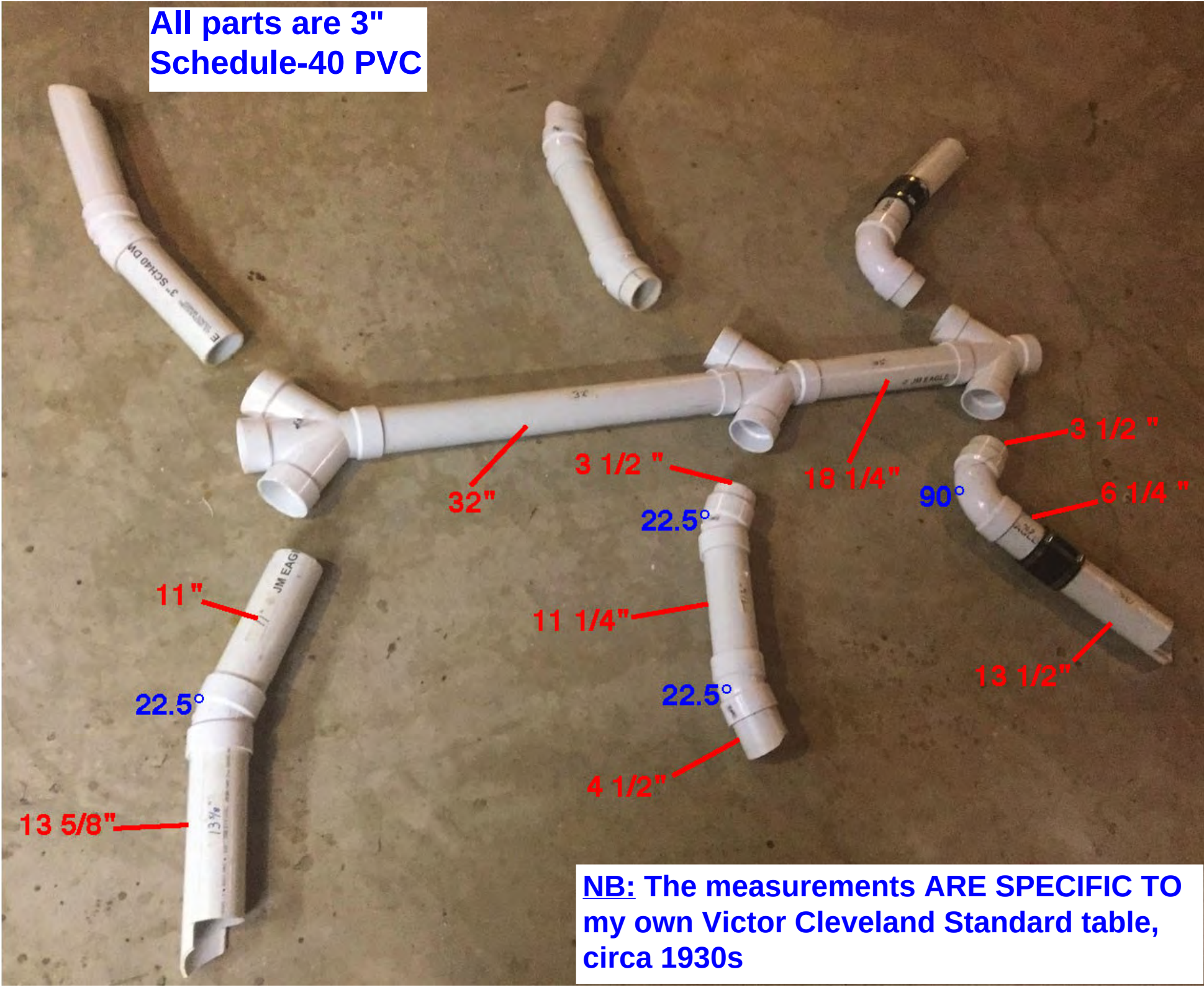
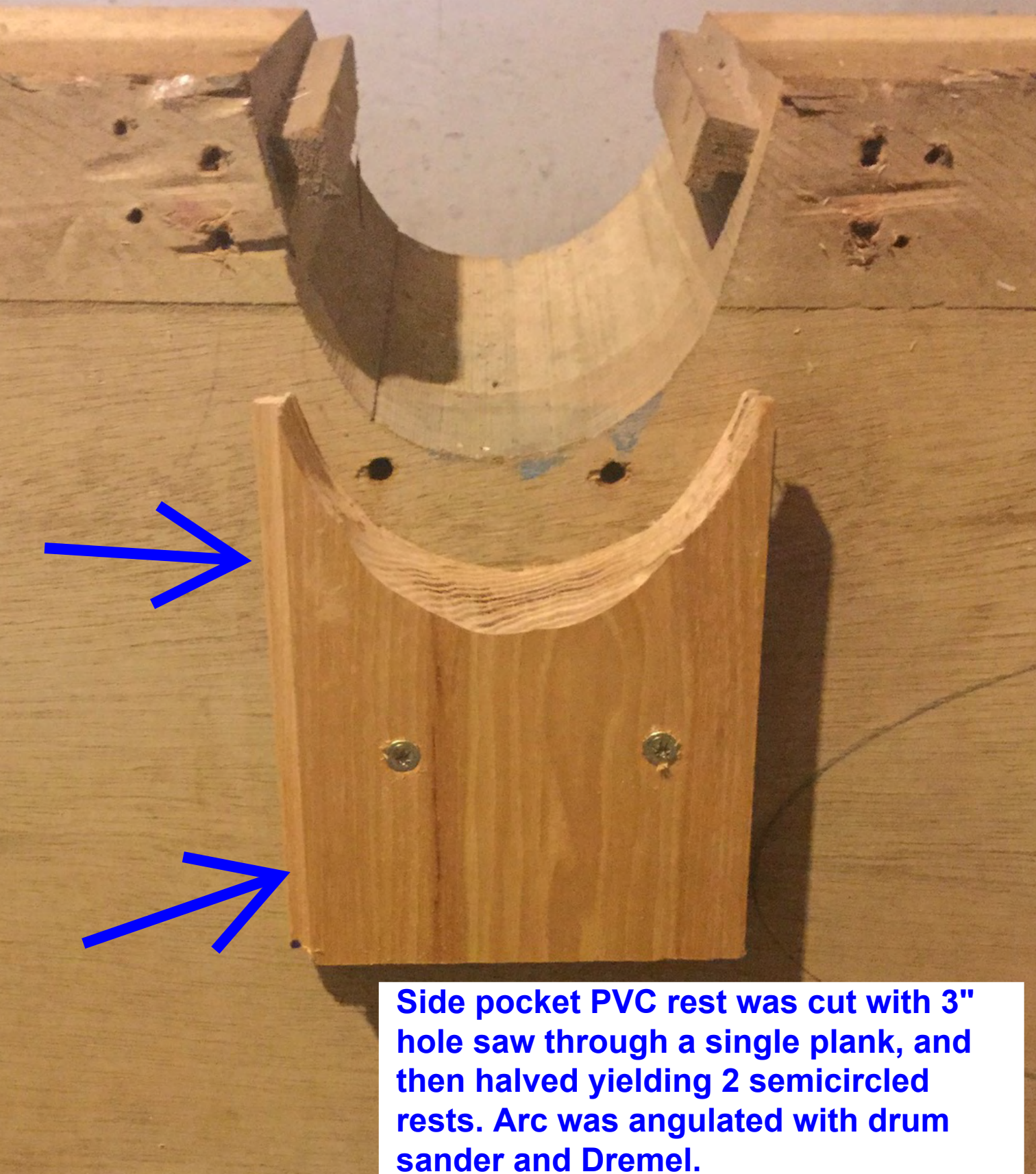

All parts are 3" Schedule-40 PVC
32"
3 1/2 "
18 1/4"
3 1/2 "
90°
6 1/4 "
22.5°
11"
11 1/4"
22.5°
13 1/2"
22.5°
4 1/2"
13 5/8"
NB: The measurements ARE SPECIFIC TO my own Victor Cleveland Standard table, circa 1930s

PIPE UNIT LENGTH	QUANTITY	TOT LENGTH	
13.625	2	27.25	
11	2	22	
32	1	32	
4.25	2	8.5	
11.25	2	22.5	
3.5	2	7	
18.25	1	18.25	
13.5	2	27	
6.25	2	12.5	
3.5	2	7	
		184	
		15.33	**Total length**

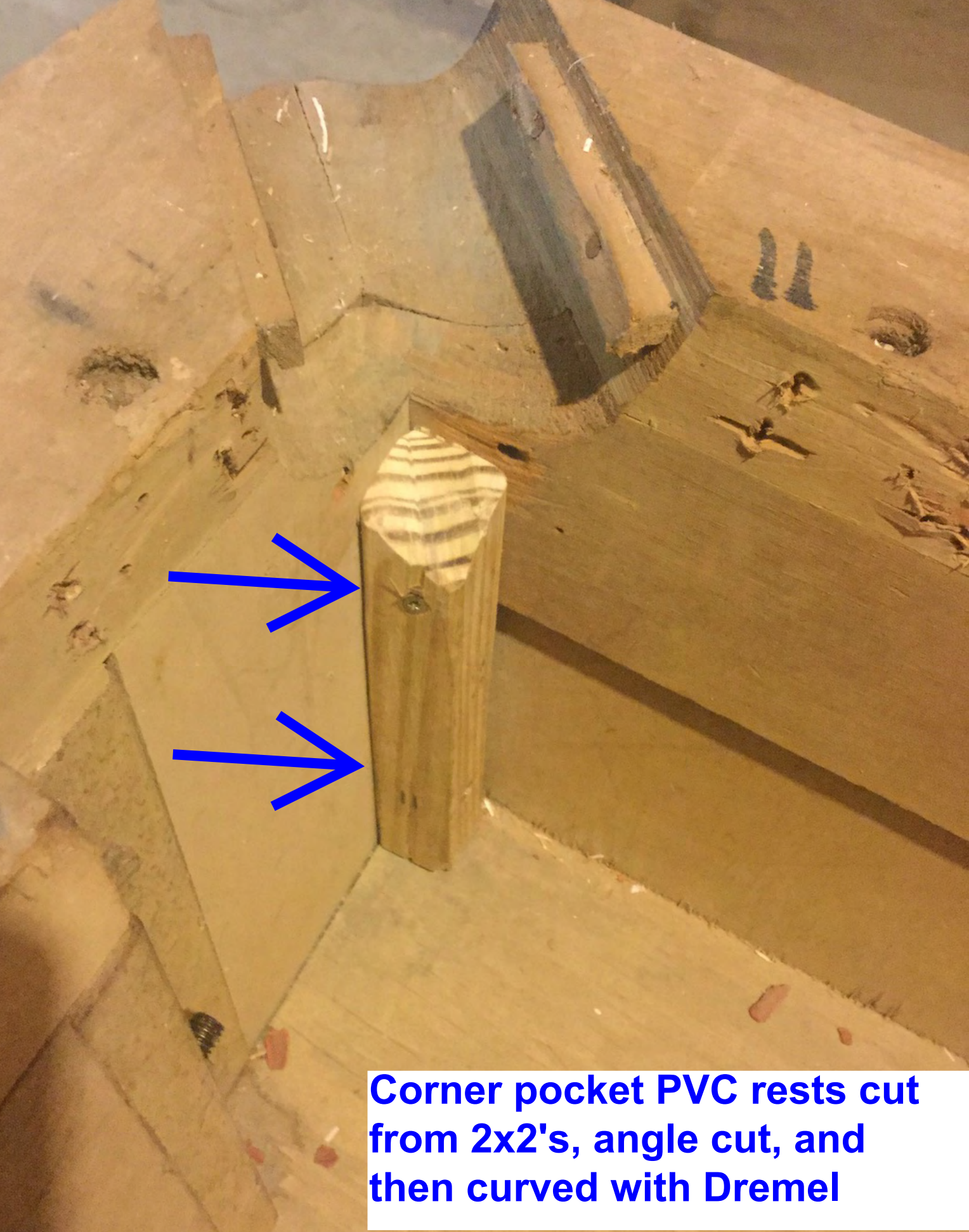
ITEM	QUANTITY	PRICE EA	TOTAL COST
10' pipe	2	15.67	31.34
Psi connector	3	7.76	23.28
22.5 deg elbow	8	5.21	41.68
90 deg elbow	2	3.58	7.16
soft rubber connector	2	6.78	13.56
			117.02


To lessen ball bouncing/rattling, the inside portions of the "Double-Y" (Psi) connnectors can be smoothened using a Dremel.
(see next)

I only actually did this for the final connector (nearest the table foot)



Side pocket PVC rest was cut with 3" hole saw through a single plank, and then halved yielding 2 semicircled rests. Arc was angulated with drum sander and Dremel.


Corner pocket PVC rests cut from 2x2's, angle cut, and then curved with Dremel


Assembly is sized-in using rope suspension. I lubed all joints at this stage with Vaseline to allow easier connect/ disconnect for fine adjustments. (BTW, the final system was friction connected only; no PVC cement.) Black rubber hose clamp connectors used at the foot corner pockets lend some additional wiggle room to lengths and angulations. They could also be added for this purpose elsewhere.

Confirm that the main return section is reasonably in the midline, and that things are generally symmetric L vs R

Confirm that the psi connectors are horizontal (L to R) to avoid creating a low gulley that could attract and trap a ball. Periodically test the evolving assembly by droppping balls into pockets.

Final suspension of the psi connector at the head corner pockets.

Final suspension of the psi connector at the side pockets.
(The psi connector at the foot rests on the ball collector itself.)

PVC is affixed at the pockets by countersinking and screwing into the rests with a flat head screw. (next)

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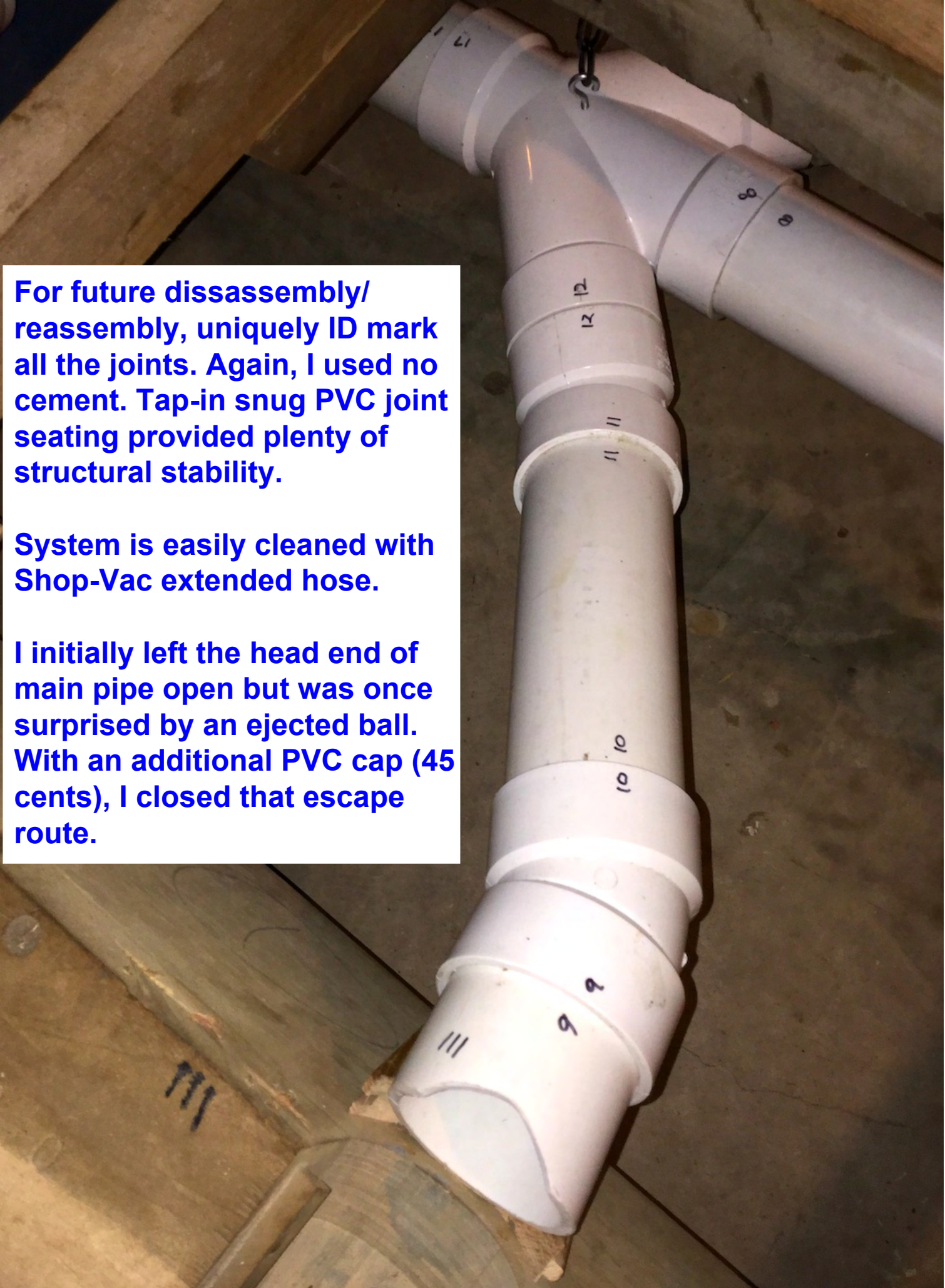
For future dissassembly/ reassembly, uniquely ID mark all the joints. Again, I used no cement. Tap-in snug PVC joint seating provided plenty of structural stability.
System is easily cleaned with Shop-Vac extended hose.
I initially left the head end of main pipe open but was once surprised by an ejected ball. With an additional PVC cap (45 cents), I closed that escape route.