



# 7350 Series Version 2 Modular Belt Conveyors

Installation, Maintenance and Parts Manual



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<hr/> <p>Record Conveyor Serial Number Here</p>
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 **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 7350 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 Critical 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. Recommended Critical Service Parts and Kits are marked in the Service Parts section of this manual with the Key Service Parts symbol .

# Warnings – General Safety

**⚠ WARNING**

The safety alert symbol, black triangle with white exclamation, is used to alert you to potential personal injury hazards.

**⚠ DANGER**



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


**⚠ 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!**

- 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.

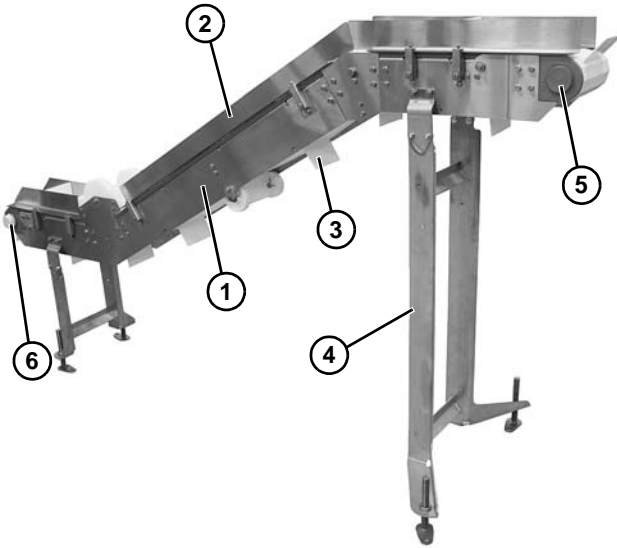
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# Product Description

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Refer to **(Figure 1)** for typical conveyor components.

1	Conveyor
2	Guides (If Equipped)
3	Belt (Cleated Belt Shown)
4	Support Stands
5	Drive End
6	Idler End



**Figure 1**

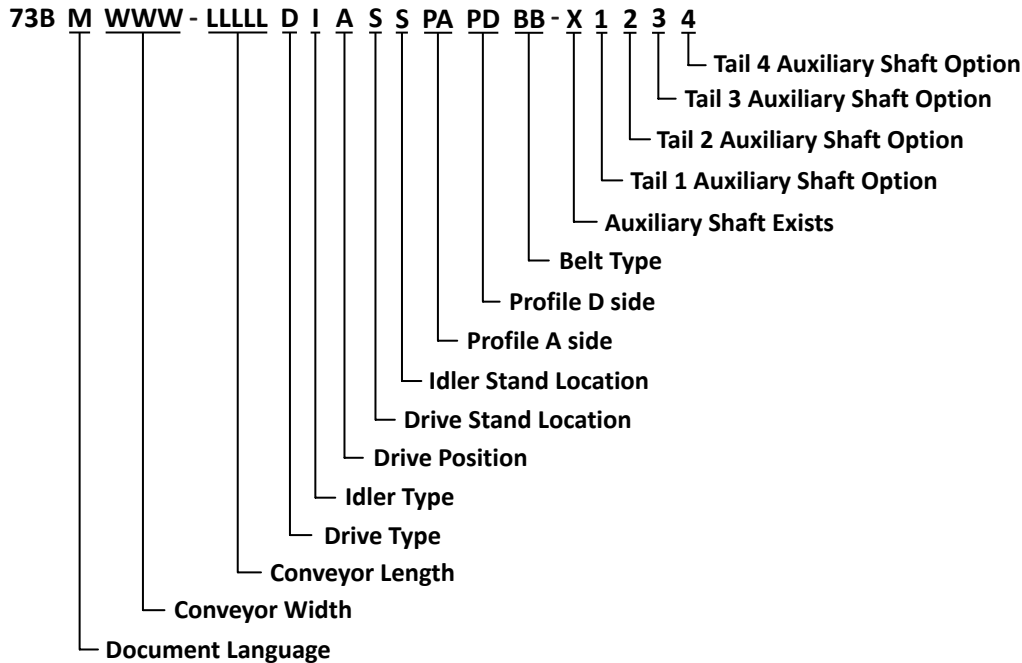
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# Specifications

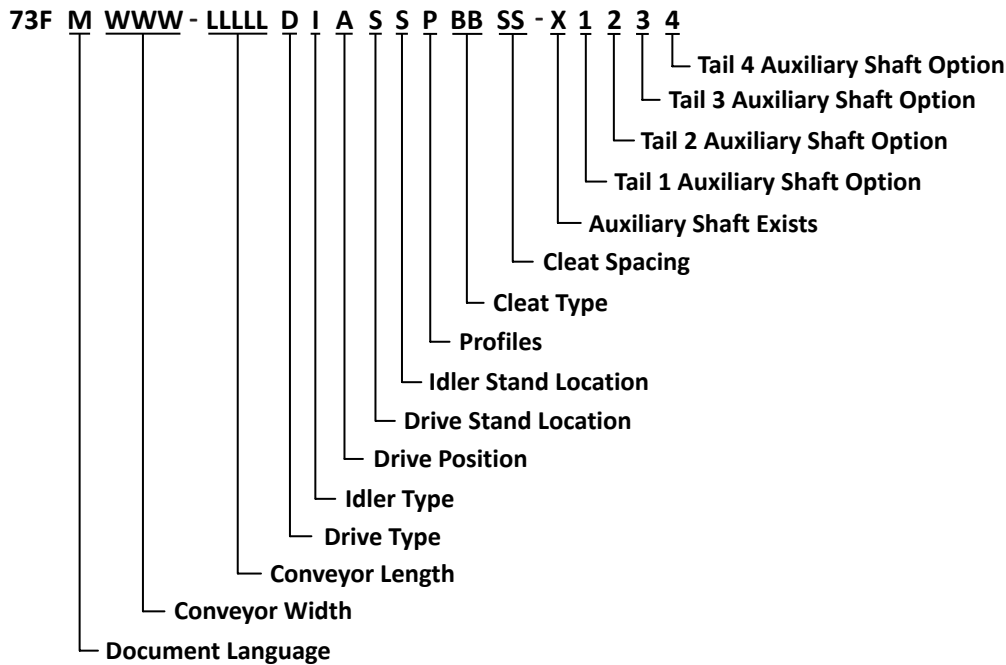
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## 7350 Series Version 2 Modular Belt Conveyors

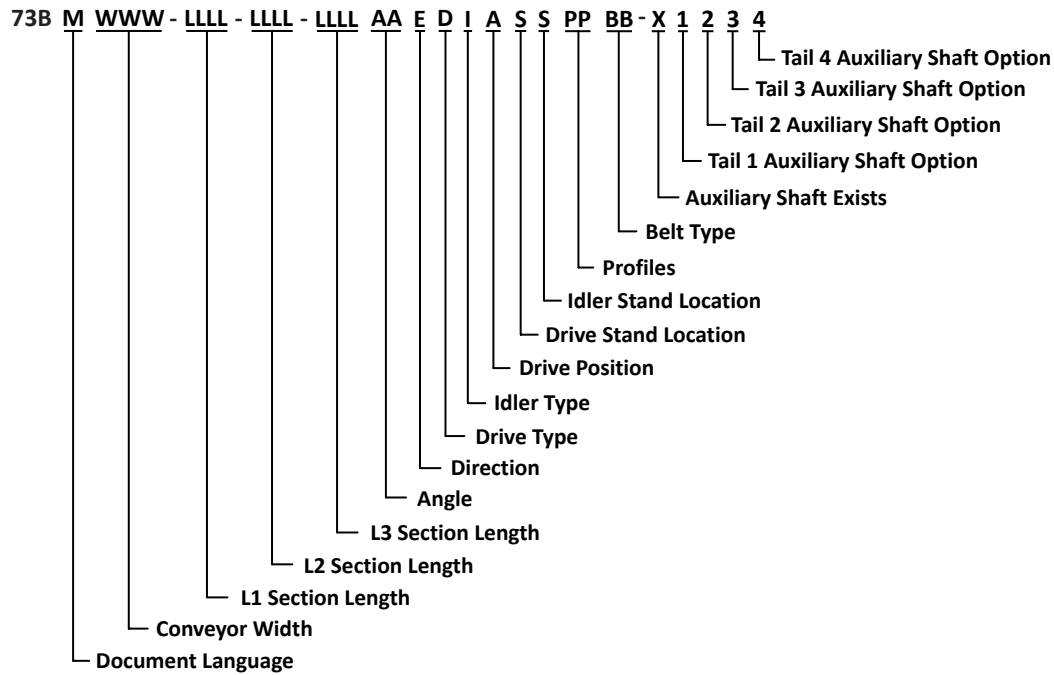
### Flat Belt 7350 Series Version 2



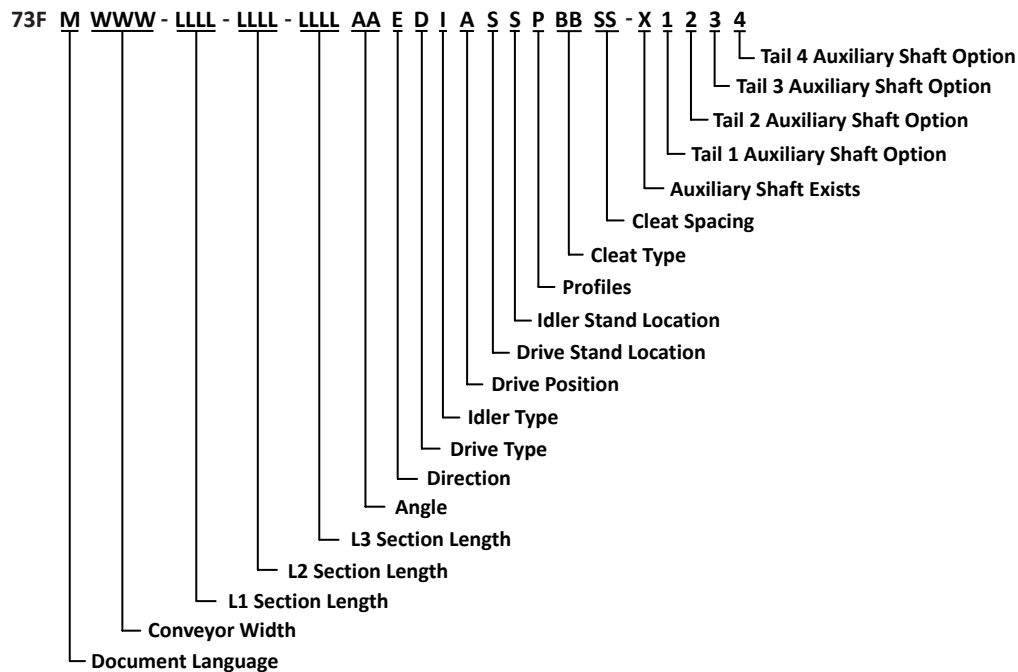
### Cleated Belt 7350 Series Version 2



## Flat Belt LPZ 7350 Series Version 2



## Cleated Belt LPZ 7350 Series Version 2

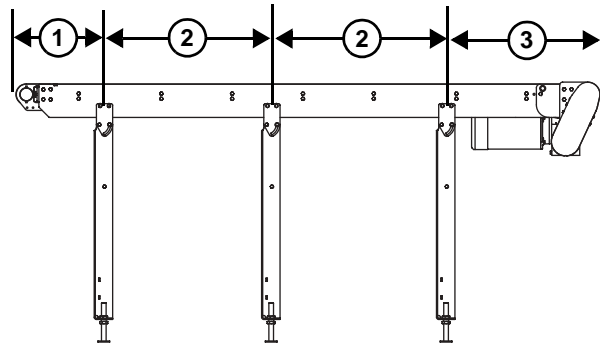


# Specifications

## Conveyor Supports

**Maximum Distances:**

- 1 = Support Stand on Idler End = 762 mm (30")
  - 2 = Between Support Stands = 2438 mm (8 ft)\*\*
  - 3 = Support Stand on Drive End = 610 mm (24")
- \*\* For conveyors longer than 3048 mm (10 ft), install stand mount kit at frame joint.



**Figure 2**

## Specifications

Conveyor Width Reference ( <u>WWW</u> )	203, 254, 305, 356, 406, 457, 508, 559, 610, 660, 711, 762, 813, 864, 914
Conveyor Belt Width	203 mm (8"), 254 mm (10"), 305 mm (12"), 356 mm (14"), 406 mm (16"), 457 mm (18"), 508 mm (20"), 559 mm (22"), 610 mm (24"), 660 mm (26"), 711 mm (28"), 762 mm (30"), 813 mm (32"), 864 mm (34"), 914 mm (36")
Maximum Conveyor Load (See NOTE Below)	97 kg/ m <sup>2</sup> (20 lbs. / ft <sup>2</sup> ) with a maximum of 340 kg (750 lbs.)
Belt Travel	305 mm (12") per revolution of pulley
Maximum Belt Speed	79 m/minute (260 ft/minute)
Conveyor Length Reference ( <u>LLLLL</u> )	0915 – 25000 in 00005 increments
Conveyor Length	915 mm (36") - 25000 mm (984.25") in 5 mm (.20") 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



## CAUTION

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

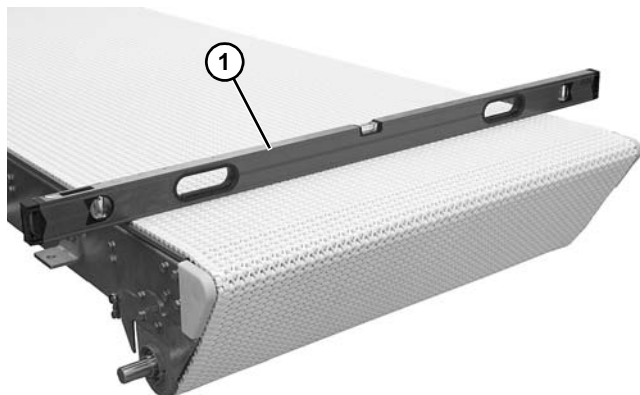


Figure 3

## Required Tools

- Level
- Torque wrench
- 5/32" hex wrench
- 13 mm wrench
- 14 mm wrench
- 17 mm wrench

## Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to "Conveyors Longer than 10 ft (3048 mm)" on page 9.
2. Attach the stands. Refer to "Stand Installation" on page 11.
3. Install the belt. Refer to "Belt Installation" on page 11.
4. Install the gearmotor. Refer to "Drive Package Installation" on page 17.

## Conveyors Longer than 10 ft (3048 mm)

### Connecting Components

Typical connecting components (Figure 4).

- |   |                         |
|---|-------------------------|
| 1 | Connecting Plate (x2)   |
| 2 | Hex Head Cap Screw (x8) |
| 3 | Conveyor Frames         |

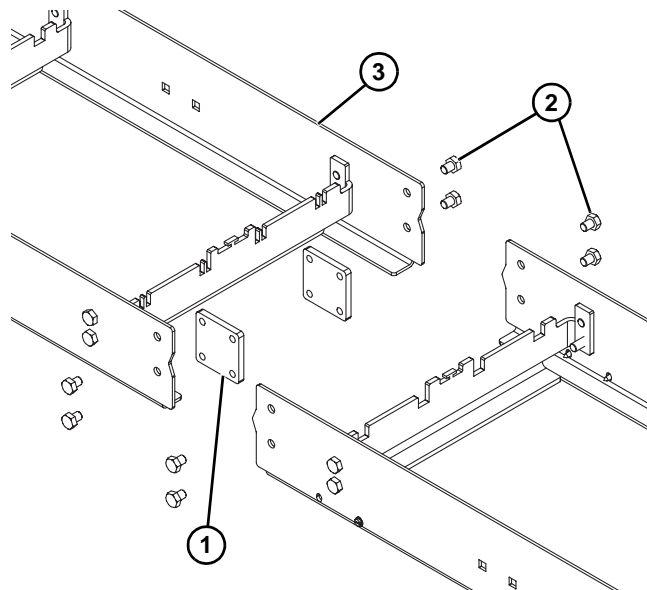


Figure 4

1. Locate and arrange conveyor sections by section labels (Figure 5, item 1).



Figure 5

2. Join both conveyor sections and install connecting plates (Figure 4, item 1) with four M8x10 hex head cap screws (Figure 4, item 2) on both sides.

# Installation

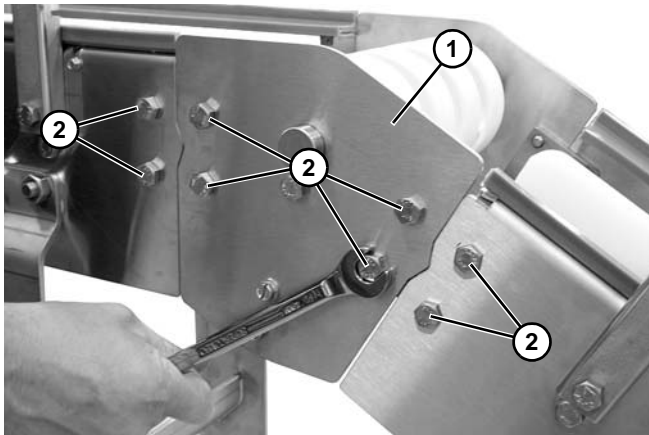
## Z-Frame Conveyors

### NOTE

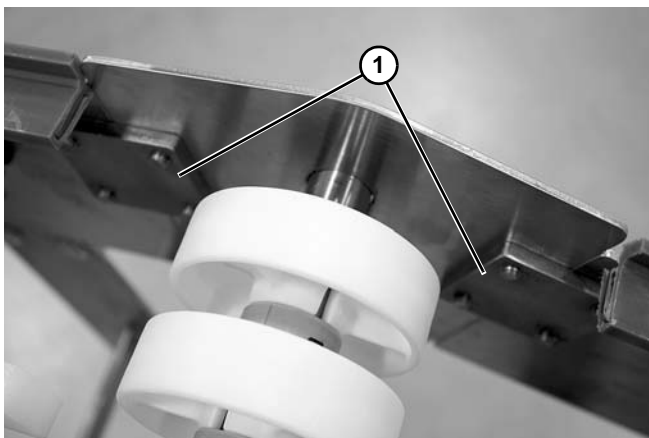
*Be sure all frame sections are properly supported during Z-Frame assembly.*

### Upper Knuckles

1. Attach upper knuckle (**Figure 6, item 1**) to frame using four bolts (**Figure 6, item 2**) and two plates (**Figure 7, item 1**) on each side of the upper knuckle assembly.



**Figure 6**

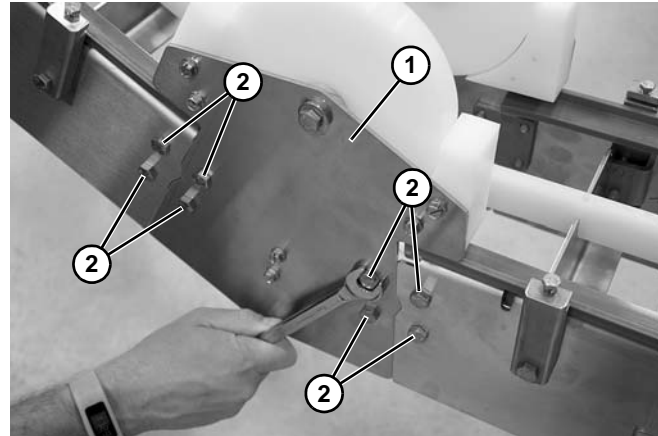


**Figure 7**

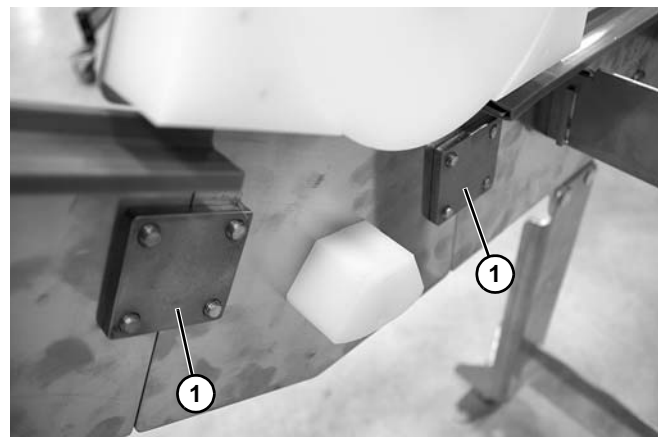
2. Tighten all bolts to 60 in-lb (7 Nm).

### Lower Knuckles

1. Attach lower knuckle (**Figure 8, item 1**) to frame using four bolts (**Figure 8, item 3**) and two plates (**Figure 9, item 1**) on each side of the lower knuckle assembly.



**Figure 8**



**Figure 9**

2. Tighten all bolts to 60 in-lb (7 Nm).

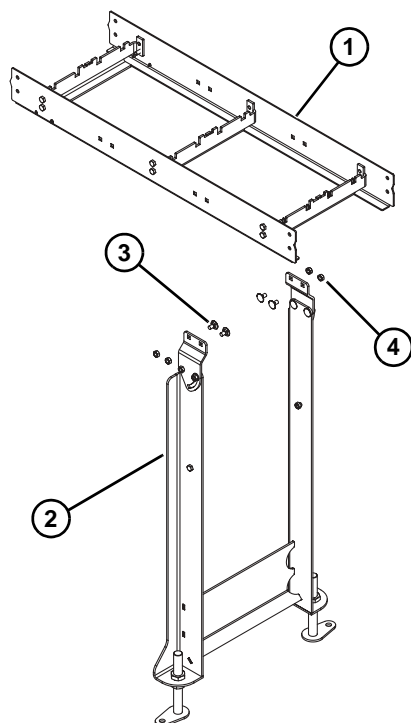
## Stand Installation

### NOTE

For detailed assembly instructions, please see support stand manual 851-885.

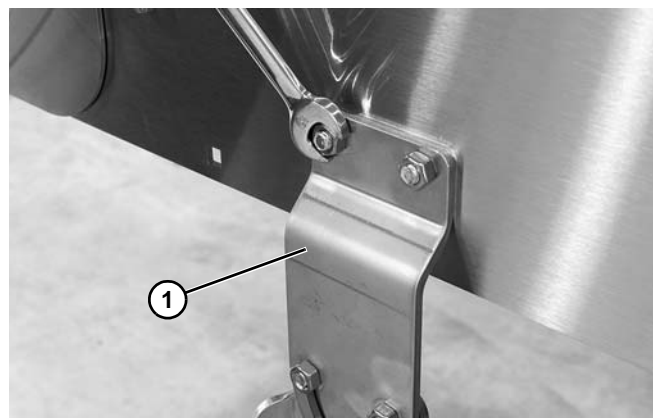
Typical stand components (**Figure 10**).

- |   |                    |
|---|--------------------|
| 1 | Conveyor Frame     |
| 2 | Stand              |
| 3 | Carriage Bolt (x4) |
| 4 | Hex Nut (x4)       |



**Figure 10**

1. Position the stands on a flat, level surface.
2. Attach the stands (**Figure 11, item 1**) to the frame.

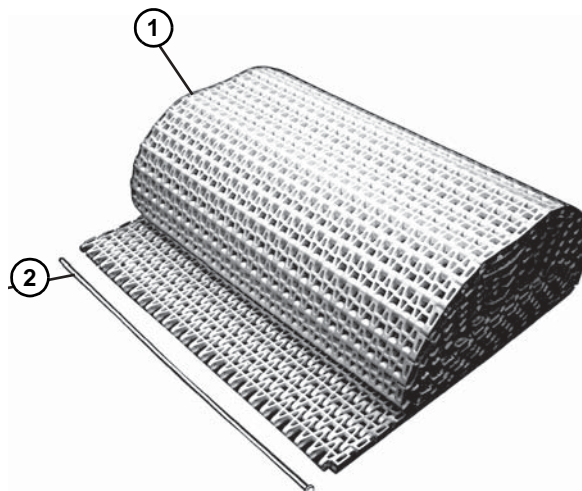


**Figure 11**

## Belt Installation

Typical belt components (**Figure 12**).

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



**Figure 12**

1. Position the belt on the conveyor frame (**Figure 13**).

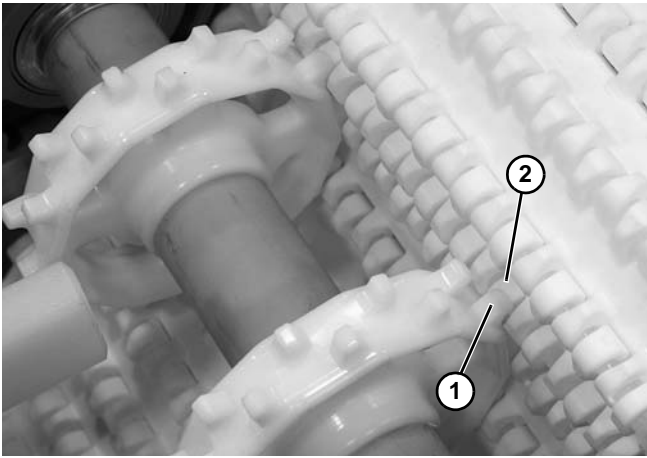


**Figure 13**

2. Wrap belt around idler tail.

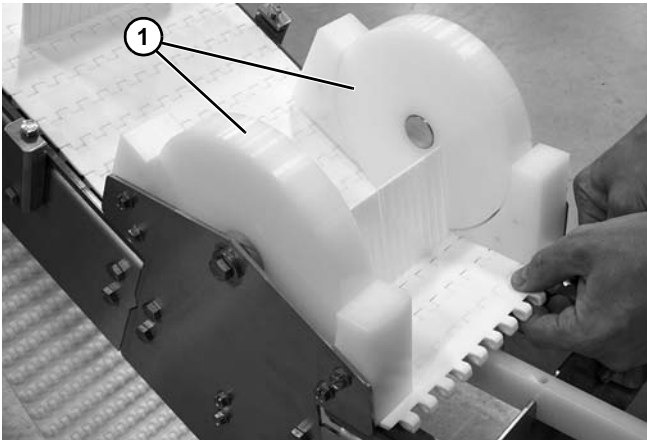
# Installation

3. Wrap the belt around the drive end of the conveyor. Make sure that the sprocket teeth have engaged the belt, with concave teeth (**Figure 14, item 1**) mating with rounded section (**Figure 14, item 2**) of belt.



**Figure 14**

4. For Z-Frame conveyors, guide the belt under the hold down guides (**Figure 15, item 1**) in the lower knuckle.



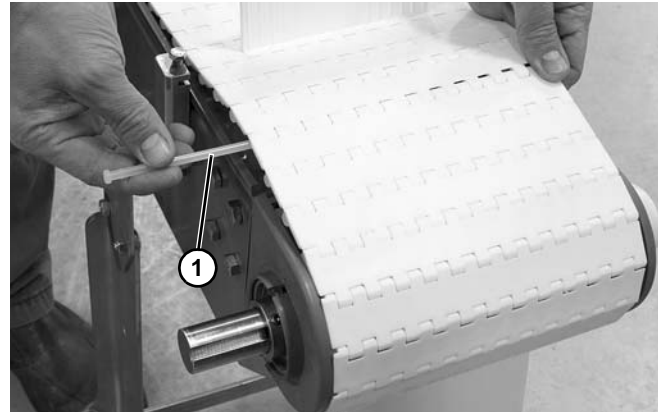
**Figure 15**

5. Bring the ends of the belt together (**Figure 16**).



**Figure 16**

6. Insert the belt rod (**Figure 17, item 1**).



**Figure 17**

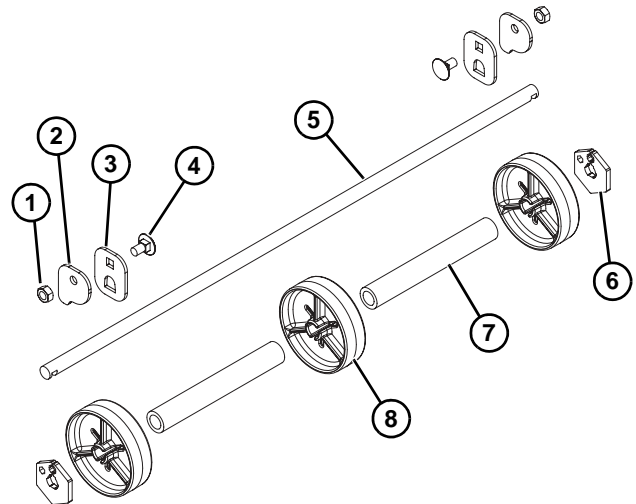
7. Push the belt rod in as far as possible.
8. Lightly tap the head of the rod with a hammer until it snaps into position.

## Belt Returns

### Flat Belt Returns 610 mm Wide and Wider

Typical return components (**Figure 18**).

- |   |                 |
|---|-----------------|
| 1 | Hex Nut         |
| 2 | Return Clip     |
| 3 | Return Bracket  |
| 4 | Carriage Bolt   |
| 5 | Shaft           |
| 6 | Retaining Plate |
| 7 | Spacer          |
| 8 | Puck            |



**Figure 18**



# Installation

1. Install carriage bolt (Figure 19, item 1) through frame rail.

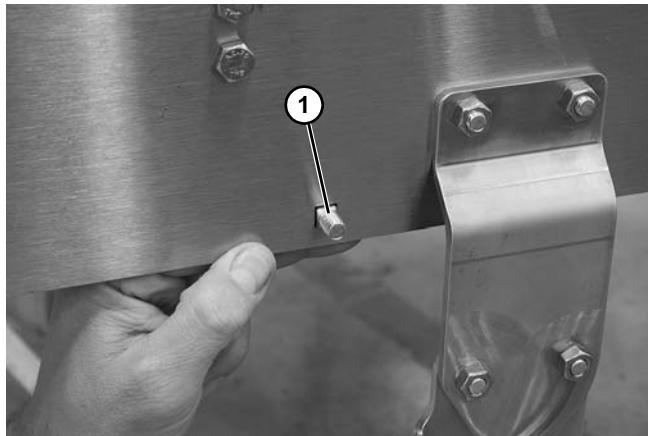


Figure 19

2. Install return bracket (Figure 20, item 1).

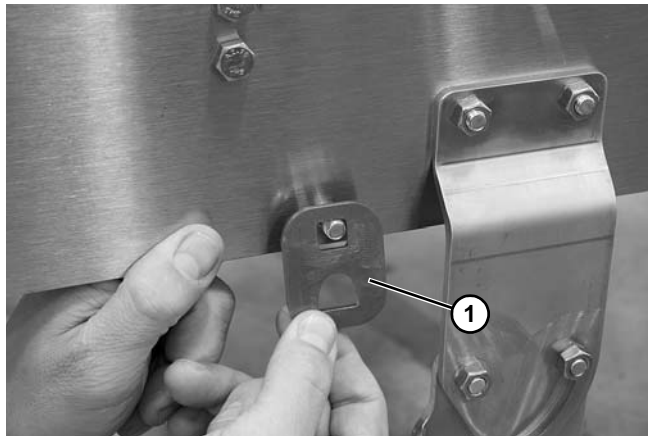


Figure 20

3. Install return clip (Figure 21, item 1) and loosely secure with nut (Figure 21, item 2).

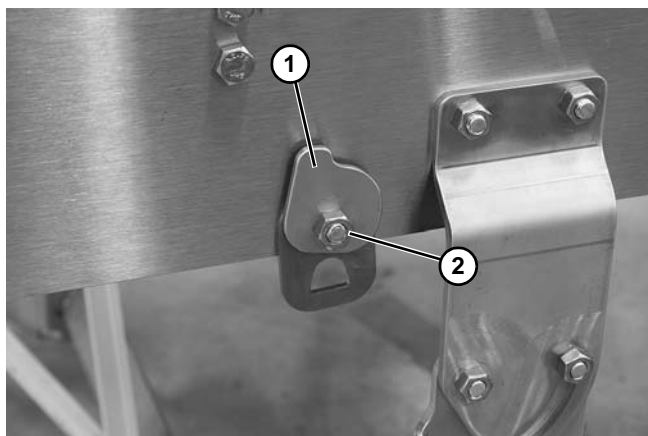


Figure 21

4. Repeat on the opposite side of the conveyor.

5. Install belt return assembly (Figure 22, item 1) onto return brackets (Figure 22, item 2).

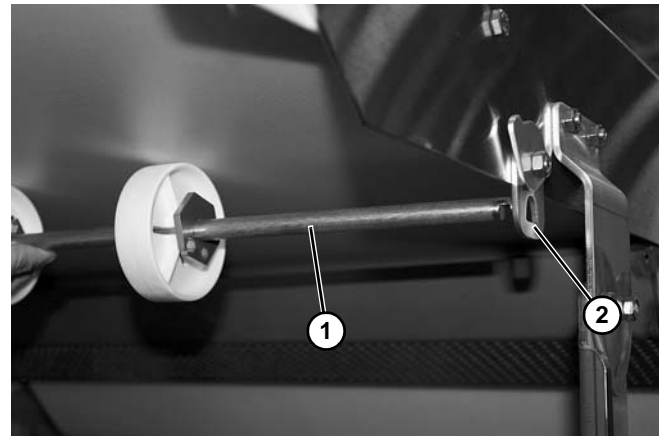


Figure 22

6. Rotate return clip (Figure 23, item 1) down against shaft (Figure 23, item 2) on both sides of conveyor. Tighten nuts (Figure 23, item 3).

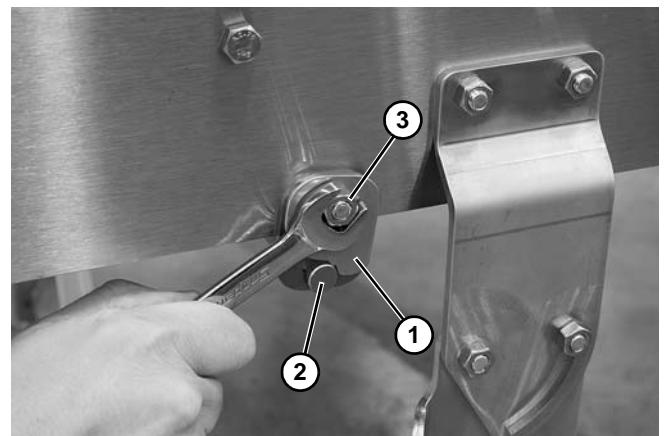


Figure 23

7. Check belt sag by measuring from the bottom of conveyor frame (Figure 24). Belt sag should not exceed 2" (51 mm).

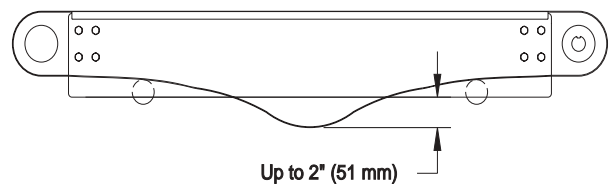


Figure 24

## ⚠ CAUTION

Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame.

# Installation

## Cleated Belt and Flat Belt Returns Under 610 mm Wide

Typical return components (Figure 25).

- |   |                |
|---|----------------|
| 1 | Spacer         |
| 2 | Puck           |
| 3 | Stub Shaft     |
| 4 | Hex Nut        |
| 5 | Return Clip    |
| 6 | Return Bracket |
| 7 | Carriage Bolt  |

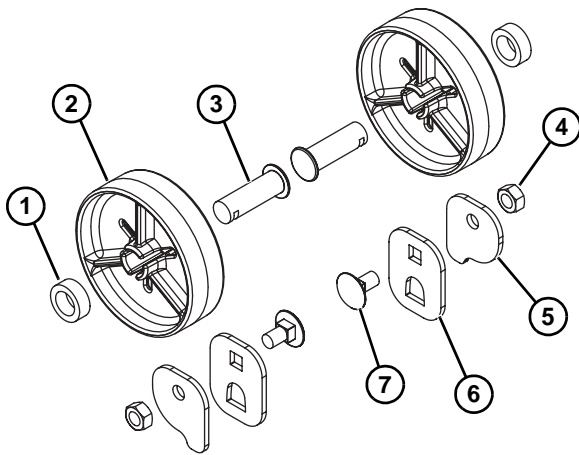


Figure 25

1. Install carriage bolt (Figure 26, item 1) through frame rail.

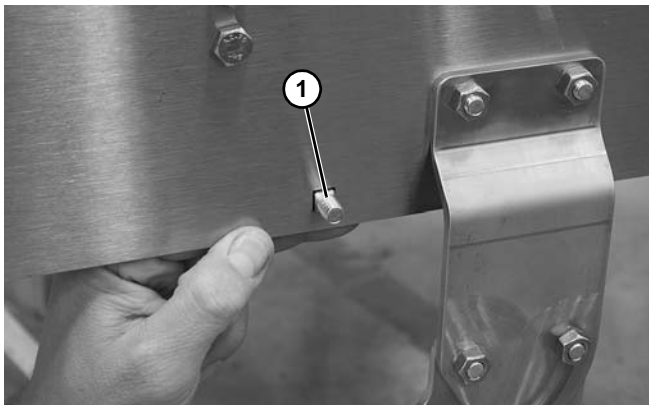


Figure 26

2. Install return bracket (Figure 27, item 1).



Figure 27

3. Install return clip (Figure 28, item 1) and loosely secure with nut (Figure 28, item 2).

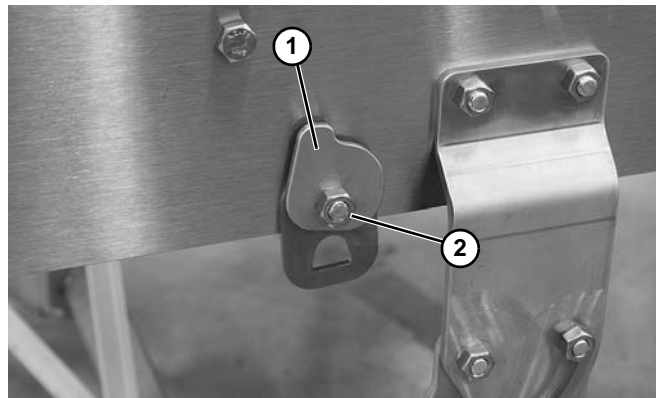


Figure 28

4. Repeat on the opposite side of the conveyor.
5. Install each puck (Figure 29, item 1) onto return bracket (Figure 29, item 2) with stub shaft (Figure 29, item 3) and spacer (Figure 29, item 4).

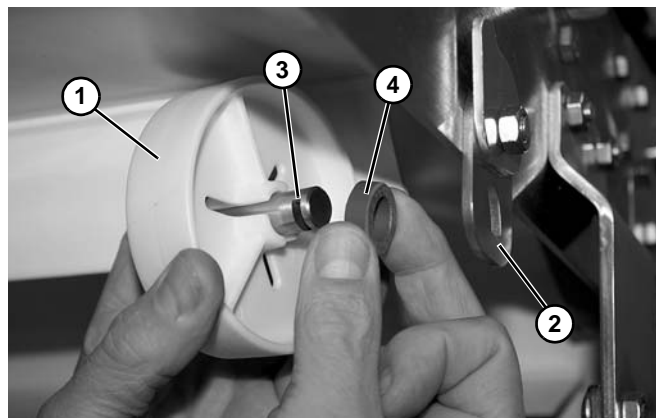
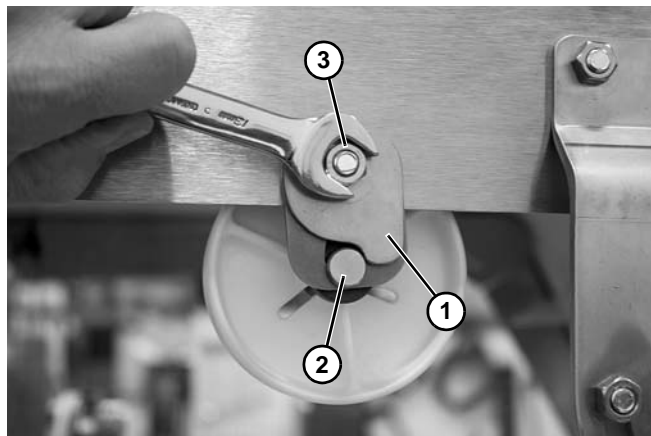


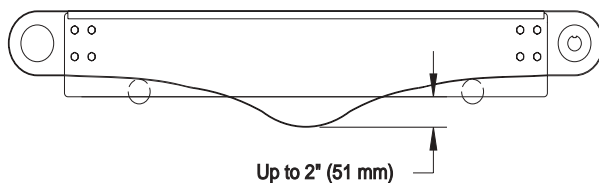
Figure 29

- Rotate return clip (**Figure 30, item 1**) down against stub shaft (**Figure 30, item 2**) on both sides of conveyor. Tighten nuts (**Figure 30, item 3**).



**Figure 30**

- Check belt sag by measuring from the bottom of conveyor frame (**Figure 31**). Belt sag should not exceed 2" (51 mm).



**Figure 31**

**⚠ CAUTION**

Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame.

## Guide Installation

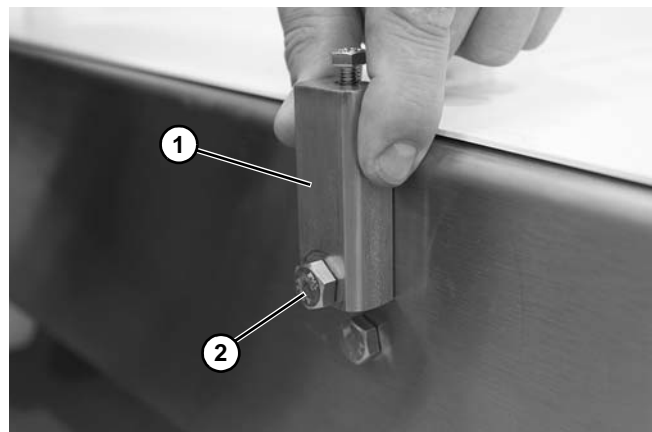
### High Side Guides

- Remove and discard the top bolt (**Figure 32, item 1**) from the conveyor side.



**Figure 32**

- Assemble the mounting block (**Figure 33, item 1**) to the conveyor side with the bolt (**Figure 33, item 2**) provided with the mounting block.



**Figure 33**

# Installation

3. Install guide (Figure 34, item 1) into the slot (Figure 34, item 2) of the mounting block and tighten bolts (Figure 34, item 3).

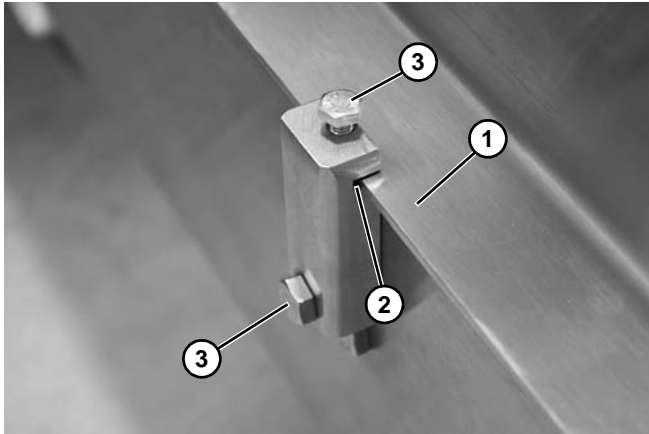


Figure 34

4. Install the connecting plate (Figure 35, item 1) over the studs.

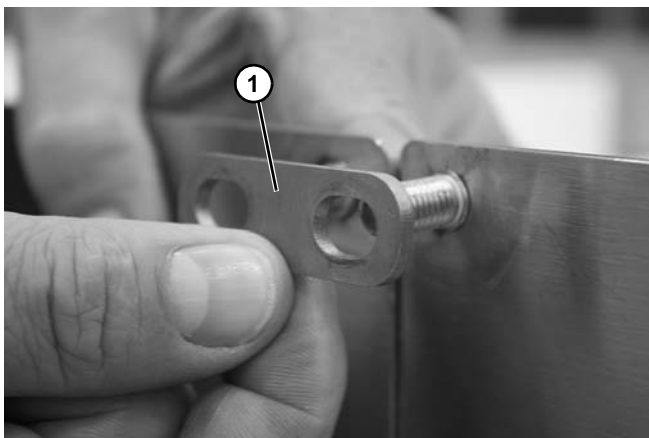


Figure 35

5. Install nuts (Figure 36, item 1) and tighten.

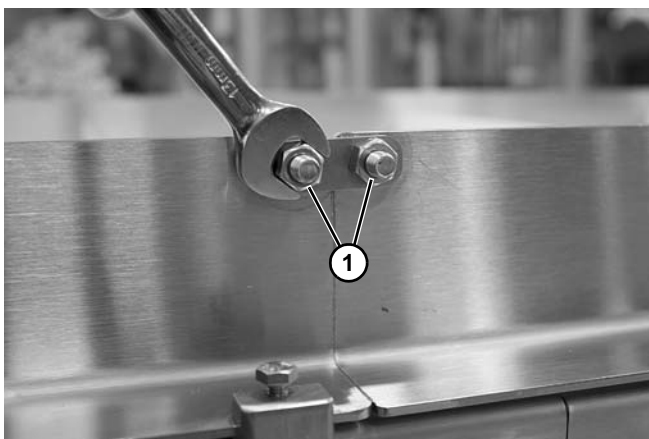


Figure 36

## Adjustable Guides

1. Remove the top bolt (Figure 37, item 1) and loosen the bottom bolt (Figure 37, item 2).

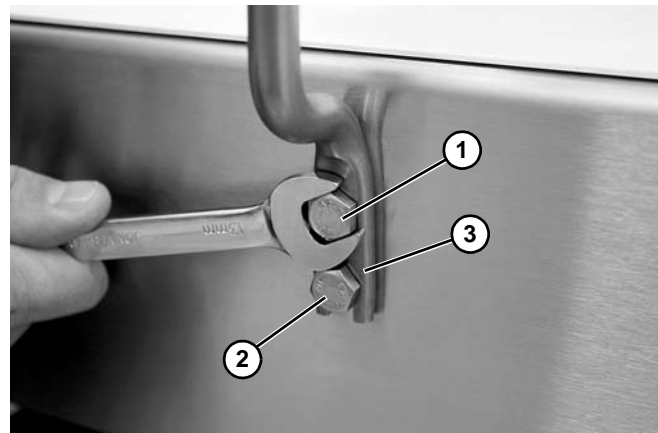


Figure 37

2. Install the guide post (Figure 37, item 3) behind lower bolt. Reinstall top bolt and tighten bolts.
3. Install guide rail (Figure 38, item 1) into rail clamp. Tighten fastener to secure (Figure 38, item 2).

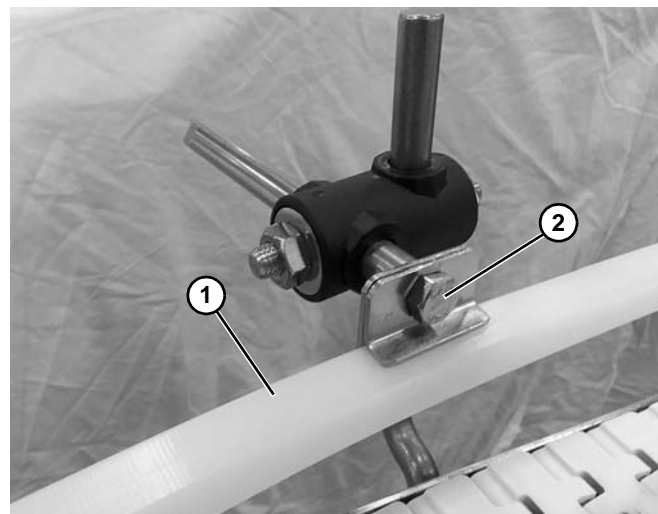


Figure 38

### NOTE

See pages 50 to 53 for detailed view of guide assembly.

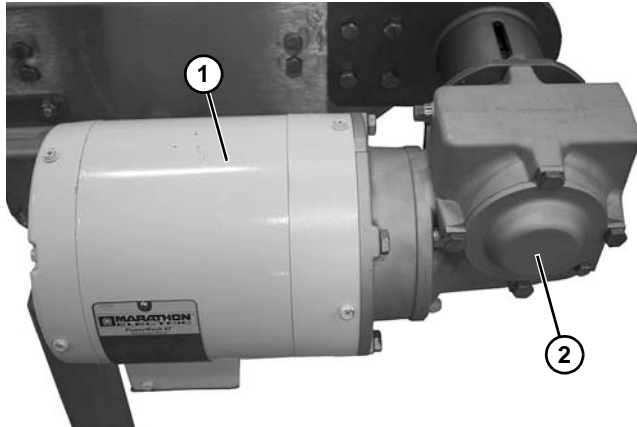


## Drive Package Installation

For detailed assembly instructions, refer to the appropriate drive package manual:

- 851-881 7350 Series Version 2 Side Mount Drives
- 851-882 7350 Series Version 2 Nose Bar Drives
- 851-883 7350 Series Version 2 Bottom Mount Drives

1. Attach the motor (**Figure 39, item 1**) to the gear reducer (**Figure 39, item 2**).



**Figure 39**

---

# Preventive Maintenance and Adjustment

---

## Required Tools

- 1/8" hex wrench
- 3/8" wrench
- 4 mm hex wrench
- 5 mm hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 13 mm wrench
- Punch and hammer (to remove belt rod)
- Flat head screwdriver

## Checklist

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

## Cleaning

### NOTE

*Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.*

### ⚠ CAUTION

**Dorner recommends cleaning all the "food zones" prior to placing conveyor into service. Ensure adequate access is provided for cleaning and servicing equipment so that the required level of hygiene can be maintained.**

### ⚠ WARNING



### SEVERE HAZARD!

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

## Maintaining the Conveyor Belt

### Troubleshooting

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

## Lubrication

No lubrication is required. Replace bearings if worn.

# Preventive Maintenance and Adjustment

## Conveyor Belt Replacement

<b>⚠ WARNING</b>

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

1. Remove guides (Figure 40, item 1) when required.

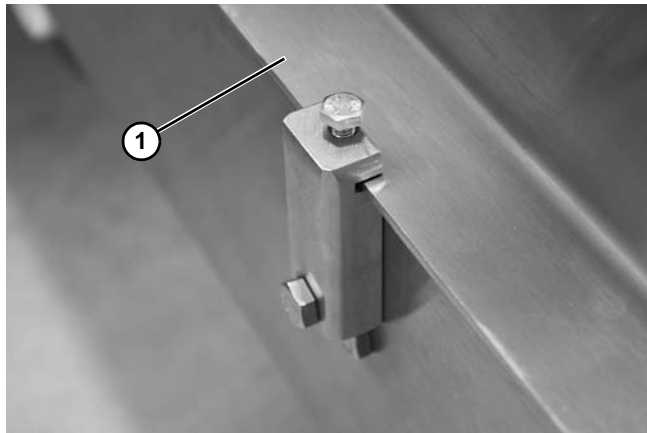


Figure 40

2. Use a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head (Figure 41).



Figure 41

3. Slide the old belt off the conveyor frame.
4. Replace the old belt with a new one. Refer to "Belt Installation" on page 11.

<b>⚠ CAUTION</b>
<b>DO NOT</b> reuse belt rods that are damaged or show signs of wear.

## Conveyor Belt Tensioning

<b>⚠ WARNING</b>

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

<b>NOTE</b>
<i>Belt should not be stretched during installation. A proper length of belt can be installed by interlocking the ends by hand without excess links.</i>

1. Remove one or more belt links to take up tension.

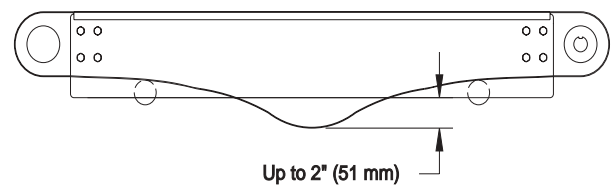


Figure 42

<b>⚠ CAUTION</b>
<b>Belt sag should not exceed 2" (51 mm) from the bottom of the conveyor frame (Figure 42).</b>

# Preventive Maintenance and Adjustment

## Wear Strips

Replace the wear strips if they become worn.

Typical standard wear strips (Figure 43).

- |   |                    |
|---|--------------------|
| 1 | Side Wear Strips   |
| 2 | Center Wear Strips |

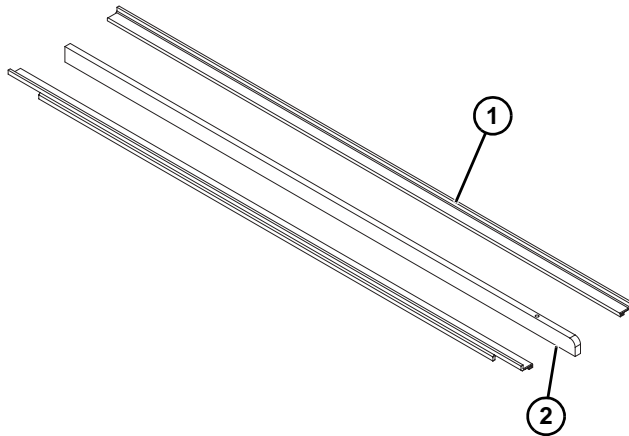


Figure 43

## Wear Strip Removal

1. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 19.
2. Remove worn wear strips (Figure 44, item 1) from the frame notches.

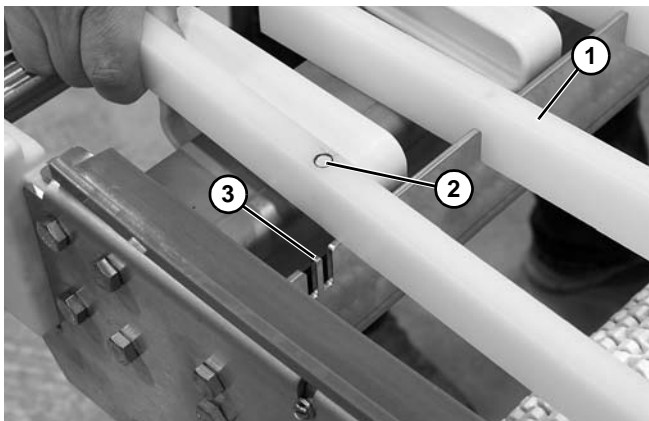


Figure 44

3. Attach new wear strips by installing the locating hole (Figure 44, item 2) over the tab (Figure 44, item 3) on the crossmember.

### NOTE

Rounded end of the wear strip must face up.

## Side Rail Wear Strip Replacement

1. Remove two self-tapping screws (Figure 45, item 1) retaining the wear strip to the frame.

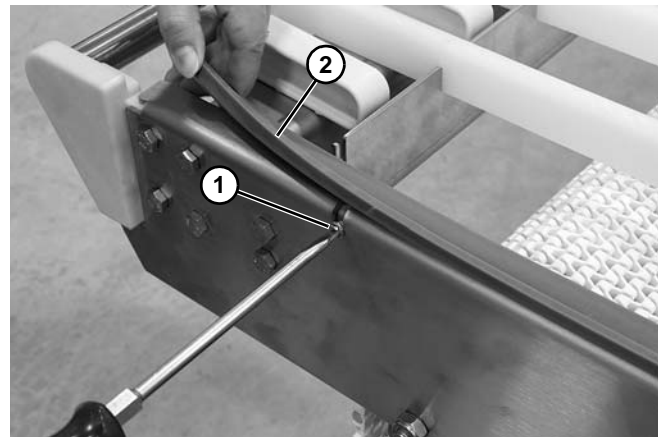


Figure 45

2. Remove the wear strip (Figure 45, item 2) from the frame rail.
3. Replace with new wear strip.

## Drive Sprocket and Spindle Replacement

### WARNING



### SEVERE HAZARD!

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

### WARNING



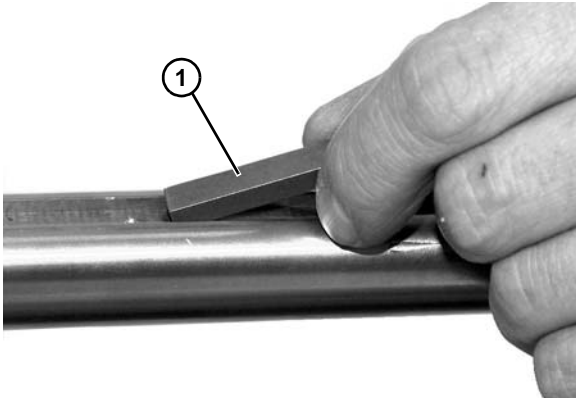
### PUNCTURE HAZARD!

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

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Open conveyor belt. Refer to “Conveyor Belt Replacement” on page 19.

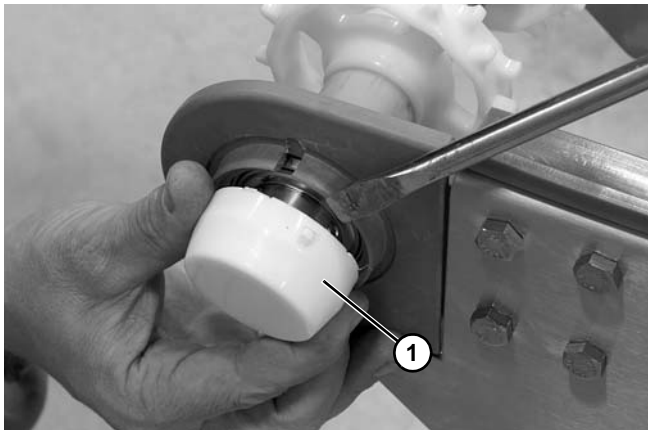
# Preventive Maintenance and Adjustment

3. Remove output shaft key (Figure 46, item 1).



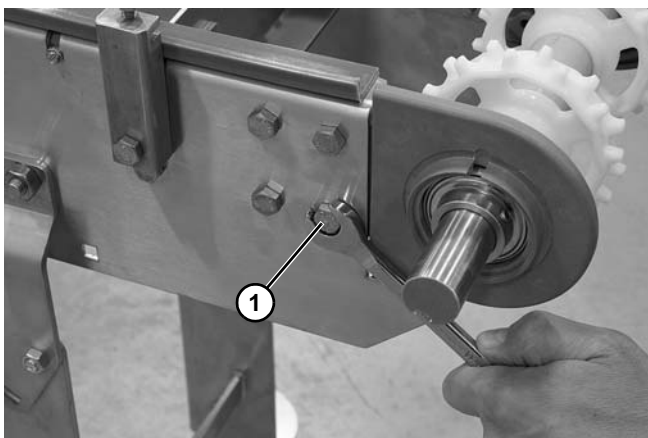
**Figure 46**

4. Remove bearing cap (Figure 47, item 1).



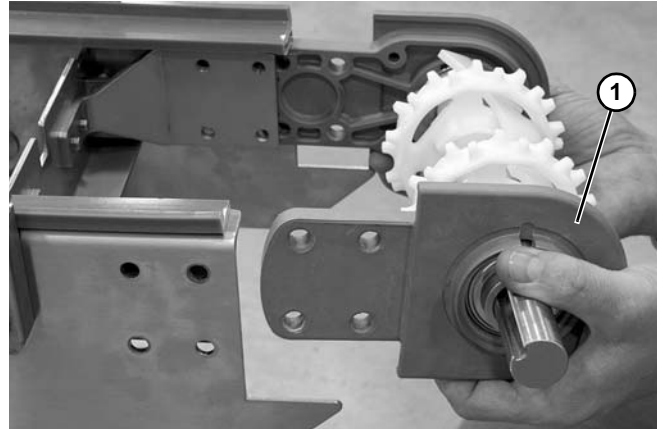
**Figure 47**

5. Remove the four headplate bolts (Figure 48, item 1) on both sides of the conveyor.



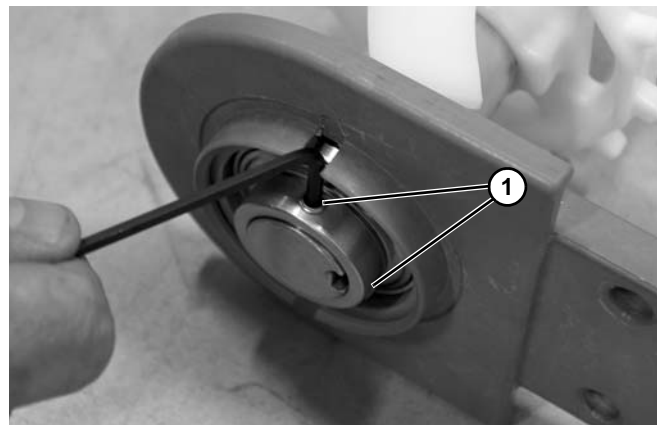
**Figure 48**

6. Remove the tail assembly (Figure 49, item 1).



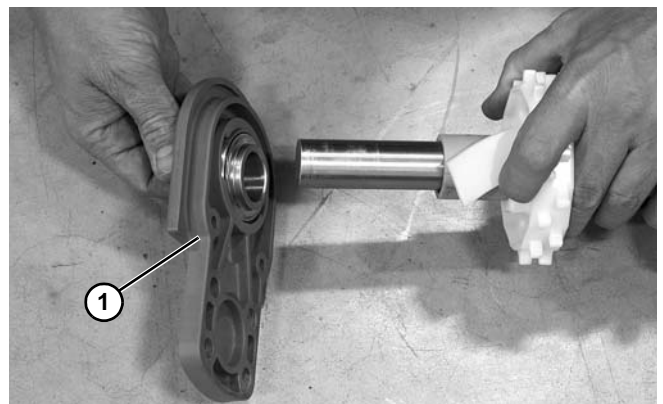
**Figure 49**

7. Loosen set screws (Figure 50, item 1).



**Figure 50**

8. Slide the headplate with bearing (Figure 51, item 1) off the drive spindle.



**Figure 51**

9. Replace bearing if worn. Refer to "Bearing Replacement" on page 27.

# Preventive Maintenance and Adjustment

10. Slide the spacer (Figure 52, item 1) off the drive spindle.

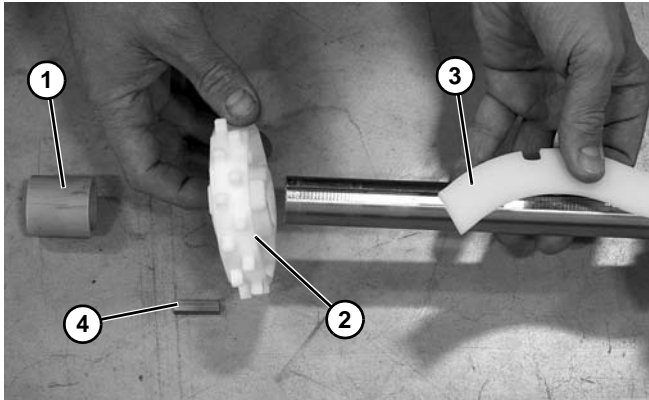


Figure 52

11. Slide entire sprocket assembly slightly outward, and remove the first sprocket (Figure 52, item 2) off the drive spindle and alignment key (Figure 52, item 3).
12. Remove drive spindle key (Figure 52, item 4).
13. Remove remaining sprockets off the alignment key while sliding the entire assembly off the drive spindle.
14. Install parts in reverse order of removal.

## NOTE

To reassemble please note the placement of the sprockets on the alignment key.

## Nose Bar Drive Sprocket and Spindle Replacement

### Nose Bar Spindle Replacement

#### ⚠ WARNING



#### SEVERE HAZARD!

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

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Open conveyor belt. Refer to "Conveyor Belt Replacement" on page 19.

3. Remove the four headplate bolts (Figure 53, item 1).

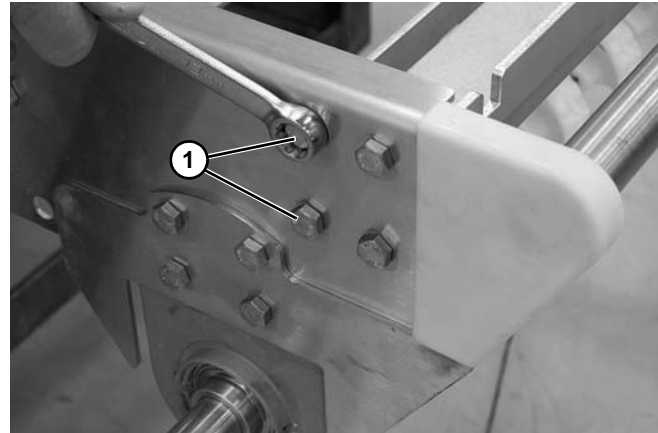


Figure 53

4. Remove headplate (Figure 54, item 1) and spindle assembly (Figure 54, item 2).

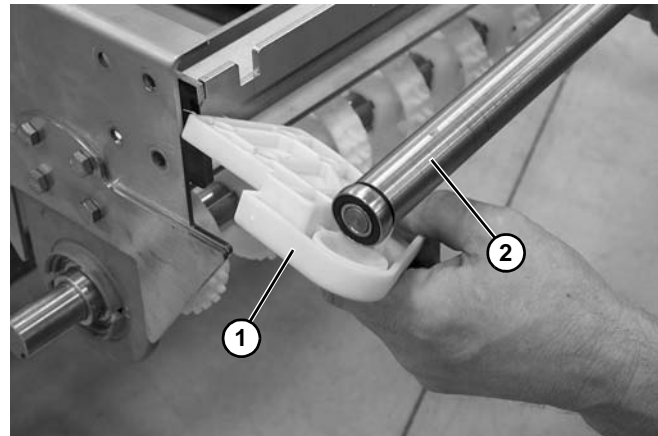


Figure 54

5. Replace spindle assembly if worn.
6. Install parts in reverse order of removal.





# Preventive Maintenance and Adjustment

## Nose Bar Drive Sprocket Replacement

 <b>WARNING</b>

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

 <b>WARNING</b>

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

1. Remove the gearmotor. For detailed instructions, refer to the appropriate drive package manual.
2. Open conveyor belt. Refer to “Conveyor Belt Replacement” on page 19.
3. Remove output shaft key (Figure 55, item 1).

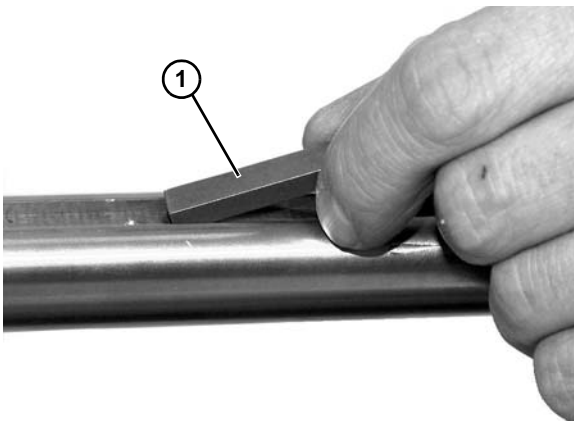


Figure 55

4. Remove bearing cap (Figure 56, item 1).

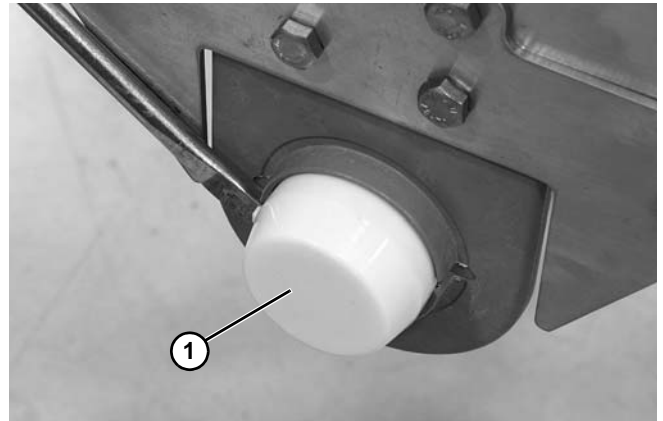


Figure 56

5. Loosen set screws (Figure 57, item 1).

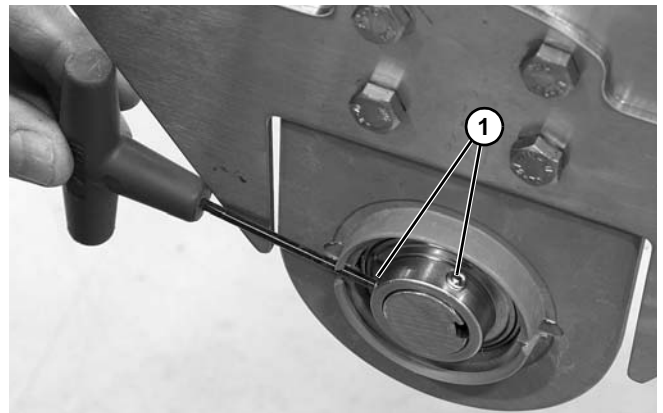


Figure 57

6. Remove the four headplate bolts (Figure 58, item 1).

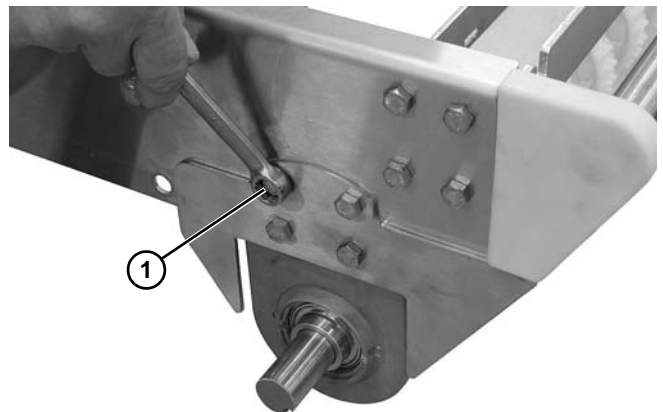
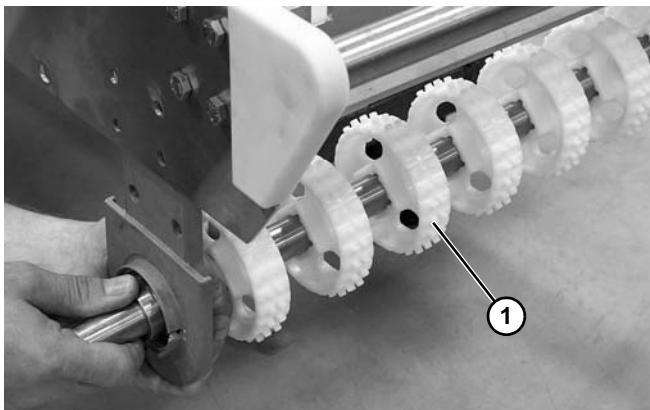


Figure 58

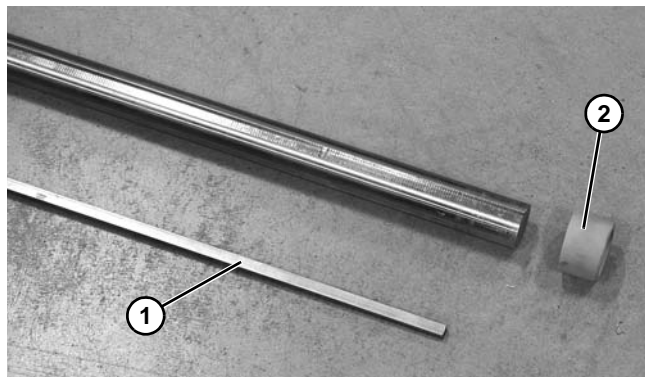
# Preventive Maintenance and Adjustment

7. Remove the tail assembly (**Figure 59, item 1**).



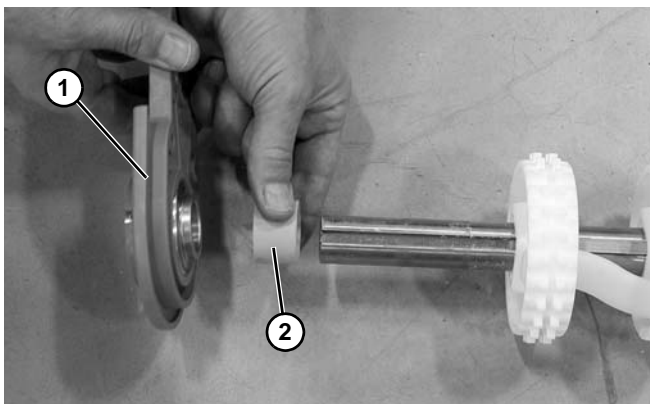
**Figure 59**

12. Remove drive spindle key (**Figure 62, item 1**) and spacer (**Figure 62, item 2**).



**Figure 62**

8. Slide the headplate with bearing (**Figure 60, item 1**) and spacer (**Figure 60, item 1**) off the drive spindle.



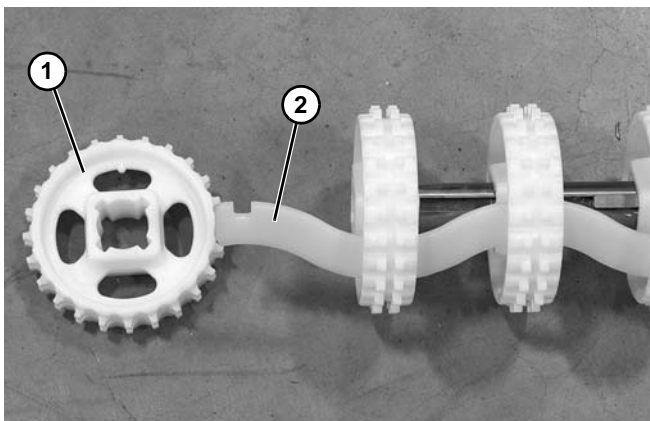
**Figure 60**

13. Install parts in reverse order of removal.

## NOTE

*To reassemble please note the placement of the sprockets on the alignment key.*

9. Replace bearing if worn. Refer to “Bearing Replacement” on page 27.
10. Slide entire sprocket assembly slightly outward, and remove the first sprocket (**Figure 61, item 1**) off the drive spindle and alignment key (**Figure 61, item 2**).




**Figure 61**

11. Remove remaining sprockets off the alignment key while sliding the entire assembly off the drive spindle.



# Preventive Maintenance and Adjustment

## Idler Puck and Spindle Replacement

<b>⚠ WARNING</b>

<b>SEVERE HAZARD!</b> LOCK OUT POWER before removing guards or performing maintenance. Exposed moving parts can cause serious injury.
<b>NOTE</b>
<i>Idler tails are equipped with plain bushing pucks, replace when worn.</i>

1. Open conveyor belt. Refer to “Conveyor Belt Replacement” on page 19.
2. Remove the four headplate bolts (Figure 63, item 1).

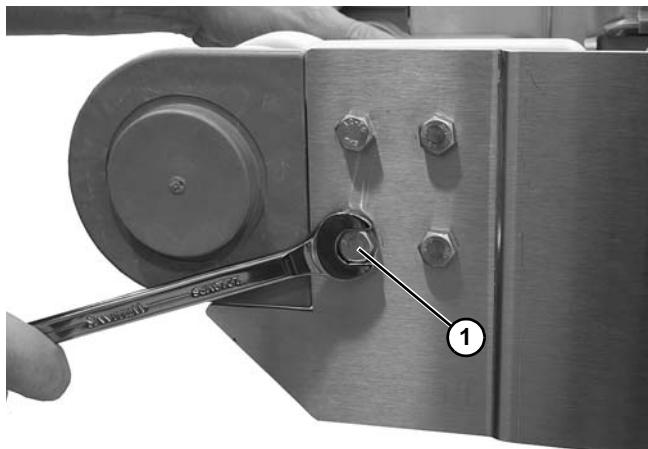


Figure 63

3. Remove headplate (Figure 64, item 1) and idler spindle assembly (Figure 64, item 2).

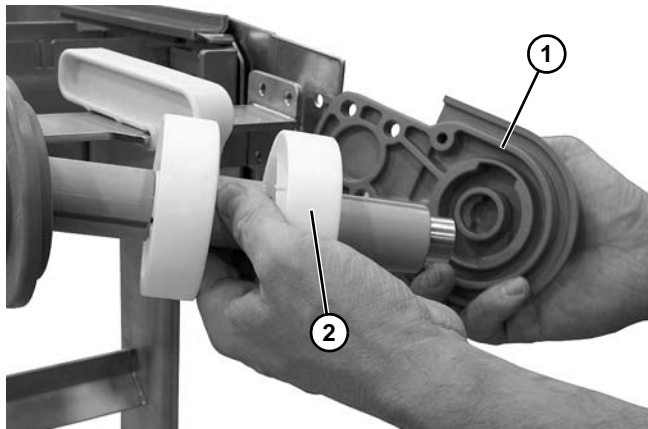


Figure 64

4. Slide off the spacer (Figure 65, item 1).

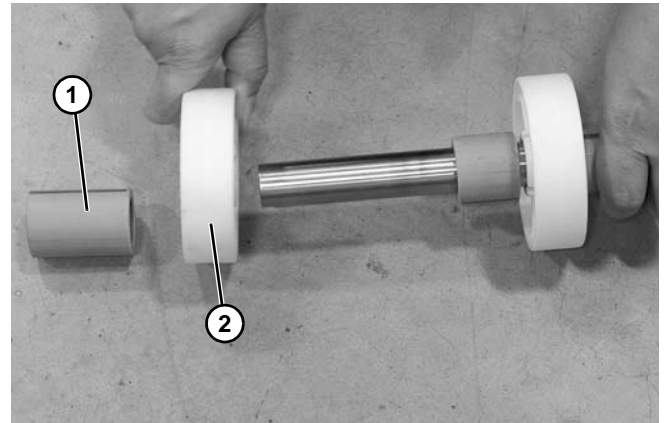


Figure 65

5. Slide off the puck and replace (Figure 65, item 2).
6. Repeat as needed.
7. Remove and replace belt shoe if worn (Figure 66, item 1).

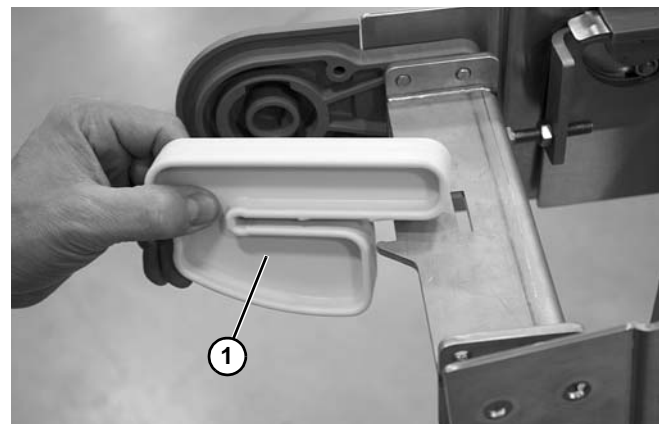


Figure 66

# Preventive Maintenance and Adjustment

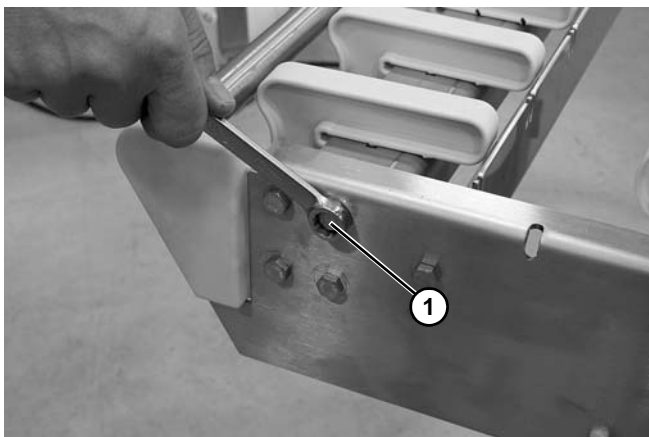
## Nose Bar Idler Spindle Replacement

### **⚠ WARNING**



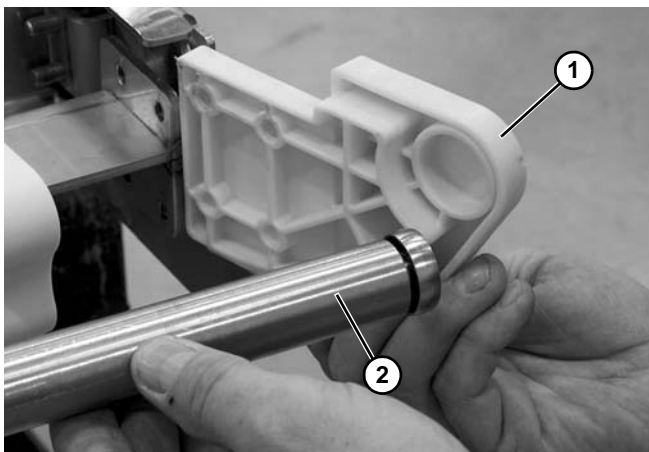
**SEVERE HAZARD!**  
LOCK OUT POWER before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

1. Open conveyor belt. Refer to “Conveyor Belt Replacement” on page 19.
2. Remove the four headplate bolts (Figure 67, item 1).



**Figure 67**

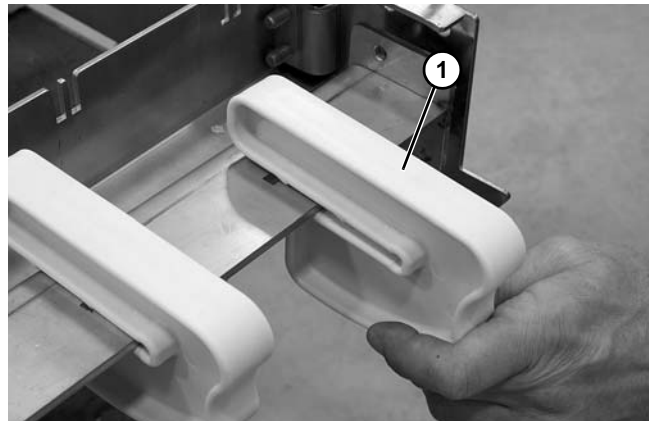
3. Remove headplate (Figure 68, item 1) and idler spindle assembly (Figure 68, item 2).



**Figure 68**

4. Replace spindle assembly if worn.

5. Remove and replace belt shoe if worn (Figure 69, item 1).



**Figure 69**

6. Install parts in reverse order of removal.

# Preventive Maintenance and Adjustment

## Bearing Replacement

<b>⚠ WARNING</b>


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

## Maintenance of Knuckles

<b>⚠ WARNING</b>

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

## Drive Bearing Removal and Replacement

<b>⚠ WARNING</b>

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

1. For standard drive bearing, refer to “Drive Sprocket and Spindle Replacement” on page 20. Follow steps 1 through 8.
2. For nose bar drive bearing, refer to “Nose Bar Drive Sprocket Replacement” on page 23. Follow steps 1 through 8.
3. Twist the bearing out (**Figure 70, item 1**).



**Figure 70**

4. Replace bearing.

## Lower Knuckle

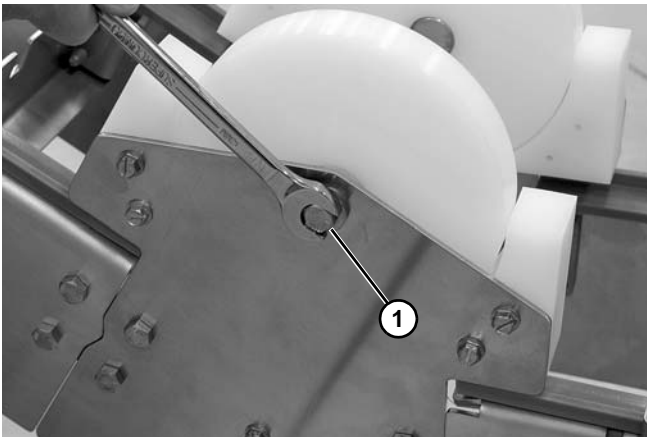
1. Remove belt. Refer to “Conveyor Belt Replacement” on page 19.
2. Remove two cap screws (**Figure 71, item 1**) on each side of the knuckle and remove the hold down roller guards (**Figure 71, item 2**). Repeat on the opposite side of the conveyor.



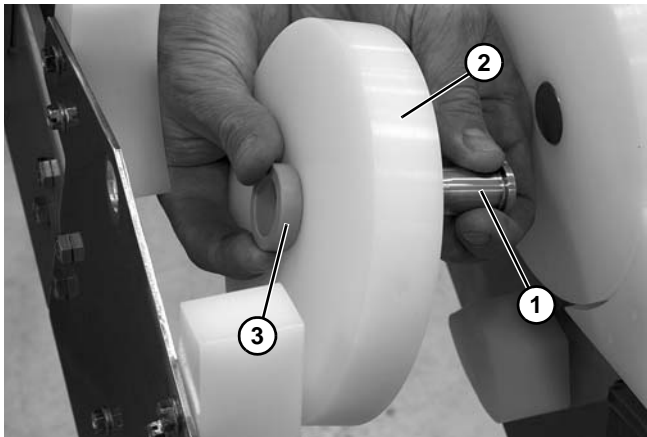
**Figure 71**

# Preventive Maintenance and Adjustment

3. Remove bolt and washer (**Figure 72, item 1**). Remove stub shaft (**Figure 73, item 1**), hold down roller (**Figure 73, item 2**), and spacer (**Figure 73, item 3**). Repeat on the opposite side of the conveyor.

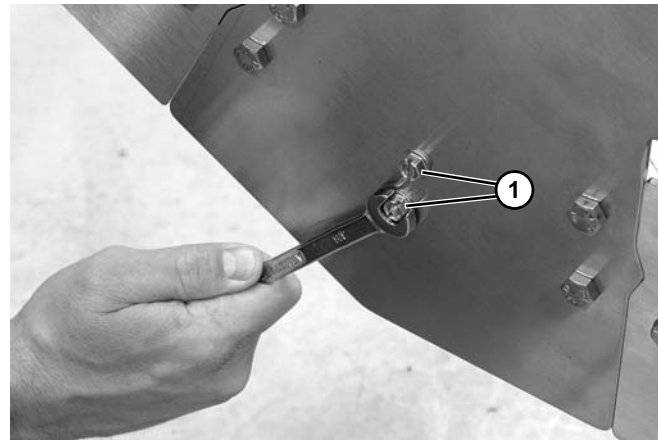


**Figure 72**

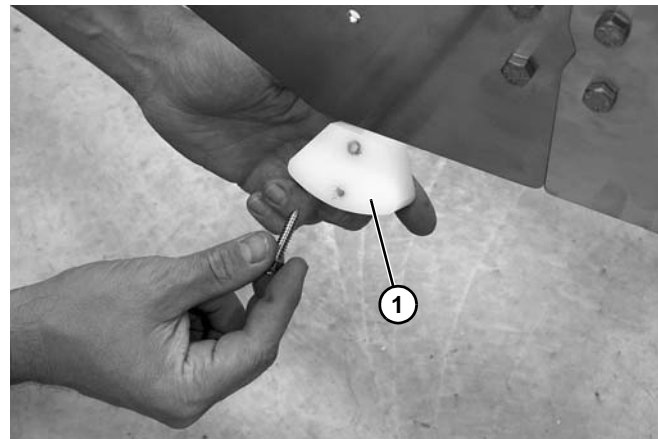


**Figure 73**

4. Remove two cap screws (**Figure 74, item 1**) and the inner belt return guide (**Figure 75, item 1**). Repeat on the opposite side of the conveyor.



**Figure 74**



**Figure 75**

5. Replace parts as necessary.
6. Install parts in reverse order of removal.

# Preventive Maintenance and Adjustment

## Upper Knuckle

1. Remove belt. Refer to “Conveyor Belt Replacement” on page 19.
2. Remove bolt (Figure 76, item 1) and shaft retainer (Figure 76, item 2) from each side of the conveyor.

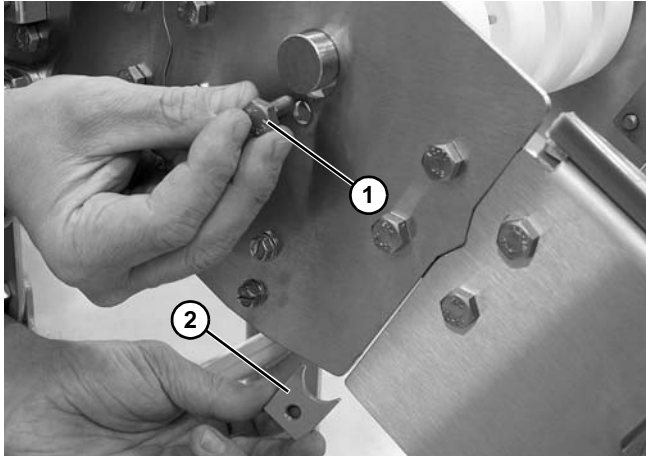


Figure 76

3. Remove upper shaft assembly (Figure 77, item 1).

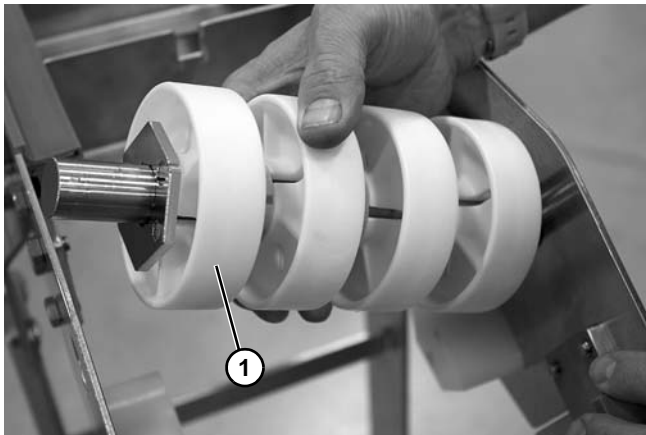


Figure 77

4. Insert an 8 mm (Figure 78, item 1) and 6 mm (Figure 78, item 2) hex wrench into the retainer plate.

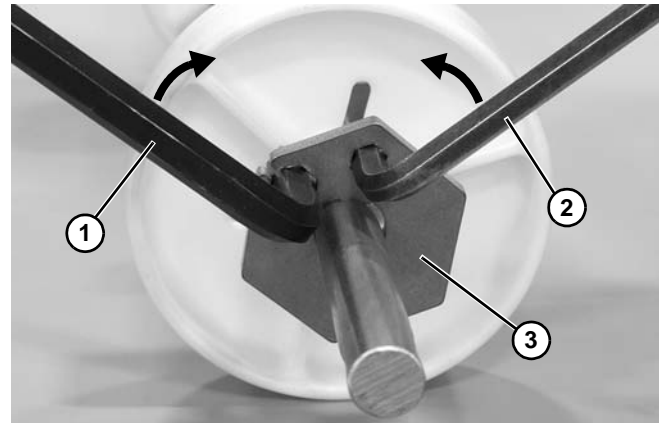


Figure 78

5. Move wrenches toward each other to unlock the retainer plate (Figure 78, item 3) and remove from the shaft.
6. Remove pucks (Figure 79, item 1) and spacers (Figure 79, item 2) from the shaft. Repeat as needed.

### NOTE

*Note the placement of the spacers during disassembly. The spacers MUST be reassembled in the same location.*

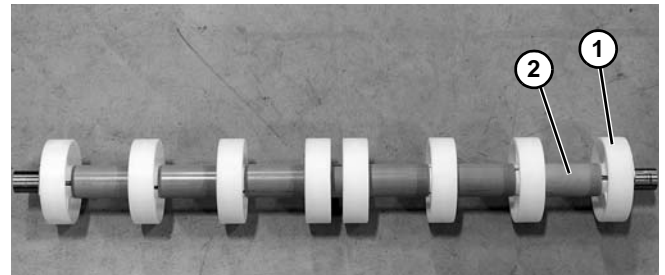
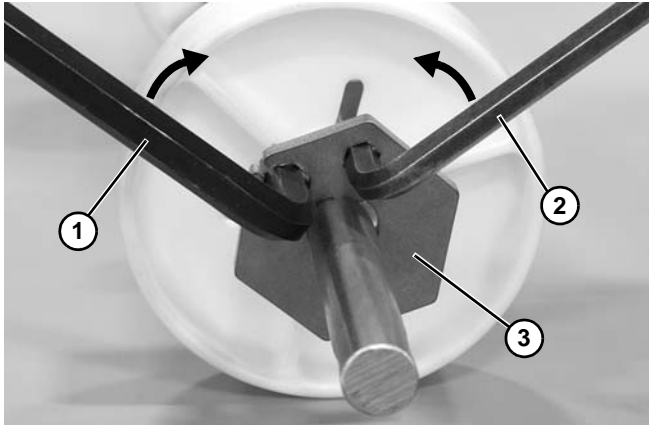


Figure 79



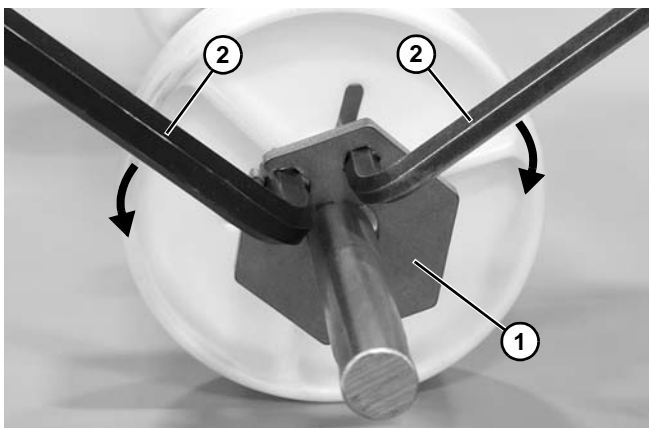
# Preventive Maintenance and Adjustment

7. Install new spacers and pucks and secure to shaft with a retainer plate on both ends.
  - a. Insert an 8 mm (**Figure 80, item 1**) and 6 mm (**Figure 80, item 2**) hex wrench into the retainer plate.



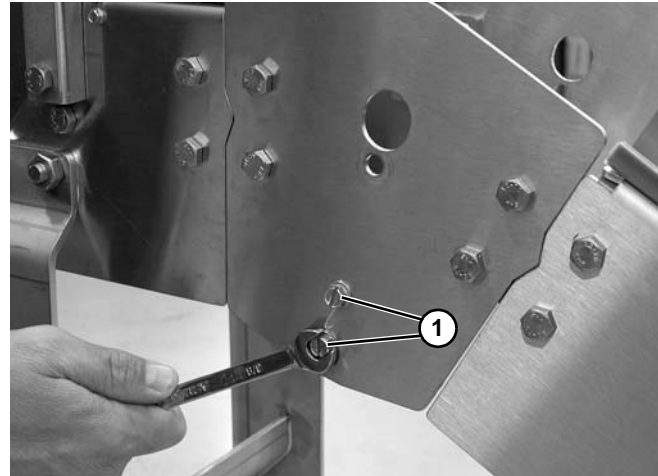
**Figure 80**

- b. Move wrenches toward each other to open the retainer plate (**Figure 80, item 3**) and install onto the shaft. Position retainer plate where needed.
  - c. To lock the retainer plate (**Figure 81, item 1**) in place, move the wrenches (**Figure 81, item 2**) away from each other.

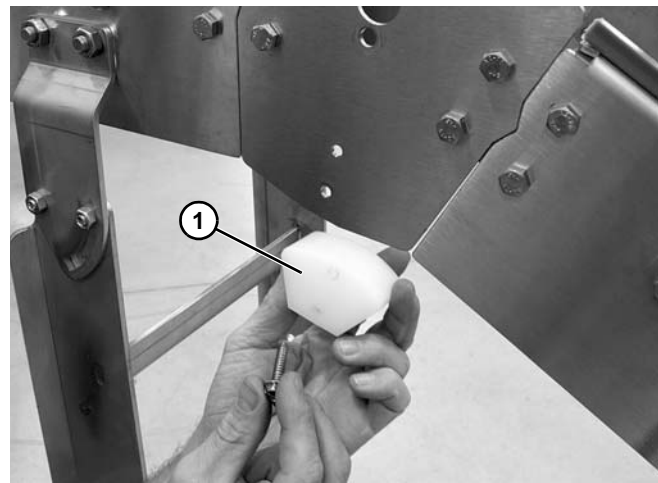


**Figure 81**

8. Remove two cap screws (**Figure 82, item 1**) and inner belt return guide (**Figure 83, item 1**). Repeat on the opposite side of the conveyor.



**Figure 82**



**Figure 83**

9. Replace parts as necessary.
10. Install parts in reverse order of removal.

# Preventive Maintenance and Adjustment

## Belt Return Maintenance

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

### Flat Belt Returns 610 mm Wide and Wider

1. Loosen nut (Figure 84, item 1) and rotate return clip (Figure 84, item 2) up on both sides of conveyor. Loosely tighten nuts to hold clip in place.

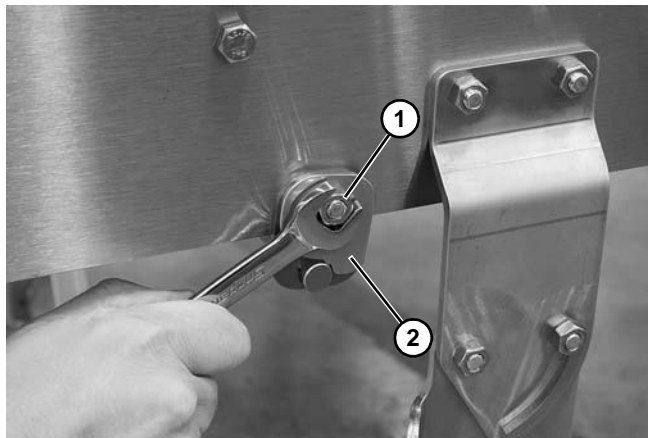


Figure 84

2. Remove belt return assembly (Figure 85, item 1) from return brackets (Figure 85, item 2).

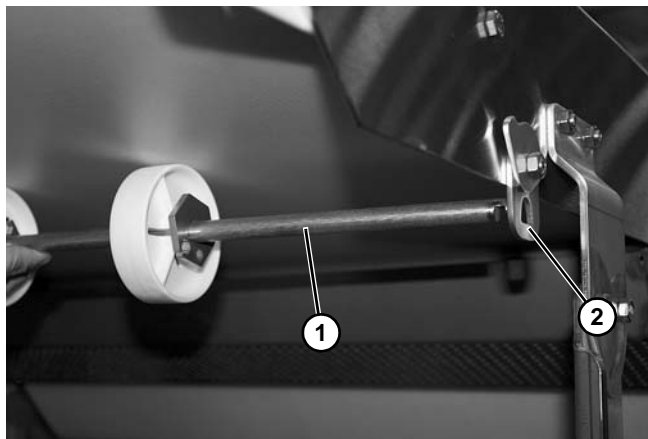


Figure 85

3. Insert an 8 mm (Figure 86, item 1) and 6 mm (Figure 86, item 2) hex wrench into the retainer plate.

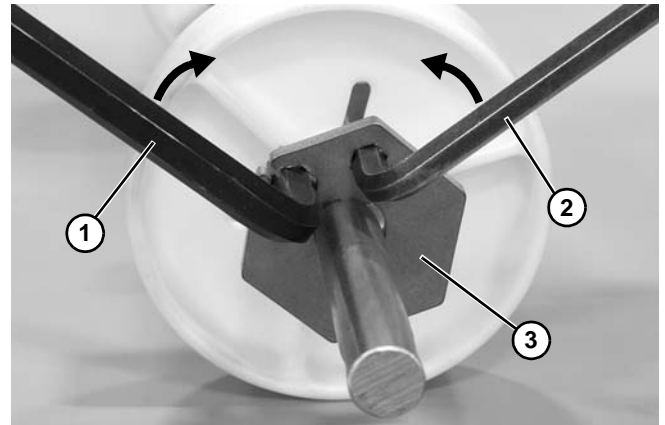


Figure 86

4. Move wrenches toward each other to unlock the retainer plate (Figure 86, item 3) and remove from the shaft.
5. Remove puck (Figure 87, item 1) from the shaft.

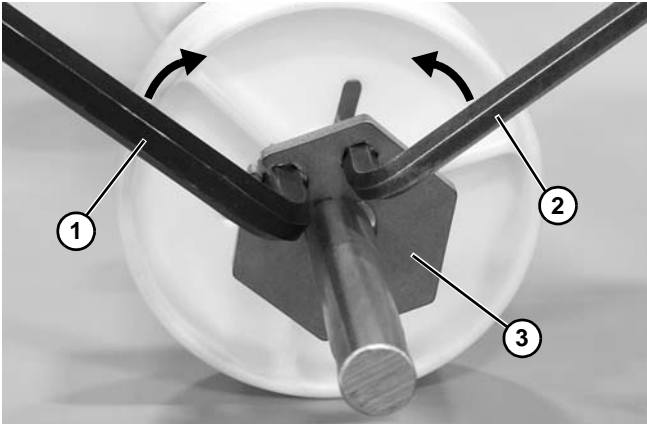


Figure 87

6. Repeat steps 3 through 5 as needed.

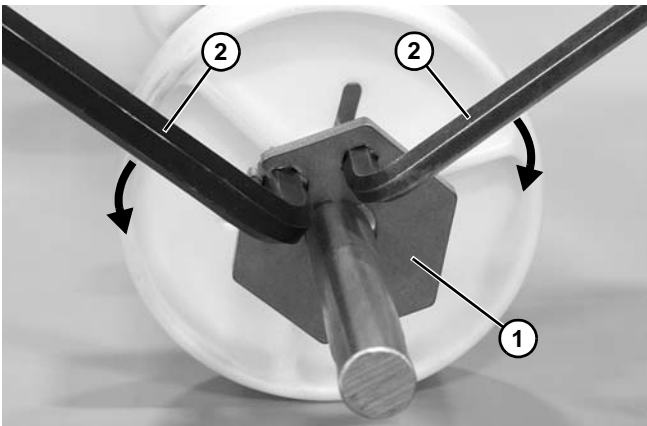
# Preventive Maintenance and Adjustment

7. Install new pucks with retainer plates on both sides.
  - a. Insert an 8 mm (**Figure 88, item 1**) and 6 mm (**Figure 88, item 2**) hex wrench into the retainer plate.



**Figure 88**

- b. Move wrenches toward each other to open the retainer plate (**Figure 88, item 3**) and install onto the shaft. Position retainer plate where needed.
  - c. To lock the retainer plate (**Figure 89, item 1**) in place, move the wrenches (**Figure 89, item 2**) away from each other.

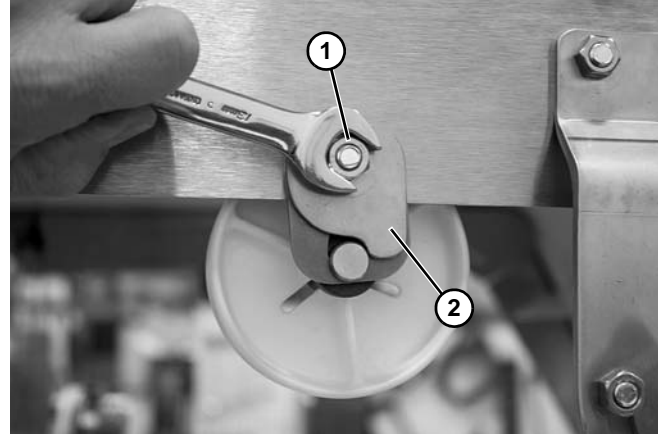


**Figure 89**

8. Install belt return assembly in reverse order of removal.

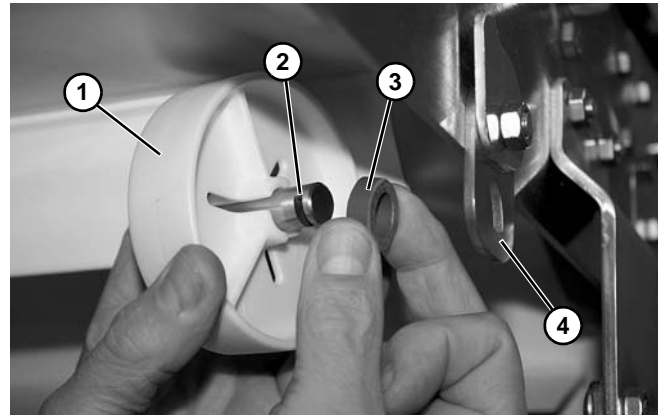
## Cleated Belt and Flat Belt Returns Under 610 mm Wide

1. Loosen nut (**Figure 90, item 1**) and rotate return clip (**Figure 90, item 2**) up on both sides of conveyor. Loosely tighten nuts to hold clip in place.



**Figure 90**

2. Remove puck (**Figure 91, item 1**), stub shaft (**Figure 91, item 2**), and spacer (**Figure 91, item 3**) from return bracket (**Figure 91, item 4**).



**Figure 91**


3. Replace worn or damaged parts.
4. Install parts in reverse order of removal.





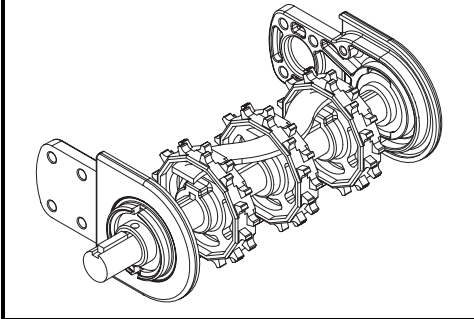
# Service Parts

## NOTE

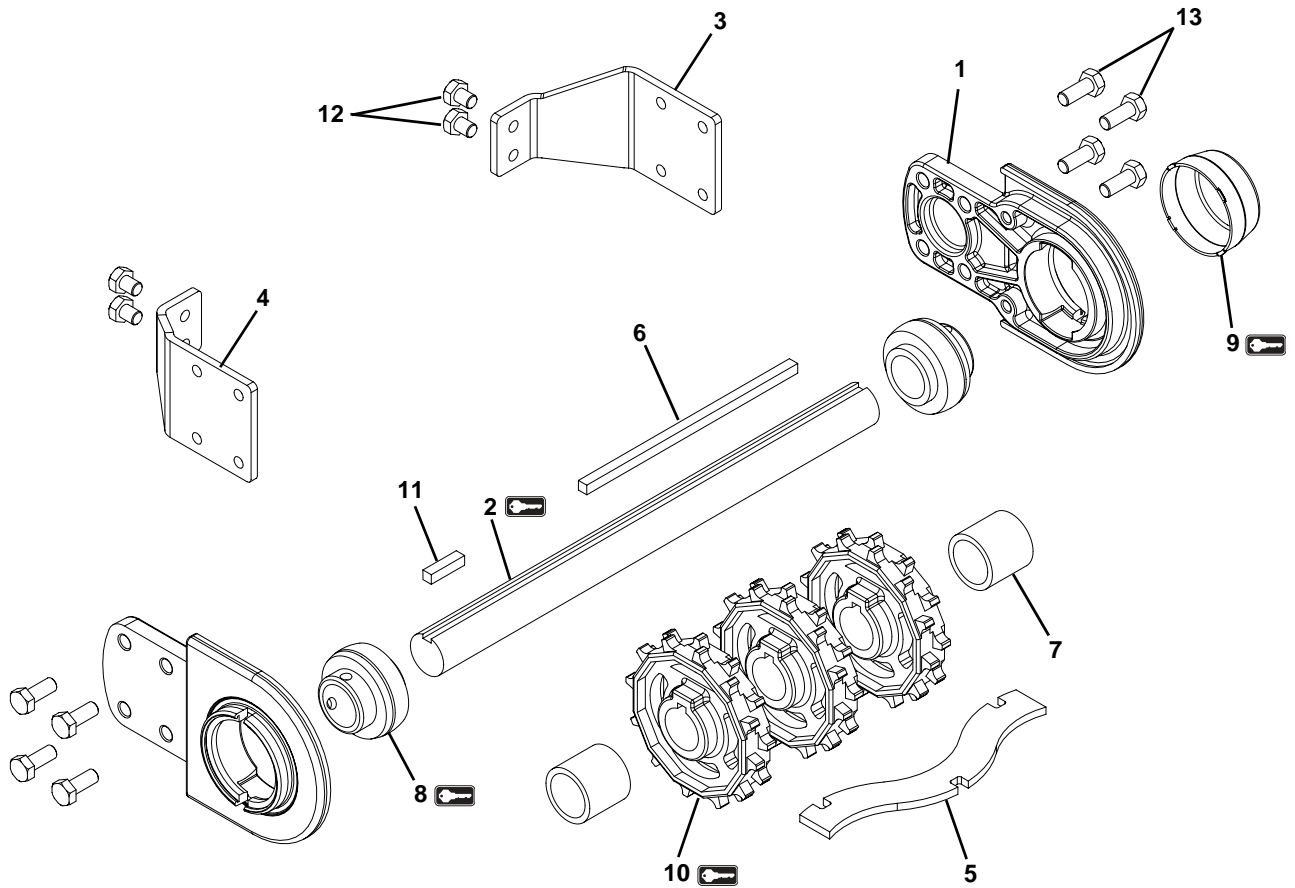
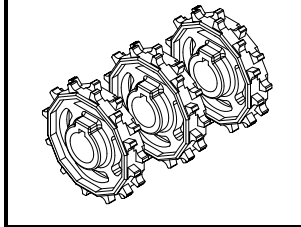
For replacement parts other than those shown in this section, contact an authorized Dorner distributor or Dorner directly. Recommended Critical Service Parts and Kits are identified by the Key Service Parts symbol . Dorner recommends keeping these parts on hand.

## End Drive Tail

### 15 Spindle Kit



### 14 Sprocket Kit

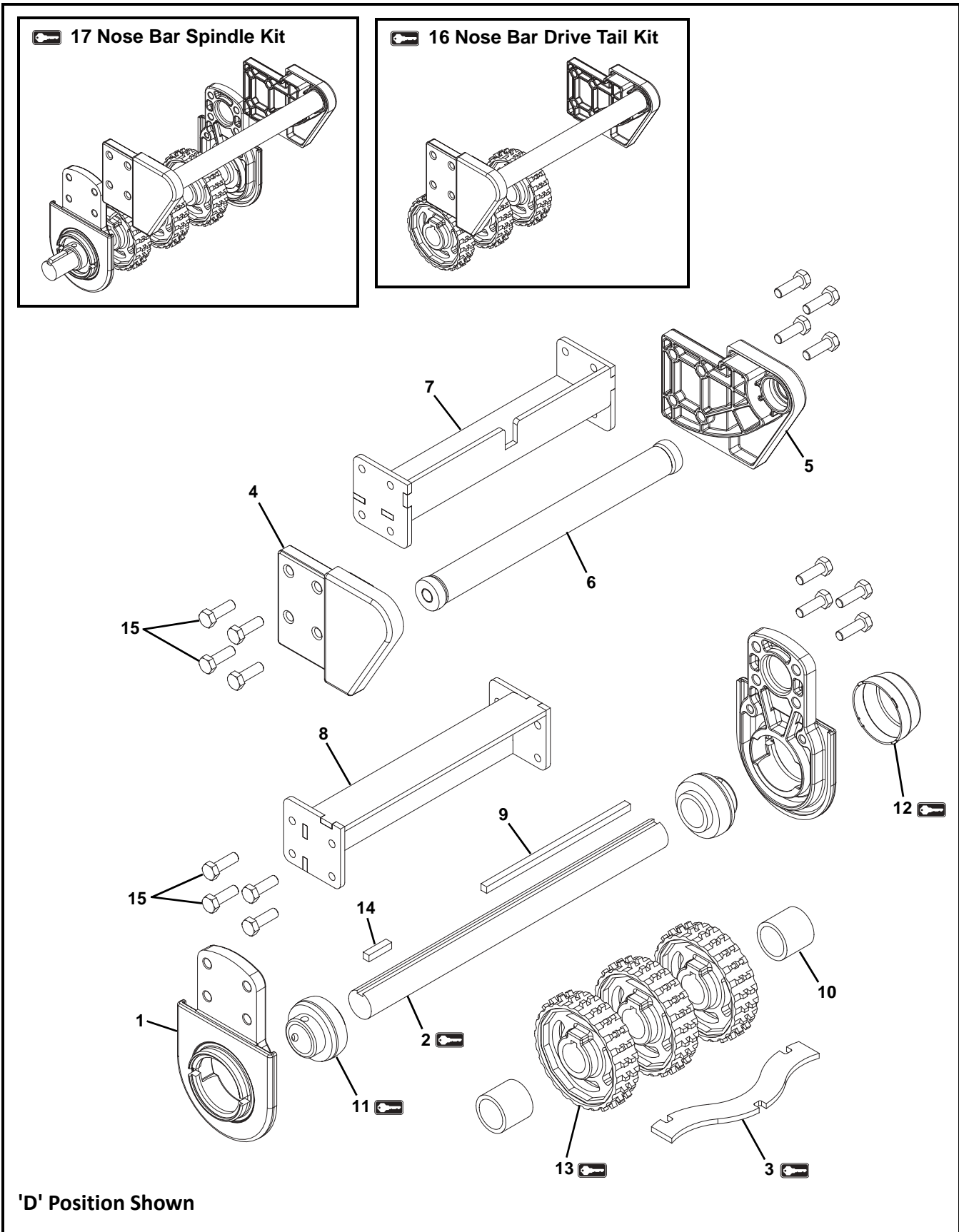


'D' Position Shown

Item	Part Number	Description
1	516983	Headplate
2	516817-K0- <u>WW</u>	Drive Spindle for 'A' position
	516817-0K- <u>WW</u>	Drive Spindle for 'D' position
	516817-KK- <u>WW</u>	Dual Shaft Spindle
3	516842-LH	Support Bracket, Left Hand
4	516842-RH	Support Bracket, Right Hand
5	516843- <u>WW</u>	Sprocket Key
6	532121- <u>LLLLL</u>	Square Key
7	532251- <u>LLLLL</u>	Spacer
8	802-161	Bearing
9	807-1454	Bearing Cap
10	807-1754	Sprocket
11	912-108SS	Square Key, .25" x 1.00"
12	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
13	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
14	520370- <u>WW</u>	Sprocket Kit (Includes Item 10)
15	520371-K0- <u>WW</u>	Spindle Kit for 'A' position (Includes Items 1, 2, 5, 6, 8,10 and 11)
	520371-0K- <u>WW</u>	Spindle Kit for 'D' position (Includes Items 1, 2, 5, 6, 8,10 and 11)
	520371-KK- <u>WW</u>	Dual Shaft Spindle Kit (Includes Items 1, 2, 5, 6, 8,10 and 11)
<u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

# Service Parts

## Nose Bar Drive Tail

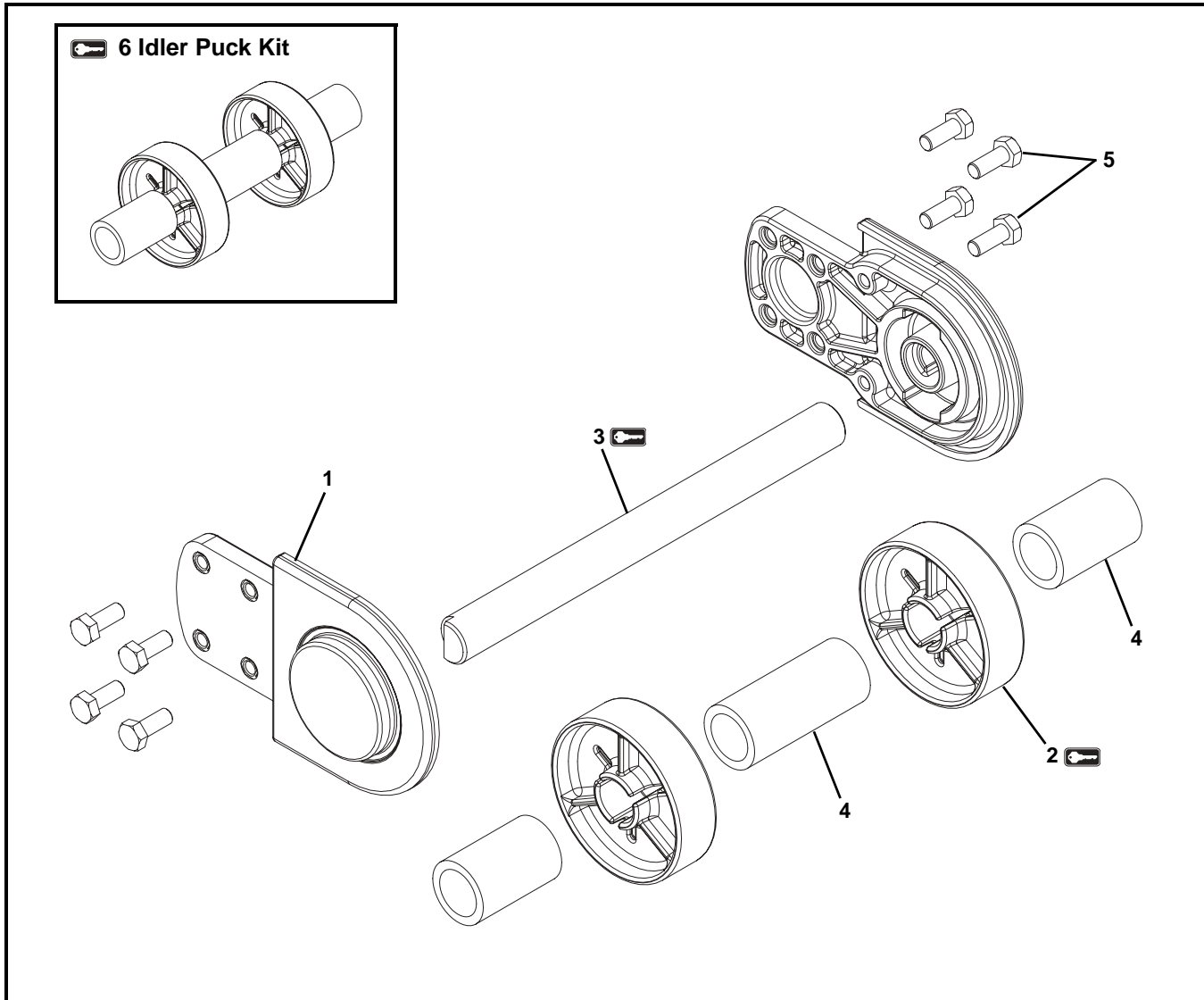


# Service Parts

Item	Part Number	Description
1	516983	Drive Headplate
2	516817-K0- <u>WW</u>	Nose Bar Drive Spindle
3	516843- <u>WW</u>	Sprocket Key
4	516918-LH	Nose Bar Headplate, Left Hand
5	516918-RH	Nose Bar Headplate, Right Hand
6	520372- <u>WW</u>	Idler Spindle Assembly
7	518392- <u>WW</u>	Support Bracket Assembly
8	518473- <u>WW</u>	Drive Support Bracket Assembly
9	532121- <u>LLLLL</u>	Square Key
10	532251- <u>LLLLL</u>	Spacer
11	802-161	Bearing
12	807-1454	Bearing Cap
13	807-1761	Sprocket
14	912-108SS	Square Key, .25" x 1.00"
15	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
16	520373- <u>WW</u>	Nose Bar Drive Tail Kit (Includes Items 4, 5, 6, and 13)
17	520374- <u>WW</u>	Nose Bar Spindle Kit (Includes Items 1, 2, 3, 4, 5, 6, 9, 11, 13 and 14)
<u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

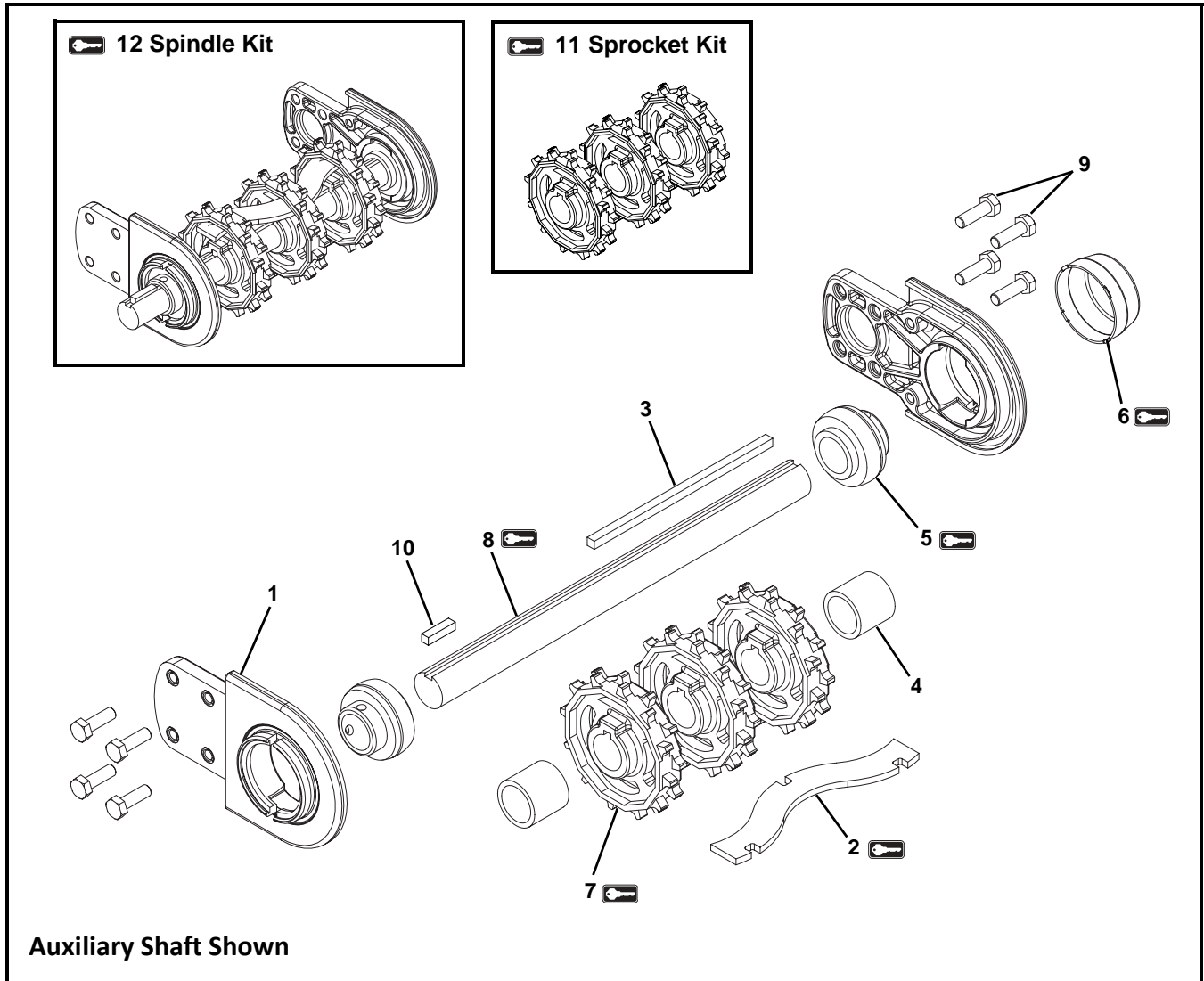
# Service Parts

## Idler Tail



Item	Part Number	Description
1	532012	Headplate
2	506296	Idler Puck
3	516825- <u>WW</u>	Idler Spindle
4	532127- <u>LLLLL</u>	Spacer
5	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
6	520375- <u>WW</u>	Idler Puck Kit (Includes items 2 and 4)
<u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments		
<u>LLLLL</u> = Part length in inches with 2 decimal places. Example: Part Length = 95.25" <u>LLLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

## Idler Tail with Auxiliary Shaft



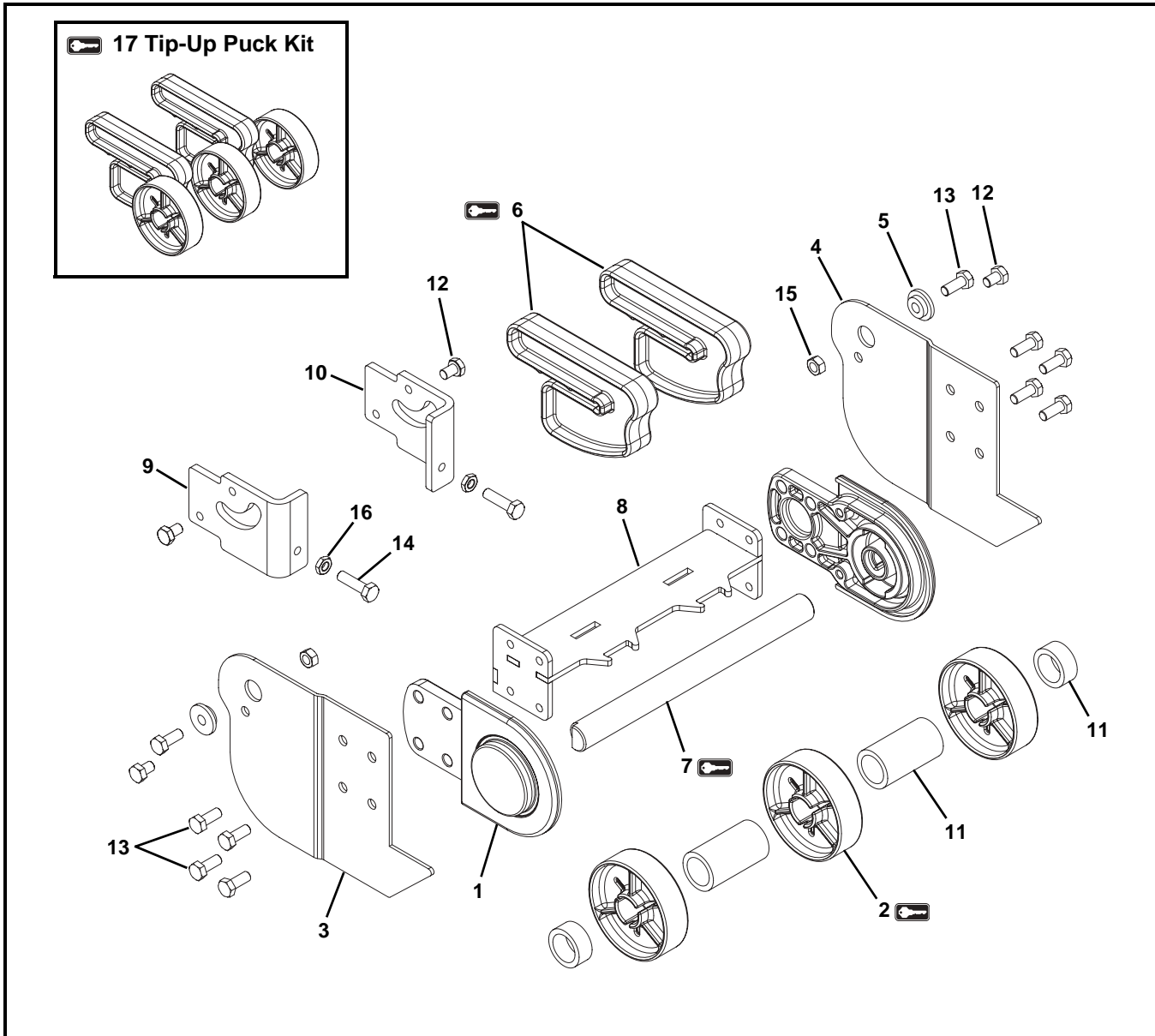
Auxiliary Shaft Shown

Item	Part Number	Description
1	532011	Headplate
2	516843- <u>WW</u>	Sprocket Key
3	532121- <u>LLLLL</u>	Square Key
4	532251- <u>LLLLL</u>	Spacer
5	802-161	Bearing
6	807-1454	Bearing Cap
7	807-1754	Sprocket
8	516817-K0- <u>WW</u>	Spindle with Auxiliary Shaft on the 'A' Side
	516817-0K- <u>WW</u>	Spindle with Auxiliary Shaft on the 'D' Side
9	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
10	912-108SS	Square Key

Item	Part Number	Description
11	520370- <u>WW</u>	Sprocket Kit (Includes item 7)
12	520371-K0- <u>WW</u>	Spindle Kit for 'A' position (Includes Items 1, 2, 3, 5, 7 and 8)
	520371-0K- <u>WW</u>	Spindle Kit for 'D' position (Includes Items 1, 2, 3, 5, 7 and 8)
<u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

# Service Parts

## Tip-Up Idler Tail

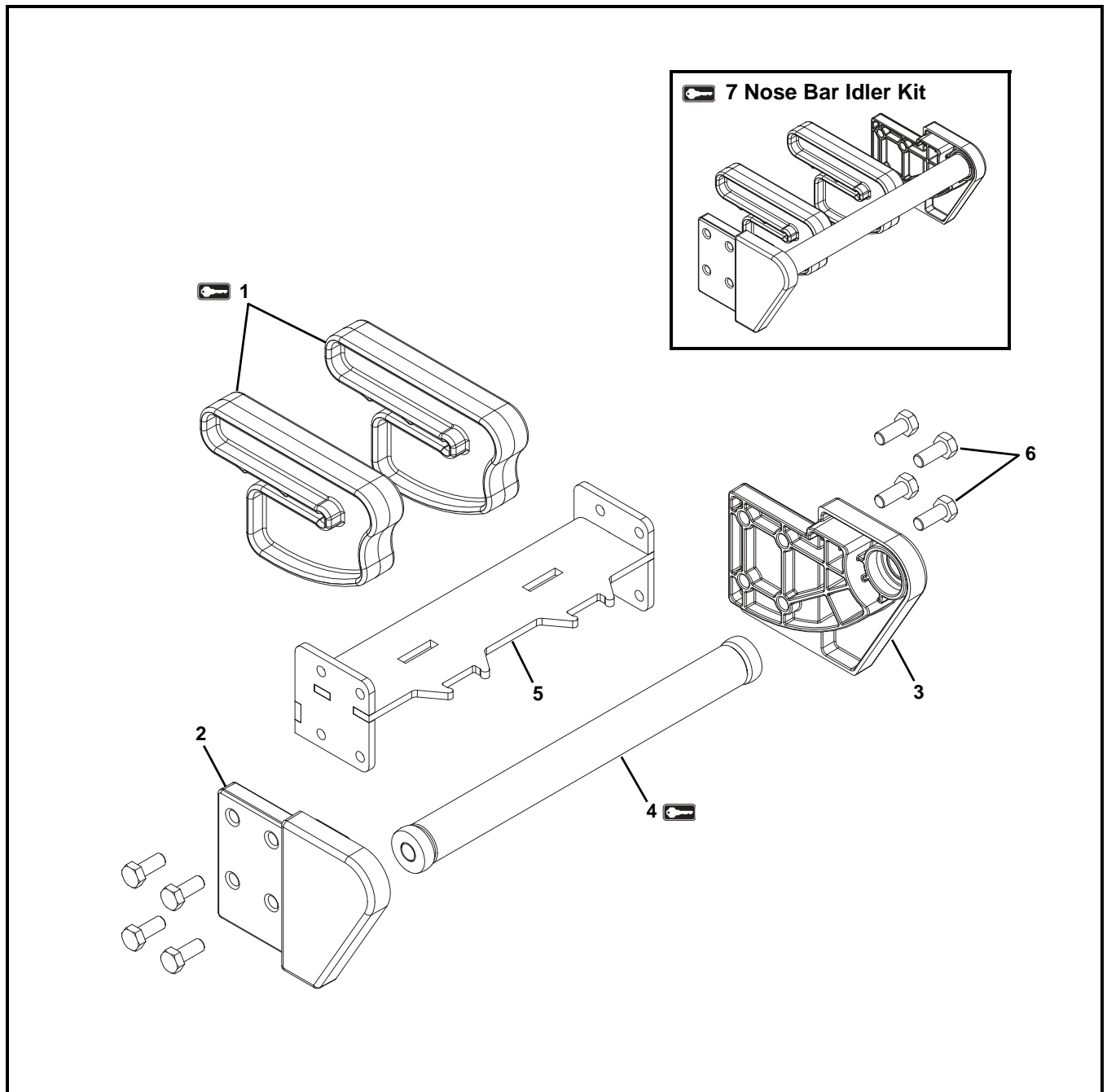


Item	Part Number	Description
1	532101	Headplate
2	506296	Puck
3	516846	Tip-Up Plate, Left Hand
4	516847	Tip-Up Plate, Right Hand
5	516850	Bushing
6	516922	Belt Shoe
7	516825- <u>WW</u>	Spindle
8	516851- <u>WW</u>	Bracket Assembly
9	518415-LH	Tip-Up Bracket, Left Hand
10	518415-RH	Tip-Up Bracket, Right Hand
11	532127- <u>LLLLL</u>	Spacer
12	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
13	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
14	960835MSS	Hex Head Cap Screw, M8-1.25 x 35 mm
15	990801MSS	Hex Nut
16	990809MSS	Hex Jam Nut
17	520376- <u>WW</u>	Tip-Up Puck Kit (Includes items 2 and 6)
		<u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments
		<u>LLLLL</u> = Part length in inches with 2 decimal places.
		Example: Part Length = 95.25" <u>LLLLL</u> = 09525
		Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com



## Nose Bar Idler Tail

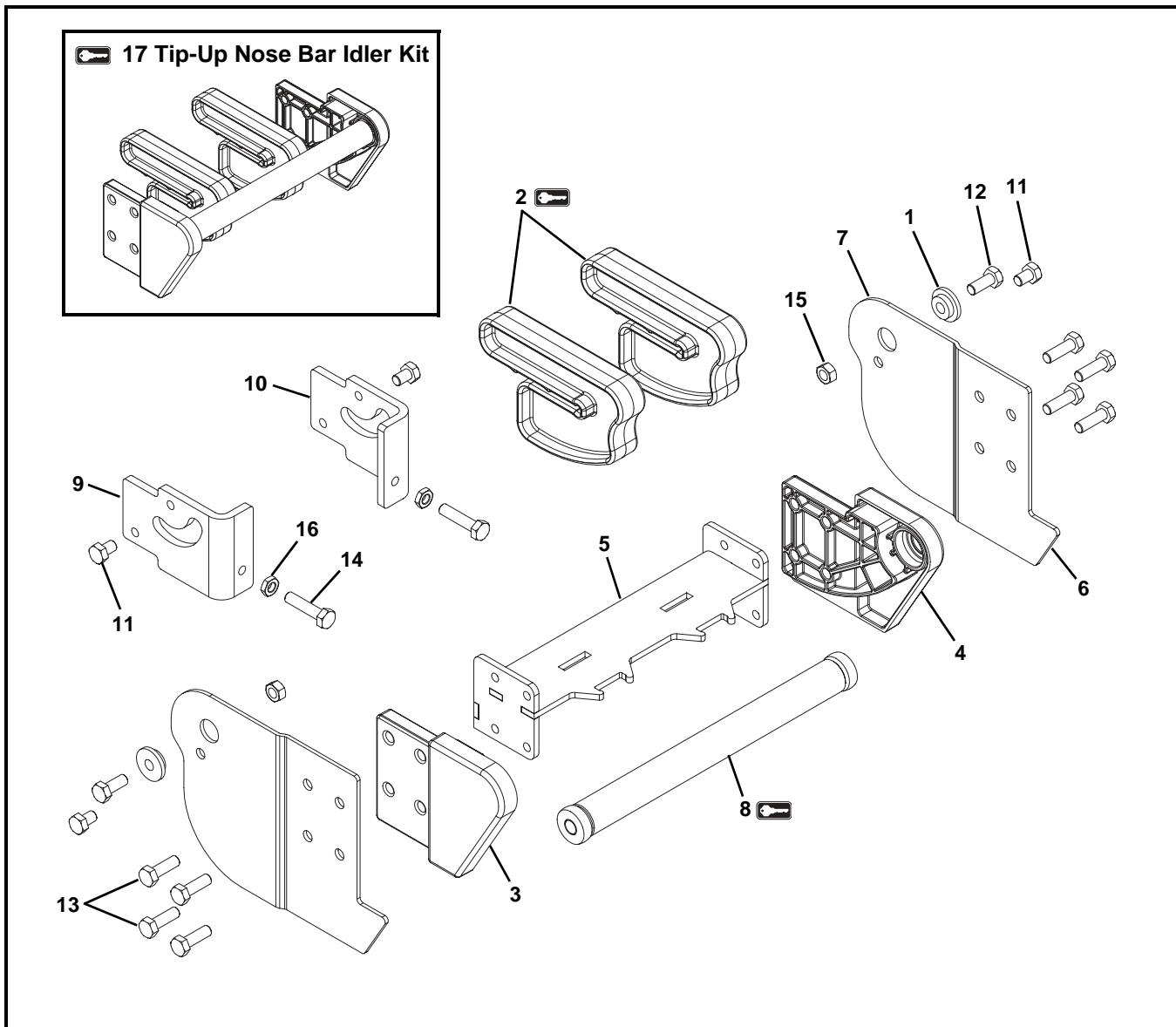


Item	Part Number	Description
1	516922	Belt Shoe
2	516918-LH	Headplate, Left Hand
3	516918-RH	Headplate, Right Hand
4	520372- <u>WW</u>	Spindle Assembly
5	518467- <u>WW</u>	Bracket Assembly
6	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm

Item	Part Number	Description
7	520377- <u>WW</u>	Nose Bar Idler Kit (Includes items 1, 2, 3 and 4)
<p><u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments</p> <p>Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com</p>		

# Service Parts

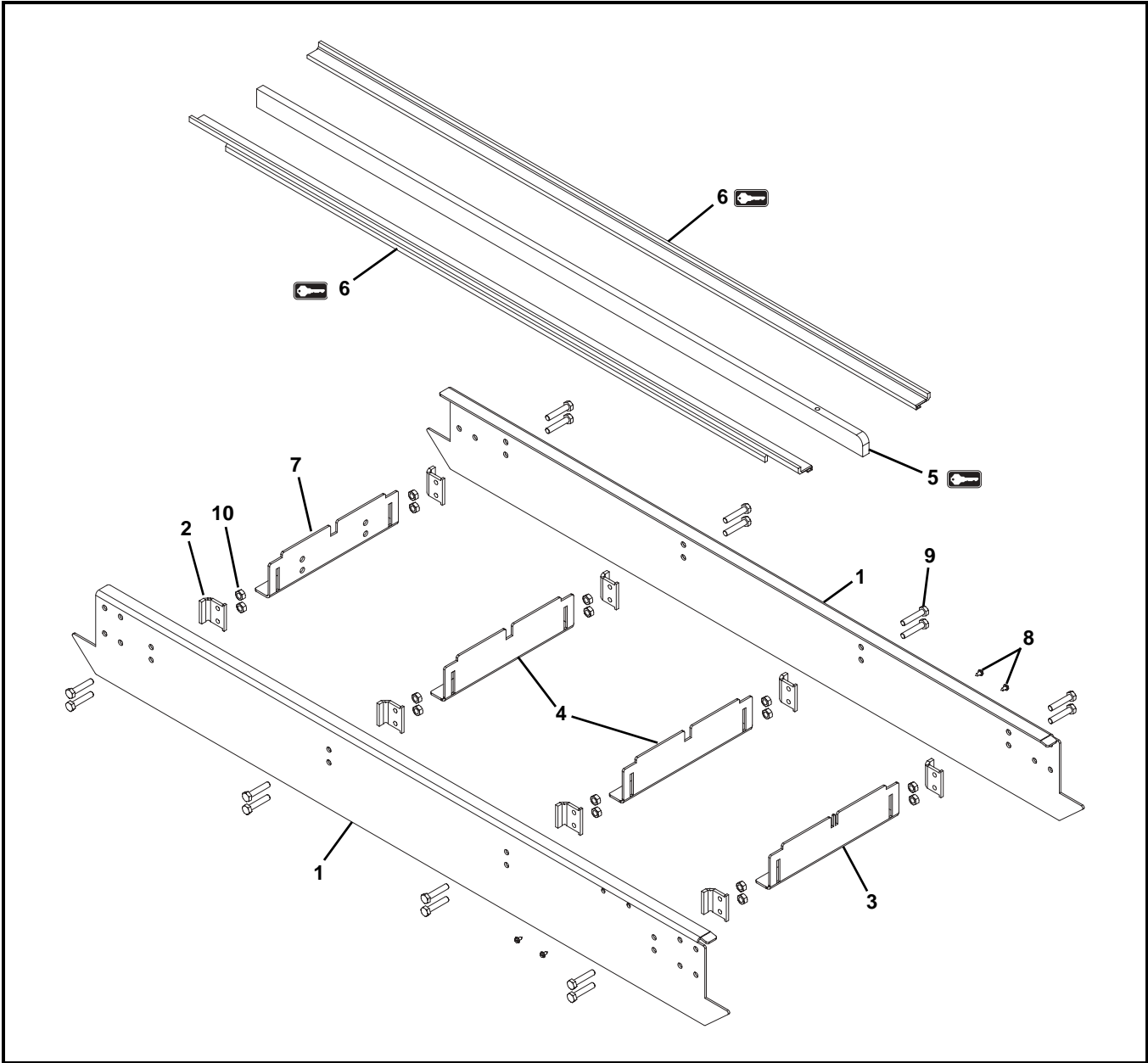
## Tip-Up Nose Bar Idler Tail



Item	Part Number	Description
1	516850	Bushing
2	516922	Belt Shoe
3	516918-LH	Headplate, Left Hand
4	516918-RH	Headplate, Right Hand
5	516920- <u>WW</u>	Bracket Assembly
6	516921-LH	Tail Bracket, Left Hand
7	516921-RH	Tail Bracket, Right Hand
8	520372- <u>WW</u>	Spindle Assembly
9	518415-LH	Tip-Up Bracket, Left Hand
10	518415-RH	Tip-Up Bracket, Right Hand
11	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
12	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm

Item	Part Number	Description
13	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
14	960835MSS	Hex Head Cap Screw, M8-1.25 x 35 mm
15	990801MSS	Hex Nut
16	990809MSS	Hex Jam Nut
17	520378- <u>WW</u>	Tip-Up Nose Bar Idler Kit (Includes items 2, 3, 4 and 8)
<p><u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments</p> <p>Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com</p>		

## Frame Assembly

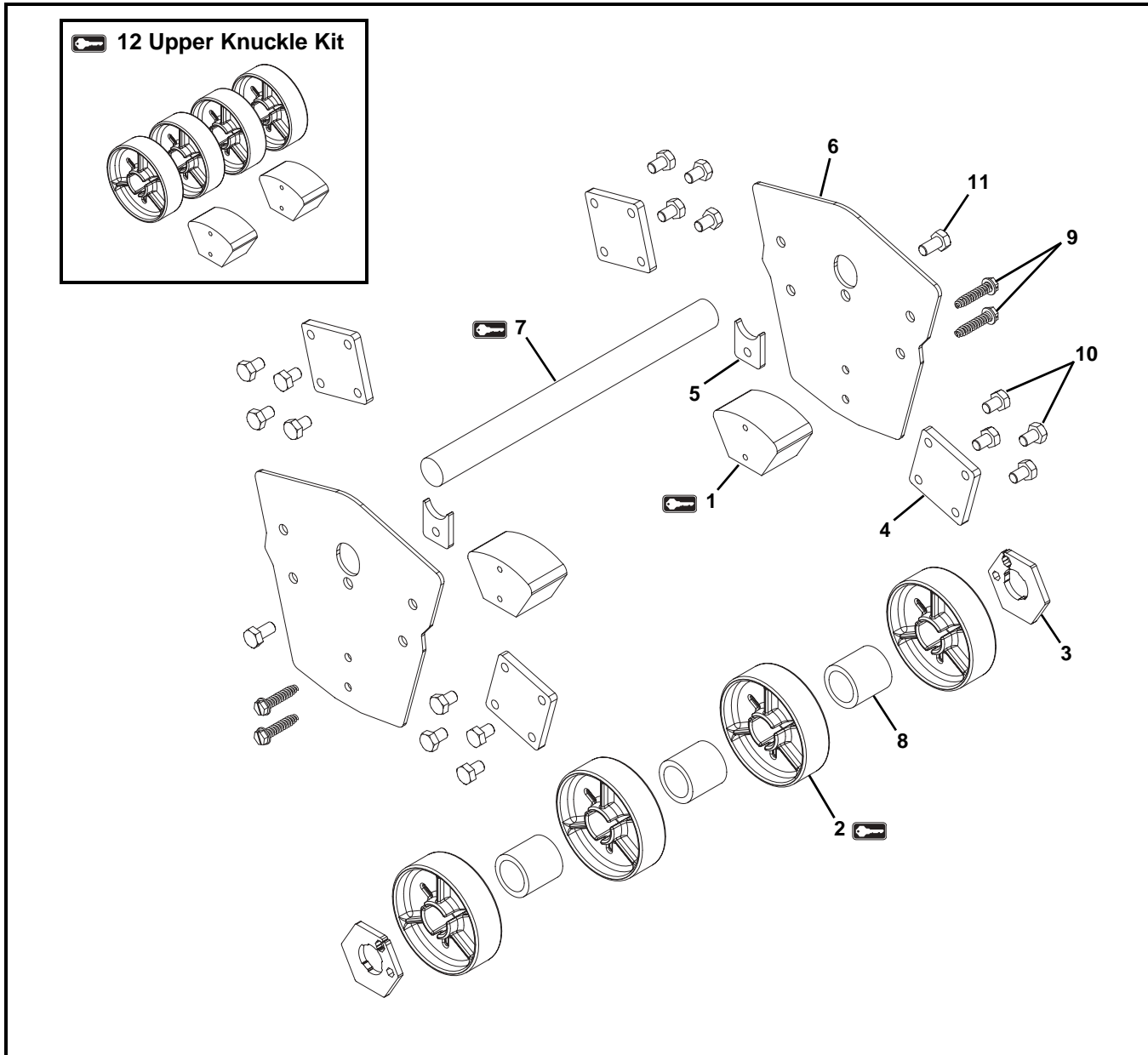


Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	515596	Crossmember Bracket
3	515591- <u>WW</u>	Crossmember - Infeed End
4	515592- <u>WW</u>	Crossmember
5	516902-F- <u>LLLLL</u>	Center Wear Strip for Standard Idler Tail
	516902-T- <u>LLLLL</u>	Center Wear Strip for Tip-Up Idler Tail
6	517563- <u>LLLLL</u>	Side Wear Strip
7	517564- <u>WW</u>	Crossmember - Discharge End
8	807-3341	Self Tapping Hex Screw, 8-18 x .375"

Item	Part Number	Description
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
10	990801MSS	Hex Nut
<p><u>WW</u> = Conveyor width reference in inches 08 - 36 in 02 increments</p> <p><u>LLLLL</u> = Part length in inches with 2 decimal places.</p> <p>Example: Part Length = 95.25" <u>LLLLL</u> = 09525</p> <p>Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com</p>		

# Service Parts

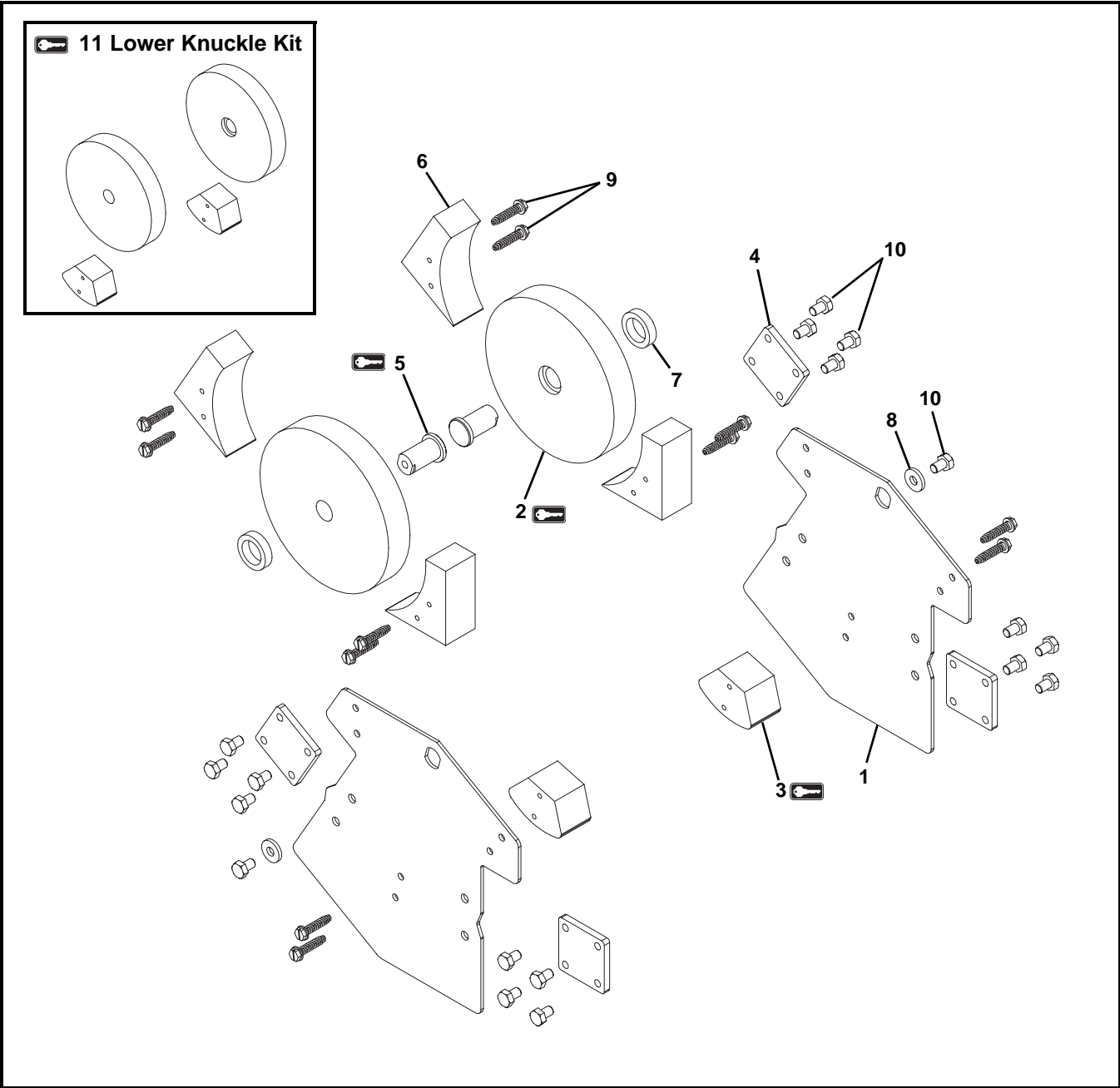
## Upper Knuckle



Item	Part Number	Description
1	352326	Inner Belt Return Guide
2	506296	Puck
3	514823	Retaining Ring
4	516942	Connecting Plate
5	532358	Shaft Clamp
6	516954-AA	Side Plate
7	518468-WW	Shaft
8	532127-LLLL	Spacer
9	807-1884	Sheet Metal Screw, #14 x 1.25

Item	Part Number	Description
10	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
11	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
12	520379-WW	Upper Knuckle Kit (Includes items 1 and 2)
AA = Angle 05, 10, 15, 20, 25, 30, 35, 40, 45, 50, 55, 60		
WW = Conveyor width reference in inches 08 - 36 in 02 increments		
LLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

## Lower Knuckle



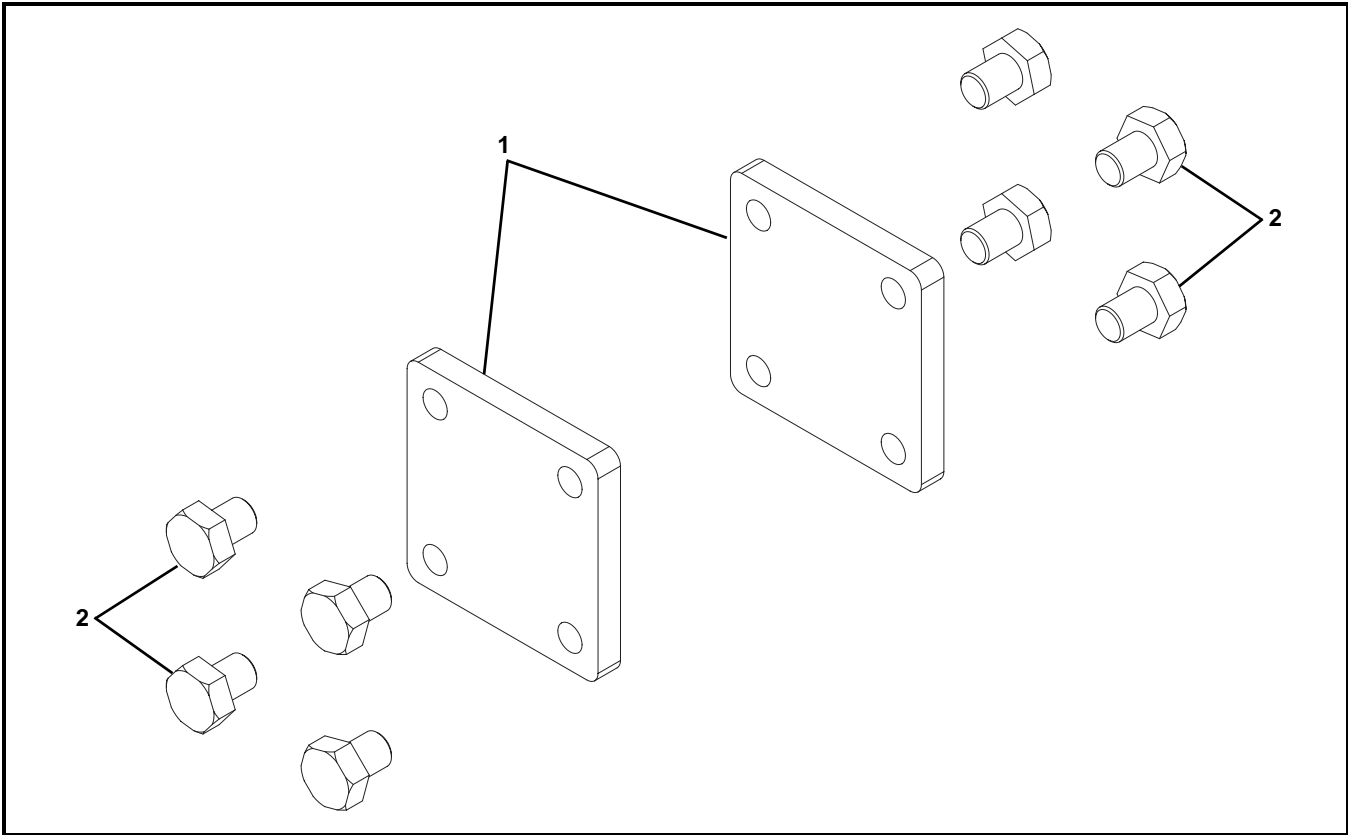
Item	Part Number	Description
1	516956-AA	Side Plate
2	352324	Hold Down Guide
3	352326	Inner Belt Return Guide
4	516942	Connecting Plate
5	532351	Stub Shaft
6	532359	Hold Down Roller Guard
7	532379	Bushing
8	807-1838	Washer

Item	Part Number	Description
9	807-1884	Sheet Metal Screw, #14 x 1.25
10	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
11	520380	Lower Knuckle Kit (Includes items 2 and 3)

AA = Angle 05, 10, 15, 20, 25, 30, 35, 40, 45, 50, 55, 60  
 Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

# Service Parts

## Connecting Assembly

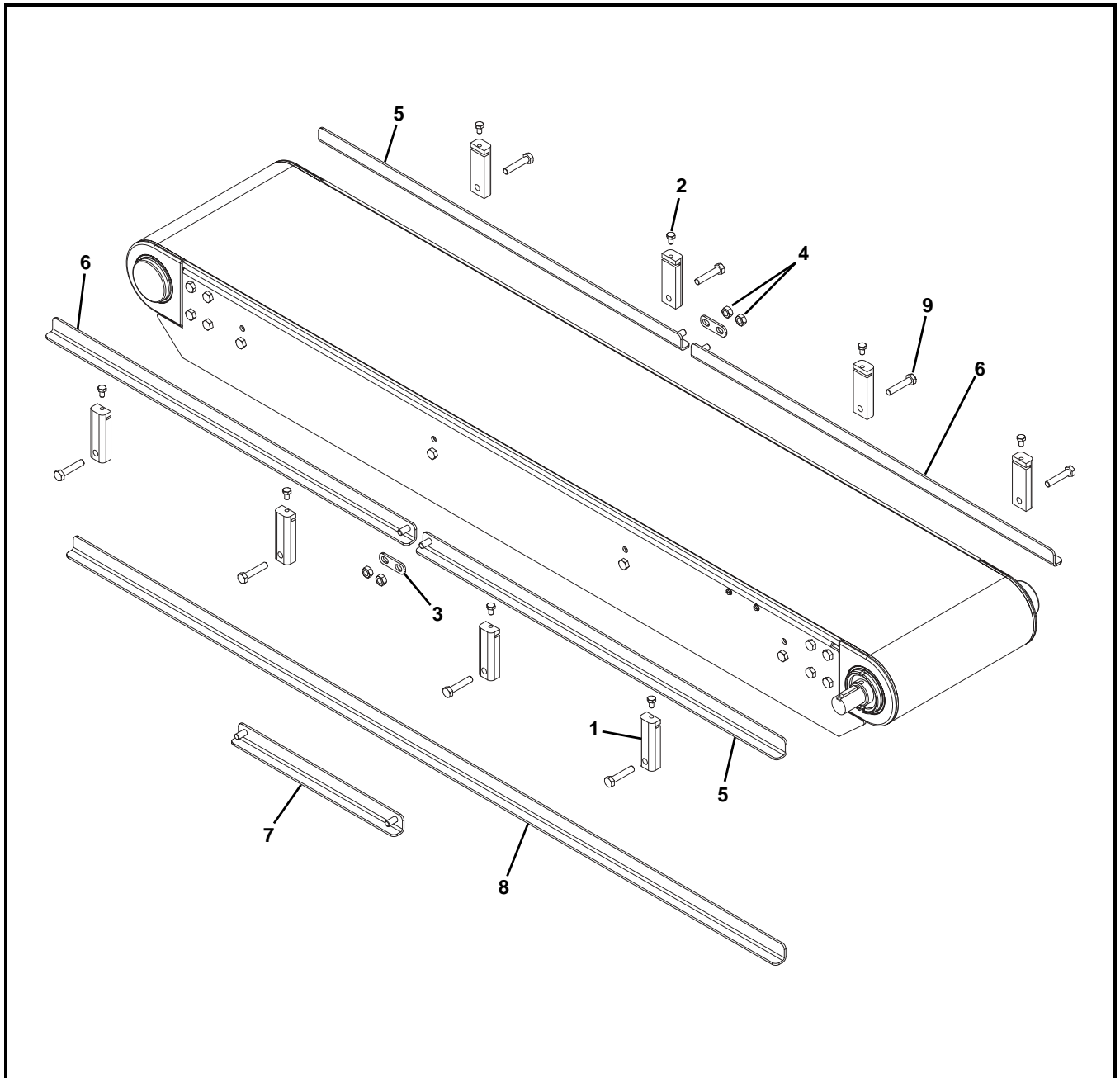


Item	Part Number	Description
1	516942	Connecting Plate
2	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or [customerservice@dorner.com](mailto:customerservice@dorner.com)



## 25 mm High Sides

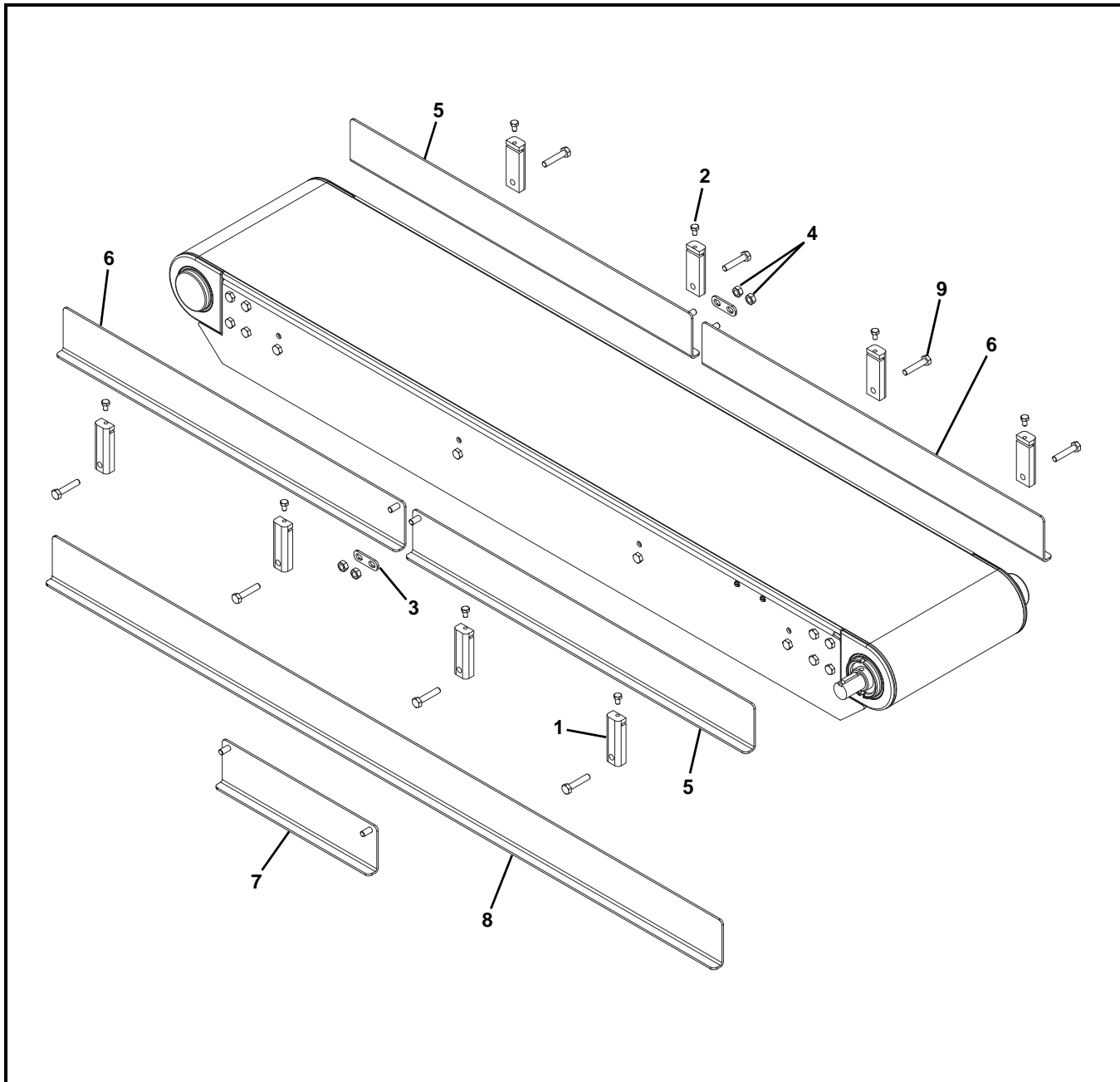


Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-05- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-05- <u>LLLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-05- <u>LLLLL</u>	Guiding, Middle (for Multiple Guide Sections Only)

Item	Part Number	Description
8	516997-01- <u>LLLLL</u>	Guiding (for One Piece Guiding)
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<p><u>LLLLL</u> = Part length in inches with 2 decimal places.                      Example: Part Length = 95.25" <u>LLLLL</u> = 09525</p>		
<p>Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com</p>		

# Service Parts

## 75 mm High Sides



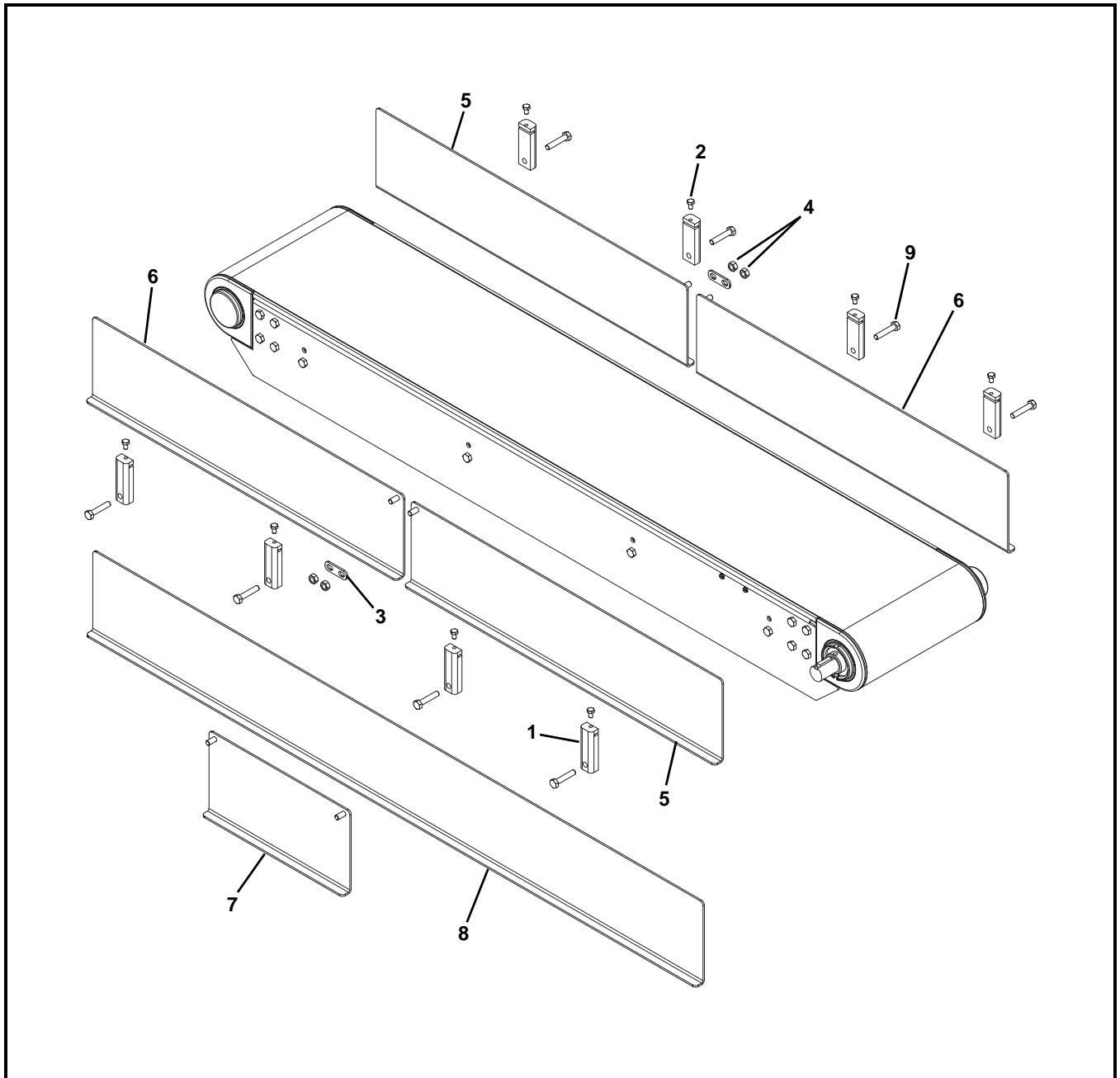
Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-04- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-04- <u>LLLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-04- <u>LLLLL</u>	Guiding, Middle (for Multiple Guide Sections Only)

Item	Part Number	Description
8	516997-03- <u>LLLLL</u>	Guiding (for One Piece Guiding)
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm

LLLLL = Part length in inches with 2 decimal places.  
 Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

## 152 mm High Sides

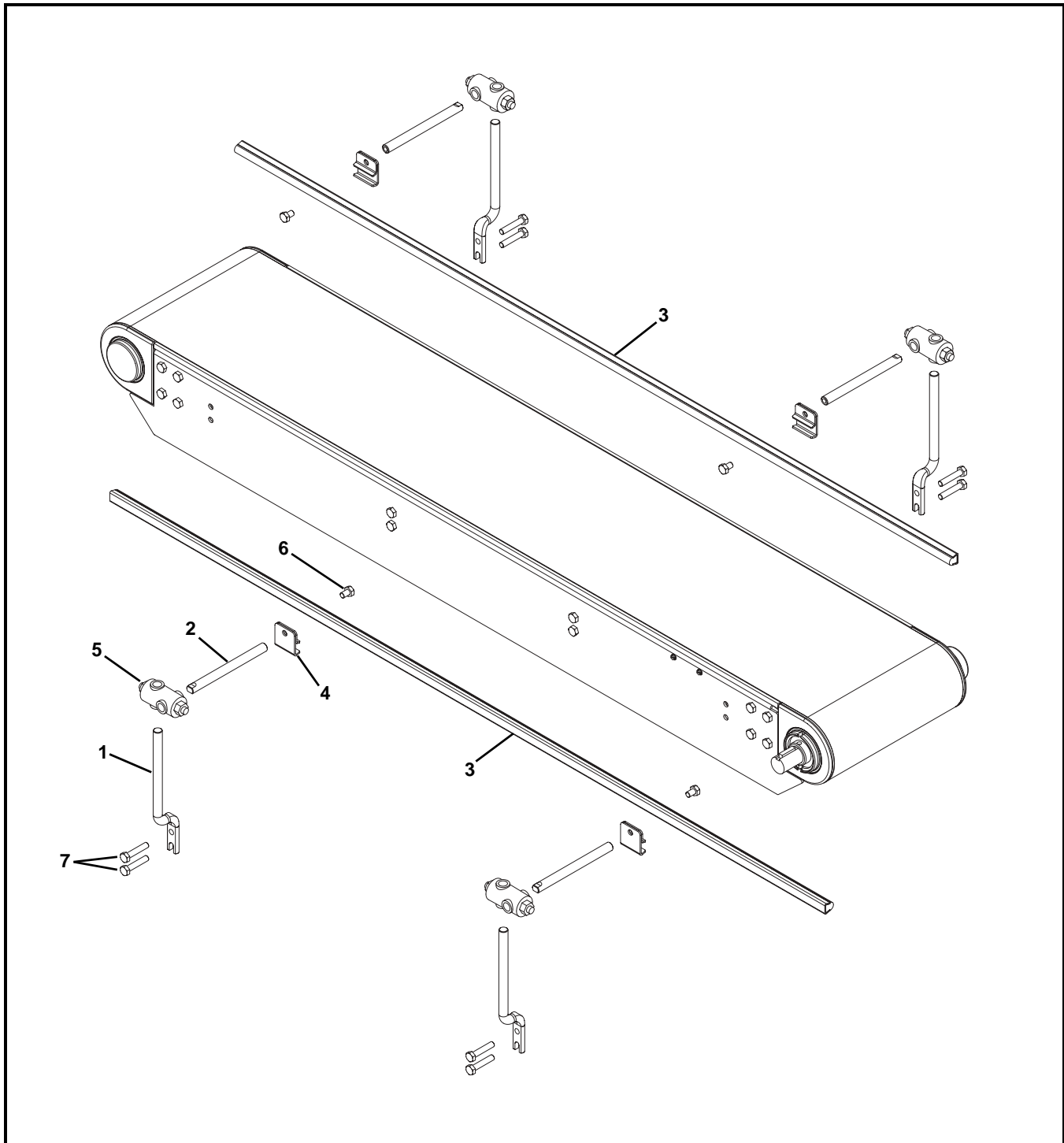


Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-06- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-06- <u>LLLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-06- <u>LLLLL</u>	Guiding, Middle (for Multiple Guide Sections Only)

Item	Part Number	Description
8	516997-06- <u>LLLLL</u>	Guiding (for One Piece Guiding)
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<p><u>LLLLL</u> = Part length in inches with 2 decimal places.                      Example: Part Length = 95.25" <u>LLLLL</u> = 09525</p>		
<p>Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com</p>		

# Service Parts

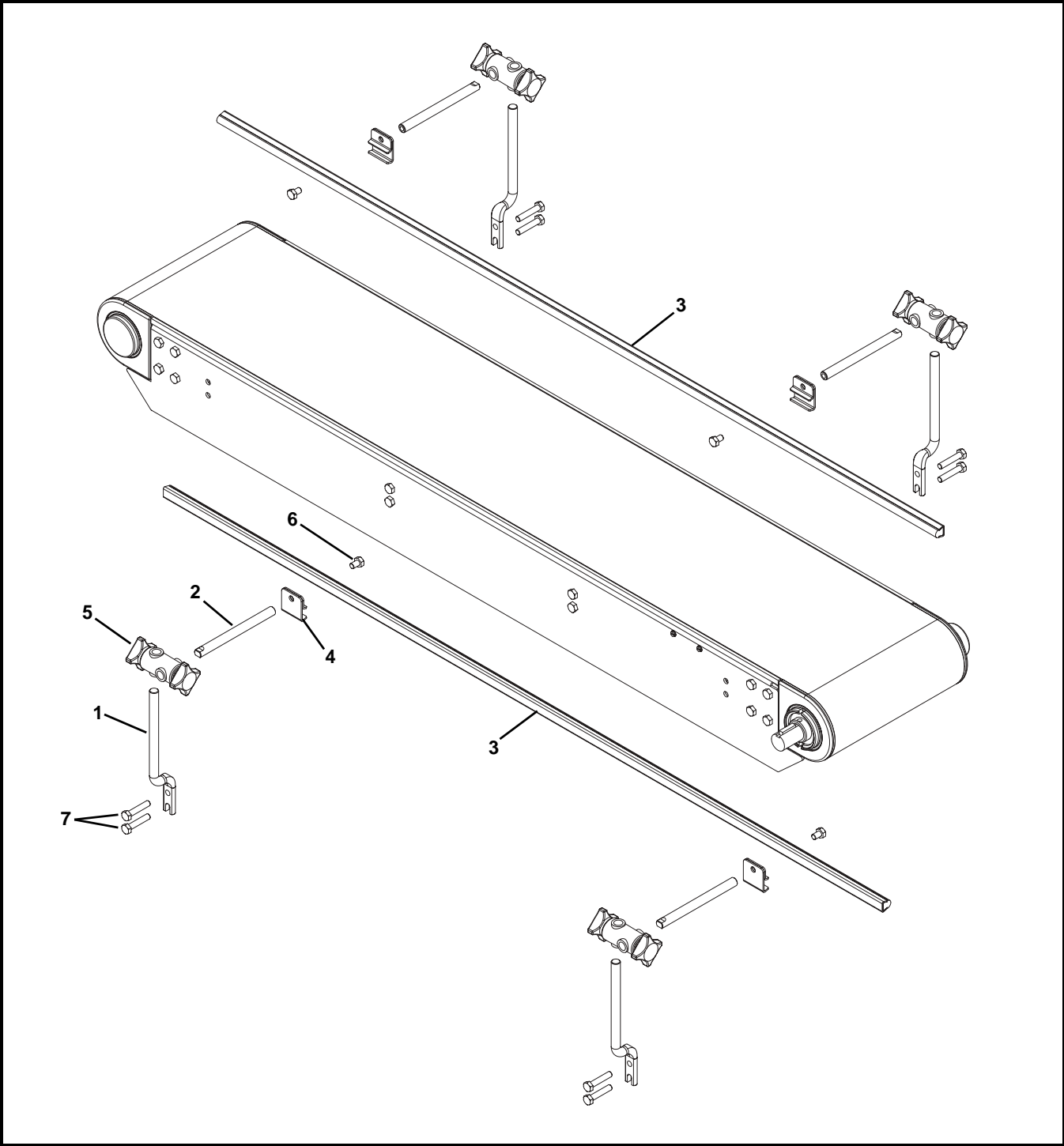
## Fully Adjustable Round Guides



Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167-LLLLL	Round Guide Rail
4	807-015	Rail Clamp
5	807-1387	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

## Tool-Less Fully Adjustable Round Guides

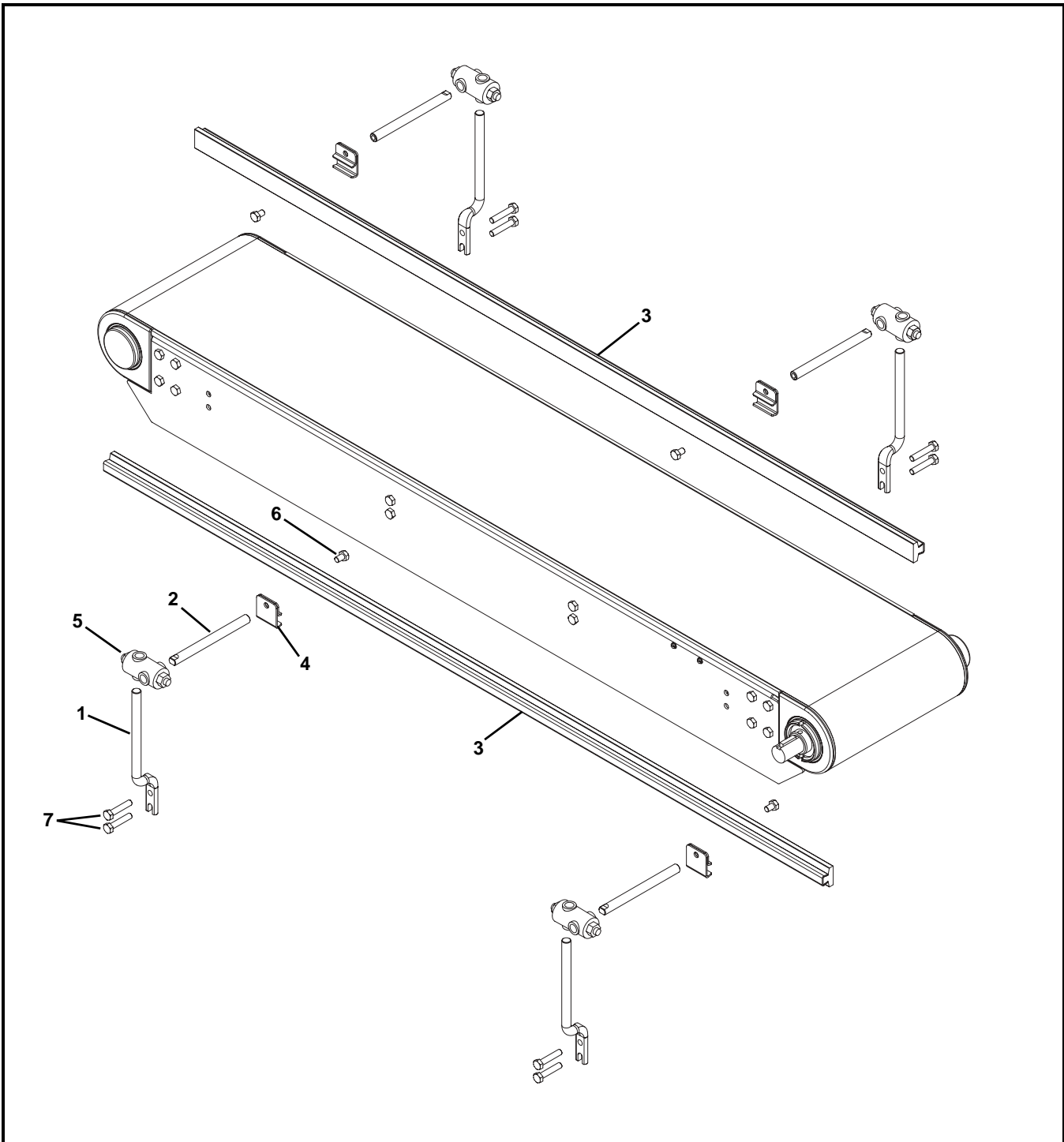


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167-LLLLL	Round Guide Rail
4	807-015	Rail Clamp
5	807-1470	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

# Service Parts

## Fully Adjustable Flat Guides

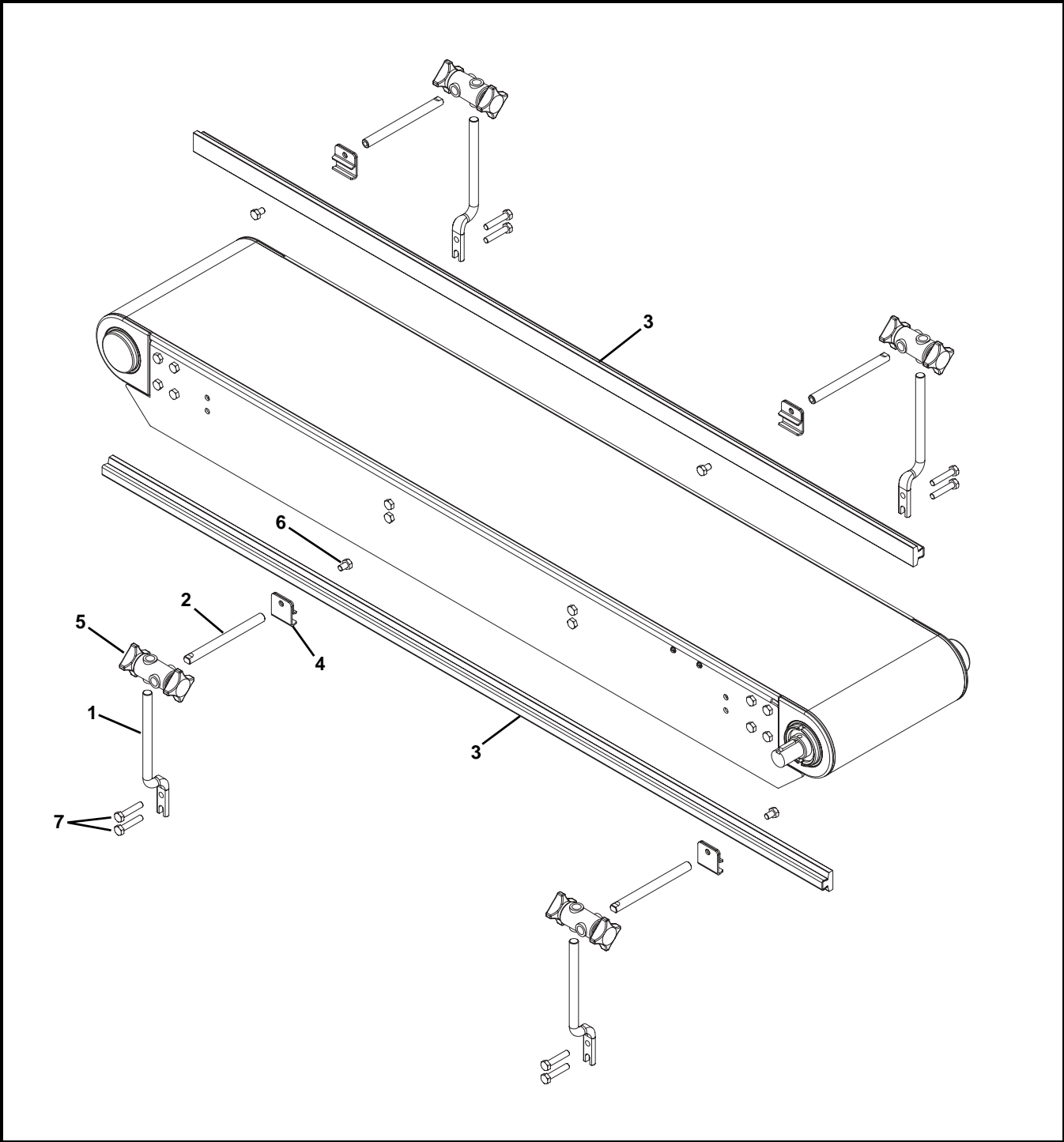


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	517599-LLLLL	Flat Guide Rail
4	807-015	Rail Clamp
5	807-1387	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		



## Tool-Less Fully Adjustable Flat Guides

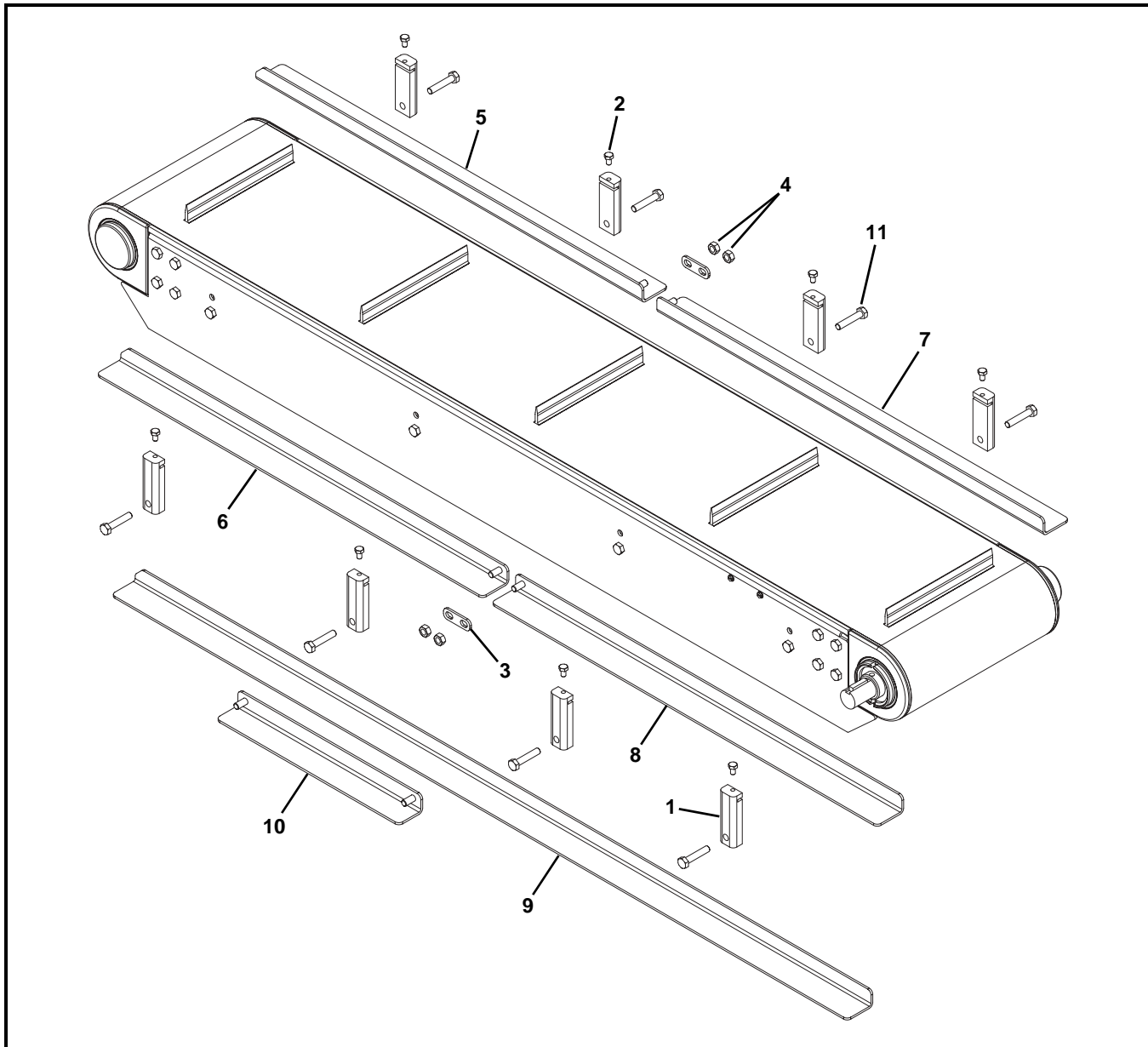


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	517599-LLLLL	Flat Guide Rail
4	807-015	Rail Clamp
5	807-1470	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

# Service Parts

## 25 mm Cleated High Sides



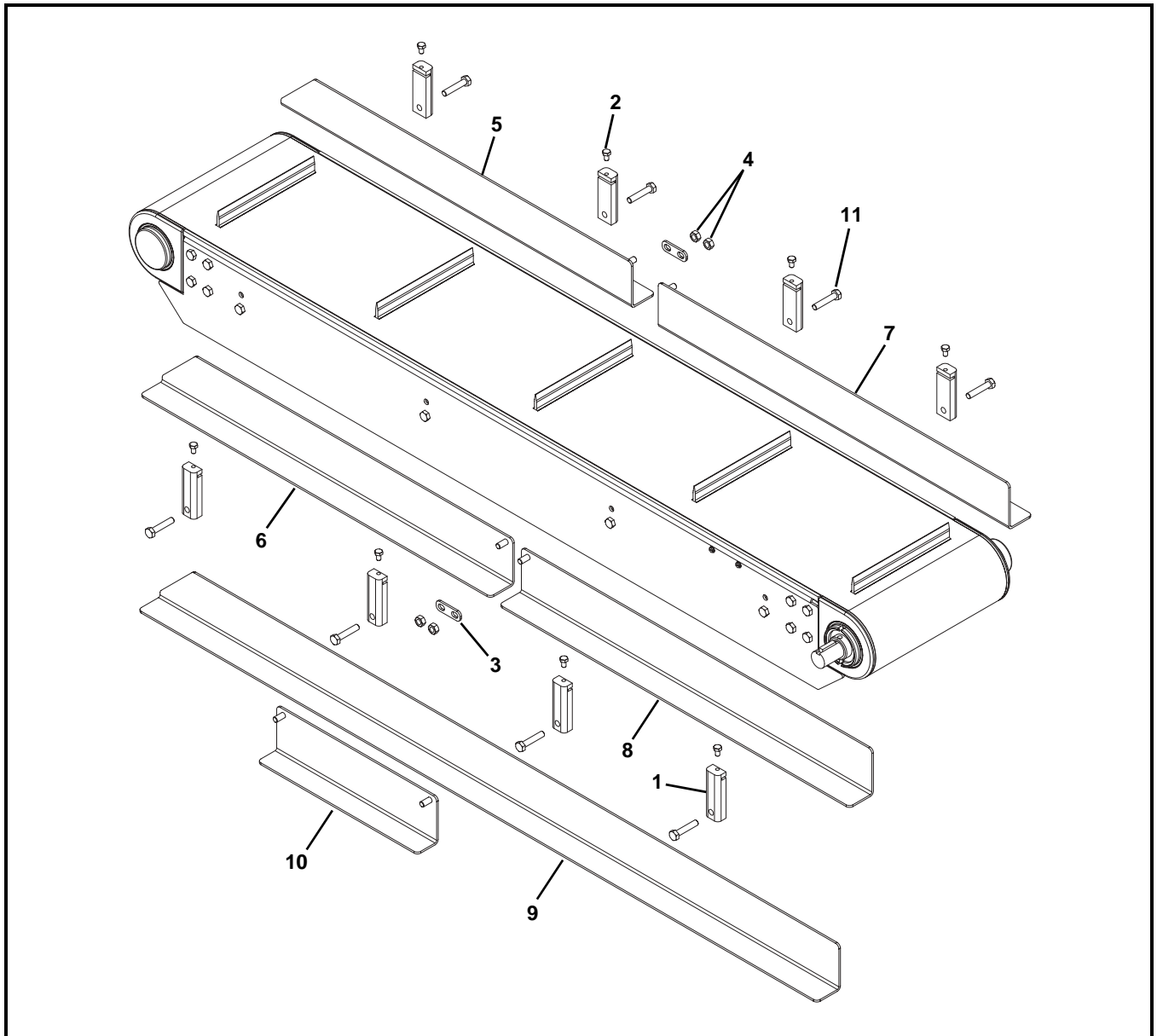
Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518386-02-LLLLL-LH	Guiding, Left Hand
6	518386-02-LLLLL-RH	Guiding, Right Hand
7	518396-02-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
8	518396-02-LLLLL-RH	Guiding, Right Hand (for Multiple Guide Sections Only)

Item	Part Number	Description
9	516998-02-LLLLL-RH	Guiding, Right Hand (for One Piece Guiding)
	516998-02-LLLLL-LH	Guiding, Left Hand (for One Piece Guiding)
10	518384-02-LLLLL	Guiding, Middle (for Multiple Guide Sections Only)
11	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm

LLLLL = Part length in inches with 2 decimal places.  
 Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

## 75 mm Cleated High Sides



Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518386-03-LLLLL-LH	Guiding, Left Hand
6	518386-03-LLLLL-RH	Guiding, Right Hand
7	518396-03-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
8	518396-03-LLLLL-RH	Guiding, Right Hand (for Multiple Guide Sections Only)

Item	Part Number	Description
9	516998-03-LLLLL-RH	Guiding, Right Hand (for One Piece Guiding)
	516998-03-LLLLL-LH	Guiding, Left Hand (for One Piece Guiding)
10	518384-03-LLLLL	Guiding, Middle (for Multiple Guide Sections Only)
11	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm

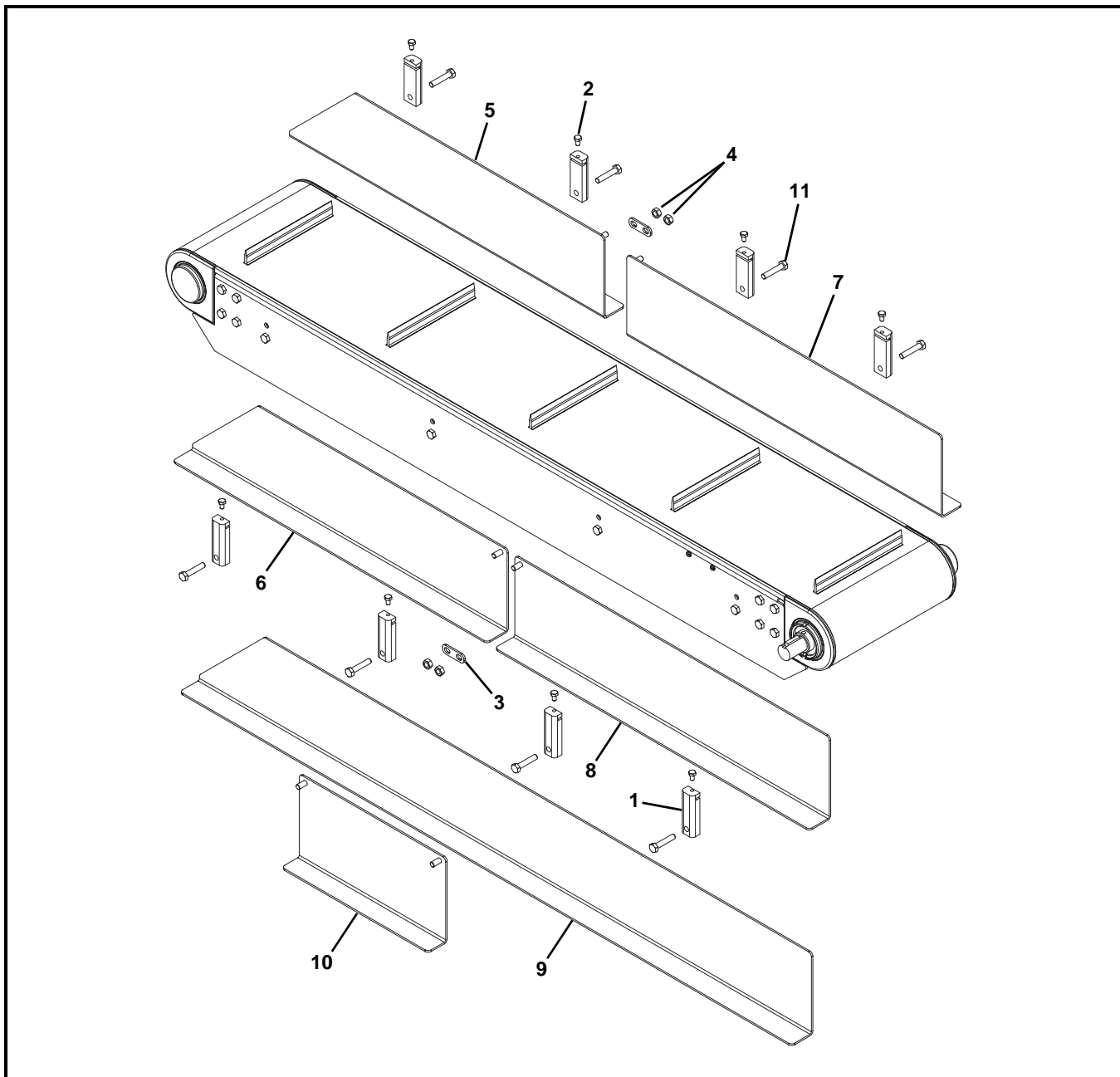
LLLLL = Part length in inches with 2 decimal places.

Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

# Service Parts

## 152 mm Cleated High Sides



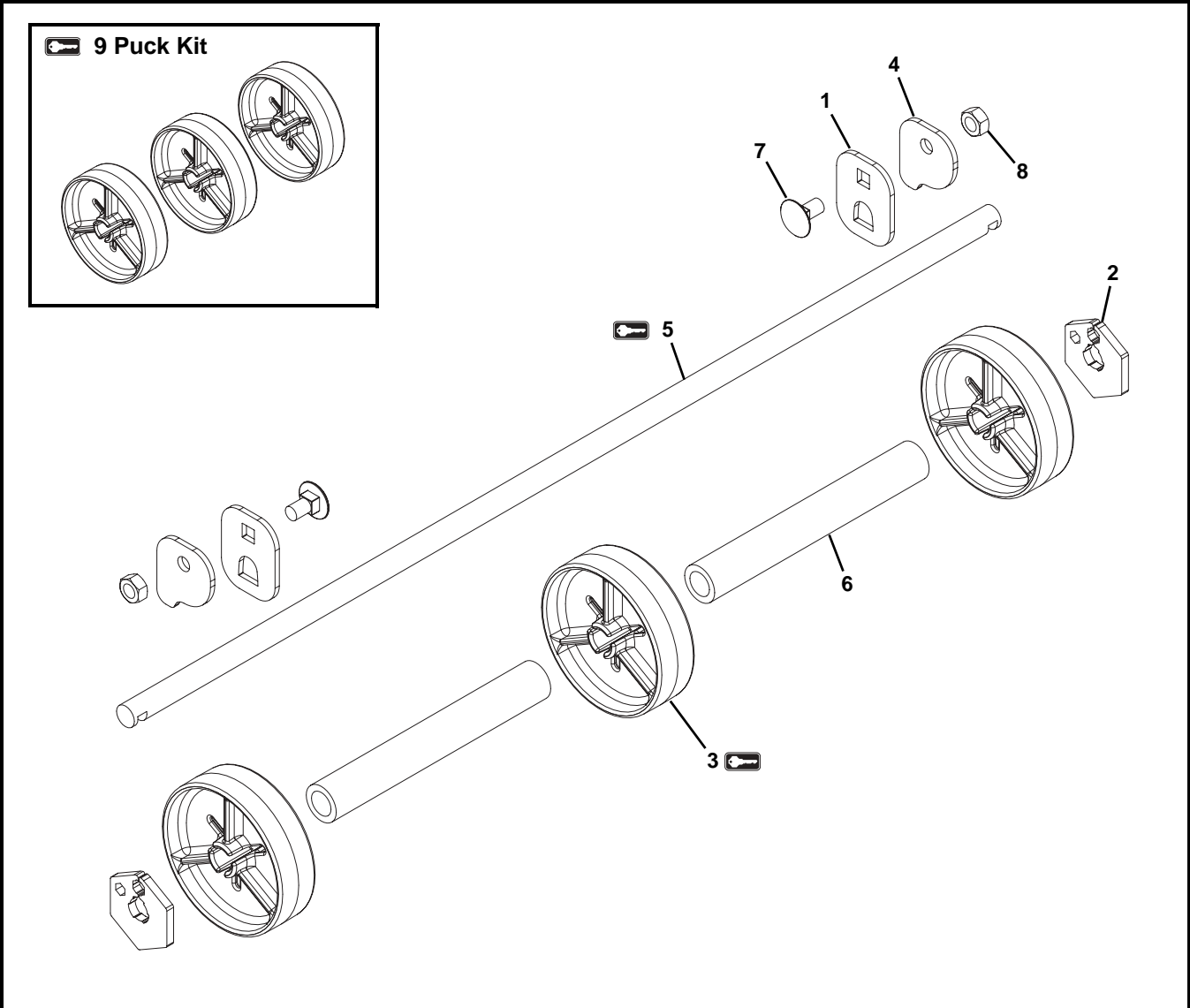
Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518386-06- <u>LLLLL</u> -LH	Guiding, Left Hand
6	518386-06- <u>LLLLL</u> -RH	Guiding, Right Hand
7	518396-06- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
8	518396-06- <u>LLLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)

Item	Part Number	Description
9	516998-06- <u>LLLLL</u> -RH	Guiding, Right Hand (for One Piece Guiding)
	516998-06- <u>LLLLL</u> -LH	Guiding, Left Hand (for One Piece Guiding)
10	518384-06- <u>LLLLL</u>	Guiding, Middle (for Multiple Guide Sections Only)
11	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm

LLLLL = Part length in inches with 2 decimal places.  
 Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

## Flat Belt Returns 610 mm Wide and Wider



Item	Part Number	Description
1	516855	Return Bracket
2	517575	Retaining Plate
3	517576	Puck
4	518394	Return Clip
5	517598-LLLLL	Shaft
6	518393-00600	Spacer
7	807-3543	Carriage Bolt, M8 x 16 mm
8	990801MSS	Hex Nut
9	520368-WWW	Puck Kit (Includes item 3)

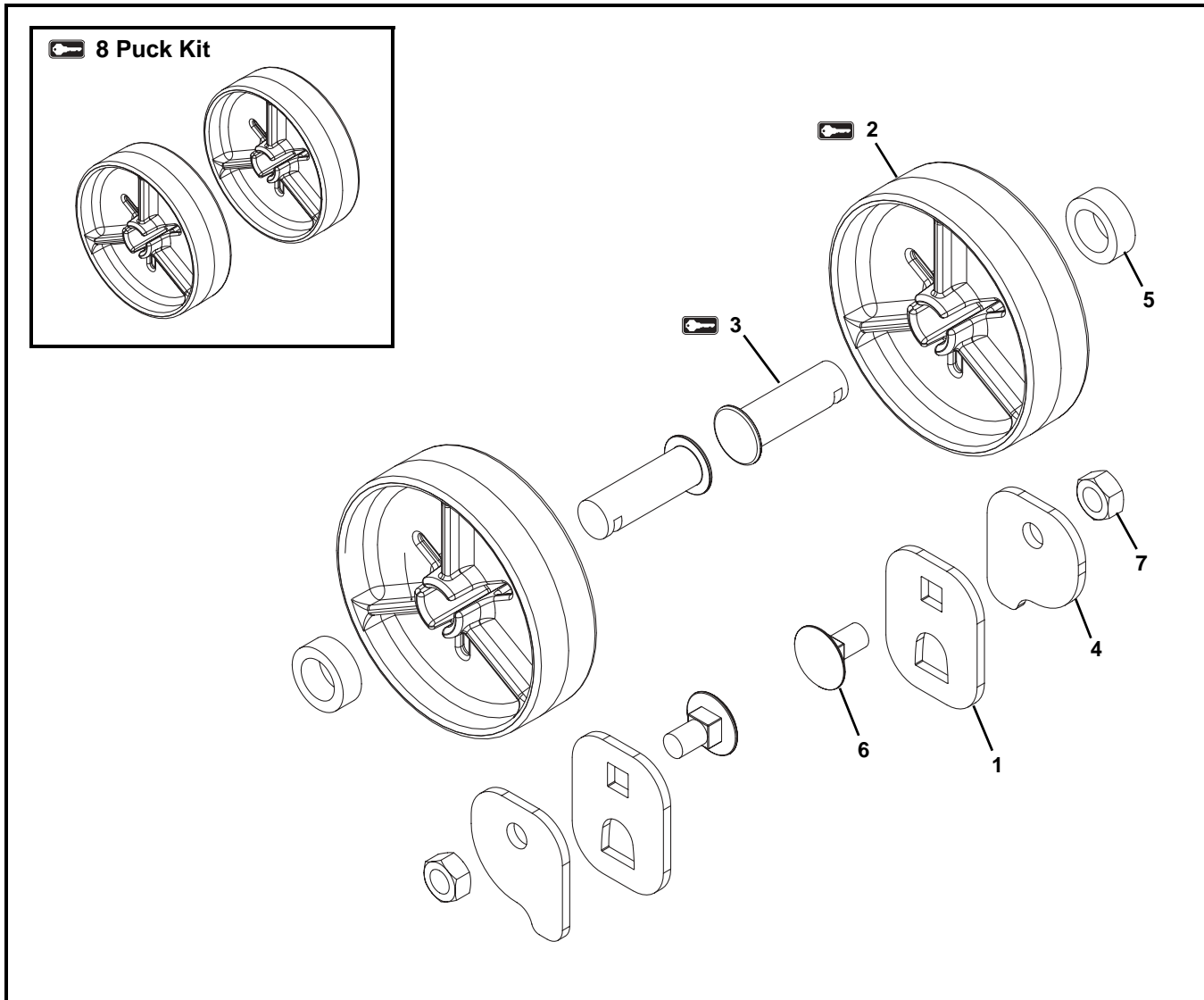
LLLLL = Part length in inches with 2 decimal places.

Example: Part Length = 95.25" LLLLL = 09525

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

# Service Parts

## Cleated Belt and Flat Belt Returns Under 610 mm Wide



Item	Part Number	Description
1	516855	Return Bracket
2	517576	Puck
3	517597	Stub Shaft
4	518394	Return Clip
5	518393-00030	Spacer
6	807-3543	Carriage Bolt, M8 x 16 mm
7	990801MSS	Hex Nut
8	550369	Puck Kit (Includes item 2)

Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or [customerservice@dorner.com](mailto:customerservice@dorner.com)



**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:**

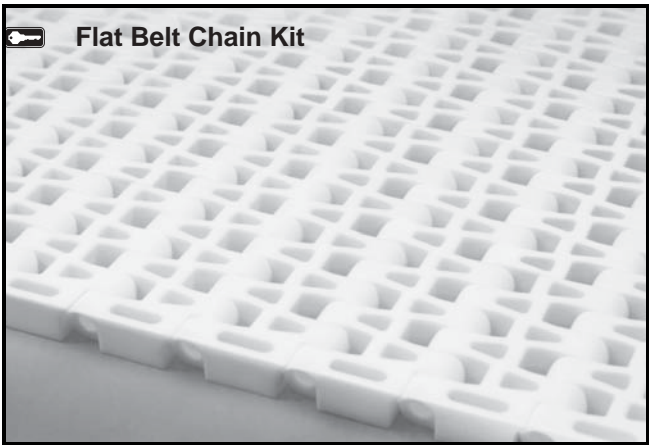
Overall chain length = 42' 5" (rounded up = 43')

Order: Qty (43) of 52BB-WW

BB = Chain reference number

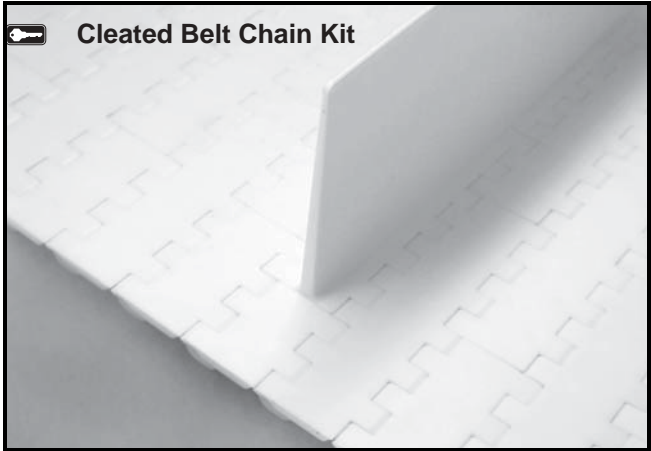
WW = Conveyor width ref: 04-36 in 02 increments

**Flat Belt Chain Repair Kit**



Item	Part Number	Description
1	52 <u>BB</u> - <u>WW</u>	Flat Belt Chain Repair Kit (Includes 1 ft (305 mm) of flat belt chain and assembly pins)
<u>BB</u> = Chain Reference number		
<u>WW</u> = Conveyor width ref: 04 - 36 in 02 increments		

**Cleated Belt Chain Repair Kit**



Item	Part Number	Description
1	52 <u>BB</u> - <u>WW</u> - <u>SS</u>	Cleated Belt Chain Repair Kit (Includes cleats on 1 ft (305mm) of belt chain and assembly pins)
<u>BB</u> = Chain Reference number		
<u>WW</u> = Conveyor width ref: 08 - 24 in 02 increments		
<u>SS</u> = Cleat Spacing		

# Return Policy

Returns must have prior written factory authorization or they will not be accepted. Items that are returned to Dorner without authorization will not be credited nor returned to the original sender. When calling for authorization, please have the following information ready for the Dorner factory representative or your local distributor:

1. Name and address of customer.
2. Dorner part number(s) of item(s) being returned.
3. Reason for return.
4. Customer's original order number used when ordering the item(s).
5. Dorner or distributor invoice number. Include part serial number if available.

A representative will discuss action to be taken on the returned items and provide a Returned Materials Authorization (RMA) number for reference. RMA will automatically close 30 days after being issued. To get credit, items must be new and undamaged. There will be a return charge on all items returned for credit, where Dorner was not at fault. It is the customer's responsibility to prevent damage during return shipping. Damaged or modified items will not be accepted. The customer is responsible for return freight.

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

Returns will not be accepted after 60 days from original invoice date. The return charge covers inspection, cleaning, disassembly, disposal and reissuing of components to inventory. If a replacement is needed prior to evaluation of returned item, a purchase order must be issued. Credit (if any) is issued only after return and evaluation is complete.

Dorner has representatives throughout the world. Contact Dorner for the name of your local representative. Our Customer Service Team will gladly help with your questions on Dorner products.

For a copy of Dorner's Warranty, contact Dorner, an authorized sales channel or visit our website: [www.dorner.com](http://www.dorner.com).

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

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



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## Dorner – North & South America

### Dorner – U.S.A.

**Headquarters**  
 975 Cottonwood Ave  
 Hartland, WI 53029, USA  
 (800) 397-8664  
 (262) 367-7600  
[info@dorner.com](mailto:info@dorner.com)

### Dorner – Canada

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

### Dorner – Latin America

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

### Dorner – Europe

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

### Dorner – Asia

128 Jalan Permatang Damar Laut, Bayan Lepas 11960  
 Penang, Malaysia  
 +604-626-2948 | [info.asia@dorner.com](mailto:info.asia@dorner.com)