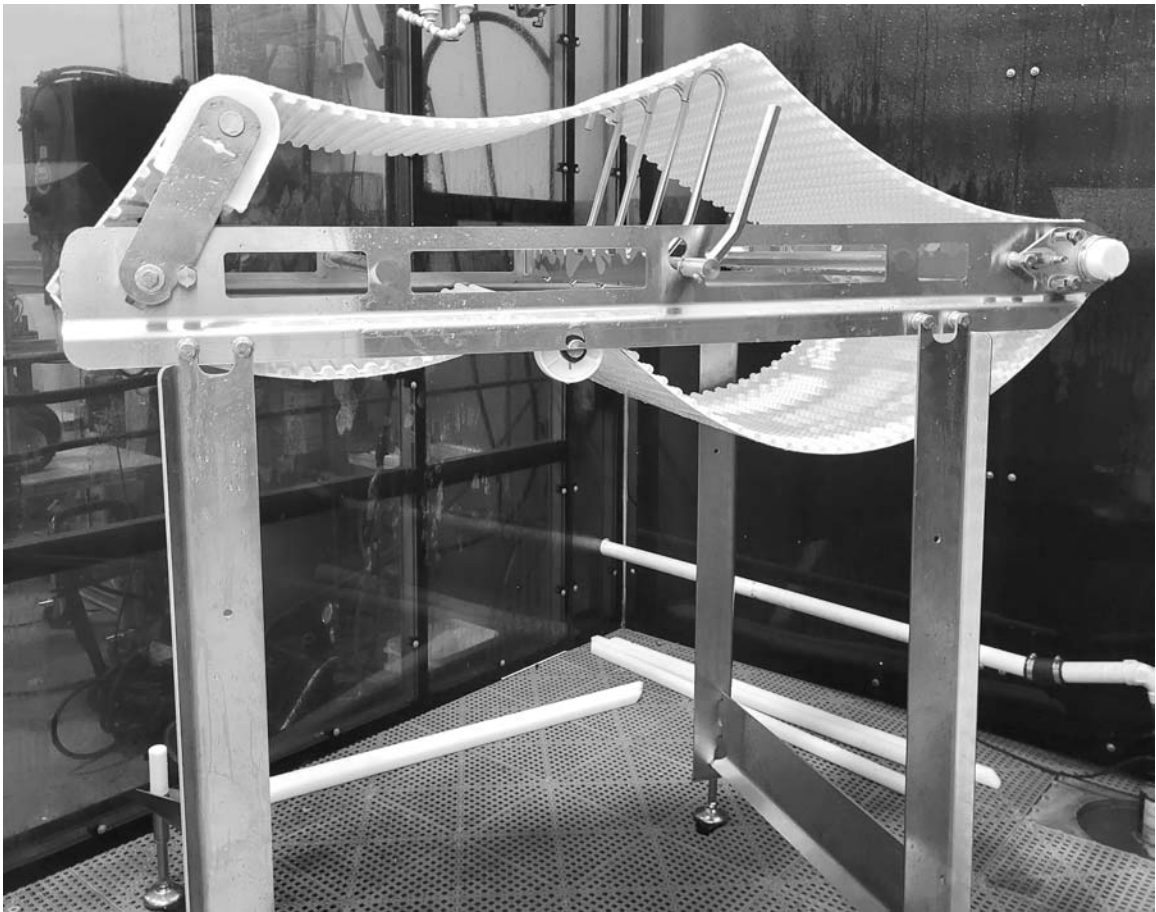




AquaPruf[®] Cleaning Manual

Initial, Daily, and Complete Cleaning Manual



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

Record Conveyor Serial Number Here

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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.

General Description

Basic Conveyor Options

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

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

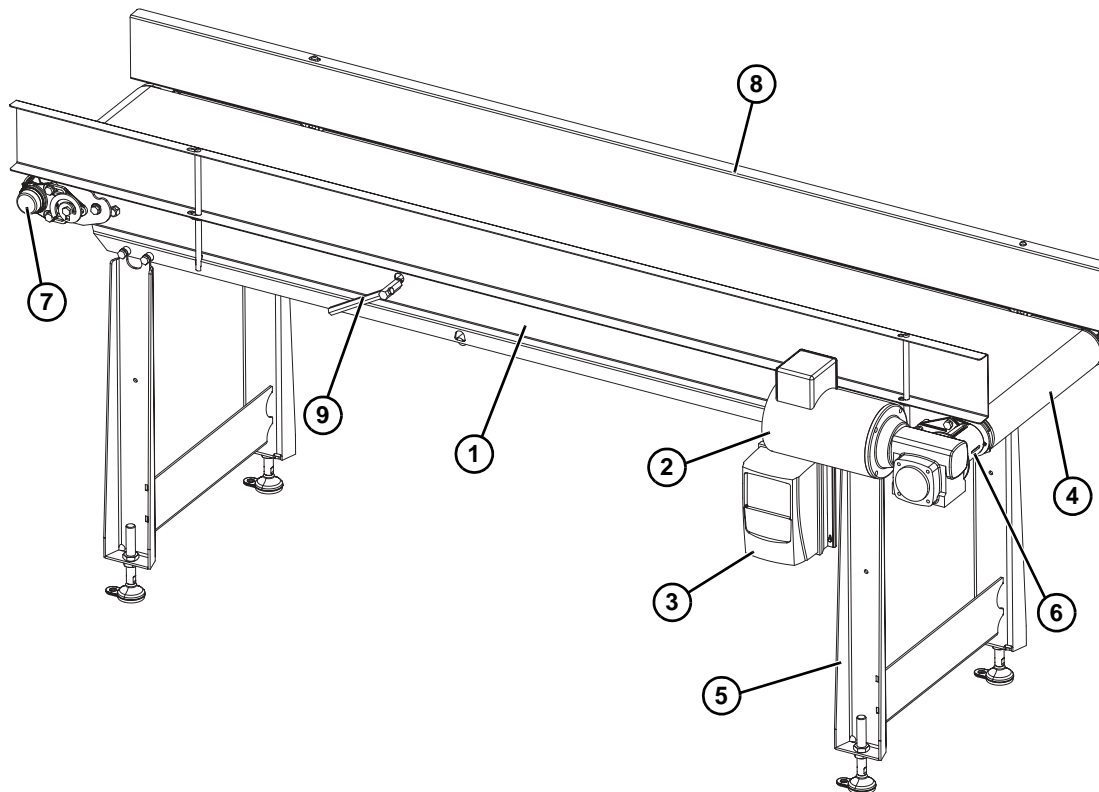


Figure 1

Components Not Capable of Full Wash Down Cleaning

- 13 mm Nose Bar
- 32 mm Nose Bar
- Center Drive Modules
- Flat Belt Types: 01, 02, 03, 05, 06, 08, 09, 56, 57, 58, 59, 60, 61, 63, 64, 66, and 71
- Cleated Belt Types: A, B, C, G, J, K, L, M, U, and V

Important Information

The information contained in this manual is provided only as an aid and service to our customers.

This manual provides initial, daily, and complete cleaning guidelines as suggestions. Please use your company's guidelines and procedures to clean your conveyor.

Warranty

The Dorner Limited Warranty applies.

Improper maintenance or sanitation could void warranty.

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

Limit of Liability

Food safety is the responsibility of the end user.

Chemical Exposure

During the regular cleaning process, operators may be exposed to harmful chemicals. It is the responsibility of the end user to provide proper protective equipment.

Maintenance

Along with regular cleaning, observe regular maintenance cycles.

Acceptable Cleaning Methods

All conveyor applications are unique. Typical cleaning procedures are rinse, clean, rinse, sanitize.

Please follow your company's guidelines and procedures to clean your conveyor.

Typical Conveyor Cleaning Methods

Dorner recommends three types of cleaning methods: initial cleaning, daily cleaning, and complete cleaning.

- For initial cleaning prior to commissioning see **“Initial Cleaning Prior to Commissioning” on page 6.**
- The Daily Cleaning method is recommended in dry food applications only. For daily cleaning see **“Daily Cleaning” on page 7.**
- In applications where a high degree of soilage is present or high risk of bacteria, the Complete Cleaning method may be required on a daily basis. For complete cleaning see **“Complete Cleaning” on page 9.**
- It is recommended that on a weekly basis, the Complete Cleaning method should be followed. For complete cleaning see **“Complete Cleaning” on page 9.**

Disclaimer

Customer is responsible for cleaning regiment. This information is provided only as a helpful guideline.

Initial Cleaning Prior to Commissioning

 **CAUTION**

All product must be completely cleaned prior to being put in service.

Initial Cleaning

Conveyor components and accessories must be cleaned prior to first use. (See “Complete Cleaning” on page 9.)

 **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.

Daily Cleaning

NOTE

Follow the correct cleaning method of rinse, clean, rinse, and sanitize to properly clean and sanitize your conveyor.

⚠ CAUTION

Customer is responsible for cleaning regiment. This information is provided only as a helpful guideline.

NOTE

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

NOTE

Use and follow the instructions provided by your company when using a Clean-Out-of-Place (COP) tank.

⚠ WARNING



SEVERE HAZARD!

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

1. Prior to conveyor shutdown, run conveyor a full belt cycle. Mechanically clean belt surface of debris.
2. Disconnect all power (electric, compressed air, etc.) connected to conveyor.
3. Remove all guiding (**Figure 2, item 1**), if equipped. Place components in COP tank.

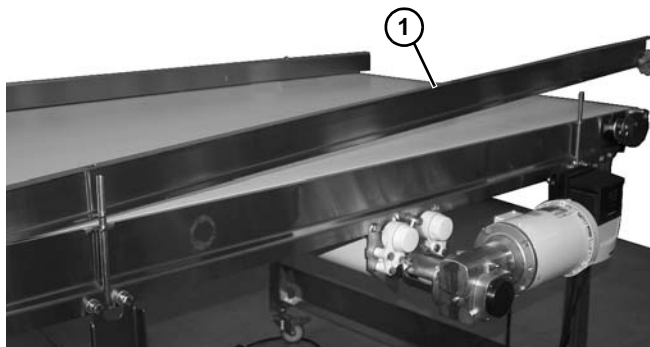


Figure 2

4. Tip up tail (**Figure 3, item 1**) to gain access to inside of conveyor.

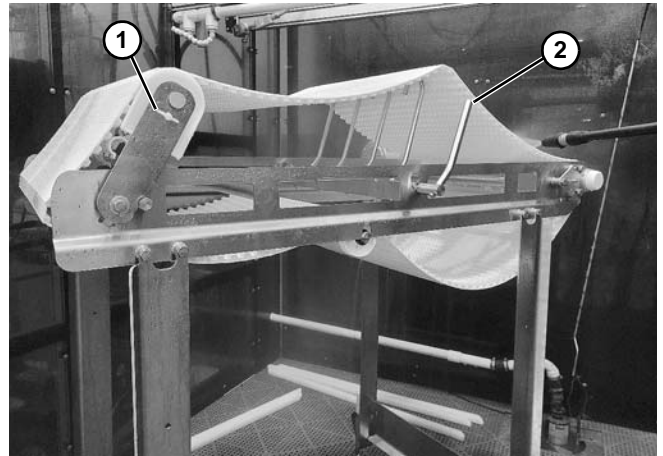


Figure 3

5. Engage belt lifters (**Figure 3, item 2**), if equipped.
6. For Modular Belt Curve conveyor - disengage chain (**Figure 4, item 1**) from curve module.

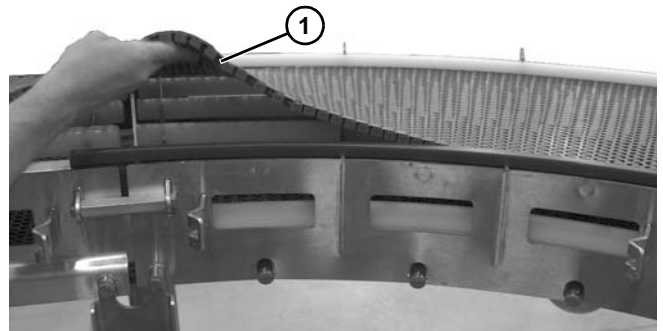


Figure 4

7. Remove belt, if possible.
8. Follow your company's acceptable cleaning method.

NOTE

Low pressure, high volume water cleaning is recommended. Mechanical cleaning with soft brush-type devices is also acceptable.

Daily Cleaning

9. Areas of cleaning focus:

- a. Under belt (**Figure 5, item 1**) and around tail end (**Figure 5, item 2**) idler pucks.

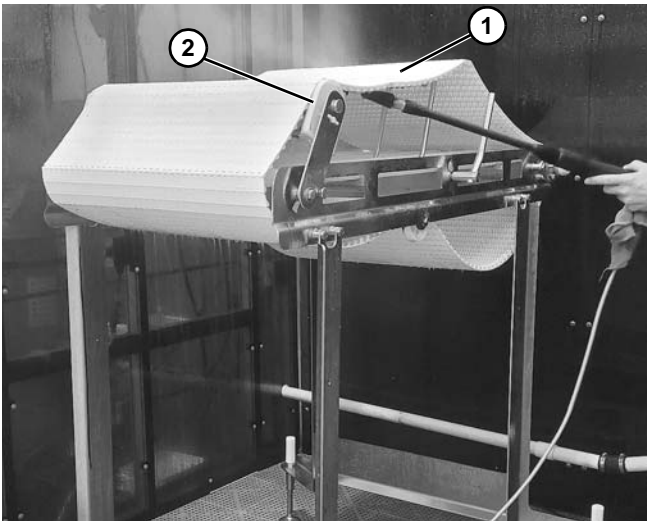


Figure 5

- b. Under belt (**Figure 6, item 1**) and around tail end wear strips (**Figure 6, item 2**).

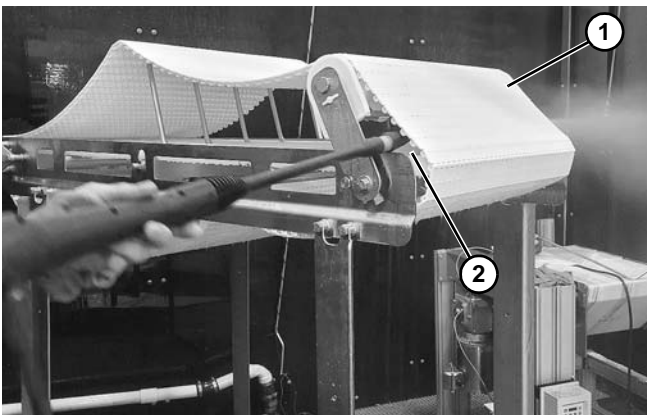


Figure 6

- c. Under belt (**Figure 7, item 1**) and around drive end sprockets (**Figure 7, item 2**).

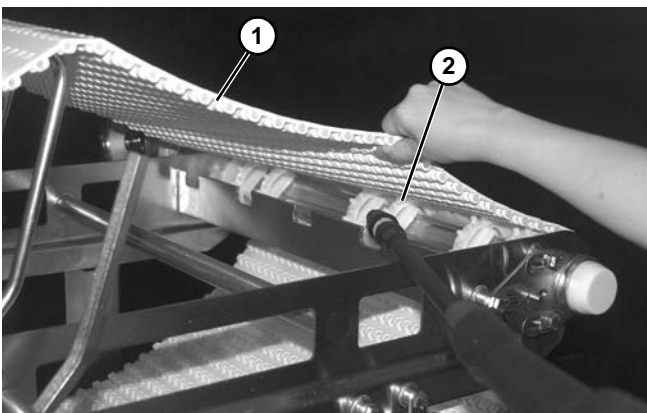


Figure 7

- d. Around the outside of conveyor frame (**Figure 8, item 1**), the outside of the conveyor belt (**Figure 8, item 2**), and belt returns (**Figure 8, item 3**).

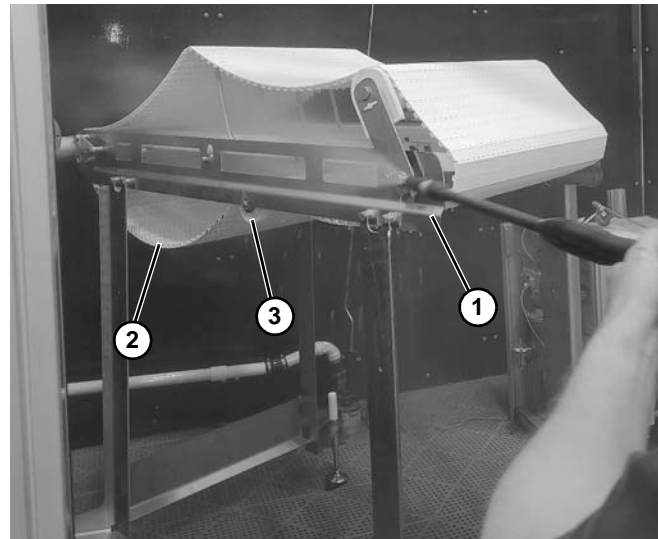


Figure 8

- e. Inside of conveyor frame and belt (**Figure 9, item 1**).

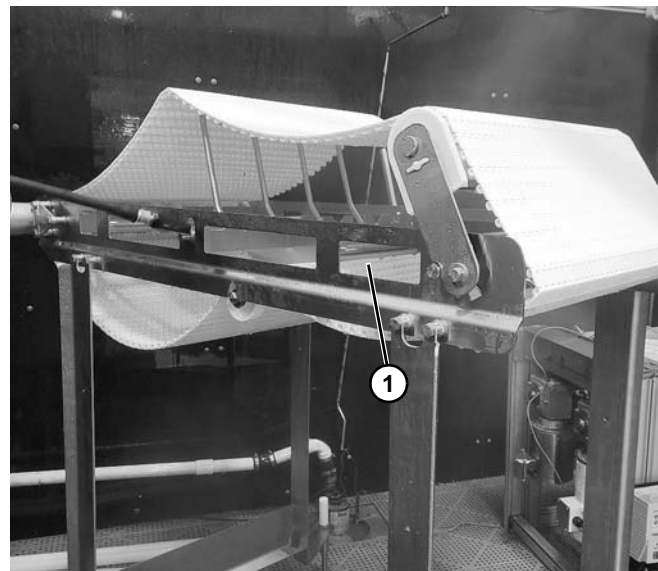


Figure 9

10. Allow conveyor to dry.
11. Reassemble conveyor.
12. Ensure all components are re-installed properly prior to re-starting conveyor, check belt engagement with roller, or chain engagement with sprockets, etc.

Complete Cleaning

NOTE

Follow the correct cleaning method of rinse, clean, rinse, and sanitize to properly clean and sanitize your conveyor.

NOTE

Use and follow the instructions provided by your company when using a Clean-Out-of-Place (COP) tank.

⚠ CAUTION

Customer is responsible for cleaning regiment. This information is provided only as a helpful guideline.

NOTE

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

Prepare for Cleaning

⚠ WARNING



SEVERE HAZARD!

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

1. Prior to conveyor shutdown, run conveyor a full belt cycle. Mechanically clean belt surface of debris.
2. Disconnect all power (electric, compressed air, etc.) connected to conveyor.
3. Remove all guiding (**Figure 10, item 1**), if equipped.

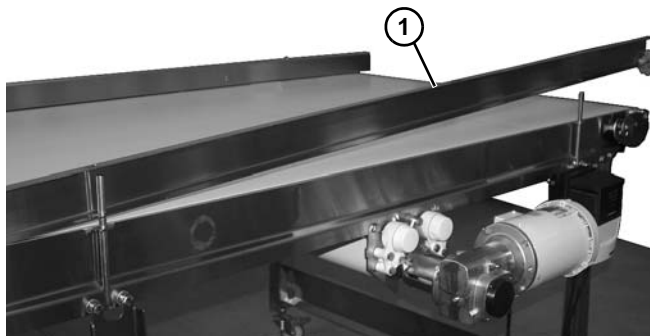


Figure 10

4. Tip up tail (**Figure 11, item 1**) to gain access to inside of conveyor.

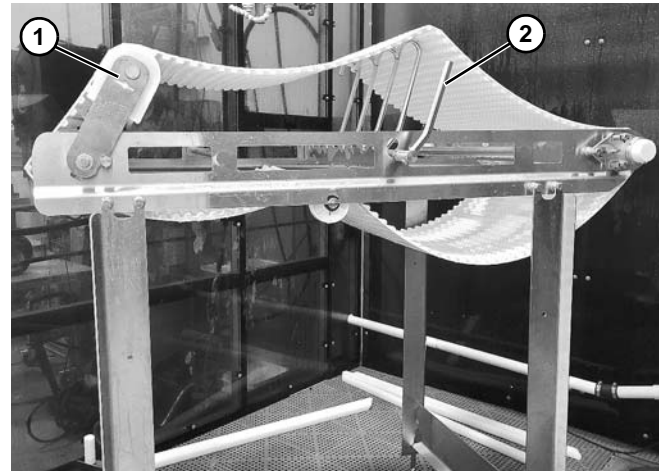


Figure 11

5. Engage belt lifters (**Figure 11, item 2**), if equipped.
6. If desired, the gearmotor can be removed from the conveyor by use of the Quick Disconnect mount:

⚠ WARNING



CRUSH HAZARD!

- **SUPPORT MOTOR PRIOR TO LOOSENING THE BOLTS**
- **Loosening motor bolts may cause it to drop down, causing serious injury.**

- a. Loosen four screws securing gear reducer to motor mount (**Figure 12**).



Figure 12

Complete Cleaning

- b. Rotate and remove gearmotor and gear reducer assembly from motor mount (**Figure 13**).

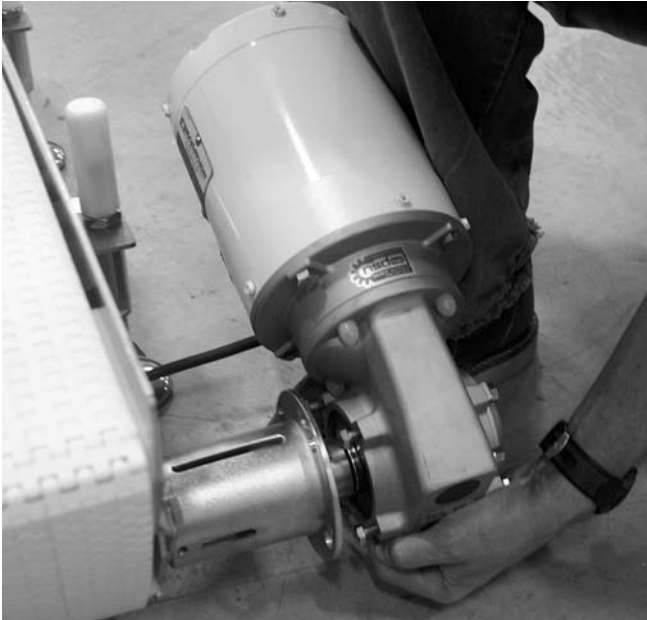


Figure 13

- 7. Remove belt returns (**Figure 14**) or (**Figure 15**). Disassemble belt returns. (For detailed instructions, see your conveyor manual.) Place components in COP tank.

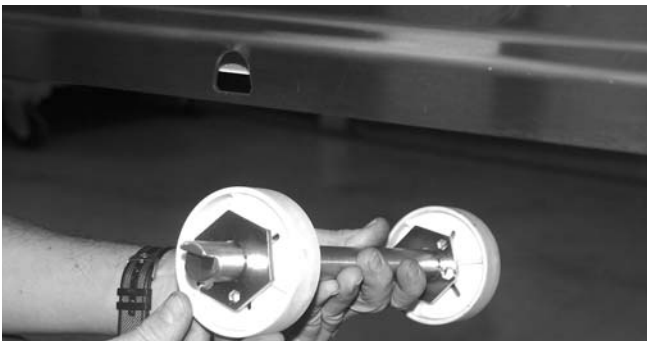


Figure 14



Figure 15

- 8. For Modular Belt Curve conveyor - disengage chain (**Figure 16, item 1**) from curve module.

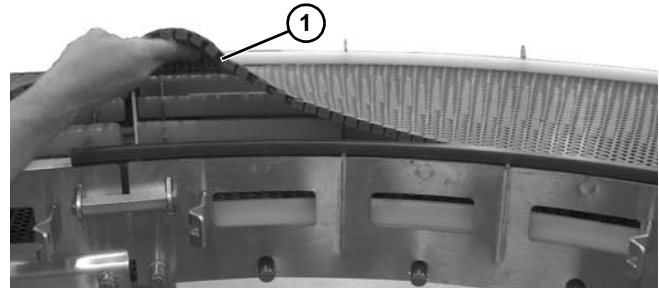


Figure 16

Belted Conveyor Cleaning

NOTE

*If cleaning on a daily basis, Dorner recommends using a plastic clipper splice on the conveyor for quick removal of belts (**Figure 17**).*



Figure 17

Removal and Installation References

For detailed instructions for removing and installing belted conveyor components, use the following as a guide.

- **Scraper:** For detailed instructions, see “Scraper Replacement” in Preventative Maintenance and Adjustment in manual number 851-943.
- **Belt:** For detailed instructions, see “End Drive Conveyor Belt Replacement” in Preventative Maintenance and Adjustment in manual number 851-943.
- **Wear Strips:** For detailed instructions, see “Wear Strips” in Preventative Maintenance and Adjustment in manual number 851-943.
- **Standard Idler Tail:** For detailed instructions, see “Idler Spindle Replacement” in Preventative Maintenance and Adjustment in manual number 851-943.
- **Nose Bar Idler Tail:** For detailed instructions, see “Nose Bar Spindle Replacement” in Preventative Maintenance and Adjustment in manual number 851-943.
- **Standard End Drive Tail:** For detailed instructions, see “End Drive Spindle Replacement” in Preventative Maintenance and Adjustment in manual number 851-943.
- **Upper and Lower Knuckles:** For detailed instructions, see “Knuckle Maintenance” in Preventative Maintenance and Adjustment in manual number 851-943.

Belted Conveyor Complete Cleaning

1. If equipped, remove scraper blade (**Figure 18, item 3**) and scraper bar posts (**Figure 18, item 1**) from scraper shaft (**Figure 18, item 2**).

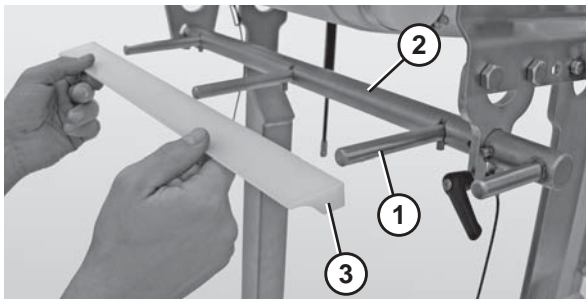


Figure 18

2. Place scraper and support posts in COP tank (**Figure 19**).

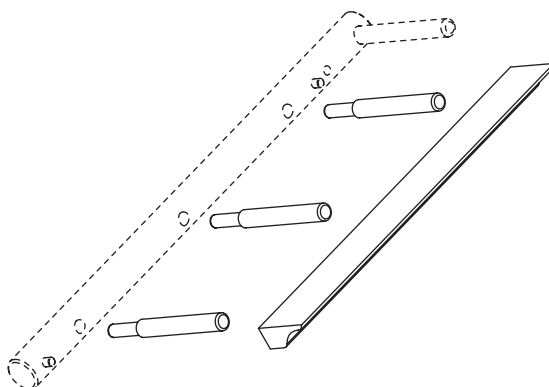


Figure 19

3. Tip up idler tail (**Figure 20, item 1**).

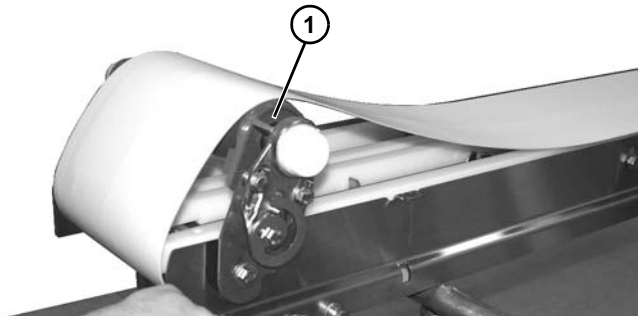


Figure 20

4. Engage belt lifters (if equipped) (**Figure 21**).



Figure 21

5. Remove wear strips (**Figure 22, item 1**).

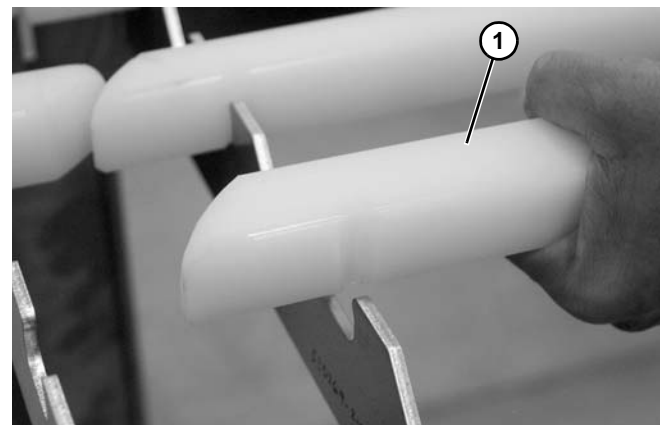


Figure 22

Complete Cleaning

- Place wear strips (**Figure 23**) in COP tank.

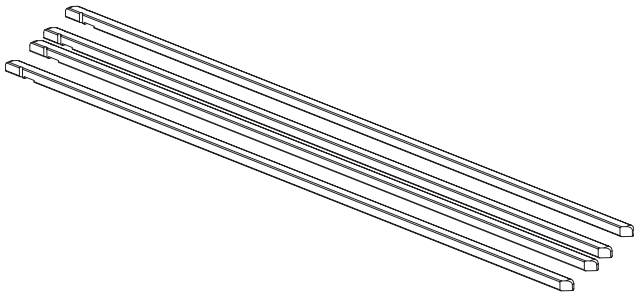


Figure 23

- Lower Knuckle (LPZ Conveyors) (If Equipped): Remove pull pin (**Figure 24, item 1**) and roller guard (**Figure 24, item 2**) on each side of conveyor on lower knuckle plate. Place roller guard in COP tank.

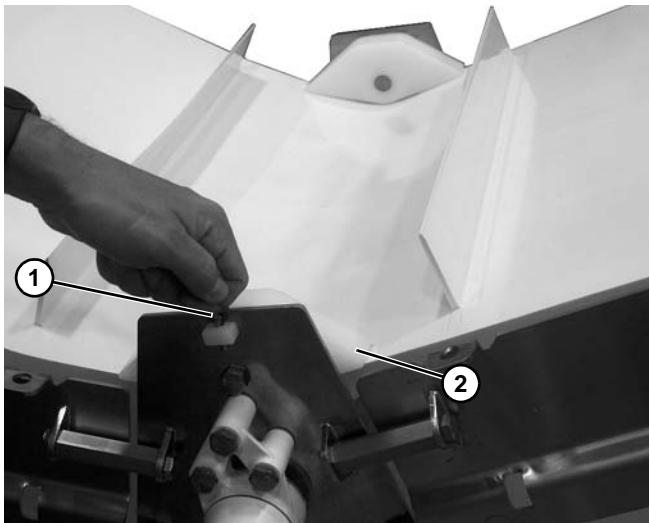


Figure 24

- Upper Knuckle (LPZ Conveyors) (If Equipped): Remove pull pin (**Figure 25, item 1**) securing roller guard (**Figure 25, item 2**) on each side of conveyor on upper knuckle plate. Place roller guard in COP tank.

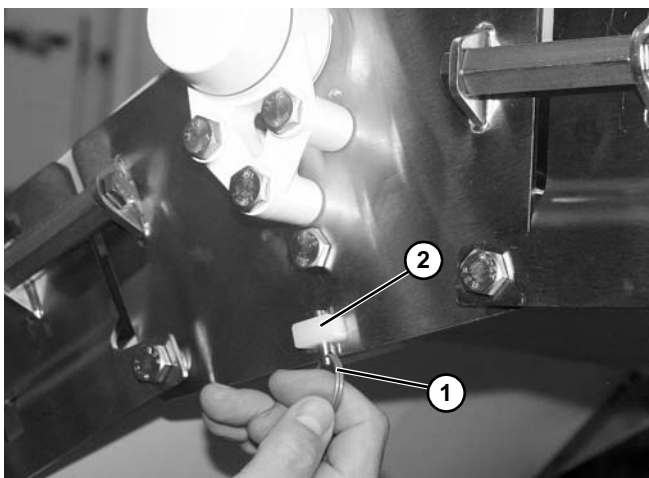


Figure 25

- Follow your company's acceptable cleaning method.

NOTE

Low pressure, high volume water cleaning is recommended. Mechanical cleaning with soft brush-type devices is also acceptable.

- Clean under belt.
- Slide belt to one side of the conveyor and clean (**Figure 26**). Slide belt to the other side of conveyor and clean.



Figure 26

- Clean tails.
 - Follow your company's acceptable cleaning method.

NOTE

Low pressure, high volume water cleaning is recommended. Mechanical cleaning with soft brush-type devices is also acceptable.

- Idler End: Clean spindle (**Figure 27, item 1**). Make sure to clean around pinch guards (**Figure 27, item 2**).

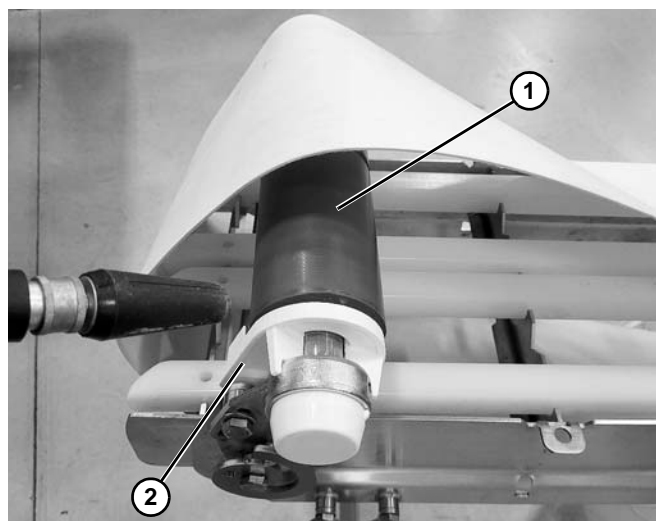


Figure 27

Complete Cleaning

- c. Drive Tail: Clean drive spindle (**Figure 28, item 1**). Make sure to clean around spindle guards (**Figure 28, item 2**).

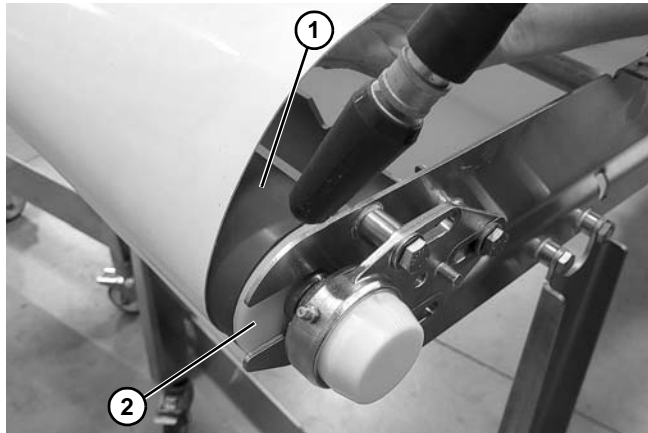


Figure 28

13. Assemble and install components reverse of removal. (If needed, see “**Removal and Installation References**” on page 11.)
14. Install belt returns.
15. Install guiding, if equipped.
16. Install gearmotor (if removed).
17. Verify belt tension and tracking. Adjust, if necessary.

Modular Belt Conveyor Cleaning

Removal and Installation References

For detailed instructions for removing modular belt conveyor components, use the following as a guide.

- **Belt**: For detailed instructions, see “Conveyor Belt Replacement” in Preventative Maintenance and Adjustment in manual number 851-944 or 851-945.
- **Wear Strips**: For detailed instructions, see “Wear Strips” in Preventative Maintenance and Adjustment in manual number 851-944 or 851-945.
- **Standard Idler Tail**: For detailed instructions, see “Idler Puck and Spindle Replacement” in Preventative Maintenance and Adjustment in manual number 851-944 or 851-945.
- **Nose Bar Idler Tail**: For detailed instructions, see “Nose Bar Idler Puck Replacement” in Preventative Maintenance and Adjustment in manual number 851-944.
- **Standard End Drive Tail**: For detailed instructions, see “Drive Replacement” in Preventative Maintenance and Adjustment in manual number 851-944, or “Drive Sprocket and Spindle Replacement” in Preventative Maintenance and Adjustment in manual number 851-945.
- **Nose Bar Drive Tail**: For detailed instructions, see “Nose Bar Idler Puck and Drive Sprocket Replacement” in Preventative Maintenance and Adjustment in manual number 851-944.
- **Upper and Lower Knuckles**: For detailed instructions, see “Knuckle Maintenance” in Preventative Maintenance and Adjustment in manual number 851-944.

Modular Belt Conveyor Complete Cleaning

1. Tip up idler tail (**Figure 29, item 1**).

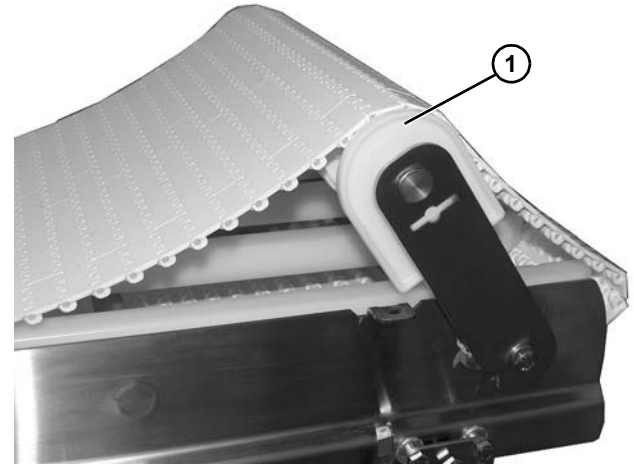


Figure 29

2. Separate belt by using a punch and hammer to push the belt rod out by striking the rod end opposite the retaining head (**Figure 30**).



Figure 30

3. Remove belt (**Figure 31, item 1**) and place in COP tank.

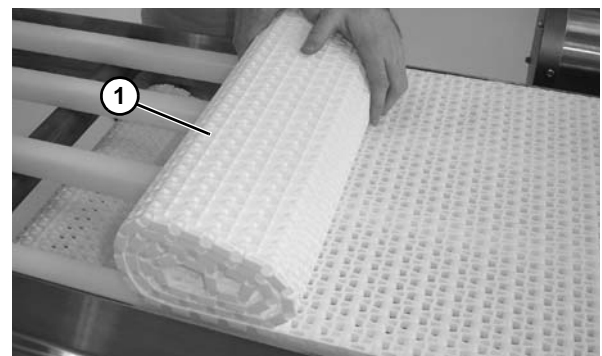


Figure 31

Complete Cleaning

4. Remove belt lifters (if equipped):

- Locate belt lifter arms (**Figure 32, item 1**). Note orientation and location of belt lifter arms on lifter bar and conveyor frame (for reassembly).

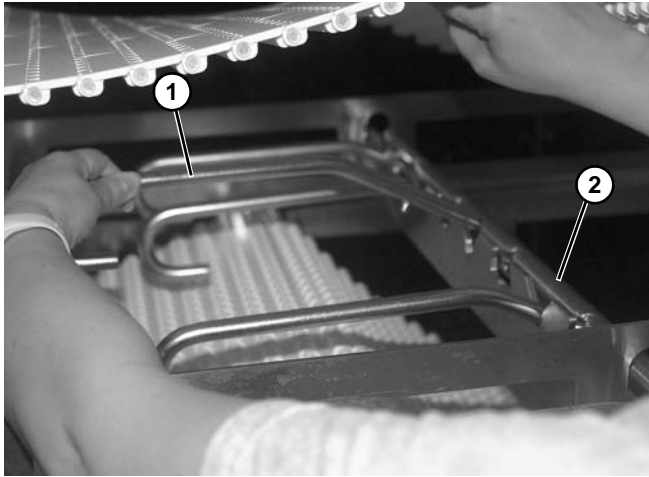


Figure 32

- Remove each belt lifter arm (**Figure 32, item 1**) from lifter bar (**Figure 32, item 2**).
- Place belt lifter arms (**Figure 33, item 1**) in COP tank.

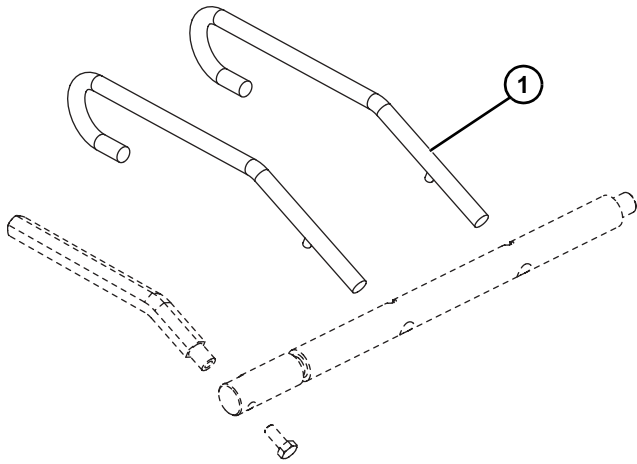


Figure 33

5. Remove wearstrips (**Figure 34, item 1**).

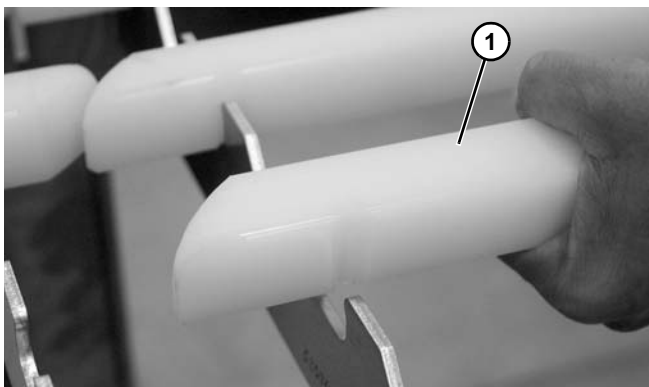


Figure 34

6. Place wear strips (**Figure 35**) in COP tank.

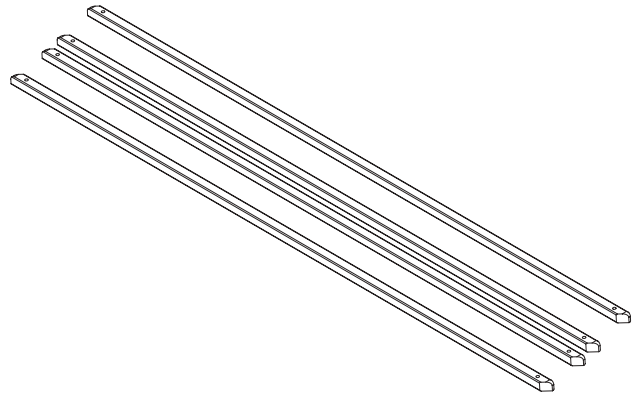


Figure 35

7. Clean tails.

- a. Follow your company's acceptable cleaning method.

NOTE

Low pressure, high volume water cleaning is recommended. Mechanical cleaning with soft brush-type devices is also acceptable.

- b. **Idler End:** Clean idler tail and pucks, disengage puck spacers (**Figure 36, item 1**), slide idler pucks (**Figure 37, item 1**), and clean again.

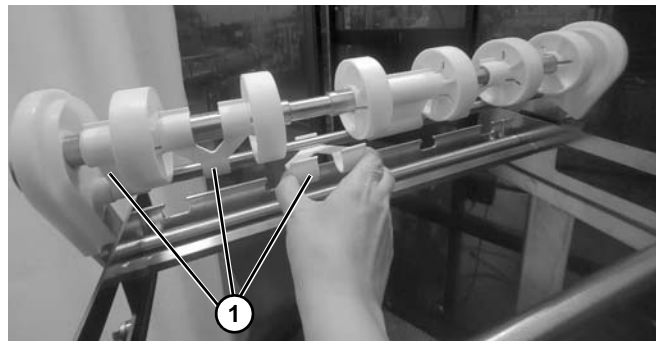


Figure 36

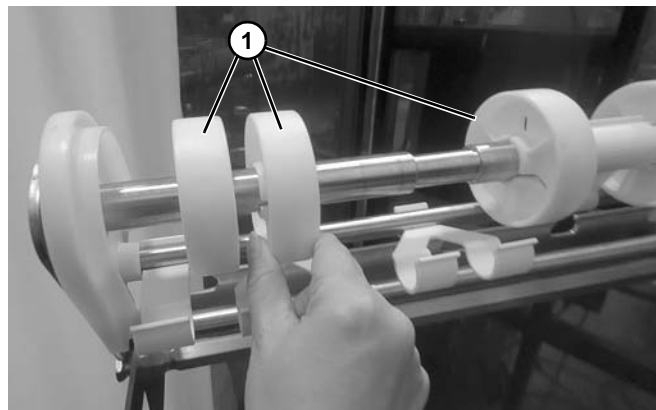


Figure 37

Complete Cleaning

- c. Nose Bar Idler End: Remove nose bar return strip (**Figure 38, item 1**) and place in COP tank. Clean tail, slide nose bar pucks (**Figure 38, item 2**), and clean again.

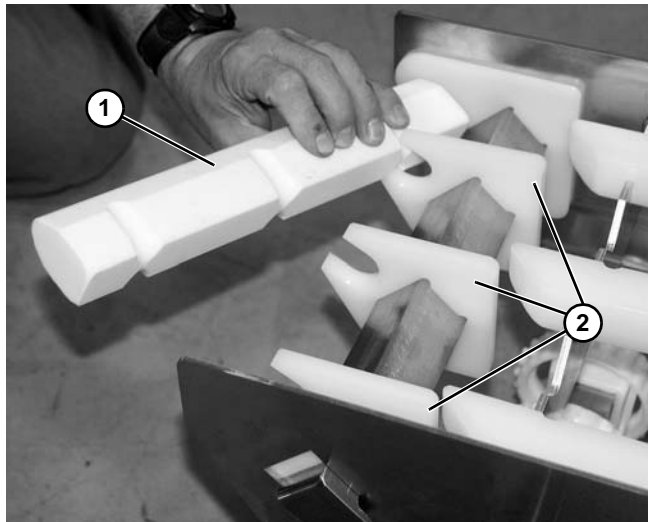


Figure 38

- d. Drive Tail: Clean drive sprocket and tail (**Figure 39**). To disengage, push down on sprocket alignment key (**Figure 40, item 1**) while sliding sprocket (**Figure 40, item 2**) out of tab. Repeat procedure to clean remaining sprockets (**Figure 41, item 1**).

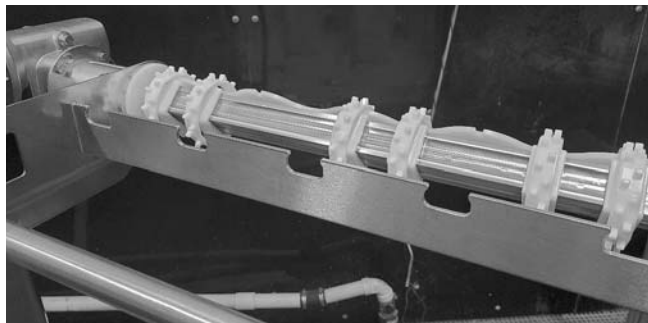


Figure 39

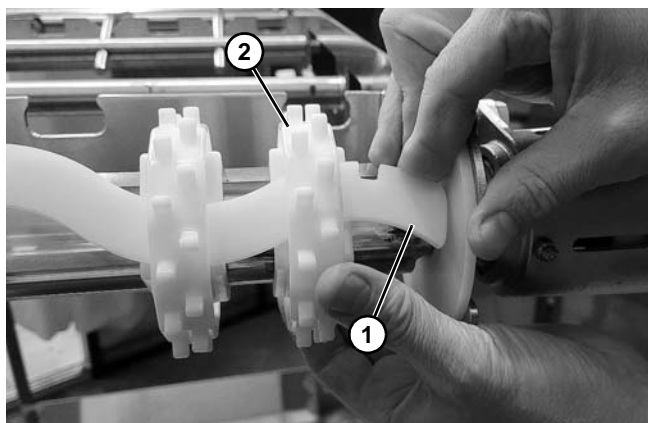


Figure 40

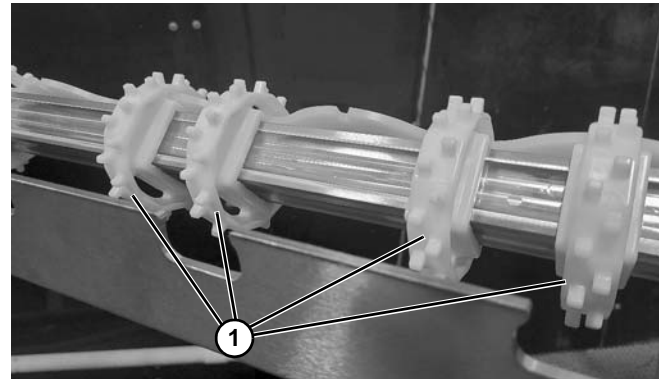


Figure 41

- e. Nose Bar Drive Tail: Remove nose bar return strip (**Figure 42, item 1**) and place in COP tank. Clean nose bar components, slide nose bar pucks (**Figure 42, item 2**), and clean again. Clean drive sprockets (**Figure 43, item 1**) and module, disengage sprocket alignment key (**Figure 43, item 2**), slide sprockets, and clean again.

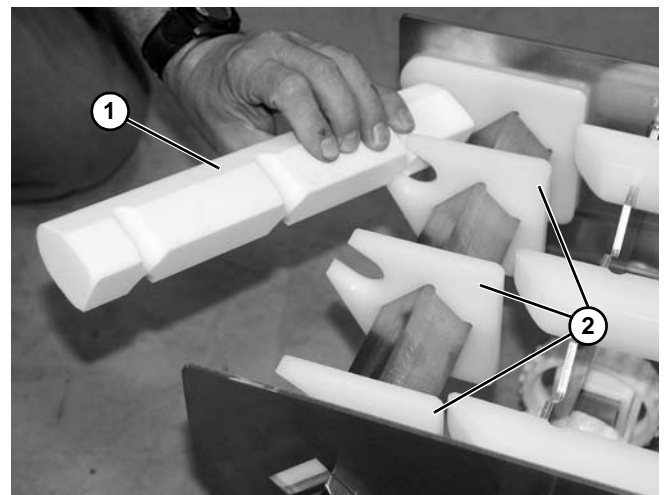


Figure 42

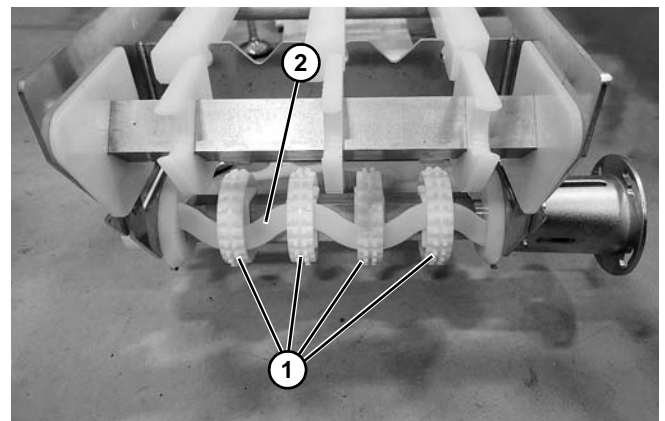


Figure 43

Complete Cleaning

8. Lower Knuckle (LPZ Conveyors) (If Equipped): Remove pull pin (**Figure 44, item 1**) and return shoe (**Figure 44, item 2**) on each side of conveyor on lower knuckle plate. Place in COP tank. Pull out on retaining bar (**Figure 45, item 1**) on the side of the lower knuckle. While pulling out bar, remove the lower knuckle wear guides (**Figure 45, item 2**) from notches (**Figure 45, item 3**) on bracket of knuckle. Place wear guides in COP tank.

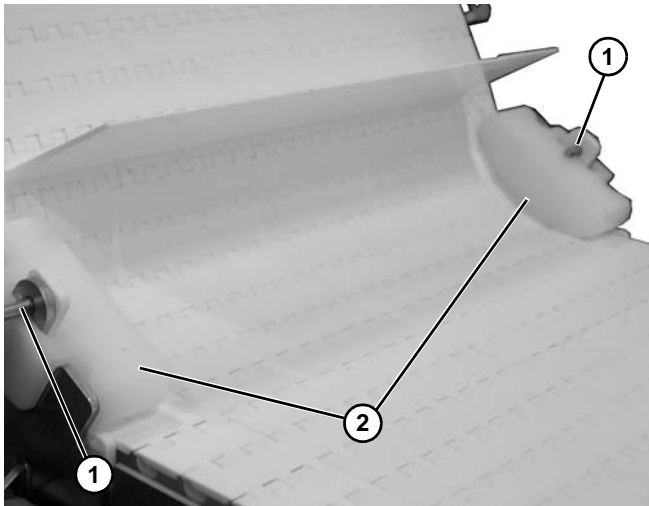


Figure 44

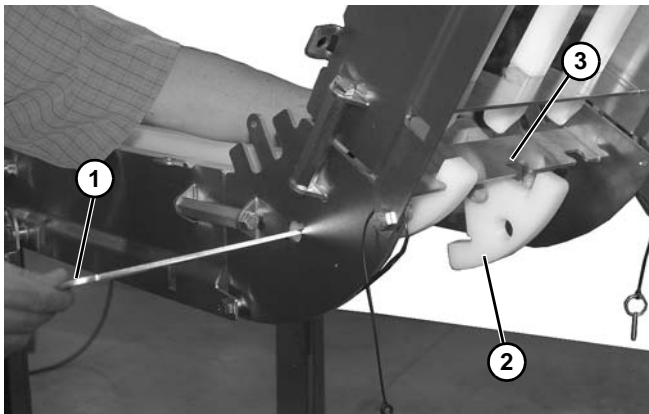


Figure 45

9. Upper Knuckle (LPZ Conveyors) (If Equipped): Remove pull pin, return shoe (**Figure 46, item 1**), and knuckle guide (**Figure 46, item 2**) on each side of conveyor on upper knuckle plate. Place in COP tank. Remove the upper knuckle wear bars (**Figure 47, item 1**) from notches (**Figure 47, item 2**) on bracket of upper knuckle. Place wear bars in COP tank.

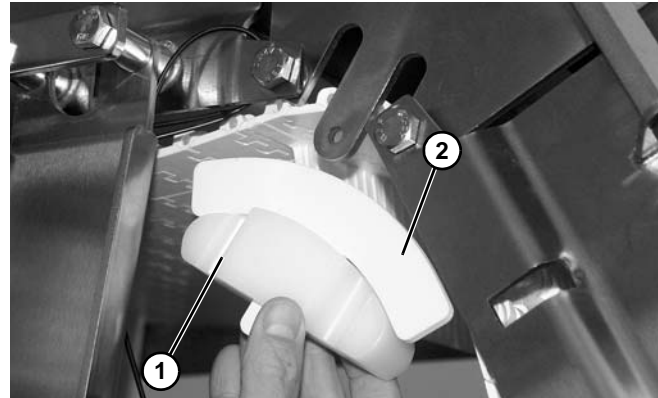


Figure 46

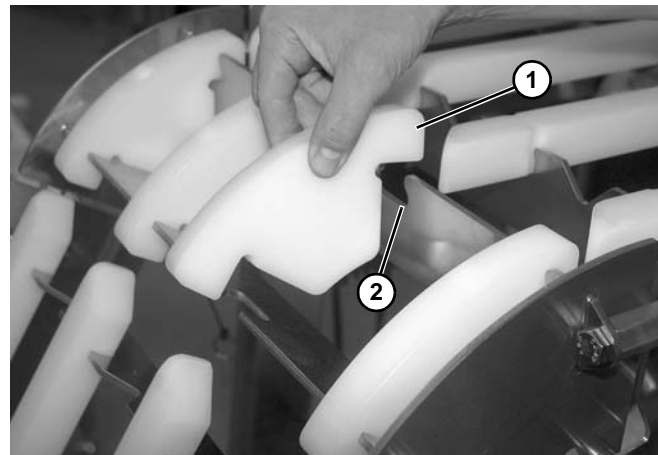


Figure 47

10. Clean conveyor components, making sure to clean tails thoroughly.
11. Assemble and install components reverse of removal. (If needed, see **“Removal and Installation References” on page 13.**)
12. Install belt returns.
13. Install guiding, if equipped.
14. Install gearmotor (if removed).
15. Verify belt tension and tracking. Adjust, if necessary.

Positive Drive Conveyor Cleaning

Removal and Installation References

For detailed instructions for removing positive drive conveyor components, use the following as a guide.

- **Belt:** For detailed instructions, see “Conveyor Belt Replacement” in Preventative Maintenance and Adjustment in manual number 851-946.
- **Wear Strips and Belt Guides:** For detailed instructions, see “Wear Strips and Belt Guides” in Preventative Maintenance and Adjustment in manual number 851-946.
- **Idler Tail:** For detailed instructions, see “Idler Puck and Spindle Replacement” in Preventative Maintenance and Adjustment in manual number 851-946.
- **Drive Tail:** For detailed instructions, see “Drive Replacement” in Preventative Maintenance and Adjustment in manual number 851-946.

Positive Drive Conveyor Complete Cleaning

1. Tip up idler tail (**Figure 48, item 1**).

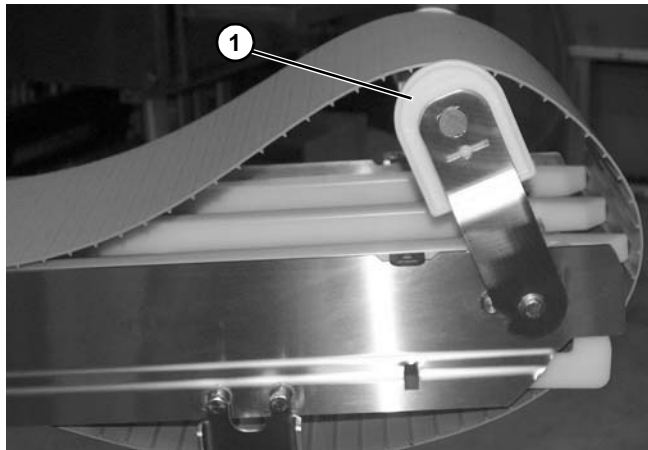


Figure 48

2. Engage belt lifters (if equipped) (**Figure 49**).



Figure 49

3. Remove wearstrips (**Figure 50, item 1**).

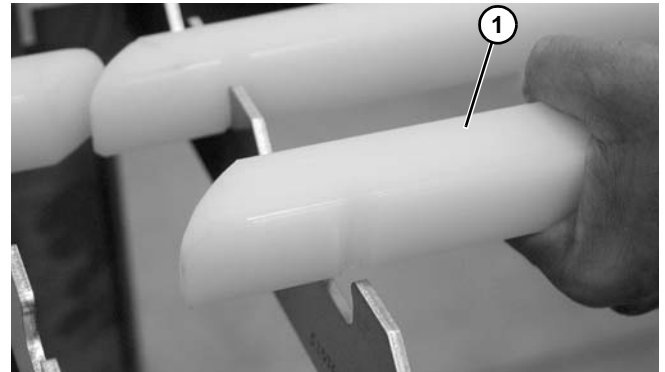


Figure 50

4. Remove drive tail belt guide (**Figure 51, item 1**) from the frame rail. Repeat on opposite side.

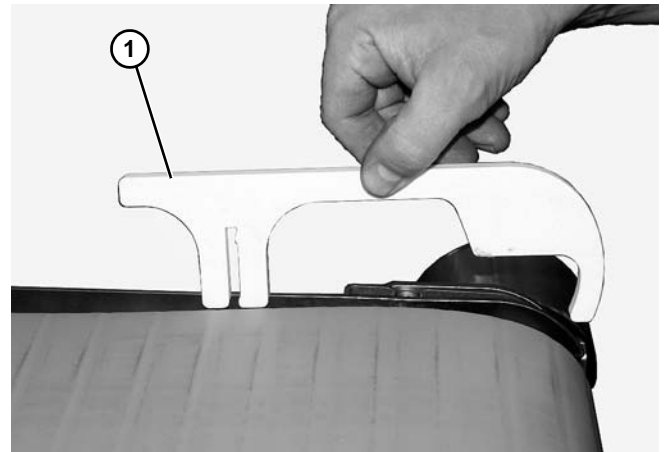


Figure 51

5. Remove two idler tail return guides (**Figure 52, item 1**).

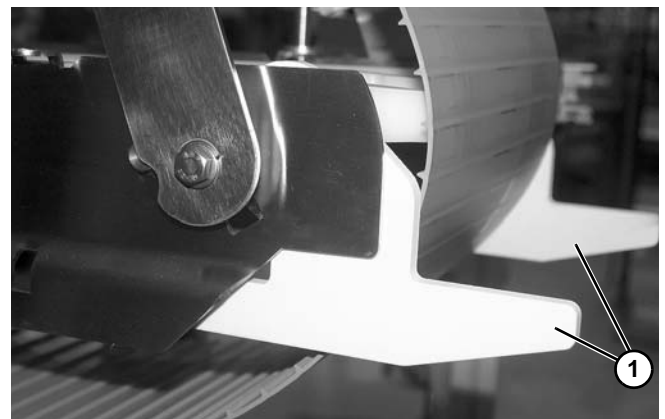


Figure 52

Complete Cleaning

- Place wearstrips, drive tail belt guides, and idler tail return guides (**Figure 53**) in COP tank.

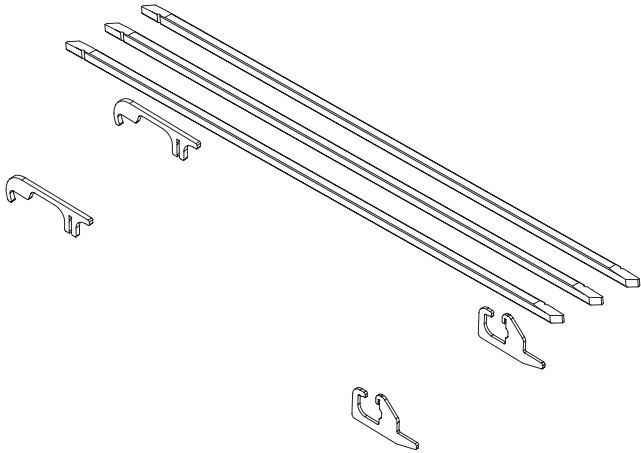


Figure 53

- Slide belt to one side of the conveyor and clean (**Figure 54**). Slide belt to the other side of conveyor and clean.

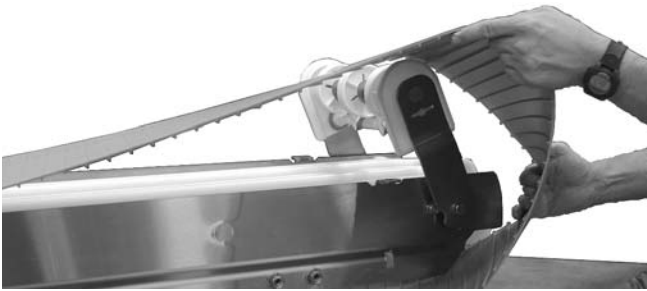


Figure 54

- Clean tails.
 - Follow your company's acceptable cleaning method.

NOTE

Low pressure, high volume water cleaning is recommended. Mechanical cleaning with soft brush-type devices is also acceptable.

- Idler End:** Clean idler tail and pucks, disengage puck spacers (**Figure 55, item 1**), slide idler pucks (**Figure 56, item 1**), and clean again. (**NOTE:** Belt shown removed in images for idler end and drive tail for clarity only.)

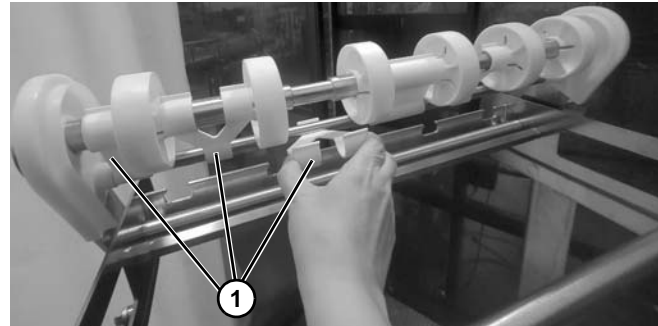


Figure 55

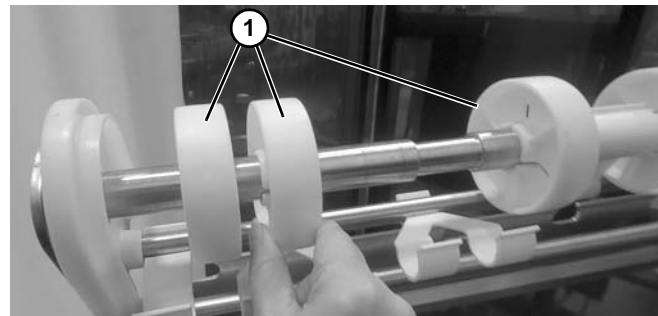


Figure 56

Complete Cleaning

- c. Drive Tail: Remove limiter bar (**Figure 57, item 1**) and place in COP tank. Clean drive sprocket and tail (**Figure 58**). To disengage, push down on sprocket alignment key (**Figure 59, item 1**) while sliding sprocket (**Figure 59, item 2**) out of tab. Repeat procedure to clean remaining sprockets (**Figure 60, item 1**).

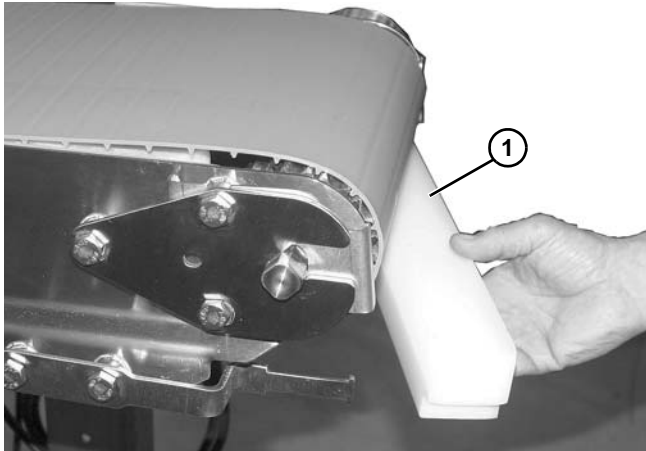


Figure 57

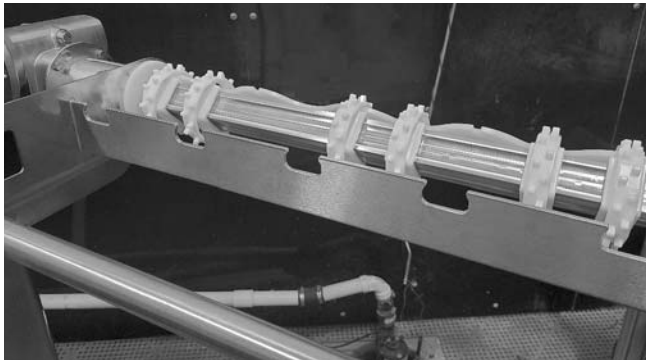


Figure 58

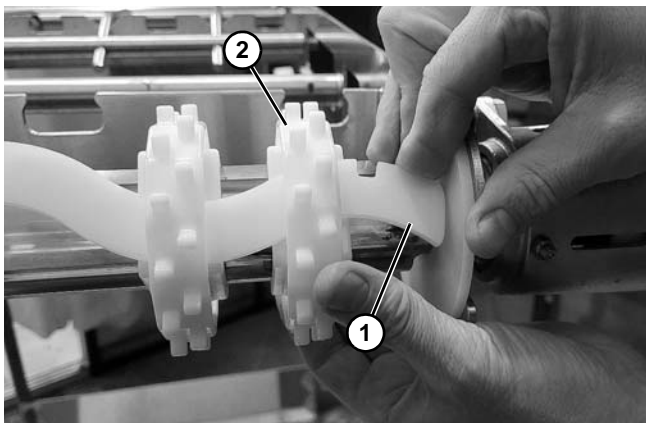


Figure 59

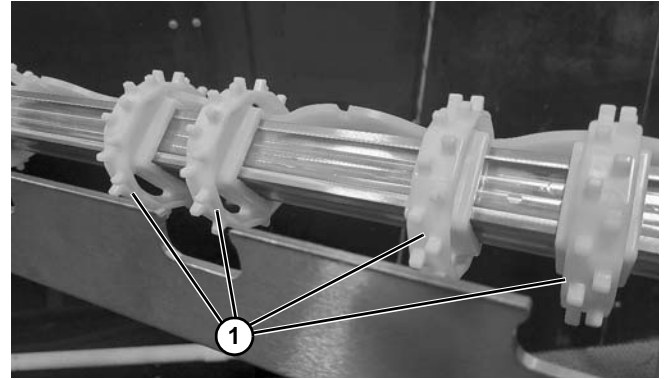


Figure 60

9. Clean under belt, making sure to clean tails thoroughly.
10. Assemble and install components reverse of removal. (If needed, see “**Removal and Installation References**” on page 17.)
11. Install belt returns.
12. Install guiding, if equipped.
13. Install gearmotor (if removed).
14. Verify belt tension and tracking. Adjust, if necessary.

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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