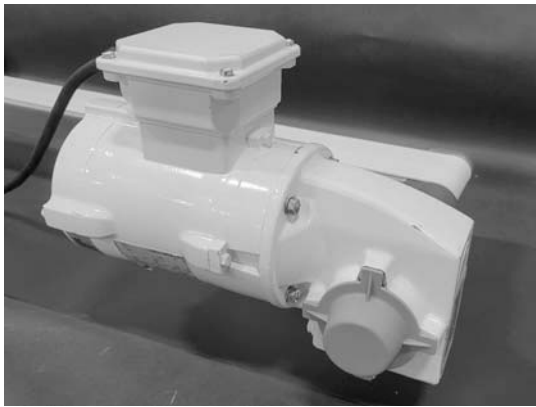
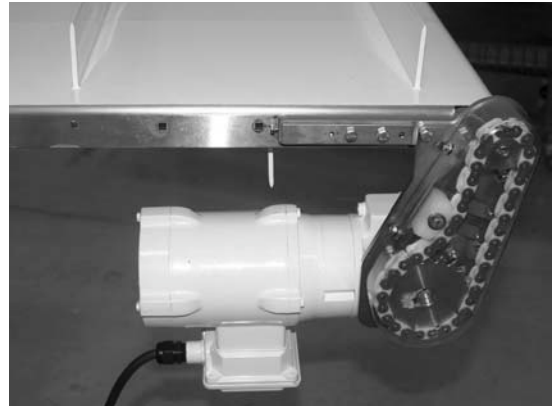


AquaGard[®] LP Gearmotor Mounting Packages

Installation, Maintenance & Parts Manual



Side 90°



Bottom 90°



Bottom Parallel Shaft

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

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




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

⚠ WARNING




Gearmotors may be HOT.
DO NOT TOUCH Gearmotors.

⚠ WARNING



Exposed moving parts can cause severe injury.
REPLACE ALL GUARDS BEFORE RUNNING CONVEYOR.

⚠ 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.

Product Description

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

1	Mounting Plate
2	Gearmotor
3	Motor Control

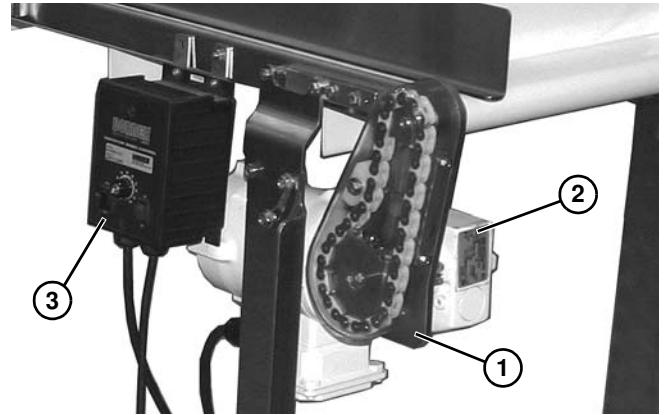
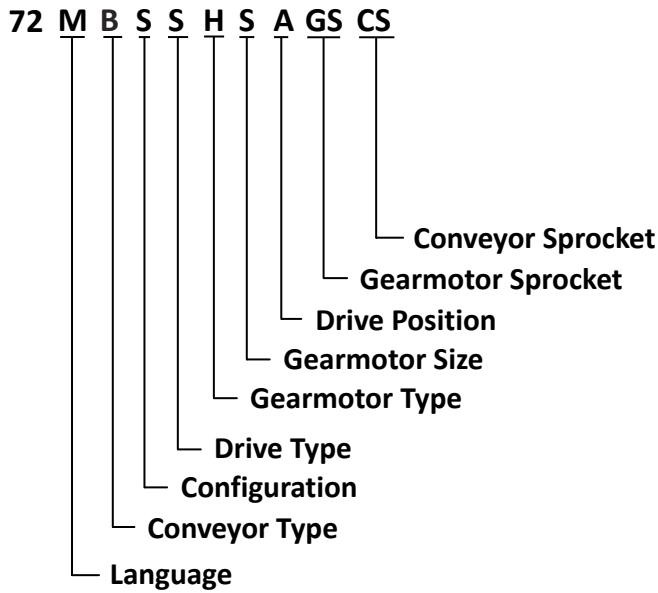


Figure 1

Specifications

Gearmotor Mounting Package



Fastener Torque Specifications

	Hex Head		Set Screw	
	Hex Size	Torque	Hex Size	Torque
M3 x 0.5	5.5 mm	0.9 Nm (8 in lbs)	2 mm	0.2 Nm (1.7 in lbs)
M4 x 0.7	7 mm	2.3 Nm (20 in lbs)	2 mm	0.7 Nm (6 in lbs)
M5 x 0.8	8 mm	4.6 Nm (40 in lbs)	2.5 mm	1.5 Nm (13 in lbs)
M6 x 1.0	10 mm	7.8 Nm (69 in lbs)	3 mm	2.5 Nm (22 in lbs)
M8 x 1.25	13 mm	19.0 Nm (169 in lbs)	4 mm	6.0 Nm (53 in lbs)
M10 x 1.5	16 mm	38.0 Nm (335 in lbs)	5 mm	12.0 Nm (106 in lbs)

Dorner recommends FDA approved grease on all threaded stainless steel fasteners.

Installation

Drive Package Types

Identify your drive package type:

- Side Drive Package
- Bottom 90° Drive Package
- Bottom Parallel Shaft Drive Package

Side Drive Package

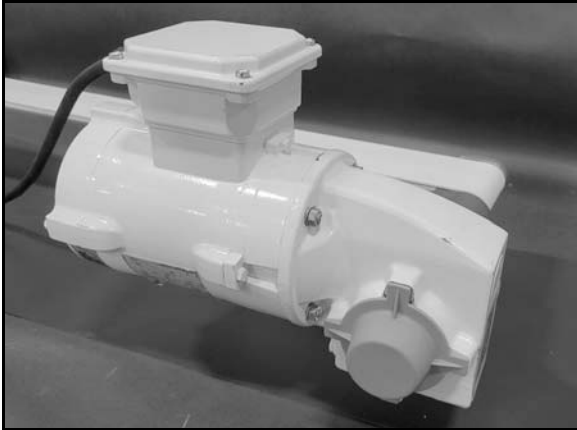


Figure 2

Typical Side Drive Package Components (Figure 3).

1	Side Mounting
2	Coupling
3	Gearmotor
4	Screw (2x)
5	Guard

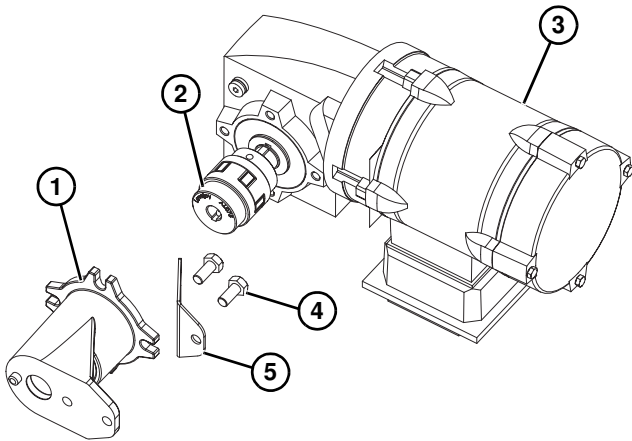


Figure 3

NOTE

Gearmotor may be operated in positions 1 through 4 (Figure 4).

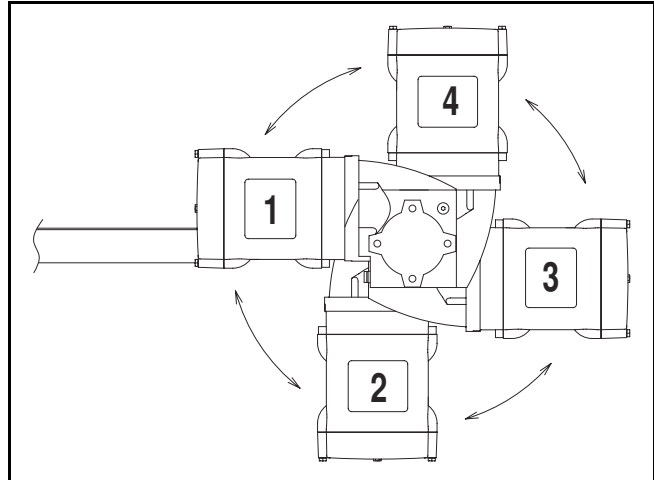


Figure 4

Bottom 90° Drive Package

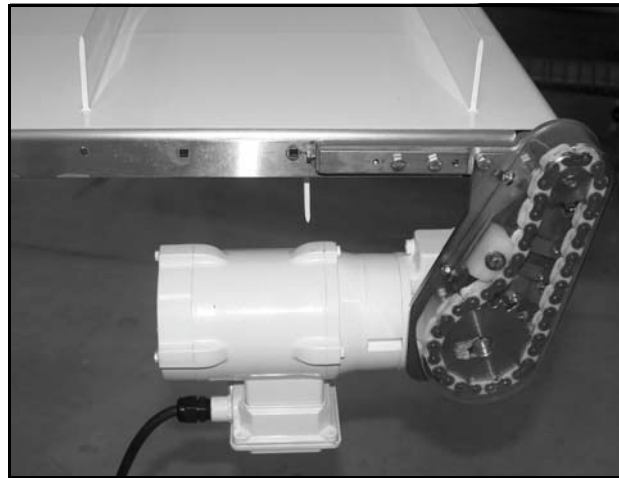


Figure 5

Typical Bottom 90° Drive Package components (Figure 6).

1	Cover
2	Screw (2x)
3	Mounting Plate
4	Gearmotor
5	Key
6	Screw and Washer (4x)
7	Driven Pulley
8	Drive Pulley
9	Timing Belt
10	Screw (x4)

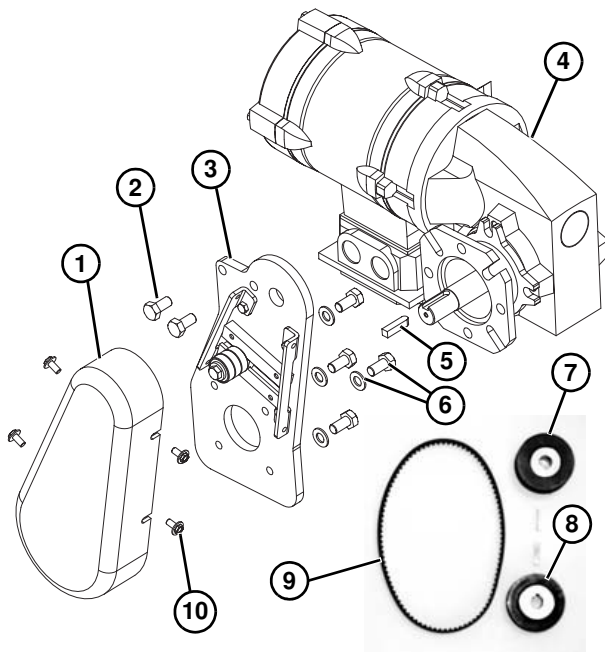


Figure 6

NOTE

Gearmotor may be operated in positions 1 through 3 (Figure 7).

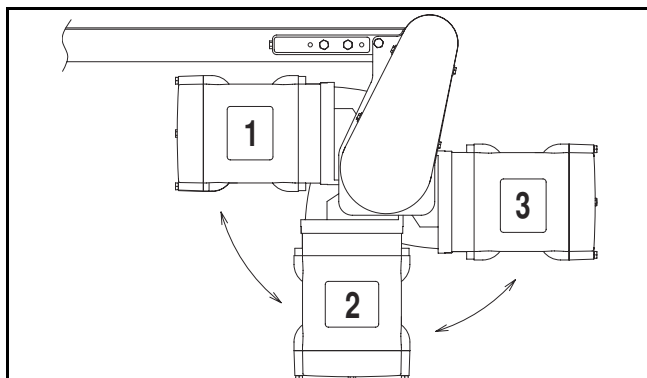


Figure 7

Bottom Parallel Shaft Drive Package



Figure 8

Typical Bottom Parallel Shaft Drive Package Components (Figure 9).

1	Cover
2	Screw (2x)
3	Mounting Plate
4	Gearmotor
5	Screw (4x)
6	Washer (4x)
7	Driven Pulley
8	Drive Pulley
9	Timing Belt
10	Screw (x4)

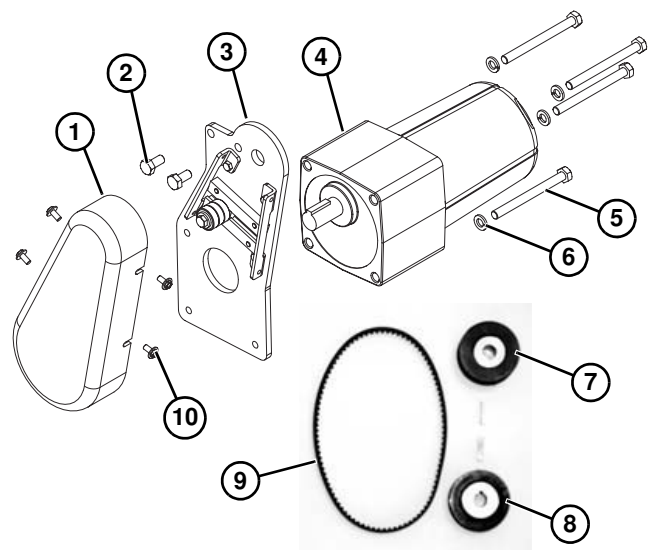


Figure 9

Installation


Drive Package Installation

- Side Mount
- Bottom 90° Mount
- Bottom Parallel Shaft Mount

Required Tools

- 2.5 mm hex wrench
- 7 mm wrench
- 8 mm wrench
- 10 mm wrench
- 13 mm wrench
- Straight edge
- Torque wrench

Install Side Mount Drive Package

⚠ WARNING

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

1. Install mounting bracket (**Figure 10, item 1**) onto drive end of conveyor with screw (**Figure 10, item 2**), making sure the stud (**Figure 11, item 1**) on the back of the mounting bracket seats into the notch in the tail plate (**Figure 11, item 2**).

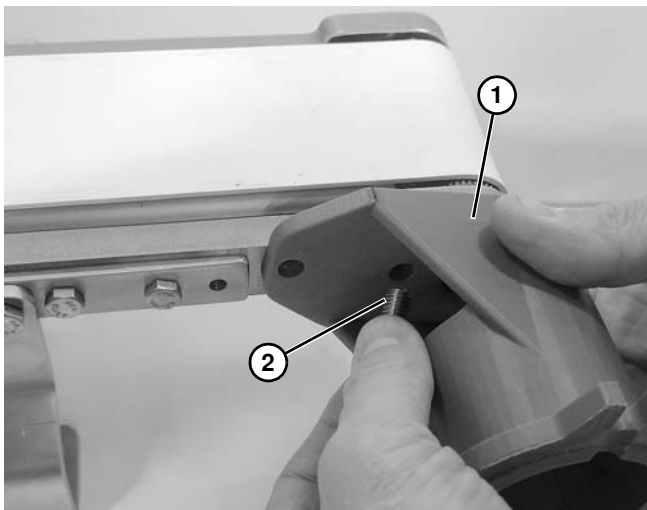


Figure 10

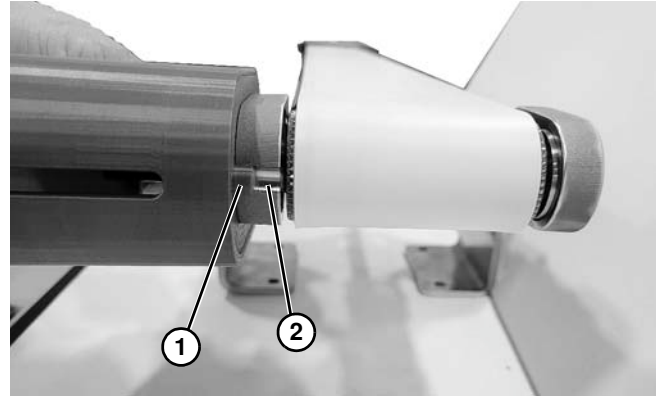


Figure 11

⚠ WARNING

<p>Drive shaft keyway may be sharp. HANDLE WITH CARE.</p>

2. Insert 3 jaw coupling (**Figure 12, item 1**) onto conveyor shaft. The end of the shaft should be flush with the end of the coupling. Secure with set screw (**Figure 13, item 1**).



Figure 12

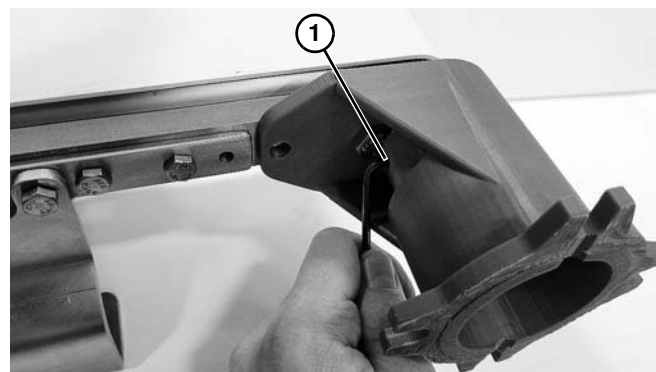


Figure 13

3. Insert spider (Figure 14, item 1) into 3 jaw coupling.



Figure 14

4. Attach angle guard (Figure 15, item 1) to mounting bracket (Figure 15, item 2) with screw (Figure 15, item 3).

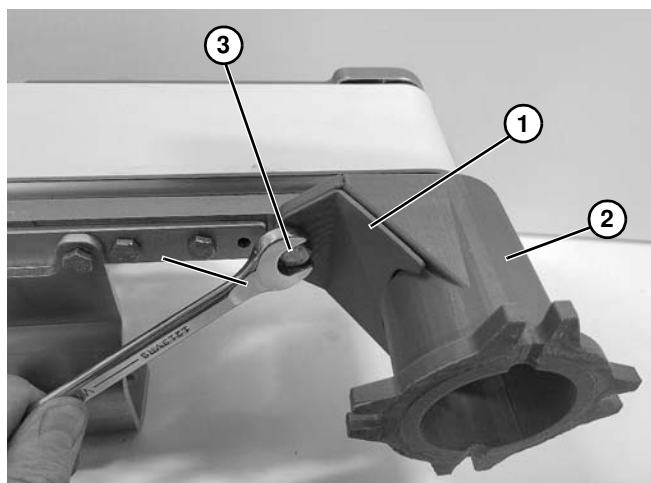


Figure 15

5. Install motor with 3 jaw coupling (Figure 16, item 1) onto shaft, making sure the couplings are engaged.

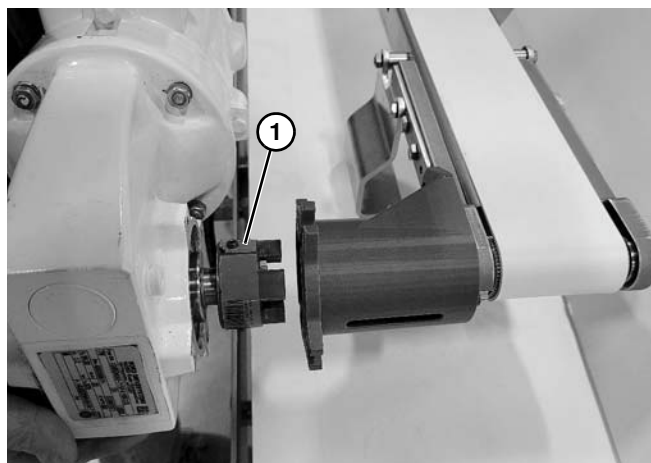


Figure 16

6. Secure gearmotor (Figure 17, item 1) with four screws (Figure 17, item 2).

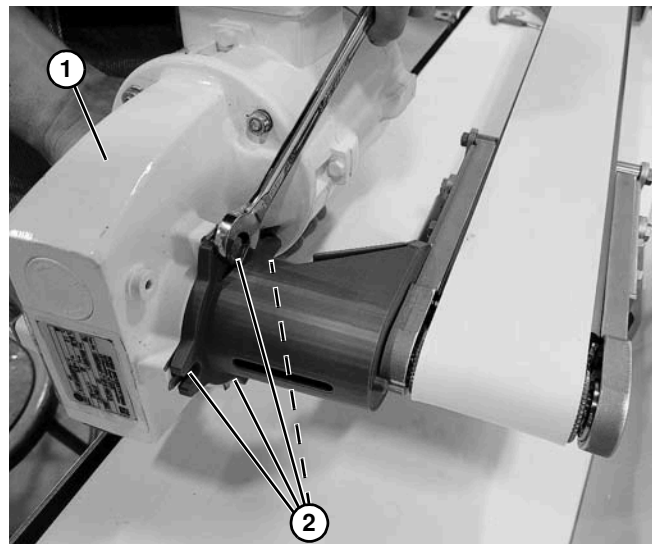


Figure 17

Install Bottom Mount Drive Package

⚠ WARNING



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

⚠ WARNING



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

Installation

1. Install mounting plate (**Figure 18, item 1**) onto drive end of conveyor with two screws (**Figure 19, item 1**).

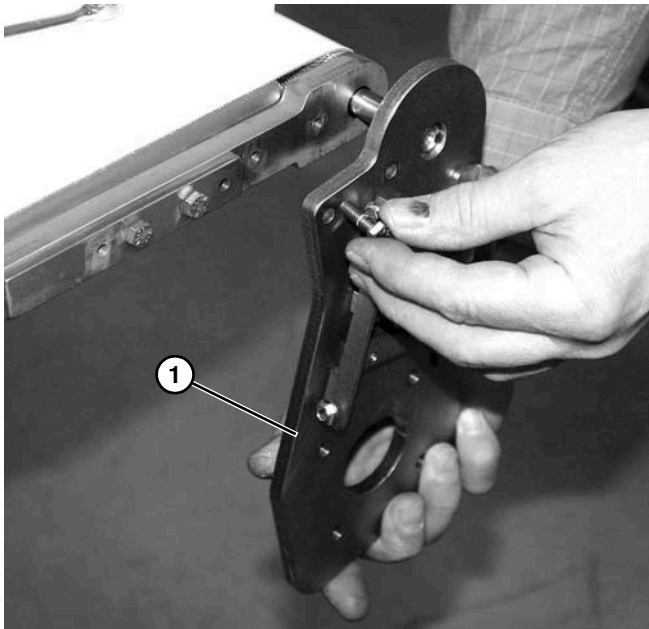


Figure 18

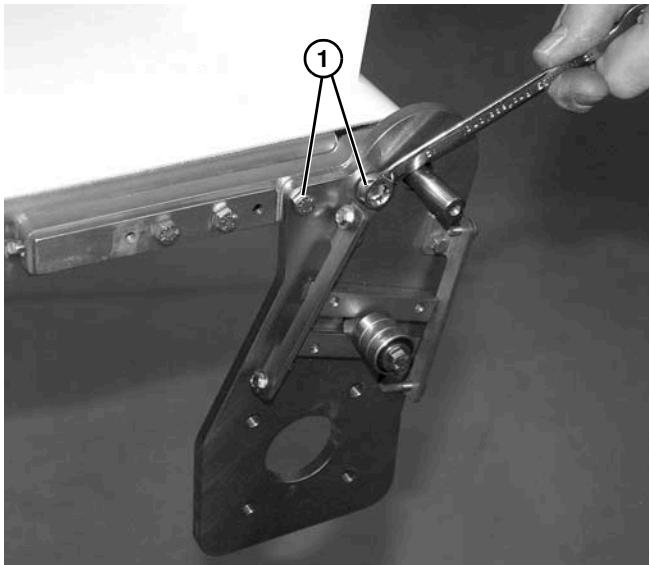


Figure 19

2. Install gearmotor:

NOTE

*Bottom 90° mount gearmotors should be oriented with the gear head up (**Figure 20**) for flat belt conveyors, and gear head down (**Figure 21**) for cleated belt conveyors.*

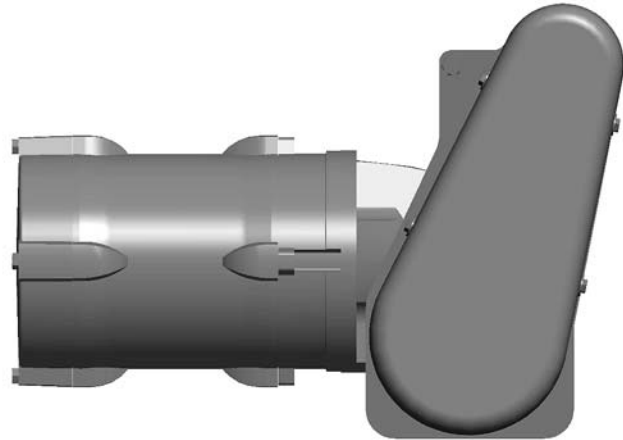


Figure 20

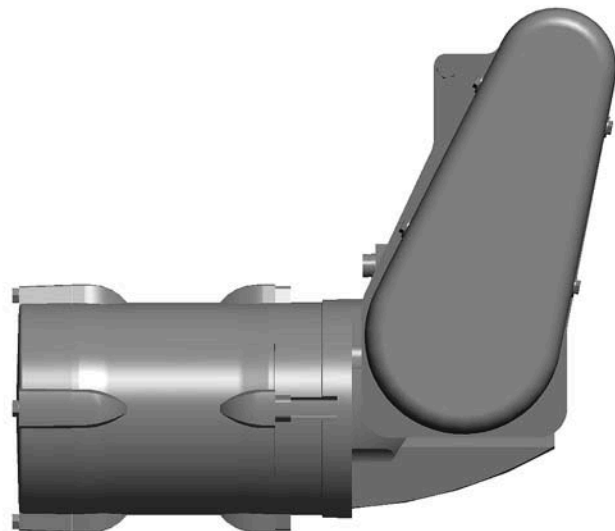


Figure 21

Installation

- For bottom 90 degree mount, install gearmotor (Figure 22, item 1) onto mounting plate (Figure 22, item 2) with four screws and washers (Figure 23, item 1).

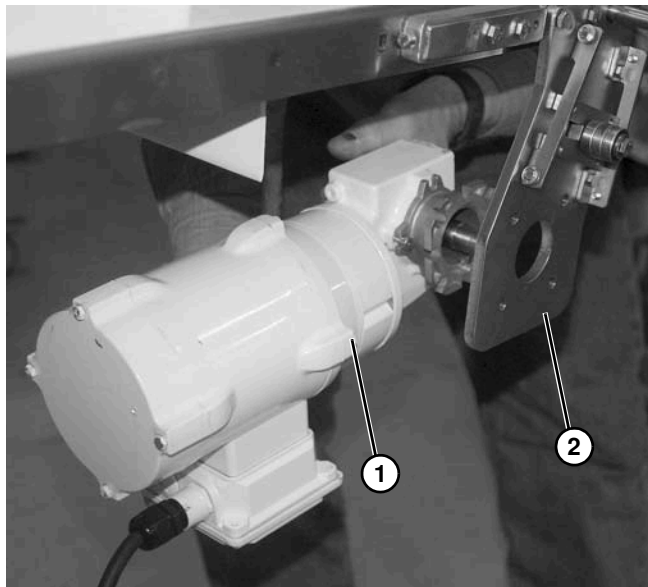


Figure 22

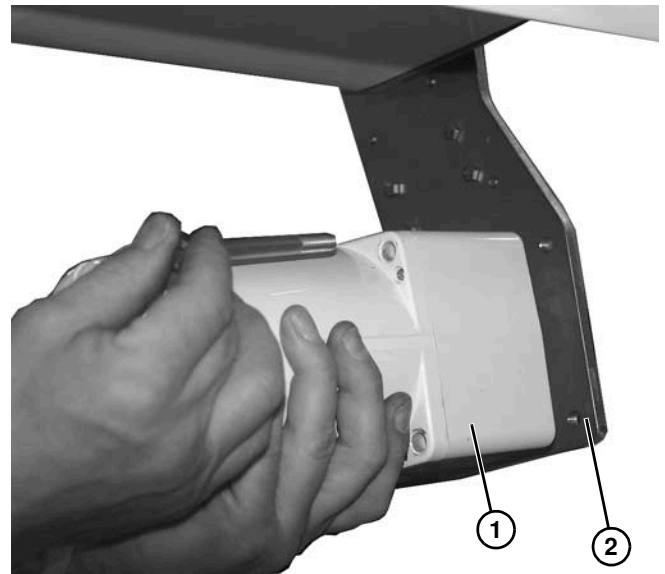


Figure 24

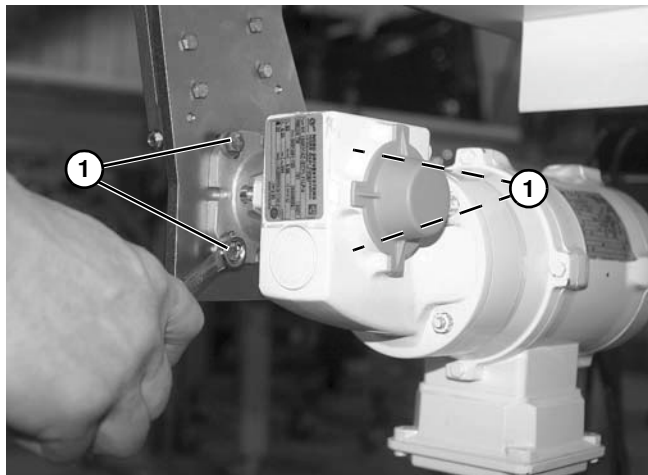


Figure 23

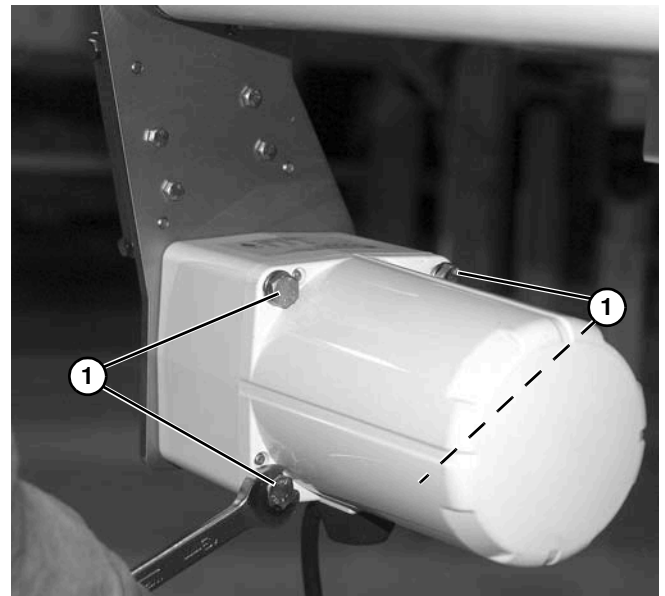


Figure 25

⚠ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

3. Install timing belt or timing chain:

Installation

Install Timing Belt

NOTE

Make sure sprocket keys are installed on conveyor input shaft (**Figure 43, item 4**) and gearmotor output shaft (**Figure 43, item 5**).

1. Install timing belt (**Figure 26, item 1**) over drive sprocket (**Figure 26, item 2**) and driven sprocket (**Figure 26, item 3**). Install timing belt and sprockets on conveyor input shaft (**Figure 26, item 4**) and gearmotor output shaft (**Figure 26, item 5**). Do not tighten sprocket set screws.

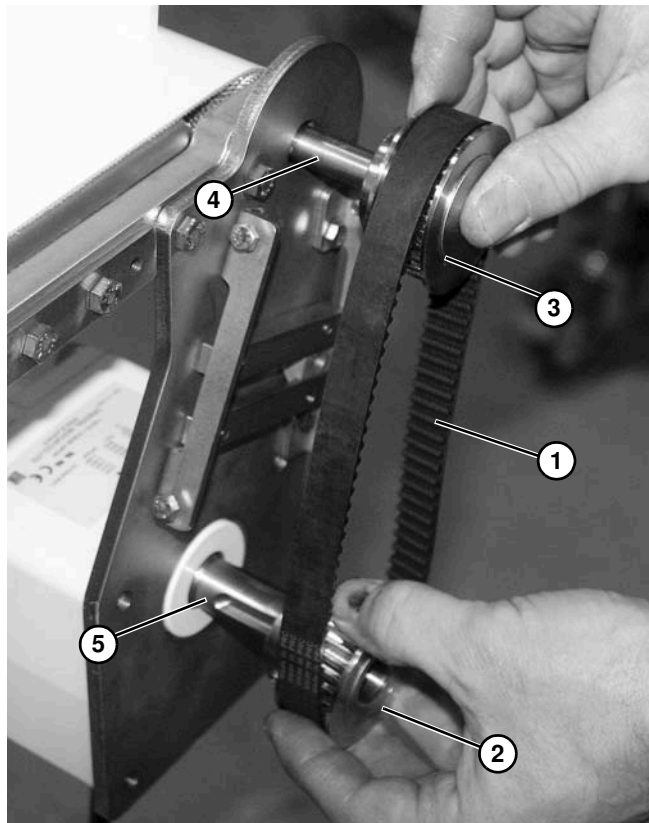


Figure 26

IMPORTANT

Using a straight edge (**Figure 27, item 1**), make sure drive sprocket (**Figure 27, item 2**) aligns with driven sprocket (**Figure 27, item 3**). Tighten drive and driven sprocket set screws.

- If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.
- If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.

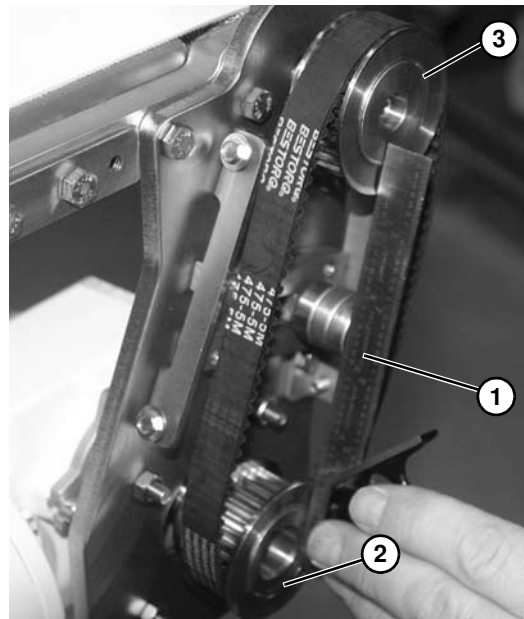


Figure 27

- Depending on conveyor belt travel (direction A or B of **Figure 28**), locate timing belt tensioner (**Figure 28, item 1**) as shown. Do not tighten tensioner screw. Tension timing belt to obtain 3 mm (1/8") deflection for 4.3 N (1.0 lb) of force at timing belt midpoint (**Figure 28, item 2**). Tighten tensioner screw (**Figure 29, item 1**).

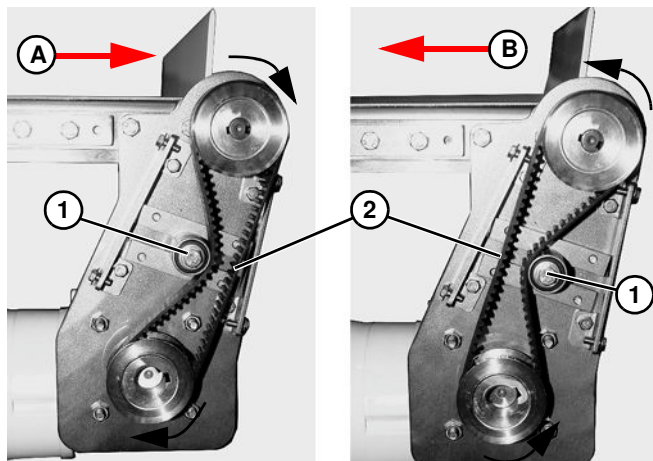


Figure 28

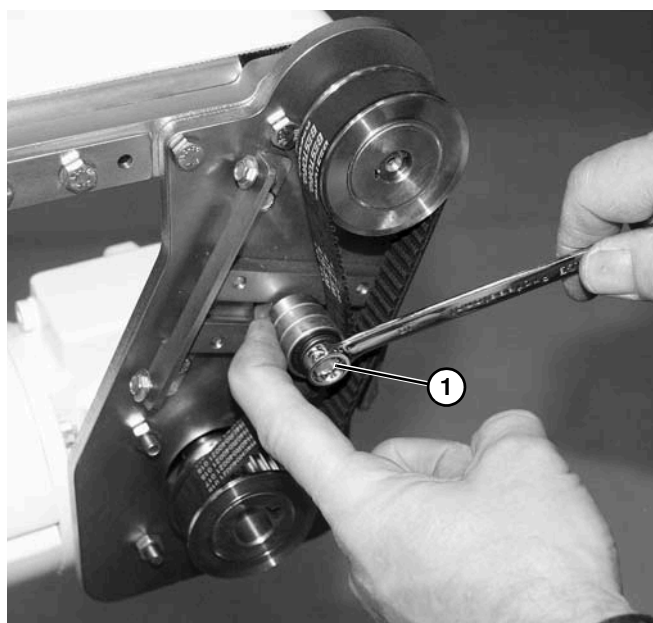


Figure 29

NOTE

*Do not over-tighten screws
(Figure 30, item 2).*

- Install cover (**Figure 30, item 1**) and tighten four screws (**Figure 30, item 2**).

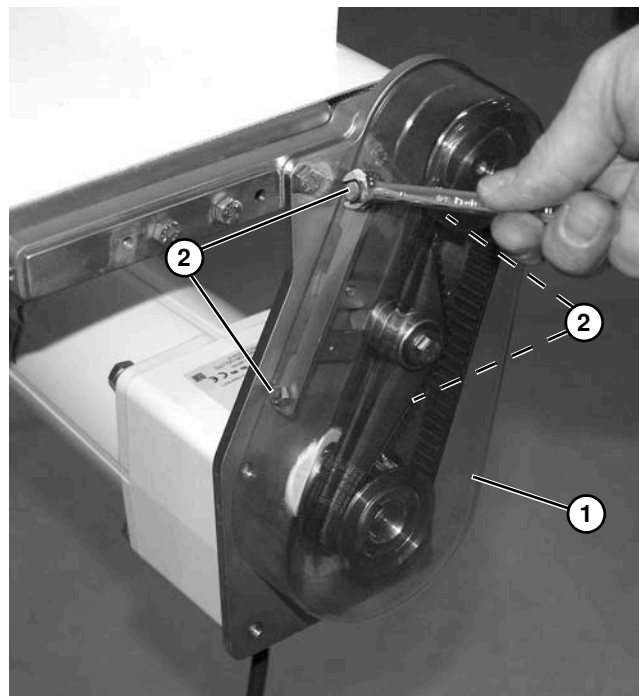


Figure 30

Installation

Install Timing Chain

NOTE

Make sure sprocket keys are installed on conveyor input shaft (**Figure 31, item 4**) and gearmotor output shaft (**Figure 31, item 5**).

1. Install timing chain (**Figure 31, item 1**) over drive sprocket (**Figure 31, item 2**) and driven sprocket (**Figure 31, item 3**). Install timing chain and sprockets on conveyor input shaft (**Figure 31, item 4**) and gearmotor output shaft (**Figure 31, item 5**). Do not tighten sprocket set screws.

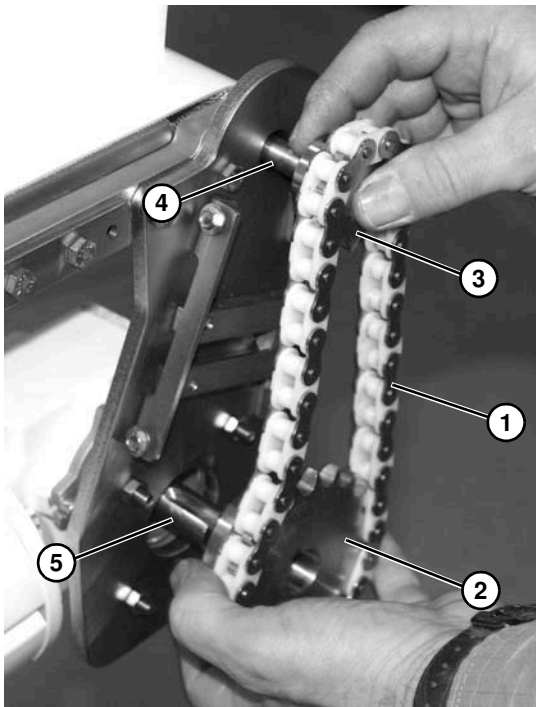


Figure 31

IMPORTANT

Using a straight edge (**Figure 32, item 1**), make sure drive sprocket (**Figure 32, item 2**) aligns with driven sprocket (**Figure 32, item 3**). Tighten drive and driven sprocket set screws (**Figure 33, item 1**).

- If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.
- If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.

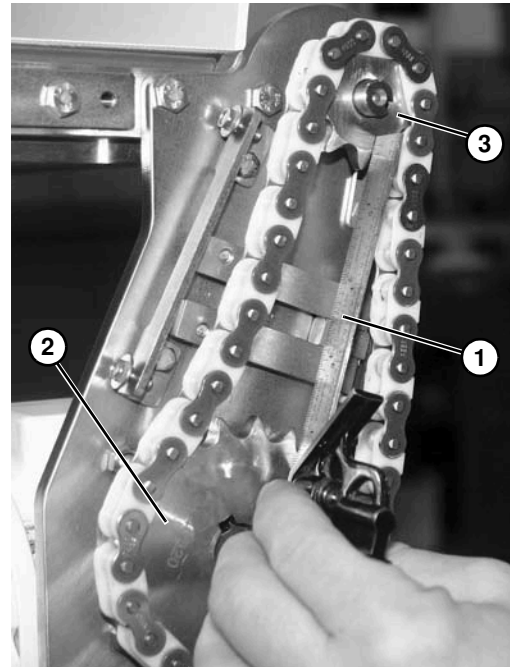


Figure 32

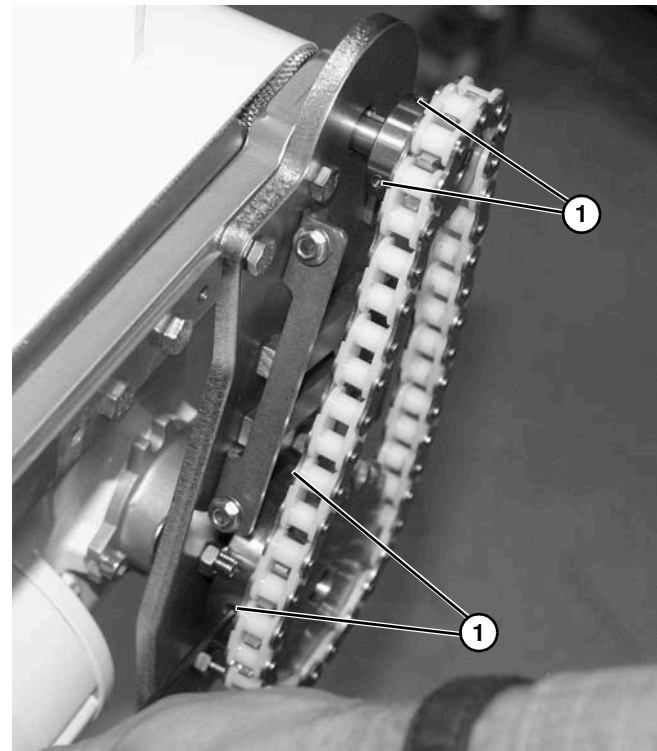


Figure 33

Installation

- Depending on conveyor belt travel (direction A or B of **Figure 34**), locate timing chain tensioner (**Figure 34, item 1**) as shown. Do not tighten tensioner screw.

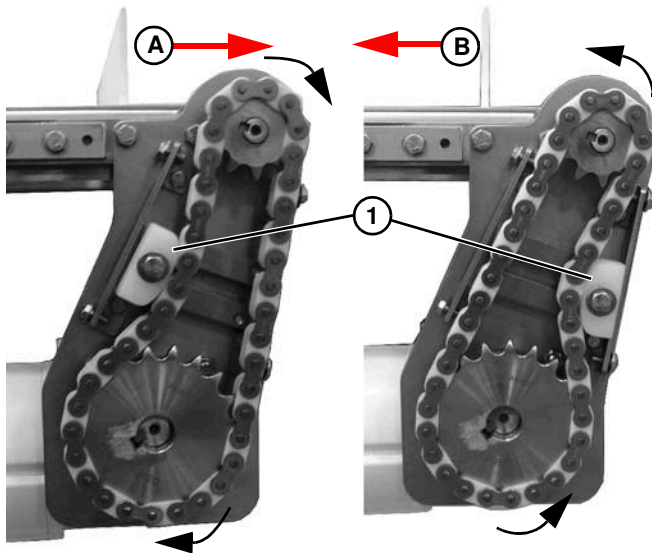


Figure 34

- Install screw and washer (**Figure 35, item 1**), timing chain tensioner (**Figure 35, item 2**), and spacer (**Figure 35, item 3**) onto drive mounting bracket.

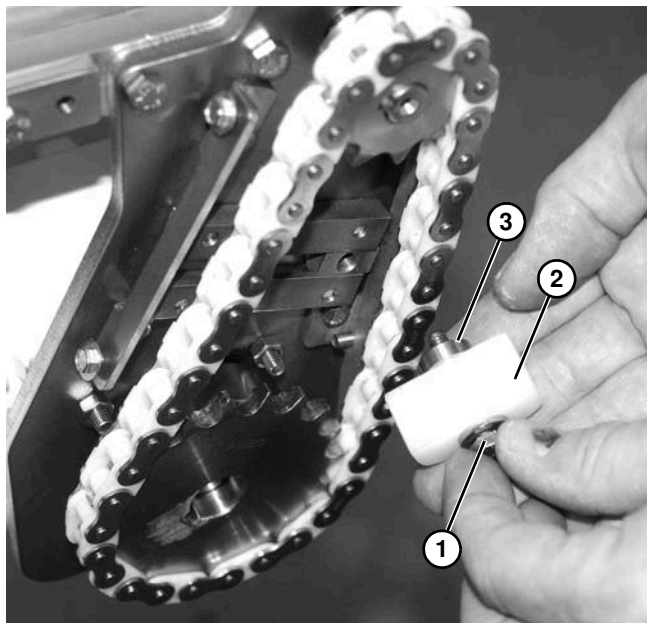


Figure 35

NOTE

Do not overtension chain. Only tension chain until slack is removed.

- Slide chain tensioner (**Figure 36, item 1**) to take up chain slack. Tighten chain tensioner screw (**Figure 36, item 2**).

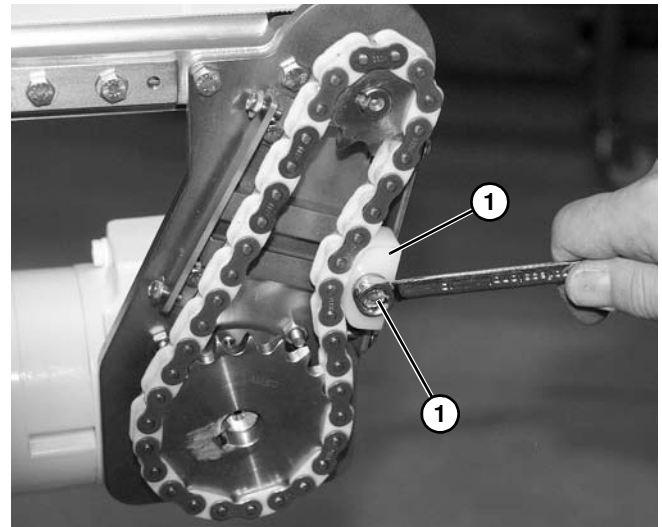


Figure 36

NOTE

Do not over-tighten screws (Figure 37, item 2).

- Install cover (**Figure 37, item 1**) and tighten four screws (**Figure 37, item 2**).

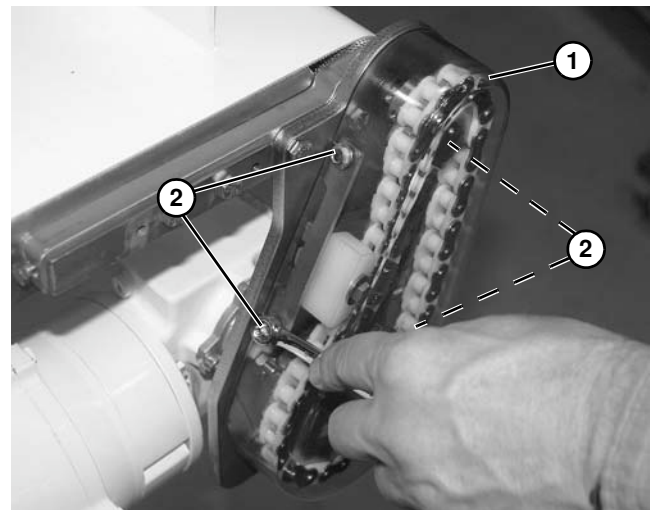


Figure 37

Preventive Maintenance and Adjustment

Required Tools

- 2.5 mm hex wrench
- 7 mm wrench
- 8 mm wrench
- 10 mm wrench
- 13 mm wrench
- Straight edge
- Torque wrench

Check List

- Keep critical service parts on hand. Refer to “Service Parts” on page 23 for recommendations.
- Replace any worn or damaged parts.

Timing Belt or Chain Replacement

⚠ WARNING



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

Replace timing belt or chain following instructions:

- A – Timing Belt Replacement
- B – Timing Chain Replacement

A – Timing Belt Replacement

1. Loosen four screws (**Figure 38, item 1**) securing cover (**Figure 38, item 2**).

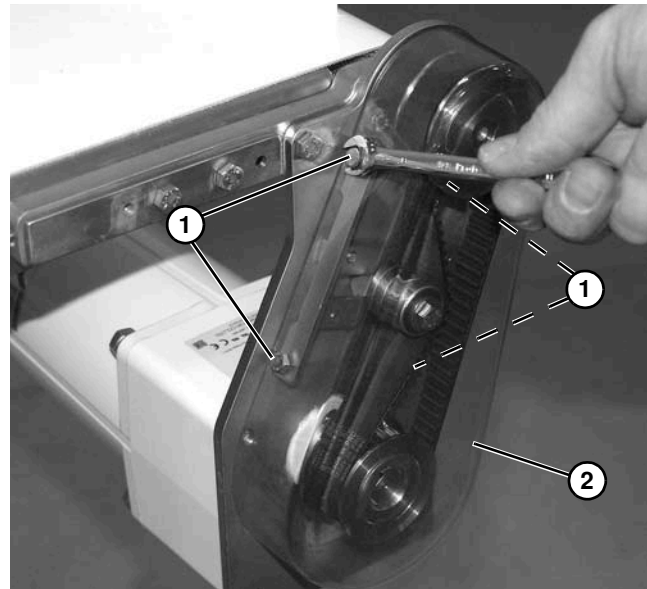


Figure 38

2. Remove cover (**Figure 38, item 1**).
3. Loosen tensioner (**Figure 39, item 1**).

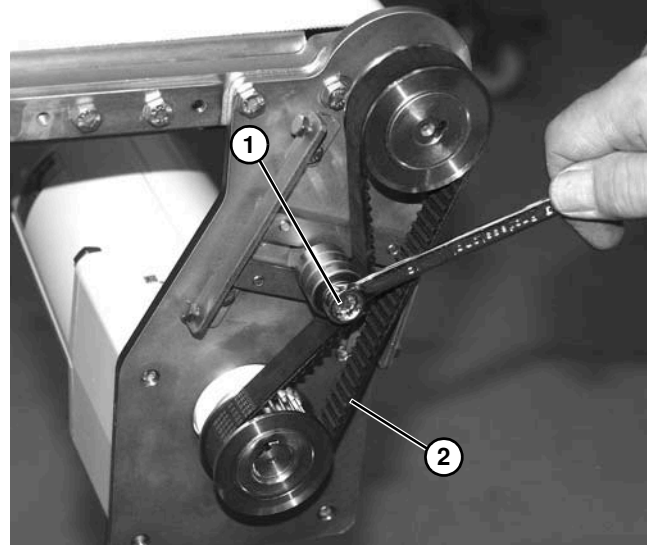


Figure 39

4. Remove timing belt (**Figure 39, item 2**).

Preventive Maintenance and Adjustment

NOTE

If timing belt does not slide over pulley flange, loosen two drive pulley set screws (**Figure 40, item 1**) and driven pulley set screws (**Figure 40, item 2**), and remove both pulleys with belt (**Figure 41**). Make sure to retain sprocket keys.

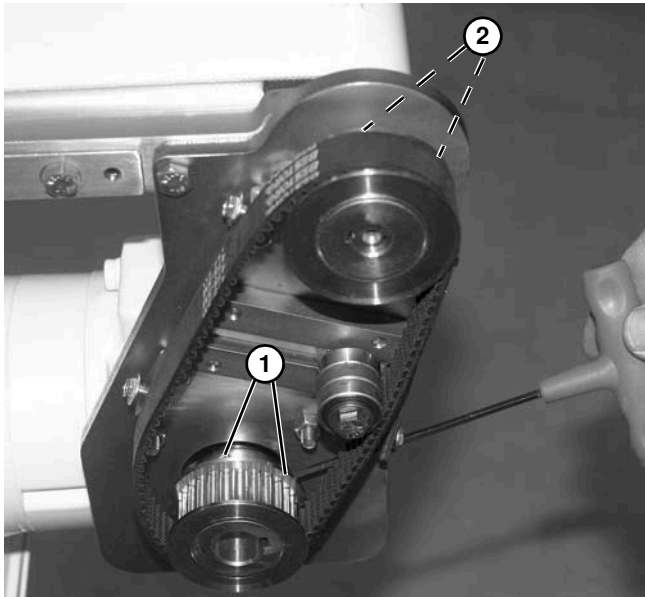


Figure 40

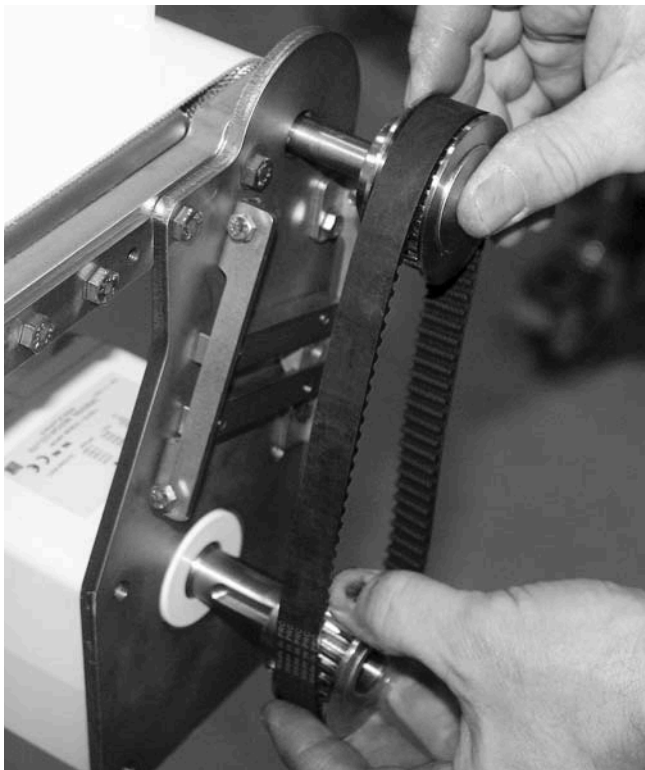


Figure 41

5. Replace components, as needed (**Figure 42**).

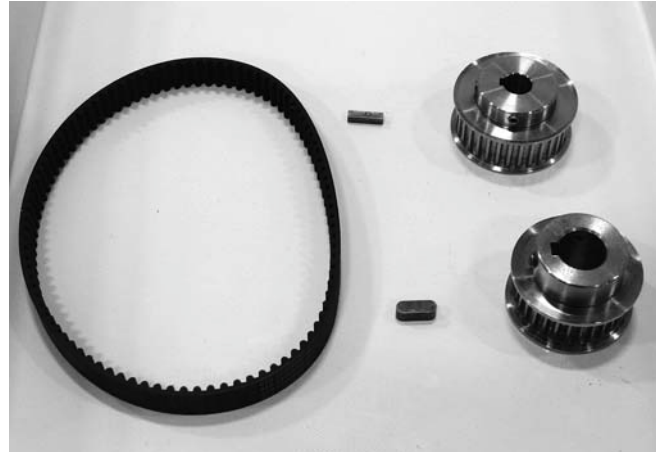


Figure 42

NOTE

Make sure sprocket keys are installed on conveyor input shaft (**Figure 43, item 4**) and gearmotor output shaft (**Figure 43, item 5**).

6. Install new timing belt (**Figure 43, item 1**) over drive sprocket (**Figure 43, item 2**) and driven sprocket (**Figure 43, item 3**). Install timing belt and sprockets on conveyor input shaft (**Figure 43, item 4**) and gearmotor output shaft (**Figure 43, item 5**). Do not tighten sprocket set screws.

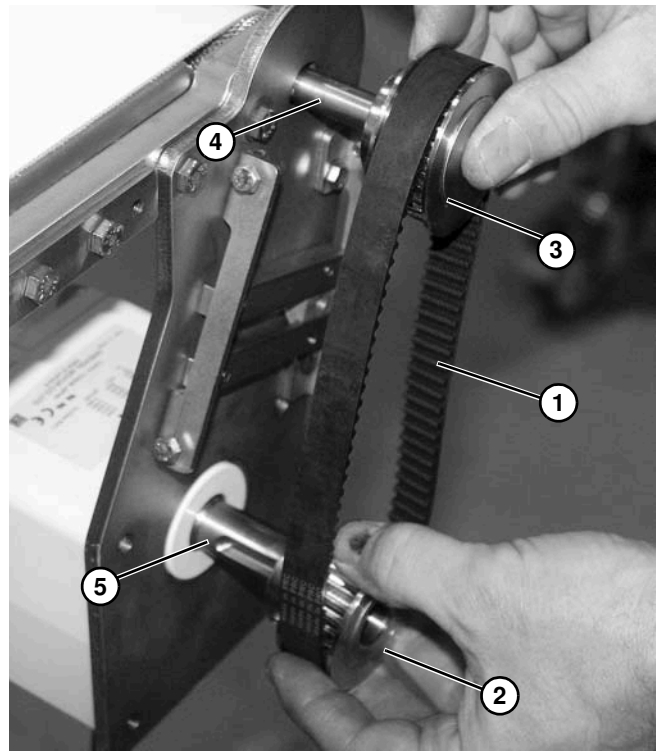


Figure 43

Preventive Maintenance and Adjustment

IMPORTANT

Using a straight edge (**Figure 44, item 1**), make sure drive sprocket (**Figure 44, item 2**) aligns with driven sprocket (**Figure 44, item 3**). Tighten drive and driven sprocket set screws.

- If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.
- If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.

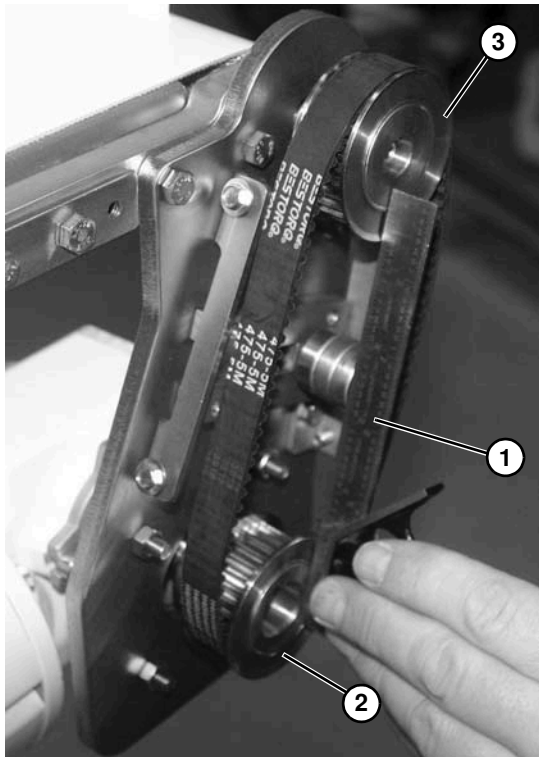


Figure 44

7. Depending on conveyor belt travel (direction A or B of **Figure 45**), locate timing belt tensioner (**Figure 45, item 1**) as shown. Tension timing belt to obtain 3 mm (1/8") deflection for 4.3 N (1.0 lb) of force at timing belt mid-point (**Figure 45, item 2**). Tighten tensioner screw (**Figure 46, item 1**).

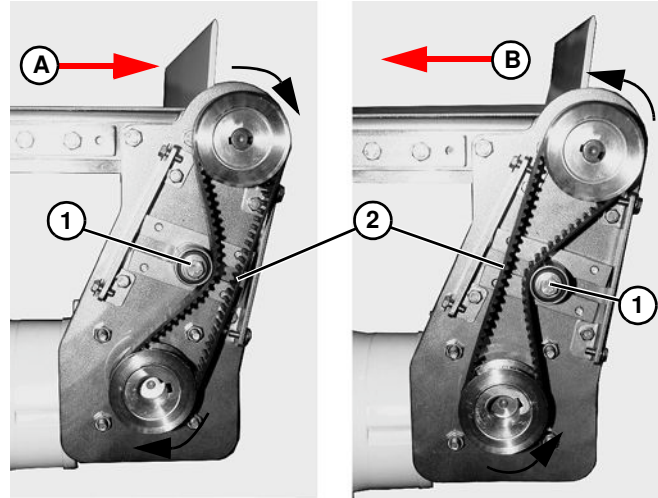


Figure 45

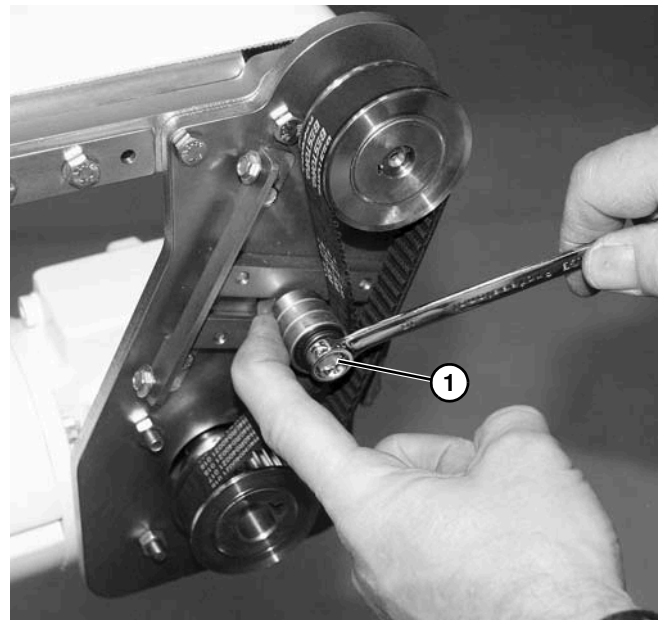


Figure 46

Preventive Maintenance and Adjustment

NOTE

Do not over-tighten screws
(Figure 47, item 2).

8. Install cover (Figure 47, item 1) and tighten four screws (Figure 47, item 2).

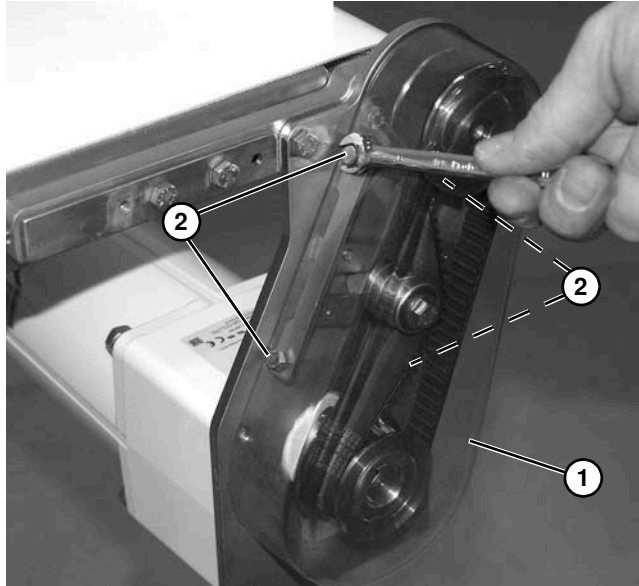


Figure 47

B – Timing Chain Replacement

1. Loosen four screws (Figure 48, item 1) securing cover (Figure 48, item 2).

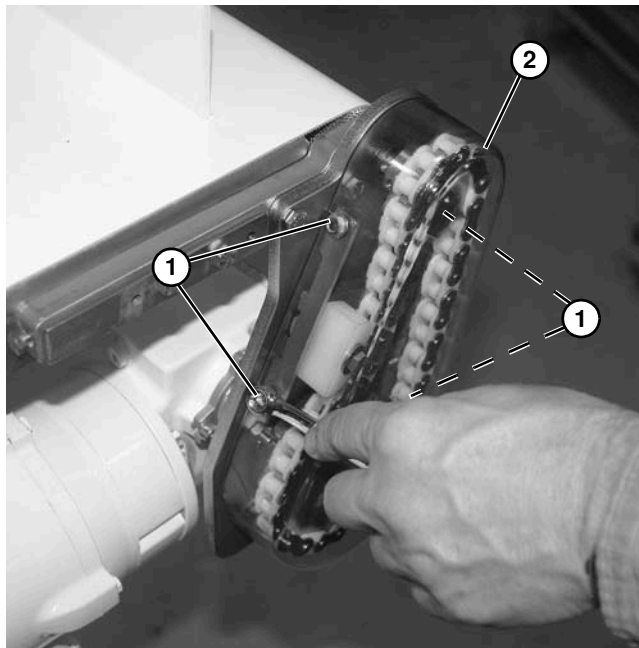


Figure 48

2. Remove cover (Figure 49, item 1).

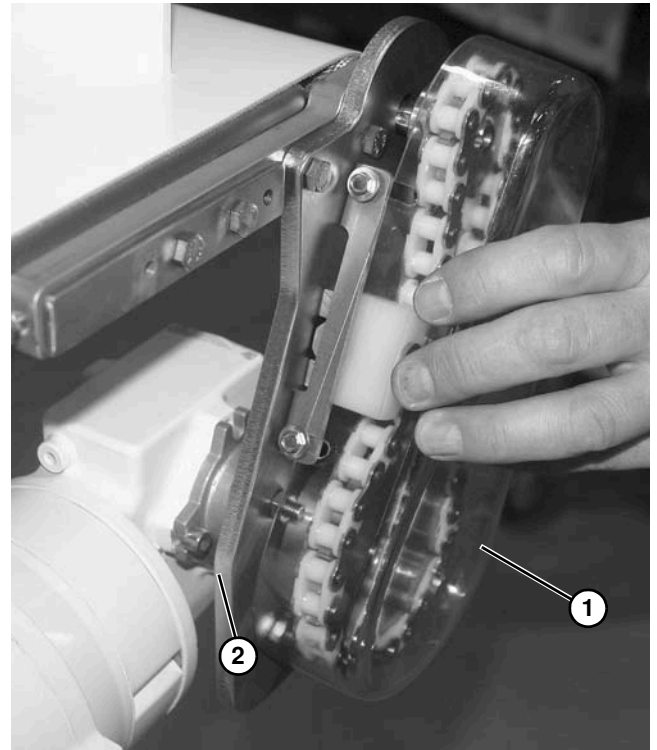


Figure 49

3. Remove timing chain tensioner screw (Figure 50, item 1).

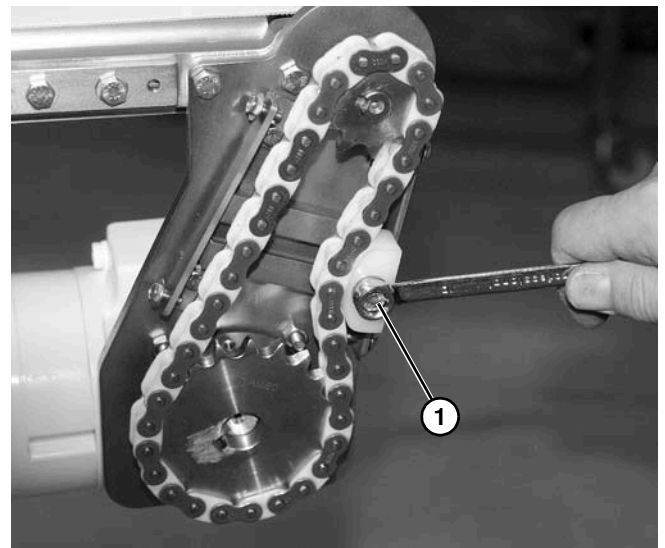


Figure 50

Preventive Maintenance and Adjustment

4. Remove screw and washer (Figure 51, item 1), timing chain tensioner (Figure 51, item 2), and spacer (Figure 51, item 3) from drive mounting bracket.

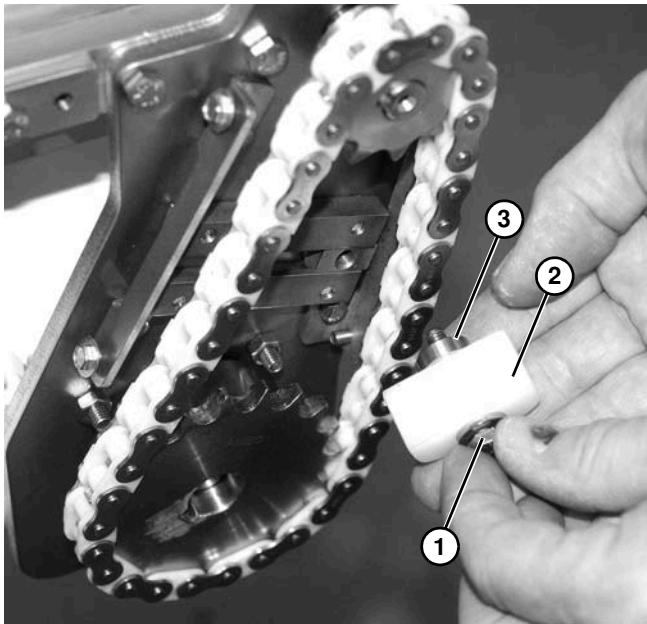


Figure 51

5. Loosen four set screws (Figure 52, item 1).

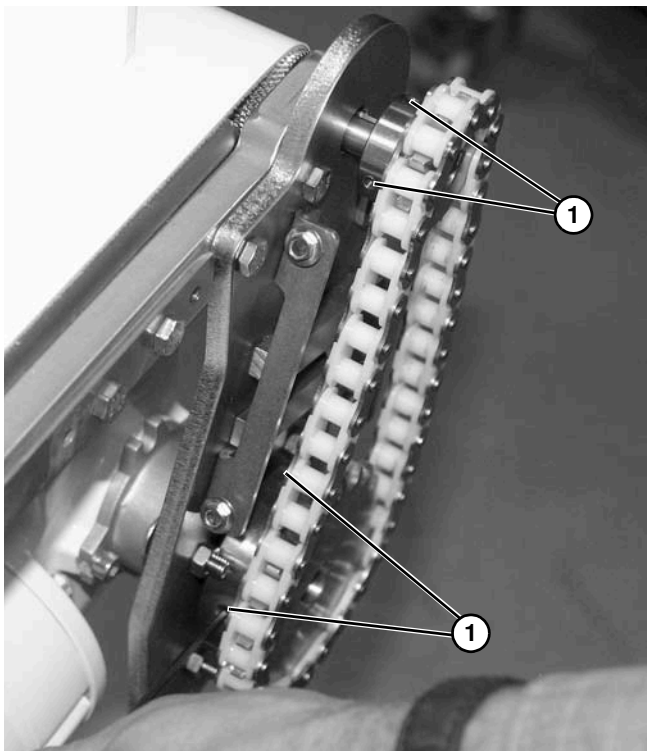


Figure 52

6. Remove timing chain (Figure 53, item 1) along with drive sprocket (Figure 53, item 2) and driven sprocket (Figure 53, item 3) from conveyor input shaft (Figure 53, item 4) and gearmotor output shaft (Figure 53, item 5). Make sure to retain sprocket keys.

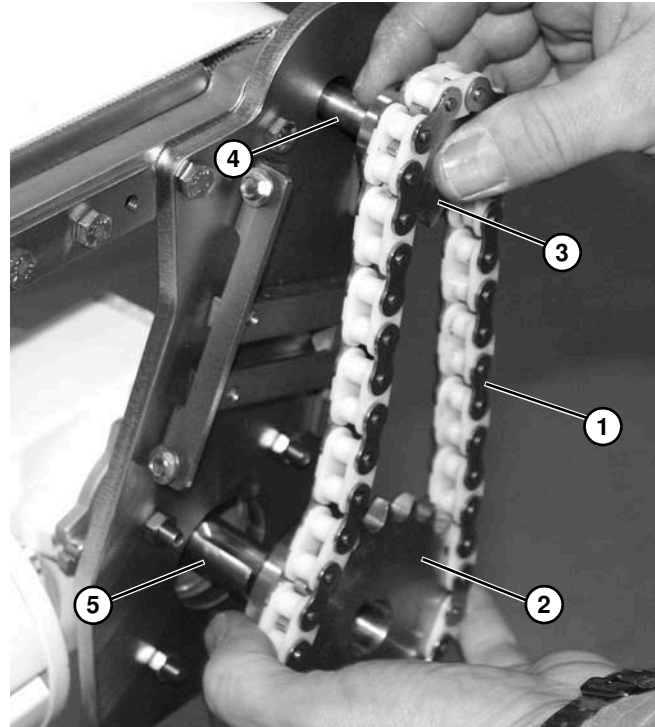


Figure 53

7. Replace components, as needed (Figure 54).

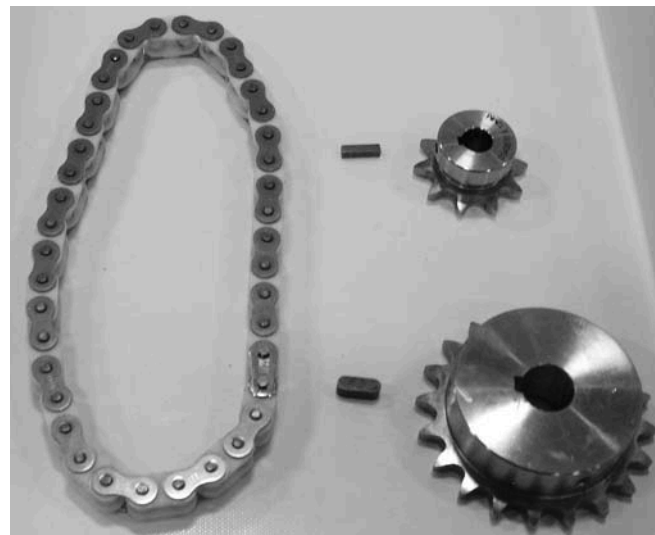


Figure 54

Preventive Maintenance and Adjustment

NOTE

Make sure sprocket keys are installed on conveyor input shaft (Figure 55, item 4) and gearmotor output shaft (Figure 55, item 5).

8. Install new timing chain (Figure 55, item 1) over drive sprocket (Figure 55, item 2) and driven sprocket (Figure 55, item 3). Install timing chain and sprockets on conveyor input shaft (Figure 55, item 4) and gearmotor output shaft (Figure 55, item 5). Do not tighten sprocket set screws.

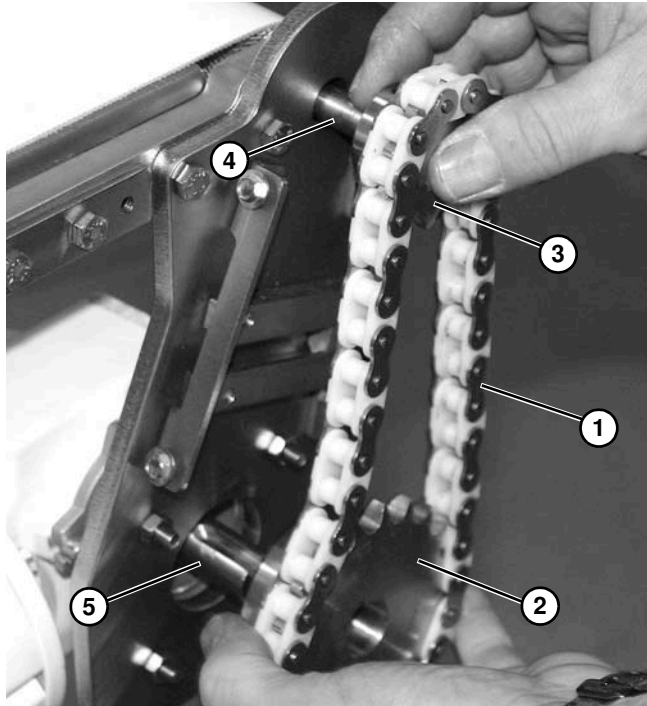


Figure 55

IMPORTANT

Using a straight edge (Figure 56, item 1), make sure drive sprocket (Figure 56, item 2) aligns with driven sprocket (Figure 56, item 3). Tighten drive and driven sprocket set screws.

- If necessary, loosen two set screws to move drive sprocket in or out. Tighten set screws.
- If necessary, loosen two set screws to move driven sprocket in or out. Tighten set screws.

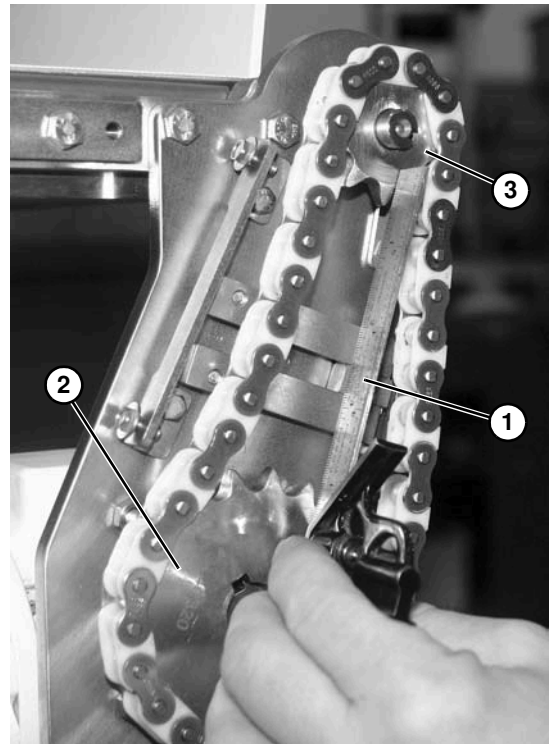


Figure 56

Preventive Maintenance and Adjustment

9. Depending on conveyor belt travel (direction A or B of **Figure 57**), locate timing chain tensioner (**Figure 57, item 1**) as shown. Do not tighten tensioner screw.

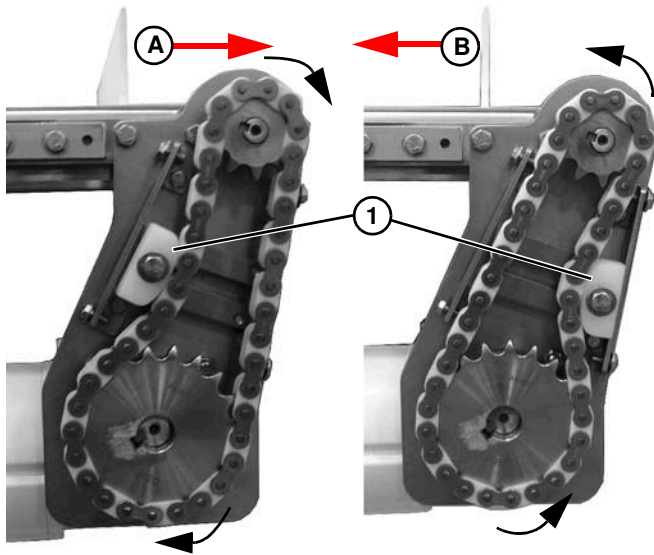


Figure 57

10. Install screw and washer (**Figure 58, item 1**), timing chain tensioner (**Figure 58, item 2**), and spacer (**Figure 58, item 3**) onto drive mounting bracket.

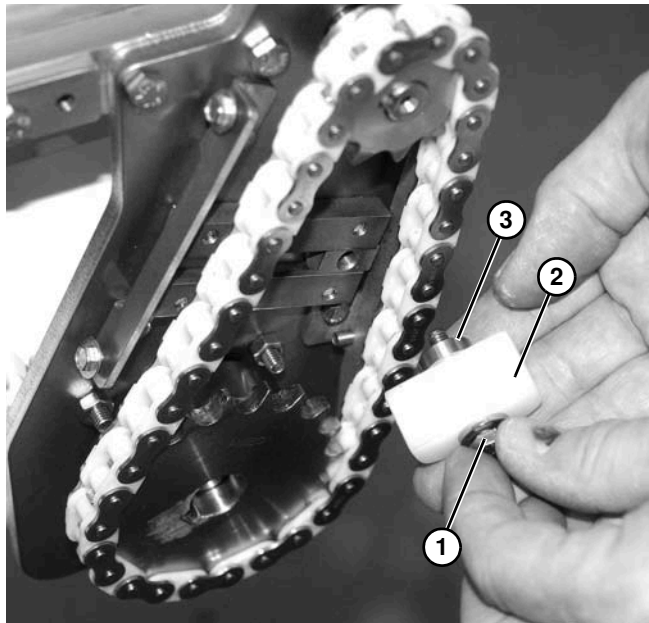


Figure 58

NOTE

Do not overtension chain. Only tension chain until slack is removed.

11. Slide chain tensioner (**Figure 59, item 1**) to take up chain slack. Tighten chain tensioner screw (**Figure 59, item 2**).

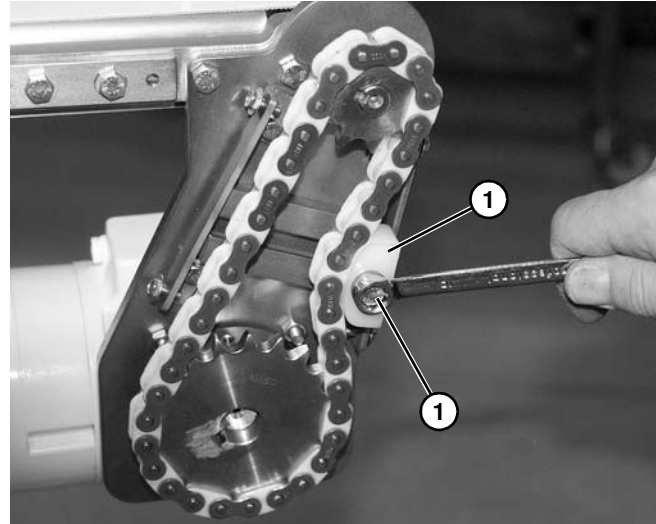


Figure 59

NOTE

*Do not over-tighten screws (**Figure 60, item 2**).*

12. Install cover (**Figure 60, item 1**) and tighten four screws (**Figure 60, item 2**).

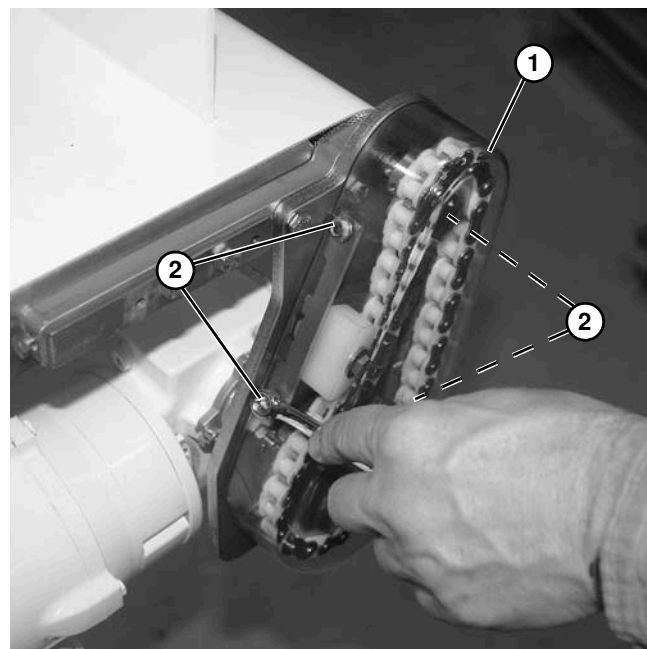


Figure 60

Preventive Maintenance and Adjustment

Timing Belt or Chain Tensioning

⚠ WARNING



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

NOTE

Figure 61 through Figure 64 shown tensioning procedure for a timing belt. Tensioning a timing chain is similar except as noted.

1. Loosen four (4) screws (**Figure 61, item 1**) and remove cover (**Figure 61, item 2**).

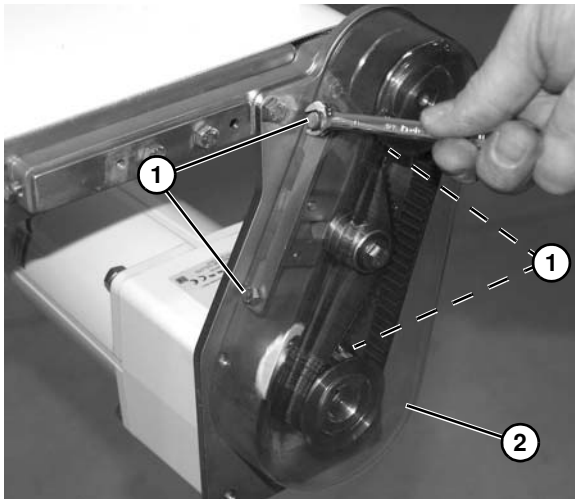


Figure 61

2. Loosen tensioner (**Figure 62, item 1**).

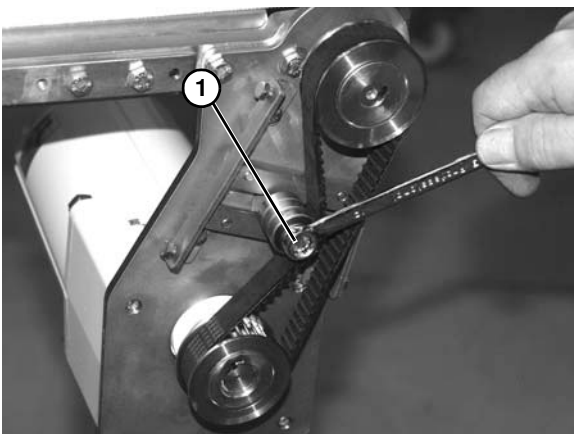


Figure 62

3. Depending on direction of conveyor belt travel (A or B of **Figure 63**), position belt tensioner (**Figure 63, item 1**) as shown.

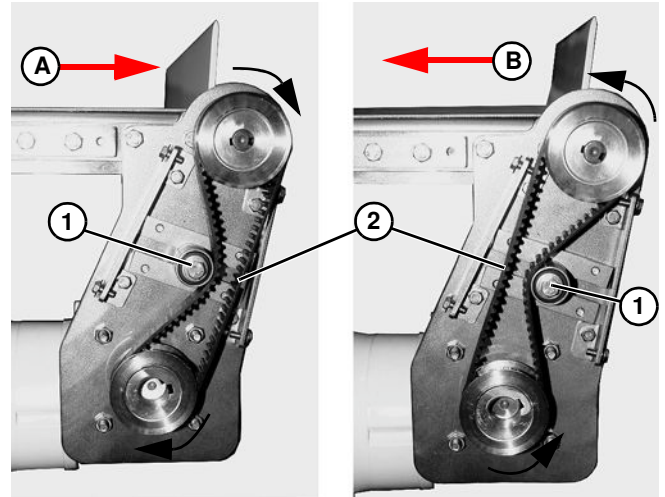


Figure 63



Figure 64

4. Tension belt or chain:
 - a. Tension belt to obtain 3 mm (1/8") deflection for 4.3 N (1.0 lb) of force at belt mid-point (**Figure 63, item 2**). Tighten tensioner screw (**Figure 64, item 1**).

Preventive Maintenance and Adjustment

NOTE

Do not overtension chain (Figure 65, item 3). Only tension chain until slack is removed.

- b. Slide chain tensioner (Figure 65, item 1) to take up chain slack. Tighten chain tensioner screw (Figure 65, item 2).

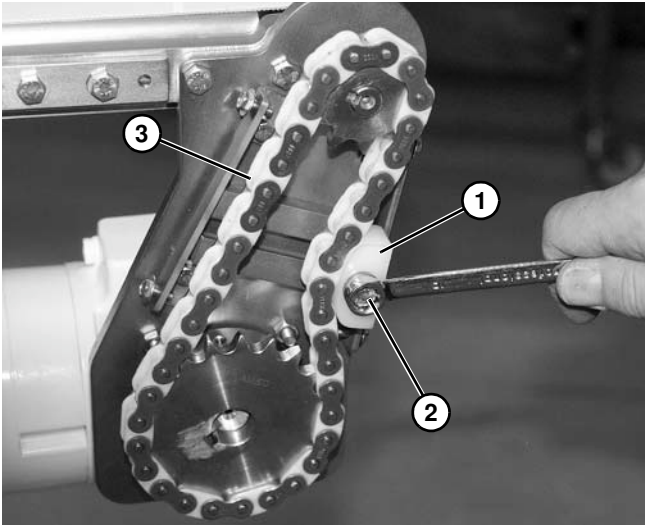


Figure 65

NOTE

Do not over-tighten screws (Figure 66, item 2).

5. Attach cover (Figure 66, item 1) with four (4) screws (Figure 66, item 2). Tighten screws.

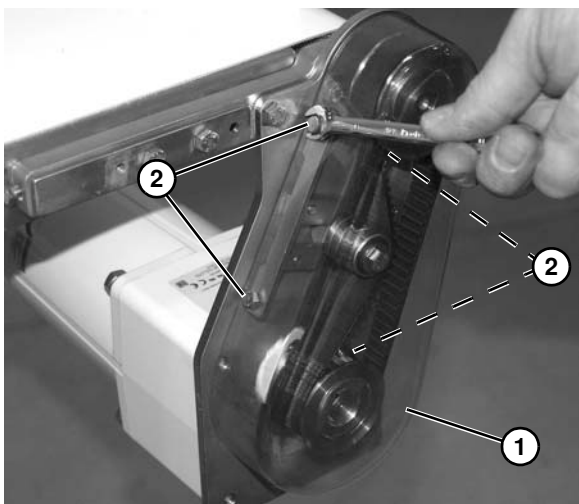

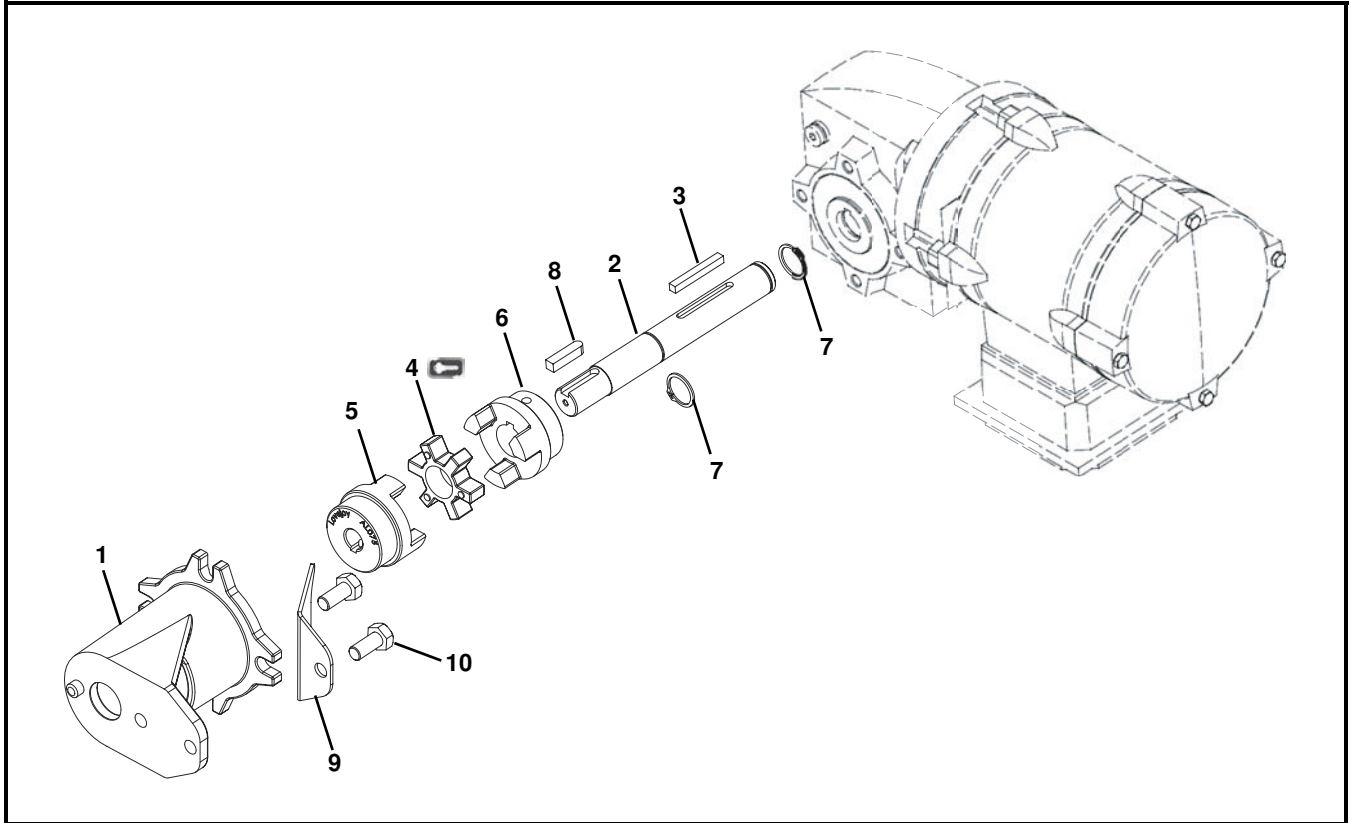


Figure 66

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.

Side Mount Package

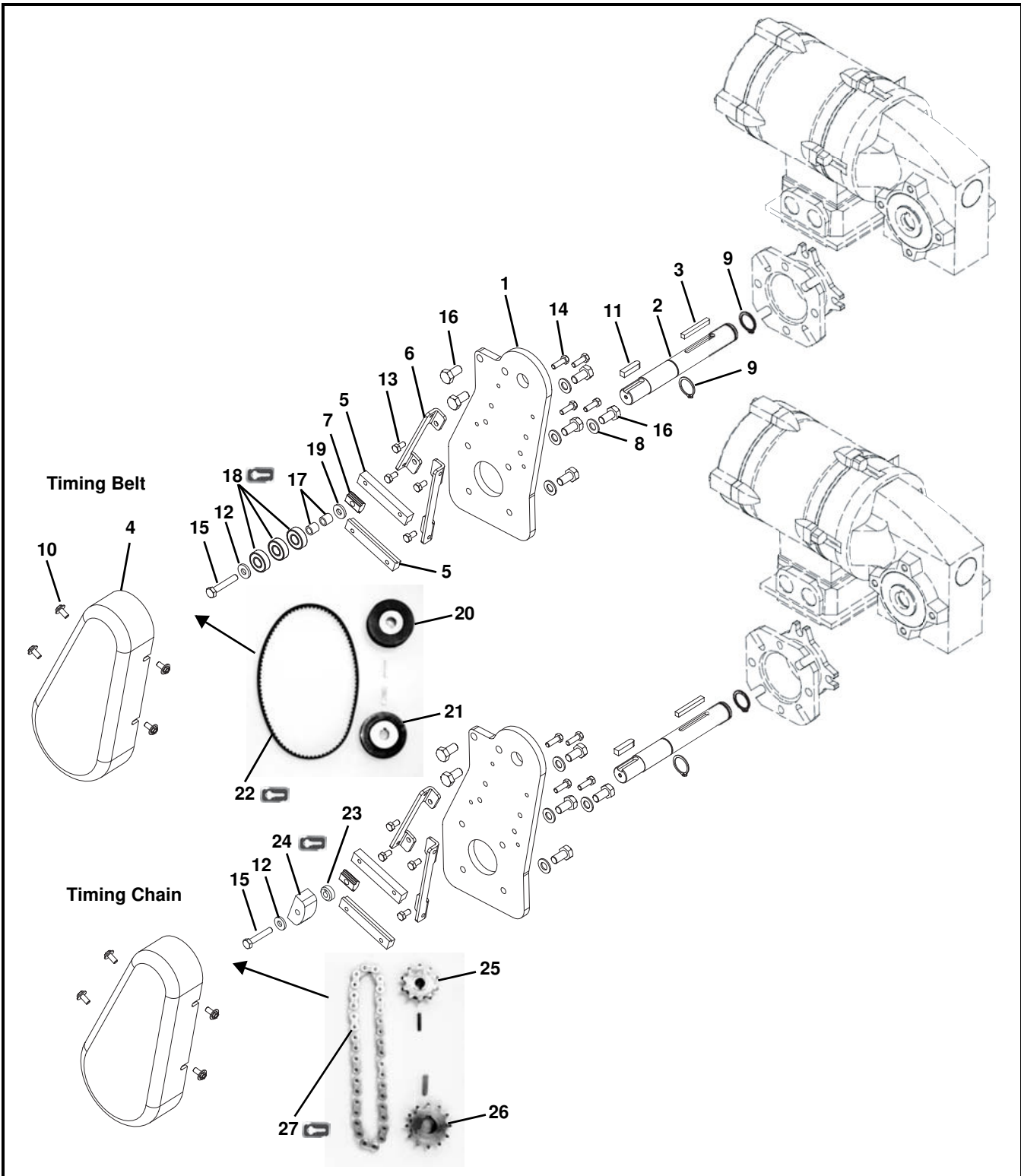


Item	Part Number	Description
1	531121	Side Mounting Bracket
2	531123	Motor Shaft for 60Hz Gearmotors
	531490	Motor Shaft for 50Hz Gearmotors
3	205561-00250	Key for 60Hz Gearmotors
	711634-00250	Key for 50Hz Gearmotors
4	807-1143	3 Jaw Spider
5	807-5191	3 Jaw Coupling, 1.75 dia. x 12 mm
6	807-5190	3 Jaw Coupling, 1.75 dia. x .75"
7	807-2710	Retaining Ring for 60Hz Gearmotors
	915-028	Retaining Ring for 50Hz Gearmotors
8	205561-00125	Key
9	531164	Angle Guard
10	960818MSS	Hex Head Cap Screw, M8-1.25 x 18 mm

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

Service Parts

90° Bottom Mount Package



Service Parts

Item	Part Number	Description
1	531109	Mounting Plate
2	531127	Motor Shaft for 60Hz Gearmotors
	531371	Motor Shaft for 50Hz Gearmotors
3	205561-00150	Key for 60Hz Gearmotors
	711634-00150	Key for 50Hz Gearmotors
4	450028P	Cover
5	450178MSS	Slide Bar, Tensioner
6	450181MSS	Cover Mounting Bracket
7	639971MSS	Drop-In Tee Bar
8	807-1951	Washer, M8
9	807-2710	Retaining Ring for 60Hz Gearmotors
	915-028	Retaining Ring for 50Hz Gearmotors
10	807-968	Flange Hex Screw, M5-0.80 x 10 mm
11	826-318	Key
12	911-201	Washer, 1/4"
13	960510MSS	Hex Head Cap Screw, M5-0.80 x 10 mm
14	960516MSS	Hex Head Cap Screw, M5-0.80 x 16 mm
15	960635MSS	Hex Head Cap Screw, M6-1.00 x 35 mm
16	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
17	801-139	Nylon Bearing for Timing Belt only
18	802-123	Bearing for Timing Belt only
19	911-201	Washer, 1/4" for Timing Belt only
20	450102	Driven Pulley, 22 Tooth, 12 mm Bore for Timing Belt only
	450103	Driven Pulley, 28 Tooth, 12 mm Bore for Timing Belt only
	450104	Driven Pulley, 32 Tooth, 12 mm Bore for Timing Belt only
21	450392M	Drive Pulley, 28 Tooth, 18 mm Bore for Timing Belt only
	450393M	Drive Pulley, 32 Tooth, 18 mm Bore for Timing Belt only
	450394M	Drive Pulley, 44 Tooth, 18 mm Bore for Timing Belt only
	450395M	Drive Pulley, 48 Tooth, 18 mm Bore for Timing Belt only
22	814-104	Timing Belt, 15 mm x 405 mm Long
	814-065	Timing Belt, 15 mm x 475 mm Long
	814-101	Timing Belt, 15 mm x 500 mm Long
	814-108	Timing Belt, 15 mm x 520 mm Long
	814-064	Timing Belt, 15 mm x 535 mm Long

Item	Part Number	Description
23	450182SS	Spacer for Timing Chain only
24	456048	Chain Tensioner for Timing Chain only
25	811-296	Driven Sprocket, 10 Tooth, 12 mm Bore for Timing Chain only
26	811-302	Drive Sprocket, 12 Tooth, 18 mm Bore for Timing Chain only
	811-304	Drive Sprocket, 16 Tooth, 18 mm Bore for Timing Chain only
	811-305	Drive Sprocket, 18 Tooth, 18 mm Bore for Timing Chain only
	811-306	Drive Sprocket, 20 Tooth, 18 mm Bore for Timing Chain only
27	456050	Timing Chain, 35 Pitch Length
	456052	Timing Chain, 37 Pitch Length
	456053	Timing Chain, 39 Pitch Length

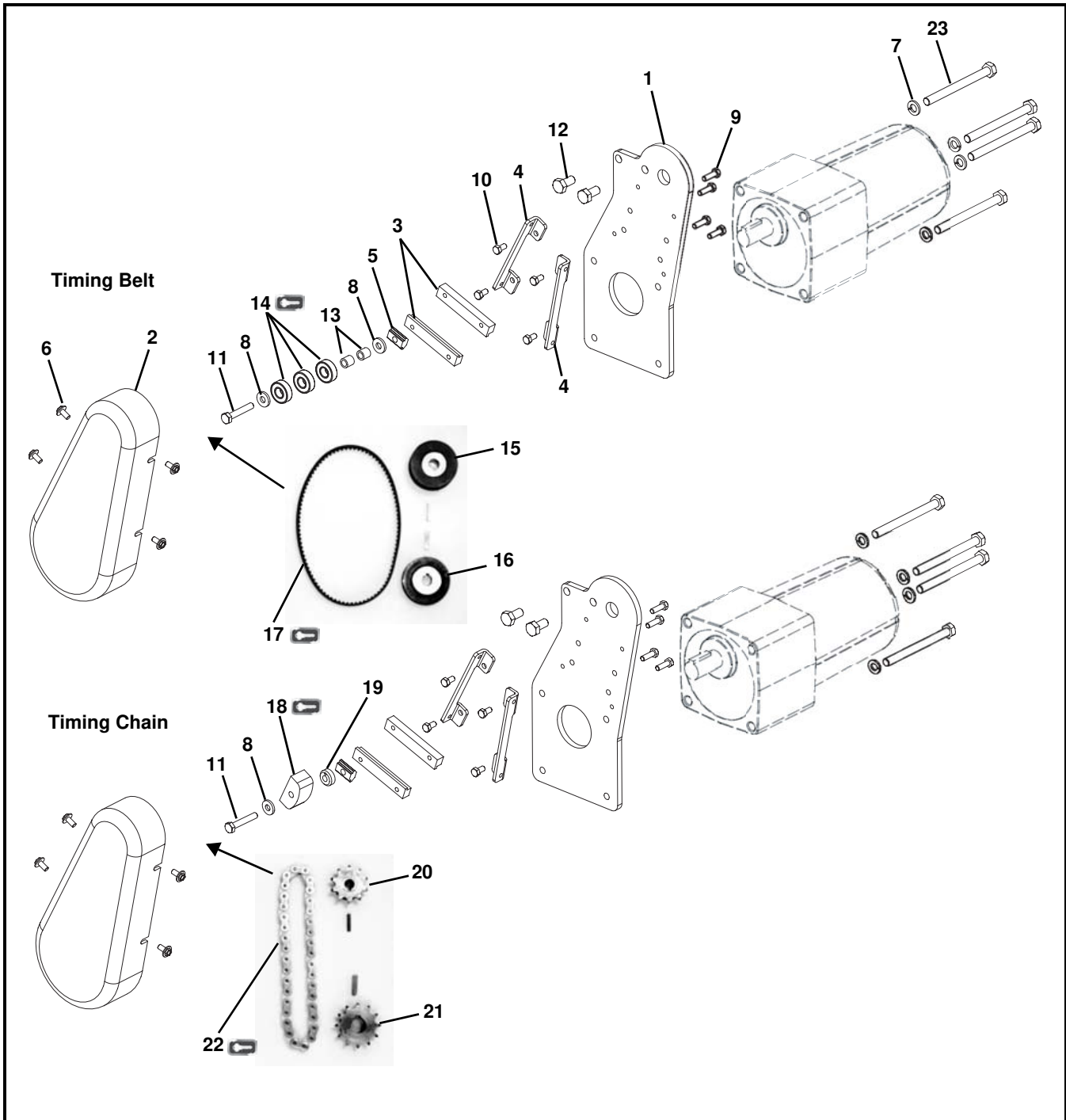
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com

Timing Belt Combinations		
Drive Pulley Teeth	Driven Pulley Teeth	Belt Length
28	32	475 mm
32	22	405 mm
32	28	475 mm
32	32	475 mm
44	22	500 mm
44	28	500 mm
44	32	520 mm
48	22	500 mm
48	28	535 mm
48	32	535 mm

Timing Chain Combinations		
Drive Sprocket Teeth	Driven Sprocket Teeth	Pitch Length
12	10	35
16	10	37
18	10	39
20	10	39

Service Parts

Parallel Shaft Bottom Mount Package



Service Parts

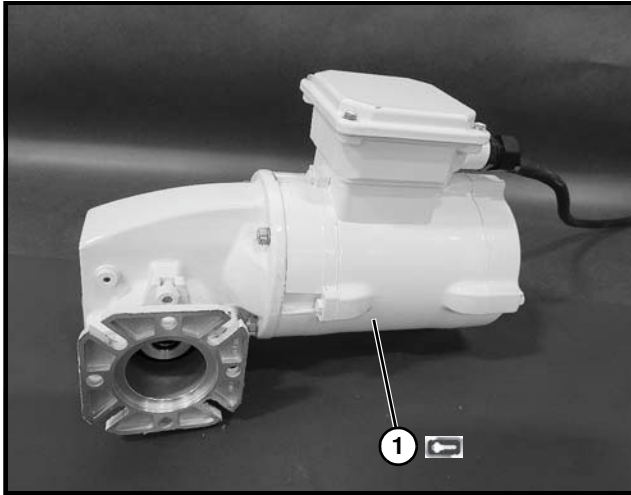
Item	Part Number	Description
1	531129	Mounting Plate
2	450028P	Cover
3	450178MSS	Slide Bar, Tensioner
4	450181MSS	Cover Mounting Bracket
5	639971MSS	Drop-In Tee Bar
6	807-968	Flange Hex Screw, M5-0.80 x 10 mm
7	911-120	Spring Lock Washer
8	911-201	Washer, 1/4"
9	960516MSS	Hex Head Cap Screw, M5-0.80 x 16 mm
10	960510MSS	Hex Head Cap Screw, M5-0.80 x 10 mm
11	960635MSS	Hex Head Cap Screw, M6-1.00 x 35 mm
12	960816MSS	Hex Head Cap Screw, M8-1.25 x 16 mm
13	801-139	Nylon Bearing for Timing Belt only
14	802-123	Bearing for Timing Belt only
15	450101	Driven Pulley, 19 Tooth, 12 mm Bore for Timing Belt only
	450102	Driven Pulley, 22 Tooth, 12 mm Bore for Timing Belt only
	450104	Driven Pulley, 32 Tooth, 12 mm Bore for Timing Belt only
16	450392M	Drive Pulley, 28 Tooth, 18 mm Bore for Timing Belt only
	450393M	Drive Pulley, 32 Tooth, 18 mm Bore for Timing Belt only
	450394M	Drive Pulley, 44 Tooth, 18 mm Bore for Timing Belt only
	450395M	Drive Pulley, 48 Tooth, 18 mm Bore for Timing Belt only
17	814-104	Timing Belt, 15 mm x 405 mm Long
	814-065	Timing Belt, 15 mm x 475 mm Long
	814-101	Timing Belt, 15 mm x 500 mm Long
	814-108	Timing Belt, 15 mm x 520 mm Long
	814-064	Timing Belt, 15 mm x 535 mm Long
18	456048	Chain Tensioner for Timing Chain only
19	450182SS	Spacer for Timing Chain only
20	811-296	Driven Sprocket, 10 Tooth, 12 mm Bore for Timing Chain only
21	811-302	Drive Sprocket, 12 Tooth, 18 mm Bore for Timing Chain only
	811-304	Drive Sprocket, 16 Tooth, 18 mm Bore for Timing Chain only
	811-305	Drive Sprocket, 18 Tooth, 18 mm Bore for Timing Chain only
	811-306	Drive Sprocket, 20 Tooth, 18 mm Bore for Timing Chain only
22	456050	Timing Chain, 35 Pitch Length
	456052	Timing Chain, 37 Pitch Length
	456053	Timing Chain, 39 Pitch Length
23	960890MSS	Hex Head Cap Screw M8-1.25 x 90 mm
Service parts can be obtained through your distributor or directly from Dorner Mfg. Corp. (800) 397-8664 or customerservice@dorner.com		


Timing Belt Combinations		
Drive Pulley Teeth	Driven Pulley Teeth	Belt Length
28	32	475 mm
32	18	405 mm
32	22	450 mm
32	32	475 mm
44	19	475 mm
44	22	500 mm
44	32	520 mm
48	19	500 mm
48	22	500 mm
48	32	535 mm

Timing Chain Combinations		
Drive Sprocket Teeth	Driven Sprocket Teeth	Pitch Length
12	10	35
16	10	37
18	10	39
20	10	39

Service Parts

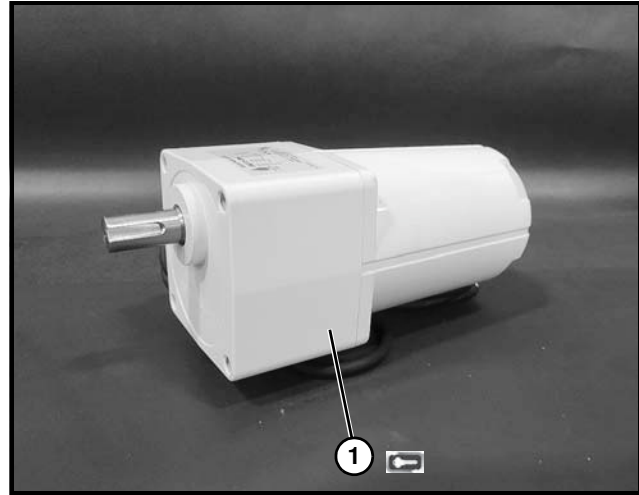
90° Gearmotor




Item	Part Number	Description
1 	826-1666	Motor, 0.11 kW (0.16 Hp), 230/460 Volts, 58 RPM, 60 Hz, 3 Phase
	826-1665	Motor, 0.24 kW (0.33 Hp), 230/460 Volts, 172 RPM, 60 Hz, 3 Phase
	826-1664	Motor, 0.24 kW (0.33 Hp), 230/460 Volts, 344 RPM, 60 Hz, 3 Phase
	826-1683	Motor, 0.12 kW (0.16 Hp), 230/400 Volts, 47 RPM, 50 Hz, 3 Phase
	826-1682	Motor, 0.25 kW (0.33 Hp), 230/400 Volts, 142 RPM, 50 Hz, 3 Phase
	826-1681	Motor, 0.25 kW (0.33 Hp), 230/400 Volts, 280 RPM, 50 Hz, 3 Phase

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

Parallel Shaft Gearmotor



Item	Part Number	Description
1 	826-319	Motor, 0.09 kW (0.12 Hp), 115 Volts, 167 RPM, 60 Hz, 1 Phase
	826-320	Motor, 0.09 kW (0.12 Hp), 115 Volts, 50 RPM, 60 Hz, 1 Phase
	826-321	Motor, 0.09 kW (0.12 Hp), 230 Volts, 167 RPM, 60 Hz, 3 Phase
	826-322	Motor, 0.09 kW (0.12 Hp), 230 Volts, 50 RPM, 60 Hz, 3 Phase

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

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.

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