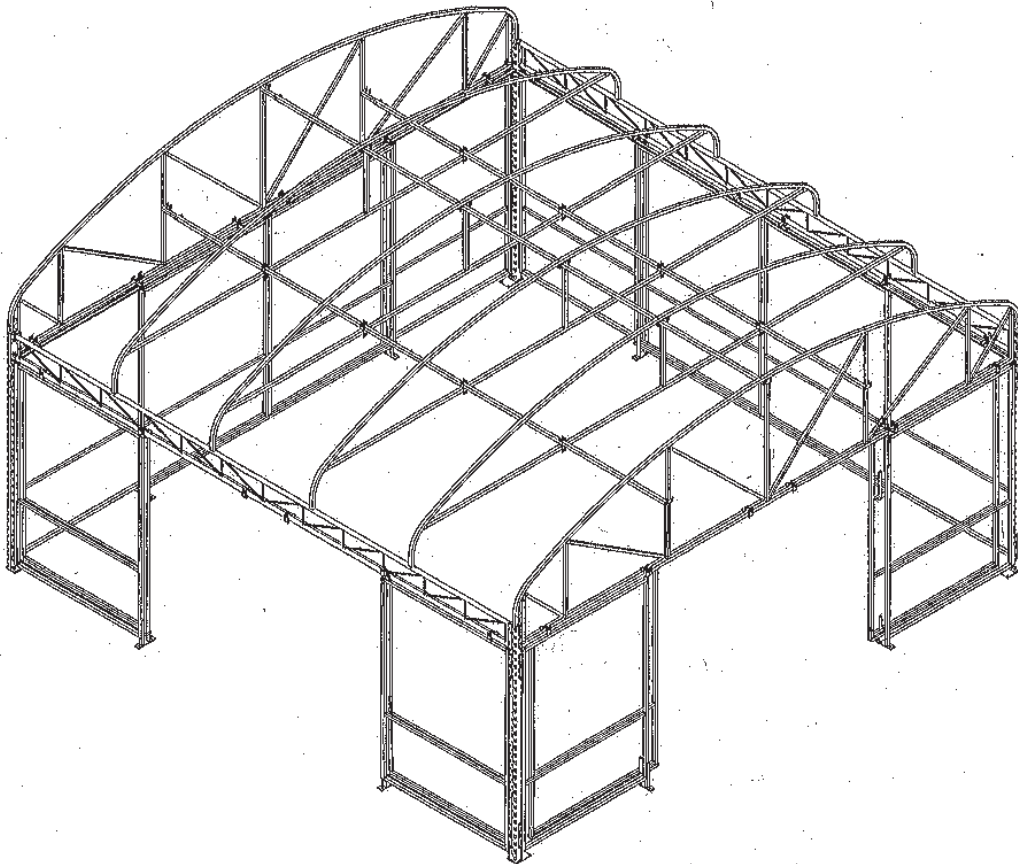




20' Round Vinyl Structure



INSTALLATION INSTRUCTIONS



20' Round Vinyl Structure

Parts List

- 24 - Truss Locks
- 38 - 5/16" x 2" Bolts w / Nuts
- 8 - Door Tracks
- 2 - Round Trusses
- 2 - Flat Trusses w / 4 Pegs
- 4 - Arches
- 8 - Ratchets
- 4 - Short Straps
- 500 - Large Tywraps
- 3 - Structure Support Purlins
- 3 - Inserts for Purlins
- 8 - Door Support & Guide Set
- 12 Truss Grabs
- 3 3/8" x 3/4" Bolts
- 4 Left fixed door frames
- 4 Right fixed door frames
- 8 Sliding door frames
- 1 Roof
- 2 Gable end covers
- 16 Door covers
- 2 1" x 3" Tubes

Questions?

Contact VRE @ (800) 499-4873 / (905) 945-8863 or Fax @ (905) 945-9294

20 X 20 ROUND STRUCTURE

INSTALLATION INSTRUCTIONS

(3/10/05)

1. Check parts list to ensure that you have all the desired components.
2. Lay out the Gable Truss. (See *diag. 1*)
3. Place ONE post on either side of the Gable Truss. (See *diag. 2*)
4. Insert the Truss into the top of the post, and tap in place to seat the TWO “Truss fingers” into the post slots. (See *diag. 3, 4, and 5*)
5. **IMPORTANT:** Insert locking “J” pin through hole in truss endplate and matching hole in the post. Tap “J” pin in place. Check that the pin is completely inserted. (See *diags. 6 - 9*)
6. Repeat steps 4 and 5 for the other side of the Truss.
7. Lay out the side Trusses. (See *diag. 10*) Place them on either side of the Gable Truss, and repeat steps 4 and 5. (See *diag. 11*)
8. Lift up the completed Gable Truss with posts. (See *diag. 12 and 13*)
9. Raise one completed side truss with one post, (See *diag. 14 and 15*). Fasten together, and repeat steps 4 and 5. (See *diag. 16*)
10. Repeat step 9 for the other side of the Gable Truss.
11. Attach the remaining Gable Truss to the posts. (See *diags. 17, 18, and 19*) Repeat steps 4 and 5.
12. Lay out the FOUR inside Trusses. (See *diag. 20 and 21*)
13. Lift them up, and sleeve them onto the tabs on the top of the side Trusses. (See *diags. 22 – 27*)
14. Square up the structure by measuring the opposite corner posts, and make sure that the measurements are the same. (See *diag. 28*)
15. Lay out the center ridge purlin. (See *diag. 29*)
16. Sleeve the insert and attach the bolt to the nut welded on the one end of the purlin. (See *diag. 30 and 31*)
17. Slide the cross purlin inside the trusses at the center of the structure from the Gable end. (See *diag. 32*)
18. Sleeve the “U” bracket welded on the end of the purlin to the side at the top of the Gable Truss. (See *diag. 33*)
19. Tywrap the purlin to the top of the center trusses to hold it up until you can get the truss grabs bolted in. (See *diag. 34*)
20. Sleeve the “U” bracket welded on the insert at the other end of the purlin on to the side at the top of the opposite Gable Truss and tighten the bolt. (See *diag. 35*)
21. If you do **NOT** have the **wall option** for this structure, continue at step 26.
22. **Wall Option:**
If you have the wall option, lay out the track on the ground in the desired locations for the doors. (See *diag. 36 and 37*) **NOTE:** There are TWO tracks per truss.
23. To install track, lift up the track and sleeve the “U” bracket onto the bottom of the truss, so that the rail is facing towards the inside of the structure. (See *diag. 38*)
24. Place the track on the bottom of the truss so it is centred between the center of the truss and the end. (See *diag. 39*)
25. Insert the bolt through the THREE “U” brackets so that the thread of the bolt faces into the structure and tighten. (See *diag. 40 and 41*)
26. Lay out the Gable fabric. (See *diag. 42*)
27. When installing the Gable fabric, be sure to have the folded seam facing into the structure. (See *diag. 43*)

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20 X 20 ROUND STRUCTURE

INSTALLATION INSTRUCTIONS

(3/10/05)

2

28. Determine the center of the curve and loosely tywrap to the center at the top of the Gable Truss. (See *diag. 44*)
29. Loosely tywrap the corners of the fabric (See *diag. 45*), and loosely for all the remaining grommets around the whole fabric. (See *diag. 46*)
30. Tighten the tywraps along the top arch, so that the fabric is just touching the bottom of the steel. (See *diag. 47*)
31. Tighten the tywraps along the bottom of the fabric, to pull the fabric tight. (See *diag. 48*)
32. Once the Gable fabric is tight, cut off the excess tywrap. (Leave at least $\frac{3}{4}$ tail for further adjustments.)
33. Repeat steps 26 – 32 for the other Gable.
34. Lay out the roof fabric on the ground (See *diag. 49*). Be sure to have the fold in the curtain facing down. (See *diag. 50*) **NOTE:** The ends with the belt sewn into it, is the Gable end.
35. Fold the fabric from one end to the other. (See *diag. 51*)
36. Lift the fabric over the top purlin so that the fabric is hanging evenly on both sides of the purlin. (See *diag. 52*)
37. Unroll the fabric from one side to the other. (See *diag. 53 and 54*)
38. Take the 1" x 3" tubing, (See *diag. 55*), and slide it into the pocket at the bottom of the fabric on both sides, so it sticks out evenly at both ends. (See *diag. 56, 57, and 58*)
39. Be sure to check that the tubing on both sides of the structure hang down evenly.
40. Flap the ends of the fabric with the belt sewn in, over the Gable Truss (See *diag. 59*).
41. Take the ratchet tightener (See *diag. 60*), and slide the end of the belt through the wheel of the ratchet (See *diag. 61 and 62*). Hook the other end of the ratchet to a hole in the post. (See *diag. 63*)
42. Crank the ratchet just enough to keep the belt from slipping out of the wheel. (See *diag. 64*)
43. Repeat step 40 for the other side of the Gable.
44. Crank the ratchet just enough to keep the fabric over the Gable Truss.
45. Repeat steps 39 – 43 for the other Gable end.
46. Take the ratchet tightener with the belt loop attached (See *diag. 65*), and slip it over the end of the 1" x 3" tubing, at all FOUR corners. Hook the other end into one of the holes in the post. (See *diag. 66, 67, and 63*)
47. Start **partially** tightening up the tension straps (1-2 clicks at a time is recommended) to ensure that the fabric stays centred.
48. Repeat sequence until the fabric is tight.
49. Tighten the belts holding the roof fabric over the Gable ends, the same way as the sides until the whole roof is tight (See *diag. 68*)
50. **Wall Option:**
If you have the wall option, lay out the solid wall sections at the desired locations. **NOTE:** There are 'left' and 'right' solid sections (See *diag. 69 and 70*). The side of the frame with the fingers that hook into the post, determines 'left' and 'right'. The cross bar that is welded into the frame should be close to the ground.
51. TWO inserts should sleeve into the frame on the opposite side of the fingers (See *diag. 71*)
52. The insert with a square tube, and a round tube, go into the bottom of the frame. Sleeve the square tube into the bottom of the frame. (See *diag. 72 and 73*). Be sure to have the round tube facing inside the structure. (See *diag. 74*)

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INSTALLATION INSTRUCTIONS

(3/10/05)

53. The insert with the “U” bracket welded on the end, sleeves into the top of the frame on the same side as the square and round tubing (See *diag. 75 and 76*)
54. Lift up the frame and mount it to the outside of the desired post. (See *diag. 77*). Tap down on the frame so the TWO ‘Truss fingers’ sit in the post slots.
55. **IMPORTANT:** Insert locking “J” pin through hole in truss endplate and matching hole in the post. Tap “J” pin in place. Check that the pin is completely inserted.
56. Lift up the top insert so that the “U” bracket goes around the bottom of the truss, insert a bolt and nut, and tighten. (See *diag. 78*)
57. Repeat steps 52– 56 for all the other desired wall frames.

58. Loosely tywrap the FOUR corners to the frame (See *diag. 80, 81, and 82*). **NOTE: Be sure to have the fold of the edge of the fabric facing into the structure.**
59. Loosely tywrap the remainder of the fabric to the frame (See *diag. 83*).
60. Slowly tighten the FOUR corners of the fabric keeping it square, and evenly spaced inside the frame.
61. Once the corners are tight, tighten up the rest of the tywraps until fabric is tight. (See *diag. 84*)
62. Cut off the access tywrap leaving a ¾” tail for future adjustments.
63. Repeat steps 58 – 63 for all remaining walls, (See *diag. 85*)
64. Lay out the doors. (See *diag. 86*). Then place the doors on something to raise it off the ground, to put the fabric on.
65. Repeat steps 59 – 63 for all doors. (See *diag. 87 and 88*)
66. To hang doors, stand the doors upright, with the welded “T” bracket on the top. Slide the “T” into the track from the center of the truss. (See *diag. 89 and 90*)
67. When sliding it open, be sure to have the bottom of the door slide in between the wall and the round pipe, attached to the bottom of the wall. (See *diag. 91*)

NOTE:

- (a) It is recommended that the structure be secured on location to resist wind and weather.
- (b) Cover **MUST** be removed **BEFORE** snowfall, as this unit is not designed for snow-load conditions.

WE, at VRE Systems, would like to thank you for your valued business!



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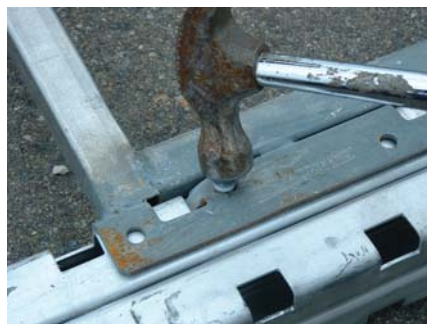
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