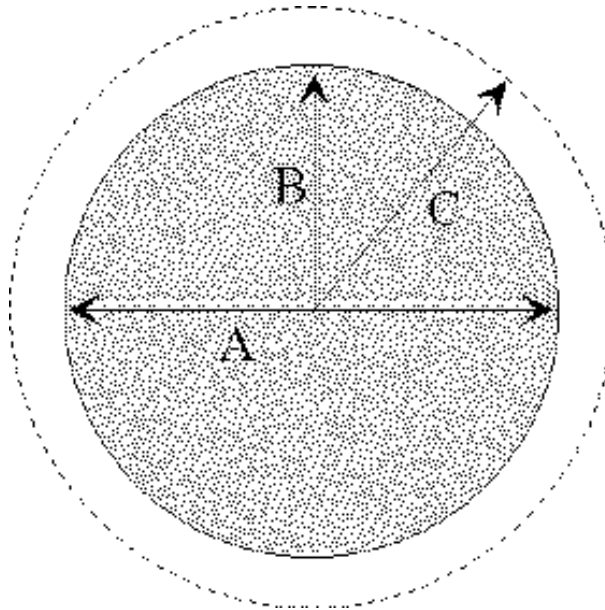


Round Installation Instructions

Warning:

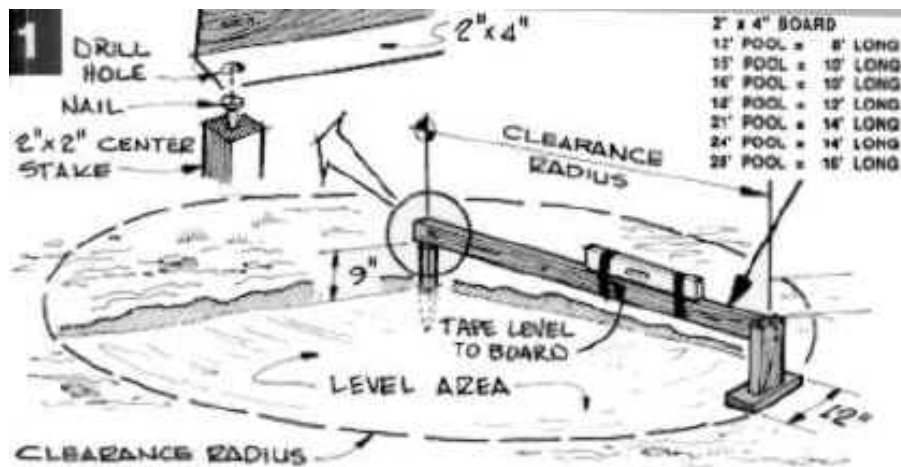
We have purposefully hidden the secrets to the installation in the text !!!!

For a "DO IT RIGHT THE FIRST TIME" installation, put someone in charge of following the directions !!!

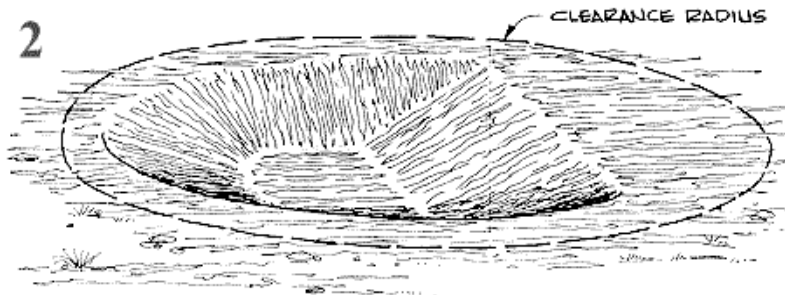


Pool Layout Dimensions

Size	A=Diameter	B=Radius	C=Clearance Radius
12'	12'	6'	7'
15'	15'	7'6"	8'6"
16'	16'	8'	9'
18'	18'	9'	10'
21'	21'	10'6"	11'6"
24'	24'	12'	13'
28'	28'	14'	15'

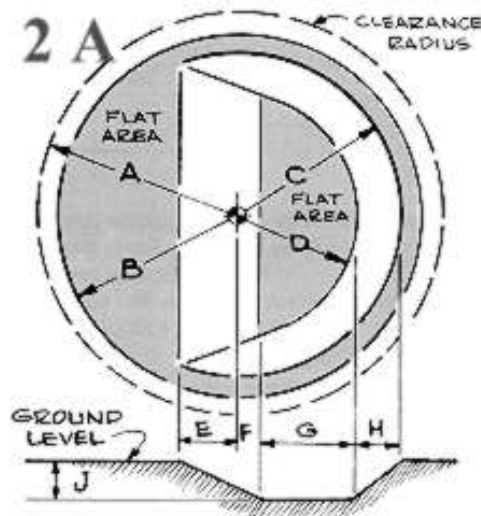


Refer to POOL LAYOUT DIMENSIONS for your diameter. Drive stake into ground at pool center. With a shovel and the constructed depth leveling tool shown above, remove sod and level pool area. *Level to the lowest spot within circle. Remove high points--do not fill in low spots. Ground must always be firm.* Be sure pool area is free of stones, sticks, roots and other objects that could puncture liner. Remember: The entire assembled pool framework must sit on flat ground within 1 inch of level at opposite sides. Spend additional time now to avoid disassembly later.



Optional Special Purpose Deep Swimming Area only
For Underwater Swimming Only, No Diving, No Jumping !!!!!

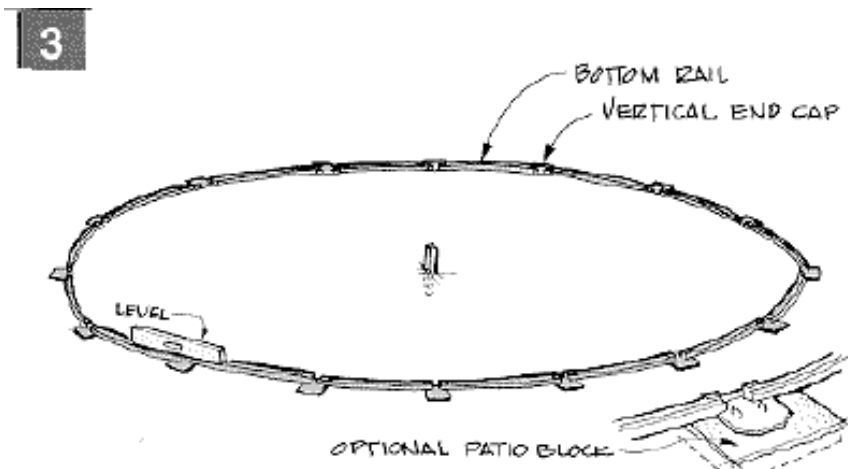
Deep Swimming Area: You may desire to gradually excavate down the center of pool, starting from 18" from the inside edge of the pool wall down to a maximum of 18" at center (NOT SHOWN). Or, excavate a deep end (illustrated above) using chart.



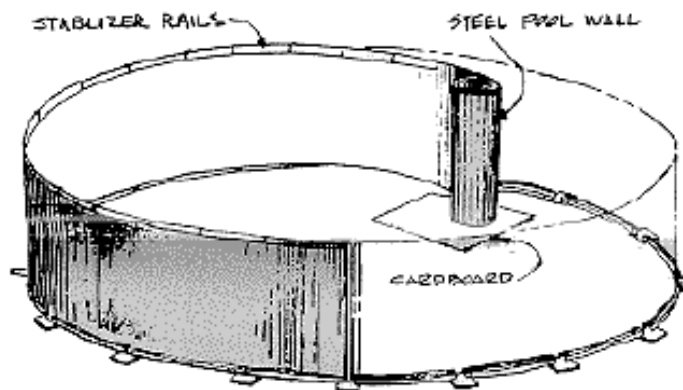
Size	<u>12'</u>	<u>15'</u>	<u>16'</u>	<u>18'</u>	<u>21'</u>	<u>24'</u>	<u>28'</u>
Fig							
A	7'	8' 6"	9'	10'	11' 6"	13'	15'
B	6'	7' 6"	8'	9'	10' 6"	12'	14'
C	5' 3"	6' 9"	7' 3"	8' 3"	9' 9"	11' 3"	13' 3"
D	2' 3"	3' 6"	4'	4' 6"	5' 6"	7'	9'
E	3' 6"	4'	4'	4'	4'	6'	6'
F	1'	1'	1'	2'	3'	3'	3'
G	1' 3"	2' 6"	3'	2' 6"	2' 6"	4'	6'
H	3'	3' 3"	3' 3"	3' 9"	4' 3"	4' 3"	4' 3"
J	1' 6"	2'	2' 6"	3'	3'	3'	3'

ONLY 20 MIL LINERS OR THICKER

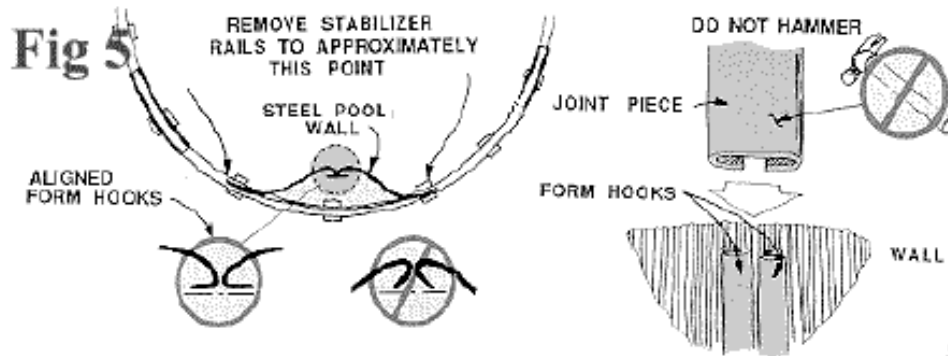
Using center stake as reference, lay out area to dimensions from table and excavate. Remember: **DO NOT DIVE OR JUMP** into the pool. Excavation is intended to provide a deeper and wider swimming area **ONLY**



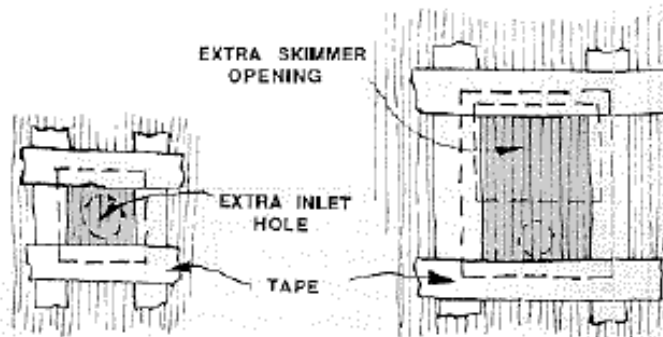
Mark out pool radius. Construct bottom framework. Form a circle by sliding bottom rails (groove up) into vertical end caps against stop (bottom connector on Aqualine pool). Confirm levelness of installation by placing level on top of bottom rails. Check around the circle to be sure ground is flat and within 1" of level at opposite sides. Remove all stakes. Note: Patio blocks are optional. If used be sure the top surface is at ground level.



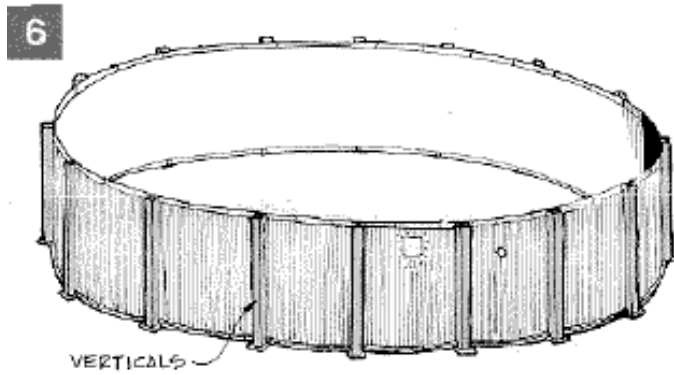
Remove pool wall from carton. Note "Up Arrow" on wall. Keep hands and feet from under wall during construction. Determine starting point from PRELIMINARY PLANNING. The skimmer openings will be at the inside end of the coil. To aid skimmer, position skimmer knockout downwind of prevailing winds. Always start wall at the center of a vertical end cap. Uncoil about 6 to 10 feet of wall and insert bottom edge into groove on bottom rails. Place stabilizer rails on top edge of pool wall, working around the top of pool as wall is inserted into bottom rails (Does not apply to Aqualine pools). Telescope small diameter rail into large diameter rail about 6 inches. You may need lots of help if the day is windy. Secure stabilizer rails to wall with duct tape between vertical caps. Bring wall ends together in center of starting vertical end cap. Adjust all bottom rails in or out uniformly if wall ends do not meet. Do not make total adjustment with one or two bottom rails. Do not install joint piece at this time. GO TO Step 5.



Remove stabilizer rails from area shown above. Bring pool wall ends inside of bottom rails as shown above. Align formed hooks on wall ends and slide joint piece down until it is even with top hooks. **WARNING:** Do not hammer joint piece on! Damage to hooks or joint piece may lead to pool wall failure. Manufacturer cannot assume responsibility of this product if joint piece has been improperly installed by forcing it in any manner. If joint piece does not slide on easily, realign sidewall hooks. Use ordinary dishwashing liquid for lubrication. When joint piece is in place, replace wall into bottom rails and reinstall stabilizer rails.



Matching pool wall cover plates are provided with your wall. Tape over skimmer openings in the event you are not using thru-the-wall equipment. Larger pools have two sets of openings to comply with local ordinances requiring two skimmers. Use a "Q-Tip" or cotton ball dipped in fast drying enamel to coat all bare metal edges of skimmer opening, return opening and mounting holes. This coating protects edges against corrosion. DO NOT use fingers as sharp edges may cause serious cuts. Enamel must dry prior to installing liner to prevent damage to liner in contact with freshly painted surfaces.



Carefully follow the details shown in Figs. A, B, or C below to assemble verticals to pool. Use all necessary hardware. Check pool for roundness by measuring across the pool from side to side. Pool diameter should be the same from point to point.

4" Inch Standard

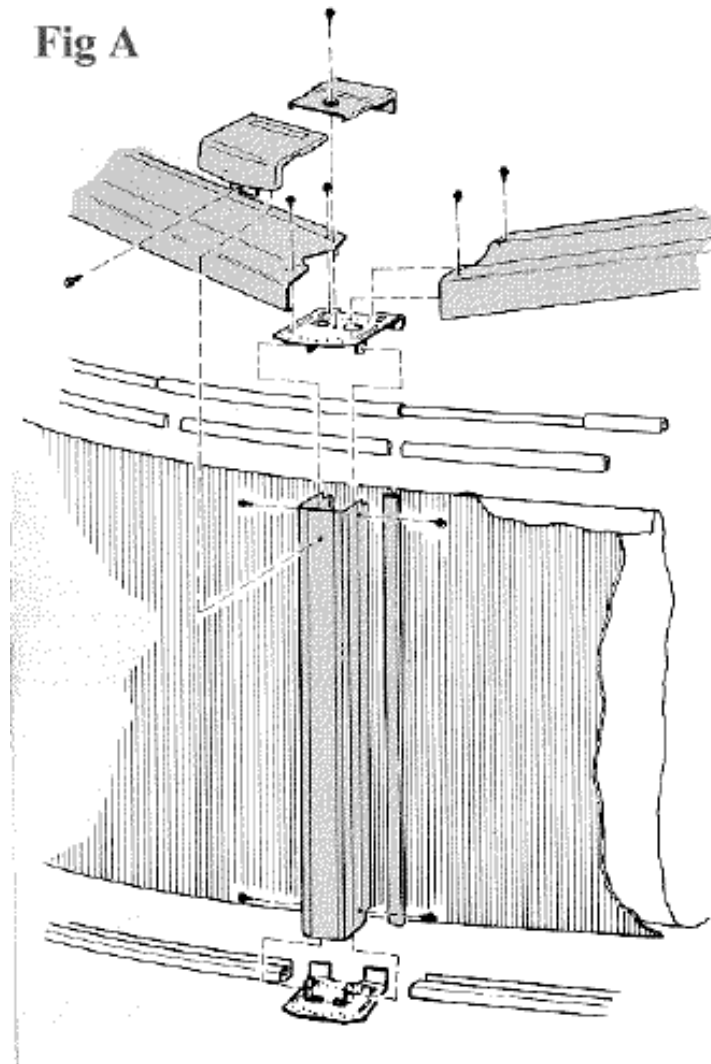


Fig B
6" Top Rail

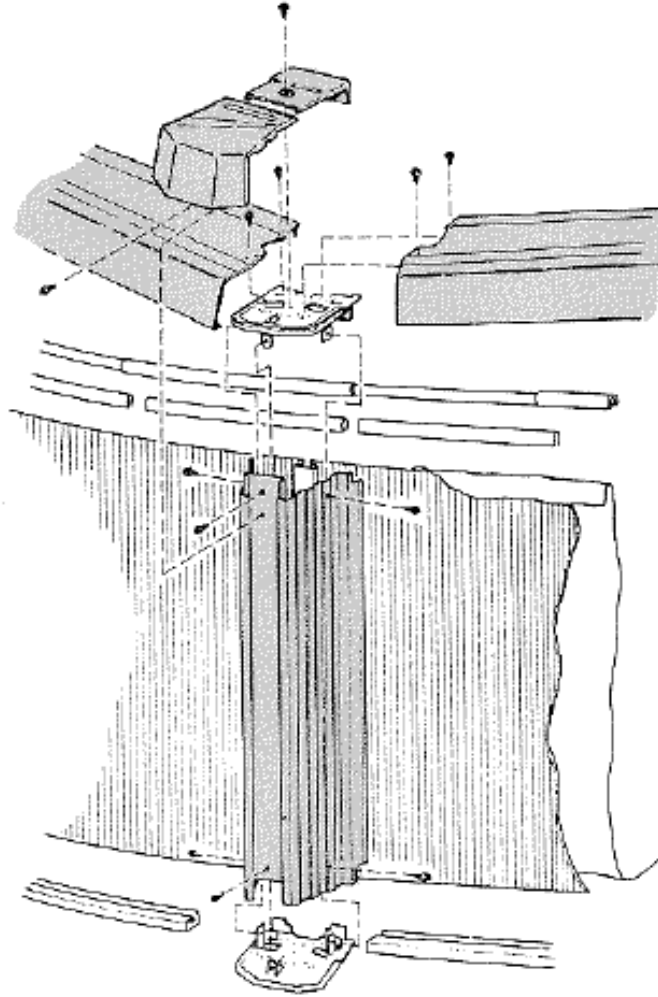
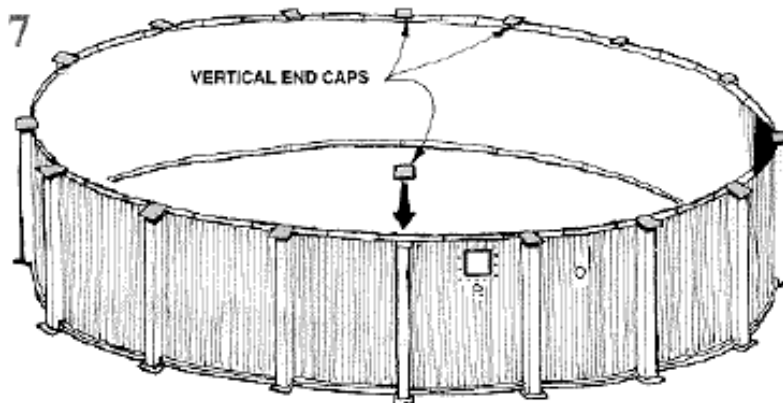
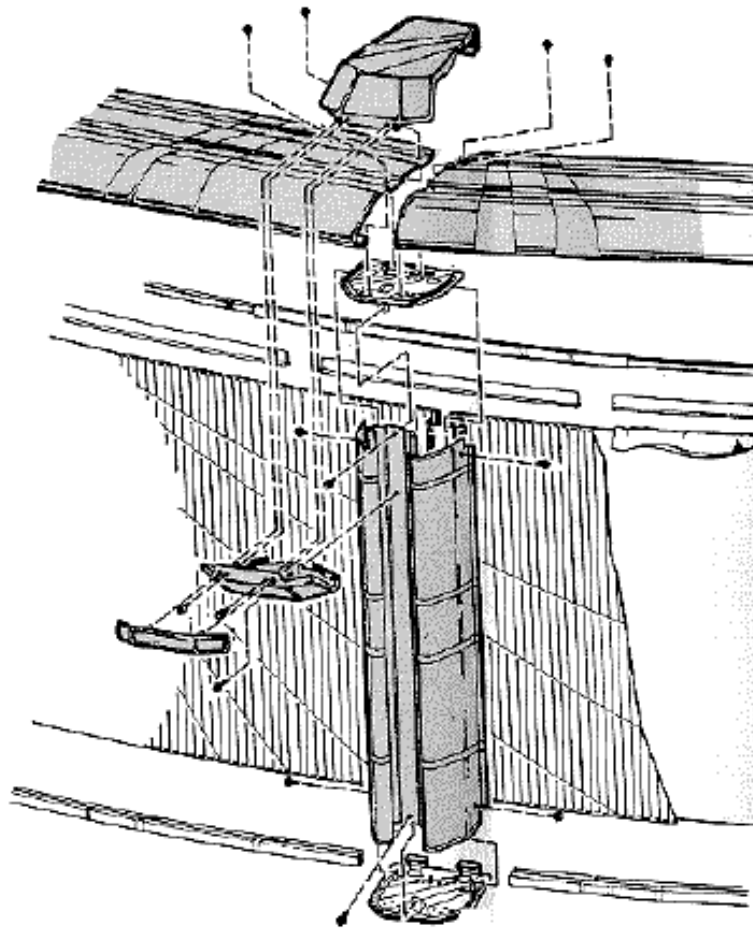
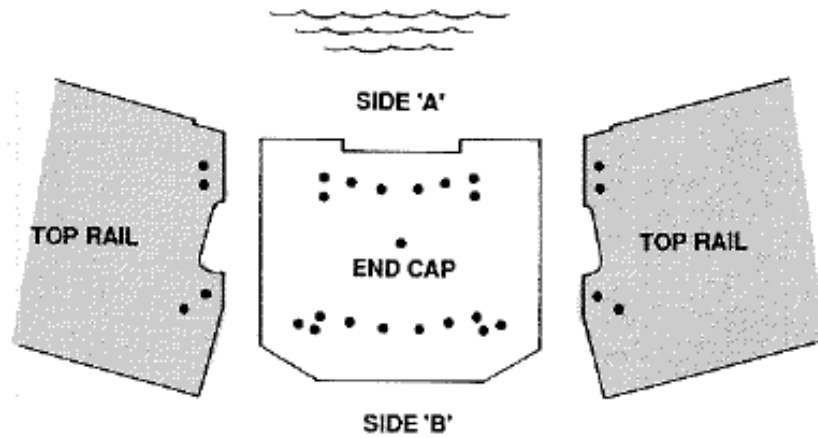


Fig C
8 1/2" Top Rails



Carefully follow Figs. A, B, or C Above to attach vertical end caps to verticals. Check pool for roundness. Check straightness of verticals using level tool. **YES, YOU ARE GOING TO PUT THE FRAME TOGETHER BEFORE PUTTING THE LINER IN**, it can only be done with a Doughboy Pool.



Looking From the Top Down

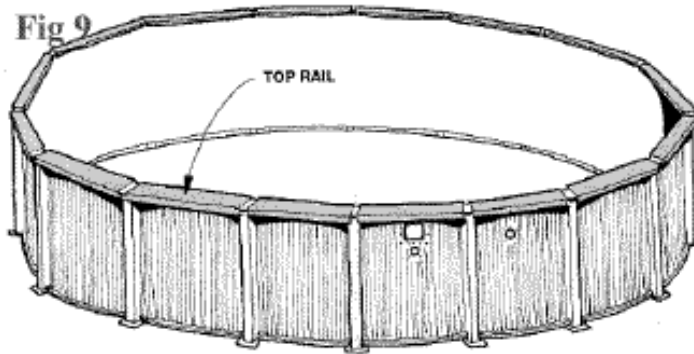
Hole Selection Chart

Four #10x3/8" screws attach top rails to each end cap. (Does not apply to Aqualine pool) Insert screws through the proper hole in top rail and into proper hole on end cap. From chart above, select proper holes (stamped on rails and end caps). Example: (16 ft Dia) Screws nearest Side a: Insert through hole stamped 16 on top rail, and into hole stamped 16 on end cap. Screws nearest Side B: Insert through hole stamped 16/28 on top rail, and into hole stamped 16 on end cap. HINT: Use felt pen to mark all proper holes before attaching.

HOLE CHART FOR 4" TOP RAIL MODEL POOLS						
Pool Diameter						
Hole Locations	12'	16'	18'	21'	24'	28'
Rail Hole-Side A	C	16/28/S	C	C	C	16/28/S
End Cap Hole Side A	12/18	16/28	18	21	24	16/28
Rail Hole Side B	C	C	C	C	C	C
End Cap Hole Side B	12/T	16	18	21	24/28	24/28

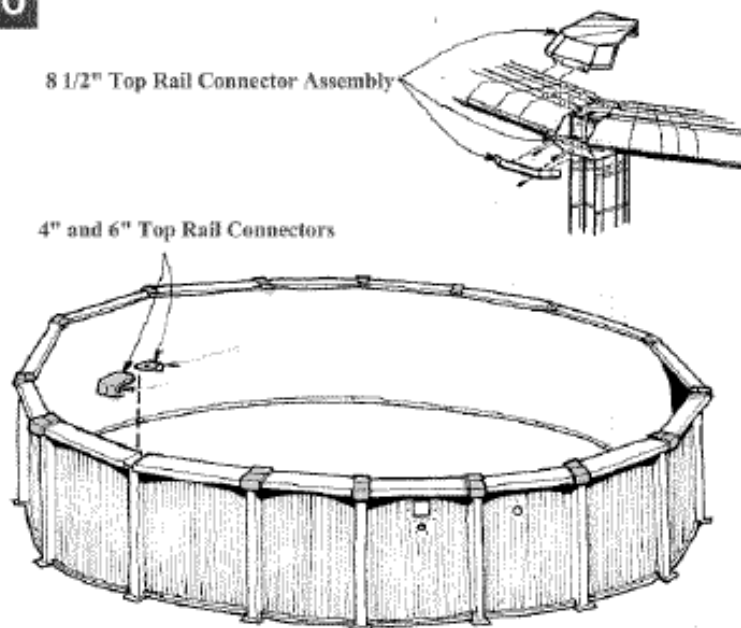
HOLE CHART FOR 6" TOP RAIL MODEL POOLS						
Pool Diameter						
Hole Locations	12'	16'	18'	21'	24'	28'
Rail Hole-Side A	C	C	C	C	24/28	24/28
End Cap Hole Side A	12	16	18	21	24/28	24/28
Rail Hole Side B	C	C	C	C	C	28
End Cap Hole Side B	12	16	18	21	24	28

HOLE CHART FOR 8 1/2" TOP RAIL MODEL POOLS						
Pool Diameter						
Hole Locations	12'	16'	18'	21'	24'	28'
Rail Hole-Side A	12/16	12/16	C	C	C	C
End Cap Hole Side A	12	16	18	21	24/28	24/28
Rail Hole Side B	C	C	C	C	C	28
End Cap Hole Side B	12	16/28	18	21	24	16/28

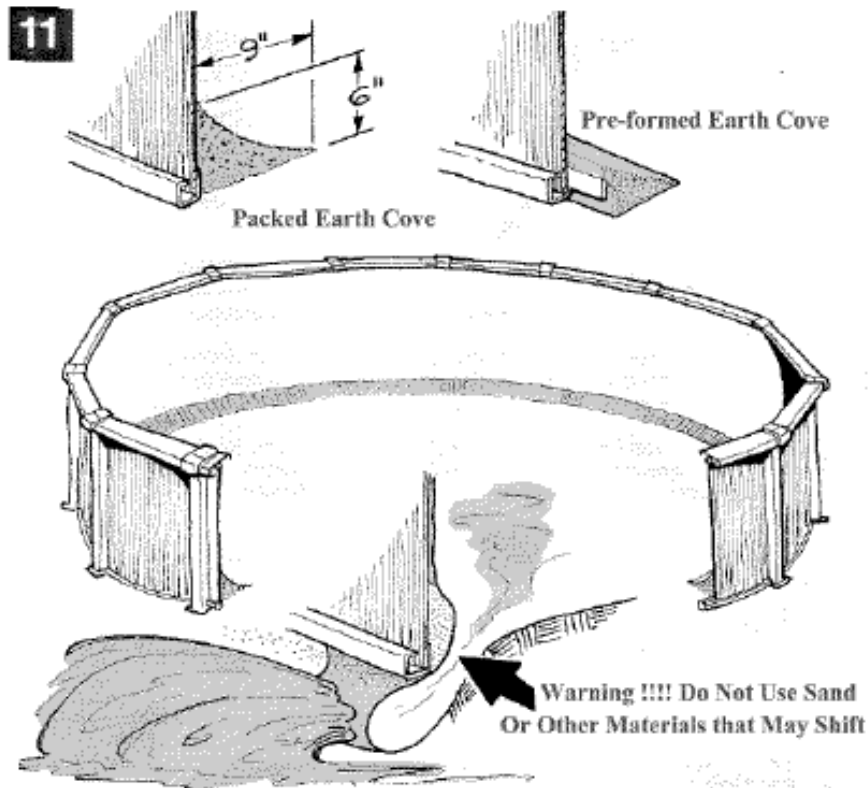


Attach all top rails using the chart from Step 8 to determine proper holes for attachment. At this time it is extremely important to check the framework to assure level installation. Place the level on each top rail, working gradually around pool, to assure framework is flat on ground with opposite sides no more than 1 inch out of level. **Remember: Always remove dirt to adjust framework-never fill in !!**

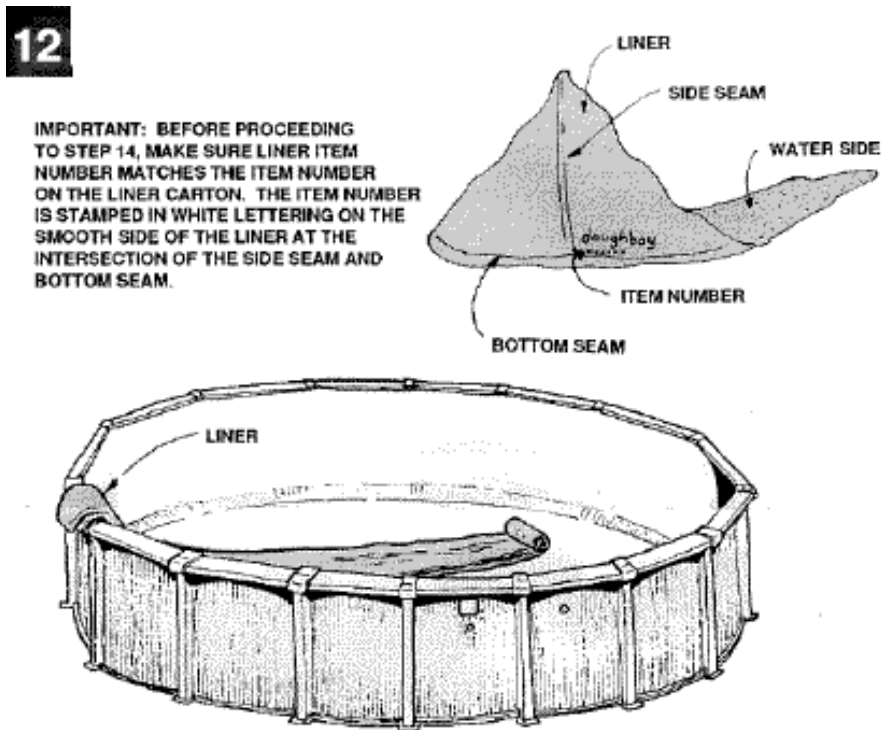
10



Attach all hardware and brackets shown in detail of your pool. Refer to Figs. A, B, or C. (Does not apply to Aqualine Pools) Attach top connectors to pool. For 4" Standard and 6" Flair model pools, attach inside connector first. The outer connector slides over inner connector. For 8 1/2" Classic models, attach vertical skirt to vertical first. Next, hook rear of top connector under inside lip of top rail then swing down over top cap to align with connector skirt and attach with screw. Finally apply the connector decorative strip



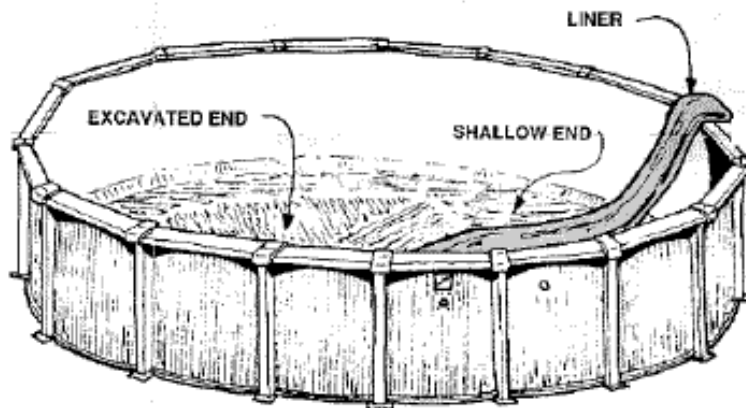
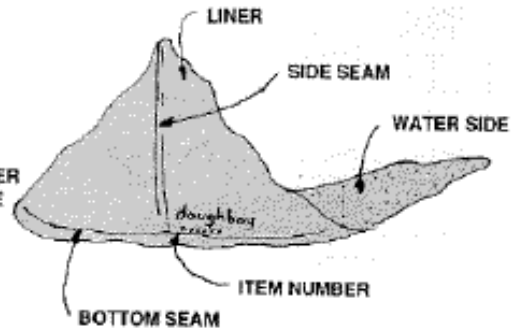
IMPORTANT STEP- The cove is a vital structural element that prevents water pressure from forcing the pool liner out under the bottom rail. The manufacturer will not assume responsibility if the cove is omitted or if improper coving is used. **EARTH COVE:** Use screened, damp earth to form a cove around the inside base of the pool wall. Shape and compact firmly. **PRE-FORMED COVE:** Specially designed pre-formed pool cove is available from your dealer. Follow cove manufacturer's instructions. Recheck pool for roundness after installing cove.



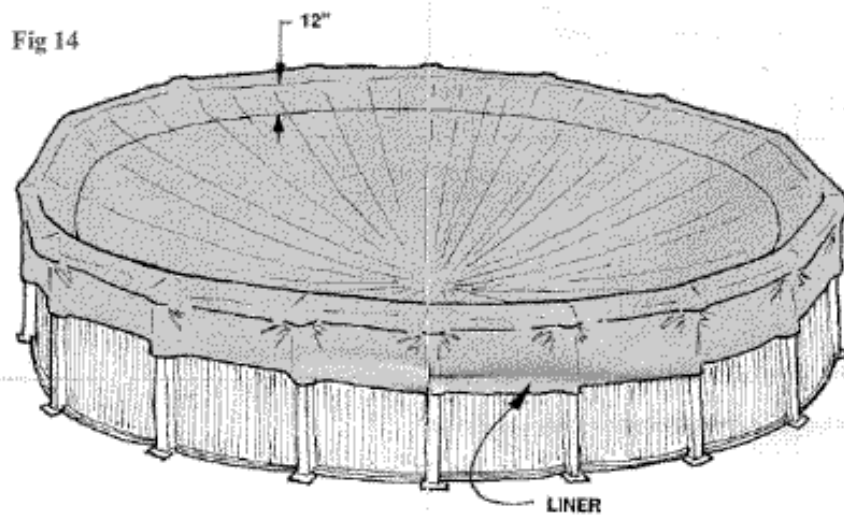
Check the pool floor (area inside pool wall) for levelness. Fill in all slight depressions with sifted earth and tamp. Remove all stones and sharp objects. Fill in all footprints on pool floor. Place liner on top of top rail. The liner should have the loose end overhanging the outside of pool by about 12 inches. Hold end and unroll liner down middle of pool as you would a carpet. Do not place liner seam over skimmer or return opening. The center seam of the liner must be positioned at the center line of the pool on 12, 21 and 24 foot round pools. For 15, 16, 18 and 28 foot round pools, position the center liner section (not the seam) at the center line of the pool. NOTE: The embossed (rough) side of the liner will be the water side.

13 DEEP AREA POOLS

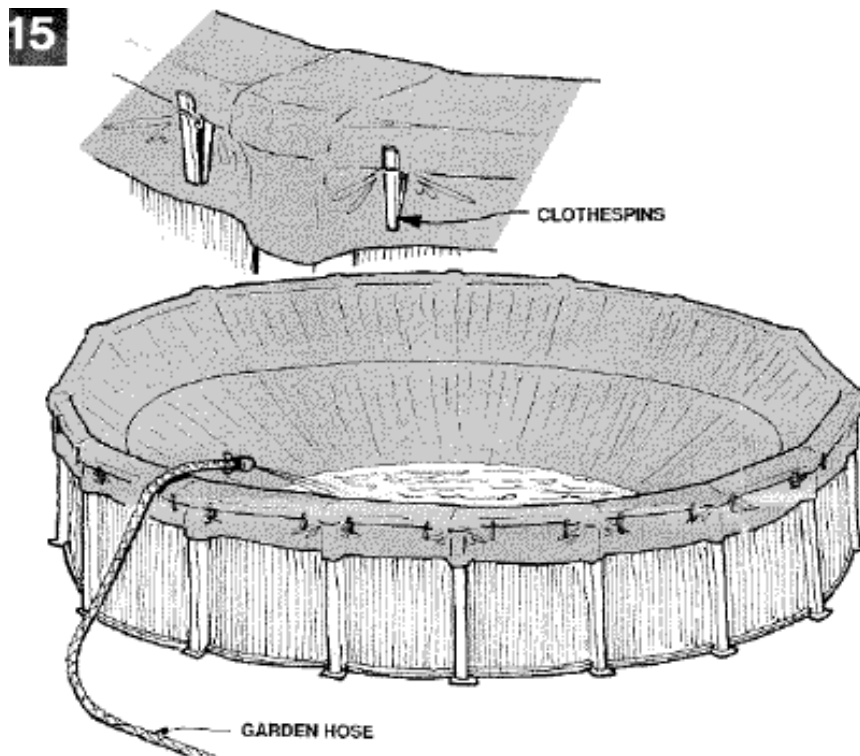
IMPORTANT: BEFORE PROCEEDING TO STEP 14, MAKE SURE LINER ITEM NUMBER MATCHES THE ITEM NUMBER ON THE LINER CARTON. THE ITEM NUMBER IS STAMPED IN WHITE LETTERING ON THE SMOOTH SIDE OF THE LINER AT THE INTERSECTION OF THE SIDE SEAM AND BOTTOM SEAM.



Excavated Pools Only: Check flatness of tapered area with 2" x 4" board. Fill in all slight depressions with sifted earth and tamp. Remove all stones and sharp objects. Fill in all footprints on pool floor. Place liner on top of middle top rail at the *shallow* end of pool. The liner should have the loose end overhanging the outside of pool by about 12 inches. Hold end and unroll down middle of pool into deep end. The center seam or center section of the liner must begin at the shallow end and run along the center line of the pool to the deep end.



Work in both directions from the point where the liner is overhanging. Unfold liner, drape over the top rail and down the sides approximately 24 inches. The liner should be barely above the pool floor in the center ONLY. Remember that the center seam or center section of the liner must be positioned at the center line of the pool. The bottom edge seam of the liner should be inside the pool about 12 inches below the top rails. Correct any bunching or pleating conditions in the liner wall. Inspect liner for open seams. If found, return to dealer for prompt replacement of liner.



Cover end of garden hose with sock and tape securely.

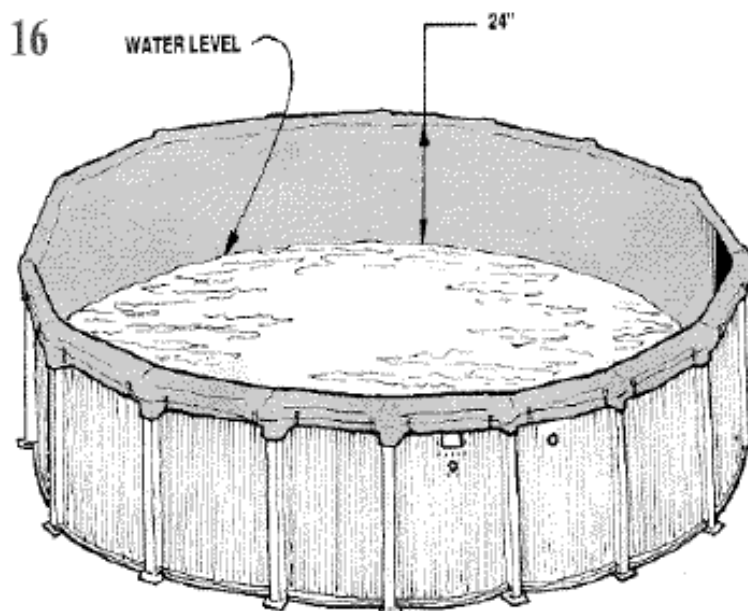
With the liner in position, hold in place by attaching two clothespins on the underside of each top rail. Carefully cover the end of the garden hose as shown, place it in the pool and begin to fill. As pool fills, the liner will stretch as the water begins to cover the bottom. At this time, check the sidewall for extreme tautness. Clothespins do not self release. Any area that feels tight should be relieved by releasing the clothespins and allowing the liner to feed back into the pool should be relieved by releasing the clothespins and allowing the liner to feed back into the pool until the desired tautness is achieved. Reclamp clothespins before you proceed around the pool checking and reclamping. Remember that you are monitoring a minimum tightness of liner over rail that will control the liner seating itself against the pool floor and up the side with no wrinkles. Continue monitoring the liner tension as the water is approaching and covering the cove area of the pool.

Be sure the liner is evenly distributed over the rail without any bunching or pleating. If this occurs, correct as you are adjusting the liner tension. To correct, grasp the liner wall nearest the wrinkled area. Pull and lift the liner wall just enough to stretch out wrinkles or pleats. It is easier if you wait until there is 1 to 2 inches of water over the wrinkled area before you try to remove it. This allows the weight of the water to hold liner flat on the ground, keeping out wrinkles after you remove them. Pull any excess liner over the rail and reclamp in position so that a minimum tautness prevents further wrinkling. Double check around the pool so that you have an even tension on the liner wall down to the liner floor. Do not attempt to lift and pull the liner with more than 4 inches of water in the wrinkled area. Damage to the liner may occur.

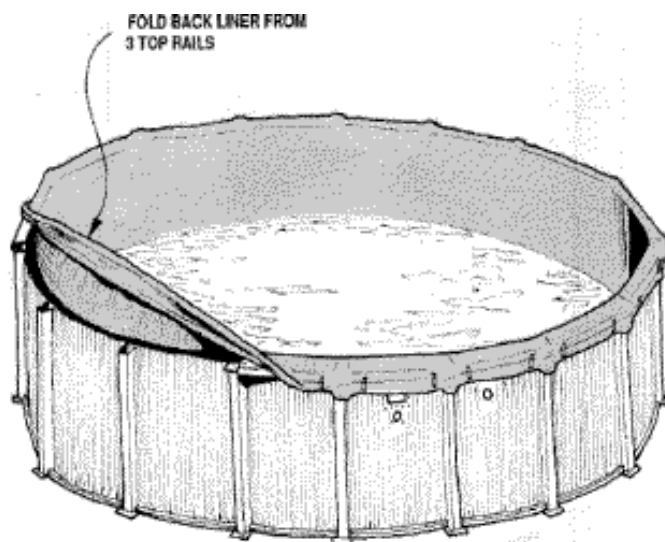
When the water is approximately 6 inches up the metal wall and covering the cove, there should be just barely enough tension on the liner to control a wrinkle-free installation.

[Filling Deep Excavated Pools:](#)

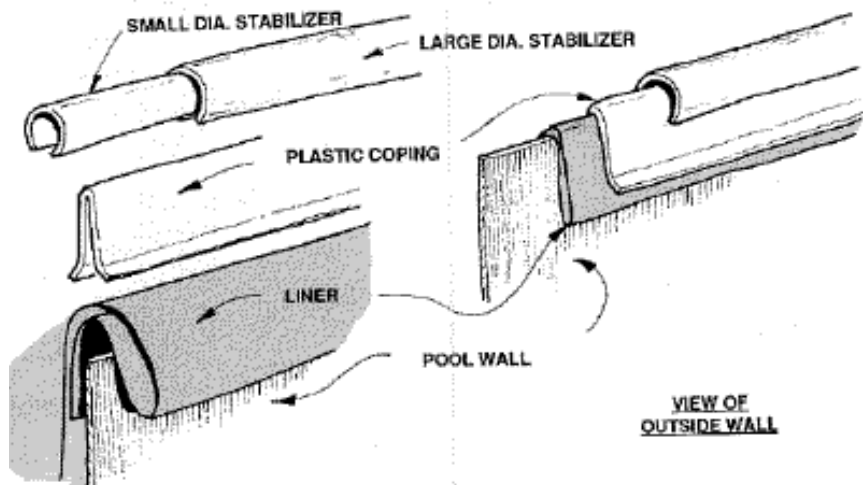
It is important to remember that the floor of the liner (not the liner wall) must stretch into the excavated area. The bottom edge seam should be located in the cove area all the way around the pool when the pool is full of water. Stretch the liner properly or you will end up with the bottom edge seam somewhere on the bottom of the pool and not enough liner will go over the steel wall to complete the installation. When this happens you may think you've received the wrong liner, when in fact the liner was improperly stretched into place.



Continue filling pool. Never allow liner to fall back into pool. Water between the liner and wall can cause pool failure. When pool has approximately 24 inches of water, stop filling. DO NOT RESUME until steps 17, 18 and 19 are completed. CAUTION: Do Not cut any openings into liner at this time.



With the help of two or three people, raise and hold the liner from three top rail sections. Removing the attaching hardware at the top rail connection, three top rails, three vertical end caps and stabilizer rails. Remember: Never Allow Liner to fall back into pool. USE CAUTION: Do Not Drop parts into the pool or behind the liner.



Make a hem as illustrated. Smooth liner against wall and secure to top of wall with plastic coping. Place stabilizer rails over coping (does not apply to Aqualine pools), Alternately telescoping small diameter into large diameter about 6 inches as above. Replace all parts removed in Step 17. Repeat same steps for entire pool perimeter, working just three top rail selections at a time. DO NOT allow liner to fall back into pool.

[Skimmer Installation](#)

With pool completely assembled, install skimmer, filter, etc. using instructions provided with the units.

SAFETY INFORMATION

Read all the safety literature, attach all safety stickers as required. If you don't have any email Doughboy for a safety packet. Email pools@doughboy-pools.com

[Cleaning Liner](#)

If you decide to drain the pool to clean the liner, or for any reason, **you must leave at least 1 foot (12 inches) of water**, measured from ground level up the metal sidewall, in the pool. Failure to comply with this warning may void the warranty.

[Liner Replacement](#)

If you decide to replace the liner, you must have the replacement liner at the pool site and ready for immediate installation. **DO NOT leave the pool standing without a liner.** Do not attempt to install the replacement liner on a windy day. Severe wind damage to your pool may result.