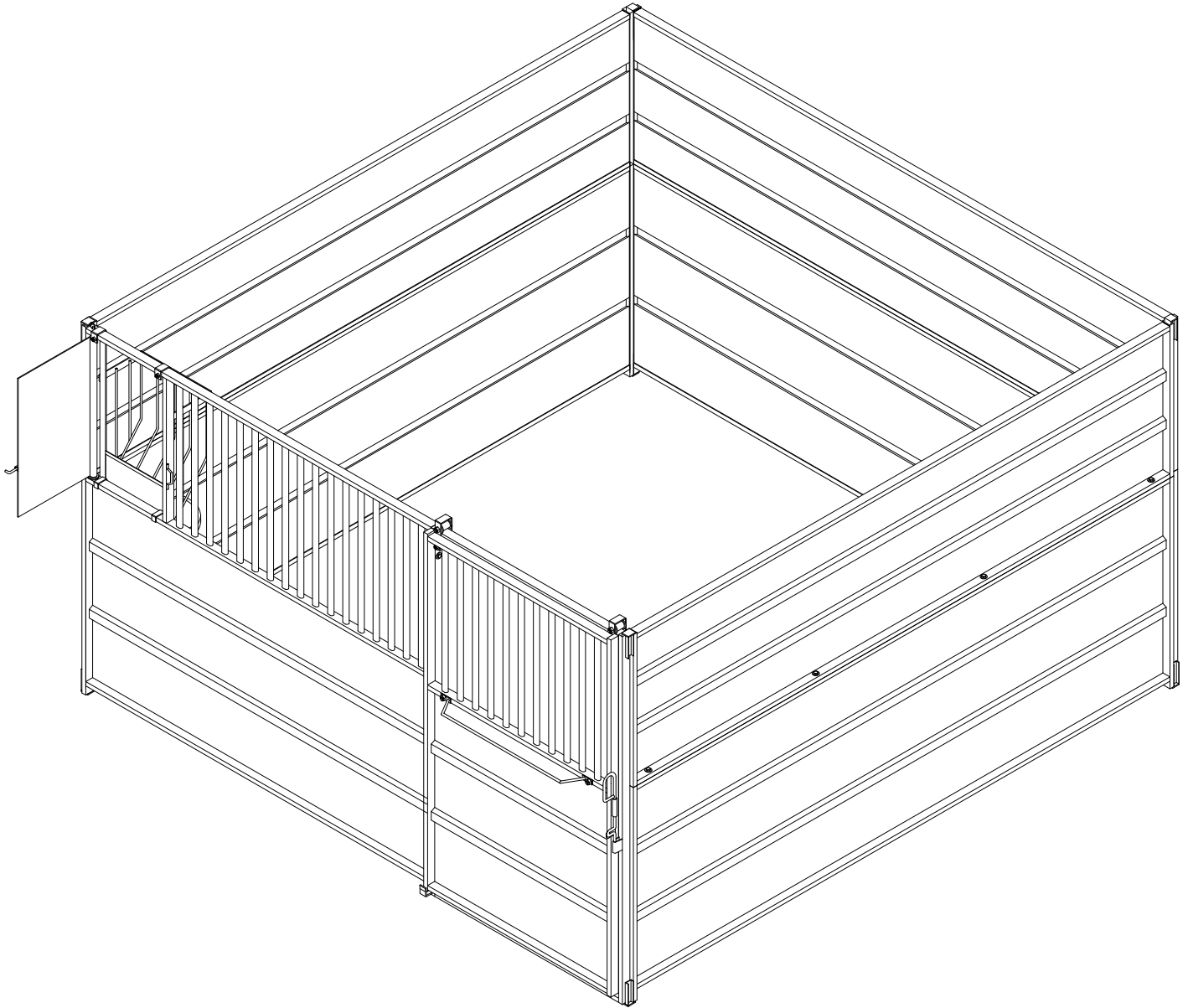


HORSE STALL

ASSEMBLY INSTRUCTIONS



POWDER RIVER

• LIVESTOCK HANDLING EQUIPMENT •

www.powderriver.com

1-800-453-5318

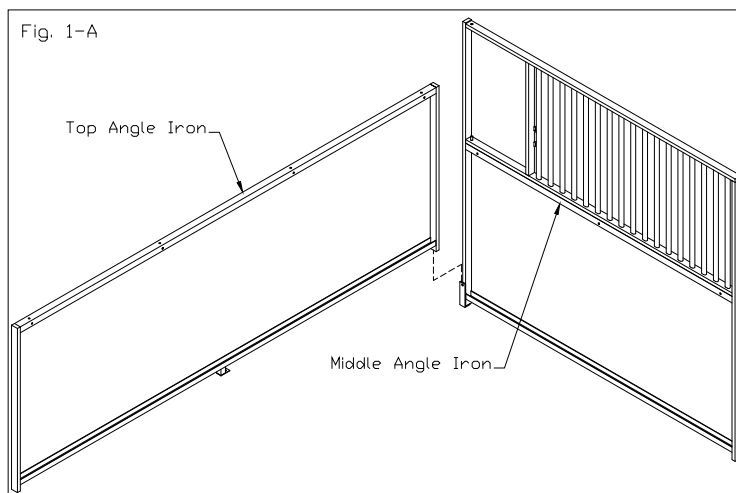
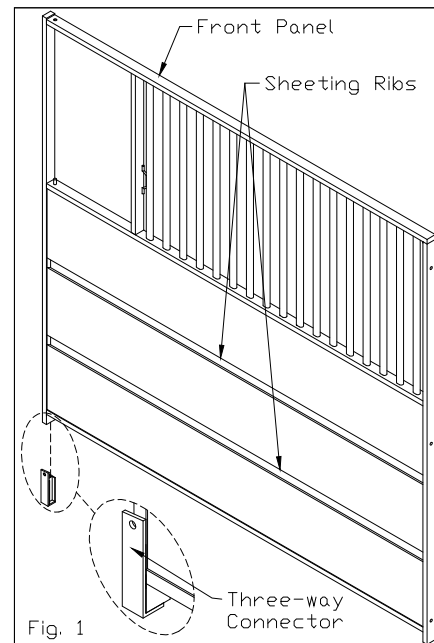
NOTE: If you have purchased open top and bottoms panels, continue steps 1 through 11, as if the drawings had open panels. Step 12 will instruct you on installing the wood paneling for the open panels.

STEP 1:

Remove all shipping straps and packaging from all of the panels. Locate and position the Front Panel so that the ribs in the sheeting, on the bottom of the panel, point outside of the stall area. (Shown in figures 1 and 2.)

NOTE: On an Open Bottom Front Panel, the vertical side of the angle iron, located in the middle of the panel, must be placed inside the stall area. (Shown in figure 1-A.)

Place a Three-way Connector into the bottom of the end tube as shown. (See figure 1.)

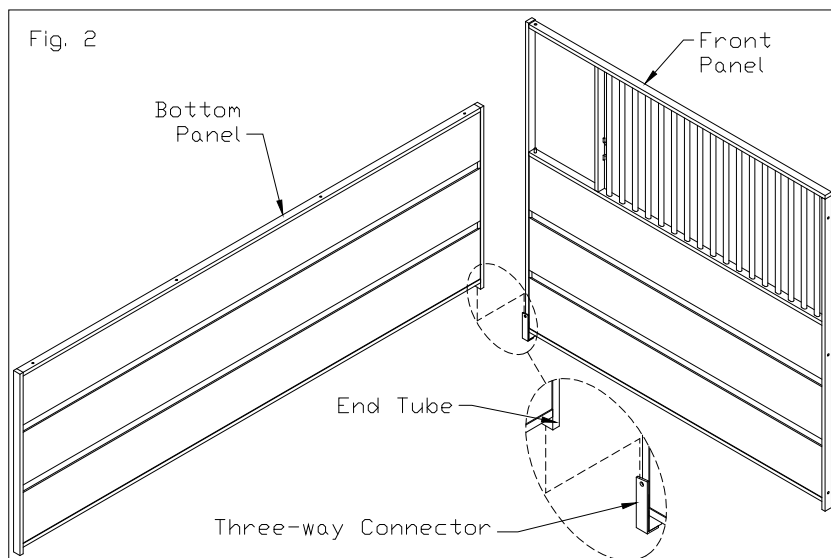


STEP 2:

Locate a Bottom Panel and position it so that the ribs in the sheeting point outside the stall. (Shown in figure 2.)

NOTE: On an Open Bottom Panel, the vertical side of top angle iron, must be placed inside the stall area. (Shown in figure 1-A.)

Place the end tube on to the Three-way Connector, which is attached to the Front Panel. (Shown in figure 2.)



STEP 3:

Locate a Top Panel, and position it to face the same way as the bottom panel.

Slide the Top and Bottom Panel Connectors (which are located on each end of the top panel) into the end tubes, which are located on the bottom panel. (See figure 3.)

NOTE: A solid Bar Top Panel and Open Top Panel is installed in the same manner as a sheet panel. The Open Top Panel must face the same direction as shown Open Bottom Panel. (See figure 1-A on page 2.)

Slide a Three-way Connector into the top of the Front and Top Panel as shown. Place a Three-way Connector into the far end of the bottom panel. (See figure 3.)

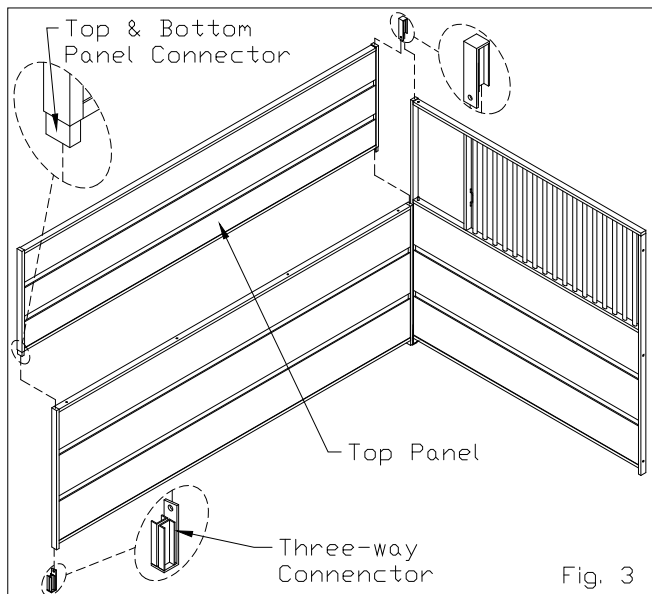


Fig. 3

STEP 4:

Locate the Door Frame. Slide the Top Connector on the Door Frame into the top rail of the Front Panel. (See figure 4.)

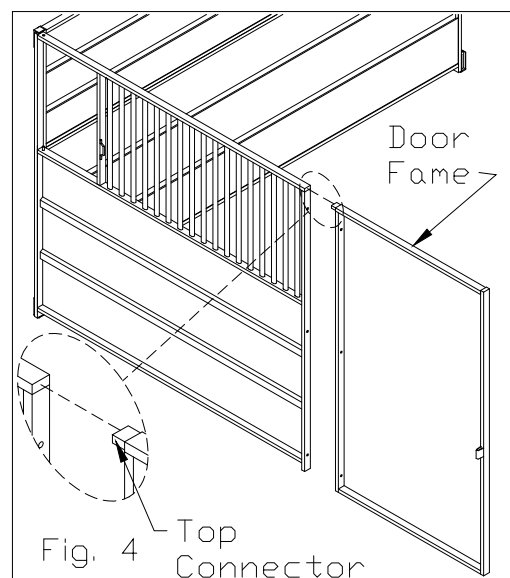


Fig. 4
Top Connector

STEP 5:

Locate the Door Guide and place it on to the middle support tubes at the bottom of both the Front Panel and Door Frame as shown. Secure them together with a (1) 3/8" x 3-1/4" hex bolt, (2) 3/8" washers, and (1) 3/8" lock nut as shown.

Finish securing the Front and Frame together using (2) 3/8" x 2-3/4" hex bolts, (4) 3/8" washers and (2) 3/8" lock nuts. (See figure 5.)

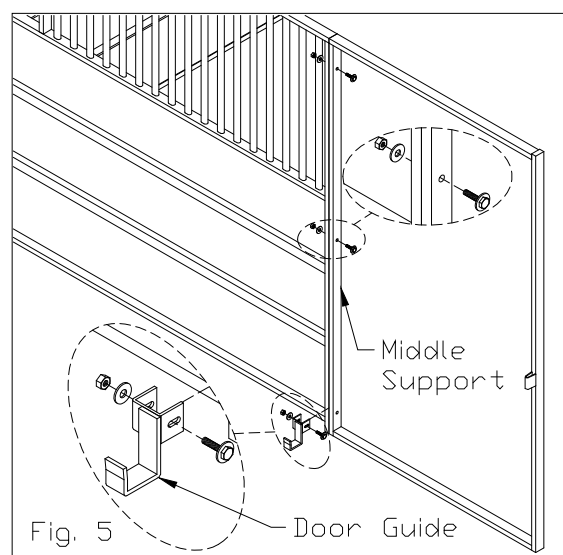


Fig. 5
Door Guide

STEP 6:

Place a bottom panel on to the Three-way Connectors.
(See figure 6.)

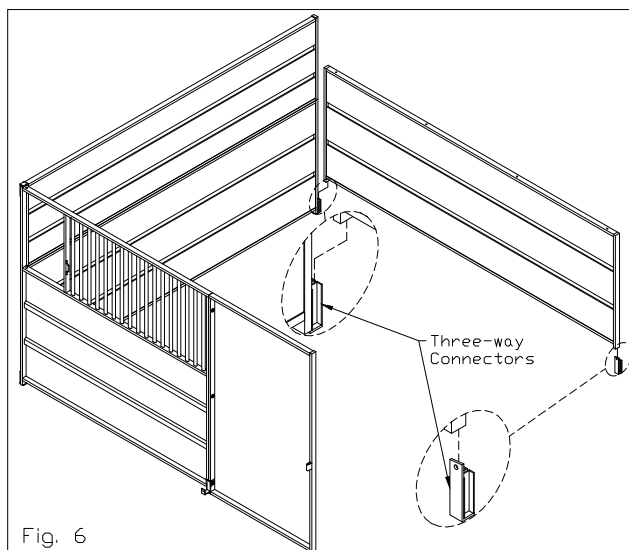


Fig. 6

STEP 7:

Place a top panel on to the bottom panel. (See figure 7.)

Repeat steps 6 and 7 to finish assembling all four sides of the stall. (Shown in figure 8.)

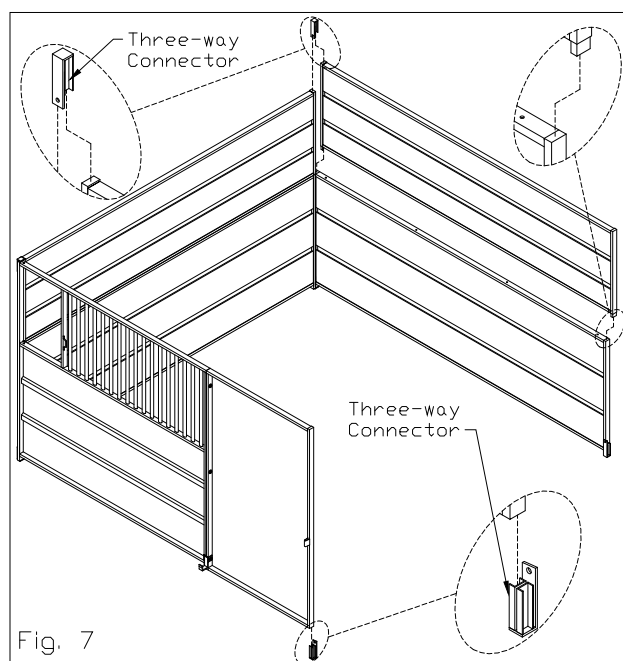


Fig. 7

STEP 8:

Secure all four sides together by placing two Three-way Connectors into the end tubes. (Shown in figure 8.)

Secure the top and bottom panels together by placing (4) 3/8" x 2-3/4" hex bolts, (8) 3/8" washers and (4) 3/8" lock nuts. (See figure 8.)

NOTE: When securing Open Top and Bottom Panels together, use (4) 3/8" x 1" elevator bolts, (4) 3/8" washers, and (4) 3/8" lock nuts. When securing an Open Bottom Panel to a Bar Top or Sheeted Panel, use (4) 3/8" x 2" elevator bolts, (4) 3/8" washer and (4) 3/8" lock nuts. The flat head on the elevator bolt must be place up through the holes on the bottom panel so that the washers and lock nuts are secured on the top panel.

Continue this on the remaining two sides until all sides are bolted together.

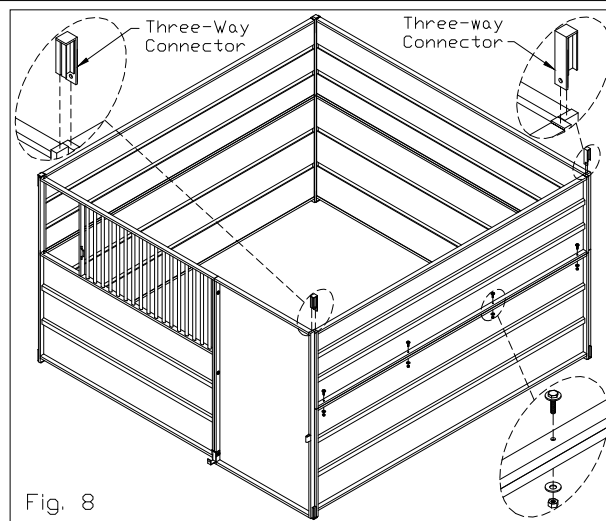
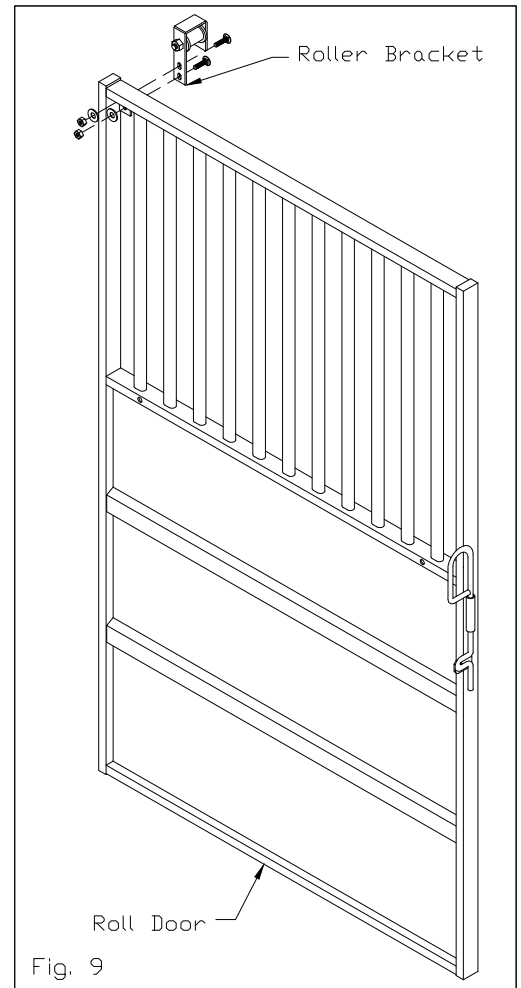


Fig. 8

STEP 9:

Locate the Roll Door and remove the Roller Brackets that have been bolted on to the top of the Roll Door upside down for shipping purposes.

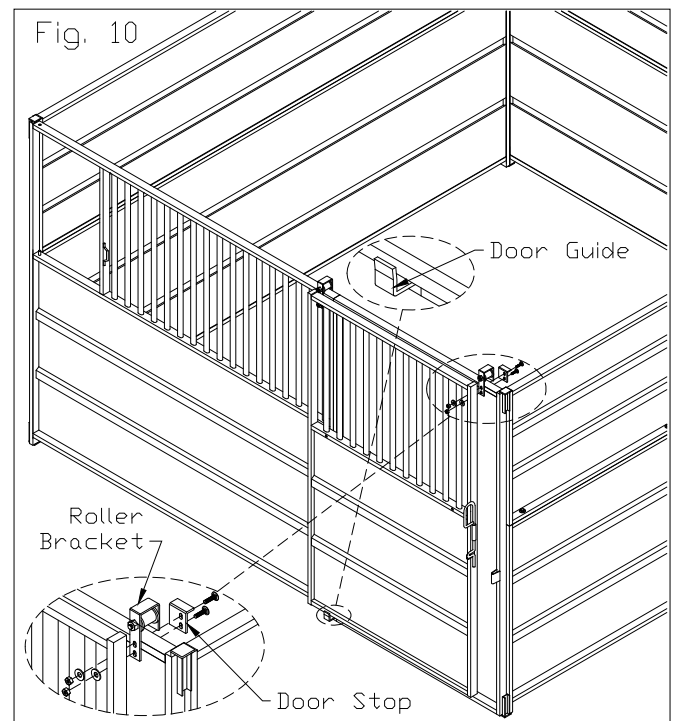
Use the same bolts, washers and nuts used during shipping, to bolt one of the Roller Brackets on to the Roll Door. (See figure 9.)



STEP 10:

Before mounting the second Roller Bracket on to the Roll Door, hang the Roll Door on the Front Panel's top rail as shown in figure 10. Be sure that the bottom of the door will roll between the Door Guide and the Front Panel as shown.

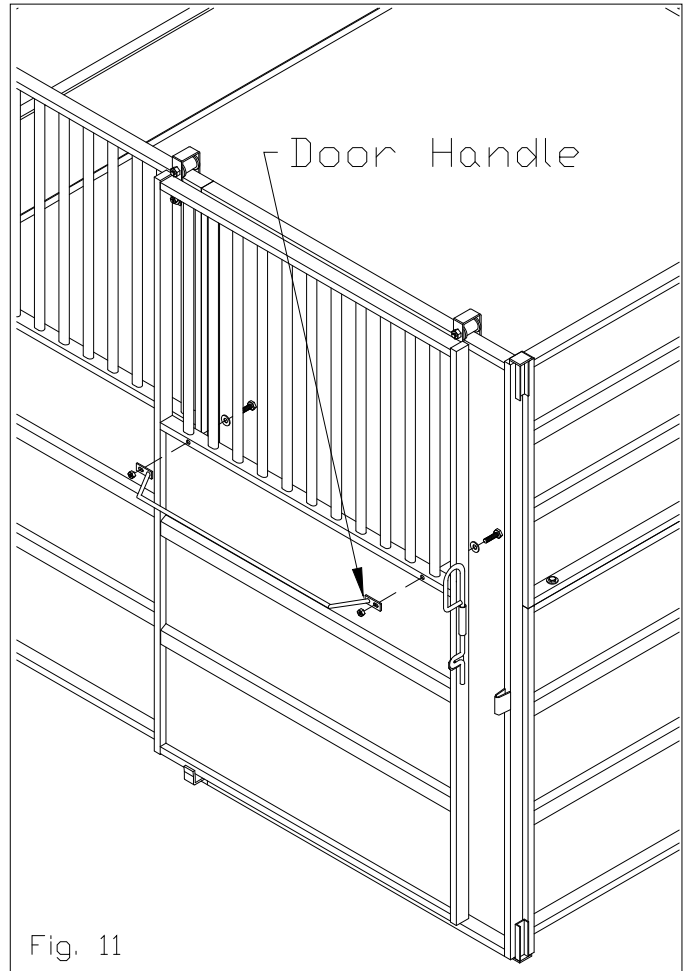
Place the second Roller Bracket on the top rail of the Door Frame. Use the same bolts, washers and nuts used during shipping, to bolt the Door Stop and Roller Bracket to the Roll Door. (Shown in figure 10.)



STEP 11:

Bolt the Door Handle to the door using (2) 3/8" x 2-3/4" hex bolts, 3/8" washers and 3/8" lock nuts. (See figure 11.)

NOTE: It may be necessary to adjust the door so that it is level. To do this, loosen the two bolts on Roller Bracket and adjust each side of the Roll Door one at a time until it is level.



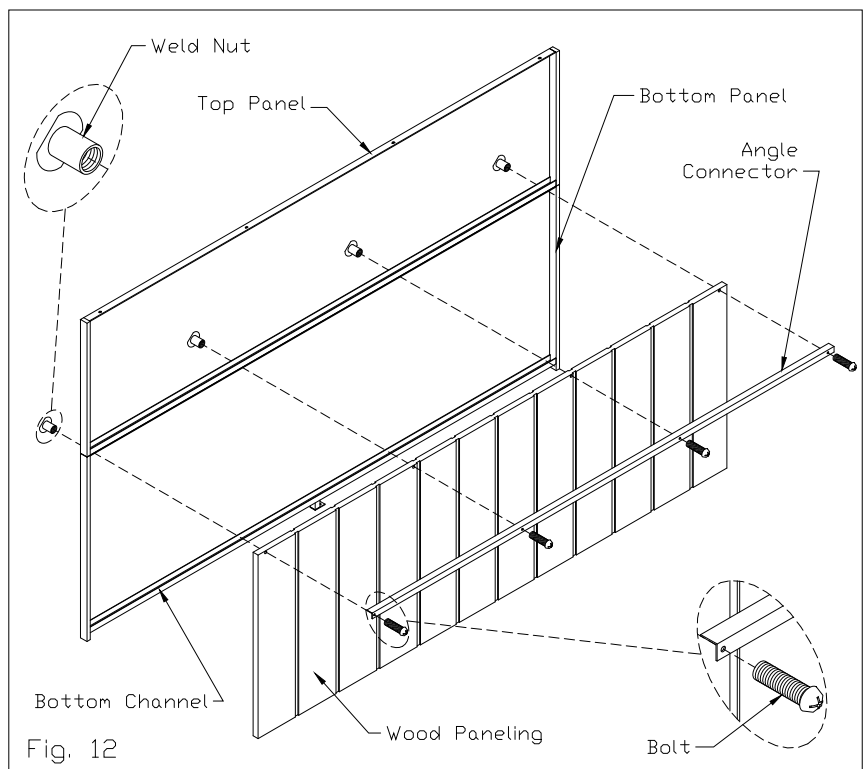
STEP 12:

When installing wood paneling (*plywood or tongue and groove, which are not included*) on the sides, front, back, and door of a stall, place the the wood paneling into the the channel at the bottom. Place the Angle Connector around the top edge of of the Wood Panel, so that it forms a "U" shaped channel with the Angle Iron that's welded to the frame. Then secure them together with 5/16" x 1-3/4" Bolts and 5/16" Weld Nuts. (Shown in figure 12.)

NOTE: The number of bolts and weld nuts depends on the length of the panel.

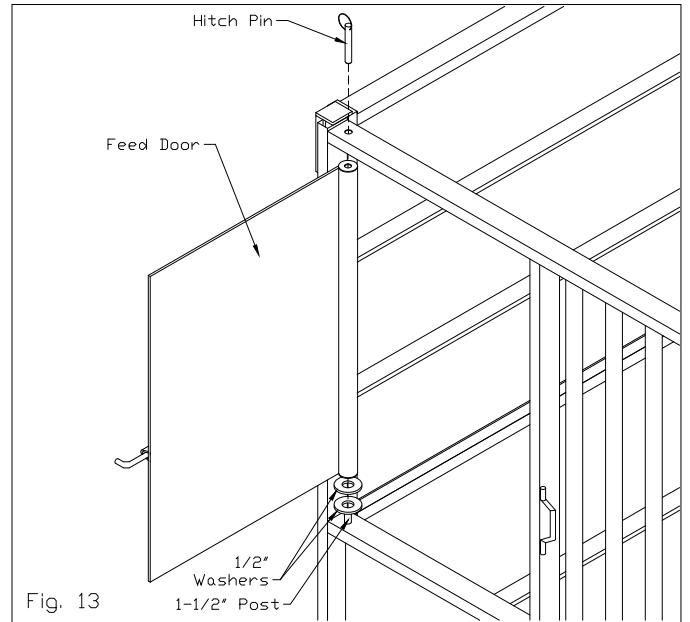
Install the paneling for the top panel in the same manner as the bottom panel.

NOTE: The bolts that secure the top and bottom panel together may be in the way of the wood paneling, so it may be necessary to notch the out the bottom of the paneling at each bolt to allow the paneling the fit properly.



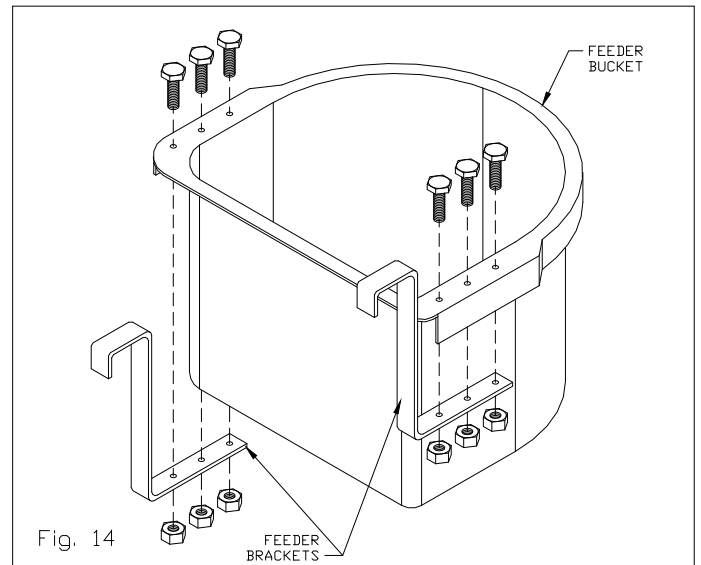
STEP 13:

Place (2) 1/2" washers over the 1-1/2" post. Then slide the feed door over the washers and on to the 1-1/2" post. Secure the door in place with a 1/2" hitch pin.
 (See figure 13.)



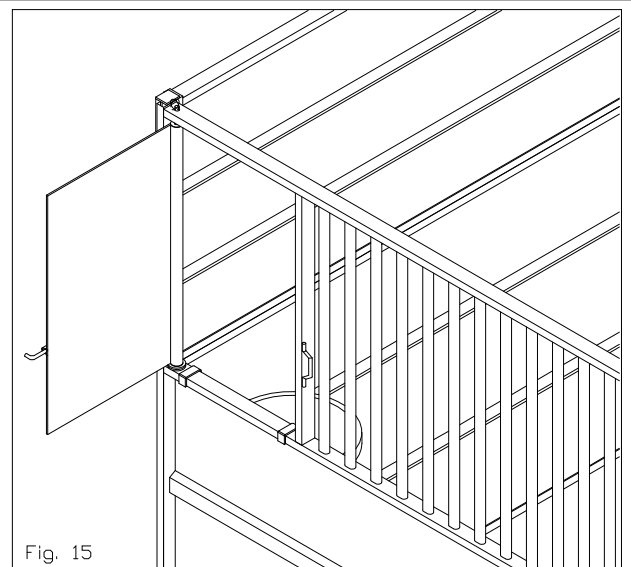
STEP 14:

Align the holes of the Feeder Brackets with the holes of the Feeder Bucket and fasten them together with the (6) 1" x 1/4" Hex Bolts and 1/4" Lock Nuts.
 (See figure 14.)



STEP 15:

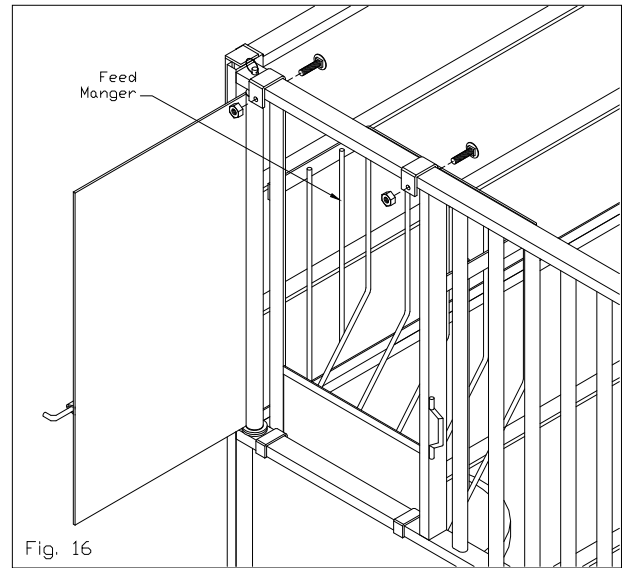
The Feeder Bucket hangs from the doorway of the Feed Door.
 (See figure 15.)



STEP 16:

The Feed Manger is mounted by sliding the bottom sheeting into the brackets on the feed bucket and hang it in the doorway of the Feed Door as shown. Secure it in place with (2) 3/8" x 3" Carriage Bolts, 3/8" washer and Lock nuts.

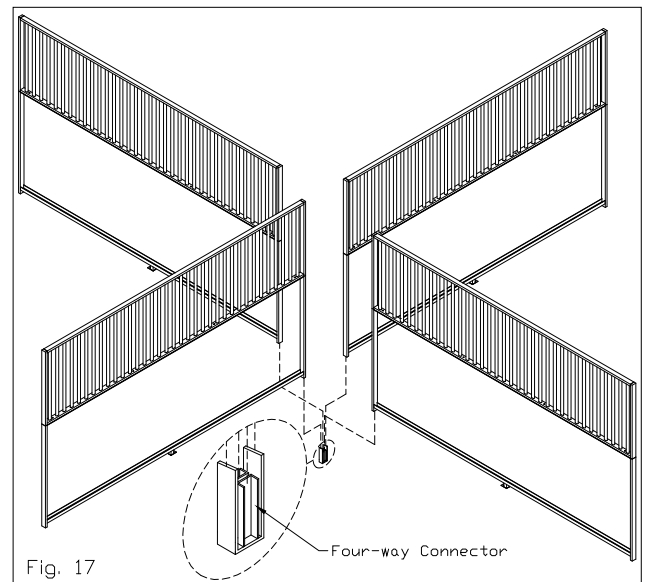
(Shown in figure 16.)



STEP 17:

When connecting four sides of a stall together. An optional Four-way Connector would replace a Three-way Connector in step 1 through 8, depending on the configuration of joining stalls.

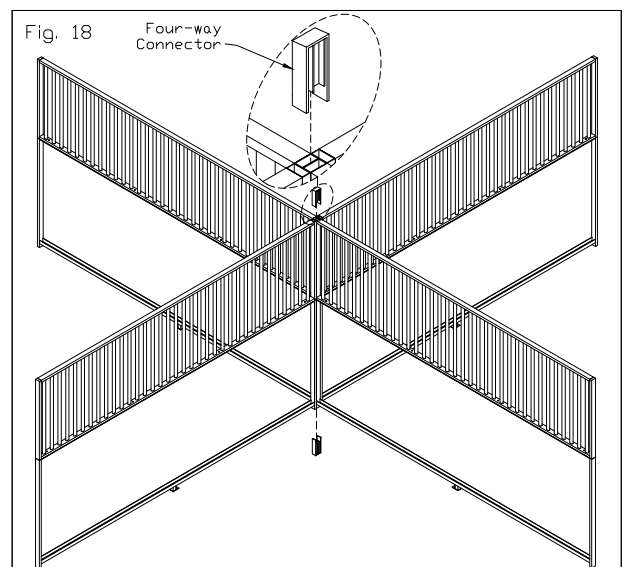
The Four-way connector is connected to the bottom of the stalls. *(See figure 17.)*



STEP 18:

To secure the four sides together, place a Four-way Connector into the top of the end tubes.

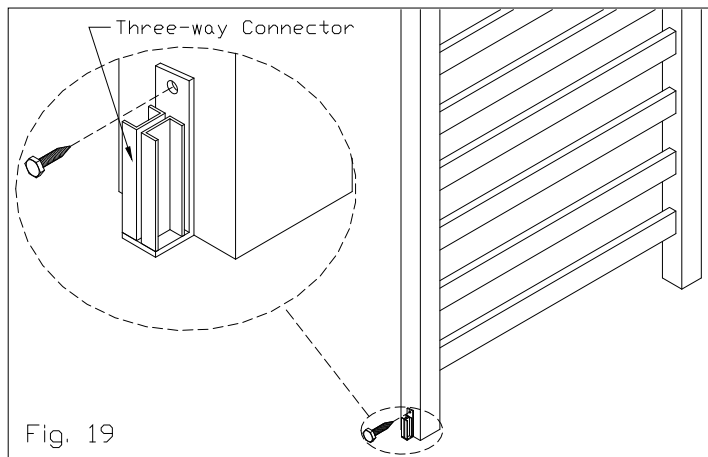
(Shown in figure 18.)



STEP 19:

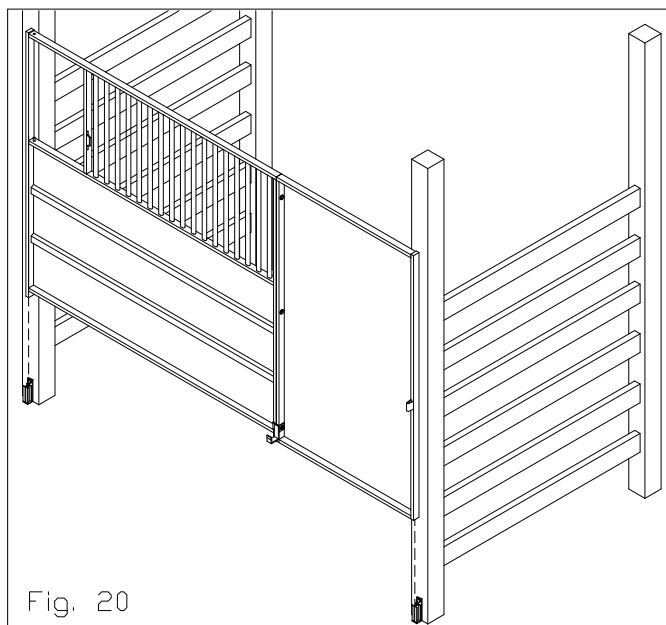
To mount the stall frame to an existing post, bolt the Three-way Connector to the bottom of the post. (*bolts are not included*)
(See figure 19.)

NOTE: Be sure to carefully measure the panel and post spacing before installing connectors.



STEP 20:

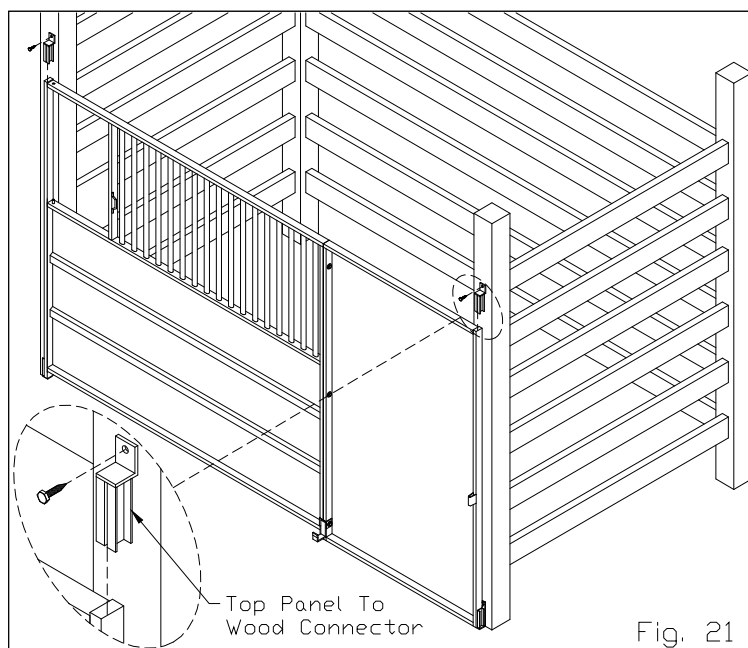
Refer to steps 4 and 5 for the assembly of the stall front and then lower the stall front into position.
(Shown in figure 20.)



STEP 21:

Insert the *optional* Panel To Wood Connectors into the end tubes as shown, and secure them to the wood post. (See figure 21.)

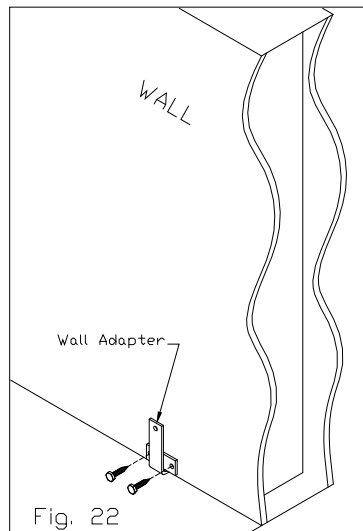
Refer to steps 9 through 16 to finish the stall assembly.



STEP 22:

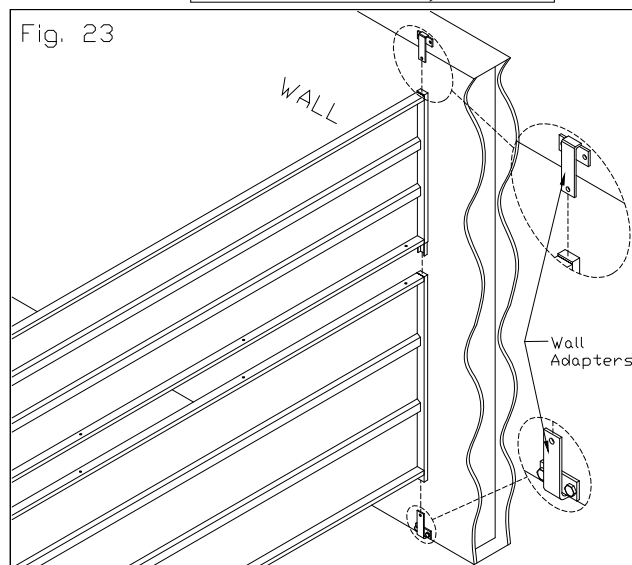
To mount the stall to an existing wall, place an *optional* Wall Adapter where you would like the first panel of the stall to start, and secure it to the wall. (*Bolts are not included.*)
(See figure 22.)

NOTE: When positioning the first adapter keep in mind the lengths of the remaining stall panels, (10 or 12 feet in length), so that the stall will fit together properly.



STEP 23:

Using figure 23 as a reference, connect the Top and Bottom panels to the Wall Adapters as shown.



STEP 24:

Secure the Top Adapter to the wall. (*Shown in figure 24.*)

