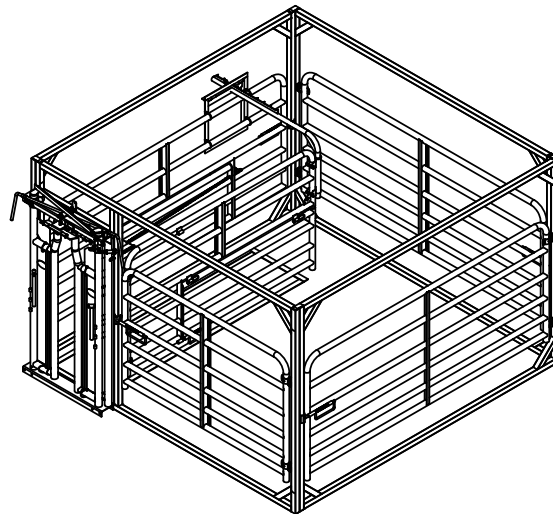




**CALVING PEN
CARE CENTER
#15503**



**PARTS & ASSEMBLY
MANUAL**

IMPORTANT - TO THE DEALER OR ERECTOR:
RETURN THIS MANUAL TO THE OWNER FOR FUTURE REFERENCE

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SAFETY



RECOGNIZE SAFETY ALERT SYMBOL

The above symbol means “ATTENTION! BE ALERT! YOUR PERSONAL SAFETY IS INVOLVED! Note this symbol in instructions for important issues concerning your personal safety. Read each message carefully to avoid personal injury or death.

SURFACE PREPARATION

Install unit on a level surface to prevent tipping of Panel Assemblies.

WARNING: KEEP CLEAR

Keep people (ESPECIALLY YOUTH) away from Pen when erecting.

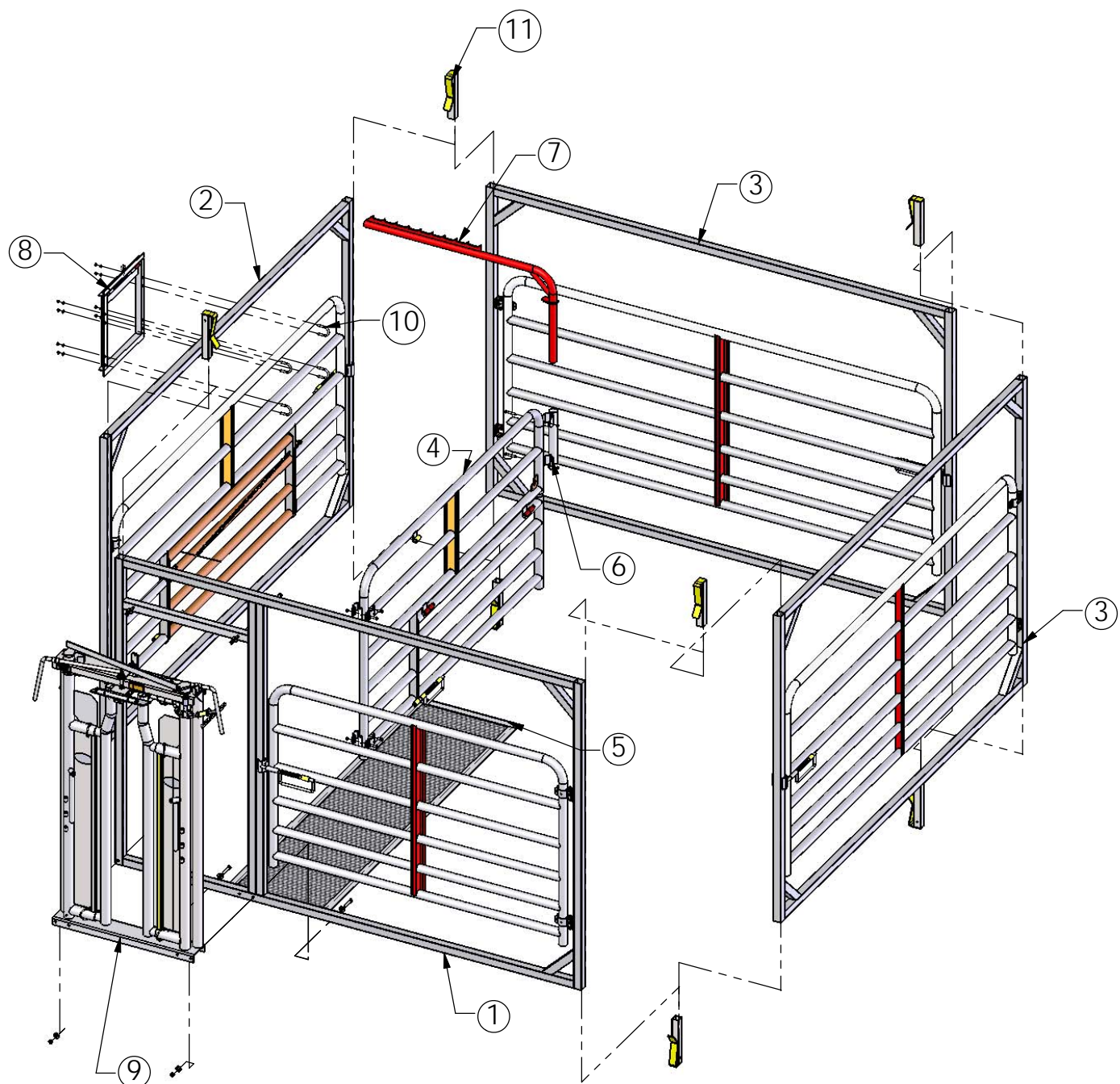
SIoux STEEL COMPANY INCLUDES ALL REASONABLE MEANS FOR ACCIDENT PREVENTION EXCEPT A SAFE AND CAREFUL OPERATOR.



REPLACEMENT SAFETY AND WARNING DECALS ARE AVAILABLE AT NO CHARGE

GENERAL INFORMATION

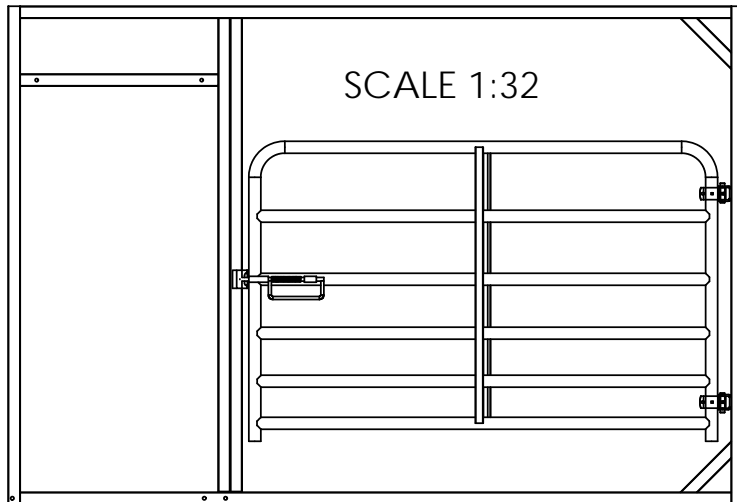
- 1) At the time of delivery, be sure to check all bundles and parts for proper quantity and condition. If a shortage or damage has occurred, **DO NOT ACCEPT DELIVERY** without making note on the freight or delivery receipt. If shortage or damage is found, notify your carrier immediately, so they can send an inspector to make a formal report. Compliance with carrier's procedure is essential for settlement of a claim as the Company's responsibility ends when the carrier receives shipment.
- 2) Carefully read and understand this manual before beginning construction of the Calving Pen Care Center. Refer to parts identification diagrams on Pages 7 - 10 to familiarize yourself with each component and its relative location in the final assembly. A detailed assembly diagram is also included with each assembly step.
- 3) This manual shows the optional 191470PG Headgate Assembly and the optional 168701 Step Plate.
- 4) It is recommended that the Calving Pen Care Center be assembled on a level flat surface.



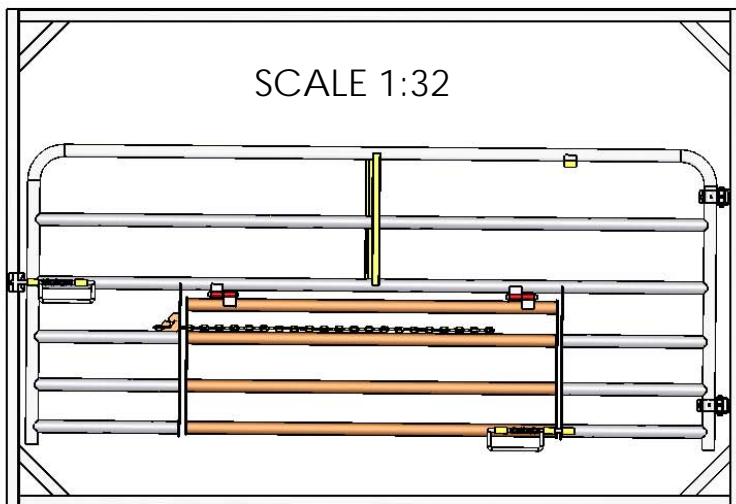
PARTS LIST

KEY	PART NUMBER	DESCRIPTION	QUANTITY
1	189756	FRONT FRAME ASSEMBLY	1
2	15505	NURSING GATE ASSEMBLY	1
3	15506	STANDARD PANEL ASSEMBLY	2
4	173979	SQUEEZE GATE ASSEMBLY	1
5	168701 (OPTIONAL)	STEP PLATE	1
6	158965	SQUEEZE LOCK MOUNT TUBE	1
7	158964	SQUEEZE LOCK RATCHET	1
8	15513	SQUEEZE LOCK FRAME	1
9	191470PG (OPTIONAL)	HEAD GATE ASSEMBLY	1
10	158966	5/16" X 2" U-BOLT	4
11	183488	CLIP CONNECTOR	8

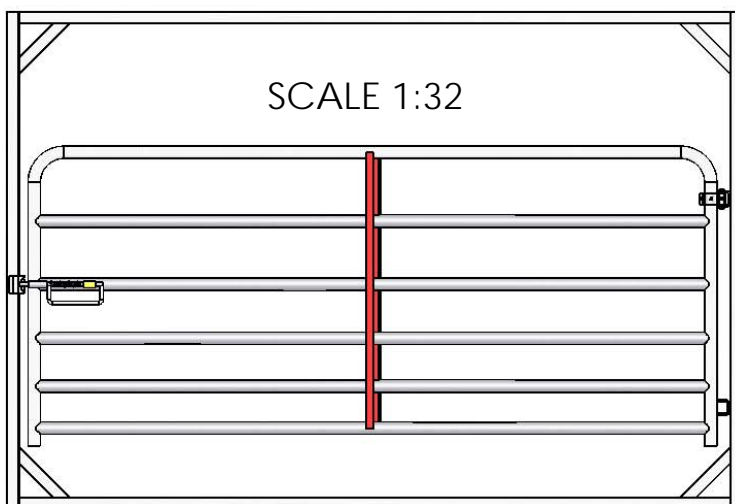
15503 - CALVING PEN PARTS & ASSEMBLIES



ITEM #1 (QTY-1)
189756 - FRONT PANEL ASSEMBLY
CONSISTING OF;
(1) 189751 SLAM LATCH FRAME
(1) 189755 - 7FT STANDARD GATE
W/SLAM LATCH



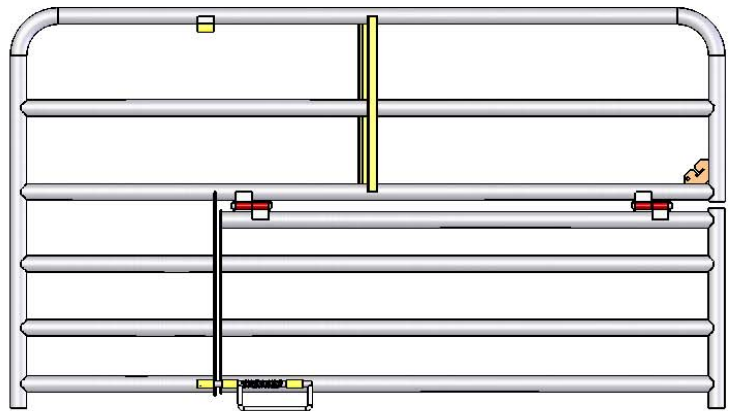
ITEM #2 (QTY-1)
15505 - NURSING PANEL ASSEMBLY
CONSISTING OF;
(1) 176131 SLAM LATCH FRAME
(1) 173976 10FT NURSING GATE
W/SWING GATE & SLAM LATCH



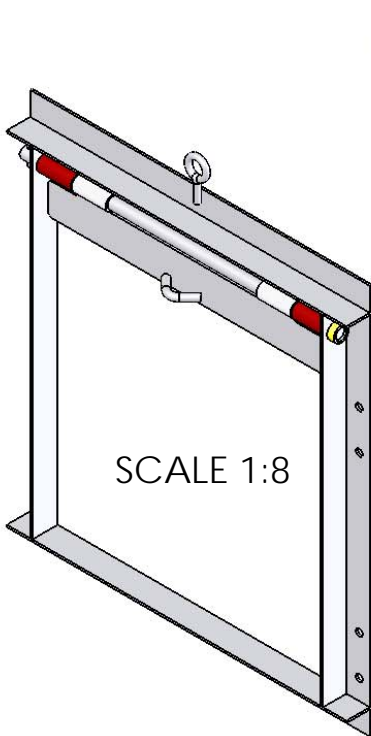
ITEM #3 (QTY - 2)
15506 - STANDARD PANEL ASSEMBLY
CONSISTING OF;
(1) 176131 SLAM LATCH FRAME
(2) 176133 10FT STANDARD GATE
W/SLAM LATCH

15503 - CALVING PEN PARTS & ASSEMBLIES

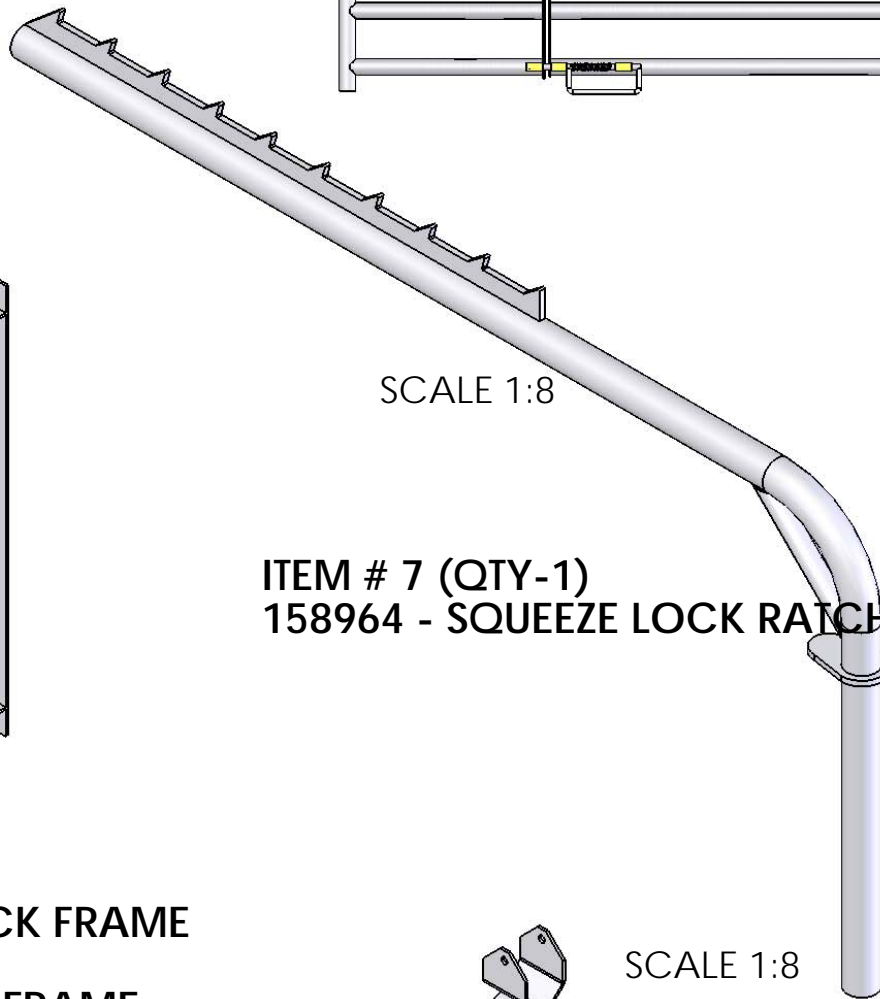
SCALE 1:24



ITEM #4 (QTY-1)
173979 - SQUEEZE GATE ASSY
CONSISTING OF;
(1) 173980 7FT SLAM LATCH GATE
(1) 173986 SWING GATE

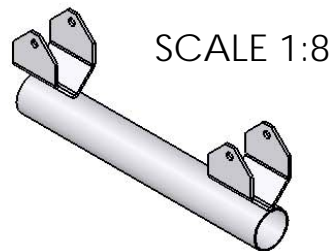


SCALE 1:8



SCALE 1:8

ITEM # 7 (QTY-1)
158964 - SQUEEZE LOCK RATCHET



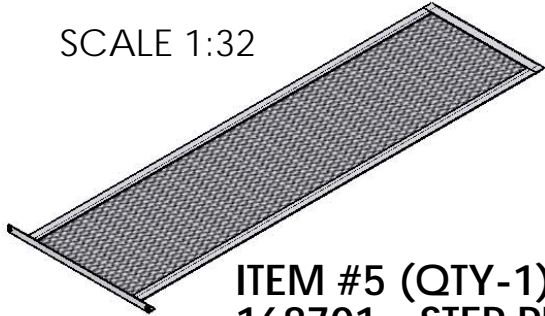
SCALE 1:8

ITEM #8 (QTY-1)
15513 - SQUEEZE LOCK FRAME
CONSISTING OF;
(1) 158963 HANGER FRAME
(1) 158962 CATCH PLATE
(1) 158967 CATCH PLATE PIN
(1) 154019 COTTER PIN

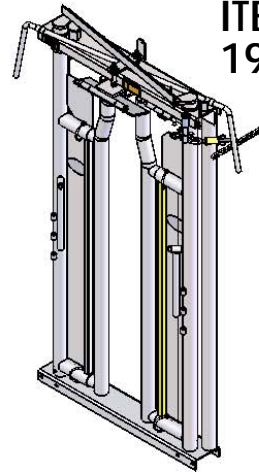
ITEM #6 (QTY-1)
158965 - SQUEEZE LOCK
MOUNT TUBE

15503 - CALVING PEN PARTS & ASSEMBLIES

SCALE 1:32

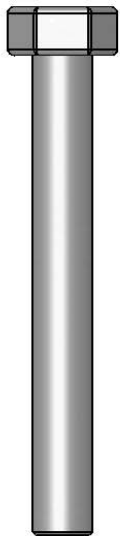


ITEM #5 (QTY-1)
168701 - STEP PLATE
(OPTIONAL)



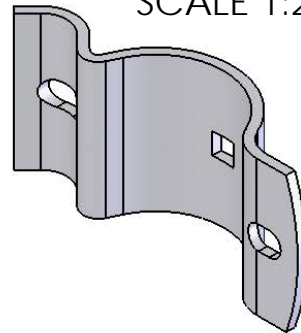
ITEM #9 (QTY-1)
191470PG - HEAD GATE
ASSEMBLY
(OPTIONAL)

SCALE 1:32



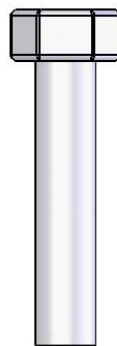
ITEM #12 (QTY-2)
157736 - 5/16" X 2 1/2" BOLT

SCALE 1:2



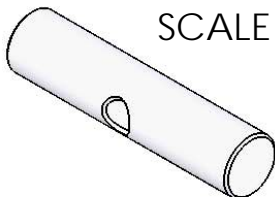
ITEM #13 (QTY-4)
168757 - 2" HINGE CLAMP

SCALE 1:1



ITEM #15 (QTY-2)
154014 - 5/16" X 1 1/2" BOLT

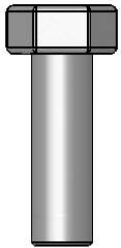
SCALE 1:2



ITEM #14 (QTY-2)
168756 - HINGE PIN

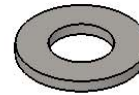
15503 - CALVING PEN PARTS & ASSEMBLIES

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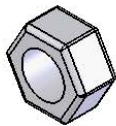
ITEM #16 (QTY-2)
157540 - 5/16" X 1" BOLT

SCALE 1:1



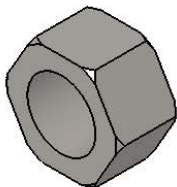
ITEM #17 (QTY-8)
154063 - 5/16" FLATWASHER

SCALE 1:1



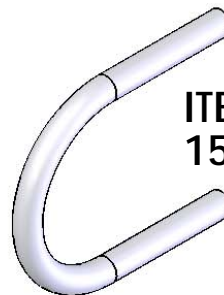
ITEM #18 (QTY-14)
154047 - 5/16" LOCK NUT

SCALE 1:1



ITEM #18 (QTY-4)
154054 - 1/2" NUT

SCALE 1:2



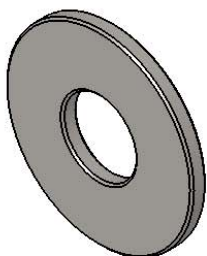
ITEM #10 (QTY-4)
158966 - 5/16" X 2" U-BOLT

ITEM #11 (QTY-8)
183488 - CONNECTOR CLIP

SCALE 1:6



SCALE 1:1



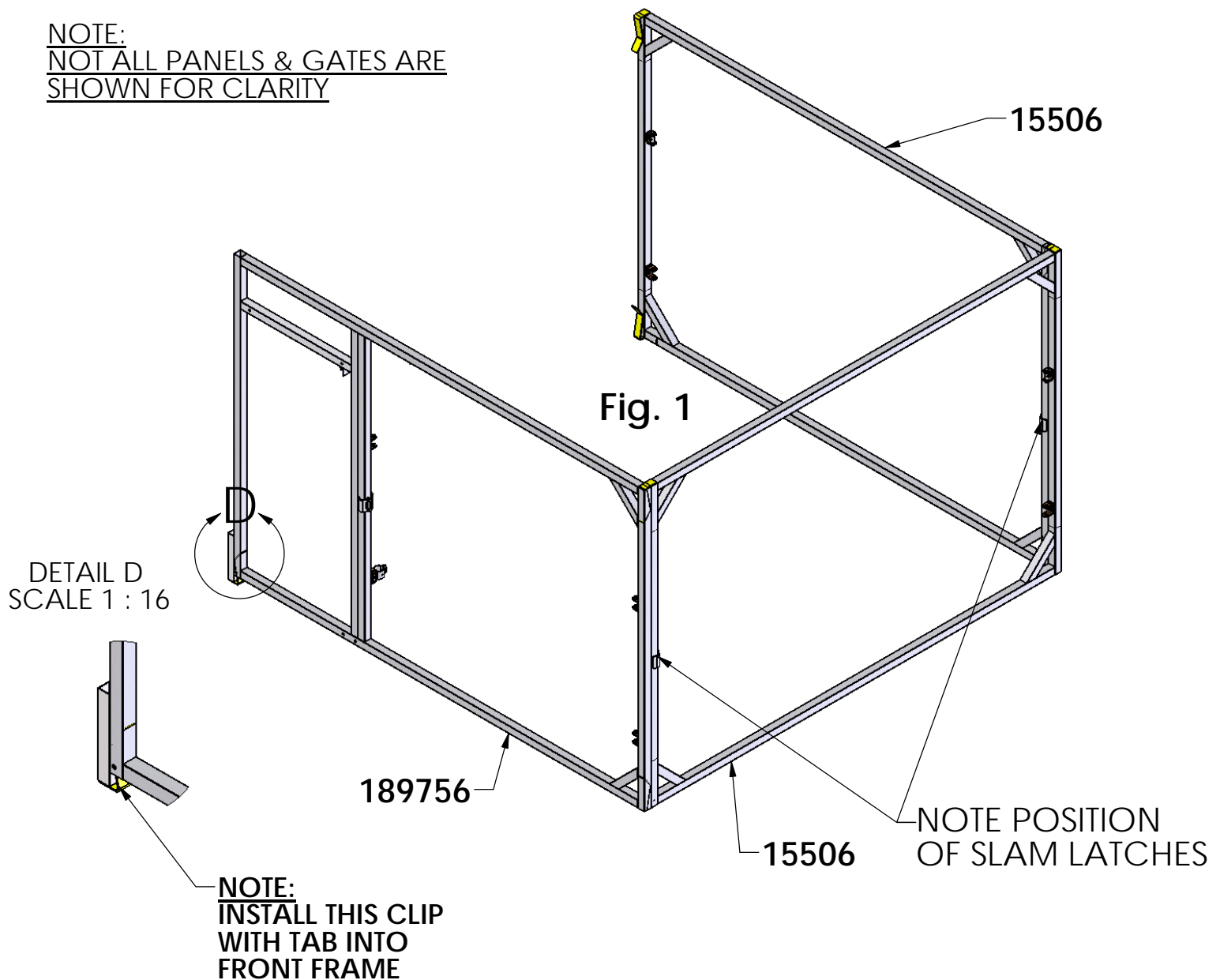
ITEM #19 (QTY-8)
154069 - 1/2" FLATWASHER

SCALE 1:1



ITEM #21 (QTY-4)
159524 - 1/2" X 3" BOLT

NOTE:
NOT ALL PANELS & GATES ARE
SHOWN FOR CLARITY

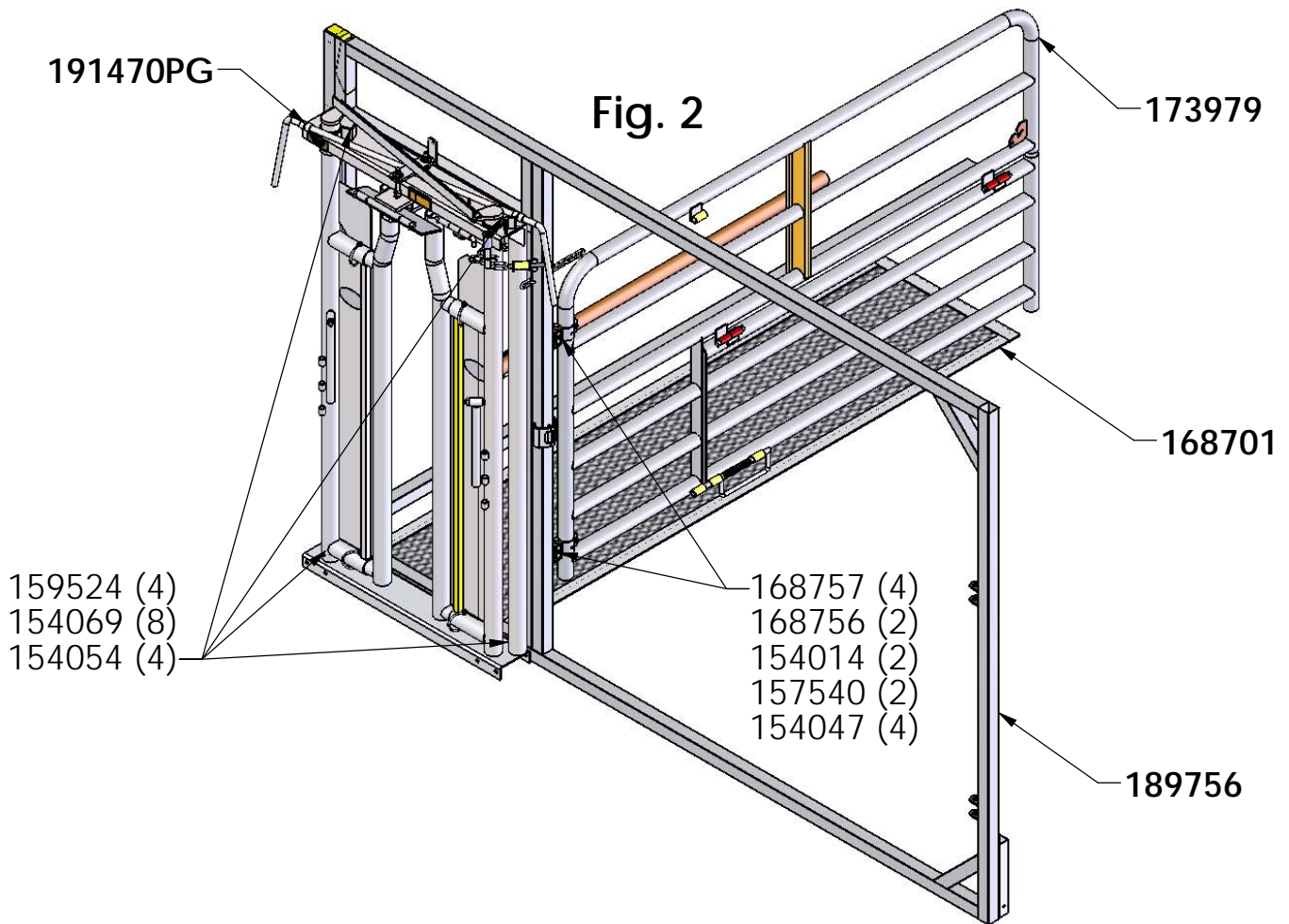


NOTE:
DO NOT REMOVE BANDING AND SUPPORT BLOCKING FROM PANEL
ASSEMBLIES UNTIL FURTHER INTO ASSEMBLY OF PEN.

STEP #1
 SELECT A SMOOTH LEVEL LOCATION FOR THE CALVING PEN ASSEMBLY.

STEP #2 Fig 1
 INSERT CONNECTOR CLIPS (183488) INTO BOTTOM RIGHT SIDE OF FRONT PANEL UPRIGHT. INSERT CONNECTOR CLIP (183488) INTO THE BOTTOM LEFT OF THE FRONT FRAME AS SHOWN. STAND THE FRONT PANEL ASSEMBLY (189756) UPRIGHT AS SHOWN. INSERT CLIP IN OTHER BOTTOM END OF THE (15506) STANDARD PANEL ASSEMBLY. SLIDE THE STANDARD PANEL OVER THE CLIP IN THE FRONT PANEL ASSEMBLY. INSERT CLIPS INTO TOPS OF THE TWO PANELS. REPEAT WITH THE REST OF THE CALVING PEN PANEL ASSEMBLIES.

NOTE:
NOT ALL PANELS & GATES ARE
SHOWN FOR CLARITY



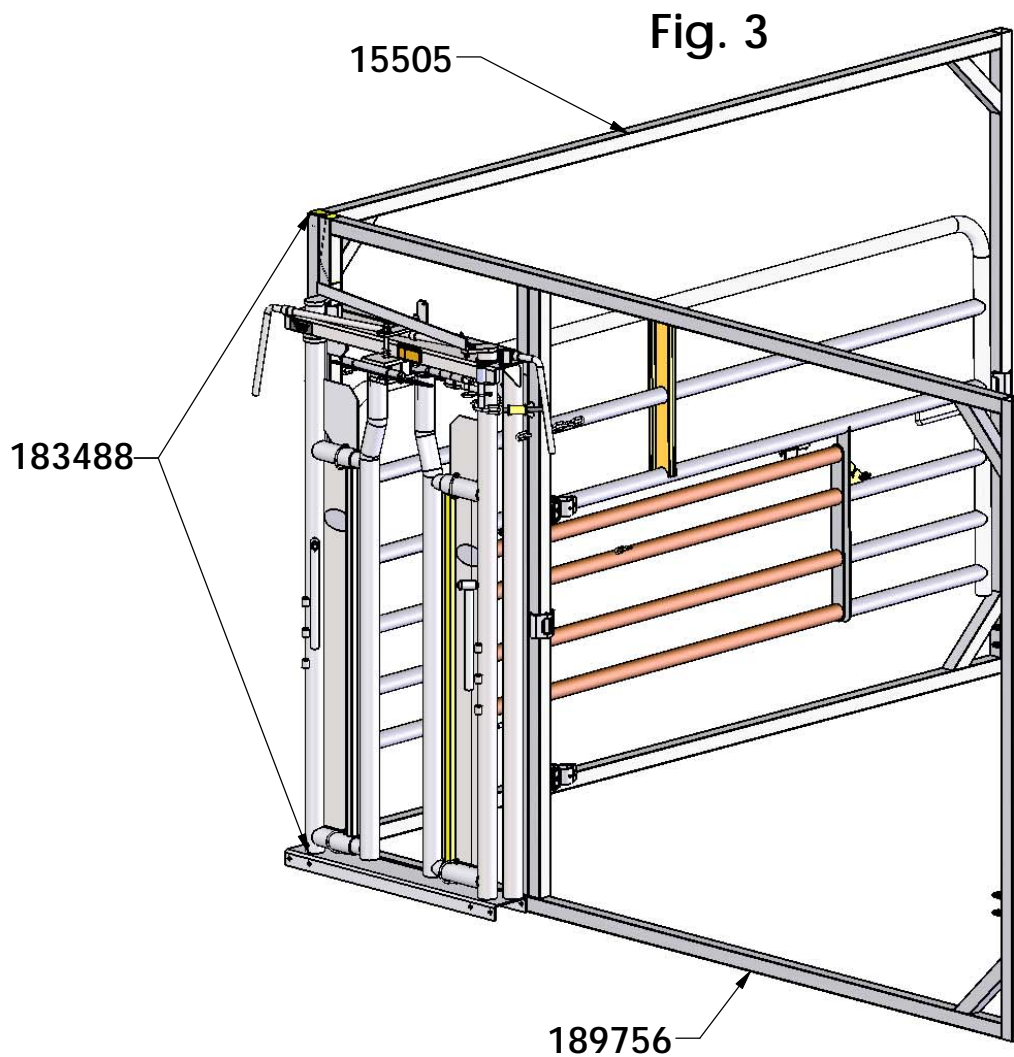
STEP #4 Fig. 2

INSTALL SQUEEZE GATE ASSEMBLY (173979) TO THE FRONT PANEL ASSEMBLY USING 4ea. HINGE CLAMPS (168757), 2ea. HINGE PINS (168756), 2ea. 5/16" X 1 1/2" BOLTS (154014), 2ea. 5/16" X 1" BOLTS (157540), & 4ea. 5/16" NUTS (154047).

STEP #5 (OPTIONAL HEADGATE & STEP PLATE ASSEMBLY)

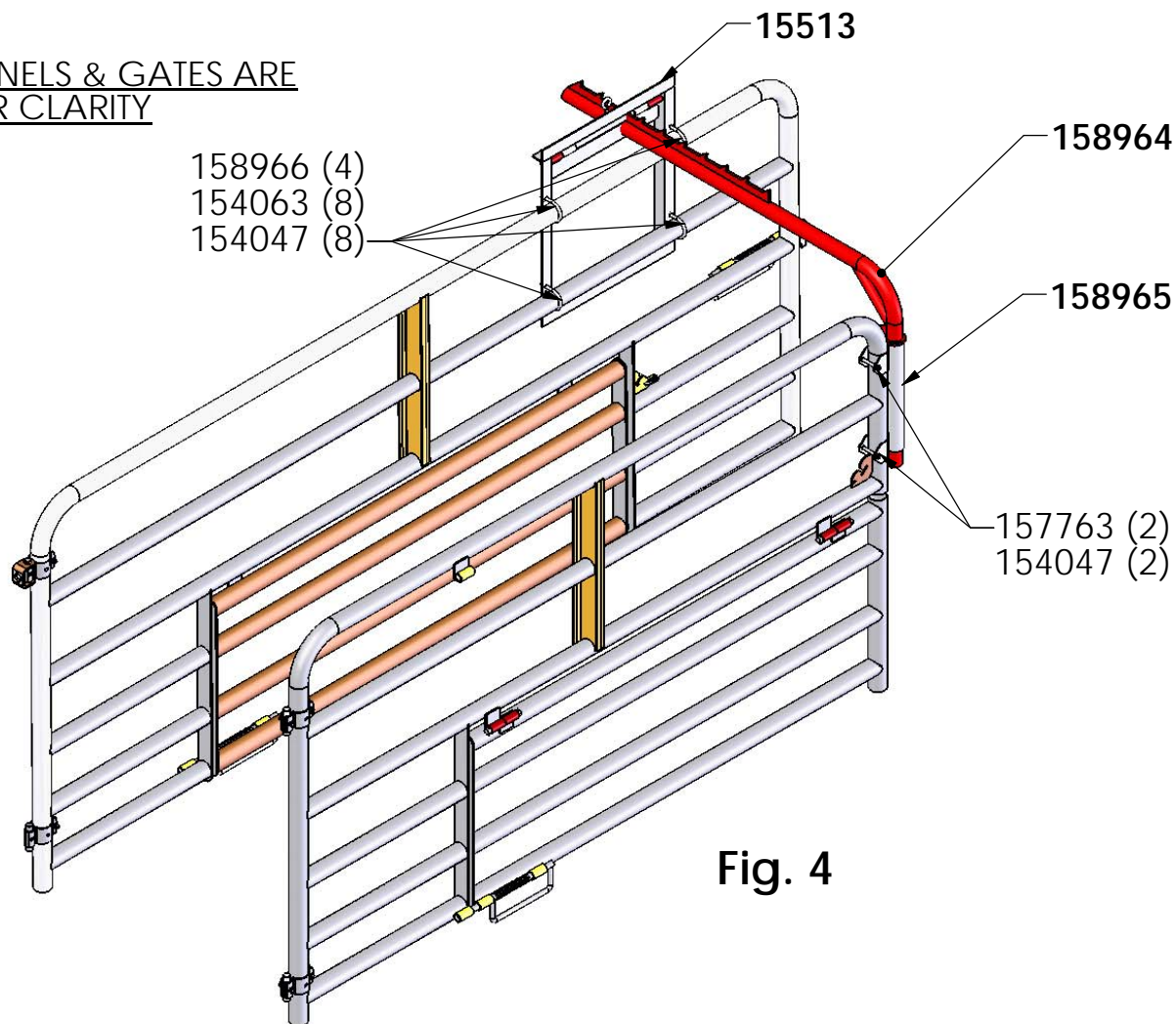
INSTALL STEP PLATE (168701) TO LOWER RAIL OF FRONT PANEL ASSEMBLY USING 2ea. 1/2" X 3" BOLTS (159524), & 2ea. 1/2" FLATWASHERS (154069) PASS BOLTS THROUGH STEP PLATE FRAME, LOWER RAIL OF FRONT FRAME AND THROUGH LOWER SLOTS IN HEAD GATE (191470PG) FASTEN WITH 2ea. 1/2" FLATWASHERS (154069) & 2ea. 1/2" NUTS (154054). ATTACH UPPER PART OF HEAD GATE TO THE FRONT PANEL USING 2ea. 1/2" X 3" BOLTS (159524), 4ea. 1/2" FLATWASHERS (154069), & 2ea. 1/2" NUTS (154054). INSTALL PANEL CONNECTOR (176230) IN LOWER LEFT CORNER OF HEADGATE FRAME.

NOTE:
NOT ALL PANELS & GATES ARE
SHOWN FOR CLARITY



STEP #6 Fig. 3
INSTALL THE NURSING GATE ASSEMBLY PANEL (15505) TO THE FRONT PANEL ASSEMBLY (189756) USING 2 (183488) CONNECTOR CLIPS. CHECK ALIGNMENT OF THE FOUR PANEL ASSEMBLIES

NOTE:
NOT ALL PANELS & GATES ARE
SHOWN FOR CLARITY



STEP #7 Fig. 4

**ATTACH SQUEEZE LOCK FRAME (15513) TO THE NURSING GATE AS SHOWN USING 4ea. 5/16" X 2" U-BOLTS (158966), 8ea. 5/16" FLATWASHERS (154063), AND 8ea. 5/16" LOCK NUTS (154047).
HAND TIGHTEN HARDWARE.**

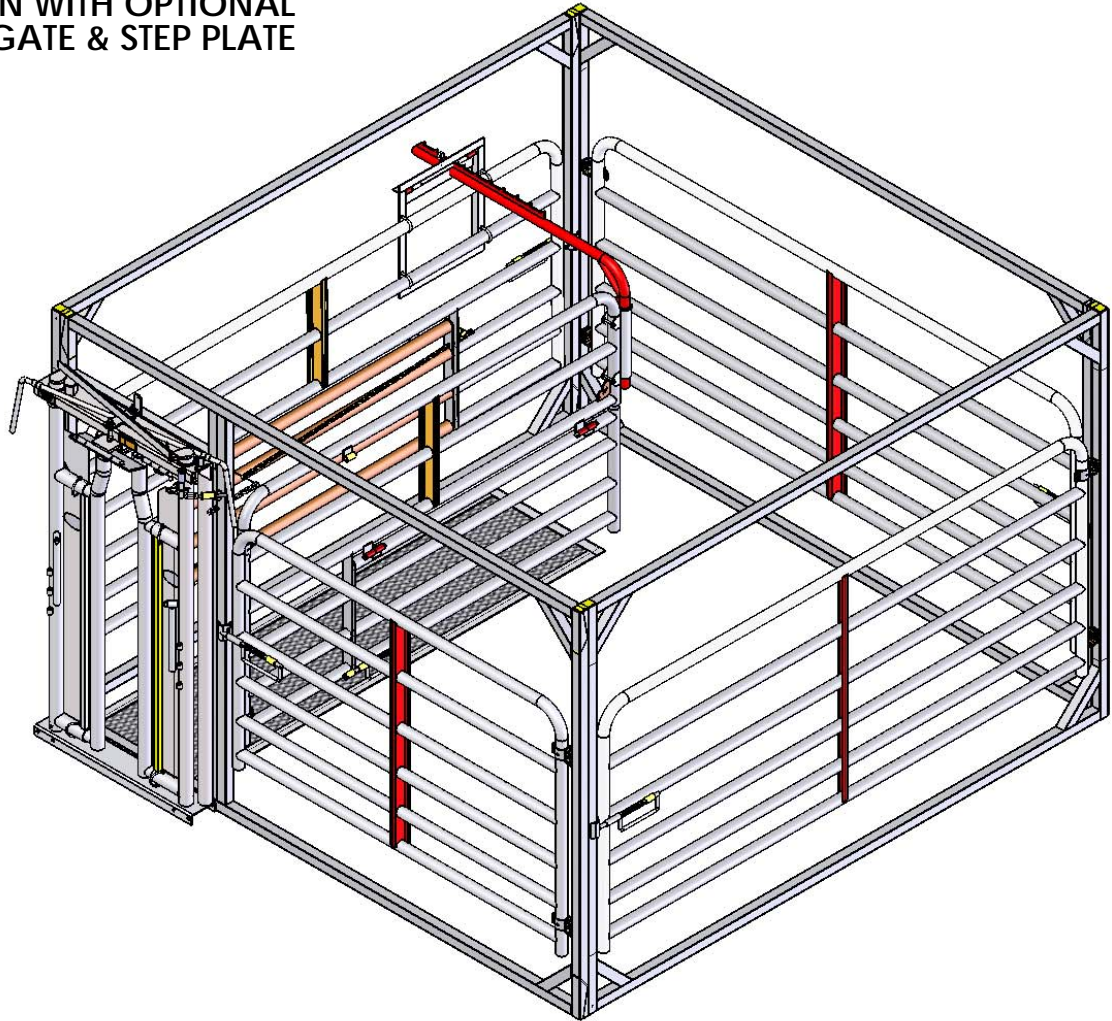
STEP #8 Fig. 4

**ATTACH SQUEEZE LOCK MOUNT TUBE (158965) TO THE UPPER SECTION OF THE SQUEEZE GATE ABOVE THE SWING GATE. USING 2ea. 5/16" X 2 1/2" BOLTS (157736), AND 2ea. 5/16" LOCK NUTS (154047).
HAND TIGHTEN HARDWARE.**

STEP #9 Fig. 4

INSERT SQUEEZE LOCK RATCHET (158964) INTO SQUEEZE LOCK MOUNT TUBE AS SHOWN. ADJUST HEIGHT OF RATCHET SO THAT IT EASILY CLEARS THE TOP OF THE NURSING GATE. TIGHTEN HARDWARE ON THE MOUNT TUBE. SWING SQUEEZE GATE ALL THE WAY TO THE NURSING GATE MAKING SURE RATCHET CLEARS THE SIDES OF THE SQUEEZE LOCK FRAME. TIGHTEN HARDWARE ON SQUEEZE LOCK FRAME.

Fig. 5
SHOWN WITH OPTIONAL
HEADGATE & STEP PLATE



STEP #10 Fig. 5

REMOVE ALL BANDING AND GATE SUPPORT BLOCKING FROM THE FOUR PANEL ASSEMBLIES. ADJUST ALL GATES SO THE SPRING LATCH PINS STRIKE THE CENTER OF THE SLAM LATCH PLATES.

STEP #11 Fig. 5

GO THROUGH ENTIRE ASSEMBLY AND TIGHTEN ALL HARDWARE CHECKING FOR FREEDOM OF MOVEMENT AND ALIGNMENT OF ALL COMPONENTS. ATTACH ROPE (158979) TO THE CATCH PLATE ON THE SQUEEZE LOCK FRAME, RUN END OF ROPE THROUGH THE EYE OF THE EYE-BOLT ON THE TOP OF THE SQUEEZE LOCK FRAME AND OVER THE TOP OF THE NURSING GATE PANEL ASSEMBLY.

LIMITED WARRANTY

Sioux Steel Company warrants to the original purchaser only that the products manufactured by Sioux Steel Company are free from defects in material and workmanship under normal use and service and when properly installed for a period of one (1) year from the date of purchase. If such a defect appears during the term of this warranty, Sioux Steel Company will, at its option, repair or replace at its factory any part or component determined to its satisfaction to be defective. All transportation charges shall be paid by purchaser.

This warranty does not apply to defects or damage from: (a) installation that is improper and/or not in accordance with the instruction manual; (b) improper or inadequate maintenance; (c) modification or alteration of the product; (d) neglect, misuse, or abuse of the product; (e) accident; (f) unauthorized repair or alteration; (g) transportation of the product from Sioux Steel Company to the customer; (h) exposure to corrosive elements; (i) EXPOSURE TO CONDITIONS IN EXCESS OF DESIGN SUCH AS ANIMALS HEAVIER THAN 1000 POUNDS; and (j) an act of God. No warranty is given by Sioux Steel Company for parts, components, or trade accessories furnished by Sioux Steel Company but not manufactured by it. They are covered by the warranty of their manufacturer, if any.

THIS LIMITED WARRANTY IS THE EXCLUSIVE WARRANTY GIVEN BY SIOUX STEEL COMPANY AND SUPERSEDES ANY PRIOR, SUBSEQUENT, CONTRARY OR ADDITIONAL REPRESENTATIONS, WHETHER ORAL OR WRITTEN. THERE ARE NO OTHER IMPLIED OR EXPRESS WARRANTIES FOR THE PRODUCT, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND/OR FITNESS FOR A PARTICULAR PURPOSE.

NEITHER SIOUX STEEL COMPANY NOR ANY OF ITS DEALERS, DISTRIBUTORS OR AGENTS SHALL BE LIABLE FOR ANY SPECIAL, EXEMPLARY, INDIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES OF ANY KIND, INCLUDING BUT NOT LIMITED TO DAMAGES FOR BODILY INJURY, DEATH, OR PROPERTY DAMAGE, LOSS OF PROFITS, LOSS OF TIME, LOSS OF ANIMALS, INCONVENIENCE, OR THE USE OR INABILITY TO USE THIS PRODUCT FOR ANY PURPOSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT, STRICT LIABILITY, OR ANY OTHER LEGAL BASIS ARISING FROM OR IN ANY WAY RELATED TO PURCHASER'S USE OR PURCHASE OF THE PRODUCT. THE MAXIMUM LIABILITY OF SIOUX STEEL COMPANY AND ITS DEALERS, DISTRIBUTORS AND AGENTS SHALL NOT EXCEED THE ACTUAL PURCHASE PRICE PAID BY THE PURCHASER FOR THE PRODUCT.

NO PERSON, FIRM, OR CORPORATION INCLUDING THE SELLING DEALER IS AUTHORIZED TO ASSUME FOR SIOUX STEEL COMPANY ANY OTHER LIABILITY OR MAKE ANY OTHER WARRANTY IN CONNECTION WITH THE SALE OF THESE PRODUCTS.

This limited warranty, and all terms and conditions set forth herein, shall be governed by the laws of the State of South Dakota and, where applicable, the laws of the United States of America. Any and all disputes arising from this limited warranty, the product, the purchaser's use of the product, or otherwise shall be venued in the South Dakota Circuit Court for the Second Judicial Circuit in Minnehaha County, South Dakota, and the Purchaser agrees to such venue and waives any challenge to such court's jurisdiction based upon lack of personal jurisdiction of inconvenience.

In the event of a warranty claim, the original purchaser must notify Sioux Steel Company of the claim by Registered or Certified Mail, Return Receipt Requested, within 30 days after discovery to:

Sioux Steel Company
196 ½ East 6th Street, PO Box 1265
Sioux Falls, SD 57101-1265
Attention: Warranty Department

The purchaser shall cooperate fully with Sioux Steel Company in the investigation of such claim, or the claim may be deemed waived. Any defective part or component must be returned to the factory at the purchaser's expense for inspection by Sioux Steel Company.

RETURN GOODS AUTHORIZATION (RGA)

Any product returned to Sioux Steel Company for warranty or non-warranty consideration must have an RGA number assigned to the product and tagged onto the product that is to be returned. ANY PRODUCT BEING RETURNED WITHOUT AN RGA NUMBER WILL BE REFUSED. IT IS THE PURCHASER'S RESPONSIBILITY FOR ANY TRANSPORTATION CHARGES. NO C.O.D.'S WILL BE ACCEPTED. An RGA number can be obtained by calling the Warranty Department at 1-800-557-4689.

Please have the following information available:

- Why are items being returned?
- Territory Representative or inside sales contact.
- Invoice number and date.
- Part number, description and quantity.
- Dealer ID number.
- Contact name, phone number, fax number and e-mail address.
- When will items be returned?

Custom built, special order or obsolete equipment may not be returned.

There will be a 10% restocking charge on all equipment authorized for return unless the equipment is under warranty, or was shipped incorrectly. If the equipment requires repainting or repackaging, a 25 % restocking and refurbishing charge will apply.