



2200 Series SmartFlex Conveyors with Cast Tails

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

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Introduction

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

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.

Product Description

Refer to **Figure 1** for typical components.

- | | |
|---|---------------------|
| 1 | Infeed Module |
| 2 | Curve Module |
| 3 | Incline Module |
| 4 | Decline Module |
| 5 | Intermediate Module |
| 6 | Drive Module |
| 7 | Gearmotor </td |
| 8 | Stands |

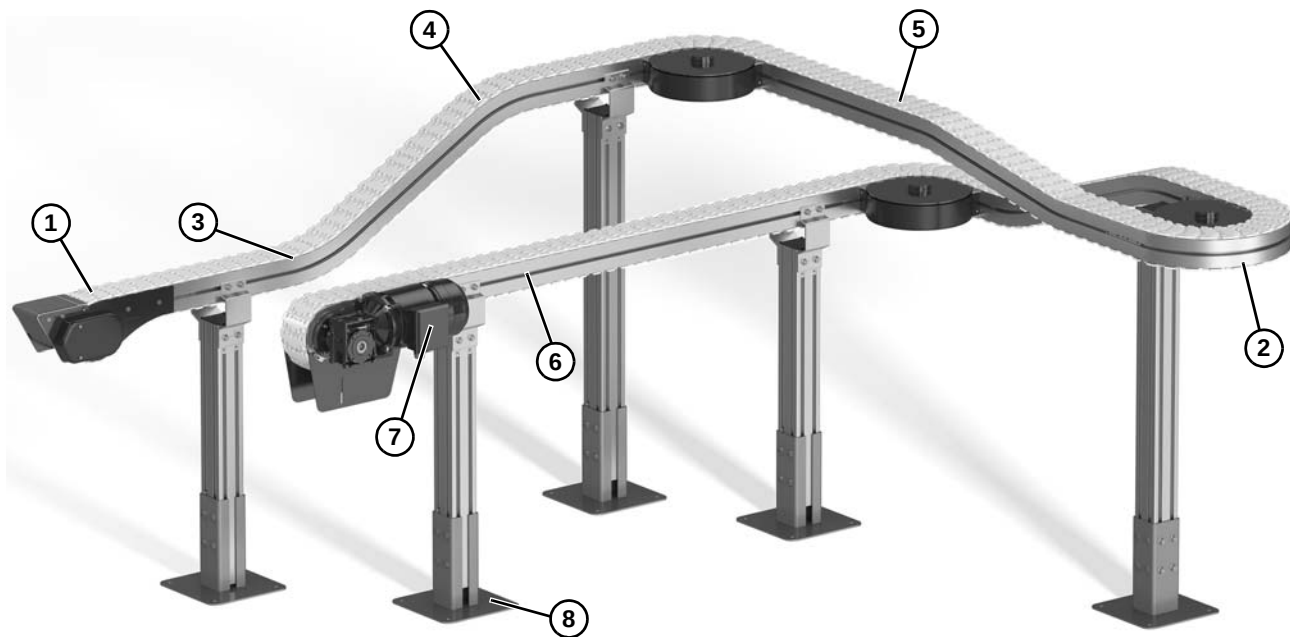
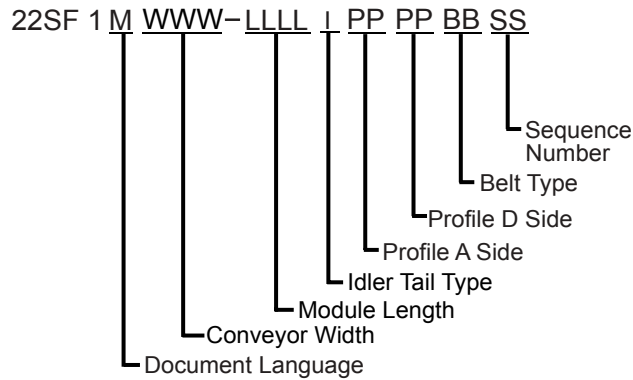


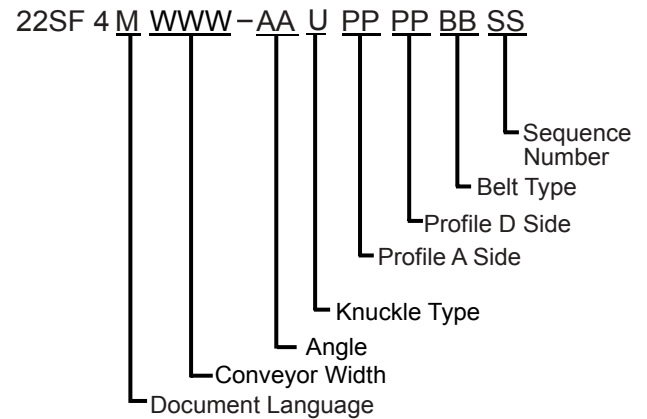
Figure 1

Modules:

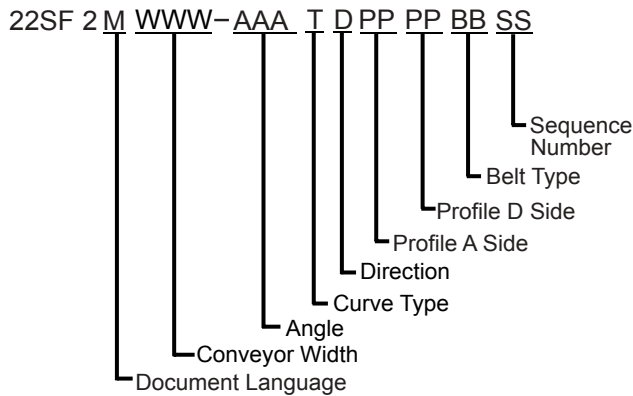
Infeed Module



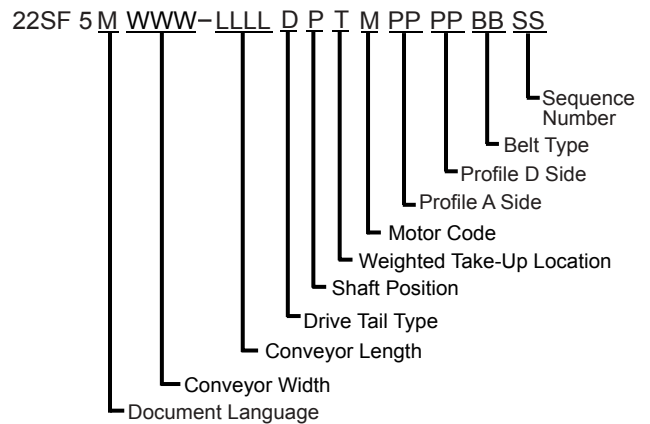
Incline/Decline Module



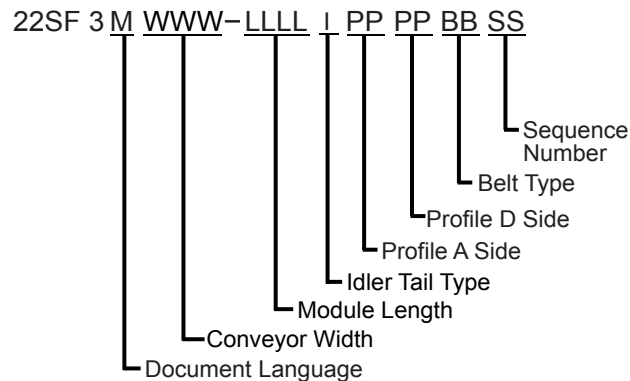
Curve Module



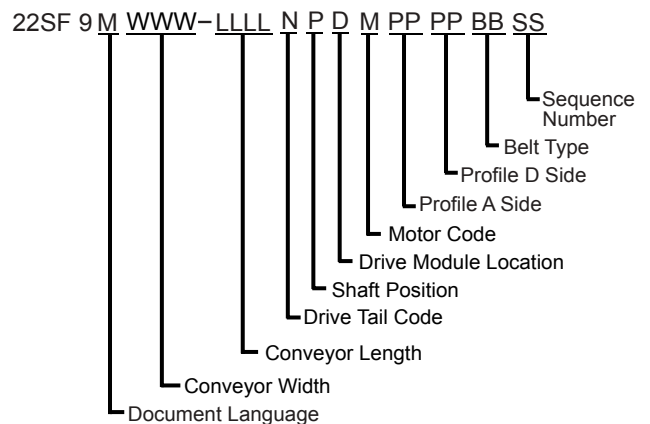
Drive Module



Intermediate Module



Top Running Drive Module



Specifications

Conveyor Supports:

Maximum Distances:

1 = 36" (914 mm)

2 = 10 ft (3048 mm)*

3 = 36" (914 mm)

* For conveyors longer than 10 ft (3048 mm), install support at joint.

Note: Additional support required on 180° curve modules.

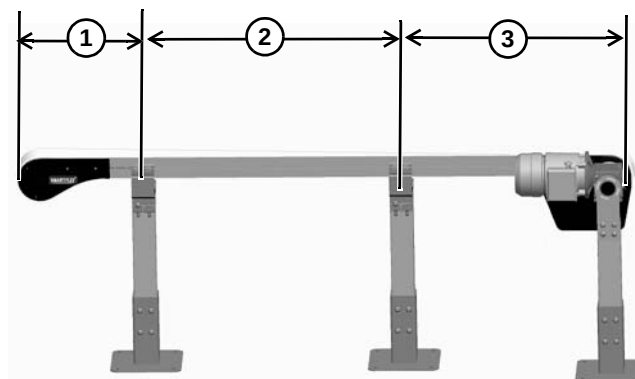


Figure 2

Specifications:

Conveyor Widths Reference (WW)	065	085	105	150
Conveyor Belt Width	2.47" (63 mm)	3.27" (83 mm)	4.05" (103 mm)	5.91" (150 mm)
Maximum Load	330 lb (149 kg)	660 lb (299 kg)	660 lb (299 kg)	660 lb (299 kg)
Maximum Belt Speed	250 Ft/min (76 M/min)			
Belt Takeup (Standard Weighted Take-up)	8" (203 mm)			
Module Length Reference	0167-5000			
Module Length	1.67' (509 mm)- 50.00' (15,240 mm)			
Total Conveyor Length	99 ft (30,175 mm) maximum			

Table 1: Gearmotor Specifications

U.S. Version

Item	Standard Load Gearmotor		
	Single Phase	Three Phase	VFD Variable Speed
Output Power	0.5 hp (0.37 kw)		
Input Voltage	115 VAC	208 – 230/460 VAC	230 VAC
Input Frequency	60Hz		10 – 60Hz
Input Current	7.4 Amperes	2.1 – 2/1 Amperes	1.6 Amperes
Gearmotor Ratios	5:1, 10:1, 20:1		
Frame Size	NEMA 56C		
Motor Type	Totally enclosed, Fan cooled		

CE Version

Item	Standard Load Gearmotor		
	Single Phase	Three Phase	VFD Variable Speed
Output Power	0.37 kW		
Input Voltage	230 VAC	230/400 VAC	230 VAC
Input Frequency	50 Hz		25 to 63 Hz
Input Current	2.6 Amperes	2.1/1.2 Amperes	2.1 Amperes
Gearmotor Ratios	5:1, 10:1, 20:1		
Protection Rating	IP55		
Frame Size	IEC 71 B5		

Specifications

SEW Gearmotor Specifications

Item	SEW Gearmotor					
	Three Phase			VFD Variable Speed		
Output Power	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)	0.5 Hp (0.37 kW)	0.75 Hp (0.56 kW)	1 Hp (0.75 kW)
Input Voltage	230/460			230/460		
Input Frequency	60 Hz			10 to 60 Hz		
Input Current	1.84/0.92 Amperes	2.50/1.25 Amperes	2.90/1.44 Amperes	1.84/0.92 Amperes	2.50/1.25 Amperes	2.90/1.44 Amperes
RPM	47	134	264	8 to 47	22 to 134	44 to 264
Ratio	37.7:1	13.4:1	6.8:1	37.7:1	13.4:1	6.8:1
Motor Frame	IEC71	IEC71	IEC80	IEC71	IEC71	IEC80
Motor Type	IP54 Totally Enclosed Fan Cooled			IP54 Totally Enclosed Fan Cooled		

Heavy Load Gearmotor Specifications

Item	Heavy Load Gearmotor				
	Single Phase	Three Phase			
Output Power	0.5 Hp (0.37 kW)	0.5 Hp (0.37 kW)	1 Hp (0.75 kW)	1.5 Hp (1.11 kW)	2.0 Hp (1.49 kW)
Input Voltage	115 VAC	208-230/460 VAC			
Input Frequency	60 Hz				
Input Current	8.0 Amperes	2.0/1.0 Amperes	3.4/1.7 Amperes	5.0/2.5 Amperes	6.2/3.1 Amperes
Gearmotor Ratios	60:1, 80:1, 100:1	60:1, 80:1, 100:1	40:1, 50:1	25:1, 30:1	15:1, 20:1
Frame Size	NEMA 56 C	NEMA 56 C	NEMA 56 C	NEMA 145TC C	NEMA 145TC C
Motor Type	Totally Enclosed Fan Cooled				

Heavy Load Gearmotor Specifications (continued)

Item	Heavy Load Gearmotor			
	VFD Variable Speed			
Output Power	0.5 Hp (0.37 kW)	1 Hp (0.75 kW)	1.5 Hp (1.11 kW)	2.0 Hp (1.49 kW)
Input Voltage	230/460 VAC			
Input Frequency	15 to 60 Hz			
Input Current	1.6/0.8 Amperes	3.2/1.6 Amperes	4.2/2.1 Amperes	5.0/2.5 Amperes
Gearmotor Ratios	60:1, 80:1, 100:1	40:1, 50:1	25:1, 30:1	15:1, 20:1
Frame Size	NEMA 56 C	NEMA 56 C	NEMA 145TC C	NEMA 145TC C
Motor Type	Totally Enclosed Fan Cooled			

Specifications

Table 2: Belt Speed for Standard Load Fixed Speed 90° Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M060ES4(vp)FN	29	226	25.5	39	12	38	12	41	12
32M040ES4(vp)FN	43	247	27.9	57	17	57	17	60	18
32M020ES4(vp)FN	86	248	27.9	115	35	113	35	120	37

(vp) = voltage and phase

11 = 115 V, 1-phase

23 = 208 – 230/460 V, 3-phase

CE Version (50 Hz Gearmotors)

Part Number	RPM	N-m	Belt Speed					
			65 mm		85 mm		105 mm & 150 mm	
			Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
62Z060ES4(vp)FN	23	26.8	31	9.3	30	9.2	32	9.8
62Z040ES4(vp)FN	35	29.4	47	14	46	14	49	15
32Z020ES4(vp)FN	70	29.9	93	28	92	28	98	30
32Z010ES4(vp)FN	140	21.5	187	57	185	56	196	60

(vp) = voltage and phase

23 = 230 V, 3-phase

21 = 230 V, 1-phase

43 = 400 V, 3-phase

Table 3: Belt Speeds for Standard Load Variable Speed 90° VFD Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M060ES423EN	29	226	25.5	9.7 - 39	2.9 - 12	9.6 - 38	2.9 - 12	10 - 41	3.1 - 12
32M040ES423EN	43	247	27.9	14 - 57	4.4 - 17	14 - 57	4.3 - 17	15 - 60	4.6 - 18
32M020ES423EN	86	248	27.9	29 - 115	8.7 - 35	28 - 113	8.6 - 35	30 - 120	9.2 - 37
32M010ES423EN	173	156	17.6	58 - 231	18 - 70	57 - 228	17 - 70	60 - 242	18 - 74

CE Version (50 Hz Gearmotors)

Part Number	RPM	N-m	Belt Speed					
			65 mm		85 mm		105 mm & 150mm	
			Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
62Z060ES423EN	23	26.8	7.7 - 31	2.3 - 9.3	7.6 - 30	2.3 - 9.2	8 - 32	2.4 - 9.8
62Z040ES423EN	35	29.4	12 - 47	3.6 - 14	12 - 46	3.5 - 14	12 - 49	3.7 - 15
32Z020ES423EN	70	29.9	23 - 93	7.1 - 28	23 - 92	7 - 28	24 - 98	7.5 - 30
32Z010ES423EN	140	21.5	47 - 187	14 - 57	46 - 185	14 - 56	49 - 196	15 - 60

Specifications

Table 4: Belt Speeds for Standard Load SEW Fixed Speed Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M038WS423EN	47	548	61.9	63	19	62	19	66	20
32M013WS423EN	134	327	37.0	179	54	177	54	187	57

Table 5: Belt Speeds for Standard Load SEW Variable Speed Gearmotors

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M038WS423EN	47	548	61.9	16 - 63	4.8 - 19	15 - 62	4.7 - 19	16 - 66	5 - 20
32M013WS423EN	134	327	37.0	45 - 179	14 - 54	44 - 177	13 - 54	47 - 187	14 - 57

Table 6: Belt Speed for Heavy Load Fixed Speed 90° Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M100EH4(vp)FN	17	913	103	23	6.9	22	6.8	24	7.2
32M080EH4(vp)FN	22	833	94	29	8.9	29	8.8	31	9.4
32M060EH4(vp)FN	29	680	76	39	12	38	12	41	12
32M050EH423FN	35	1206	136	47	14	46	14	49	15
32M040EH423FN	43	1023	115	57	17	57	17	60	18
32M030EH423FN	58	1217	137	77	24	76	23	81	25
32M025EH423FN	70	1069	121	93	28	92	28	98	30
32M020EH423FN	86	1184	134	115	35	113	35	120	37
32M015EH423FN	115	910	103	153	47	152	46	161	49

Table 7: Belt Speed for Heavy Load Variable Speed 90° VFD Gearmotors

U.S. Version (60 Hz Gearmotors)

Part Number	RPM	In-lb	N-m	Belt Speed					
				65 mm		85 mm		105 mm & 150 mm	
				Ft/min	M/min	Ft/min	M/min	Ft/min	M/min
32M100HH423EN	17	913	103	5.7 - 23	1.7 - 6.9	5.6 - 22	1.7 - 6.8	5.9 - 24	1.8 - 7.2
32M080HH423EN	22	833	94	7.3 - 29	2.2 - 8.9	7.3 - 29	2.2 - 8.8	7.7 - 31	2.3 - 9.4
32M060HH423EN	29	680	76	9.7 - 39	2.9 - 12	9.6 - 38	2.9 - 12	10 - 41	3.1 - 12
32M050HH423EN	35	1206	136	12 - 47	3.6 - 14	12 - 46	3.5 - 14	12 - 49	3.7 - 15
32M040HH423EN	43	1023	115	14 - 57	4.4 - 17	14 - 57	4.3 - 17	15 - 60	4.6 - 18
32M030HH423EN	58	1217	137	19 - 77	5.9 - 24	19 - 76	5.8 - 23	20 - 81	6.2 - 25
32M025HH423EN	70	1069	121	23 - 93	7.1 - 28	23 - 92	7 - 28	24 - 98	7.5 - 30
32M020HH423EN	86	1184	134	29 - 115	8.7 - 35	28 - 113	8.6 - 35	30 - 120	9.2 - 37
32M015HH423EN	115	910	103	38 - 153	12 - 47	38 - 152	12 - 46	40 - 161	12 - 49
32M010HH423EN	173	636	72	58 - 231	18 - 70	57 - 228	17 - 70	60 - 242	18 - 74

Installation

Required Tools

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

Recommended Installation Sequence

- Locate and arrange sections by section labels:
- Assemble conveyor (Module lengths longer than 10 ft. (3000 mm))
- Install knuckles
- Install curves
- Install tails
- Unroll wear strips
- Install mounting bracket
- Install support stands
- Install belt
- Install weighted take-up
- Install guiding
- Install drive package
 - Motor mounting package
 - Gearmotor

Typical Connecting Components (**Figure 3**)

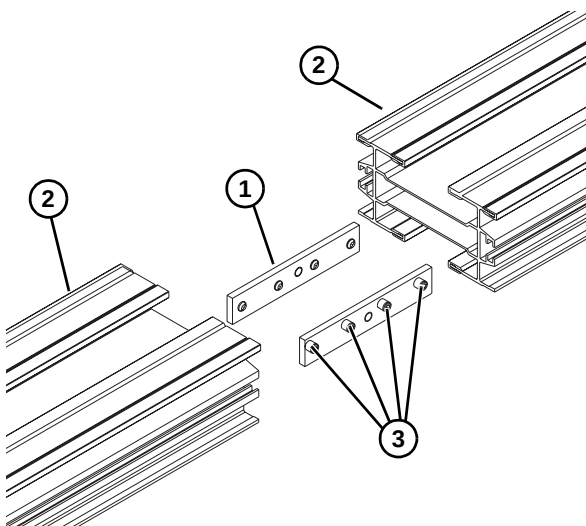


Figure 3

1	Clamp Plate
2	Conveyor frames
3	Set Screw, M8 - 1.25 x 10 mm

Module Lengths Longer Than 10 ft (3048 mm)

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

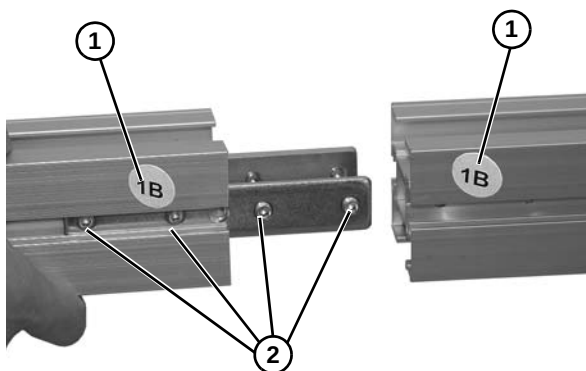


Figure 4

2. Join both conveyor sections, and tighten two set screws (**Figure 4, item 2**) on both sides. Tighten all set screws 1/4 turn past contact with frame.

Knuckles

NOTE

Be sure all frame sections (**Figure 5, item 1**) are properly supported during knuckle assembly.

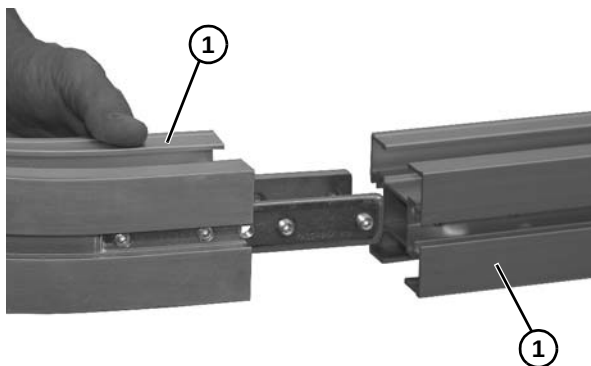


Figure 5

1. Join knuckle conveyor frame section (**Figure 6, item 1**), and conveyor frame (**Figure 6, item 2**) and secure with two set screws (**Figure 6, item 3**) on both sides. Tighten all set screws 1/4 turn past contact with frame.

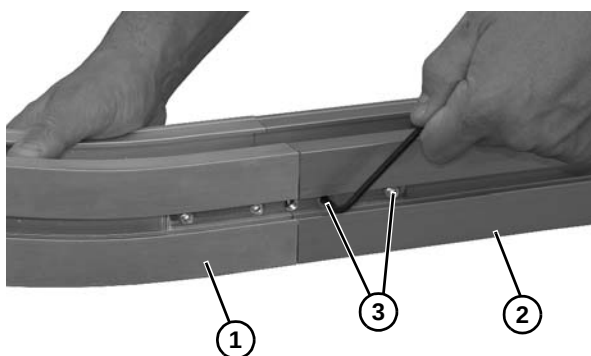


Figure 6

Curves

Typical Curve Connecting Components (**Figure 7**)

- | | |
|---|------------------------------|
| 1 | Clamp Plate |
| 2 | Conveyor Frames |
| 3 | Curve Assembly |
| 4 | Set Screw, M8 - 1.25 x 10 mm |

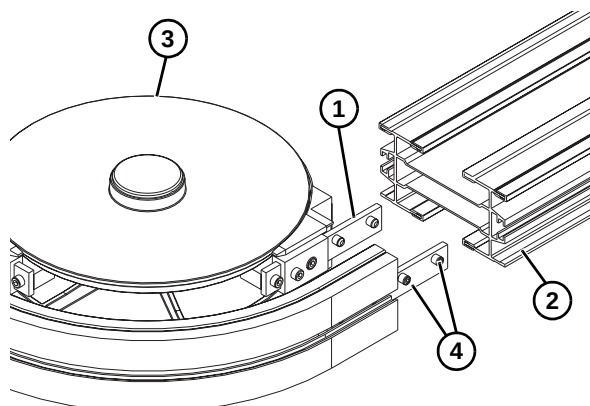


Figure 7

1. Remove two screws (**Figure 8, item 1**) and guard (**Figure 8, item 2**) from curve assembly.

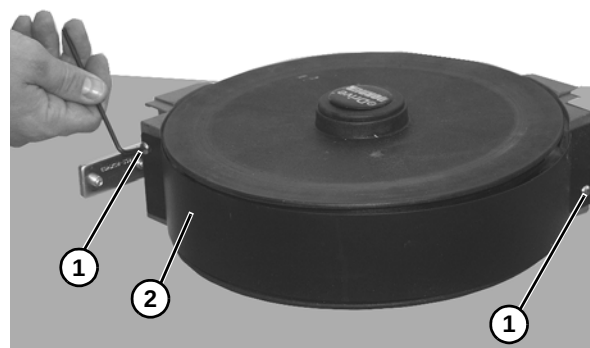


Figure 8

2. Install curve assembly (**Figure 9, item 1**) clamp plates (**Figure 9, item 2**) into one conveyor section (**Figure 9, item 3**) by lining up clamp plate with slot in conveyor frame.

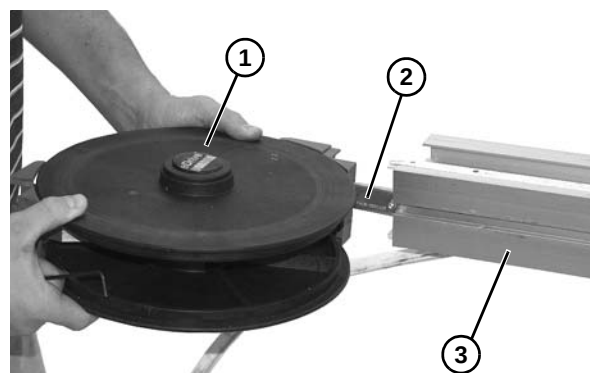


Figure 9

Installation

- Secure with two set screws (**Figure 10, item 1**). Tighten all set screws 1/4 turn past contact with frame.

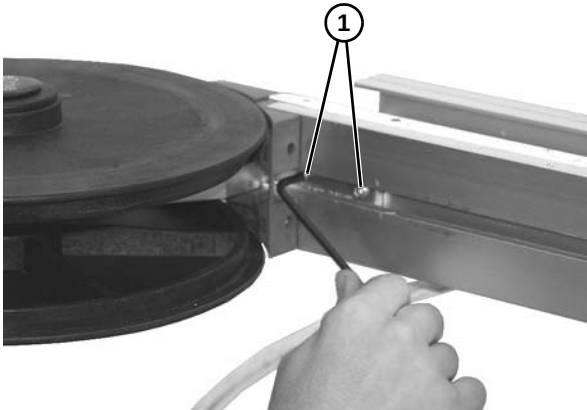


Figure 10

- Install outer curve frame assembly (**Figure 11, item 1**) clamp plate (**Figure 11, item 2**) into conveyor frame section (**Figure 11, item 3**) by lining up clamp plate with slot in conveyor frame.

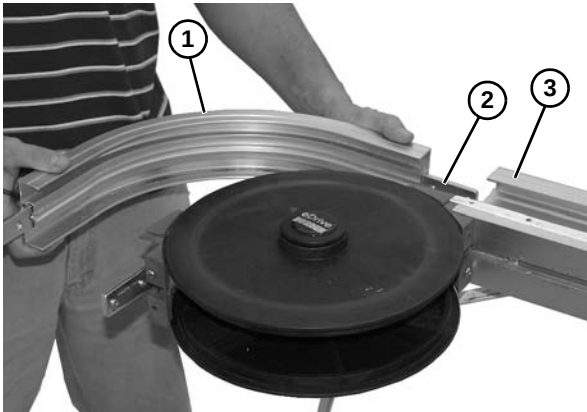


Figure 11

- Install opposite end of conveyor onto curve assembly, repeating procedure. Tighten all set screws 1/4 turn past contact with frame.
- Install guard with (**Figure 12, item 1**) two screws (**Figure 12, item 2**).



Figure 12

Tails

- Install tail assembly (**Figure 13, item 1**) clamp plate into conveyor frame section (**Figure 9, item 2**) by lining up clamp plate with slot in conveyor frame.

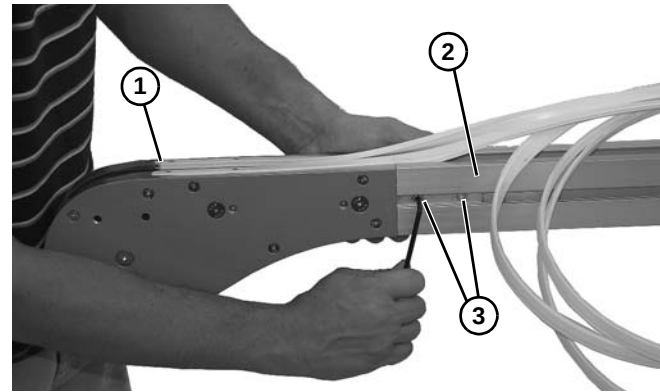


Figure 13

- Secure with two set screws (**Figure 13, item 3**). Tighten all set screws 1/4 turn past contact with frame.

Unroll Wear Strips

NOTE

Top and bottom wear strips are shipped pinned/attached at various places on conveyor.

- Unroll wear strip (**Figure 14, item 1**).

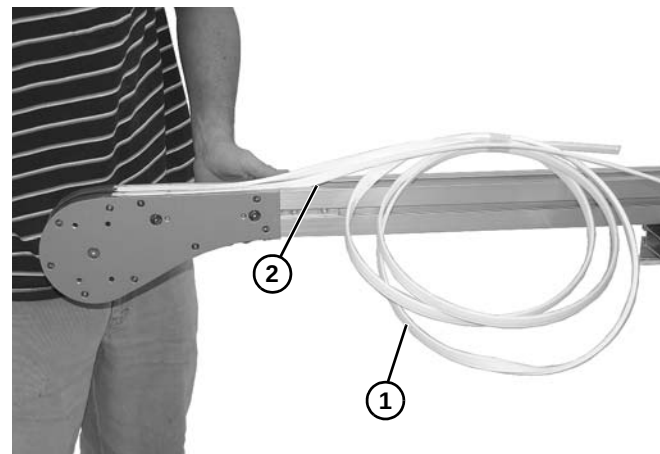


Figure 14

- Guide wear strip into channel (**Figure 14, item 2**) on conveyor frame.

Mounting Brackets

1. Locate brackets. Exploded views shown in **Figure 15**.

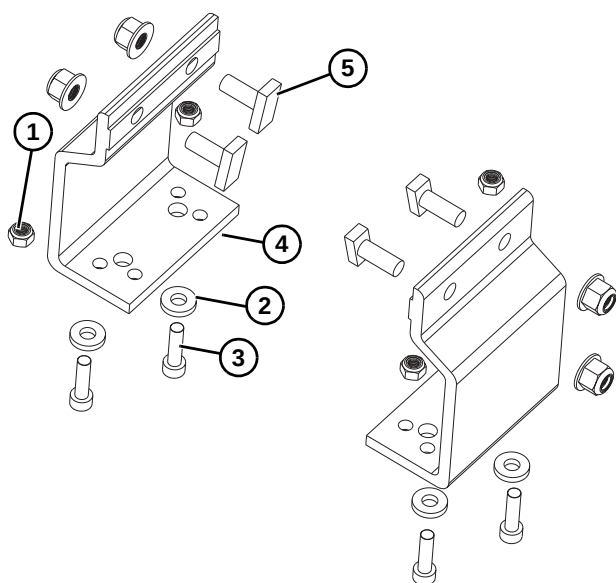


Figure 15

2. Remove nuts (**Figure 15, item 1**), washers (**Figure 15, item 2**), and screws (**Figure 15, item 3**) from brackets (**Figure 15, item 4**).
3. Insert bracket with studs (**Figure 15, item 5**) with head parallel to slot into conveyor side slots.
4. Fasten brackets (**Figure 16, item 1**) to conveyor with nuts (**Figure 16, item 2**) on studs. Turn nuts clockwise to rotate studs in side slots.

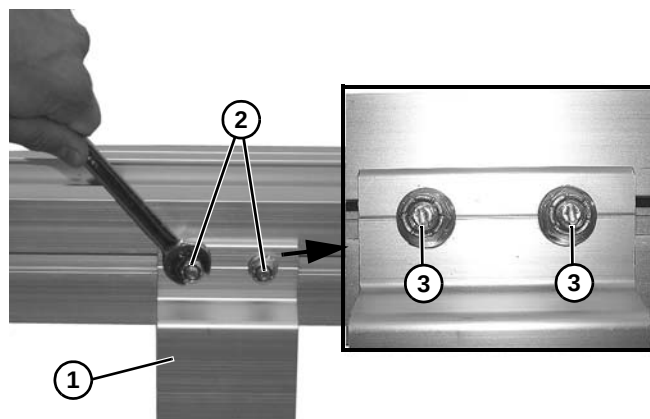


Figure 16

NOTE

Be certain that stud slot (**Figure 16, item 3**) is close to vertical when finished tightening nut.

5. Tighten nuts (**Figure 16, item 2**).

Install Support Stands

NOTE

For detailed assembly instructions, please see your appropriate support stand manual.

1. Fasten brackets (**Figure 17, item 1**) to support stand (**Figure 17, item 2**) with mounting screws, washers, and nuts (**Figure 17, item 3**).

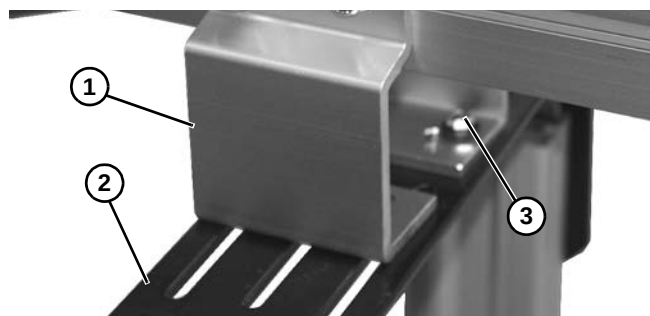


Figure 17

Belt Installation

Typical Belt Components (**Figure 18**).

- | | |
|---|------------|
| 1 | Chain Belt |
| 2 | Belt Rod |

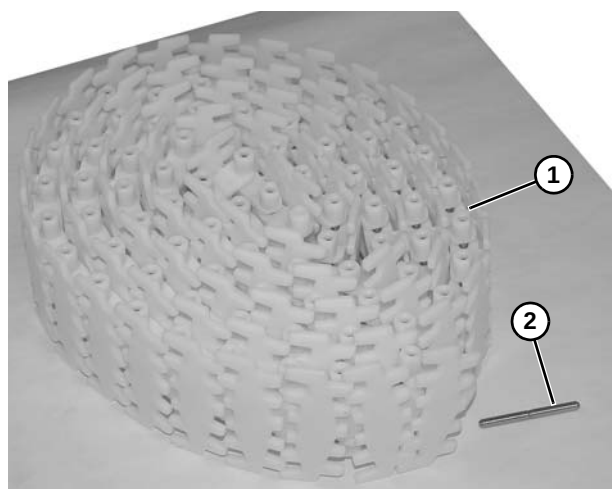


Figure 18

1. Position the belt on the conveyor frame.

Installation

2. Install the belt with direction arrow (**Figure 19, item 1**) pointing in direction of belt travel (**Figure 19, item 2**). Install belt from under tail end (**Figure 19, item 3**) and onto cogs (**Figure 19, item 4**) of shaft.

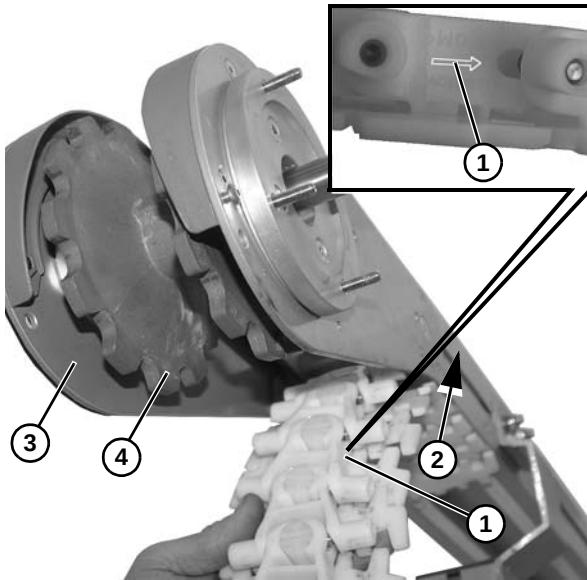


Figure 19

3. Continue wrapping belt (**Figure 20, item 1**) on top of idler tail retaining guide (**Figure 20, item 2**), continuing to turn shaft (**Figure 20, item 3**) to guide belt around cogs (**Figure 20, item 4**) of shaft.

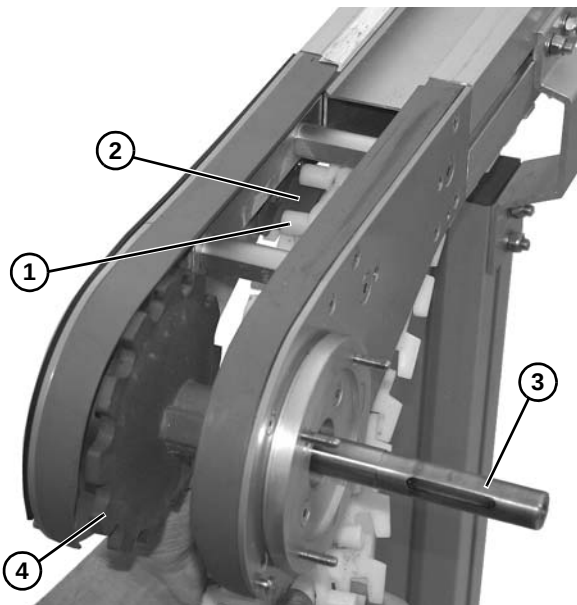


Figure 20

4. Insert the belt rod:

Standard Tail

- Install belt around drive end of conveyor and bring the ends of the belt (**Figure 22, item 1**) together.
- Insert rod (**Figure 22, item 2**).

NOTE

*Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area (**Figure 21, item 1**) on conveyor drive end.*

- Use punch and hammer or belt removal tool #203480 to press pin just below flush with side of belt. Stop when pin detent is felt.

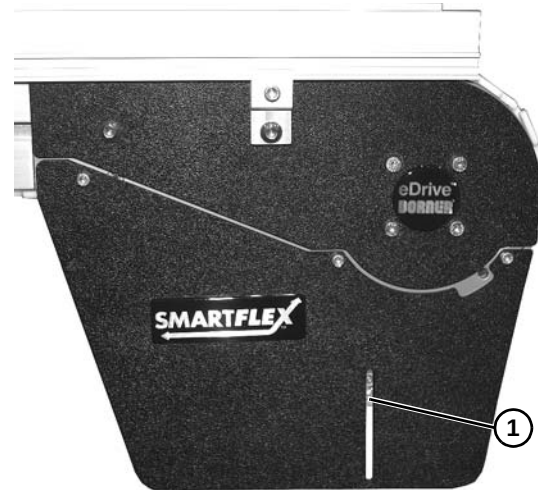


Figure 21

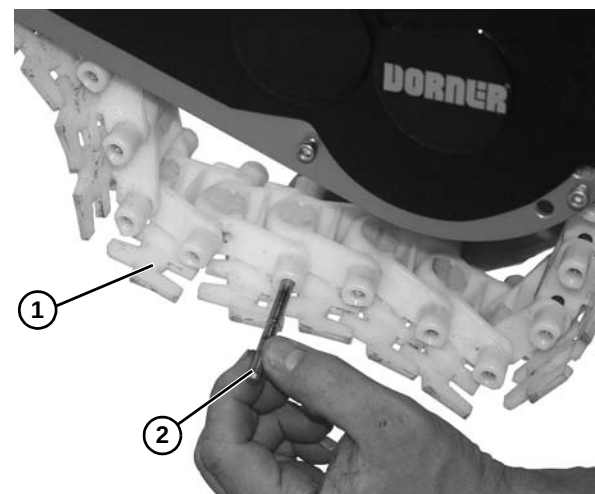


Figure 22

Weighted Take Up Tail

- Install belt around drive end of conveyor and bring the ends (**Figure 23, item 1**) of the belt together.
- Belt should only have enough slack to allow the idler assembly to be installed.
- Insert rod (**Figure 23, item 2**).
- Use punch and hammer or belt removal tool #203480 to press pin just below flush with side of belt. Stop when pin detent is felt.

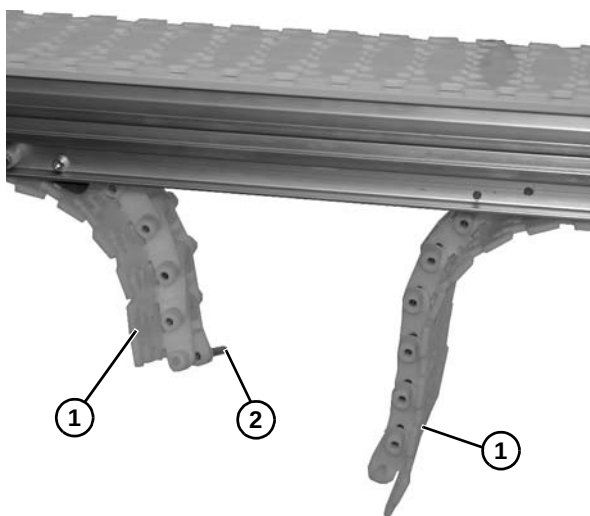


Figure 23

Weighted Take-Up

1. Install idler pulley assembly (**Figure 24, item 1**) onto belt (**Figure 24, item 2**).

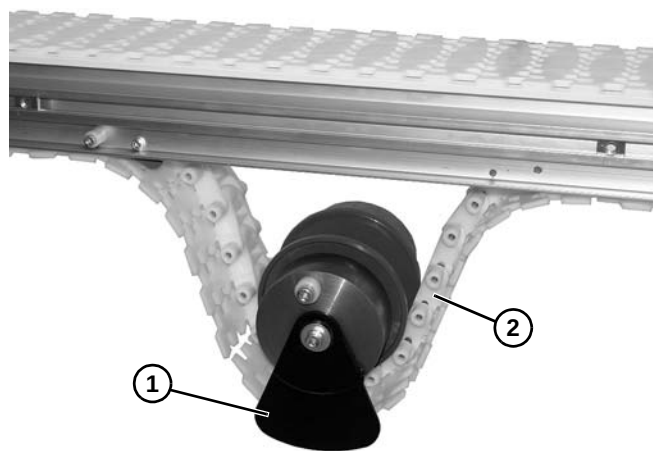


Figure 24

2. Make sure teeth on pulley and guard are facing mating teeth on take up box assembly.
3. Raise weighted take up box assembly, with plate (**Figure 25, item 1**) on idler pulley assembly on outside of outer plate (**Figure 25, item 2**) weighted take up assembly.

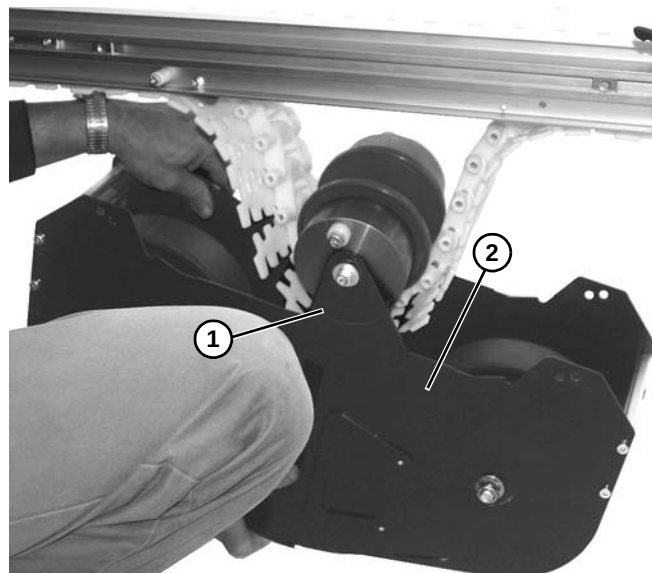


Figure 25

4. Raise weighted take up assembly (**Figure 26, item 1**) with notch (**Figure 26, item 2**) in assembly mating with stud (**Figure 26, item 3**) on conveyor frame.

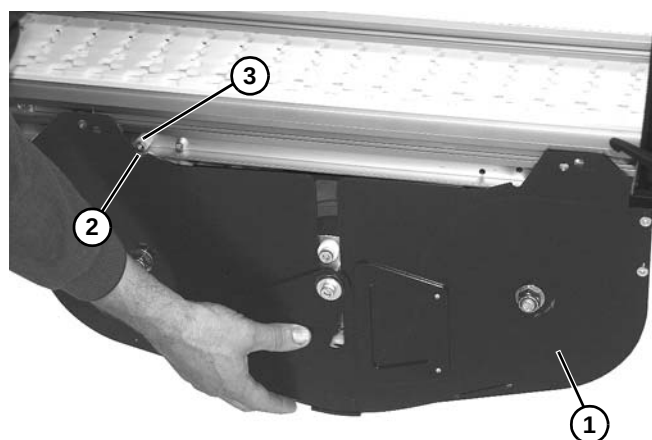


Figure 26

5. Install and tighten two hex head screws (**Figure 27, item 1**) on each side to secure assembly to frame.

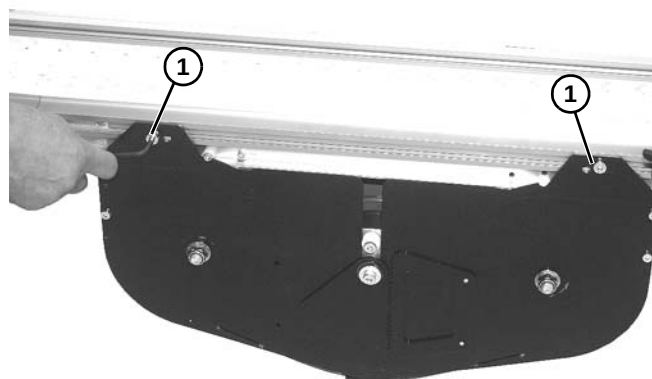


Figure 27

Installation

Top Running Drive

1. Install top running drive assembly (**Figure 28, item 1**) clamp plates into conveyor frame sections (**Figure 28, item 2**) by lining up clamp plates with slots in conveyor frame.

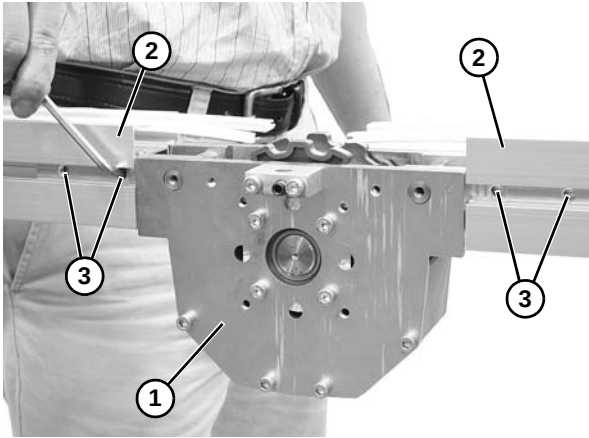


Figure 28

2. Secure with four set screws (**Figure 28, item 3**) on both sides of conveyor. Tighten all set screws 1/4 turn past contact with frame.
3. Install belt with the direction arrow pointing in the direction of belt travel.
4. Install belt around conveyor ends and bring the ends of the belt (**Figure 29, item 1**) together.

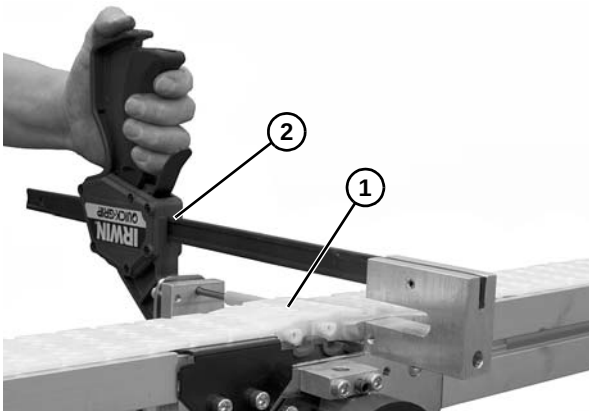


Figure 29

5. Insert the belt rod. Use a punch and hammer or belt removal tool #203480 (**Figure 29, item 2**) to press pin just below flush with side of belt. Stop when pin detent is felt.

6. Install drive motor mounting plate (**Figure 30, item 1**) using four hex head cap screws (**Figure 30, item 2**).

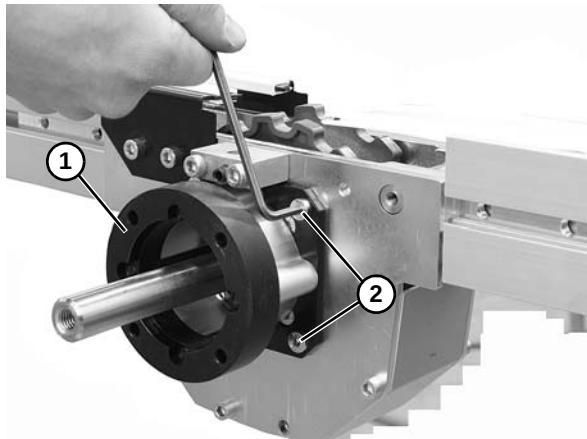


Figure 30

7. Install belt hold down tabs (**Figure 31, item 1**) to drive assembly (**Figure 31, item 2**) using four socket head screws (**Figure 31, item 3**).

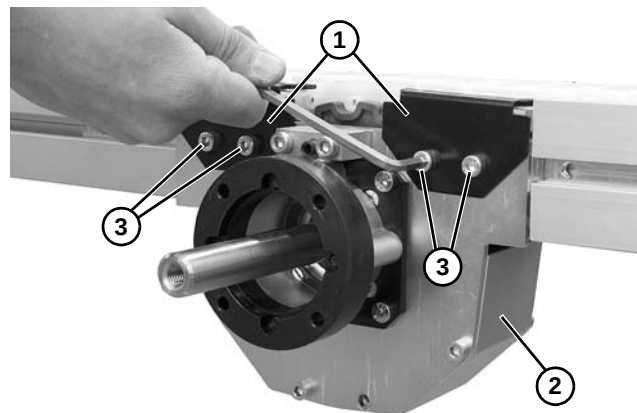


Figure 31

8. Repeat on opposite side.
9. Install belt hold down wheel (**Figure 32, item 1**) and tighten set screw (**Figure 32, item 2**).

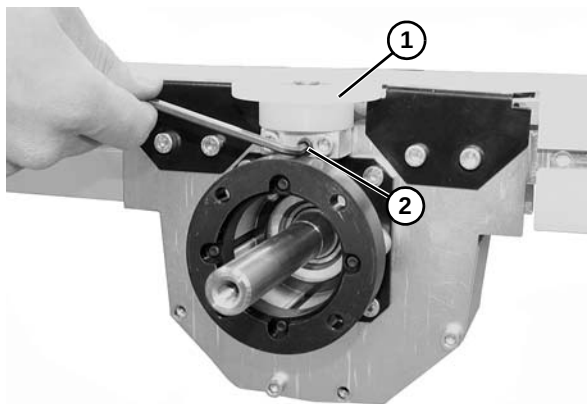


Figure 32

10. Install drive package (**Figure 33, item 1**) to drive motor mounting bracket (**Figure 33, item 2**) using four socket head screws (**Figure 33, item 3**).

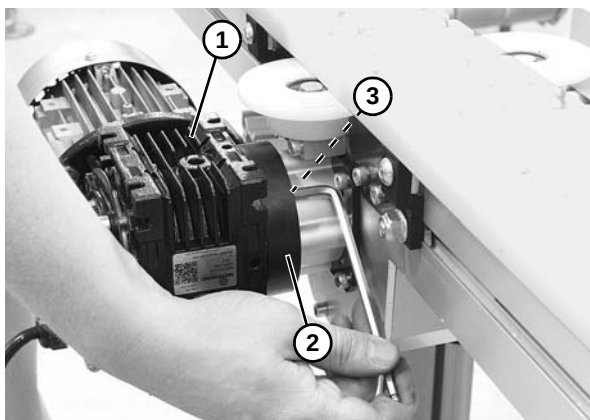


Figure 33

Install Guiding

All guiding must be located and installed by the end user.

Standard 1.5" and 3" Guiding

1. Install stud (**Figure 34, item 1**) onto retaining clip (**Figure 34, item 2**) with nut (**Figure 34, item 3**).

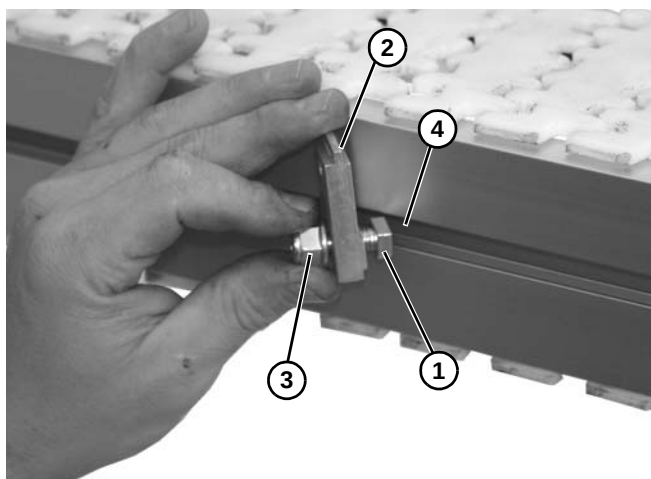


Figure 34

2. Install stud (**Figure 34, item 1**) into side rail channel (**Figure 34, item 4**). The end clips should be no greater than 12" from end of the conveyor.

3. Fasten retaining clip (**Figure 35, item 1**) to conveyor with nut (**Figure 35, item 2**) on stud.

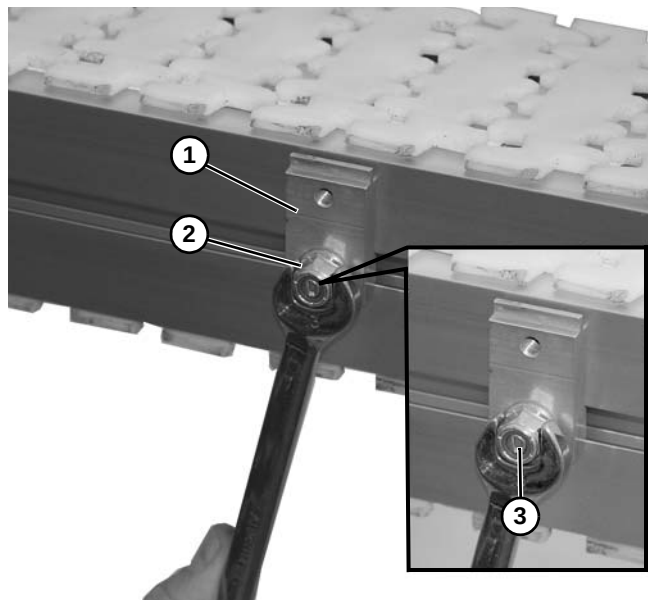


Figure 35

NOTE

*Be certain that slot (**Figure 35, item 3**) is close to vertical when finished tightening nut.*

4. Tighten nuts (**Figure 35, item 2**).
5. Install guide (**Figure 36, item 1**) and retaining clip (**Figure 36, item 2**) to conveyor side rail with socket head screw (**Figure 36, item 3**).

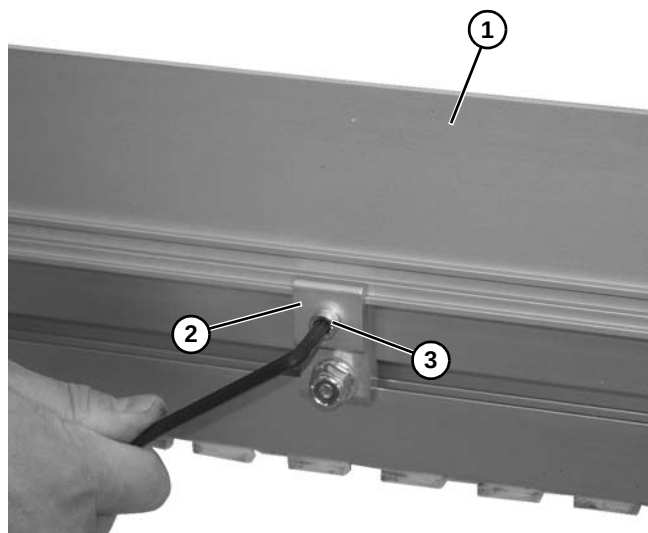


Figure 36

Installation

Puck/Pallet Guiding

1. Install clip assembly (**Figure 37, item 1**) into side rail channel (**Figure 37, item 2**). The end clips should be no greater than 12" from the end of the conveyor.

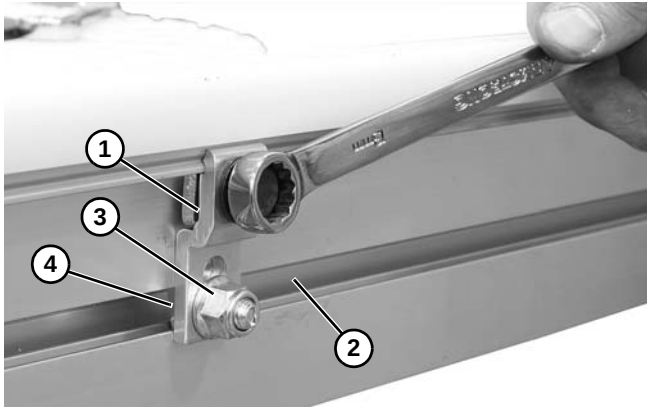


Figure 37

NOTE

*Make sure that the studs (**Figure 37, item 4**) rotate inside the channel and engage with the conveyor.*

2. Fasten clip (**Figure 37, item 1**) to conveyor with nut (**Figure 37, item 3**) on stud.
3. Tighten nuts (**Figure 38, item 1**).

NOTE

*Be certain that slot (**Figure 38, item 2**) is close to vertical when finished tightening nut.*

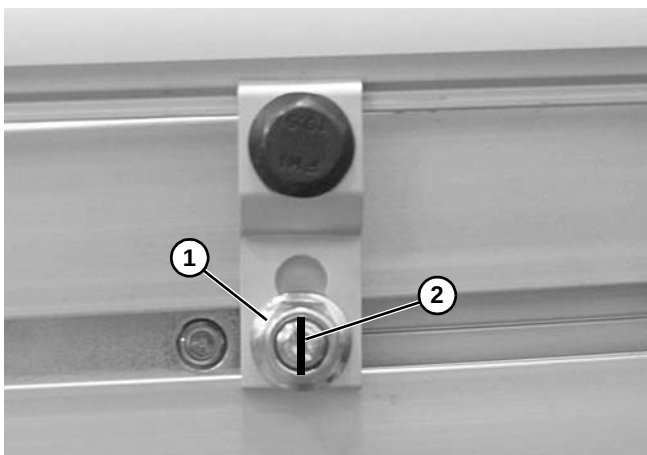


Figure 38

4. Attach wear strip (**Figure 39, item 1**) to guiding (**Figure 39, item 2**).

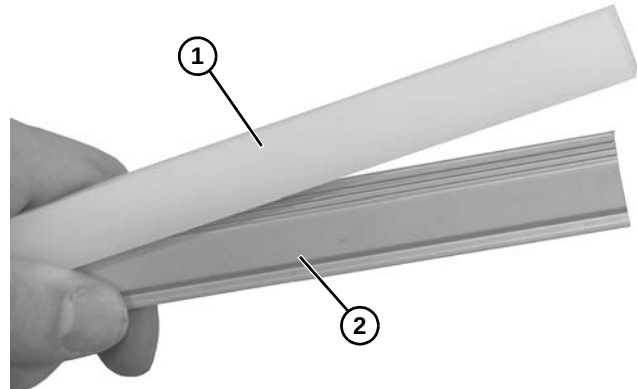


Figure 39

5. Attach guiding (**Figure 40, item 1**) to clip (**Figure 40, item 2**) and tighten screw (**Figure 40, item 3**).

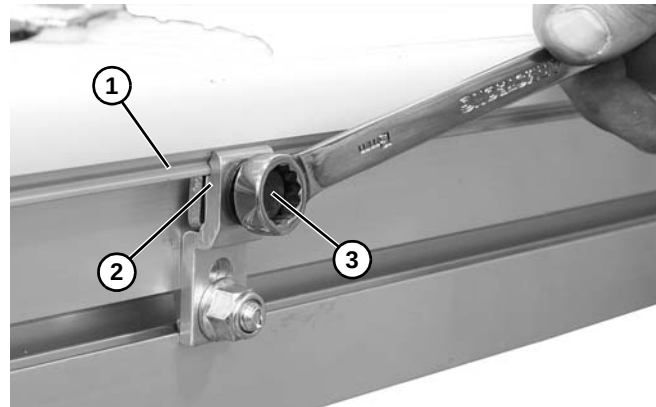


Figure 40

Fully Adjustable Guiding

1. Install stud (Figure 41, item 1) on guiding assembly (Figure 41, item 2) into side rail channel (Figure 41, item 3). The end guiding assemblies should be no greater than 12" from end of the conveyor.

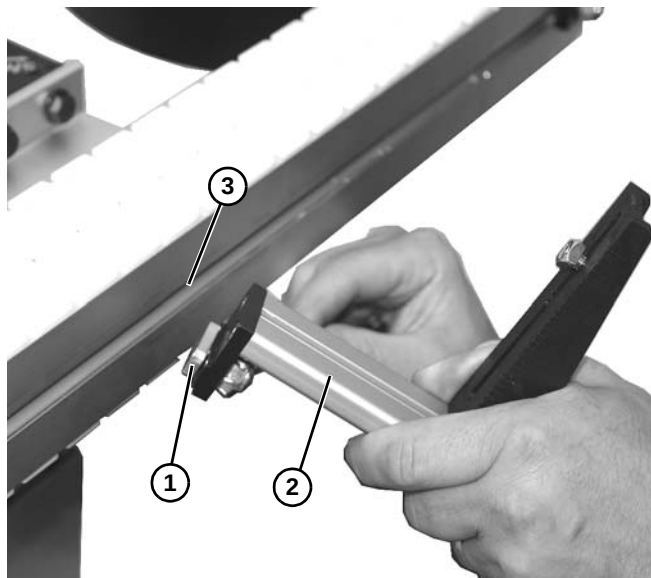


Figure 41

2. Tighten stud on guiding assembly (Figure 42, item 1) to conveyor with nut (Figure 42, item 2) on stud.

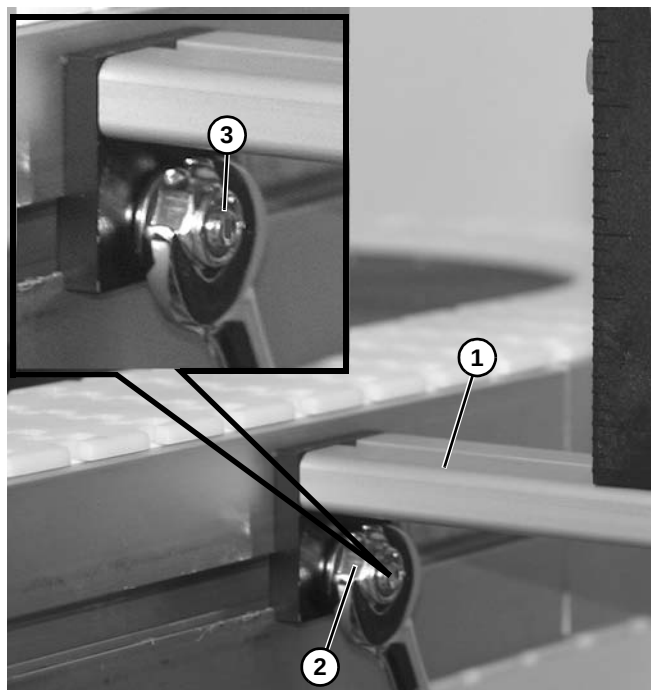


Figure 42

NOTE

Be certain that slot (Figure 42, item 3) is close to vertical when finished tightening nut.

3. Tighten nuts (Figure 42, item 2).
4. Install guide rail (Figure 43, item 1) onto square nut (Figure 43, item 2) onto mounting bracket (Figure 43, item 3) with socket head screw (Figure 43, item 4) or handle (Figure 44, item 1) for tool-less guiding.

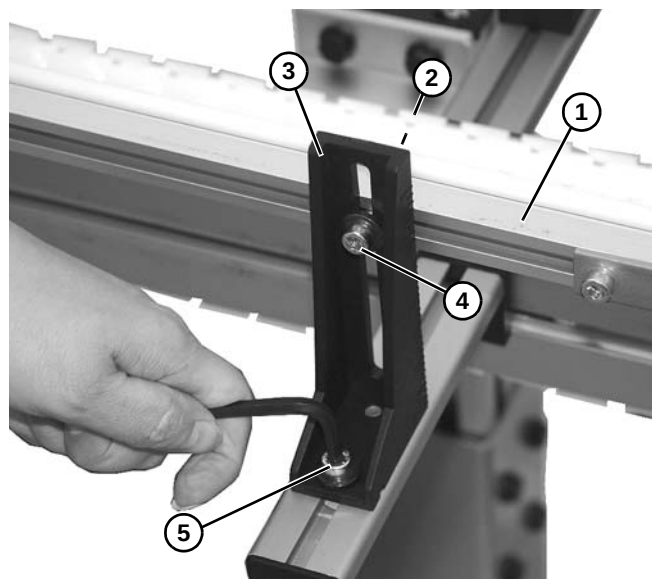


Figure 43

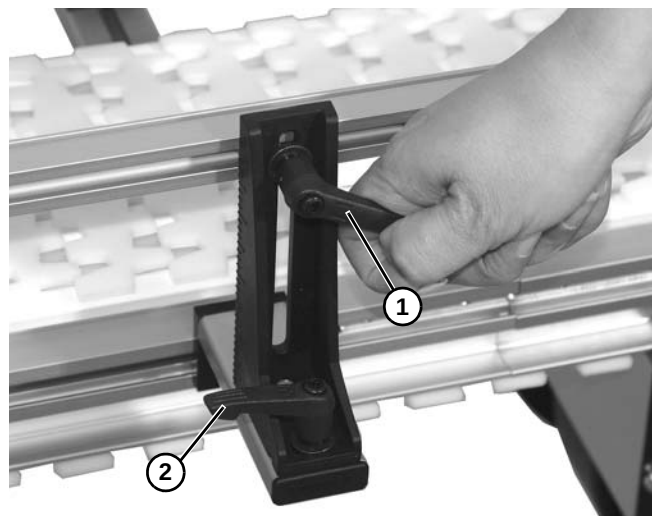


Figure 44

5. Loosen socket head screw (Figure 43, item 5) or handle (Figure 44, item 2) and adjust mounting bracket (Figure 43, item 3) as needed.

Installation

6. For curves, install inside of curve guide rail (**Figure 45, item 1**) to straight guide rails (**Figure 45, item 2**). Tighten set screws (**Figure 45, item 3**).

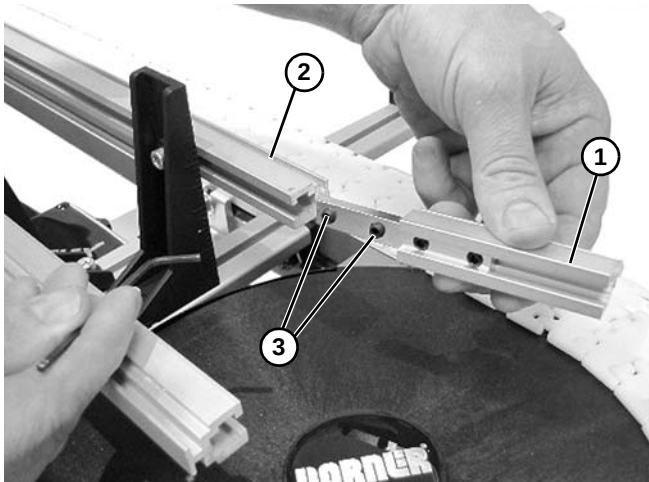


Figure 45

7. To install curve assembly guiding, start at one end of the conveyor and slide the guiding over the guide rails.
8. On the inside of the curve, install inner guiding (**Figure 46, item 1**) onto both of the inner guide rails (**Figure 46, item 2**).

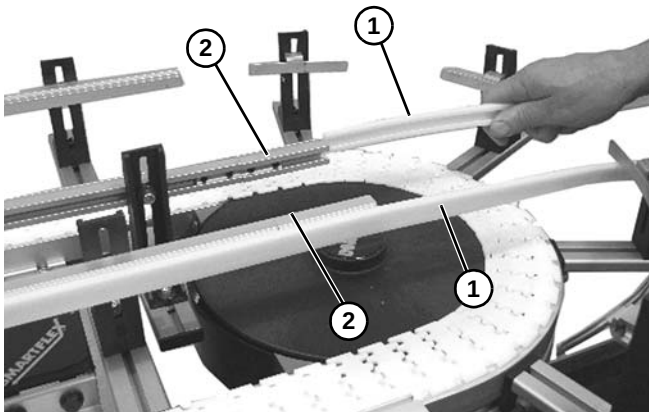


Figure 46

9. On outside of curve, install guiding (**Figure 47, item 1**) on the guide supports (**Figure 47, item 2**).

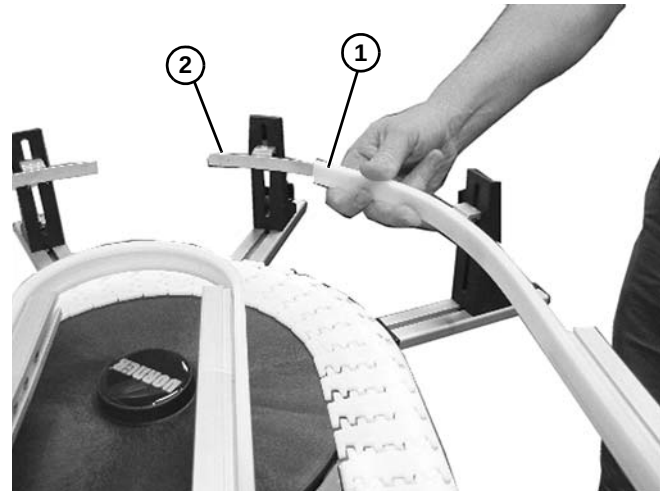


Figure 47

10. To adjust guiding width loosen screws (**Figure 43, item 5**) or handle (**Figure 44, item 2**). Adjust to desired width. Tighten screw or handle.
11. To adjust guiding height loosen screws (**Figure 43, item 4**) or handle (**Figure 44, item 1**). Adjust to desired height. Tighten screw or handle.

Install Drive Package

1. Install spacer (when applicable) (**Figure 48, item 1**), washer (**Figure 48, item 2**), and key (**Figure 48, item 3**) onto drive shaft.

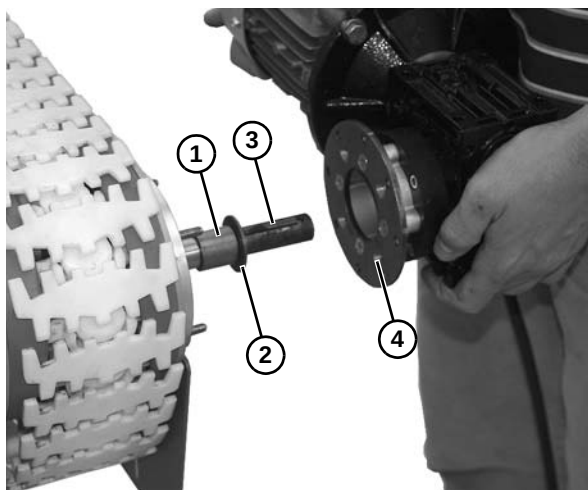


Figure 48

2. Attach the motor (**Figure 48, item 4**) onto the drive shaft.
3. Install four washers (**Figure 49, item 1**) and nuts (**Figure 49, item 2**) to secure motor to conveyor.

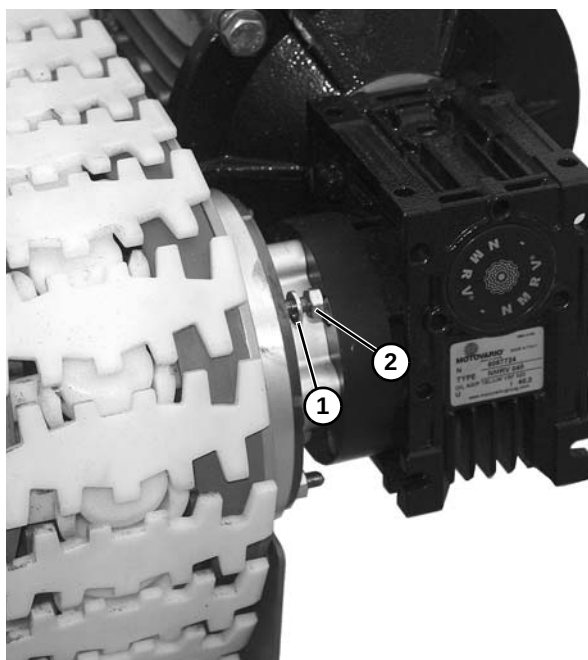


Figure 49

4. Install and tighten flat head screw (**Figure 50, item 1**) onto the drive shaft.

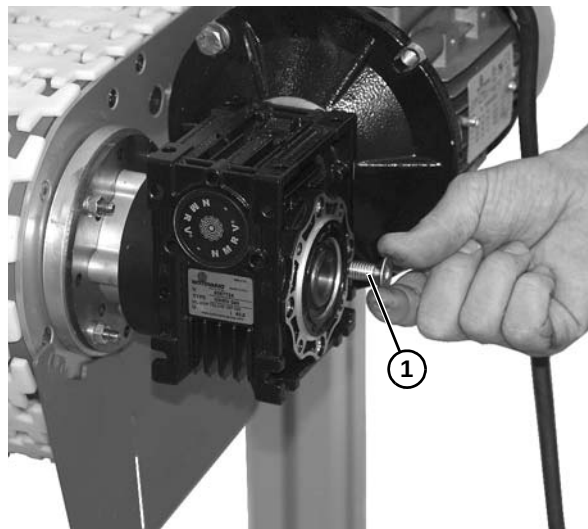


Figure 50

5. Install drive motor stand mounting bracket (**Figure 51, item 1**) onto the drive motor (**Figure 51, item 2**) with four washers and socket head screws (**Figure 51, item 3**).

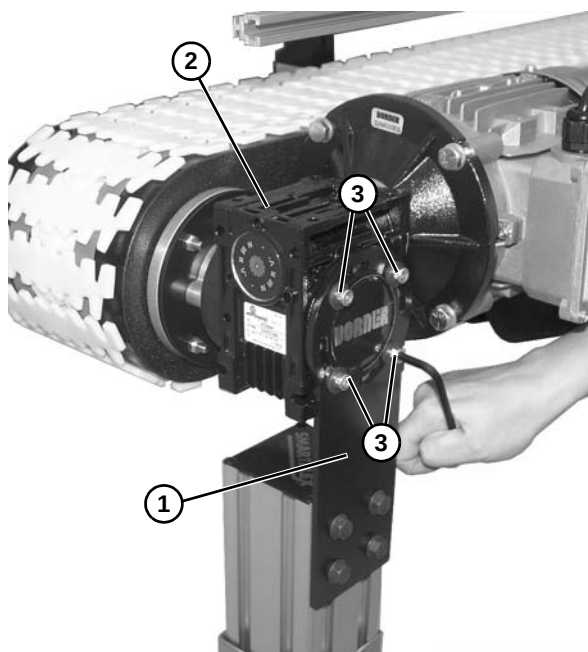


Figure 51

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
- 8 mm hex wrench
- 10 mm wrench
- 13 mm wrench
- 16 mm wrench
- Belt Removal Tool #203480

Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 46 for recommendations.
- Replace any worn or damaged parts.

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

NOTE

Visit www.dorner.com for complete list of troubleshooting solutions.

Inspect conveyor belt for:

- Surface cuts or wear
- Skipping

Damage to belt links or rods, surface cuts and / or wear indicate:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories

Skipping indicates:

- Excessive load on belt
- Worn spindle or impacted dirt on drive spindle

Conveyor Belt Replacement

⚠ WARNING



SEVERE HAZARD!

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

Replacing a Section of Belt

1. Use a punch and hammer or belt removal tool #203480 to push the belt rod (Figure 52, item 1) out by striking the rod end.

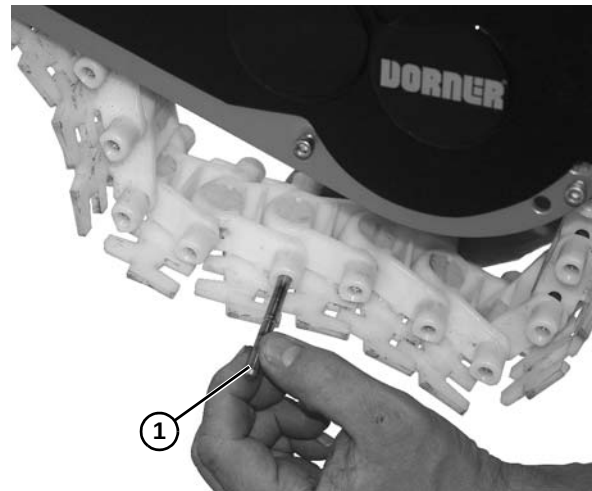


Figure 52

⚠ WARNING



SEVERE HAZARD!

If conveyor belt is damaged or worn, replace belt section.

2. Remove the belt rods on both sides of the section of belt being replaced.
3. Replace old section of belt.

⚠ CAUTION

DO NOT reuse belt rods that are damaged or show signs of wear.

Preventive Maintenance and Adjustment

NOTE

Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area (**Figure 53, item 1**) on convey or drive end.

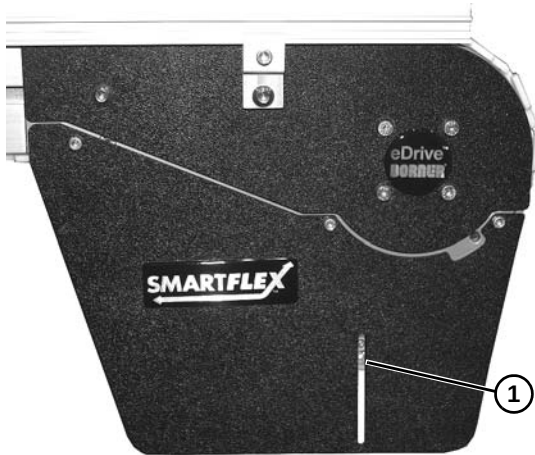


Figure 53

Replacing the Entire Belt

1. Use a punch and hammer or belt removal tool #203480 to push the belt rod (**Figure 54, item 1**) out by striking the rod end.

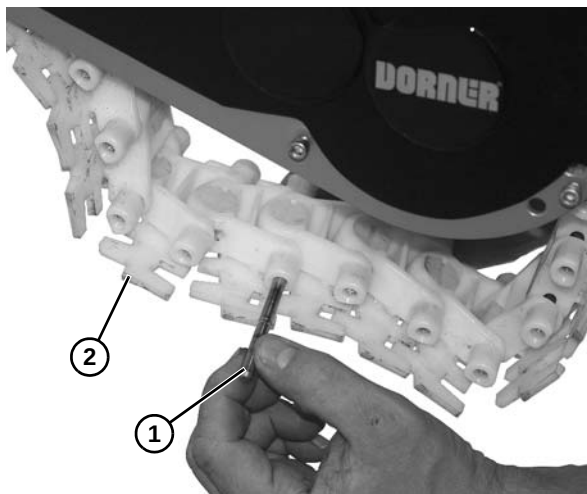


Figure 54

2. Slide the old belt (**Figure 54, item 2**) off the conveyor frame.
3. Replace the old belt with a new one. Refer to "Belt Installation" on page 15.

NOTE

Drive spindle shaft assembly replacement is recommended with belt replacement (see "Drive Spindle Shaft Assembly" on page 30).

CAUTION

DO NOT reuse belt rods that are damaged or show signs of wear.

Conveyor Belt Tensioning

WARNING



SEVERE HAZARD!

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

NOTE

Belt should not be stretched during installation. A proper length of belt can be installed by interlocking the ends by hand without excess links.

1. Remove one or more belt links to take up tension. Refer to "Replacing a Section of Belt" on page 24.

NOTE

Before inserting belt rod to connect belt ends, be certain that the slack on belt is showing in slotted area (**Figure 55, item 1**) on convey or drive end.

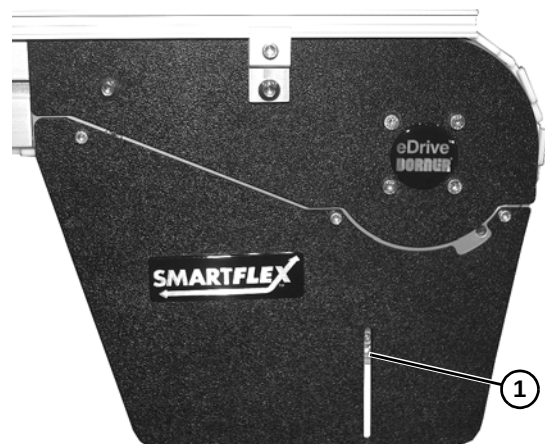


Figure 55

Preventive Maintenance and Adjustment

Wear Strip Removal

Replace the wear strips if they become worn.

NOTE

Top and bottom wear strips are shipped pinned/attached at various places on conveyor.

1. Remove belt. See “Conveyor Belt Replacement” on page 24.
2. Remove wear strip (**Figure 56, item 1**) from top of frame assembly up to pinned end (**Figure 56, item 2**).



Figure 56

3. Cut and remove worn wear strip section and replace with new wear strip. See “Wear Strip Installation” on page 26.
4. Remove lower wear strips, as needed, repeat procedure used for upper wear strips.

Wear Strip Installation

1. Remove wear strips. See “Wear Strip Removal” on page 26.

Attaching Wear Strip on Straight Frame

1. Start the wear strips (**Figure 57, item 1**) at an idler end (**Figure 57, item 2**) of conveyor. Separate the top and bottom flange of the wear strip at the end of rail and press into place.



Figure 57

2. Make sure the wear strip (**Figure 58, item 1**) is properly mounted and snaps onto the frame (**Figure 58, item 2**). Please identify the longer flange of the wear strip must always face the inside of the conveyor.

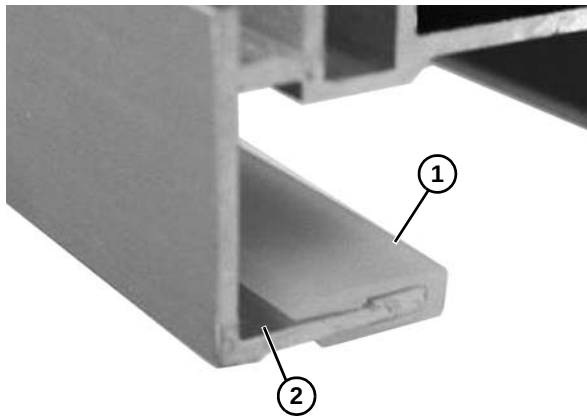
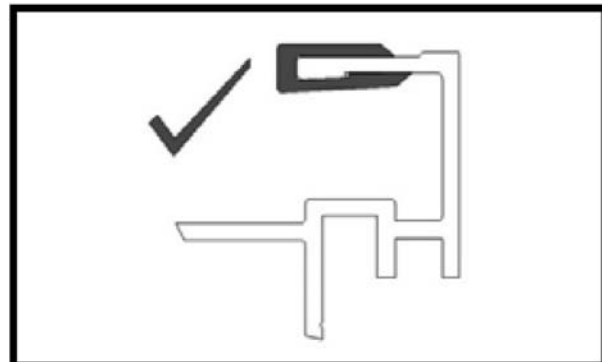
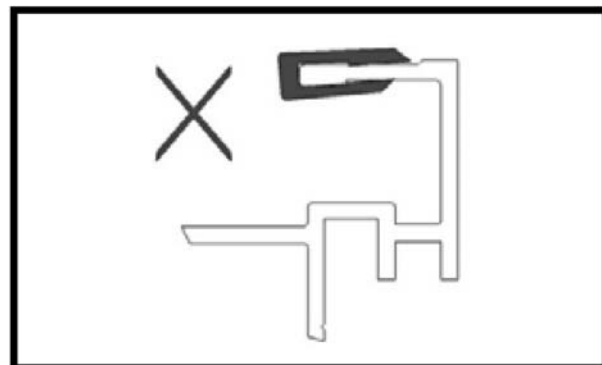


Figure 58



Correct Installation



Wrong Installation

Preventive Maintenance and Adjustment

Attaching Wear Strip on Conveyor Frame

1. Cut both wear strip (**Figure 59, item 1**) ends in a 45° angle. The beginning of a new wear strip (in the direction of travel) must cut back a small angle.

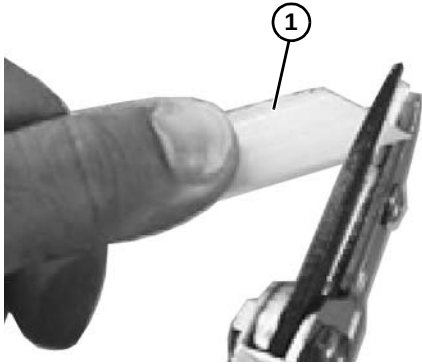


Figure 59

2. Allow a space of approximately 1/16" to 1/8" (**Figure 60, item 1**) between two wear strip ends. The travel direction is indicated by arrow.

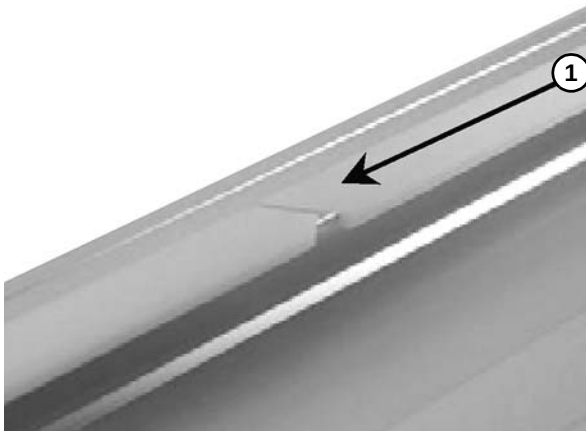


Figure 60

3. Do not place two wear strip joints opposite each other. Make sure there is a distance of at least 4" (**Figure 61, item 1**) between them to make the chain run smoother. This does not apply to a wear strip that begins by an idler unit or after a drive tail, where joints are always parallel.

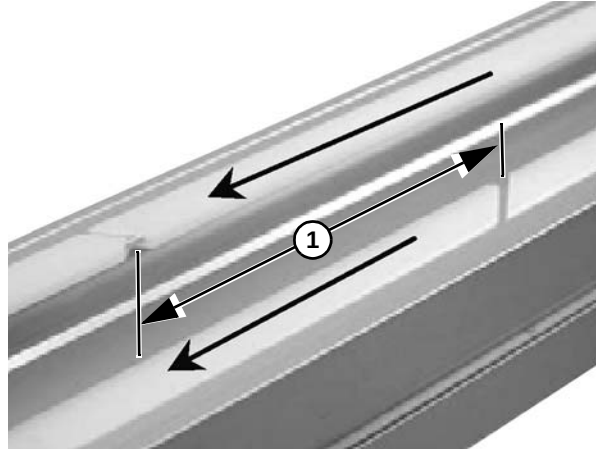


Figure 61

NOTE

Try to let the wear strip run in as continuous lengths as possible by reducing number of breaks, except in circumstances stated below:

- *It is recommended to use short wear strips (75"- 100") where chemicals may have an effect on the wear strip composition.*
- *It is important to cut the wear strip and allow for elongation in high load areas. Cutting is required in wheel bends (see following page), at idler tails and where the conveyor will be heavily loaded, especially at drive unit. This prevents the wear strip from stretching out and entering into the drive tail, which may block the chain movement.*
- *Never join wear strip in horizontal or vertical bends, since forces are higher on the wear strip side in these sections. Instead, place the joint before the bend.*
- *Avoid joining wear strips on top of the conveyor frame joints.*

Preventive Maintenance and Adjustment

Attaching Wear Strip at Wheel Bend

1. Cut the wear strip end flat (**Figure 62, item 1**). Make sure there is no gap created at the plastic molding part.

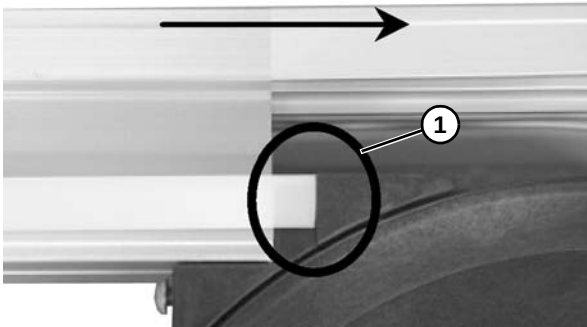


Figure 62

2. The step is applied onto out feed end (**Figure 63, item 1**) as well.

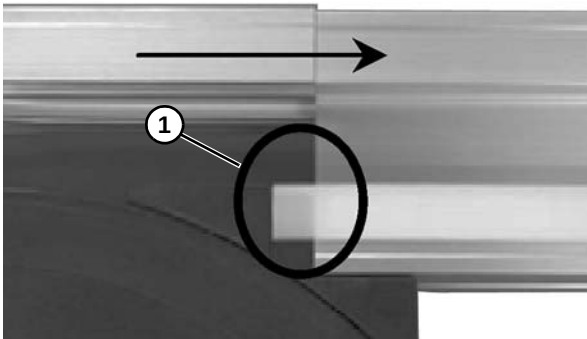


Figure 63

3. In the outer bend (**Figure 64, item 1**), make sure that the wear strip is properly connected to the conveyor frame.



Figure 64

Attaching Wear Strip

1. Attach wear strip replacement tool (**Figure 65, item 1**) over wear strip (**Figure 65, item 2**) and frame near the beginning of each wear strip section. Tightly secure in place.

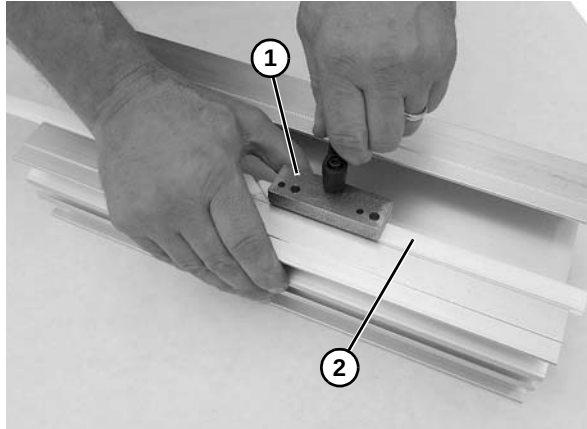


Figure 65

2. Using the wear strip replacement tool (**Figure 66, item 1**) drill two holes through the two small location holes (**Figure 66, item 2**) through the wear strip and frame using the #18 drill bit from the wear strip replacement kit.

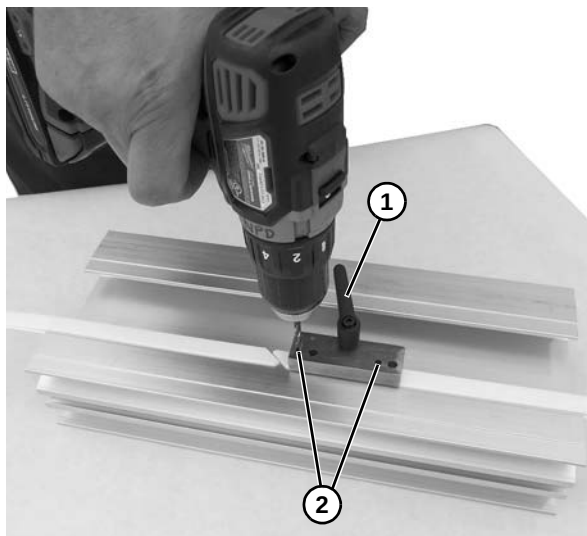


Figure 66

3. Remove debris from conveyor frame.
4. Relocate wear strip replacement tool to align the two larger guide holes with the holes drilled in the frame.

Preventive Maintenance and Adjustment

- Pressing down firmly, install nylon set screws (**Figure 67, item 1**) through larger guide holes (**Figure 67, item 2**) into conveyor frame.

NOTE
<i>Nylon set screw should be almost flush with the wear strip top when installed correctly.</i>

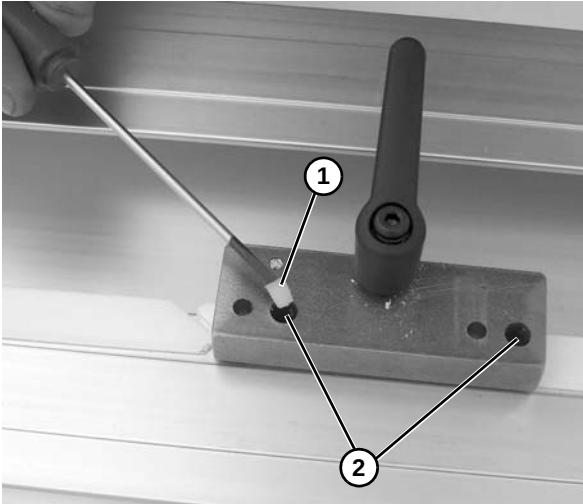


Figure 67

- Using a file, scrape off the top of the nylon set screw above the wear strip (**Figure 68, item 1**) to assure a smooth surface for the belt.

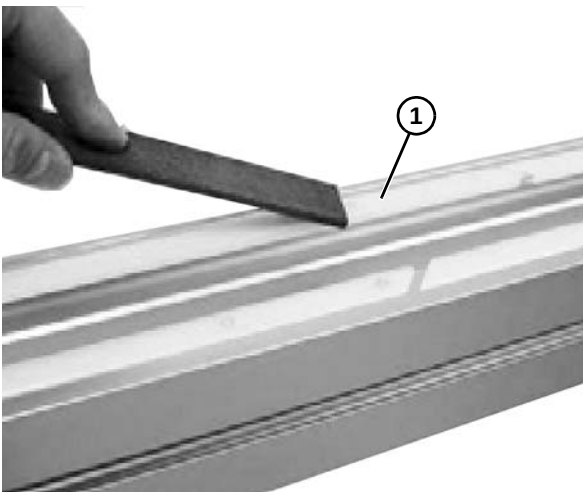


Figure 68

Preventive Maintenance and Adjustment

Idler Pulley Assembly

⚠ WARNING



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

1. Remove three flat head screws (**Figure 69, item 1**).

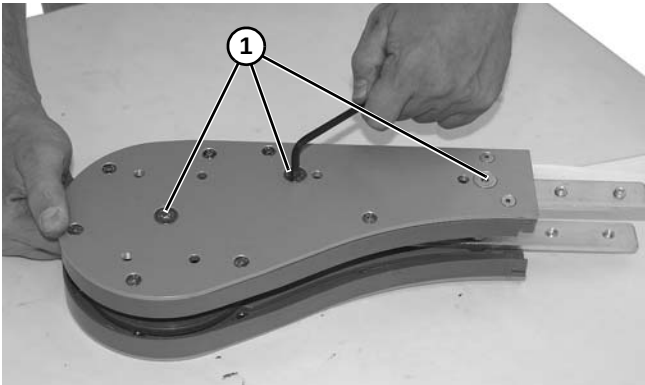


Figure 69

2. Remove the head plate (**Figure 70, item 1**) from the idler end.

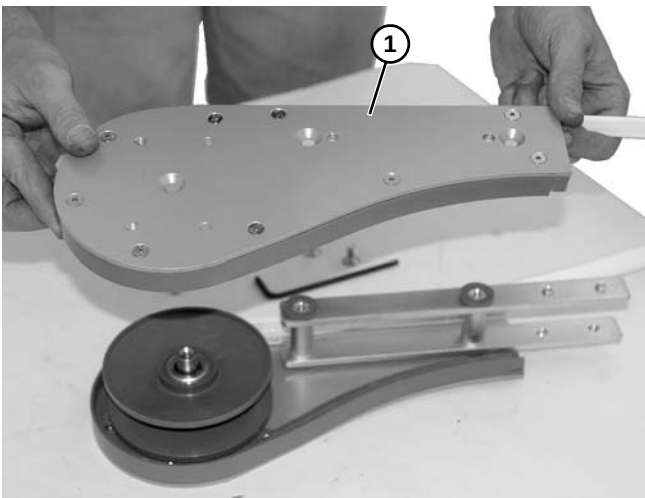


Figure 70

3. Remove flat head screw (**Figure 71, item 1**) and remove idler pulley (**Figure 71, item 2**) from idler head plate assembly.

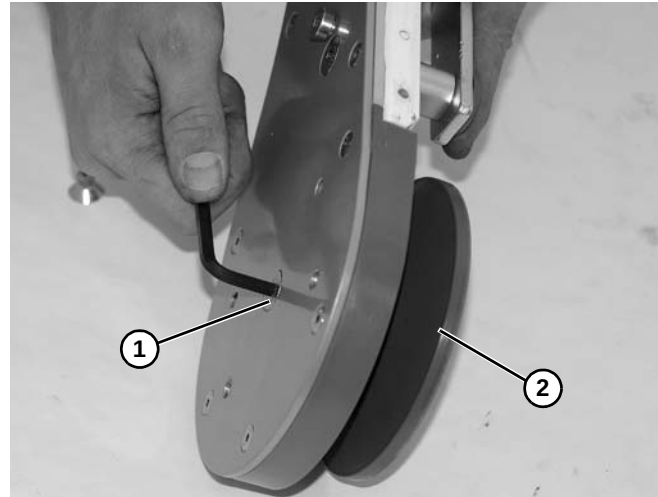


Figure 71

4. Install components reverse of removal.

Drive Spindle Shaft Assembly

⚠ WARNING



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

1. Remove the gearmotor.
2. Loosen two socket head set screws (**Figure 72, item 1**) on each side of conveyor, and remove the drive tail assembly (**Figure 72, item 2**) from the conveyor frame (**Figure 72, item 3**).

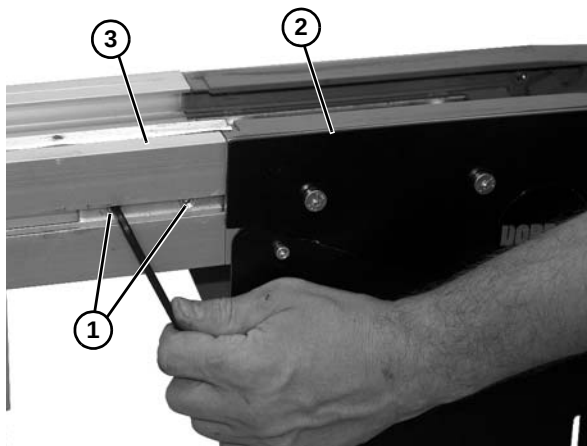


Figure 72

Preventive Maintenance and Adjustment

3. Remove four socket head screws (**Figure 73, item 1**) on side of drive spindle.

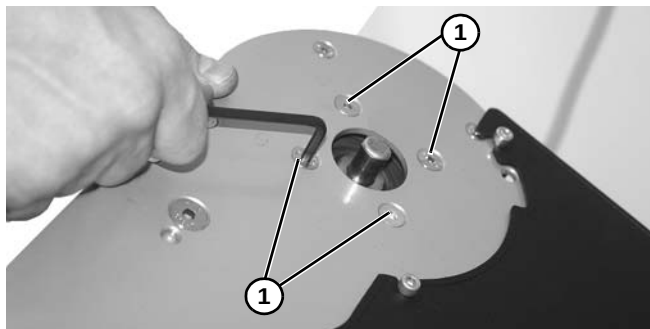


Figure 73

4. Remove two socket head screws (**Figure 74, item 1**) on side of drive spindle.

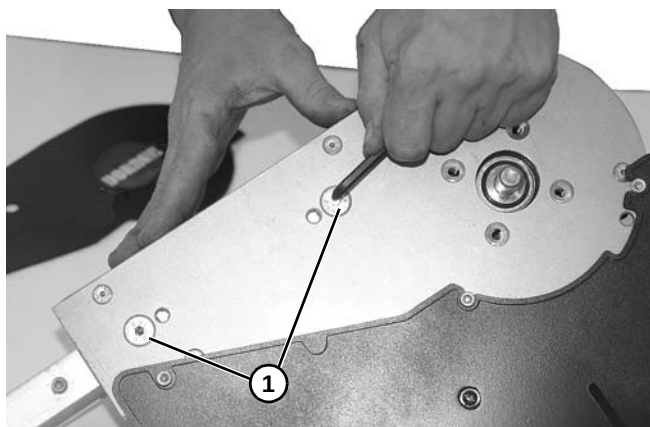


Figure 74

5. Remove the head plate (**Figure 75, item 1**) from the drive end.

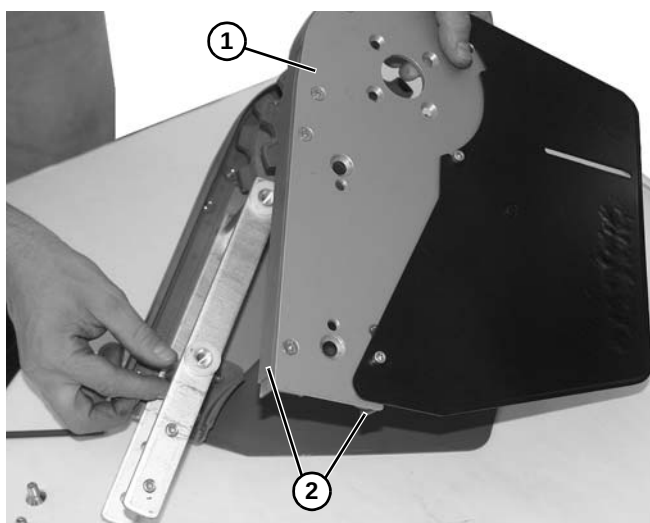


Figure 75

6. To remove upper and lower retaining guides (**Figure 75, item 2**), see “Retaining Guide Replacement” on page 32.

7. Remove spindle shaft assembly (**Figure 76, item 1**) from idler head plate assembly.

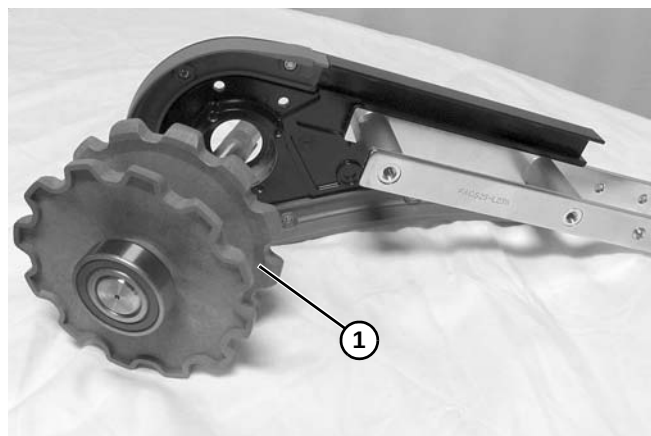


Figure 76

8. Install components reverse of removal.

Preventive Maintenance and Adjustment

Retaining Guide Replacement

Cantenary Drive End

1. Remove drive spindle shaft assembly. See “Drive Spindle Shaft Assembly” on page 30.
2. Remove three socket head screws (**Figure 77, item 1**) and remove drive plate guard (**Figure 77, item 2**) from drive plate (**Figure 77, item 3**).

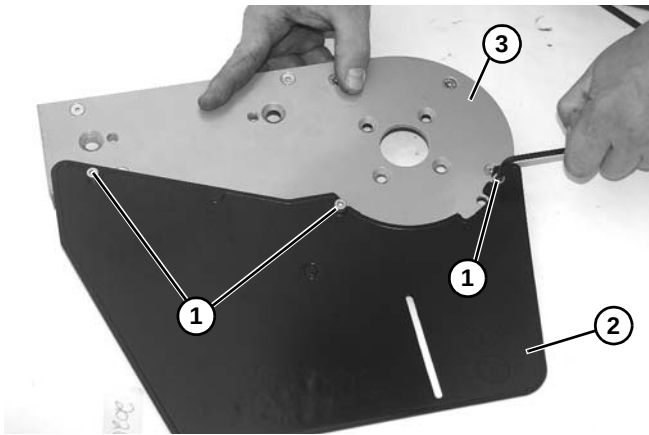


Figure 77

3. Remove two socket head screws (**Figure 78, item 1**).

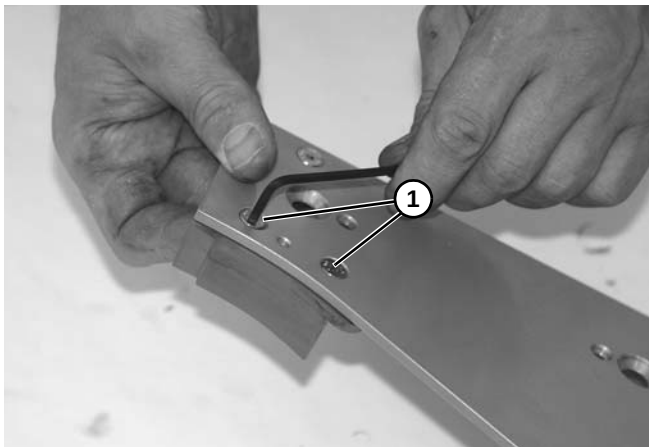


Figure 78

4. Remove lower retaining guide (**Figure 79, item 1**) from drive plate (**Figure 79, item 2**).

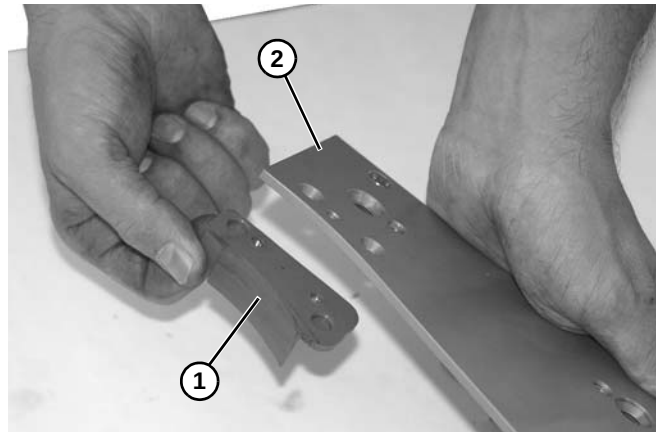


Figure 79

5. Remove three socket head screws (**Figure 80, item 1**).

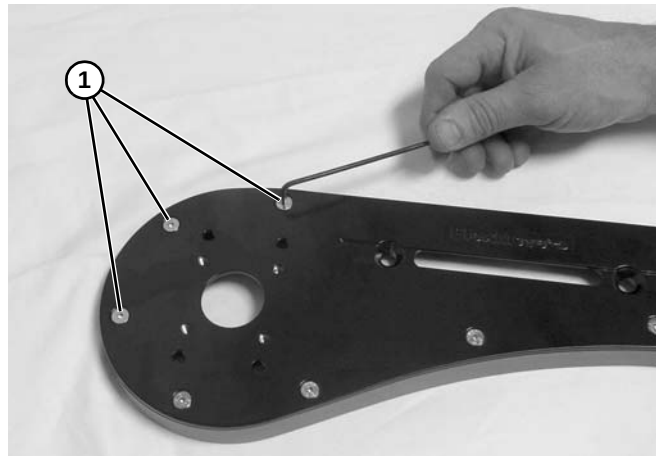


Figure 80

6. Remove upper retaining guide (**Figure 81, item 1**) from drive plate (**Figure 81, item 2**).

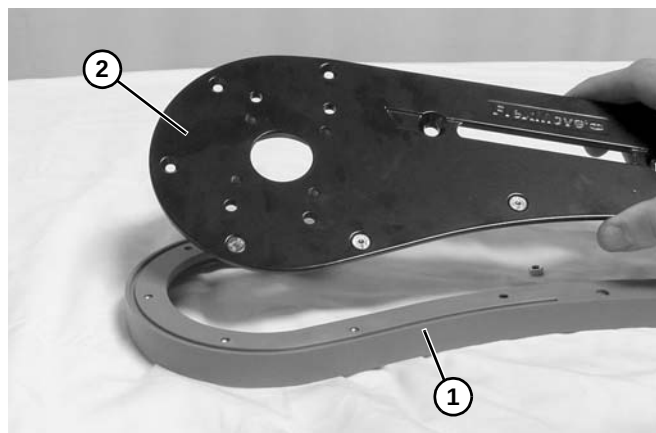


Figure 81

7. Install components reverse of removal.

Preventive Maintenance and Adjustment

Idler End and GTU Drive Tail

1. Remove idler pulley assembly. See “Idler Pulley Assembly” on page 30.
2. Remove seven (7) socket head screws (**Figure 82, item 1**) from idler head plate assembly.

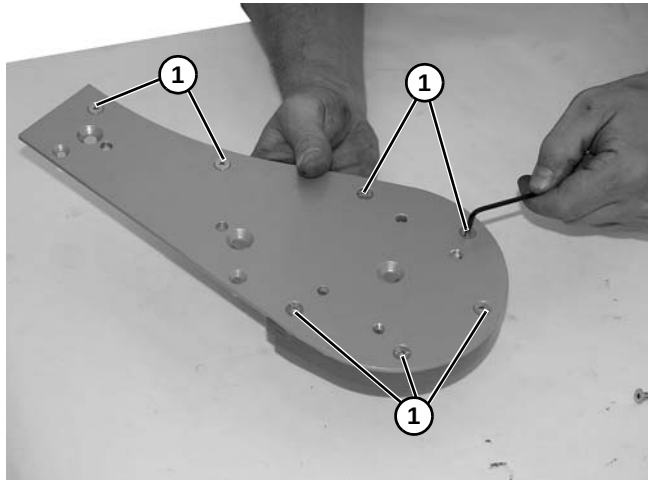


Figure 82

3. Remove retaining guide (**Figure 83, item 1**) from idler head plate assembly (**Figure 83, item 2**). Replace components, as needed.

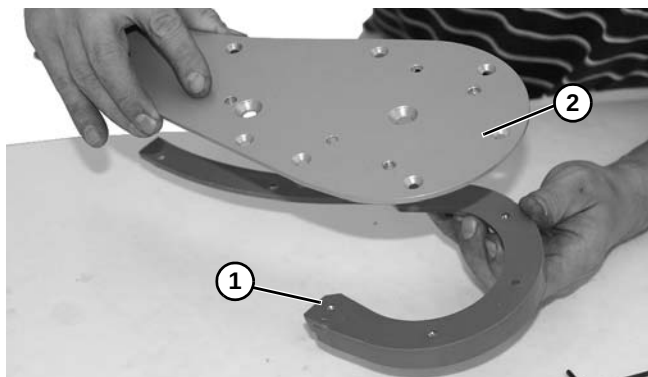


Figure 83

4. Install components reverse of removal.

Top Running Drive

1. Remove four socket head screws (**Figure 84, item 1**). Remove drive package (**Figure 84, item 2**) from drive motor mounting bracket (**Figure 84, item 3**).

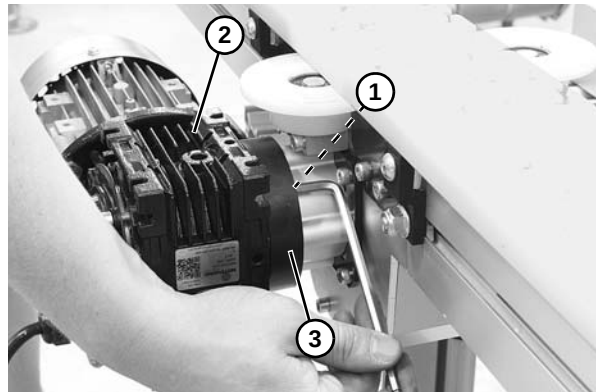


Figure 84

2. Loosen set screw (**Figure 85, item 1**) and remove belt hold down wheel (**Figure 85, item 2**).

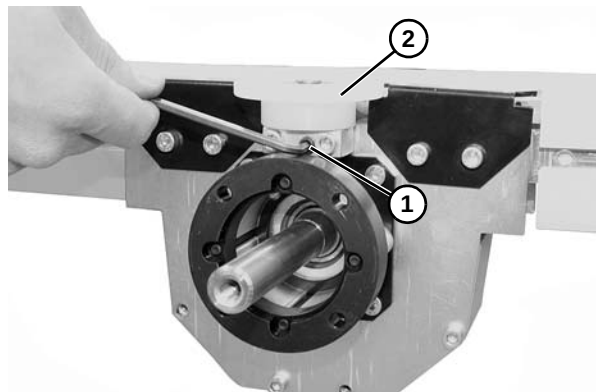


Figure 85

3. Repeat on opposite side.
4. Remove four socket head screws (**Figure 86, item 1**) securing belt hold down tabs (**Figure 86, item 2**) to drive assembly (**Figure 86, item 3**).

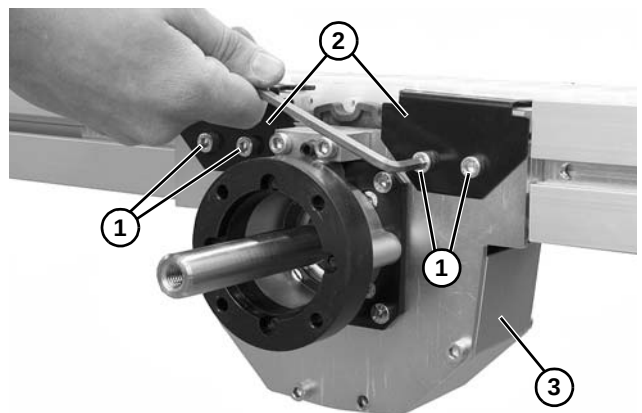


Figure 86

Preventive Maintenance and Adjustment

5. Repeat on opposite side.
6. Use belt removal tool #203480 (**Figure 87, item 1**) or a punch and hammer to push the belt rod out by striking the rod end.

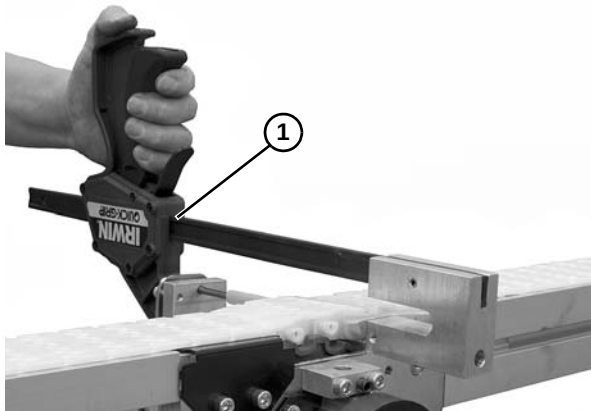


Figure 87

⚠ WARNING



SEVERE HAZARD!

If conveyor belt is damaged or worn, replace belt section.

7. Remove four hex head cap screws (**Figure 88, item 1**) and remove drive motor mounting plate (**Figure 88, item 2**).

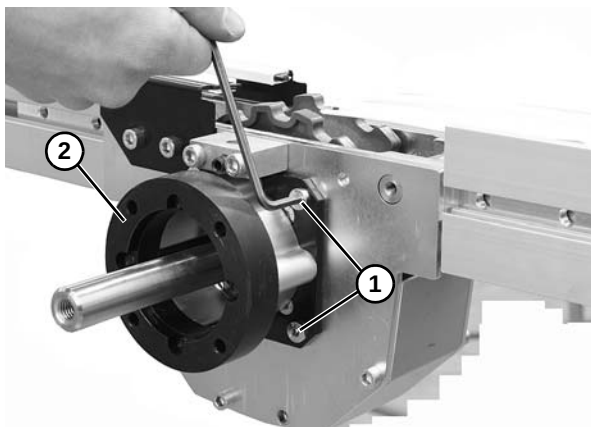


Figure 88

8. Loosen set screws (**Figure 89, item 1**) on both sides of conveyor.

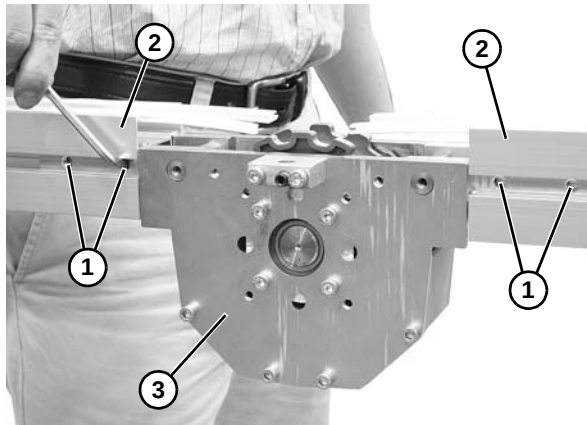


Figure 89

9. Separate conveyor halves (**Figure 89, item 2**) and remove drive assembly (**Figure 89, item 3**).
10. Remove four socket head screws (**Figure 90, item 1**).

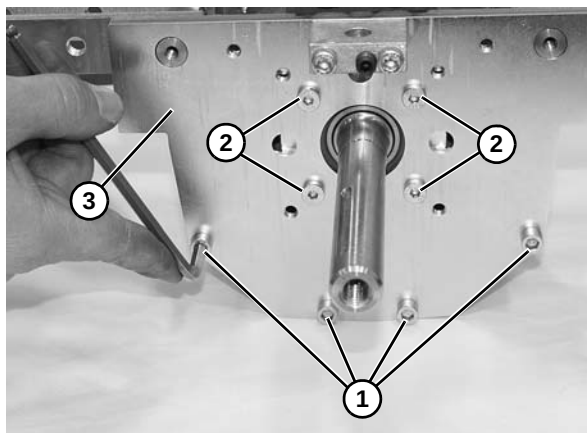


Figure 90

11. Remove four low head cap screws (**Figure 90, item 2**) and remove side plate (**Figure 90, item 3**).
12. Remove four low head cap screws securing spindle assembly to side plate on the opposite side.
13. Replace spindle assembly.

Preventive Maintenance and Adjustment

Curve Assembly

⚠ WARNING



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

1. Remove socket head screw (**Figure 91, item 1**) and socket head screw (**Figure 91, item 2**) from corner wheel assembly pinch bracket (**Figure 91, item 3**).

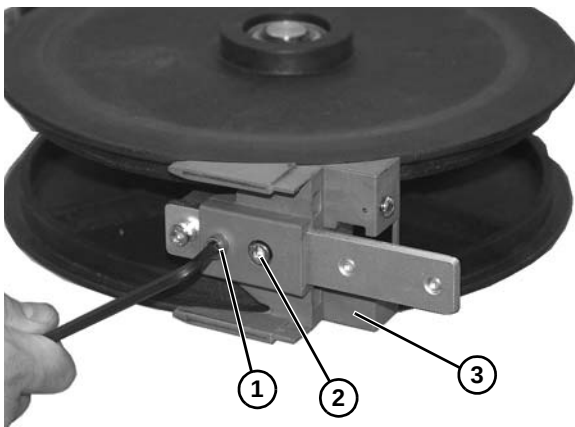


Figure 91

2. Install components reverse of removal.

Weighted Take-Up

1. Remove two socket head screws (**Figure 92, item 1**) on each side securing assembly to frame.

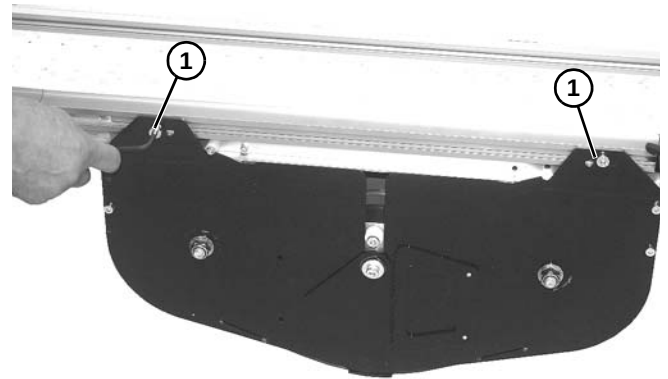


Figure 92

2. Lower weighted take up assembly (**Figure 93, item 1**) from conveyor (**Figure 93, item 2**) by disengaging locking teeth (**Figure 93, item 3**) on both sides.

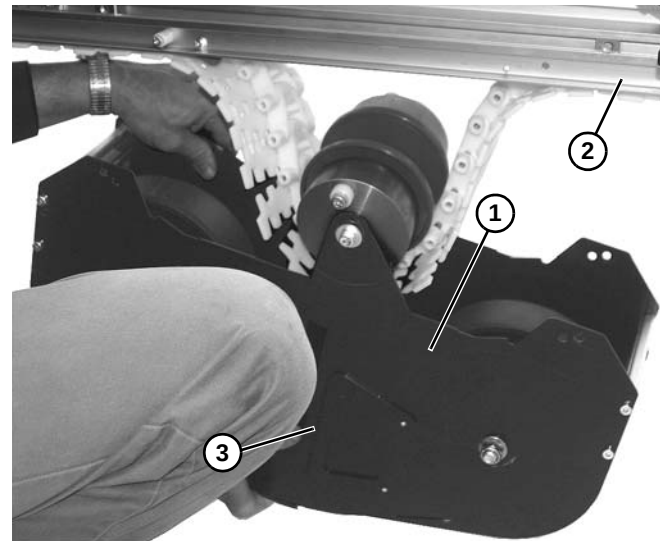


Figure 93

Preventive Maintenance and Adjustment

3. Use two wrenches to remove nut (**Figure 94, item 1**) on bolt securing wheel (**Figure 94, item 2**) onto weighted take up assembly housing (**Figure 94, item 3**).

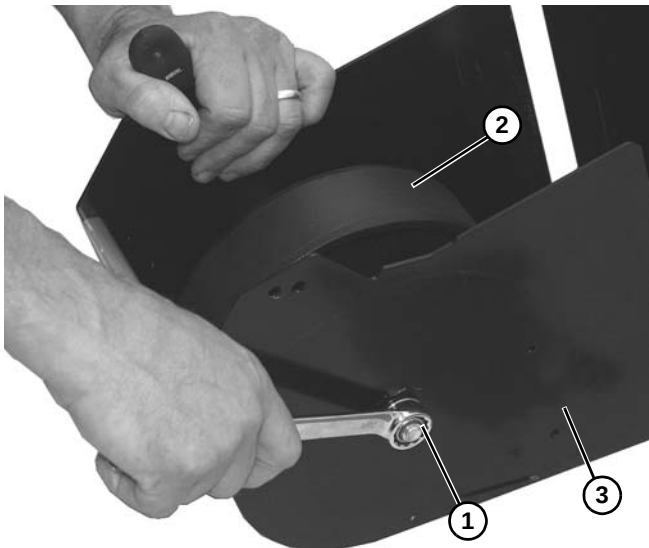


Figure 94

4. Remove bolt (**Figure 95, item 1**), washer (**Figure 95, item 2**), two spacers (**Figure 95, item 3**), and wheel (**Figure 95, item 4**) from take up assembly housing (**Figure 95, item 5**).

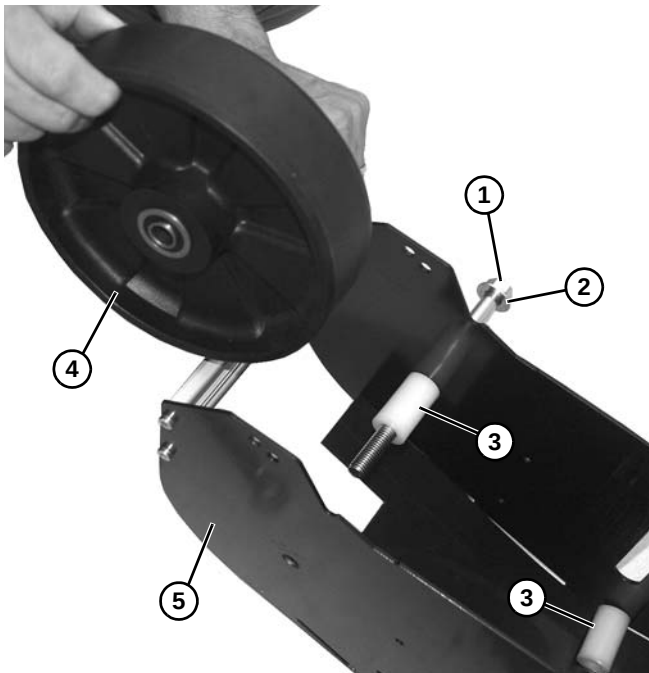


Figure 95

5. Remove idler pulley assembly (**Figure 96, item 1**) from belt (**Figure 96, item 2**).

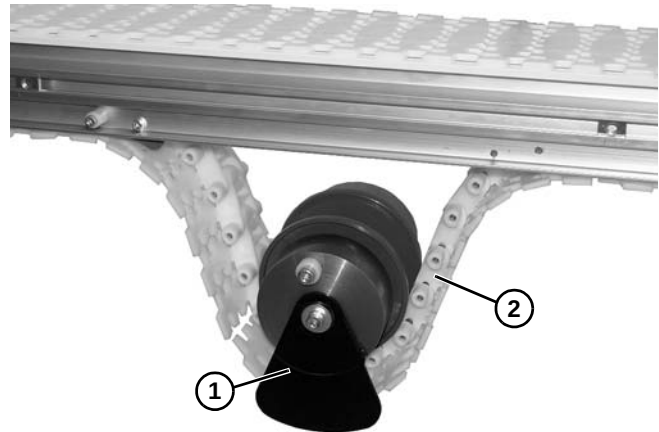


Figure 96

6. Remove socket head screw (**Figure 97, item 1**) from end of idler pulley assembly.

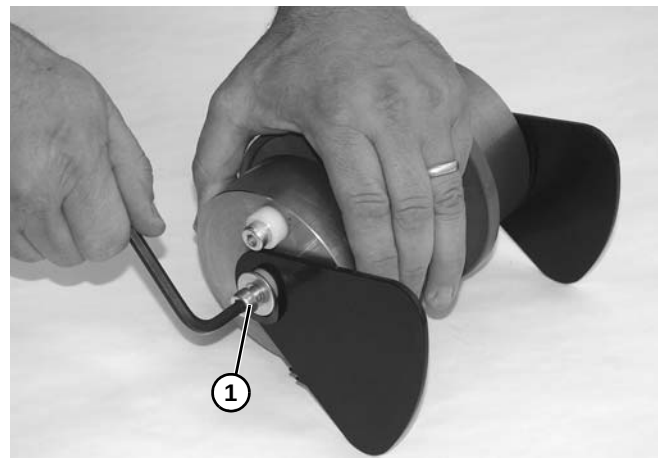


Figure 97

7. Remove bolt (**Figure 98, item 1**), washer (**Figure 98, item 2**), spacer (**Figure 98, item 3**), wave washer (**Figure 98, item 4**), and plate (**Figure 98, item 5**) from end of idler assembly (**Figure 98, item 6**).

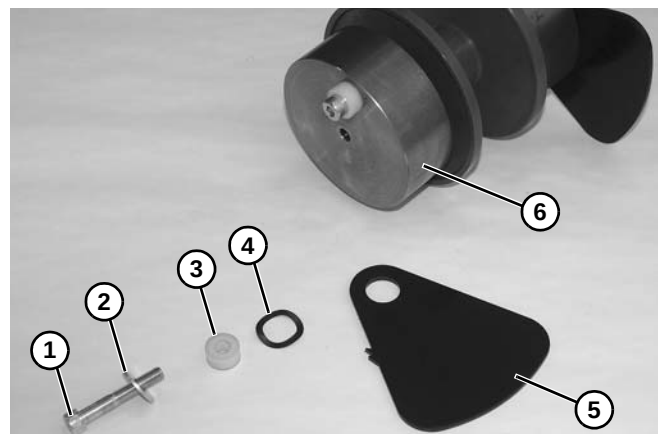


Figure 98

Preventive Maintenance and Adjustment

8. Repeat on opposite side.
9. Remove two weights (**Figure 99, item 1**) from each side of pulley (**Figure 99, item 2**).

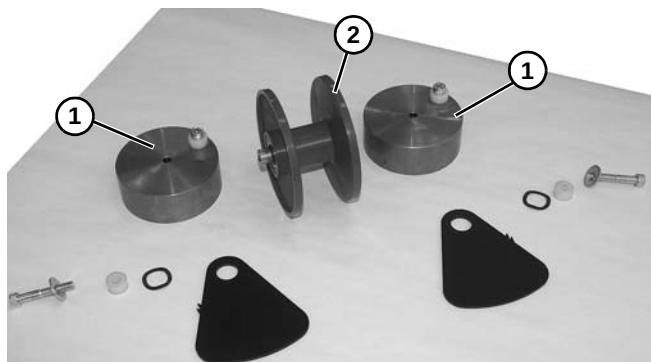


Figure 99

10. Install components reverse of removal, using two hex wrenches (**Figure 100, item 1**) on each side of idler assembly to tighten components.

NOTE

*Be certain that notches (**Figure 100, item 2**) on both plates are on top side, and spacers are in same orientation, as shown, before tightening components.*

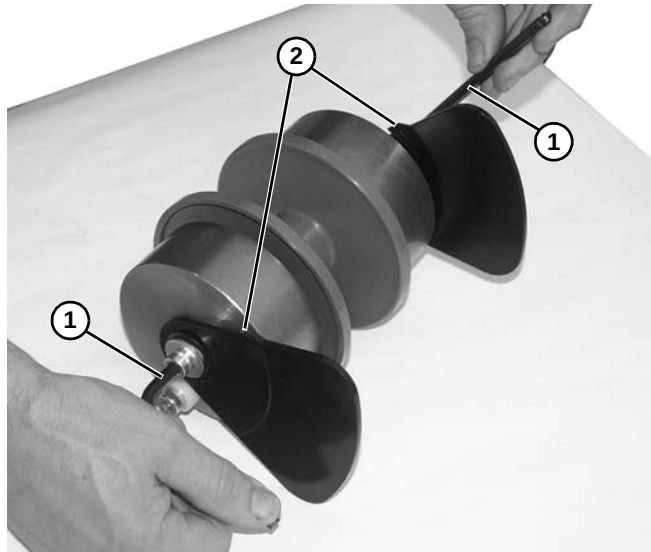


Figure 100

11. Install idler pulley assembly (**Figure 101, item 1**) onto weighted take up assembly (**Figure 101, item 2**).

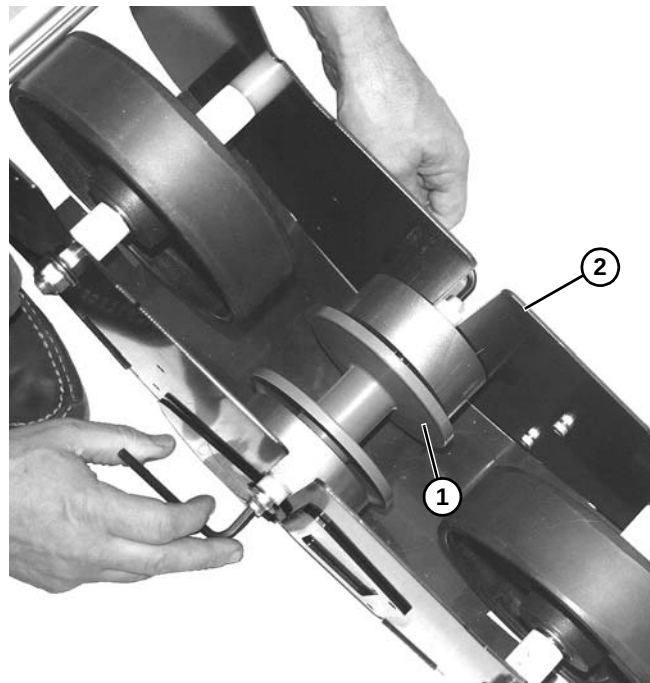


Figure 101

12. Install remaining components reverse of removal.

Preventive Maintenance and Adjustment

Power Transfer

Removal

1. Remove two hex head screws (**Figure 102, item 1**) and cover (**Figure 102, item 2**) from power transfer assembly.

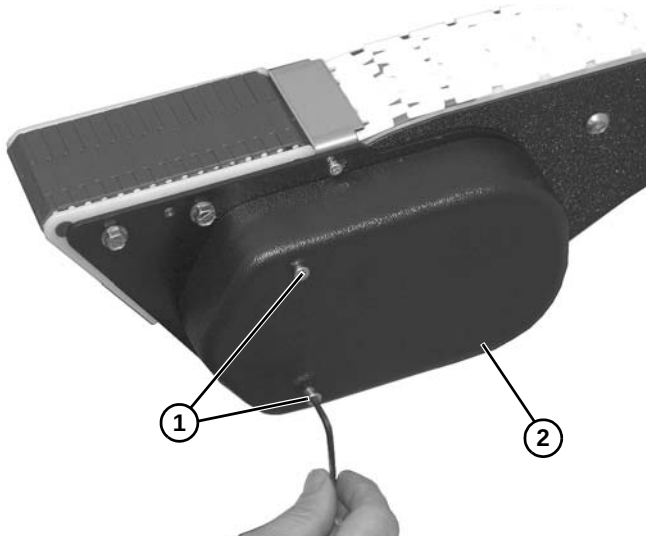


Figure 102

2. Loosen two socket head screws (**Figure 103, item 1**) holding tensioning pulley (**Figure 103, item 2**) onto timing belt (**Figure 103, item 3**).

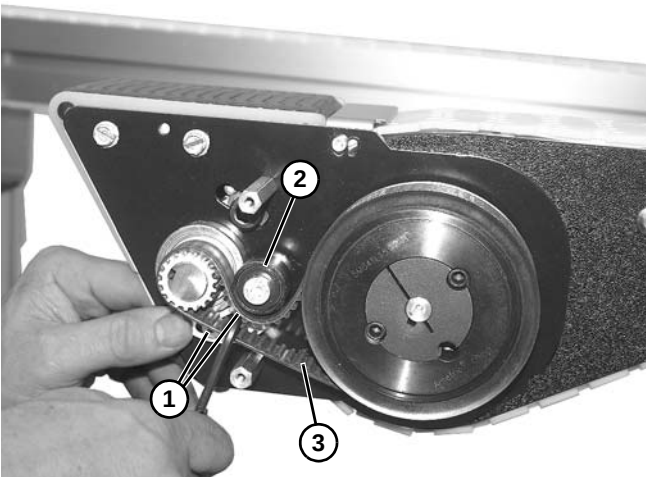


Figure 103

3. Remove timing belt (**Figure 103, item 3**) from assembly.

4. Loosen socket head screw (**Figure 104, item 1**) on both sides of the conveyor.

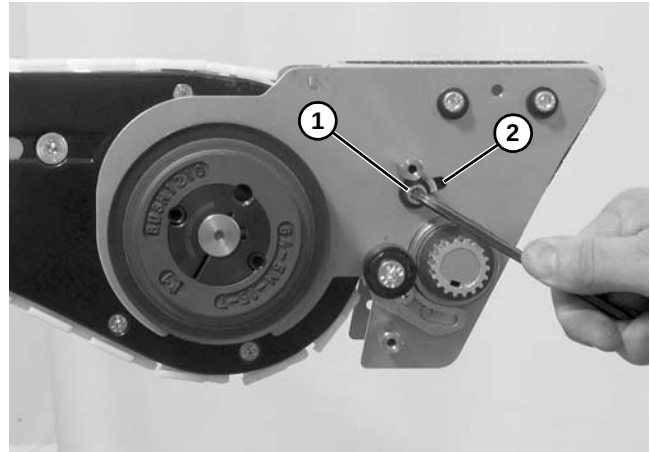


Figure 104

5. Slide idler assembly within slot (**Figure 104, item 2**) to remove tension on belt.
6. Remove two socket head screws (**Figure 105, item 1**) and tensioner plate (**Figure 105, item 2**).

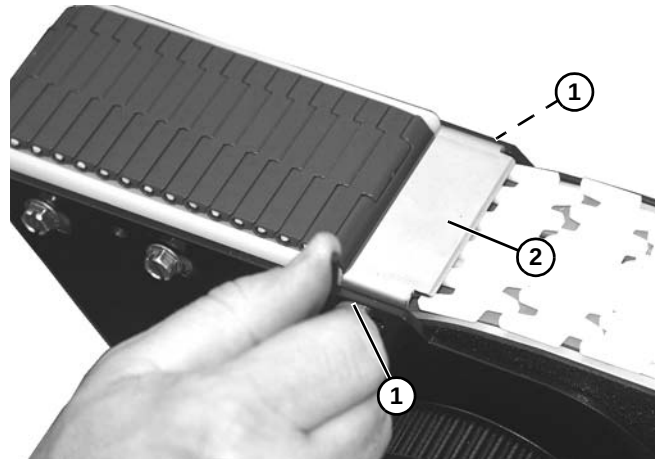


Figure 105

Preventive Maintenance and Adjustment

7. Lift slightly on belt (**Figure 106, item 1**) and push pin (**Figure 106, item 2**) out of belt.

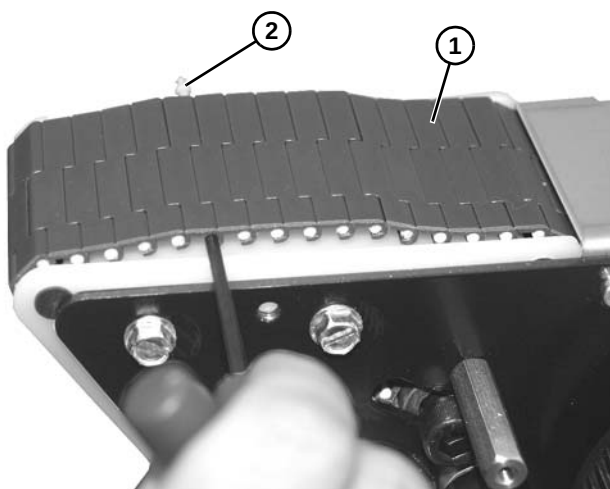


Figure 106

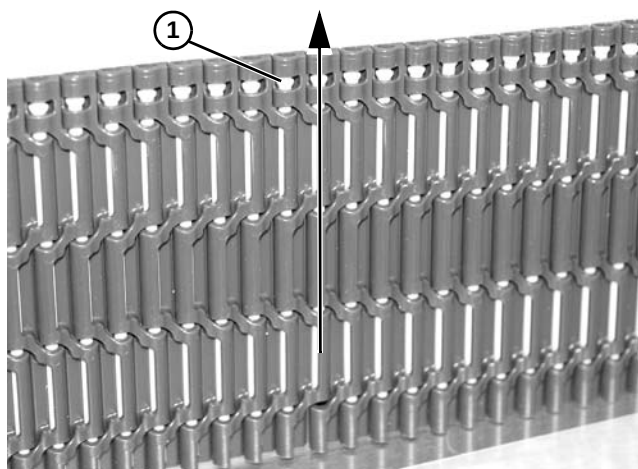


Figure 107

NOTE

Note that head of pin (**Figure 107, item 1**) should be removed in direction shown.

8. Remove belt.

9. Remove four socket head screws (**Figure 108, item 1**) holding wear bar assembly (**Figure 108, item 2**) onto power transfer.

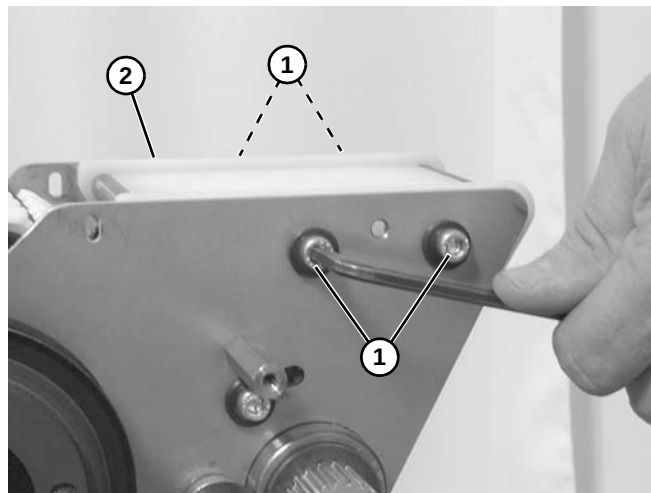


Figure 108

10. Remove wear bar assembly (**Figure 109, item 1**) from power transfer.

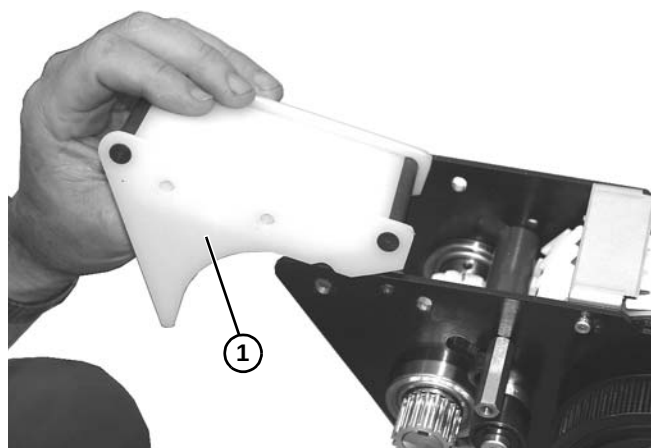


Figure 109

Preventive Maintenance and Adjustment

11. Disassemble side guide plates (**Figure 110, item 1**), wear rods (**Figure 110, item 2**), and wear bar (**Figure 110, item 3**). Replace worn components.

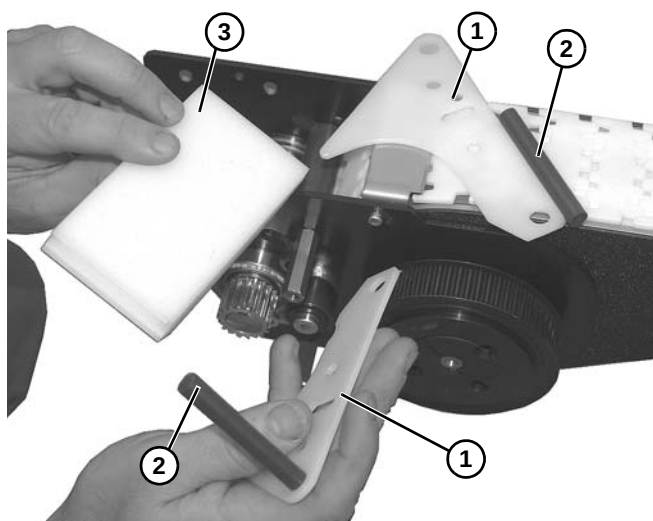


Figure 110

12. Remove socket head screw (**Figure 111, item 1**) on both sides of the conveyor and remove idler assembly.

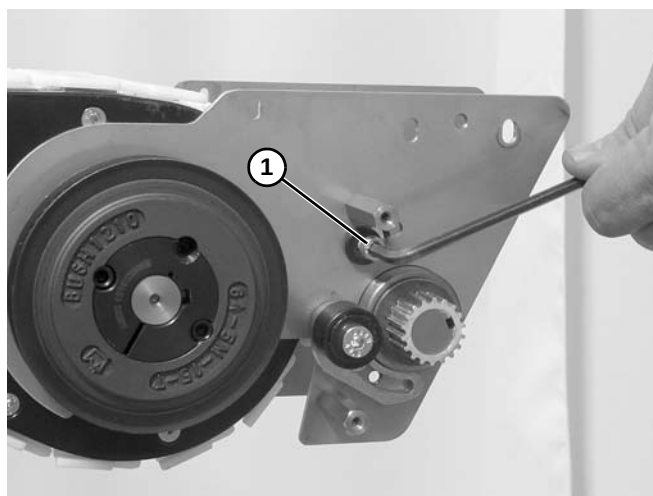


Figure 111

13. Replace idler assembly and install socket head screws to secure.

14. Loosen two set screws (**Figure 112, item 1**) on two bearings (**Figure 112, item 2**).

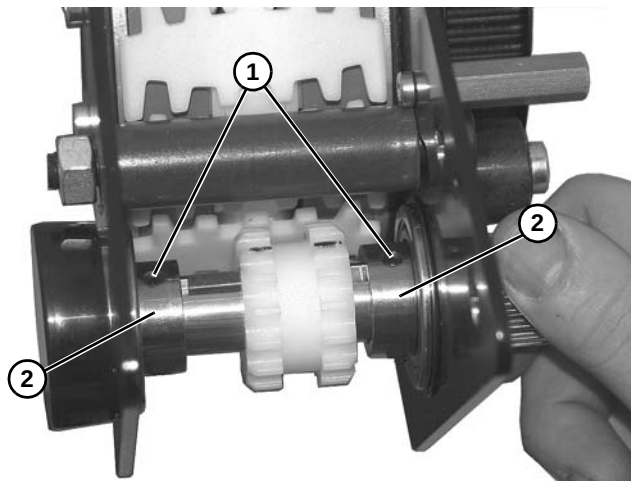


Figure 112

15. Remove drive shaft (**Figure 113, item 1**), making certain not to lose key (**Figure 113, item 2**) when removing gear (**Figure 113, item 3**).

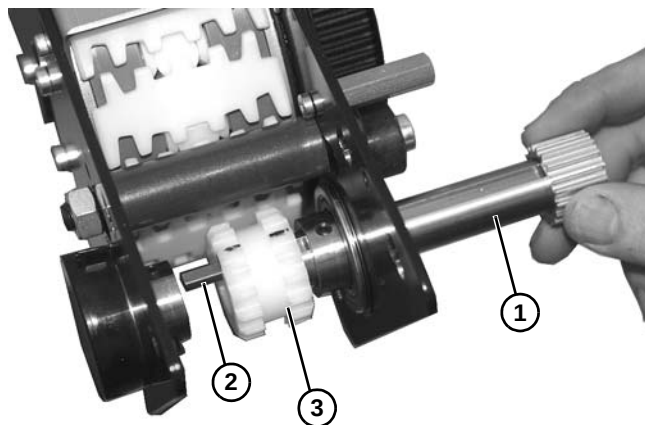


Figure 113

Preventive Maintenance and Adjustment

16. Remove key (**Figure 114, item 1**) from gear (**Figure 114, item 2**).

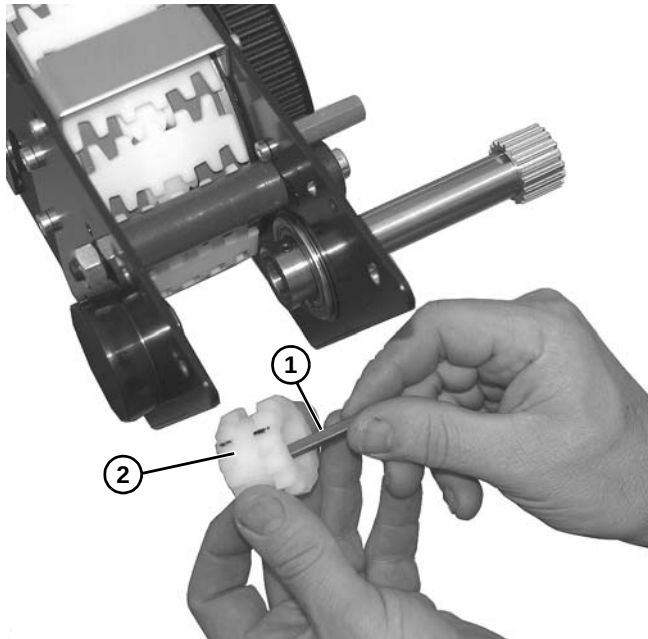


Figure 114

Installation

1. Install drive shaft (**Figure 115, item 1**) on two bearings (**Figure 115, item 2**) and press outward as shown.

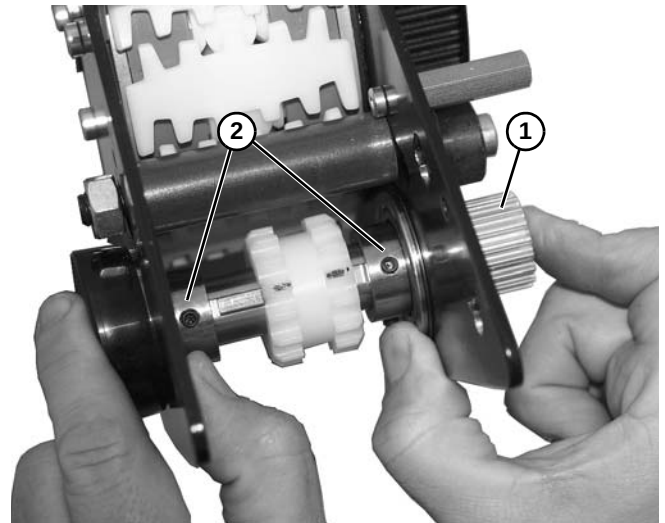


Figure 115

2. Secure drive shaft onto bearings with two set screws (**Figure 116, item 1**).

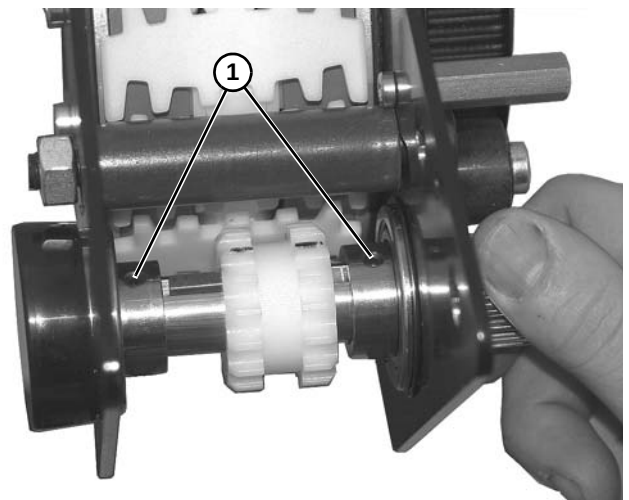


Figure 116

Preventive Maintenance and Adjustment

3. Raise belt (**Figure 117, item 1**) into position, and move gear (**Figure 117, item 2**) so that cogs line up with belt, as shown.

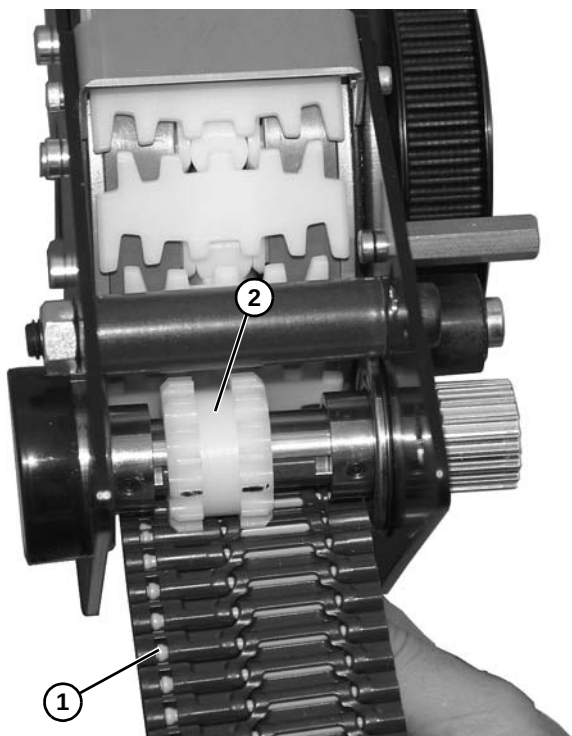


Figure 117

4. Install wear bar assembly (**Figure 118, item 1**) with four socket head screws (**Figure 118, item 2**).

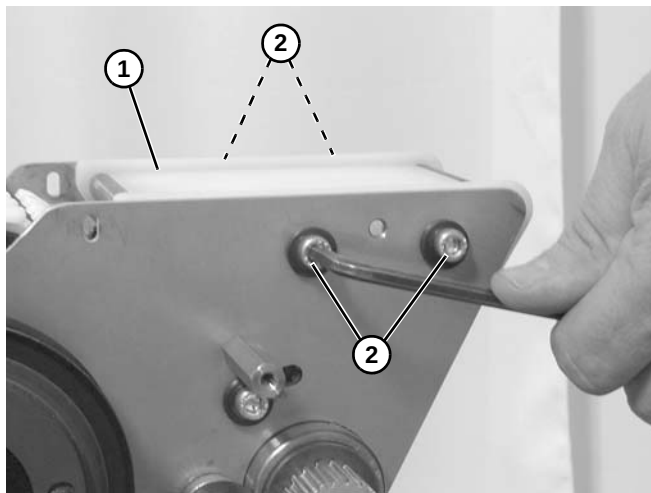


Figure 118

5. Guide belt (**Figure 119, item 1**) through idler assembly with belt routing under gear (**Figure 119, item 2**) and over wear tube (**Figure 119, item 3**).

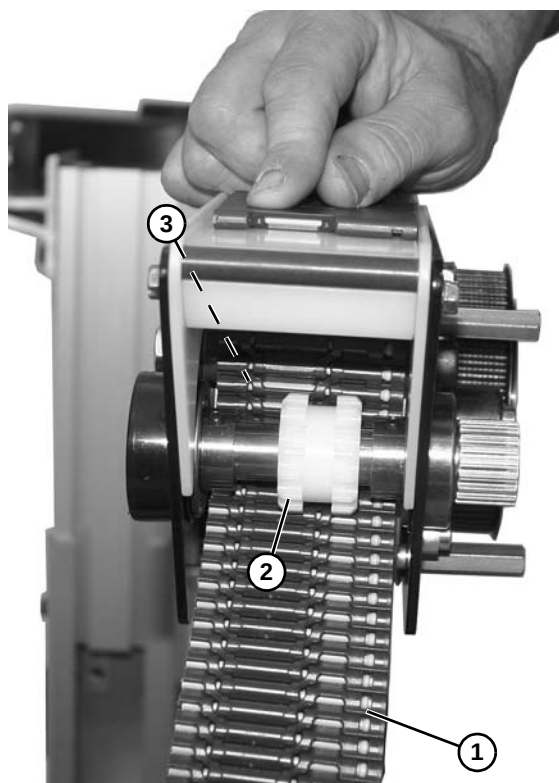


Figure 119

6. Bring ends of belt together and install pin (**Figure 120, item 1**).

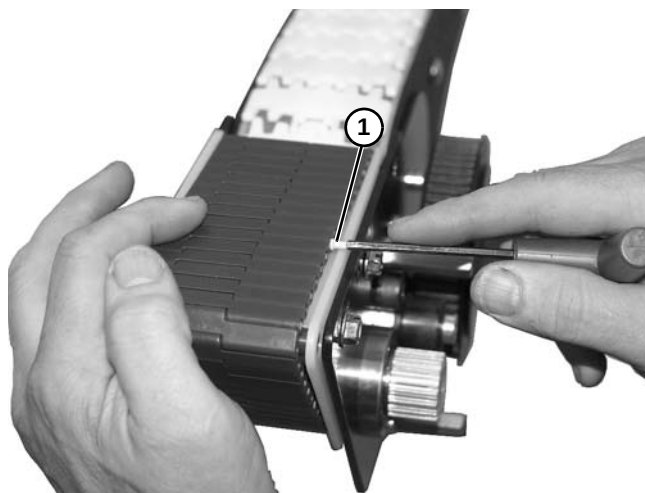


Figure 120

Preventive Maintenance and Adjustment

7. Install tensioner plate (Figure 121, item 1) with two socket head screws (Figure 121, item 2).

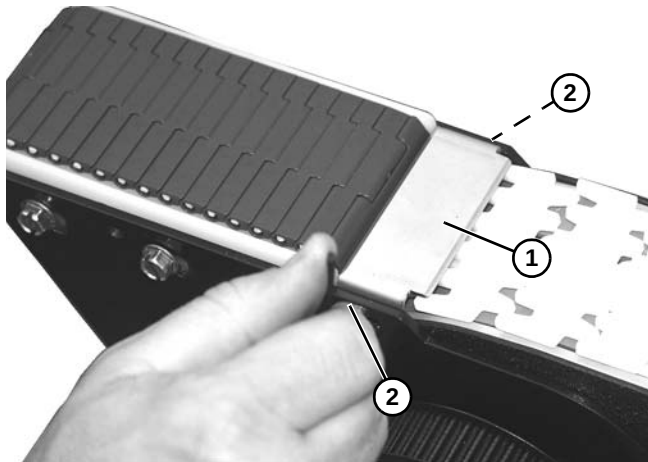


Figure 121

8. Slide idler assembly within slot (Figure 122, item 1) to remove excess slack from belt (Figure 122, item 2). Tighten socket head screws (Figure 122, item 3).

⚠ CAUTION
DO NOT overtighten belt or excessive wear will occur.

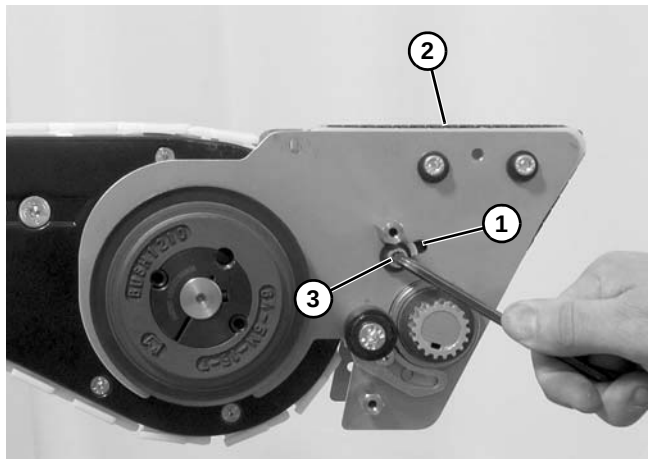


Figure 122

9. Rotate drive shaft (Figure 123, item 1) to verify tightness of belt (Figure 123, item 2). Belt should turn freely. Loosen socket head screw (Figure 123, item 3) and adjust, if necessary.

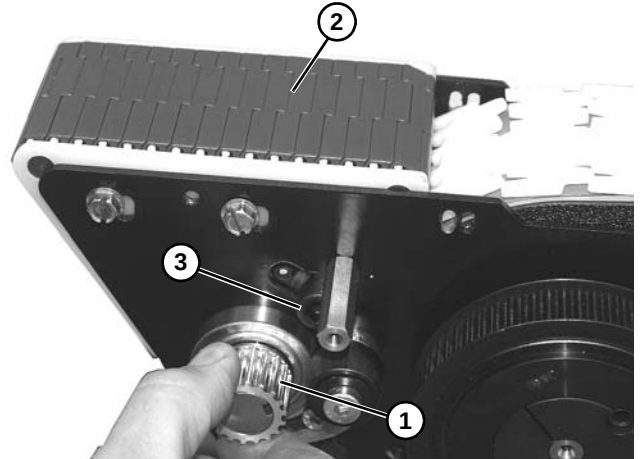


Figure 123

10. Install timing belt:

- On idler end, route and install belt (Figure 125, item 1) as shown. Press up on tensioner (Figure 125, item 2) and tighten two hex head screws (Figure 125, item 3).

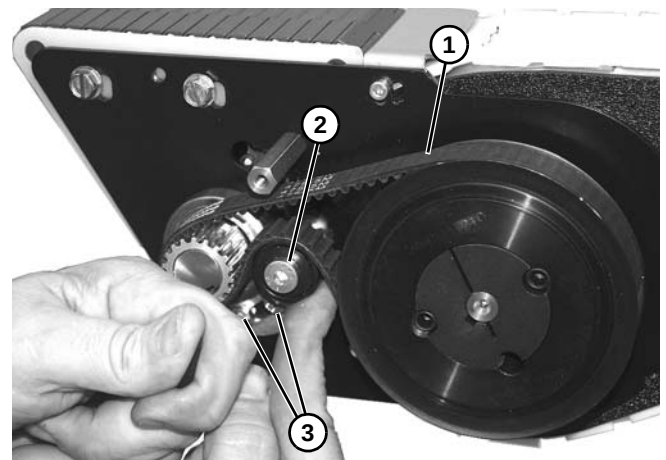


Figure 124

- On drive end, route and install belt (Figure 126, item 1) as shown. Press down on tensioner (Figure 126, item 2) and tighten two hex head screws (Figure 126, item 3)

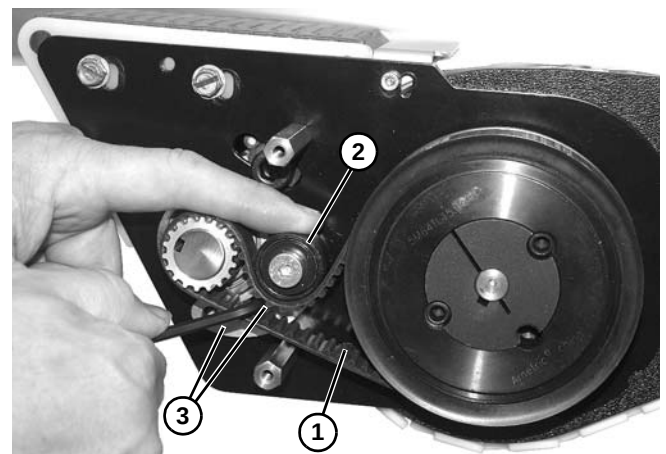


Figure 125

Preventive Maintenance and Adjustment

11. Install cover (**Figure 126, item 1**) with two hex head screws (**Figure 126, item 2**).

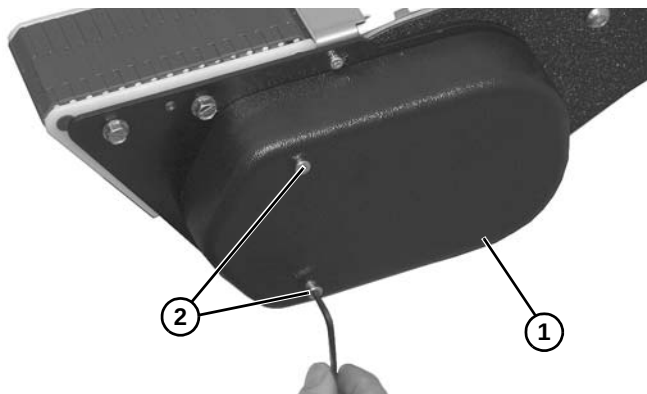


Figure 126

Roller Transfer

1. Remove two hex head screws (**Figure 127, item 1**) on each side of conveyor, and remove roller transfer assembly (**Figure 127, item 2**) from conveyor.



Figure 127

2. Remove nuts (**Figure 128, item 1**), washers (**Figure 128, item 2**), and roller transfer (**Figure 128, item 3**) from support bracket (**Figure 128, item 4**).

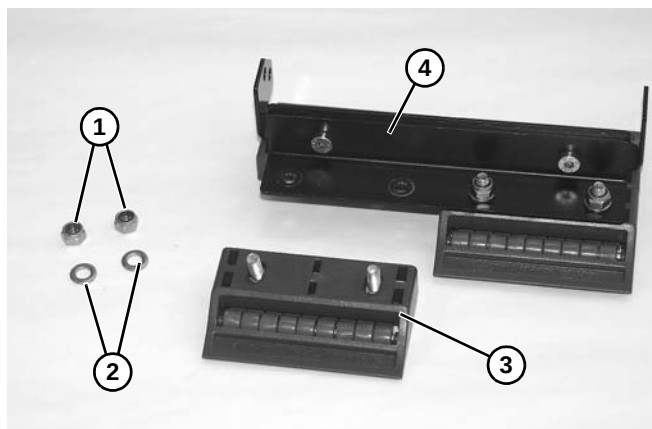


Figure 128

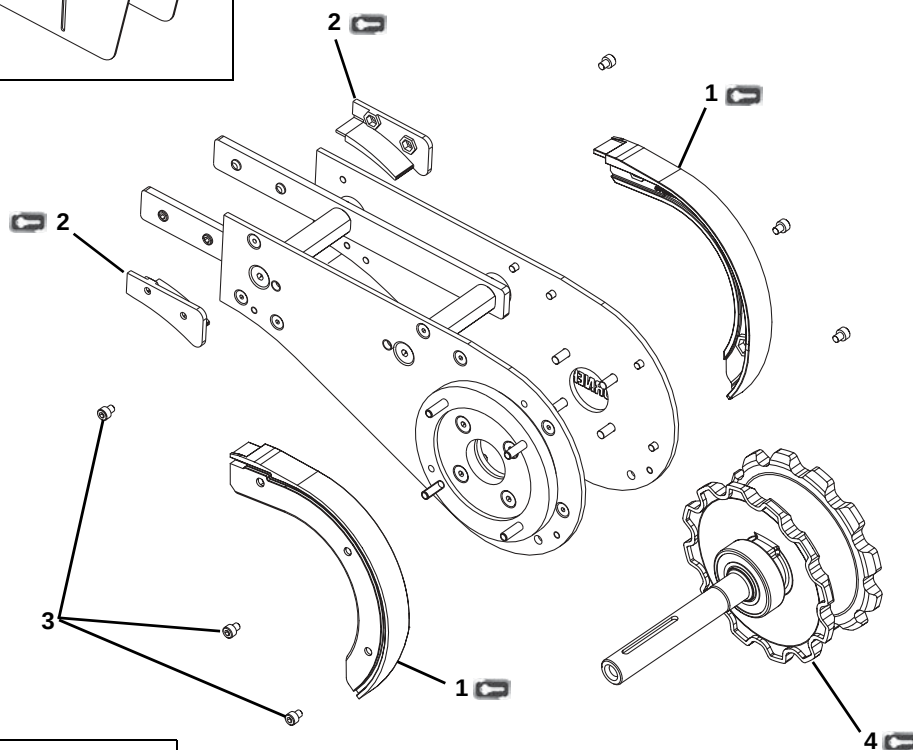
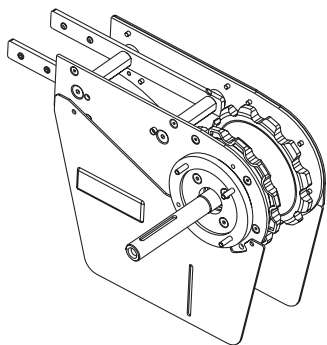
Service Parts

NOTE

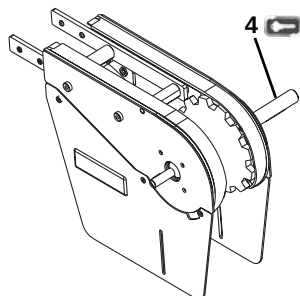
For replacement parts other than those shown in this section, contact an authorized Dorner Service Center or the factory. Key Service Parts and Kits are identified by the Performance Parts Kits logo . Dorner recommends keeping these parts on hand.

Drive Tail

5 Drive Tail Kit



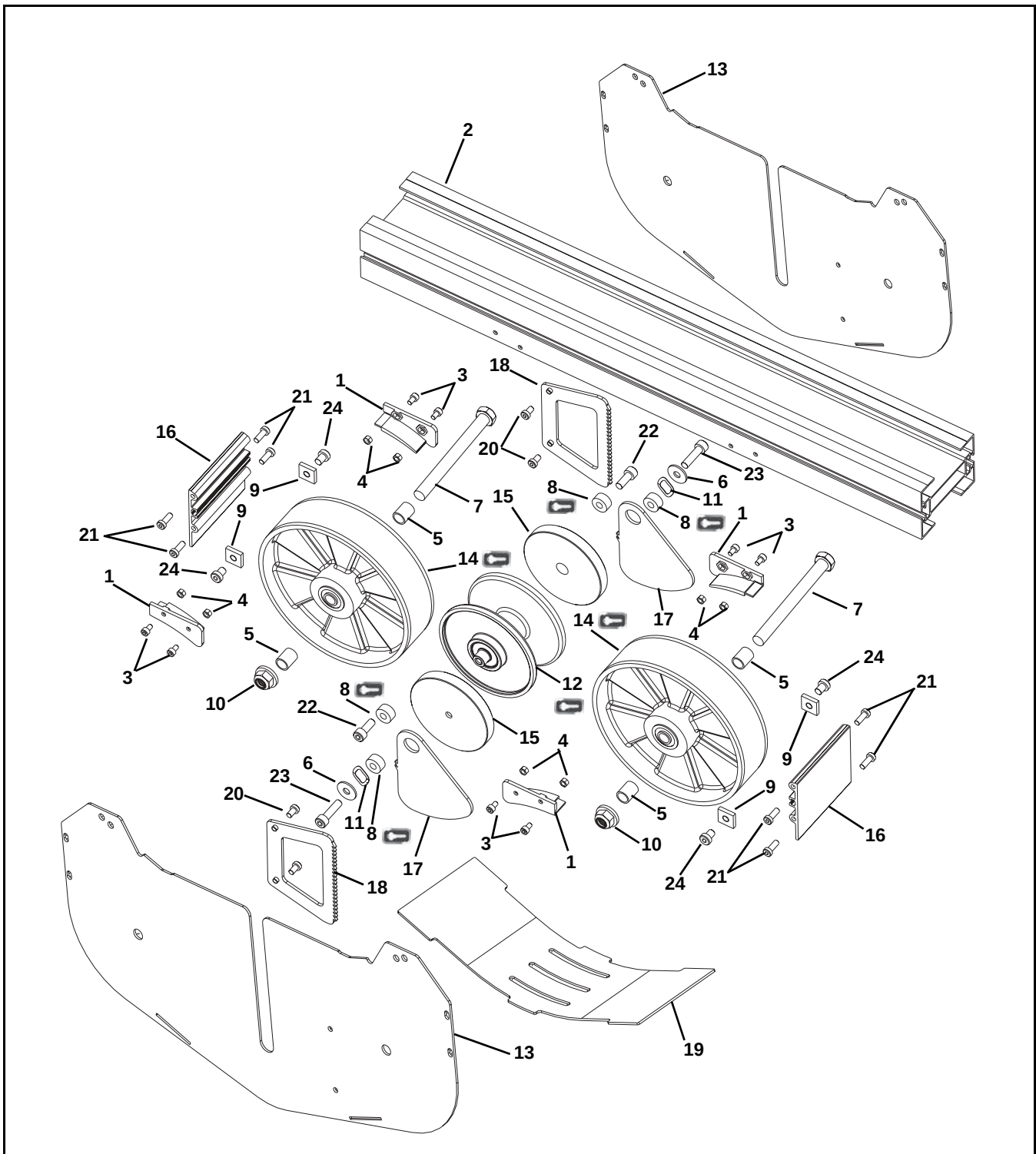
Optional Auxiliary Shaft Shown



Item	Part Number	Description
1 	834-FSD63101-A	Retaining Guide Set for 65 width Conveyors
	834-FMD83101-A	Retaining Guide Set for 85 width Conveyors
	834-FCD103101-A	Retaining Guide Set for 105 & 150 width Conveyors
2 	834-FSD63102-A	Belt Capture Guide Set for 65 width Conveyors
	834-FMD83102-A	Belt Capture Guide Set for 85 width Conveyors
	834-FCD103102-A	Belt Capture Guide Set for 105 & 150 width Conveyors
3	920506M	Socket Head Screw, M5-.80 x 6 mm
4 	205700-EN- <u>WWW</u>	Standard Load Spindle Shaft Assembly
	205700-CN- <u>WWW</u>	CE Spindle Shaft Assembly
	205700-EA- <u>WWW</u>	Standard Load Spindle Shaft Assembly with Auxiliary Shaft
	205700-CA- <u>WWW</u>	CE Spindle Shaft Assembly with Auxiliary Shaft
	205700-HN- <u>WWW</u>	Heavy Load Spindle Shaft Assembly
	205700-HA- <u>WWW</u>	Heavy Load Spindle Shaft Assembly with Auxiliary Shaft
5	205750- <u>WWW</u> -EN	Standard Load Drive Tail Kit with Shaft in the 'A' Position
	205750- <u>WWW</u> -NE	Standard Load Drive Tail Kit with Shaft in the 'D' Position
	205750- <u>WWW</u> -CN	CE Drive Tail Kit with Shaft in the 'A' Position
	205750- <u>WWW</u> -NC	CE Drive Tail Kit with Shaft in the 'D' Position
	205750- <u>WWW</u> -HN	Heavy Load Drive Tail Kit with Shaft in the 'A' Position
	205750- <u>WWW</u> -NH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position
	205750- <u>WWW</u> -EA	Standard Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AE	Standard Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750- <u>WWW</u> -CA	CE Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AC	CE Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750- <u>WWW</u> -HA	Heavy Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AA	Drive Tail Kit with two Auxiliary Shafts
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		

Service Parts

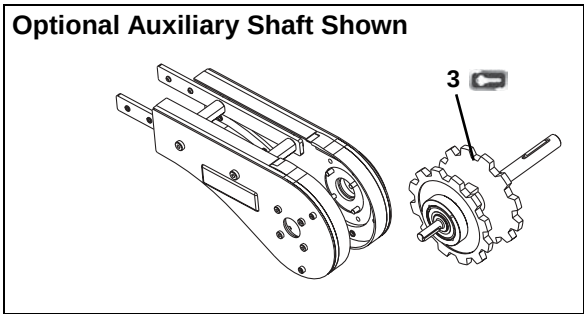
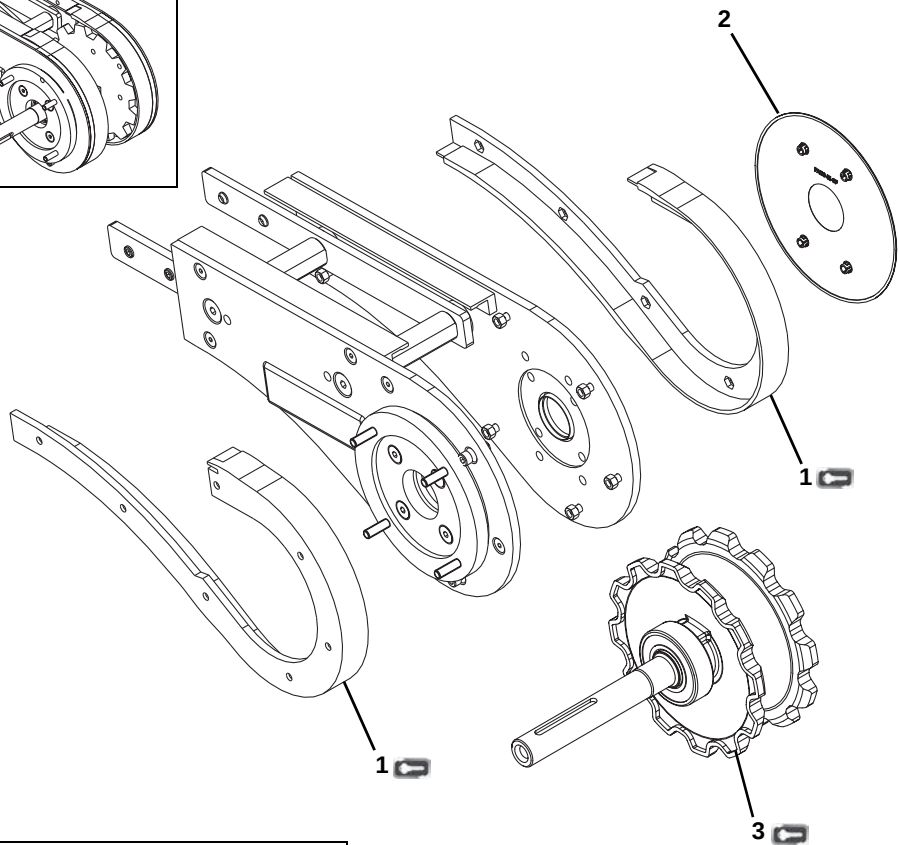
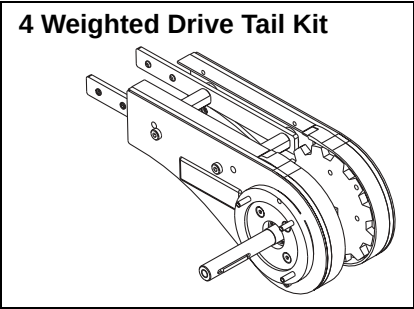
Weighted Take-Up



Item	Part Number	Description
1	834-FSD63102-1	Belt Capture Guide Set, for 65 width Conveyors
	834-FMD83102-1	Belt Capture Guide Set, for 85 width Conveyors
	834-FCD103102-1	Belt Capture Guide Set, for 105 & 150 width Conveyors
2	203345- <u>WWW</u> - <u>LLL</u>	Conveyor Section
3	920516M	Socket Head Screw, M5-.80 x 16 mm
4	990501M	Hex Nut, M5-0.80
5	203455	Bushing, 0.50" x 0.75" for 105 width Conveyors
	203456	Bushing 0.50" x 1.125" for 150 width Conveyors
6	807-1760	Washer
7	807-2290	Hex Bolt, 1/2-13 x 3.5" for 65 width Conveyors
	807-3092	Hex Bolt, 1/2-13 x 4.5" for 85 width Conveyors
	807-2291	Hex Bolt, 1/2-13 x 5" for 105 width Conveyors
	807-2292	Hex Bolt, 1/2-13 x 7" for 150 width Conveyors
8 	807-2297	Nylon Spacer, 0.75" x 0.32" x 0.375"
9	834-014	Slide Nut
10	910-320	Lock Nut
11	807-2314	Spring Washer
12 	834-FSIM-15	Idler Pulley Assembly for 65 width Conveyors
	834-FMIM-15	Idler Pulley Assembly for 85 width Conveyors
	834-FCIM-15	Idler Pulley Assembly for 105 width Conveyors
	834-FLIM-15	Idler Pulley Assembly for 150 width Conveyors
13	203330	Weighted Take-Up Plate
14 	203331	Wheel (Standard Belt)
	201759	Wheel (Friction Top Belt)
15	203343	Weighted Take-Up Disk for 65, 85 & 105 width Conveyors
	203363	Weighted Take-Up Disk for 150 width Conveyors
16	203344- <u>WWW</u>	End Guard
17	203349	Latching Cover
18	203351	Ratchet Plate
19	203457- <u>WWW</u>	Bottom Guard
20	950610M	Low Head Cap Screw, M6-1.00 x 10 mm
21	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
22	920820M	Socket Head Cap Screw, M8-125 x 20 mm
23	920830M	Socket Head Cap Screw, M8-125 x 30 mm for 65 & 105 width Conveyors
	920850M	Socket Head Cap Screw, M8-125 x 50 mm for 150 width Conveyors
24	950810M	Low Head Cap Screw, M8-1.25 x 10 mm
<u>WWW</u> = Conveyor width reference: 065, 85, 105, 150		
<u>LLL</u> = Conveyor frame section in inches: 029, 035, 047, 059		
Length Example: Length = 29" LLL = 029		

Service Parts

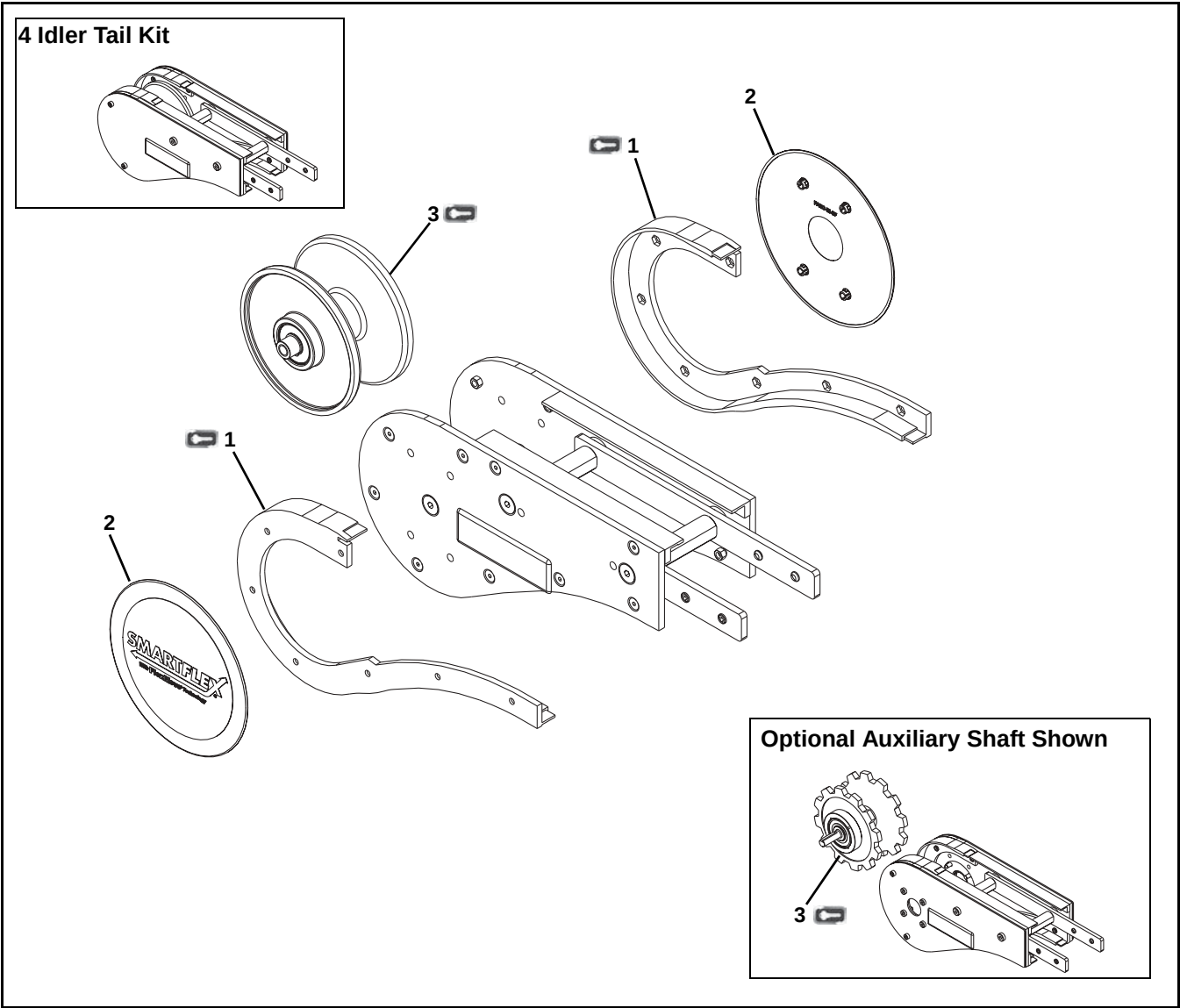
Weighted Take-Up Drive Tail



Item	Part Number	Description
1 	834-FSE63001-A	Retaining Guide Set for 65 width Conveyors
	834-FME83001-A	Retaining Guide Set for 085 width Conveyors
	834-FCE103001-A	Retaining Guide Set for 105 width Conveyors
	834-FCE103001-1	Retaining Guide Set for 150 width Conveyors
2	834-FAEC-IE-SF	Idler Tail Cover
3 	205700-EN- <u>WWW</u>	Standard Load Spindle Shaft Assembly
	205700-CN- <u>WWW</u>	CE Spindle Shaft Assembly
	205700-EA- <u>WWW</u>	Standard Load Spindle Shaft Assembly with Auxiliary Shaft
	205700-CA- <u>WWW</u>	CE Spindle Shaft Assembly with Auxiliary Shaft
	205700-HN- <u>WWW</u>	Heavy Load Spindle Shaft Assembly
	205700-HA- <u>WWW</u>	Heavy Load Spindle Shaft Assembly with Auxiliary Shaft
4	205750- <u>WWW</u> -EN	Standard Load Drive Tail Kit with Shaft in the 'A' Position
	205750- <u>WWW</u> -NE	Standard Load Drive Tail Kit with Shaft in the 'D' Position
	205750- <u>WWW</u> -CN	CE Drive Tail Kit with Shaft in the 'A' Position
	205750- <u>WWW</u> -NC	CE Drive Tail Kit with Shaft in the 'D' Position
	205750- <u>WWW</u> -HN	Heavy Load Drive Tail Kit with Shaft in the 'A' Position
	205750- <u>WWW</u> -NH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position
	205750- <u>WWW</u> -EA	Standard Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AE	Standard Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750- <u>WWW</u> -CA	CE Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AC	CE Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750- <u>WWW</u> -HA	Heavy Load Drive Tail Kit with Shaft in the 'A' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AH	Heavy Load Drive Tail Kit with Shaft in the 'D' Position and Auxiliary Shaft
	205750- <u>WWW</u> -AA	Drive Tail Kit with two Auxiliary Shafts
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		

Service Parts

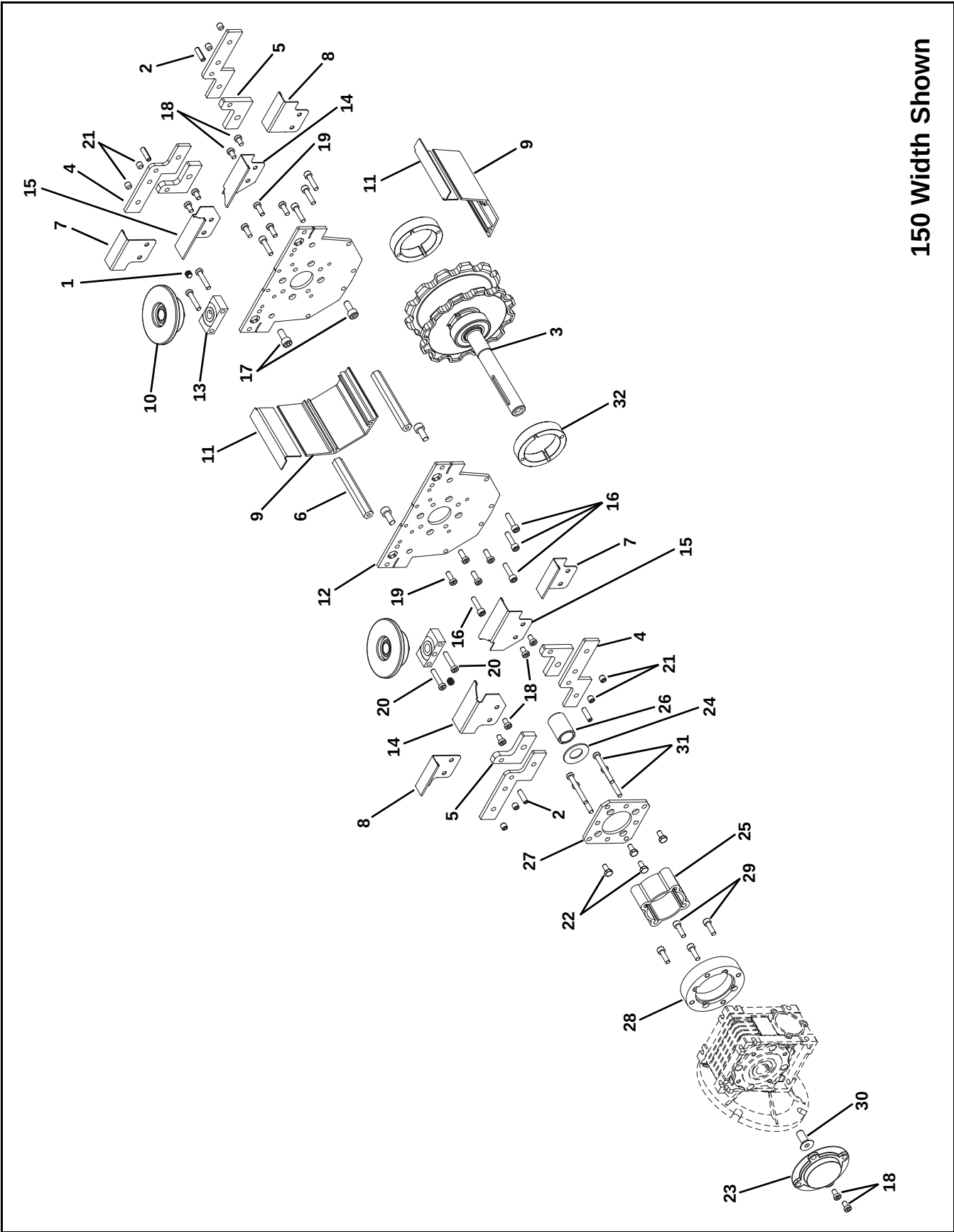
Idler Tail



Item	Part Number	Description
1 	834-FSE63001-A	Retaining Guide Set for 65 width Conveyors
	834-FME83001-A	Retaining Guide Set for 085 width Conveyors
	834-FCE103001-A	Retaining Guide Set for 105 width Conveyors
	834-FCE103001-1	Retaining Guide Set for 150 width Conveyors
2	834-FAEC-IE-SF	Idler Tail Cover
3 	834-FSIM-15	Idler Pulley Assembly for 65 width Conveyors
	834-FMIM-15	Idler Pulley Assembly for 85 width Conveyors
	834-FCIM-15	Idler Pulley Assembly for 105 width Conveyors
	834-FLIM-15	Idler Pulley Assembly for 150 width Conveyors
	205700-AN- <u>WWW</u>	Idler Pulley Assembly with Auxiliary Shaft
4	205749- <u>WWW</u> -NN	Idler Tail Kit
	205749- <u>WWW</u> -AN	Idler Tail Kit with Auxiliary Shaft in the 'A' Position
	205749- <u>WWW</u> -NA	Idler Tail Kit with Auxiliary Shaft in the 'D' Position
	205749- <u>WWW</u> -AA	Idler Tail Kit with two Auxiliary Shafts
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		

Service Parts

Top Running Drive



150 Width Shown

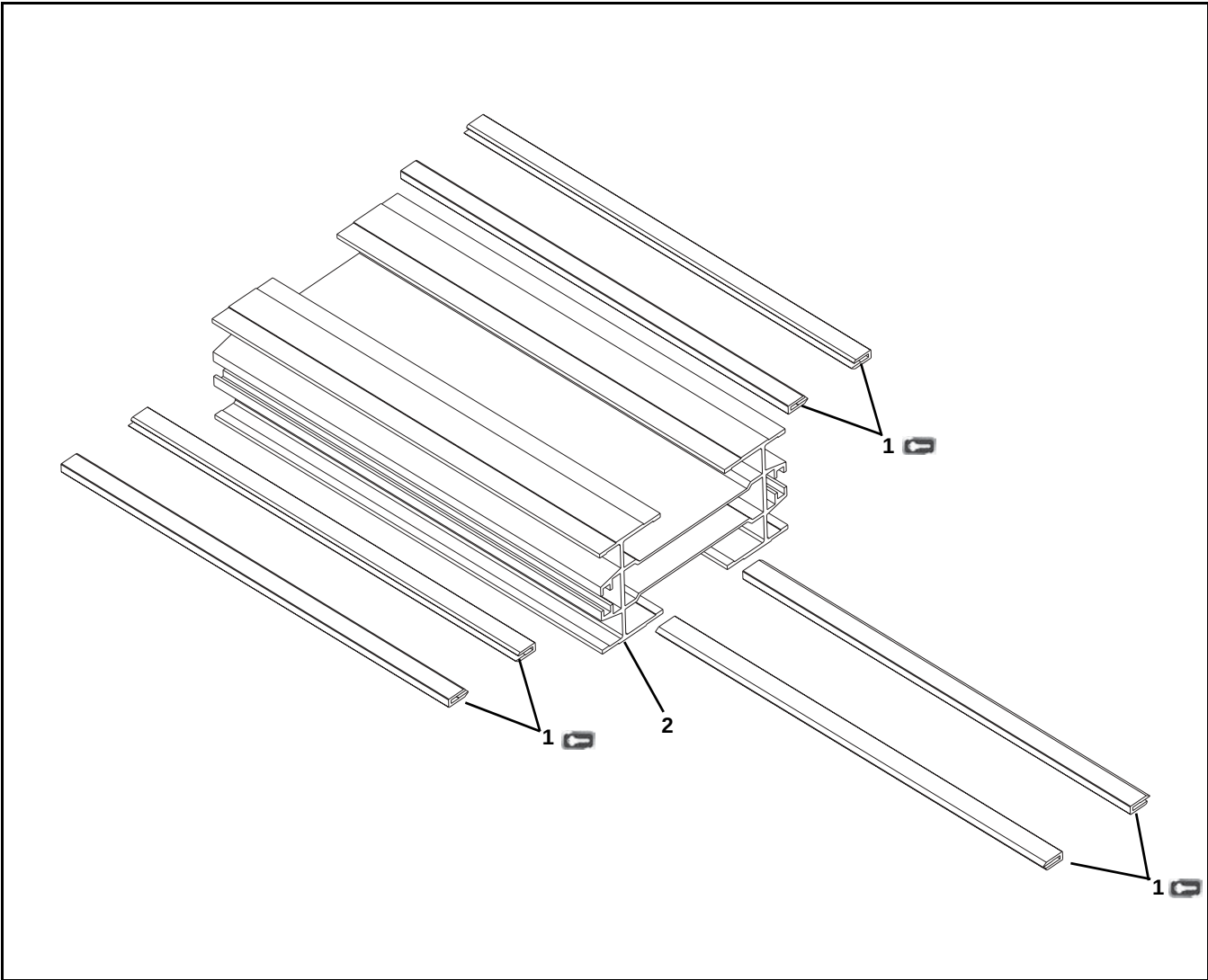
Service Parts

Item	Part Number	Description
1	807-2555	Set Screw, M8-1.25 x 10 mm
2	913-051	Pin for 065 width Conveyors
	913-509	Pin for 150 width Conveyors
3	834-FSDD-A65DL-314	Spindle Assembly for 065 width Conveyors
	834-FMDD-A85DL-314	Spindle Assembly for 085 width Conveyors
	834-FCDD-A105DL-314	Spindle Assembly for 105 width Conveyors
	834-FLDD-A150DL-314	Spindle Assembly for 150 width Conveyors
4	205140	Connecting Bar for 065 width Conveyors
	205142	Connecting Bar for 085 & 105 width Conveyors
	204290	Connecting Bar for 150 width Conveyors
5	205141	Spacing Bar for 065 width Conveyors Only
	204291	Spacing Bar for 150 width Conveyors Only
6	205147	Hex Post for 065 width Conveyors
	206266	Hex Post for 085 width Conveyors
	205116	Hex Post for 105 width Conveyors
	204292	Hex Post for 150 width Conveyors
7	204293-LH	Wear Strip Support Left Hand for 150 width Conveyors Only
8	204293-RH	Wear Strip Support Right Hand for 150 width Conveyors Only
9	205125	Extrusion Guard for 065 width Conveyors
	206269	Extrusion Guard for 085 width Conveyors
	204380	Extrusion Guard for 105 & 150 width Conveyors
10	204379	Hold Down Assembly for 065 width Conveyors
	206283	Hold Down Assembly for 085 width Conveyors
	204381	Hold Down Assembly for 105 & 150 width Conveyors
11	204790	Pinch Guard for 065 width Conveyors
	206270	Pinch Guard for 085 width Conveyors
	204791	Pinch Guard for 105 & 150 width Conveyors
12	205115	Side Plate
13	205134	Wheel Block
14	205139-LH	Wear Strip Support Left Hand for 065 width Conveyors
	206267-LH	Wear Strip Support Left Hand for 085 width Conveyors
	205137-LH	Wear Strip Support Left Hand for 105 & 150 width Conveyors

Item	Part Number	Description
15	205139-RH	Wear Strip Support Right Hand for 065 width Conveyors
	206268-RH	Wear Strip Support Right Hand for 085 width Conveyors
	205137-RH	Wear Strip Support Right Hand for 105 & 150 width Conveyors
16	708180P	Trilobe Screw, M6-1.00 x 25 mm
17	920818M	Socket Head Screw, M8-1.25 x 18 mm for 150 width Conveyors Only
18	950610M	Low Head Cap Screw, M6-1.00 x 10 mm
19	950616M	Low Head Cap Screw, M6-1.00 x 16 mm
20	950630M	Low Head Cap Screw, M6-1.00 x 30 mm
21	970808M	Set Screw, M8-1.25 x 10 mm
22	960612MSS	Hex Head Cap Screw, M6-1.00 x 12 mm
23	807-2016	Cover
24	807-2277	Disc Spring
25	202270-00134	Extrusion for 065 & 105 width Conveyors
	202270-00223	Extrusion for 150 width Conveyors
26	203065	Drive Spacer
27	205132	Motor Mount
28	350115	Adapter Ring
29	920620M	Socket Head Screw, M6-1.00 x 20 mm
30	931025M	Flat Head Screw, M10-.50 x 25 mm
31	950650M	Low Head Cap Screw, M6-1.00 x 50 mm
32	834-B6005-C70-T12	Bearing Retainer for 065 width Conveyors
	834-B6205-C70-T15	Bearing Retainer for 085, 105 & 150 width Conveyors
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		

Service Parts

Frame Assembly



Item	Part Number	Description
1 	See Wear Strip Section	Wear Strips
2	834-FSCB-3- <u>LLLL</u>	Frame for 65 width Conveyors
	834-FMCB-3- <u>LLLL</u>	Frame for 85 width Conveyors
	834-FCCB-3- <u>LLLL</u>	Frame for 105 width Conveyors
	834-FLCB-3- <u>LLLL</u>	Frame for 150 width Conveyors
<u>LLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

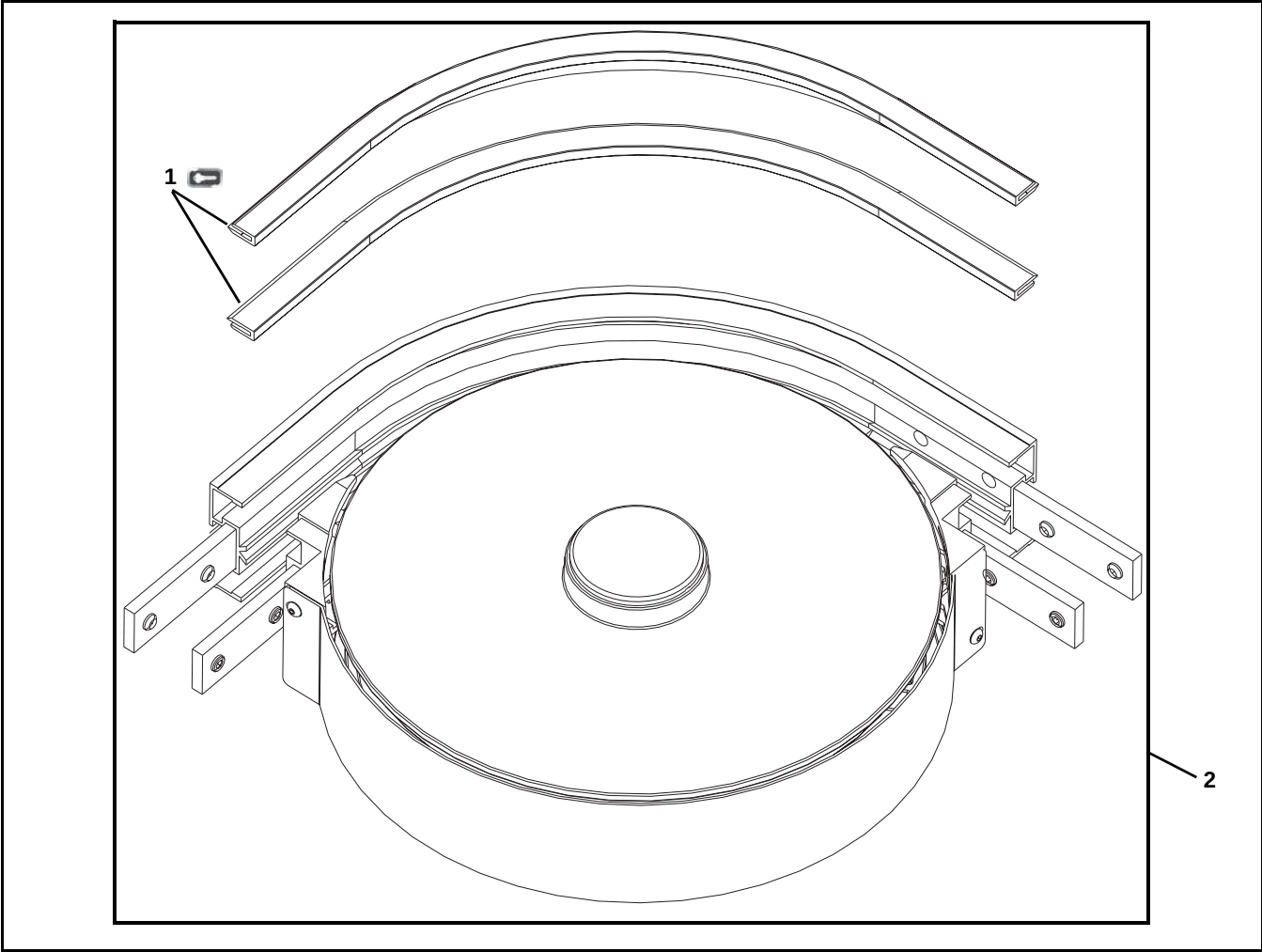
Wear Strip Replacement Tool



Item	Part Number	Description
1	203475	Wear Strip Replacement Tool Kit
2	834-FASLS-M5	Nylon Set Screws, M5 x 6 mm
3	896-1008	Drill Bit, #18, 0.1695"

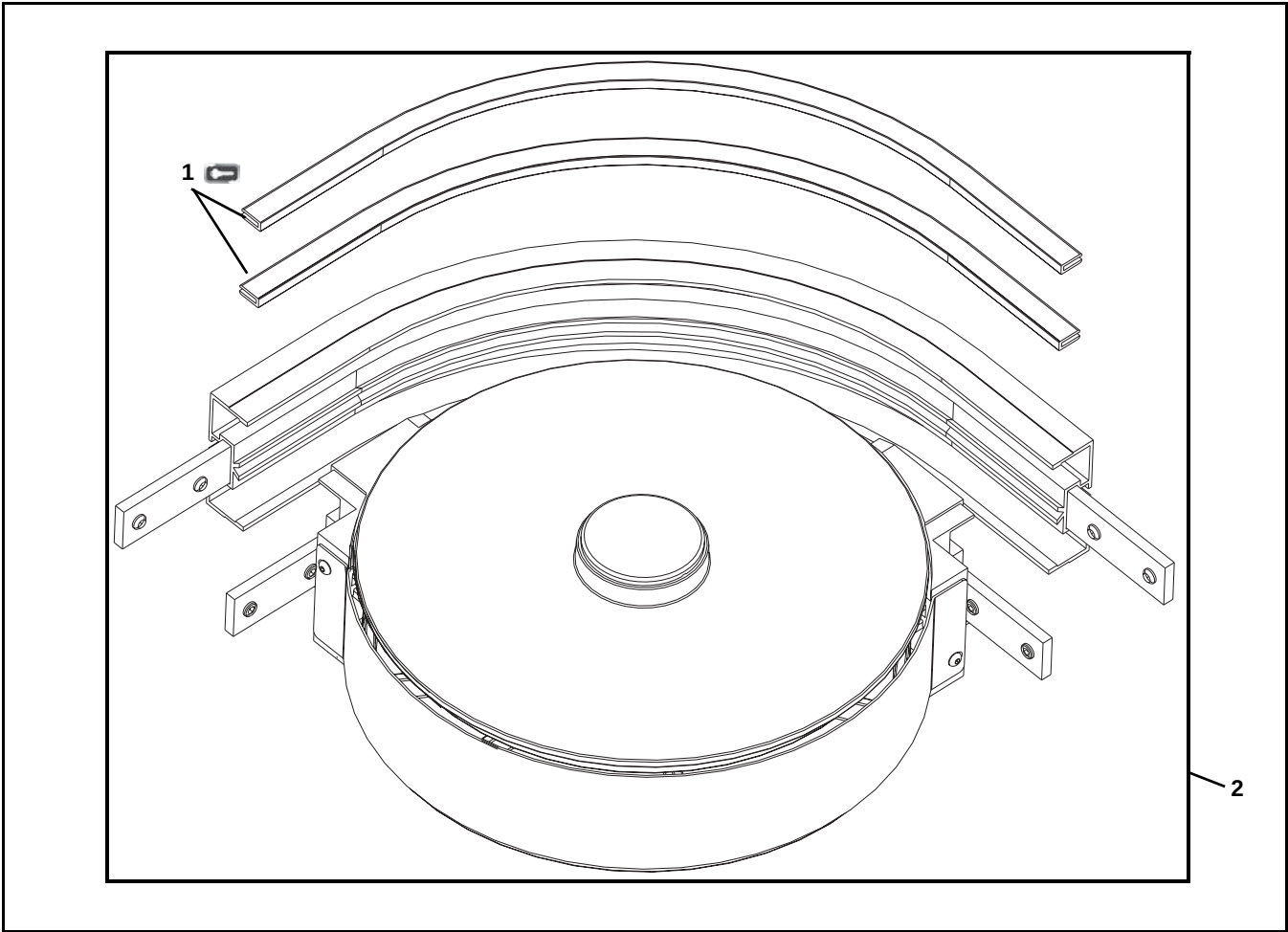
Service Parts

65 Width Curve Frame Assembly



Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	203458-045	45° Wheel Curve Kit
	203458-090	90° Wheel Curve Kit
	203458-180	180° Wheel Curve Kit
	834-034	90° 500 Radius Plain Bend Curve Kit
	834-035	90° 700 Radius Plain Bend Curve Kit
3	205165-065	Guard Assembly for Top Running Drive Only (Not Shown)
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

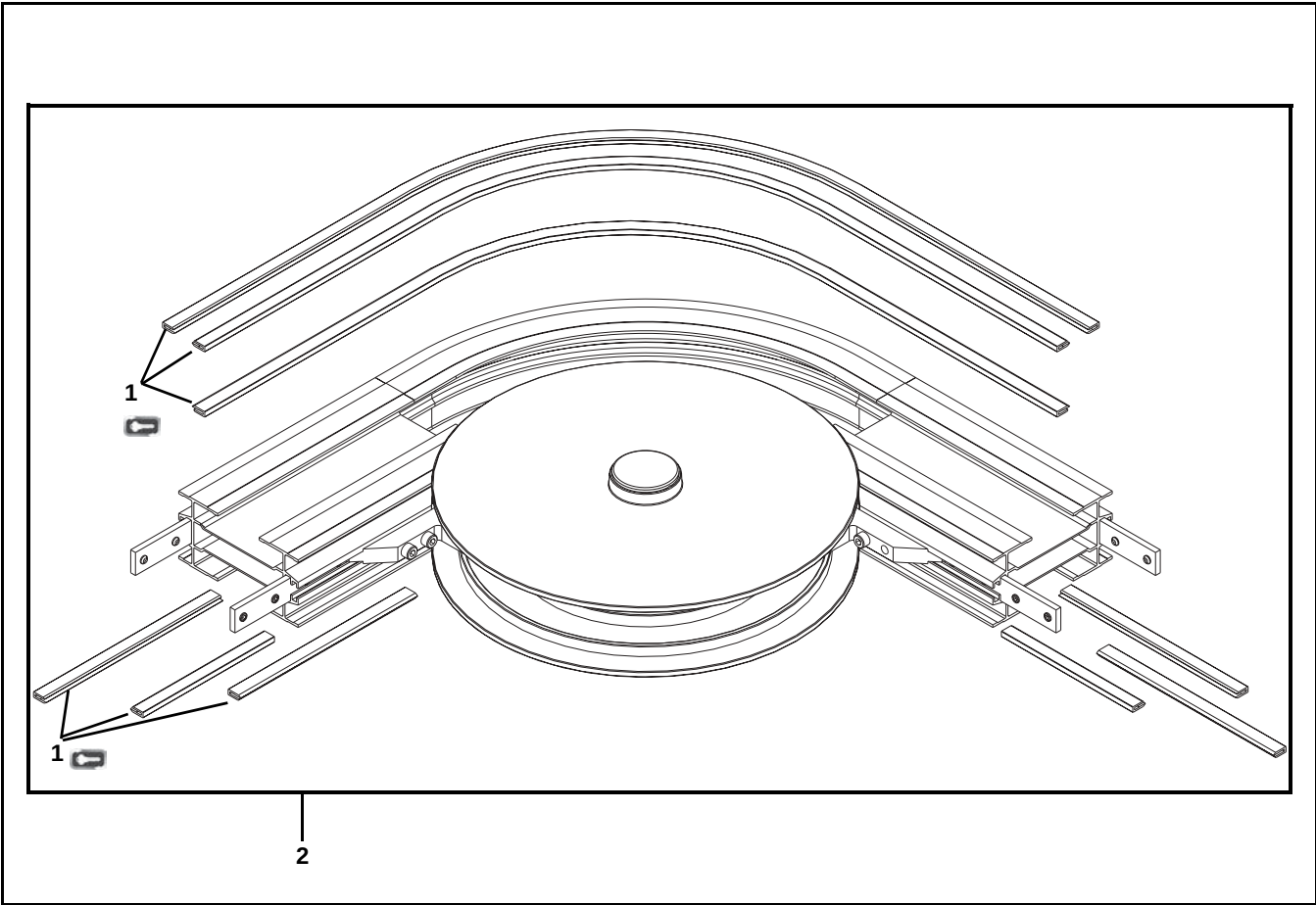
105 Width Curve Frame Assembly



Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	203459-045	45° Wheel Curve Kit
	203459-090	90° Wheel Curve Kit
	203459-135	135° Wheel Curve Kit
	203459-180	180° Wheel Curve Kit
	834-054	90° 500 Radius Plain Bend Curve Kit
	834-055	90° 700 Radius Plain Bend Curve Kit
3	205165-105	Guard Assembly for Top Running Drive Only (Not Shown)
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

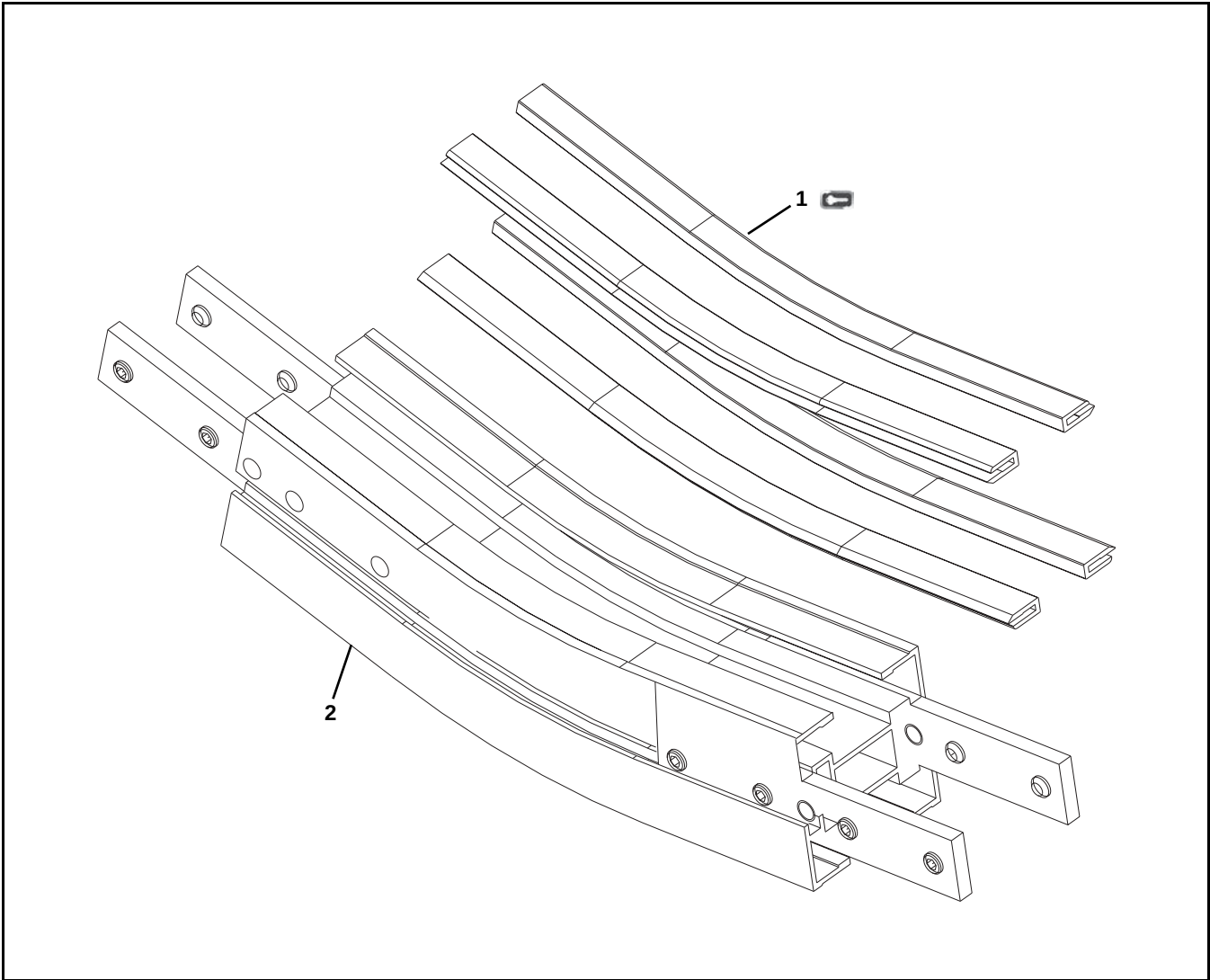
Service Parts

150 Width Curve Frame Assembly



Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	203460-045	45° Wheel Curve Kit
	203460-090	90° Wheel Curve Kit
	203460-180	180° Wheel Curve Kit
3	205165-150	Guard Assembly for Top Running Drive Only (Not Shown)
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

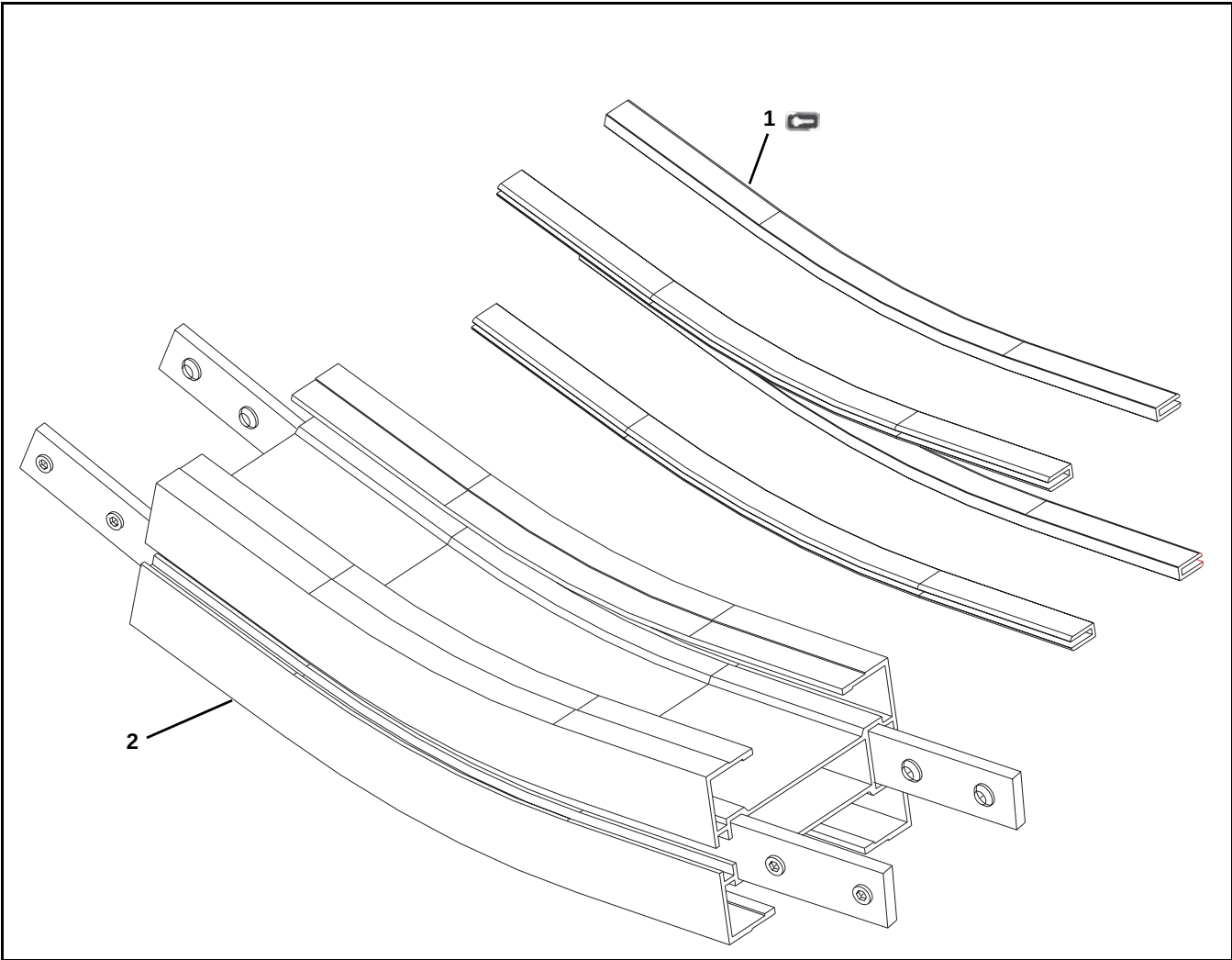
65 Width Knuckle Frame Assembly



Item	Part Number	Description
1 	See Wear Strip Section	Wear Strips
2	834-030	5° Knuckle Kit
	834-036	7° Knuckle Kit
	834-031	10° Knuckle Kit
	834-037	15° Knuckle Kit
	834-032	20° Knuckle Kit
	834-033	30° Knuckle Kit
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

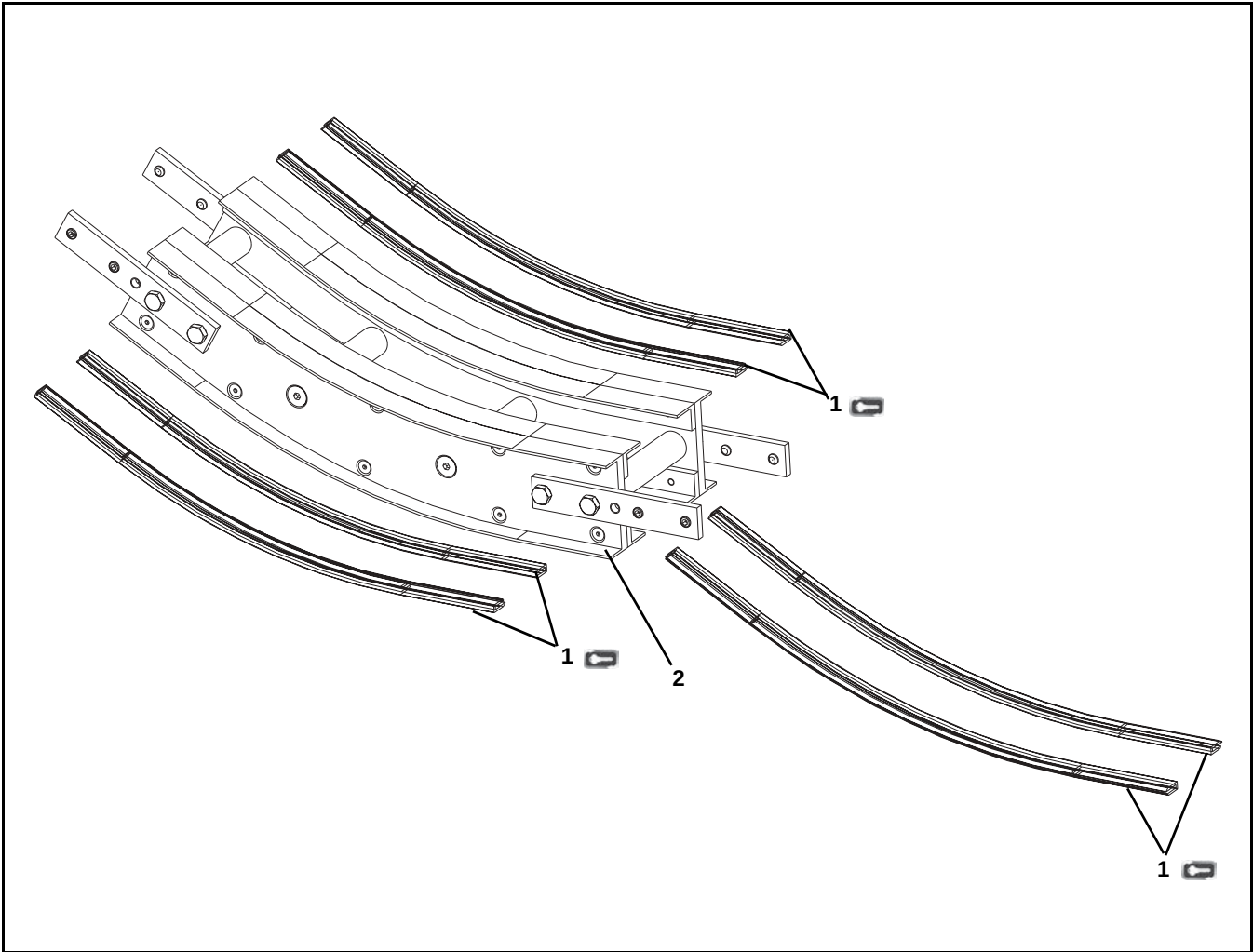
Service Parts

105 Width Knuckle Frame Assembly



Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	834-050	5° Knuckle Kit
	834-056	7° Knuckle Kit
	834-051	10° Knuckle Kit
	834-057	15° Knuckle Kit
	834-052	20° Knuckle Kit
	834-053	30° Knuckle Kit
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

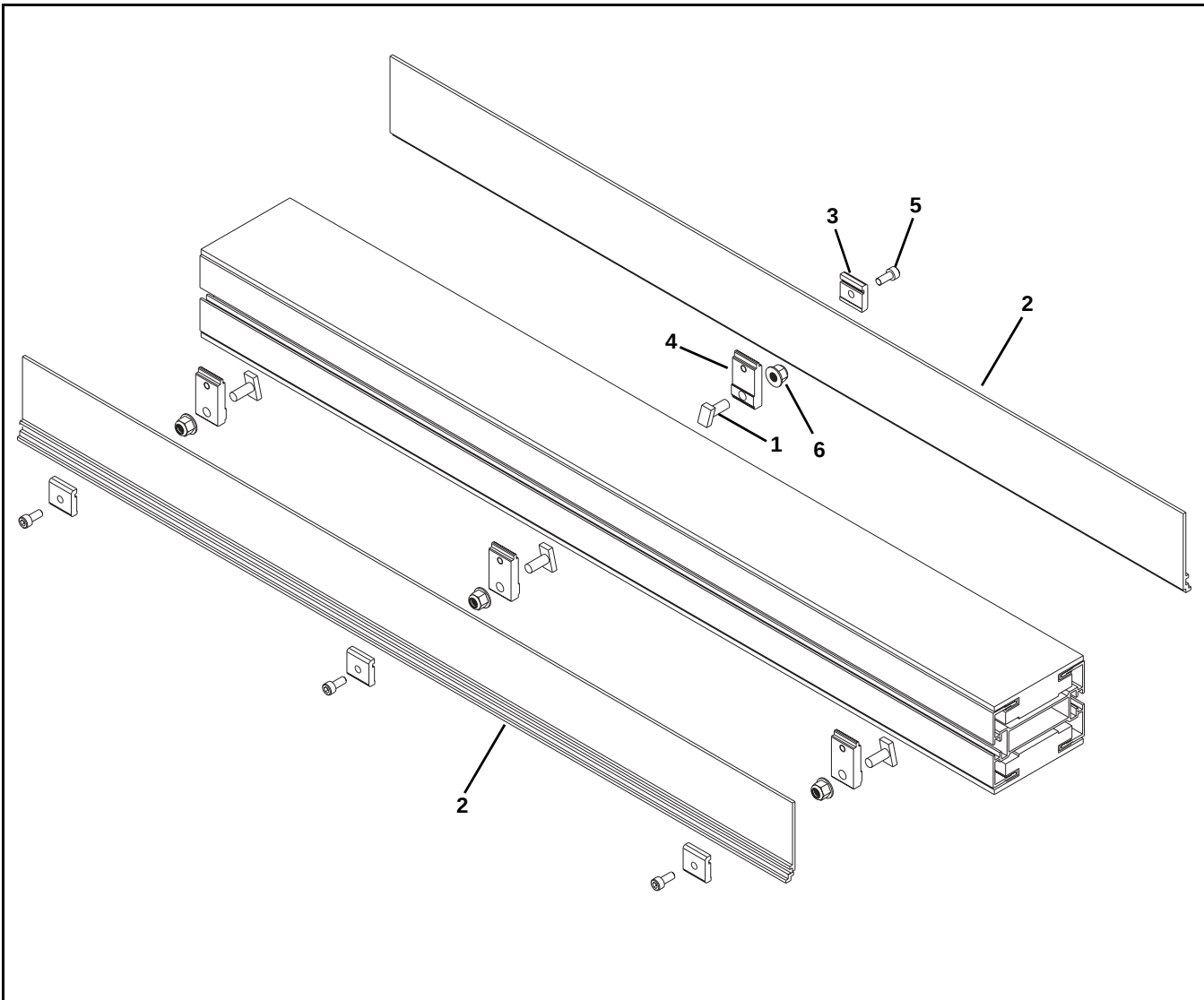
150 Width Knuckle Frame Assembly



Item	Part Number	Description
1	See Wear Strip Section	Wear Strips
2	834-070	5° Knuckle Kit
	834-071	10° Knuckle Kit
	834-072	20° Knuckle Kit
	834-073	30° Knuckle Kit
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

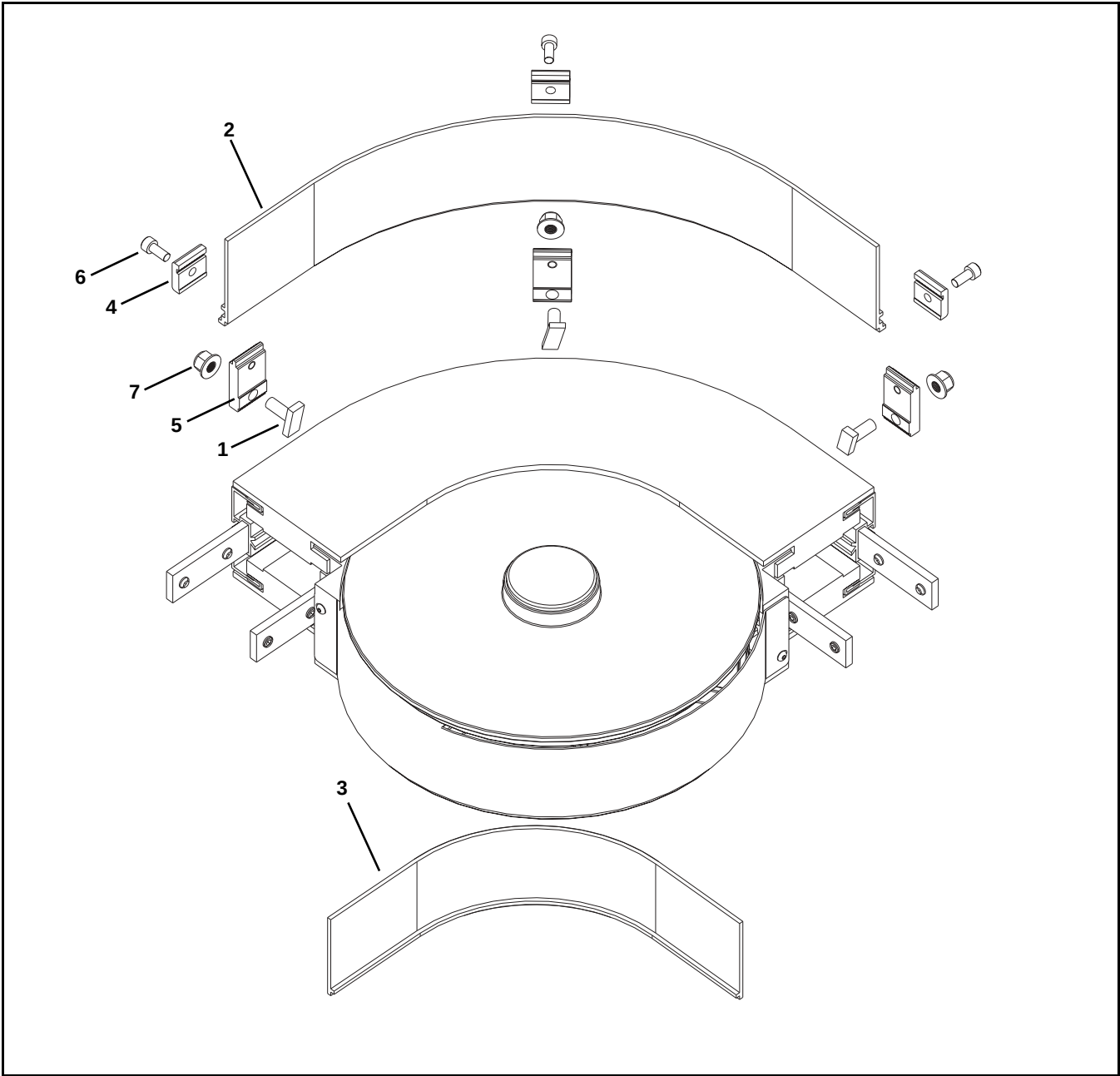
Service Parts

04 3" High Sides for Straight Modules



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204127- <u>LLLLL</u>	3" High Side
3	204566	Mounting Clip
4	210829	Guide Clip Adapter
	210831	Guide Clip Adapter for Tail Mount Only
	210836	Guide Clip Adapter for Roller Transfer Tail Mount Only
5	920614M	Socket Head Screw, M6-1.00 x 14 mm
6	990812M	Hex Nut, M8-1.25
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

04 3" High Sides for Curve Modules

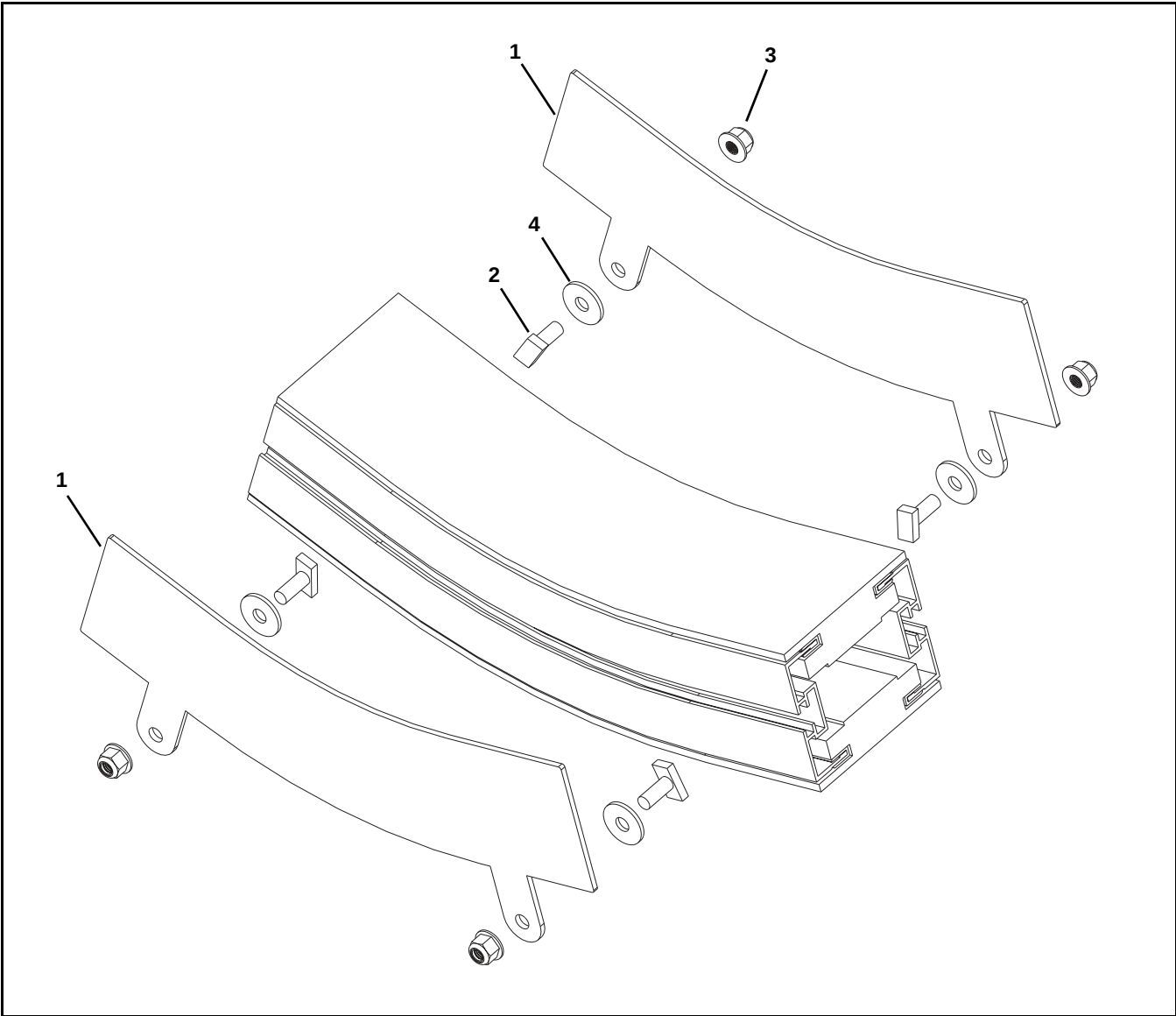


Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204134- <u>WWW</u> - <u>AAA</u>	3" High Side for Wheel Bend Curves - Outside Edge
	204336- <u>WWW</u> - <u>AAA</u>	3" High Side for 500R Plain Bend Curves - Outside Edge
	204340- <u>WWW</u> - <u>AAA</u>	3" High Side for 700R Plain Bend Curves - Outside Edge
3	204136- <u>WWW</u> - <u>AAA</u>	3" High Side for Wheel Bend Curves - Inside Edge
	204335- <u>WWW</u> - <u>AAA</u>	3" High Side for 500R Plain Bend Curves - Inside Edge
	204339- <u>WWW</u> - <u>AAA</u>	3" High Side for 700R Plain Bend Curves - Inside Edge

Item	Part Number	Description
4	204566	Mounting Clip
5	210829	Clip Guide Adapter
6	920614M	Socket Head Screw, M6-1.00 x 14 mm
7	990812M	Hex Nut, M8-1.25
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		
<u>AAA</u> = Angle of curve: 045, 090, 135, 180		

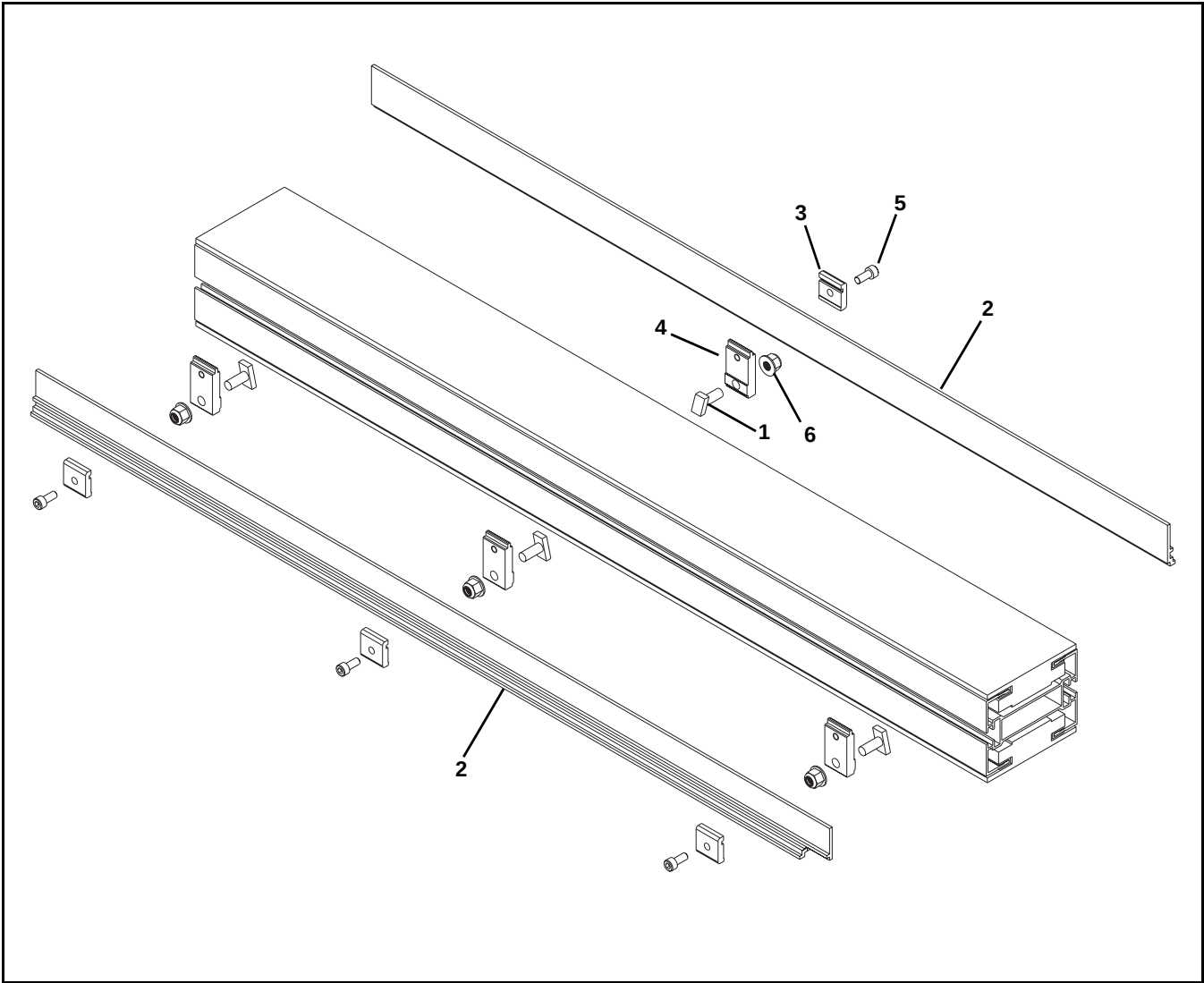
Service Parts

04 3" High Sides for Incline/Decline Modules



Item	Part Number	Description
1	204144-AA- <u>WWW</u>	Guide Plate for Lower knuckle
	204174-AA- <u>WWW</u>	Guide Plate for Upper Knuckle
2	834-FATB-20	Stud, M8 x 20 mm
3	990812M	Hex Nut, M8-1.25
4	204145	Spacer
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		
<u>AAA</u> = Angle of curve: 045, 090, 135, 180		

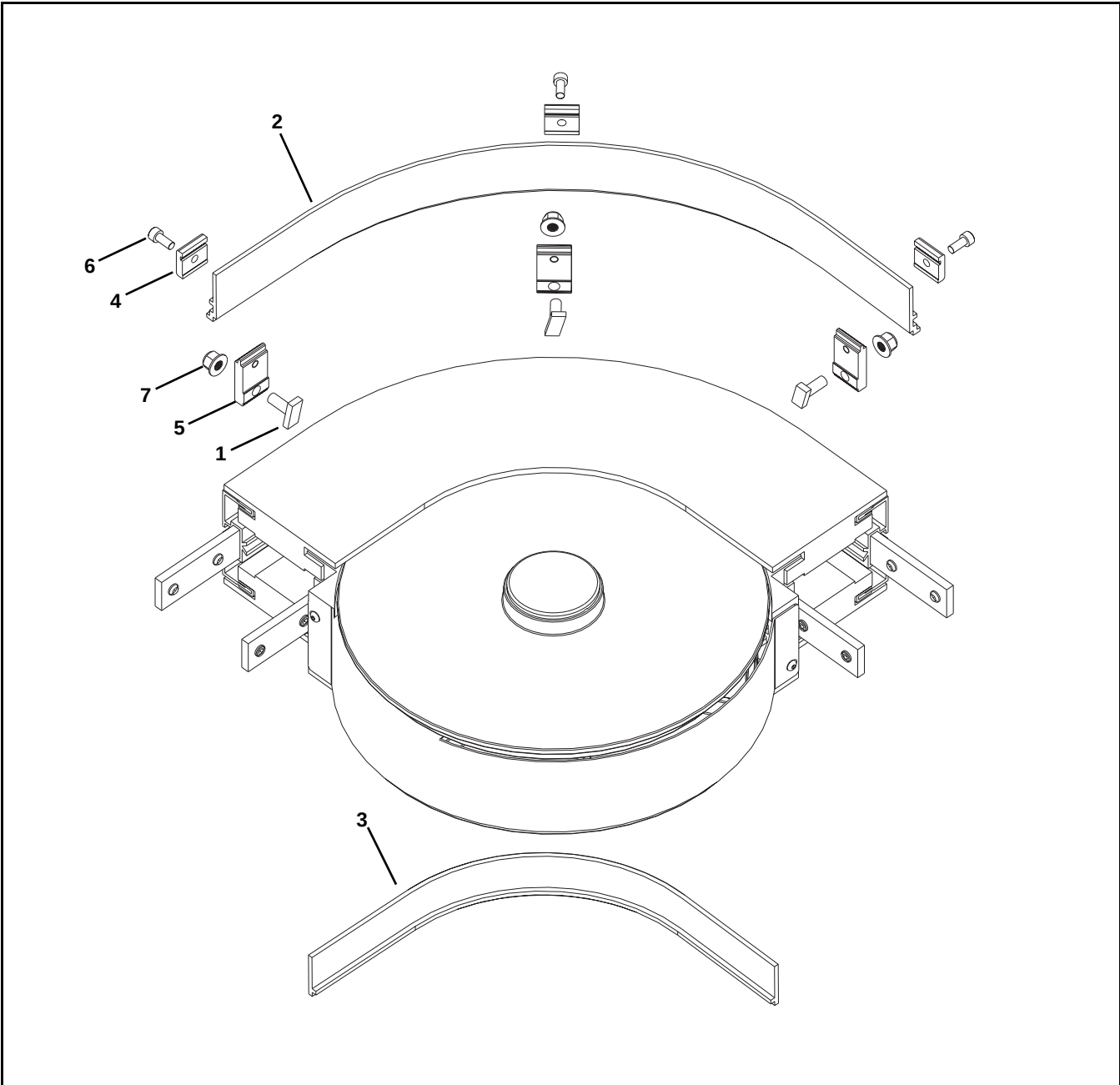
05 1.50" High Sides for Straight Modules



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204172- <u>LLLLL</u>	1.50" High Side
3	204566	Mounting Clip
4	210829	Guide Clip Adapter
	210831	Guide Clip Adapter for Tail Mount Only
	210836	Guide Clip Adapter for Roller Transfer Tail Mount Only
5	920614M	Socket Head Screw, M6-1.00 x 14 mm
6	990812M	Hex Nut, M8-1.25
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

Service Parts

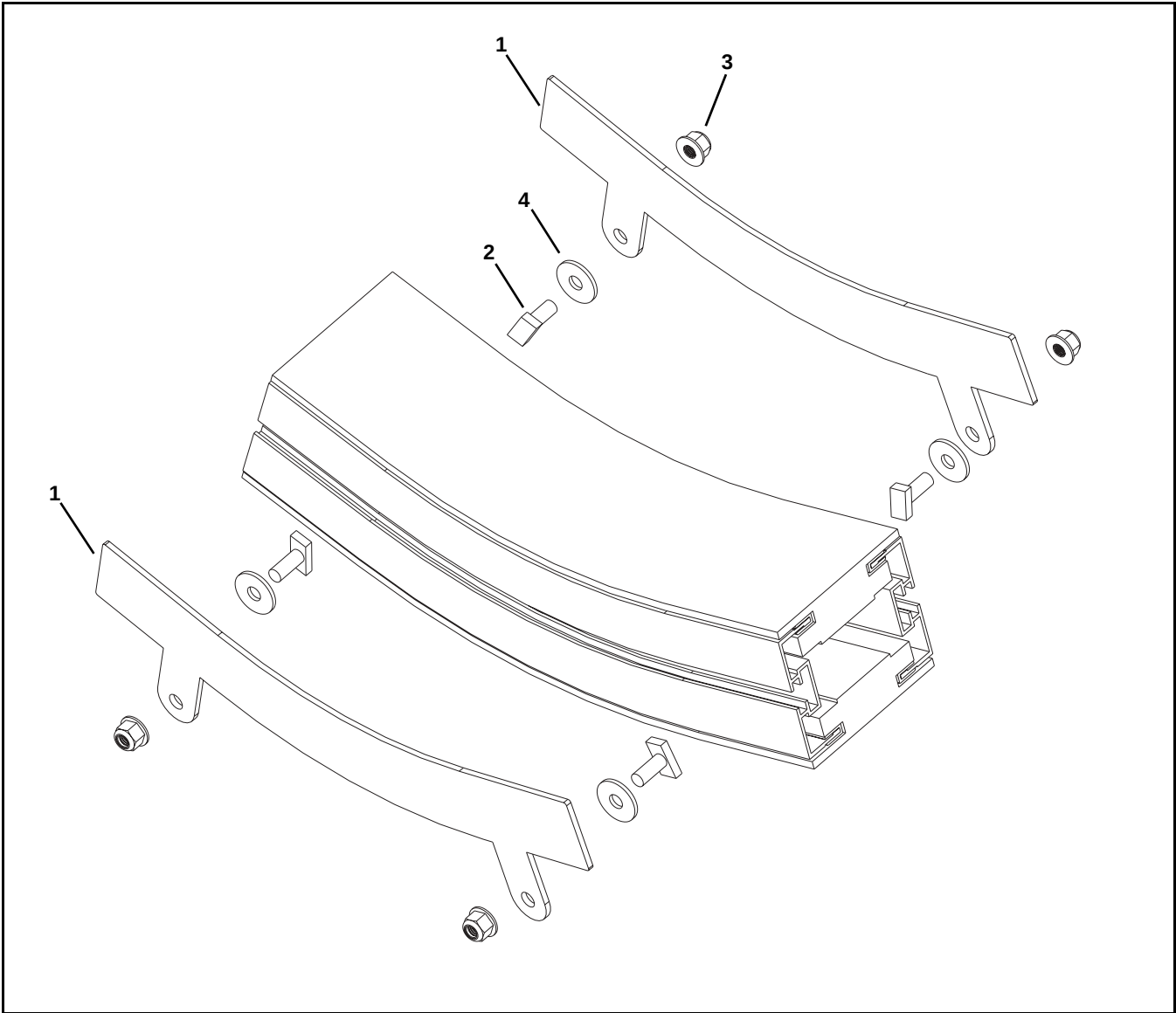
05 1.50" High Sides for Curve Modules



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	204135- <u>WWW</u> - <u>AAA</u>	1.50" High Side for Wheel Bend Curves - Outside Edge
	204334- <u>WWW</u> - <u>AAA</u>	1.50" High Side for 500R Plain Bend Curves - Outside Edge
	204338- <u>WWW</u> - <u>AAA</u>	1.50" High Side for 700R Plain Bend Curves - Outside Edge
3	204137- <u>WWW</u> - <u>AAA</u>	1.50" High Side for Wheel Bend Curves - Inside Edge
	204333- <u>WWW</u> - <u>AAA</u>	1.50" High Side for 500R Plain Bend Curves - Inside Edge
	204337- <u>WWW</u> - <u>AAA</u>	1.50" High Side for 700R Plain Bend Curves - Inside Edge

Item	Part Number	Description
4	204566	Mounting Clip
5	210829	Clip Guide Adapter
6	920614M	Socket Head Screw, M6-1.00 x 14 mm
7	990812M	Hex Nut, M8-1.25
		<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150
		<u>AAA</u> = Angle of curve: 045, 090, 135, 180

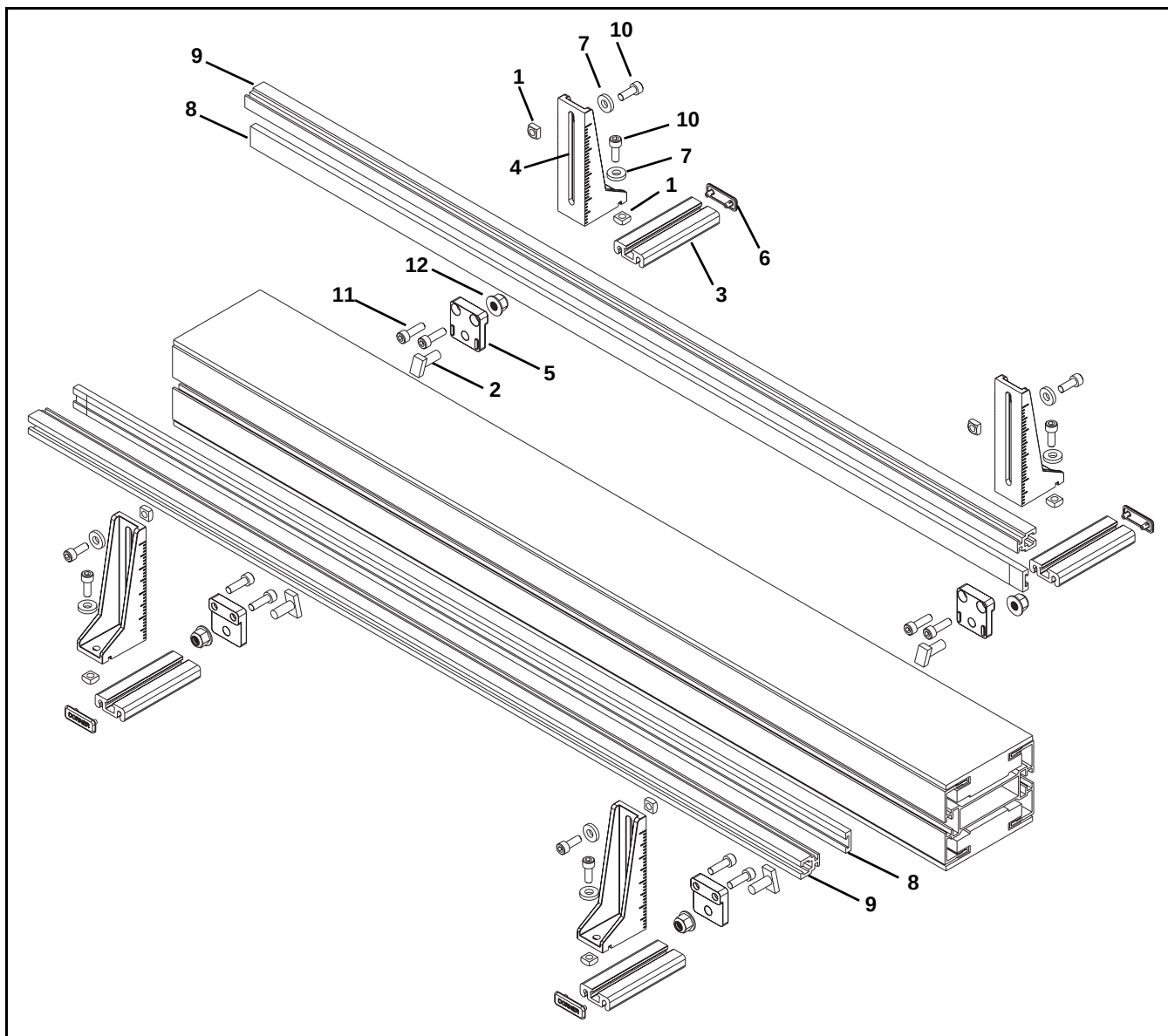
05 1.50" High Sides for Incline/Decline Modules



Item	Part Number	Description
1	204342-AA- <u>WWW</u>	Guide Plate for Lower knuckle
	204343-AA- <u>WWW</u>	Guide Plate for Upper Knuckle
2	834-FATB-20	Stud, M8 x 20 mm
3	990812M	Hex Nut, M8-1.25
4	204145	Spacer
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		
<u>AAA</u> = Angle of curve: 045, 090, 135, 180		

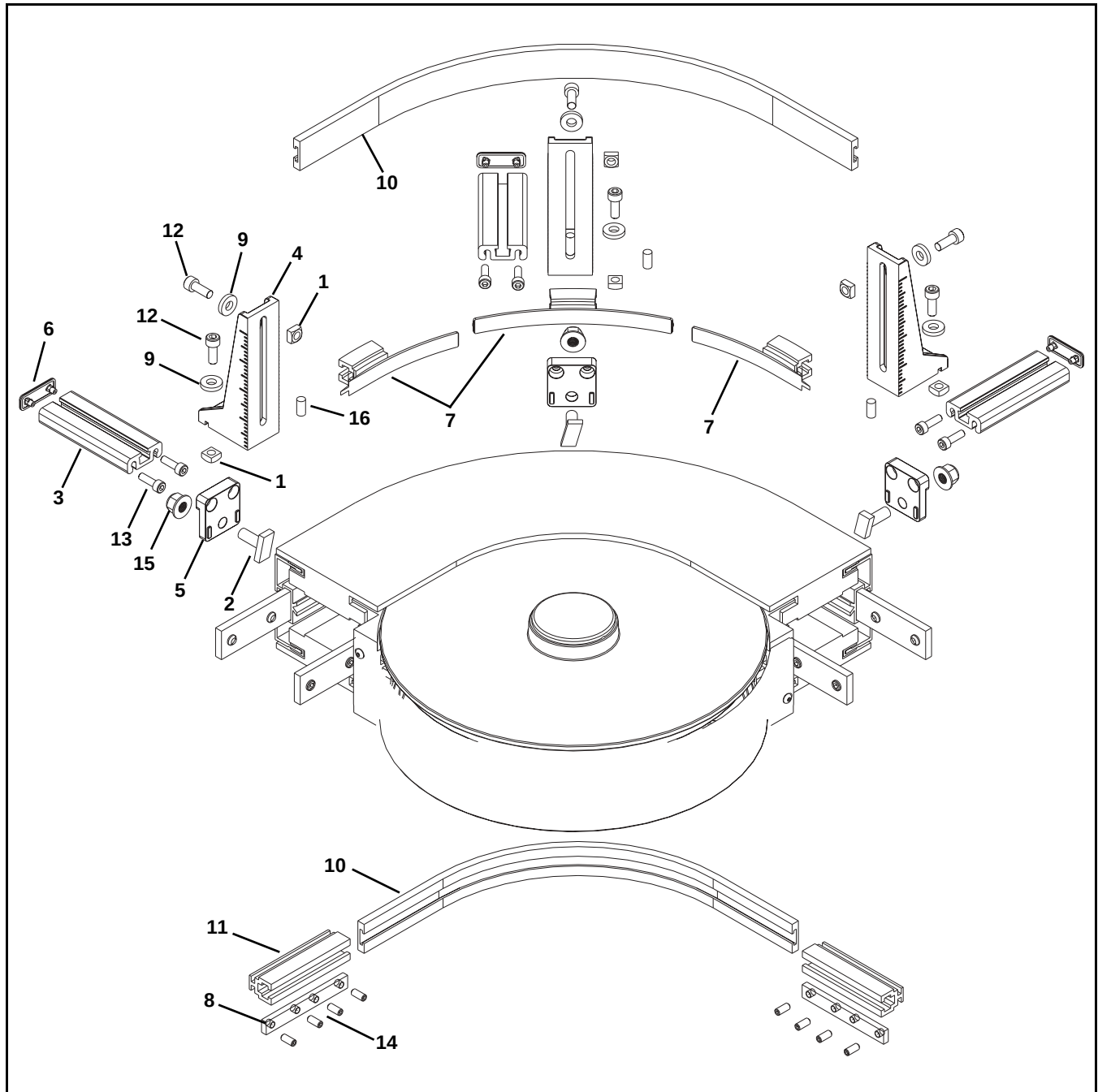
Service Parts

13 Fully Adjustable Guiding for Straight Modules



Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00353	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	605279P	Washer
8	614068P- <u>LLLL</u>	Guiding
9	636975P- <u>LLLL</u>	Guide Rail
10	920616M	Socket Head Screw, M6-1.00 x 16 mm
11	920516M	Socket Head Screw, M5-0.80 x 16 mm
12	990812M	Hex Nut, M8-1.25
<u>LLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

13 Fully Adjustable Guiding for Curve Modules

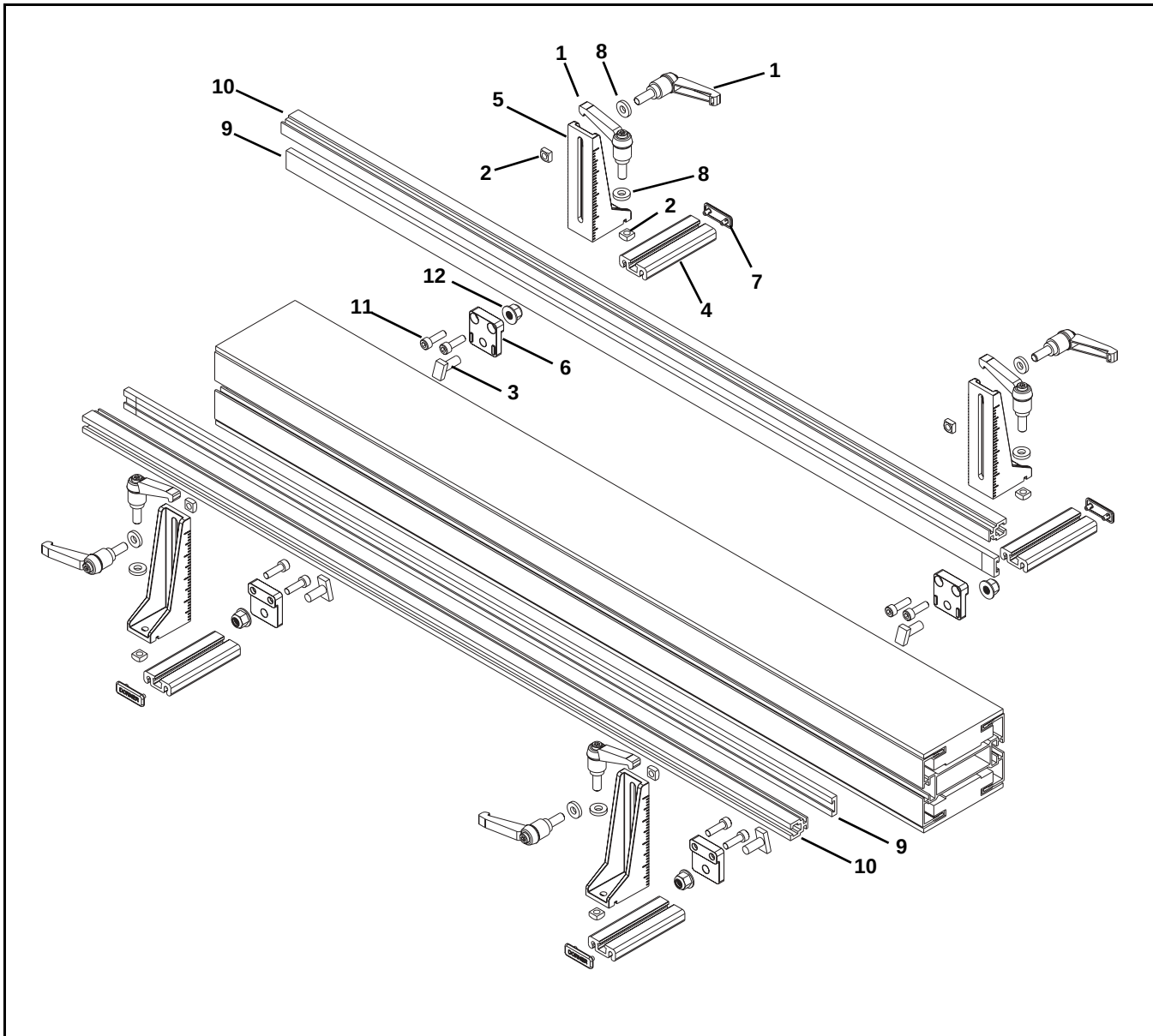


Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00353	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	203494	Guide Support
8	210913	Nut Bar
9	605279P	Washer
10	614068P- <u>LLLLL</u>	Guiding

Item	Part Number	Description
11	636975P- <u>LLLLL</u>	Guide Rail
12	920616M	Socket Head Screw, M6-1.00 x 16 mm
13	920516M	Socket Head Screw, M5-0.80 x 16 mm
14	930510M	Flat Head Screw, M5-0.80 x 10 mm
15	990812M	Hex Nut, M8-1.25
16	913-051	Roll Pin
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

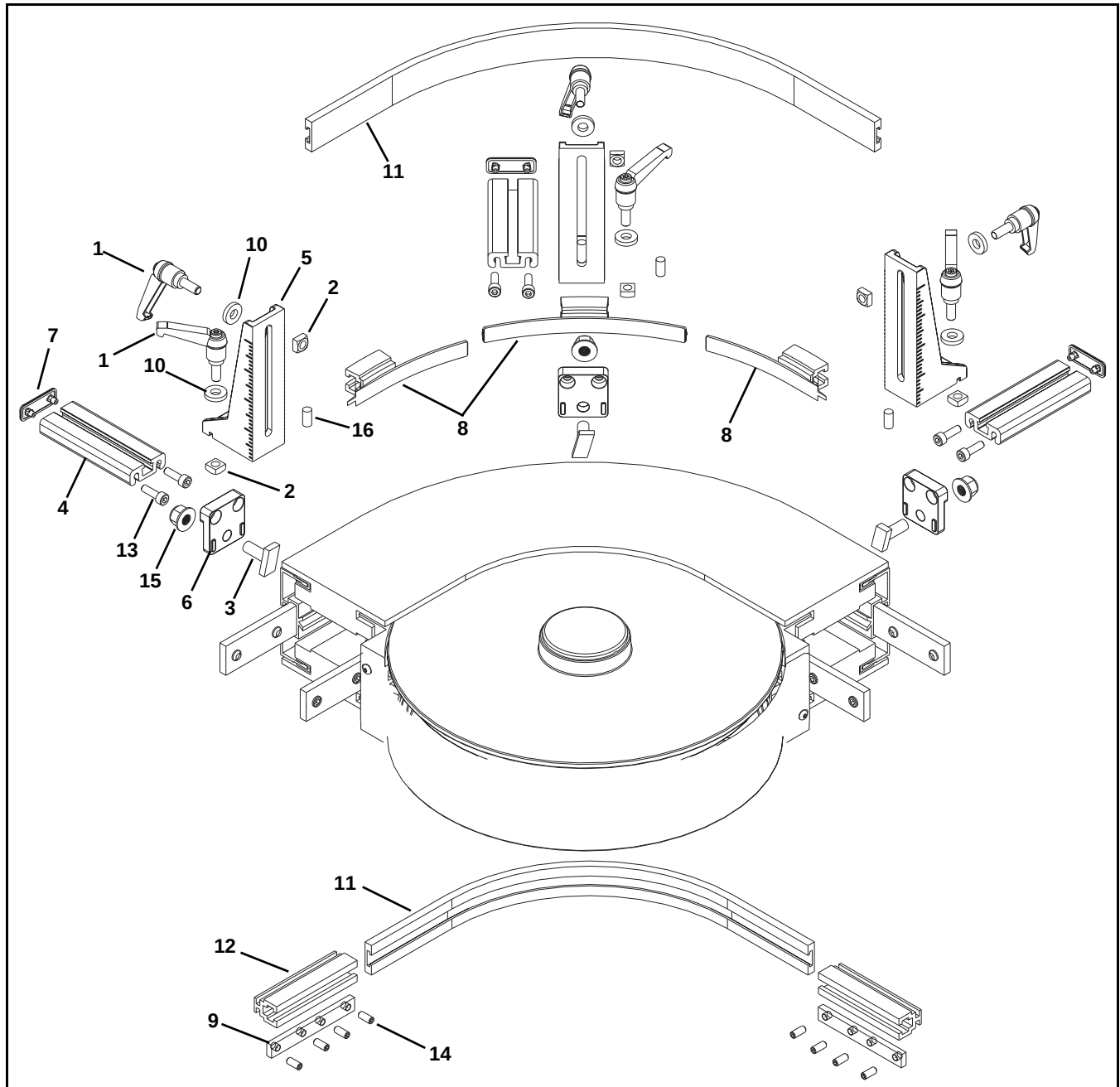
Service Parts

14 Tool-Less Fully Adjustable Guiding for Straight Modules



Item	Part Number	Description
1	807-2272	Handle
2	807-920	Square Nut, M6-1.0
3	834-FATB-20	Stud, M8 x 20 mm
4	210846-00353	Extrusion Base
5	210847	Mounting Bracket
6	210848	Mounting Block
7	210849	Cap
8	605279P	Washer
9	614068P-LLLLL	Guiding
10	636975P-LLLLL	Guide Rail
11	920516M	Socket Head Screw, M5-0.80 x 16 mm
12	990812M	Hex Nut, M8-1.25
LLLLL = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

14 Tool-Less Fully Adjustable Guiding for Curve Modules

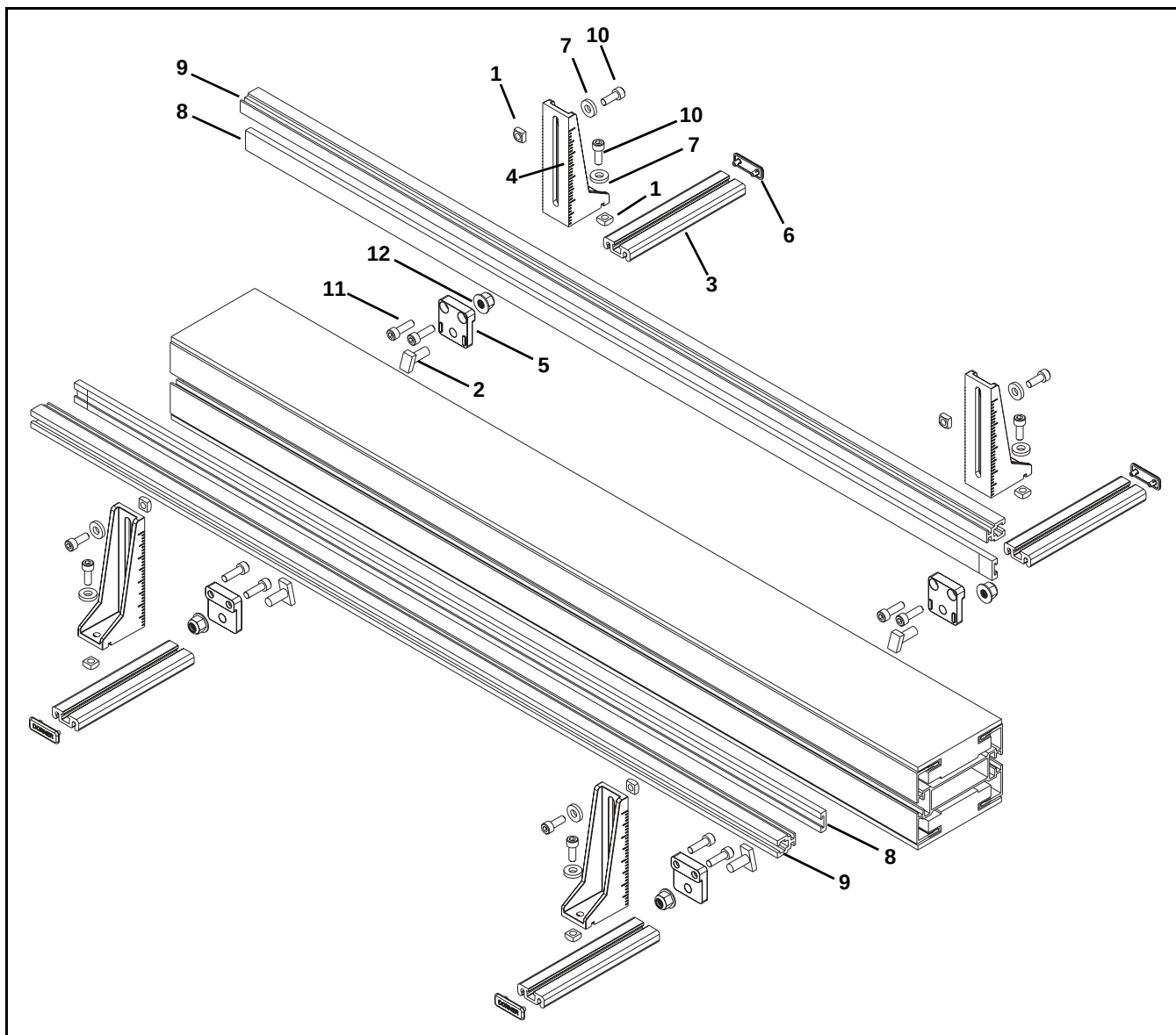


Item	Part Number	Description
1	807-2272	Handle
2	807-920	Square Nut, M6-1.0
3	834-FATB-20	Stud, M8 x 20 mm
4	210846-00353	Extrusion Base
5	210847	Mounting Bracket
6	210848	Mounting Block
7	210849	Cap
8	203494	Guide Support
9	210913	Nut Bar
10	605279P	Washer
11	614068P- <u>LLLLL</u>	Guiding

Item	Part Number	Description
12	636975P- <u>LLLLL</u>	Guide Rail
13	920516M	Socket Head Screw, M5-0.80 x 16 mm
14	930510M	Flat Head Screw, M5-0.80 x 10 mm
15	990812M	Hex Nut, M8-1.25
16	913-051	Roll Pin
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

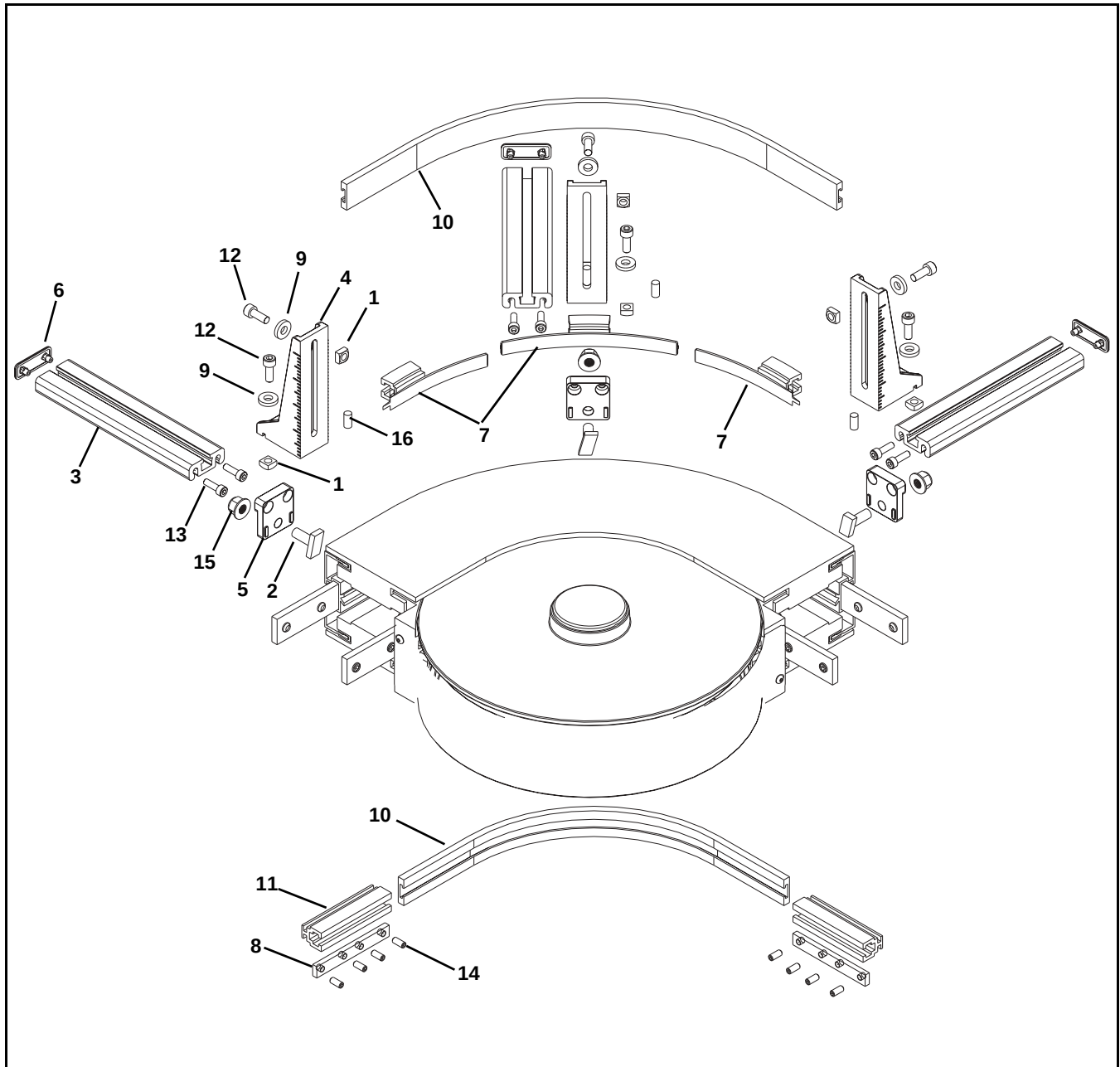
Service Parts

16 Gull Wing Guiding for Straight Modules



Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00600	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	605279P	Washer
8	614068P- <u>LLLLL</u>	Guiding
9	636975P- <u>LLLLL</u>	Guide Rail
10	920616M	Socket Head Screw, M6-1.00 x 16 mm
11	920516M	Socket Head Screw, M5-0.80 x 16 mm
12	990812M	Hex Nut, M8-1.25
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

16 Gull Wing Guiding for Curve Modules

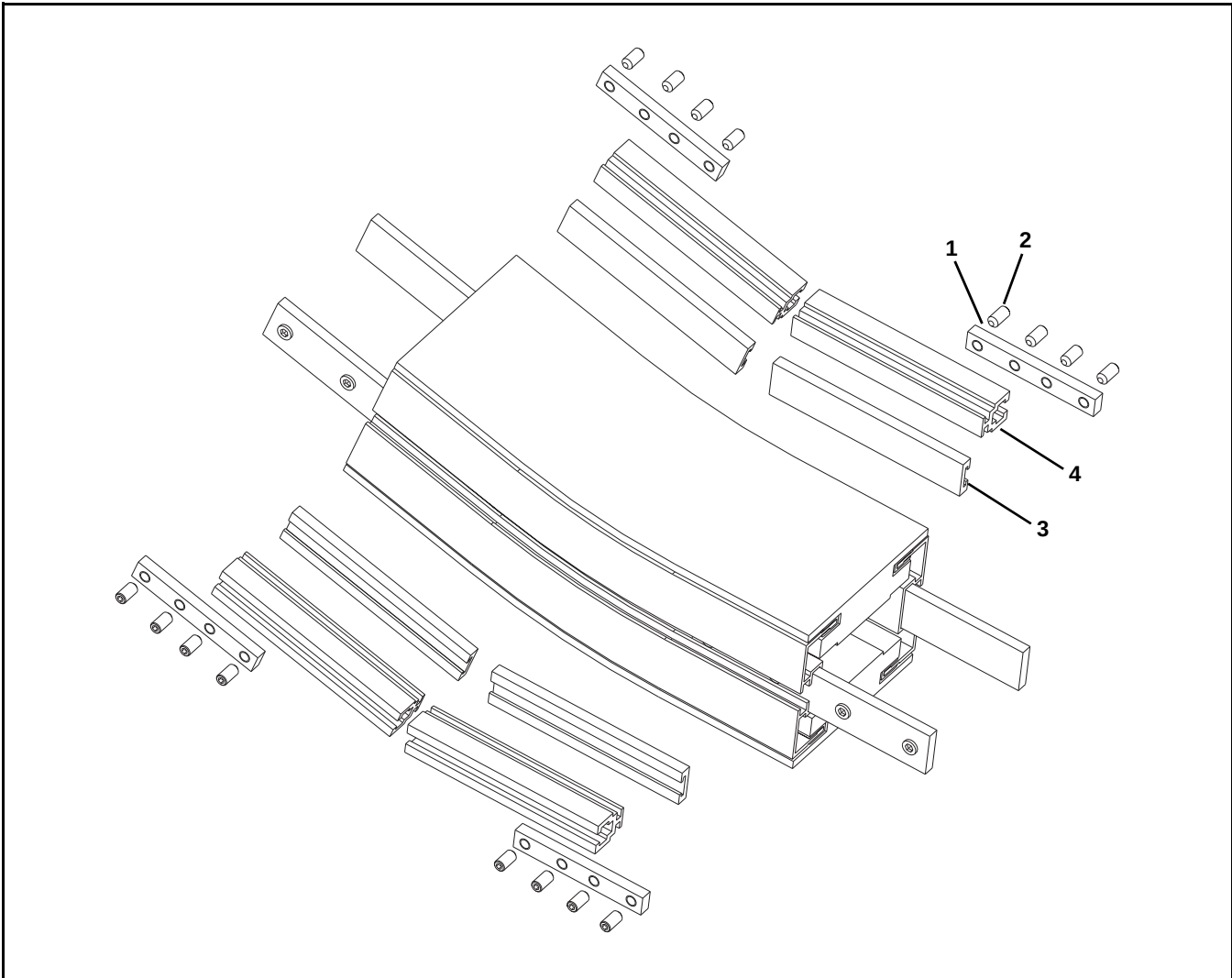


Item	Part Number	Description
1	807-920	Square Nut, M6-1.0
2	834-FATB-20	Stud, M8 x 20 mm
3	210846-00600	Extrusion Base
4	210847	Mounting Bracket
5	210848	Mounting Block
6	210849	Cap
7	203494	Guide Support
8	210913	Nut Bar
9	605279P	Washer
10	614068P- <u>LLLLL</u>	Guiding
11	636975P- <u>LLLLL</u>	Guide Rail
12	920616M	Socket Head Screw, M6-1.00 x 16 mm

Item	Part Number	Description
13	920516M	Socket Head Screw, M5-0.80 x 16 mm
14	930510M	Flat Head Screw, M5-0.80 x 10 mm
15	990812M	Hex Nut, M8-1.25
16	913-051	Roll Pin
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

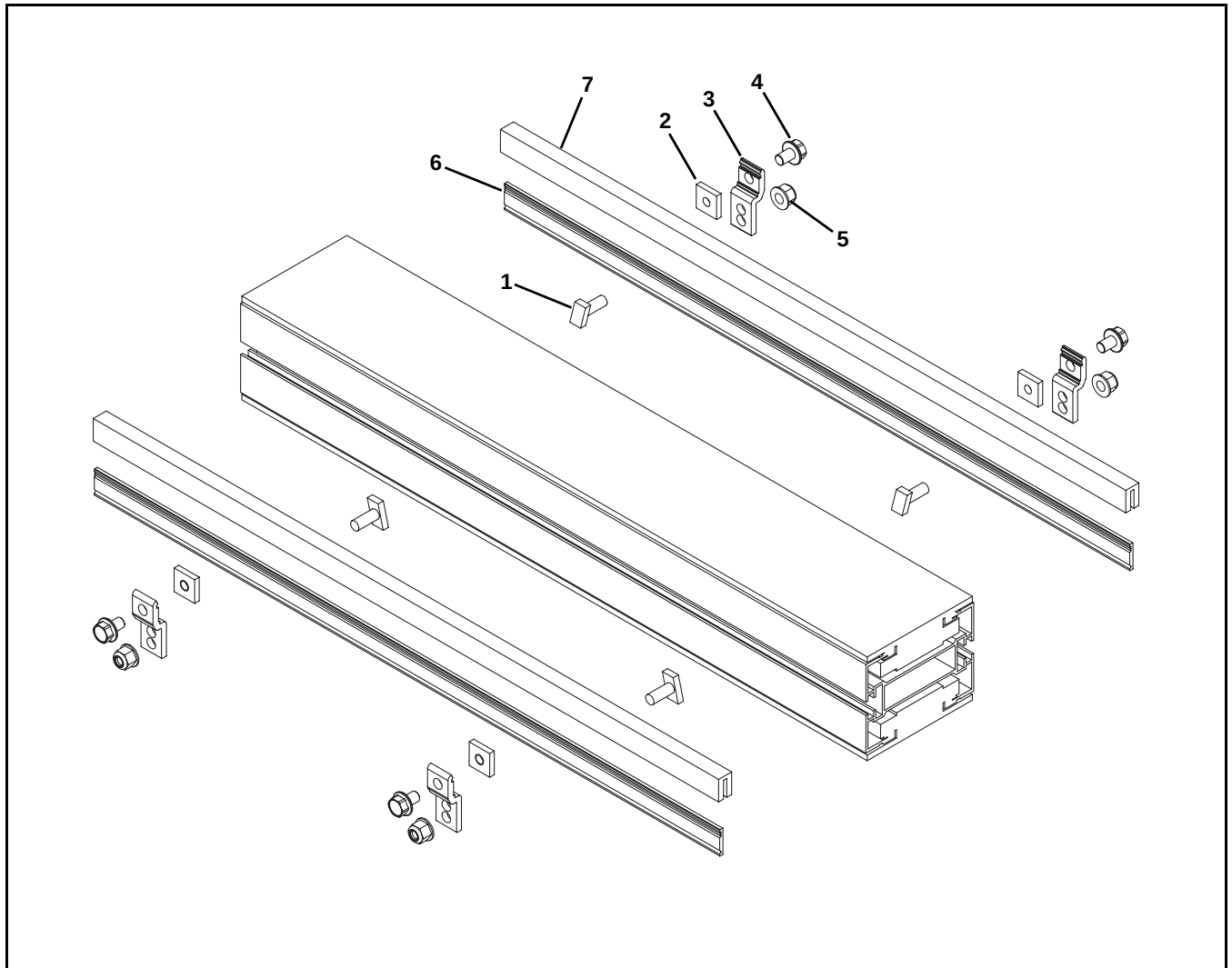
Service Parts

#13 & #14 - Adjustable Guiding and #16 - Gull Wing Guiding for Incline/Decline Modules



Item	Part Number	Description
1	210913	Nut Bar
2	930510M	Flat Head Screw, M5-0.80 x 10 mm
3	614068P- <u>LLLLL</u>	Guiding
4	636975P- <u>LLLLL</u>	Guide Rail
<u>LLLLL</u> = Part length in inches with two decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

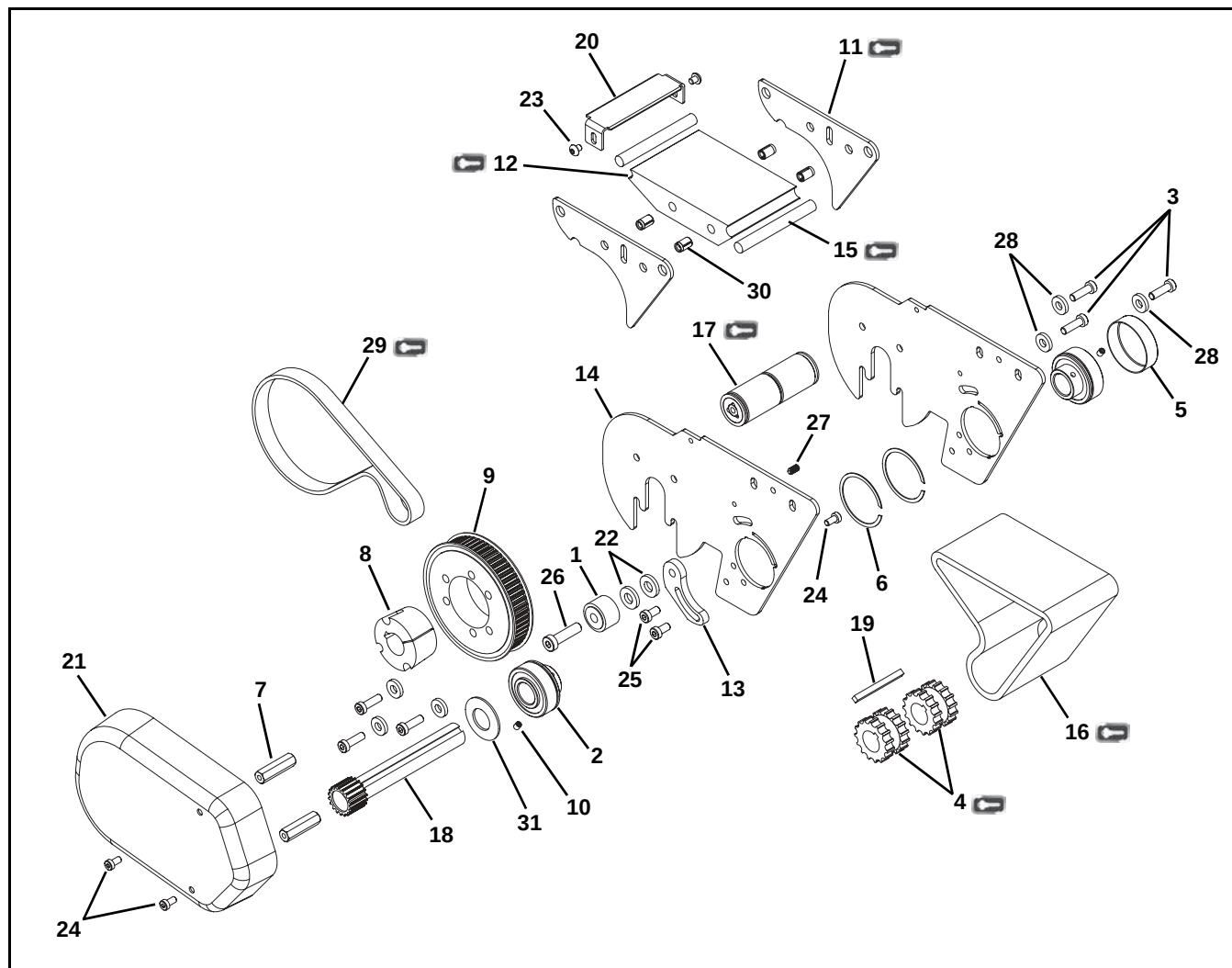
#17 & #18 - Puck / Pallet Guiding



Item	Part Number	Description
1	834-FATB-20	Stud, M8 x 20 mm
2	834-FASN-M8	Slide-In Nut, M8
3	205129	Clip
4	960882M	Hex Head Flange Screw, M8 x 12 mm
5	990812M	Hex Nut, M8-1.25
6	460055	Guide Rail (per foot)
7	203825	Clip On Wear Strip (per foot)

Service Parts

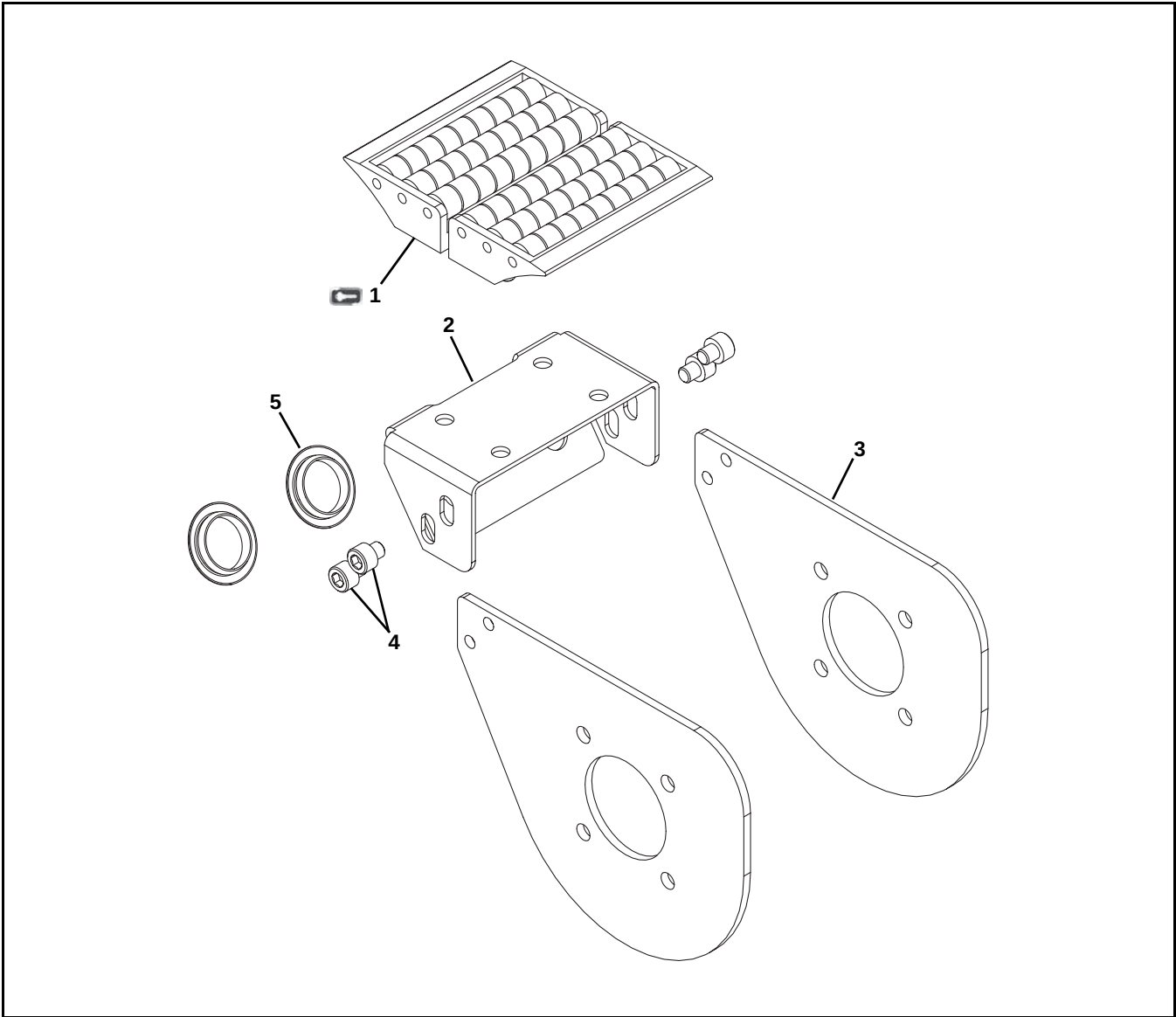
Power Transfer



Item	Part Number	Description
1	802-046	Cam Bearing
2	802-110	Bearing
3	950620M	Low Head Cap Screw, M6-1.00 x 20 mm
4	807-2009	Sprocket
5	807-2285	Cover
6	807-2286	Retaining Ring
7	807-2287	Hex Post
8	811-289	Bushing
9	811-559	Pulley
10	907-115	Socket Head Set Screw, #10-32 x 0.19
11	203229	Side Guide Plate
12	205711- <u>WWW</u>	Wear Bar
13	203231	Timing Belt Tensioner
14	203243	Side Plate for 65 width Conveyors
	205710- <u>WWW</u>	Side Plate for 85 width Conveyors
	203244	Side Plate for 105 & 150 width Conveyors
15	205726- <u>WWW</u>	Wear Rod

Item	Part Number	Description
16	203249- <u>WWW</u>	Power Transfer Belt
17	205725- <u>WWW</u>	Tensioner Assembly
18	203264- <u>WWW</u>	Shaft Assembly
19	203267- <u>WWW</u>	Square Key, 3/16" x 105 mm
20	205727- <u>WWW</u>	Tensioner Plate
21	350505	Power Transfer Cover
22	605280P	Washer
23	910506M	Button Head Screw, M5-0.80 x 6 mm
24	950510M	Low Head Cap Screw, M5-0.80 x 10 mm
25	950612M	Low Head Cap Screw, M6-1.00 x 12 mm
26	950830M	Low Head Cap Screw, M8-1.25 x 30 mm
27	970510M	Socket Head Set Screw, M5-0.80 x 10 mm
28	605279P	Washer
29	814-097	Timing Belt 5 mm x 15 mm
30	990621M	Insert
31	807-2277	Washer
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		

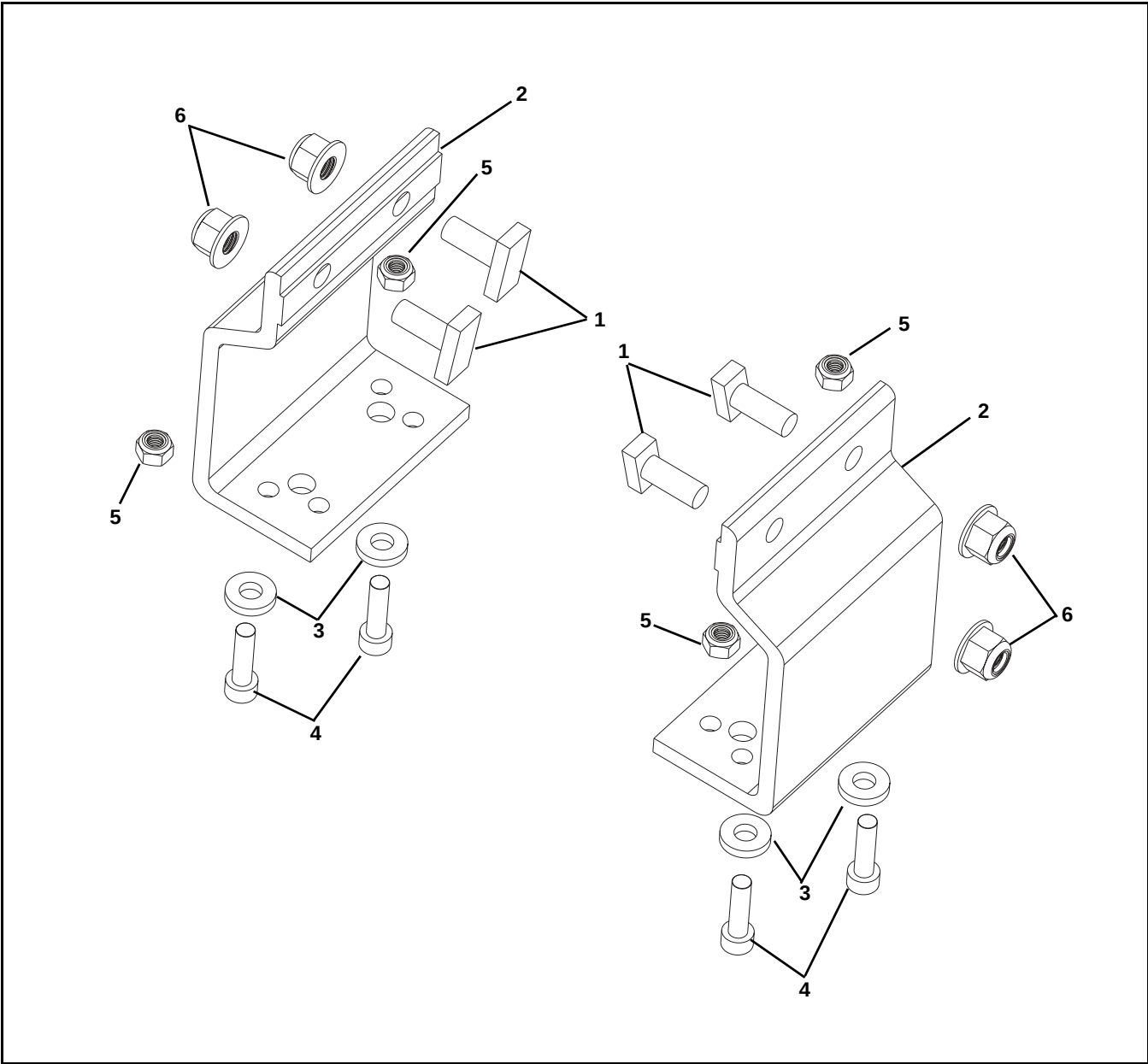
Transfer Roller



Item	Part Number	Description
	807-1829	Transfer Roller for 65 & 85 Width Conveyors (2x)
	807-1830	Transfer Roller for 105 Width Conveyors (2x)
	807-1829	Transfer Roller for 150 Width Conveyors (4x)
2	206195- <u>WWW</u>	Bracket
3	206172	Side Plate
4	920606M	Socket Head Screw, M6-1.00 x 6 mm
5	807-3118	Plug
<u>WWW</u> = Conveyor width reference: 065, 085, 105, 150		

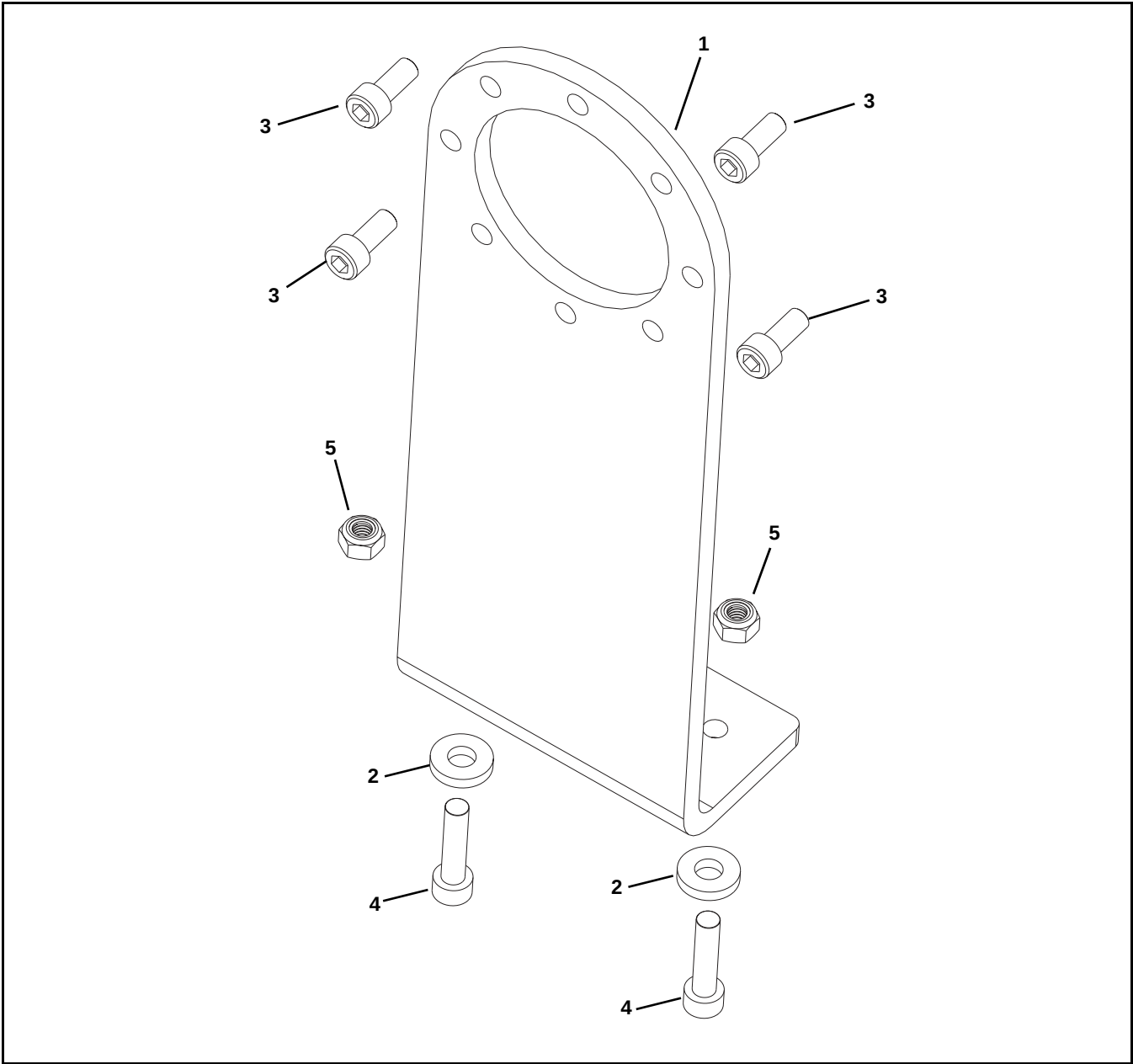
Service Parts

Mounting Brackets



Item	Part Number	Description
1	834-007	Stud, M8 x 20 mm
2	834-008	Mounting Bracket
3	605279P	Washer
4	920622M	Socket Head Screw, M6-1.00 x 22 mm
5	990602M	Hex Nut, M6-1.00
6	990812M	Flanged Hex Nut, M8-1.25

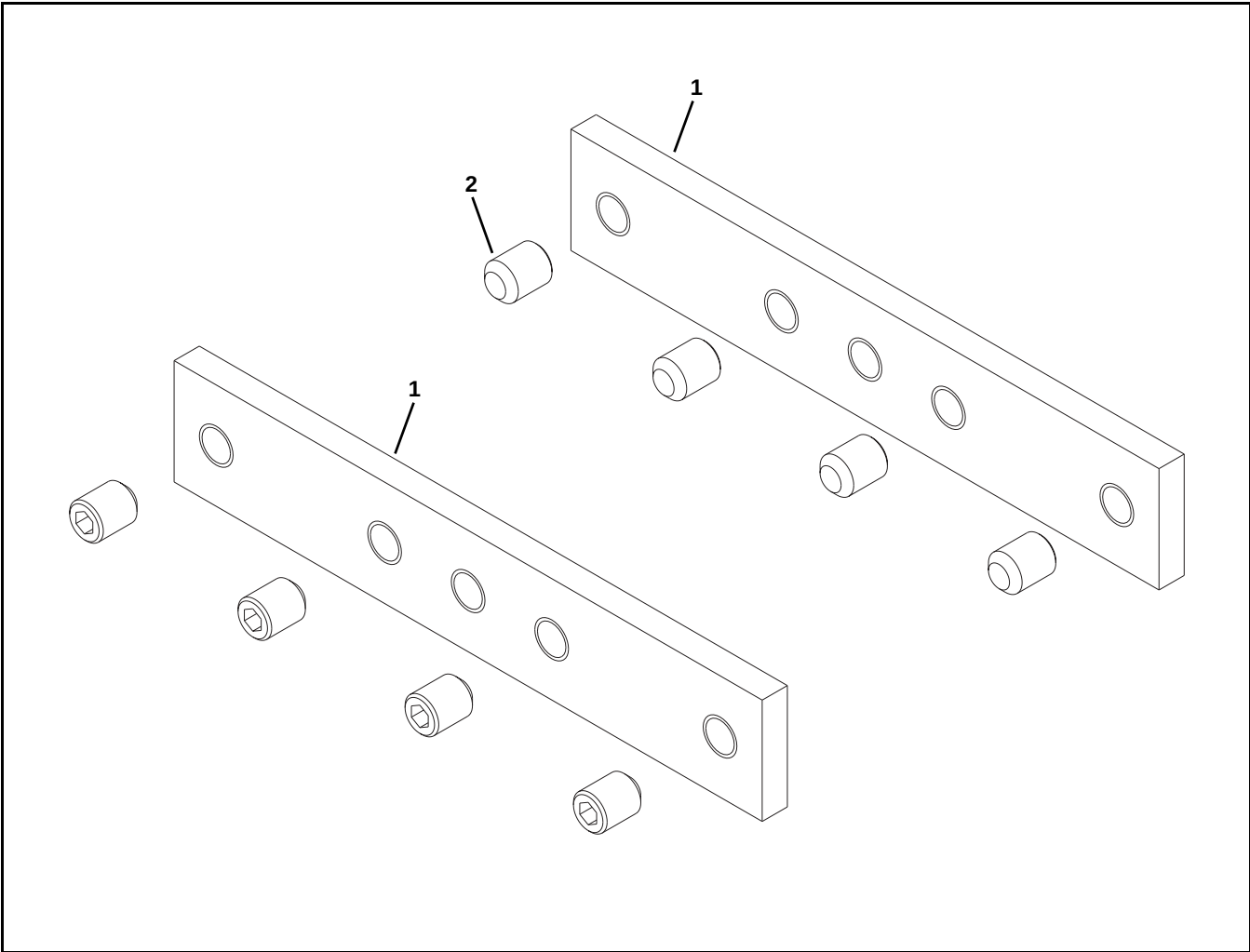
Motor Mounting Assembly



Item	Part Number	Description
1	203166	Motor Mounting Bracket
2	605279P	Washer
3	920614M	Socket Head Screw, M6-1.00 x 14 mm
4	920625M	Socket Head Screw, M6-1.00 x 25 mm
5	990602M	Hex Nut, M6-1.00

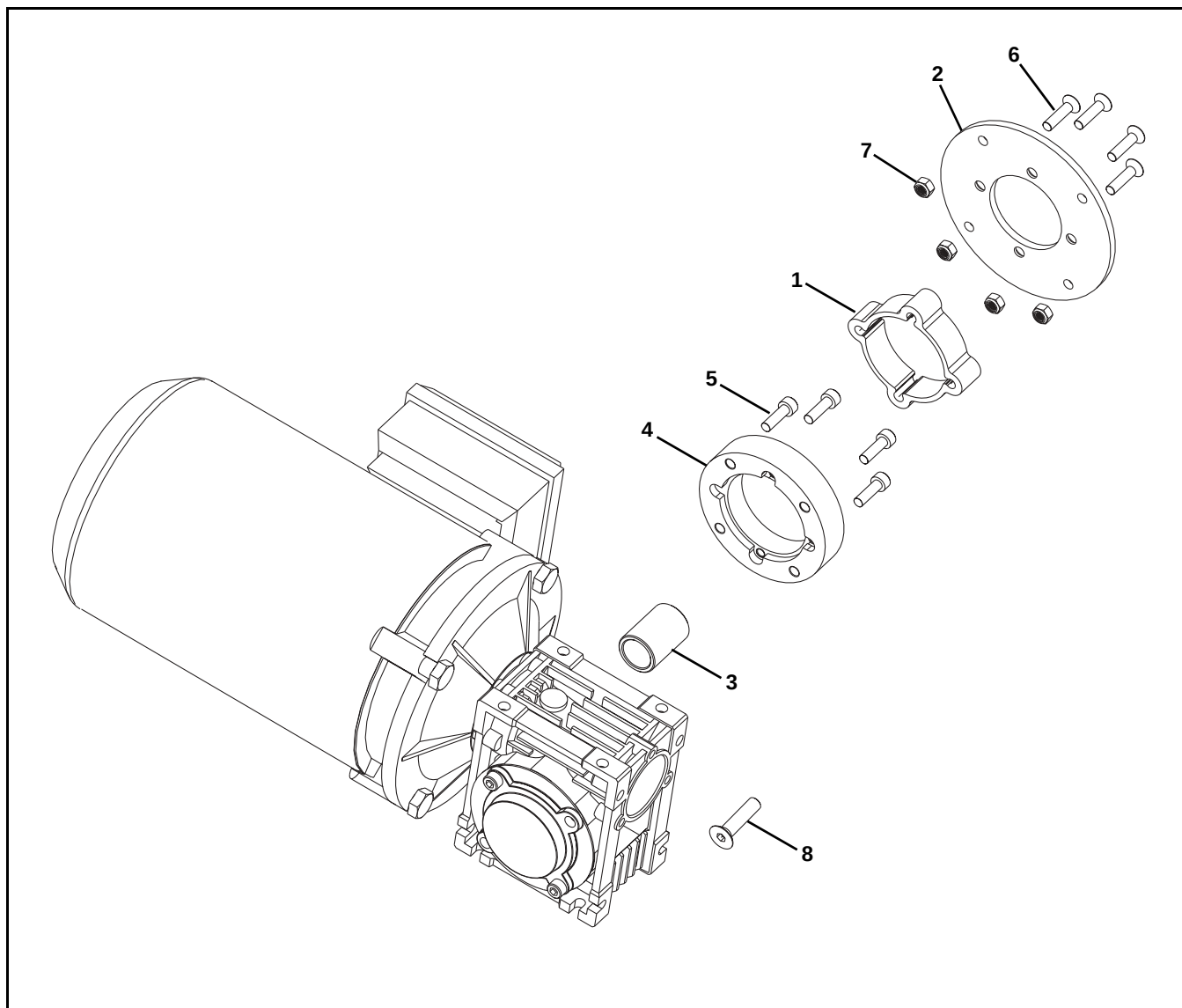
Service Parts

Connecting Assembly



Item	Part Number	Description
1	834-005	Connecting Bracket
2	970810M	Set Screw, M8-1.25 x 10 mm

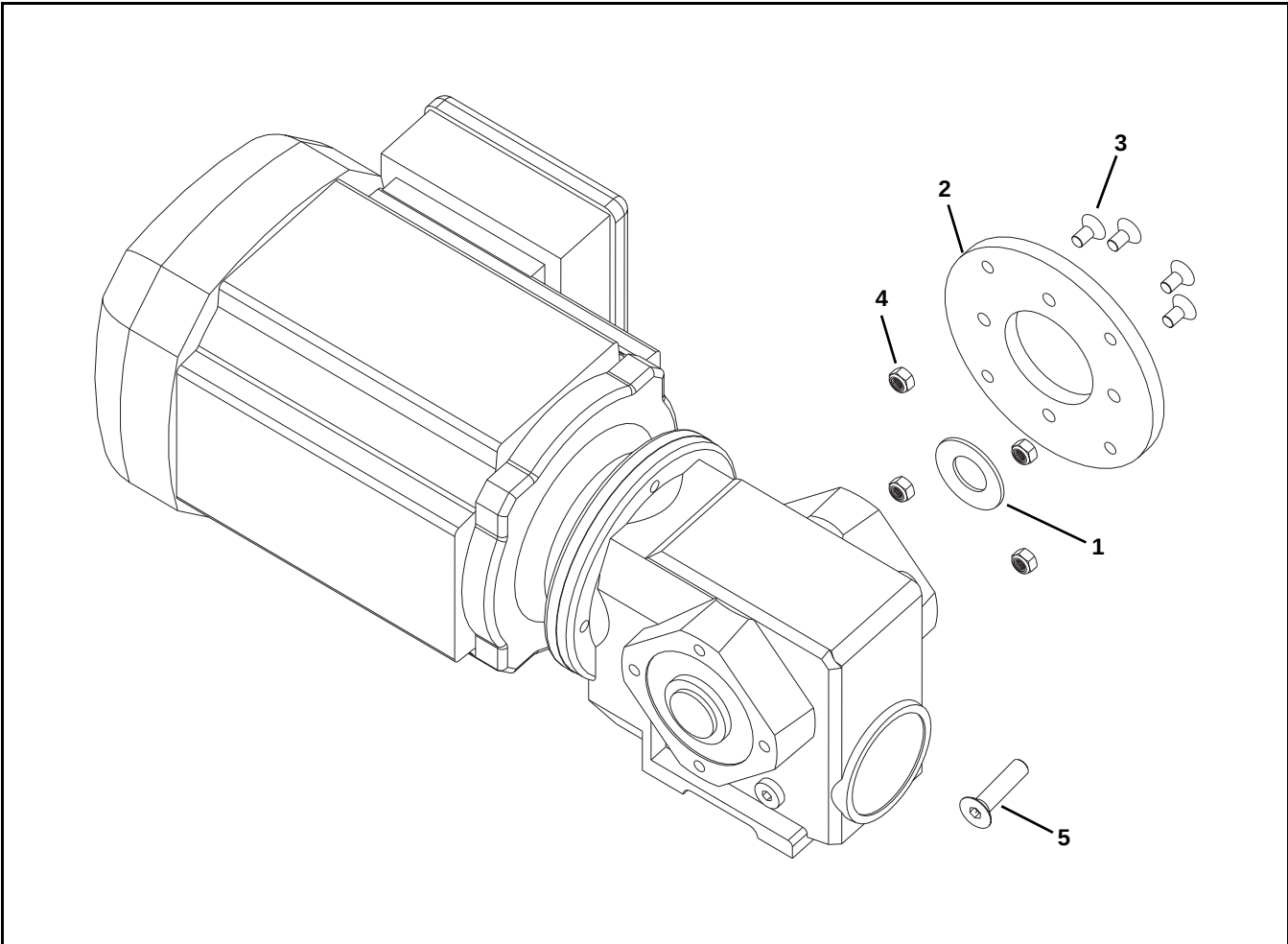
E-Drive and CE Gearmotor Mounting Package



Item	Part Number	Description
1	202270-00075	Extrusion
2	202971	Drive Plate
3	203065	Drive Spacer
4	350115	Adapter Ring
5	920620M	Socket Head Screw, M6-1.00 x 20 mm
6	930625M	Flat Head Screw, M6-1.00 x 25 mm
7	990602M	Hex Nut, M6-1.00
8	931025M	Flat Head Screw, M10-1.50 x 25 mm

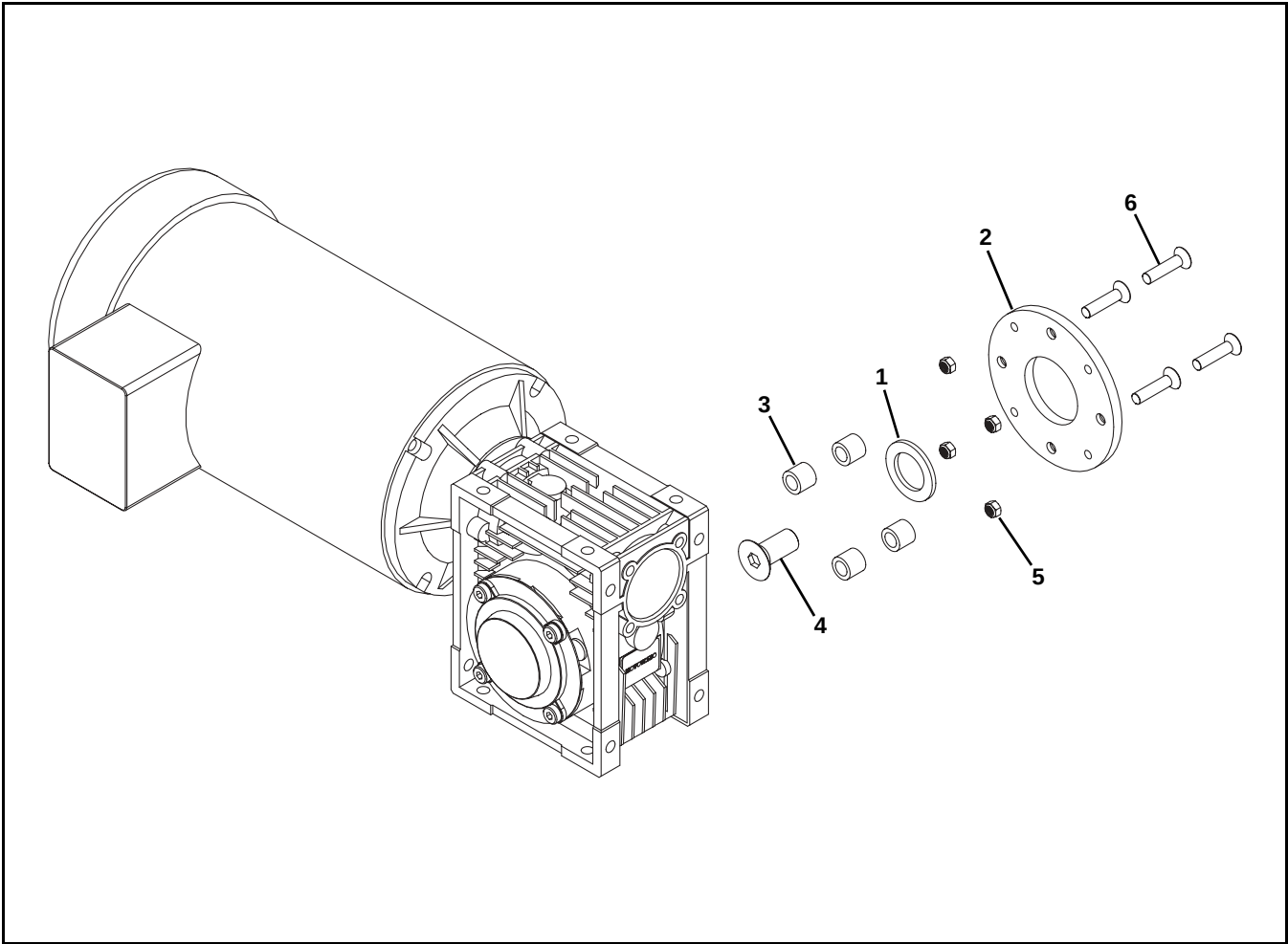
Service Parts

SEW Gearmotor Mounting Package



Item	Part Number	Description
1	807-3104	Shim
2	203043	Drive Plate
3	930612M	Flat Head Screw, M6-1.00 x 12 mm
4	990602M	Hex Nut, M6-1.00
5	931025M	Flat Head Screw, M10-1.50 x 25 mm

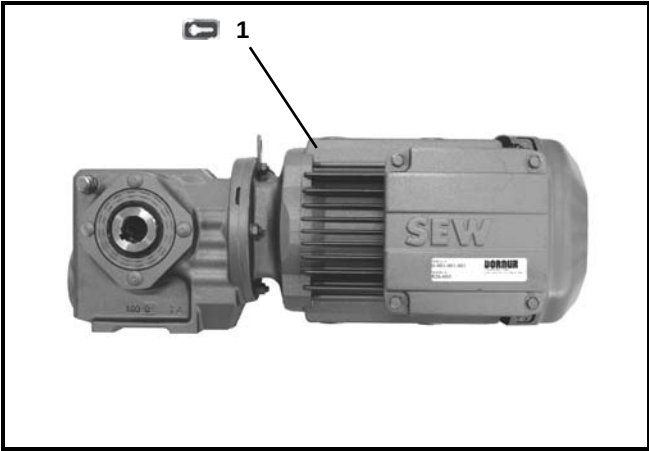
Heavy Load Gearmotor Mounting Package



Item	Part Number	Description
1	203844	Shim
2	203846	Drive Plate
3	352314	Spacer
4	931640M	Flat Head Screw, M16-2.0 x 40 mm
5	990602M	Hex Nut, M6-1.00
6	930835M	Flat Head Screw, M8-1.25 x 35 mm

Service Parts

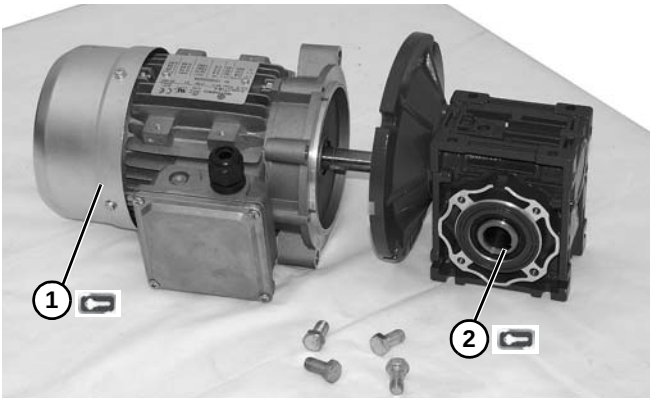
90° SEW Gearmotors



Item	Part Number	Description
1 	32M038WS423EN	Gearmotor, 0.80 Hp (0.37 Kw), 230/460 Volts, 37.7:1
	32M013WS423EN	Gearmotor, 0.75 Hp (0.56 Kw), 230/460 Volts, 13.4:1
	32M007WS423EN	Gearmotor, 1.00 Hp (0.75 Kw), 230/460 Volts, 6.8:1

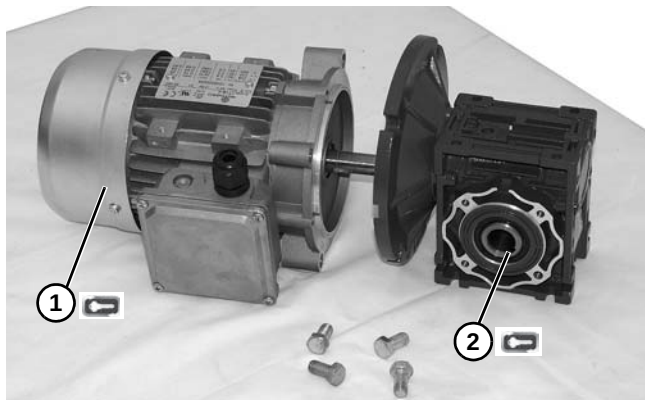
Standard Load 90° Industrial Gearmotors

U.S. Version



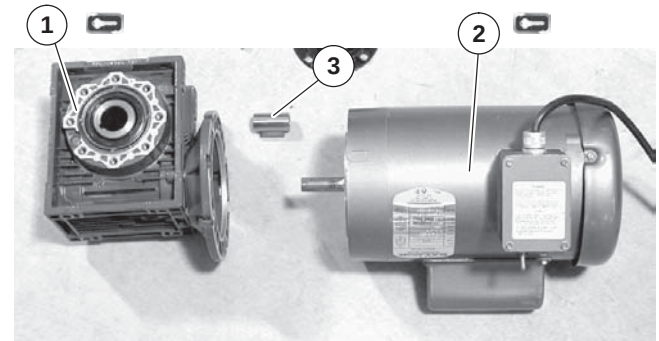
Item	Part No.	Description
1 	62MES411FN	Motor, 0.25hp (0.19Kw), 115/230 Volts, 60 Hz, 1-Phase
	62MES423FN	Motor, 0.25hp (0.19Kw), 208–230/460 Volts, 60 Hz, 3-Phase
	22MSD3DEN	Motor, 0.25hp (0.19Kw), 130 VDC
	62MEH411FN	Motor, 0.5hp (0.37Kw), 115/230 Volts, 60Hz, 1–Phase
	32MES423FN	Motor, 0.5hp (0.37Kw) 208–230/460 Volts, 60Hz, 3 Phase
	62MHD9DEN	Motor, 0.5hp (0.37Kw), 90 VDC
	32MES423EN	Motor, 0.5hp (0.37Kw), 230 Volts, 3 Phase Inverter Duty
	32MHD9DEN	Motor, 0.75 hp, (0.56Kw), 90 VDC
2 	32M005EL	Gear Reducer, 5:1, NEMA 42CZ
	32M010EL	Gear Reducer, 10:1, NEMA 42CZ
	32M020EL	Gear Reducer, 20:1, NEMA 42CZ
	32M040EL	Gear Reducer, 40:1, NEMA 42CZ
	32M060EL	Gear Reducer, 60:1, NEMA 42CZ
	32M005ES	Gear Reducer, 5:1, NEMA 56C
	32M010ES	Gear Reducer, 10:1, NEMA 56C
	32M020ES	Gear Reducer, 20:1, NEMA 56C
	32M040ES	Gear Reducer, 40:1, NEMA 56C
	32M060ES	Gear Reducer, 60:1, NEMA 56C
	32M010EH	Gear Reducer, 10:1, NEMA 140 TC

CE Version



Item	Part No.	Description
1	826-281	Motor, 0.19 kW 230 Volts, 1400 RPM 50 Hz, 1-Phase
	826-282	Motor, 0.37 kW 230 Volts, 1400 RPM 50 Hz, 1-Phase
	826-284	Motor, 0.19 kW 230/400 Volts, 1400 RPM 50 Hz, 3-Phase
	826-285	Motor, 0.37 kW 230/400 Volts, 1400 RPM 50 Hz, 3-Phase
2	62Z005ES	Gear Reducer, 5:1, 63 B5
	62Z010ES	Gear Reducer, 10:1, 63 B5
	62Z020ES	Gear Reducer, 20:1, 63 B5
	62Z040ES	Gear Reducer, 40:1, 63 B5
	62Z060ES	Gear Reducer, 60:1, 63 B5
	32Z005ES	Gear Reducer, 5:1, 71 B5
	32Z010ES	Gear Reducer, 10:1, 71 B5
	32Z020ES	Gear Reducer, 20:1, 71 B5

Heavy Load 90° Industrial Gearmotors



Item	Part No.	Part Description
1	32M008HH	Gear Reducer, 7.5:1 NEMA 140TC
	32M010HH	Gear Reducer, 10:1 NEMA 140TC
	32M015HH	Gear Reducer, 15:1 NEMA 140TC
	32M020HH	Gear Reducer, 20:1 NEMA 140TC
	32M025HH	Gear Reducer, 25:1 NEMA 140TC
	32M030HH	Gear Reducer, 30:1 NEMA 140TC
	32M040HH	Gear Reducer, 40:1 NEMA 140TC
	32M050HH	Gear Reducer, 50:1 NEMA 140TC
	32M060HH	Gear Reducer, 60:1 NEMA 56C
	32M080HH	Gear Reducer, 80:1 NEMA 56C
	32M100HH	Gear Reducer, 100:1 NEMA 56C
2	62MS411FN	Motor, 0.25hp (0.19Kw), 115/230 Volts, 60 Hz, 1-Phase
	62MH411	Motor, 0.5hp (0.37Kw), 115/230 Volts, 60Hz, 1-Phase
	62MH423	Motor, 0.5hp (0.37Kw) 208-230/460 Volts, 60Hz, 3 Phase
	32MHH423FN10	Motor, 1 hp (0.75Kw), 230 Volts, 3 Phase
	32MS423EN	Motor, 0.5hp (0.37Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423EN10	Motor, 1hp (0.75Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423EN15	Motor, 1.5hp (1.1Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423FN15	Motor, 1.5hp (1.1Kw), 230 Volts, 3 Phase
	62MHD9DEN	Motor, 0.5hp (0.37Kw), 90 Volts DC,
	62MHD9DEN75	Motor, 0.75hp (0.56Kw), 90 Volts DC,
	32MHH423EN20	Motor, 2.0hp (1.5Kw), 230 Volts, 3 Phase Inverter Duty
	32MHH423FN20	Motor, 2.0hp (1.5Kw), 230 Volts, 3 Phase
	32MHH411EC10	Motor, 1.0hp (0.75Kw), 115 Volts, Integrated Controller
	32MHH411EC15	Motor, 0.5hp (0.37Kw), 115 Volts, Integrated Controller
3	820-329	Bushing Shaft Adapter, 56C to 140TC

Service Parts

Wear Strip

Item	Part No.	Description
1	834-FASR-25U	Standard Low Friction UHMW (sold per foot)
	834-FASR-25A	Special Conductive (sold per foot)
	834-FASR-25X	Special HI Speed (sold per foot)
	834-FASR-25P	Special Abrasive Resistant (sold per foot)

Ordering a Replacement Chain

Determine the length of the chain required for the conveyor and round up to the next foot length. Order the proper number of chain repair kits (1' long each) for your conveyor. Dorner will ship chain kits that are of reasonable length fully assembled.

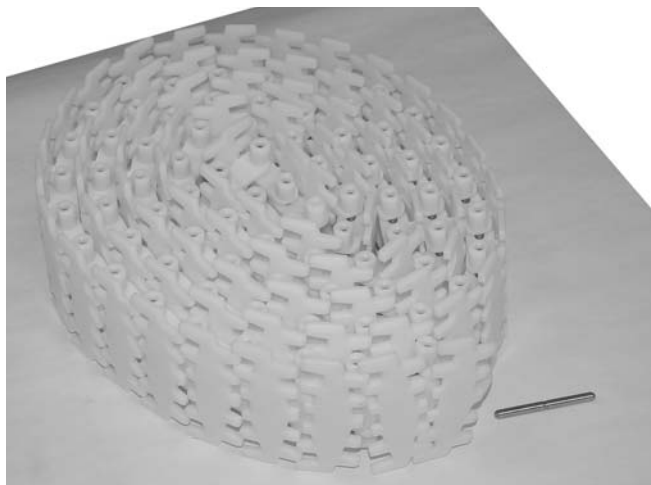
Example:

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

Order Qty (43) of 834-0 W I

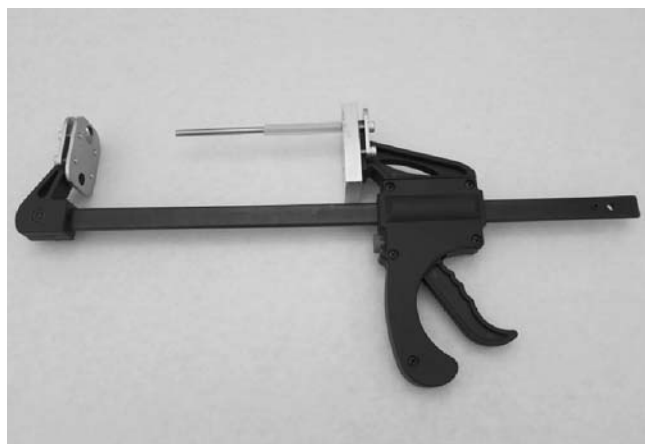
W = Width (2=65, 4=105 & 6=150 width conveyors)

I = Chain type (2=Low Friction, 3=Friction Insert Chains)



Item	Part Number	Description
1 	834-0 <u>WT</u>	Chain Repair Kit (Includes 1 ft (305 mm) of chain and assembly pins)
<u>W</u> = Width (2=65, 4=105 & 6=150 width conveyors)		
<u>I</u> = Chain type (2=Low Friction, 3=Friction Insert Chains)		

Belt Removal Tool



Item	Part Number	Description
1	203480	Belt Removal Tool

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.



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

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

Outside the USA:
TEL 1-262-367-7600
FAX 1-262-367-5827