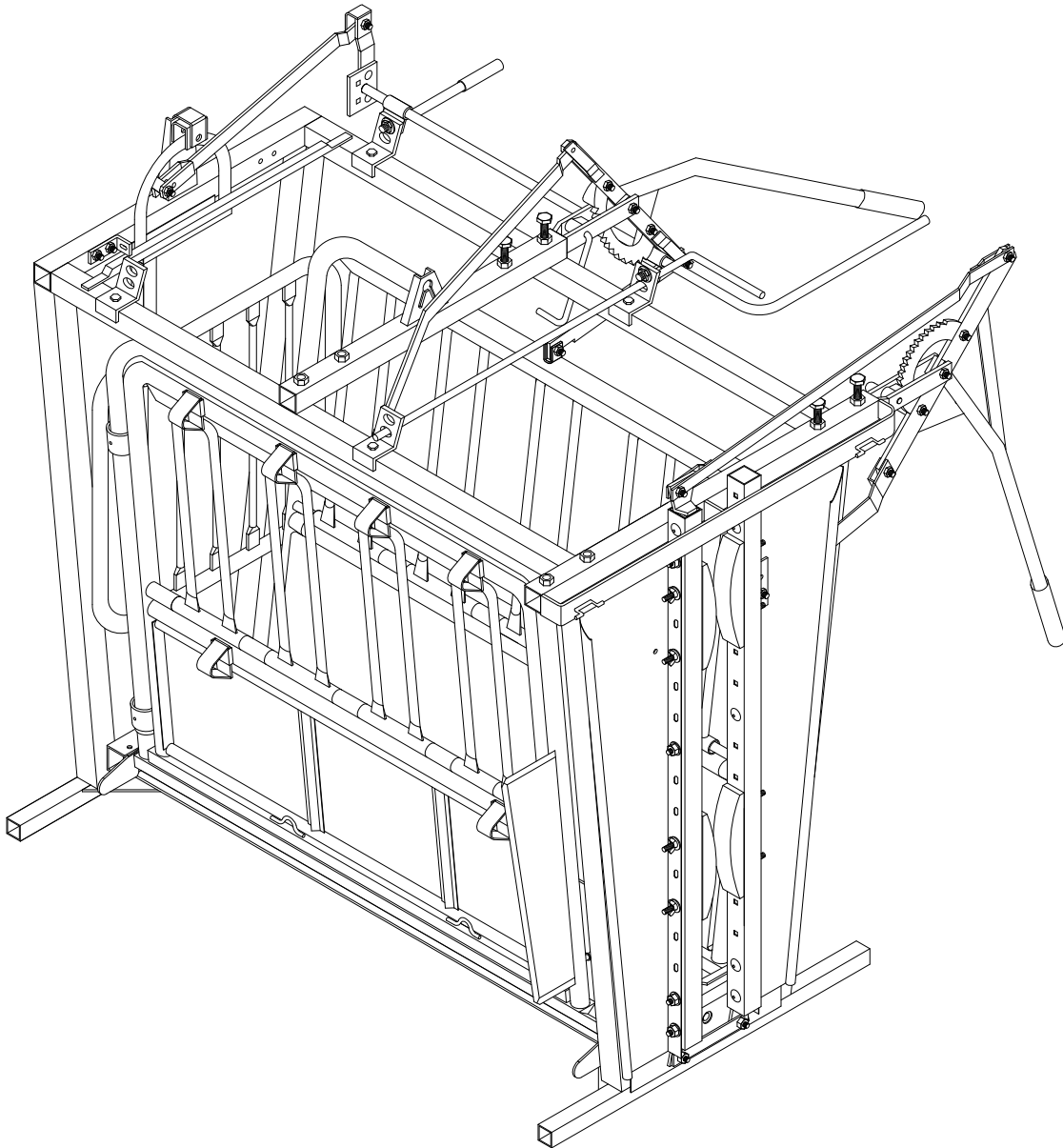


HEAVY DUTY CHUTE SAFETY YOKE CONVERSION

ASSEMBLY INSTRUCTIONS

#001-00155



POWDER RIVER

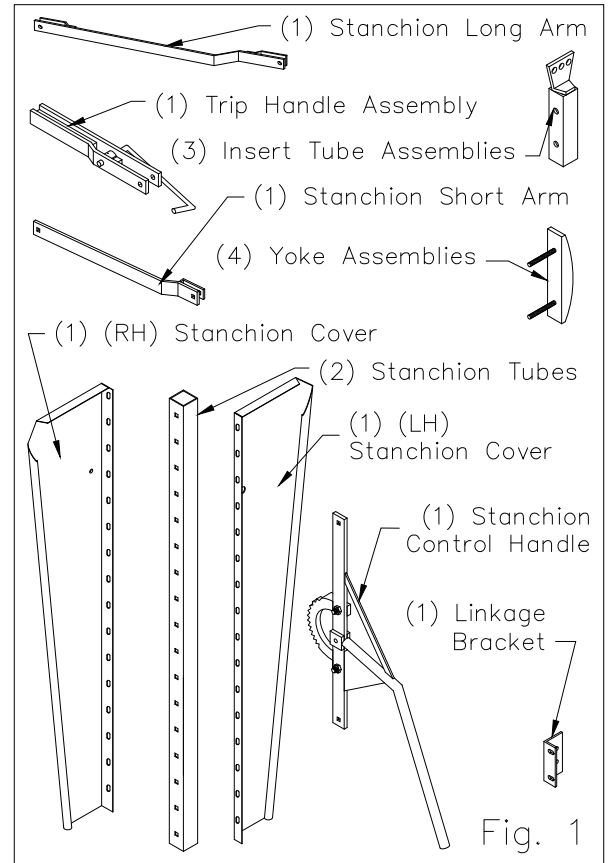
• LIVESTOCK HANDLING EQUIPMENT •

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STEP 1:

Remove all packaging and make sure that each part in figure 1 is accounted for.

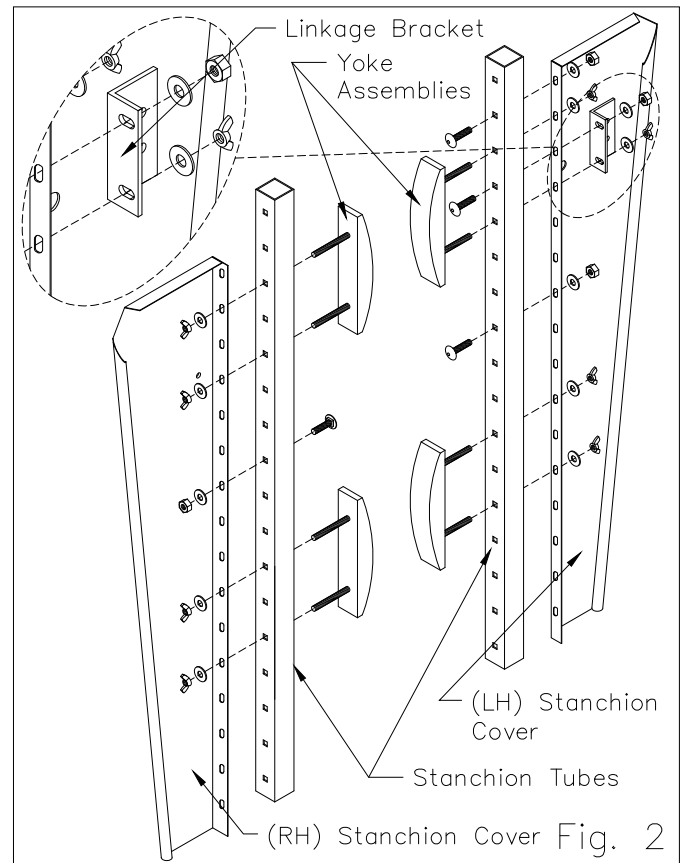


STEP 2:

Using figure 2 as a reference bolt the two Stanchion Tubes to the right and left-hand Stanchion Covers, using (3) 1/2" x 3 1/2" carriage bolts, washers and lock nuts.

Bolt the Linkage Bracket to the Left-hand Stanchion Cover and Stanchion Tube with (1) 1/2" x 3 1/2" carriage bolt, washer and lock nut as shown in figure 2.

Secure the (4) Yoke Assemblies to both Stanchion Tubes with (8) 1/2" Wing nuts and washers as shown in figure 2.



STEP 3:

Slide the Insert Tube Assemblies into the ends of the Stanchion Tubes as shown in figure 3. Secure them in place with (6) 1/2" x 3 1/2" carriage bolts, washers and lock nuts as shown

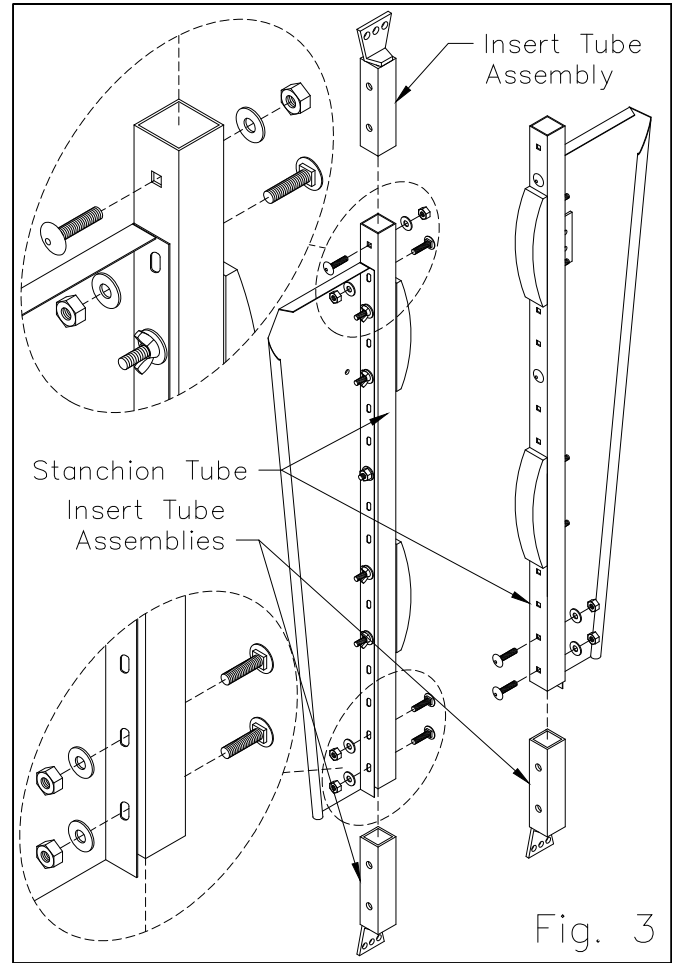


Fig. 3

STEP 4:

Bolt the Long and Short Arms to the Stanchion Control Handle with (2) 1/2" x 1 3/4" carriage bolts and lock nuts as shown in figure 4.

Bolt the Trip Handle Assembly to the Stanchion Control Handle with (1) 5/8" x 3 1/2" hex bolt and lock nut as shown.

Slide the Yellow Grip on the end of the handle.

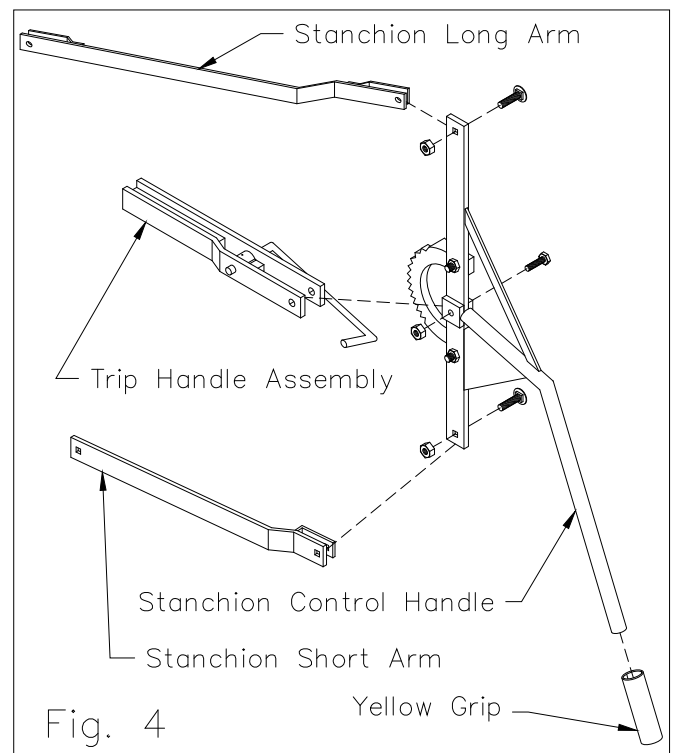


Fig. 4

STEP 5:

In order to remove the Auto Head Gate you will need to raise the front end of the chute off the ground.



**FOR YOUR SAFETY SECURELY
BLOCK IT!**

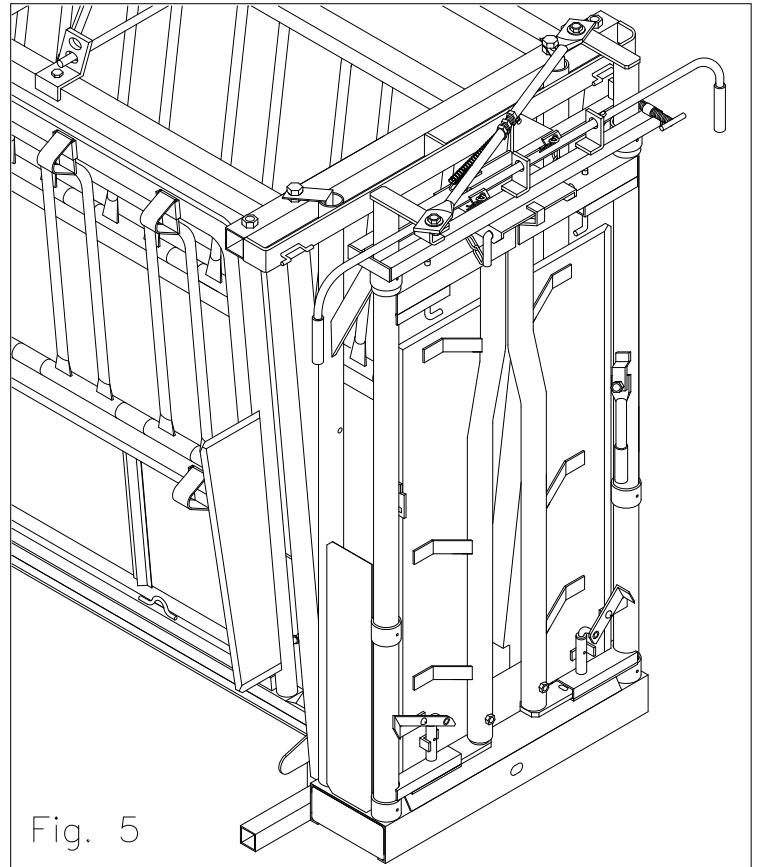


Fig. 5

STEP 6:

With the front end of the chute raised off the ground and securely blocked, remove the (2) 5/8" lock nuts and the Stanchion Hinge Strap from underneath the Auto Head Gate as shown in figure 6.



IMPORTANT!

***TO PREVENT THE AUTO HEAD GATE
FROM FALLING AND CAUSING INJURY
TO YOU, SET THE CHUTE COMPLETE
DOWN ON THE GROUND BEFORE
CONTINUING!***

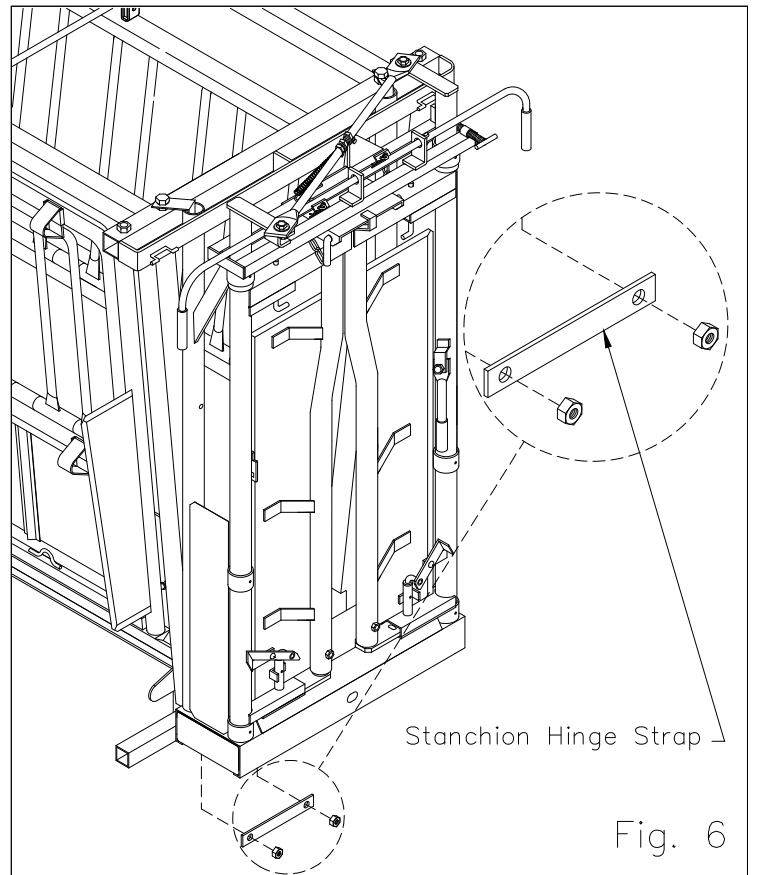


Fig. 6

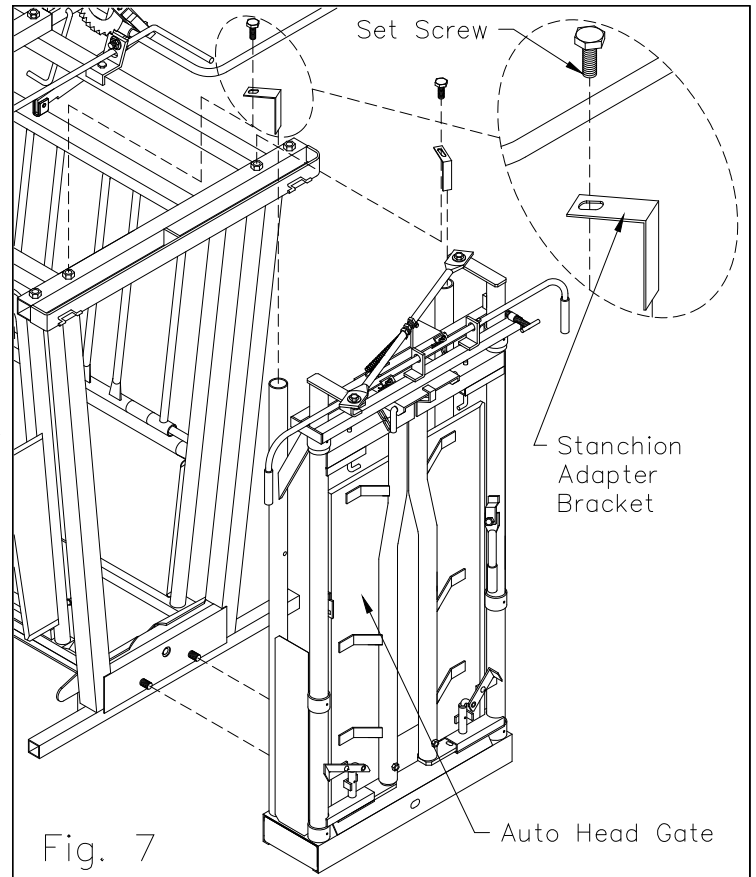
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STEP 7:

With the chute on the ground remove the (2) set screws that hold the Stanchion Adapter Brackets in place. Remove the Stanchion Adapter from the Head Gate as shown in figure 7.

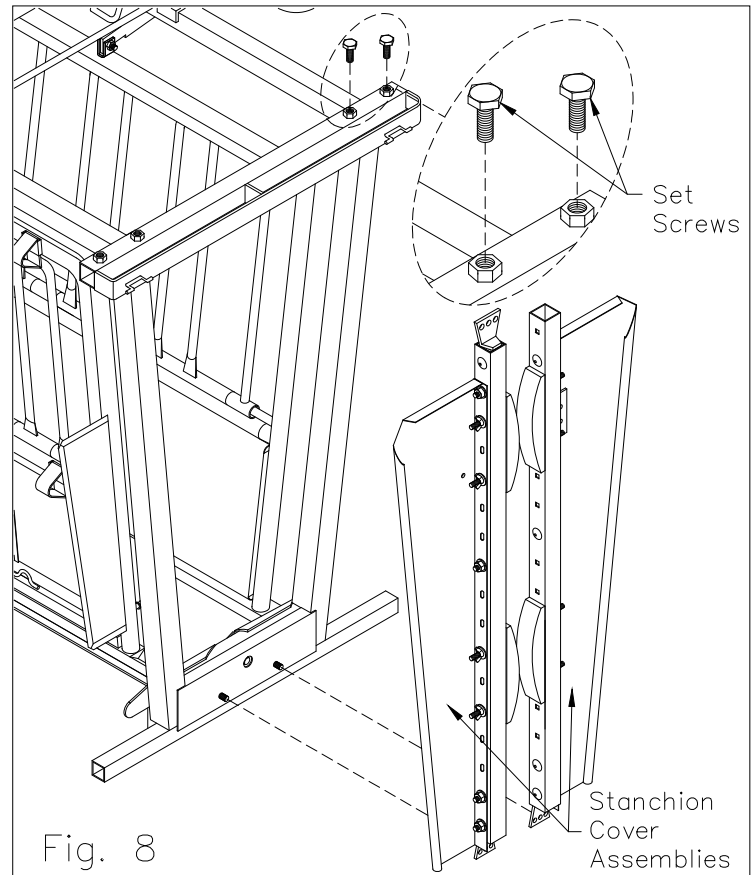
Pull the bottom of the Auto Head Gate out away from the bolts at the bottom of the chute. Raise the front end of the chute up until the Auto Head Gate can be moved out away from the chute as shown.

NOTE: It will take at least two men to move the Auto Head Gate.

**STEP 8:**

Place the (2) Set Screws that were removed in step 7 into the nuts on the front frame of the chute as shown in figure 8.

Slide the Stanchion Cover Assemblies between the slots at the top of the front frame and onto the bolts on the bottom of the front frame as shown. (Refer to figure 9 for a picture of Stanchion Cover Assemblies attached to the chute frame.)



STEP 9:

Using the (2) 5/8" lock nuts that were removed in step 6, bolt the Stanchion Hinge Strap onto the bottom of the chute as shown in figure 9.

Slide the Stanchion Control Assembly all the way into the front square tube as shown. Secure the Control Assembly to the chute by tightening the set screws as shown in figure 9.

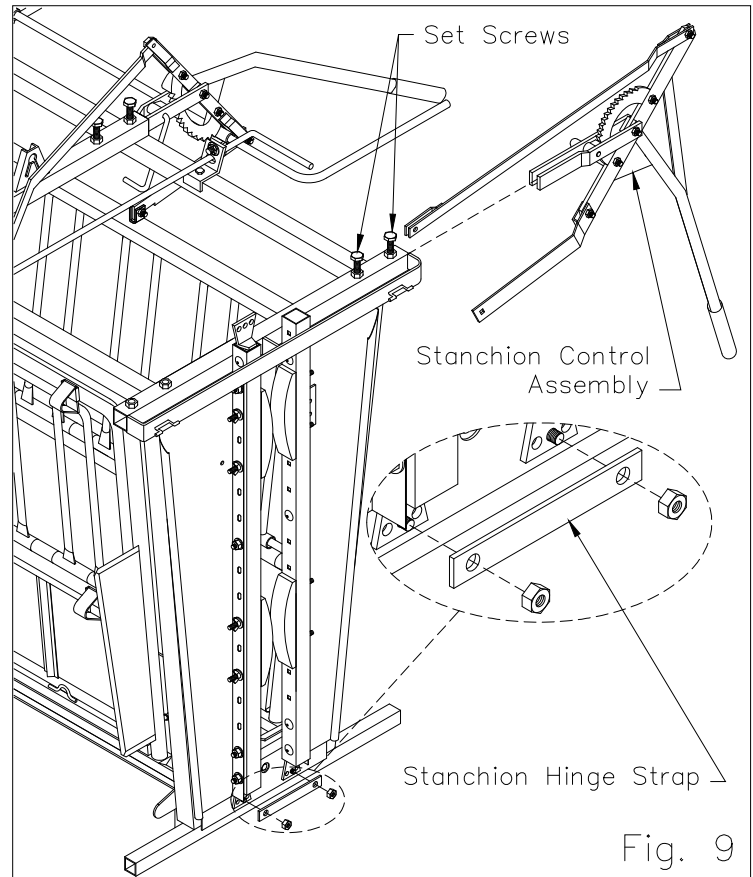


Fig. 9

STEP 10:

Using a 5/8" x 2" carriage bolt and lock nut secure the Stanchion Long Arm to the far hole on the Inset Tube Assembly as shown in figure 10.

Slide the Stanchion Short Arm behind the Stanchion Cover and secure it to the Stanchion Cover using a 1 1/2" x 1 1/2" carriage bolt and lock nut as shown.

NOTE: When the Head Gate is completely closed, the Stanchion Control Handle should be at the last notch on the Ratchet. If it is not at the last notch, you will need to move the Long Stanchion Strap to another hole on the Inset Bracket. This will allow the Head Gate to open as far as possible.

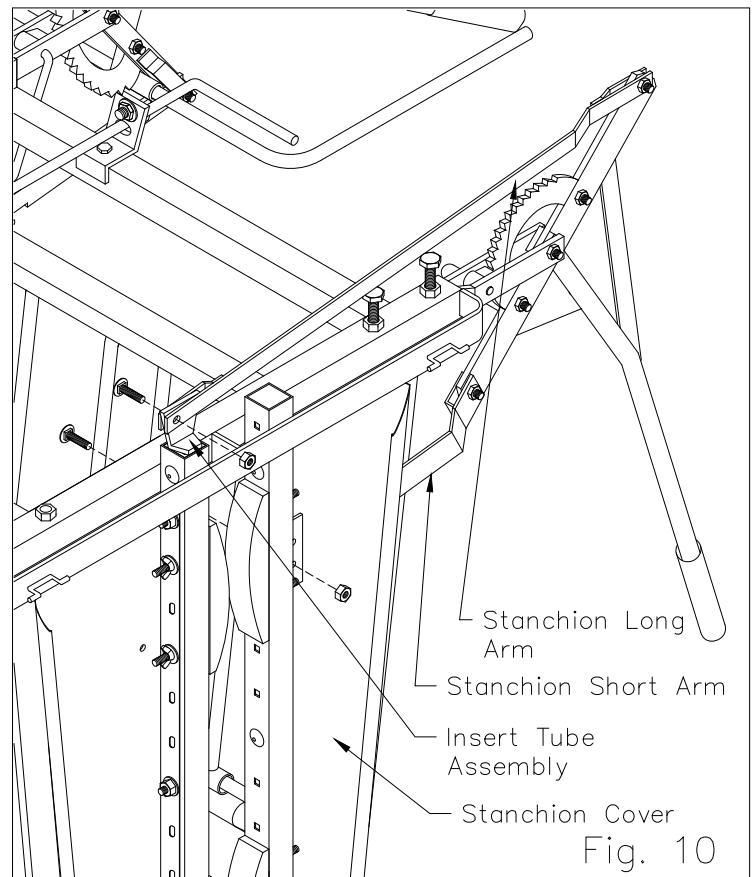


Fig. 10