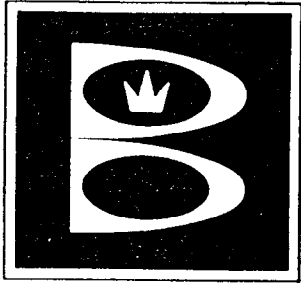


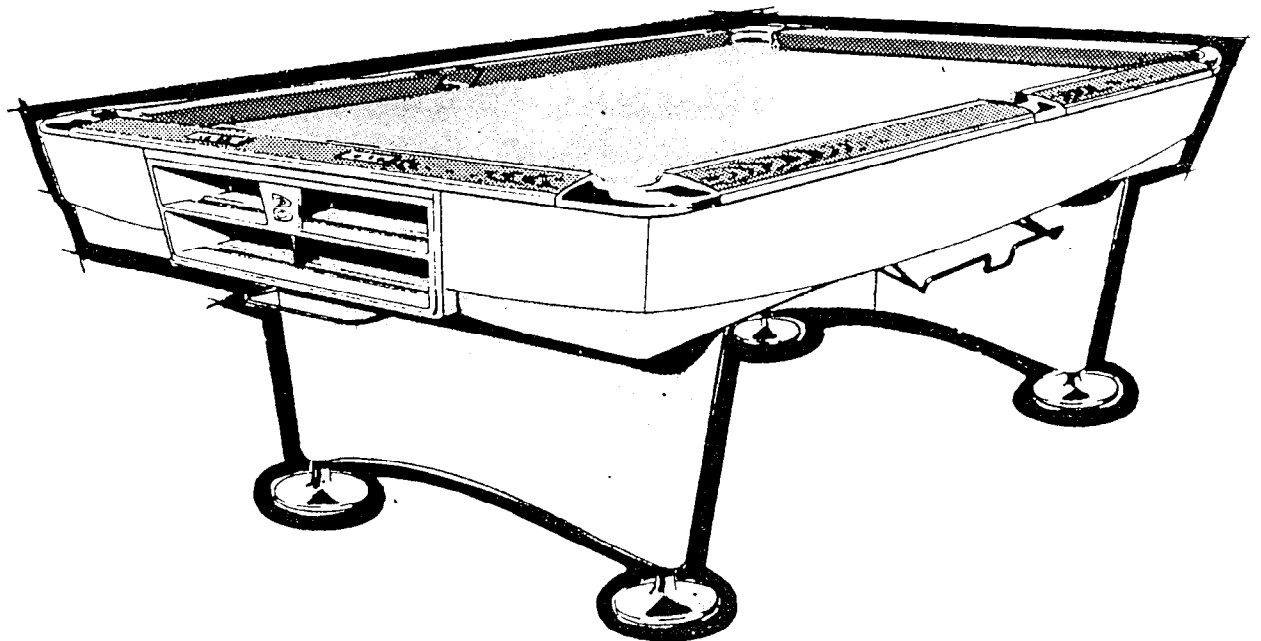
SERVICE MANUAL



Brunswick
CORPORATION

GOLD CROWN

BILLIARD
TABLE



DECEMBER 1961

**BOWLING SERVICE DEPARTMENT
MUSKEGON, MICHIGAN**

201718-1

TOOLS REQUIRED

PACKAGING — Hammer, Bar and Carton Cutter

TABLE ASSEMBLY: FEET — Medium screw driver (straight blade)

LEG, STRETCHER and BASE FRAME — Ratchet socket (with extension)

SLATE — Brace, straight blade bit and electrical drill

RAILS and CASTINGS — Ratchet socket (with extension)
carpenters square, chalk line or straight edge

BALL STORAGE RACK and FOOT APRONS — Medium screw driver — (straight blade)

APRONS — $\frac{3}{8}$ ratcheting wrench (craftman no. R-4343)
Sears, Roebuck and Co.

POCKETS — Nail set or drift pin and screw driver (straight blade)

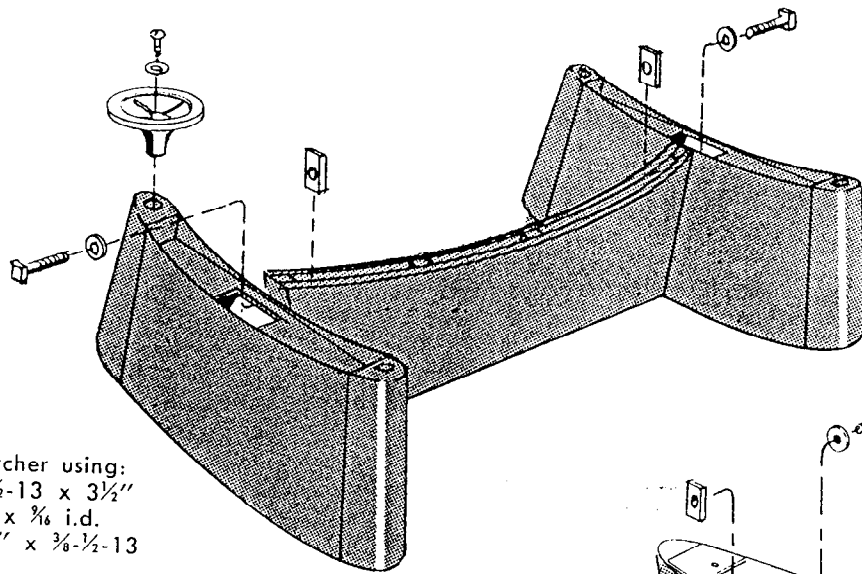
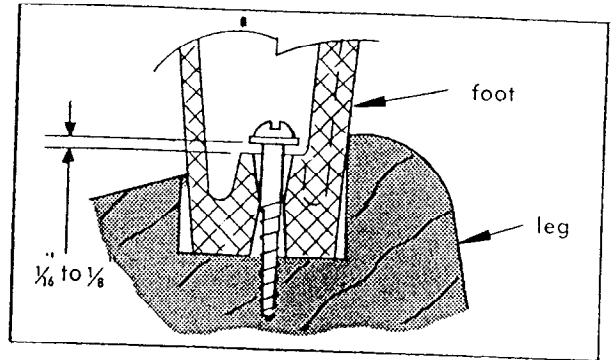
TRIANGLE, BRIDGE RACKS and APRON ANCHOR STRAPS
— Screw driver (straight blade)

BALL RETURN TABLE — Screw driver (straight blade)
gullies — yankee drill and screw driver (straight blade)

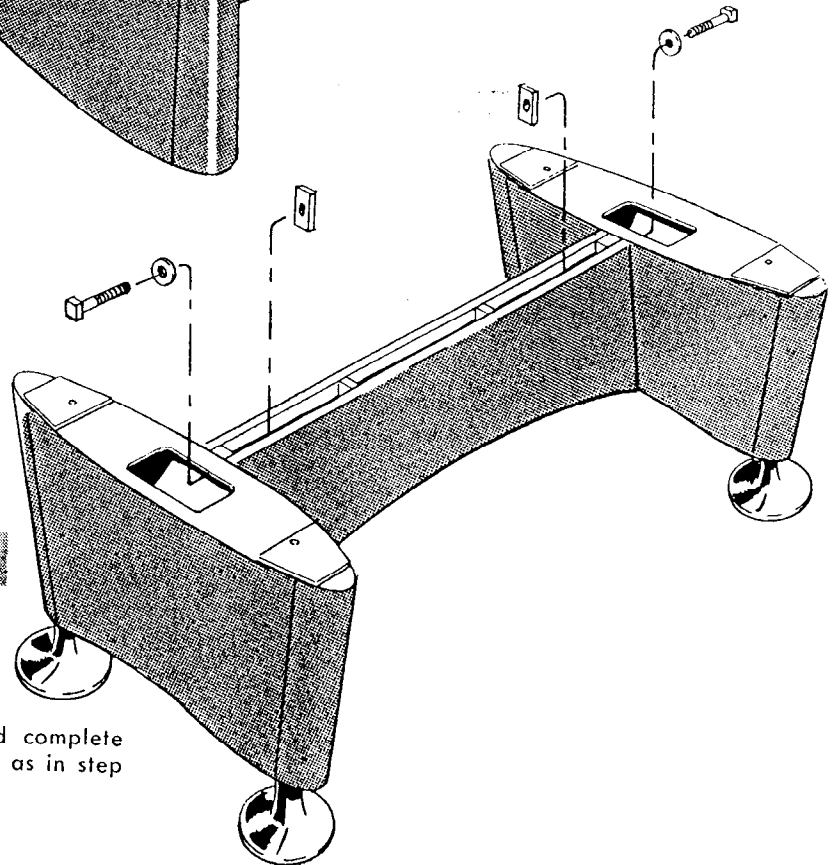
LEG AND STRETCHER ASSEMBLY

Place the two legs and the stretcher upside down on the floor as shown.

1. Attach the (4) feet to the legs with the hardware in the foot package.
(4) r.d. hd. slotted wood screws #12 x 2"
(4) flat washers $\frac{3}{8}$ o.d. x $\frac{1}{32}$ i.d.



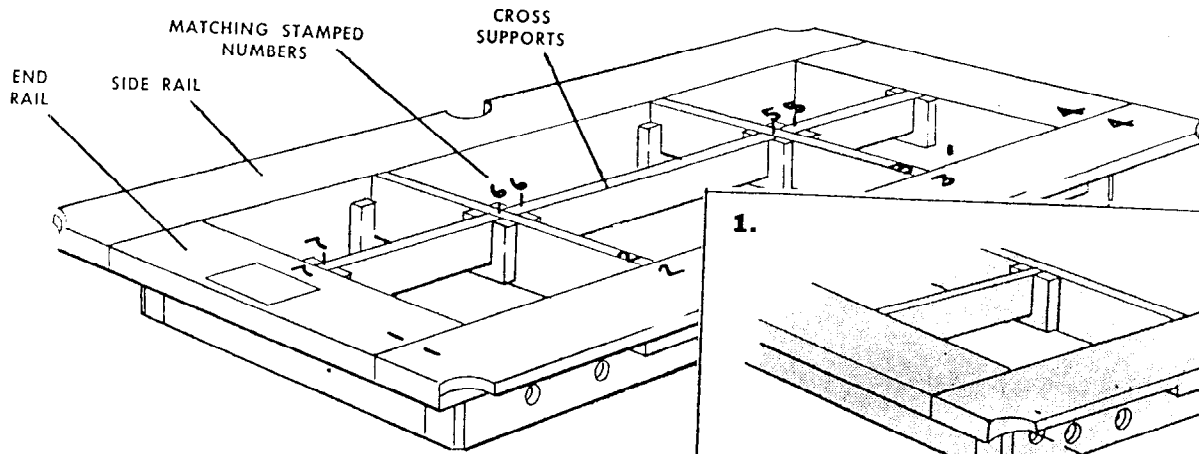
2. Attach the legs to the stretcher using:
(2) sq. hd. mach. bolts $\frac{1}{2}$ -13 x $3\frac{1}{2}$ "
(2) flat washers $1\frac{3}{8}$ o.d. x $\frac{1}{8}$ i.d.
(2) special nuts 1" x $1\frac{1}{4}$ " x $\frac{3}{8}$ - $\frac{1}{2}$ -13



3. Turn legs and stretcher right side up and complete assembly by using the same type hardware as in step (2).

INSTALLATION

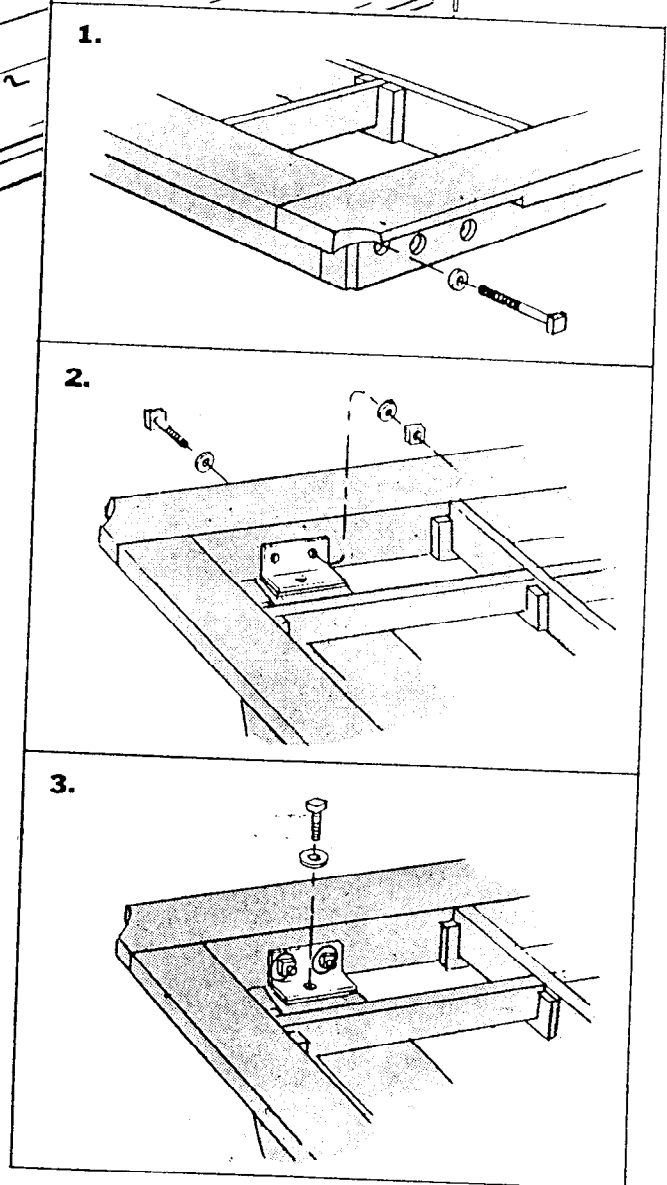
BASE FRAME ASSEMBLY



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 assembly as follows:

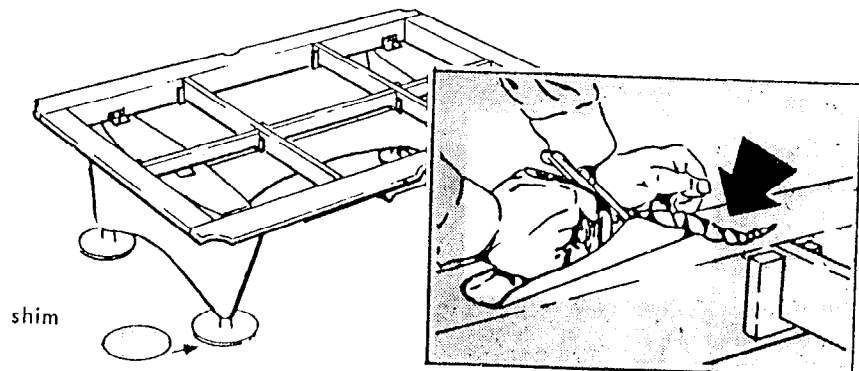
1. Attach the side rail members to the end rail members which contain blind nuts. Use one bolt at each corner.
 - (4) square hd. machine bolts $\frac{1}{2}$ -13 x 7"
 - (4) flat washers $1\frac{1}{8}$ o.d. x $\frac{5}{16}$ i.d.
2. Secure one leg attaching bracket at each corner of the side rail members, using:
 - (8) square hd. mach. bolts $\frac{1}{2}$ -13 x $3\frac{1}{4}$ "
 - (16) flat washers $1\frac{1}{8}$ o.d. x $\frac{5}{16}$ i.d.
 - (8) square nuts $\frac{1}{2}$ -13
3. Secure the four leg attaching brackets to blind nuts in legs using:
 - (4) square 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. Round veneer shims are supplied.

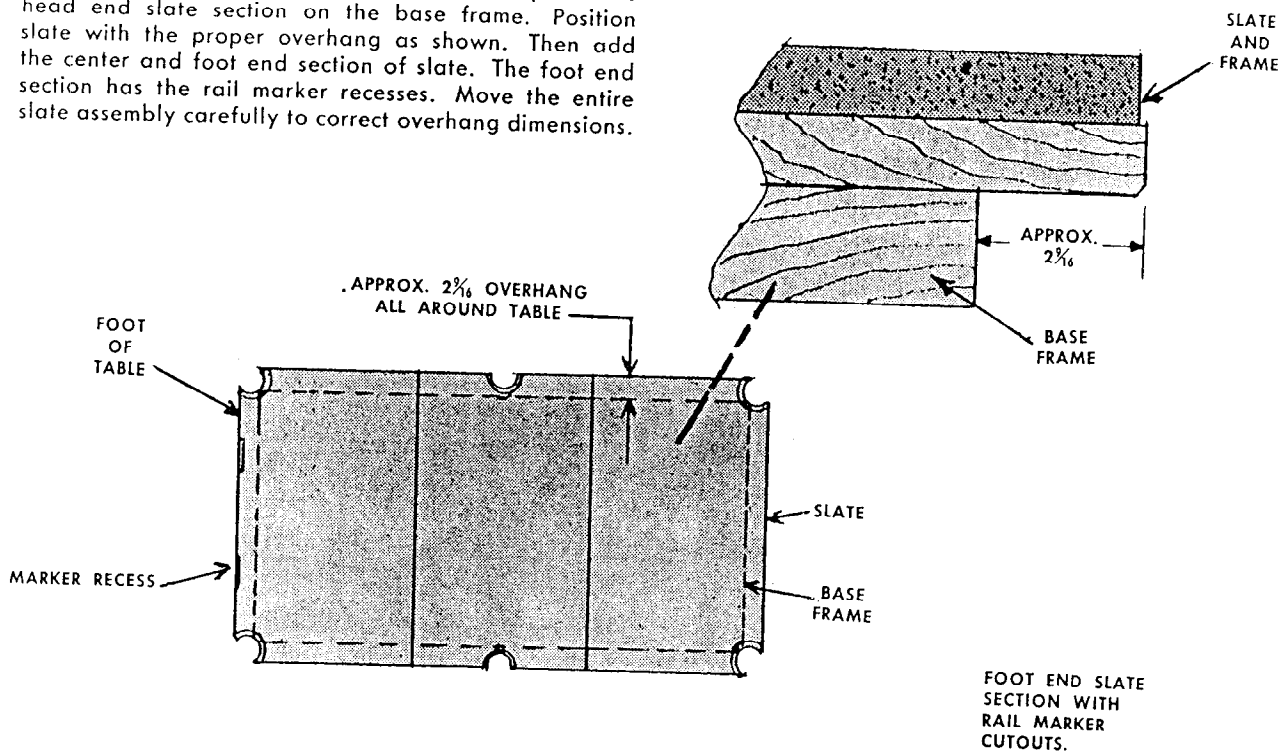


INSTALLATION

SLATE ASSEMBLY

1. 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.



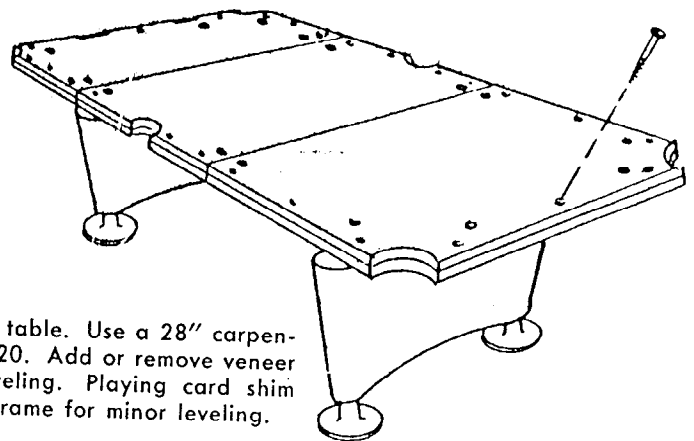
2. ATTACHING SLATE

Drill $\frac{3}{8}$ " pilot holes for wood screws. Make sure the pilot hole angle matches countersunk hole in slate. Insert (2) #16 x $3\frac{1}{2}$ " 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.

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. Add or remove veneer shims under table feet where necessary for major leveling. Playing card shim stock can be used under slate joints between slate and frame for minor leveling.

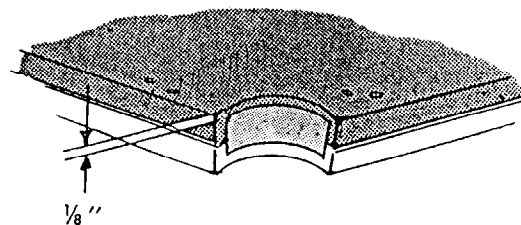
With the table completely level, fill all slate cracks, chips and screw holes with the fast setting plaster of paris material furnished with each shipment. When dry, sand smooth and thoroughly clean slate with bench or dust cloth.



3. CLOTH REINFORCEMENT PIECES

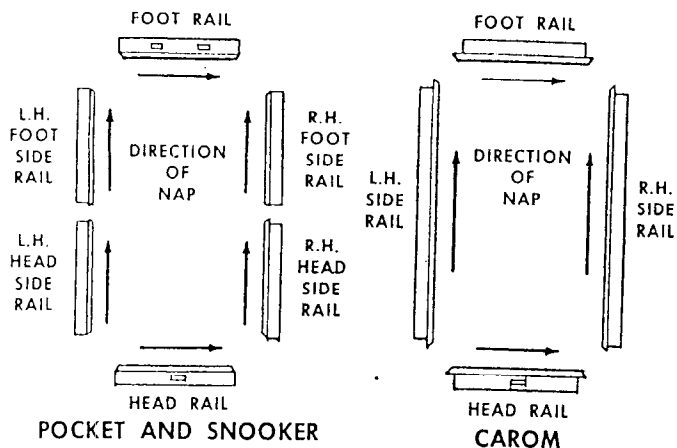
The slate cloth reinforcement pieces are packaged with the rails.

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.



INSTALLATION

RAIL ASSEMBLY



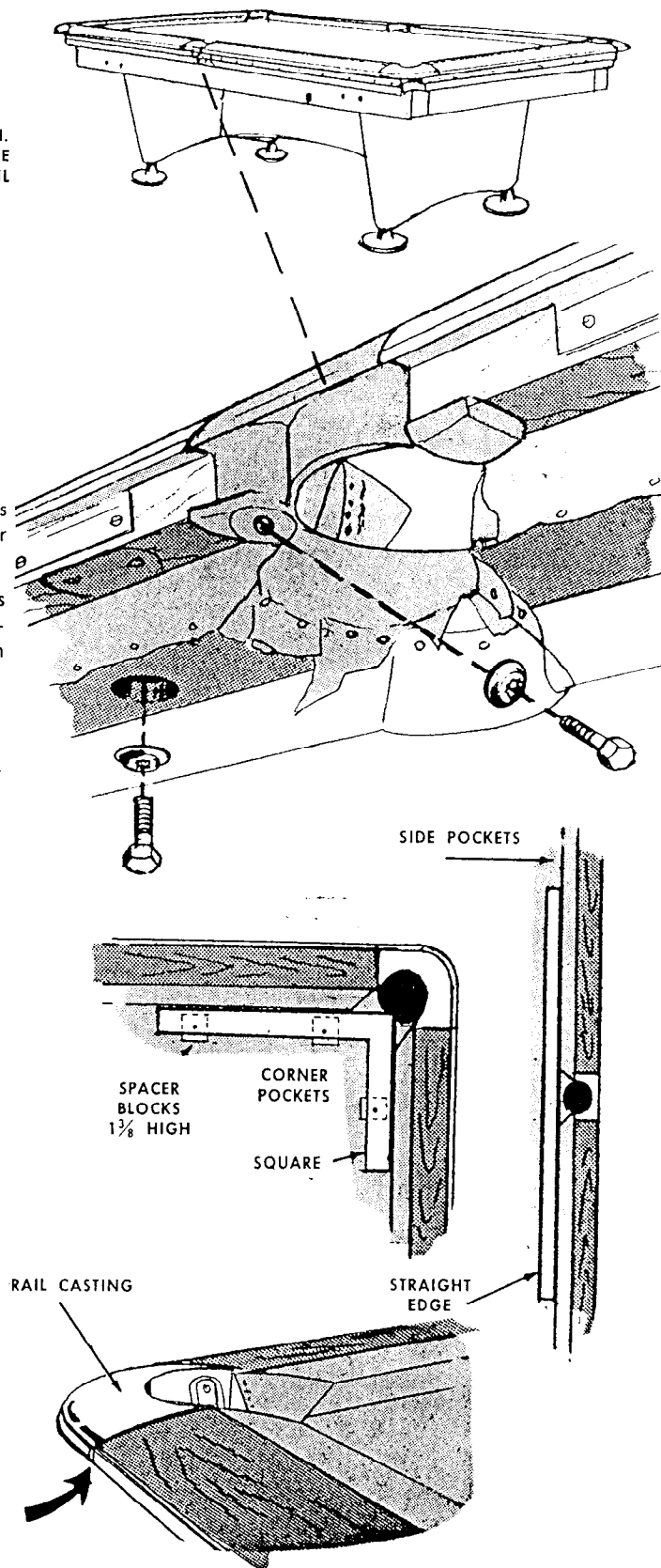
RAIL IDENTIFICATION

1. Place rails on the table in their respective places as shown in drawing above. Each rail is stamped for identification.
2. Insert bolts and dome washers up through slate holes and thread into flush nuts in rails. Leave this hardware fairly loose until final adjustments have been made. Rail attaching hardware:
 - (18) Machine bolts, slotted hex hd. $\frac{3}{8}$ "#16 x 2"
 - (18) Washers dome shakeproof
3. Place castings in rail openings and attach to rails. Leave hardware loose for final adjustment.
 - (12) Machine bolts, hex hd. $\frac{3}{8}$ "#16 x 1 $\frac{1}{4}$ "
 - (12) Washers dome shakeproof

4. Line up corner rails and castings with a carpenter's square. Position spacer blocks under the square to raise it to cushion height. Use smooth blocks to prevent damage to cloth. Blocks may be fastened to square with screws if desired.

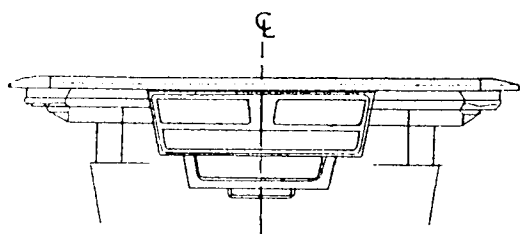
Line up side rails and castings with a straight edge or line on the cushion or feather strip line. Tighten securely in place.

5. In all cases make sure the castings are flush or $\frac{1}{32}$ " beyond apron extrusions. Apron extrusions are not to protrude beyond edge of castings to prevent damage to clothing.



INSTALLATION

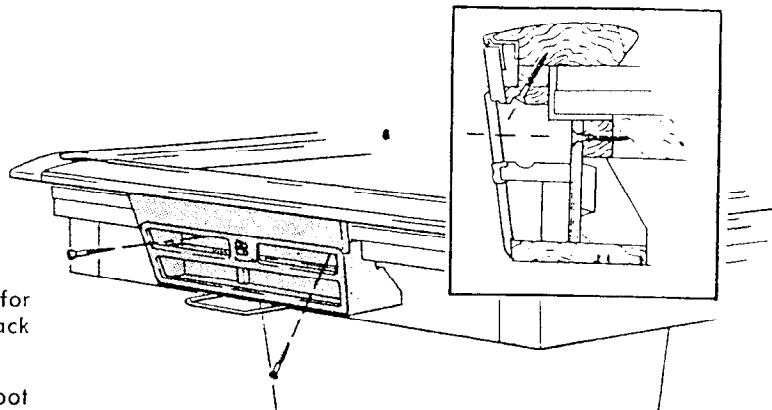
BALL STORAGE RACK AND APRONS



BALL STORAGE RACK

NOTE: For gully return tables refer to page (16) for gully installation before proceeding with ball storage rack or aprons.

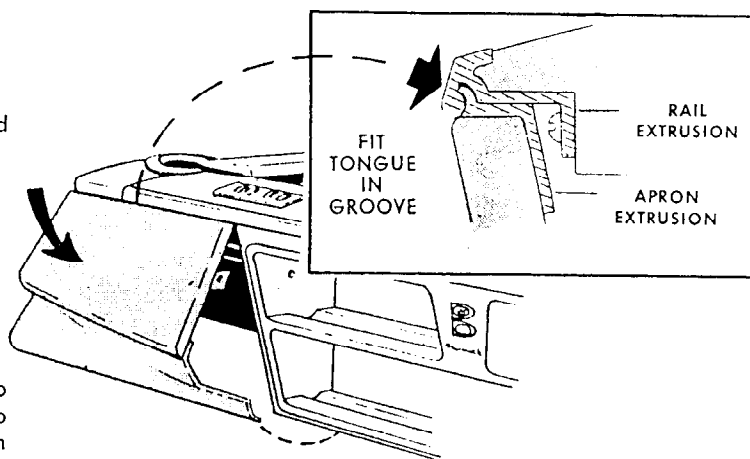
1. Center and attach the ball storage rack to the foot end rail and base frame as shown using:
(6) flat hd. wood screws #10 x 2 $\frac{3}{4}$ "



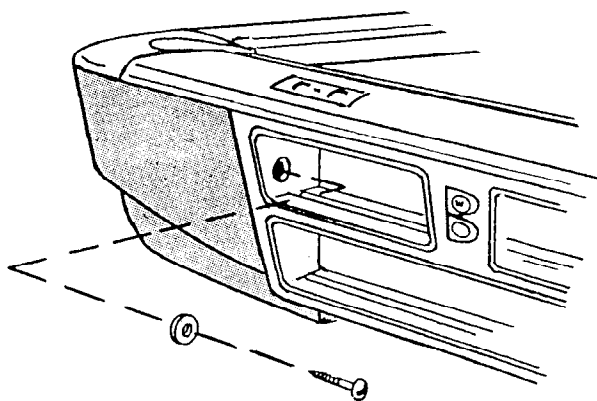
APRONS

NOTE: Aprons for each table are to be kept in matched sets, as received.

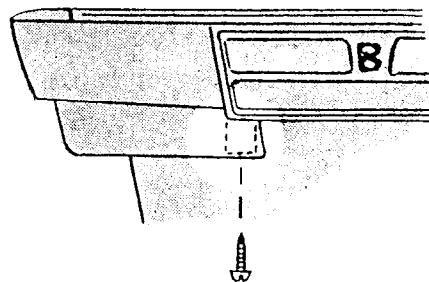
2. Position the left hand foot end apron at an angle to the rail and fit the tongue on the apron extrusion into the groove on the rail extrusion. Hold the top of apron in place and swing the apron down in place. Repeat for the right hand end apron.



3. Attach the end aprons to the ball storage rack using:
(2) round hd. mach. screws #10-24 x 1 $\frac{1}{2}$ "
(2) flat washers $\frac{1}{2}$ " o.d. x $\frac{1}{2}$ i.d.

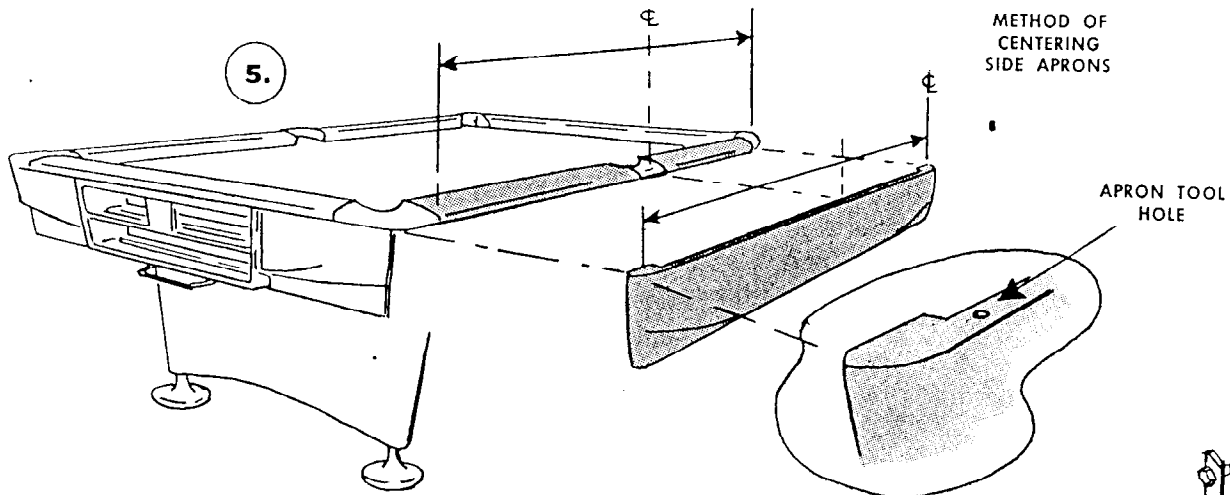


4. Place support blocks on the inside plastic lip of the end of both aprons and attach blocks to bottom of ball storage rack using:
(2) round hd. wood screws #8 x 1 $\frac{3}{4}$ "



INSTALLATION

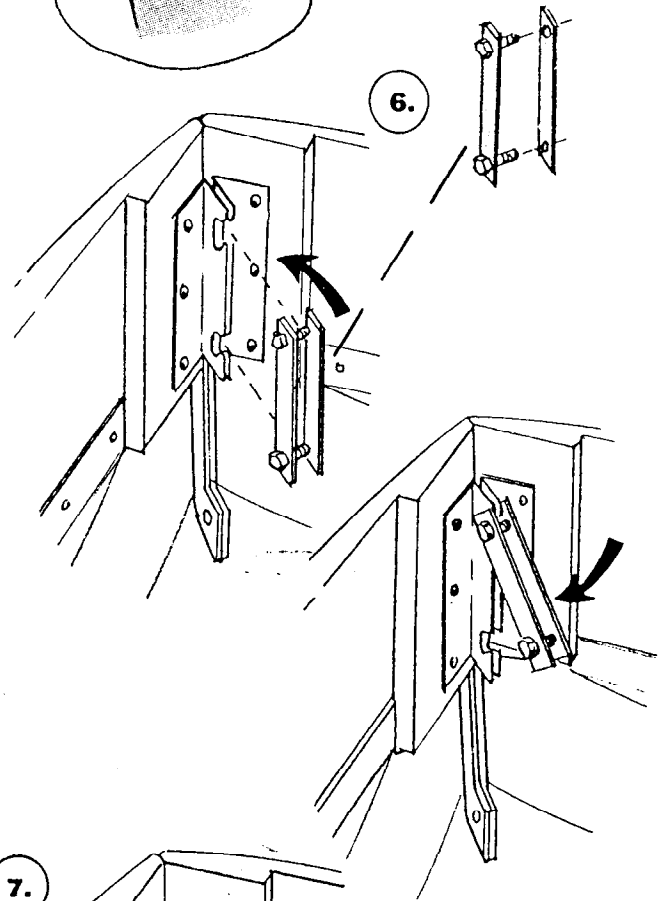
APRONS



5. To install the side apron, find and mark the center of side rail between the end castings and the center between the tool holes at each end of apron. Match center lines, insert apron tongue and swing down. Hold in place by attaching and securing one anchor strap, as shown on page (14).

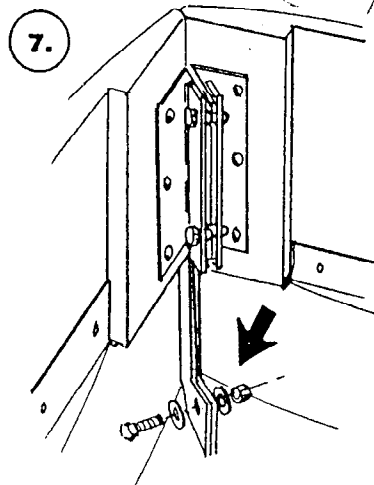
6. Secure the side apron to the foot apron at the corner brackets using:
- (2) hex hd. mach. screws $\frac{1}{4}$ -20 x $\frac{5}{8}$
 - (1) washer plate
 - (1) nut plate

Insert the (2) hex head machine screws through the washer plate and just start the threads into the nut plate. Hold the apron corners together and slip the top machine screw into apron bracket notches, keeping the washer plate and nut plate on the outside of the apron brackets. Then swing the assembly down to engage the lower bracket notches. Tighten the assembly in place, finger tight, and then finish tightening with the $\frac{3}{8}$ ratcheting open end wrench. See tool list.



7. Join the bottom plastic apron strips using:
- (1) hex head mach. screw $\frac{1}{4}$ -20 x $\frac{3}{8}$ "
 - (2) flat washer $\frac{1}{4}$ "
 - (2) hex nut $\frac{1}{4}$ -20

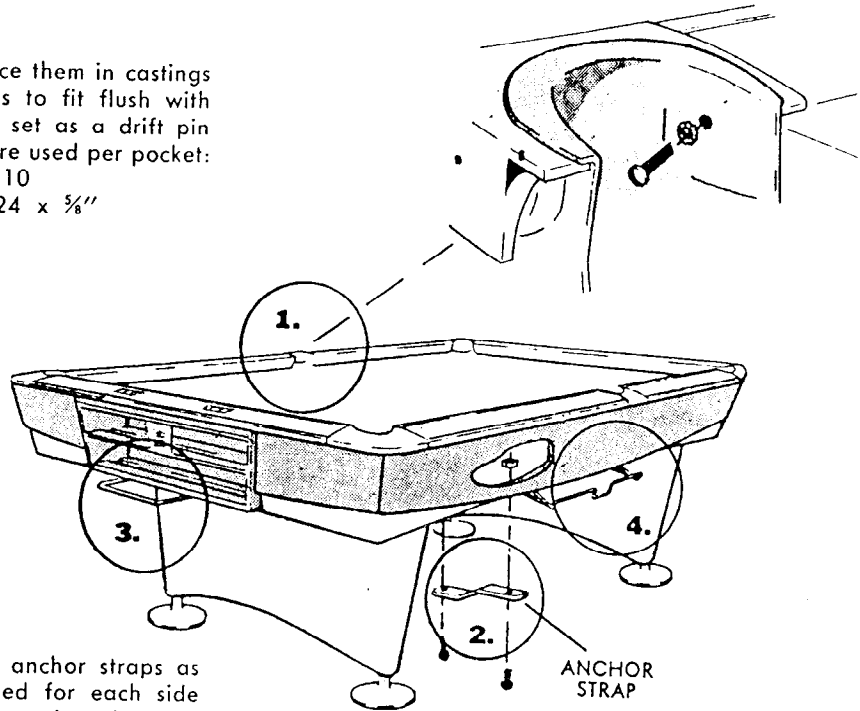
8. Center and install the remaining side apron and the head apron, using the hardware shown above, at each corner.



INSTALLATION

POCKETS AND ANCHOR STRAPS

1. Install side and corner pockets. Place them in castings and carefully fit and trim the 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 x $\frac{5}{8}$ "



2. Attach aprons to base frame, using anchor straps as shown. Three anchor straps are used for each side apron, one for the head apron, and one is to be used on the foot apron of carom or snooker tables. Hardware used:

Apron:

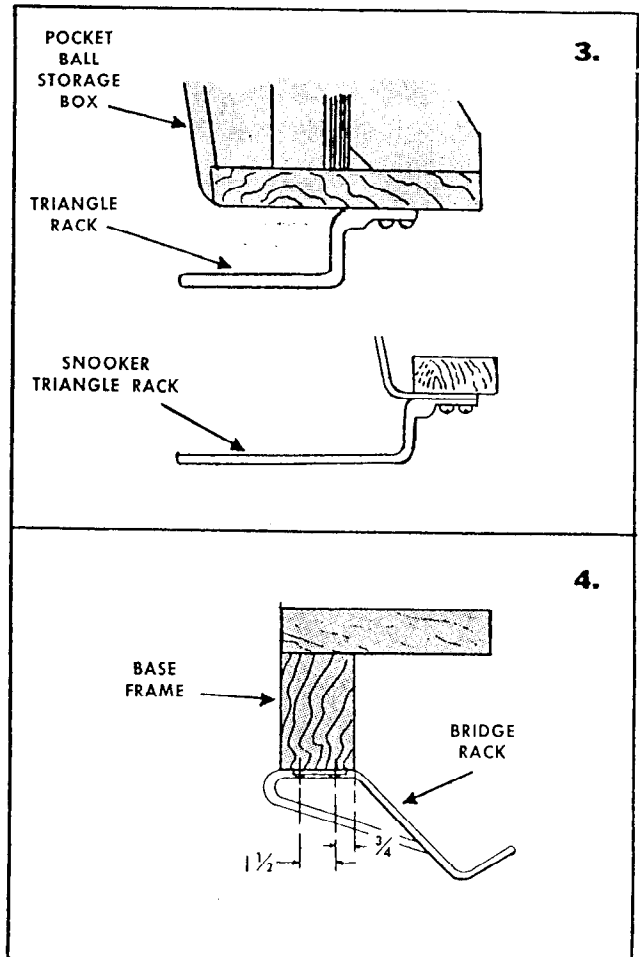
Machine screw rd. hd. #10-24 x $\frac{1}{2}$ "
 keps nut #10-24

Base frame:

Round head wood screw #10 x $\frac{3}{4}$ "

3. Attach the triangle rack to the bottom of the ball storage rack. Holes are predrilled. Hardware used:
 (4) round hd. wood screws #10 x $\frac{3}{4}$ "

Snooker table triangle racks are attached with the same hardware, with (2) support blocks placed on the inside lip of the plastic apron.



4. Attach bridge racks at the center of each side base frame, as per dimensions shown. Hardware used:
 (4) per rack, rd. hd. wood screws #12 x $1\frac{1}{4}$ "