Introduction

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.

IMPORTANT

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

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 2200 series conveyors are covered by Patent Numbers 5,174,435, 6,298,981, 6,422,382 and corresponding patents and patent applications in other countries.

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

IMPORTANT

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

### 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

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

### 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.

### WARNING

Gearmotors may be HOT. DO NOT TOUCH Gearmotors.
Product Description

Refer to Figure 1 for typical components.

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<table>
<thead>
<tr>
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<tbody>
<tr>
<td>1</td>
<td>Conveyor</td>
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<tr>
<td>2</td>
<td>Gearmotor Mounting Package</td>
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<td>Gearmotor</td>
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<td>Guiding &amp; Accessories</td>
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<td>Support Stand</td>
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<td>Variable Speed Controller</td>
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<td>9</td>
<td>Drive End</td>
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<tr>
<td>10</td>
<td>Idler/Tension End</td>
</tr>
</tbody>
</table>

Specifications

Models:

Flat Belt 2200 Series Conveyor

<table>
<thead>
<tr>
<th>Flat Belt 2200 Series Conveyor</th>
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<tbody>
<tr>
<td>202 M WW—LLL G D I D PA PD BB</td>
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<tr>
<td>Belt Type Profile (D side) Profile (A side) Motor Shaft Position Idler Tail Type Drive Tail Type Tracking / Mounting Brackets Conveyor Width Conveyor Length Document Language</td>
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</table>

Cleated Belt 2200 Series Conveyor

<table>
<thead>
<tr>
<th>Cleated Belt 2200 Series Conveyor</th>
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<tbody>
<tr>
<td>2C2 M WW—LLLL G D I D PP C BB SSSS</td>
</tr>
<tr>
<td>Cleat Spacing Belt Material Cleat Type Profiles Motor Shaft Position Idler Tail Type Drive Tail Type Tracking / Mounting Brackets Conveyor Width Conveyor Length Document Language</td>
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</table>

Conveyor Supports:

Maximum Distances:

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
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</thead>
<tbody>
<tr>
<td>1 = 18” (457 mm)**</td>
<td></td>
</tr>
<tr>
<td>2 = 6 ft (1829 mm)***</td>
<td></td>
</tr>
<tr>
<td>3 = 18” (457 mm)</td>
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</tr>
</tbody>
</table>

** For Heavy Load Bottom Mount Package, mount support under gear head.

*** For conveyors longer than 12 ft (3658 mm), install support at joint.
### Specifications

**Specifications:**

<table>
<thead>
<tr>
<th>Conveyor Width Reference (WW)</th>
<th>02</th>
<th>03</th>
<th>04</th>
<th>05</th>
<th>06</th>
<th>08</th>
<th>10</th>
<th>12</th>
<th>18</th>
<th>21</th>
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<tbody>
<tr>
<td>Conveyor Belt Width</td>
<td>1.75&quot; (44mm)</td>
<td>2.75&quot; (70mm)</td>
<td>3.75&quot; (95mm)</td>
<td>5&quot; (127mm)</td>
<td>6&quot; (152mm)</td>
<td>8&quot; (203mm)</td>
<td>10&quot; (254mm)</td>
<td>12&quot; (305mm)</td>
<td>18&quot; (457mm)</td>
<td>21&quot; (533mm)</td>
<td>24&quot; (609mm)</td>
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<tr>
<td>Maximum Conveyor Load*</td>
<td>30 lb (14kg)</td>
<td>35 lb (16kg)</td>
<td>42 lb (19kg)</td>
<td>50 lb (23kg)</td>
<td>60 lb (27kg)</td>
<td>70 lb (32kg)</td>
<td>80 lb (36kg)</td>
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<td>(See NOTE Below)</td>
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<tr>
<td>Conveyor Startup Torque*</td>
<td>2 in-lb (0.5Nm)</td>
<td>3 in-lb (0.6Nm)</td>
<td>4 in-lb (0.7Nm)</td>
<td>6 in-lb (0.9Nm)</td>
<td>8 in-lb (1.1Nm)</td>
<td>10 in-lb (1.4Nm)</td>
<td>12 in-lb (1.7Nm)</td>
<td>14 in-lb (2.0Nm)</td>
<td>18 in-lb (2.3Nm)</td>
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<tr>
<td>Belt Travel</td>
<td>4.0&quot; (88 mm) per revolution of pulley</td>
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<td></td>
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<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td>Maximum Belt Speed*</td>
<td>264 ft/minute (80.5 m/minute)</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Belt Takeup</td>
<td>0.38&quot; (10 mm) of stroke = 0.75&quot; (19 mm) of belt take-up</td>
<td></td>
<td></td>
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</tr>
</tbody>
</table>

### NOTE

Maximum conveyor loads based on:
- Non-accumulating product
- Product moving towards gearmotor
- Conveyor being mounted horizontal

* See Ordering and Specifications Catalog for details.

** Lengths available only in 6" (152 mm) & wider conveyors.
Installation Component List

Conveyor frame (two sections if longer than 12ft)
Conveyor brackets (4x)
Return rollers (for longer conveyors)

Required Tools

- Hex-key wrenches: 4 mm, 5 mm
- Level
- Torque wrench

Recommended Installation Sequence

- Install support stands (see accessory instructions)
- Assemble conveyor (if required)
- Attach mounting brackets to conveyor
- Attach conveyor to stands
- Install return rollers on conveyor (optional)
- Mount gearmotor mounting package (see accessory instructions)
- Attach guides/accessories (see page 20 through page 44 of “Service Parts” section for details)

Conveyors Up to 12ft (3658mm)

No assembly is required. Install mounting brackets and return rollers. Refer to “Mounting Brackets” on page 8 and “Return Rollers” on page 9.

Conveyors Longer Than 12ft (3658mm)

1. Locate and arrange conveyor sections by section labels (Figure 4, item 1).

2. On tension end of the conveyor, identified with a label (Figure 5, item 1), push in head plate assembly (Figure 5, item 2): On both sides of conveyor, loosen and move cam tracking assemblies (Figure 5, item 3) (if equipped) away from head plates, then loosen fastening screws (Figure 5, item 4) and push head plate assembly inward.

3. Roll out conveyor belt and place conveyor frame sections (Figure 6, item 1) into belt loop.
4. Join conveyor sections and install frame connector plates (Figure 7, item 1) or connector/mount brackets (Figure 7, item 2) and screws (Figure 7, item 3) on both sides as indicated. Tighten screws to 60 in-lb (7 Nm).

5. With a 5 mm hex-key wrench, rotate pinion gear (Figure 8, item 1) to tension the conveyor belt. Tighten fastening screws (Figure 8, item 2) on both sides of conveyor to 80 in-lb (9 Nm). For proper tensioning, refer to “Conveyor Belt Tensioning” on page 13.


7. If equipped with cam tracking assemblies (Figure 5, item 3), reposition and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 14.

8. If drive tail is equipped with tracking cam assemblies (Figure 9, item 1), remove 3rd head plate screw (Figure 9, item 2), from head plate with the output shaft.

Mounting Brackets

1. Locate brackets. Exploded views shown in Figure 10 & Figure 11.

2. Remove screws (Figure 10, item 1 & 2) & (Figure 11, item 1 & 2), washers (Figure 10, item 3), nuts (Figure 10, item 4) and T-bars (Figure 10, item 5) from brackets.

3. Insert T-bars (Figure 10, item 5) & (Figure 11, item 5) into conveyor side slots (Figure 12, item 1). Fasten brackets (Figure 12, item 2) to conveyor with mounting screws (Figure 12, item 3).
Installation

4. Fasten brackets to support stand with mounting screws (Figure 12, item 4), washers (Figure 12, item 5) and nuts (Figure 12, item 6).
5. Tighten screws (Figure 12, item 3 & 4) to 60 in-lb (7 Nm).

Return Rollers

Cleated Belt and 2–6” (51–152 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded views shown in Figure 13 & Figure 14.
2. Remove screws (Figure 13, item 1) & (Figure 13, item 1) and clips (Figure 13, item 2) from roller assembly.

NOTE
Mounting brackets for flat belt conveyors shown.

8–24” (203–610 mm) Wide Flat Belt Conveyors

1. Locate return rollers. Exploded view shown in Figure 16.
2. Remove screws (Figure 16, item 1) and clips (Figure 16, item 2) from roller assembly.
3. Install roller assembly as shown (Figure 17, item 1). Tighten screws (Figure 17, item 2) to 60 in-lb (7 Nm).
Preventive Maintenance and Adjustment

Required Tools

Standard Tools
- Hex-key wrenches: 2.5 mm, 4 mm, 5 mm
- Arbor press

Special Tools
- 807–1716 Bearing Puller Tool (or equivalent)
- 450293 Bearing Installation Tool (Bearing Pusher)
- 456063 Bearing Removal Tool

Checklist
- Keep service parts on hand (see “Service Parts” section for recommendations)
- Keep supply of belt cleaner
- Clean entire conveyor and knurled pulley while disassembled
- Replace worn or damaged parts

Lubrication
No lubrication is required. Replace bearings if worn.

Maintaining Conveyor Belt

Troubleshooting
Inspect conveyor belt for:
- Surface cuts or wear
- Stalling or slipping
- Damage to V-guide

Surface cuts and wear indicate:
- Sharp or heavy parts impacting belt
- Jammed parts
- Improperly installed bottom wipers (if installed)
- Accumulated dirt in wipers (if installed)
- Foreign material inside the conveyor
- Improperly positioned accessories
- Bolt-on guiding is pinching belt

Stalling or slipping indicates:
- Excessive load on belt
- Conveyor belt or drive timing belt are not properly tensioned
- Worn knurl or impacted dirt on drive pulley
- Intermittent jamming or drive train problems

Damage to V-guide indicates:
- Twisted or damaged conveyor frame
- Dirt impacted on pulleys
- Excessive or improper side loading

Cleaning
Use Dorner Belt Cleaner. Mild soap and water may also be used. Do not soak the belt.

For /05 woven polyester and /06 black anti-static belts, use a bristled brush to improve cleaning.

Conveyor Belt Replacement

Conveyor Belt Replacement Sequence
Remove old conveyor belt:
- Conveyor without Stands or Gearmotor Mounting Package
- Conveyor with Stands and Gearmotor Mounting Package

- Install new conveyor belt
- Tension conveyor belt

⚠️ WARNING ⚠️
Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guards or performing maintenance.
Preventive Maintenance and Adjustment

Belt Removal for Conveyor Without Stands or Gearmotor Mounting Package

1. If equipped, remove bottom wipers (Figure 18, item 1): Remove fastening screws (Figure 18, item 2) then remove wiper.

2. If equipped, remove return rollers and guiding and accessories from one side of conveyor.

3. On tension end of the conveyor, identified with a label (Figure 19, item 1), push in head plate assembly (Figure 19, item 2): On both sides of conveyor, loosen and move cam tracking assemblies (Figure 19, item 3) (if equipped) away from head plates, then loosen fastening screws (Figure 19, item 4) and push head plate assembly inward.

4. Remove conveyor belt.

Belt Removal for Conveyor With Stands and Gearmotor Mounting Package

1. Place temporary support stands (Figure 20, item 1) at both ends of the conveyor. Place an additional support stand under the drive motor (Figure 20, item 2), if equipped. See WARNING.

2. Remove mounting brackets (Figure 20, item 3) from one side of conveyor. (Reverse steps 3 & 4 of “Mounting Brackets” section beginning on page 8.) If equipped with heavy load drive package, remove brackets from side opposite drive cover (Figure 21, item 1).

3. If equipped, remove bottom wipers (Figure 18, item 1): Remove fastening screws (Figure 18, item 2) then remove wiper (Figure 18, item 1).

4. If equipped, remove return rollers, guiding and accessories from side opposite drive cover (Figure 21, item 1).

5. If equipped with heavy load drive package, remove drive support bracket (Figure 21, item 2): Remove bracket screws (Figure 21, item 3) then remove bracket (Figure 21, item 2).

WARNING

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

Figure 18

Figure 19

Figure 20

Figure 21
Preventive Maintenance and Adjustment

6. On tension end of the conveyor, identified with a label (Figure 22, item 1), push in head plate assembly (Figure 22, item 2): On both sides of conveyor, loosen and move cam tracking assemblies (Figure 22, item 3) (if equipped) away from head plates, then loosen fastening screws (Figure 22, item 4) and push head plate assembly inward.

7. Remove belt (Figure 23, item 1) from conveyor.

Belt Installation for Conveyor without Stands or Gearmotor Mounting Package

1. Orient belt so splice leading fingers (Figure 24, item 1) point in the direction of belt travel as identified by the conveyor directional label (Figure 24, item 2).

2. Slide belt onto the conveyor frame assembly.


4. If equipped, install wipers, return rollers and guiding.

Belt Installation for Conveyor with Stands and Gearmotor Mounting Package

1. Ensure temporary support stands (Figure 20, item 1) are placed at both ends of the conveyor. Place an additional support stand under the drive motor (Figure 20, item 2), if equipped. See WARNING.

2. Orient belt so splice leading fingers (Figure 24, item 1) point in the direction of belt travel as identified by the conveyor directional label (Figure 24, item 2).

3. Install belt (Figure 25, item 1) on conveyor. Lift conveyor slightly to avoid pinching belt on temporary support stands.

4. Re-install conveyor mounting brackets. Refer “Mounting Brackets” beginning on page 8, steps 3 through 5.

5. If equipped with a heavy load drive package, re-install drive support bracket (Figure 21, item 2).


7. If equipped, re-install wipers, return rollers and guiding.

WARNING

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

Figure 22

Figure 23

Figure 24

Figure 25
Preventive Maintenance and Adjustment

Conveyor Belt Tensioning

1. On tension end of the conveyor, identified with a label (Figure 26, item 1), adjust head plate assembly (Figure 26, item 2): On both sides of conveyor, loosen fastening screws (Figure 26, item 3) and rotate pinion gear (Figure 26, item 4) to adjust head plate assembly.

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks (Figure 27, item 1 & 2). Replace belt if proper tensioning can not be obtained while aligning the end of the conveyor frame with or between the tensioning marks. See NOTE.

Conveyors with 1.25” (32 mm) Diameter Pulleys

1. On tension end of the conveyor, identified with a label (Figure 26, item 1), adjust head plate assembly (Figure 26, item 2): On both sides of conveyor, loosen fastening screws (Figure 26, item 3) and rotate pinion gear (Figure 26, item 4) to adjust head plate assembly.

2. Adjust head plate assembly so end of conveyor frame aligns with or between the head plate tensioning marks (Figure 27, item 1 & 2). Replace belt if proper tensioning can not be obtained while aligning the end of the conveyor frame with or between the tensioning marks. See NOTE.

Conveyors with Nose Bar Idlers

1. On tension end of the conveyor, identified with a label (Figure 28, item 1), adjust head plate assembly (Figure 28, item 2): On both sides of conveyor, loosen fastening screws (Figure 28, item 3) and rotate pinion gear (Figure 28, item 4) to adjust head plate assembly.

2. Adjust head plate assembly so the edge of the axle support plate (Figure 29, item 1) is separated from the end of the conveyor (Figure 29, item 2) by 1.125” (29 mm). Replace belt if proper tensioning can not be obtained within a distance of 1.50” (38 mm). See NOTE.

NOTE

On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12” (44 – 305 mm) wide conveyors and 50 in-lb (4.5 Nm) for an 18 – 24” (457 – 610 mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten fastening screws (Figure 26, item 3) on both sides of conveyor to 60 in-lb (7 Nm).

4. If equipped with cam tracking assemblies (Figure 26, item 5), position against head plates and adjust belt tracking. Refer to “Conveyor Belt Tracking” on page 14.

A WARNING

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

NOTE

On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12” (44 – 305 mm) wide conveyors and 50 in-lb (4.5 Nm) for an 18 – 24” (457 – 610 mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.
Preventive Maintenance and Adjustment

Conveyor Belt Tracking

V-Guided Belts

V-guided belts do not require tracking adjustment.

Non V-Guided Belts

Non V-guided belt conveyors are equipped with belt tracking cam assemblies (Figure 30, item 1) for belt tracking adjustment.

When adjusting belt tracking, always adjust the discharge end of the conveyor first. To adjust belt tracking:

5. Ensure head plate fastening screws (Figure 30, item 2) on both sides of conveyor are tightened.
6. On both sides of conveyor, loosen two (2) cam fastening screws (Figure 30, item 3). Adjust cams (Figure 30, item 4) until indicator slots (Figure 30, item 5) are horizontal and facing end of conveyor. Then slide cam assemblies against head plates (Figure 30, item 6) and re-tighten cam fastening screws (Figure 30, item 3) to 60 in-lb (7 Nm).
7. On the side toward which the belt is tracking, loosen head plate fastening screws (Figure 30, item 2).
8. With the conveyor running, use a 5 mm hex-key wrench to rotate the tracking cam (Figure 30, item 4) in small increments until the belt tracks in the center of the conveyor. Then while holding the cam in position, re-tighten the head plate fastening screws (Figure 30, item 2) with a 4 mm hex-key wrench to 60 in-lb (7 Nm).

NOTE

On pinion gear, do not exceed a torque of 25 in-lb (2.8 Nm) for 2 – 12” (44 – 305 mm) wide conveyors or 50 in-lb (4.5 Nm) for an 18 – 24” (457 – 610 mm) wide conveyor. Over tensioning the conveyor belt could cause excessive pulley bearing load and early failure.

3. After adjusting proper tensioning, tighten fastening screws (Figure 28, item 3) on both sides of conveyor to 60 in-lb (7 Nm).
4. If equipped with cam tracking assemblies (Figure 28, item 5) position against head plates and adjust belt tracking. Refer to “Conveyor Belt Tracking”, next section.
Pulley Removal

**WARNING**

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

Leaving the conveyor belt in place, remove the desired pulley following the corresponding instructions below:

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

### A – Idler Pulley Removal

1. On one side of the conveyor, loosen two (2) head plate fastening screws (Figure 31, item 1) and remove them.

### NOTE

To prevent damage to the head plates and pulley, be sure to remove them slowly because they are not attached to pulley.

2. Remove the head plate (Figure 32, item 1) from the conveyor frame.

3. Pulley will slide out of opposite head plate and drop into slack of belt (Figure 33).

4. Slide spindle out of the belt loop.

---

*Figure 31*

*Figure 32*

*Figure 33*
B – Drive Pulley Removal

⚠️ WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

1. On one side of the conveyor, loosen two (2) head plate fastening screws (Figure 34, item 1) and remove.

NOTE

To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.

2. Remove the head plate (Figure 35, item 1) from the conveyor frame.

3. Drive pulley will slide out of opposite head and drop into slack of belt.

4. Slide the drive pulley out of the belt loop.

Bearing Removal & Replacement

Removal

1. Place bearing removal tool part #456063 (Figure 36, item 1) below bearing (Figure 36, item 2) with lip (Figure 36, item 3) located in gap (Figure 36, item 4) between bearing and spindle hub (Figure 36, item 5) as shown.

2. Using a puller part #807-1716 (Figure 37, item 1), remove and discard bearing.

A WARNING

Drive shaft keyway may be sharp. HANDLE WITH CARE.

NOTE

To prevent damage to the head plates, be sure to remove them slowly because they are not attached to pulley.

1. Do not use any removed bearings. Replace them.

IMPORTANT

Figure 36

Figure 37

Figure 34

Figure 35
Preventive Maintenance and Adjustment

Replacement

1. Inspect the head plates bearing seating surface (Figure 38, item 1). If they are worn or damaged, replace. See “Service Parts” on page 20.

2. Inspect spindle (Figure 39, item 1). Replace if worn.
3. Slide bearing (Figure 39, item 2) onto spindle.

4. Using an arbor press or similar device, press bearing onto pulley shaft (Figure 40).

5. Repeat steps 1 through 4 for each bearing.

Drive Pulley and Idler Pulley Installation

Drive Pulley Installation

1. With opposite head plate installed, position the drive pulley through the loop of the belt, into the opposite head plate.
2. Place the head plate (Figure 41, item 1) and attach the head plate to the conveyor frame with the two (2) screws removed. Tighten screws 60 in-lb (7 Nm).

Idler Pulley Installation

1. With opposite head plate installed, position the idler pulley through the loop of the belt, into the opposite head plate.
2. Place the head plate (Figure 42, item 1) and attach the head plate to the conveyor frame with the two (2) screws removed and hand tighten.
Preventive Maintenance and Adjustment

Nose Bar Bearing Replacement

1. On both sides of conveyor, use a 4 mm hex-key wrench to loosen cam fastening screws (Figure 43, item 1) and slide cam assemblies toward the center of the conveyor.

2. On both sides of conveyor, use a 4 mm hex-key wrench to loosen head plate fastening screws (Figure 43, item 2) to remove belt tension. Then remove belt from end of conveyor.

3. On one side of conveyor, use a 3 mm and 4 mm hex-key wrench to remove head plate fastening screws (Figure 43, item 3) & (Figure 43, item 2) and remove head plate (Figure 43, item 4).

4. Slide bearing rods (Figure 44, item 1) out side of conveyor and replace bearings (Figure 44, item 2) as necessary.

5. After replacing bearings, re-install head plate (Figure 43, item 4). Use a 3 mm hex-key wrench to tighten one (1) fastening screw (Figure 43, item 3) to 30 in-lb (3.4 Nm). Leave two (2) fastening screws (Figure 43, item 2) loose for belt tensioning.

6. Re-install belt on end of conveyor, then tension the belt. See “Conveyor Belt Tensioning” on page 13.

7. Re-position the cam assemblies against the head plates and adjust belt tracking. See “Conveyor Belt Tracking” on page 14.
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.

2” (51 mm) Wide Conveyor

C & D Position

A & B Position

19 Drive Spindle Kit

20 Nosebar Drive Spindle Kit

21 Idler Spindle Kit
## Service Parts

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
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<td>950612M</td>
<td>Low Head Cap Screw, M6 x 12 mm</td>
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<td>2</td>
<td>240425</td>
<td>Head Plate LH</td>
</tr>
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<td>3</td>
<td>240427</td>
<td>Head Plate LH Drive Side, Position A and B</td>
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<td>4</td>
<td>240428</td>
<td>Head Plate RH Drive Side, Position C and D</td>
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<td>5</td>
<td>22BK2</td>
<td>Bearing Kit (x2)</td>
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<td>Bearing Kit (x4)</td>
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<td>950610M</td>
<td>Low Head Cap Screw, M6 x 10 mm</td>
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<tr>
<td>11</td>
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<td>Tension Slide Bar</td>
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<tr>
<td>12</td>
<td>240420</td>
<td>Rack Gear, 14.5 Degree PA x 24 P</td>
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<tr>
<td>13</td>
<td>240423</td>
<td>Pinion, 2” (51 mm)</td>
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<td>14</td>
<td>240422</td>
<td>Pinion Pin</td>
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<td>456402</td>
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<td>247602</td>
<td>Nosebar Drive Spindle, Lagged 2” (51mm)</td>
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<tr>
<td>16</td>
<td>980422M</td>
<td>Square Key, 4 mm x 22 mm</td>
</tr>
<tr>
<td>17</td>
<td>240420-LLLLL</td>
<td>2” (51mm) Frame</td>
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<tr>
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<tr>
<td>19</td>
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<td>22D-02</td>
<td>Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 15)</td>
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<tr>
<td>21</td>
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<td>Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)</td>
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**LLLLL** = part length in inches with 2 decimal places

Example: Part Length = 55.08” **LLLLL** = 05508
Service Parts
3” (76 mm) to 6” (152 mm) Wide Conveyor

C & D Position

A & B Position

21 Drive Spindle Kit

23 Idler Spindle Kit

22 Nosebar Drive Spindle Kit

2200 Series End Drive Conveyors

Dorner Mfg. Corp. 22 851-452 Rev. L
<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
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<tbody>
<tr>
<td>1</td>
<td>950612M</td>
<td>Low Head Cap Screw, M6 x 12 mm</td>
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<td>Head Plate LH</td>
</tr>
<tr>
<td>3</td>
<td>240427</td>
<td>Head Plate LH Drive Side, Position A and B</td>
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<td>4</td>
<td>240428</td>
<td>Head Plate RH Drive Side, Position C and D</td>
</tr>
<tr>
<td>5</td>
<td>22BK2</td>
<td>Bearing Kit (x2)</td>
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<tr>
<td>6</td>
<td>2473WW</td>
<td>Idler Spindle</td>
</tr>
<tr>
<td>7</td>
<td>808–020</td>
<td>Magnet, 0.25” Dia. x 0.25” long</td>
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<td>8</td>
<td>450226SSP</td>
<td>Sleeve, 0.25” Magnet (Stainless Steel)</td>
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<td>9</td>
<td>240426</td>
<td>Head Plate RH</td>
</tr>
<tr>
<td>10</td>
<td>950610M</td>
<td>Low Head Cap Screw, M6 x 10 mm</td>
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<td>Tension Slide Bar</td>
</tr>
<tr>
<td>12</td>
<td>240420</td>
<td>Rack Gear, 14.5 Degree PA x 24P</td>
</tr>
<tr>
<td>13</td>
<td>240421</td>
<td>Pinion Bushing</td>
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<tr>
<td>14</td>
<td>2030WWM</td>
<td>Pinion Gear</td>
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<td>4564WW</td>
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<td>Square Key, 4 mm x 22 mm</td>
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<td>2404WW-LLLLL</td>
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<td>Conveyor Bed Plate</td>
</tr>
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<td>19</td>
<td>807–1105</td>
<td>Flat Head Torx Screw, M6 x 10 mm</td>
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<td>Cam Mounting Assembly</td>
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<td>21</td>
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<td>Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 15)</td>
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<td>22D–WW</td>
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<td>Nosebar Drive Spindle Kit, Position C and D – Lagged, Smooth (Includes Items 1, 2, 4, 5, 9 and 15)</td>
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<tr>
<td>23</td>
<td>22T–WW</td>
<td>Idler Spindle Kit (Includes Items 1 and 2 and 5 through 10)</td>
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**Note:**
- WW = Conveyor width reference: 03, 04, 05, 06
- LLLLL = part length in inches with 2 decimal places
- Example: Part Length = 55.08” LLLLL = 05508
Service Parts

8" (203 mm) to 12" (305 mm) Wide Conveyor

22 Drive Spindle Kit

24 Idler Spindle Kit

23 Nosebar Drive Spindle Kit

C & D Position

A & B Position
## Service Parts

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
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<tbody>
<tr>
<td>1</td>
<td>950612M</td>
<td>Low Head Cap Screw, M6 x 12 mm</td>
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<td>2</td>
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<td>Head Plate, LH</td>
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<td>3</td>
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<td>Head Plate, LH Drive Side, Position A and B</td>
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<td>4</td>
<td>240428</td>
<td>Head Plate RH Drive Side, Position C and D</td>
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<td>Bearing Kit (x2)</td>
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<td>22BK4</td>
<td>Bearing Kit (x4)</td>
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<td>Idler Spindle</td>
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<tr>
<td>7</td>
<td>808-020</td>
<td>Magnet, 0.25” Dia. x 0.25” long</td>
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<td>8</td>
<td>450226SSP</td>
<td>Sleeve, 0.25” Magnet Stainless Steel</td>
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<td>9</td>
<td>240426</td>
<td>Head Plate RH</td>
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<tr>
<td>10</td>
<td>950610M</td>
<td>Low Head Cap Screw, M6 x 10 mm</td>
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<td>11</td>
<td>240329</td>
<td>Tension Slide Bar</td>
</tr>
<tr>
<td>12</td>
<td>240420</td>
<td>Rack Gear, 14.5 Degree PA x 24P</td>
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<td>Side Rail, LH</td>
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<tr>
<td>14</td>
<td>240414-LLLLL</td>
<td>Center Rail</td>
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<td>15</td>
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<td>Pinion Gear</td>
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<td>16</td>
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<td>Nosebar Drive Spindle, Lagged</td>
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<tr>
<td>18</td>
<td>980422M</td>
<td>Square Key, 4 mm x 22 mm</td>
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<td>19</td>
<td>2405WWW-LLLLL</td>
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<td>Flat Head Torx Screw, M6 x 10 mm</td>
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<td>21</td>
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<td>Cam Mounting Assembly</td>
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<tr>
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<td>Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 17)</td>
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<td>24</td>
<td>22T-WW</td>
<td>Idler Spindle Kit (Includes Items 1, 2 and 5 through 10)</td>
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**WW** = Conveyor width reference: 08, 10, 12

**LLLLL** = part length in inches with 2 decimal places

Example: Part Length = 55.08” **LLLLL** = 05508
Service Parts
18" (457 mm) to 24" (610 mm) Wide Conveyor

C & D Position

A & B Position

23 Drive Spindle Kit

24 Nosebar Drive Spindle Kit

25 Idler Spindle Kit
## Service Parts

<table>
<thead>
<tr>
<th>Item</th>
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<td>240425</td>
<td>Head Plate, LH</td>
</tr>
<tr>
<td>3</td>
<td>240427</td>
<td>Head Plate LH Drive Side, Position A and B</td>
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<td>4</td>
<td>240428</td>
<td>Head Plate, RH Drive Side, Position C and D</td>
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<td>Bearing Kit (x2)</td>
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<td>22BK4</td>
<td>Bearing Kit (x4)</td>
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<td>7</td>
<td>808–020</td>
<td>Magnet, 0.25” Dia. x 0.25” long</td>
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<td>8</td>
<td>450226SSP</td>
<td>Sleeve, 0.25” Magnet Stainless Steel</td>
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<td>9</td>
<td>240426</td>
<td>Head Plate, RH</td>
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<tr>
<td>10</td>
<td>950610M</td>
<td>Low Head Cap Screw, M6 x 10 mm</td>
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<td>Tension Slide Bar</td>
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<tr>
<td>12</td>
<td>240420</td>
<td>Rack Gear, 14.5 Degree PA x 24 P</td>
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<td>16</td>
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<td>Center Rail Cross Support, 18” (457 mm)</td>
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<td>240418</td>
<td>Center Rail Cross Support, 21” (533 mm)</td>
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<td>240419</td>
<td>Center Rail Cross Support, 24” (610 mm)</td>
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<tr>
<td>19</td>
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<td>Square Key, 4 mm x 22 mm</td>
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<td>20</td>
<td>2405WW-LLLLL</td>
<td>Conveyor Bed Plate</td>
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<td>21</td>
<td>807–1105</td>
<td>Flat Head Torx Screw, M6 x 1 mm</td>
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<tr>
<td>22</td>
<td>240025</td>
<td>Cam Mounting Assembly</td>
</tr>
<tr>
<td>23</td>
<td>22A–WW</td>
<td>Drive Spindle Kit, Position A and B – Grooved (Includes Items 1, 2, 3, 5, 9 and 18)</td>
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<tr>
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<td>22D–WW</td>
<td>Drive Spindle Kit, Position C and D – Grooved (Includes Items 1, 2, 4, 5, 9 and 18)</td>
</tr>
<tr>
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<td>22NA–WW</td>
<td>Nosebar Drive Spindle Kit, Position A and B – Lagged, Smooth (Includes Items 1, 2, 3, 5, 9 and 18)</td>
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<td>25</td>
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WW = Conveyor width reference: 18, 21, 24
LLLLL = part length in inches with 2 decimal places
Example: Part Length = 55.08” LLLLL = 05508
Service Parts
Nosebar End Assembly

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<td>Nosebar Rod</td>
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<td>Knurl Pin, 0.125” DIA x 0.937” Lg</td>
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<td>Nose Bar Roller</td>
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<td>Socket Head Screw, M5 x 18 mm</td>
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<td>Nosebar Roller Kit</td>
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WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24
## Service Parts

### 04 3” (76 mm) Aluminum Side

For 2’ – 12’ Conveyors
For 13’ – 18’ Conveyors

<table>
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<td>See Chart Below</td>
<td>2200 Guide 3” (76mm) HS</td>
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<td>Single Drop-in Tee Bar (x10)</td>
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<td>Low Head Cap Screw M6 x 20 mm</td>
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### Item 2: 2200 Guide 3” (76mm) HS

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<td>Right Hand</td>
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<td>3’ (914mm)</td>
<td>Left Hand</td>
<td>280403–03600 N/A</td>
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<td>Right Hand</td>
<td>280403–03600 N/A</td>
</tr>
<tr>
<td>4’ (1219mm)</td>
<td>Left Hand</td>
<td>280403–04800 N/A</td>
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<td>280403–04800 N/A</td>
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<td>280403–07200 N/A</td>
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<td>280403–07200 N/A</td>
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<th>End Guide</th>
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<td>280403–07500 280401–09300</td>
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Service Parts

- 05 1.5” (38mm) Aluminum Side

For 2’ – 12’ Conveyors

For 13’ – 18’ Conveyors

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<td>Low Head Cap Screw M6 x 20 mm</td>
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<td>10’ (3048mm)</td>
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<td>11’ (3353mm)</td>
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07 Low to Side Wiper

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<td>Low Head Cap Screw M6 x 20 mm</td>
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<td>16’ (4877mm)</td>
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<tr>
<td>17’ (5182mm)</td>
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<tr>
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## Service Parts
### 09 Low to High Side

For 2’ – 12’ Conveyors

For 13’ – 18’ Conveyors

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<td>Low Head Cap Screw M6 x 20 mm</td>
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### Item 2: 2200 Guide 0.5” (13mm) HS

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<td>3’ (914mm)</td>
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<tr>
<td>14’ (4267mm)</td>
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<td>15’ (4572mm)</td>
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<tr>
<td>16’ (4877mm)</td>
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<td>280901–11700</td>
<td>280902–07500</td>
<td>280902–11700</td>
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<tr>
<td>17’ (5182mm)</td>
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<td>280902–07500</td>
<td>280902–12900</td>
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<tr>
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### Service Parts

#### 10 0.5” (13mm) Extruded Plastic

For 2’ – 12’ Conveyors
For 13’ – 18’ Conveyors

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<td>2200 Guide</td>
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<tr>
<td>4</td>
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<td>Single Drop-in Tee Bar (x10)</td>
</tr>
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<td>Low Head Cap Screw M6 x 20 mm</td>
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#### Item 2: 2200 Guide 0.5” (13mm) HS

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<td>Right Hand 281002–07500 281002–08100</td>
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<td>14” (4267mm)</td>
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<td>Right Hand 281002–07500 281002–09300</td>
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<td>15” (4572mm)</td>
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<td>Right Hand 281002–07500 281002–10500</td>
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<td>16” (4877mm)</td>
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<td>Right Hand 281002–07500 281002–11700</td>
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<td>17” (5182mm)</td>
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<td>Right Hand 281002–07500 281002–12900</td>
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<tr>
<td>18” (5486mm)</td>
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<td>Right Hand 281002–07500 281002–14100</td>
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#### Diagram: 2200 Series End Drive Conveyors
## Service Parts
### 13 Adjustable Guiding

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<td>4</td>
<td>202027M</td>
<td>Guide Mounting Shaft Vertical</td>
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<td>5</td>
<td>202028M</td>
<td>Guide Mounting Shaft Horizontal</td>
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<td>674175MP</td>
<td>Square Nut</td>
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<td>7</td>
<td>807–652</td>
<td>Cross Block</td>
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<td>807–948</td>
<td>Vinyl Shaft Cap</td>
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<td>Flat Extruded Guide (per foot)</td>
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## 14 Tool-Less Adjustable Guiding

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<td>352056</td>
<td>Tool-Less Guiding Assembly (Includes items 1 thru 9)</td>
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LLLLL = Length in inches with 2 decimal places.

Length Example: Length = 95.25" LLLLL = 09525
# Service Parts

## 0.5” (13mm) Cleated Belt Guiding

### For 2’ – 12’ Conveyors

- **Part Number**: 0.5” (13mm) Cleated Belt Guiding
- **Description**: Guide Retaining Clip, 2200 Guide, 0.47” (13mm) Cleated, Drop-In Tee Bar (x10), Low Head Cap Screw M6 x 20 mm

### For 13’ – 18’ Conveyors

- **Part Number**: 0.5” (13mm) HS
- **Description**: Guide Retaining Clip, 2200 Guide, 0.5” (13mm) Cleated, Drop-In Tee Bar (x10), Low Head Cap Screw M6 x 20 mm

<table>
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<th>Item</th>
<th>Part Number</th>
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<tr>
<td>1</td>
<td>200121</td>
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<td>2</td>
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<td>2200 Guide, 0.47” (13mm) Cleated</td>
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<td>3</td>
<td>639971MK10</td>
<td>Drop-In Tee Bar (x10)</td>
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<td>4</td>
<td>950620M</td>
<td>Low Head Cap Screw M6 x 20 mm</td>
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<td>4’ (1219mm)</td>
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<tr>
<td>16’ (4877mm)</td>
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<tr>
<td>17’ (5182mm)</td>
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<tr>
<td>18’ (5486mm)</td>
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</table>

2200 Series End Drive Conveyors
### 1” (25mm) Cleated Belt Guiding

#### For 2’ − 12’ Conveyors
- Item 1: 200121 Guide Retaining Clip
- Item 2: See Chart Below
- Item 3: 639971MK10 Drop-In Tee Bar (x10)
- Item 4: 950620M Low Head Cap Screw M6 x 20 mm

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
</tr>
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<tr>
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#### For 13’ − 18’ Conveyors

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<td>281702–07428</td>
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<tr>
<td>14’ (4267mm)</td>
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<td>Right Hand</td>
<td>281702–09228</td>
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<tr>
<td>15’ (4572mm)</td>
<td>Left Hand</td>
<td>281701–10428</td>
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<td></td>
<td>Right Hand</td>
<td>281702–10428</td>
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<tr>
<td>16’ (4877mm)</td>
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<td>281701–11628</td>
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<tr>
<td></td>
<td>Right Hand</td>
<td>281702–11628</td>
</tr>
<tr>
<td>17’ (5182mm)</td>
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<td>281701–12828</td>
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<td>Right Hand</td>
<td>281702–12828</td>
</tr>
<tr>
<td>18’ (5486mm)</td>
<td>Left Hand</td>
<td>281701–14028</td>
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<td>Right Hand</td>
<td>281702–14028</td>
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# Service Parts

## 2” (51mm) Cleated Belt Guiding

For 2’ – 12’ Conveyors  
For 13’ – 18’ Conveyors

<table>
<thead>
<tr>
<th>Item</th>
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<td>200121</td>
<td>Guide Retaining Clip</td>
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<tr>
<td>2</td>
<td>See Chart Below</td>
<td>2200 Guide 2.3” Cleated</td>
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<tr>
<td>3</td>
<td>639971MK10</td>
<td>Drop-In Tee Bar (x10)</td>
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<tr>
<td>4</td>
<td>950620M</td>
<td>Low Head Cap Screw M6 x 20 mm</td>
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<tr>
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<th>Length</th>
<th>End Guide</th>
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</thead>
<tbody>
<tr>
<td>2' (610mm)</td>
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<tr>
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<td>Right Hand 281903–03456</td>
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<td>Right Hand 281903–04656</td>
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<tr>
<td>5' (1524mm)</td>
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<tr>
<td></td>
<td>Right Hand 281903–05856</td>
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<tr>
<td>6' (1829mm)</td>
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<tr>
<td></td>
<td>Right Hand 281903–07056</td>
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</tr>
<tr>
<td>7' (2134mm)</td>
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<tr>
<td></td>
<td>Right Hand 281903–08256</td>
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</tr>
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<td>8' (2438mm)</td>
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<tr>
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<td>Right Hand 281903–09456</td>
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<td>Right Hand 281903–10656</td>
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<td>Right Hand 281903–11856</td>
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<th>End Guide</th>
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</thead>
<tbody>
<tr>
<td>12' (3658mm)</td>
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<td>Right Hand 281903–14256</td>
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<tr>
<td>13' (3962mm)</td>
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<td></td>
<td>Right Hand 281902–07428</td>
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<tr>
<td>14' (4267mm)</td>
<td>Left Hand 281901–07428</td>
<td>281901–09228</td>
<td></td>
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<tr>
<td></td>
<td>Right Hand 281902–07428</td>
<td>281902–09228</td>
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<tr>
<td>15' (4572mm)</td>
<td>Left Hand 281901–07428</td>
<td>281901–10428</td>
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<td>Right Hand 281902–07428</td>
<td>281902–10428</td>
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<tr>
<td>16' (4877mm)</td>
<td>Left Hand 281901–07428</td>
<td>281901–11628</td>
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<tr>
<td></td>
<td>Right Hand 281902–07428</td>
<td>281902–11628</td>
<td></td>
</tr>
<tr>
<td>17' (5182mm)</td>
<td>Left Hand 281901–07428</td>
<td>281901–12828</td>
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<tr>
<td></td>
<td>Right Hand 281902–07428</td>
<td>281902–12828</td>
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<tr>
<td>18' (5486mm)</td>
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Flared Side Guiding

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<td>202213</td>
<td>Side–Flare Mounting Guide 3' (914mm)</td>
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<td></td>
<td>202214</td>
<td>Side–Flare Mounting Guide 4' (1219mm)</td>
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<tr>
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<td>202215</td>
<td>Side–Flare Mounting Guide 5' (1524mm)</td>
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<td>202216</td>
<td>Side–Flare Mounting Guide 6' (1829mm)</td>
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<td>Flared Guide 45° 2' (610mm)</td>
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<td>202523M</td>
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<td>202523M</td>
<td>Flared Guide 45° 5' (1524mm)</td>
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<td>202523M</td>
<td>Flared Guide 45° 6' (1829mm)</td>
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<td>Drop–In Tee Bar</td>
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<td>910506M</td>
<td>Button Head Screw M5 x 6 mm</td>
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<tr>
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<td>911−512</td>
<td>Washer</td>
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<tr>
<td>7</td>
<td>950620M</td>
<td>Low Head Cap Screw M6 x 20 mm</td>
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## Service Parts
### Flat Belt Stand Mount Assembly

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>240831</td>
<td>Stand Mount</td>
</tr>
<tr>
<td>2</td>
<td>300150MK4</td>
<td>Drop-In Tee Bar (x4)</td>
</tr>
<tr>
<td>3</td>
<td>605279P</td>
<td>Washer</td>
</tr>
<tr>
<td>4</td>
<td>807–920</td>
<td>Square Nut M6</td>
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<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
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</thead>
<tbody>
<tr>
<td>5</td>
<td>920620M</td>
<td>Socket Head Screw M6 x 20 mm</td>
</tr>
<tr>
<td>6</td>
<td>950612M</td>
<td>Low Head Cap Screw M6 x 12 mm</td>
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## Cleated Belt Stand Mount Assembly

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<tr>
<td>1</td>
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<td>Cleated Mount Assembly</td>
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<td>300150MK4</td>
<td>Drop-In Tee Bar (x4)</td>
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<td>3</td>
<td>605279P</td>
<td>Washer</td>
</tr>
<tr>
<td>4</td>
<td>807–920</td>
<td>Square Nut M6</td>
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<tr>
<th>Item</th>
<th>Part Number</th>
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<tbody>
<tr>
<td>5</td>
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<td>Socket Head Screw M6 x 20 mm</td>
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## Service Parts

### Flat Belt Stand Mount Assembly for 2’ (610mm) Conveyors

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<td>240834</td>
<td>Stand Mount, RH 2’ (610mm)</td>
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<td>605279P</td>
<td>Washer</td>
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<tr>
<td>4</td>
<td>639971MK10</td>
<td>Drop-In Tee Bar (x10)</td>
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### Cleated Belt Stand Mount Assembly for 2’ (610mm) Conveyors

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<td>2</td>
<td>240853</td>
<td>Cleated Stand Bracket Assembly RH 2’ (610mm) Conveyor</td>
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<td>3</td>
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<td>4</td>
<td>639971MK10</td>
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Service Parts

Connecting Assembly without Stand Mount

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<tr>
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<td>Frame Connector Bar</td>
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Flat Belt Connecting Assembly with Stand Mount

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<td>240831</td>
<td>Stand Mount</td>
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<tr>
<td>2</td>
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<td>Square Nut M6 5 mm x 10 mm</td>
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<td>920620M</td>
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<td>6</td>
<td>950616M</td>
<td>Low Head Cap Screw M6 x 16 mm</td>
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<td>7</td>
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<td>Flat Belt Connecting Assembly with Stand Mounts</td>
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## Cleated Belt Connecting Assembly with Stand Mount

<table>
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<tr>
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<td>807-920</td>
<td>Square Nut M6 5 mm x 10 mm</td>
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<tr>
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<td>605279P</td>
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<tr>
<td>4</td>
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<td>Frame Connector Bar</td>
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<td>Low Head Cap Screw M6 x 16 mm</td>
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<tr>
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<td>240863</td>
<td>Cleated Belt Connecting Assembly with Stand Mounts</td>
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</table>

## 2” (51mm) to 6” (152mm) Flat Belt Return Roller

<table>
<thead>
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<tbody>
<tr>
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<td>Return Roller Guard – Short</td>
</tr>
<tr>
<td>2</td>
<td>240827</td>
<td>Return Roller Clip</td>
</tr>
<tr>
<td>3</td>
<td>802-027</td>
<td>Bearing</td>
</tr>
<tr>
<td>4</td>
<td>913-100</td>
<td>Dowel Pin</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Item</th>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>950616M</td>
<td>Low Head Cap Screw M6 x 16 mm</td>
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<td>240840</td>
<td>Roller Assembly (Includes Items 1, 3 and 4)</td>
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<td>240830</td>
<td>2” (51mm) to 6” (152mm) Flat Belt Return Roller Assembly</td>
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Service Parts

8” (203mm) to 24” (610mm) Flat Belt Return Roller

<table>
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<td>1</td>
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<td>Return Roller</td>
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<tr>
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<td>240827</td>
<td>Return Roller Clip</td>
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<tr>
<td>3</td>
<td>2409WW</td>
<td>Return Roller Guard</td>
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<tr>
<td>4</td>
<td>2410WW</td>
<td>Return Roller Rod</td>
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<table>
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<tr>
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<tbody>
<tr>
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WW = Conveyor width ref.: 02, 03, 04, 05, 06, 08, 10, 12, 18, 21, 24

Cleated Belt Return Roller

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<tr>
<td>1</td>
<td>240825</td>
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<tr>
<td>2</td>
<td>240828</td>
<td>Cleated Return Roller Clip</td>
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<tr>
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<td>802–027</td>
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<td>4</td>
<td>913–100</td>
<td>Dowel Pin</td>
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<table>
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<th>Item</th>
<th>Part Number</th>
<th>Description</th>
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</thead>
<tbody>
<tr>
<td>5</td>
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<td>Low Head Cap Screw M6 x 16 mm</td>
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<tr>
<td>6</td>
<td>240840</td>
<td>Roller Assembly (Includes Items 1, 3 and 4)</td>
</tr>
<tr>
<td>7</td>
<td>240832</td>
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</tbody>
</table>
Flat Belt Part Number Configuration
Refer to Dorner patent plate (Figure 45). From the model number, determine conveyor width (“WW”), length (“LLLL”) and belt type (“BB”). Use data to configure belt part number as indicated below. *Add “V” for V-guided belts.

22 - WW LLLL / BB V *

Cleated Belt Part Number Configuration
Refer to Dorner patent plate (Figure 45). From the model number, determine conveyor type (“T”), width (“WW”), length (“LLLL”), cleat type (“C”) and cleat spacing (“SSSS”). Use data to configure belt part number as indicated below. *Add “V” for V-guided belts.

2T - WW LLLL C SSSS V *
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.

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.

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