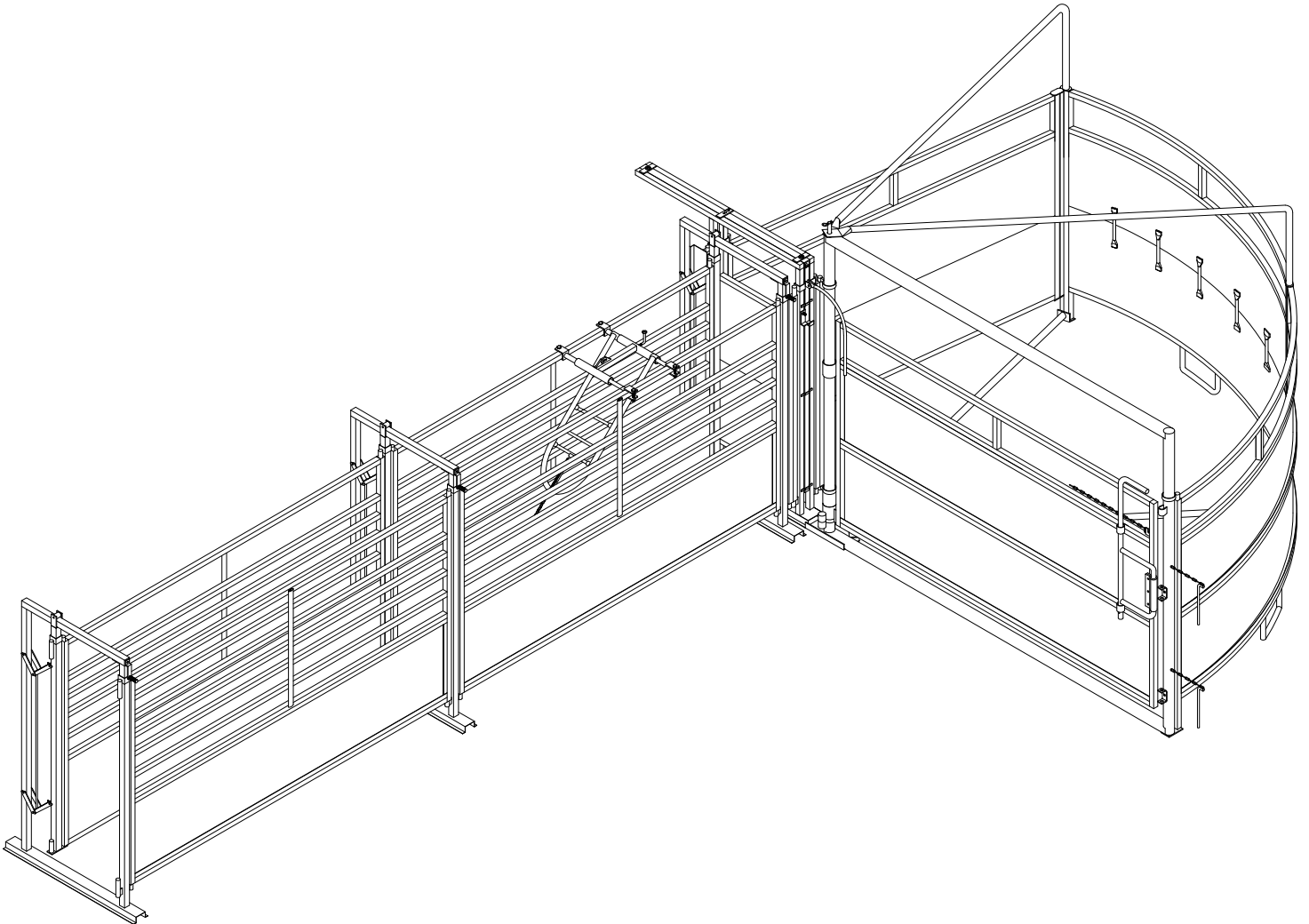


SINGLE GATE STRAIGHT RANCHER

ASSEMBLY INSTRUCTIONS

#007-50870



POWDER RIVER

• LIVESTOCK HANDLING EQUIPMENT •

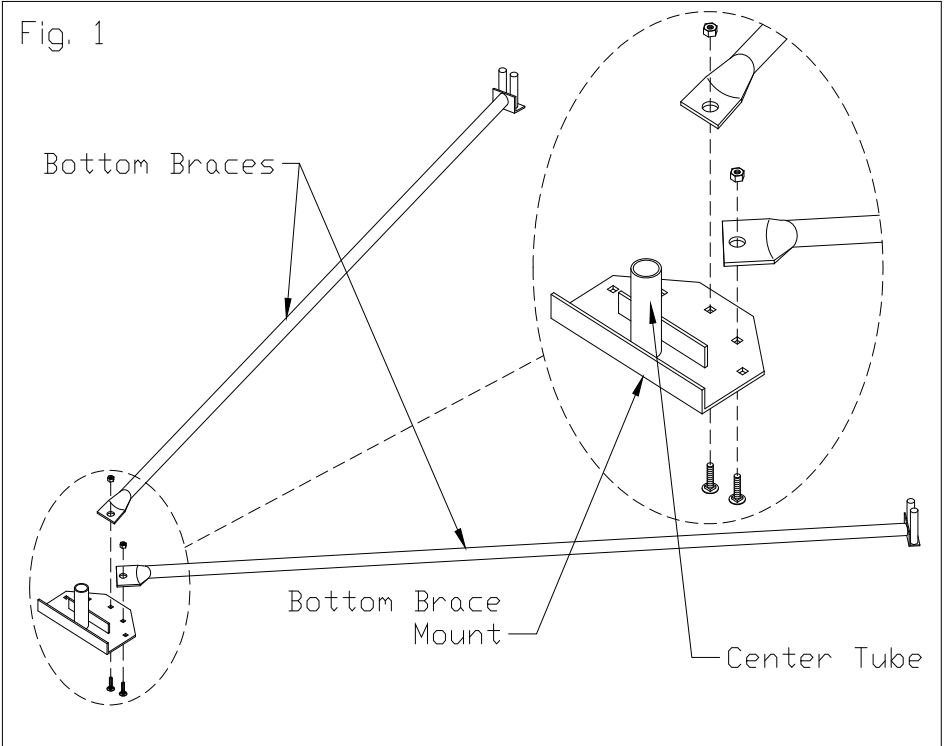
www.powderriver.com

1-800-453-5318

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.

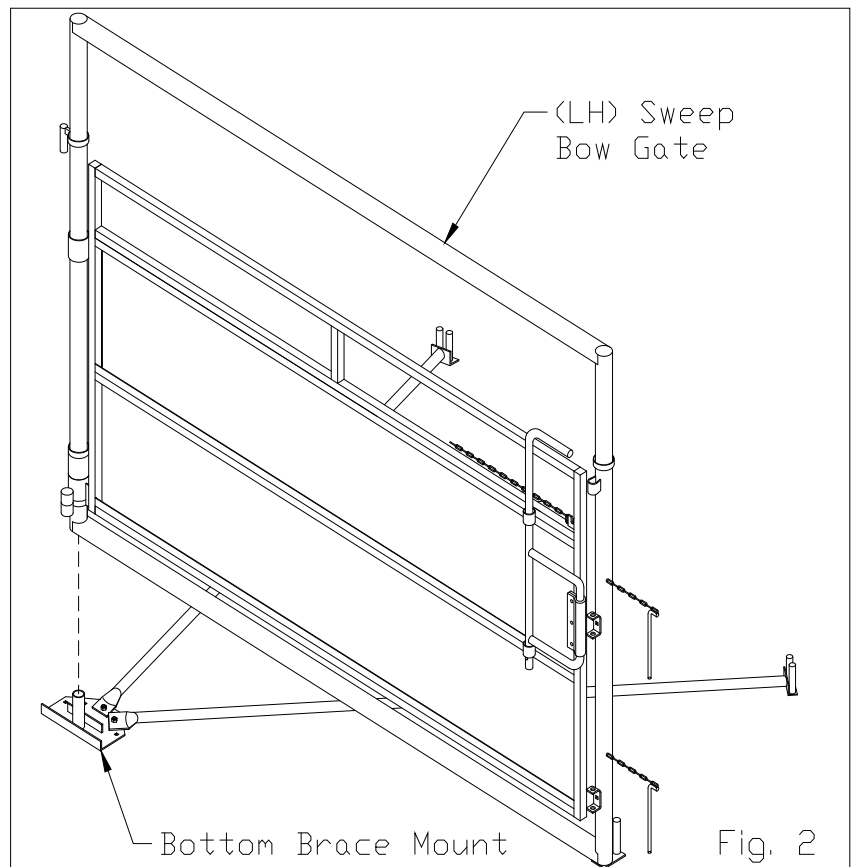
Place the center of the Bottom Brace Mount where you want the Tub to sit and alley to begin.

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



POWDER RIVER
 • LIVESTOCK HANDLING EQUIPMENT •

STEP 3:

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

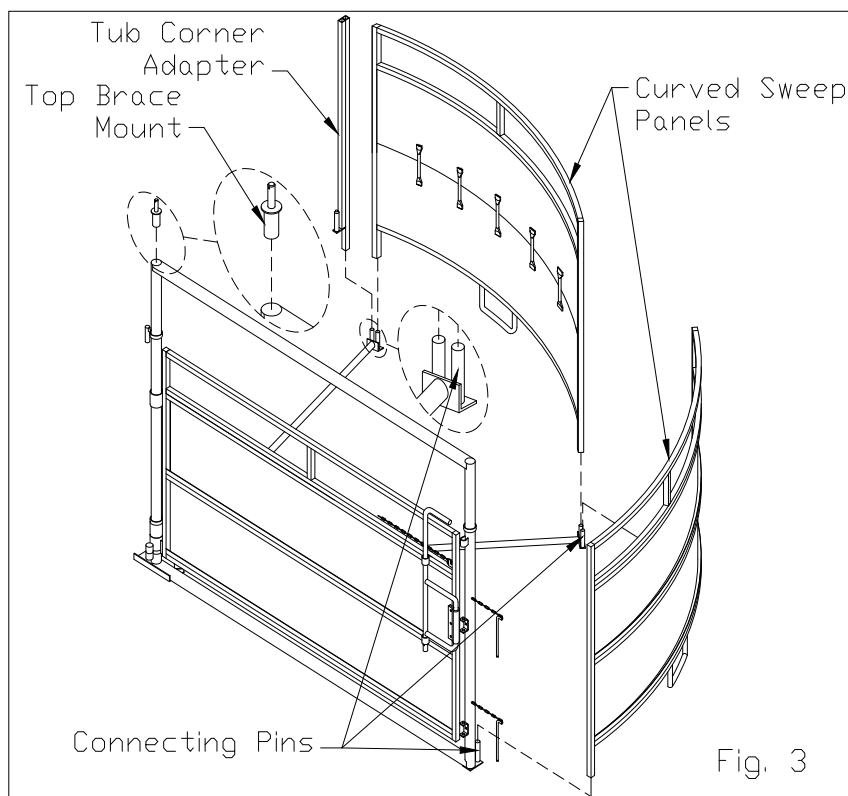


Fig. 3

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.

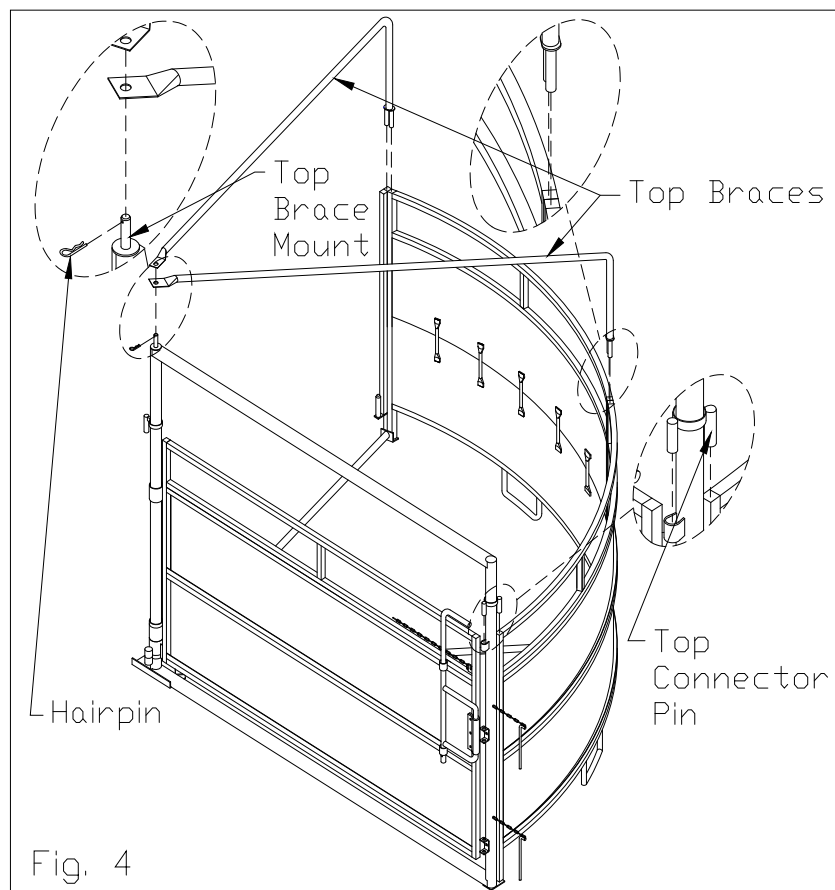


Fig. 4

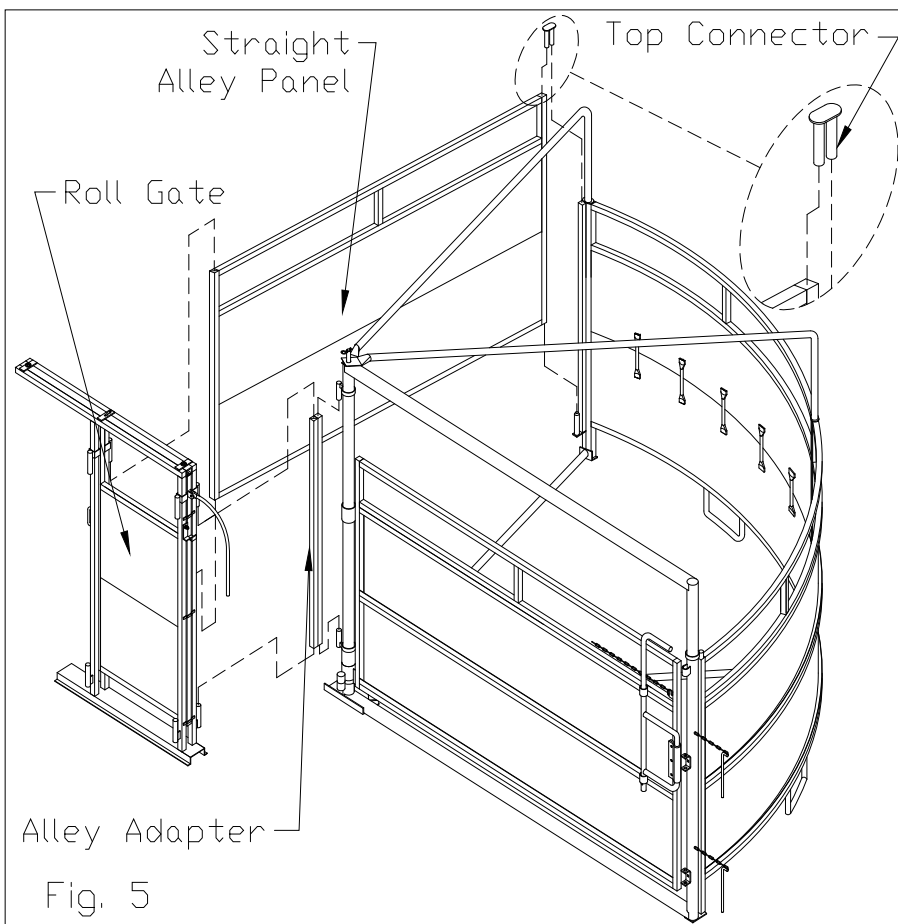
STEP 5:

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.

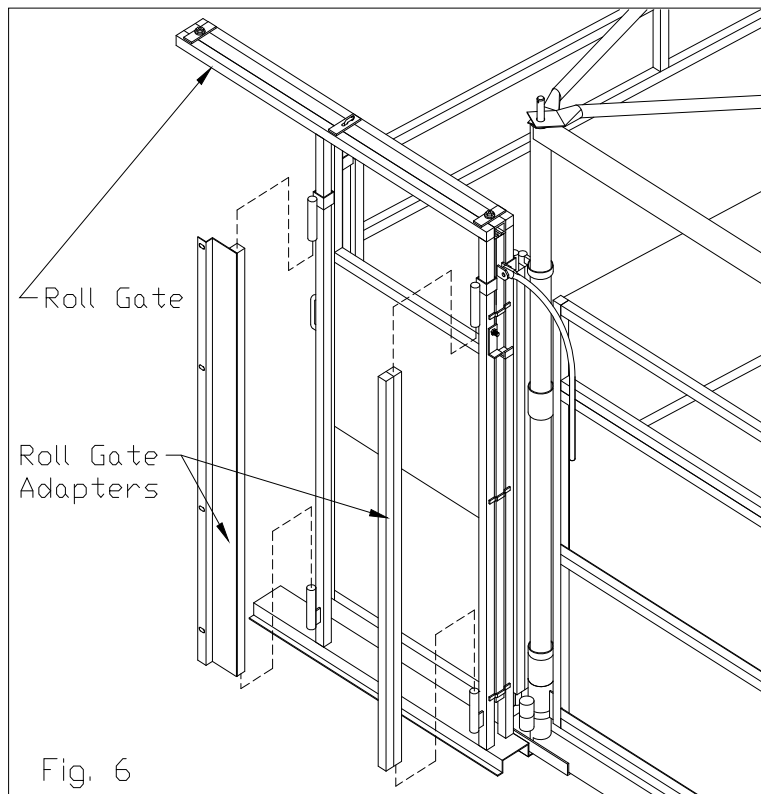
The flange on one side of the Roll Gate base plate will need to slide under the Bottom Brace Mount in order to install the Alley Adapter.

(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:**

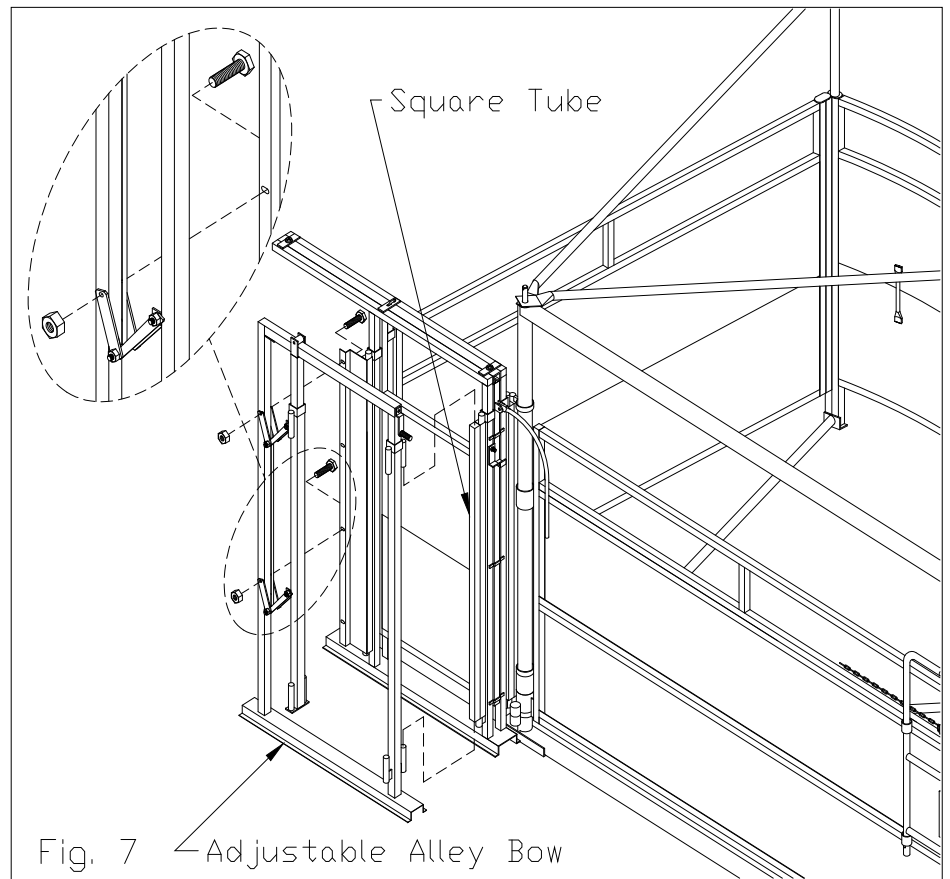
Place the Roll Gate Adapters onto the bottom connector pins on the Roll Gate. Secure the Roll Gate Adapter to the Roll Gate by sliding the top connector pins into the tops of the adapter as shown in figure 6.



STEP 7:

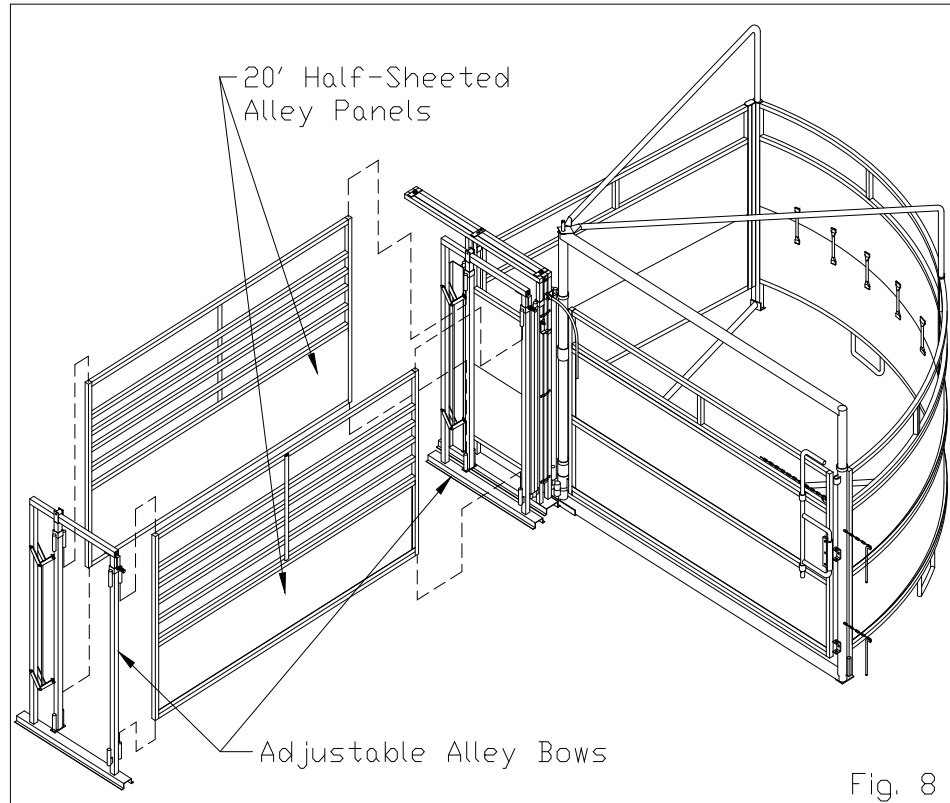
Using figure 7 as a reference. Remove the two outside bolts on the Adjustable Alley Bow. Slide the Adjustable Alley Bow up to the Roll Gate Adapters and slide the square tube onto the bottom connector pin on the Adjustable Alley Bow. Slide the top connector pin into the top of square tube as shown.

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. Tighten them together with the two lock nut that were previously removed as shown in figure 7.

**STEP 8:**

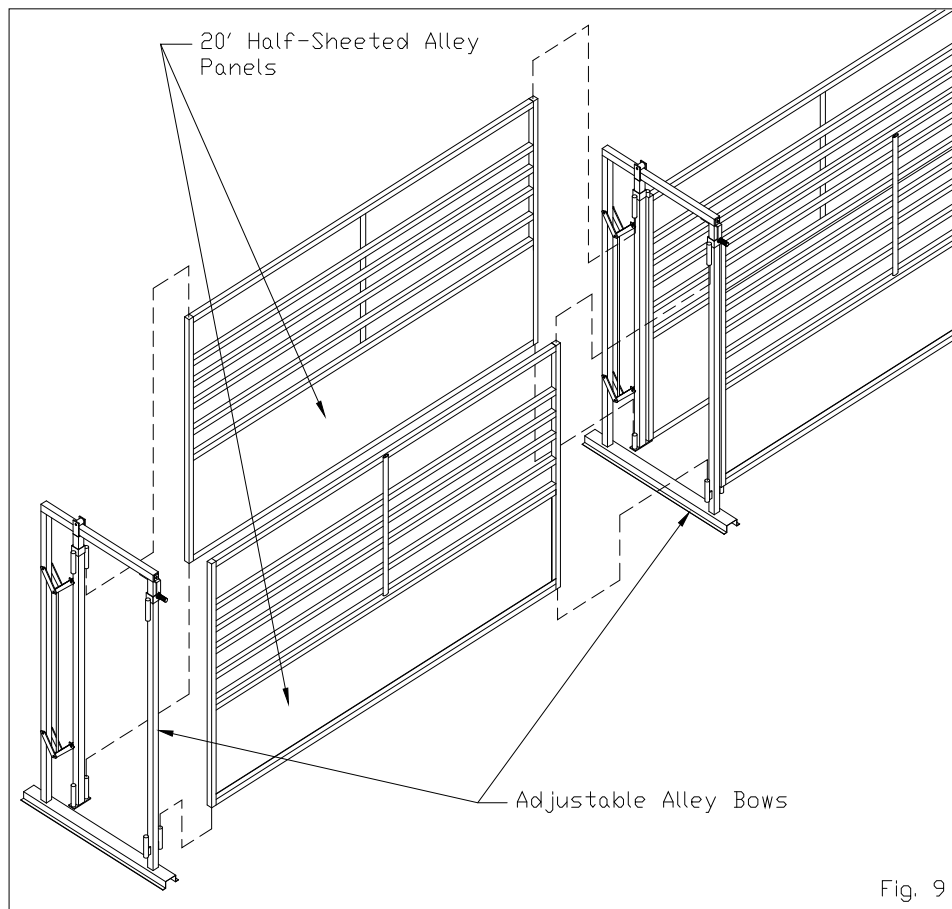
Connect one of the 20' Half-Sheeted Alley Panels to the Adjustable Alley Bow that is connected to the Roll Gate, by sliding the end tube onto the bottom connecting pin. Slide the top connecting pin into the top of the end tube on the Alley Panel. Secure the far end of the Alley Panel to the other Adjustable Alley Bow as shown in figure 8.

Secure the Second Panel to both Adjustable Alley Bows in the same manner as the first.



STEP 9:

Using figure 9 as a reference, secure the remaining 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 Alley Panels, at the desired location as shown in figure 10.

NOTE: 10' alley add sections are available in half sheeted or full Sheeted panels.

