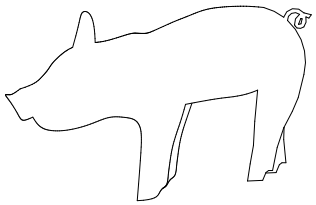
SUPREME FEEDER

MANUAL NO. 166156
REV F / 12-29-22 ECN 22-080

12 DOOR HOG FEEDER
ASSEMBLY INSTRUCTIONS

This feeder is designed for feeding an average hog from about 40 pounds up to about 250 pounds. Some different breeds of hogs might require modifications, different feed flow adjustments, or different feeding techniques for this feeder to do its job properly. Contact your Sioux dealer if you have any questions.



Assembly Video of Feeder can be found at:
https://www.youtube.com/watch?v=aqJ9EWoTbqk&t=37s

- **STEP #1** Check the parts against the packing list. Any claims for damage in shipping should be made with the delivery carrier immediately. Any shortage claims against the packing list should be made to Sioux Steel Co. promptly. When ordering repair parts please use the correct part number as shown on the packing list.

- **STEP #2** If the (6) 147021 taper hopper parts have not already been bolted to the bottom assembly, position the first tapper hopper outside the inner band/drain channel assembly so that notches fit around the two bolts found on the inner band/drain channel assembly. Utilizing a 1/4 x 1.00 thread forming screw, bolt the center hole of taper hopper to the inner band. Continue mounting other 6 taper hopper parts by overlapping the taper hopper utilizing the 1/4" x 1" thread forming screw in the center holes of each taper hopper. Connect the seams of the taper hopper together using ¼" x .50 thread forming screws and ¼" rubber washer. Finally on the bottom of the taper hopper to inner band/drain channel where the taper hopper overlaps use a ¼" x ¾" drill screw. See hopper assembly you tube video at https://youtu.be/K5dXHEA18r4 for more detailed instructions. Refer to illustration #1 for part identification.

- **STEP #3** Install the (4) adjuster tubes (166173). IMPORTANT – Attach each tube to the adjusting band with 5/16 lock nuts and 5/16 flat washers as seen in illustration #7. At this point DO NOT tighten these nuts. Attach the tops of the adjuster tubes to the adjuster disk with 5/16 lock nuts – make sure the concave side of the disk is up. Be cautious not to over-tighten these nuts. Do not assemble the adjuster crank at this time.

- **STEP #4** The hopper rings are pairs of sections which should be assembled into rings before being set on the taper hopper.

  Hopper Extension Assembly
  Assemble the two hopper extension sections together with 1/4 x 5/8 bolts and 1/4 flange nuts in all except the top and bottom holes of the vertical seams. Lap the ends together according to illustration #8 and any markings on the sections. Position the completed extension ring over the taper hopper with the fold down. Position the vertical seam on the extension hopper to the front (between the skids). Secure the extension ring to the taper hopper with 1/4 x 5/8 bolts and 1/4 flange nuts.

Main Hopper Extension Assembly

Position the hopper splice over the main hopper section rolled ends and secure the front hopper section to the rear section with the 1/4 x 5/8 bolts and 1/4 flange nuts in all the holes of the vertical seam except the bottom holes. The sections are lapped together according to illustration #8, with the hemmed edge down. Position the main hopper assembly onto the extension hopper assembly so that the section with the hole for the lid lock (1 hole) is toward the front of the feeder (this is the side the step will be attached & the side the feeder will be filled from). Secure the main hopper to the extension hopper with 1/4 x 5/8 bolts and 1/4 flange nuts. Attach the lid lock to the front hopper section loosely with a #10 x 1/2 locking screw & #10 hex nut; do not over-tighten, the lid lock must swing freely. Attach the lid hold down clip directly opposite the lid lock with two (2) 1/4 x 5/8 hex bolt and 1/4 flange nuts.

Attach step as shown in illustration #6 using 1/4 x 5/8 hex bolts, and 1/4 flange nuts. If holes are not provided for the steps, holes must be drilled (9/32 diameter). Prick marks are provided at four (4) spots around each hopper ring for this purpose.

- **STEP #5** Assemble the adjuster crank to the adjuster bar with 1/2 flat washers and 3/16 x 1 cotter pins as shown in illustration #2. Thread the adjuster crank down into the adjuster disk about 1". Position the ends of the adjuster bar in line with the hopper splice clips and secure each end with 1/4 x 5/8 hex head bolts and 1/4 flange nuts. Turn the crank to make sure the feed adjusting band moves up and down its entire range freely. It is usually best to leave the threads of the adjuster crank ungreased. Dust and feed tend to build up on the greased threads and in time forms a gummy deposit that interferes with the adjustment.

- **STEP #6** Attach the lid stop to the top lid using 1/4 x 5/8 hex head bolts, 1/4 flange nuts and 1-1/4 flat washer (flat washer & bolt head on top). Attach the lid w-rod to the top lid using 1/4 x 5/8 bolts, 1/4 flange nuts as shown in illustration #4. Position the lid over the main hopper according to illustration #4, raise the front by the handle, and slide the lid back until it is held by the lid stop. With the top lid in the open position attach the lid w-rod brackets to the adjuster bar using 1/4 x 5/8 hex head bolts, 1/4 flange nuts. See illustration #4.

- **STEP #7** Make sure the feed band is completely flat against the bottom of the feeder and tighten the 5/16 lock nuts. See illustration #7.

- **STEP #8** For standard ground feeds and for pigs weighing about 100 pounds the suggested starting feed band adjustment height is 1-1/8. Adjust up or down from this starting adjustment to suit your operating conditions.

  In normal operation when the feeder is level the depth of feed in all openings is approximately the same. If the feeder cannot be leveled, or if it is desired to change the feed depth on any particular side of the trough, washer(s) may be inserted between the adjuster tubes and the adjuster disk to tilt the feed adjusting band in the desired direction.

SUPREME - 12 DOOR HOG FEEDERS
PACKING LIST

PART NO.	DESCRIPTION	142002 60 BU.	142702 L/LID	142802 L/DOOR	142902 L/LID&DR
228723	BOTTOM ASSEMBLY W/DOORS	1	1	0	0
229715	BOTTOM ASSEMBLY L/DOORS	0	0	1	1
147021	TAPER HOPPER	6	6	6	6
168964	HARDWARE BAG	1	1	1	1
144026	LID ASSEMBLY	1	0	1	0
144009	W-ROD ASSEMBLY	1	0	1	0
144011	ADJUSTER BAR ASSEMBLY	1	1	1	1
144044	FRONT HOPPER w/DECALS	1	1	1	1
144018	REAR HOPPER	1	1	1	1
166173	ADJUSTER TUBE	4	4	4	4
144052	EXTENSION HOPPER	2	2	2	2

PACKING LIST CONTINUED:

168964 BASIC HARDWARE BUNDLE 60 BU

PART NO.	DESCRIPTION	QTY
133044	LID STOP	1
133055	CRANK	1
133074	STEP BACK-UP PLATE	2
133093	STEP	1
133096	ADJUSTER DISC	1
144006	HOPPER SPLICE	2
144014	LID HOLD DOWN CLIP	1
157936	LID LOCK	1
154063	5/16 FLAT WASHER	4
154069	1/2 FLAT WASHER	2
157224	5/16 ELASTIC LOCK NUT	8
159627	#10 ELASTIC LOCK NUT	6
164781	1/4 FLANGE NUT	90
164785	1/4 X 5/8 HEX HEAD BOLT	90
164787	3/16 X 1 COTTER PIN	2
168056	#10 X 1/2 HEX HEAD SCREW	6
224377	1/4" RUBBER WASHER	24
224378	1/4 X .50 THREAD FORMING SCREW	24
229716	1/4 X 1.00 THREAD FORMING SCREW	6
187299	1/4" X 3/4" SELF DRILLING SCREW	6
166156	SUPREME FEEDER MANUAL	1

#168966 EXTENSION HARDWARE BUNDLE - NEW STYLE

PART NO.	DESCRIPTION	QTY
133093	STEP	1
133074	STEP BACK-UP PLATE	2
164785	1/4 X 5/8 HEX BOLT	46
164781	1/4 FLANGE NUT	46
157224	5/16 ELASTIC LOCK NUT	8
154063	5/16 FLAT WASHER	4

ILLUSTRATION #1

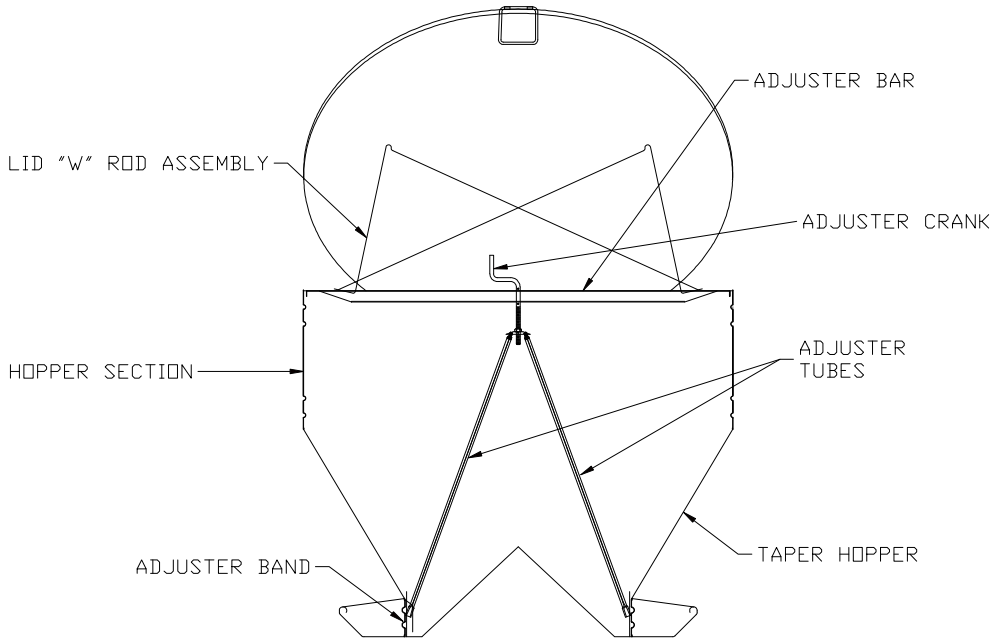


ILLUSTRATION #2

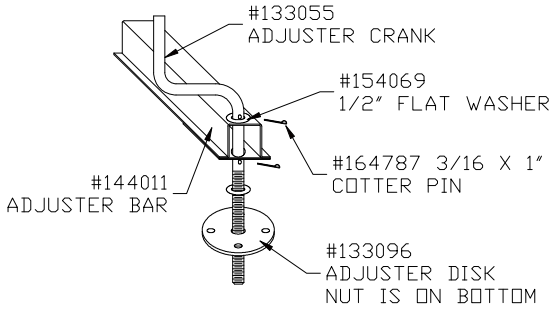


ILLUSTRATION #3

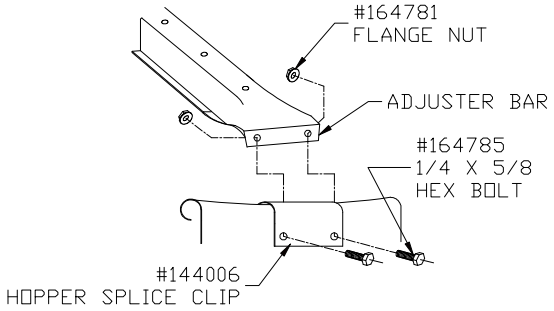
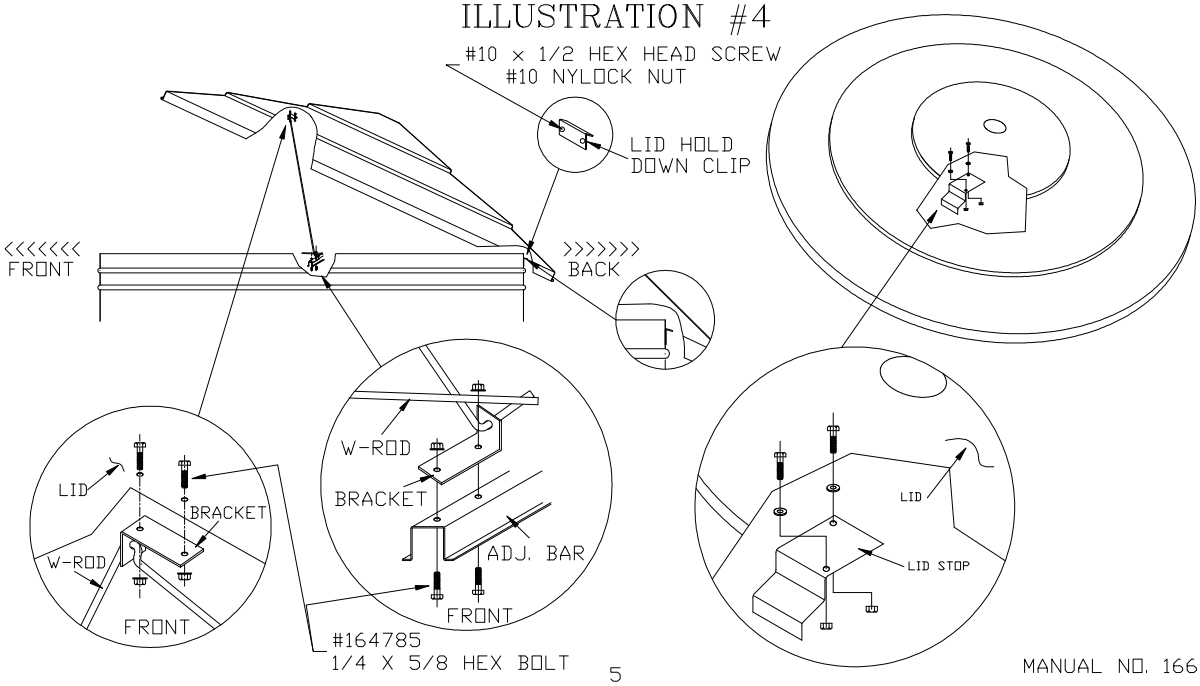


ILLUSTRATION #4



MANUAL NO. 166156

ILLUSTRATION #5

TWO RING SIZE SHOWN

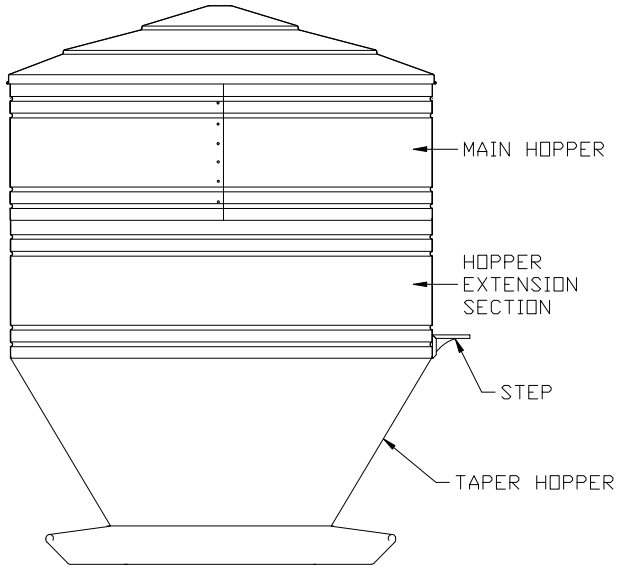
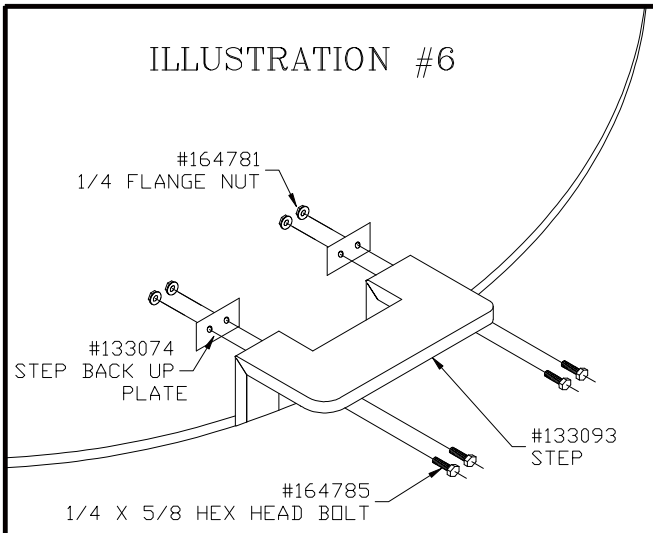


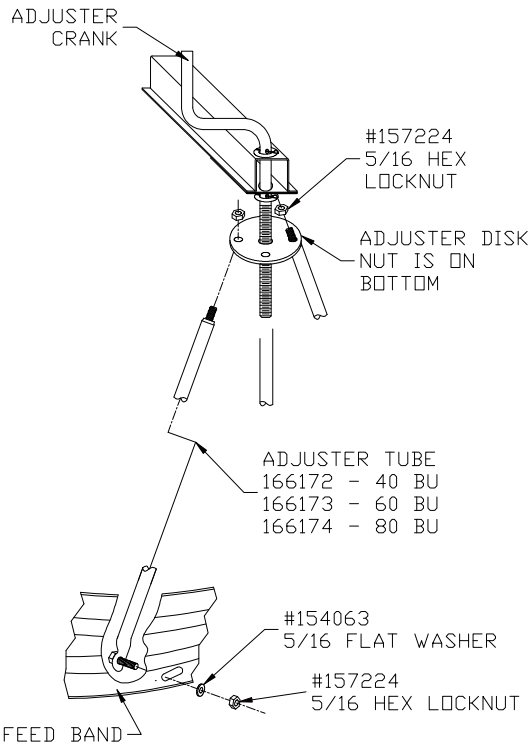
ILLUSTRATION #6



DRILL PRICK MARKS WITH 9/32 DIA DRILL

ILLUSTRATION #7

TWO RING SIZE SHOWN



THE SLOTS IN THE FEED BAND ARE TO ALLOW FOR LEVELING OF THE FEED BAND AFTER ASSEMBLY IS COMPLETE. THE 5/16 NUTS MUST BE TIGHT FOR PROPER OPERATION.

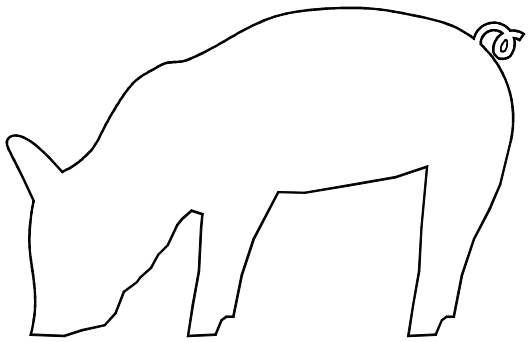
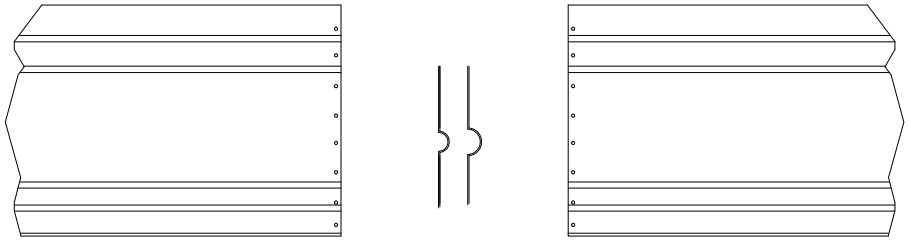


ILLUSTRATION #8



OVERLAP BEADS - POSITION HEMMED SIDE DOWN

MANUAL NO. 166156

Sioux Steel Co.
196 1/2 East 6th Street
P.O. Box 1265
Sioux Falls, SD 57101-1265

Phone: .....(800) 557-4689
(605) 336-1750
(605) 557-4689
Sales Fax: ....(605) 357-8597
Fax: .....(605) 336-2528

NEW PRODUCT WARRANTY

HIQUAL & LIVESTOCK EQUIPMENT

A. GENERAL PROVISIONS. "Sioux Steel" means Sioux Steel Company, 196 1/2 East Sixth Street, Sioux Falls, South Dakota 57104. The warranties described below are provided by Sioux Steel to the original purchasers of new products purchased from Sioux Steel or from an authorized Sioux Steel Dealer (the "Products"). Under these warranties, Sioux Steel will, at its option, repair or replace at its factory any Product covered under these warranties which is found to be defective in material and workmanship during the applicable warranty term or refund the purchase price paid for the defective Product. Customer will be responsible for labor charges for removing the defective Product and reinstalling the repaired or replacement Product, any premium charge for overtime labor requested of Sioux Steel and shipping charges to and from Sioux Steel's factory. These warranties are not transferrable.

B. WARRANTY PERIOD. Subject to exclusions and limitations set forth herein, each new Product is warranted for the number of years specified below. Each warranty term begins from the date of purchase to the (End User) regardless of delay in receipt of the Product by Customer due to the time required to process, handle, ship, assemble, construct and install the Product. Customer must retain proof of the date of purchase. Replacement parts for and repairs to the Product will be warranted only for the remainder of the original warranty term. The replacement parts for or repairs to the Product will not extend the warranty term beyond the original warranty term. Products described below include all parts, components and accessories.

Product/Part Name	8 Years	3 Years	Lifetime Warranty	1 Year
Victory, Cattleman's, Heavy Duty and Super Six steel construction livestock gates labeled through the Company's "Lifetime Guarantee Gate Program" ("Lifetime Guaranteed Gates")			X	
Locking Mechanisms			X	
Rump Fingers			X	
Cleated Rubber Flooring			X	
Squeeze Chutes	X			
Head Gates	X			
Calving Pens		X		
Hydraulic Chute	X			
Hydraulic Components				X
Hydraulic Calf Chute	X			
Hydraulic Components				X
Palp Cage (Pin On)		X		
Crowding Tubs		X		
Scale Equipment		X		
Adjustable Alleys		X		
Slick Door (Pin On)		X		
Bow Gates		X		
Panel - Heavy Duty and 2" Range Tough		X		
Portable Systems and chute				X

Product/Part Name	8 Years	3 Years	Lifetime Warranty	1 Year
All Other Livestock Equipment, including Bulk Bins, Poly products and all Livestock Gates that are not labeled through the "Guarantee Gate Program" as provided above				X
Post Pounder **Note:** Commercial or Government use (6 Month warranty)				X

Exclusions specific to Livestock Equipment: Damage or loss of any kind from (1) storage of feed products that are not free-flowing or that have a density greater than 40 pounds per square foot; and (2) the storage of materials other than free-flowing livestock feed.

C. ITEMS COVERED SEPARATELY. The Sioux Steel warranties do not cover any parts, components or materials that are part of the Product, or used in conjunction with the Product, that are not manufactured by Sioux Steel. Such parts, components and materials will be subject to the warranties provided by the manufacturer, if any.

D. WHAT IS NOT WARRANTED. Sioux Steel does not warrant and is not responsible for the following: (1) used products; (2) modification or alteration of the Products; (3) Products that have not been properly installed or not installed in accordance with the instruction manual, improper assembly, or improper construction by any persons other than Sioux Steel employees; (4) depreciation, damage or loss caused by the use of parts, components or accessories not provided by Sioux Steel, unauthorized repairs, normal wear, lack of necessary and proper maintenance, a failure to follow operating instructions/recommendations, misuse, lack of proper protection during storage, vandalism or theft, exposure to the elements or corrosive materials, accidents or acts of nature including lightning, flooding, hail, straight winds and tornadoes; and (5) cosmetic damage or damage that does not hinder the functionality of the Products. (6) Warranty does not cover corrosion.

E. LIFETIME GUARANTEED GATES. The Limited Warranty for New Sioux Steel Company Products shall apply to the Lifetime Guaranteed Gates ("Gates") for the life of the original purchaser with the exception of Section D above. Sioux Steel does not warrant and is not responsible for the following: (1) modification or alteration of the Gates; (2) cosmetic damage, normal wear and tear or damage that does not hinder the functionality of the Gates, including fading of the color; (3) damage caused by use for purposes inconsistent with its intended purpose or design; (4) damage due to use of any parts or components not supplied by the Sioux Steel.

F. LIMITATIONS OF WARRANTIES AND CUSTOMER'S REMEDIES. To the extent permitted by law, neither Sioux Steel, the Dealer nor any person or company affiliated with either of them makes any warranties, representations, conditions or promises express or implied as to the quality, performance or freedom from defects of the Products covered by these warranties other than those set forth herein. THERE ARE NO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. NEITHER SIOUX STEEL, THE DEALER, NOR ANY PERSON OR COMPANY AFFILIATED WITH EITHER OF THEM WILL BE LIABLE FOR ANY DAMAGES, INCLUDING, BUT NOT LIMITED TO, INCIDENTAL, SPECIAL, EXEMPLARY, CONSEQUENTIAL, LOST PROFITS AND REVENUES, LOST USE OF THE PRODUCTS OR ANY OTHER PROPERTY, BODILY INJURY OR PROPERTY DAMAGE CLAIMS OF ANY PERSON, LOST COMMODITIES, REMOVAL OR STORAGE COSTS FOR THE PRODUCTS, OTHER EQUIPMENT AND COMMODITIES, DAMAGE TO THE ENVIRONMENT ARISING FROM OR IN ANY MANNER RELATED TO ANY RELEASE OF HAZARDOUS MATERIALS, AND REMEDIATION EXPENSES THEREFORE, WHETHER BASED ON CONTRACT, TORT, STRICT LIABILITY OR ANY OTHER LEGAL BASIS, EVEN IF ADVISED OF THE POSSIBILITY OF SUCH DAMAGES. IN NO INSTANCE WILL SIOUX STEEL, THE DEALER OR ANY PERSON OR COMPANY AFFILIATED WITH EITHER OF THEM BE LIABLE TO CUSTOMER OR ANY PERSON IN AN AMOUNT IN EXCESS OF THE PURCHASE PRICE PAID BY CUSTOMER FOR THE PRODUCT.

G. NO DEALER WARRANTY. THE DEALER HAS NO AUTHORITY TO MAKE ANY WARRANTY, REPRESENTATION, CONDITION OR PROMISE ON BEHALF OF SIOUX STEEL, OR TO MODIFY THE TERMS OR LIMITATIONS OF THIS WARRANTY IN ANY WAY.

H. GOVERNING LAW/VENUE. These warranties, and all terms set forth herein, are governed by the laws of the State of South Dakota and, where applicable, the laws of the United States of America. Any and all disputes arising from these warranties, the purchase and use of the Products, bodily injury and property damage claims or otherwise must be venued in the South Dakota Circuit Court sitting in Minnehaha County, South Dakota. Customer agrees to such venue and waives any challenge to such court's jurisdiction based upon lack of personal jurisdiction or inconvenience.

I. SECURING WARRANTY SERVICE. In order to receive warranty services, customer must give Sioux Steel written notice of a warranty claim within 30 days of the date of discovery of the defective materials or workmanship, and Customer must complete the following steps:

(1) Obtain from Sioux Steel a Return Goods Authorization Number ("RGA Number") by calling the Customer Service Department at 1-800-557-4689, and providing the following information:

- The name of the territory representative, Dealer or Sioux Steel salesperson from whom the Product was purchased.
- The Dealer's identification number.
- The invoice number and date of purchase.
- Customer's name, phone number, fax number, mailing address and email address.
- The date that the Product will be returned.

(2) Pay the shipping charges to ship the Product to Sioux Steel's factory, and the return shipping charges.

- Sioux Steel
  Boyd Distribution
  221 E 11th Ave
  Lennox, SD 57039

(3) Reason for Return.

(4) Make sure the RMA Number is labeled visibly on the returned product.