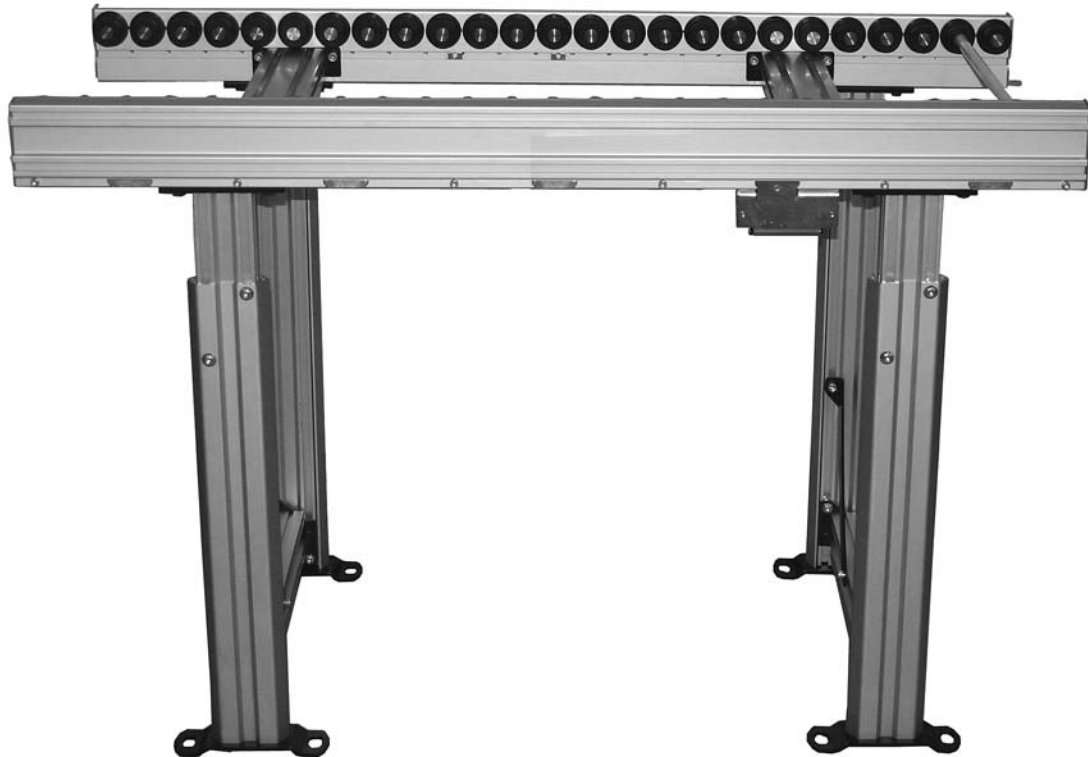




ERT™ 250 Conveyor

Installation, Maintenance & Parts Manual



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

Record Conveyor Serial Number Here

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IMPORTANT

<i>Some illustrations may show guards removed. DO NOT operate equipment without guards.</i>

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.

Dorner's Limited Warranty applies.

Dorner has convenient, pre-configured kits of Key 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. Key Parts and Kits are marked in the Service Parts section of this manual with the Performance Parts Kits logo .

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

Warnings – General Safety

⚠ WARNING

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

⚠ DANGER



Climbing, sitting, walking or riding on conveyor will cause severe injury. **KEEP OFF CONVEYORS.**

⚠ DANGER



DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.

⚠ WARNING



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

⚠ WARNING



Gearmotors may be **HOT**. **DO NOT TOUCH** Gearmotors.

⚠ WARNING



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.

⚠ WARNING



Loosening stand height or angle adjustment screws may cause conveyor sections to drop down, causing severe injury.

SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.

Product Description

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

1	Conveyor
2	Gearmotor
3	Support Stand

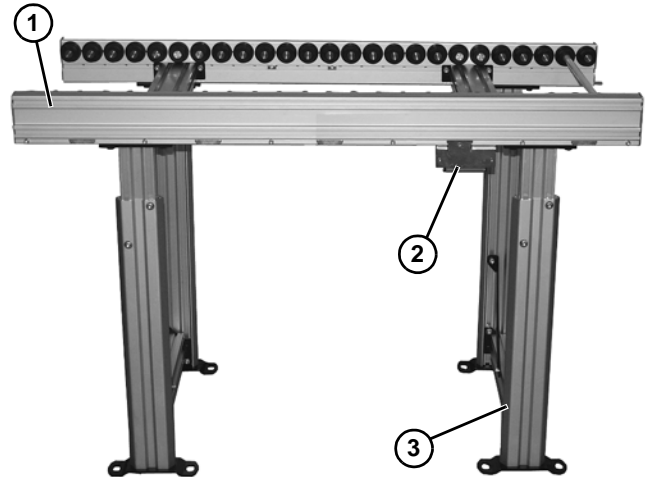
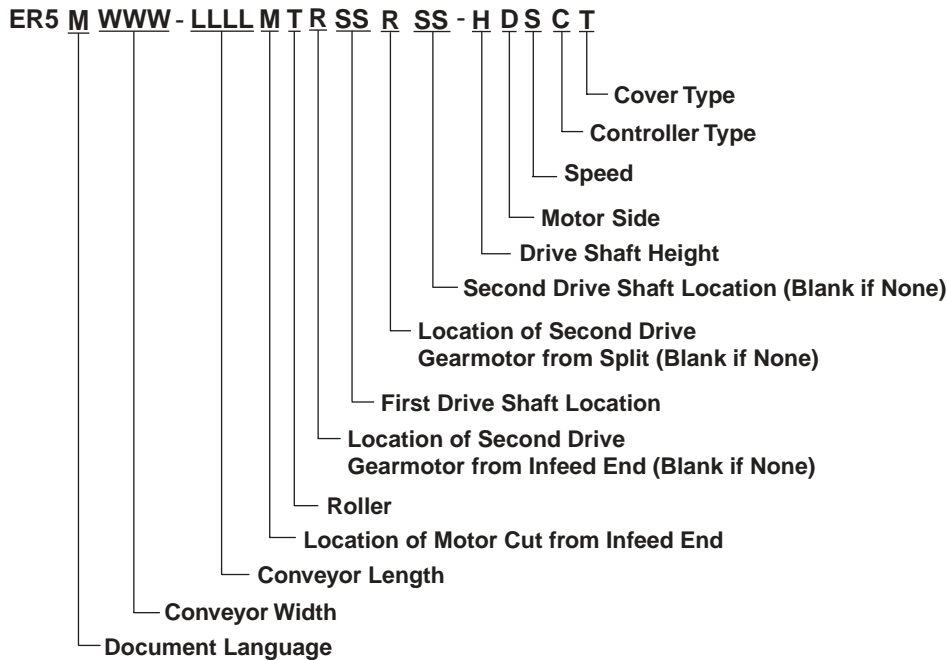


Figure 1

Specifications

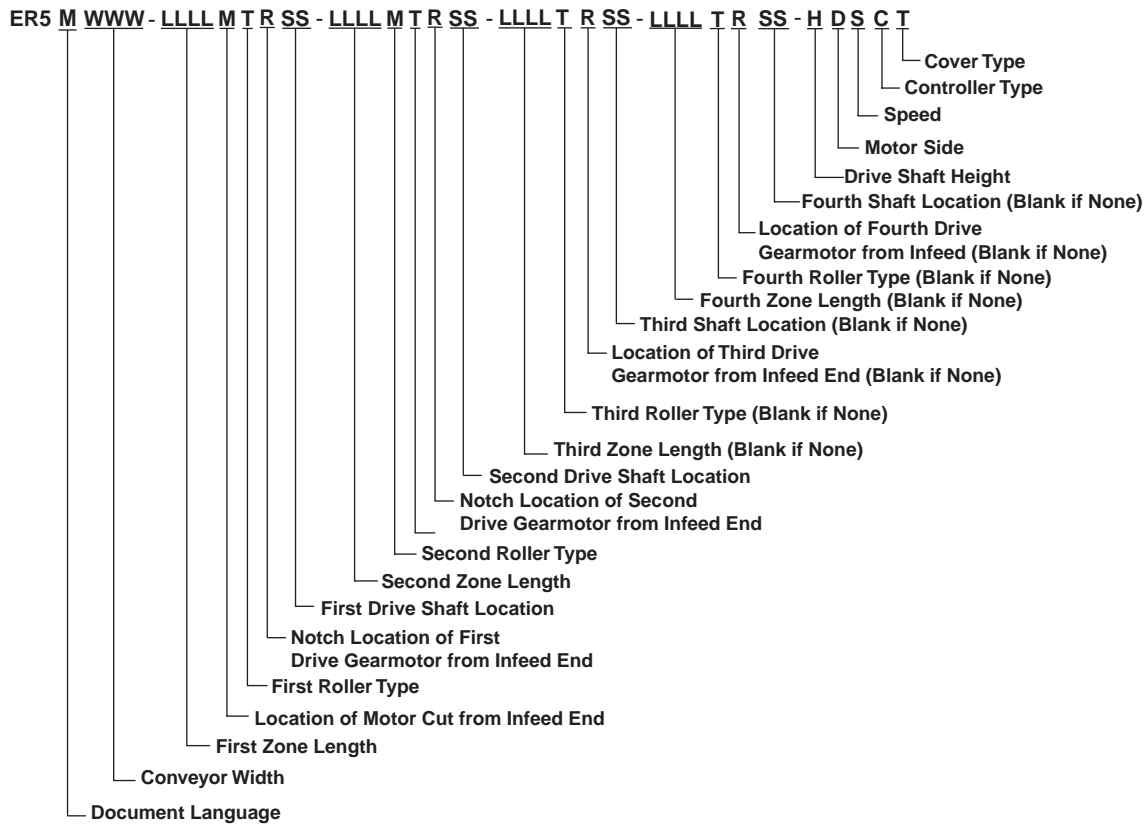
Models:

Single Zone Conveyor

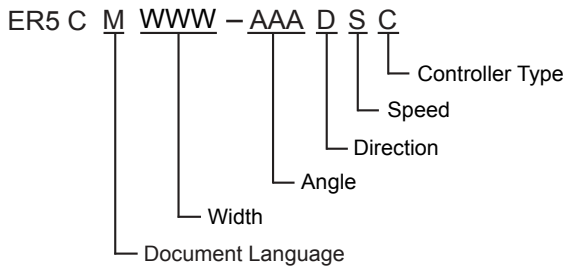


Specifications

Multiple Zone Conveyor



Corner Conveyor



Specifications

Conveyor Supports:

Maximum Distances:

1 = 457 mm (18")

2 = 2400 mm (95")

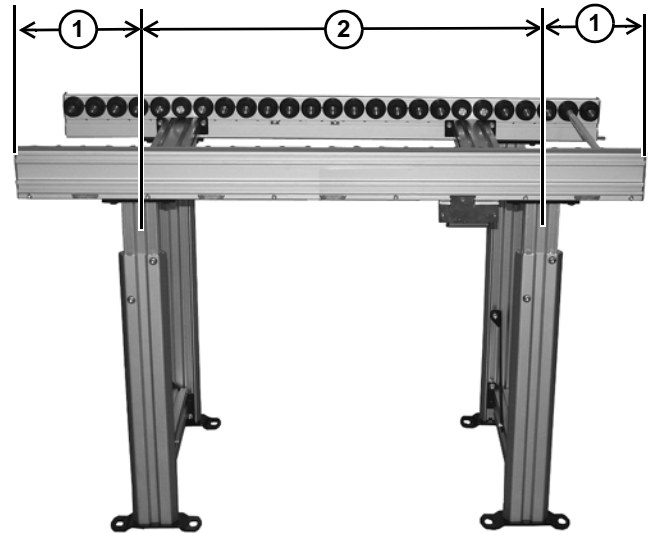


Figure 2

Specifications

Conveyor Width Reference (WWW)	120	160	200	240	280	320	360	400
Conveyor Width	120 mm (4.72")	160 mm (6.30")	200 mm (7.87")	240 mm (9.45")	280 mm (11.02")	320 mm (12.60")	360 mm (14.17")	400 mm (15.75")
Maximum Load	115 Kg (250 lbs) per pallet, 7 Kg (15 lbs) per roller in contact with pallet							
Maximum Speed	37 M/min (121 ft/min)							
Conveyor Length Reference	0250 - 3500 in 0050 increments							
Conveyor Length	250 mm - 3500 mm (9.84" - 137.80")							

Conveyor Width Reference (WWW)	440	480	520	560	600	640	680	720
Conveyor Width	440 mm (17.32")	480 mm (18.90")	520 mm (20.47")	560 mm (22.05")	600 mm (23.62")	640 mm (25.20")	680 mm (26.77")	720 mm (28.35")
Maximum Load	115 Kg (250 lbs) per pallet, 7 Kg (15 lbs) per roller in contact with pallet							
Maximum Speed	37 M/min (121 ft/min)							
Conveyor Length Reference	0250 - 3500 in 0050 increments							
Conveyor Length	250 mm - 3500 mm (9.84" - 137.80")							

Conveyor Width Reference (WWW)	760	800	840	880	920	960
Conveyor Width	760 mm (29.92")	800 mm (31.50")	840 mm (33.07")	880 mm (35.65")	920 mm (36.22")	960 mm (37.80")
Maximum Load	115 Kg (250 lbs) per pallet, 7 Kg (15 lbs) per roller in contact with pallet					
Maximum Speed	37 M/min (121 ft/min)					
Conveyor Length Reference	0250 - 3500 in 0050 increments					
Conveyor Length	250 mm - 3500 mm (9.84" - 137.80")					

Specifications

Table 1: Gearmotor Specifications

Item	Standard Load Gearmotors
Output Power	50 watt
Input Voltage	24 VDC
Input Currents	2.5 amp Running 3.0 amp Starting
Gearmotor Ratio	See Below
Protection Rating	IP 54 ingress rating

Table 2: Pallet Speed for Standard Load Fixed Speed Gearmotors

Part Number	RPM (Nominal)	N-m	In-Lb	Pallet Speed	
				M/min	Ft/min
826-984	10	4.4	39.1	1 - 10	3.4 - 34
826-985	15	3.0	26.2	1.5 - 15	5.0 - 50
826-986	20	2.2	19.2	2.1 - 21	6.9 - 69
826-987	25	1.8	15.7	2.6 - 26	8.4 - 84
826-988	37	1.2	10.6	3.8 - 38	12.4 - 124
826-989	46	1	8.7	4.6 - 46	15.1 - 151
826-990	62	0.72	6.4	6.3 - 63	20.7 - 207
826-991	73	0.59	5.2	7.7 - 77	25.2 - 252

Installation and Adjustment

NOTE

Conveyor **MUST** be mounted straight, flat and level within confines of conveyor. Use a level for setup.

Required Tools

- 4 mm Hex Wrench
- 5 mm Hex Wrench
- 6 mm Hex Wrench
- 13 mm Wrench

Recommended Installation Sequence

- Attach conveyor to stands

Attach Conveyor to Stands

NOTE

For detailed assembly instruction, please see your appropriate support stand manual.

1. Thread screw (**Figure 3, item 1**) into slide-in nut (**Figure 3, item 2**). Repeat for a second screw and nut.

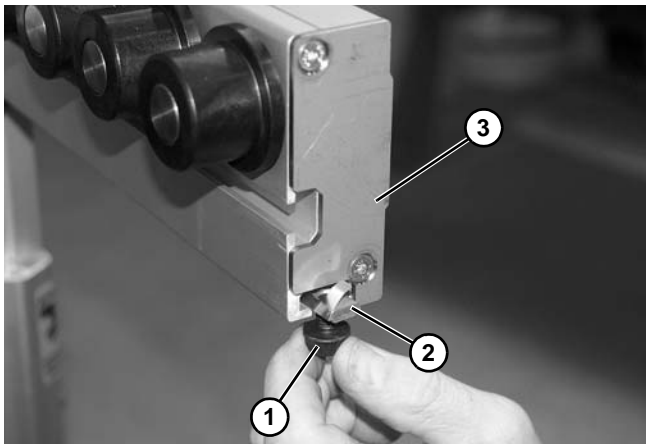


Figure 3

2. Insert screw and nut assemblies through end cap (**Figure 3, item 3**) and into conveyor channel. Slide one down the channel, keeping the second close to the end of the conveyor.

3. Raise stand leg (**Figure 4, item 1**) to bottom of conveyor. Make sure top plate mounting screws (**Figure 4, item 2**) align into channel.

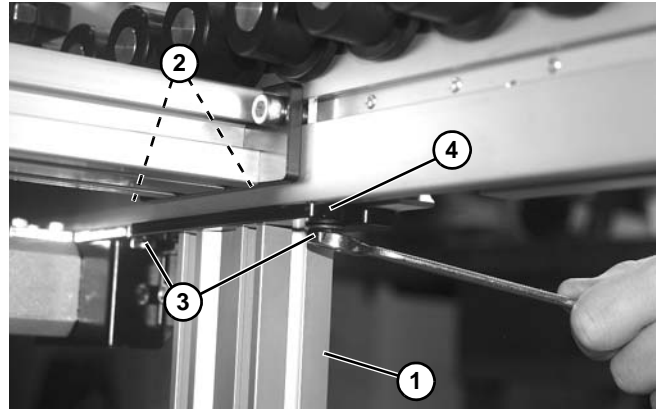


Figure 4

4. Slide mounting hardware (**Figure 4, item 3**) into slot (**Figure 4, item 4**) on both sides of top plate and tighten.
5. Repeat for other leg of stand.

Corner Conveyors

1. For installing conveyor (**Figure 5, item 1**) to corner conveyor (**Figure 5, item 2**), install studs and/or spring nuts into conveyor channels. Align conveyor and tie bracket (**Figure 5, item 3**) with corner conveyor.

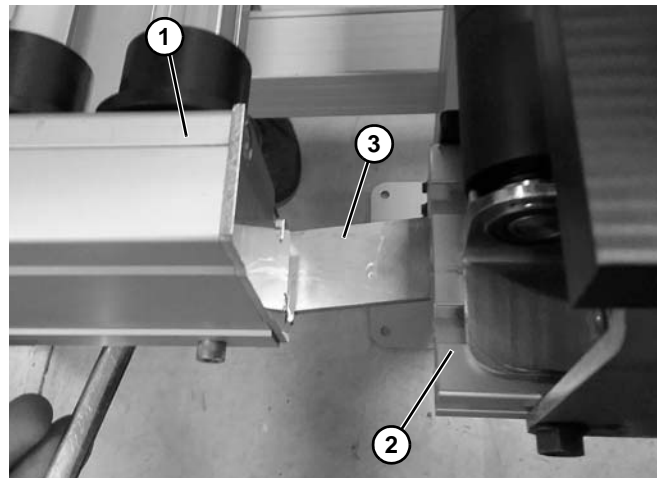


Figure 5

Installation and Adjustment

2. Install tie bracket (**Figure 6, item 1**) with four bolts (**Figure 6, item 2**).

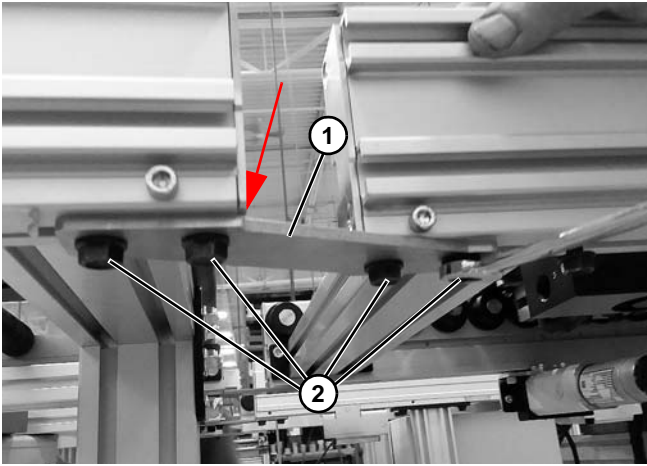


Figure 6

NOTE

Verify straight of bracket is aligned with end of conveyor. See red arrow (**Figure 6**).

Motor Relocation

1. Remove screws (**Figure 7, item 1**) holding side cover (**Figure 7, item 2**) onto conveyor frame.

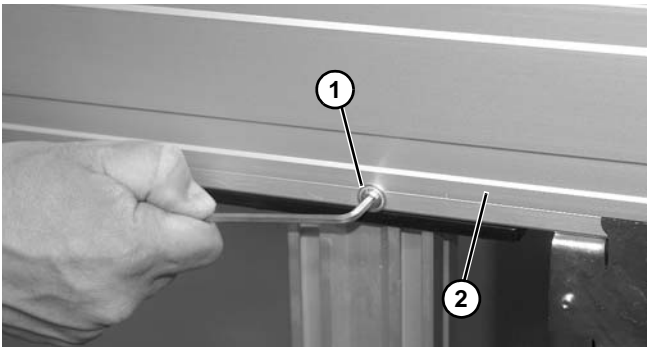


Figure 7

2. Rotate and remove side cover (**Figure 8, item 1**) from conveyor frame

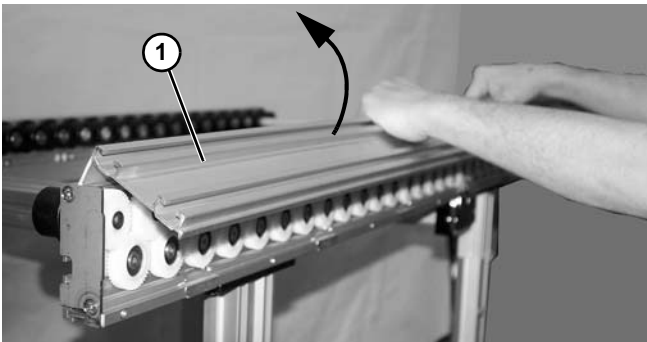


Figure 8

3. Remove screws (**Figure 9, item 1**) connecting the motor to the spring nuts (**Figure 9, item 2**) in the conveyor frame.

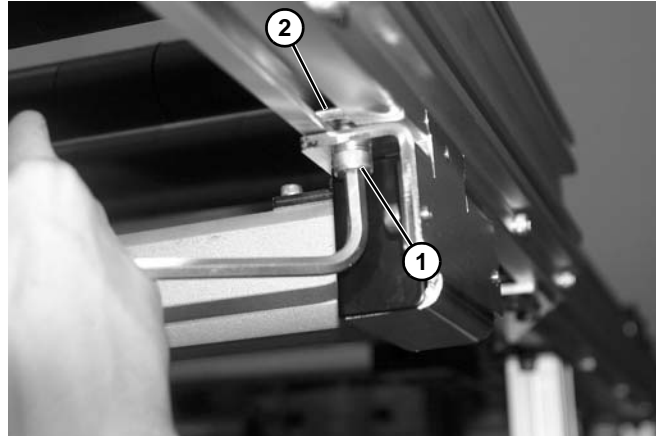


Figure 9

4. Lower and remove motor (**Figure 10, item 1**) from conveyor frame.

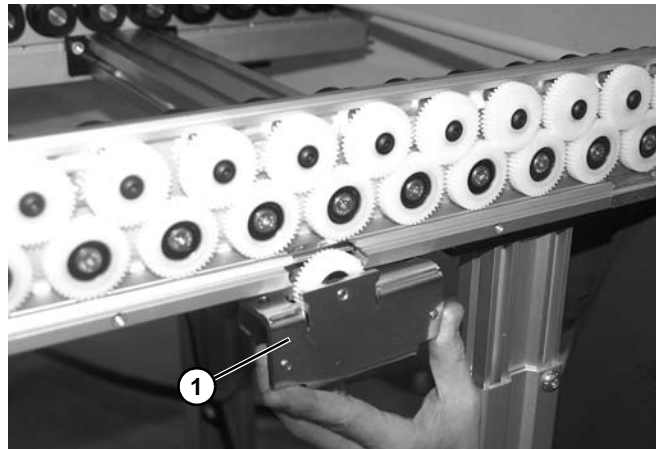


Figure 10

5. Remove plug (**Figure 11, item 1**) on conveyor frame at the new location for motor. Place plug into previous motor location.

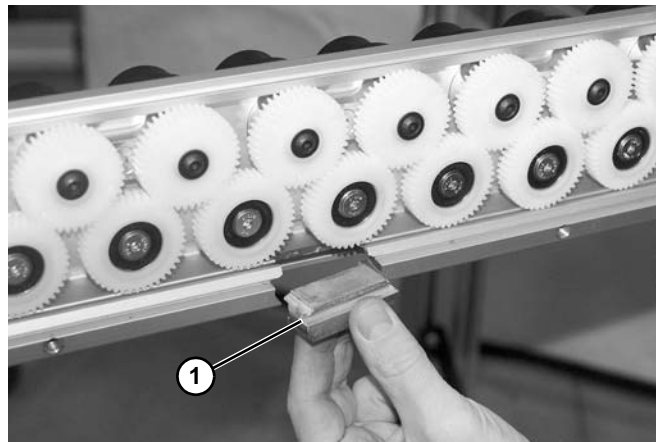


Figure 11

Installation and Adjustment

6. Install two sprint nuts (**Figure 12, item 1**) into bottom slotted area (**Figure 12, item 2**) of the conveyor frame.

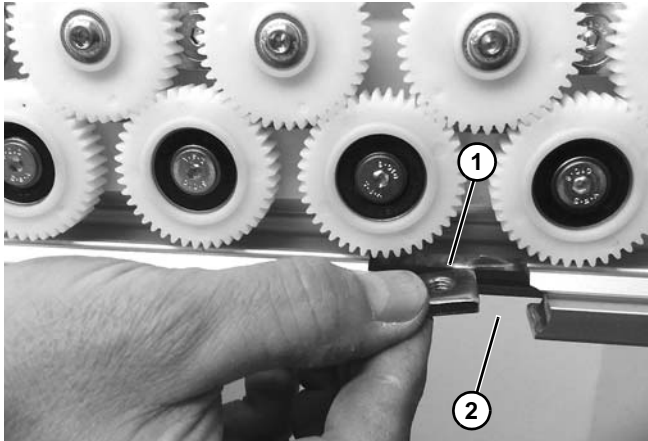


Figure 12

7. Raise the motor (**Figure 13, item 1**), into position, and attach the motor to the conveyor frame with two low head cap screws (**Figure 14, item 1**) onto the spring nuts (**Figure 14, item 2**). Tighten screws.

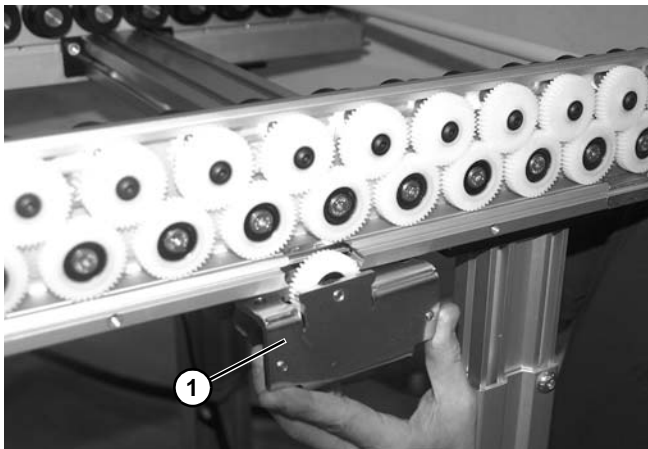


Figure 13

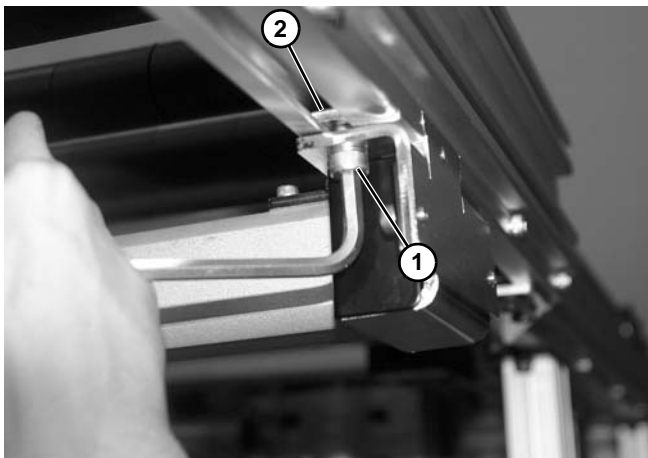


Figure 14

Drive Shaft Relocation

1. Remove screws (**Figure 15, item 1**) holding side cover (**Figure 15, item 2**) onto conveyor frame.

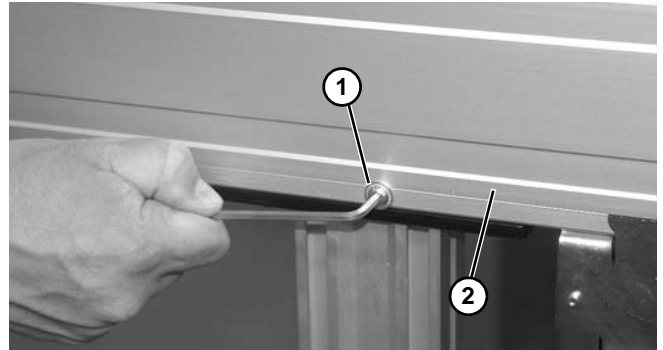


Figure 15

2. Rotate and remove side cover (**Figure 16, item 1**) from conveyor frame

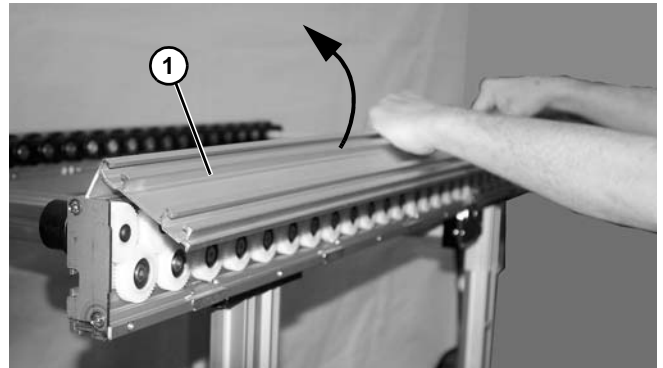


Figure 16

3. Remove slip bearing rollers above the fixed bearing roller you are replacing. (See “Driven or Slip Roller” on page 16.)
4. Install sprocket removal tool, part number 400289 (**Figure 17, item 1**) between gears.

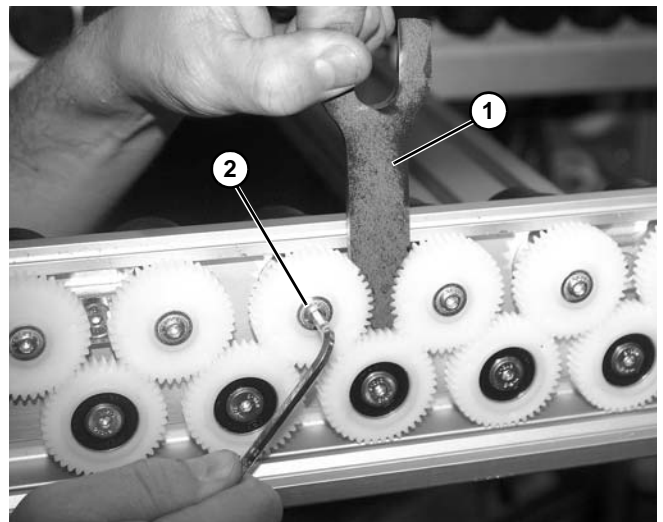


Figure 17

Installation and Adjustment

5. Remove screw (Figure 17, item 2) holding gear onto roller shaft.
6. Install opposite end of sprocket removal tool, part number 400289 (Figure 18, item 1) to pry gear (Figure 18, item 2) from roller shaft.

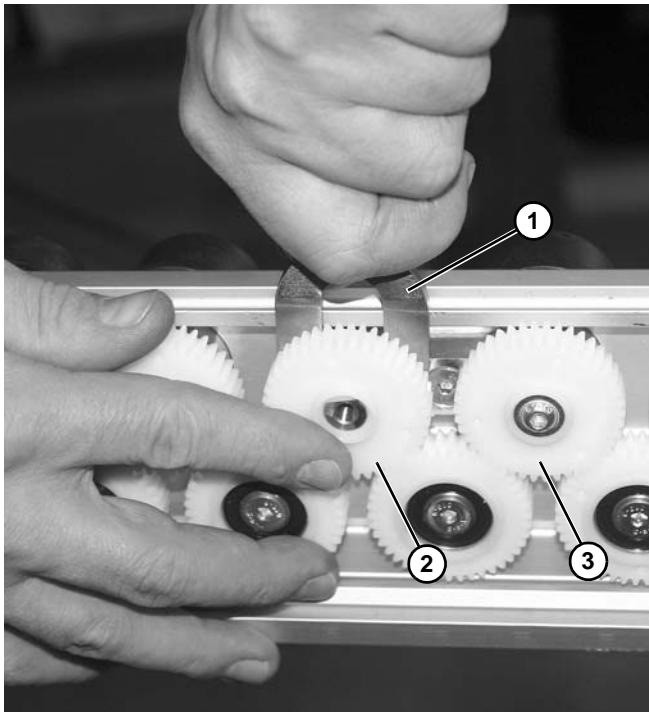


Figure 18

7. Repeat for second gear (Figure 18, item 3).
8. Remove screw (Figure 19, item 1) from center of bearing assembly (Figure 19, item 2).

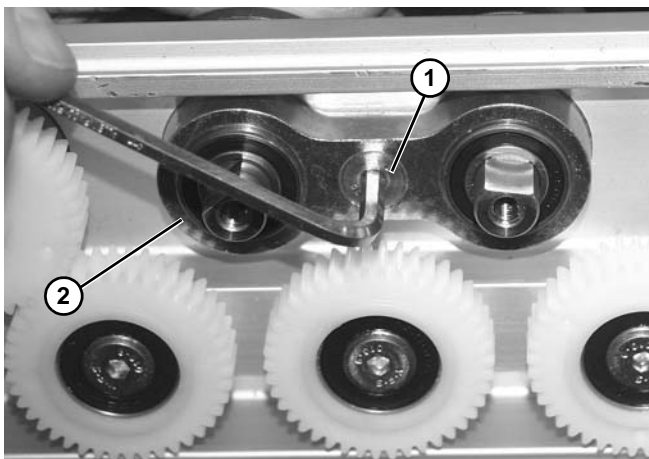


Figure 19

NOTE

There are two different style rollers available: Driven rollers (Figure 20, item 1) and slip rollers (Figure 20, item 2). For slip rollers, skip to step 10.

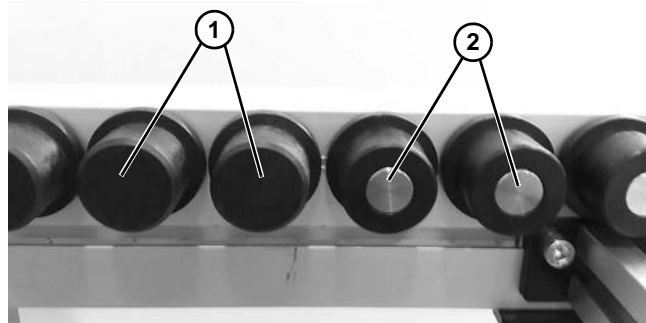


Figure 20

9. Using a hammer and pin punch, drive out pin (Figure 22, item 1) holding roller onto shaft.

NOTE

Be certain to drive pin out through slotted hole (Figure 21, item 1). DO NOT drive pin out on side of roller where pin (Figure 21, item 2) is sticking out.

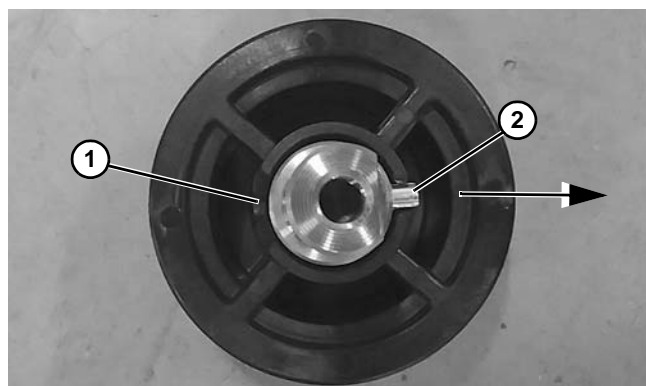


Figure 21

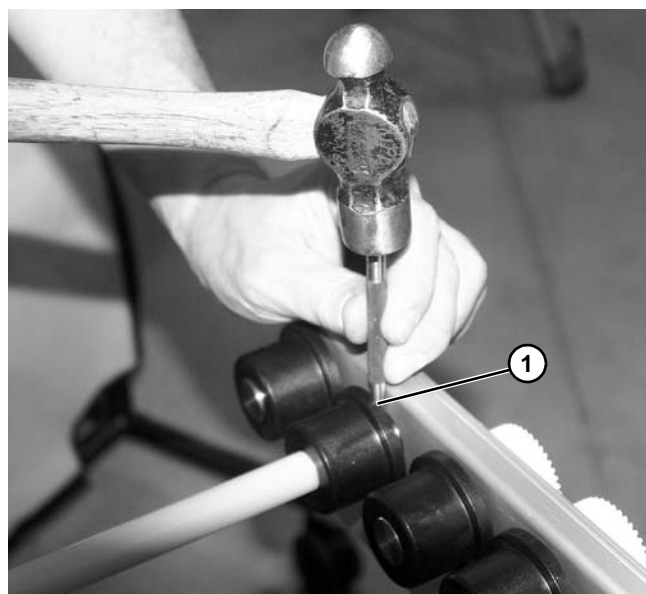


Figure 22

Installation and Adjustment

10. Use a small screwdriver to release bearing assembly (**Figure 23, item 1**) from the conveyor frame.

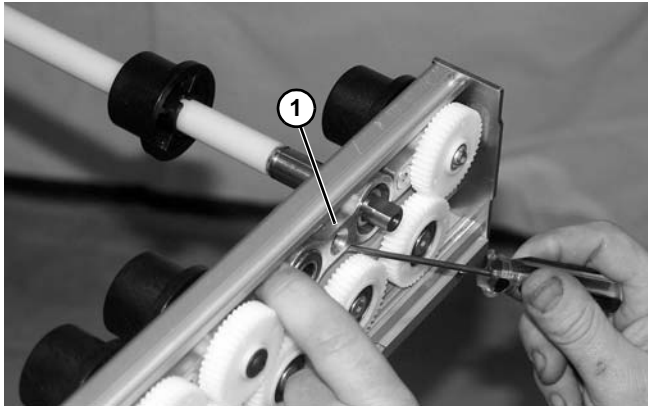


Figure 23

11. Remove the bearing assembly (**Figure 24, item 1**) along with washer (**Figure 24, item 2**) and shaft assembly (**Figure 24, item 3**) from the conveyor frame.

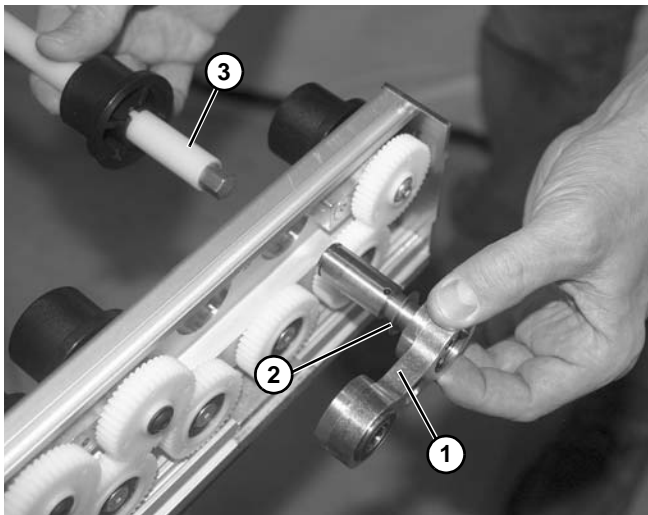


Figure 24

12. Repeat steps 3-7 to remove both gears and bearing assembly for the new location.

13. Use a no-mar hammer to tap slightly on roller shaft to release the roller (**Figure 25, item 1**) from the assembly.



Figure 25

14. Remove roller assembly (**Figure 26, item 1**) and washer (**Figure 26, item 2**) from the conveyor frame.

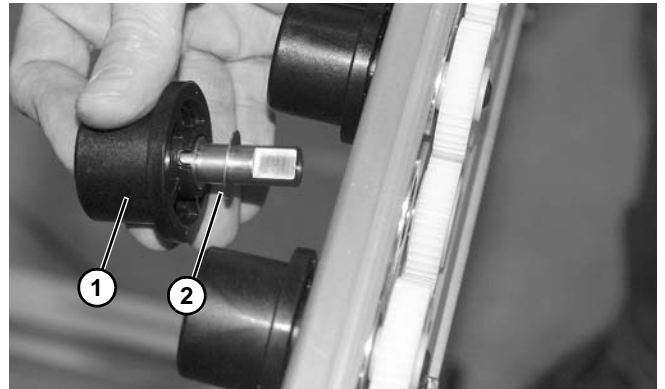



Figure 26

15. Reassemble drive shaft roller in new location and remaining gears and bearing assembly from the original location in reverse order of removal.

Installation and Adjustment

Adjust Stands

⚠ WARNING

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

1. Support the conveyor.
2. Loosen two screws (**Figure 27, item 1**) on each side of conveyor.

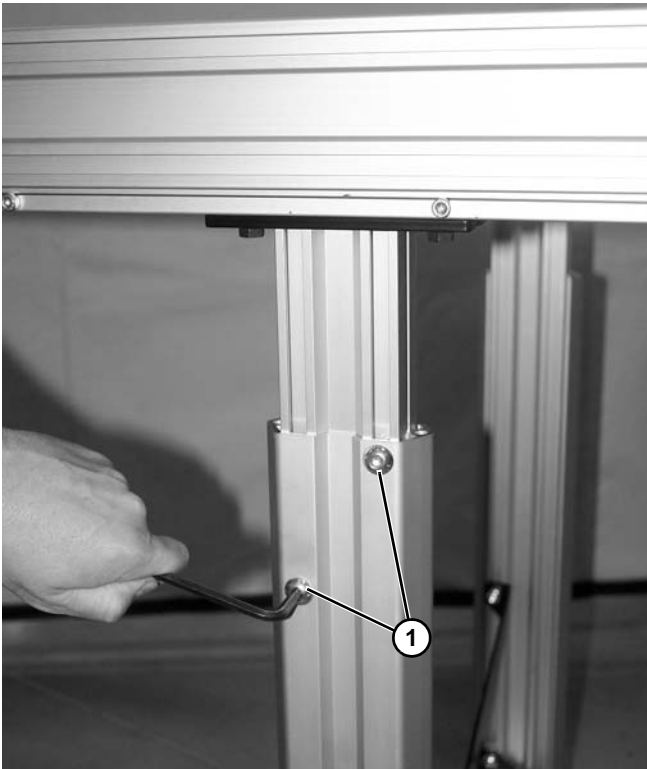



Figure 27

3. Raise or lower stand leg.

⚠ WARNING

<p>Failure to secure screws may cause conveyor sections to drop down causing severe injury.</p> <p>TIGHTEN SCREWS AFTER ADJUSTMENT.</p>

4. Making sure conveyor is level (**Figure 28**), tighten all four screws.



Figure 28

Preventive Maintenance and Replacement

Required Tools

- 4 mm Hex Wrench
- 5 mm Hex Wrench
- 6 mm Hex Wrench
- 10 mm Hex Wrench
- 13 mm Wrench
- No-Mar Hammer
- Sprocket Removal Tool (Dorner Part number 400289)

Checklist

- Keep service parts on hand (see “Service Parts” section for recommendations)
- Clean entire conveyor while disassembled
- Replace worn or damaged parts

Lubrication

No lubrication is required. Replace roller assemblies if worn.

Side Cover Removal and Installation

1. Remove screws (**Figure 29, item 1**) holding side cover (**Figure 29, item 2**) onto conveyor frame.

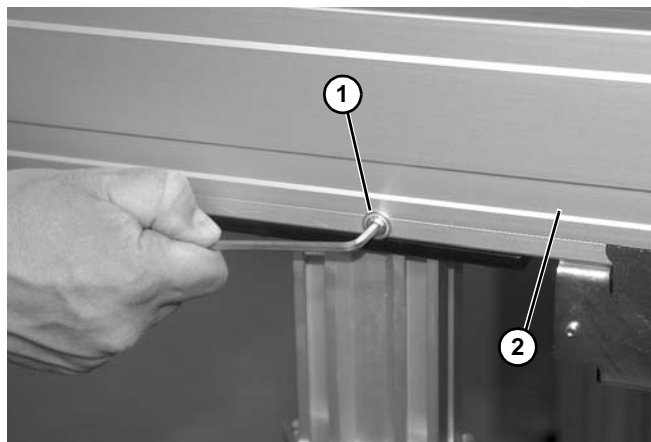


Figure 29

2. Rotate and remove side cover (**Figure 30, item 1**) from conveyor frame

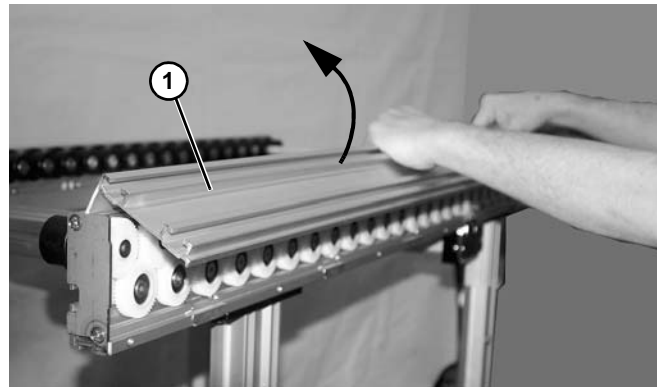


Figure 30

3. To install side cover (**Figure 31, item 1**), place flange of side cover into channel (**Figure 31, item 2**) of conveyor frame. Lower cover.

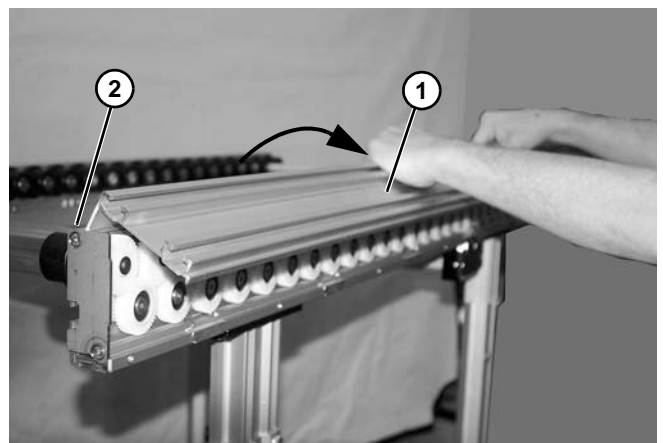


Figure 31

4. Secure cover with screws (**Figure 32, item 1**).

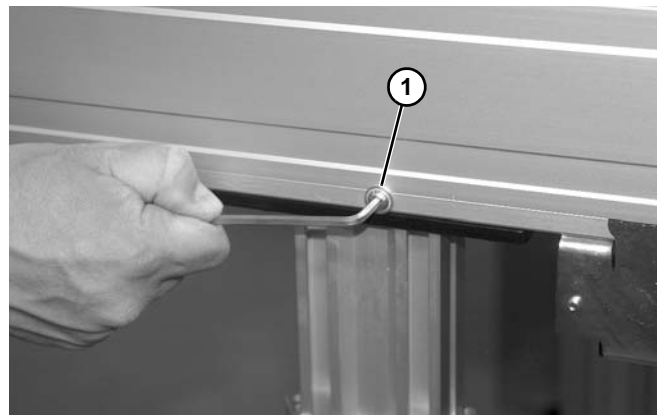


Figure 32

Preventive Maintenance and Replacement

5. Tighten screws securing cover, making sure the cover is fully seated onto channel of conveyor frame. (See for examples of correct (**Figure 33**) and incorrect (**Figure 34**) installation.)

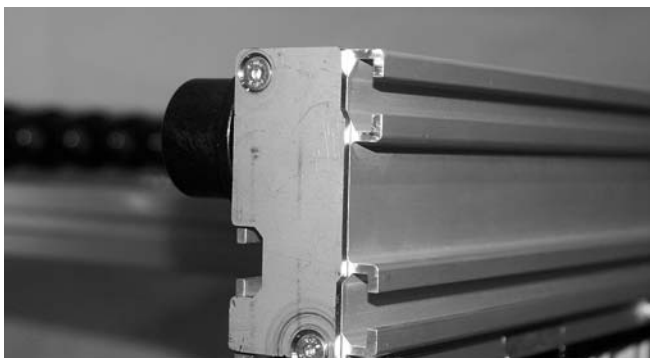


Figure 33

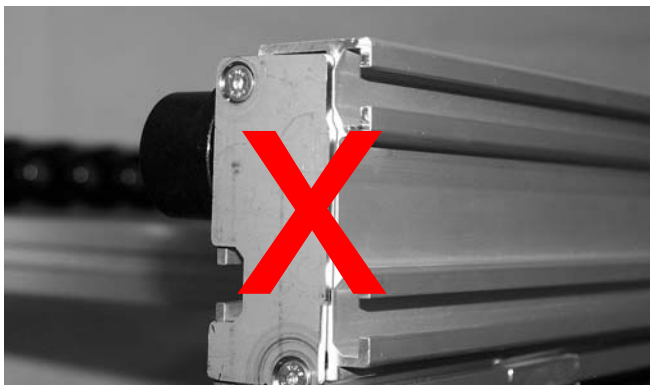


Figure 34

Roller Replacement

Driven or Slip Roller

1. Remove side cover from conveyor. (See “Side Cover Removal and Installation” on page 15.)
2. Install sprocket removal tool, part number 400289 (**Figure 35, item 1**) between gears.

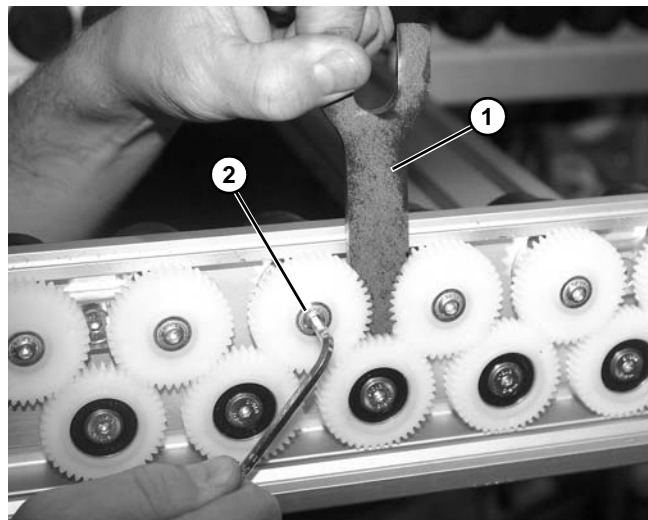


Figure 35

3. Remove screw (**Figure 35, item 2**) holding gear onto roller shaft.
4. Install opposite end of sprocket removal tool, part number 400289 (**Figure 36, item 1**) to pry gear (**Figure 36, item 2**) from roller shaft.

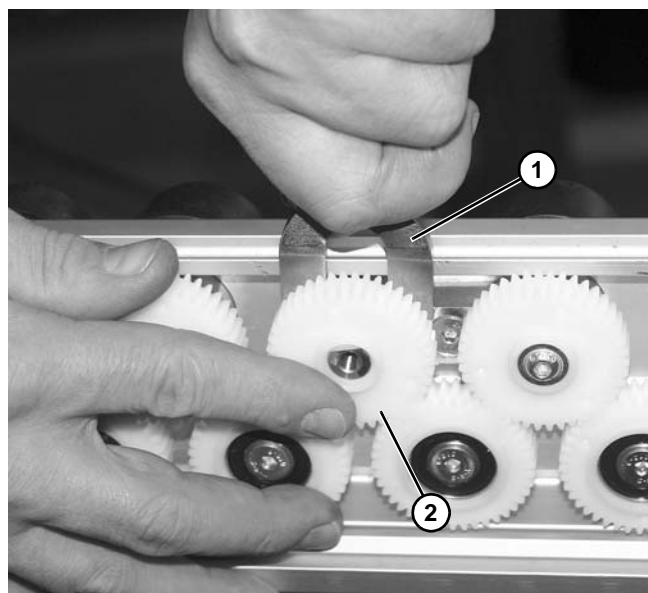


Figure 36

Preventive Maintenance and Replacement

5. Remove the gear (**Figure 37, item 1**) from the roller shaft (**Figure 37, item 2**). Make note of the raised flange (**Figure 37, item 3**) on the gear. This raised flange should be installed toward the outside.

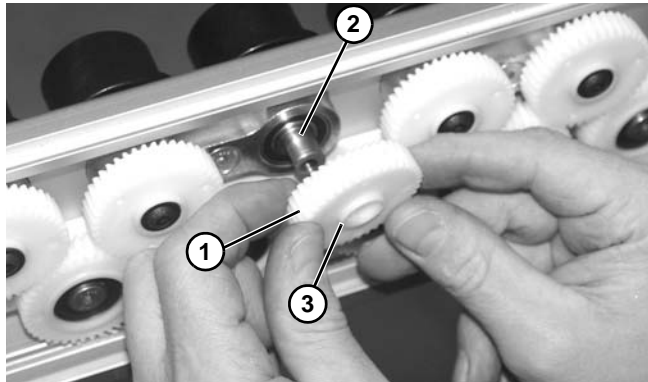


Figure 37

6. Use a no-mar hammer to tap slightly on roller shaft to release the roller (**Figure 38, item 1**) from the assembly.



Figure 38

7. Remove roller assembly (**Figure 39, item 1**) and washer (**Figure 39, item 2**) from the conveyor frame.

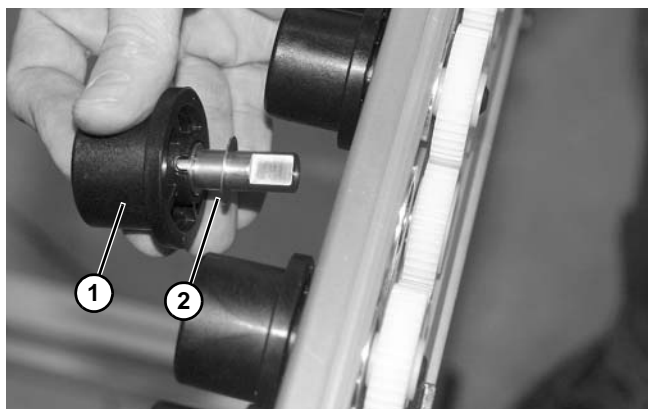


Figure 39

NOTE

*There are two different style rollers available: Driven rollers (**Figure 40, item 1**) and slip rollers (**Figure 40, item 2**).*

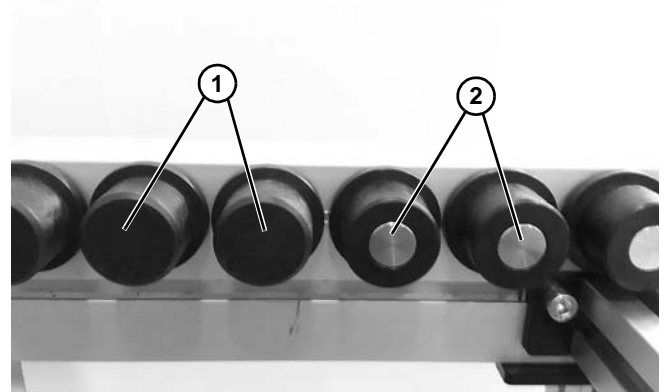


Figure 40

8. Install new roller assembly in reverse order of removal.

Drive Shaft Roller (Upper Location)

1. Remove side cover from conveyor. (See "Side Cover Removal and Installation" on page 15.)
2. Remove slip bearing rollers above the fixed bearing roller you are replacing. (See "Driven or Slip Roller" on page 16.)
3. Install sprocket removal tool, part number 400289 (**Figure 41, item 1**) between gears.

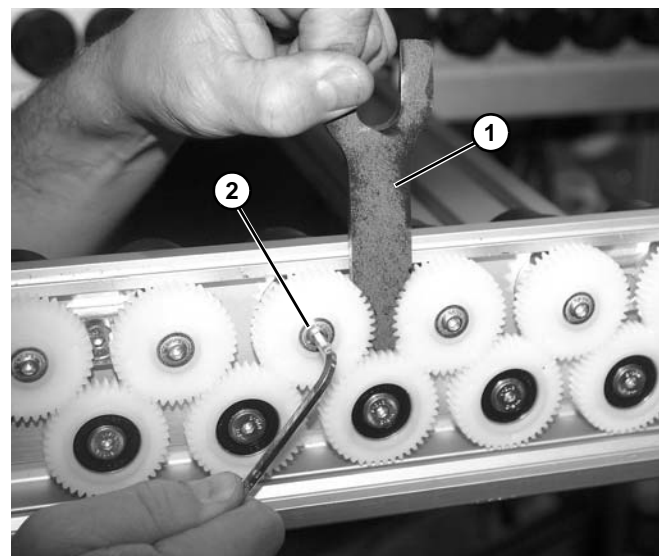


Figure 41

4. Remove screw (**Figure 41, item 2**) holding gear onto roller shaft.

Preventive Maintenance and Replacement

5. Install opposite end of sprocket removal tool, part number 400289 (**Figure 42, item 1**) to pry gear (**Figure 42, item 2**) from roller shaft.

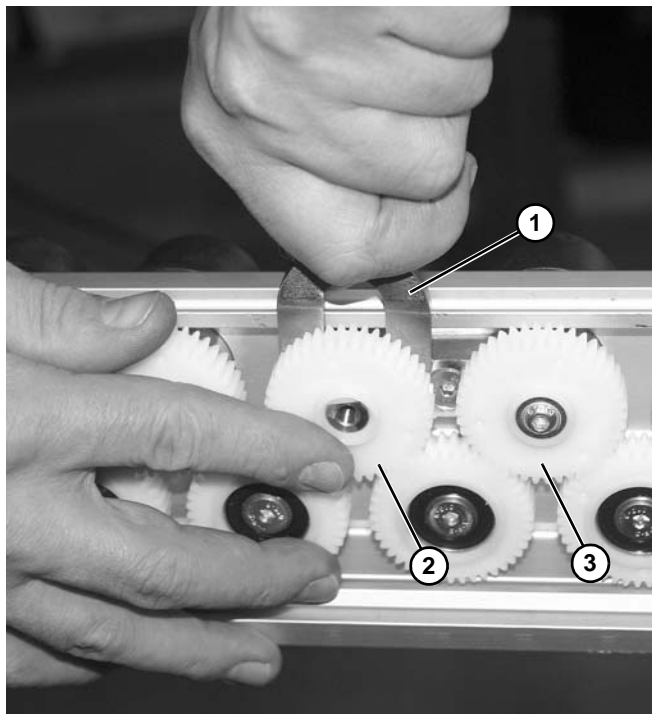


Figure 42

6. Repeat for second gear (**Figure 42, item 3**).
7. Remove screw (**Figure 43, item 1**) from center of bearing assembly (**Figure 43, item 2**).

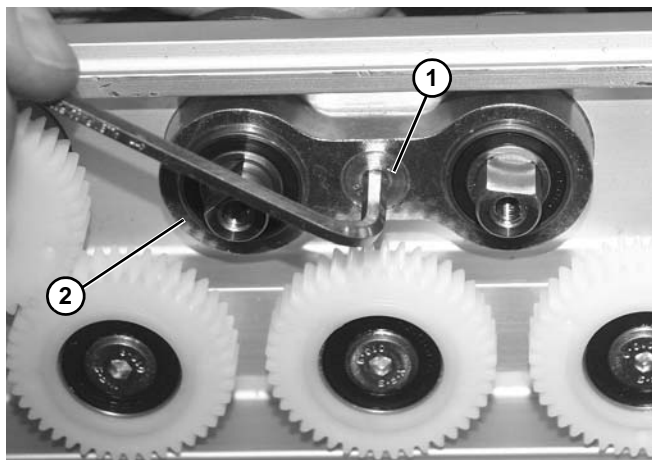


Figure 43

8. Using a hammer and pin punch, drive out pin (**Figure 45, item 1**) holding roller onto shaft.

NOTE

*Be certain to drive pin out through slotted hole (**Figure 44, item 1**). DO NOT drive pin out on side of roller where pin (**Figure 44, item 2**) is sticking out.*

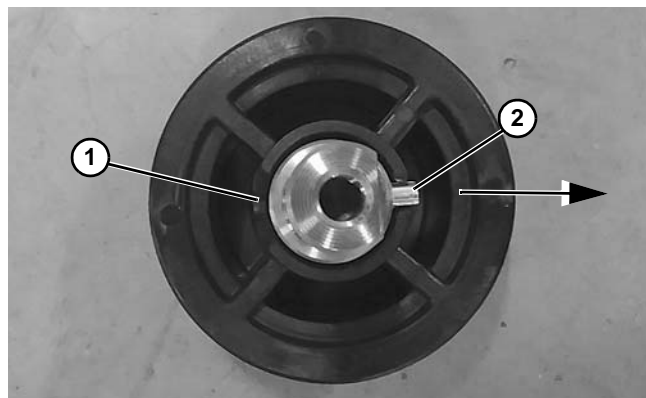


Figure 44

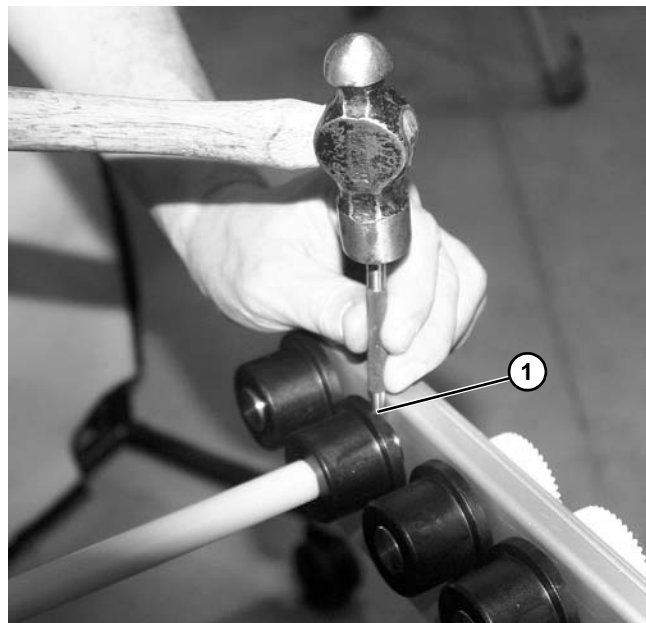


Figure 45

Preventive Maintenance and Replacement

9. Use a small screwdriver to release bearing assembly (Figure 46, item 1) from the conveyor frame.

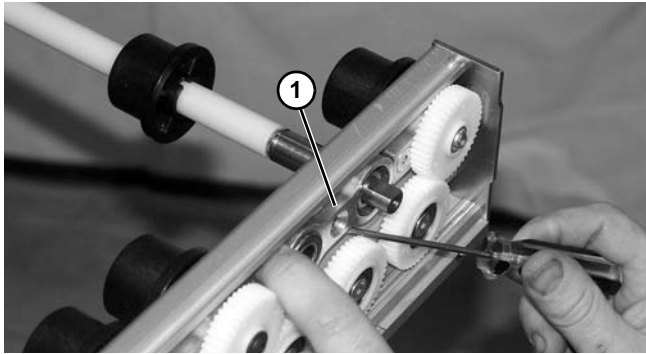


Figure 46

10. Remove the bearing assembly (Figure 47, item 1) along with washer (Figure 47, item 2) and shaft assembly (Figure 47, item 3) from the conveyor frame.

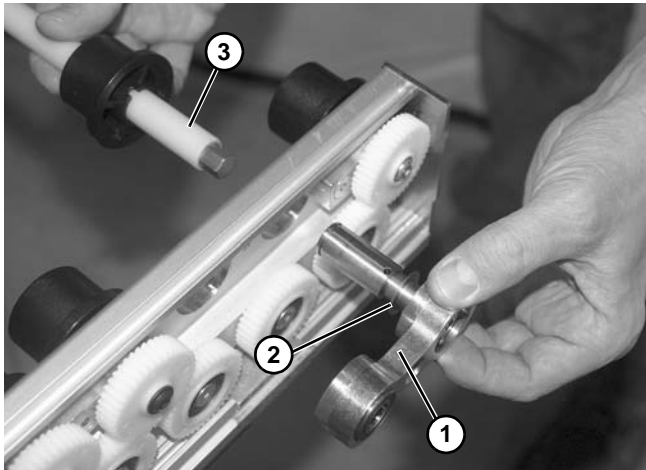


Figure 47

11. Remove shaft assembly (Figure 48, item 1) from both sides of conveyor frame.

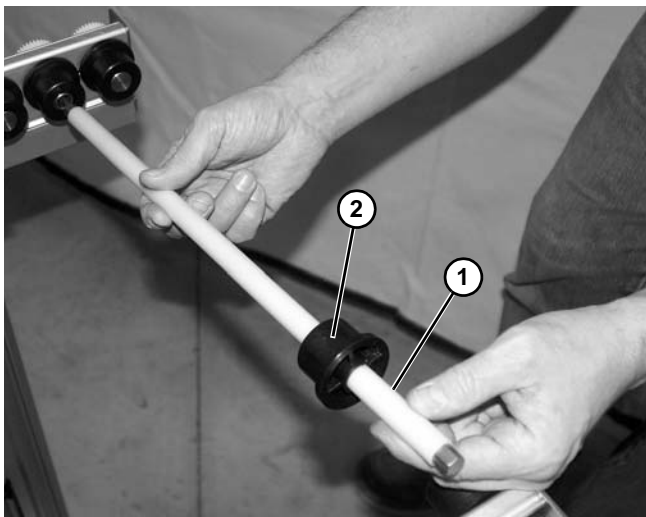


Figure 48

12. Remove roller (Figure 48, item 2) from shaft cover.
13. Remove shaft cover (Figure 49, item 1) from shaft (Figure 49, item 2).

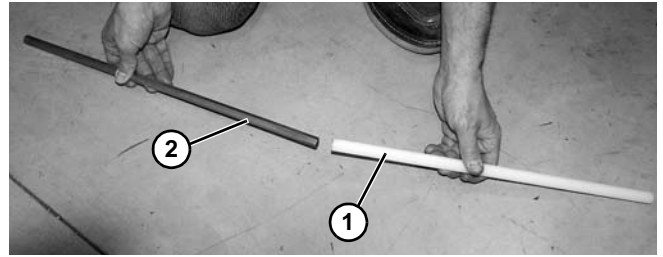


Figure 49

14. Install new roller assembly in reverse order of removal.

Drive Shaft Roller (Lower Location)

1. Remove side cover from conveyor. (See “Side Cover Removal and Installation” on page 15.)
2. Remove screw (Figure 50, item 1) and lower gear located next to shaft.

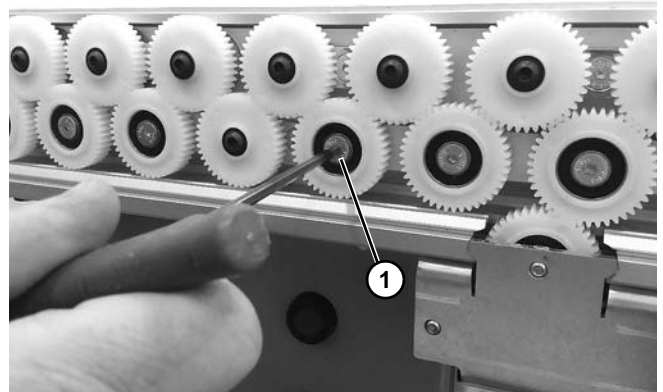


Figure 50

3. Remove screw (Figure 51, item 1) from bearing assembly.

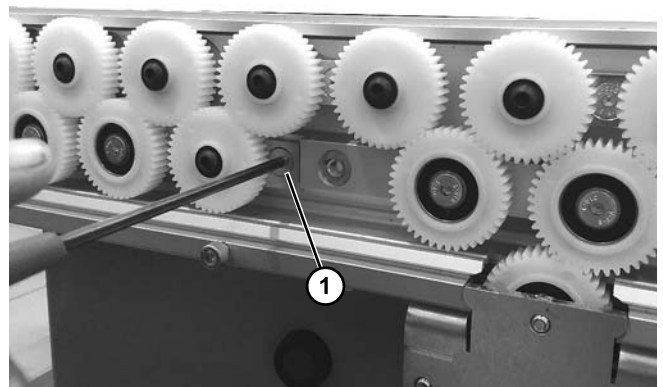


Figure 51

Preventive Maintenance and Replacement

4. Remove bearing assembly (Figure 52, item 1).

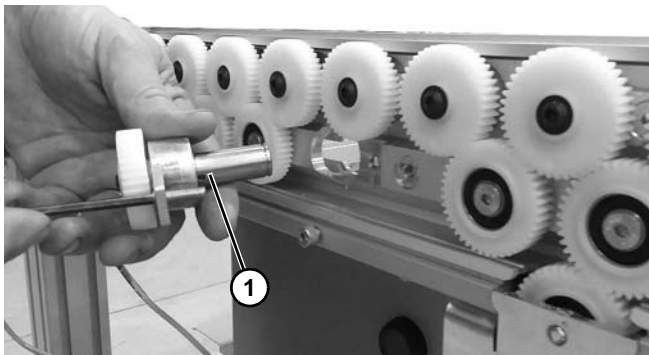


Figure 52

5. Remove shaft assembly (Figure 53, item 1).

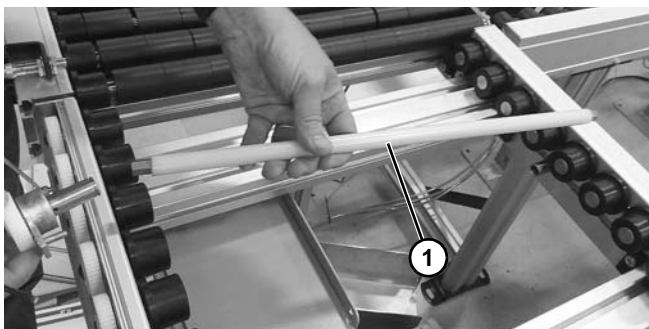


Figure 53

6. Install new roller assembly in reverse order of removal.

Gear Replacement

Lower Gear Replacement

1. Remove side cover from conveyor. (See “Side Cover Removal and Installation” on page 15.)
2. Remove screw (Figure 54, item 1) from lower gear (Figure 54, item 2).

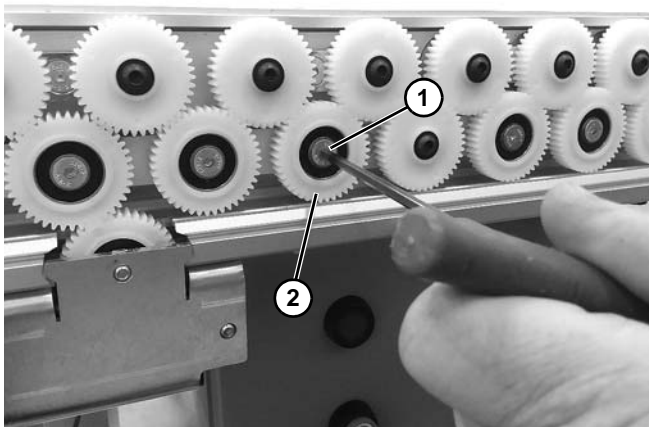


Figure 54

3. Remove screw (Figure 55, item 1) and gear (Figure 55, item 2) from frame.

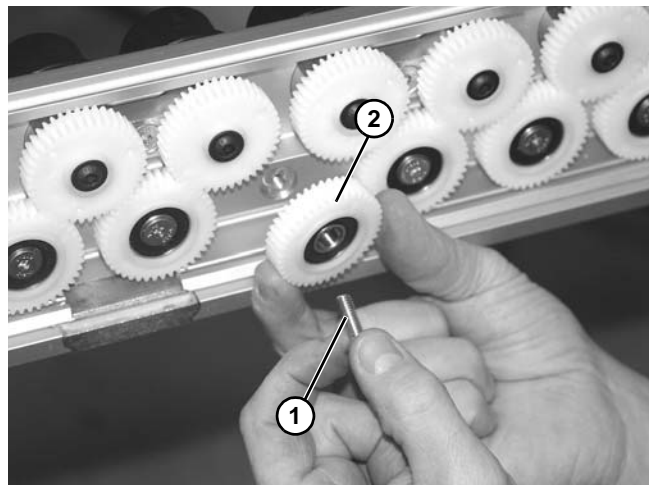


Figure 55

4. Remove spacer (Figure 56, item 1) from end of gear (Figure 56, item 2).

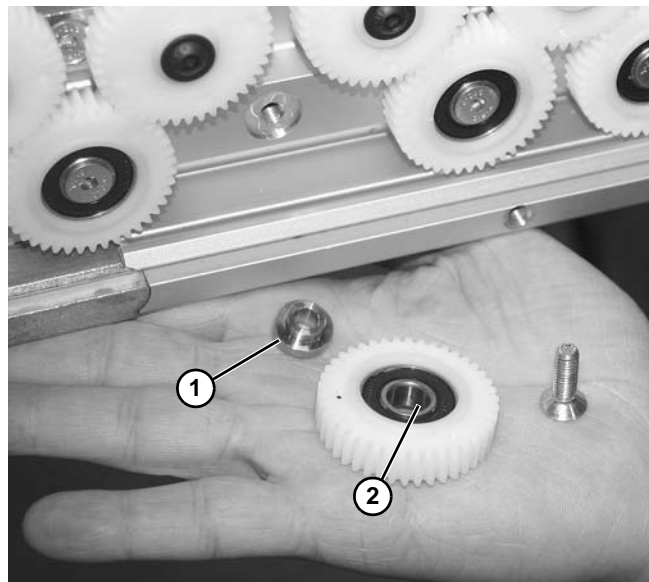


Figure 56

Preventive Maintenance and Replacement

5. Install new gear in reverse order of removal. NOTE: When installing, be certain spacer flange is properly installed onto gear (**Figure 57, item 1**), with large flange end (**Figure 57, item 2**) of spacer mating with recessed area (**Figure 57, item 3**) on conveyor frame.

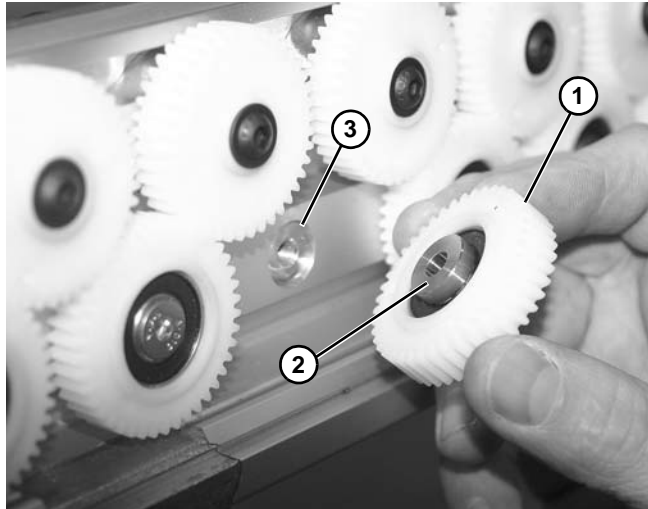


Figure 57

6. Install new gear in reverse order of removal.

Upper Gear Replacement

1. Remove side cover from conveyor. (See “Side Cover Removal and Installation” on page 15.)
2. Install sprocket removal tool, part number 400289 (**Figure 58, item 1**) between gears.

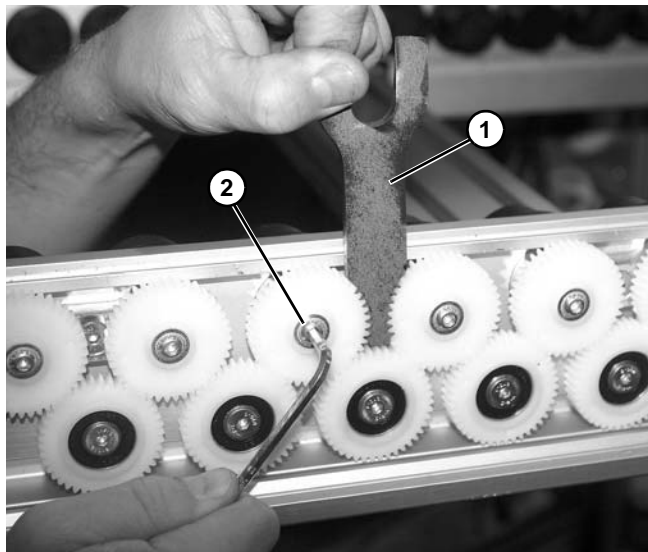


Figure 58

3. Remove screw (**Figure 58, item 2**) holding gear onto roller shaft.

4. Install opposite end of sprocket removal tool, part number 400289 (**Figure 59, item 1**) to pry gear (**Figure 59, item 2**) from roller shaft.

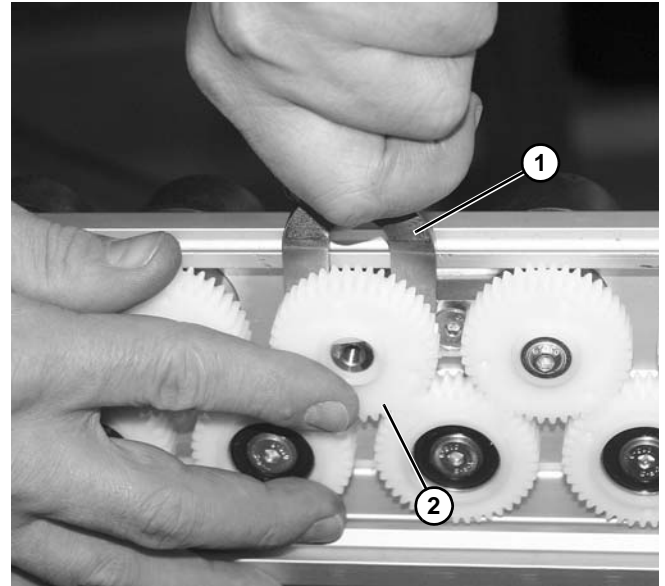


Figure 59

5. Remove the gear (**Figure 60, item 1**) from the roller shaft (**Figure 60, item 2**). Make note of the raised flange (**Figure 60, item 3**) on the gear. This raised flange should be installed toward the outside.

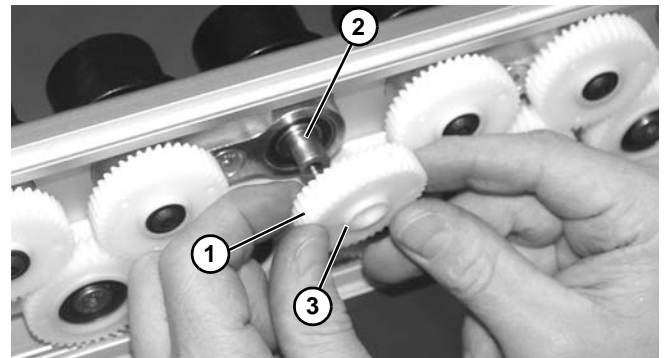


Figure 60

6. Install new gear in reverse order of removal.
7. Torque screw to 10 N-m (88 in-lbs).

Preventive Maintenance and Replacement

Corner Conveyor

Corner Assembly, Roller and Gear Replacement

1. Remove side cover from conveyor.
2. Install sprocket removal tool, part number 400289 (Figure 61, item 1) between gears.

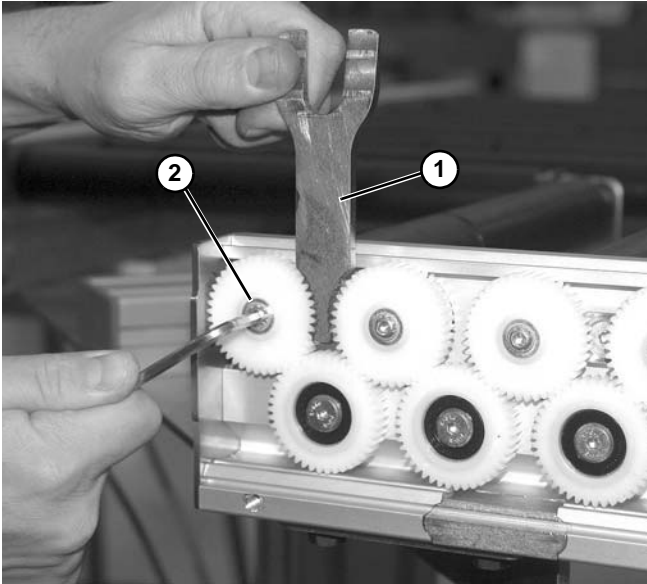


Figure 61

3. Remove flanged button head screw (Figure 61, item 2) holding gear onto roller shaft.
4. Install opposite end of sprocket removal tool (Figure 62, item 1) to pry gear (Figure 62, item 2) from roller shaft.

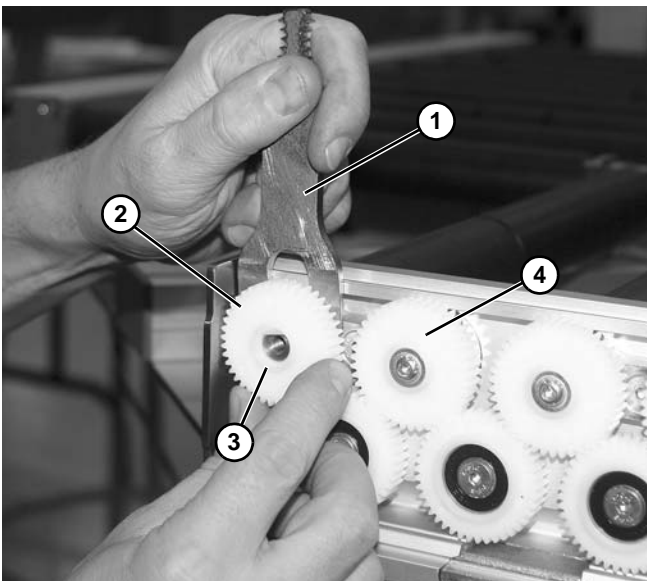


Figure 62

5. Remove the gear (Figure 62, item 2) from the roller shaft. Make note of the raised flange (Figure 62, item 3) on the gear. This raised flange should be installed toward the outside.
6. Repeat for second gear (Figure 62, item 4).
7. Loosen two bolts (Figure 63, item 1) from corner angle bracket (Figure 63, item 2).

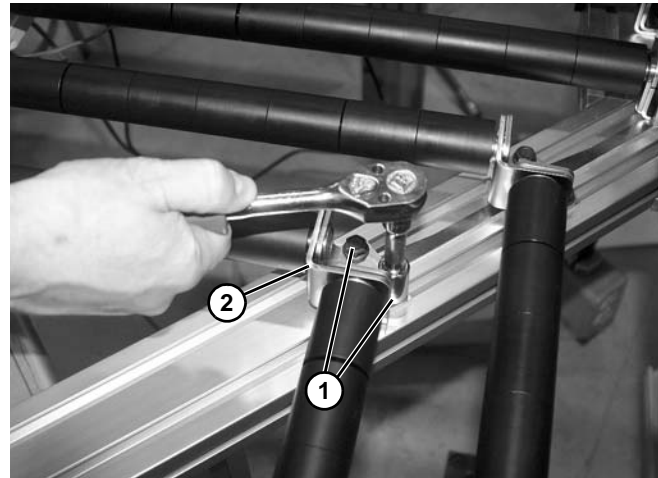


Figure 63

8. Remove flat head screw (Figure 64, item 1) from center of bearing assembly (Figure 64, item 2).

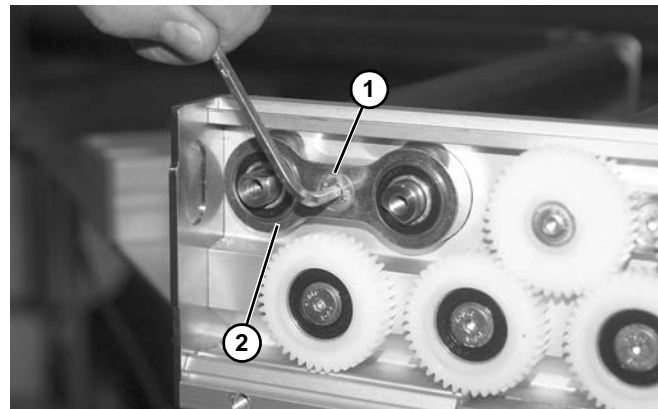


Figure 64

Preventive Maintenance and Replacement

9. While holding rollers (**Figure 65, item 1**), remove bearing assembly (**Figure 65, item 2**) from the conveyor frame.



Figure 65

10. Remove lockwasher (**Figure 66, item 1**) and washer (**Figure 66, item 2**) from end of roller shaft (**Figure 66, item 3**).

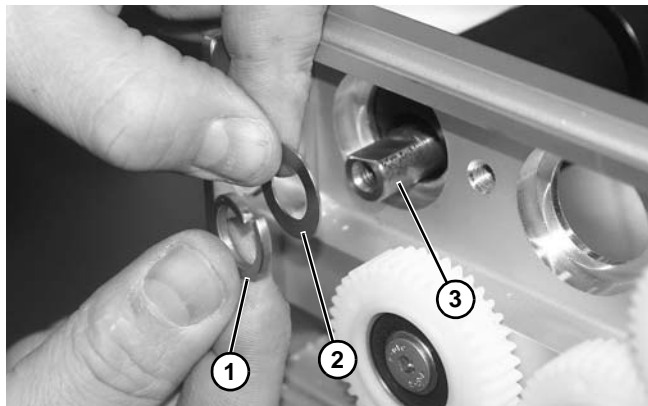


Figure 66

11. Slightly pull roller shaft (**Figure 67, item 1**) out and remove rollers (**Figure 67, item 2**) as you pull shaft further outward from corner bracket (**Figure 67, item 3**).

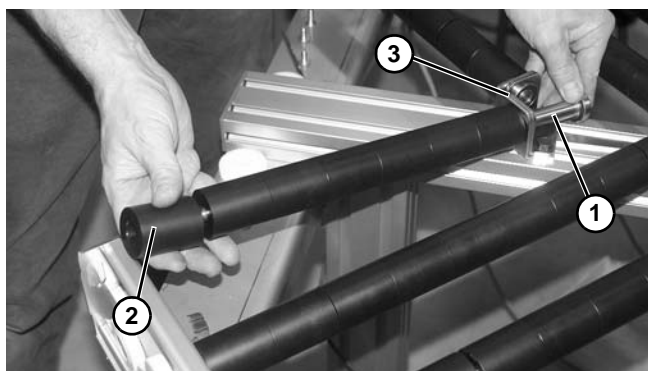


Figure 67

12. Once all rollers are removed, continue to remove shaft (**Figure 68, item 1**) from corner bracket (**Figure 68, item 2**).

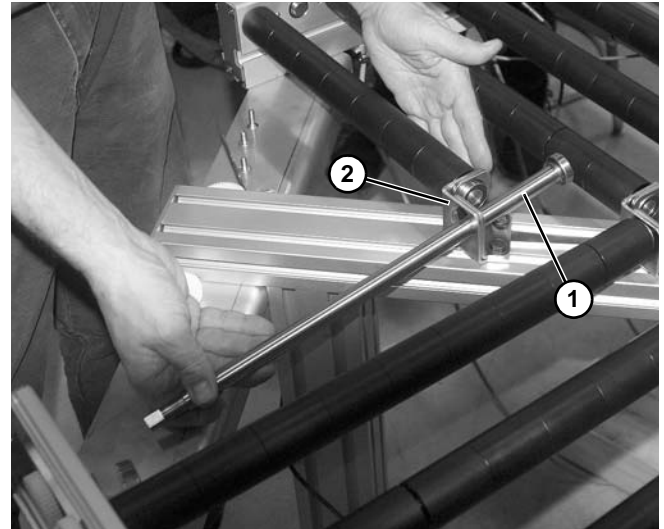


Figure 68

13. Replace worn or damaged parts.
14. Installation is the reverse of removal.

NOTE

*When reinstalling components, make certain stand-off brackets (**Figure 69, item 1**) are fully seated onto angle brackets (**Figure 69, item 2**) before tightening bearing assembly back onto conveyor frame.*

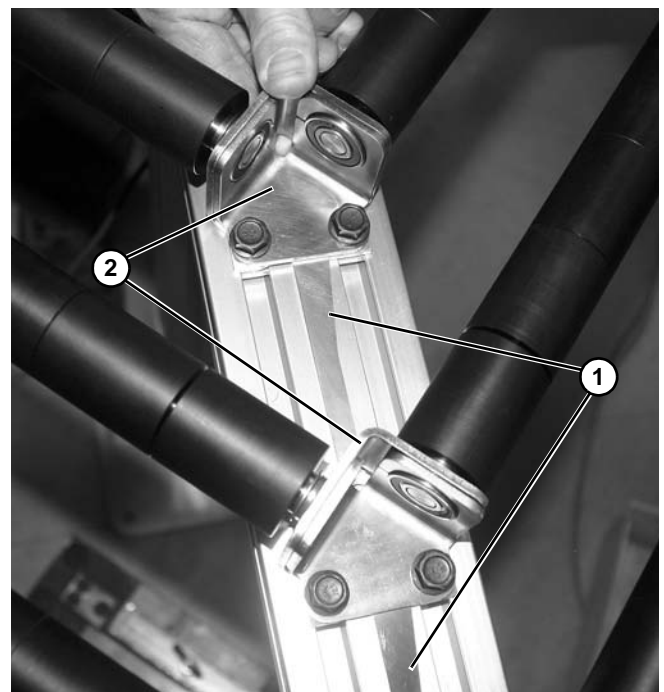


Figure 69

Preventive Maintenance and Replacement

Motor Idler Gear Replacement

⚠ WARNING



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

1. Remove side cover from conveyor. (See “Side Cover Removal and Installation” on page 15.)
2. Remove screws (Figure 70, item 1) connecting the motor to the spring nuts (Figure 70, item 2) in the conveyor frame.

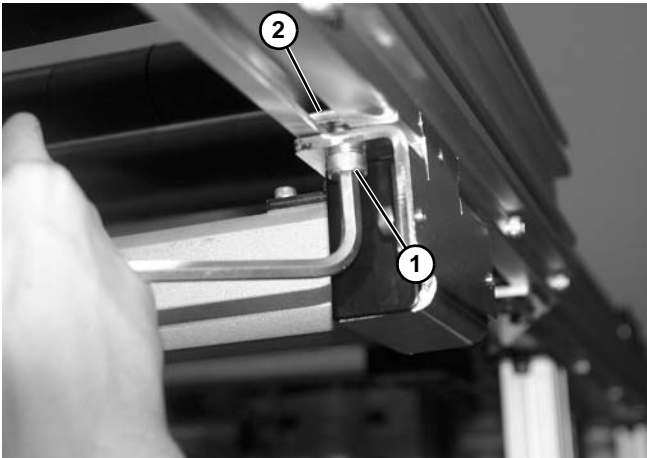


Figure 70

3. Lower and remove motor (Figure 71, item 1) from conveyor frame.

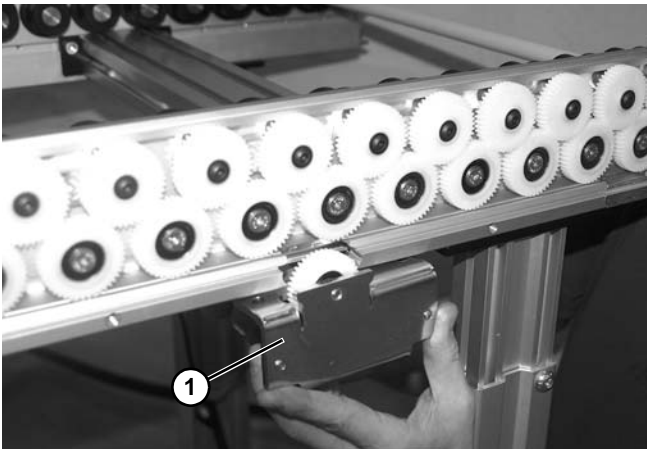


Figure 71

4. Remove screw (Figure 72, item 1) holding idler gear (Figure 72, item 1) onto motor mounting bracket.

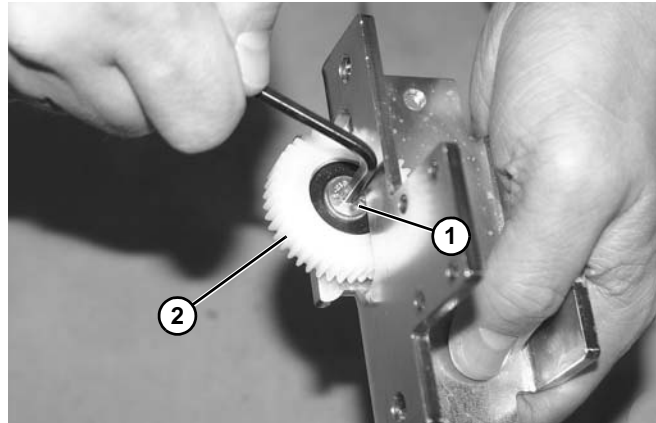


Figure 72

5. Remove spacer (Figure 73, item 1) from idler gear.

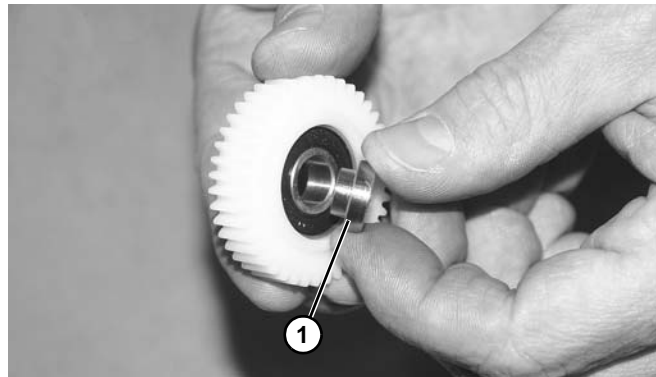



Figure 73

6. Install components in reverse order of removal.

Preventive Maintenance and Replacement

Motor Replacement

⚠ WARNING

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

1. Remove side cover from conveyor. (See “Side Cover Removal and Installation” on page 15.)
2. Remove screws (**Figure 74, item 1**) connecting the motor to the spring nuts (**Figure 74, item 2**) in the conveyor frame.

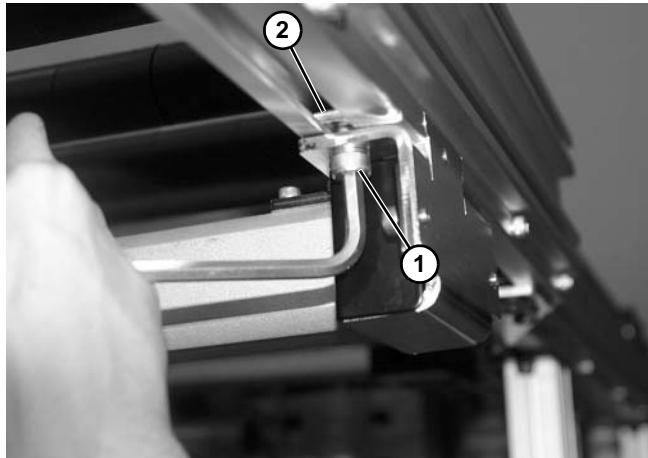


Figure 74

3. Lower and remove motor (**Figure 75, item 1**) from conveyor frame.

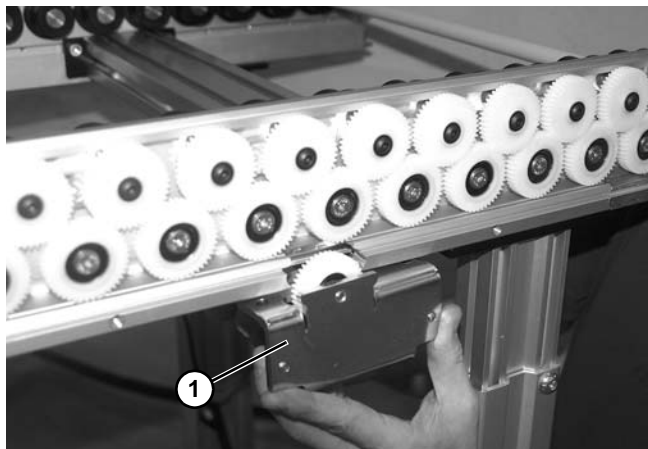


Figure 75

4. Remove two screws (**Figure 76, item 1**) holding cover to motor bracket.

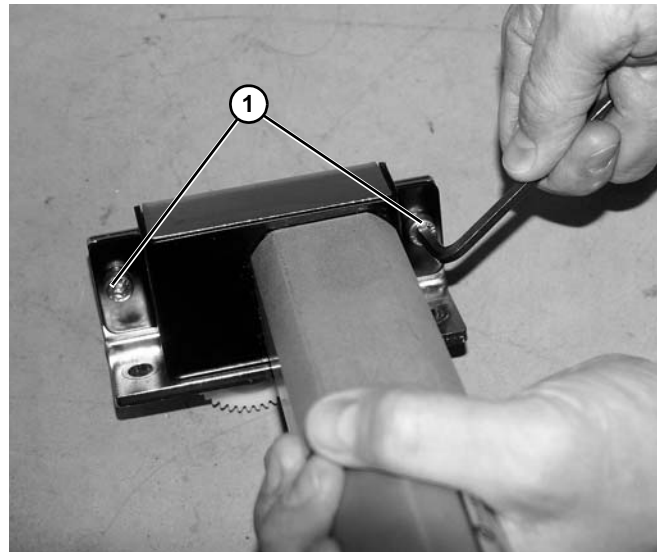


Figure 76

5. Remove the cover (**Figure 77, item 1**) from motor bracket (**Figure 77, item 2**).

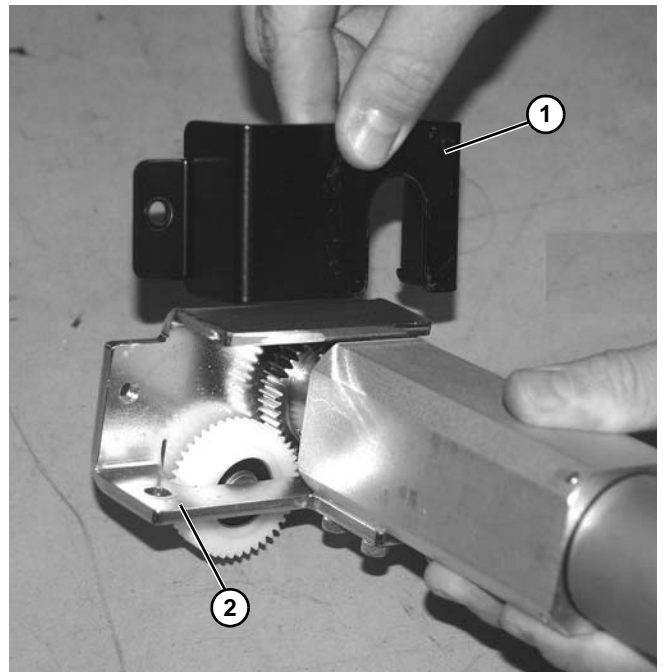


Figure 77

Preventive Maintenance and Replacement

6. Remove four screws (**Figure 78, item 1**) and remove motor mounting bracket (**Figure 78, item 2**) from motor (**Figure 78, item 3**).

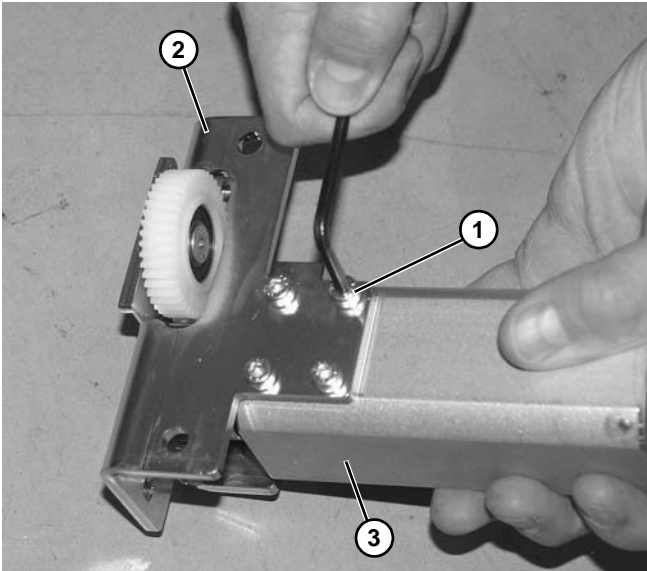


Figure 78

7. Loosen two set screws (**Figure 79, item 1**) on gear.

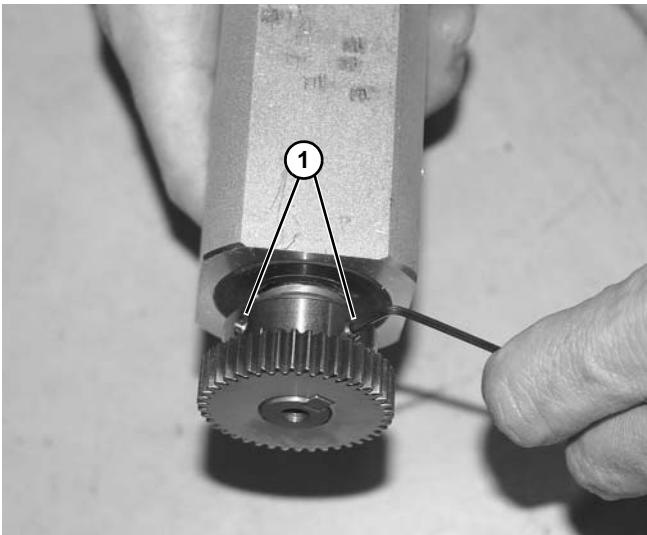


Figure 79

8. Remove gear (**Figure 80, item 1**) from motor shaft (**Figure 80, item 2**).

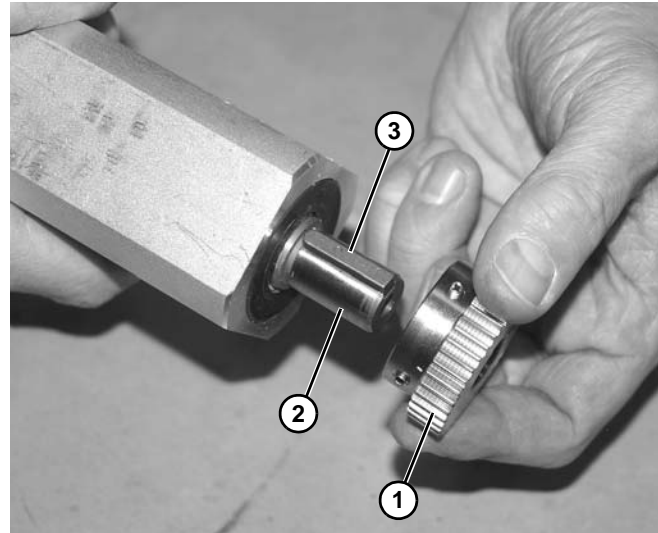



Figure 80

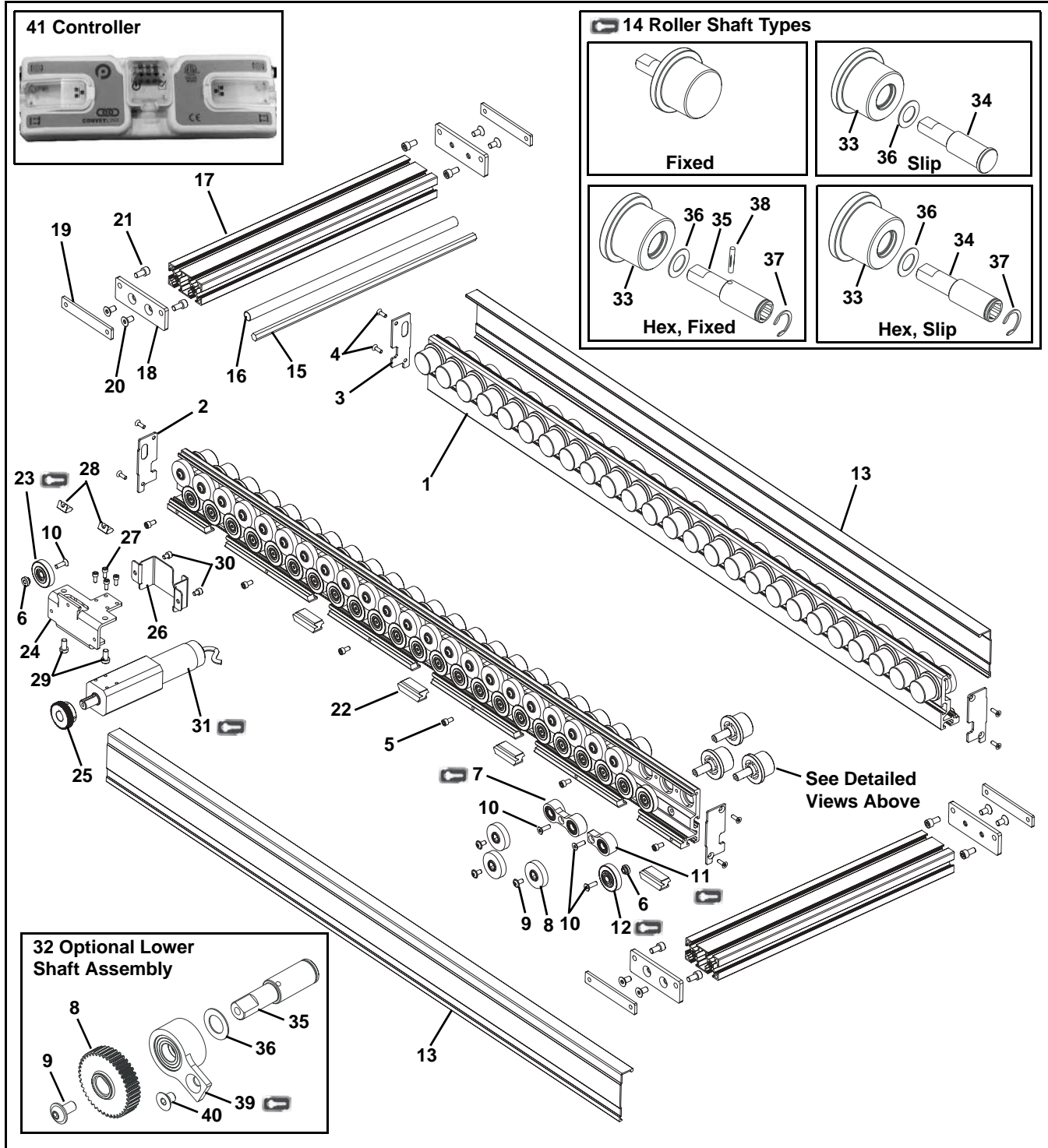
9. Remove key (**Figure 80, item 3**) from end of motor shaft.
10. Install components in reverse order of removal.

Service Parts

NOTE

For replacement parts other than those shown in this section, contact an authorized *Dorner Service Center* or the factory. Key Service Parts and Kits are identified by the Performance Parts Kits logo . Dorner recommends keeping these parts on hand.

ERT 250 Conveyor



ERT™ 250 Conveyor

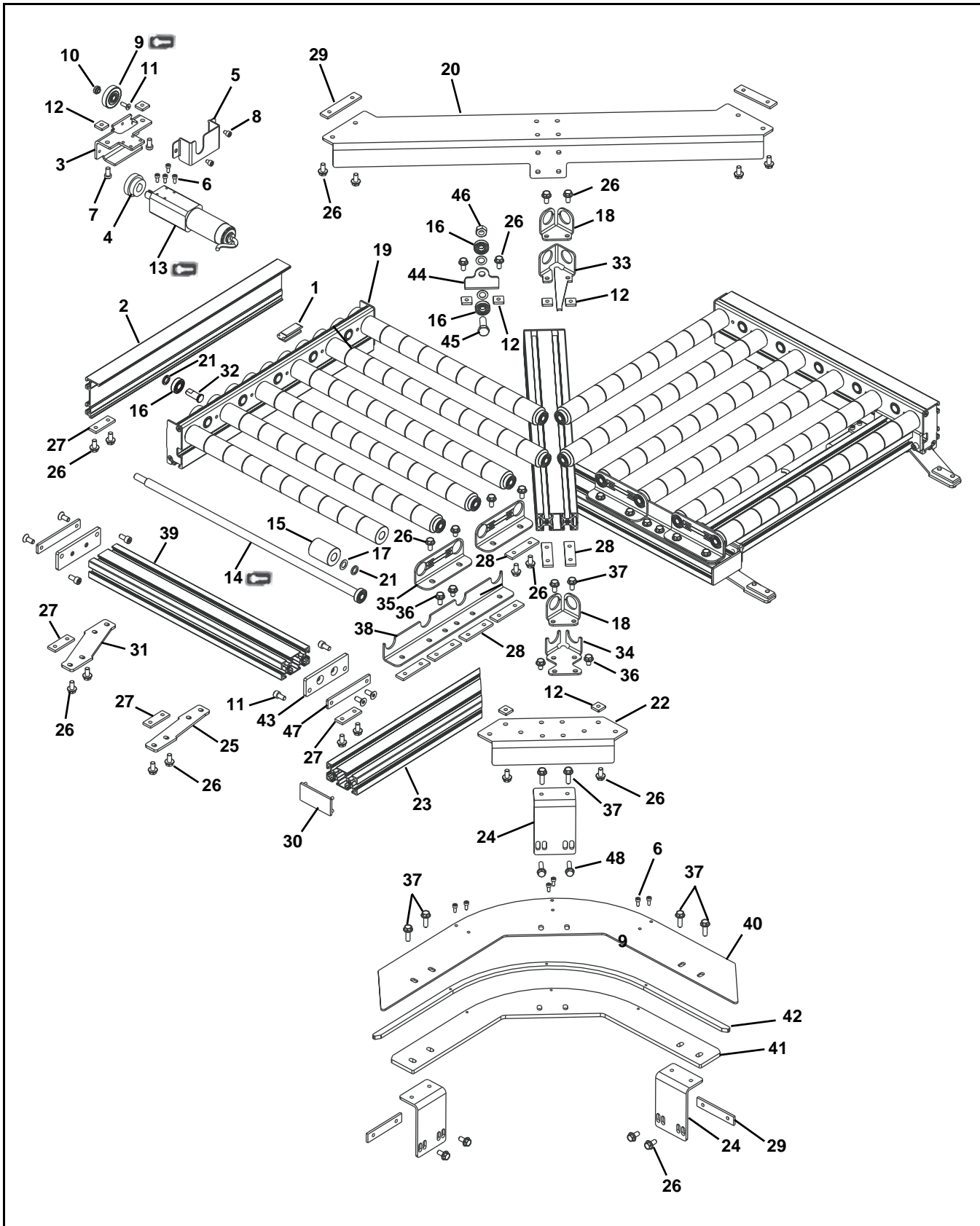
Service Parts

Item	Part Number	Description
1	-----	Consult Factory for Side Rail Part Number
2	400065-RH	End Cover, Right Hand
3	400065-LH	End Cover, Left Hand
4	807-4143	Torx Flat Head Screw, M5 x 16 mm
5	920612M	Socket Head Screw, M6-1.00 x 12 mm
6	400076	Bearing Spacer
7	400063-2	Bearing Assembly
8	400219	Upper Gear
9	910612MF	Flanged Button Head Screw, M6-1.00 x 12 mm
10	930620M	Flat Head Screw, M6-1.00 x 20 mm
11	400063-1	End Bearing Assembly for Conveyor Lengths that end in 50
12	400075	Lower Gear
13	400065-LLLLL-M	Flush Cover
	400058-LLLLL-M	T-Slot Cover
14	400062-PF	Plain, Fixed Roller Shaft Assembly
	400062-PS	Plain, Slip Roller Shaft Assembly
	400062-HF	Hex, Fixed Roller Shaft Assembly
	400062-HS	Hex, Slip Roller Shaft Assembly
15	400072- <u>WWW</u>	Shaft
16	400073- <u>WWW</u>	Shaft Cover
17	400071-LLLLL-M	Crossmember
18	400070	Crossmember Plate
19	206774	Nut Bar
20	930816M	Flat Head Screw, M6-1.00 x 16 mm
21	920816M	Socket Head Screw, M8-1.25 x 16 mm
22	400059	Blocking Plug
23	400075	Bearing, Idler Gear
24	400078	Motor Mounting Bracket
25	400085	Motor Gear
26	400080	Drive Cover
27	920512M	Socket Head Screw, M5-.80 x 12 mm
28	FASL-M8	Spring Nut
29	950816M	Low Head Cap Screw, M8-1.25 x 16 mm
30	920608M	Socket Head Screw, M6-1.00 x 8 mm

Item	Part Number	Description
31	826-984	Motor, Speed = 10 Mpm, Gear Ratio = 67:1, RPM = 8.7-87
	826-985	Motor, Speed = 15 Mpm, Gear Ratio = 45:1, RPM = 12.9-129
	826-986	Motor, Speed = 20 Mpm, Gear Ratio = 33:1, RPM = 17.6-176
	826-987	Motor, Speed = 25 Mpm, Gear Ratio = 27:1, RPM = 21.5-215
	826-988	Motor, Speed = 37 Mpm, Gear Ratio = 18:1, RPM = 31.7-317
	826-989	Motor, Speed = 46 Mpm, Gear Ratio = 15:1, RPM = 38.7-387
	826-990	Motor, Speed = 62 Mpm, Gear Ratio = 11:1, RPM = 52.9-529
	826-991	Motor, Speed = 76 Mpm, Gear Ratio = 9:1, RPM = 64.5-645
	32	400245
33	400060-S	Roller
34	400061-S	Slip Shaft
35	400061-H	Hex Shaft
36	400149	Washer
37	915-357	Retaining Ring, 16 mm
38	913-517	Groove Pin
39	400063-3	Lower Shaft Bearing Assembly
40	930608M	Flat Head Screw, M6-1.00 x 8 mm
41	826-999	Controller
<u>WWW</u> = Conveyor width reference: 120-960 in 40 mm increments		
<u>LLLLL</u> = Part Length in mm with one decimal place.		
Length Example: Length = 485 mm LLLLL = 04850		

Service Parts

90° Corner Conveyor



ERT™ 250 Conveyor

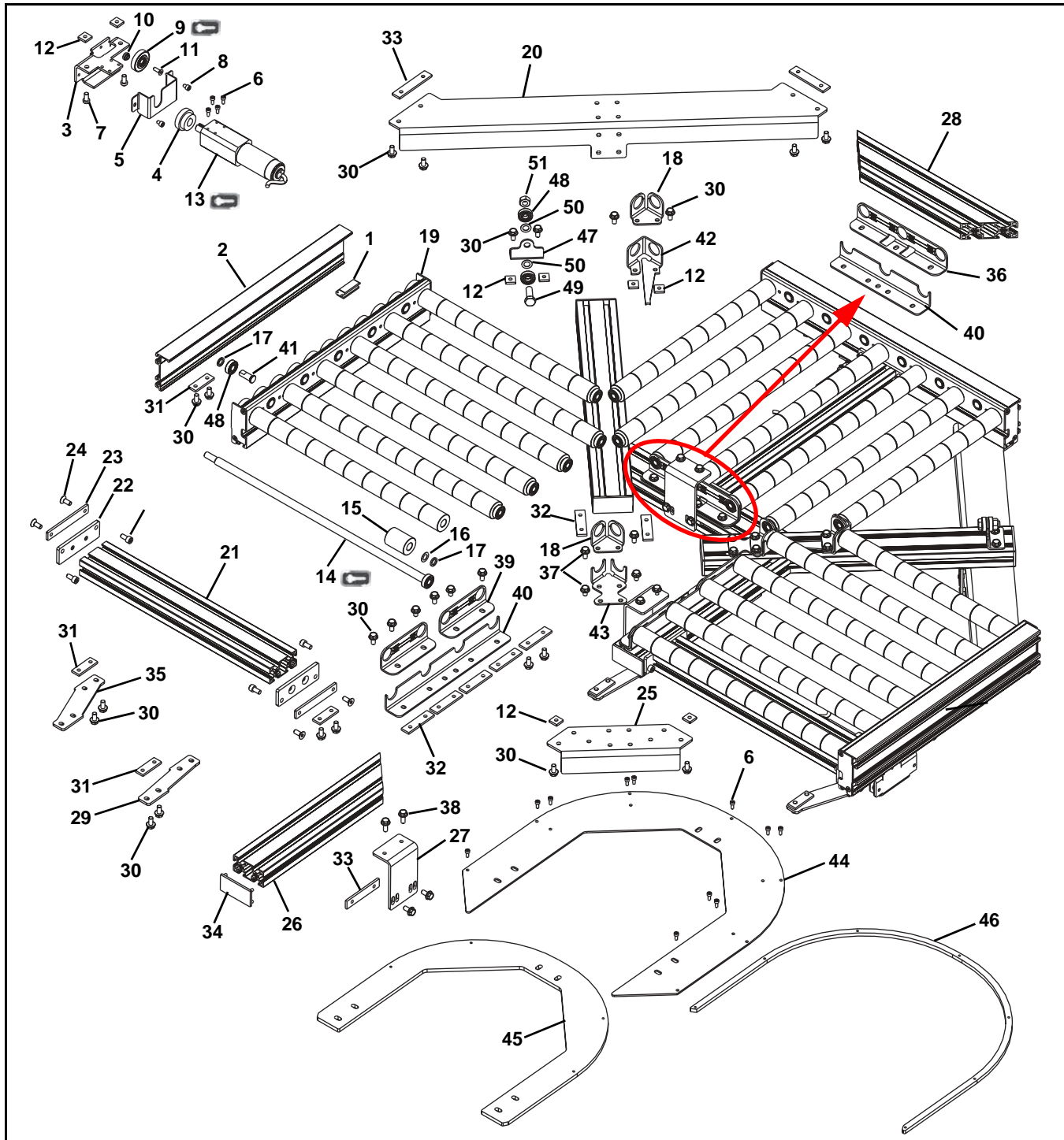
Service Parts

Item	Part Number	Description
1	400059	Blocking Plug
2	400058-LLLLL-M	T-Slot Cover
3	400078	Motor Mounting Bracket
4	400085	Motor Gear
5	400080	Drive Cover
6	920512M	Socket Head Screw, M5-.80 x 12 mm
7	920816M	Socket Head Screw, M8-1.25 x 16 mm
8	920608M	Socket Head Screw, M6-1.00 x 8 mm
9	400075	Bearing, Idler Gear
10	400076	Bearing Spacer
11	930816M	Flat Head Screw, M6-1.00 x 16 mm
12	FASN-M8	Square Nut
13	826-984	Motor, Speed = 10 Mpm, Gear Ratio = 67:1, RPM = 8.7-87
	826-985	Motor, Speed = 15 Mpm, Gear Ratio = 45:1, RPM = 12.9-129
	826-986	Motor, Speed = 20 Mpm, Gear Ratio = 33:1, RPM = 17.6-176
	826-987	Motor, Speed = 25 Mpm, Gear Ratio = 27:1, RPM = 21.5-215
	826-988	Motor, Speed = 37 Mpm, Gear Ratio = 18:1, RPM = 31.7-317
	826-989	Motor, Speed = 46 Mpm, Gear Ratio = 15:1, RPM = 38.7-387
	826-990	Motor, Speed = 62 Mpm, Gear Ratio = 11:1, RPM = 52.9-529
	826-991	Motor, Speed = 76 Mpm, Gear Ratio = 9:1, RPM = 64.5-645
14	400401-08	Corner Roller Shaft Assembly, 442.80 mm (17.433") Long
	400401-09	Corner Roller Shaft Assembly, 492.80 mm (19.402") Long
	400401-10	Corner Roller Shaft Assembly, 542.80 mm (21.370") Long
	400401-11	Corner Roller Shaft Assembly, 592.80 mm (23.339") Long
	400401-13	Corner Roller Shaft Assembly, 692.80 mm (27.276") Long
	400401-14	Corner Roller Shaft Assembly, 742.80 mm (29.244") Long
	400401-15	Corner Roller Shaft Assembly, 792.80 mm (31.213") Long
	400401-16	Corner Roller Shaft Assembly, 842.80 mm (33.181") Long
400401-18	Corner Roller Shaft Assembly, 942.80 mm (37.118") Long	
15	400090	Non-Flanged roller
16	802-253	Bearing
17	400149	Washer
18	400098	Bearing Clamp
19	-----	Consult Factory for Side Rail Part Number
20	400107-01	Angle Support 759.85 mm (29.915") Long
	400107-02	Angle Support 829.85 mm (32.671") Long
	400107-03	Angle Support 1112.85 mm (43.813") Long
	400107-04	Angle Support 1183.85 mm (46.608") Long
21	911-720	Lock Washer
22	400108	Inner Angle Support

Item	Part Number	Description
23	400109-LLLLL-M	Crossmember
24	400119	Angle Support
25	400294-14	Connecting Plate
26	960883M	Flanged Head Cap Screw, M8 x 16 mm
27	FBCS-20X55	Connecting Strip (10 pack)
28	FBCS-20X76	Connecting Strip (10 pack)
29	FBCS-20X96	Connecting Strip (10 pack)
30	FBEC-40X80	End Cap
31	400294-30	Offset Connecting Plate 30 mm (1.181") Wide
	400294-40	Offset Connecting Plate 40 mm (1.575") Wide
	400294-50	Offset Connecting Plate 50 mm (1.969") Wide
	400294-70	Offset Connecting Plate 70 mm (2.756") Wide
32	400261	Blank Shaft
33	400262	Inner Bearing Bracket, Long
34	400263	Inner Bearing Bracket
35	400291	Angle Bearing Mount, 2 Place
	400292	Angle Bearing Mount, 3 Place
36	960882M	Flanged Head Cap Screw, M8 x 12 mm
37	960885M	Flanged Head Cap Screw, M8 x 25 mm
38	400290-04	Angle Bearing Mount, 4 Roll
	400290-03	Angle Bearing Mount, 3 Roll
	400290-02	Angle Bearing Mount, 2 Roll
39	FBSB-40X80-LLLLL-M	Corner Center Support Beam
40	400379-01	Top Corner Guiding for Conveyor Widths 320x320 & 480x320
	400379-02	Top Corner Guiding for Conveyor Widths 400x400, 480x400 & 480x480
	400379-03	Top Corner Guiding for Conveyor Widths 640x480 & 640x640
	400379-04	Top Corner Guiding for Conveyor Widths 800x640 & 800x800
41	400380-01	Inside Corner Guiding for Conveyor Widths 320x320 & 480x320
	400380-02	Inside Corner Guiding for Conveyor Widths 400x400, 480x400 & 480x480
	400380-03	Inside Corner Guiding for Conveyor Widths 640x480 & 640x640
	400380-042	Inside Corner Guiding for Conveyor Widths 800x640 & 800x800
42	400381-01	Outside Corner Guiding for Conveyor Widths 320x320 & 480x320
	400381-02	Outside Corner Guiding for Conveyor Widths 400x400, 480x400 & 480x480
	400381-03	Outside Corner Guiding for Conveyor Widths 640x480 & 640x640
	400381-04	Outside Corner Guiding for Conveyor Widths 800x640 & 800x800
43	400070	Crossmember Plate
44	400378	Corner Bearing Holder
45	961235MSS	Hex Head Cap Screw, M12-1.75 x 35 mm
46	991201M	Hex Nut
47	206774	Nut Bar
48	960897M	Hex Head Cap Screw, M8-1.25 x 30 mm
LLLLL = Part Length in mm with one decimal place.		
Length Example: Length = 485 mm LLLLL = 04850		
WWW = Pallet Width Reference: 320, 400, 480, 640, 800		

Service Parts

180° Corner Conveyor



Item	Part Number	Description
1	400059	Blocking Plug
2	400058-LLLLL-M	T-Slot Cover
3	400078	Motor Mounting Bracket
4	400085	Motor Gear
5	400080	Drive Cover
6	920512M	Socket Head Screw, M5-.80 x 12 mm

Item	Part Number	Description
7	920816M	Socket Head Screw, M8-1.25 x 16 mm
8	920608M	Socket Head Screw, M6-1.00 x 8 mm
9	400075	Bearing, Idler Gear
10	400076	Bearing Spacer
11	930816M	Flat Head Screw, M6-1.00 x 16 mm

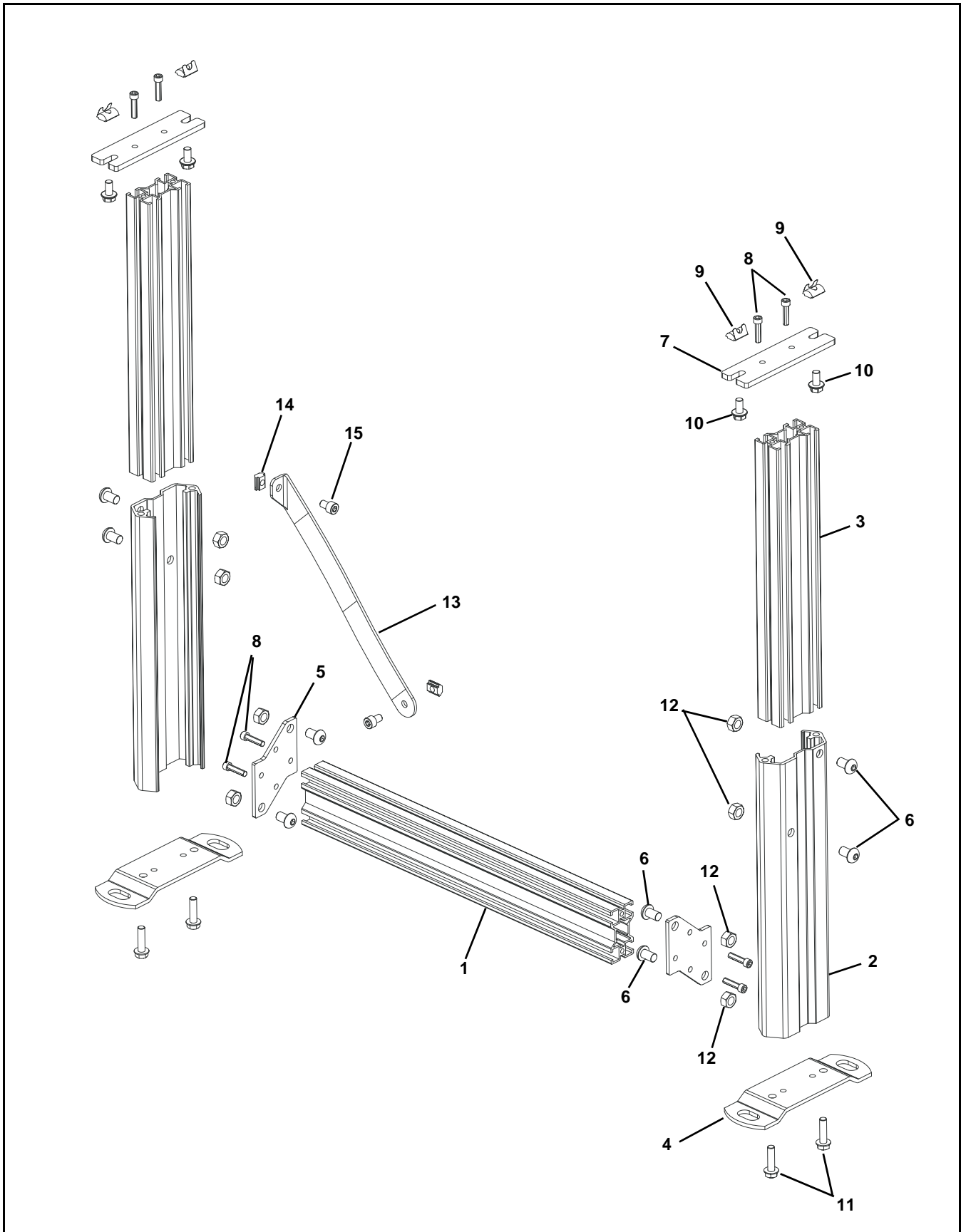
Service Parts

Item	Part Number	Description
12	FASN-M8	Square Nut
13	826-984	Motor, Speed = 10 Mpm, Gear Ratio = 67:1, RPM = 8.7-87
	826-985	Motor, Speed = 15 Mpm, Gear Ratio = 45:1, RPM = 12.9-129
	826-986	Motor, Speed = 20 Mpm, Gear Ratio = 33:1, RPM = 17.6-176
	826-987	Motor, Speed = 25 Mpm, Gear Ratio = 27:1, RPM = 21.5-215
	826-988	Motor, Speed = 37 Mpm, Gear Ratio = 18:1, RPM = 31.7-317
	826-989	Motor, Speed = 46 Mpm, Gear Ratio = 15:1, RPM = 38.7-387
	826-990	Motor, Speed = 62 Mpm, Gear Ratio = 11:1, RPM = 52.9-529
	826-991	Motor, Speed = 76 Mpm, Gear Ratio = 9:1, RPM = 64.5-645
	14	400401-08
400401-09		Corner Roller Shaft Assembly, 492.80 mm (19.402") Long
400401-10		Corner Roller Shaft Assembly, 542.80 mm (21.370") Long
400401-11		Corner Roller Shaft Assembly, 592.80 mm (23.339") Long
400401-13		Corner Roller Shaft Assembly, 692.80 mm (27.276") Long
400401-14		Corner Roller Shaft Assembly, 742.80 mm (29.244") Long
400401-15		Corner Roller Shaft Assembly, 792.80 mm (31.213") Long
400401-16		Corner Roller Shaft Assembly, 842.80 mm (33.181") Long
400401-18		Corner Roller Shaft Assembly, 942.80 mm (37.118") Long
15	400090	Non-Flanged roller
16	400149	Washer
17	911-720	Spring Washer
18	400098	Bearing Clamp
19	-----	Consult Factory for Side Rail Part Number
20	400107-01	Angle Support for 320 x 320 and 400 x 400 Wide Curve Conveyors
	400107-02	Angle Support for 480 x 320, 480 x 400 and 480 x 480 Wide Curve Conveyors
	400107-03	Angle Support for 640 x 480 and 640 x 640 Wide Curve Conveyors
	400107-04	Angle Support for 800 x 640 and 800 x 800 Wide Curve Conveyors
21	FBSB-40X80-LLLLL-M	Crossmember
22	400070	Crossmember Plate
23	206774	Nut Bar
24	807-4142	Trilobe Flat Head Screw, M8 x 20 mm
25	400108	Inner Angle Support
26	400109-LLLLL-M	Crossmember
27	400119	Angle Support
28	400232-04240-M	Crossmember
29	400294-14	Connecting Plate
30	960883M	Flanged Head Cap Screw, M8 x 16 mm

Item	Part Number	Description
31	FBCS-20X55	Connecting Strip (10 pack)
32	FBCS-20X76	Connecting Strip (10 pack)
33	FBCS-20X96	Connecting Strip (10 pack)
34	FBEC-40X80	End Cap
35	400294-50	Offset Plate for 320 x 320 Wide Curve Conveyors
	400294-70	Offset Plate for 400 x 400, 800 x 640 and 800 x 800 Wide Curve Conveyors
	400294-40	Offset Plate for 480 x 320, 480 x 400 and 480 x 480 Wide Curve Conveyors
	400294-30	Offset Plate for 640 x 480 and 640 x 640 Wide Curve Conveyors
36	400292	Angle Bearing Mounting Clamp
37	960882M	Flanged Head Cap Screw, M8 x 12 mm
38	960884M	Flange Head Cap Screw, M8 x 20 mm
39	400291	Bearing Mounting Clamp, 2 Place
40	400290-02	Angle Bearing Mount, 2 Roll
	400290-03	Angle Bearing Mount, 3 Roll
	400290-04	Angle Bearing Mount, 4 Roll
41	400261	Blank Shaft
42	400262	Inner Bearing Bracket, Long
43	400263	Inner Bearing Bracket
44	400356-01	Top Plate for 400 x 400, 480 x 400, 480 x 480 and 640 x 480 Wide Curve Conveyors
	400356-02	Top Plate for 320 x 320 and 480 x 320 Wide Curve Conveyors
	400356-03	Top Plate for 640 x 640 and 800 x 640 Wide Curve Conveyors
	400356-04	Top Plate for 800 x 800 Wide Curve Conveyors
45	400357-01	Inside Plate for 400 x 400, 480 x 400, 480 x 480 and 640 x 480 Wide Curve Conveyors
	400357-02	Inside Plate for 320 x 320 and 480 x 320 Wide Curve Conveyors
	400357-03	Inside Plate for 640 x 640 and 800 x 640 Wide Curve Conveyors
	400357-04	Inside Plate for 800 x 800 Wide Curve Conveyors
46	400358-01	Outside Plate for 400 x 400, 480 x 400, 480 x 480 and 640 x 480 Wide Curve Conveyors
	400358-02	Outside Plate for 320 x 320 and 480 x 320 Wide Curve Conveyors
	400358-03	Outside Plate for 640 x 640 and 800 x 640 Wide Curve Conveyors
	400358-04	Outside Plate for 800 x 800 Wide Curve Conveyors
47	400378	Corner Bearing Holder
48	802-253	Bearing
49	961235MSS	Hex Bolt, M12 x 35 MM
50	400149	Washer
51	991201M	Hex Nut
		LLLLL = Part length in inches with 2 decimal places.
		Length Example: Length = 95.25" LLLLL = 09525

Service Parts

Support Stand



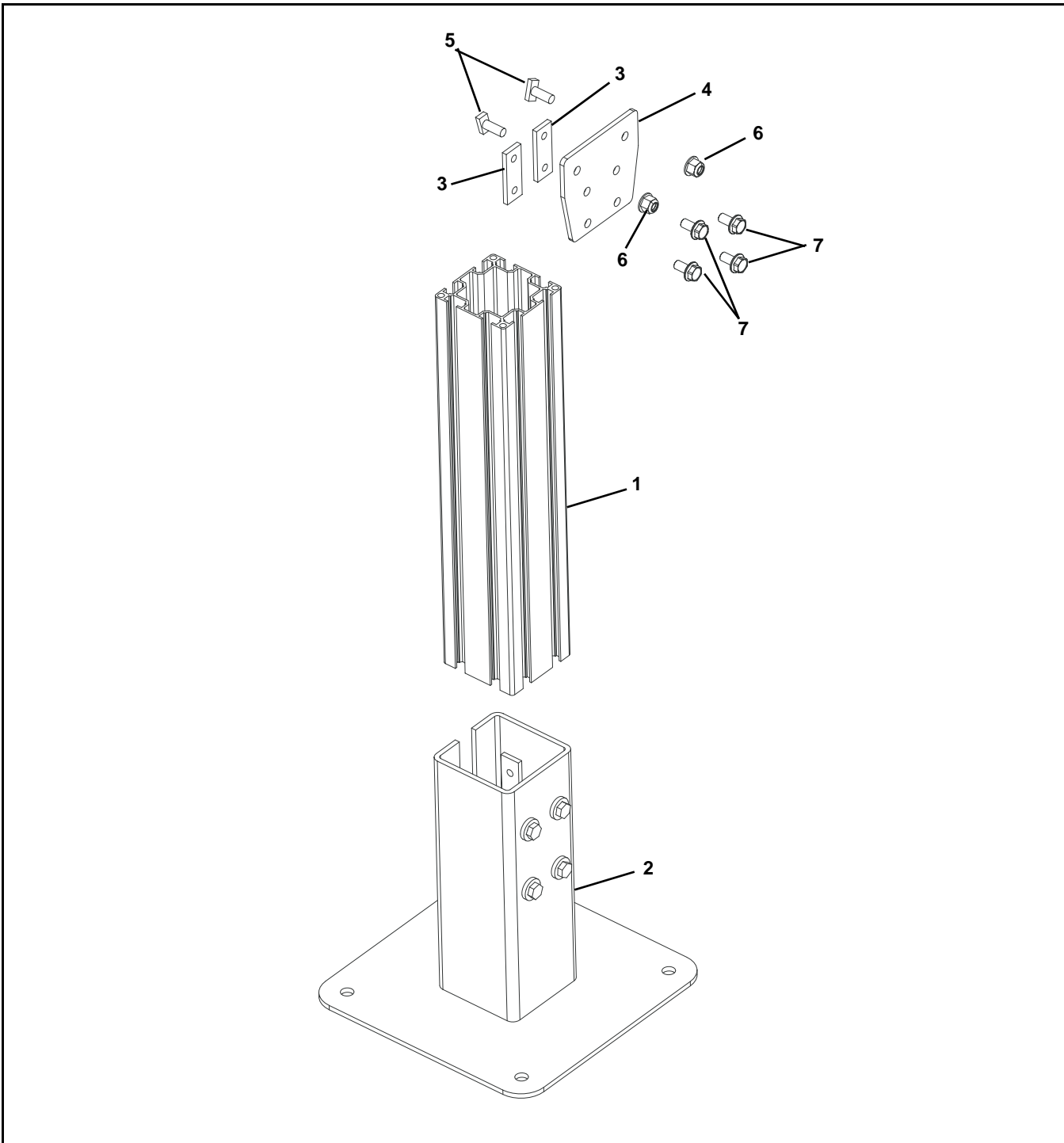
ERT™ 250 Conveyor

Service Parts

Item	Part Number	Description
1	710210-LLLLL-M	Crossmember
2	710031-03520-M	Boot
3	710211-LLLLL-M	Leg
4	710004	Foot
5	710006	End Plate
6	911016M	Button Head Screw, M10-1.50 x 16 mm
7	205188	Top Plate
8	708180P	Trilobe Screw, M6-1.00 x 25 mm
9	FASL-M8	Spring Nut, M8
10	960883M	Flanged Hex Head Cap Screw, M8-1.25 x 16 mm
11	960897M	Flanged Hex Head Cap Screw, M8-1.25 x 30 mm
12	991011M	Hex Nut, M10
13	734056	Angle Brace
14	202390M	Drop-in Tee Bar
15	920812M	Socket Head Screw, M8-1.25 x 12 mm
<u>LLLLL</u> = Part length in mm with one decimal place.		
Length Example: Length = 485 mm <u>LLLLL</u> = 04850		

Service Parts

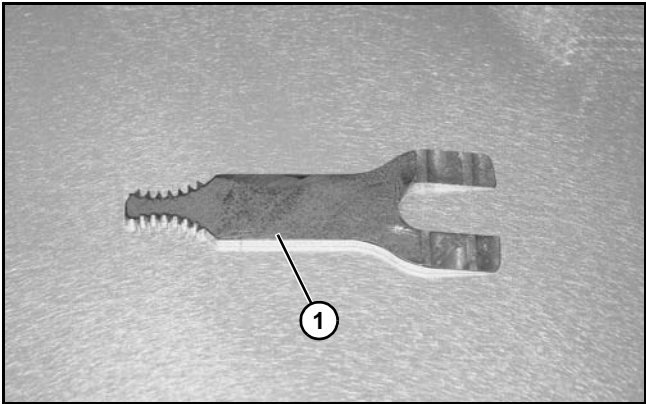
Post Support Stand



Item	Part Number	Description
1	FBSB-80X80-LLLLL-M	Beam
2	FBFT-80B	Foot Assembly
3	FBCS-20X55	Connecting Strip
4	400278	Top Plate
5	FATB-20	Twist-In Stud, M8 x 20 mm
6	990812M	Lock Nut, M8

Item	Part Number	Description
7	960883M	Flanged Hex Head Cap Screw, M8 x 16 mm
LLLLL = Part length in mm with one decimal place.		
Length Example: Length = 485 mm LLLLL = 04850		

Sprocket Removal Tool



Item	Part Number	Description
1	400289	Sprocket Removal Tool

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 (if available, part serial number).

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

Product Type										
Product Line	Standard Products								Engineered to order parts	
	Conveyors	Gearmotors & Mounting Packages	Support Stands	Accessories	Spare Parts (non-belt)	Spare Belts - Standard Flat Fabric	Spare Belts - Cleated & Specialty Fabric	Spare Belts - Plastic Chain	All equipment and parts	
1100	30% return fee for all products except: 50% return fee for conveyors with modular belt, cleated belt or specialty belts								non-returnable	case-by-case
2200										
2200 Modular Belt										
2200 Precision Move										
ERT 250										
3200										
3200 LPZ										
3200 Precision Move										
4100										
6200										
Controls										
7200 / 7300	50% return fee for all products									
7350	non-returnable									
7360										
7400										
7600										

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 factory, distributor, service center or visit our website at www.dorner.com.

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

Transforming Conveyor Automation

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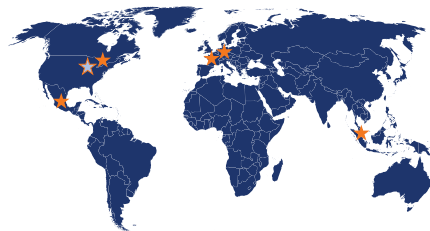
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