

# BRUNSWICK

*Since 1845*

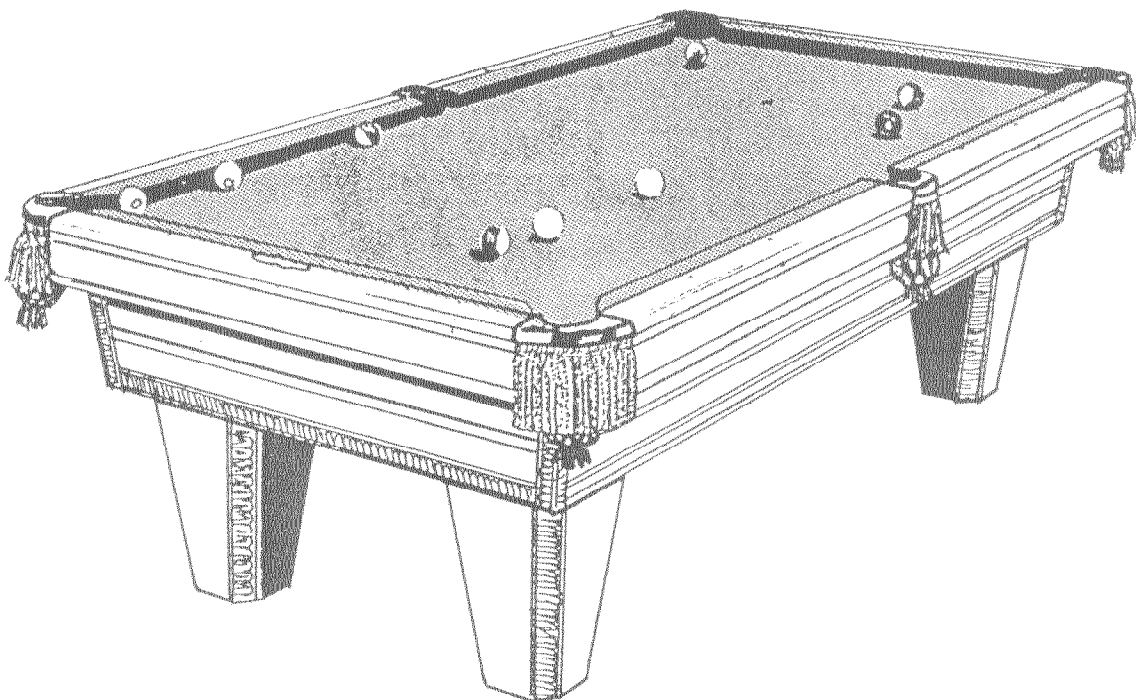
## INSTALLATION MANUAL

Please follow step-by-step instructions

### HERITAGE

### billiard table

MODEL DG-1



SERVICE DEPARTMENT  
MARION VIRGINIA

AUGUST 1976

51-902384-002

printed in U.S.A.

## ASSEMBLY INSTRUCTIONS

The following instructions describe the step-by-step assembly sequence for the Heritage Billiard Table including a 4' x 8' and 4-1/2' x 9' pocket or gully table.

When assembling a pocket table, disregard any reference to gully table assembly.

1. Remove the base frame assembly from carton. If billiard table is equipped with automatic gully return system, the ball receiver box can be installed at this time.
  - 1A. Position base frame assembly upside down as shown in Figure 1.
  - 1B. Position the ball receiver box at center of foot end base frame member and attach securely four places with round head phillips tap screws, #10 x 1" (Figure 2).
2. Position the base frame assembly over two stools or chairs as shown in Figure 3.
3. Remove the four legs from leg carton.
4. Position leg at corner of base frame as shown in Figure 4. Align the mounting holes in the leg with the threaded "tee" nuts pre-positioned in the base frame. Insert four (4) hex head cap screws, 3/8-16 x 1-3/4" (with a washer on each screw) through the mounting holes in leg and tighten finger tight.
5. Making sure that both sides of leg are against sides of base frame, tighten the four (4) screws securely. Proceed in same manner with other three legs.
6. When all four (4) legs are securely fastened to base frame, remove the stools or chairs and position table in its permanent location.

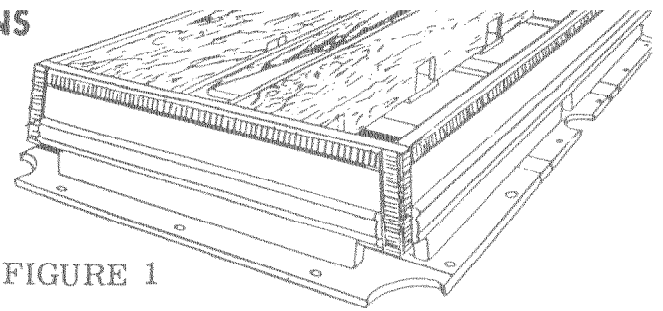


FIGURE 1

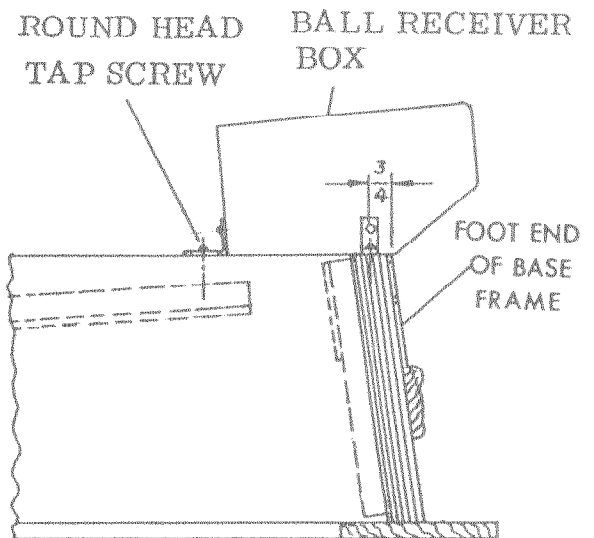


FIGURE 2

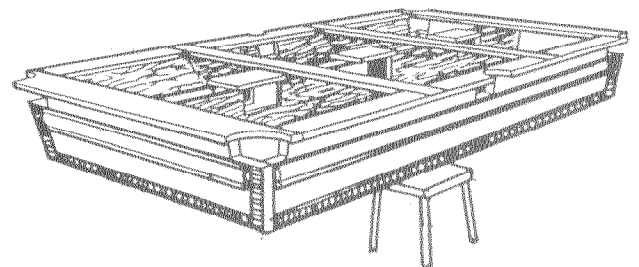


FIGURE 3

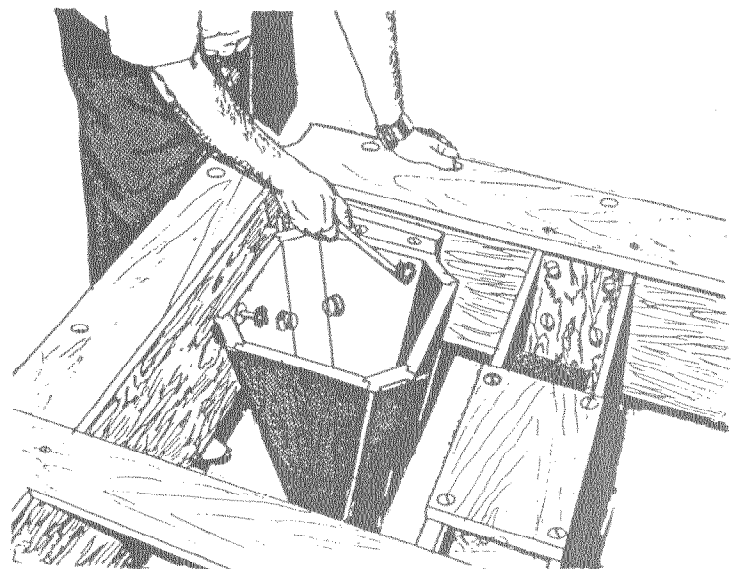


FIGURE 4

TABLE EQUIPPED WITH AUTO-  
MATIC GULLY RETURN SYSTEM.

1. Bond the three long cork pads to the inclined track inside the center support.
2. Bond the four cork pads (6" x 3-1/2") to each side of center support at locations shown.
3. Bond the two cork pads (8" x 1-3/4") at center cut-out at approximate location shown.
4. Bond the cork pad 4-1/4" x 5" to the end panel of center support as shown.

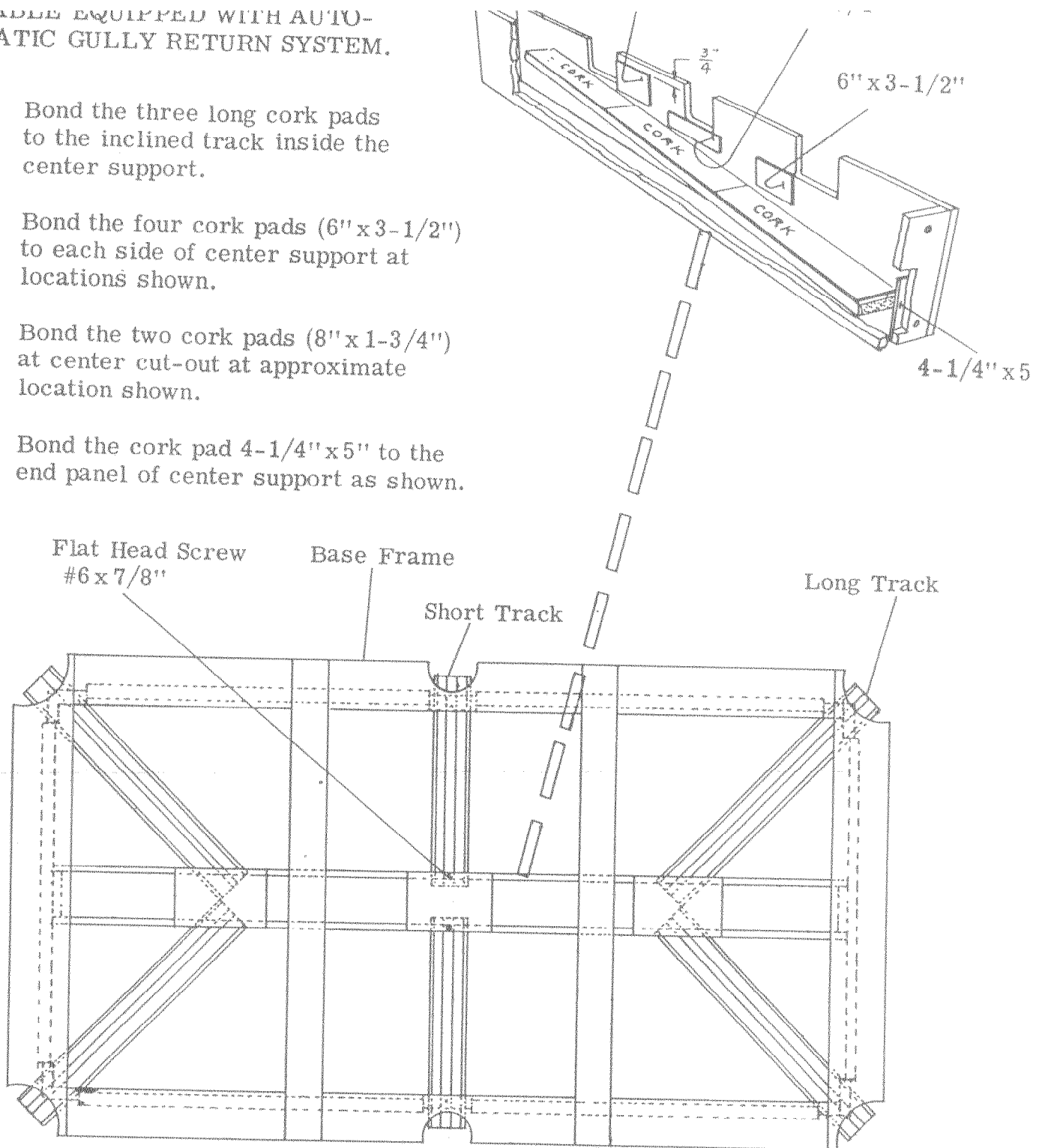


FIGURE 5

5. Position the two short gully tracks at center pocket cut-outs as shown in Figure 5. The pilot holes at one inch from edge of gully track to be at center support.
6. Attach gully tracks to base frame with flat head cross recessed tap screws, #6 x 7/8".
7. Position the four long gully tracks at corners of table with the pilot hole nearest to edge of gully track at center of table.
8. Fasten the corner gully tracks to base frame with flat head cross recessed tap screws, #6 x 7/8".

7. Place a carpenters level on top of base frame to determine the highest corner. Level the base frame by placing leveling shims under legs at the low corners. Be sure that all four (4) feet have positive bearing against the floor. The top of base frame must be absolutely level before installing slate.

8. Carefully open the slate crate and remove the three (3) slate sections. Place center slate section on base frame. Align the slate section with slate frame and proceed to add remaining two (2) sections.

9. Butt the slate joints together and check to see if all rail holes through slate sections align with holes in slate frame sufficient to allow rail bolts.

10. Using the twelve (12) C'sink holes in slate section as template, pilot drill 5/32 diameter holes through slate frame.

11. Insert four (4) flat head wood screws #16 x 3" into the two C'sink holes in end slate sections at each end of table. Tighten the four (4) screws securely to draw the slate joints together.

12. Then insert the remaining eight (8) screws, tightening them alternately right and left until all screws are securely fastened. When done in this manner, the slate joints will be tight.

CAUTION: Do not use a lubricant on these screws as it may stain the bed cloth.

13. Place a straight edge across the three (3) slate sections and check for flatness. Shim stock may be added between the end slate frame sections and base frame to obtain flatness. With the table completely level and the surfaces flat, slate cracks, chips, screw holes and slate joints may be filled with fast setting Plaster of Paris. Allow the plaster to dry, then sand smooth. Thoroughly clean the slate surface with brush and dust cloth. (Figure 6) Install the cloth reinforcement pieces as follows. Apply a coat of BruBaCol Adhesive on all slate pocket openings. Cement the reinforcement strips to the slate, as shown in Figure 7. Allow the cement to dry, then sand edges of pocket openings to eliminate sharp edges. (Figure 7) Break the edge around entire periphery of slate.

14. THE TABLE IS NOW READY TO BE COVERED WITH CLOTH

Lay the bed cloth over top of slate, nap side up, with nap of cloth running from head to foot end of 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. Leave balance of cloth overhang, at the foot and right side.

Do not spread tacks on bed cloth.  
Keep them in a small container.

FLAT HEAD WOOD SCREW

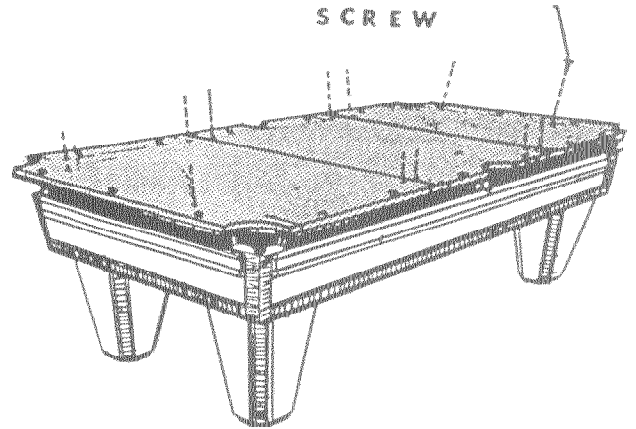


Fig. 6

CLOTH REINFORCEMENT PAD

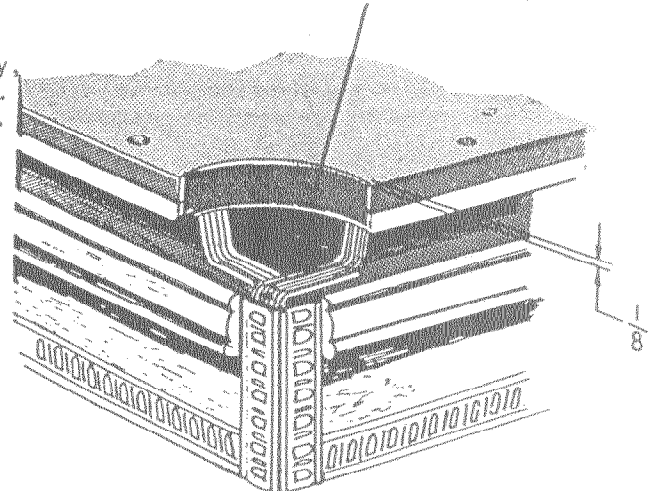


Fig. 7

15. After bed cloth is completely installed on table, cut holes in cloth at all rail screw locations.

16. Place all six (6) rails upside down on top of table in their respective locations. (The end rail with nameplate goes at head end of table). Figure 9.

17. Insert pocket irons into holes through end of rails (Figure 9).

18. Locate bag of hardware (from large hardware carton) containing assembly hardware for rails and pocket irons.

19. Remove twelve (12) flat head C'Sink machine screws 5/16 - 18 x 1-1/4" long, press pocket iron tight against rail as shown in Figure 8, and insert machine screw into hole near edge of rails. Tighten all screws securely.

20. When all pocket irons are securely fastened to rail assemblies, carefully turn complete rail and pocket assembly over, "**CAUTION**" DO NOT LET RAIL ASSEMBLY "BOW" OR "TWIST" WHEN TURNING RAIL ASSEMBLY OVER.

21. Align holes in bottom of rail with holes through slate frame. Adjust side rails until the cushion nose forms a straight line from head end corner pocket to foot end corner pocket. Fasten rails securely with hardware shown (Figure 10) maintaining a straight line as sighted along side rail cushion nose.

22. Attach pockets to underside of slate frame using 3/4" long flat head nails from hardware bag (Figure 11).

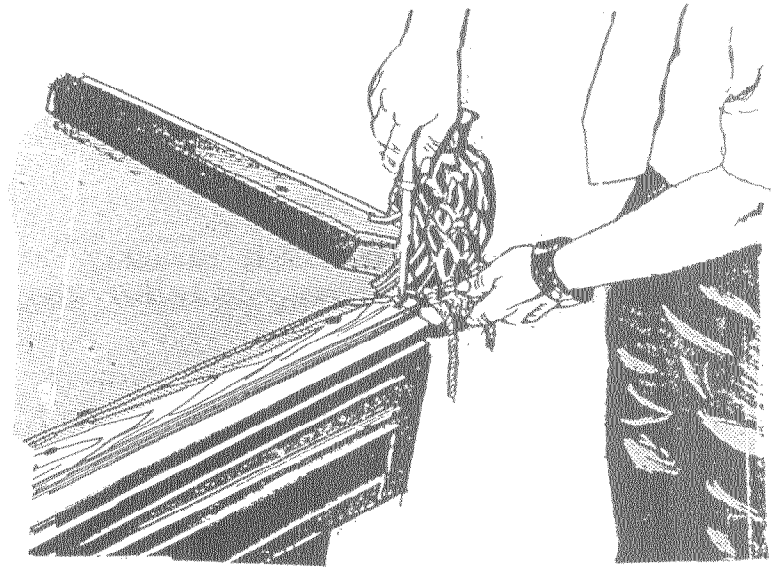


Fig. 8

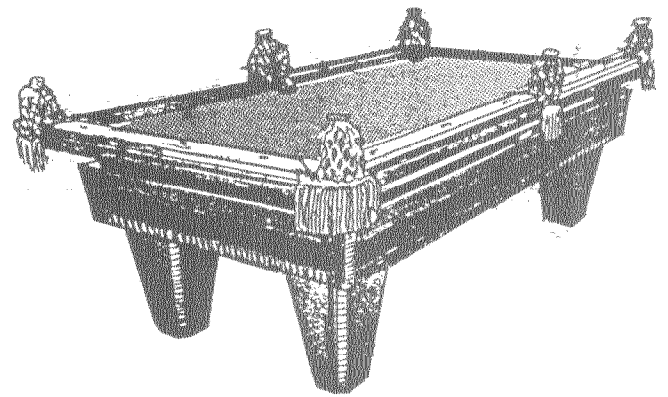


Fig. 9

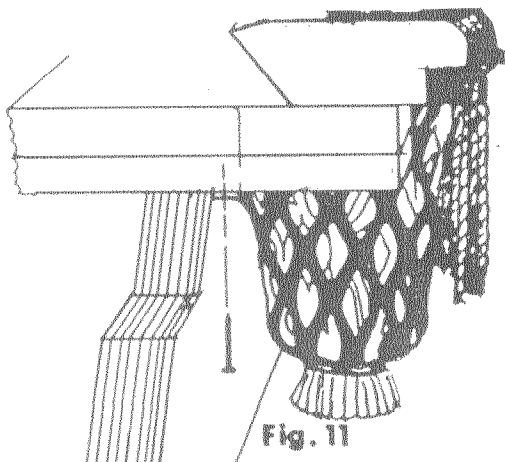


Fig. 11

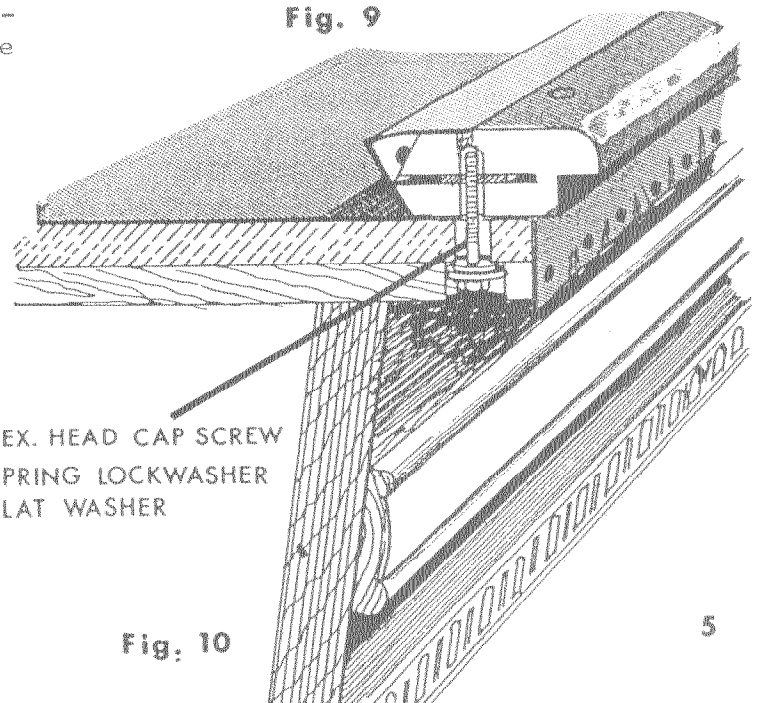


Fig. 10

23. Attach metal brackets (two (2) per apron) from hardware bag as shown (Figure 12). Pilot holes are pre-drilled in back side of apron.
24. Attach aprons to rails securely, using eighteen (18) apron screws, #8 x 1-14/16" long as shown in Figure 13.
25. Attach metal brackets to underside of slate frame securely using #8 x 3/8" round head self tap screws.

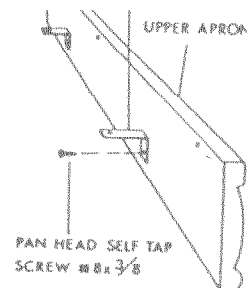


Fig. 12

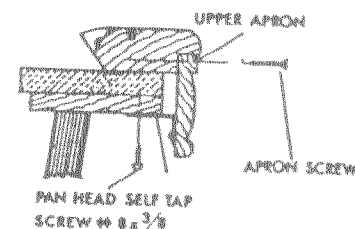


Fig. 13

THIS COMPLETES THE ASSEMBLY OF THE HERITAGE 8' & 9' BILLIARD TABLE

### SERVICE PARTS

HERITAGE BILLIARD TABLE, MODEL DG-1 8' & 9'

<u>ITEM NO.</u>	<u>PART NO.</u>	<u>PART DESCRIPTION</u>
1.	51-200904-010	Corner Gully Pocket Assembly - Complete
2.	51-200905-010	Side Gully Pocket Assembly - Complete
3.	51-200861-002	Corner Gully Track - 4' x 8' Table
	51-200861-004	Corner Gully Track - 4-1/2' x 9' Table
4.	51-200861-003	Gully Track - Side Pocket - 4' x 8'
	51-200861-005	Gully Track - Side Pocket - 4-1/2' x 9'
5.	11-086336-001	Flat Head Self Tap Screw, #6 x 7/8"
6.	51-200907-000	Ball Receiver Box
7.	11-042837-009	Round Head Self Tap Screw, #10 x 1"
8.	51-200908-002	Metal Bracket
9.	51-200908-003	Metal Bracket
10.	11-042834-003	Round Head Self Tap Screw, #10 x 5/8"
11.	51-200904-008	Plastic Gully Boot - Corner
12.	51-200905-008	Plastic Gully Boot - Side