



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

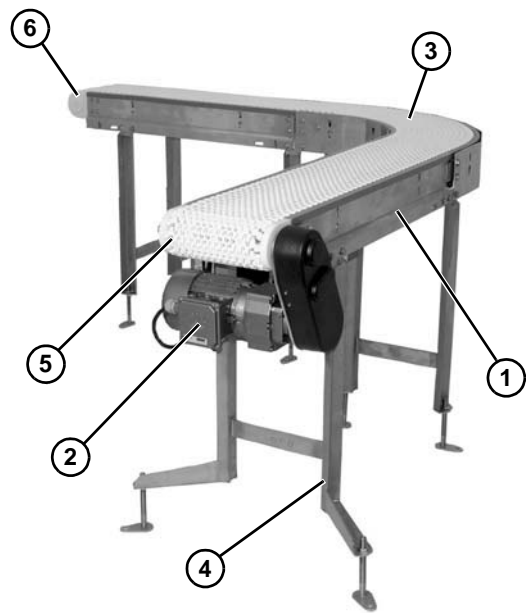


Figure 1

Specifications

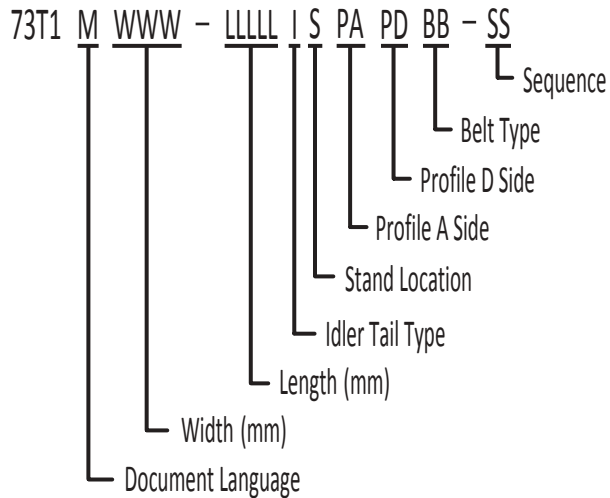
Conveyor Width Reference (<u>WWW</u>)	152, 305, 457, 610
Conveyor Belt Width	152 mm (6"), 305 mm (12"), 457 mm (18"), 610 mm (24")
Maximum Conveyor Load (See NOTE Below)	97 kg/ m ² (20 lbs. / ft ²) with a maximum of 227 kg (500 lbs.)
Belt Travel	305 mm (12") per revolution of pulley
Maximum Belt Speed	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

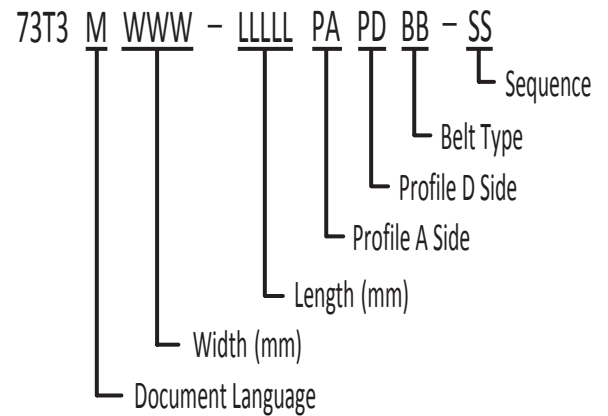
- Maximum conveyor loads are based on:
- Non-accumulating product
 - Product moving toward gearmotor
 - Conveyor being mounted horizontally
 - Conveyor being located in a dry environment
 - Conveyor equipped with standard belt only

7350 Series Version 2 Curve Conveyor Modules

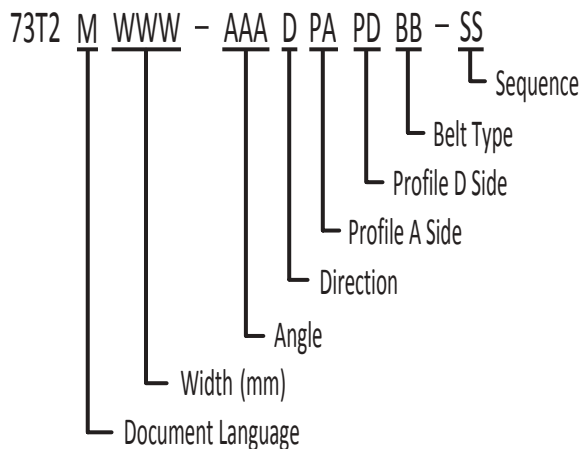
7350 Series Version 2 Infeed / Idler Module



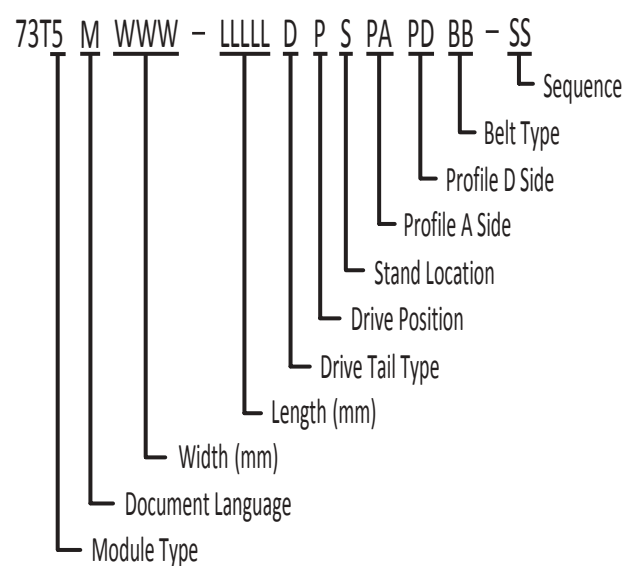
7350 Series Version 2 Intermediate Module



7350 Series Version 2 Curve Module



7350 Series Version 2 Exit / Discharge Module



Specifications

Conveyor Supports

Maximum Distances:

- A = Support Stand on Idler End = 914 mm (36")
- B = Support Stand on Drive End = 610 mm (24")
- * Additional stands located at frame joints.

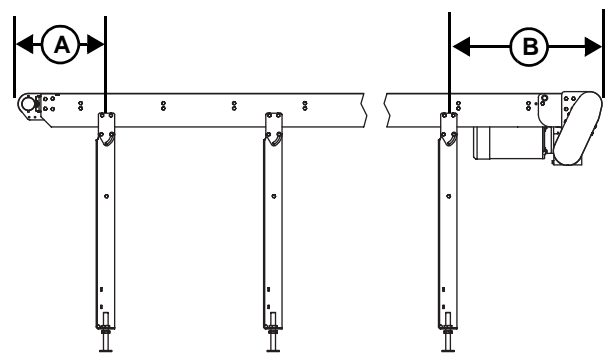


Figure 2

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°	1	2	2	2
180°	1	3	3	3

CAUTION

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

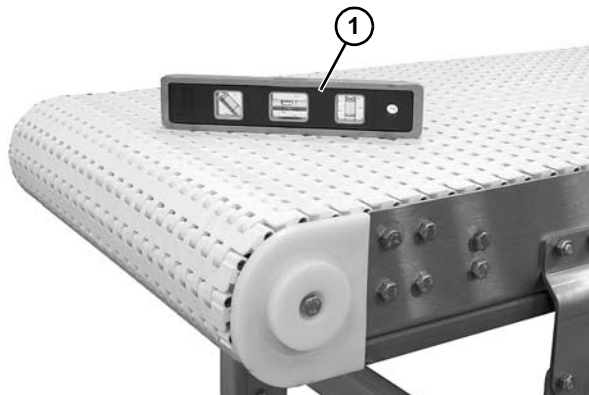


Figure 3

Required Tools

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

Recommended Installation Sequence

1. Remove shipping brackets (Figure 4, item 1) from both side of the conveyor.



Figure 4

2. Assemble the conveyor (if required). Refer to "Connecting Components" on page 7 or "Belt Installation" on page 8.
3. Attach the stands. Refer to "Stand Installation" on page 8.
4. Install the belt. Refer to "Belt Installation" on page 8.
5. Install the gearmotor. Refer to "Drive Package Installation" on page 12.

Connecting Components

Typical connecting components (Figure 5).

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

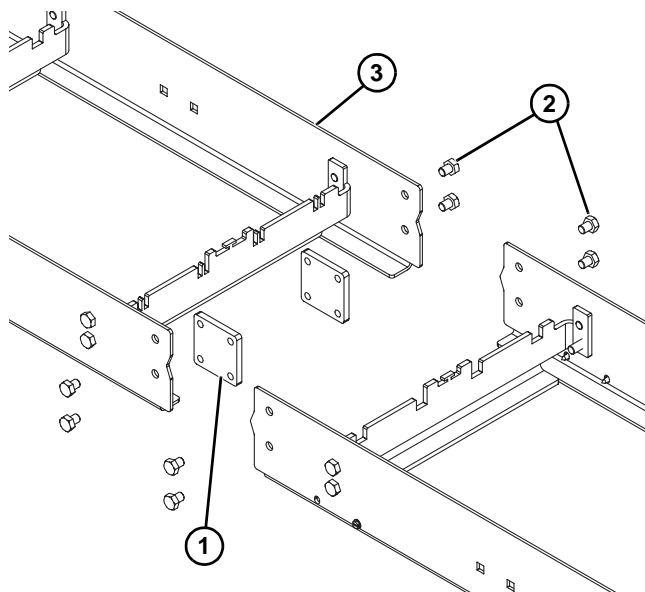


Figure 5

1. Locate and arrange conveyor sections by section labels (Figure 6, item 1).



Figure 6

2. Join both conveyor sections and install connecting plates (Figure 5, item 1) with four screws (Figure 5, item 2) on both sides. Tighten to 14-16 ft-lbs (19-22 Nm).

Installation

Stand Installation

NOTE

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

Typical stand components (**Figure 7**).

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

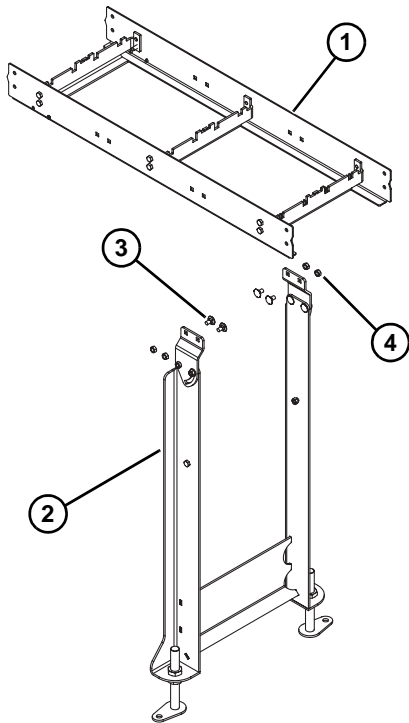


Figure 7

1. Position the stands on a flat, level surface.
2. Attach the stands (**Figure 8, item 1**) to the frame. Tighten carriage bolt nuts to 14-16 ft-lbs (19-22 Nm).

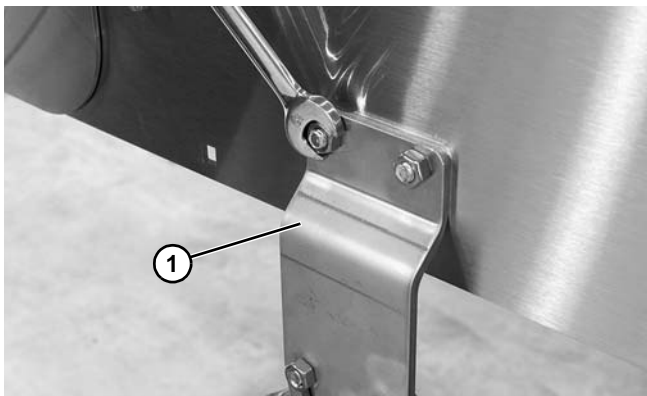


Figure 8

Belt Installation

Typical belt components (**Figure 9**).

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

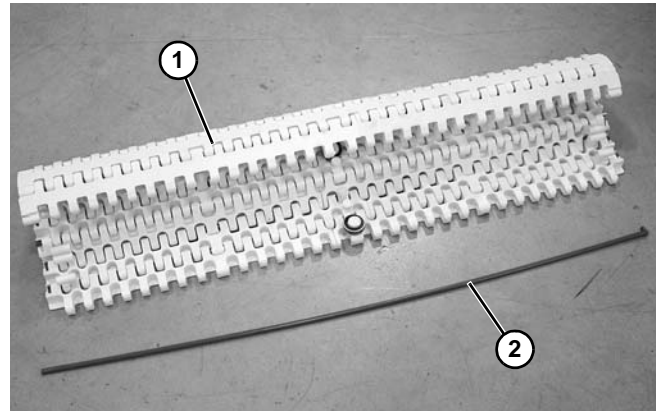


Figure 9

1. Position the belt on the conveyor frame.
2. Orient the belt with the arrows (**Figure 10, item 1**) on the underside of the belt pointing in the direction of the travel of the belt.

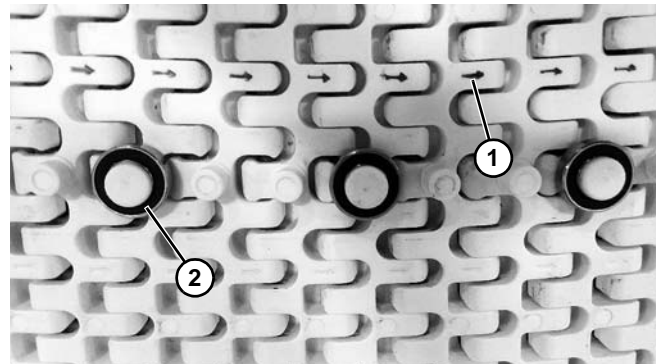


Figure 10

NOTE

*The bearings (**Figure 10, item 2**) on the underside of the belt must not be next to each other. A minimum of one space, and a maximum of two spaces, is required between bearings.*

3. Wrap the belt around the idler tail (**Figure 11, item 1**). Feed the belt through the idler tail with belt tabs (**Figure 11, item 2**) riding on the inside of the headplate channel (**Figure 11, item 3**).

NOTE

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

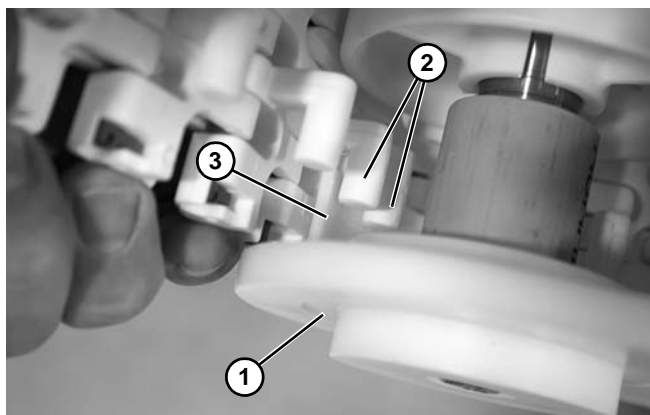


Figure 11

4. Feed the ends of the belt through the top and bottom of the curved frame sections. Make sure the belt tabs (**Figure 12, item 1**) and (**Figure 13, item 1**) are properly engaged with the wearstrips (**Figure 12, item 2**) and (**Figure 13, item 2**).

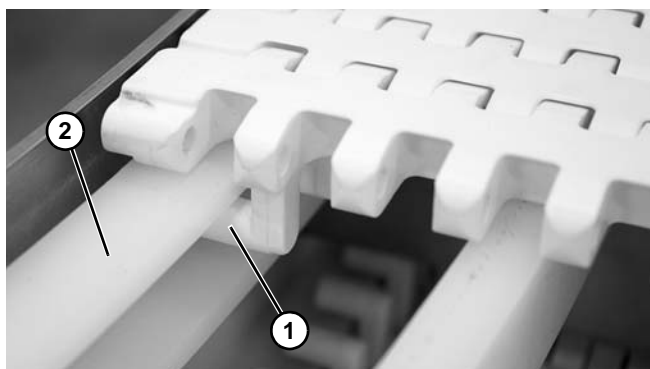


Figure 12

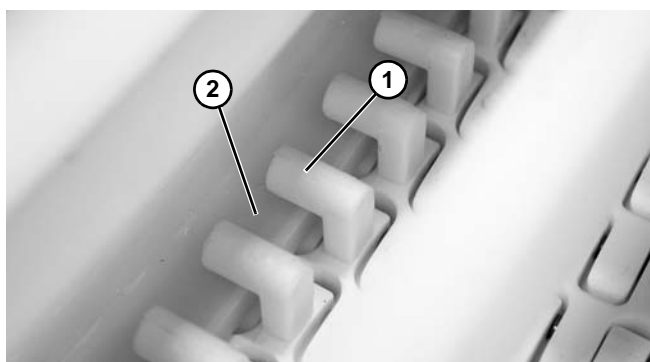


Figure 13

5. If applicable, feed the end of the belt around the pucks (**Figure 14, item 1**) in the gravity take-up. Make sure the belt tabs (**Figure 15, item 1**) are properly engaged with the wearstrips (**Figure 15, item 2**).

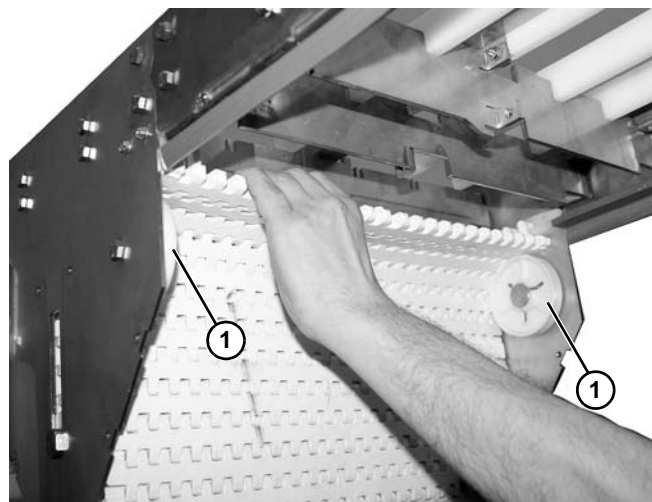


Figure 14

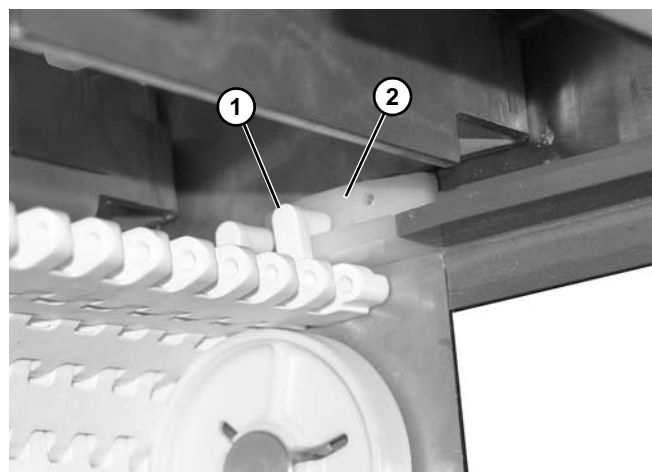


Figure 15

Installation

6. Continue feeding belt around the gravity take-up (**Figure 16, item 1**).

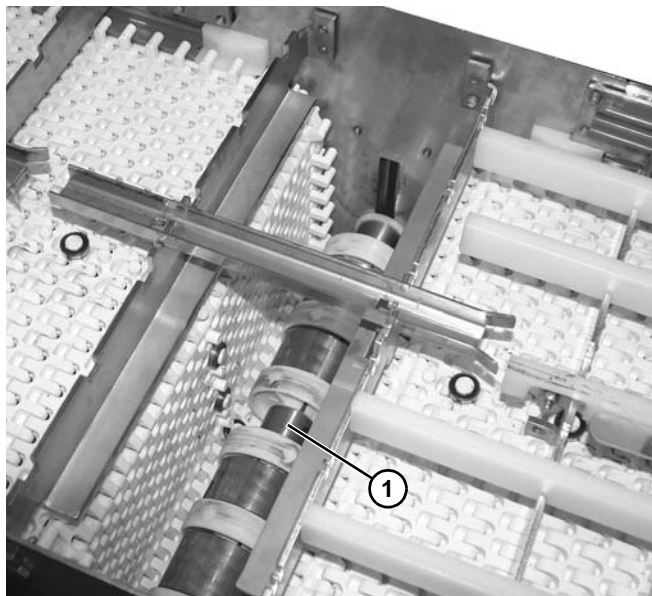


Figure 16

7. Wrap the belt around the drive end of the conveyor. Make sure the sprocket teeth have engaged the belt with the teeth (**Figure 17, item 1**) mating with the rounded section (**Figure 17, item 2**) of the belt.

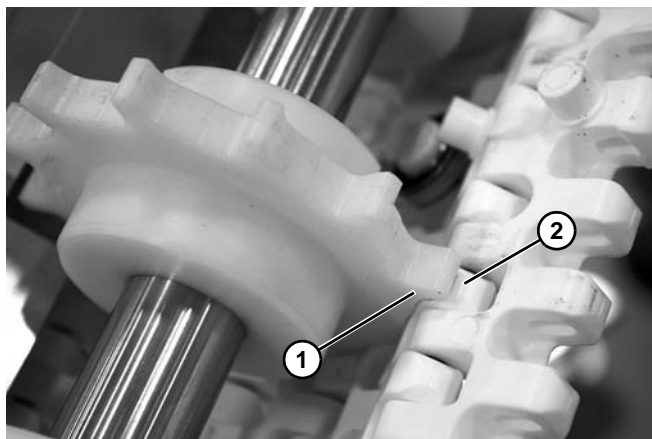


Figure 17

8. Bring the ends of the belt together (**Figure 18**).



Figure 18

9. Insert the belt rod (**Figure 19, item 1**) and push it through the belt.

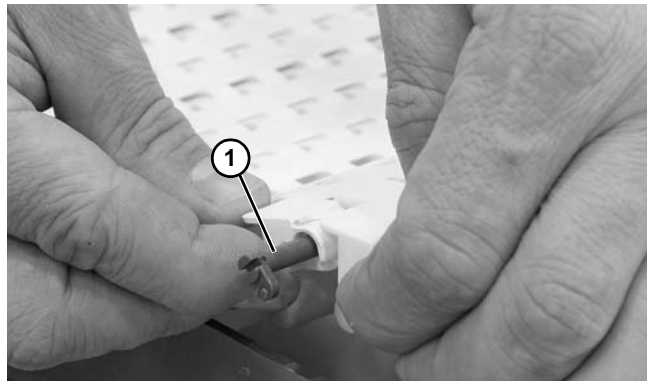


Figure 19

10. Insert a flat blade screwdriver into the slot on the rod head (**Figure 20, item 1**). Rotate rod head clockwise into the locked position (**Figure 20, item 2**).

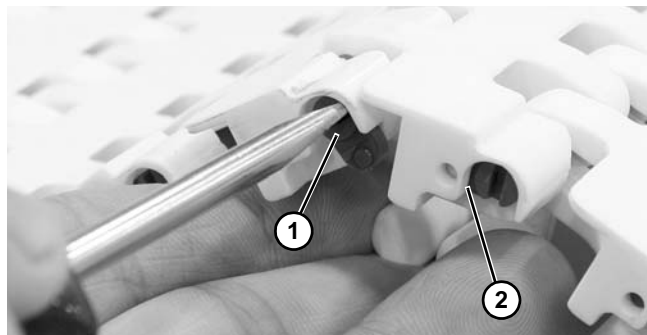


Figure 20

Guide Installation

High Side Guides

1. Remove and discard the top screw (**Figure 21, item 1**) from the conveyor side.



Figure 21

2. Assemble the mounting block (**Figure 22, item 1**) to the conveyor side with the screw (**Figure 22, item 2**) provided with the mounting block.

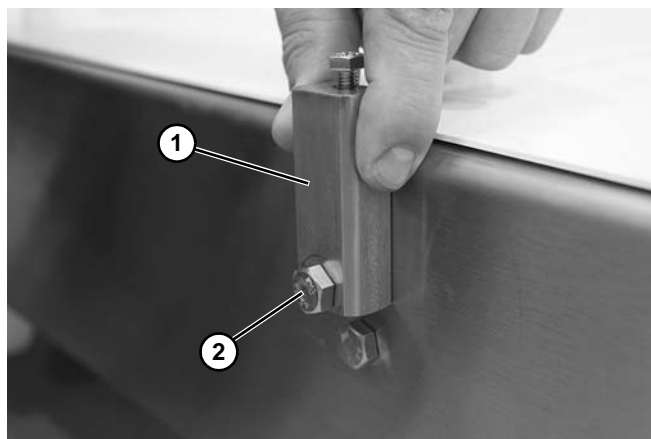


Figure 22

3. Install guide (**Figure 23, item 1**) into the slot (**Figure 23, item 2**) of the mounting block and tighten screws (**Figure 23, item 3**).

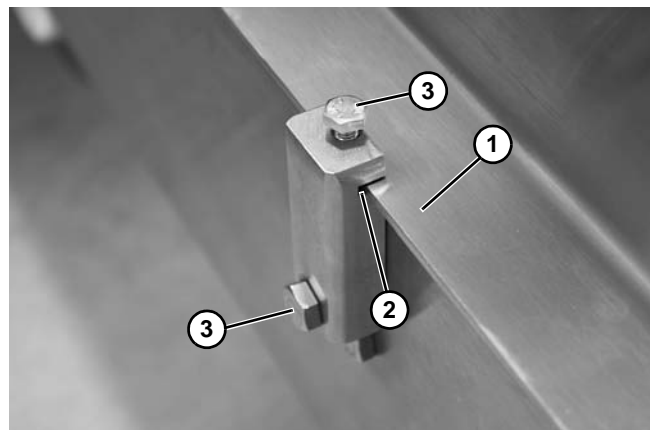


Figure 23

4. Install the connecting plate (**Figure 24, item 1**) over the studs.

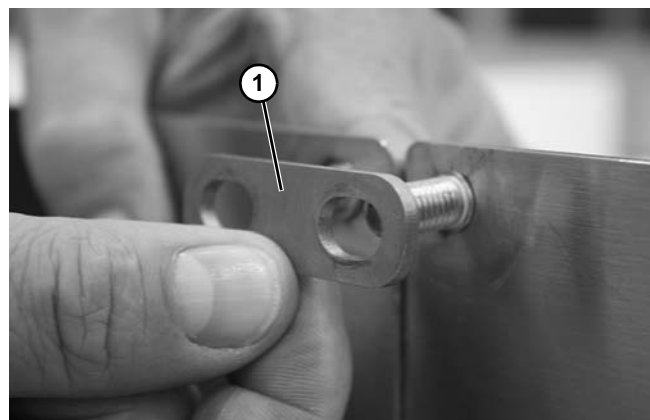


Figure 24

5. Install nuts (**Figure 25, item 1**) and tighten.

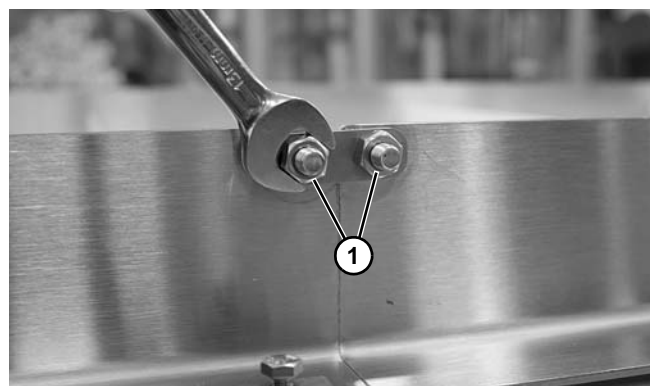


Figure 25

Installation

Adjustable Guides

1. Remove the top screw (**Figure 26, item 1**).

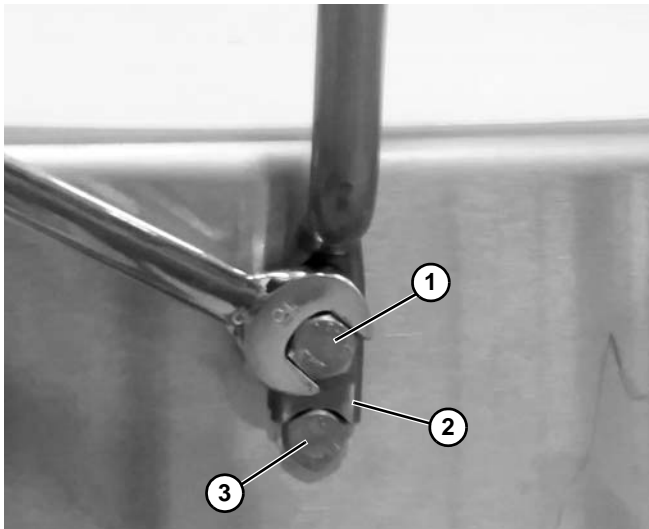


Figure 26

2. Install the guide post (**Figure 26, item 2**) resting on lower screw (**Figure 26, item 2**). Install top screw (provided with the guide post) and tighten.
3. Install guide rail (**Figure 27, item 1**) into rail clamp. Tighten fastener to secure (**Figure 27, item 2**).

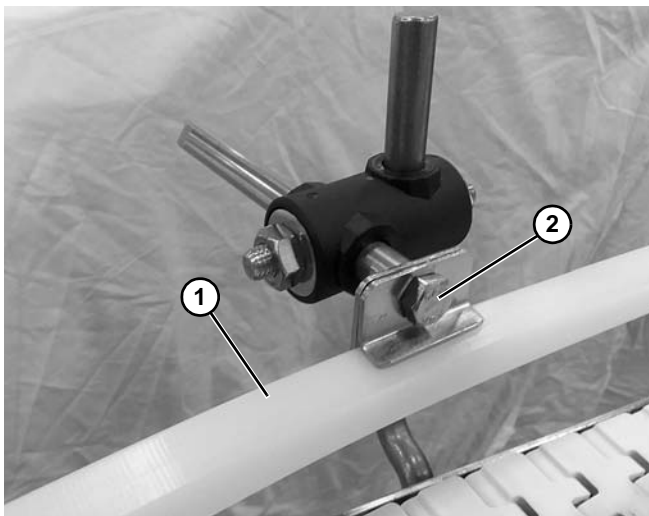


Figure 27

NOTE

See pages 51 to 54 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 28, item 1**) to the gear reducer (**Figure 28, item 2**).

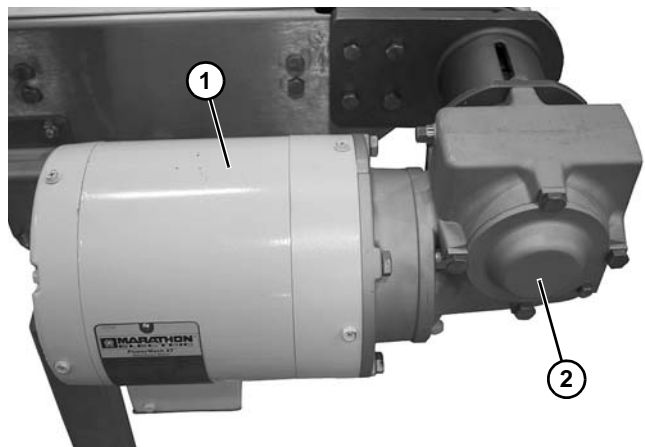


Figure 28

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
- Flat blade screwdriver

Checklist

- Keep critical service parts on hand. Refer to the "Service Parts" section starting on page 33 for recommendations.
- Replace any worn or damaged parts.

Cleaning

NOTE
<i>Proper conveyor application, cleaning, and sanitation are the responsibility of the end user.</i>

 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 29, item 1) when required.

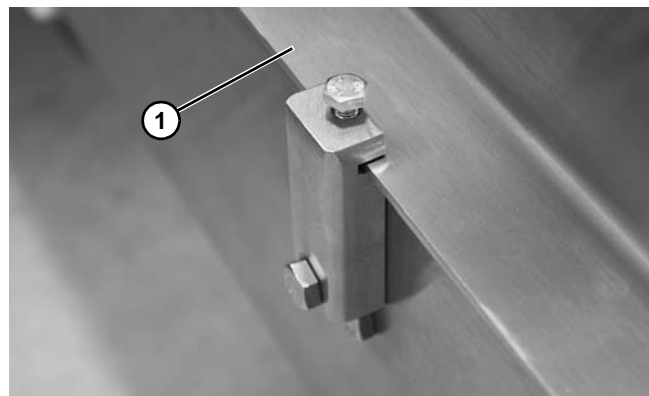


Figure 29

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 30, item 1**), not a single piece rod (**Figure 30, item 2**).

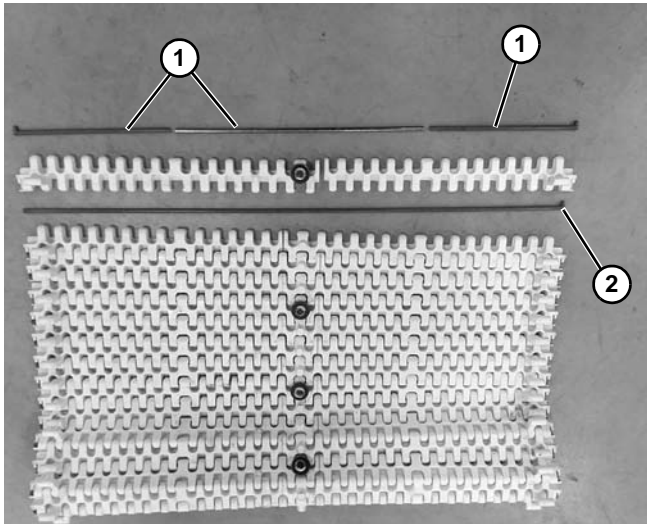


Figure 30

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 31, item 1**).

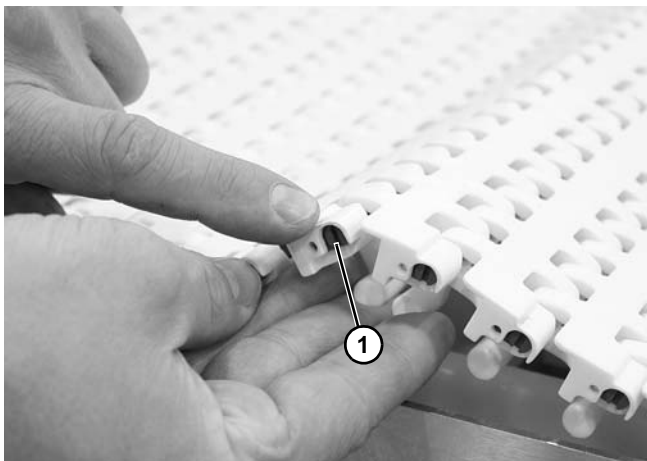


Figure 31

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

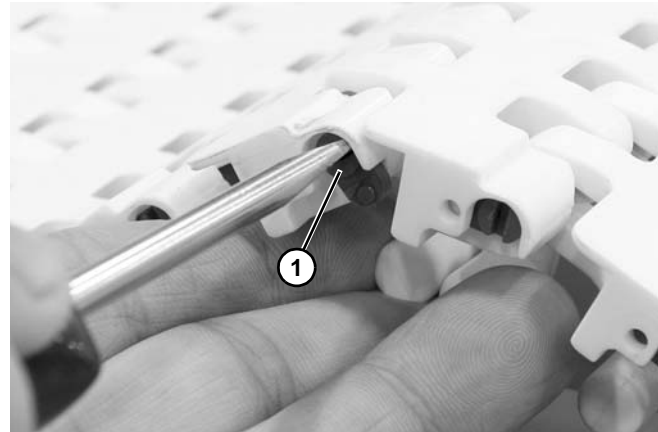


Figure 32

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

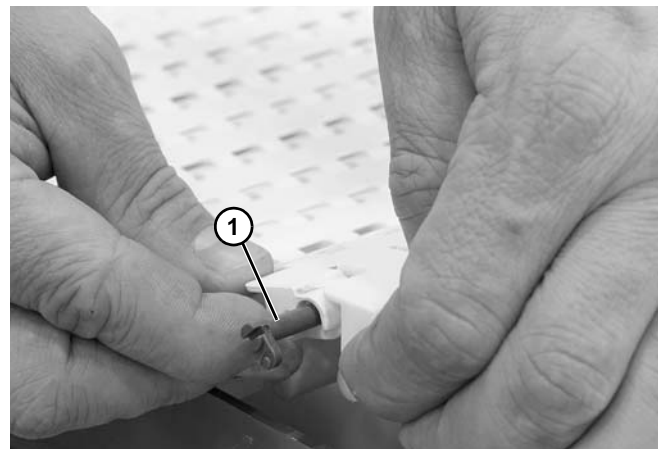


Figure 33

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 34, item 1**), not a single piece rod (**Figure 34, item 2**).

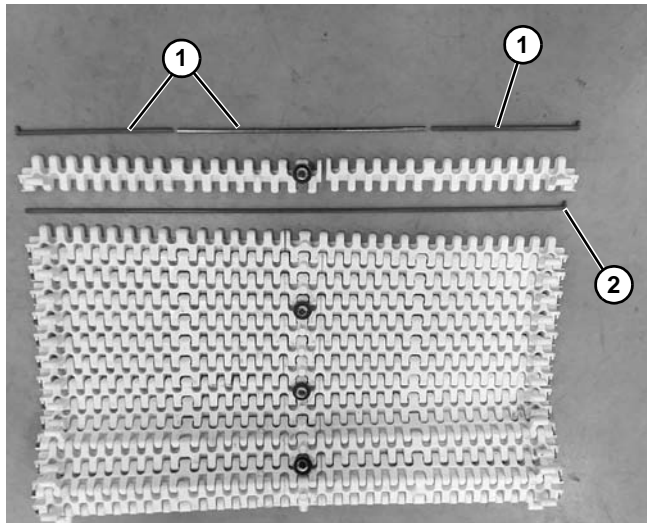


Figure 34

1. Lift up the belt near the tail end of the conveyor, or near a straight section. Locate the slotted end of the rod head (**Figure 35, item 1**).

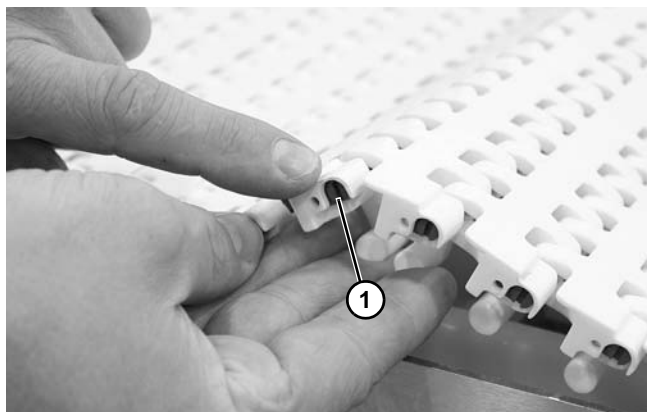


Figure 35

2. Insert a flat blade screwdriver into the slot on the rod head (**Figure 36, item 1**) and rotate the rod head counterclockwise to unlock.

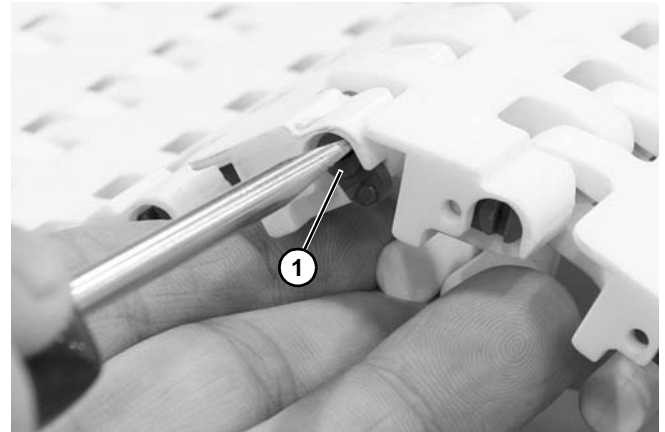


Figure 36

3. Remove the belt rod (**Figure 37, item 1**).

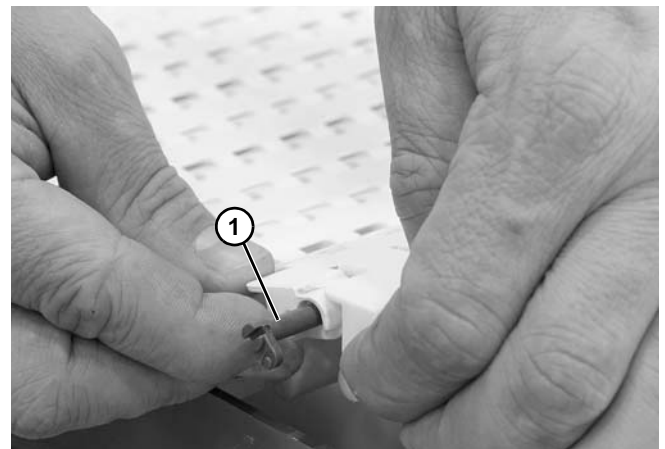


Figure 37

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

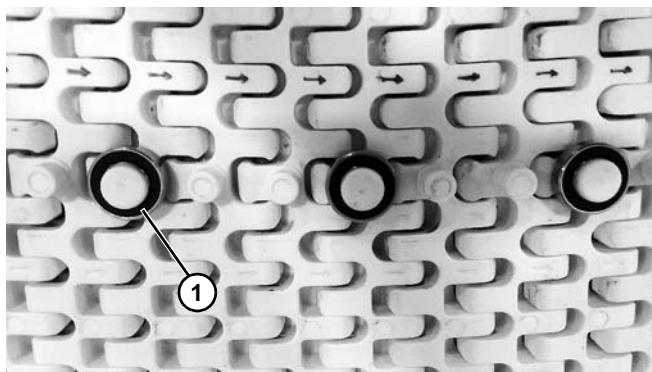


Figure 38

NOTE

The bearings (**Figure 38, item 1**) on the underside of the belt must not be next to each other. A minimum of one space, and a maximum of two spaces, is required between bearings.

Wear Strips

Replace the wear strips if they become worn.

Typical straight wear strips (**Figure 39**).

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

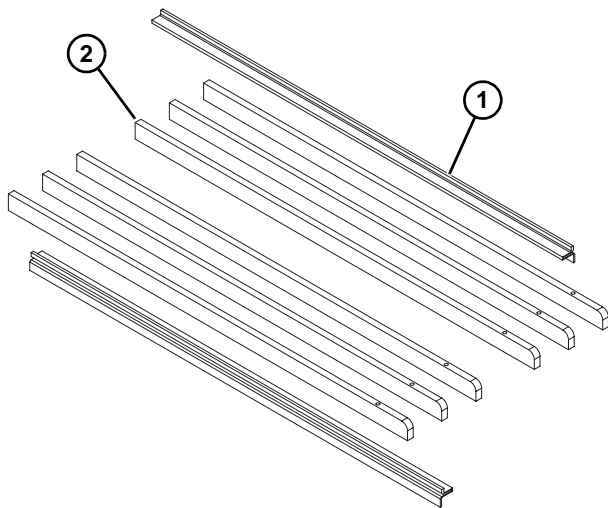


Figure 39

Typical curve wear strips (**Figure 40**).

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

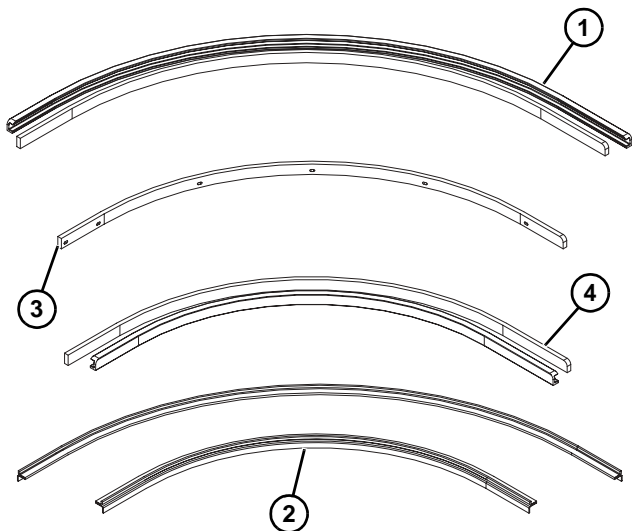


Figure 40

Preventive Maintenance and Adjustment

Wear Strip Removal

1. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 13.
2. Remove worn wear strips (**Figure 41, item 1**) from the frame notches.

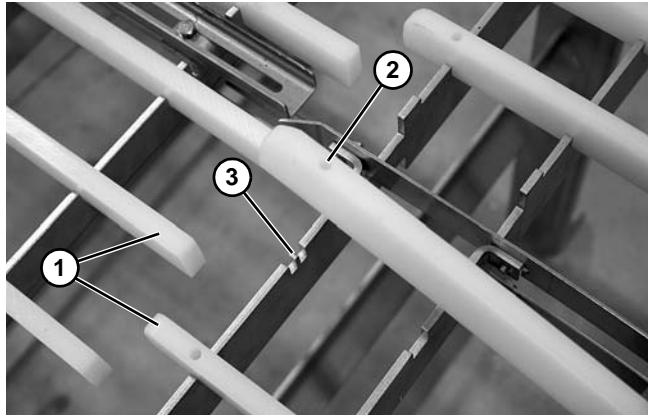


Figure 41

3. Attach new wear strips by installing the locating hole (**Figure 41, item 2**) over the tab (**Figure 41, 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 screws (**Figure 42, item 1**) retaining the wear strip support brackets (**Figure 42, item 2**) to the frame crossmembers (**Figure 42, item 3**).

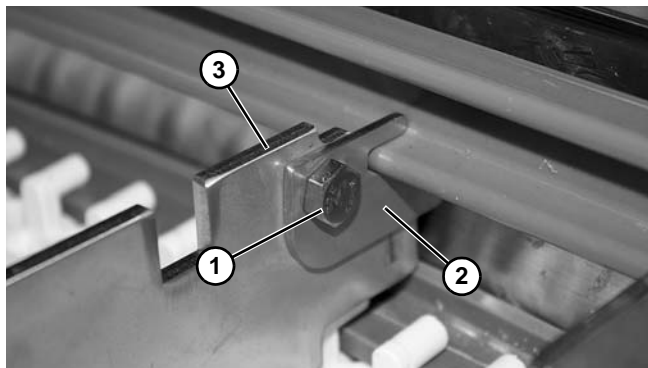


Figure 42

2. Remove the upper wear strip (**Figure 43, item 1**) from the frame.

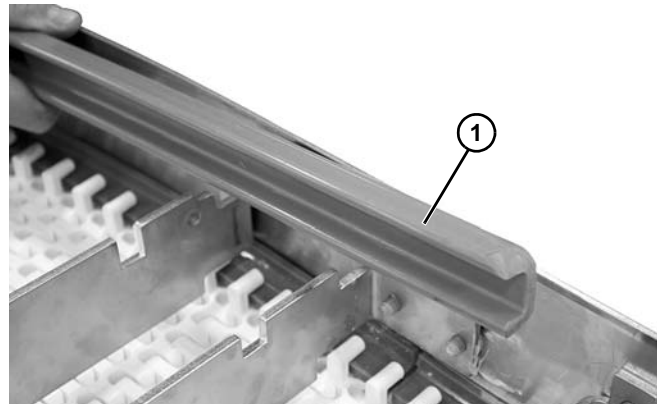


Figure 43

3. When installing a new wear strip, make sure the wear strip (**Figure 44, item 1**) is contacting the crossmember tab (**Figure 44, item 2**) - to prevent the wear strip from disengaging.

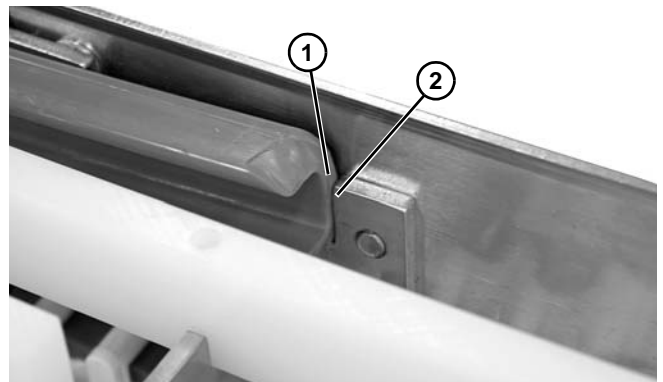


Figure 44

Preventive Maintenance and Adjustment

Curve Bearing Guide Wear Strip

1. Remove the screw (**Figure 45, item 1**) retaining the wear strip to the frame crossmember.

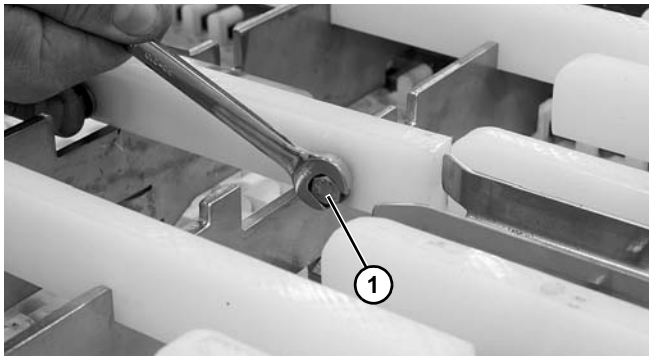


Figure 45

2. Remove the wear strip (**Figure 46, item 1**).

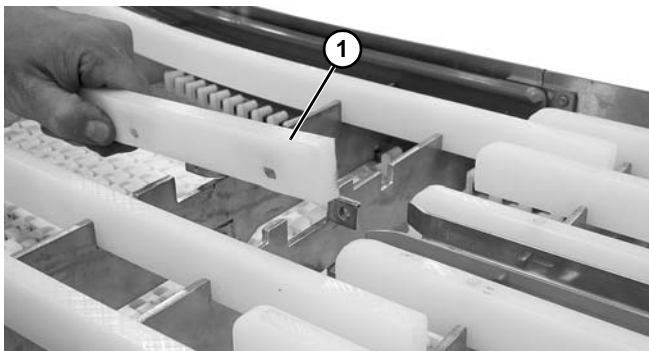


Figure 46

3. Install a new wear strip.

NOTE

Insert the first screw on the infeed end of the curve section with the screw head (**Figure 47, item 1**) on the outside of the curve. The remainder of the screw heads (**Figure 47, item 2**) should be located on the inside of the curve.

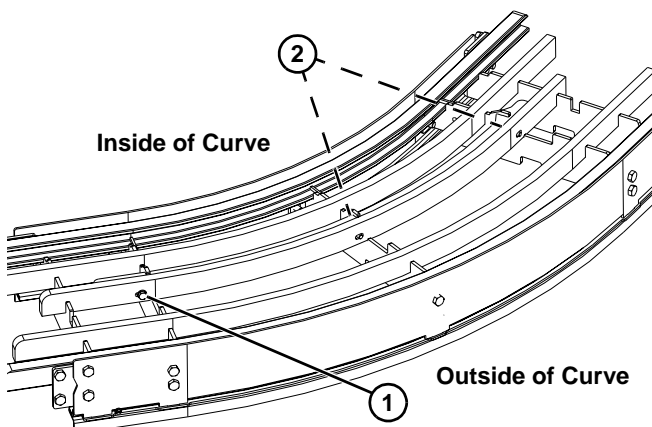


Figure 47

Bottom Wear Strip

1. Remove the screw (**Figure 48, item 1**) retaining the wear strip to the frame.

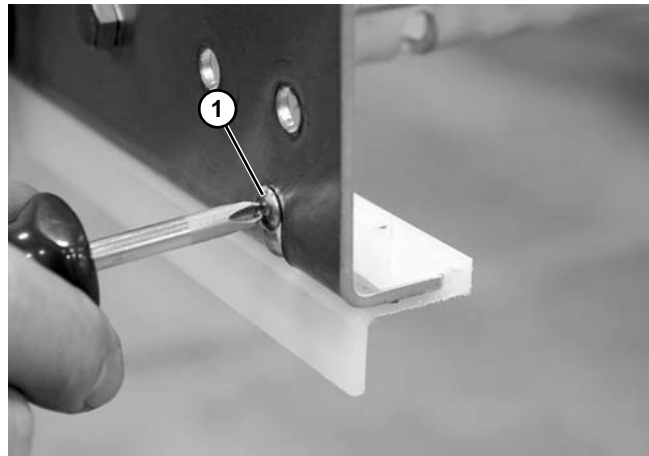


Figure 48

2. Remove the bottom wear strip (**Figure 49, item 1**) from the frame rail (**Figure 49, item 2**).

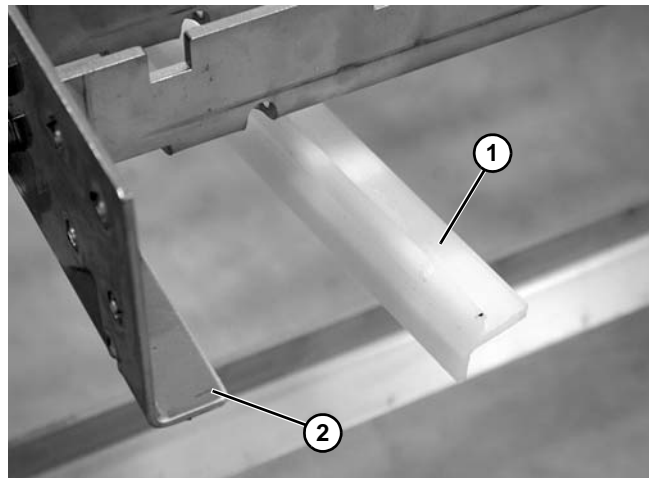


Figure 49

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 13.
3. Remove bearing cover (**Figure 50, item 1**).

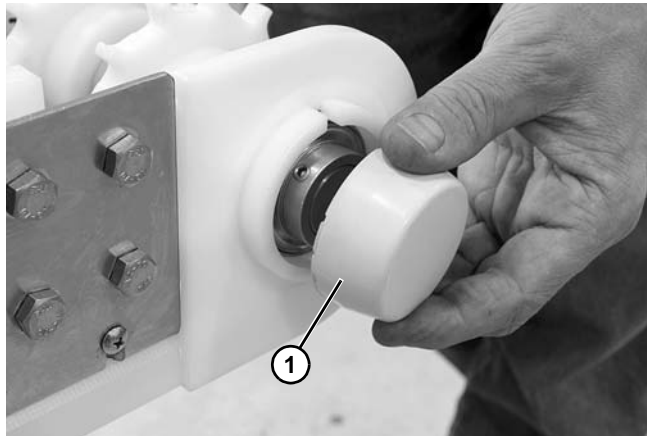


Figure 50

4. Remove the four headplate screws (**Figure 51, item 1**) on both sides of the conveyor.

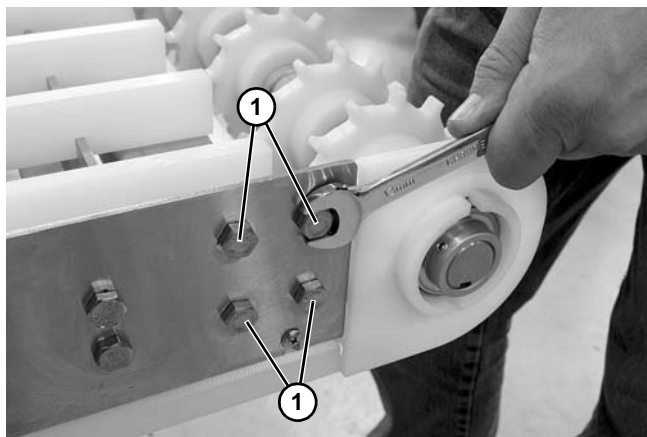


Figure 51

⚠ CAUTION

Support bracket (**Figure 52, item 2**) will not be attached and could fall.

5. Remove drive tail assembly (**Figure 52, item 1**).

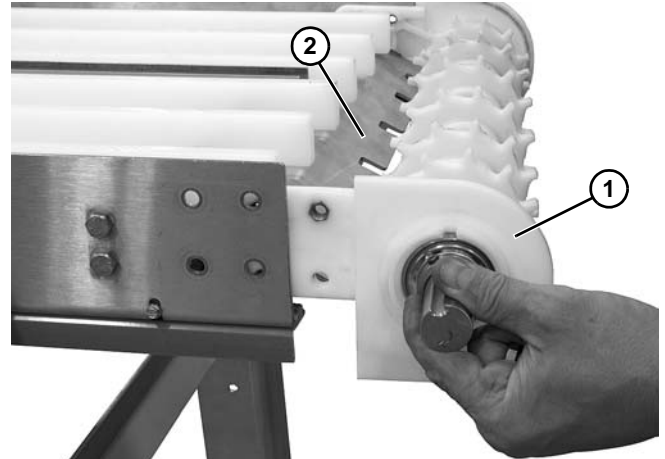


Figure 52

6. Loosen set screws (**Figure 53, item 1**).

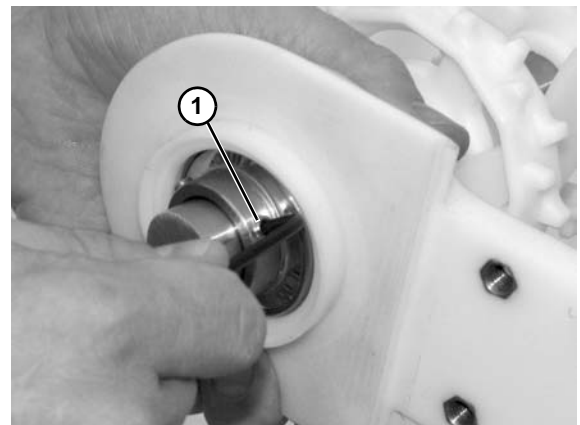


Figure 53

Preventive Maintenance and Adjustment

- Slide the headplate with bearing (**Figure 54, item 1**) off the shaft. Replace bearing if worn. Refer to “Bearing Replacement” on page 26.
- Remove the four headplate screws (**Figure 55, item 1**) on both sides of the conveyor.

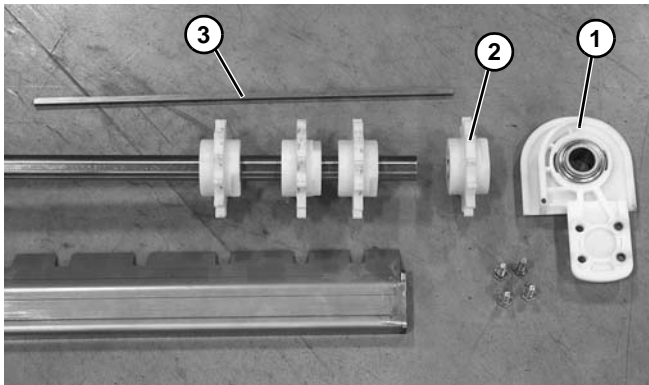


Figure 54

- Slide off the drive sprocket (**Figure 54, item 2**).
- Repeat as needed.
- Remove the shaft key (**Figure 54, item 3**).

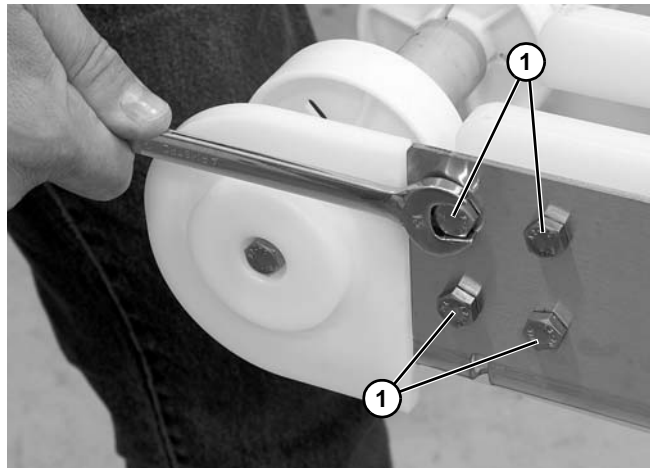


Figure 55

- Remove idler tail assembly (**Figure 56, item 1**).

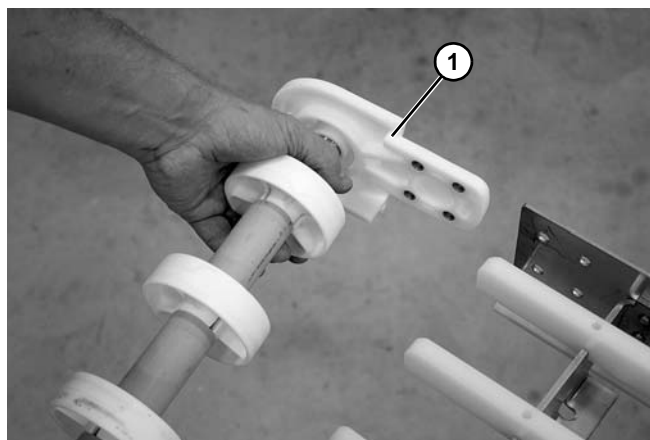


Figure 56

- Using a 13 mm socket (**Figure 57, item 1**), remove the headplate screw from the shaft.

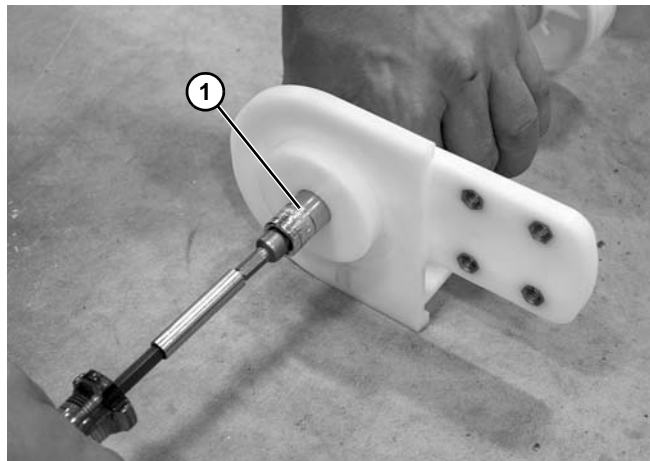


Figure 57

Idler Puck and Spindle Replacement

⚠ WARNING



SEVERE HAZARD!

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

NOTE

Idler tails are equipped with plain bushing pucks, replace when worn.

- Open conveyor belt. Refer to “Conveyor Belt Replacement” on page 13.

Preventive Maintenance and Adjustment

5. Slide the headplate (**Figure 58, item 1**) off the shaft.

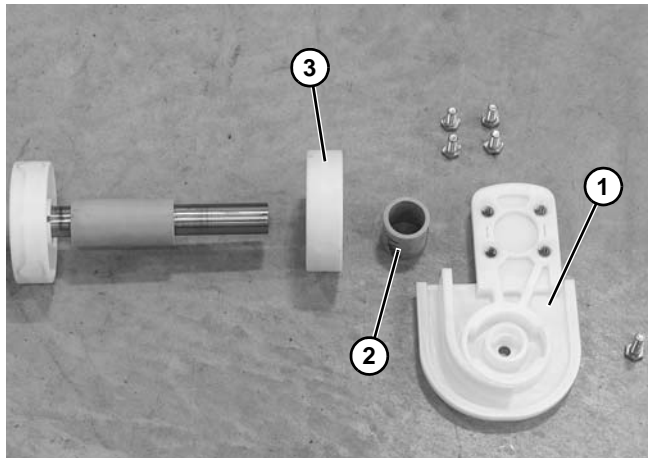


Figure 58

6. Slide off the round puck spacer (**Figure 58, item 2**).
7. Slide off the puck and replace (**Figure 58, item 3**).
8. Repeat as needed.

Power Transfers

Removal

1. Remove two hex head screws (**Figure 59, item 1**) and cover (**Figure 59, item 2**).

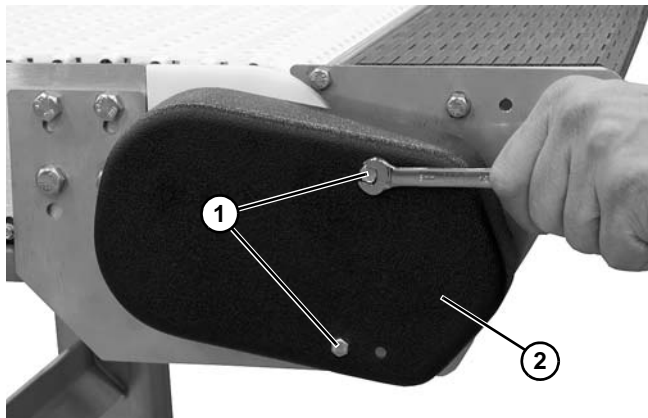


Figure 59

2. Loosen two hex head screws (**Figure 60, item 1**) holding tensioning bearing (**Figure 60, item 2**) against timing belt (**Figure 60, item 3**).

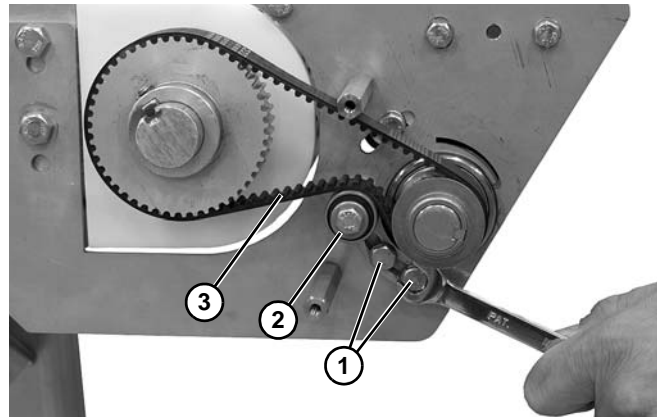


Figure 60

3. Remove timing belt (**Figure 61, item 1**).

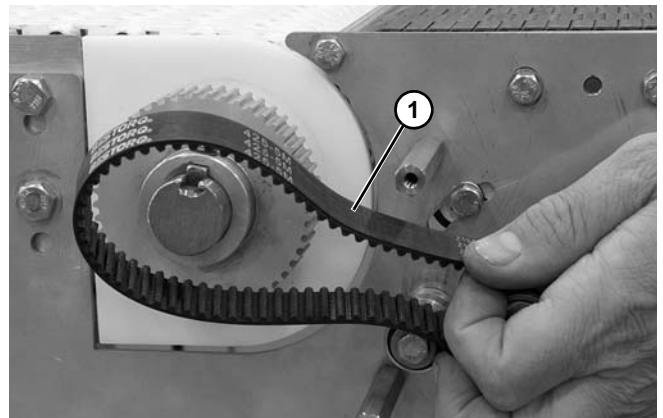


Figure 61

4. Loosen hex head screw (**Figure 62, item 1**) on both sides of the power transfer.

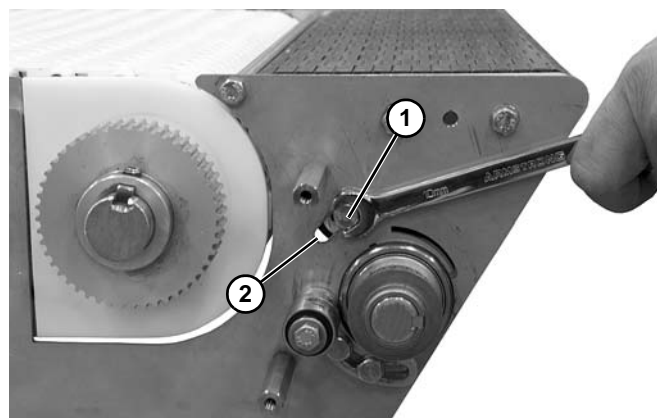


Figure 62

5. Slide idler assembly within slot (**Figure 62, item 2**) to remove tension on belt.

Preventive Maintenance and Adjustment

6. Lift slightly on belt (**Figure 63, item 1**) and push pin (**Figure 63, item 2**) out of belt.

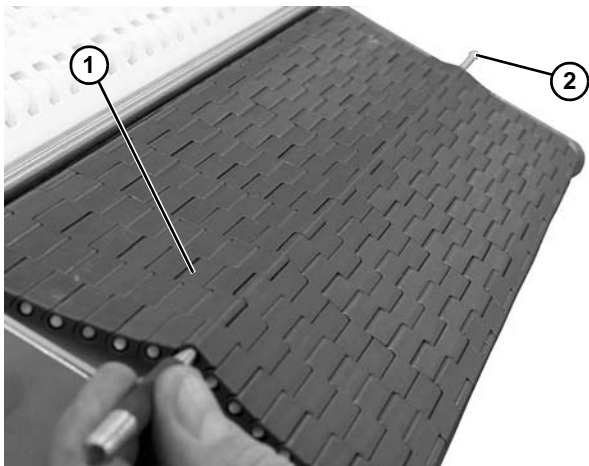


Figure 63

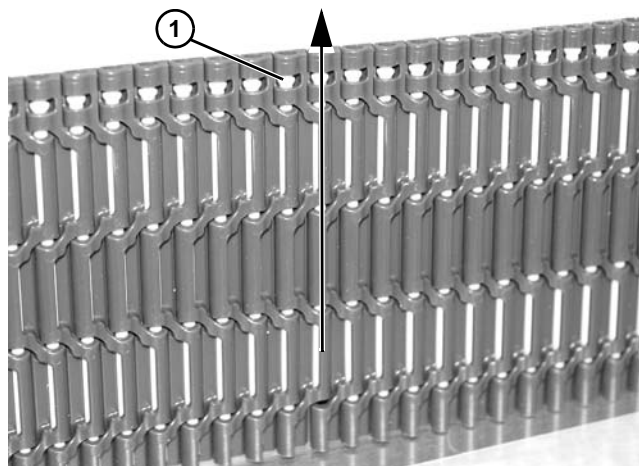


Figure 64

NOTE

Note that head of pin (**Figure 64, item 1**) should be removed in direction shown.

7. Remove belt.

8. Remove two hex head screws (**Figure 65, item 1**) on both sides of the power transfer.

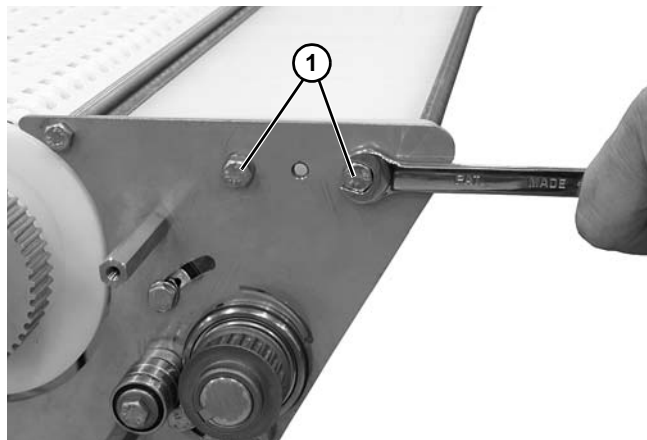


Figure 65

9. Remove the wear bar assembly (**Figure 66, item 1**) from the power transfer.

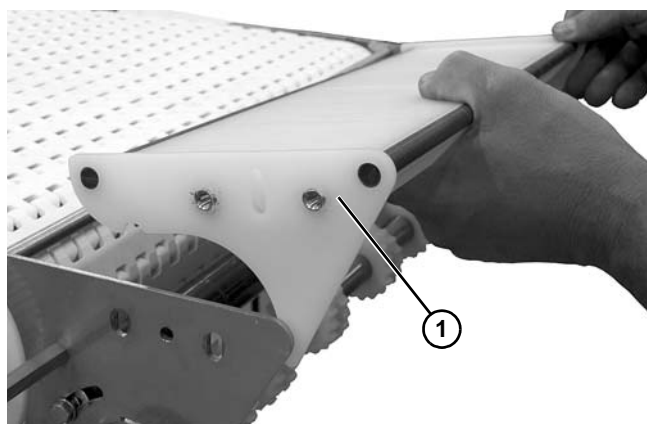


Figure 66

10. Disassemble side guide plates (**Figure 67, item 1**), wear rods (**Figure 67, item 2**), and wear bar (**Figure 67, item 3**). Replace worn parts.

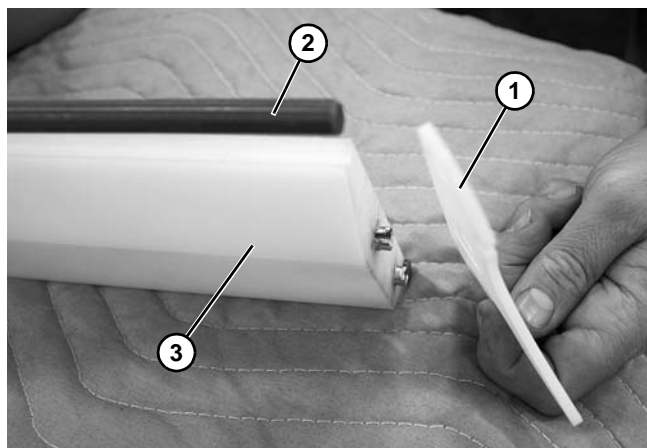


Figure 67

Preventive Maintenance and Adjustment

11. Remove hex head screw (**Figure 68, item 1**) on both sides of the power transfer and remove idler assembly.

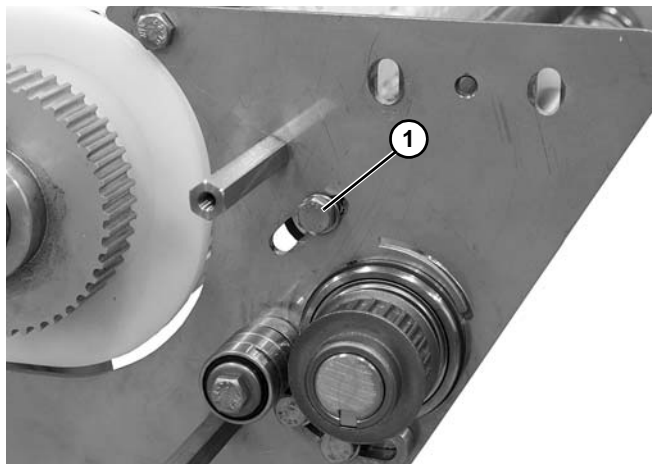


Figure 68

12. Replace the idler assembly and install hex head screws to secure.
13. Loosen two set screws (**Figure 69, item 1**) on bearing (**Figure 69, item 2**) on both sides of the power transfer.

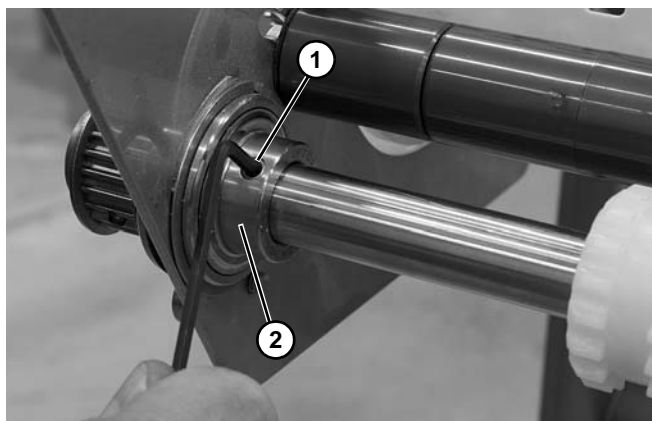


Figure 69

14. Loosen set screw (**Figure 70, item 1**) on drive sprocket (**Figure 70, item 2**).

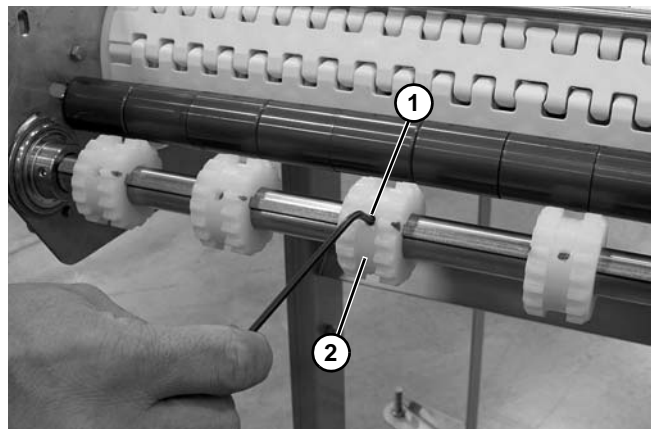


Figure 70

15. While removing drive shaft (**Figure 71, item 1**), slide drive sprockets (**Figure 71, item 2**) and shaft key (**Figure 71, item 3**) from shaft.

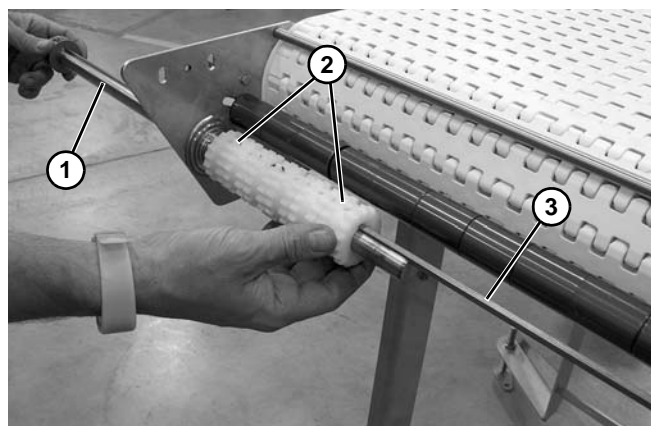


Figure 71

Preventive Maintenance and Adjustment

Installation

1. Insert drive shaft (**Figure 72, item 1**) through bearing (**Figure 72, item 2**).

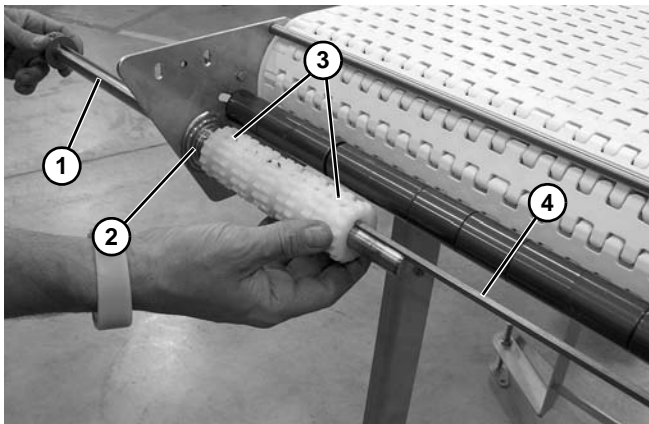


Figure 72

2. Slide drive sprockets (**Figure 72, item 3**) and shaft key (**Figure 72, item 4**) onto shaft while pushing shaft through bearing.
3. Insert drive shaft through opposite bearing (**Figure 73, item 1**) and press outward on bearings as shown.

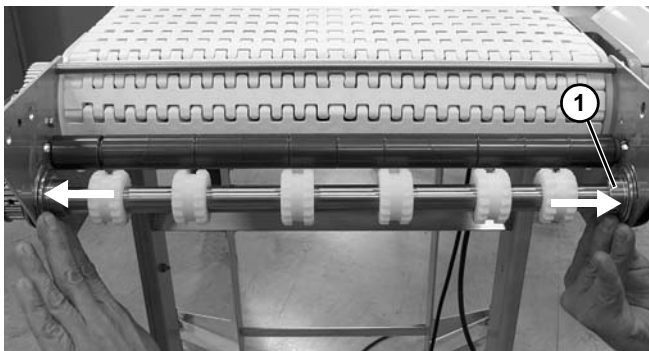


Figure 73

4. Tighten set screw (**Figure 74, item 1**) on drive sprocket (**Figure 74, item 2**).

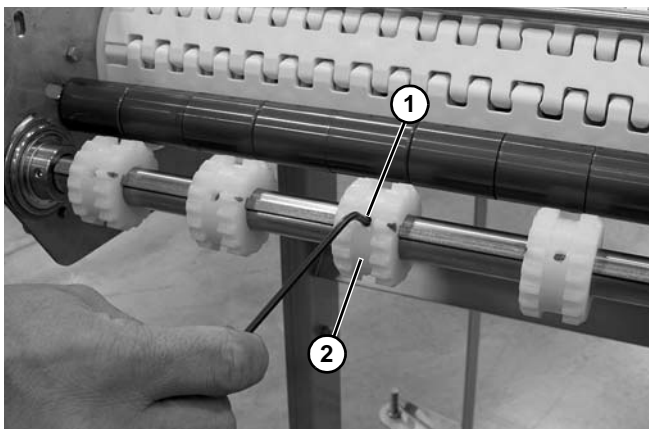


Figure 74

5. Tighten two set screws (**Figure 75, item 1**) on bearing (**Figure 75, item 2**) on both sides of the power transfer.

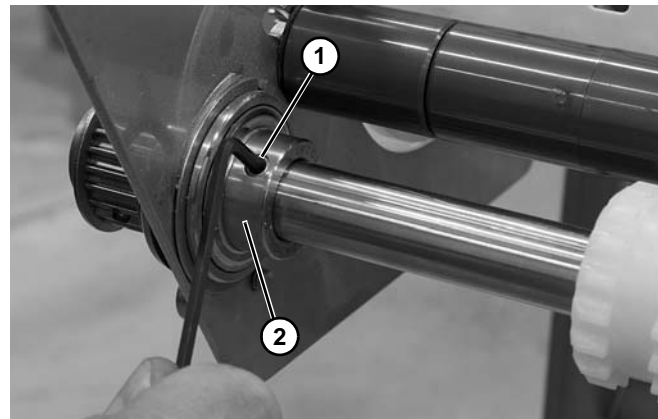


Figure 75

6. Raise belt (**Figure 76, item 1**) into position. Move drive sprockets (**Figure 76, item 2**) so that the teeth line up with the belt, as shown.

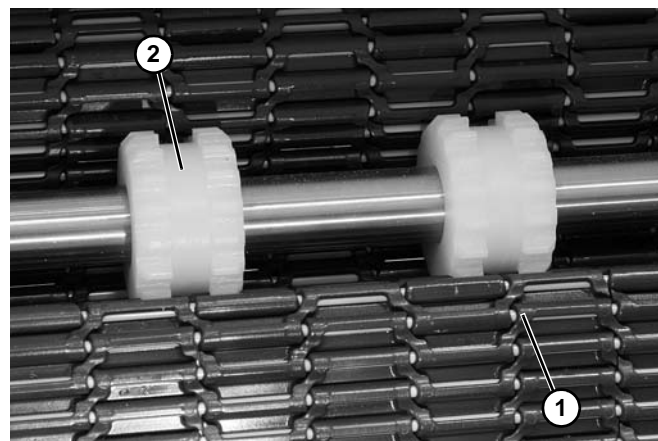


Figure 76

7. Install support bar assembly (**Figure 77, item 1**) with two hex head screws (**Figure 77, item 2**) on both sides of the power transfer.

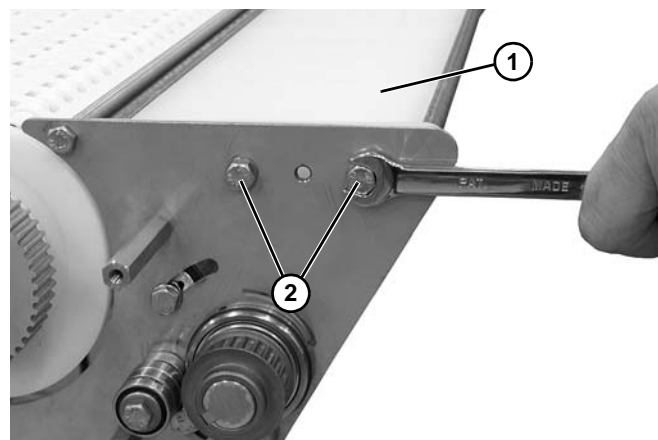


Figure 77

Preventive Maintenance and Adjustment

8. Guide belt (**Figure 78, item 1**) through idler assembly. Route the belt under the sprocket (**Figure 78, item 2**) and over idler assembly (**Figure 78, item 3**).

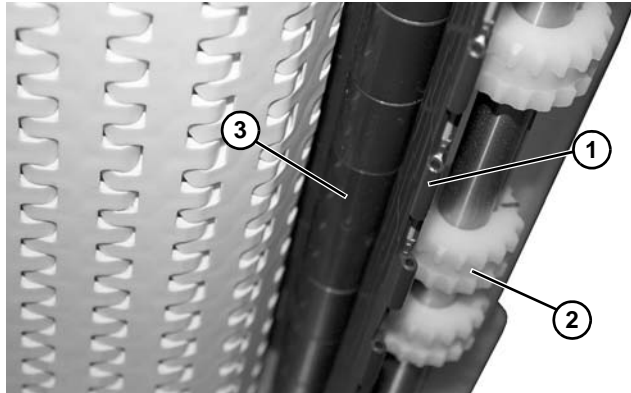


Figure 78

9. Bring ends of belt together and install pin (**Figure 79, item 1**).



Figure 79

10. Slide idler assembly within slot (**Figure 80, item 1**) to remove excess slack from belt (**Figure 80, item 2**). Tighten hex head screws (**Figure 80, item 3**).

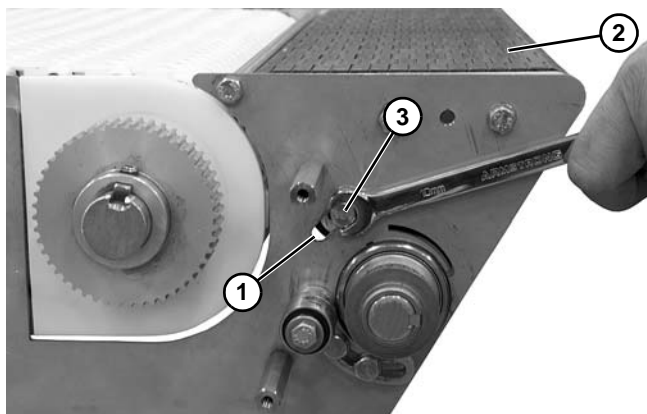


Figure 80

11. Rotate drive shaft (**Figure 81, item 1**) to verify tightness of belt (**Figure 81, item 2**). Belt should turn freely. Loosen hex head screw (**Figure 81, item 3**) on both sides and adjust, if necessary.

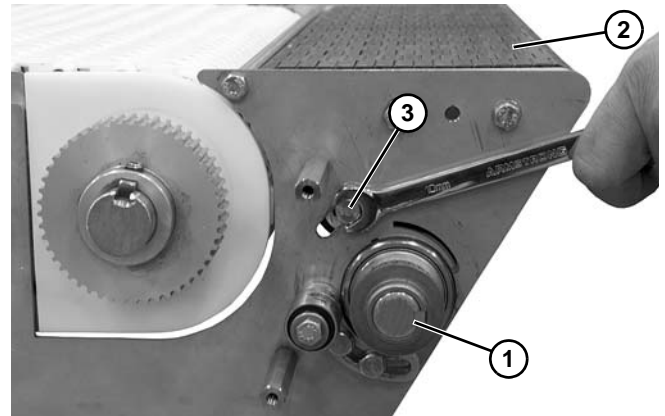


Figure 81

12. Route and install belt (**Figure 82, item 1**) as shown. Press up on tensioner (**Figure 82, item 2**) and tighten two hex head screws (**Figure 82, item 3**).

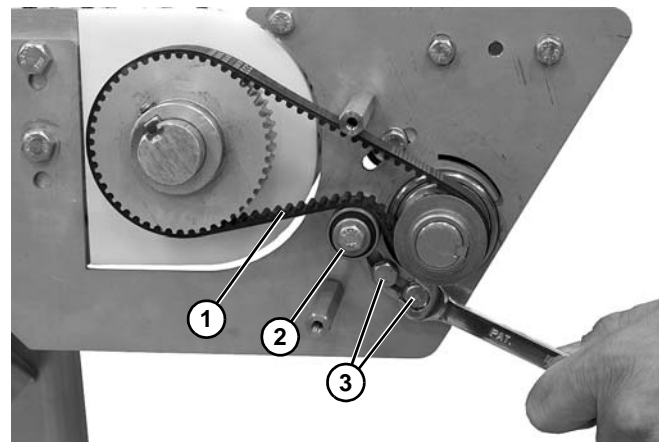


Figure 82

Preventive Maintenance and Adjustment

13. Install cover (**Figure 83, item 1**) with two hex head screws (**Figure 83, item 2**).

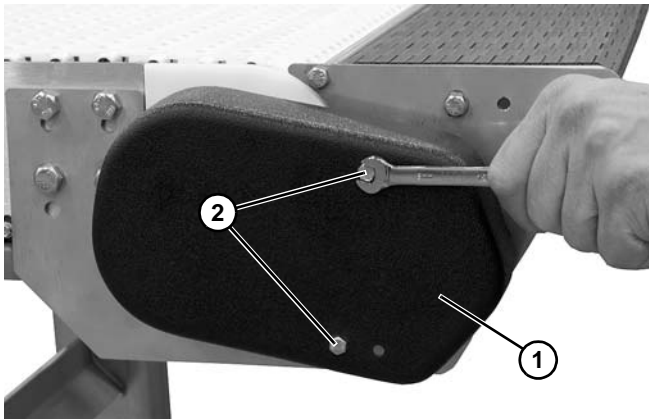


Figure 83

14. Adjust height as needed by loosening two hex head screws (**Figure 84, item 1**) on both sides of the power transfer. Tighten screws.

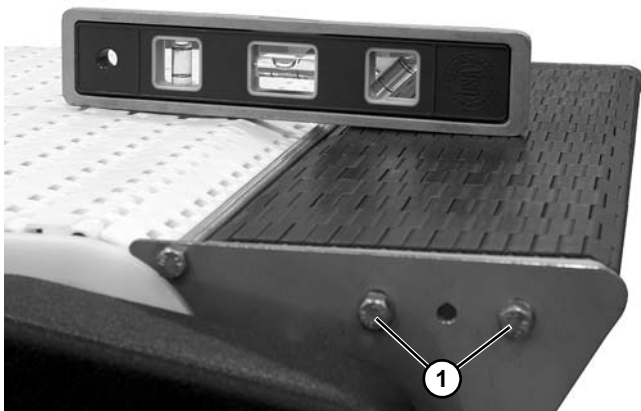


Figure 84

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 19. Follow steps 1 through 7.
2. Twist the bearing out (**Figure 85, item 1**).

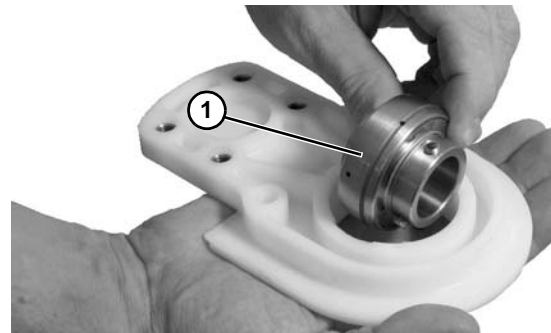


Figure 85

3. Replace the bearing.

Preventive Maintenance and Adjustment

Gravity Take-Up

Removal

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 86, item 1).

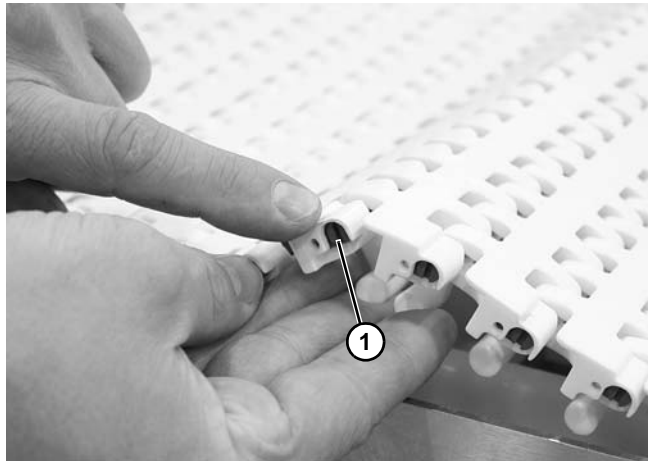


Figure 86

2. Insert a flat blade screwdriver into the slot on the rod head (Figure 87, item 1) and rotate the rod head counterclockwise to unlock. Remove the belt rod.

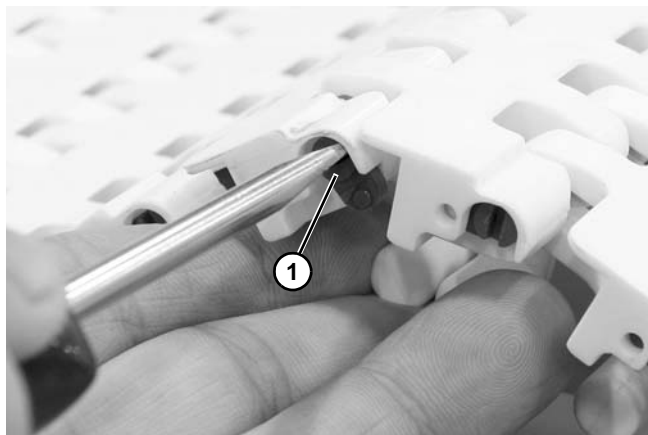


Figure 87

3. Disconnect the ends of the belt.

4. Remove two screws (Figure 88, item 1) and belt guide (Figure 89, item 2). Repeat on opposite side.

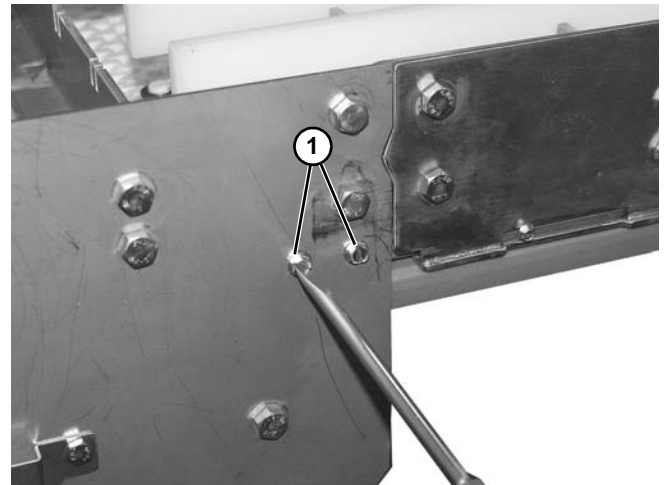


Figure 88

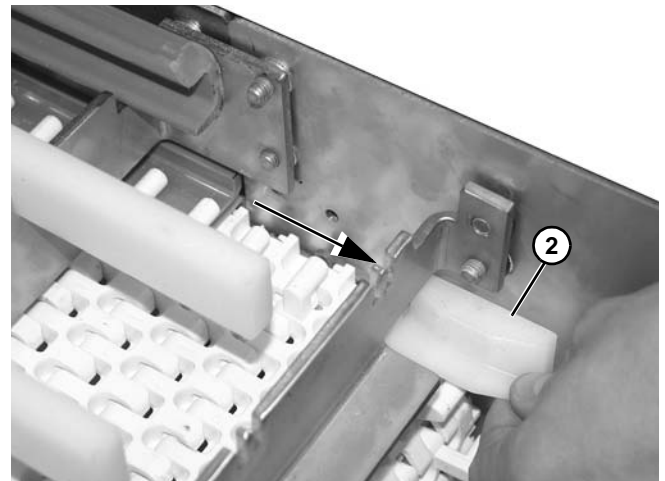


Figure 89

5. Remove two hex head screws (Figure 90, item 1) on each side, and remove guard plate (Figure 90, item 2).

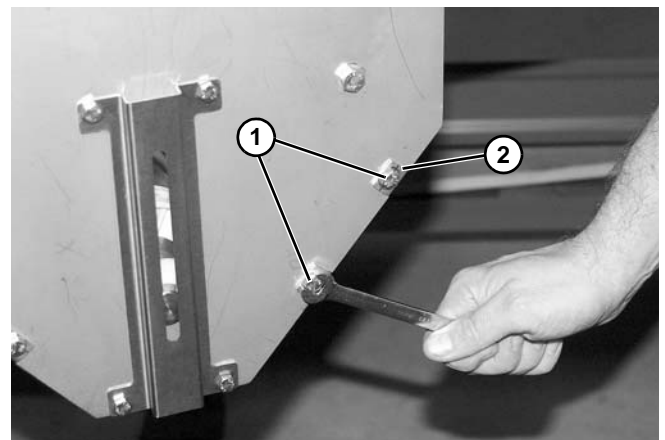


Figure 90

Preventive Maintenance and Adjustment

6. Remove four hex head screws (**Figure 91, item 1**), and remove guard (**Figure 91, item 2**). Repeat on opposite side.

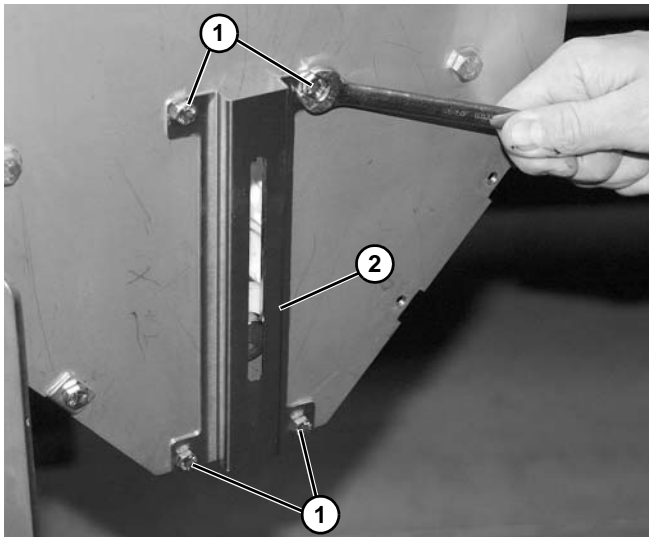


Figure 91

7. Remove the end of the belt from around the gravity take-up (**Figure 92, item 1**).

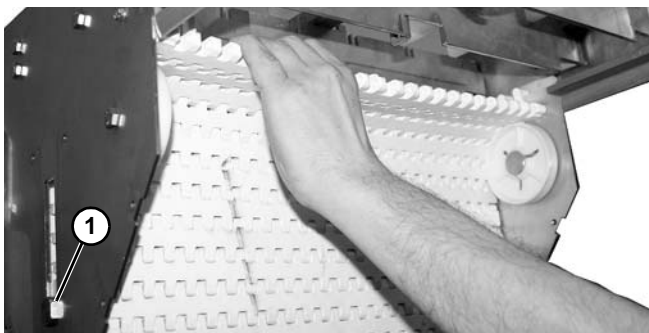


Figure 92

8. Tilt one end down and the opposite end upward, and remove gravity take-up assembly (**Figure 93, item 1**).

NOTE

*Be careful as you lower take-up assembly.
Parts are loose.*

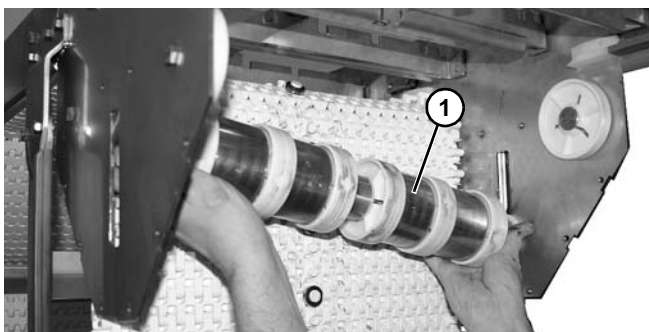


Figure 93

9. Remove bushing (**Figure 94, item 1**) and spacer (**Figure 94, item 2**) from end of take-up assembly.

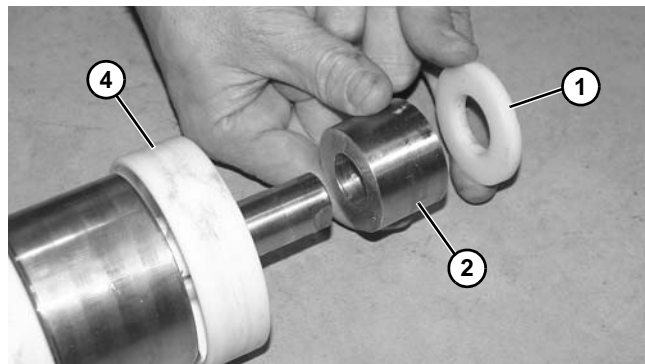


Figure 94

10. Remove idler puck (**Figure 94, item 3**) from end of take-up assembly.
11. Remove remaining components, as needed.
12. Remove hex head screw (**Figure 95, item 1**) and puck (**Figure 96, item 2**). Repeat on opposite side.

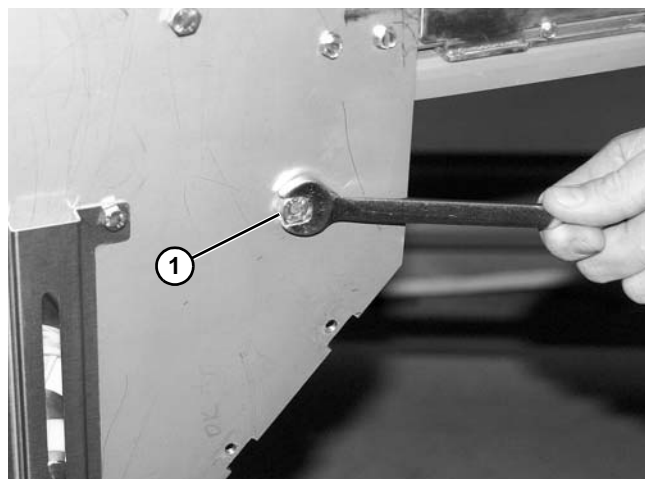


Figure 95

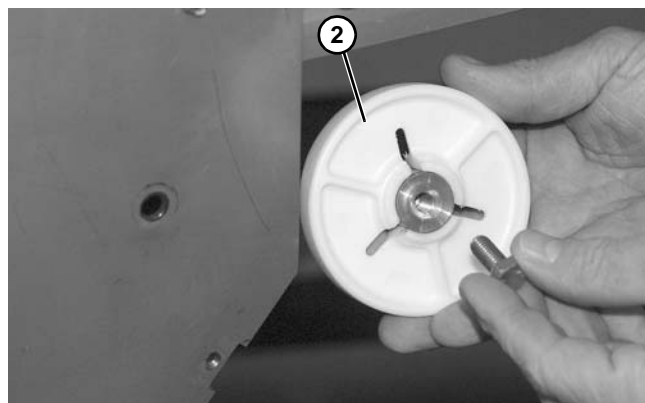


Figure 96

Preventive Maintenance and Adjustment

Installation

1. Install puck (Figure 98, item 1) with hex head screw (Figure 97, item 2). Repeat on opposite side.

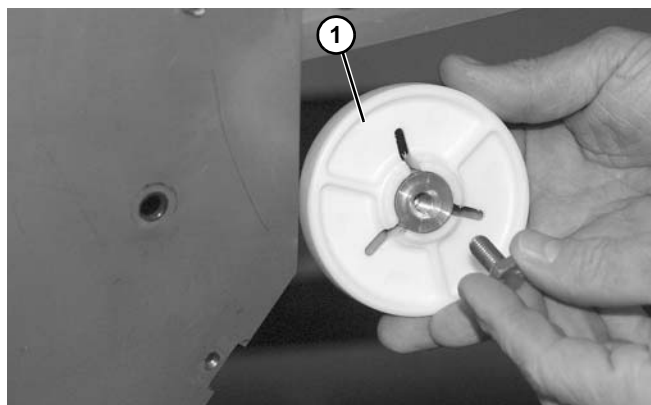


Figure 97

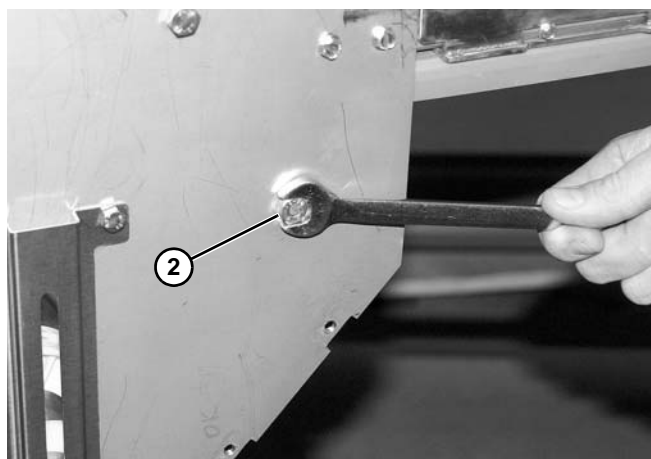


Figure 98

2. Install idler puck (Figure 99, item 1) onto the end of take-up assembly.

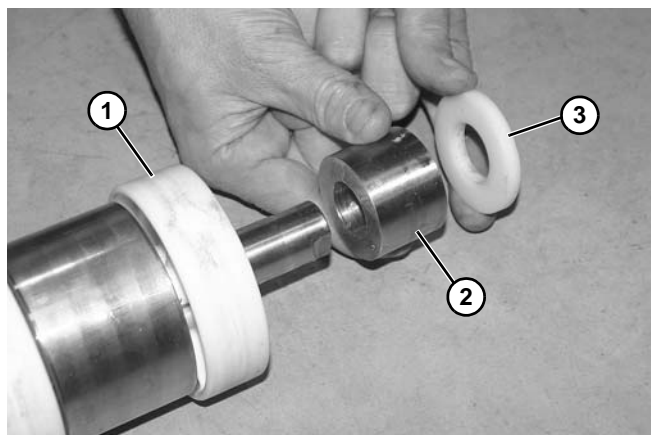


Figure 99

3. Install spacer (Figure 99, item 2) and bushing (Figure 99, item 3) onto the end of take-up assembly.

4. Tilt one end down and the opposite end upward, and install gravity take-up assembly (Figure 100, item 1).

NOTE

Be careful as you raise take-up assembly into position. Parts are loose.

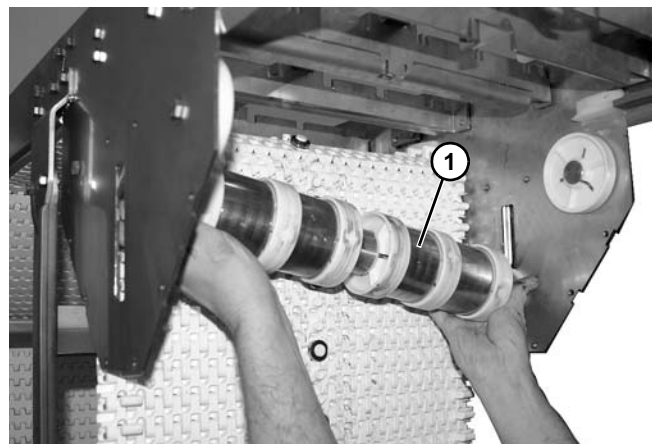


Figure 100

5. Lower take-up assembly so that shaft tapered end (Figure 101, item 1) fits into slotted end (Figure 101, item 2) on frame.

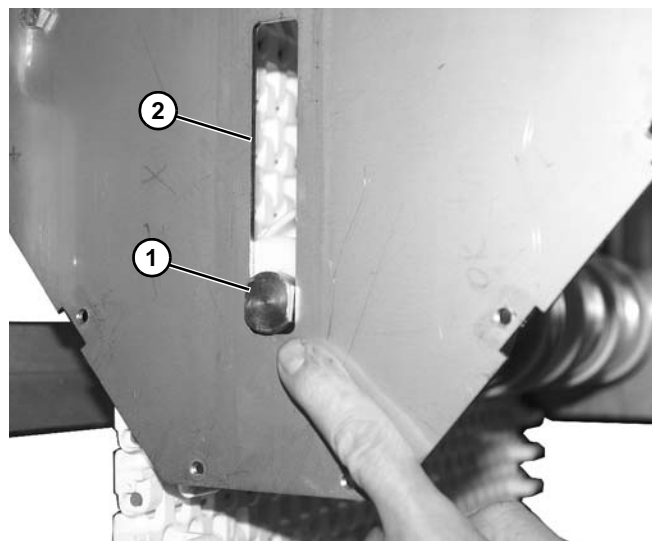


Figure 101

Preventive Maintenance and Adjustment

6. Install belt guide (Figure 102, item 1) with two screws (Figure 103, item 2). Repeat on opposite side.

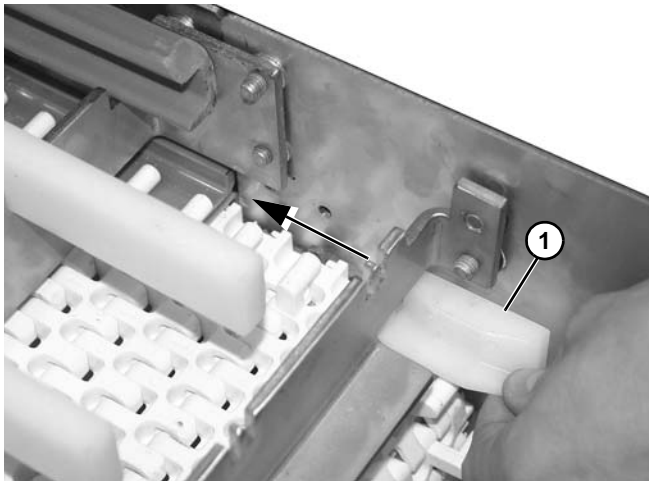


Figure 102

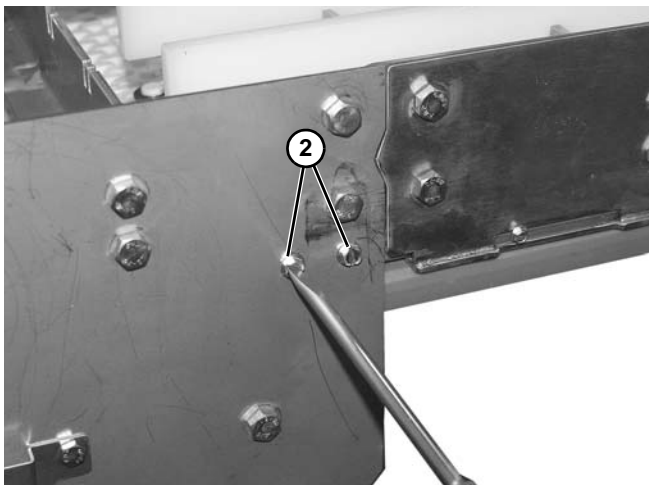


Figure 103

7. Install the end of the belt around the gravity take-up (Figure 104, item 1) and to the opposite end of conveyor.

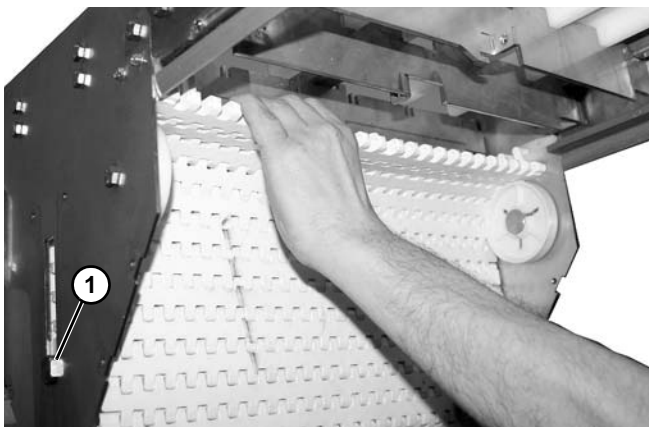


Figure 104

NOTE

Be certain that belt tab (Figure 105, item 1) rides onto belt guide (Figure 105, item 2).

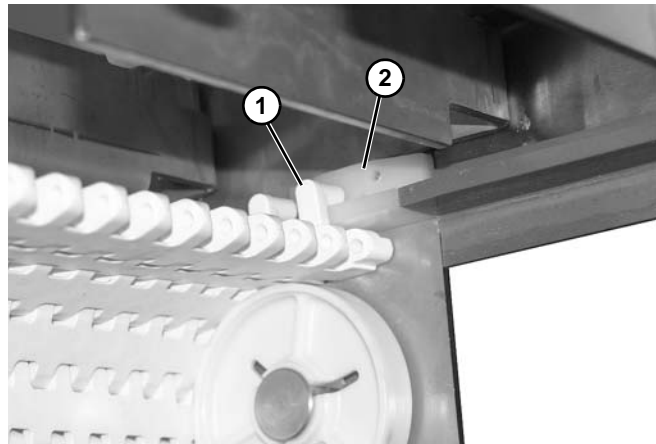


Figure 105

8. Continue feeding belt around the gravity take-up (Figure 106, item 1).

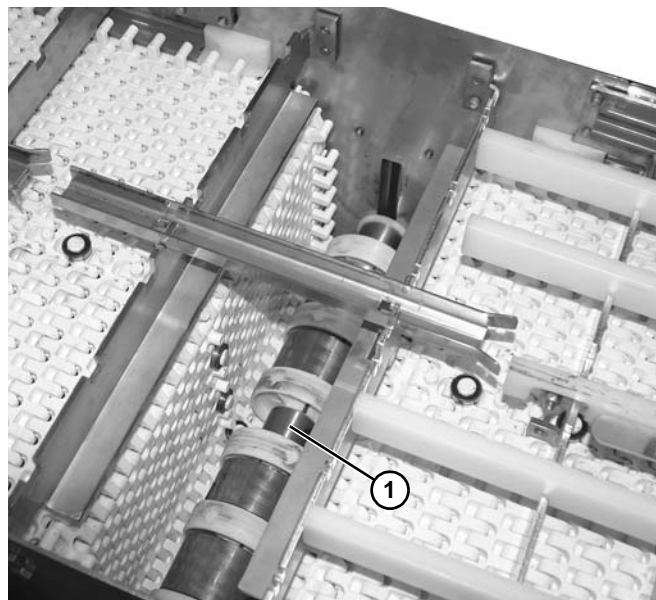


Figure 106

Preventive Maintenance and Adjustment

9. Bring the ends of the belt together (**Figure 107**).



Figure 107

10. Insert the belt rod (**Figure 108, item 1**) and push it through the belt.

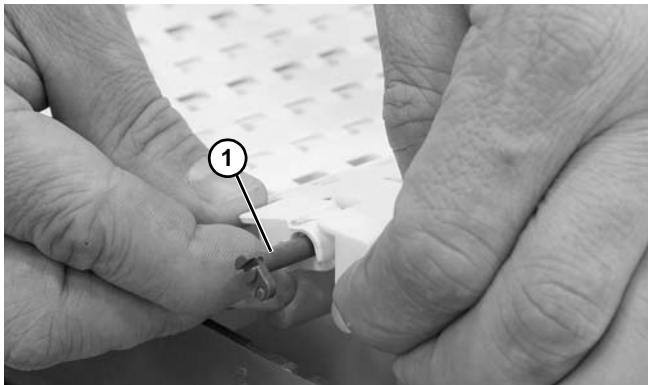


Figure 108

11. Insert a flat blade screwdriver into the slot on the rod head (**Figure 109, item 1**). Rotate rod head clockwise into the locked position (**Figure 109, item 2**).

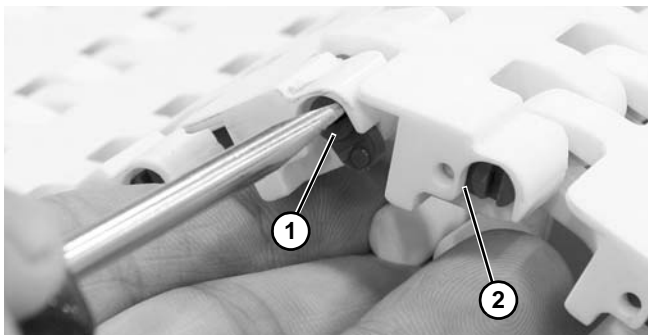


Figure 109

12. Install guard (**Figure 110, item 1**), with four hex head screws (**Figure 110, item 2**). Repeat on opposite side.

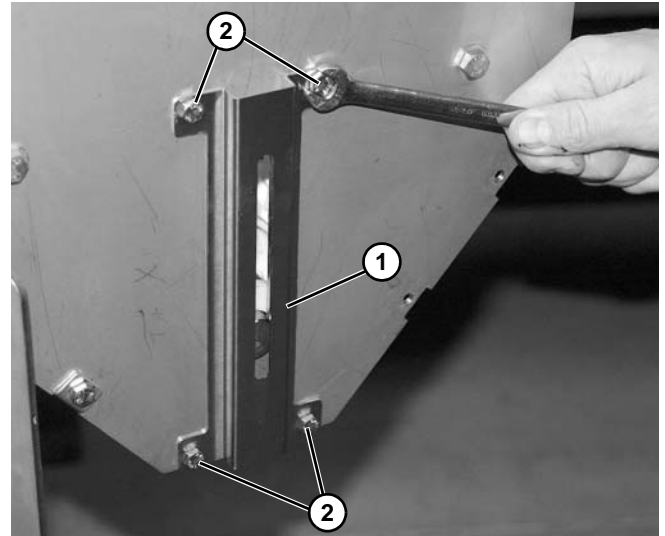


Figure 110

13. Install guard plate (**Figure 111, item 1**) with two hex head screws (**Figure 111, item 2**) on each side.

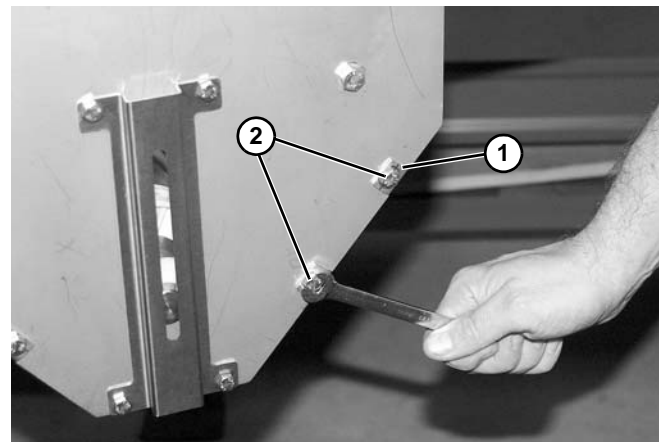



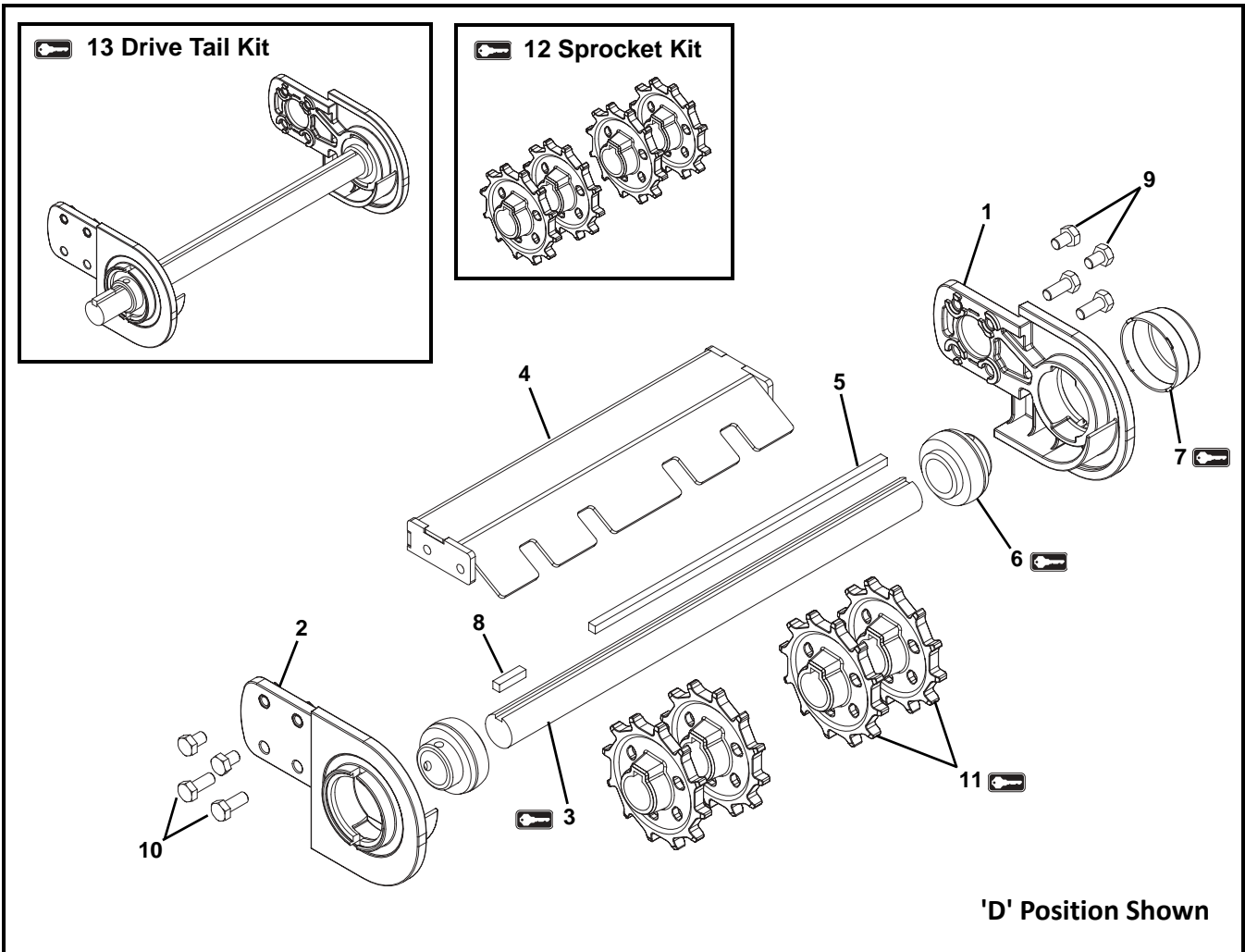
Figure 111

Notes




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

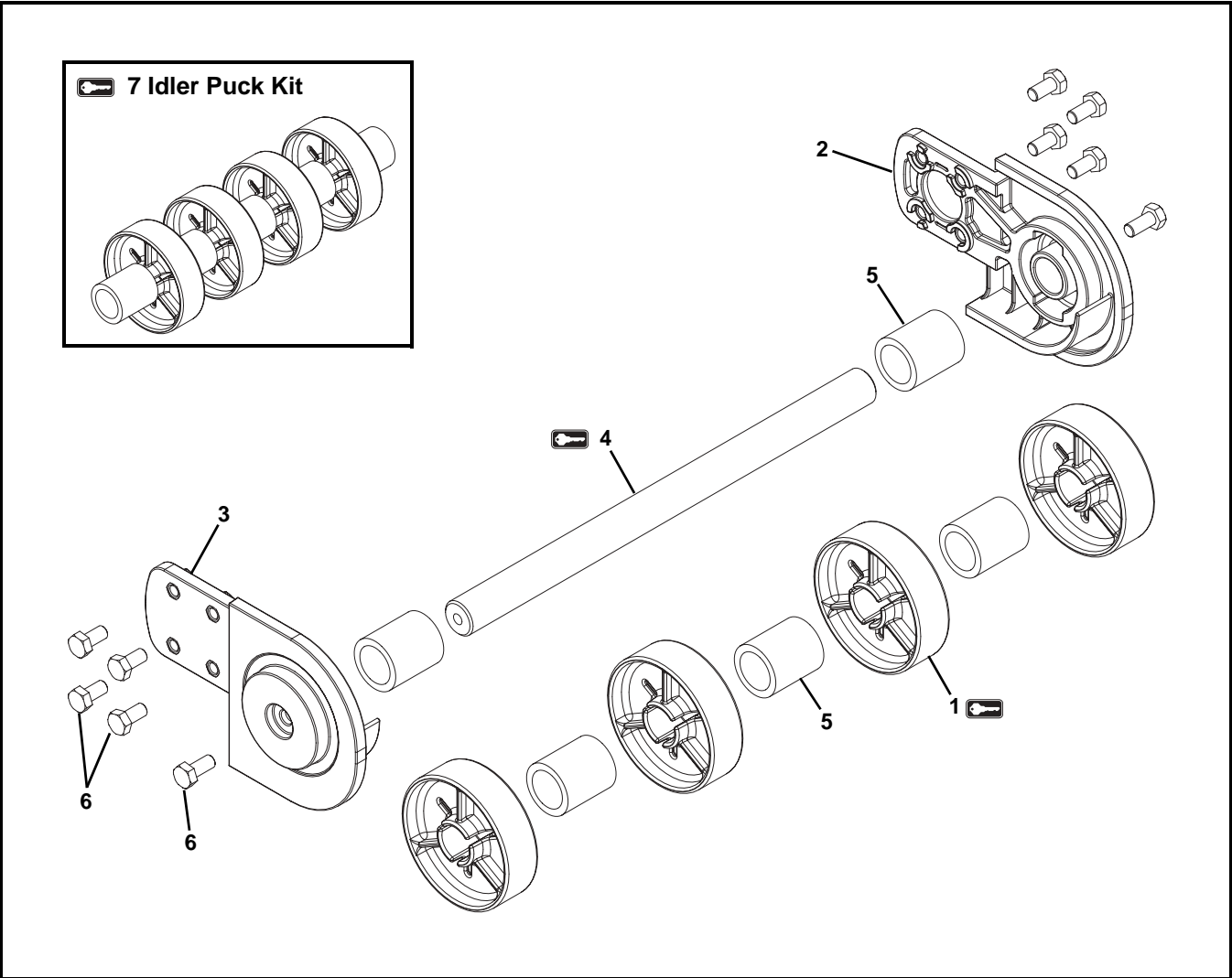


Item	Part Number	Description
1	516809	Headplate, Left Hand
2	516811	Headplate, Right Hand
3	516815-K0- <u>WW</u>	Spindle
	516815-KK- <u>WW</u>	Dual Shaft Spindle
4	516839- <u>WW</u>	Support Bracket
5	532121- <u>LLLLL</u>	Square Key
6	802-161	Bearing
	807-1454	Bearing Cap
8	912-108SS	Square Key, .25" 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>	Drive Tail Kit (Includes items 1, 2, 3, 5, 6 and 8)
	520362-KK- <u>WW</u>	Dual Shaft Drive Tail Kit (Includes items 1, 2, 3, 5, 6 and 8)
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
See Specifications chart on page 4 for conveyor belt widths.		
<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

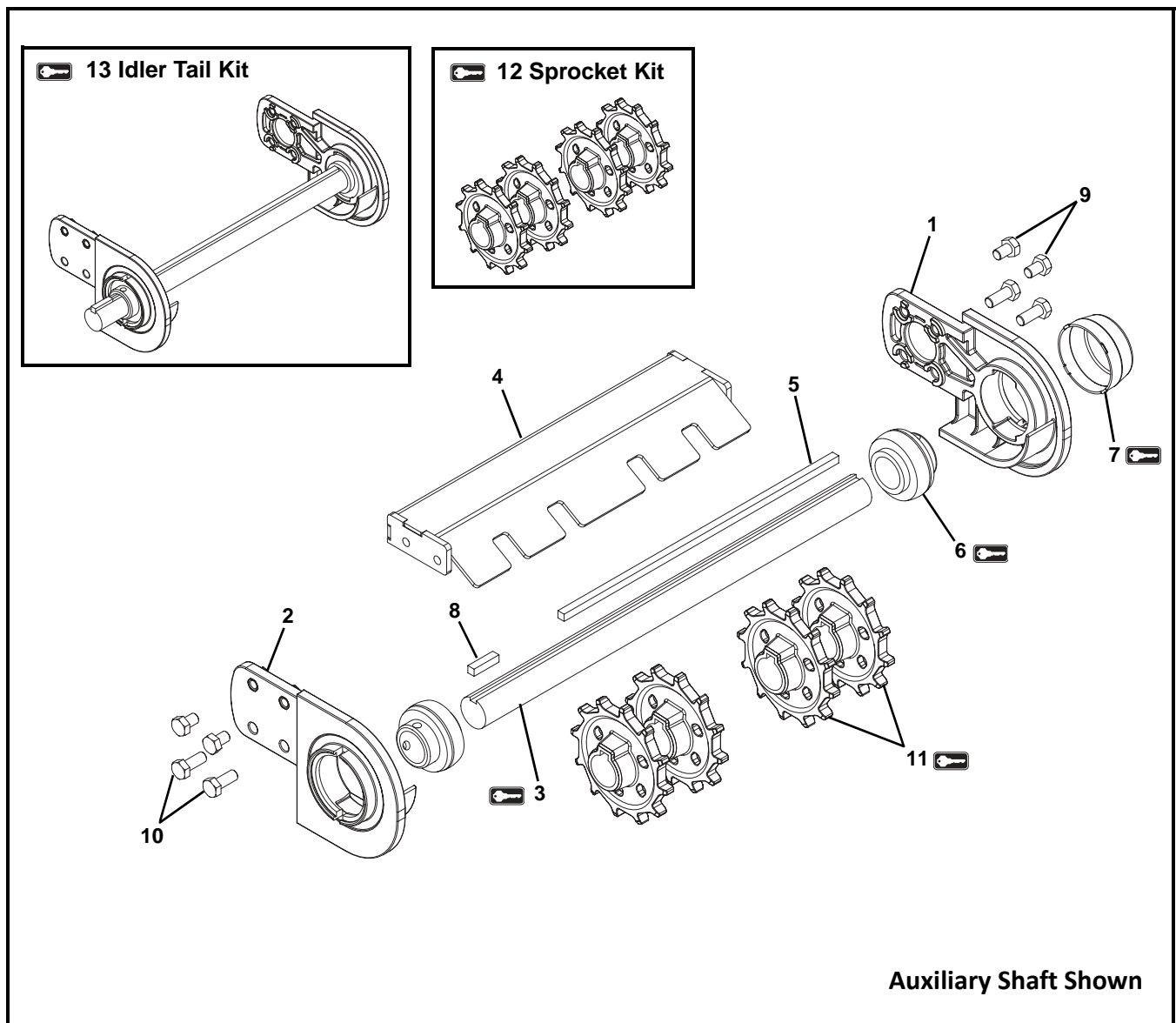
Idler Tail



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)

WWW = Conveyor width reference in inches 06, 12, 18, 24
See Specifications chart on page 4 for conveyor belt widths.
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

Idler Tail with Auxiliary Shaft



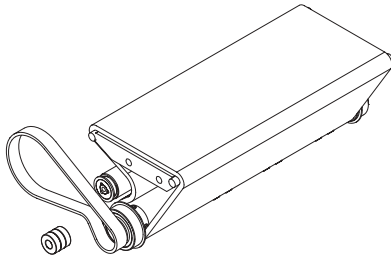
Item	Part Number	Description
1	516809	Headplate, Left Hand
2	516811	Headplate, Right Hand
3	516815-K0- <u>WW</u>	Spindle
4	516839- <u>WW</u>	Support Bracket
5	532121- <u>LLLLL</u>	Square Key
6	802-161	Bearing
7	807-1454	Bearing Cap
8	912-108SS	Square Key, .25" x 1.00"
9	960812MSS	Hex Head Cap Screw, 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>	Idler Tail Kit (Includes items 1, 2, 3, 5, 6 and 8)
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
See Specifications chart on page 4 for conveyor belt widths.		
<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		

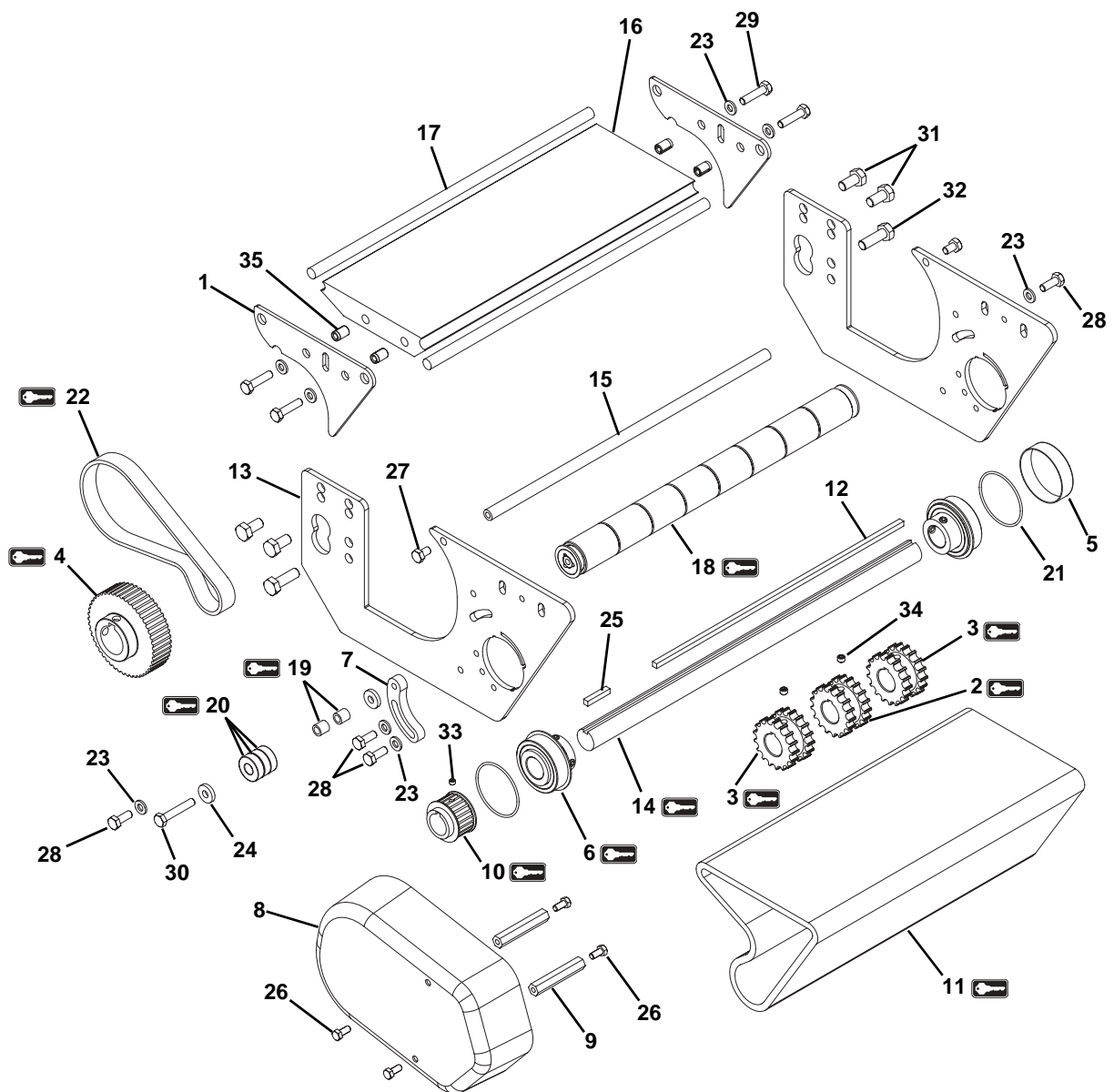
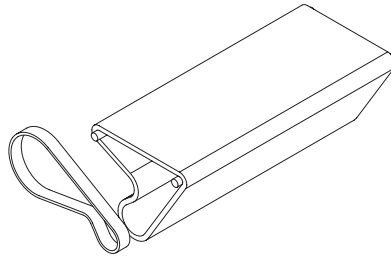
Service Parts

Power Transfer

 37 Power Transfer Kit



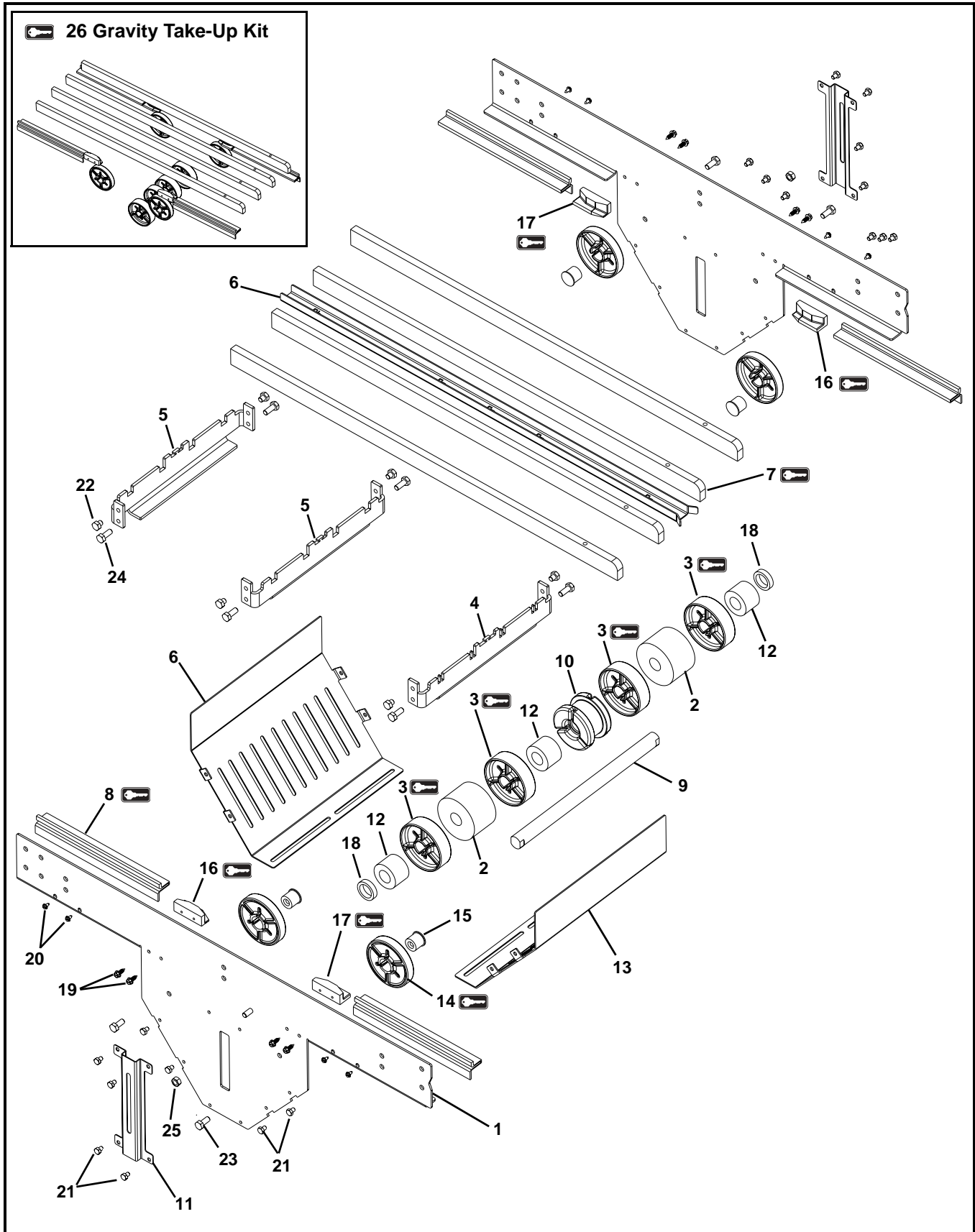
 36 Belt Kit










Item	Part Number	Description
1	203229	Plate
2	203765	Center Sprocket
3	203765P	Sprocket
4	509855	Pulley 48T
5	514644	Bearing Cover
6	514647	Bearing
7	516897	Tensioner
8	516981	Cover
9	516982	Spacer
10	518497	Pulley 22T
11	2P- <u>WW</u> /01	Power Transfer Belt
12	350789- <u>WW</u>	Square Key
13	516888D	Side Plate
14	516891- <u>WW</u>	Spindle
15	516896- <u>WW</u>	Pinch Guard
16	516901- <u>WW</u>	Support Bar
17	516979- <u>WW</u>	Bar
18	518498- <u>WW</u>	Idler Assembly
19	801-139	Nylon Bearing
20	802-123	Bearing
21	812-097	O-Ring
22	814-096	Belt
23	911-222	Washer
24	911-527	Washer
25	912-080SS	Square Key, .1875" x 1.00"
26	960510MSS	Hex Head Cap Screw, M5-0.80 x 10 mm
27	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
28	960616MSS	Hex Head Cap Screw, M6-1.00 x 16 mm
29	960625MSS	Hex Head Cap Screw, M6-1.00 x 25 mm
30	960635MSS	Hex Head Cap Screw, M6-1.00 x 35 mm
31	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
32	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
33	970504MSS	Set Cup Screw, M5-0.80 x 5 mm
34	970605M	Set Cup Screw, M6-1.00 x 5 mm
35	990621M	Nut
36	520381- <u>WW</u>	Belt Kit (Includes items 10, 16 and 21)
37	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		
See Specifications chart on page 4 for conveyor belt widths.		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

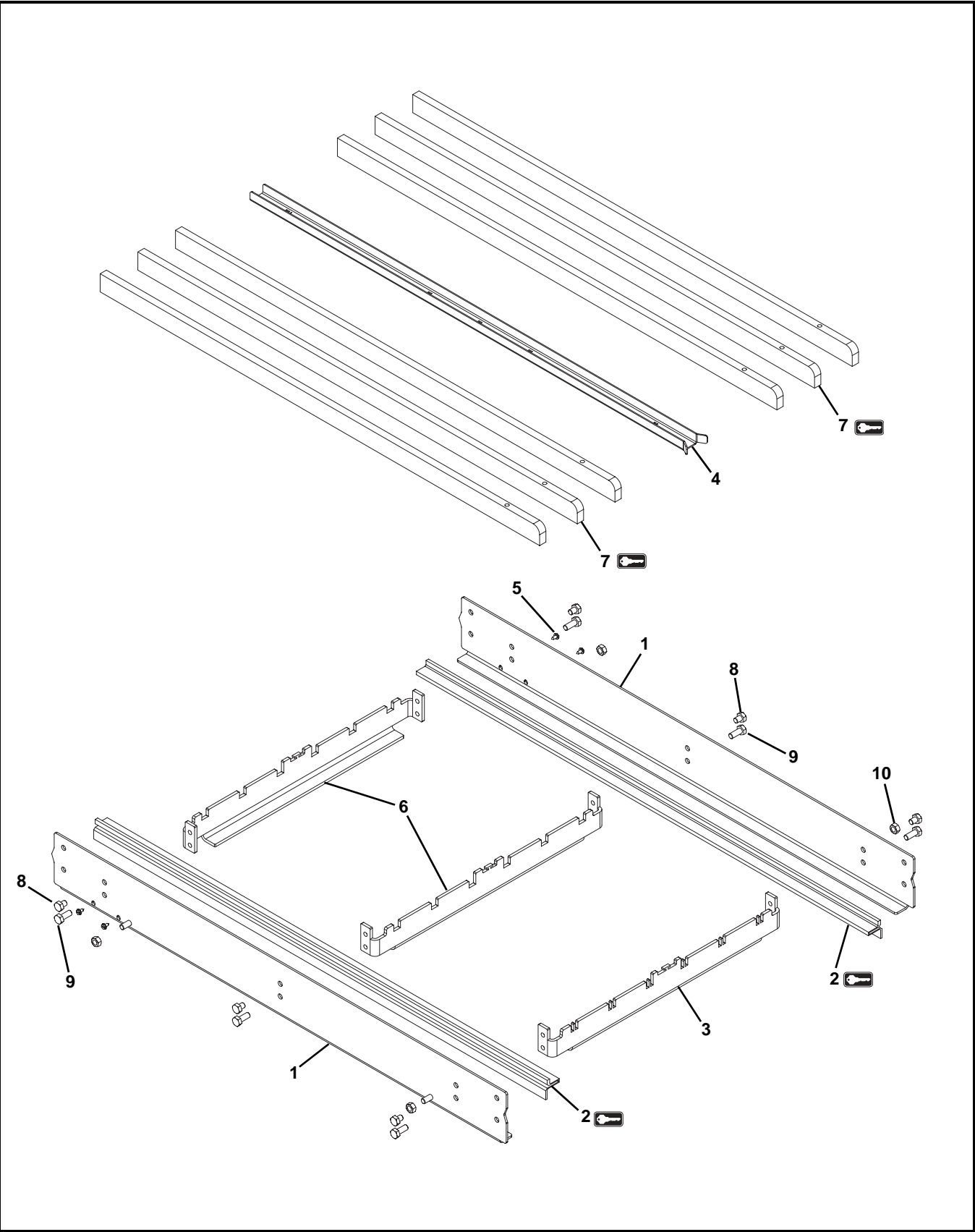
Gravity Take-Up





Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	350473	Weight for 12" (305 mm) Wide and Wider Conveyors
3 	506296	Idler Puck
4	515586- <u>WW</u>	Crossmember with Pins
5	515587- <u>WW</u>	Crossmember
6	515597- <u>LLLLL</u>	Bearing Rail
7 	516802-S- <u>LLLLL</u>	Bed Rail
8 	517579- <u>LLLLL</u>	Wearstrip
9	520345- <u>WW</u>	Shaft
10	520346	Weight
11	520347	End Guard
12	520348	Spacer
13	520349- <u>WW</u>	Slotted Guard Plate
14 	520350	Puck
15	520351	Idler Stub
16 	520352	Belt Guide - Left Hand
17 	520353	Belt Guide - Right Hand
18	532127- <u>LLLLL</u>	Bushing
19	807-3052	Self-Tapping Hex Screw, 12 x .625"
20	807-3341	Self-Tapping Hex Screw, 8-18 x .375"
21	960608MSS	Hex Head Cap Screw, M6-1.00 x 8 mm
22	960808MSS	Hex Head Cap Screw, M8-1.25 x 8 mm
23	960818MSS	Hex Head Cap Screw, M8-1.25 x 18 mm
24	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
25	990801MSS	Hex Nut for Diagonal Bracing Only
26 	520384- <u>WW</u> - <u>LLLLL</u>	Gravity Take-Up (Includes items 3, 7, 8, 14, 16, and 17)
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
See Specifications chart on page 4 for conveyor belt widths.		
<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

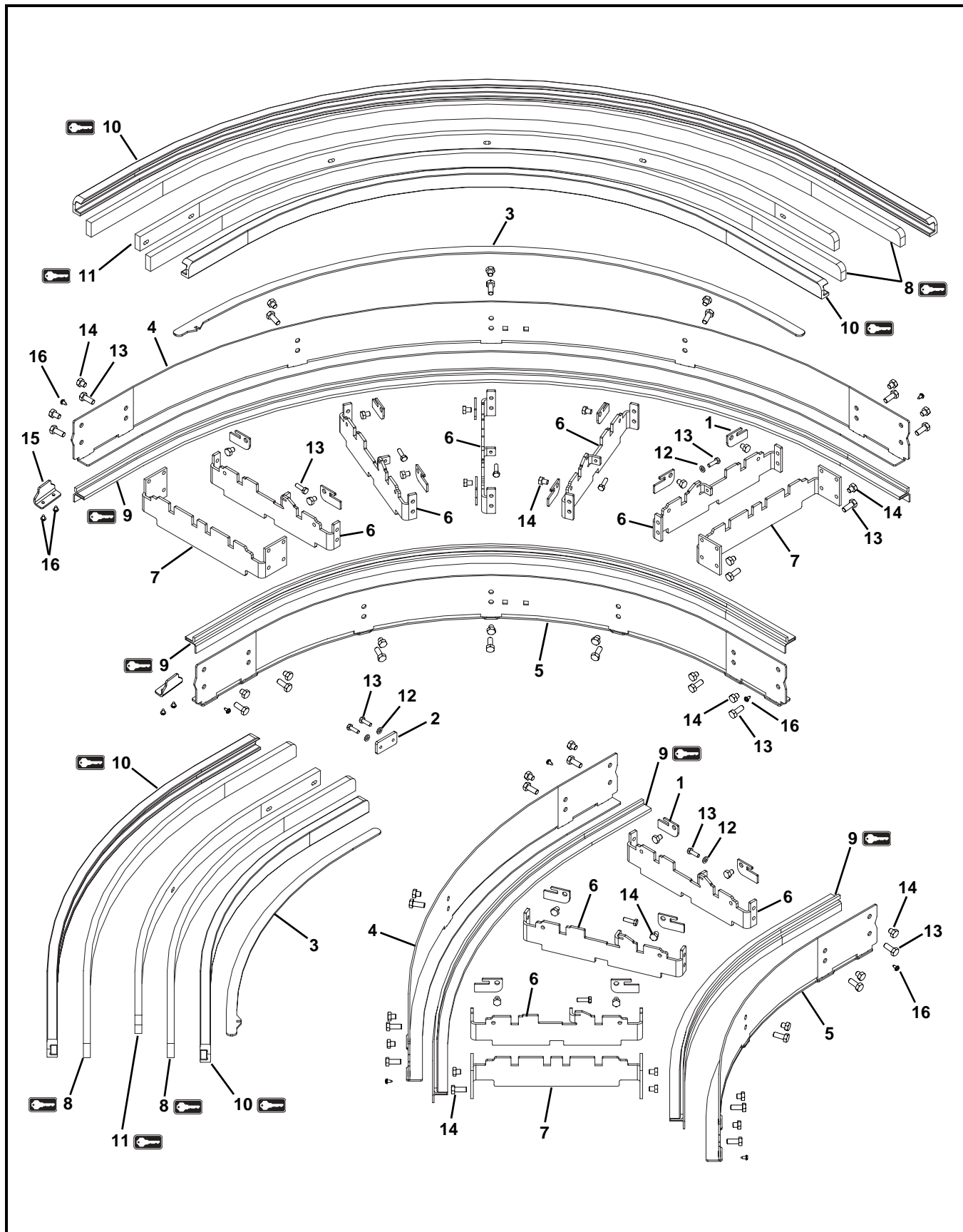
Straight Frame



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2 	517579- <u>LLLLL</u>	Wear Strip
3	520458- <u>WW</u>	Crossmember for frames under 8.89" (226 cm) long
	515586- <u>WW</u>	Crossmember for frames 8.89" (226 cm) long and longer
4	515597- <u>LLLLL</u>	Bearing Rail
5	807-3341	Self Tapping Hex Screw, 8-18 x .375"
6	520459- <u>WW</u>	Crossmember for frames under 8.89" (226 cm) long
	515587- <u>WW</u>	Crossmember for frames 8.89" (226 cm) long and longer
7 	516802-S- <u>LLLLL</u>	Bed Rail
8	960808MSS	Hex Head Cap Screw, M8-1.25 x 8 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		
See Specifications chart on page 4 for conveyor belt widths.		
<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

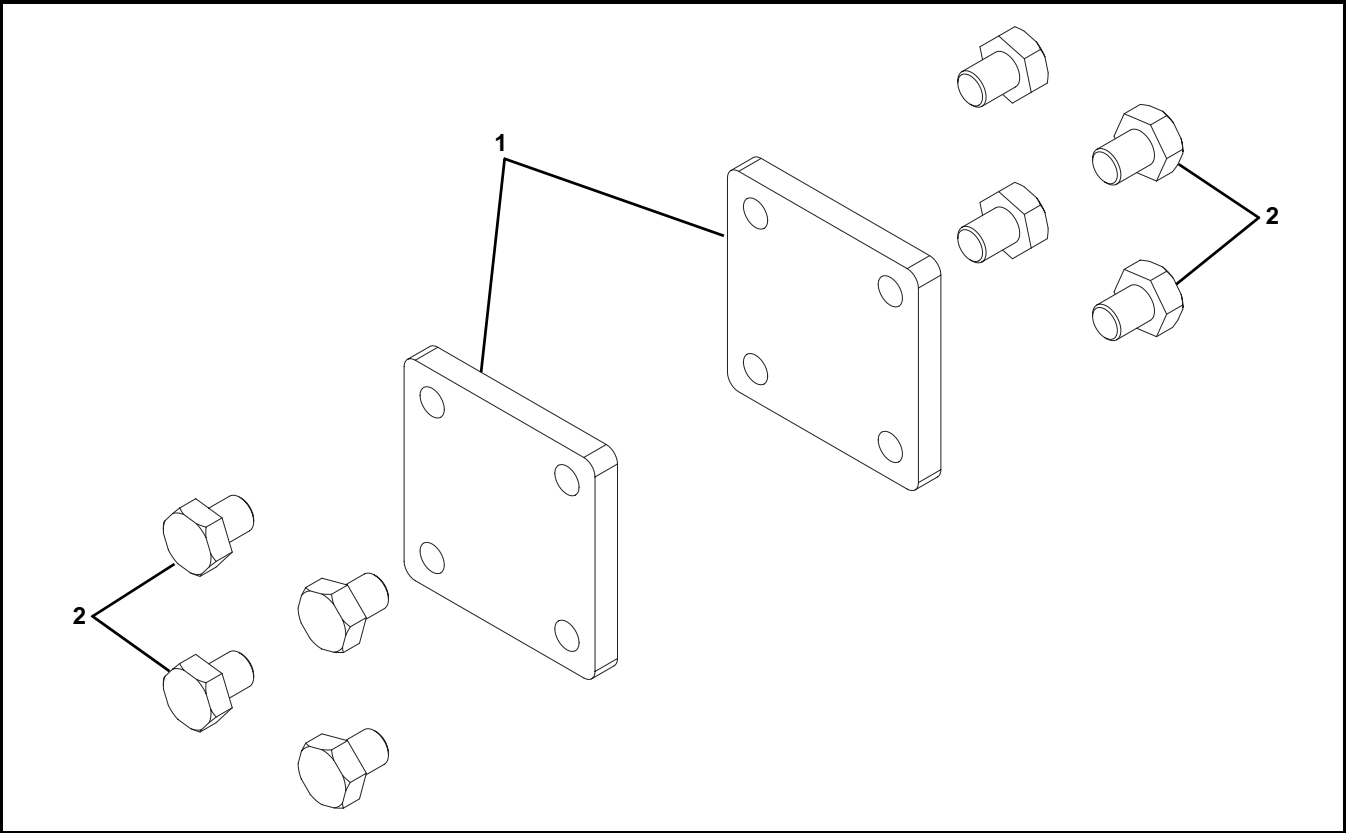
Curve Frame



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-LH</u>	Outer Frame for Left Hand Curve
	515577- <u>WW-AA-RH</u>	Outer Frame for Right Hand Curve
5	515578- <u>WW-AA-LH</u>	Inner Frame for Left Hand Curve
	515578- <u>WW-AA-RH</u>	Inner Frame for Right Hand Curve
6	515589- <u>WW-LH</u>	Crossmember for Left Hand Curve
	515589- <u>WW-RH</u>	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	960808MSS	Hex Head Cap Screw, M8-1.25 x 8 mm
15	520354	Support Bracket (for 135° and 180° Curves Only)
16	807-3341	Self-Tapping Hex Screw, 8-18 x .375"
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
See Specifications chart on page 4 for conveyor belt widths.		
<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

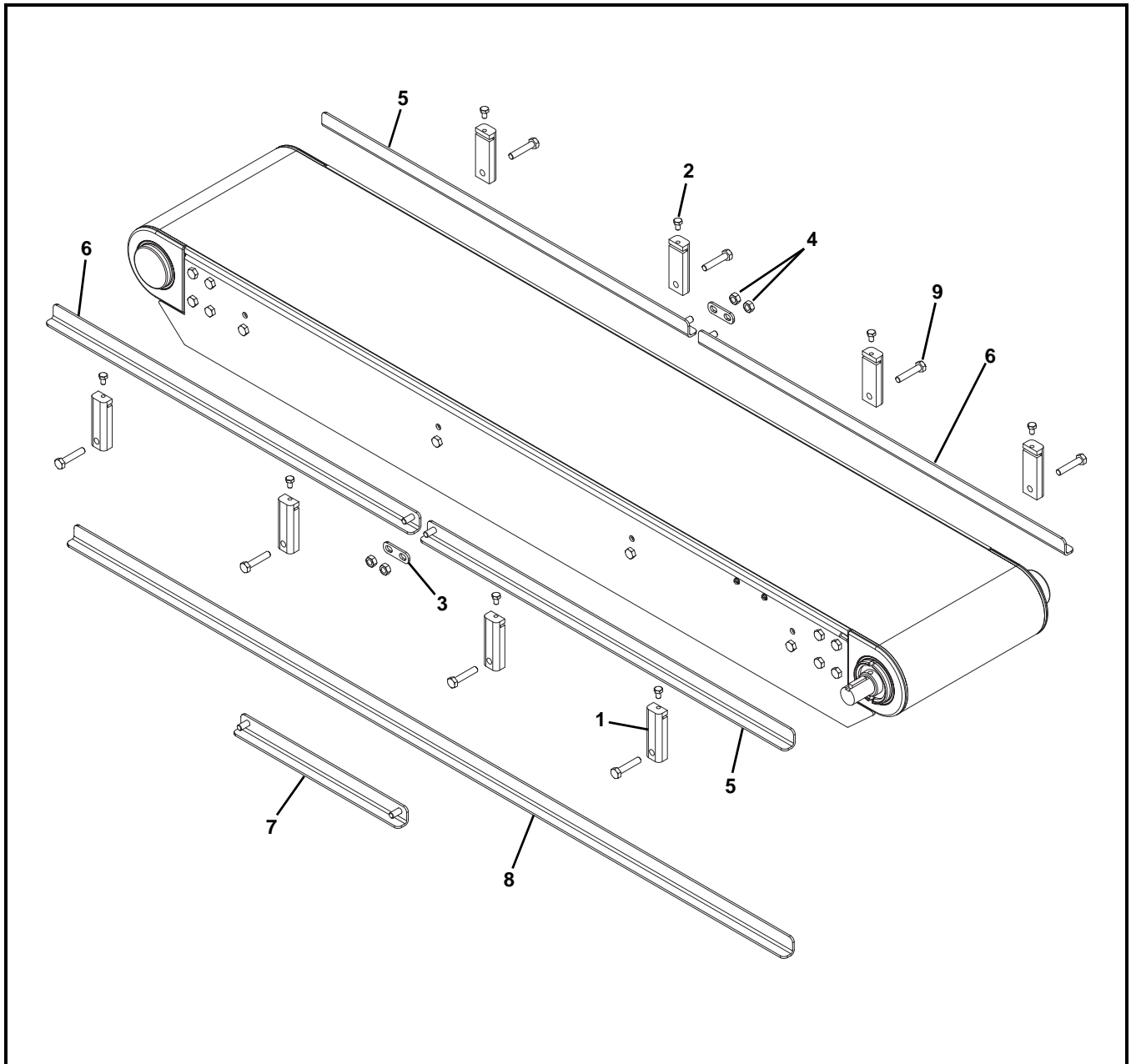
Connecting Assembly



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

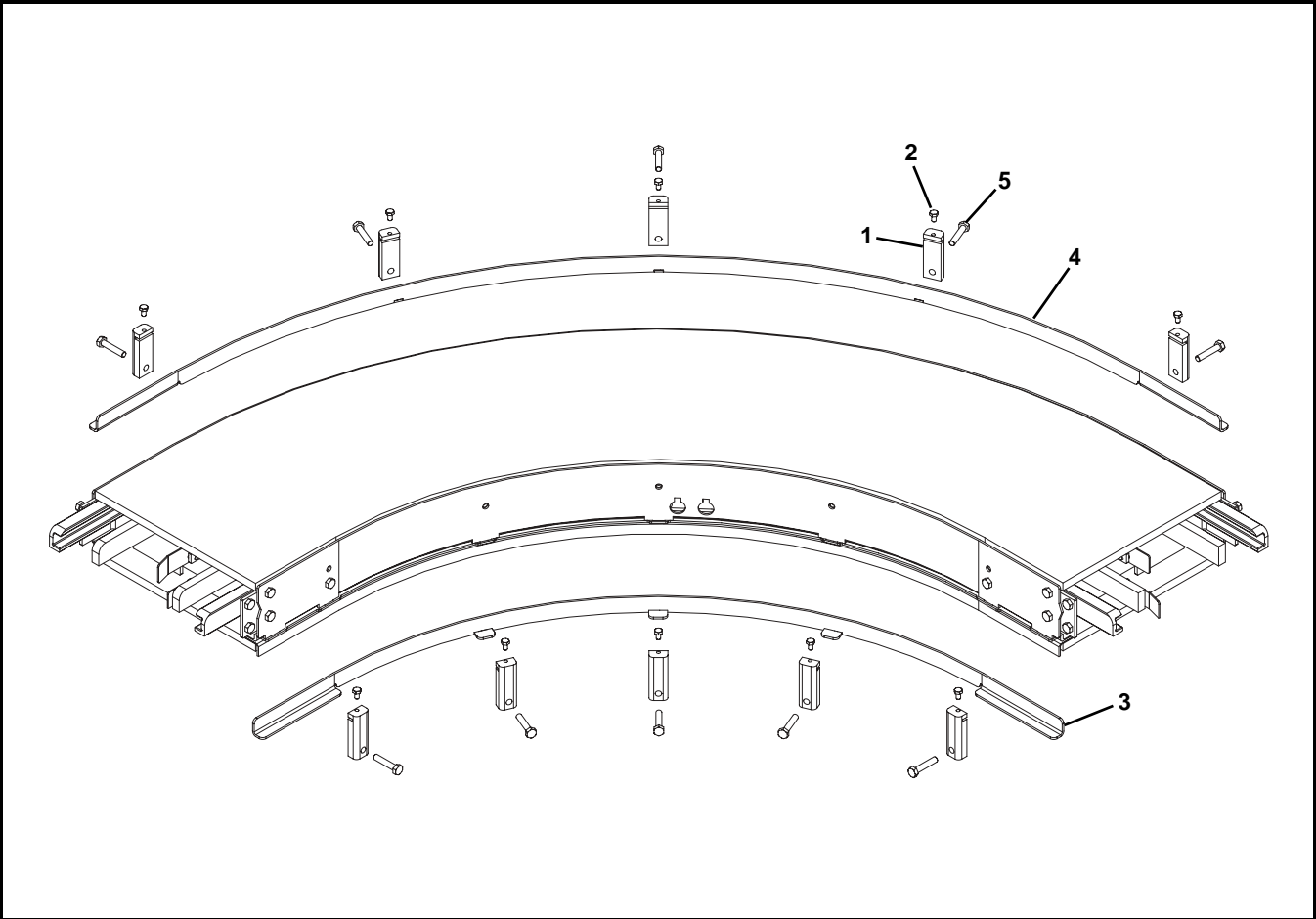


Item	Part Number	Description
1	516999-01	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-01- <u>LLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-01- <u>LLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-01- <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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 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		

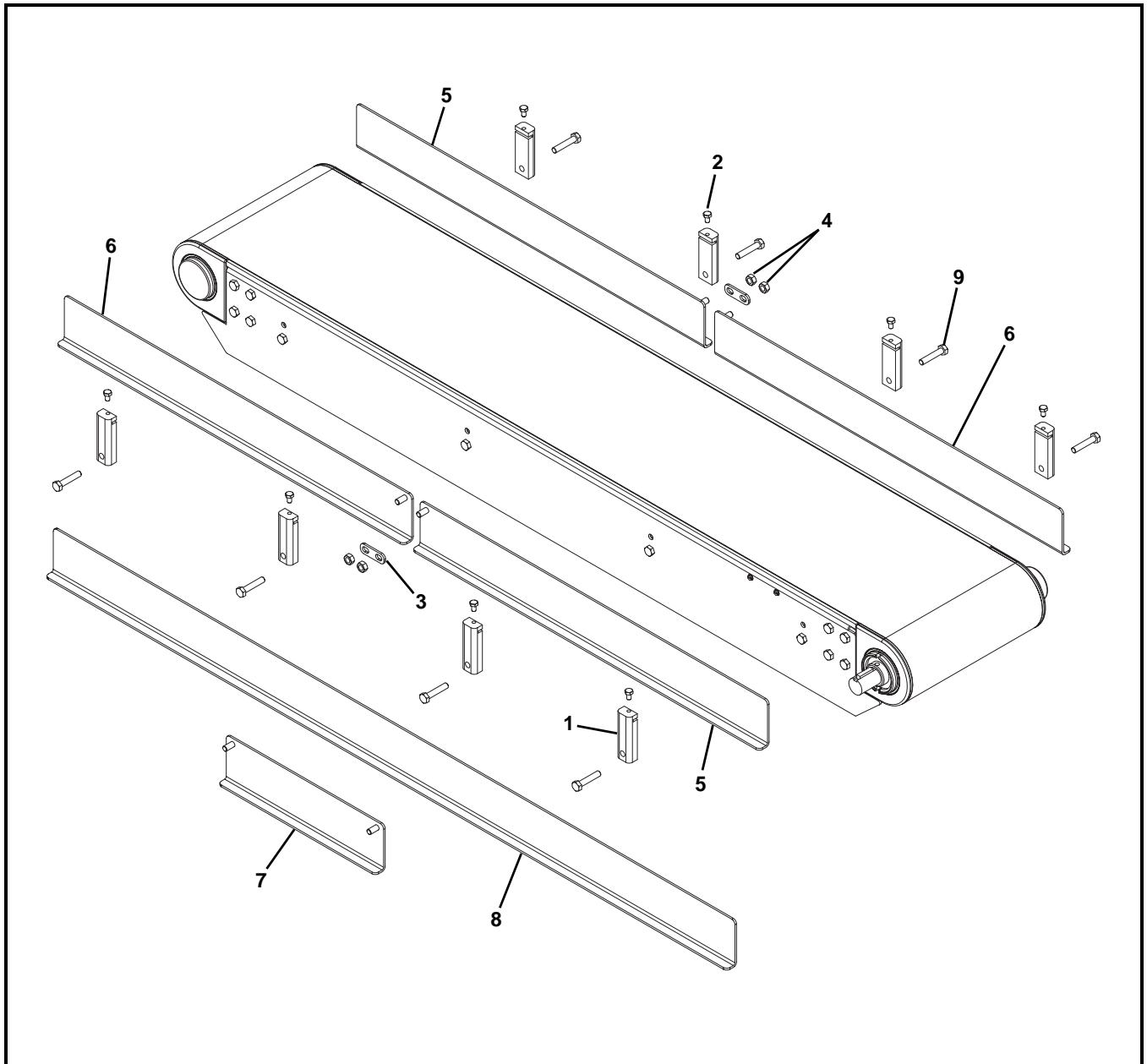
Service Parts

25 mm High Sides for Curve Sections



Item	Part Number	Description
1	516999-01	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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
See Specifications chart on page 4 for conveyor belt widths.		
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

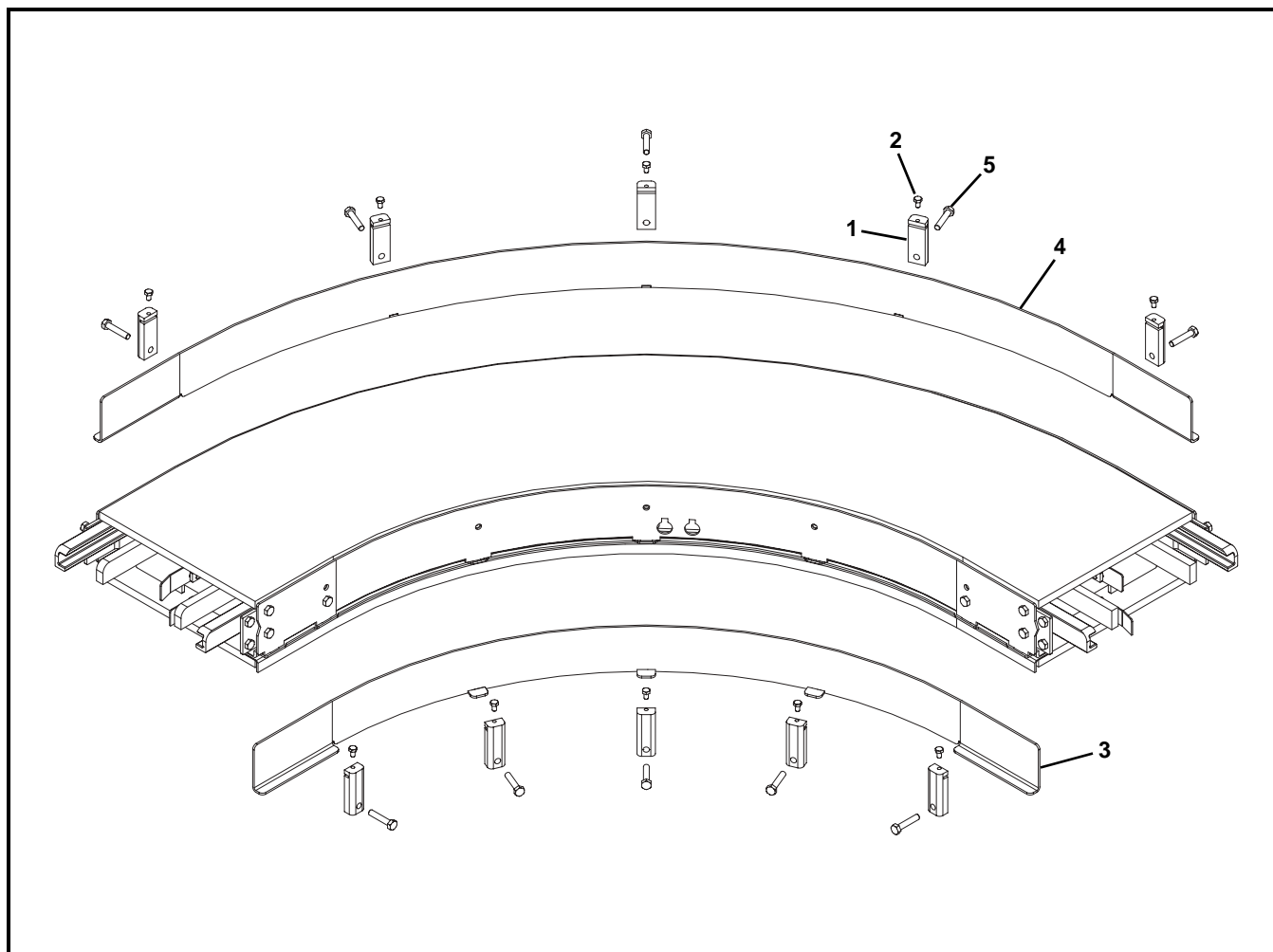


Item	Part Number	Description
1	516999-01	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-03- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-03- <u>LLLLL</u> -RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-03- <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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 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		

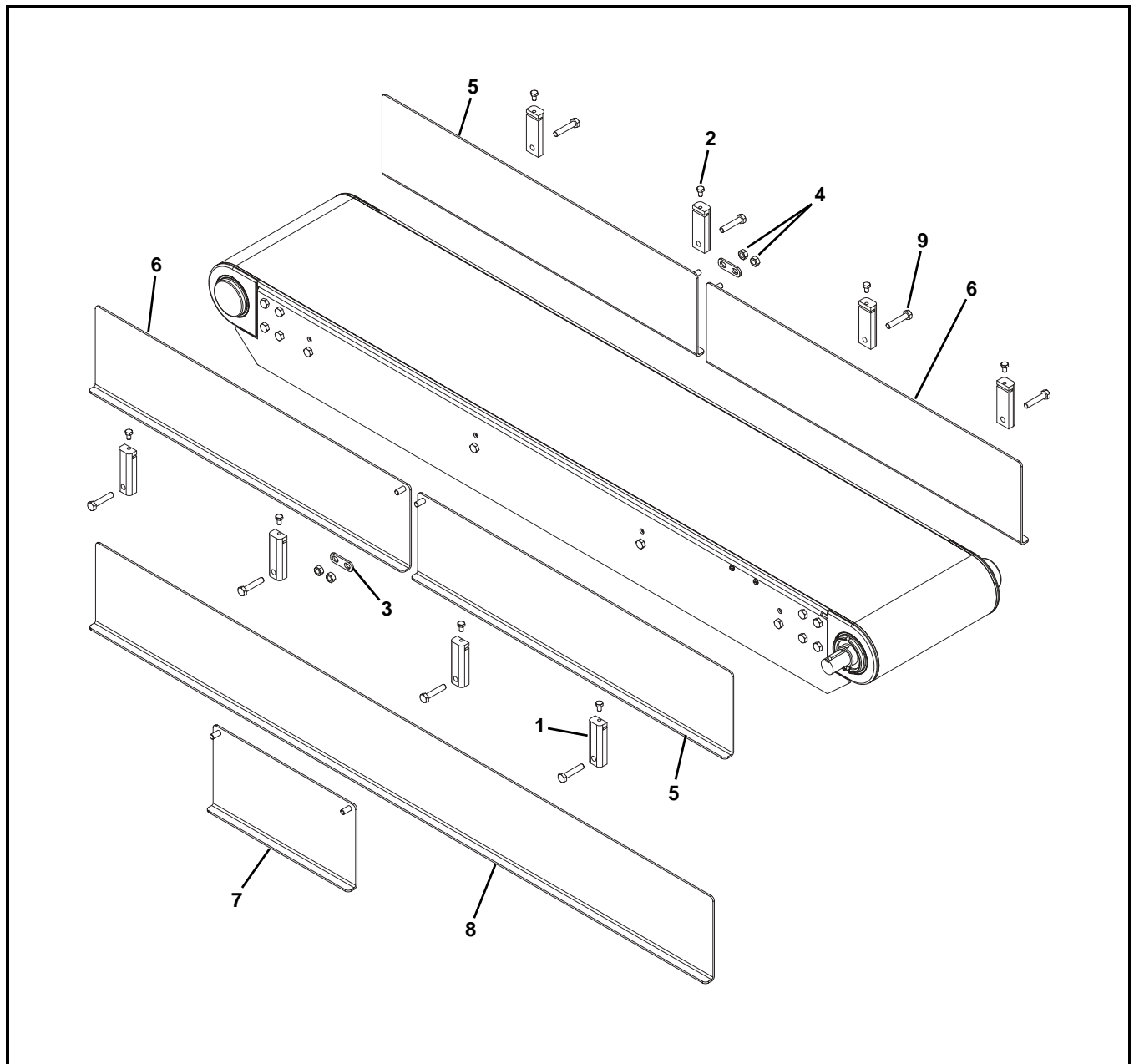
Service Parts

75 mm High Sides for Curve Sections



Item	Part Number	Description
1	516999-01	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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
See Specifications chart on page 4 for conveyor belt widths.		
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

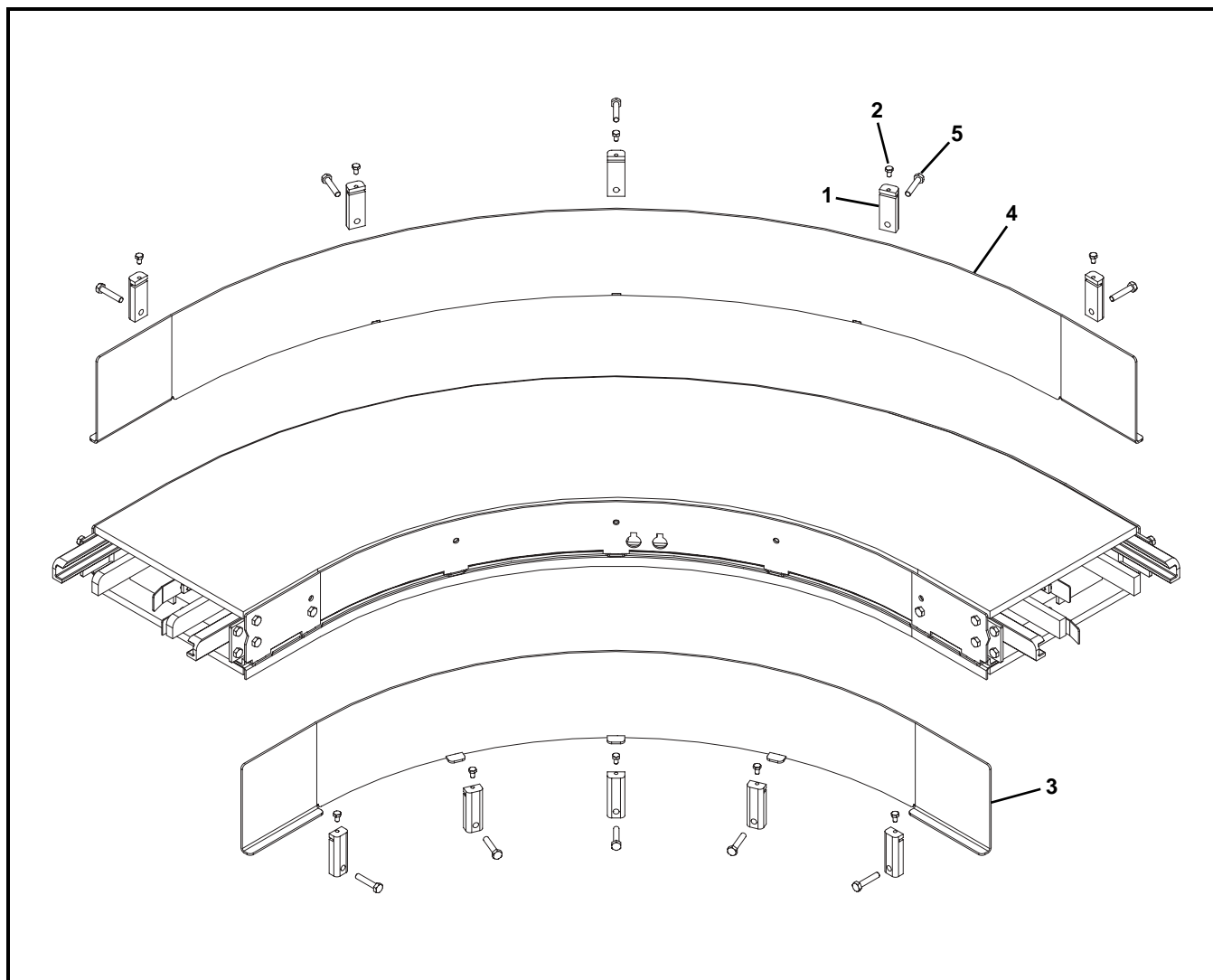


Item	Part Number	Description
1	516999-01	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-06- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-06- <u>LLLLL</u> -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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 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		

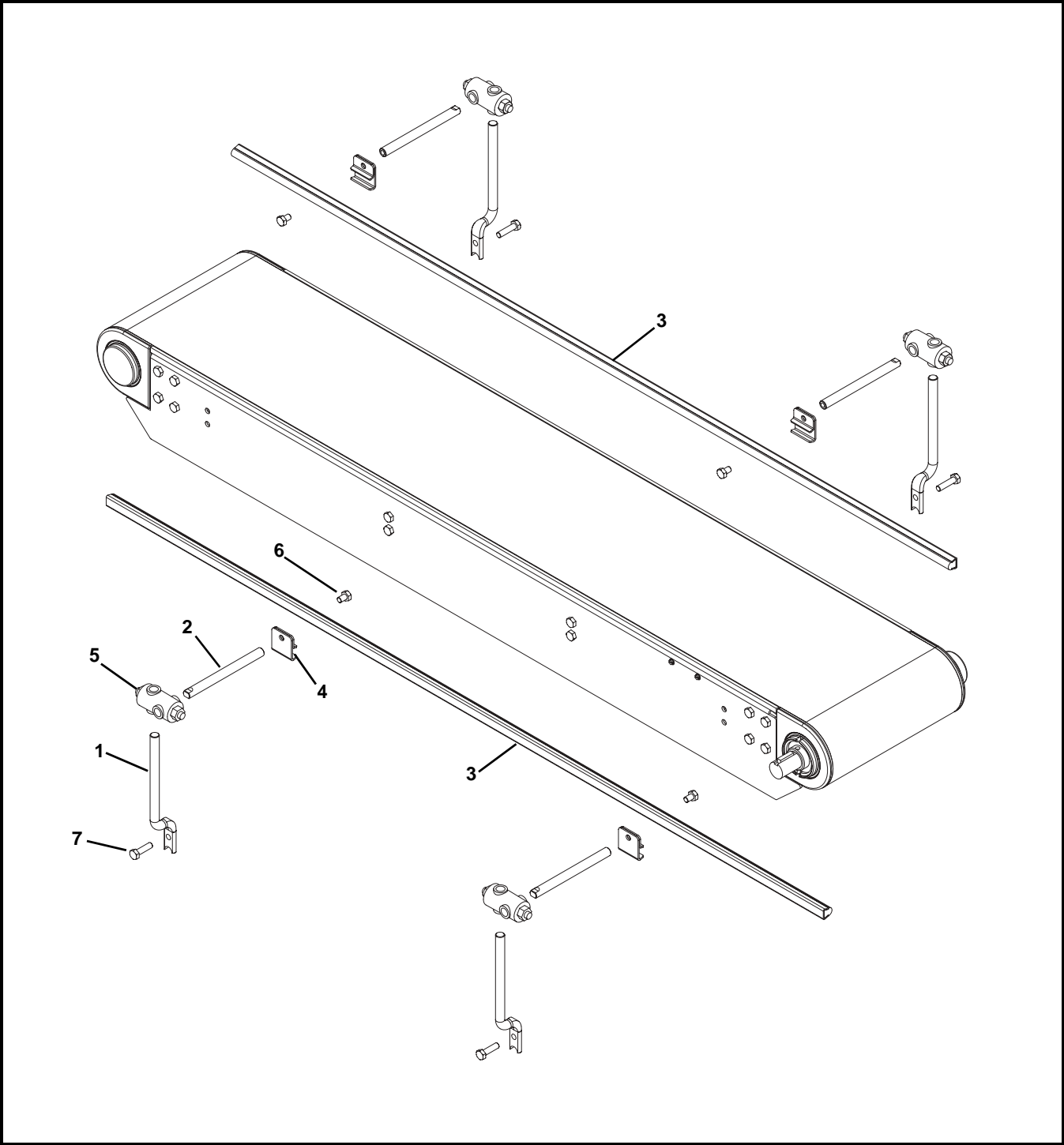
Service Parts

152 mm High Sides for Curve Sections



Item	Part Number	Description
1	516999-01	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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
<u>AA</u> = Conveyor angle reference 45, 90		
<u>WW</u> = Conveyor width reference in inches 06, 12, 18, 24		
See Specifications chart on page 4 for conveyor belt widths.		
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

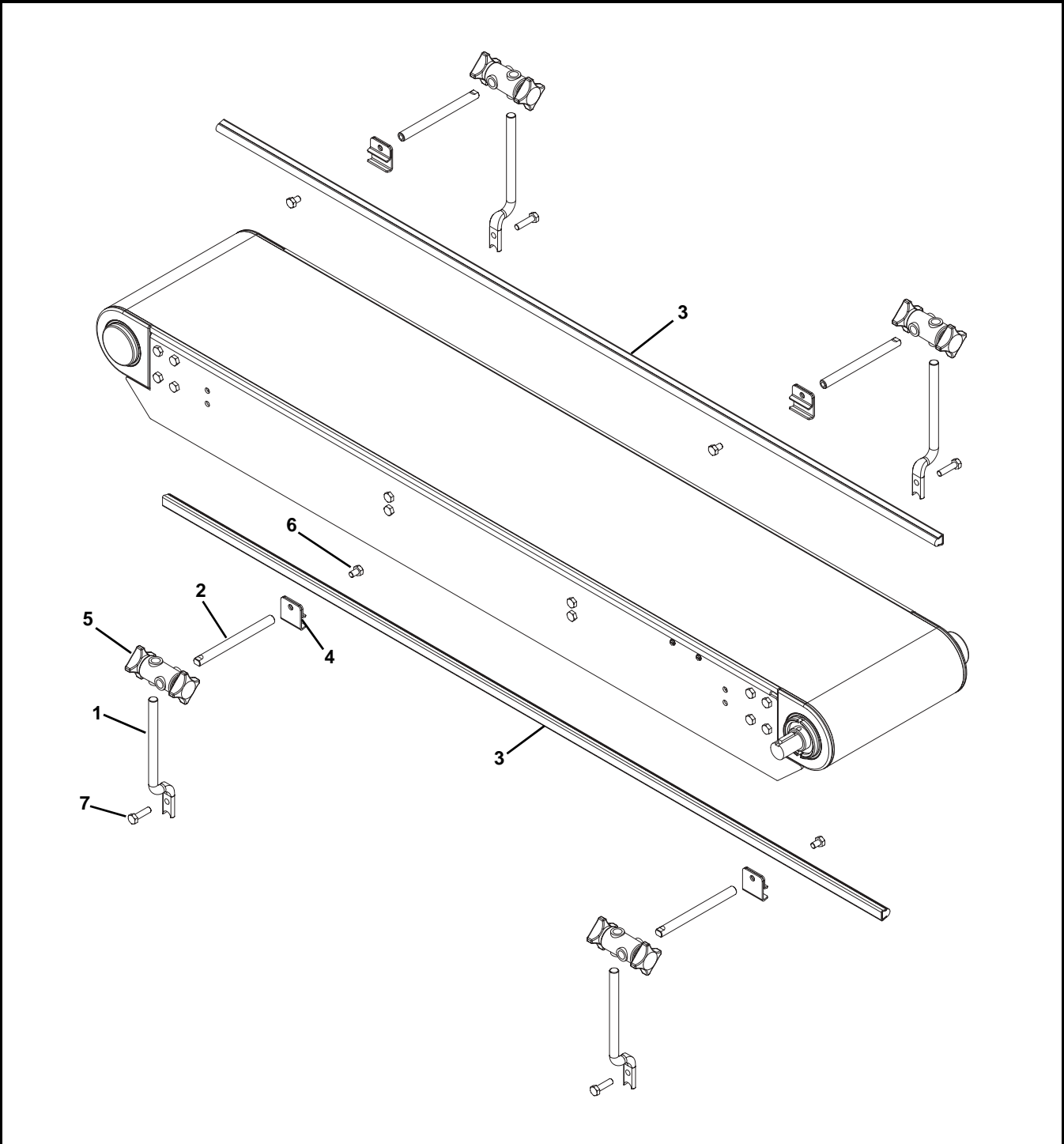


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167- <u>LLLLL</u>	Round Guide Rail
4	807-015	Rail Clamp
5	807-1387	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 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

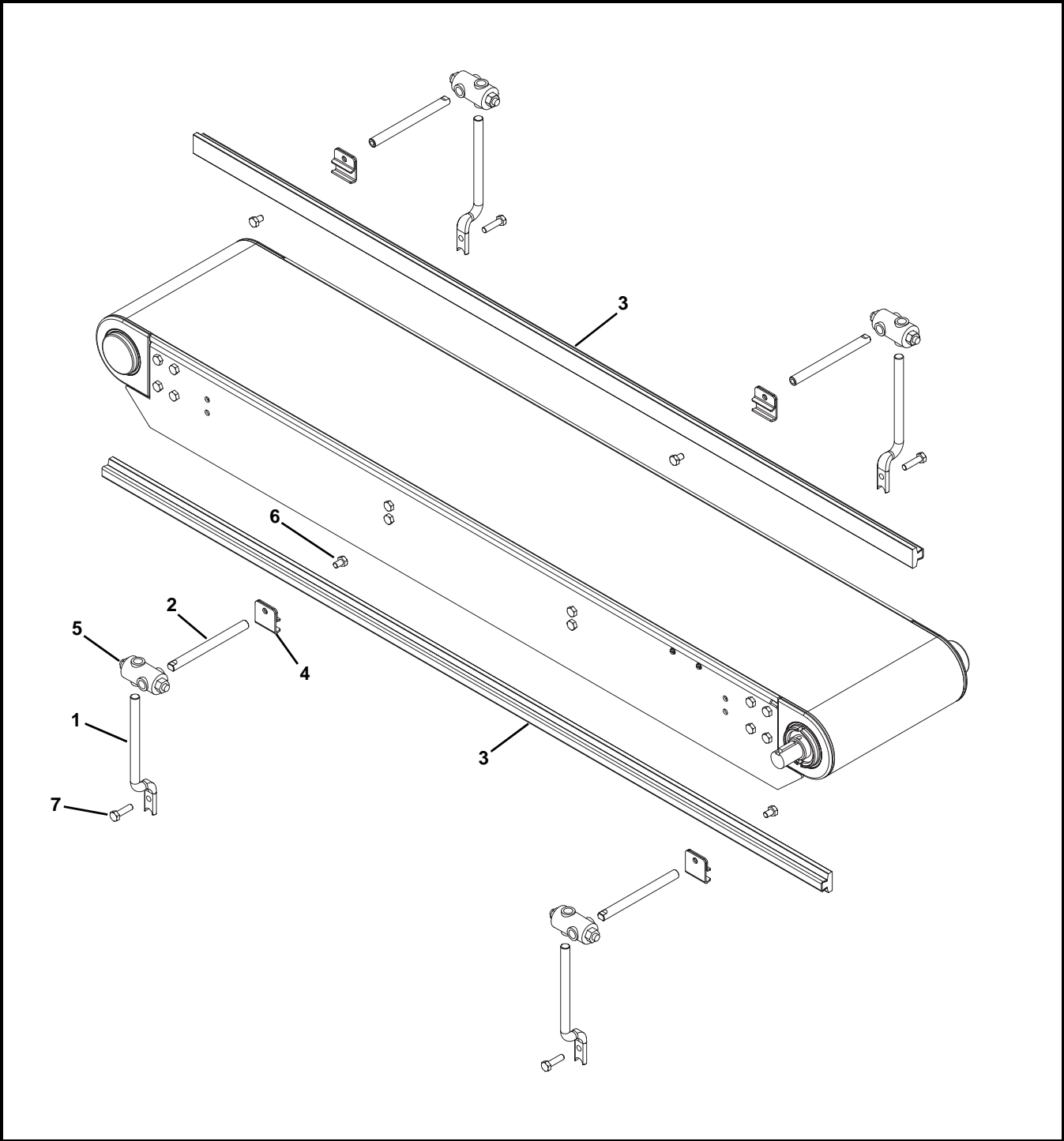
Tool-Less Fully Adjustable Round Guides



Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167- <u>LLLLL</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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 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		

Fully Adjustable Flat Guides

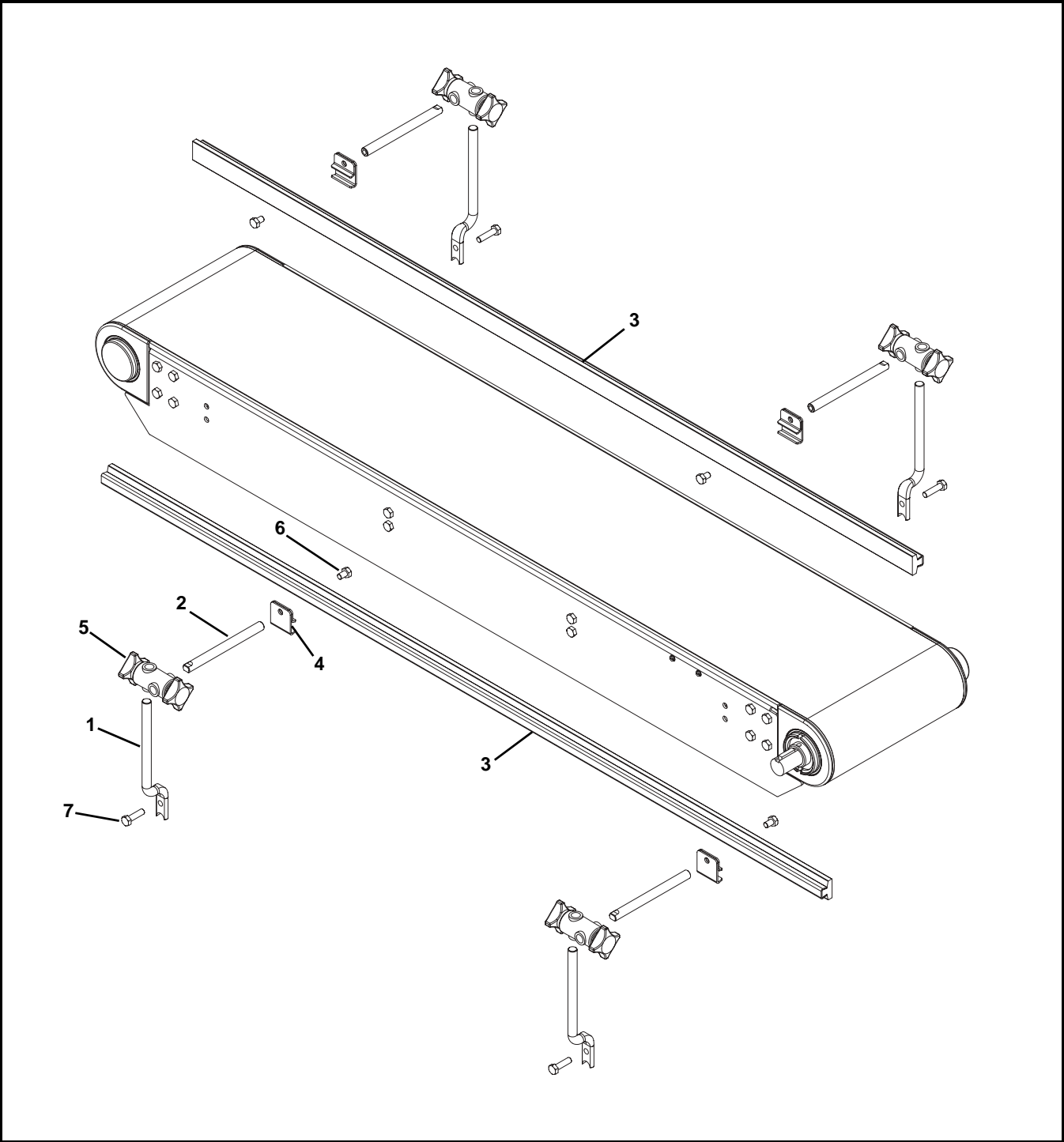


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	517599- <u>LLLL</u>	Flat Guide Rail
4	807-015	Rail Clamp
5	807-1387	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

Item	Part Number	Description
7	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 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

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	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 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:

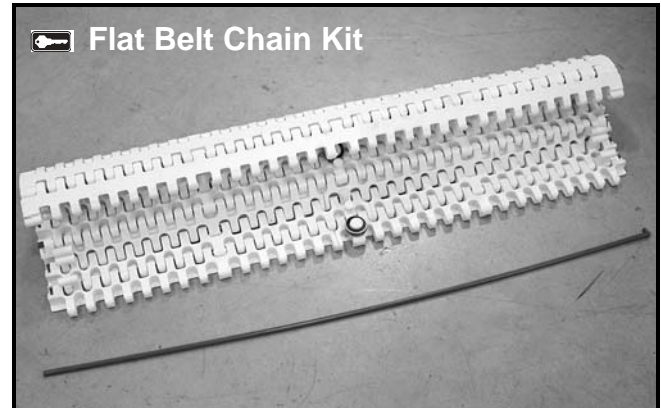
Overall chain length = 42' 5" (rounded up = 43')


Order: Qty (43) of 52BB-WW

BB = Chain reference number (Refer to belt type in part number. See Page 5 for details.)

WW = Conveyor width ref: 06, 12, 18, 24 increments

Flat Belt Chain Repair Kit



Item	Part Number	Description
1 	52 <u>BB</u> - <u>WW</u> -FG	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: 06, 12, 18, 24 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.

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

www.dorner.com



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