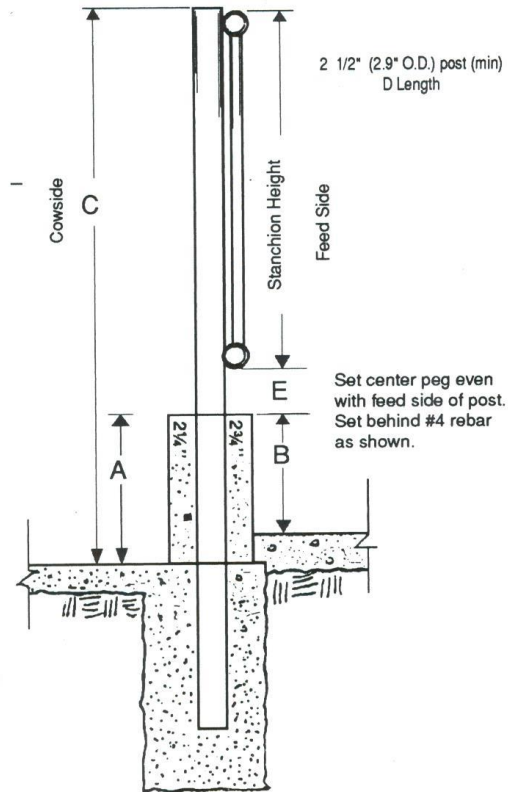


# CURB MEASUREMENT

COW	BREEDING SMALL		
	HEIFER	HEIFER	CALVES
A 16" - 19"	16"	14"	12"
B 13"	13"	11"	9"
C 60"	58"	50"	45"
D 38 1/4"	35 1/2"	32 1/8"	29"
E 4"	3"	2"	2"





# DaSilveira Southwest, Inc.

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Before you begin installing your stanchions make sure that you have received the correct amount of stanchions and handles. The first thing you must consider is where you want the handle to be placed. It is advised that you place the handle in the middle of each "Run" that you wish to operate. Do not operate more than 100 holes per handle, or 50 holes on each side. This allows for equal changes in the length of the Lock Rail due to

1. On each set of U-Bolts attach one nut on each threaded side. Thread the nut all the way until it comes to a stop.



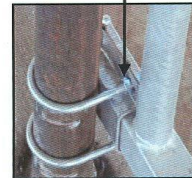
2. Begin by placing two 2x4 boards on top of each other at each end of the first curb. This will give you the approximate amount of spacing needed between the curb and the bottom of the stanchion. Refer to the Curb Measurement Chart for accurate measuring.

3. Place the stanchion on top of the boards.



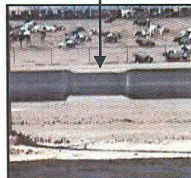
4. Place a clamp set around the Top Rail. Take a U-Bolt place it around the back of the post and through the top two holes of the clamp. Loosely tighten the clamp to the post and stanchion with the nuts provided. Place another U-Bolt around the back of the post and through the bottom two holes of the clamp. Loosely tighten the clamp to the post and stanchion with the nuts provided. Repeat this step for each clamp.

Nuts in the back.

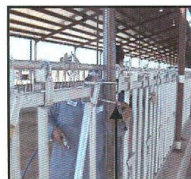


5. Place another set of two 2x4 boards on top of each other at each end of the next curb.

Lock Rail Inserted



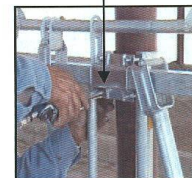
6. Place the next stanchion on top of the boards and slide the Top and Bottom Rails into the already mounted clamps. You may also insert the Lock Rail into the Lock Rail of the previous stanchion.
7. Repeat steps 4 through 6 until all the stanchions have been loosely mounted to the posts. Remember to place the stanchion with the handle in the center. For example: If you are mounting 20 stanchions in one "Run" the stanchion with the handle should be the 11<sup>th</sup> stanchion mounted.



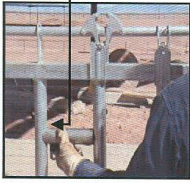
Leveling the U-Bolts

8. After you have loosely mounted each stanchion go back to the beginning of the "Run." You will now begin leveling the stanchions. Make sure that each stanchion is relative to the next stanchion and that both stanchions are leveled. Once the stanchion is level you can level and securely tighten the U-Bolts of the clamp.
9. Continue step 8 until the entire "Run" is leveled and all the U-Bolts have been securely tightened.

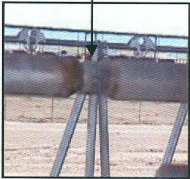
Tightening the U-Bolts



**Vertical Fence Bar**



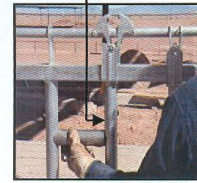
**Lock Rail Welded**



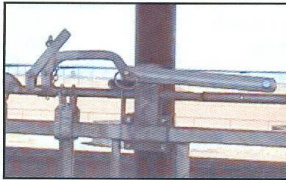
10. Go back to the handle and set it to the Self-Locking position. Measure the distance between the stationary Vertical Fence Bar and the Pivot Bar. Refer to the chart below to ensure that the measurement is correct. This distance should be the same at the top and bottom.

11. Go to the next stanchion on either side, or you can have two people working their way out from the stanchion. Place all the Pivot Bars between the Latching Sleeves so that they are in the locked position. You will move the Lock Rail until the measurement between the stationary Vertical Fence Bar and the Pivot Bar are the same as the stanchion with the handle. You will also need to make sure that the Lock Rails are in perfect alignment and leveled vertically and horizontally. When this is correct you may weld the two Lock Rails together. If this is not done properly than your handle will not operate correctly.

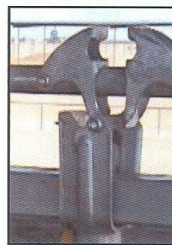
**Pivot Bar**



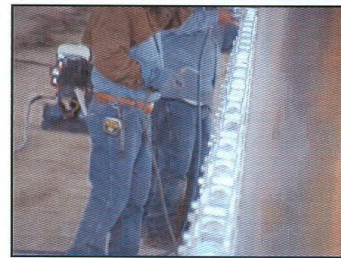
**Handle in Self-Locking Position**



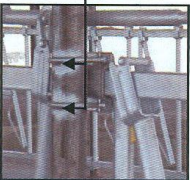
**Pivot Bar Between Latching Sleeves**



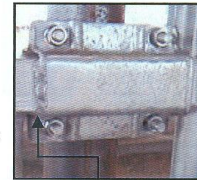
**Latching Sleeves Perfectly Aligned**



**Welds on Bottom**



12. At the same stanchion, that you just finished welding the Lock Rails together you may also weld the U-Bolts to the post. It is only necessary that you weld the under parts of the top two U-Bolts at least ¼". At this time you will weld one side of the clamp to the Top and Bottom Rails. To determine which side you will weld refer to the stanchion with the handle. Which ever side of the stanchion is welded to the clamp will be the same side you should weld. The weld will only be on the front part of the Top and Bottom Rails, and will be the entire length of the part facing you.



13. Repeat steps 12 and 13 until all stanchions in the "Run" have been properly set. You have now completed your installation.

**Clamp Welded to Top Rail**

Stanchion Size	Type of Stanchion	Distance Between Bars
4 Holes in 10'	Regular	6 ¼"
4 Holes in 10'	Adjustable	6 ¼"
4 Holes in 9'	Regular	6 ¼"
4 Holes in 9'	Adjustable	6 ¼"
4 Holes in 8'	Regular	6 ¼"
4 Holes in 8'	Adjustable	6 ¼"
5 Holes in 11'	Regular	6 ¼"
5 Holes in 11'	Adjustable	6 ¼"
5 Holes in 10'	Regular	6 ¼"
5 Holes in 10'	Adjustable	6 ¼"
6 Holes in 10'	Regular	6"
6 Holes in 10'	Adjustable	5 ½"
7 Holes in 10'	Regular	6"
7 Holes in 10'	Adjustable	5 1/8"
8 Holes in 10'	Regular	5 ½"