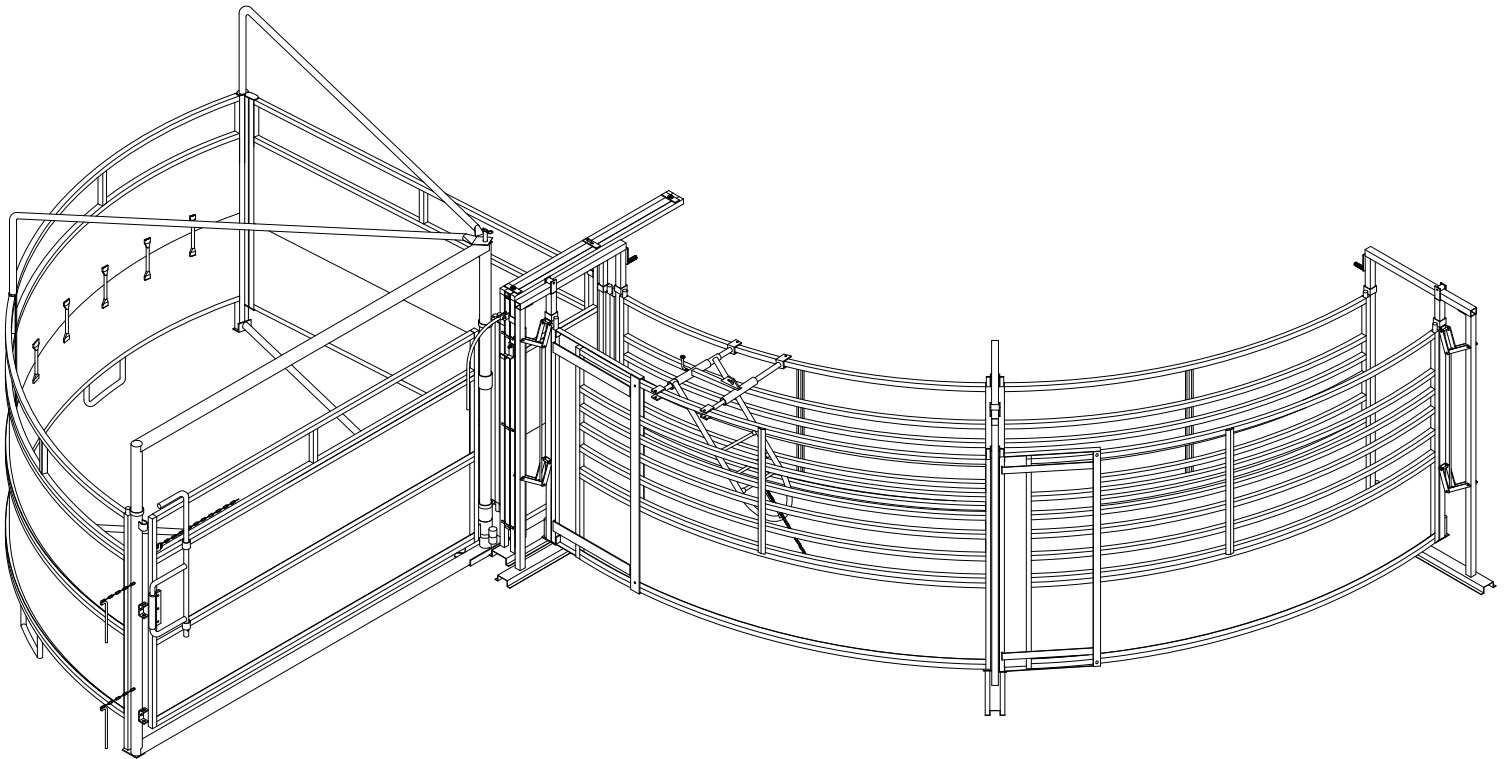


# SINGLE GATE CURVED RANCHER

ASSEMBLY INSTRUCTIONS

#007-50875



# POWDER RIVER

• LIVESTOCK HANDLING EQUIPMENT •

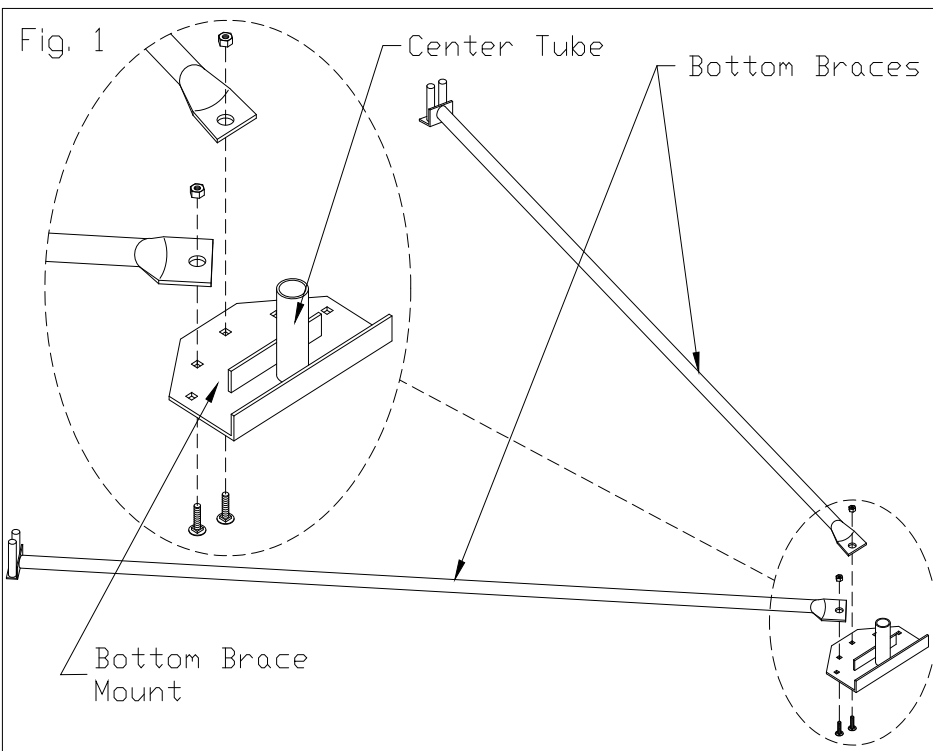
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**STEP 1:**

Secure the Bottom Braces to the Bottom Brace Mount with (2) 1/2" x 1-1/4" carriage bolts and 1/2" lock nuts as shown in figure 1.

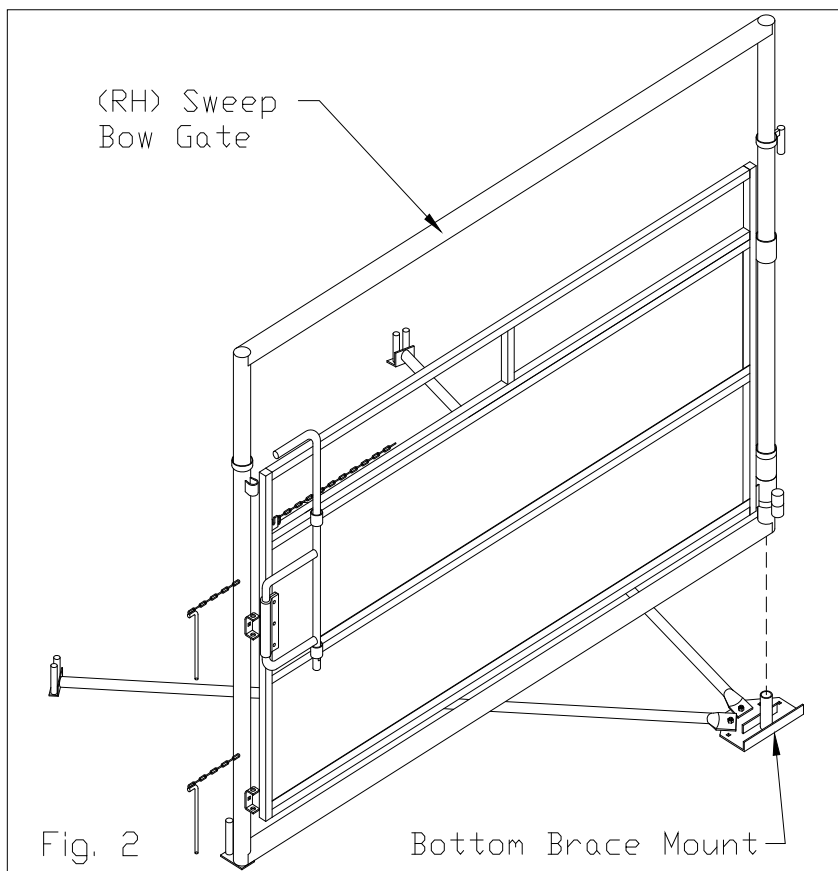
Place the center of the Bottom Brace Mount where you want the Tub to sit and alley to begin.

**CAUTION!**

***GATES AND PANELS ARE HEAVY AND WILL FALL OVER IF NOT PROPERLY SUPPORTED WHILE BEING INSTALLED. IT IS BEST TO USE A FORKLIFT OR TRACTOR TO LIFT THE HEAVY ITEMS!***

**STEP 2:**

Slide the (*right-hand*) Sweep Bow Gate onto the center tube on the Bottom Brace Mount as shown in figure 2.



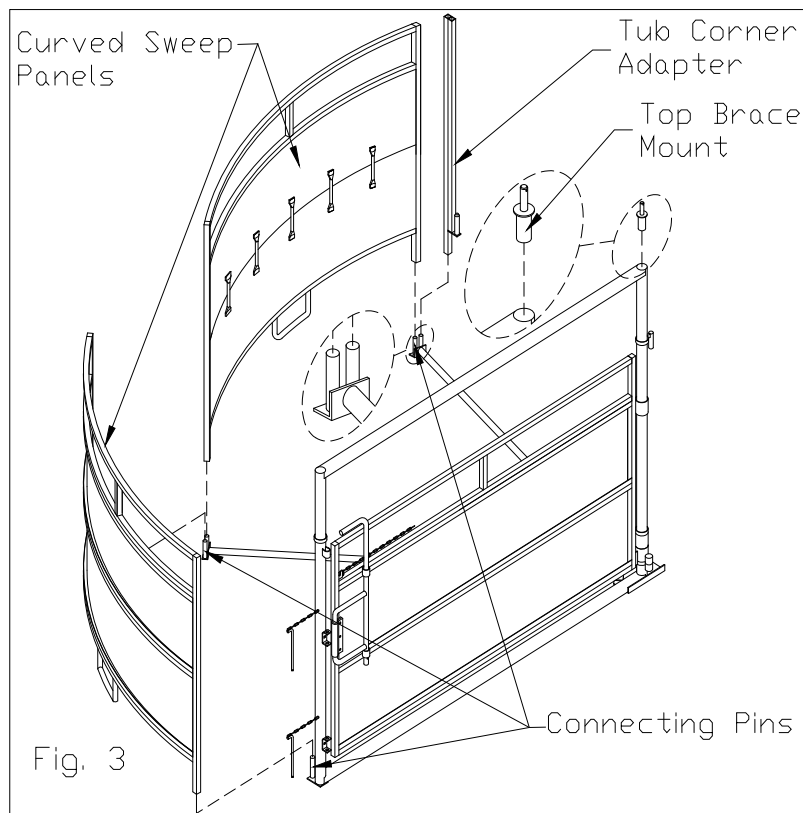
**POWDER RIVER**  
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**STEP 3:**

Slide the Curved Sweep Panels onto the connecting pins on both the Bottom Brace and the Sweep Bow Gate as shown in figure 3.

Place the Tub Corner Adapter on the Bottom Brace connector pin as shown.

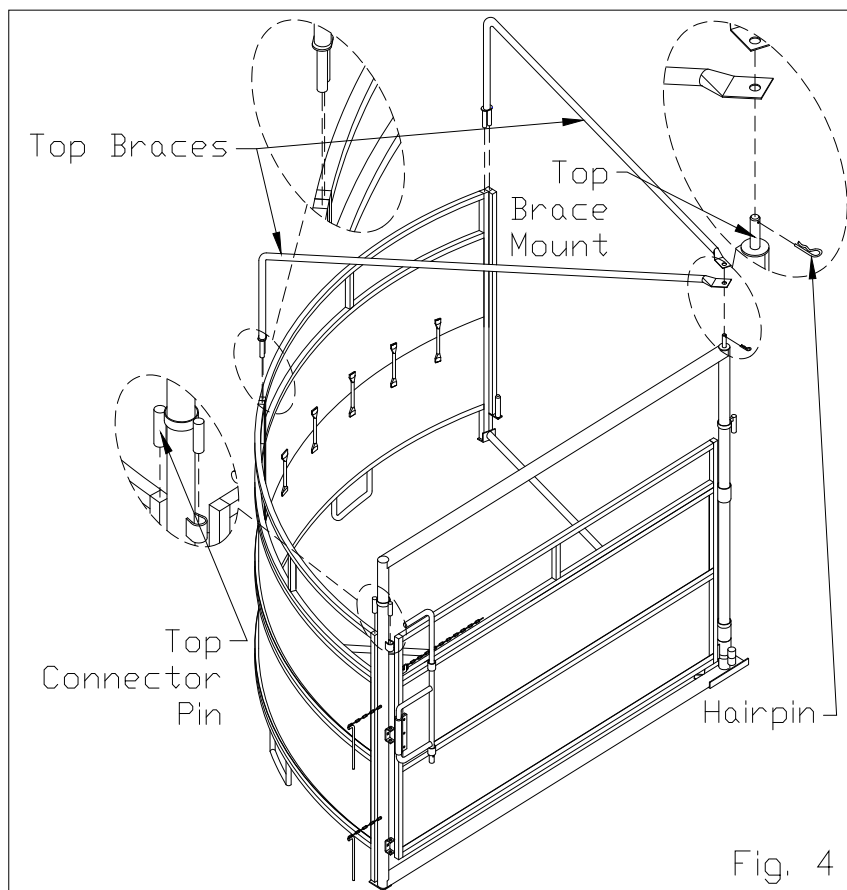
Place the Top Brace Mount into the end tube of the Sweep Bow Gate as shown in figure 3.

**STEP 4:**

Secure the Sweep Bow Gate to the Curved Sweep Panel by sliding the top connector pin into the end tube on the curved panel as shown in figure 4.

Place the Top Braces onto the Top Brace Mount and into the end tubes of the Curved Sweep Panels and Tub Corner Adapter as shown.

Secure the Top Braces to the Bow Gate by inserting the hairpin through the Top Brace Mount as shown in figure 4.



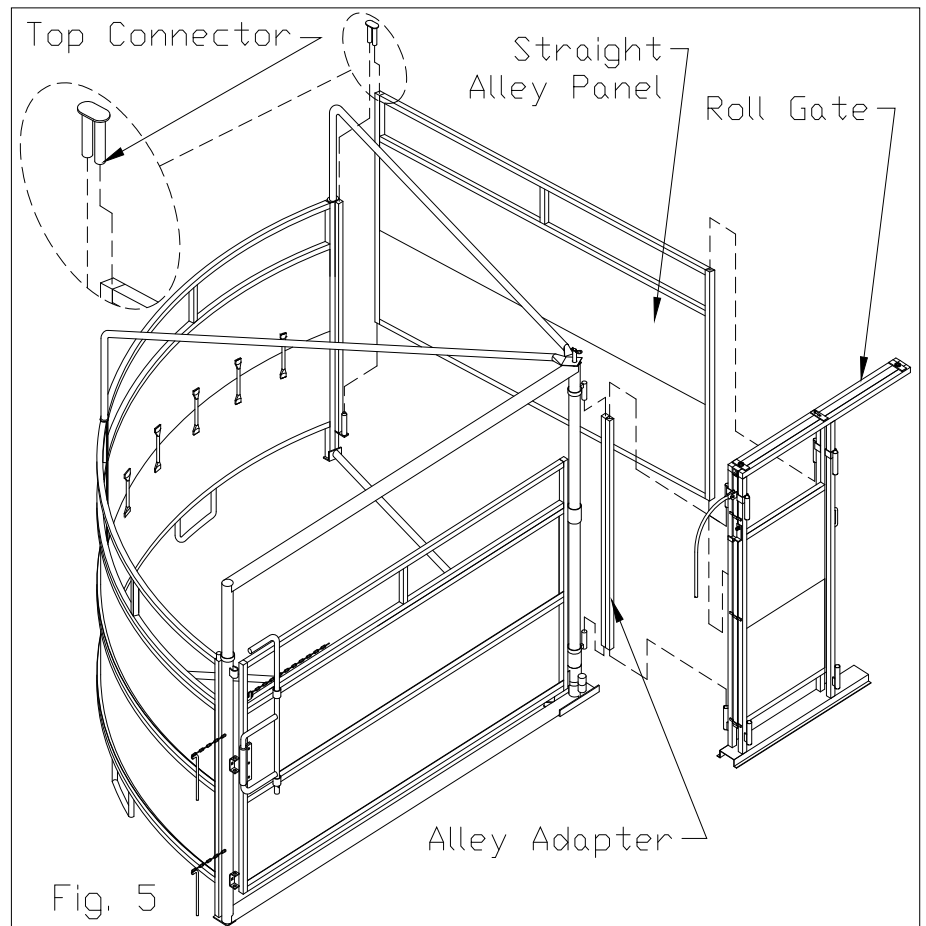
**STEP 5:**

Slide the Straight Alley Panel onto the bottom connector pins on the Tub Corner Adapter and Roll Gate as shown. Secure the Straight Alley Panel in place by placing the Top Connector into the end tubs on the Alley Panel and Corner Adapters and by sliding the top pin connector on the Roll gate into the end tube on the opposite end of the panel as shown in figure 5.

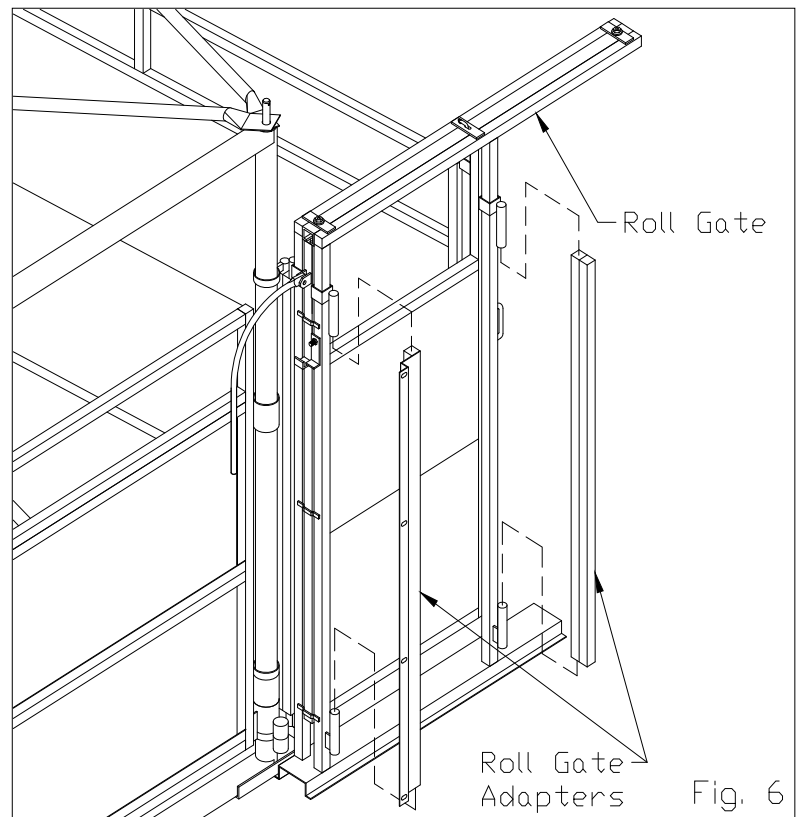
The flange on one side of the Roll Gate base plate will need to slide under the Bottom Brace Mount in order to install the Alley Adapter.

*(For a picture of the Bottom Brace Mount refer to figures 1 & 2)*

Place the Alley Adapter onto the Bottom Connector Pin on the Bow Gate and Roll Gate. Slide the Top Connector Pins down to secure it to the both Gates as shown.

**STEP 6:**

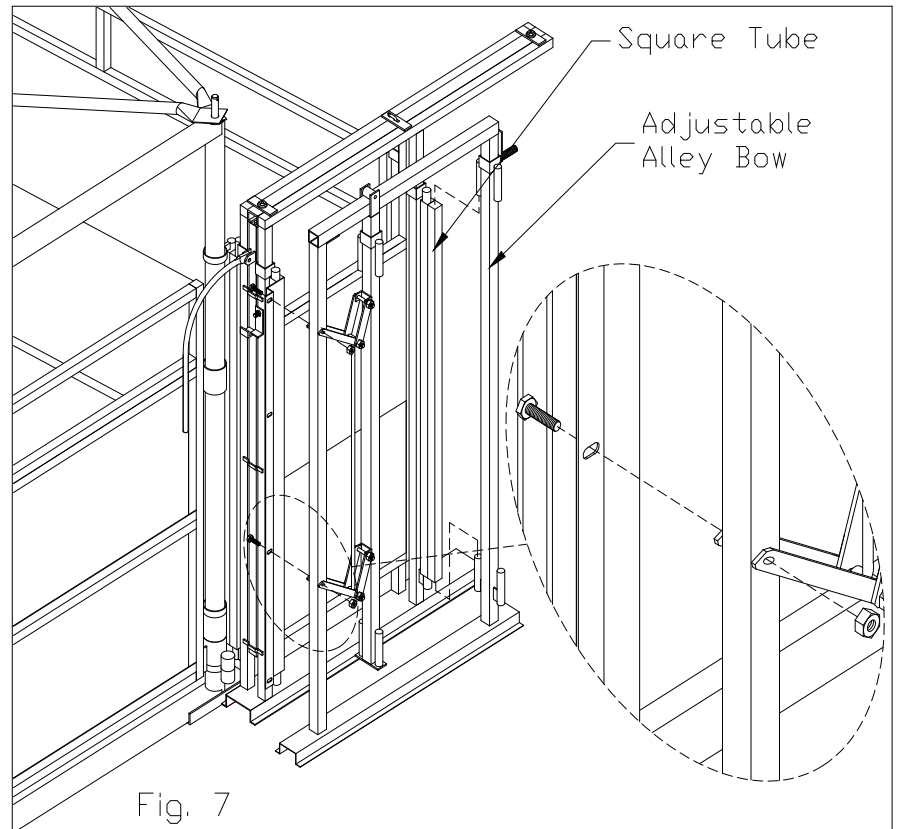
Place the Roll Gate Adapters onto the bottom connector pins on the Roll Gate. Secure the Roll Gate Adapter to the Roll Gate by sliding the top connector pins into the tops of the adapter as shown in figure 6.



**STEP 7:**

Using figure 7 as a reference. Remove the two outside bolts on the Adjustable Alley Bow. Slide the Adjustable Alley Bow up to the Roll Gate Adapters and slide the square tube onto the bottom connector pin on the Adjustable Alley Bow. Slide the top connector pin into the top of square tube as shown.

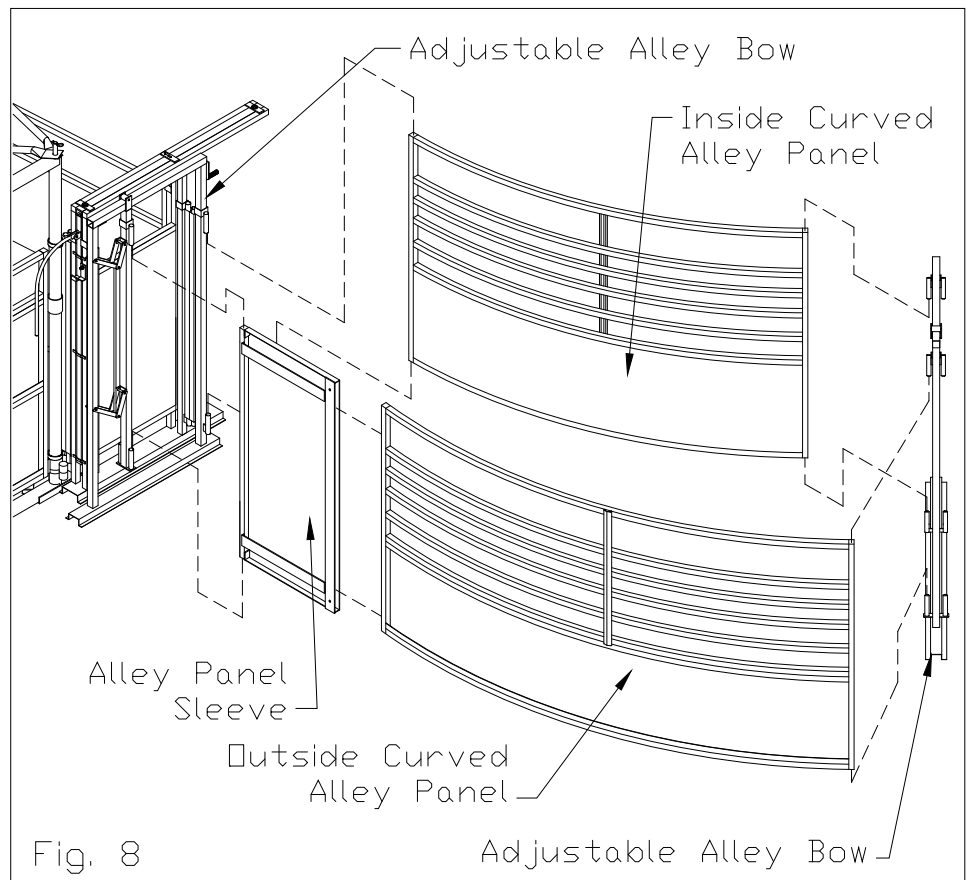
Secure the other side of the Alley Bow and Roll Gate Adapter together, by placing the two bolts that were removed from that Alley Bow through two slotted holes on the adapter and through the holes on the Alley bow. Tight them together with the two lock nuts that were previously removed as shown in figure 7.

**STEP 8:**

Connect the Alley Panel Sleeve to the Adjustable side of the Adjustable Alley Bow by Sliding the end tube on the Alley Panel Sleeve onto the bottom connector pin and sliding the top connector pin into the top of the end tube as shown. (*The Sheeted Side of the Alley Panel Sleeve faces inside the alley.*)

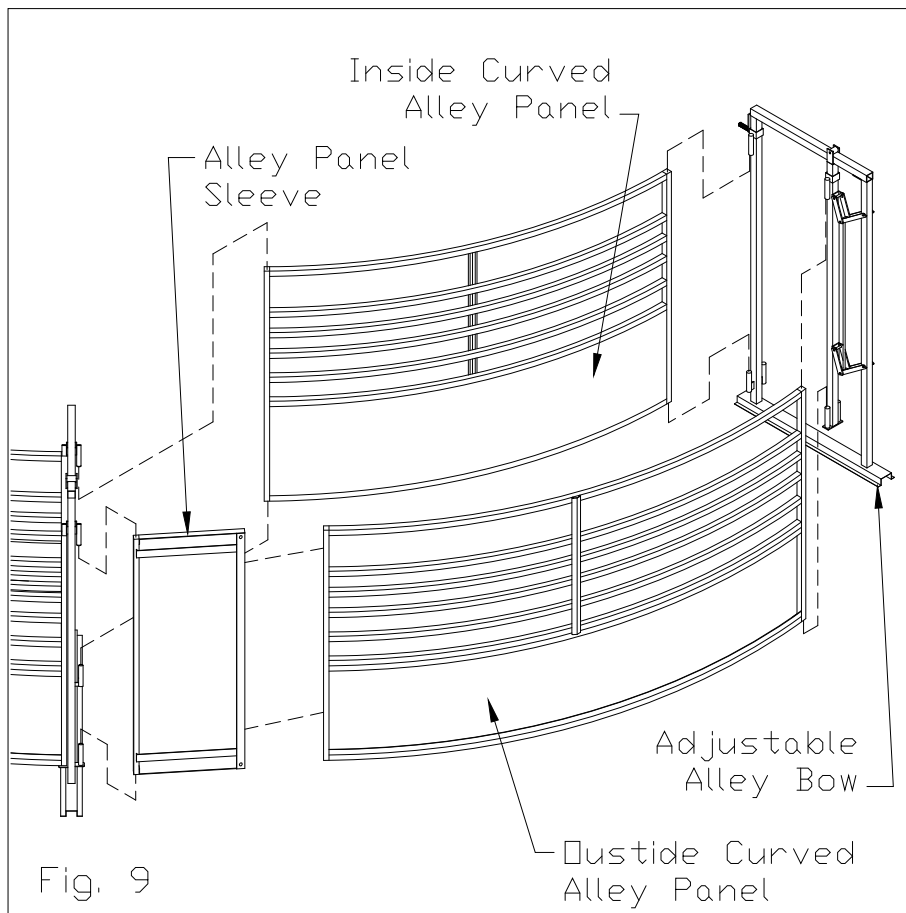
Connect the Inside Curved Alley Panel to both Adjustable Alley Bows as shown in figure 8.

Slide one end of the Outside Curved Alley Panel into the open end of the Alley Panel Sleeve and connect the other end of the Curved Alley Panel to the Alley Bow as shown in figure 8.



**STEP 9:**

Using figure 9 as a reference, secure the remaining Alley Panel Sleeve, Curved Alley Panels, and Adjustable Alley Bows together in the same manner as before in step 8.

**STEP 10:**

Bolt the Alley No-Back onto the top rail of the Curved Alley Panels, at the desired location.

*NOTE: 10' alley add sections are available in curved or straight panels, and also half sheeted or full Sheeted panels.*

