



RR2557 Grizzly Bar and Pan Kit

Assembly Guide

For RR2503 and RR2506 EcoPro series conveyors

This guide covers mounting the bracket arms, fitting the adjustable grizzly bars, and suspending the debris pan. Complete the steps in order and keep this guide with the conveyor instructions.

Safety and preparation

WARNING Stop the processor and conveyor, shut off the engine, and disable starting as directed in the machine instructions. Wait for all movement to stop before installation, adjustment, or clearing debris.

WARNING Work on firm, level ground. Secure the machine against movement and mechanically support the conveyor before working at its discharge end. Never rely on a hydraulic cylinder or winch alone to support a raised conveyor. Keep people out from beneath it.

Wear eye protection when punching, drilling, and removing burrs. Keep hands, loose clothing, and hair away from rotating drill bits. Check behind each drilling location and protect the belt, roller, hoses, and other components from the drill and metal chips.

Step 1 Unpack and check the kit

Lay out the grizzly-bar assembly, bracket arms, left and right bracket plates, debris pan, suspension chains, and supplied mounting hardware. Check for missing or damaged parts before starting.



Kit components before installation

Have a tape measure, marker, center punch, hammer, drill, 1/8-inch and 7/16-inch drill bits, deburring tool, and correctly sized wrenches or sockets ready. If parts or mounting locations differ from this guide, contact your nearest dealer.

Step 2 Mark the bracket mounting holes

At the conveyor discharge end, mark the lower and upper hole centers on the trough side, using the end and bottom edges shown in the photographs as the measuring references. Repeat for the bracket on the opposite side.

Hole center	From the end of the conveyor	Up from the bottom of the trough
Lower hole	5 1/2 inches	1 inch
Upper hole	5 1/2 inches	2 15/16 inches



Lower mounting hole Upper mounting hole

Hold each bracket arm against its marked mounting location and confirm that its holes align with both marks. Check both sides before drilling. Do not change the measurements to force a mismatched part to fit; contact your nearest dealer if the pattern does not match.

Step 3 Center punch the marks

With the conveyor securely supported, use a center punch and hammer to make a small indentation at each verified hole center. These marks help keep the drill bit from wandering.



Center punch the verified mounting-hole locations

Step 4 Drill the pilot holes

WARNING Check the space behind every hole before drilling. Keep the drill clear of the belt, roller, and other components, and control the bit as it breaks through the metal.

Drill a 1/8-inch pilot hole at each punched mark. Keep the drill square to the trough side and do not allow the bit to contact components behind it.



Drill each pilot hole with a 1/8-inch bit

Step 5 Enlarge and finish the mounting holes

Enlarge each pilot hole with a 7/16-inch drill bit. Deburr both sides of the holes where accessible, then remove all metal chips from the trough, belt, roller, and surrounding area before assembly continues.

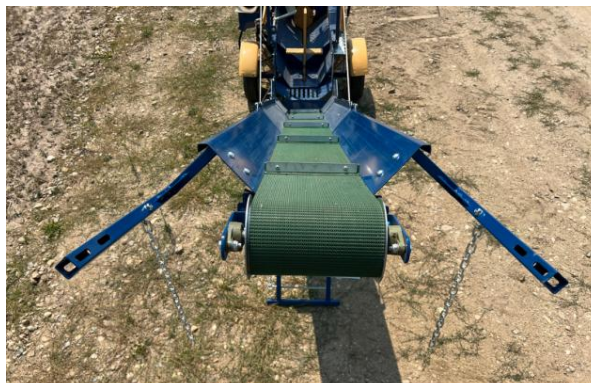


Enlarge the mounting holes with a 7/16-inch bit

Check that the mounting hardware passes through the finished holes without forcing it. Keep all supplied hardware together for the next steps.

Step 6 Fit the bracket arms

Mount the bracket arms at the discharge end using the supplied hardware. Match the side and end views below. Start all fasteners by hand and leave the bolts loose enough for alignment; do not fully tighten them yet.



A Bracket arm side view **B** Both bracket arms fitted

Step 7 Fit the left and right bracket plates

Attach the bracket plates to the arms with the supplied hardware. The plates are different for the left and right sides; match their orientation to the installed view below. Leave the bolts loose enough to position the grizzly-bar assembly.



Left and right bracket plates mounted on the arms

NOTE The plates can be repositioned along the arms to accommodate conveyor belt tension adjustment. They do not replace the conveyor's belt-tensioning mechanism. After any belt adjustment, recheck the grizzly position and clearance.

Step 8 Install the grizzly bars

WARNING Support the grizzly-bar assembly while installing its fasteners. Keep fingers out of the bracket joints and use assistance if needed to hold the assembly safely.

Position the grizzly-bar assembly between the bracket plates and install the supplied hardware. Adjust its angle to suit the wood being conveyed and the amount of debris to be separated.



A Grizzly bars attached to the plates B Grizzly angle and discharge position

Check that the grizzly bars are aligned with the discharge path and remain clear of the conveyor belt and roller. Make all angle and position adjustments with the machine shut down and starting disabled.

Step 9 Tighten the mounting hardware

Once the assembly is aligned, tighten all bolts securing the bracket arms, bracket plates, and grizzly bars. Check both sides and confirm that the selected position is held securely.

NOTE Use the specified tightening torques where provided with the equipment or hardware. If a torque specification is needed, contact your nearest dealer.

Check before installing the pan

- Both bracket arms are seated securely against their mounting surfaces.
- Left and right plates are correctly oriented and secured.
- The grizzly-bar assembly is supported at both sides and does not contact the belt or roller.
- Loose hardware, drilling chips, and tools have been removed.

Step 10 Install the debris pan

Support the pan beneath the grizzly bars and attach the suspension chains using the supplied hardware. Match the mounting arrangement below. Adjust the chain lengths and select the pan mounting holes to set the desired debris-collection angle.



A Pan suspended below the grizzly bars **B** Pan angle and chain connections

Snug the bolt at both ends of every chain. Check that all chains are attached securely and that the pan hangs clear of the conveyor belt, roller, and other moving components.

Final inspection and first use

- Confirm that every bracket, grizzly-bar, and chain connection is secure.
- Check that the pan and chains cannot enter the belt or roller during use.
- Remove tools and loose parts. Keep people clear of the discharge and debris-drop areas.
- Follow the processor and conveyor operating instructions. From the normal controls, briefly run the conveyor without wood and observe the kit from a safe distance. Stop immediately if any part rubs, shifts, or interferes with movement.

Initial operation recheck

After the first short period of use, stop the conveyor and engine, disable starting, and wait for all movement to stop. Recheck fasteners, chain connections, grizzly position, and pan clearance. Repeat these checks after belt-tension or kit-angle adjustments.

WARNING Never reach into the grizzly bars, pan, belt, or roller while the conveyor is moving. Shut down and disable starting before removing lodged wood, clearing debris, or adjusting the kit.

For replacement parts, missing specifications, or installation assistance, contact your nearest dealer.