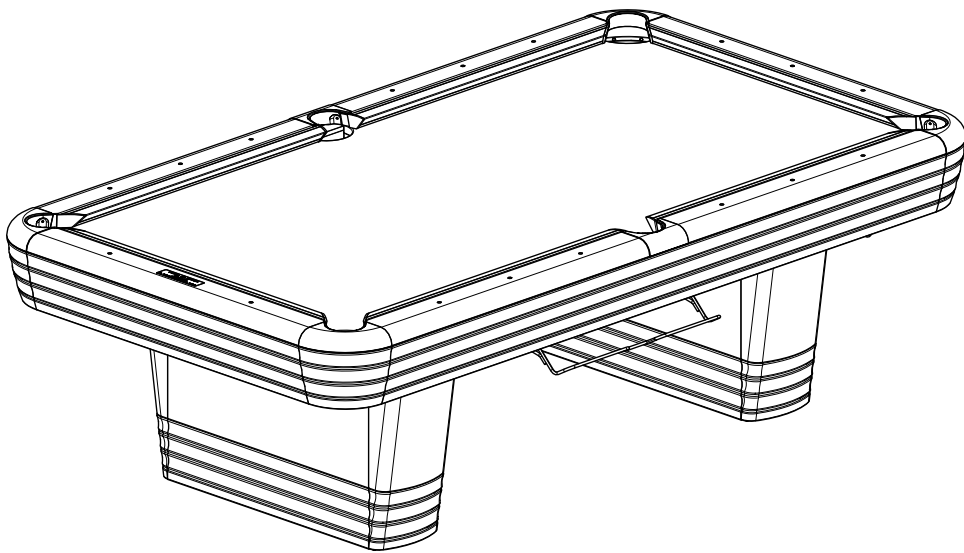


Centennial™

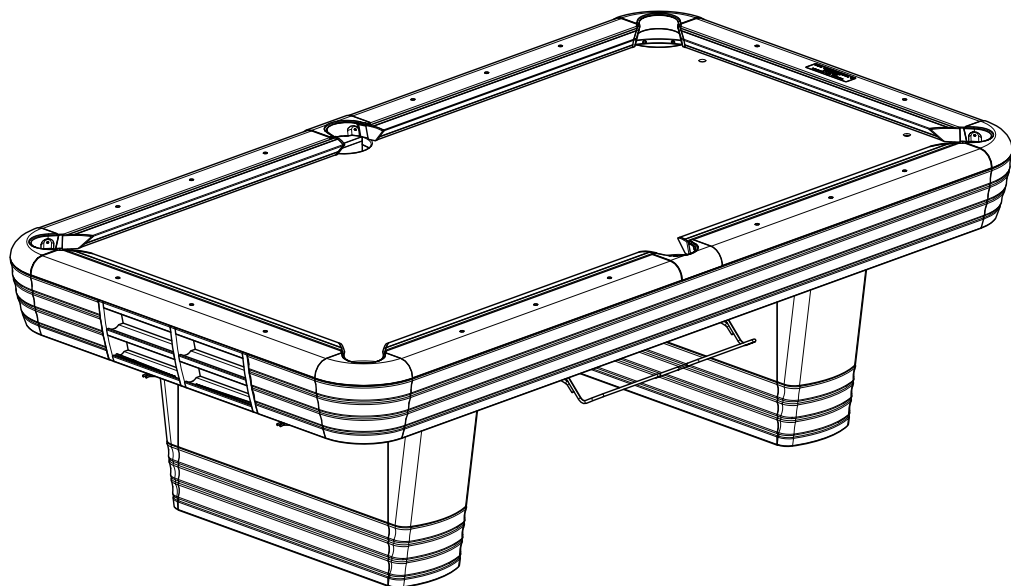
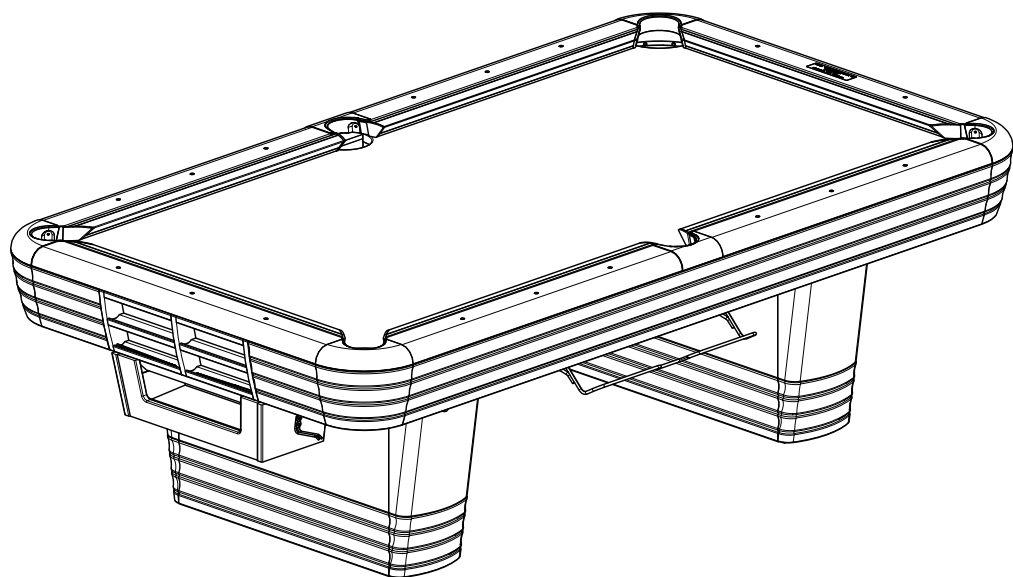


POCKET BILLIARD TABLE INSTALLATION MANUAL



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SERVICE DEPARTMENT P.O. BOX 68 BRISTOL, WI 53104
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NOTE: Please use the instructions in this manual to assembly the tables shown below. Also note that careful handling of all components will assure damage-free assembly.



BASEFRAME AND PEDESTAL ASSEMBLY

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FIGURE ONE

Step #1: Position two pedestal assemblies right side up as shown. Approximate the required spacing between pedestals for base frame attachment.

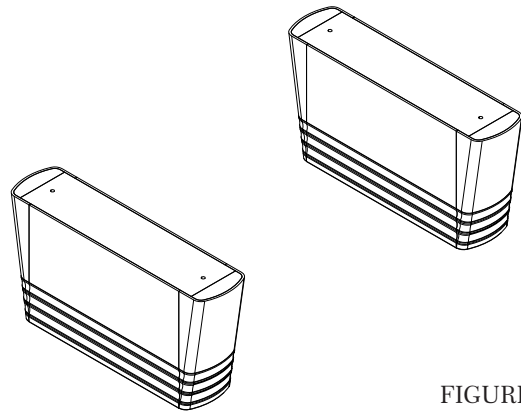


FIGURE ONE

FIGURE TWO

Step #2: Position two side sills, two end sills and two cross supports on the floor. If there is not enough floor space, assemble the base frame in position on top of the pedestal assemblies. Match stamped numbers along one side sill with the corresponding number stamped in the end of each end sill and cross support.

Step #3: Insert dowel pins at each end of end sills and cross supports into corresponding holes in each of the two side sills. Dowel pins are intended to be a friction fit and may need added force to mate with side sills. Use a rubber mallet as needed to persuade full engagement.

Step #4: Once full engagement has been achieved, fasten components together using 1/2-13 x 4 1/2 hex head bolts, 1/2 flat washers and 1/2-13 rectangular nuts. Tighten each joint securely.

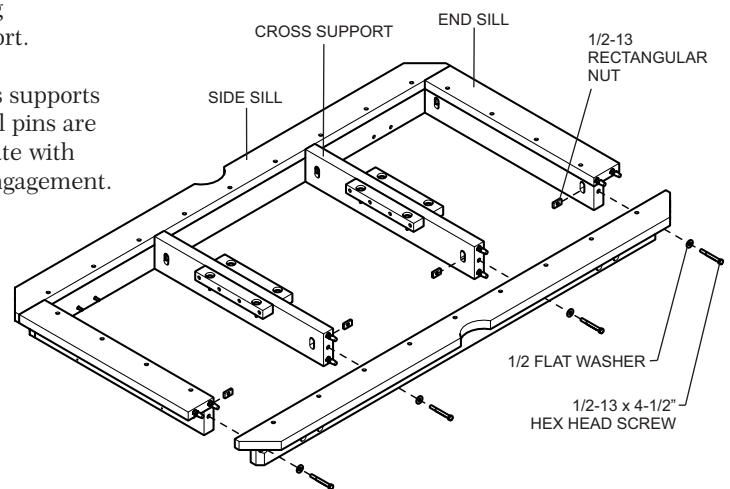


FIGURE TWO



BASEFRAME AND PEDESTAL ASSEMBLY

CENTENNIAL

FIGURE THREE

Step #5: Place base frame on top of pedestal. Loosely attach four right angle metal brackets, two at each end of each side sill, using 3/8-16 x 2 1/2 hex head bolts, 3/8 flat washers, and 3/16 hex nuts.

Step #6: Loosely attach metal brackets to each pedestal using 1/2-13 x 2 1/2 hex head bolts and 1/2 flat washer. Tighten all attachment hardware insuring the base frame is securely attached to the pedestal.

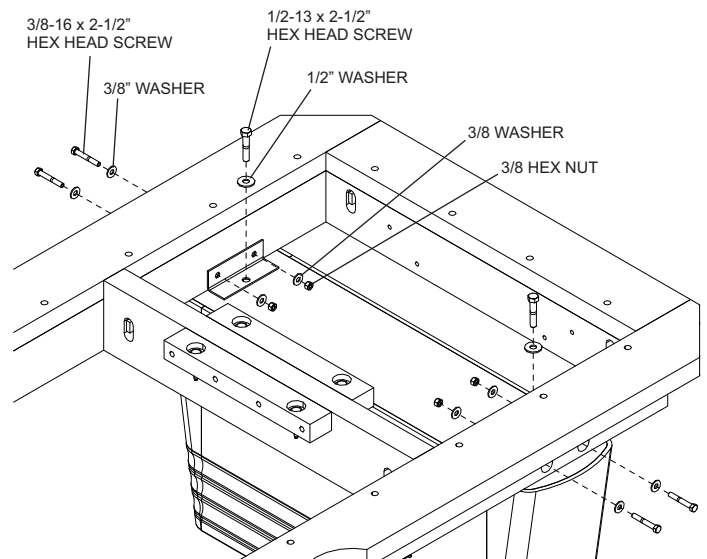


FIGURE THREE

FIGURE FOUR

Step #7: Position the assembly in its permanent location.

Step #8: Using a precision leveling device, place shims under pedestal foot pads as needed to insure the top surface of the base frame is level prior to placing slate.

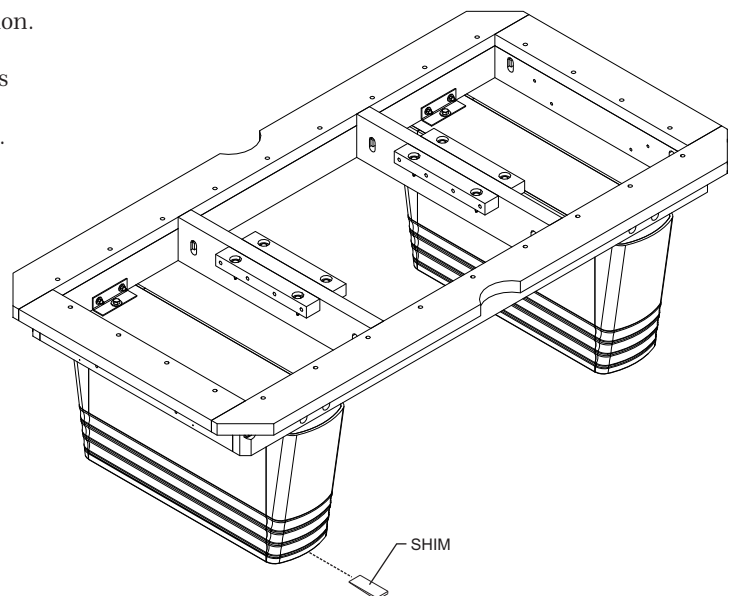


FIGURE FOUR



SLATE ASSEMBLY AND LEVELING

CENTENNIAL

FIGURE ONE

Step #1: With baseframe level and placed in its permanent location, position the center slate section evenly between the two cross supports as shown, with an equal amount of overhang at each side of the base frame.

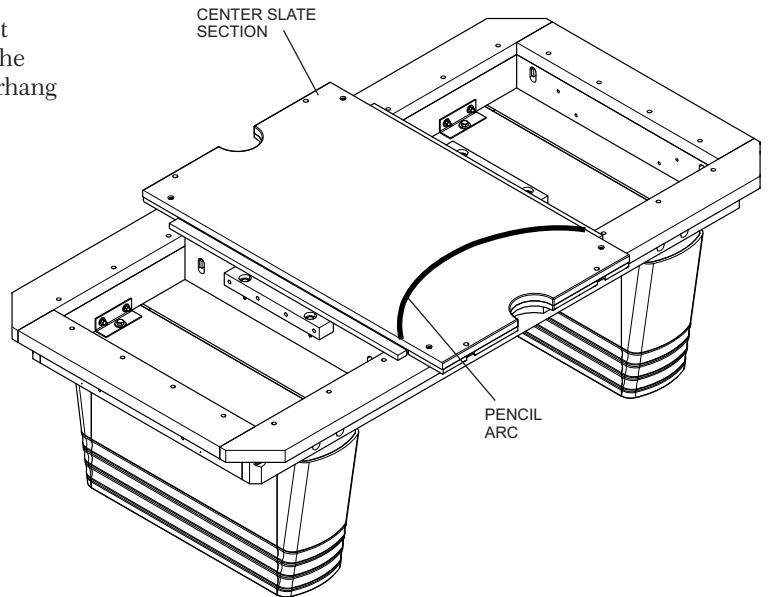


FIGURE ONE

FIGURE TWO

Step #2: Position the two end slate sections on the base frame as shown. Be sure that the penciled arc forms a radius as shown.

Step #3: Recheck to be sure the slate has an equal amount of overhang around the base frame.

Step #4: Using the 12 countersink holes in the slate as a template, pilot drill $5/32$ " diameter holes into the mounting cleats.

Step #5: Loosely fasten all sections with $1/4 \times 2-1/2$ flat head screws. Proceed to figure three before tightening screws securely.

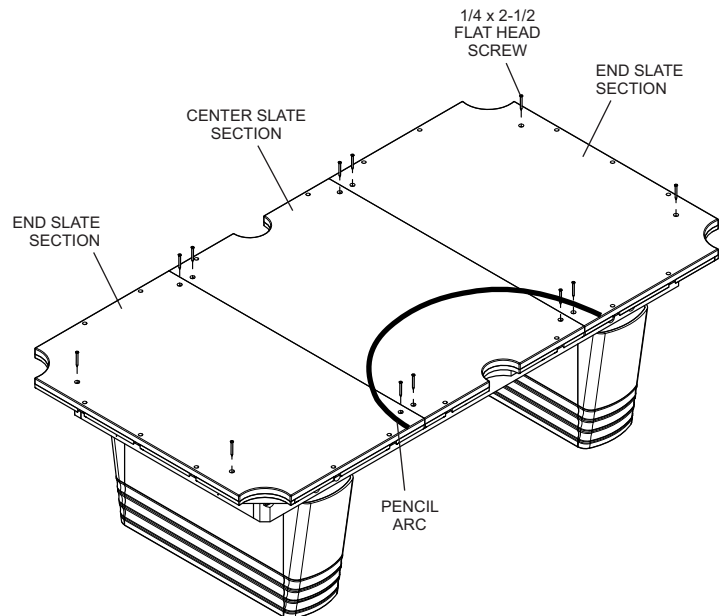


FIGURE TWO

SLATE ASSEMBLY AND LEVELING

CENTENNIAL

FIGURE THREE

Step #6: With a precision tool, level each end slate section by driving wooden slate shims or wedges (provided) between the top of the base frame and bottom of the slate as shown around perimeter only. Keep the wedges as close to the countersink holes as possible.

Step #7: With both end slates perfectly level, continue fastening the end slates at the joints. Recheck for levelness and, if necessary, back the screws out and adjust the shim position. Then, retighten the slate attaching screws.

Step #8: When satisfied that both end slates are level, shim the center slate section as required to obtain a flush fit at both joints, then screw the center slate down. Use hex base levelers to aid the slate joint leveling process. Hex base levelers are only available on the cross supports.

Step #9: Slate joints can now be filled with Rock Hard putty or wax. Lightly sand or scrape across the joints after grouting.

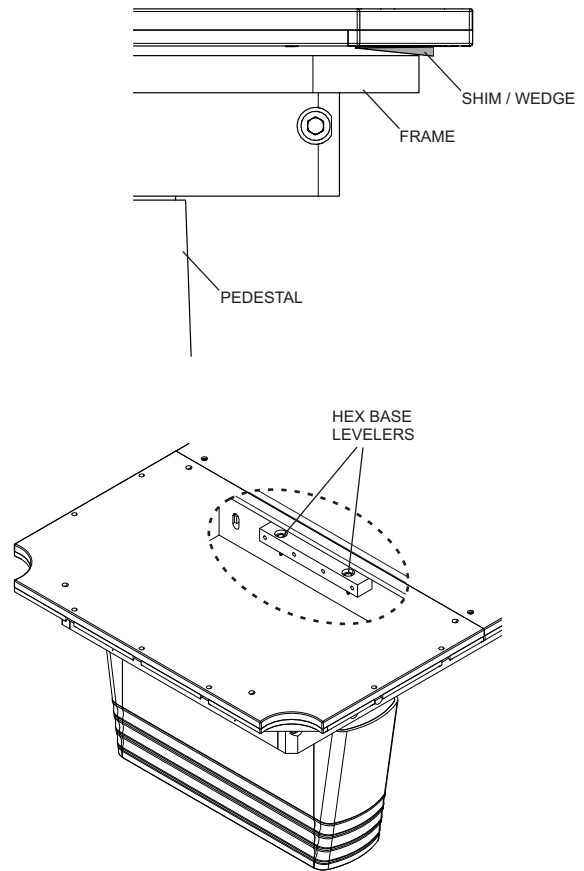


FIGURE THREE

FIGURE FOUR

Step #10: From the end of a bed cloth, cut strips of cloth approximately 1-1/2" wide by 8" long and glue the strips to the pocket cutouts. This is important as this will provide cushioning from ball impact and the bed cloth will last much longer.

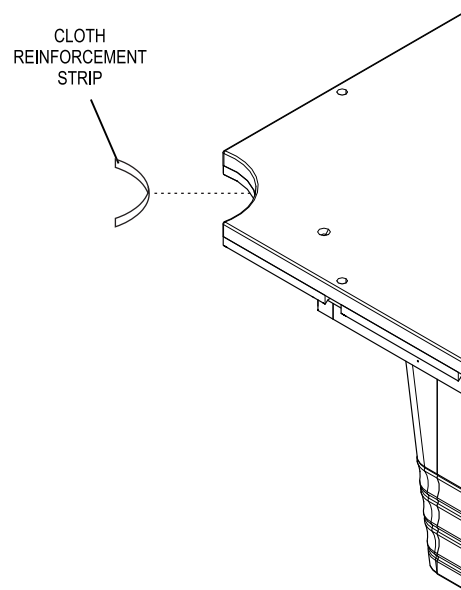


FIGURE FOUR



ATTACHING BED CLOTH TO FRAMED SLATE

Before attaching the billiard cloth, clean slate thoroughly.

FIGURE ONE

Step #1: Lay the bed cloth over the top of the slate, nap side up, with the nap running from the head end to the foot end of the table.

NOTE: In determining the direction of the nap, run your hand lightly over the surface of the cloth. If it meets resistance, it is going against the nap.

Step #2: Leave only enough cloth overhang at the head end and left side to permit tacking into the wood slate frame. Leave the balance of cloth overhang at the foot end and right side.

NOTE: Do not spread tacks on the bed cloth. Keep them in a container that slides over the cloth.

Step #3: Tack or staple the cloth securely to the wood frame at #1 with two tacks or staples approximately 2" apart.

Step #4: Stretch the cloth across the table and tack or staple securely at #2 with two tacks or staples 2" apart.

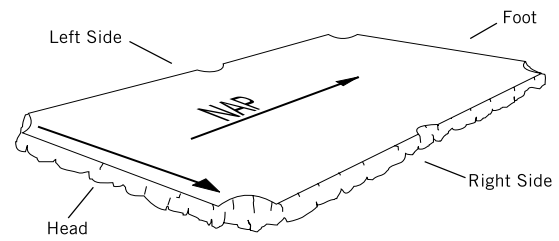


FIGURE ONE

FIGURE TWO

Step #5: Stretch the cloth from #1 to #3 and tack or staple securely into the wood frame at the left side of the table. See Figure B.

Step #6: Stretching the cloth across the table from #3 and pulling from #2, tack or staple the cloth at #4.

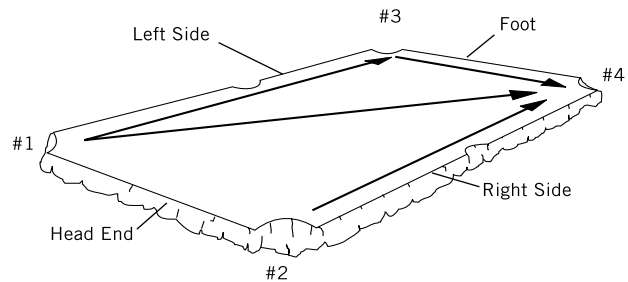


FIGURE TWO

FIGURE THREE

Step #7: On the left side, stretch the cloth tightly from #1 toward the side pocket opening and tack or staple securely at #5.

Step #8: Repeat Step 5, stretching the cloth from #3 and tacking or stapling at #6.

Step #9: On the right side of the table, grasp the cloth firmly and stretch across the table from #5 and toward the side pocket from #2 and tack or staple at #7.

Step #10: Repeat Step 7, stretching from #6 and toward the side pocket from #4 and tack or staple at #8.

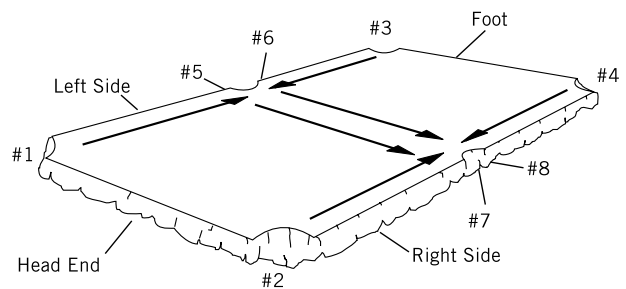


FIGURE THREE



ATTACHING BED CLOTH TO FRAMED SLATE

CENTENNIAL

FIGURE FOUR

Step #11: At location #9, cut a short slit in the cloth at the edge centered on the side pocket opening. Grasp the cloth firmly above this slit, pull the cloth into the side pocket opening and tack or staple to the wood frame. Complete fastening of the cloth to the side pocket opening, making sure the cloth is tacked or stapled to the wood frame.

Step #12: Stretching the cloth tightly across the table from location #9, repeat Step 11 at location #10.

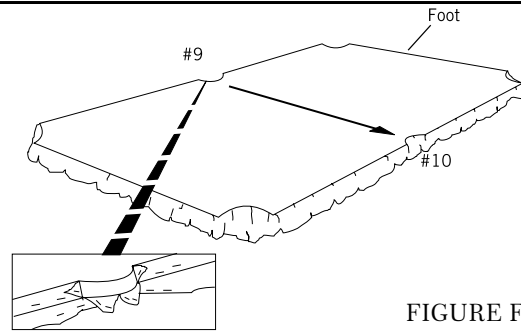


FIGURE FOUR

FIGURE FIVE

Step #13: At the head end of the table, tack or staple the cloth at location #11, maintaining uniform overhang.

Step #14: Pull the cloth from location #11 toward location #12 and tack or staple securely along the wood frame, keeping the cloth even along the head end.

Step #15: Stretch the cloth firmly from location #11 to the foot end of the table and tack or staple at location #13.

Step #16: Stretch the cloth tightly from locations #12 and #13 toward location #14 and tack or staple securely along the wood slate frame.

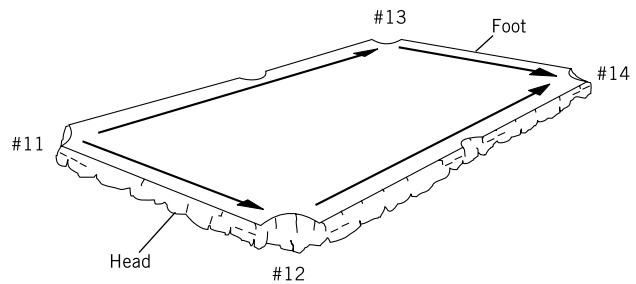


FIGURE FIVE

FIGURE SIX

Step #17: Tack or staple all of the left side on 2" centers keeping the cloth even along the wood frame.

Step #18: Tack or staple the balance of the head end on 2" centers also keeping the cloth even along the wood frame.

Step #19: Stretch the cloth tightly toward the foot end of the table, tacking or stapling on 2" centers along the wood frame at the foot end.

Step #20: Stretch the cloth tightly across the table to the right side, tacking or stapling on 2" centers all the way along the wood frame at the right side.

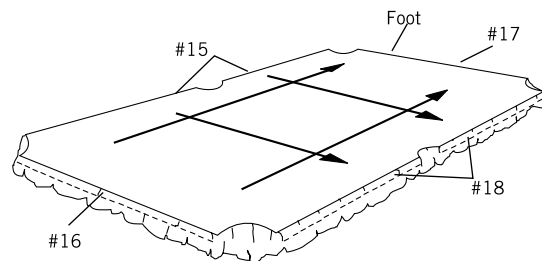


FIGURE SIX

FIGURE SEVEN

Step #21: Stretch the cloth into the corner pocket openings and tack or staple to the wood slate frame.

Step #22: Trim off excess cloth around the perimeter of the slate. Locate the eighteen (18) rail attach holes and cut clearance holes in the cloth with a sharp knife.

NOTE: Occasionally cloth will stretch, leaving wrinkles at the pockets. To retighten, remove apron, one end rail and one side rail. Pull cloth taut, and retack or restaple along the open end and side to restore original tightness.

Cut holes in cloth at rail both locations.

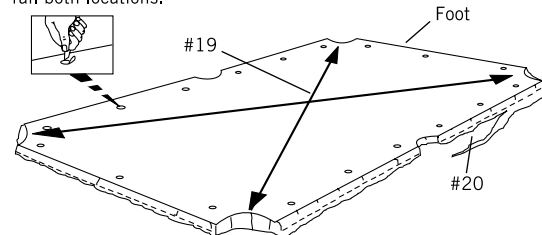


FIGURE SEVEN



ATTACHING RAIL CLOTH

CORNER POCKET FIGURE ONE

Step #1: Place cloth on rail with the back side down. The cloth should have equal amount of overhang at both ends of rail and extend 1/2" over the featherstrip groove on the cushion side as shown.

Step #2: Except for approximately 3" at end of rail, tap featherstrip down with a tapping block and hammer, starting at center of rail. Stretch cloth tightly toward each end of rail and tap featherstrip down.

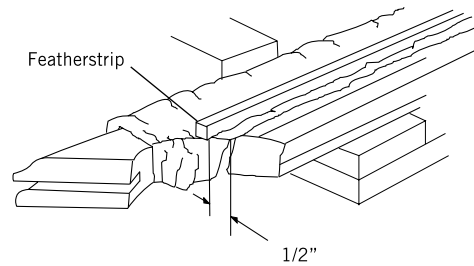


FIGURE ONE

FIGURE TWO

Step #3: At each end of rail, pull the cloth toward the rubber cushion an additional 3/4". Then tap remainder of featherstrip down.

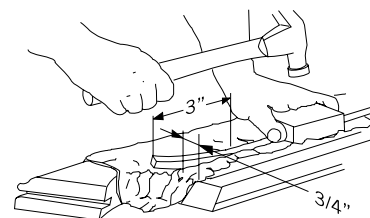


FIGURE TWO

FIGURE THREE

Step #4: Trim the cloth on cushion side of featherstrip along the total length of featherstrip as illustrated.

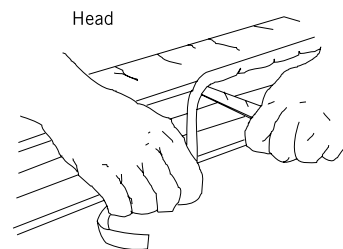


FIGURE THREE

FIGURE FOUR

Step #5: Fold the cloth down over front of rail, then using thumb and forefinger as a guide along front edge of the cushion to keep the tapping block at rear edge of featherstrip, tap the featherstrip down flush with rail surface as shown

NOTE: Never try to tap a featherstrip flush with just a hammer as you will surely dent the rail surface behind the featherstrip.

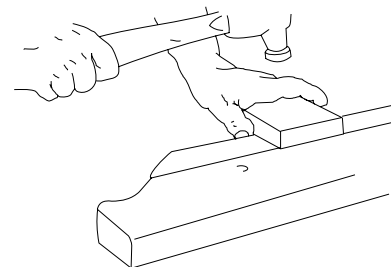


FIGURE FOUR

FIGURE FIVE

Step #6: Turn rail over and at corner pockets fold the cloth over the mitred edge as shown, stretching tightly and working out any wrinkles as you staple three places in area shown.

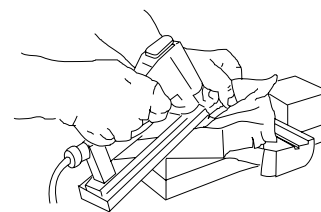


FIGURE FIVE



ATTACHING RAIL CLOTH (CONTINUED)

FIGURE SIX

Step #7: Staple three places along the rear edge of the pocket facing X, then trim off excess cloth at pocket area.

Step #8: If rail is an end rail, repeat Step 7 at other corner pocket. Then, starting at center of rails, stretch cloth tightly over cushion and staple at bottom of rail working toward

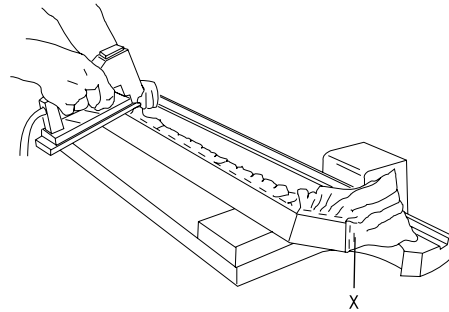


FIGURE SIX

FIGURE SEVEN

Step #9: Trim excess cloth from bottom of rail flush with edge of cloth relief groove.

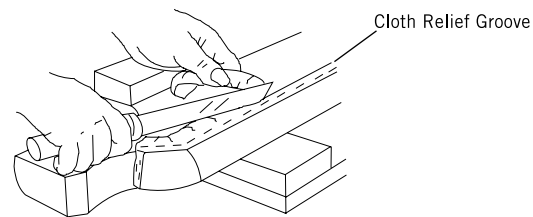


FIGURE SEVEN

SIDE POCKET
FIGURE EIGHT

Step #10: At side pocket, stretch the cloth tightly over nose of cushion and staple three places as shown.

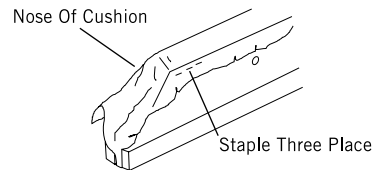


FIGURE EIGHT

FIGURE NINE

Step #11: Slit the cloth up to the edge of cushion nose as shown. Then firmly pull the small strip to the rear of the cushion and staple at rear of facing.

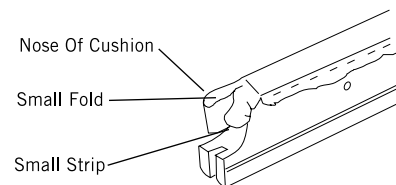


FIGURE NINE

FIGURE TEN

Step #12: Hold the small fold in place with thumb and forefinger and firmly hold it down over facing. Then staple at rear of facing and at bottom of rail as shown.

Step #13: Trim excess cloth as required.

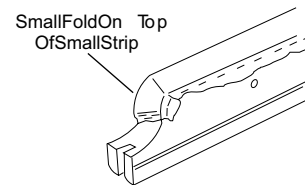


FIGURE TEN



RAIL ASSEMBLY

FIGURE ONE

Step #1: Position six rails, four corner pocket castings, and two side pocket castings upside down in their respective locations on a protective surface as shown.

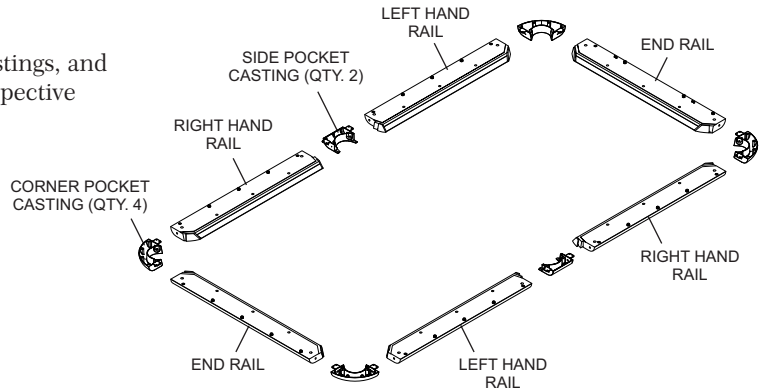


FIGURE ONE

FIGURES TWO & THREE

Step #2: Attach four corner pocket castings and two side pocket castings as showing in Figures 2 and 3. Align the castings with the holes in the rails. Place a 5/16" joint connector nut, slotted end up, in the holes provided. Align the threaded hole in the connector nut (rotate with screwdriver) with casting bolt holes.

Then thread a 5/16" external tooth lock washer and 5/16" flat washer into the joint connector nut. Align each casting flush with bottom surface of the rail and extending past back edge of the rail, approximately 1/16". Tighten each hex cap screw once properly aligned.

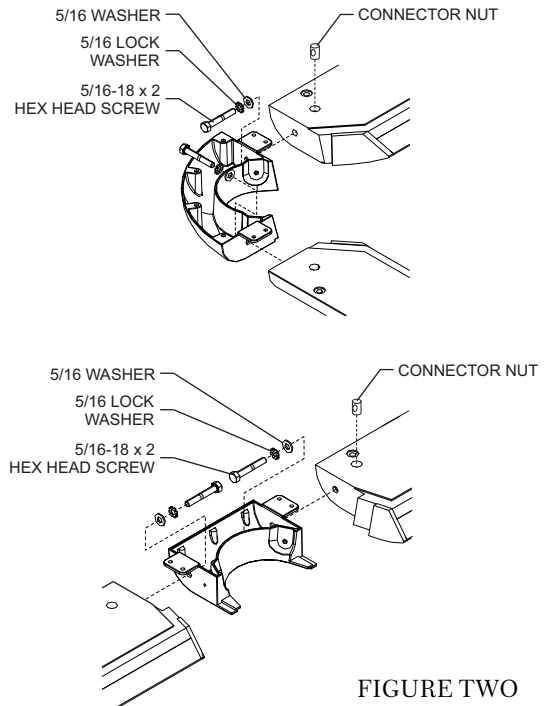


FIGURE TWO

Step #3: Place a straight edge against both rails, across the side pocket casting and check the alignment. If the two rails are not aligned, loosen the hex cap screw on one side of the pocket casting and bring the rails into alignment. Re-tighten the hex cap screws and re-check; repeat as needed to align rails on both sides.

Step #4: With hex cap screws tightened, drive #8 x 3/4" pan head screws through the holes provided in each casting tab, into bottom surface of wood rail. Two screws per tab, two tabs per casting.

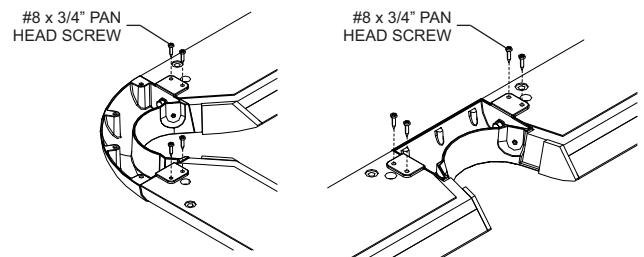


FIGURE THREE



APRONS, APRON CORNERS AND BALL STORAGE RACK ASSEMBLY

CENTENNIAL

FIGURE ONE

Step #1: With the rail assembly in the upside down position, place two side apron assemblies, one head end apron assembly and one foot end apron assemblies upside down in position on top of the rail assembly. Using 1/4-20 x 3/4" hex head bolts and 1/4 flat washers, loosely start fasteners through apron flange, into threaded inserts in bottom surface of the rails.

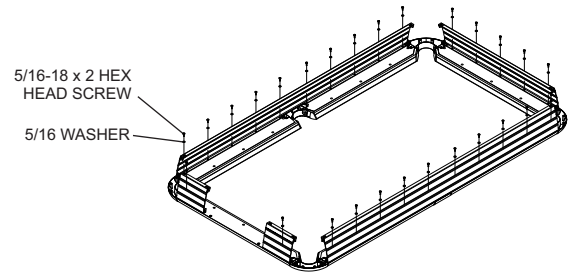


FIGURE ONE

FIGURE TWO

Step #2: Loosely attach four apron corner castings to four corner pocket castings using #10 x 3/4" hex flange head cap screws.

Step #3: Loosely connect each apron end to four apron corner castings using #10 x 5/8" hex flange head cap screw. Properly align apron with apron corner casting exterior surfaces and tighten fasteners securely.

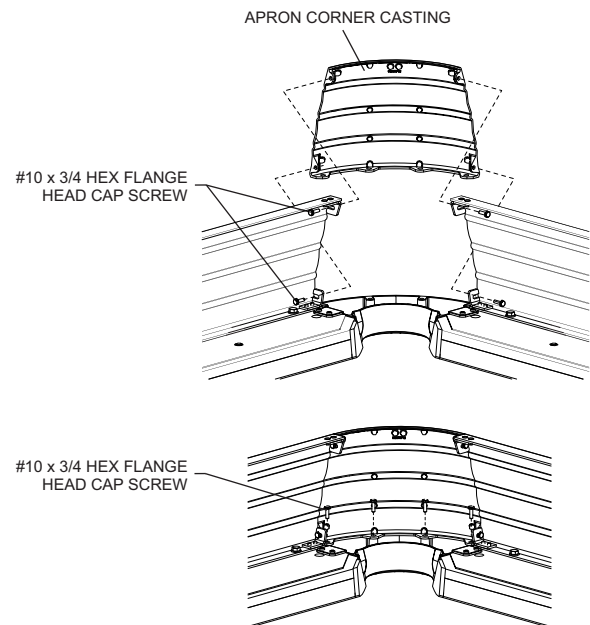


FIGURE TWO

FIGURE THREE

Step #4: Loosely attach the ball storage rack to the foot end rail using two 1/4-20 x 3/4" hex head bolts.

Step #5: Connect the end of each foot apron to the ball storage rack using two 1/4-20 x 3/4" hex head bolts. Align each apron end with front profile of ball storage rack and tighten all fasteners.

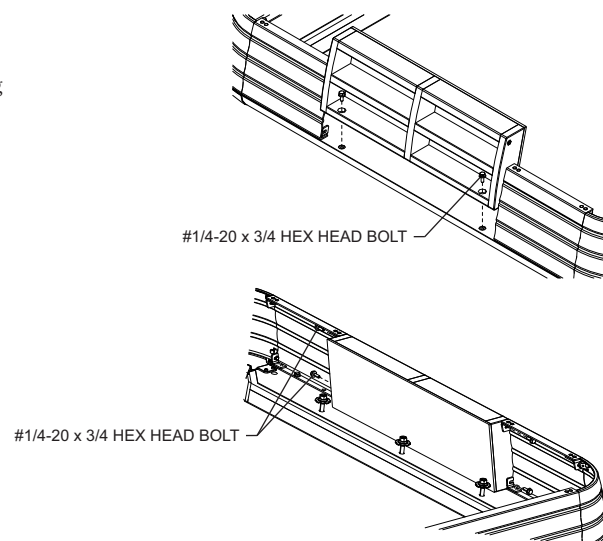


FIGURE THREE



APRONS, APRON CORNERS AND BALL STORAGE RACK ASSEMBLY

CENTENNIAL

FIGURE FOUR

Step #6: At this time, tighten all apron flange attach fasteners that have been left loose.

Step #7: Thread all eighteen 3/8-16 x 2 3/4 machine studs into each location on the bottom surface of the six rails. Thread machine studs in until contact with wood is made and then loosen 1/4 turn. This will allow for free movement of the stud and internal nut plate.

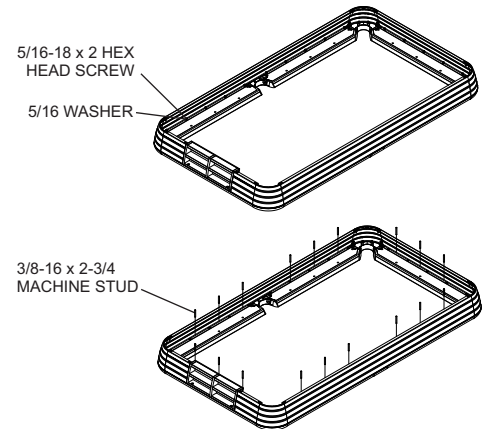


FIGURE FOUR

FIGURE FIVE

Step #8: Carefully turn the rail and apron assembly over and lower over the table. Finger clearance between bottom edge of aprons and slate is limited, therefore, shift toward one end and lower that end over the slate first, then shift in the opposite direction and lower the other end over the slate. All eighteen machine studs must be aligned with the clearance holes in the slate during this process.

CAUTION: Do not allow excessive weight to be applied to wood components when turning the assembly over, the strain may cause damage.

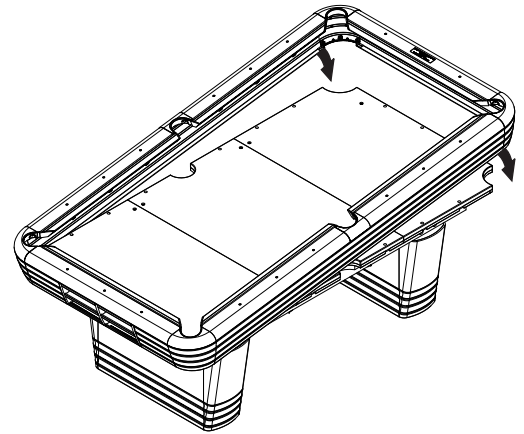


FIGURE FIVE

FIGURE SIX

Step #9: Thread the hex nut and dome washer onto all eighteen machine studs. Center entire rail and apron assembly across width and length of the slate and tighten to a recommended torque of 15 ft/lbs.

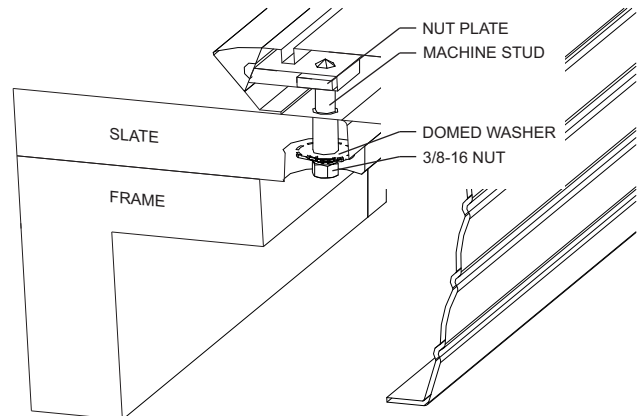


FIGURE SIX

POCKET, STORAGE BOX, TRIANGLE RACKS, BRIDGE RACK AND BED SPOT ASSEMBLY

CENTENNIAL

FIGURE ONE

Step #1: Install and fasten four corner pockets and two side pockets into their respective pocket castings using #10-24 x 5/8 socket head machine screw and #10 external tooth washer.

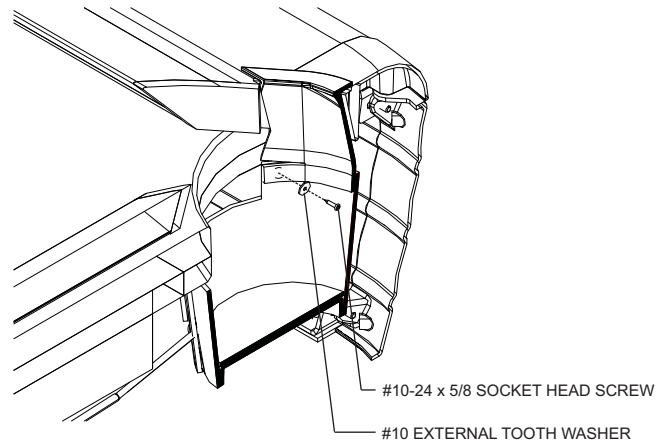


FIGURE ONE

FIGURE TWO

Step #4: Attach two triangle racks to the foot and end sill of the base frame using #8 x 3/4 pan head screws and #8 flat fender washer. Attach utilizing the pre-drilled pilot holes in the end sill. After initial attachment, hang eight and nine ball racks, if available, and adjust racks as needed vertically.

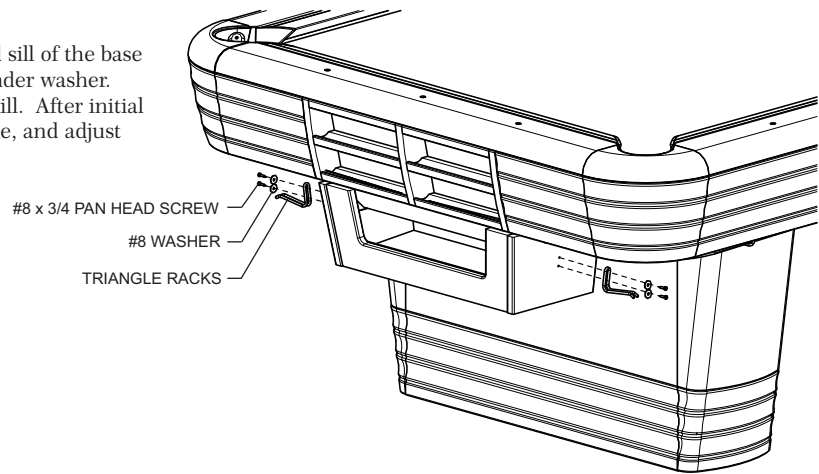


FIGURE TWO



POCKET, STORAGE BOX, TRIANGLE RACKS, BRIDGE RACK AND BED SPOT ASSEMBLY

CENTENNIAL

FIGURE THREE

Step #5: Attach one bridge rack to the bottom edge of both side sills using #8 x 1-1/4 pan head screws. Attach utilizing the pre-drilled holes at the center of each side sill bottom edge. Use the forward most hole pattern in the bridge rack brackets for this application.

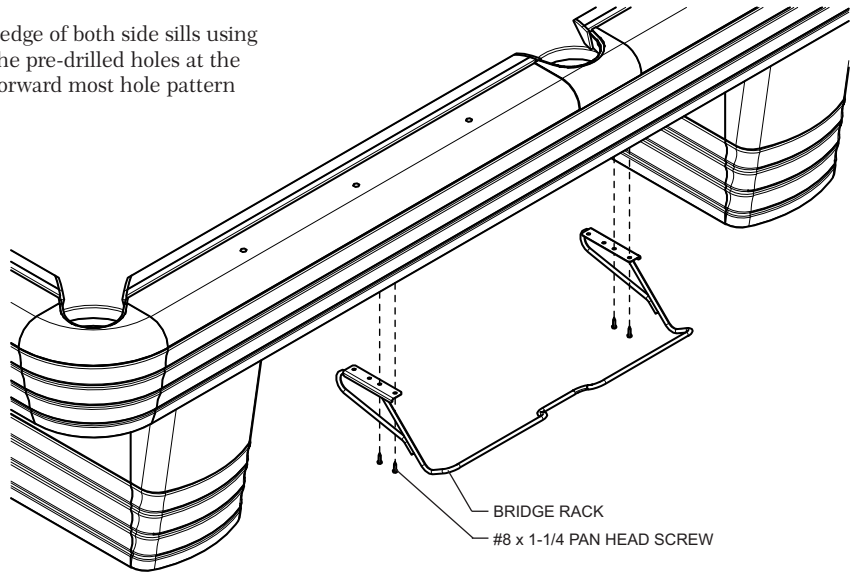


FIGURE THREE

FIGURE FOUR

Step #6: Locate and apply the foot end bed spot. Bed spot is to be aligned with the center rail sight in each rail and the center sight of side rail on the foot end of the table. (Head bed spot optional and located in the same manner)

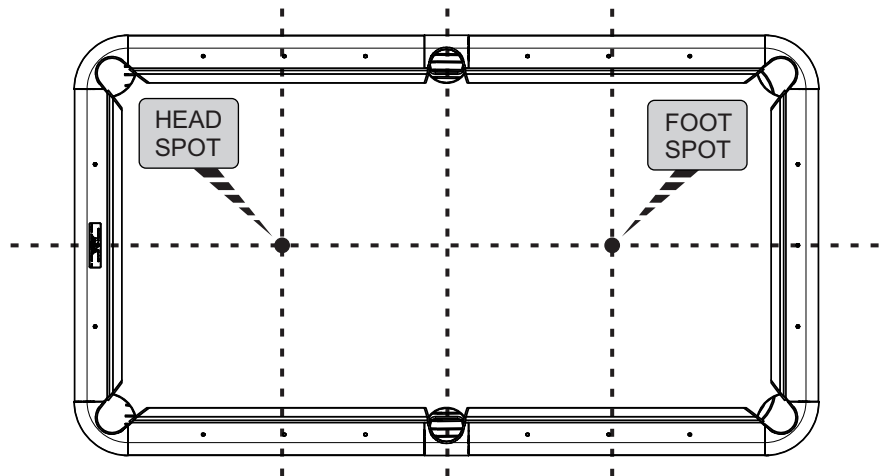


FIGURE FOUR



GULLY VERSION ASSEMBLY

CENTENNIAL

FIGURE ONE

Step #1: Attach two triangle racks to each end of the receiver box assembly using #8 x 3/4 pan head screws and #8 flat fender washer. Attach utilizing the pre-drilled pilot holes in the end sill. After initial attachment, hang eight and nine ball racks, if available, and adjust racks as needed vertically.

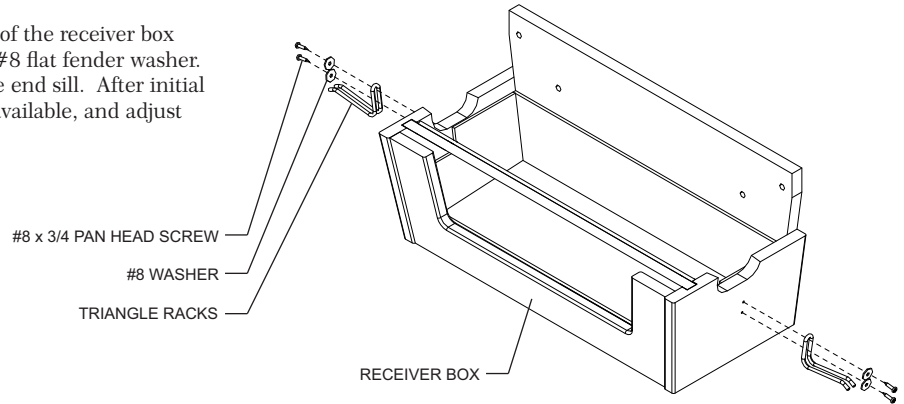


FIGURE ONE

FIGURE TWO

Step #2: Align and attach the receiver box assembly using 5/16-18 x 4" hex head bolt, flat washers and 5/16-18 hex nuts.

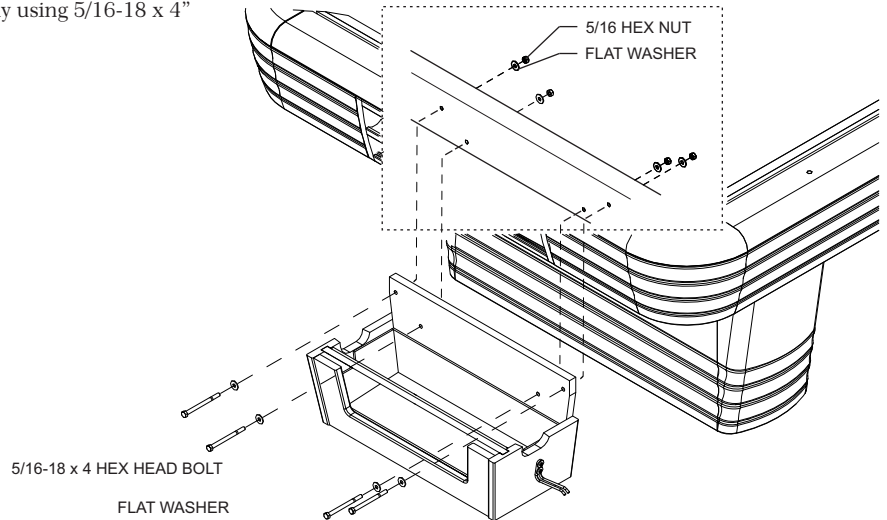


FIGURE TWO



GULLY VERSION ASSEMBLY CONTINUED

CENTENNIAL

FIGURE THREE

Step #3: Working from the foot end of the table, place the foot end gully track assemblies. One side at a time, insert the end through the opening in the receiver box assembly. Hold the track assembly in place, making sure all hanger brackets are up against the base frame, and attach using #10 x 1-1/4 pan head screws and #10 fender washers.

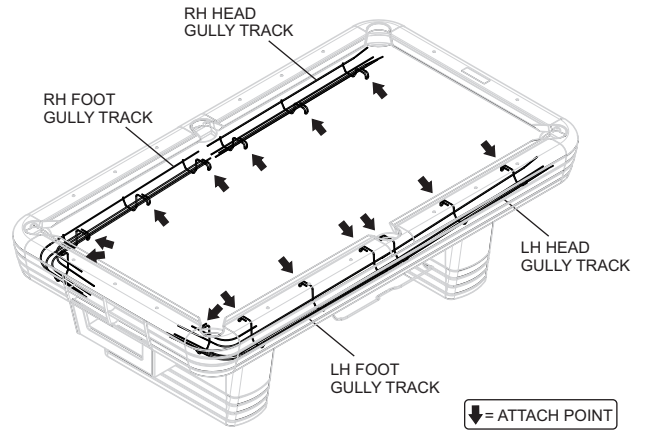


FIGURE THREE

FIGURE FOUR

Step #4: Attach both head end gully track assemblies utilizing the same hardware. Hold track assemblies in place, making sure all hanger brackets are up against the base frame and side pocket ends are touching the foot end track assemblies leaving no gap.

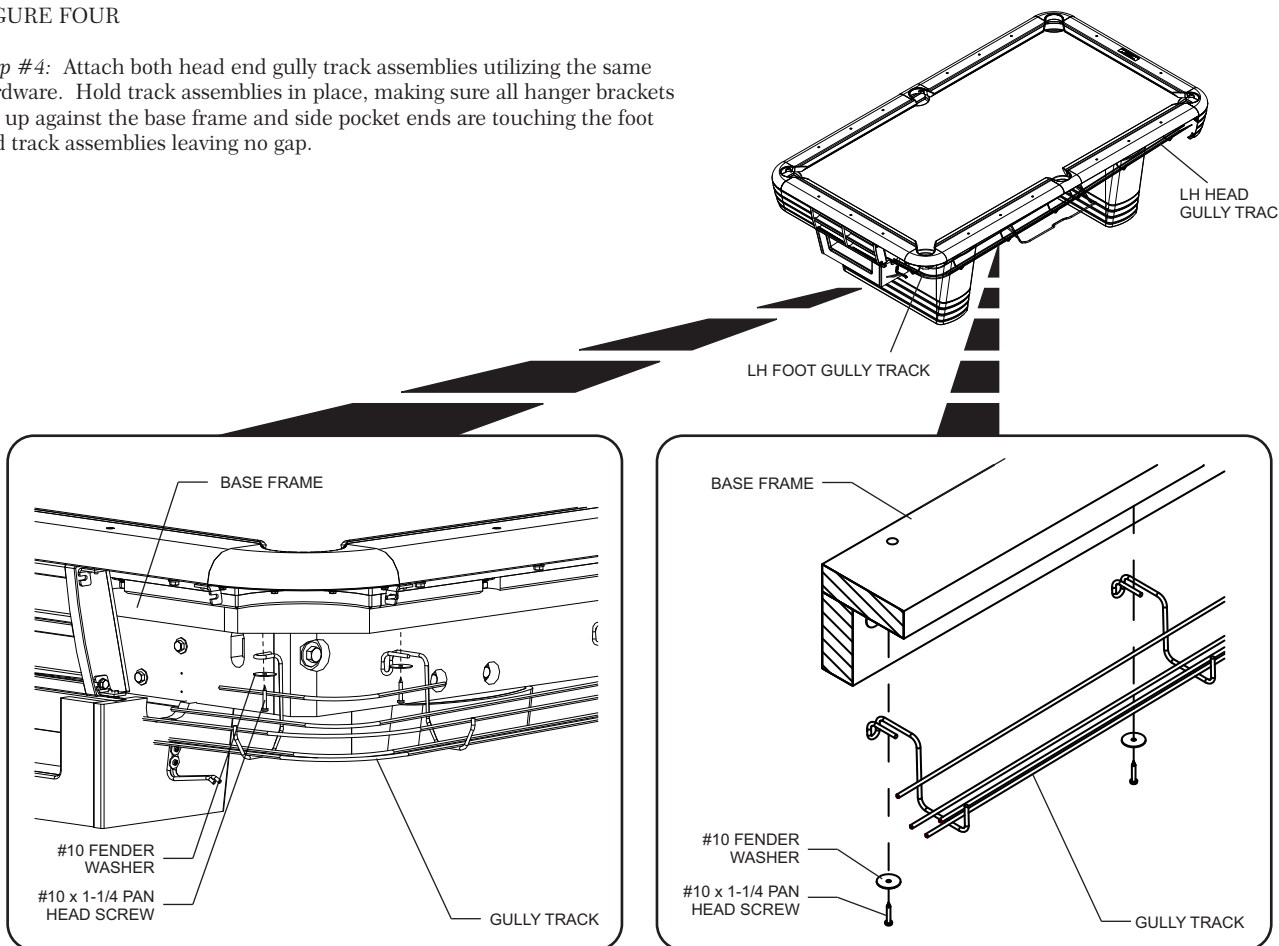


FIGURE FOUR

