415 Osage Avenue, Kansas City, KS 66105
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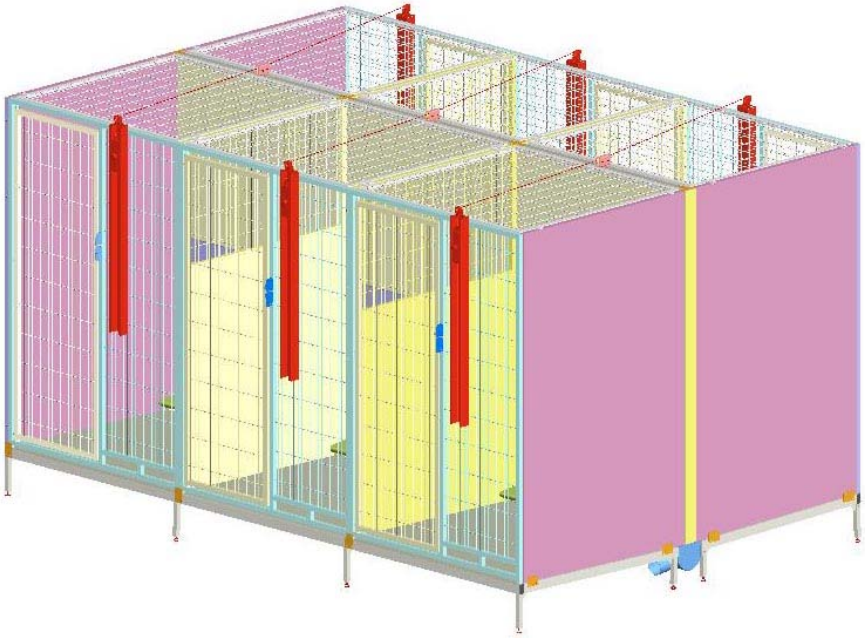

Double Kennel Installation on Raised Floor

PN:006.5100.01
Updated: 8-1-2014

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INTRODUCTION

Thank you for placing your trust in T Kennel Systems. T Kennel values you as a customer and will do everything we can to provide quality products and service, to assure your experience with T Kennel is a pleasant one.

The animal kennel system you have purchased has been precision made and shipped according to your instructions. Once assembled, your system will look custom built and especially made for your animal holding area.

For your personal safety, the safety of your workers, the public safety, and to maintain your kennel system it is very important to read and follow all instructions.

KENNEL INSTALLATION MANUALS ARE AVAILABLE FOR:
Single Kennel Installation on Raised Floor
Double Kennel Installation on Raised Floor
Single Kennel Installation on Concrete Floor
Double Kennel Installation on Concrete Floor

SAFETY FIRST:

| ▲ | CAUTION | Kennels are heavy and precautions must be taken to protect from personal injury. Get help when lifting heavy parts.

| ▲ | CAUTION | Edges of steel and stainless steel kennels and parts may be sharp. We recommend that you always wear protective gloves during unloading, inspection and assembly.

| ▲ | WARNING | T Kennel products are designed for animal use only. Never allow a person in or on your Kennel Assembly.

A. Tools Required (Not Included)

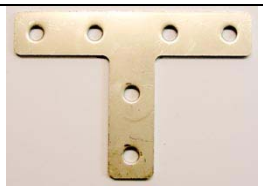
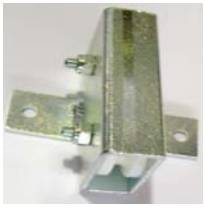
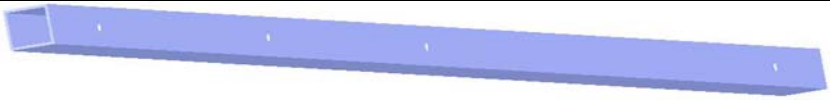
This list of tools is the minimum required to install/assemble your Kennels. Depending on your facility and kennel configuration, you may need additional tools and/or specialty tools.

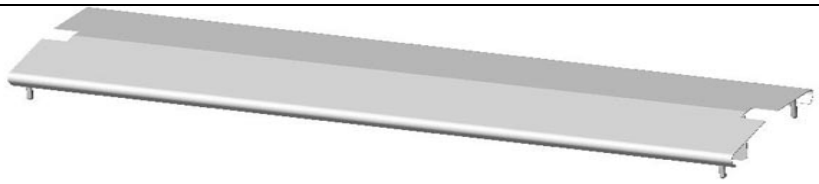
 RATCHET/SOCKET WRENCH WRENCH 5/16" AND 7/16"	 C-CLAMP VISE GRIP
 7/16 COMBINATION WRENCH	 FOUR FT. LONG LEVEL
 5/16" HEX HEAD DRIVER	 SAUSAGE GUN Only required if Sealant Sausages are provided
 SCREW GUN	 WIRE CRIMPING TOOL 3/32" FERRULE
 CAULKING GUN	 WIRE CUTTER

Other Tools: Tape Measure, Straight-Line (Laser or String), Pry-Bar, Screw Driver, Hammer, Chalk Line, Saw Zall with Bi-Metal Blade, Hammer Drill with concrete Bit, Tin Snip and Hacksaw.

B. Kennel Assembly Hardware

The hardware pictured below is for the assembly of T Kennel's standard Single Kennel System. Your hardware may vary depending upon your kennel configuration, building design, etc. Please feel free to call our Sales Department or Tech Services Department if you have any questions.

 041.0069.02 STRIKER BAR	 731.0000.00 LATCH ASSEMBLY-LH	 041.0087.00 BRACKET-LH	 041.0087.01 BRACKET-RH
 061.1010.00 #12X1 TEK SCREW	 061.1020.01 #12X2 TEK SCREW	 062.2515.00 1/4-20X1.5 CAP SCREW	 064.2500.22 1/4-20 NYLOCK NUT
 041.0071.00 4-HOLE PLATE	 062.2510.22 LEG LEVELER 1-1/2 LG	 051.0000.22 CAP PLASTIC 1X2	 060.5000.00 SCREW ½ FL WASHER
 300.1333.00 X-BRACKET	 300.1334.00 T-BRACKET	 731.0000.01 LATCH ASSEMBLY-LH FOR GLASS GATE PANEL	 043.0004.01 SLEEVE (FERRULE)
 PULLEY BRACKET ASSEMBLY	 PULLEY BRACKET ASSEMBLY FOR THE REVERSE GATE PANEL	 COUNTERWEIGHT	 O58.1005.00 KNOB ¼-20X3/4 STUD
 COUNTERWEIGHT GUIDE			
 KING POST			
 PVC STRIP 3" WIDE X 96" LONG X 3/32" THICK	 178.0009.00 TAPE, 2 FACE	 182.00007.00 DRAIN PATCH	

 FULL T-COVER			
 178.0008.00 ADHESIVE E6000, TUBE *CAULKING GUN REQUIRED*	 SIKAFLEX SEALANT TUBE *CAULKING GUN REQUIRED*	 SIKAFLEX SEALANT SAUSAGE *SAUSAGE GUN REQUIRED*	 SIKAFLEX PRIMER 016.0001.00

C. Floor and Drain Assembly

1. Set each floor in an upright position **(Figure 1)** to install leg-leveling screws **(Figure 2)** into legs of all floors.

Figure 1

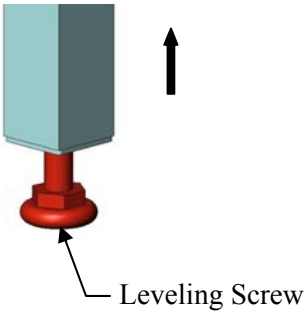


Figure 2

Floor Identification: Please familiarize yourself with the different types of floors **(Figure 3)** that are used in a run of kennels.

Start Floor:
All Kennel runs will begin with a Start floor. This floor will have a total of 4 or 6 legs placed on both sides of the floor frame and will stand on its own. This floor is 1/2" wider than the width of your kennel gate panel. Example: A 48” wide kennel will require a 48 ½” Start Floor. The Start floor is only used once per row of kennels and is always placed on the left hand side. (Your kennels are designed to be assembled working left to right)

Center Floor(s):
Runs of 3 or more kennels will have a Center floor(s). This floor will have 2 or 3 legs located on the right hand side of the floor when viewed from the front. This floor will be the exact width of your kennel gate panel. Example: A 48” wide kennel will require a 48” Center floor.

End Floor:
Runs of 2 or more kennels will have a End floor. This floor will have 2 or 3 legs located on the right hand side of the floor when viewed from the front. This floor is 1/2" wider than the width of your kennel gate panel. Example: A 48” wide kennel will require a 48 ½” End Floor. The End floor is only used once per row of kennels and is always the last floor in the row located on the right hand side.

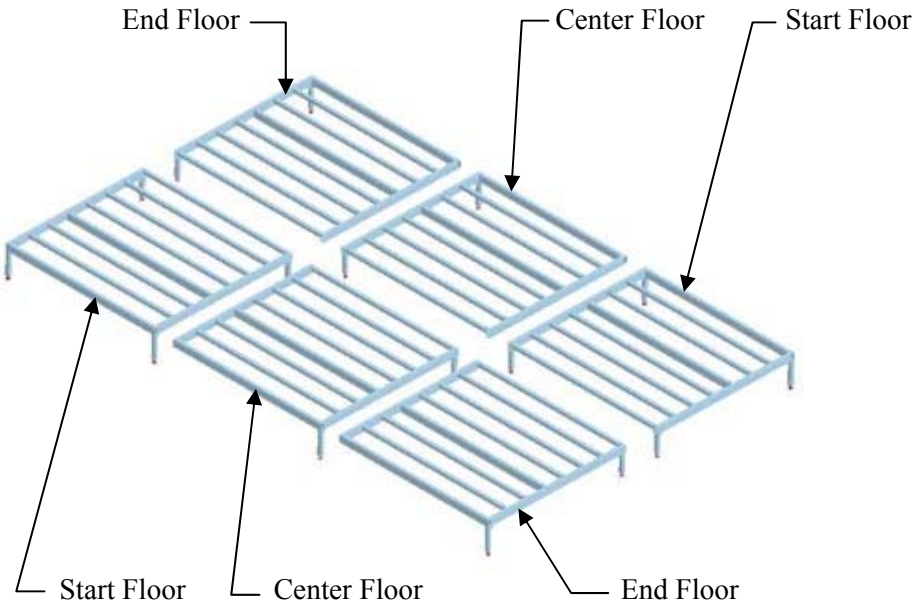


Figure 3

Note: Be sure to keep the top and front surfaces flush using C-Clamps to hold the floors in place until you have installed 2” Tek screws.

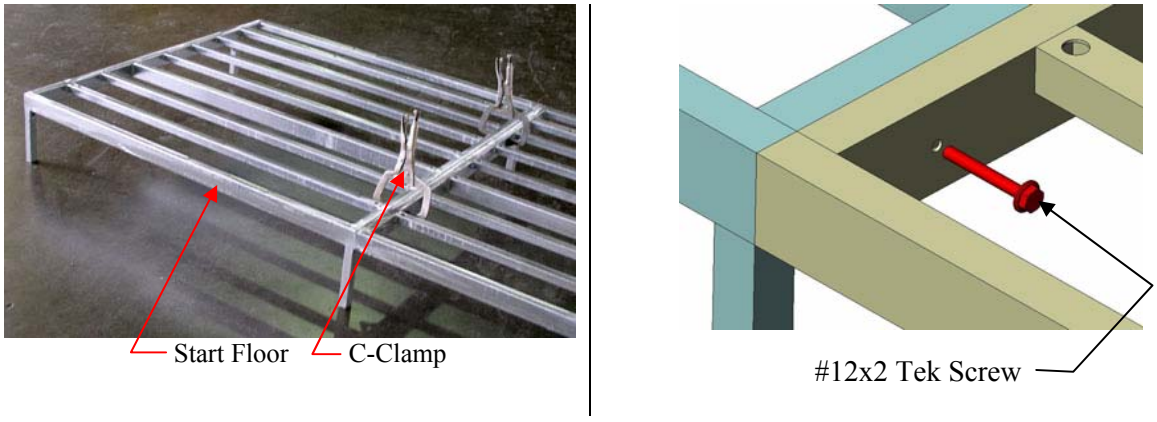


Figure 4

2. Arrange floors starting with the Start Floor (four or six-legs) on the far left. Attach a Center Floor (two or three legs) to the first Start Floor as shown in **(Figure 4)**, using 2” Tek Screws at the pre-drilled holes. Use the same method to attach all the remaining floors with two or three-legs. Repeat this procedure for the other row of kennel floors. Make any final adjustments and move floors into their final position.

Note: When leveling floors from front to back, the floors must have a slope of 1/4 inch per foot. Be careful to maintain this slope for your kennel system (Figure 5). The Level shown in the picture with 12" dimension is only the representation of slope of 1/4 inch per foot (12"). For example, if your kennel floor is 6' deep there should be a 1 ½" (1/4" x 6 = 1 ½") difference in height of the floor at the front than at the back.

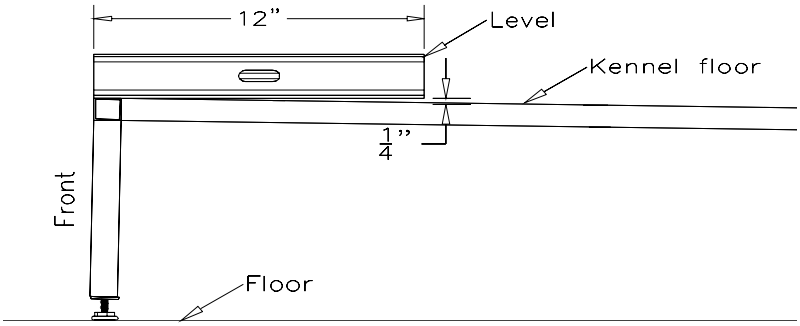


Figure 5

3. Using a carpenters level, adjust each floor with leg leveling screws so that all the floors are absolutely level from side-to-side only, allowing the ¼ per foot slope from front to back.

4. Lay out the trench drain section(s) into position between the two rows of floors (**Figure 5A**). The drain sections are configured according to your facility layout sign-off drawing (**Figure 5B**). Please check to make sure your drain location matches with the sign-off drawing.

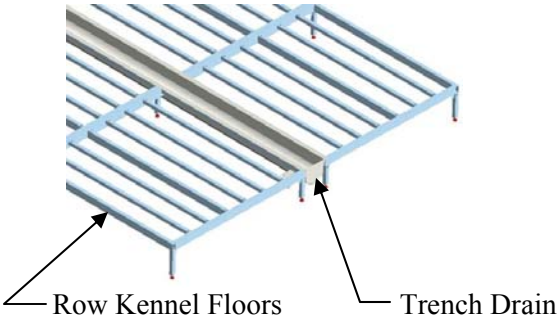


Figure 5A

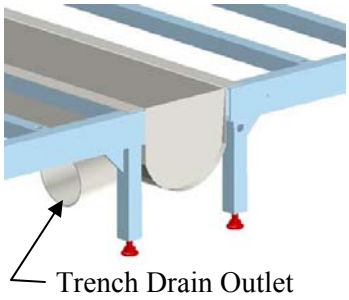


Figure 5B

Begin trench drain installation by lining up the trench drain with the welded trench drain outlet facing your floor drain **(Figure 6)**.
Each additional section needs to overlap 1-1/2". The shallower section is always placed inside the deeper section **(Figure 6A, 6B)**. Proper overlapping the drain sections will prevent leaking.

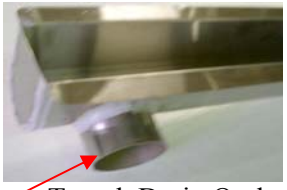


Figure 6

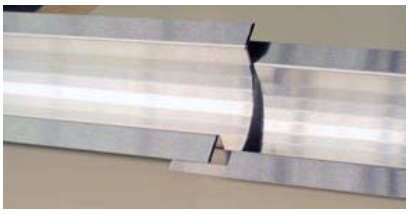


Figure 6A

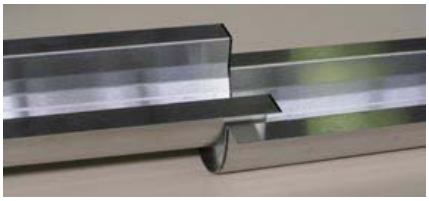


Figure 6B

5. Apply a generous bead of Sealant (Sikaflex) (**J. Kennel Assembly Hardware**) where the trench drain overlaps 1-1/2 inch **(Figure 7)**. Next, apply a bead of sealant along the top of both sides of the drain flange. This will provide a seal between the drain and the floor frame when the drain sections are re-attached. Once the drains are re-attached to the floor frames, smooth out any sealant at the drain overlap areas as shown in the **(Figure 7)**.

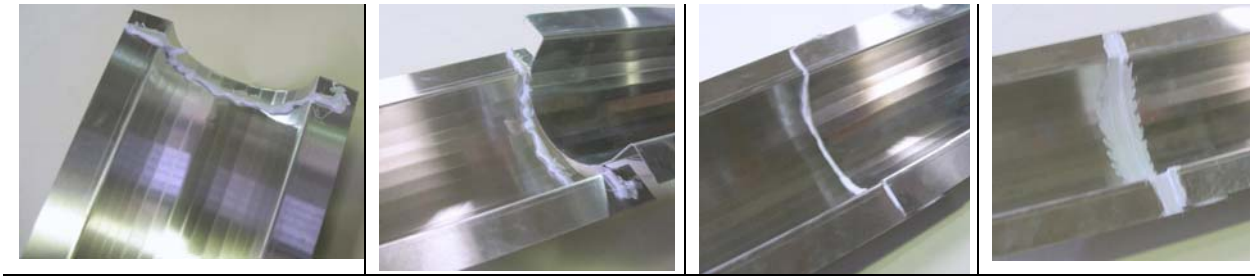
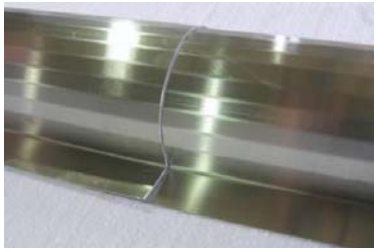


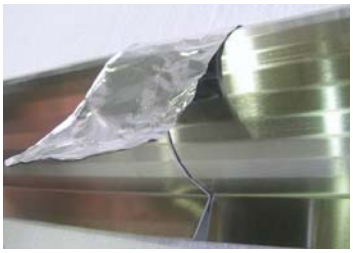
Figure 7

Drain Patch installation

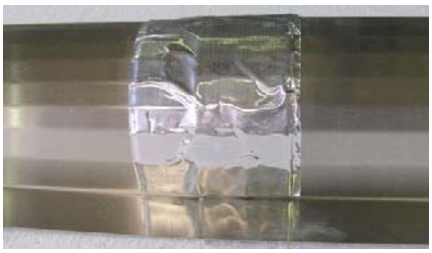
Included in the hardware kit for your raised floor kennel system are 3 ½" x 8" butyl patches to be used as an extra measure to prevent leaks where the trench drain sections overlap. The butyl drain patches need to be installed after trench drains are installed and secured into place, but before the PVC flooring is installed. You will have to reach through the floor frame and under the drain(s) to do this. Install the patch by peeling off the wax paper cover and pressing the patch firmly in place on the *OUTSIDE* of the trench drains at each spot where the drain sections overlap. Center the patch so that it equally covers the areas on each side of overlapping sections (**Figure 9B & 9C**).



Drain Overlapping Sections
Figure 9A



Drain Patch shown loose
Figure 9B



Drain Patch Fully Installed
Figure 9C

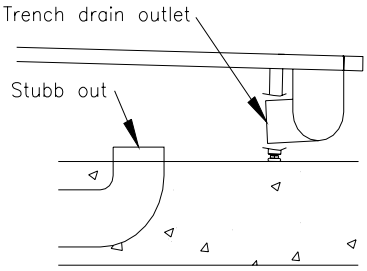


Figure 10

6. After installing the drains, move the floors into place (if applicable). Your plumber will make the final connection between the drain outlet and the sewer drain **(Figure 10)**.

Note: Your T Kennel system does not include the hardware or plumbing to make this final connection. You or your plumber must supply this per local plumbing code.

7. Floor Adjustment

Based on your Double Kennel System on raised floor order, the installer is required to adjust the distance from the front edge of nearest floor to the front edge of the opposite floor before placing the PVC floor panels. For example, on 8FT Double Kennel System on raised floor, the distance should be 96 inches as shown in **(Figure 11)**.

8. After making the final plumbing connections and floor adjustments, prepare to attach the Acrylic PVC floor panels to the open kennel floor frames. Lay the PVC floor panels textured surface side up on the kennel floors to make sure they fit properly, and then remove. Apply a generous bead of adhesive (page 4) around the top surface perimeter and cross members of the floor frames **(Figure 11)**.

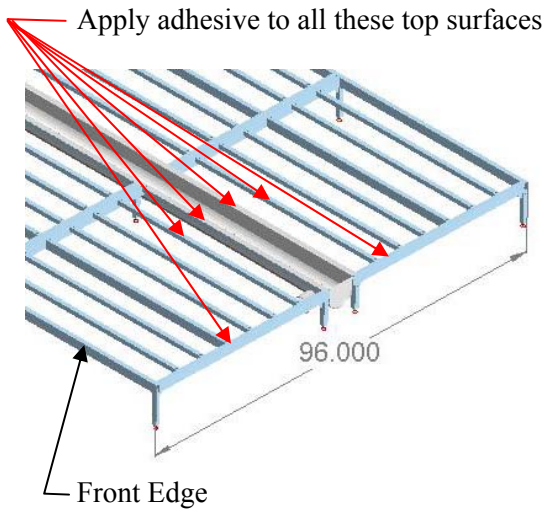


Figure 11

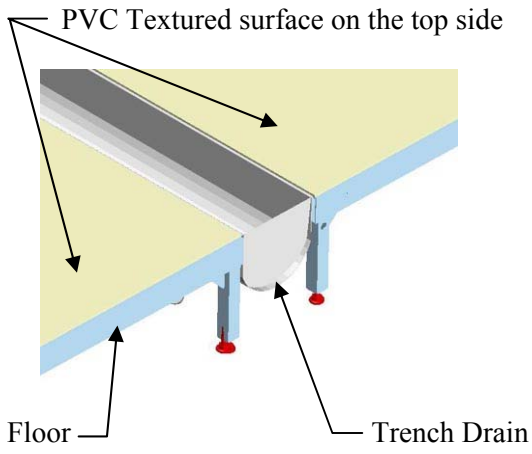
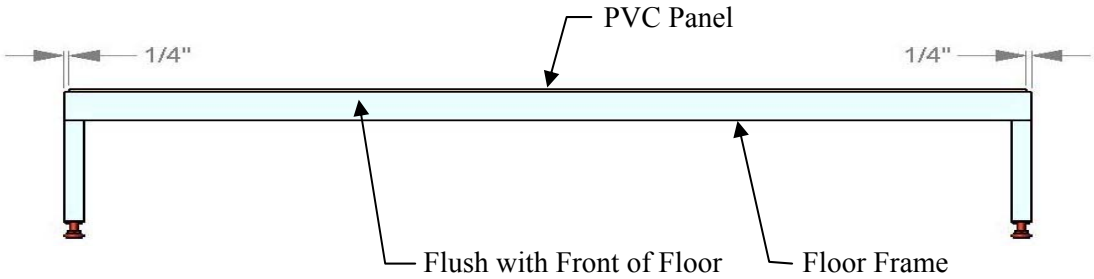


Figure 12

8. Place the pre cut Acrylic PVC floor panel textured surface side up on the open floor frame **(Figure 12)**. Make sure the PVC floor panel lines up flush with the front edge of the floor frame. The Start and the End floors are 1/2" wider than the PVC floor panel so you must center the PVC panel to accomplish a ¼-inch gap on either side of the floor **(Figure 13)**. The PVC floor panel for the Center floors will fit flush on both sides. After placing all the PVC floor panels in place, apply a generous but constant bead of sealant all the way around (perimeter) to all outer edges of PVC floor panels to ensure a watertight seal.



Front View (Start and End Floors)
Figure 13

9. Apply even pressure to the Acrylic PVC floor panel to insure even adhesion. Remove any adhesive from around the exterior edges with rag or putty knife. A partial cure will take 24 hrs with a full cure taking 24 hrs.

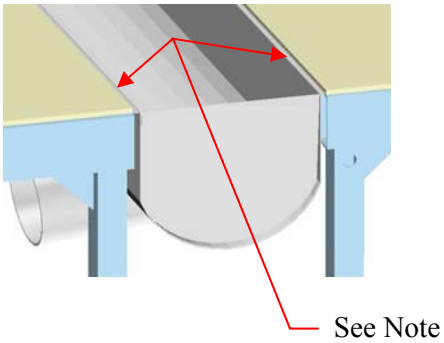


Figure 13A

Note: After the PVC floor panels have dried enough to walk on, apply a generous bead of sealant along both sides of the drain where the PVC floor panels meet the drain flanges **(Figure 13A)**.

D. King Post and Side Panel Assembly

(*Note*: *The Kennel System is designed to assemble from left to right.)*

King Post

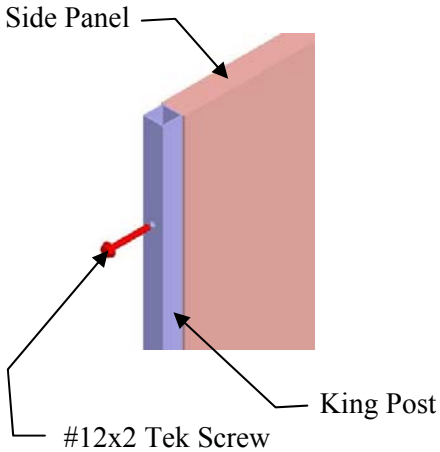


Figure 14

1. Attach a King Post to the first Side Panel on the far left using 2" Self-Drilling Tek Screws through the pre-drilled holes **(Figure 14)**. The King Post should always mount to the short front end of the Side Panel.

Assembly Tip: The First Side Panel, King Post and Gate Panel are easier to assemble on the floor and then lifted into place.

Remove Door from each Gate Panel

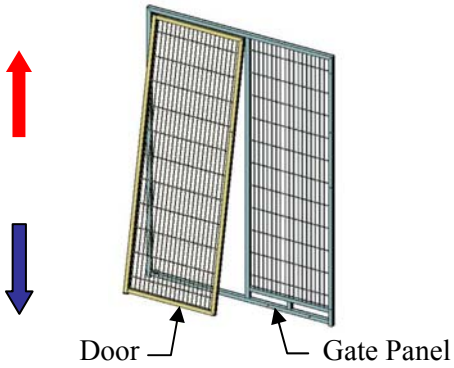


Figure 15

2. Locate the Gate Panels and remove the Door from each Gate Panel. Slightly open and lift up on the door. Once the Door clears the hinge pin at the bottom, pull the bottom of Door toward you **(Figure 15)**. Pull the top of the Door down until the top of the Door clears the top hinge pin.

Mark all of the Doors so that they match with the original Gate Panels. Put the Doors aside until all the Gate Panels are ready to attach.

E. Attach Gate Panel to the King Post

1. Set the first Side Panel (with King Post attached) on the left side of the first floor. Be sure the bottom of the panel slopes from the front to back of the Kennel. Have a helper hold it in place **(Figure 16)**.

2. Attach the Gate Panel to the King Post using 2" Self-Drilling Tek Screws through the pre-drilled holes. Make sure that Gate Panel and King Post are flush up against each other **(Figure 17)**.

Note: For kennels with the optional Stainless Steel Gates, you must pre-drill a pilot hole for the 2" self-drilling Tek Screws. Using the pre-drilled holes as a guide, drill 3/16" hole into the King Post or Gate Panel you are installing. We strongly suggest using a Cobalt drill-bit for this step.

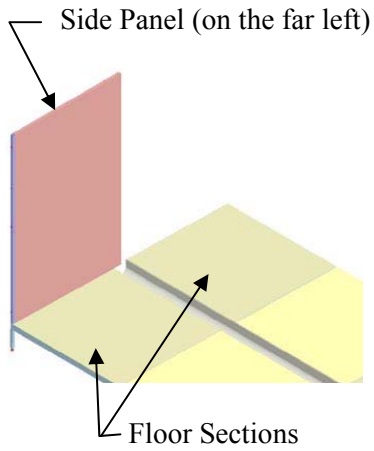


Figure 16

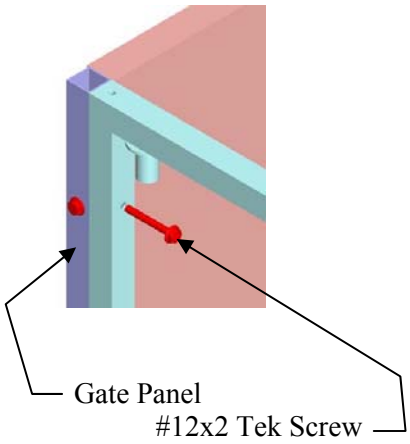


Figure 17

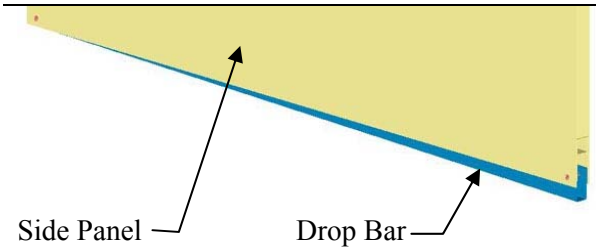


Figure 17a

Note: On standard Side Panels, the slope is ¼" per foot. Refer to your layout to confirm floor slope.

To match the bottom of the Side Panel with the slope of the concrete floor, adjust the Drop Bar, (located inside the u-channel at the bottom of the side panel), by pulling it downwards. (**Figure 17a**). Make sure the Side Panel is level at the Top.

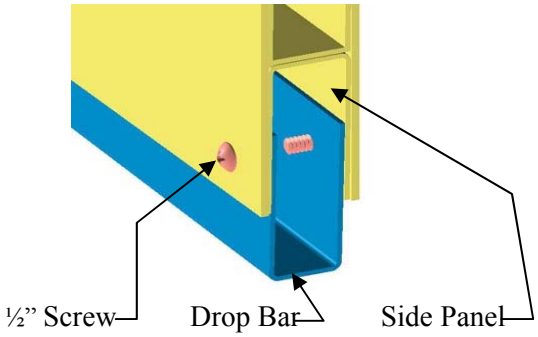


Figure 17b

After making the final adjustment of the Drop Bar, secure it in place with ½" self-drilling screws on both sides of Side Panel at both ends as shown in (**Figure 17b**).

Field Note: If the floor is not uniform, the Drop Bar can be cut and adjusted to adapt to most common floor irregularities.

F. Attach Second Side Panel to the Gate Panel

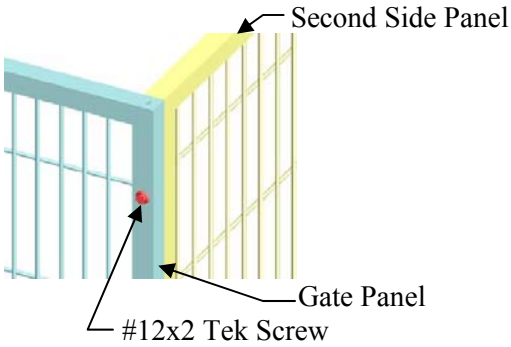


Figure 18

3. Attach the Second Side Panel to the Gate Panel using 2" Self-Drilling Tek Screws through the pre-drilled holes (**Figure 7**).

Note:
From the Second Kennel on, the Gate Panels will attach to the preceding Kennels' Gate.

G. Complete the First Section of Kennels

4. Locate the second Gate Panel and attach it to the first Gate Panel using 2" Self-Drilling Tek Screws through the pre-drilled holes as shown in **(Figure 19)**. Assemble the rest of the Gate and Side Panels, for the first section as shown in **(Figure 19A)**.

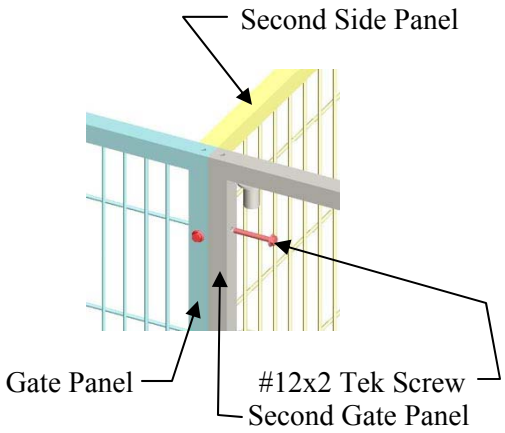
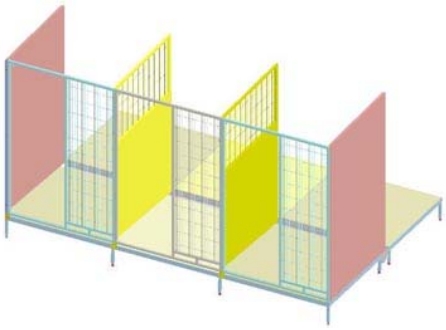


Figure 19



First Section
Figure 19A

5. Locate the Vertical Slide Panels and place them inside the kennels you have already half way assembled as shown in **(Figure 20)**.

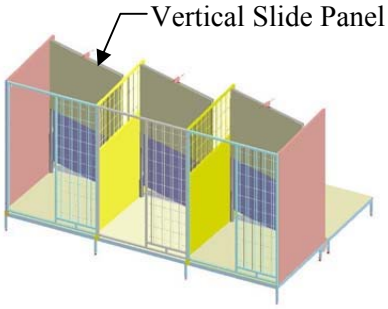


Figure 20

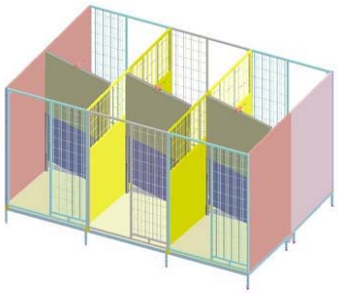


Figure 21

6. Begin assembling the second section of kennels, starting from the left side with a King Post and a Side Panel as shown in the **(Figure 21)**, just like the first row, now follow **(Figures 16 thru 19)** again to complete the second section.

H. Attach Brackets to the Side Panels and Vertical Slide Panels

If your shipment includes T-Brackets and X-Brackets, see installation option on the page 15 & 16 before installing the Panels.

Note: Make sure the Vertical Slide Panels are centrally located on the joint between Side Panels before attaching the brackets.

1. Locate LH & RH Brackets that have three drilled holes. Attach the brackets to both sides of the Vertical Slide Panel using 1" self drilling Tek screws. Make sure to flush the Brackets with the top face of the Vertical Slide Panel **(Figure 22).**

2. After attaching the Brackets to the Vertical Slide Panel and you will notice it is taller than the Side Panels **(Figure 22)**. Position the Vertical Slide Panel in the middle of the kennels by bringing its legs inside the trench drain **(Figure 22A)** and mount to the Side Panels using 1" self-drilling Tek screws. Be sure to flush the top of the Side Panels with the top of Vertical Slide Panel before attaching (**Figure 23**). Have another helper hold in place while you attach. Follow the same instructions to attach the brackets to the Side Panels on the other side of Kennels (**Figure 23A**).

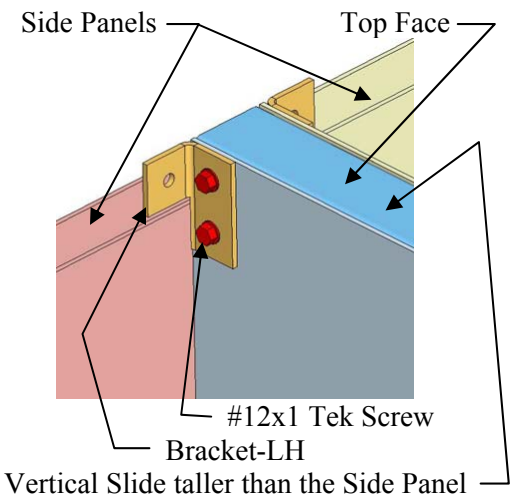


Figure 22

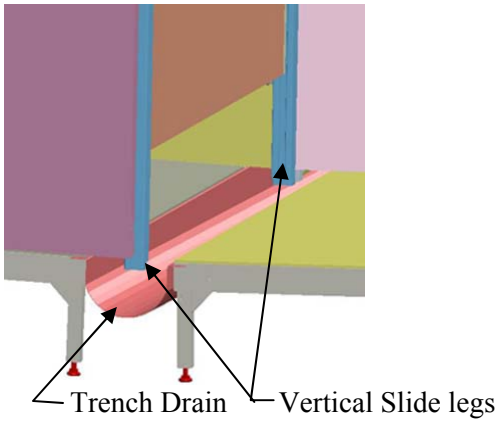


Figure 22A

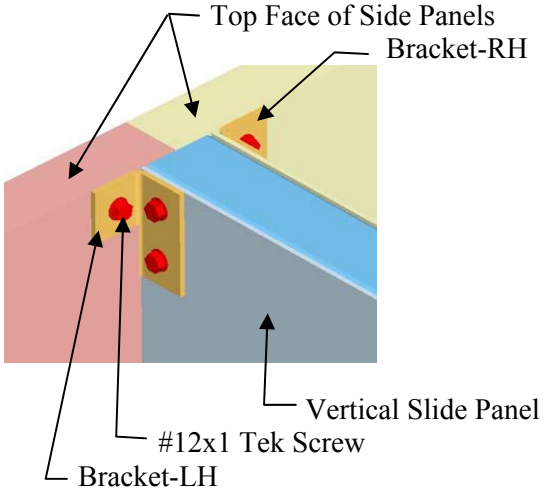


Figure 23

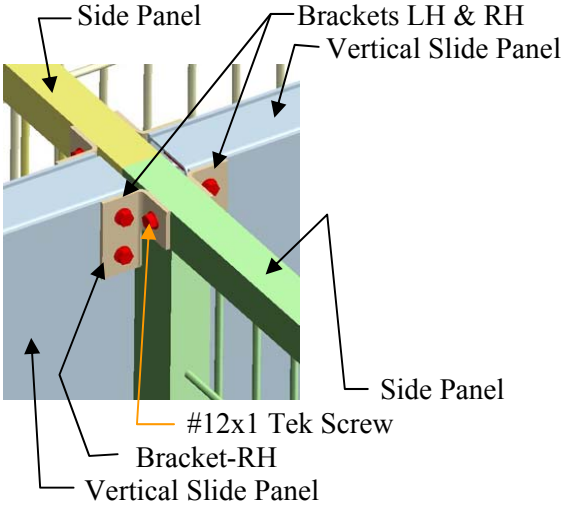
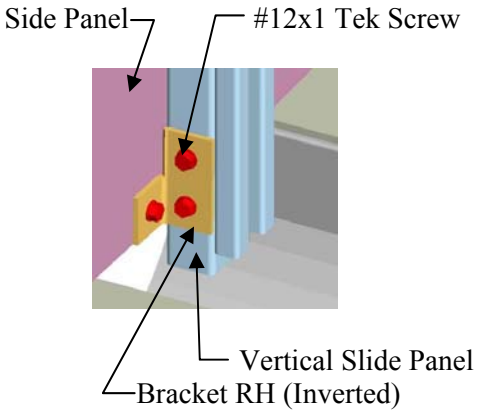


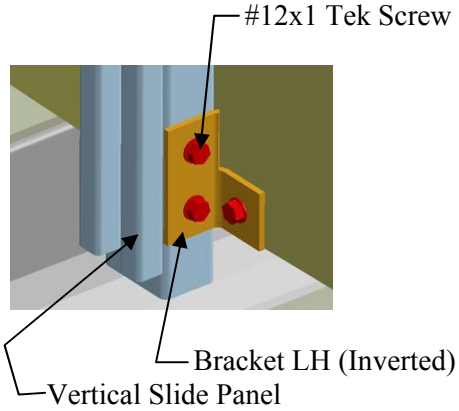
Figure 23A

Note: On Double Kennels that have different depths the Vertical Slide will not be exactly flush with both sides of the side panels because each side of the kennel's slope will be different. (For example if a double kennel depth is 4' deep on one side and 6'deep on the other the over all drop of the 4' side will be different than the 6' side.)

4. Locate the LH and RH Brackets **(Figure 24A & 24B)** that have three drilled holes. Use 1" Tek Screws to attach the Brackets to the Side Panels and both sides (legs) of the Vertical Slide Panel. The Brackets should be flush with the bottom of the Side Panels as shown in **(Figure 24A & 24B)**.



Bottom Lower LH Corner
Figure 24A



Bottom Lower RH Corner
Figure 24B

Installation Option (Side Panels and Vertical Slide Panels)

If your shipment came with X brackets and T brackets as shown in (**Figure 25 & 26**). Please follow the directions below.

Note: Make sure the Vertical Slide Panels are centrally located on the joint between Side Panels before attaching the brackets.

1. Attach T-Bracket by placing it on the top of both joining Side Panels and Vertical Slide Panel using 1" self-drilling Tek Screws as shown in **(Figure 25)**. Follow the same instructions to attach Bracket on the other end of the kennels.

2. Attach X-Bracket by placing it on the top of both joining Side Panels and both Vertical Slide Panels using 1" self-drilling Tek Screws as shown in **(Figure 26)**.

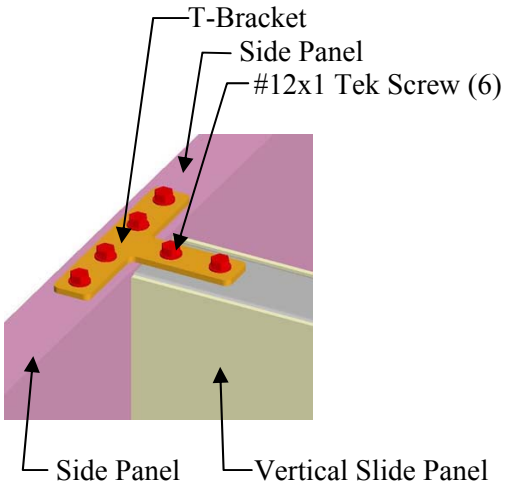


Figure 25 (On the Top)

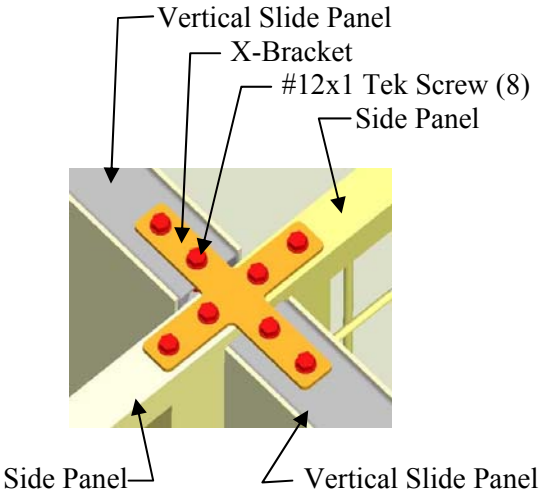


Figure 26 (On the Top)

I. Secure Gate Panel to Floor using 4 hole Plates

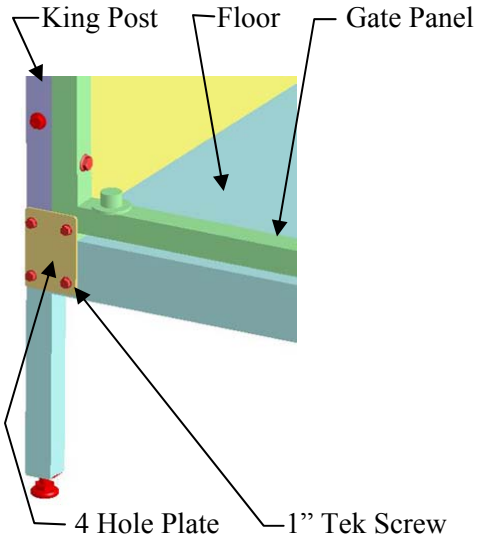


Figure 27

1. After all the Gate Panels are installed, locate the 4 hole Plate. Attach the first 4 hole Plate over the King Post and the first Gate Panel frame tube with (4) 1" Tek Screws as shown in **(Figure 27)**. The rest of the Plates will mount where each Gate Panel meets with another Gate Panel **(Figure 28)**.

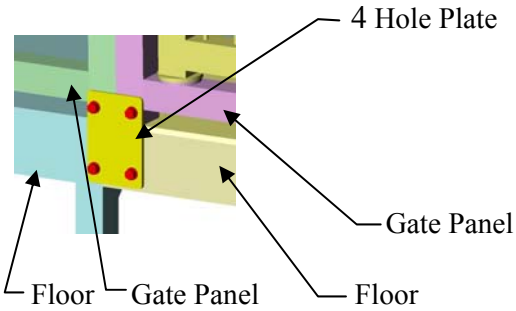


Figure 28

2. Attach a 4 hole Plate over the side of the Floor and the Side Panel on the front side of the kennel with (4) 1” Tek Screws as shown in **(Figure 29)**. Then attach the next 4 hole Plate on the rear side of the kennel with (4) 1” Tek Screws as shown in **(Figure 30)**. Use the same instructions for the second section of the kennels, using the same instructions on the other side of the kennel system.

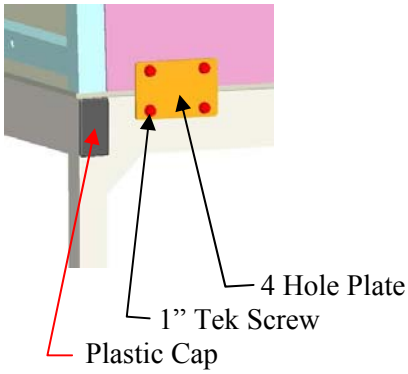


Figure 29

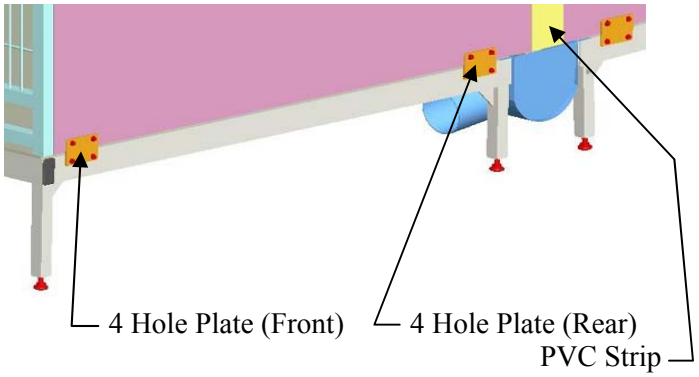


Figure 30

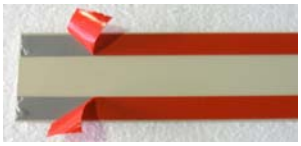
3. Plug open ends of tubing with Plastic Cap on each end of the kennel system as shown in **(Figure 29)**.

J. PVC Decorative Strip Installation

3” PVC Strips have been provided to cover the seam where the two side panels butt up against each other at the outside ends of the double kennels. To install the optional 3” PVC Strip, measure the length needed to cover the seam and cut to length. Apply a row of 2-sided adhesive tape down each side of the PVC Strip (**Figure 30a**). Peel back approximately 1” (**Figure 30b**) of the protective backing on the tape rows and place the PVC Strip evenly over the seam to be covered. Working from top to bottom press the PVC Strip down firmly, and slowly pull the protective cover off the adhesive tape while applying pressure to the strip (**Figure 30c**).

PVC Strip shown with Tape

Figure 30a



PVC strip shown with tape is peeled.

Figure 30b

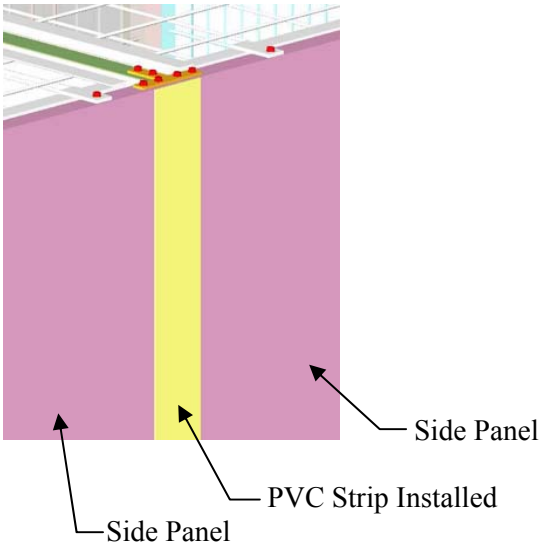


Figure 30c

J. Install Counterweight System for the Transfer Door

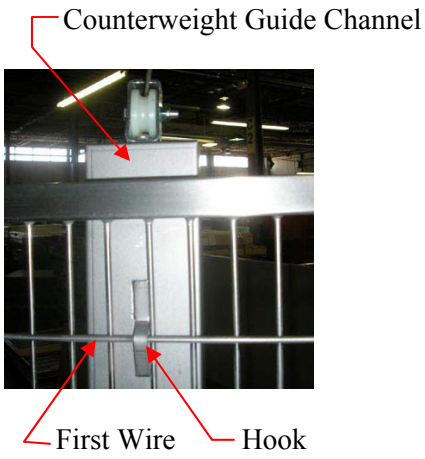


Figure 31

Insert Counterweight Guide Channel into the first and fourth wire to the right of the Gate Panel opening using the hooks welded to the back of the Counterweight Guide Channel as shown in **(Figure 31 & 32)**.

Figure 32

Note: To install the counterweights, check to make sure the sliding door in the Vertical Slide Panel is secure in the open (up) position, which is held in position with a setscrew, installed by the factory. *This setscrew is located in the door channel. Do not remove it until you install both counterweights.*

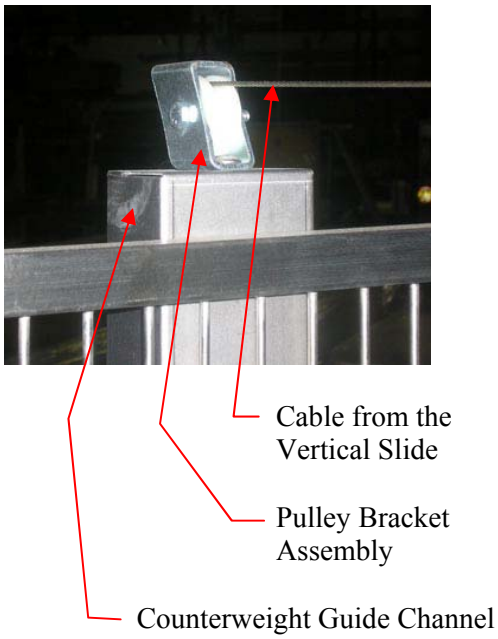


Figure 33

After installing the counterweight guide channel, route the cable from the Vertical Slide Panel over the nylon pulley wheel (which is the part of the pulley bracket assembly that is mounted on the top of the counterweight guide) down through the hole in the top of the counterweight guide channel **(Figure 33 & 34).**

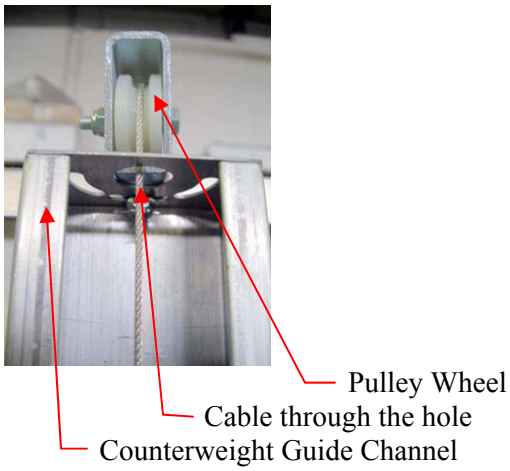


Figure 34

Note: Two persons will be required to complete the following steps.

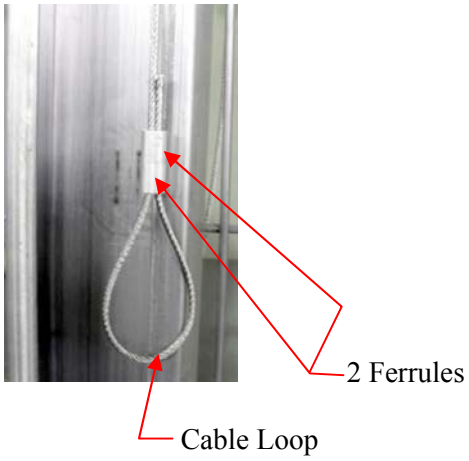


Figure 35

With the cable properly routed into the counterweight guide channel, have person #1 slide two (2) ferrules onto the cable then make a loop with the cable, and route the cable back through the two (2) ferrules **(Figure 35)**.

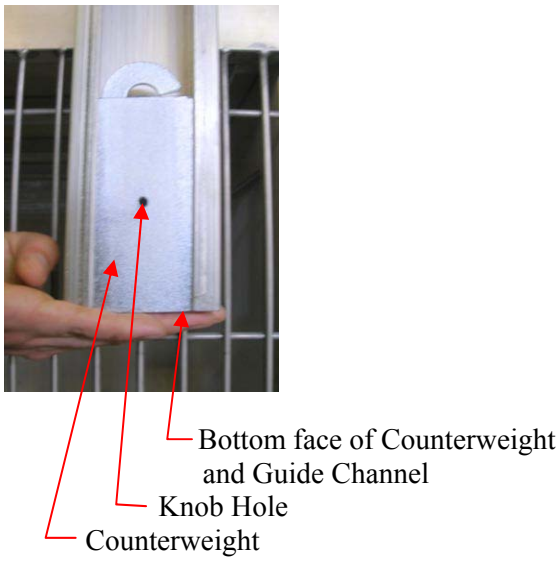


Figure 36

Have person #2 locate the counterweight to be installed and place it into the bottom of the counterweight guide channel. Make sure the threaded knob hole is facing outward. Slide the weight up until the bottom of the weight is even with the bottom of the counterweight guide channel **(Figure 36)**.

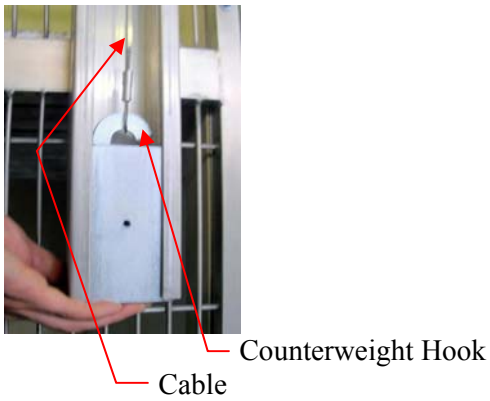


Figure 37

Place the cable loop around the counterweight hook at the top of the counterweight. Pull the cable tight so there is no slack from the Vertical Slide Panel to the counterweight. Leave enough slack in the loop to allow the counterweight to be removed **(Figure 37)**.

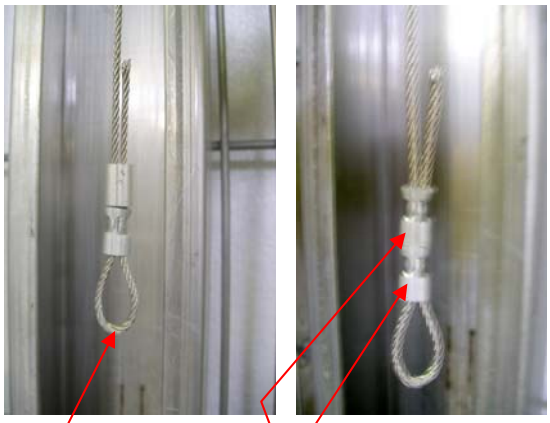


Figure 38

Slide the cable loop off of the counterweight hook and have person #2 set the counterweight on the floor. With person #1 holding the cable loop and ferrules secure, person #2 can now crimp both Ferrules tightly with crimping tool. **(Figure 38)**

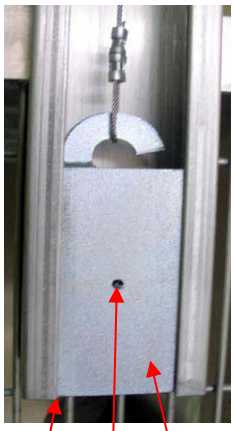


Figure 39

Install counterweight back into the counterweight guide channel with the threaded hole facing outward **(Figure 39).** Slide cable loop over counterweight hook and allow counterweight to hang freely. Trim off any excess cable **(Figure 40)**.

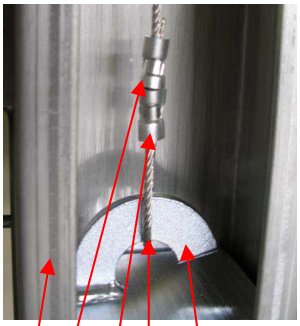


Figure 40

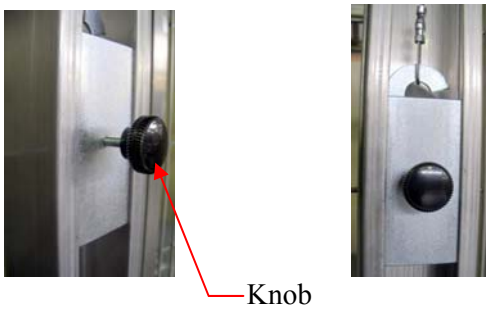


Figure 41

Install the Knob into the threaded hole in the Counterweight **(Figure 41)**.

After all the counterweights are installed, remove the setscrew from the track of the Vertical Slide Panel(s). This will release the door and all the Counterweights will control the movements of the door.

Standard Pulley System

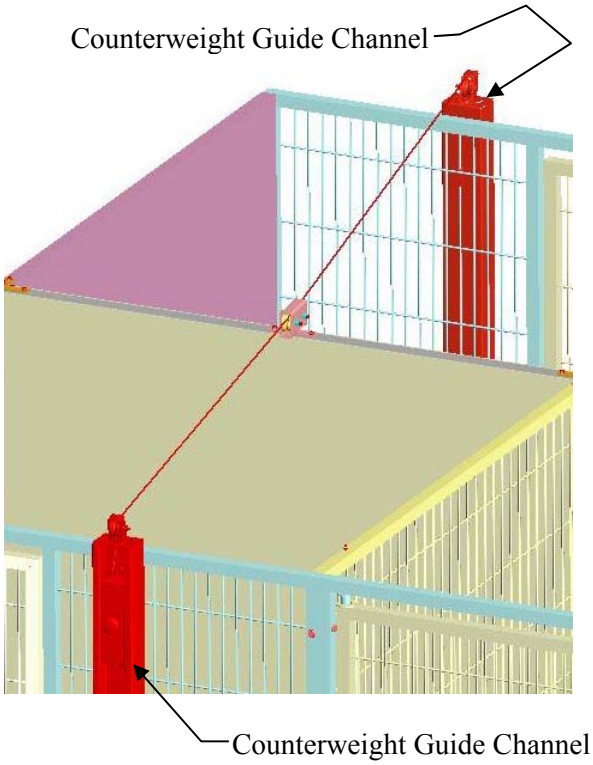


Figure A

In the Standard Pulley System, the cable will be in line between both Counterweight Guide Channels as shown in **(Figure A & B)**.

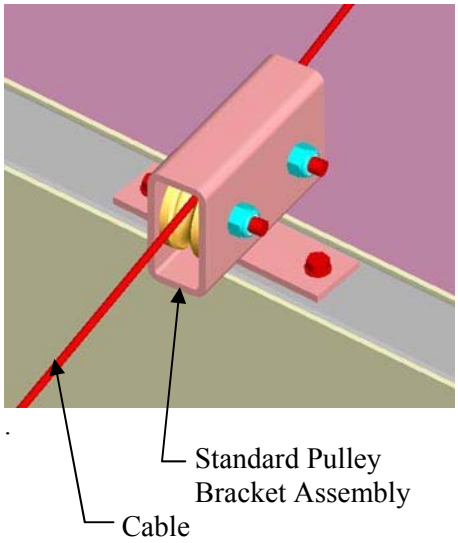


Figure B

Option: Reverse Pulley System
(For the Reverse Gate Panel)

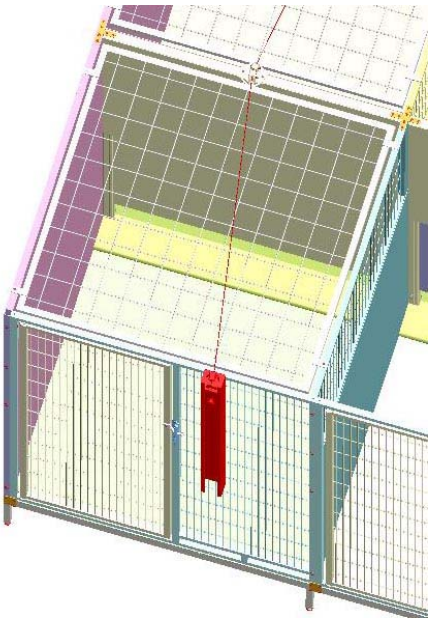


Figure C

In the Reverse Pulley System, the cable will be set at an angle between both Counterweight Guide Channels because of Reverse Gate Panel as shown in **(Figure C & D)**.

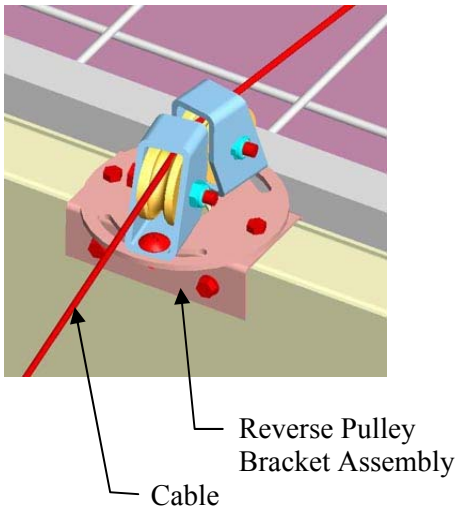
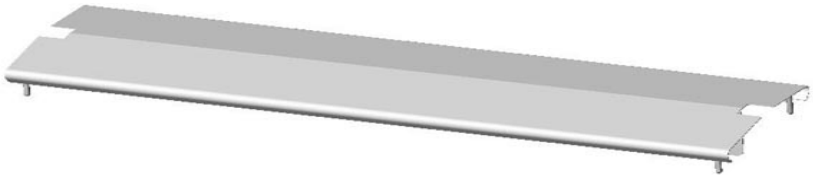


Figure D

K. Install Full T Cover



Full T Cover

Tilt the Full T cover to install between two legs of Vertical Slide Panel, first placing on one leg in the cutout of Full T Cover as shown in **(Figure 42)**. The legs of the Full T Cover will touch the Floor and it will fully cover the trench drain **(Figure 43 & 43A)**.

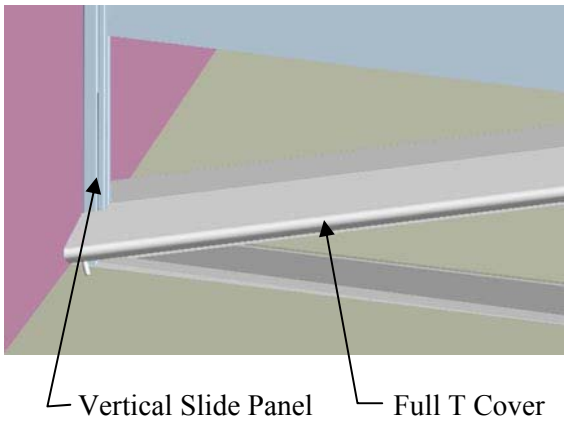


Figure 42

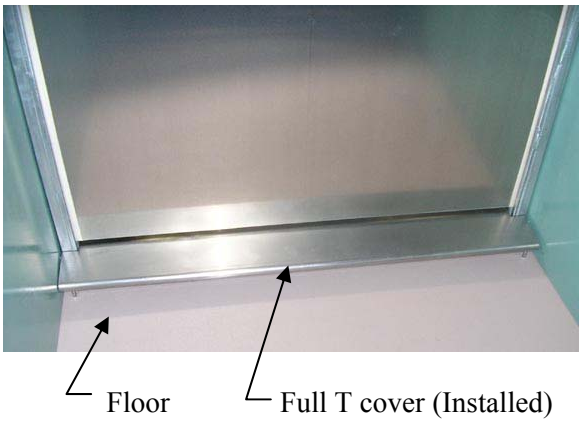


Figure 43

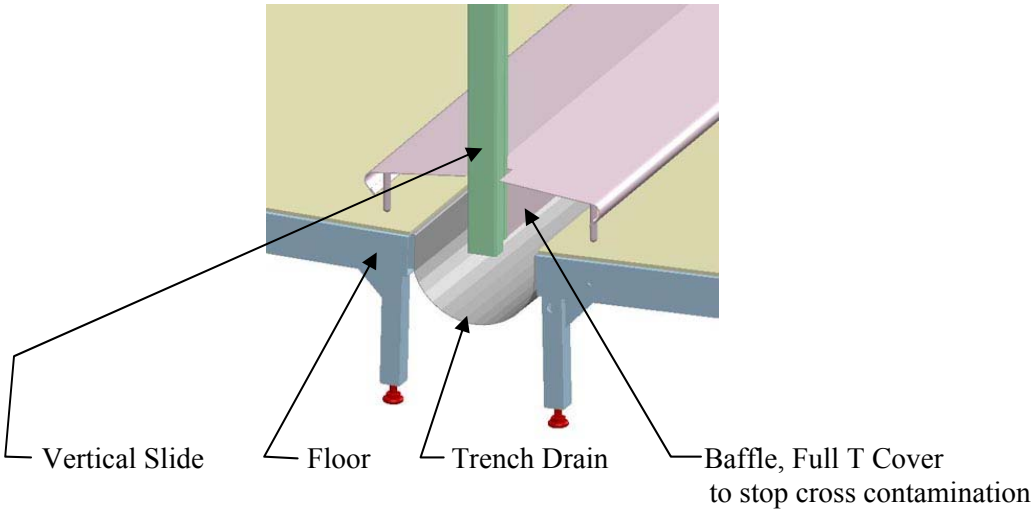


Figure 43A

L. Sealing Kennel Assembly

READ THIS ENTIRE SECTION PRIOR TO SEALING THE KENNEL. The goal is to start in the back of the kennel and work your way out. Having to walk into a freshly sealed kennel may compromise the sealant and possibly cause leaking.

1. Use a primer or Isopropyl Alcohol (Make sure to read health hazard information) to clean all the corners, cracks, edges, and areas that need to be sealed. This should remove any dust or oil that would inhibit good adhesion **(Figure 44)**.

2. Cut the Sealant (page 14) tube **(Figure 45)** end off at a 60° angle. The hole should be about the diameter of a ballpoint pen. Use a coat hanger or longer pin to poke a hole in the Sealant tube to start the flow **(Figure 46)**.


Figure 44


Figure 45


Figure 46

Sealing Tip: Running a strip of masking tape **(Figure 47)** approximately ¼" from either side of the seam to be sealed will help produce a professional looking caulking job.


Figure 47


Figure 48


Figure 49


Figure 50


Figure 51

3. Begin sealing at the back of the kennel. Seal the corners where the Side Panels meet the Vertical Slide Panel, working top to bottom. Smooth the sealant with the tip of your gloved finger so that there are no gaps or pinholes in the sealant. It may help to dip your gloved finger into a bowl of dish detergent to prevent sticking. After applying and smoothing the sealant with you finger, peel off the masking tape using caution not to smear the fresh sealant.

Seal the Side Panels to the floor working back to front. Smooth the sealant with the tip of your gloved finger so that there are no gaps or pinholes in the sealant.

4. Refer to the sealant manufacturer's directions for drying times. We strongly suggest waiting at least 72 hours for the sealant to cure completely before applying any water or using the kennels.

M. Install Striker Bar and Latch Assembly

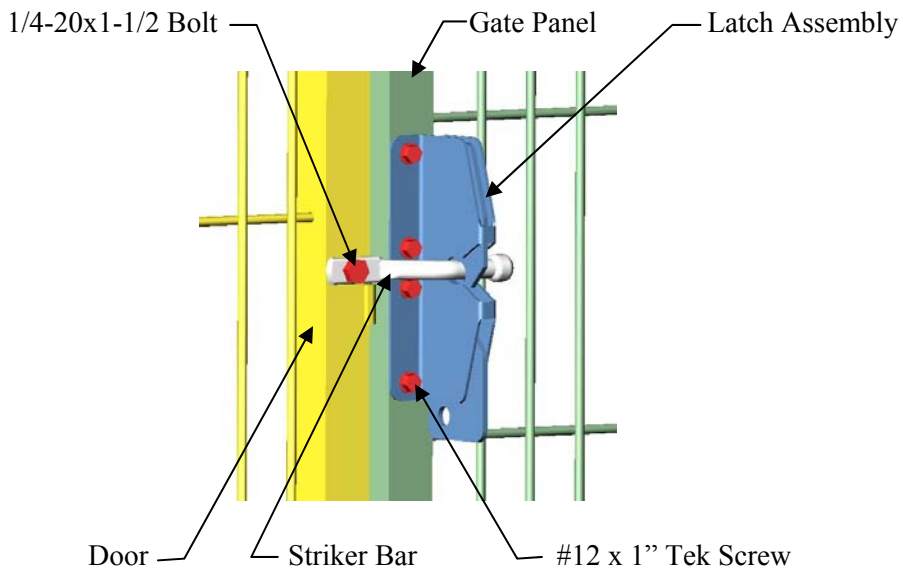


Figure 52

1. Install the Striker Bar to the pre-drilled Door using a 1/4”-20 x 1-1/2 Hex Bolt and 1/4"-20 Nylox Nut **(Figure 52)**. Position the Striker bar into a horizontal position.

Note:
To install the Latch Assembly to the Stainless Steel Gate Panel, you must pre-drill the holes using a 3/16 cobalt drill bit through only one wall of tube for the 1” Tek Screws by matching with the pre-drilled holes in the Latch Assembly.

2. Hold the Latch Assembly in place against the Gate Panel and close the Door. Make sure to center the Striker Bar within the latch pocket and latch looks straight. Using (4) 1” Tek Screws, mount the Latch Assembly to the Gate Panel **(Figure 52 & 52A)**.

Latch Assembly for optional Glass Gate Panel Assembly

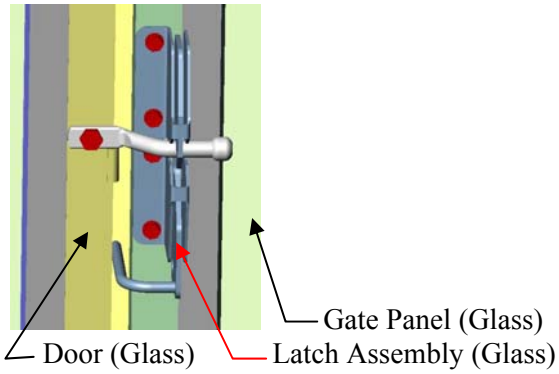


Figure 52A

Use the same installation instructions as shown above for the Glass Gate Panel Assembly.

N. Installation Options:

1. Top Wire Panel

Hardware Required

061.1010.00 - #12X1 TEK SCREW

Locate Top Wire Panel with slotted tabs. Position the Top Wire Panel with the tabs resting on the top of Side Panels equally spaced within the opening. Attach Top Wire Panel to the Side Panels using 1" Tek Screws through the slotted tabs as shown in **(Figure 53 & 54)**. The mount tabs are staggered to avoid interference with each other when assembling multiple kennels.

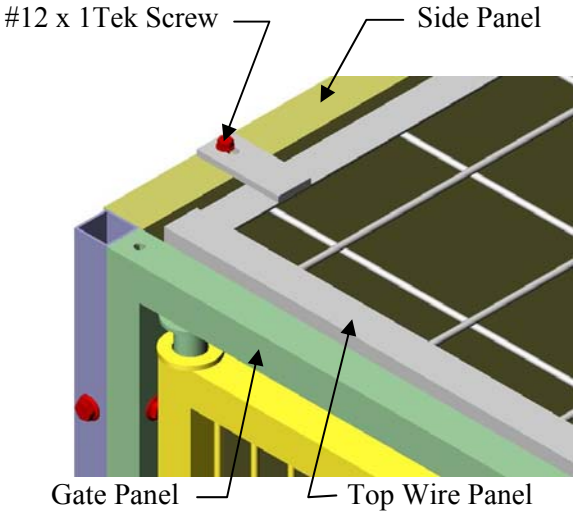


Figure 53

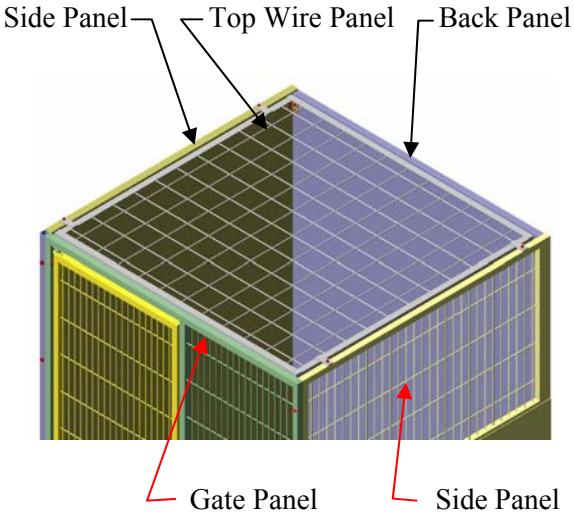


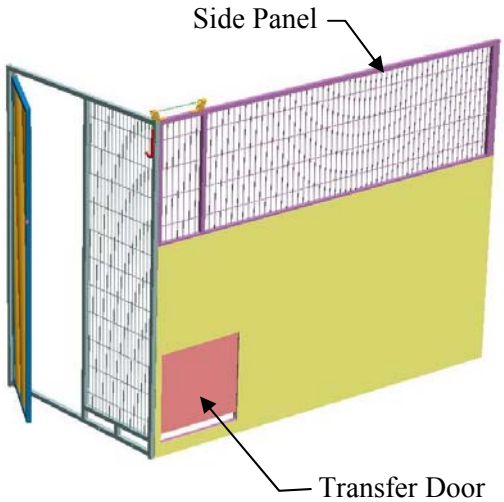
Figure 54

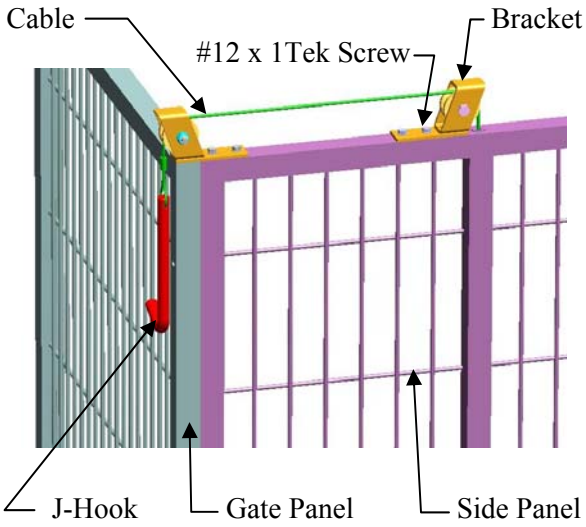
2. Side Transfer door Assembly

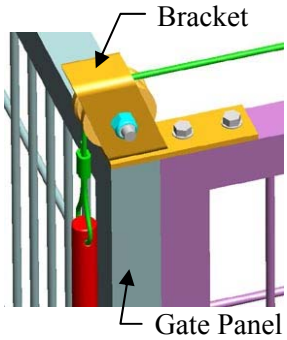
Hardware Required

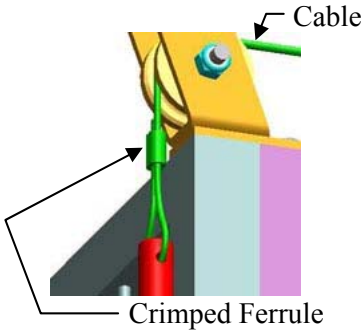
 061.1010.00 #12X1 TEK SCREW	 731.0000.08 BRACKET, TRANSFER DOOR	 310.0555.02 PULLEY NYLON	 062.2515.00 1/4X1.5 CAP SCREW	 064.2500.22 1/4 NYLOCK NUT
 043.0004.01 SLEEVE (FERRULE)	 041.0091.00 J-HOOK	J-HOOK **OR** CARABINER	 193.0050.01 CARABINER	

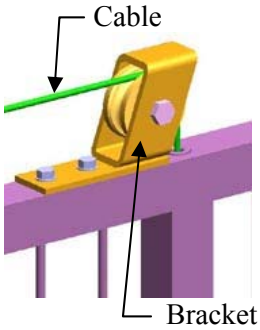
Install Pulley Bracket Assemblies using #12 x 1” long Self-Drilling Screws as shown. Locate J-Hook or Carabiner and Ferrule.

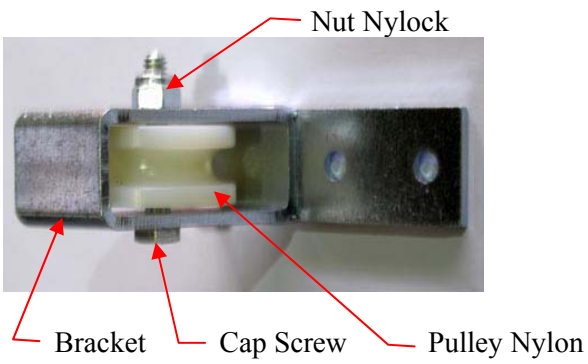


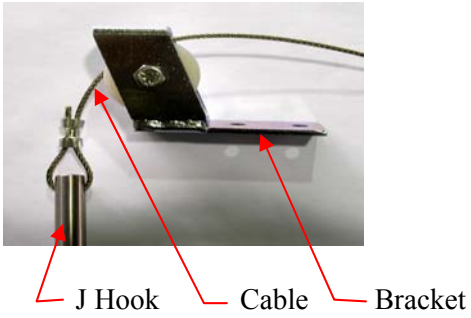


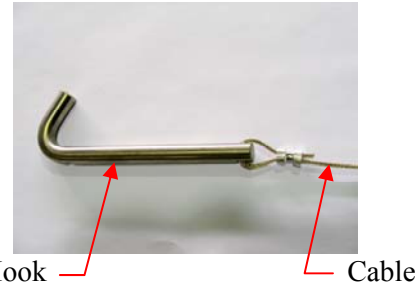












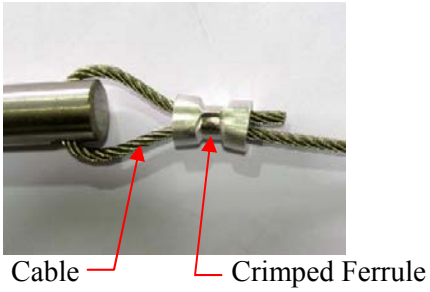


Figure A

OR

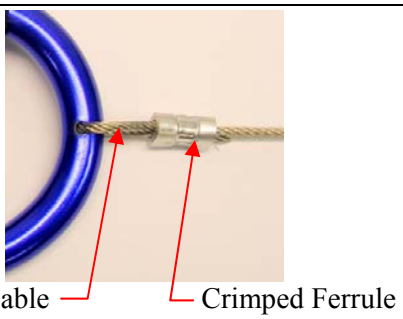


Figure B

J-Hook or Carabiner Installation

To install the J-Hook or Carabiner for the optional transfer door, route the cable as shown in (**Figure A)**. Take an aluminum ferrule and route the cable through the ferrule, then through the hole in the J-Hook/Carabiner, and back through the ferrule.

Before crimping the ferrule to secure the cable, adjust the length of the cable so that the J-Hook or Carabiner can properly hook to the cross members of the wire mesh panel in a position that will hold the transfer door fully open. When you are satisfied with the position of the J-Hook/Carabiner, crimp the ferrule tightly to the cable and trim off any excess cable (**Figure B)**.

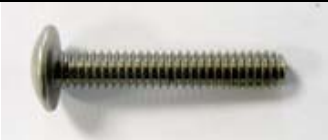
3. Feed Tray Cam Lock Installation

Hardware Required

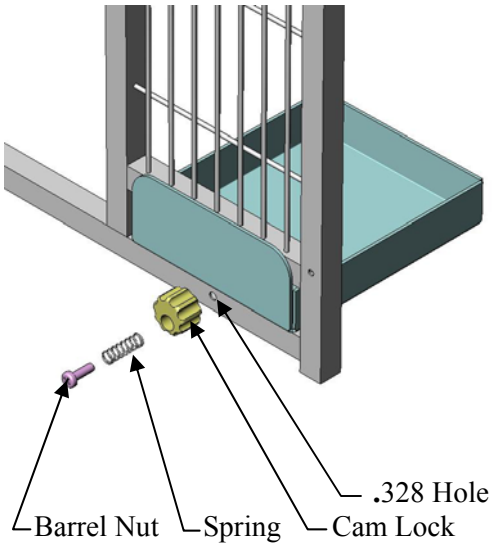
058.3002.01 CAM LOCK

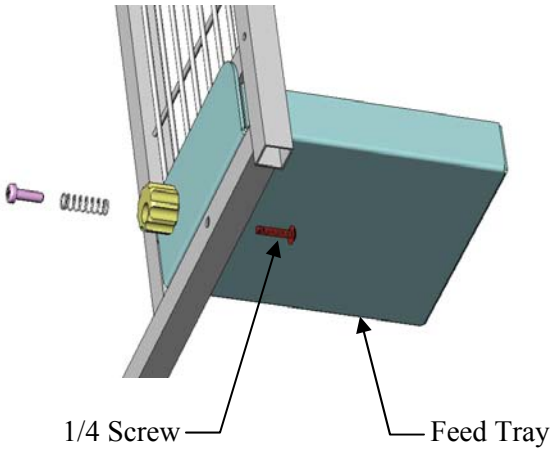
064.2500.17 BARREL NUT

085.1012.00 SPRING



062.2515.04 SCREW 1/4 W/TORQUE PATCH





1. Locate .328 Diameter hole on the right hand side of bottom tube. Align Cam Lock 058.3002.01 with .328 diameter hole in bottom tube by holding larger diameter towards front.

2. Slide Spring 058.1012.00 onto a Barrel Nut 064.2500.17 and insert it into Cam Lock. Screw 062.2515.04 as shown from the backside of bottom tube and tighten securely.

3. Adjust the Cam Lock so that it can freely move clockwise or counterclockwise.

4. Insert Feed Tray into the Feed Tray slot. Turn Cam Lock to lock the Feed Tray in place.