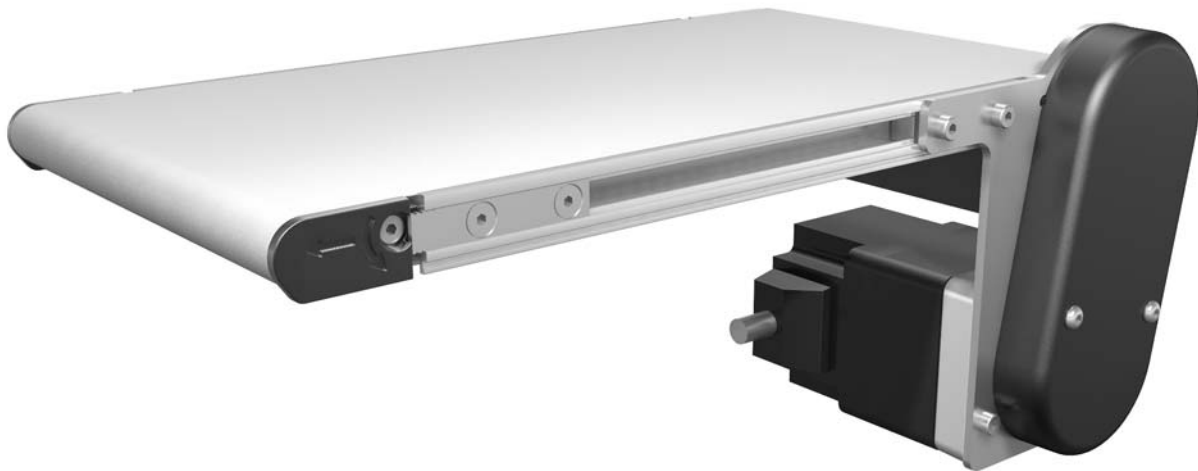




1100 Series End Drive Conveyors

Installation, Maintenance & Parts Manual



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

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

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

For other service manuals visit our website at:
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IMPORTANT

<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 1100 series conveyors have patents pending.

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	Bottom Mount
3	Gearmotor
4	Guiding
5	Mounting Brackets
6	Return Rollers

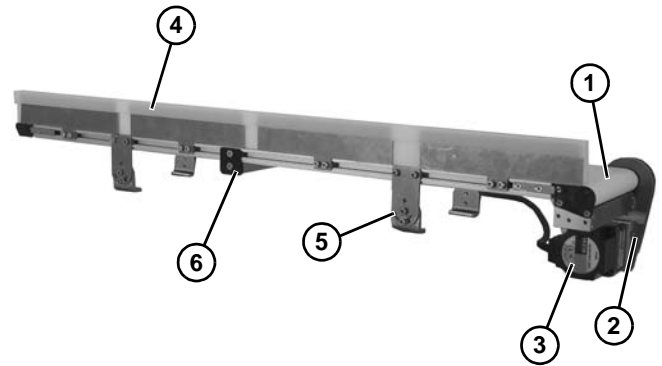
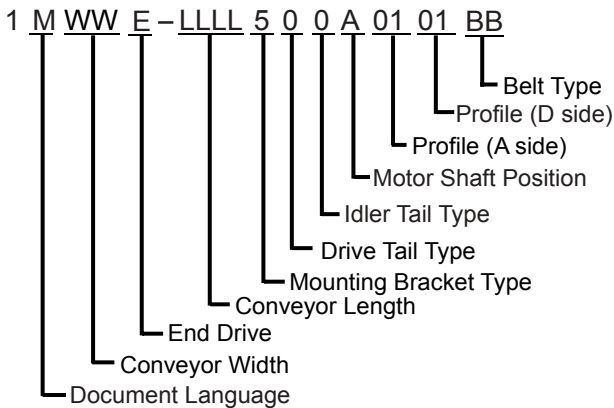


Figure 1

Specifications

Models:

1100 Series End Drive Conveyor



Conveyor Supports:

Maximum Distances:

- 1 = 18" (457 mm)
- 2 = 36" (914 mm)
- 3 = 18" (457 mm)

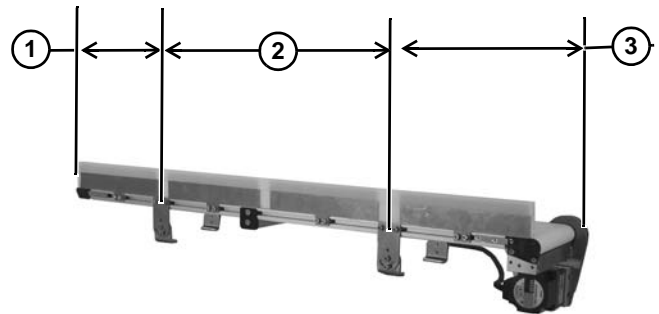


Figure 2

Specifications

Specifications:

Conveyor Width Reference (WW)	02	04	06	08	10
Conveyor Belt Width	1.75" (44 mm)	3.75" (95 mm)	6" (152 mm)	8" (203 mm)	10" (254 mm)
Maximum Conveyor Load* (See NOTE Below)	15 lb (6.8 kg)				
Conveyor Startup Torque*	1.5 in-lb (0.17 Nm)	2 in-lb (0.22 Nm)	2.5 in-lb (0.28 Nm)	3 in-lb (0.34 Nm)	4 in-lb (0.45 Nm)
Belt Travel	3.1" (79 mm) per revolution of pulley				
Maximum Belt Speed	65.4 ft/minute (19.9 m/minute)				
Conveyor Belt Reference (LLLL)	0088 to 0600 in 0001 increments				
Conveyor Length (Feet)	0.88 ft (268 mm) to 6 ft (1829 mm) in 0.12" (0.31 mm) increments				

* See Ordering and Specifications Catalog for details.

NOTE

Maximum conveyor loads based on:

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

NOTE

Conveyor comes assembled with mount package and gearmotor attached. If maintenance is needed to the components see 1100 Series End Drive Mounting Package manual 851-748.

NOTE

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

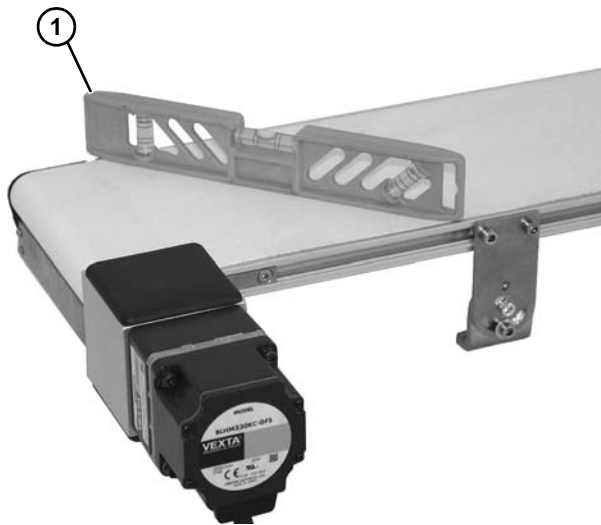


Figure 3

Installation Component List

<ul style="list-style-type: none"> Conveyor frame Conveyor brackets (4x) Return rollers (for longer conveyors)

Required Tools

- Hex-key wrenches:
2 mm, 2.5 mm, 3 mm, 4 mm
- Level
- Needle nose pliers
- Torque wrench

Recommended Installation Sequence

- Attach mounting brackets to conveyor
- Attach conveyor to stands
- Install return rollers on conveyor
- Attach guides/accessories (see page 32 through page 52 of “Service Parts” section for details)

Mounting Brackets

Standard Mounting Bracket

1. Locate short or tall mounting brackets. Exploded views shown in Figure 4 & Figure 5.

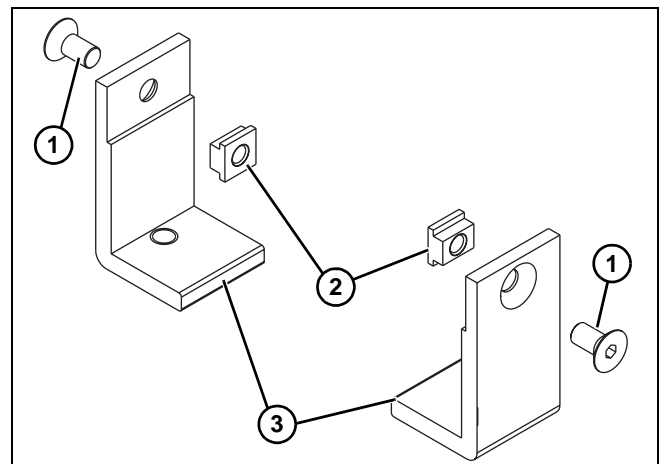


Figure 4

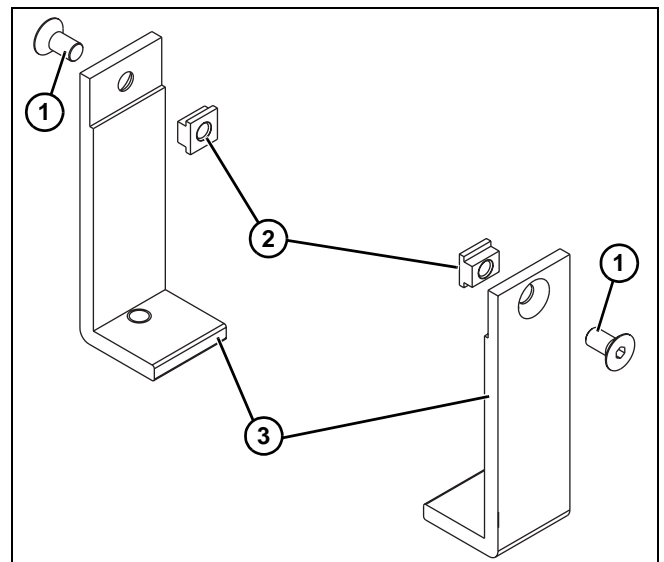


Figure 5

2. Remove screws (**Figure 4, item 1**) or (**Figure 5, item 1**), and T-bars (**Figure 4, item 2**) or (**Figure 5, item 2**) from short brackets (**Figure 4, item 3**) or tall brackets (**Figure 5, item 3**).

Installation

Pivoting Mounting Bracket

1. Locate pivoting brackets. Exploded view shown in Figure 6.

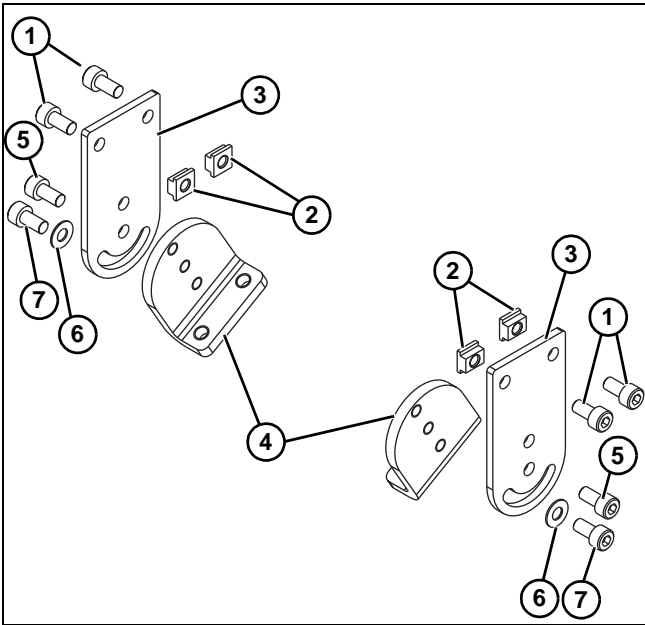


Figure 6

2. Remove screws (Figure 6, item 1) and T-bars (Figure 6, item 2) from flat mounting brackets (Figure 6, item 3).
3. Install angled mounting brackets (Figure 6, item 4) onto flat mounting brackets (Figure 6, item 3) on top end with screws (Figure 6, item 5). On bottom, install washer (Figure 6, item 6) with screw (Figure 6, item 7).

Install Mounting Brackets

1. For standard mounting brackets, insert one T-bar (Figure 7, item 1), or pivoting mounting brackets, install two T-bars (Figure 7, item 1) into conveyor side slots (Figure 7, item 2).

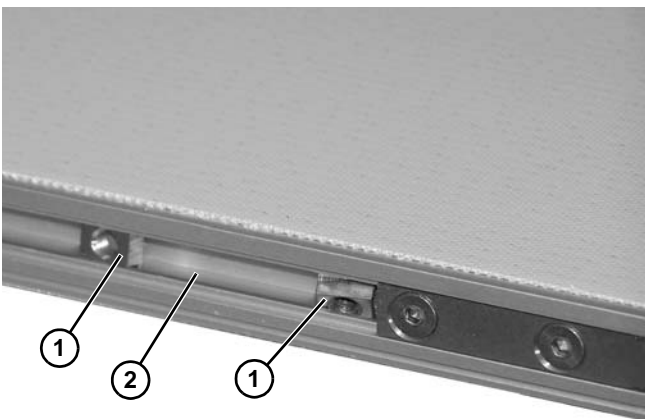


Figure 7

NOTE

Installing pivoting mounting brackets onto conveyor shown below.

2. Fasten brackets (Figure 8, item 1) to support stand with mounting screws (Figure 8, item 2).

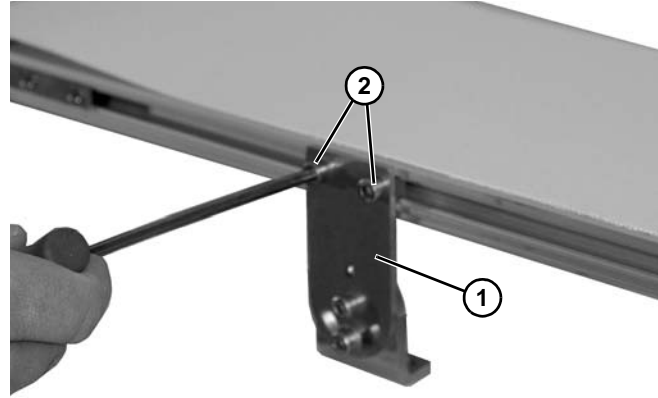


Figure 8

3. Tighten screws (Figure 8, item 2) to 60 in-lb (7 Nm).
4. To adjust angle of pivoting bracket (Figure 9, item 1) loosen screw (Figure 9, item 2) and rotate pivoting bracket to desired position.

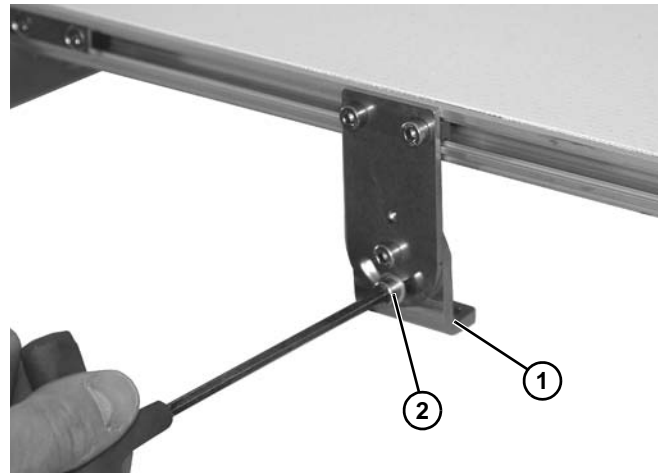


Figure 9

5. Tighten screw (Figure 9, item 2) to 15 in-lb (1.7 Nm).

Return Rollers

1. Locate return rollers. Exploded view shown in Figure 10.

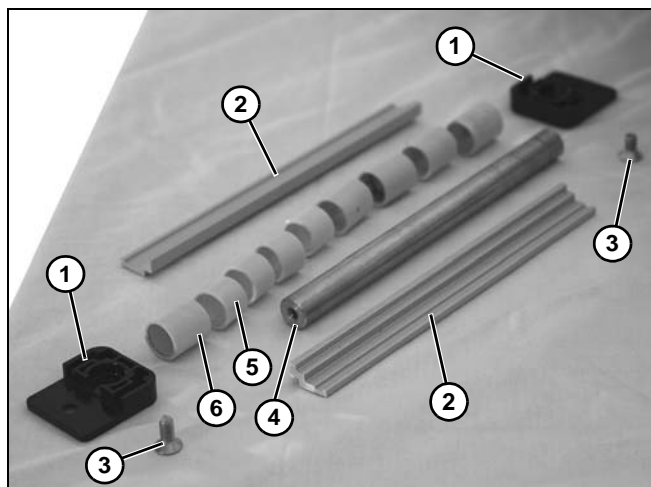


Figure 10

- | | |
|---|---------------------|
| 1 | Return Roller Clip |
| 2 | Return Roller Guard |
| 3 | Screw |
| 4 | Return Roller Rod |
| 5 | Roller (Short) |
| 6 | Roller (Long) |

2. Remove screws (**Figure 10, item 3**) from roller assembly.

3. Insert one T-bar (**Figure 11, item 1**) into conveyor side slots (**Figure 11, item 2**) with a needle nose pliers.

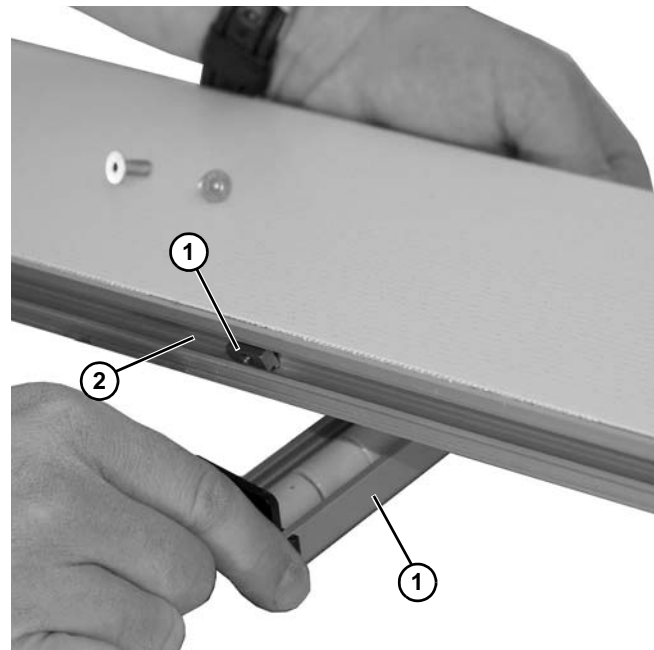


Figure 11

4. Install roller assembly (**Figure 11, item 1**) as shown.
5. Install and tighten screws (**Figure 12, item 1**) to 15 in-lb (1.7 Nm).

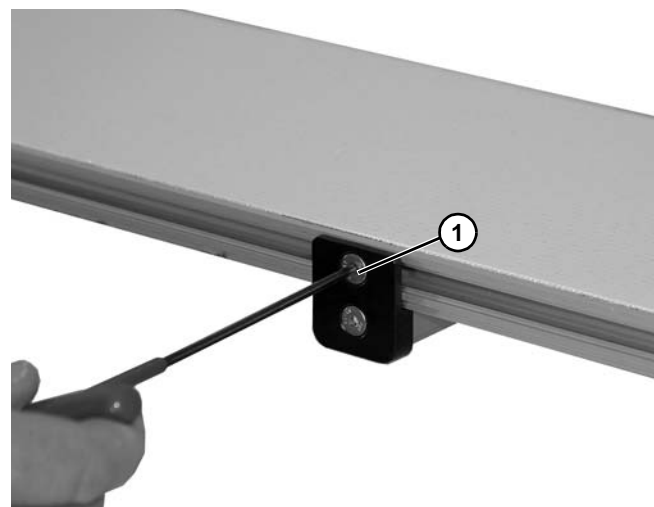


Figure 12

Installation

Guiding

1. Insert two T-bars (Figure 13, item 1) into conveyor side slots (Figure 13, item 2).

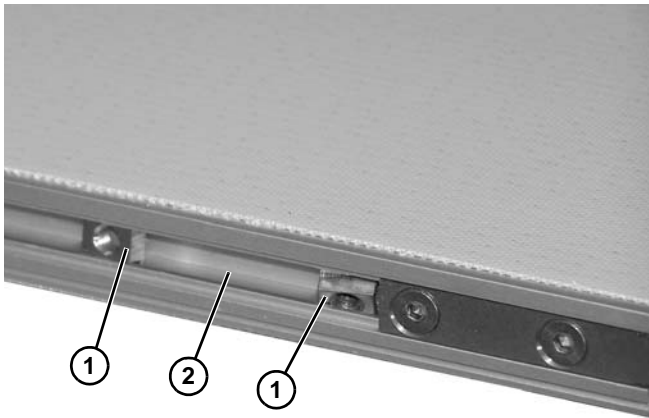


Figure 13

2. Install guiding support bracket (Figure 14, item 1) with two screws (Figure 14, item 2).

NOTE

2" profile shown below. For other guide profile layouts see pages page 25 thru page 26.

NOTE

Space support brackets evenly along conveyor as shown in (Figure 15).

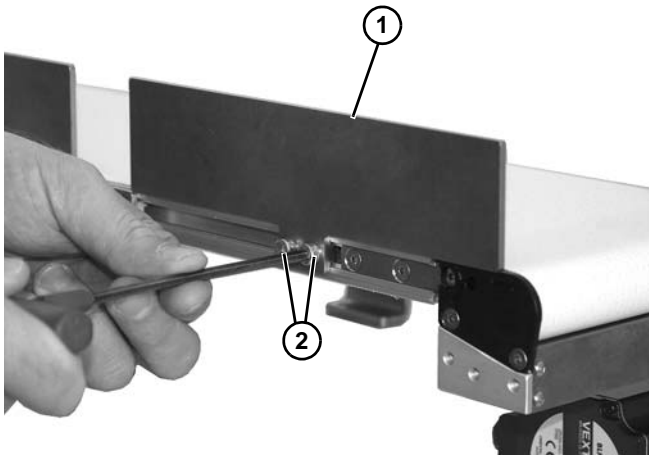


Figure 14

3. Install guide (Figure 15, item 1) onto guiding support bracket (Figure 15, item 2).

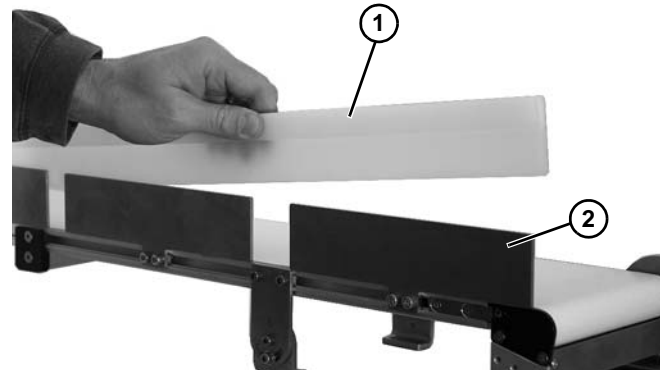


Figure 15

Preventive Maintenance and Adjustment

Required Tools

Standard Tools

- Hex-key wrenches:
2 mm, 2.5 mm, 3 mm, 4 mm
- Level
- Needle nose pliers
- Torque wrench

Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner
- Clean entire conveyor and lagged 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

Surface cuts and wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:

- Excessive load on belt
- Conveyor belt is not properly tensioned
- Impacted dirt on drive pulley
- Intermittent jamming or drive train problems
- Gears worn or slipping on shaft

Cleaning

IMPORTANT

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

Use Dornier Belt Cleaner. Mild soap and water may also be used. Do not soak the belt.

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
- Install new conveyor belt
- Tension conveyor belt

Belt Removal

1. Place temporary support stands at both ends of the conveyor.
2. Loosen two screws (**Figure 16, item 1**) on both sides of conveyor.

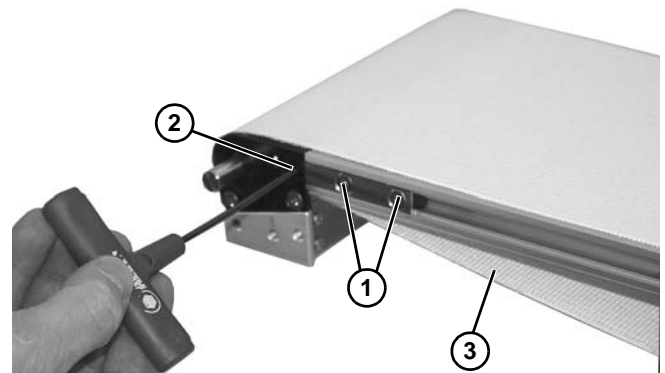


Figure 16

3. Rotate tensioning screw (**Figure 16, item 2**) to lessen tension on belt (**Figure 16, item 3**).

Preventive Maintenance and Adjustment

4. Remove two screws (**Figure 17, item 1**) on each side of conveyor holding pinch drive assembly (**Figure 17, item 2**).

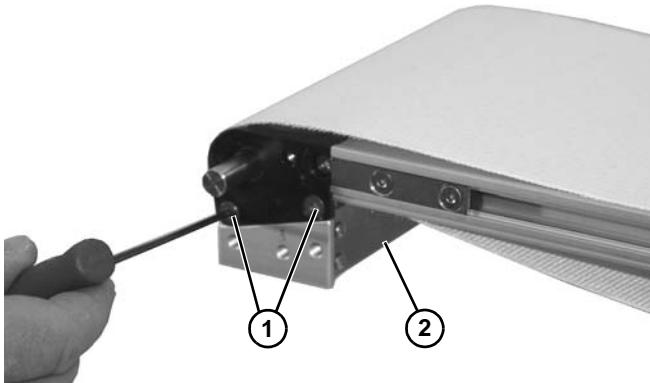


Figure 17

5. Lower pinch drive (**Figure 18, item 2**) from conveyor.

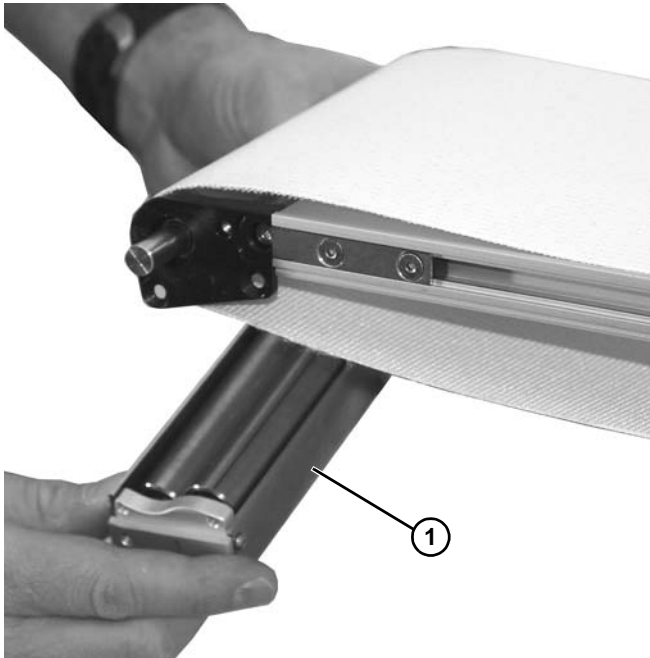


Figure 18

6. Remove screw (**Figure 19, item 1**) on each side of conveyor.

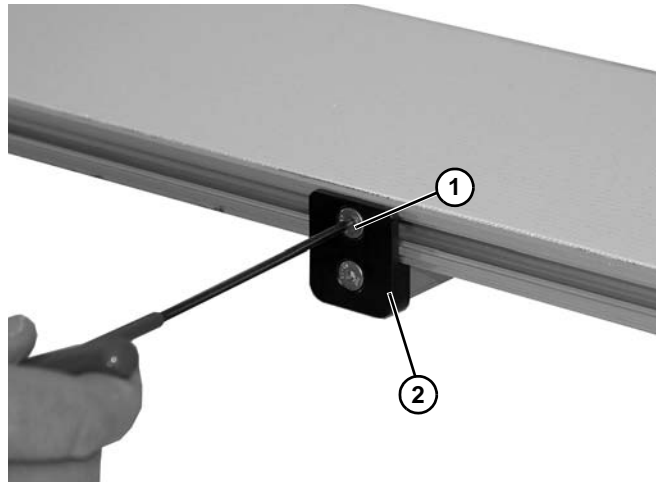


Figure 19

7. Lower return roller assembly (**Figure 19, item 2**) from conveyor frame.
8. Remove two screws (**Figure 20, item 2**) and remove mounting brackets (**Figure 20, item 1**) from one side of conveyor. (Reverse steps 3 & 4 of “Install Mounting Brackets” section beginning on page 8.)

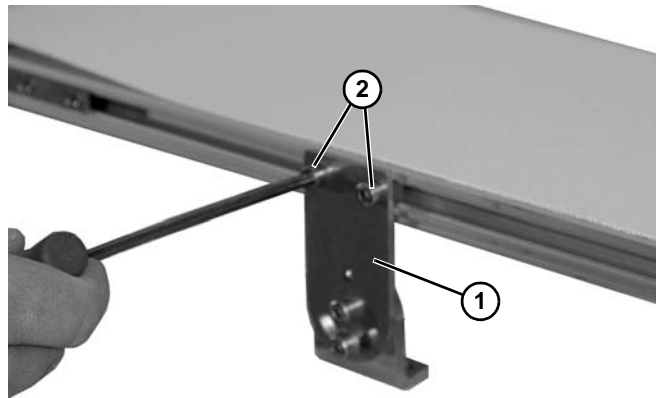


Figure 20

9. Remove belt (**Figure 21, item 1**) from conveyor.

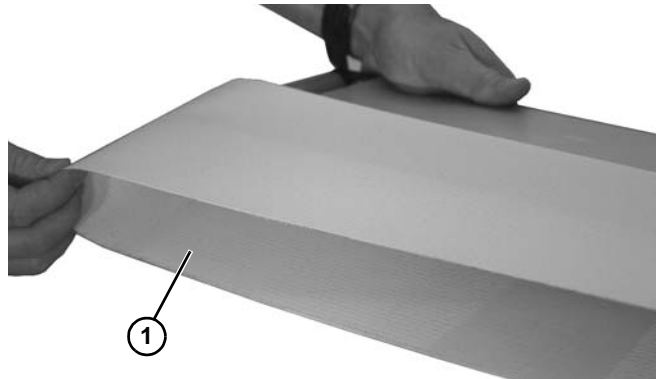


Figure 21

Preventive Maintenance and Adjustment

Belt Installation

1. Ensure temporary support stands (**Figure 22, item 1**) are placed at both ends of the conveyor.
2. Orient belt so splice leading fingers (**Figure 22, item 1**) point in the direction of belt travel as identified by the conveyor directional label (**Figure 22, item 2**).

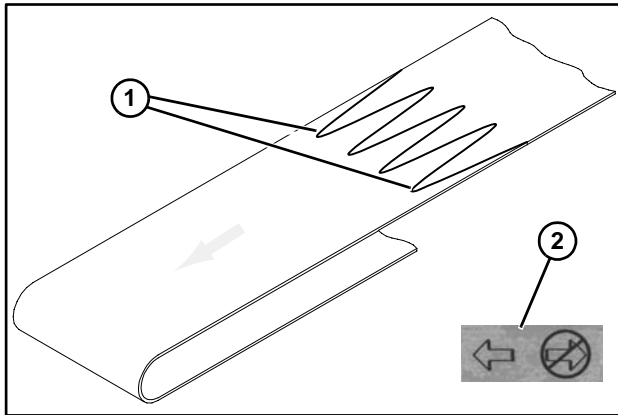


Figure 22

3. Install belt (**Figure 23, item 1**) on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.

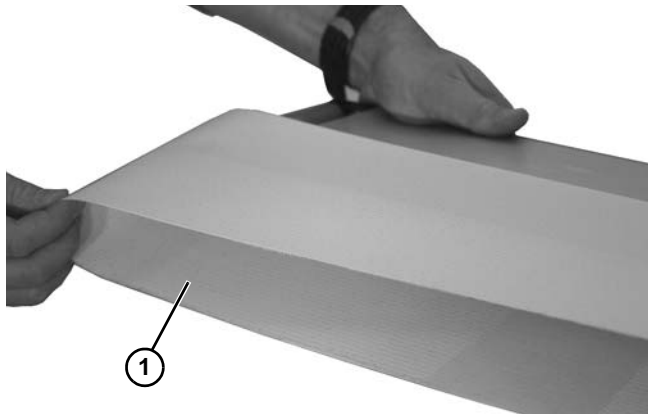
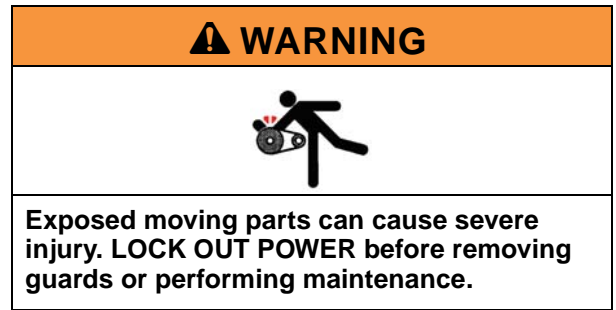


Figure 23

4. Re-install conveyor mounting brackets. Refer to “Mounting Brackets” on page 7.
5. Tension belt. Refer to “Conveyor Belt Tensioning” on page 13“.
6. Install return rollers, and if equipped, re-install guiding.

Conveyor Belt Tensioning



Conveyors with 1.00" (25 mm) Diameter Pulleys

1. On drive tail end of the conveyor, adjust head plate assembly (**Figure 24, item 1**): On both sides of conveyor, loosen fastening screws (**Figure 24, item 2**) and rotate tracking cam (**Figure 24, item 3**) to adjust head plate assembly.

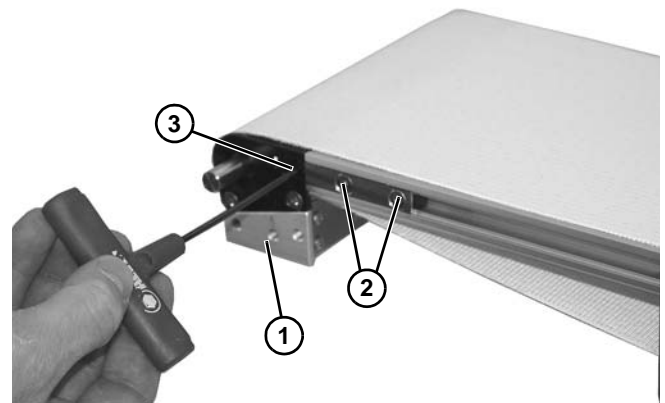


Figure 24

Preventive Maintenance and Adjustment

- Adjust head plate assembly so the edge of the drive tail plate (**Figure 25, item 1**) is separated from the end of the conveyor frame (**Figure 25, item 2**) by 0.19" (4.8 mm) (**Figure 25, item 3**), and tighten screws (**Figure 25, item 2**) to 12 in-lb (1.4 Nm).

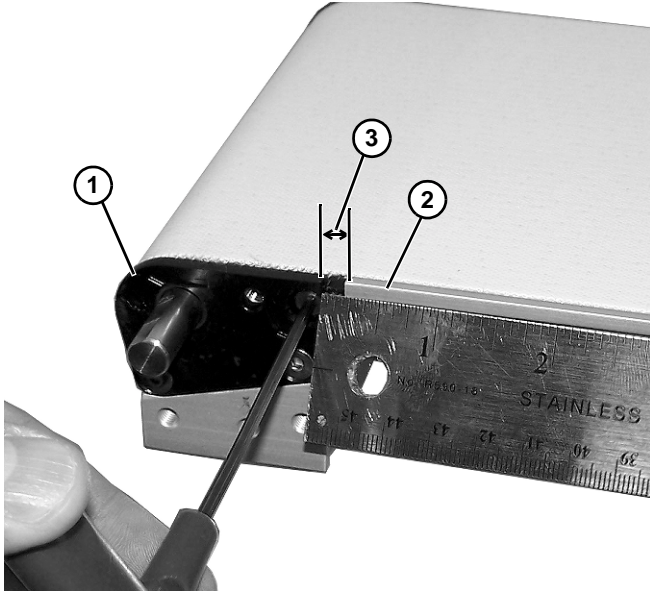


Figure 25

IMPORTANT

Over-tension can cause loss of load capacity and premature bearing failure.

- On tension end of the conveyor, adjust idler end (**Figure 26, item 1**) tracking cam (**Figure 26, item 2**) to adjust head plate assembly just enough to remove slack in the belt.

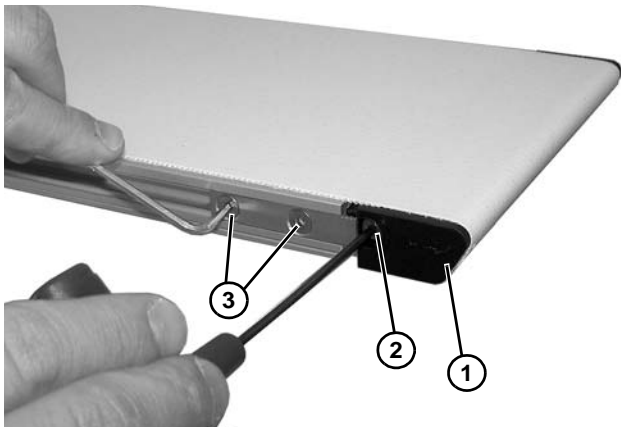


Figure 26

- Tighten screws (**Figure 26, item 3**) to 12 in-lb (1.4 Nm).

Conveyors with Nose Bar Tail

- Tension drive tail end of the conveyor. (See step 1 of "Conveyors with 1.00" (25 mm) Diameter Pulleys" on page 13.)

IMPORTANT

Over-tension can cause loss of load capacity and premature bearing failure.

- On tension end of the conveyor, adjust idler end (**Figure 27, item 1**) tracking cam (**Figure 27, item 2**) just enough to remove slack in the belt.

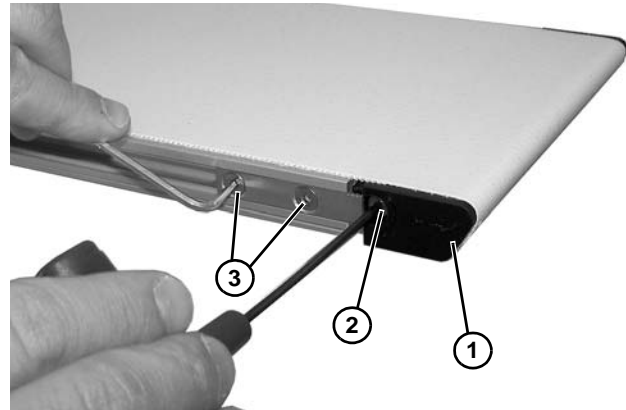


Figure 27

- Tighten screws (**Figure 27, item 3**) to 12 in-lb (1.4 Nm).

Preventive Maintenance and Adjustment

Conveyor Belt Tracking

Non V-guided belt conveyors are equipped with a belt tracking cam (Figure 28, item 1) for belt tracking adjustment.

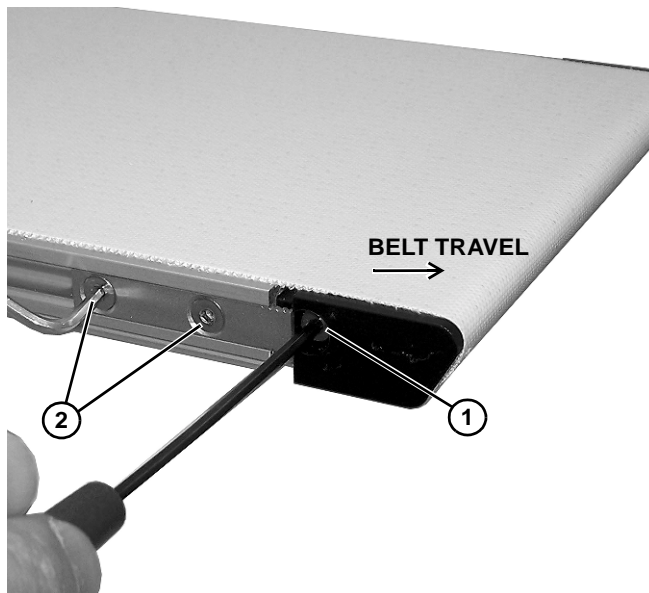




Figure 28

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

1. With conveyor running, insert 2.5 mm hex wrench into tracking cam (Figure 28, item 1) on the side toward which the belt is tracking.
2. Loosen head plate fastening screws (Figure 28, item 2).
3. Rotate tracking cam (Figure 28, item 1) in small increments until belt tracks in the center of conveyor.
4. While holding tracking cam (Figure 28, item 1), tighten head plate fastening screws (Figure 28, item 2) to 12 in-lb (1.4 Nm).

Spindle Removal



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

- A – Idler Spindle Removal
- B – Drive Spindle Removal

A – Idler Spindle Removal

1. Remove two screws on each side of the drive end of conveyor and remove pinch drive assembly (See “Belt Removal” on page 11).
2. On both sides of the idler end (Figure 29, item 1) conveyor, loosen two (2) head plate fastening screws (Figure 29, item 2).

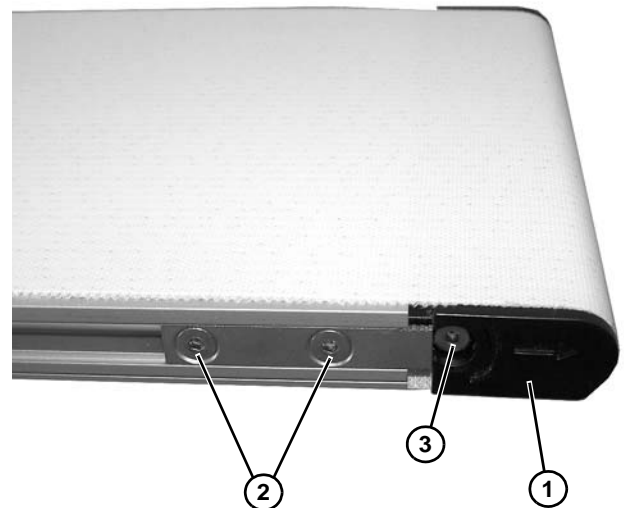


Figure 29

3. On both sides of conveyor, rotate belt tracking cam screw (Figure 29, item 3) to remove tension on belt.
4. Remove belt (Figure 30, item 1) from conveyor.

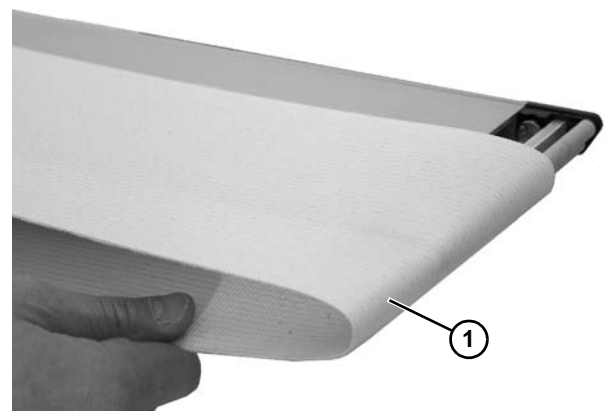


Figure 30

Preventive Maintenance and Adjustment

5. Remove the idler spindle assembly (**Figure 31, item 1**) from the conveyor frame.

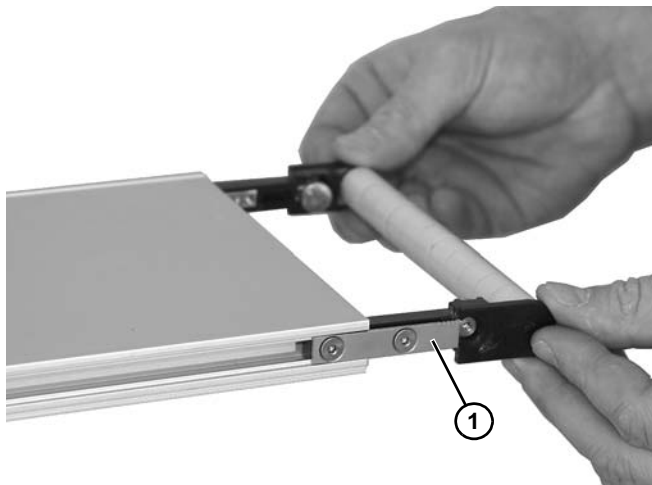


Figure 31

6. Disassemble components as shown (**Figure 32**).



Figure 32

B – Drive Pulley Removal

1. Loosen two screws (**Figure 33, item 1**) on both sides of conveyor.

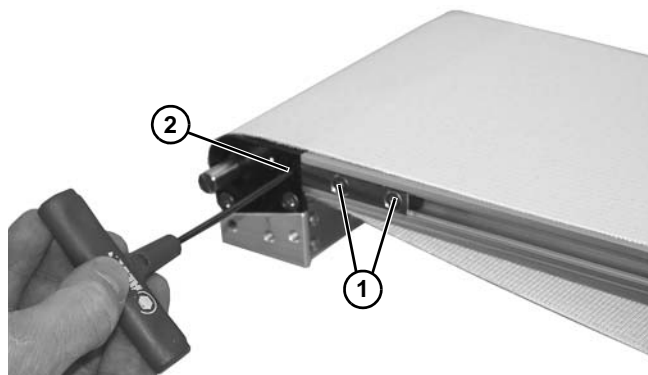


Figure 33

2. On both sides of conveyor, rotate belt tracking cam screw (**Figure 33, item 2**) to remove tension on belt.
3. Remove two screws on each side of conveyor and remove pinch drive assembly (See “Belt Removal” on page 11).
4. Remove belt (**Figure 34, item 1**) from conveyor.

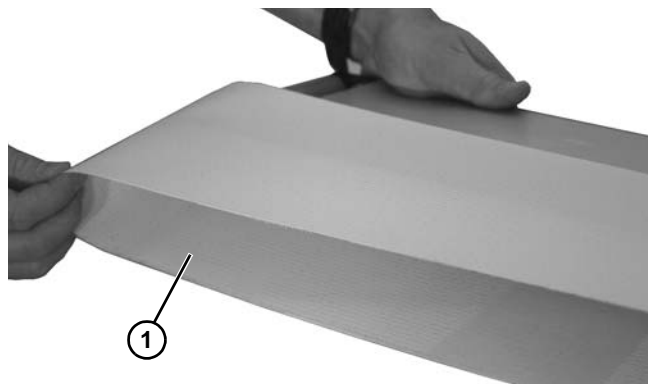


Figure 34

Preventive Maintenance and Adjustment

5. Remove the drive spindle assembly (Figure 35, item 1) from the conveyor frame.

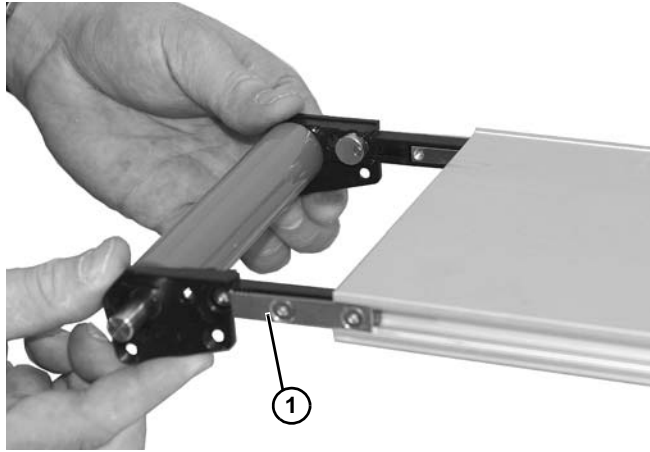


Figure 35

6. Disassemble components as shown (Figure 36).



Figure 36

Pinch Roller Removal

Removal

1. Loosen two screws (Figure 37, item 1) on both sides of conveyor.

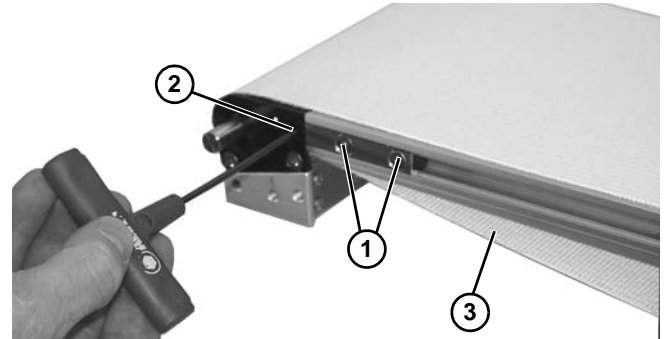


Figure 37

2. Loosen tensioning screw (Figure 37, item 2) to loosen tension on belt (Figure 37, item 3).
3. Remove two screws (Figure 38, item 1) on each side of conveyor holding pinch drive assembly (Figure 38, item 2).

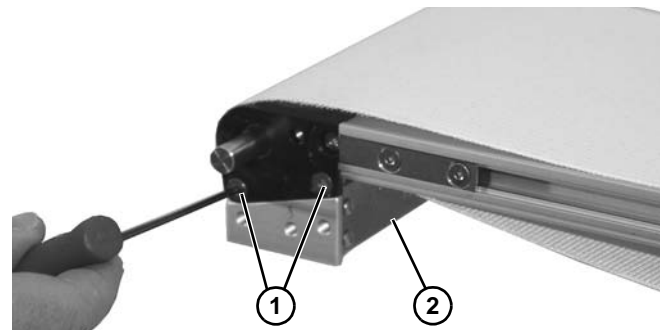


Figure 38

4. Lower pinch drive (Figure 39, item 1) from conveyor.

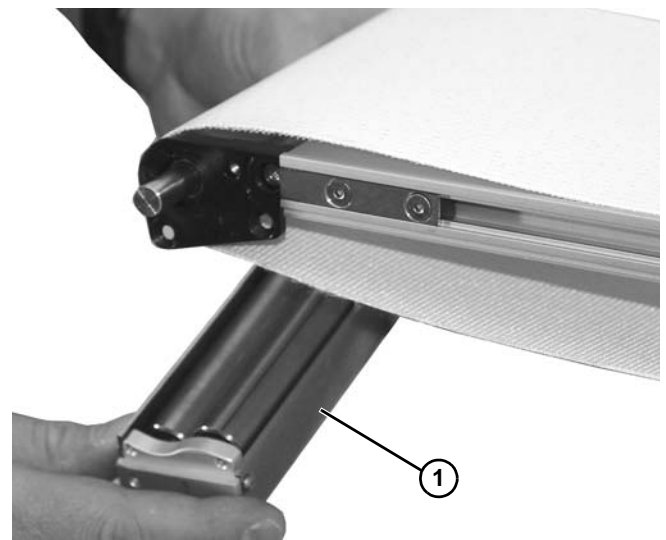


Figure 39

Preventive Maintenance and Adjustment

5. Remove two screws (Figure 40, item 1) from each side of roller mounting block (Figure 40, item 2).

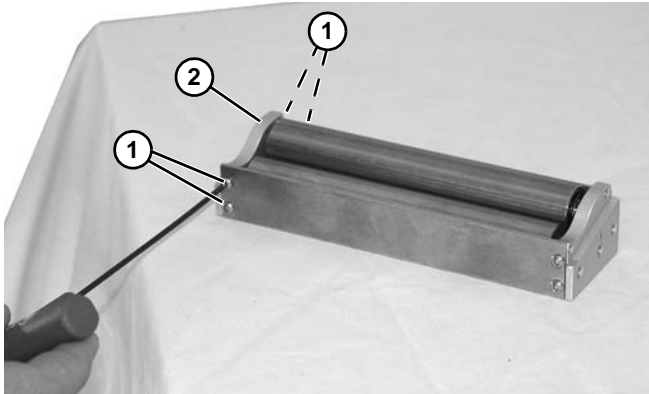


Figure 40

6. Remove roller mounting block (Figure 41, item 1).

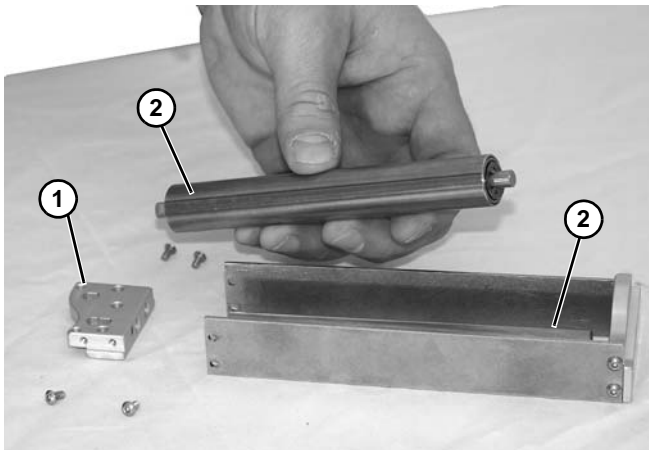


Figure 41

7. Remove each pinch roller (Figure 41, item 2).
8. Remove set screw (Figure 42, item 1) and compression spring (Figure 42, item 2) from roller mounting block (Figure 42, item 3).

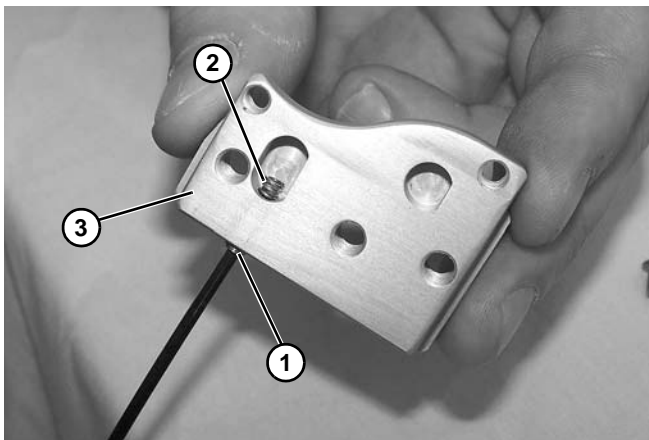


Figure 42

Installation

1. Install compression spring and set screw back into roller mounting block.
2. Install pinch roller onto roller mounting block, mating squared roller end (Figure 41, item 1) with slotted area (Figure 41, item 2) on mounting block end.

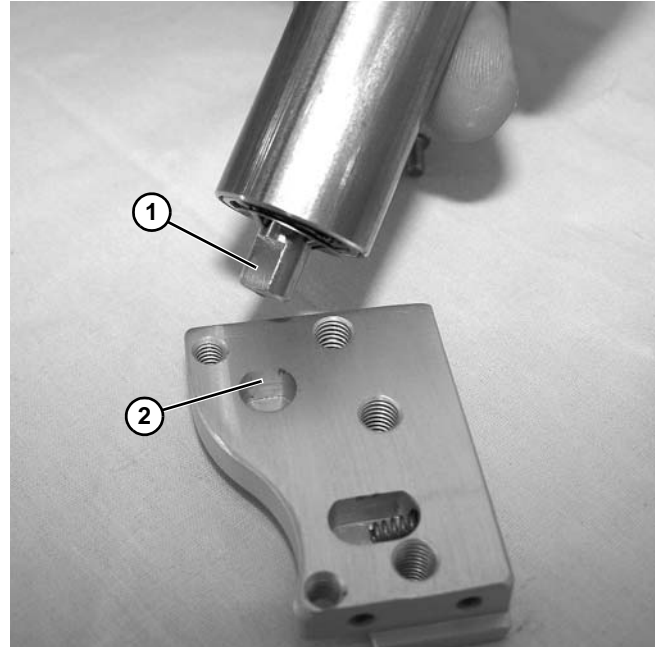


Figure 43

3. Install remaining components, reverse of removal.

Drive and Idler Bearing Replacement

IMPORTANT

All spindles are provided with bearings installed at the factory. It is not recommended to install new bearings in the field. Replace the entire spindle assembly with bearings.

Nosebar Bushing Replacement

IMPORTANT

Nosebar tail is provided with bushings installed at the factory. It is not recommended to change the bushings in the field. Replace the entire nosebar tail.

Preventive Maintenance and Adjustment

Drive Spindle and Idler Spindle Installation

Drive Spindle Installation

1. Assemble the drive spindle (**Figure 44, item 1**) onto each tail plate as shown and raise drive spindle assembly T-bars (**Figure 44, item 2**) to the conveyor frame.

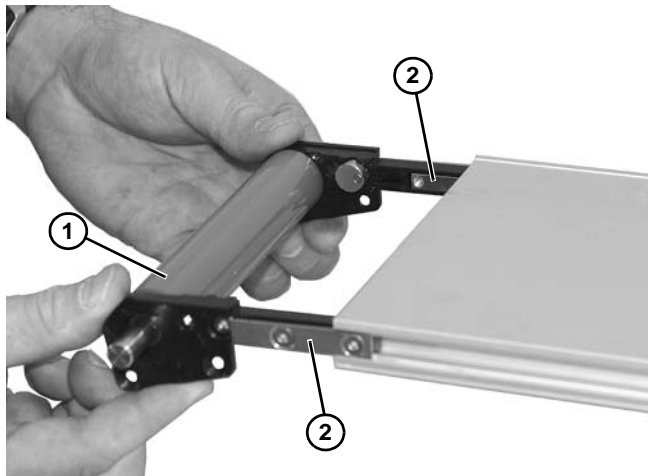


Figure 44

2. Tighten screws to 12 in-lb (1.4 Nm). (Install belt and see “Conveyor Belt Tensioning” on page 13 to tension belt to specification.)

Idler Spindle Installation

1. Install tail plate assembly with notch (**Figure 45, item 1**) in tail plate matching with slotted portion (**Figure 45, item 2**) of shaft.

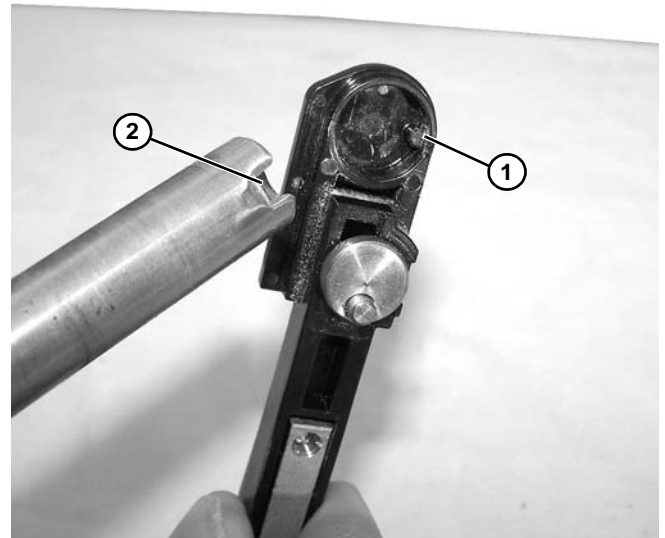


Figure 45

2. Assemble the idler spindle bearings (**Figure 46, item 1**) onto shaft onto each tail plate as shown and raise idler spindle assembly T-bars (**Figure 46, item 2**) to the conveyor frame.

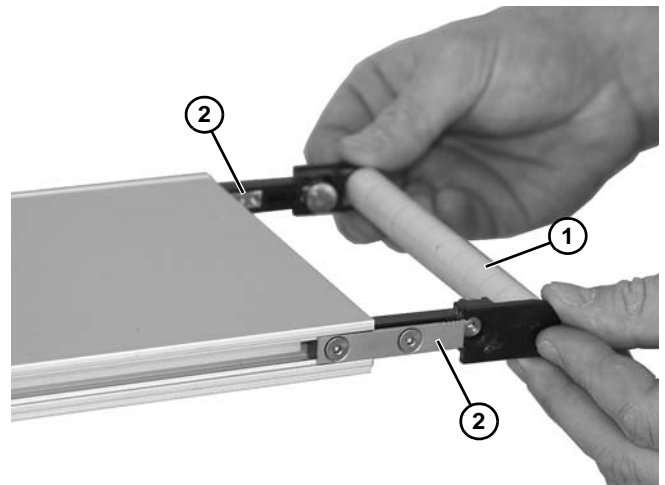



Figure 46

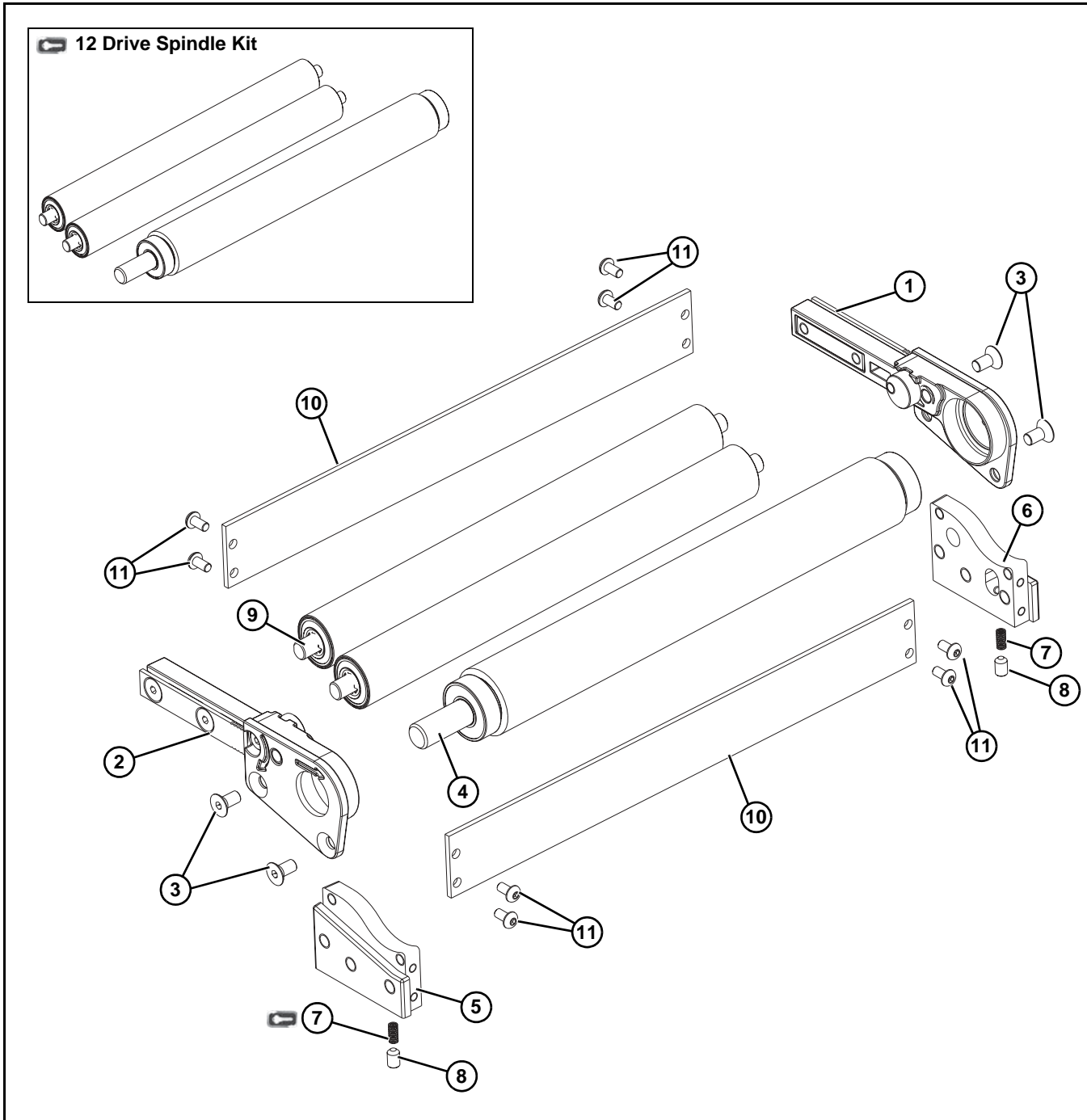
3. Tighten screws 12 in-lb (1.4 Nm). (Install belt and see “Conveyor Belt Tensioning” on page 13 to tension belt to specification.)

Service Parts

NOTE

For replacement parts other than those shown in this section, contact an authorized *Dorner Service Center* or the factory. Key Service Parts and Kits are identified by the Performance Parts Kits logo . Dorner recommends keeping these parts on hand.

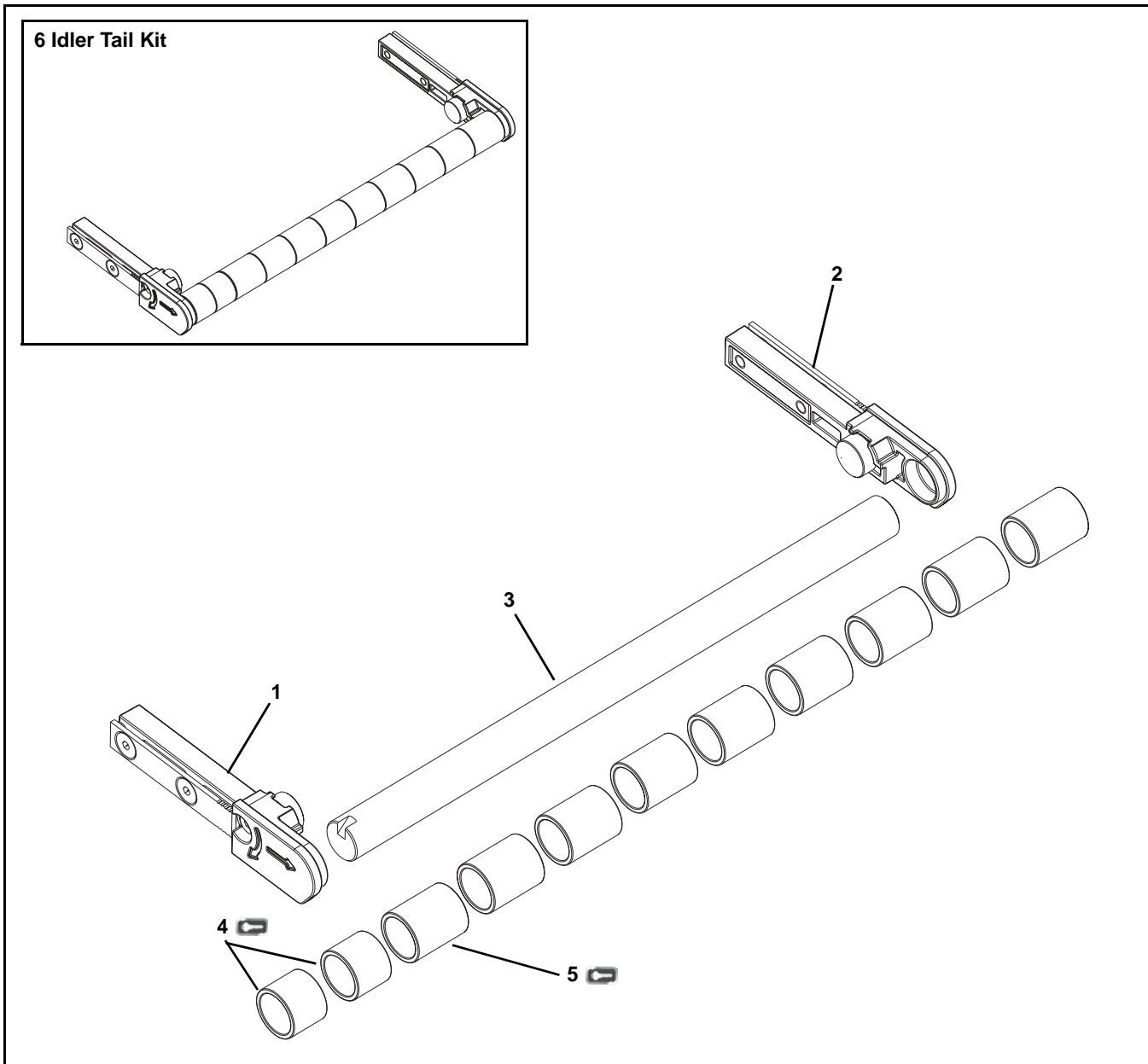
Drive End



Item	Part Number	Description
1	210102	Right Hand Tail Plate Assembly for A & B Position
	210104	Right Hand Tail Plate Assembly for C & D Position
2	210103	Left Hand Drive Plate Assembly for A & B Position
	210105	Left Hand Drive Plate Assembly for C & D Position
3	930408MSS	Flat Head Screw, M4 - 0.70 x 8 mm
4	204053- <u>WW</u>	Drive Spindle Assembly
5	210086	Roller Mounting Block Right Hand
6	210085	Roller Mounting Block Left Hand
7	807-2198	Compression Spring
8	970406MSS	Cup Set Screw, M4 - 0.50 x 6 mm
9	204055- <u>WW</u>	Pinch Roller Assembly
10	210109- <u>WW</u>	Guard Plate
11	910306MSS	Button Head Screw, M3 - 0.50 x 6 mm
12	11EDS- <u>WW</u>	Drive Spindle Kit (Includes Items 4 and 9)
<u>WW</u> = Conveyor width reference: 02, 04, 06, 08, & 10		

Service Parts

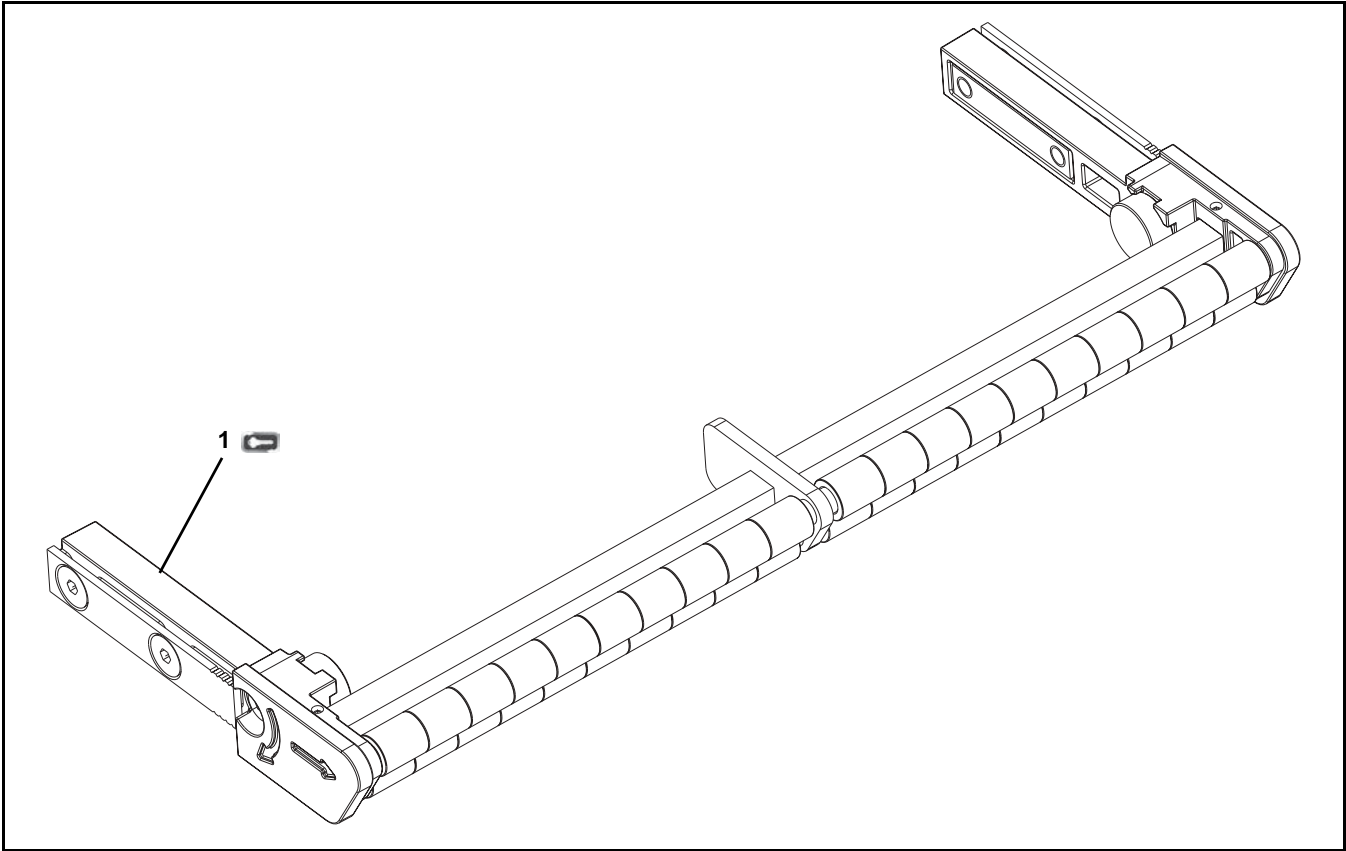
Idler End



Item	Part Number	Description
1	210094	Right Hand Tail Plate Assembly
2	210093	Left Hand Tail Plate Assembly
3	210091- <u>WW</u>	Shaft
4	801-148	Bearing, 0.625 dia. x 0.50 long (for quantities see Bearing Chart)
5	801-149	Bearing, 0.625 dia. x 0.75 long (for quantities see Bearing Chart)
6	210092- <u>WW</u>	Idler Tail Kit (Includes items 1 through 5)
<u>WW</u> = Conveyor width reference: 02, 04, 06, 08 & 10		

Bearing Quantity Chart		
<u>WW</u>	Item #4 (801-148)	Item #5 (801-149)
02	0	2
04	1	4
06	1	7
08	2	9
10	0	13

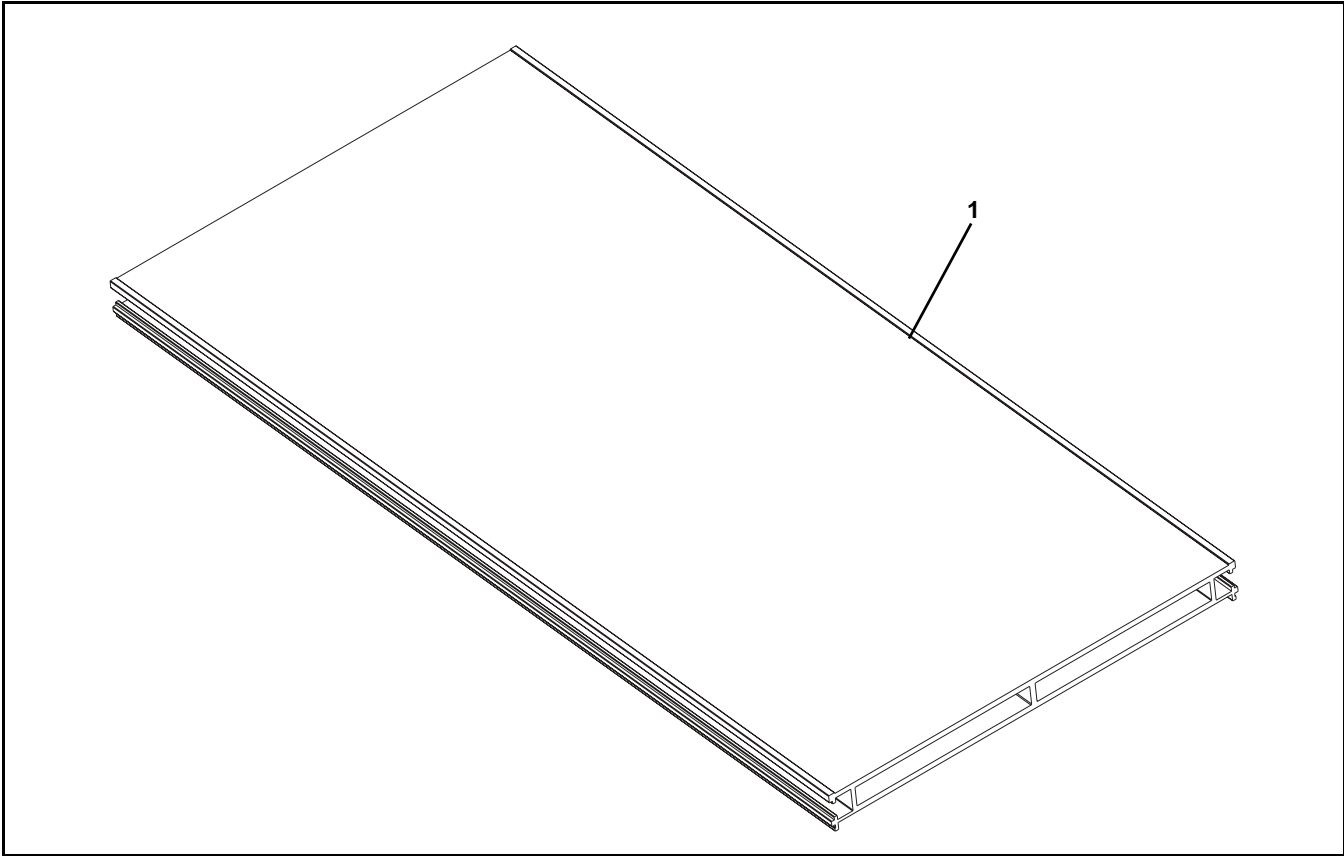
Nose Bar Idler End



Item	Part Number	Description
1	11TT- <u>WW</u>	Nosebar Tail Assembly
<u>WW</u> = Conveyor width reference: 02, 04, 06, 08, & 10		

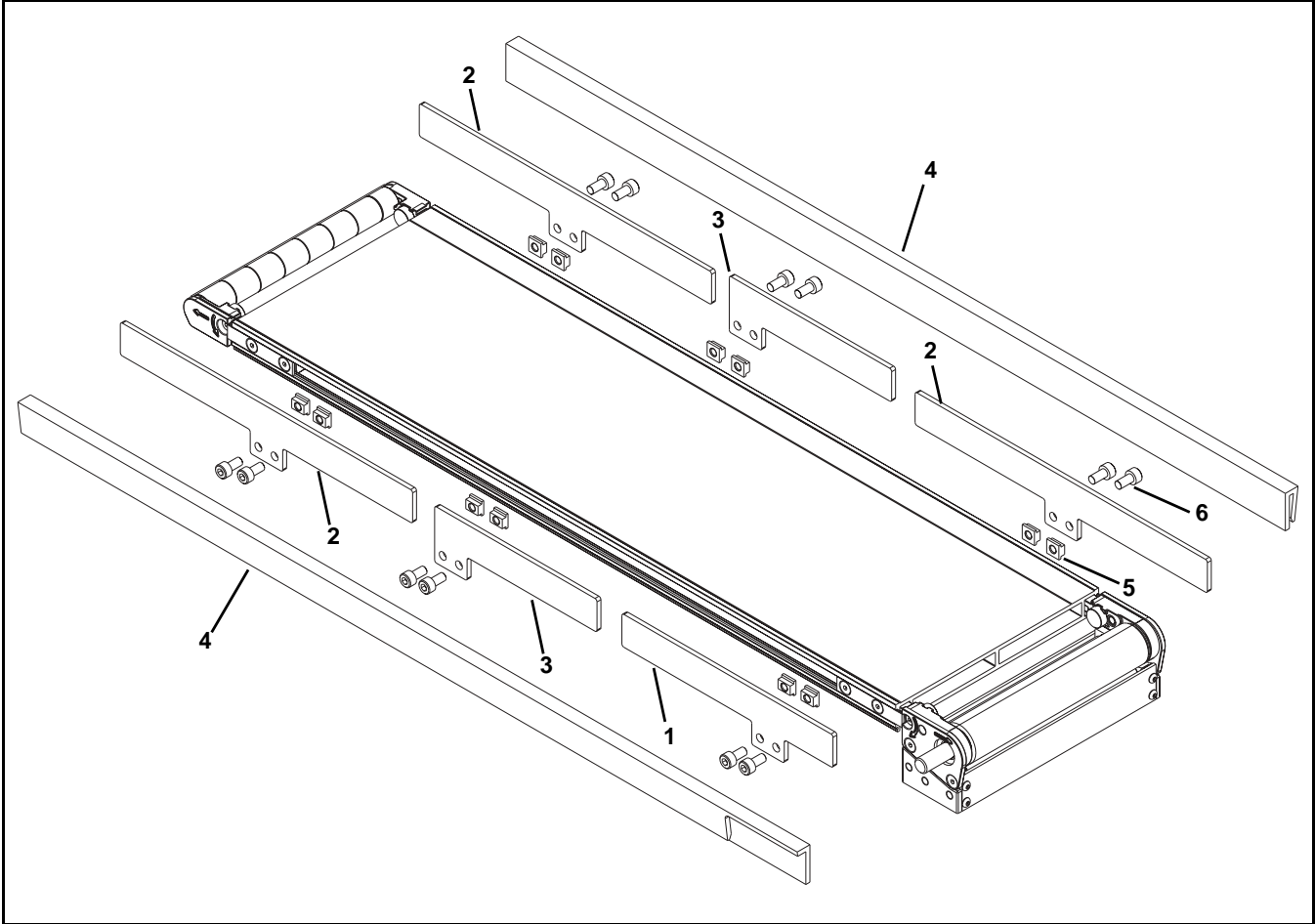
Service Parts

Frame



Item	Part Number	Description
1	210071-LLLLL	2" Wide Frame
	210072-LLLLL	4" Wide Frame
	210073-LLLLL	6" Wide Frame
	210074-LLLLL	8" Wide Frame
	210075-LLLLL	10" Wide Frame
LLLLL= Part length in inches with 2 decimal places		
Example: Part Length = 35.25" LLLLL = 03525		

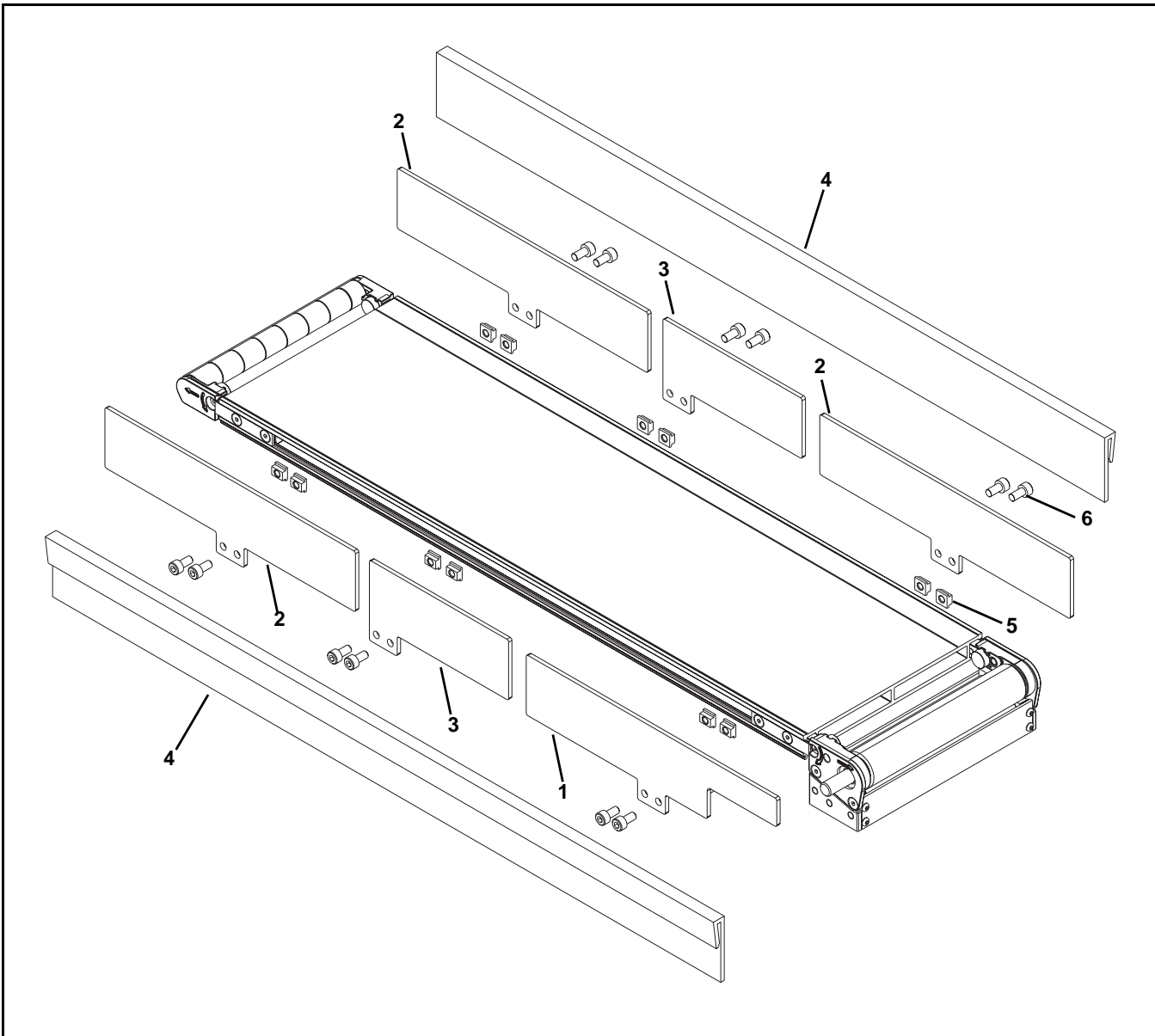
1" Profile



Item	Part Number	Description
1	204044	Guiding Support Bracket, 1" x 2.50" Drive End, Drive Side Only for Conveyors under 14" long
	204042	Guiding Support Bracket 1" x 6.50" Drive End, Drive Side Only for Conveyors 14" long and longer
2	210159	Guiding Support Bracket 1" x 9"
3	210161	Guiding Support Bracket 1" x 5"
4	210163-LLLLL	1" UHMW Guiding
5	210135	Single T-Bar
6	950512MSS	Low Head Cap Screw, M5 - 0.80 x 12 mm
LLLLL= Part length in inches with 2 decimal places.		
Example: Part Length = 35.25" LLLLL = 03525		

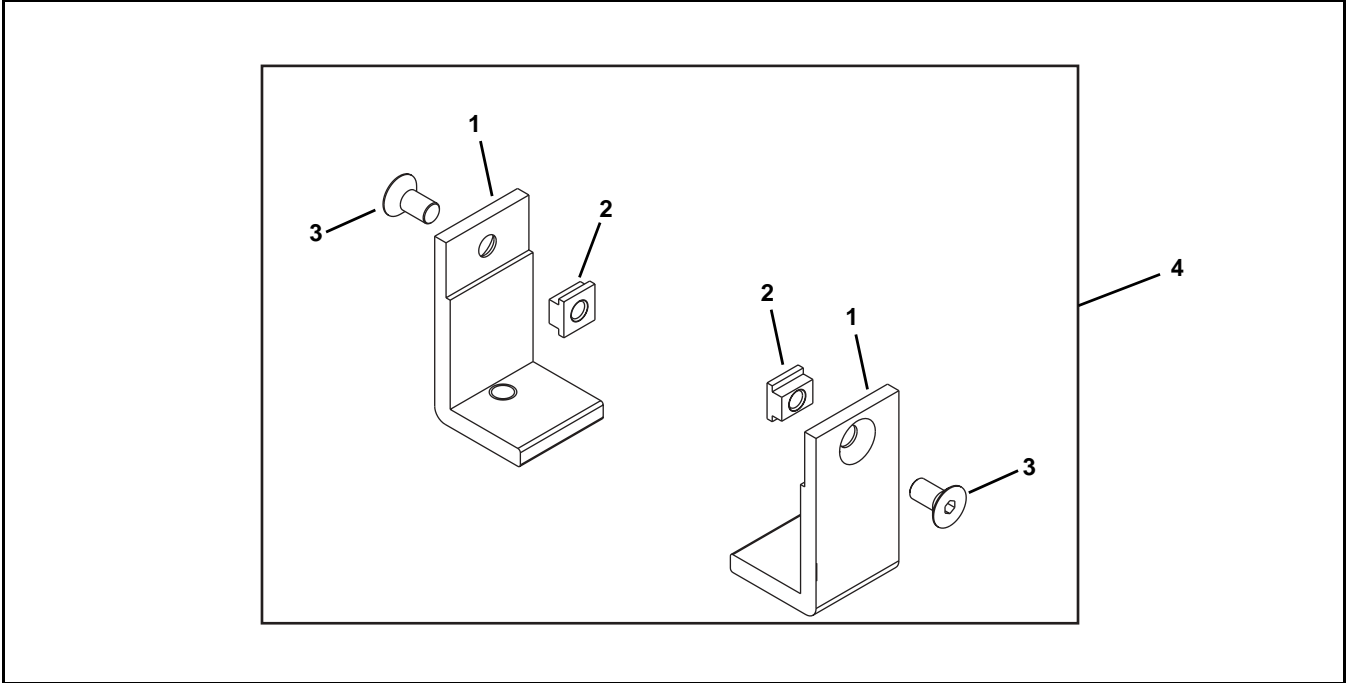
Service Parts

2" Profile



Item	Part Number	Description
1	204045	Guiding Support Bracket 2" x 2.50" Drive End Only for Conveyors under 14" long
	204043	Guiding Support Bracket 2" x 6.50" Drive End Only for Conveyors 14" long and longer
2	210158	Guiding Support Bracket 2" x 9"
3	210160	Guiding Support Bracket 2" x 5"
4	210162-LLLLL	2" UHMW Guiding
5	210135	Single T-Bar
6	950512MSS	Low Head Cap Screw, M5 - 0.80 x 12 mm
LLLLL= Part length in inches with 2 decimal places.		
Example: Part Length = 35.25" LLLLL = 03525		

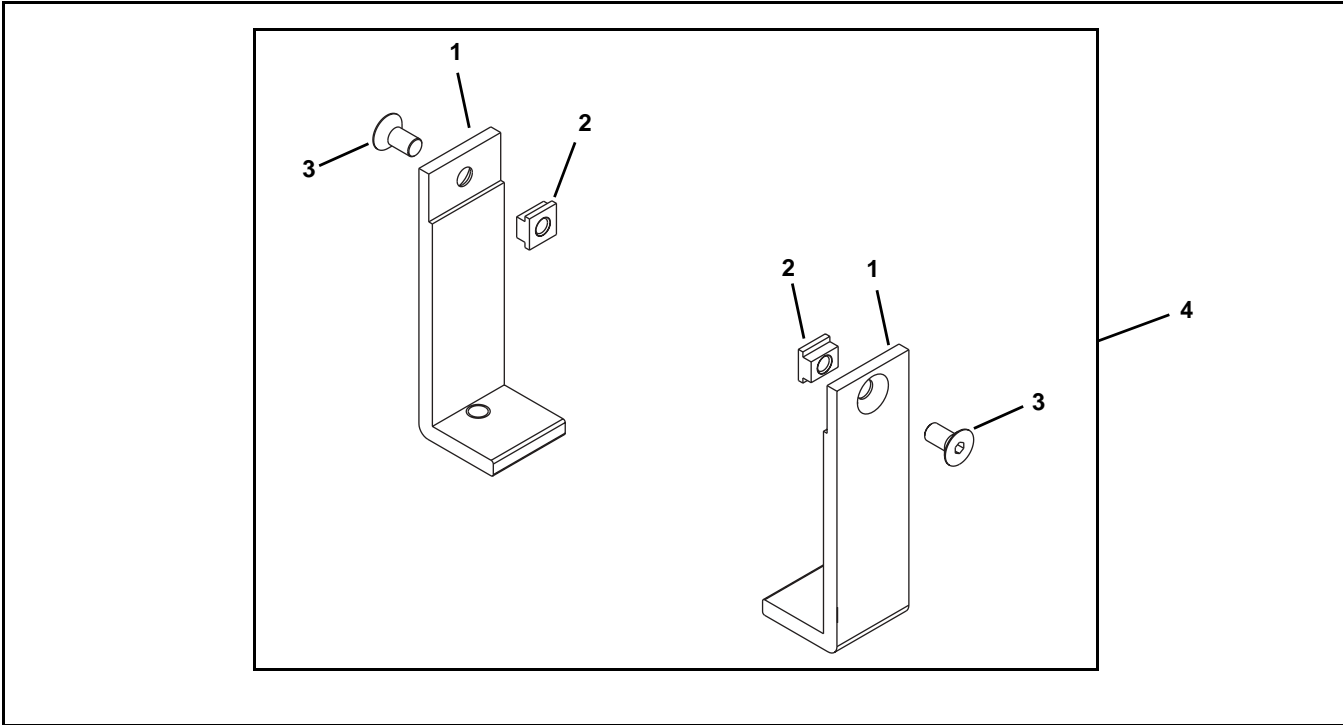
Short Mounting Bracket



Item	Part Number	Description
1	210145	Mounting Bracket (Short)
2	210135	Single T-Bar
3	930512MSS	Flat Head Screw, M5 - 0.80 x 12 mm
4	210143	Short Mounting Bracket Assembly

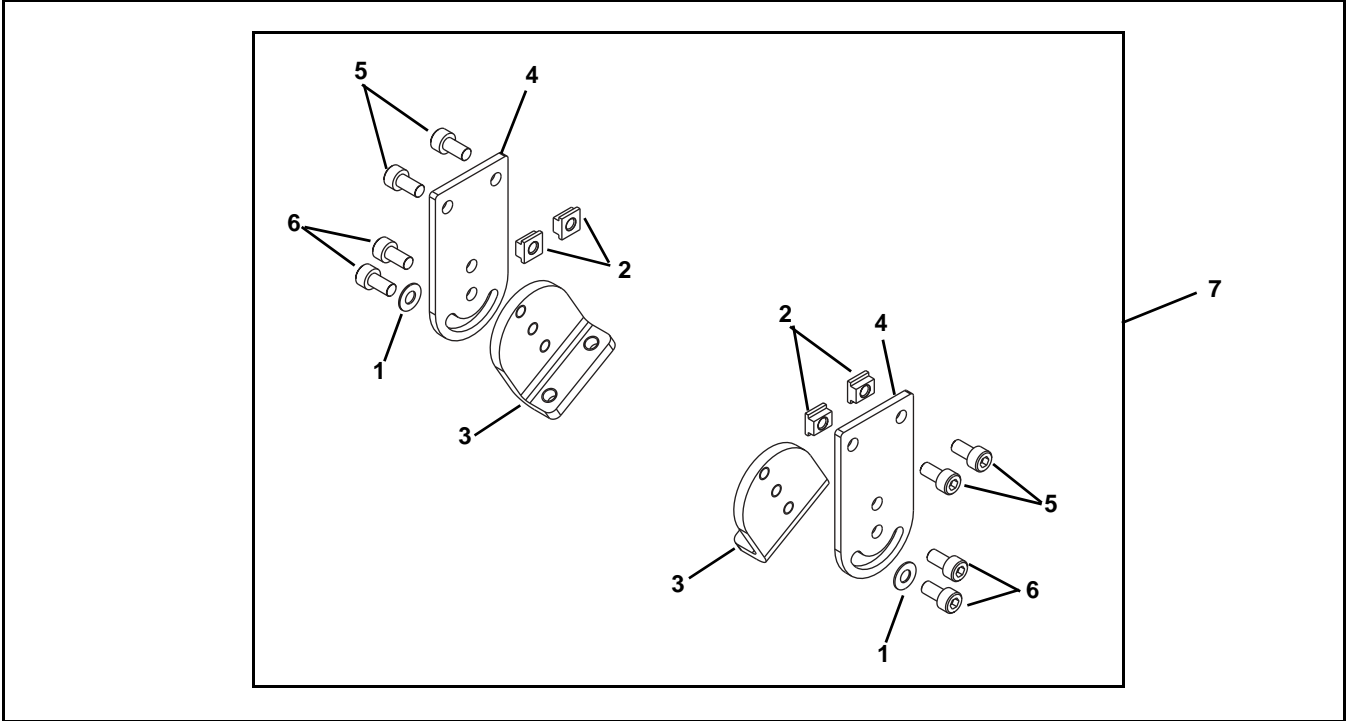
Service Parts

Tall Mounting Bracket



Item	Part Number	Description
1	210146	Mounting Bracket (Tall)
2	210135	Single T-Bar
3	930512MSS	Flat Head Screw, M5 - 0.80 x 12 mm
4	210144	Tall Mounting Bracket Assembly

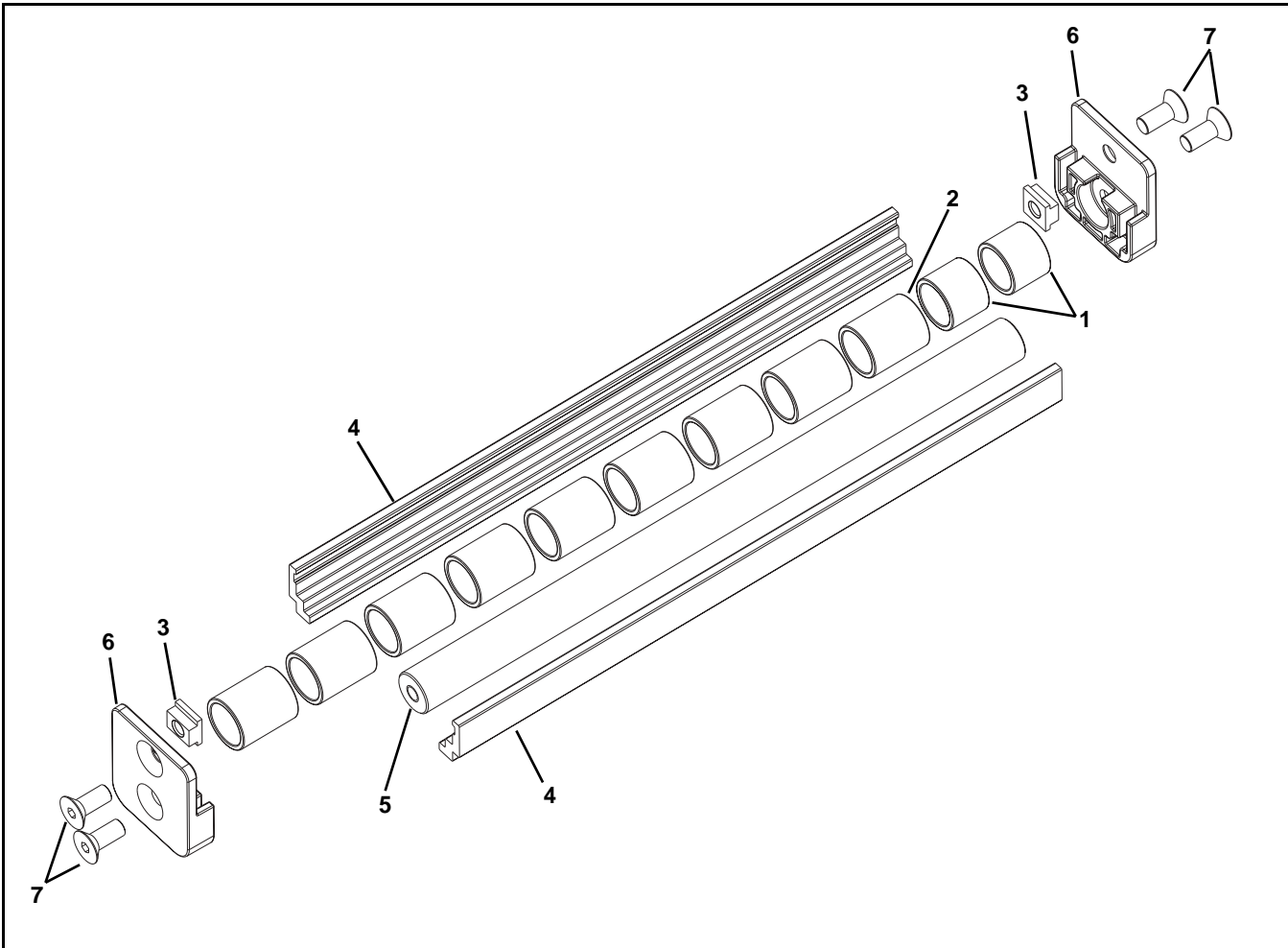
Pivoting Mounting Bracket



Item	Part Number	Description
1	911-205	Washer
2	210135	Single T-Bar
3	210147	Angled Mounting Bracket
4	210148	Flat Mounting Bracket
5	950512MSS	Low Head Cap Screw, M5 - 0.80 x 12mm
6	950510MSS	Low Head Cap Screw, M5 - 0.80 x 10mm
7	210149	Pivoting Mounting Bracket Assembly

Service Parts

Return Roller



Item	Part Number	Description
1	801-148	Bearing, 0.625" Dia x 0.50" long
2	801-149	Bearing, 0.625" Dia x 0.75" long
3	210135	Single T-Bar
4	210140- <u>WW</u>	Roller Guard
5	210150- <u>WW</u>	Roller Shaft
6	210152	Mounting Block
7	930512MSS	Flat Head Screw, M5 - 0.80 x 12 mm

WW = Conveyor width reference: 02, 04, 06, 08, & 10

Conveyor Belt Part Number Configuration

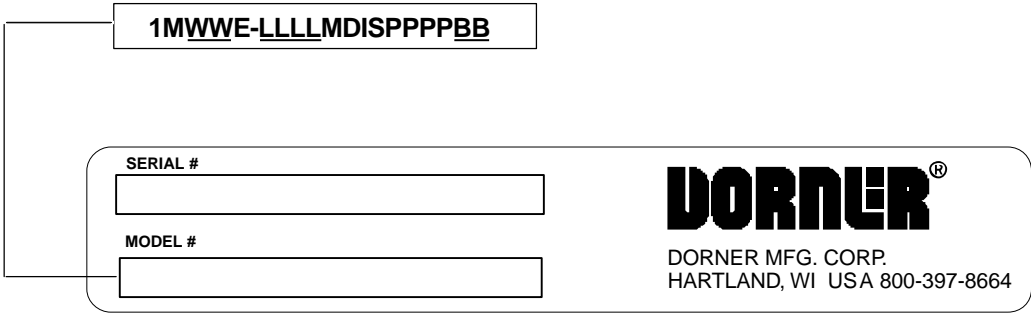


Figure 47

End Drive Part Number Configuration

Refer to Dorner serial number plate (Figure 47). From the model number, determine conveyor width (“WW”), length (“LLL”) and belt type (“BB”). Use data to configure belt part number as indicated below.

11 - WW LLLL / BB

11 - _____ / _____
(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: 50% return fee for conveyors with modular belt, 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.

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

 <p>Dorner Mfg. Corp. reserves the right to change or discontinue products without notice. All products and services are covered in accordance with our standard warranty. All rights reserved. © Dorner Mfg. Corp. 2013</p>	<p>DORNER MFG. CORP. 975 Cottonwood Ave., PO Box 20 Hartland, WI 53029-0020 USA TEL 1-800-397-8664 (USA) FAX 1-800-369-2440 (USA) Internet: www.dorner.com</p>	<p>Outside the USA: TEL 1-262-367-7600 FAX 1-262-367-5827</p>
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