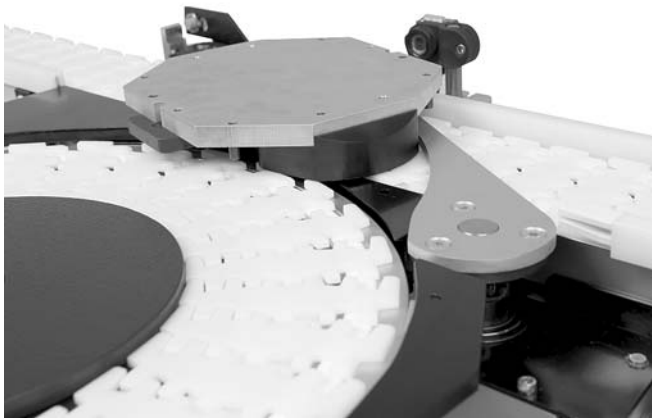




# SmartFlex Pallet System Accessories

Installation, Maintenance & Parts Manual



**Divert and Merge**



**Lift and Locate Station / Pallet Stop**



**Pallet**


For other service manuals visit our website at:  
[www.dornerconveyors.com/manuals-literature](http://www.dornerconveyors.com/manuals-literature)

# Table of Contents

Introduction .....	3	45° Divert-Merge .....	38
Warnings – General Safety .....	4	90° Divert-Merge .....	40
Specifications .....	5	Parallel Divert-Merge .....	42
Accessories: .....	5	45° Parallel Divert-Merge .....	44
Pallets .....	5	90° Parallel Divert-Merge .....	46
Pallet Stops .....	5	45° Merge .....	48
Lift and Locate Station .....	5	90° Merge .....	50
Divert and Merge .....	5	Parallel-Merge .....	52
Fixed Merge .....	5	45° Parallel-Merge .....	54
Installation .....	6	90° Parallel-Merge .....	56
Required Tools .....	6	Return Policy .....	58
Pallets .....	6		
Pallet Stops .....	6		
Pneumatic and Control Logic Suggestions .....	7		
Recommended Pneumatics .....	7		
Attaching and Operations of Pneumatics .....	7		
Sensor Installation and Basic Logic .....	7		
Lift and Locate Station .....	8		
Pneumatic and Control Logic Suggestions .....	9		
Recommended Pneumatics .....	9		
Attaching and Operations of Pneumatics .....	9		
Sensor Installation and Basic Logic .....	10		
Divert and Merge .....	11		
Guiding .....	12		
45° Divert-Merge Layout .....	14		
90° Divert-Merge Layout .....	15		
Parallel Divert-Merge Layout .....	16		
45° Parallel Divert-Merge Layout .....	17		
90° Parallel Divert-Merge Layout .....	18		
Pneumatic and Control Logic Suggestions .....	19		
Diverts Only .....	19		
Diverts and Merge .....	21		
Fixed Merge .....	22		
Merge .....	22		
Parallel Merge .....	23		
Guiding .....	23		
45° Merge Layout .....	25		
90° Merge Layout .....	26		
Parallel Merge Layout .....	27		
45° Parallel Merge Layout .....	28		
90° Parallel Merge Layout .....	29		
Preventive Maintenance and Adjustment .....	30		
Required Tools .....	30		
Checklist .....	30		
Pallets .....	30		
Pallet Stops .....	30		
Removal .....	30		
Lift and Locate Station .....	30		
Divert and Merge .....	33		
Replace Cylinder Assembly .....	33		
Service Parts .....	34		
Pallets .....	34		
Pallet Stops .....	35		
Lift and Locate Station .....	36		

## IMPORTANT

*Some illustrations may show guards removed. DO NOT operate equipment without guards.*

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

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.

# 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

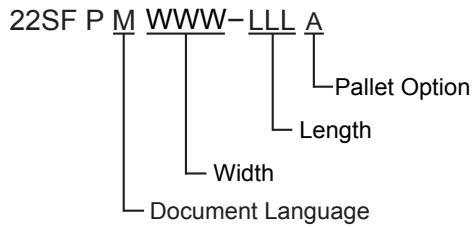


Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.

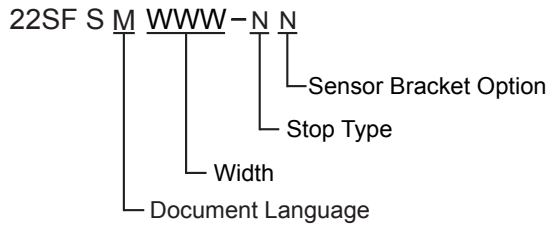
**SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.**

## Accessories:

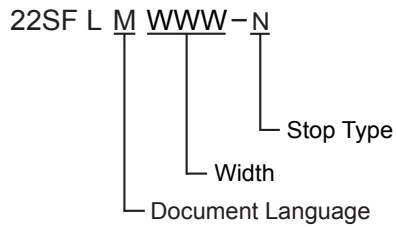
### Pallets



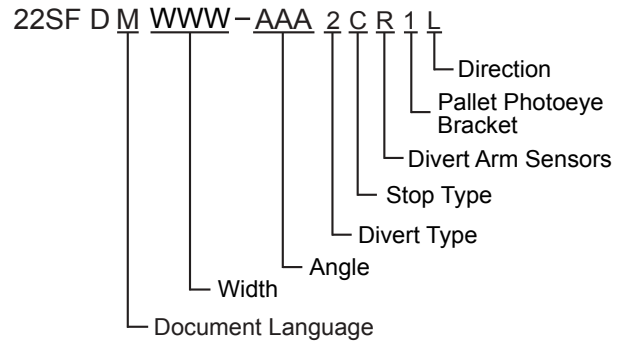
### Pallet Stops



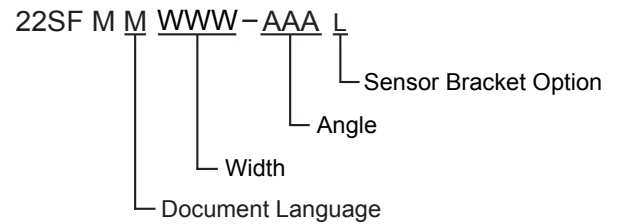
### Lift and Locate Station



## Divert and Merge



## Fixed Merge



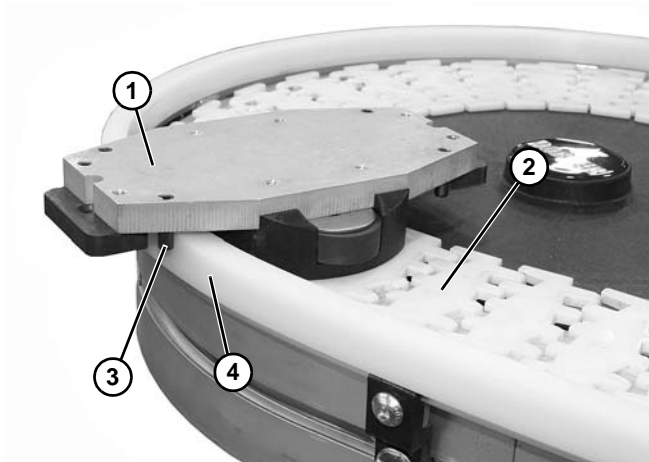
# Installation

## Required Tools

- 3/32" hex wrench
- 3 mm hex wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 7 mm wrench
- 10 mm wrench
- 13 mm wrench
- Belt Removal Tool #203480

## Pallets

1. Place pallet (**Figure 1, item 1**) on conveyor belt (**Figure 1, item 2**).



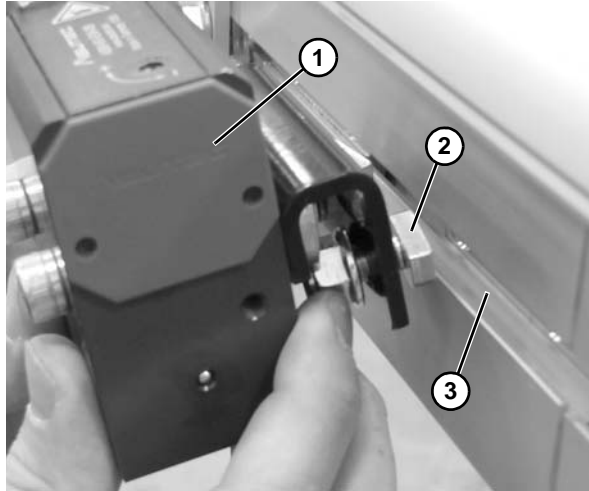
**Figure 1**

2. Make sure that the guide pins (**Figure 1, item 3**) are on the outside of the wear strip (**Figure 1, item 4**).

## Pallet Stops

The following procedure is for the Cushioned Stop Module. The procedure for the Fixed Stop Module is similar.

1. Install pallet stop (**Figure 2, item 1**) to the conveyor.



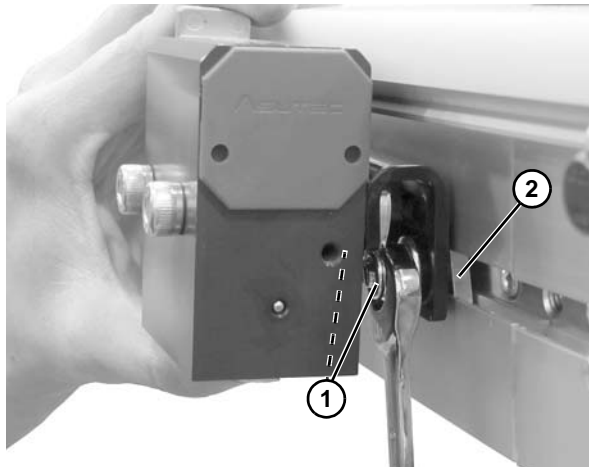
**Figure 2**

2. Make sure that the studs (**Figure 2, item 2**) are inside the channel (**Figure 2, item 3**) of the conveyor.

### NOTE

*Make sure that the studs (**Figure 3, item 2**) rotate inside the channel and engage with the conveyor.*

3. Tighten hex nuts (**Figure 3, item 1**) with wrench.

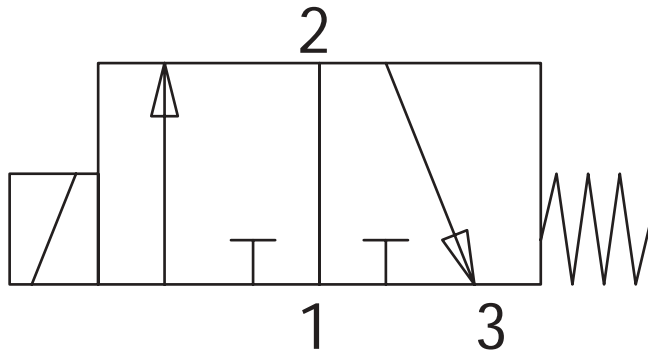


**Figure 3**

## Pneumatic and Control Logic Suggestions

### Recommended Pneumatics

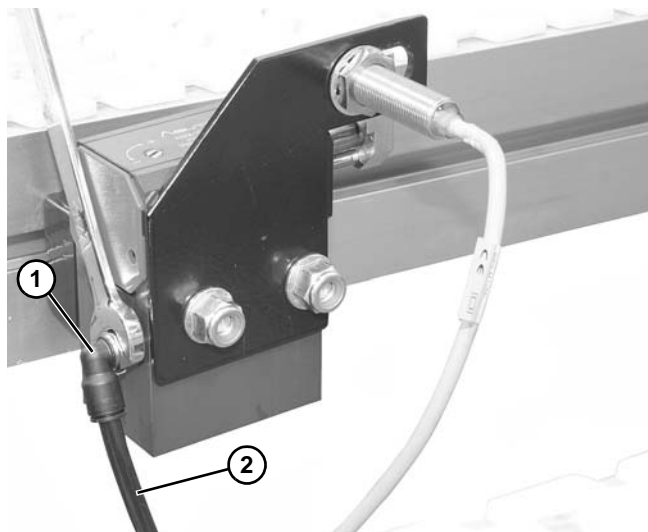
Dorner recommends using a 3 port, 2 way solenoid valve (**Figure 4**) to operate Pallet Stops.



**Figure 4**

### Attaching and Operations of Pneumatics

1. Connect the solenoid to the stop. Dorner fittings (**Figure 5, item 1**) accept 1/4" outside diameter tubing standard (**Figure 5, item 2**).



**Figure 5**

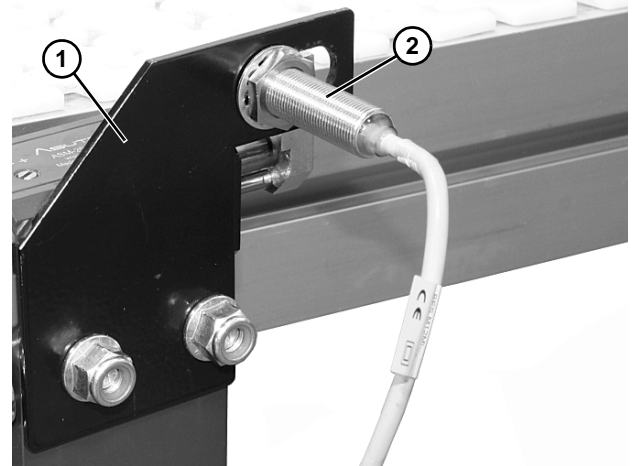
2. Stops release the pallet when air is supplied to the stop.

## Sensor Installation and Basic Logic

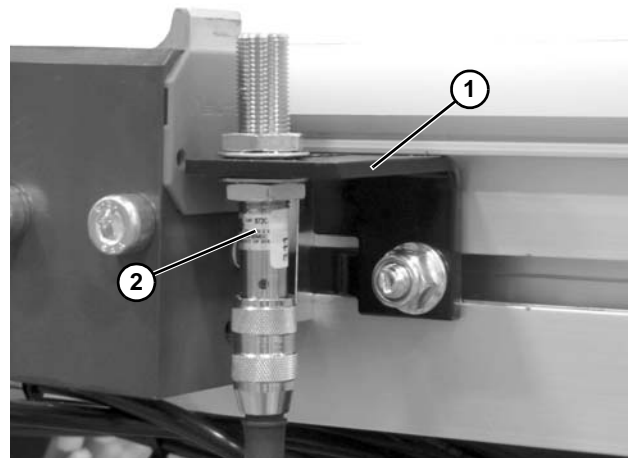
### 2 Options:

- Side Sensor (**Figure 6**)
- Bottom Up Sensor (**Figure 7**)

Optional sensor bracket (**Figure 6, item 1**) and (**Figure 7, item 1**) can be used to mount a 12 mm barrel proximity sensor (**Figure 6, item 2**) and (**Figure 7, item 2**).



**Figure 6**



**Figure 7**

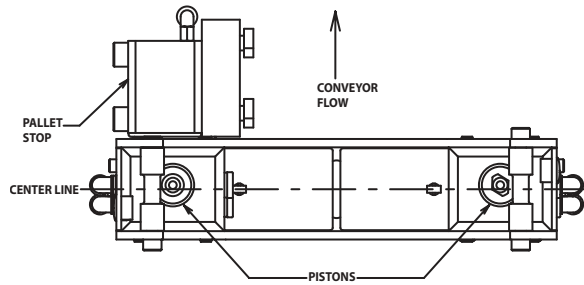
- Proximity sensor detects off the pallet stop block.
- Use proximity sensor to detect pallet located at the stop.
- The stop can reset when the proximity sensor signal clears.

# Installation

## Lift and Locate Station

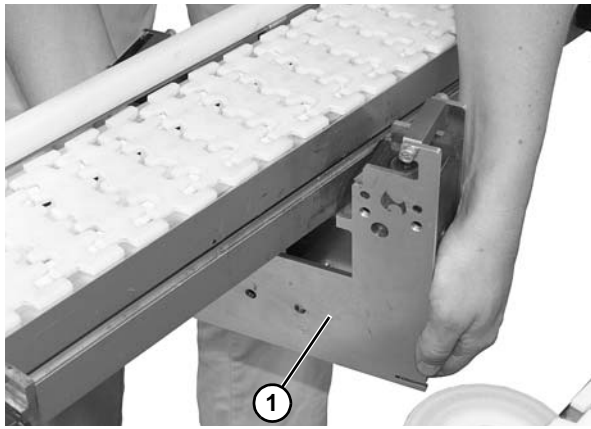
### NOTE

Position lift and locate station with pistons located closest to the pallet stop. The unit is not symmetrical. See **Figure 8**.



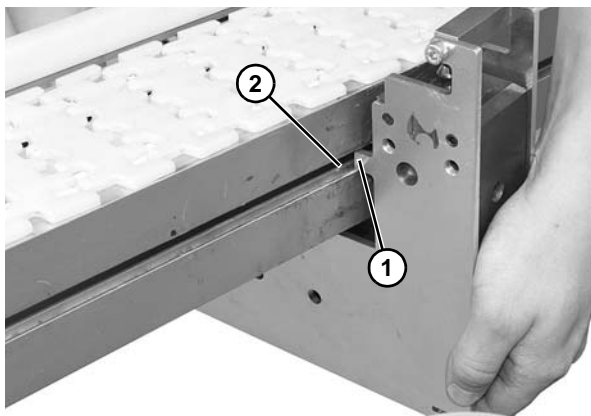
**Figure 8**

1. Raise lift and locate station (**Figure 9, item 1**), on an angle as shown, into position from under the conveyor.



**Figure 9**

2. Rotate lift and locate station so that the tabs (**Figure 10, item 1**) on both sides can be inserted into the channel (**Figure 10, item 2**) of the conveyor.

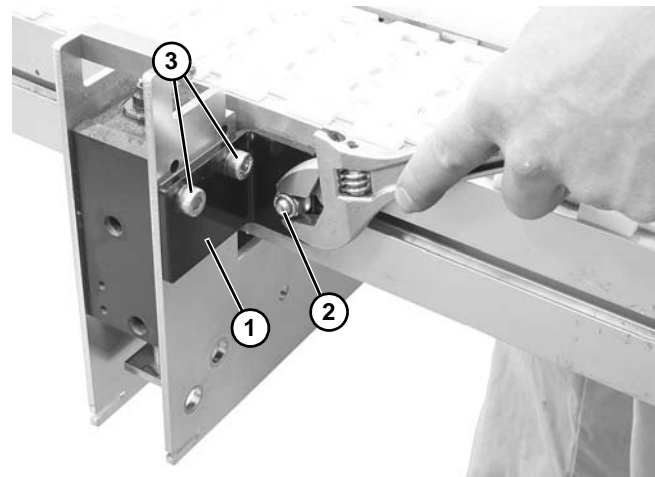


**Figure 10**

### NOTE

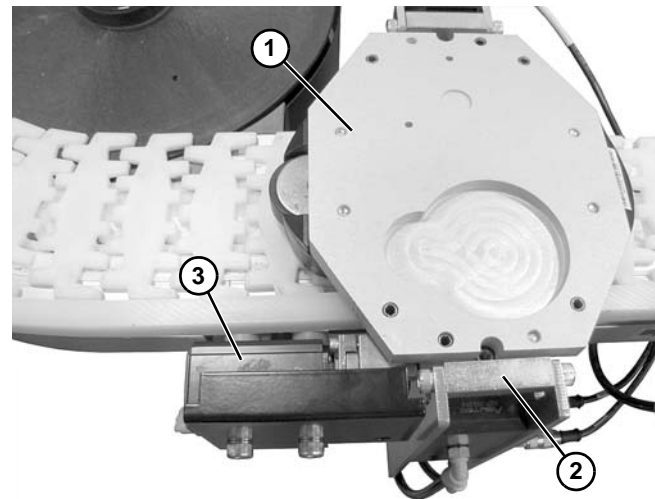
Make sure that the stud rotates inside the channel and engages with the conveyor.

3. Loosely install angle bracket (**Figure 11, item 1**) to conveyor with M8 x 20 mm stud and hex nut (**Figure 11, item 2**).



**Figure 11**

4. Loosely secure the angle bracket (**Figure 11, item 1**) to the lift and locate station with two socket head screws (**Figure 11, item 3**).
5. Repeat on opposite side of conveyor.
6. Tighten socket head screws and hex nuts.
7. Place pallet (**Figure 12, item 1**) on lift and locate (**Figure 12, item 2**).

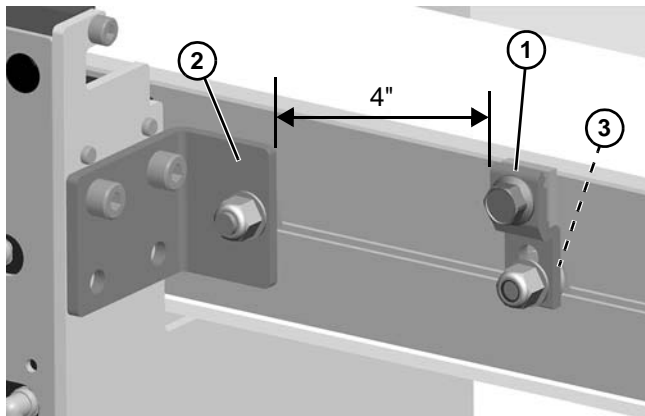


**Figure 12**

8. Install pallet stop (**Figure 12, item 3**). Position against pallet.

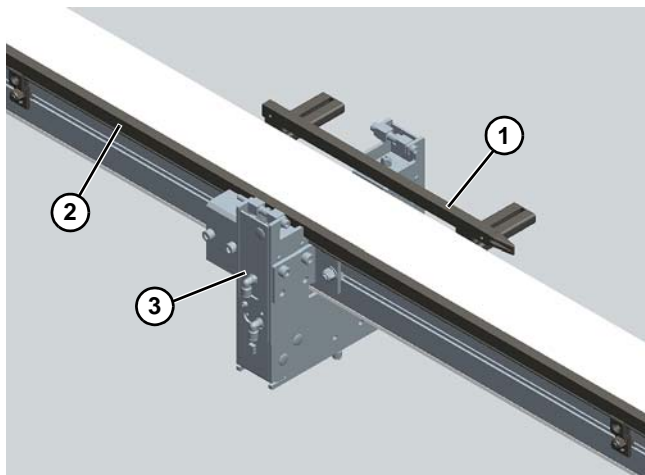


- Install lead in guide clip (**Figure 13, item 1**) 4" before angle bracket (**Figure 13, item 2**). Lead in guide clip has a washer (**Figure 13, item 3**) between the frame and clip.



**Figure 13**

- Install the lift and locate guiding (**Figure 14, item 1**) on the opposite side of the conveyor as the continuous guiding (**Figure 14, item 2**). Guiding to be installed to help contain the pallet as it enters and exits the lift and locate station (**Figure 14, item 3**). For component details see page 36.

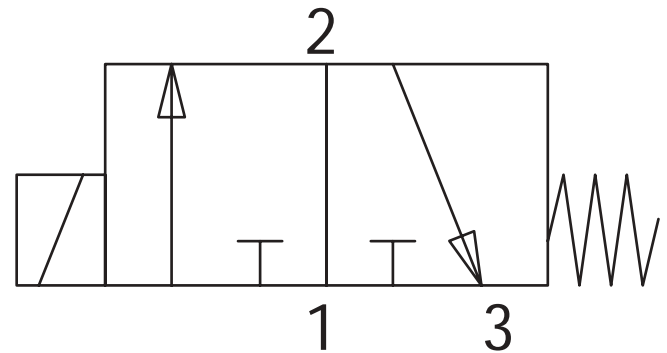


**Figure 14**

## Pneumatic and Control Logic Suggestions

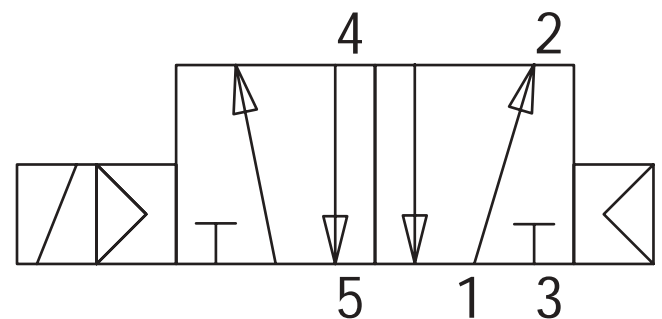
### Recommended Pneumatics

Dorner recommends using a 3 port, 2 way solenoid valve (**Figure 15**) to operate Lift and Locate Stop.



**Figure 15**

Dorner recommends using a 5 port, 2 way solenoid valve (**Figure 16**) to operate Lift and Locate Pallet Unit.

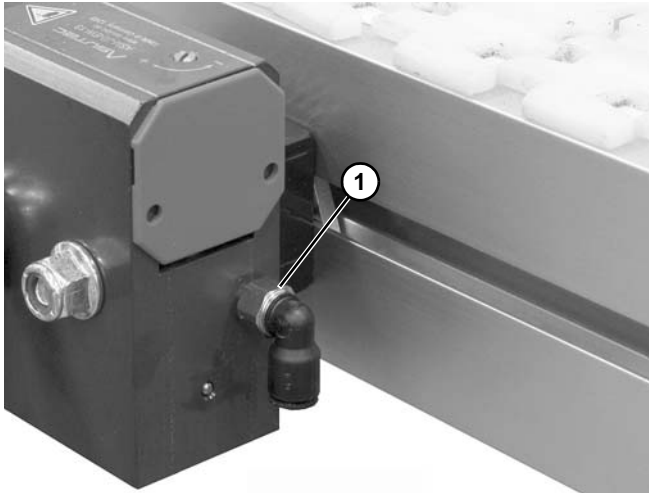


**Figure 16**

# Installation

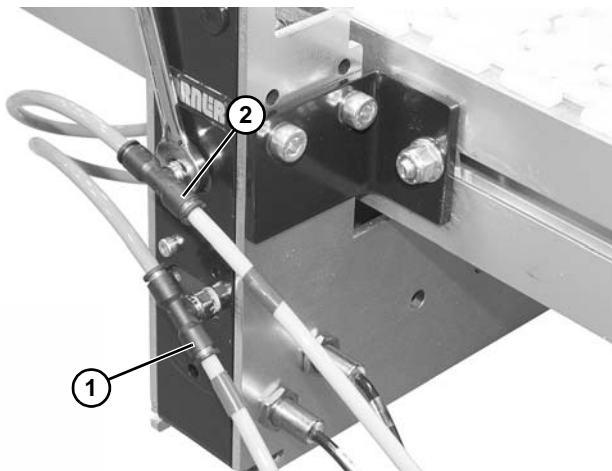
## Attaching and Operations of Pneumatics

1. Connect the 3 port, 2 way solenoid valve to the stop. Dorner fittings (**Figure 17, item 1**) accept 1/4" outside diameter tubing standard.



**Figure 17**

2. Stops release when air is supplied to the stop.
3. Connect Port 4 (**Figure 16**) of the 5 port, 2 way solenoid to the lowest port (**Figure 18, item 1**) on the lift. Dorner fittings accept 1/4" outside diameter tubing standard.
4. Connect Port 2 (**Figure 16**) of the 5 port, 2 way solenoid to the upper port (**Figure 18, item 2**) on the lift. Dorner fittings accept 1/4" outside diameter tubing standard.

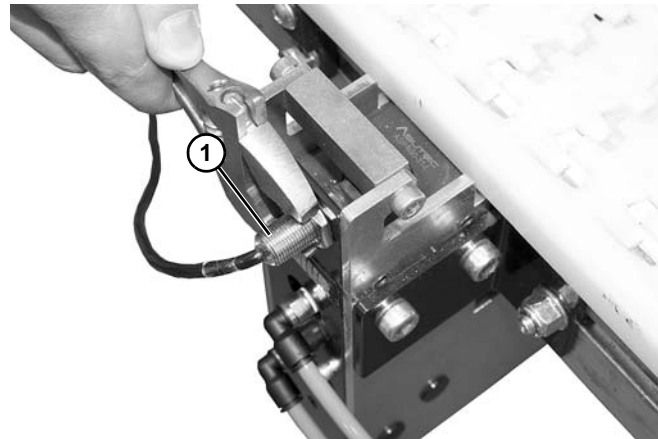


**Figure 18**

- The lift raises when air is supplied to the lower port of the lift and the upper port is allowed to exhaust.
- The lift lowers when air is supplied to the upper port of the lift and the lower port is allowed to exhaust.

## Sensor Installation and Basic Logic

1. Mount pallet sensing 12 mm barrel proximity sensor (**Figure 19, item 1**).



**Figure 19**

- Proximity sensor detects off the pallet stop block.
  - Use proximity sensor to detect pallet located at the stop.
  - The stop can reset when the proximity sensor signal clears.
2. 12 mm barrel proximity sensors can be mounted to the side of the lift that will detect if the lift is in the up or down position:
    - a. Remove screw (**Figure 20, item 1**) from lift side cover.



**Figure 20**

- b. Remove side cover (Figure 21, item 1).

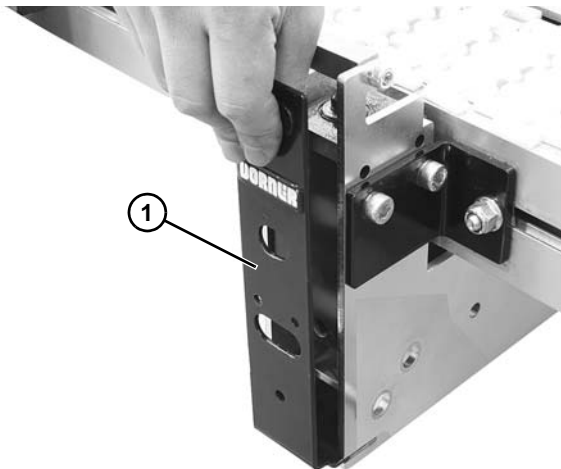


Figure 21

- c. Remove plastic cover and mount sensors (Figure 22, item 1) to lift frame. Install side cover with screw.

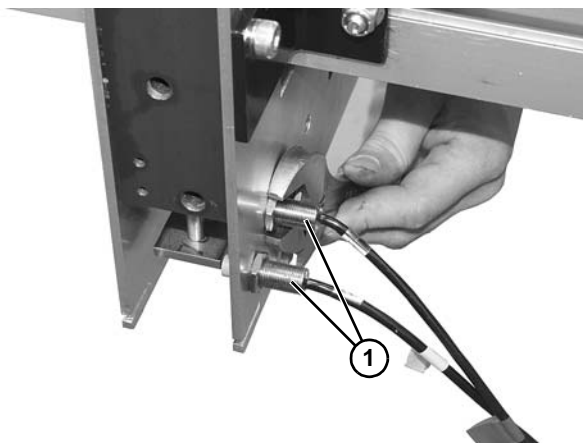


Figure 22

## Divert and Merge

90° Divert-Merge shown. All other configurations are similar. See layout drawings starting on page 14.

### NOTE

*Make sure that the stud(s) rotate inside the channel and engage with the conveyor.*

1. Install conveyor tie plate (Figure 23, item 1) to straight conveyor section (Figure 23, item 2) with two M8 x 35 mm studs (Figure 23, item 3), washers (Figure 23, item 4), and hex nuts (Figure 23, item 5).

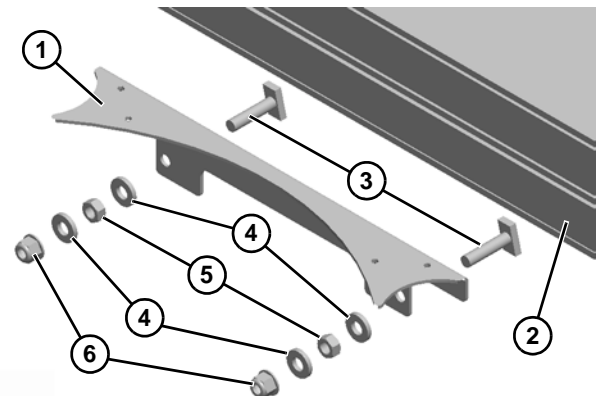


Figure 23

2. Thread on hex nuts (Figure 23, item 6) a couple turns at this time.
3. Install tie bar (Figure 24, item 1) to curved conveyor section (Figure 24, item 2) with two M8 x 20 mm studs (Figure 24, item 3) and hex nuts (Figure 24, item 4).

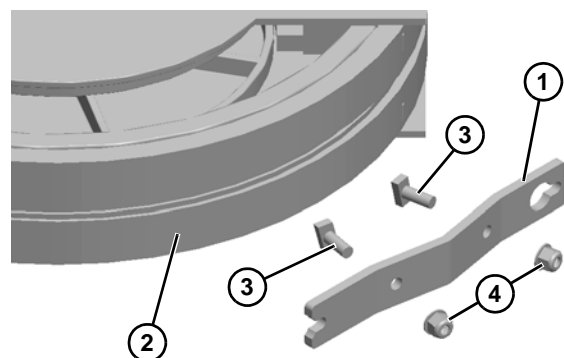
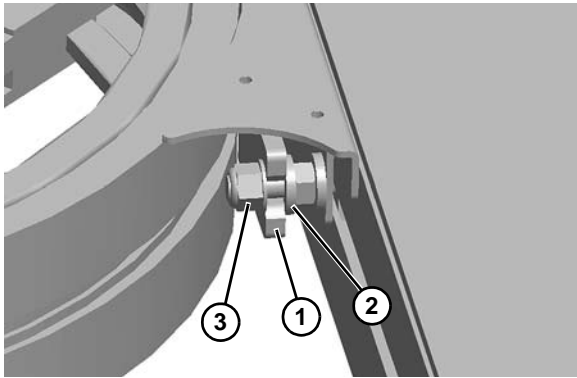


Figure 24

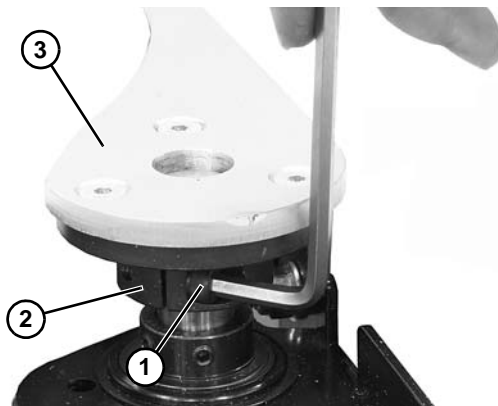
# Installation

4. Connect conveyor sections together. Make sure that the tie bar (**Figure 25, item 1**) is positioned between washers (**Figure 25, item 2**) and hex nuts (**Figure 25, item 3**) on both sides.



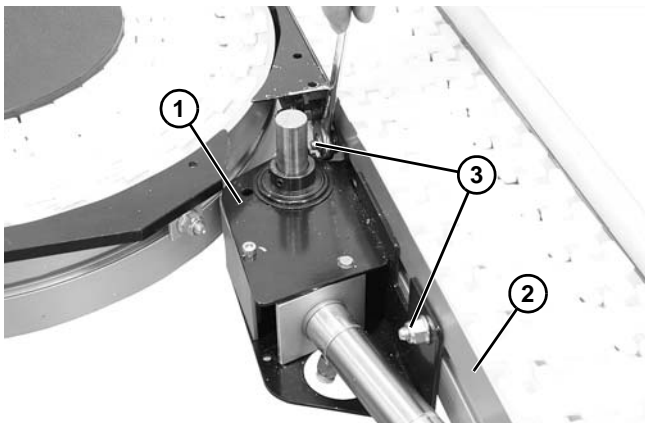
**Figure 25**

5. Tighten hex nuts (**Figure 25, item 3**).
6. To aid in the installation of the diverter assembly, loosen socket head screw (**Figure 26, item 1**) on flange collar (**Figure 26, item 2**). Remove diverter arm (**Figure 26, item 3**).



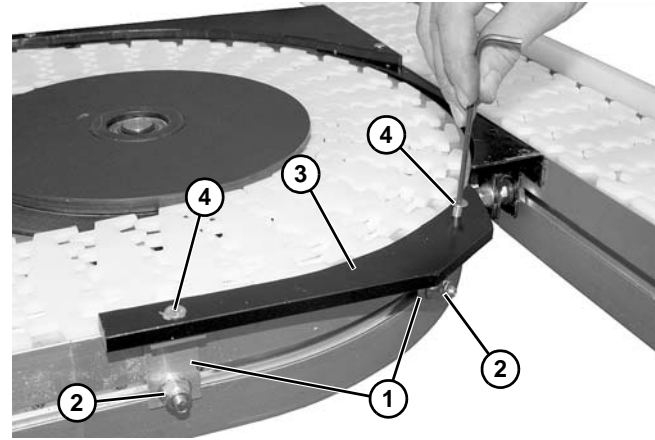
**Figure 26**

7. Install diverter assembly (**Figure 27, item 1**) to conveyor (**Figure 27, item 2**) with two M8 x 20 mm studs and hex nuts (**Figure 27, item 3**).



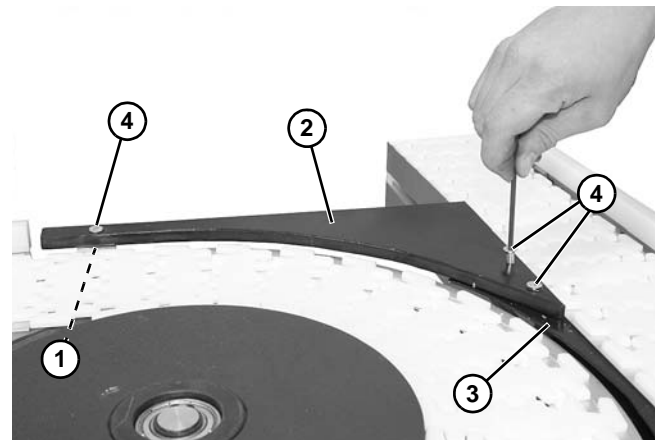
**Figure 27**

8. Tighten hex nuts with wrench.
9. Install diverter arm (**Figure 26, item 3**).
10. Install two angle supports (**Figure 28, item 1**) to conveyor with two M8 x 20 mm studs and hex nuts (**Figure 28, item 2**). Do not tighten hex nuts at this time.



**Figure 28**

11. Install exit wedge guide (**Figure 28, item 3**) to angle supports with two flat head screws (**Figure 28, item 4**).
12. Tighten hex nuts with wrench.
13. Install one angle support (**Figure 29, item 1**) to conveyor with one M8 x 20 mm stud and hex nut. Do not tighten hex nut at this time.



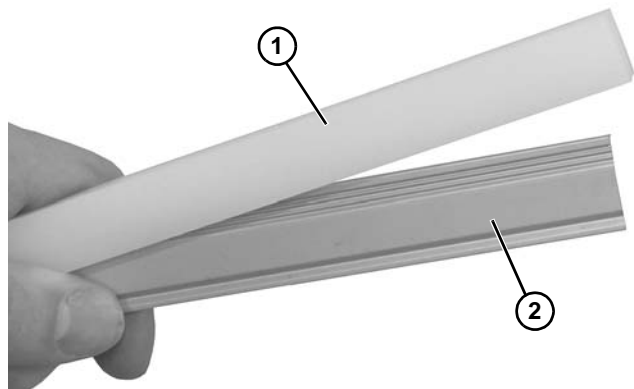
**Figure 29**

14. Install entrance wedge guide (**Figure 29, item 2**) to angle support and conveyor tie plate (**Figure 29, item 3**) with three flat head screws (**Figure 29, item 4**).
15. Tighten hex nut with wrench.

## Guiding

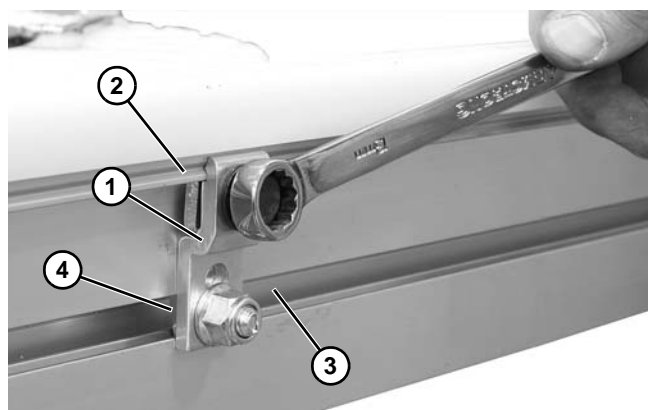
For exact locations refer to layout drawings starting on page 14.

1. Attach wear strip (**Figure 30, item 1**) to guiding (**Figure 30, item 2**).



**Figure 30**

2. Attach clip (**Figure 31, item 1**) to guiding (**Figure 31, item 2**).



**Figure 31**

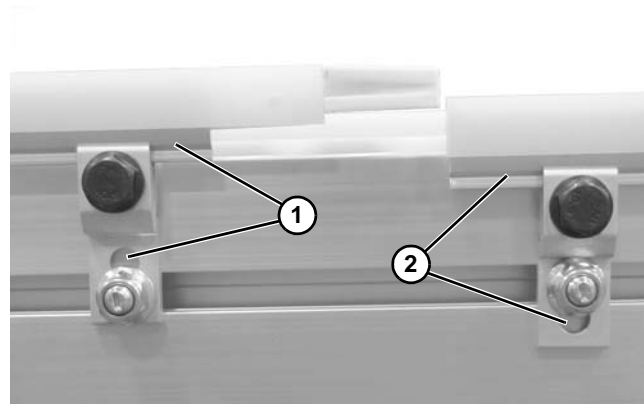
### NOTE

Make sure that the studs (**Figure 31, item 4**) rotate inside the channel and engage with the conveyor.

3. Attach clip (**Figure 31, item 1**) to conveyor (**Figure 31, item 3**).

### NOTE

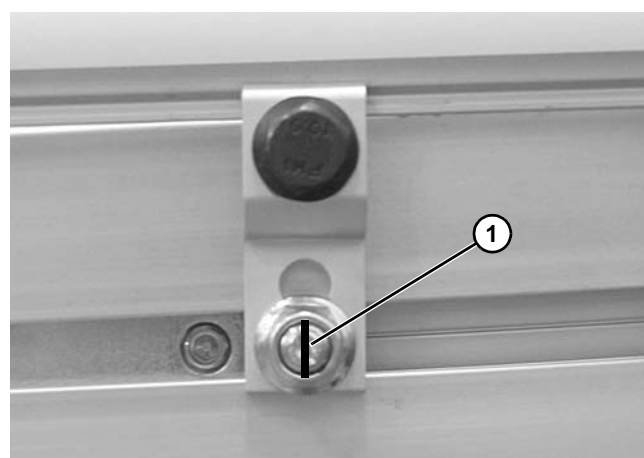
Guiding can be assembled in a high position (**Figure 32, item 1**) or a low position (**Figure 32, item 2**).



**Figure 32**

### NOTE

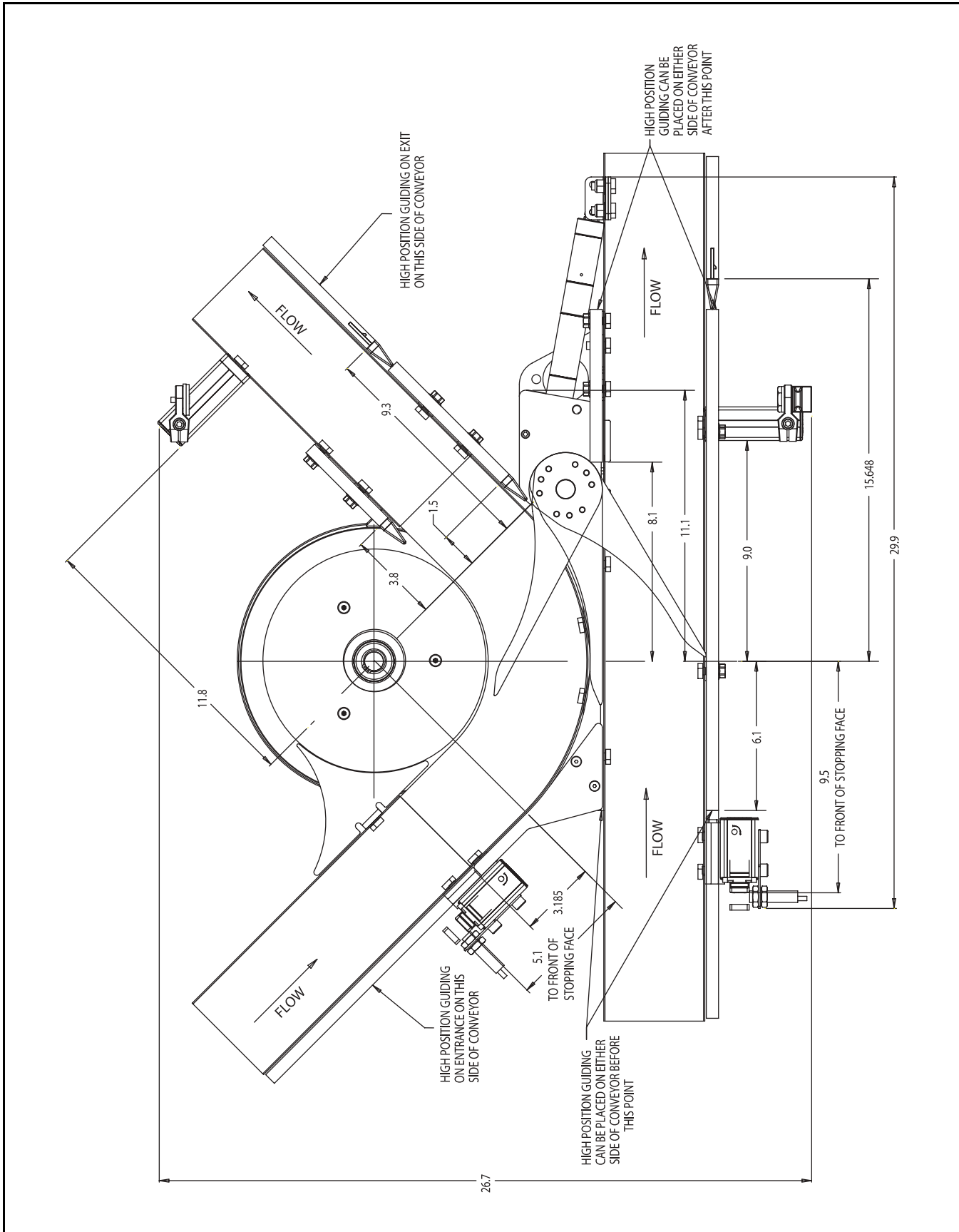
Be certain that slot (**Figure 33, item 1**) is close to vertical when finished tightening nut.



**Figure 33**

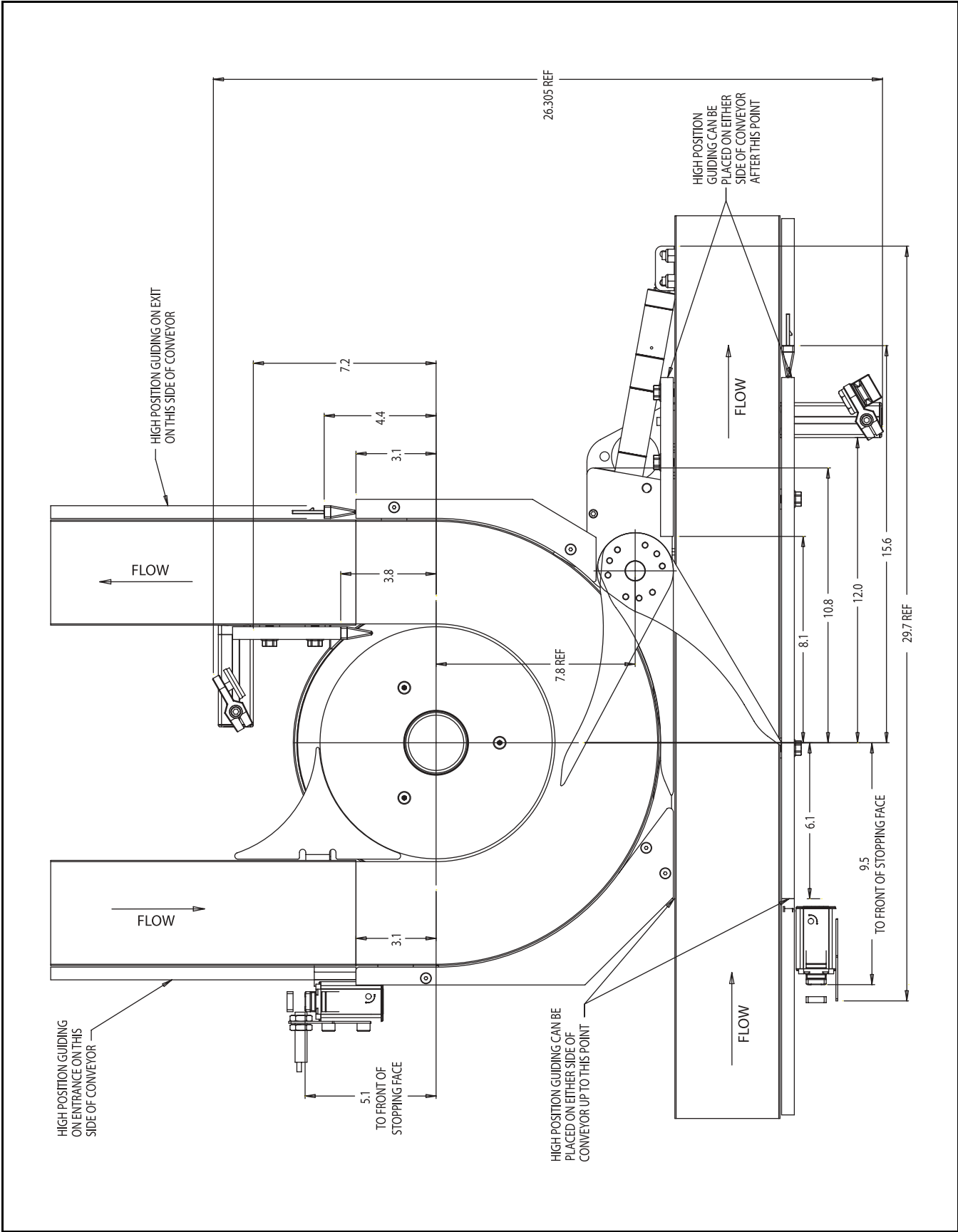
# Installation

## 45° Divert-Merge Layout



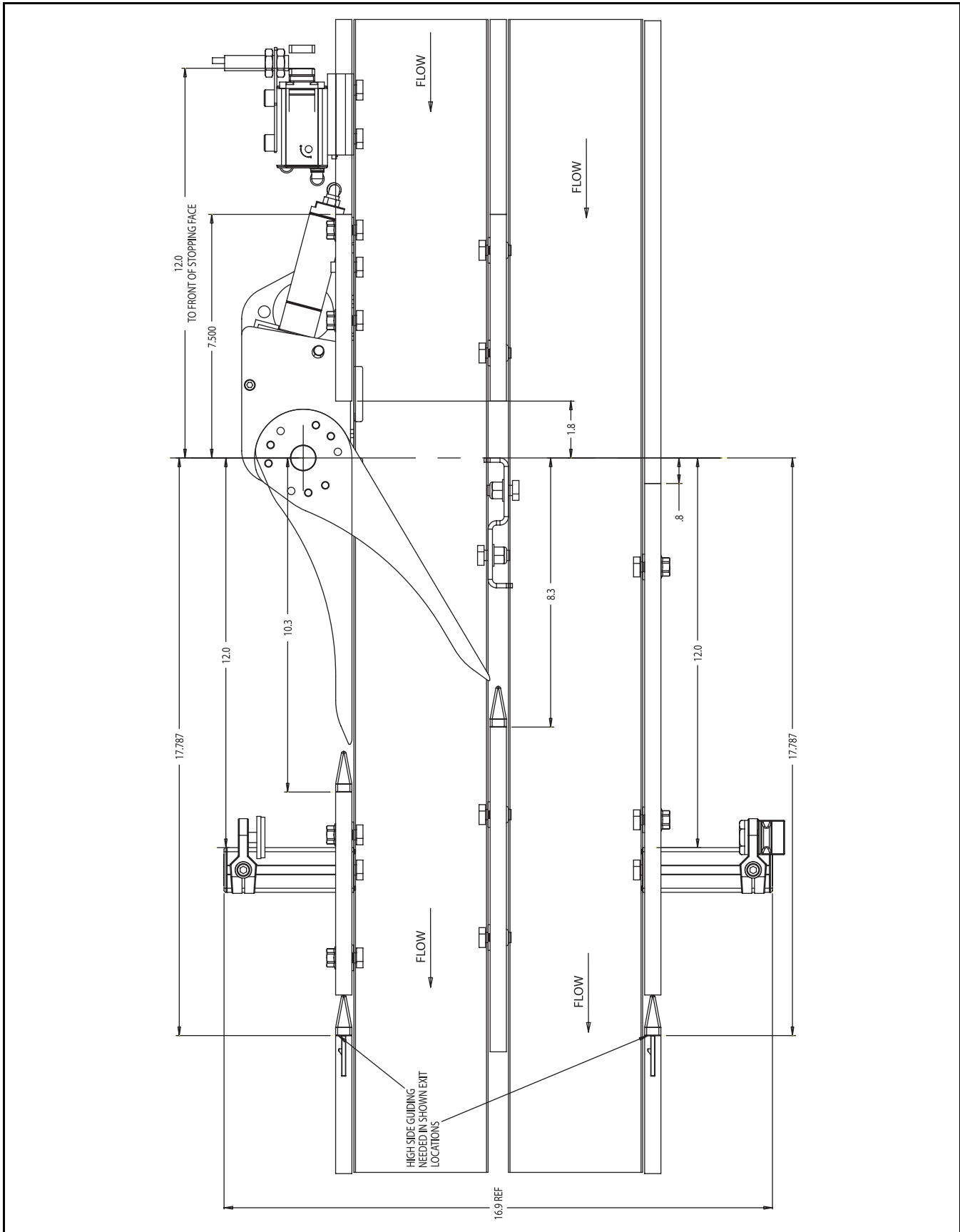
SmartFlex Pallet System Accessories

90° Divert-Merge Layout



# Installation

## Parallel Divert-Merge Layout

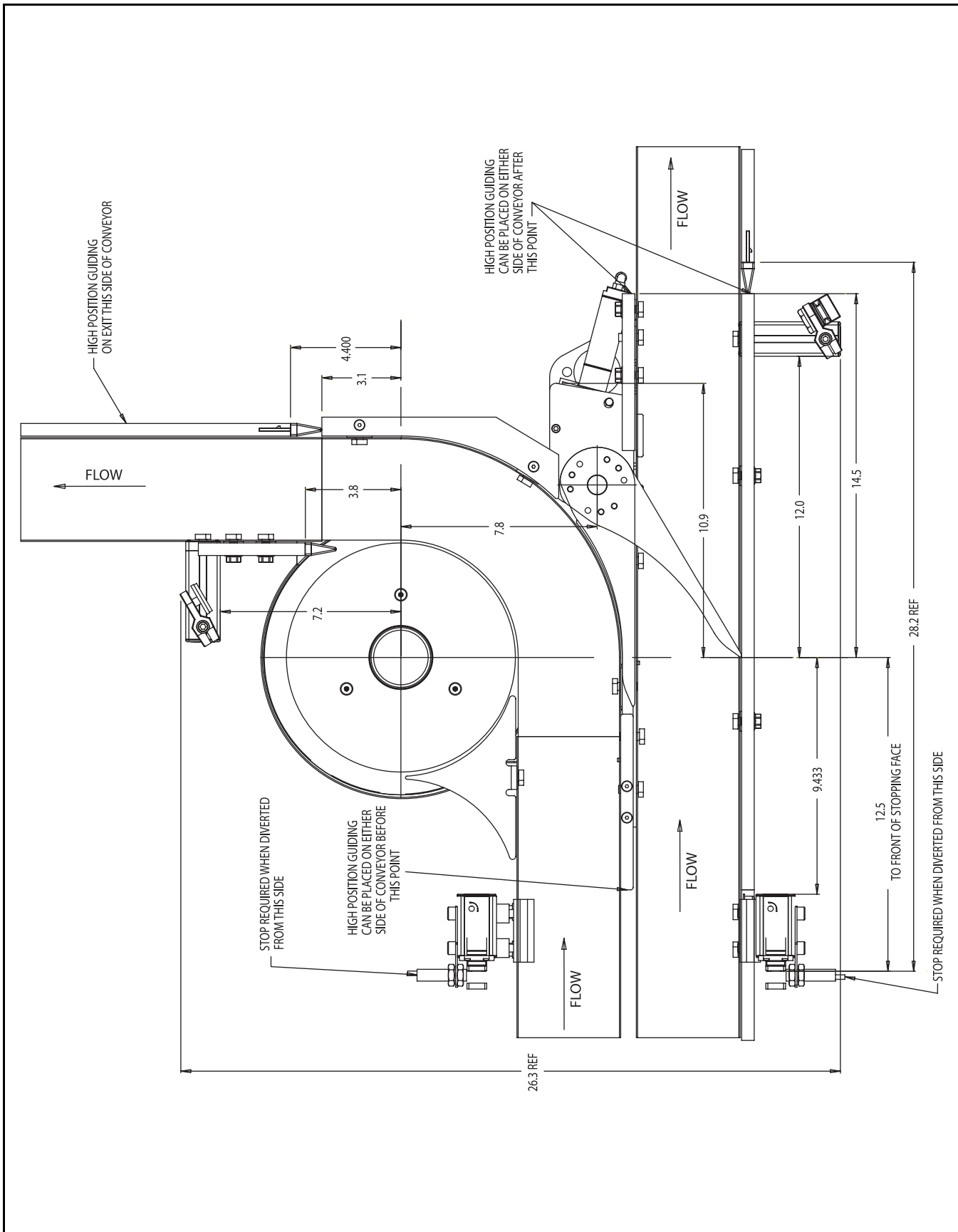






# Installation

## 90° Parallel Divert-Merge Layout

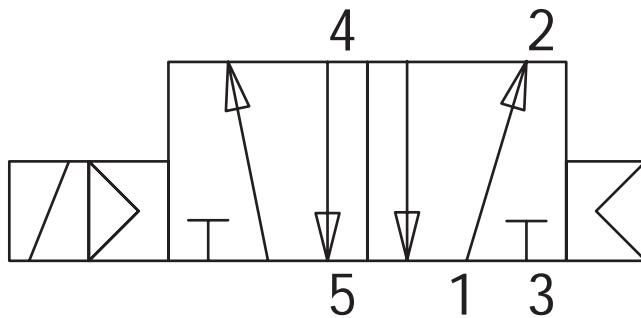


## Pneumatic and Control Logic Suggestions

### Diverts Only

#### Recommended Pneumatics

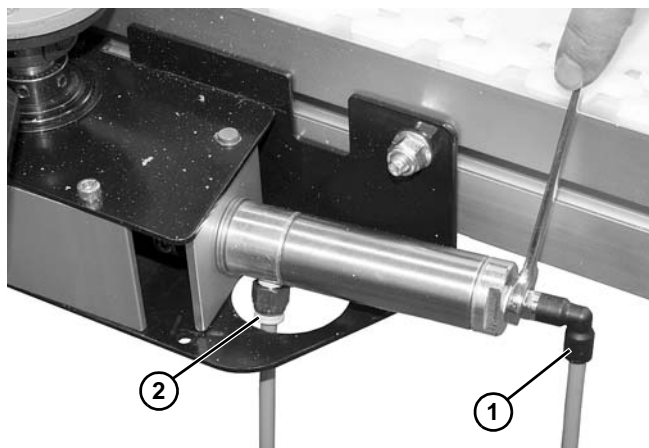
Dorner recommends using a 5 port, 2 way solenoid valve (Figure 34) to divert.



**Figure 34**

#### Attaching and Operations of Pneumatics

1. Connect Port 4 (Figure 34) of the 3 port, 2 way solenoid to the cylinders back port (Figure 35, item 1). Dorner fittings accept 1/4" outside diameter tubing standard.
2. Connect Port 2 (Figure 34) of the 3 port, 2 way solenoid to the cylinders front port (Figure 35, item 2). Dorner fittings accept 1/4" outside diameter tubing standard.

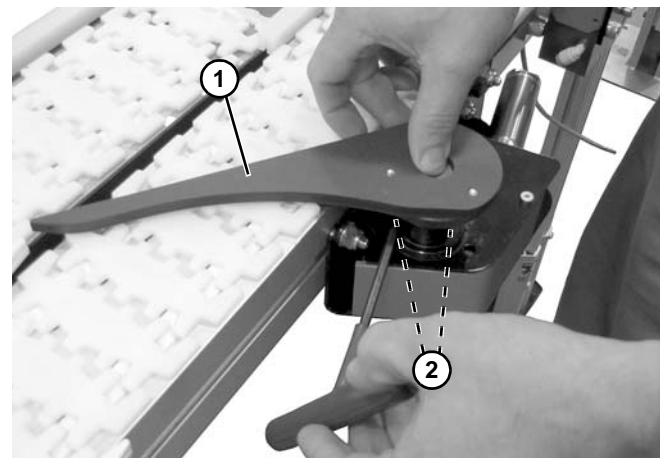


**Figure 35**

- The divert arm will swing into the conveyor when air is supplied to the back port of the cylinder and the front port is allowed to exhaust.
- The divert arm will swing away from the conveyor when air is supplied to the front port of the cylinder and the back port is allowed to exhaust.

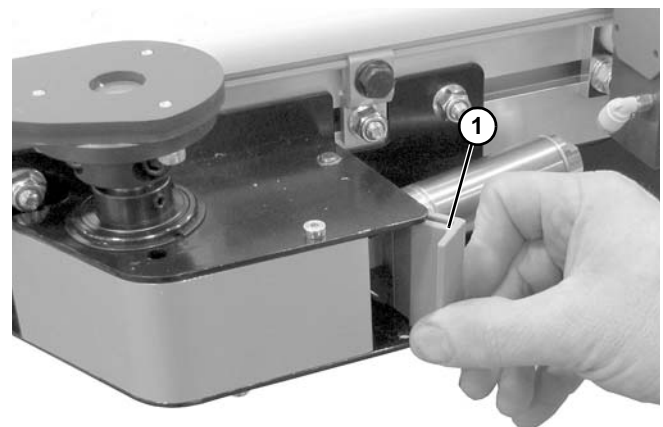
3. Adjust limits:

- a. Move divert to maximum displacement angle (Figure 36, item 1).



**Figure 36**

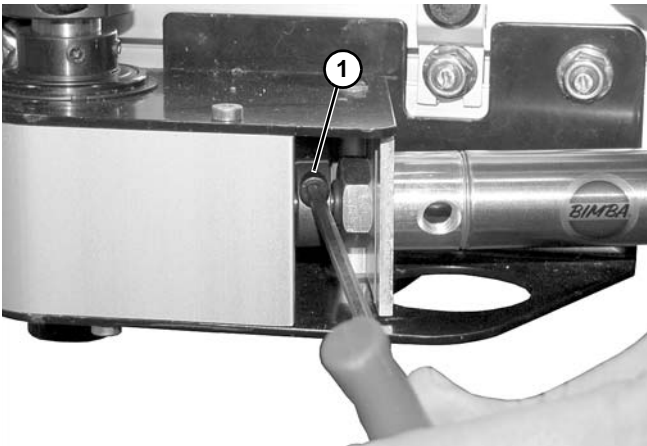
- b. Loosen two fasteners (Figure 36, item 2).
- c. Reposition divert to the desired end location and tighten fasteners.
- d. Remove guard (Figure 37, item 1).



**Figure 37**

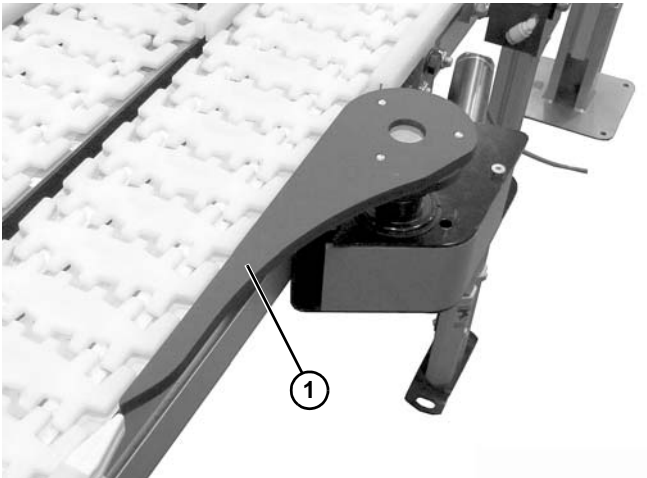
# Installation

- e. Loosen stop collar (**Figure 38, item 1**) or cylinder.



**Figure 38**

- f. Move divert (**Figure 39, item 1**) to desired minimum position and tighten fasteners.

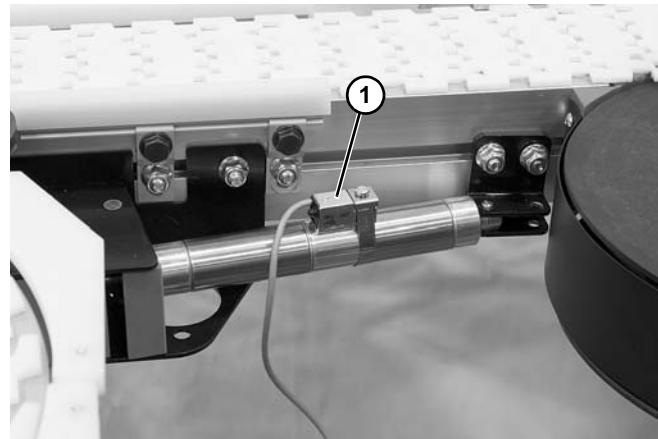


**Figure 39**

- g. Verify divert movement by energizing cylinder.

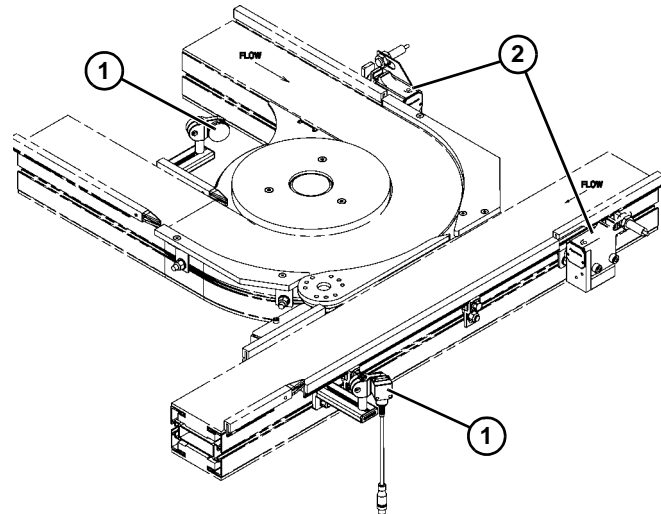
## Sensor Installation and Basic Logic

Reed sensors (**Figure 40, item 1**) can be mounted on the cylinder. A divert module with magnet installed must be requested.



**Figure 40**

A photo eye kit (**Figure 41, item 1**) can be mounted in a manner that will sense pallets in the divert zone.



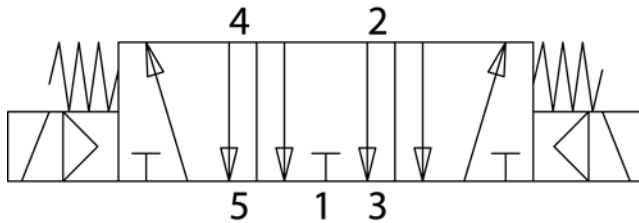
**Figure 41**

- Once pallet has cleared the photo eye, the traffic control stops (**Figure 41, item 2**) can allow a new pallet into the zone.

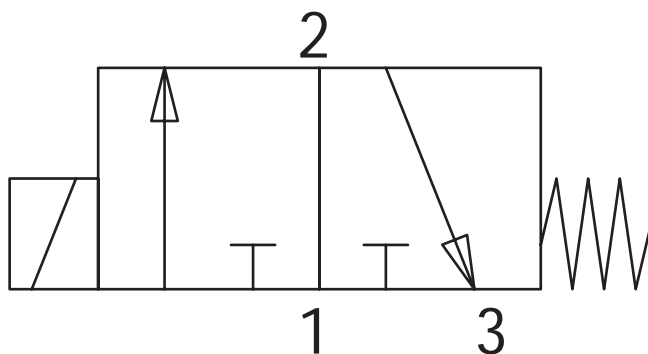
## Diverts and Merge

### Recommended Pneumatics

Dorner recommends using a 5 port, 3 way, exhaust center (**Figure 42**) and 3 port, 2 way solenoid valve (**Figure 43**) to operate divert and merge.

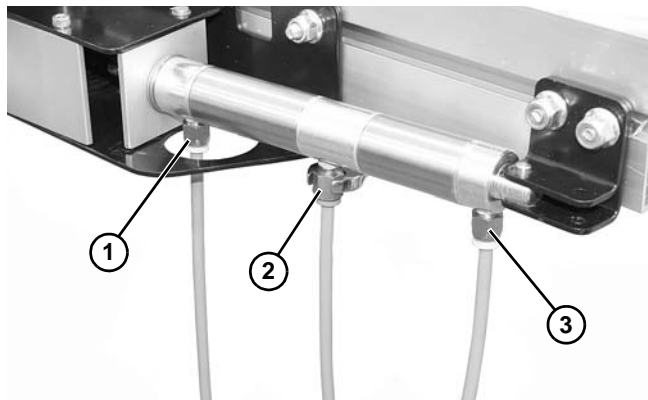


**Figure 42**



**Figure 43**

### Attaching and Operations of Pneumatics



**Figure 44**

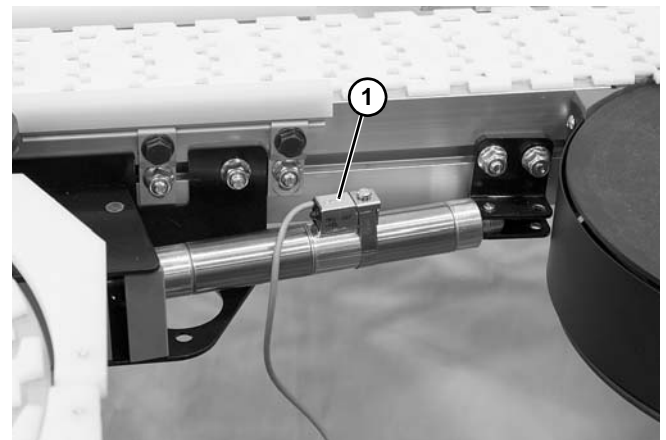
1. Connect Port 4 (**Figure 42**) of the 5 port, 3 way solenoid to the cylinder front port (**Figure 44, item 1**). Dorner fittings accept 1/4" Outside Diameter tubing.
2. Connect Port 2 (**Figure 42**) of the 5 port, 3 way solenoid to the cylinders middle port (**Figure 44, item 2**). Dorner fittings accept 1/4" Outside Diameter tubing.

3. Connect the 3 port, 2 way solenoid (**Figure 43**) to the cylinders back port (**Figure 44, item 3**). Dorner fittings accept 1/4" Outside Diameter tubing.

- The divert arm will be fully extended into the conveyor when both the middle port and the back port is pressurized and the front port is allowed to exhaust.
- The divert arm will be at its middle position when both the back port and the front port are pressurized and the middle port is allowed to exhaust.
- The divert arm will be fully retracted away from the attached conveyor frame when the front port is pressurized and the middle and back ports allowed to exhaust.

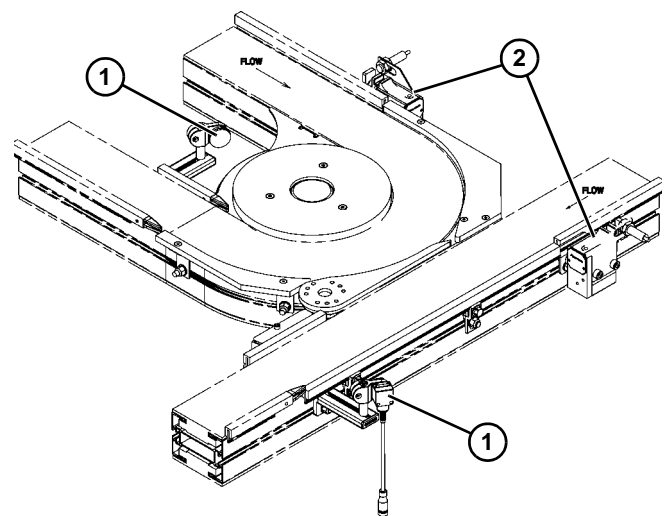
### Sensor Installation and Basic Logic

Reed sensors (**Figure 45, item 1**) can be mounted on the cylinder. A divert module with magnet installed must be requested.



**Figure 45**

A photo eye kit (**Figure 46, item 1**) can be mounted in a manner that will sense pallets in the divert and merge zone.



**Figure 46**

- Once pallet has cleared the photo eye, the traffic control stops (**Figure 46, item 2**) can allow a new pallet into the zone.

# Installation

## Fixed Merge

### Merge

#### NOTE

Make sure that the stud(s) rotate inside the channel and engage with the conveyor.

1. Install conveyor tie plate (Figure 47, item 1) to straight conveyor section (Figure 47, item 2) with two M8 x 35 mm studs (Figure 47, item 3), washers (Figure 47, item 4), and hex nuts (Figure 47, item 5).

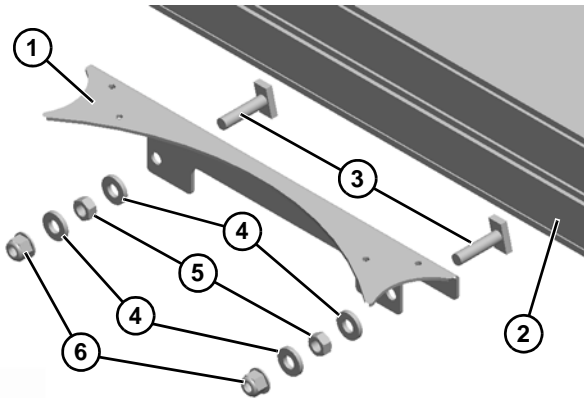


Figure 47

2. Thread on hex nuts (Figure 47, item 6) a couple turns at this time.
3. Install tie bar (Figure 48, item 1) to curved conveyor section (Figure 48, item 2) with two M8 x 20 mm studs (Figure 48, item 3) and hex nuts (Figure 48, item 4).

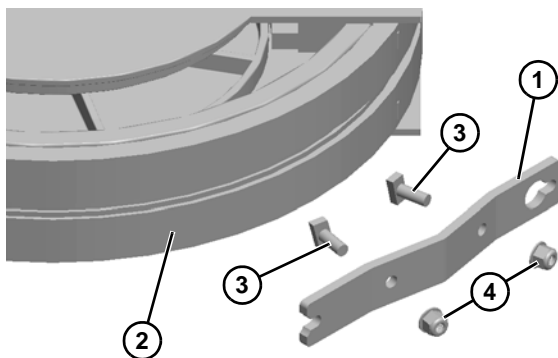


Figure 48

4. Connect conveyor sections together. Make sure that the tie bar (Figure 49, item 1) is positioned between washers (Figure 49, item 2) and hex nuts (Figure 49, item 3) on both sides.

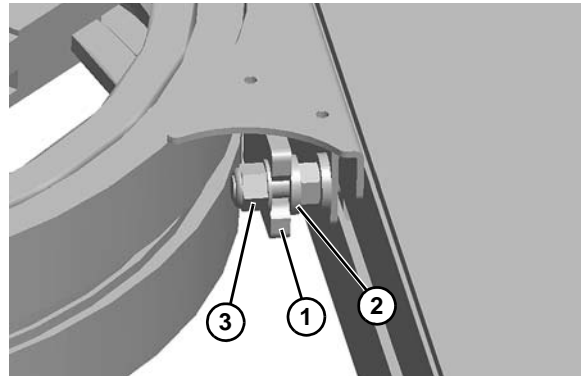


Figure 49

5. Tighten hex nuts (Figure 49, item 3).
6. Install 45 degree corner guide (Figure 50, item 1) to conveyor tie plate (Figure 50, item 2) with two flat head screws (Figure 50, item 3).

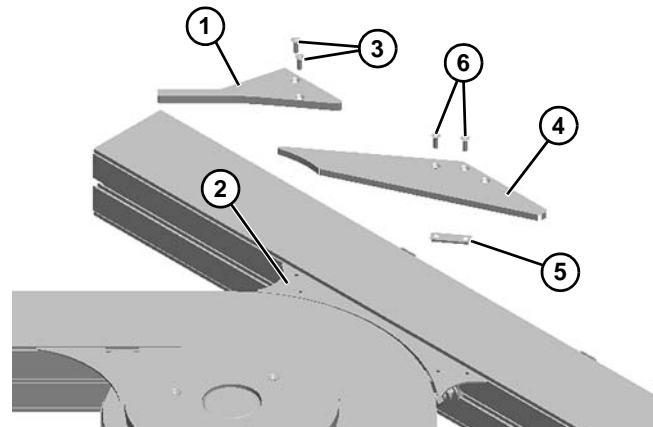


Figure 50

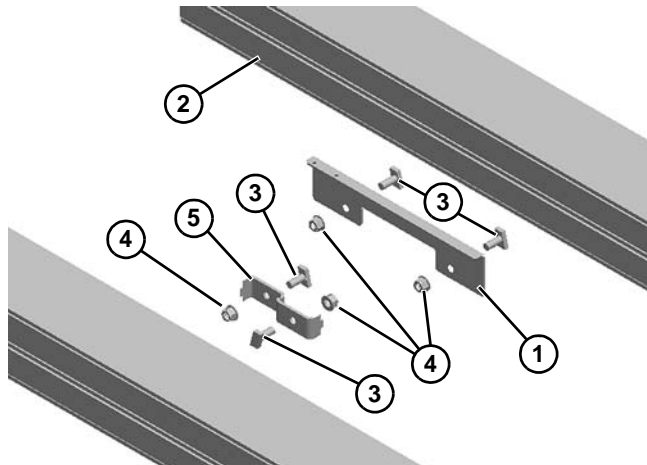
7. Install corner guide (Figure 50, item 4) to conveyor tie plate (Figure 50, item 2) with spacer (Figure 50, item 5) and two flat head screws (Figure 50, item 6).

## Parallel Merge

### NOTE

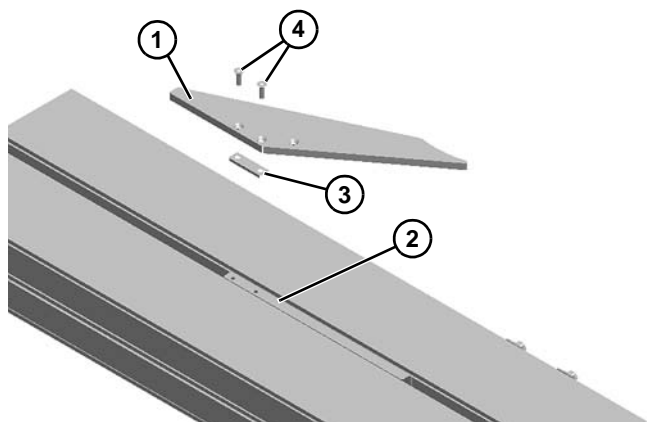
*Make sure that the stud(s) rotate inside the channel and engage with the conveyor.*

1. Install conveyor tie plate (**Figure 51, item 1**) to conveyor section (**Figure 51, item 2**) with two M8 x 20 mm studs (**Figure 51, item 3**) and hex nuts (**Figure 51, item 4**).



**Figure 51**

2. Install frame connecting clip (**Figure 51, item 5**) to conveyor sections with two M8 x 20 mm studs (**Figure 51, item 3**) and hex nuts (**Figure 51, item 4**).
3. Tighten hex nuts (**Figure 51, item 4**).
4. Install corner guide (**Figure 52, item 1**) to conveyor tie plate (**Figure 52, item 2**) with spacer (**Figure 52, item 3**) and two flat head screws (**Figure 52, item 4**).

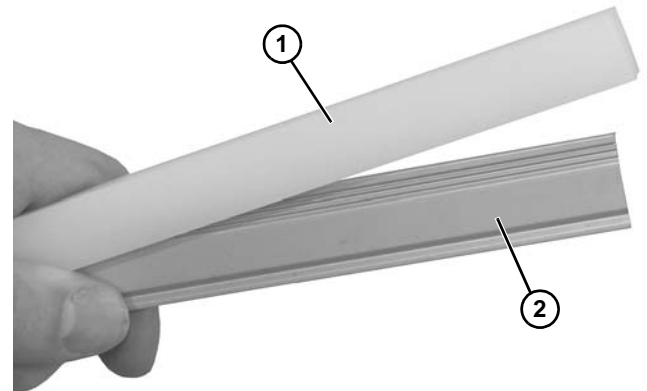


**Figure 52**

## Guiding

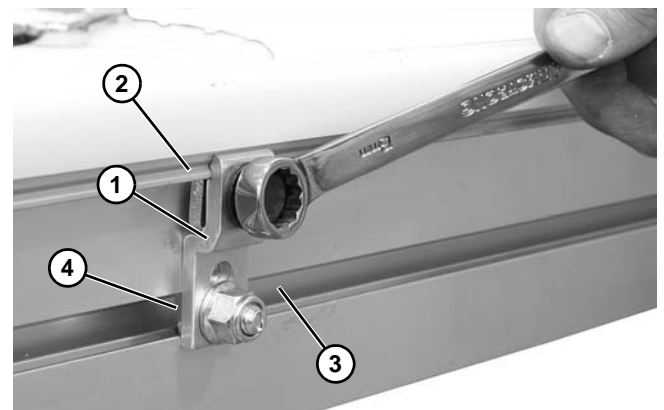
For exact locations refer to layout drawings starting on page 25.

1. Attach wear strip (**Figure 53, item 1**) to guiding (**Figure 53, item 2**).



**Figure 53**

2. Attach clip (**Figure 54, item 1**) to guiding (**Figure 54, item 2**).



**Figure 54**

### NOTE

*Make sure that the studs (**Figure 54, item 4**) rotate inside the channel and engage with the conveyor.*

3. Attach clip (**Figure 54, item 1**) to conveyor (**Figure 54, item 3**).

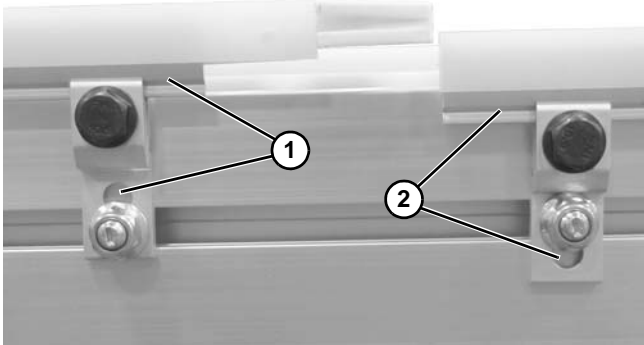
---

# Installation

---

## NOTE

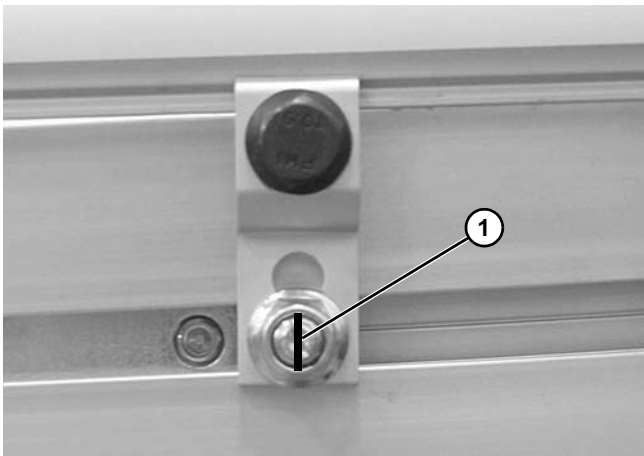
Guiding can be assembled in a high position (**Figure 55, item 1**) or a low position (**Figure 55, item 2**).



**Figure 55**

## NOTE

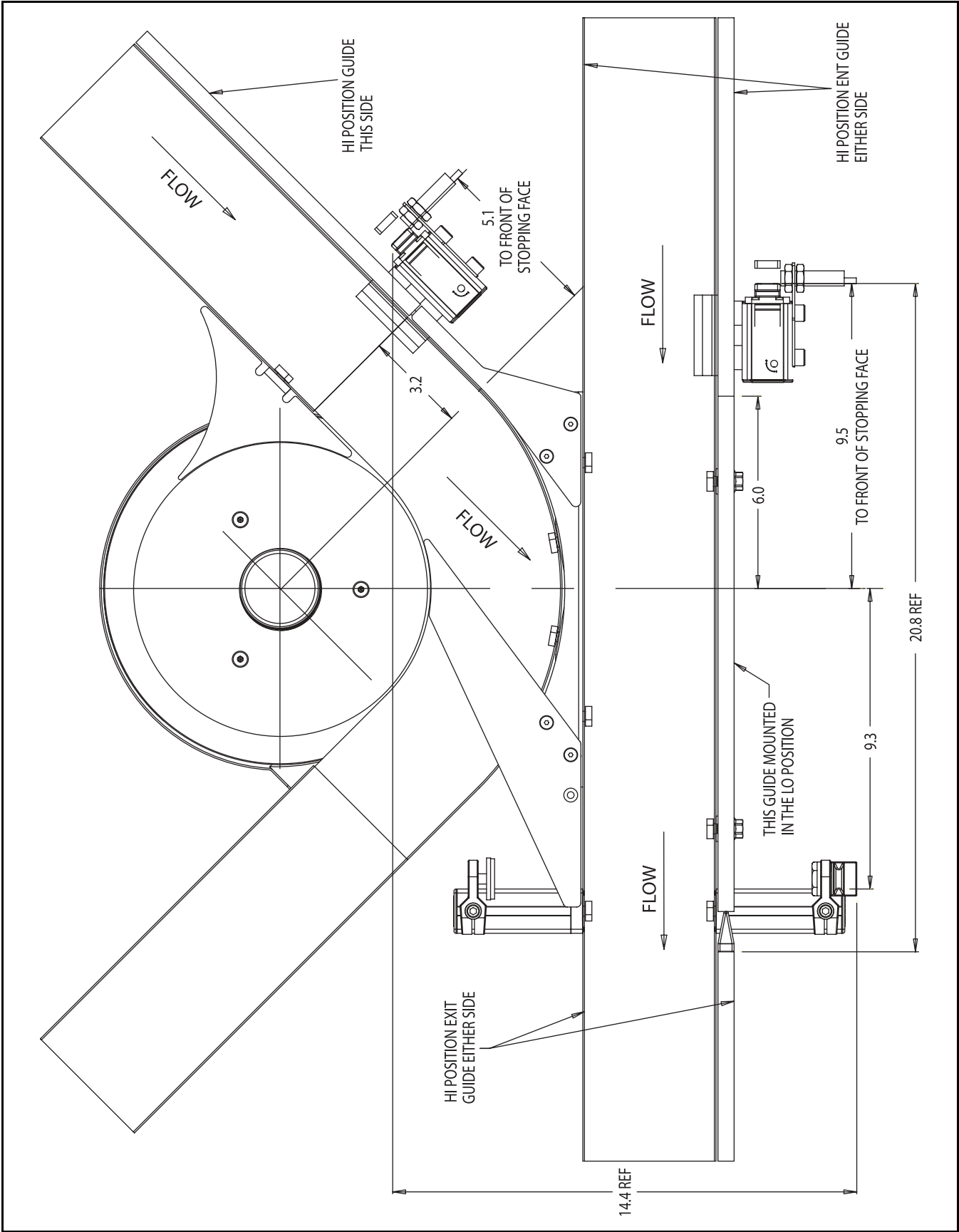
Be certain that slot (**Figure 56, item 1**) is close to vertical when finished tightening nut.



**Figure 56**

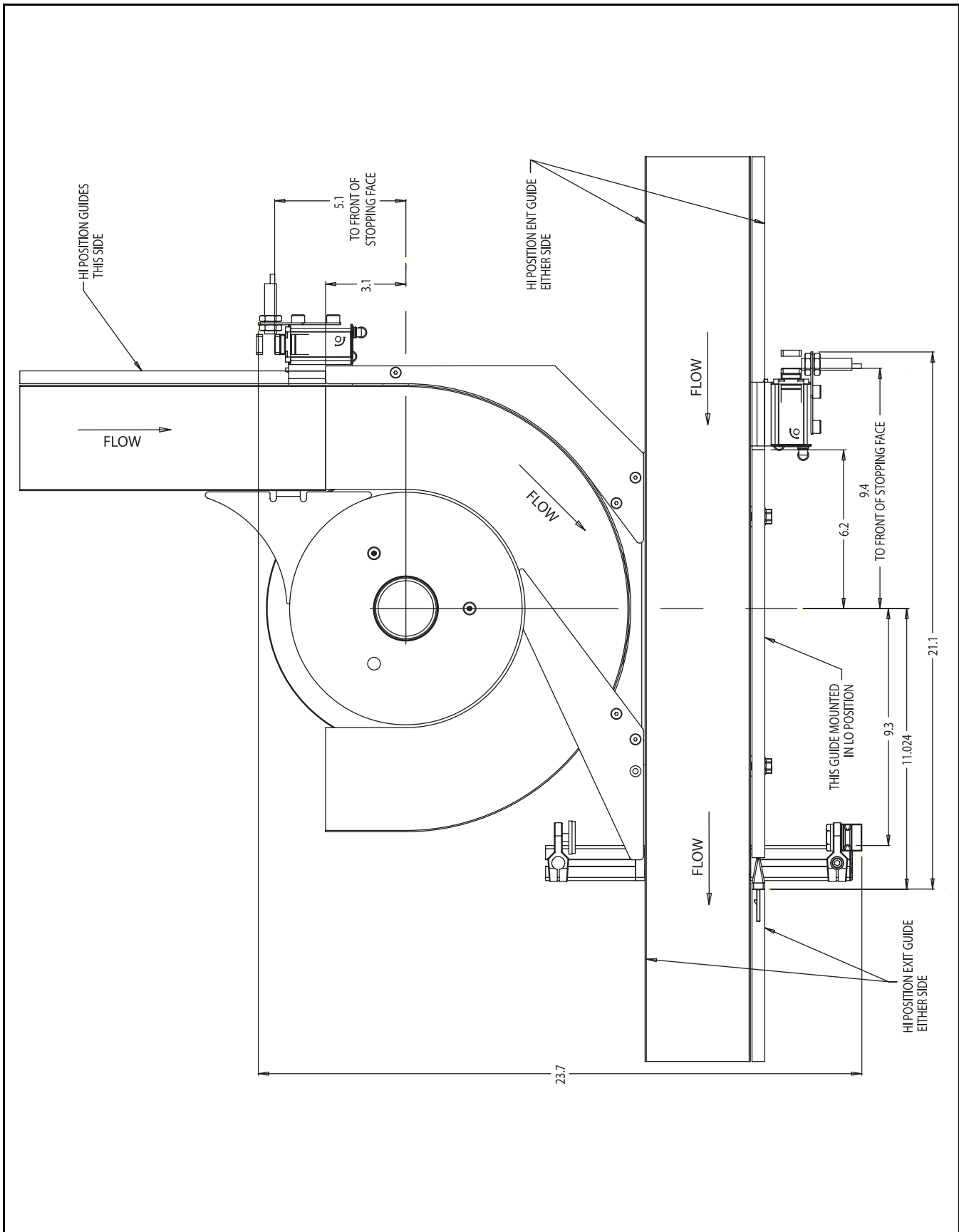


45° Merge Layout

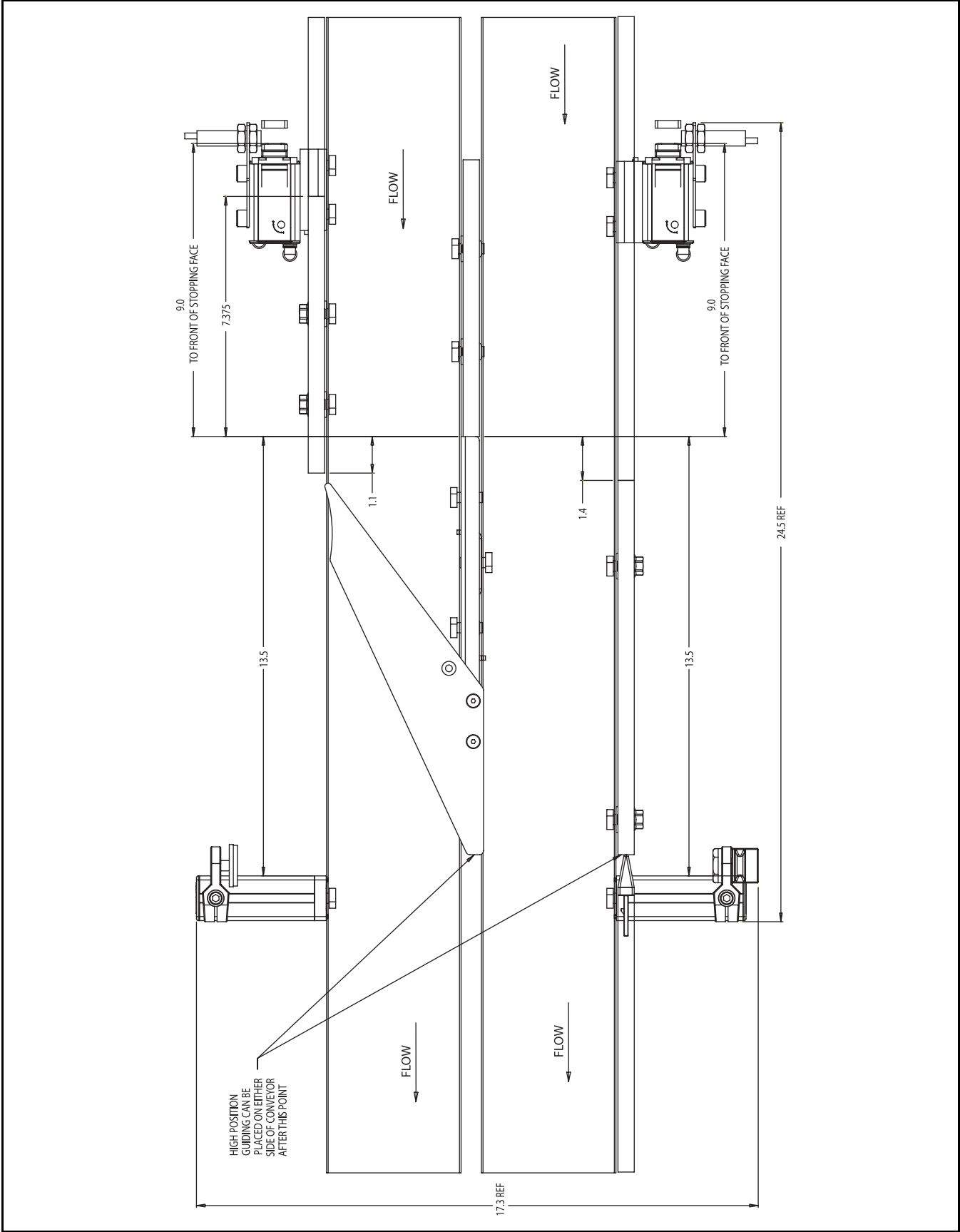


# Installation

## 90° Merge Layout

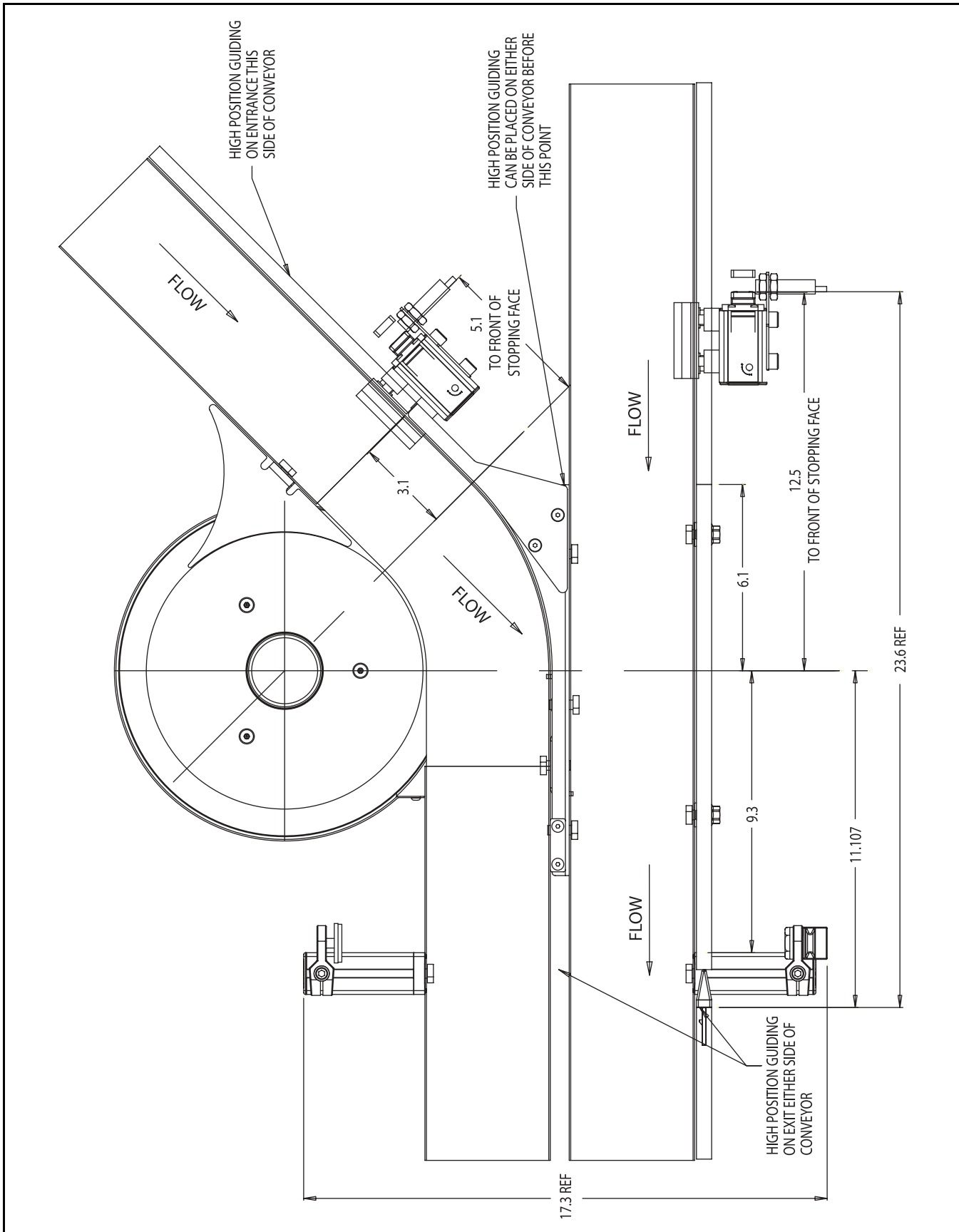


Parallel Merge Layout

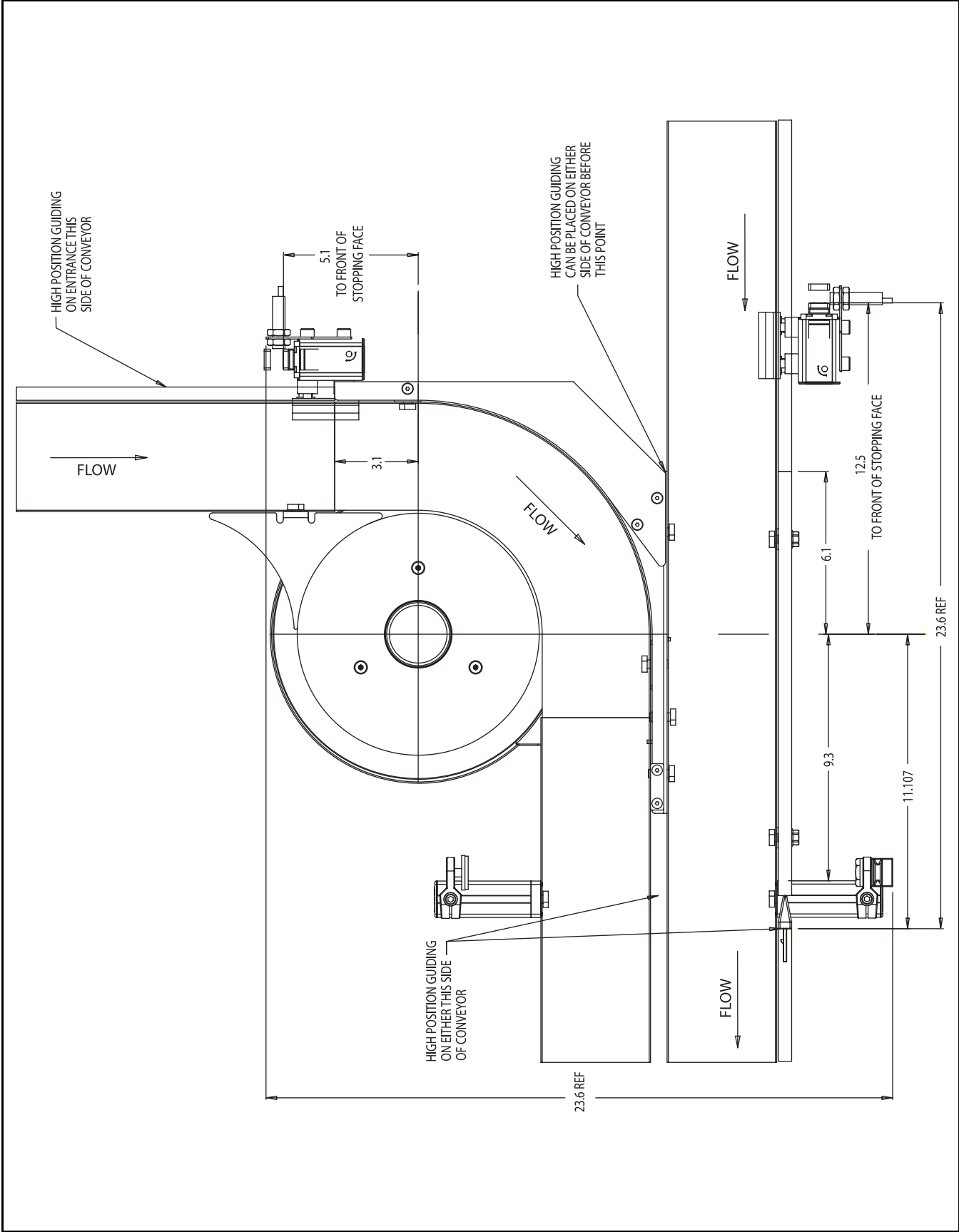


# Installation

## 45° Parallel Merge Layout



90° Parallel Merge Layout



# Preventive Maintenance and Adjustment

## Required Tools

- 3/32" hex wrench
- 3 mm hex wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 7 mm wrench
- 10 mm wrench
- 13 mm wrench
- Belt Removal Tool #203480

## Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 34 for recommendations.
- Replace any worn or damaged parts.

## Pallets

1. Remove pallet from conveyor.
2. Remove four socket head screws (**Figure 57, item 1**) and remove pucks (**Figure 57, item 2**).

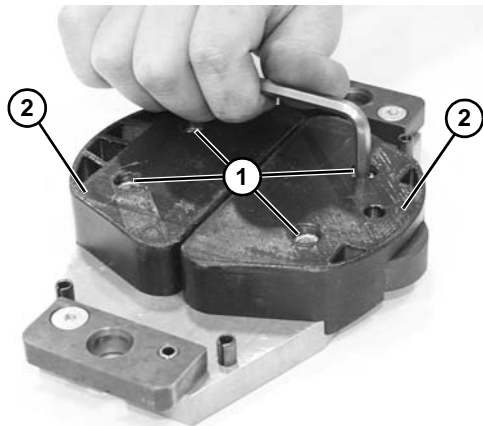


Figure 57

3. Turn over bumper pallet puck (**Figure 58, item 1**) and remove bumper (**Figure 58, item 2**) and washer (**Figure 58, item 3**).

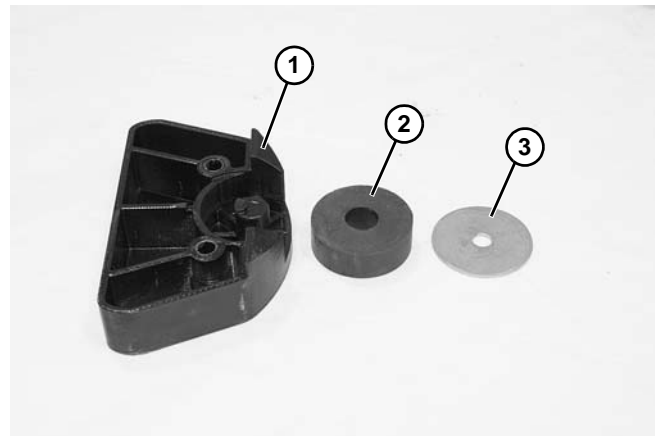


Figure 58

4. Replace worn or damaged parts.

## Pallet Stops

### Removal

For removal of Pallet Stops, reverse the installation procedure. Refer to "Pallet Stops" starting on page 6.

## Lift and Locate Station

1. Remove fittings (**Figure 59, item 1**) on both sides of the lift and locate station.

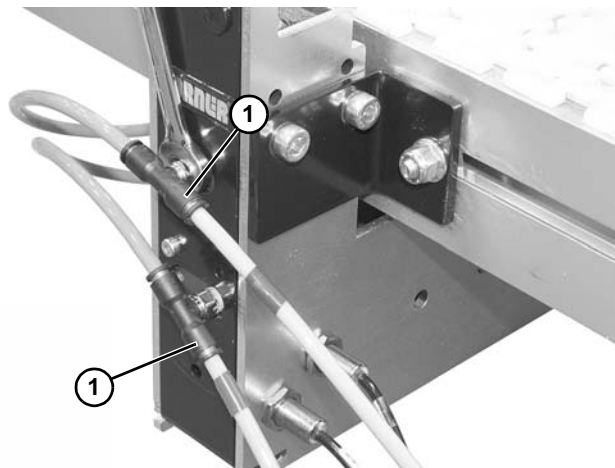
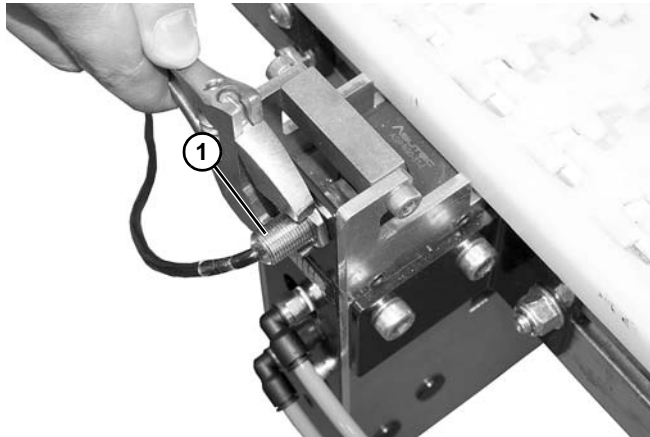


Figure 59

# Preventive Maintenance and Adjustment

2. Remove pallet proximity sensor (**Figure 60, item 1**).



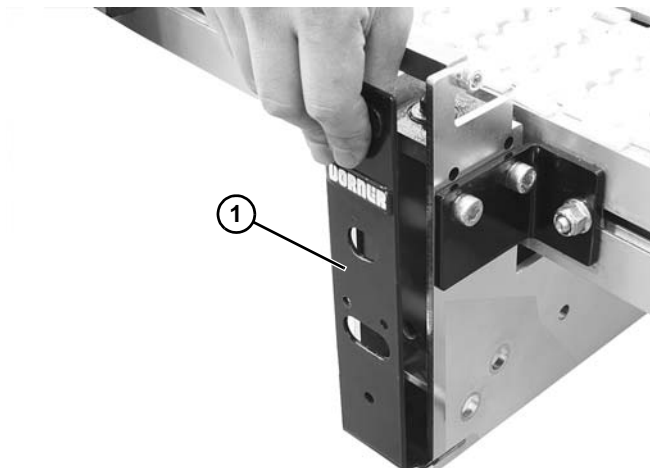
**Figure 60**

3. Remove screw (**Figure 61, item 1**) from lift side cover.



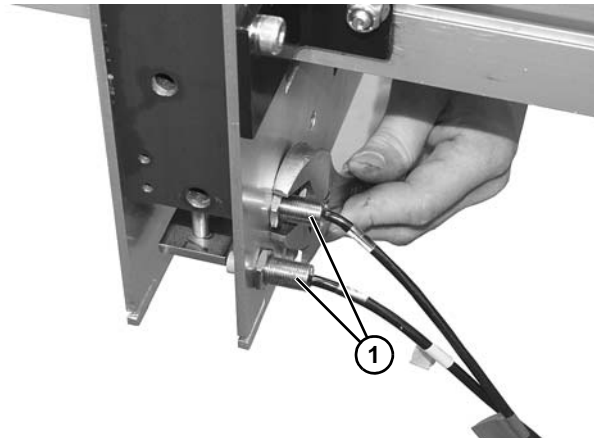
**Figure 61**

4. Remove side cover (**Figure 62, item 1**).



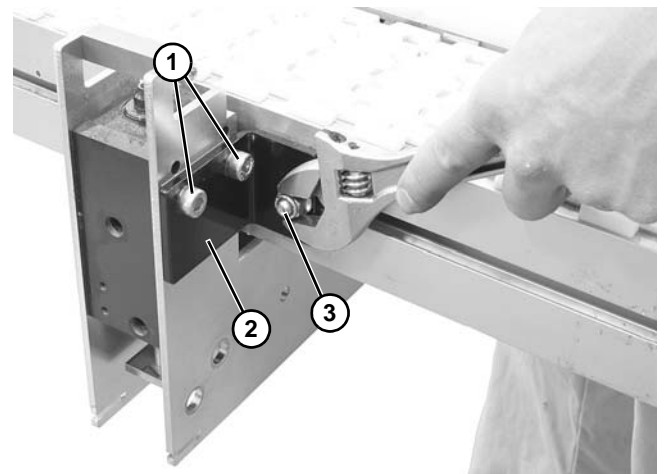
**Figure 62**

5. Remove proximity sensors (**Figure 63, item 1**) from lift side of unit.



**Figure 63**

6. Remove two socket head screws (**Figure 64, item 1**) securing the angle bracket (**Figure 64, item 2**) to the lift and locate station.

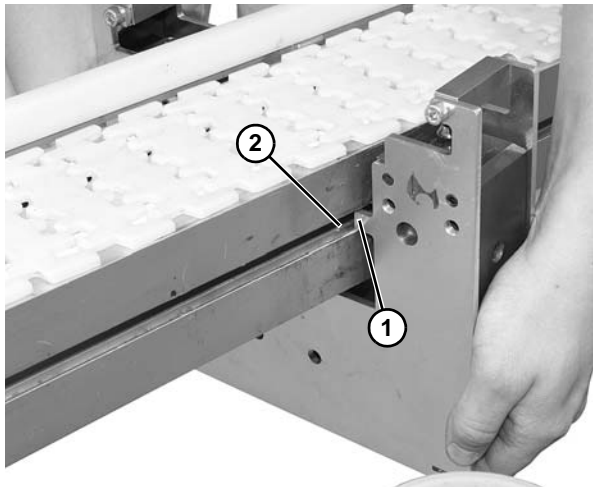


**Figure 64**

7. Loosen hex nut (**Figure 64, item 3**) securing angle bracket to conveyor and slide out of the way.
8. Repeat on opposite side of conveyor.

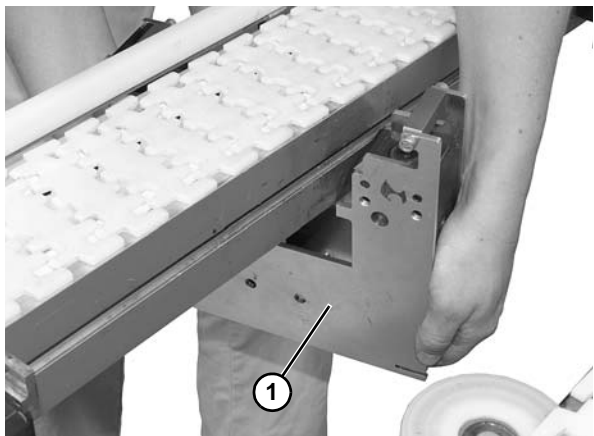
# Preventive Maintenance and Adjustment

9. Rotate lift and locate station so that the tabs (**Figure 65, item 1**) on both sides disengage from the channel (**Figure 65, item 2**) of the conveyor.



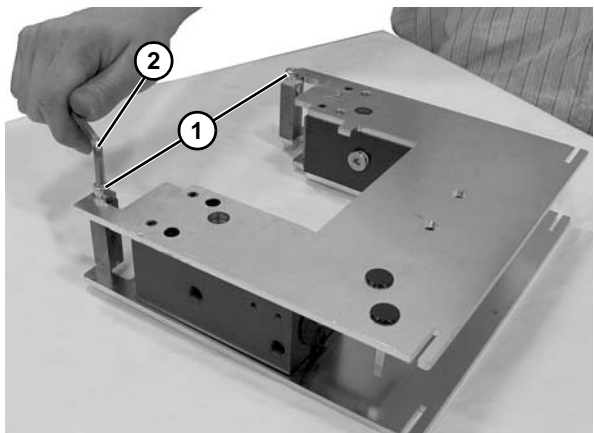
**Figure 65**

10. Lower lift and locate station (**Figure 66, item 1**), on an angle as shown, and remove from under the conveyor.



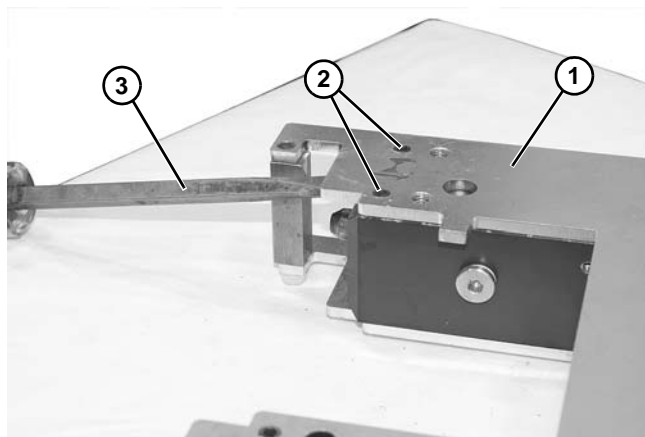
**Figure 66**

11. Remove two socket head screws (**Figure 67, item 1**) with allen wrench (**Figure 67, item 2**).



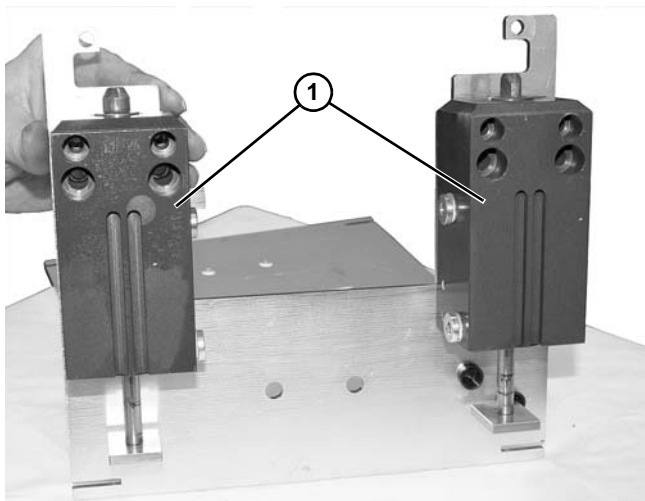
**Figure 67**

12. Pry side plate (**Figure 68, item 1**) from groove pins (**Figure 68, item 2**) using a flat blade screw driver (**Figure 68, item 3**) on both sides of lift and locate station.



**Figure 68**

13. Remove lift unit(s) (**Figure 69, item 1**) from groove pins.



**Figure 69**

14. Replace worn or damaged parts.

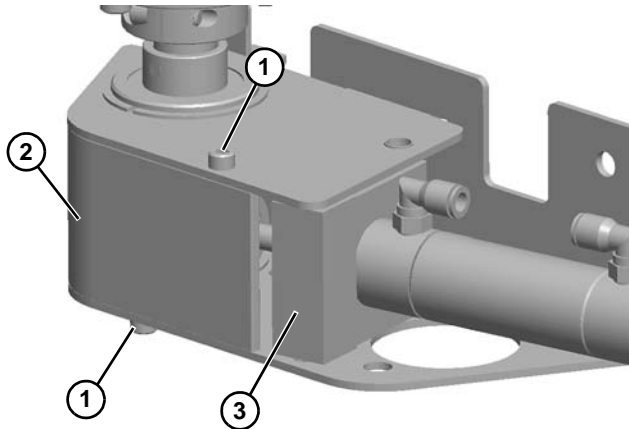


# Preventive Maintenance and Adjustment

## Divert and Merge

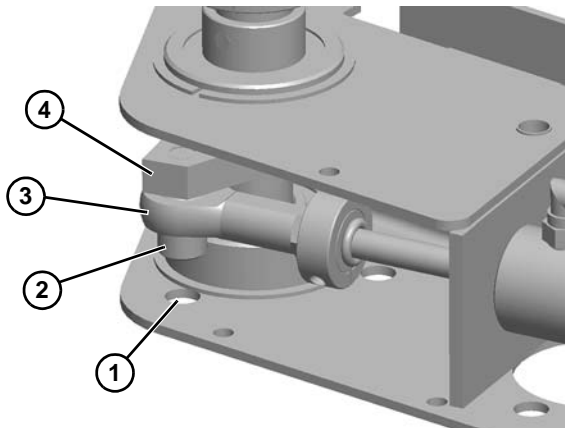
### Replace Cylinder Assembly

1. Disconnect 1/4" tubing from cylinder fittings.
2. Using an allen wrench, remove two socket head screws (**Figure 70, item 1**) securing bottom guard (**Figure 70, item 2**) to the top and bottom plates.



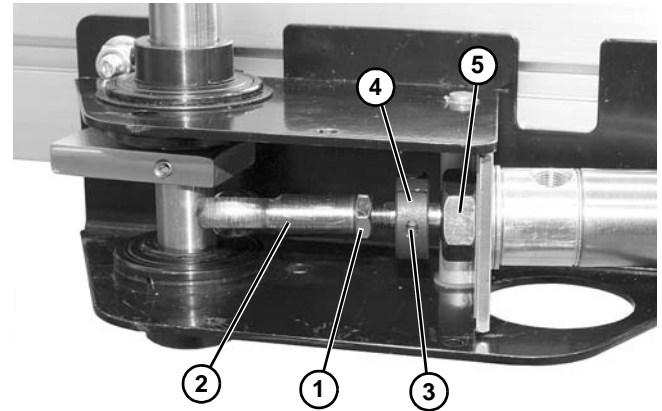
**Figure 70**

3. Remove cover (**Figure 70, item 3**) from cylinder assembly.
4. Feed allen wrench through access hole (**Figure 71, item 1**) in bottom plate and remove socket head screw (**Figure 71, item 2**) securing eye bolt (**Figure 70, item 3**) to the arm block (**Figure 71, item 4**).



**Figure 71**

5. Using a wrench, loosen jam nut (**Figure 72, item 1**). Remove eye bolt (**Figure 72, item 2**) and jam nut from threaded rod.




**Figure 72**

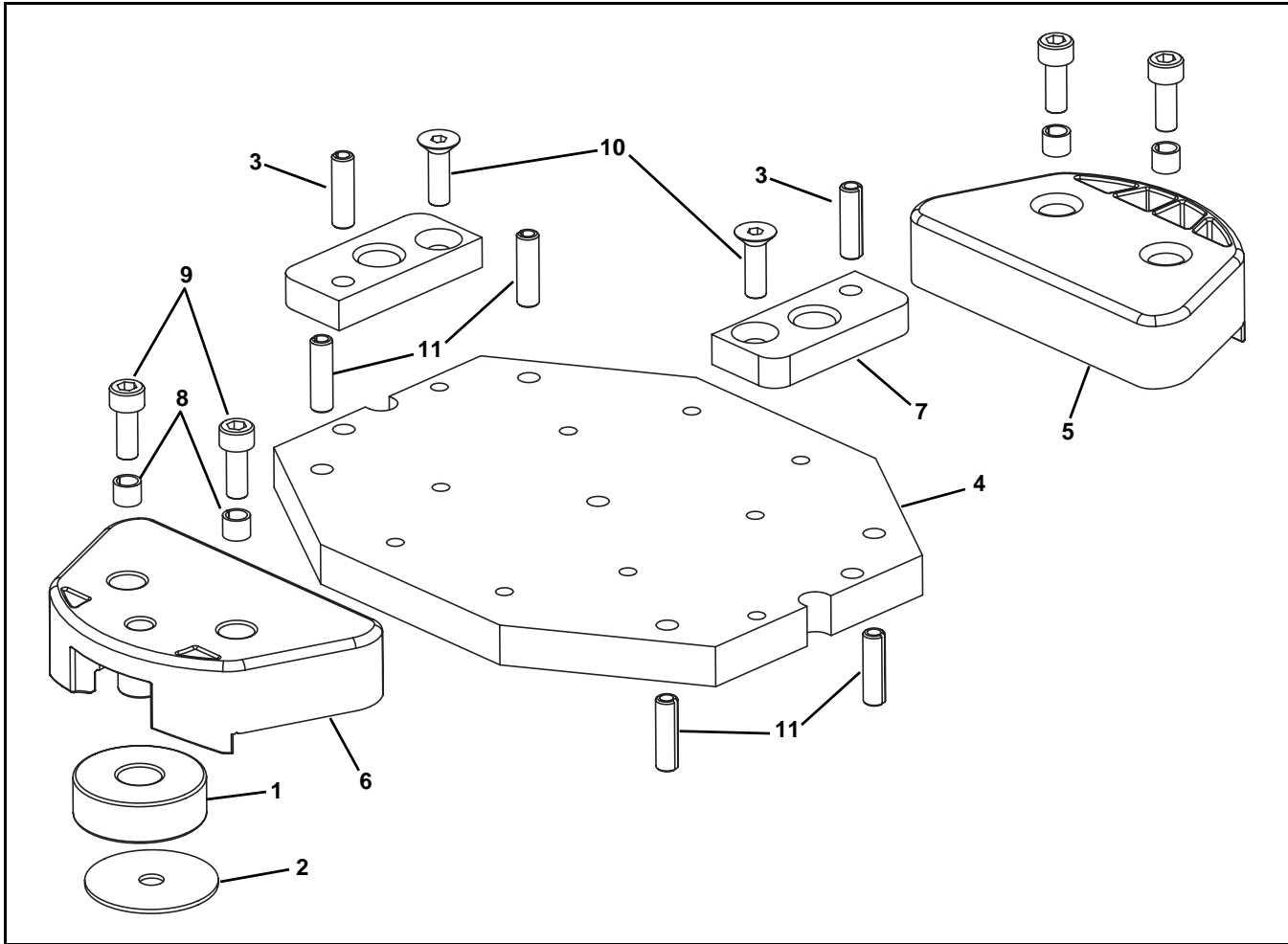
6. Loosen stop screw (**Figure 72, item 3**) and remove collar (**Figure 72, item 4**) from rod. Using 7/8" open end wrench on back end of cylinder, unscrew cylinder from mounting nut (**Figure 72, item 5**).
7. Remove and replace cylinder.
8. Installation is the reverse of removal.

# Service Parts

## NOTE

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

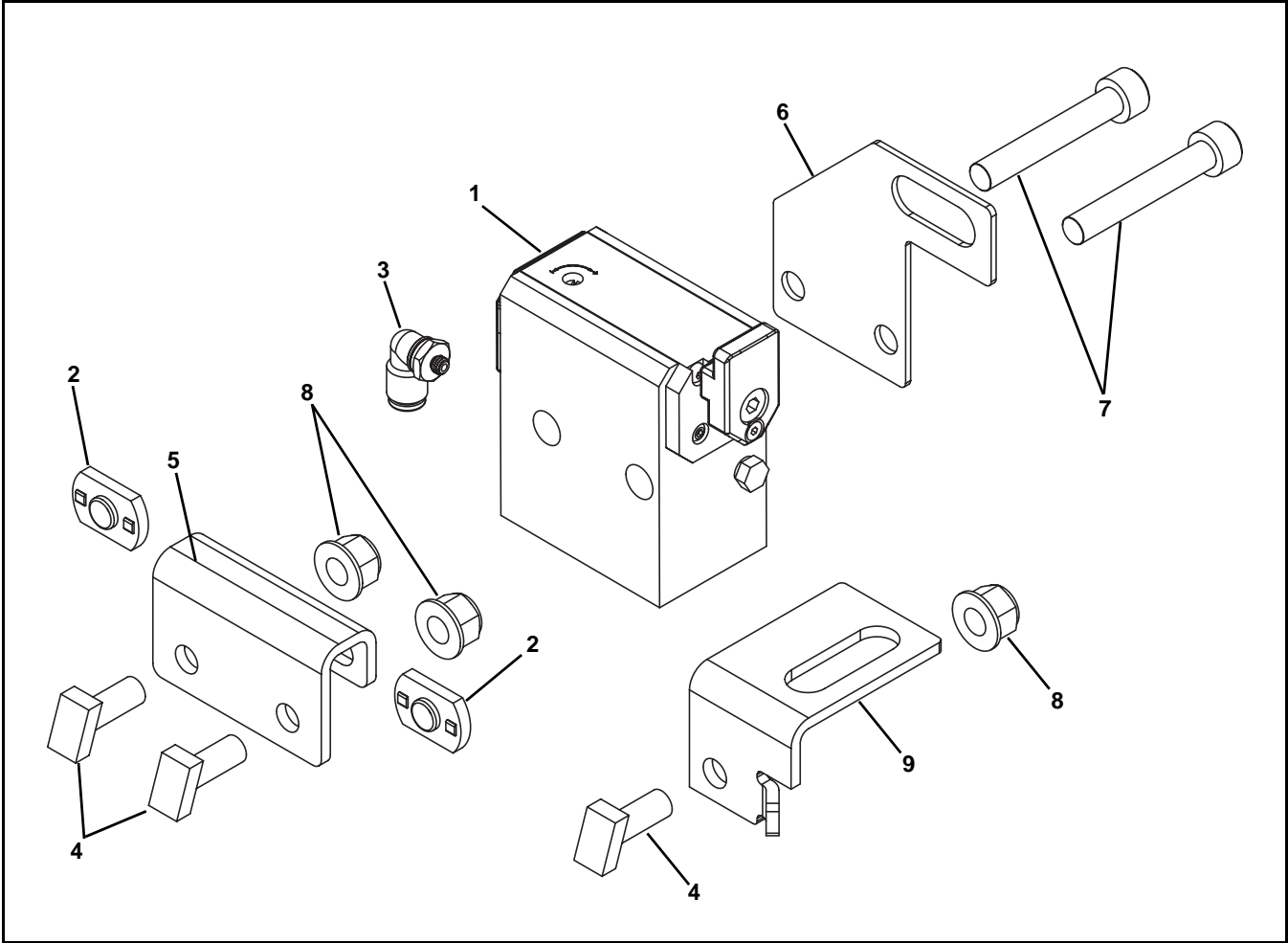
## Pallets



Item	Part Number	Description
1	807-2554	Bumper
2	807-692	Washer
3	913-509	Pin
4	205152- <u>LLL</u>	Pallet
5	203895	Basic Pallet Puck
6	203896	Bumper Pallet Puck
7	205148	Stop Block
8	450226SSP	Sleeve
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	930620M	Flat Head Screw, M6-1.00 x 20 mm
11	913-015	Pin, Groove, .25" x .875" Length

LLL = Pallet Length 100, 150, 200

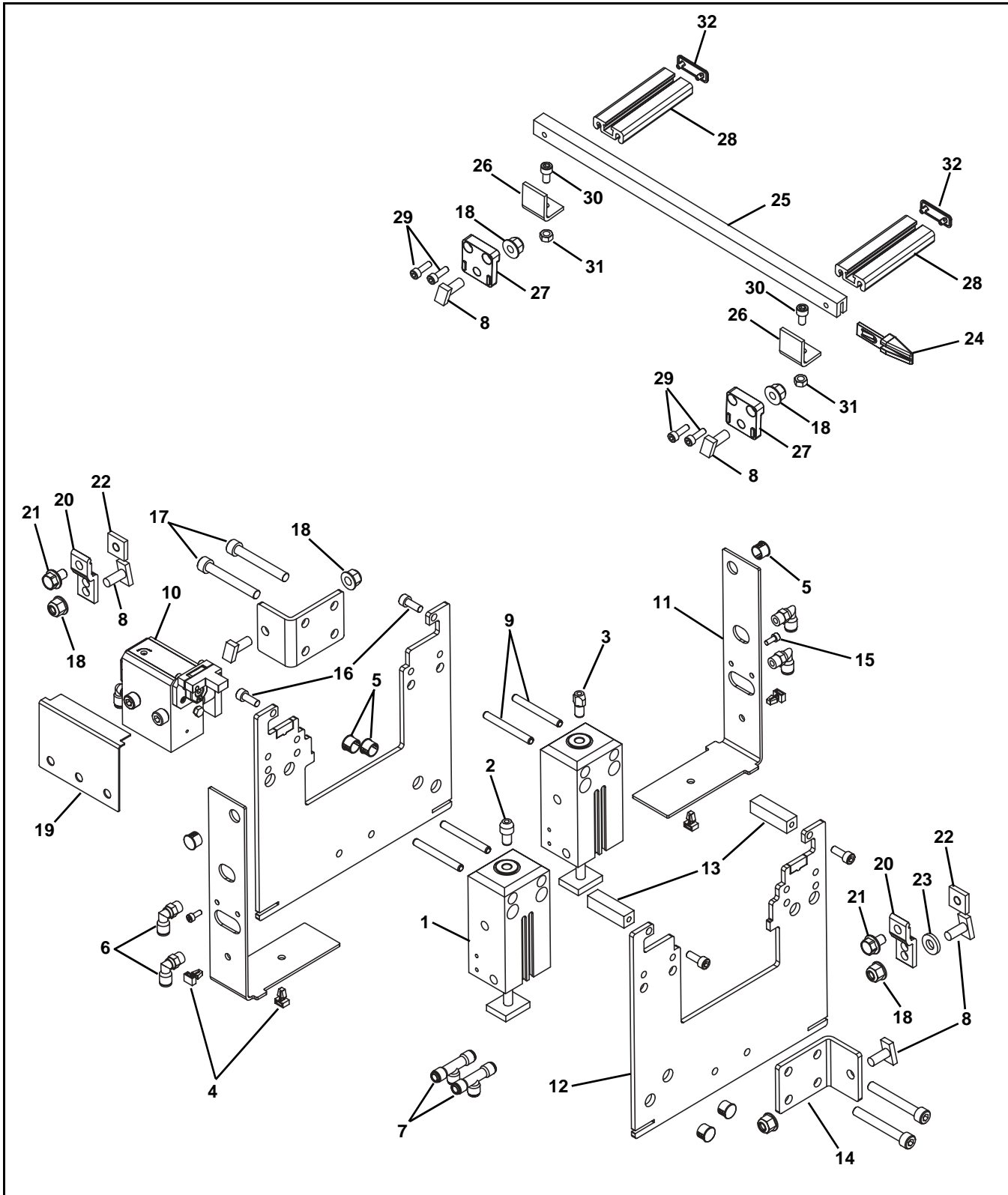
**Pallet Stops**



Item	Part Number	Description
1	804-724	Fixed Stop Module
	807-725	Cushioned Stop Module
2	807-1075	Nut, Weld, M8-1.25
3	810-529	Elbow Fitting
4	834-007	Stud, M8 x 20 mm
5	205154	Bracket
6	205155	Side Mount Sensor Bracket
7	920850M	Socket Head Screw, M8-1.25 x 50 mm
8	990812M	Hex Nut
9	205157	Bottom Mount Sensor Bracket

# Service Parts

## Lift and Locate Station

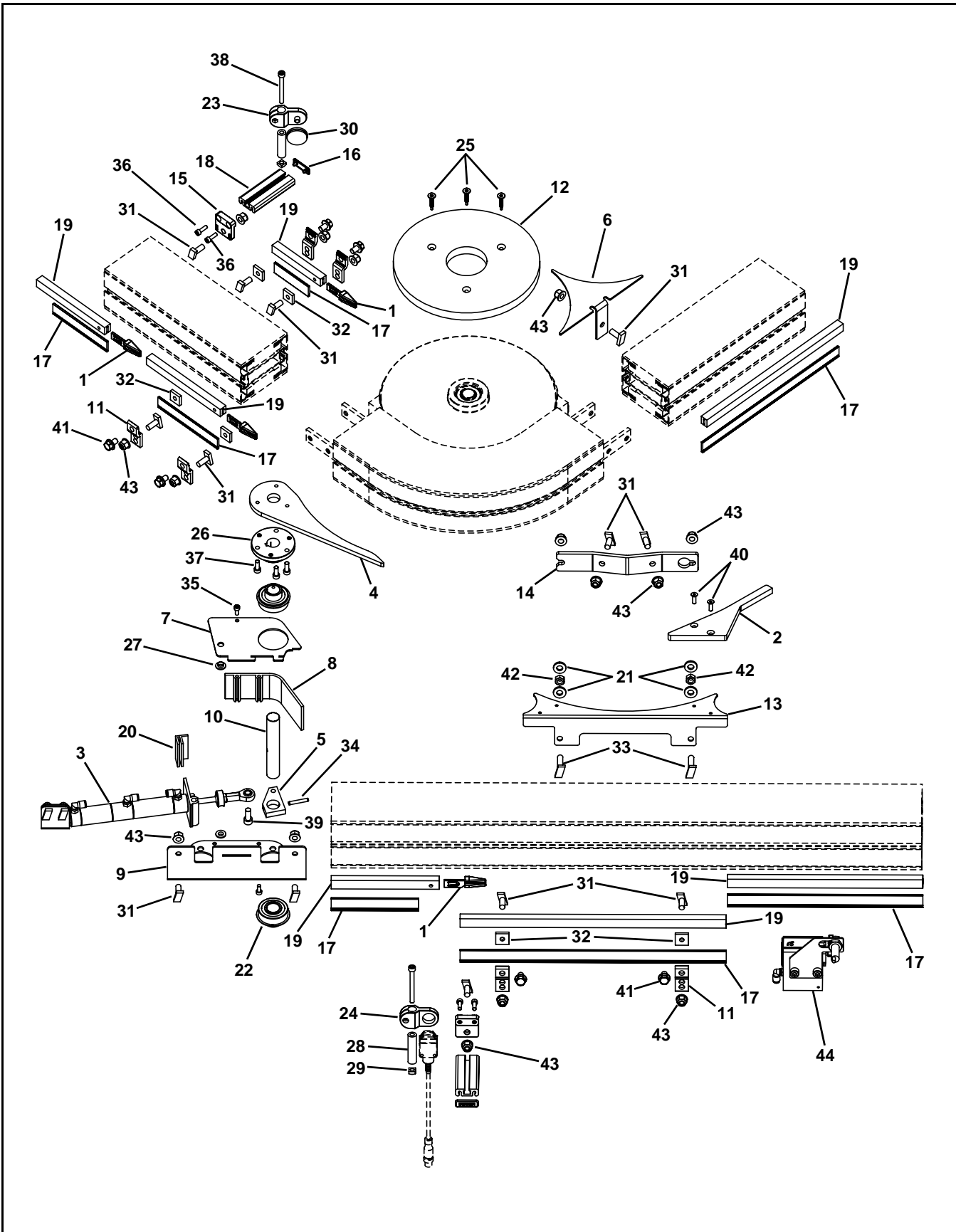


# Service Parts

Item	Part Number	Description
1	804-726	Lift Unit
2	804-727	Locator Pin, Round
3	804-728	Locator Pin, Diamond
4	807-2593	Cable Clip
5	807-684	Plug
6	810-222	Male Elbow
7	810-251	Tee Union
8	834-007	Stud, M8 x 20 mm
9	913-436	Groove Pin
10	204440	Fixed Pallet Stop
	204442	Cushion Pallet Stop
11	205120	Guard
12	205149	Side Plate
13	205150	Stop Block
14	205151	Angle Plate
15	920410M	Socket Head Screw, M4-.70 x 10 mm
16	920616M	Socket Head Screw, M6-1.00 x 16 mm
17	920860M	Socket Head Screw, M8-1.25 x 60 mm
18	990812M	Hex Nut, M8-1.25
19	205167	Guard Bracket
20	205129	Clip
21	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
22	834-014	Slide In Nut, M8
23	605280P	Washer
24	203894	Lead-In Guide
25	204851	Wearstrip
26	207162	Wearstrip Bracket
27	210848	Mounting Block
28	210846-00353	Extrusion
29	920516M	Socket Head Screw, M5-.80 x 16 mm
30	920612M	Socket Head Screw, M6-1.00 x 12 mm
31	9990601M	Hex Nut
32	210849	Cap

# Service Parts

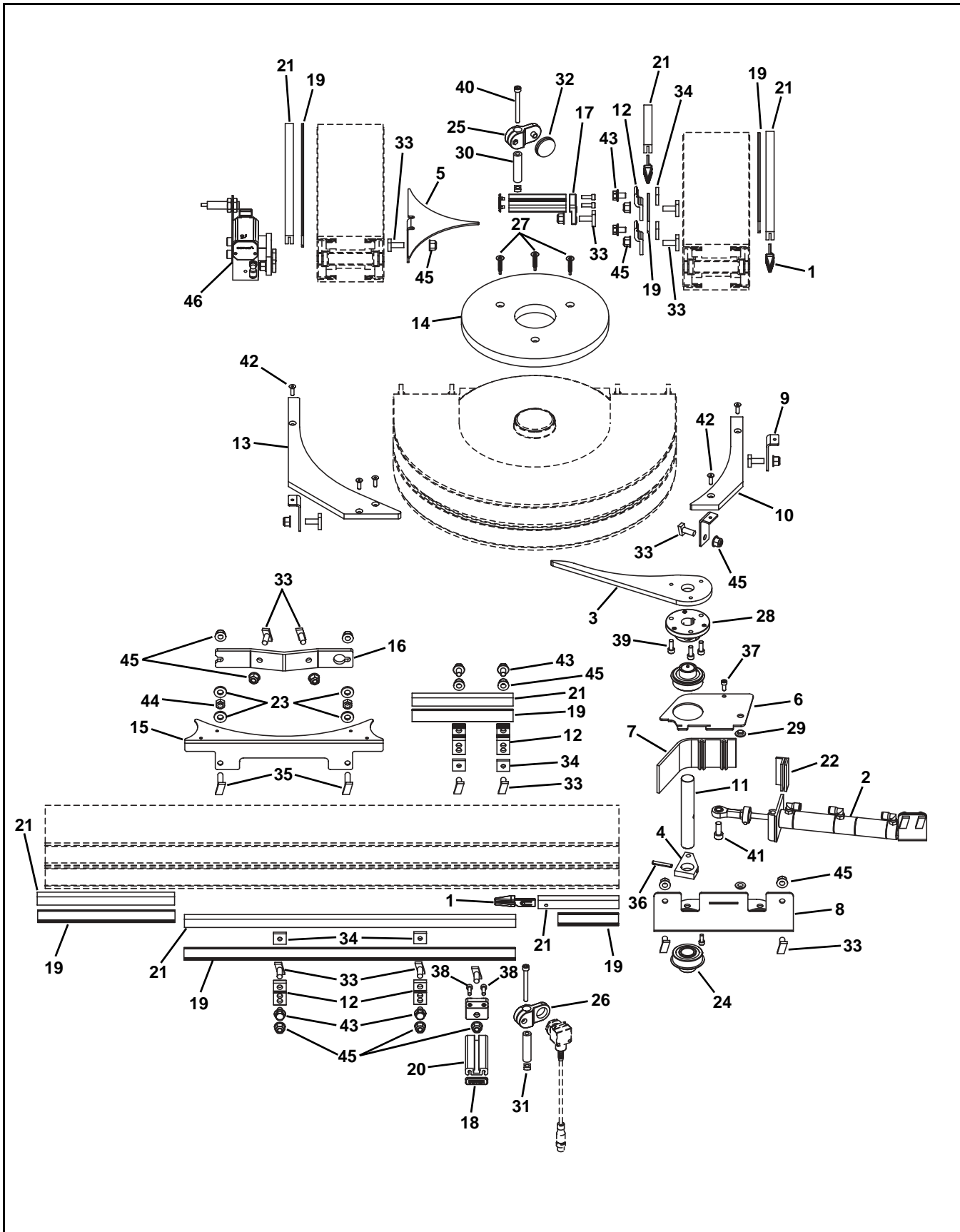
## 45° Divert-Merge



Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204298	Wedge Guide
3	204391	Cylinder Assembly
4	204775	Diverter Arm
5	204776	Arm Block
6	204788	Corner Guide
7	205117	Top Plate
8	205118	Bottom Guard
9	205119	Bottom Angle Plate
10	205127	Shaft
11	205129	Clip
12	205131	Wheel Guide
13	205158	Conveyor Tie Plate
14	205159	Tie Bar
15	210848	Mounting Block
16	210849	Cap
17	205925-LLLL	0.5" High Side Guide
18	210846-00353	Extrusion 3.53" long
19	350899-LLLL	Clip On Wear Strip
20	532226-00200	Bar 2.00" long
21	605280P	Washer
22	802-232	Bearing
23	807-1390	Reflector Mount Clamp
24	807-1391	Photo Eye Mount Clamp
25	807-2556	Flat Head Screw, #10-16 x 1.25"
26	807-2562	Flange Collar
27	807-2563	Spacer
28	807-2565	Post Spacer
29	807-920	Square Nut, M6-1.0
30	809-289	Reflector
31	834-007	Stud, M8 x 20 mm
32	834-014	Slide In Nut, M8
33	834-018	Stud, M8 x 35 mm
34	913-142	Roll Pin
35	920512M	Socket Head Screw, M5-.80 x 12 mm
36	920516M	Socket Head Screw, M5-.80 x 16 mm
37	920616M	Socket Head Screw, M6-1.00 x 16 mm
38	920660M	Socket Head Screw, M6-1.00 x 60 mm
39	920820M	Socket Head Screw, M8-1.25 x 20 mm
40	930516M	Flat Head Screw, M5-.80 x 16 mm
41	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
42	990801M	Hex Nut
43	990812M	Hex Nut
44	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

## 90° Divert-Merge

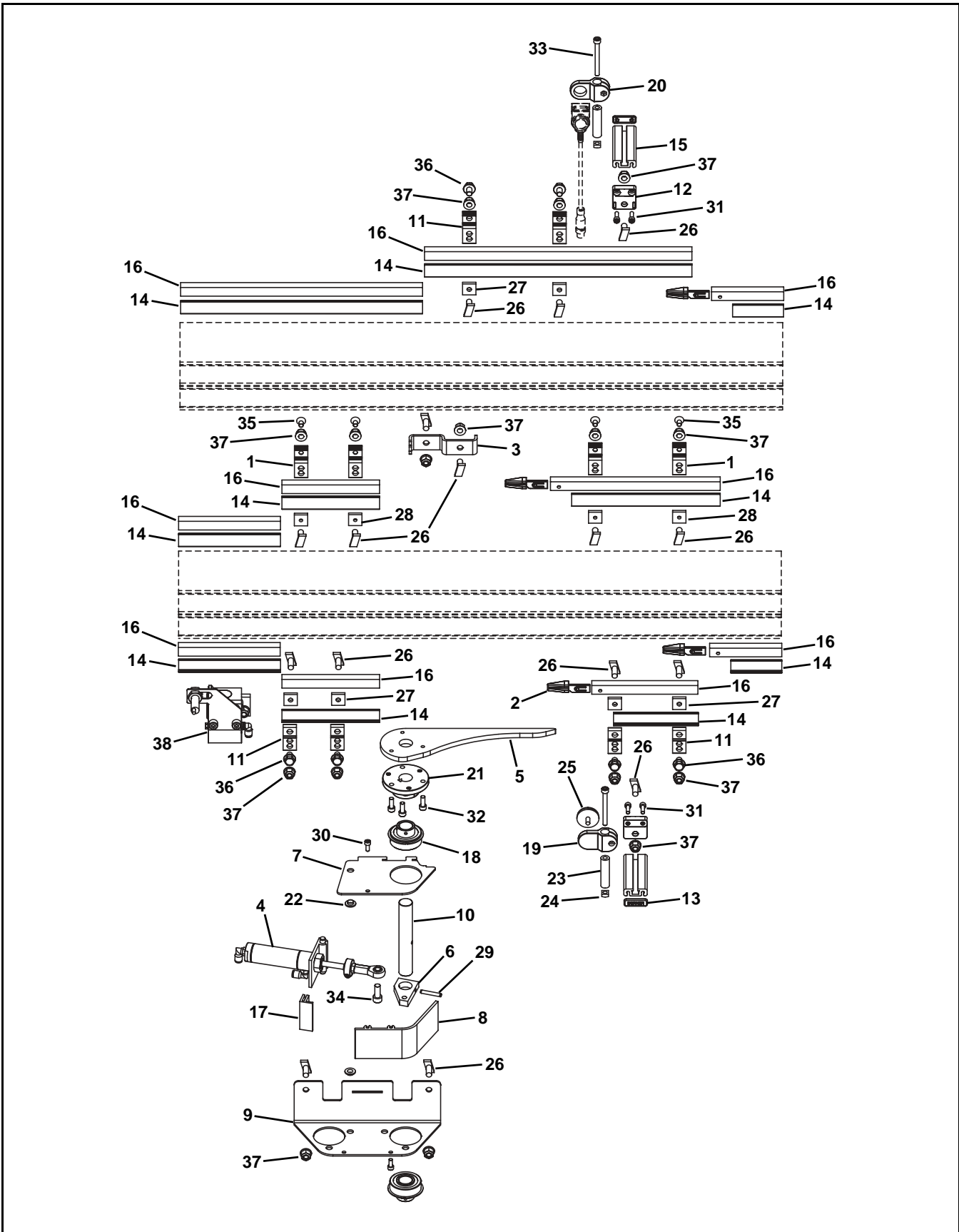




Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204391	Cylinder Assembly
3	204775	Diverter Arm
4	204776	Arm Block
5	204788	Corner Guide
6	205117	Top Plate
7	205118	Bottom Guard
8	205119	Bottom Angle Plate
9	205123	Angle Support
10	205124	Wedge Guide - Exit
11	205127	Shaft
12	205129	Clip
13	205130	Wedge Guide - Entrance
14	205131	Wheel Guide
15	205158	Conveyor Tie Plate
16	205159	Tie Bar
17	210848	Mounting Block
18	210849	Cap
19	205925-LLLL	0.5" High Side Guide
20	210846-00353	Extrusion 3.53" long
21	350899-LLLL	Clip On Wear Strip
22	532226-00200	Bar 2.00" long
23	605280P	Washer
24	802-232	Bearing
25	807-1390	Reflector Mount Clamp
26	807-1391	Photo Eye Mount Clamp
27	807-2556	Flat Head Screw, #10-16 x 1.25"
28	807-2562	Flange Collar
29	807-2563	Spacer
30	807-2565	Post Spacer
31	807-920	Square Nut, M6-1.0
32	809-289	Reflector
33	834-007	Stud, M8 x 20 mm
34	834-014	Slide In Nut, M8
35	834-018	Stud, M8 x 35 mm
36	913-142	Roll Pin
37	920512M	Socket Head Screw, M5-.80 x 12 mm
38	920516M	Socket Head Screw, M5-.80 x 16 mm
39	920616M	Socket Head Screw, M6-1.00 x 16 mm
40	920660M	Socket Head Screw, M6-1.00 x 60 mm
41	920820M	Socket Head Screw, M8-1.25 x 20 mm
42	930516M	Flat Head Screw, M5-.80 x 16 mm
43	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
44	990801M	Hex Nut
45	990812M	Hex Nut
46	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

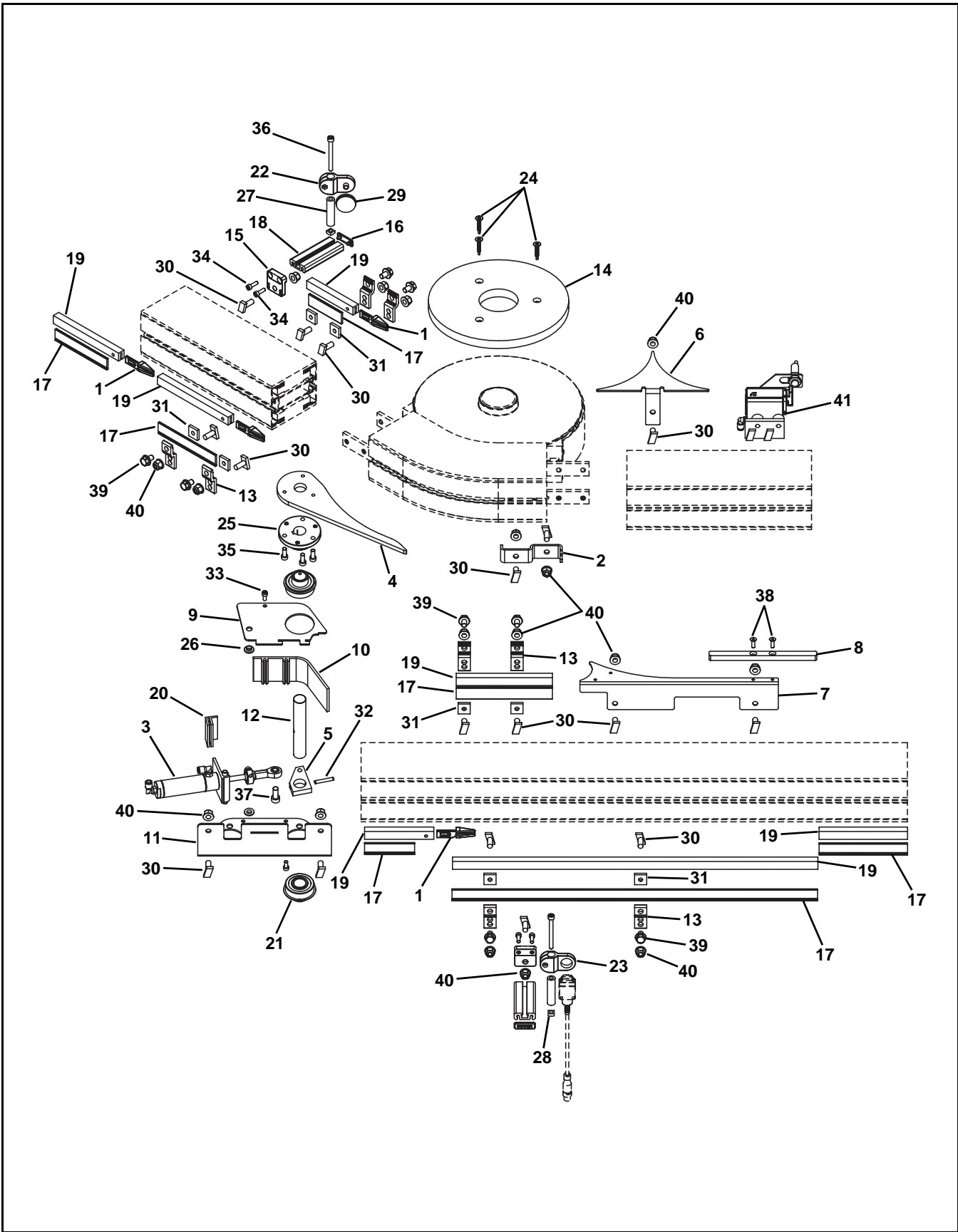
## Parallel Divert-Merge



Item	Part Number	Description
1	203877	Clip
2	203894	Lead In Guide Wedge
3	204289	Frame Connecting Clip
4	204385	Cylinder Assembly - 2 Position
5	204775	Diverter Arm
6	204776	Arm Block
7	205117	Top Plate
8	205118	Bottom Guard
9	205119	Bottom Angle Plate
10	205127	Shaft
11	205129	Clip
12	210848	Mounting Block
13	210849	Cap
14	205925-LLLL	0.5" High Side Guide
15	210846-00353	Extrusion 3.53" long
16	350899-LLLL	Clip On Wear Strip
17	532226-00200	Bar 2.00" long
18	802-232	Bearing
19	807-1390	Reflector Mount Clamp
20	807-1391	Photo Eye Mount Clamp
21	807-2562	Flange Collar
22	807-2563	Spacer
23	807-2565	Post Spacer
24	807-920	Square Nut, M6-1.0
25	809-289	Reflector
26	834-007	Stud, M8 x 20 mm
27	834-014	Slide In Nut, M8
28	834-019	Slide In Nut, M6
29	913-142	Roll Pin
30	920512M	Socket Head Screw, M5-.80 x 12 mm
31	920516M	Socket Head Screw, M5-.80 x 16 mm
32	920616M	Socket Head Screw, M6-1.00 x 16 mm
33	920660M	Socket Head Screw, M6-1.00 x 60 mm
34	920820M	Socket Head Screw, M8-1.25 x 20 mm
35	930612M	Flat Head Screw, M6-1.00 x 12 mm
36	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
37	990812M	Hex Nut
38	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

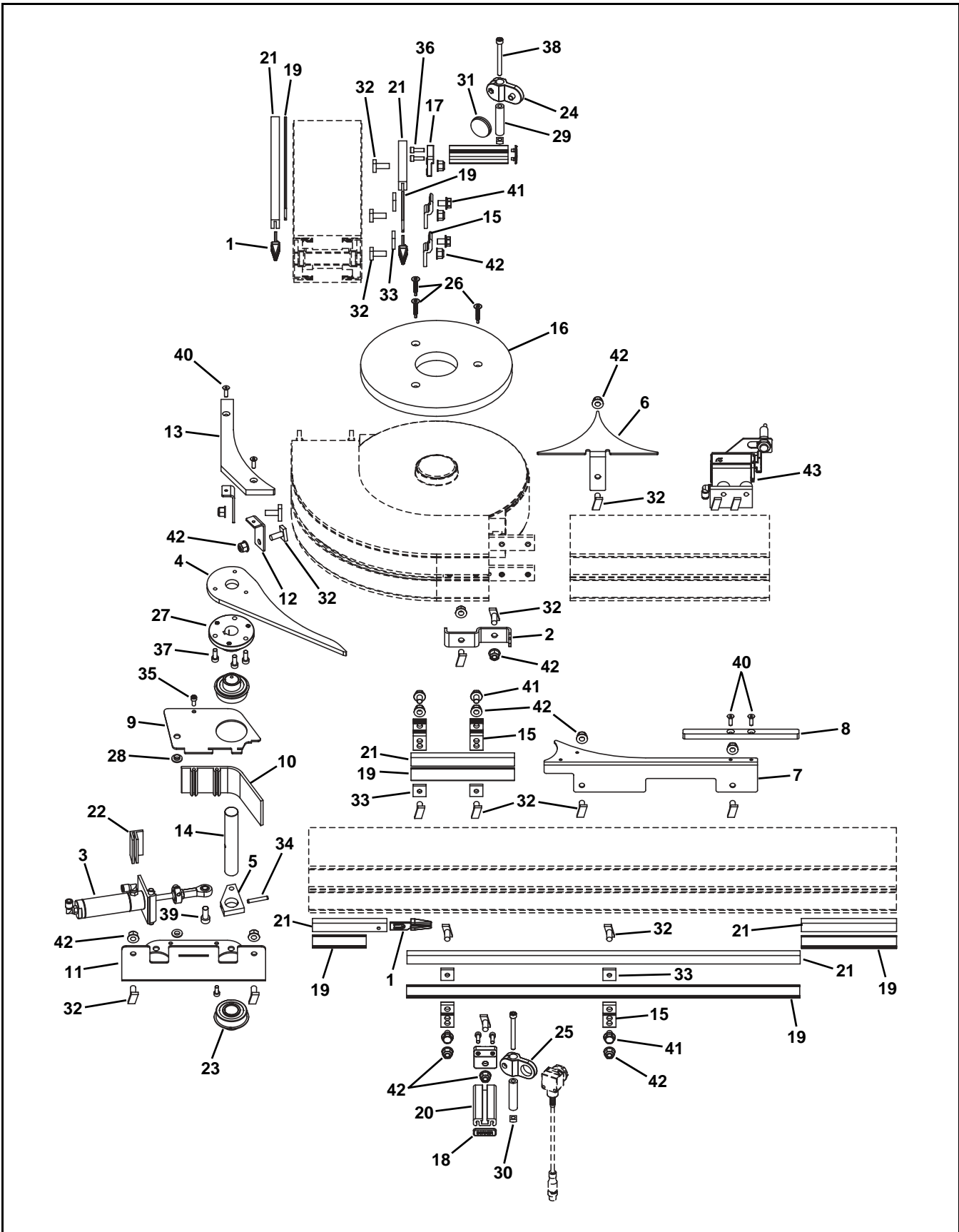
## 45° Parallel Divert-Merge



Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204289	Frame Connecting Clip
3	204385	Cylinder Assembly
4	204775	Diverter Arm
5	204776	Arm Block
6	204788	Corner Guide
7	204797	Tie Bar
8	204835	Divert Guide
9	205117	Top Plate
10	205118	Bottom Guard
11	205119	Bottom Angle Plate
12	205127	Shaft
13	205129	Clip
14	205131	Wheel Guide
15	210848	Mounting Block
16	210849	Cap
17	205925-LLLL	0.5" High Side Guide
18	210846-00353	Extrusion 3.53" long
19	350899-LLLL	Clip On Wear Strip
20	532226-00200	Bar 2.00" long
21	802-232	Bearing
22	807-1390	Reflector Mount Clamp
23	807-1391	Photo Eye Mount Clamp
24	807-2556	Flat Head Screw, #10-16 x 1.25"
25	807-2562	Flange Collar
26	807-2563	Spacer
27	807-2565	Post Spacer
28	807-920	Square Nut, M6-1.0
29	809-289	Reflector
30	834-007	Stud, M8 x 20 mm
31	834-014	Slide In Nut, M8
32	913-142	Roll Pin
33	920512M	Socket Head Screw, M5-.80 x 12 mm
34	920516M	Socket Head Screw, M5-.80 x 16 mm
35	920616M	Socket Head Screw, M6-1.00 x 16 mm
36	920660M	Socket Head Screw, M6-1.00 x 60 mm
37	920820M	Socket Head Screw, M8-1.25 x 20 mm
38	930516M	Flat Head Screw, M5-.80 x 16 mm
39	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
40	990812M	Hex Nut
41	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

## 90° Parallel Divert-Merge

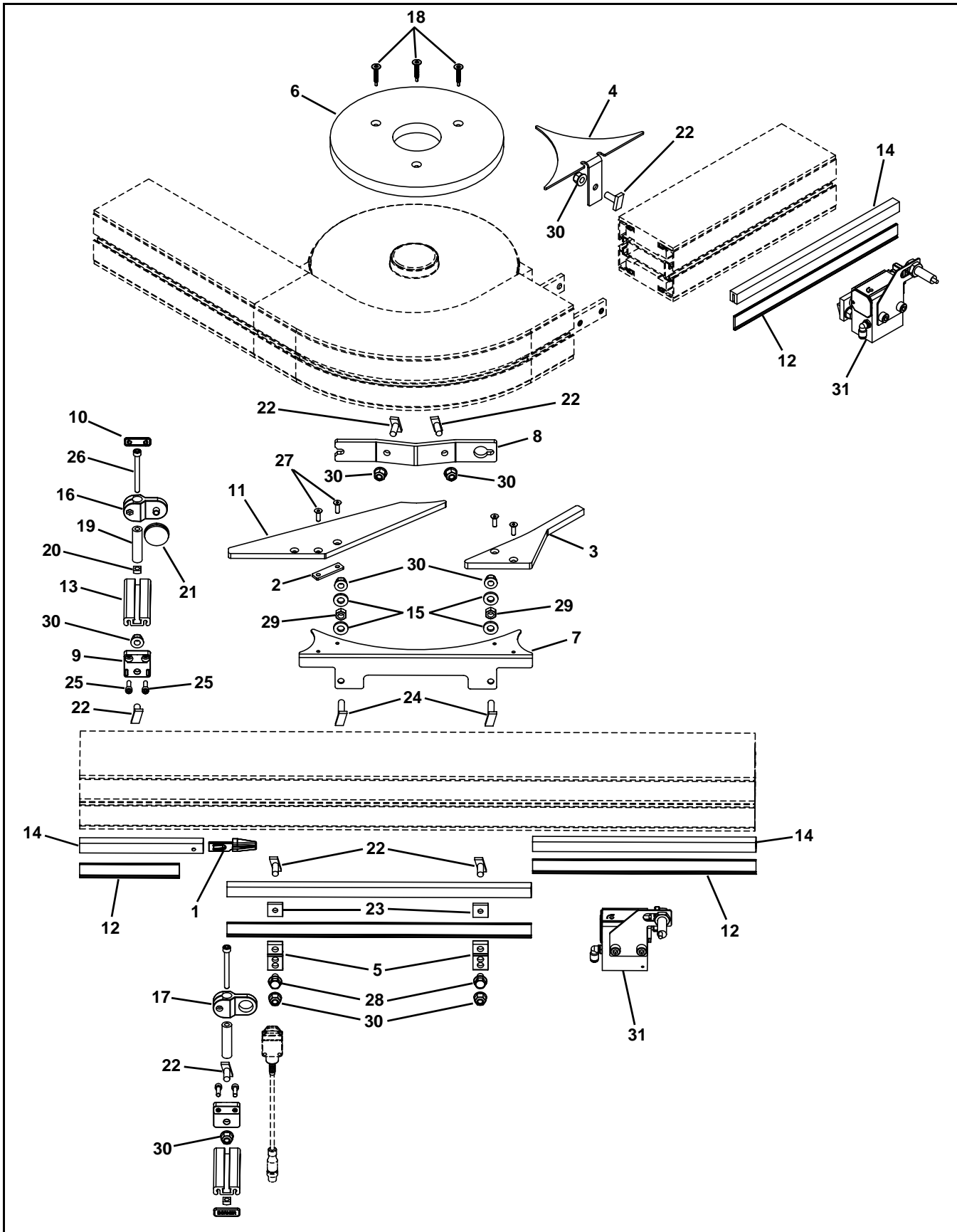


SmartFlex Pallet System Accessories

Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204289	Frame Connecting Clip
3	204385	Cylinder Assembly
4	204775	Diverter Arm
5	204776	Arm Block
6	204788	Corner Guide
7	204797	Tie Bar
8	204835	Divert Guard
9	205117	Top Plate
10	205118	Bottom Guard
11	205119	Bottom Angle Plate
12	205123	Angle Support
13	205124	Wedge Guide - Exit
14	205127	Shaft
15	205129	Clip
16	205131	Wheel Guide
17	210848	Mounting Block
18	210849	Cap
19	205925-LLLL	0.5" High Side Guide
20	210846-00353	Extrusion 3.53" long
21	350899-LLLL	Clip On Wear Strip
22	532226-00200	Bar 2.00" long
23	802-232	Bearing
24	807-1390	Reflector Mount Clamp
25	807-1391	Photo Eye Mount Clamp
26	807-2556	Flat Head Screw, #10-16 x 1.25"
27	807-2562	Flange Collar
28	807-2563	Spacer
29	807-2565	Post Spacer
30	807-920	Square Nut, M6-1.0
31	809-289	Reflector
32	834-007	Stud, M8 x 20 mm
33	834-014	Slide In Nut, M8
34	913-142	Roll Pin
35	920512M	Socket Head Screw, M5-.80 x 12 mm
36	920516M	Socket Head Screw, M5-.80 x 16 mm
37	920616M	Socket Head Screw, M6-1.00 x 16 mm
38	920660M	Socket Head Screw, M6-1.00 x 60 mm
39	920820M	Socket Head Screw, M8-1.25 x 20 mm
40	930516M	Flat Head Screw, M5-.80 x 16 mm
41	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
42	990812M	Hex Nut
43	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

## 45° Merge

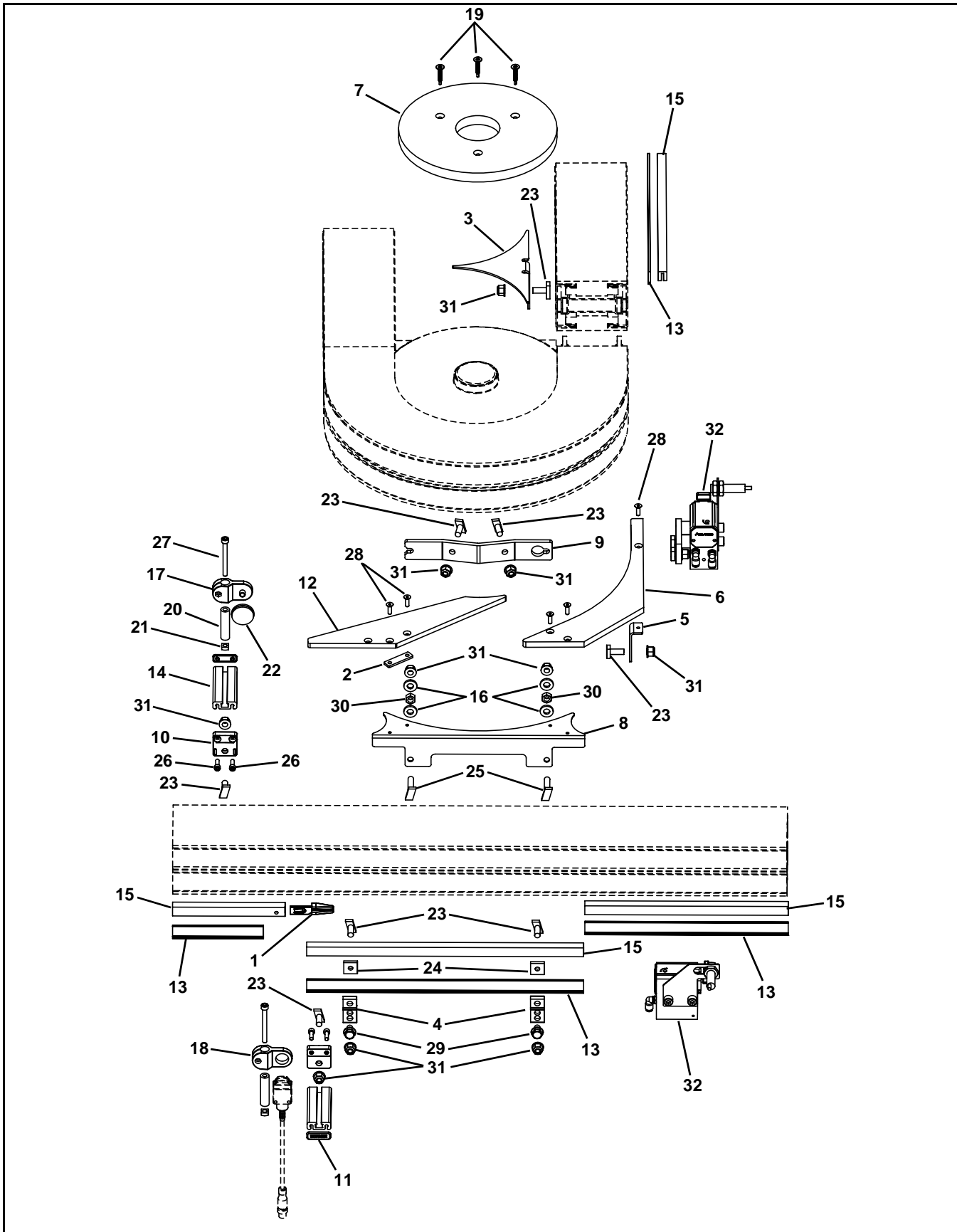




Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204295	Spacer
3	204298	45° Corner Guide
4	204788	Corner Guide
5	205129	Clip
6	205131	Wheel Guide
7	205158	Conveyor Tie Plate
8	205159	Tie Bar
9	210848	Mounting Block
10	210849	Cap
11	204833	Corner Guide
12	205925-LLLL	0.5" High Side Guide
13	210846-00353	Extrusion 3.53" long
14	350899-LLLL	Clip On Wear Strip
15	605280P	Washer
16	807-1390	Reflector Mount Clamp
17	807-1391	Photo Eye Mount Clamp
18	807-2556	Flat Head Screw, #10-16 x 1.25"
19	807-2565	Post Spacer
20	807-920	Square Nut, M6-1.0
21	809-289	Reflector
22	834-007	Stud, M8 x 20 mm
23	834-014	Slide In Nut, M8
24	834-018	Stud, M8 x 35 mm
25	920516M	Socket Head Screw, M5-.80 x 16 mm
26	920660M	Socket Head Screw, M6-1.00 x 60 mm
27	930516M	Flat Head Screw, M5-.80 x 16 mm
28	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
29	990801M	Hex Nut
30	990812M	Hex Nut
31	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

## 90° Merge

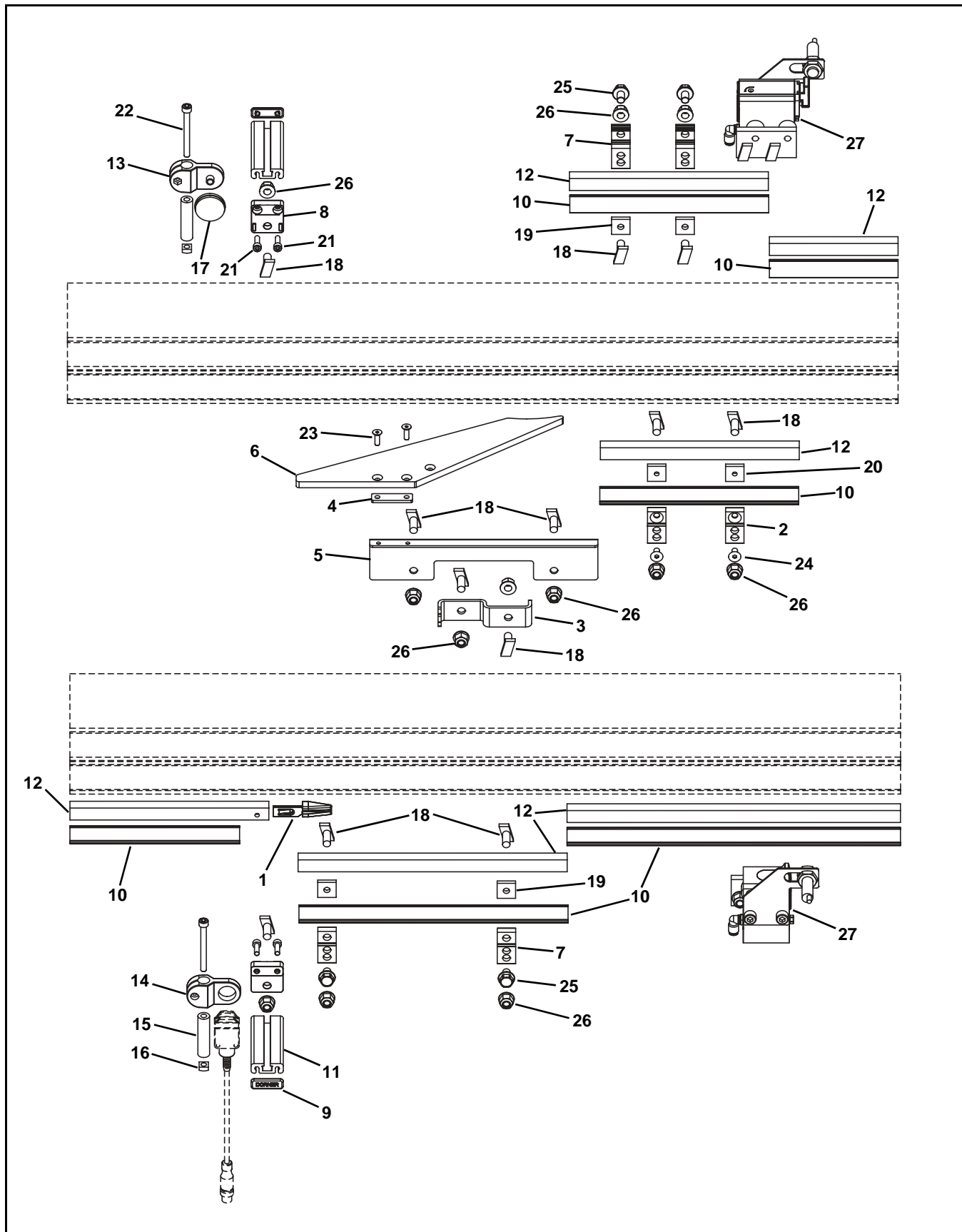


SmartFlex Pallet System Accessories

Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204295	Spacer
3	204788	Corner Guide
4	205129	Clip
5	205123	Angle Support
6	205130	Wedge Guide - Entrance
7	205131	Wheel Guide
8	205158	Conveyor Tie Plate
9	205159	Tie Bar
10	210848	Mounting Block
11	210849	Cap
12	204833	Corner Guide
13	205925-LLLL	0.5" High Side Guide
14	210846-00353	Extrusion 3.53" long
15	350899-LLLL	Clip On Wear Strip
16	605280P	Washer
17	807-1390	Reflector Mount Clamp
18	807-1391	Photo Eye Mount Clamp
19	807-2556	Flat Head Screw, #10-16 x 1.25"
20	807-2565	Post Spacer
21	807-920	Square Nut, M6-1.0
22	809-289	Reflector
23	834-007	Stud, M8 x 20 mm
24	834-014	Slide In Nut, M8
25	834-018	Stud, M8 x 35 mm
26	920516M	Socket Head Screw, M5-.80 x 16 mm
27	920660M	Socket Head Screw, M6-1.00 x 60 mm
28	930516M	Flat Head Screw, M5-.80 x 16 mm
29	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
30	990801M	Hex Nut
31	990812M	Hex Nut
32	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
LLLL = Length in inches with 2 decimal places.		
Length Example: Length = 6.25" LLLL = 00625		

# Service Parts

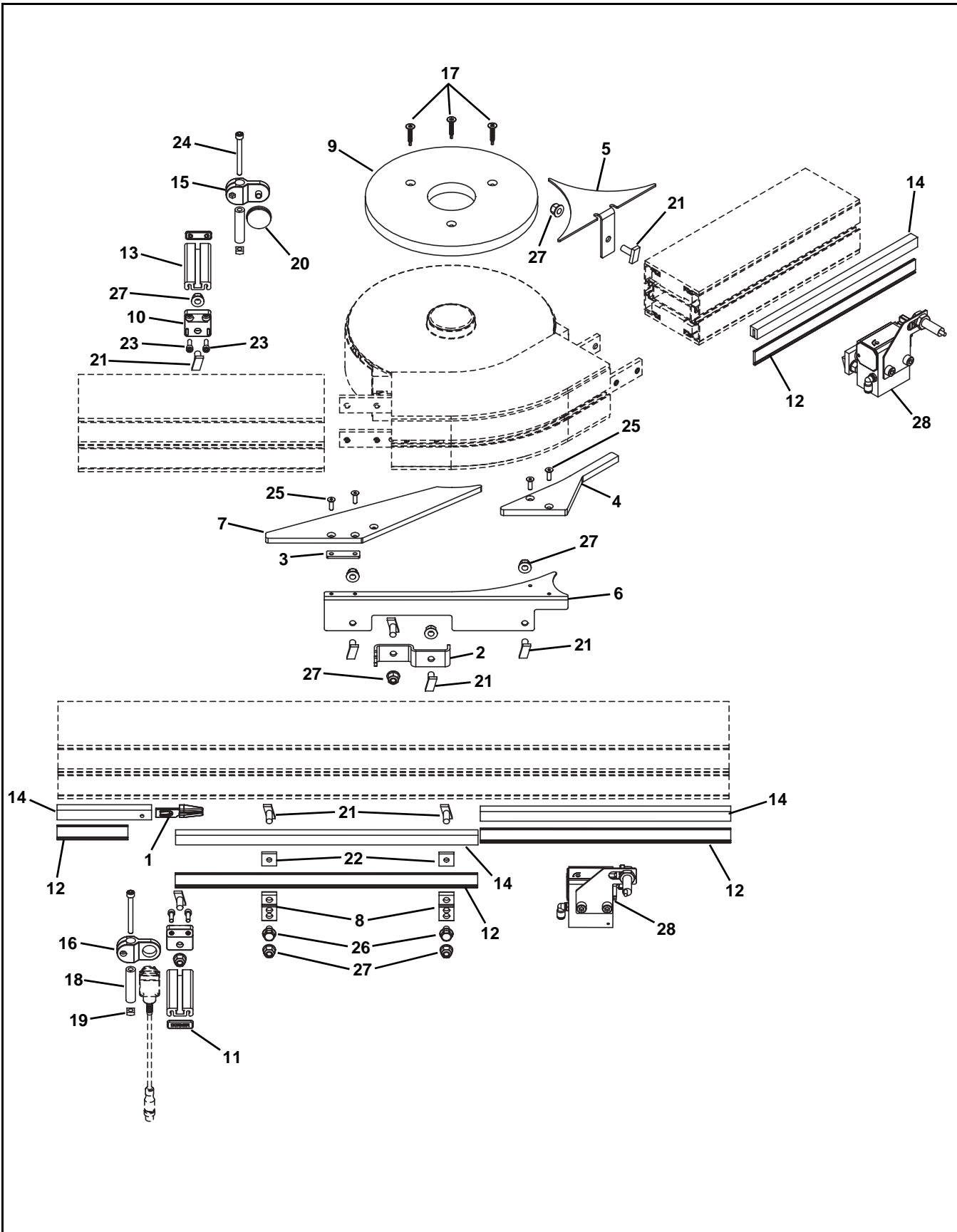
## Parallel-Merge



Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	203877	Clip
3	204289	Frame Connecting Clip
4	204295	Spacer
5	204426	Tie Plate
6	204833	Corner Guide
7	205129	Clip
8	210848	Mounting Block
9	210849	Cap
10	205925- <u>LLLL</u>	0.5" High Side Guide
11	210846-00353	Extrusion 3.53" long
12	350899- <u>LLLL</u>	Clip On Wear Strip
13	807-1390	Reflector Mount Clamp
14	807-1391	Photo Eye Mount Clamp
15	807-2565	Post Spacer
16	807-920	Square Nut, M6-1.0
17	809-289	Reflector
18	834-007	Stud, M8 x 20 mm
19	834-014	Slide In Nut, M8
20	834-019	Slide In Nut, M6
21	920516M	Socket Head Screw, M5-.80 x 16 mm
22	920660M	Socket Head Screw, M6-1.00 x 60 mm
23	930516M	Flat Head Screw, M5-.80 x 16 mm
24	930612M	Flat Head Screw, M6-1.00 x 12 mm
25	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
26	990812M	Hex Nut
27	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

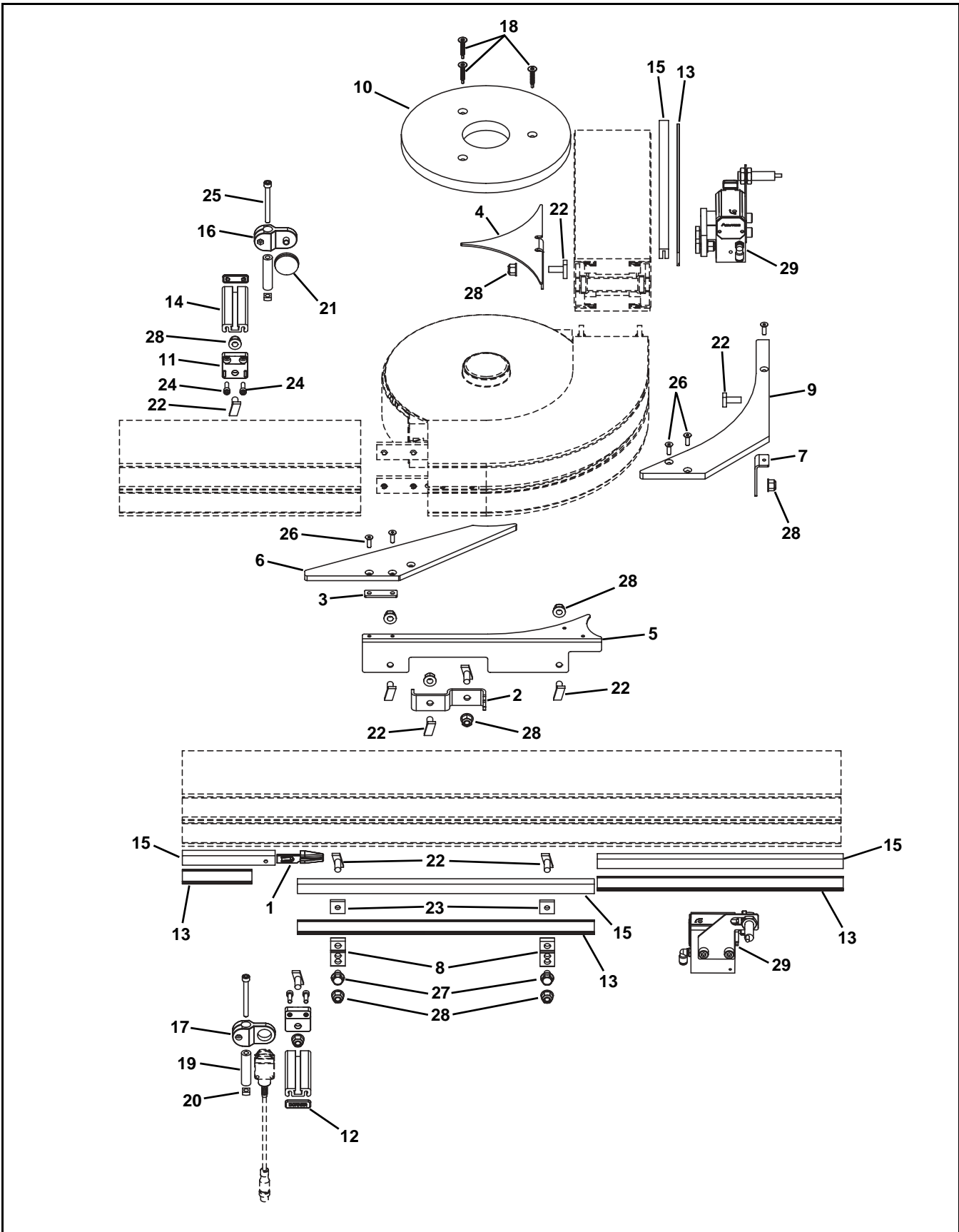
## 45° Parallel-Merge



Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204289	Frame Connecting Clip
3	204295	Spacer
4	204298	45° Corner Guide
5	204788	Corner Guide
6	204797	Tie Plate
7	204833	Corner Guide
8	205129	Clip
9	205131	Wheel Guide
10	210848	Mounting Block
11	210849	Cap
12	205925- <u>LLLL</u>	0.5" High Side Guide
13	210846-00353	Extrusion 3.53" long
14	350899- <u>LLLL</u>	Clip On Wear Strip
15	807-1390	Reflector Mount Clamp
16	807-1391	Photo Eye Mount Clamp
17	807-2556	Flat Head Screw, #10-16 x 1.25"
18	807-2565	Post Spacer
19	807-920	Square Nut, M6-1.0
20	809-289	Reflector
21	834-007	Stud, M8 x 20 mm
22	834-014	Slide In Nut, M8
23	920516M	Socket Head Screw, M5-.80 x 16 mm
24	920660M	Socket Head Screw, M6-1.00 x 60 mm
25	930516M	Flat Head Screw, M5-.80 x 16 mm
26	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
27	990812M	Hex Nut
28	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# Service Parts

## 90° Parallel-Merge





Item	Part Number	Description
1	203894	Lead In Guide Wedge
2	204289	Frame Connecting Clip
3	204295	Spacer
4	204788	Corner Guide
5	204797	Tie Plate
6	204833	Corner Guide
7	205123	Angle Support
8	205129	Clip
9	205130	Wedge Guide - Entrance
10	205131	Wheel Guide
11	210848	Mounting Block
12	210849	Cap
13	205925- <u>LLLL</u>	0.5" High Side Guide
14	210846-00353	Extrusion 3.53" long
15	350899- <u>LLLL</u>	Clip On Wear Strip
16	807-1390	Reflector Mount Clamp
17	807-1391	Photo Eye Mount Clamp
18	807-2556	Flat Head Screw, #10-16 x 1.25"
19	807-2565	Post Spacer
20	807-920	Square Nut, M6-1.0
21	809-289	Reflector
22	834-007	Stud, M8 x 20 mm
23	834-014	Slide In Nut, M8
24	920516M	Socket Head Screw, M5-.80 x 16 mm
25	920660M	Socket Head Screw, M6-1.00 x 60 mm
26	930516M	Flat Head Screw, M5-.80 x 16 mm
27	960882M	Flange Head Cap Screw, M8-1.25 x 12 mm
28	990812M	Hex Nut
29	204447	Fixed Pallet Stop
	204448	Cushion Pallet Stop
<u>LLLL</u> = Length is inches width 2 decimal places.		
Length Example: Length = 6.25" <u>LLLL</u> = 00625		

# 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. Include part serial number if available.

A representative will discuss action to be taken on the returned items and provide a Returned Materials 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 Line	Product Type								Engineered to order parts
	Standard Products								
	Conveyors	Gearmotors & Mounting Packages	Support Stands	Accessories	Spare Parts (non-belt)	Spare Belts - Standard Flat Fabric	Spare Belts - Cleated & Spec. Fabric	Spare Belts - Plastic Chain	All equipment and parts
1100 Series	30% return fee for all products except: 50% return fee for conveyors with modular belt, cleated belt or speciality belts  All Electrical items are assigned original manufacturers return policy.						non-returnable		case-by-case
2200 Series									
3200 Series									
Pallet Systems									
FlexMove/SmartFlex									
GAL Series									
All Electrical									
7100 Series	50% return fee for all products						non-returnable		case-by-case
7200/7300 Series									
AquaGard 7350 Series Version 2									
GES Series									
AquaGard 7350/7360 Series	non-returnable								
AquaPruf Series	non-returnable								

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 Dorner, an authorized sales channel or visit our website: [www.dorner.com](http://www.dorner.com).

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

[www.dorner.com](http://www.dorner.com)



## Dorner – North & South America

### Dorner – U.S.A.

#### Headquarters

975 Cottonwood Ave  
Hartland, WI 53029, USA  
(800) 397-8664  
(262) 367-7600  
info@dorner.com

### Dorner – Canada

100-5515 North Service Road  
Burlington, Ontario L7L 6G6  
Canada  
(289) 208-7306  
info@dorner.com

### Dorner – Latin America

Carretera a Nogales #5297, Nave 11.  
Parque Industrial Nogales  
Zapopan, Jalisco C.P. 45222 México  
+52.33.30037400 | info.latinamerica@dorner.com

### Dorner – Europe

Karl-Heinz-Beckurts-Straße 7  
52428 Jülich, Germany  
+49 (0) 2461/93767-0 | info.europe@dorner.com

### Dorner – Asia

128 Jalan Permatang Damar Laut, Bayan Lepas 11960  
Penang, Malaysia  
+604-626-2948 | info.asia@dorner.com



© Dorner Mfg. Corp. 2018. All Rights Reserved.