

PRODUCT MANUAL

**ARROWLOCK 55 & 75 SERIES
CATTLE CHUTES**

5500 | 7500



SEPTEMBER 2025 | 2026015

1-877-275-6075
cs@arrowquip.com
arrowquip.com



WARNING

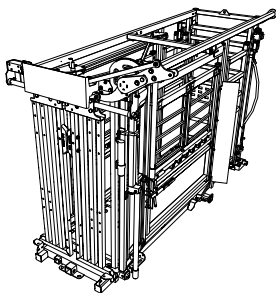
PLEASE FOLLOW ALL SAFETY INSTRUCTIONS PROVIDED IN THIS MANUAL BEFORE OPERATION.

ARROWQUIP DOES NOT ACCEPT RESPONSIBILITY FOR ANY ACCIDENTS OR INJURY WHEN THIS SAFETY MANUAL HAS NOT BEEN READ IN FULL AND KEPT WITH THE PRODUCT AT ALL TIMES.

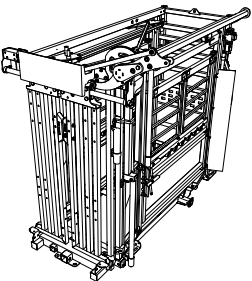
OPERATORS OF THIS PRODUCT TAKE AND ACCEPT RESPONSIBILITY FOR ANY HARM OR INJURY TO THE ANIMAL OR OPERATOR WHEN IT PERTAINS TO HOW THE EQUIPMENT IS USED AND MAINTAINED.

Please keep this manual for frequent reference and to pass on to new users or owners.

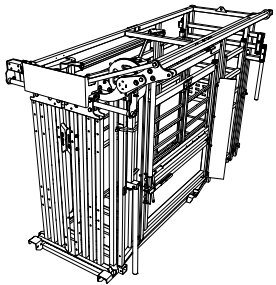
THIS PRODUCT MANUAL IS FOR THE FOLLOWING PRODUCTS:



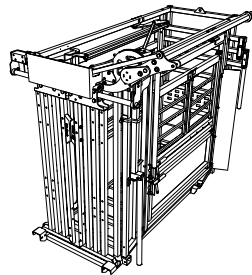
75 SERIES DELUXE VET



75 SERIES STANDARD



55 SERIES DELUXE VET



55 SERIES STANDARD

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SAFETY PRECAUTIONS

PLEASE FOLLOW ALL SAFETY INSTRUCTIONS PROVIDED IN THIS MANUAL BEFORE OPERATION. ARROWQUIP DOES NOT ACCEPT RESPONSIBILITY FOR ANY ACCIDENTS OR INJURY WHEN THIS SAFETY MANUAL HAS NOT BEEN READ IN FULL AND KEPT WITH THE PRODUCT AT ALL TIMES. ANY HARM TO THE ANIMAL OR INJURY TO THE OPERATOR WHICH OCCURS DUE TO HOW THE PRODUCT IS OPERATED, OR RESULTING FROM A LACK OF SAFETY PRECAUTIONS ARE THE SOLE RESPONSIBILITY OF THE OPERATOR.

All farm machinery and equipment are potentially dangerous. Careless use of any Arrowquip livestock equipment may cause injury or damage to persons, cattle, or property. Arrowquip has taken precautions in the design and manufacturing of this product to ensure that it is safe and user friendly. Therefore, the user must assume all responsibility and risk associated with the possession and use of the cattle squeeze chute.

SAFETY GUARANTEE

Arrowquip is committed to creating safe cattle management experiences. With this commitment to safety, in the event any purchaser of Arrowquip equipment is **physically injured while operating the equipment AND requires medical treatment**, Arrowquip will provide a **full refund** of the equipment purchase price and the purchaser will be allowed to keep the equipment. Equipment must be warranty-registered, and the purchaser must read and practice the contents and recommended maintenance and procedures outlined herein to be eligible.

Arrowquip also commits to repair or replace any part of the equipment that is defective, malfunctions or otherwise falls under normal use and inside the equipment’s warranty terms. If the equipment requires replacement, it shall be replaced with an identical model or a newer model of the equipment. For further details, visit arrowquip.com/promise.



WARNING:

Read below before operation.

Ensure the operator understands the contents of this manual before using the cattle squeeze chute.

1. **DO NOT** wear loose-fitted clothing.
2. Ensure the cattle squeeze chute is on a firm, level, dry surface that is free of rocks and other trip hazards. A level concrete pad flush with the ground and with the chute bolted to the concrete is strongly recommended.
3. **DO NOT** enter the vet cage until the animal is secured in the head gate and the rump bar has been placed so that the cow cannot back up.
4. **DO NOT** stand in front of the head gate while operator is moving the cattle through the squeeze chute.
5. **DO NOT ALLOW CHILDREN UNDER THE AGE OF 18 NEAR AN OPERATING MACHINE.**
6. Follow safe cattle handling procedures in other areas of the yard so that cattle are more docile in the chute.
7. **DO NOT** make any modifications to Arrowquip equipment. Non-factory modifications to the equipment can reduce the safety for the operator & livestock, and void warranty.

RISK ASSESSMENT

Conduct a risk assessment on procedures for which the cattle squeeze chute used and establish a safe work procedure.

8. Ensure all users of the equipment have been inducted and comply with safe working procedure.
9. Please ensure that there are **NO** large or hazardous objects inside the chute that may cause injury to the animal or operator or may cause the equipment to malfunction.
10. Make sure that your chute has been cleared of **ALL** livestock after use.
11. Some chemicals and medicines can damage powder coat. Take all precautions and wash after use.

OPERATING THE ARROWLOCK CATTLE CHUTE



ENSURE ALL CHUTE FUNCTIONS AND ADD-ONS ARE WORKING PROPERLY BEFORE OPERATING.

1. Ensure the head gate and all access points are closed before the animal enters the chute.
2. Open the tail gate for the animal to enter the squeeze chute enclosure.
3. Close tail gate.
4. Open head gate slightly more than the neck size of the animal to tempt the animal to stick its head through. When the neck of the animal is in the correct position, quickly close the head gate securely on the animal's neck.
5. If required, side squeeze animal and engage head restraint to restrain further movement.
6. If the animal applies excessive pulling pressure on the head gate, it is recommended to use the anti-backing bar behind cattle rump

3E ARROWLOCK HEAD GATE ASSEMBLY



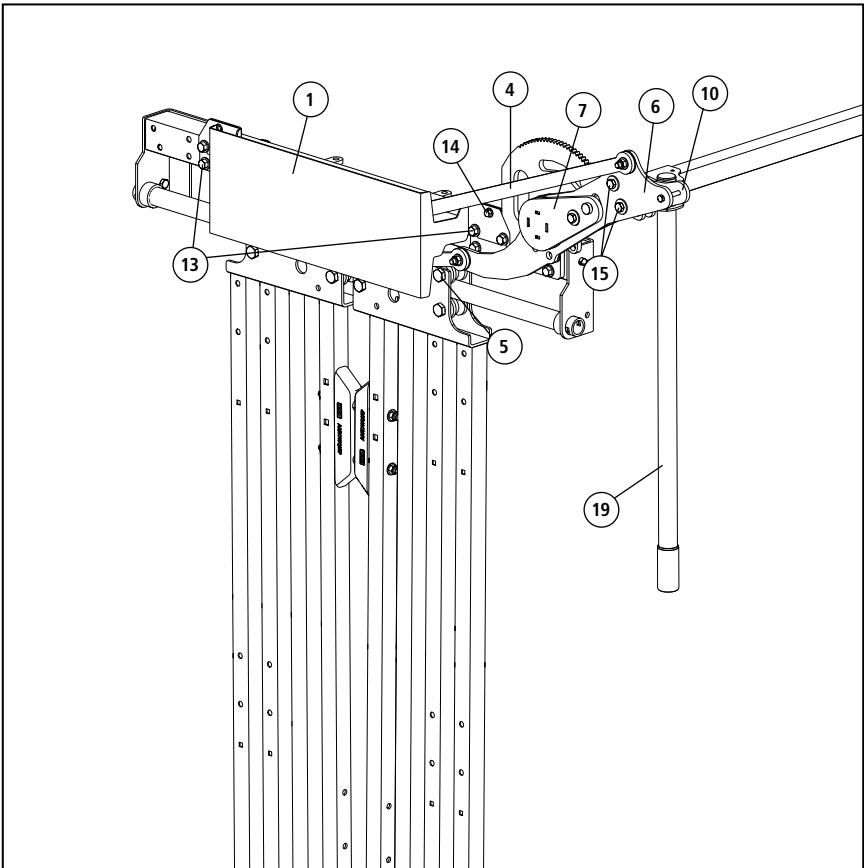
ENSURE THE LOCK AND LINKAGE POINTS ARE THOROUGHLY LUBRICATED WITH LIGHT OIL OR WD-40.

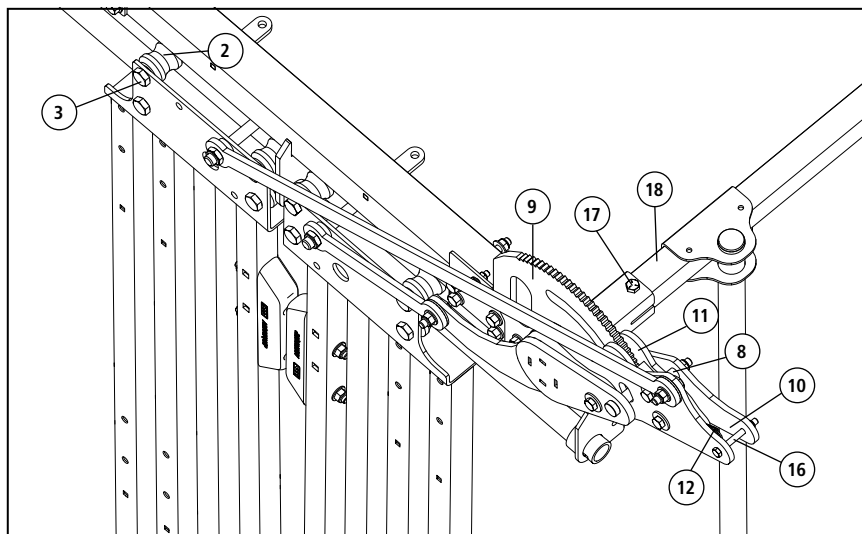
Your chute will come with the head gate fully assembled and ready for use. However, if you need to disassemble your head gate for any reason, the following guide will help you properly reassemble your chute.

ASSEMBLING THE ARROWLOCK HEAD GATE

Fit the mechanism parts as shown in the diagram below.

ARROWLOCK 55 & 75 MODELS

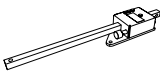




1	55/75 HEAD GATE SHIELD
2	Q-CATCH ROLLER
3	HEAD GATE ROLLER BOLT AND NUT
4	55/75 HEAD GATE TOP-LINK
5	55/75 HEAD GATE BOTTOM-LINK
6	RATCHET HAMMER FLF
7	RATCHET DRIVE/PAWL
8	55/75 RATCHET SPACER
9	55/75 RATCHET PLATE
10	55/75 RATCHET HAMMER TOP FLF
11	SPRING & PAWL
12	3" LONG EXTENSION SPRING
13	1/2 X 4-1/2 FLANGE BOLTS AND LOCKING NUTS
14	3/8 X 1 FLANGE BOLTS AND LOCKING NUTS
15	1/2 X 3-1/2 HEX BOLTS WITH 1/4" WASHERS & LOCKING NUTS
16	3/8X 4-1/4 HEX BOLT WITH LOCKING NUT
17	1/2 X 3-1/4 HEX BOLT WITH LOCKING NUT
18	55/75 CONTROL TUBE
19	HEAD GATE HANDLE

HEAD GATE & SQUEEZE CONVERSION

All Arrowquip products are made with precision parts to require minimal maintenance. However, regular maintenance will

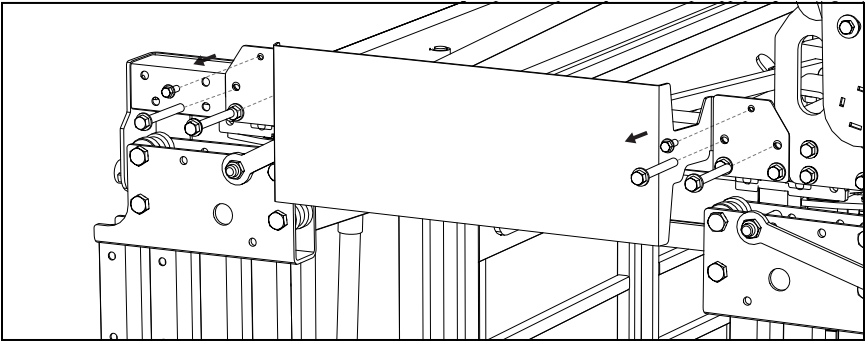
PRODUCT	LEFT-HAND PRODUCT CODE	RIGHT-HAND PRODUCT CODE
SQUEEZE TRIDANGLE 	2025571	2026420
SQUEEZE LOCKBOX 	2025123	2026246
ARROWLOCK DRIVE ASSEMBLY 	2024930	2026335

REQUIREMENTS:

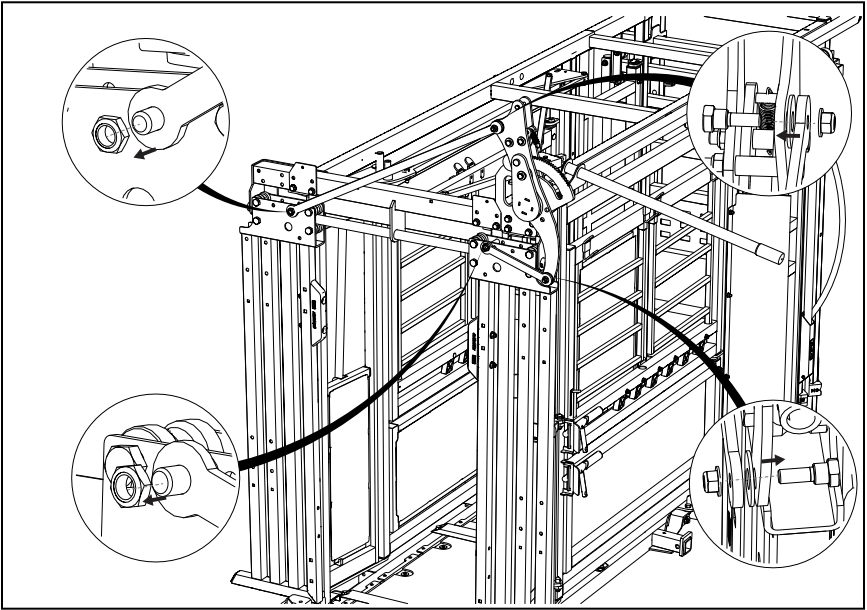
- 2 people
- Pliers
- Ratchet Pawl Assembly
- 2 x 9/16" Wrench
- 13/16" Wrench
- 1-1/16" Wrench
- 2 x 3/4" Wrench

INSTALLATION

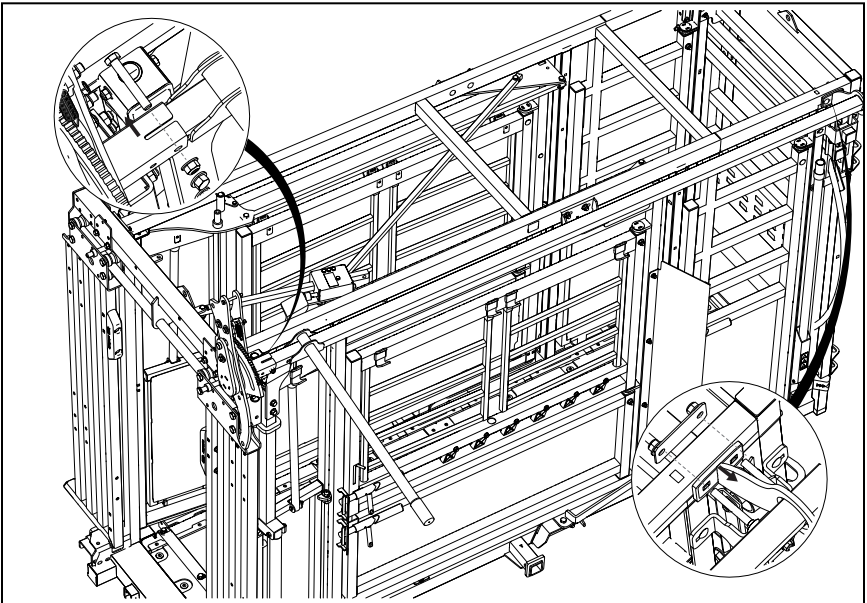
1. Remove shield.



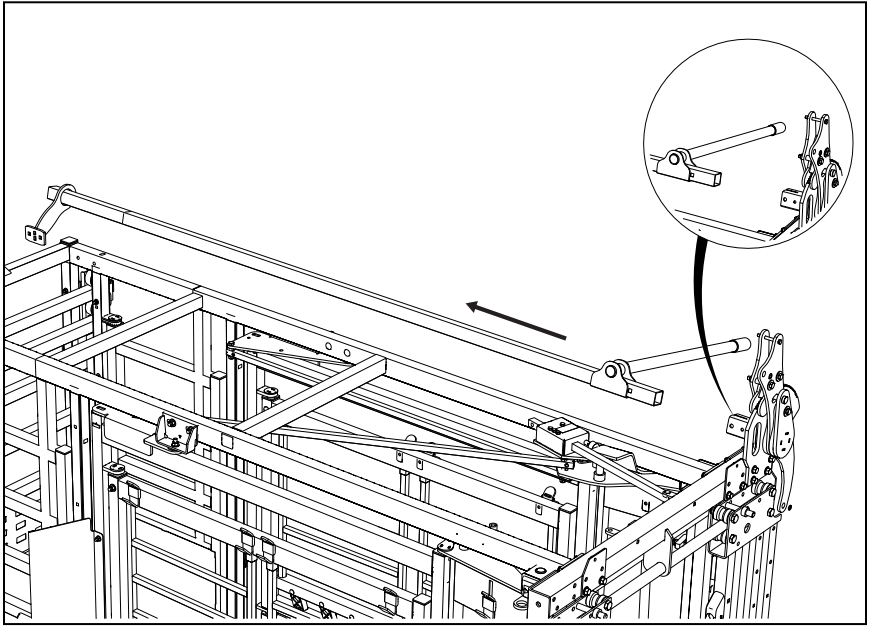
2. Remove linkages.



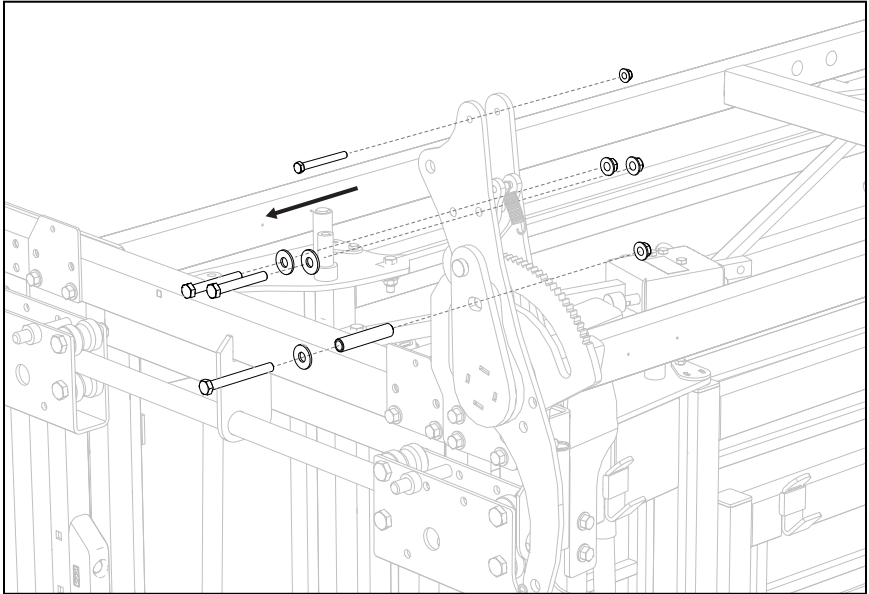
3. Remove locking bolt at the front of control tube and unbolt rear control bracket.



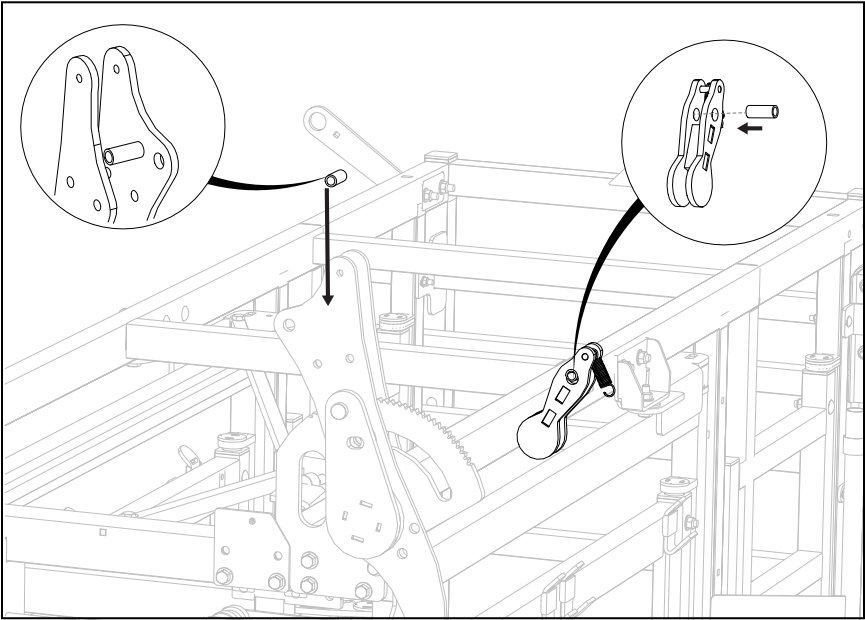
4. Remove control tube assembly and rear bracket.



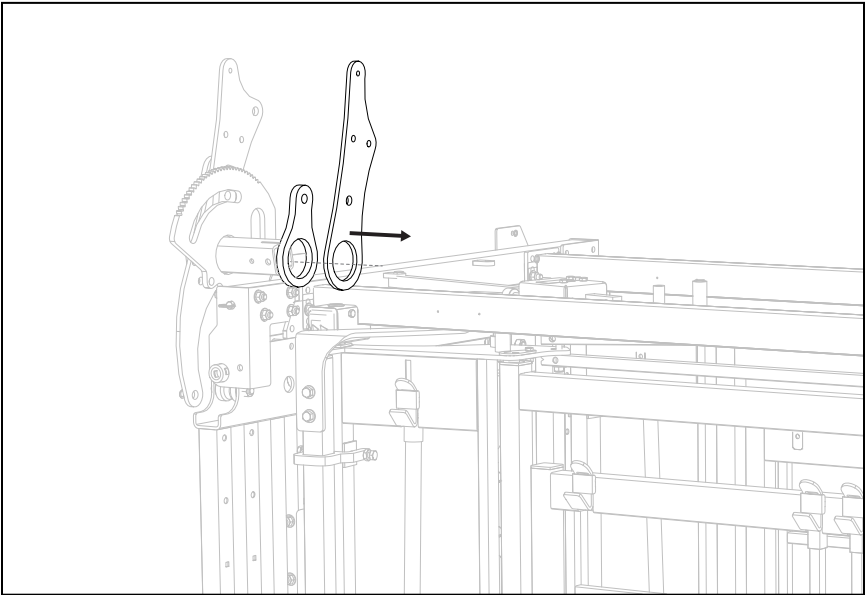
5. Remove bolts from ratchet plate.



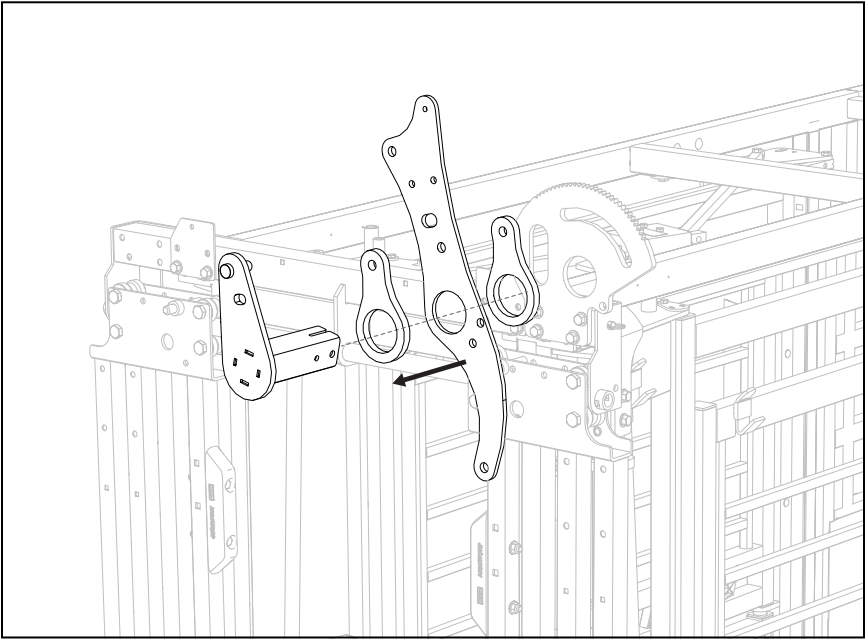
6. Remove pawl and spring.



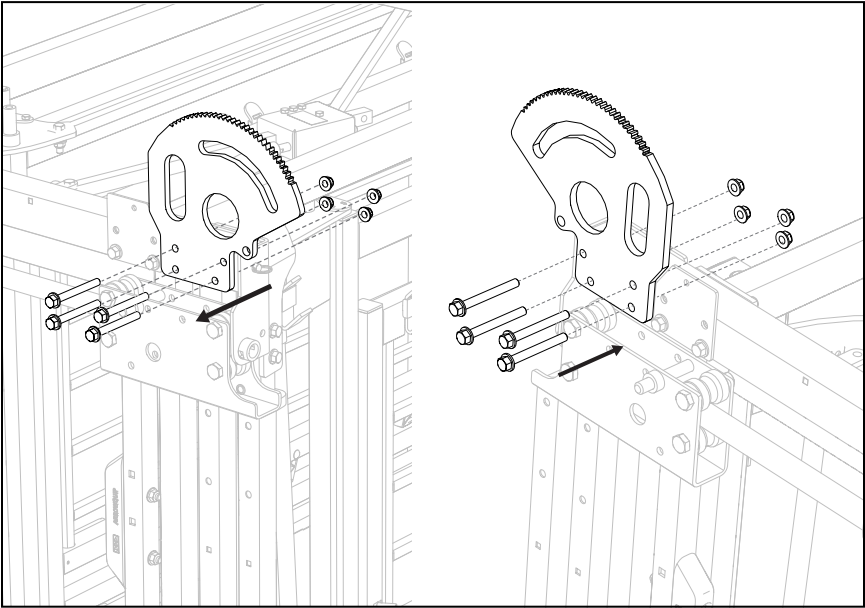
7. Remove lock hammer top (2024756) and spacer from rear side of ratchet plate.



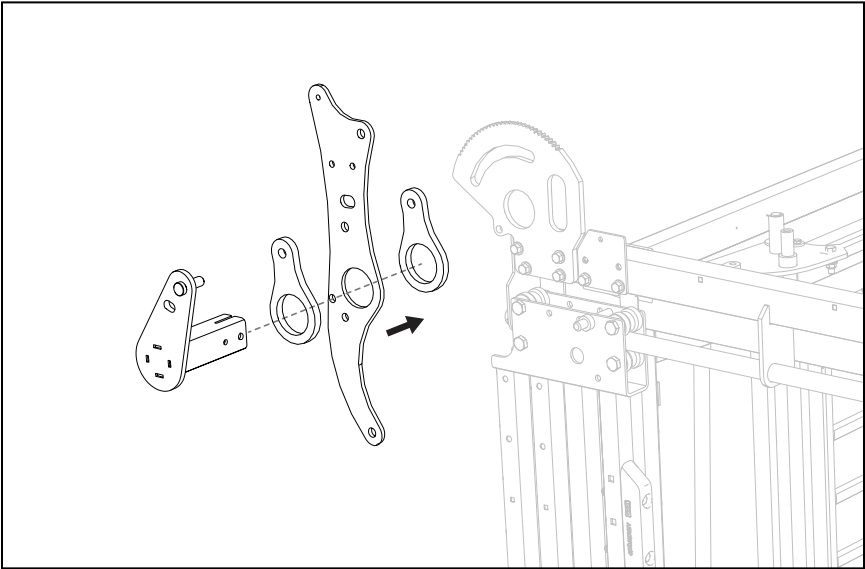
8. Remove ratchet pawl with the plastic spacers and ratchet hammer.



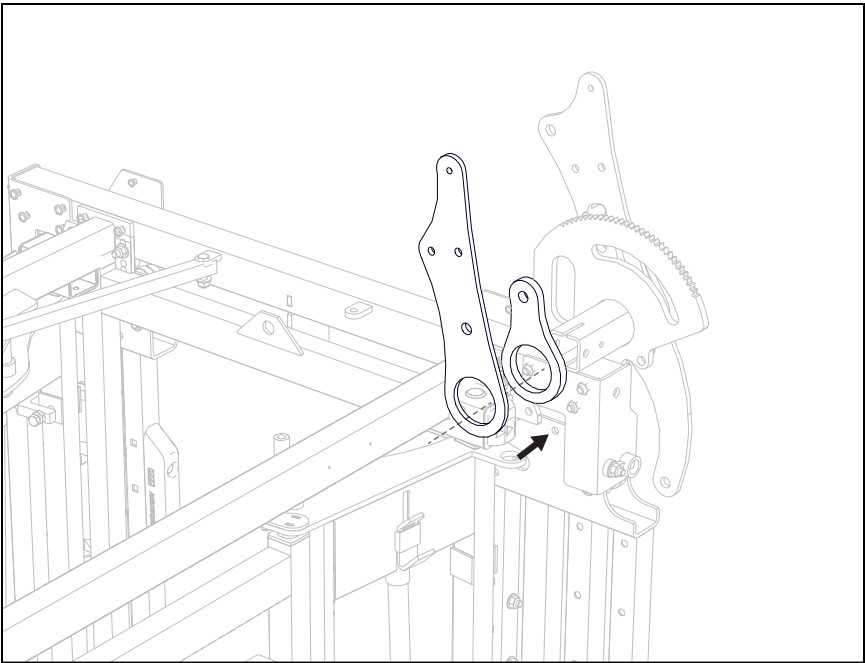
9. Remove ratchet plate and install on opposite side.



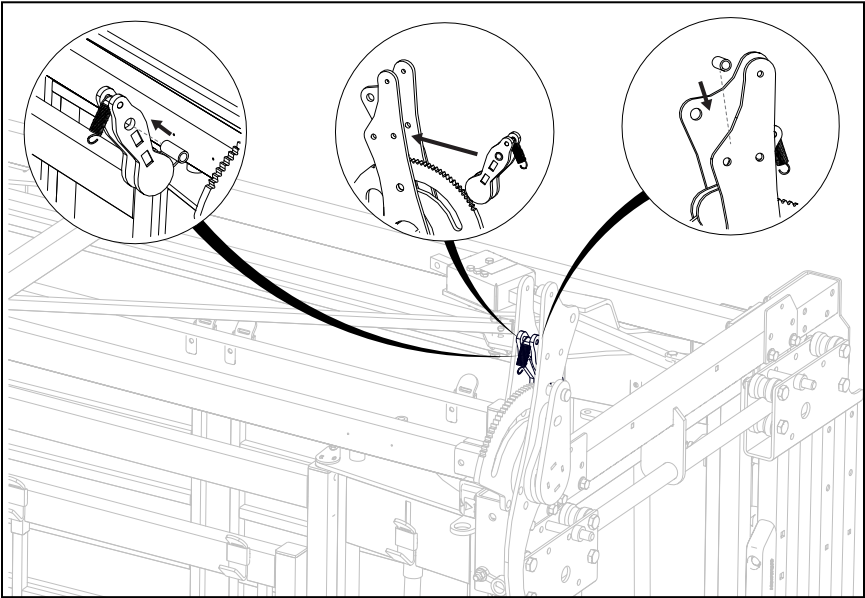
10. Install RH Ratchet Drive/Release WA, spacers and hammer.



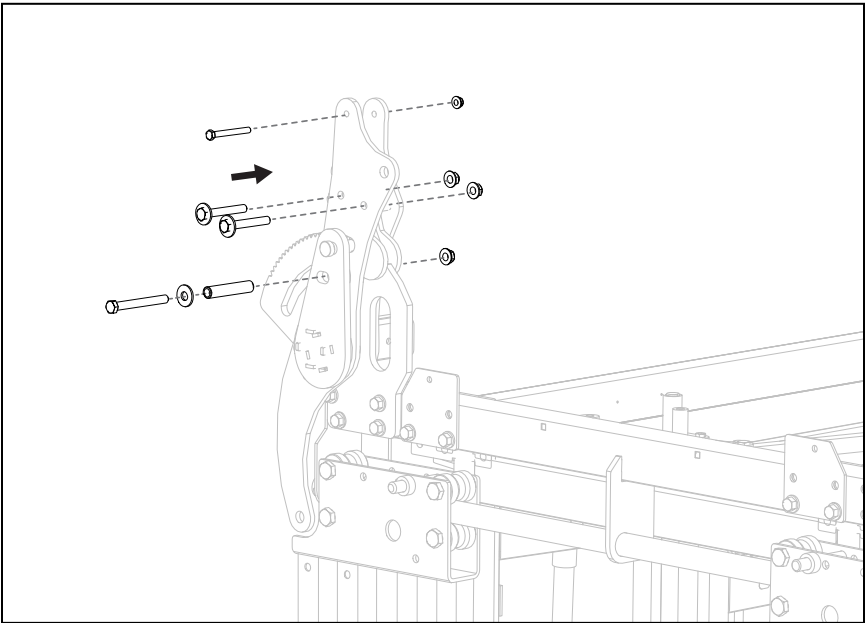
11. Install spacer and lock hammer top (2024756).



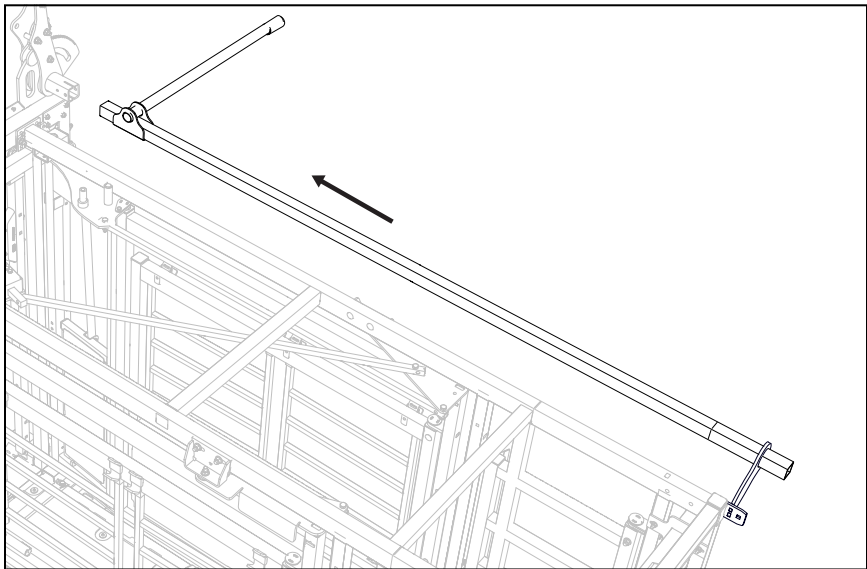
12. Install pawl and spring with 2X bolts.



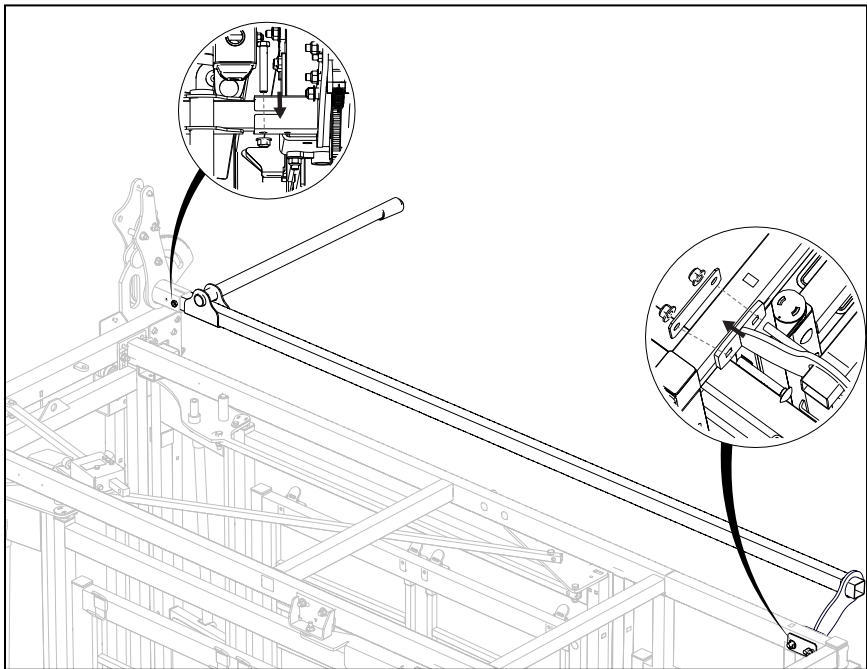
13. Install remaining 2X Arrowlock bolts.



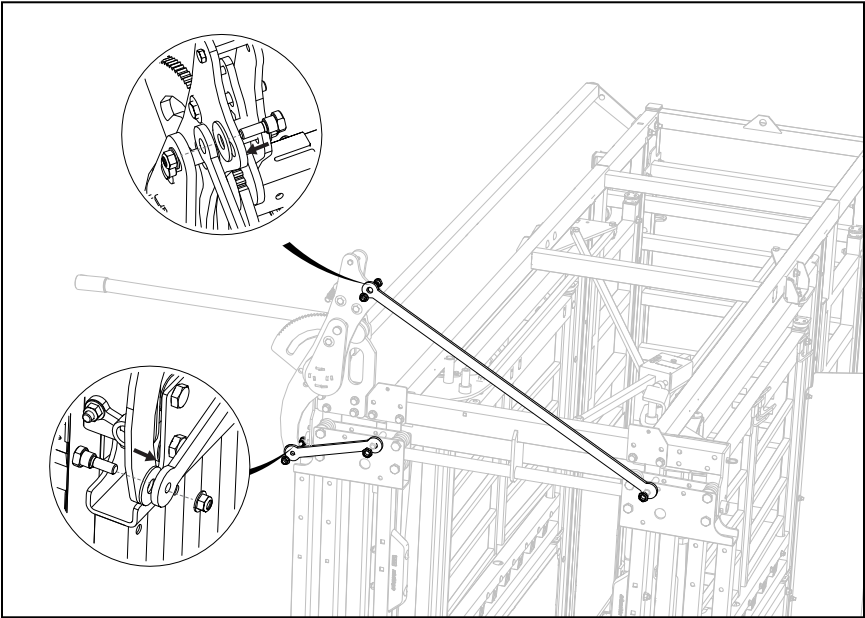
14. Install control tube and handle.



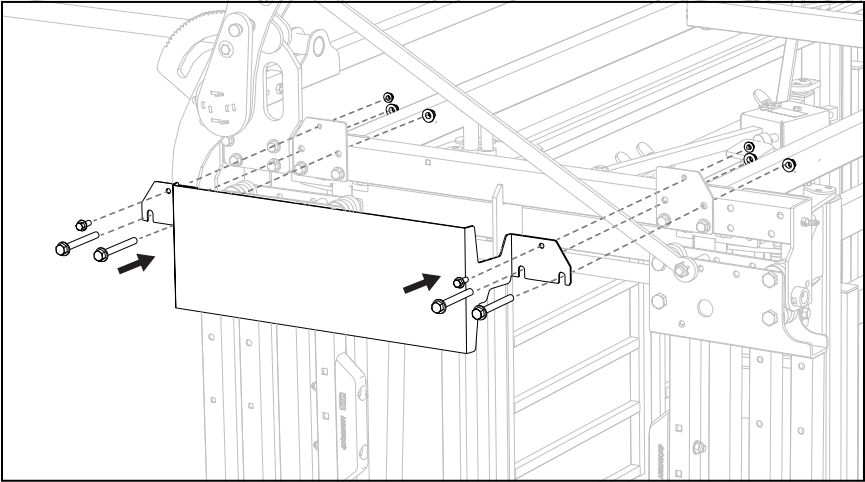
15. Install rear control tube pin and fasten front control tube. Note bolt should crush down sleeve until sleeve clamps control tube top and bottom.



16. Install linkages.

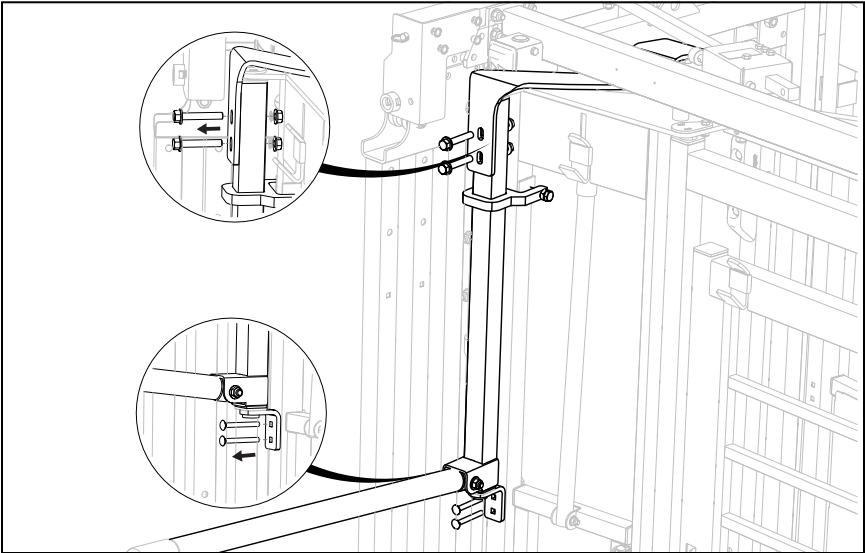


17. Install Name Shield.

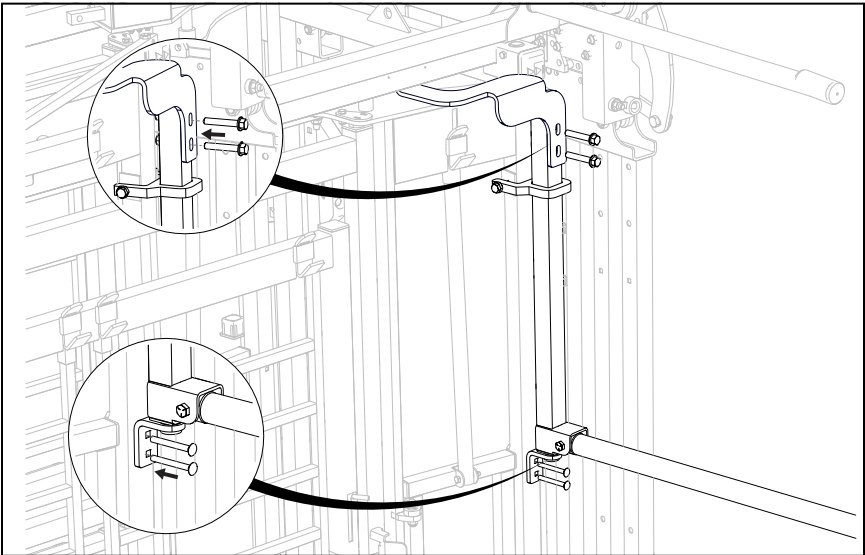


SQUEEZE THE CHUTE TO REMOVE TRIDANGLE.

18. Remove the Left-hand Tridangle and squeeze bracket.

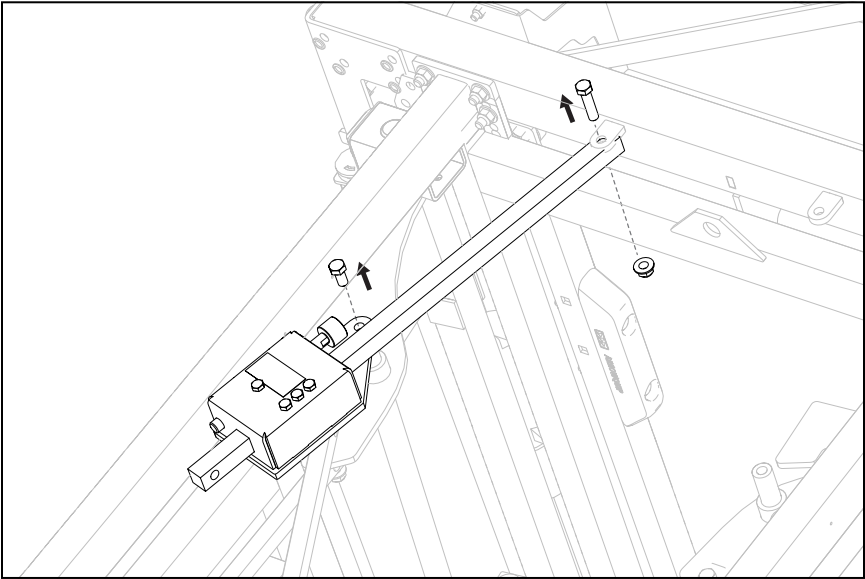


19. Install the squeeze bracket and Right-hand Tridangle on the opposite side.

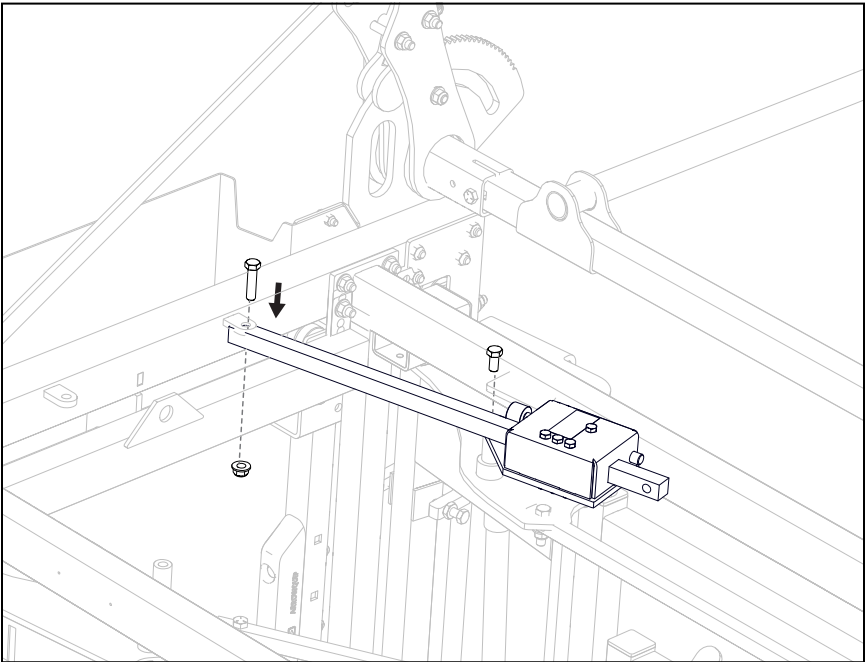


DO NOT TIGHTEN BOLTS UNTIL STEP 25.

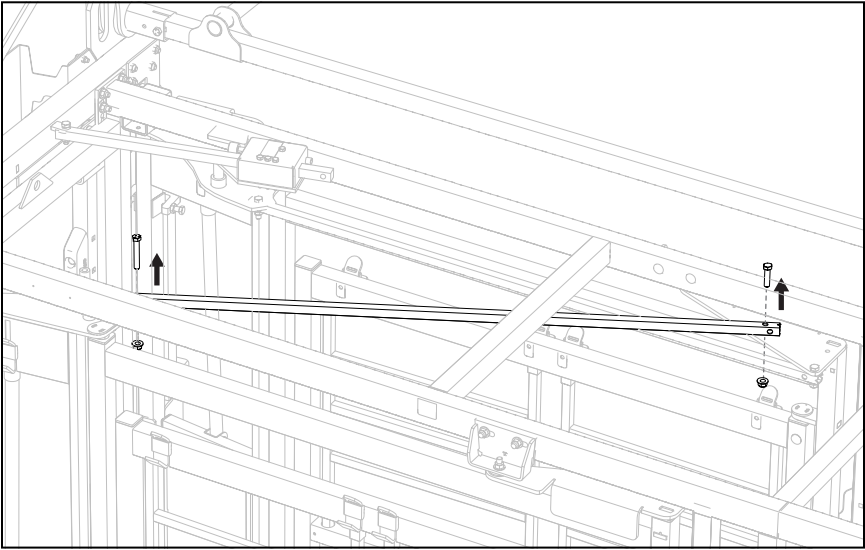
20. Unmount the Left-hand squeeze lockbox. Set aside.



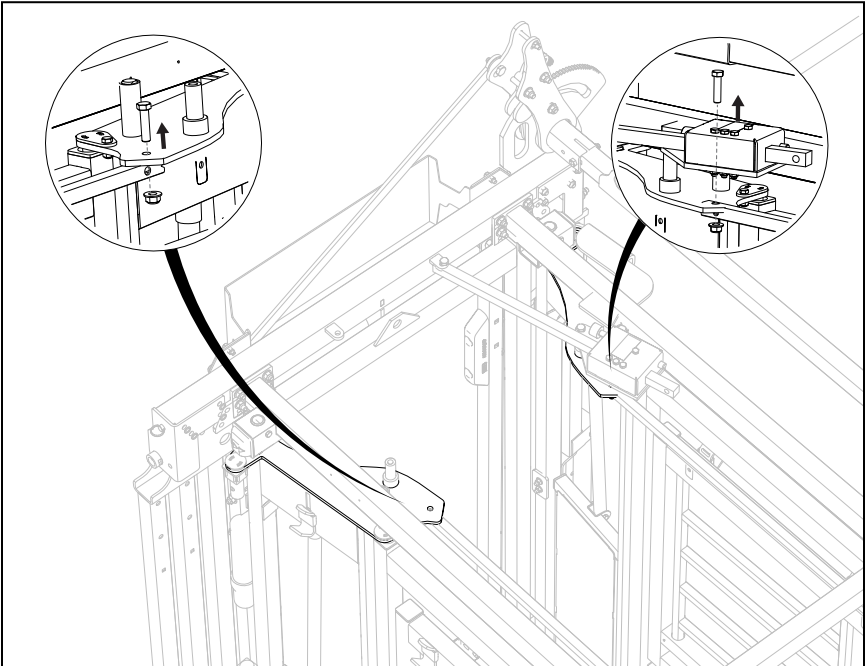
21. Mount the Right-hand squeeze lockbox.



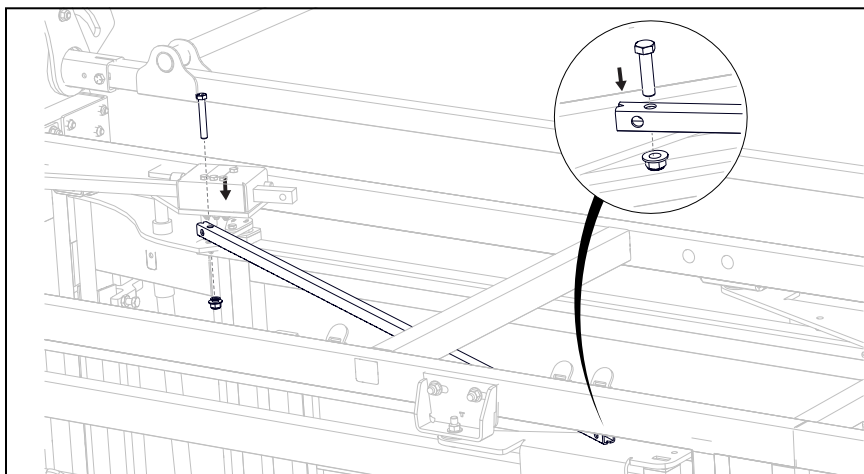
22. Detach the middle tie rod.



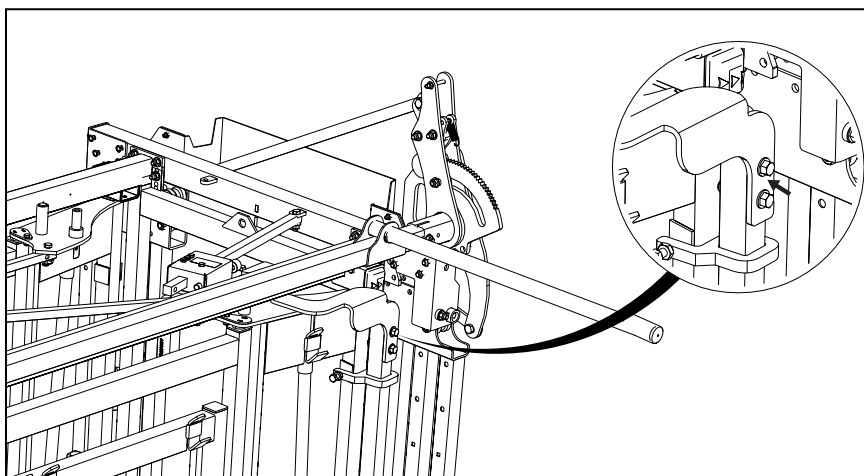
23. Swap the bolts as shown.



24. Attach the middle tie rod as shown.



25. Secure bolts on the squeeze bracket and Tridangle.



BEFORE WORKING WITH ANIMALS, SAFETY CHECK:



- All parts have been reinstalled correctly.
- All chute functions, including the head gate and squeeze mechanisms, are working properly.
- All bolts are tightened correctly.
- Any bolts securing moving parts should be able to rotate freely.

ROLLING DOOR CONVERSION

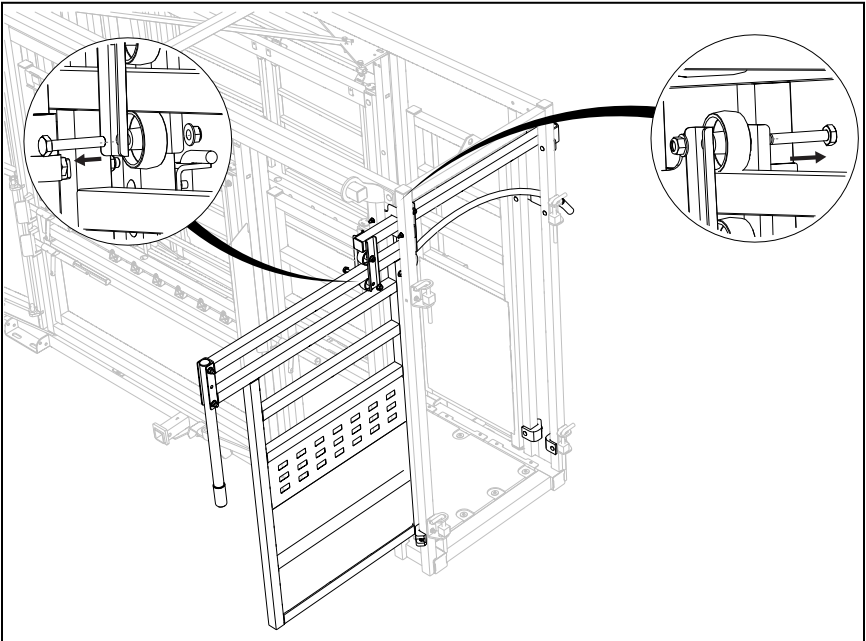
NOTE: To convert the Rolling Door on the 55 Series Model, you must purchase an installation kit.

REQUIREMENTS:

- 2 people
- 2 x 9/16" Wrench
- 2 x 3/4" Wrench

INSTALLATION

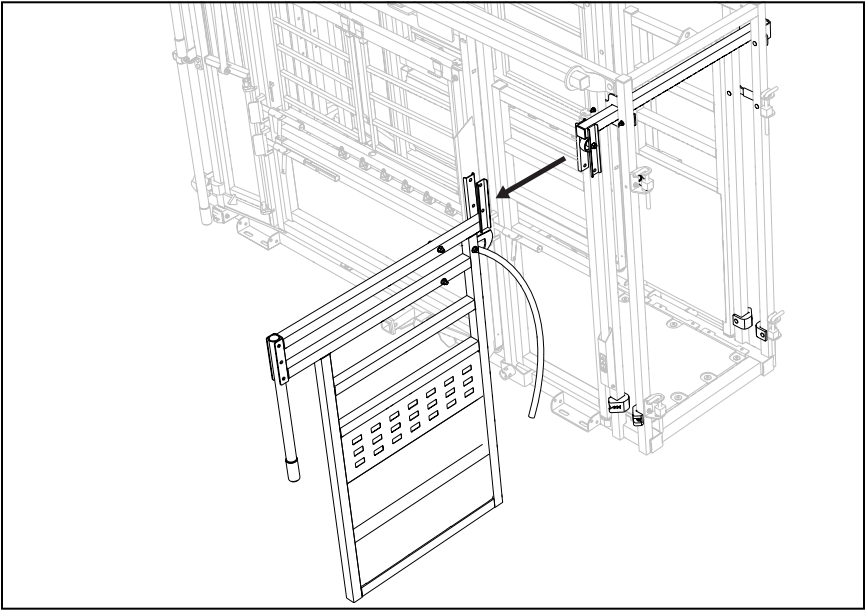
1. Open Rolling Door and remove top and bottom wheel from working side.



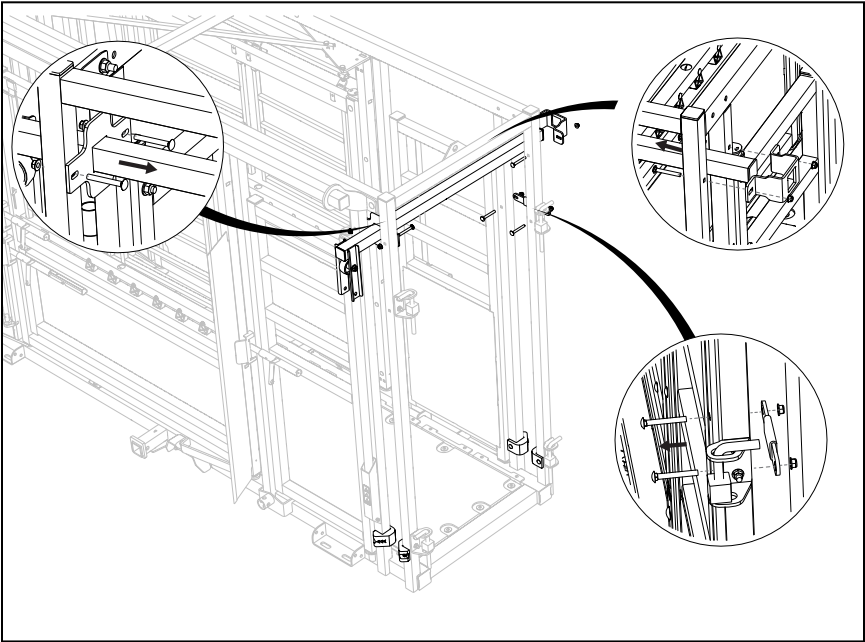
CAUTION:

Door will swing down.

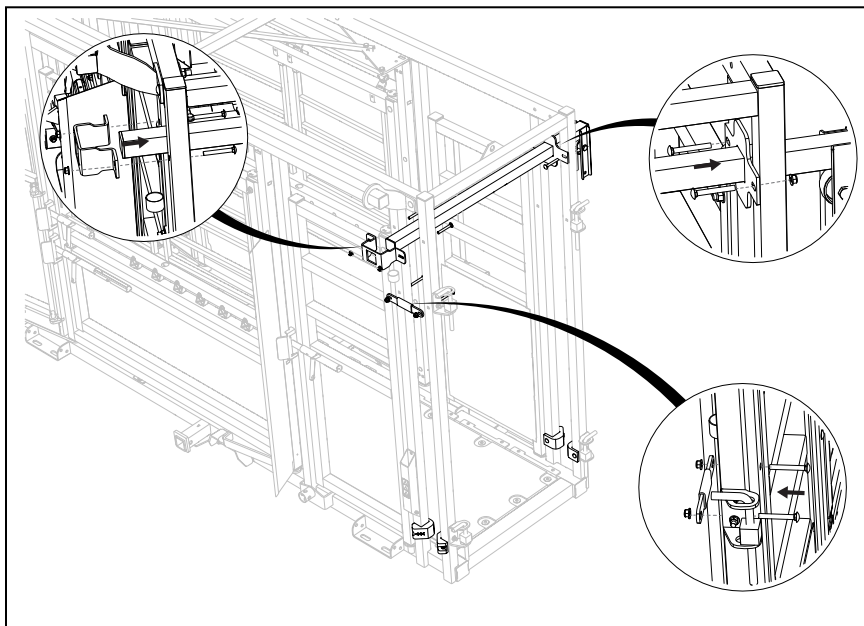
2. Remove the Rolling Door completely.



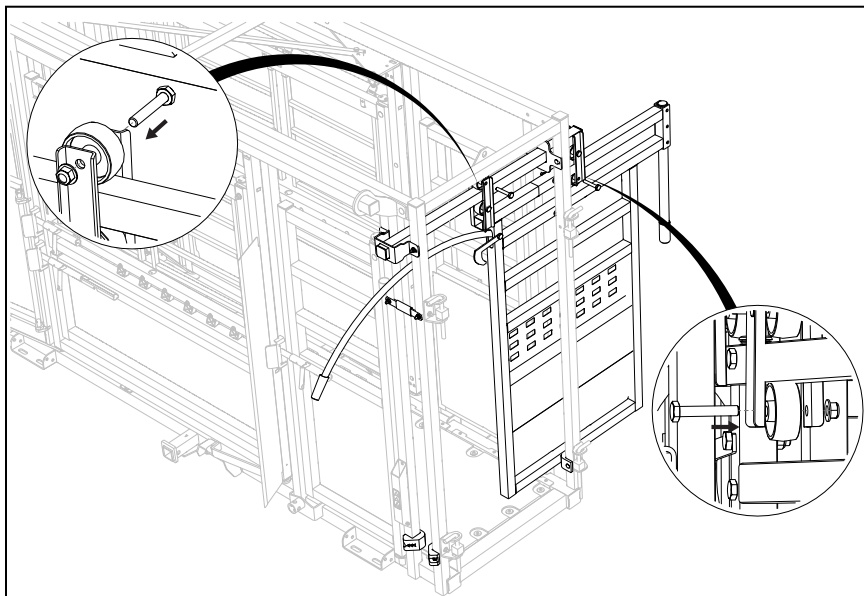
3. Remove the side bracket, track plate, and door handle slider as shown.



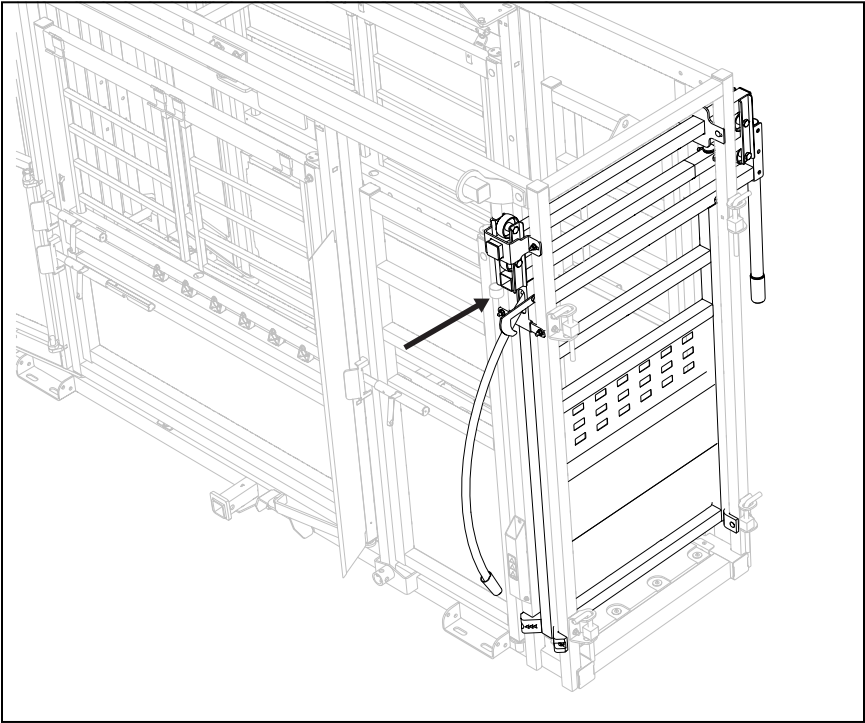
4. Install the side bracket, track plate, and door handle slider on opposite side.



5. Slide the door into the track and install top and bottom wheels.



6. Close door.



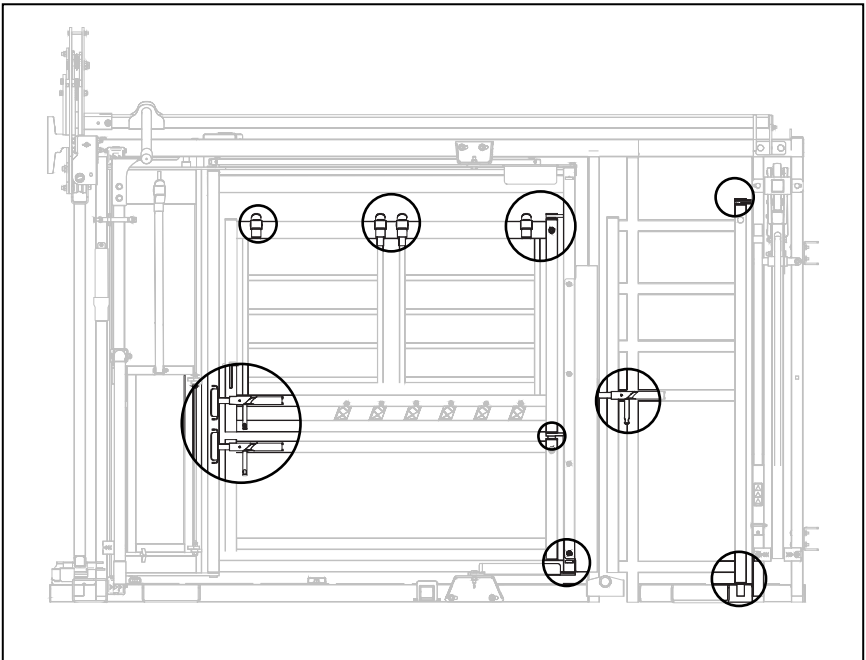
RECOMMENDED MAINTENANCE

All Arrowquip products are made with precision parts to require minimal maintenance. However, regular maintenance will keep your equipment running smoothly and safely.

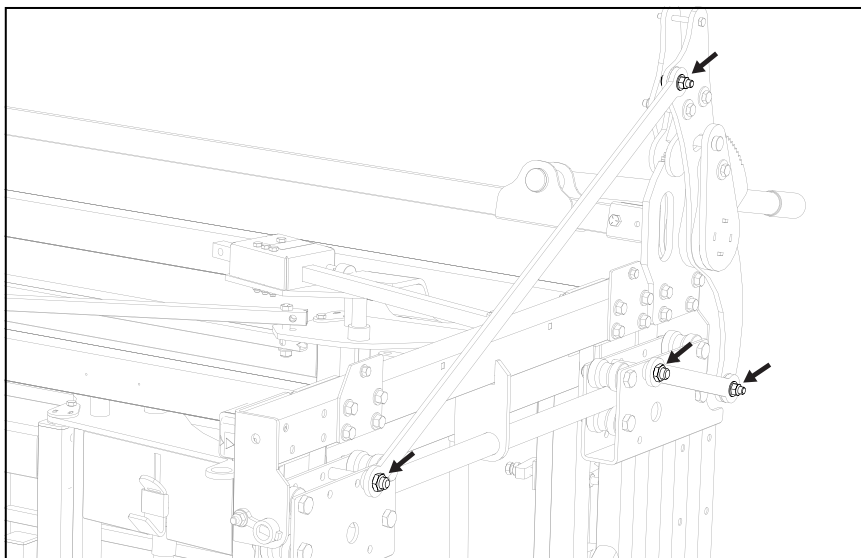
REGULAR MAINTENANCE

EVERY 6 MONTHS:

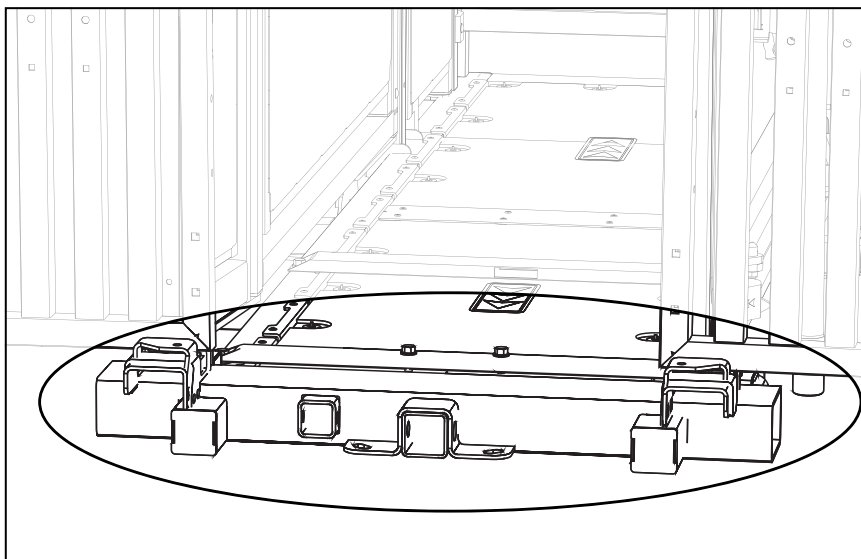
- Inspect the entire unit. Ensure all moving components are free of debris and functioning properly. Use proper cleaning and troubleshooting steps if necessary.
- Lubricate Slam Latches and door hinges with WD-40 Dry Lube.
- Check gate latches and striker plates for wear. Ensure gates are locking securely.



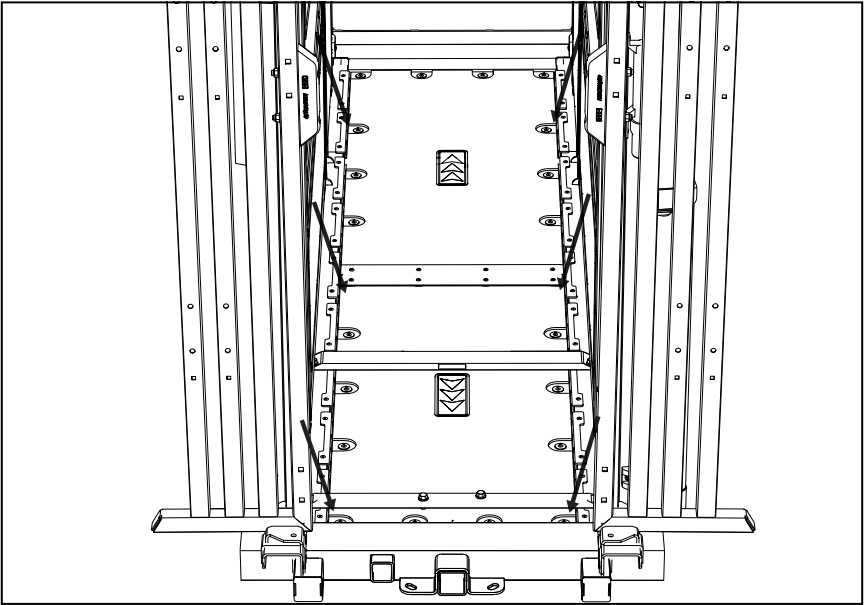
- Inspect the Head Gate.
 - You should feel the head gate rollers moving when you open the head gate. The rollers should be tight enough to be moved by hand, but not over-tight to cause the rollers to bind. If rollers are binding, loosen bolts with 15/16" wrenches



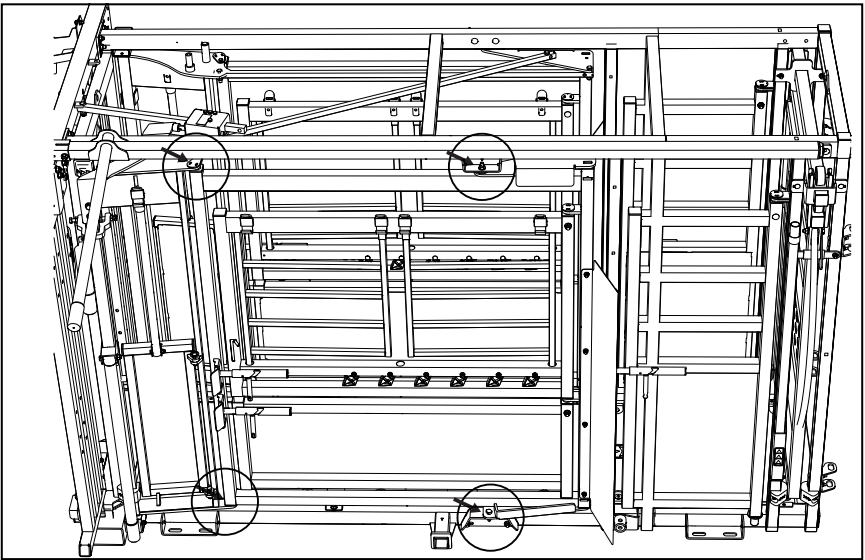
- Clean bottom head gate door track to prevent dirt build-up.



- Clean the chute floor. Excess build-up of manure or dirt inside the chute can cause the squeeze and head gate to malfunction.

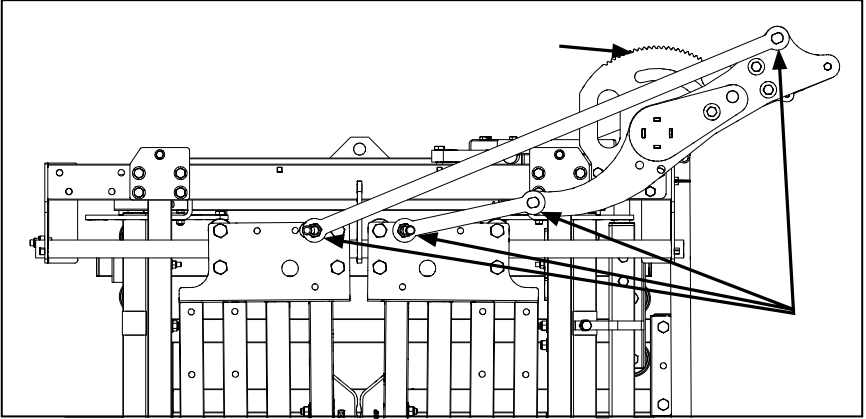


- Check main squeeze and pivot bolt for wear.



WHEN NECESSARY:

- Clean the unit to remove excess build-up or dirt.
- Lubricate the head gate.
 - Use WD-40 on all connection points.



NOTE: Tube spacers are removed with the plastic spacers.

TROUBLESHOOTING GUIDE

If you have a problem with your Arrowlock Cattle Chute, please consider the following tips or call us at 1-877-275-6075.

1. Make sure the unit is situated on level ground or base.
2. Make sure head gate door tracks are clear of debris.
3. Keep floor clean. Excess build-up of manure or dirt inside the chute can cause the squeeze and head gate to malfunction.
4. Ensure bolts on the head gate are tightened correctly.
 - a. Too loose will cause premature wear on head gate parts.
5. Check nuts and bolts on all moving parts to ensure they are tightened correctly and are not binding.
6. All pivot points should be lubricated as needed with WD-40.

RECOMMENDED USE

Arrowlock 55 Series Standard & Deluxe Vet Models | 5 Years or 10,000 Total Head of Cattle

Arrowlock 75 Series Standard & Deluxe Vet Models | 10 Years or 25,000 Total Head of Cattle

WARRANTY

Your product must be registered to claim warranty, and to ensure that Arrowquip has the required information to contact you in the event of a product or part recall. Any owner who fails to register their product warranty with Arrowquip through their Authorized Arrowquip Dealer voluntarily voids their warranty.

Arrowquip will repair or replace products or parts of a product that prove defective due to manufacturer defect during the Warranty Period, at their sole discretion. This excludes defects resulting from normal wear and tear or product misuse.

NOTE: Any modification, in any fashion, to any Arrowquip equipment immediately voids the product warranty. This includes the parts contained therein.

E.g. If a modification is made to the squeeze mechanism in a squeeze chute, and the sternum bar is bent afterwards, warranty for the damaged part, the sternum bar, contained in the modified equipment, the squeeze chute, is void. In addition, any remaining warranty for the squeeze chute and other parts contained therein, including, but not limited to, the head gate, locking system, Q-Catch system, and rollers, is null and void.

REGISTER FOR WARRANTY NOW:

ONLINE: arrowquip.com/product-registration

PHONE: 1-877-275-6075 | **EMAIL:** cs@arrowquip.com

ADD-ONS MAINTENANCE & SAFETY PRECAUTIONS

4TH GENERATION HEAD HOLDER

For complete information, read the 4th Generation Head Holder manual.

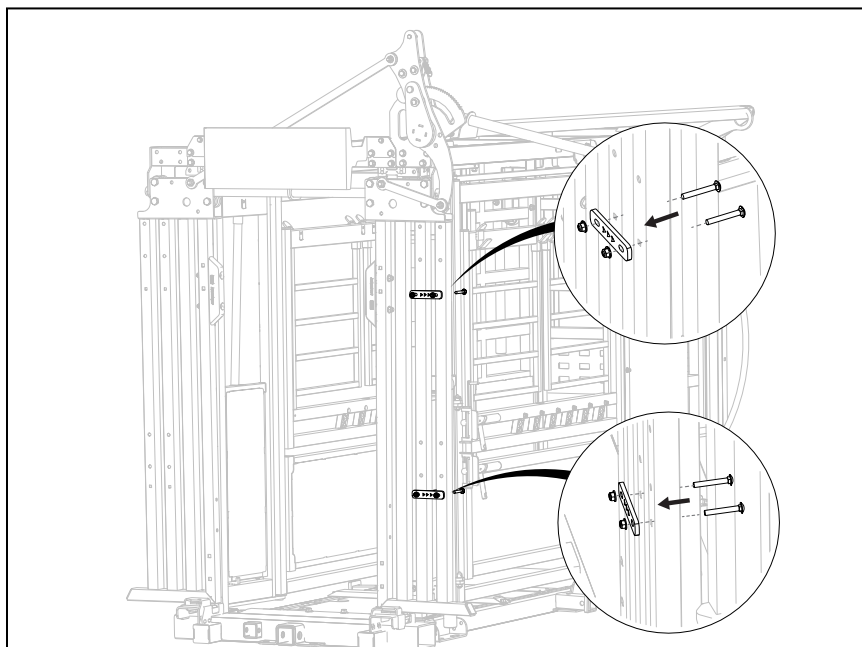
REQUIREMENTS:

- 2 people
- 9/16" Wrench
- 3/4" Wrench

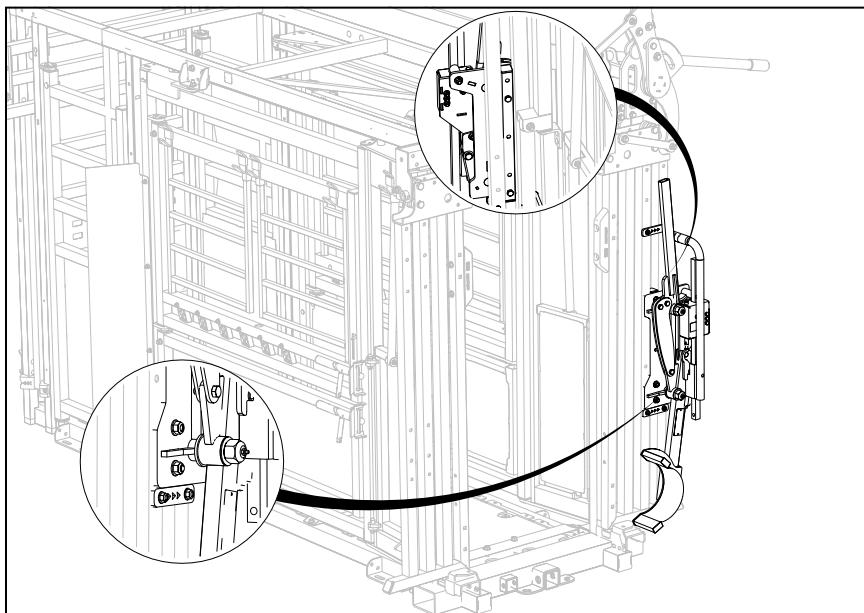
INSTALLATION

1. Install top and bottom stops to the slots in the Head Gate.

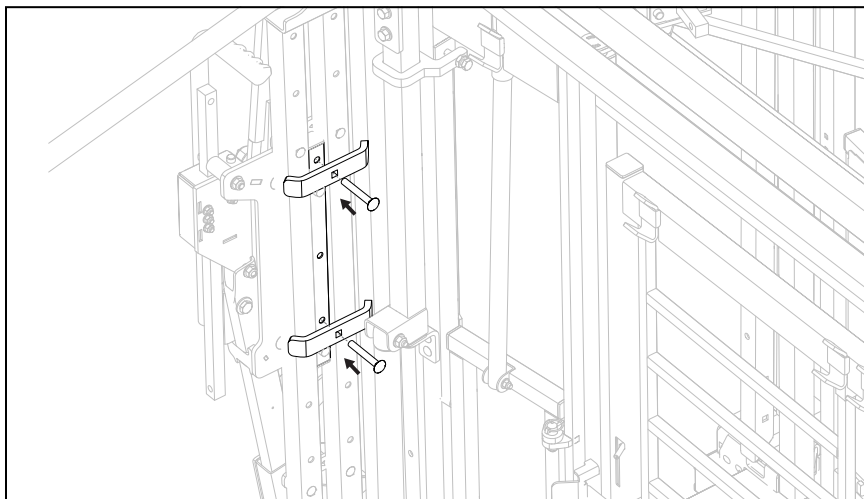
Note: **DO NOT** hold the bottom plate on the Head Holder when adjusting.



2. Align the rear Head Holder tube between the Head Gate rails, resting the Head Holder on the stop.



3. Loosely fasten on rear brackets.



4. Lift the Head Holder to desired position and tighten brackets.

SAFETY PRECAUTIONS:

- Ensure the Head Holder remains open until required to hold the animal's head.

MAINTENANCE:

1. Add grease throughout grease nipples as needed.
2. Every 6 months:
 - a. Check bolts to ensure they are tightened properly.
 - c. Spray brake cleaner on a rag and wipe the lock box shaft while opening and closing the Head Holder.

LUG POST

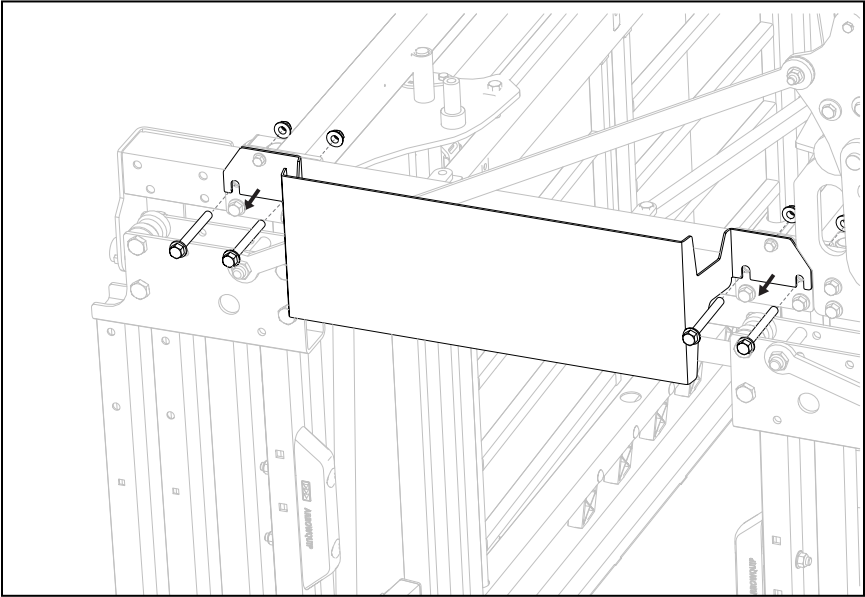
REQUIREMENTS:

- 2 people
- 9/16" Wrench
- 3/4" Wrench

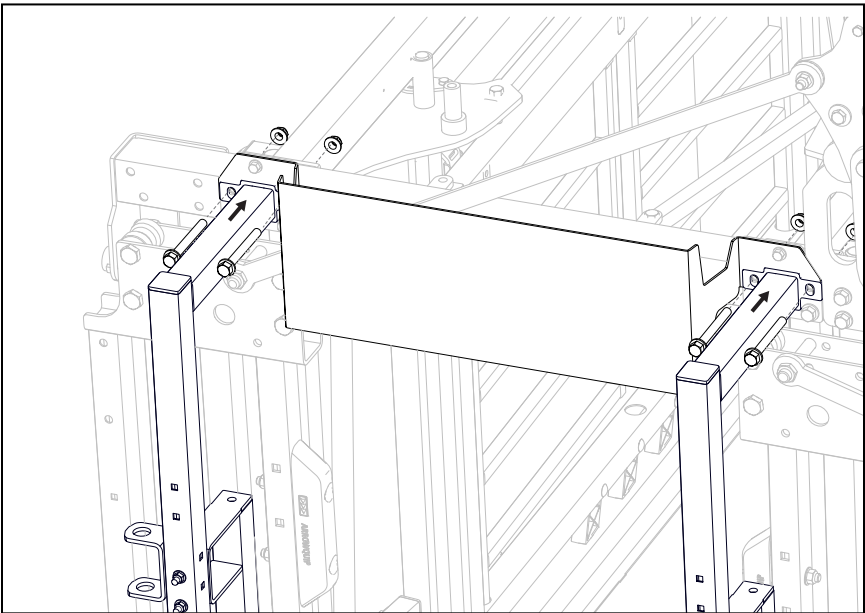
INSTALLATION:

NOTE: Only install one side at a time so name shield stays on the chute.

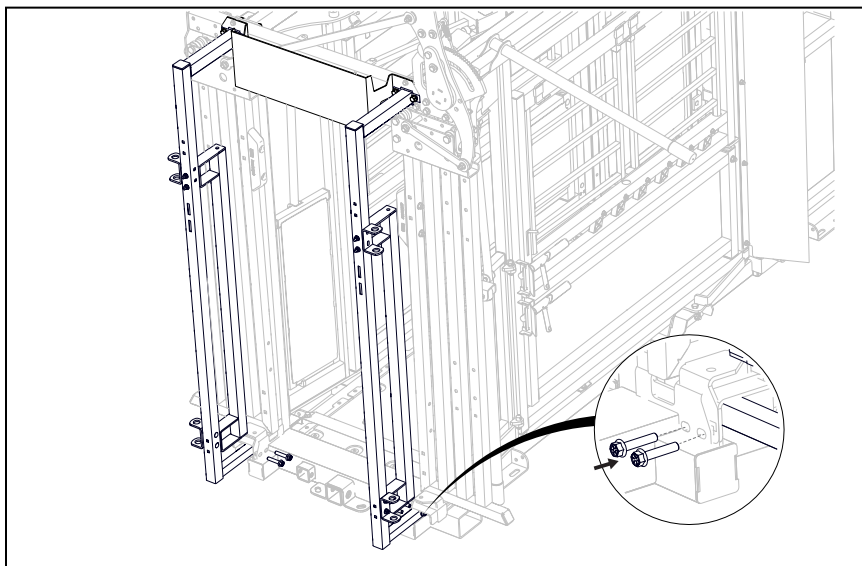
1. Remove bolts holding decal name shield.



2. Install lug post and top two bolts, do not tighten all the way.

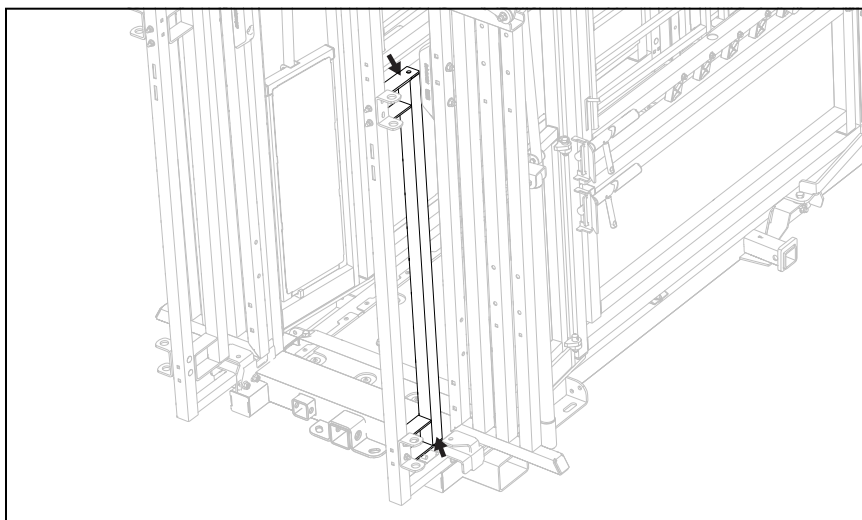


3. Align bottom of lug post and carriage head bolts with the head towards the inside of the chute.



4. Tighten down all 4 bolts.
5. Repeat steps to install the post on the opposite side.

NOTE: Remove filler post before installing head holder.



BALK GATE

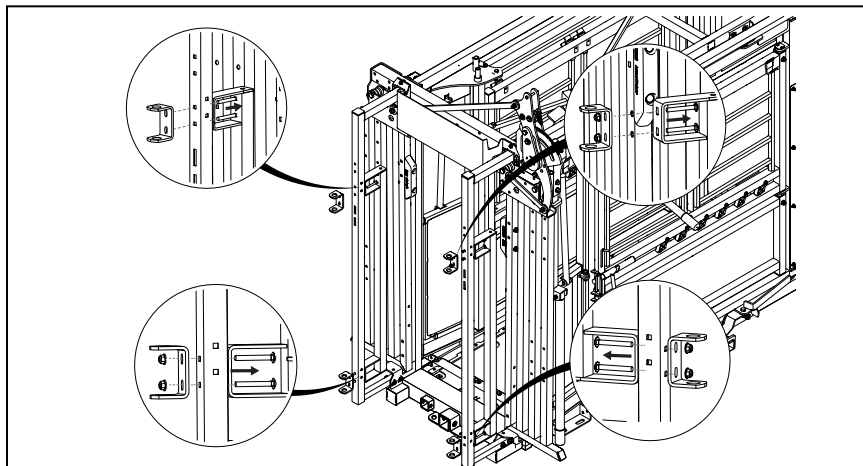
REQUIREMENTS:

- 2 people
- 1 1/8" Wrench
- 3/4" Wrench

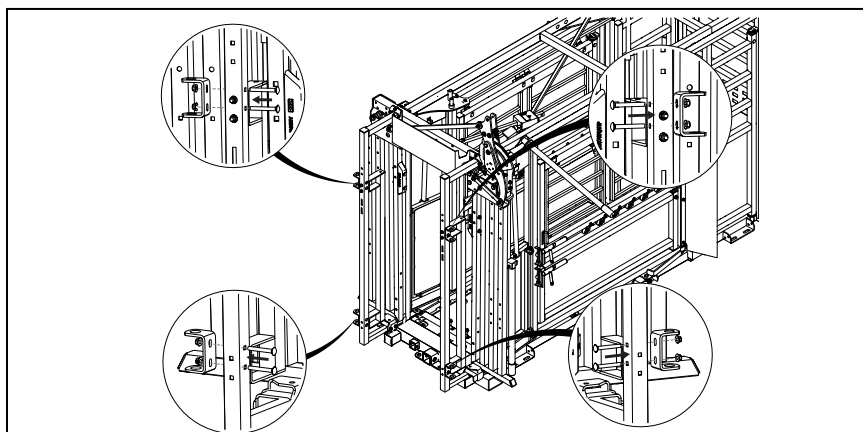
INSTALLATION:

NOTE: The balk gate cannot be installed without lug posts. For installation, refer to lug post installation.

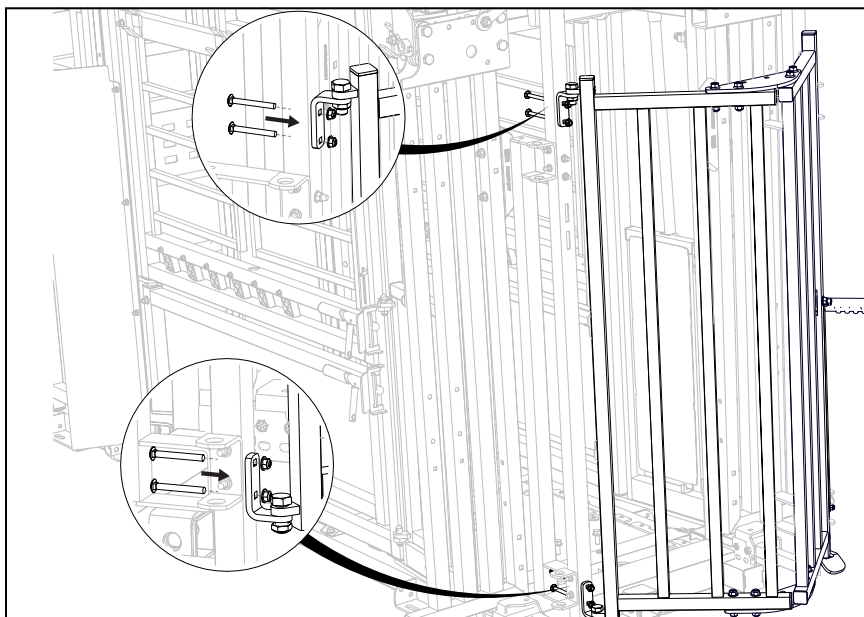
1. Remove front panel clips from front of Lug Posts.



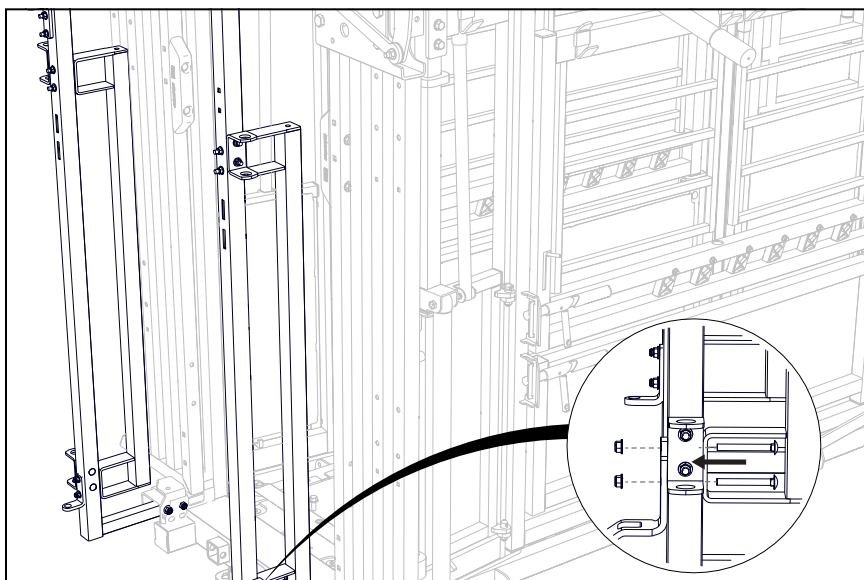
2. Attach panel clips to the side of Lug Posts.



3. Bolt on striker plate to the bottom of Lug Posts on opposite side.



4. Mount Balk gate and hinges to the front of offside Lug Post.



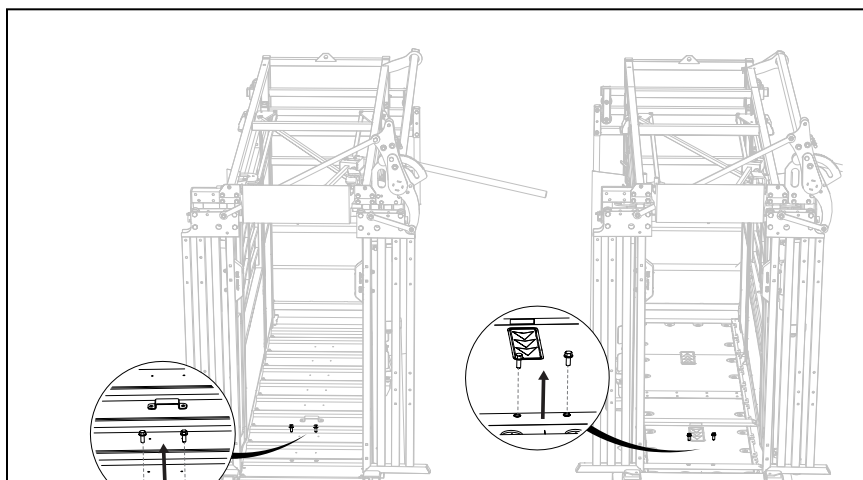
SHEETED STERNUM BAR

REQUIREMENTS:

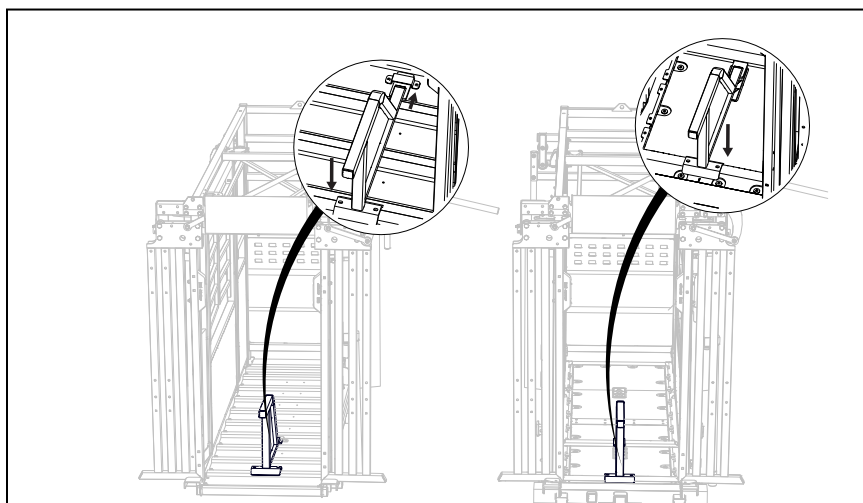
- 2 people
- 1 1/8" Wrench
- 3/4" Wrench

INSTALLATION:

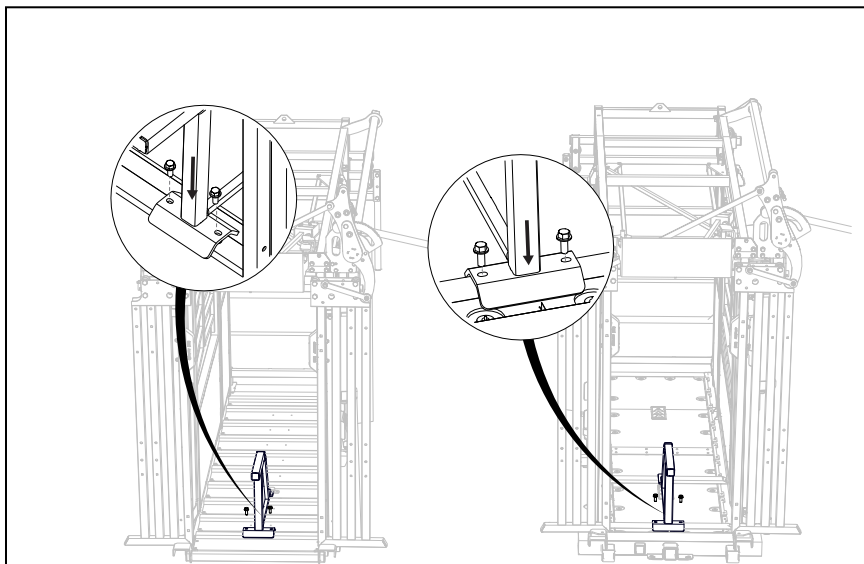
1. Remove stock bolts from hold down



2. Insert back-end of Sternum Bar into hold down.



3. Bolt down the front of the Sternum Bar.



SAFETY CHECK:

- Ensure the Sternum Bar is installed correctly before running cattle through the chute.

SAFETY PRECAUTIONS:

- It is recommended you remove the sternum bar when working calves.

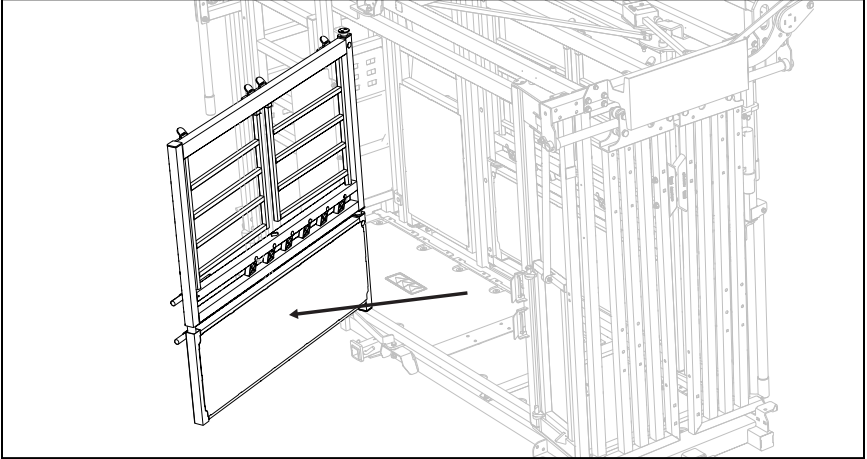
CALF RESTRAINER BAR

REQUIREMENTS:

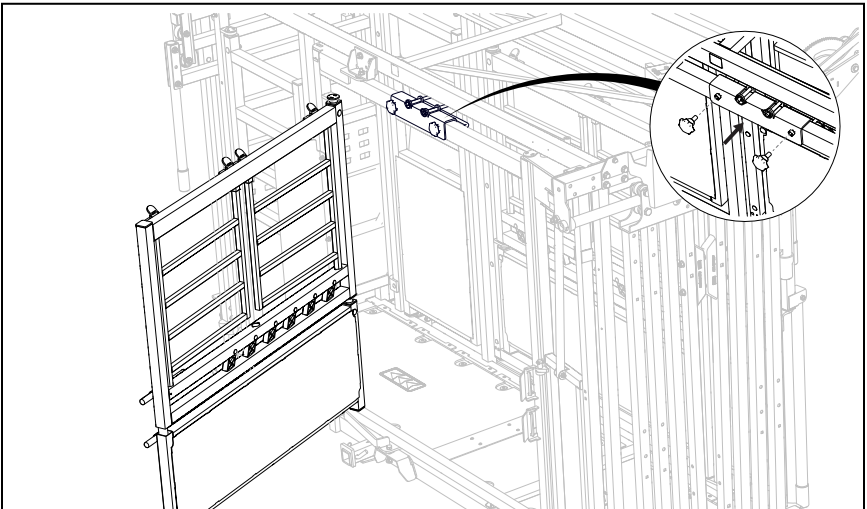
- 2 people
- 1 1/8" Wrench
- 3/4" Wrench

INSTALLATION:

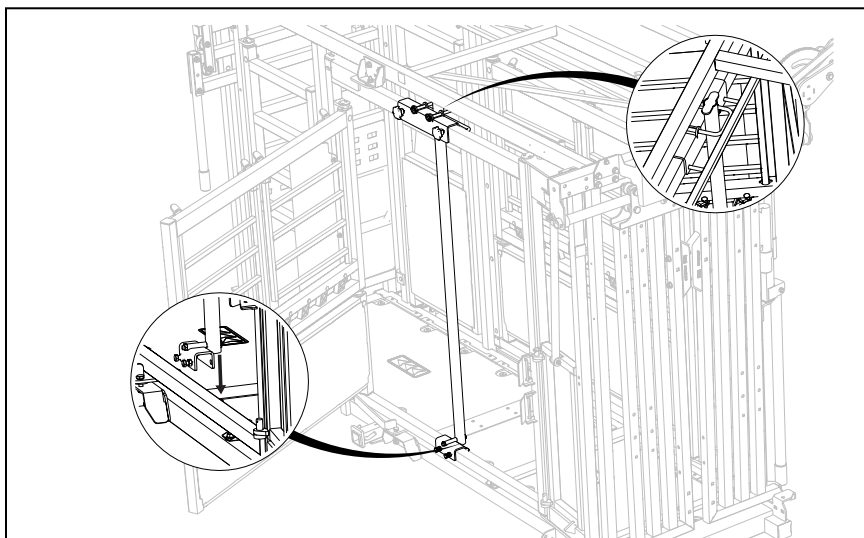
1. Open emergency doors.



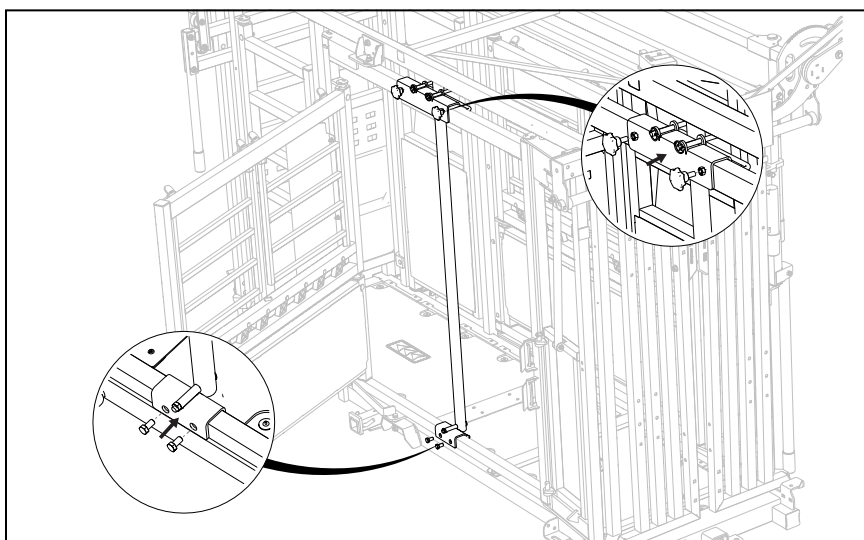
2. Mount on top bracket.



3. Insert Restrainer Bar into top bracket.



4. Set bottom bracket onto the squeeze frame.



WHEEL KIT

REQUIREMENTS:

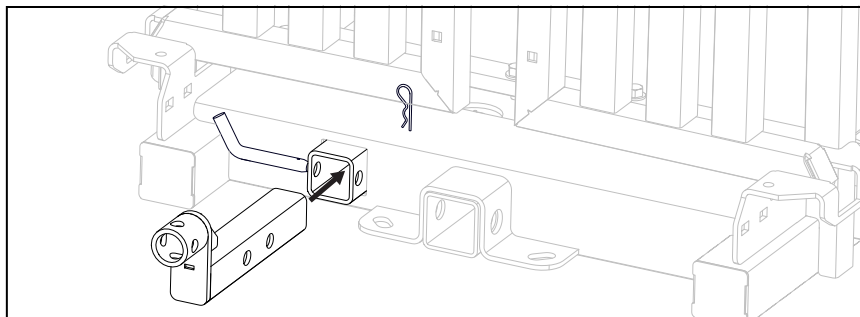
- 2 people
- Portable Wheel Kit

INSTALLATION:



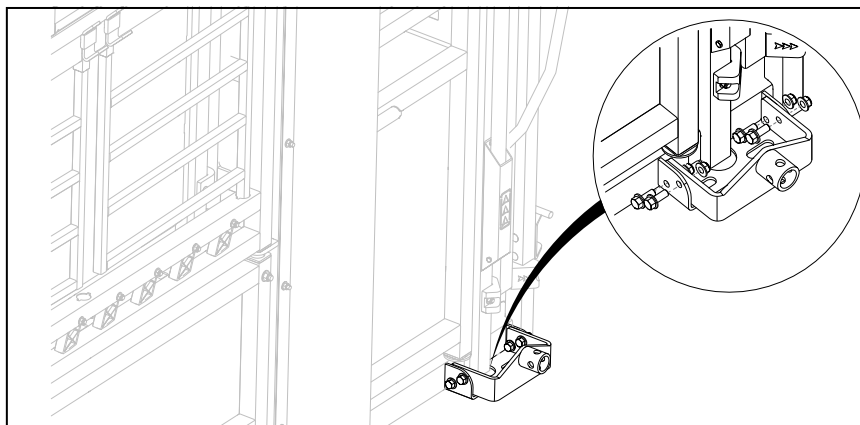
THE CHUTE MUST BE FLAT ON THE GROUND BEFORE PROCEEDING.

1. Mount the jack adaptor to the front of the chute.

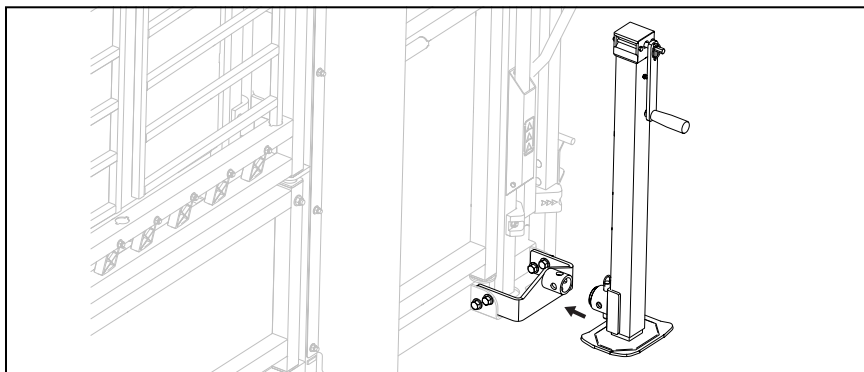


2. Bolt on mount brackets to the side of the chute..

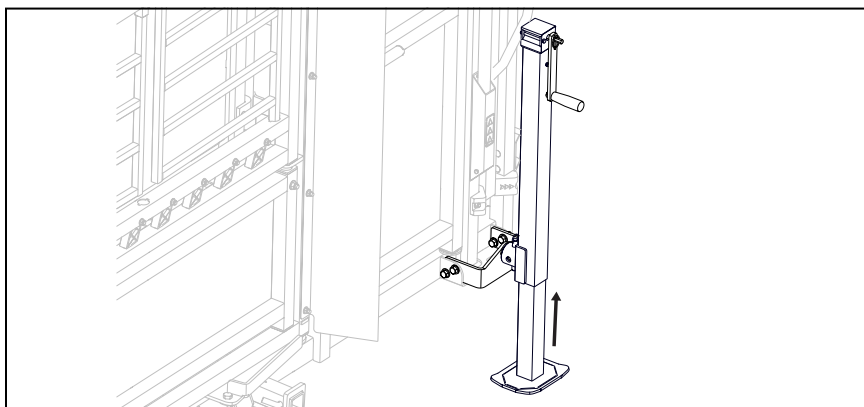
NOTE: If your chute was built after October 2025, the jack mounts have been integrated into the frame.



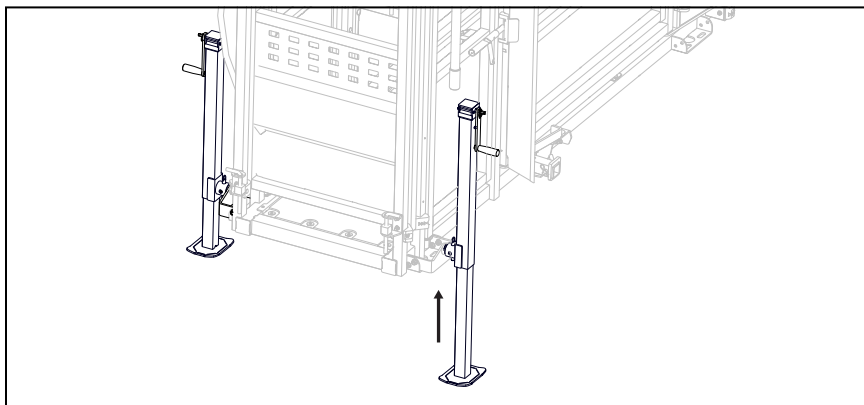
3. Install both jacks on the mounts located near the vet cage.



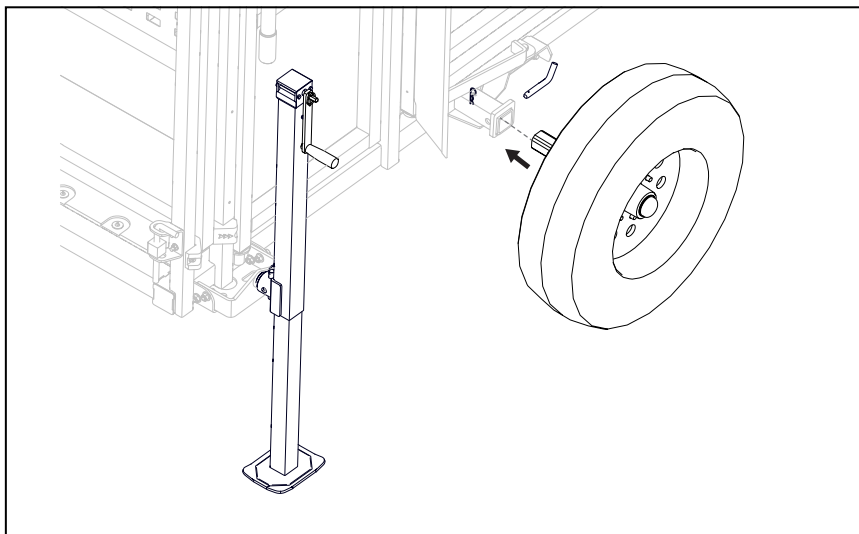
4. Using the jack, raise one side of the unit approx. 6" off the ground.



5. Raise the opposite side of the unit enough to install the wheel.

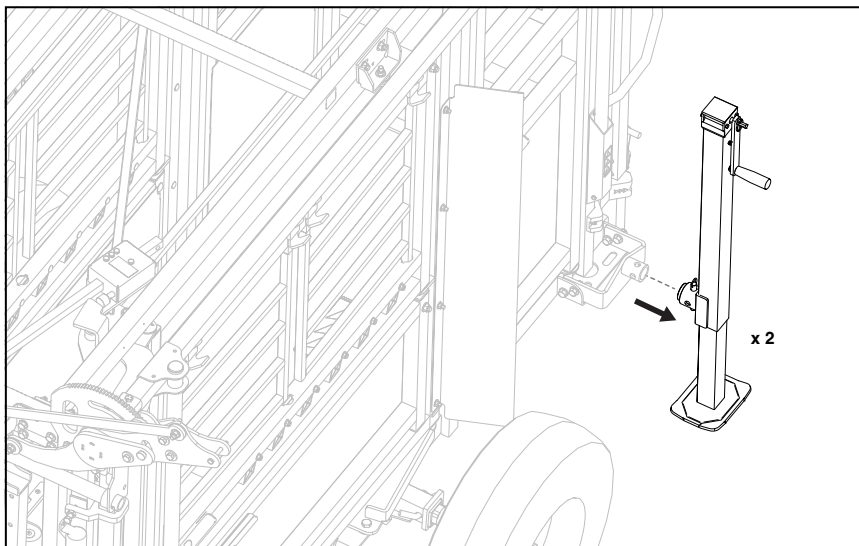


6. Install the wheel and secure with transport pins.

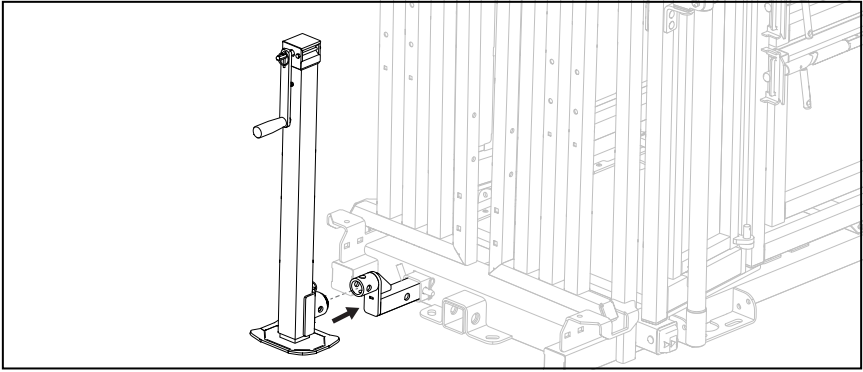


7. Repeat **STEPS 5 & 6** on other side.

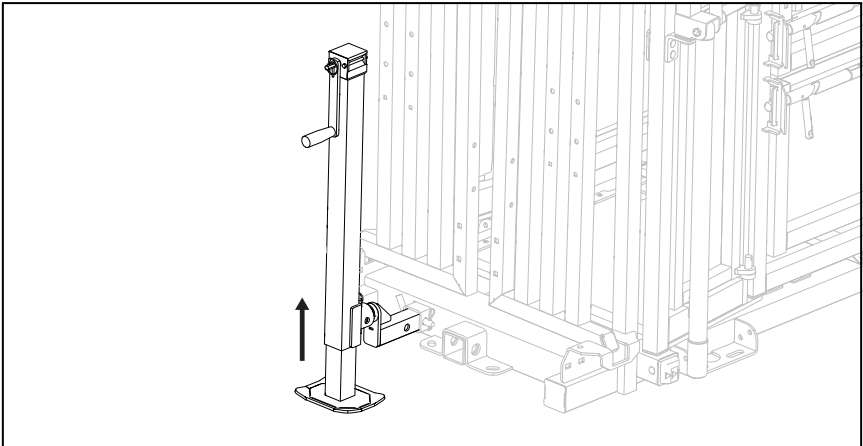
8. Remove both jacks.



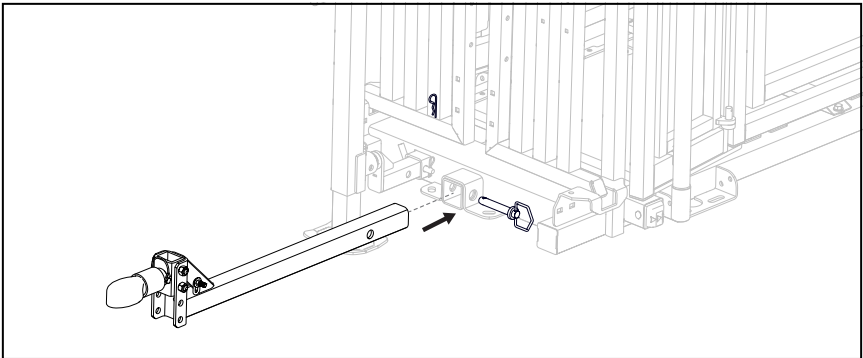
9. Attach the removable jack mount to the front of the chute and secure with the pin.



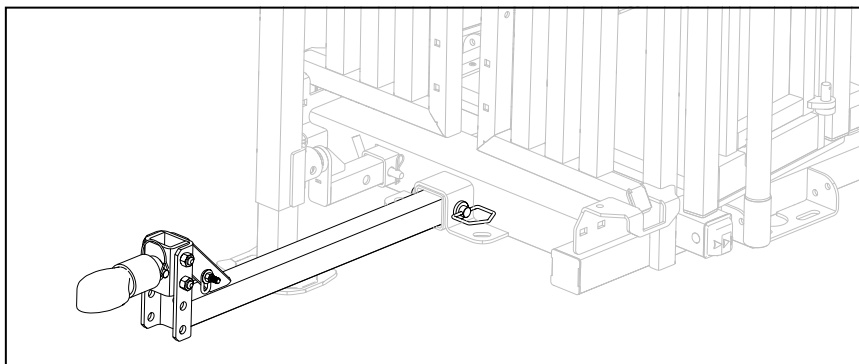
10. Using the front jack, raise the chute above the ground enough to install the hitch.



11. Install the hitch and secure with the pin.

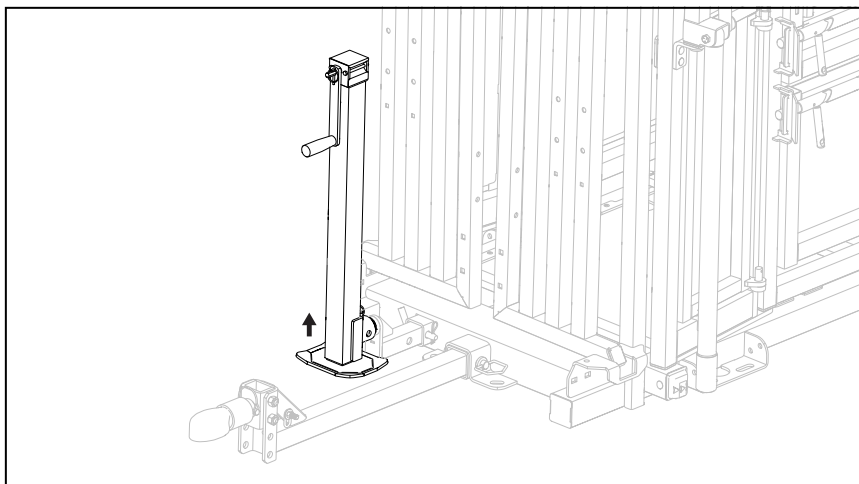


12. Attach the unit to the towing vehicle. Adjust the hitch to the proper position for the vehicle, if necessary.



NOTE: Ensure safety chains provided have been attached to the unit.

13. Retract the front jack completely.



SAFETY CHECK:

STOP

- Jacks are retracted completely.
- All doors and gates are shut.
- Tires are in good condition.

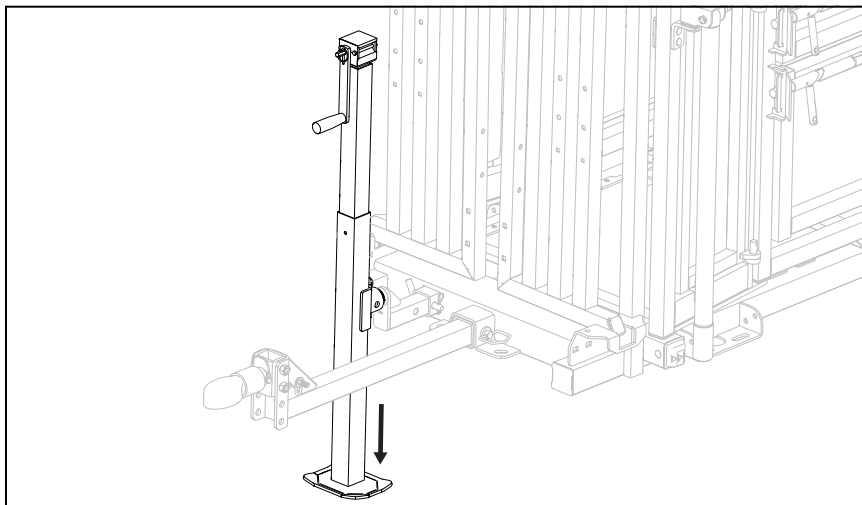
MAXIMUM SPEED: 50 KPH / 30 MPH

REMOVAL:

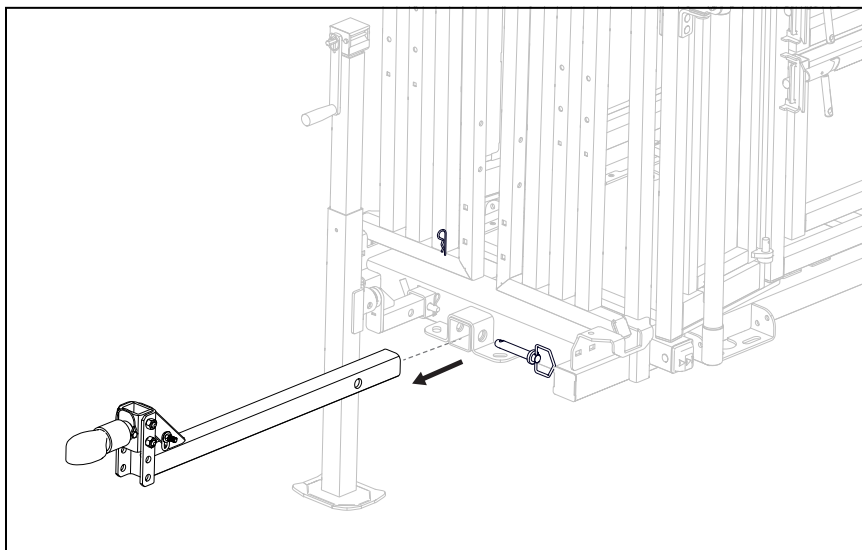


ENSURE YOU ARE DISCONNECTING THE CHUTE ON FIRM, LEVEL GROUND BEFORE PROCEEDING.

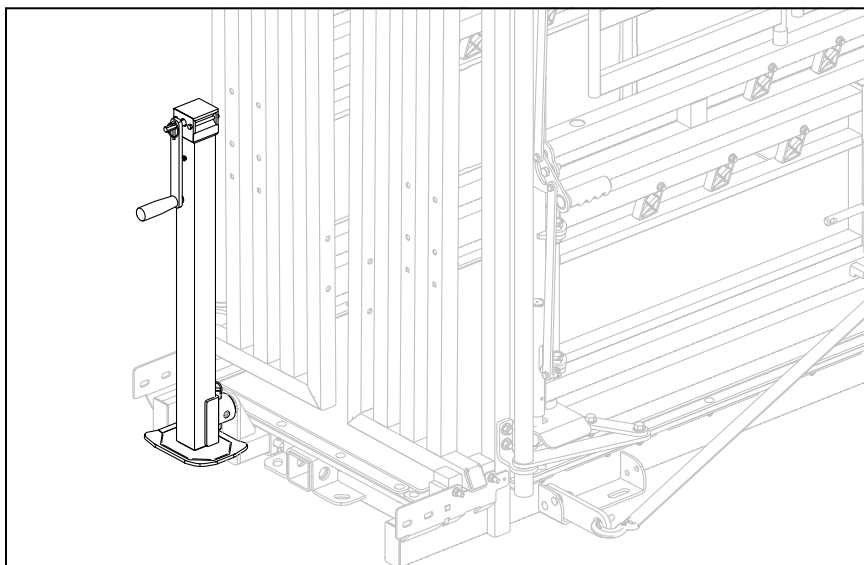
1. Lower the front jack to the ground and unhook the unit from the towing vehicle.



2. Remove the hitch.

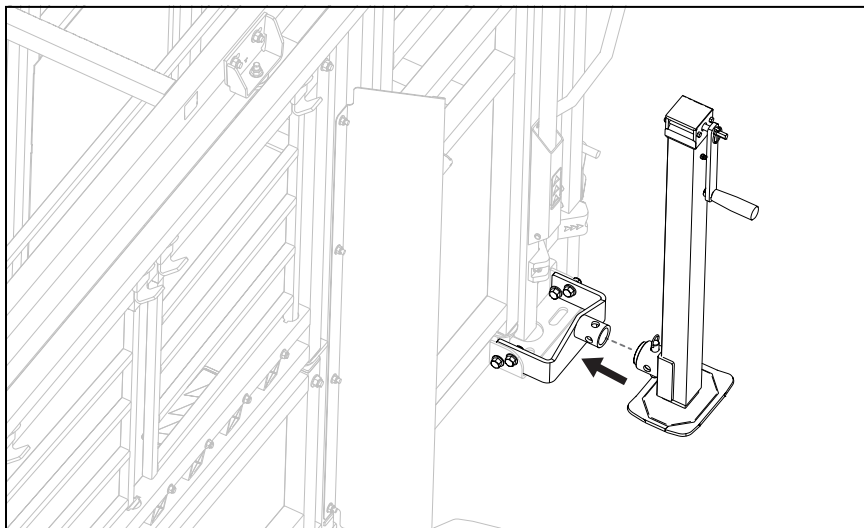


3. Using the front jack, lower the chute to the ground.

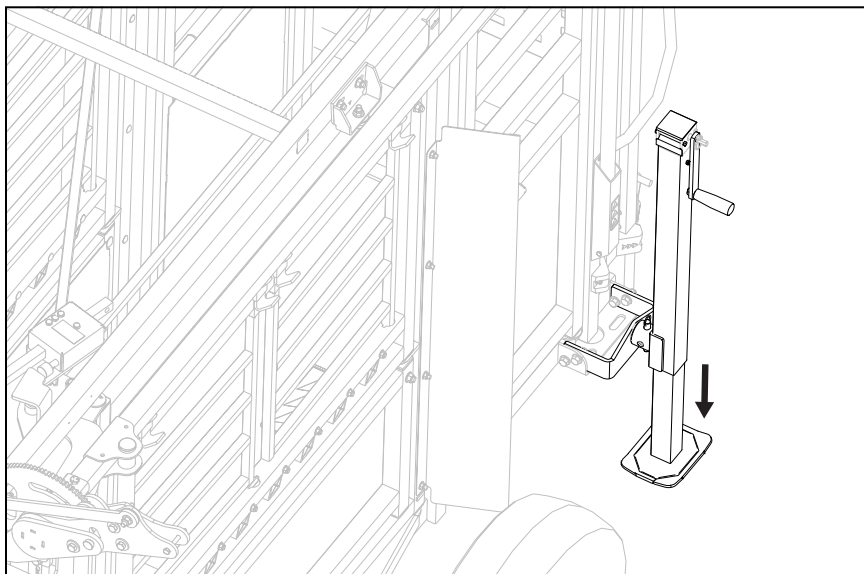


THE FRONT SECTION OF THE CHUTE MUST BE LYING FLAT ON THE GROUND BEFORE PROCEEDING.

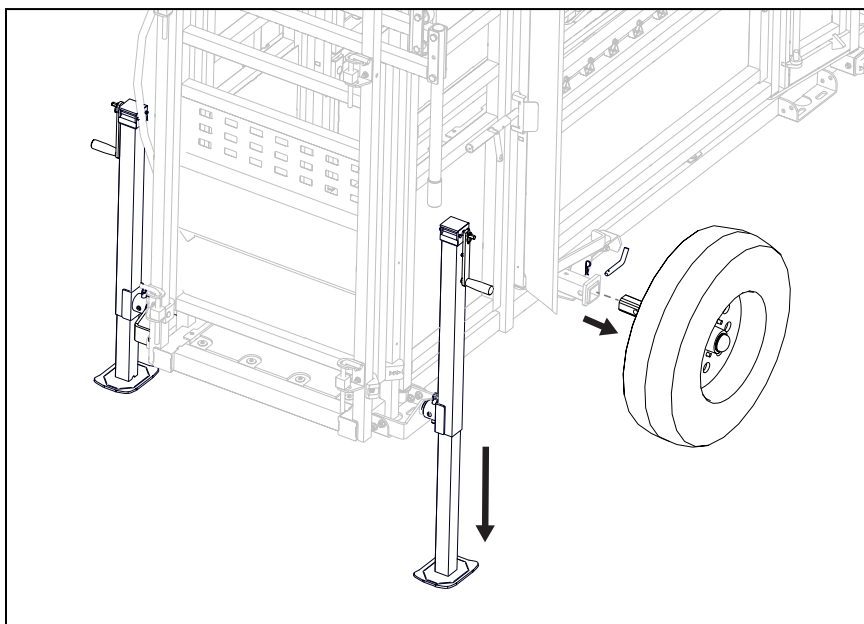
4. Transfer the front jack to the rear mount. Attach the second jack to the opposite side.



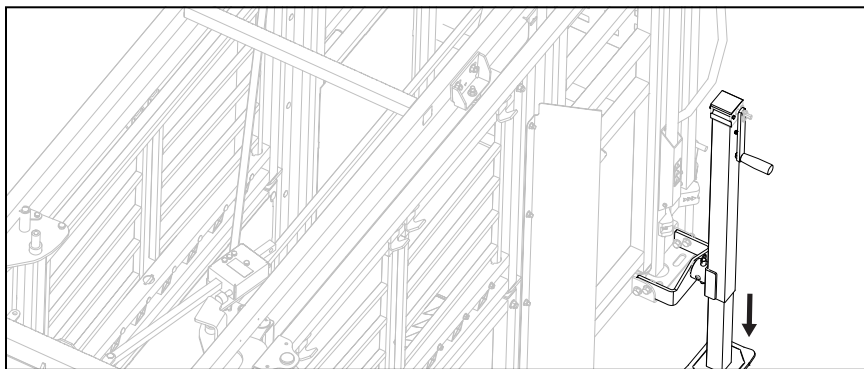
5. Using the jack, raise one side of the unit halfway.



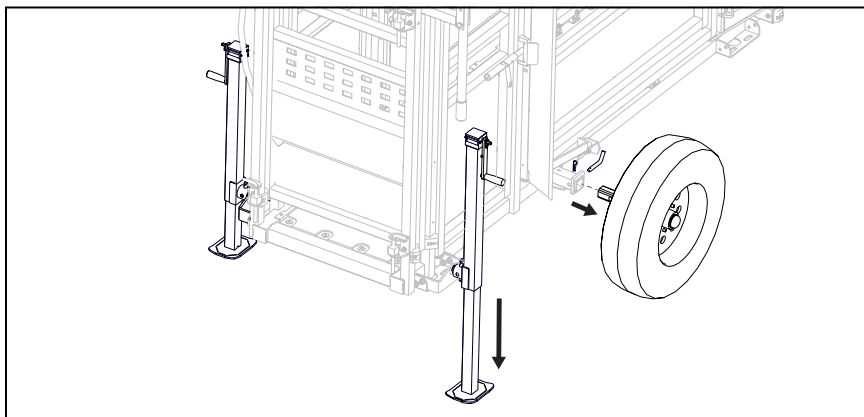
6. Jack the opposite side of the unit all the way up. Remove wheel and set safely aside.



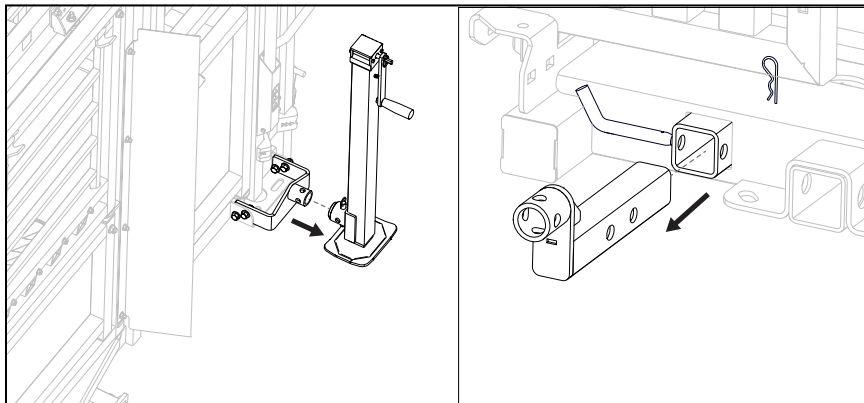
7. Jack the other side the rest of the way up. Remove wheel and set safely aside.



8. Retract both jacks until the chute lays flat on the ground.



9. Remove jacks and front jack adaptor. Set aside.



SAFETY CHECK:



- Inspect for damages due to transport.
- Head gate and squeeze mechanisms are functioning properly.
- All latches on doors, gates, and panels are functioning properly.
- When applicable, all add-ons are properly installed and functioning.

WHEEL MAINTENANCE

It is extremely important to apply and maintain proper wheel mounting torque on your trailer wheel. Torque is a measure of the amount of tightening applied to a fastener (nut or bolt) and is expressed as length force. For example, a force of 90 pounds applied at the end of a wrench on foot long will yield 90 ft. lbs. of torque. A torque wrench is the best method to assure the proper amount of torque is being applied to a fastener.

Be sure to use only fasteners matched to the cone angle of your wheel – usually 60° or 90°. The proper procedure for attaching your wheels is as follows:

1. Start all bolts or nuts by hand to prevent cross-threading.
2. Tighten bolts or nuts in the sequence shown for wheel torque requirements.
3. The tightening of the fasteners should be done in stages. Following the recommended sequence, tighten fasteners per wheel torque requirements diagram.
4. Wheel nuts/bolts should be torqued before first road use and after each wheel removal. Check and re-torque after the first 10 miles, 25 miles, and again at 50 miles. Check periodically thereafter.



If you have any questions regarding your product or require assistance, please contact Arrowquip's Client Care Team at **1-877-275-6075** or by email at **cs@arrowquip.com**

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