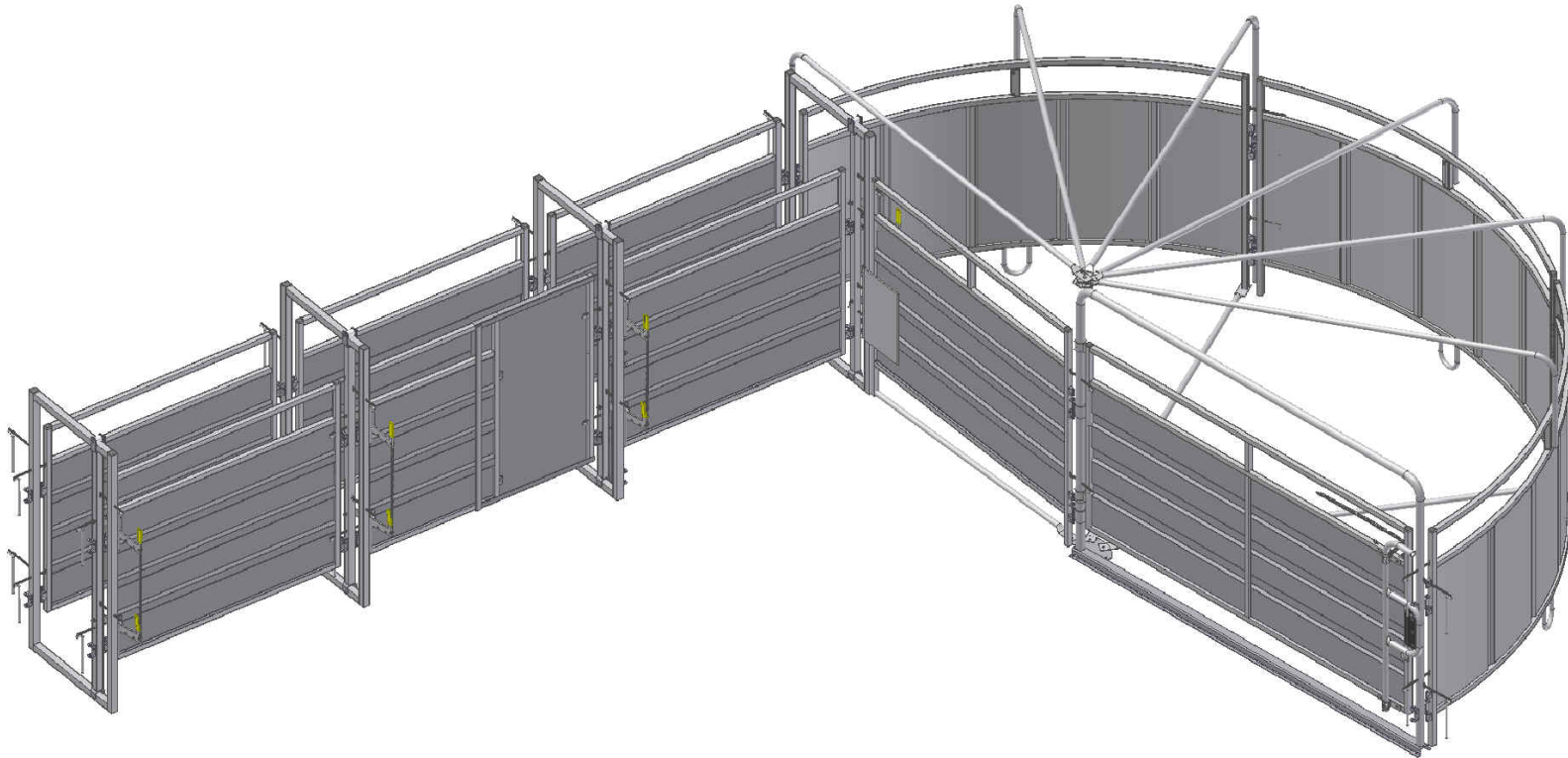


CATTLEMAN'S TUB AND ALLEY

ASSEMBLY INSTRUCTIONS

#006-30000



POWDER RIVER

• LIVESTOCK HANDLING EQUIPMENT •

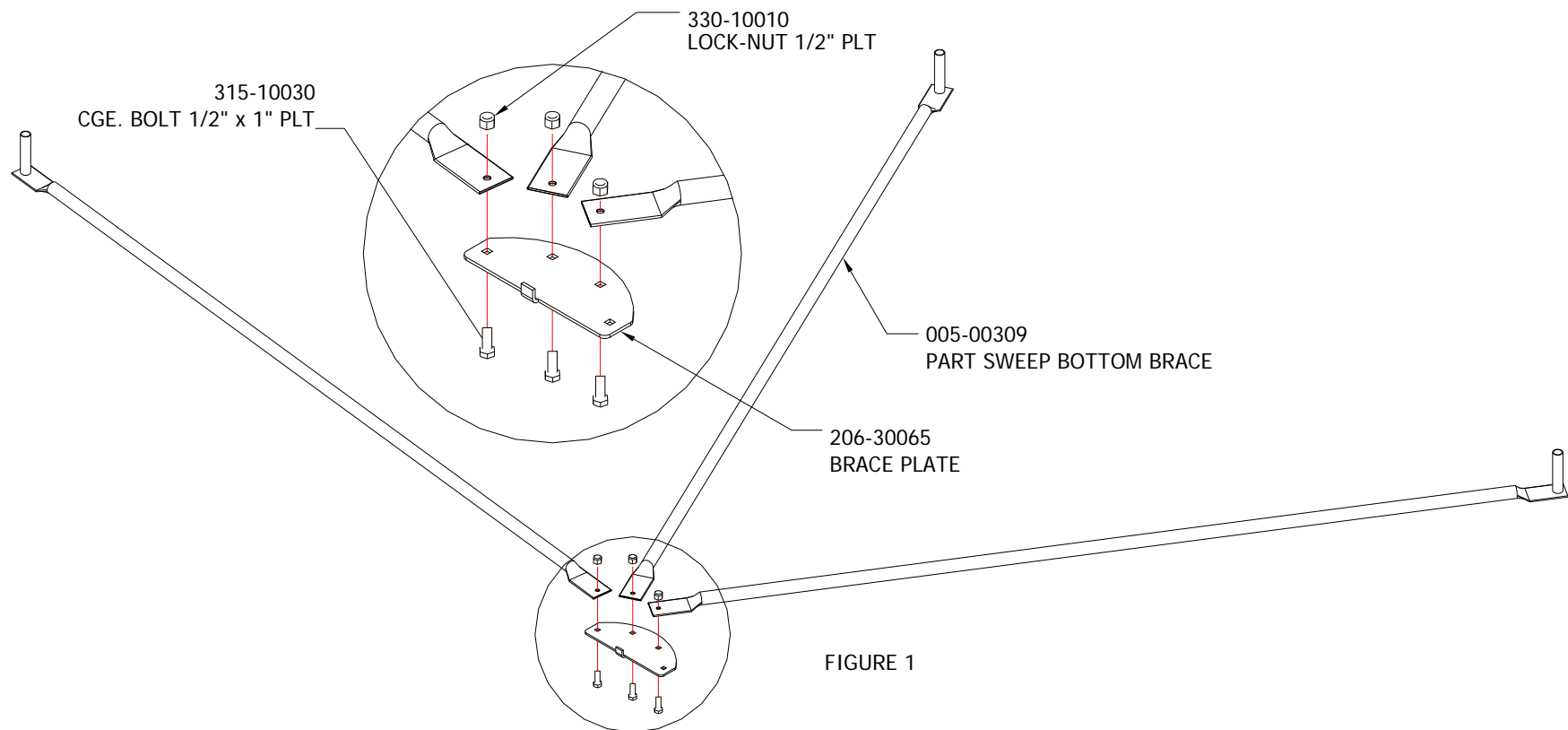
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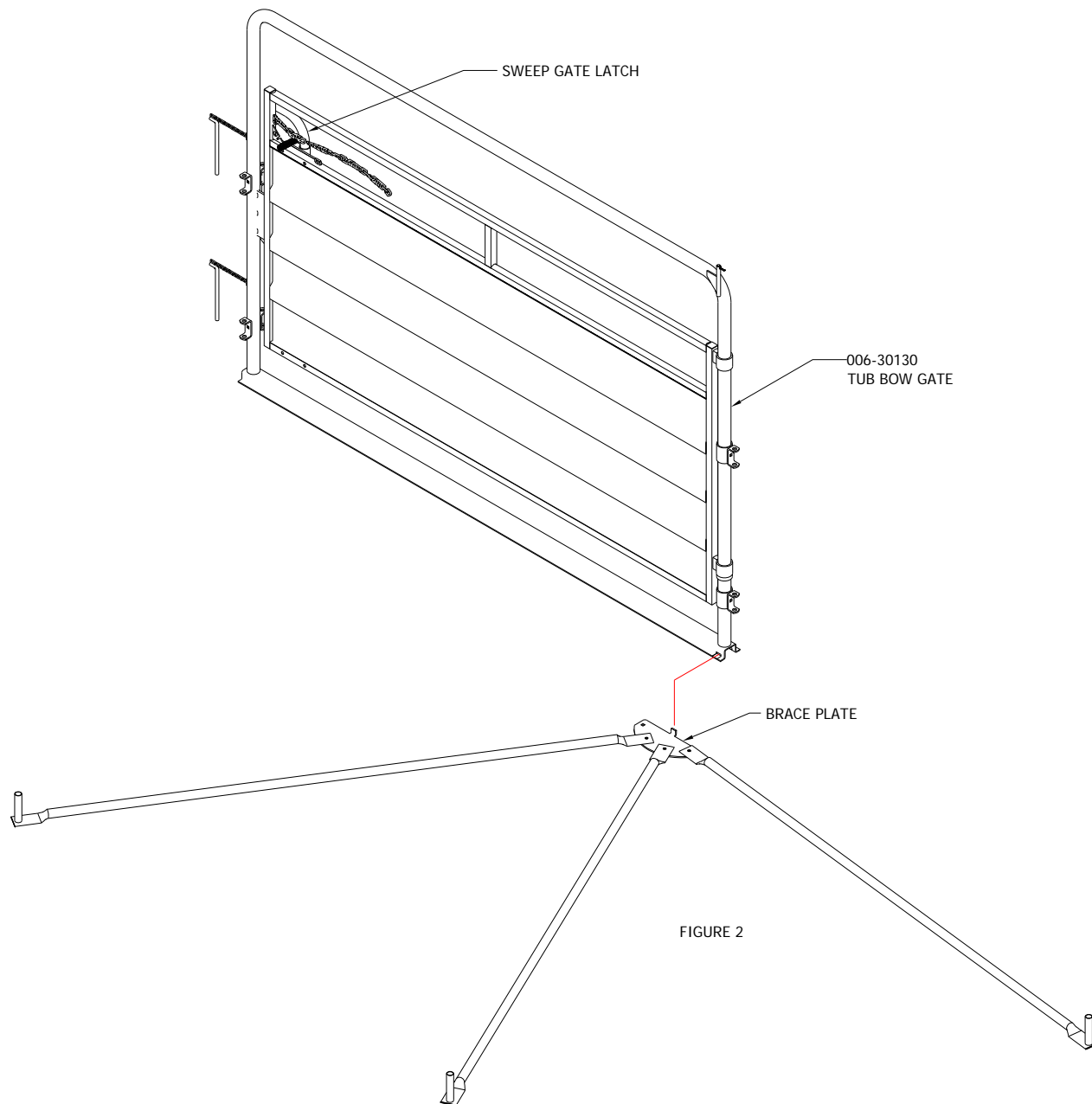
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Step 1: (Cattleman's Tub)

-- Unpack and verify that all parts were received.

Connect three bottom braces to the top main brace using $\frac{1}{2}$ " x 1" carriage bolts, and $\frac{1}{2}$ " lock nut. Be sure that you place the braces in the left three holes and leave the last hole empty (shown in fig. 1)





Step 2:

Connect the sweep bow gate and brace plate by sliding the tab into the groove on the bottom corner of the bow gate. Be sure that the sweep gate latch is facing the outside of the tub.

Step 3:

Align the bottom tubes of the L-braces with the connector on the bottom braces and drop into place. Repeat with each of the three braces. Now align the top holes with the pin extending from the bow-gate. Drop each brace into place and secure using the hairpin.

Note: Stacking order does not matter when securing braces to pin.

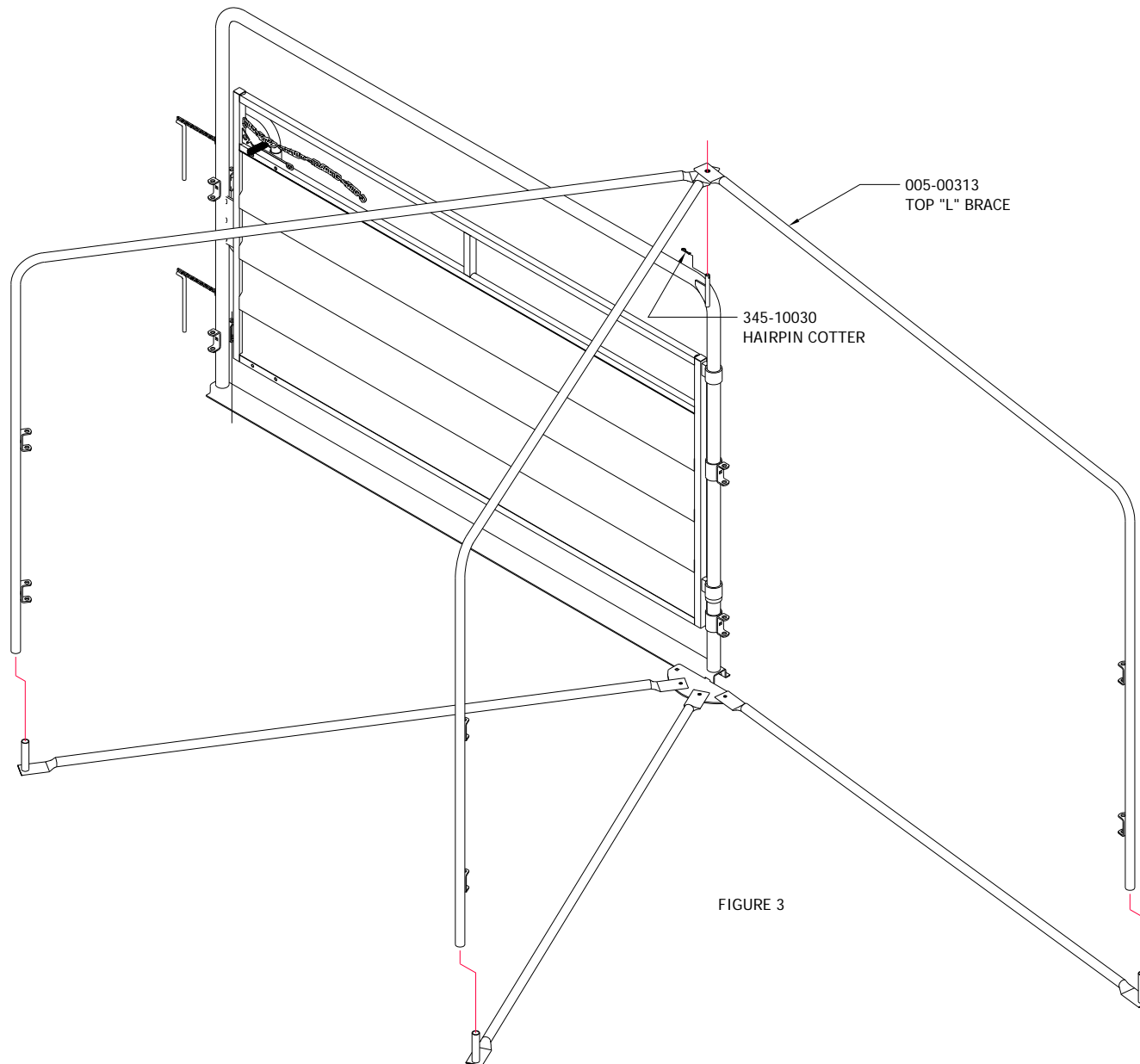
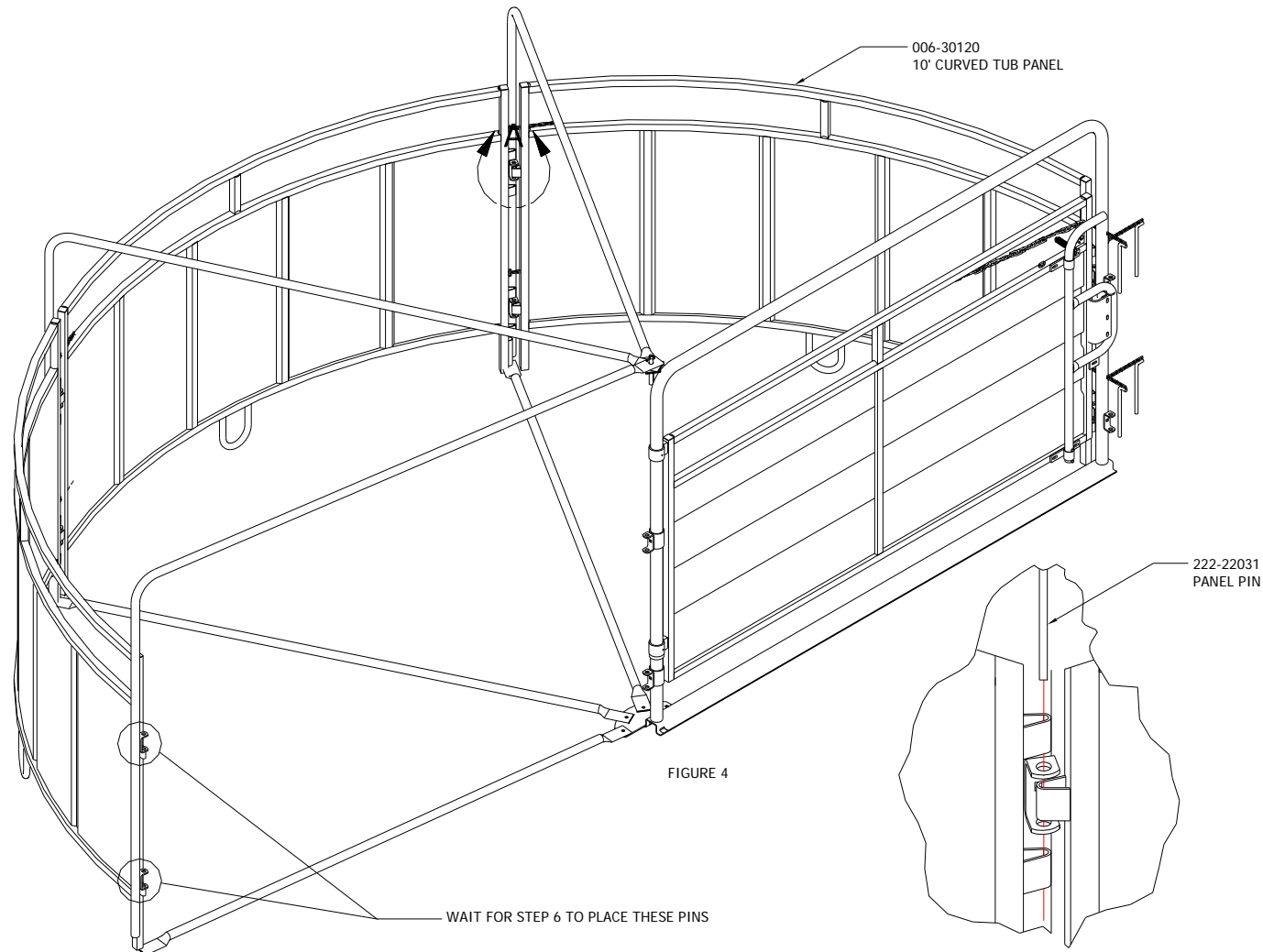


FIGURE 3

Step 4:

Line up connectors on ends of curved panels with the connectors on the L-brace and drop pins through to secure panels to the L-brace. Do this on top and bottom of each panel until all are secure and in place, leaving the last connectors vacant.

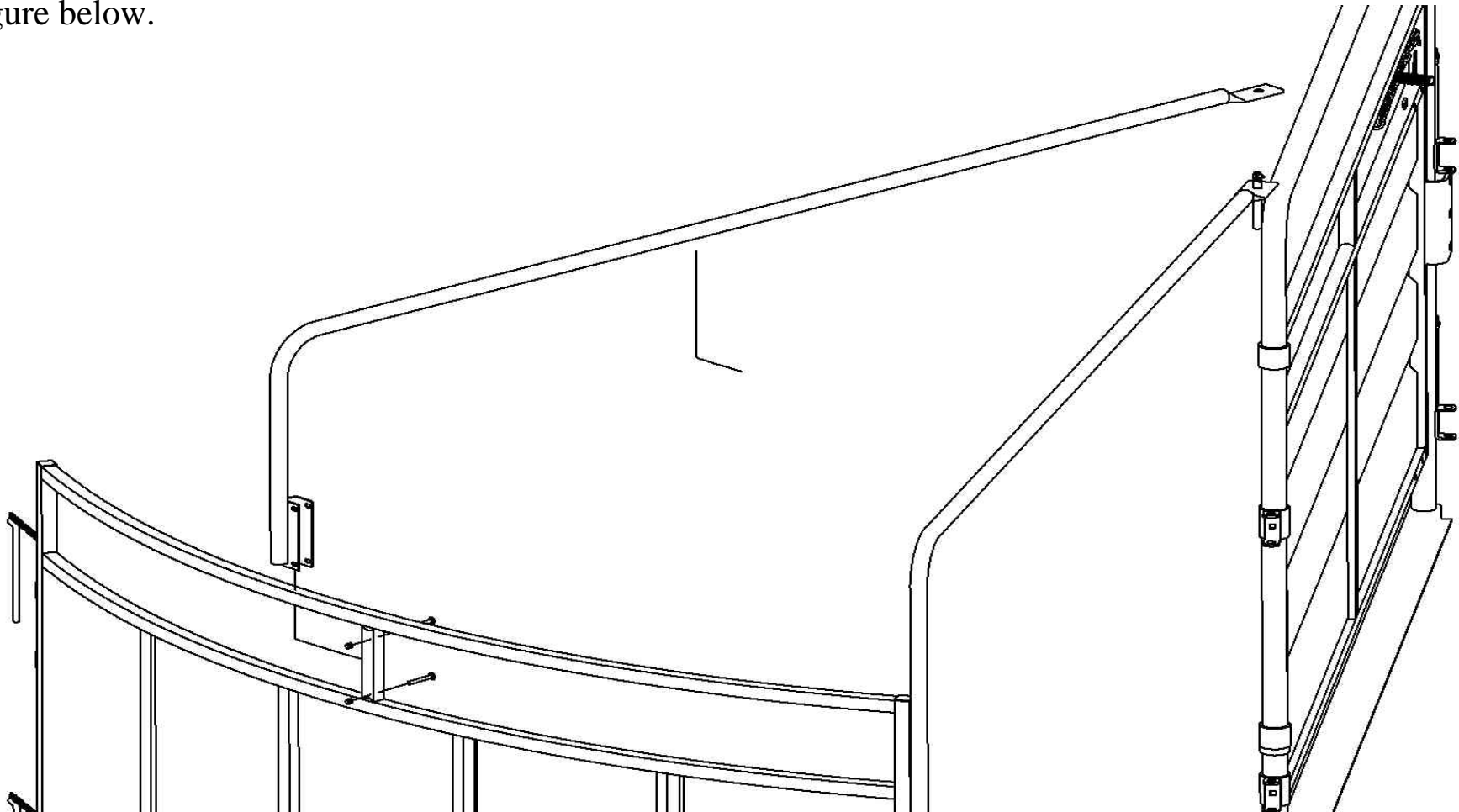


Step 5:

Take the L brace with the mounting channel and insert the channel plate on the panel tub stub and align the other end of the L brace with the pin. Then remove the cotter pin and fit the braces onto the pin then secure it with the cotter pin again. Finally use the 3/8" Lock Nut and the 3/8" Cge Bolt and secure the L brace the tub stub as shown in figure below.

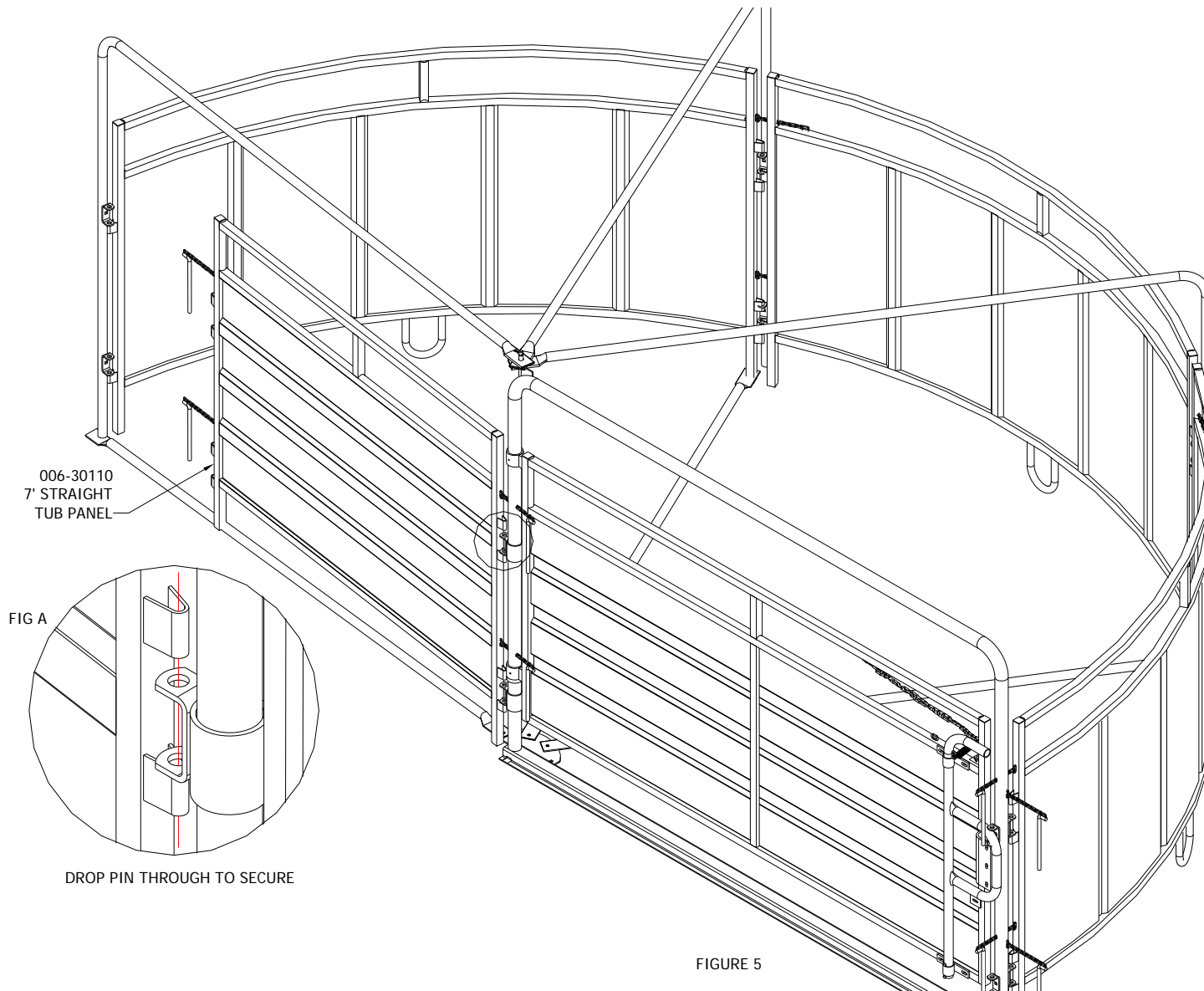
L brace with mounting plate

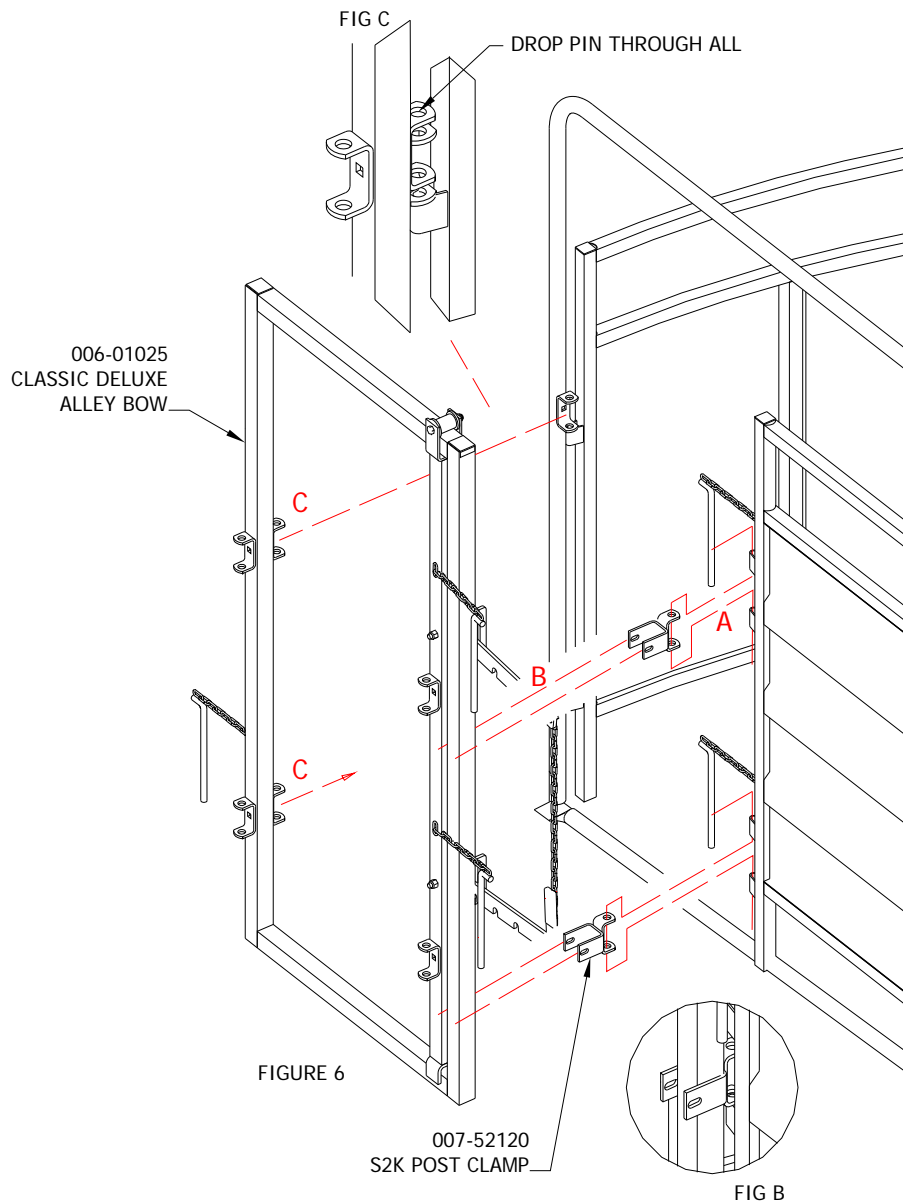
- 3/8" Lock Nut Nylon Plated
- 3/8" x 2 1/2" Carriage Bolt Plated



Step 6:

Place the 7' straight tub panel in line with the bow gate. Align connectors (see figure A) and drop panel pin to secure. Repeat for bottom connectors.





Step 7:

- A) Align the holes of the post clamp and the bracket connected to the straight tub panel. Drop pin through all, then repeat on clamp below.
- B) Slide alley bow into groove of clamp (see figure B)
- C) Align holes of connectors and drop pin through all (see figure C)

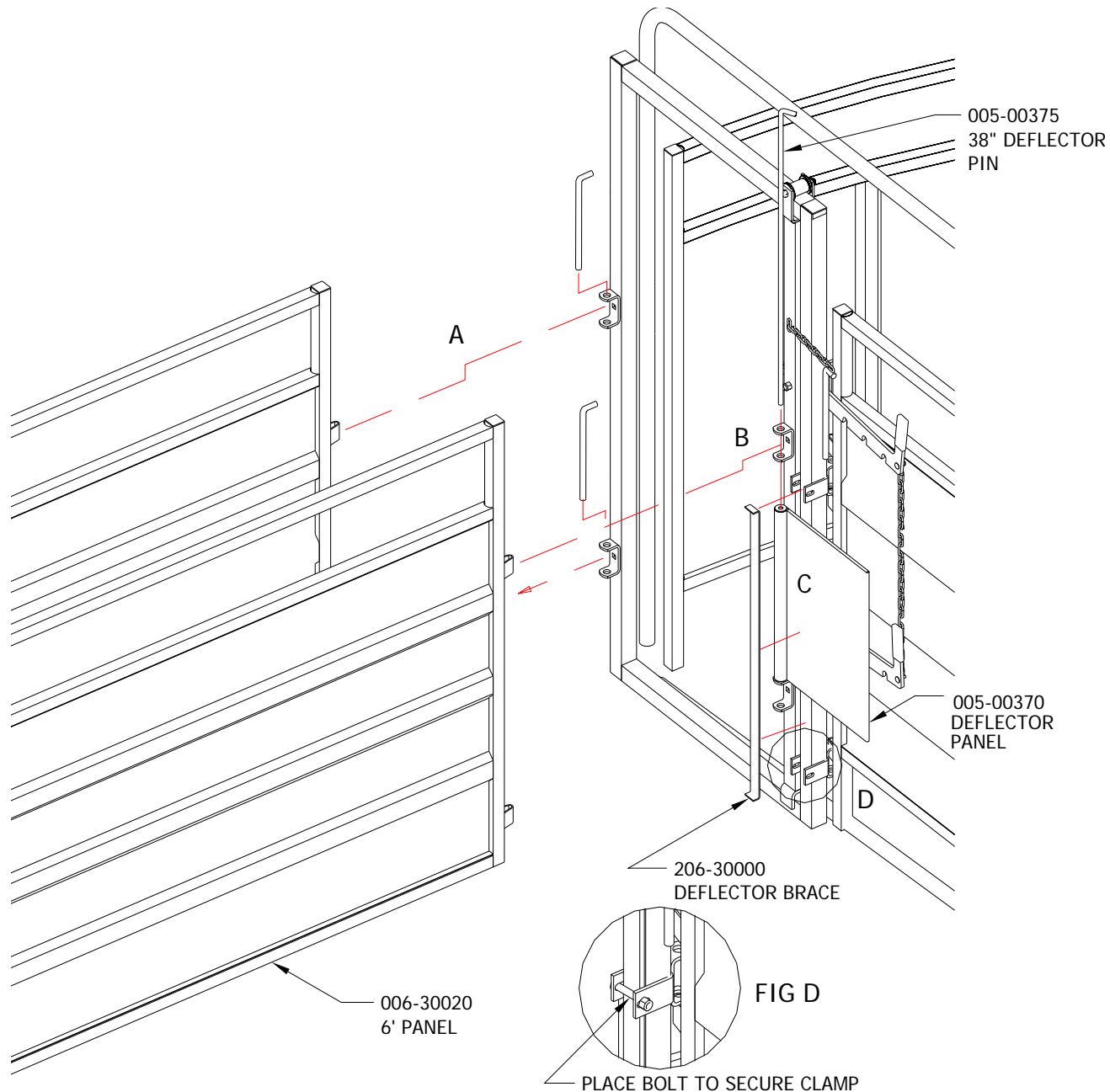


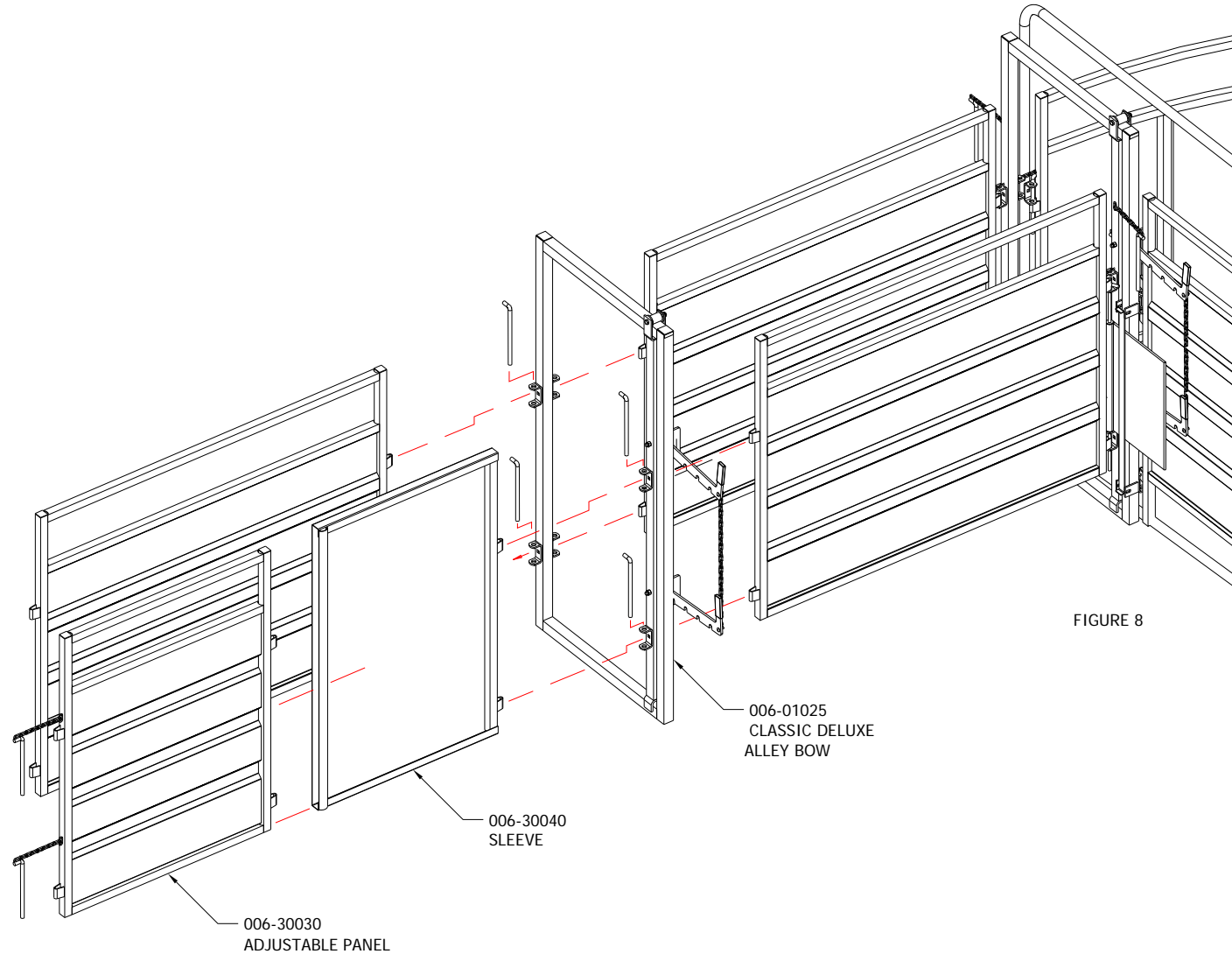
FIGURE 7

Step 8:

- A) Line up bracket and panel clip. Drop pin through. Repeat for bottom of panel.
- B) Line the deflector panel up with the brackets on the bow gate (fig 7). Now slide 6' panel into brackets. Line up all holes and drop large 38" deflector pin through all holes.
- C) Place deflector brace into clamps which are holding alley bow gate into place. Press the brace flush with the deflector panel. See Picture on step 8 for more detail.
- D) Place bolt through clamp (fig D).

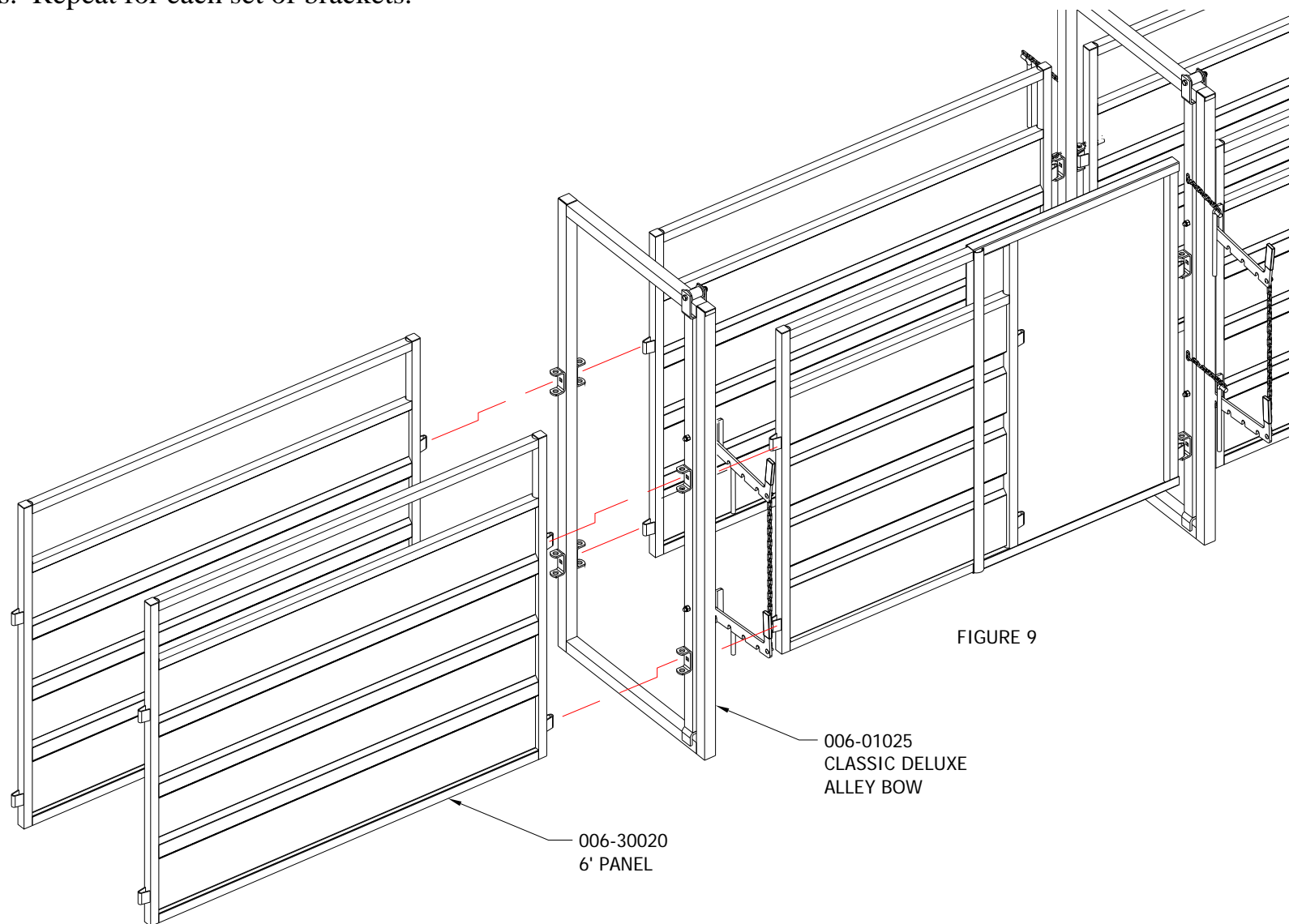
Step 9: (Adjustable Alley Panel Assembly)

- Place alley bow as shown. Align brackets and panel clips. Drop pins through each, securing the alley bow to the panels.
- The sleeve slides into the adjustable panel, and is completed prior to shipment from Powder River.



Step 10:

Place alley bow as shown. Align brackets and panel clips. Now drop pins through each, securing the alley bow to the panels. Repeat for each set of brackets.



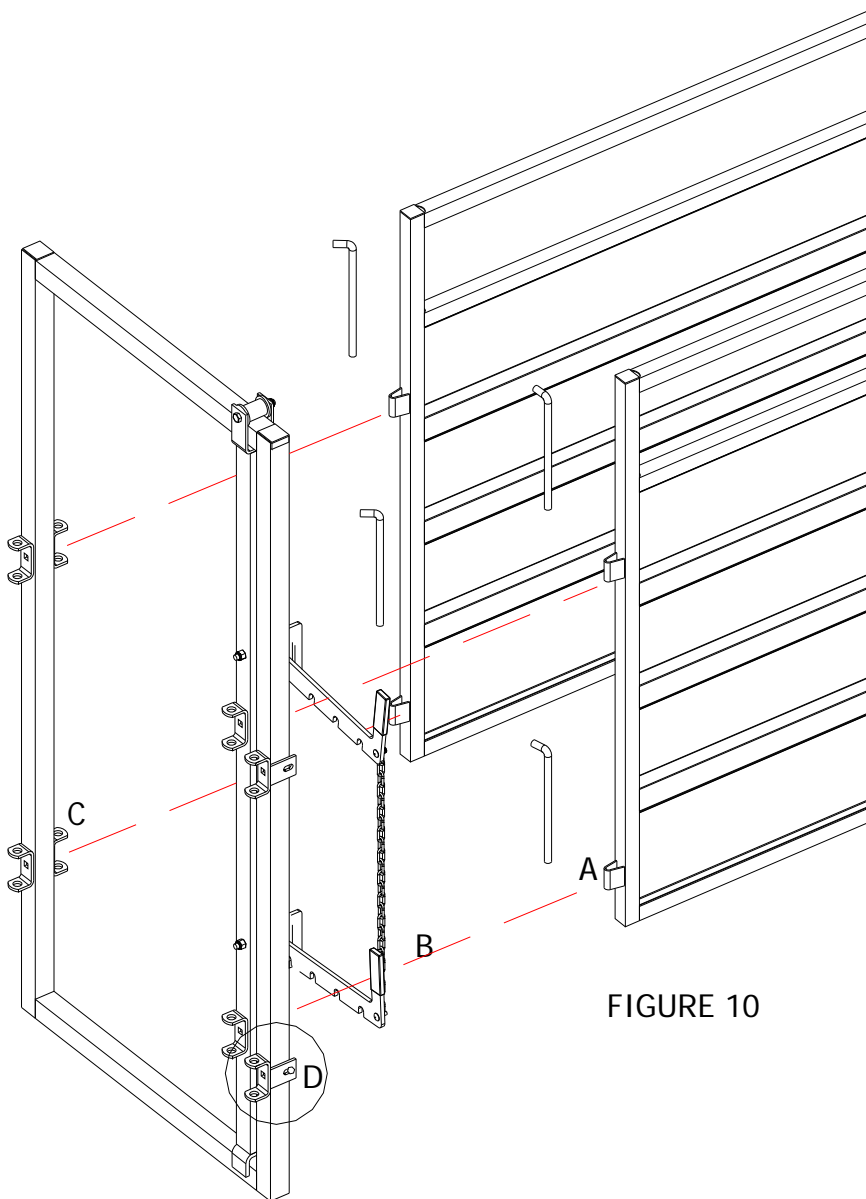
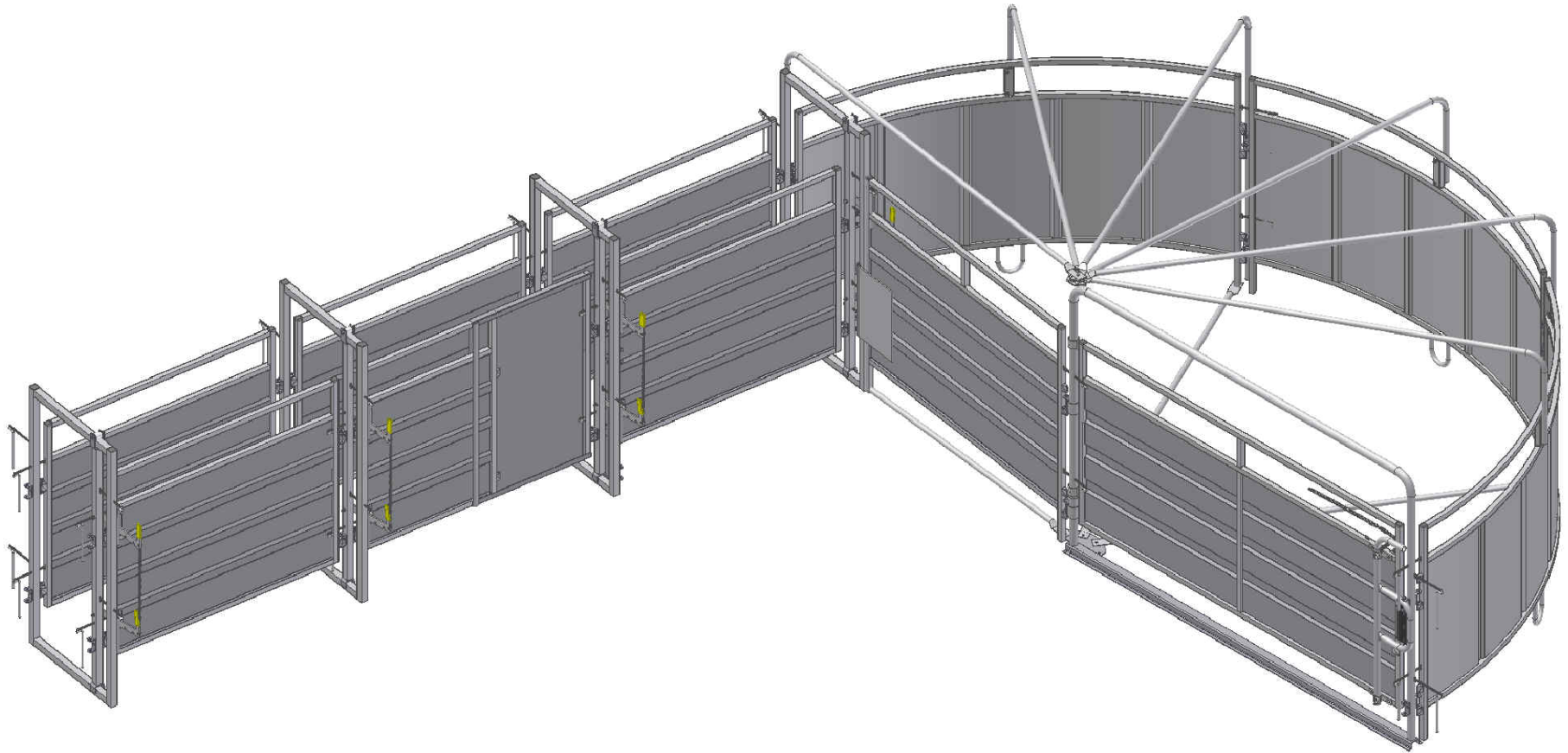


FIGURE 10

Step 11 :

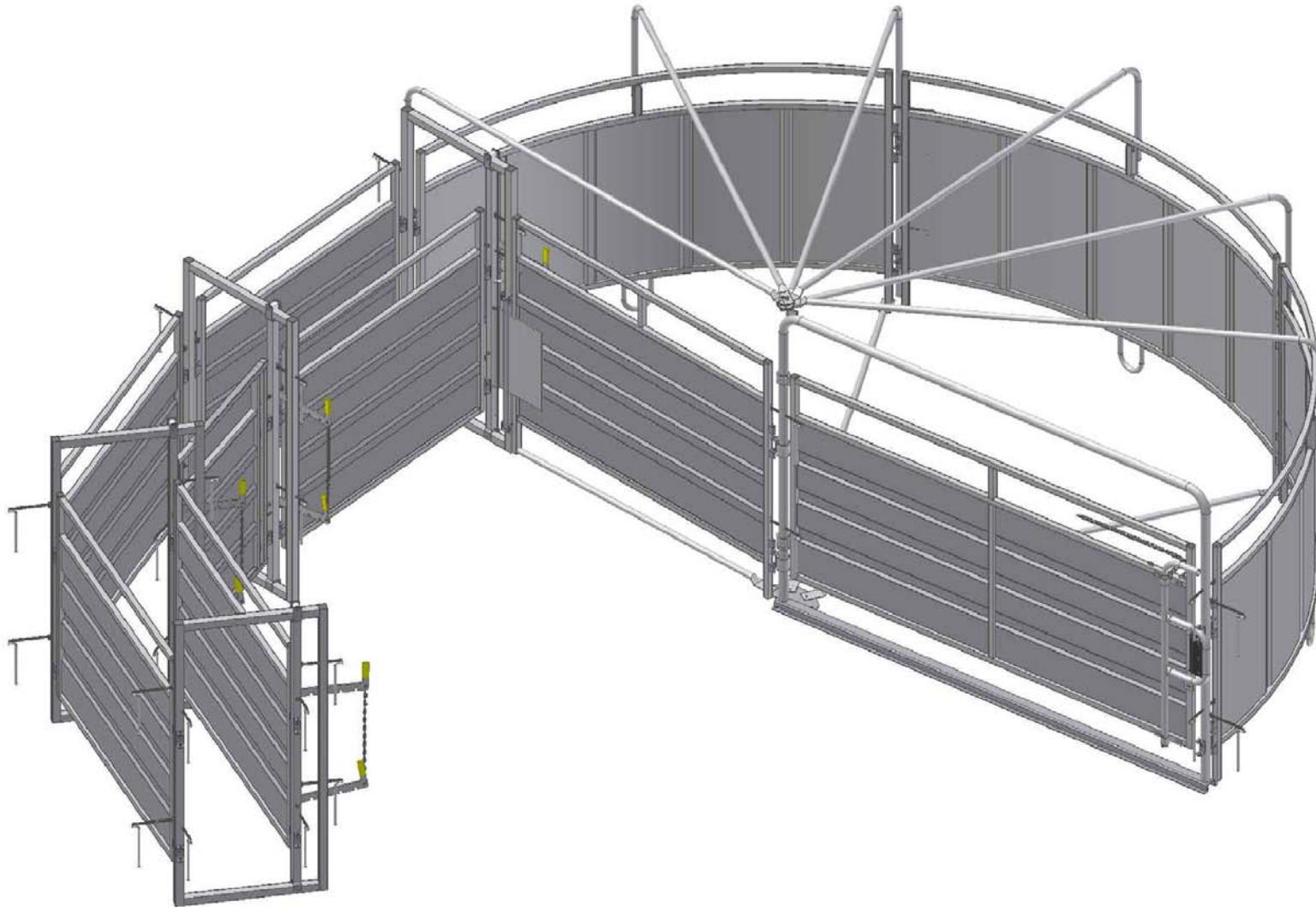
- A) Align the holes of the bracket on the bow and the panel clip connected to the straight tub panel.
- B) Drop pin through clip and bracket.
- C) Repeat on opposite side.
- D) Place clamp on bow as shown in fig D and then secure with bolt.

The final assembly of the Tub and Alley will look like this.



Adjustments:

All curve adjustments of alley will be made at the sleeve and adjustable panel. The further the adjustable panel is pushed into the sleeve, the more the alley will curve.



Alley Curving Right:

To assemble the alley so that it curves right instead of left, use this figure for reference. To assemble, follow the instructions on step 8, except on the opposite side of the alley. Be sure to rotate alley-bows so that the handles are on opposite side, as seen in the figure below.

