



# 5200 Series Curved End Drive Conveyors

Installation, Maintenance and Parts Manual



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## Introduction

**⚠ CAUTION**

**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.

The Dorner Limited Warranty applies.

Dorner 5200 Series conveyors have patents pending.

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

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 .


# Warnings – General Safety

**⚠ DANGER**



**SEVERE HAZARD!**  
**KEEP OFF CONVEYORS.** Climbing, sitting, walking or riding on conveyor will result in death or serious injury.


**⚠ DANGER**



**EXPLOSION HAZARD!**

- **DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.** The electric gearmotor generates heat and could ignite combustible vapors.
- Failure to comply will result in death or serious injury.

**⚠ WARNING**



**CRUSH HAZARD!**

- **DO NOT** place hands or fingers inside the conveyor while it is running.
- **DO NOT** wear loose garments while operating the conveyor. Loose garments can become caught up in the conveyor.
- Failure to comply could result in serious injury.

**⚠ WARNING**



**CRUSH HAZARD!**


- **SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.**
- Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing serious injury.

**⚠ WARNING**




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

**⚠ WARNING**




**BURN HAZARD!**  
**DO NOT TOUCH** the motor while operating, or shortly after being turned off. Motors may be **HOT** and can cause serious burn injuries.

**⚠ WARNING**



**PUNCTURE HAZARD!**  
Handle drive shaft keyway with care. It may be sharp and could puncture the skin, causing serious injury.

**⚠ WARNING**



**SEVERE HAZARD!**

- 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.
- Failure to comply could result in serious injury.

# Product Description

Refer to (Figure 1) for typical conveyor components.

Typical Components	
1	Conveyor
2	Gearmotor
3	Belt
4	Support Stands
5	Motor Controller
6	Drive End
7	Idler End

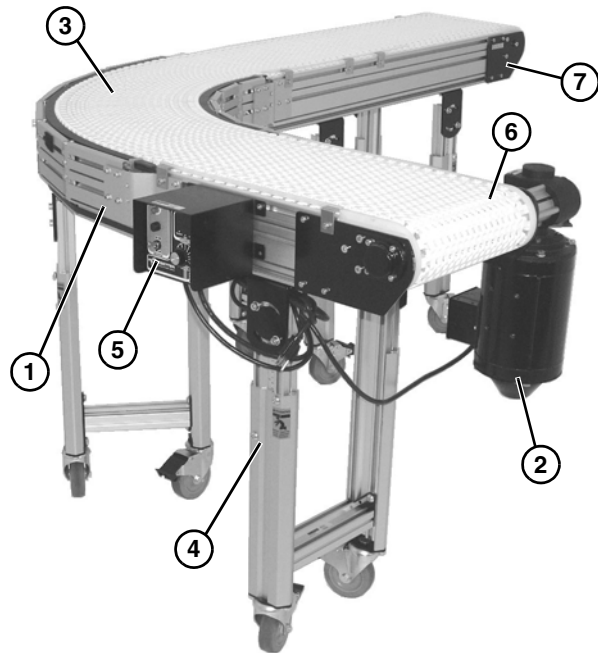


Figure 1

# Specifications

Conveyor Width Reference ( <u>WW</u> )	08 – 36 in 02 increments
Conveyor Belt Width	8" (203 mm) - 36" (914 mm) in 2" (51 mm) increments
Maximum Conveyor Load	20 lbs. / ft <sup>2</sup> (97 kg/ m <sup>2</sup> ) with a maximum of 500 lbs. (227 kg)
Belt Travel	12" (305 mm) per revolution of pulley
Maximum Belt Speed	250 ft/minute (76 m/minute)
Conveyor Length Reference ( <u>LLL</u> )	036 – 999 in 001 increments
Conveyor Length	36" (914 mm) - 999" (25.4 m) in 1" (25 mm) increments

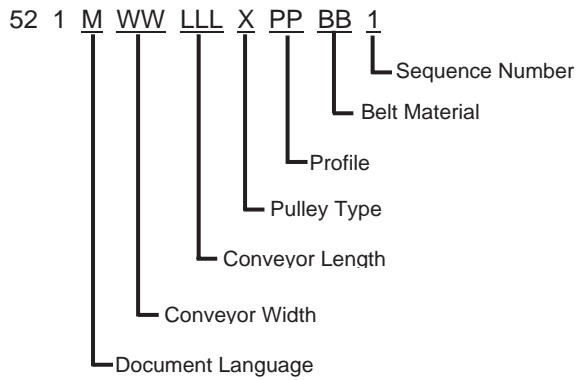
## IMPORTANT

*Maximum conveyor loads are based on:*

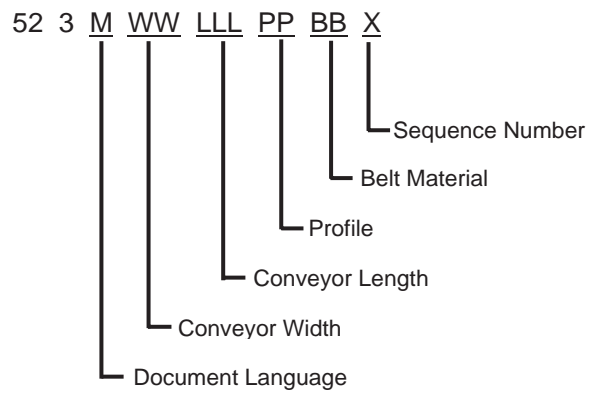
- *Non-accumulating product*
- *Product moving toward gearmotor*
- *Conveyor being mounted horizontally*
- *Conveyor being located in a dry environment*
- *Conveyor equipped with standard belt only*

## 5200 Series Curve Conveyor Modules

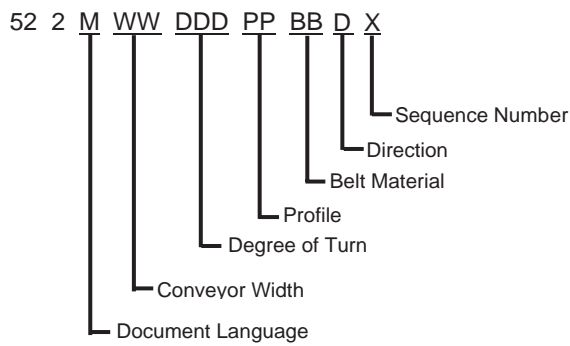
### 5200 Series Infeed / Idler Module



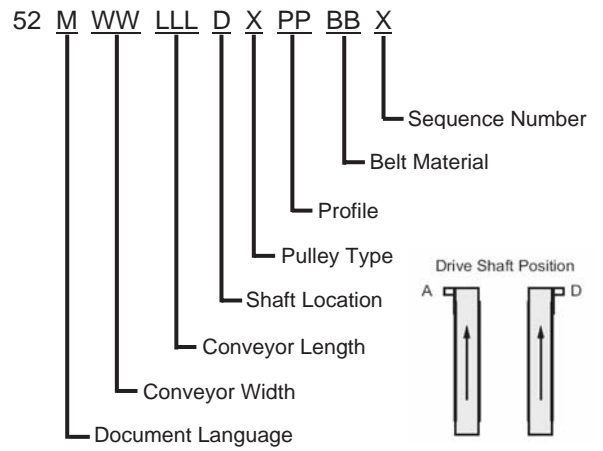
### 5200 Series Intermediate Module



### 5200 Series Curve Module



### 5200 Series Exit / Drive Module



# Specifications

## Conveyor Supports

### Infeed / Idler Module:

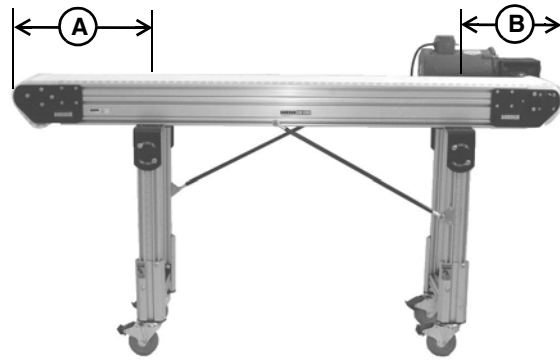
- “A” = 3 ft (914 mm) maximum (See **Figure 2**)
- Modules 24” - 47” long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, plus an additional support stand at each straight section break (over 13’ straight frame module)

### Intermediate Module:

- Modules 24” - 59” long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, plus an additional support stand at each straight section break (modules over 13’)

### Exit / Drive Module:

- “B” = 3 ft (914 mm) maximum (See **Figure 2**)
- Modules 24” - 47” long get 1 support stand
- All other lengths get 2 support stands, evenly spaced, plus an additional support stand at each straight section break (modules over 13’)



**Figure 2**

### Curve Module:

- Reference chart for support stand quantities, evenly spaced along curve (See **Figure 3**)

Width Degree	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"
15°	0	0	0	0	0	0	0	0	0	0	0	0	0	1	1
30°	0	0	0	0	0	1	1	1	1	1	1	1	1	1	1
45°	0	0	1	1	1	1	1	1	1	1	1	1	1	1	1
60°	0	1	1	1	1	1	1	1	1	1	1	1	1	1	1
75°	1	1	1	1	1	1	1	1	1	1	1	1	1	2	2
90°	1	1	1	1	1	1	1	1	1	1	2	2	2	2	2
105°	1	1	1	1	1	1	1	1	2	2	2	2	2	2	2
120°	1	1	1	1	1	1	1	2	2	2	2	2	2	2	2
135°	1	1	1	1	1	1	2	2	2	2	2	2	2	3	3
150°	1	1	1	1	1	2	2	2	2	2	2	3	3	3	3
165°	1	1	1	1	2	2	2	2	2	2	3	3	3	3	3
180°	1	1	1	2	2	2	2	2	2	3	3	3	3	3	3

**Figure 3**

## CAUTION

Conveyor **MUST** be mounted straight, flat and level within confines of conveyor. Use a level (Figure 4, item 1) during setup.

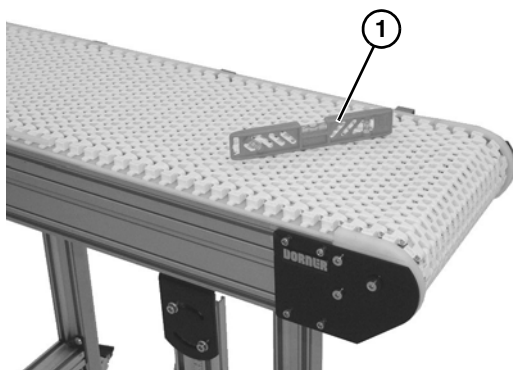


Figure 4

## Required Tools

- Level
- Torque wrench
- 4 mm hex wrench
- 5 mm hex wrench

## Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to “Conveyors Longer than 12 ft (3658 mm)” on page 7 or “All Conveyors” on page 8.
2. Attach the stands. Refer to “Stand Installation” on page 10.
3. Install the gearmotor. Refer to “Drive Package Installation” on page 10.

## Conveyors Longer than 12 ft (3658 mm)

### Frame Connecting Components

Typical Frame Connecting Components (Figure 5)

- |   |                                       |
|---|---------------------------------------|
| 1 | Bar Frame Connector                   |
| 2 | Drop-in Tee Bar                       |
| 3 | Conveyor frames                       |
| 4 | Plate Frame Connector                 |
| 5 | Low Head Cap Screw, M6 - 1.00 x 12 mm |
| 6 | Washer                                |
| 7 | Socket Head Screw, M6 - 1.00 x 20 mm  |

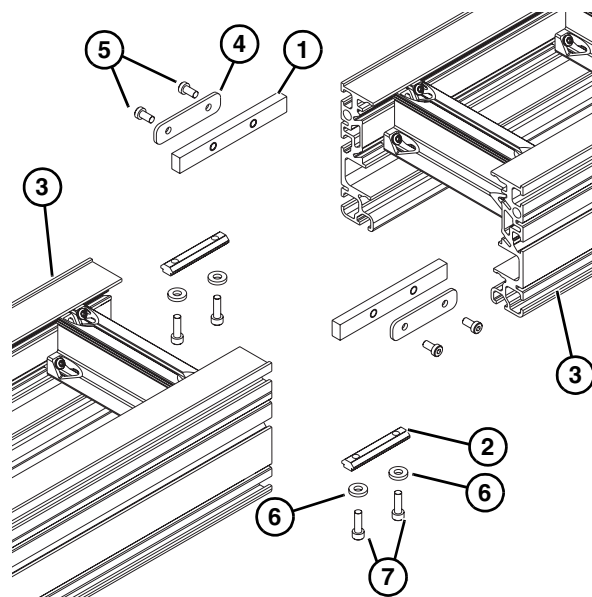


Figure 5

1. Install two bar frame connectors (Figure 5, item 1) and two drop-in tee bars (Figure 5, item 2) into one conveyor section (Figure 5, item 3).
2. Join both conveyor sections, and install plate frame connectors (Figure 5, item 4), and secure with M6x12 low head cap screws (Figure 5, item 5) on both sides. Tighten cap screws to 60 in-lb (7 Nm).
3. Install washers (Figure 5, item 6) and M6x20 socket head screws (Figure 5, item 7) into drop-in tee bar (Figure 5, item 2) on both sides as indicated. (Do not tighten hardware. This is for stand installation.)

## NOTE

The stop plate (Figure 6, item 1) on the center wear strip (Figure 6, item 2) faces the drive end (Figure 6, item 3) of the conveyor.

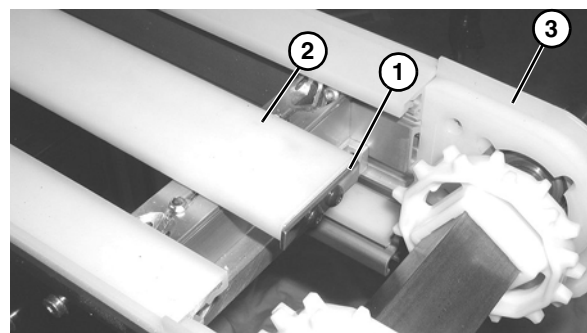


Figure 6



# Installation

## All Conveyors

### Curve Connecting Components

Typical Curve Connecting Components (Figure 7)

1	Offset Connecting Plate, Left
2	Offset Connecting Plate, Right
3	Curved Section
4	Drop-in Tee Bar
5	Socket Head Screw, M6 - 1.00 x 16 mm
6	Straight Section

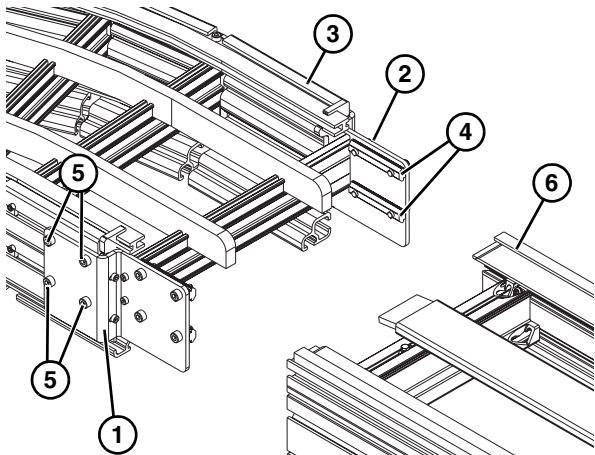


Figure 7

1. For joining curved to straight sections, install left offset connecting plate (Figure 7, item 1) and right connecting plate (Figure 7, item 2) onto curved section (Figure 7, item 3) with two drop-in tee bars (Figure 7, item 4) and four M6x16 socket head screws (Figure 7, item 5), making sure the straight frame section is flush to the curve section crossmember.
2. Secure straight section (Figure 7, item 6) onto curved section with the same hardware as previous step. Tighten all socket head screws to 60 in-lb (7 Nm).

#### NOTE

The bottom of the straight frame sections (Figure 8, item 1) and curve frame sections (Figure 8, item 2) must be level.

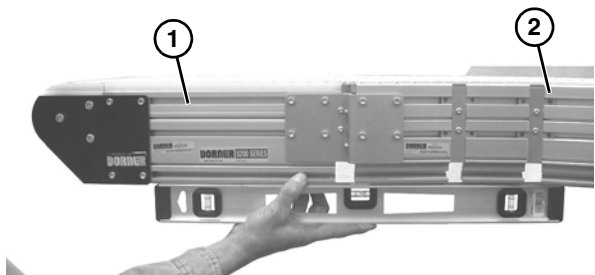


Figure 8

### Belt Installation

Typical Belt Components (Figure 9)

1	Chain Belt
2	Belt Rod

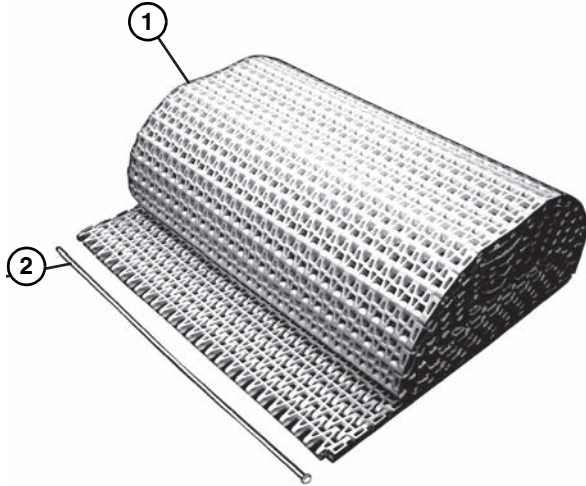


Figure 9

#### NOTE

Ensure the belt is running in the correct direction, with hole (Figure 10, item 1) towards conveyor motor.

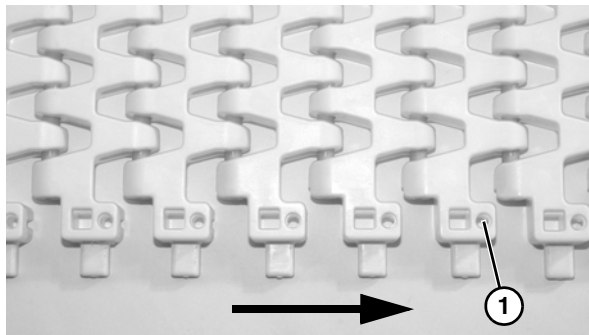


Figure 10

1. Position the belt on the conveyor frame (Figure 11).

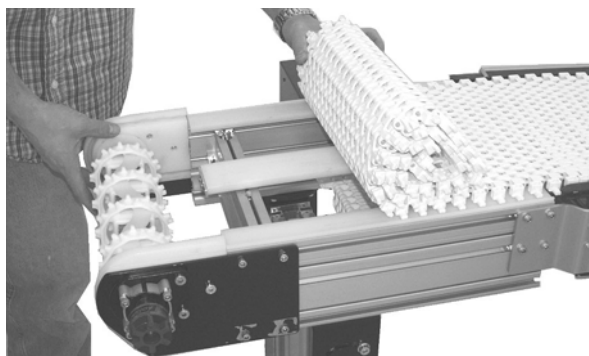
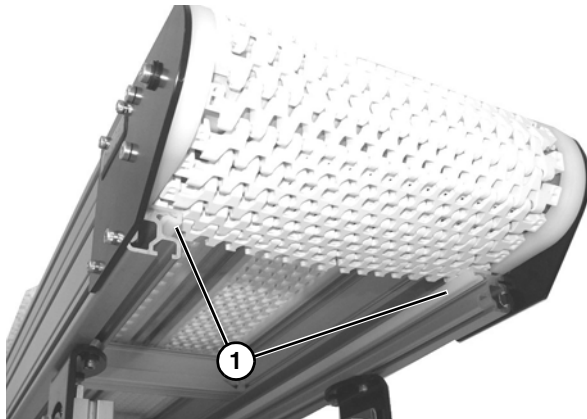


Figure 11



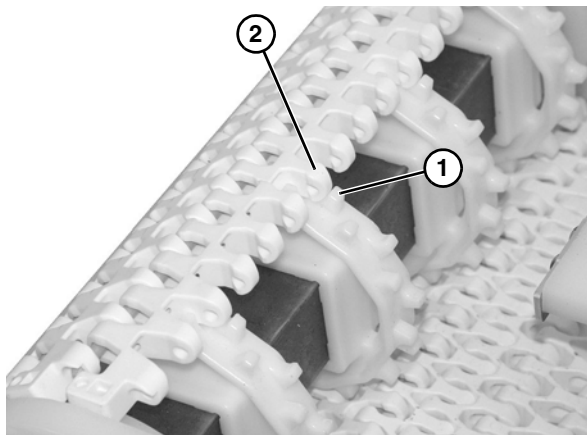
# Installation

2. Wrap belt around idler tail.
3. Install belt around lower frame section and above lower wear strips (**Figure 12, item 1**).



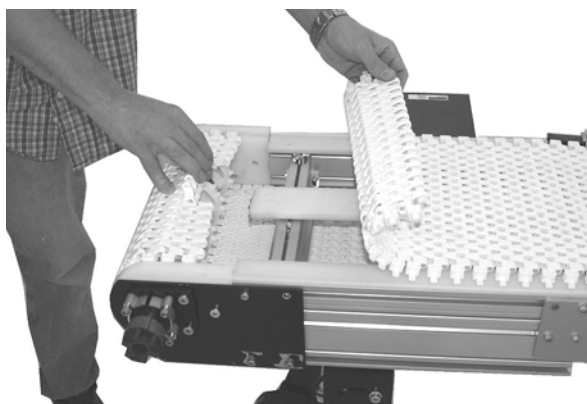
**Figure 12**

4. Wrap the belt around the drive end of the conveyor, making sure the sprocket teeth have engaged the belt, with concave teeth (**Figure 13, item 1**) mating with rounded section (**Figure 13, item 2**) of belt.



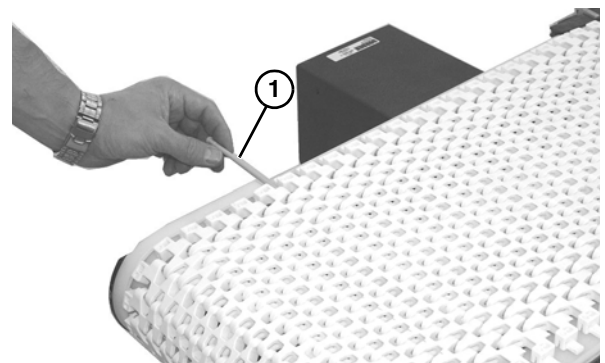
**Figure 13**

5. Feed the ends of the belt through the top and bottom of the curved frame sections.
6. Bring the ends of the belt together (**Figure 14**).



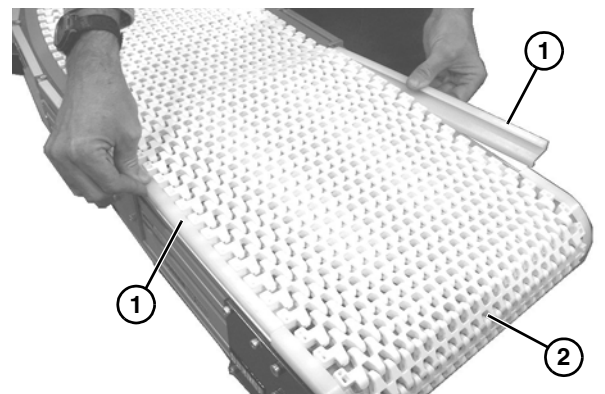
**Figure 14**

7. Insert the belt rod (**Figure 15, item 1**).



**Figure 15**

8. Push the belt rod in as far as possible.
9. Lightly tap the head of the rod with a hammer until it snaps into position.
10. Slide the top wear strips (**Figure 16, item 1**) with wide lip facing up, under the conveyor belt (**Figure 16, item 2**) catching the bottom lip on conveyor frame, to cover the belt tabs.



**Figure 16**

 <b>WARNING</b>

<b>CRUSH HAZARD!</b> Failure to install the top wear strip in the proper orientation will result in a belt pinch point. Exposed moving parts can cause serious injury.

# Installation

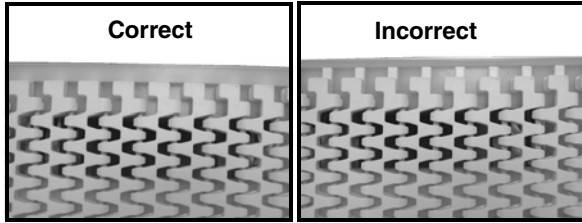


Figure 17

## NOTE

Top wear strips are left loose to facilitate ease of belt installation and/or removal.

## Stand Installation

## NOTE

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

Typical stand components (Figure 18)

1	Conveyor Frame
2	Stand
3	M6 - 1.0 x 20 mm socket head cap screws (x4)

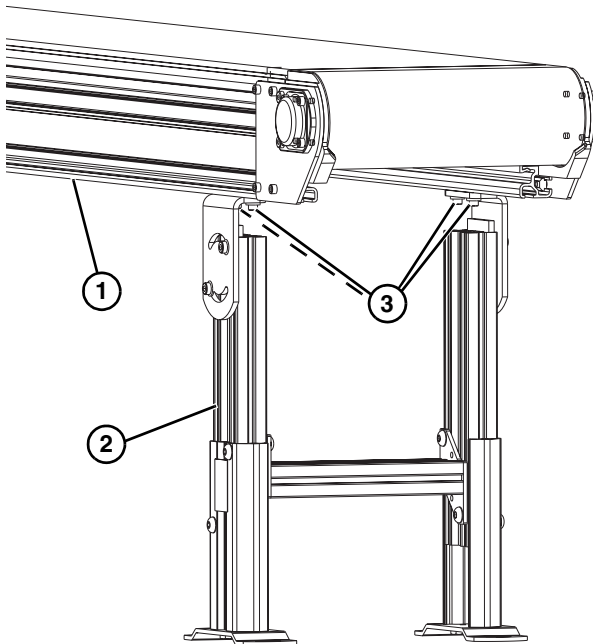


Figure 18

1. Properly support the conveyor.

2. Attach stands (Figure 19, item 1) to the bottom of the conveyor frame (Figure 19, item 2). Tighten socket head screws (Figure 19, item 3), on each side, to secure in place.

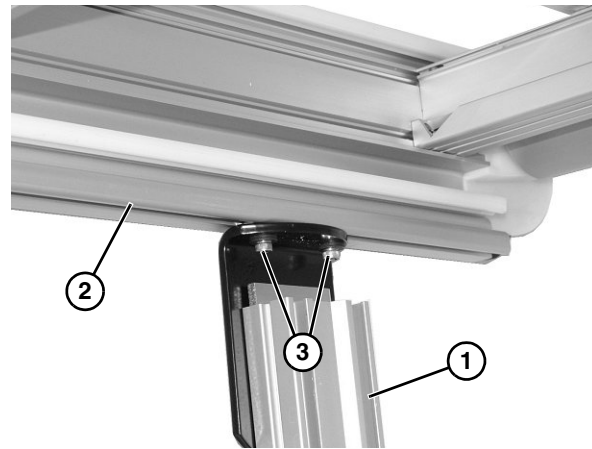


Figure 19

## Drive Package Installation

## NOTE

For detailed assembly instructions, refer to the appropriate Drive Packages Installation, Maintenance and Parts Manual.

1. Attach the motor (Figure 20, item 1) to the gear reducer (Figure 20, item 2).

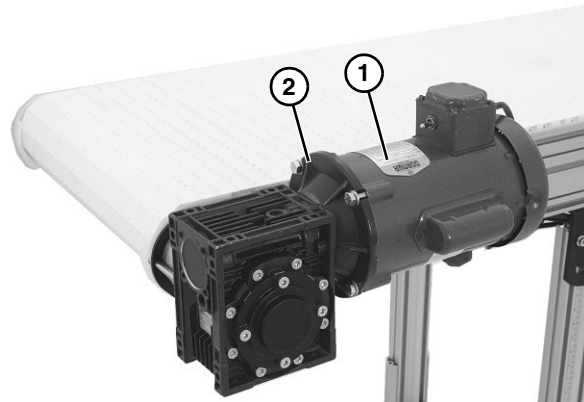


Figure 20

# Preventive Maintenance and Adjustment

## Required Tools

- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- Punch and hammer (to remove belt rod)

## Checklist

- Keep service parts on hand. Refer to the "Service Parts" section starting on page 20 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](http://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 to push the belt rod (Figure 21, item 1) out by striking the rod end opposite the retaining head.

### 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.

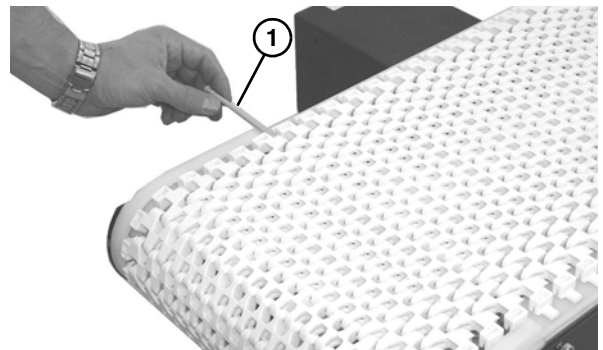


Figure 21

3. Replace old section of belt.

### CAUTION

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

# Preventive Maintenance and Adjustment

## Replacing the Entire Belt

1. Use a punch and hammer to push the belt rod (Figure 22, item 1) out by striking the rod end opposite the retaining head.

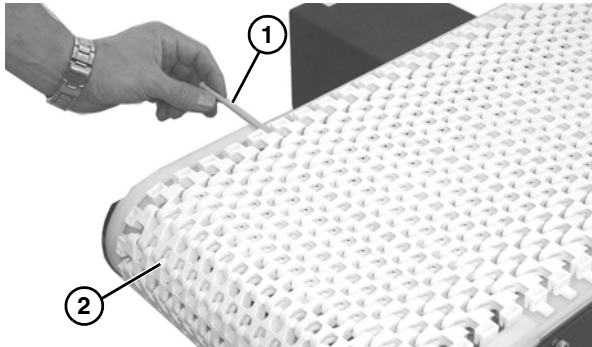


Figure 22

2. Slide the old belt (Figure 22, item 2) off the conveyor frame.
3. Replace the old belt with a new one. Refer to “Belt Installation” on page 8.

### 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 11.

## Wear Strips

Replace the wear strips if they become worn.

Typical Standard Wear Strips (Figure 23)

- |   |                               |
|---|-------------------------------|
| 1 | Wear Strip, Center            |
| 2 | Wear Strips, Lower Side       |
| 3 | Wear Strips, Lower Side       |
| 4 | Stop Plate, Center Wear Strip |

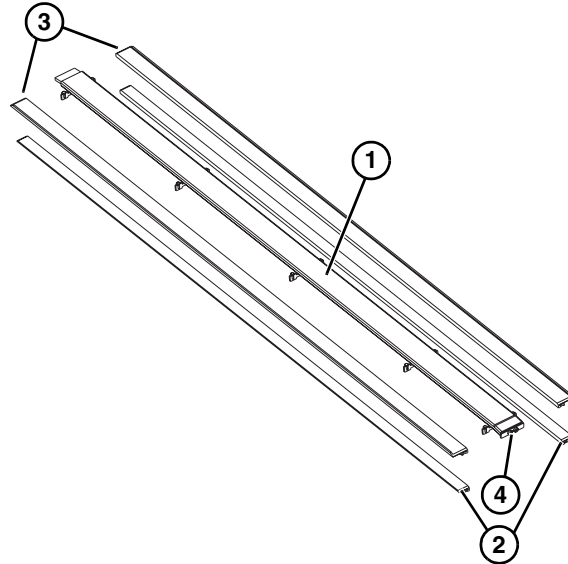


Figure 23

## Removal

1. Remove upper wear strips (Figure 24, item 1) from top of frame assembly.

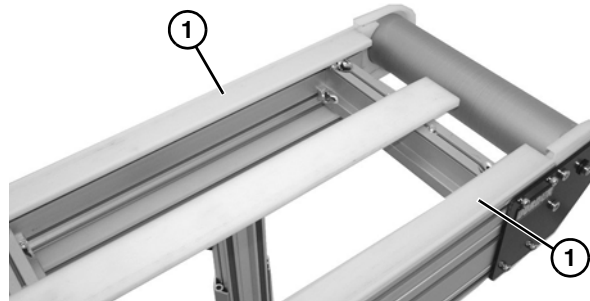
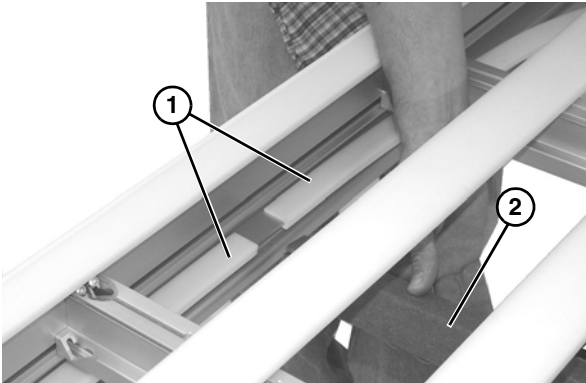


Figure 24

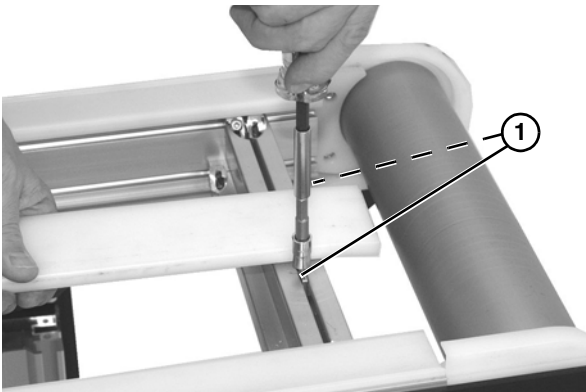
# Preventive Maintenance and Adjustment

2. Remove lower wear strips (**Figure 25, item 1**), and if necessary, lower belt return (**Figure 25, item 2**) from lower frame assembly.



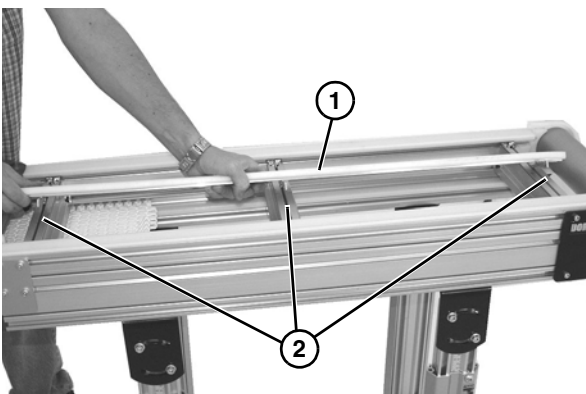
**Figure 25**

3. Remove two screws (**Figure 26, item 1**) from each clamp on center frame channel.



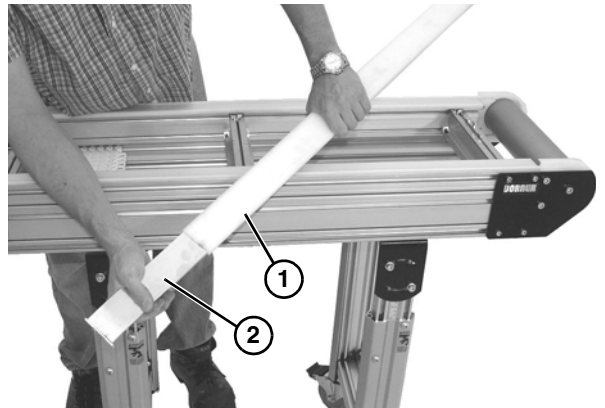
**Figure 26**

4. Remove center frame channel (**Figure 27, item 1**), making sure to keep each clamp matched with channel of each cross member (**Figure 27, item 2**).



**Figure 27**

5. Remove the center wear strip (**Figure 28, item 1**) from the center frame channel (**Figure 28, item 2**).

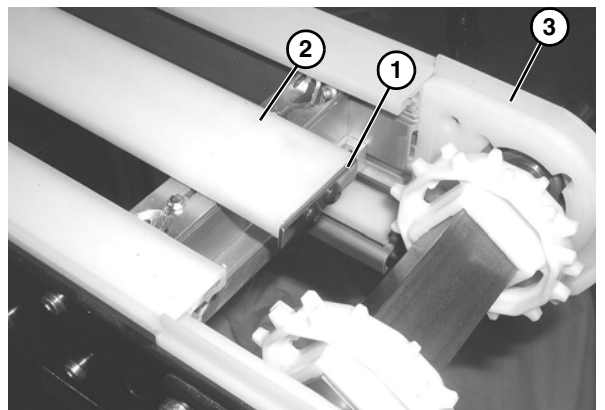


**Figure 28**

## Installation

### NOTE

The stop plate (**Figure 29, item 1**) on the center wear strip (**Figure 29, item 2**) faces the drive end (**Figure 29, item 3**) of the conveyor.




**Figure 29**

Install components reverse of removal.



# Preventive Maintenance and Adjustment

## Spindle Removal

<b>⚠ WARNING</b>

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

Remove conveyor belt to access spindle(s). See “Replacing the Entire Belt” on page 12. Remove the desired spindle following the corresponding instructions below:

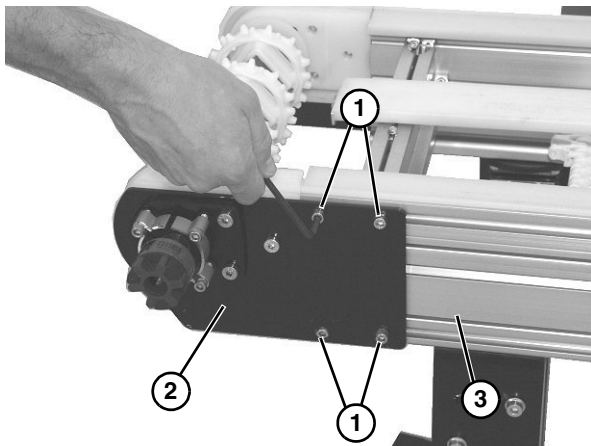
- A – Drive Spindle Removal
- B – Idler Spindle Removal
- C – Nose Bar Idler Spindle Removal

### A – Drive Spindle Removal

<b>⚠ WARNING</b>

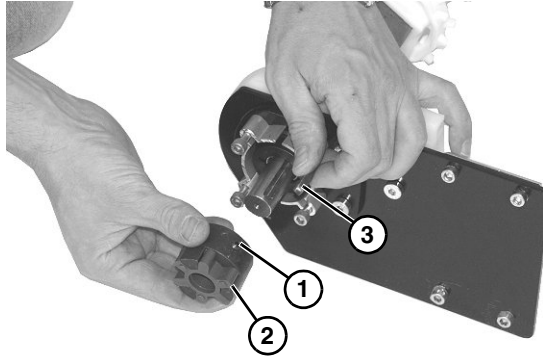
<b>Drive shaft keyway may be sharp. HANDLE WITH CARE.</b>

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Loosen the four socket head screws (**Figure 30, item 1**). Repeat on opposite side.



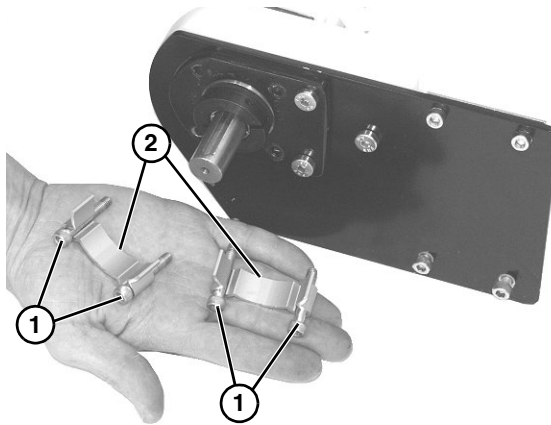
**Figure 30**

3. Remove the drive tail assembly (**Figure 30, item 2**) from the frame (**Figure 30, item 3**).
4. Loosen set screw (**Figure 31, item 1**) and remove coupling (**Figure 31, item 2**).



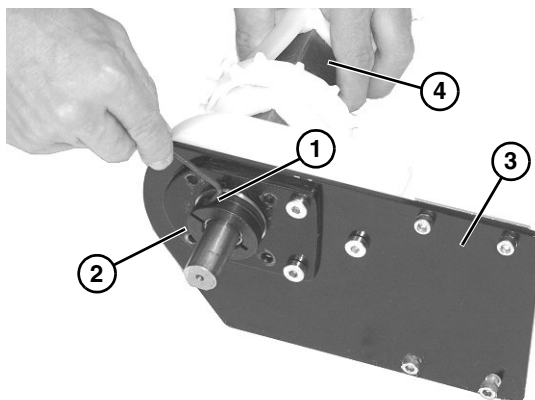
**Figure 31**

5. Remove key (**Figure 31, item 3**).
6. Remove four socket head screws (**Figure 32, item 1**) and drive guards (**Figure 32, item 2**).



**Figure 32**

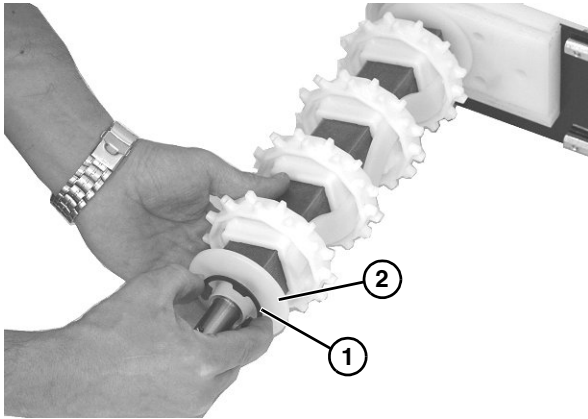
7. Loosen the bearing collar set screw (**Figure 33, item 1**) and remove bearing collar (**Figure 33, item 2**).



**Figure 33**

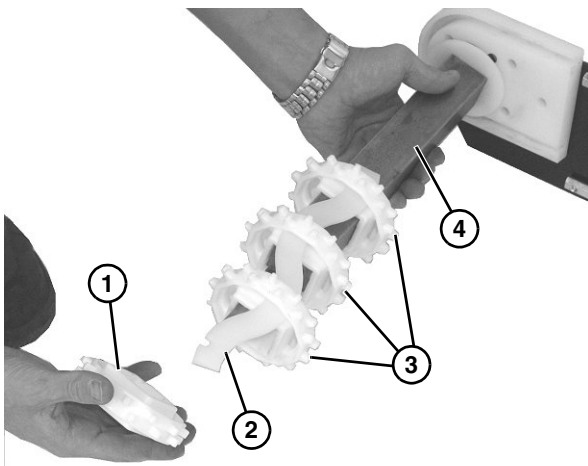
8. Remove plate (**Figure 33, item 3**) from drive spindle (**Figure 33, item 4**).
9. Remove retaining clip (**Figure 34, item 1**) and flanged puck (**Figure 34, item 2**) from drive spindle.

# Preventive Maintenance and Adjustment



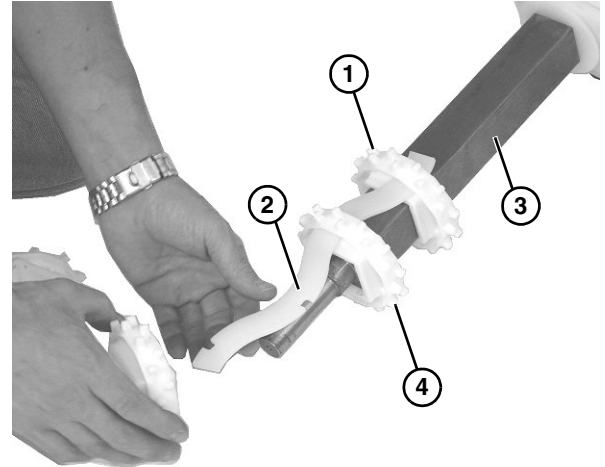
**Figure 34**

10. Slide entire sprocket assembly slightly outward, and remove the first sprocket (**Figure 35, item 1**) off the drive spindle and alignment bar (**Figure 35, item 2**).



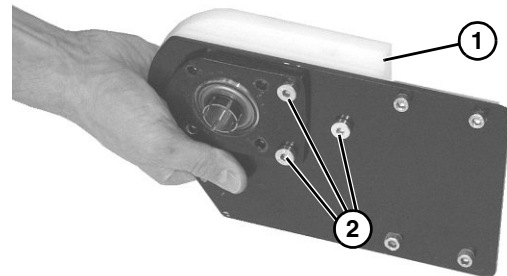
**Figure 35**

11. Remove remaining sprockets (**Figure 35, item 3**) off the alignment bar as you slide entire assembly off the drive spindle (**Figure 35, item 4**).
12. To assemble sprockets onto drive spindle, slide one sprocket (**Figure 36, item 1**) onto alignment bar (**Figure 36, item 2**) and slide assembly onto drive spindle (**Figure 36, item 3**).



**Figure 36**

13. Install second sprocket (**Figure 36, item 4**) and subsequent sprockets one by one, while sliding entire assembly onto alignment bar and spindle.
14. Check drive terminal assembly (**Figure 37, item 1**) for wear. If worn, remove three low head cap screws (**Figure 37, item 2**) and replace.



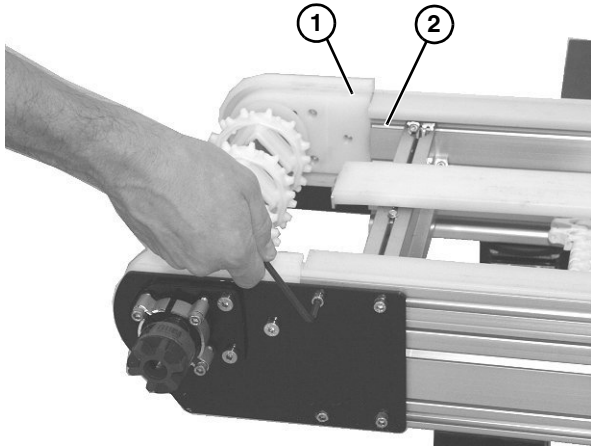
**Figure 37**



# Preventive Maintenance and Adjustment

## NOTE

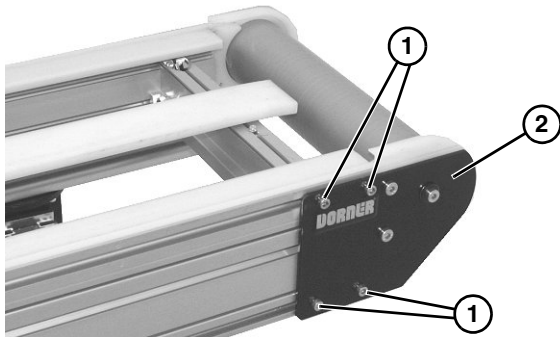
When reinstalling the drive spindle tail assembly, the terminal assembly (**Figure 38, item 1**) should be flush with the conveyor frame (**Figure 38, item 2**).



**Figure 38**

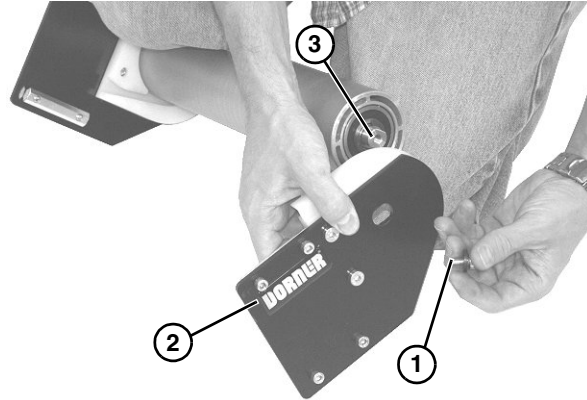
## B – Idler Spindle Removal

1. Be sure the conveyor is supported.
2. On one side of conveyor, loosen the four socket head screws (**Figure 39, item 1**). Repeat on opposite side.



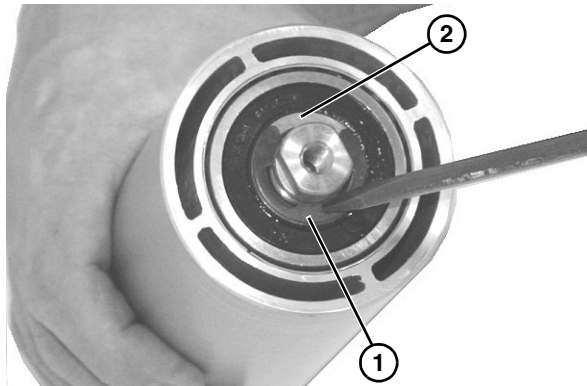
**Figure 39**

3. Remove idler tail assembly (**Figure 39, item 2**).
4. Remove socket head screw (**Figure 40, item 1**) from plate (**Figure 40, item 2**) and center of spindle shaft (**Figure 40, item 3**). Repeat procedure on opposite side.



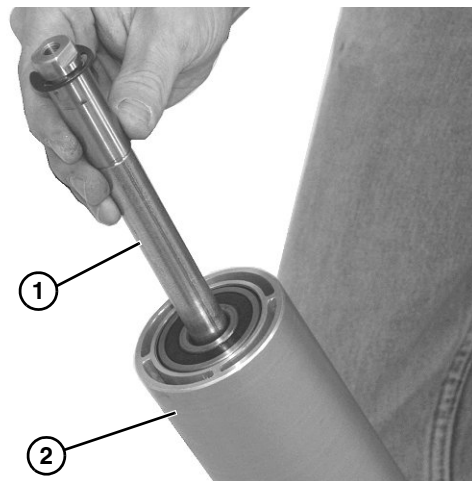
**Figure 40**

5. Remove the spindle shaft assembly: remove the clip ring (**Figure 41, item 1**) and washer (**Figure 41, item 2**) from one side of the spindle assembly.



**Figure 41**

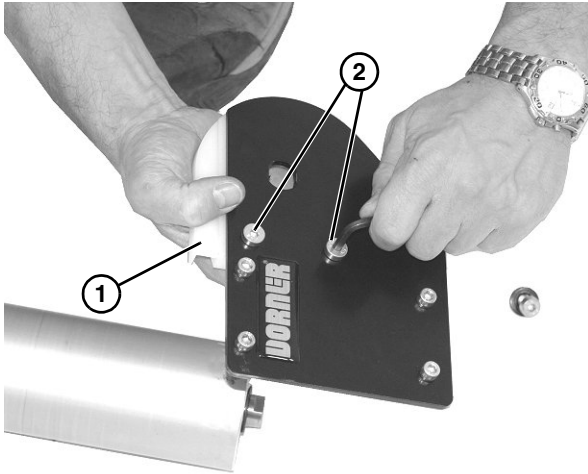
6. Slide the shaft assembly (**Figure 42, item 1**) out of the pulley (**Figure 42, item 2**).



**Figure 42**

# Preventive Maintenance and Adjustment

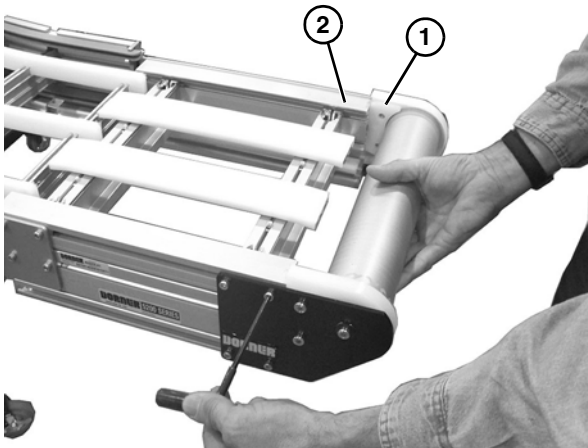
7. Check idler terminal assembly (**Figure 43, item 1**) for wear. If worn, remove two low head cap screws (**Figure 43, item 2**) and replace.



**Figure 43**

## NOTE

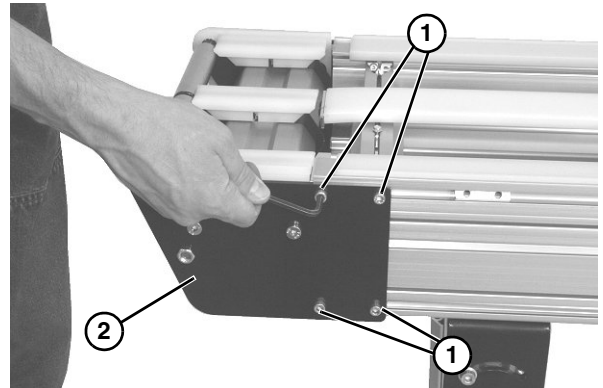
When reinstalling the idler spindle tail assembly, the idler terminal assembly (**Figure 44, item 1**) should be flush with the conveyor frame (**Figure 44, item 2**).



**Figure 44**

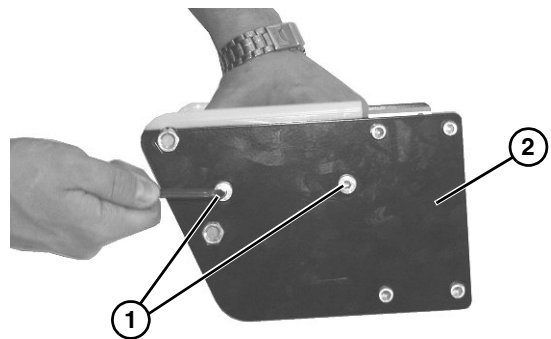
## C – Nose Bar Idler Spindle Removal

1. Be sure the conveyor is supported.
2. On one side of conveyor, loosen the four socket head screws (**Figure 45, item 1**). Repeat on opposite side.



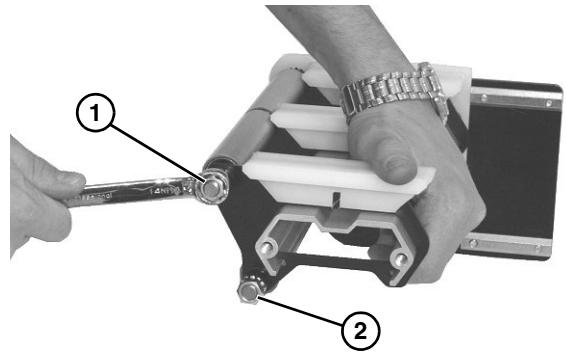
**Figure 45**

3. Remove idler tail assembly (**Figure 45, item 2**).
4. Remove two low head cap screws (**Figure 46, item 1**) from plate (**Figure 46, item 2**). Repeat procedure on opposite side.



**Figure 46**

5. Remove upper nut (**Figure 47, item 1**) and spacer from end of axle shaft assembly.

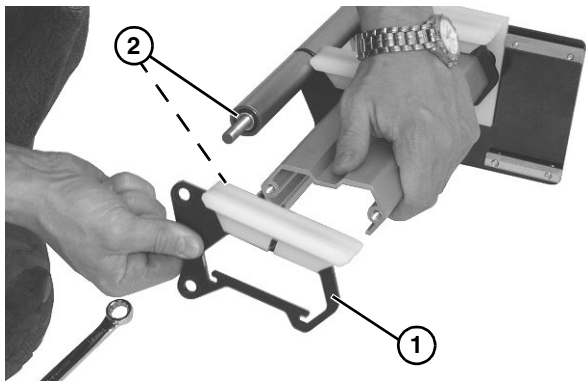


**Figure 47**

6. Remove lower nut (**Figure 47, item 2**) and spacer from lower axle shaft assembly.

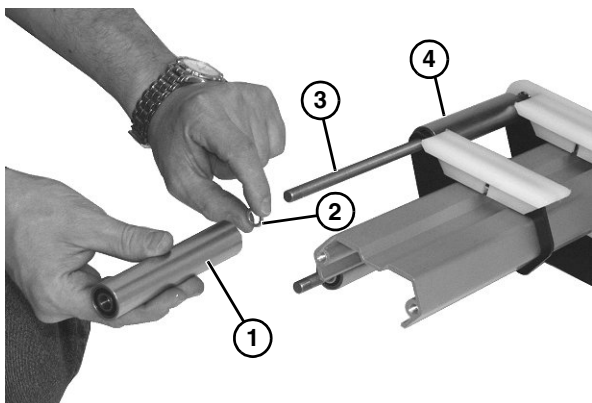
# Preventive Maintenance and Adjustment

- Slide the support plate (**Figure 48, item 1**) off of both axle shafts.



**Figure 48**

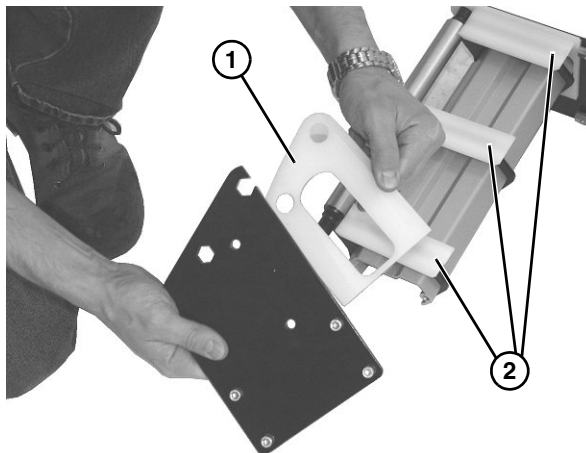
- Remove washer (**Figure 48, item 2**) off of lower and upper axle shafts.
- Remove roller assembly (**Figure 49, item 1**) and washer (**Figure 49, item 2**) from axle shaft (**Figure 49, item 3**).



**Figure 49**

- Remove remaining roller assembly components (**Figure 49, item 4**) on opposite side.

- Check idler terminal assembly on each side (**Figure 50, item 1**) for wear. If worn, replace.

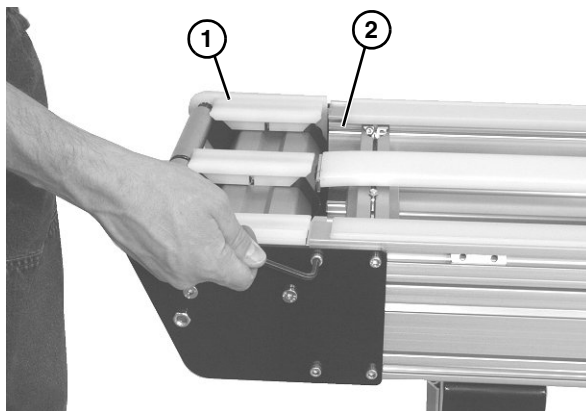


**Figure 50**

- Remove and replace wear guides (**Figure 50, item 2**) if worn. When replacing, secure onto pins on each support plate.

## NOTE

When reinstalling the idler spindle tail assembly, the idler terminal assembly (**Figure 51, item 1**) should be flush with the conveyor frame (**Figure 51, item 2**).



**Figure 51**

# Preventive Maintenance and Adjustment

## Spindle Replacement

### Drive Spindle

To replace the drive spindle, reverse the "A - Drive Spindle Removal" procedure on page 14.

### Idler Spindle

To replace the idler spindle, reverse the "B - Idler Spindle Removal" procedure on page 16.

## Bearing Replacement

 <b>WARNING</b>

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

## Drive Bearing Removal and Replacement

 <b>WARNING</b>

<b>Drive shaft keyway may be sharp. HANDLE WITH CARE.</b>

### Removal

1. Turn bearing (**Figure 52, item 1**) to align with slots (**Figure 52, item 2**) in bearing housing. Then remove bearing.

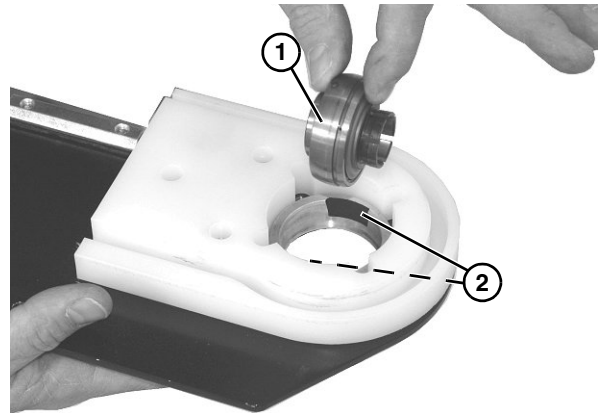


Figure 52

### Replacement

1. Inspect bearing housing bearing surface. If worn or damaged, replace. See "Service Parts" on page 20.
2. Insert bearing (**Figure 53, item 1**) into housing slot: Locate anti-rotation nub (**Figure 53, item 2**) to align with slot (**Figure 53, item 3**), and twist bearing into housing.

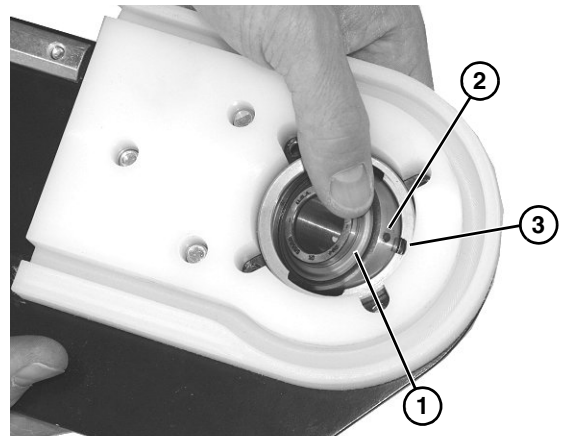



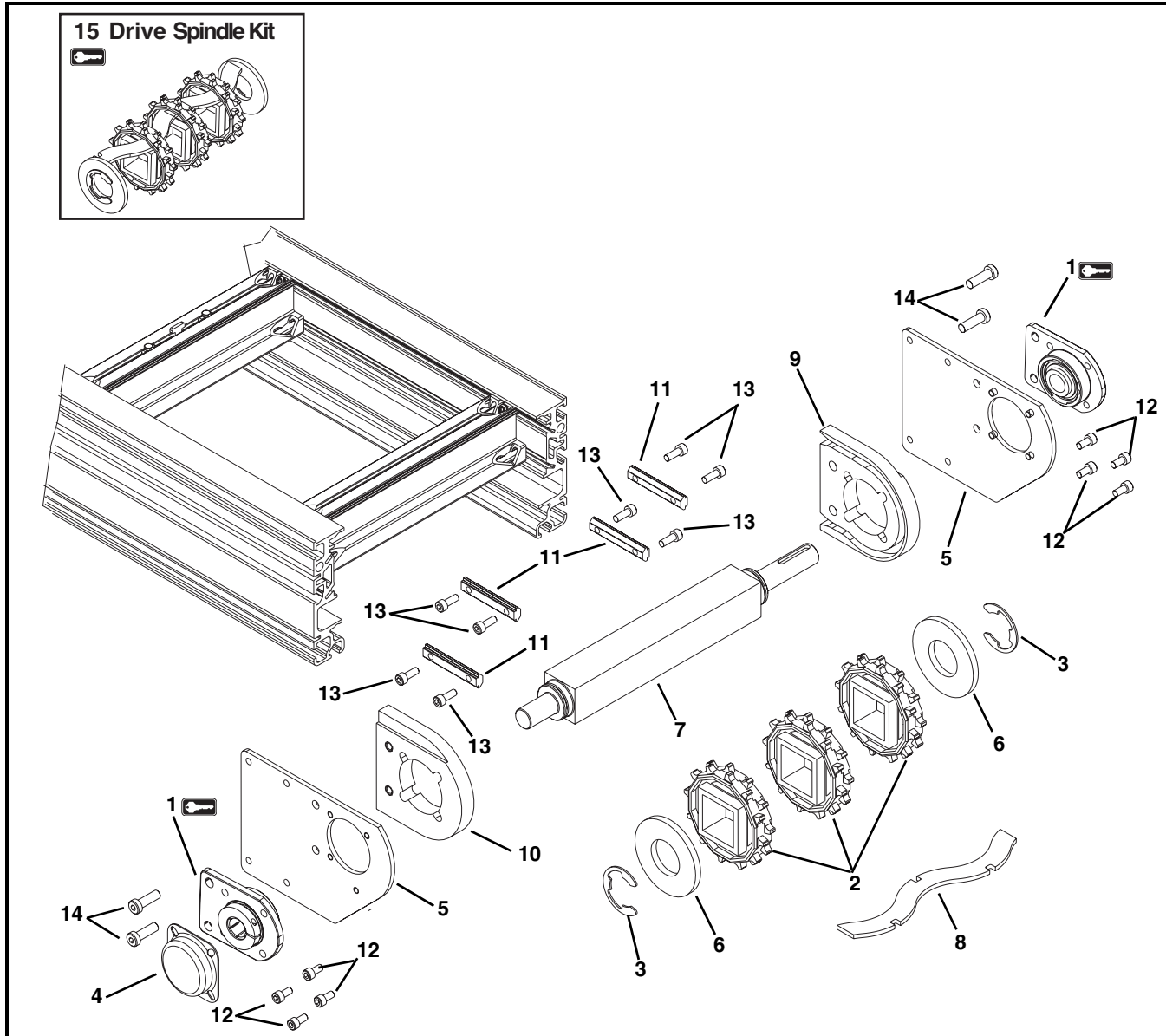
Figure 53


# Service Parts


## NOTE

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

## Drive End Components

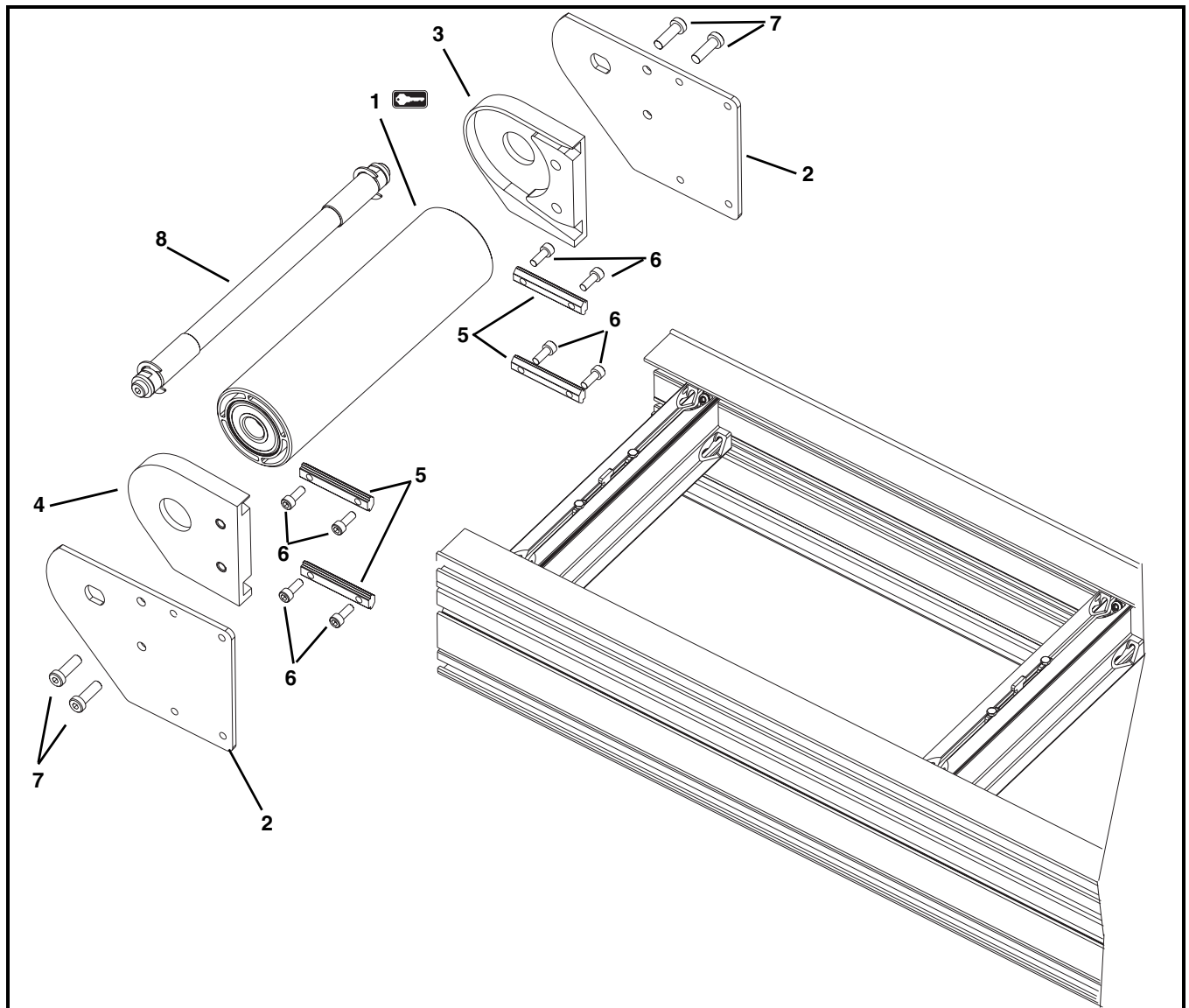



Item	Part Number	Description
1 	52BKD	Drive Bearing Kit
2	807-1444	Sprocket
3	915-240	Retaining Ring
4	300139	Shaft Cover
5	352109	Cover Plate
6	352111	Sprocket Alignment Retainer Key
7	352212- <u>WW</u>	Drive Spindle
8	352213- <u>WW</u>	Sprocket Alignment Bar
9	352214	Drive Terminal Assembly Left Hand

Item	Part Number	Description
10	352215	Drive Terminal Assembly Right Hand
11	300150M	Drop-In Tee Bar
12	920612M	Socket Head Screw, M6-1.00 x 12 mm
13	920616M	Socket Head Screw, M6-1.00 x 16 mm
14	920895M	Low Head Cap Screw, M8-1.25 x 25 mm
15 	52CDT- <u>WW</u>	Drive Spindle Kit (Includes Items 2, 3, 6 and 8)

WW = Conveyor width reference: 08 - 36 in 02 increments

## Idler End Components

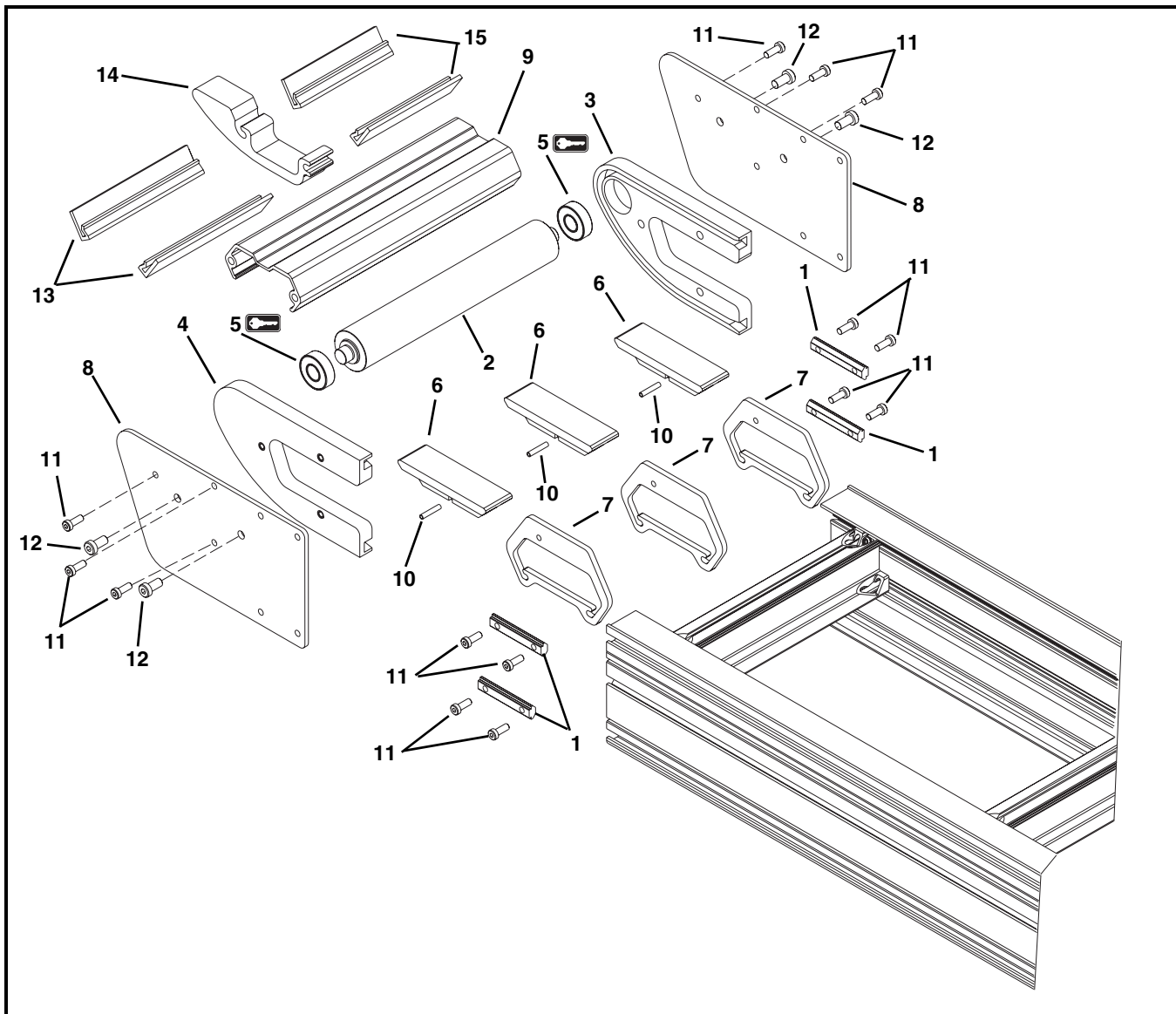


Item	Part Number	Description
1 	352033- <u>WW</u>	Idler Pulley Assembly
2	352110	Cover Plate
3	352223	Idler Terminal Assembly Left Hand
4	352224	Idler Terminal Assembly Right Hand

Item	Part Number	Description
5	300150M	Drop-In Tee Bar
6	920616M	Socket Head Screw, M6-1.00 x 16 mm
7	920895M	Low Head Cap Screw, M8-1.25 x 25 mm
8	352034- <u>WW</u>	Idler Wand Assembly
<u>WW</u> = Conveyor width reference: 08 – 36 in 02 increments		

# Service Parts

## Nose Bar Idler End Components



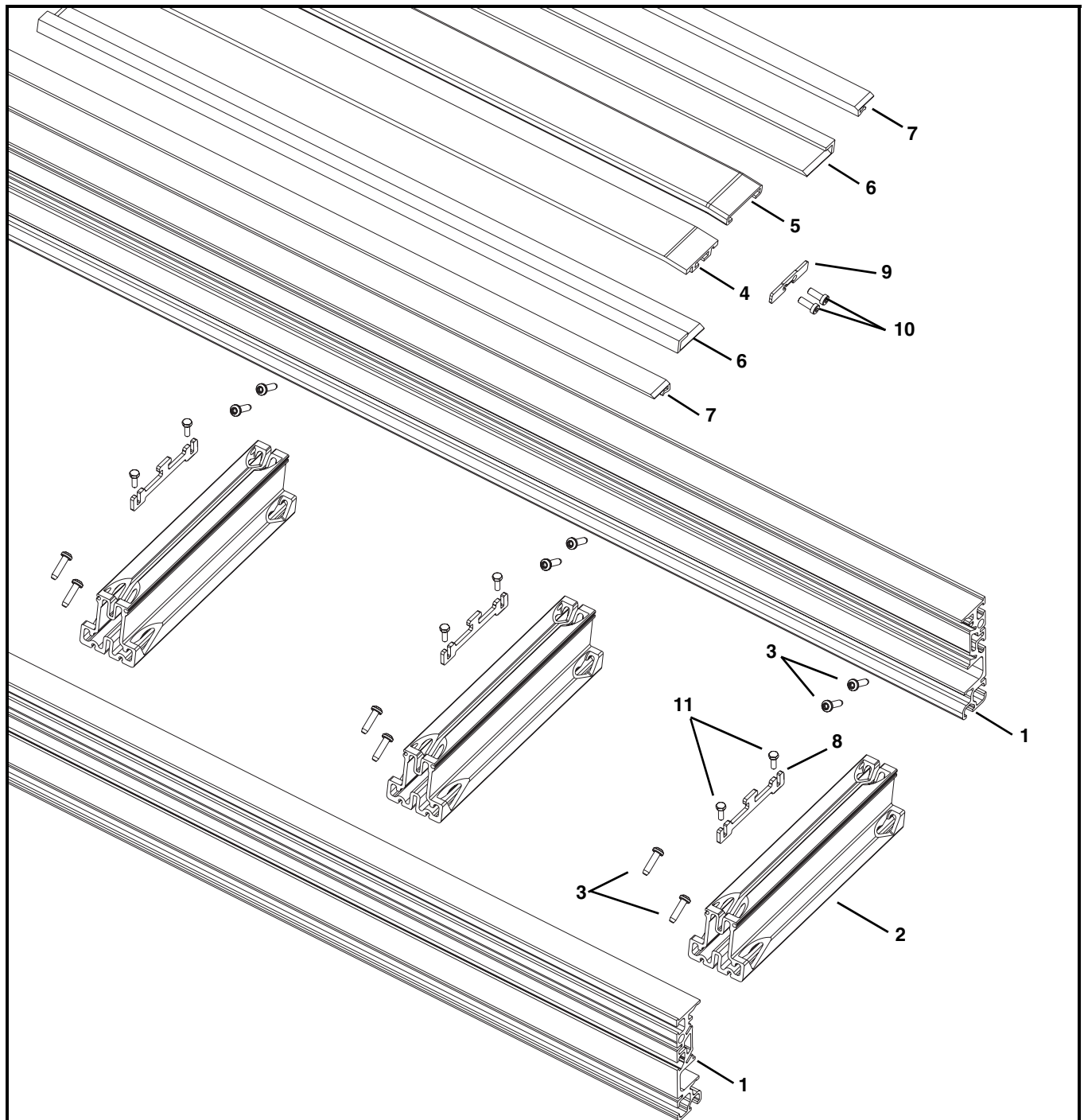
Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	352252- <u>WW</u>	Spindle
3	352259	Nose Bar Terminal Assembly, Left Hand
4	352260	Nose Bar Terminal Assembly, Right Hand
5	52BKNBC	Bearing Kit
6	352128	Wear Guide
7	352246	Support Plate
8	352249	Tail Plate

Item	Part Number	Description
9	352251- <u>WW</u>	Crossmember
10	913-405	Pin
11	920616M	Socket Head Screw, M6-1.00 x 16 mm
12	920893M	Low Head Cap Screw, M8-1.25 x 25 mm
13	352268- <u>WW</u>	Spacer
14	352266	Transfer Shoe
15	352269- <u>WW</u>	Shoe Spacer

WW = Conveyor width reference: 08 – 36 in 02 increments



## Frame Assembly

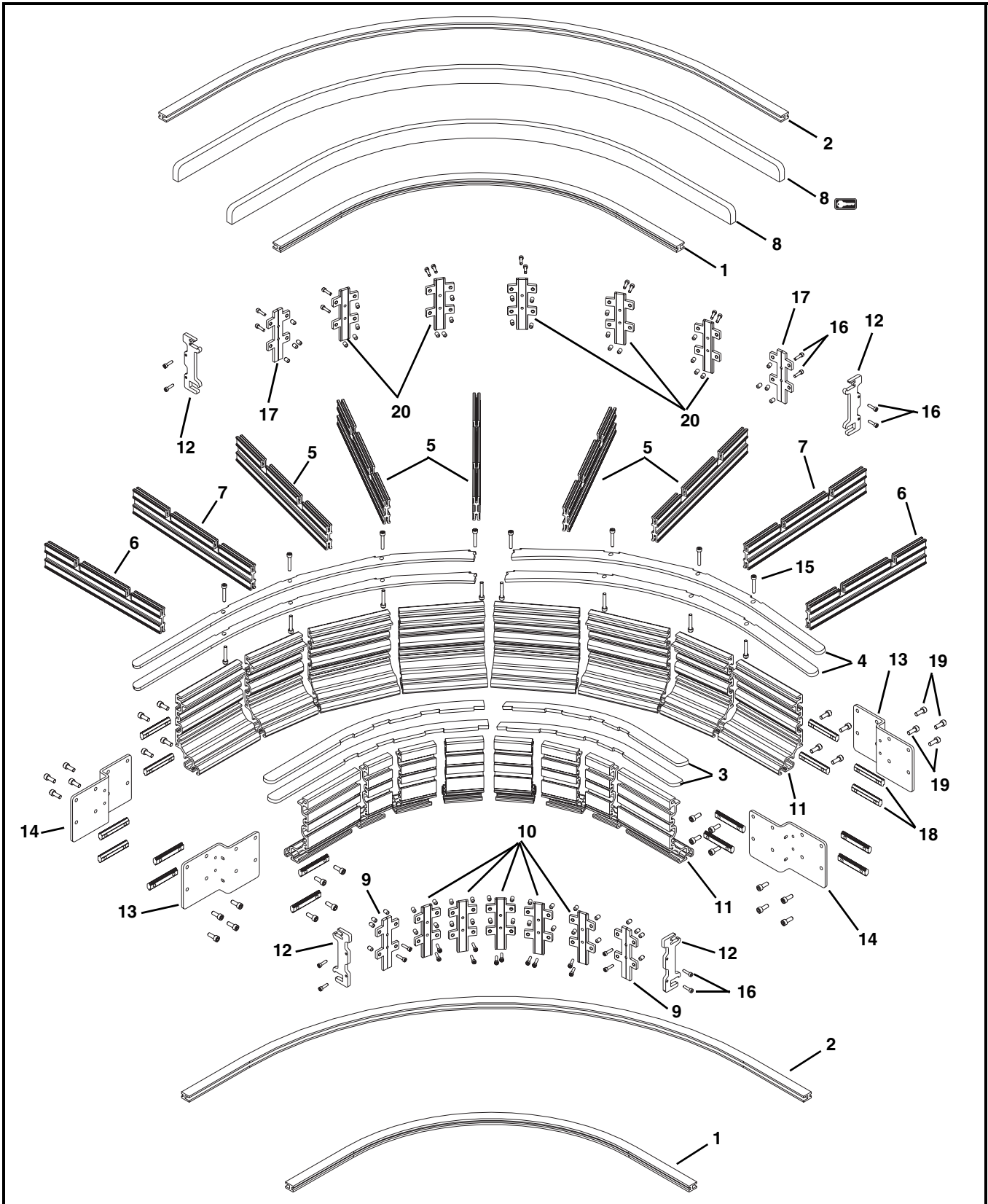


Item	Part Number	Description
1	352100-LLLLL	Side Rail
2	352201-WW	Cross Support Rail
3	352108	Pan Screw, M5-.80 x 20 mm
4	352102-LLLLL	Center Bed Rail
5	352103-LLLLL	Center Wearstrip
6	352210-LLLLL	Top Wearstrip
7	352105-LLLLL	Return Wearstrip
8	352106	Center Bed Rail Hold Down Clip

Item	Part Number	Description
9	352107	Center Wearstrip Stop Plate
10	901-135	Button Head Cap Screw, 1/4-20 x 0.88"
11	960498M	Hex Head Cap Screw, M4-.70 x 12 mm
WW = Conveyor width reference: 08 – 36 in 02 increments LLLLL = Length in inches with 2 decimal places. Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

## Curve Conveyor Frame and Wear Strips



# Service Parts

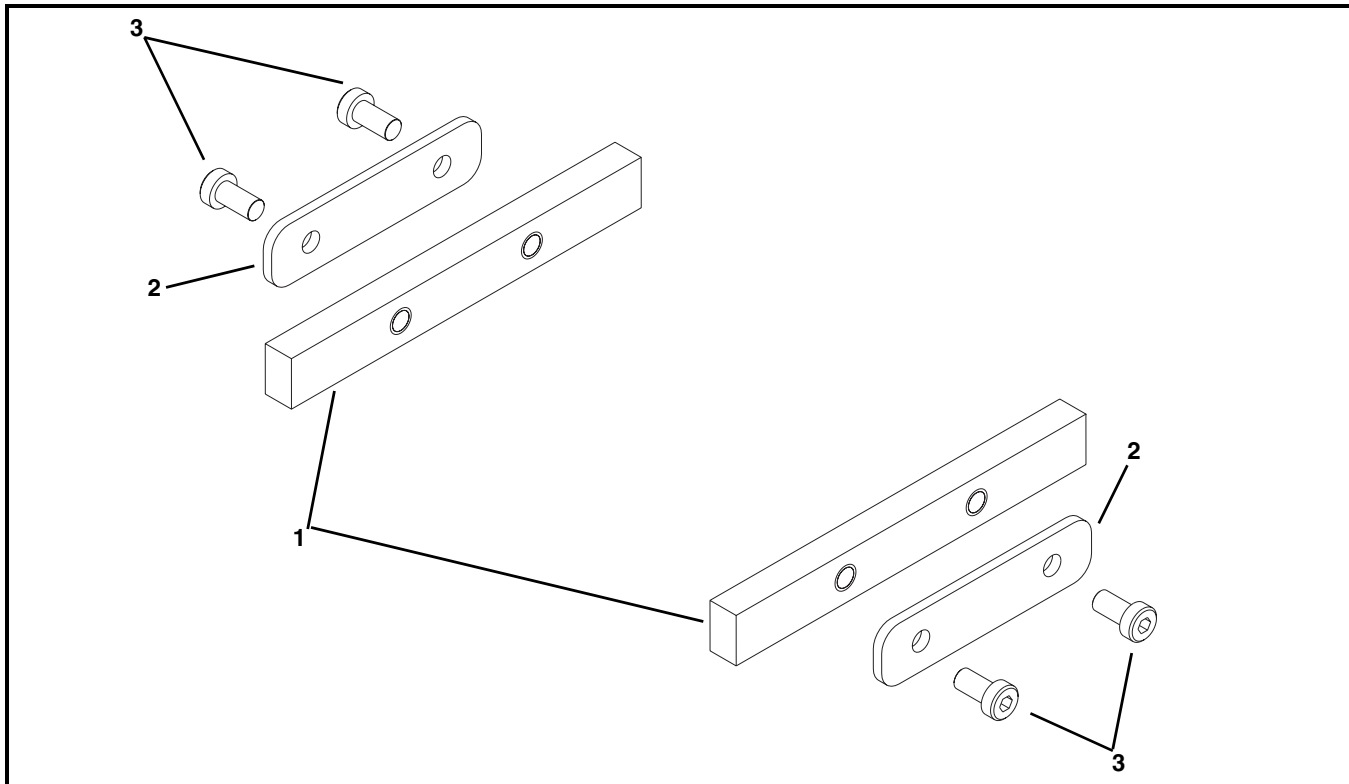
Item	Part Number	Description
1	352203- <u>WW</u> - <u>DDD</u>	Inner Guide
2	352204- <u>WW</u> - <u>DDD</u>	Outer Guide
3	See Chart #3	Inner Spine
4	See Chart #4	Outer Spine
5	352202- <u>WW</u>	Cross Support Rail
6	352207- <u>WW</u>	End Cross Support Rail
7	352209- <u>WW</u>	7.5° Cross Support Rail
8	352208- <u>LLLLL</u>	Top Wearstrip
9	352273	7.5° Inner Connecting Plate Assembly
10	352271	15° Inner Connecting Plate Assembly
11	352200- <u>LLLLL</u>	Side Rail
12	352226	Guide Alignment Plate
13	352227	Offset Connecting Plate, Right
14	352228	Offset Connecting Plate, Left
15	920530M	Socket Head Screw, M5-.80x30mm
16	920416M	Socket Head Screw, M4-.70x16mm
17	352274	7.5° Outer Connecting Plate Assembly
18	300150M	Drop-In Tee Bar
19	920616M	Socket Head Screw, M6-1x16mm
20	352272	15° Outer Connecting Plate Assembly
<u>WW</u> = Conveyor width reference: 08 – 36 in 02 increments		
<u>DDD</u> = Degree of curve		
Degree Example: Curve = 30° <u>DDD</u> = 030		
<u>LLLLL</u> = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" <u>LLLLL</u> = 09525		

Chart #3	
Degree	Part Number
15°	352231- <u>WW</u> (x2)
30°	352233- <u>WW</u> (x2)
45°	352235- <u>WW</u> (x2)
60°	352237- <u>WW</u> (x2)
75°	352239- <u>WW</u> & 352237- <u>WW</u>
90°	352239- <u>WW</u> (x2)
105°	352237- <u>WW</u> (x2) & 352243- <u>WW</u>
120°	352239- <u>WW</u> (x2) & 352241- <u>WW</u>
135°	352239- <u>WW</u> (x2) & 352243- <u>WW</u>
150°	352239- <u>WW</u> (x2) & 352241- <u>WW</u> (x2)
165°	352239- <u>WW</u> (x2), 352241- <u>WW</u> & 352243- <u>WW</u>
180°	352239- <u>WW</u> (x2) & 352243- <u>WW</u> (x2)

Chart #4	
Degree	Part Number
15°	352232- <u>WW</u> (x2)
30°	352234- <u>WW</u> (x2)
45°	352236- <u>WW</u> (x2)
60°	352238- <u>WW</u> (x2)
75°	352240- <u>WW</u> & 352238- <u>WW</u>
90°	352240- <u>WW</u> (x2)
105°	352238- <u>WW</u> (x2) & 352244- <u>WW</u>
120°	352240- <u>WW</u> (x2) & 352242- <u>WW</u>
135°	352240- <u>WW</u> (x2) & 352244- <u>WW</u>
150°	352240- <u>WW</u> (x2) & 352242- <u>WW</u> (x2)
165°	352240- <u>WW</u> (x2), 352242- <u>WW</u> & 352244- <u>WW</u>
180°	352240- <u>WW</u> (x2) & 352244- <u>WW</u> (x2)

# Service Parts

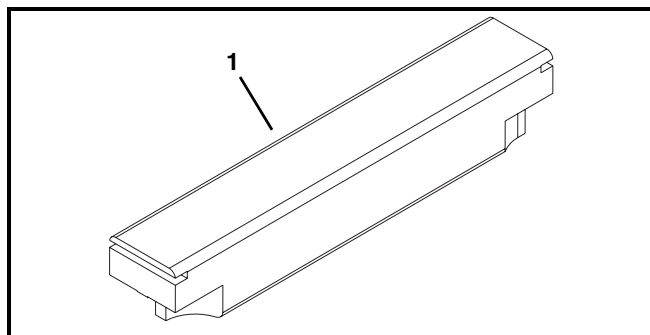
## Connecting Assembly



Item	Part Number	Description
1	352315	Bar Frame Connector
2	240859	Plate Frame Connector

Item	Part Number	Description
3	920692M	Low Head Cap Screw, M6-1.00 x 12 mm

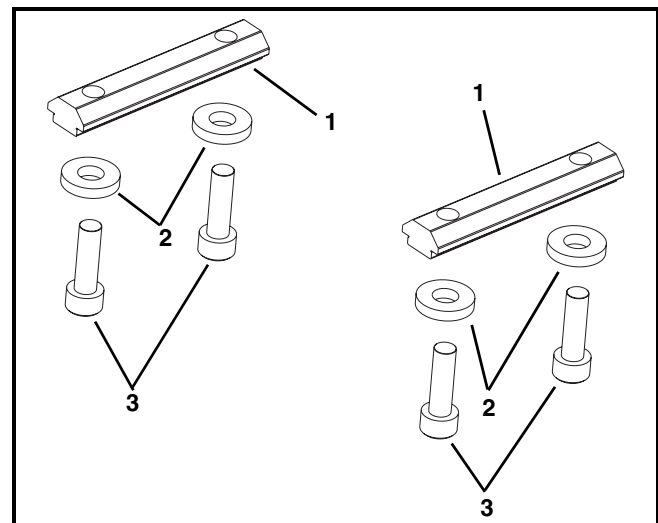
## Flat Belt Returns



Item	Part Number	Description
1	352220- <u>WW</u>	Returns - Straight Sections of Conveyor
	352211- <u>WW</u>	Returns - Curved Sections of Conveyor

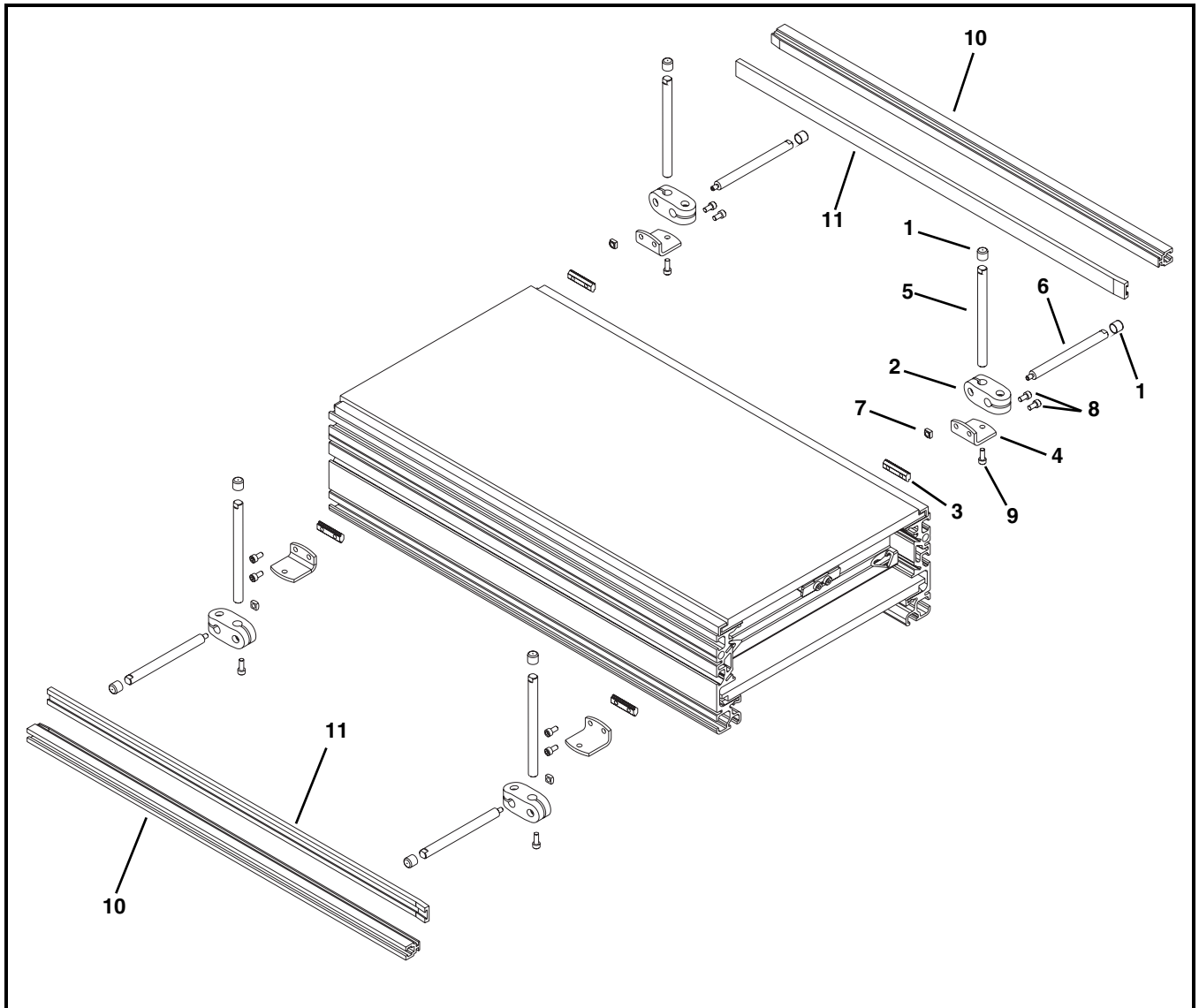
WW = Conveyor width ref: 18 - 36 in 02 increments

## Stand Mount Kit



Item	Part Number	Description
1	300150M	Drop-In Tee Bar
2	605279P	Washer
3	920620M	Socket Head Screw, M6-1.00 x 20 mm

## Fully Adjustable Guiding (Straight Module)

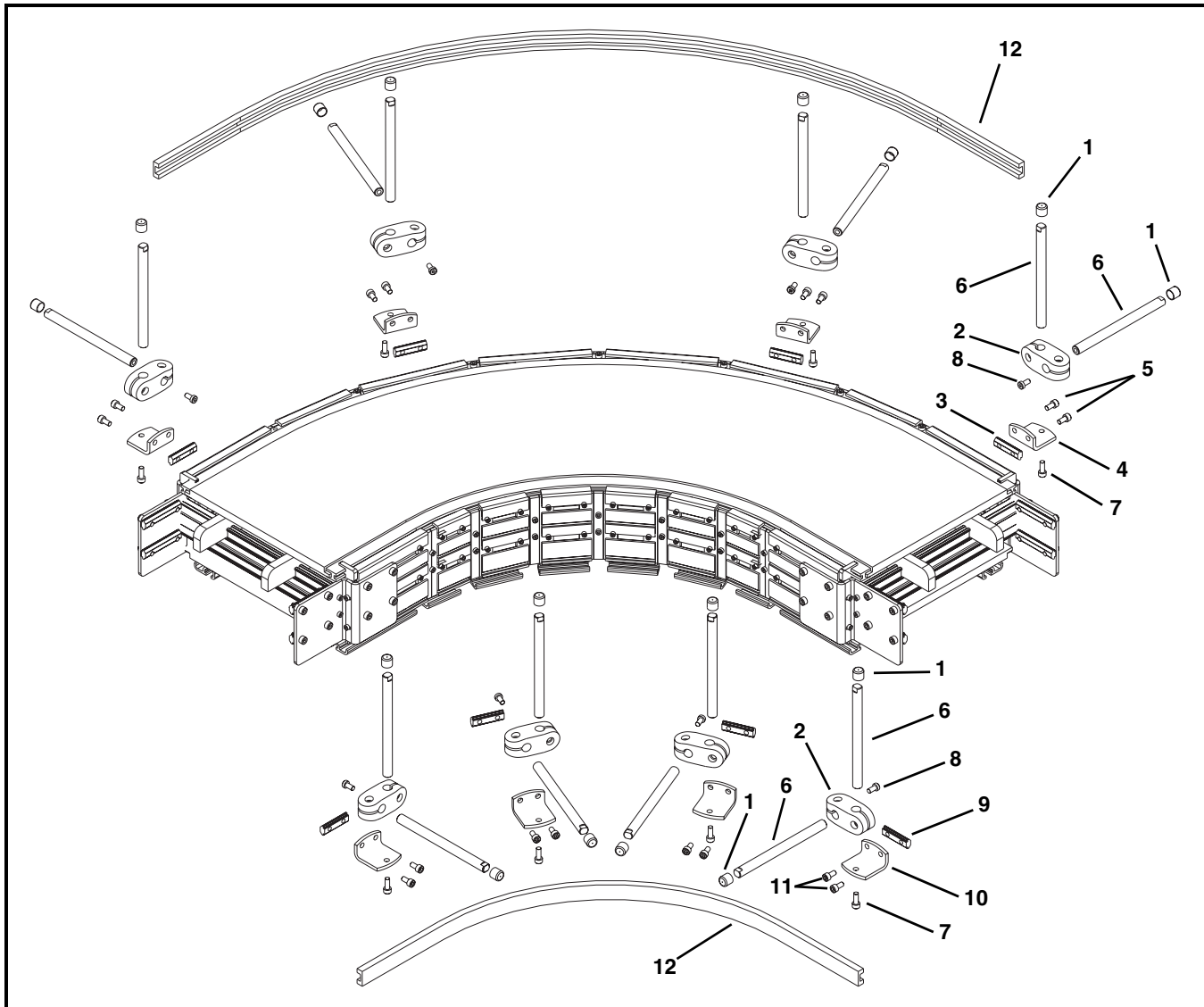


Item	Part Number	Description
1	807-948	Shaft Cap
2	807-652	Cross Block
3	200830M	Drop-In Tee Bar
4	202004M	Mounting Bracket
5	202027M	Vertical Mounting Guide Shaft
6	202028M	Horizontal Mounting Guide Shaft

Item	Part Number	Description
7	674175MP	Square Nut, M6-1.00
8	920612M	Socket Head Screw, M6-1.00 x 12 mm
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	381300-LLLLL	Aluminum Profile Guide
11	614068P	Extruded Guide (Per Foot)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		

# Service Parts

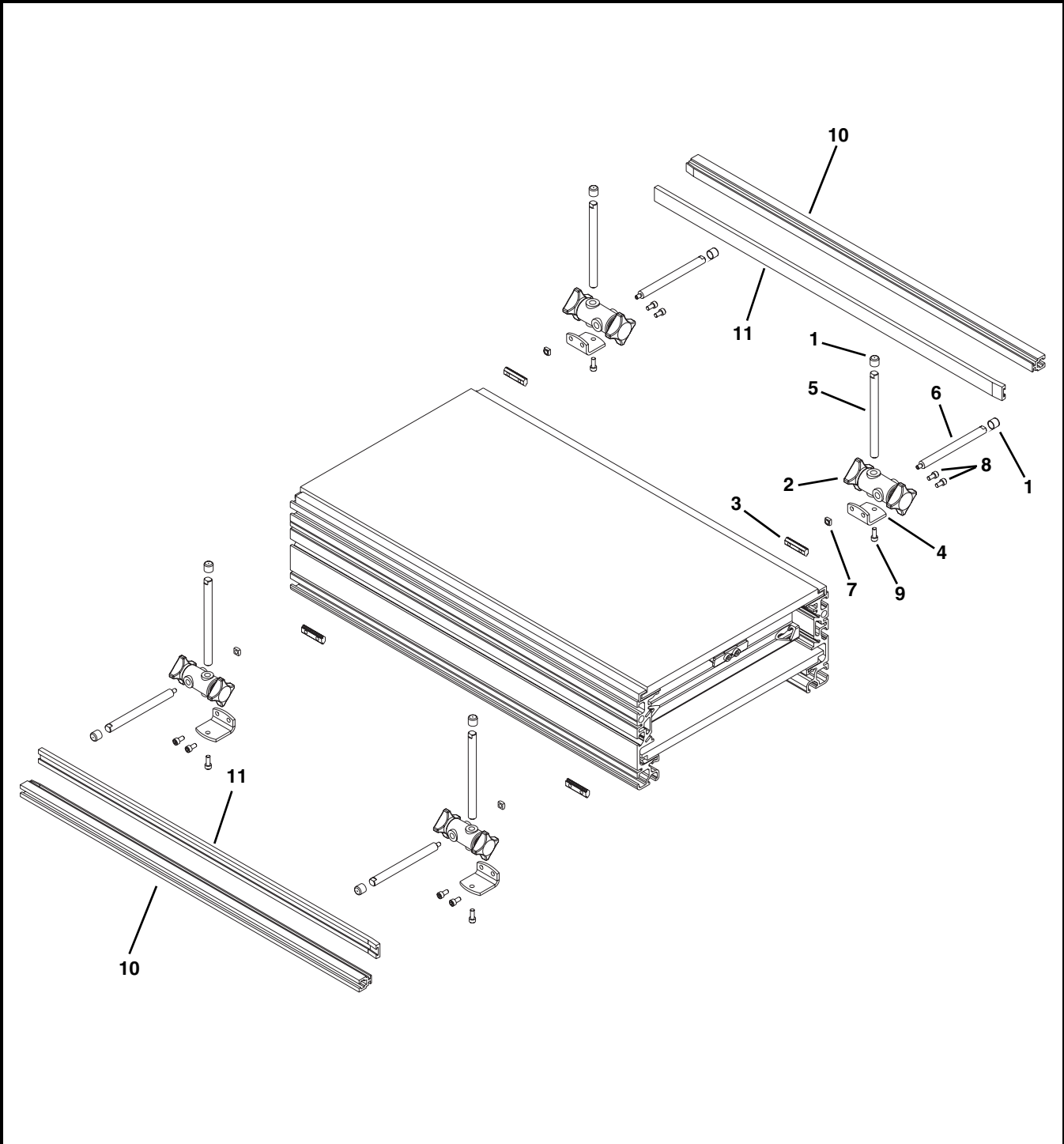
## Fully Adjustable Guiding (Curve Module)



Item	Part Number	Description
1	807-948	Shaft Cap
2	807-652	Cross Block
3	200830M	Drop-In Tee Bar, Outer Curve
4	202004M	Mounting Bracket, Outer Curve
5	920612M	Socket Head Screw, M6-1.00x12 mm
6	202027M	Mounting Guide Shaft
7	920616M	Socket Head Screw, M6-1.00x16 mm
8	920692M	Low Head Cap Screw, M6-1.00x16 mm
9	200830M	Drop-In Tee Bar, Inner Curve (12" through 36" wide)

Item	Part Number	Description
10	325303	Mounting Bracket, Inner Curve (8" and 10" wide)
	202004M	Mounting Bracket, Inner Curve (12" through 36" wide)
11	920512M	Socket Head Screw, M5-.80x12 mm for inner curve (8" and 10" wide)
	920616M	Socket Head Screw, M6-1.00x12 mm for inner curve (12" through 36" wide)
12	234014	U-Channel Guide, 4' Long

## Tool-Less Fully Adjustable Guiding (Straight Module)



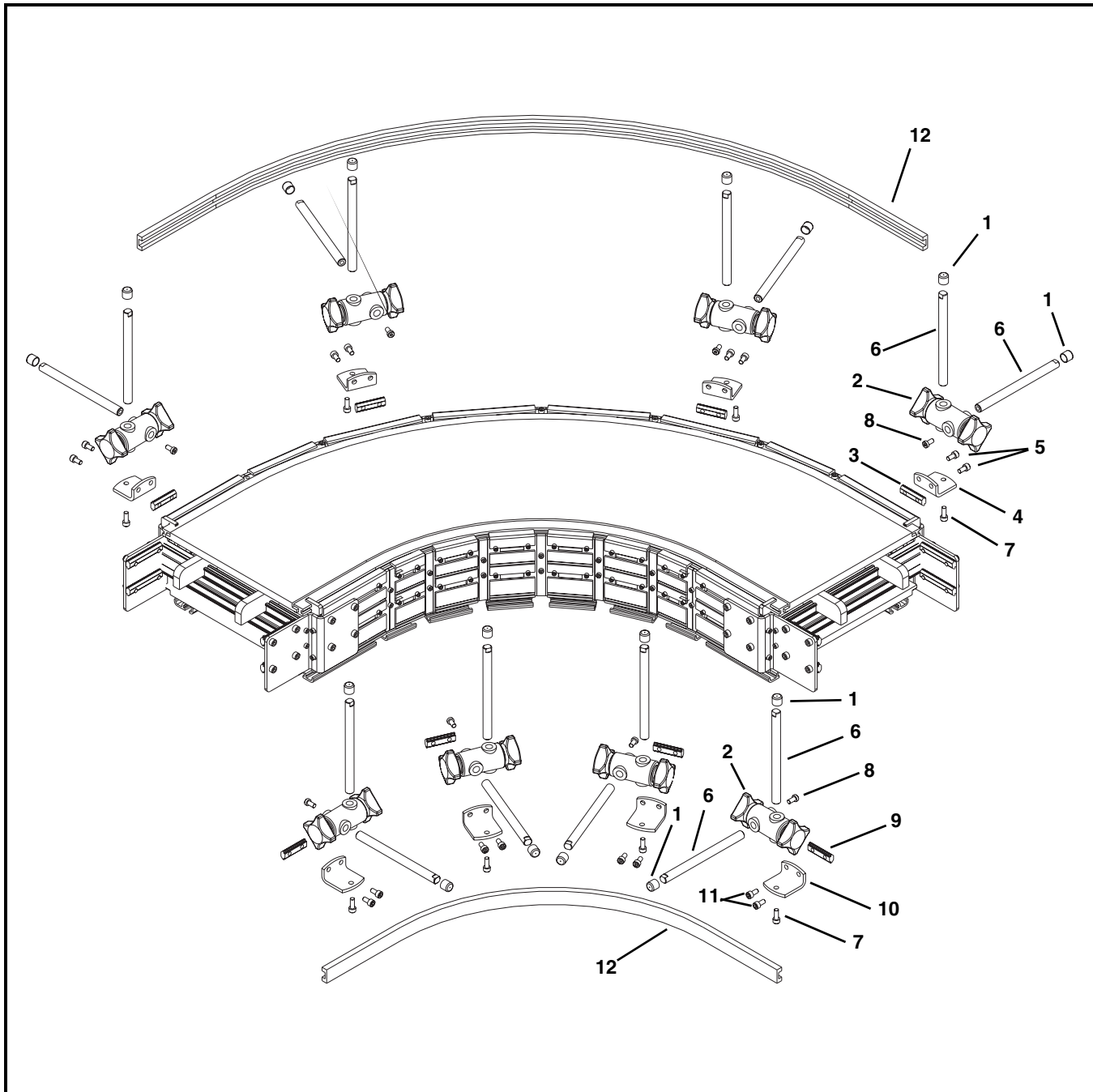
Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	200830M	Drop-In Tee Bar
4	202004M	Mounting Bracket
5	202027M	Vertical Mounting Guide Shaft
6	202028M	Horizontal Mounting Guide Shaft
7	674175MP	Square Nut, M6-1.00

Item	Part Number	Description
8	920612M	Socket Head Screw, M6-1.00 x 12 mm
9	920616M	Socket Head Screw, M6-1.00 x 16 mm
10	381400-LLLLL	Aluminum Profile Guide
11	614068P	Extruded Guide (Per Foot)
LLLLL = Length in inches with 2 decimal places.		
Length Example: Length = 95.25" LLLLL = 09525		



# Service Parts

## Tool-Less Fully Adjustable Guiding (Curve Module)



Item	Part Number	Description
1	807-948	Shaft Cap
2	807-1470	Cross Block
3	200830M	Drop-In Tee Bar, Outer Curve
4	202004M	Mounting Bracket, Outer Curve
5	920612M	Socket Head Screw, M6-1.00x12 mm
6	202027M	Mounting Guide Shaft
7	920616M	Socket Head Screw, M6-1.00x16 mm
8	920692M	Low Head Cap Screw, M6-1.00x16 mm
9	200830M	Drop-In Tee Bar, Inner Curve (12" through 36" wide)

Item	Part Number	Description
10	325303	Mounting Bracket, Inner Curve (8" and 10" wide)
	202004M	Mounting Bracket, Inner Curve (12" through 36" wide)
11	920512M	Socket Head Screw, M5-.80x12 mm for inner curve (8" and 10" wide)
	920616M	Socket Head Screw, M6-1.00x12 mm for inner curve (12" through 36" wide)
12	234014	U-Channel Guide, 4' Long

**Ordering a Replacement Chain**

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

**Example:**

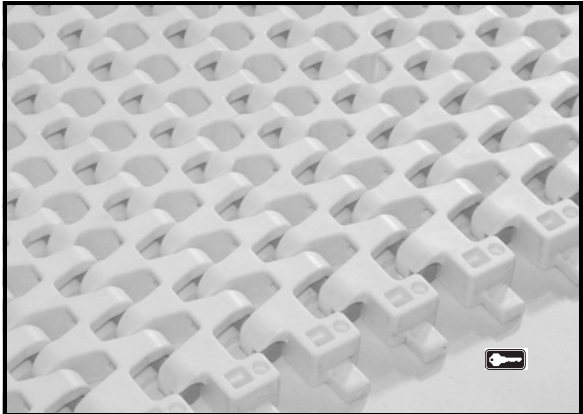
Overall chain length = 42' 5" (rounded up = 43')


Order: Qty (43) of 52MT-WW

MT = Chain reference number

WW = Conveyor width ref: 08-36 in 02 increments

**Flat Belt Chain Repair Kit**



Item	Part Number	Description
1 	52MT- <u>WW</u>	Flat Belt Chain Repair kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
<u>WW</u> = Conveyor width ref: 08 - 36 in 02 increments		

# 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.

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

There will be a return charge on all new undamaged items returned for credit where Dorner was not at fault. Dorner is not responsible for return freight on such items.

## Conveyors and conveyor accessories

Standard catalog conveyors	30%
MPB Series, cleated and specialty belt conveyors	50%
7400 & 7600 Series conveyors	non-returnable items
Engineered special products	case by case
Drives and accessories	30%
Sanitary stand supports	non-returnable items

## Parts

Standard stock parts	30%
MPB, cleated and specialty belts	non-returnable items

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 Technical Sales, Catalog Sales and Service Teams will gladly help with your questions on Dorner products.

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

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



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