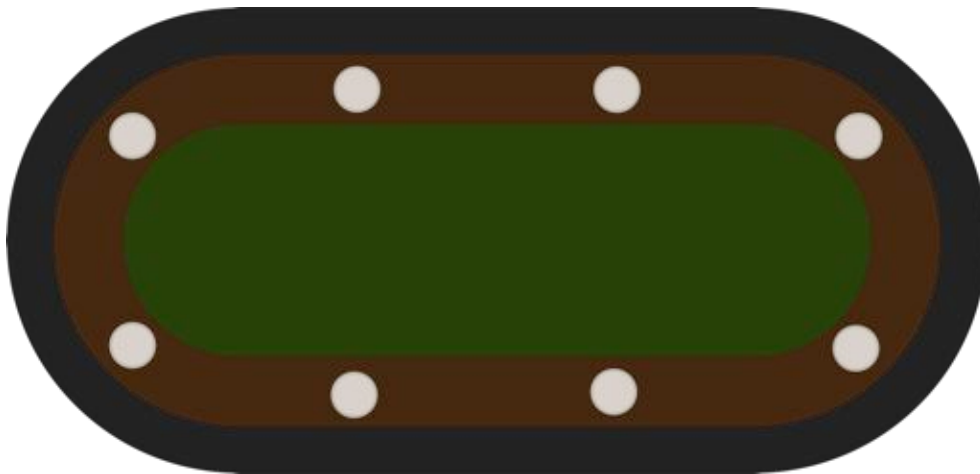


TIM'S CUSTOM POKER TABLES 44"x84" RACETRACK POKER TABLE PLANS

Are you looking to build your own poker table? This complete set of plans will describe in great detail how to build a Racetrack Hold 'em style poker table. If you follow these instructions you will be playing on your new poker table with a couple of weekends worth of work. Invite your buddies over and have fun building. If you have any questions during your build, please email me at thebert@timscustompokertables.com and I will be happy to help. Also I would love to hear any feedback and see some pictures of your completed table after using these instructions.

The following poker table plans will guide you step by step to build your own poker table that seats eight with a racetrack and jumbo drop in drink cup holders measuring 44" wide by 84" long.



Designing Your Table:

First you must choose the size of poker table you want to build. Many of my customers want a table that is eight feet long (96") and four feet (48") wide that can comfortably fit 10 or 12 people, including a dealer. Many customers with a dedicated room for a poker table, or bars that hold tournaments also prefer this size. However, if you are the weekend player, and you need to store your table out of sight, you may want to build a table seven feet (84") long and 44 inches wide.

Once you have made a decision on the size of table you want to build, you will need to determine the radius of the ends. For the standard circle ends, the width of your table divided by two will determine your radius. A 44" wide table will have a 22" Radius and a 48" wide table will have a 24" radius.

NOTE: *DO NOT go cheap on materials! The better materials you buy the longer your table will last and the more you will enjoy playing on it. You will definitely want to get a nice vinyl and foam for the rail and a good cloth for the infield surface. It is well worth spending a little extra now than replacing cheap materials later.*

WARNING: Always use proper safety gear while using tools and chemicals including but not limited to safety goggles, gloves hearing protection, face shield, respirator, etc,

WARNING: Always follow the tooling manufacture recommendations and chemical company's safety precautions

Materials required:

- 2 each sheets of 3/4"X4'X8' plywood (one sheet must have a sanded finish or choose Maple, Birch, Oak, etc.) Do not get particle board or any other cheap wood.
- 1 each sheet of 5/8"X4'X8' of wood for the infield surface. This can be a less expensive piece of wood. I only use sanded plywood now although these plans show wafer board. This will give you a 1/8" higher infield surface. You can choose a 1/2"X4'8' if you want a completely flush playing surface between the infield surface and the racetrack.
- 1 pair of folding table replacement legs. (you will have to oversize the holes in the table legs to 1/4")
- 1 small box of 1 1/4" wood screws.
- 1 small box of 1" wood screws.
- 16 each 1/4" "T Nuts" (used to install the table legs)
- 16 each 1" X 1/4" bolts (used to install the table legs)
- 16 each 1/4" washers (used to install the table legs)
- 16 each 1/4" loc washers (used to install the table legs)
- 2 each 6" handles (if you plan on installing cup holders you will not need handles)
- 1 each 30"X80" sheet of Volara closed cell foam (used for infield cushion) Automotive headliner may be used instead Volara if you want a softer, less dense playing surface.
- 1 piece of cloth measuring at least 30"X80" (used for the infield cloth) AVOID FELT! The cards will not slide. Felt will ball up very quick and become unsightly. I recommend using Suited Speed Cloth that is made in America.
- 3 yards of high quality vinyl (for the rail covering)
- 1 1"X4'X8' sheet of high density foam (used for rail padding) you can use a 1"X2'X7' if you cut it into three 8" strips if you don't mind seaming the foam.





Consumables Required:

- 1 each can of spray adhesive (I prefer 3M Super 77)
- 1 each bottle of wood glue
- 1 small box of 5/16" staples
- 1 small fold of sand paper: 180, 220, and 320 grit
- 1 each tack cloth
- 1 quart of sealing primer or a pint of black "ebony" stain (for sealing the bottom of the table)
- 1 pint of stain, your choice of color
- 1 quart of clear finish
- 1 pack of razor blades
- 2 china bristle paint brushes and a six inch paint roller with a medium nap
- 4 18 gauge finish nails or equivalent
- 1 quart of mineral spirits
- 1 bag of cotton cloths (for polishing)
- 1 roll of quality paper towels
- Carpenters Pencil

Tools Required:



- 3/8 Chuck Drill/Screw Gun
- Drill bit set, countersink and screw tips
- 1/2" Chuck Drill and 3 5/8" Hole Saw for jumbo drop in drink cup holders. (you can use a Jig Saw instead)
- Jig Saw with a fine cut wood blade
- Circular Saw (you can use a Jig Saw instead)
- Router with a 1/4" or 1/2" Roundover bit
- Tape Measure
- Chalk Line, Level or Straight Edge
- Drywall Square
- Clamps
- Saw Horses
- Electric Sander
- Staple Gun or Fine Wire Tacker
- Shears
- Belt Sander
- Hammer

Procedure A: Drawing and Cutting Your Table



<p>A.1</p>		<p>Place the two 3/4"X4'X8' sheets of plywood together on a bench or saw horses and align them with each other. The racetrack sheet should be on the top with the finish (nice) side facing up. The base sheet should be on the bottom with the nice side facing down. Put a few 1 1/4 screws in through the bottom piece to keep the two sheets together.</p> <p>CAUTION: DO NOT LET THE SCREWS PROTRUDE THROUGH THE TOP OF THE RACETRACK SHEET.</p>
<p>A.2</p>		<p>Measure the distance of the radius from the side of the table on each end. In this case we are building a table 44" X 84" so the radius is 22" Lightly (do not press to hard or you will be able to see your line after the stain is applied) draw a pencil line 22" from the side of the sheet from end to end. This will be the center line of your table.</p> <p>On one end, place a pencil mark 22" from the end in the center of the line.</p>
<p>A.3</p>		<p>Make a radius tool (top in this photo) to draw the radius ends. I used a piece of wood with a finish nail in one end as the pivot point and a pencil at the other to mark the radius. For this table the pencil tip should be 22" from the pivot nail for the end radius and 12" from the pencil tip to the pivot nail for the racetrack radius.</p> <p>Make the rail tool (bottom in this photo). This tool is essentially made the same except the nails are not a pivot point, they are a guide. The distance from the pencil tip is 1 1/2" and 4".</p>
<p>A.4</p>		<p>Place the radius tool (A.3) with the pivot point finish nail at 22" from the pencil on the mark you made 22" from the end on the center line and hammer it into the wood sheet. Draw the radius. Be sure to draw a full 180 degrees.</p> <p>To find the pivot point for the opposite end, measure along the centerline of the table from the edge of the radius you just marked along the center line and place a pencil mark at 62" inches.</p>

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A.5		<p>Place the radius tool (A.3) with the pivot point finish nail at 22" from the pencil on the mark you made at 62" on the center line. Hammer the nail into the race track sheet and draw the radius. Be sure you draw a full 180 degrees. Use a straight edge or chalk line, connect both of the radius together and mark or draw a pencil line along the entire length.</p> <p>At this point you will be able to see the final size of your table. Check your measurements one more time. The table should be 44" wide and 84" long.</p>
A.6		<p>Time to make your first cut. Start with cutting off the excess width using a circular saw.</p>
A.7		<p>Next cut out each radius on each end where you marked it using a jig saw.</p>
A.8		<p>After the cuts are made they may be cleaned up with a router or belt sander if needed.</p>

<p>A.9</p>		<p>Here is a quick look at the table after the cuts are made.</p>
<p>A.10</p>		<p>Place a mark on each sheet on one end with a line and arrow facing up so you will know how the sheets will go together later.</p>




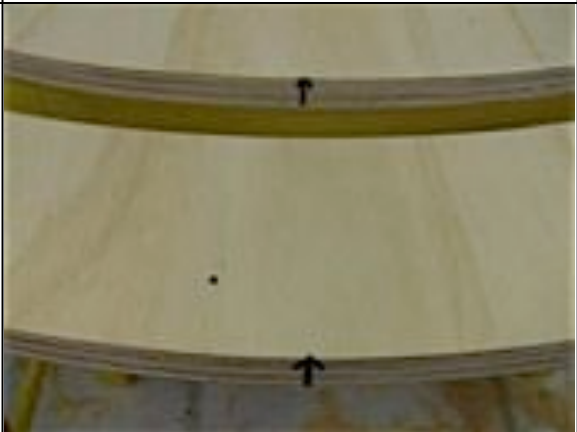
Procedure B: Marking the Racetrack Inside Diameter

<p>B.1</p>		<p>Place the radius tool in the same 22" pivot point you used to mark the ends of the table. This time the measurement on the radius tool from the pencil to the pivot point finish nail will be 12". Run the radius tool and mark (lightly) with the pencil around the entire diameter of the racetrack ends. This will give you a 6" racetrack when the rail is installed.</p> <p>Repeat this procedure for the opposite end.</p>
<p>B.2</p>		<p>Once the radius is marked on each end, use a level or a strait edge to line up the two ends and mark the line with a pencil.</p> <p>CAUTION: DO NOT MAKE THE CUT AT THIS TIME.</p>




Procedure C: Cutting the Holes for the Cup Holders

<p>C.1</p>		<p>Position your drink cup holders in the positions you want them. The Jumbo cups seen here must be centered at 3" from the racetrack inside diameter line (B.1 and B.2) you marked on the previous step. This measurement may not look correct at this time although the cups will be centered on the racetrack after the rail filler piece is cut (F.2) and the rail is installed. Lightly trace around the cups with a pencil.</p>
<p>C.2</p>		<p>Mark the center of each hole.</p>
<p>C.3</p>		<p>If you have a 3 5/8" hole saw, place the pilot bit on the center of the mark use a 1/2" chuck drill to cut out each hole through both the racetrack and base. If you use a 3 5/8" hole saw your cups will be slightly loose in the wood. The</p> <p>CAUTION: RUN THE HOLE SAW AT FULL SPEED AND DRILL STEADY AND STRAIGHT. IF YOU CATCH AN EDGE AS THE SAW CONTACTS THE WOOD YOU MAY MARK UP OR SPLINTER THE RACETRACK SHEET.</p>
<p>C.4</p>		<p>If you plan on using a jig saw to cut your holes, drill a pilot hole and carefully cut out the holes through both sheets. Clean up the cuts with sand paper.</p> <p><i>NOTE: Make your cuts just on the inside of your line and they will be a tight fit.</i></p> <p>Cut out the remaining holes, then remove the 1 1/4" screws that were installed (procedure A1) in the base sheet on the bottom. Remove the racetrack sheet and place it aside.</p>




Procedure D: Marking and Cutting the Base Sheet 4" Piece for the Rail

<p>D.1</p>		<p>With the Racetrack sheet removed from the top of the base sheet. Measure and mark with the rail tool (Procedure A3) a 4" line around the entire diameter of the base (Lower/Bottom) sheet. This 4" area will be the top piece of the rail. The pencil point should be four inches from the finish nail.</p> <p>NOTE: This is the base sheet NOT the racetrack sheet.</p>
<p>D.2</p>		<p>Drill a pilot hole on the inside edge (not in the 4" marked area) just large enough for the jig saw blade to fit through.</p> <p>NOTE: Pay close attention at the location of the pilot hole.</p>
<p>D.3</p>		<p>Carefully cut with the jig saw along the line. It will be necessary to support the 4" rail piece with clamps as you cut around the table.</p>
<p>D.4</p>		<p>Mark the end of the base sheet with an arrow pointing up so you will know which direction the rail piece goes later. Set the rail top piece and the base sheet aside.</p>





Procedure E: Cutting out the Racetrack

E.1		<p>Place the racetrack sheet on the saw horses with the finish side up.</p> <p>NOTE: The race track infield cut will be the most critical cut on your table. Take the extra time to make this cut as straight and clean as possible. The entire cut will be visible when your table is complete.</p> <p>Drill a pilot hole on the inside edge (NOT in the racetrack area) just large enough for the jig saw blade to fit through. Carefully cut on the line.</p>
E.2		<p>NOTE: Pay close attention to the location of the pilot hole. The pilot hole should be on the center piece NOT ON THE RACE TRACK.</p>
E.3		<p>View of the race track cut out.</p>

Procedure F: Marking and Cutting the Racetrack 1 1/2" Filler Piece for the Rail



<p>F.1</p>		<p>With the race track sheet on the bench or saw horses with the finish side up. Measure and mark with a pencil 1 1/2" around the entire diameter of the racetrack. This will become the bottom part of the rail.</p> <p>Use the rail tool (Procedure A.3) you made to mark this area with a finish nail located 1 1/2" from the pencil point.</p>
<p>F.2</p>		<p>Drill a pilot hole on the inside edge, this pilot hole will not be seen when the table is assembled. Cut out the 1 1/2" band on the line around the entire diameter. It will be necessary to support the rail piece with clamps as you cut around the table.</p> <p>Trim the outside diameter of the racetrack with a belt sander removing approximately 1/16" of material.</p> <p>NOTE: It will be necessary to sand the outside diameter of the race track with a belt sander to allow the rail to fit on the racetrack a little easier.</p>
<p>F.3</p>		<p>Place another mark on the end of the racetrack sheet with an arrow pointing up. Set the bottom rail filler 1 1/2" piece aside.</p>

Procedure G: Marking and Cutting out the Infield Wood Sheet



<p>G.1</p>		<p>Place the race track over the 5/8"X4'X8' infield sheet. Trace a pencil line around the racetrack inside diameter on to the infield sheet. Be sure to place an "X" on the infield sheet at the end of the racetrack that is marked with an arrow. Set the racetrack aside.</p>
<p>G.2</p>		<p>Cut carefully on the outer edge of the line and carefully sand the edge of the infield sheet to fit.</p>
<p>G.3</p>		<p>Place the racetrack over the infield sheet. Trim the infield sheet by sanding the edge to obtain a gap with a minimum of 1/32" and a maximum of 1/16" depending on the type of cloth you use.</p> <p>CAUTION: DO NOT SAND TOO MUCH OFF THE INFIELD SHEET. SAND ONLY A SMALL AMOUNT AT A TIME AND KEEP CHECKING THE GAP.</p>
<p>G.4</p>		<p>The "X" is on the end of the racetrack marked with the arrow. The race track is 1/8" higher than the infield sheet. When the Volara foam is installed, the infield playing surface will be 1/8" higher than the racetrack.</p>

Procedure H: Rail Construction



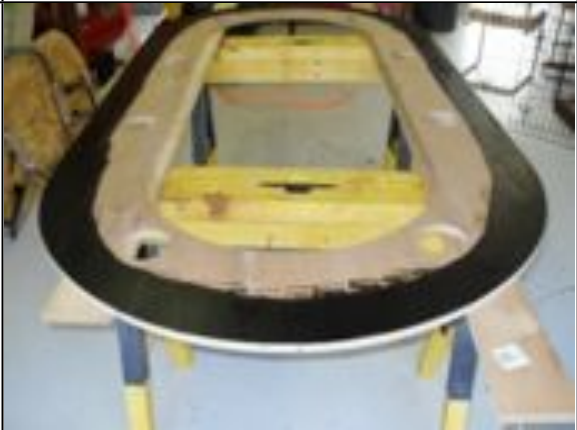

<p>H.1</p>		<p>Place the 4" rail piece that you cut out from the base sheet (D.3) on the saw horses with the top side facing down. Place the 1 1/2" rail filler piece that you cut from the racetrack sheet (F.2) with the top side facing down onto the 4" rail piece. Align the outside edges. Be sure marks you made earlier (A.10) are aligned and facing down this time.</p>
<p>H.2</p>		<p>Trace a pencil line around the inner diameter of the 1 1/2" rail piece. This line is so you will know where to put the wood glue.</p> <p>If you plan on using a finish nail gun or air stapler, go to the next step.</p> <p>Place clamps around the two pieces. Drill pilot holes about every eight inches around the entire diameter of the rail. Countersink all the pilot holes you drilled.</p>
<p>H.3</p>		<p>Set the 1 1/2" rail piece aside for a moment in a way that you will know exactly how it will be installed again.</p> <p>NOTE: Wood glue will dry very quick; you must work fast during this step.</p> <p>Run a bead of wood glue in the 1 1/2" area you just marked. Position the 1 1/2 rail piece back on the top rail piece. Quickly align the outside edges and clamp into position.</p>
<p>H.4</p>		<p>Start installing 1 1/4" wood screws (or use a nail gun or air stapler). Begin with a couple fasteners at the center on each side and at each radius end. ensure the pieces are still aligned and install the remaining fasteners using a star pattern rotating the clamps as necessary.</p> <p>After all the screws are installed remove the clamps and clean off any excess glue and sand the outer diameter joint smooth.</p>


<p>H.5</p>		<p>NOTE: It is not absolutely necessary to round your edges on your rail. Rounding the edges adds a little more comfort as well as protection. if you move your table often, it helps prevent tearing the vinyl if you bump your table into any anything.</p> <p>Using a 1/4" or 1/2" roundover bit, run the router along the bottom outside diameter edge of the rail.</p> <p>Turn the rail over so the top side is facing up. Router the top outside edge.</p>
<p>H.6</p>		<p>Router the top inside edge with the 1/2" Roundover bit.</p> <p>NOTE: On this table, a 1/2" roundover bit was used.</p> <p>Sand the rail top, rounded corners, sides and bottom with 180 grit sand paper. Remove all the dust with a hand broom or shop air. Place the rail aside.</p>

Procedure I: Installing the Folding Legs

<p>I.1</p>		<p>Here is a close up of the 1/4" hardware used to install the folding legs. You will need sixteen pieces each of the 1/4" bolts, 1/4" washers, 1/4" loc washers and "T" nuts.</p> <p>NOTE: The folding legs usually come with 3/32" holes for attach points. It will be necessary to oversize the holes to 1/4"</p>
<p>I.2</p>		<p>Place the base sheet on the saw horses with the top side facing down. Place the legs on the base and align them centering the legs on the base sheet.</p> <p>Use a drywall square and line up the hinge points on the legs. If the legs are not square the table will wobble.</p>

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<p>I.3</p>		<p>Using a 1/4" drill bit, drill through the leg attachment points and the base sheet. Be sure to temporarily install screws so the legs do not shift as you are drilling the other holes. After all the holes are drilled, remove the legs, and turn the base over so the top side faces up.</p>
<p>I.4</p>		<p>After you have turned the base sheet over so the top side is facing up. Drill using a 3/4" paddle bit approximately 1/8" deep so the "T-Nuts" will sit flush with the base sheet.</p> <p>Drill approximately 1/4" deep into the holes using a 3/8" drill bit, drill from the top of the base to allow the "T Nuts" to be installed. Hammer the "T-Nuts" into place.</p>
<p>I.5</p>		<p>Turn the base sheet back over so the top side is facing down again. Apply two coats of black primer/sealer with a 6" roller or a couple coats of black (ebony) stain on the entire bottom surface of the base sheet. Place it aside and let it dry.</p> <p>Place the race track sheet (this picture is the race track sheet, staining in process) with the bottom surface up. Apply two coats of black primer/sealer or a couple coats of black (ebony) stain on the entire bottom surface of the racetrack sheet.</p> <p>CAUTION: DO NOT AN FINISH ON THE SIDES OF THE TABLE OR THE CUP HOLES.</p>
<p>I.6</p>		<p>After the finish has dried. Put the base sheet on the saw horses with the bottom side facing up. Install the legs with the 1/4" bolts using washers and lock washers as shown. Do not over tighten the bolts.</p> <p>If you have installed drink cup holders you can skip this step. The drink cup holders can easily be removed and your table can be moved holding onto the hole cut outs.</p> <p>Install handles at the center of each end. The handles will make it much easier to move your table. Extend the legs and place the table on the legs.</p>

<p>I.7</p>		<p>Look closely at the "T-Nuts" and bolts. If the bolts are sticking up past the top surface you will have to grind them flush to the T Nuts.</p> <p>Use an electric sander to "scuff" the top surface of the base sheet to smooth any rough areas that might keep the infield sheet from laying flat on the surface. Clean the base with a hand broom or shop air.</p> <p>NOTE: <i>If you look closely at this picture you can see the grind marks on the bolts and the wood</i></p>
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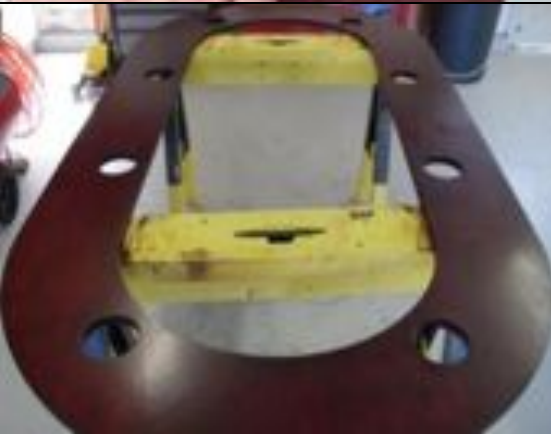

Procedure J: Installing the Infield Sheet to the Base

<p>J.1</p>		<p>Place the racetrack sheet onto the base sheet. Be sure the marks (D.4 and F.3) are on the same end. Install the drink cups in each hole. This will align the racetrack to the base sheet. Place the infield wood piece (G.2) into position and center it. Be sure the "X" marked (G.4) on the infield wood sheet is at the correct end. If all your cuts are good and the infield wood sheet is centered, the gap between the racetrack sheet and infield wood sheet will be 1/32" to 1/16" around the entire table.</p> <p>If you did not install cup holders, center the infield sheet on the base using a tape measure.</p>
<p>J.2</p>		<p>Temporarily install a couple of 1" wood screws through the infield sheet into the base to hold the hold the infield sheet in place during this step.</p> <p>Drill a pilot hole about every eight to ten inches and countersink each hole. Make sure the countersink is deep enough so the screw head is just below the surface. I have circled the fastener locations in this picture for reference.</p>
<p>J.3</p>		<p>Install 1" wood screws in the holes. Be sure all the screw heads are just below the surface and have not gone through the bottom side of the base.</p> <p>Sand the infield sheet smooth with 180 grit sand paper. This will also assist the adhesive bond from the wood to the Volara foam. Clean off the sawdust with a hand broom or shop air and wipe off the wood with isopropyl alcohol.</p>



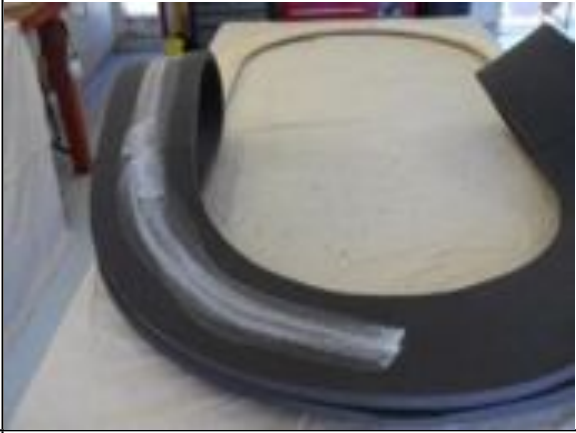

Procedure K: Application of Stain to the Racetrack

<p>K.1</p>		<p>Sand the racetrack with an electric sander, I start with 180 grit, then 220 grit and finish with 320 grit. Clean the wood between each grit with a brush or shop air. Wipe the wood with a lint free cloth dampened with Mineral Spirits between grit changes. Doing this will draw out the grain or "pop the grain" in the wood and will be more defined when you apply the stain.</p>
<p>K.2</p>		<p>Clean the wood thoroughly and wipe with a Tack Cloth. Apply a coat of wood sealer and let it soak in. Wipe off any extra sealer after fifteen minutes. Let the wood dry for about an hour.</p>
<p>K.3</p>		<p>Clean and wipe the wood with a tack cloth again. Apply the first coat of stain using a china bristle brush. Follow the stain manufactures directions.</p>





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K.4		<p>Scuff the surface between coats with steel wool. Apply as many coats as needed until the desired color is reached.</p>
K.5		<p>After the stain has fully dried. Apply a thin coat of polyurethane clear finish. Block sand with 600 grit and clean between coats. Be sure to wipe with a tack cloth before applying each coat. Apply a minimum of three coats. If you need an extra durable finish you might consider using Helmsman Spar Finish.</p>
K.6		<p>After you are satisfied with the coverage smoothness of the clear polyurethane, polish the racetrack using finishing wax. You can easily see the difference between the previous picture and this one after the finishing wax is applied.</p>





Procedure L: Installing the Rail Foam and Covering the Rail

<p>L.1</p>		<p>To purchase a good quality High Density full sheet of foam go to SuitedSpeedCloth.com This foam has a 65 lb. compression rating, 100% recovery rate and a ten year life expectancy. With this foam there is no need to cover seams. You will save alot of time and enjoy a comfortable, good quality rail for several years. Most fabric stores sell foam in 24" wide sections, this foam is usually white or green and is not as dense as a good quality foam even though they call it Hi Density. If you use this foam, cut the foam into 8" wide strips. After your strips are glued to the rail, cover each seam with a sheet of fabric softener. Only use a light coat of spray adhesive on the fabric softener.</p>
<p>L.2</p>		<p>Wipe the rail clean with Isopropyl Alcohol or a cloth dampened with soap and water to remove any dust prior to installing the foam.</p> <p>This view shows the rail laying on the foam, the outer diameter is on the right side in this picture. If you are not starting with a full sheet of foam, make sure to make your cuts to allow enough foam to completely cover the sides of the rail on inside and outside edges with a about a 1/2" overlap on the bottom. Remember the inside diameter edge is 3/4" thick, the rail is 4" wide and the outside diameter edge is 1 1/2" thick.</p>
<p>L.3</p>		<p>Lay the rail on a bench with the top surface of the rail up. Position your foam on the rail. Lift the foam on one end and apply the spray adhesive on the foam and the rail. Allow the adhesive set up for about 30 seconds. I usually work with a quarter area at a time. Firmly press the foam down on the wood. Follow the same process for the rest of the rail foam.</p>
<p>L.4</p>		<p>I purchased the foam used in this set of plans from SuitedSpeedCloth.com You can also place an order for precision cut rail foam to the exact dimension of your table.</p> <p>For this exact table, use the following measurements when you place your order:</p> <ul style="list-style-type: none"> • 44"X84" Table size • 22" End Radius • 4.00" Wide Rail • 1.50" Outside Diameter Thickness • .750" Inside Diameter Thickness





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L.5		<p>After the foam is glued to the wood, turn the rail over so the foam is on the bottom. It is time to do a final trim on the foam to keep the rail looking smooth and even. Mark the inside diameter of the foam about 1 1/4 inches (at the absolute minimum) from the edge of the wood with a marker. This measurement comes from the inside edge of the rail being 3/4" thick and allows about a 1/2" of foam to be roller over (L.2) to the bottom of the wood.</p>
L.6		<p>Mark the outside diameter of the foam about 2" inches (at the absolute minimum) from the edge of the wood with a marker. This measurement comes from the outside edge of the rail being 1 1/2" thick and allows about a 1/2" of foam to be roller over (L.2) to the bottom of the wood. This edge is more visible when your table is finished. If you have enough foam to increase the minimum measurement a little then do so. This picture shows I added about 3/4" more foam to be rolled over to the bottom. If you don't have enough foam rolled over to the bottom your rail will look wavy when viewing your table from the side. too much is better than not enough.</p>
L.7		<p>Trim the foam on your marks with a electric knife on the lines you marked. These electric knives only cost about \$10.00 and can be found in most Walmart/Target type stores. This could be a good investment if it prevents your wife from finding her knife in your toolbox next Thanksgiving.</p>
L.8		<p>Remove the rail from the work area and lay the fabric face down. Place the rail with the foam side down on the fabric and center it.</p> <p>I recommend using a fine wire tacker instead of a stapler. A fine wire tacker is easier to use than a stapler and provides much cleaner look. This tool can be purchased from Your Auto Trim You can use a regular or electric staple gun but its going to be allot of work. If you are not all that comfortable in your ability in covering the rail, you can have an automotive upholstery shop install the vinyl for approximately \$50.00 or \$60.00.</p>


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L.9		<p>Start in the center on one side and pull the fabric tight. Place a few staples where you are pulling. Only place a few staples in the area you are pulling. Pull right next the area and place a few more staples. Repeat the same procedure on the opposite side. Be sure to pull the fabric as tight as possible, The tighter the better. Work your way around the rail from the center of the sides to the beginning of the radius end. Your Staples should be placed right on the inside edge of the 1 1/2 inch rail filler piece.</p>
L.10		<p>Pull the vinyl tight and place three or four staples at the end and at 45 degrees.</p>
L.11		<p>Pull the vinyl tight and place three or four staples between the areas that were stapled in the previous step.</p>
L.12		<p>Again, Pull the vinyl tight and place three or four staples between the areas that were stapled in the previous step.</p>


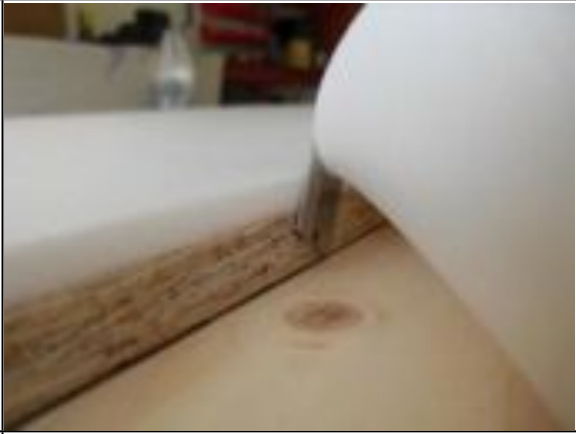

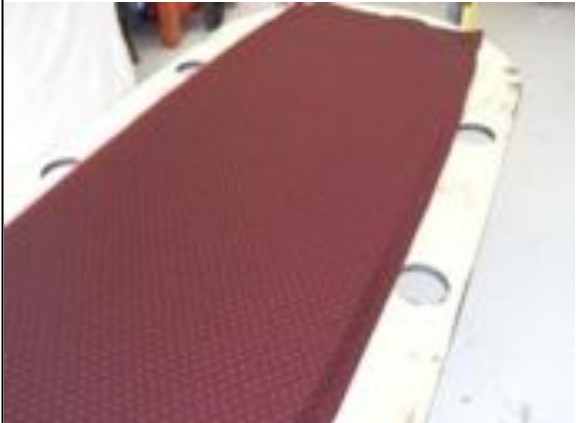
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L.13		<p>As you pull the vinyl tight, the wrinkles will go away.</p>
L.14		<p>No wrinkles in the outside end radius. Now run a second row of staples around the entire outside diameter on the rail.</p>
L.15		<p>Draw a rectangle piece in the center of the fabric allowing about 6 to 8 inches (from the wood) of material to work with on the sides. The ends of the rectangle should be located where the radius begins.</p> <p>Draw strips beginning from the center of the cutout to 3 inches from the foam on the radius ends.</p>
L.16		<p>Completely cut out the center rectangle piece that was drawn in the previous step.</p> <p>Cut along the lines for the strips you have drawn on the radius ends but do not cut them off.</p>



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L.17		<p>Start in the center of one side and pull the vinyl tight. Run a few staples. Work your way to the radius end. Be consistent when you are pulling to keep the fabric the same tension as you move around the rail. Repeat the same procedure for the opposite side.</p>
L.18		<p>Begin Pulling and stapling again every other cut strip.</p>
L.19		<p>After all of the staples are installed. Carefully trim off the excess material with a razor blade.</p>
L.20		<p>Finished and trimmed rail. The rail should be tight and the same thickness around the entire diameter of the rail. Now your fingers are sore so take a break.</p> <p>NOTE: If you used a staple gun, make sure the staples are not sticking up at all or they will scratch your table! You can use a hammer and a punch to sink the staples in deeper if needed.</p>




Procedure M: Installing the Infield Foam and Cloth

<p>M.1</p>		<p>Clean the infield surface of any sanding dust (J.3) with a tack free cloth dampened with isopropyl alcohol and let it dry.</p> <p>Position the foam on the infield sheet and make sure the entire infield surface is covered. Carefully pull one end towards the center. Spray the infield wood surface and the back side of the Volara foam with spray adhesive. Let the adhesive cure for about 30 seconds. Start at the center of the foam and lightly press the foam down sliding your hand back and forth width wise. Work from the center to the end. Repeat this step for the other end. This motion will assist in avoiding air bubbles.</p>
<p>M.2</p>		<p>Verify the foam is securely attached and smooth around the entire infield wood sheet. If you have any air trapped you can puncture the foam with a pick or small nail and release the air.</p> <p>Carefully trim the excess material using a razor blade. Be sure to hold the razor blade completely vertical. Take your time in this step and change to a new blade if it becomes dull.</p>
<p>M.3</p>		<p>Wipe the foam surface with a tack cloth. The Volara has a lot of static electricity. This will remove any particles that are clinging to the foam prior to installing the cloth.</p>
<p>M.4</p>		<p>Position your cloth on the infield surface. If you are using a suited speed cloth, line up the suites with the side.</p> <p>The cloth used on this table is Trump Card Mini Suited Speed Cloth.</p>



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M.5		<p>Carefully pull one end of the cloth towards the center. Spray the infield foam and the back side of the cloth with spray adhesive. Let the adhesive cure for about 30 seconds. If the adhesive splattered in any area, blot it up with a towel to prevent the adhesive from bleeding through into the top of the cloth. Start at the center of the cloth and lightly press the cloth down sliding your hand back and forth width wise. Work from the center to the end. Cover the end of the cloth you just glued down to prevent the spray adhesive from getting on the cloth when you spray the other side. Repeat this procedure for the other side of the cloth.</p>
M.6		<p>Staple the cloth to the side of the infield wood sheet along the entire diameter. Place a staple about every other inch. Trim the excess cloth just below the staples with a razor blade.</p>

Procedure N: Installing the Racetrack

N.1		<p>Drill two rows of 1/8" pilot holes from the top of the table base approximately 12" (inches) apart. You will need to drill the inside row of screws about an 1" from the infield sheet and the outside row about 1" from the edge of the base.</p>
N.2		<p>This diagram shows the approximate hole locations.</p>
N.3		<p>Countersink the holes on the bottom of the base sheet. Position the racetrack on the base sheet. Install 1 1/4" wood screws from the bottom of the base into the racetrack.</p>

Procedure O: Finishing touches

O.1		<p>Place the rail on the table; I prefer not to permanently install the rail. Your rail can be easily damaged if it is attached to the table if you move your table around frequently.</p> <p>Install the drink cup holders</p> <p>Invite your friends over and enjoy being the envy of everyone who plays on your new table.</p>
O.2		<p>This customer decided to go with the Jumbo Brass Cup Holders after he saw the table with them. Here is the final product.</p>