

BRUNSWICK

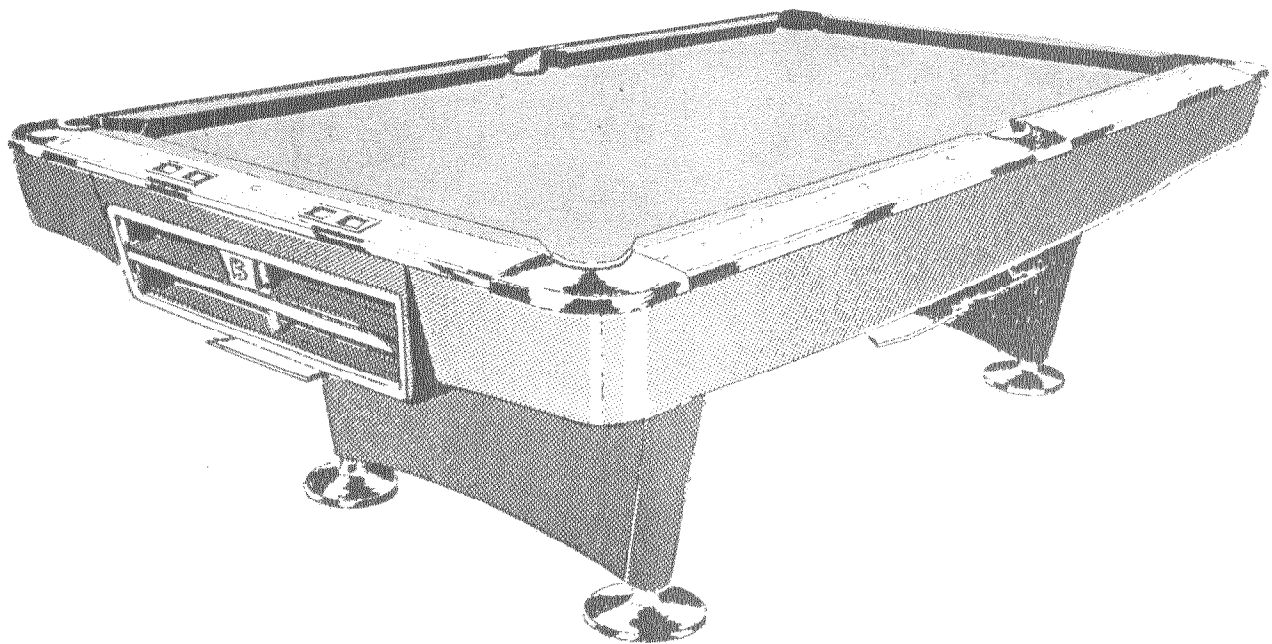
Since 1845

INSTALLATION MANUAL

Please follow step-by-step instructions

GOLD CROWN III billiard table

MODEL "A K"



FEB. 1976

**SERVICE DEPARTMENT
MARION VIRGINIA**

51-903039-001

printed in U.S.A.

Each Brunswick Gold Crown Billiard Table has been carefully inspected to insure proper fit and is warranted against defective workmanship.

Carefully unpack and examine each box and crate as well as the packing materials before discarding, to make sure that you have all the necessary parts for the installation of the Billiard Table.

The installation procedure outlined in this manual reflects the many years of know-how by Brunswick's expert billiard mechanics. Careful attention to this procedure during installation of the table will result in efficient assembly.

To be assured the Gold Crown Billiard Table will remain level during the many years of service, it must be installed on a solid unyielding surface.

PACKAGE INSTRUCTIONS

A general note on number of cartons and contents. Remove all parts carefully to protect finishes. When removing aprons from cartons, keep them in matched sets for each table as received. Most important is the handling of the slate. Follow instructions on the slate crates.

(4) FOOT CASTINGS IN ONE CARTON	(1) CARTON — MISCELLANEOUS HARDWARE, SHIMS, ADHESIVE, SPOTS AND TRIANGLE RACK	BALL RETURN TABLE RECEIVER BOX IN ONE CARTON	
(2) LEGS IN ONE CARTON	RAIL CASTINGS IN ONE CARTON	POCKETS OR GULLY BOOTS IN ONE CARTON WITH HARDWARE	(2) BALL RETURN GULLIES IN ONE PACKAGE
(1) STRETCHER IN ONE CARTON	RAILS IN ONE CARTON	SET APRONS IN ONE CARTON	(2) BRIDGE RACKS WITH HARDWARE IN ONE CARTON
COMPLETE BASE FRAME	BALL STORAGE RACK IN ONE CARTON		

INSTALLATION

LEG AND STRETCHER ASSEMBLY

1. Attach the adjustable foot castings to legs as shown. (Figure 1)

Turn castings into legs as far as they will go and tighten nut finger tight only.

2. Turn legs right side up and attach stretcher (four places) securely using:

- (4) Hex Head Machine Bolts 1/2 - 13 x 3"
- (4) Flat Washers 1 3/8 O.D. x 9/16 I.D.

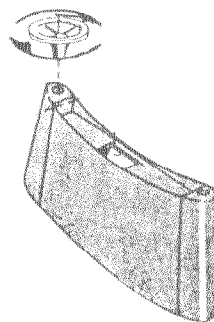


FIGURE 1

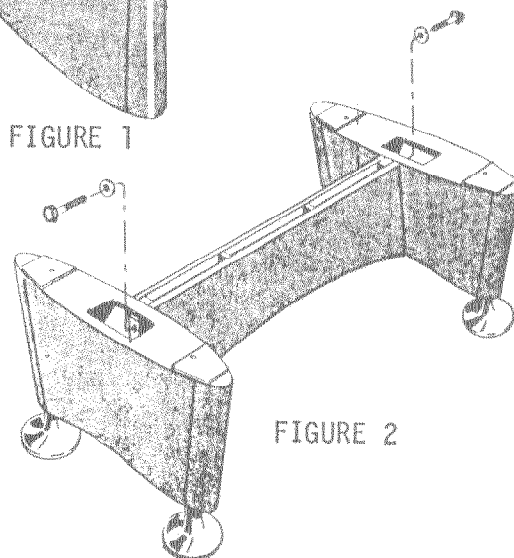
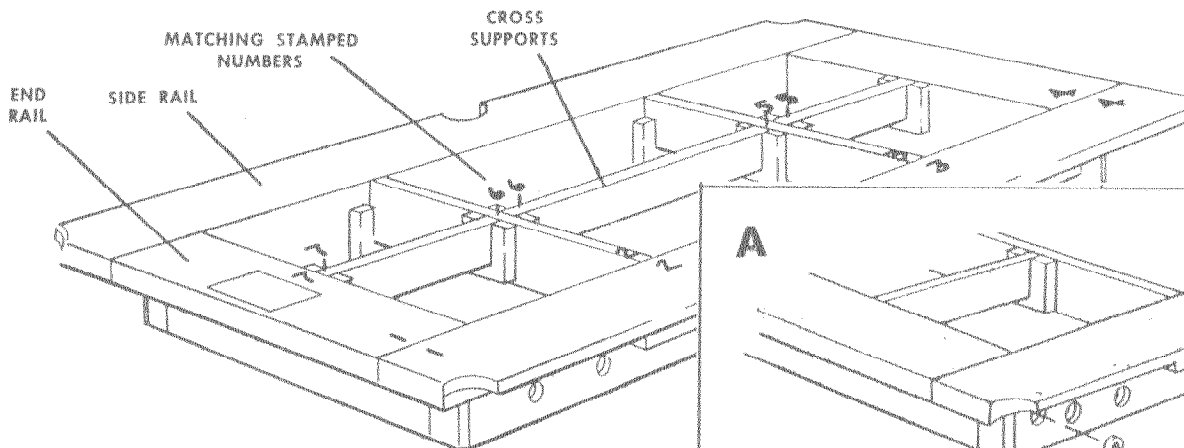


FIGURE 2

INSTALLATION

BASE FRAME ASSEMBLY



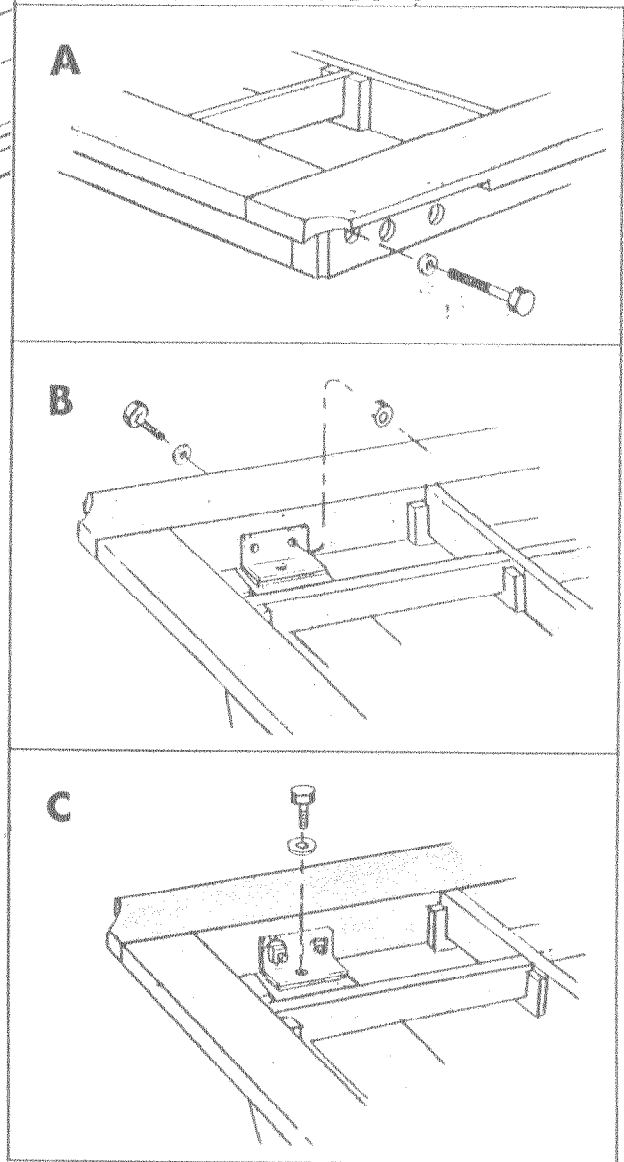
3. Assemble the complete base frame on the floor, matching the numbers stamped on component parts, as shown above.

Carefully lift the base frame to the top of the leg assembly. Use package marked base frame hardware to assemble as follows:

- A** Attach the side rail members to the end rail members which contain blind nuts. Use one bolt at each corner.
- (4) Hex hd. machine bolts $\frac{1}{2}$ -13 x 7"
 - (4) flat washers $1\frac{1}{8}$ o.d. x $\frac{5}{16}$ i.d.

- B** Secure one leg attaching bracket at each corner of the side rail members, using:
- (8) Hex hd. mach. bolts $\frac{3}{8}$ -16 x $3\frac{1}{4}$ "
 - (16) flat washers 1" o.d. x $\frac{7}{16}$ i.d.
 - (8) Hex nuts $\frac{3}{8}$ -16

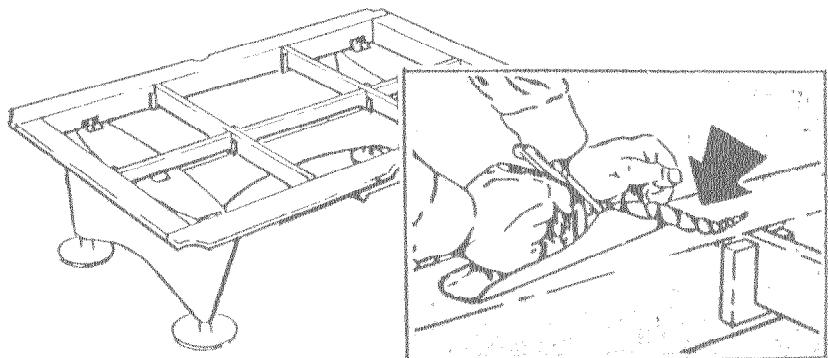
- C** Secure the four leg attaching brackets to blind nuts in legs using:
- (4) Hex hd. mach. bolts $\frac{1}{2}$ -13 x 2"
 - (4) flat washers $1\frac{1}{8}$ o.d. x $\frac{5}{16}$ i.d.



4. LEVELING BASE FRAME

Place the table in its permanent location. With a straight edge check the top of base frame for any high or low spots. All high spots should be removed by planing. Then level table.

NOTE: The table feet must be leveled on a solid unyielding surface.

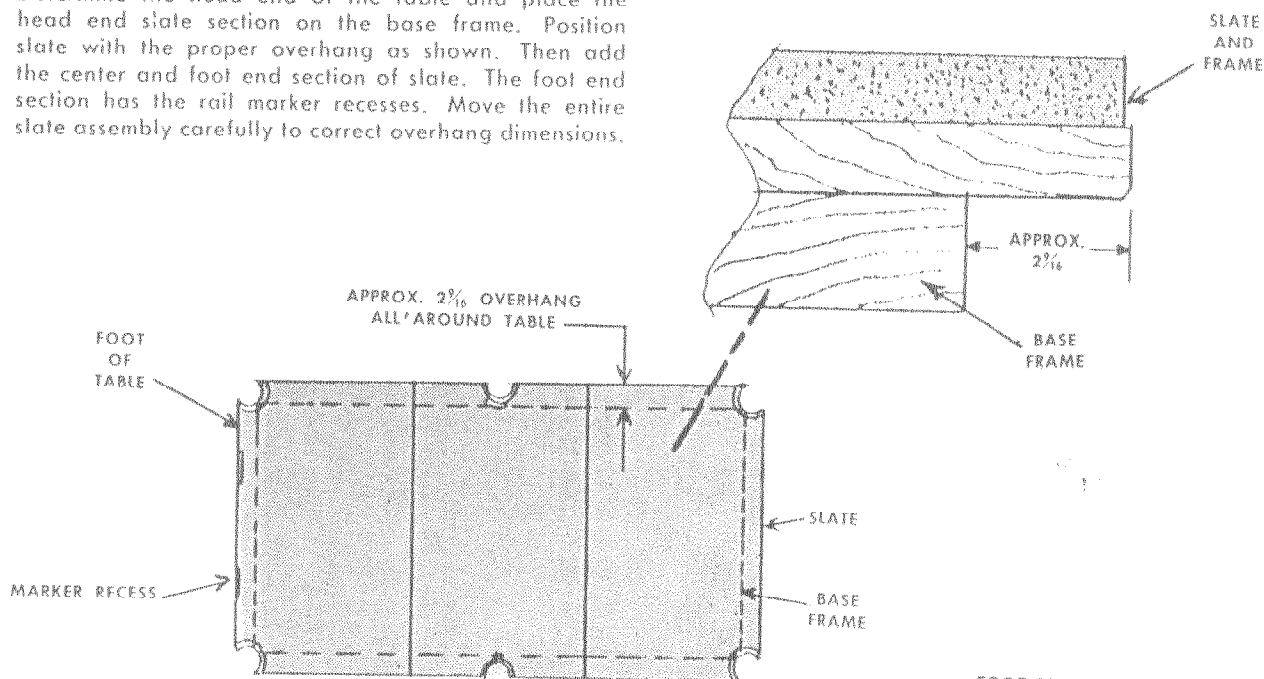


INSTALLATION

SLATE ASSEMBLY

5. PLACING SLATE

Determine the head end of the table and place the head end slate section on the base frame. Position slate with the proper overhang as shown. Then add the center and foot end section of slate. The foot end section has the rail marker recesses. Move the entire slate assembly carefully to correct overhang dimensions.



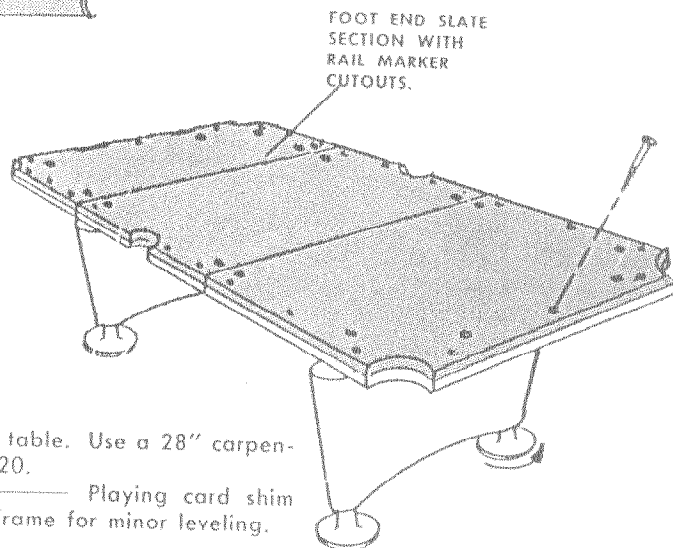
6. ATTACHING SLATE

Drill $\frac{3}{16}$ " pilot holes for wood screws. Make sure the pilot hole angle matches countersunk hole in slate. Insert (2) #16 x $3\frac{1}{4}$ " f.h. wood screws into the foot and head end of slate and tighten. Then insert the (16) remaining screws, tightening them alternately left and right until all screws are securely fastened. When done in this manner the slate joints will be tight.

CAUTION: Do not use a lubricant on screws anchoring slate to base frame. Any lubricant will stain bed cloth.

7. After the slate has been installed, check the level of the table. Use a 28" carpenter's level. Slate should not be out of level more than .020. For major levelness correction, Adjust foot castings. ——— Playing card shim stock can be used under slate joints between slate and frame for minor leveling.

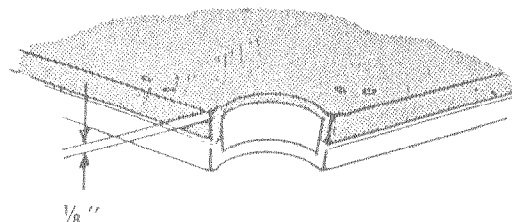
With the table completely level, fill all slate cracks, chips and screw holes with the fast setting plaster of paris material furnished with each shipment. When dry, sand smooth and thoroughly clean slate with bench or dust cloth.



8. CLOTH REINFORCEMENT PIECES

The slate cloth reinforcement pieces are packaged with the rails.

Apply a coat of brubacol adhesive furnished with shipment on slate pocket openings and cement cloth as shown. When the cement has dried, lightly sand any sharp edges.



HOW TO ATTACH BRUNSWICK BILLIARD CLOTH

The following instructions for attaching Brunswick billiard cloth applies to all models of Brunswick billiard tables.

When covering billiard tables, clean the slate thoroughly. Recheck tables for levelness and shim where necessary. If the plaster of paris in the slate joints is broken, replaster the joints using a putty knife. When plaster is dry sand the joints until the slate is perfectly smooth.

Lay the bed cloth over top of slate, nap side up, with nap running from head to foot end of table. New model table has recesses in the slate for rail markers, designating the foot end of the table.

To determine direction of nap, run hand lightly over surface of cloth — if it meets a slight resistance, it is going against the nap.

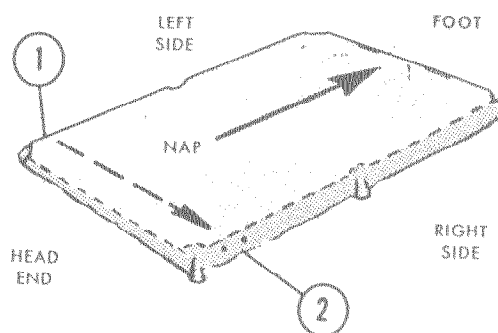
Leave only enough cloth at head and left side to permit tacking into wood slate frame. (This is especially important on 5 x 10 table.) Leave balance of cloth overhang, at the foot and right side.

Do not spread tacks on bed cloth — keep them in a small container that slides over cloth.

1. Tack cloth securely to wood slate frame at (1) with two tacks approximately 3" apart.

2. Stretch cloth across the table and tack securely at (2) again using two tacks 3" apart.

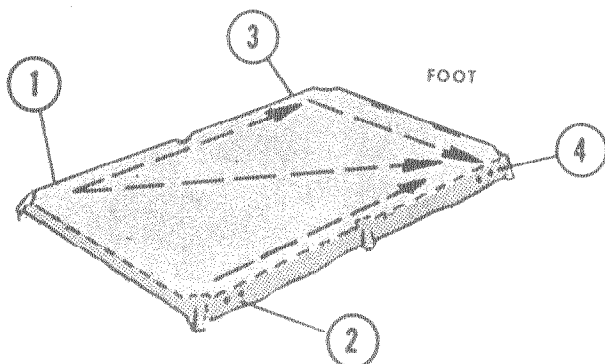
A.



3. Stretch cloth from (1) to (3) and tack securely into wood slate frame at left side of table.

4. Stretching cloth across table from (3) and pulling from (2), tack cloth at (4).

B.



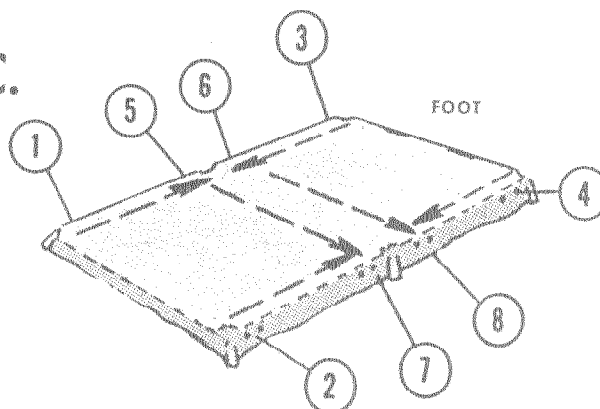
5. On left side, stretch cloth tightly from (1) toward side pocket opening and tack securely at (5).

6. Repeat operation 5, stretching cloth from (3) and tacking at (6).

7. On right side of table, grasp cloth firmly, stretch across table from (5) and toward side pocket from (2) and tack at (7).

8. Repeat operation 7, stretching from (6) and toward side pocket from (4) and tack at (8).

C.



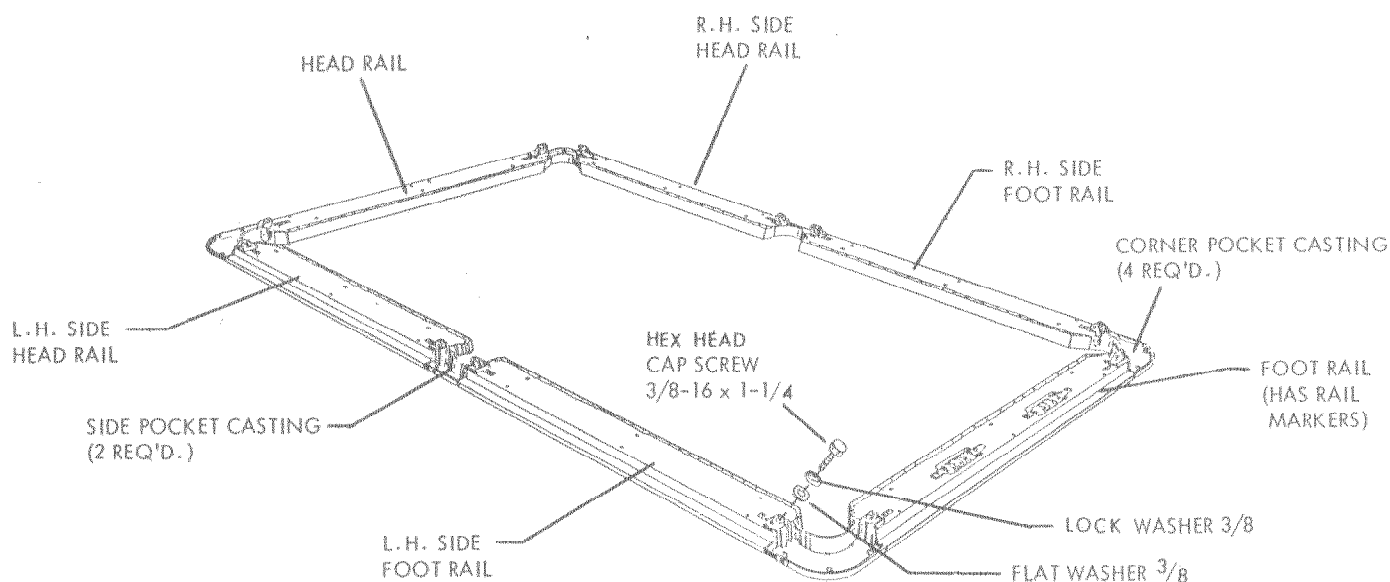
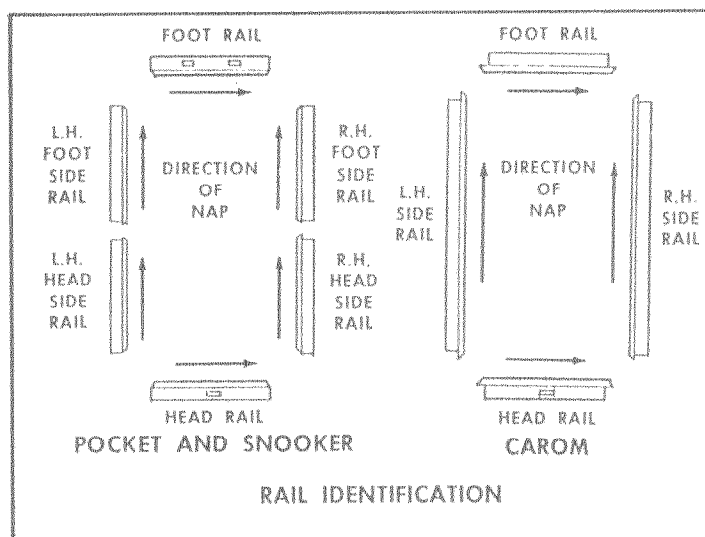


FIGURE 1

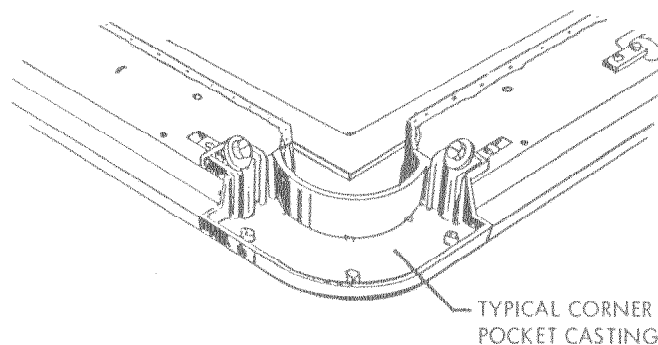
9. Remove the six (6) rail assemblies from the package and place them upside down on a large piece of paper or rug.

Position the rail assemblies upside down as shown in Figure 1. All rail sections are marked for easy identification.



10. Attach the rails to the six (6) pocket castings as shown in Figures 1 and 2. Leave the mounting bolts finger tight.

11. Place a carpenters square against the cushions at all four corners (Fig. 2). Square the corners and tighten the corner pocket casting bolts.



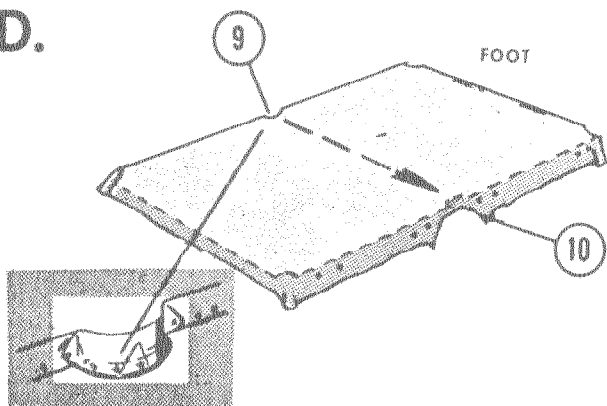
12. Place a straight edge against the rails of both left and right hand side rails. Be certain the rails are straight, then tighten the side pocket casting bolts on both sides of the table.

FIGURE 2

9. At (9), cut a short slit in cloth at edge centered on side pocket opening. Grasp cloth firmly above this slit, pull cloth into side pocket opening and tack to undercut of slate frame. Complete tacking of cloth to side pocket opening, making sure that cloth is tacked to undercut of slate frame.

10. Stretching cloth tightly across the table from (9) repeat the above operation at (10). Be sure to tack cloth to undercut of slate frame.

D.



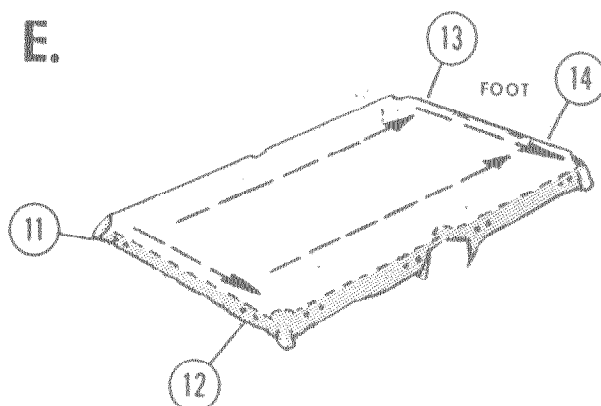
11. At head end of table, tack cloth at (11) maintaining uniform overhang.

12. Pull cloth from (11) toward (12) and tack securely keeping cloth even along head end.

13. Stretch cloth firmly from (11) to Foot End of table and tack at (13).

14. Stretch cloth tightly from (12) and (13) toward (14) and tack securely.

E.



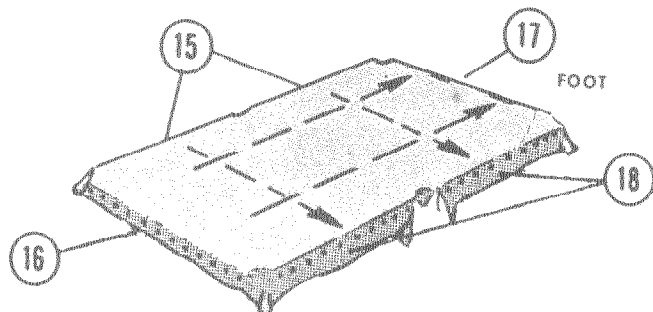
15. Tack all of left side on 3" centers keeping cloth even along wood slate frame.

16. Tack balance of head end on 3" centers also keeping cloth even along wood slate frame.

17. Stretch cloth tightly toward Foot End of table, tacking on 3" centers all the way across.

18. Stretch cloth tightly across table to Right Side, tacking on 3" centers all the way across.

F.

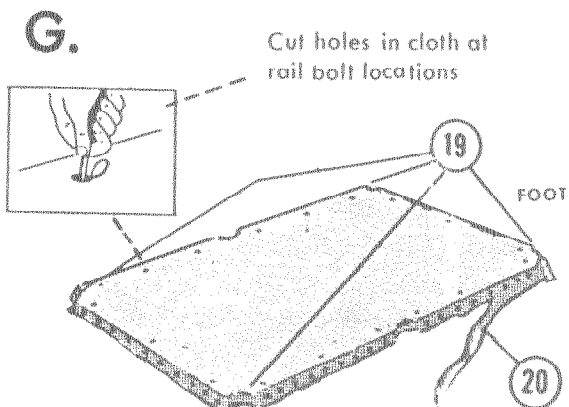


19. Stretch cloth into corner pocket openings and tack to undercut of slate frame.

20. Trim off excess cloth with a sharp knife.

NOTE: When installing cloth on carom tables, eliminate operations No. 5, 6, 7, 8, 9, 10, and 19. Otherwise follow same procedure as outlined above. Occasionally cloth will stretch, leaving wrinkles at the pockets. To re-tighten, remove only one end rail and one side rail. Pull cloth taut, and re-tack along the open end and side to restore original tightness.

G.



INSTALLATION RAILS AND APRONS

13. Position the side aprons, end aprons and ball storage rack on rails as shown in Figure 1.
 14. Loosely attach the aprons to rails with hex head machine screws, 5/16 - 18 x 2" and flat washers. (Figure 2)
 15. Holding corners firmly together, attach angle brackets as shown in Figure 2 with (4) round head cross recessed tap screws #10 x 3/4" (Disregard center mounting holes in bracket.)
 16. Attach ball storage rack securely to foot end rail two places with hex head cap screws 5/16 - 18 - x 2" and washers. (Figure 1)
 17. Attach the foot end aprons to ball storage Rack (Figure 1) with round head machine screws, #10 - 24 x 1 1/2", flat washers and hex nuts 10 - 24 (2 ea.)
 18. With this accomplished, go back and tighten all apron mounting hardware securely.
 19. If assembling a pocket table, the triangle rack may be installed at this time as shown in Figure 1.
- If table is to be equipped with gully return, Do Not attach triangle rack to bottom of ball storage rack.
20. Carefully turn rails and aprons assembly over. Place over table with head end elevated as shown in Figure 3.

Lower foot end of assembly onto table, then carefully lower head end into position.

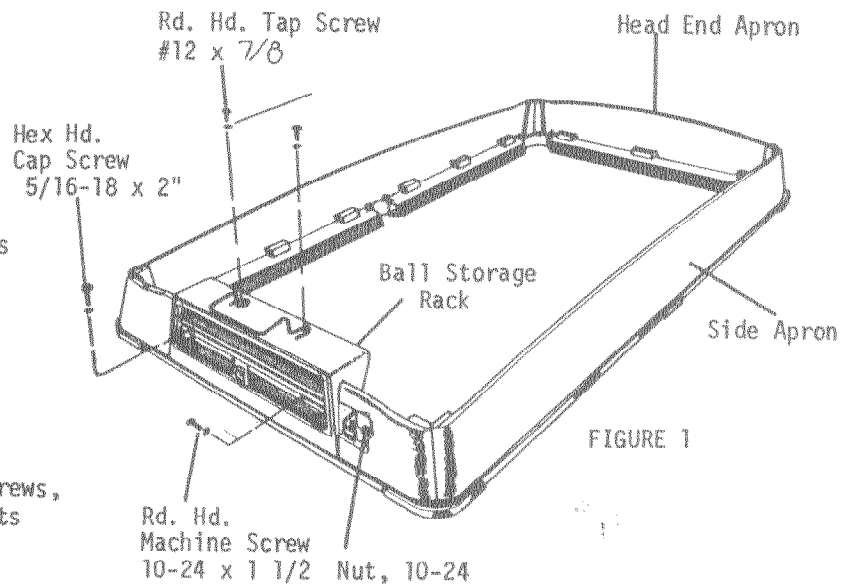


FIGURE 1

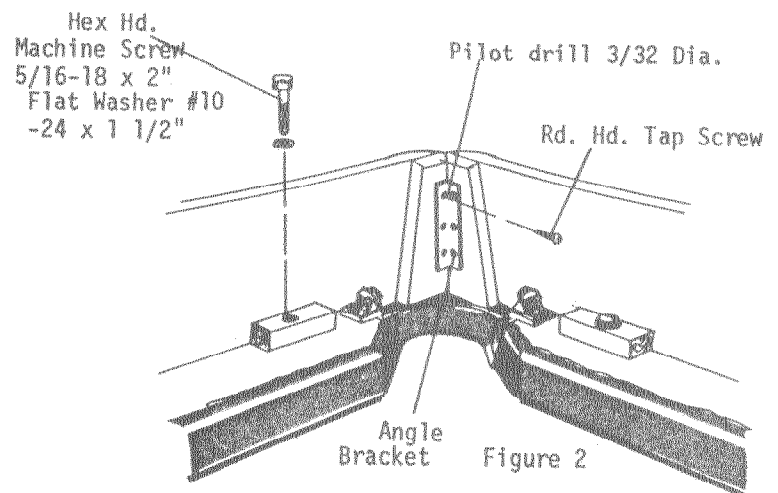


Figure 2

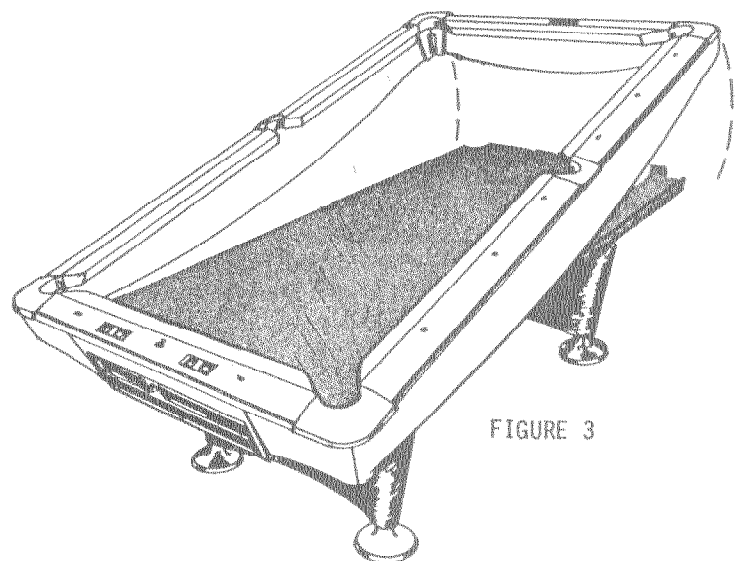


FIGURE 3

INSTALLATION

POCKETS, BRIDGE RACKS & BED SPOTS

21. Insert Hex Head cap screws - $3/8 - 16 \times 2 \frac{1}{4}$ ", and dome washer up through clearance holes in slate and thread into floating nuts in rails. (18 places) With rail and apron assembly properly aligned, tighten securely.

22. Install side and corner pockets. Place them in castings and carefully fit and trim ends to fit flush with cushion ends. Use a scribe or nail set as a drift pin to help locate casting hole.

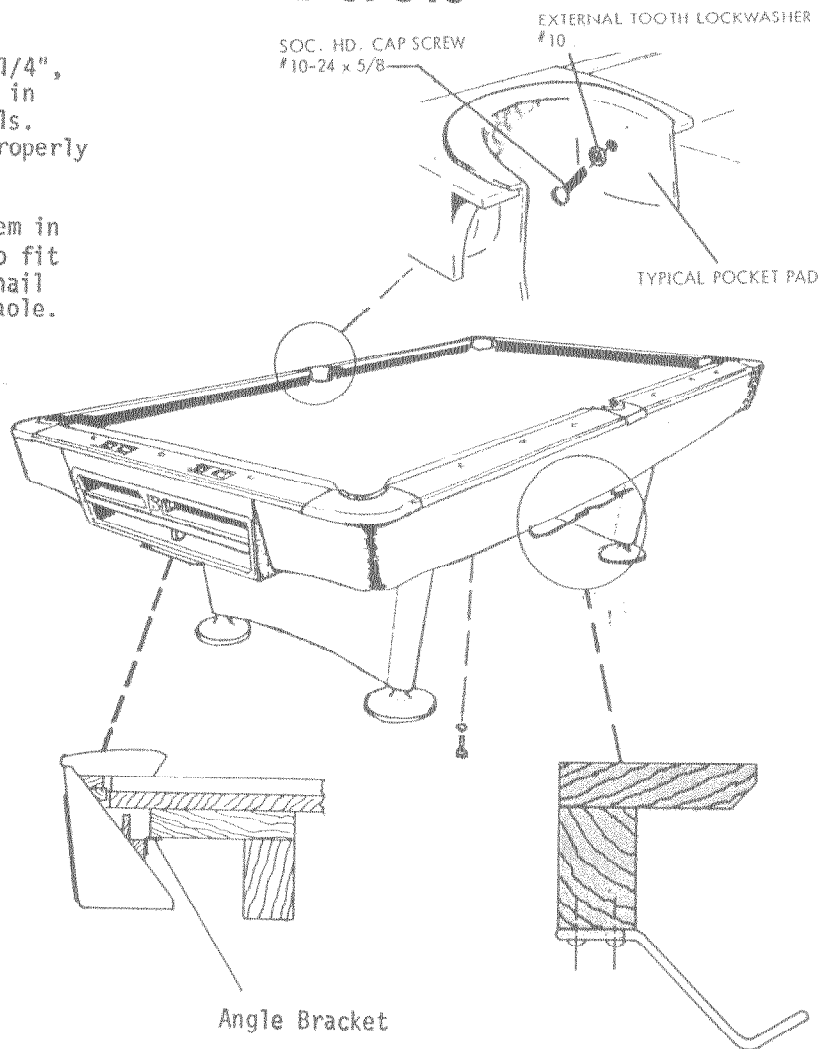
Hardware used per pocket:

- (2) lockwashers, external tooth #10
- (2) Rd. Hd. Machine screws #10 - $24 \times 5/8$ "

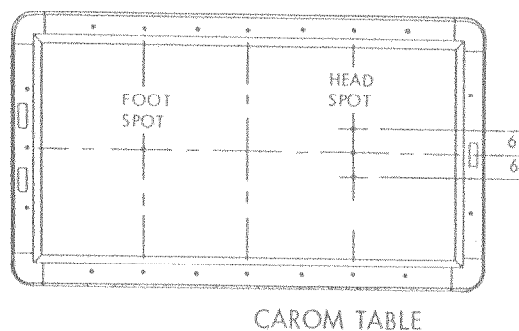
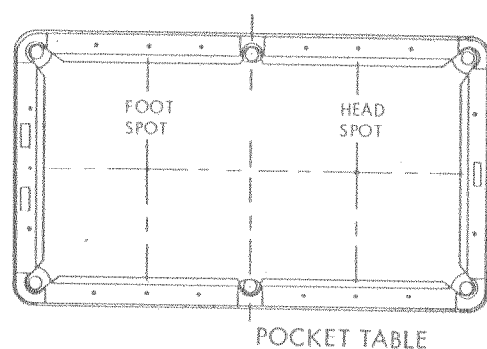
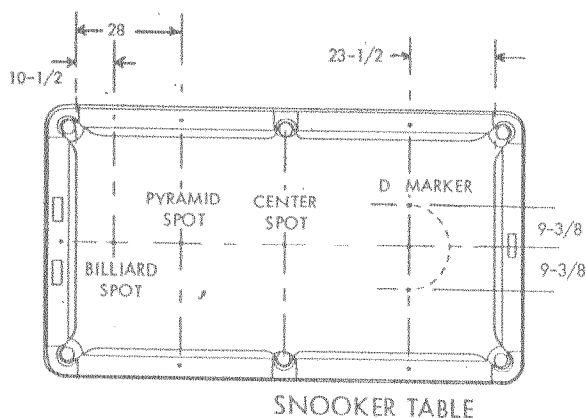
23. Attach angle bracket (two) to ball storage rack and base frame pad using round head cross recessed tap screws, #10 x $3/4$ (4)

24. Attach Bridge rack to base frame at each side of table using round head cross recessed tap screws, #12 x $1 \frac{1}{4}$ ". Pilot holes are pre-drilled for proper location.

25. Locate and install bed spots for each style of table as shown.

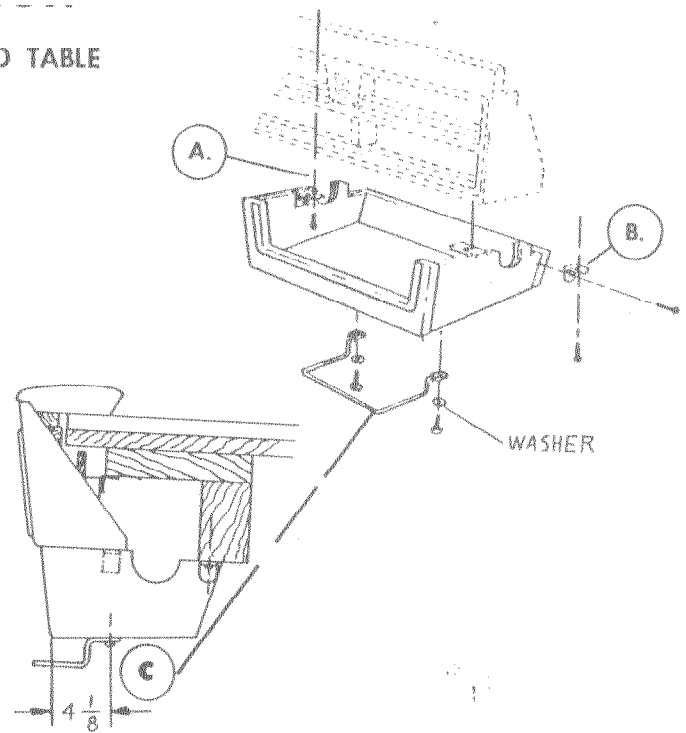


LOCATING BED SPOTS



GULLY RETURN BILLIARD TABLE

1. Attach the ball receiver box to the ball rack as shown in illustration point "A" using:
(4) rd. hd. mach. screws #10 - 24 x 1 1/4"
(4) flat washers
(4) keps nuts #10 - 24
2. Attach brackets at the back of the ball receiver box, see illustration point "B"
(2) rd. Hd. wood screws #10 x 5/8"
3. Attach brackets (Point B) to bottom of base frame with (2) rd. hd. wood screws #10 x 5/8.
4. Attach the triangle rack to the bottom of the receiver box. Center and install to dimension, point "C" using: (2) flat washers &
(2) rd. hd. wood screws #12 x 7/8"



Install wire gullys as shown using round head cross recessed self tapping screws, #8 x 7/8"

- A. Place the foot end gully sections through the opening in the ball receiver box and attach to dimensions shown.
- B. Attach head end gully sections to dimensions shown.

