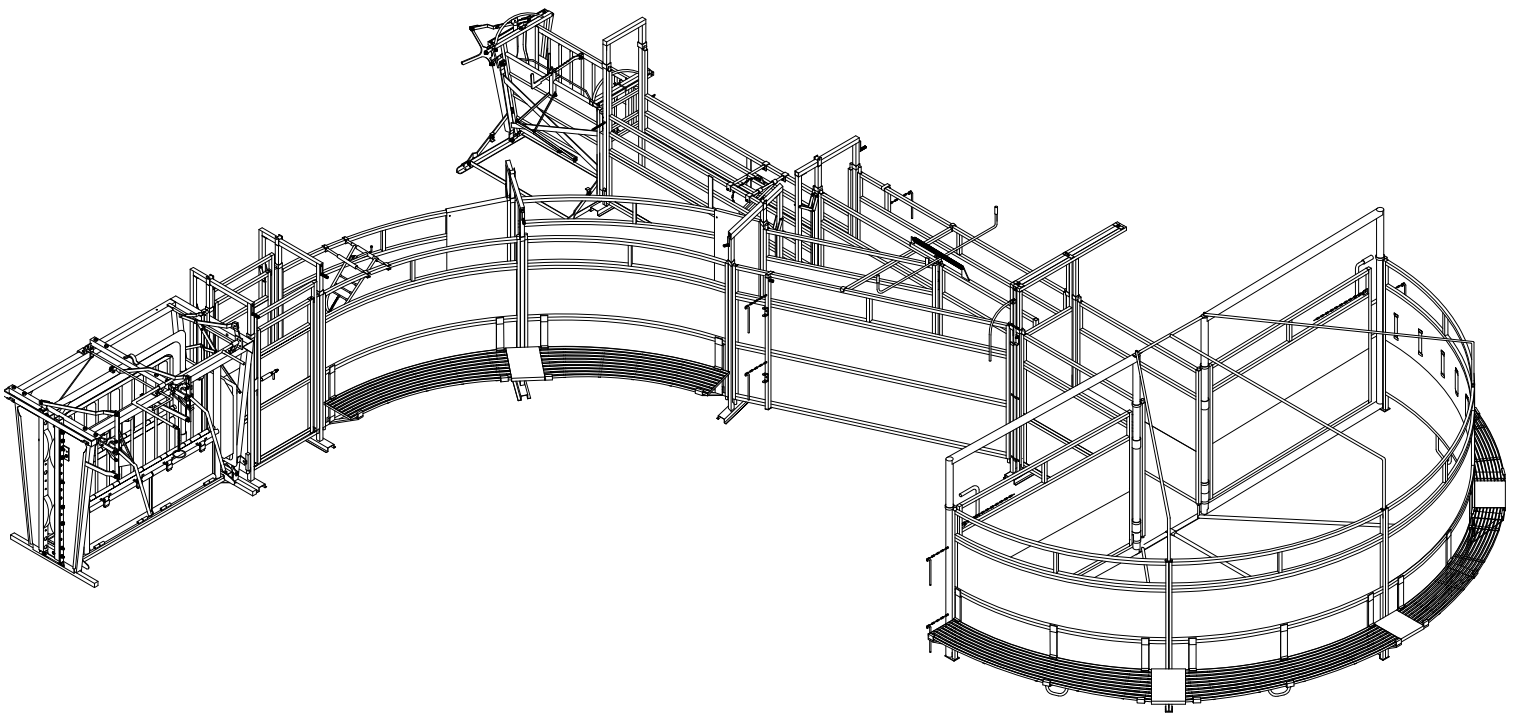


# SYSTEM 2000 DELUXE

ASSEMBLY INSTRUCTIONS

#007-50009



# POWDER RIVER

• LIVESTOCK HANDLING EQUIPMENT •

[www.powderriver.com](http://www.powderriver.com)

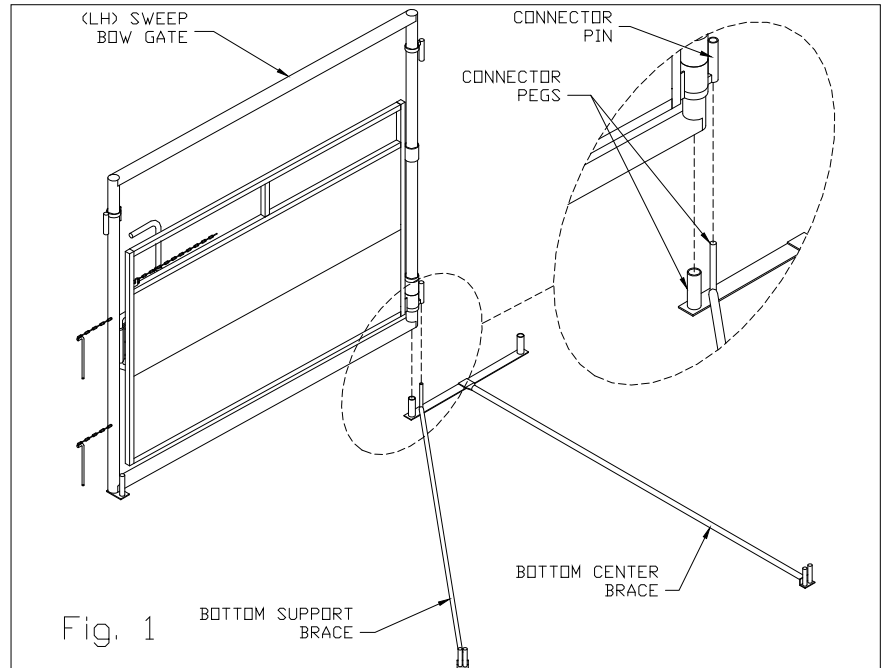
1-800-453-5318

**CAUTION!**

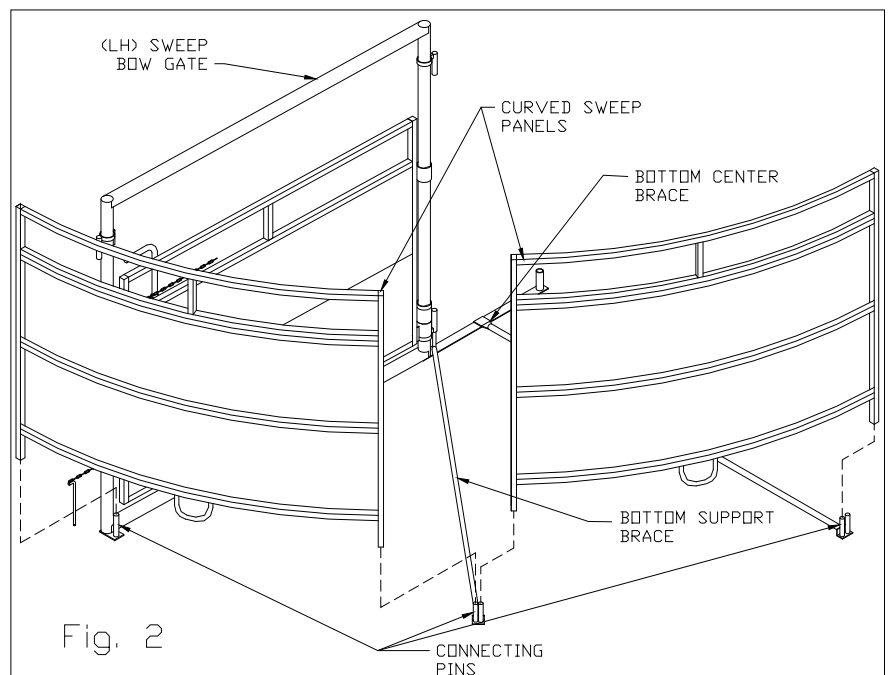
**GATES AND PANELS ARE HEAVY AND WILL FALL OVER IF NOT PROPERLY SUPPORTED WHILE BEING INSTALLED. IT IS BEST TO USE A FORKLIFT OR TRACTOR TO LIFT THE HEAVY ITEMS!**

**STEP 1:**

Place the "T" end of the Bottom Center Brace where the alley will begin. Lower the (left-hand) Sweep Bow Gate over the connector peg on the Bottom Center Brace. Once the gate has started to slide over the connector peg position the Bottom Support Brace connector peg to slide into the connecting pin on the gate and continue lowering the gate until it rests on the ground as shown in figure 1.

**STEP 2:**

Slide two Curved Sweep Panels onto the connecting pins on the Sweep Bow Gate, Bottom Support Brace, and Bottom Center Brace as shown in figure 2.



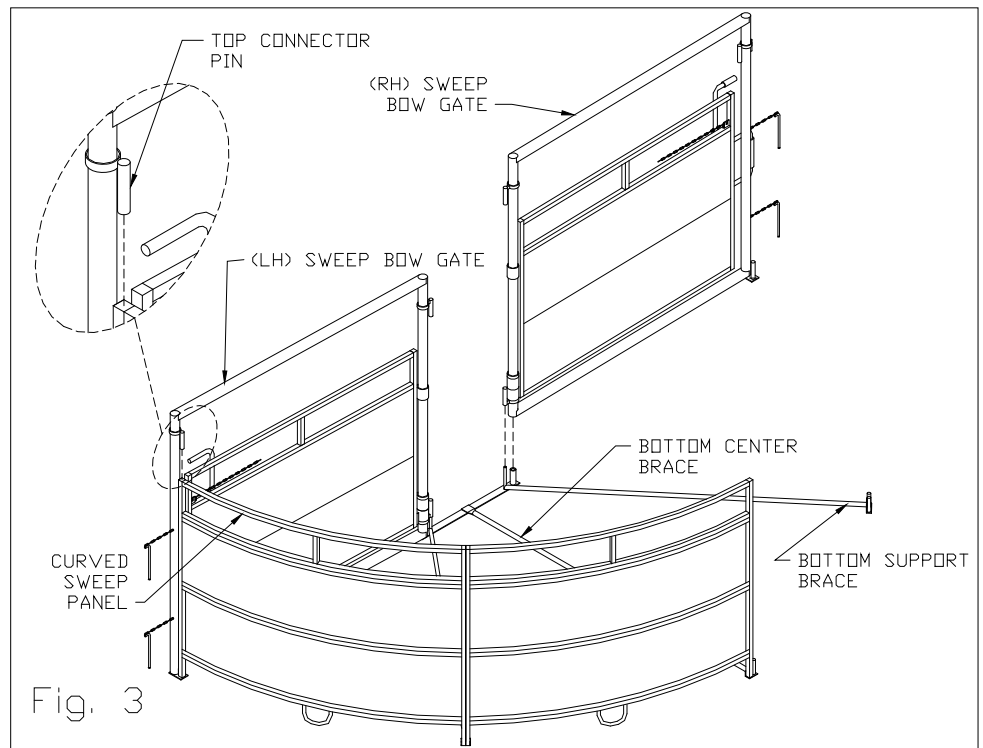
**POWDER RIVER**  
 • LIVESTOCK HANDLING EQUIPMENT •

**STEP 3:**

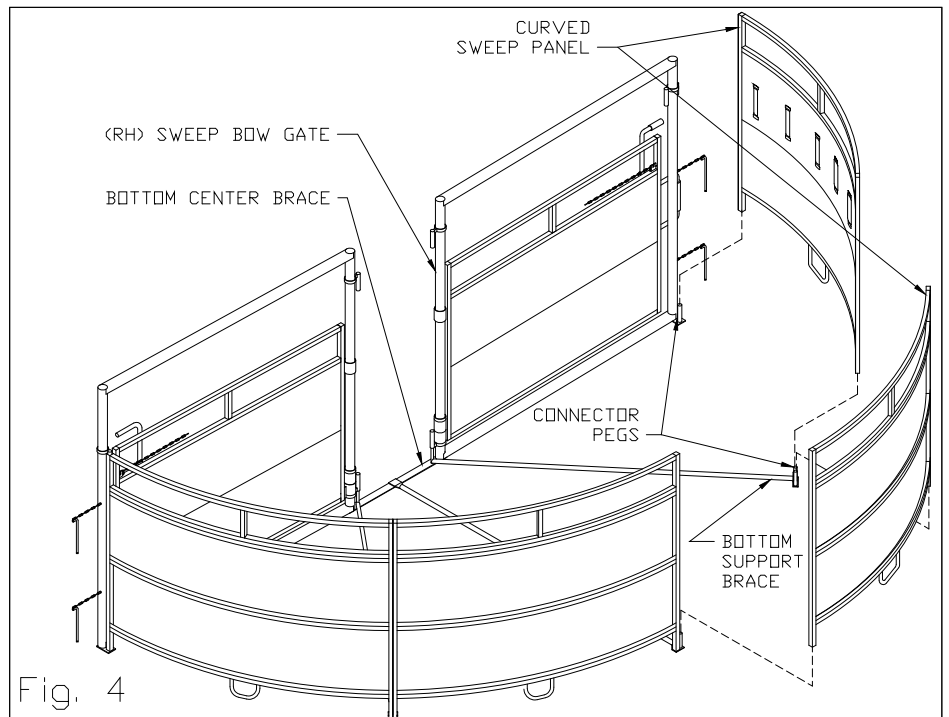
Secure the (*left-hand*) Sweep Bow Gate to the Curved Sweep Panel by sliding the top connector pin into the end tube of the curved panel as shown.

The (*right-hand*) Sweep Bow Gate is installed in the same manner as the (*left-hand*) Sweep Bow Gate was in step 1.

Lower the (*right-hand*) Sweep Bow Gate onto the connector pegs on the Bottom Center Brace and Bottom Support Brace as shown in figure 3.

**STEP 4:**

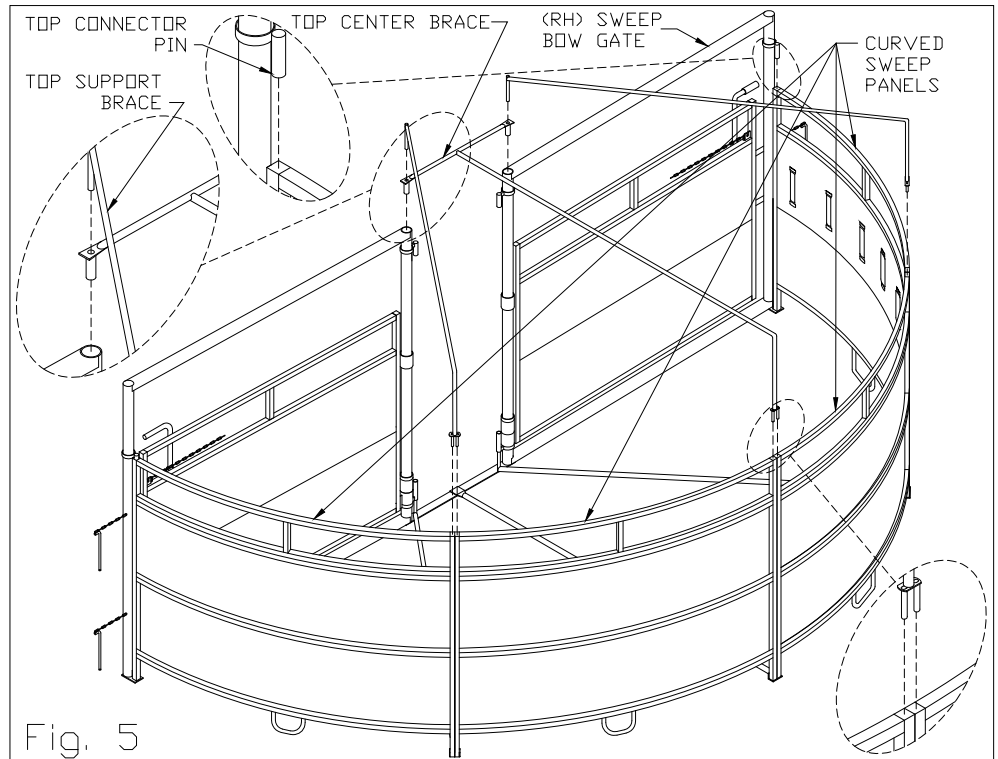
Place the remaining two Curved Sweep Panels onto the connector pins on the (*right-hand*) Sweep Bow Gate, Bottom Support Brace, and Bottom Center Brace as shown in figure 4.



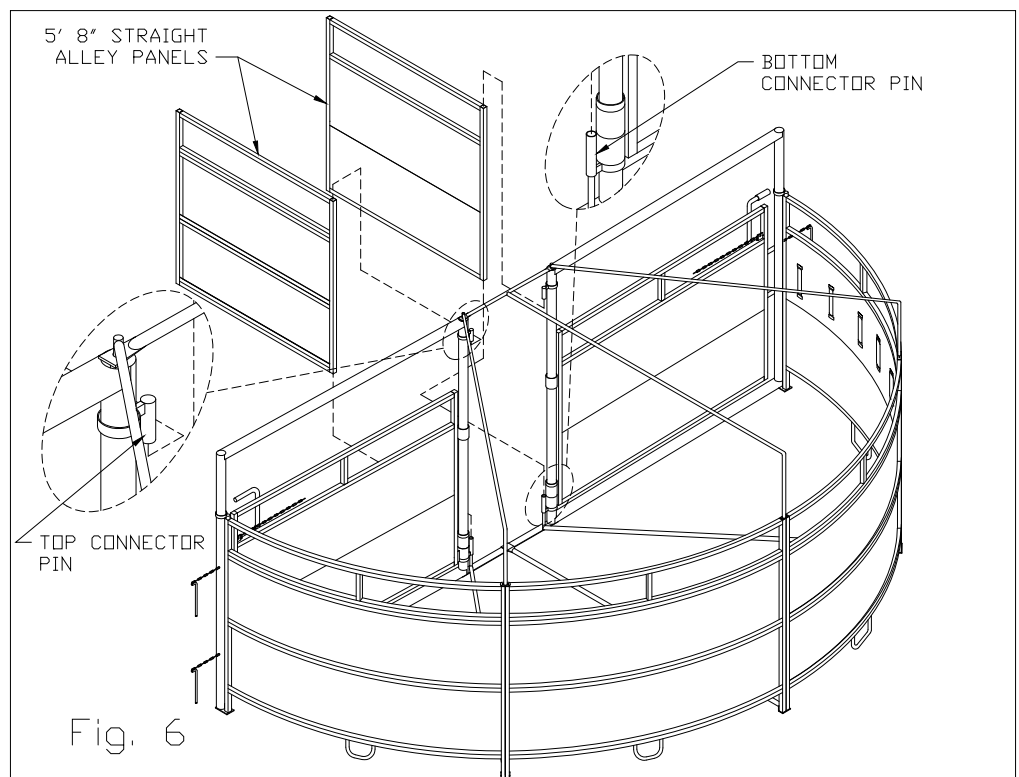
**STEP 5:**

Secure the (*right-hand*) Sweep Bow Gate to the Curved Sweep Panel by sliding the top connector pin into the end tube of the curved panel as shown.

Secure the Sweep Bow Gates and Curved Sweep Panels together by sliding the Top Center Brace and Top Support Braces into the end tubes of the Curved Sweep Panels and Bow Gates as shown in figure 5.

**STEP 6:**

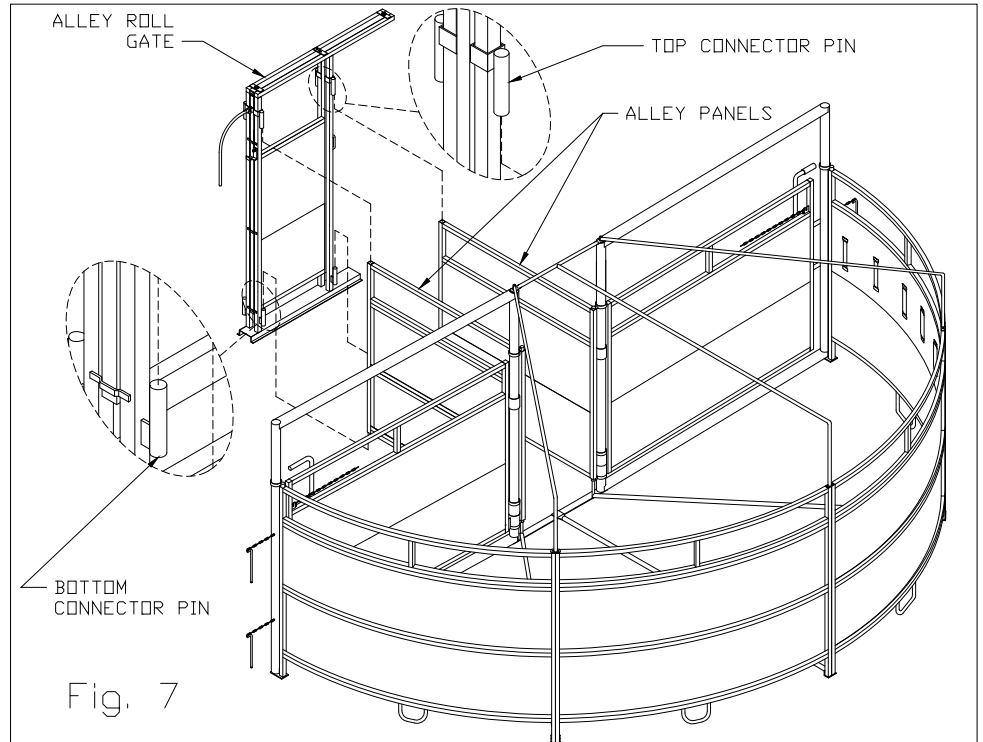
Place the two 5' 8" Straight Alley Panel onto the bottom connector pins on the Sweep Bow Gates. Secure the panels to the gate by sliding the top connector pins into the tops of the end tubes on the panels as shown in figure 6.



**STEP 7:**

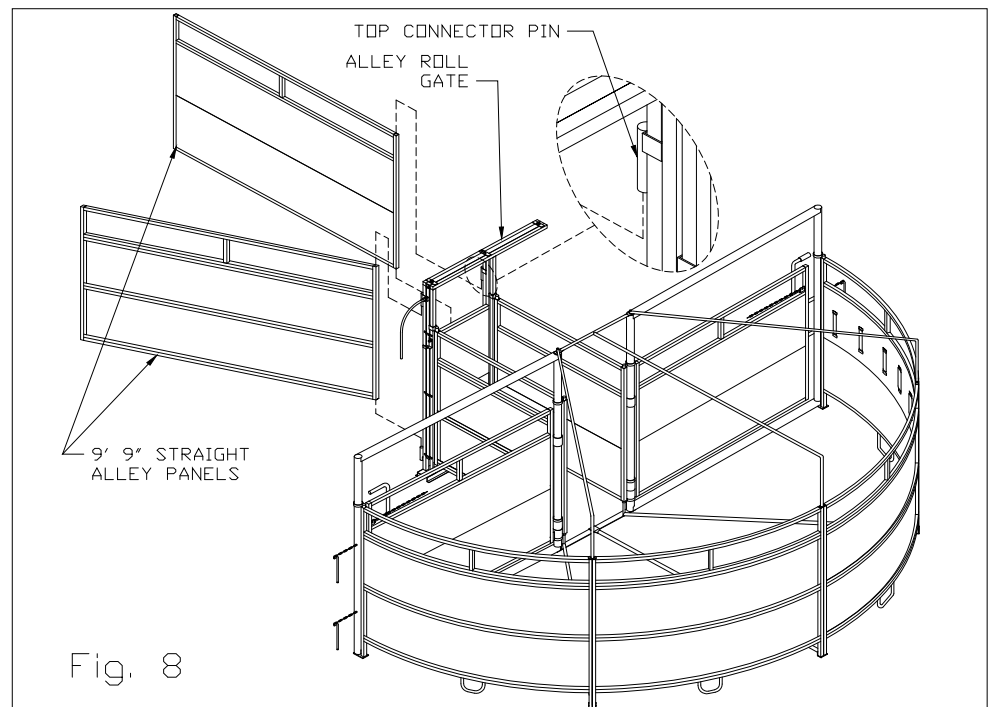
Place the bottom connecting pins on the Alley Roll Gate into the bottoms of the end tubes on the Alley Panels as shown.

Slide the top connecting pins into the tops of the end tubes on the panels as shown in figure 7.

**STEP 8:**

Connect the two 9' 9" Straight Alley Panels to the Alley Roll Gate in the same manner as steps 6 and 7.

Place the panels onto the bottom connector pins on the Alley Roll Gate. Slide the top connector pins into the tops of the panels as shown in figure 8.



**STEP 9:**

Connect both 9' 9" Alley Panels to the outside connecting pins on the two different Adjustable Alley Bows as shown.

Secure the two alley bows together with the Diversion Connector Tub as shown in figures 9 and 10.

**NOTE:** Measure the distance from the Adjustable Alley Bows to the far side of each Sweep Bow Gate to ensure that the alley bows are centered properly.

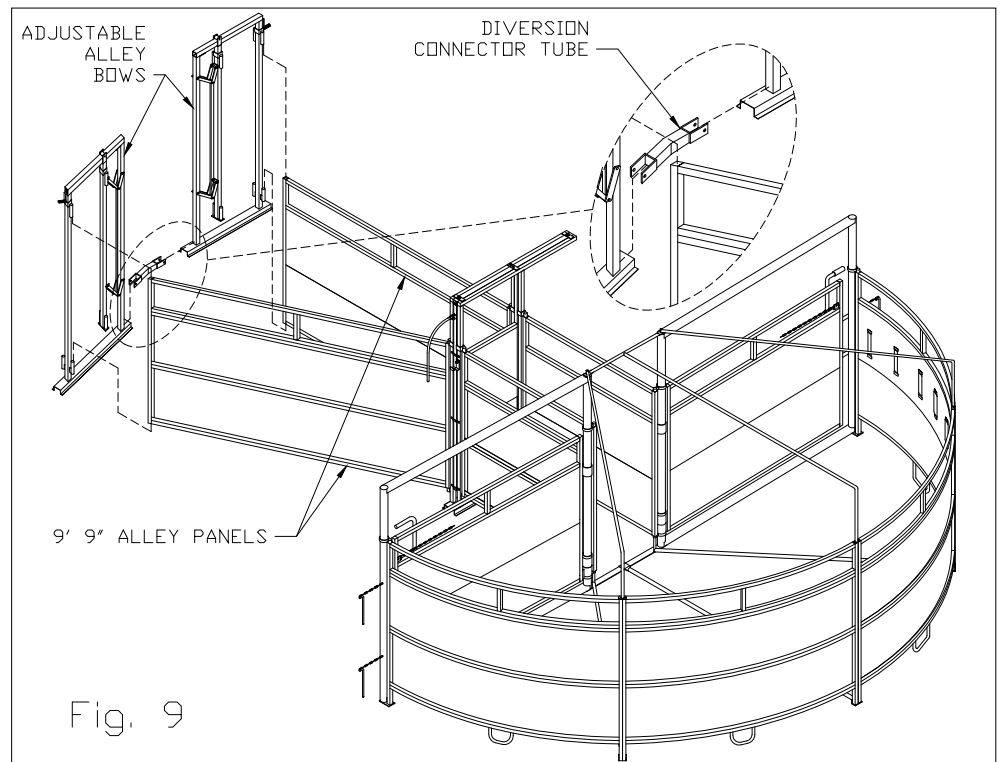


Fig. 9

**STEP 10:**

Connect the (right-hand and left-hand) Diversion Panels to the inside connector pins on the Adjustable Alley Bows. Bring the other ends together as shown in figure 10.

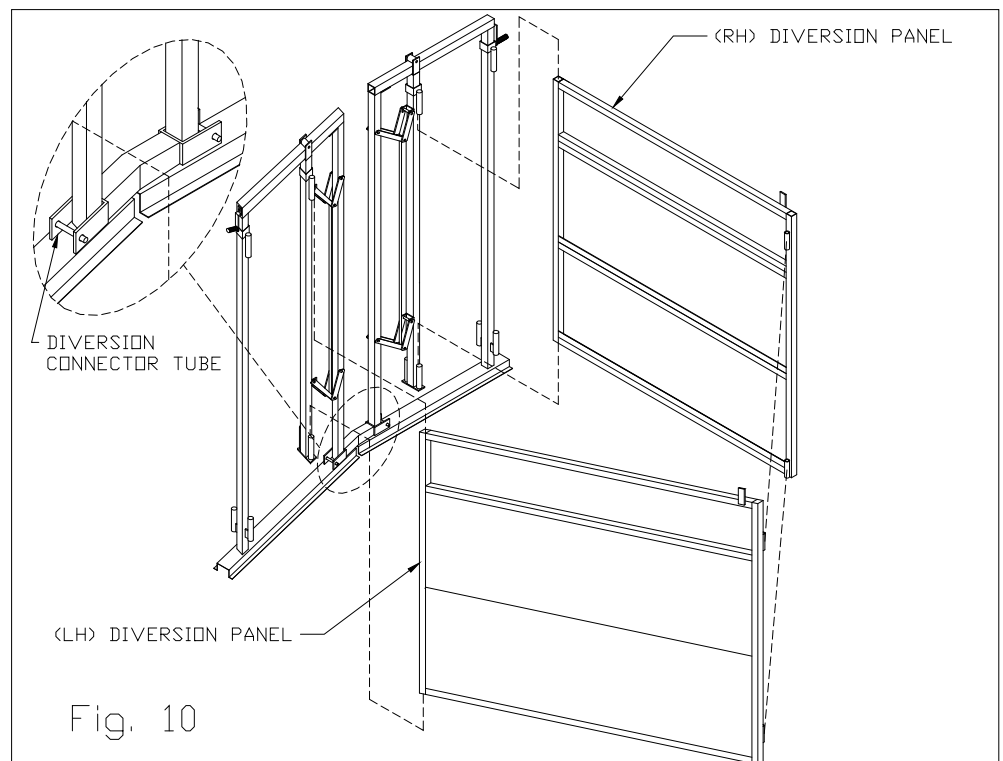
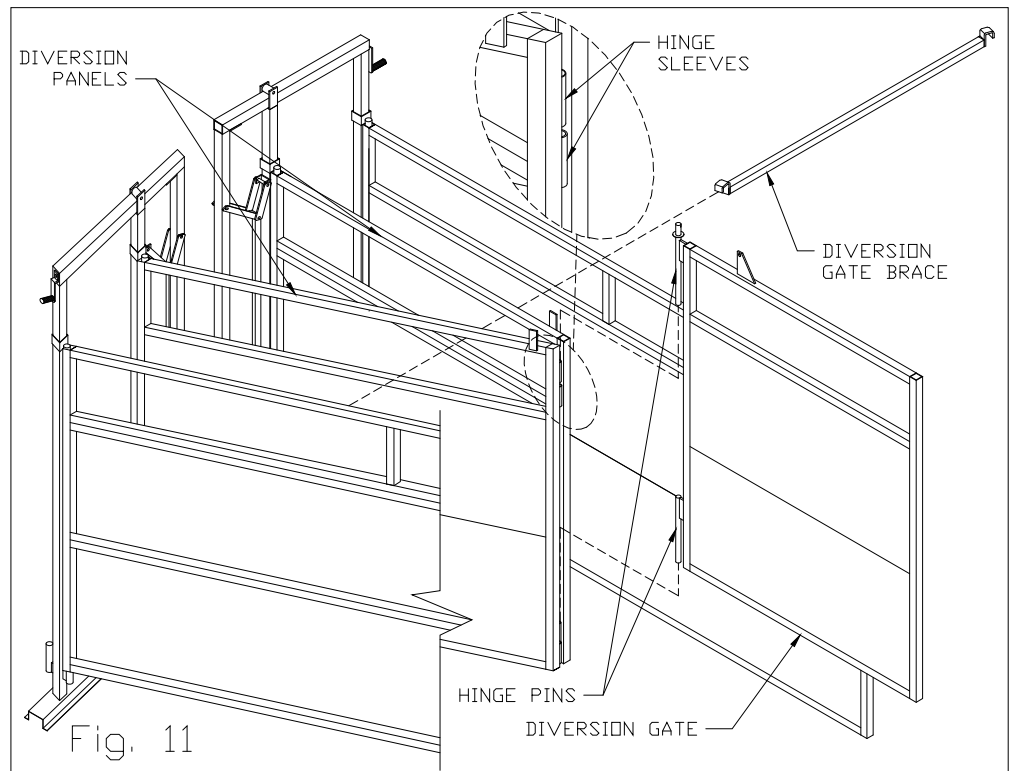


Fig. 10

**STEP 11:**

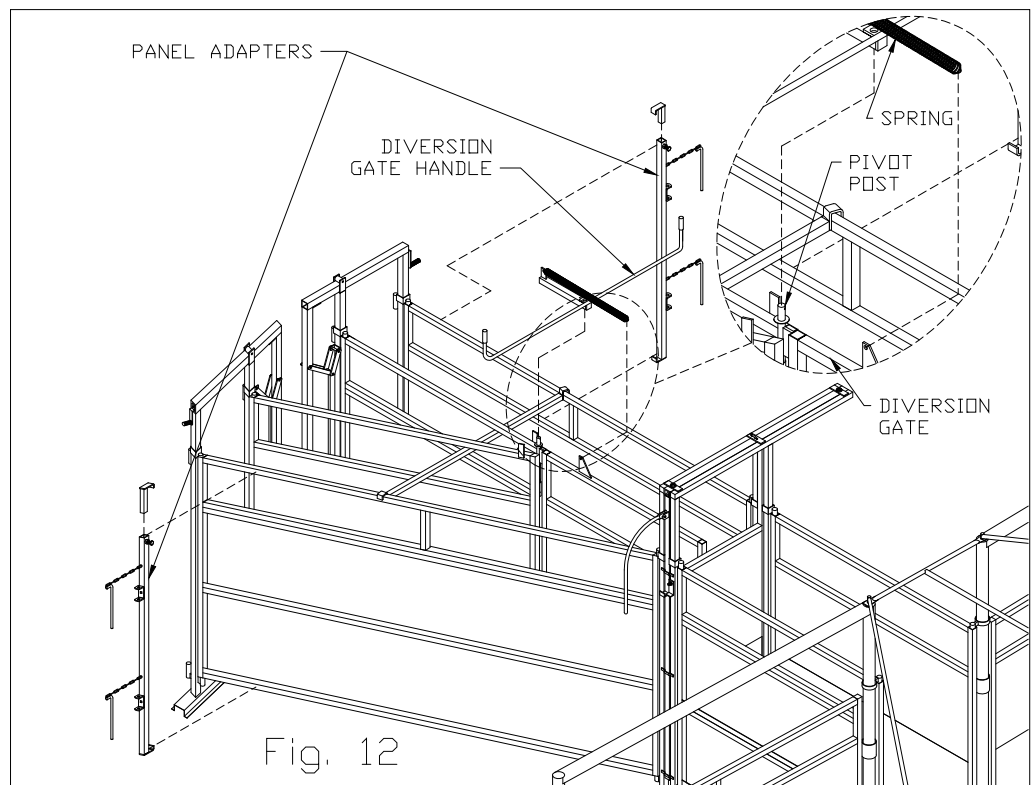
Slide the Diversion Gate Brace over the top rails on the outside panels and under the top rails on the middle two Diversion Panels. The ends of the Diversion Gate Brace should lock onto the top rails on the outside panels as shown in figures 11, 12 and 13.

Place the hinge pins on the Diversion Gate through the hinge sleeves on both Diversion Panels as shown in figure 11.

**STEP 12:**

Hook the spring onto the Diversion Gate and use the Diversion Gate Handle to stretch the spring out until the handle can slide over the pivot post and insert a cotter pin into the hole on the pivot post to hold the handle in place.

The Panel Adapters hook onto the outside alley panels as shown in figure 12.



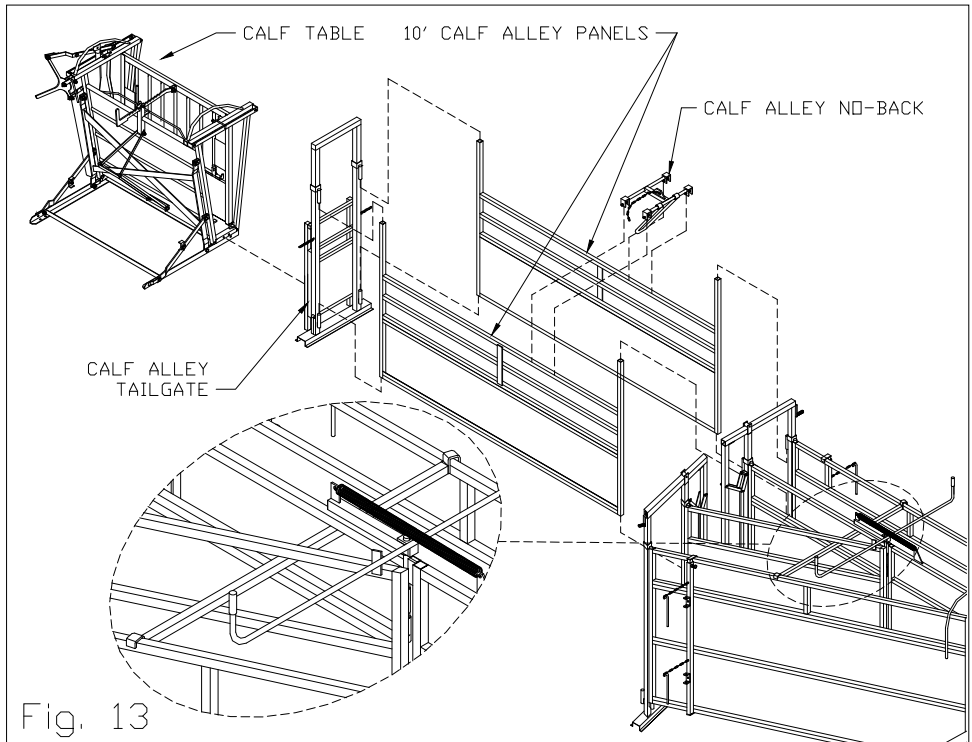
**STEP 13:**

Using figure 13 as a reference, connect the 10' Calf Alley Panels to the Adjustable Alley Bow and Calf Tailgate in the same manner as the previous panels.

Bolt the Calf Alley No-Back on to the top rail of the Calf Alley panels about 7 or 8 feet from the Calf Tailgate.

The Calf Table sits next to the Calf Alley Tailgate.

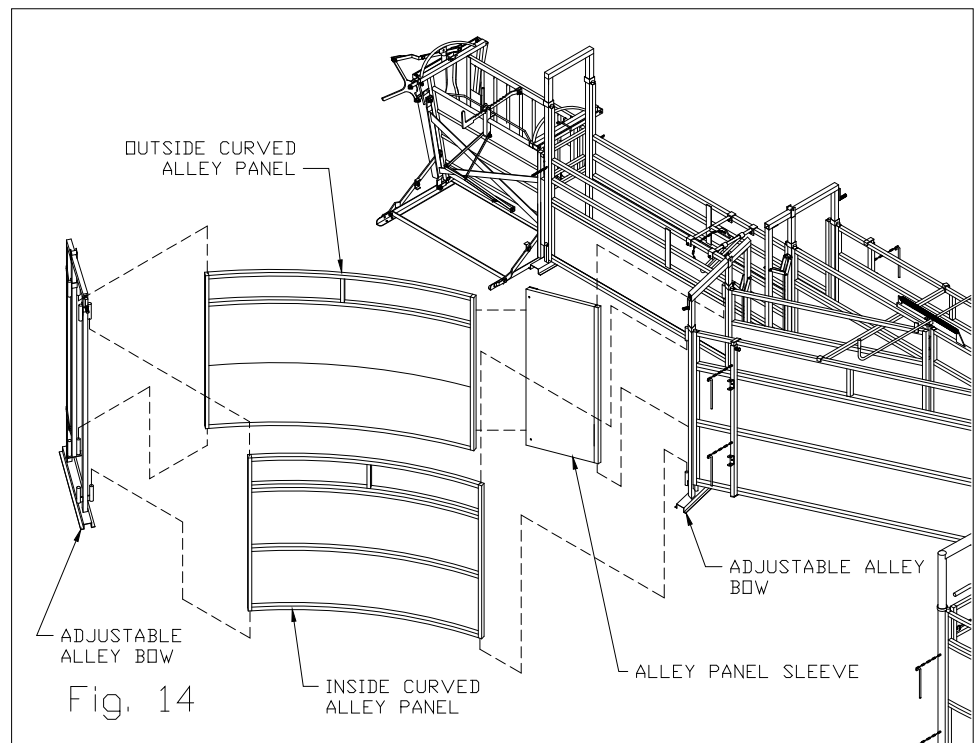
**NOTE:** *The Calf Table is reversible for left or right side branding. (Picture shows right side branding.)*

**STEP 14:**

Connect the Alley Panel Sleeve to the adjustable side of the Adjustable Alley Bow by sliding the end tube of the Alley Panel Sleeve onto the bottom connector pin and sliding the top connector pin into the top of the end tube. *(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.

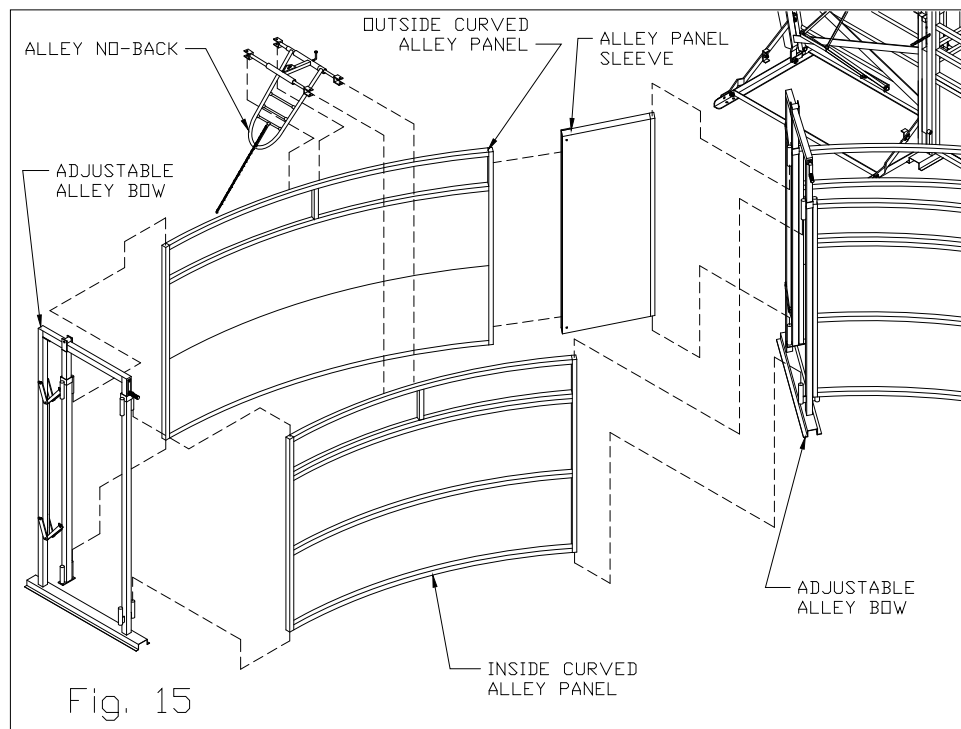
Slide one end of the Outside Curved Alley Panel into the open end of the Alley Panel Sleeve and connect the other end of the Curved Alley Panel to the Alley Bow as shown in figure 14.



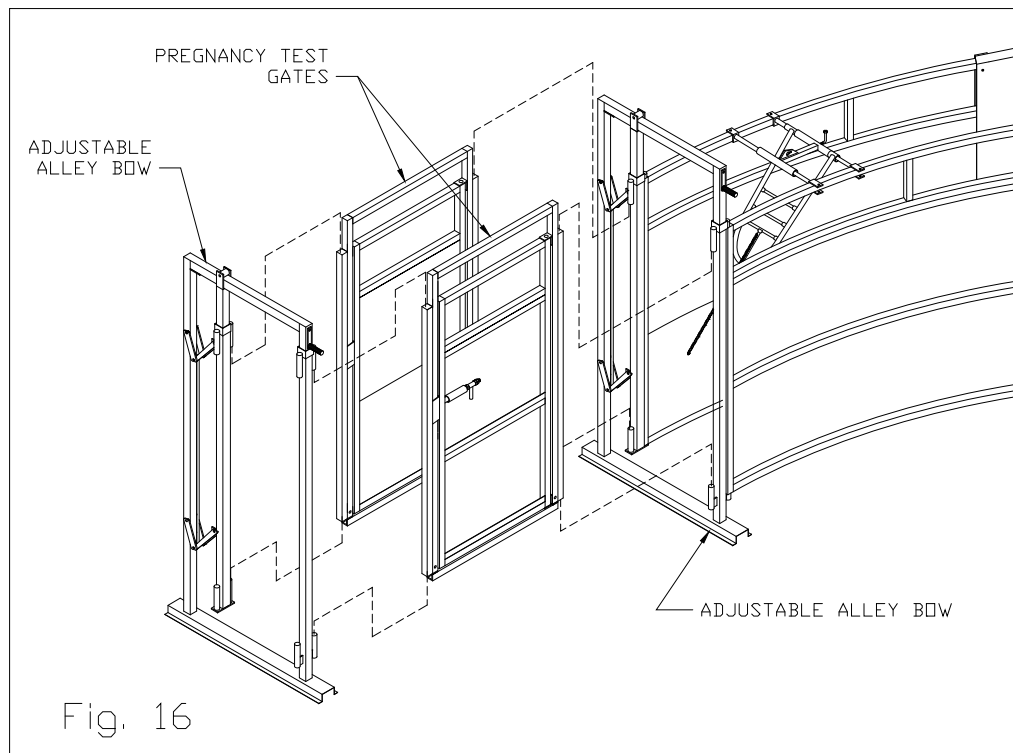
**STEP 15:**

Using figure 15 as a reference connect the Alley Panel Sleeve, Curved Alley Panels and Adjustable Alley Bows together in the same manner as before in step 14.

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

**STEP 16:**

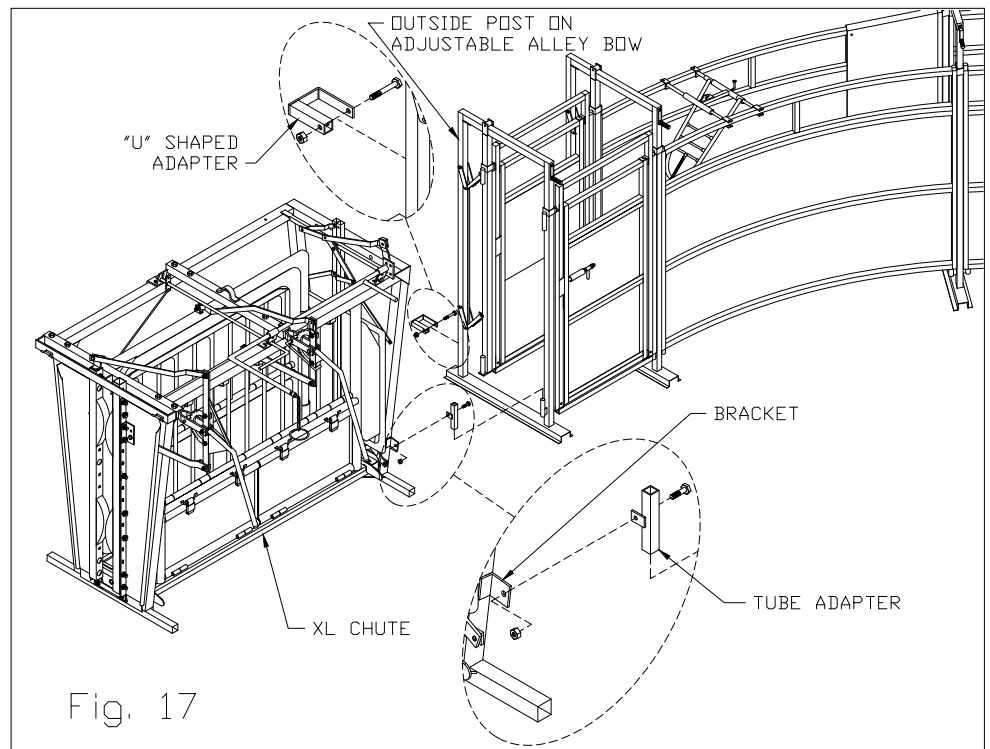
Connect the Pregnancy Test Gate Set and Adjustable Alley Bows together as shown in figure 16.



**STEP 17:**

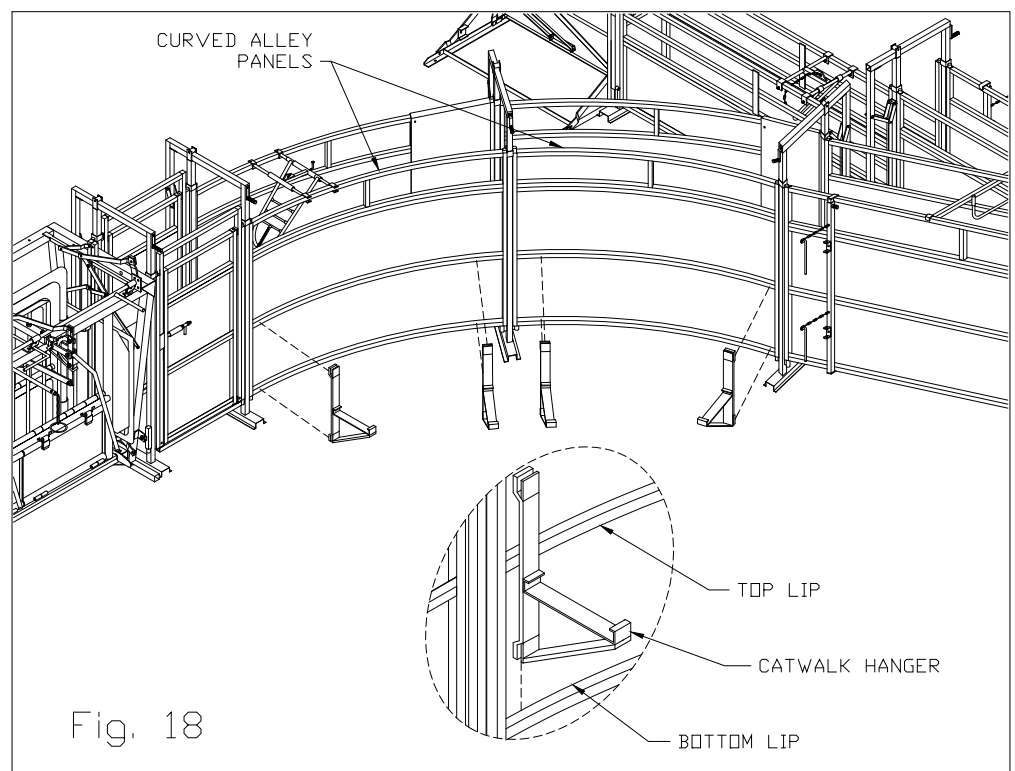
Slide the Tube Adapter onto the connector pin on the alley bow as shown.

Place the XL Chute next to the alley bow so that the hole in the Tube Adapter and the hole in the bracket on the chute are aligned and bolt them together as shown. The "U" Shaped Adapter bolts around the outside post on the alley bow and onto the bracket on the chute as shown in figure 17.

**STEP 18:**

Slide the bottom end of the Catwalk Hanger over the bottom lip of the inside Curved Alley Panel. Then tilt the hanger to one side until it is possible to slide the top of the hanger over the top lip of the Curved Alley Panel.

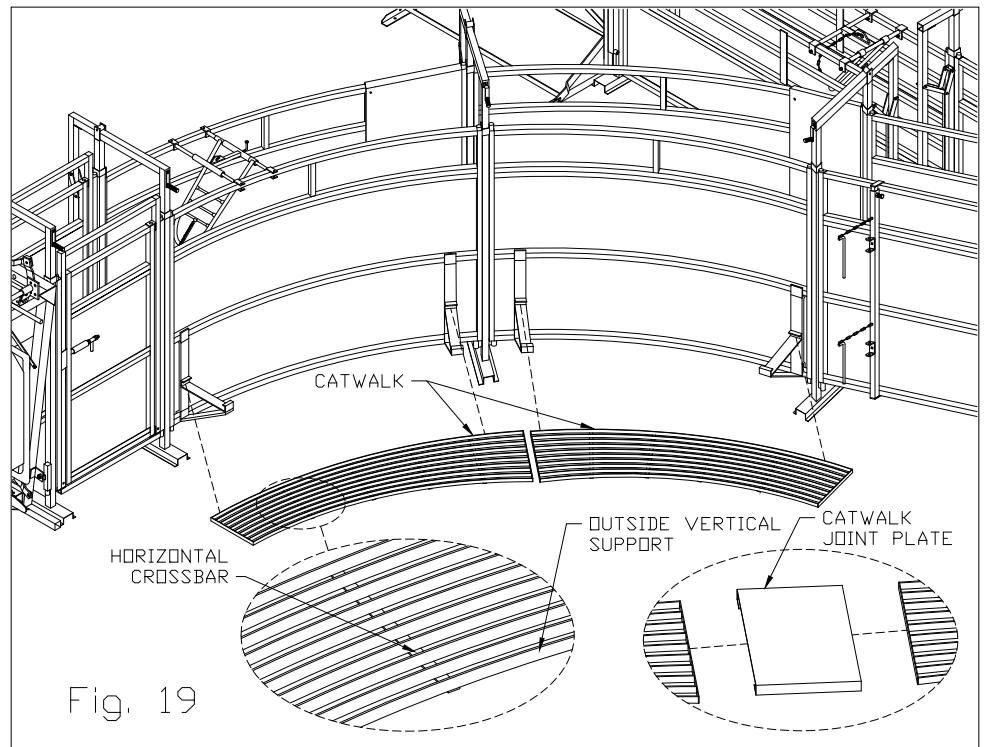
Place two Catwalk Hangers on each end of one Curved Alley Panel as shown in figure 18.



**STEP 19:**

Slide the inside edge of the catwalk into the inside hook on the hanger. (You may need to slide the hanger so that it is positioned between two horizontal crossbars on the Catwalk.) Push in on the outside vertical support until the catwalk drops into place.

The Catwalk Joint Plate is slid onto the ends of the adjoining Catwalk Sections as shown in figure 19.

**STEP 20:**

Place three Catwalk Hangers evenly spaced on each Curved Sweep panel as shown in figure 20. Refer to step 18 for installing Catwalk Hangers.

Install the Catwalk on the sweep tub in the manner as on the alley in step 19.

