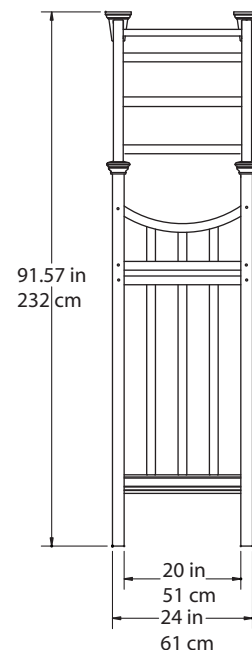
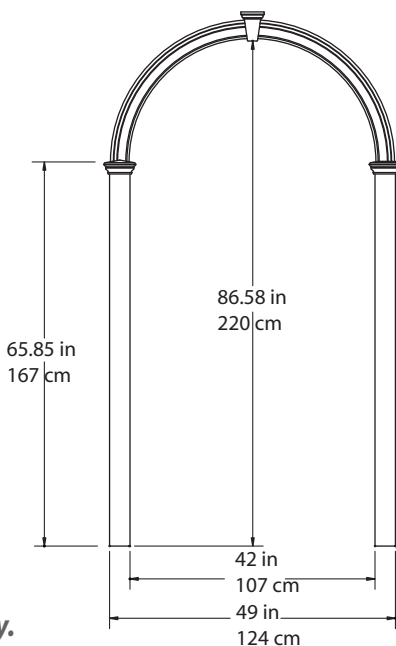
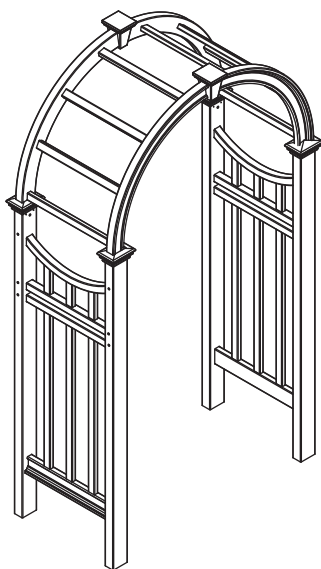


# ASSEMBLY INSTRUCTIONS

## The Vienna Arbor / Arch



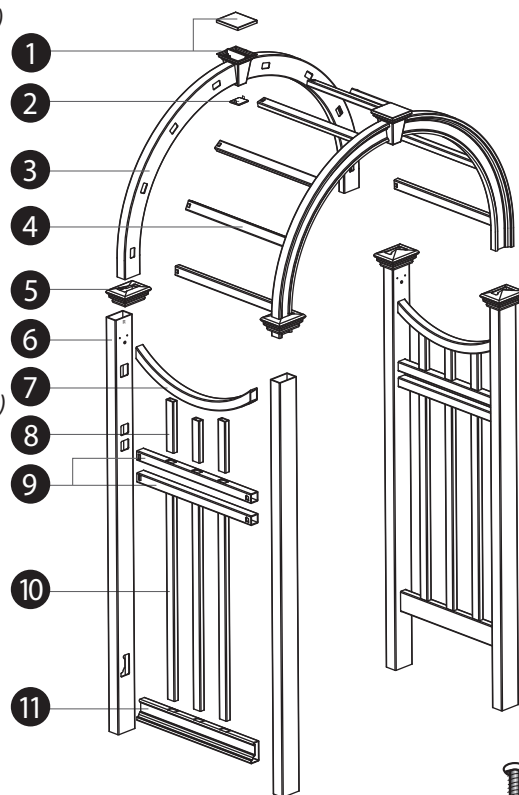
Please read through before starting assembly.

**IMPORTANT: CHECK THE INSIDE OF YOUR POSTS FOR ALL MATERIALS.**

### Check Box for These Contents

In the event of missing or defective parts please call our customer service dept. at **1 800 282 9346** (Mon. to Fri. 8:00 AM to 5:00 PM EST).

1. Arch Keystone (10836) & Top Lid (10668-1) & Keystone Inserts (10837) -(2 of each)
2. Keystone Bottom Plate (2) - 10666-1
3. Arches (4) - (2 ea. Right 10671-1, 2 ea. Left 10670-1)
4. Arch Rafters (8) - 10672-1
5. Post Caps (4) - (2 ea. Right 10674-1, 2 ea. Left 10673-1)
6. Posts (4) (2 ea. Right 10676-1, 2 ea. Left 10675-1)
7. Side Panel Horizontal BentTop Rails (2) - 10656-1
8. Side Panel Vertical Spindles Short (6 Total, 4 Long (A) 10679-1, 2 Short (B) 10678-1)
9. Side Panel Horizontal Mid-Rails (4) - 10681-1
10. Side Panel Vertical Spindles Long (6 for Bottom Panel) - 10680-1
11. Side Panel Horizontal Bottom Rails (2) - 10662-1
12. Hardware (in plastic bag)
  - a. 1 1/2" (4 cm) Self-Auguring Screws - 20005 - (16 for Keystone & Arch to Post)
  - b. 1 1/2" (4 cm) Self-Auguring Screws - 20005 - (8 for ground anchors)
  - c. 3" (8 cm) Self-Auguring Screws - 20007- (12 for Top & Mid Rails to Post)
13. Ground Anchoring Stakes (4) - 10844

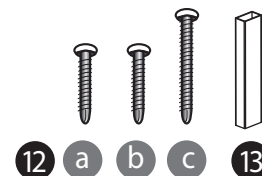


### Tools You Will Need

- Cordless Drill
- Hammer
- Tape Measure
- Level
- Stool or Short Ladder
- Shovel

### General Information

- Read Instructions through carefully before beginning assembly.
- When assembling components, place on a non-abrasive surface (i.e. shipping box) to avoid scratching.
- We recommend an area approx 10'x 8' (3 m x 2.4 m) for unobstructed assembling.
- You should not need to use excessive force when assembling components.



Not to Scale

## STEP ONE

vita

### Assemble the Arch System

**1**

Insert arches into arch keystone ensuring they terminate flush to the internal connector. Ensure that the "R" and "L" identifications are located at the bottom of the arch assembly. The tabs protruding out of the internal connector should fit outside the arches. Ensure that the arches are orientated properly as per illustration.

**2**

Fasten the arch system to the keystone by installing the small (1 1/2 in. / 4 cm.) screws into the two pre-drilled holes provided.

**3**

Invert the arch system and install two small (1 1/2 in. / 4 cm.) screws from the bottom of the keystone into the two pre-drilled flanges on either side of the bottom of the insert. This will connect the bottom of the arches to the insert.

**4**

Seal the bottom hole on the keystone by inserting the bottom plate as provided.

**5**

Install the top cap on the arch keystone. Push down firmly so the cap locks into position.

**6**

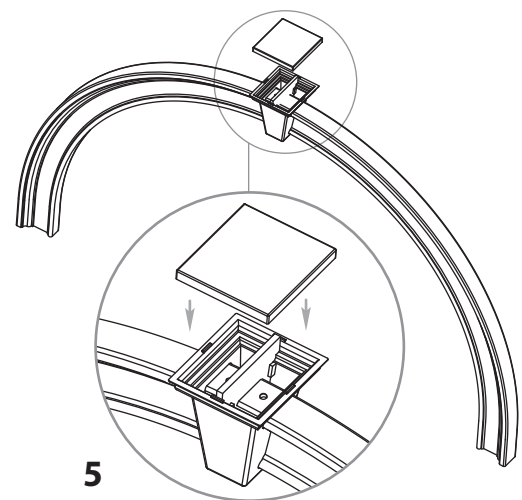
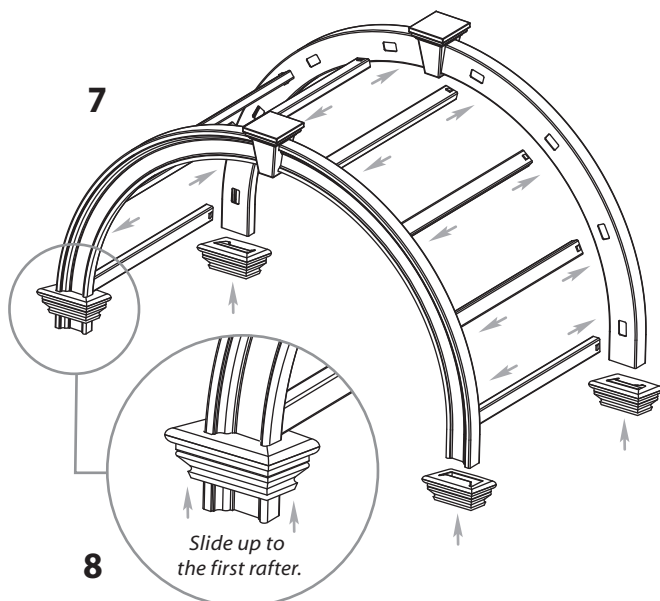
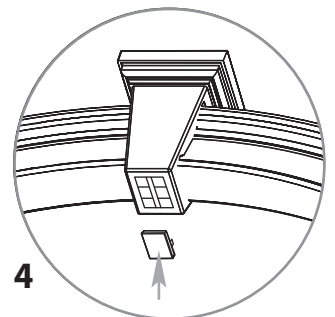
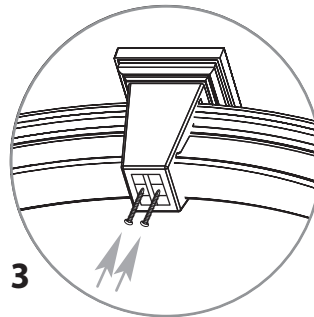
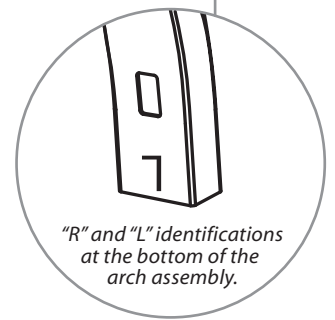
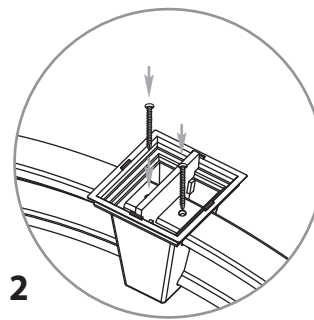
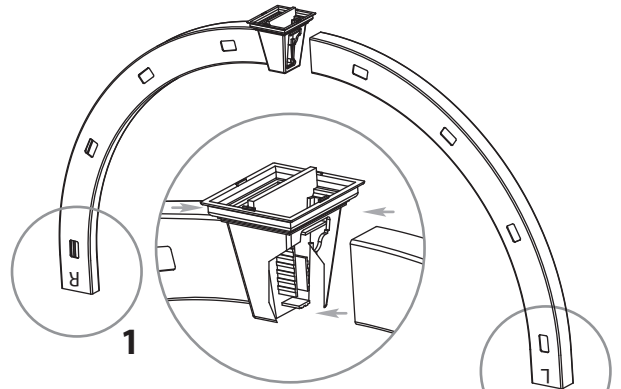
Repeat for other arch.

**7**

Insert arch rafters (8) into the holes on the arches until they bottom out inside the arches. There are "locking tabs" located at each end of these rafters that once inserted into the holes will lock into place.

**8**

Install post caps on the bottom of all arches. Slide up into temporary position until they hit the first rafter.

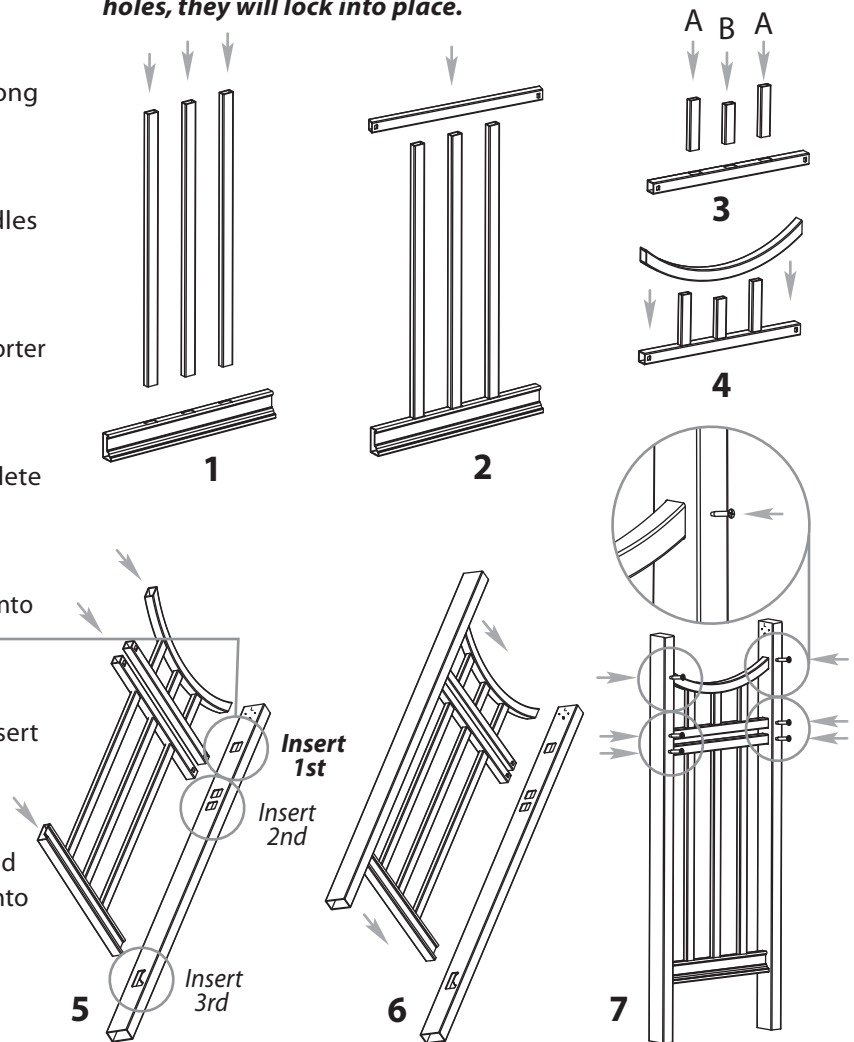


## STEP TWO

### Assemble the Top & Bottom Side Panels

**NOTE:** Some of the horizontal rails have locking tabs located at both ends. Once inserted and pushed into the routed holes, they will lock into place.

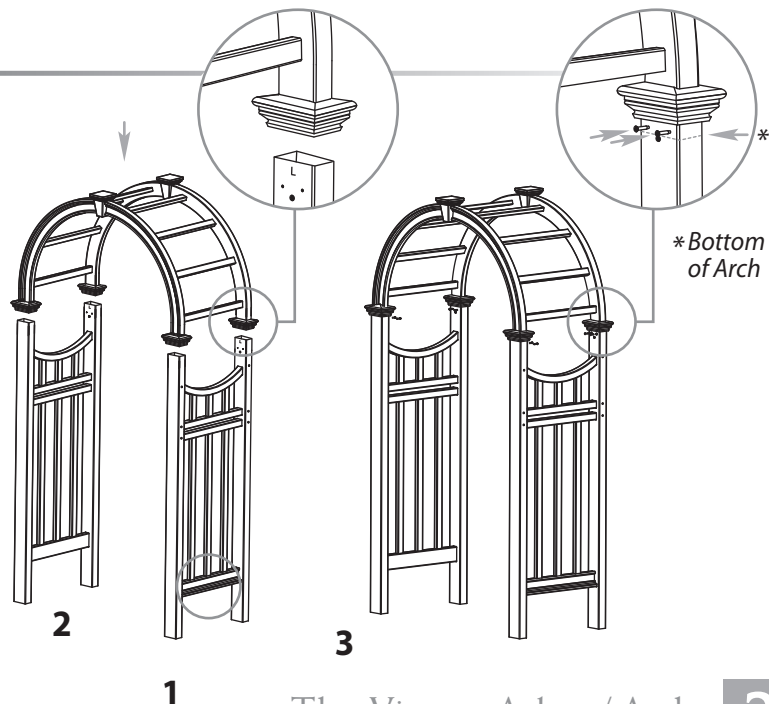
- 1**  
Lay out the horizontal bottom rail and insert the three long vertical spindles.
- 2**  
Slide one horizontal mid-rail over the ends of the spindles to complete the bottom panel.
- 3**  
Layout the other horizontal mid-rail and insert the three shorter spindles in the pattern identified on the illustration.
- 4**  
Slide the horizontal bent top rail over the ends to complete the top side panel to complete the top panel.
- 5**  
Set out one post and complete the side panel by inserting it into the post. **Start with the bent top rail first.**
- 6**  
Layout the second post with holes facing upwards and insert the completed panel and connected post into.
- 7**  
Fasten the horizontal bent top rail and both horizontal mid rails to the posts by installing 6 long (3 in./ 8 cm.) screws into two posts as illustrated.
- 8**  
Repeat for other side panel.



## STEP THREE

### Connect Arch System to Side Panels

- 1**  
Set out both side panels **ensuring that bottom rail profiles are facing outwards.**
- 2**  
Insert the assembled arch into the top of all four posts until the arch bottoms rest on top of the "stopper" bolts. You will need a helper.
- 3**  
**Pull the post caps down into final position over the posts and fasten** the arch system to the posts by installing 2 short ( 1 1/2 in./ 4 cm) screws per post as illustrated.



## STEP FOUR

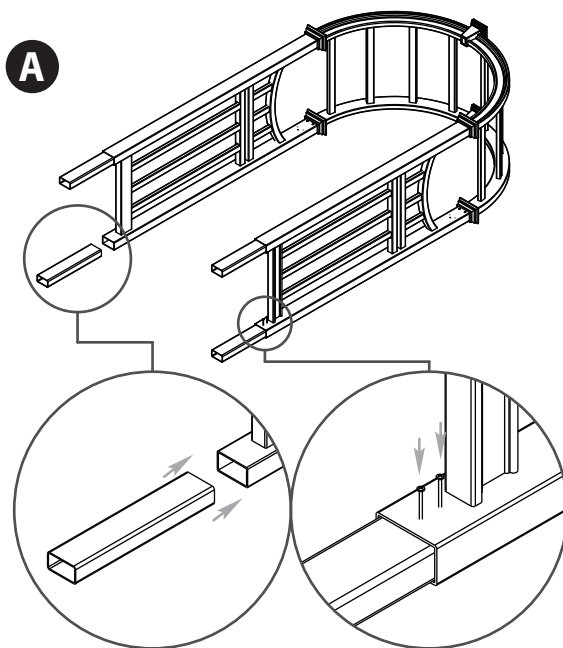
### Ground Anchors Installation

Arbors must be well secured to prevent tipping over from wind load etc. We have provided four ground anchors for securing the arbor either into the ground or a concrete footing. In some cases it may be acceptable to secure the arbor to an existing structure such as a fence post. If you are installing your arbor on concrete or a deck, see your hardware store for the appropriate galvanized bracketing hardware.

#### A Install Ground Anchors

Insert the ground anchors into each of the post until they reach the bottom rail.

Fasten each posts with two of the provided screws as shown.



#### B Into Earth Without Concrete Footing

1

Move the arbor to its final location (you will need a helper). When you are satisfied with the location, mark the positions of the posts, then move the arbor aside and lay it carefully on it's side. Excavate 4 holes approx 12" (30 cm) deep. Carefully move the arbor back into position and level it both vertically and horizontally.

2

Backfill the holes with the excavated soil to cover the anchors.

#### C Into Earth With Concrete Footing

1

Complete A #1 above, with the exception of excavating the holes at least 6" (15 cm) wide x 18" (46 cm) deep. Fill holes with wet cement within 3" (8 cm) of your grade (you will need 2 bags of pre-mix concrete - purchase separately). Carefully move the arbor back into position.

2

Support the arbor plumb and level over the holes with bricks, stones or blocks of wood under the bottom rail of the side panel. The post bottoms should insert themselves approx 1/2" (1.3 cm) into the concrete.

#### Optional

If you plan on attaching a fence or bench to the arbor, or in the event of extreme wind conditions we would not recommend using the ground anchors provided. Consider purchasing pressure treated lumber and trimming it down to **3 1/4 (8.3 cm) wide** and cutting it into 36" lengths. Insert into the bottom of all four posts until they hit the bottom horizontal rail on the side panel. Fasten accordingly with screws and install either directly into the ground or into a concrete footing.

