



# 7350 Series Version 2 Modular Belt Curved Conveyors

Installation, Maintenance and Parts Manual



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Record Conveyor Serial Number Here

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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 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.

# Product Description

Refer to (Figure 1) for typical conveyor components.

1	Conveyor
2	Gearmotor
3	Belt
4	Support Stands
5	Drive End
6	Idler End

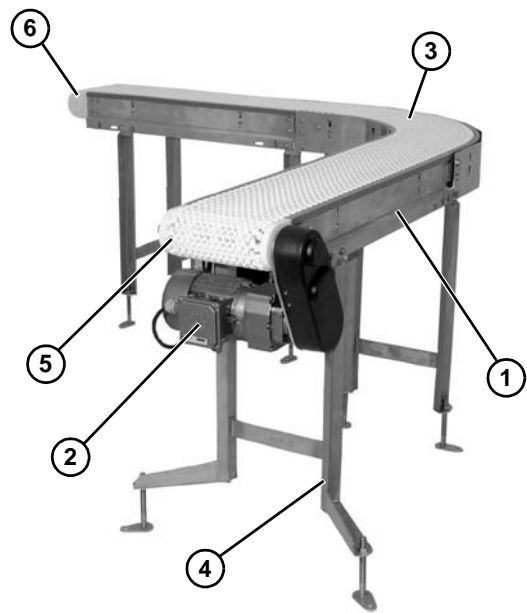


Figure 1

# Specifications

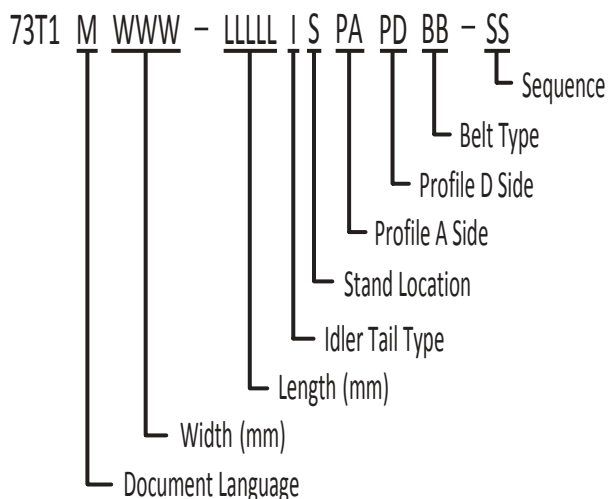
Conveyor Width Reference ( <u>WWW</u> )	152, 305, 457, 610
Conveyor Belt Width	152 mm (6"), 305 mm (12"), 457 mm (18"), 610 mm (24")
Maximum Conveyor Load (See NOTE Below)	97 kg/ m <sup>2</sup> (20 lbs. / ft <sup>2</sup> ) with a maximum of 227 kg (500 lbs.)
Belt Travel	305 mm (12") per revolution of pulley
Maximum Belt Speed	65 m/minute (213 ft/minute)
Conveyor Length Reference ( <u>LLLLL</u> )	00305 - 15240 in 00005 increments
Conveyor Length	305 mm (12") - 15240 mm (600") (25.4 m) in 5 mm (.20") increments

## NOTE

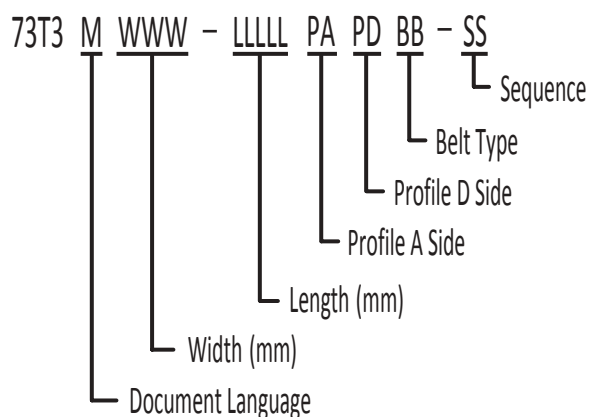
- Maximum conveyor loads are based on:
- Non-accumulating product
  - Product moving toward gearmotor
  - Conveyor being mounted horizontally
  - Conveyor being located in a dry environment
  - Conveyor equipped with standard belt only

## 7350 Series Version 2 Curve Conveyor Modules

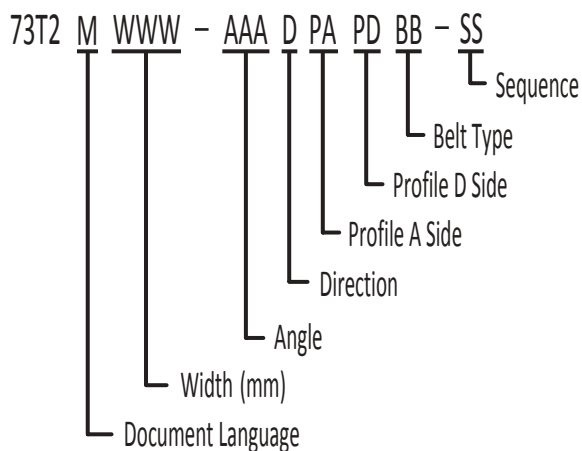
### 7350 Series Version 2 Infeed / Idler Module



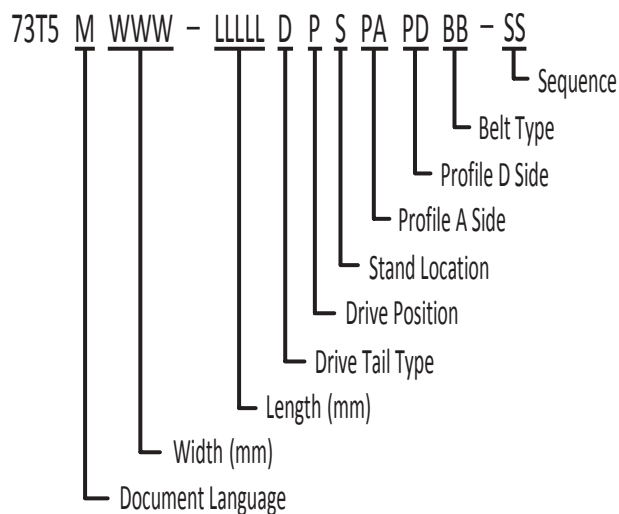
### 7350 Series Version 2 Intermediate Module



### 7350 Series Version 2 Curve Module



### 7350 Series Version 2 Exit / Discharge Module



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# Specifications

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## Conveyor Supports

### Infeed / Idler Module:

- "A" = 914 mm (36") maximum (See Figure 2)
- Modules 610 mm (24") - 1194 mm (47") long get 1 support stand
- All other lengths get 2 support stands, plus an additional support stand at each straight section break (over 3962 mm (13') straight frame module)

### Intermediate Module:

- Modules 610 mm (24") - 1499 mm (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 3962 mm (13'))

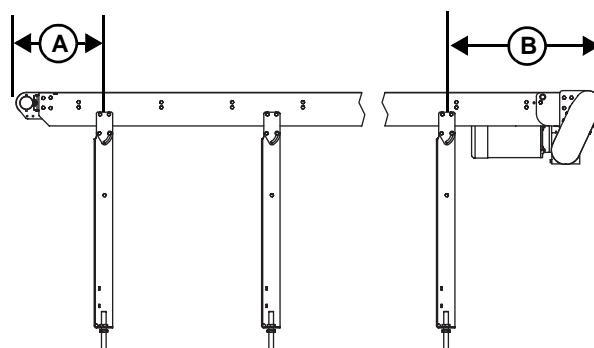
### Exit / Drive Module

- "B" = 610 mm (24") maximum (See Figure 2)
- Modules 610 mm (24") - 1194 mm (47") long get 1 support stand
- All other lengths get 2 support stands, plus an additional support stand at each straight section break (modules over 3962 mm (13'))

### Curve Module:

Reference chart below for support stand quantities:

Degree/Width	152 mm (6")	305 mm (12")	457 mm (18")	610 mm (24")
45°	0	0	0	0
90°	0	1	1	1
135°	0	2	2	2
180°	0	3	3	3



**Figure 2**

## CAUTION

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

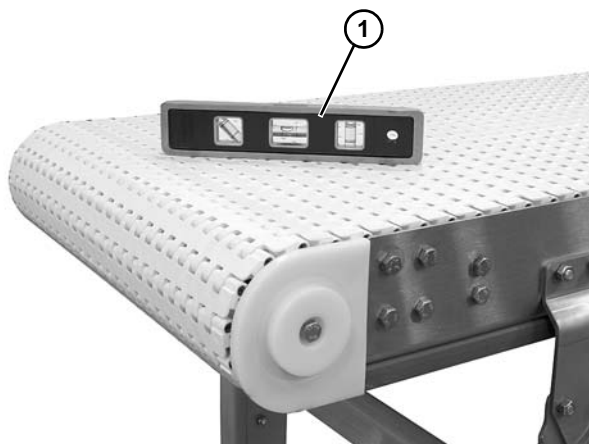


Figure 3

## Required Tools

- Level
- Flat blade screwdriver
- 5/32" hex wrench
- 13 mm wrench
- 14 mm wrench
- 17 mm wrench

## Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to "Connecting Components" on page 7 or "Belt Installation" on page 8.
2. Attach the stands. Refer to "Stand Installation" on page 8.
3. Install the belt. Refer to "Belt Installation" on page 8.
4. Install the gearmotor. Refer to "Drive Package Installation" on page 11.

## Connecting Components

Typical connecting components (Figure 4).

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

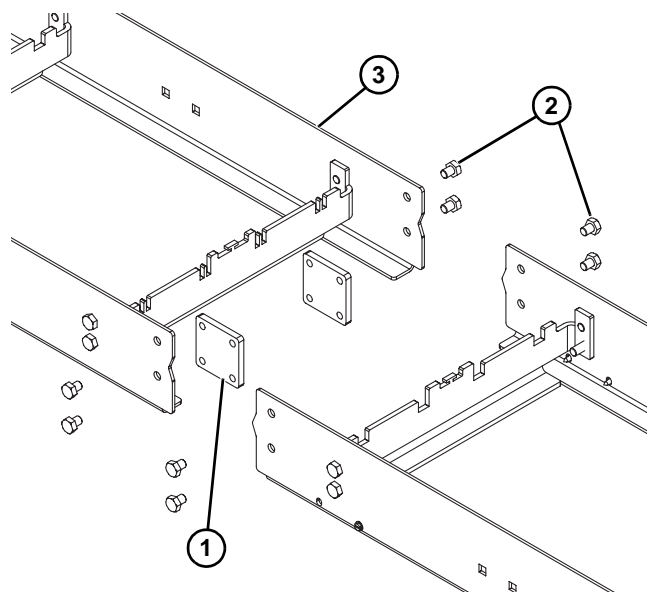


Figure 4

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

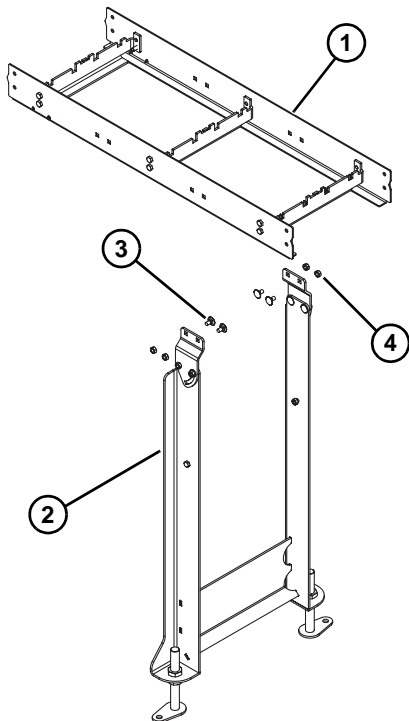
## Stand Installation

### NOTE

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

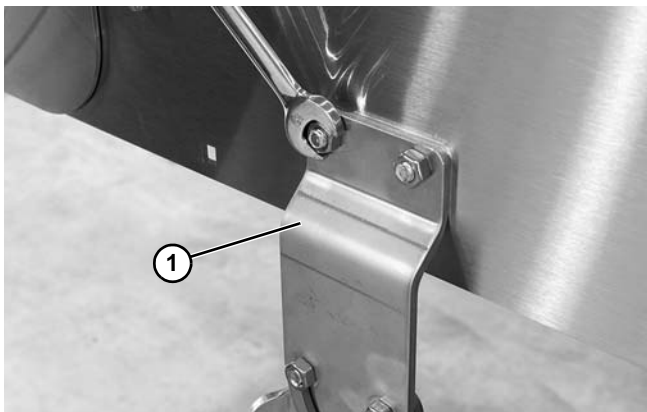
Typical stand components (**Figure 6**).

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



**Figure 6**

1. Position the stands on a flat, level surface.
2. Attach the stands (**Figure 7, item 1**) to the frame.

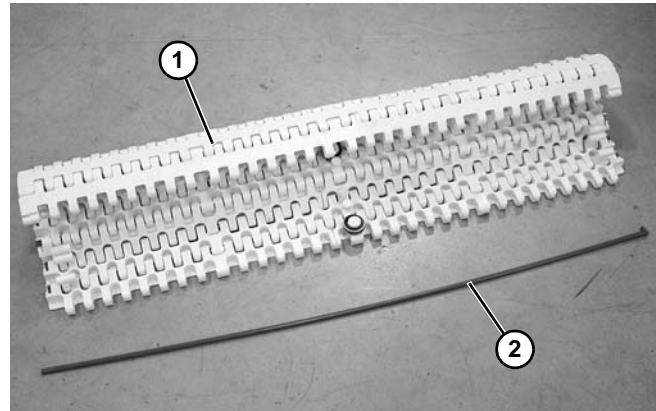


**Figure 7**

## Belt Installation

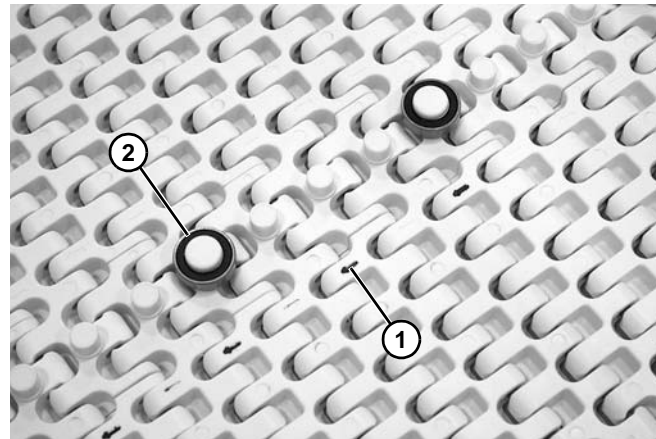
Typical belt components (**Figure 8**).

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



**Figure 8**

1. Position the belt on the conveyor frame.
2. Orient the belt with the arrows (**Figure 9, item 1**) on the underside of the belt pointing in the direction of the travel of the belt.



**Figure 9**

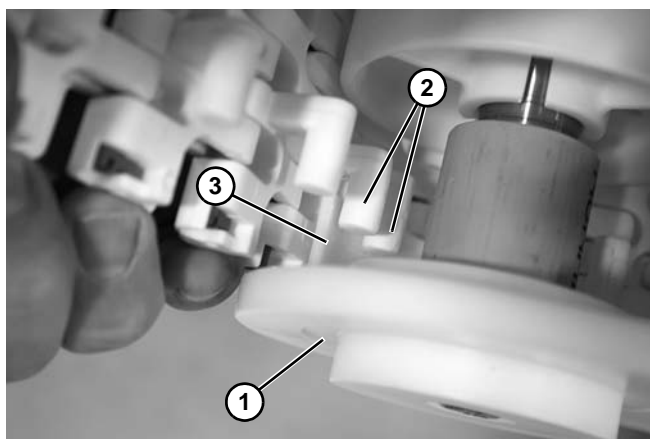
### NOTE

*The bearings (**Figure 9, item 2**) on the underside of the belt must not be next to each other. A minimum of one space, and a maximum of three spaces, is required between bearings.*

3. Wrap the belt around the idler tail (**Figure 10, item 1**). Feed the belt through the idler tail with belt tabs (**Figure 10, item 2**) riding on the inside of the headplate channel (**Figure 10, item 3**).

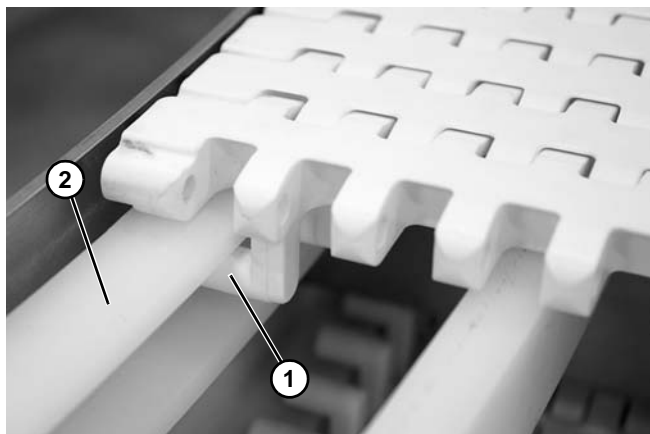
## NOTE

*The belt tabs must ride on the inside of the headplate channel or jamming occurs.*

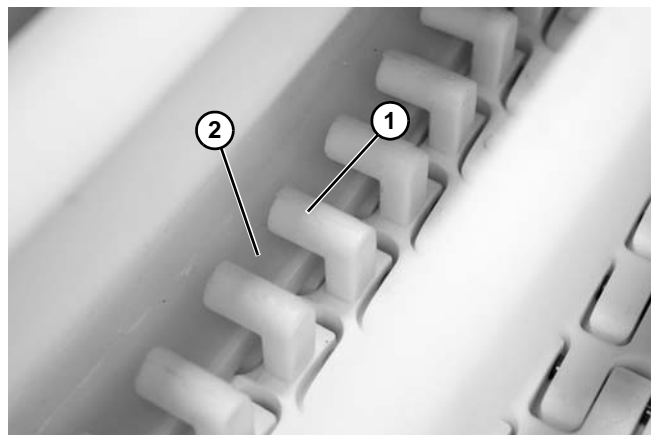


**Figure 10**

4. Feed the ends of the belt through the top and bottom of the curved frame sections. Make sure the belt tabs (**Figure 11, item 1**) and (**Figure 12, item 1**) are properly engaged with the wearstrips (**Figure 11, item 2**) and (**Figure 12, item 2**).

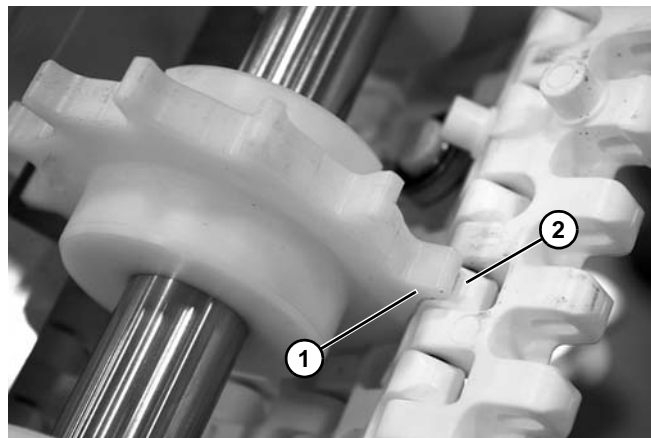


**Figure 11**



**Figure 12**

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



**Figure 13**

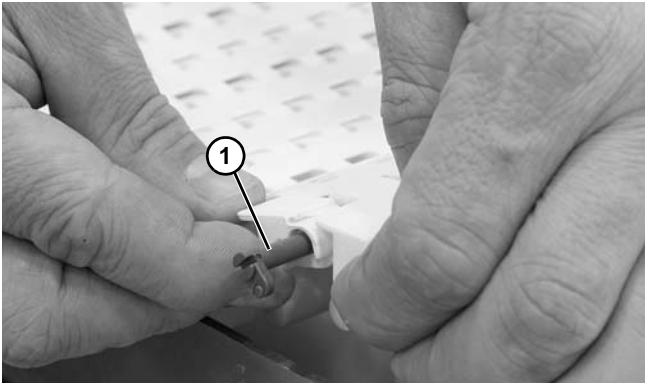
6. Bring the ends of the belt together (**Figure 14**).



**Figure 14**

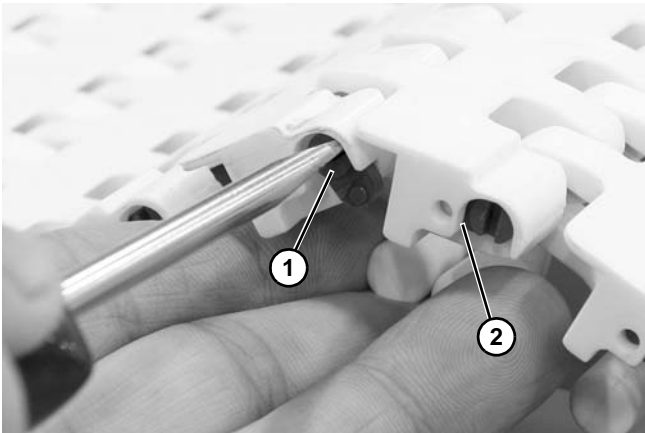
# Installation

7. Insert the belt rod (**Figure 15, item 1**) and push it through the belt.



**Figure 15**

8. Insert a flat blade screwdriver into the slot on the rod head (**Figure 16, item 1**). Rotate rod head clockwise into the locked position (**Figure 16, item 2**).



**Figure 16**

## Guide Installation

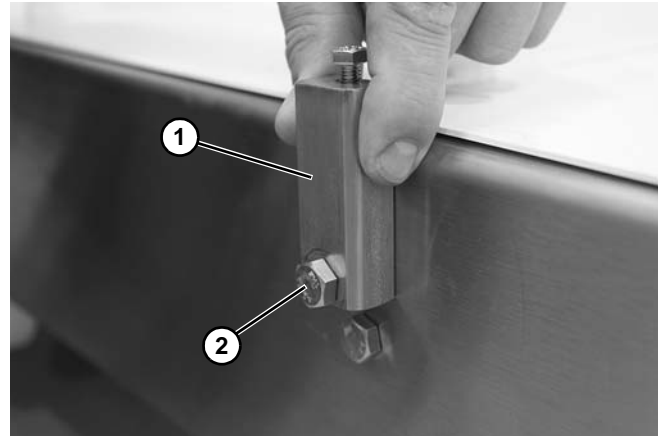
### High Side Guides

1. Remove and discard the top bolt (**Figure 17, item 1**) from the conveyor side.



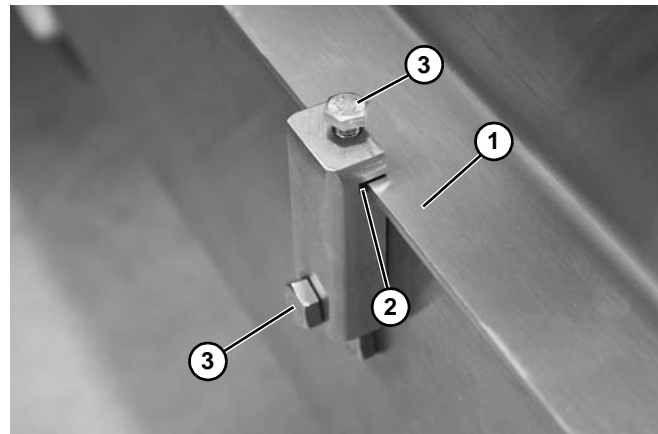
**Figure 17**

2. Assemble the mounting block (**Figure 18, item 1**) to the conveyor side with the bolt (**Figure 18, item 2**) provided with the mounting block.



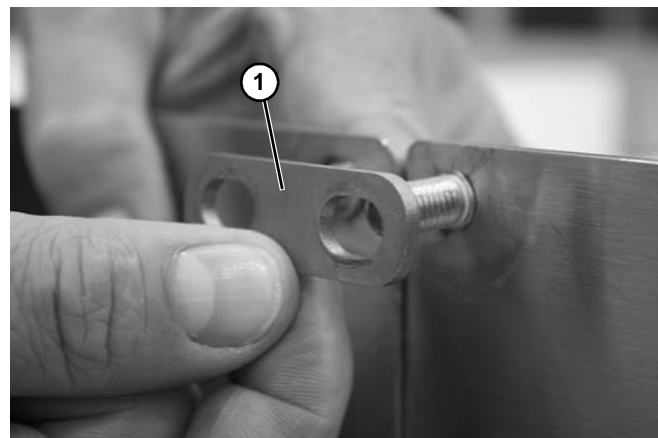
**Figure 18**

3. Install guide (**Figure 19, item 1**) into the slot (**Figure 19, item 2**) of the mounting block and tighten bolts (**Figure 19, item 3**).



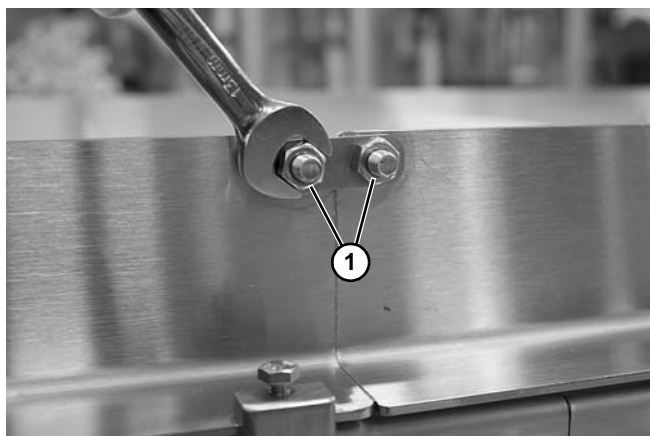
**Figure 19**

4. Install the connecting plate (**Figure 20, item 1**) over the studs.



**Figure 20**

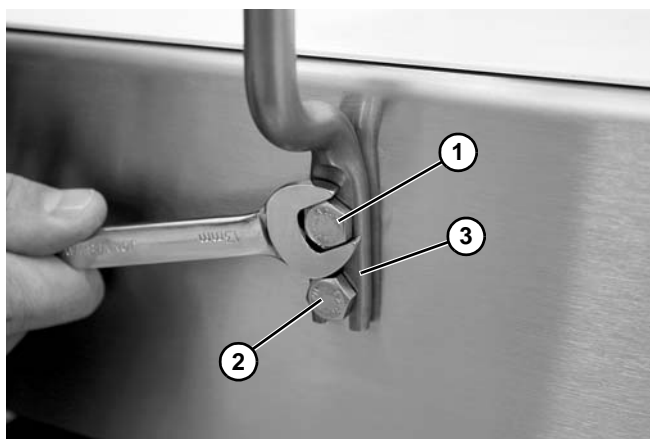
5. Install nuts (**Figure 21, item 1**) and tighten.



**Figure 21**

## Adjustable Guides

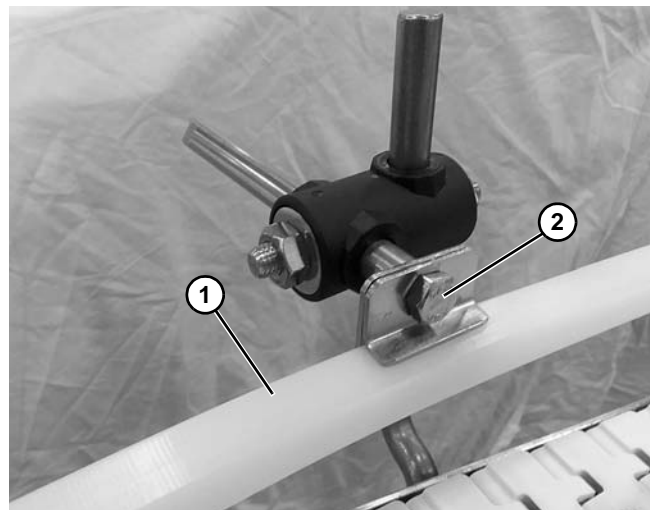
1. Remove the top bolt (**Figure 22, item 1**) and loosen the bottom bolt (**Figure 22, item 2**).



**Figure 22**

2. Install the guide post (**Figure 22, item 3**) behind lower bolt. Reinstall top bolt and tighten bolts.

3. Install guide rail (**Figure 23, item 1**) into rail clamp. Tighten fastener to secure (**Figure 23, item 2**).



**Figure 23**

## NOTE

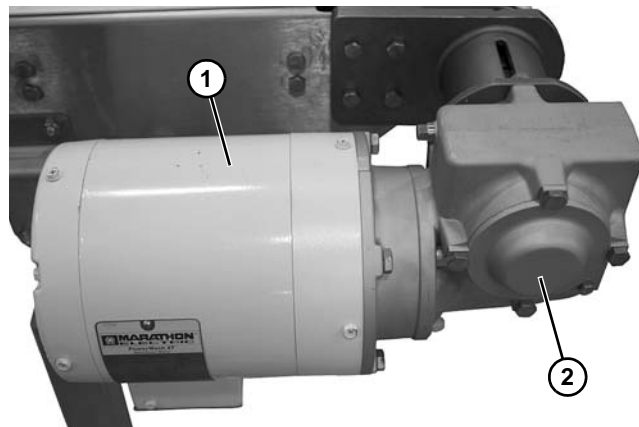
See pages 43 to 46 for detailed view of guide assembly.

## Drive Package Installation

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

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

1. Attach the motor (**Figure 24, item 1**) to the gear reducer (**Figure 24, item 2**).



**Figure 24**

# Preventive Maintenance and Adjustment

## Required Tools

- 1/8" hex 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)
- Phillips screwdriver

## Checklist

- Keep critical service parts on hand. Refer to the "Service Parts" section starting on page 27 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" before placing the conveyor into service. Ensure that 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.

## Lubrication

No lubrication is required. Replace bearings if worn.

## 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

## Conveyor Belt Replacement

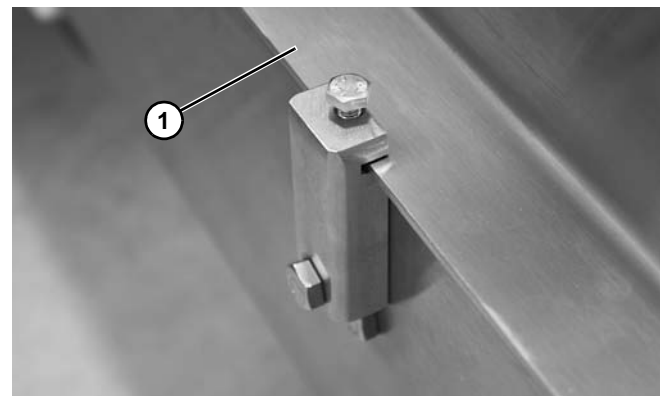
### ⚠ WARNING



#### SEVERE HAZARD!

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

1. Remove guides (Figure 25, item 1) when required.



**Figure 25**

# Preventive Maintenance and Adjustment

## NOTE

On 610 mm wide conveyors, DO NOT remove rods located at the bearing. These links are made up of 3 short rods (Figure 26, item 1), not a single piece rod (Figure 26, item 2).

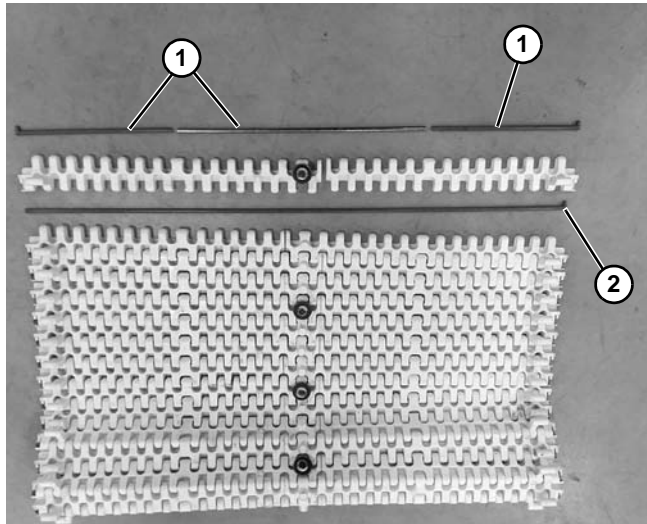


Figure 26

2. Lift up the belt near the tail end of the conveyor, or near a straight section. Locate the rod head with a slot (Figure 27, item 1).

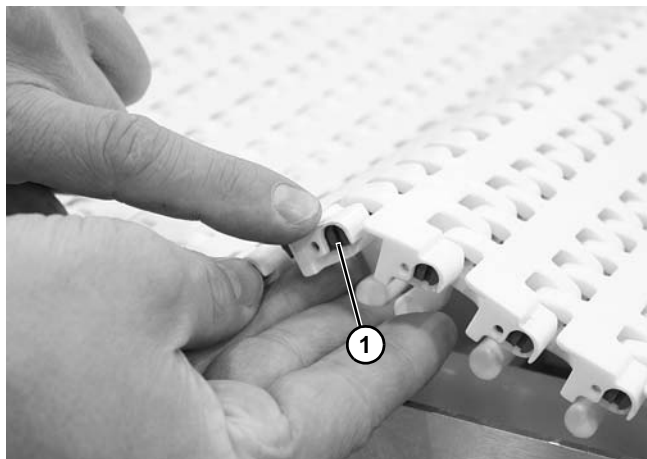


Figure 27

3. Insert a flat blade screwdriver into the slot on the rod head (Figure 28, item 1) and rotate the rod head counterclockwise to unlock.

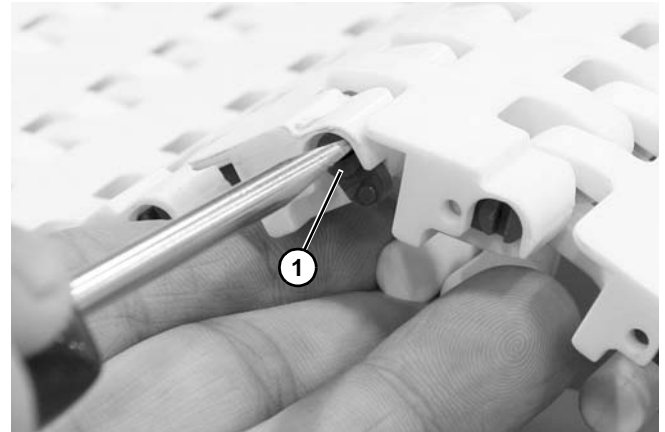


Figure 28

4. Remove the belt rod (Figure 29, item 1).

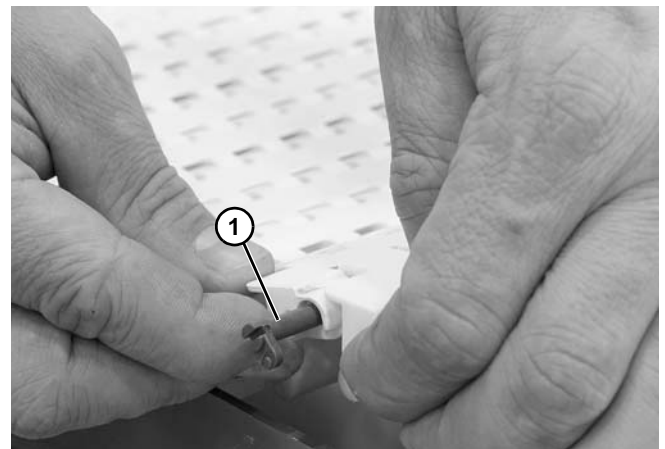


Figure 29

5. Slide the old belt off the conveyor frame.
6. 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.

# Preventive Maintenance and Adjustment

## Conveyor Belt Tensioning

### **WARNING**

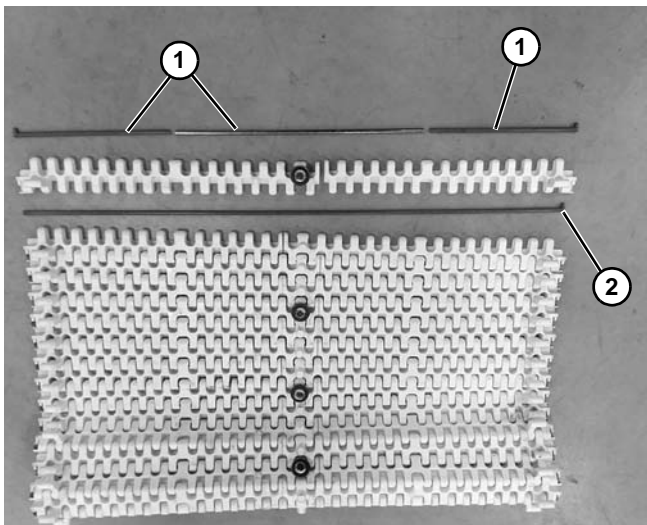


#### **SEVERE HAZARD!**

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

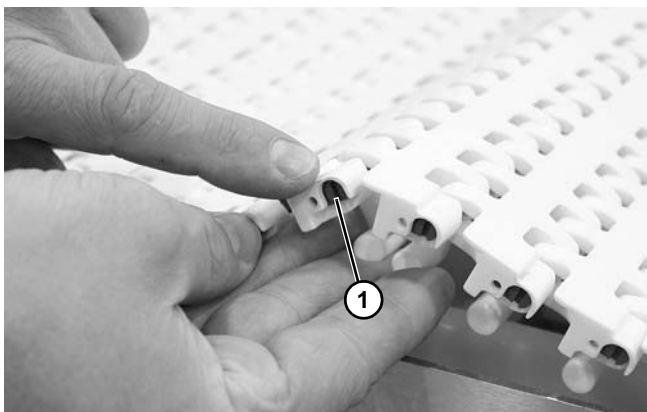
### **NOTE**

On 610 mm wide conveyors, **DO NOT** remove rods located at the bearing. These links are made up of 3 short rods (**Figure 30, item 1**), not a single piece rod (**Figure 30, item 2**).



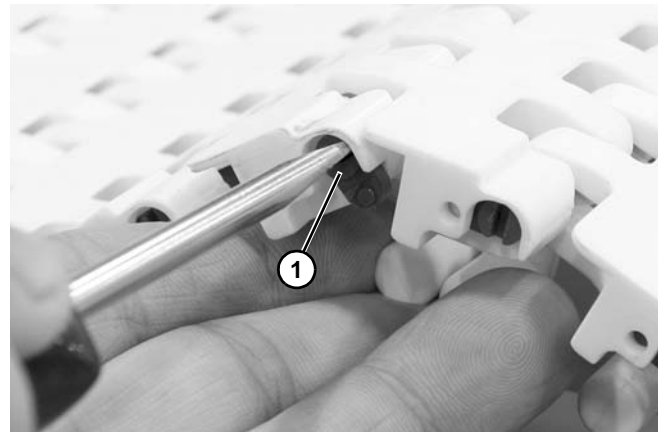
**Figure 30**

1. Lift up the belt near the tail end of the conveyor, or near a straight section. Locate the rod head with a slot (**Figure 31, item 1**).



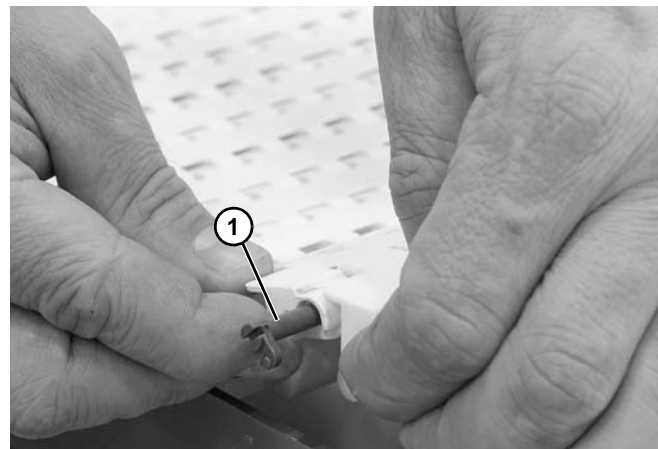
**Figure 31**

2. Insert a flat blade screwdriver into the slot on the rod head (**Figure 32, item 1**) and rotate the rod head counterclockwise to unlock.



**Figure 32**

3. Remove the belt rod (**Figure 33, item 1**).



**Figure 33**

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

### **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.*

# Preventive Maintenance and Adjustment

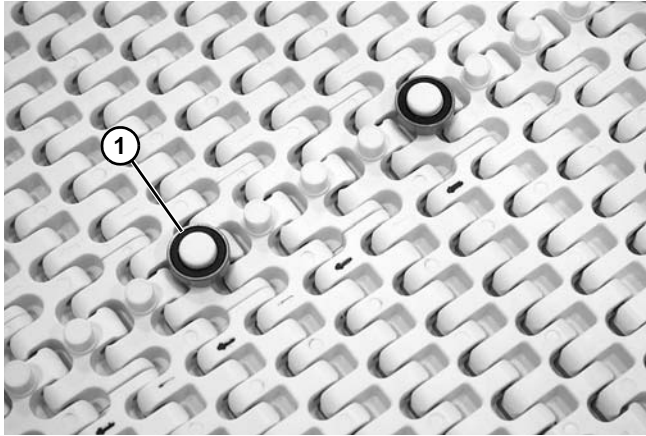


Figure 34

## NOTE

The bearings (**Figure 34, item 1**) on the underside of the belt must not be next to each other. A minimum of one space, and a maximum of three spaces, is required between bearings.

## Wear Strips

Replace the wear strips if they become worn.

Typical straight wear strips (**Figure 35**).

- |   |                       |
|---|-----------------------|
| 1 | Wear Strip            |
| 2 | Wear Strips, Bed Rail |

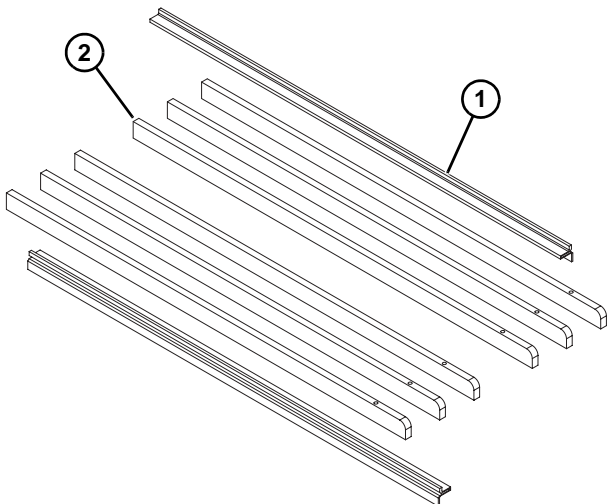


Figure 35

Typical curve wear strips (**Figure 36**).

- |   |                           |
|---|---------------------------|
| 1 | Wear Strip, Upper         |
| 2 | Wear Strip, Lower         |
| 3 | Wear Strip, Bearing Guide |
| 4 | Wear Strips, Bed Rail     |

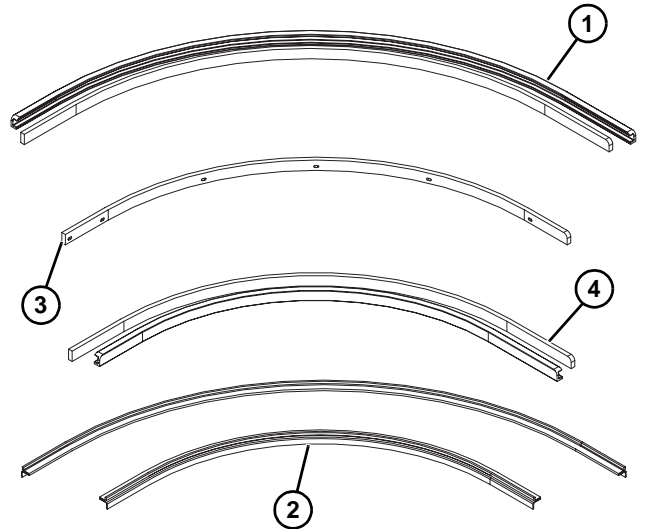
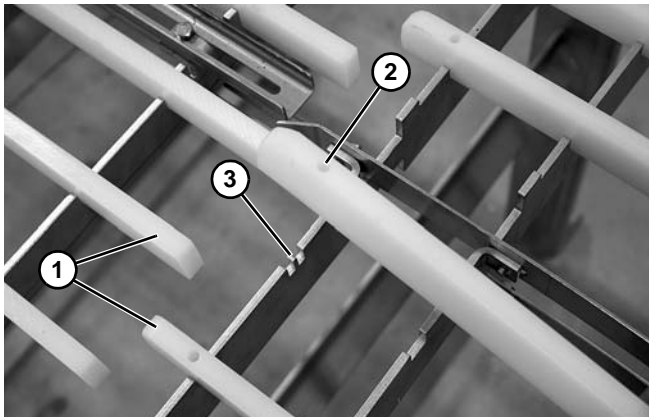


Figure 36

# Preventive Maintenance and Adjustment

## Wear Strip Removal

1. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 12.
2. Remove worn wear strips (**Figure 37, item 1**) from the frame notches.



**Figure 37**

3. Attach new wear strips by installing the locating hole (**Figure 37, item 2**) over the tab (**Figure 37, item 3**) on the crossmember.

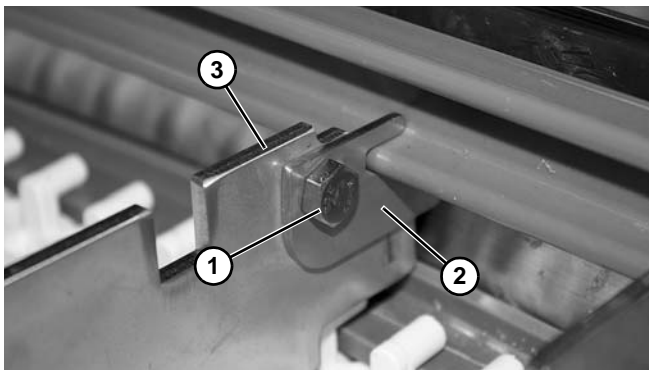
### NOTE

*Rounded end of the wear strip must face up.*

## Curved Wear Strip Removal

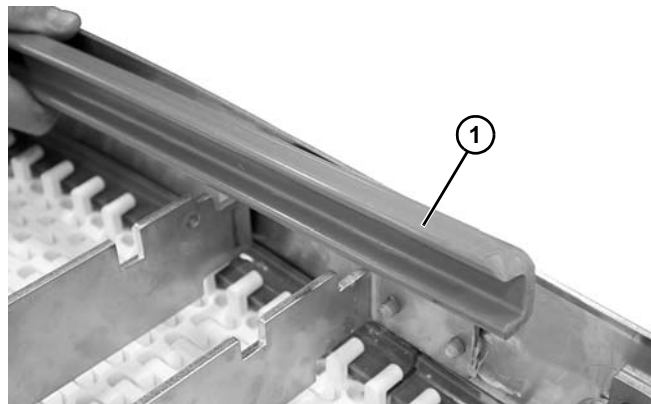
### Top Wear Strip

1. Remove the bolt (**Figure 38, item 1**) retaining the wear strip support bracket (**Figure 38, item 2**) to the frame crossmember (**Figure 38, item 3**).



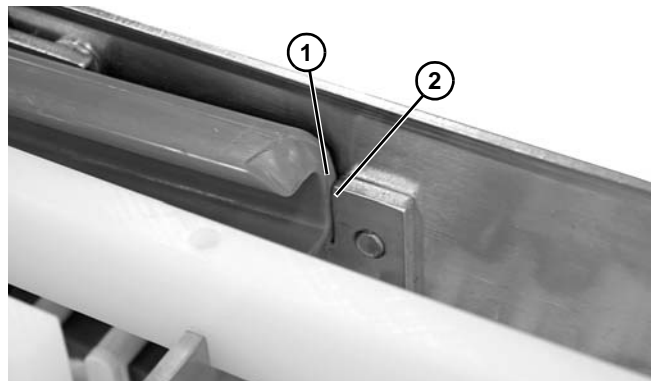
**Figure 38**

2. Remove the upper wear strip (**Figure 39, item 1**) from the frame.



**Figure 39**

3. When installing a new wear strip, make sure the wear strip (**Figure 40, item 1**) is contacting the crossmember tab (**Figure 40, item 2**).

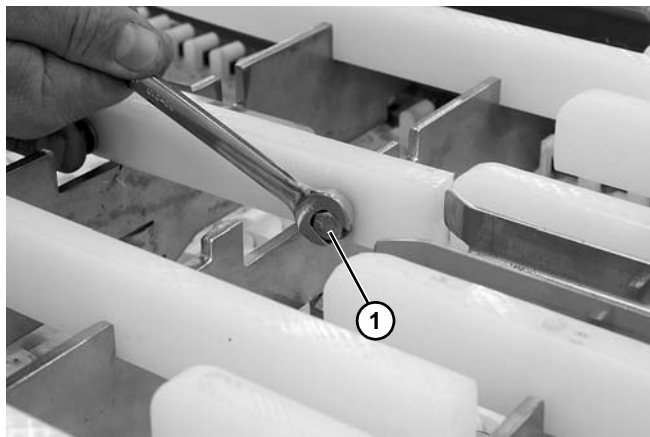


**Figure 40**

# Preventive Maintenance and Adjustment

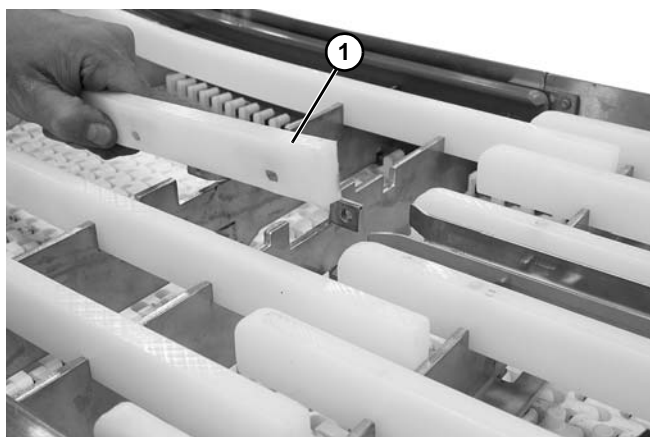
## Curve Bearing Guide Wear Strip

1. Remove the bolt (**Figure 41, item 1**) retaining the wear strip to the frame crossmember.



**Figure 41**

2. Remove the wear strip (**Figure 42, item 1**).

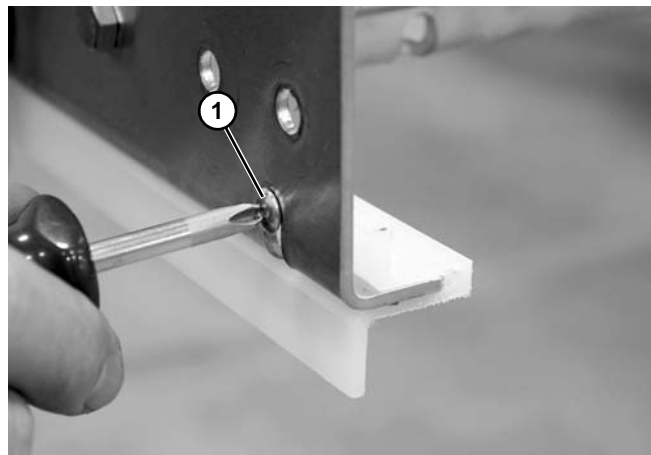


**Figure 42**

3. Install a new wear strip.

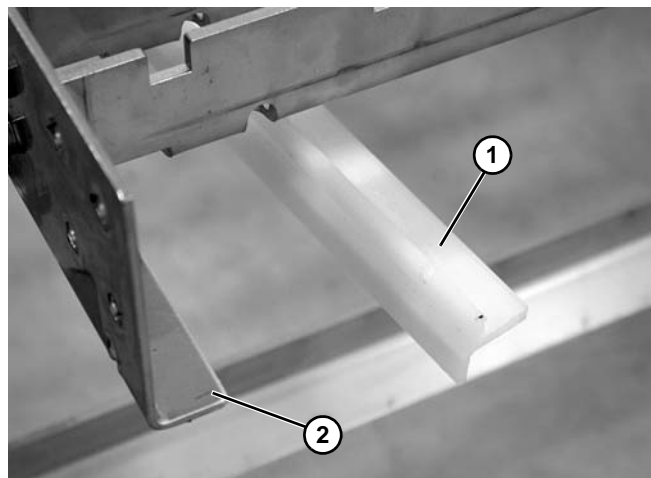
## Bottom Wear Strip

1. Remove the screw (**Figure 43, item 1**) retaining the wear strip to the frame.



**Figure 43**

2. Remove the bottom wear strip (**Figure 44, item 1**) from the frame rail (**Figure 44, item 2**).



**Figure 44**

3. Install a new wear strip.

# Preventive Maintenance and Adjustment

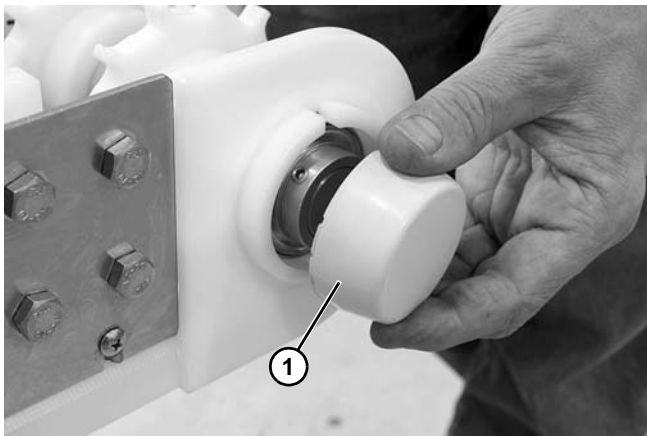
## Drive Sprocket and Spindle Replacement

### **⚠ WARNING**



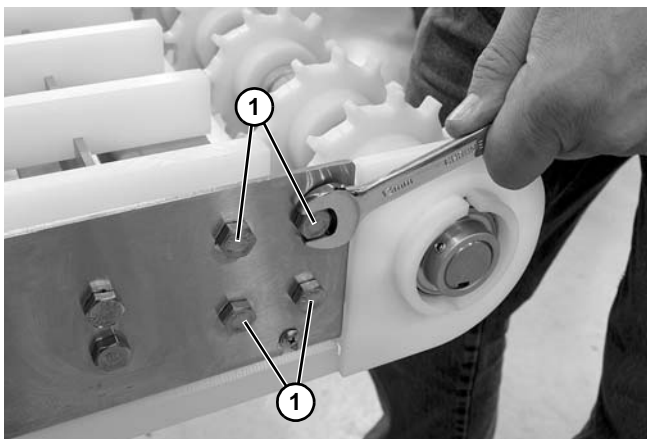
**SEVERE HAZARD!**  
**LOCK OUT POWER** before removing guards or performing maintenance. Exposed moving parts can cause serious injury.

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 12.
3. Remove bearing cover (**Figure 45, item 1**).



**Figure 45**

4. Remove the four headplate bolts (**Figure 46, item 1**) on both sides of the conveyor.

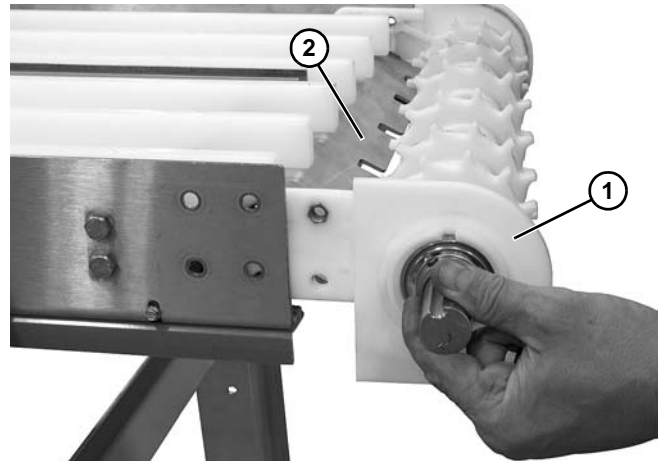


**Figure 46**

### **⚠ CAUTION**

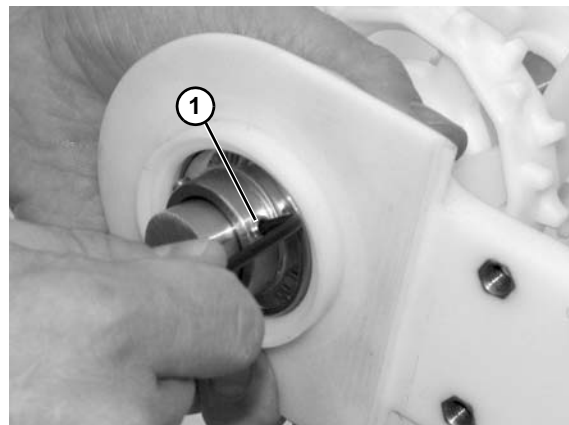
Support bracket (**Figure 47, item 2**) will not be attached and could fall.

5. Remove drive tail assembly (**Figure 47, item 1**).



**Figure 47**

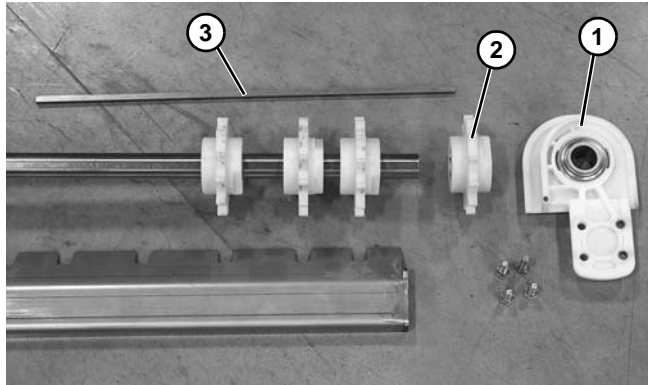
6. Loosen set screws (**Figure 48, item 1**).



**Figure 48**

# Preventive Maintenance and Adjustment


- Slide the headplate with bearing (**Figure 49, item 1**) off the shaft. Replace bearing if worn. Refer to “Bearing Replacement” on page 25.



**Figure 49**

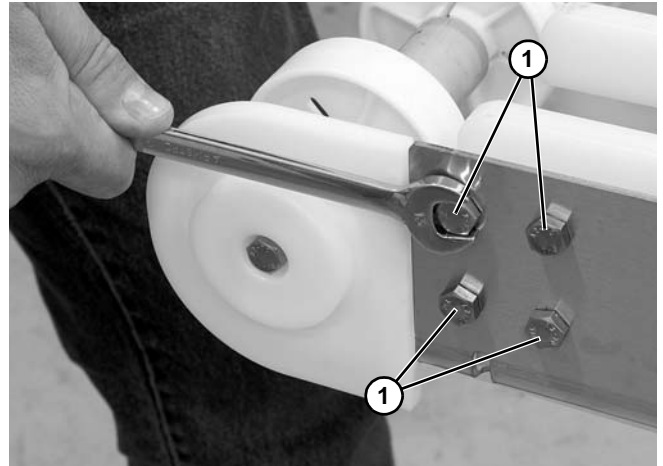
- Slide off the drive sprocket (**Figure 49, item 2**).
- Repeat as needed.
- Remove the shaft key (**Figure 49, item 3**).

## Idler Puck and Spindle Replacement

<b>⚠ WARNING</b>

<b>SEVERE HAZARD!</b> <b>LOCK OUT POWER</b> 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>

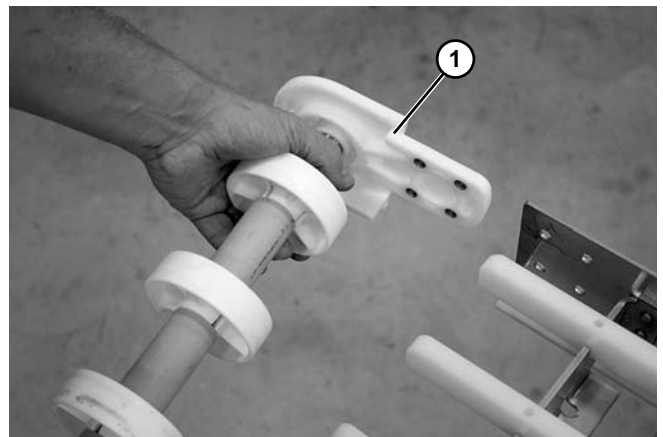
- Open conveyor belt. Refer to “Conveyor Belt Replacement” on page 12.

- Remove the four headplate bolts (**Figure 50, item 1**) on both sides of the conveyor.



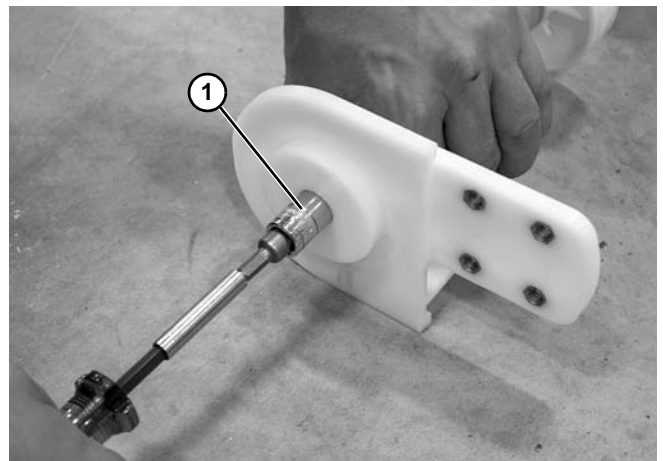
**Figure 50**

- Remove idler tail assembly (**Figure 51, item 1**).



**Figure 51**

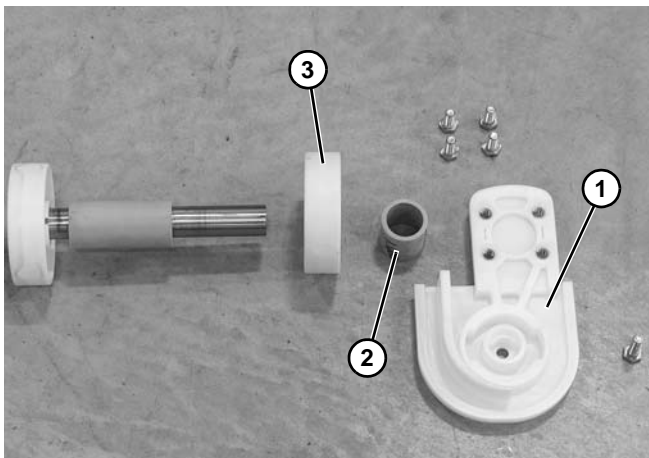
- Using a 13 mm socket (**Figure 52, item 1**), remove the headplate bolt from the shaft.



**Figure 52**

# Preventive Maintenance and Adjustment

5. Slide the headplate (Figure 53, item 1) off the shaft.



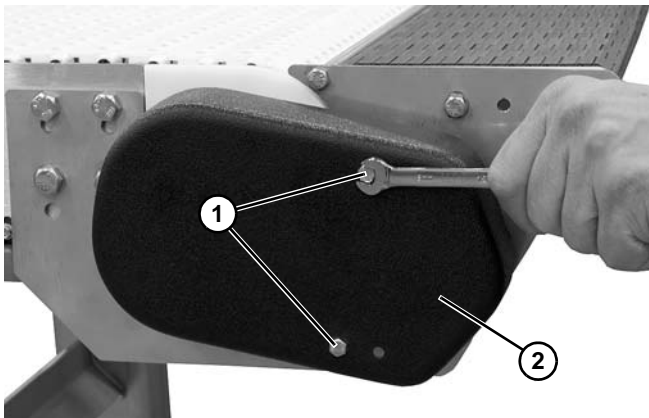
**Figure 53**

6. Slide off the round puck spacer (Figure 53, item 2).
7. Slide off the puck and replace (Figure 53, item 3).
8. Repeat as needed.

## Power Transfers

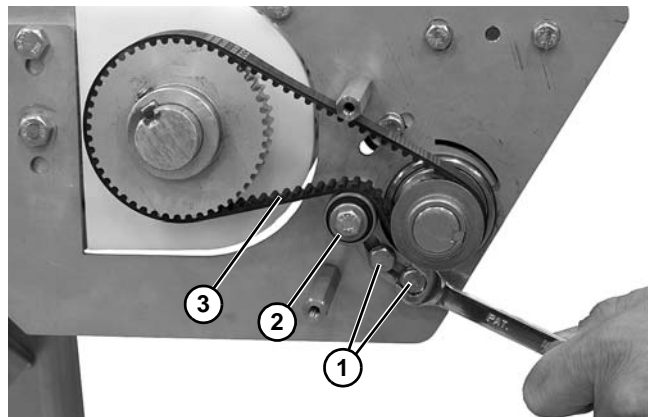
### Removal

1. Remove two hex head screws (Figure 54, item 1) and cover (Figure 54, item 2).



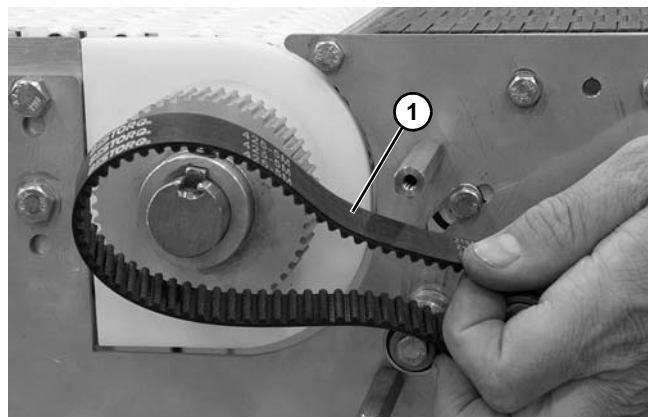
**Figure 54**

2. Loosen two hex head screws (Figure 55, item 1) holding tensioning bearing (Figure 55, item 2) against timing belt (Figure 55, item 3).



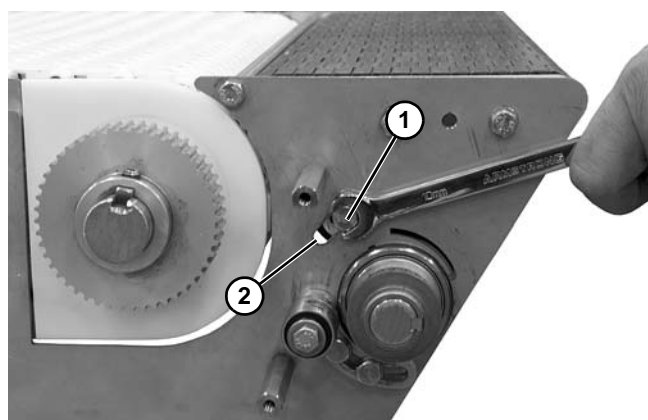
**Figure 55**

3. Remove timing belt (Figure 56, item 1).



**Figure 56**

4. Loosen hex head screw (Figure 57, item 1) on both sides of the power transfer.

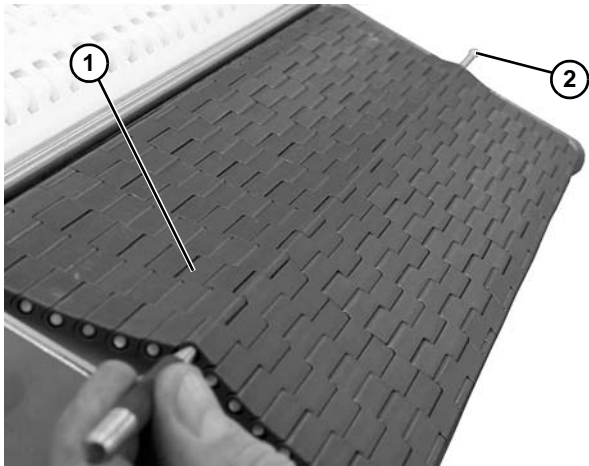


**Figure 57**

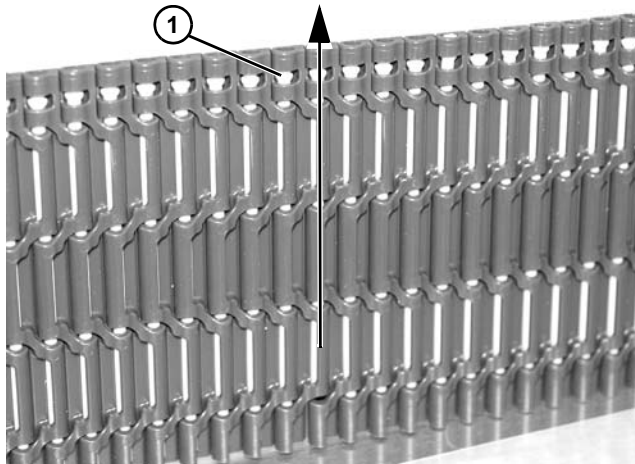
5. Slide idler assembly within slot (Figure 57, item 2) to remove tension on belt.

# Preventive Maintenance and Adjustment

6. Lift slightly on belt (**Figure 58, item 1**) and push pin (**Figure 58, item 2**) out of belt.



**Figure 58**



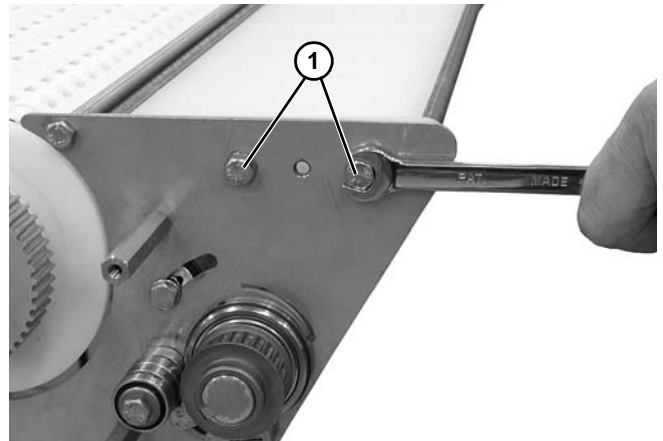
**Figure 59**

## NOTE

Note that head of pin (**Figure 59, item 1**) should be removed in direction shown.

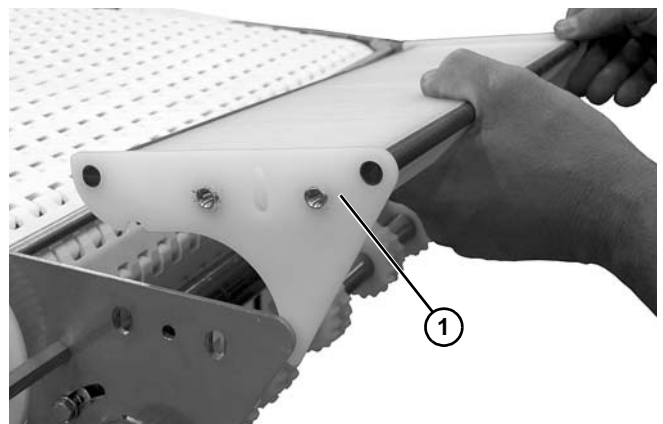
7. Remove belt.

8. Remove two hex head screws (**Figure 60, item 1**) on both sides of the power transfer.



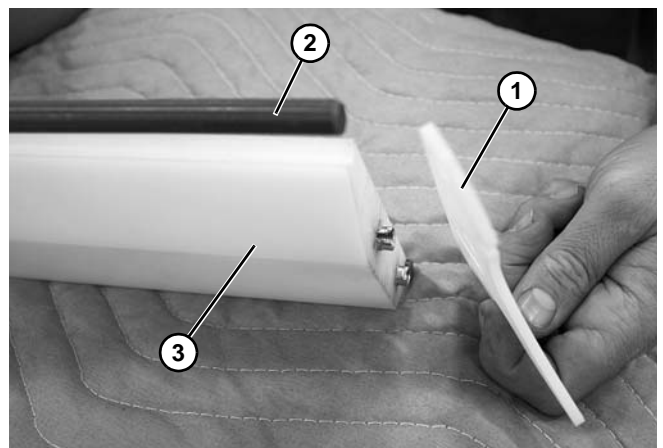
**Figure 60**

9. Remove the wear bar assembly (**Figure 61, item 1**) from the power transfer.



**Figure 61**

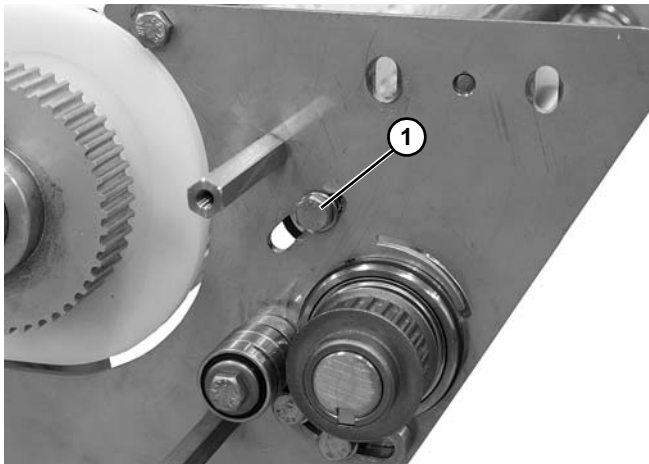
10. Disassemble side guide plates (**Figure 62, item 1**), wear rods (**Figure 62, item 2**), and wear bar (**Figure 62, item 3**). Replace worn parts.



**Figure 62**

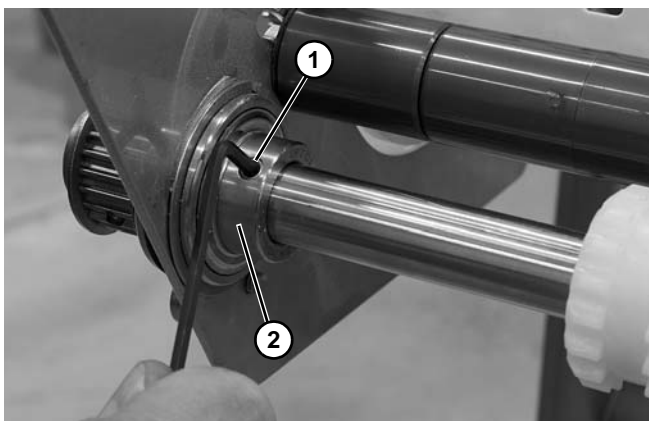
# Preventive Maintenance and Adjustment

11. Remove hex head screw (**Figure 63, item 1**) on both sides of the power transfer and remove idler assembly.



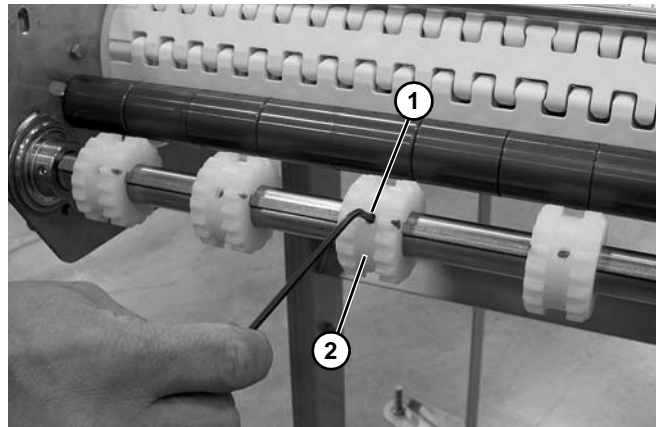
**Figure 63**

12. Replace the idler assembly and install hex head screws to secure.
13. Loosen two set screws (**Figure 64, item 1**) on bearing (**Figure 64, item 2**) on both sides of the power transfer.



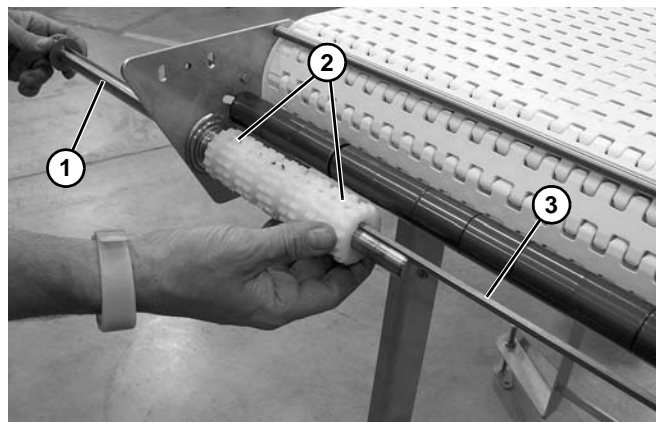
**Figure 64**

14. Loosen set screw (**Figure 65, item 1**) on drive sprocket (**Figure 65, item 2**).



**Figure 65**

15. While removing drive shaft (**Figure 66, item 1**), slide drive sprockets (**Figure 66, item 2**) and shaft key (**Figure 66, item 3**) from shaft.

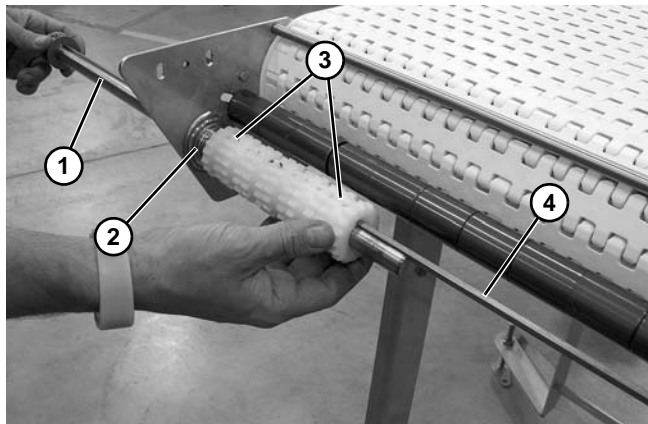


**Figure 66**

# Preventive Maintenance and Adjustment

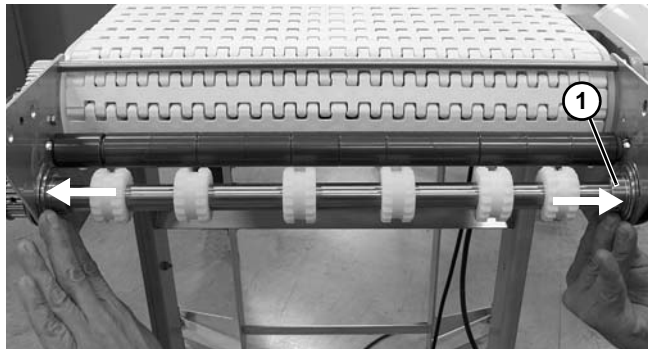
## Installation

1. Insert drive shaft (**Figure 67, item 1**) through bearing (**Figure 67, item 2**).



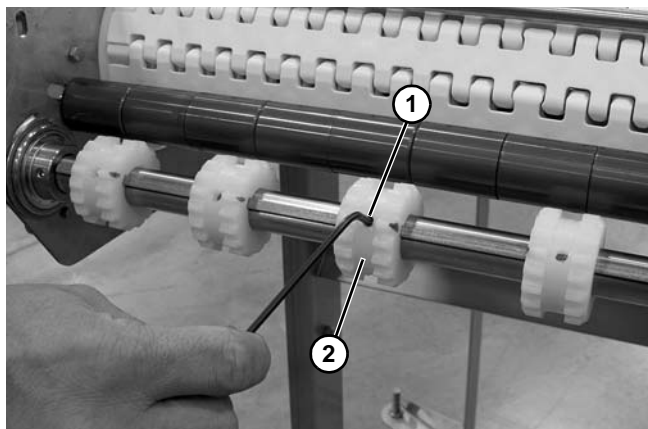
**Figure 67**

2. Slide drive sprockets (**Figure 67, item 3**) and shaft key (**Figure 67, item 4**) onto shaft while pushing shaft through bearing.
3. Insert drive shaft through opposite bearing (**Figure 68, item 1**) and press outward on bearings as shown.



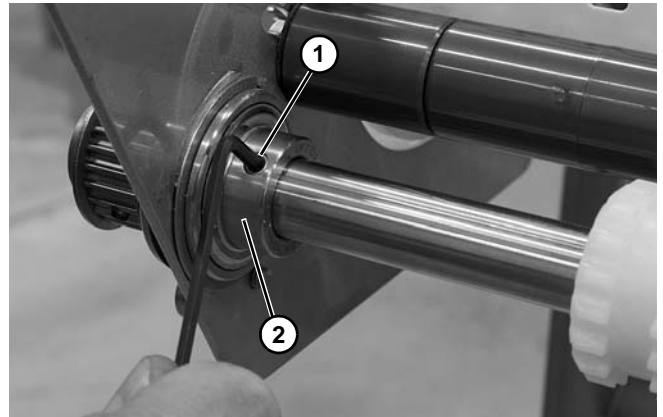
**Figure 68**

4. Tighten set screw (**Figure 69, item 1**) on drive sprocket (**Figure 69, item 2**).



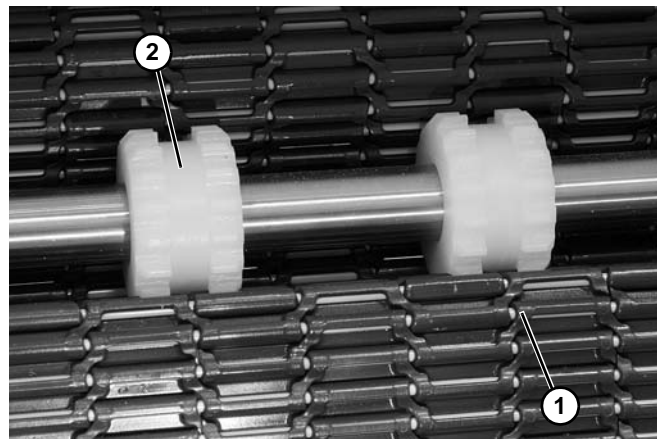
**Figure 69**

5. Tighten two set screws (**Figure 70, item 1**) on bearing (**Figure 70, item 2**) on both sides of the power transfer.



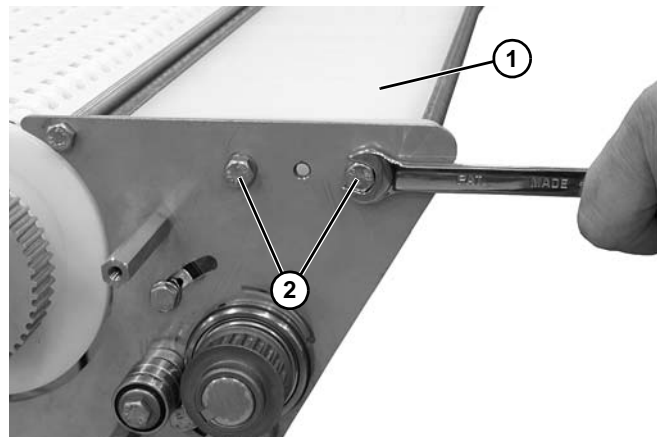
**Figure 70**

6. Raise belt (**Figure 71, item 1**) into position. Move drive sprockets (**Figure 71, item 2**) so that the teeth line up with the belt, as shown.



**Figure 71**

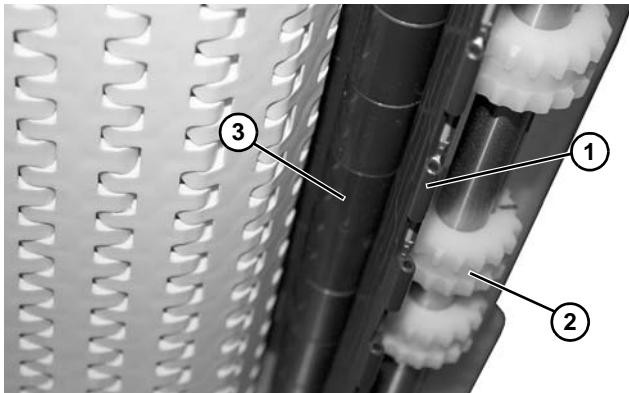
7. Install wear bar assembly (**Figure 72, item 1**) with two hex head screws (**Figure 72, item 2**) on both sides of the power transfer.



**Figure 72**

# Preventive Maintenance and Adjustment

8. Guide belt (**Figure 73, item 1**) through idler assembly. Route the belt under the sprocket (**Figure 73, item 2**) and over wear tube (**Figure 73, item 3**).



**Figure 73**

9. Bring ends of belt together and install pin (**Figure 74, item 1**).

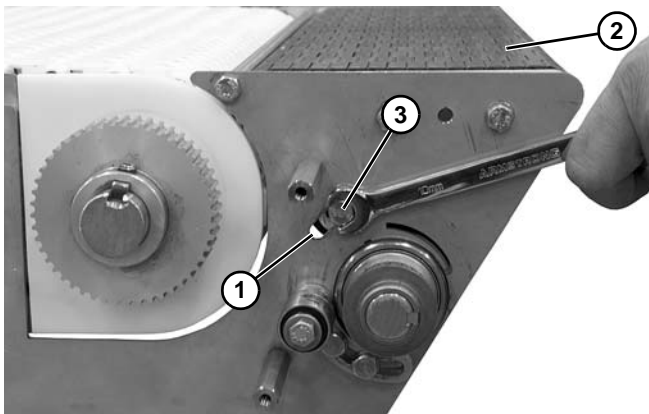


**Figure 74**

10. Slide idler assembly within slot (**Figure 75, item 1**) to remove excess slack from belt (**Figure 75, item 2**). Tighten hex head screws (**Figure 75, item 3**).

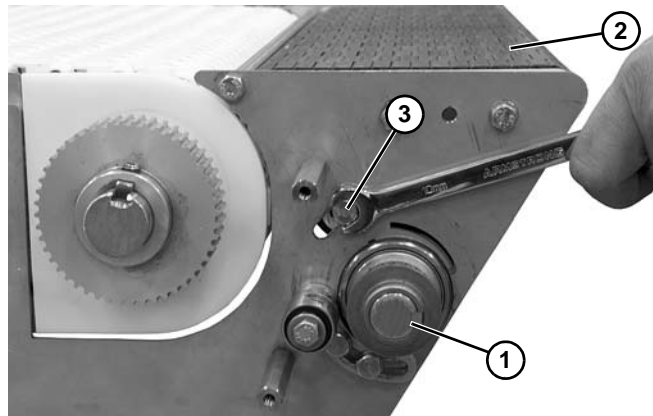
## **CAUTION**

**DO NOT** overtighten belt or excessive wear will occur.



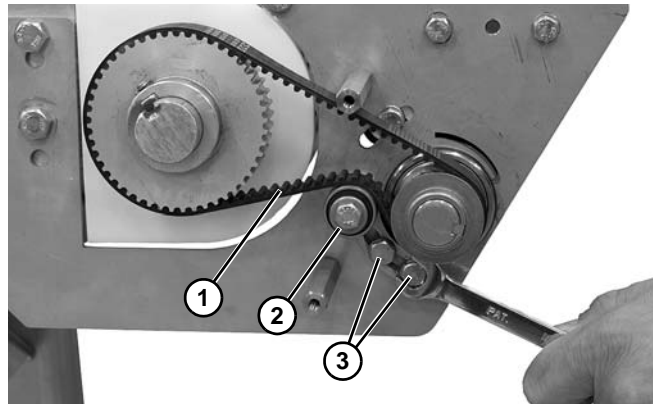
**Figure 75**

11. Rotate drive shaft (**Figure 76, item 1**) to verify tightness of belt (**Figure 76, item 2**). Belt should turn freely. Loosen hex head screw (**Figure 76, item 3**) on both sides and adjust, if necessary.



**Figure 76**

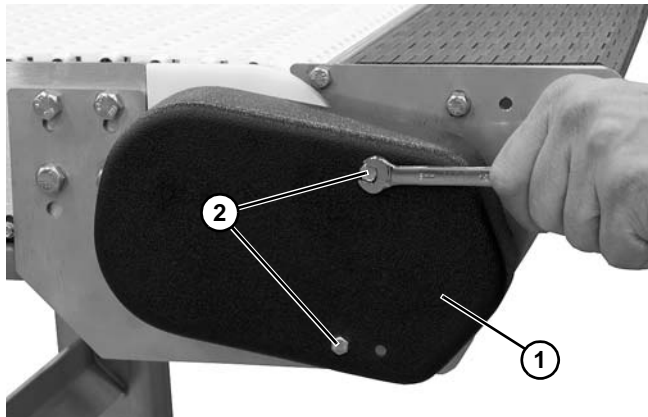
12. Route and install belt (**Figure 77, item 1**) as shown. Press up on tensioner (**Figure 77, item 2**) and tighten two hex head screws (**Figure 77, item 3**).



**Figure 77**

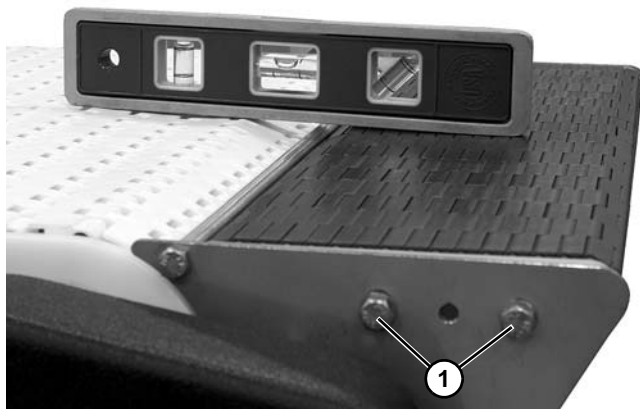
# Preventive Maintenance and Adjustment

13. Install cover (**Figure 78, item 1**) with two hex head screws (**Figure 78, item 2**).



**Figure 78**

14. Adjust height as needed by loosening two hex head screws (**Figure 79, item 1**) on both sides of the power transfer. Tighten screws.



**Figure 79**

## Bearing Replacement

### **⚠ WARNING**



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

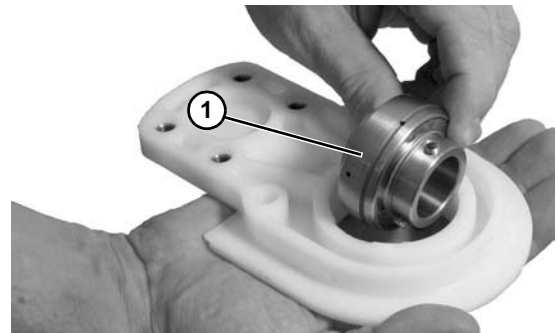
## Drive Bearing Removal and Replacement

### **⚠ WARNING**



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

1. Refer to “Drive Sprocket and Spindle Replacement” on page 18. Follow steps 1 through 7.
2. Twist the bearing out (**Figure 80, item 1**).



**Figure 80**


3. Replace the bearing.

---

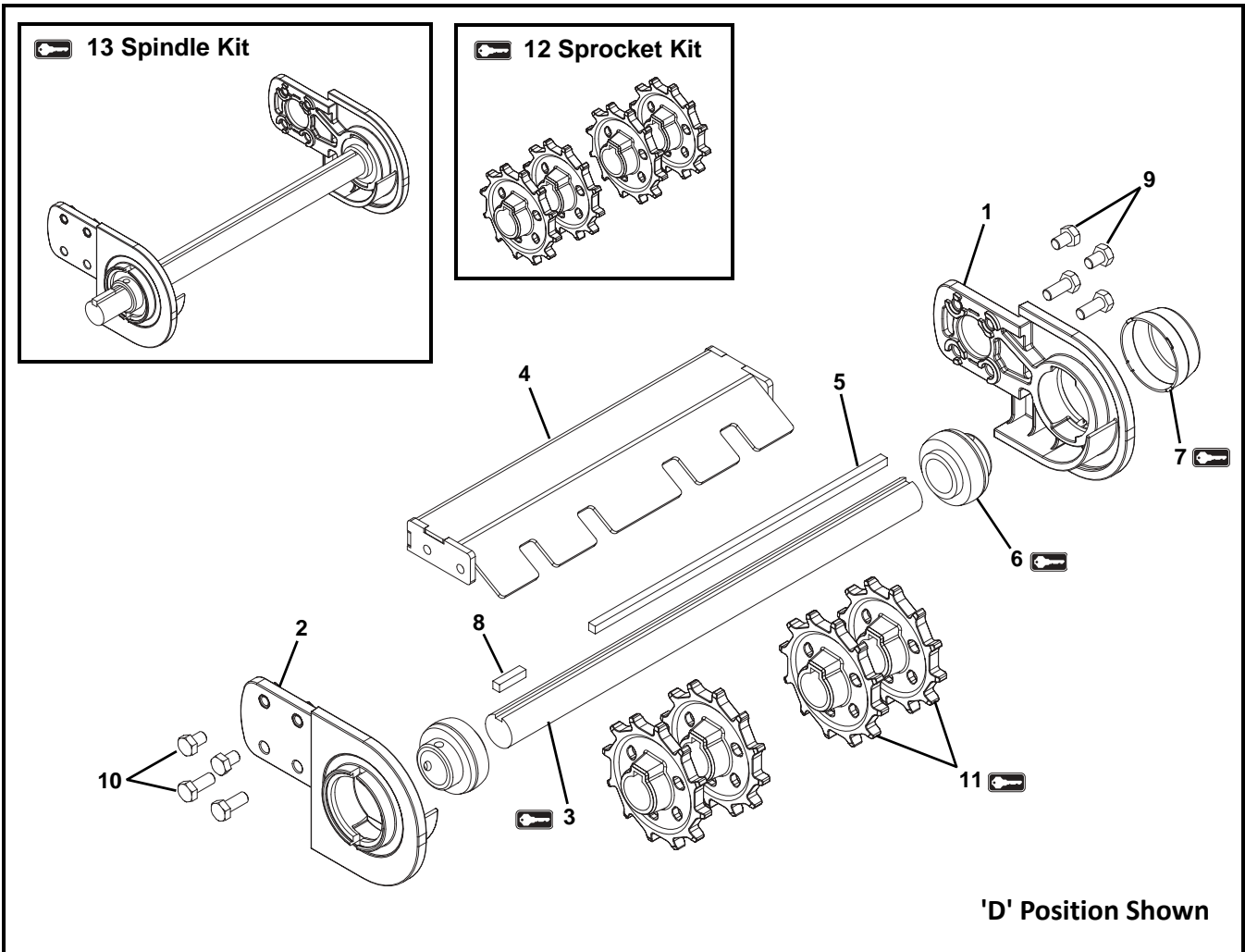
# Notes

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

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

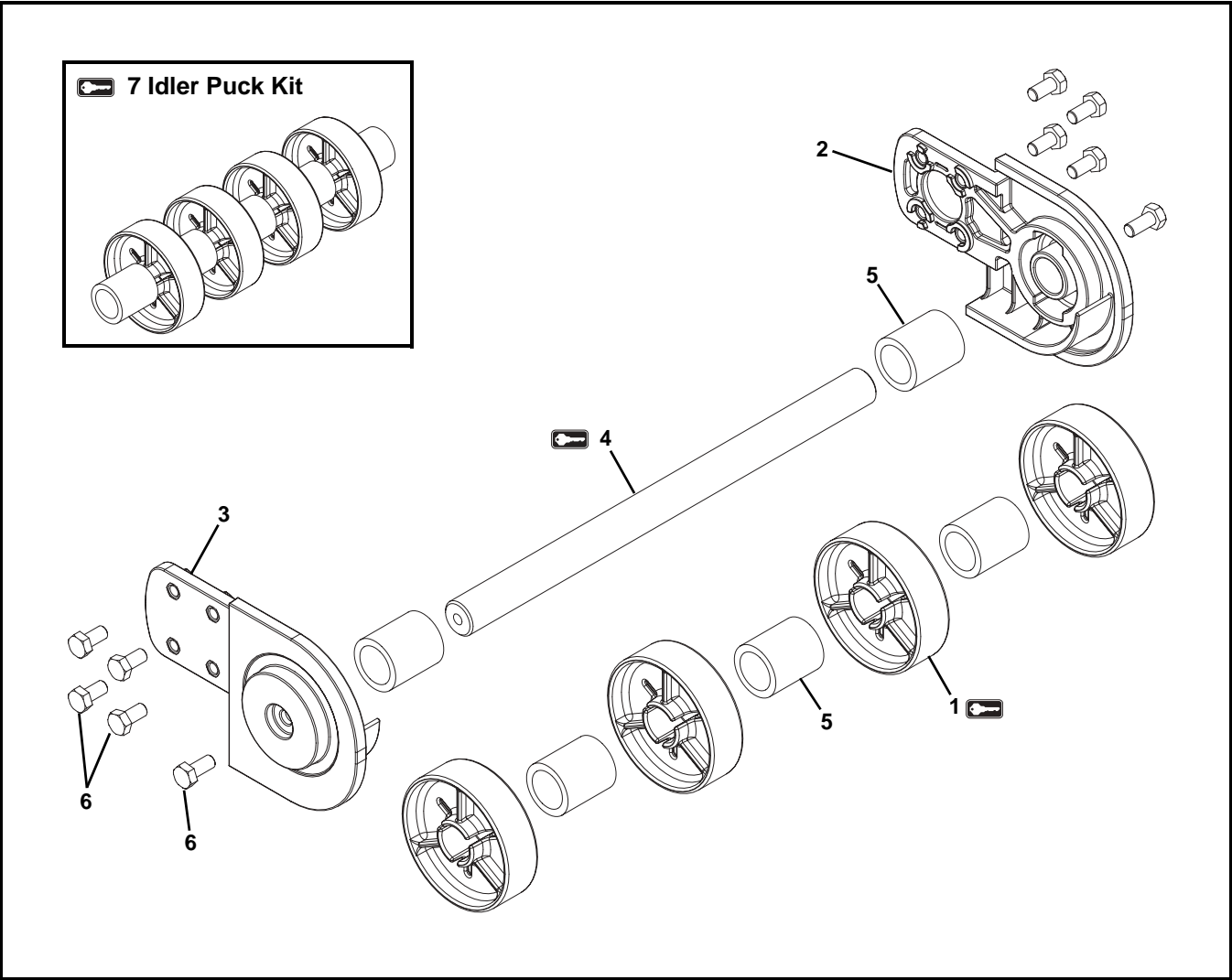


Item	Part Number	Description
1	516809	Headplate, Left Hand
2	516811	Headplate, Right Hand
3	516815-K0- <u>WW</u>	Spindle
	516815-KK- <u>WW</u>	Dual Shaft Spindle
4	516839- <u>WW</u>	Support Bracket
5	532121- <u>LLLLL</u>	Square Key
6	802-161	Bearing
	807-1454	Bearing Cap
8	912-108SS	Square Key, .25" x 1.00"
9	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
10	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm

Item	Part Number	Description
11	FXSPT-12T	Sprocket
	520361- <u>WW</u>	Sprocket Kit (Includes item 11)
	520362-K0- <u>WW</u>	Spindle Kit (Includes items 1, 2, 3, 5, 6 and 8)
	520362-KK- <u>WW</u>	Dual Shaft Spindle Kit (Includes items 1, 2, 3, 5, 6 and 8)
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
<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		

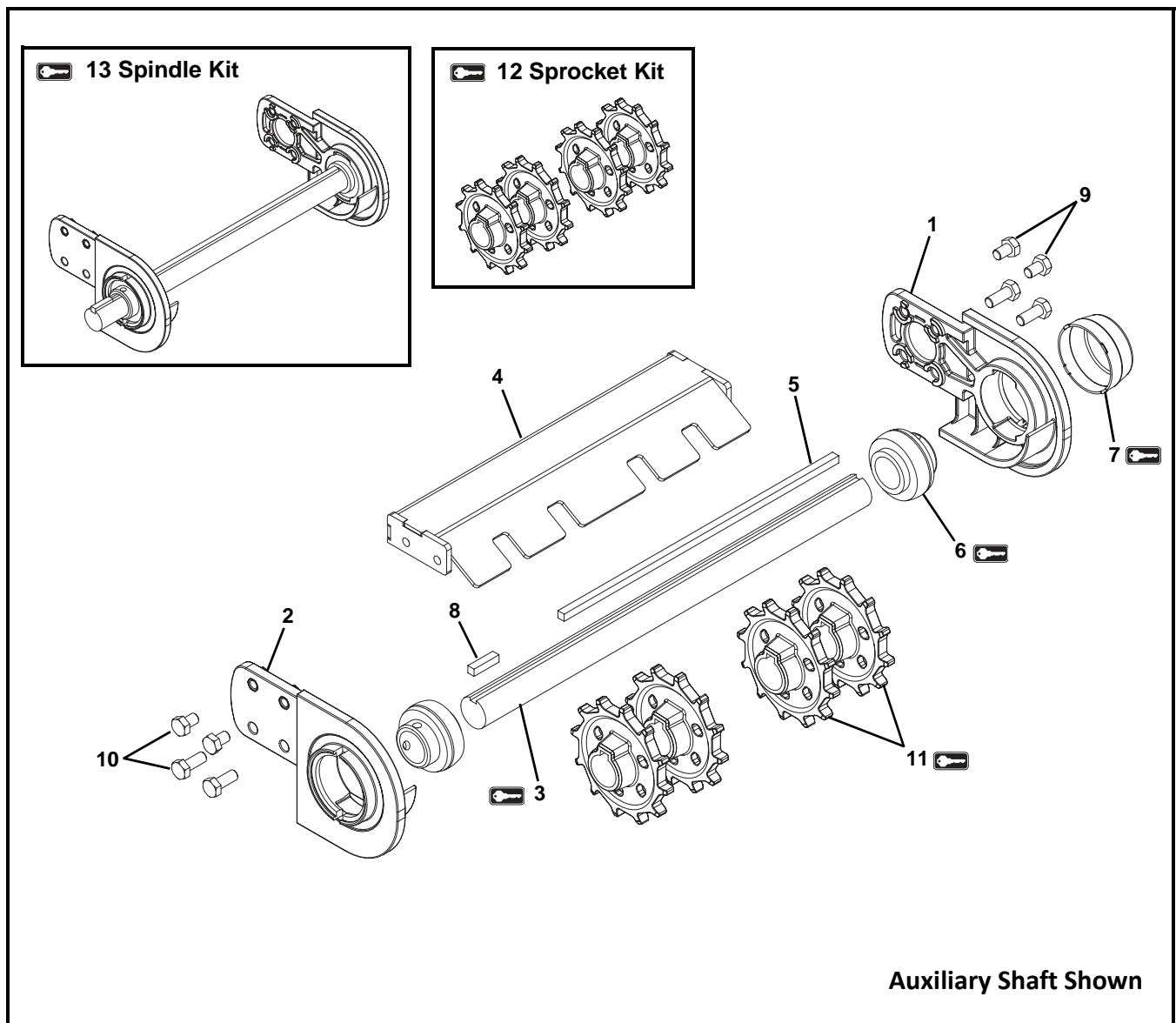
# Service Parts

## Idler Tail



Item	Part Number	Description
1	506296	Idler Puck
2	516805	Headplate, Left Hand
3	516807	Headplate, Right Hand
4	516823-00- <u>WWW</u>	Spindle
5	532127- <u>LLLLL</u>	Spacer
6	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
7	520375- <u>WWW</u>	Idler Puck Kit (Includes items 1 and 5)
<u>WWW</u> = Conveyor width reference in inches 06, 12, 18, 24		
<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



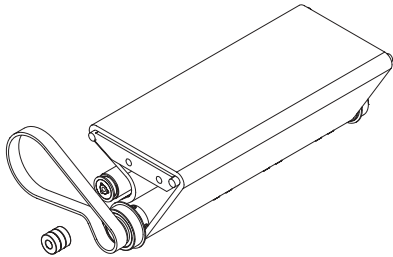
Item	Part Number	Description
1	516809	Headplate, Left Hand
2	516811	Headplate, Right Hand
3	516815-K0- <u>WW</u>	Spindle
4	516839- <u>WW</u>	Support Bracket
5	532121- <u>LLLLL</u>	Square Key
6	802-161	Bearing
7	807-1454	Bearing Cap
8	912-108SS	Square Key, .25" x 1.00"
9	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
10	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
11	FXSPT-12T	Sprocket

Item	Part Number	Description
12	520361- <u>WW</u>	Sprocket Kit (Includes item 11)
13	520362-K0- <u>WW</u>	Spindle Kit (Includes items 1, 2, 3, 5, 6 and 8)
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
<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		

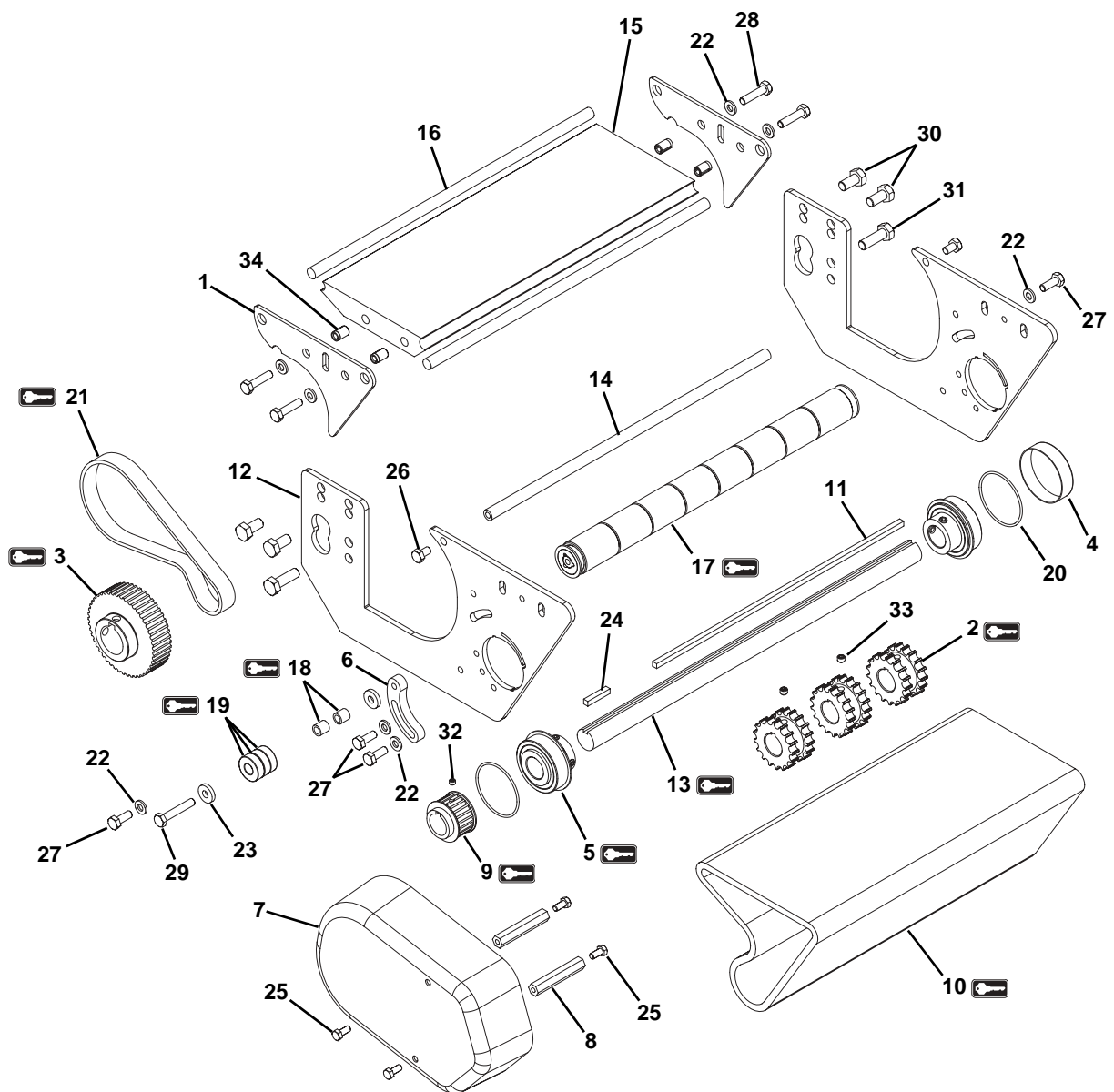
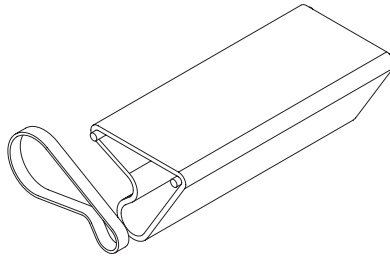
# Service Parts

## Power Transfer

 36 Power Transfer Kit



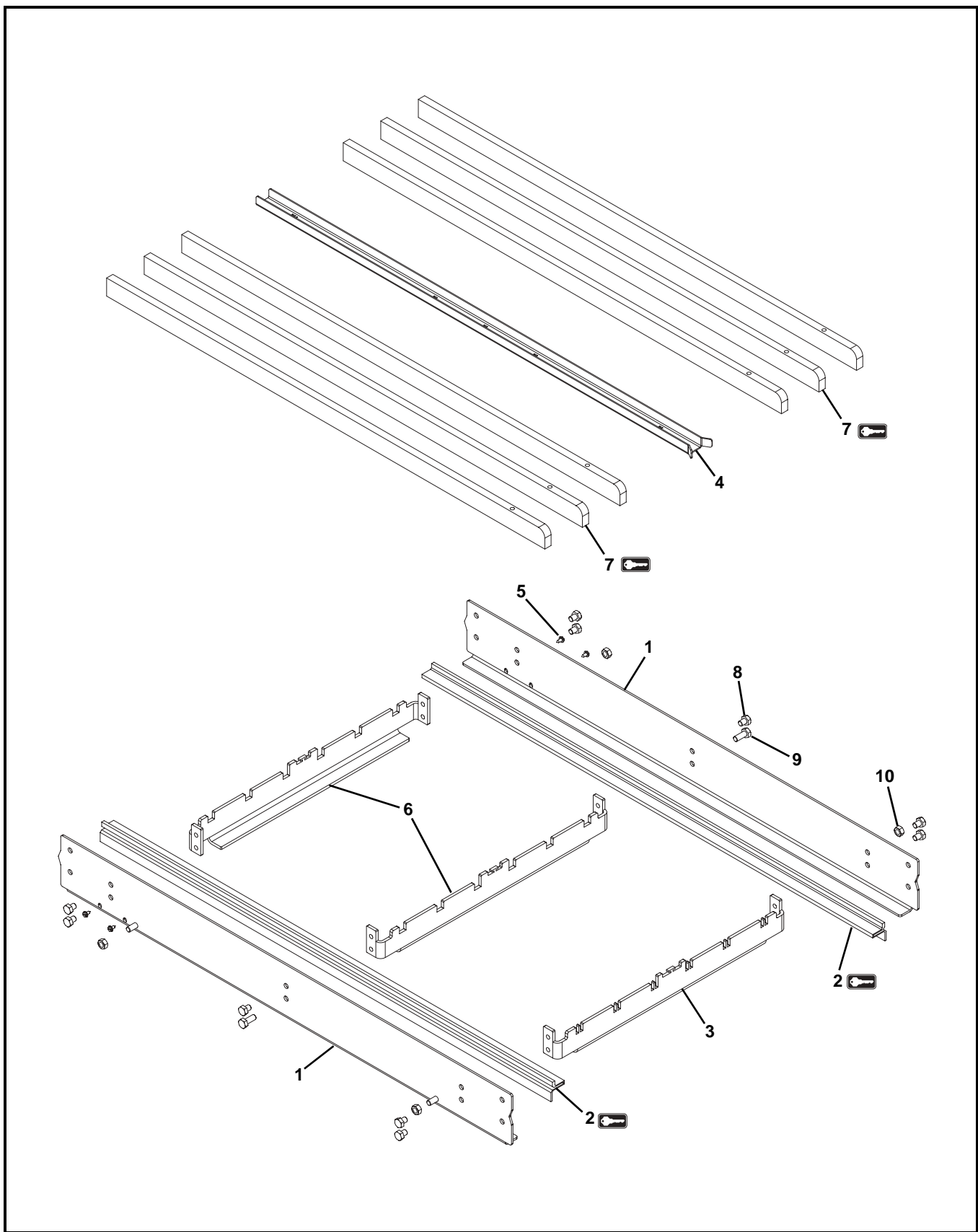
 35 Belt Kit





Item	Part Number	Description
1	203229	Plate
2	203765	Sprocket
3	509855	Pulley 48T
4	514644	Bearing Cover
5	514647	Bearing
6	516897	Tensioner
7	516981	Cover
8	516982	Spacer
9	518497	Pulley 22T
10	2P- <u>WW</u> /01	Power Transfer Belt
11	350789- <u>WW</u>	Square Key
12	516888D	Side Plate
13	516891- <u>WW</u>	Spindle
14	516896- <u>WW</u>	Pinch Guard
15	516901- <u>WW</u>	Support Bar
16	516979- <u>WW</u>	Bar
17	518498- <u>WW</u>	Idler Assembly
18	801-139	Nylon Bearing
19	802-123	Bearing
20	812-097	O-Ring
21	814-096	Belt
22	911-222	Washer
23	911-527	Washer
24	912-080SS	Square Key, .1875" x 1.00"
25	960510MSS	Hex Head Cap Screw, M5-0.80 x 10 mm
26	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
27	960616MSS	Hex Head Cap Screw, M6-1.00 x 16 mm
28	960625MSS	Hex Head Cap Screw, M6-1.00 x 25 mm
29	960635MSS	Hex Head Cap Screw, M6-1.00 x 35 mm
30	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
31	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
32	970504MSS	Set Cup Screw, M5-0.80 x 5 mm
33	970605M	Set Cup Screw, M6-1.00 x 5 mm
34	990621M	Nut
35	520381- <u>WW</u>	Belt Kit (Includes items 10, 16 and 21)
36	520382- <u>WW</u>	Power Transfer Kit (Includes items 2, 5, 10, 15, 16, 17, 19 and 21)
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

# Service Parts

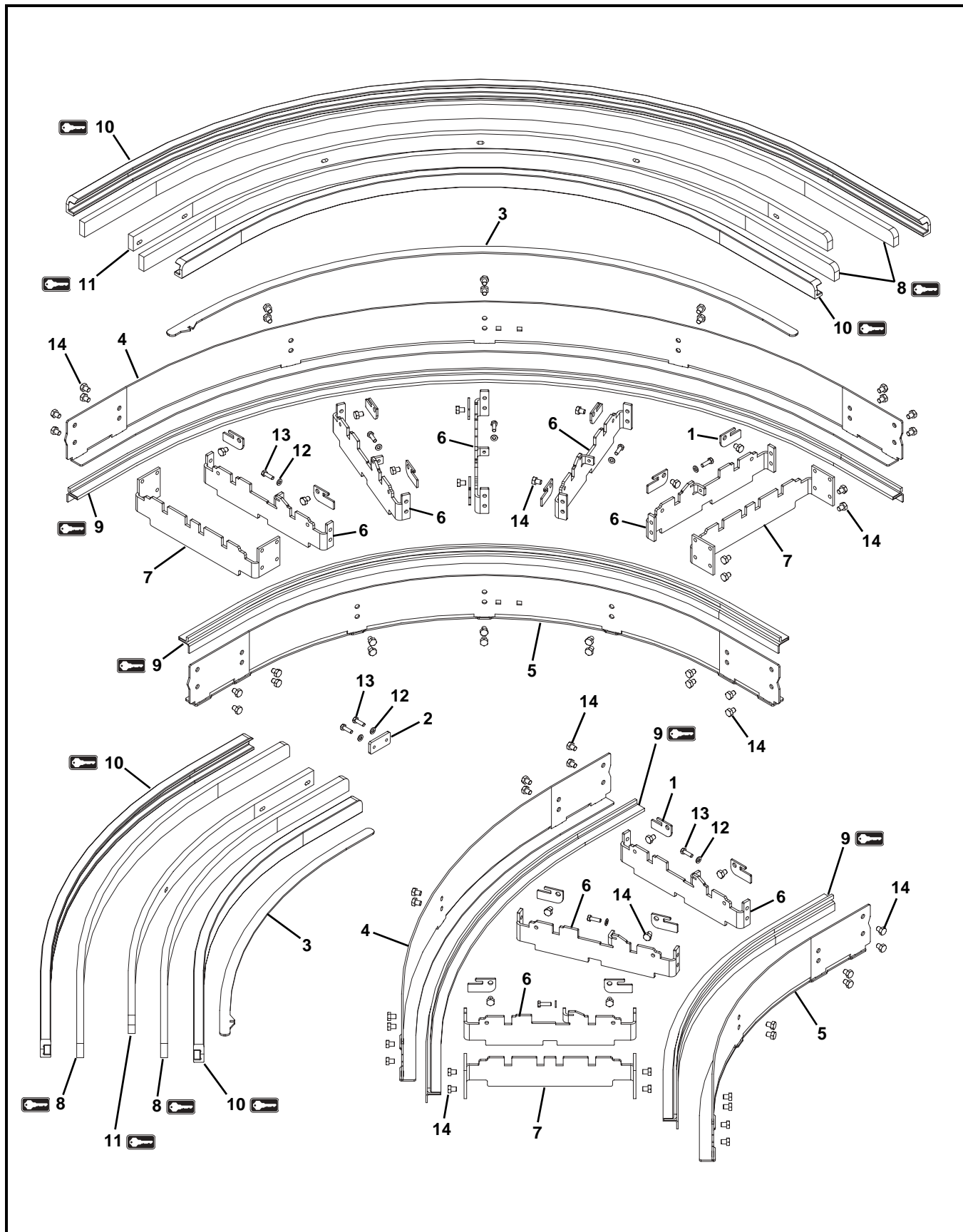
## Straight Frame



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2 	517579- <u>LLLLL</u>	Wear Strip
3	515586- <u>WW</u>	Crossmember
4	515597- <u>LLLLL</u>	Bearing Rail
5	807-3341	Self Tapping Hex Screw, 8-18 x .375"
6	515587- <u>WW</u>	Crossmember
7 	516802-S- <u>LLLLL</u>	Bed Rail
8	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
9	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
10	990801MSS	Hex Nut
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
<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

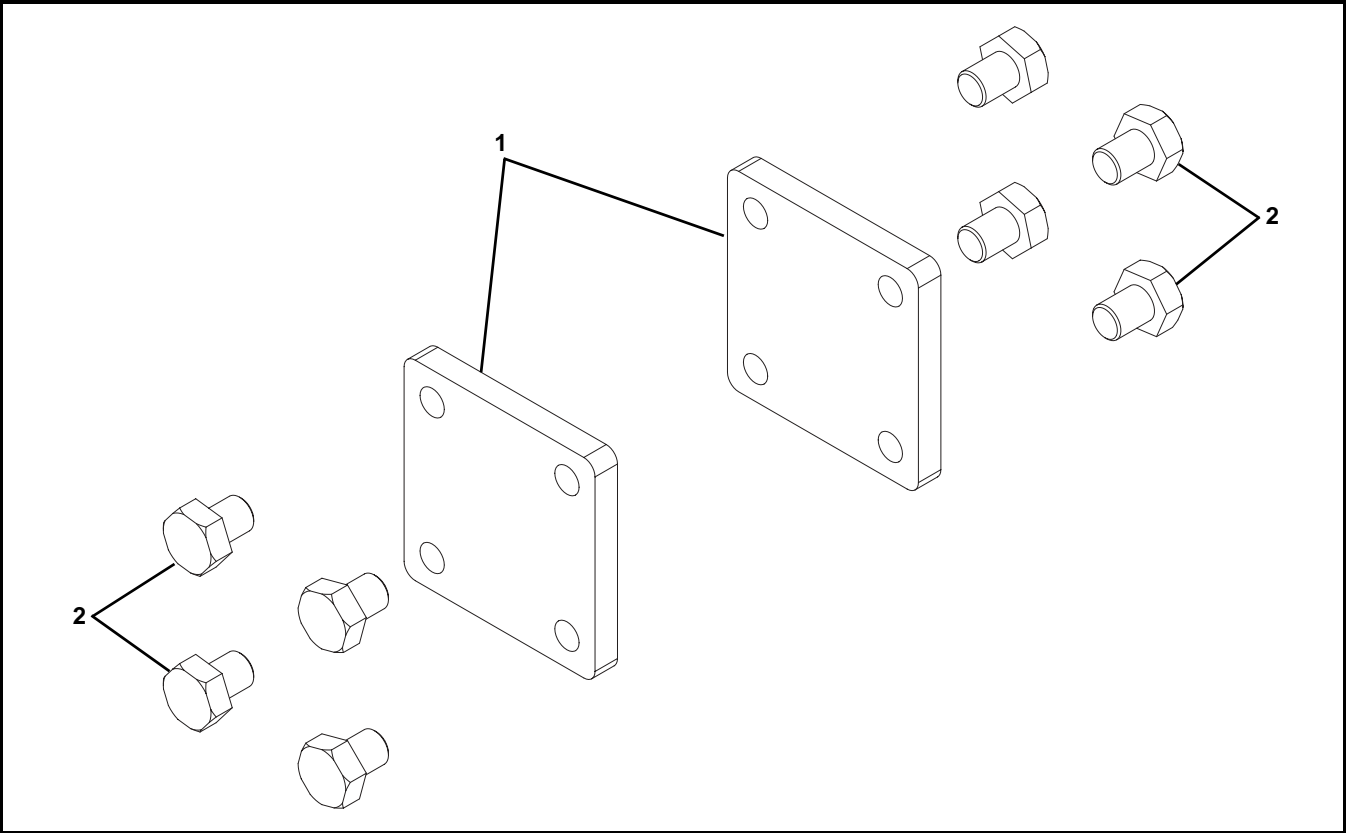
## Curve Frame



Item	Part Number	Description
1	515599	Retaining Clamp
2	520330	Connector Plate (for 135° and 180° Curves Only)
3	515503- <u>WW-AA</u>	Bearing Spine
4	515577- <u>WW-AA</u> -LH	Outer Frame for Left Hand Curve
	515577- <u>WW-AA</u> -RH	Outer Frame for Right Hand Curve
5	515578- <u>WW-AA</u> -LH	Inner Frame for Left Hand Curve
	515578- <u>WW-AA</u> -RH	Inner Frame for Right Hand Curve
6	515589- <u>WW</u> -LH	Crossmember for Left Hand Curve
	515589- <u>WW</u> -RH	Crossmember for Left Hand Curve
7	515590- <u>WW</u>	Crossmember
8	516802-C- <u>LLLLL</u>	Bed Rail
9	517579- <u>LLLLL</u>	Wear Strip
10	518431- <u>LLLLL</u>	Wear Rail
11	520342- <u>WW-AA</u>	Bearing Guide (for 135° and 180° Curves Only)
12	911-222	Washer
13	960620MSS	Hex Head Cap Screw, M6-1.00 x 20 mm
14	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
<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

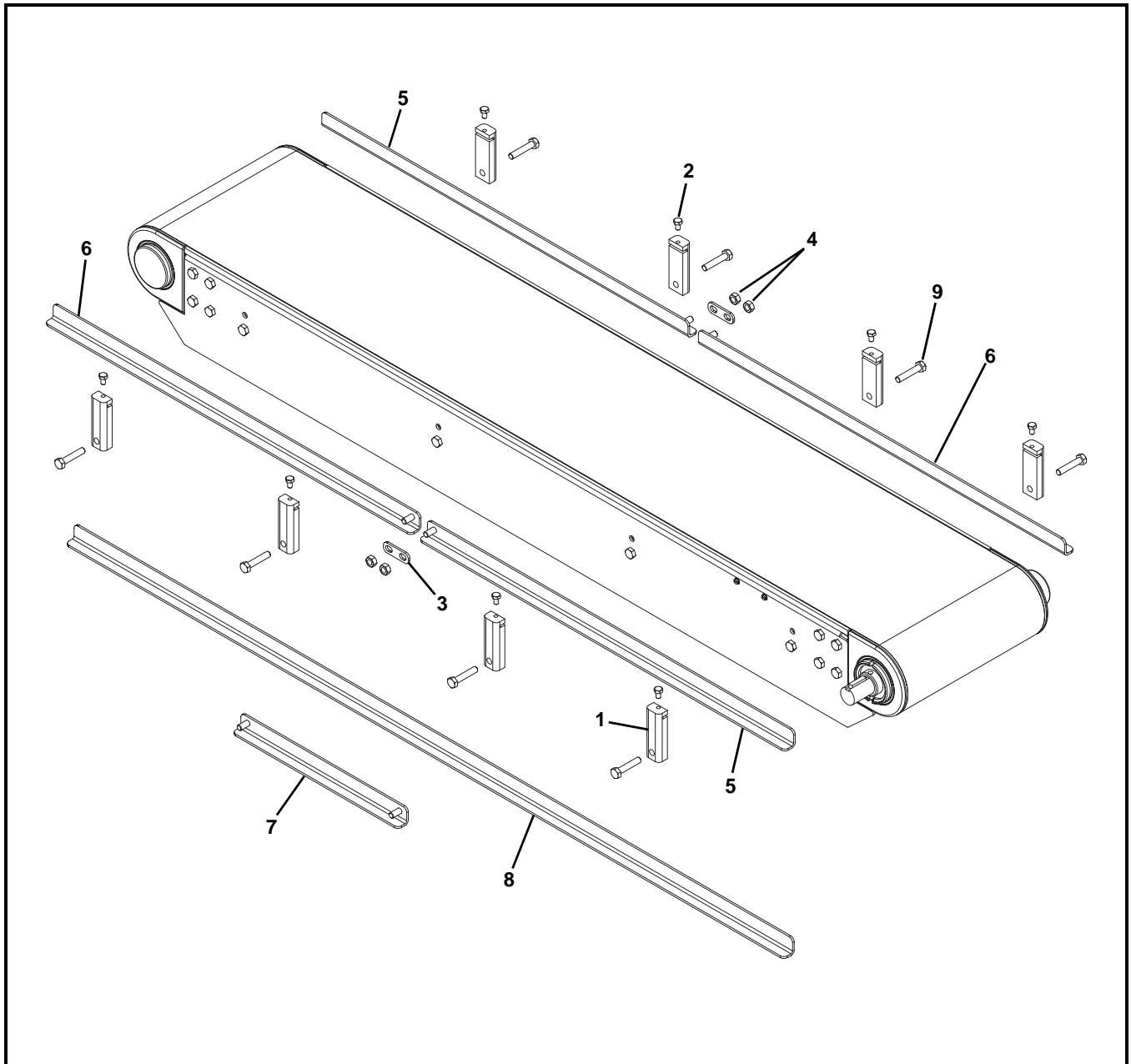
## Connecting Assembly



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

## 25 mm High Sides for Straight Sections

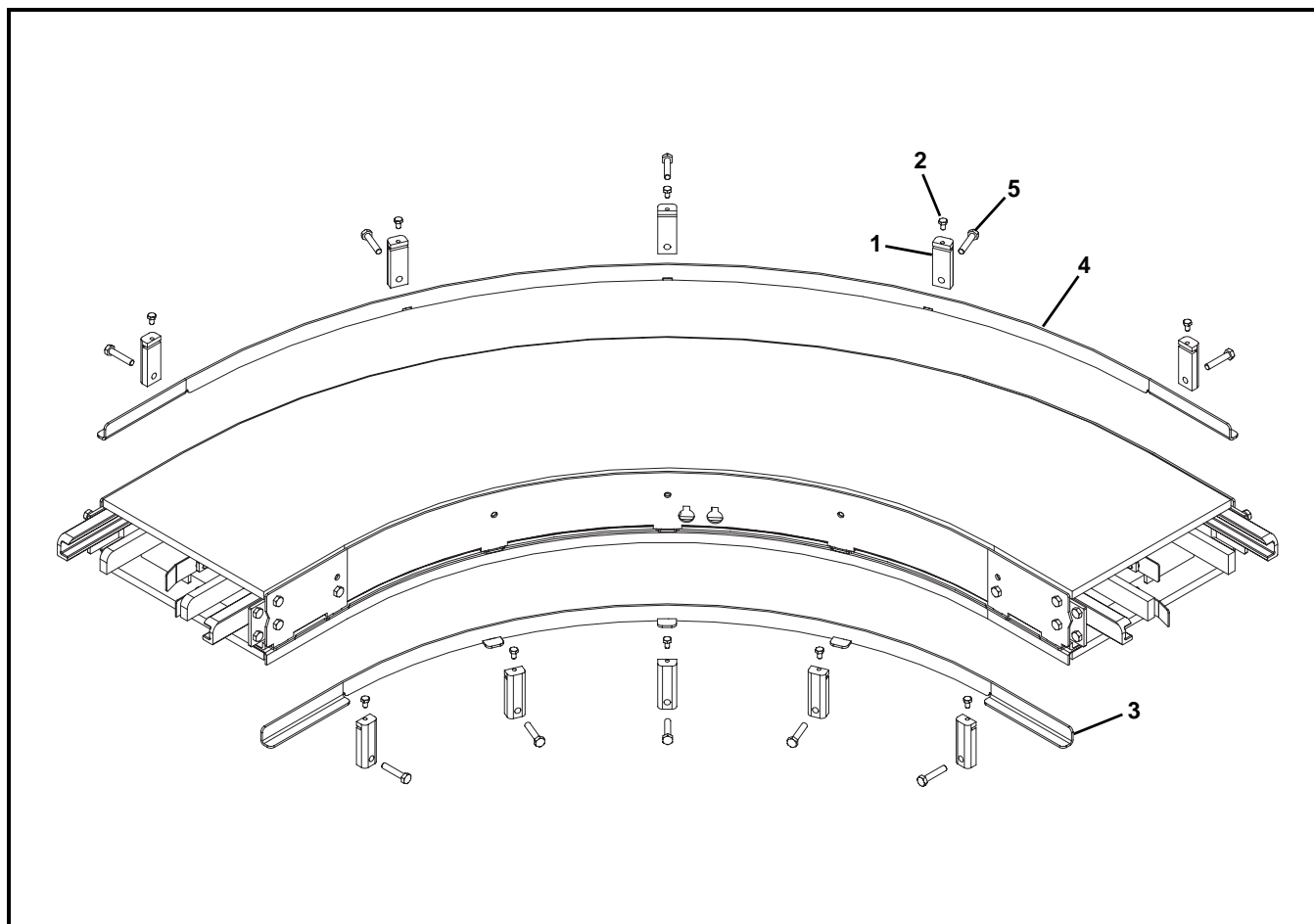


Item	Part Number	Description
1	516999-02	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-05- <u>LLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-05- <u>LLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-05- <u>LLLL</u>	Guiding, Middle (for Multiple Guide Sections Only)
8	516997-01- <u>LLLL</u>	Guiding (for One Piece Guiding)

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

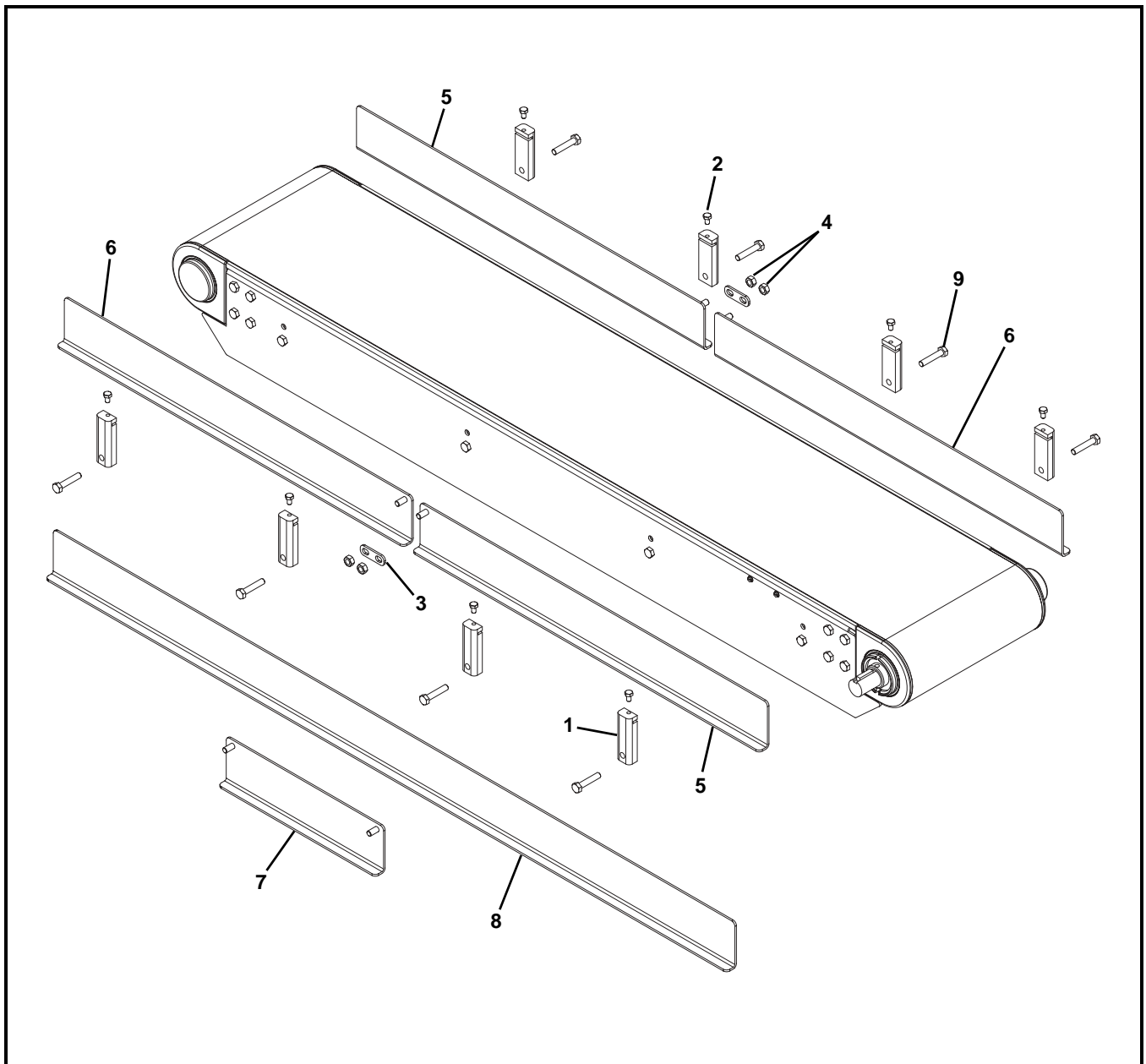
# Service Parts

## 25 mm High Sides for Curve Sections



Item	Part Number	Description
1	516999-02	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516908- <u>WW</u> -01- <u>AA</u>	Guiding for Inside Curve Section
4	516909- <u>WW</u> -01- <u>AA</u>	Guiding for Outside Curve Section
5	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

## 75 mm High Sides for Straight Sections

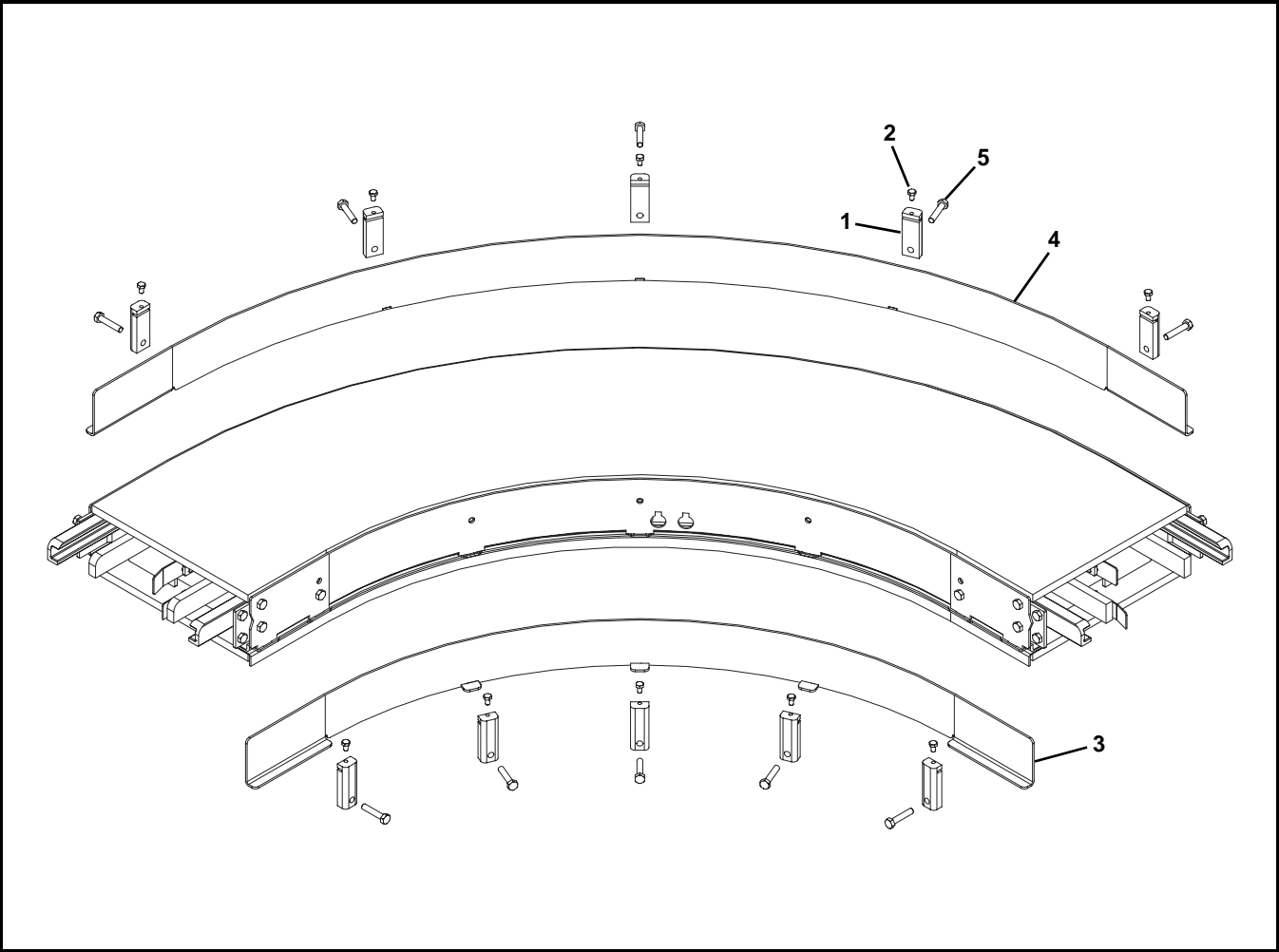


Item	Part Number	Description
1	516999-02	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-04- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-04- <u>LLLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-04- <u>LLLLL</u>	Guiding, Middle (for Multiple Guide Sections Only)
8	516997-03- <u>LLLLL</u>	Guiding (for One Piece Guiding)

Item	Part Number	Description
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<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		

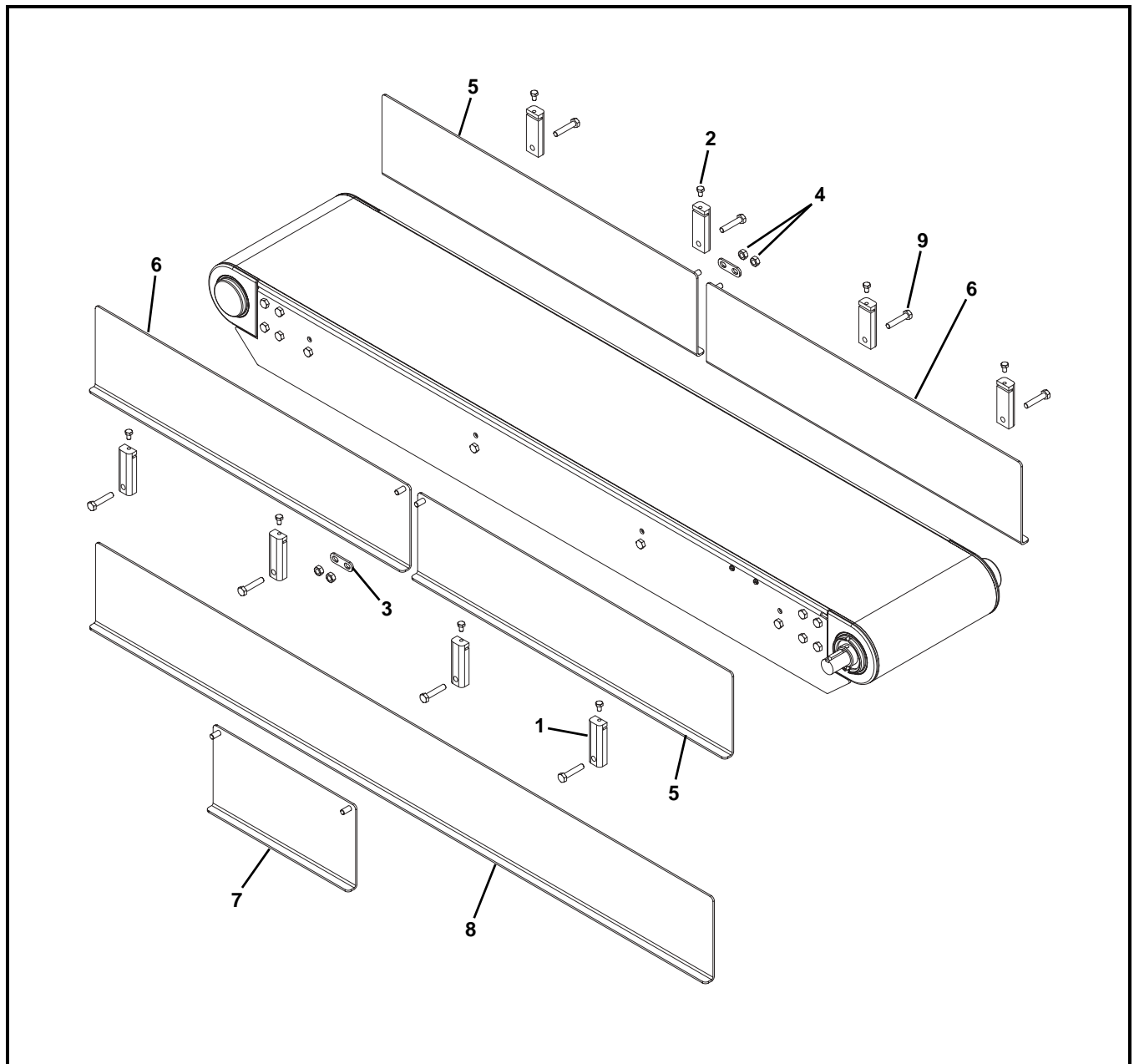
# Service Parts

## 75 mm High Sides for Curve Sections



Item	Part Number	Description
1	516999-02	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516908- <u>WW</u> -03- <u>AA</u>	Guiding for Inside Curve Section
4	516909- <u>WW</u> -03- <u>AA</u>	Guiding for Outside Curve Section
5	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
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 for Straight Sections

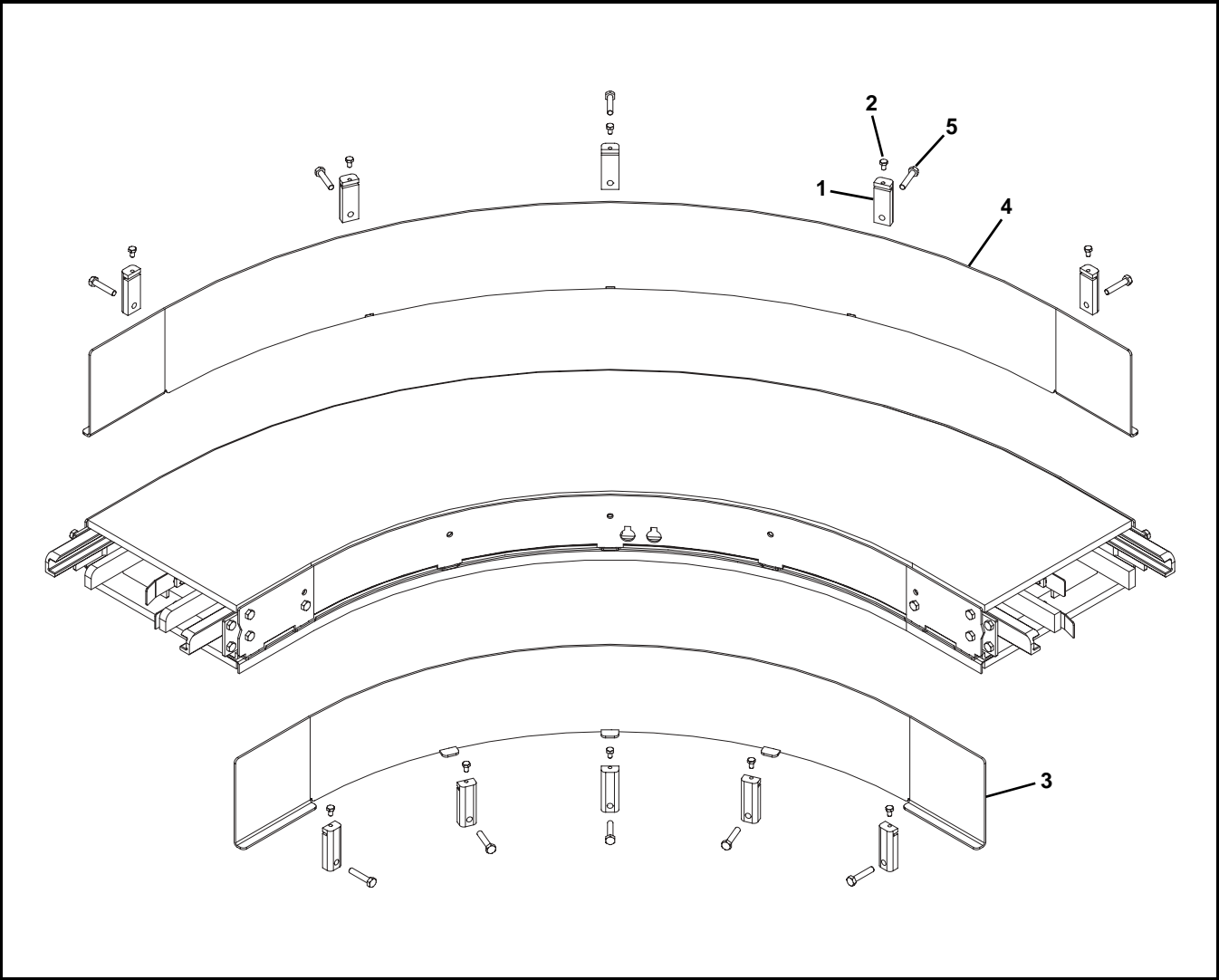


Item	Part Number	Description
1	516999-02	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-06- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-06- <u>LLLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-06- <u>LLLLL</u>	Guiding, Middle (for Multiple Guide Sections Only)
8	516997-06- <u>LLLLL</u>	Guiding (for One Piece Guiding)

Item	Part Number	Description
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<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		

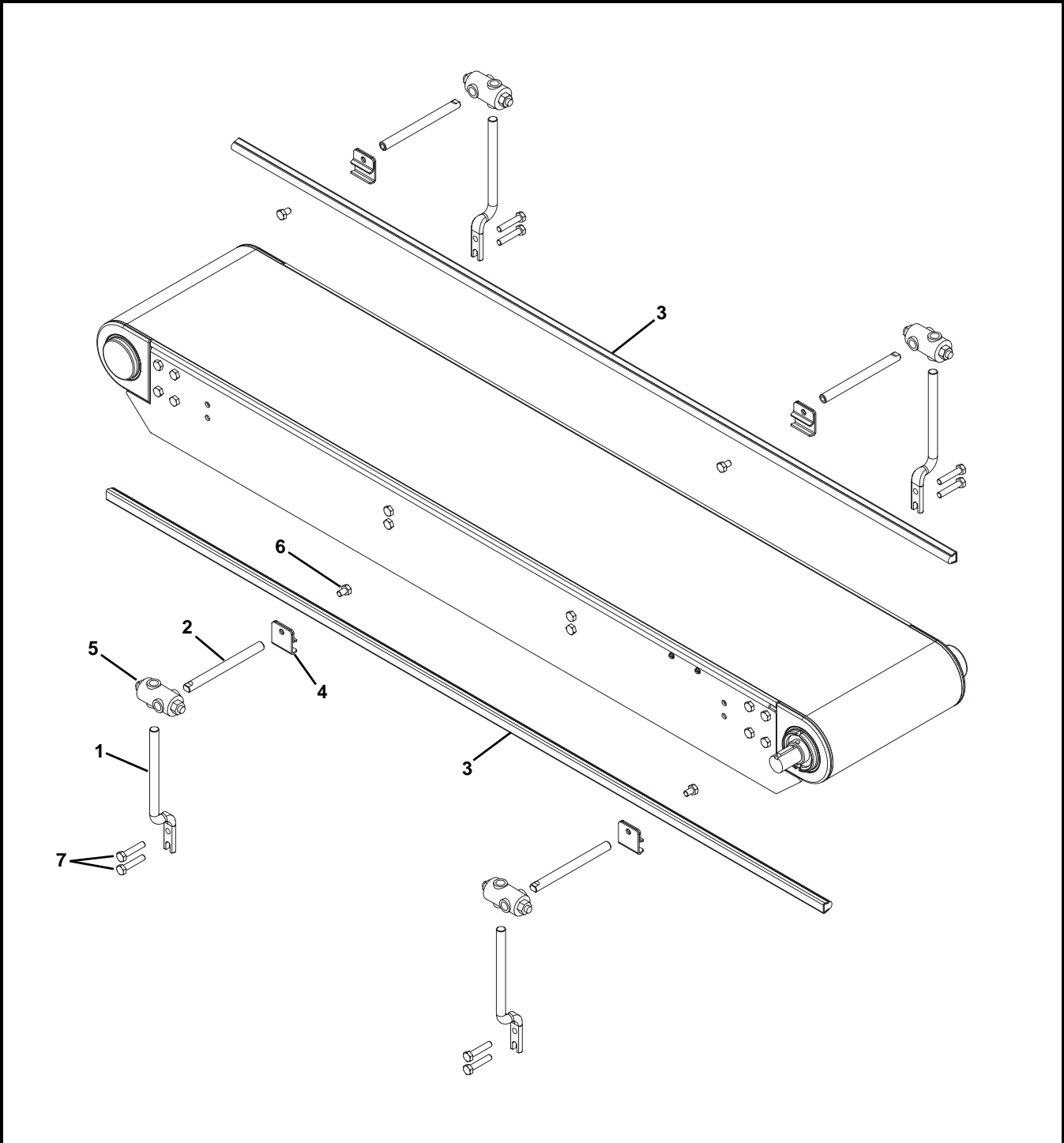
# Service Parts

## 152 mm High Sides for Curve Sections



Item	Part Number	Description
1	516999-02	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516908- <u>WW</u> -06- <u>AA</u>	Guiding for Inside Curve Section
4	516909- <u>WW</u> -06- <u>AA</u>	Guiding for Outside Curve Section
5	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Fully Adjustable Round Guides

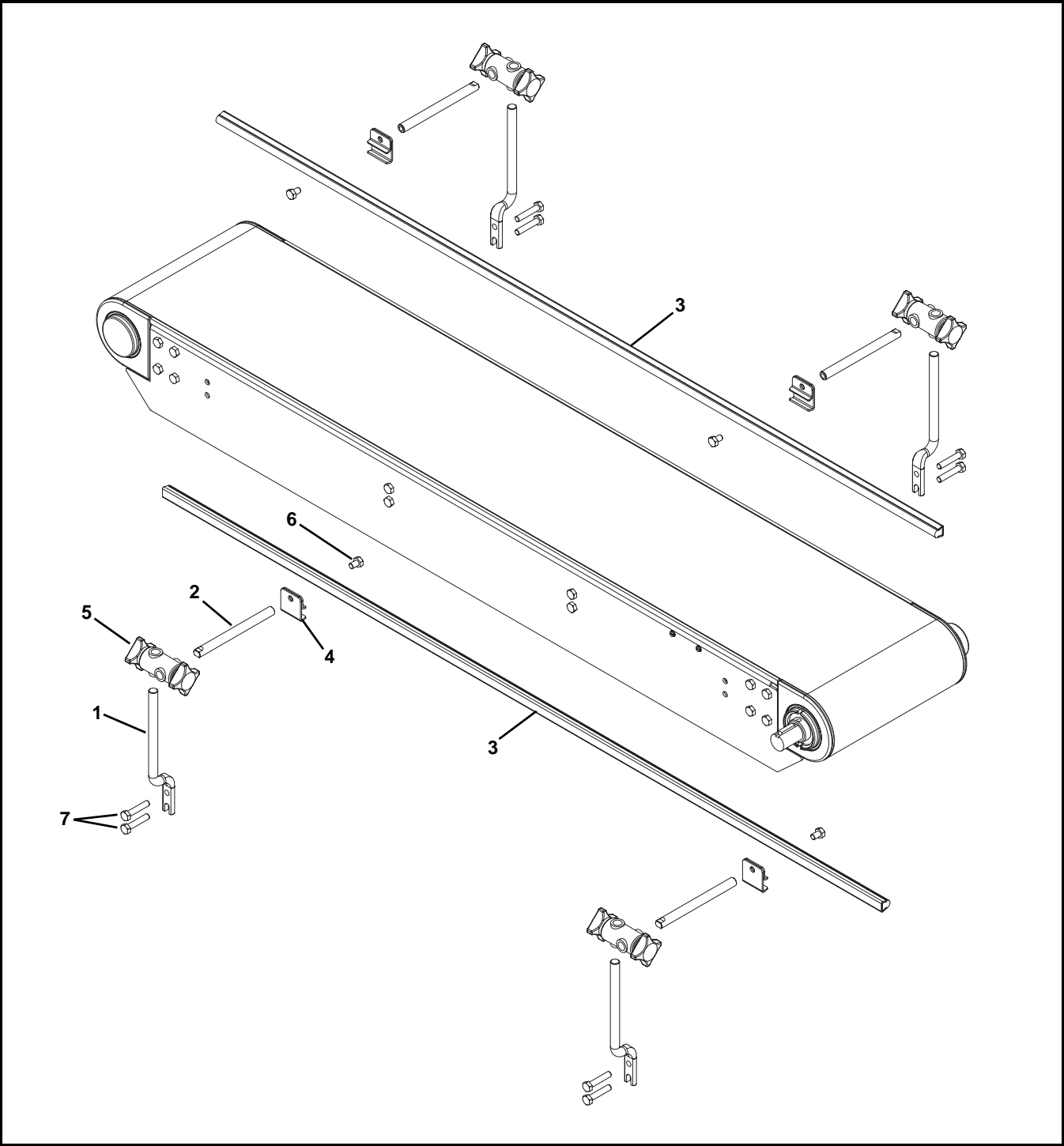


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167- <u>LLLLL</u>	Round Guide Rail
4	807-015	Rail Clamp
5	807-1387	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<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

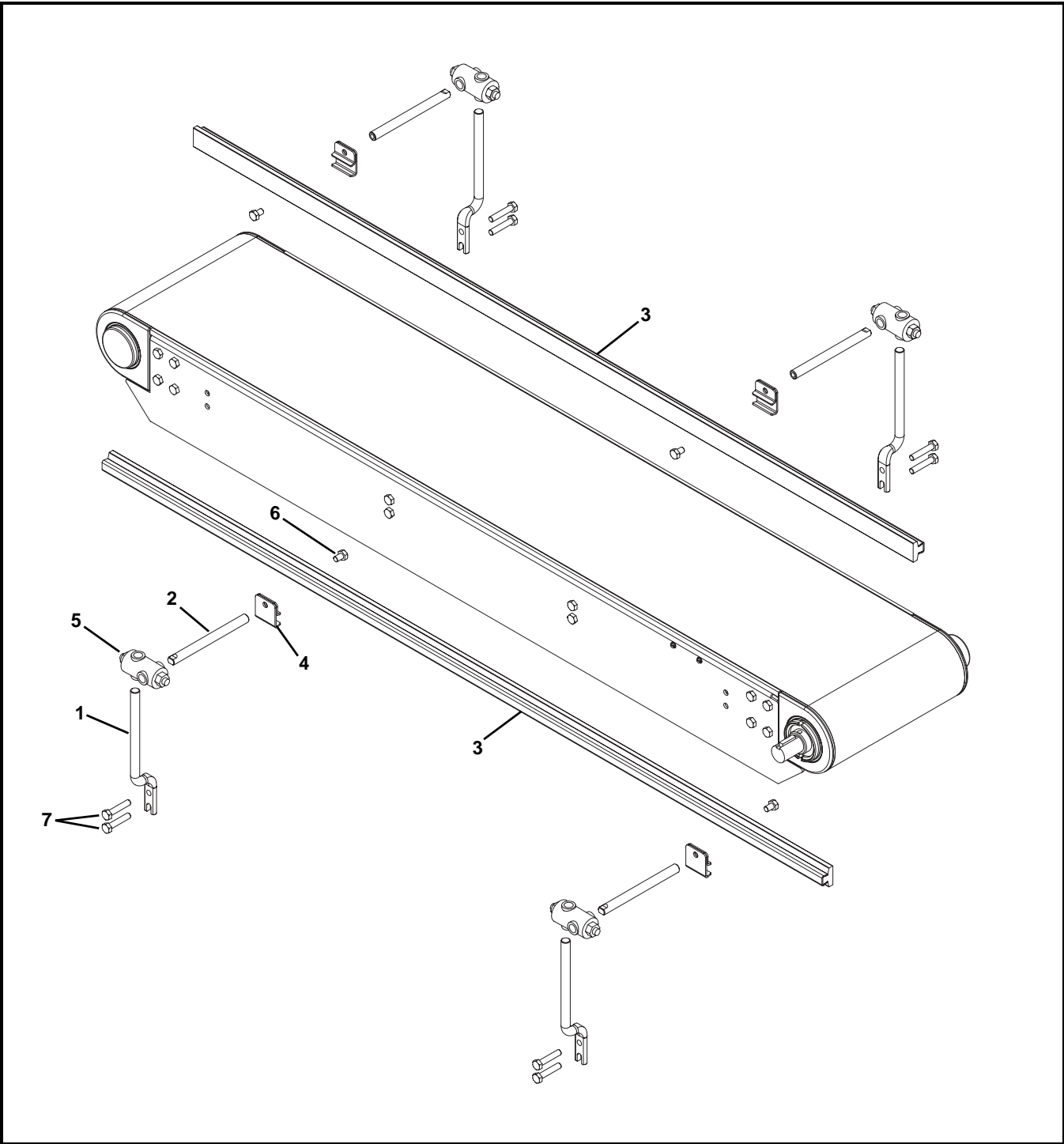
## Tool-Less Fully Adjustable Round Guides



Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167- <u>LLLL</u>	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
<u>LLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Fully Adjustable Flat Guides

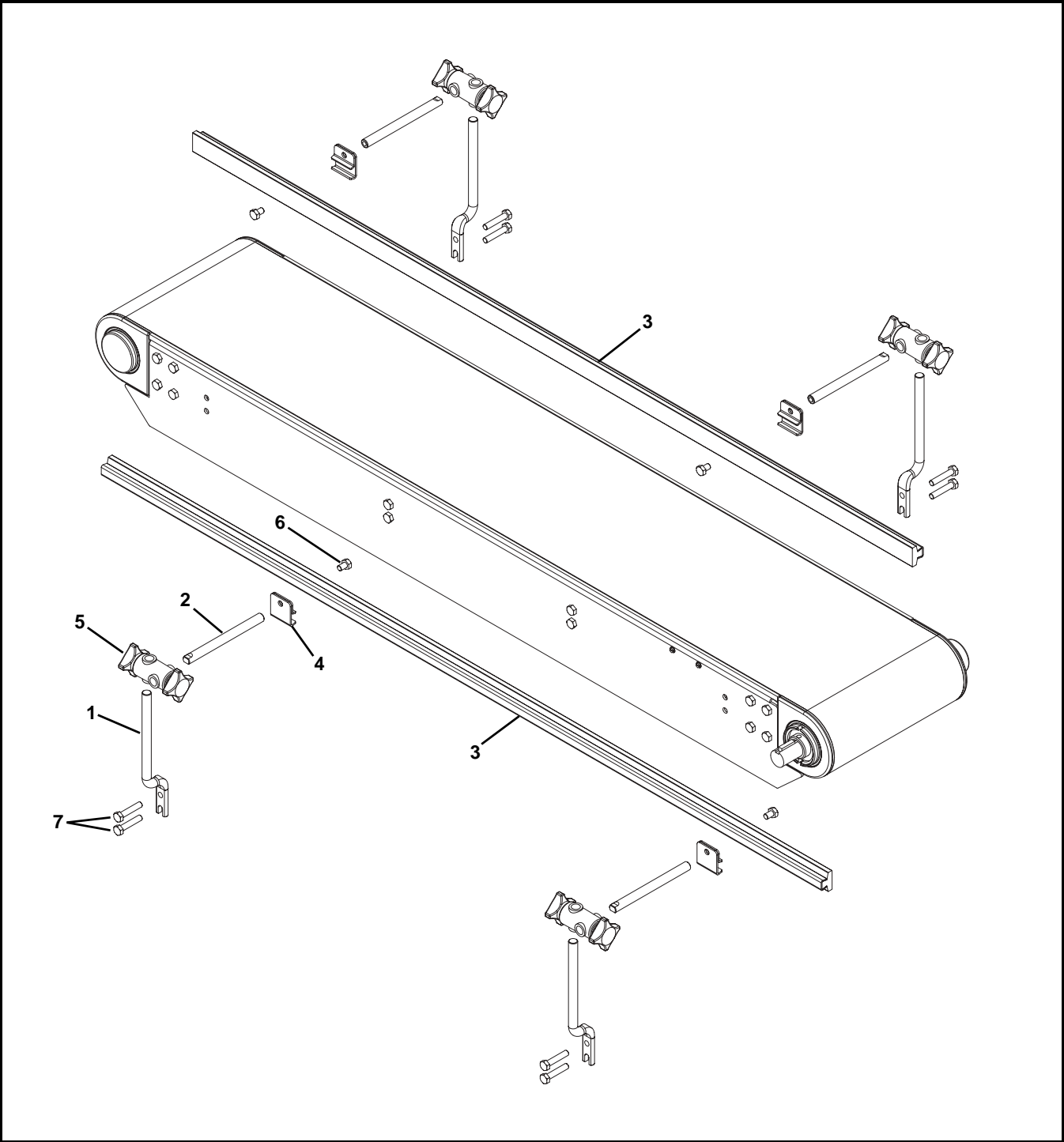


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	517599- <u>LLLLL</u>	Flat Guide Rail
4	807-015	Rail Clamp
5	807-1387	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
<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

## Tool-Less Fully Adjustable Flat Guides



Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	517599- <u>LLLL</u>	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
<u>LLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or 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:

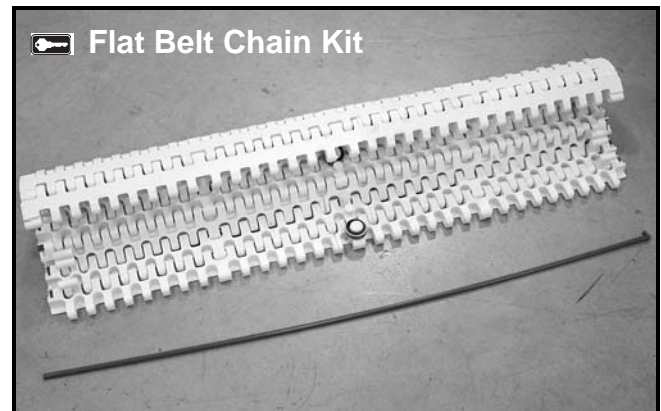
Overall chain length = 42' 5" (rounded up = 43')


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		

# 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 Type								
	Standard Products								Engineered to order parts
Product Line	Conveyors	Gearmotors & Mounting Packages	Support Stands	Accessories	Spare Parts (non-belt)	Spare Belts - Standard Flat Fabric	Spare Belts - Cleated & 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	50% return fee for all products								
7100 Series									
7200/7300 Series									
AquaGard 7350 Series Version 2									
GES Series	non-returnable								
AquaGard 7350/7360 Series									
AquaPruf Series									

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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