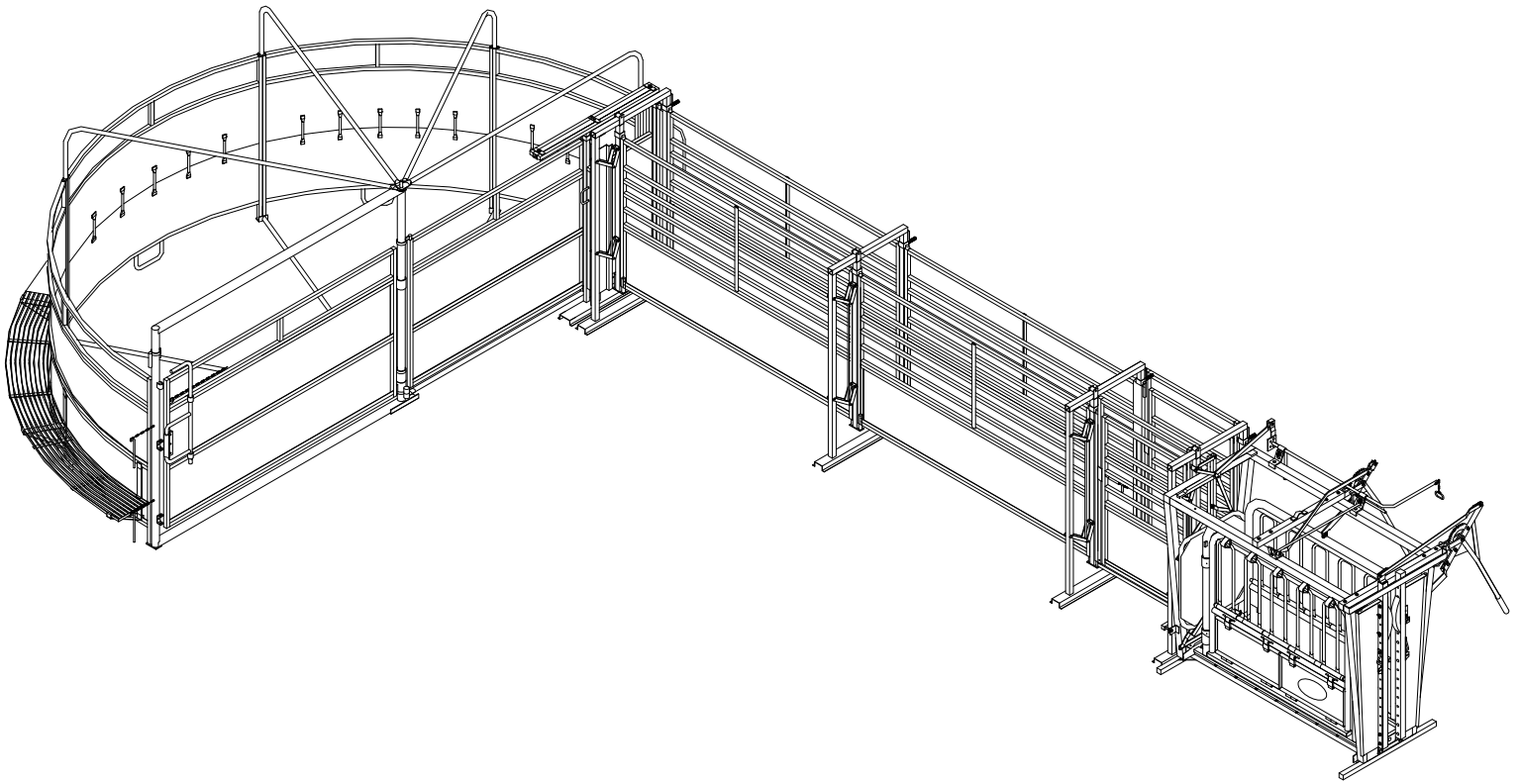


SYSTEM 2000

25' RANCHER STRAIGHT

ASSEMBLY INSTRUCTIONS

#007-50011



POWDER RIVER

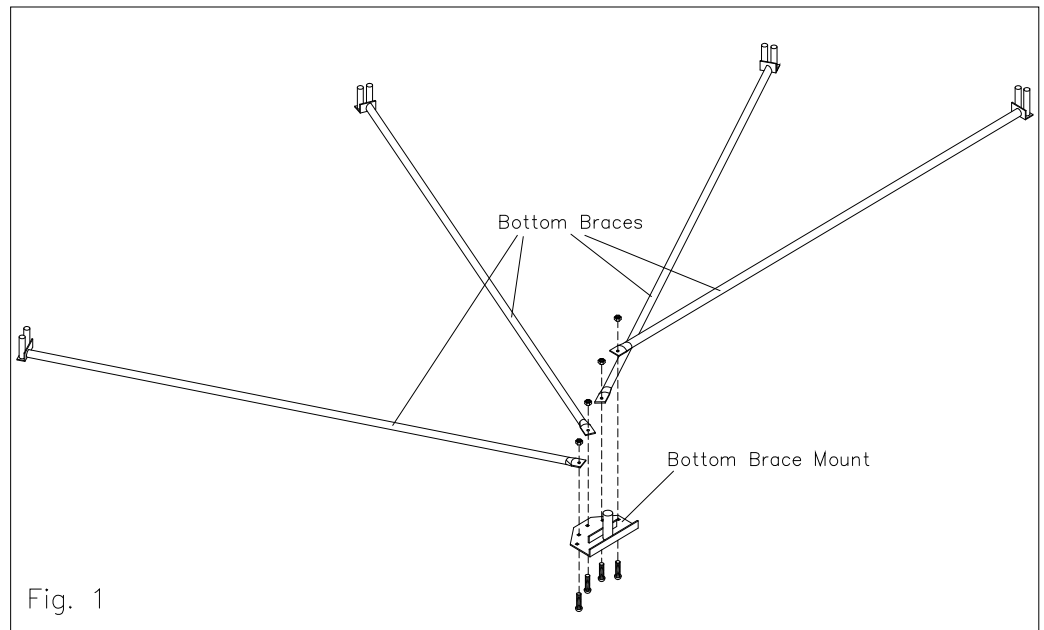
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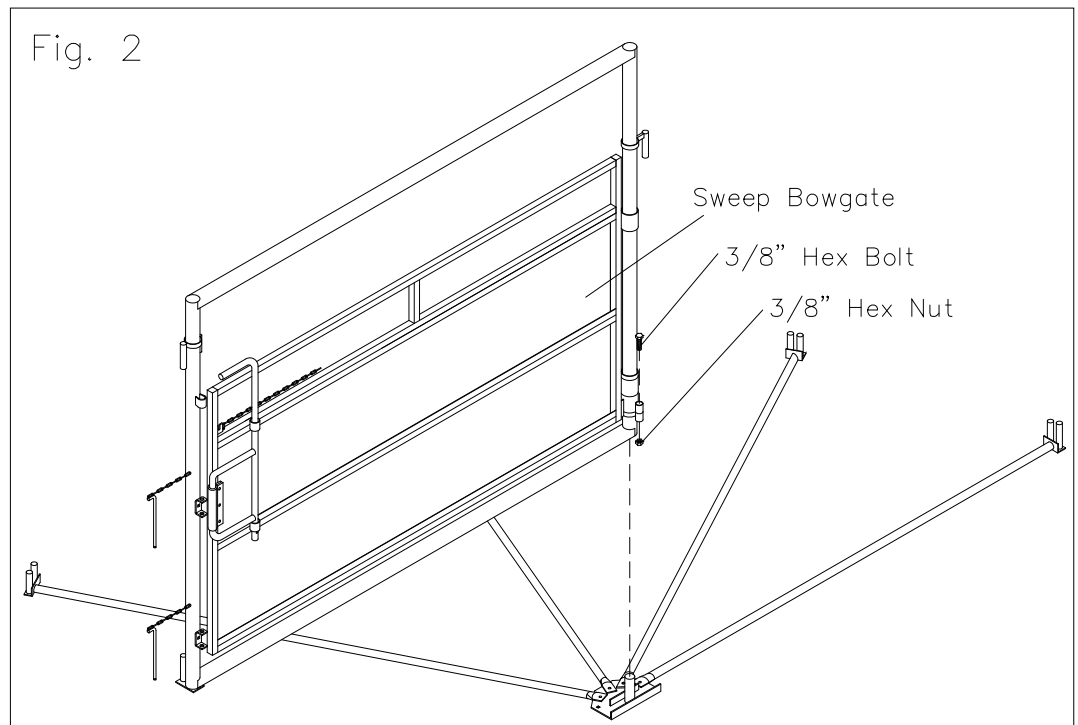
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STEP 1:

To begin the assembly, locate the position where the desired center of the sweep tub will be located. Place the bottom brace mount flat on the ground near the center and using (4) 1/2" X 1-1/4" carriage bolts and 1/2" lock nuts, secure the bottom braces into place as shown in figure 1.

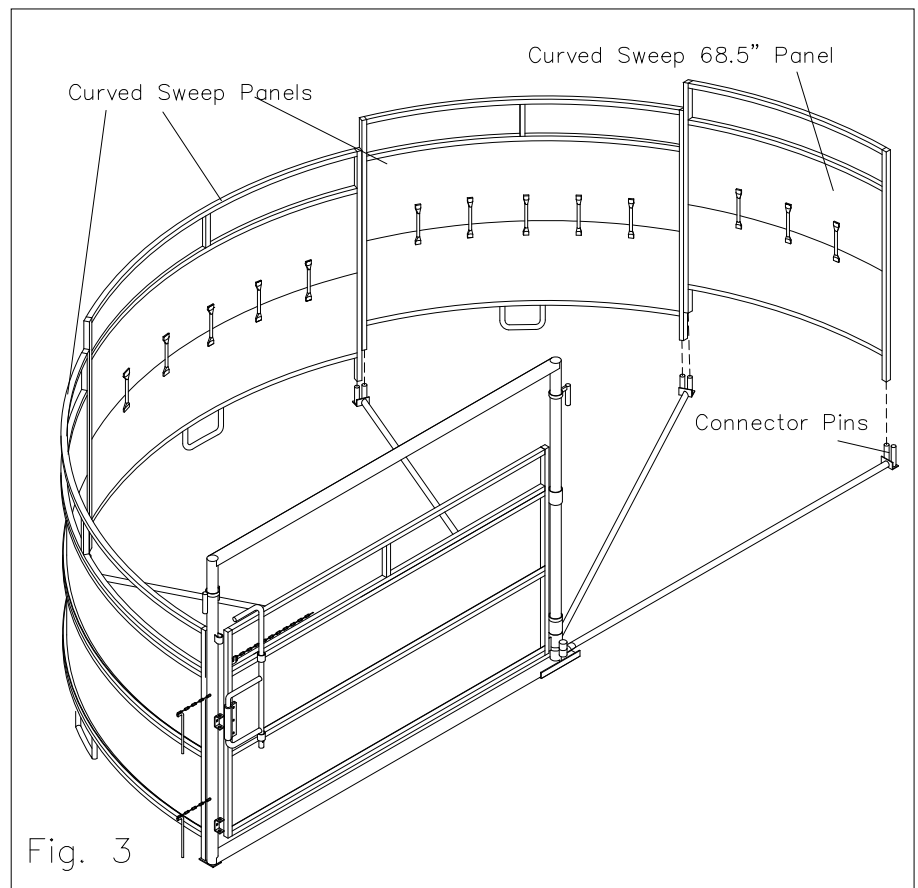
**STEP 2:**

Using a forklift, lower the Sweep Bowgate gently. The end pipe of the Bowgate should slide gently over the pipe in the center of the Bottom Brace Mount as shown in figure 2. Unscrew the Hex Nut on the bottom of the hinge on the Bowgate and remove the 3/8" Hex Bolt from the hinge. This will allow the Sweep Bowgate to swing all the way around the sweep tub.

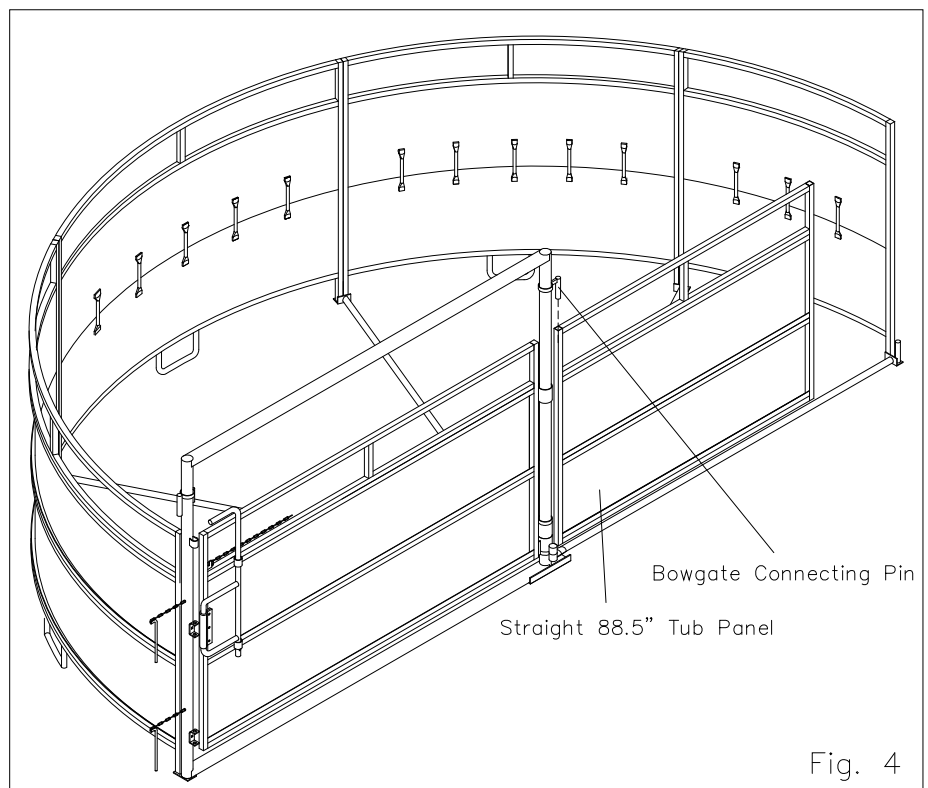


STEP 3:

Using figure 3 as a reference, lower each of the sweep panels into place. Starting at the left side of the Bowgate, slide the endpost of each of the three Curved Sweep Panels over the connector pegs on the Bottom Braces. Finally, slide the end of the shorter 68.5" Curved Sweep Panel into place by lowering it onto the connector pegs as well.

**STEP 4:**

Lift the Bowgate Connecting Pin up and lower the 88.5" Straight Tub Panel into place. Lower it over the connecting pin at the bottom of the Sweep Bowgate and then lower the Top Bowgate Connecting Pin into place as shown in figure 4.



STEP 5:

Now lower the longer tube of the Sweep to Alley Adaptor over the remaining Bottom Brace connector pin as shown in figure 5.

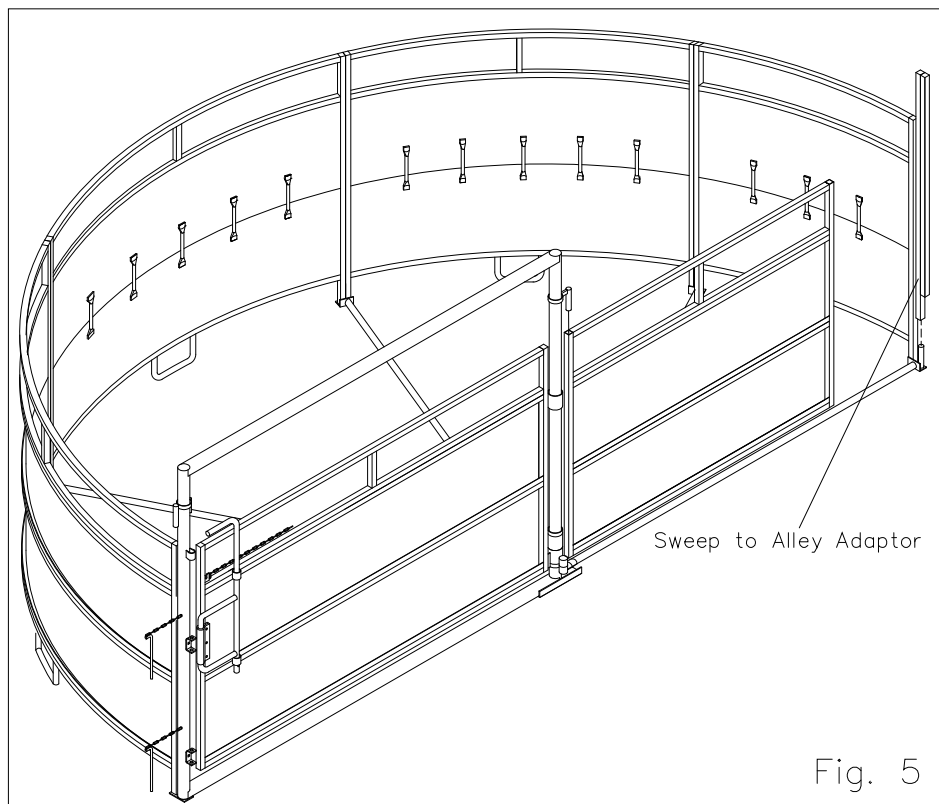


Fig. 5

STEP 6:

To complete the Sweep Tub portion of the assembly, lower the Sweep Top Brace Mount into the top of the Bowgate endpost. Then lower each of the Top Braces over the pipe on top of the Top Brace Mount and slide the connector pins on the ends of the Top Braces into the Sweep Panel endposts as shown in figure 6.

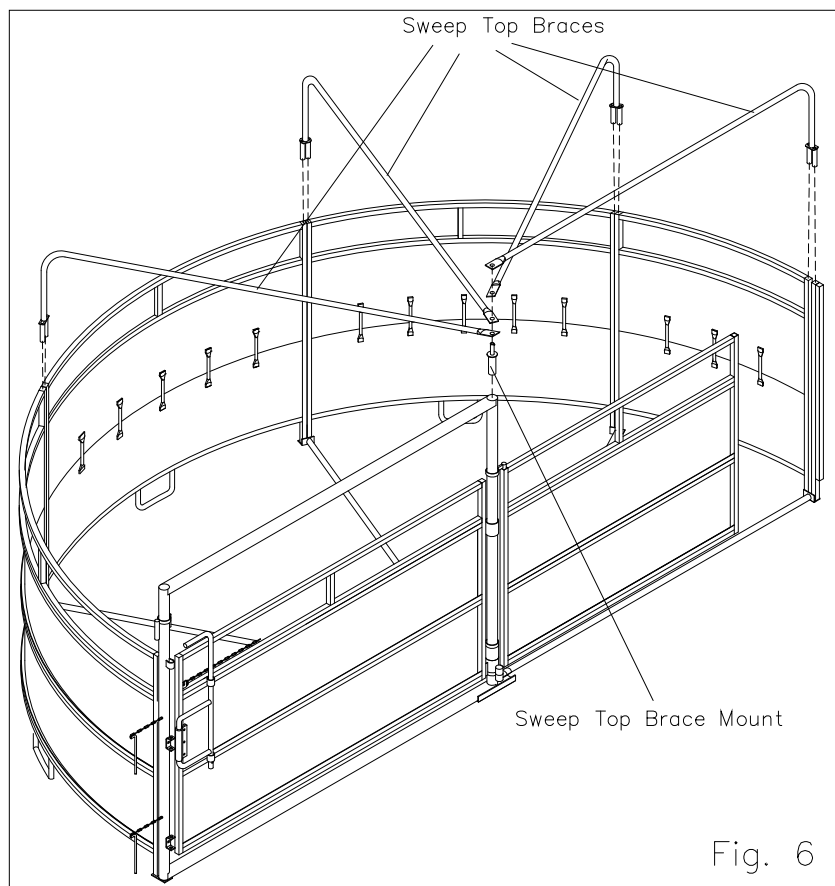


Fig. 6

STEP 7:

To begin adding the alley to the sweep tub, connect the Alley Roll Gate to the opening in the sweep tub. Slide one of the bottom connector pins on the Alley Roll Gate under the square tube endpost of the 88.5" Straight Tub Panel. The other connector pin on the bottom of the Alley Roll Gate should slide into the bottom of the Sweep to Alley Adaptor. Now slide the top connector pins on the Alley Roll Gate down into the top of the 88.5" Straight Tub Panel and the Sweep to Alley Adaptor as shown in figure 7.

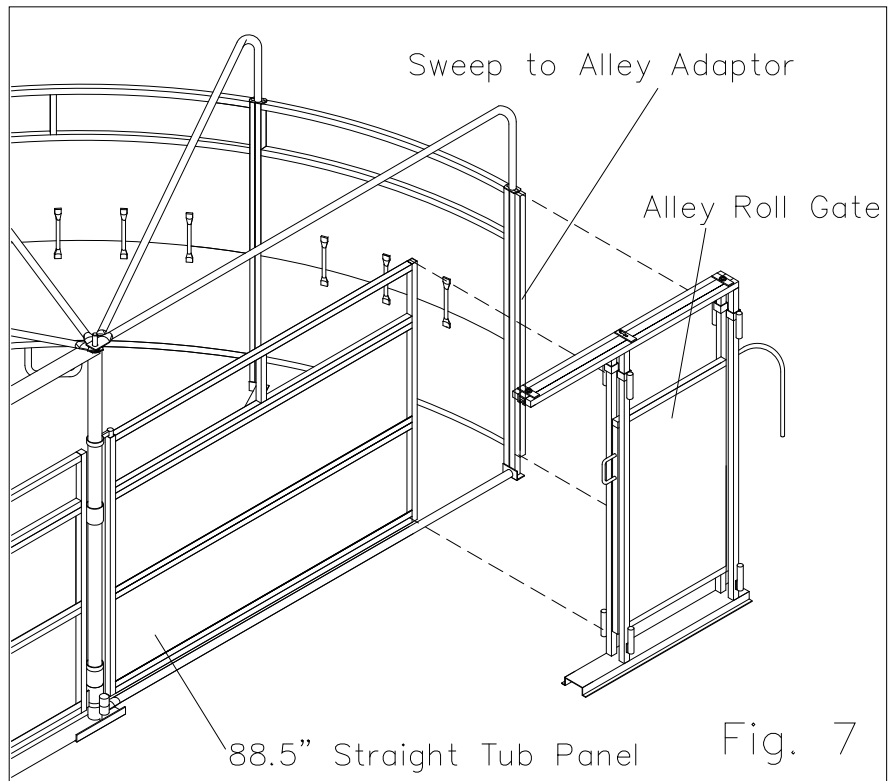


Fig. 7

STEP 8:

Add the Alley Roll Gate Adaptors to the alley by using the connector pins on the Alley Roll Gate. Slide the square tubes on each of the adaptors over the bottom connector pins. Then lower the top connector pins over the Alley Roll Gate Adaptor Set to secure the adaptors.

Next, attach the Alley Bow to the alley. Using the adaptor made of two square tubes, slide the square tube over the bottom connector pin on the Alley Bow and lower the top connector pin down into place. To secure the other part of the Adaptor Set, unscrew the bolts on the square tube of the Alley Bow Frame that align with the slots on the Adaptor. Push the bolts through the slots on the Adaptor and replace the nuts as shown in figure 8.

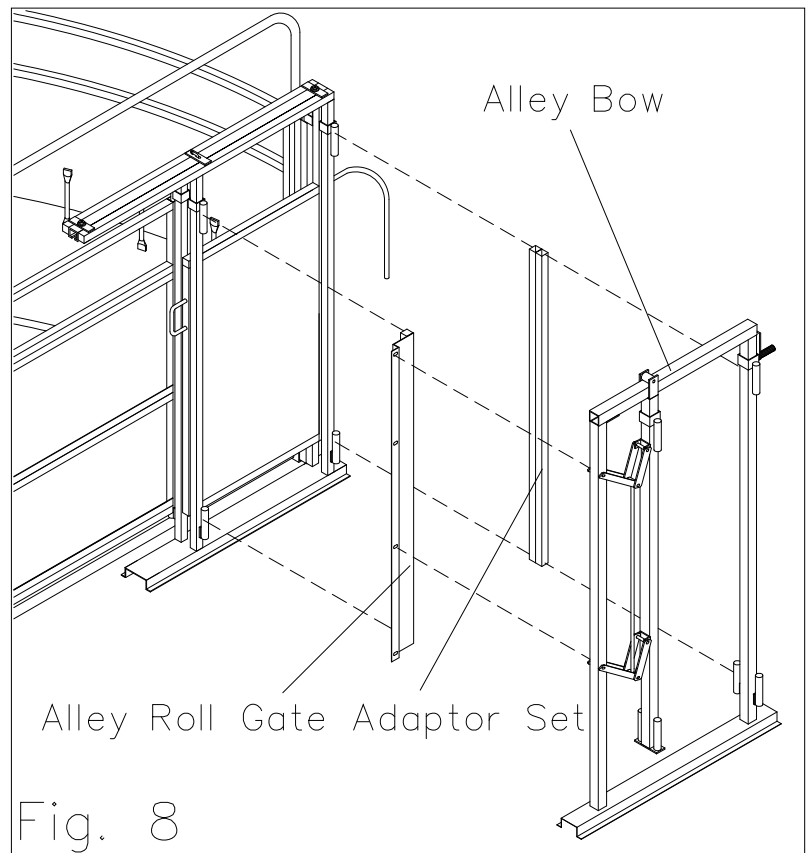
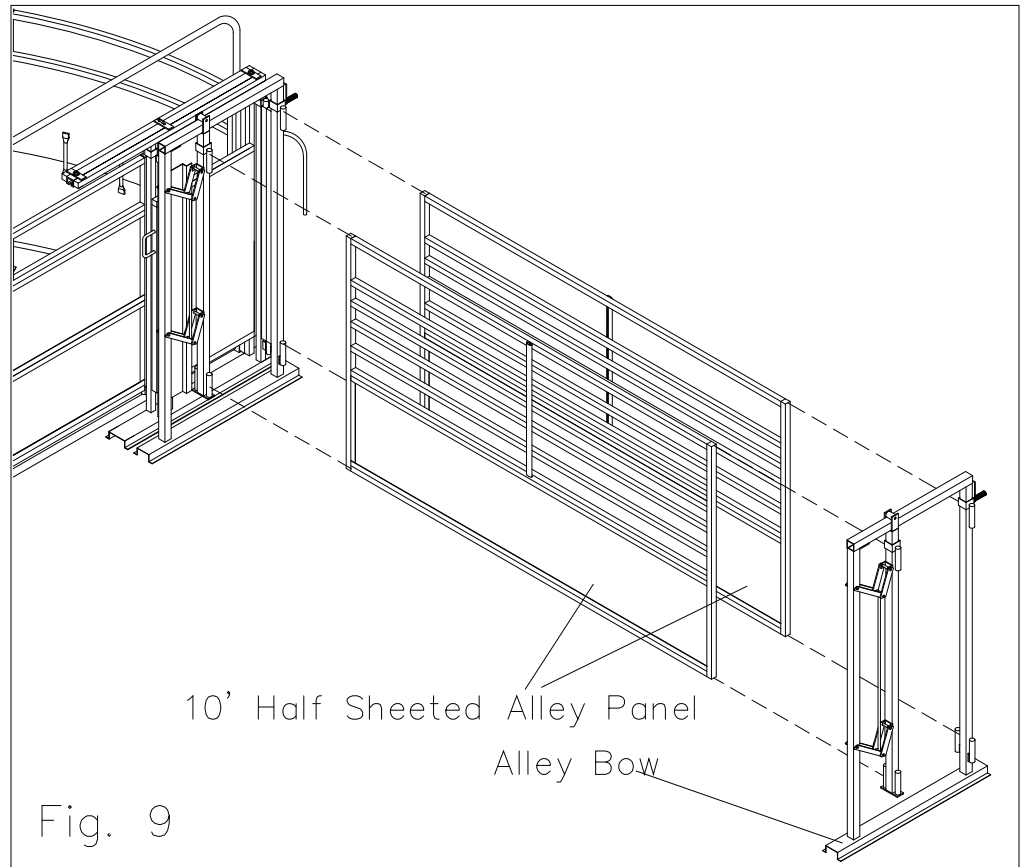


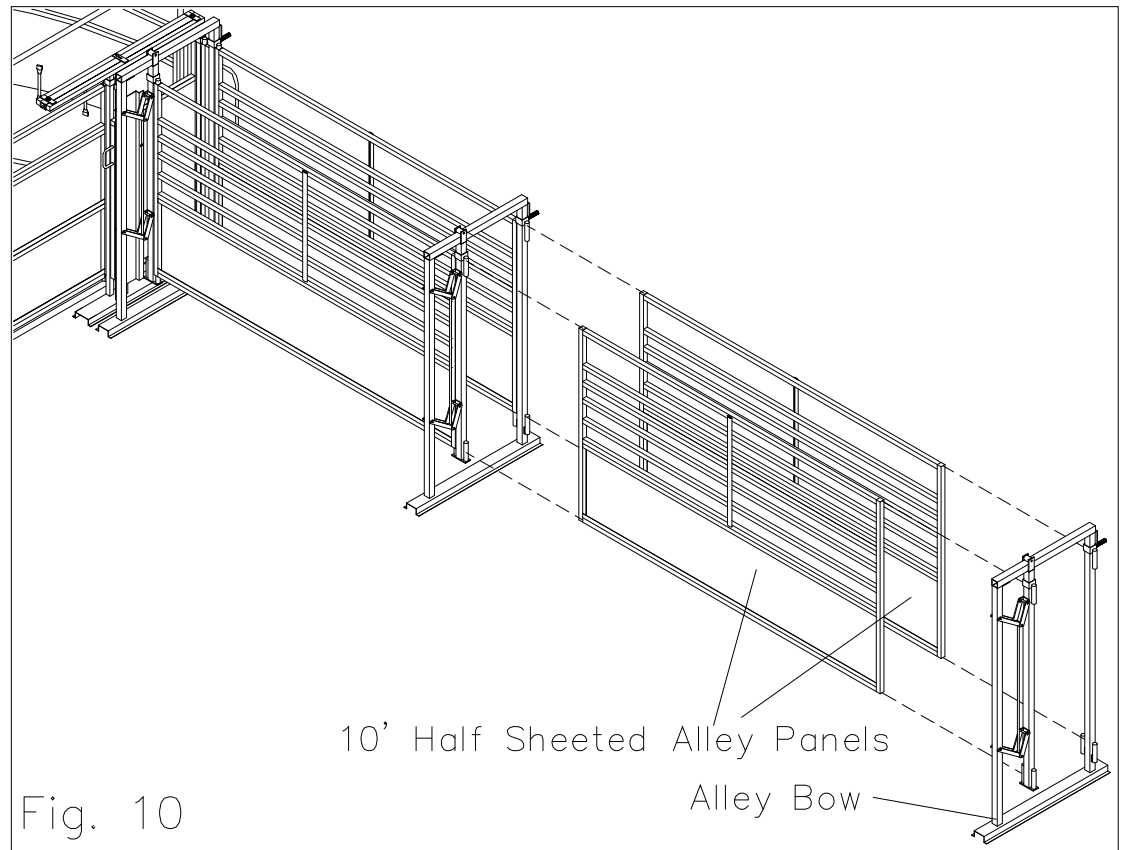
Fig. 8

STEP 9:

Lower one end of each of the 10' Half Sheeted Alley Panels over the bottom connector pins on the Alley Bow. Then move another Alley Bow to the other end of the 10' Half Sheeted Alley Panels. Lower the other end of the Alley Panels onto the bottom connector pins of the second Alley Bow. Using figure 9 for reference, drop all the top connector pins on the Alley Bows into place. The 10' Half Sheeted Alley Panels should now be secure.

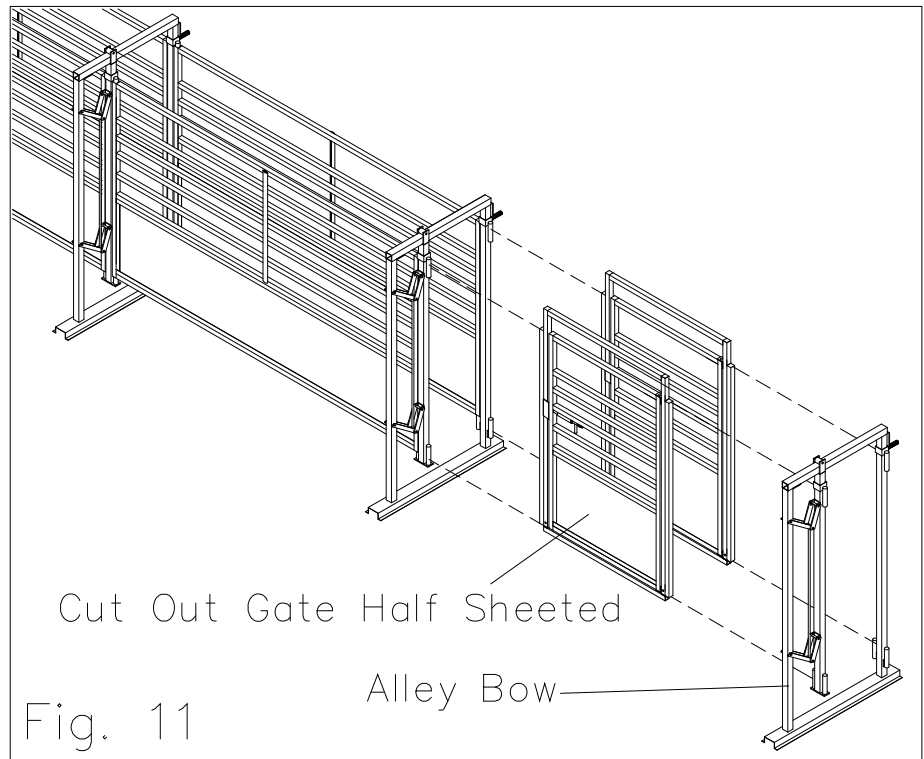
**STEP 10:**

Repeat the procedures in Step 9 to add a second set of 10' Sheeted Alley Panel to the straight alley.

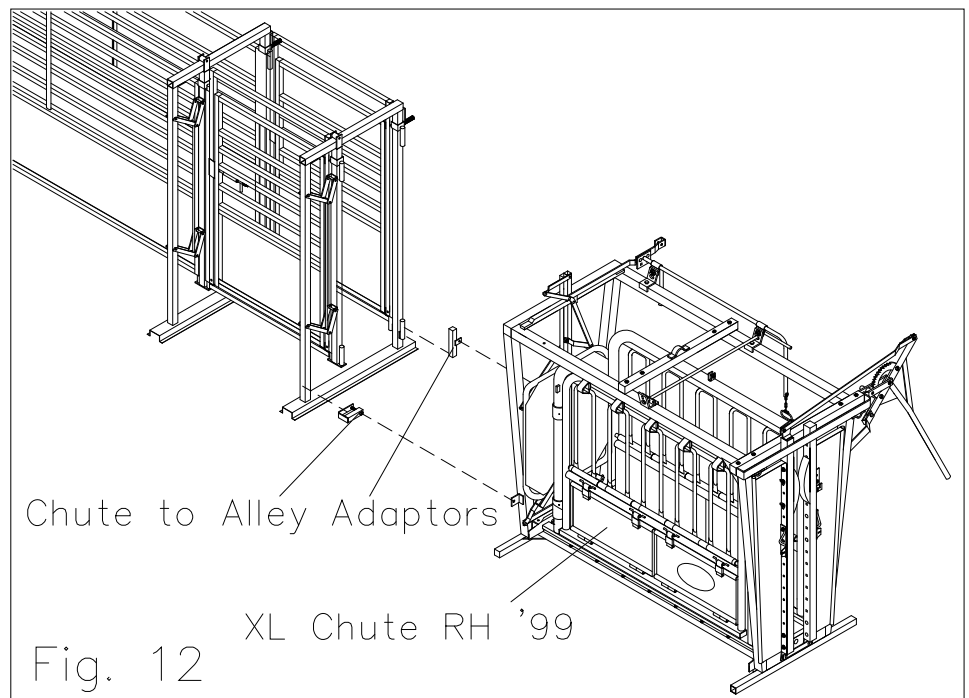


STEP 11:

To add the Cut Out Gate Half Sheeted to the alley, lower one end of each of the Cut Out Gate Panels over the bottom connector pins on the Alley Bow. Then move the next Alley Bow into place and lower the other end of the Cut Out Gate Panels over the lower connector pins. Then slide all the top connector pins on the two Alley Bows down into place as shown in figure 11.

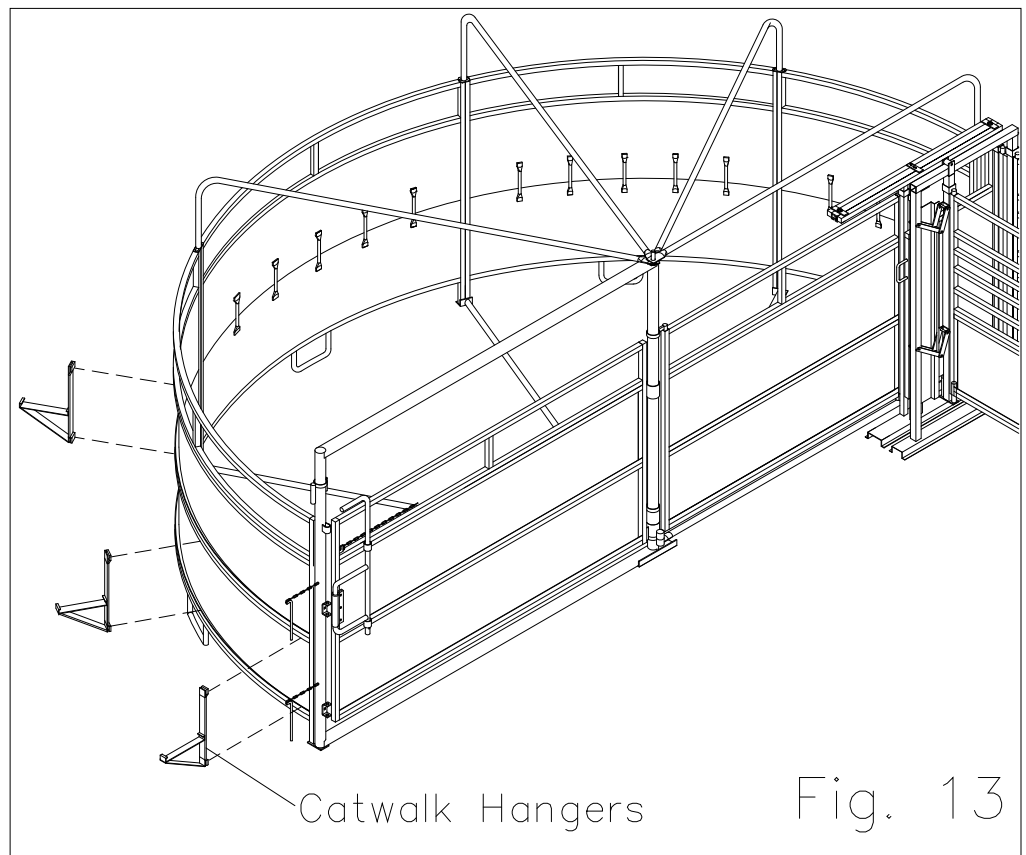
**STEP 12:**

To add the Chute to the end of the alley, first attach the Chute to Alley Adaptors to the assembly, as shown in figure 12. Then take the Adaptor piece made of square tube and slide it over the connector pin on the non-adjusting side of the Alley Bow. To attach the other adaptor piece, unscrew the bolt on the end of the piece of flat bar and slide the assembly over the adjustable side of the Alley Bow. There is a small piece of flat bar that protrudes from each side of the chute. Using the hex bolts already attached to the Chute to Alley Adaptors, bolt the chute to the adaptors.



STEP 13:

Take three catwalk hangers per 10' Curved Sweep Panel and evenly space them along the outside of the Panels. Slide the bottom of the hangers over the lip on the outside of the panel. Then slide the other end of the hangers over the upper lip as shown in figure 13. Repeat the procedure for each of the three 10' Curved Sweep Tub Panels.

**STEP 14:**

To hang the catwalk, slide one end of the Outside Catwalk into the end of the Catwalk Hangers as shown. Using a pry bar, insert the catwalk inside each of the catwalk hangers as shown in figure 14. Repeat this for each of the three catwalks until all the catwalks are secure. Using a pry bar, place the two Catwalk Joint Plates over the ends of two meeting catwalks.

