

GROUP FEEDING ROLLING PEN ASSEMBLY INSTRUCTIONS



Step#1 Install 2 side rails , there is 1x left and 1x right . Install each rail on the lowest side step on the group hutch body . Make sure the 3 holes in the side rail are facing the front of the group hutch. Mark and drill the bottom hole from the side rail as shown above. Then install one 3/8' x1'' hex bolt from outside with 3/8'' standard washer and nylon lock nut from the inside just hand tighten until step 3 is done.



Step#3 Once plumb mark and drill a 3/8 " hole on both end brackets as shown. Then install two 3/8" x 1" hex bolts and two 3/8" fender washer and two 3/8 nylon lock nuts from the inside. Tighten nuts and **also tighten the bolt and nut from Step#1**



Step#2 Make sure side rails are plumb by using a level . (Note: this is very im-



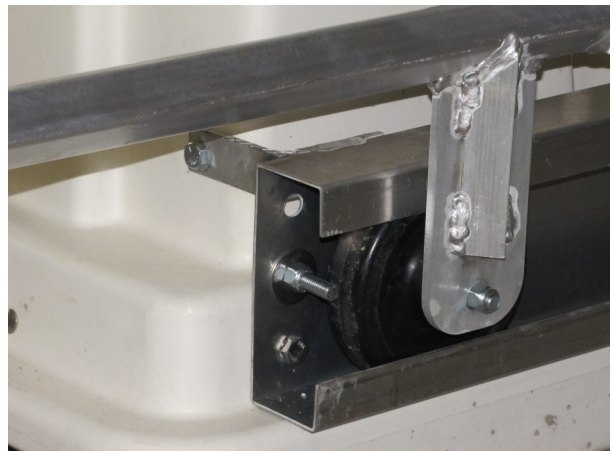
Step#4 Lock plate installation . There are two lock plates to install. Measure from edge 10.5" as shown above.



Step#5 Mark and drill two 3/8" holes as shown. Install two 3/8' x 2.5" hex bolts. Then install from the inside two 3/8' fender washer and two 3/8" nylon lock nuts and tighten .



Step#6 Install two 5" plastic wheels on support brackets on rear of side gate. Install one 3/8" x 3" hex bolt with 3/8 washer. Then on other side of wheel install 3/8" flat washer and 1/2 nut as spacer.



Step#7 Insert wheel in side rail as shown then install 3/8 nylon lock nut then tighten. Next install 3/8" x 1.5 hex bolt with two 3/8 flat washer on each side then install 3/8" lock nut. This bolt prevents the wheels from falling out of the side rails. Repeat this step on opposite side.



Step#8 With both side wheels installed on the side gates the next step is to install the front feeding panel



Step#9 Install 4 x 3/8" x 1.5 hex bolts , 4 x 3/8" flat washers and 4 x 3/8" nylon lock nuts. Repeat this step on opposite side as well. Do not tighten until **Step#11**



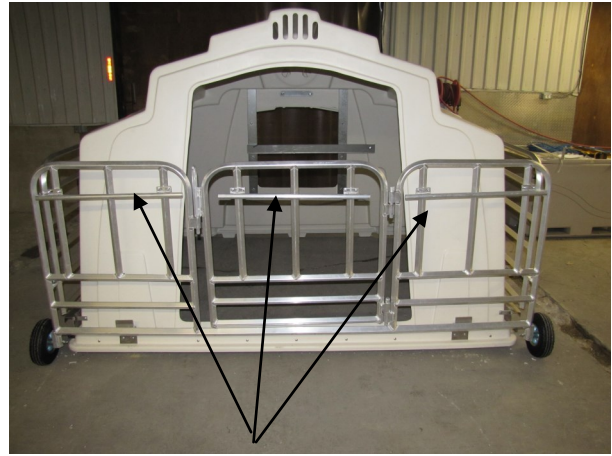
Step#9 Install both front wheels to front feeding pane. Use 1/2" x 7 " hex bolt with 1/2" washer on both sides of the wheel housing then install 1/2" nylon lock nut and tighten.



Step#10 Push front panel all the way in .Make sure the whole front panel is against the group hutch.



Step#11 Tighten all 8 bolts as shown above.



Step#12 Install 3 x adjustable head rails as shown above. Install 6 u bolts and 6 5/16 lock nuts. Adjust to desired height.



Step#12 Install feed and water troughs as shown above.



Step#13 Install side hutch brackets, Measure 1 1/2" from side and 6 inches from bottom as shown . Mark and drill two 3/8 holes then install 2 x 3/8" x 1 hex bolts from outside. Install 2 x 3/8" fender washer and 2 x 3/8" nylon lock nuts from the inside. Repeat this step on opposite side



Step#14 Install lift kit. Install top swivel first using 1/2" x 1 hex bolt with 1/2 nylon lock nut. Then place lift kit bracket as shown above. Mark and drill 3/8" hole in all 6 locations



Step#15 Install plate on inside as shown using 3 x 3/8" fender washer and 3 x 3/8" nylon lock nuts and tighten.