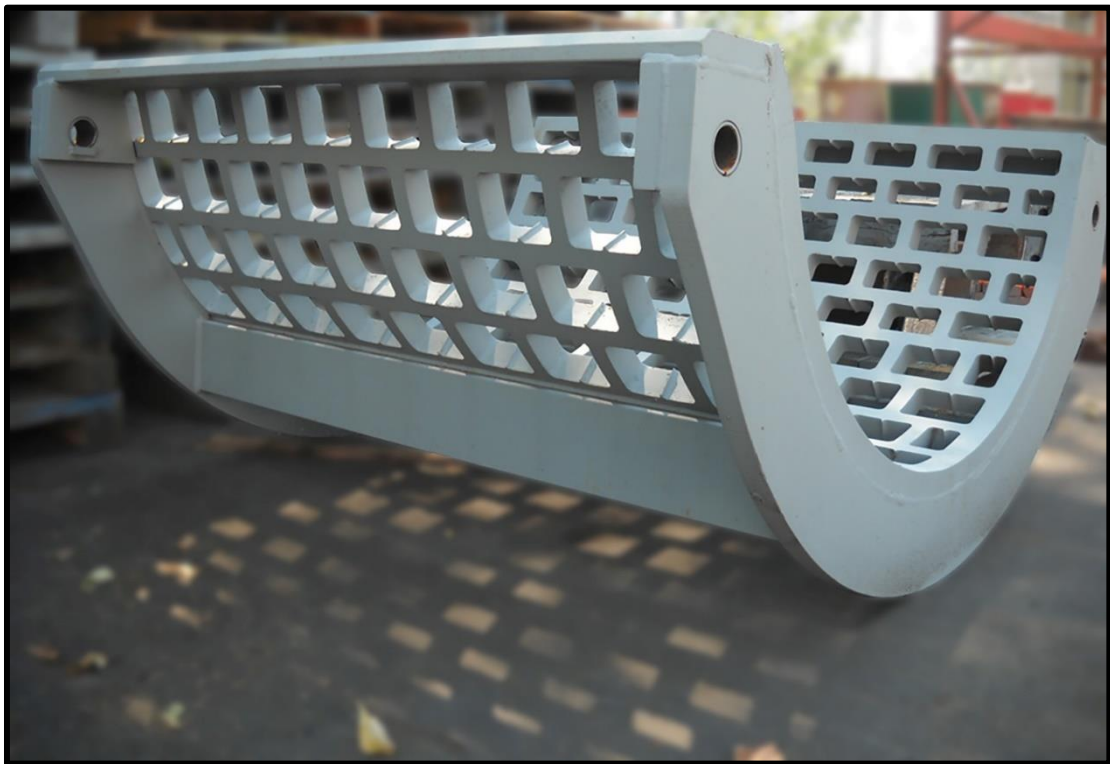




# **BRUNETTE MACHINERY**

## **GRIZZLY MILL HOG**

### **Grate Inspection and Replacement Instructions**





## GRIZZLY MILL HOG — GRATE

### INSPECTION

The Grizzly Mill grate is a wearing item and should be inspected periodically.

The grate liner of the Grizzly Mill Hog is made from 2-inch-thick wear-resistant AR500 material.

**NOTE:** The clearance gap between the striker bar tip and the grate is  $\frac{3}{8}$  inches.

As the grate liner wears, clearance will increase affecting product quality.

- The liner can be rebuilt by welding, as long as the wear does not exceed 20% ( $\frac{3}{8}$ " ) of the original thickness.
- As a preventative measure, it is recommended to build up the leading edge of the openings in the liner after the square corner has worn off. This will extend the life of the grate considerably.
  - Build up the worn corner with a soft underlay rod (7018) and top off with hard facing.
  - Several passes of hard surface weld work is best, as a single pass will be diluted by the underlay material, making the surface pass too soft.
  - This can be done to the first 5 or 6 rows of the liner when it is in its installed position.
- When the wear point of the grate liner is  $1\frac{3}{4}$ " –  $1\frac{5}{8}$ " it must be replaced.
- The grate liner can be replaced 3 times before the frame reaches its fatigue life.
- Inspect the grate shear pins. If there is damage, check the hardened bushing for wear or misalignment.
- In some situations, the shear pins will break completely. Inspect the grate frame location and confirm position.
- Replace shear pins as needed.



## GRIZZLY MILL HOG — GRATE (continued)

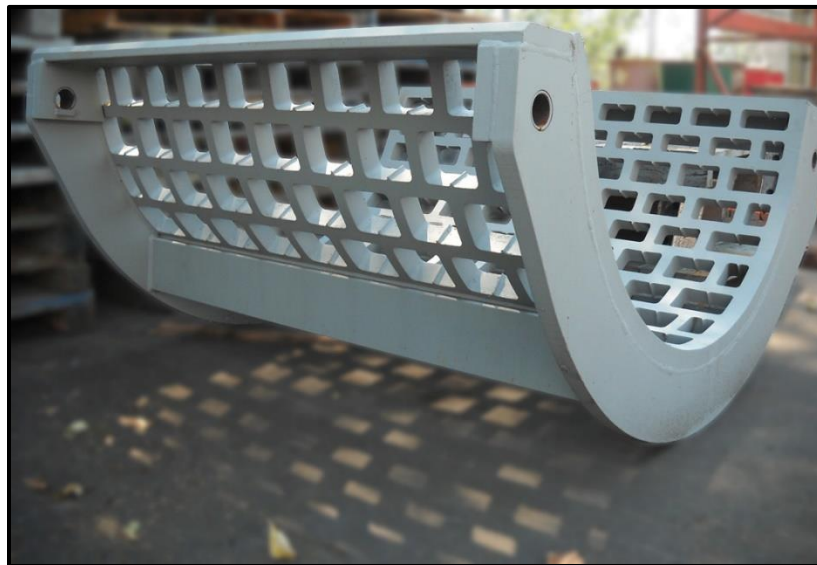
### REPLACEMENT

#### **CAUTION:**

When removing the grate for replacement or repair, **extreme care** must be taken to maintain the distance between the mounting holes as heavy welding will distort the frame. It is best to set the grate assembly into a jig with heavy spreader bars welded to each side.

Grate removal should be coordinated with a striker bar replacement. Removing all striker bars first will add clearance to assist in lifting the grate over the top of the rotor.

- If space underneath the hog permits, the grate can be removed by lowering it into the hog conveyor.
- For this purpose, two 1½" holes on each side of the lower box are provided. Insert two 1¼" diameter rods into these holes underneath the grate.
- The rods must be approx. 12" longer than the width of the Grizzly Mill Hog and reach from one side to the other.
- Remove the shear pins holding the grate and lower the grate onto the rods. The pins can be extracted or driven through into the frame.
- Once the grate frame is removed the pins can be knocked out.
- The grate can then be rolled around and lifted out through the top.  
(See photos on next page)





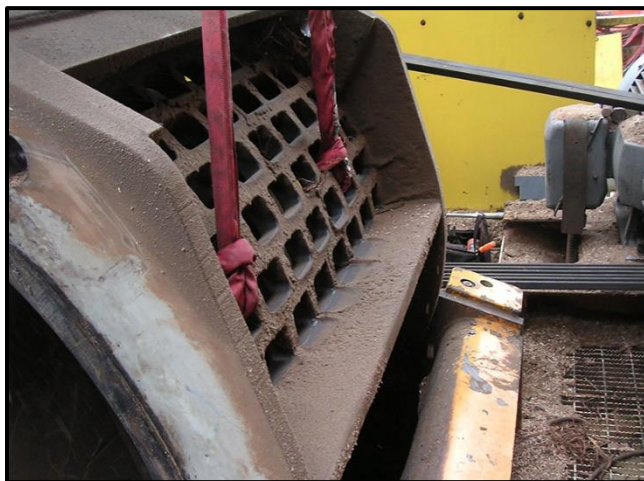


## GRIZZLY MILL HOG — GRATE (continued)

### REPLACEMENT



1 1/4" Diameter Rod



**Step #3**  
 Energize HPU, open upper box  
 and secure safety brace prior to  
 proceeding with grate removal.

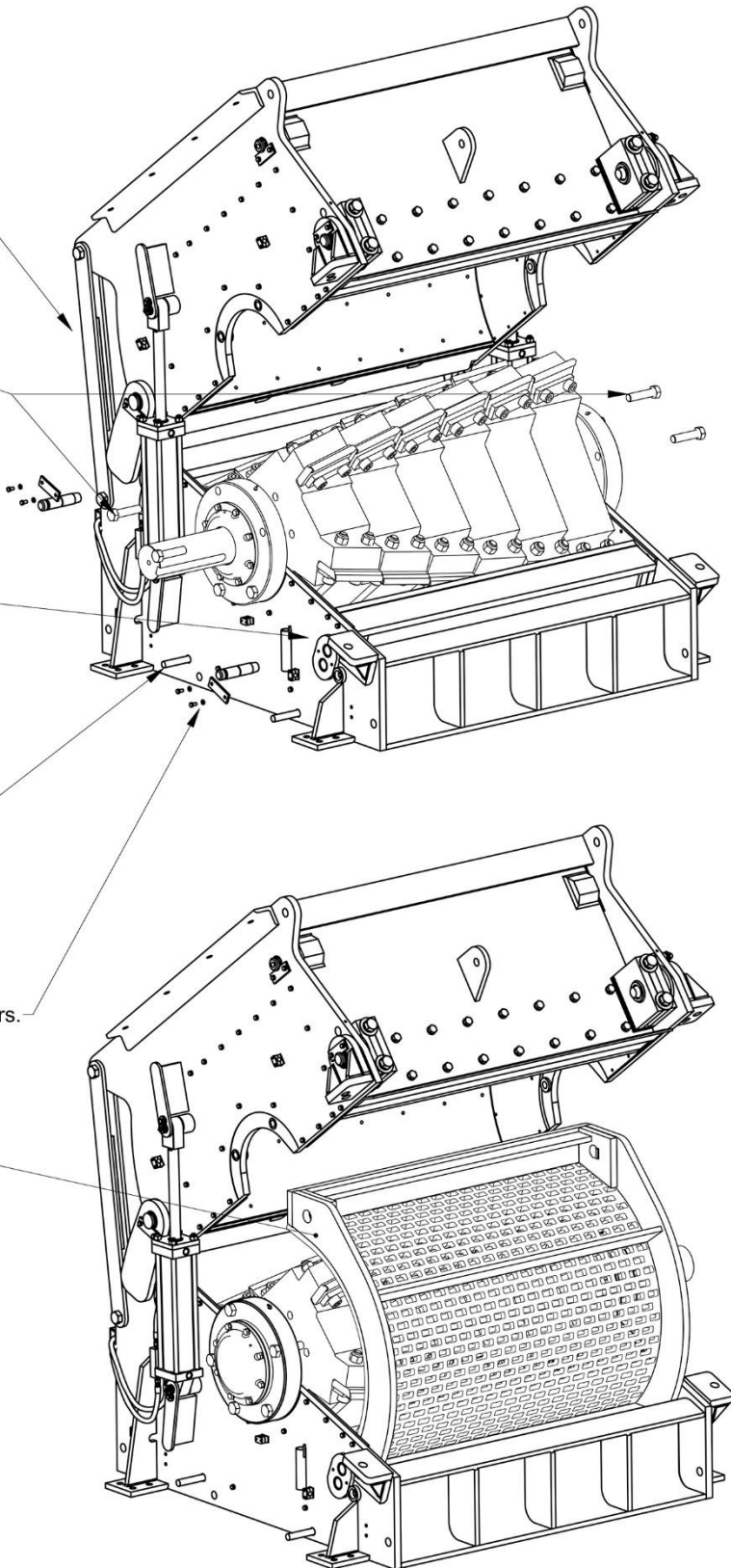
**Step #1**  
 Remove upper frame  
 rotor bearing fasteners  
 (2 ea side)

**Step #2**  
 Remove upper frame  
 to lower frame  
 lock bolts (1 per side)

**Step #4**  
 Insert [ 2 ] Bars 1 1/4" Dia  
 x Width of Grizzly + 12" Lg  
 [ by Customer ] and slide  
 thru the Lower Frame Side  
 Plates PRIOR to removing  
 grate shear and pivot pins

**Step #5**  
 Remove Grate Shear and Pivot Pins.  
 The Grate will be supported by the bars.

**Step #6**  
 Roll Grate around the Rotor  
 to the top and remove.



**NOTE :**  
 1 - Pictorial representation only, items are not exactly  
 as shown and may vary per customer specifications.  
 2 - Ensure safety brace is secured in place PRIOR to  
 beginning grate removal.  
 3 - For other item part numbers and descriptions see the  
 general assembly parts drawing.

This dwg derived from filename: 10110583 Top Open.sldasm



**GRIZZLY MILL Model 4800**  
 GRATE REMOVAL PROCEDURE DRAWING



drawn by: Tegart  
 date: 18-09-26  
 dwg no: 10110583  
 Rev: -





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