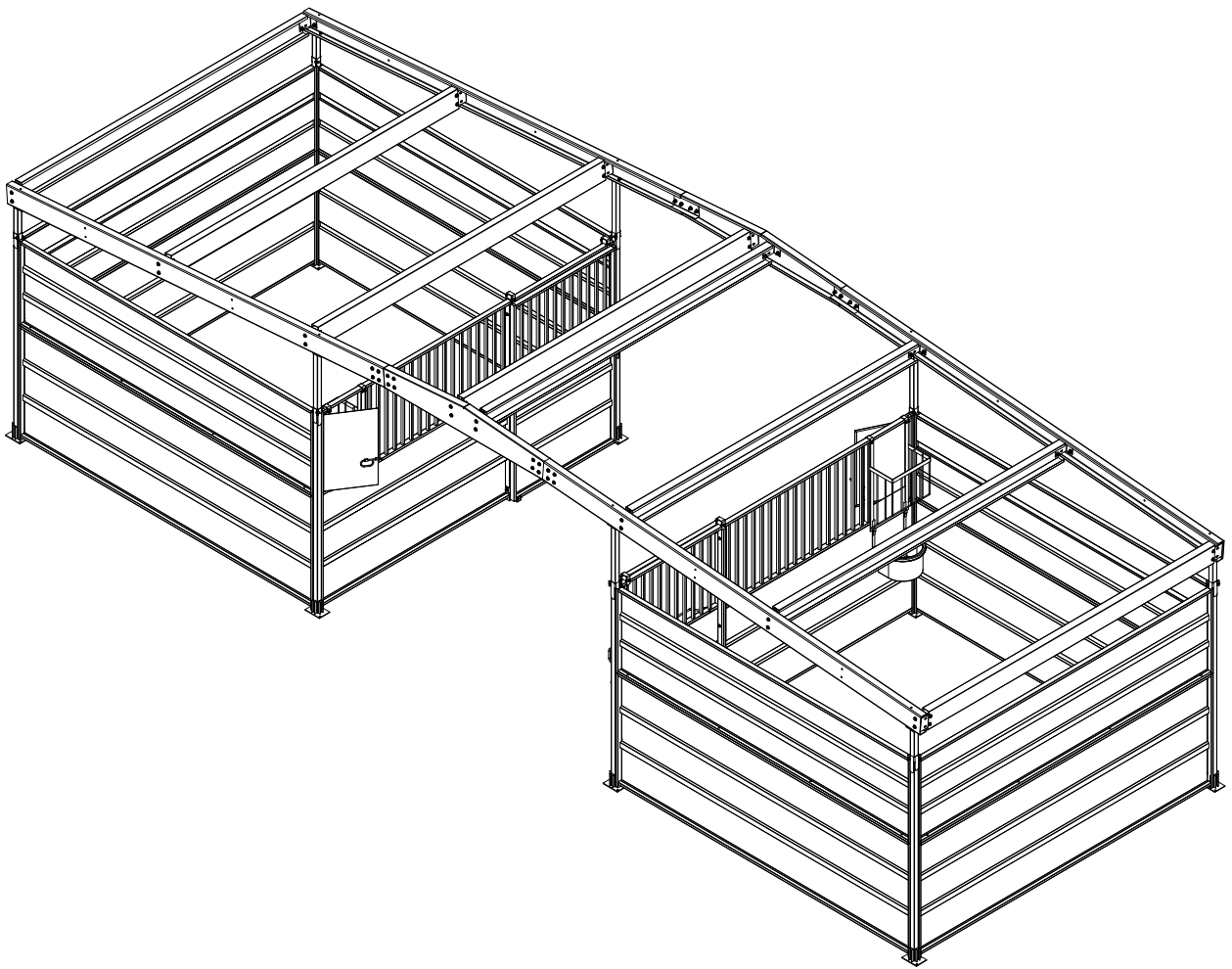


# *Integrated Equine Systems*

ASSEMBLY INSTRUCTIONS



## **Step 1:**

Begin assembly by removing all shipping straps and packaging from Integrated Equine System. Separate and group materials. Locate and position the posts 12' apart from each other forming a rectangle (three 12' squares in a row) with the four shorter 8' posts being placed on the ends (the backs of the stalls) and the four longer 9' posts placed in the center (as shown in figure 1). Place post with top tabs sloping upwards towards the middle of the Integrated Equine System.

*Note: When assembling one stall Integrated Equine Systems, locate and position the posts 12' apart from each other forming a square with the two shorter 8' posts placed on the end or back of the stall and the two 9' posts placed towards the front of the stall. The tabs should slope upwards to the inside of the Integrated Equine System.*

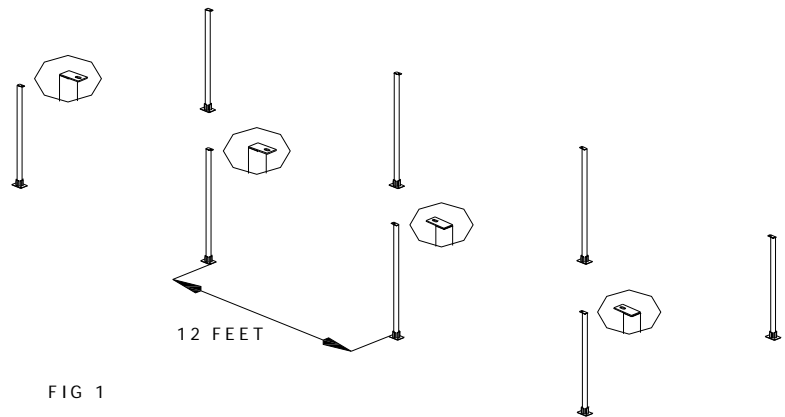


FIG 1

## **Step 2:**

For installation of Stall Panels follow the sequence in figure 2.

*Note: When assembling one stall Integrated Equine Systems; follow the instructions for stall panel installation omitting the steps to assemble the second stall.*

*Note: To install open top and bottoms stall panels, continue steps 2 through 12, as if the drawings had open panels. Step 13 will instruct on installing the wood paneling for the open panels. If you have purchased nonsheeted 2" paneling begin with step 18.*

Locate and position a bottom panel so that the ribs in the sheeting point outside the stall (see figure 2-B).

*Note: On an open bottom panel the vertical side of the top angle iron must be placed inside the stall area (see figure 2-C)*

Place the end tube of the bottom panel into the tabs of the bottom post plates (see figure 2-B and 2-C).

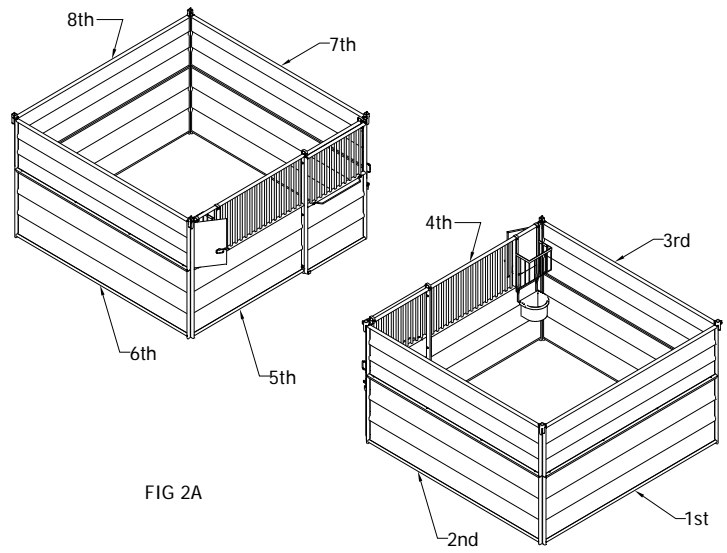


FIG 2A

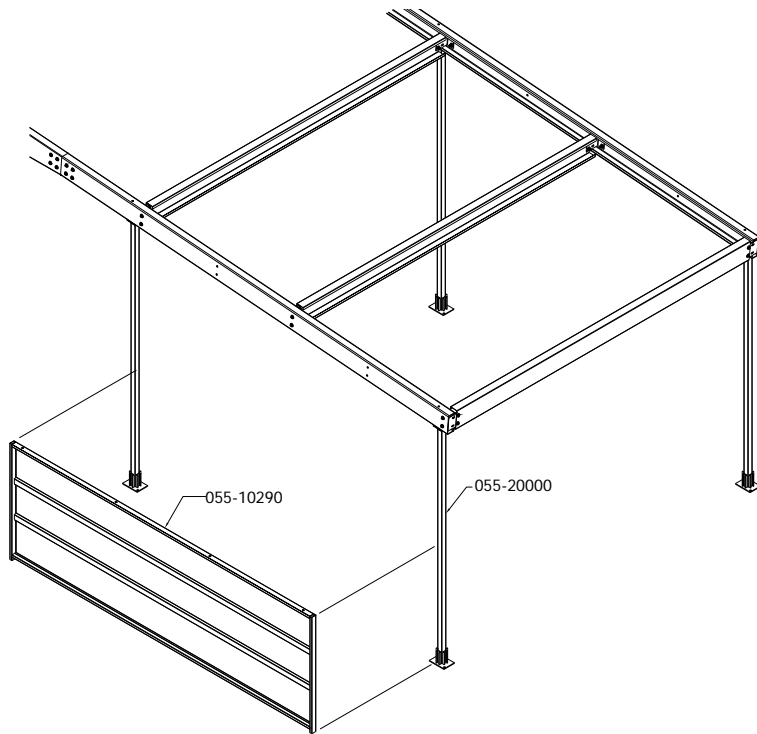


Figure 2B

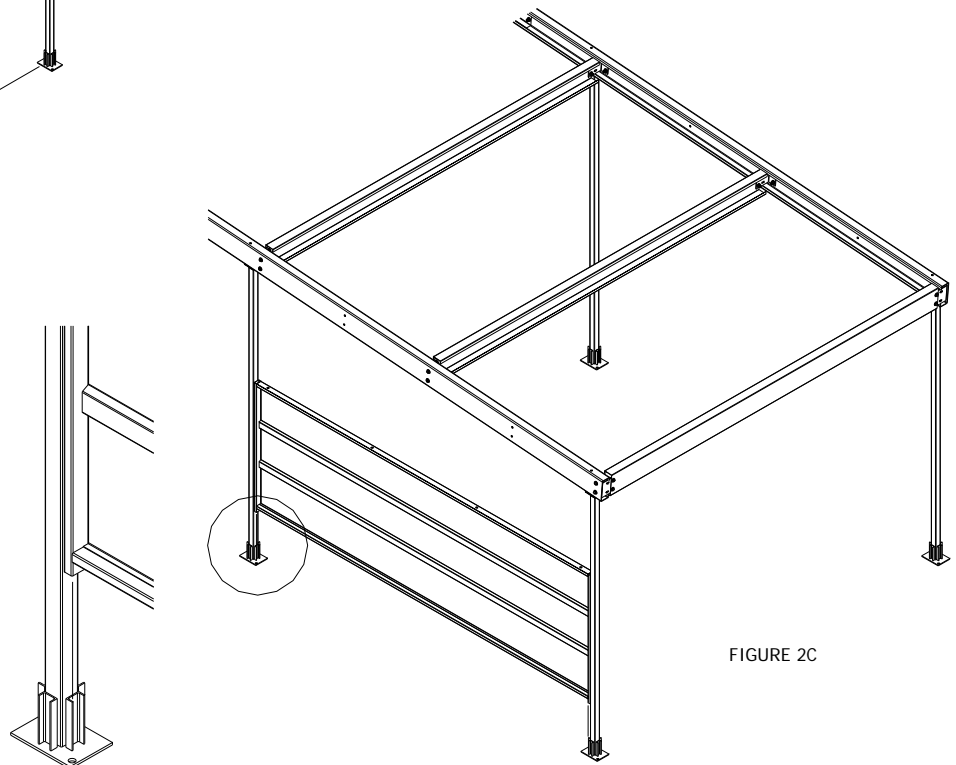
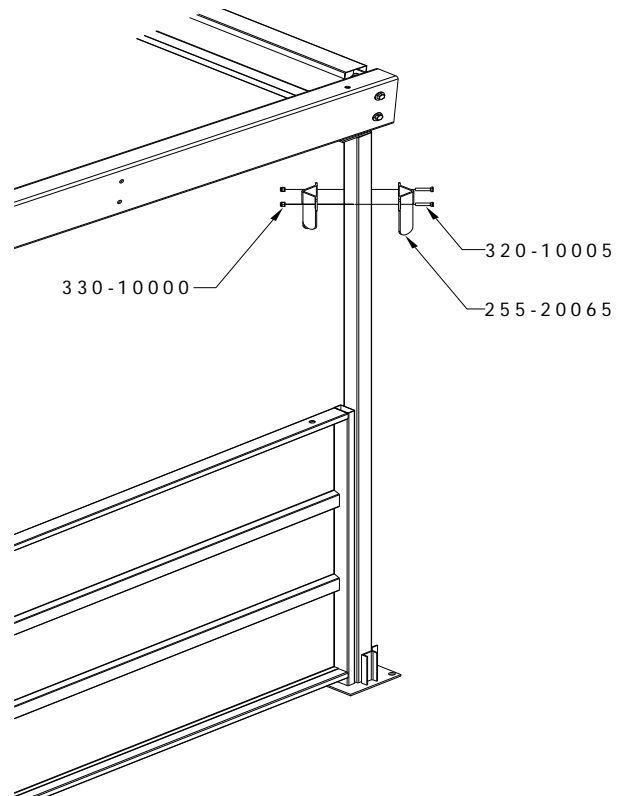


FIGURE 2C

**Step3**

Attach a four-way connector to the post and bolt loosely to allow sliding up and down the post (see figure 3).



**Figure 3**

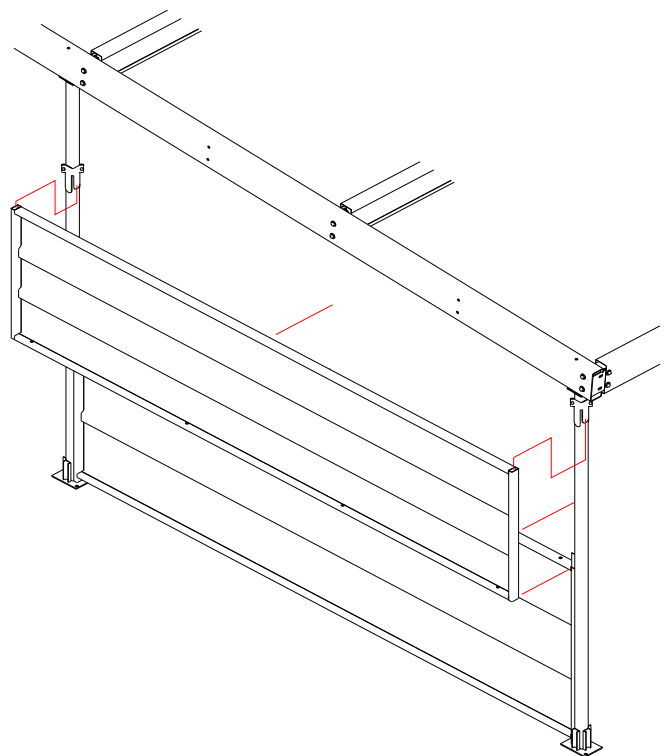
**Step 4**

Locate and position a top panel to face the same way as the installed bottom panel.

Slide the four-way connectors up on the post. While placing the top panel onto the bottom panel, slide the four-way connector down placing the tabs into the tubes of the top panel (see figure 4).

*Note: A solid bar top panel and open top panel is installed in the same manner as a sheeted panel. The open top panel must face the same direction as the shown open bottom panel in figure 4).*

**Figure 4**



### **Step 5**

Install panels 2, 3, 6, 7 and 8 by repeating steps 2 through 4 (see figure 5).

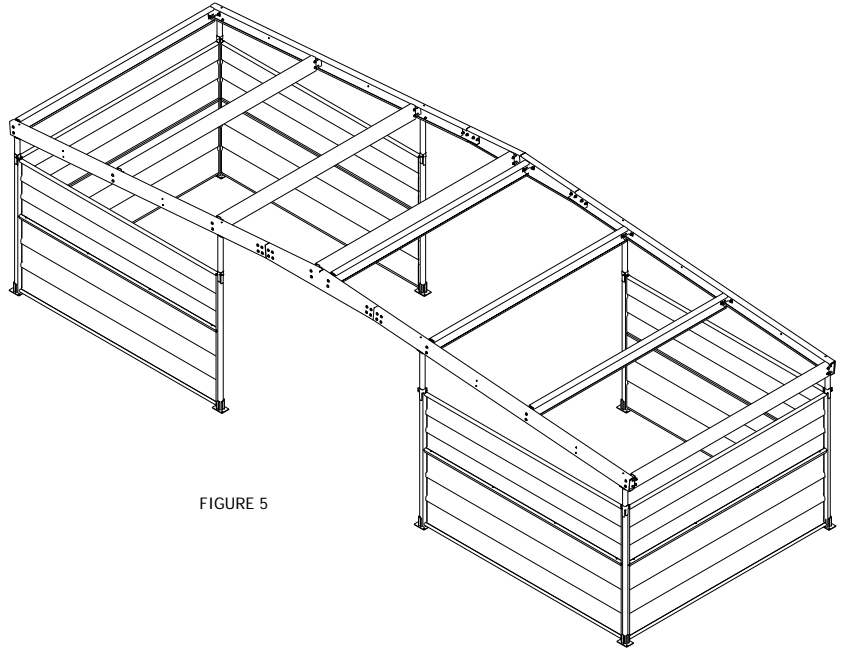


FIGURE 5

### **Step 6**

Locate and position the front panel with the ribs in the sheeting on the panel pointing outside the stall area towards the breezeway of the Integrated Equine System (see figure 6).

*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.*

Slide the four-way connectors up on the posts while placing the end tubes of the bottom of the front panel into the tabs of the bottom post plate. Slide the four-way connectors down placing the tabs into the top tubes of the front panel (see fig. 6).

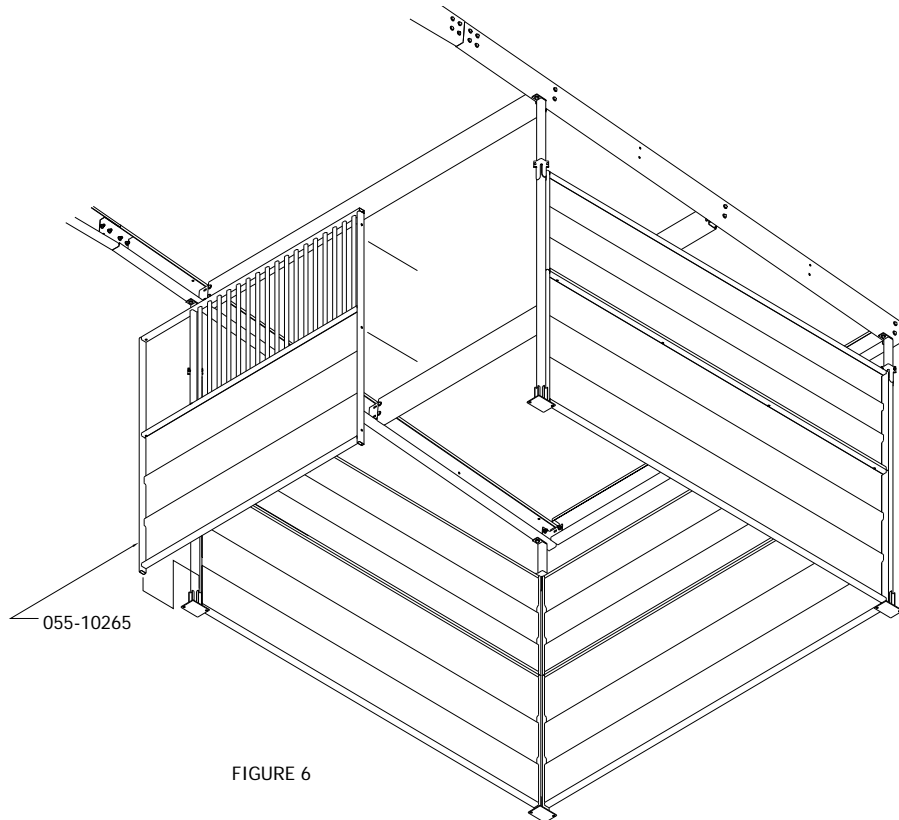


FIGURE 6

### **Step 7**

Locate the door frame. Slide the top connector of the door frame into the top rail of the front panel (see figure 7).

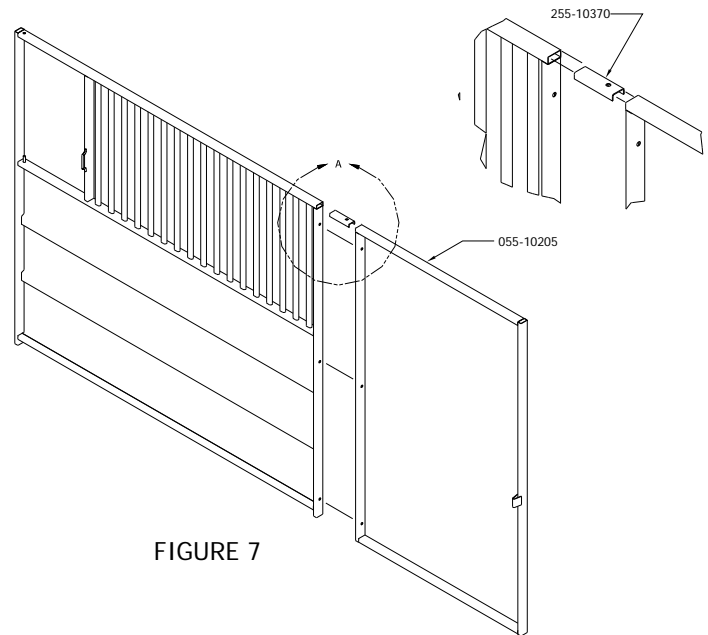


FIGURE 7

### **Step 8**

Locate and place the door guide on to the middle support tubes at the bottom of both the front panel and door frame as shown in figure 8. 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 in figure 8.

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 (figure 8).

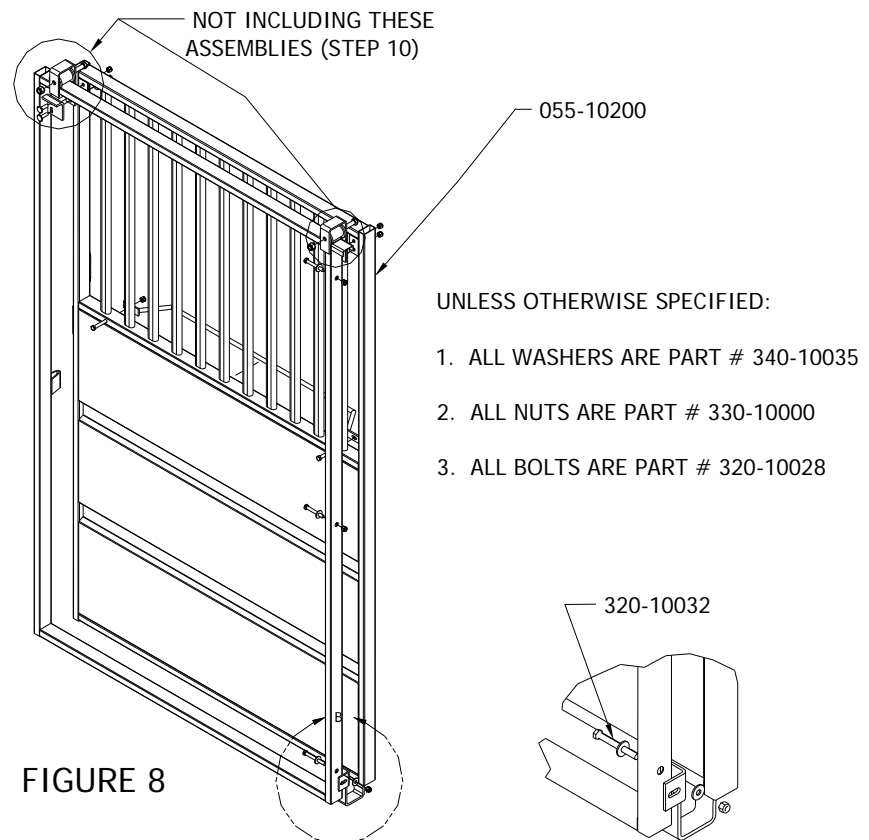


FIGURE 8

### **Step 9**

Secure the top and bottom panels, of end and side panels, together by placing (4) 3/8" x 2-3/4" hex bolts, (8) 3/8" washers and (4) 3/8" (see figure 9).

*Note: When securing open top panels to bottom panels, use (4) 3/8" x 1" elevator bolts, (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 placed up through the holes on the bottom panel so that the washers and lock nuts are secured on the top panel.*

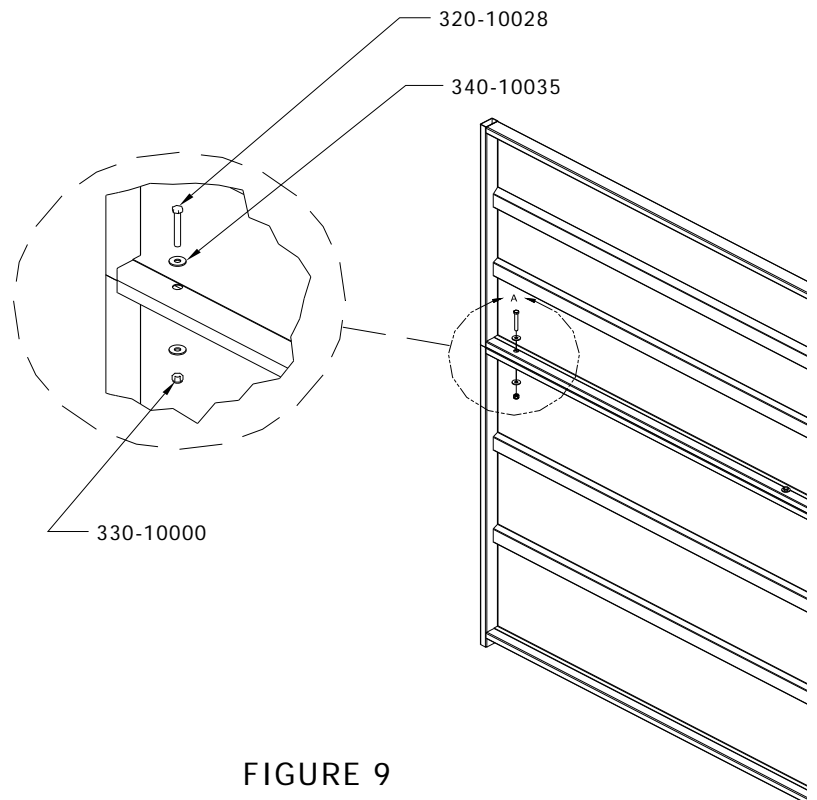


FIGURE 9

### **Step 10**

Locate the roll door and remove the roller brackets that have been bolted to the top of the roll door upside down for shipping purposes.

Use the same bolts, washers, and nuts to bolt one of the roller brackets to the roll door (see figure 10). Follow step 11 for second roller bracket.

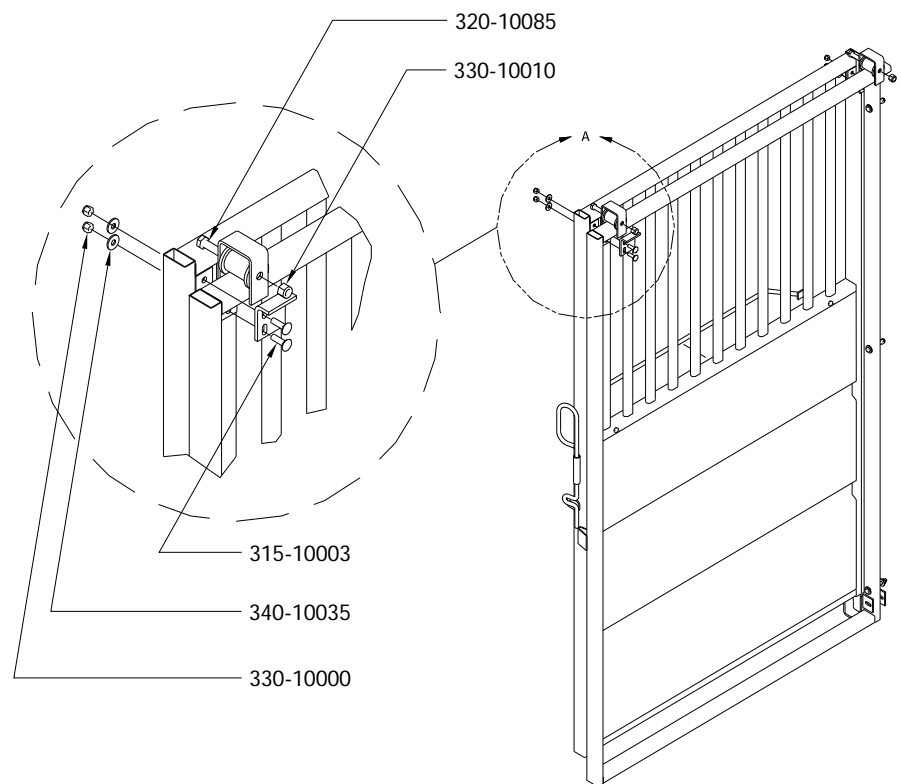


FIGURE 10

### **Step 11**

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 11. 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 (see figure 11).

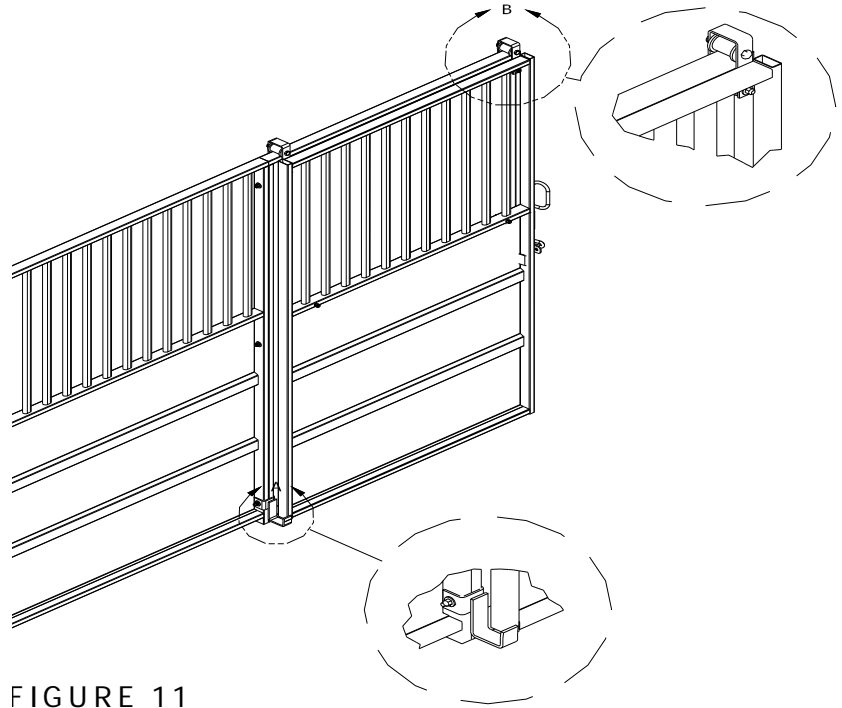


FIGURE 11

### **Step 12**

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 12).

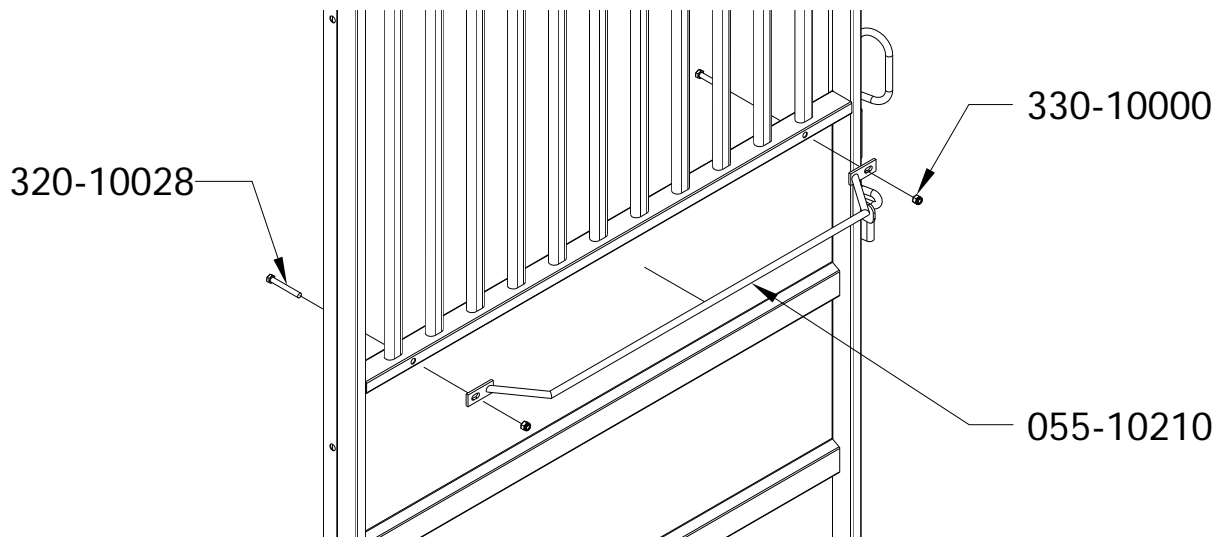


Figure 12

*Note: It may be necessary to adjust the door so that it is level. To do this, loosen the two bolts on the roller bracket and adjust each side of the roll door one at a time until it is level.*

### **Step 13**

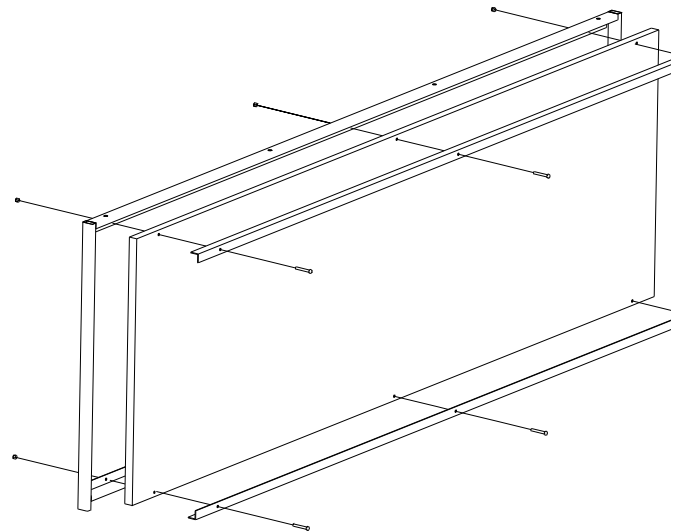
When installing wood paneling (plywood or tongue and groove; which are not included) on the sides, front, back, and door of a stall place the wood paneling into the channel at the top and bottom. Place the angle connector around the top edge of the wood panel forming a “u” shaped channel with the angle iron that is welded to the frame. Secure it together with 5/16” x 1-3/4” bolts and 5/16” weld nuts .

*Note: The number of bolts and weld nuts depend on the length of the panels.*

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

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

**Figure 13**

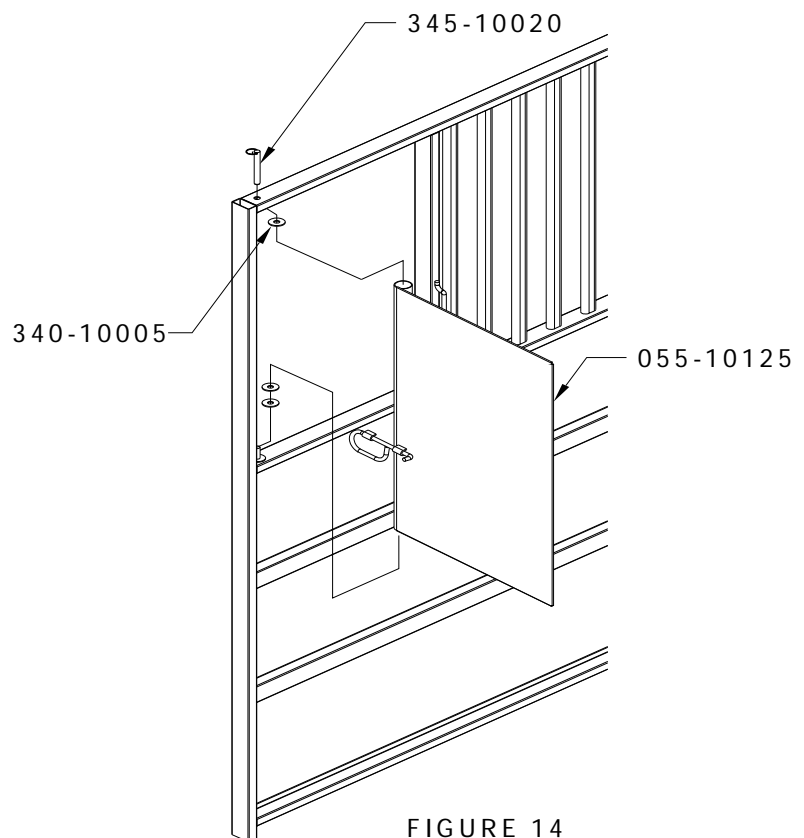


### **Step 14**

Assembly of feed door and feeder

*Note: Not all Integrate Equine Systems come with feed doors and/or feeders.*

Place (2) 1/2” washers over the 1-1/2” post at the end of the feed door opening on the front panel. Slide the feed door over the washers and on to the 1-1/2” post. Secure the door in place with 1/2” hitch pin (see figure 14).



**FIGURE 14**

**Step 15**

Align the holes of the feeder brackets with the holes of the feeder bucket and fasten them together with (6) 3/16" x 3/4" hex bolts and 3/16" lock nuts (see figure 15).

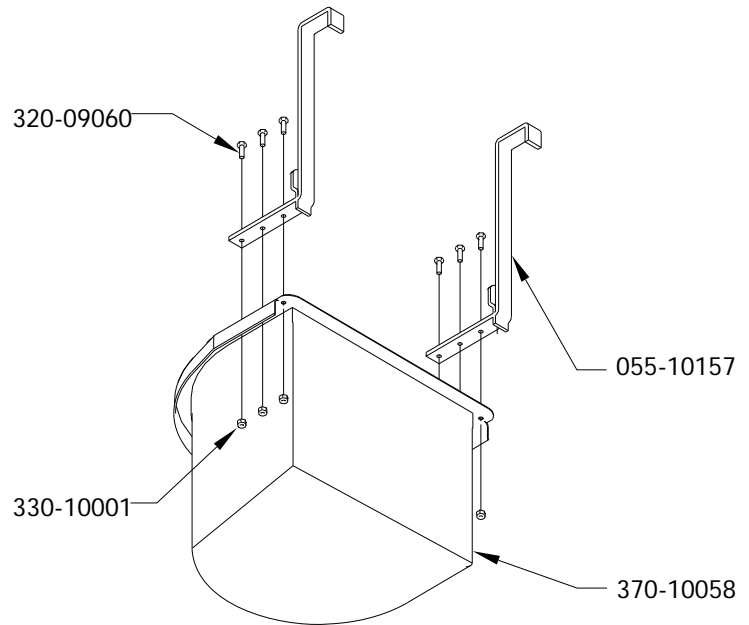


FIGURE 15

**Step 16**

The feeder bucket hangs from the doorway of the feed door (see figure 16).

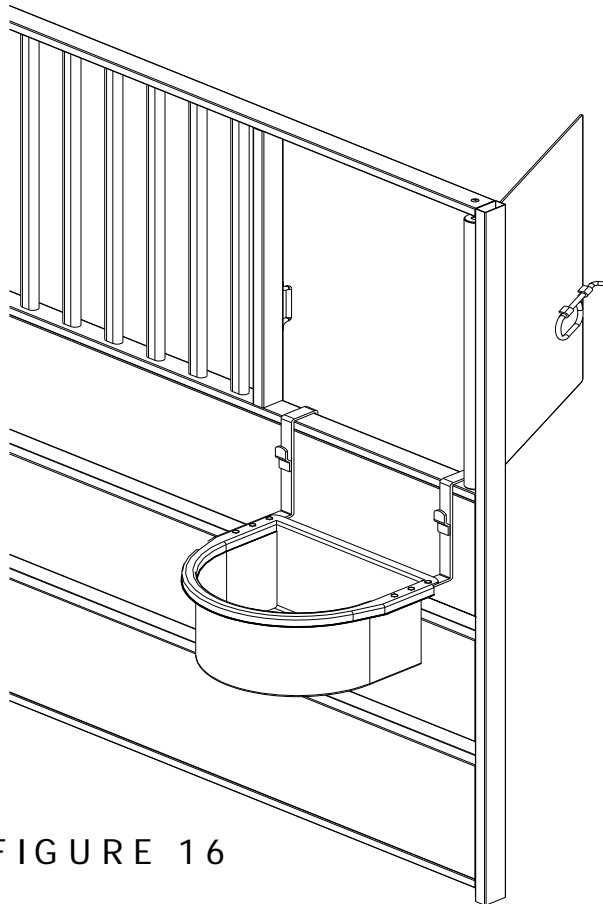
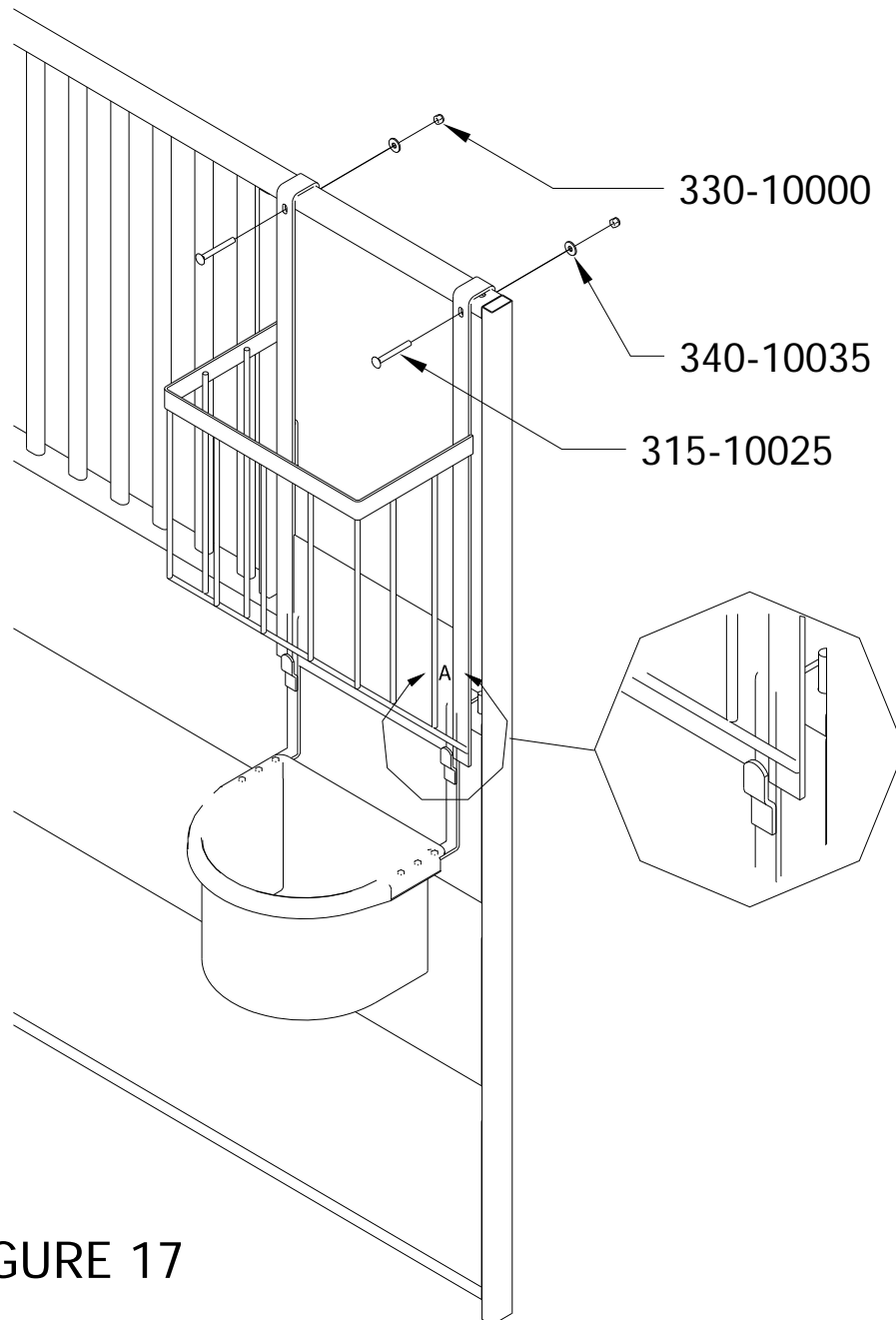


FIGURE 16

**Step 17**

Mount the feed manger by sliding the bottom sheeting into the brackets of the feed bucket and hanging it in the doorway of the feed door as shown in figure 17. Secure it in place with (2) 3/8" x 3" carriage bolts, 3/8" washers, and lock nuts (see figure 17).



**FIGURE 17**

Repeat steps 2 through 17 to install the second stall (panels 5-8) following the sequence labeled in step 2. Tighten all four-way connectors upon completion. When finished proceed to step 25.

### **Step 18**

Installing 2" open paneling.

For installation of Stall Panels follow the sequence in figure 2.

Insert a 2" panel connector in the end tube of a 2" panel (see figure 18). Place a center connector on top of the 2" panel connector. Invert and insert a 2" panel connector into the center connector and 2" panel (see figure 18).

### **Step 19**

Attach a four-way connectors to the two end posts and bolt loosely to allow sliding up and down the post (see figure 18).

### **Step 20**

Slide the four-way connectors up on the post while setting the bottom panel connectors into the tabs of the post bottom plate.

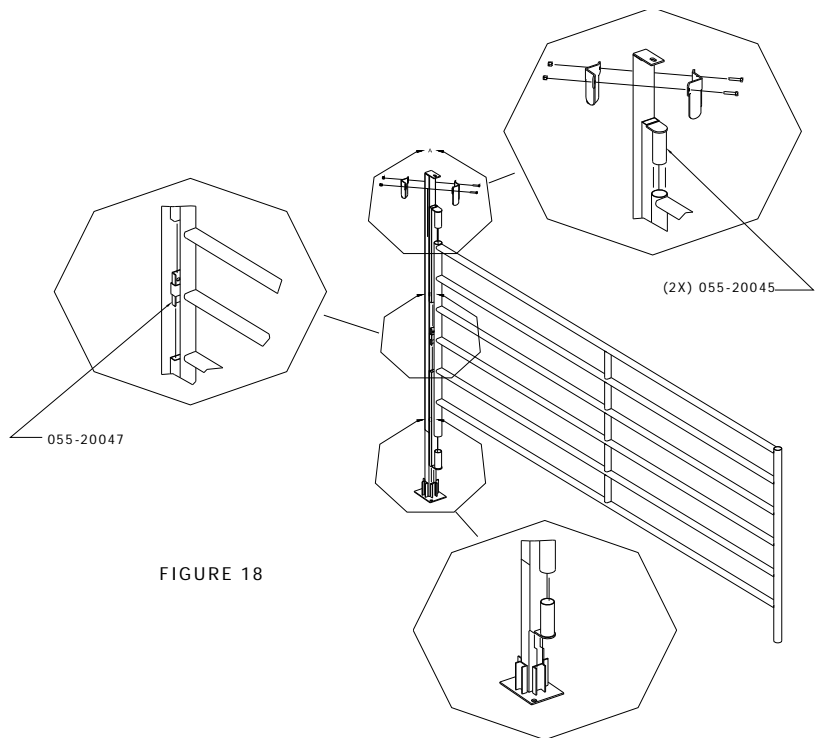
### **Step 21**

Slide the four-way connectors down placing the tabs into the top tubes of the panel connectors (see figure 18). Install the second panel following steps 18 through 21.

### **Step 22**

To install the third panel insert a 2" bottom panel connector in the end tube of a 2" panel (see figure 18). Place a center connector on top of the 2" panel connector. Invert and insert a 2" panel connector into the center connector and 2" panel (see figure 18). Follow steps 19 through 21 to continue the installation.

**SEE NEXT PAGE FOR  
MORE DETAIL**



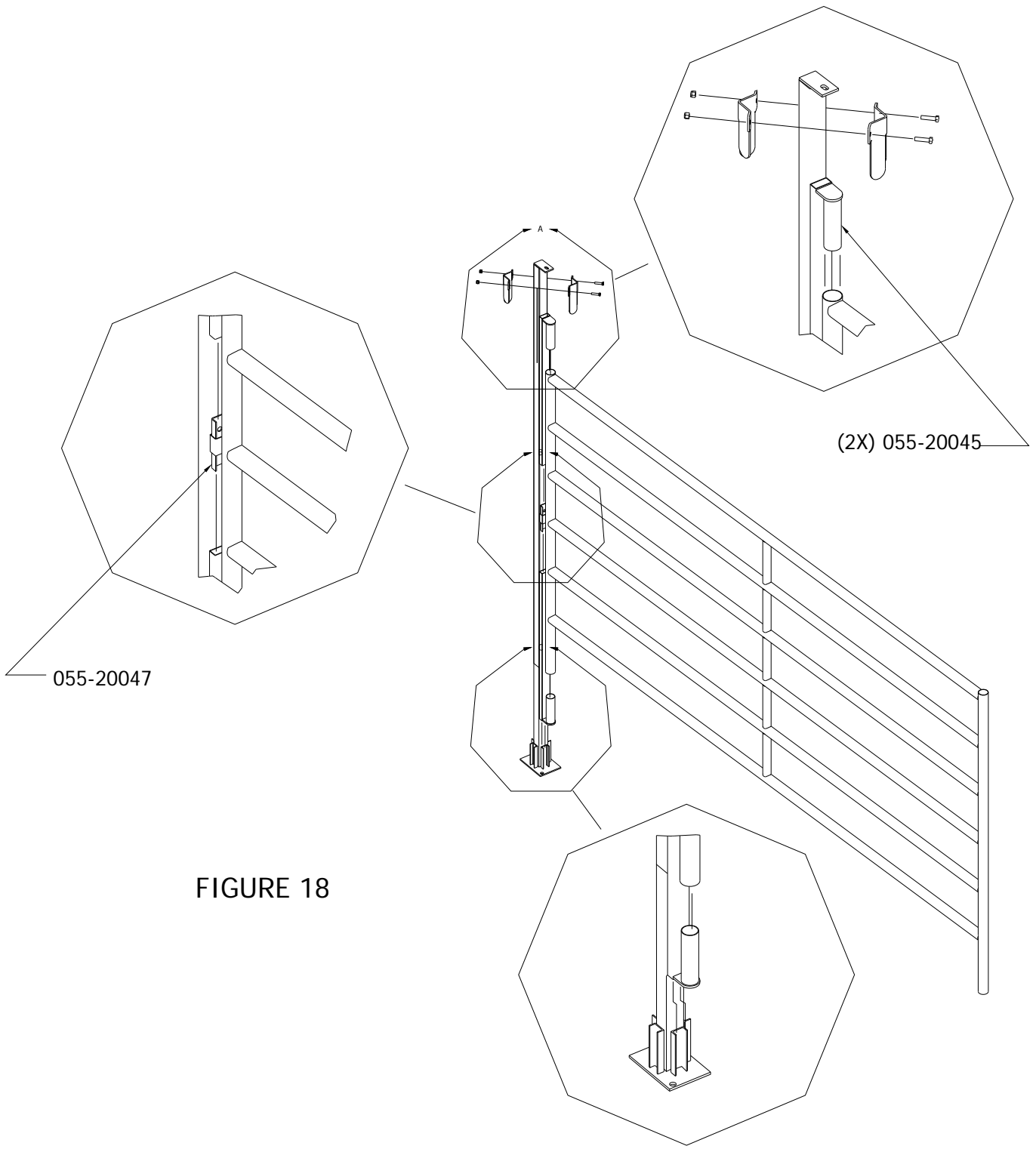


FIGURE 18

### **Step 23**

To install the 2" combo panel insert a 2" combo adapter into the bottom end tube of a 2" panel (see figure 19). Place the bow section into the cradle section of the adapter (figure 23).

### **Step 24**

Slide the four-way connectors up on the post while setting the combo in tabs of the post bottom plate (see figure 19). Slide down the four-way connector placing the tabs into the top tube of the combo adapter (see figure 19).

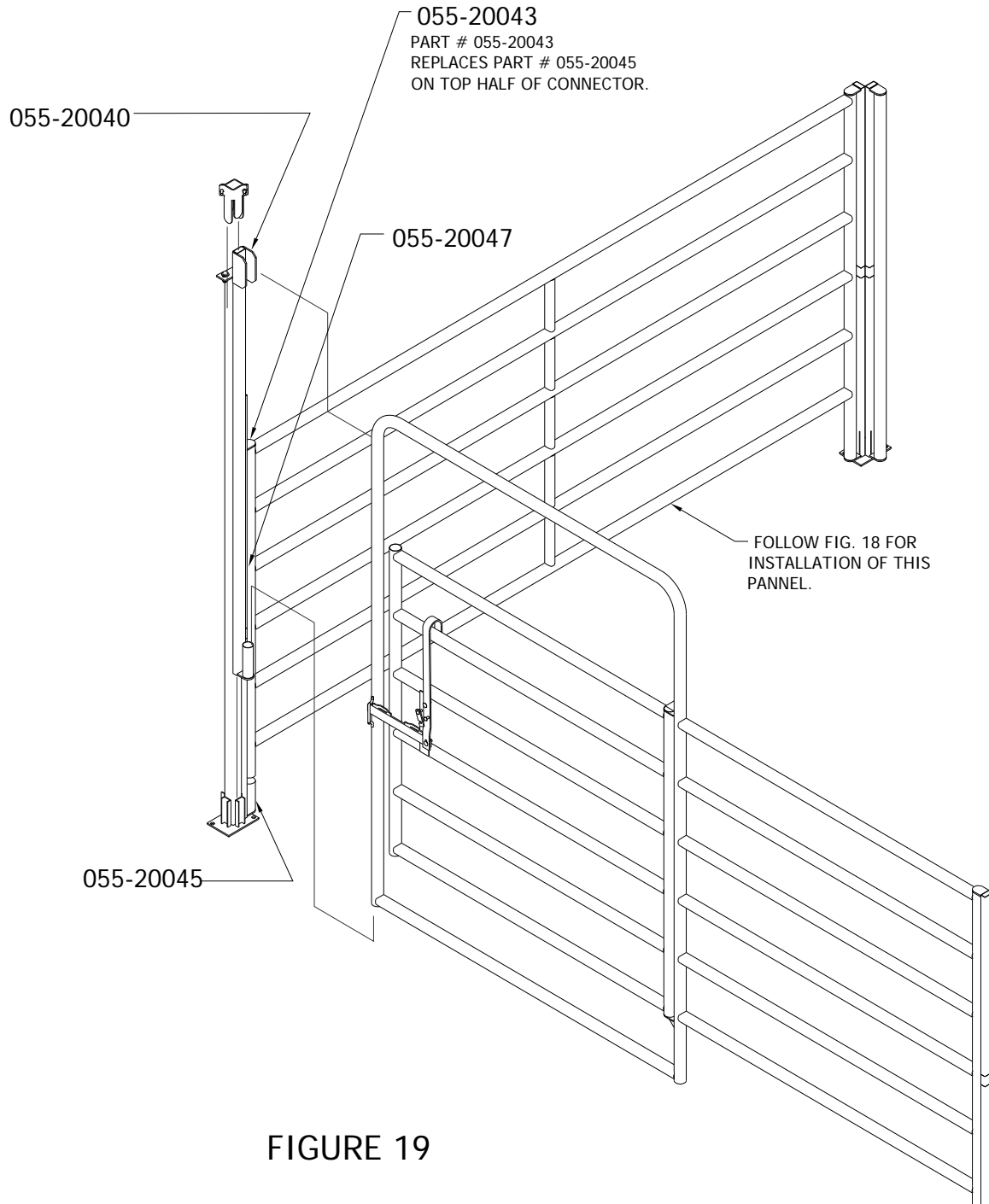


FIGURE 19

### **Step 25**

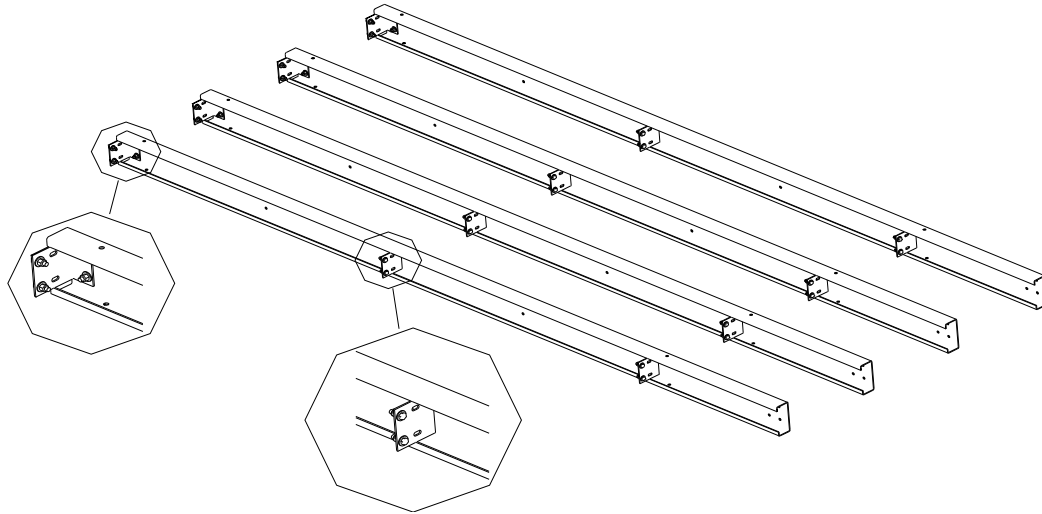
Repeat steps 2 through 17 to install the second stall (panels 5-8) following the sequence labeled in step 2. Tighten all four-way connectors upon completion.

### **Step 26**

Bolt twelve (½"x1½" hex bolts) L-brackets to the rafters leaving the bolts loose (see figure 20).

*Note: When assembling one stall Integrated Equine Systems, bolt eight ( ½"x1½" hex bolts) L-Brackets to the rafters leaving the bolts loose.*

**Figure 20**



### **Step 27**

Lift rafters into place on top of post placing the inside channeling of the rafter inwards. Bolt to post. Tighten bolts on the L-brackets. (see figure 21).

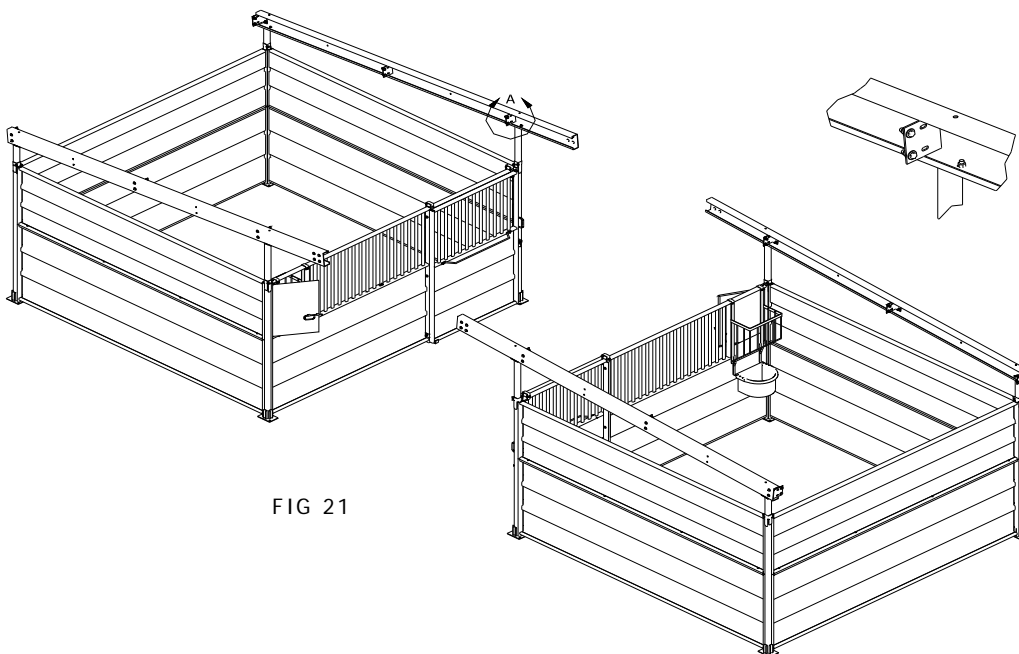
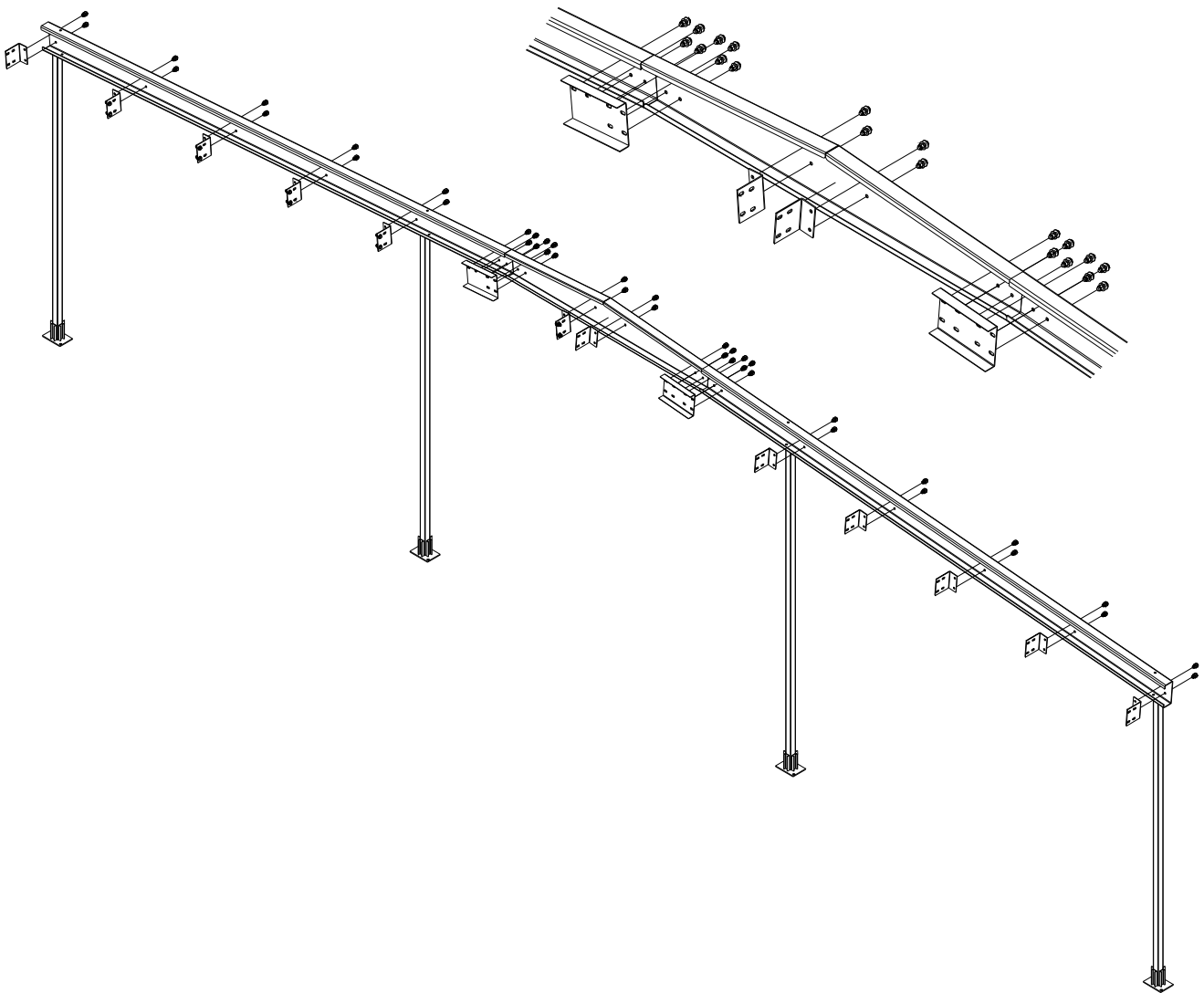


FIG 21

## **Step 28**

*Note: When assembling one stall Integrated Equine Systems omit step 28.*

Mount two L-brackets to the center of each breeze-way beam (center rafter). Slide the mount plates (small channels) into each end of the breeze-way beams. Install the bridge by sliding the mount plates out of the rafters and into the bridge to hold it into place. Bolt the mounting plates to rafters (as shown in figure 22).

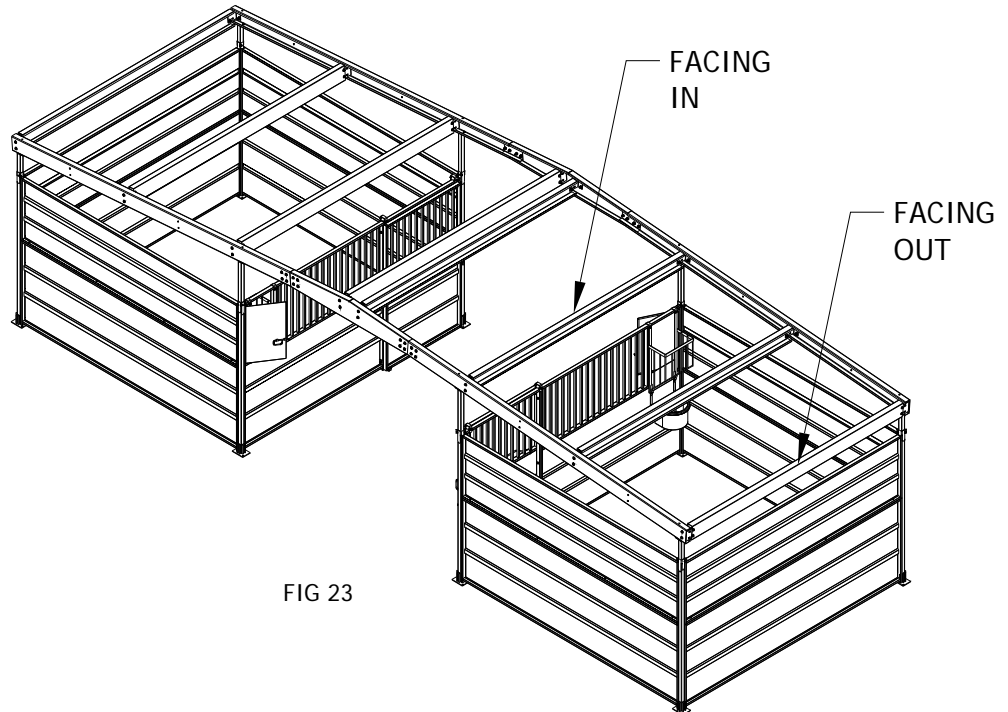


**FIG 22**

## **Step 29**

Bolt eight purlins into place; with the smooth sides of end purlins facing out and the smooth sides of the inner purlins facing the center (see figure 23).

*Note: When assembling one stall Integrated Equine Systems bolt four purlins into place; with the smooth side of the end purlin facing out and the smooth sides of the remaining purlins facing forwards (see figure 23-B).*



## **Step 30**

Verify that all bolts are tight and structure is sturdy.

## **Step 31**

Depending on Equine System, install metal roofing.

