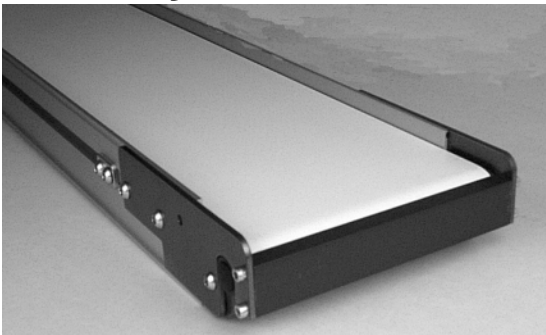
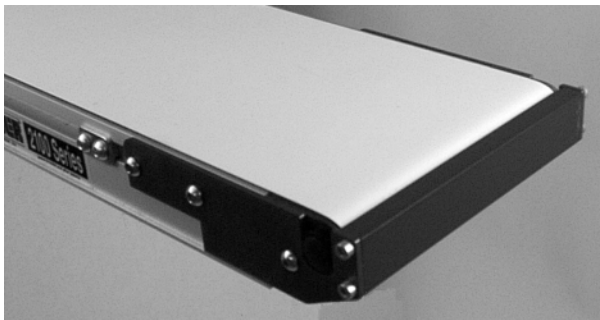


**Pulley Transfer Plates  
for 2100 Series Conveyors**





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## Warnings – General Safety



	<b>WARNING</b>	
<p>The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.</p>		

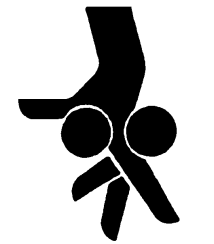

	 <b>DANGER</b>
<p>Climbing, sitting, walking or riding on conveyor will cause severe injury. <b>KEEP OFF CONVEYORS.</b></p>	

	 <b>DANGER</b>
<p><b>DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.</b></p>	

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

	 <b>WARNING</b>
<p>Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.</p> <p>When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, <b>CHECK FOR POTENTIAL PINCH POINTS</b> and other mechanical hazards before system start-up.</p>	

	 <b>WARNING</b>
<p>Exposed moving parts can cause severe injury. <b>REPLACE ALL GUARDS BEFORE RUNNING CONVEYOR.</b></p>	

	 <b>DANGER</b>
<p>Use of transfer plate with high friction conveyor belt will cause severe injury. <b>DO NOT</b> use transfer plate with /03, /08, /55, /62, /64, or other high friction belts.</p>	

## Introduction

**IMPORTANT:** Some illustrations may show guards removed. Do NOT operate equipment without guards.

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 2100 Series conveyors are covered by Patent No. 5,174,435, 5,131,529 and corresponding patents and patent applications in other countries.

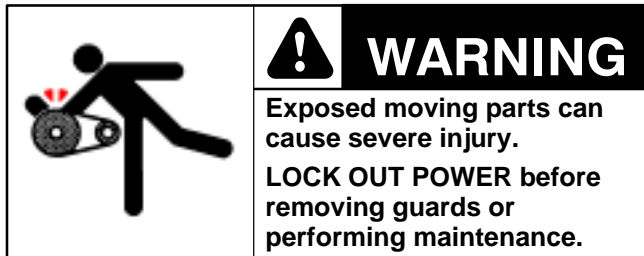
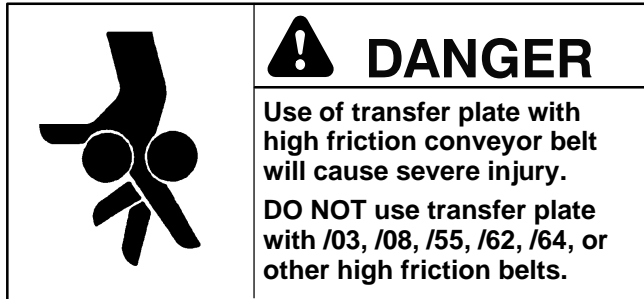
Dorner's Limited Warranty applies.

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

## Required Tools

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

## Low-side Conveyor Mounting



1. Gather components (Figure 1)

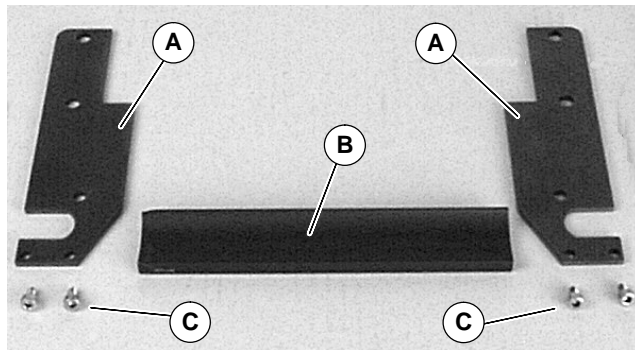


Figure 1

Illustration References	
A	Transfer (Tail) Cover Plate (Low Side) (2x)
B	Transfer Plate
C	M4 x 8 mm Socket Head Screw (4x)

2a. Loosen two (2) screws (E of Figure 2).

2b. Rotate cam so slot (D) is horizontal and pointing at tail cover plate.

2c. While holding cam plate assembly (F) against tail cover plate, tighten two (2) screws (E) to 71 in-lb (8 Nm).

2d. Repeat step 2a, 2b and 2c for other side of conveyor.

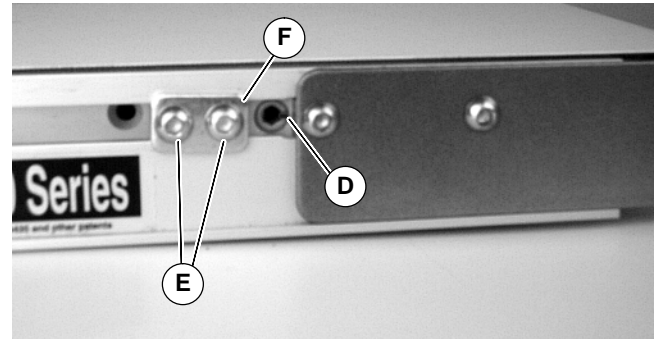


Figure 2

3. If installing on drive end, remove gearmotor mounting package. See mounting package instructions for details.

4. Remove screws (K & L of Figure 3). Remove and discard existing cover plates (J).

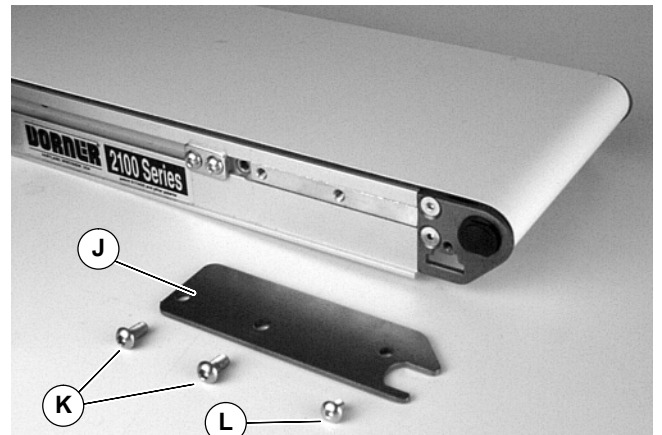


Figure 3

5. Install transfer cover plates (A of Figure 4) using original screws (K & L of Figure 3).

- Tighten screws (K) to 71 in-lb (8 Nm)
- Tighten screws (L) to 28 in-lb (3 Nm)

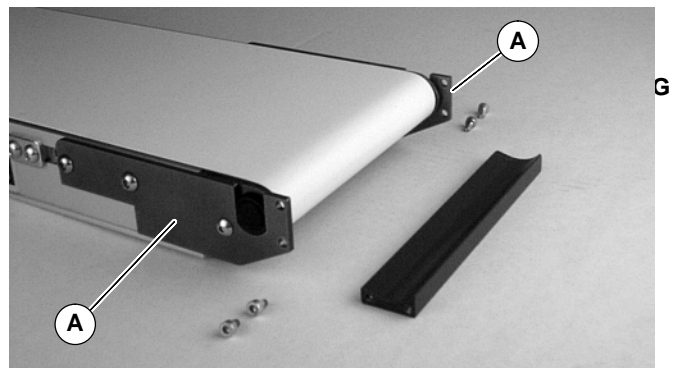


Figure 4

# Installation

- Install transfer plate (B of Figure 5) with the wide side up (see detail). While maintaining clearance between transfer plate and conveyor belt, tighten screws (C) to 36 in-lb (4 Nm).

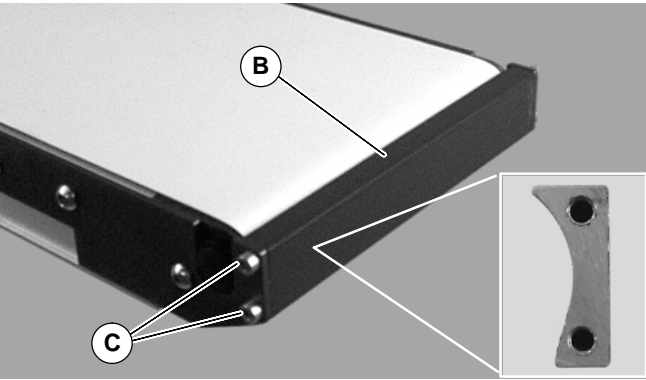


Figure 5

- If transfer plate is installed on drive end, replace gearmotor mounting package. See mounting package instructions for details.

## High-side Conveyor Mounting

	<div data-bbox="354 1003 722 1073"> <b>DANGER</b> </div> <div data-bbox="354 1083 722 1270"> <p>Use of transfer plate with high friction conveyor belt will cause severe injury.</p> <p><b>DO NOT</b> use transfer plate with /03, /08, /55, /62, /64, or other high friction belts.</p> </div>
	<div data-bbox="354 1323 722 1392"> <b>WARNING</b> </div> <div data-bbox="354 1402 722 1554"> <p>Exposed moving parts can cause severe injury.</p> <p><b>LOCK OUT POWER</b> before removing guards or performing maintenance.</p> </div>

- Gather components (Figure 6)

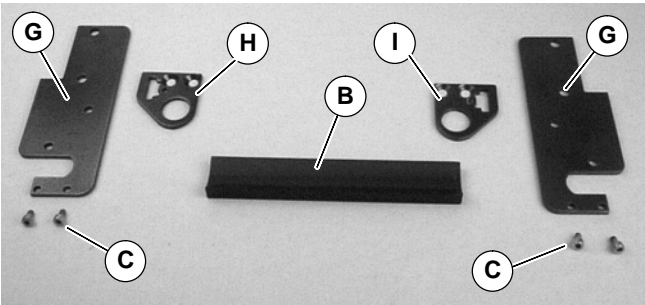


Figure 6

Illustration References	
B	Transfer Plate
C	M4 x 8 mm Socket Head Screw (4x)
G	Transfer (Tail) Cover Plate (High Side) (2x)
H	Pulley Tail Plate (LH)
I	Pulley Tail Plate (RH)

- Release conveyor belt tension (Figure 7). See 2100 Series manual for details.



Figure 7

- If installing on drive end, remove gearmotor mounting package. See mounting package instructions for details.

4. Remove screws (K & L of Figure 8). Remove and discard existing cover plates (M).

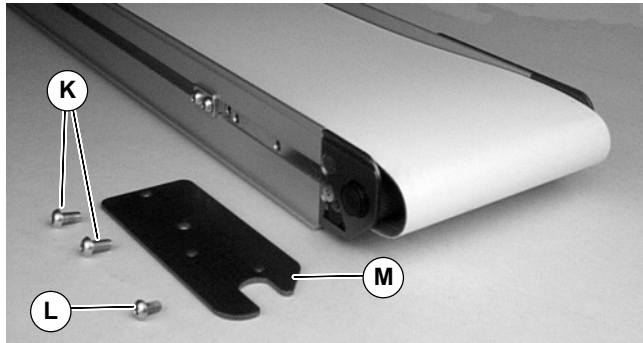


Figure 8

5. Remove and discard existing left (N of Figure 9) and right (P) pulley tail plates. Remove and retain bottom wiper (Q).

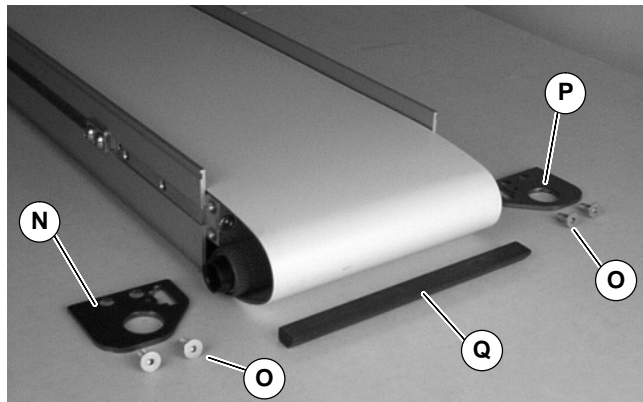


Figure 9

6. Install new left (H of Figure 10) and right (I) pulley tail plates using original screws (O of Figure 9). Tighten screws to 35 in-lb (4 Nm). Re-install bottom wiper (Q of Figure 9).

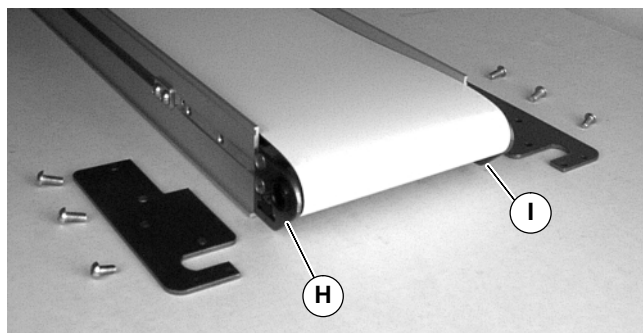


Figure 10

7. Loosely install transfer cover plates (G of Figure 11) using original screws (K & L).

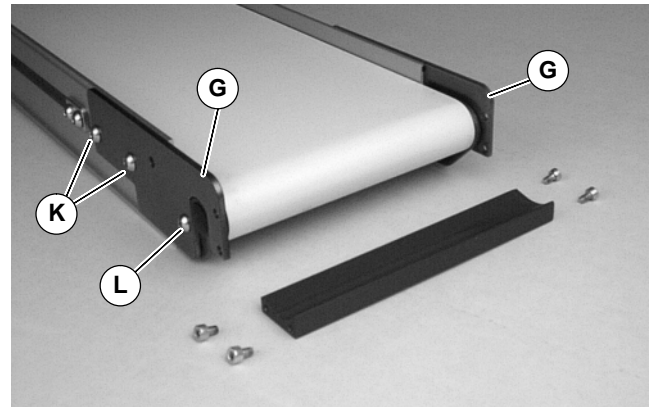


Figure 11

8. Re-tension and track conveyor belt. See 2100 Series manual for details.

- Tighten screws (K) to 71 in-lb (8 Nm)
- Tighten screws (L) to 28 in-lb (3 Nm)

9. Install transfer plate (B of Figure 12) with the wide side up (see detail). While maintaining clearance between transfer plate and conveyor belt, tighten screws (C) to 36 in-lb (4 Nm).

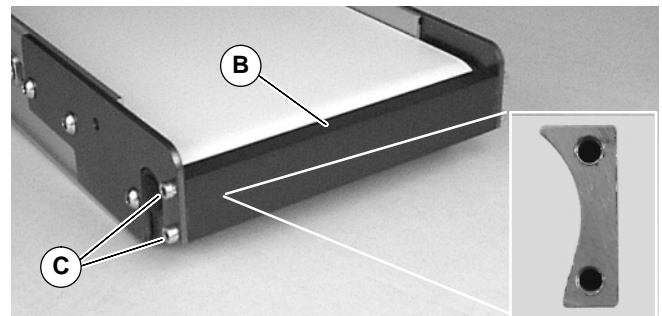


Figure 12

10. If transfer plate is installed on drive end, replace gearmotor mounting package. See mounting package instructions for details.

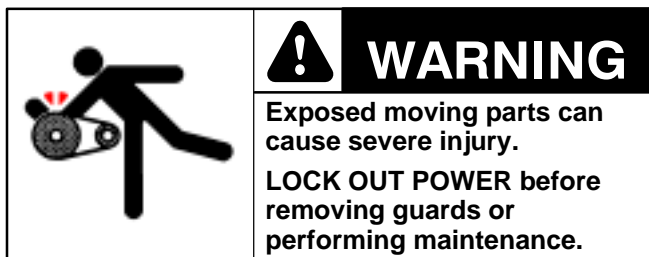


# Preventive Maintenance & Adjustment

## Required Tools

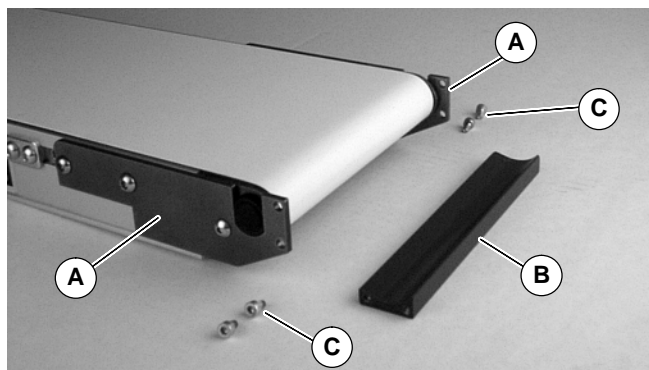
- Hex key wrenches:  
3 mm, 4 mm, 5 mm
- Torque wrench

## Cleaning



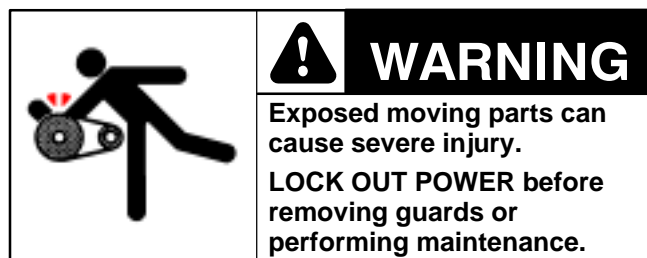
**NOTE:** Low side conveyor shown; high side similar.

Periodically, remove four (4) screws (C of Figure 13) and remove transfer plate (B). Clean any debris from between plate and conveyor belt. Replace transfer plate (B). See steps 6 and 7 on page 4.



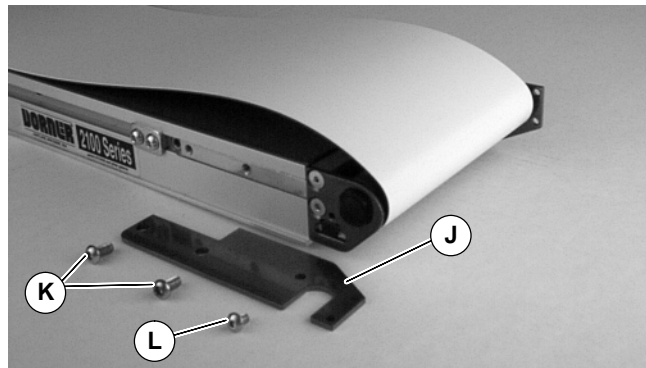
**Figure 13**

## Conveyor Belt Replacement



**NOTE:** Low side conveyor shown; high side similar.

1. Remove four (4) screws (C of Figure 13) and remove transfer plate (B).
2. On side opposite gearmotor, remove two (2) screws (K of Figure 14), screw (L) and transfer cover plate (J).

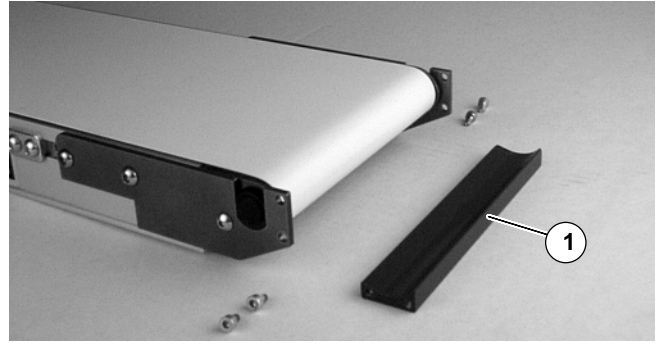


**Figure 14**

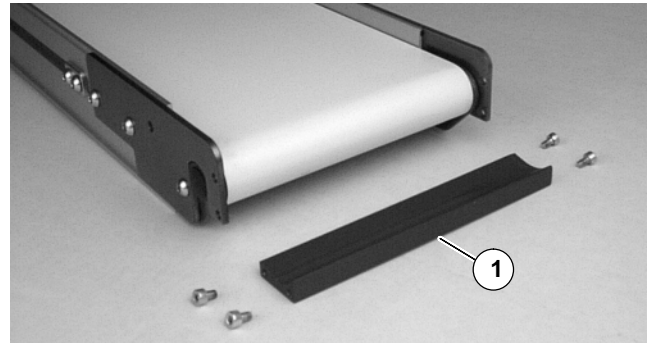
3. Remove and replace conveyor belt. See 2100 Series manual for details.
4. Replace transfer cover plate and tighten screws (K & L of Figure 14).
  - Tighten screws (K) to 71 in-lb (8 Nm)
  - Tighten screws (L) to 28 in-lb (3 Nm)
5. Replace transfer plate (B of Figure 13). See steps 6 and 7 on page 4.

**NOTE:** For replacement parts other than those shown on this page, contact an authorized Dorner Service Center or the factory.

Item	Part No.	Part Description
1	2631WWM	Transfer Plate (for low side conveyor, Figure 15 or high side conveyor, Figure 16)
WW = conveyor width reference		



**Figure 15**



**Figure 16**

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## Return Policy

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No returns will be accepted without prior written factory authorization. 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. 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.

A representative will discuss action to be taken on the Returned items and provide a Returned Goods Authorization Number to reference.

There will be a 15% restocking charge on all new items returned for credit where Dorner was not at fault. These will not be accepted after 60 days from original invoice date. The restocking charge covers inspection, cleaning, disassembly, and reissuing 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. Feel free to contact Dorner for the name of your local representative. Our technical sales and service staff will gladly help with your questions on Dorner products.

For a copy of Dorner's Limited Warranty, contact factory, distributor, service center or visit our website @ [www.dorner.com](http://www.dorner.com)

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

**DORNER<sup>®</sup>**

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