7350 Series Version 2 Belted Conveyors

Installation, Maintenance and Parts Manual

For other service manuals visit our website at:
www.dornerconveyors.com/manuals-literature

Record Conveyor Serial Number Here

851-879 Rev. C

Table of Contents

⚠ 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.**

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

1	Conveyor
2	Gearmotor
3	Belt (Flat Belt Shown)
4	Support Stands
5	Drive End
6	Idler End
7	Guides

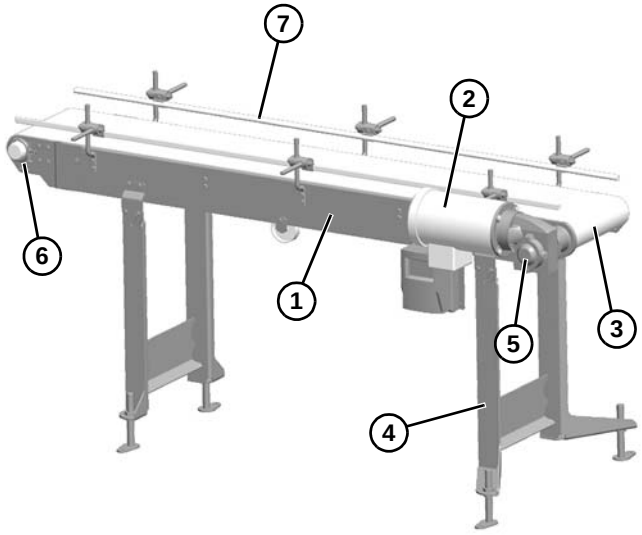
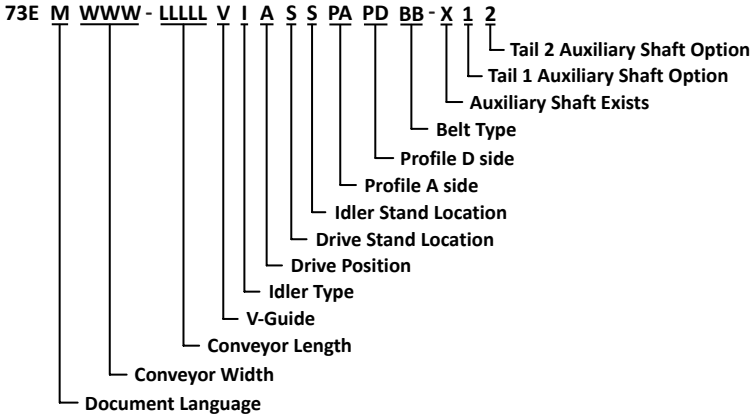


Figure 1

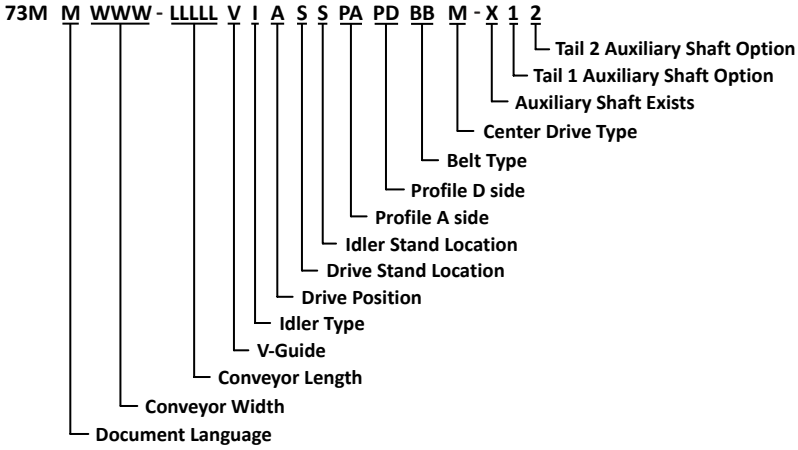
Specifications

7350 Series Version 2 Conveyors

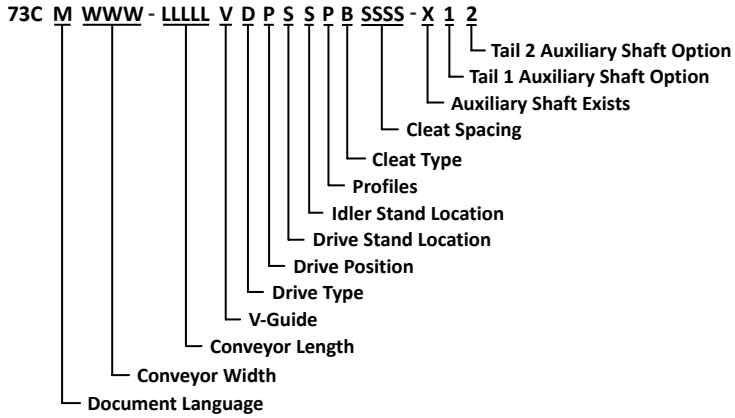
Flat Belt End Drive 7350 Series Version 2



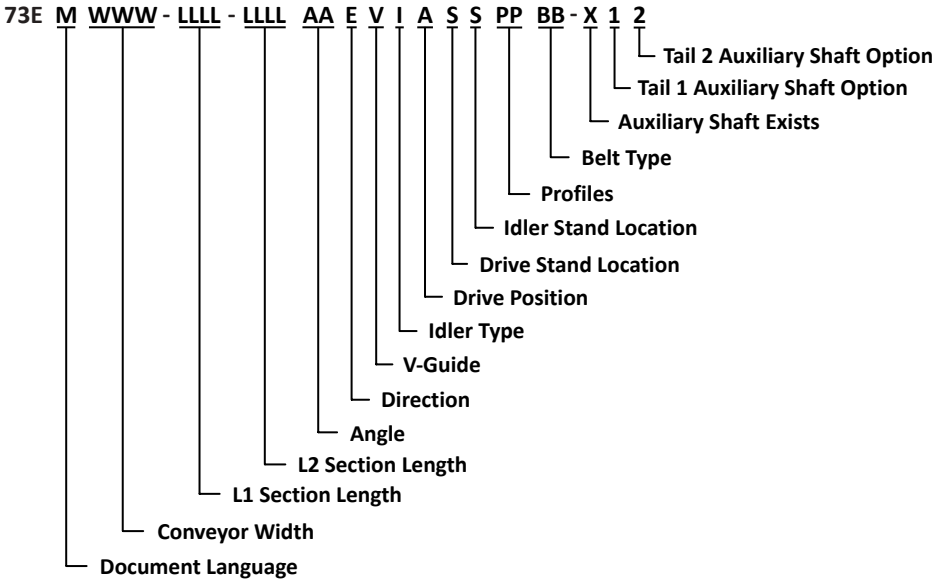
Flat Belt Center Drive 7350 Series Version 2



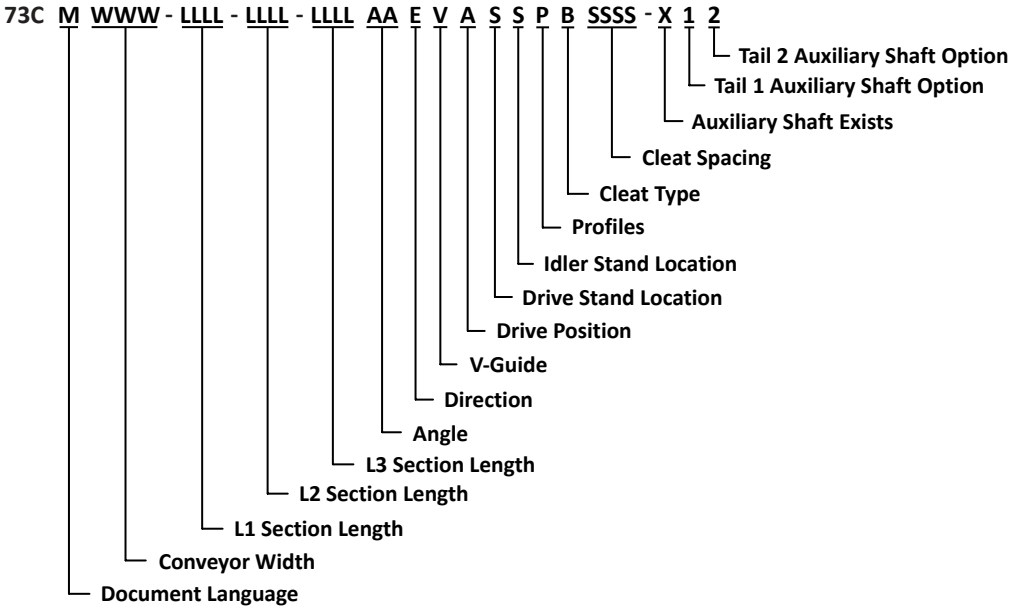
Cleated Belt End Drive 7350 Series Version 2



Flat Belt LPZ 7350 Series Version 2



Cleated Belt LPZ 7350 Series Version 2



Specifications

Conveyor Supports

Maximum Distances:

1 = Support Stand on Drive End = 610 mm (24")

2 = Between Support Stands = 2438 mm (8 ft)**

3 = Support Stand on Idler End = 762 mm (30")

** For conveyors longer than 3048 mm (10 ft), install stand mount kit at frame joint.

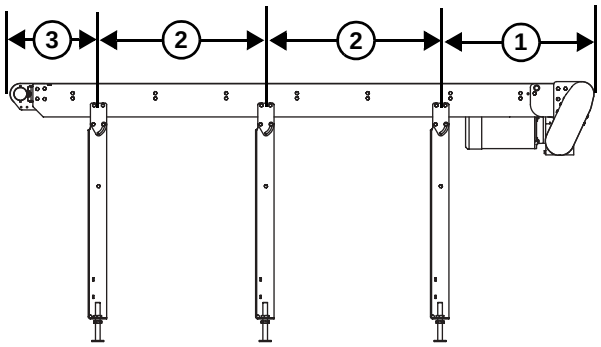


Figure 2

Specifications

Conveyor Width Reference (WWW)	152, 203, 254, 305, 356, 406, 457, 508, 559, 610, 660, 711, 762, 813, 864, 914
Conveyor Belt Width	152 mm (6") 203 mm (8"), 254 mm (10"), 305 mm (12"), 356 mm (14"), 406 mm (16"), 457 mm (18"), 508 mm (20"), 559 mm (22"), 610 mm (24"), 660 mm (26"), 711 mm (28"), 762 mm (30"), 813 mm (32"), 864 mm (34"), 914 mm (36")
Maximum Conveyor Load (See NOTE Below)	97 kg/ m^2 (20 lbs. / ft^2) with a maximum of 227 kg (500 lbs.)
Belt Travel	229 mm (9") per revolution of pulley
Maximum Belt Speed	91 m/minute (300 ft/minute)
Conveyor Length Reference (LLLLL)	00915 - 12190 in 00005 increments
Conveyor Length	915 mm (36") - 12190 mm (480") 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*

⚠ CAUTION

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

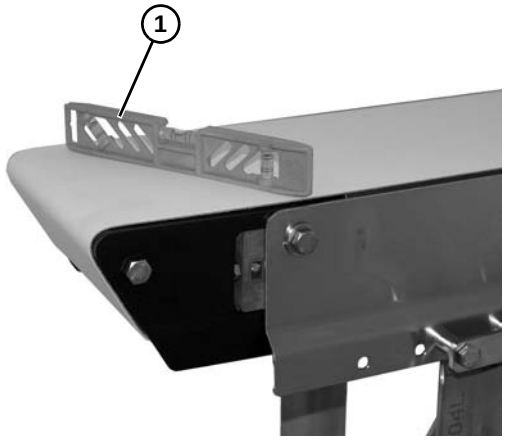


Figure 3

Required Tools

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

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to “Conveyors Longer than 10 ft (3048 mm)” on page 9.
2. Attach the stands. Refer to “Stand Installation” on page 12.
3. Install the belt. Refer to “Belt Installation” on page 12.
4. Install belt returns. Refer to “Belt Returns” on page 13.
5. Install the gearmotor. Refer to “Drive Package Installation” on page 17.

Conveyors Longer than 10 ft (3048 mm)

Connecting Components

Typical connecting components **(Figure 4)**.

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

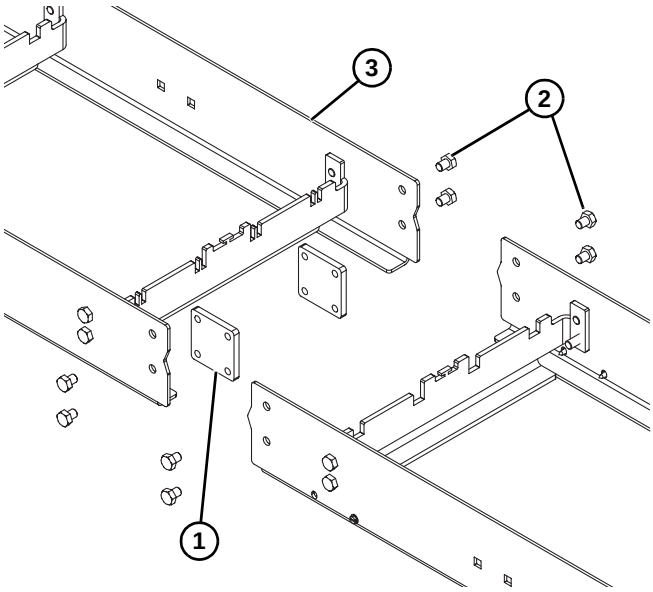


Figure 4

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

Figure 5

2. Join both conveyor sections and install connecting plates **(Figure 4, item 1)** with four screws **(Figure 4, item 2)** on both sides. Tighten to 14-16 ft-lbs (19-22 Nm).

Installation

Z-Frame Conveyors

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

Upper Knuckles

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

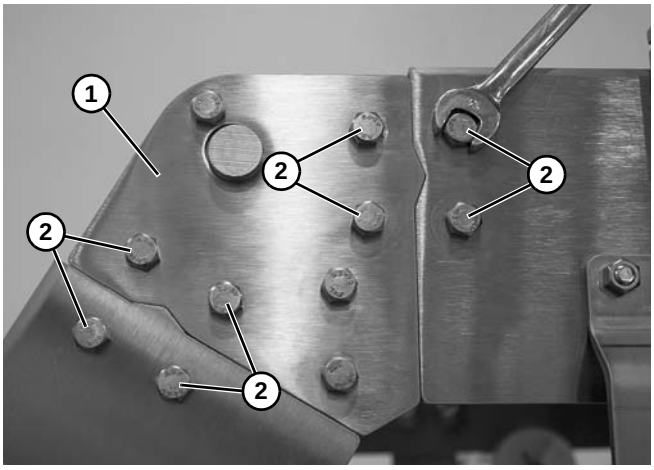


Figure 6

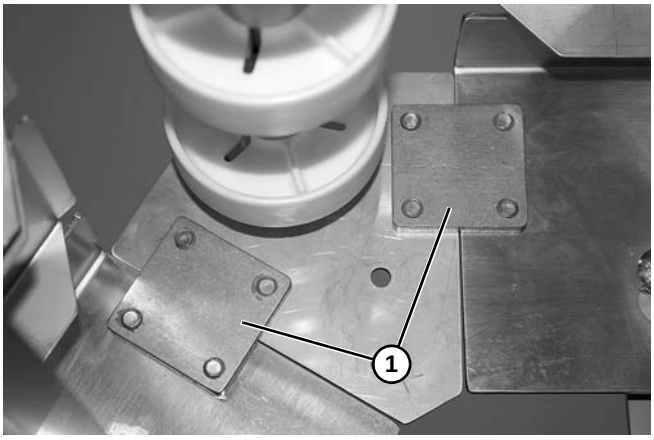


Figure 7

2. Remove screws **(Figure 8, item 1)**.

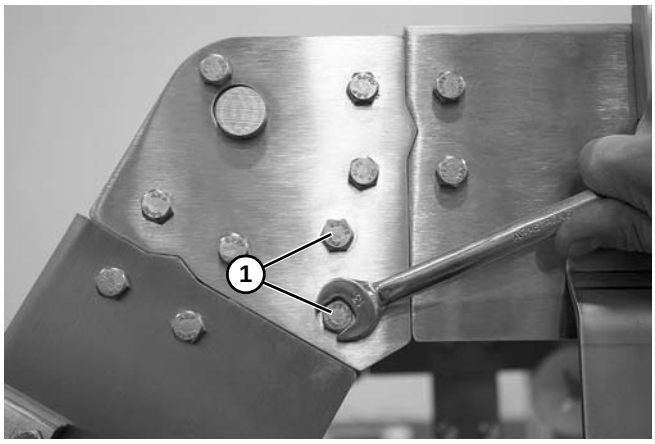


Figure 8

3. Remove bearing guard **(Figure 9, item 1)** with bearing.

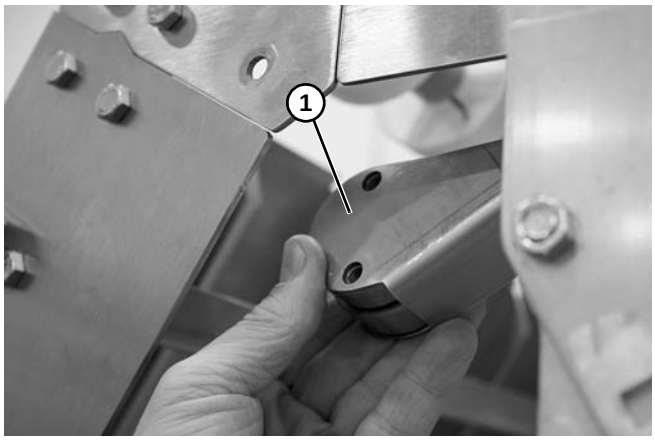


Figure 9

4. Install belt. Refer to “Belt Installation” on page 12.
5. Install bearing guard and bearing.
6. Tighten all screws to 14-16 ft-lbs (19-22 Nm).

Lower Knuckles

1. Attach lower knuckle **(Figure 10, item 1)** to frame using four screws **(Figure 10, item 2)** and two plates **(Figure 11, item 1)** on each side of the lower knuckle assembly.

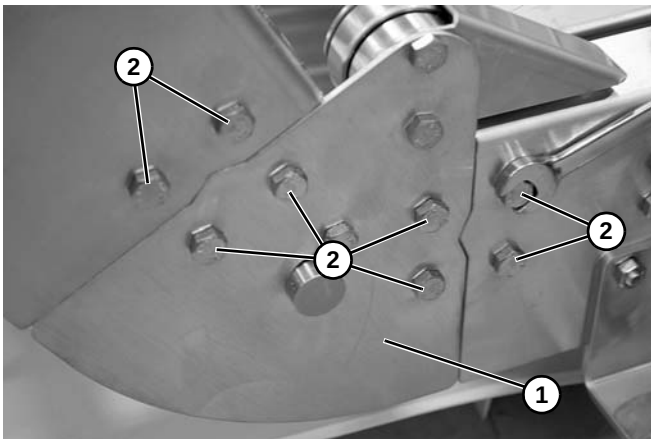


Figure 10

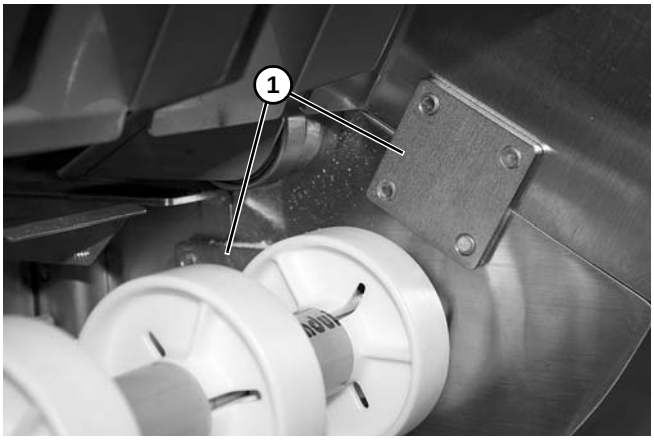


Figure 11

2. Remove screws **(Figure 12, item 1)**.

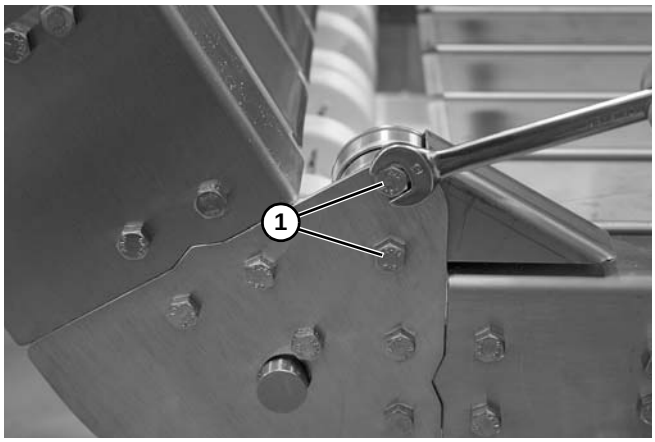


Figure 12

3. Remove bearing guard **(Figure 13, item 1)** with bearing.

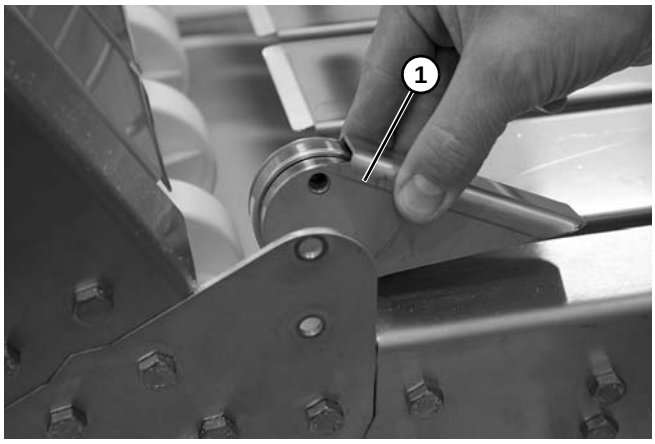


Figure 13

4. Install belt. Refer to “Belt Installation” on page 12.
5. Install bearing guard and bearing.
6. Tighten all screws 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 14)**.

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

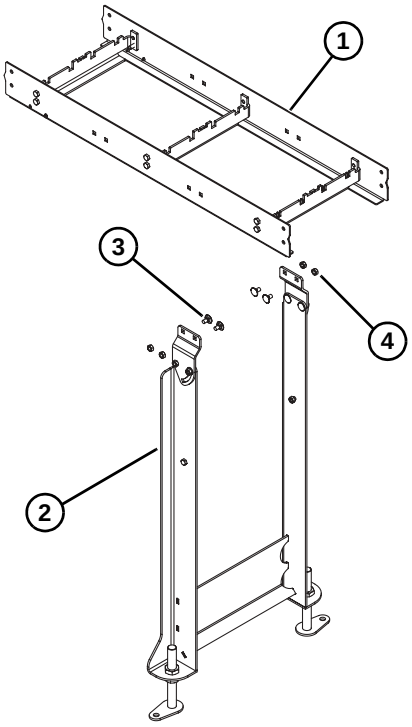


Figure 14

1. Position the stands on a flat, level surface.
2. Attach the stands **(Figure 15, item 1)** to the frame. Tighten screws to 14-16 ft-lbs (19-22 Nm).

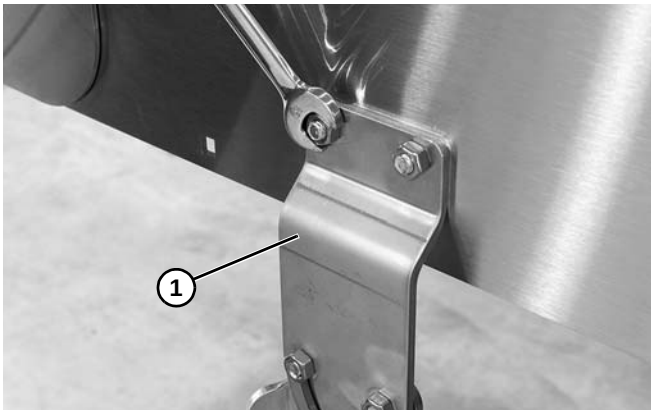


Figure 15

Belt Installation

⚠ WARNING

Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.

1. Place temporary support stands **(Figure 16, item 1)** at both ends of the conveyor. Place an additional support stand **(Figure 16, item 2)** under the drive motor, if equipped. See WARNING.

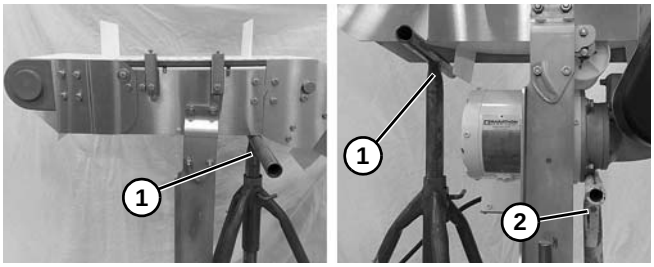


Figure 16

2. Remove fasteners **(Figure 17, item 1)** securing the stand brackets from one side of the conveyor and remove brackets.

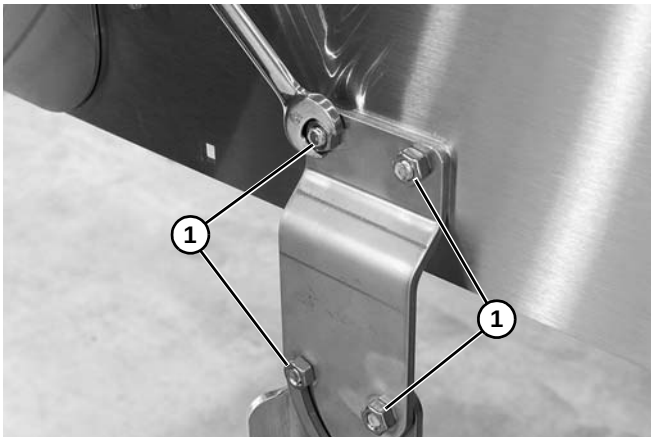


Figure 17

3. Rotate idler end **(Figure 18, item 1)** upward as shown.

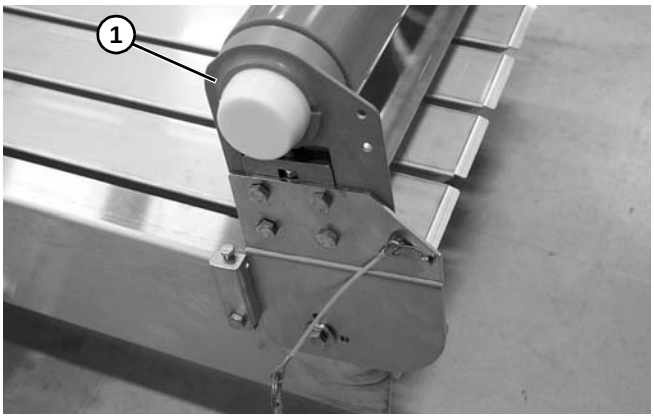


Figure 18

4. Position the belt **(Figure 19, item 1)** onto the conveyor **(Figure 19, item 2)**.

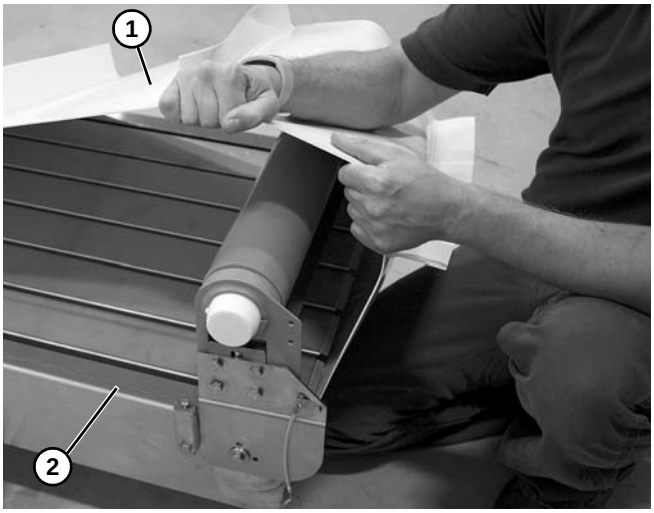


Figure 19

5. Install stand brackets to conveyor with fasteners.

NOTE

*Loosen nuts and adjust screws **(Figure 20, item 1)** to level tail (as needed).*

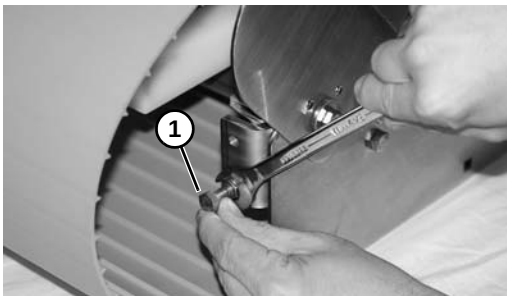


Figure 20

6. Repeat procedure for the opposite end of the conveyor to fully install the belt.

NOTE

*To lower idler tail, push idler tail **(Figure 21, item 1)** to its maximum up position, and move locking lever **(Figure 21, item 2)** up to disengage lock. Lower tail slowly.*

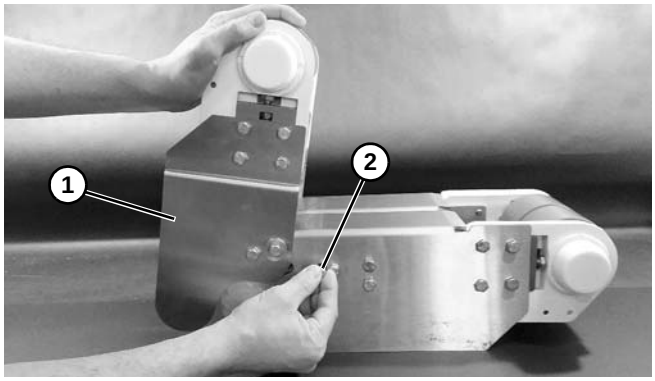


Figure 21

Belt Returns

Flat Belt Returns 508 mm Wide and Wider

Typical flat return components **(Figure 22)**.

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

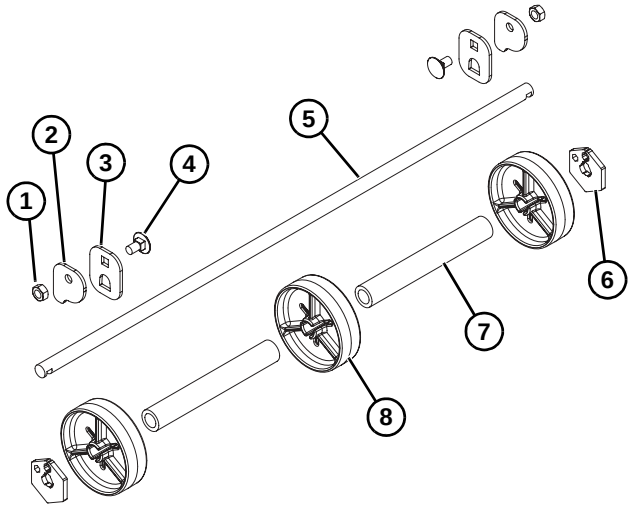


Figure 22

1. Install carriage bolt **(Figure 23, item 1)** through frame rail.

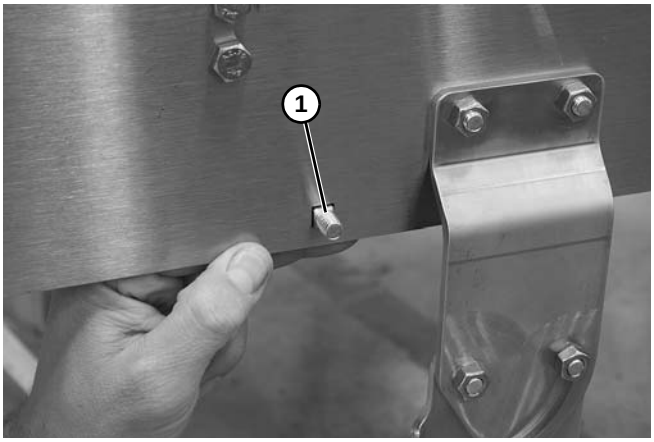


Figure 23

2. Install return bracket **(Figure 24, item 1)**.

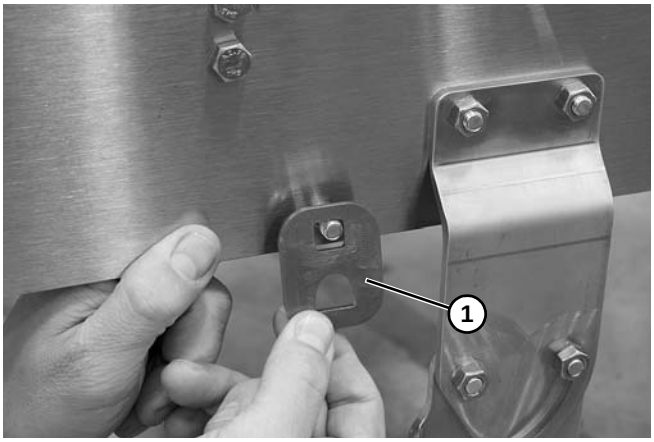


Figure 24

3. Install return clip **(Figure 25, item 1)** and loosely secure with nut **(Figure 25, item 2)**.

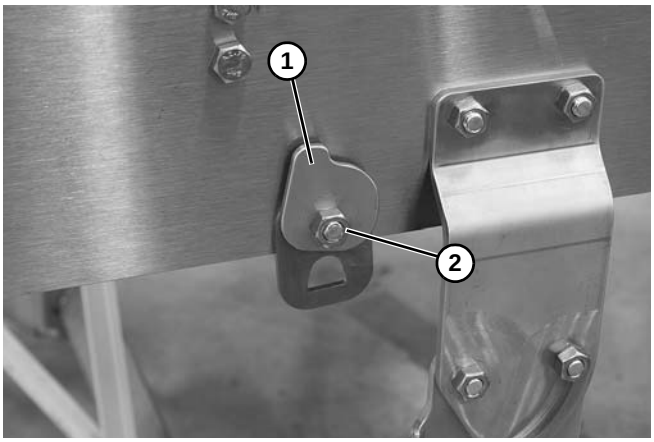


Figure 25

4. Repeat on the opposite side of the conveyor.
5. Install belt return assembly **(Figure 26, item 1)** onto return brackets **(Figure 26, item 2)**.

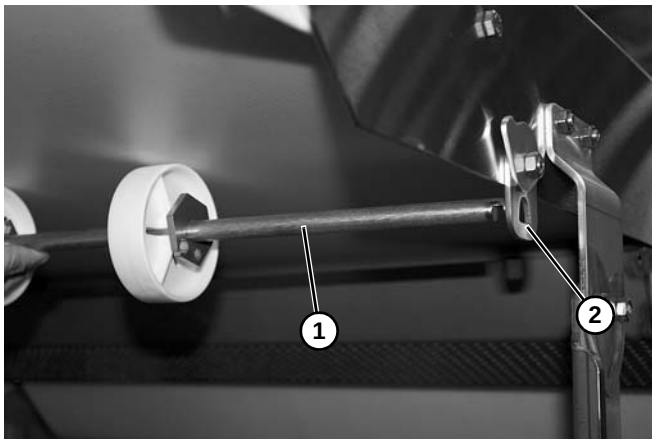


Figure 26

6. Rotate return clip **(Figure 27, item 1)** down against shaft **(Figure 27, item 2)** on both sides of conveyor. Tighten nuts **(Figure 27, item 3)**.

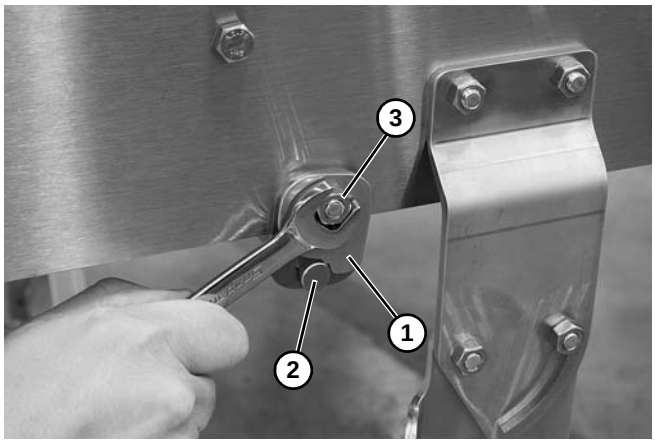


Figure 27

Cleated Belt and Flat Belt Returns Under 508 mm Wide

Typical cleated return components **(Figure 28)**.

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

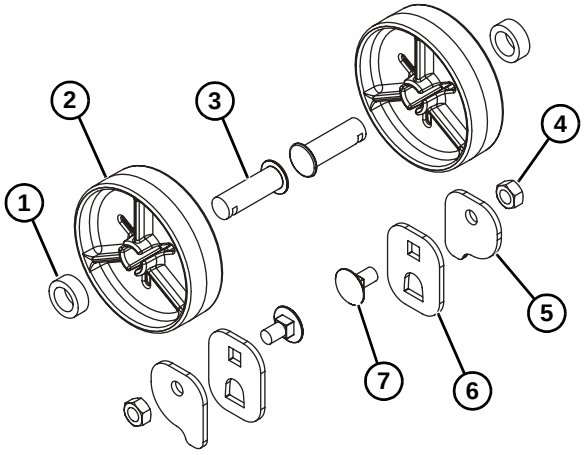


Figure 28

1. Install carriage bolt **(Figure 29, item 1)** through frame rail.

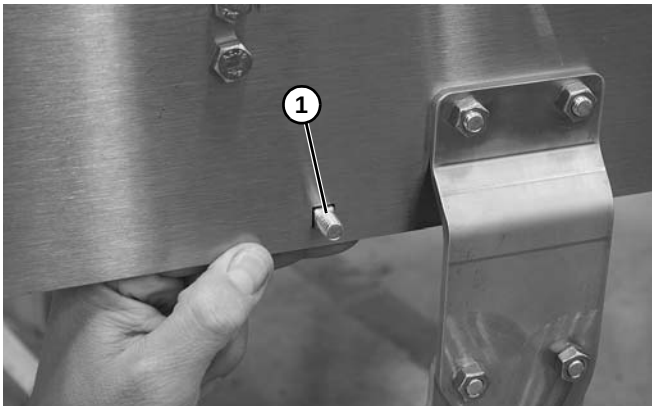


Figure 29

2. Install return bracket **(Figure 30, item 1)**.

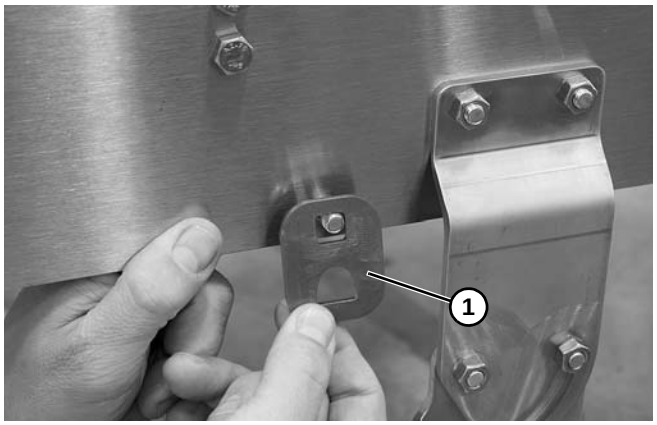


Figure 30

3. Install return clip **(Figure 31, item 1)** and loosely secure with nut **(Figure 31, item 2)**.

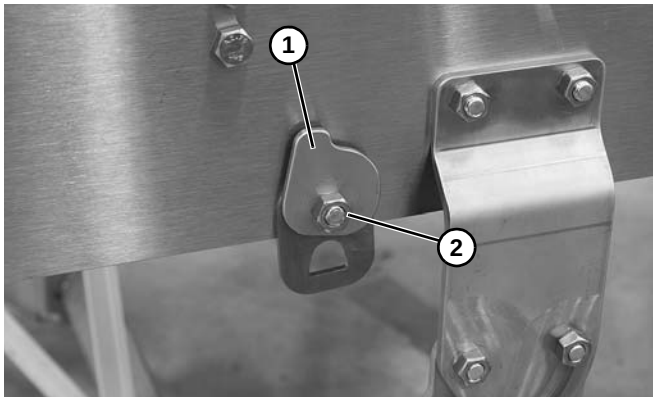


Figure 31

4. Repeat on the opposite side of the conveyor.
5. Install each puck **(Figure 32, item 1)** onto return bracket **(Figure 32, item 2)** with stub shaft **(Figure 32, item 3)** and spacer **(Figure 32, item 4)**.

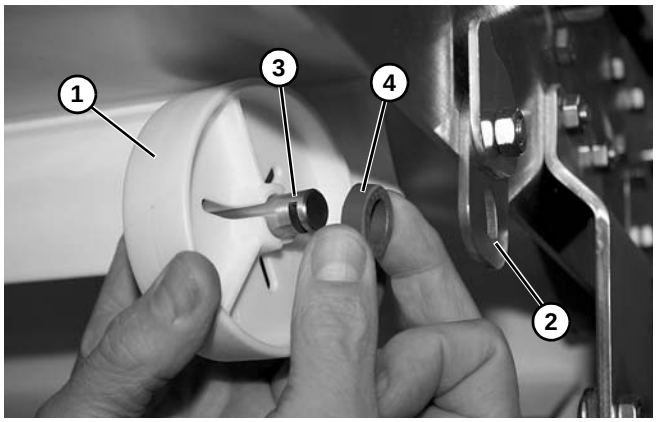


Figure 32

6. Rotate return clip **(Figure 33, item 1)** down against shaft **(Figure 33, item 2)** on both sides of conveyor. Tighten nuts **(Figure 33, item 3)**.

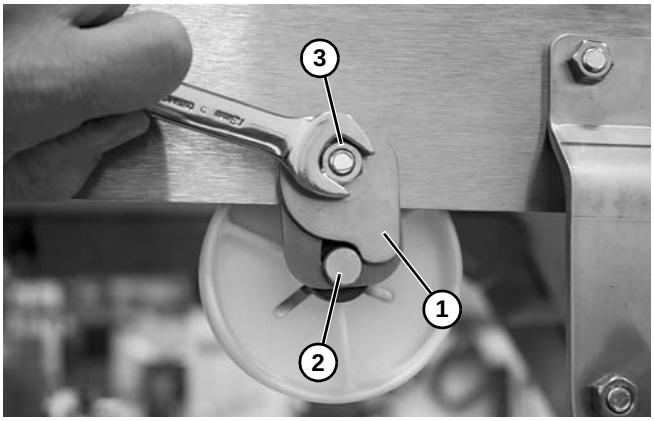


Figure 33

Guide Installation

High Side Guides

1. Remove the top screw **(Figure 34, item 1)** from the conveyor side.

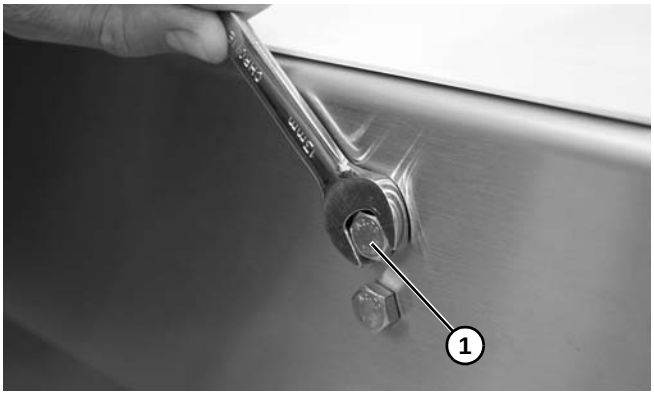


Figure 34

2. Assemble the mounting block **(Figure 35, item 1)** to the conveyor side with the screw **(Figure 35, item 2)**, provided.

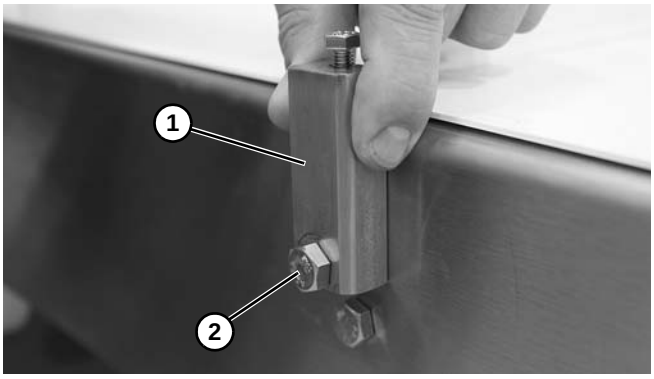


Figure 35

3. Install guide **(Figure 36, item 1)** into the slot **(Figure 36, item 2)** of the mounting block and tighten screws **(Figure 36, item 3)**.

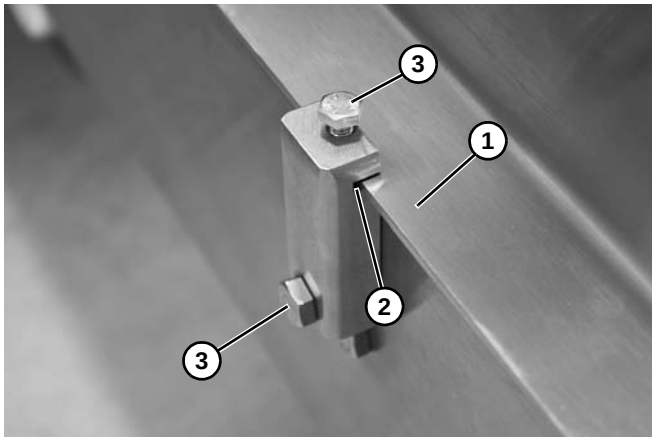


Figure 36

4. Install the connecting plate **(Figure 37, item 1)** over the studs.

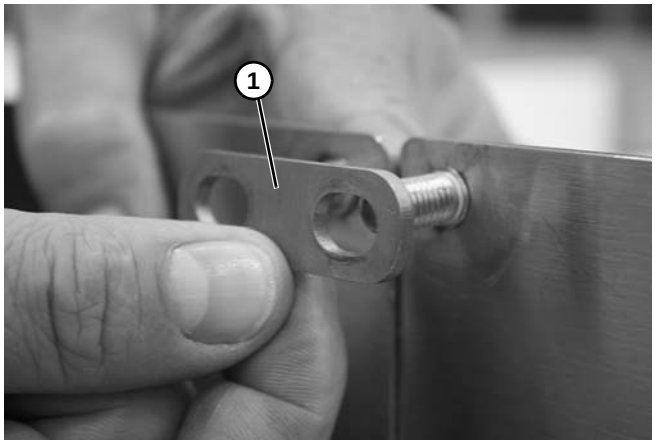


Figure 37

5. Install nuts **(Figure 38, item 1)** and tighten.

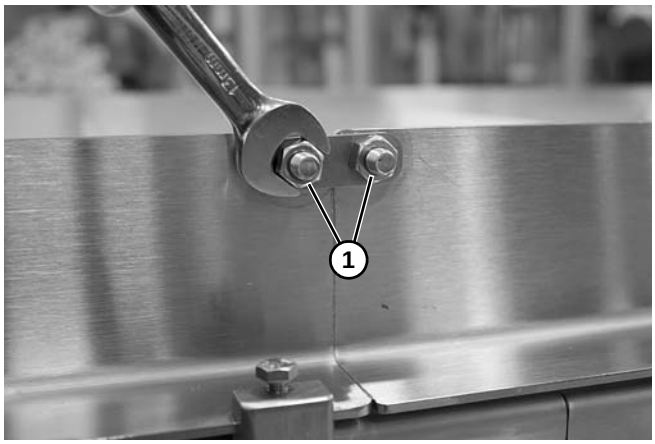


Figure 38

Adjustable Guides

1. Remove the top screw **(Figure 39, item 1)**.

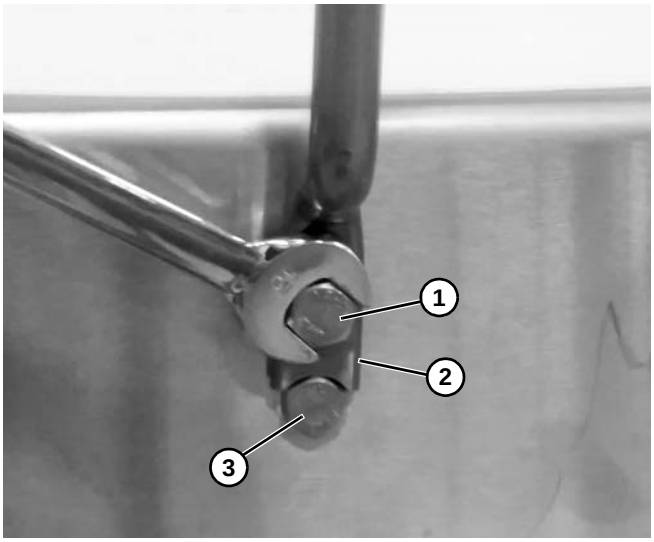


Figure 39

2. Install the guide post **(Figure 39, item 2)** resting on lower screw **(Figure 39, item 3)**. Reinstall top screw and tighten.
3. Install guide rail **(Figure 40, item 1)** into rail clamp. Tighten fastener to secure **(Figure 40, item 2)**.

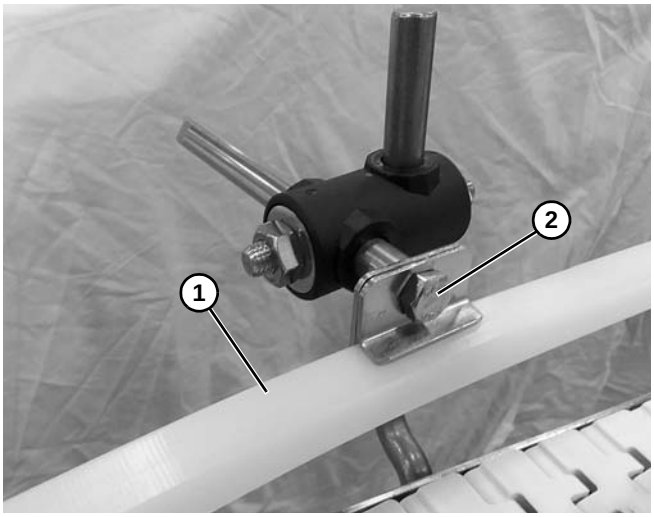


Figure 40

NOTE

See pages 66 to 69 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
- 851-884 7350 Series Version 2 Center Drives

1. Attach the motor **(Figure 41, item 1)** to the gear reducer **(Figure 41, item 2)**.

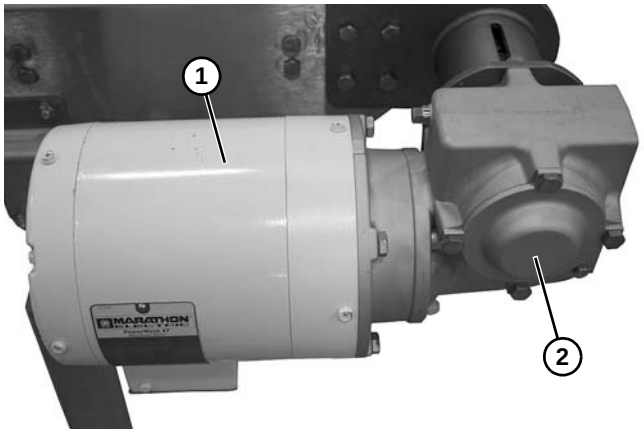


Figure 41

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
- 10 mm hex wrench
- 13 mm hex wrench

Checklist

- Keep critical service parts on hand. Refer to the "Service Parts" section starting on page 44 for recommendations.
- Replace any worn or damaged parts.

Cleaning

NOTE

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

⚠ CAUTION

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

⚠ WARNING

SEVERE HAZARD!

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

Lubrication

No lubrication is required. Replace bearings if worn.

Maintaining the Conveyor Belt

Troubleshooting

Inspect conveyor belt for:

- Surface cuts or wear

Damage to the belt, surface cuts and/or wear indicates:

- Sharp or heavy parts impacting belt
- Jammed parts
- Accumulated dirt
- Foreign material inside the conveyor
- Improperly positioned accessories
- Excessive load on belt
- Dirt impacted on spindle
- Excessive or improper side loading
- Improper tracking

Skipping indicates:

- Excessive load on belt
- Worn spindle or impacted dirt on drive spindle
- Improper tracking

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 42, item 1)** when required.

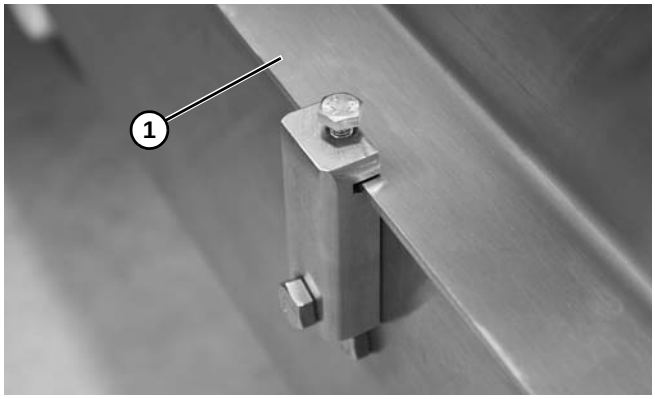


Figure 42

2. Remove belt returns:

   a. For flat returns 508 mm wide and wider, refer to "Flat Belt Returns 508 mm Wide and Wider" on page 41. Follow steps 1 and 2.

   b. For cleated returns and flat returns under 508 mm wide, refer to "Cleated Belt and Flat Belt Returns Under 508 mm Wide" on page 42. Follow steps 1 and 2.

⚠ WARNING

Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.

3. Place temporary support stands **(Figure 43, item 1)** at both ends of the conveyor. Place an additional support stand **(Figure 43, item 2)** under the drive motor, if equipped. See WARNING.

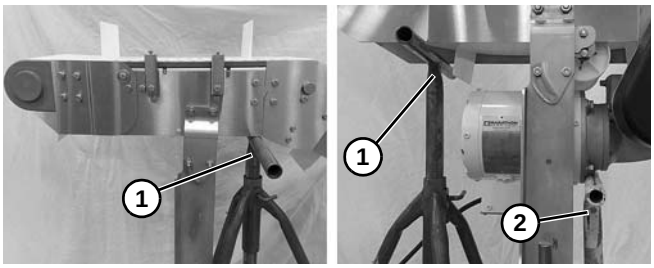


Figure 43

4. Remove fasteners **(Figure 44, item 1)** securing the stand brackets from one side of the conveyor and remove brackets.

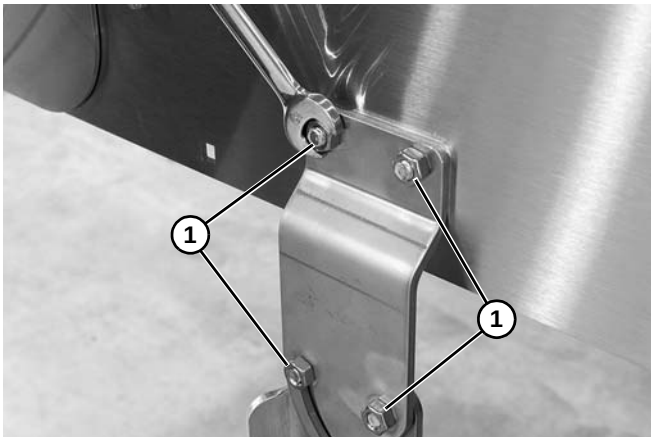


Figure 44

5. Rotate idler end **(Figure 45, item 1)** upward as shown.

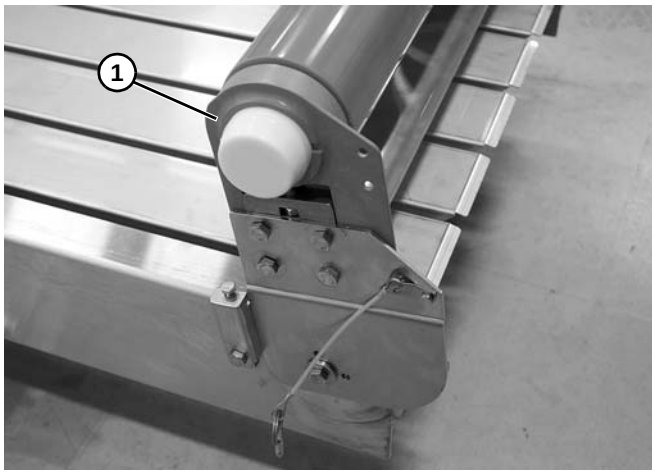


Figure 45

6. Remove the belt **(Figure 46, item 1)** from the conveyor **(Figure 46, item 2)**.

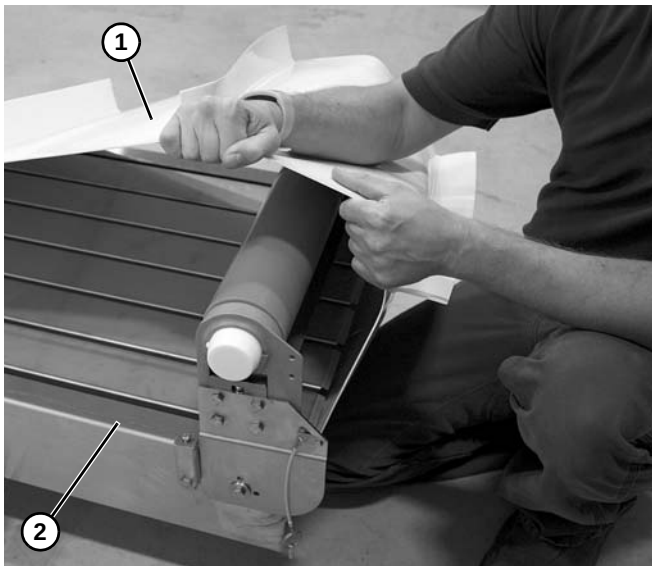


Figure 46

7. Repeat procedure for the opposite end of the conveyor to fully remove the belt.

8. Replace the belt. Refer to “Belt Installation” on page 12.

NOTE

*To lower idler tail, push idler tail **(Figure 47, item 1)** to its maximum up position, and move locking lever **(Figure 47, item 2)** up to disengage lock. Lower tail slowly.*

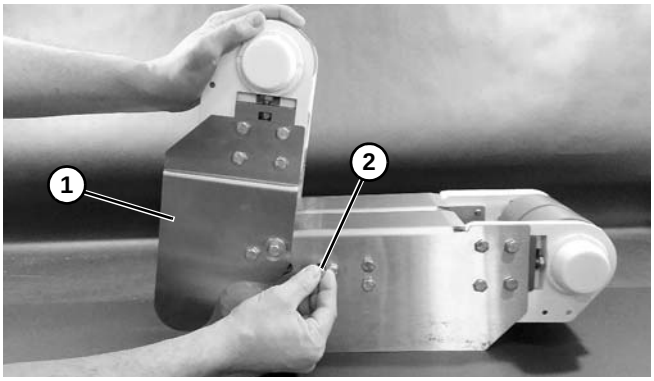


Figure 47

Center Drive Conveyor Belt Replacement

⚠ WARNING

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

⚠ WARNING

Exposed moving parts can cause severe injury.
REMOVE COMPRESSED AIR SUPPLY before removing guards or performing maintenance.

Belt Removal

1. Remove guides **(Figure 48, item 1)** when required.

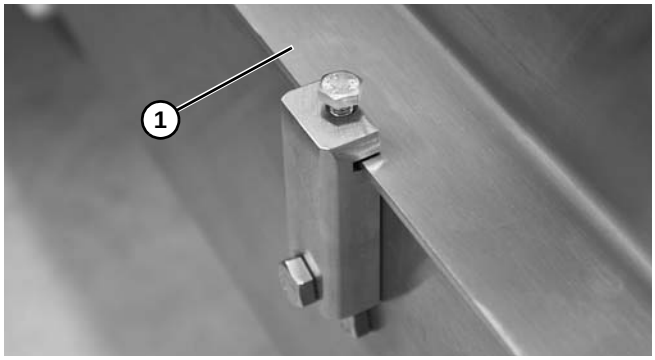


Figure 48

2. Remove belt returns:
   a. For flat returns 508 mm wide and wider, refer to “Flat Belt Returns 508 mm Wide and Wider” on page 41. Follow steps 1 and 2.
   b. For flat returns under 508 mm wide, refer to “Cleated Belt and Flat Belt Returns Under 508 mm Wide” on page 42. Follow steps 1 and 2.
3. Remove air supply and remove hose **(Figure 49, item 1)** from the center drive.

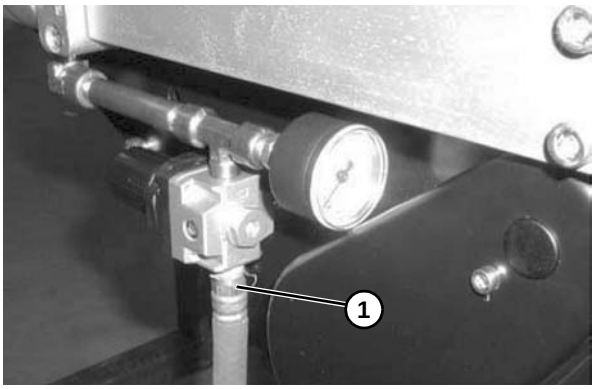


Figure 49

4. Tip up tail **(Figure 50, item 1)**.

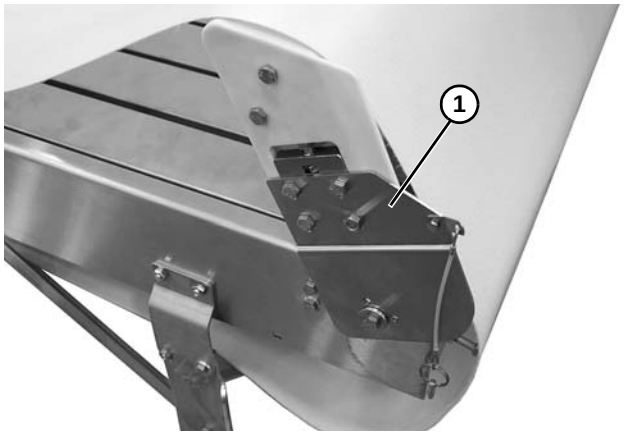


Figure 50

5. Rotate tension nut **(Figure 51, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

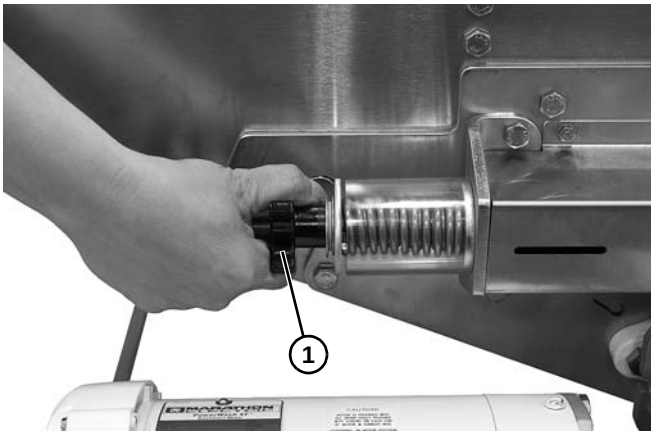


Figure 51

6. Remove four screws **(Figure 52, item 1)** and cover **(Figure 52, item 1)**.

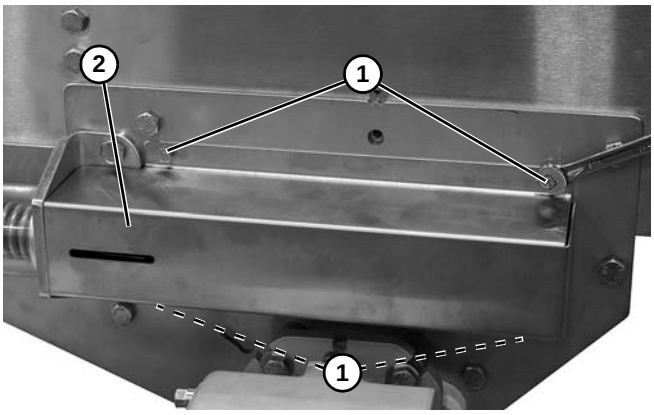


Figure 52

7. Remove two screws **(Figure 53, item 1)** from each side of the center drive. Remove the stationary guard assembly **(Figure 53, item 2)**.

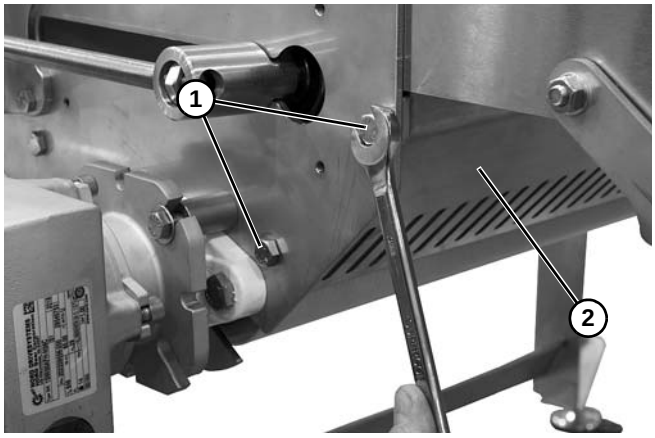


Figure 53

8. Remove screw **(Figure 54, item 1)** from each side of the center drive from the idler guard assembly.

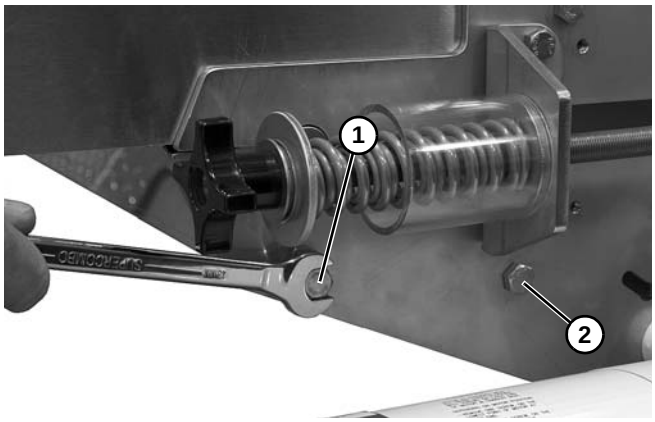


Figure 54

9. Loosen screw **(Figure 54, item 2)** on each side of the center drive.

⚠ CAUTION

Pulleys are heavy. Use caution when removing or installing a pulley.

10. Swing idler guard assembly **(Figure 55, item 1)** down. Remove the idler pulley **(Figure 55, item 2)**.

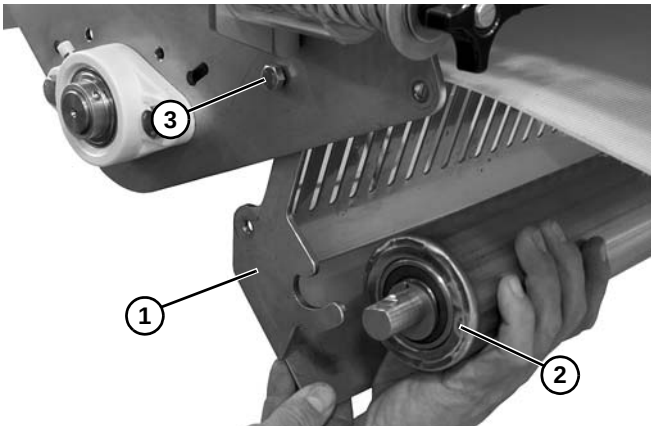


Figure 55

11. Remove screw **(Figure 55, item 3)** from each side of the center drive. Remove the idler guard assembly **(Figure 55, item 1)**.
12. Loosen tension nut **(Figure 56, item 1)** on each side of the center drive so that the tension pulley spacer **(Figure 56, item 2)** aligns with hole **(Figure 56, item 3)**.

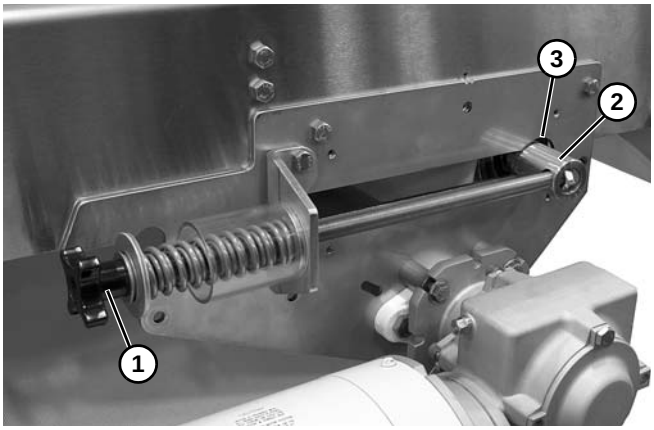


Figure 56

13. Remove two screws **(Figure 57, item 1)** from plate **(Figure 57, item 2)** on both sides of the center drive.

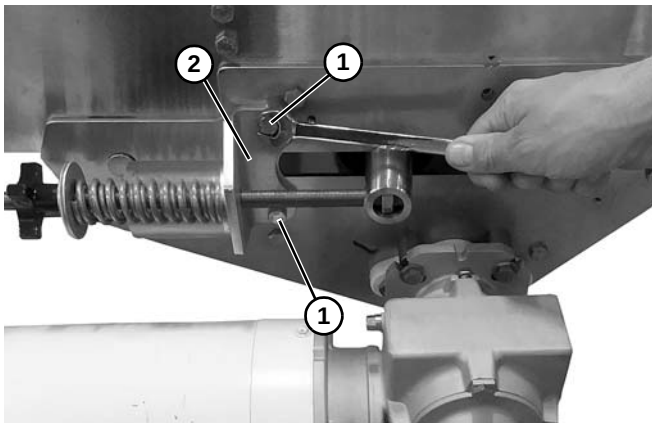


Figure 57

14. Remove tension assembly **(Figure 58, item 1)** on both sides of the center drive.

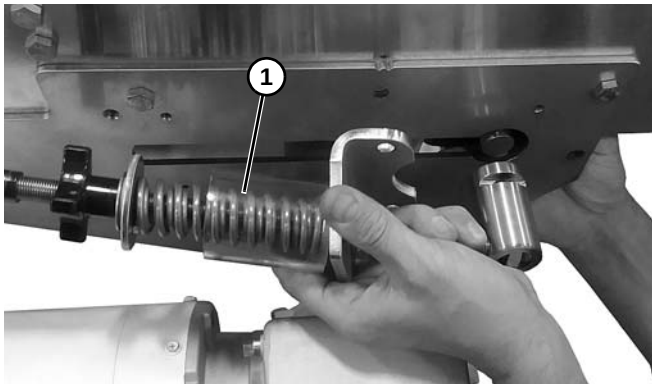


Figure 58

⚠ CAUTION

Pulleys are heavy. Use caution when removing or installing a pulley.

15. Slide shaft **(Figure 59, item 1)** into the tensioner pulley **(Figure 59, item 2)**. Remove the tensioner pulley**.**

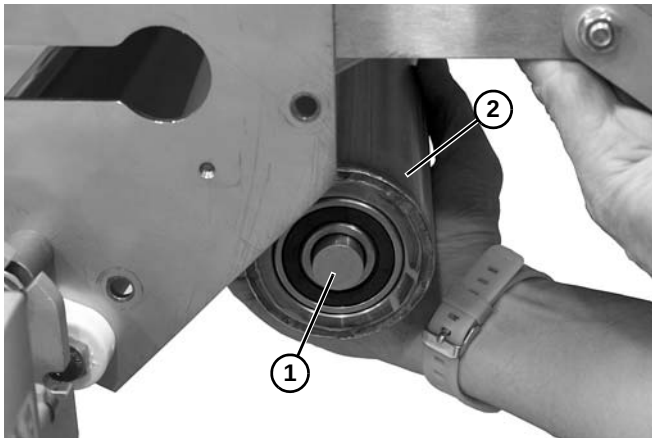


Figure 59

16. Remove belt **(Figure 60, item 1)** from center drive module **(Figure 60, item 2)**.

WARNING

Removing mounting brackets without support under the gearmotor will cause the conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.

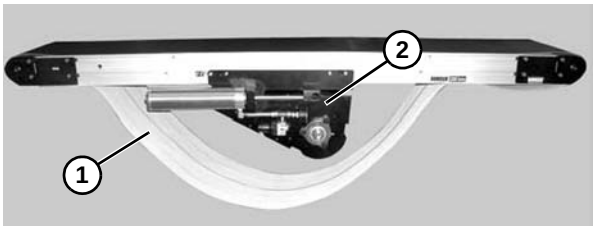


Figure 60

17. Place temporary support stands at both ends of the conveyor. See WARNING.
18. Remove fasteners **(Figure 61, item 1)** securing the stand brackets from one side of the conveyor and remove brackets.

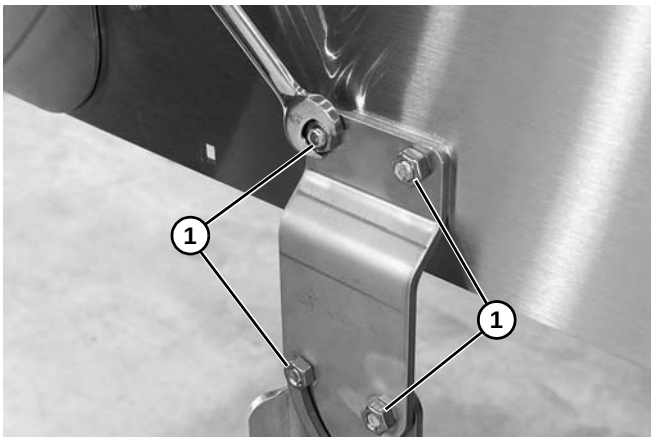


Figure 61

19. Repeat procedure for the opposite end of conveyor.

20. Remove the belt from under the stand **(Figure 62, item 1)** and from the conveyor **(Figure 62, item 2)** on both ends.

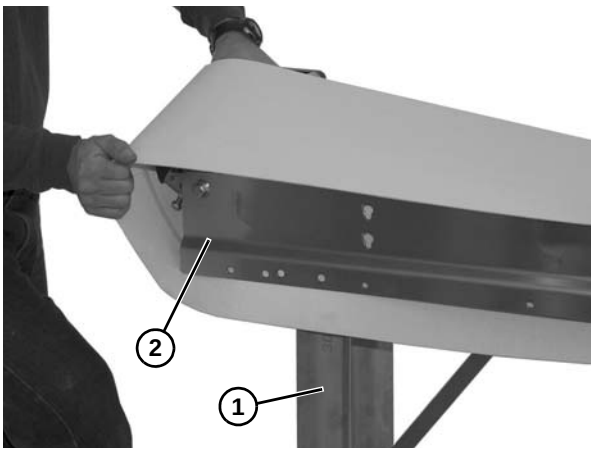


Figure 62

21. Replace the old belt with a new one.

NOTE

*To lower idler tail, push idler tail **(Figure 63, item 1)** to its maximum up position, and move locking lever **(Figure 63, item 2)** up to disengage lock. Lower tail slowly.*

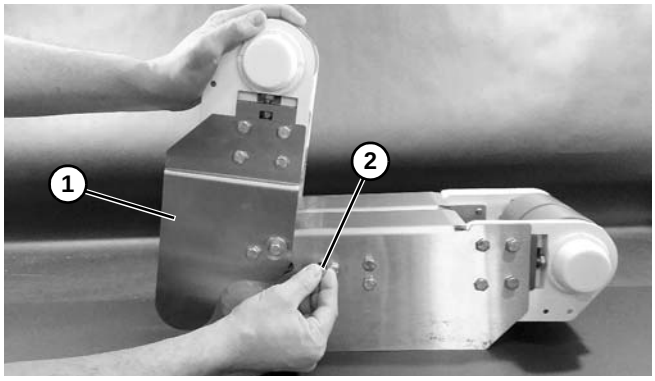


Figure 63

Belt Installation

⚠ WARNING

Removing mounting brackets without support under the gearmotor will cause the conveyor to tip, causing severe injury.

PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.

1. Ensure that temporary support stands are placed at both ends of the conveyor. See WARNING.
2. Orient belt so splice leading fingers **(Figure 64, item 1)** point in the direction of belt travel as identified by the conveyor directional label **(Figure 64, item 2)**.

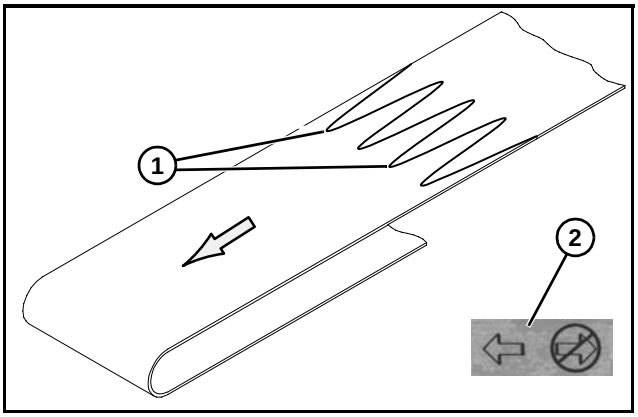


Figure 64

3. Install belt **(Figure 65, item 1)** on conveyor. Lift conveyor **(Figure 65, item 2)** slightly to avoid pinching belt on temporary support stands.

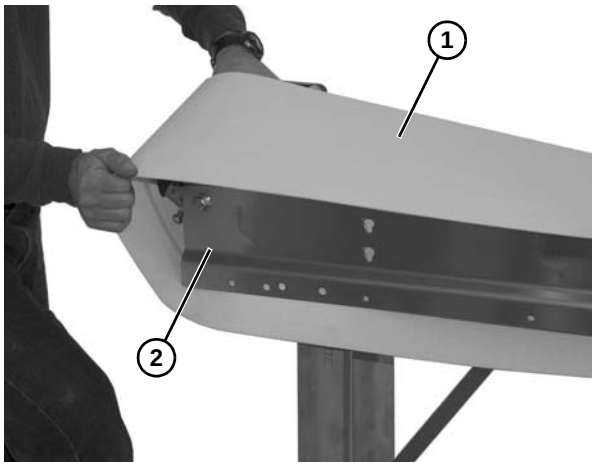


Figure 65

4. Reverse steps 1 thru 14 of the Center Drive “Belt Removal” on page 20”.
5. If equipped, reinstall guiding.
6. Reattach air supply **(Figure 66, item 1)** to center drive. Refer to “Center Drive Conveyor Belt Tensioning” on page 25” for more information.

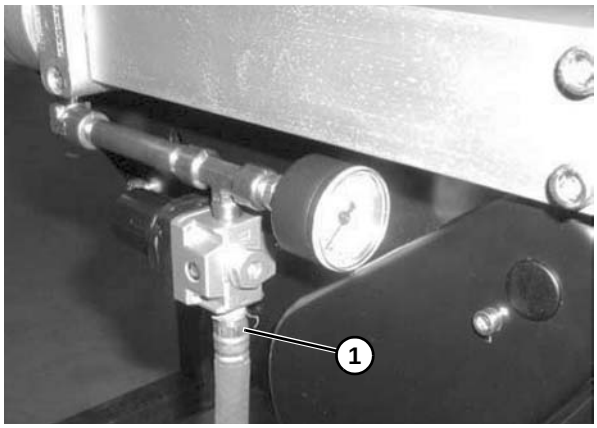


Figure 66

7. Track drive and conveyor if required. See “Center Drive Module Tracking” on page 27 and “Conveyor Belt Tracking” on page 27”.

Conveyor Belt Tensioning

WARNING

SEVERE HAZARD!

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

CAUTION

Over-tensioning of conveyor may stretch conveyor belt and reduce bearing life.

1. Tighten screw **(Figure 67, item 1)** on each side to take up tension. Align the same arrows **(Figure 67, item 2)** and marks **(Figure 67, item 3)** on each side of the conveyor to keep the tail straight.

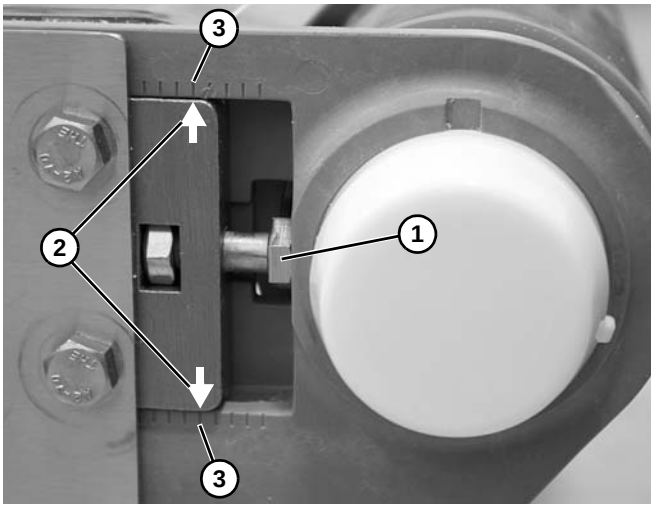


Figure 67

Center Drive Conveyor Belt Tensioning

WARNING

SEVERE HAZARD!

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

A - With Pneumatic Tensioning

1. Connect air supply **(Figure 68, item 1)** to regulator **(Figure 68, item 2)**.
2. Adjust regulator knob **(Figure 68, item 3)** until gauge reads the appropriate pressure. Adjust regulator starting at 15 psi, raising the pressure to keep the belt from slipping up to the maximum shown in the following table.

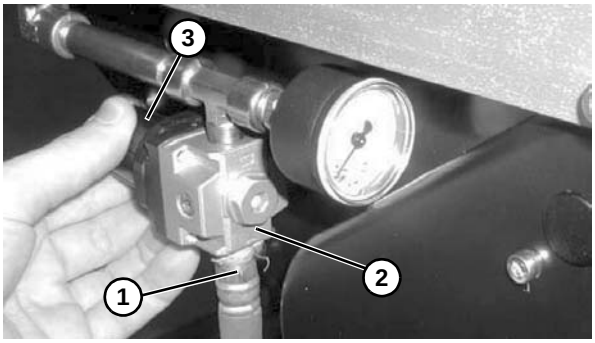


Figure 68

Suggested Maximum Tensioning Air Pressure for Center Drive Conveyors	
Width	**Pressure**
6" (152 mm)	15-30 psi (103-207 kPa)
8" (203 mm)	15-40 psi (103-276 kPa)
10" (254 mm)	15-50 psi (103-345 kPa)
14" (356 mm)	15-60 psi (103-414 kPa)
18" (457 mm)	15-70 psi (103-483 kPa)
24" (610 mm) & wider	15-80 psi (103-552 kPa)

3. If proper belt tension cannot be achieved before the out of tension indicator **(Figure 69, item 1)** begins to turn red, the belt must be replaced.

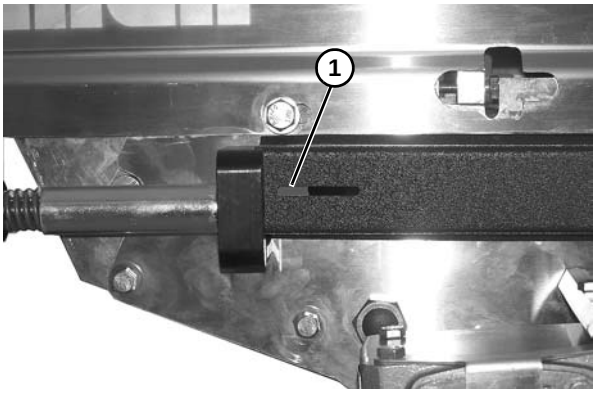


Figure 69

4. If belt tracking is necessary, refer to “Conveyor Belt Tracking” on page 27 and “Center Drive Module Tracking” on page 27.

B - With Manual Tensioning

⚠ WARNING

Threaded rod end may be sharp. Cover with guard while adjusting tension knob.

HANDLE WITH CARE.

1. Turn knob **(Figure 70, item 1)** on each side of the center drive clockwise until the tensioning spring **(Figure 70, item 2)** is completely behind the spring cover **(Figure 70, item 3)**. There should be approximately a 1/8" gap **(Figure 71, item 1)** between knob and spring cover.

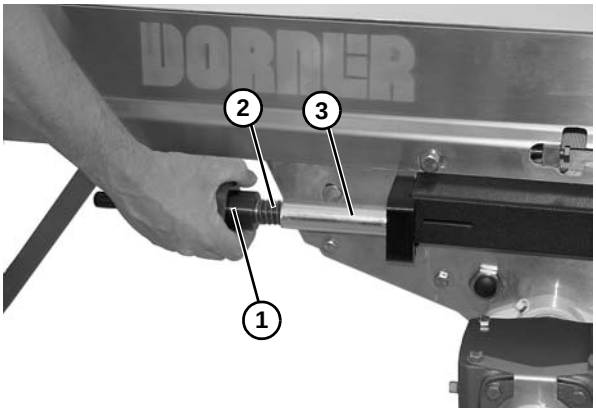


Figure 70

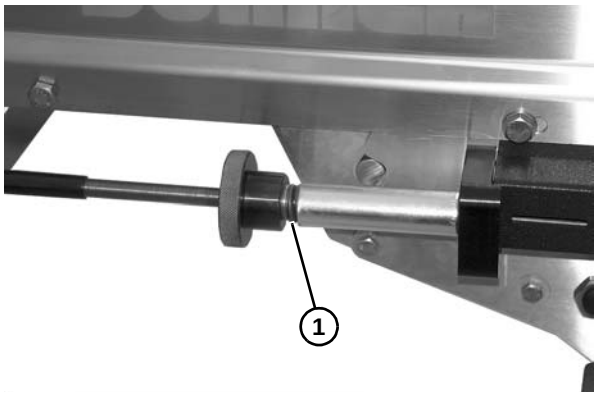


Figure 71

2. As normal belt stretch occurs over time, the spring **(Figure 70, item 2)** will be exposed out of the spring cover **(Figure 70, item 3)**. When the spring is exposed over 1/2", or if conveyor belt slippage occurs, retighten knob **(Figure 70, item 1)** on each side of the center drive clockwise until tensioning spring is completely behind the spring cover.
3. If proper belt tension cannot be achieved before the out of tension indicator **(Figure 69, item 1)** begins to turn red, the belt must be replaced.
4. If belt tracking is necessary, refer to “Conveyor Belt Tracking” on page 27 and “Center Drive Module Tracking” on page 27.

Conveyor Belt Tracking

1. Tighten or loosen screw **(Figure 72, item 1)** on each side to correct tracking. Align the same arrows **(Figure 72, item 2)** and marks **(Figure 72, item 3)** on each side of the conveyor as a starting point for tracking the belt.

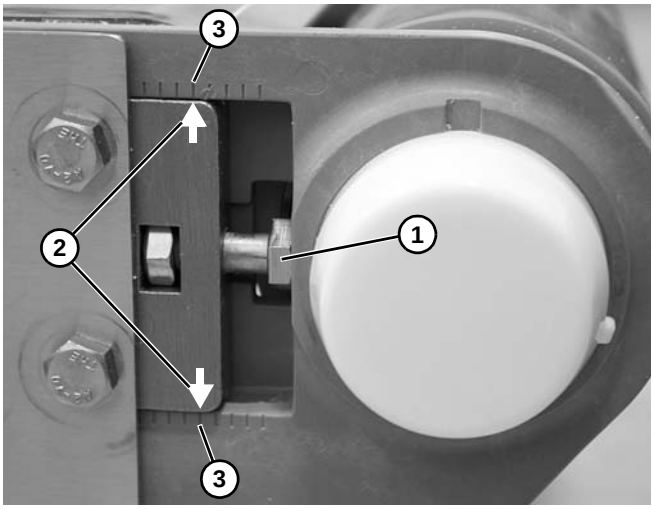


Figure 72

Center Drive Module Tracking

V-Guided Belts

V-guided belts do not require tracking adjustment.

Non V-Guided Belts

Non V-guided belt center drives are equipped with tracking screws.

Non V-guided belt center drives are equipped with tracking cams. Adjust center drive tracking with the conveyor running.

1. Inspect belt as it exits the center drive:
   a. Belt tracking normally, no adjustment required.
   b. If the belt is not tracking normally, adjust the cam on the side where the belt is running tight.
2. If necessary, loosen the center drive fastening screws **(Figure 73, item 1)** on the side of the center drive that requires adjustment.

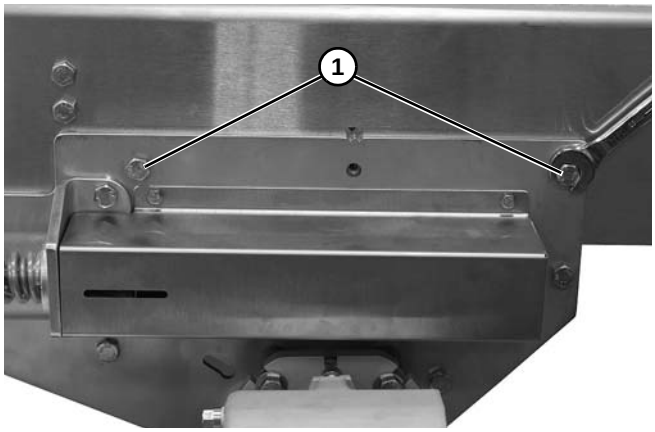


Figure 73

3. Rotate the tracking cam **(Figure 74, item 1)** left or right in small increments. After each adjustment, watch the belt as it exits the center drive. Continue to rotate the tracking cam until the conveyor belt is tracking normally.

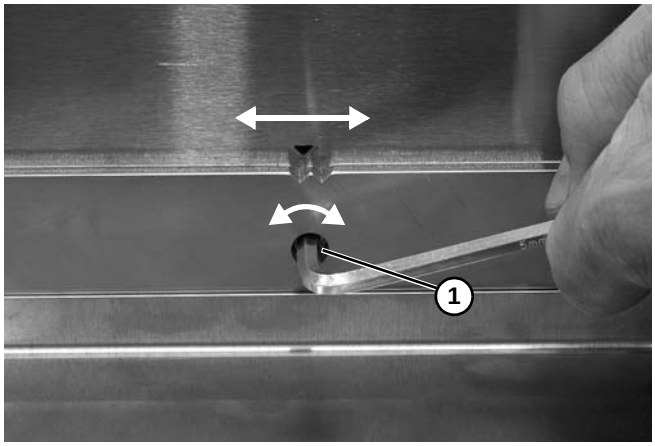


Figure 74

4. Tighten the center drive fastening screws **(Figure 73, item 1)** to 14-16 ft-lbs (19-22 Nm).

Drive 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. Remove conveyor belt. Refer to "Conveyor Belt Replacement" on page 18.
3. Remove two headplate screws **(Figure 75, item 1)**. Repeat on opposite side of the conveyor.

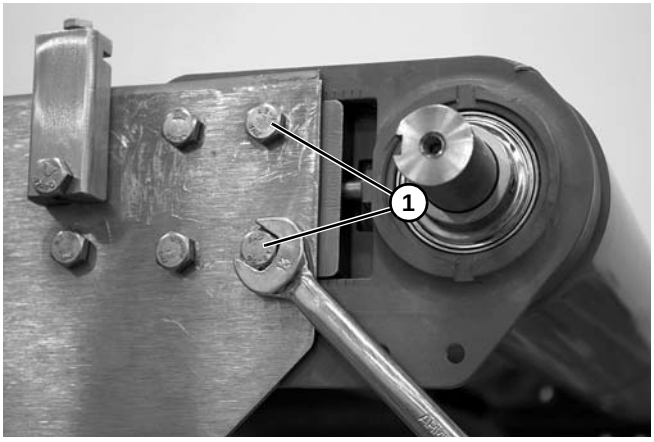


Figure 75

4. Slide the drive spindle assembly **(Figure 76, item 1)** off the drive tail blocks **(Figure 76, item 2)**.

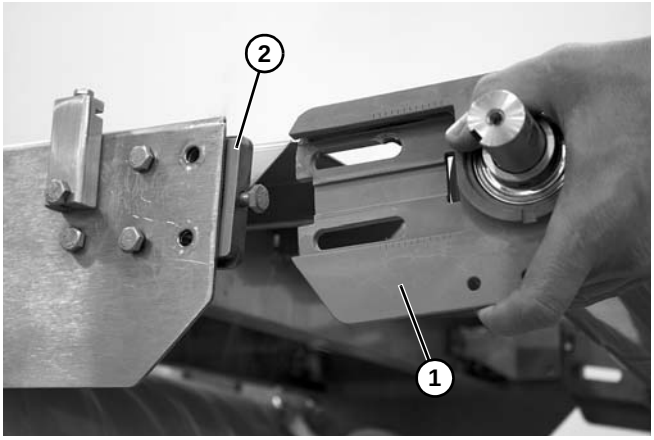


Figure 76

5. Remove the bearing cover **(Figure 77, item 1)**.

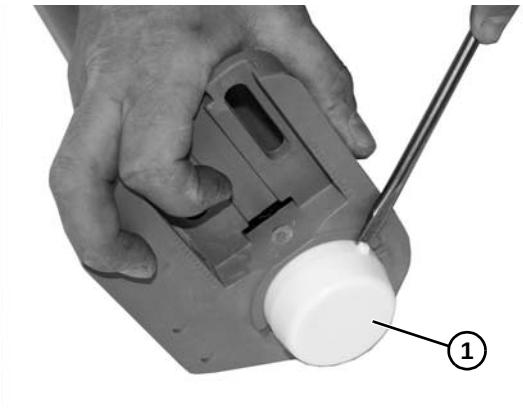


Figure 77

6. Loosen two set screws **(Figure 78, item 1)**.

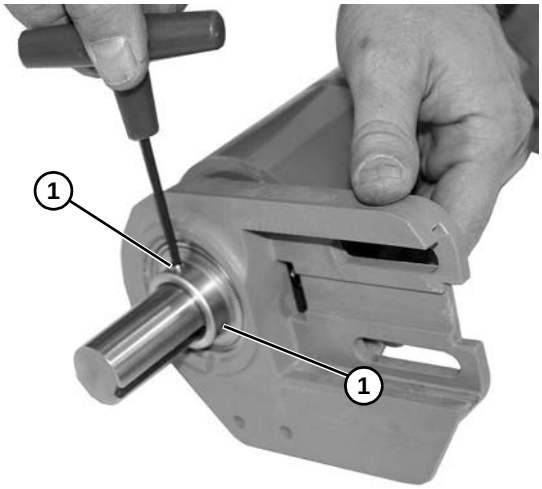


Figure 78

7. Slide the headplate with bearing **(Figure 79, item 1)** off the shaft **(Figure 79, item 2)**.

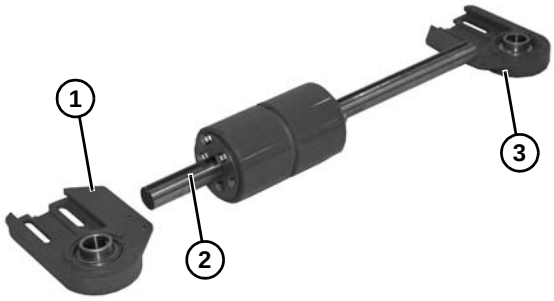


Figure 79

8. Repeat for opposite side headplate **(Figure 79, item 3)**.
9. If necessary, refer to "Bearing Replacement" on page 36 for replacing bearing in each headplate.
10. Install parts in reverse order of removal.

Idler Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

1. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 18.

⚠ CAUTION

Support bracket (Figure 80, item 2) will not be attached and could fall.

2. Remove two headplate screws **(Figure 80, item 1)**. Repeat on opposite side of the conveyor.

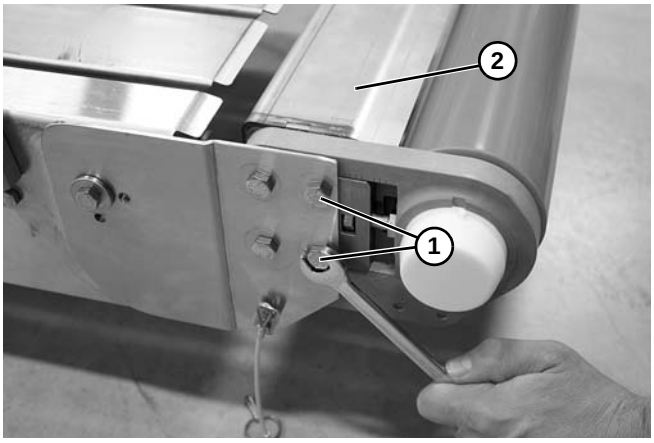


Figure 80

3. Remove support bracket **(Figure 81, item 1)**.

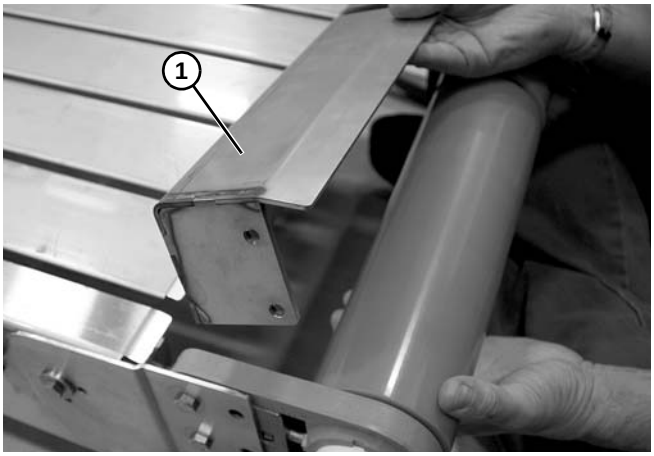


Figure 81

4. Slide the idler spindle assembly **(Figure 82, item 1)** off the pivot tail blocks **(Figure 82, item 2)**.

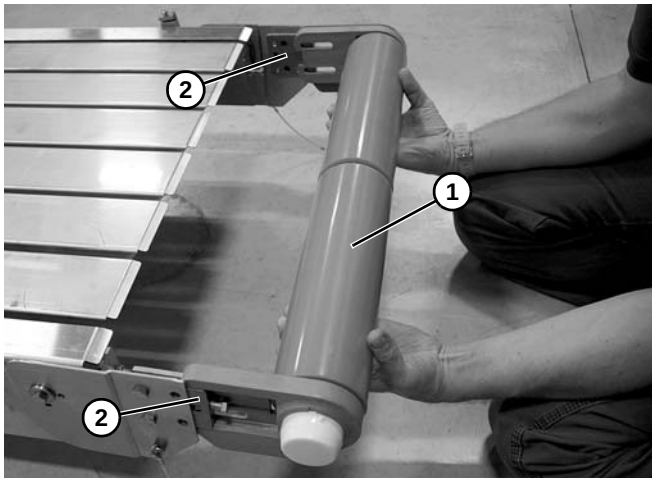


Figure 82

5. Remove the bearing cover **(Figure 83, item 1)**. Repeat on opposite side.

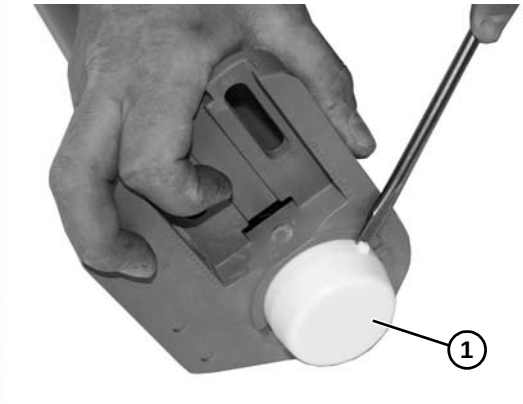


Figure 83

6. Loosen two set screws **(Figure 84, item 1)**.

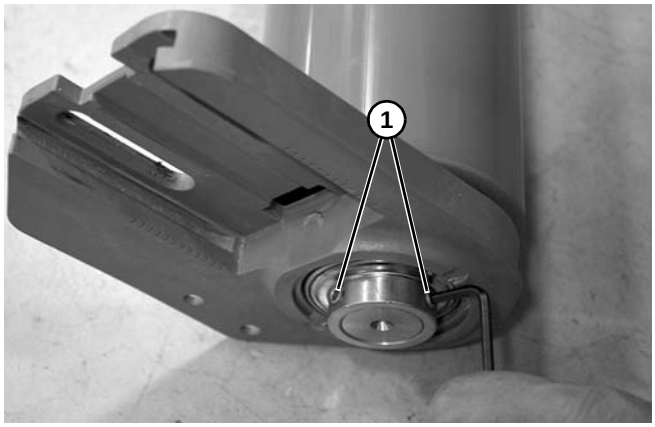


Figure 84

7. Slide the headplate with bearing **(Figure 85, item 1)** off the shaft **(Figure 85, item 2)**.

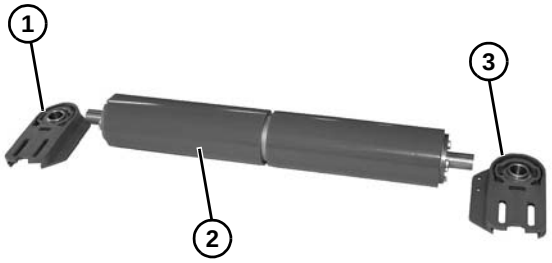


Figure 85

8. Repeat for opposite side headplate **(Figure 85, item 3)**.
9. If necessary, refer to "Bearing Replacement" on page 36 for replacing bearing in each headplate.
10. Install parts in reverse order of removal.
11. Check level of idler tail by placing a level **(Figure 86, item 1)** on top of bed rail and support bracket.

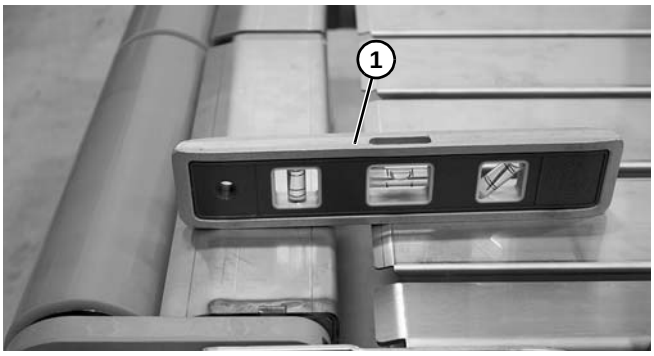


Figure 86

12. If needed, raise idler tail and loosen nut **(Figure 87, item 1)**. Tighten or loosen screw **(Figure 87, item 2)** to move idler tail up or down to level with conveyor bed rail. Ensure that nuts are tight after leveling.

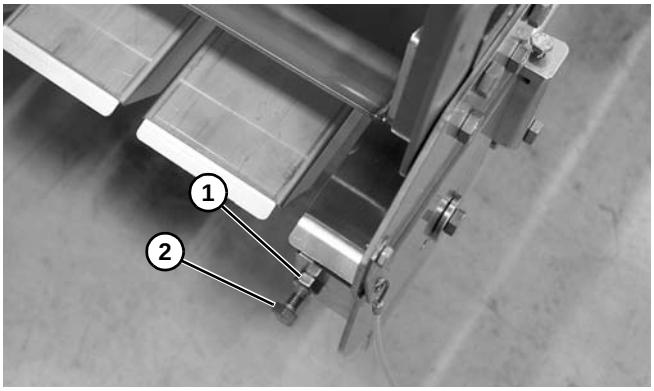


Figure 87

Nose Bar Idler Spindle Replacement

WARNING

SEVERE HAZARD!

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

1. Remove conveyor belt. Refer to "Conveyor Belt Replacement" on page 18.
2. Slide the nose bar idler **(Figure 88, item 1)** off the pivot tail blocks **(Figure 88, item 2)**.

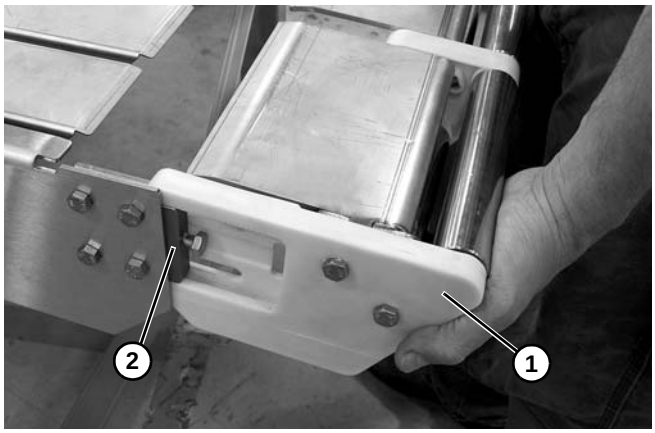


Figure 88

3. Remove headplate screws **(Figure 89, item 1)**.

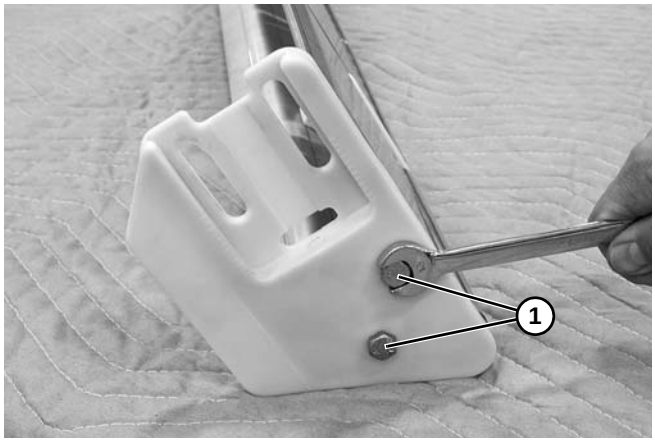


Figure 89

4. Slide off end plate **(Figure 90, item 1)**.

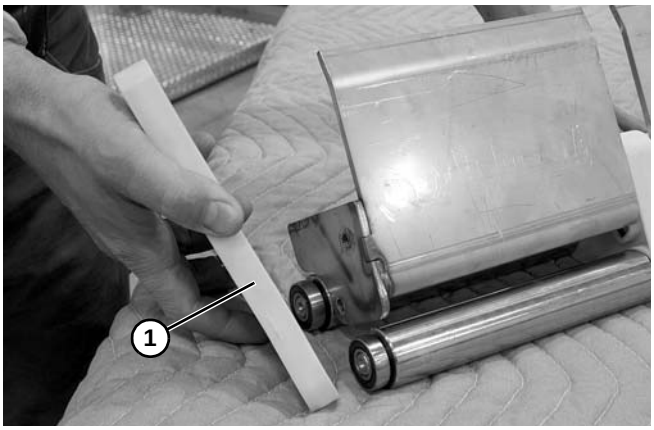


Figure 90

5. Remove idler roller bearing assemblies **(Figure 91, item 1)** from nose bar puck.

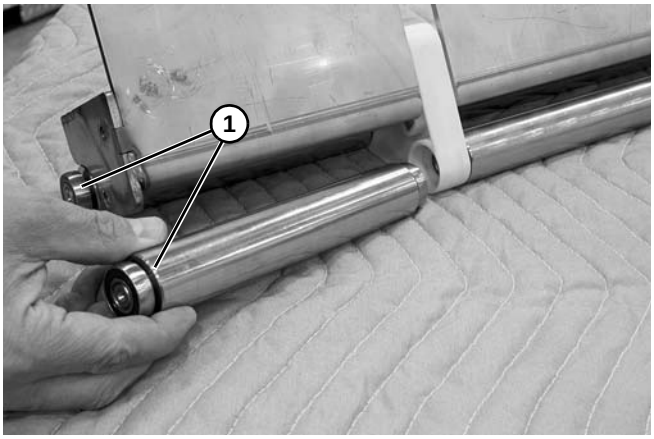


Figure 91

6. Remove nose bar puck **(Figure 92, item 1)**.

Figure 92

7. Repeat as needed.
8. Install parts in reverse order of removal.

9. For tip up tail only:

   a. Check level of idler tail by placing a level **(Figure 93, item 1)** on top of bed rail and support bracket.

Figure 93

   b. If needed, raise idler tail and loosen nut **(Figure 94, item 1)**. Tighten or loosen screw **(Figure 94, item 2)** to move idler tail up or down to level with conveyor bed rail. Ensure that nuts are tight after leveling.

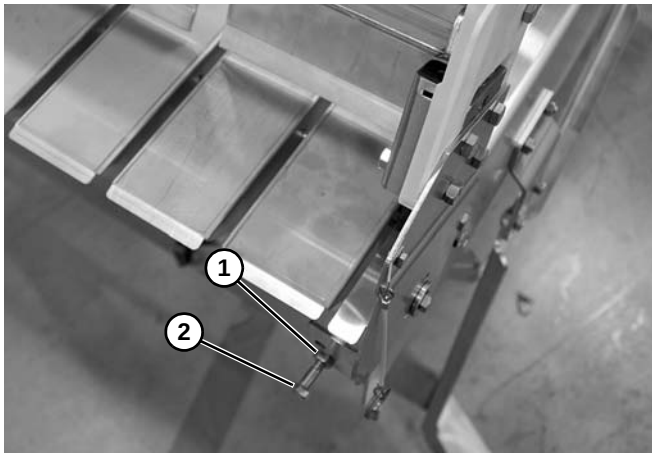


Figure 94

Center Drive Spindle Replacement

⚠ WARNING

SEVERE HAZARD!

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

⚠ WARNING

Exposed moving parts can cause severe injury.

REMOVE COMPRESSED AIR SUPPLY before removing guards or performing maintenance.

- A – Tensioner Pulley Removal
- B – Idler Pulley Removal
- C – Drive Pulley Removal

A – Tensioner Pulley Removal

1. Remove air supply and remove hose **(Figure 95, item 1)** from the center drive.

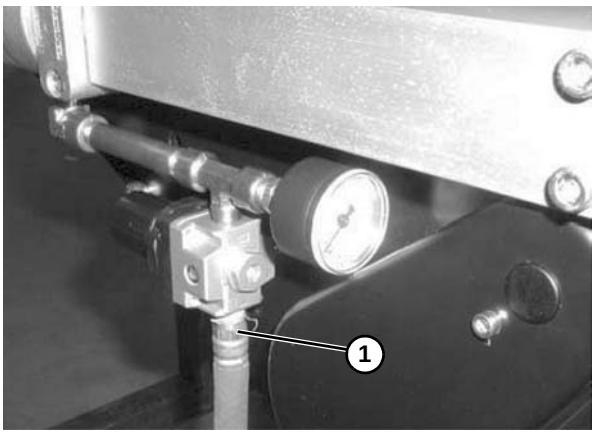


Figure 95

2. Tip up tail **(Figure 96, item 1)**.

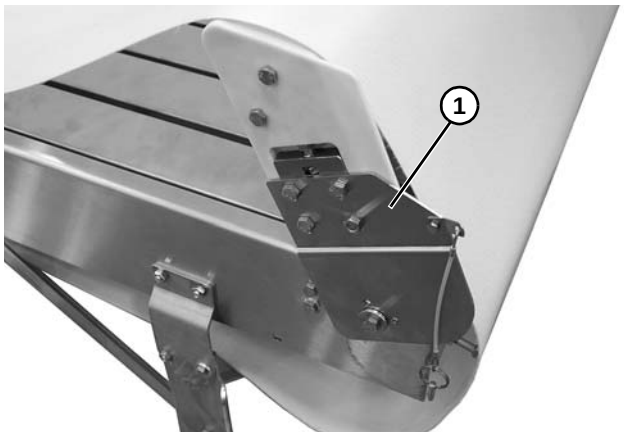


Figure 96

3. Rotate tension nut **(Figure 97, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

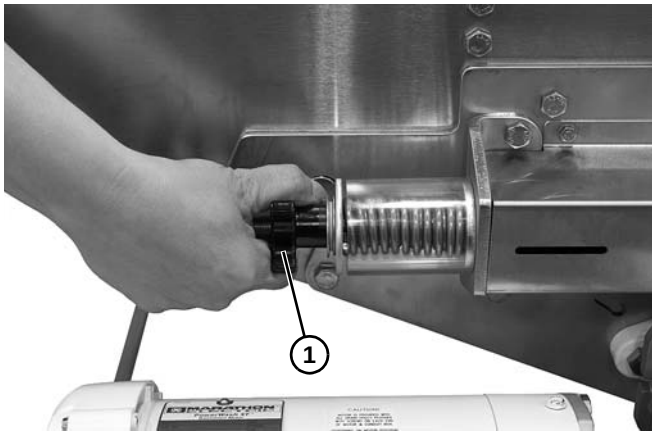


Figure 97

4. Remove four screws **(Figure 98, item 1)** and cover **(Figure 98, item 1)**.

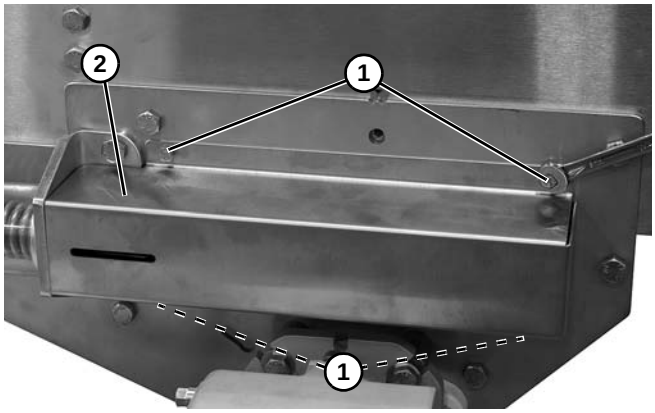


Figure 98

5. Remove two screws **(Figure 99, item 1)** from each side of the center drive. Remove the stationary guard assembly **(Figure 99, item 2)**.

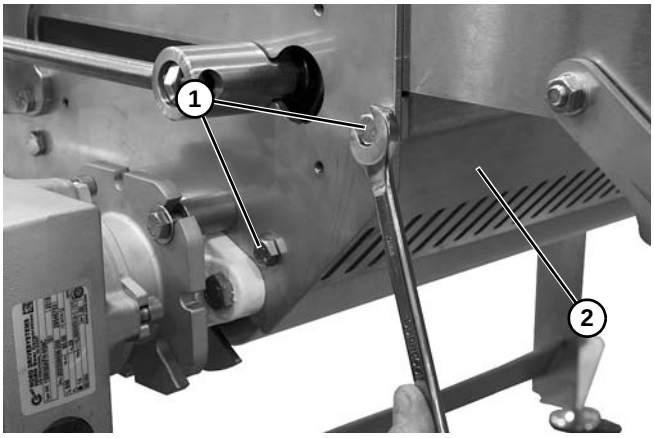


Figure 99

6. Loosen tension nut **(Figure 100, item 1)** on each side of the center drive so that the tension pulley spacer **(Figure 100, item 2)** aligns with hole **(Figure 100, item 3)**.

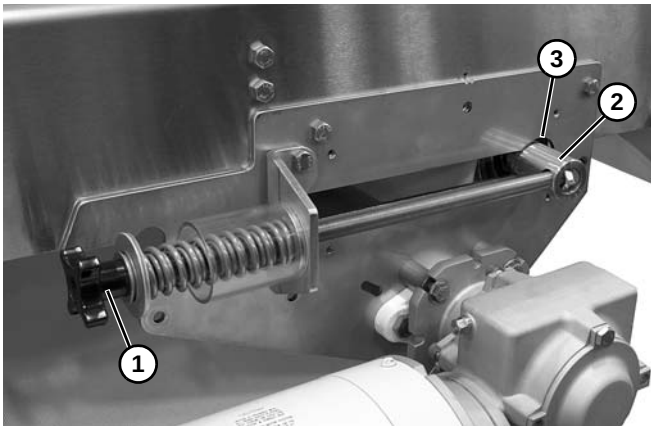


Figure 100

7. Remove two screws **(Figure 101, item 1)** from plate **(Figure 101, item 2)** on both sides of the center drive.

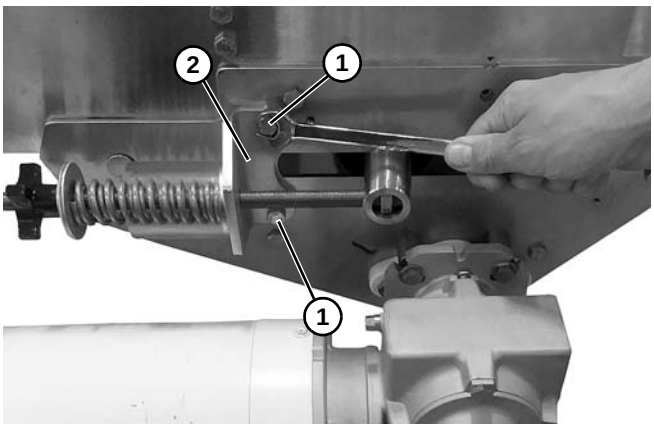


Figure 101

8. Remove tension assembly **(Figure 102, item 1)** on both sides of the center drive.

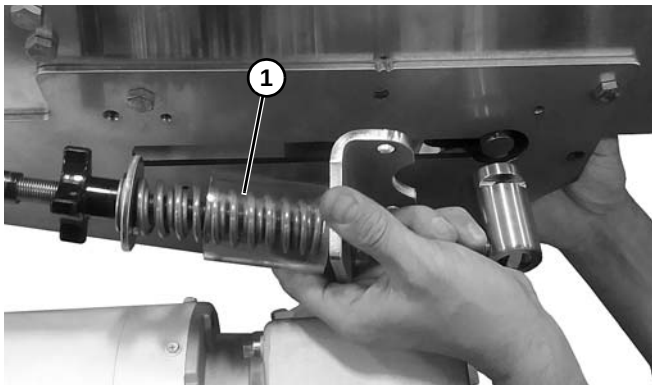


Figure 102

9. Slide shaft **(Figure 103, item 1)** into the tensioner pulley **(Figure 103, item 2)**. Remove the tensioner pulley**.**

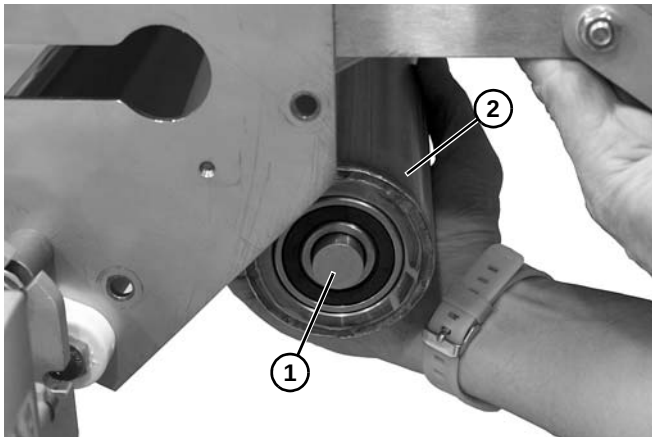


Figure 103

10. Remove the shaft **(Figure 104, item 1)** from the tensioner pulley **(Figure 104, item 2)**.

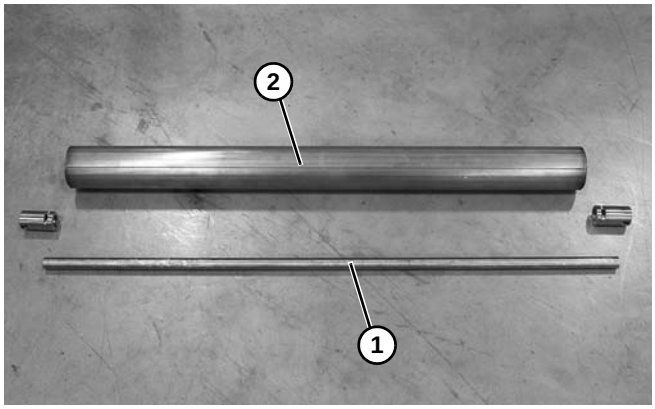


Figure 104

B – Idler Spindle Replacement

1. Remove air supply and remove hose **(Figure 105, item 1)** from the center drive.

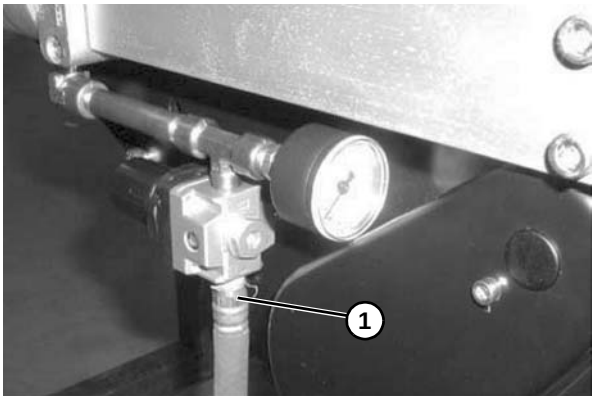


Figure 105

2. Rotate tension nut **(Figure 106, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

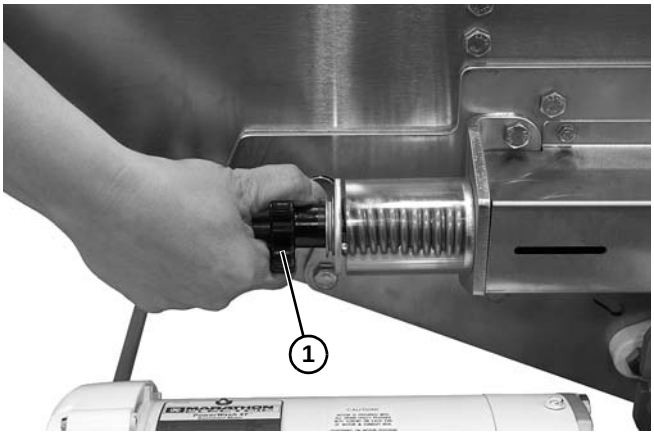


Figure 106

3. Remove screw **(Figure 107, item 1)** from each side of the center drive from the idler guard assembly.

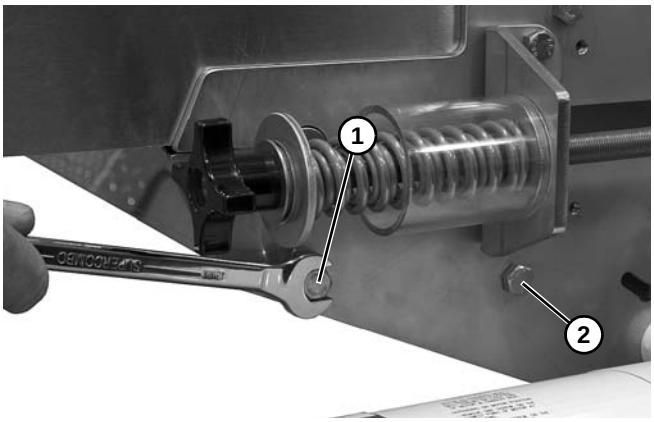


Figure 107

4. Loosen screw **(Figure 107, item 2)** on each side of the center drive.

5. Swing idler guard assembly **(Figure 108, item 1)** down. Remove the idler pulley **(Figure 108, item 2)**.

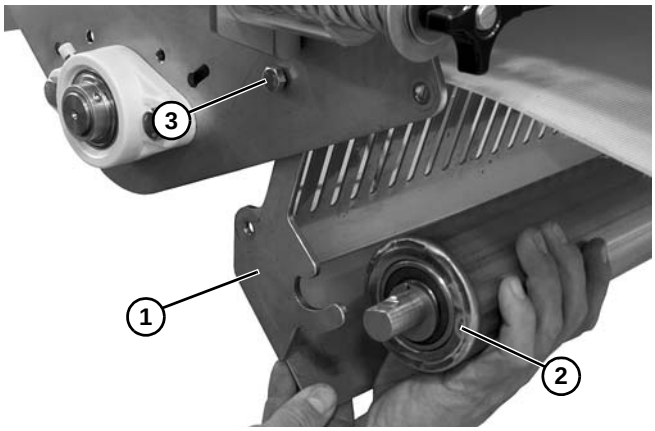


Figure 108

6. Remove the spacers **(Figure 109, item 1)** and shaft **(Figure 109, item 2)** from the idler pulley **(Figure 109, item 3)**.

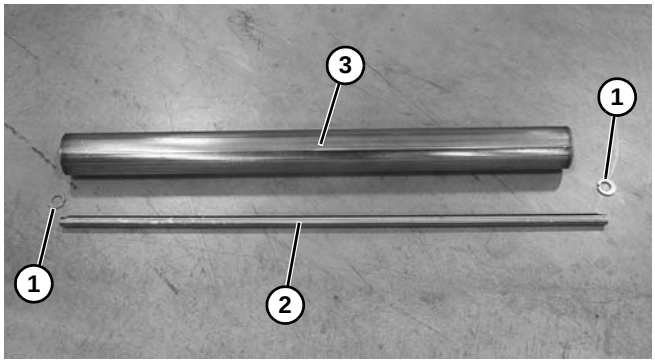


Figure 109

C – Drive Spindle Replacement

⚠ WARNING

Drive shaft keyway may be sharp.
HANDLE WITH CARE.

1. Remove air supply and remove hose **(Figure 110, item 1)** from the center drive.

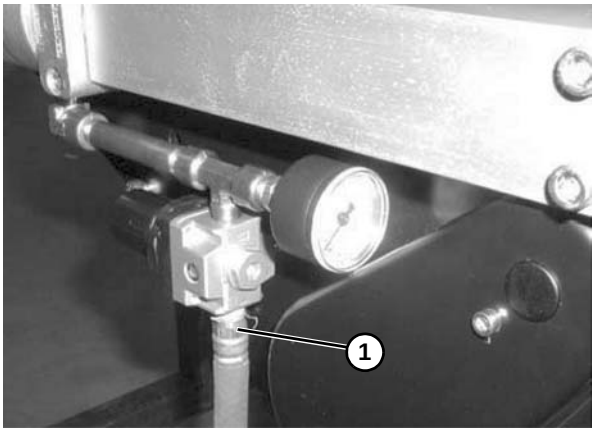


Figure 110

2. Rotate tension nut **(Figure 111, item 1)** on each side of the center drive counterclockwise to remove all tension on the belt.

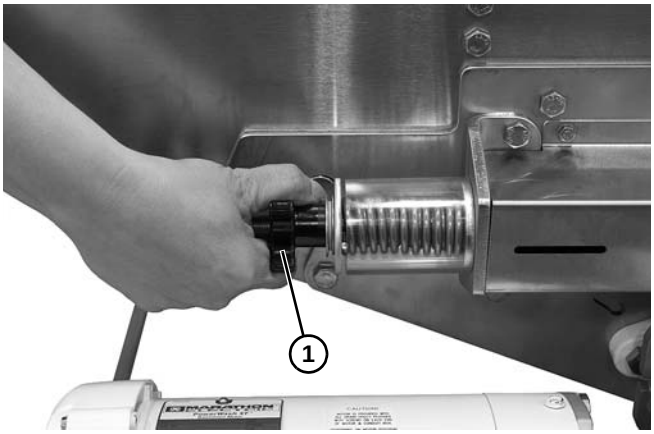


Figure 111

3. Complete steps 6 thru 15 of the Center Drive "Belt Removal" on page 20".
4. Remove gearmotor and gear reducer. See Center Drive Package Manual 851-884 for detailed instructions.
5. Loosen bearing set screws **(Figure 112, item 1)** on both sides of the center drive.

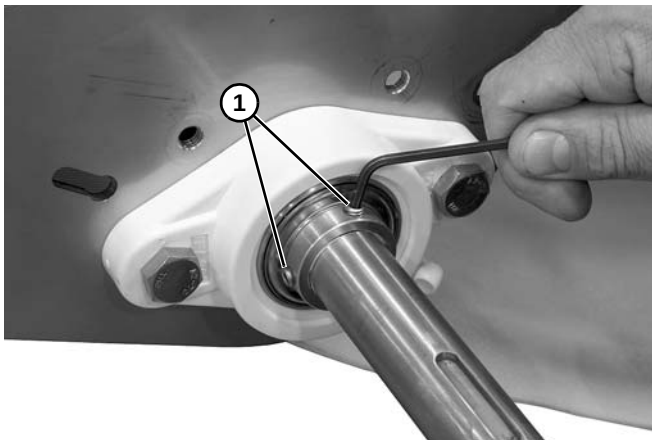


Figure 112

6. Remove two screws **(Figure 113, item 1)** from the bearing housing **(Figure 113, item 2)** on both sides of the center drive.

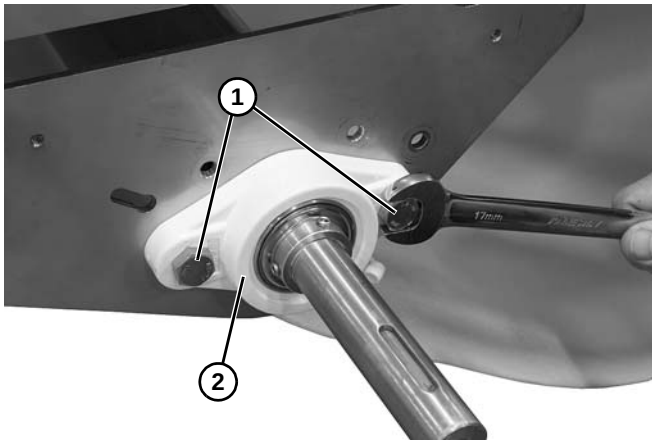


Figure 113

7. Slide drive pulley **(Figure 114, item 1)** out.

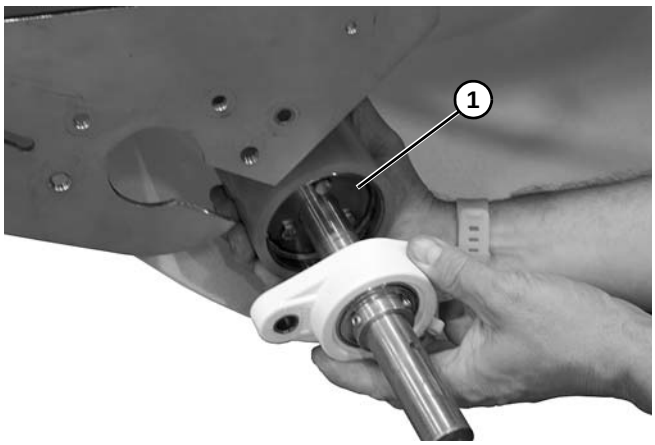


Figure 114

Bearing Replacement

⚠ WARNING

SEVERE HAZARD!

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

Drive and Idler Bearing Replacement

⚠ WARNING

PUNCTURE HAZARD!

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

1. For drive bearing, refer to "Drive Spindle Replacement" on page 28. Follow steps 1 through 7.
2. For idler bearing, refer to "Idler Spindle Replacement" on page 29. Follow steps 1 through 7.
3. Turn bearing **(Figure 115, item 1)** to align with slots **(Figure 115, item 2)** in bearing housing. Then remove bearing.

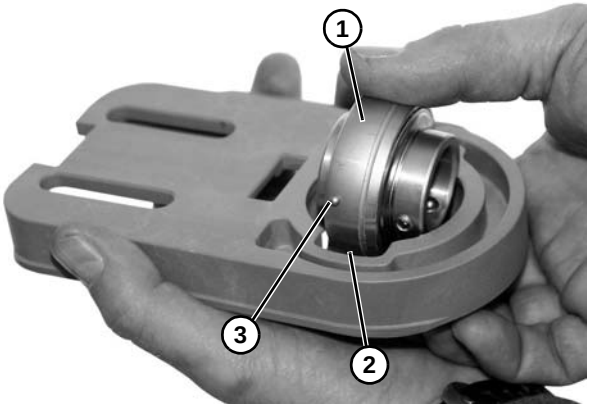


Figure 115

4. Inspect bearing housing bearing surface. Replace if worn or damaged. Refer to "Service Parts" on page 44.
5. Insert bearing **(Figure 115, item 1)** into housing slot. Locate anti-rotation nub **(Figure 115, item 3)** to align with slot **(Figure 115, item 2)** and twist bearing into housing.

Center Drive Bearing Replacement

The bearings in 7350 Series Center Drive Assemblies are not removable. Replace the entire pulley assembly when worn.

When replacing the bearing housing, make sure that the grease fitting **(Figure 116, item 1)** is facing down.

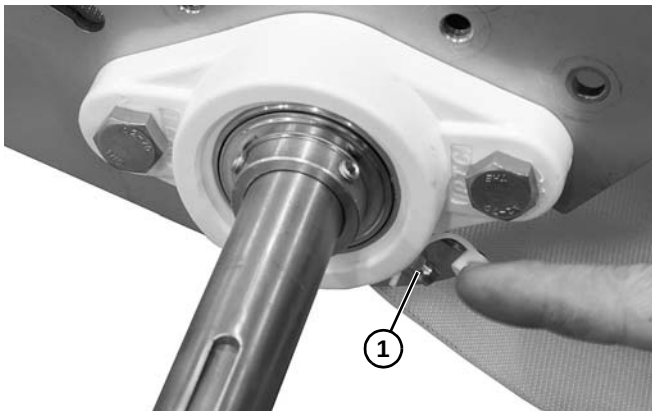


Figure 116

Knuckle Maintenance

WARNING

SEVERE HAZARD!

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

Lower Knuckle

Bearing Replacement

1. Remove screws **(Figure 117, item 1)**.

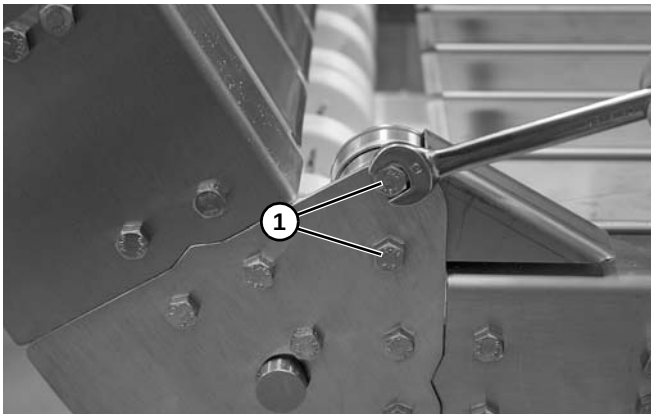


Figure 117

2. Remove bearing guard **(Figure 118, item 1)** with bearing.

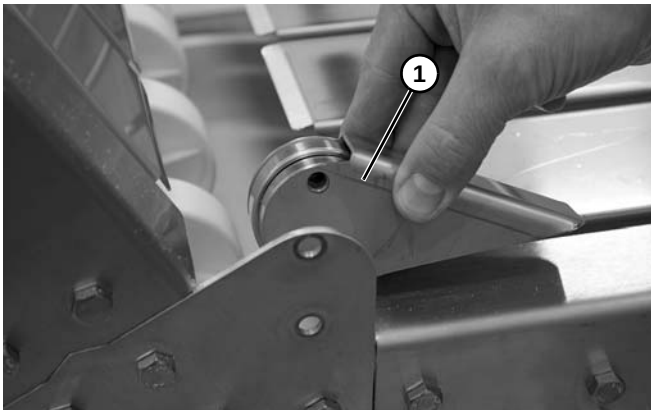


Figure 118

3. Remove bearing **(Figure 119, item 1)**.

Figure 119

4. Install parts in reverse order of removal.

Puck Replacement

1. Remove screws **(Figure 117, item 1)** and bearing guard **(Figure 118, item 1)**.
2. Remove belt. Refer to "Conveyor Belt Replacement" on page 18.
3. Remove screw **(Figure 120, item 1)** and shaft retainer **(Figure 120, item 2)** for lower shaft assembly. Repeat for the other side.

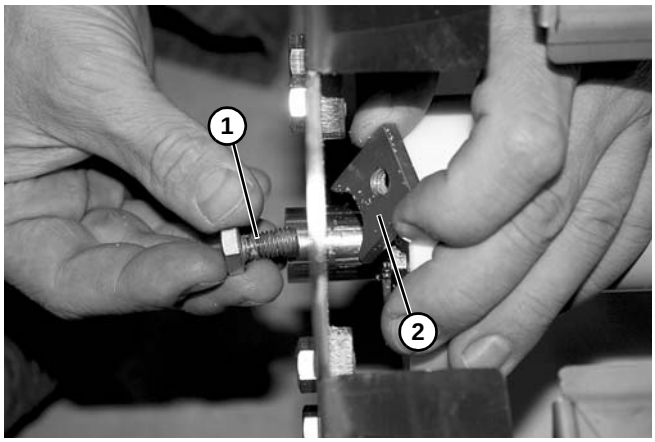


Figure 120

4. Remove lower shaft assembly **(Figure 121, item 1)**.

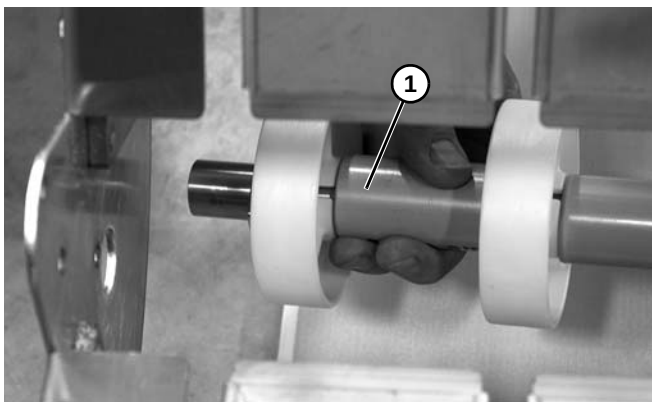


Figure 121

5. Insert an 8 mm **(Figure 122, item 1)** and 6 mm **(Figure 122, item 2)** hex wrench into the retainer plate.

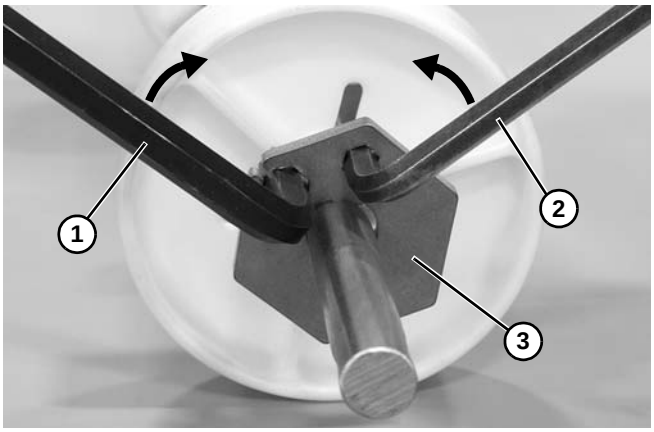


Figure 122

6. Move wrenches toward each other to unlock the retainer plate **(Figure 122, item 3)** and remove from the shaft.
7. Remove pucks **(Figure 123, item 1)** and spacers **(Figure 123, item 2)** from the shaft. Repeat as needed.

NOTE

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

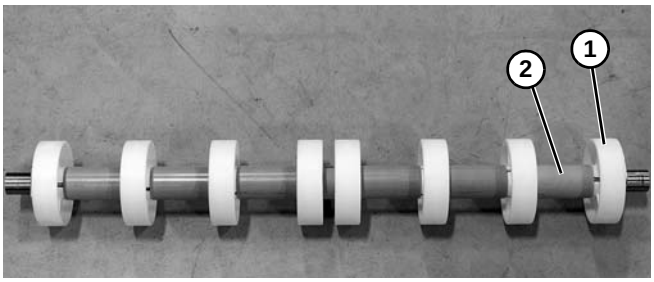


Figure 123

8. Install new spacers and pucks and secure to shaft with a retainer plate on both ends.
   a. Insert an 8 mm **(Figure 124, item 1)** and 6 mm **(Figure 124, item 2)** hex wrench into the retainer plate.

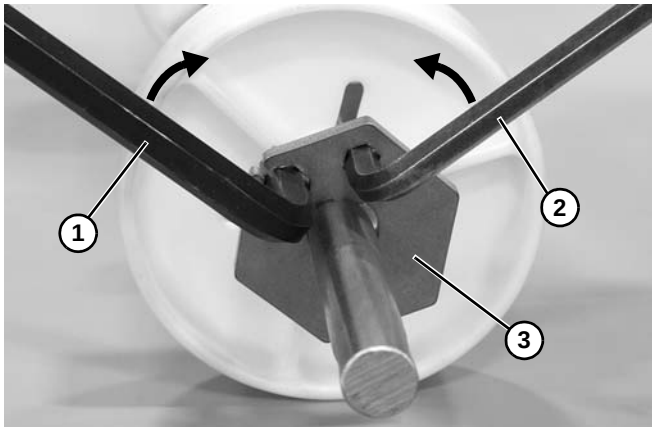


Figure 124

   b. Move wrenches toward each other to open the retainer plate **(Figure 124, item 3)** and install onto the shaft. Position retainer plate where needed.
   c. To lock the retainer plate **(Figure 125, item 1)** in place, move the wrenches **(Figure 125, item 2)** away from each other.

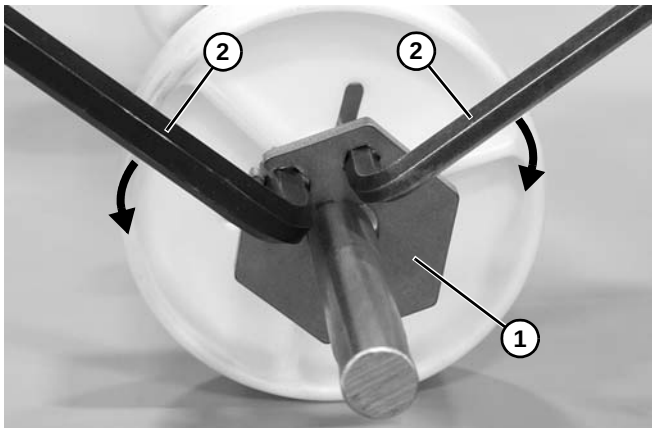


Figure 125

9. Install lower shaft assembly in reverse order of removal.

Upper Knuckle

Bearing Replacement

1. Remove screws **(Figure 126, item 1)**.

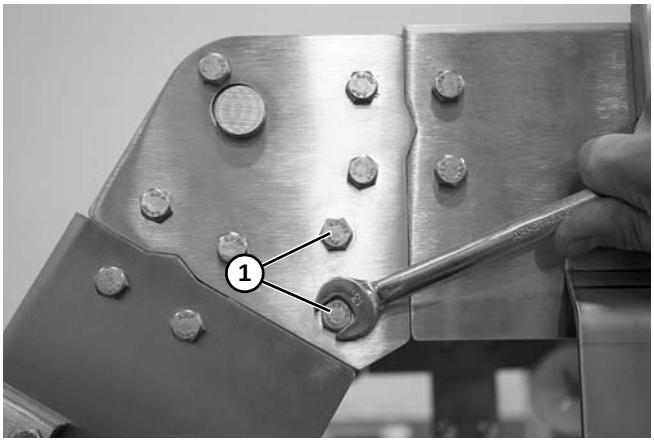


Figure 126

2. Remove bearing guard **(Figure 127, item 1)** with bearing.

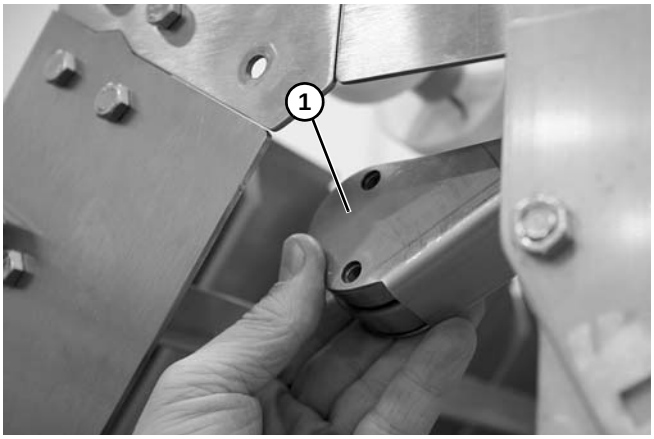


Figure 127

3. Remove bearing **(Figure 128, item 1)**.

Figure 128

4. Install parts in reverse order of removal.

Puck Replacement

1. Remove screws **(Figure 126, item 1)** and bearing guard **(Figure 127, item 1)**.
2. Remove belt. Refer to "Conveyor Belt Replacement" on page 18.
3. Remove screw **(Figure 129, item 1)** and shaft retainer **(Figure 129, item 2)** for upper shaft assembly. Repeat for the other side.

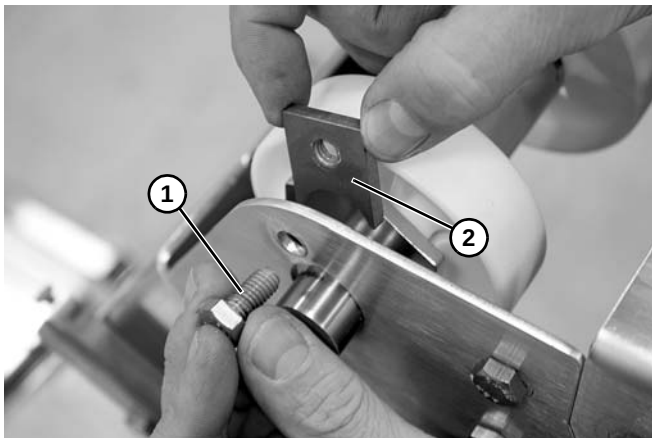


Figure 129

4. Remove upper shaft assembly **(Figure 130, item 1)**.

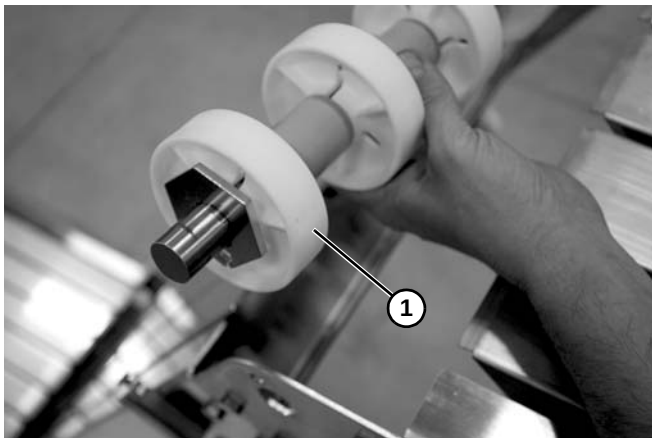


Figure 130

5. Insert an 8 mm **(Figure 131, item 1)** and 6 mm **(Figure 131, item 2)** hex wrench into the retainer plate.

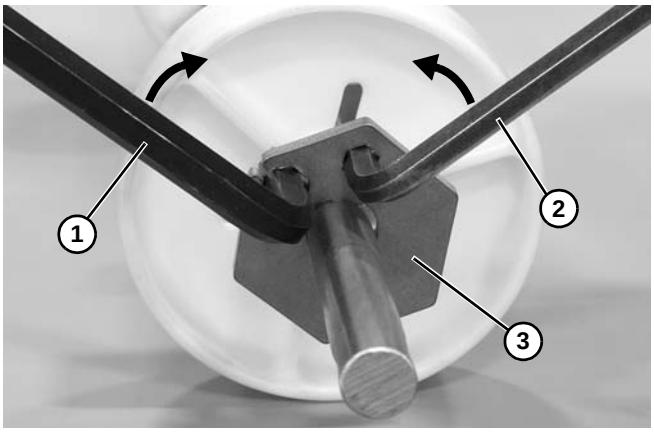


Figure 131

6. Move wrenches toward each other to unlock the retainer plate **(Figure 131, item 3)** and remove from the shaft.
7. Remove pucks **(Figure 132, item 1)** and spacers **(Figure 132, item 2)** from the shaft. Repeat as needed.

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

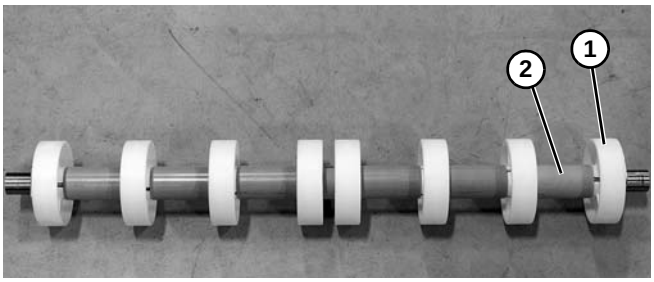


Figure 132

8. Install new spacers and pucks and secure to shaft with a retainer plate on both ends.
   a. Insert an 8 mm **(Figure 133, item 1)** and 6 mm **(Figure 133, item 2)** hex wrench into the retainer plate.

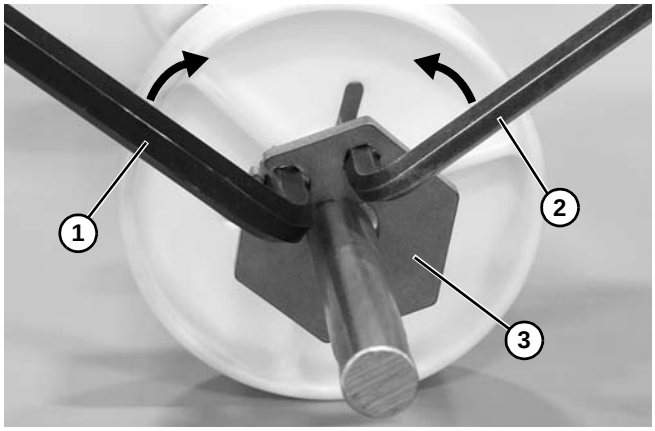


Figure 133

   b. Move wrenches toward each other to open the retainer plate **(Figure 133, item 3)** and install onto the shaft. Position retainer plate where needed.
   c. To lock the retainer plate **(Figure 134, item 1)** in place, move the wrenches **(Figure 134, item 2)** away from each other.

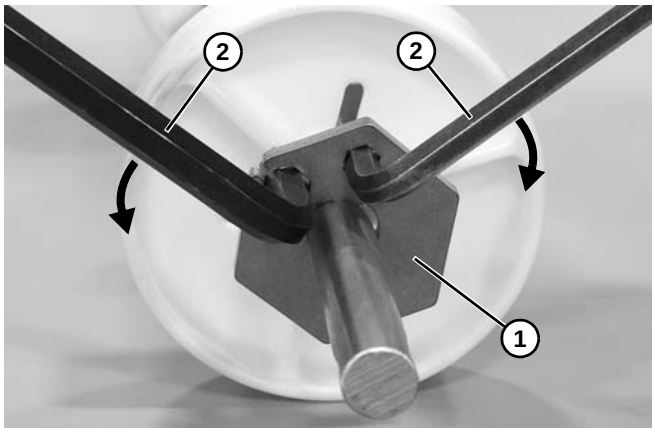


Figure 134

9. Install upper shaft assembly in reverse order of removal.

Belt Return Maintenance

WARNING

SEVERE HAZARD!

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

Flat Belt Returns 508 mm Wide and Wider

1. Loosen nut **(Figure 135, item 1)** and rotate return clip **(Figure 135, item 2)** up on both sides of conveyor. Loosely tighten nuts to hold clip in place.

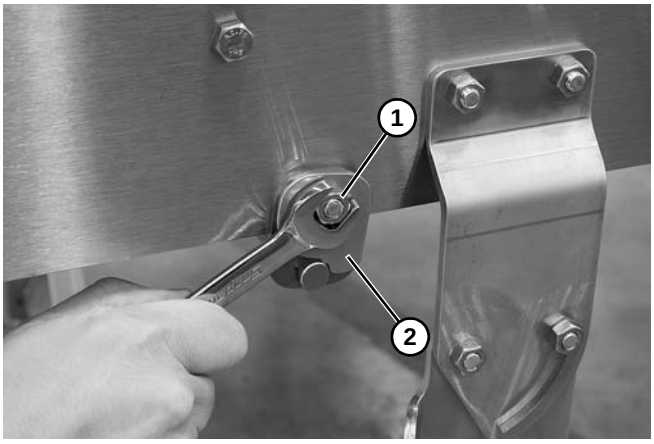


Figure 135

2. Remove belt return assembly **(Figure 136, item 1)** from return brackets **(Figure 136, item 2)**.

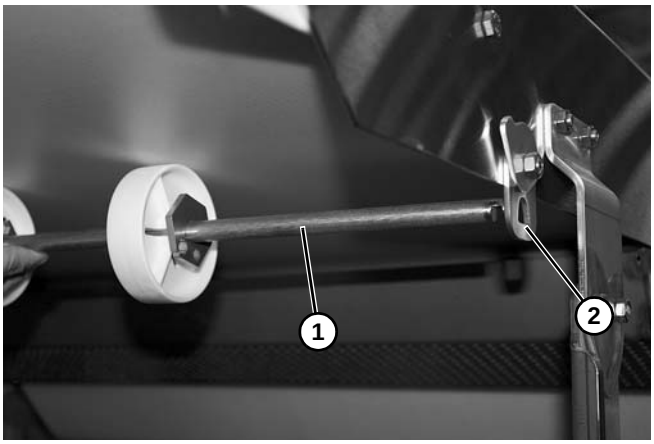


Figure 136

3. Insert an 8 mm **(Figure 137, item 1)** and 6 mm **(Figure 137, item 2)** hex wrench into the retainer plate.

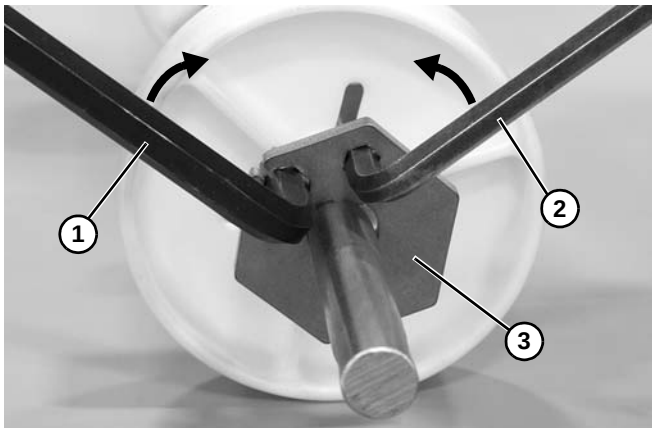


Figure 137

4. Move wrenches toward each other to unlock the retainer plate **(Figure 137, item 3)** and remove from the shaft.
5. Remove puck **(Figure 138, item 1)** from the shaft.

Figure 138

6. Repeat steps 3 through 5 as needed.

7. Install new pucks with retainer plates on both sides.

   a. Insert an 8 mm **(Figure 139, item 1)** and 6 mm **(Figure 139, item 2)** hex wrench into the retainer plate.

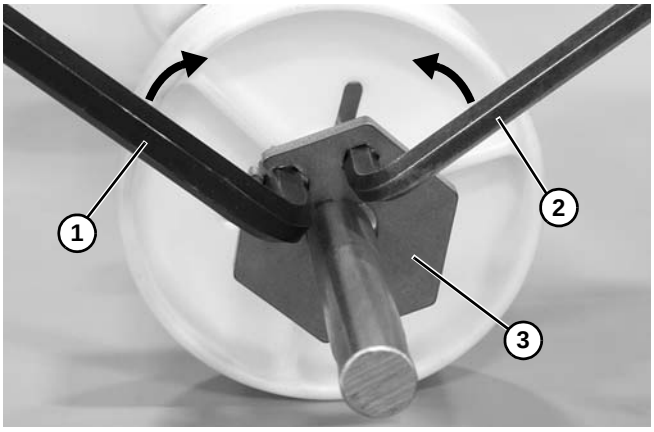


Figure 139

   b. Move wrenches toward each other to open the retainer plate **(Figure 139, item 3)** and install onto the shaft. Position retainer plate where needed.

   c. To lock the retainer plate **(Figure 140, item 1)** in place, move the wrenches **(Figure 140, item 2)** away from each other.

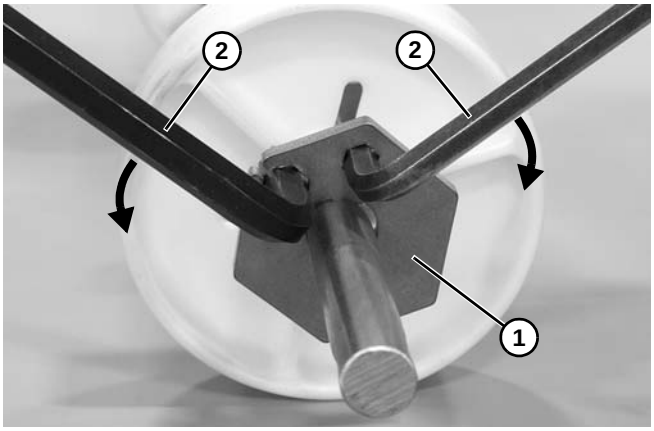


Figure 140

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

Cleated Belt and Flat Belt Returns Under 508 mm Wide

1. Loosen nut **(Figure 141, item 1)** and rotate return clip **(Figure 141, item 2)** up on both sides of conveyor. Loosely tighten nuts to hold clip in place.

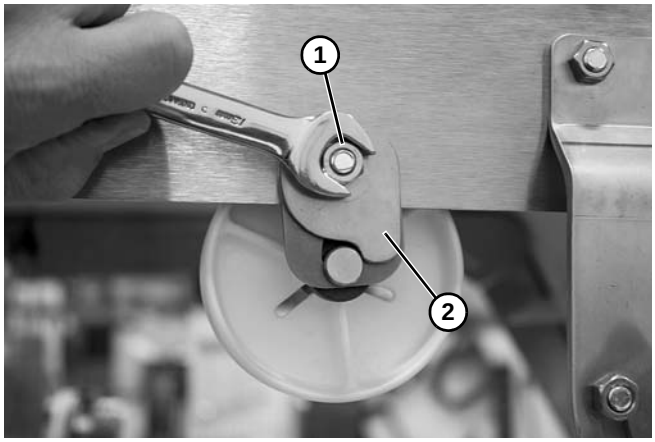


Figure 141

2. Remove puck **(Figure 142, item 1)**, stub shaft **(Figure 142, item 2)**, and spacer **(Figure 142, item 3)** from return bracket **(Figure 142, item 4)**.

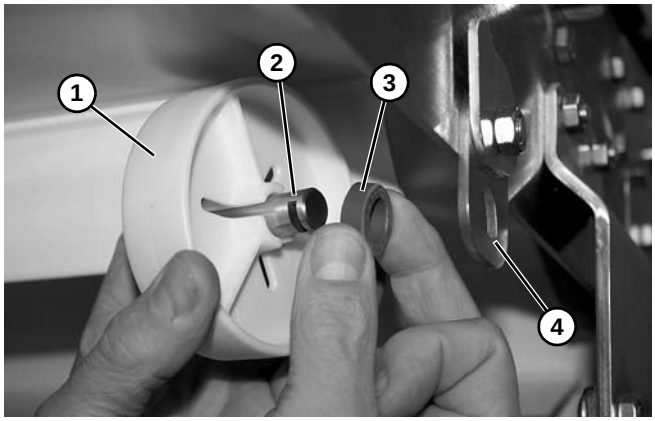


Figure 142

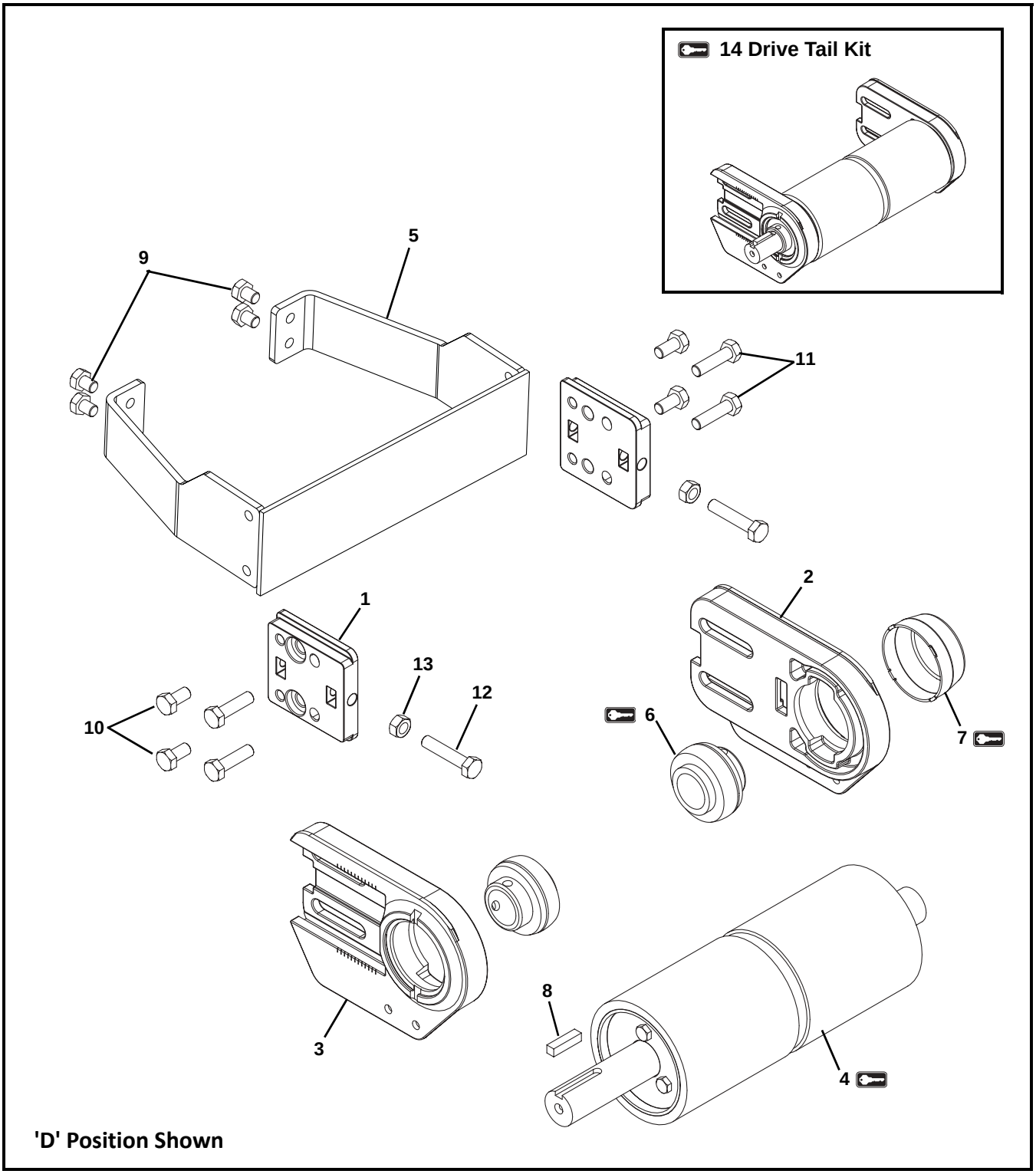
3. Replace worn or damaged parts.
4. Install parts in reverse order of removal.

Notes

Service Parts

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

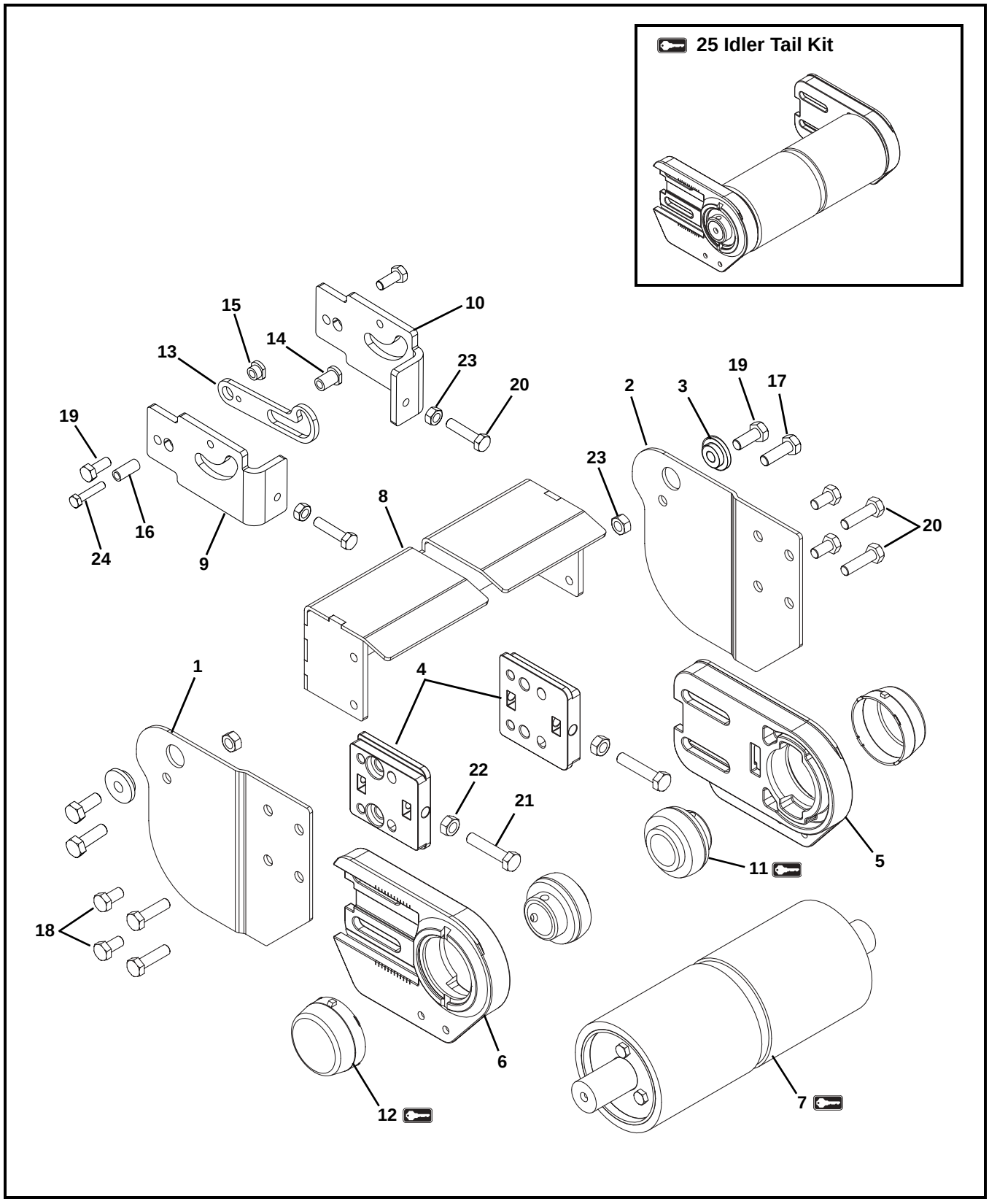
End Drive Tail



Item	Part Number	Description
1	516914	Drive Tail Block
2	532298	Headplate for A and B Position
3	532299	Headplate for D and C Position
4	516819-K0-WW	Drive Spindle for 'A' position
	516819-0K-WW	Drive Spindle for 'D' position
	516819-KK-WW	Dual Shaft Spindle
5	516841-WW	Support Bracket Assembly
6	802-161	Bearing
7	807-1454	Bearing Cap
8	912-108SS	Square Key, 0.25" x 1.00"
9	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
10	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
11	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
12	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
13	990802MSS	Lock Nut
14	520364-K0-WW	Drive Tail Kit for 'A' position (Includes Items 2, 3, 4, 7 and 9)
	520364-0K-WW	Drive Tail Kit for 'D' position (Includes Items 2, 3, 4, 7 and 9)
	520364-KK-WW	Dual Shaft Drive Tail Kit (Includes Items 2, 3, 4, 7 and 9)
WW = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 8 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

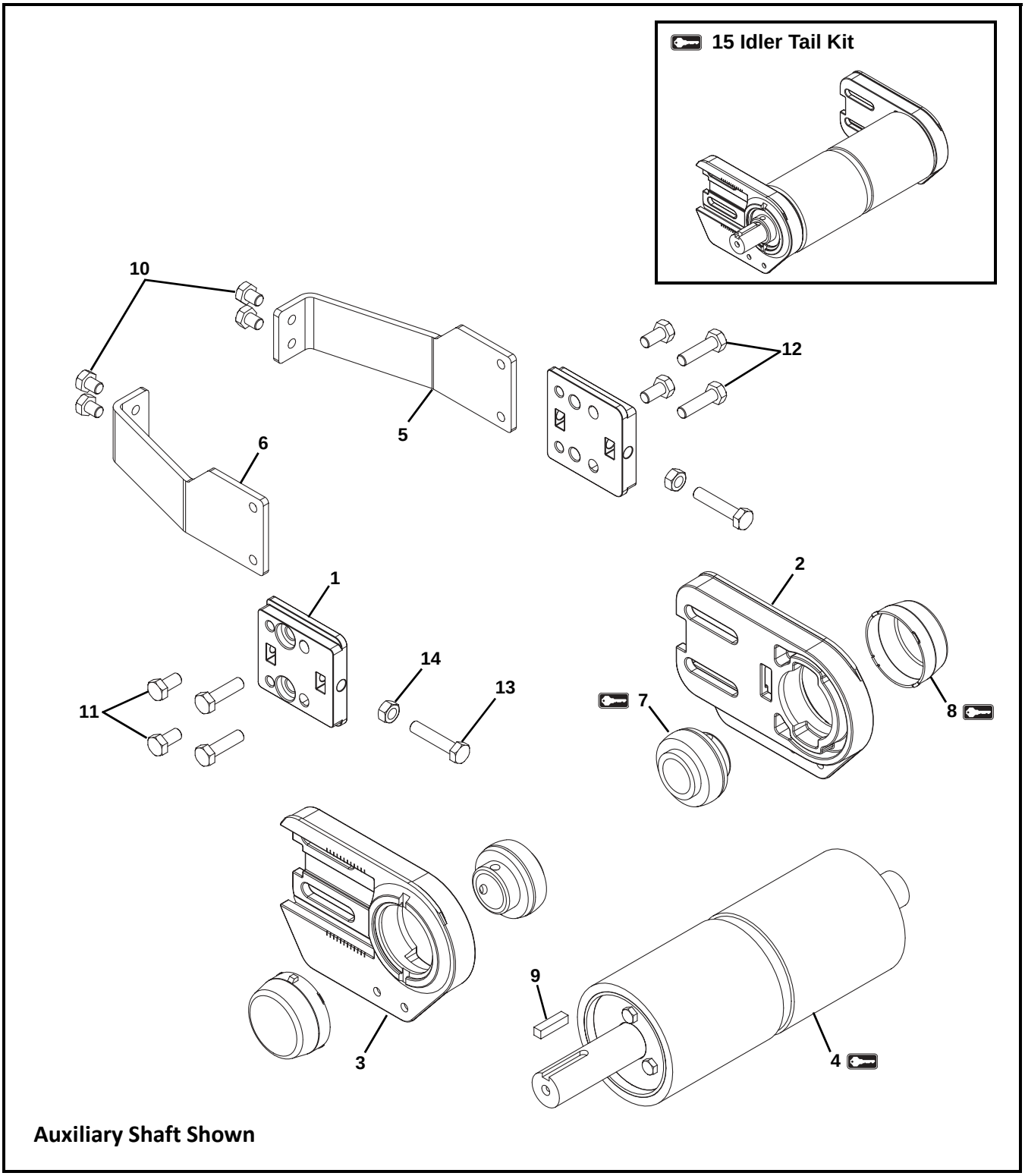
Tip-Up Idler Tail



Item	Part Number	Description
1	516848	Tip-Up Plate, Left Hand
2	516849	Tip-Up Plate, Right Hand
3	516850	Bushing
4	516914	Block
5	532298	Headplate 'A' Side
6	532299	Headplate 'D' Side
7	516819-00-WW	Idler Spindle
8	516852-WW	Bracket Assembly
9	518415-LH	Tip-Up Bracket, Left Hand
10	518415-RH	Tip-Up Bracket, Right Hand
11	802-161	Bearing
12	807-1454	Bearing Cap
13	520436	Tip Up Bracket
14	520437	Locking Lever
15	520438	Mount Bushing
16	520439	Sleeve
17	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
18	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
19	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
20	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
21	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
22	990802MSS	Lock Nut
23	990801MSS	Hex Nut
24	960630MSS	Hex Head Cap Screw, M6-1.00 x 30 mm
25	520364-00-WW	Idler Tail Kit (Includes items 5, 6, 7 and 11)
WW = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 8 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

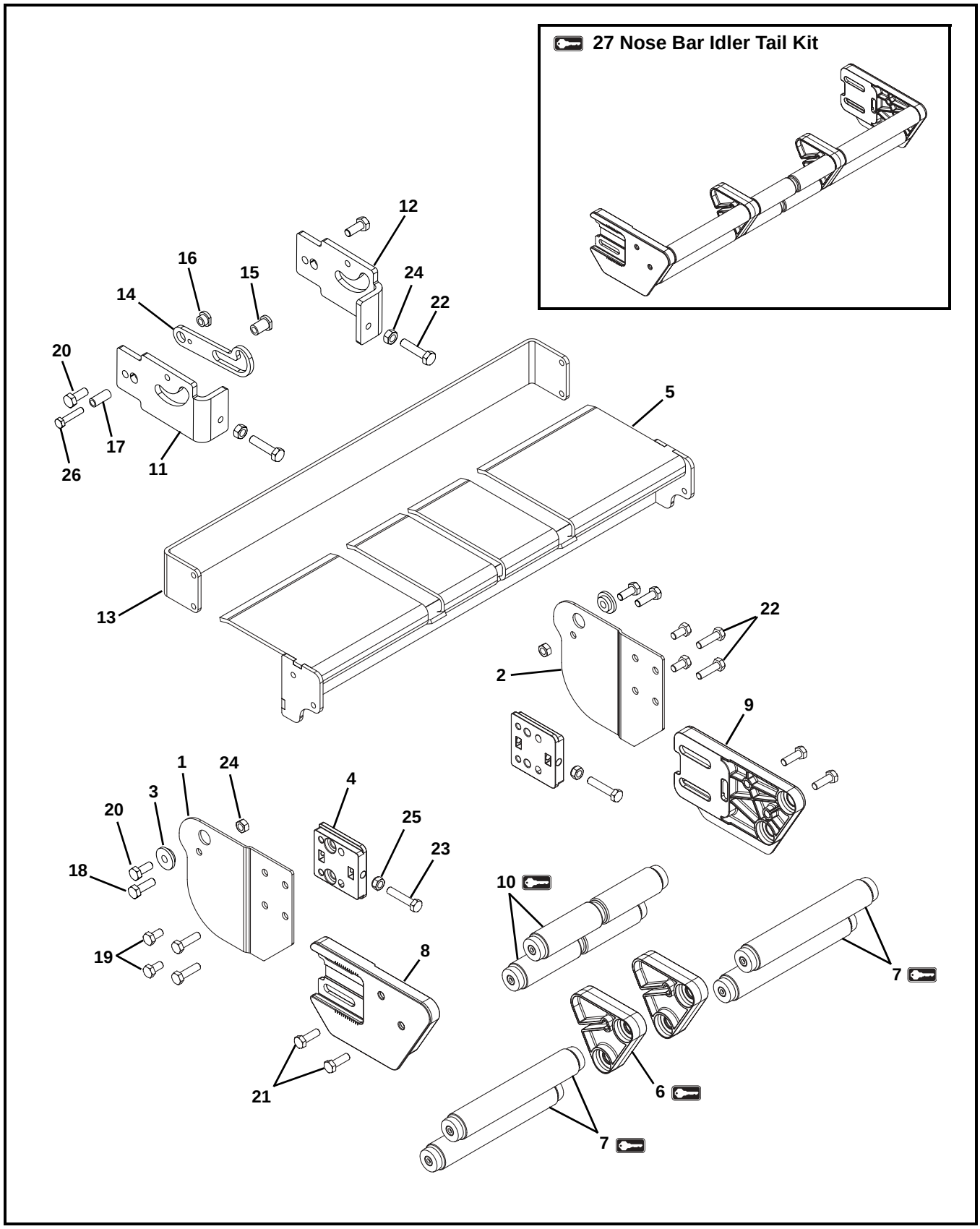
Fixed Idler Tail for Center Drive Conveyors



Item	Part Number	Description
1	516914	Block
2	532298	Headplate for A and B Position
3	532299	Headplate for D and C Position
4	516819-00-WW	Idler Spindle
	516819-K0-WW	Idler Spindle with Auxiliary Shaft for 'A' position
	516819-0K-WW	Idler Spindle with Auxiliary Shaft for 'D' position
5	516841-LH	Support Bracket, Left Hand
6	516841-RH	Support Bracket, Right Hand
7	802-161	Bearing
8	807-1454	Bearing Cap
9	912-108SS	Square Key, 0.25" x 1.00"
10	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
11	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
12	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
13	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
14	990802MSS	Lock Nut
15	520364-00-WW	Idler Tail Kit (Includes Items 2, 3, 4, 7 and 9)
	520364-K0-WW	Idler Tail Kit with Auxiliary Shaft for 'A' position (Includes Items 2, 3, 4, 7 and 9)
	520364-0K-WW	Idler Tail Kit with Auxiliary Shaft for 'D' position (Includes Items 2, 3, 4, 7 and 9)
WW = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 8 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

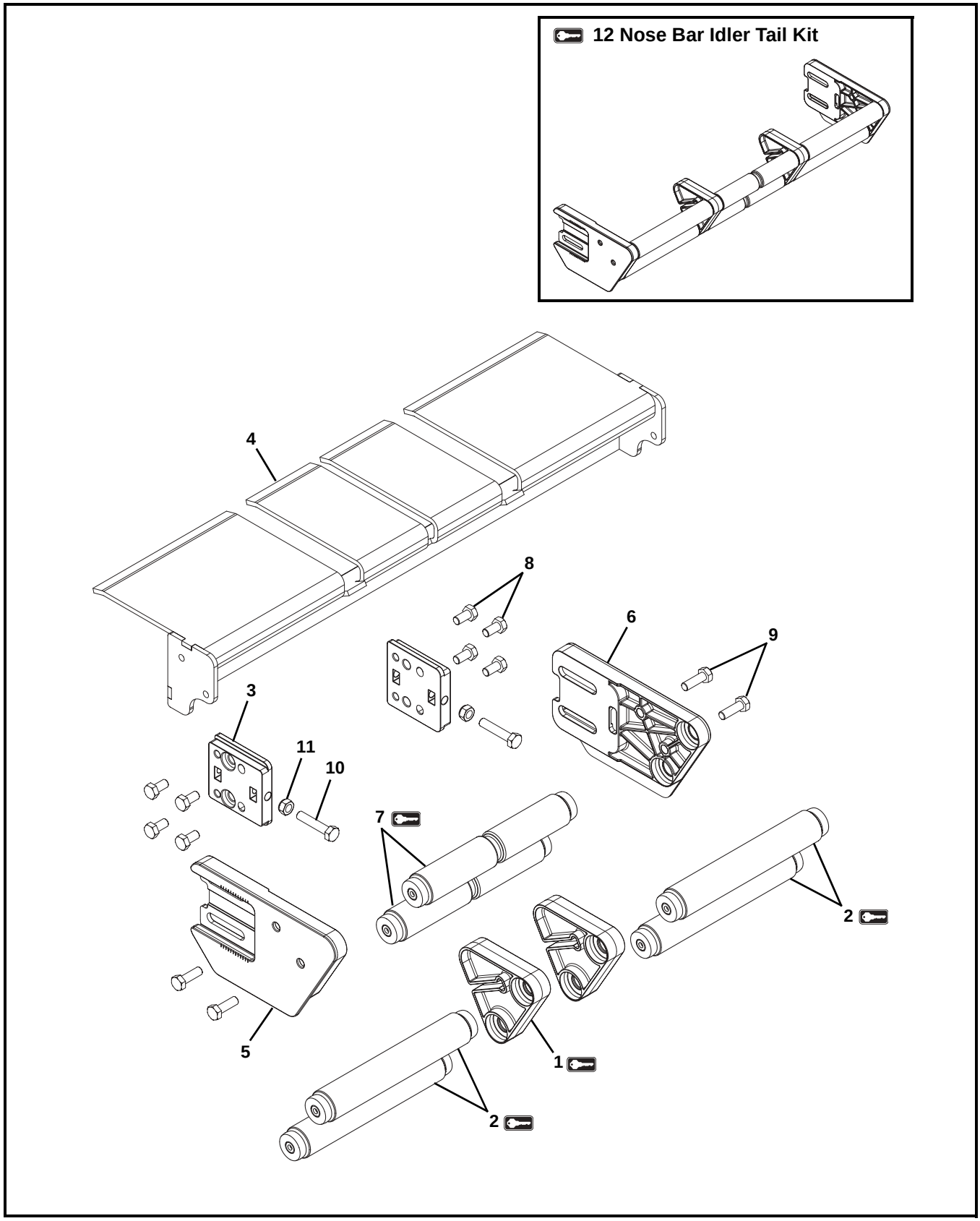
Tip-Up Nose Bar Idler Tail



Item	Part Number	Description
1	516848	Tip-Up Plate, Left Hand
2	516849	Tip-Up Plate, Right Hand
3	516850	Bushing
4	516914	Block
5	516927-T-WW	Crossmember
6	516929	Puck for 22-36 Wide Conveyors Only
7	520360	Spindle Assembly for 22-36 Wide Conveyors Only
8	516928-LH	Nose Bar Headplate, Left Hand
9	516928-RH	Nose Bar Headplate, Right Hand
10	520359-WW	V-Groove Spindle Assembly
11	518415-LH	Tip-Up Bracket, Left Hand
12	518415-RH	Tip-Up Bracket, Right Hand
13	520325-WW	Stop Bracket
14	520436	Tip Up Bracket
15	520437	Locking Lever
16	520438	Mount Bushing
17	520439	Sleeve
18	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
19	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
20	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
21	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
22	960830MSS	Hex Head Cap Screw, M8-1.25 x 30 mm
23	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
24	990801MSS	Hex Nut
25	990802MSS	Lock Nut
26	960630MSS	Hex Head Cap Screw, M6-1.00 x 30 mm
27	520365-WW	Nose Bar Idler Tail Kit (Includes Items 6, 7, 8, 9 and 10)
WW = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 8 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

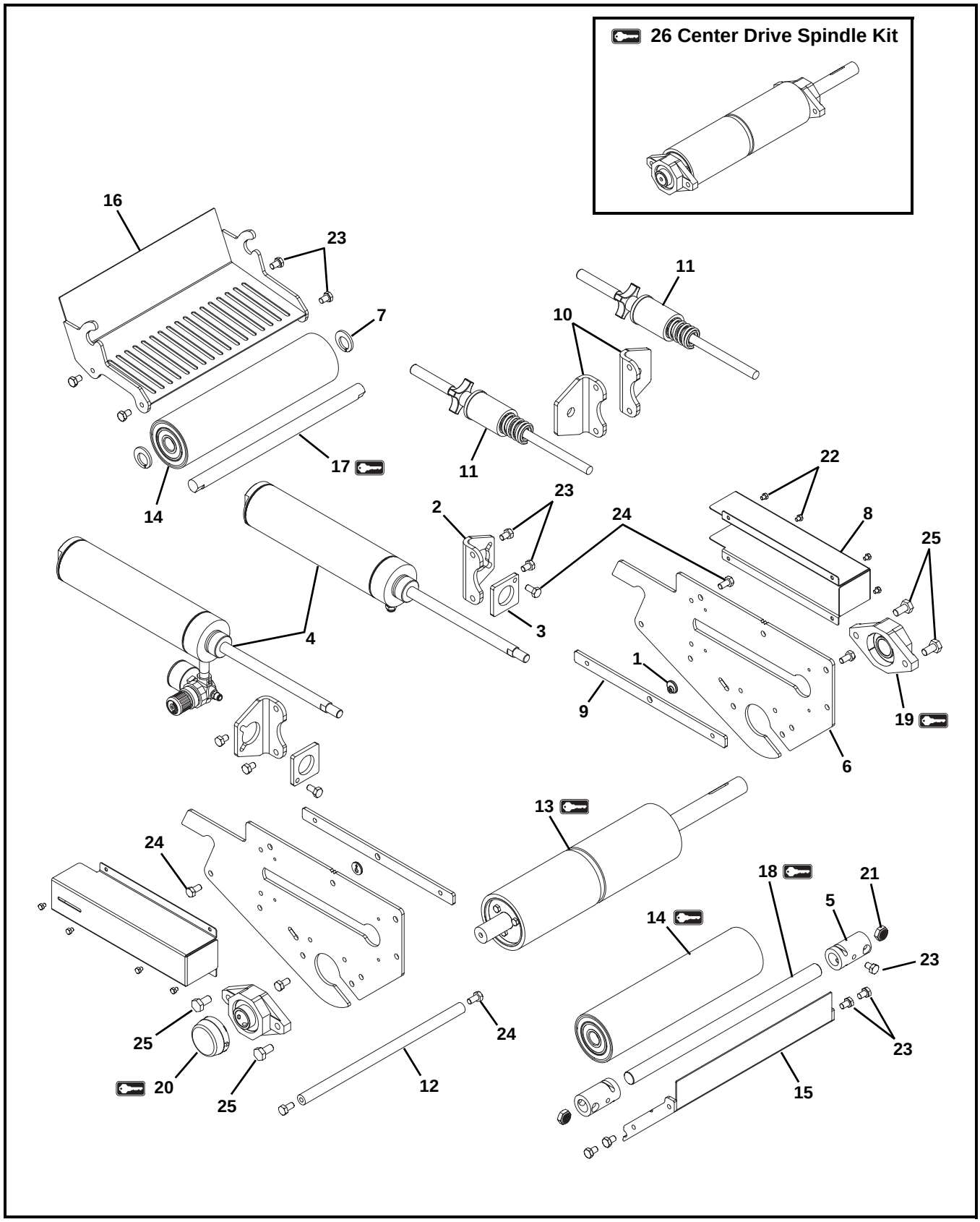
Fixed Nose Bar Idler Tail for Center Drive Conveyors



Item	Part Number	Description
1	516929	Puck for 22-36 Wide Conveyors Only
2	520360	Spindle Assembly for 22-36 Wide Conveyors Only
3	532294	Block
4	516927-F-WW	Crossmember
5	516928-LH	Nose Bar Headplate, Left Hand
6	516928-RH	Nose Bar Headplate, Right Hand
7	520359-WW	V-Groove Spindle Assembly
8	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
9	960825MSS	Hex Head Cap Screw, M8-1.25 x 25 mm
10	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
11	990802MSS	Lock Nut
12	520365-WW	Nose Bar Idler Tail Kit (Includes Items 1, 2, 5, 6 and 7)
WW = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 8 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

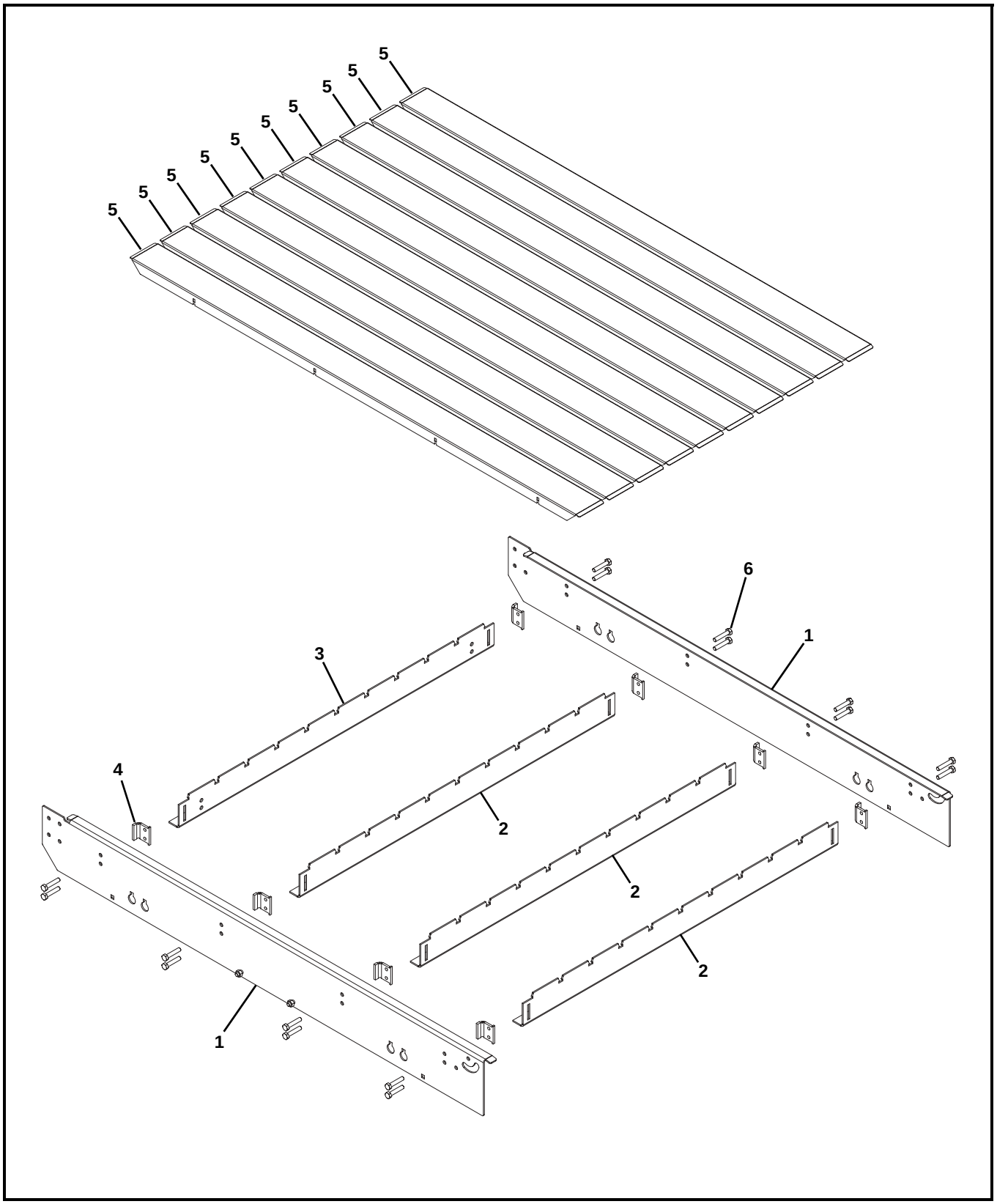
Center Drive Module



Item	Part Number	Description
1	350404	Cam
2	514898	Cylinder Bracket for Pneumatic Tension Only
3	514899	Nut Plate for Pneumatic Tension Only
4	515501	Pneumatic Tension Kit
5	515502	Spacer
6	516867	Side Plate
7	518351	Bushing
8	518379	Rod Guard
9	518380	Nut Bar
10	518492	Spring Bracket for Manual Tension Only
11	514891-WW	Tensioner Assembly for Manual Tension Only
12	516881-WW	Cross Tube
13	516882-WW	Center Drive Spindle Assembly
14	518349-WW	Idler Spindle
15	518459-WW	Tension Guard
16	518491-WW	Idler Guard
17	532409-WW	Idler Shaft
18	532425-WW	Axle Shaft
19	802-192	Bearing
20	807-1454	Bearing Cap
21	910-083	Hex Jam Nut
22	960506MSS	Hex Head Cap Screw, M5-0.80 x 6 mm
23	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm
24	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
25	961020MSS	Hex Head Cap Screw, M10-1.50 x 20 mm
26	520366-WW	Center Drive Spindle Kit (Includes Items 13 and 19)
WW = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 8 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

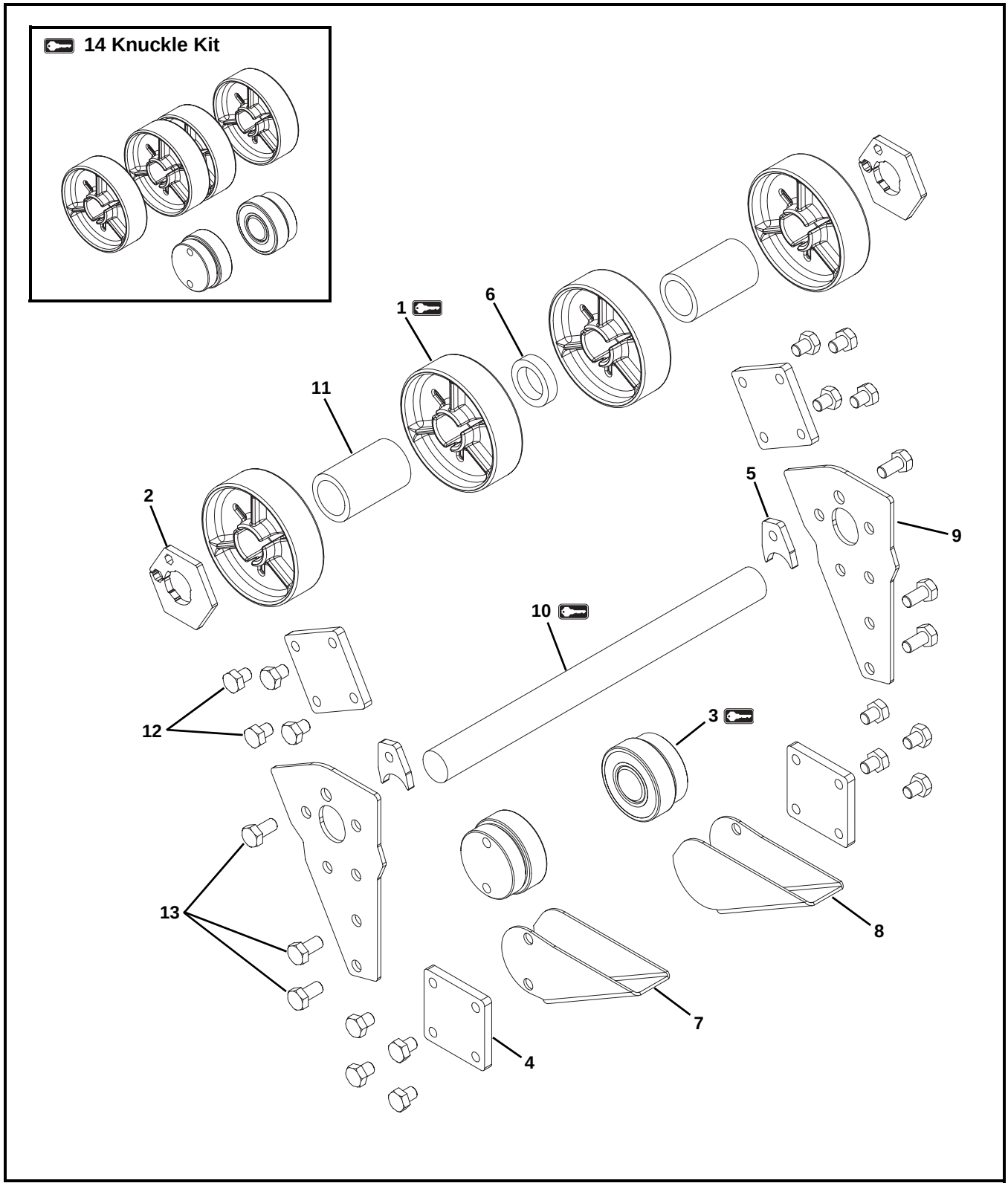
Frame



Item	Part Number	Description
1	----------	Consult Factory for Frame Part Number
2	515593-WW	Crossmember
3	517578-WW	Drive End Crossmember
4	515596	Crossmember Mounting Bracket
5	516804-LLLLL	Bed Rail
6	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
WW = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 8 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		

Service Parts

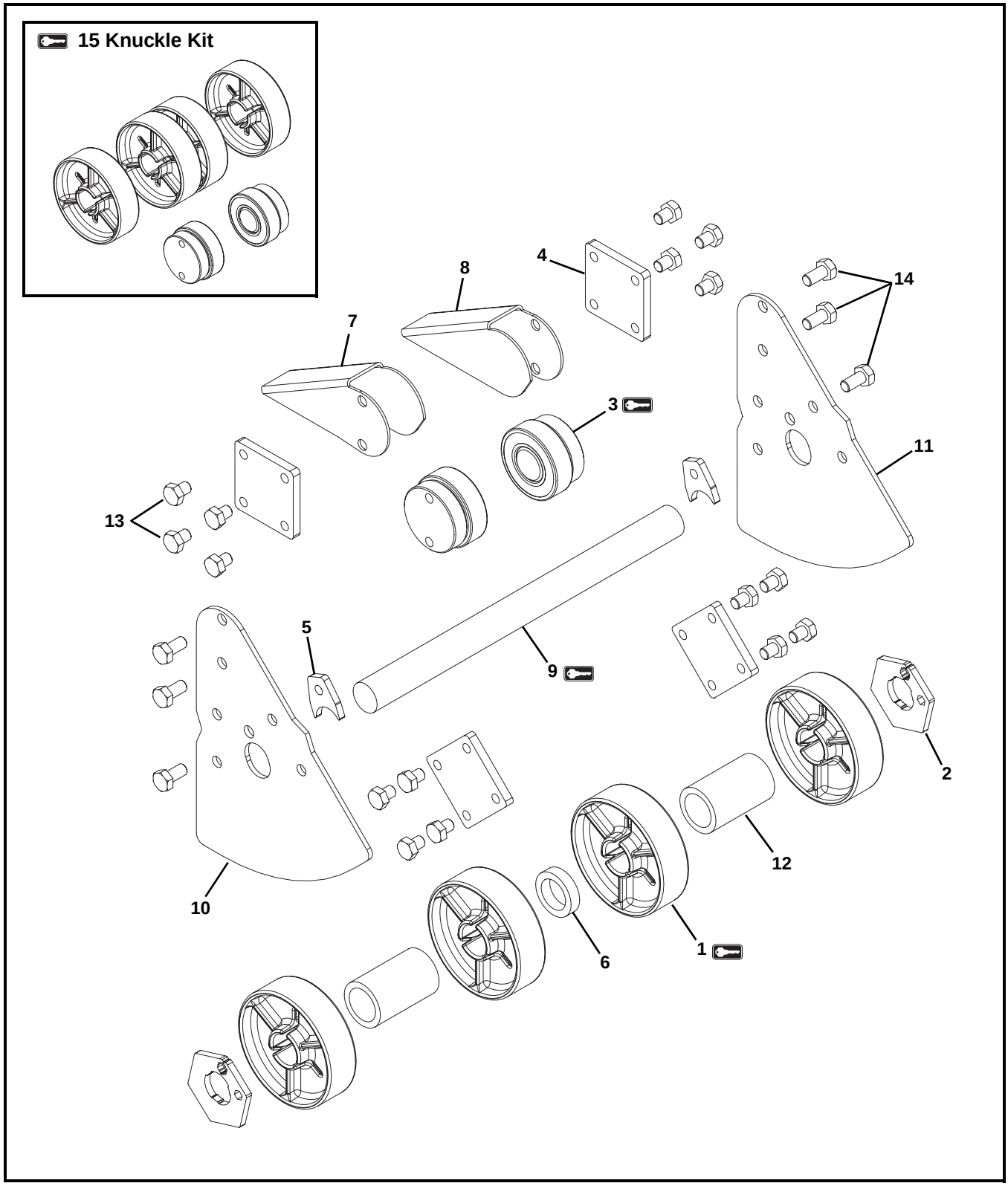
Upper Knuckle



Item	Part Number	Description
1	506296	Idler Puck
2	514823	Retaining Ring
3	520304	Bearing Assembly (for Cleated Belts Only)
4	516942	Connecting Plate
5	518377	Shaft Clamp
6	532379	Center Spacer
7	514831-LH	Bearing Guard, Left Hand (for Cleated Belts Only)
8	514831-RH	Bearing Guard, Right Hand (for Cleated Belts Only)
9	514887-AA	Side Plate (for Cleated Belts Only)
	514889-AA	Side Plate (for Flat Belts Only)
10	516958-WW	Roller Shaft
11	532127-LLLLL	Spacer
12	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
13	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
14	520367-WW	Knuckle Kit (Includes items 1 and 3)
AA = Angle 05, 10, 15, 20, 25, 30, 35, 40, 45, 50, 55, 60		
WW = Conveyor width reference in inches 06 - 24 in 02 increments		
See Specifications chart on page 8 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		

Service Parts

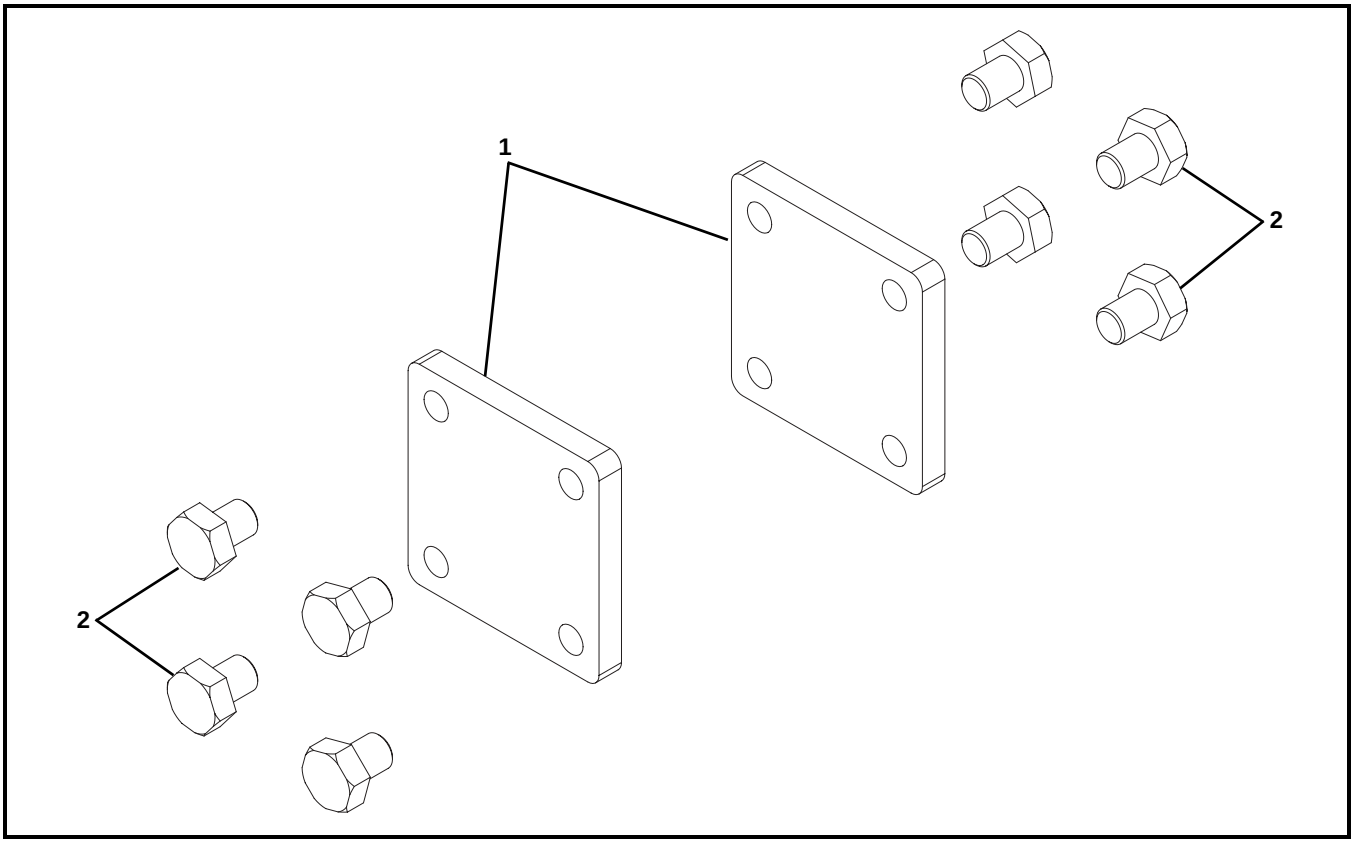
Lower Knuckle



Item	Part Number	Description
1	506296	Idler Puck
2	514823	Retaining Ring
3	520304	Bearing Assembly
4	516942	Connecting Plate
5	518377	Shaft Clamp
6	532379	Center Spacer
7	514831-LH	Bearing Guard, Left Hand (for Sidewall Cleated Belts Only)
8	514831-RH	Bearing Guard, Right Hand (for Sidewall Cleated Belts Only)
9	516958-WW	Roller Shaft
10	518495-AA-LH	Side Plate, Left Hand (for Cleated Belts Only)
	516960-AA	Side Plate (for Sidewall Cleated Belts Only)
11	518495-AA-RH	Side Plate, Right Hand (for Cleated Belts Only)
	516960-AA	Side Plate (for Sidewall Cleated Belts Only)
12	532127-LLLLL	Spacer
13	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
14	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
15	520367-WW	Knuckle Kit (Includes items 1 and 3)
AA = Angle 30, 35, 40, 45, 50, 55, 60		
WW = Conveyor width reference in inches 06 - 24 in 02 increments		
See Specifications chart on page 8 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		

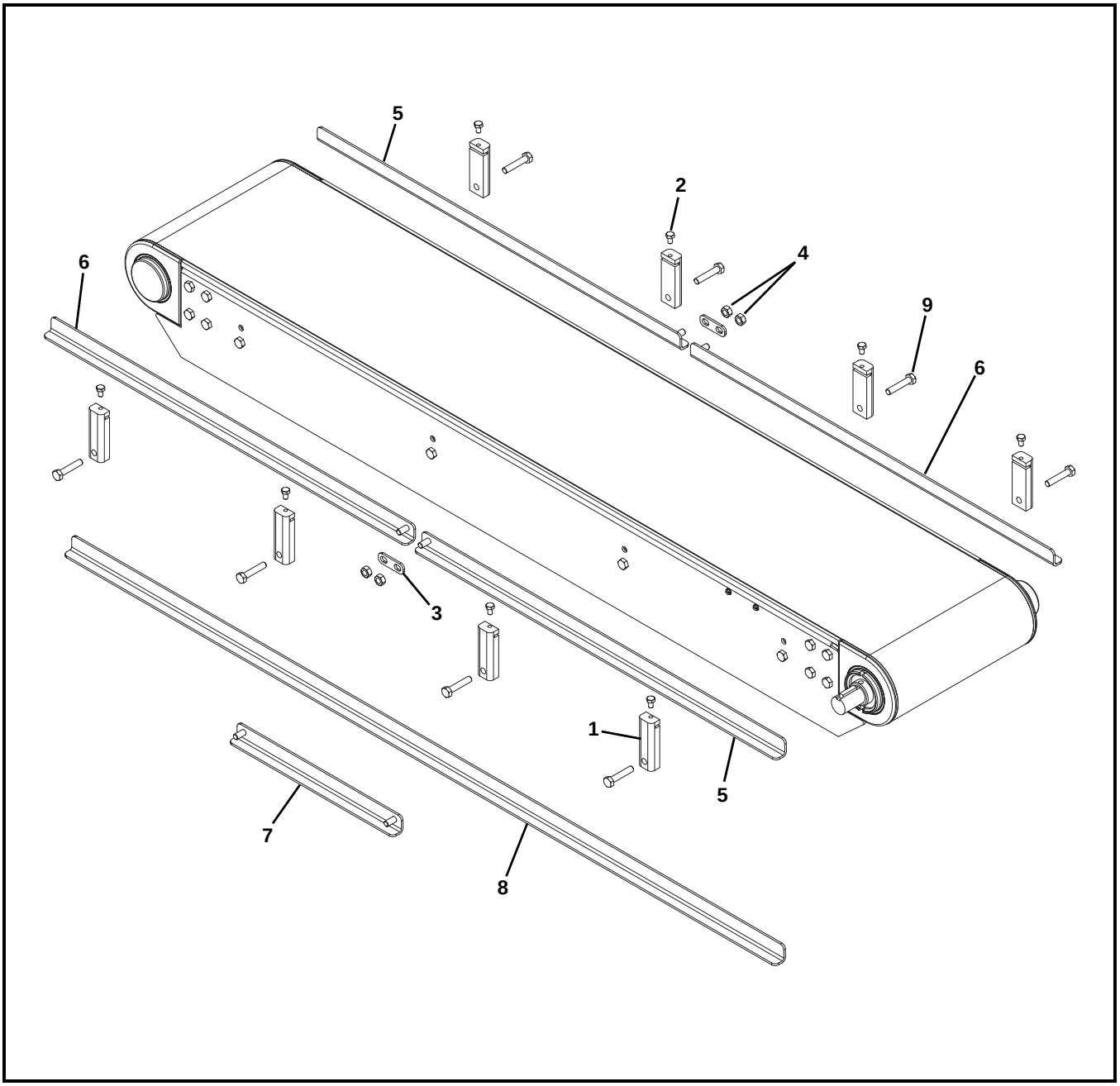
Service Parts

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

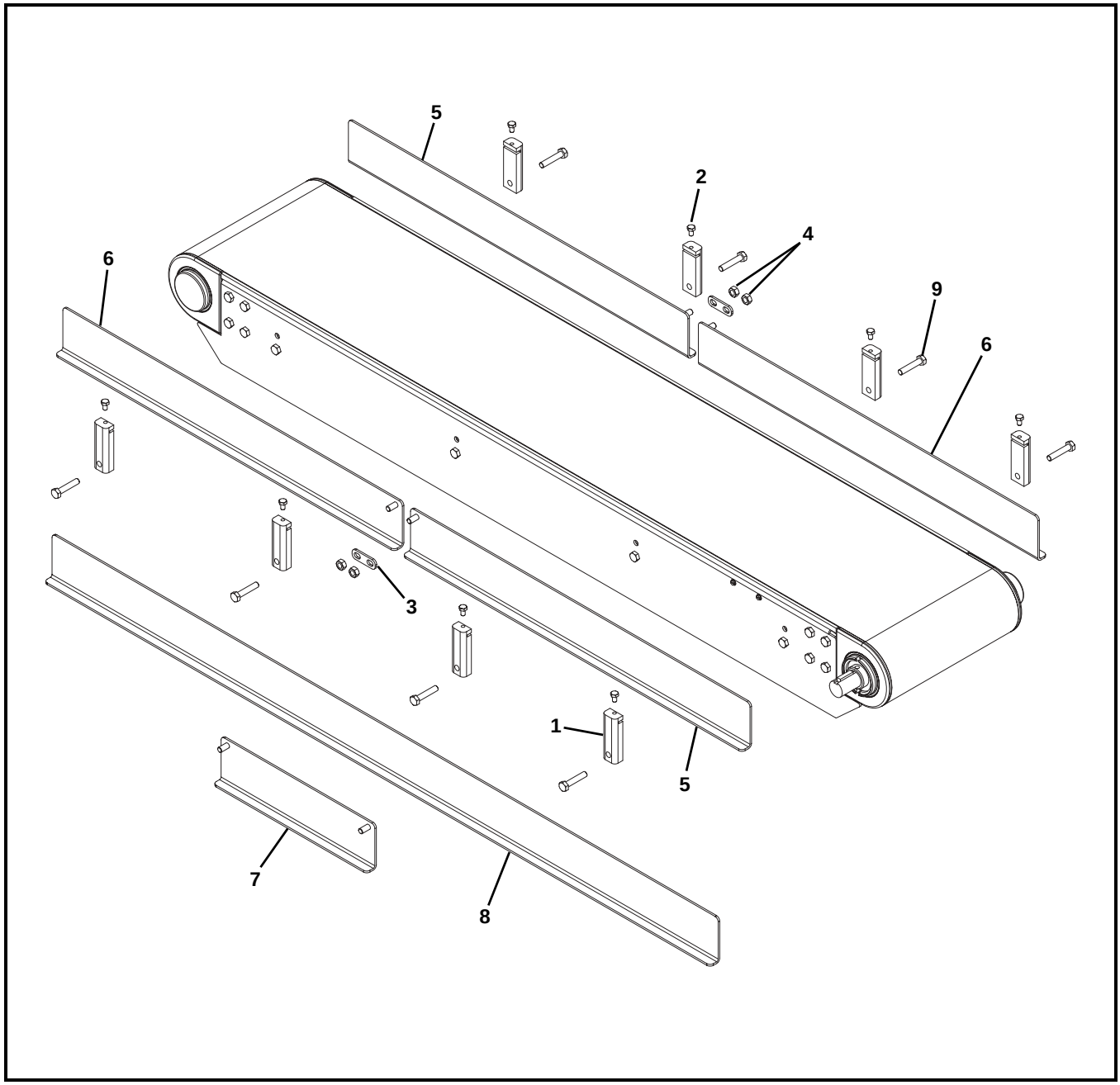


Item	Part Number	Description
1	516999-01	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-01-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-01-LLLLL-RH	Guiding, Right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

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

Service Parts

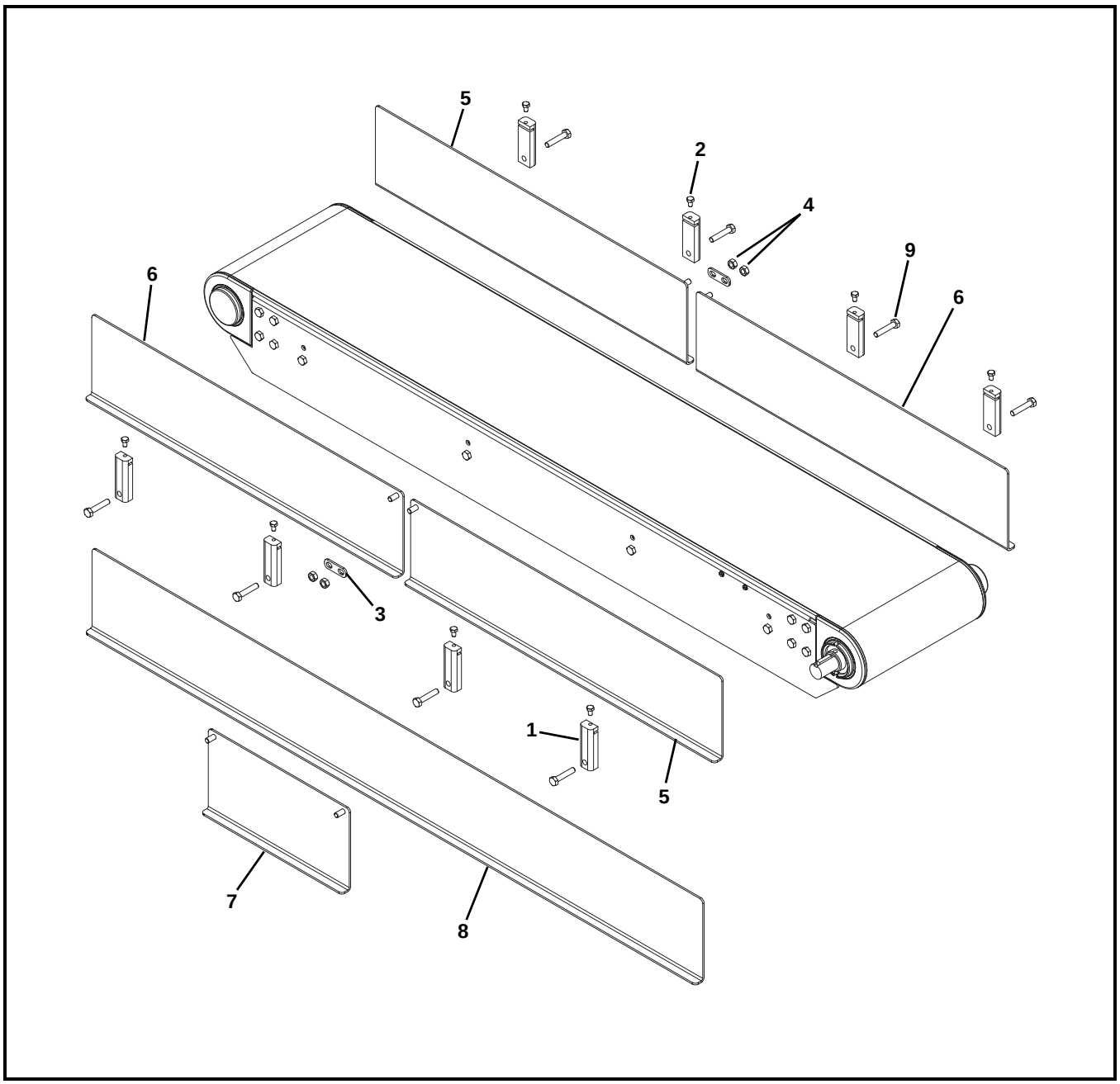
75 mm High Sides



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-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-03-LLLLL-RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-03-LLLLL	Guiding, Middle (for Multiple Guide Sections Only)

Item	Part Number	Description
8	516997-03-LLLLL	Guiding (for One Piece Guiding)
9	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

152 mm High Sides

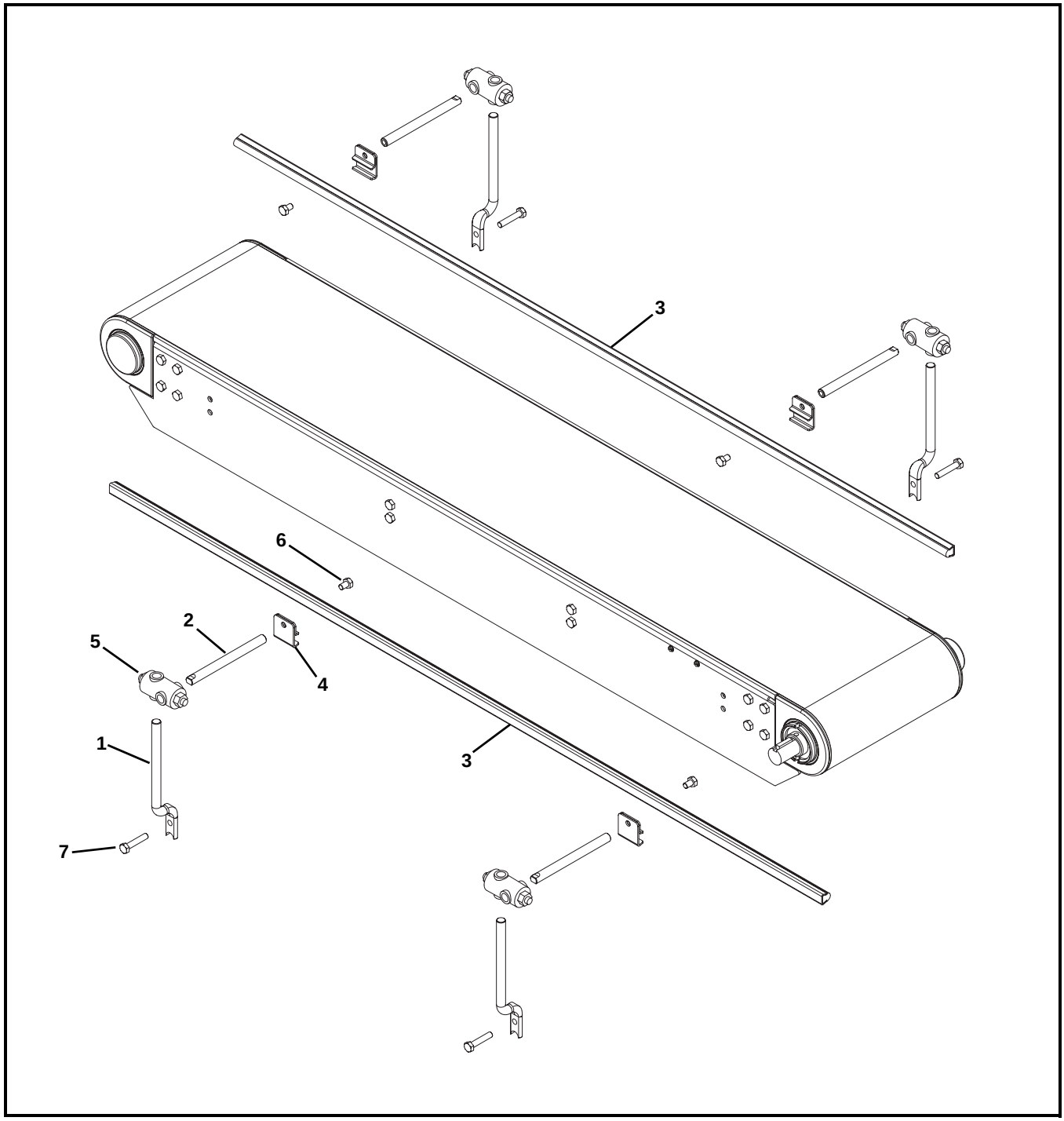


Item	Part Number	Description
1	516999-01	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-06-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-06-LLLLL-RH	Guiding, Right Hand (for Multiple Guide Sections Only)
7	518399-06-LLLLL	Guiding, Middle (for Multiple Guide Sections Only)

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

Service Parts

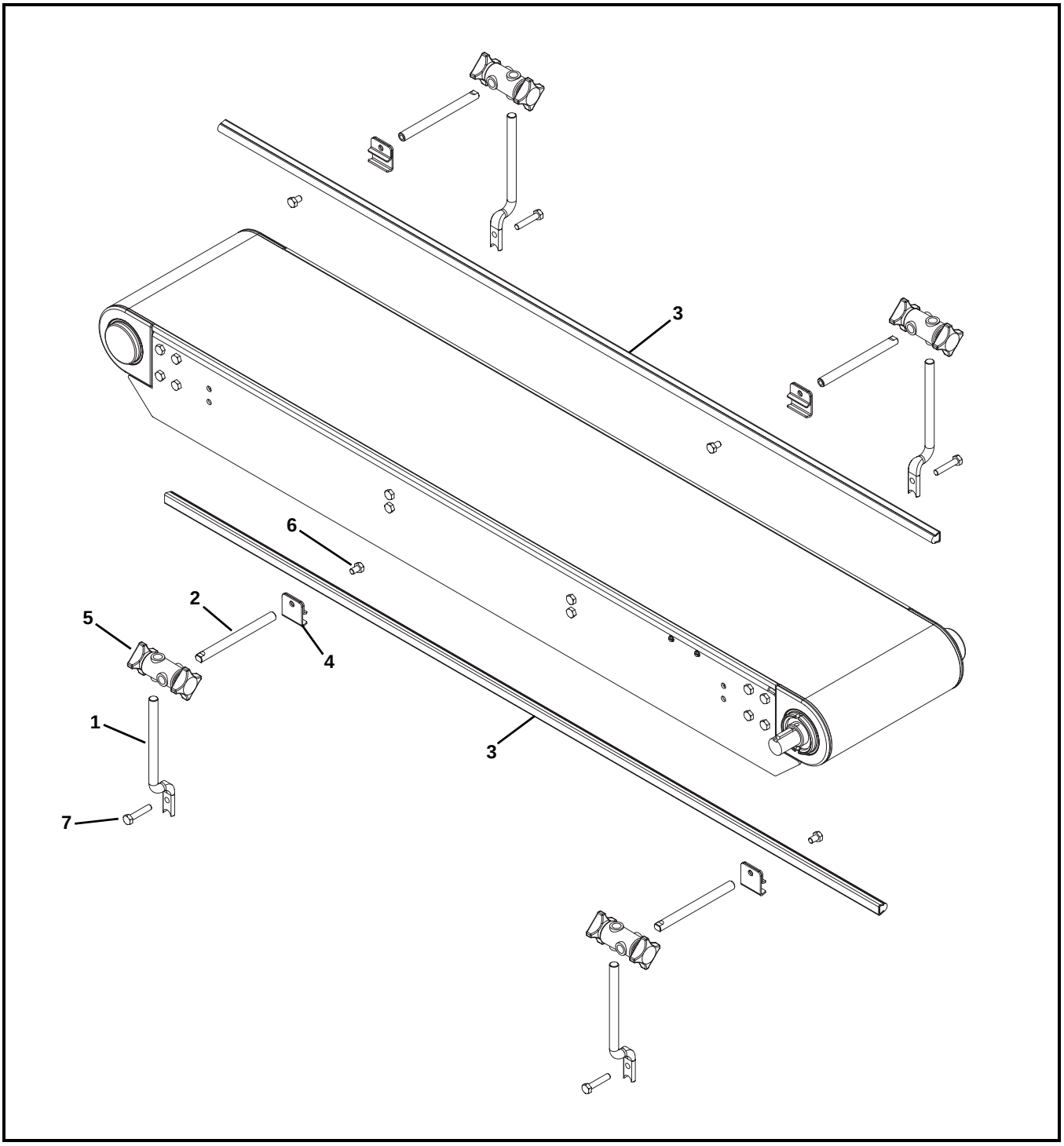
Fully Adjustable Round Guides



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

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

Tool-Less Fully Adjustable Round Guides

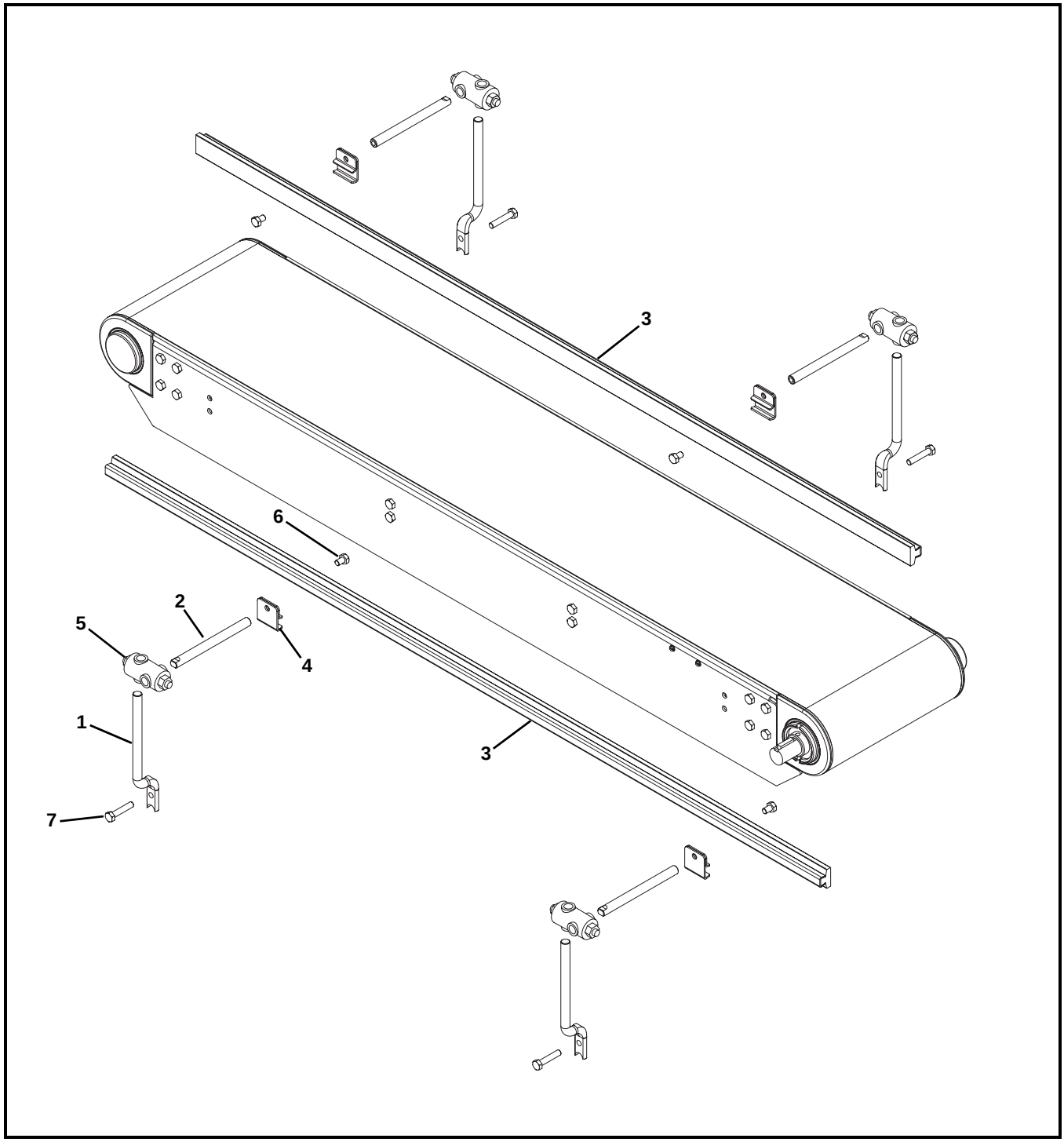


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167-LLLLL	Round Guide Rail
4	807-015	Rail Clamp
5	807-1470	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

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

Service Parts

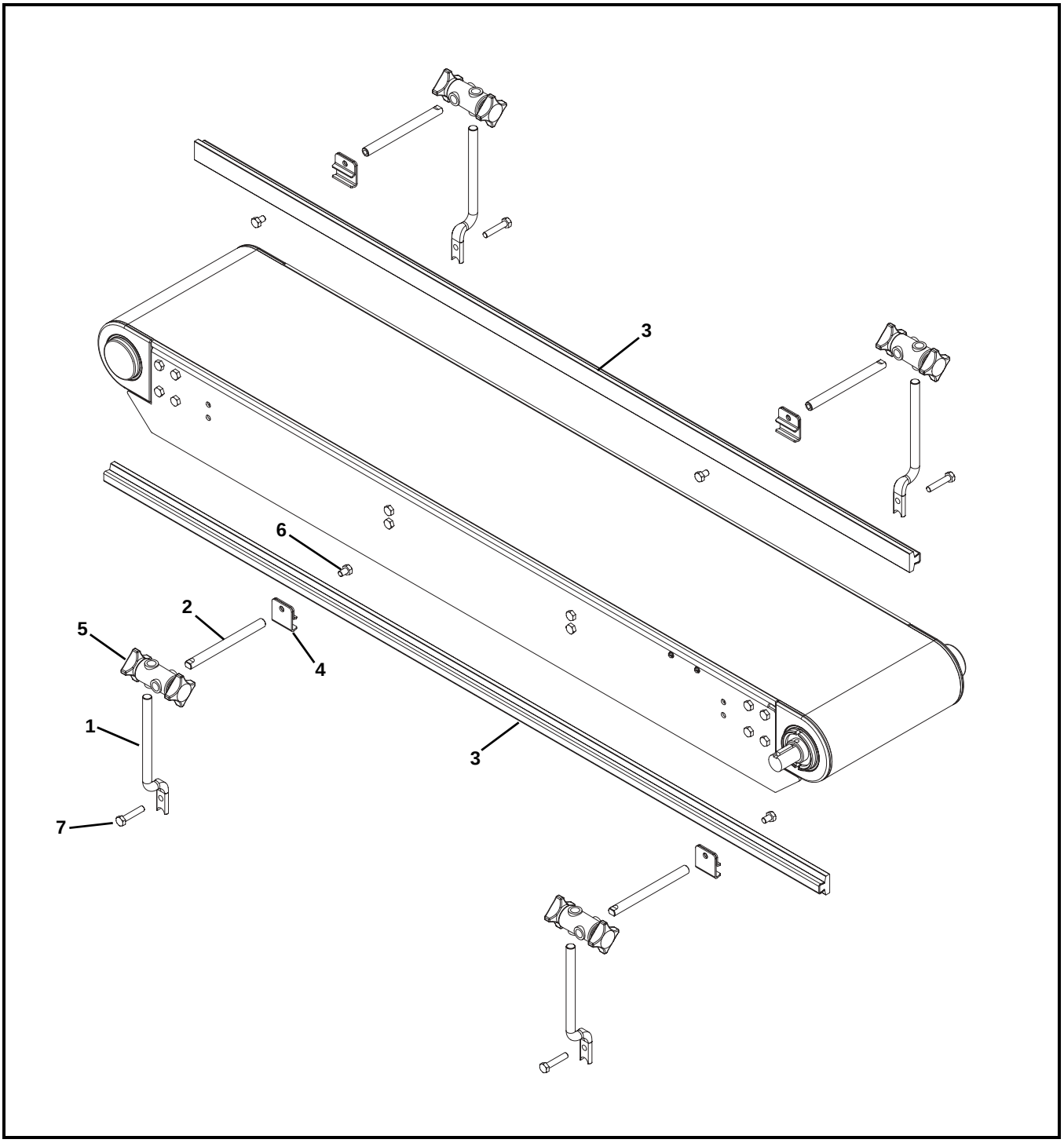
Fully Adjustable Flat Guides



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

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

Tool-Less Fully Adjustable Flat Guides

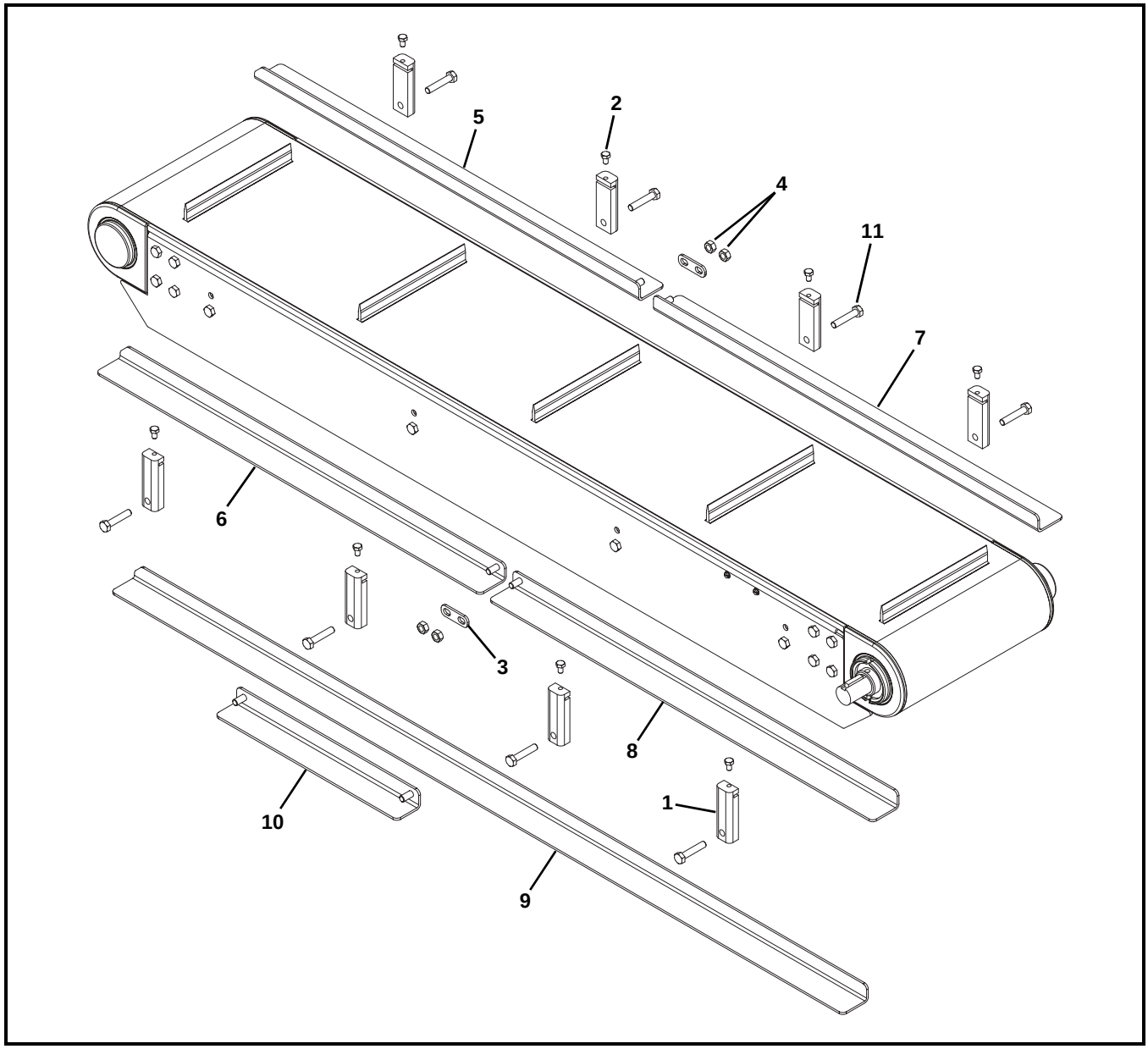


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	517599-LLLLL	Flat Guide Rail
4	807-015	Rail Clamp
5	807-1470	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

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

Service Parts

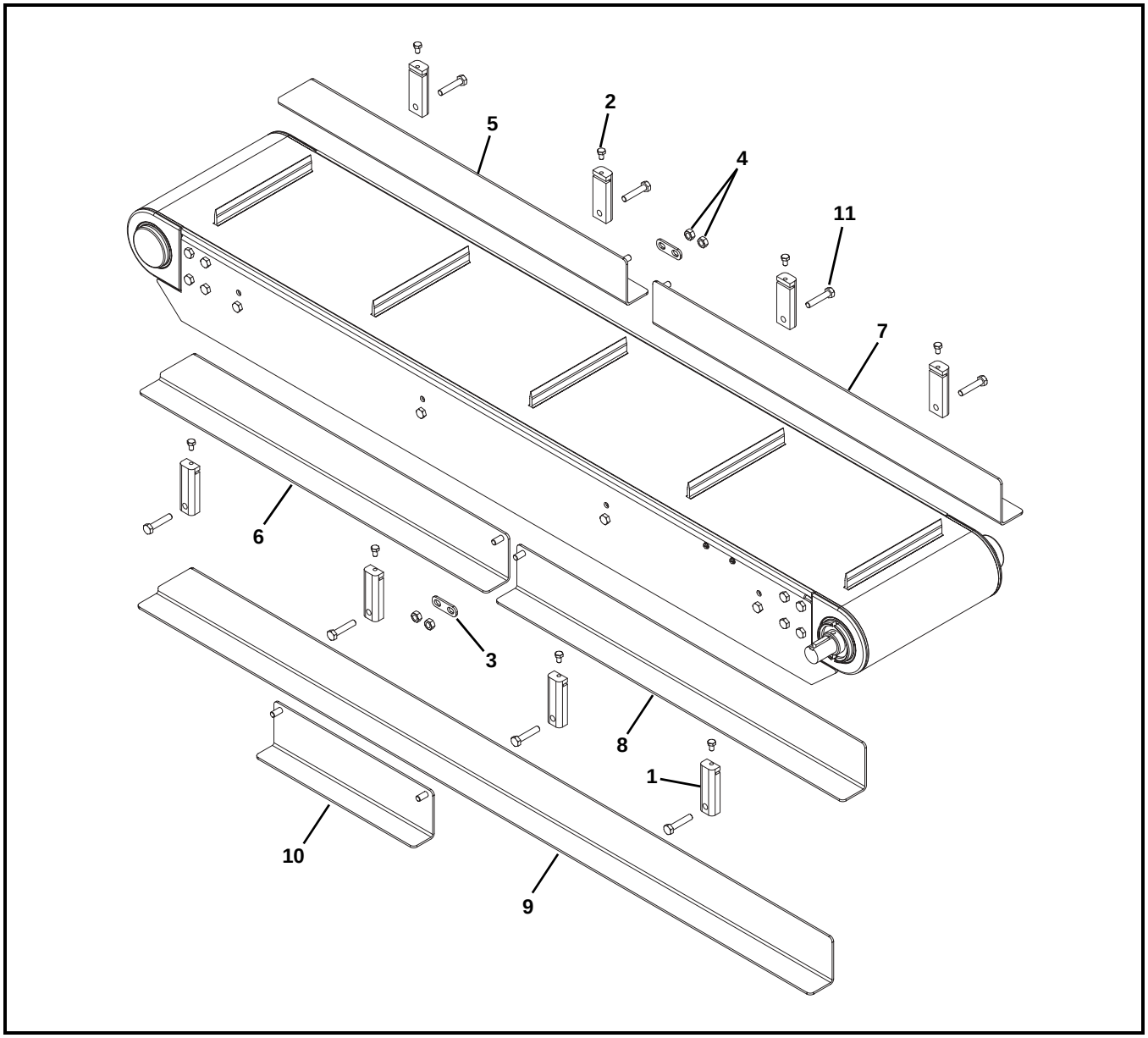
25 mm Cleated High Sides



Item	Part Number	Description
1	516999-01	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	518386-01-LLLLL-LH	Guiding, Left Hand
6	518386-01-LLLLL-RH	Guiding, Right Hand
7	518396-01-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
8	518396-01-LLLLL-RH	Guiding, Right Hand (for Multiple Guide Sections Only)

Item	Part Number	Description
9	516998-01-LLLLL-RH	Guiding, Right Hand (for One Piece Guiding)
	516998-01-LLLLL-LH	Guiding, Left Hand (for One Piece Guiding)
10	518384-01-LLLLL	Guiding, Middle (for Multiple Guide Sections Only)
11	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

75 mm Cleated High Sides

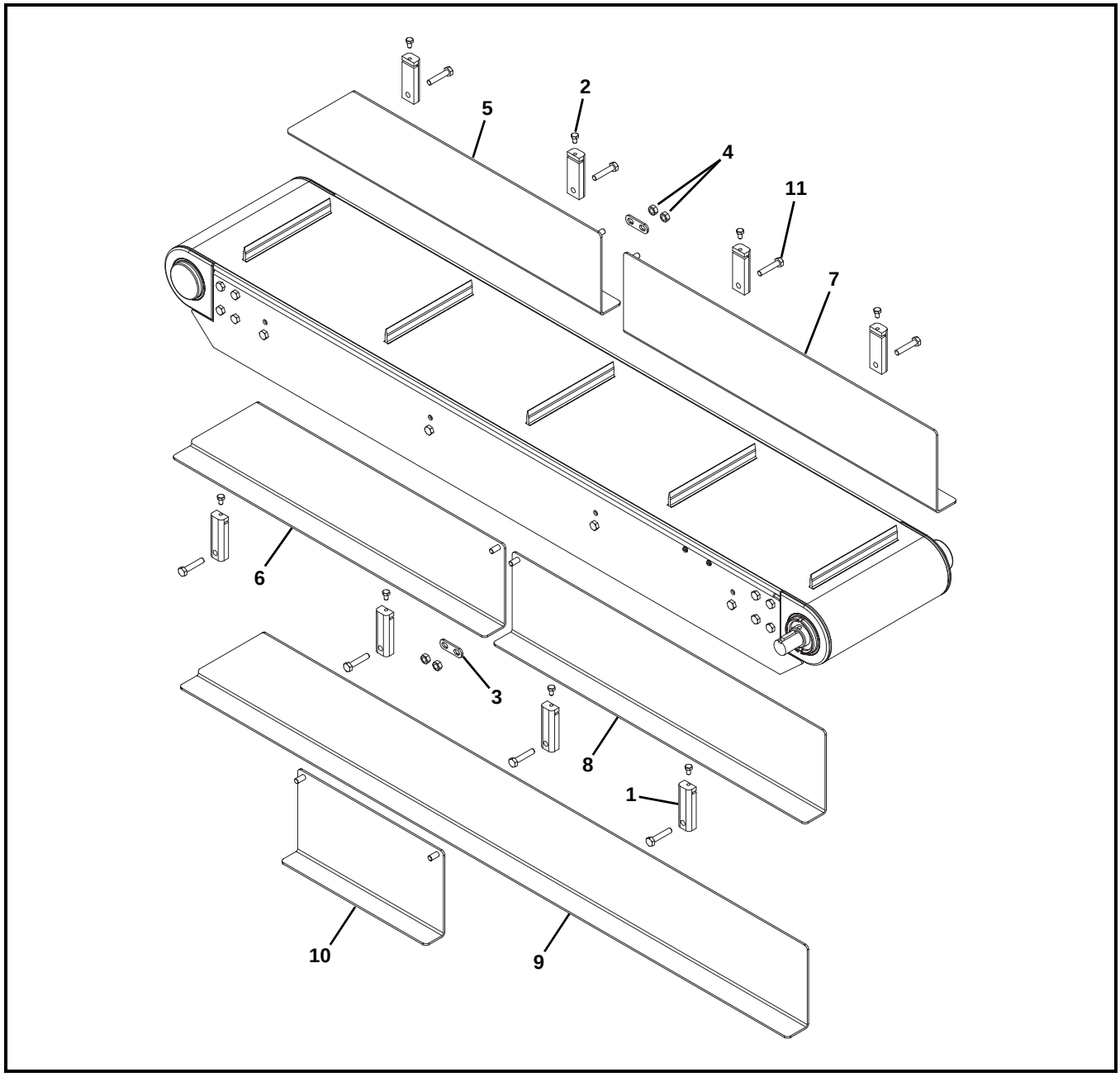


Item	Part Number	Description
1	516999-01	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518386-03-LLLLL-LH	Guiding, Left Hand
6	518386-03-LLLLL-RH	Guiding, Right Hand
7	518396-03-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
8	518396-03-LLLLL-RH	Guiding, Right Hand (for Multiple Guide Sections Only)

Item	Part Number	Description
9	516998-03-LLLLL-RH	Guiding, Right Hand (for One Piece Guiding)
	516998-03-LLLLL-LH	Guiding, Left Hand (for One Piece Guiding)
10	518384-03-LLLLL	Guiding, Middle (for Multiple Guide Sections Only)
11	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

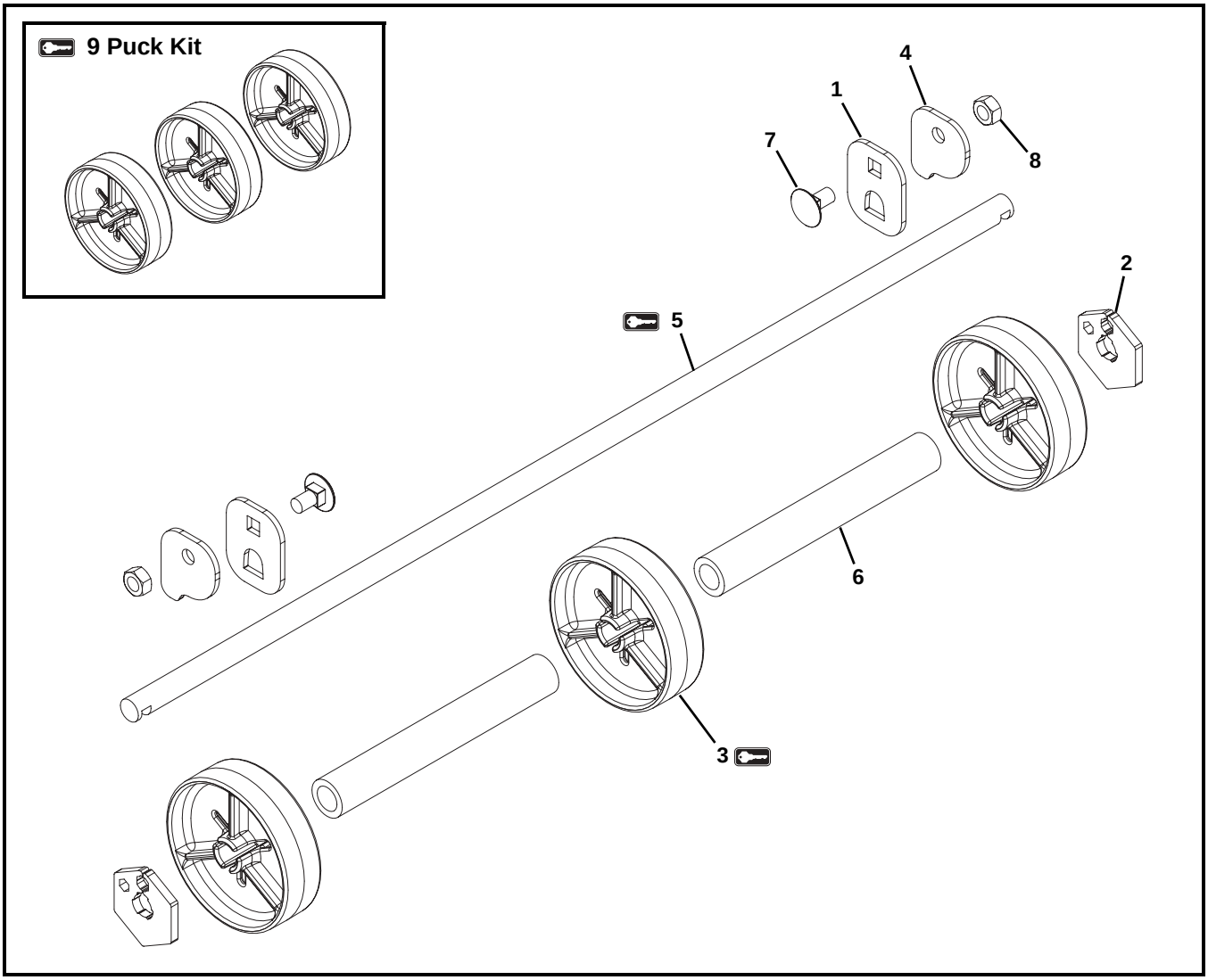
152 mm Cleated High Sides



Item	Part Number	Description
1	516999-01	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	518386-06-LLLLL-LH	Guiding, Left Hand
6	518386-06-LLLLL-RH	Guiding, Right Hand
7	518396-06-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
8	518396-06-LLLLL-RH	Guiding, Right Hand (for Multiple Guide Sections Only)

Item	Part Number	Description
9	516998-06-LLLLL-RH	Guiding, Right Hand (for One Piece Guiding)
	516998-06-LLLLL-LH	Guiding, Left Hand (for One Piece Guiding)
10	518384-06-LLLLL	Guiding, Middle (for Multiple Guide Sections Only)
11	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
LLLLL = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" LLLLL = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

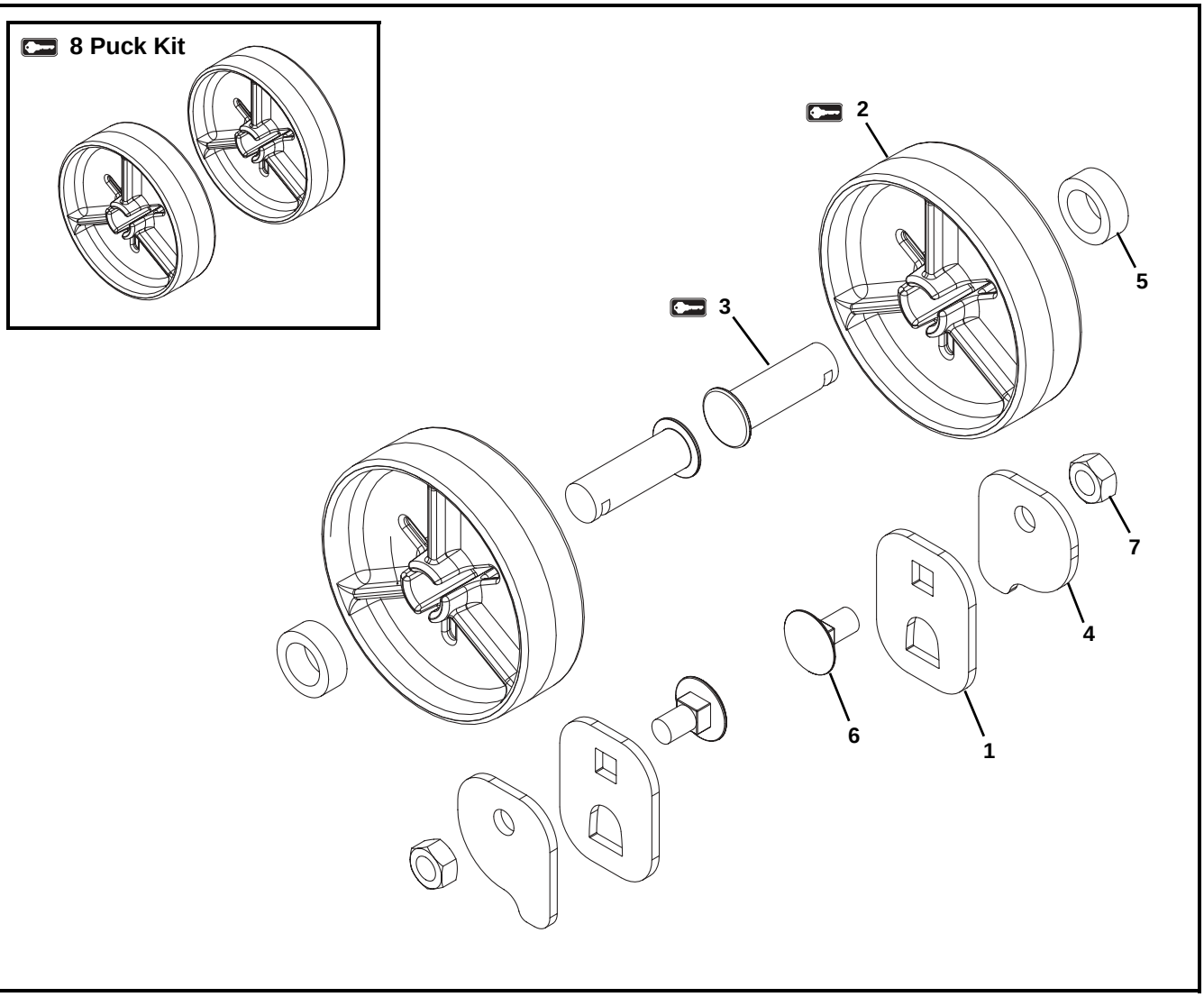
Flat Belt Returns 508 mm Wide and Wider



Item	Part Number	Description
1	516855	Return Bracket
2	517575	Retaining Plate
3	517576	Puck
4	518394	Return Clip
5	517598-LLLLL	Shaft
6	518393-00600	Spacer
7	807-3543	Carriage Bolt, M8 x 16 mm
8	990801MSS	Hex Nut
9	520368-WW	Puck Kit (Includes item 3)
WW = Conveyor width reference in inches 06 - 24 in 02 increments		
See Specifications chart on page 8 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		

Service Parts

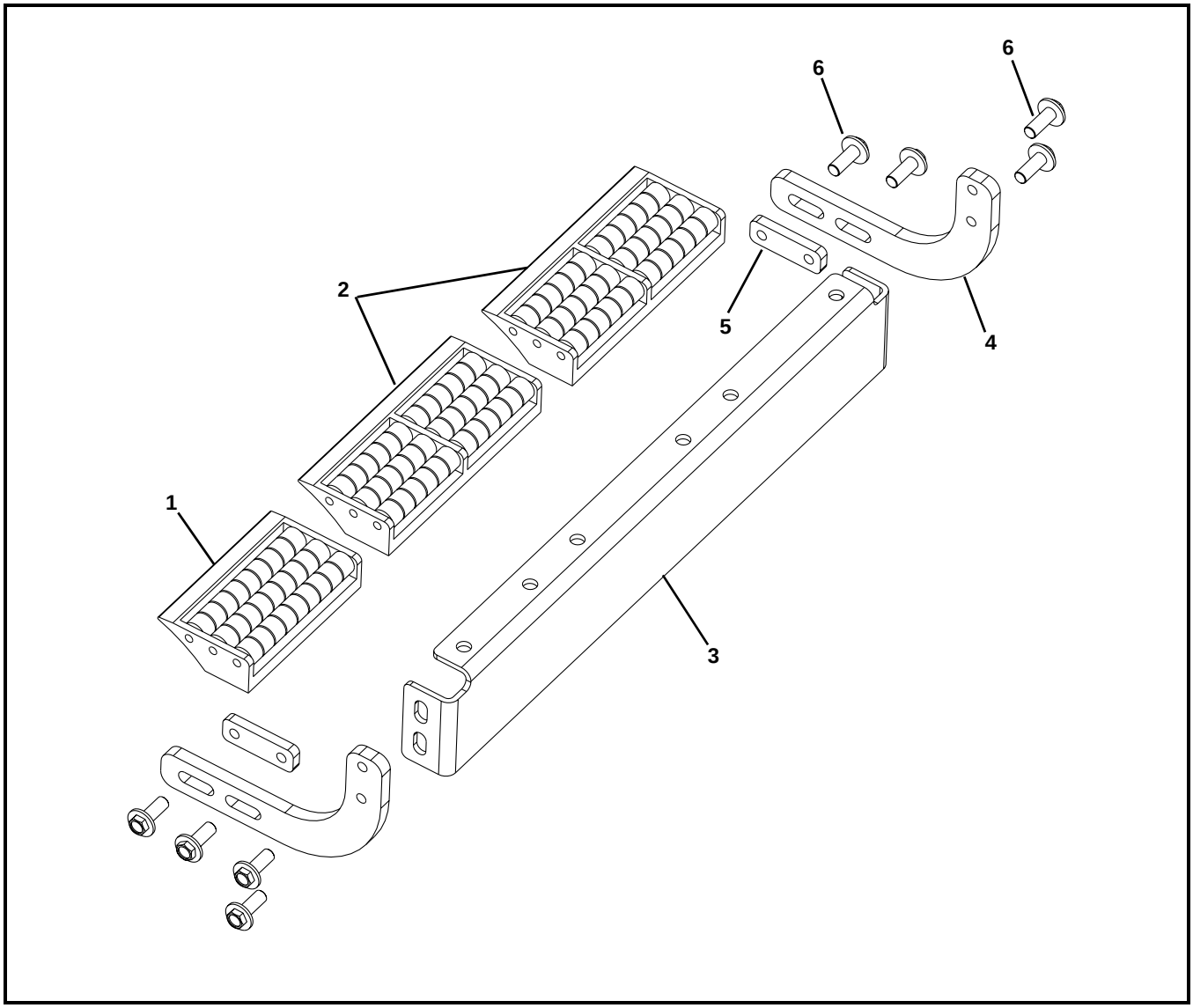
Cleated Belt and Flat Belt Returns Under 508 mm Wide



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

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

Roller Transfer



Item	Part Number	Description
1	807-1829	3.35" Transfer Plate
2	807-1830	4.53" Transfer Plate
3	518353-WW	Support Bracket
4	520309	Mounting Bracket
5	532387	Nut Plate
6	960616MSSF	Flanged Hex Head Cap Screw, M6-1.00 x 16 mm
WW = Conveyor width reference in inches 08 - 36 in 02 increments		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Configuring Conveyor Belt Part Number

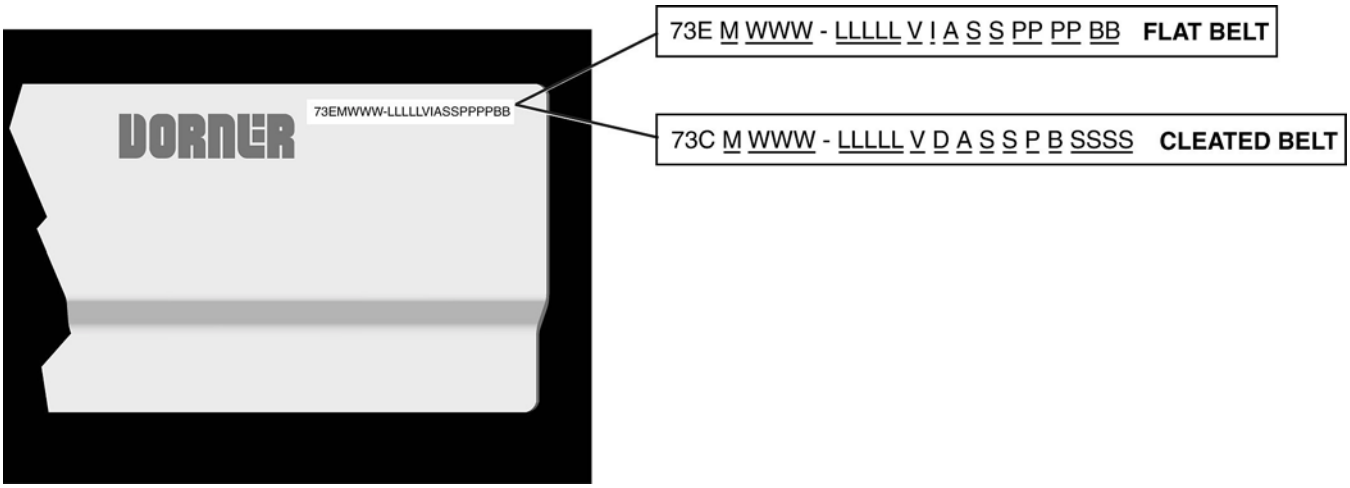


Figure 143

Flat Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 143)**. From the model number determine the conveyor width (WWW), length (LLLLL) and belt type (BB). Use data to configure belt part number as indicated below. *Add "V" for v-guided belts or add "VG" for 06, 08, 57, 59, and 64 v-guided belt types.

73E-WWW LLLLL / BB V*

73E-_____ _____ / ___ V*

(Fill In)

Cleated Belt Part Number Configuration

Refer to model number on the conveyor frame **(Figure 143)**. From the model number determine the conveyor width (WWW), length (LLLLL), cleat type (B) and cleat spacing (SSSS). Use data to configure belt part number as indicated below. *Add "V" for v-guided belts.

73C-WWW LLLLL B SSSS V*

73C-_____ _____ _ _____ V*

(Fill In)

Notes

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.

<table>
<tr><td></td><td colspan="9">Product Type</td></tr>
<tr><td></td><td colspan="8">Standard Products</td><td>Engineered to order parts</td></tr>
<tr><td>Product Line</td><td>Conveyors</td><td>Gearmotors & Mounting Packages</td><td>Support Stands</td><td>Accessories</td><td>Spare Parts (non-belt)</td><td>Spare Belts - Standard Flat Fabric</td><td>Spare Belts - Cleated & Spec. Fabric</td><td>Spare Belts - Plastic Chain</td><td>All equipment and parts</td></tr>
<tr><td>1100 Series</td><td colspan="6" rowspan="7">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.</td><td colspan="2" rowspan="11">non-returnable</td><td rowspan="11">case-by-case</td></tr>
<tr><td>2200 Series</td></tr>
<tr><td>3200 Series</td></tr>
<tr><td>Pallet Systems</td></tr>
<tr><td>FlexMove/SmartFlex</td></tr>
<tr><td>GAL Series</td></tr>
<tr><td>All Electrical</td></tr>
<tr><td>7100 Series</td><td colspan="6" rowspan="4">50% return fee for all products</td></tr>
<tr><td>7200/7300 Series</td></tr>
<tr><td>AquaGard 7350 Series Version 2</td></tr>
<tr><td>GES Series</td></tr>
<tr><td>AquaGard 7350/7360 Series</td><td colspan="8" rowspan="2">non-returnable</td></tr>
<tr><td>AquaPruf Series</td></tr>
</table>

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

DORNER

Dorner – North & South America

Dorner – U.S.A. Headquarters
975 Cottonwood Ave
Hartland, WI 53029, USA
(800) 397-8664
(262) 367-7600
info@dorner.com

Dorner – Canada
100-5515 North Service Road
Burlington, Ontario L7L 6G6
Canada
(289) 208-7306
info@dorner.com

Dorner – Latin America
Carretera a Nogales #5297, Nave 11.
Parque Industrial Nogales
Zapopan, Jalisco C.P. 45222 México
+52.33.30037400 | info.latinamerica@dorner.com

Dorner – Europe

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

Dorner – Asia

128 Jalan Permatang Damar Laut, Bayan Lepas 11960
Penang, Malaysia
+604-626-2948 | info.asia@dorner.com