

ALL $\frac{3}{4}$ " AND $\frac{1}{2}$ " Tubing is stock.

ALL PARTITIONS ARE OF TEMPERED $\frac{1}{8}$ "

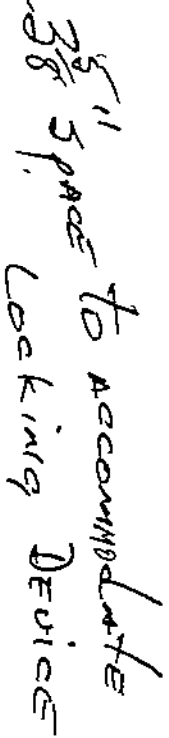
HARD BOARD ATTACHED TO THE FRAME WITH
POP RIVETS EVERY $3\frac{5}{8}$ " THIS ALLOWS FOR
PLENTY OF VERTICAL STRENGTH AND DURABILITY
Below is a list of TOOLS AND SUPPLIES -
WITH THESE PRESENT THESE BOXES CAN
BE BUILT IN 40 MAN HOURS.

ARC WELDER
ACETYLENE TORCH
HAND GRINDER
HAND DRILL
 $\frac{7}{16}$ $\frac{3}{8}$ $\frac{1}{8}$ BITS
SOCKET SET.
 $\frac{1}{2}$ $\frac{3}{4}$ $\frac{9}{16}$ OPEN END WRENCHES
POP RIVET GUN

10 SECTIONS $\frac{3}{4}$ " Tubing
3 SECTIONS $\frac{1}{2}$ " Tubing
1 4'x8' PC MARINE Ply
4 4'x8' PC TEMPERED HARDWOOD
400 $\frac{1}{8}$ x $\frac{3}{8}$ POP RIVETS
PAINT
12 PCS WALL STANDARDS
1 PC 4'x8' PEG BOARD
1 PC 2x2 HARD WOOD
RUBBERIZED STAIR
RUNNER

Fig I STANDARD $\frac{3}{4}$ " Square Tubing
HEATED AND BENT AT points 1, 2 heat. with
ACETYLENE TORCH AND BEND ON FLAT SURFACE
TO INSURE of Tubing NOT turning. If Tubing
TURNS a good fit will be difficult
Tubing is welded with ARC WELDER
AT points W1 - W2 - W3 ANGLES should
be CLEAN AND WELL-fitted BEFORE welding. After
completing 12 of these, cut 6 pieces $9\frac{1}{2}$ " long
~~and~~ 8 pieces 2" long AND 2 pieces $3\frac{5}{8}$ " long
Fig 5 (STANDING) will crudely demonstrate the
USE of these pieces to SPACE the BOXES
AND TO ALLOW WORKING ROOM BETWEEN BOX 3
AND BOX 4 FOR INSTALLING AND REPAIR
TO THE LOCKING DEVICE.

3

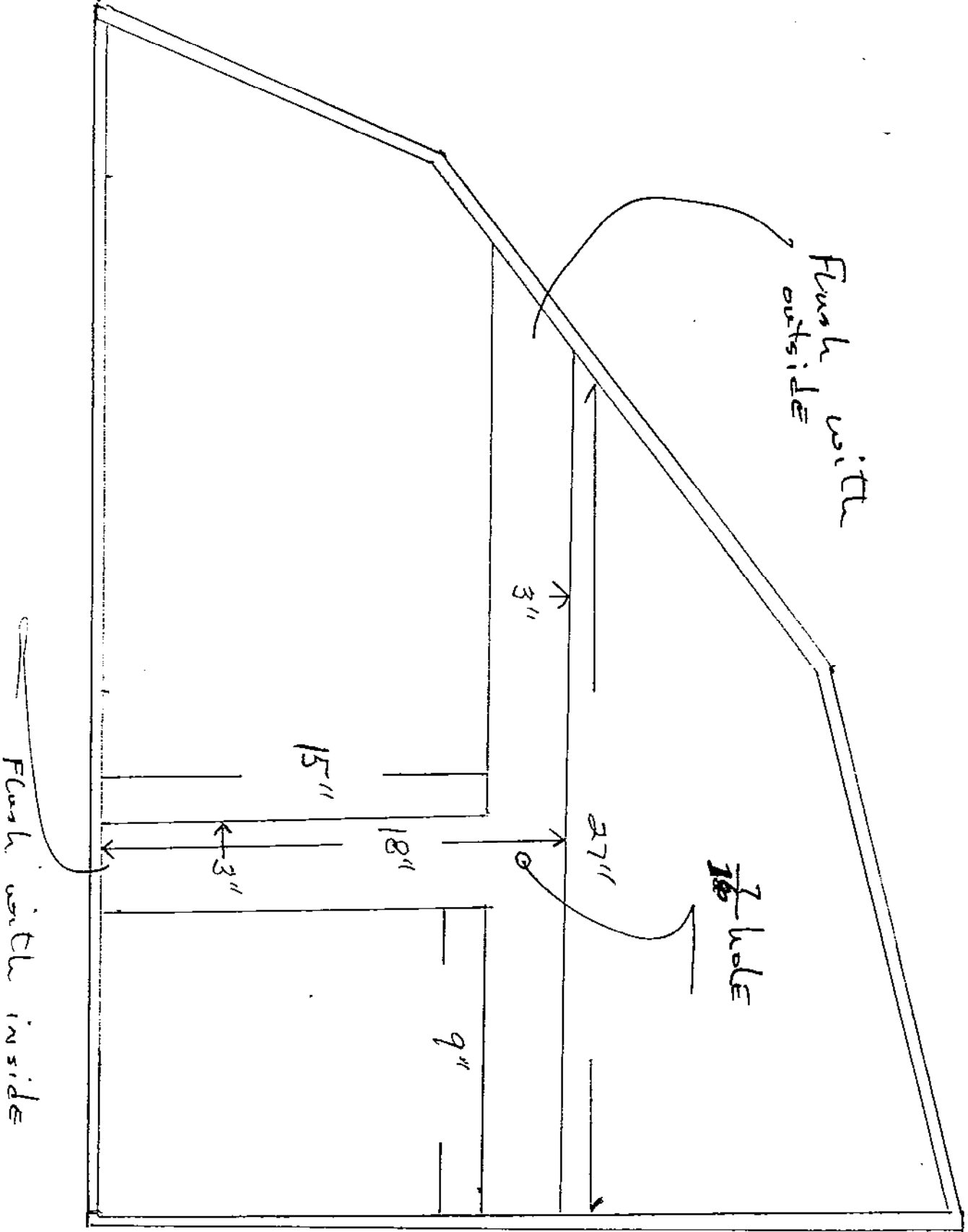


6 deg bar $76 \frac{1}{2} \times 44$

The $\frac{3}{8}$ " Flat stock absorbs 80% of the
STRESS . . . AND MUST FIT WELL.

By placing the bottom flush with
the interior of the tubing and the top flush
with the outside a strong fit will result.

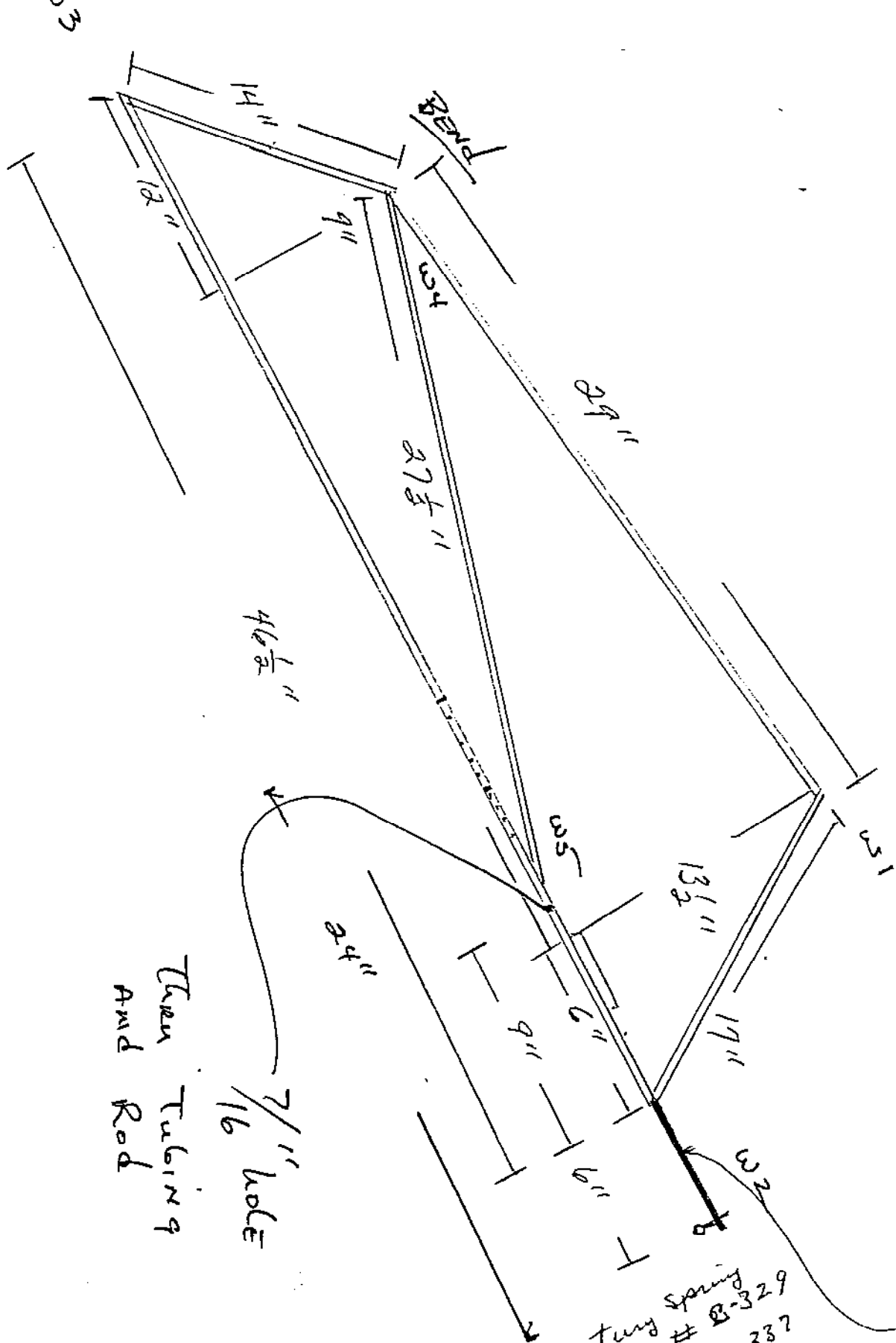
the pivot bolt is a $\frac{7}{16}$ TEMPERED BOLT with
A 1" shoulder inserted from the inside
so the lock nuts ARE ON THE EXTERIOR.



The gate must fit the contour of the box or the locking device will not function and a bigger hazard is that the dogs will be distracted trying to get out. the result of a bad fit is that the muzzles will frequently get caught in the end bars and be removed from the dogs.

The rod carries the full measure of weight ~ tension and never has a rest position so the hole must be exactly centered. Use of a center punch will aid in all drilled holes.

All welded points should be ground smooth and must fit closely to insure strength and reduce the rust factor



5/8" Cold roll Rod must be pushed in to gate prior to dailing.

Then Tubing And Rod

4 Dog Box Century Spring Co. L.A. # B-329 # B-337
6 Dog Box

24"

29"

14"

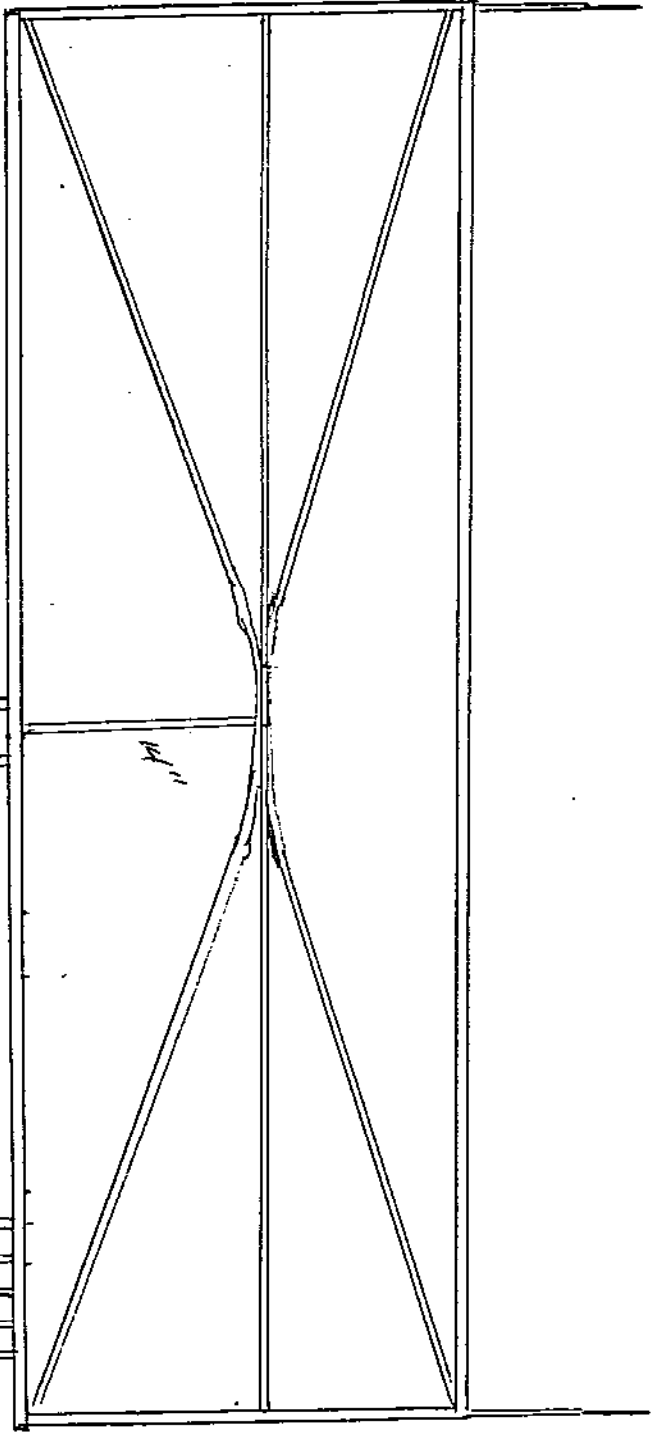
3/4" x 13"

locking Gate

1 3/4" space

1/2" x 13" Tines

Centered to the dog box



The Locking device is a simple LEVER operated SPEAR engaging the GATE. AS SHOWN

the SPEAR should move only $1\frac{1}{2}$ inches forward motion stopped by a bead welded to the ROD REARWARD motion impaired by the $\frac{3}{8}$ "

REAR CROSS MEMBER

$\frac{1}{2}$ " TUBING ELEVATES the front end of the SPEAR this is held in place with 2 $\frac{3}{4}$ " WOOD SCREWS. REMOVAL of this piece FACILITATES REPAIR OR REPLACEMENT of Locking SPEAR OR COMPONENTS

the LEVER is centered on $\frac{3}{8}$ " ALL THREAD by 2 NUTS ACTING AS LOCK NUTS ON EACH side of the LEVER use of a BICYCLE grip the LEVER operation should give the operator AN EASY TASK.

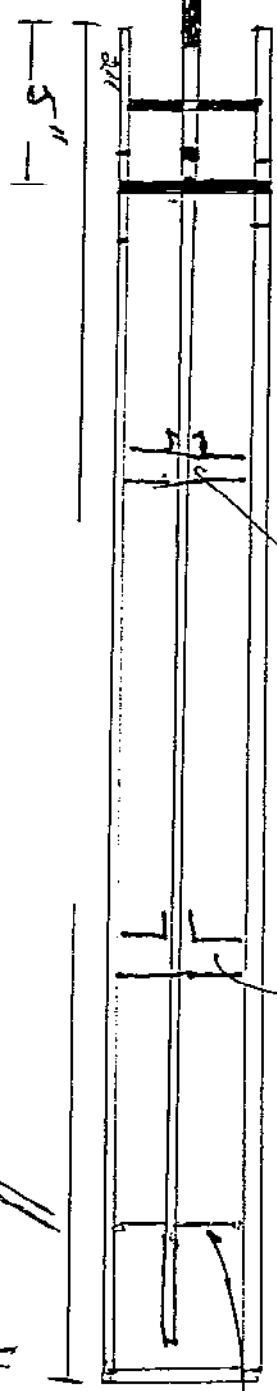
1" square
2 3/8" tube

12" Riser

1" P.U.C. Tee don't
install to aim

locking space

3/8" ALL Thread



5" - 1

4 1/2"

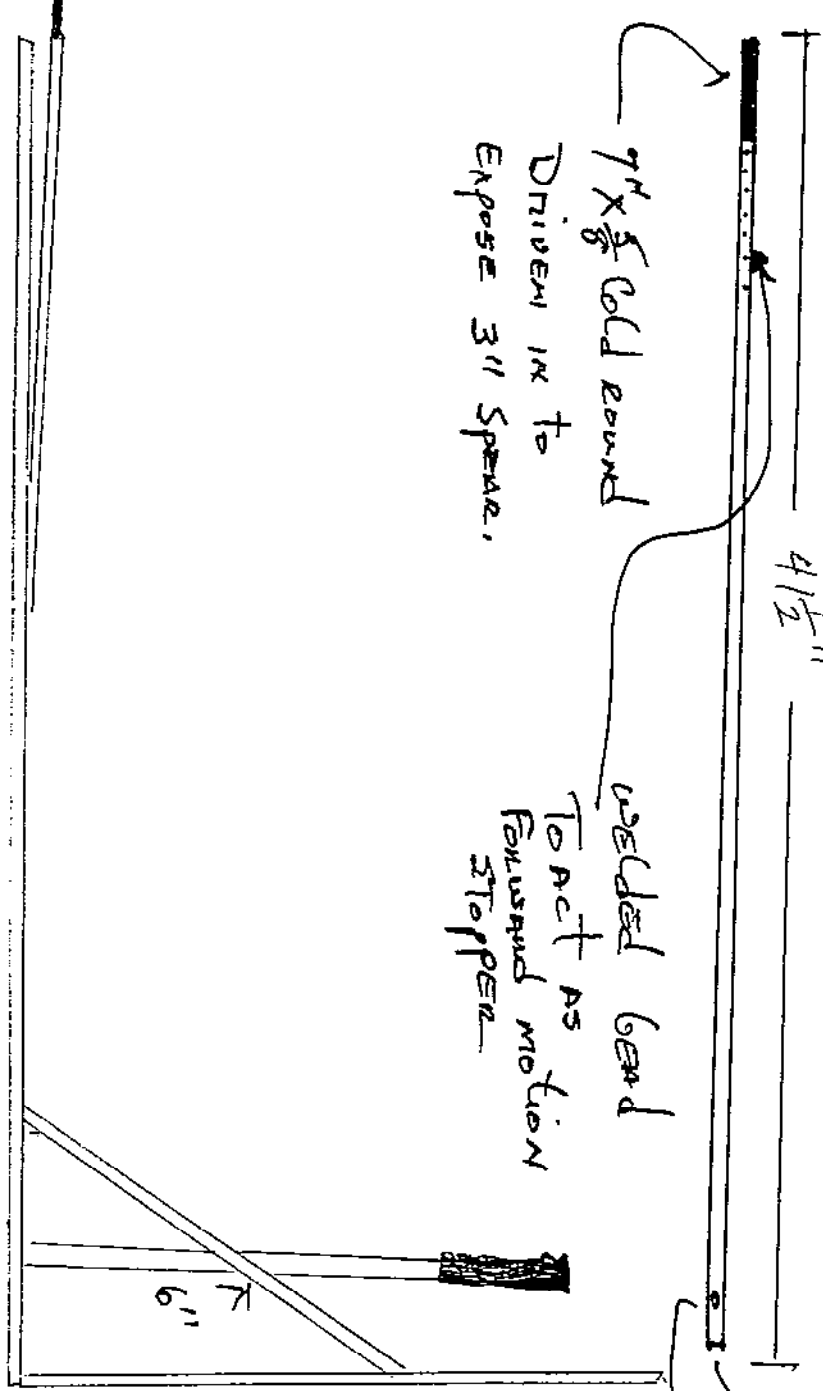
5 1/2"

7" x 5/8" Cold Round
Driven in to
Expose 3" Space.

welded bead
To act as
Forward motion
stopper

Side elevation
of piston

3/8 hole to
Reambulate lever



THE REAR DOORS ARE PEG BOARD
TO ALLOW MAXIMUM VENTILATION AND LIGHT
IN THE BOX. THE GUIDES ARE
SHELVING STANDARDS CUT TO FIT.

THE 2" SQUARE WOOD SERVES AS
HANDLE AND STOPPER. THE HANDLE SHOULD
BE PAINTED TO IDENTIFY PROPER BOX

