



Quality Frame Tents for Rental and Commercial Industries

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ASSEMBLY INSTRUCTIONS

40' x 60' x 8' CANOPY (Keder Style)

1. Lay out four (4) corner fittings, ten (10) side tee fittings, six (6) special tee fittings, and twenty (20) white 9'4" spreader pipes. Form the frame perimeter, assemble, and secure using pins. Place two (2) 6-way crown fittings in the center of the frame with two (2) 9'4" spreader pipes and one (1) top tee fitting between them. Install four (4) intermediate fittings in the frame quadrants, as shown in the schematic.
2. Assemble the first quadrant as follows:
 - Insert one (1) white 14'4" hip rafter over the corner fitting and secure with a pin. Connect the opposite end to an intermediate fitting and pin.
 - Insert one (1) green 10'6" rafter over a tee fitting and pin. Connect the opposite end to an intermediate fitting and pin. Repeat this process for the adjacent 10'6" rafter.
 - Insert one (1) white 14'4" hip rafter over a special tee fitting and pin. Connect the opposite end to an intermediate fitting and pin. Repeat for the adjacent 14'4" rafter.
 - Insert one (1) white 14'4" rafter over the 6-way crown fitting and pin. Connect the opposite end to an intermediate fitting and pin.
3. Adjacent to the previous assembly, insert one (1) 2 in. red 21'10½" rafter over the 8-way crown fitting and pin. Connect the opposite end to a special tee fitting and pin.
4. Assemble the other quadrant (other end) next to the rafter installed in step 3, following the same method as in step 2.
5. Insert two (2) red 21'10½" KEDER rafters into the 8-way crown fitting and pin. Secure the opposite ends into the special tee fittings and pin. This will complete one end of the frame.
6. Install a 9'4" white spreader pipe over the assembled 6-way crown and pin. Connect the top tee fitting to the opposite end of the spreader pipe and pin.
 - Insert two (2) KEDER 21'10½" rafters from the top tee to the tee fittings and pin.

Install the remaining 9'4" white spreader pipe over the top tee fitting and pin. Connect and pin the opposite end to the remaining 6-way crown fitting.

7. Repeat steps 5 and 2 to assemble the remaining end quadrants of the frame. **Note:** Assemble in reverse order so the final insertions are at ground level, making them easier to handle. See diagrams.
8. Install the frame support cable, which prevents frame spread. Loop one end of the cable around the leg post of the center tee fitting. Run the cable across the width of the frame and loop it onto the opposite center tee fitting.
9. Install the brace bar connecting one side to the rafter to the other side hooking with the special pin provided
10. Pull the top through the rail. Start with the 40x20 End. When the end is pulled through then hook the corner webbing to the tab on the corner and repeat on the other side. Then repeat on the other end.
11. Pull the mids in the same way and align with the Valance. Hook the rope into the opposing valance ring and tie down to the baseplate. Do not tighten all the way. Repeat for the remainder of the tension ropes. Once done, walk around and tighten all.
12. Raise one side of the canopy high enough to insert the black 7'8" leg pipes into the corner fittings and secure them with pins. Use caution when lifting, and use a ladder. Gloves and hard hats are recommended. Three to four people are needed.
13. Repeat step 10 for the opposite side of the canopy.
14. Insert all remaining leg pipes into the fittings and secure them with pins.
15. The canopy and frame can now be tied down. **Caution:** Tie down only at the corners or tee fittings. **Do not tie to the spreader pipes**, as they may bend.

40' X 60' X 8' Keder CANOPY Parts List:

- 4 ea. — Tension Corner fittings
- 2 ea. — 6-way crown fittings
- 6 ea. — Special tee fittings
- 10 ea. — Tee fittings
- 4 ea. — Inter-fittings
- 1 ea. — Top tee fitting
- 20 ea - baseplates tension
- 20 ea - rope
- 22 ea. — 9'4" white pipe (spreaders)
- 8 ea. — 10'6" green pipe (hip rafters)
- 16 ea. — 14'4" white pipe (hip rafters)
- 2 ea. — 21'10½" red pipe (rafters)
- 6 ea. — 21'10½" KEDER pipe (rafters)
- 20 ea. — 7'8" black pipe (legs)

