



7350 Series Version 2 Positive Drive Conveyors

Installation, Maintenance and Parts Manual



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Record Conveyor Serial Number Here

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 **CAUTION**

Some illustrations may show guards removed. DO NOT operate equipment without guards.

Upon receipt of shipment:

- Compare shipment with packing slip. Contact factory regarding discrepancies.
- Inspect packages for shipping damage. Contact carrier regarding damage. Accessories may be shipped loose.
- See accessory instructions for installation.

The Dorner Limited Warranty applies.

Dorner 7350 Series conveyors have patents pending.

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

Dorner has convenient, pre-configured kits of Critical Service Parts for all conveyor products. These time saving kits are easy to order, designed for fast installation, and guarantee you will have what you need when you need it. Recommended Critical Service Parts and Kits are marked in the Service Parts section of this manual with the Key Service Parts symbol .

Warnings – General Safety

⚠ WARNING

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

⚠ DANGER



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

⚠ WARNING



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

⚠ WARNING



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

⚠ WARNING



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

⚠ DANGER



EXPLOSION HAZARD!

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

⚠ WARNING



CRUSH HAZARD!

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

⚠ WARNING



CRUSH HAZARD!

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

⚠ WARNING



SEVERE HAZARD!

- Dorner cannot control the physical installation and application of conveyors. Taking protective measures is the responsibility of the user.
- When conveyors are used in conjunction with other equipment or as part of a multiple conveyor system, CHECK FOR POTENTIAL PINCH POINTS and other mechanical hazards before system start-up.
- Failure to comply could result in serious injury.

Product Description

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

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

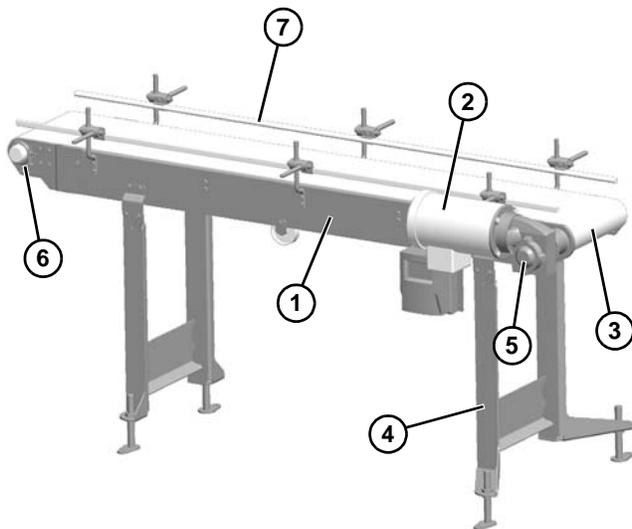
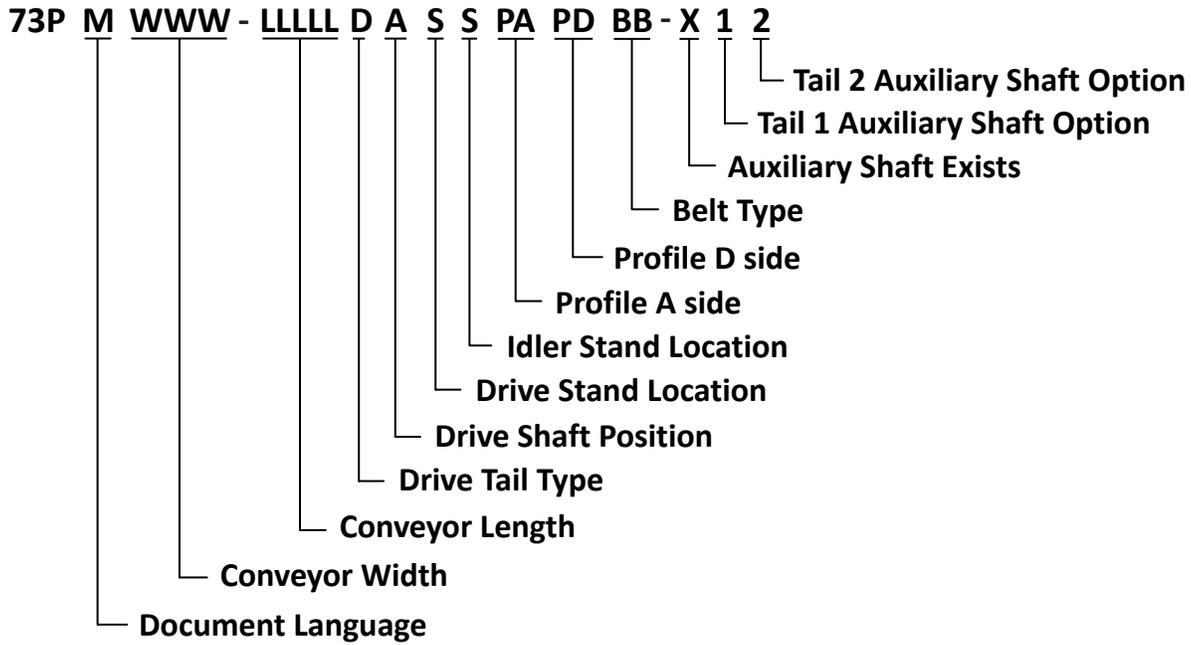


Figure 1

Specifications

7350 Series Version 2 Positive Drive Conveyors



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.

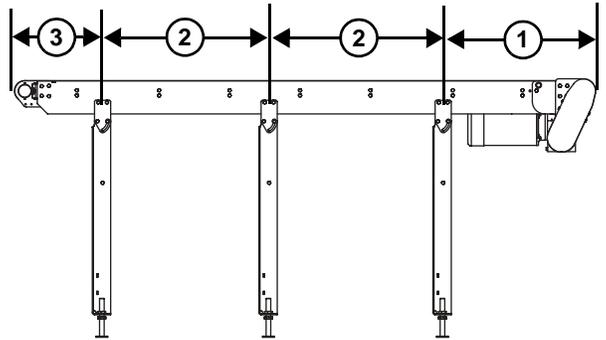


Figure 2

Specifications

Conveyor Width Reference (<u>WWW</u>)	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	305 mm (12") per revolution of pulley
Maximum Belt Speed	71 m/minute (233 ft/minute)
Conveyor Length Reference (<u>LLLLL</u>)	00915 - 25000 in 00005 increments
Conveyor Length	915 mm (36") - 25000 mm (984") 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

Installation

⚠ 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
- 10 mm wrench
- 13 mm wrench

Recommended Installation Sequence

1. Assemble the conveyor (if required). Refer to “Conveyors Longer than 10 ft (3048 mm)” on page 8.
2. Attach the stands. Refer to “Stand Installation” on page 9.
3. Install the belt. Refer to “Belt Installation” on page 9.
4. Install belt returns. Refer to “Belt Returns” on page 11.
5. Install the gearmotor. Refer to “Drive Package Installation” on page 14.

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 |

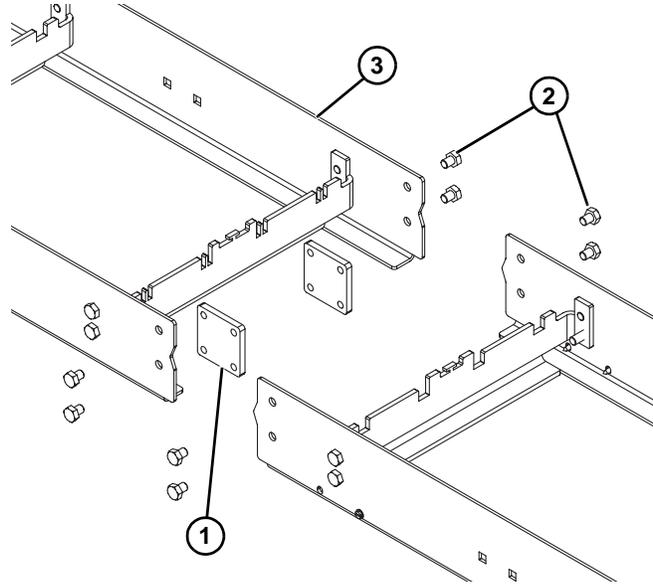


Figure 4

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).

Stand Installation

NOTE

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

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

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

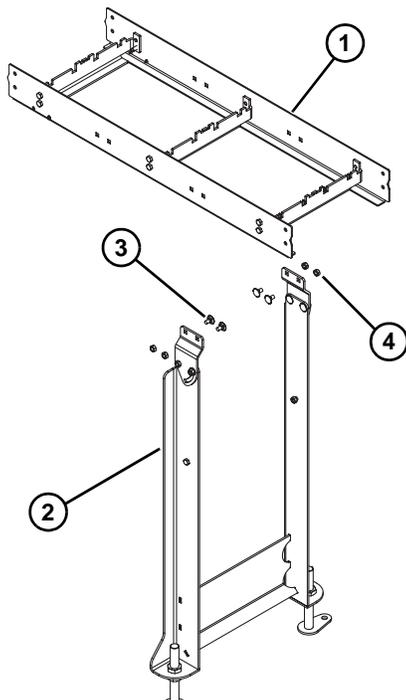


Figure 6

1. Position the stands on a flat, level surface.
2. Attach the stands (**Figure 7, item 1**) to the frame. Tighten to 14-16 ft-lbs (19-22 Nm).

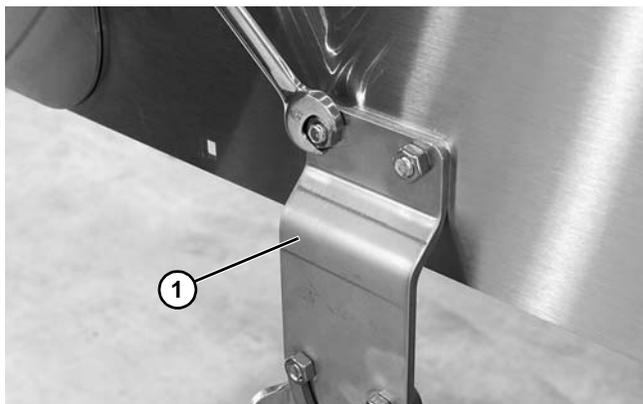


Figure 7

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 8, item 1**) at both ends of the conveyor. Place an additional support stand (**Figure 8, item 2**) under the drive motor, if equipped. See WARNING.

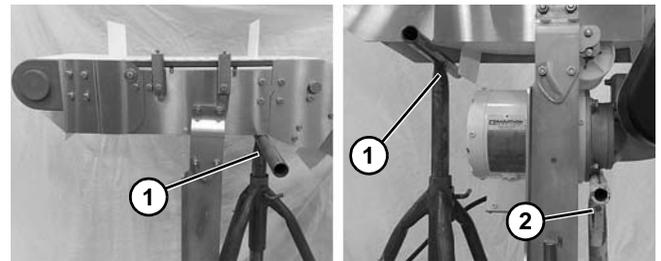


Figure 8

2. Remove fasteners (**Figure 9, item 1**) securing the stand brackets from one side of the conveyor and remove brackets.

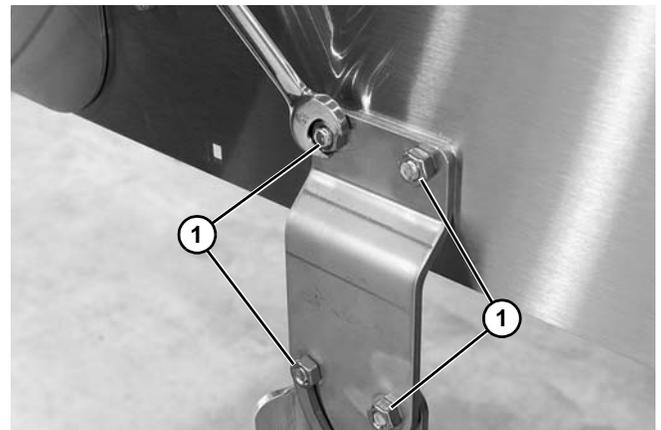


Figure 9

Installation

3. Rotate tip-up idler tail (**Figure 10, item 1**) upward as shown.

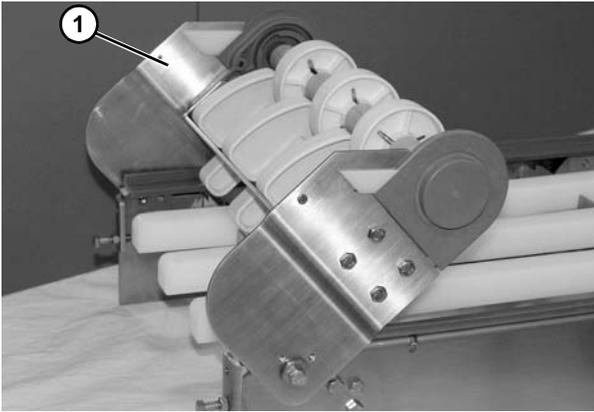


Figure 10

4. Position the belt (**Figure 11, item 1**) onto the conveyor (**Figure 11, item 2**).

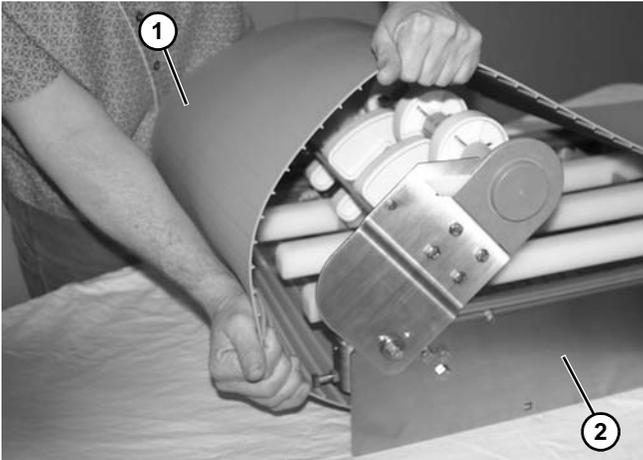


Figure 11

5. Install stand brackets to conveyor with fasteners.

NOTE

*Loosen nuts and adjust screws (**Figure 12, item 1**) to level tail (as needed).*

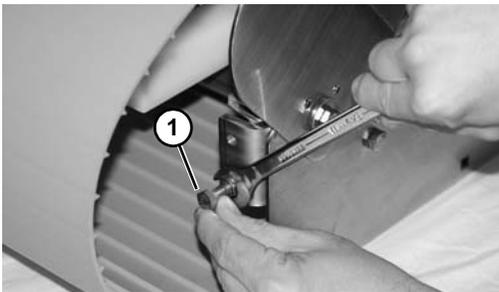


Figure 12

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

NOTE

*To lower idler tail, push idler tail (**Figure 13, item 1**) to its maximum up position, and move locking lever (**Figure 13, item 2**) up to disengage lock. Lower tail slowly.*

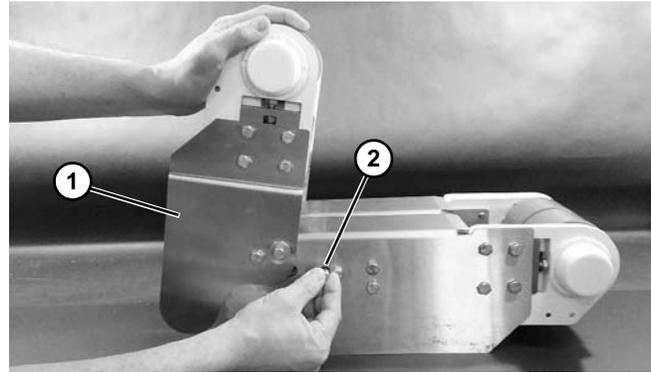


Figure 13

Return Shoe

1. Attach one bracket (**Figure 14, item 1**) to each side of the conveyor loosely with two screws (**Figure 14, item 2**).

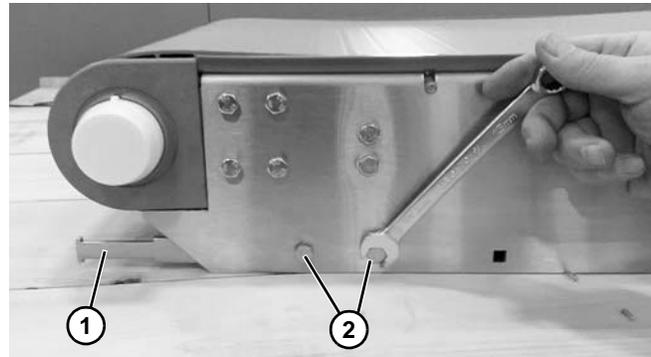


Figure 14

2. Insert return shoe (**Figure 15, item 1**).



Figure 15

3. Adjust bracket to engage belt. Tighten screws.

Belt Returns

Belt Returns 660 mm Wide and Wider

Typical return components (Figure 16).

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

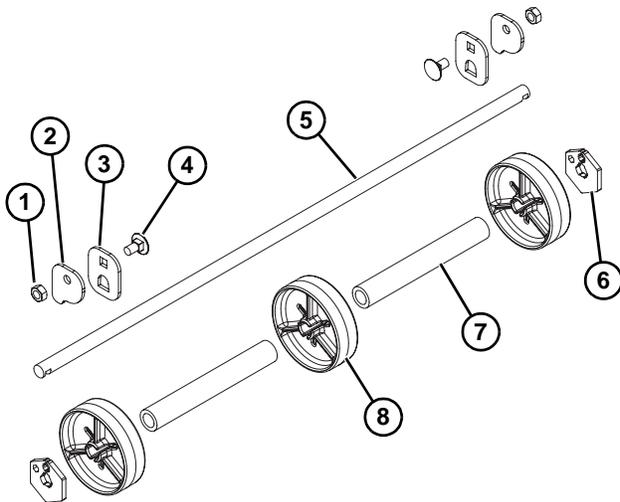


Figure 16

1. Install carriage bolt (Figure 17, item 1) through frame rail.

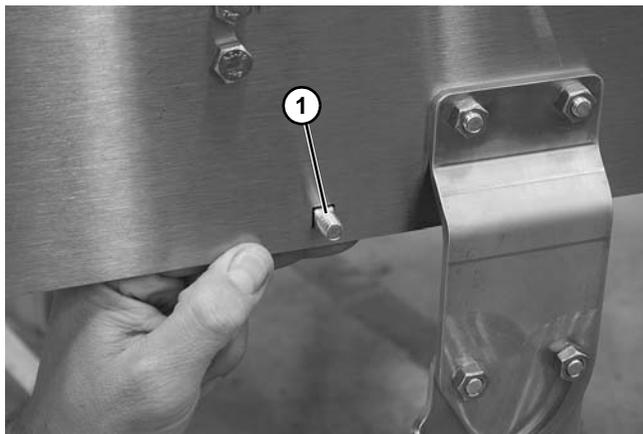


Figure 17

2. Install return bracket (Figure 18, item 1).

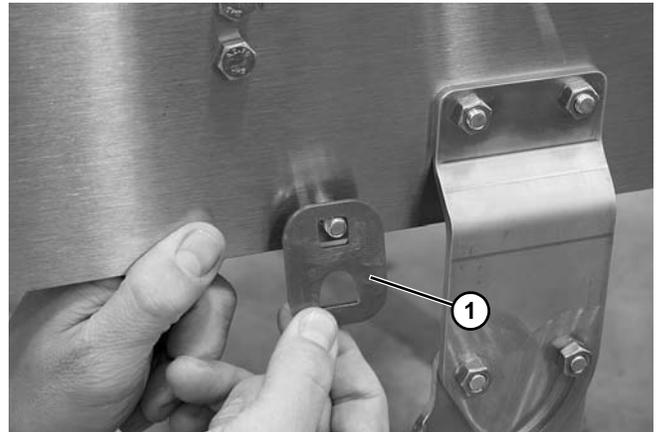


Figure 18

3. Install return clip (Figure 19, item 1) and loosely secure with nut (Figure 19, item 2).

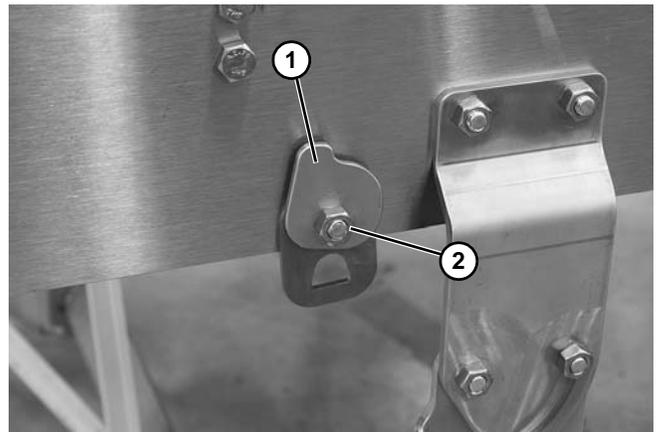


Figure 19

4. Repeat on the opposite side of the conveyor.
5. Install belt return assembly (Figure 20, item 1) onto return brackets (Figure 20, item 2).

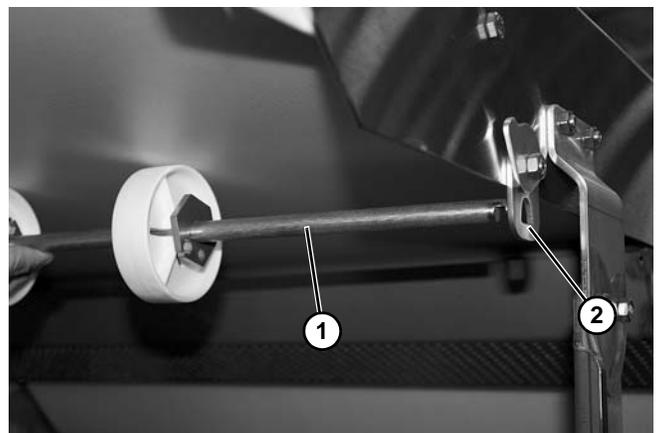


Figure 20

Installation

- Rotate return clip (**Figure 21, item 1**) down against shaft (**Figure 21, item 2**) on both sides of conveyor. Tighten nuts (**Figure 21, item 3**).

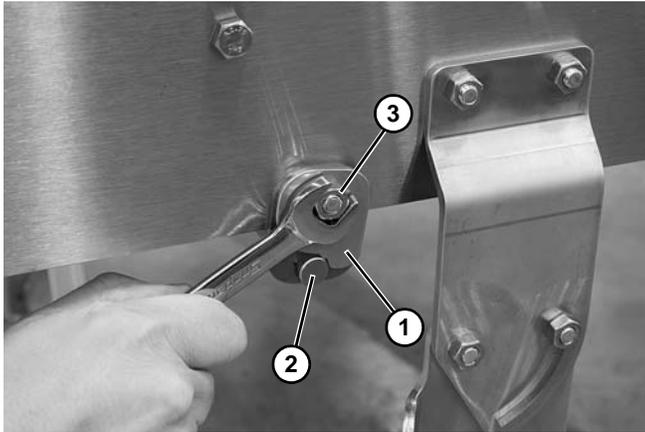


Figure 21

Belt Returns Under 660 mm Wide

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

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

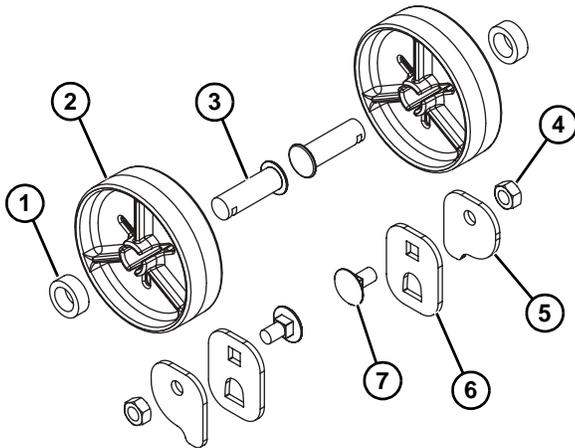


Figure 22

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

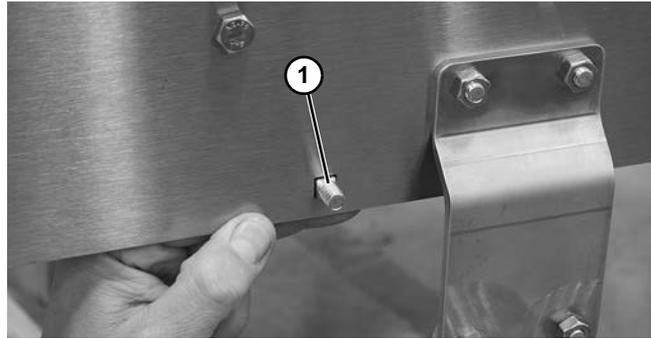


Figure 23

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



Figure 24

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

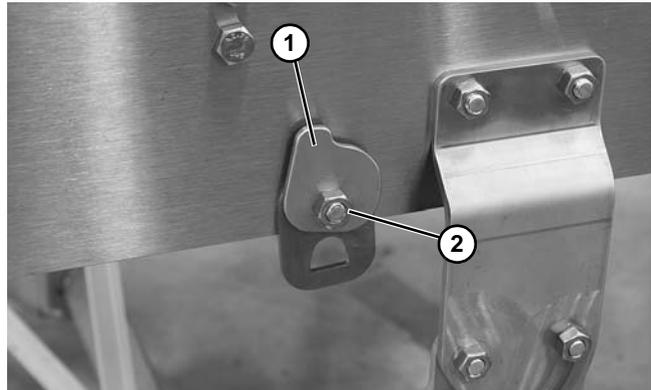


Figure 25

- Repeat on the opposite side of the conveyor.

Installation

5. Install each puck (Figure 26, item 1) onto return bracket (Figure 26, item 2) with stub shaft (Figure 26, item 3) and spacer (Figure 26, item 4).

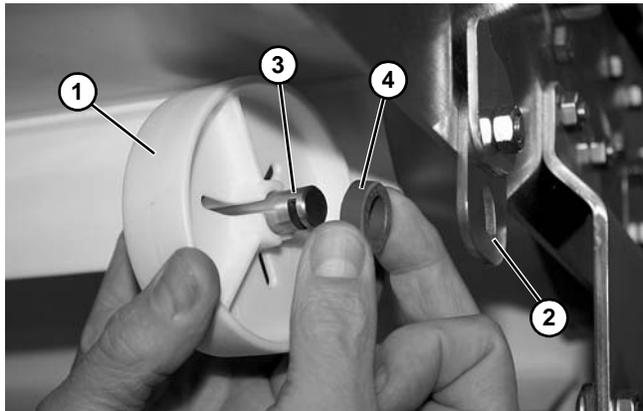


Figure 26

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).

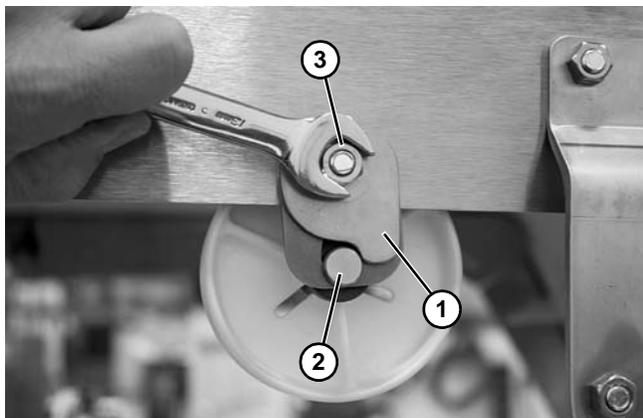


Figure 27

Guide Installation

High Side Guides

1. Remove the top screw (Figure 28, item 1) from the conveyor side.



Figure 28

2. Assemble the mounting block (Figure 29, item 1) to the conveyor side with the screw (Figure 29, item 2) provided.

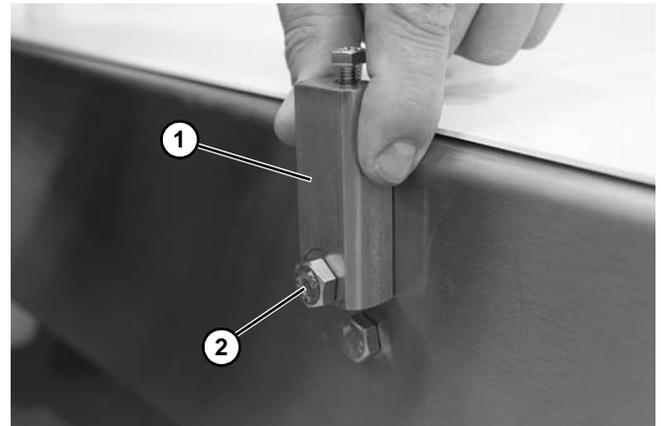


Figure 29

3. Install guide (Figure 30, item 1) into the slot (Figure 30, item 2) of the mounting block and tighten screws (Figure 30, item 3).

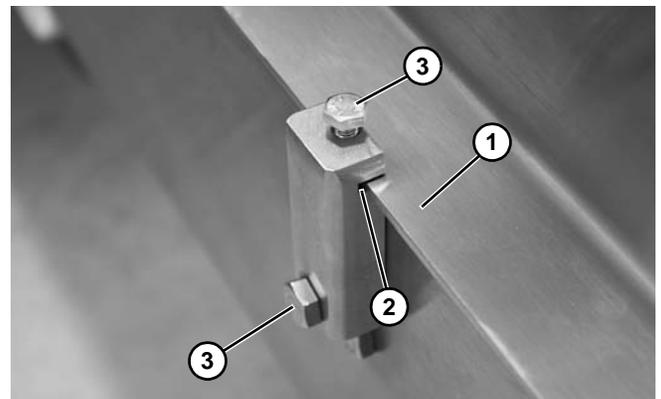


Figure 30

4. Install the connecting plate (Figure 31, item 1) over the studs.

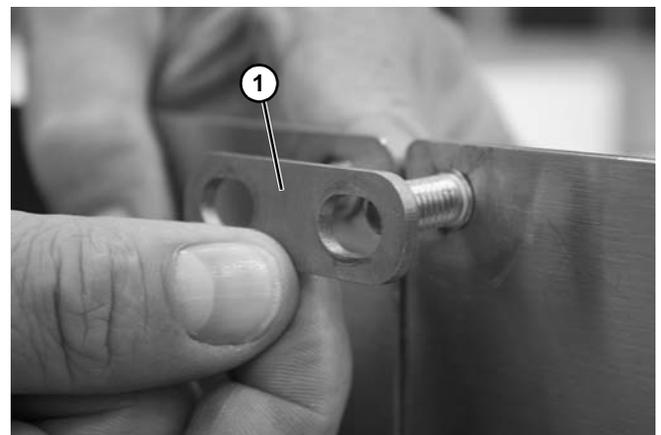


Figure 31

Installation

5. Install nuts (**Figure 32, item 1**) and tighten.

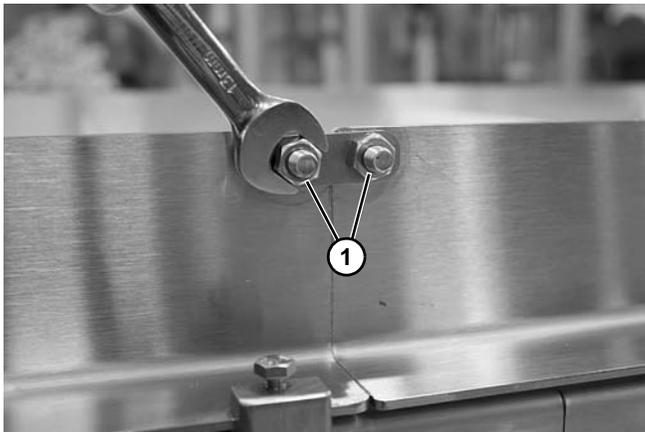


Figure 32

Adjustable Guides

1. Remove the top screw (**Figure 33, item 1**).

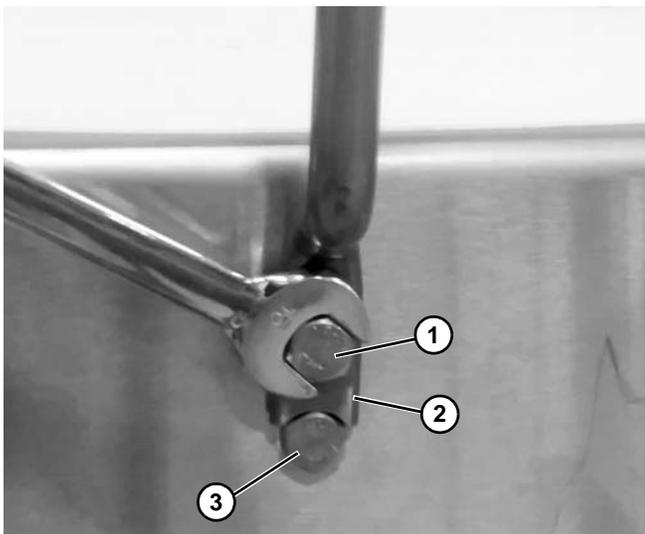


Figure 33

2. Install the guide post (**Figure 33, item 2**) resting on lower screw (**Figure 33, item 3**). Reinstall top screw and tighten.

3. Install guide rail (**Figure 34, item 1**) into rail clamp. Tighten fastener (**Figure 34, item 2**) to secure.

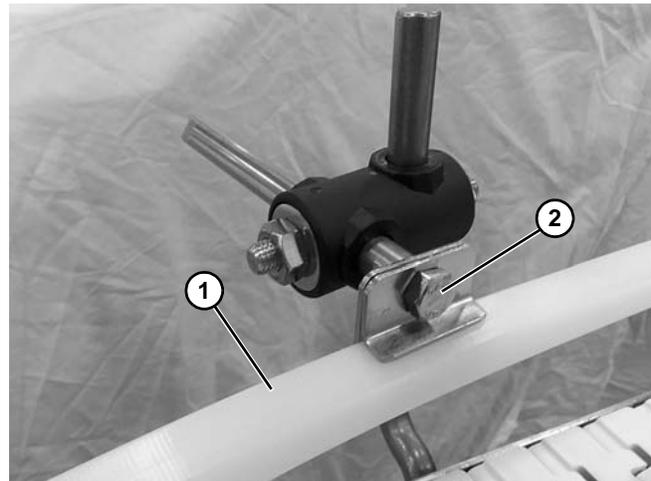


Figure 34

NOTE

See pages 34 to 37 for detailed view of guide assembly.

Drive Package Installation

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

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

1. Attach the motor (**Figure 35, item 1**) to the gear reducer (**Figure 35, item 2**).

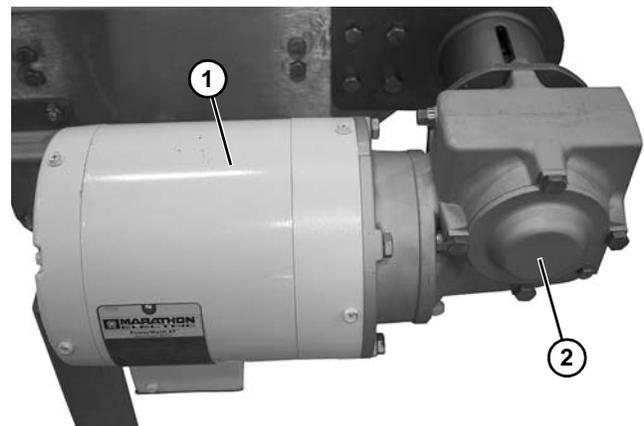


Figure 35

Preventive Maintenance and Adjustment

Required Tools

- 1/8" hex wrench
- 6 mm hex wrench
- 8 mm hex wrench
- 10 mm wrench
- 13 mm wrench
- 17 mm wrench
- Flat Blade Screwdriver

Checklist

- Keep critical service parts on hand. Refer to the "Service Parts" section starting on page 24 for recommendations.
- Replace any worn or damaged parts.

Cleaning

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

⚠ CAUTION
Dorner recommends cleaning all the "food zones" 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
- Worn return shoe

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 36, item 1) when required.

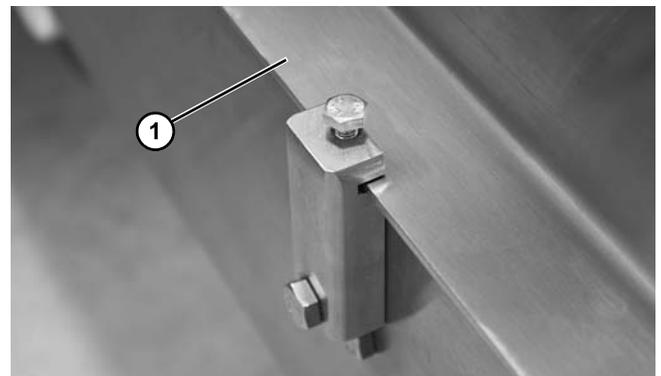


Figure 36

2. Remove belt returns:
 - a. For flat returns 660 mm wide and wider, refer to "Belt Returns 660 mm Wide and Wider" on page 21. Follow steps 1 and 2.

Preventive Maintenance and Adjustment

- b. For cleated returns and flat returns under 660 mm wide, refer to “Belt Returns Under 660 mm Wide” on page 23. Follow steps 1 and 2.

 WARNING

<p>Removing mounting brackets without support under gearmotor will cause conveyor to tip, causing severe injury.</p> <p>PROVIDE SUPPORT UNDERNEATH THE GEARMOTOR WHEN CHANGING THE BELT.</p>

3. Place temporary support stands (Figure 37, item 1) at both ends of the conveyor. Place an additional support stand (Figure 37, item 2) under the drive motor, if equipped. See WARNING.

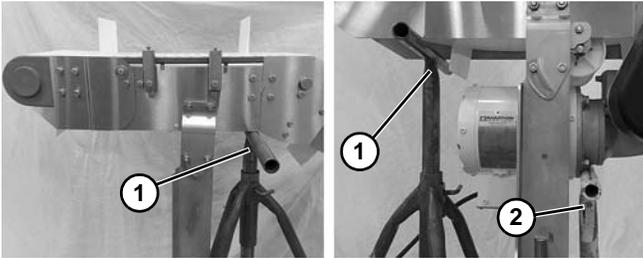


Figure 37

4. Remove fasteners (Figure 38, item 1) securing the stand brackets from one side of the conveyor and remove brackets.

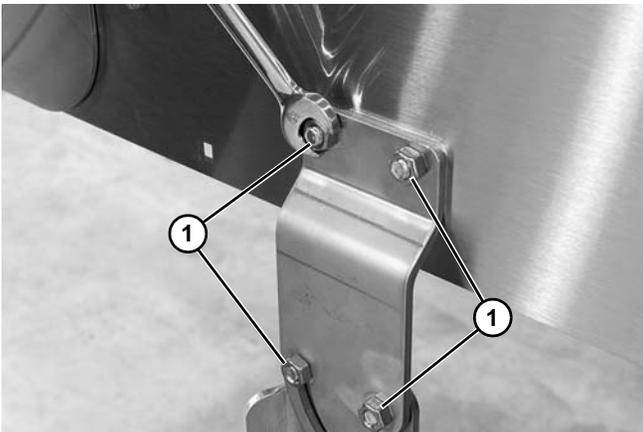


Figure 38

5. Rotate idler end (Figure 39, item 1) upward as shown.

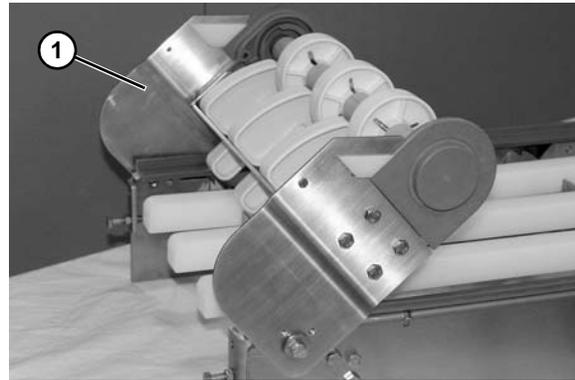


Figure 39

6. Remove the belt (Figure 40, item 1) from the conveyor (Figure 40, item 2).

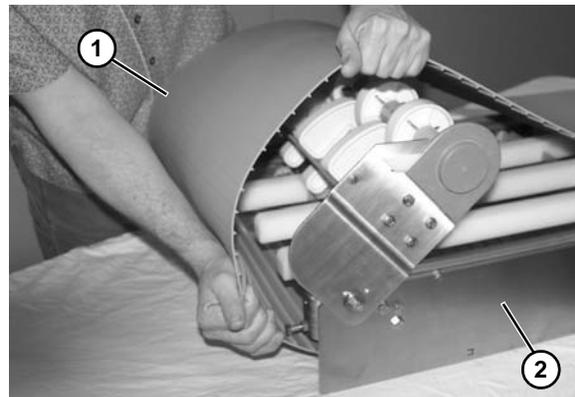


Figure 40

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 9.

NOTE
<p>To lower idler tail, push idler tail (Figure 41, item 1) to its maximum up position, and move locking lever (Figure 41, item 2) up to disengage lock. Lower tail slowly.</p>

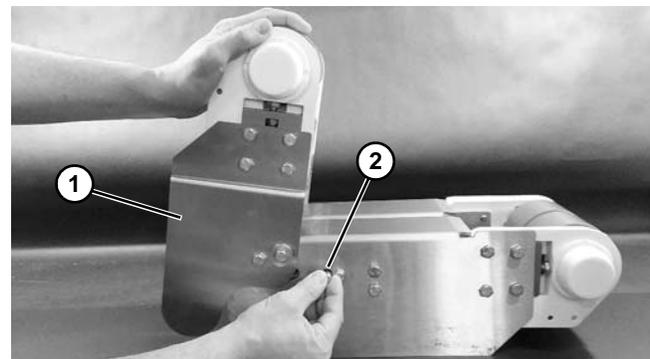


Figure 41

Preventive Maintenance and Adjustment

Wear Strips

Replace the wear strips if they become worn.

Typical standard wear strips (**Figure 42**).

1	Side Wear Strips
2	Center Wear Strips

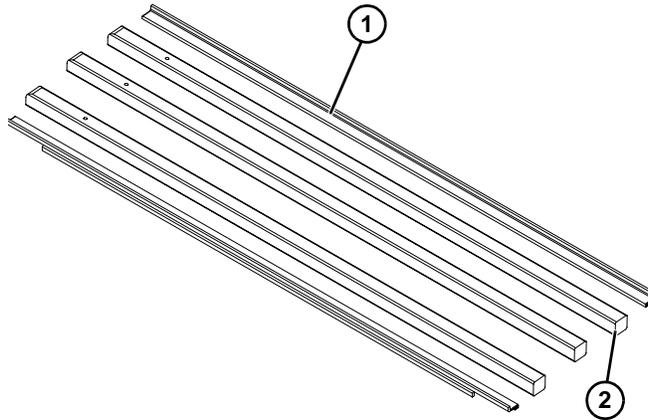


Figure 42

Wear Strip Removal

1. Remove conveyor belt. Refer to “Conveyor Belt Replacement” on page 15.
2. Remove worn wear strips (**Figure 43, item 1**) from the frame notches.

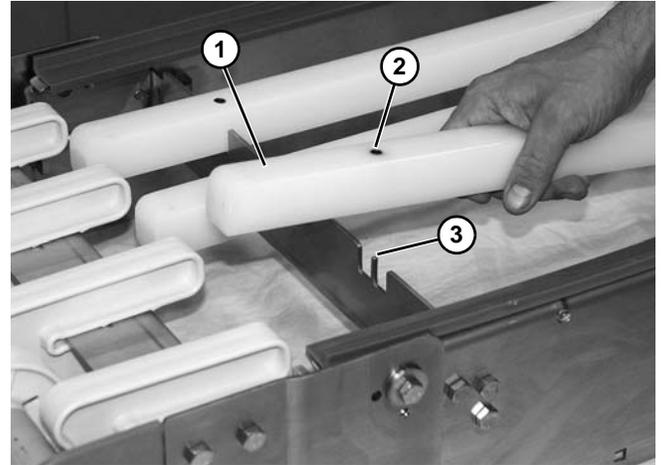


Figure 43

3. Attach new wear strips by installing the locating hole (**Figure 43, item 2**) over the tab (**Figure 43, item 3**) on the crossmember.

NOTE

Angled end of the wear strip must face up.

Side Rail Wear Strip Replacement

1. Remove two self-tapping screws (**Figure 44, item 1**) retaining the wear strip to the frame.

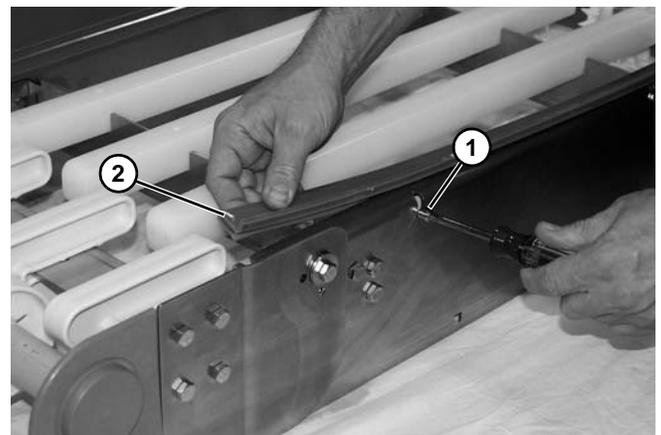


Figure 44

2. Remove the wear strip (**Figure 44, item 2**) from the frame rail.
3. Replace with new wear strip and self-tapping screws.

Preventive Maintenance and Adjustment

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 15.
3. Remove two screws (**Figure 45, item 1**) securing drive support brackets (**Figure 45, item 2**) to center member. Repeat on opposite side of the conveyor.

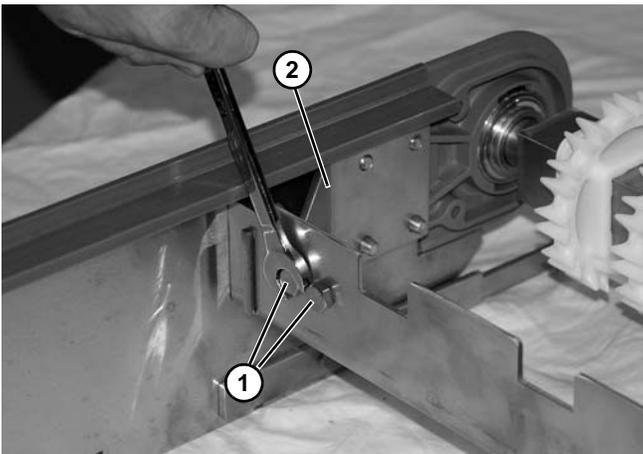


Figure 45

4. Remove four headplate screws (**Figure 46, item 1**). Repeat on opposite side of the conveyor.

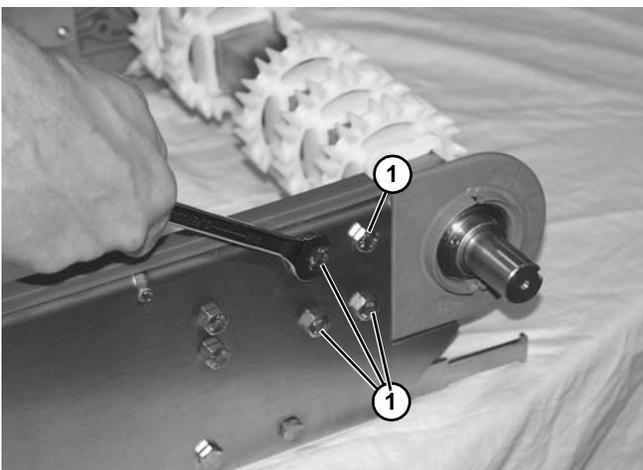


Figure 46

5. Slide the drive spindle assembly (**Figure 47, item 1**) and drive tail blocks (**Figure 47, item 2**) off of frame (**Figure 47, item 3**).

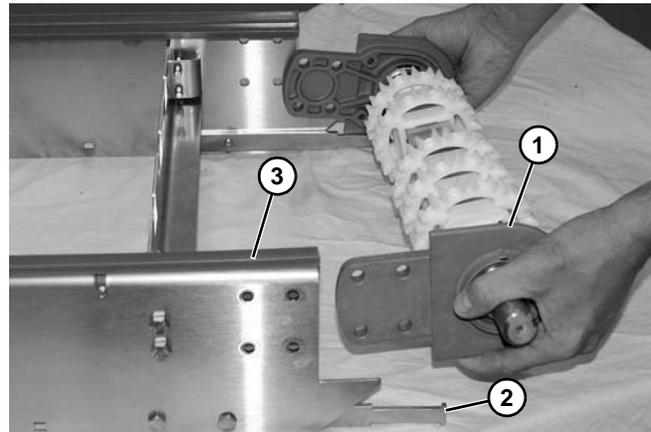


Figure 47

6. Remove the bearing cover (**Figure 48, item 1**).

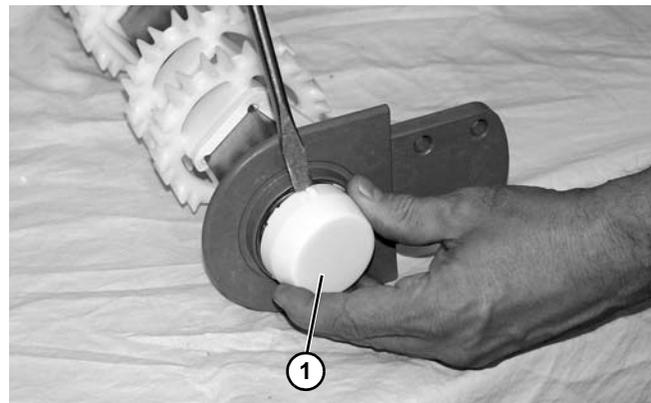


Figure 48

7. Loosen two set screws (**Figure 49, item 1**).

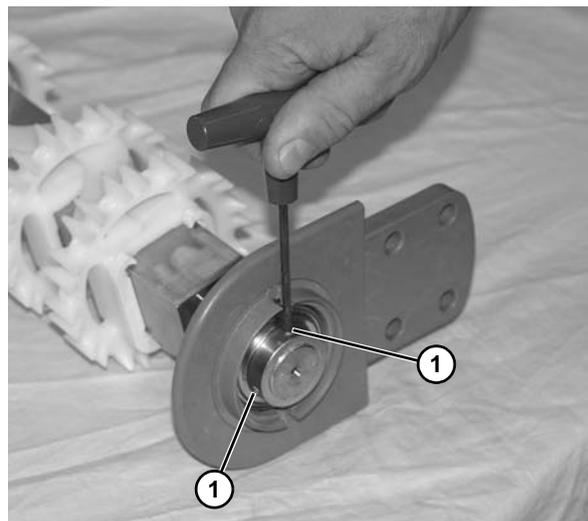


Figure 49

8. Slide the headplate with bearing off the shaft.

Preventive Maintenance and Adjustment

9. Remove the retaining clip (Figure 50, item 1) off the shaft (Figure 50, item 2).

NOTE
<i>Make note of the recessed areas (Figure 50, item 3) of shaft where retaining clip seats into.</i>

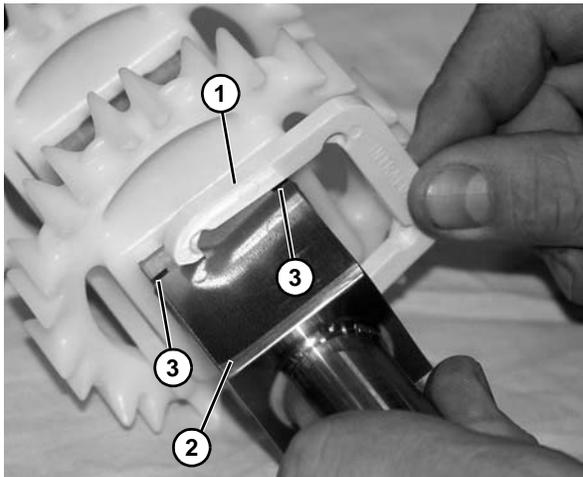


Figure 50

10. Remove the sprockets (Figure 51, item 1) and sprocket key (Figure 51, item 2) off the shaft (Figure 51, item 3).

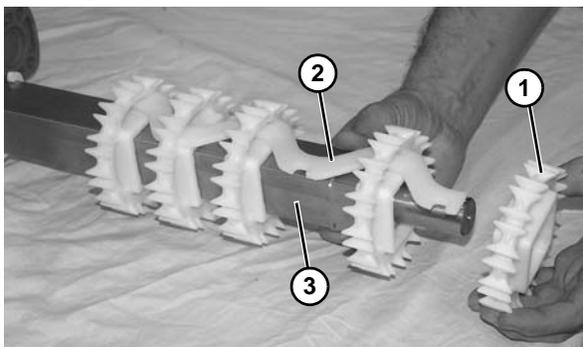


Figure 51

11. Repeat for opposite side headplate.
12. If necessary, refer to “Bearing Replacement” on page 21 for replacing bearing in each headplate.
13. 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 15.
2. Remove four headplate screws (Figure 52, item 1). Repeat on opposite side of the conveyor.

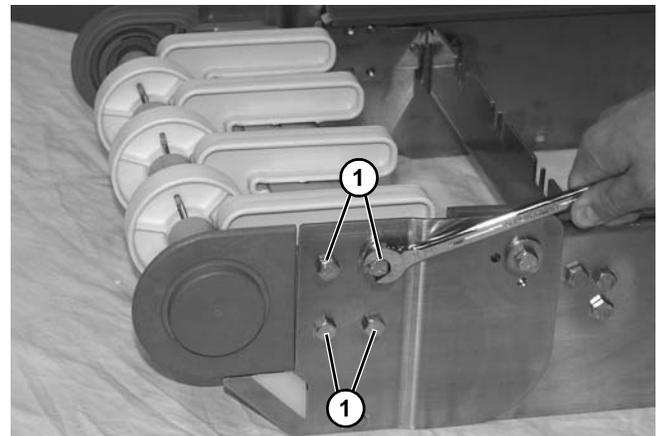


Figure 52

3. Slide the idler spindle assembly (Figure 53, item 1) off the pivot tail blocks (Figure 53, item 2).

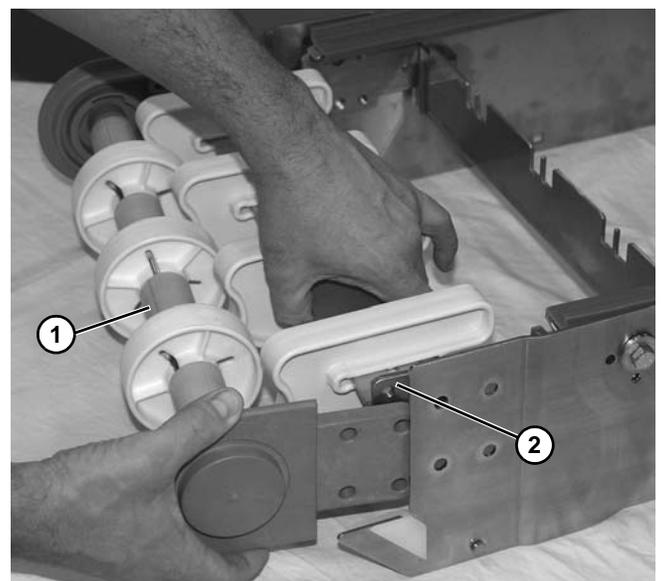


Figure 53

Preventive Maintenance and Adjustment

- Remove the headplate (**Figure 54, item 1**) from spindle. Repeat on opposite side.

NOTE

Make note of the notch (**Figure 54, item 2**) on the spindle where it seats into notched area (**Figure 54, item 3**) in headplate.

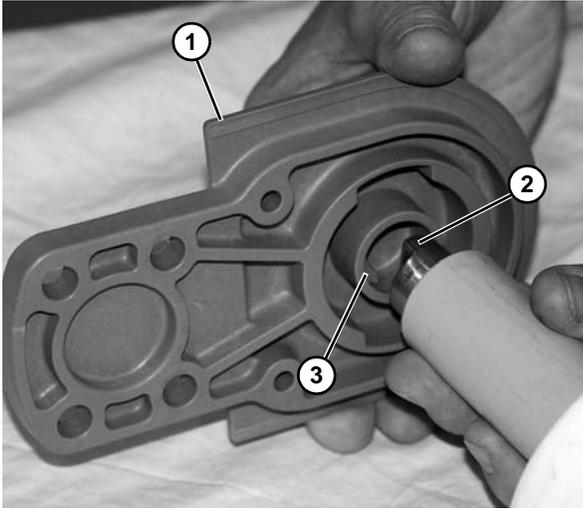


Figure 54

- Slide off the round puck spacer (**Figure 55, item 1**).

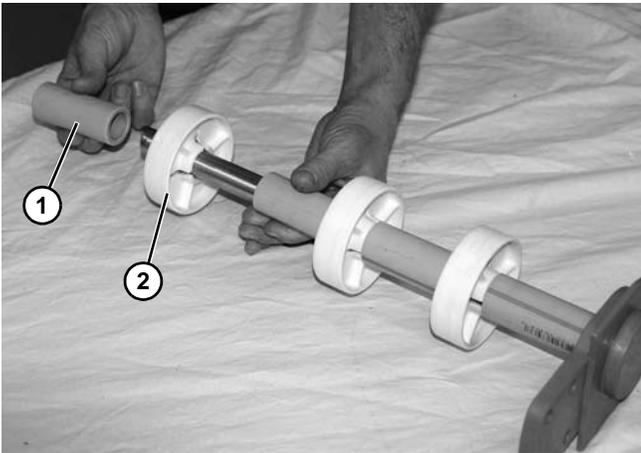


Figure 55

- Slide off puck (**Figure 55, item 2**) and replace if worn.
- Repeat as needed.

- Slide off wear belt shoe (**Figure 56, item 1**) and replace if worn.

NOTE

Make note of the notch (**Figure 56, item 2**) where each belt shoe seats onto support bracket (**Figure 56, item 3**).

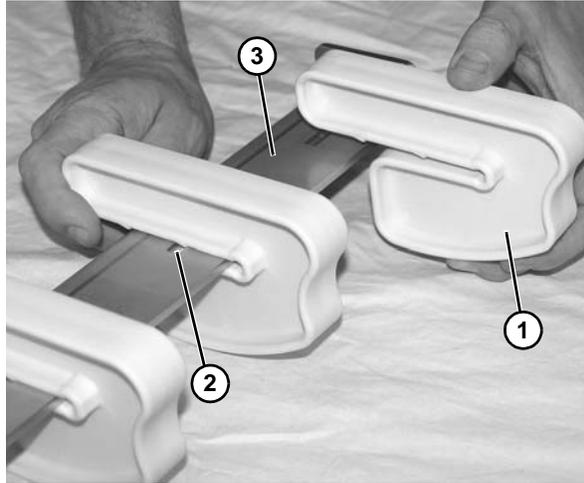


Figure 56

- Repeat as needed.
- Remove belt support J-Legs (**Figure 57, item 1**).

NOTE

Before installing shoe, make sure narrow surface (**Figure 57, item 2**) of J-Leg is to the outside, and wider surface (**Figure 57, item 3**) is installed toward the inside of conveyor.

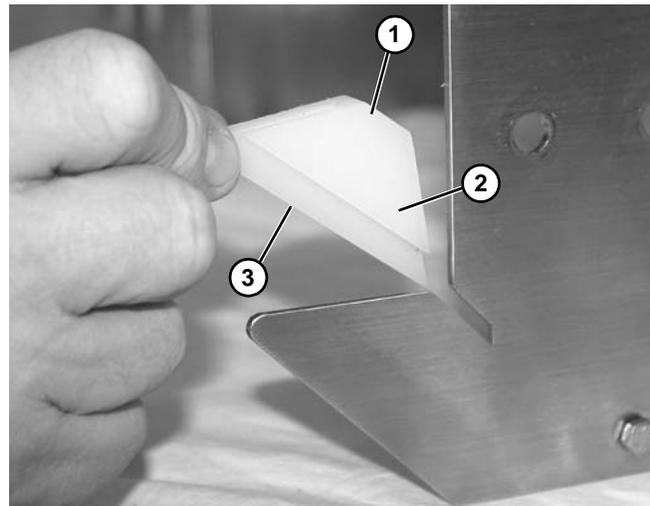


Figure 57

- Install parts in reverse order of removal.

Preventive Maintenance and Adjustment

Bearing Replacement

⚠ WARNING

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

Belt Return Maintenance

⚠ 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 18. Follow steps 1 through 7.
2. For idler bearing, refer to “Idler Spindle Replacement” on page 19. Follow steps 1 through 7.
3. Turn bearing (**Figure 58, item 1**) to align with slots (**Figure 58, item 2**) in bearing housing. Then remove bearing.

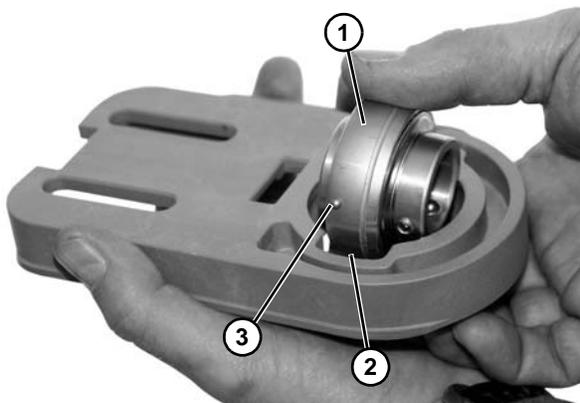


Figure 58

4. Inspect bearing housing bearing surface. Replace if worn or damaged. Refer to “Service Parts” on page 24.
5. Insert bearing (**Figure 58, item 1**) into housing slot. Locate anti-rotation nub (**Figure 58, item 3**) to align with slot (**Figure 58, item 2**) and twist bearing into housing.

Belt Returns 660 mm Wide and Wider

1. Loosen nut (**Figure 59, item 1**) and rotate return clip (**Figure 59, item 2**) up on both sides of conveyor. Loosely tighten nuts to hold clip in place.

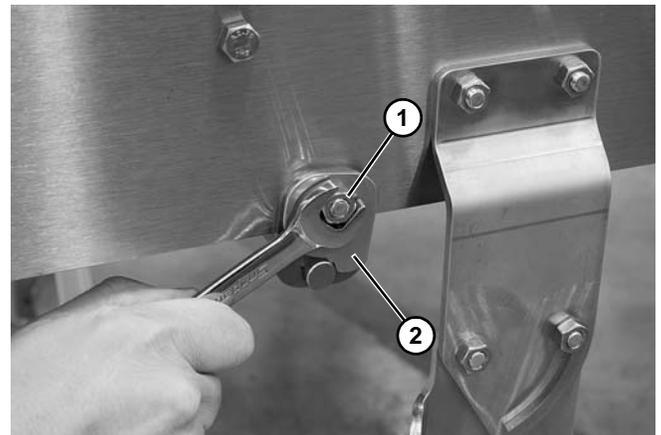


Figure 59

2. Remove belt return assembly (**Figure 60, item 1**) from return brackets (**Figure 60, item 2**).

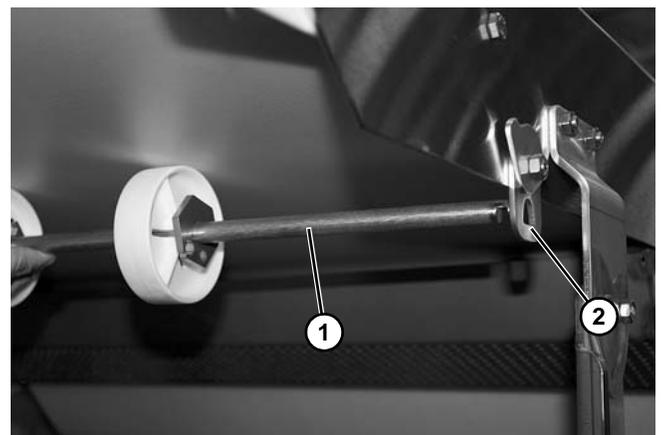


Figure 60

Preventive Maintenance and Adjustment

3. Insert an 8 mm (**Figure 61, item 1**) and 6 mm (**Figure 61, item 2**) hex wrench into the retainer plate.

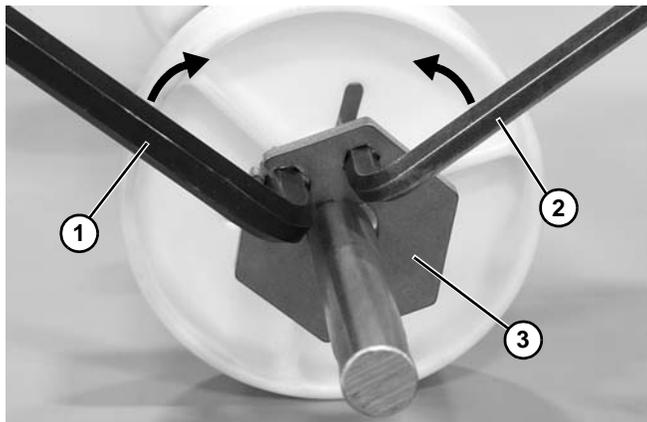


Figure 61

4. Move wrenches toward each other to unlock the retainer plate (**Figure 61, item 3**) and remove from the shaft.
5. Remove puck (**Figure 62, item 1**) from the shaft.



Figure 62

6. Repeat steps 3 through 5 as needed.

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

- a. Insert an 8 mm (**Figure 63, item 1**) and 6 mm (**Figure 63, item 2**) hex wrench into the retainer plate.

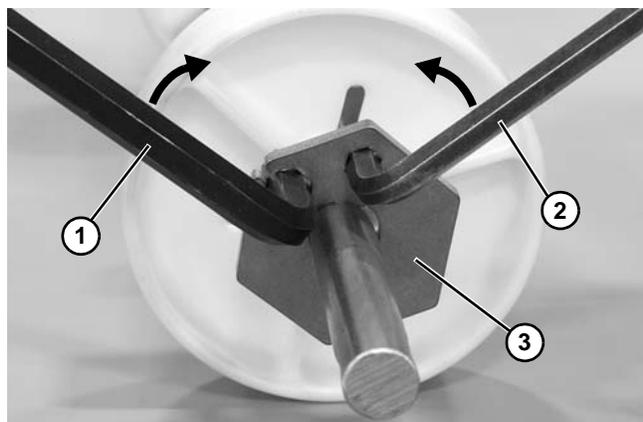


Figure 63

- b. Move wrenches toward each other to open the retainer plate (**Figure 63, item 3**) and install onto the shaft. Position retainer plate where needed.
- c. To lock the retainer plate (**Figure 64, item 1**) in place, move the wrenches (**Figure 64, item 2**) away from each other.

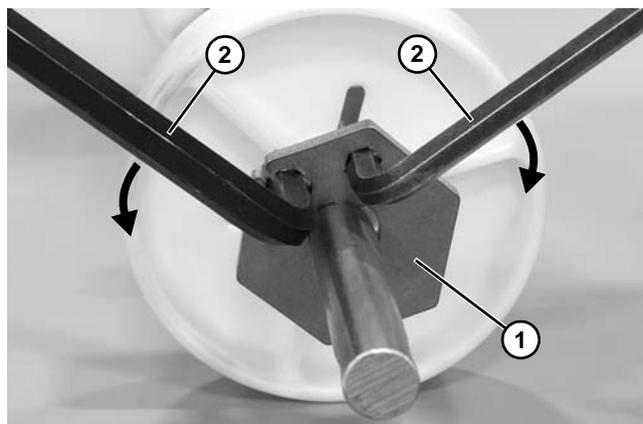


Figure 64

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

Preventive Maintenance and Adjustment

Belt Returns Under 660 mm Wide

1. Loosen nut (**Figure 65, item 1**) and rotate return clip (**Figure 65, item 2**) up on both sides of conveyor. Loosely tighten nuts to hold clip in place.

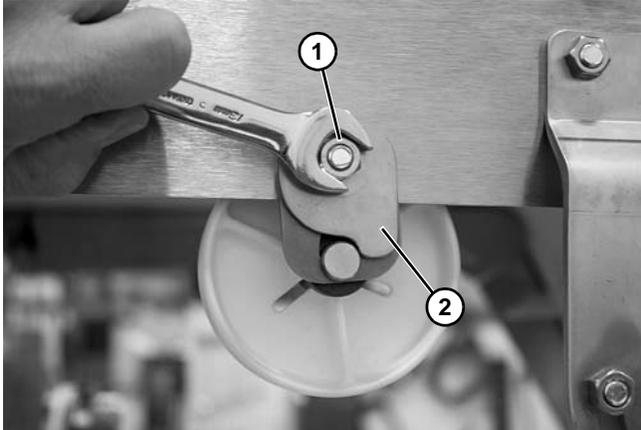


Figure 65

2. Remove puck (**Figure 66, item 1**), stub shaft (**Figure 66, item 2**), and spacer (**Figure 66, item 3**) from return bracket (**Figure 66, item 4**).

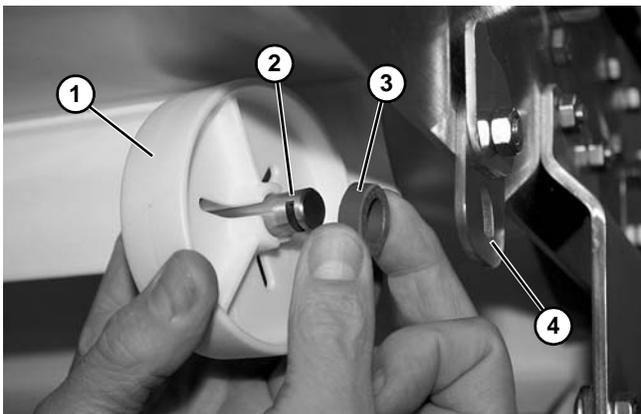


Figure 66

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

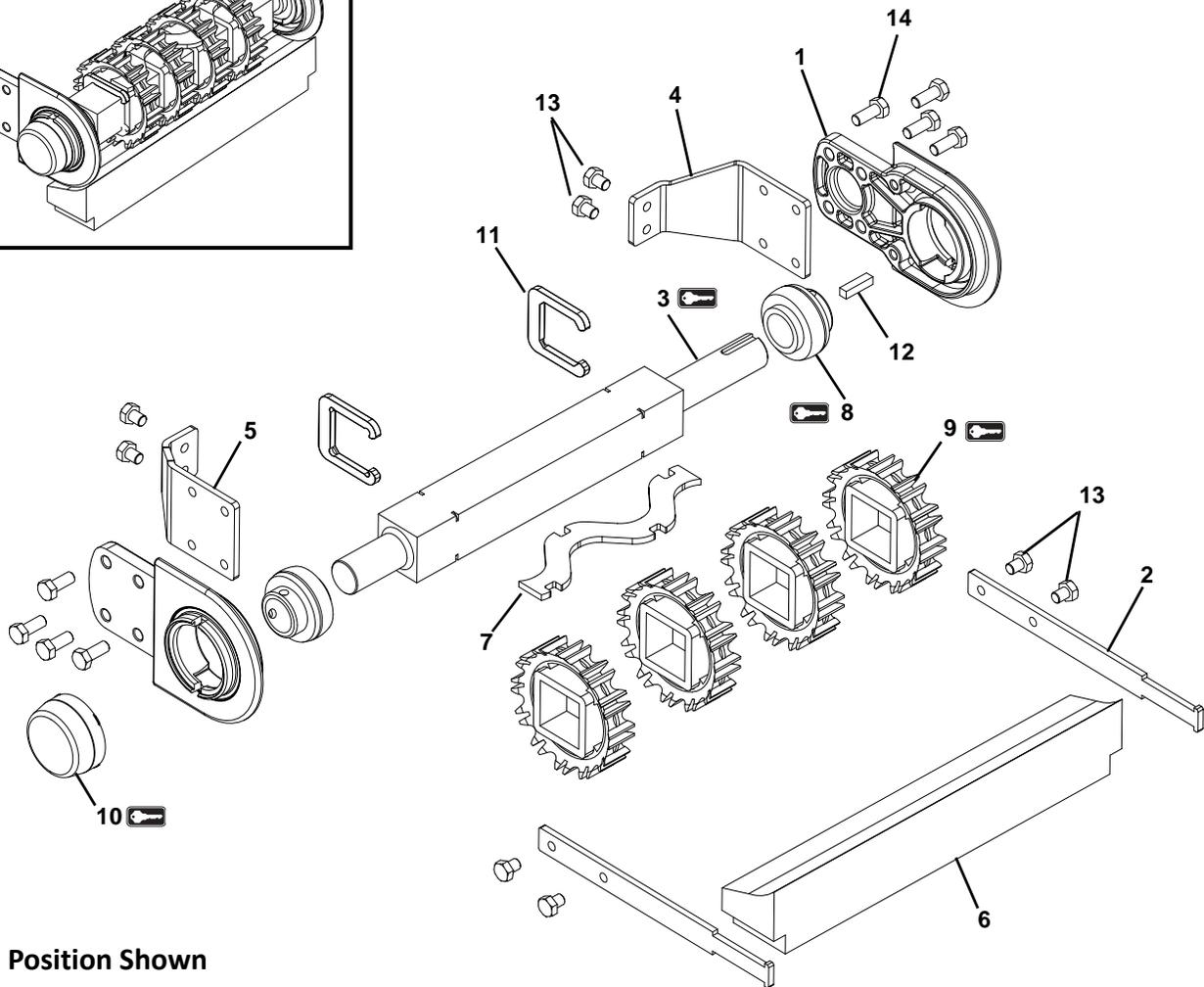
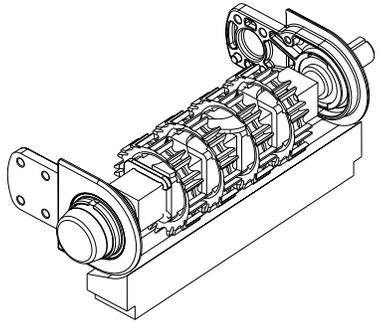
Service Parts

NOTE

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

End Drive Tail

15 Drive Tail Kit

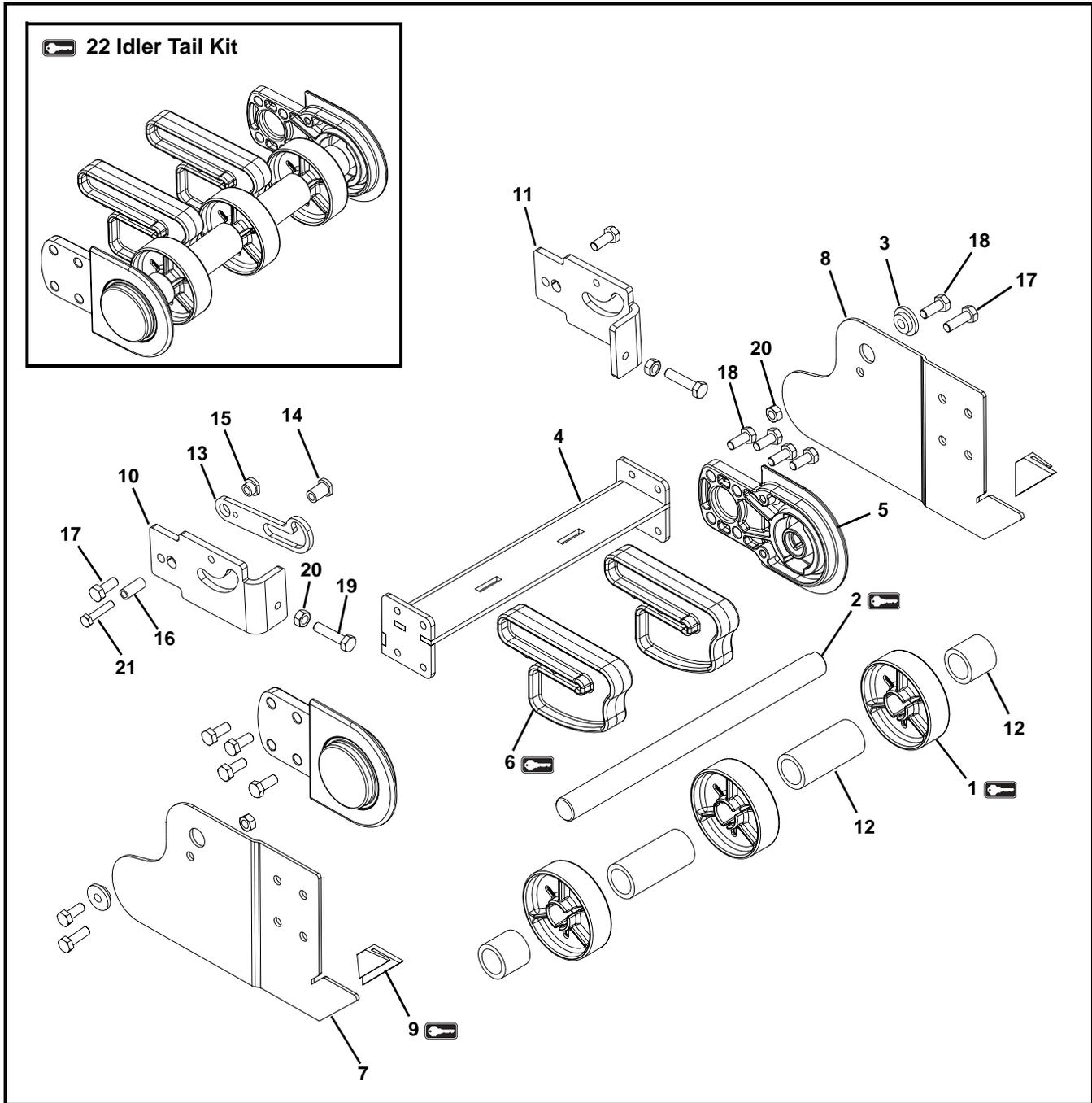


'A' Position Shown

Item	Part Number	Description
1	516813	Headplate Assembly
2	516845	Return Shoe Support Arm
	516821-0K- <u>WW</u>	Drive Spindle for "D" position
	516821-K0- <u>WW</u>	Drive Spindle for "A" position
	516821-KK- <u>WW</u>	Dual Shaft Spindle
4	516842-LH	Drive Support Bracket, Left Hand
5	516842-RH	Drive Support Bracket, Right Hand
6	516844- <u>WW</u>	Return Shoe
7	516991- <u>WW</u>	Sprocket Key for 10" and Wider Conveyors Only
8	802-161	Bearing
9	807-1445	Sprocket
10	807-1454	Bearing Cap
11	807-1947	Retaining Clip
12	912-108SS	Square Key, .25" x 1.00"
13	960810MSS	Hex Head Cap Screw, M8-1.25 x 10 mm
14	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
	520431-0K- <u>WW</u>	Drive Tail Kit for 'D' position (Includes items 1, 3, 6, 7, 8, 9, 10, 11, and 12)
	520431-K0- <u>WW</u>	Drive Tail Kit for 'A' position (Includes items 1, 3, 6, 7, 8, 9, 10, 11, and 12)
	520431-KK- <u>WW</u>	Dual Shaft Drive Tail Kit (Includes items 1, 3, 6, 7, 8, 9, 10, 11, and 12)
<u>WW</u> = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 7 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

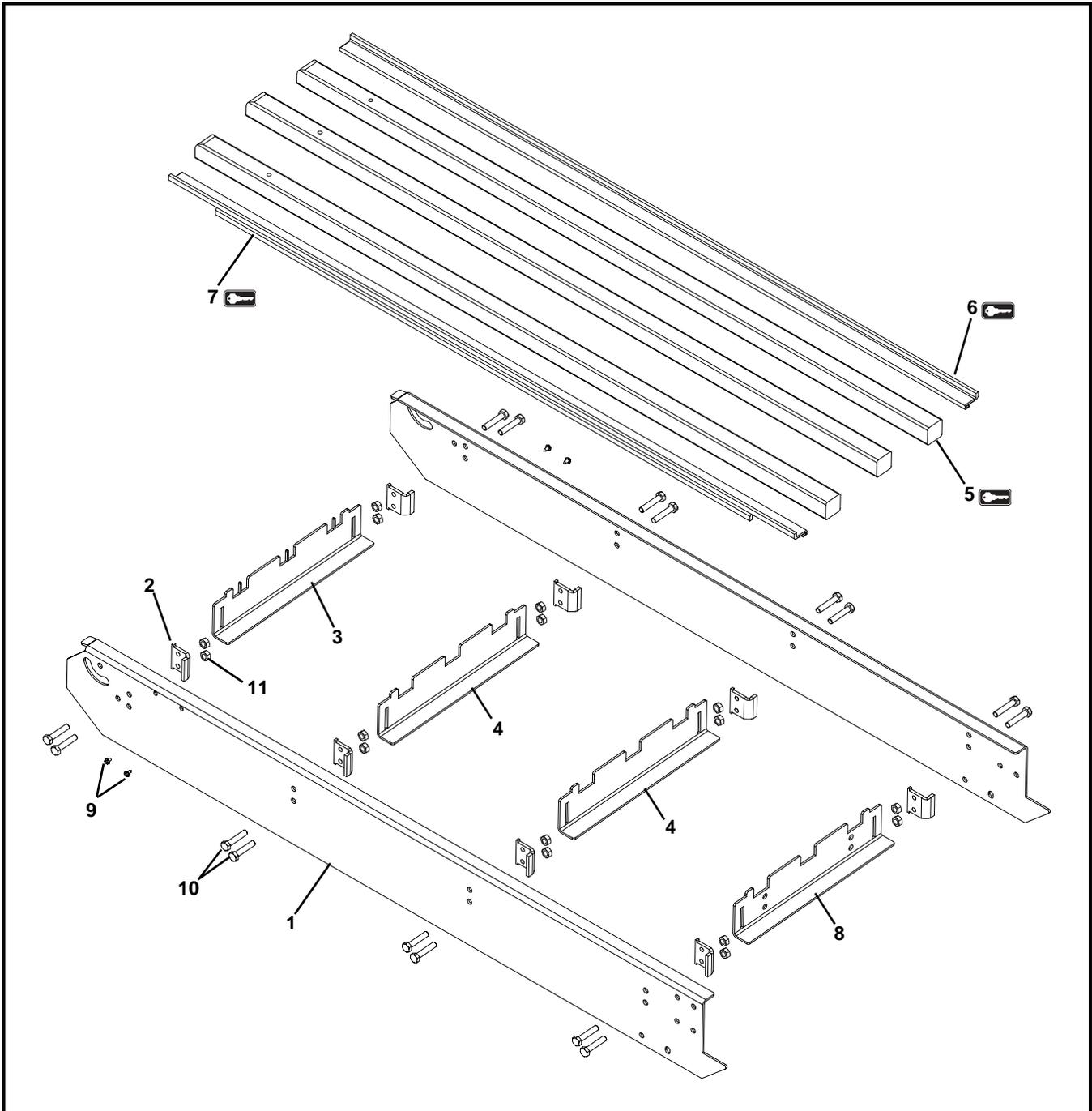


Service Parts

Item	Part Number	Description
1 	506296	Idler Puck
2 	516829- <u>WW</u>	Idler Spindle
3	516850	Bushing
4	516853- <u>WW</u>	Support Bracket
5	516900	Headplate Assembly
6 	516922	Belt Support Shoe
7	516963	Tail Plate, Left Hand
8	516964	Tail Plate, Right Hand
9 	518413	Wear J-Leg
10	518415-LH	Bracket, Left Hand
11	518415-RH	Bracket, Right Hand
12	532127- <u>LLLLL</u>	Spacer Tube
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	960820MSS	Hex Head Cap Screw, M8-1.25 x 20 mm
19	960835MSS	Hex Head Cap Screw, M8-1.25 x 35 mm
20	990801MSS	Hex Nut
21	960630MSS	Hex Head Cap Screw, M6-1.00 x 30 mm
22 	520432- <u>WW</u>	Idler Tail Kit (Includes items 1, 2, 5, 6, 9, and 12)
<u>WW</u> = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 7 for conveyor belt widths.		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

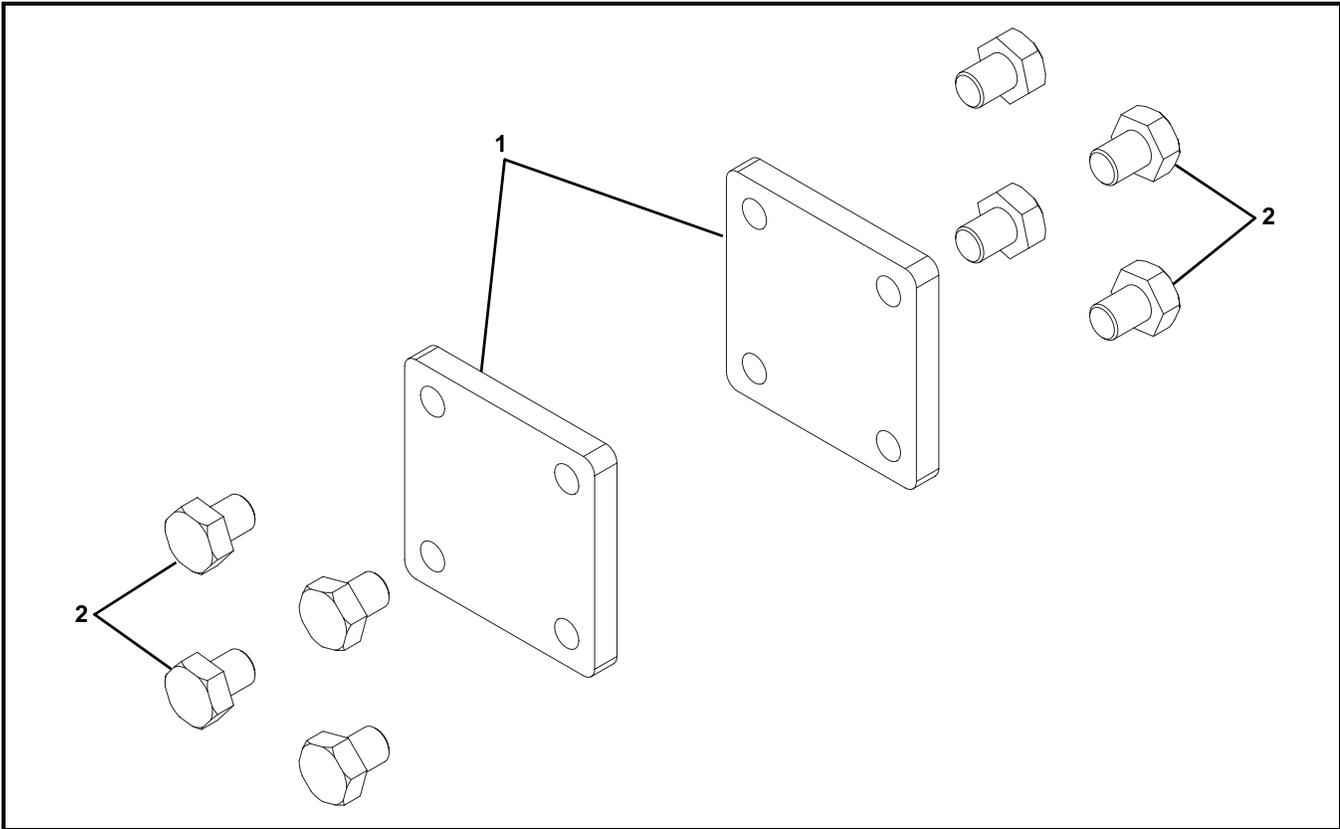
Frame



Item	Part Number	Description
1	-----	Consult Factory for Frame Part Number
2	515596	Crossmember Mount Bracket
3	515594- <u>WW</u>	Crossmember Infeed End
4	515595- <u>WW</u>	Crossmember
5	516803- <u>LLLLL</u>	Bed Rails
6	517563- <u>LLLLL</u>	Wearstrip for Single Section Frame, Left Hand
	520434- <u>LLLLL</u>	Infeed Wearstrip for Multi-Section Frame, Left Hand
	520433- <u>LLLLL</u>	Mid Wearstrip for Multi-Section Frame, Left Hand
	520435- <u>LLLLL</u>	Discharge Wearstrip for Multi-Section Frame, Left Hand
7	517563- <u>LLLLL</u>	Wearstrip for Single Section Frame, Right Hand
	520435- <u>LLLLL</u>	Infeed Wearstrip for Multi-Section Frame, Right Hand
	520433- <u>LLLLL</u>	Mid Wearstrip for Multi-Section Frame, Right Hand
	520434- <u>LLLLL</u>	Discharge Wearstrip for Multi-Section Frame, Right Hand
8	517577- <u>WW</u>	Crossmember Discharge End
9	807-3341	Self-Tapping Hex Screw, 8-18 x .375"
10	960840MSS	Hex Head Cap Screw, M8-1.25 x 40 mm
11	990801MSS	Hex Nut
<u>WW</u> = Conveyor width reference in inches 06 - 36 in 02 increments		
See Specifications chart on page 7 for conveyor belt widths.		
<u>LLLLL</u> = Part length in inches with 2 decimal places.		
Example: Part Length = 95.25" <u>LLLLL</u> = 09525		
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		

Service Parts

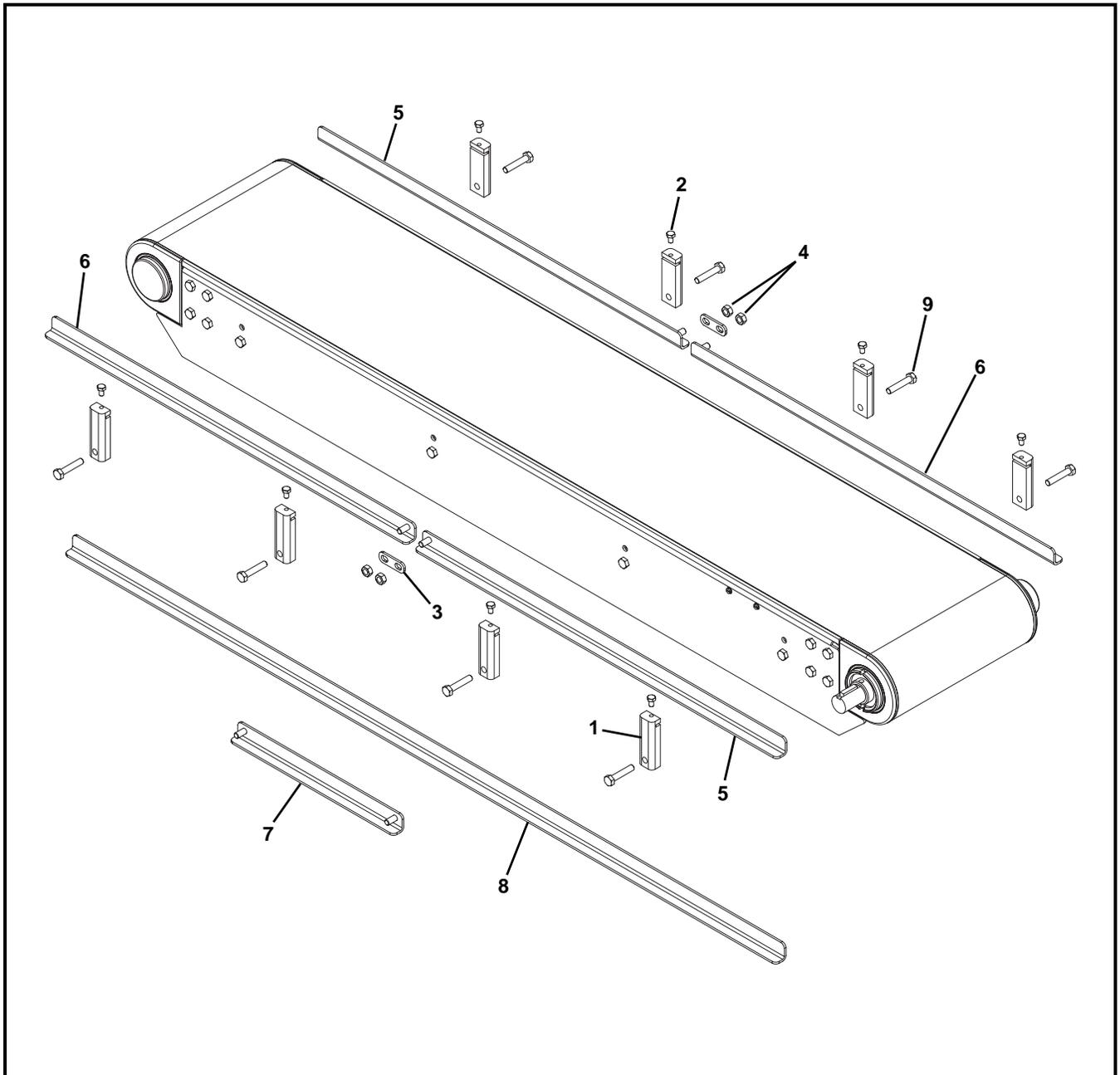
Connecting Assembly



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

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

25 mm High Sides

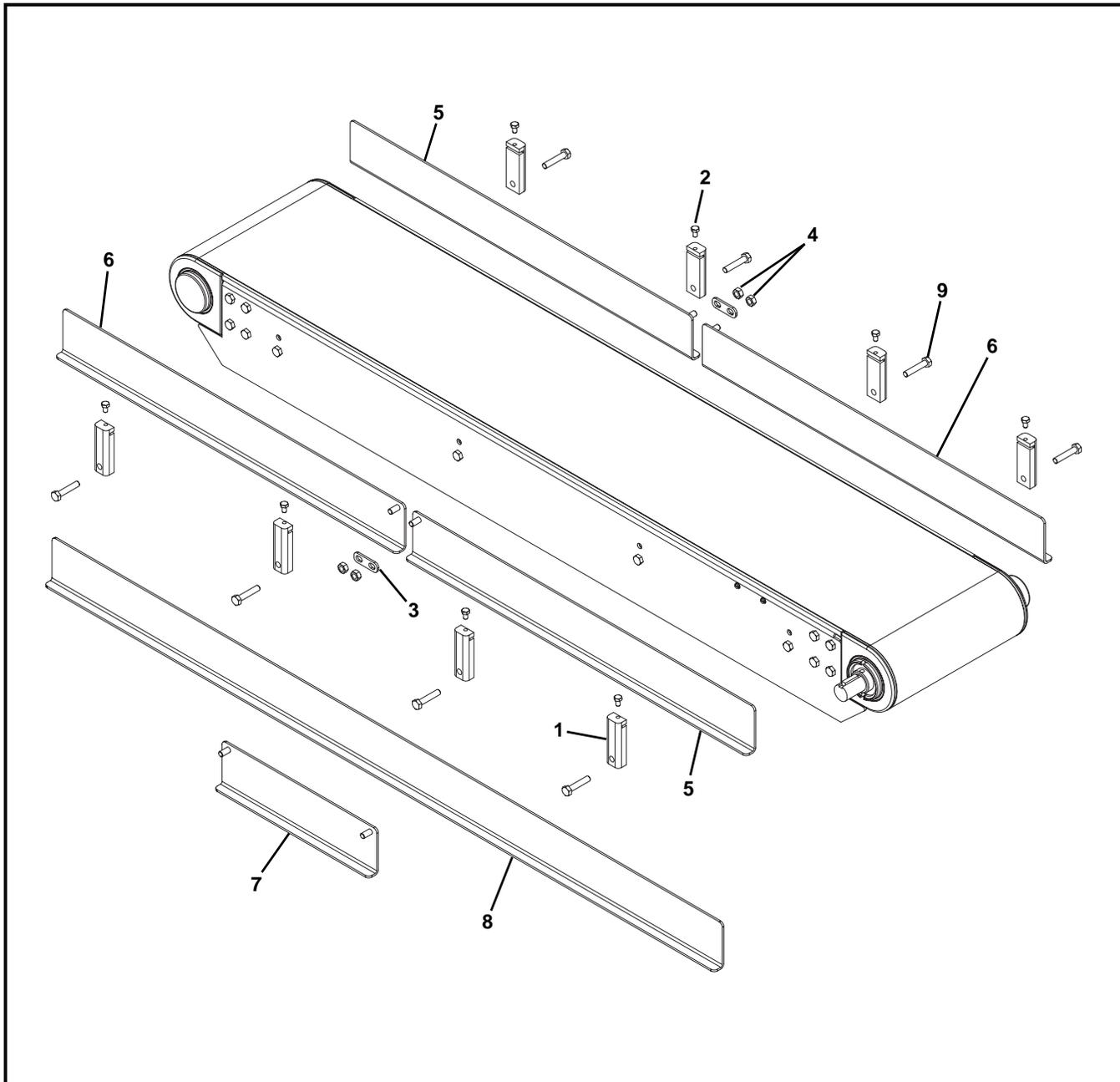


Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-01- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-01- <u>LLLLL</u>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

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

Service Parts

75 mm High Sides



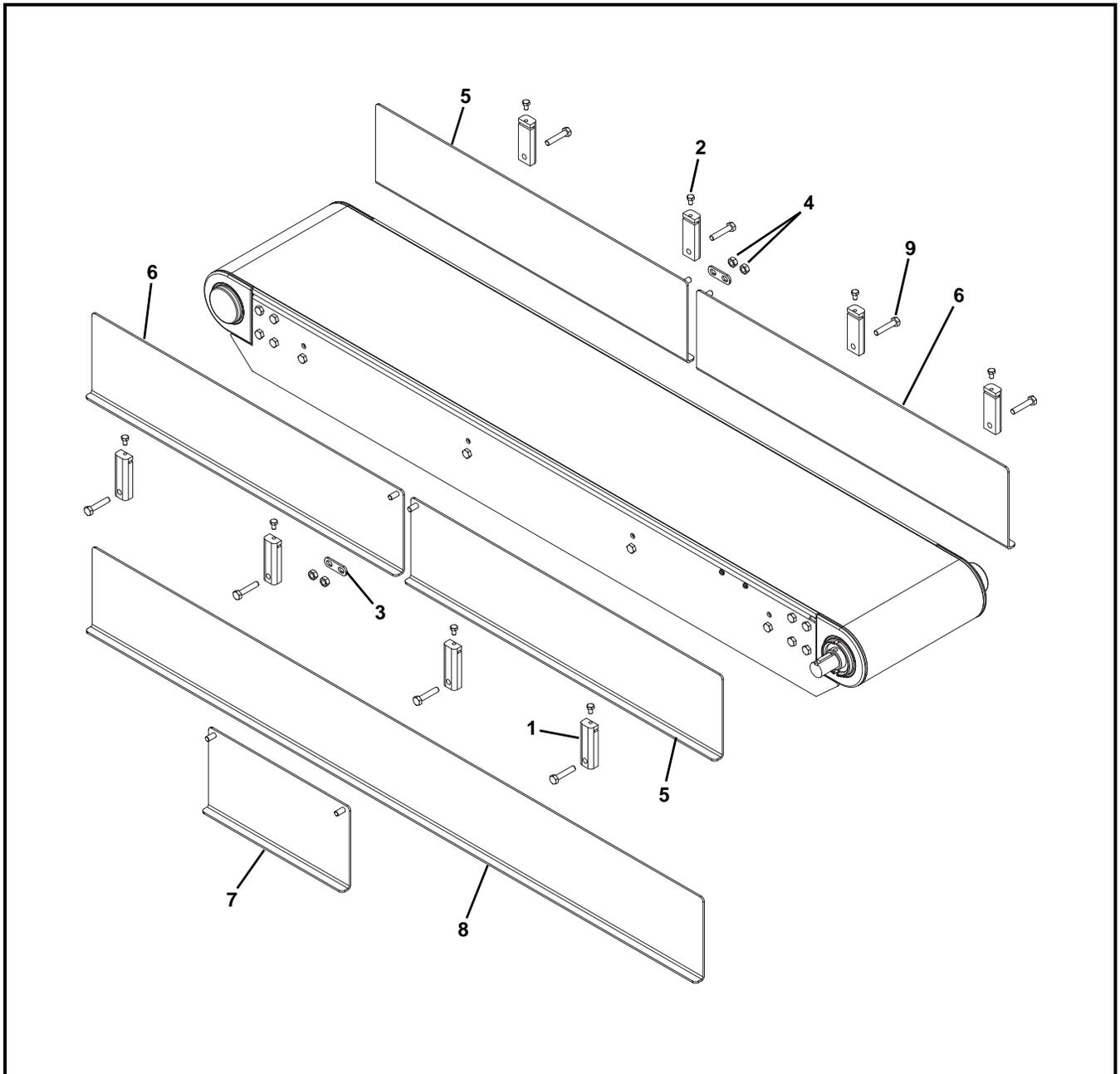
Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-03- <u>LLLLL</u> -LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-03- <u>LLLLL</u>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

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

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

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

152 mm High Sides

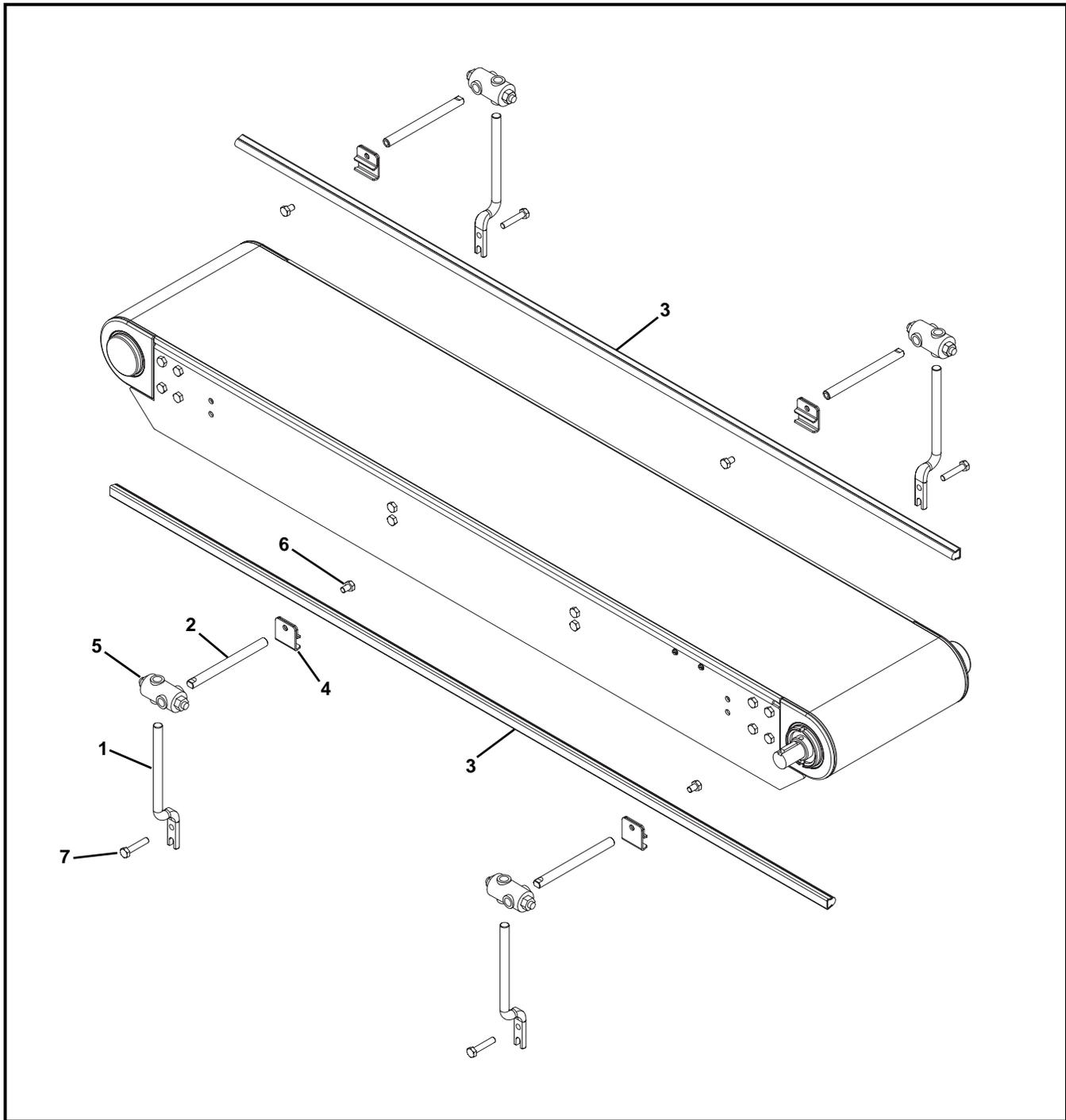


Item	Part Number	Description
1	516999-03	Mounting Block
2	960610MSS	Hex Head Cap Screw, M6-1.00 x 10 mm
3	516935	Guide Connecting Plate (for Multiple Guide Sections Only)
4	990801MSS	Hex Nut
5	518400-06-LLLLL-LH	Guiding, Left Hand (for Multiple Guide Sections Only)
6	518400-06-LLLLL-RH	Guiding, Right 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
<p>LLLLL = Part length in inches with 2 decimal places. Example: Part Length = 95.25" LLLLL = 09525</p>		
<p>Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com</p>		

Service Parts

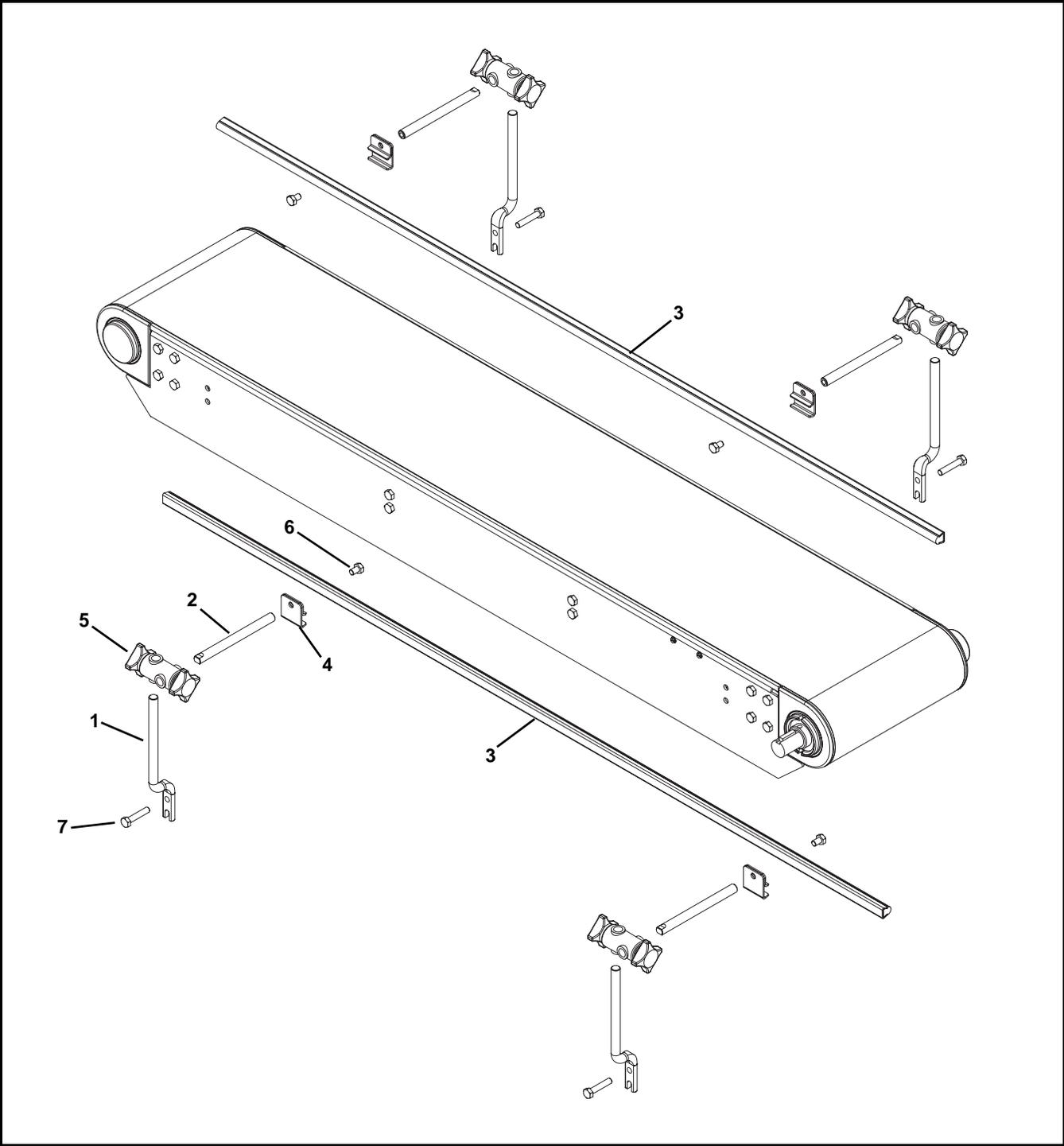
Fully Adjustable Round Guides



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

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

Tool-Less Fully Adjustable Round Guides

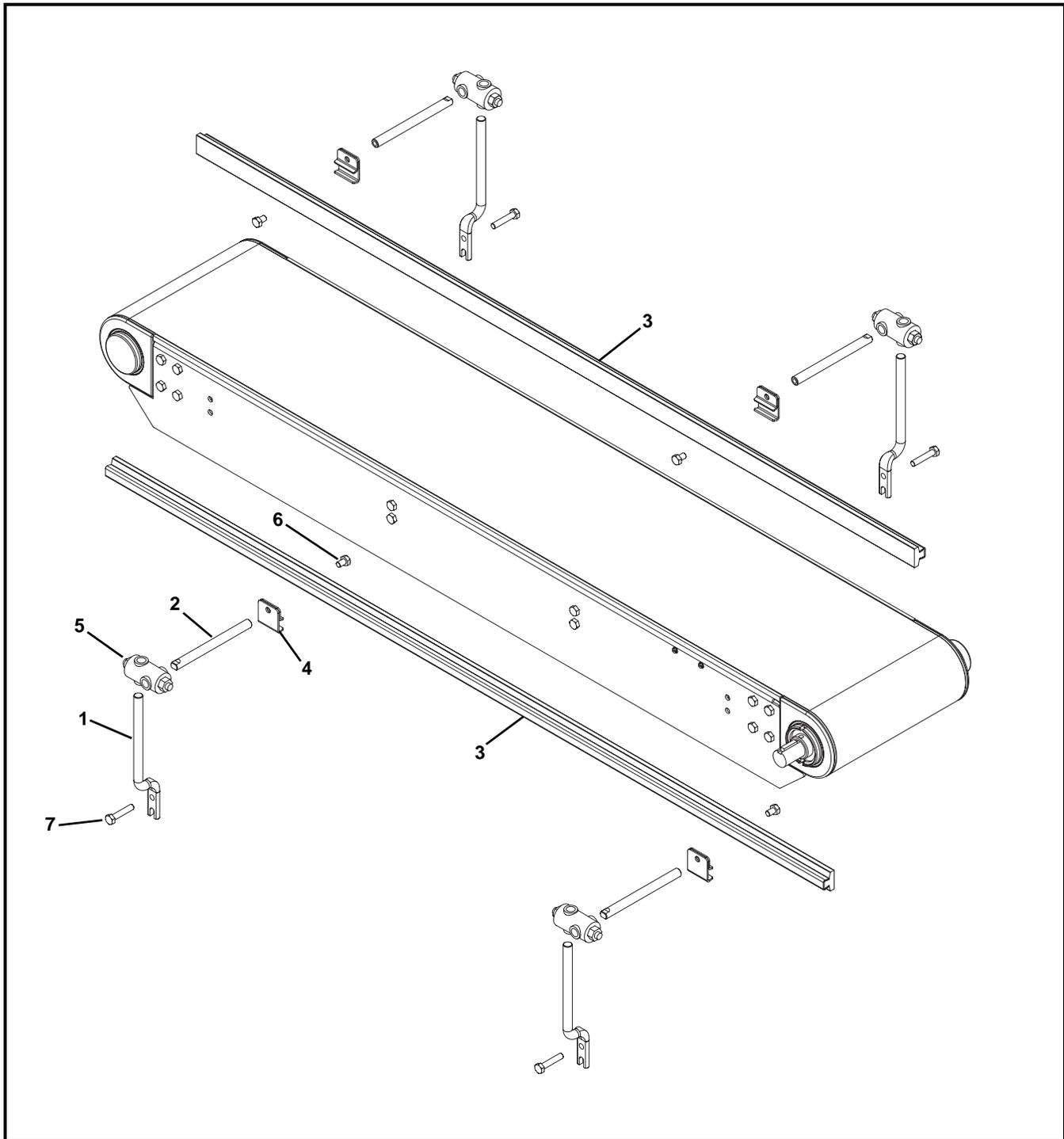


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	532167-LLLLL	Round Guide Rail
4	807-015	Rail Clamp
5	807-1470	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

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

Service Parts

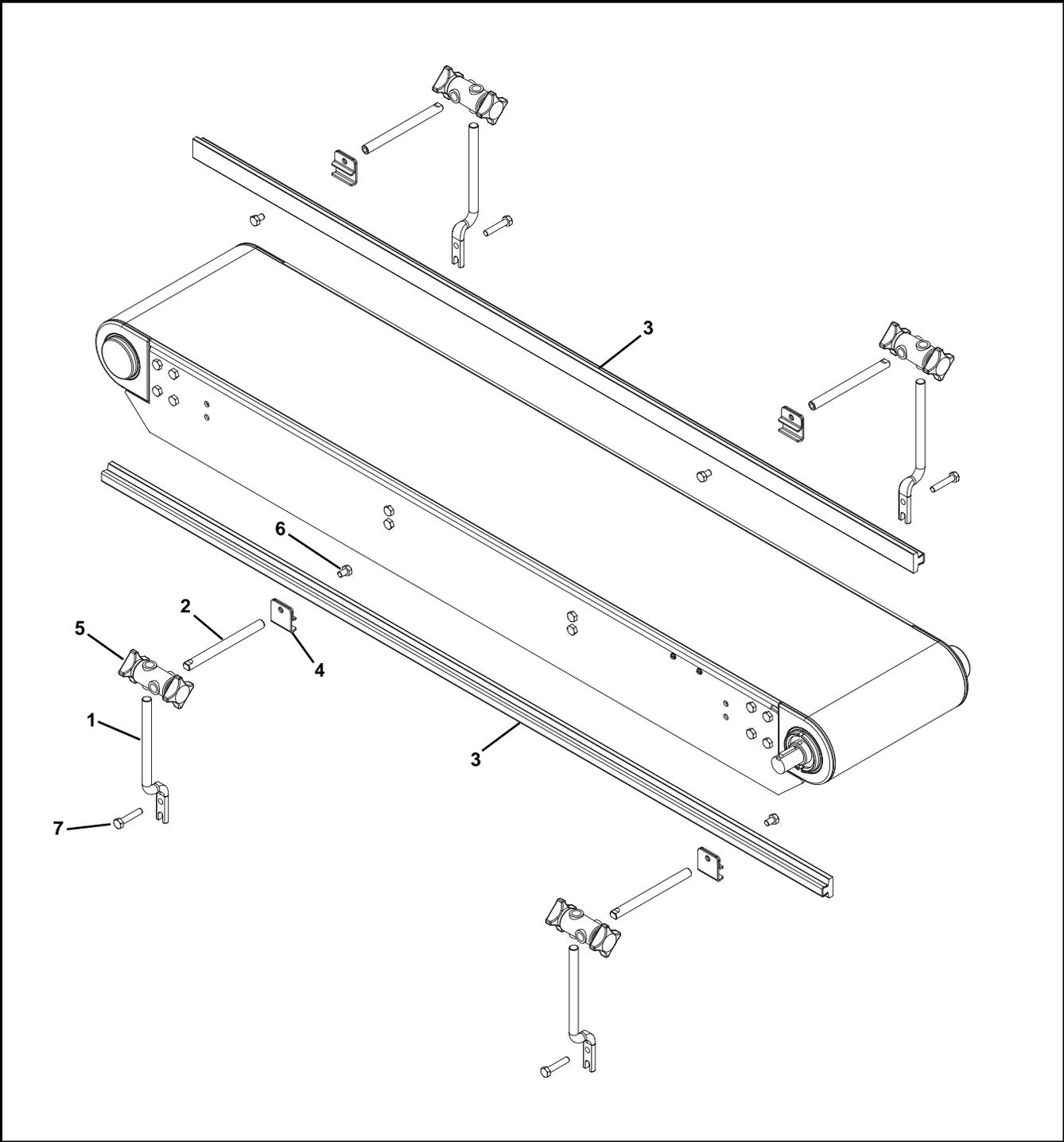
Fully Adjustable Flat Guides



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

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

Tool-Less Fully Adjustable Flat Guides

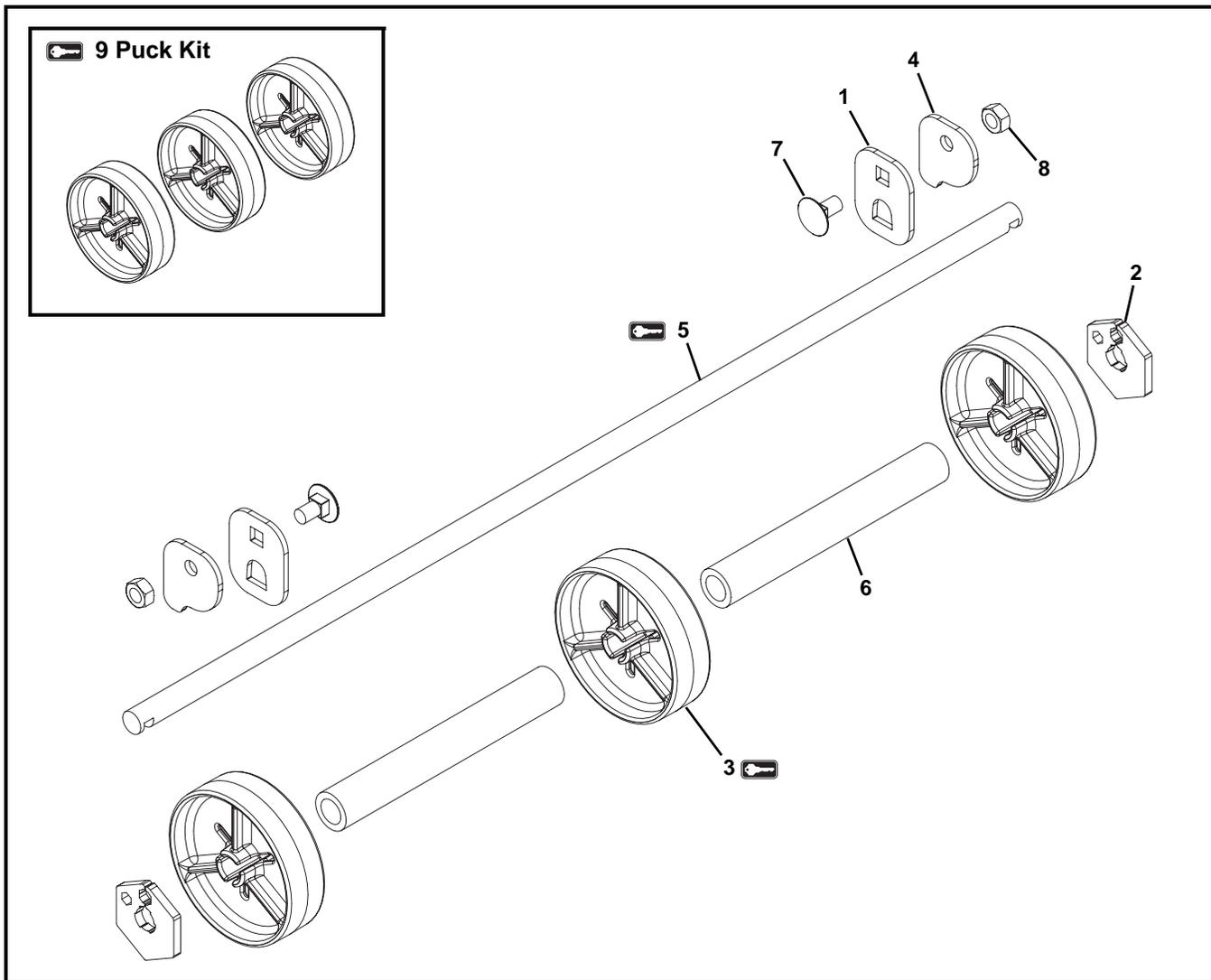


Item	Part Number	Description
1	516996	Offset Guide Post
2	532300	Post Guide
3	517599-LLLLL	Flat Guide Rail
4	807-015	Rail Clamp
5	807-1470	Cross Block Clamp
6	960812MSS	Hex Head Cap Screw, M8-1.25 x 12 mm

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

Service Parts

Belt Returns 660 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- <u>LLLLL</u>	Shaft
6	518393-00600	Spacer
7	807-3543	Carriage Bolt, M8 x 16 mm
8	990801MSS	Hex Nut
9	520368- <u>WW</u>	Puck Kit (Includes item 3)

WW = Conveyor width reference in inches 06 - 36 in 02 increments

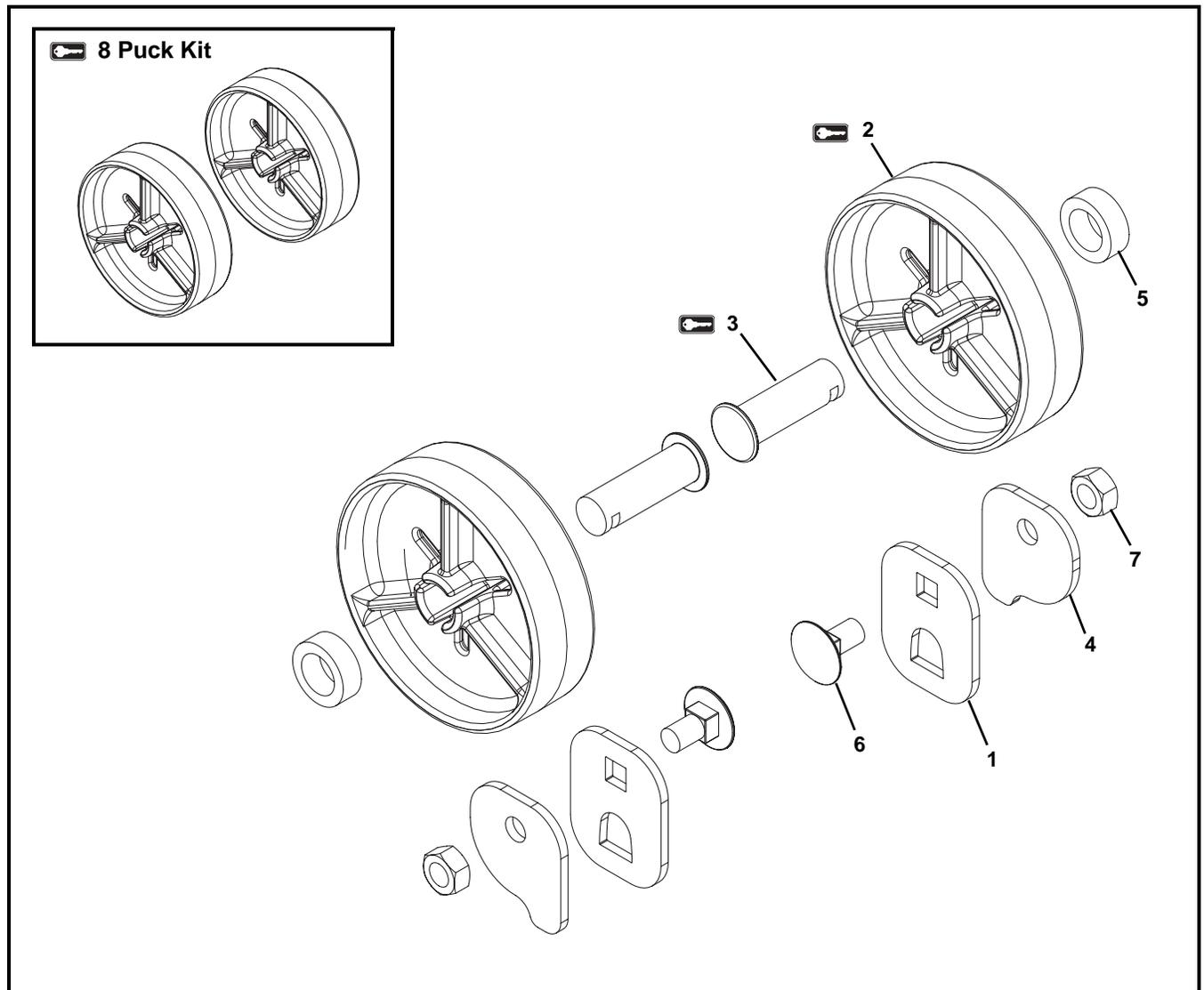
See Specifications chart on page 7 for conveyor belt widths.

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

Belt Returns Under 660 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

Service Parts

Configuring Conveyor Belt Part Number

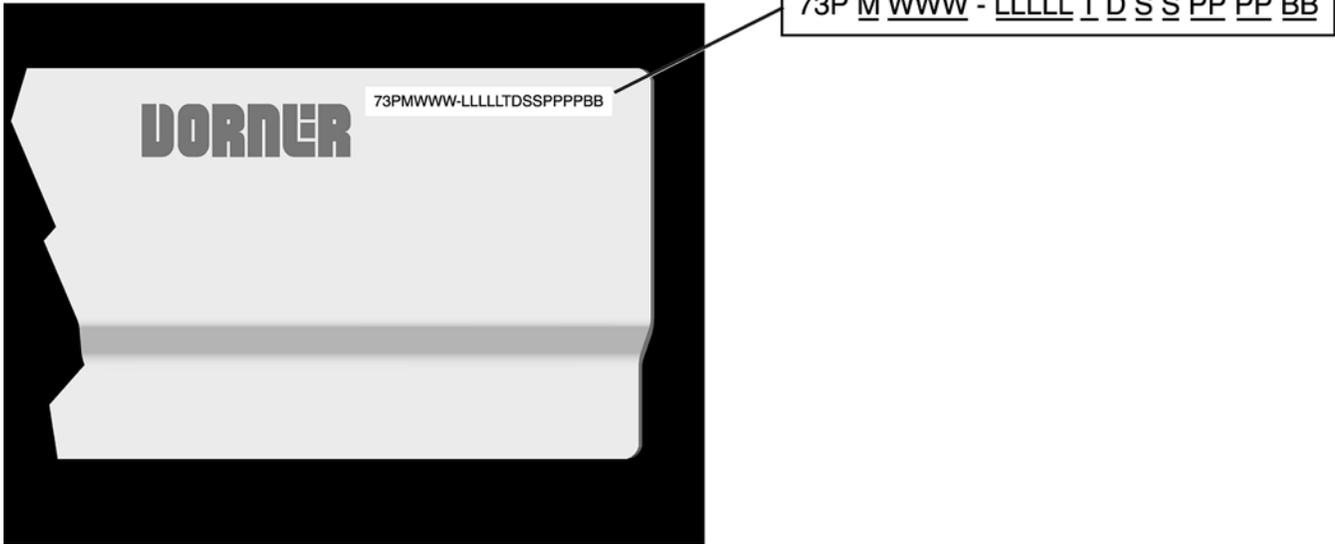


Figure 67

Flat Belt Part Number Configuration

Refer to model number on the conveyor frame (**Figure 67**). 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.

73P1-WWW-LLLLL / BB

73P1- _____ - _____ / _____
(Fill In)

Return Policy

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

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

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

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

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

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

For a copy of Dorner's Warranty, contact Dorner, an authorized sales channel or visit our website: www.dorner.com.

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

www.dorner.com



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