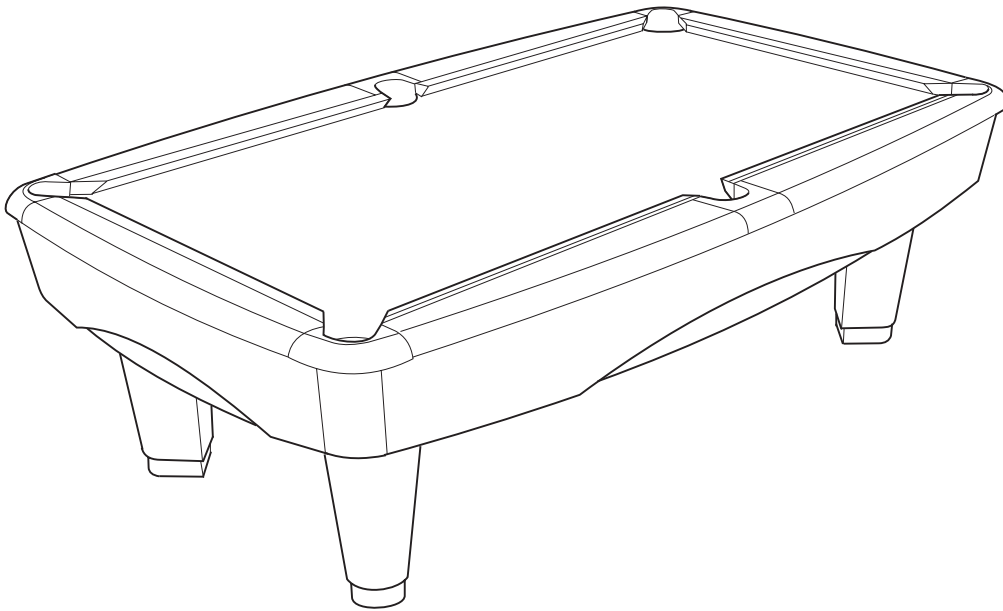


# Metro<sup>TM</sup>



## POCKET BILLIARD TABLE INSTALLATION MANUAL



[www.brunswickbilliards.com](http://www.brunswickbilliards.com)

SERVICE DEPARTMENT P.O. BOX 68 BRISTOL, WI 53104

NOTE: Please use the instructions in this manual to assemble the tables shown below. Illustrations may be different depending on the table being assembled. Also note that careful handling of *all* components will assure damage-free assembly.

# BASEFRAME AND LEG ASSEMBLY

METRO

FIGURE ONE

*Step #1:* Loosely assemble the two side sills to the four cross support sills as shown in *Figure One* with 5/16-18 x 4" hex head bolts, 5/16 flat washers and 5/16-18 weld nuts.

*Step #2:* Attach two slate attach cleats to each end of the baseframe as shown in *Figure One* with 5/16-18 x 5-1/2" hex head bolts, 5/16 flat washers and 5/16-18 hex nuts.

Position flush with the top of the sill and securely tighten

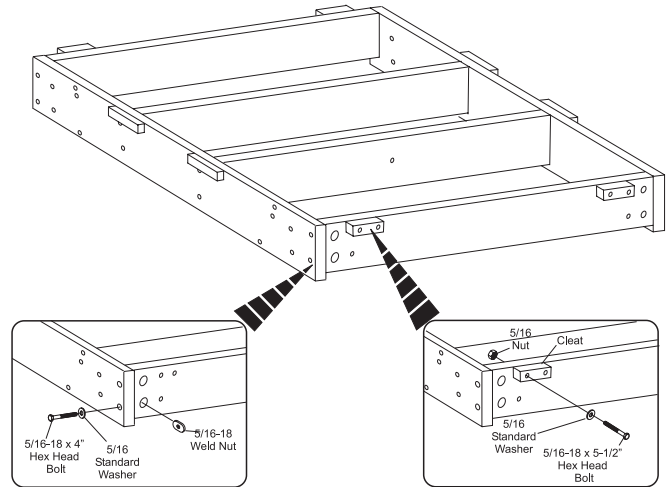


FIGURE ONE

FIGURE TWO

*Step #3:* Set the legs out with the levelers up. Run out about 1/4" to assure that they are free to rotate.

*Step #4:* Set the legs out, upright at the four corners and set the assembled baseframe on top.

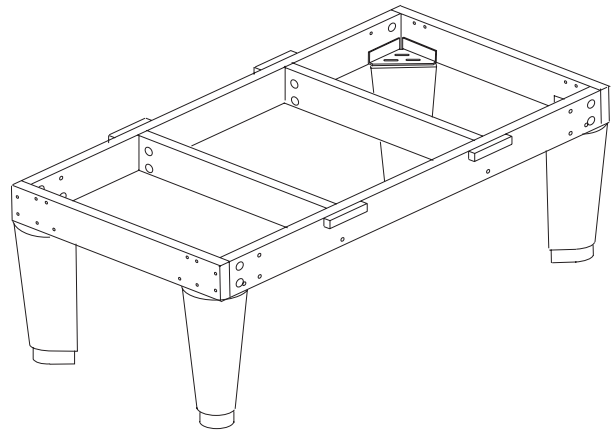


FIGURE TWO

FIGURE THREE

*Step #5:* Set a leg attach bracket in each corner of the baseframe on top of the leg.

*Step #6:* Loosely attach the brackets to the leg using 5/16-18 x 1-1/4" hex head bolts and 5/16 flat washers.

*Step #7:* Loosely attach the baseframe to the brackets using 3/8-16 x 2-3/4" hex head bolts, 3/8 flat washers and 3/8-16 hex nuts.

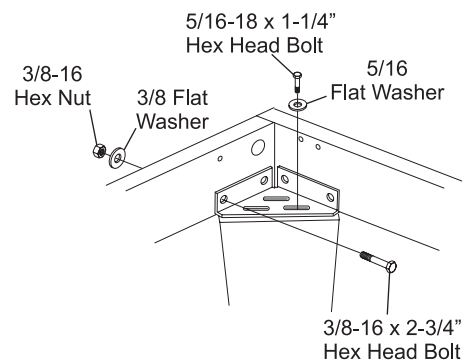


FIGURE THREE

# BASEFRAME AND LEG ASSEMBLY (CONTINUED)

METRO

FIGURE FOUR

*Step #8:* Measure the baseframe assembly diagonally and adjust as required to obtain the same measurement to assure the baseframe is square. With all joints flush and legs aligned properly, tighten all hardware securely.

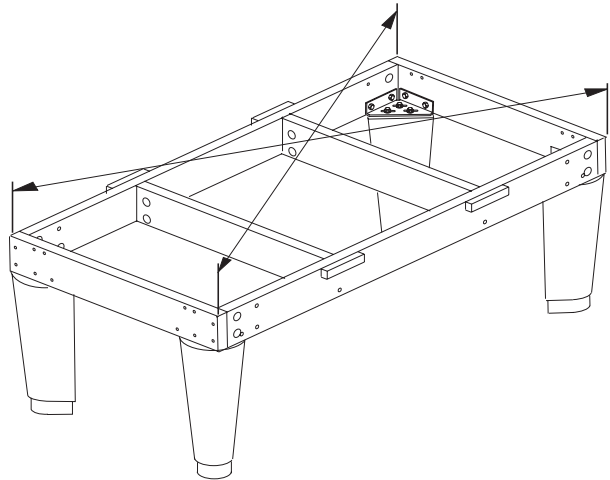


FIGURE FOUR

FIGURE FIVE

*Step #9:* Screw #10 x 1" pan head tapping screws through the top of each leg bracket into the leg.

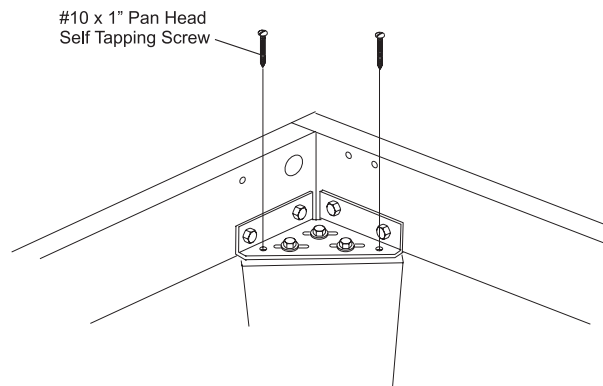


FIGURE FIVE

FIGURE SIX

*Step #10:* Position the baseframe and leg assembly in its final location. Level the baseframe with your preferred level by rotating the leg levelers. The levelers should be rotated out at least 1/4" to allow for further leveling when the slate is attached.

**NOTE:** Try to leave at least 5' between the outer edge of the baseframe to any wall.

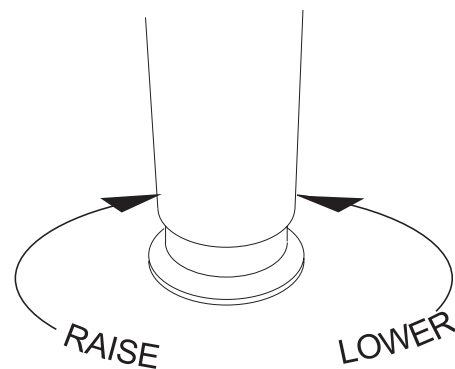


FIGURE SIX



# SLATE ASSEMBLY AND LEVELING

METRO

FIGURE ONE

*Step #1:* Position the center slate section evenly between the two slate joint supports as shown, with an equal amount of overhang at each side of the base frame.

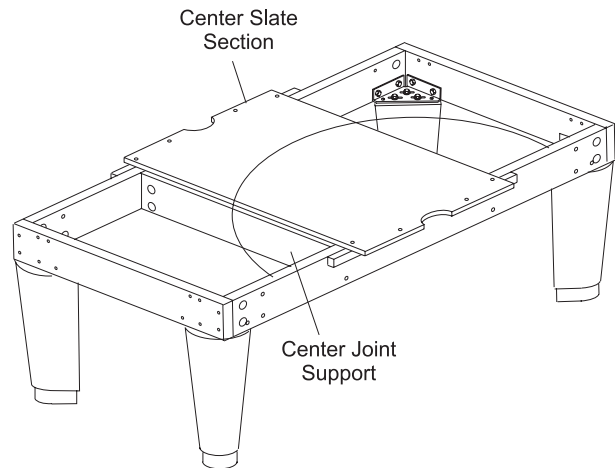


FIGURE ONE

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:* Securely fasten the end slate sections at both ends of the table with  $1/4 \times 1-3/4$ " flat head screws for UNFRAMED slate or  $\#14 \times 3$ " flat head screws for FRAMED slate.

*Step #6:* With a precision tool, level each end slate section by driving wooden slate wedges (provided) between the top of the base frame and bottom of the slate as shown. 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.

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

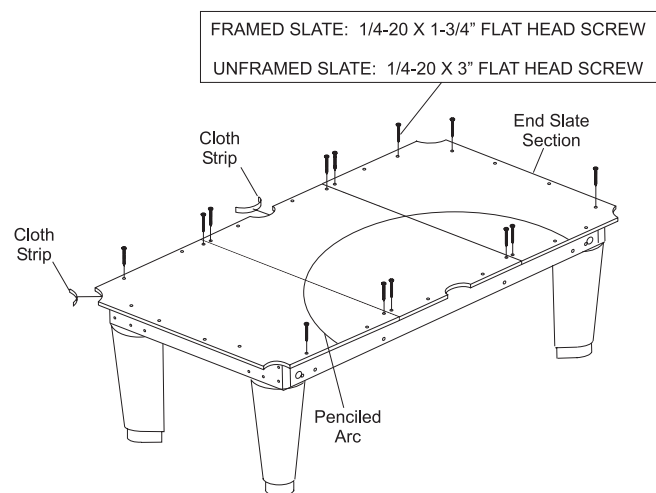


FIGURE TWO



# SLATE ASSEMBLY AND LEVELING (CONTINUED)

METRO

FIGURE THREE

*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.

*Step #11:* Clean top of slate thoroughly with a damp cloth before applying the bed cloth.

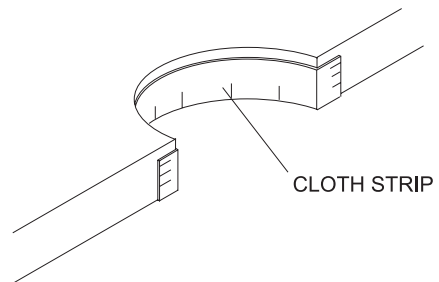


FIGURE THREE

# ATTACHING BILLIARD CLOTH TO UNFRAMED SLATE

METRO

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. Leave an equal amount of cloth overhang at the ends and sides of the slate.

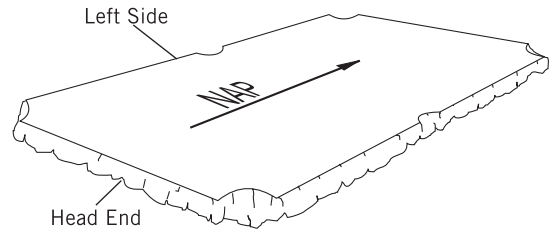


FIGURE ONE

FIGURE TWO

*Step #2:* At the head end of the table, fold the cloth back away from the edge of the slate and spray a coat of contact adhesive (not included) as indicated by the shaded area of the edge of the slate. Hold the can approximately 4-8" from the area to be coated. Coat the underside of the slate also. Place a piece of protective paper or card board on the top surface of the cloth.

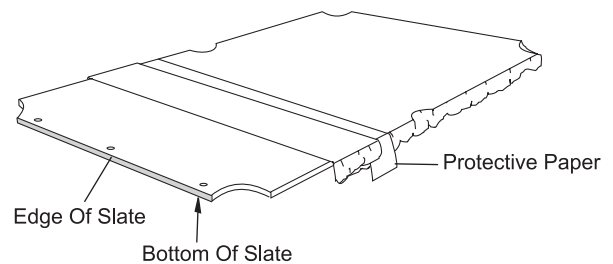


FIGURE TWO

FIGURE THREE

*Step #3:* Attach the cloth at #1.

*Step #4:* Stretch the cloth across the table at #2. Fold the cloth overhang underneath the edge of the slate at the end.

*Step #5:* Fold the cloth back at the foot end of the table and repeat Step 1.

*Step #6:* Stretch the cloth from #1 to #3 and press into position.

*Step #7:* Stretch the cloth #3 to #4, pulling from #1 and #2. Press into place.

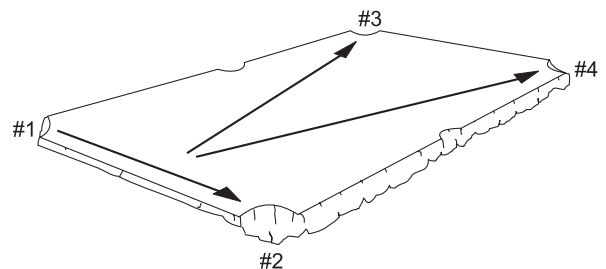


FIGURE THREE

# 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.

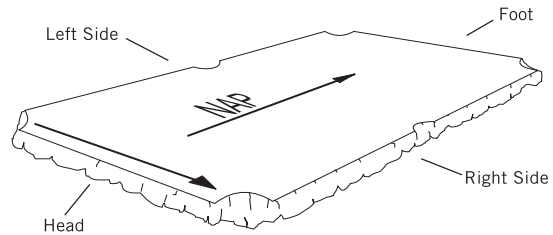


FIGURE ONE

## 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.

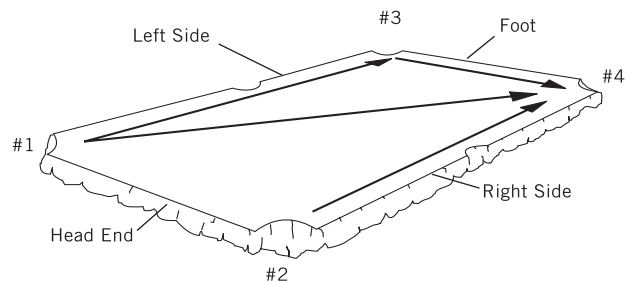


FIGURE TWO

## 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.

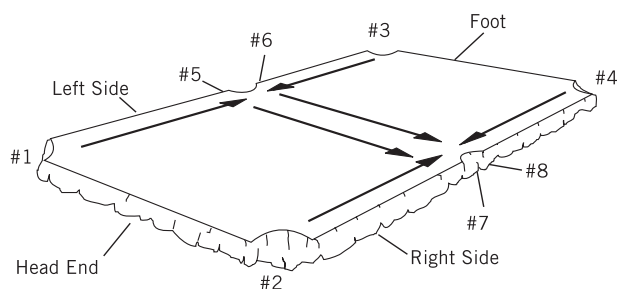


FIGURE THREE



# ATTACHING BED CLOTH TO FRAMED SLATE (CONTINUED)

METRO

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.

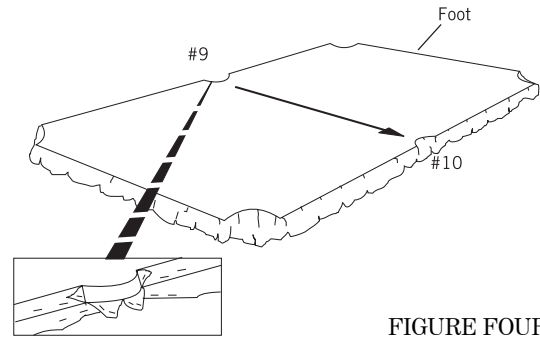


FIGURE FOUR

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.

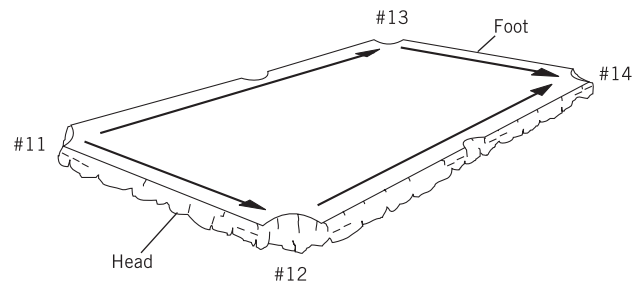


FIGURE FIVE

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.

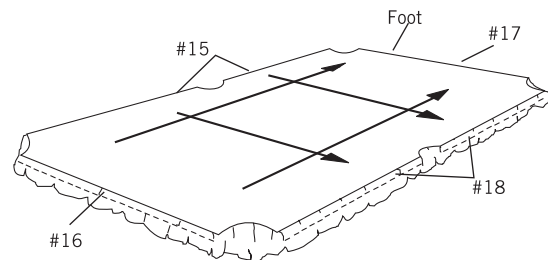


FIGURE SIX

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.

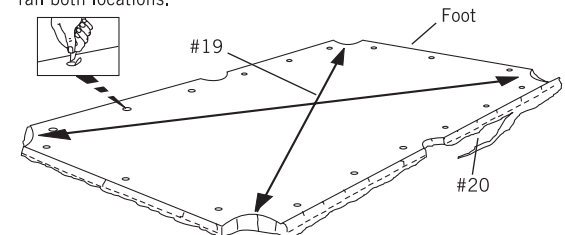


FIGURE SEVEN

# ATTACHING RAIL CLOTH

METRO

## 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.

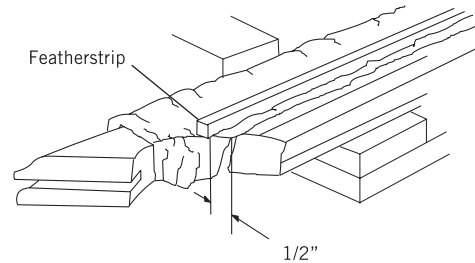


FIGURE ONE

*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 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.

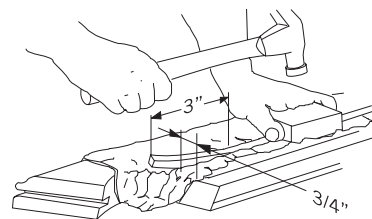


FIGURE TWO

### FIGURE THREE

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

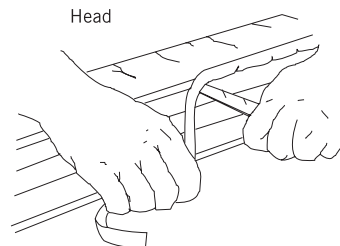


FIGURE THREE

### 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.

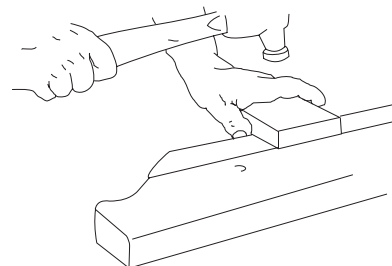


FIGURE FOUR

### 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.

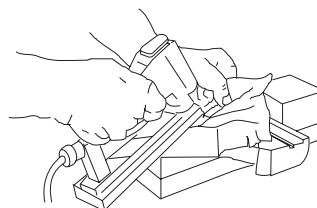


FIGURE FIVE

# ATTACHING RAIL CLOTH (CONTINUED)

METRO

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 each end.

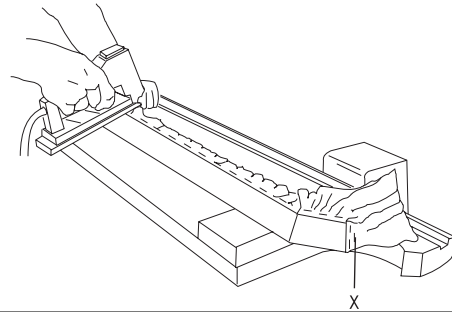


FIGURE SIX

FIGURE SEVEN

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

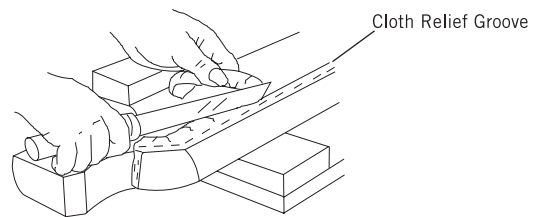


FIGURE SEVEN

## SIDE POCKET

FIGURE EIGHT

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

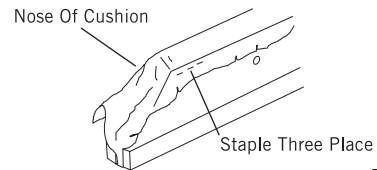


FIGURE EIGHT

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.

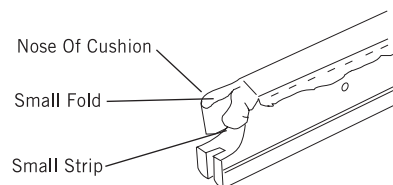


FIGURE NINE

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.

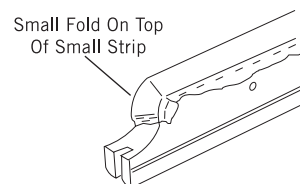


FIGURE TEN

# RAIL AND APRON ASSEMBLY

METRO

FIGURE ONE

*Step #1:* Position the six rails upside down in their respective locations on a protected surface as shown.

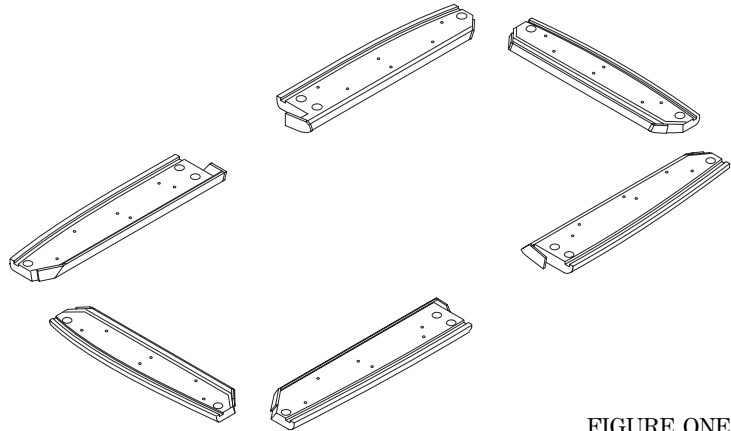


FIGURE ONE

FIGURE TWO

*Step #2:* With the rails laid out, drive roll pins into the end of each rail. Leave 1/8" of roll pin exposed. Position the sides and corner castings on rails using so pins align with clearance holes.

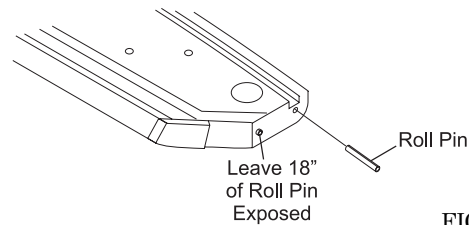


FIGURE TWO

FIGURES THREE AND FOUR

*Step #2:* Attach the corner and side castings to the rails using 5/16-18 x 1-3/4" hex head bolts, 5/16 flatwashers and 5/16-18 weld nuts. Tighten finger tight, square the rail assembly and tighten all casings securely.

**NOTE:** the castings will not be flush with the top and back of the rails you will have about a 1/8" overhang.

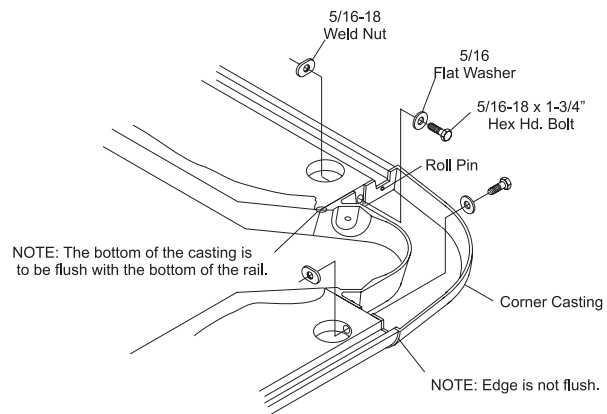


FIGURE THREE

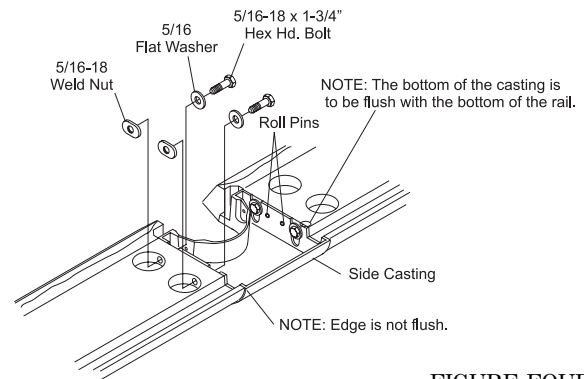


FIGURE FOUR



# RAIL AND APRON ASSEMBLY (CONTINUED)

METRO

## FIGURES FIVE AND SIX

*Step #3:* Set the aprons into the relief in the bottom of the rail. Loosely attach the aprons with 1/4-20 x 2" hex head bolts and 1/4 flat washers.

*Step #4:* Slide the apron corners onto the apron ends with the corner flush with the bottom of the apron. Attach with #10 x 1/2" pan head tapping screws.

*Step #5:* Properly position the aprons to the rail and secure all apron hardware.

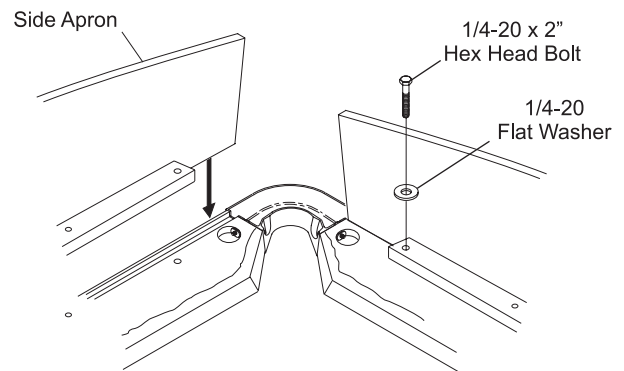


FIGURE FIVE

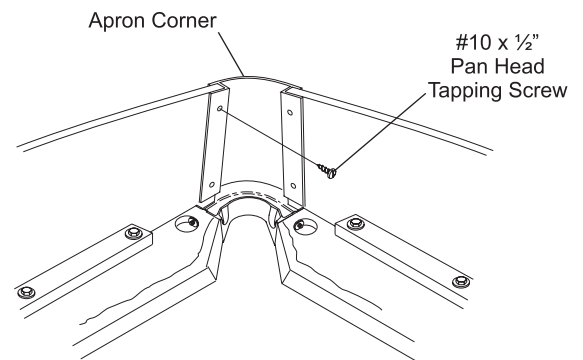


FIGURE SIX

# RAIL AND APRON ASSEMBLY (CONTINUED)

METRO

FIGURE SIX

*Step #6:* Carefully tuen the rail and apron over and lower it over the table.

**CAUTION:** Do not let the rail assembly “twist” or “bow” while turning as the strain may cause the rail to crack at the ends.

*Step #7:* Align the eighteen machine studs with the eighteen clearance holes through the slate, and lower assembly onto the slate.

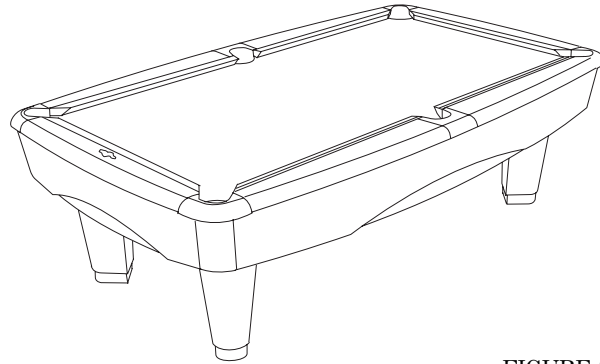


FIGURE SIX

FIGURE SEVEN

*Step #8:* Thread the 3/8-16 hex nut and dome washer onto the machine stud (three places) at the ends of the table and tighten securely.

*Step #9:* Making sure that the side rails are in a straight line as sighted down the length of the table (cushion side), fasten the side rails securely with remaining nuts and dome washers.

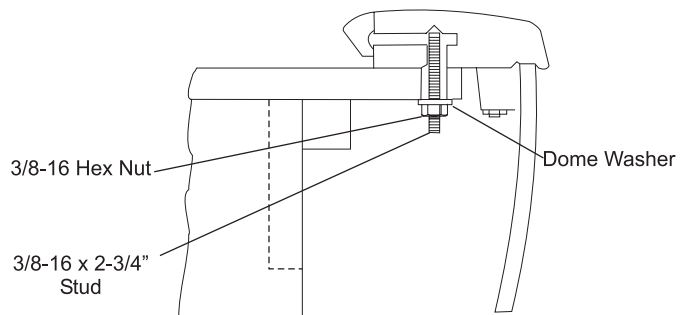


FIGURE SEVEN

FIGURE EIGHT

*Step #10:* Install the side and corner pockets by pulling them up from under the rail and apron assembly. Place them in the castings and carefully fit and trim end to fit flush behind the cushion facing. Use a scribe or nail set as a drift pin to locate castings hole. Install with #10-24 x 5/8" socket head machine screws and #10 external tooth washers.

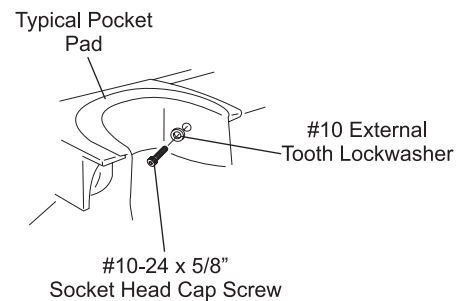


FIGURE EIGHT

FIGURE NINE

*Step #11:* Thoroughly brush the area on which the bed

*Step #12:* Locate and install bed spots for each type of table as shown.

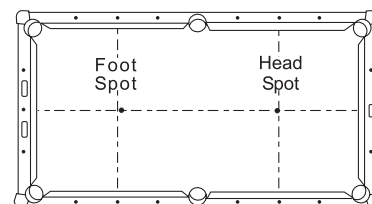


FIGURE NINE

# BALL RETURN SYSTEM

METRO

FIGURE ONE

*Step #1:* Position the ball receiver box at the center of the bottom of the foot end sill. Securely attach with eight #10 x 2" drill point screws and #10 fender washers.

*NOTE:* This procedure should be done prior to installation of the slate.

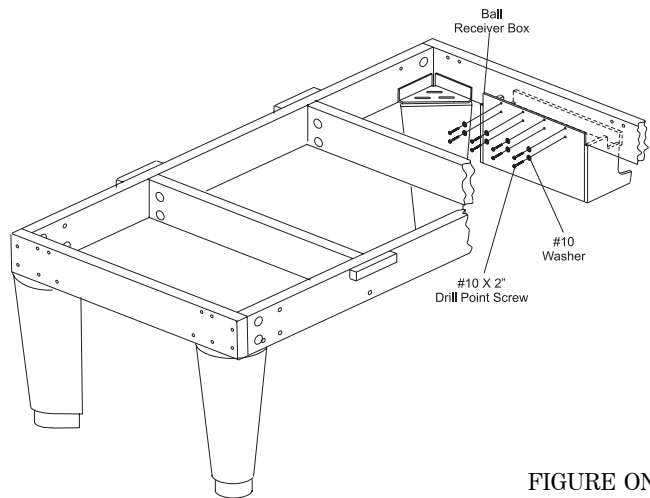


FIGURE ONE

FIGURE TWO

*Step #2:* Install the side and corner pockets by pulling them up from under the rail and apron assembly. Place them in the castings and carefully fit and trim end to fit flush behind the cushion facing. Use a scribe or nail set as a drift pin to locate castings hole. Install with #10-24 x 5/8" socket head machine screws and #10 external tooth washers.

*NOTE:* This system requires four head gully boots. Use left-hand and right-hand head pockets at the foot of the table.

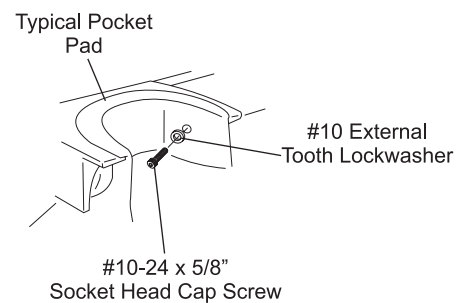


FIGURE TWO

FIGURE THREE

*Step #3:* Attach the gully track to the bottom of the sills using #10 x 1-1/4" pan head tapping screws. Use two screws per cleat, one into the bottom of the sill and one inside. Install the foot end tracks first then butt the head track to the foot track.

*NOTE:* To obtain a smoother roll the wires can be bent to match.

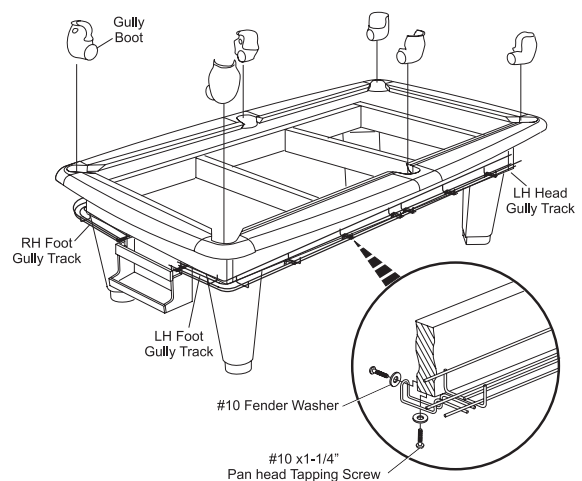
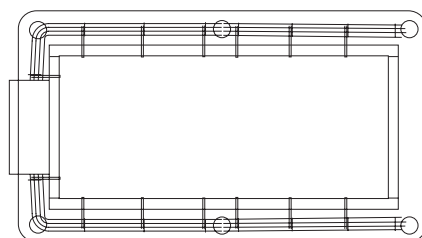


FIGURE THREE