

# THE ULTIMATE POOL

## ROUND STYLE



INSTALLATION MANUAL

# INTRODUCTION

Congratulations on your decision to purchase the truly unique and superior Ultimate Round Pool! The 14- gauge powder coated steel wall system is the strongest hybrid pool on the market today.

As you read through this manual, you will notice that we stress the importance of proper installation to ensure a long lasting and safe investment for your family. This pool is designed to be installed by the 'do-it-yourself' homeowner or a professional pool installer.

The Ultimate Round Pool carries a lifetime warranty on the steel panel system as well as a pro-rated warranty on the liner. To protect your investment, please fill out and send back your warranty cards when this pool is constructed.

# INGROUND INSTALLATION

The Ultimate Pool can be installed completely inground. The Concrete Collar should be poured 12" thick by 12" wide around the entire perimeter of the pool. (2500 PSI Concrete is recommended).

Once the concrete collar is dry, it is time to backfill. You have two choices when backfilling. First, and most common, is to backfill with a  $\frac{3}{4}$ " stone. The second option is to place Sona Tubes every 4' around the perimeter and backfill with the dirt from the excavation. Either of these methods will ensure that the concrete deck is supported properly. With the pool backfilled, you can now begin forming your deck with  $\frac{3}{8}$ " rerod placed in a 2' x 2' grid or mesh. Both are acceptable methods of reinforcing concrete.

Following these steps to install your Ultimate Pool inground will ensure a long lasting swimming structure.



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## SAFETY

A pool is a wonderful investment for years of fun and relaxation for you and your family. Proper safety measures should always be followed to ensure a safe and fun environment in your backyard.



Every Ultimate Round Pool kit is supplied with a safety packet including information about the swimming pool safety and a no-diving/no jumping sign to be placed on the top rail of the pool near the ladder entry/exit.

The Ultimate Round Pool is not safe for diving or jumping of any kind. For your safety and the safety of your family and friends, please read the safety information thoroughly.

All pools installed aboveground should have a locking/removable ladder that should always be locked or removed when the pool is not in use.



**DANGER! NO JUMPING! NO DIVING! SHALLOW WATER.**



*The Ultimate Pool is NOT designed for diving. Misuse could lead to serious injury or death. Children should be supervised at all times.*



# TOOLS AND MATERIALS

## TOOLS AND MATERIALS

### SITE PREP

- Transit or Similar Leveling Device
- Earth Moving Tools; Shovel, Rake, Wheelbarrow...
- String Line
- Hammer
- Spray Paint or Similar Ground Marking Product
- (2) Tape Measures

### POOL ASSEMBLY

- (2) 9/16" Wrenches/Ratchet Sockets
- 2' or 4' Level
- Drill with 5/16 Nut Driver Head and #2 Phillips Bit
- #2 and #3 Phillips Screw Driver
- Duct Tape
- Drift Pins
- Hammer
- Sharp Razor Knife
- Shop Vacuum
- Rounded (bottom) Trowel
- Sand Bottom Mix (see chart below)
- (1) 36" Flat Board 1x3 (to level bottom mix)

### POOL BOTTOM BASE

- 10ft pool = .5 cubic yards
- 18ft pool = 1.25 cubic yards
- 21ft pool = 1.55 cubic yards
- 24ft pool = 2.5 cubic yards
- 28ft pool = 3.0 cubic yards

## SITE LOCATION AND PREPARATION

Site location in the yard is a very important part of building a swimming pool. It is vital to locate the pool within the current building code requirements for your local municipality. A building permit may be required for the installation of your swimming pool and it is important to follow all guidelines associated with the local municipality.

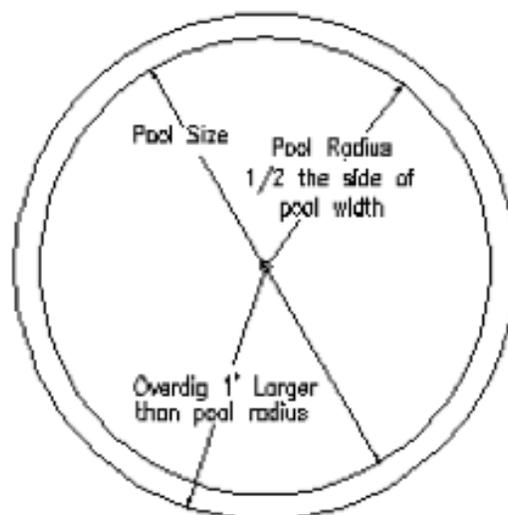
The location selected should be on virgin or compacted ground, free of overhead power lines and other dangerous obstructions. If the pool is placed at the bottom of a large slope, a surface water management system may need to be added when landscaping around the pool.

Unlike other aboveground pools, the Ultimate Pool can be buried in the ground, set into a hill or slope, and the ground can be backfilled against the pool wall if needed.

Once the location of your pool is determined begin the layout process by locating the center point of your pool as shown in the illustration below.

Make a circle on the ground which represents the over-dig area of the pool. This over-dig is located 12" outside the diameter of the pool.

With the ground marked for the outline of the over-dig, begin removal of the topsoil. It is important that the pool is built on undisturbed earth not fill dirt. Fill dirt will settle over time causing your pool to sink and become unlevelled.



# POOL AND WALL LAYOUT

## SITE LOCATION AND PREPARATION (CONTINUED)

Remove the dirt until the ground is level, and free of rocks and/or sharp objects. A transit or laser level is the best tool for this job. These items can be rented at any tool rental store or mass merchant rental department.



## POOL AND WALL LAYOUT

Now that the dirt is removed and the ground is level it is time to begin laying out the pool and wall system. First you must locate the center of the pool and place a supplied layout stake in this location. Next you will find that one panel is different from all the rest, this is the skimmer panel and should be placed so the prevailing wind will push the water into the opening. Another suggestion is that the skimmer panel be placed out of sight toward the back of the pool because this is where the filtration system will set.

With the skimmer panel position identified, begin setting your layout stakes at the end of each wall panel joint location as shown in the previous drawing. This pin placement will mark the inside location of each panel joint.

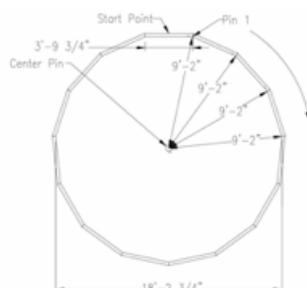
### EXAMPLE:

#### CENTER PIN TO PANEL JOINT:

- 10' = 5'
- 18' = 9' 2"
- 21' = 10' 6 1/2"
- 24' = 12' 2 1/4"
- 28' = 14'

#### DISTANCE BETWEEN PINS:

- 10' = 2'
- 18' = 3' 10"
- 21' = 3' 10"
- 24' = 3' 10"
- 28' = 3' 10"



## POOL AND WALL LAYOUT (CONTINUED)

There are several steps that need to be followed before placing the panels into position. Each panel must be marked on the inside face with a line  $1\frac{1}{2}$ " up from the bottom. This line will mark the finished level for the pool bottom under the liner.



## OPTIONAL WALK-IN STAIR

There is an option to install an 8 foot 5-tread walk-in stair in the Ultimate Pool. This stair must be installed in the radius end of the pool. **Note: A special liner must be ordered when using this stair option.**

First locate the stair placement at the site. Align the appropriate panels to either side of the stair and clamp them to the stair flange. When using the "synthetic wood" top seat the coping must be flush with the top of the stair as shown in photo B (see next page).

When using the bendable aluminum coping, you should bring the elevation up to or near the top of the bullnose stair as shown in photo C (see next page). As you can see in photo A (see next page), there will be a void below the stair shell that must be framed out to hold back the concrete bond beam that will be poured behind and under the stair shell. After the finished elevation is established, drill through the stair flange at each bolt hole location using a  $\frac{1}{2}$ " drill bit and bolt together.

# STAIR INSTALLATION

## OPTIONAL WALK-IN STAIR (CONTINUED)



## STAIR INSTALLATION

Two stair buttness and two flange washers are included with each Ultimate stair.

The stair buttness should be attached on the outside of the stair flange and the washer should be on the inside of the stair flange. This will create a “sandwich” of steel and flange, strengthening the plastic flange and reducing the chance that the bolts will be pulled through.

## SETTING THE WALLS

Begin moving your wall panels into place. Make sure you place the skimmer panel in the proper location. Remember that the filtration equipment will be placed behind this wall section. That said, it will be visible and an electric service will be required to operate the pump. All the other panels are uniform and can be placed anywhere on the pool.



## SETTING THE WALLS (CONTINUED)

After all of the wall panels are placed around the site, it is time to begin the wall erection. Starting with the skimmer panel, align the front edge of the panel with the layout stakes in the location of your choice.

Secure the panels by using the 9/16" galvanized nuts and bolts that were supplied with this package. Begin bolting the panels together **using only the top two and the bottom bolt on each seam,** until you have closed the circle. NOTE: Keep the panel connection on the outside of the layout stakes. We suggest that you hand tighten the panel bolts until the entire pool wall is erected.

After the wall is assembled double check the position of the wall matching the wall seam to the perimeter layout stakes.

As you tighten the bolts make sure the panels are flush on the inside and the top seat joints are together. This will ensure a smooth liner installation and a flush top seat fit. Use a level to make sure that the pool walls are both plumb and level. Finish by driving the 18" rebar into the ground through the holes at the bottom flange on the back of panel. Make sure rebar is installed to correct depth. No more than 3" should be exposed when finished.

Do not remove the inside perimeter pins. They will be needed to attach string lines for the pool bottom.

If any sections of the pool wall are going to be buried into the ground, we highly recommend a concrete bonding collar be placed behind all of these panels.



# INSTALLING TOP SEAT AND COPING

## INSTALLING TOP SEAT AND COPING

There are two top seat/coping options for the Ultimate Round Pool. There is the (E) brown “synthetic wood” with the aluminum side mount bead receiver, and the (F) white bendable aluminum coping. Each option will be covered in the following pages.



### “SYNTHETIC WOOD”

This top seat is a brown “synthetic wood” with mounting brackets on the underside. Center the top seat on top of each pool wall panel. The 90° angled bracket hooks under the outside of the panel top as shown in photo G.

In your pool kit you will find sections of “dual track” white aluminum coping. To install the coping, you will need your power drill and a 5/16 hex head socket bit. Each section of coping should be positioned tight against underside of the top seat and attached to the pool wall using the self-drilling self-tapping hex head screws. These screws should pass through both the coping and the top seat bracket.

It is very important to make sure the top seat is pressed against the top of the panel and both the coping and top seat are centered on the panel and before mounting. These self-tapping screws should be installed a maximum of 6” apart to insure the coping is secure to the panel and the liner will not “pull down” the coping. Make sure not to overtighten screws or heads could break off causing the track to come loose. Use two layers of duct tape to cover the screw heads.

## INSTALLING TOP SEAT AND COPING

### INSTALLING TOP SEAT AND COPING (CONTINUED)

Locate the top cap joint covers and position them over each miter joint. Each cap hooks in the front first and secured to the top seat with color coated nails as shown in photo H.



# INSTALLING TOP SEAT AND COPING

## INSTALLING TOP SEAT AND COPING (CONTINUED)

### “BENDABLE ALUMINUM COPING”

The bendable aluminum coping is primarily used when pouring a concrete deck. This coping comes in 10ft sections.

After the coping is mounted, place a support bracket on the back side in the middle of each panel and behind each coping joint. Lock the bracket into the back of the coping and fasten it to the top of the panel using one of the self-drilling screws.

Finish the installation by snapping a coping cap over each butt joint.



## MOUNTING SKIMMER AND RETURN FITTINGS

### MOUNTING SKIMMER AND RETURN FITTINGS

Every Ultimate Pool is supplied with a pre-punched wall panel to mount the skimmer and return plumbing fittings. To mount the skimmer, simply insert the face of the skimmer through the rectangle opening in the wall and secure it using the two set screws supplied with the skimmer. If you have any questions, please refer to the manufacture's installation instruction in the skimmer package.



To install the return fitting, you need to un-thread the retaining nut from the fitting. Insert the threads through the pre-punched hole from the inside of the pool and tighten the retaining nut to the back of the fitting. **Be careful not over tighten this nut.**

Finishing up walls - Make sure to run duct tape down every panel seam to help with liner fitment.

# INSTALLING THE POOL BOTTOM

## INSTALLING THE POOL BOTTOM

The first thing you need to do is to remove any loose rocks from inside the pool and level the ground as flat as possible. Make sure the pool walls are clean then run a piece of duct tape down the face of each panel joint to cover the entire seam.

Remember that pencil line we drew on the bottom of the panels? Now you need to tie a string line to the perimeter pins inside the pool at the level of the pencil mark or 1½" up from the bottom of the panel. Then run a series of string lines across the pool to another pin. Continue doing this so you have several pie sections of string lines. The lines need to be taught so they will hold the level height of the finished bottom. The goal is to have at least 1½" of space between the string line and the virgin ground. Begin to transfer the bottom material into the pool.

The bottom mix should be damp but not wet. There are several materials that can be used to make up the pool bottom. Mason sand is the easiest, but you can also mix a 7 to 1 sand to Portland cement mixture to create a harder bottom that will not shift with foot traffic during the swim season. If you choose to go with a hard-bottom mixture and the sand is damp, **DO NOT ADD WATER;** just mix them together for a "sand castle" consistency. See your pool dealer for additional pool base options.



### INSTALLING THE POOL BOTTOM (CONTINUED)

Spread the bottom material around the floor of the pool and **COMPACT** it to cover the string lines as you go. Use the edge of a flat board (about 36" long) to scrape the excess bottom material to expose the string lines. Run a trowel across the surface to smooth it out. A rounded bottom trowel works best. Remember to pull your pins and fill in their divots as you progress.

### INSTALLING THE LINER

Remove the liner from the box and if possible, unroll it (end to end) in a clean, safe area near the pool. This will allow the vinyl to relax and the sun to soften the material as well. **DO NOT UNFOLD** the liner at this time. A warm flexible liner will be easier to install than a cold stiff one. Also be sure to save the safety/warranty packet for later.

Before installing the liner, double check the pool walls and the pool bottom for any dirt or sharp objects that could damage the vinyl material. Lastly, make sure the skimmer and return gaskets are in place.

Find the seam in the side wall of the liner and position the liner so it will align over the skimmer opening inside the pool. We do this in case the pattern at the seam does not match well. This tile section will be cut out when installing the skimmer faceplate. With several people in place, pick up the unrolled liner and rest it on the top seat of the pool. The liner is folded so that it can be pulled across the pool area as it unfolds. Try not to drag the liner across the pool bottom any more that you have to.

The top of the liner has a vinyl bead welded to it. Install the liner by inserting the liner bead into the bottom track of the white aluminum coping.

# INSTALLING THE LINER

## INSTALLING THE LINER (CONTINUED)

The weight of the vinyl pulling down will keep the bead in the coping. Make sure that the points around the perimeter of the liner floor match up with the panel joints of the pool wall. All wrinkles must be removed before filling with water.

If you have a soft "push broom" you can tap the bristle end against the base of the liner wall to help move the bottom material and remove any wrinkles.

Another trick is to insert a shop-vac hose through the top of the skimmer and down the pool wall through the rectangle opening behind the liner.

Keep the vacuum hose at least 15" up from the floor. Turn on the vacuum and suck the liner back against the wall. If your suction is poor, you may need to tape the skimmer lid closed where the vacuum hose was inserted.

If you are satisfied with the fit of the liner, start filling it with water. After you have between 6" and 8" of water in the pool, you can remove the vacuum hose and prepare cutting in the skimmer and return fittings.



### CUTTING IN SKIMMER AND RETURN OPENINGS

Now that the water level in the pool is at least 6" deep, the side wall vinyl should be stretched tight enough to install the skimmer and return face plates. You will need a #3 Phillips head screwdriver and a good razor edge to install these plates.

Note: Do not use a power screwdriver to install these screws. Over tightening can cause the holes to strip or the face plate to crack. If you have any questions, please refer to the installation instructions supplied with each fitting.

Find the twelve flat head skimmer screws that came with the skimmer along with the rectangle face plate and gasket.

To start the mounting of the skimmer face plate, you must first find the four corner holes. Push your finger against the liner to find the round depression of the screw sockets for each corner screw. Push the tip of the #3 Phillips screw driver against the depression and turn the screwdriver to mark the vinyl. Insert one of the top corner screws through the face plate and gasket and drive it through the vinyl liner into the skimmer. Make sure the gasket is attached to face plate before mounting. Continue installing the other corner screws and fill in the blanks to complete. Do not over tighten.

## CUTTING IN SKIMMER AND RETURN OPENINGS

### CUTTING IN SKIMMER AND RETURN OPENINGS (CONTINUED)

After the plate is mounted insert the razor edge through the vinyl at the inside edge of the face plate. Slowly run the blade around the inside perimeter and remove the section of material. You may want to keep this section of liner for future patch material.

The return fitting face plate is installed in a similar manner as the skimmer. First find the round face plate and the pack of four faceplate screws supplied with the fitting.

Note: There is no gasket installed between the liner and the return face plate. Press your finger against the liner to locate and mark the (4) holes. Screw down the faceplate with the #3 Phillips screw driver and cut out the center section of vinyl with the razor edge.

To finish, snap on the face plate escutcheon to hide the screw heads. The return fitting has a directional eye that threads into the fitting. The directional eye should be positioned in an upward position away from the skimmer. The purpose of this fitting is to move the surface water around the pool and back to the skimmer. This fitting should not be tightened completely, only positioned for easy adjustment.



## INSTALLING THE FILTRATION EQUIPMENT

There are many types of equipment designed to filter the swimming pool water. Please check with your local pool dealer for the proper sizing and filter media to meet your needs. The Ultimate Pool comes with a 1 ½" PVC threaded orifices on the skimmer and pool water return.

When installing the plumbing lines, make sure that the skimmer is connected to the front (suction) of the pump and the return fitting is connected to the discharge side of the filter. Shut off valves are recommended for service and maintenance on this equipment.



# INSTALLING VERTICAL SIDING

## INSTALLING VERTICAL SIDING

With the Ultimate Round Pool, you have the option to skirt the outside walls with a vertical vinyl siding. The vinyl siding kit comes complete with a hardware packet, pre cut "J" channels and vinyl siding to cover the outside perimeter of the pool wall.

To start this installation, attach the first section of "J" channels to the pool panel next to the skimmer panel. The "J" channel is placed upside down so that it is seated under the top seat and against the pool wall flange as shown. Each section of "J" channels is held on by four (4) of the self-drilling self-tapping hex head screws. Note: The slotted holes in the "J" channels are not used for this application.

To get the screws started, you need to hold back the front edge of the "J" channel so that the screws can have the angle to penetrate into the steel. Continue installing the "J" channel to the top of each pool panel. Do not install a "J" channel onto the top or bottom of the skimmer panel.

Install a section of "J" channels to the bottom of each panel following the same steps as the top installation.



## INSTALLING VERTICAL SIDING (CONTINUED)

There is a wind stability plate for each panel. To install this plate you must remove the adjacent panel bolts from the wall assembly, insert the plate over the holes and re-install the bolts. The plate should be staggered from one panel to the next using the third and/or fourth bolt hole from top and bottom.

After the stability plates are installed, insert the clear, self-adhesive rubber bumper between the plate and the center wall stiffener as shown. The final phase is to install the vinyl siding. The vinyl siding is pre-cut to fit between the "J" channels we installed earlier on the top and bottom of the panels.

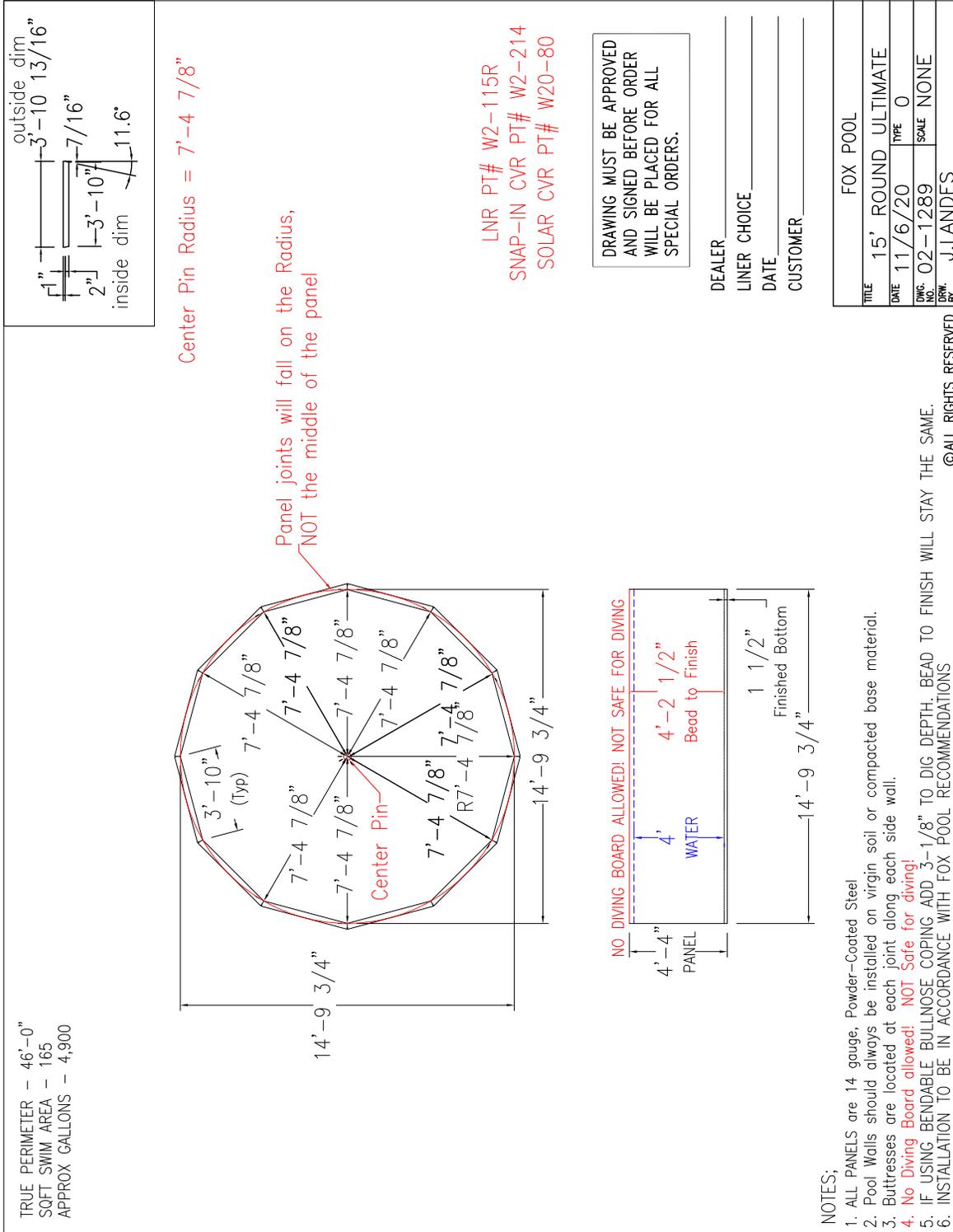
To install the siding simply insert the bottom of the siding panel into the bottom "J" channel, then gently flex the siding in the middle and insert it into the upper "J" channel. Insert the second siding panel next to the first and lock them together.

Continue this process around the pool to the opposite side of the skimmer panel. Secure the end pieces of siding to the stability plates using a hex headed self-drilling self-taping screw at each plate. This procedure will help prevent wind damage to the siding.



# POOL DRAWINGS

## 15FT ROUND WITH NO STAIR



## 15FT ROUND WITH STAIR

TRUE PERIMETER - 46'-3 1/2"  
 SOFT SWIM AREA - 168  
 APPROX GALLONS - 5,000

Center Pin Radius = 7'-4 7/8"

LNR PT# W2-15RS  
 SNAP-IN CVR PT# W2-214  
 SOLAR CVR PT# W20-80

DRAWING MUST BE APPROVED AND SIGNED BEFORE ORDER WILL BE PLACED FOR ALL SPECIAL ORDERS.

DEALER \_\_\_\_\_  
 LINER CHOICE \_\_\_\_\_  
 DATE \_\_\_\_\_  
 CUSTOMER \_\_\_\_\_

NO DIVING BOARD ALLOWED! NOT SAFE FOR DIVING

4'-4" PANEL  
 4'-2 1/2" Bead to Finish Water  
 1 1/2" Finished Bottom

**NOTES:**

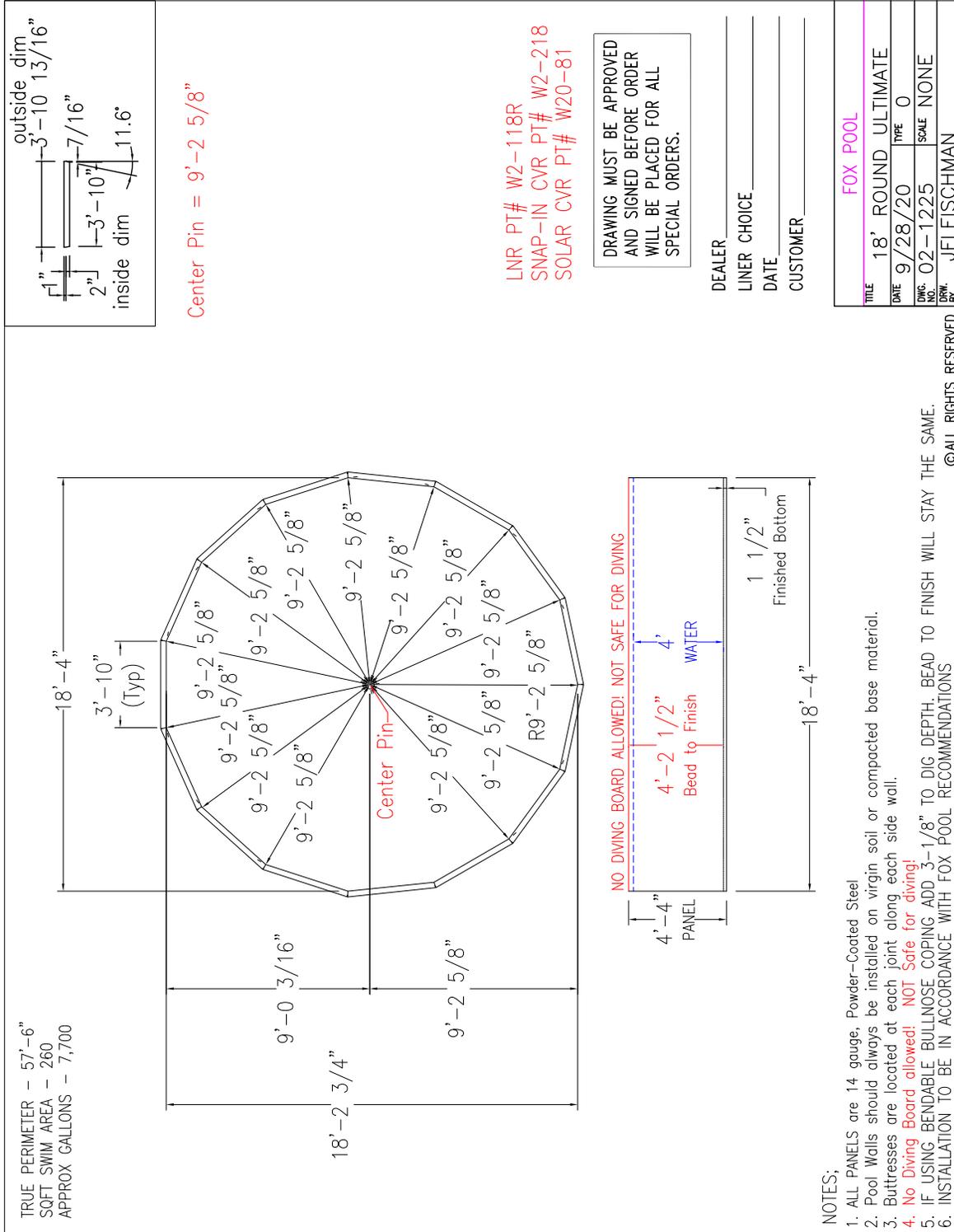
1. ALL PANELS are 14 gauge, Powder-Coated Steel
2. Pool Walls should always be installed on virgin soil or compacted base material.
3. Buttresses are located at each joint along each side wall.
4. No Diving Board allowed! NOT Safe for diving!
5. IF USING BENDABLE BULLNOSE COPING ADD 3-1/8" TO DIG DEPTH. BEAD TO FINISH WILL STAY THE SAME.
6. INSTALLATION TO BE IN ACCORDANCE WITH FOX POOL RECOMMENDATIONS

|          |           |       |      |
|----------|-----------|-------|------|
| TITLE    | FOX POOL  |       |      |
| DATE     | 11/6/20   | TYPE  | 0    |
| DWG. NO. | 09-18505  | SCALE | NONE |
| DRW. BY  | J. LANDES |       |      |

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# POOL DRAWINGS

## 18FT ROUND WITH NO STAIR



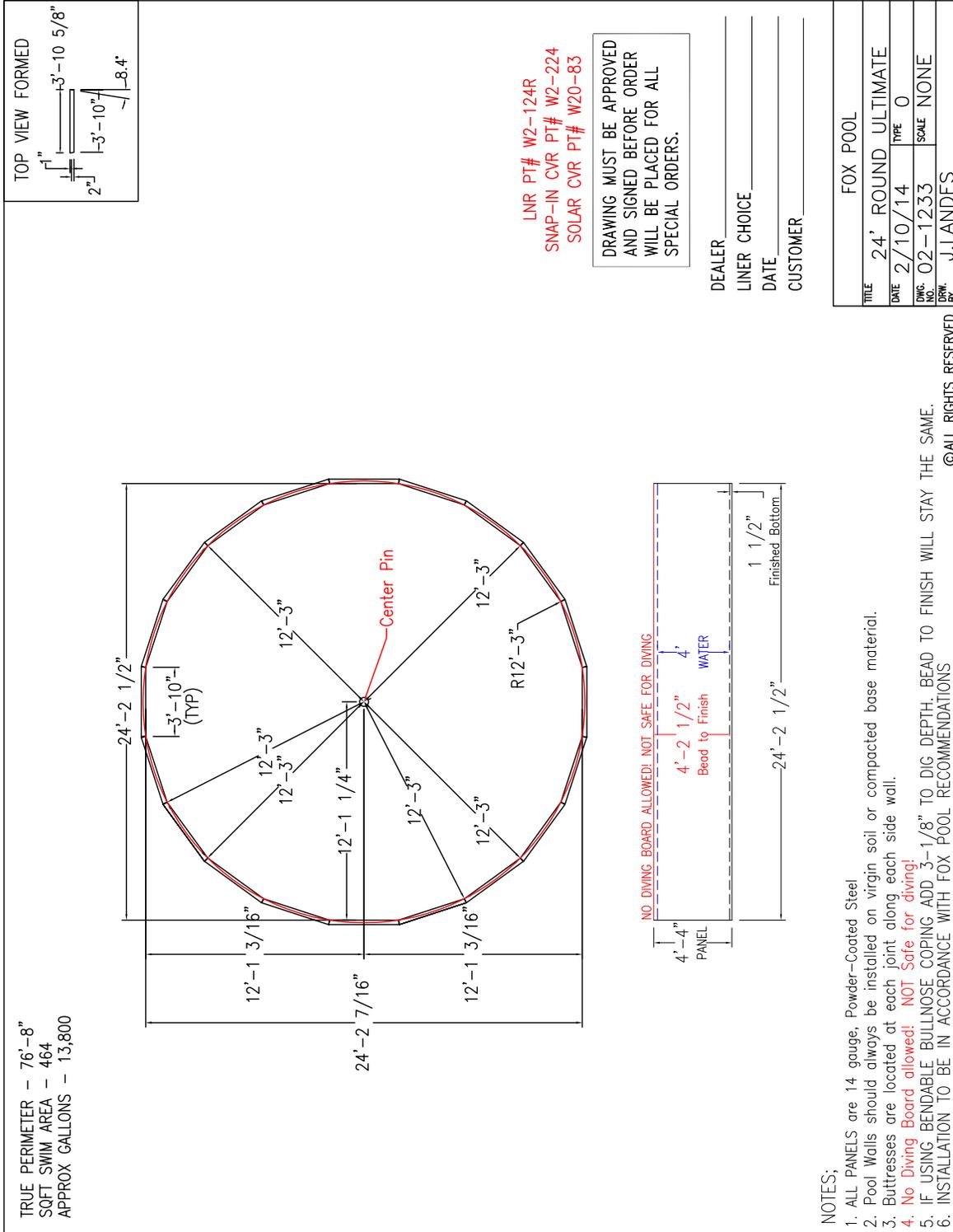




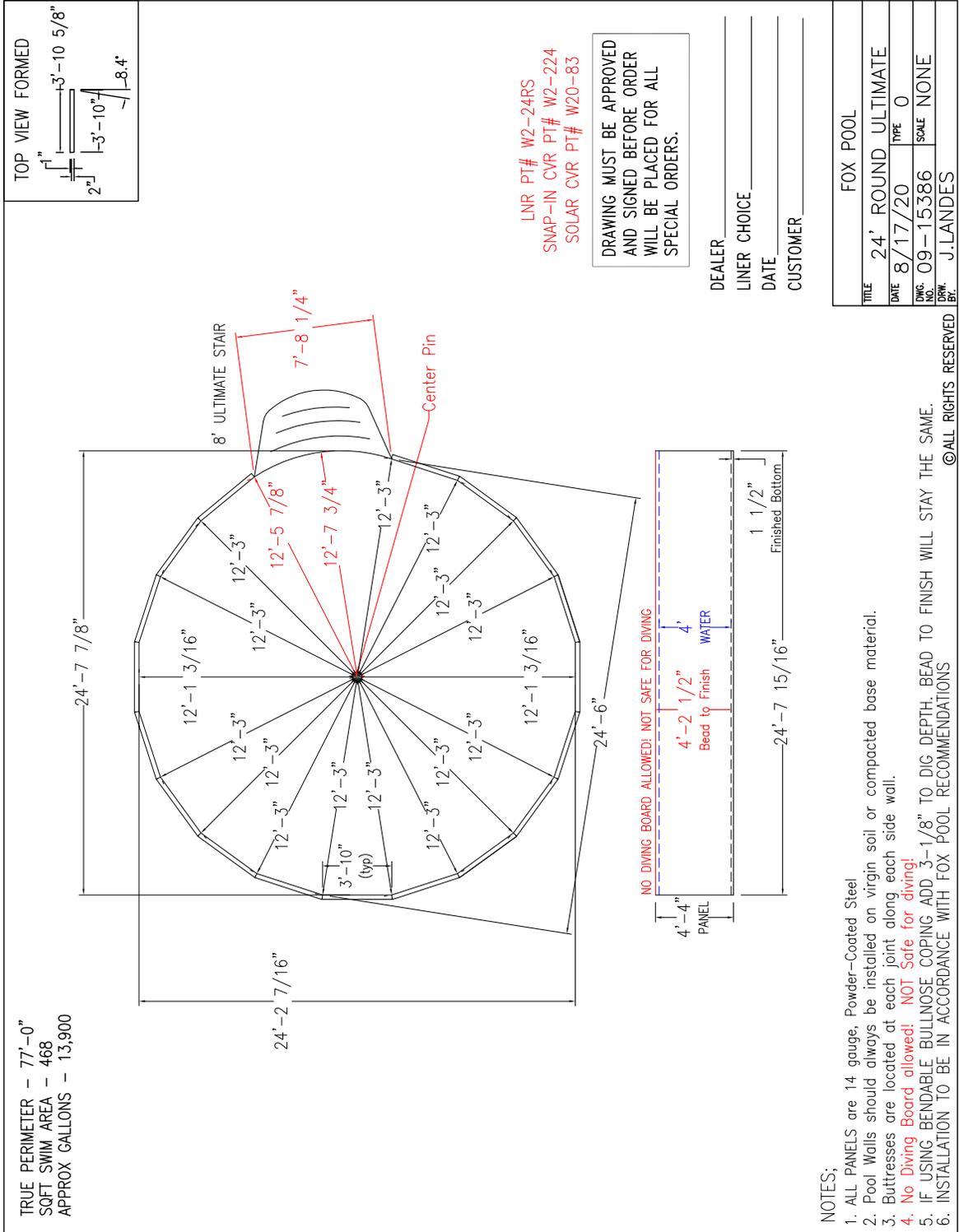


# POOL DRAWINGS

## 24FT ROUND WITH NO STAIR



## 24FT ROUND WITH STAIR





## 28FT ROUND WITH STAIR

