

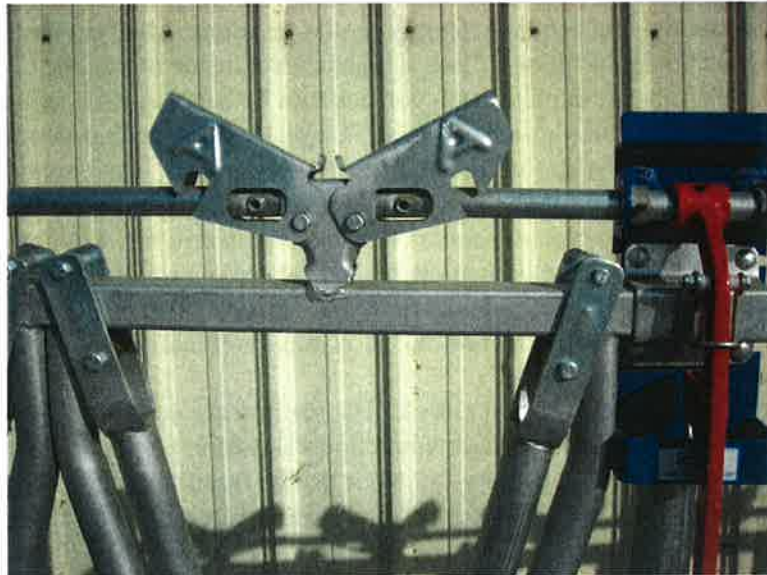
# ACCU-LOCK



#1



#2



#3



Patent No: 6,776,124; 6,834,620 & 7,353,778B2

## ACCU-LOCK GENERAL INSTALLATION GUIDE

For mature cows and heifers, normal specifications call for 16" from cow stand floor to top of curb, and about 13"-14" on feed side. Using these numbers, place two 2 x 4 pieces flat on top of each other on the curb about 12" away from the poles on the curb where the section will set. Looking at the section, you wouldn't think it matters which way you turn the section, but it does. **Always install the section with the panel bolt heads facing the feed side.**

Once you have your first panel up, and as you put the second panel up, always keep the end of the section frame (toward the next panel you are putting up) at the center of the post, or less. Before putting the clamps on, slide the small piece of galvanized channel provided over the tubing, centered on the joint where they come together, between the face of the post and the sections – then place the clamps provided and bolt together with 5/16" x 1-1/2" carriage bolts with nuts. **The toprail has to slide together at the same time you bring the stanchions together.**

It is usually best to leave blocks under the sections with the bolts finger-tight until the entire run is up. You will then be able to raise or lower certain sections as required to make sure the sections are straight. Then tighten all bolts and remove blocks. A straight corral not only looks better, but is important for the smoothest operation of the headlocks. We also recommend a 1/2" tack-weld underneath the top post clamp to the post to eliminate any chance of sag.

**Before you start installation, read handle instructions and location.**

## ACCU-LOCK HANDLE ASSEMBLY INSTRUCTIONS

Picture #2 - Shown is handle assembly which includes (1) 5" x 11" x 3/16" plate with pre-punched holes to fit stanchion mounting clamps. Plate has (1) higher bracket with pre-punched holes for the stanchion toprail, and (1) lower bracket that serves as a handle "lock".

**We recommend a maximum of 20 sections per handle, and that the handle be mounted as close to the center of the run as possible,** which will better distribute any "twisting" that could occur if the handle was on the end of the run. Mount the plate as shown in picture #3. **You will need to determine your handle location before you install your stanchions, as the bracket, handle arm, and collars will have to be put on the toprail as you install your sections.** Once your run is installed, the handle assembly should be adjusted and set first. You may slide the handle arm to the left or right to avoid the toprail splice. Note, collars are set inside or outside of blue bracket.

Leaving the handle in the position shown in picture #2, you can turn by hand, or take a vise grip and clamp to the toprail and turn the pipe so that the toprail pins are as shown in picture #3. The pins should be sticking out facing the cow side. **Visually center the pin in the slot on the lockhead** (picture #3). **Also, note the slot is parallel with the top rail, and all panels should be set the same.** Then, leaving the handle as shown in picture #2, tighten the set screw provided on the handle arm, and tighten the collars as shown in picture #3. You may release your vise grip, lift up the handle arm as shown in picture #2, and tighten the second set screw provided on the handle arm. You may then start welding the toprail together. **It is very important that you center the pin in the slot, and lift up each rail the same as you did when you adjusted and set the handle!** It is important that the lockheads are lifted to a height that brings the large oval slot parallel with the toprail.

You have two positions with this handle - lock and unlock. Handle arm down and locked with ring lock as shown in picture #3 is feed position, and up and locked in place with clip as shown in picture #2 is lock position. Probably not necessary if tightened properly, but once you are sure your handle installation is correct, you may tack-weld each side of the handle arm to the toprail to insure no slippage will occur because of loosening of the set screw. Do not tack-weld collars.

**Any questions? Call (800) 872-5441**