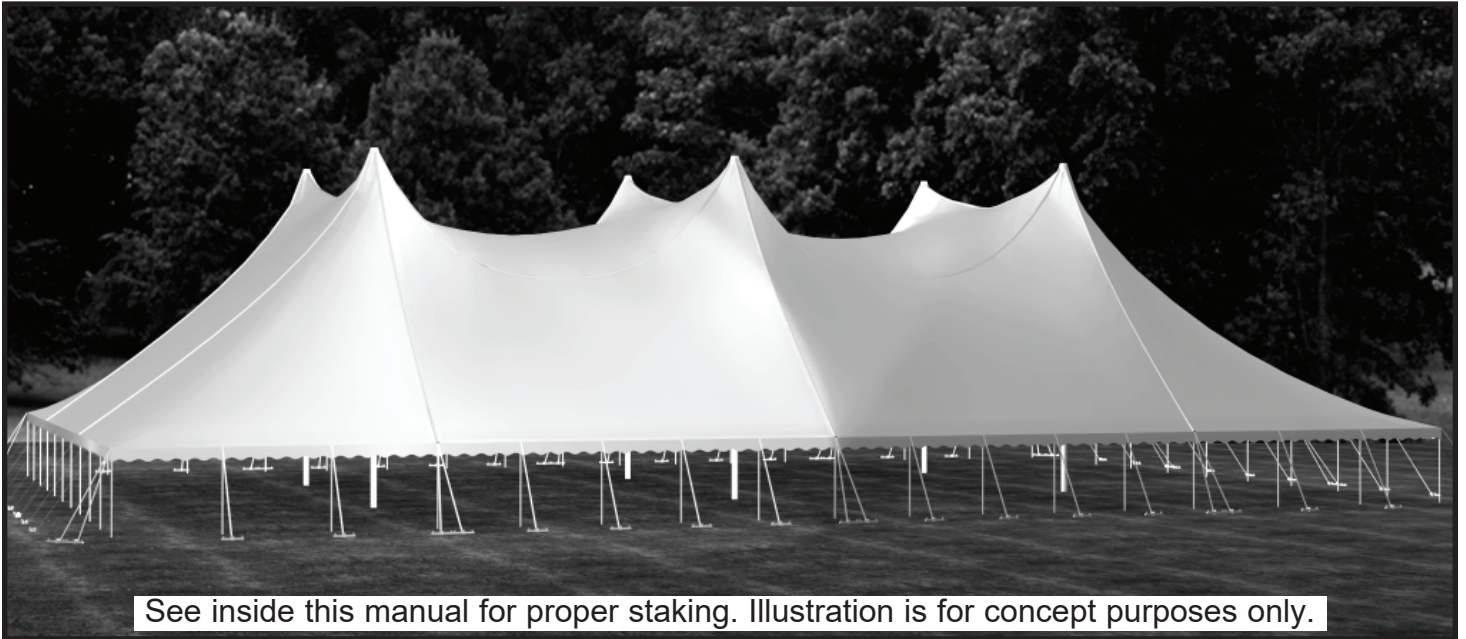


Installation Instructions

100' One-piece

Century® Tent

Non-Certified Installation



Please read all assembly / installation instructions before the installation or removal of this product.



7701 Highway 41 N
Evansville, IN 47725
Phone: 812-867-2421
Fax: 812-867-1429
1-800-544-4445
email: tents@anchorinc.com
www.anchorinc.com

IMPORTANT:

The installation of this Century Tent should be performed/supervised by knowledgeable tent installers with a clear understanding of safety issues as well as the methods of anchoring. The requirements as specified with blue print (supplied by Anchor Industries Inc.) must be followed. The installer/owner must read the assembly instructions completely prior to any installation. Particular attention must be given to anchoring! See Caution Statement on back page of this manual.

MANPOWER REQUIRED

Six experienced installers should be able to assemble a 100' x 100' tent in approximately six hours.

TOOLS REQUIRED

Sledge Hammers
Stake Driver
2 Measuring Tapes
Front End Loader

INSPECT SITE

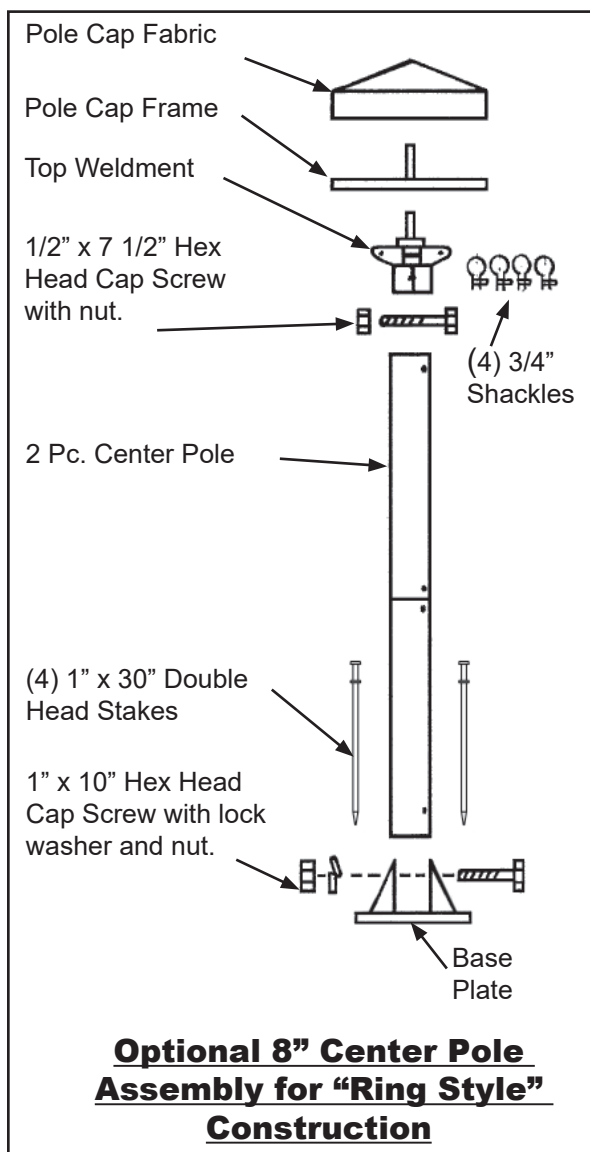
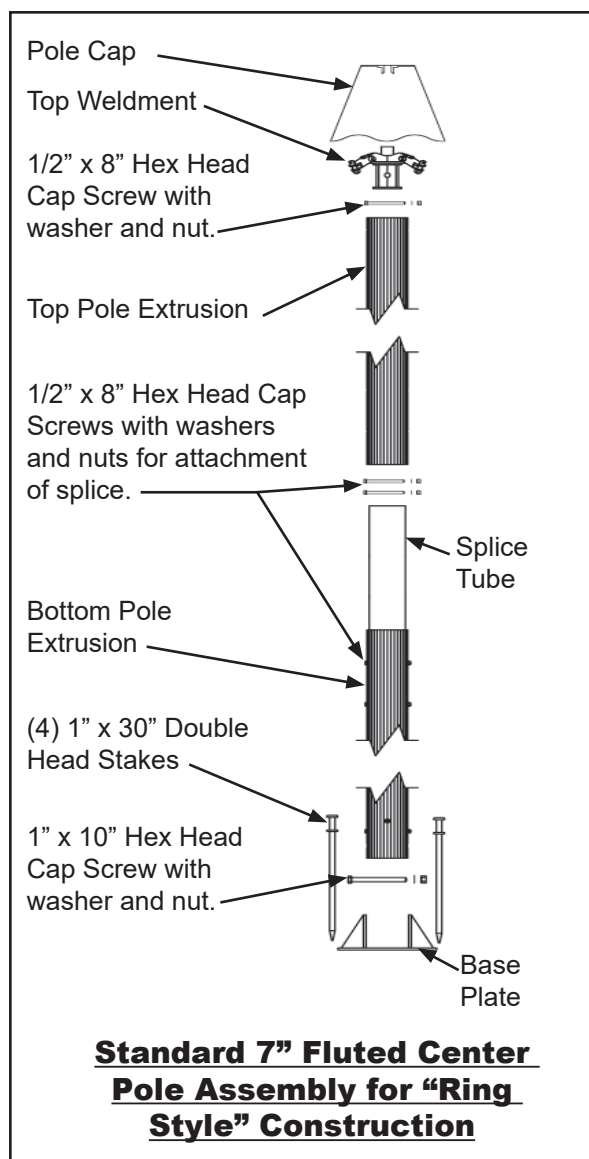
Caution:

Consult your local utility locator service or the National Utility Locating Contractors Association (NULCA) prior to installation. Prior to actual tent assembly, be sure to look up, down, above & below for obstacles, pipes, wires, trouble, etc.

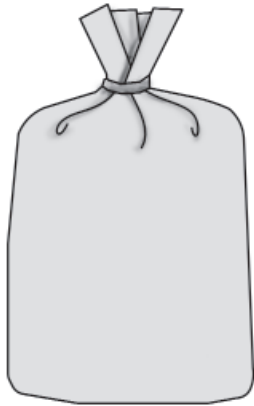
LAYOUT & CHECK

Utilize parts list for a quick I.D. and a check list to ensure that you have all the parts.

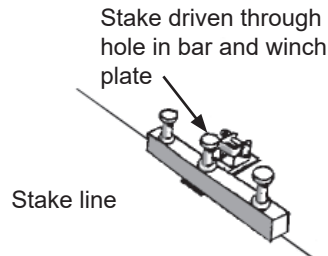
Parts Illustrations



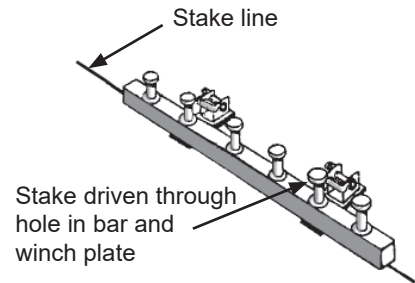
Parts Illustrations (cont'd)



Bag with Fabric
Section



2' STAKE BAR

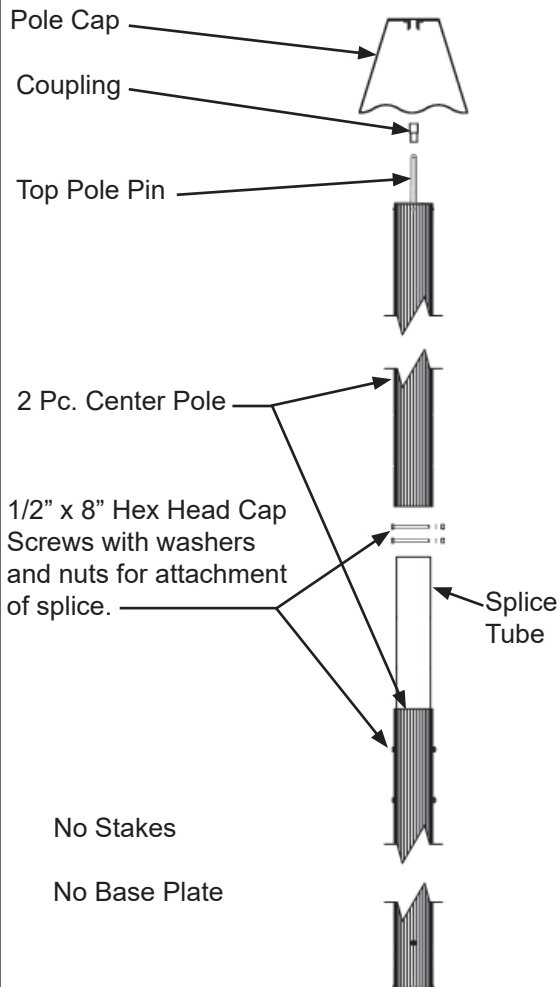


4' STAKE BAR



Maxi-Grip Flap
Tool - (1) per
Tent Section

PARTS	QUANTITY PER SECTION		
	END (PAIR)	30' MIDDLE	40' MIDDLE
BAG WITH FABRIC SECTION	2	1	1
CENTER POLE ASSEMBLY	2	2	2
SIDE POLE	32	6	10
SEE WEB GUY LAYOUTS & STAKING TABLES FOR STAKING REQUIREMENTS.			



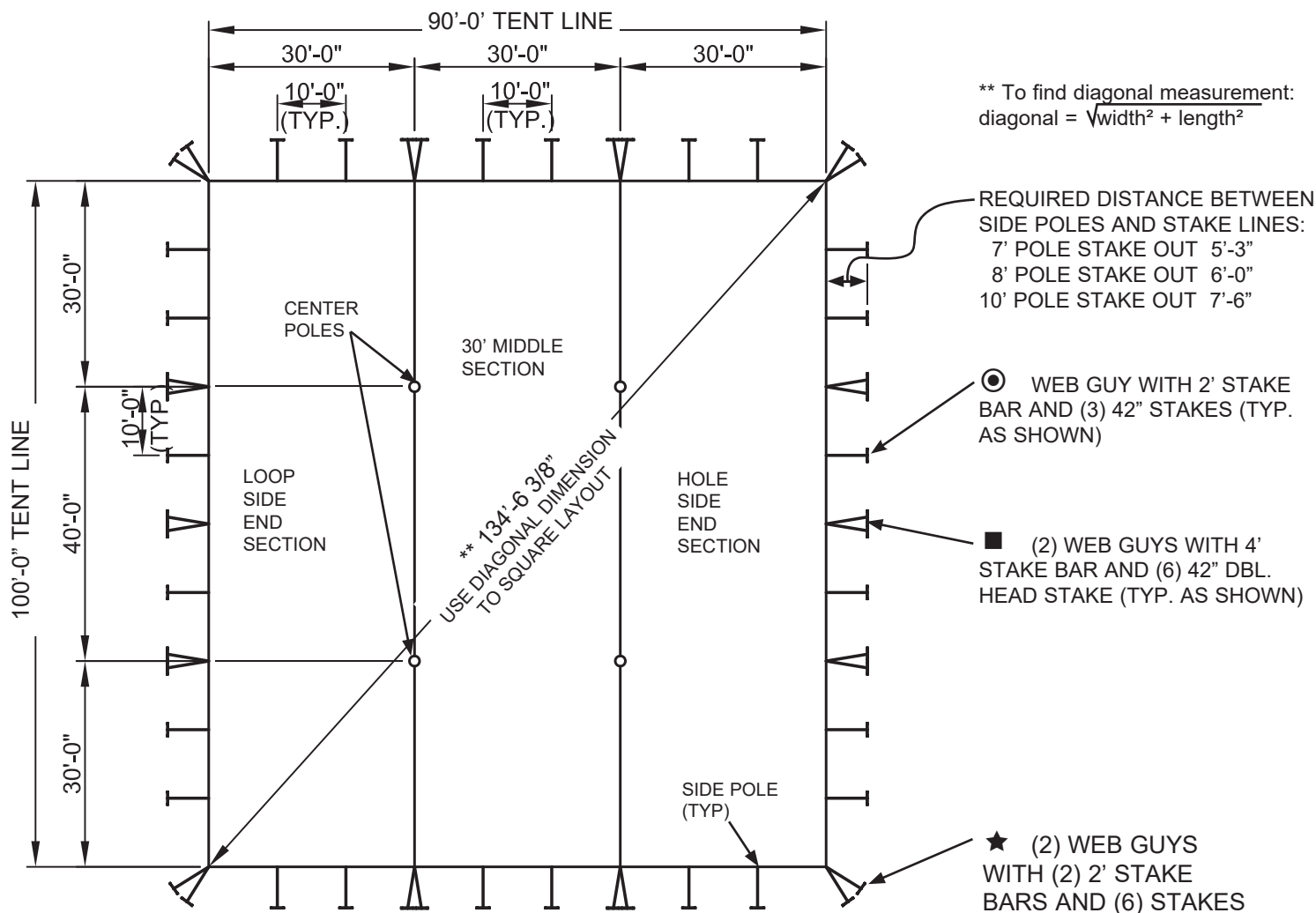
**Standard 7" Fluted Pole
Assembly for "Plate Style"
Construction**

APPROVED SIDE AND CENTER POLES		
	LENGTH	SIZE
Side	8'	Alum. 2" Sch. 40 Pipe Alum. 2 1/2" Sch. 40 Pipe Alum. 3" Fluted Alum. 3" Kedar Trac Fluted
	10'	Alum. 2 1/2" Sch. 40 Pipe Alum. 3 1/2" Fluted Alum. 3 1/2" Kedar Trac Fluted
	12'	Alum. 2 1/2" Sch. 40 Pipe Alum. 3 1/2" Fluted Alum. 3 1/2" Kedar Trac Fluted
Center	37'	Alum. 8" Ctr. Pole Assy. Alum. 7" Fluted Assy.
	39'	Alum. 8" Ctr. Pole Assy. Alum. 7" Fluted Assy.
	41'	Alum. 8" Ctr. Pole Assy. Alum. 7" Fluted Assy.

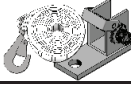

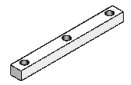
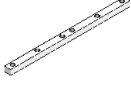

1 WEB GUY LAYOUT*

100' one-pc. (2) Ends with 30' Mid

MARK LOCATION OF STAKES, SIDE POLES & CENTER POLES



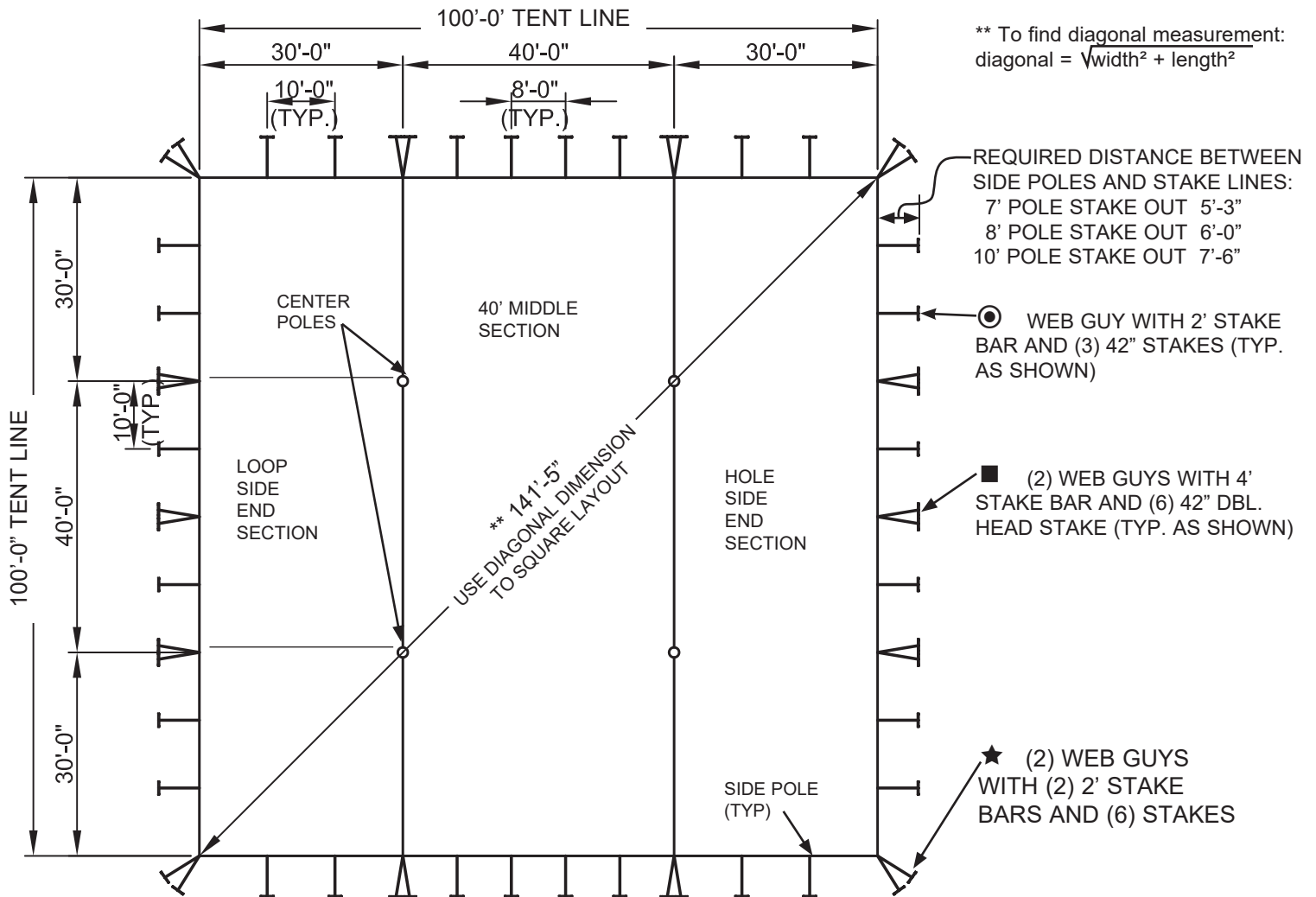
Staking Table

Illustration	Item No.	Description	Qty. for 100' x 60' (2) 30' Ends	Qty. for 30' Mid	Qty. for 40' Mid
	23000	Century Guy w/ Winch	44	8	32
	37020A 3704242 (over 25)	42" Double Hd. Stake	132*	24*	96*
	33000	2'-0" Stake Bar w/ (3) Holes	28	4	8
	33100	4'-0" Stake Bar w/ (6) Holes	8	2	12
	23100	Winch Tool	3	0	2

WEB GUY LAYOUT*

100' one-pc. (2) Ends with 40' Mid

MARK LOCATION OF STAKES, SIDE POLES & CENTER POLES



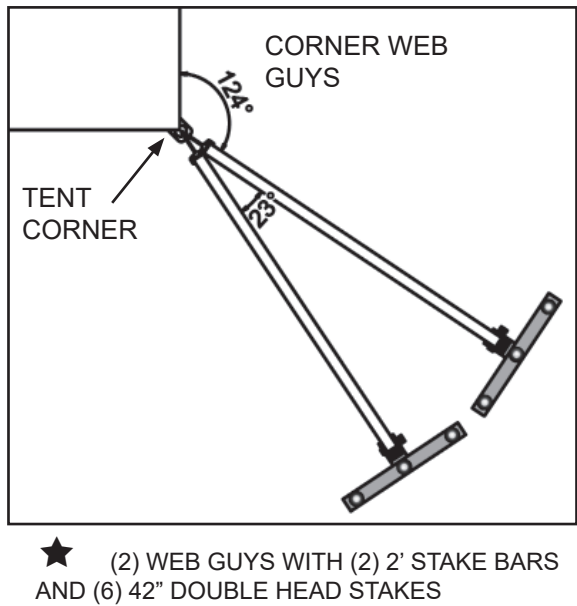
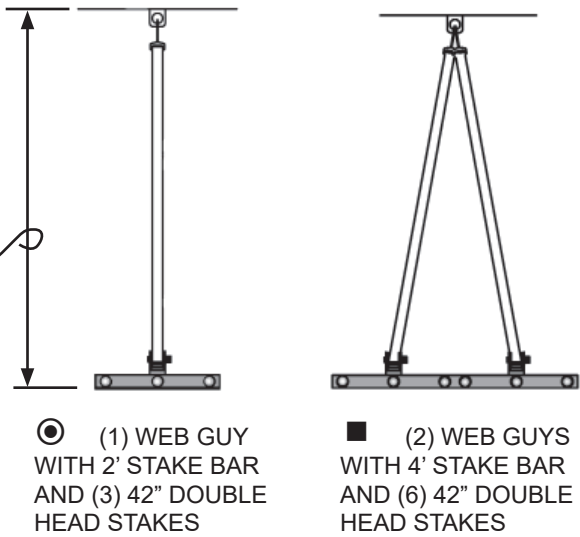
● ★ ■ SEE STAKING GUIDELINES ON NEXT PAGE.

*** IMPORTANT NOTE:** REFER TO CAUTION STATEMENT #2 FOR IMPORTANT WARNING ABOUT NUMBER OF STAKES SUPPLIED. (SEE BACK PAGE OF THIS MANUAL)

THE INSTALLER MUST USE THE LOCAL SOIL CONDITIONS TO CALCULATE THE ACTUAL NUMBER OF STAKES REQUIRED AND IS RESPONSIBLE FOR THE STAKING PATTERN AND CONFIGURATION. ANCHOR PROVIDES ANCHORING PACKAGES FOR COMMON SOIL CLASSIFICATIONS; CONTACT YOUR TENT SALES REPRESENTATIVE FOR MORE INFORMATION.

WEB GUY - STAKING GUIDELINES

REQUIRED DISTANCE
BETWEEN SIDE POLES
AND STAKE LINES:
8' POLE STAKE OUT 6' 0"
10' POLE STAKE OUT 7' 6"
12' POLE STAKE OUT 9' 0"



2 TENT LAYOUT

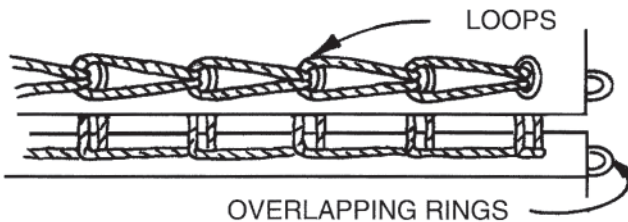
Drive stakes at points located. Each 2' stake bar requires (3) 42" double head stakes. Each 4' stake bar requires (6) 42" double head stakes.

Spread drop cloths and unroll tent.

Caution: Any objects with sharp projections which must remain on site under the tent should be padded and taped.

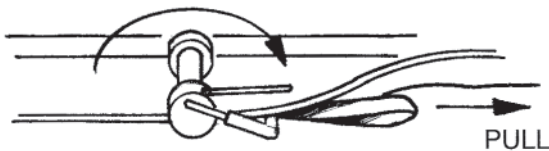
3 LACING

With tent sections on ground, overlap rings (or plates) at center pole holes with grommet side on top. Starting at end opposite long loop, lace between center pole holes first. Push first loop up through corresponding grommet.



Continue lacing process. Attach ridge snap to ring as you come to them. Tie off last long loop.

Cover lacing by joining protective flaps using Maxi Grip tool.

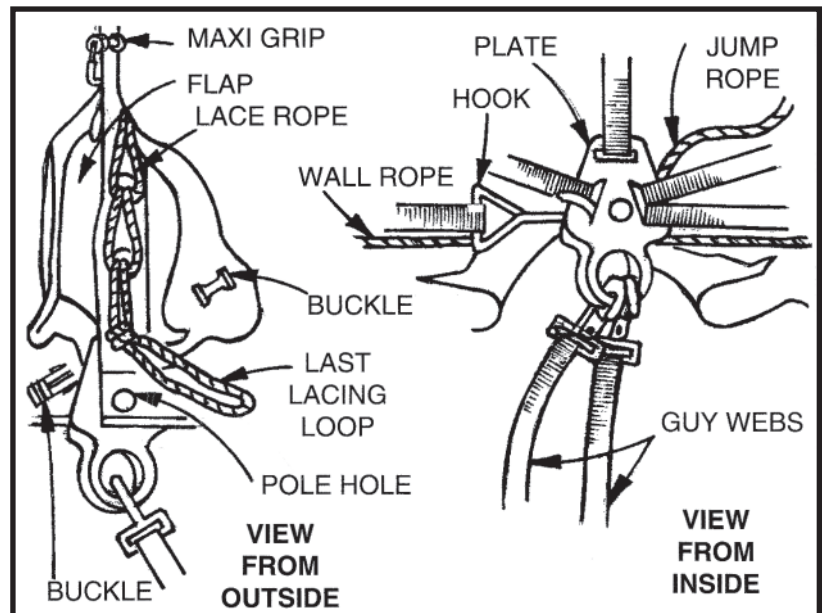
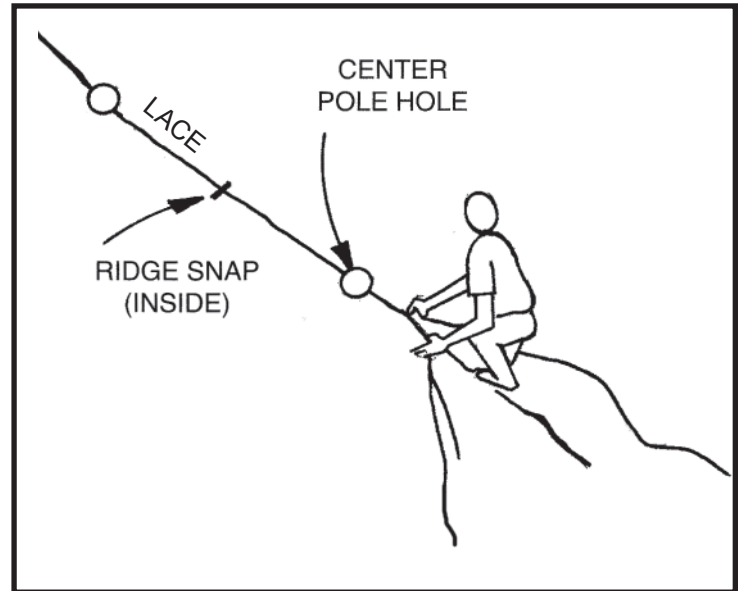


Secure flap with buckles at top and bottom.

Then lace from center pole to eave on both sides of tent. Tie off last long loop. Align plates and attach hook on inside of tent as shown.

Attach two guy webs through both plates.

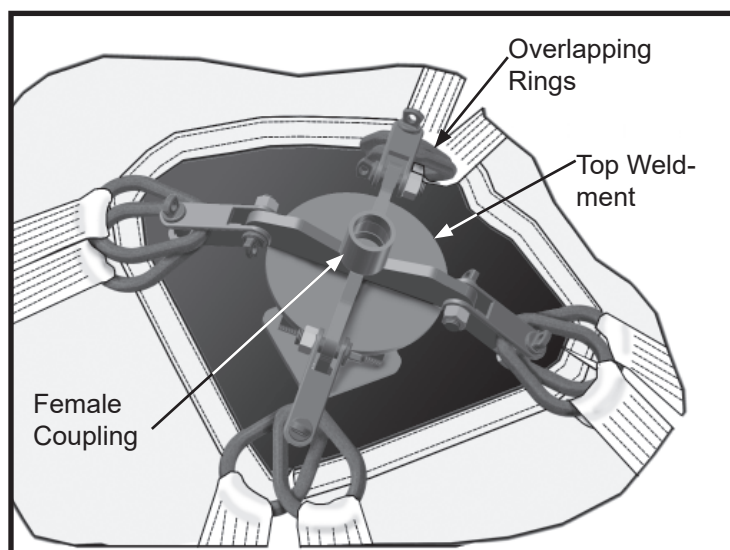
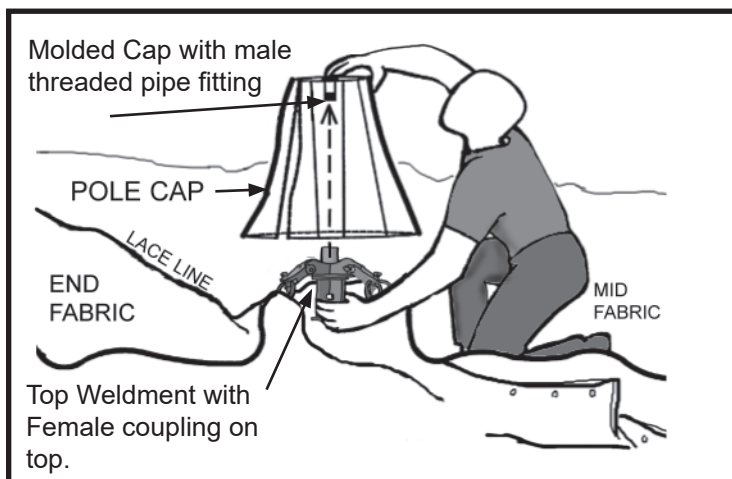
Lace all sections of tent.



4a CENTER POLE TOP WELDMENT FOR “RING STYLE” CONSTRUCTION

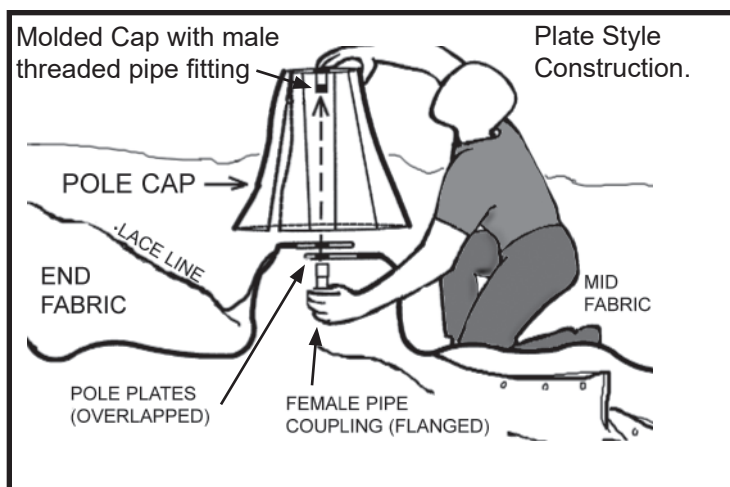
Set top weldment in center pole hole and connect to overlapping rings as shown.

Place pole cap over top weldment, and push fabric and weldment up into cap and secure from underneath by threading the female coupling onto the male pipe fitting molded to the inside top of the pole cap.



4b CENTER POLE TOP WELDMENT FOR “PLATE STYLE” CONSTRUCTION

Pole Cap - Overlap the pole hole plates in the mid and end fabric lace line. Push fabric and plates up into cap and secure from underneath by threading the female, flanged pipe coupling onto the male pipe fitting molded to the inside top of the pole cap.



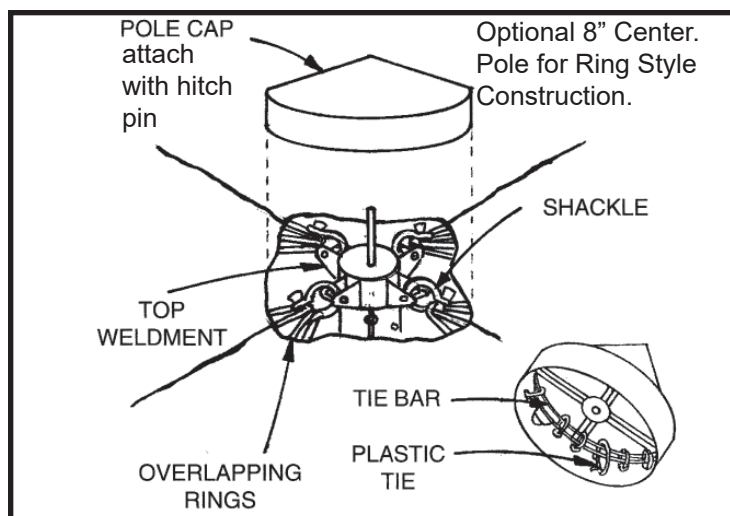
4c OPTIONAL 8” CENTER POLE FOR “RING STYLE” CONSTRUCTION

Set top weldment in center pole hole and connect to overlapping rings with shackles provided.

Place assembled pole cap over pipe of top weldment. Attach hinge pin to pipe extending through top of pole cap. Rotate pole cap to align holes in pipes.

Note:

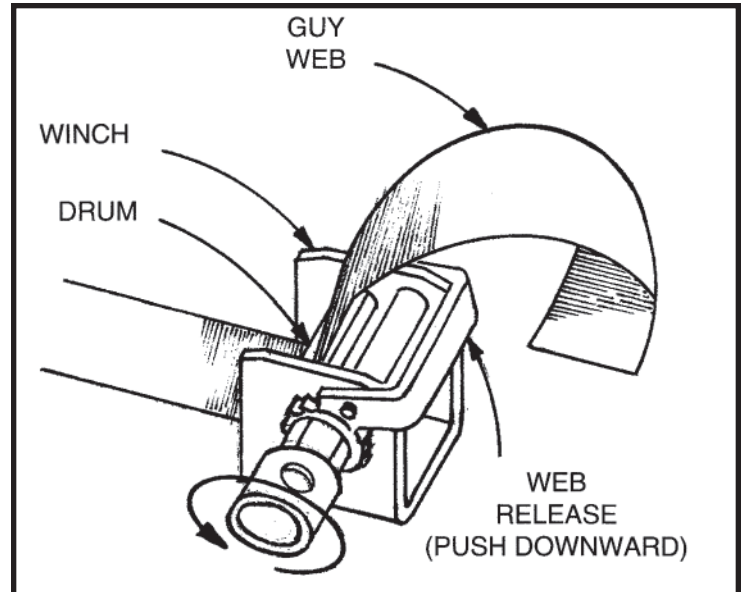
Pole cap assembly is illustrated on a separate sheet packed with fabric top.



5 Web to Winch

Insert guy web loosely into slot in winch drum, approximately 4'-0" for 8'-0" side pole and 1'-6" for 10'-0" side pole.

Rotate drum 1 1/2 to 2 times to secure web.
Repeat at all guy web locations.



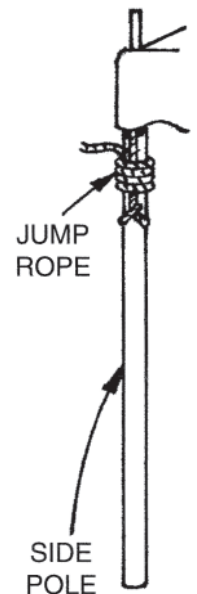
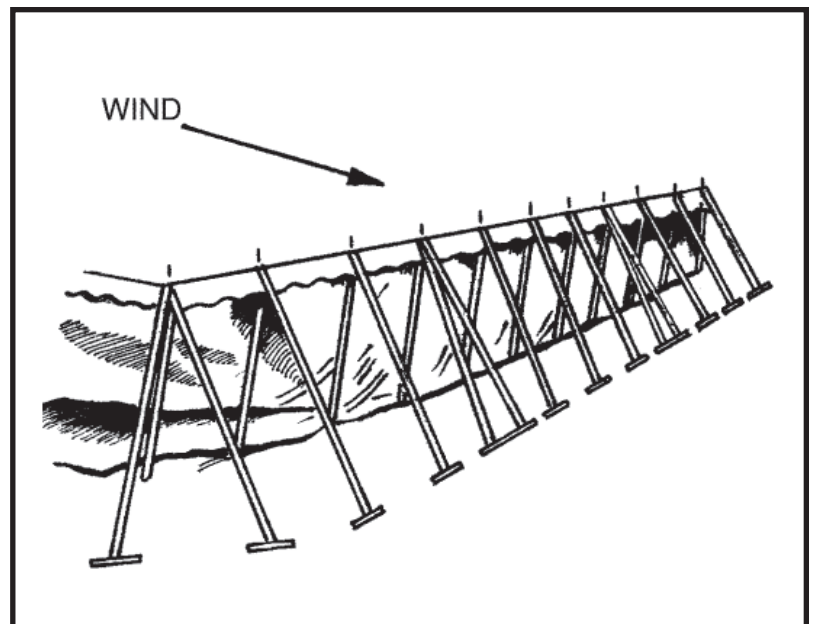
6 Raise Side Poles

Start at side opposite wind. Insert each side pole pin into side pole hole and raise slightly less than perpendicular. Bottom of each pole should be pointed inward toward center of tent.

Wall ropes are to be outside of corner and side pole.

Tie jump rope around each side pole as it is inserted in pole hole.

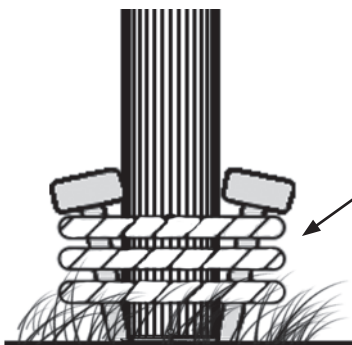
Continue around tent.



7 Raise Center Poles

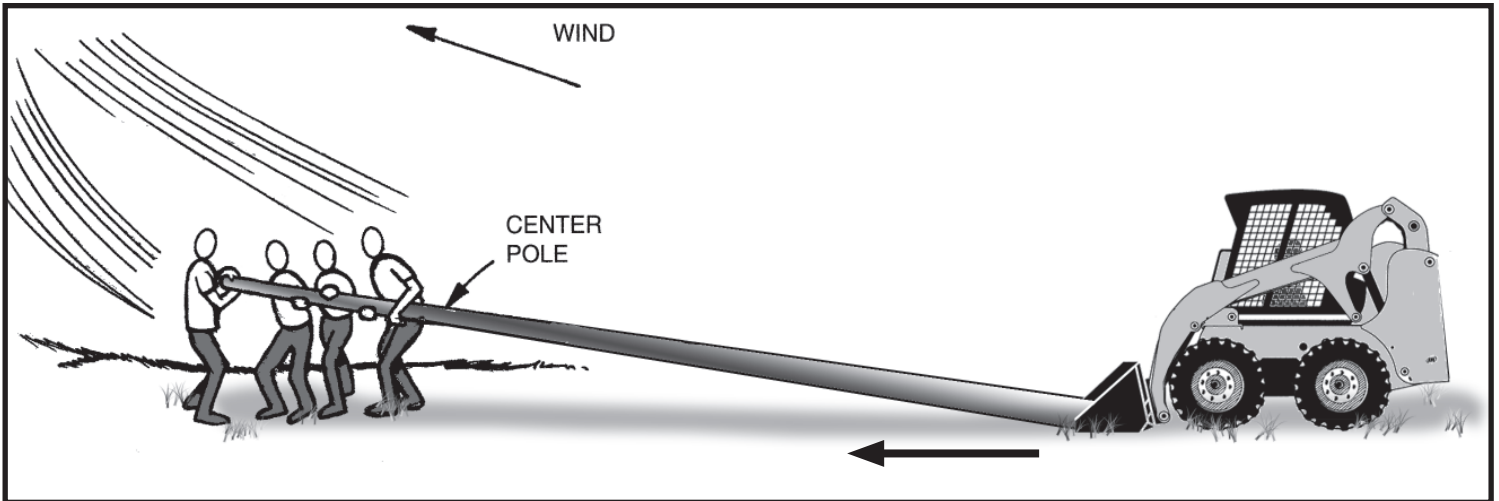
Important Information to prevent/minimize tent damage prior to center poles being erected.

1. Traditionally, raising all side poles prior to pushing center poles is acceptable, however, during a **high wind install**, only raise the side poles as needed on the side of the tent that the center poles are being pushed from. This helps to eliminate wind damage.
2. If wind is high, pre-drive a stake at center pole locations and use a rope to tie the center pole weldments down to prevent the wind from picking them up and damaging the fabric.
3. Care should be taken not to place anything under the fabric that can be rubbed against. We recommend a short saw-horse type of device to set the pole to working height during installation of the top weldments. Nothing should be used that is higher than head height to the crew working under the fabric. The top weldments should never be allowed to support the center pole when lying on the ground. Something should always hold the top of the pole off the ground.
4. The center poles should always be pushed up in a direction parallel to the length of the tent. The center poles should always be pushed from the 100' side. This puts the longest lace line curve in position to minimize fabric damage and stress on the maxi-grip flaps.
5. All center poles should be assembled and pre-positioned in order to speed the process of erection. The fabric is most vulnerable to damage during the installation process. Anything (in a safe manner) possible to speed the process should be done.
6. Center poles should be positioned as closely as possible to the orientation that they will be pushed in. Rotation of the poles once attached to the top weldments should be avoided.
7. Sudden stresses to the poles and fabric should be avoided. When disengaging the center pole base plates from the forks of the erection equipment, care should be taken not to have a sudden drop of the poles as may happen when the base plate is allowed to slide off the forks when the forks are raised off the ground.
8. Once center pole erection is begun it should not be stopped until the tent is tensioned.
9. Maxi-grip flap connections should be double checked prior to raising the first pole. This is especially important if there has been wind and the fabric has flexed considerably.
10. Fabric bunching around the top of the center poles during installation should be avoided. This is especially important on the maxi-grip lace line locations. The fabric flexing and popping into position when placed in this condition puts a lot of stress on the maxi-grip and it is hard to notice any opening in the flap. Extra care should be taken here.
11. The actual erection sequence of poles is somewhat dependent of the type and quantity of equipment that is available. With one piece of equipment it will be necessary to partially raise a pole and temporarily stake that pole to prevent movement, then relocate the equipment to push an adjacent pole, then return to the first pole. Base plates should be kept flat on the ground at all times.
12. Care should be taken to avoid as much stress on the fabric as possible. The stress can be minimized if poles are pushed up in a manner that reduces dragging of poles as much as possible.



CAUTION: For Tents using **Center poles with No base plates**, it is required to properly anchor bases of all Center poles to prevent movement after Center Poles are raised.

7 Raise Center Poles cont'd



Assemble center poles with base plates (where applicable). Raise center poles with top pointing downwind. With bottom of center pole in bucket of front end loader, slowly guide top of pole under tent with installers as shown.

For Ring Style construction, connect top weldment to pole with bolt, washer, and nut at center pole hole.

For Plate Style construction, insert top pole pin into female coupling at center pole hole and tie jump rope to pole to prevent pole pin from dislodging while raising pole.

Continue guiding top of pole to prevent snagging of fabric. Raise top of pole as high as possible by hand while moving forward with loader.

Set base plate down approximately ten feet from center pole position previously marked. Drive two 30' stakes through holes in plate.

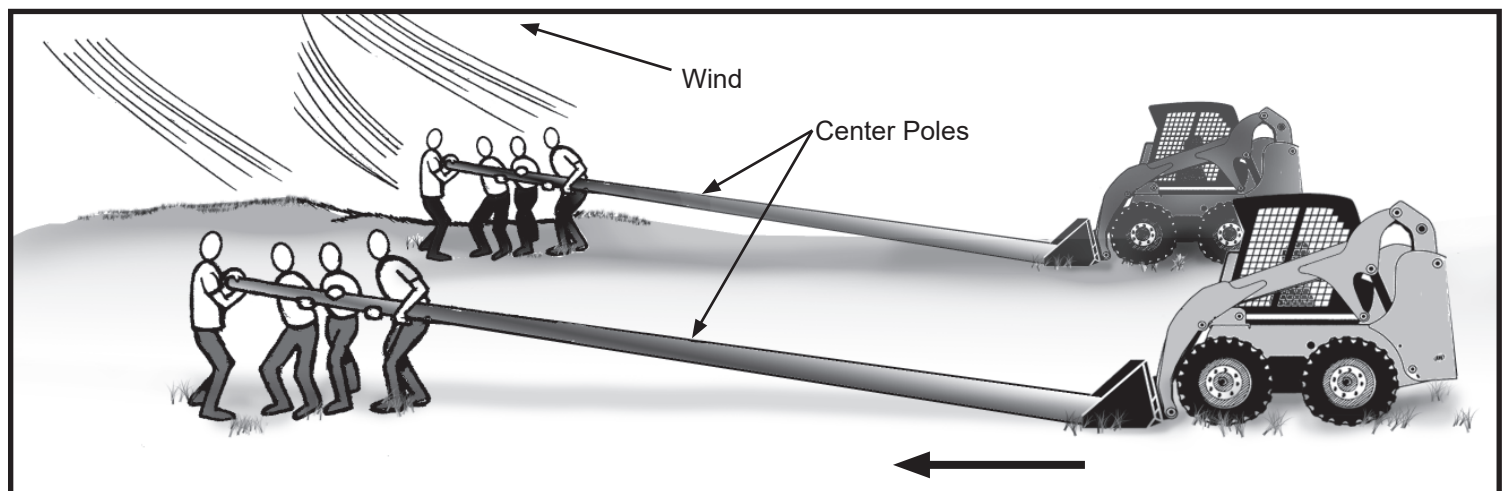
Repeat with other poles. Placing bottoms of poles at locations previously marked. When in position, drive four 30" stakes through holes in base plate.

Reposition first pole to vertical position and stake.

With 120' tent, raise a short pole to a slant and stake. Connect long pole (of same set) to top weldment. Do not raise. Raise other short pole (of same set) fully and stake.

Then raise long pole and stake. Repeat for other set(s) of center poles.

Alternate method raising Center Poles using Two loaders



Having two loaders available can make installation faster and easier.

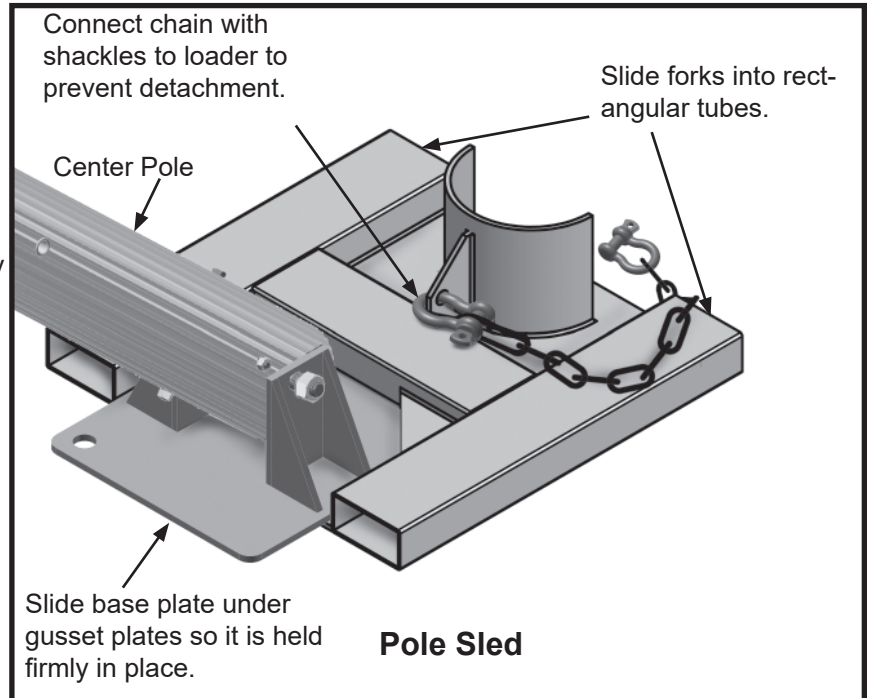
Using the same method just mentioned, the two center poles can be raised simultaneously without the requirement of setting the baseplates 10' from final vertical position.

Alternate method using Pole Sled (for use with fork truck or front end loader with pallet fork attachment).

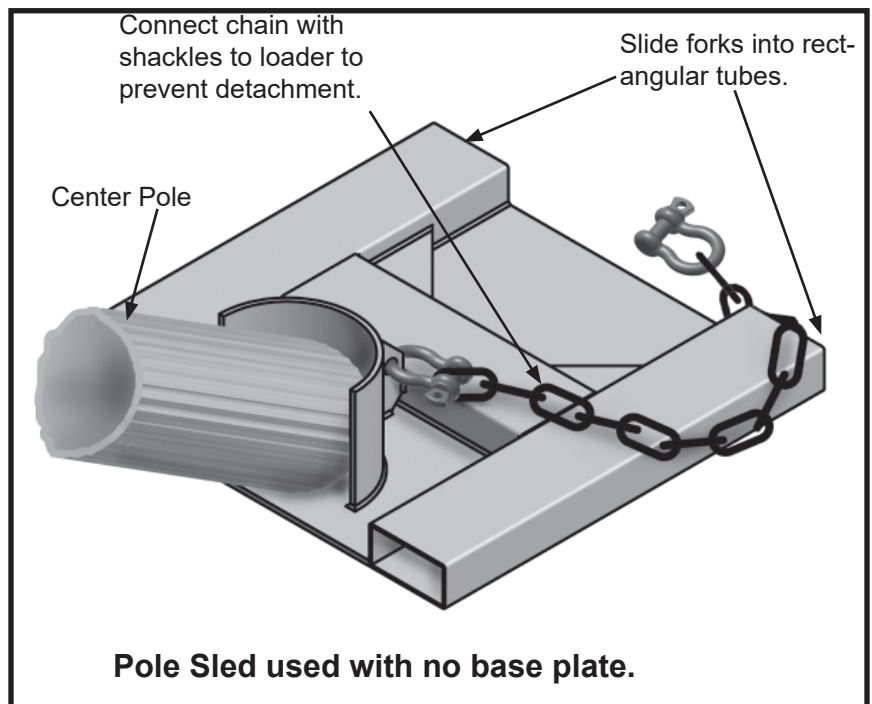
Using the pole sled makes it possible to keep the center pole steadily attached to a loader with pallet forks.

The pole sled may be turned to be used with base plate or curved plate for pole with no base plate.

The tent is still put up in the same manner as already outlined.



Pole Sled must be purchased separately.



8 Tension Guy Webs

Tension webs at laces that are parallel with the width of tent first and then at corners.

Next, tension guy webs at middle(s).

Work around the tent in a balanced manner so that tent is tensioned as evenly all around as possible.

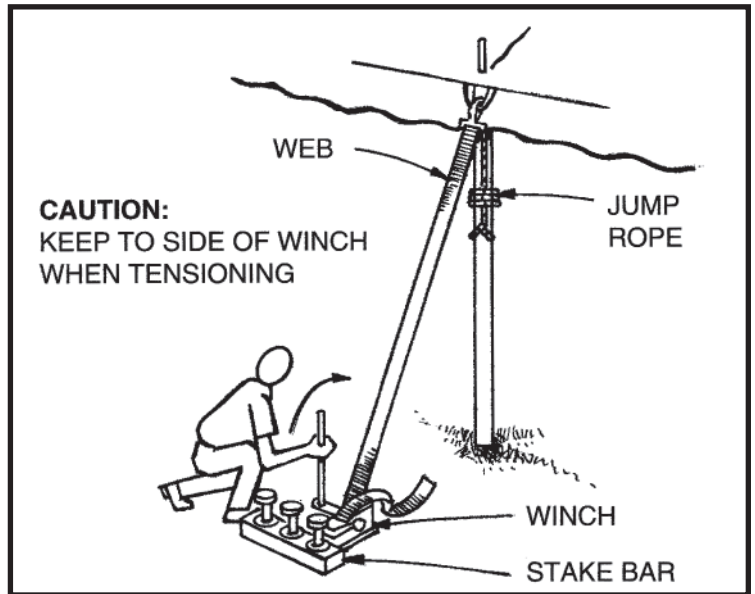
Caution - DO NOT OVER-TENSION TENT BEYOND EAVE LINE.

Tension remaining guy webs.

At one side pole at a time, release winch tension and place bottom of poles at previously marked eave line location.

Insert guy web into winch. Pull excess through winch. Tension as needed using winch bar.

Do not use extenders on winch bar tool.



9 Final Side Pole Adjustment

With side poles standing vertical and bases at the marked side pole locations for the footprint, ratchet webs to tension the top evenly.

Protective covers are recommended for all stakes and stake bars.

10 Take Down - Use Extreme Caution Removing All Poles

1. Spread ground cover.
2. Release tension on all web guys.
3. Slant side poles inward - slowly and carefully.
4. Remove center and side poles.
5. Reverse installation steps.

IMPORTANT:

Check Guy Webs periodically for tightness and good condition.

Store tent in a cool, dry area. Never store while wet or damp.



PHONE NUMBER

812 · 867 · 2421

FAX NUMBER

812 · 867 · 1429

Anchor products are of superior design and operate best within the parameters of these instructions. It is imperative that the instructions be carefully read and **COMPLETELY FOLLOWED**. Please read installation instructions before the installation or removal of this product. Installation instructions are available online at www.anchorinc.com or by calling 1-800-544-4445.

CAUTION:

1. For each installation, the installer is solely responsible for evaluating the site and the proper securing method determined. Some soils require different staking or securing than that provided with the tent. Due to this variety of soil conditions, these are the manufacturer's suggested sequence of installation procedures. Anchor's responsibility is limited to the manufacture of the tent parts and materials. We are not responsible for methods that installers may choose to erect and secure the tent to the ground.
2. The number of stakes suggested in the installation instructions do not necessarily meet all or any relevant codes on the site of the tent installation. The number of stakes suggested **will, in many cases, keep the tent erected**, however, due to various soil conditions; these stakes will be insufficient **to keep the tent secure in high winds**. It is the tent installer's responsibility, not the manufacturer, to determine the appropriate number of stakes to meet the necessary wind loads on the site. Regardless of the number of stakes we suggest, we make no representation or warranty as to whether this specific number of stakes will meet the local tent code. Anchor does not, nor can it make any suggestions, representation, or warranties about the adequate staking required at each specific installation site. Staking information provided in the installation instructions **is not a suggestion about what is necessary to meet a site-specific load**.

For additional important information, consult: "The IFAI Procedural Handbook For the Safe Installation and Maintenance of Tentage" and the IFAI Pocket Guide "Pullout Capacity of Tent Stakes", both available from the IFAI Tent Rental Division on their website (www.ifai.com).

3. Inasmuch as the weather is unpredictable, good judgment and common sense must be incorporated within installation guidelines. It is the responsibility of the tent installer/maintainer to determine the severity of the weather, proper time and method of installation and/or erection and disassembly. **Note: We recommend that snow and ice be removed from the tent surface as soon as possible because accumulation will damage the tent or fabric structure. Please consult with our Engineering Department about the maximum loads for each product.**

This product has been manufactured for use as a temporary structure. For the safety of all occupants, evacuation is recommended if threatening weather occurs, or if there is any doubt concerning the safe use of this product.

4. Proper safety equipment should be used at all times to insure a safe installation and take down. We suggest a careful evaluation be made to determine safety equipment needed, such as hard hats, steel-toe shoes, safety glasses and other as required. It is our desire that all installations are safe. Please be aware of hidden dangers both underground, i.e., gas lines, water lines, electrical lines, etc. and above the tent such as power lines and telephone lines.
5. Anchor stands behind its products in accordance with its standard Terms and Conditions of sale. A copy of our Terms and Conditions of Sale can be obtained by contacting Anchor at the telephone number and/or address on this document.