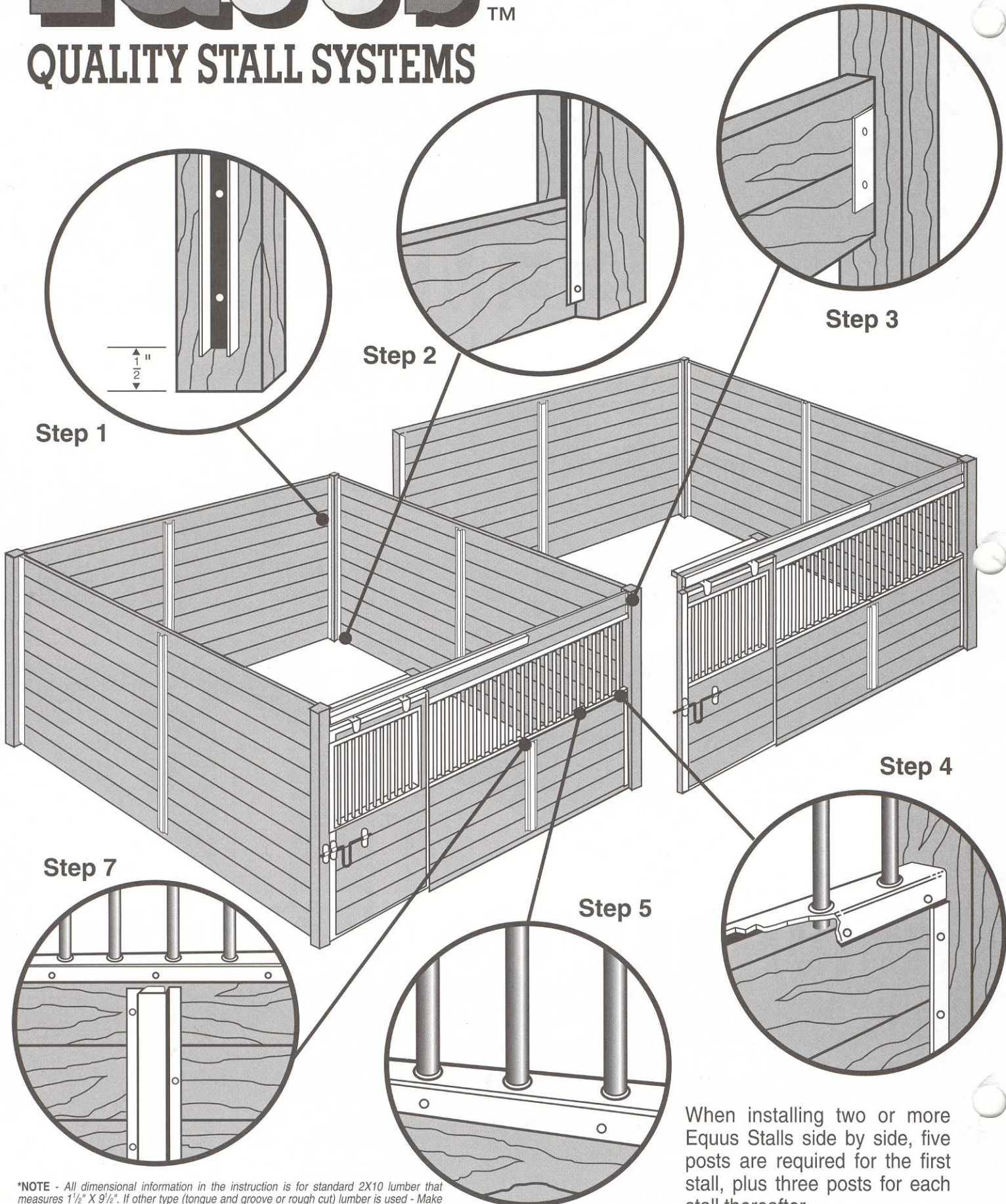


# EQUUS<sup>TM</sup>

## QUALITY STALL SYSTEMS

# Assembly Instructions



Step 1

Step 2

Step 3

Step 4

Step 5

Step 7

When installing two or more Equus Stalls side by side, five posts are required for the first stall, plus three posts for each stall thereafter.

*\*NOTE - All dimensional information in the instruction is for standard 2X10 lumber that measures 1 1/2" X 9 1/2". If other type (tongue and groove or rough cut) lumber is used - Make appropriate adjustments in the number of boards and/or height locations of components. Drawings are available for 2 x 6 center matched lumber - contact factory.*



# Post Installation

FIGURE 1

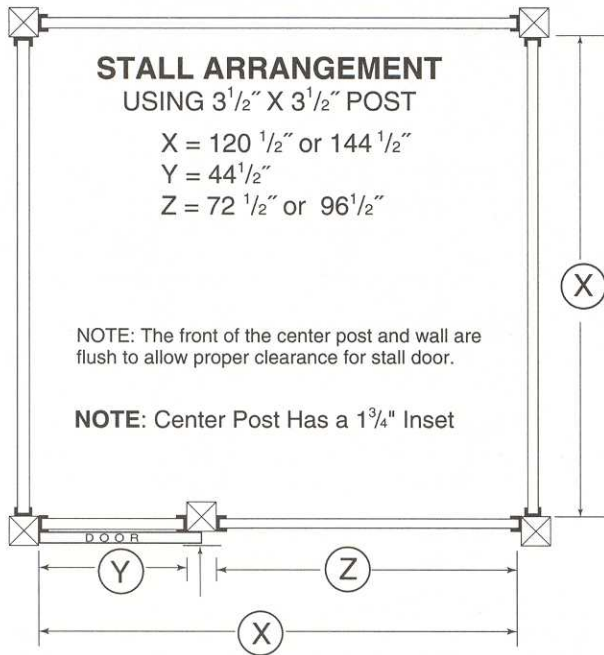


FIGURE 1 above, shows the top view of a stall system and the proper placement of the posts for correct wall alignment.

Determine the size stall you will build.

Any size stall can be built using the Equus System.

1. Corner post can be set 10' or 12' (or any other spacing as desired) on center to fit building design or special needs. Equus grill work channels will have to be cut to fit space between post if this system is used.
2. Preferred option is to set the face to face dimension between 4x4 (nominal 3 1/2" x 3 1/2") post an even two foot spacing plus 1/2" to use the Equus grill system without cutting.
3. On all layouts, the opening for the slide door must be no larger than 46" and should be no smaller than 48" minus the post size. ie: using a 3 1/2" post, the door opening should be no smaller than 48"-3 1/2"=44 1/2".

After making your lumber list (top of page 5), the next step is to layout the stall. Install all corner posts with 8 feet or more of length above the ground with 10 foot or 12 foot plus 1/2 inch BETWEEN posts, depending on the width of the Equus grill you have selected. This is shown in FIGURE 1. Be sure all posts are plumb, level and true.

**NOTE:** If you are not fastening the posts at the top you will need to make sure they are placed deep enough into the footing to provide adequate holding power.

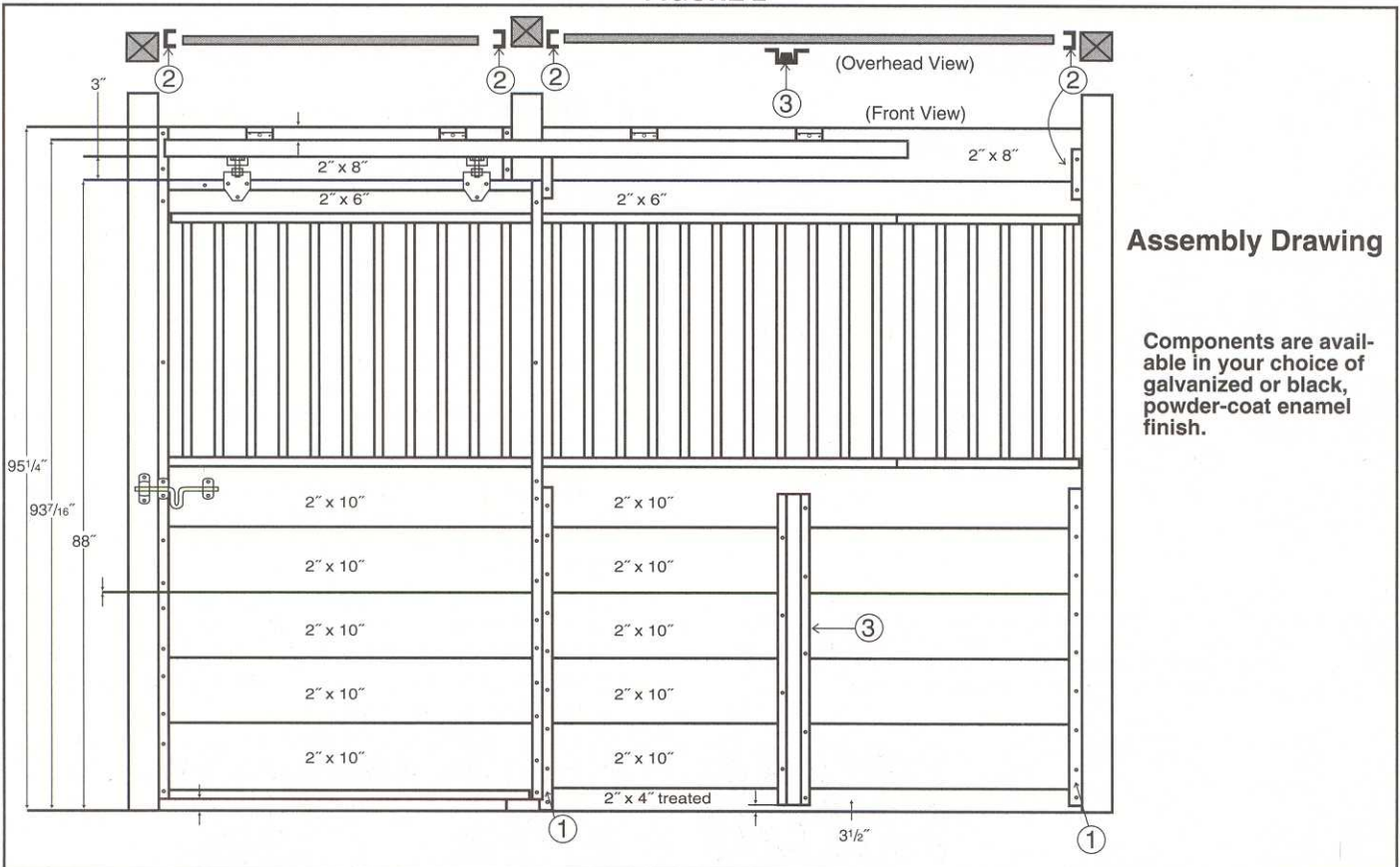
Next, install the center door post in the front wall with a 44 1/2" space for the door opening shown in FIGURE 1. Take note of the 1 3/4" inset of the center post, which is necessary so that the sliding door can be flush with the corner post and open past the center post.. The front wall and the center post must all be flush and 1 3/4" back from the front of the corner post to allow the sliding door track installation and door operation.

With all posts in place, you are now ready to install the Equus stall walls you have selected. Unpack each carton for installation and account for all parts on the packing list. Review the assembly drawings to understand where the parts should go and read all instructions carefully. To avoid mistakes, perform each step in the sequence shown here.

## Front Wall System Assembly

**Step 1:** Install end channels (item 1, part #4501) on the corner post and center post. End channels should be centered on the inside surface of the corner posts for the sides and back of the stall. For the front of the stall the end channels should be 1 3/4" inset from the front of the corner posts and flush with the front of the center post which is inset from the corner post line, as shown in FIGURE 1 and in the assembly drawing (figure 2). All channels should be placed 1/2" above the floor surface and anchored to the posts with 3/4" truss-head screws supplied.

FIGURE 2





**For solid wood walls,** fasten two (2) end channels to each post, one directly above the other.

**For grill work walls,** fasten only one (1) end channel at the bottom of each post.

**Step 2:** You are now ready to install the wall lumber. Slide the first board down to  $\frac{1}{2}$ " below the bottom of the end channels. After the bottom board is located and leveled, anchor it in place with the  $\frac{3}{4}$ " truss-head screws supplied. Note: Rubbing soap on the inside surfaces of the end channels will let the wood slide in easier.

**For solid wood walls,** continue installing all remaining wall boards and secure in place with the  $\frac{3}{4}$ " truss head screws supplied. Complete installation by adding two (2) wall braces (item 3, Part #4503) vertically, one above the other, and centered on the stall wall, outside whenever possible.

**For grill work walls,** continue installing wall boards up to the top of the lower end channels.

### Installing Grill Work in Front Walls

**Step 3:** Using the  $\frac{3}{4}$ " truss-head screws, install two (2) header channels (item 2, part #4502) one on the corner post and one on the center post  $35\frac{1}{4}$ " above the top 2" x 10" wall board. The  $35\frac{1}{4}$ " dimension is from the top of the 2" x 10" to the bottom of the header channel.

**Step 4:** The grill work pipes have two dimples on each end which are used to hold the pipes in the U channels. To assemble, make sure a plastic grommet is installed in each pipe hole in the U channel then push the pipes into the U channel until they snap into place.

**Note:** If you plan to install a Model 4250 Feeder Door into the grill work, remove three bars from the area where you want the door located. Slip the Feeder Door over the pipe by the opening. This pipe will act as a hinge. The spring-loaded latch must face toward the aisle.

After all pipes are in place, place the grill work assembly over the wall board and press down until the pipes come into contact with the lumber.

**Step 5:** Slip the first header board (2" x 6") into the header channels installed in step 3, and slide down until it rests firmly on top of the pipes in the grill work. Set the second header (2" X 8") on top of the first and attach through the header channels.

**Step 6:** At this point, the remaining  $\frac{3}{4}$ " truss-head screws should be installed in the header channels and the upper and lower grill work U channels.

**Step 7:** Using the  $\frac{3}{4}$ " truss-head screws furnished, install the wall brace centered vertically on the wall below the grill work, outside the stall whenever possible.

**Step 8:** To install the door header, use the  $\frac{3}{4}$ " truss-head screws supplied, install two (2) header channels, one on the door corner post and one on the center post. ( $88\frac{1}{4}$ " above the floor measured to the bottom of the header channel.) The header channels should be  $1\frac{3}{4}$ " inset from the front of the door corner post and flush with the front of the center post. This is inset from the corner post line, shown in figure 1 and 2.

**Step 9:** Install the 2" x 8" wood door header into the header channels installed in step 8 above. Set the top of the door header board at  $95\frac{1}{4}$ ". (This dimension may be adjusted for building and wood tolerances to allow the door to align with the stall front).

## Side Wall System Assembly

**Step 1:** Install the end channels centered on the inside surface of the corner posts, as shown in the Assembly Drawing. All channels should be placed  $\frac{1}{2}$ " above the floor surface and anchored with the  $\frac{3}{4}$ " truss-head screws supplied.

**For solid wood walls,** fasten two (2) end channels to each post, one directly above the other.

**For grill work walls,** fasten only one (1) end channel at the bottom of each post.

**Step 2:** You are now ready to install the wall lumber. Slide the first board down to  $\frac{1}{2}$ " below the bottom of the end channels. After the bottom board is located and leveled, anchor it in place with the  $\frac{3}{4}$ " truss-head screws supplied. Note: Rubbing soap on the inside surface of the end channels will let the wood slide easier.

**For solid wood walls,** continue installing all remaining wall boards and secure in place with the  $\frac{3}{4}$ " truss-head screws supplied. Complete installation by adding two (2) wall braces (item 3) vertically, one above the other, and centered on the wall. Secure with  $\frac{3}{4}$ " truss-head screws supplied.

**For grill work walls,** continue installing wall boards up to the top of the lower end channels. Finally, install one wall brace (item 3) below the grill work.

**Step 3:** Using the  $\frac{3}{4}$ " truss-head screws, install two (2) header channels, one on the corner post and one on the center post  $35\frac{1}{4}$ " above the top 2" x 10" wall board. The  $35\frac{1}{4}$ " dimension is from the top of the 2" x 10" to the bottom of the header channel.

**Step 4:** The grill work pipes have two dimples on each end which are used to hold the pipes in the U channels. To assemble, make sure a plastic grommet is installed in each pipe hole in the U channel then push the pipes into the U channel until they snap into place.

**Note:** If you plan to install a Model 4250 Feeder Door into the grill work, remove three bars from the area where you want the door located. Slip the Feeder Door over the pipe by the opening. This pipe will act as a hinge. The spring loaded latch must face toward the aisle.

After all pipes are in place, place the grill work assembly over the wall board and press down until the pipes come into contact with the lumber.

**Step 5:** Slip the header board (2" x 6") into the header channels installed in step 3, and slide down until it rests firmly on top of the pipes in the grill work.

**Step 6:** At this point, the remaining  $\frac{3}{4}$ " truss-head screws should be installed in the header channels and the upper and lower grill work U channels.

**Step 7:** Using the  $\frac{3}{4}$ " truss-head screws furnished, install the wall brace (item 3) centered vertically on the wall below the grill work, outside the stall whenever possible. A solid wall requires two (2) wall braces, one directly above the other.



# Lumber Requirements\*

\*Use only DRY lumber in contact with Equus components. Green Lumber is not authorized and the product warranty is void if Green lumber is used. Green lumber can cause immediate rust.

The first step in building your Equus Stall is to decide on the finished size you desire, which determines the lumber lengths.

Any size stall can be built using the Equus System.

1. Corner post can be set 10' or 12' (or any other spacing as desired) on center to fit building design or special needs. Equus grill work channels will have to be cut to fit space between post if this system is used.

2. Preferred option is to set the face to face dimension between 4x4 (nominal 3 1/2" x 3 1/2") post an even two foot spacing plus 1/2" to use the Equus grill system without cutting.

The following specifications cover the lumber required for each Equus wall model using the preferred size system above. Lumber listed is for 12' side walls. Should your needs be different, change the lumber lengths accordingly. Treated lumber and dimensional lumber measuring no more than 1 1/2" thick is recommended.

Typical corner posts are standard 4x4's measuring 3 1/2" x 3 1/2". Five (5) posts are required for the first stall and three (3) additional posts for each stall thereafter, when constructed side-by-side. Note: All 4x4 posts should be 8' in length above the ground. Longer posts are required if they are to be embedded in the ground. Larger posts may be used but will change the stall size in order to build the stall without cutting the grill work channels.

## Model 4650 - Front Wall with Grill Work and Door:

- 5 - 2" x 10" x 48" Boards for door
- 1 - 2" x 6" x 48" Board for top of door
- 1 - 2" x 8" x 44" Track board above door
- 1 - 2" x 4" Treated x 96" or 72" for bottom of front wall
- 5 - 2" x 10" x 96" or 72" for front wall
- 1 - 2" x 6" x 96" or 72" front wall header board
- 1 - 2" x 8" x 96" or 72" front wall track board

## Model 4550 - Solid Front Wall with Door:

- 5 - 2" x 10" x 48" Boards for door
- 1 - 2" x 6" x 48" Board for top of door
- 1 - 2" x 8" x 44" Track board above door
- 1 - 2" x 4" Treated x 96" or 72" for bottom of front wall
- 10 - 2" x 10" x 96" or 72" for front wall

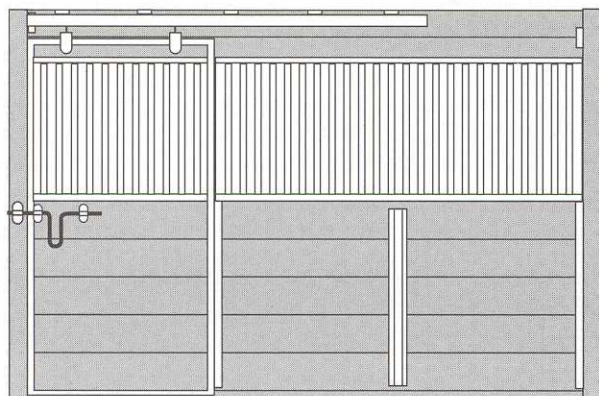
## Model 4600 - Side Wall with Grill Work:

- 1 - 2" x 4" Treated x 144" or 120" for bottom of side wall
- 5 - 2" x 10" x 144" or 120" for side wall
- 1 - 2" x 6" x 144" or 120" side wall header board
- 1 - 2" x 8" x 144" or 120" side wall top header board

## Model 4500 - Solid Side Wall:

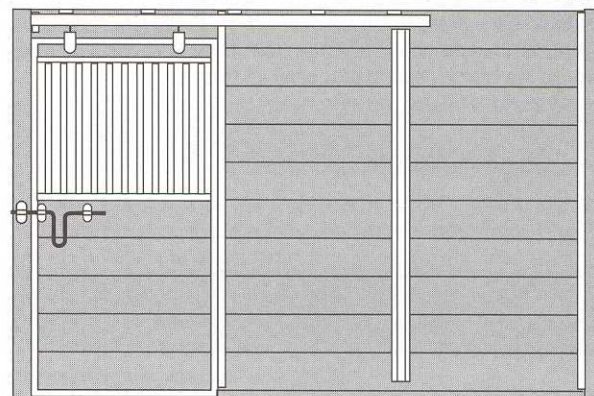
- 1 - 2" x 4" Treated x 144" or 120" for bottom of side wall
- 10 - 2" x 10" x 144" or 120" for side wall

# EQUUS HARDWARE COMPONENTS SUPPLIED



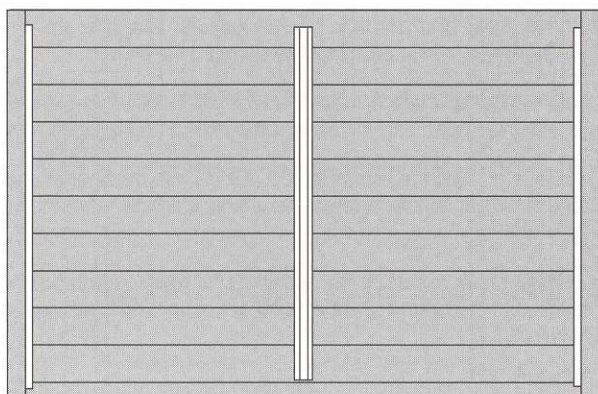
## Model 4650 Wall and Door System:

- 1 - Sliding Door System..... Part No. 4800
  - 2 - Grill Work sections..... Part No. 4000  
10' front includes 1 @ 24" and 1 @ 48"  
12' front includes 2 @ 48"
  - 2 - End Channels..... Part No. 4501-48
  - 4 - Header Channels..... Part No. 4502
  - 1 - Wall Brace..... Part No. 4503-48
  - \*1 - Track & Hardware pkg..... Part No. 4900 or 4901
- Door dimensions are 48" wide, 87 1/4" high. Top of track board must be at least 95 1/4" to allow door grill to align with wall grill.



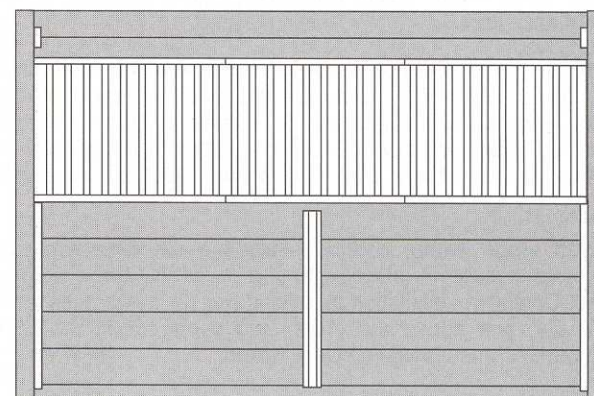
## Model 4550 Wall and Door System:

- 1 - Sliding Door System..... Part No. 4800
  - 2 - End Channels..... Part No. 4501-96
  - 2 - Header Channels..... Part No. 4502
  - 1 - Wall Brace..... Part No. 4503-96
  - \*1 - Track & Hardware pkg..... Part No. 4900 or 4901
- Door dimensions are 48" wide, 87 1/4" high. Top of track board must be at least 95 1/4" to allow door grill to align with wall grill.



## Model 4500 Wall System:

- 2 - End Channels.....Part No. 4501-96
- 1 - Wall Brace.....Part No. 4503-96



## Model 4600 Wall System:

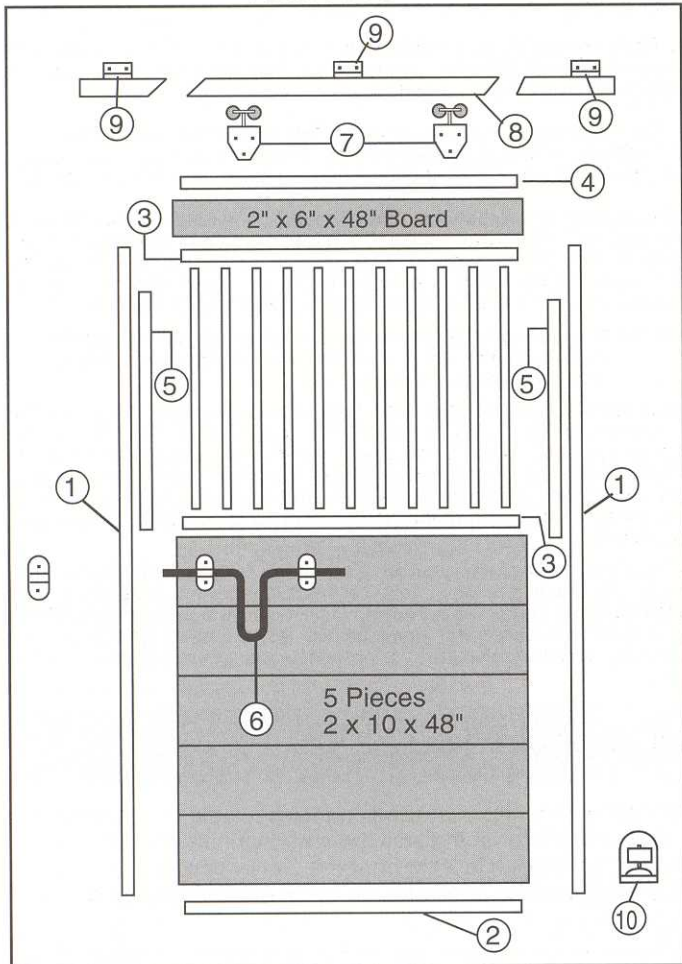
- 3 - Grill Work sections..... Part No. 4000  
10' wall includes 1 @ 24" and 2 @ 48"  
12' front includes 3 @ 48"
- 2 - End Channels..... Part No. 4501-48
- 2 - Header Channels..... Part No. 4502
- 1 - Wall Brace..... Part No. 4503-48

\* Additional Materials Required.



# Sliding Door Assembly Part Number 4800

FIGURE 3



**Step 1:** Slide the five pieces of 2" x 10" into the left and right channels (item 1) keeping them up from the bottom by 1 1/2". Allow 1/8" space between each board and alternate grain direction from board to board. Alternating the grain direction will reduce the effect of board warp.

**Step 2:** Install both side caps (item 5) into the left and right side channels (item 1) using two of the truss-head screws supplied. These side caps simply slide into the side channels. Holes must be aligned.

**Step 3:** Assemble the door grill by snapping the pipes into the grommet installed into the U Channels (item 3), making sure that the truss-head screws are all facing the front of the door. Note: The top U channel has additional holes for the optional pendant type door trolley hangers (not shown).

**Step 4:** Install the assembled grill work into the door by sliding the bottom U channel over the top 2" x 10" allowing the pipes to touch the wood.

**Step 5:** Slide the 2" x 6" x 48" top rail board down, between the left and right side channel (item 1), into the top U Channel firmly pressing down on the grill work pipes.

**Step 6:** Slide the top channel (item 4) down onto the 2" x 6" x 48" board installed in step 5.

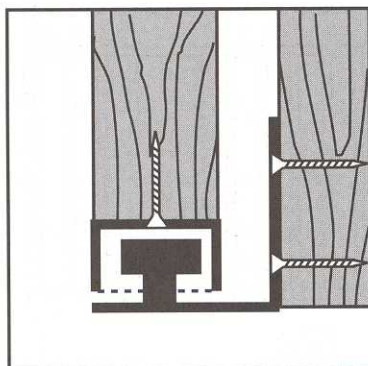
**Step 7:** Square the door by measuring diagonally from corner to corner. Hold square and install all screws. The 2" x 6" top board must press firmly on the grill pipes when fastened. Adjust u-channels and fasten.

**Step 8:** Install the door latch (item 6) on the left or right side of the door, as desired, using the fasteners that are packaged with the latch. Placement is indicated in figure 3.

**Step 9:** Install the trolley hangers (item 7) according to the directions furnished with the style of hangers ordered.

**Step 10:** Install the bottom door channel (item 2) with truss-head screws (see figure 4). Drilling is advised to prevent splitting the wood.

FIGURE 4



## Hanging the Door

**NOTICE:** Plyco has a continuing policy of product improvement and reserves the right to make product changes without incurring an obligation to make changes in Plyco or Equus products previously sold. The information in this instruction sheet is subject to change without notice. Plyco assumes no responsibility for any errors that may inadvertently appear herein.

**Step 1:** Fasten the Door Track (item 8, part of kit #4900 or 4901) to the track board with top of mounting brackets (item 9) at 96 1/2" above the floor. This dimension may need to be adjusted due to variations in wood size to get the door grill to align with the wall grill. Hold the track in place with the door attached to confirm alignment before attaching the track. Use 3/8" x 2" lag bolts furnished to mount the track. This allows for about 1 1/2" clearance under the door for bottom stay roller.

**Step 2:** Using the No. 10 screws supplied, install the stay roller (item 10) on the wall at the lower corner of the door opposite the door latch (see figure 3) so that it can run within the bottom door channel.

**Step 3:** Hang the door by sliding the trolley hangers (item 7) into the door track from one end while, at the same time, sliding the bottom door channel (item 2) over the stay roller (item 10).

**Note:** The bottom rail channel fits between the door verticals, and is flush with the bottom of the door verticals. The door verticals will act as a stop in the open and closed position.

**Note:** Figure 4 is shown without door verticals. Bottom rail is attached with open part down.

**PLYCO**  
CORPORATION

Elkhart Lake, Wisconsin 53020

USA  
800-558-5895  
Fax 800-257-5926

INTERNATIONAL  
414-876-3611  
Fax 414-876-3527