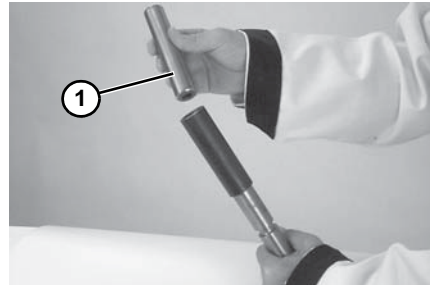
**Figure 41**

4. Slide sleeve (**Figure 42, item 1**) of tool over bearing.



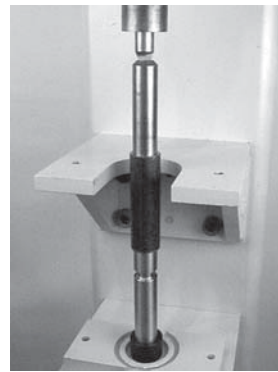
**Figure 42**

5. Place open end of pusher (**Figure 43, item 1**) into sleeve.



**Figure 43**

6. Using an arbor press or similar device, press bearing onto pulley shaft (**Figure 44**).



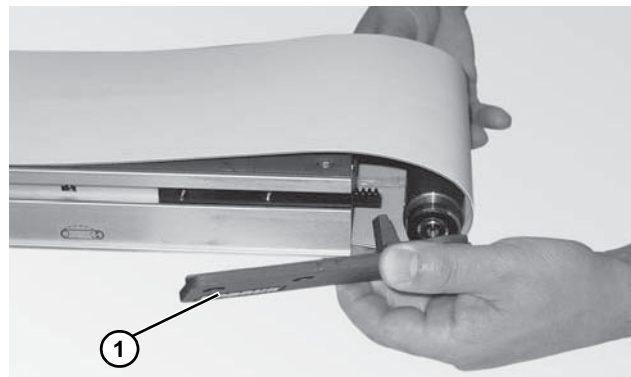
**Figure 44**

7. Repeat steps 1 through 5 for each bearing.

## Drive Pulley and Idler 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 45, 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 45**

# Preventive Maintenance and Adjustment

## 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 46, item 1**) and attach the head plate to the conveyor frame with the two (2) screws removed and hand tighten.

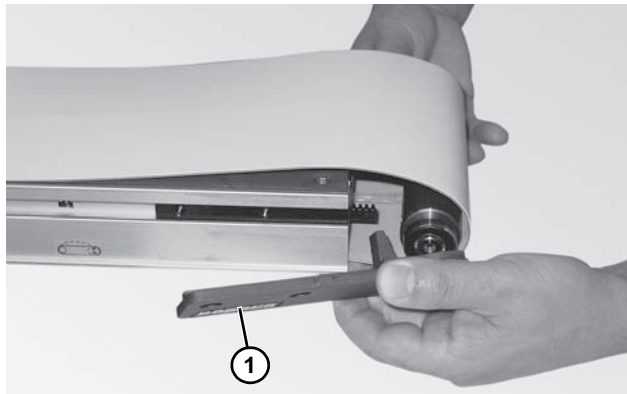


Figure 46

1. Using a support (**Figure 47, item 1**), raise conveyor and stand off the floor.

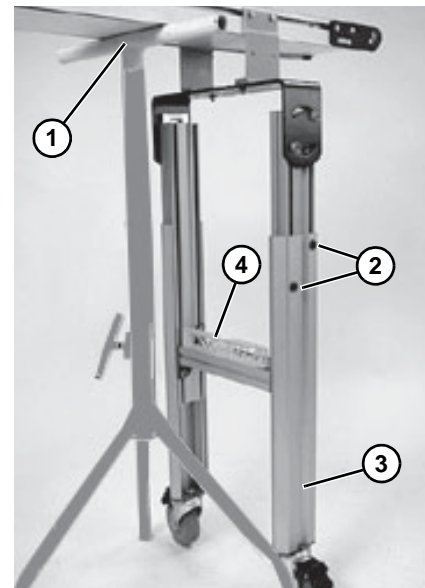



Figure 47


## Stand Height Adjustment

### Height Adjustment for Fixed and Adjustable Height Stands


#### Required Tools

- 6 mm Hex Key Wrench

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

|  |
|--|
| <b>⚠ WARNING</b>   |
|   |
| Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.<br><b>SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.</b> |


2. Loosen button screws (**Figure 47, item 2**).
3. Raise or lower stand leg (**Figure 47, item 3**) to the required height. Level stand from side to side using a level (**Figure 47, item 4**).

|  |
|--|
| <b>⚠ WARNING</b>   |
|   |
| Failure to secure screws ( <b>Figure 47, item 2</b> ) may cause conveyor sections to drop down causing severe injury.<br><b>TIGHTEN SCREWS (Figure 47, item 2) AFTER ADJUSTMENT.</b> |

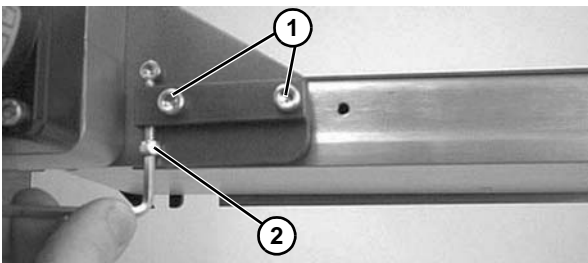
4. Tighten button screws (**Figure 47, item 2**) to 150 in-lb (17 N-m).
5. Repeat steps 2 through 4 on opposite stand leg.

# Preventive Maintenance and Adjustment

## Gearmotor Mounting Package Removal

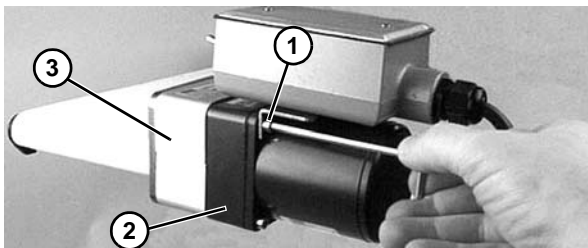
|   |
|---|
| <b>⚠ WARNING</b>  |
|    |
| <b>Exposed moving parts can cause severe injury.</b><br><b>LOCK OUT POWER</b> before removing guards or performing maintenance. |

1. Loosen two (2) screws (**Figure 48, item 1**).



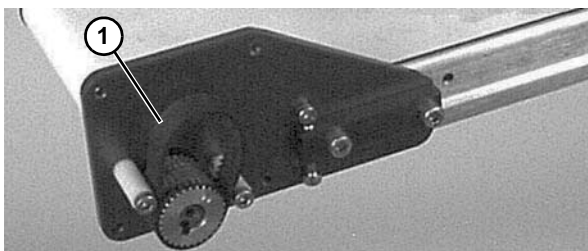
**Figure 48**

2. Loosen timing belt tensioner screw (**Figure 48, item 2**).
3. Remove four (4) screws (**Figure 49, item 1**). Remove gearmotor (**Figure 49, item 2**) and cover (**Figure 49, item 3**).



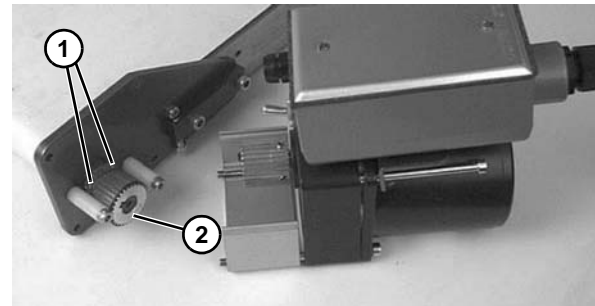
**Figure 49**

4. Remove timing belt (**Figure 50, item 1**).



**Figure 50**

5. Loosen set screws (**Figure 51, item 1**) and remove driven pulley (**Figure 51, item 2**).




**Figure 51**

6. Replace drive or driven pulley. See “Drive or Driven Timing Pulley Replacement” on page 21. Tighten screws to 80 in-lb (9 Nm).
7. Complete steps 5-9 of “Timing Belt Replacement” on page 21. See “Drive or Driven Timing Pulley Replacement” on page 21.

# Preventive Maintenance and Adjustment

## Timing Belt Tensioning

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

1. Loosen two (2) screws (Figure 52, item 1). Tighten timing belt tensioner screw (Figure 52, item 2) to 15 in-lb (1.7 Nm).

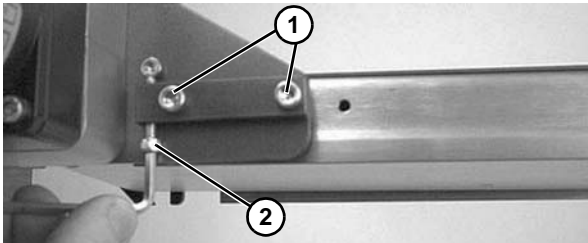



Figure 52

2. Tighten screws (Figure 52, item 1) to 80 in-lb (9 Nm).

## Timing Belt Replacement

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

1. Loosen two (2) screws (Figure 52, item 1).
2. Loosen timing belt tensioner screw (Figure 52, item 2).
3. Remove four (4) screws (Figure 53, item 1). Remove gearmotor (Figure 53, item 2) and top cover (Figure 53, item 3).

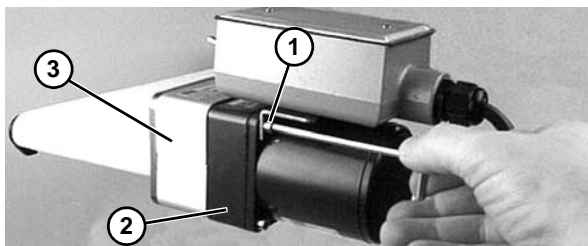


Figure 53

4. Remove old timing belt (Figure 54, item 1).

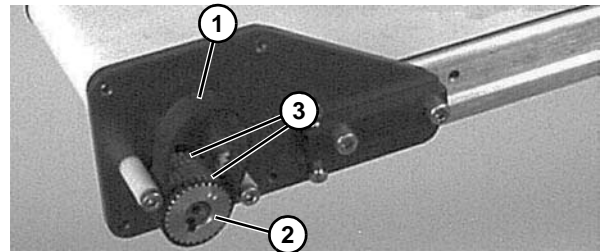


Figure 54

5. Place new timing belt (Figure 54, item 1) over driven pulley (Figure 54, item 2) and between belt flanges (Figure 54, item 3).
6. Insert gearmotor drive pulley into timing belt. Mount assembly with two (2) bottom screws (Figure 55, item 1). Tighten to 45 in-lb (5 Nm).

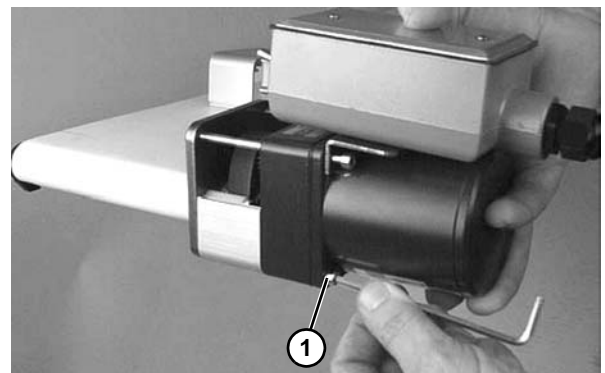



Figure 55

7. Insert top cover (Figure 53, item 3) into bottom cover. Mount assembly with two (2) top screws (Figure 53, item 1). Tighten to 45 in-lb (5 Nm).
8. Tighten timing belt tensioner screw (Figure 52, item 2) to 15 in-lb (1.7 Nm)
9. Tighten screws (Figure 52, item 1) to 80 in-lb (9 Nm).

## Drive or Driven Timing Pulley Replacement

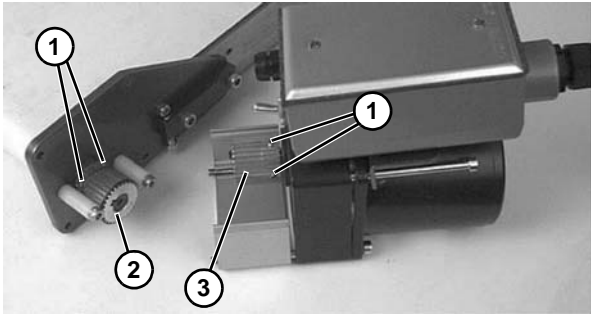
|   |
|---|
| <b>⚠ WARNING</b>  |
|    |
| <b>Exposed moving parts can cause severe injury.</b><br><b>LOCK OUT POWER</b> before removing guards or performing maintenance. |

1. Complete steps 1 through 4 of “Timing Belt Replacement” on page 21.



# Preventive Maintenance and Adjustment

- Loosen set screws (**Figure 56, item 1**) and remove driven pulley (**Figure 56, item 2**) or drive pulley (**Figure 56, item 3**).



**Figure 56**

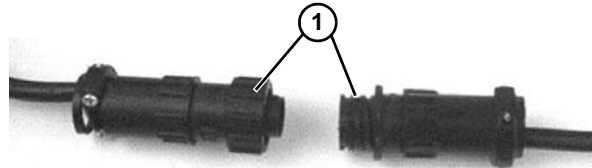
- Replace drive or driven pulley. Tighten set screws to 33 in-lb (3.7 Nm).
- Complete steps 5 through 9 of “Timing Belt Replacement” on page 21.

## Gearmotor Replacement

|   |
|---|
| <b>⚠ WARNING</b>  |
|   |
| <p>Exposed moving parts can cause severe injury.<br/> <b>LOCK OUT POWER</b> before removing guards or performing maintenance.</p> |
| <b>⚠ DANGER</b>   |
|   |
| <p>Hazardous voltage will cause severe injury or death.<br/> <b>LOCKOUT POWER BEFORE</b> before wiring.</p>                       |

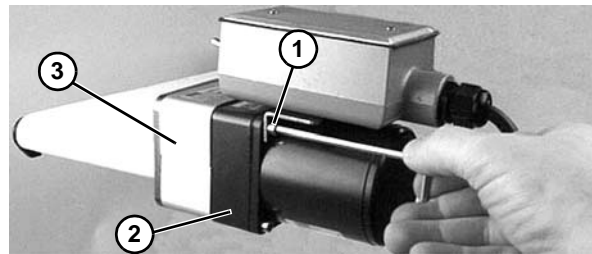
- For single phase motor, unplug power cord from outlet.

- For variable speed motor, unplug cord at disconnect (**Figure 57, item 1**).



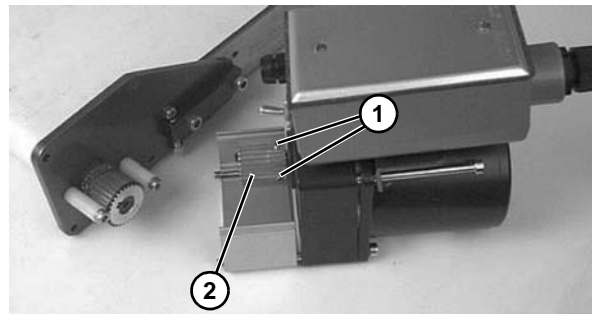
**Figure 57**

- Remove four (4) screws (**Figure 58, item 1**). Remove gearmotor (**Figure 58, item 2**) and top cover (**Figure 58, item 3**).



**Figure 58**

- Loosen set screws (**Figure 59, item 1**) and remove drive pulley (**Figure 59, item 2**).




**Figure 59**

- Replace drive pulley (**Figure 59, item 2**) on new gearmotor and tighten set screws (**Figure 59, item 1**) to 33 in-lb (3.7 Nm).
- Complete steps 5 through 9 of “Timing Belt Replacement” on page 21.
- Replace wiring:
  - For a single phase motor, reverse step 1.
  - For variable speed motor, reverse step 2.

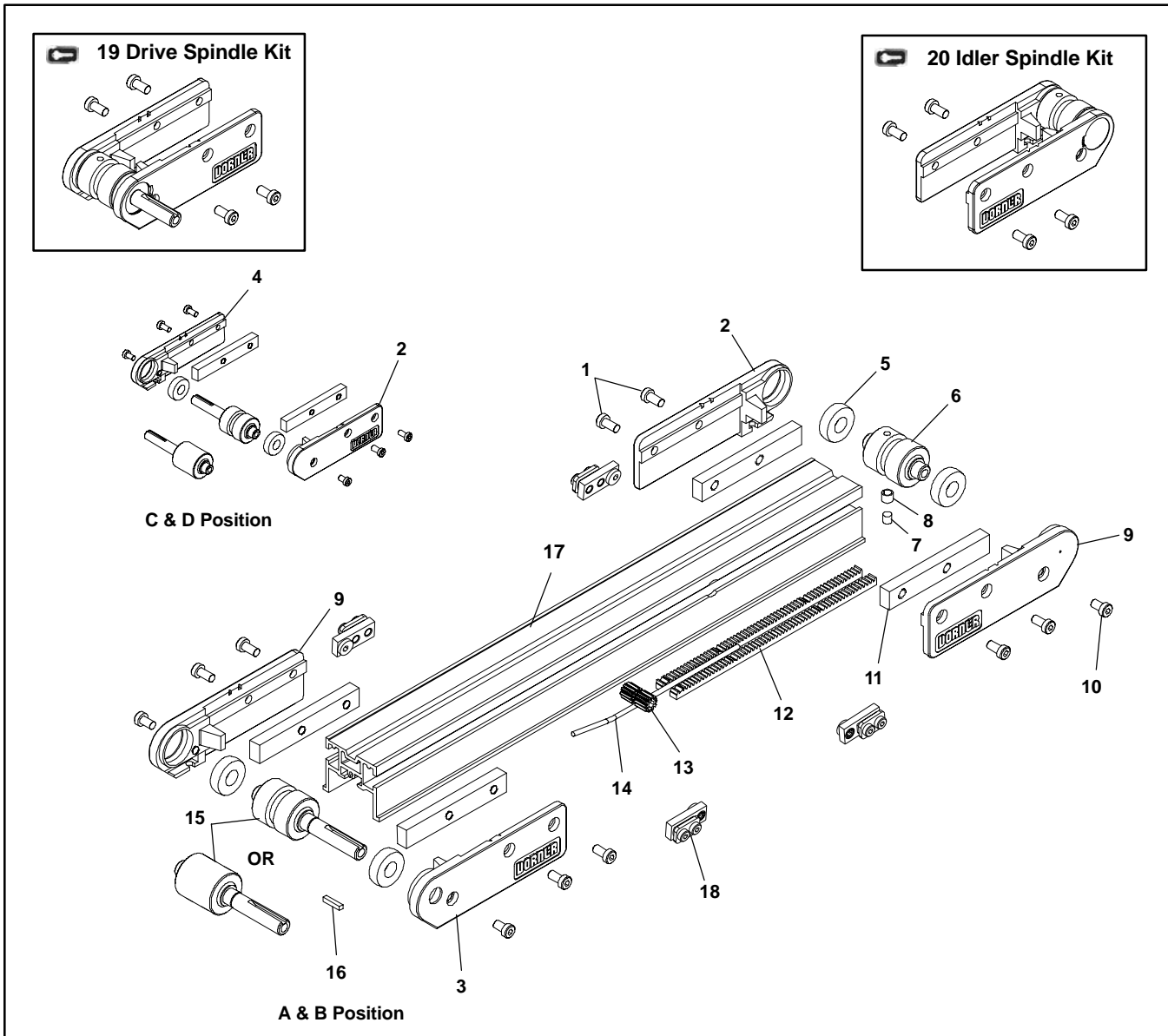


# Service Parts

## 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.

## 2" (51 mm) Wide Conveyor

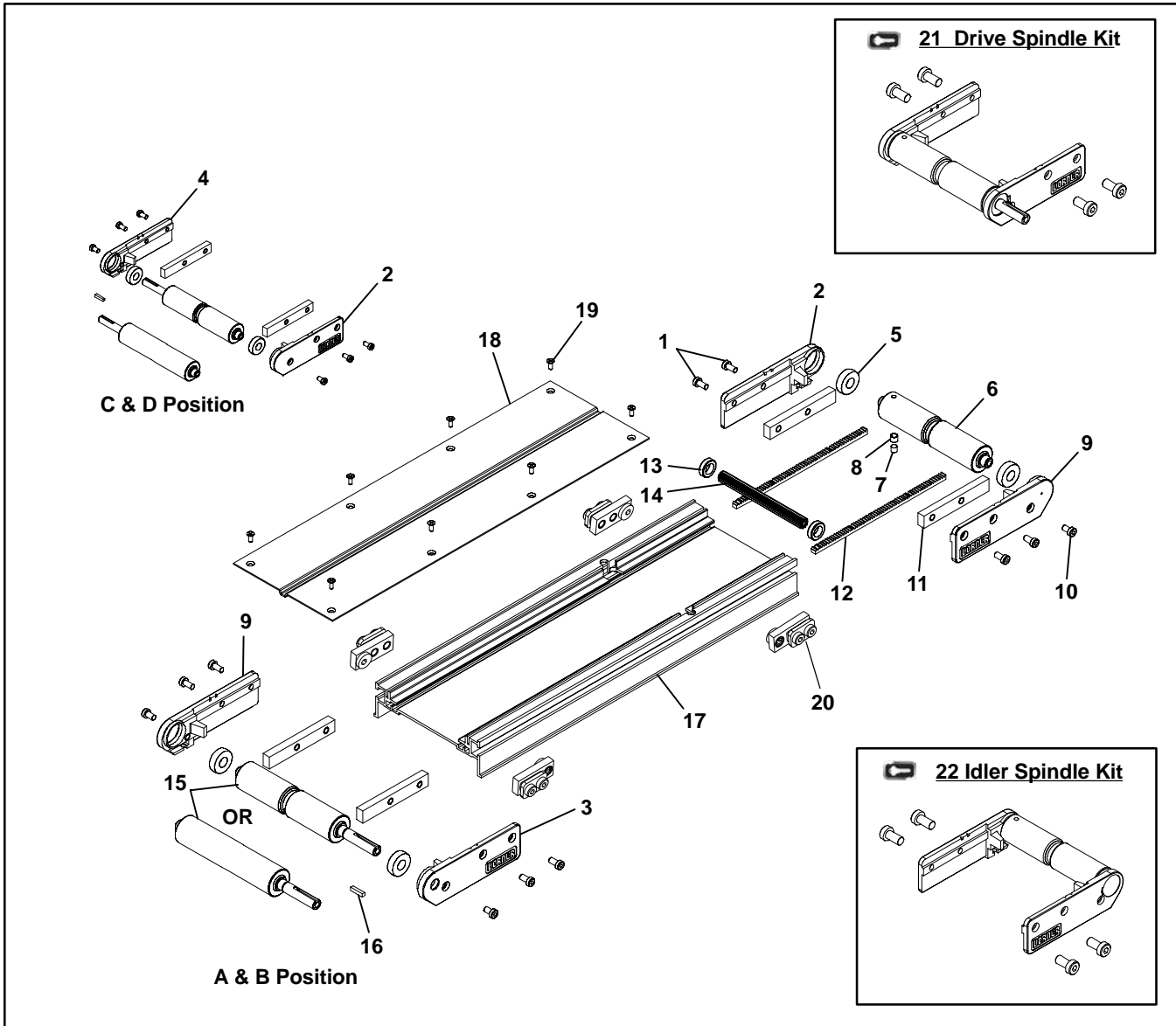




| Item  | Part Number  | Description   |
|---|--------------|---|
| 1   | 920692M      | Socket Head Screw, M6 x 12 mm   |
| 2   | 240425       | Head Plate LH   |
| 3   | 240427       | Head Plate LH Drive Side, Position A and B  |
| 4   | 240428       | Head Plate RH Drive Side, Position C and D  |
| 5   | 22BK2        | Bearing Kit (x2)  |
|   | 22BK4        | Bearing Kit (x4)  |
| 6   | 247302       | Idler Spindle, 2" (51mm)  |
| 7   | 808-020      | Magnet, 0.25" Dia. x 0.25" long Sleeve, 0.25"                                       |
| 8   | 450226SSP    | Magnet Stainless Steel  |
| 9   | 240426       | Head Plate, RH  |
| 10  | 920691M      | Socket Head Screw, M6 x 10mm  |
| 11  | 240329       | Tension Slide Bar   |
| 12  | 240420       | Rack Gear, 14.5 Degree PA x 24 P  |
| 13  | 240423       | Pinion, 2" (51 mm)  |
| 14  | 240422       | Pinion Pin  |
| 15  | 456402       | Drive Spindle, 2" (51 mm)   |
|   | 247602       | Nosebar Drive Spindle, Lagged 2" (51mm)   |
| 16  | 980422M      | Square Key, 4 mm x 22 mm  |
| 17  | 240402-LLLLL | 2" (51mm) Frame   |
| 18  | 240025       | Cam Mounting Assembly   |
| 19  | 22A-02       | Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 15) |
|   | 22D-02       | Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 15) |
| 20  | 22T-02       | Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)                            |
| LLLLL = part length in inches with 2 decimal places |              |   |
| Example: Part Length = 55.08" LLLLL = 05508         |              |   |

# Service Parts

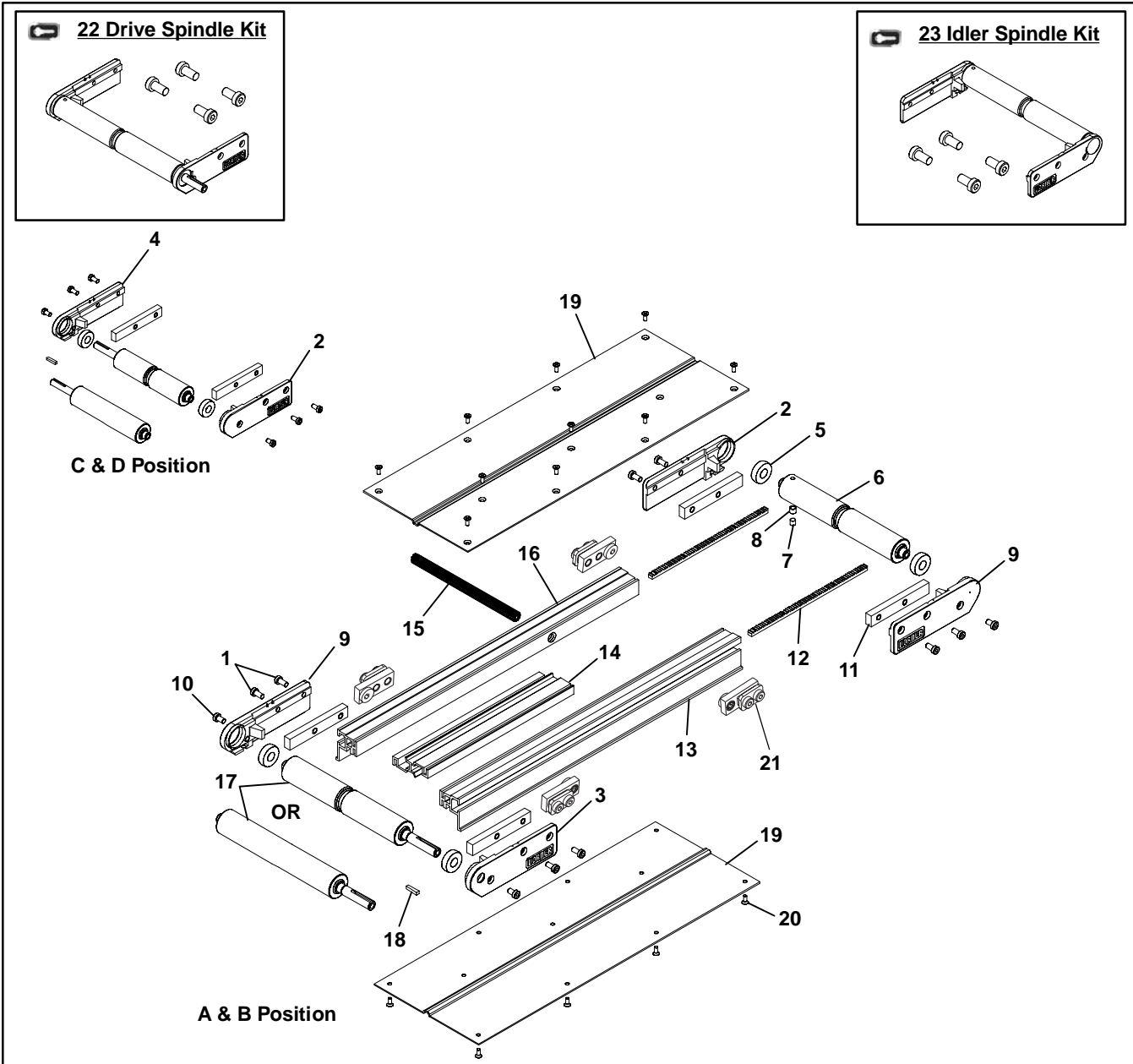
## 3" (76 mm) to 6" (152 mm) Wide Conveyor



| 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,<br>Position A and B   |
| 4   | 240428                               | Head Plate RH Drive Side,<br>Position C and D   |
| 5   | 22BK2                                | Bearing Kit (x2)  |
|   | 22BK4                                | Bearing Kit (x4)  |
| 6   | 2473 <del>WW</del>                   | Idler Spindle   |
| 7   | 808-020                              | Magnet, 0.25" Dia. x 0.25" long   |
| 8   | 450226SSP                            | Sleeve, 0.25" Magnet<br>(Stainless Steel)   |
| 9   | 240426                               | Head Plate RH   |
| 10  | 920691M                              | Socket Head Screw, M6 x 10 mm   |
| 11  | 240329                               | Tension Slide Bar   |
| 12  | 240420                               | Rack Gear, 14.5 Degree PA x 24P   |
| 13  | 240421                               | Pinion Bushing  |
| 14  | 2030 <del>WW</del> M                 | Pinion Gear   |
| 15  | 4564 <del>WW</del>                   | Drive Spindle   |
|   | 2476 <del>WW</del>                   | Nosebar Drive Spindle, Lagged   |
| 16  | 980422MS                             | Square Key, 4 mm x 22 mm  |
| 17  | 2404 <del>WW</del> - <del>LLLL</del> | Conveyor Frame  |
| 18  | 2405 <del>WW</del> - <del>LLLL</del> | Conveyor Bed Plate  |
| 19  | 807-1105                             | Flat Head Torx Screw, M6 x 10 mm  |
| 20  | 240025                               | Cam Mounting Assembly   |
| 21  | 22A- <del>WW</del>                   | Drive Spindle Kit, Position A and B –<br>Grooved (Includes Items 1,2, 3, 5, 9<br>and 15)  |
|   | 22D- <del>WW</del>                   | Drive Spindle Kit, Position C and D –<br>Grooved (Includes Items 1, 2, 4, 5, 9<br>and 15) |
| 22  | 22T- <del>WW</del>                   | Idler Spindle Kit (Includes Items 1, 2<br>and 5 through 10)                               |
| <del>WW</del> = Conveyor width reference: 03, 04, 05, 06      |                                      |   |
| <del>LLLL</del> = part length in inches with 2 decimal places |                                      |   |
| Example: Part Length = 55.08" <del>LLLL</del> = 05508         |                                      |   |

# Service Parts

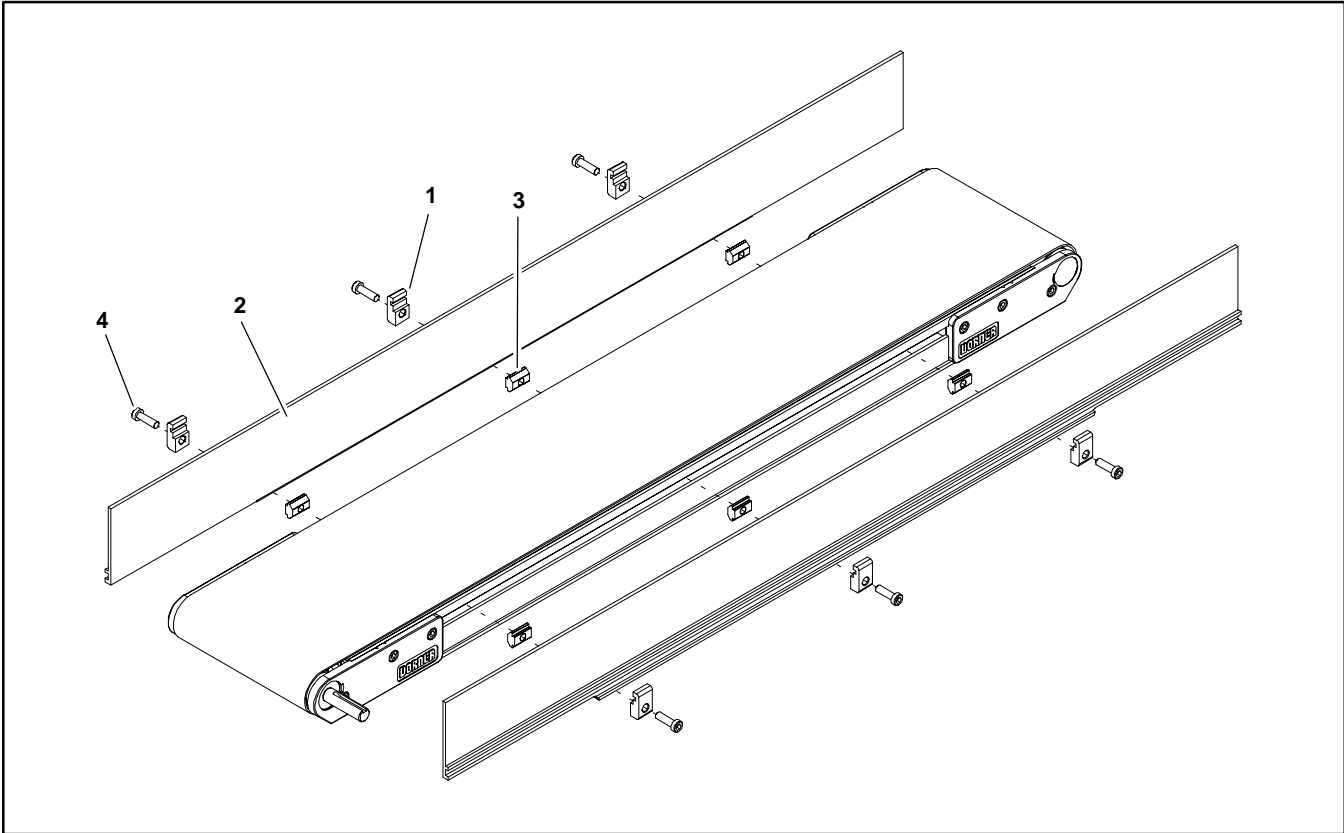
## 8" (203 mm) to 12" (305 mm) Wide Conveyor



| 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   | 2473 <del>WW</del>      | Idler Spindle   |
| 7   | 808-020                 | Magnet, 0.25" Dia. x 0.25" long   |
| 8   | 450226SSP               | Sleeve, 0.25" Magnet Stainless Steel  |
| 9   | 240426                  | Head Plate RH   |
| 10  | 920691M                 | Socket Head Screw, M6 x 10 mm   |
| 11  | 240329                  | Tension Slide Bar   |
| 12  | 240420                  | Rack Gear, 14.5 Degree PA x 24P   |
| 13  | 240412- <del>LLLL</del> | Side Rail, LH   |
| 14  | 240414- <del>LLLL</del> | Center Rail   |
| 15  | 2030 <del>WWM</del>     | Pinion Gear   |
| 16  | 240413- <del>LLLL</del> | Side Rail, RH   |
| 17  | 4564 <del>WW</del>      | Drive Spindle   |
|   | 2476 <del>WW</del>      | Nosebar Drive Spindle, Lagged   |
| 18  | 980422M                 | Square Key, 4 mm x 22 mm  |
| 19  | 2405 <del>WW-LLLL</del> | Side Rail RH  |
| 20  | 807-1105                | Flat Head Torx Screw, M6 x 10 mm  |
| 21  | 240025                  | Cam Mounting Assembly   |
| 22  | 22A- <del>WW</del>      | Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 17) |
|   | 22D- <del>WW</del>      | Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 17) |
| 23  | 22T- <del>WW</del>      | Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)                            |
| <del>WW</del> = Conveyor width reference: 08, 10, 12          |                         |   |
| <del>LLLL</del> = part length in inches with 2 decimal places |                         |   |
| Example: Part Length = 55.08" <del>LLLL</del> = 05508         |                         |   |

# Service Parts

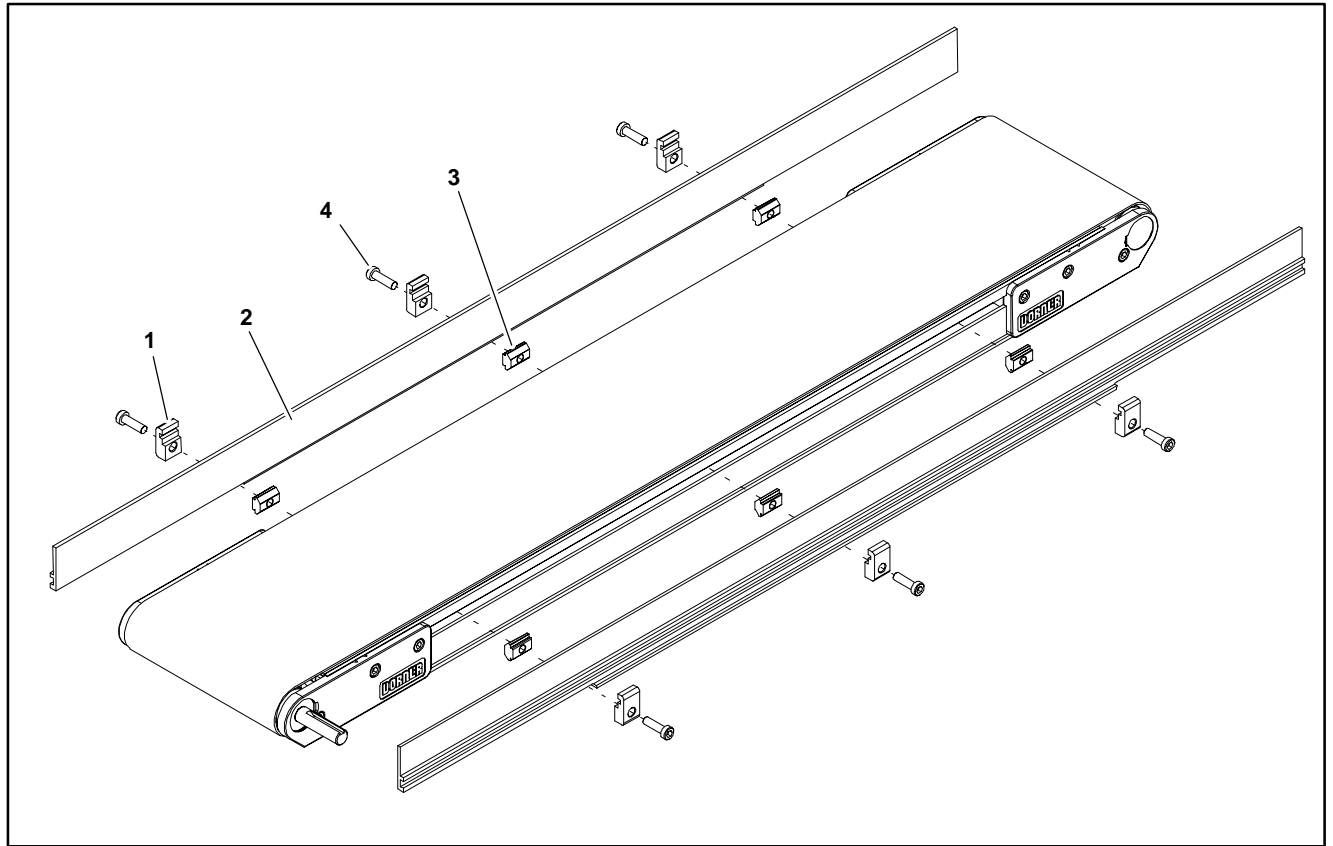
## -04 3" (76 mm) Aluminum Side



| Item | Part Number     | Description                  |
|------|-----------------|------------------------------|
| 1    | 200121          | Guide Retaining Clip         |
| 2    | See Chart Below | 2200 Guide 3" (76mm) HS      |
| 3    | 639971MK10      | Single Drop-in Tee Bar (x10) |
| 4    | 950620M         | Socket Head Screw M6 x 20mm  |

| Item 2: 2200 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 |

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

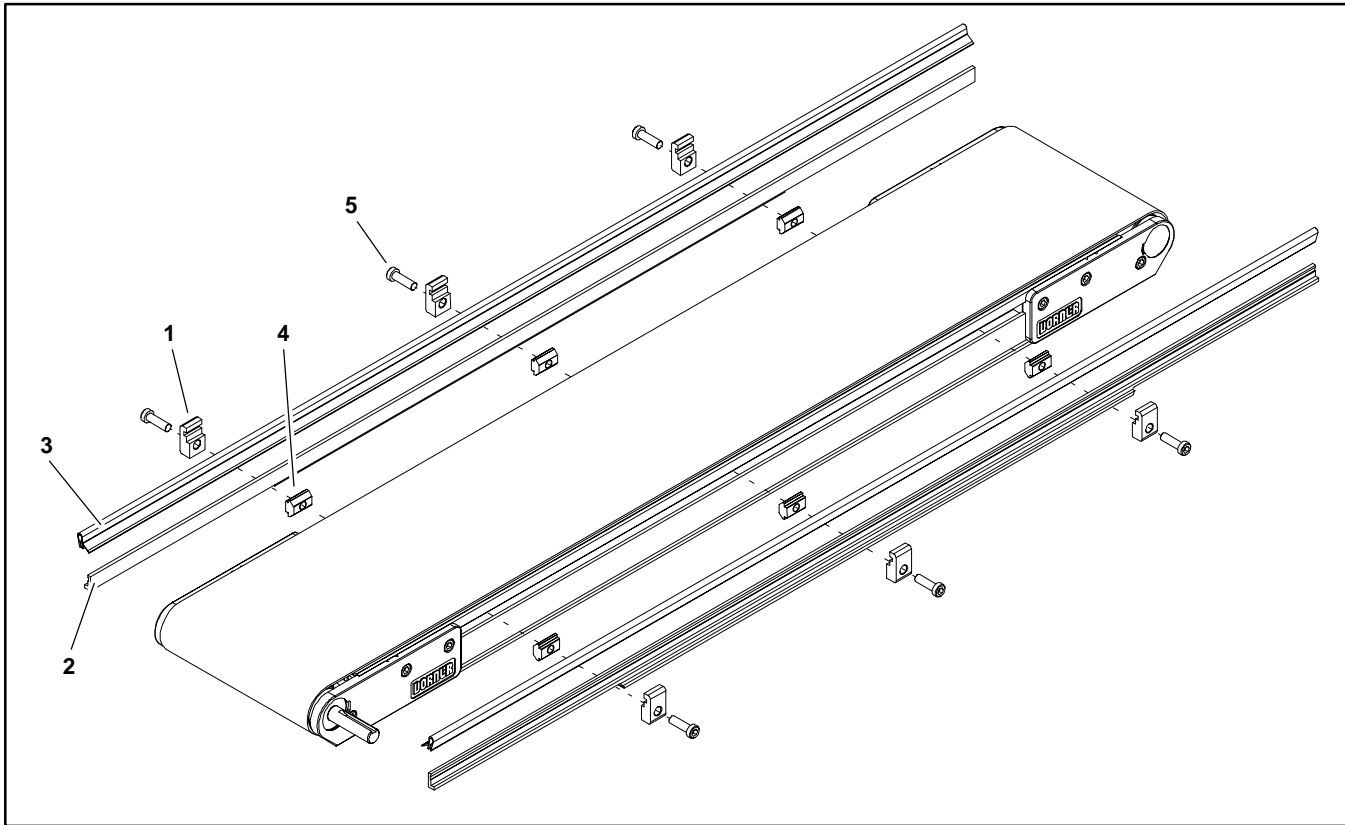


| Item | Part Number     | Description                  |
|------|-----------------|------------------------------|
| 1    | 200121          | Guide Retaining Clip         |
| 2    | See Chart Below | 2200 Guide 3" (76 mm) HS     |
| 3    | 639971MK10      | Single Drop-in Tee Bar (x10) |
| 4    | 950620M         | Socket Head Screw M6 x 20 mm |

| Item 2: 2200 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 |

# Service Parts

## -07 Low to Side Wiper

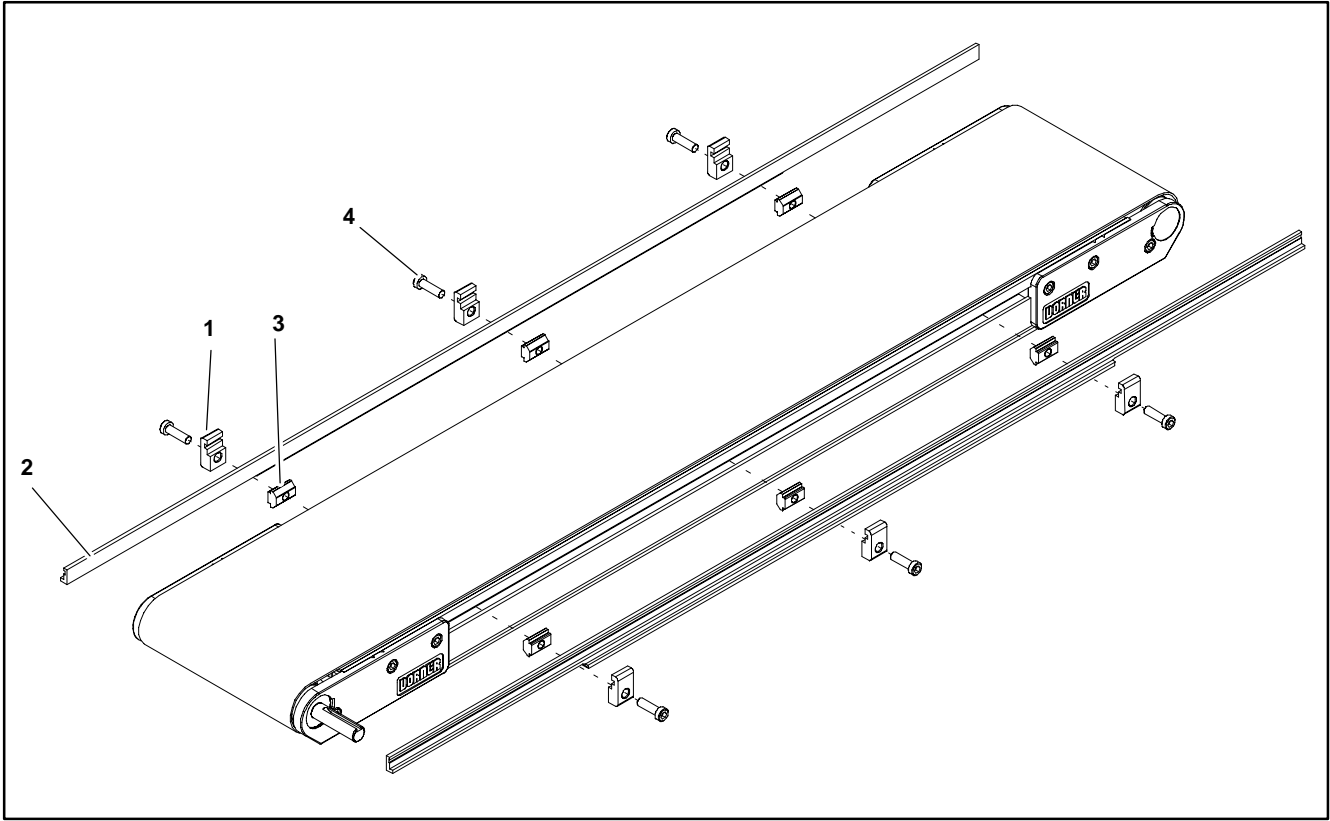


| Item | Part Number     | Description                    |
|------|-----------------|--------------------------------|
| 1    | 200121          | Guide Retaining Clip           |
| 2    | See Chart Below | 2200 Guide 3" (76 mm) HS       |
| 3    | 41-00-24        | Side Wiper Nylatron (per foot) |
| 4    | 639971MK10      | Single Drop-in Tee Bar (x10)   |
| 5    | 950620M         | Socket Head Screw M6 x 20 mm   |

| Item 2: 2200 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 |



## -09 Low to High Side

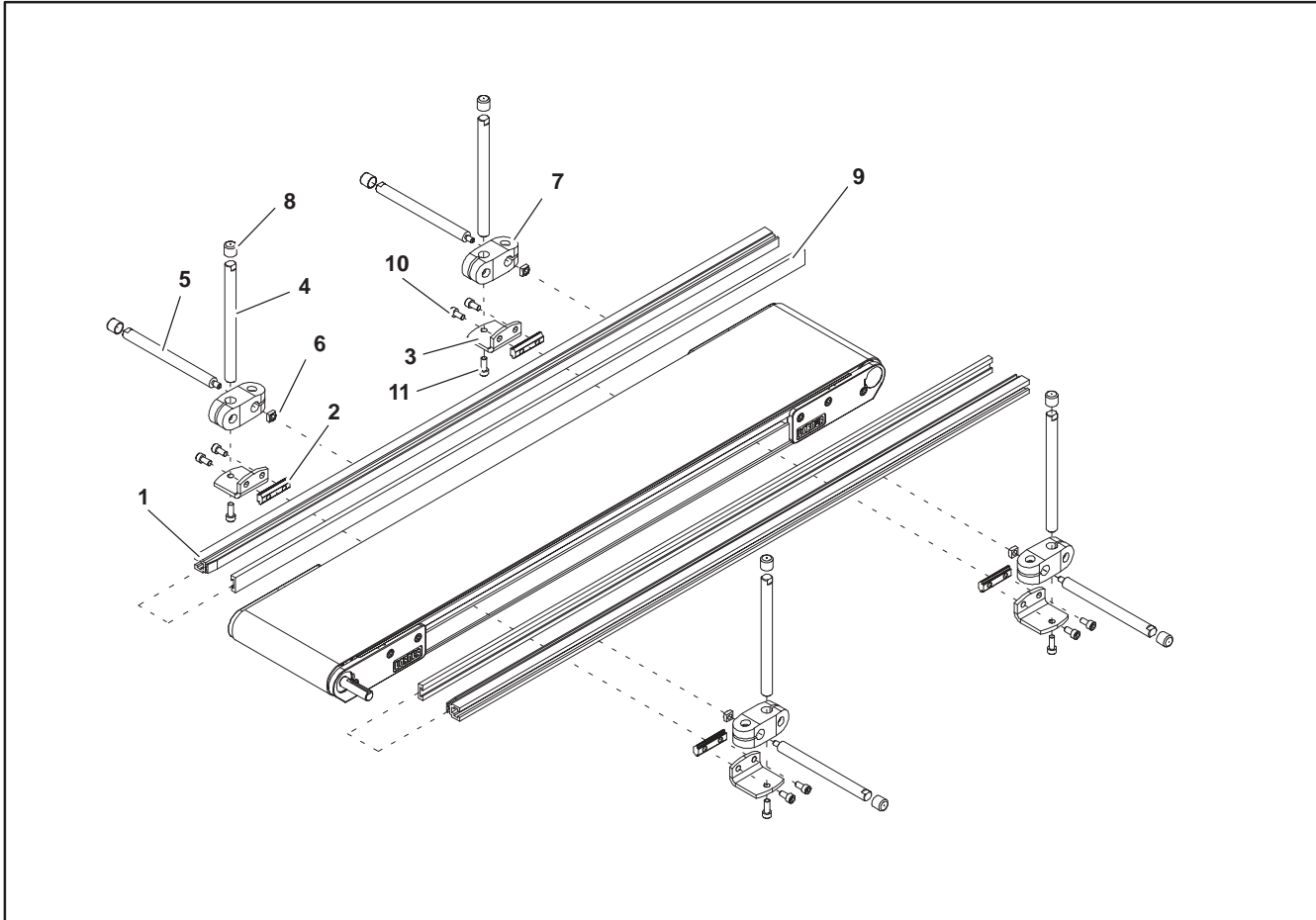


| Item | Part Number     | Description                  |
|------|-----------------|------------------------------|
| 1    | 200121          | Guide Retaining Clip         |
| 2    | See Chart Below | 2200 Guide 3" (76 mm) HS     |
| 3    | 639971MK10      | Single Drop-in Tee Bar (x10) |
| 4    | 950620M         | Socket Head Screw M6 x 20 mm |

| Item 2: 2200 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 |

# Service Parts

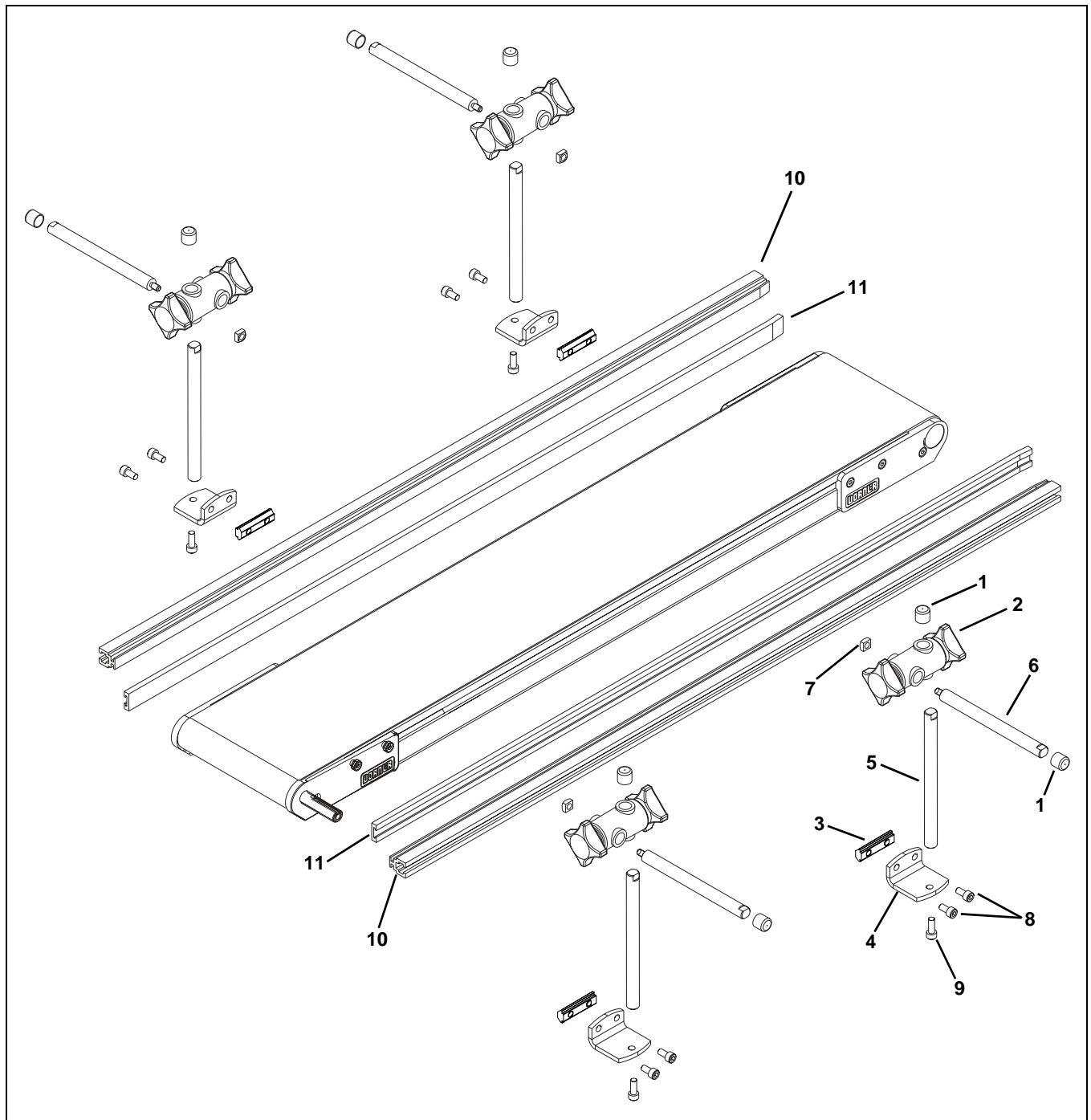
## -13 Adjustable Guiding



| Item | Part Number | Description                         |
|------|-------------|-------------------------------------|
| 1    | 202983      | Aluminum Profile Guide 2' (610 mm)  |
|      | 202984      | Aluminum Profile Guide 3' (914 mm)  |
|      | 202985      | Aluminum Profile Guide 4' (1219 mm) |
|      | 202986      | Aluminum Profile Guide 5' (1524 mm) |
|      | 202987      | Aluminum Profile Guide 6' (1829 mm) |
|      | 202988      | Aluminum Profile Guide 7' (2134 mm) |
|      | 202989      | Aluminum Profile Guide 8' (2438 mm) |

| Item | Part Number | Description                     |
|------|-------------|---------------------------------|
| 2    | 200830M     | Drop-In Tee Bar                 |
| 3    | 202004      | Mounting Bracket                |
| 4    | 202027M     | Guide Mounting Shaft Vertical   |
| 5    | 202028M     | Guide Mounting Shaft Horizontal |
| 6    | 674175MP    | Square Nut                      |
| 7    | 807-652     | Cross Block                     |
| 8    | 807-948     | Vinyl Shaft Cap                 |
| 9    | 614068P     | Flat Extruded Guide (per foot)  |
| 10   | 920612M     | Socket Head Screw M6 x 12 mm    |
| 11   | 920616M     | Socket Head Screw M6 x 16 mm    |

## -14 Tool-Less Adjustable Guiding

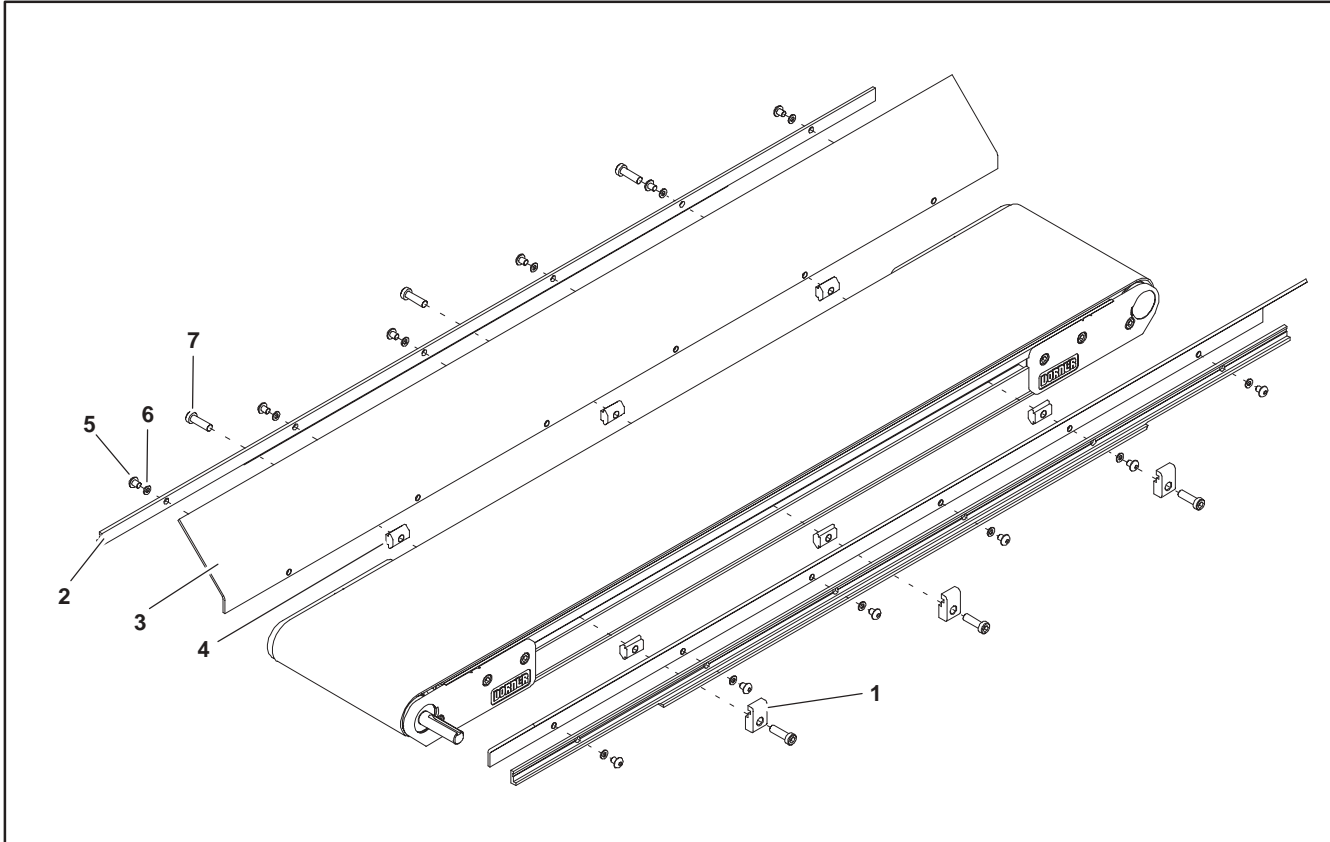


| Item | Part Number | Description                     |
|------|-------------|---------------------------------|
| 1    | 807-948     | Shaft Cap                       |
| 2    | 807-1470    | Cross Block                     |
| 3    | 200830M     | Drop-In Tee Bar                 |
| 4    | 202004M     | Mounting Bracket                |
| 5    | 202027M     | Vertical Mounting Guide Shaft   |
| 6    | 202028M     | Horizontal Mounting Guide Shaft |

| Item  | Part Number   | Description                        |
|---|---------------|------------------------------------|
| 7   | 674175MP      | Square Nut, M6-1.00                |
| 8   | 920612M       | Socket Head Screw, M6-1.00 x 12 mm |
| 9   | 920616M       | Socket Head Screw, M6-1.00 x 16 mm |
| 10  | 460063-LLLLL  | Aluminum Profile Guide             |
| 11  | 614068P-LLLLL | Extruded Guide                     |
| LLLLL = Length in inches with 2 decimal places. |               |                                    |
| Length Example: Length = 95.25" LLLLL = 09525   |               |                                    |

# Service Parts

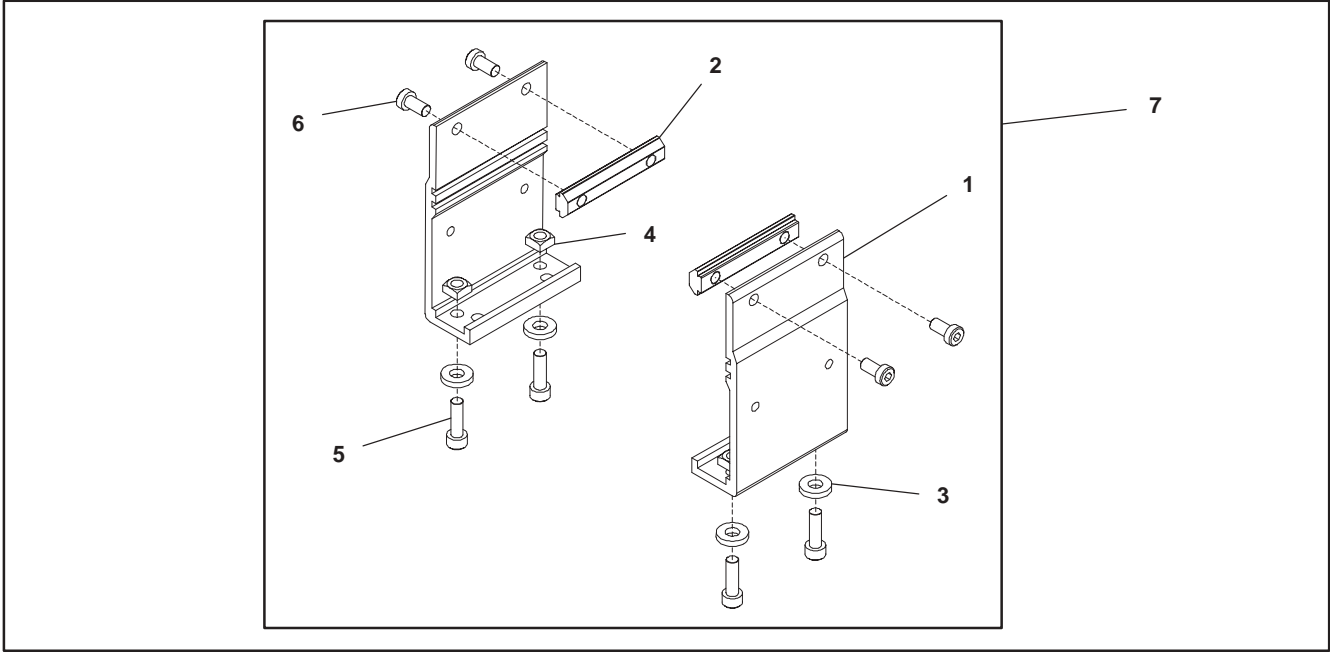
## Flared Side Guiding



| 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    | 639971M     | Drop-In Tee Bar              |
| 5    | 910506M     | Button Head Screw M5 x 6mm   |
| 6    | 911-512     | Washer                       |
| 7    | 950620M     | Cap Low-Head Screw M6 x 20mm |

**Flat Belt Stand Mount Assembly**

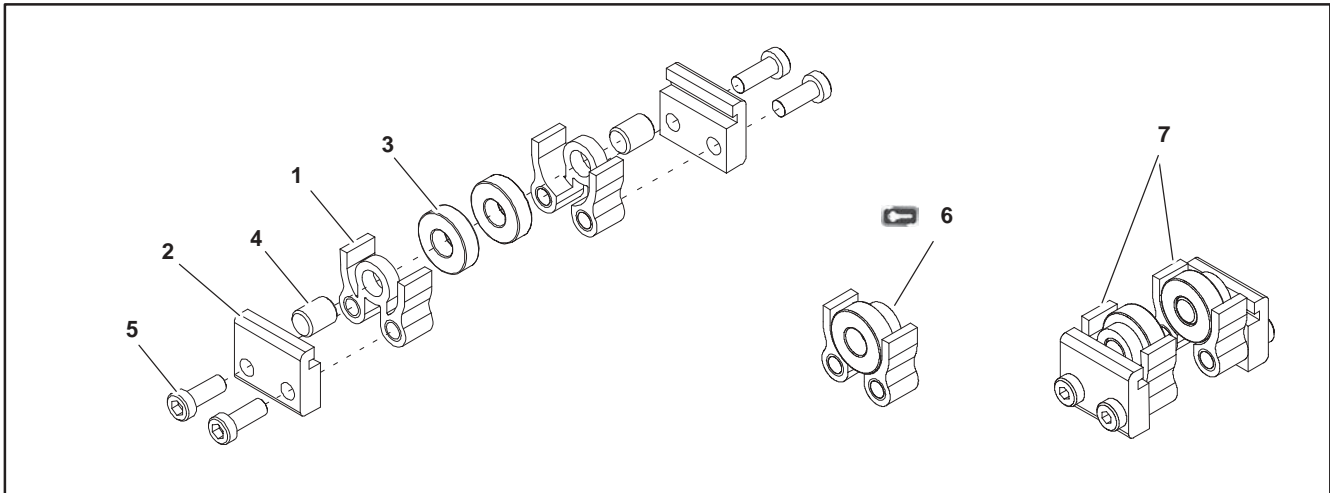


| Item | Part Number | Description          |
|------|-------------|----------------------|
| 1    | 240831      | Stand Mount          |
| 2    | 300150MK4   | Drop-In Tee Bar (x4) |
| 3    | 605279P     | Washer               |
| 4    | 807-920     | Square Nut M6        |

| Item | Part Number | Description                    |
|------|-------------|--------------------------------|
| 5    | 920620M     | Socket Head Screw M6 x 20 mm   |
| 6    | 950612M     | Socket Low Head Screw M6x12 mm |
| 7    | 240839      | Flat Belt Stand Mount Assembly |

# Service Parts

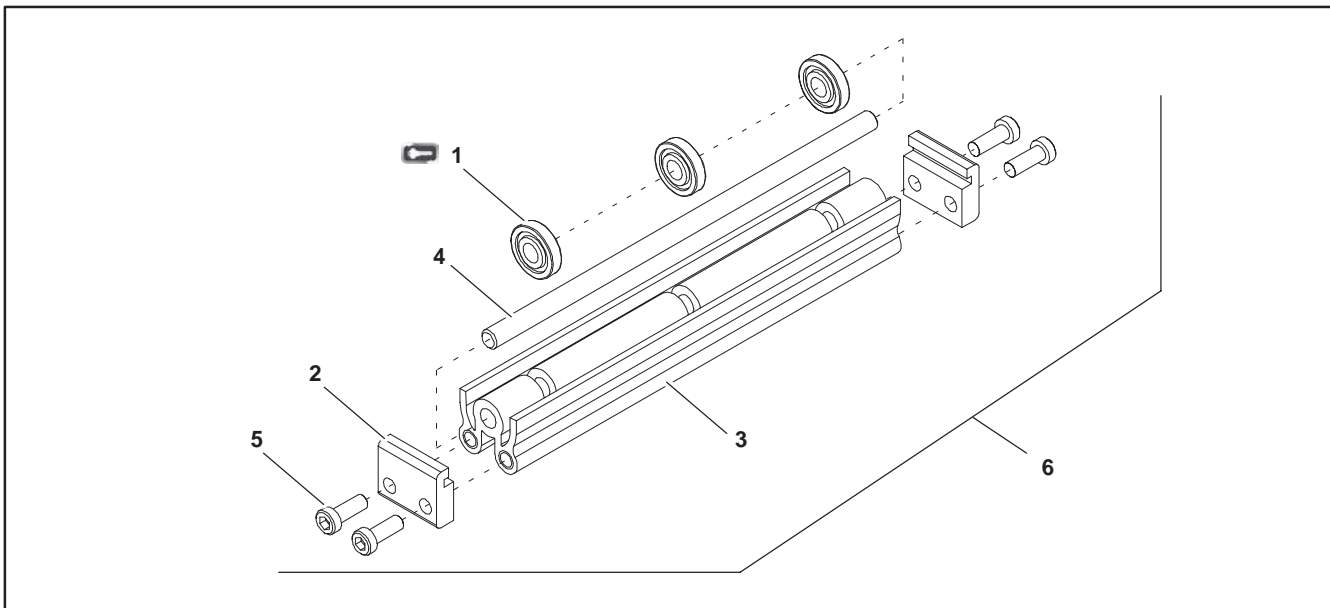
## 2" (51 mm) to 6" (152 mm) Flat Belt Return Roller



| 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    | 950616M     | 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 |

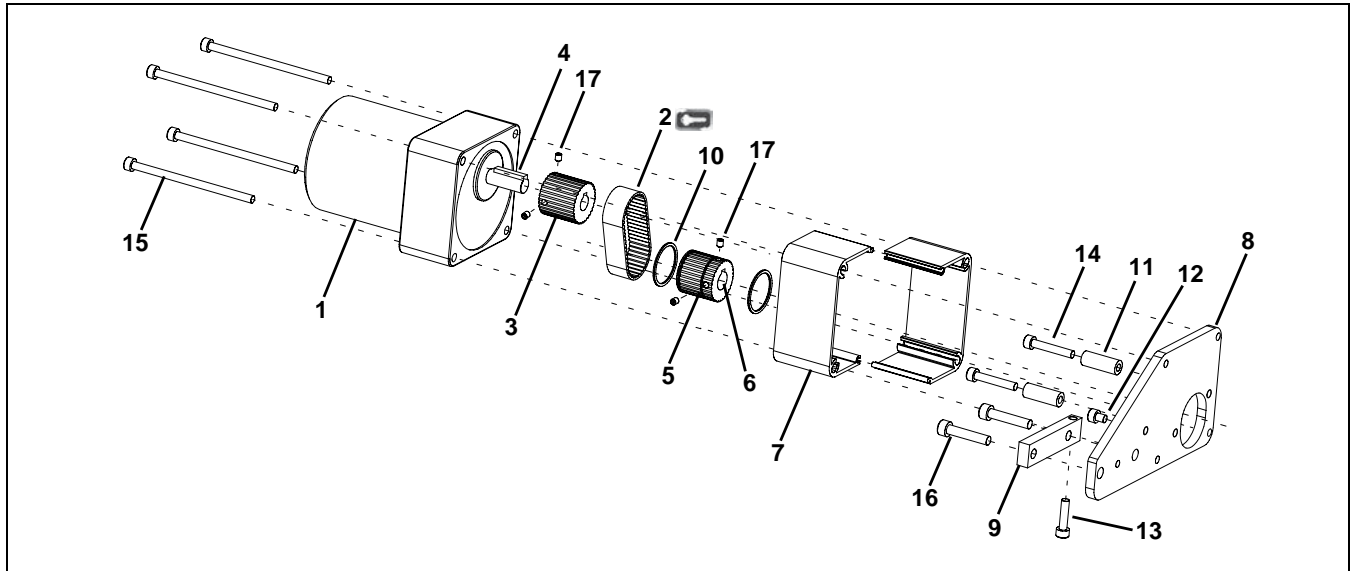
## 8" (203 mm) to 24" (610 mm) Flat Belt Return Roller



| Item | Part Number          | Description                     |
|------|----------------------|---------------------------------|
| 1    | 240826               | Return Roller                   |
| 2    | 240827               | Return Roller Clip              |
| 3    | 2409 $\overline{WW}$ | Return Roller Guard             |
| 4    | 2410 $\overline{WW}$ | Return Roller Rod               |
| 5    | 950616M              | Socket Low Head Screw M6 x 16mm |

| Item  | Part Number          | Description  |
|---|----------------------|--|
| 6   | 2408 $\overline{WW}$ | 8" (203mm) to 24" (610mm) Flat Belt Return Roller Assembly |
| $\overline{WW}$ = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24 |                      |  |

## Gearmotor Mounting Package

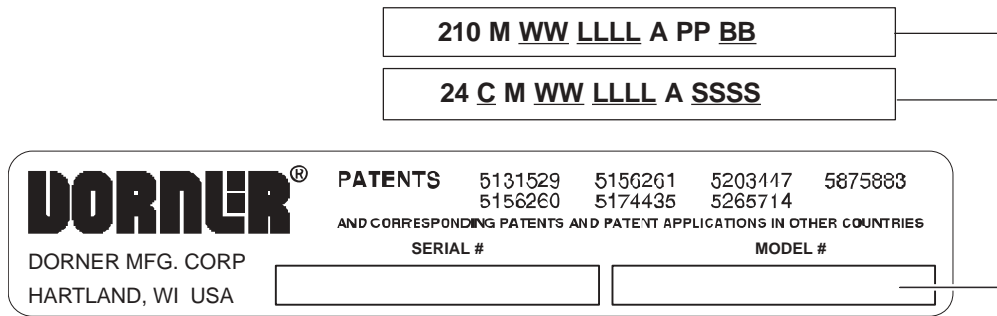


| Item    | Part No.      | Part Description  |
|---------|---------------|---|
| 1       | 62M060PL411FR | Gearmotor, 0.03 hp, 115 Volts, 25 RPM, 60 Hz, 1-Phase, 60:1       |
|         | 62M036PL411FR | Gearmotor, 0.03 hp, 115 Volts, 42 RPM, 60 Hz, 1-Phase, 36:1       |
|         | 62M025PL411FR | Gearmotor, 0.03 hp, 115 Volts, 60 RPM, 1-Phase, 25:1              |
|         | 62M015PL411FR | Gearmotor, 0.03 hp, 115 Volts, 100 RPM, 139 RPM, 1-Phase, 15:1    |
|         | 62M036PL423EN | Gearmotor, 0.03 hp, 230 Volts, 42 RPM, 10 - 60 Hz, 3-Phase, 36:1  |
|         | 62M015PL423EN | Gearmotor, 0.03 hp, 230 Volts, 100 RPM, 10 - 60 Hz, 3-Phase, 15:1 |
|         | 62M009PL423EN | Gearmotor, 0.03 hp, 230 Volts, 167 RPM, 10 - 60 Hz, 3-Phase, 9:1  |
|         | 2             | 814-088   |
| 814-089 |               | Timing Belt, 3mm x 15mm (179mm long)                              |
| 3       | 450078M       | Drive Pulley, 1/2" Bore   |
|         | 450076M       | Drive Pulley, 10mm Bore   |
| 4       | 912-052       | Key, 1/8" x 5/8", 1/2" Bore                                       |
|         | 980422M       | Key, 4mm x 22mm, 10mm Bore  |
| 5       | 450077M       | Driven Pulley, 12 mm Bore   |
| 6       | 980422M       | Driven Pulley Key, 4 mm x 22 mm                                   |

| Item | Part No. | Part Description                   |
|------|----------|------------------------------------|
| 7    | 450087   | Guard, Half, Light Duty Side Drive |
| 8    | 450046M  | Plate, Side Drive LD               |
| 9    | 450088M  | Tensioning Bar, Side Drive         |
| 10   | 807-954  | Spiral Retaining Ring              |
| 11   | 807-973  | Nylon Spacer                       |
| 12   | 920506M  | Socket Head Screw M5x6mm           |
| 13   | 920525M  | Socket Head Screw M5x25mm          |
| 14   | 920530M  | Socket Head Screw M5x30mm          |
| 15   | 920500M  | Socket Head Screw M5x100mm         |
|      | 920590M  | Socket Head Screw M5x90mm          |
|      | 920460M  | Socket Head Screw M4x60mm          |
| 16   | 920635M  | Socket Head Screw M6x25mm          |
| 17   | 970405M  | Cup Set Screw M4x5mm               |

# Service Parts

## Conveyor Belt Part Number Configuration



**Figure 60**

### Flat Belt Part Number Configuration

Refer to Dorner patent plate (**Figure 60**). 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 60**). 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.


| Product Type        |   |                                |                |             |                        |                                    |  |                             |                           |
|---------------------|---|--------------------------------|----------------|-------------|------------------------|------------------------------------|--|-----------------------------|---------------------------|
| Standard Products   |   |                                |                |             |                        |                                    |  |                             | Engineered to order parts |
| Product Line        | Conveyors   | Gearmotors & Mounting Packages | Support Stands | Accessories | Spare Parts (non-belt) | Spare Belts - Standard Flat Fabric | Spare Belts - Cleated & Specialty Fabric | Spare Belts - Plastic Chain | All equipment and parts   |
| 1100                | 30% return fee for all products except:<br>50% return fee for conveyors with modular belt,<br>cleated belt or specialty belts |                                |                |             |                        |                                    | non-returnable                           |                             | case-by-case              |
| 2200                |   |                                |                |             |                        |                                    |  |                             |                           |
| 2200 Modular Belt   |   |                                |                |             |                        |                                    |  |                             |                           |
| 2200 Precision Move |   |                                |                |             |                        |                                    |  |                             |                           |
| 2300                |   |                                |                |             |                        |                                    |  |                             |                           |
| 2300 Modular Belt   |   |                                |                |             |                        |                                    |  |                             |                           |
| 3200                |   |                                |                |             |                        |                                    |  |                             |                           |
| 3200 LPZ            |   |                                |                |             |                        |                                    |  |                             |                           |
| 3200 Precision Move |   |                                |                |             |                        |                                    |  |                             |                           |
| 4100                |   |                                |                |             |                        |                                    |  |                             |                           |
| 5200                |   |                                |                |             |                        |                                    |  |                             |                           |
| 5300                |   |                                |                |             |                        |                                    |  |                             |                           |
| 6200                |   |                                |                |             |                        |                                    |  |                             |                           |
| Controls            |   |                                |                |             |                        |                                    |  |                             |                           |
| 7200 / 7300         | 50% return fee for all products   |                                |                |             |                        |                                    |  |                             |                           |
| 7350                | non-returnable  |                                |                |             |                        |                                    |  |                             |                           |
| 7360                |   |                                |                |             |                        |                                    |  |                             |                           |
| 7400                |   |                                |                |             |                        |                                    |  |                             |                           |
| 7600                |   |                                |                |             |                        |                                    |  |                             |                           |

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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|---|--|---|