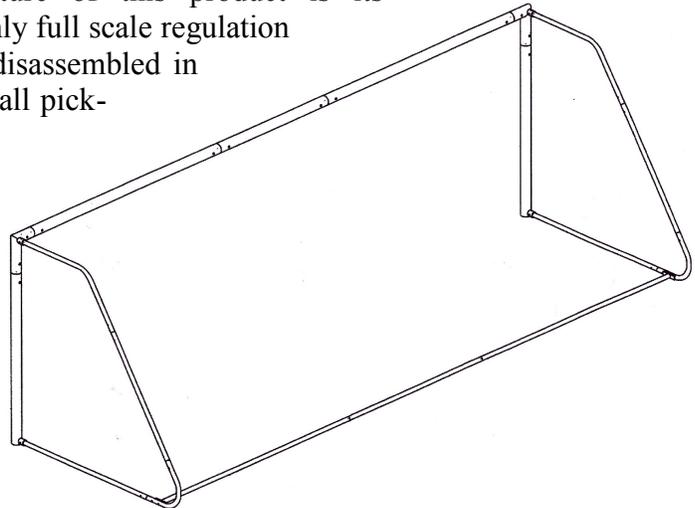


MASTER GOAL ASSEMBLY INSTRUCTIONS FOR 6 1/2' x 12' GOAL

Congratulations on the purchase of the MASTER GOAL. It is the most revolutionary goal ever developed for the game of soccer. This goal is manufactured with the highest degree of quality and will provide years of excellent service if reasonable care and proper maintenance are provided by the user. The most unique feature of this product is its storage/portability. The MASTER GOAL is the only full scale regulation soccer goal designed to be fully assembled and disassembled in only a few minutes to easily fit in a mini van, small pick-up truck or even a sport utility vehicle.

Open all boxes and examine all goal parts for damage. Use the following parts list for the goal you have purchased, to determine if you have any missing parts. Immediately contact the supplier, distributor, or manufacturer from which you purchased your goal if you find you have an incomplete product.



Refer to the following list for sizes and length of parts to help determine their locations during the assembly process.

Parts List

13 1/2" Heavy Expansion Clamp	5 each
4" Dia. Corner (Style "X")	1 each
4" Dia. Corner (Style "Y")	1 each
4" Dia. End Post	2 ea. (72")
4" Dia. Header Tube	2 ea. (60")
Back Stay - "Top" Corner	2 each
Back Stay - "Bottom" Corner	2 each
Back Stay - Angle Splice (with 2 swaged ends)	2 ea. (41")
Back Stay - Ground Runner Splice (with 1 swaged ends)	2 ea. (57 1/2")
Ground Cross Bar	1 ea. (73")
Ground Cross Bar with swaged end	1 ea. (76 1/2")
Back Stay Hardware	
Spring Buttons (packaged with backstay corners)	2 each
3/8 x 2 1/2" Allen Cap Screw	6 each
3/8 Flange Nuts	4 each
7/16 X 2 1/4" Allen Cap Screw	10 each

WARNING – WARNING - WARNING

This goal was designed to be used as a soccer ball goal, for the game of soccer only. Securely anchor soccer goal at all times, unsecured goals can fall over causing serious injury or death. Safety Warning Labels must be clearly visible. Never allow anyone to sit on, stand on, hang on, or climb on soccer goal and/or net, as they may break and/or fall over causing serious injury or death. Do not attempt to climb on goal while attaching net. Check structural integrity and connecting hardware before every use. All fasteners and fastenings must be checked to insure they are fully tightened before and after each use of this product. Replace damaged or missing parts or fasteners immediately and before using. When goals are not in use; remove net, tip goal on its face and securely anchor to ground or store goal in a secure area. Fully disassemble goals for seasonal storage. Assembled Soccer Goals must be anchored at all times and should never be left Unattended. Do not use soccer Goals in High Winds, Bad Weather, Natural Disasters or Lightning. Any modifications to this goal will void any warranties. Always instruct anyone who might come in contact with goal, on the safe handling of and potential dangers associated with movable soccer goals. Always exercise extreme caution when moving goals and provide adequate manpower and goals should only be moved by authorized personnel. Soccer goals should only be used on level fields and never on a hill or slope.

Assembly Instructions

Tools required:

1 ea. - Tape measure

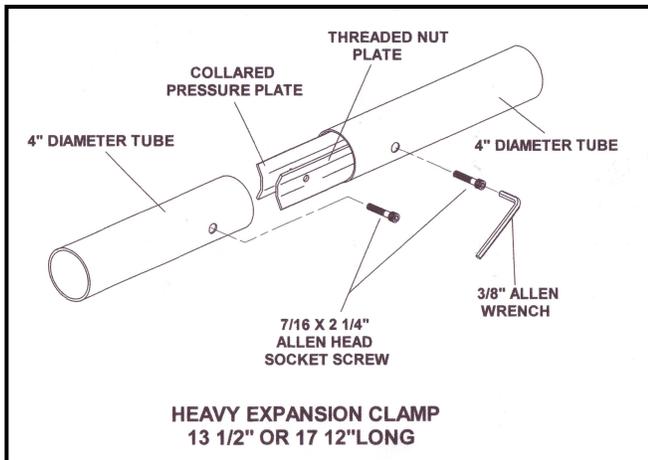
1 ea. - 3/16" Allen Wrench (Provided)

1 ea. - 3/8" Allen Wrench (Provided)

1 ea. - 9/16" Standard Wrench

STEP 1: Basic Expansion Clamp Assembly Method

The Goal you are about to assemble uses specially designed expansion clamps to join adjacent ends of all 4" tubes. Different length clamps may be used at different locations as indicated in the attached drawing diagrams. The basic concept is simple. The following illustrates the use of these clamps through out the assembly process.



Heavy Expansion Clamp (Used on 4" Diameter Main frame Tubes)

Important: There may be two (2) sizes of "Heavy Expansion Clamps" depending on the goal size you have purchased. To attach the ends and corners of the 4" diameter tubes together during "Main (Front) Frame" assembly, slide two halves of a heavy clamp halfway into the end of a 4" tube. Rotate the clamp or tube so the hole in the "threaded nut plate" is aligned with the hole near the end of the tube. Insert a 7/16 x 2 1/4" allen head socket screw through the hole and then into the threaded nut plate. Rotate clockwise until the allen head screw seats into the collar on the "collared

pressure plate". Do not completely tighten. At this time, slip the adjoining tube section over the remaining exposed end of the clamp and rotate the tube such that the hole near the end of that tube aligns with the hole in the "threaded nut plate". Use the 3/8" allen wrench to tighten this end of the clamp up all the way and then completely tighten the previous allen head screw up all the way.

STEP 2: Orientation of 4" Goal Front

Refer to the attached drawing. On a level area, lay all the parts out on the ground with all parts respectively located to each other and properly orientated. IMPORTANT: X and Y style corners must be orientated as show in Fig. 1. (**Long** side aligned with header tubes).

Refer to STEP 1 for expansion clamp assembly. (**Fig. 1**) With the "Y" and "X" corners properly orientated and face down, attach each of the main post to the short side of their respective corner using a 13 1/2" expansion clamp assemblies. Do not tighten any of the expansion clamps until all are in place.

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STEP 3: 4” Header and Post Assembly

(Fig. 2) Next, join the each of the three sections together that make up the header section, using the 17 ½” expansion clamp assemblies. Again, do not tighten any of the expansion clamps.

(Fig 1) Finally, attach the long side of the respective “X” and “Y” corners to each end of the assembled header. Adjust each of the tubes square and aligned to each other and to the corners and tighten all the cap screw socket bolts.

STEP 4: Orientation of Backstay Side

Top backstay corner is orientated with the **long** side angled down. (Fig. 4) Insert the spring button into the end of the short leg of the top corner as shown with the button towards the center of the goal on each side. (Fig. 3) The bottom backstay corner is oriented with the **spring buttons towards the center** of the goal and the **two holes** down towards the ground.

STEP 5: Backstay Assembly

Remove the protective plugs at the swaged end of each of the backstay splice tubes. **CAUTION: Do not allow the swag end of the splice tubes to become damage or deformed or they will not maintain a proper fit to their respective adjacent tube. Also, save the plugs for later use if the goal is disassembled for transport or storage.** With the corners properly orientated, attach the (backstay angle splice) and (backstay ground runner splice) to the respective ends of each of the top and bottom backstay corners.

(Fig. 5) With the front of the goal face down, insert the top and bottom end of the backstay assembly into the respective stubs at each of the 4” corner and 4” post bottom. Cross bolt into place using the provided 3/8” x 2 ½” cap screw and flange nut. Tighten the bolts at this time.

STOP!!! CHECK TO MAKE SURE ALL CLAMPS ARE TIGHT AND SECURE BEFORE PROCEEDING.

STEP 6: Ground Bar Assembly and Attachment to Backstays

Raise the front of the goal and attached backstays up into the normal playing position. (Fig. 6) Assemble the ground bar tubing as shown. (Fig. 7) Position the assembled ground bar and attach it to each of the bottom backstay corners using the provided 3/8” x 2 ½” cap screws.

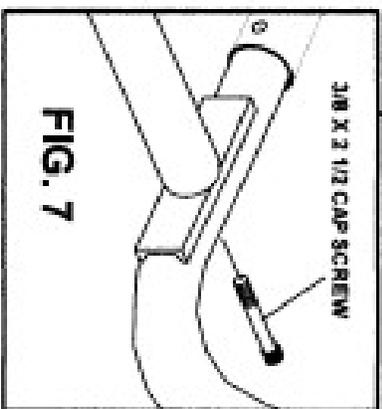
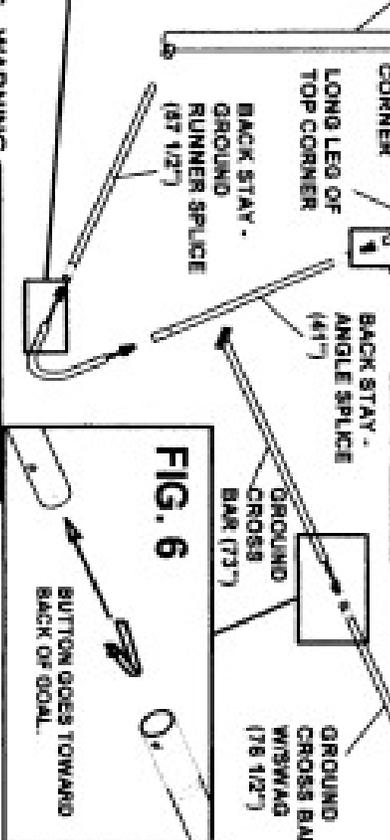
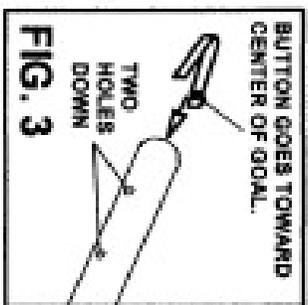
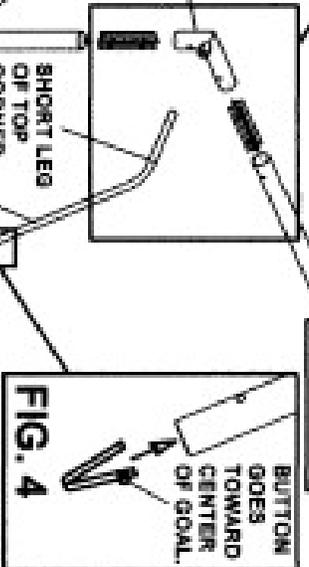
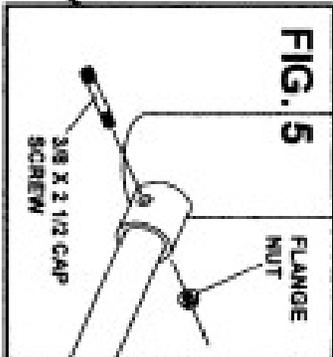
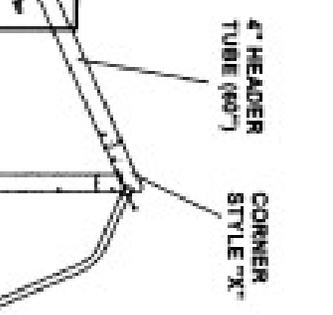
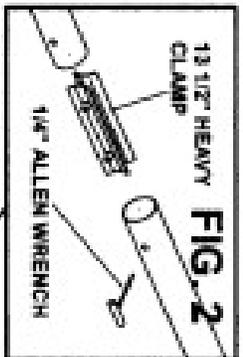
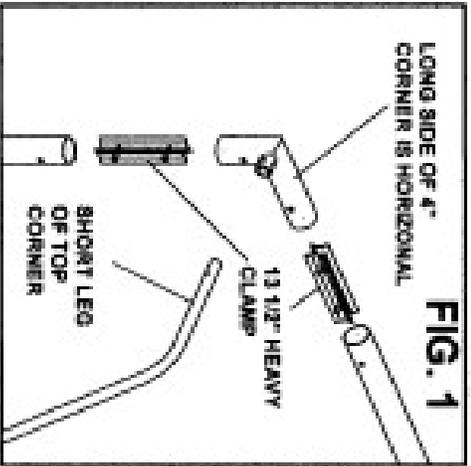
STEP 7: Net Attachment

Nets are sold separately. Follow the net attachment instructions provided with the type and brand of net being used for this goal.

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6 1/2' X 12' GOAL ASSEMBLY DIAGRAM



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The goal was designed to be used as a soccer ball goal, for the game of soccer only. Soccer involves soccer goals at all times, conventional goals are not designed for use as a soccer ball goal. Safety should be observed. Labels must be clearly visible. Never allow anyone to sit on, stand on, hang on, or climb on a goal or structure, as they may break under the overhanging section of the goal. Do not attempt to remove the goal or any parts of the goal. Check structural integrity and surrounding structure before every use. All fasteners and attachments must be checked to insure they are fully tightened before use. Check the use of this product. Always clean up or install parts in a clean area. Always use proper safety and caution when using. When goals are not in use, secure them to the back and always anchor or ground or store goal in a secure area. Fully assembled goals for outdoor use. Assembled soccer goals must be installed at all times and should never be left unattended. Do not use soccer goals at high winds, bad weather, severe weather or lightning. Any modifications to the goal will void any warranty. Always instruct users and always use proper safety and caution when using goals. Always use proper safety and caution when using goals. Soccer goals should only be used as goal posts and never as a ball or sign.