



GrowSpan™ Round Premium High Tunnels (CR and FR Models)

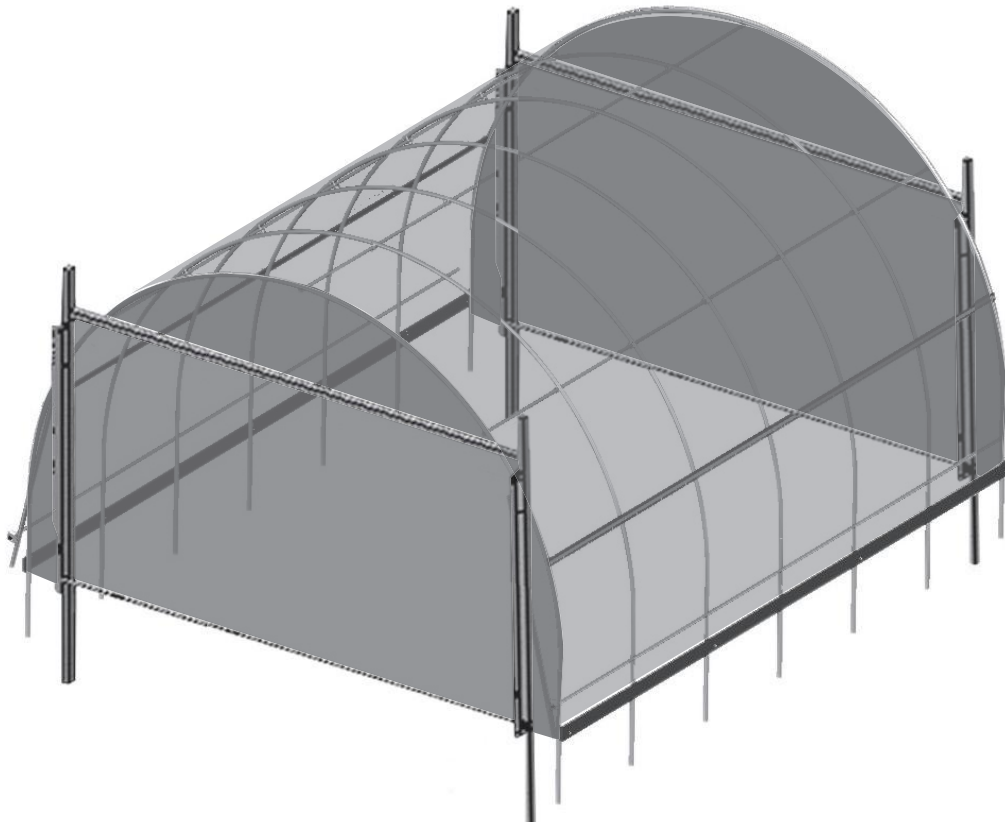


Photo may show a different but similar model.

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WARNING: Cancer and Reproductive Toxicity - P65Warnings.ca.gov

Revision date: 10.25.21

STK#	DIMENSIONS
PB01670R4	20' W x 12' H x 24' L
PB01675R4	20' W x 12' H x 36' L
PB01680R4	20' W x 12' H x 48' L
PB01685R4	20' W x 12' H x 72' L
PB01690R4	20' W x 12' H x 96' L



YOU MUST READ THIS DOCUMENT BEFORE YOU BEGIN TO ASSEMBLE THE SHELTER.

Thank you for purchasing this GrowSpan™ high tunnel. When properly assembled and maintained, this product will provide years of reliable service. These instructions include helpful hints and important information needed to safely assemble and properly maintain the high tunnel. Please read these instructions **before** you begin.

If you have any questions during the assembly, contact Customer Service for assistance.

SAFETY PRECAUTIONS

- Wear eye protection.
- Wear head protection.
- Wear gloves when handling metal tubes.
- Use a portable GFCI (Ground Fault Circuit Interrupter) when working with power tools and cords.
- Do not climb on the high tunnel or framing during or after construction.
- Do not occupy the high tunnel during high winds, tornadoes, or hurricanes.
- Provide adequate ventilation if the structure is enclosed.
- Do not store hazardous materials in the high tunnel.
- Provide proper ingress and egress to prevent entrapment.

ANCHORING INSTRUCTIONS

Prior to assembling this high tunnel, please read the **MUST READ** document included with the shipment.

⚠ WARNING: The anchor assembly is an integral part of the high tunnel construction. Improper anchoring may cause high tunnel instability and failure of the structure. Failing to anchor the high tunnel properly *will void the manufacturer's warranty* and may cause serious injury and damage.

LOCATION

Choosing the proper location is an important step before you begin to assemble the structure.

The following suggestions and precautions will help you determine whether your selected location is the best location.

- Never erect the structure under power lines.
- Identify whether underground cables and pipes are present *before* preparing the site or anchoring the structure.
- Location should be away from structures that could cause snow to drift on or around the building.
- Do not position the high tunnel where large loads such as snow and ice, large tree branches, or other overhead obstacles could fall.

SITE

After choosing a location, proper preparation of the site is essential. Follow the information below.

- *A level site is required.* The site must be level to properly and safely erect and anchor the structure.
- For sites that are not concrete or gravel, placing wood blocks or other suitable supports under each rafter leg helps prevent the pipes from sinking or working into the site.
- **Drainage:** Water draining off the structure and from areas surrounding the site should drain away from the site to prevent damage to the site, the structure, and contents of the structure.

⚠ WARNING: The individuals assembling this structure are responsible for designing and furnishing all temporary bracing, shoring and support needed during the assembly process. For safety reasons, those who are not familiar with recognized construction methods and techniques must seek the help of a qualified contractor.

ASSEMBLY PROCEDURE

Following the instructions as presented will help ensure the proper assembly of your high tunnel. Failing to follow these steps may result in an improperly assembled and anchored high tunnel and will void all warranty and protection the owner is entitled.

The steps outlining the assembly process are as follows:

1. Verify that all parts are included in the shipment. Notify Customer Service for questions or concerns.
2. Read these instructions, the Must Read document, and all additional documentation included with the shipment **before** you begin assembling the high tunnel.
3. Gather the tools, bracing, ladders (and lifts), and assistance needed to assemble the high tunnel.
4. Check the weather **before** you install the roof cover and any panels (if equipped). Do not install covers or panels on a windy or stormy day.
5. Re-evaluate the location and site based on the information and precautions presented in the documentation included with the shipment.
6. Prepare the site (if applicable).
7. Assemble the frame components in the order they are presented in these instructions.
8. Assemble the frame including the struts (if equipped).
9. Consult the MUST READ document and properly anchor the assembled frame.
10. Install, tighten, and secure the end panel and main cover (if equipped). This applies to fabric covers that stretch over the frame assembly. Your shelter may include roof panels or side panels or both.
11. Read the Care and Maintenance information at the end of these instructions.
12. Complete and return all warranty information as instructed.

REQUIRED TOOLS

The following list identifies the main tools needed to assemble the shelter. Additional tools and supports may be needed depending on the structure, location, and application.

- Tape measure or measuring device
- Fine point marker to mark the location on tubing.
- Variable speed drill/driver (cordless with extra batteries works best)
- Wrench, ratchet and socket (recommended)
- Scissors
- Ropes long enough to reach over the frame.
- Hammers and gloves
- Metal file
- Duct tape
- Box cutter or utility knife
- Ladders, work platforms, and other machinery for lifting designed to work safely at the height of the frame

UNPACK AND IDENTIFY PARTS

The following steps will ensure that you have all the necessary parts before you begin to assemble the shelter frame.

1. Unpack the contents of the shipment and place where you can easily inventory the parts. Refer to the Bill of Materials/Spec Sheets.
2. Verify that all parts listed on the Bill of Materials/Spec Sheets are present. If anything is missing or you have questions, consult the Pictorial Parts Guide and all diagrams for clarification, or contact Customer Service.

NOTE: At this time, you do not need to open the plastic bags containing smaller parts such as fasteners or washers (if equipped).

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SHELTER ACCESSORIES AND CONSTRUCTION SUGGESTIONS

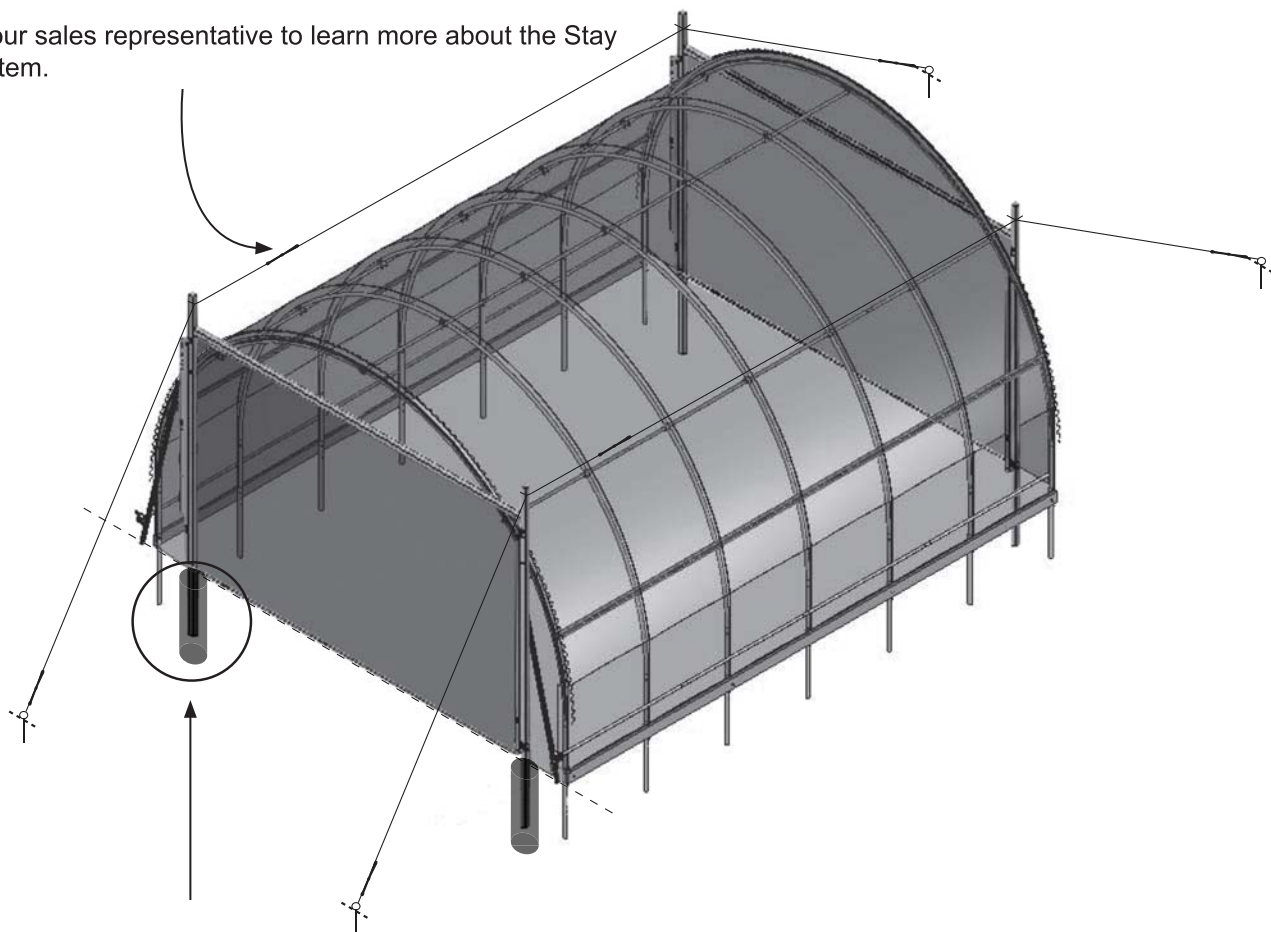
The diagram below describes accessories available for your building and suggests ways to improve the stability of the customer-supplied end framing. Contact your sales representative to purchase or to learn more about accessories.

Stay Cable System

The Stay Cable System provides additional support to the building frame and customer-supplied end framing. When properly installed, stay cables help stabilize the main frame and end wall frame, especially in areas where strong winds are common.

Stay Cable Systems are shipped complete with cable, turnbuckles, and all the necessary clamps to secure the cable to the building, end frame, and ground anchors.

Contact your sales representative to learn more about the Stay Cable System.



Customer-Supplied End Framing Installation

In areas where loose or sandy soil conditions are found or where deep frost is common, setting the customer-supplied end frame posts in concrete is recommended. This helps prevent shifting and provides an additional level of stability in extreme climates and during adverse weather-related conditions.

Always consult local and regional building codes and follow construction practices common to the area when setting the customer-supplied end frame posts.

End frame materials and concrete are supplied by the customer. A treated 4" x 4" post is recommended for each jamb and header. In areas where quality 4" x 4" posts are not available, place two 2" x 6" boards of the required length together and secure these using exterior fasteners to create a single 2-ply post. Off-set and reinforce any joints when short pieces of lumber are used to construct the same post. DO NOT ALIGN JOINTS!

CUSTOMER-SUPPLIED MATERIALS — Baseboard, Ribbon Boards, & Wood Screws

Baseboards and ribbon boards are optional, but recommended, for buildings with roll-up sides. Materials for baseboards and ribbon boards are *not included* and are *supplied by customer*.

ATTENTION: Fasteners to secure boards to building frame are included. *Recommended* lumber dimensions shown; wider boards can be used if desired. Counter sink holes for 1/4" carriage bolts if bolt length is too short for board thickness.

BASEBOARDS

The baseboard, when installed properly, helps prevent the ground posts from sinking into the ground when anchored. Depending on the building, it also provides a surface to attach struts or other building components.

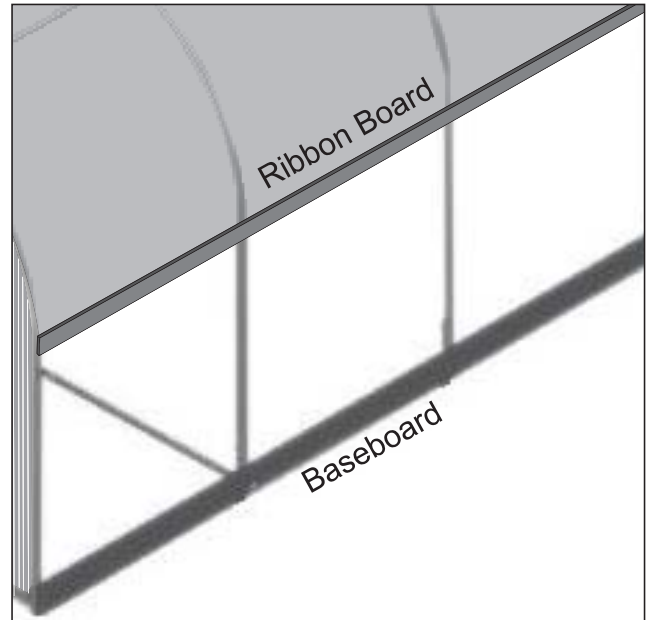
ATTENTION: Baseboards run the frame length along both sides at ground level. Installation of customer-supplied baseboard is described later in this guide.

RIBBON BOARDS

A ribbon board typically runs a few feet above the ground along the sidewall. It serves as a mounting surface for the u-channel that secures the main cover and roll-up portion of the main cover.

MATERIAL DIMENSIONS

- Baseboards: 2" x 6" (minimum)
- Ribbon Boards: 2" x 4" or 2" x 6" (recommended)



Actual frame may differ from example shown.

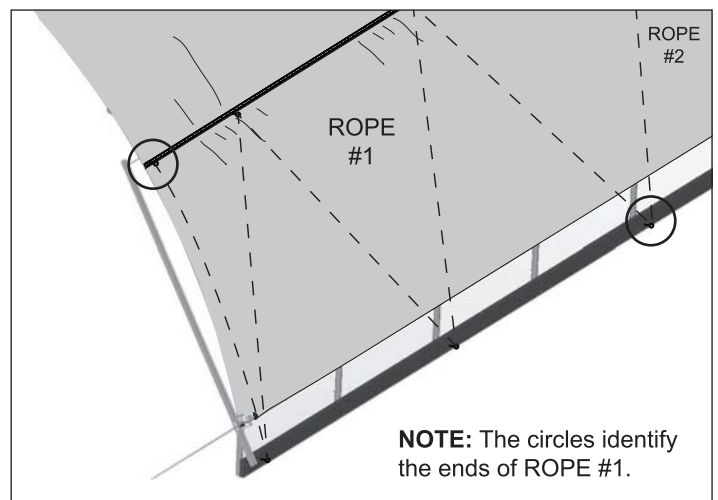
IMPORTANT: IF RIBBON BOARDS ARE USED, PURCHASE WOOD SCREWS TO ATTACH THE U-CHANNEL TO THE INSTALLED RIBBON BOARD.

TEK SCREWS ARE NOT WOOD FASTENERS. NEVER USE TEK SCREWS TO SECURE ANY COMPONENT TO WOOD. THEY WILL NOT HOLD.

ANTI-BILLOW ROPE INSTALLATION

TO PREVENT DAMAGE AND POSSIBLE INJURY, INSTALL THE ANTI-BILLOW ROPES IN SHORT LENGTHS ALONG EACH SIDE OF THE FRAME.

DO NOT INSTALL AS A SINGLE LENGTH TIED AT EACH END OF THE BUILDING. DOING SO WILL RESULT IN A LOOSE SIDE PANEL IF THE SINGLE ROPE BREAKS DURING STRONG WINDS.



NOTE: The circles identify the ends of ROPE #1.

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The following graphics and photos will help you identify the different parts. (Some parts are not shown.)



102856 End Clamp 102548 Cross Connector 102717 Gearbox Drive



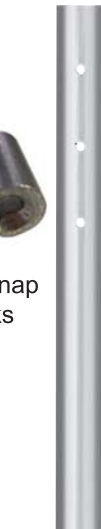
102197 Poly Latch U-Channel 102570 Aluminum Channel



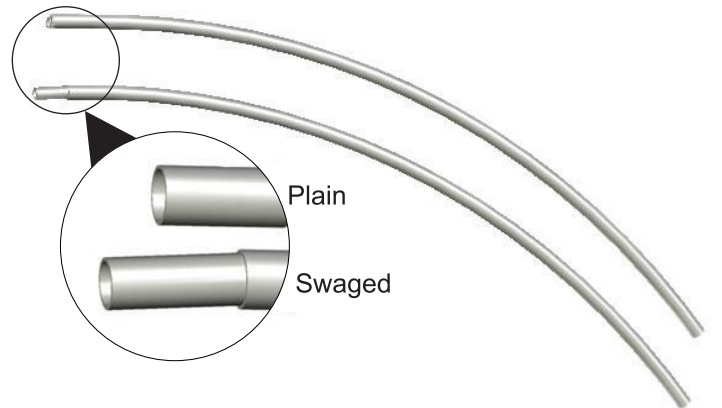
102569 Bearing 103544 Mounting Plate 117063 EZ-Snap Rope Hooks



CC6212 Fabric Clips FA4482B Tek Screw 103496 Gear Box



102675 Ground Post



Swaged and Plain Rafter Sections

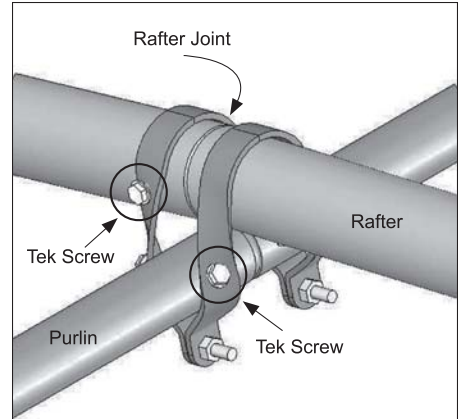


102198 U-Channel Spring

FRAME ASSEMBLY NOTE

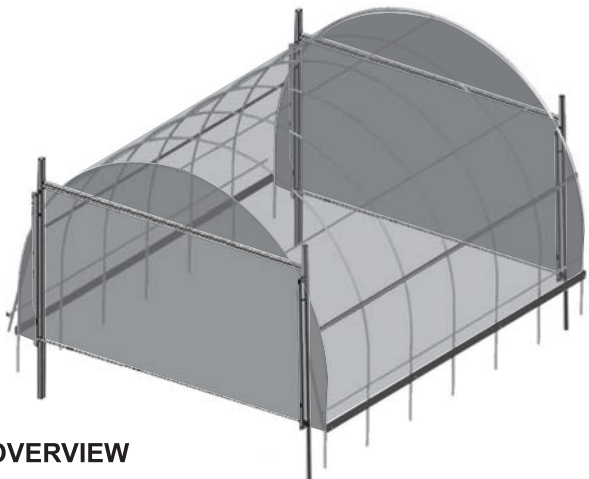
During the assembly of the frame, install a Tek screw through each clamp into the rafter and through each clamp into the purlin.

Position all Tek screws so they will not touch the cover material once it is installed.



MATERIAL IDENTIFICATION NUMBERS FOUND ON THE BILL OF MATERIALS

- **DCC4931**—This number identifies the bulk material used to cover the open areas of the end frame and door frame: See End Panel Location and Door Frame Panel Location diagrams in the Quick Start section of this guide.
- **QED108181**— This sku represents the material used for the 16'W x 10'H roll-up doors for all 20' wide buildings. There are two (2) panels of identical dimensions. These panels include a pocket at the bottom and installed grommets along each side. The top of the panel, which is attached to the door frame, is plain.
- **Main Cover**— *Buildings* with the FR identification number (e.g., PB01675R4FR) have a 5.2oz clear fabric main cover; cover part number begins with the letters **QC**. *Buildings* with the CR identification number (e.g., PB01675R4CR) include a film cover identified by a six digit sku number; there are no letters in the film identification number.



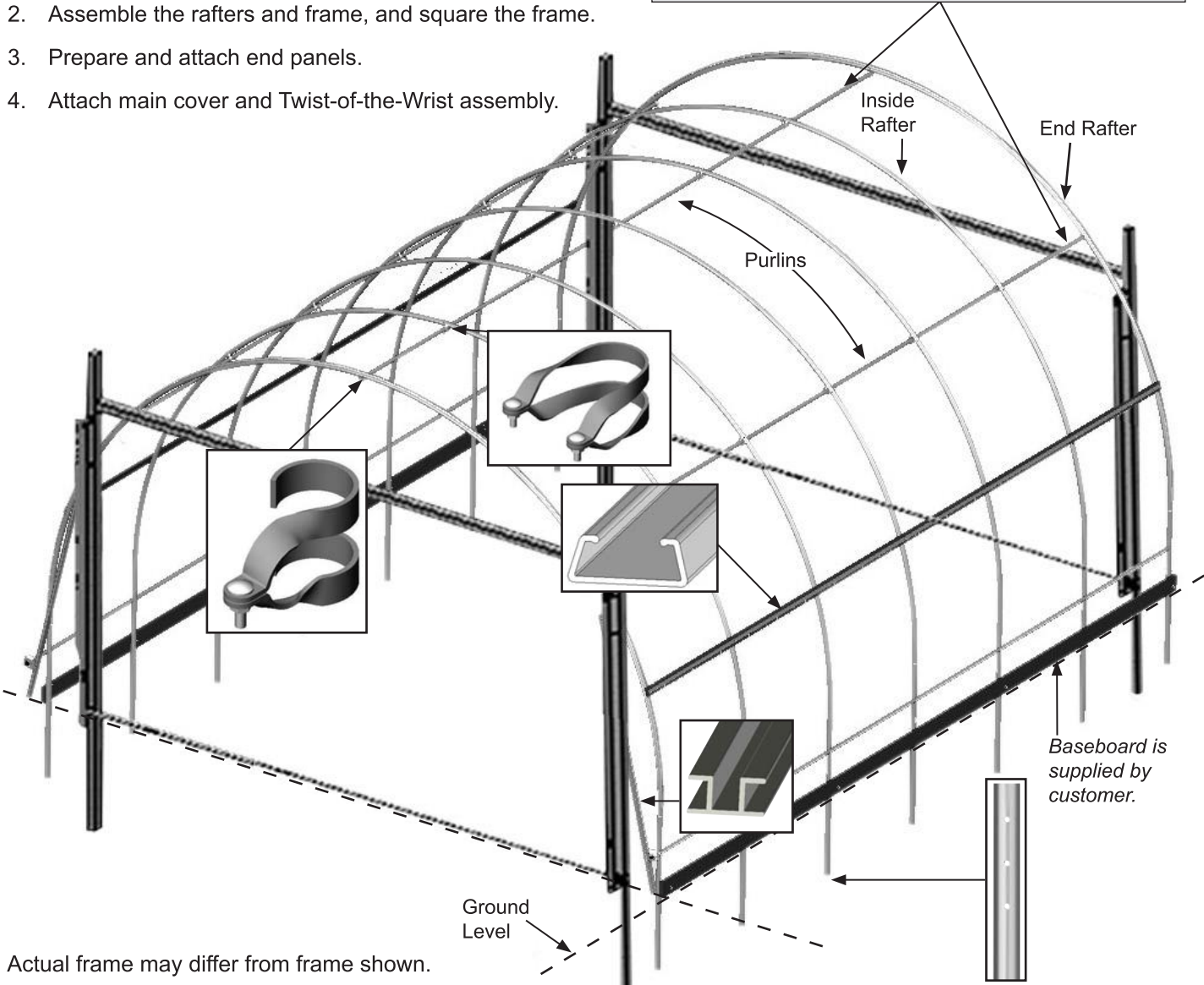
Round Premium High Tunnels

OVERVIEW

This section is an overview of the process for assembling your high tunnel. For details, please see section, Assembling the High Tunnel Frame Components. See illustration below to identify main parts of high tunnel.

1. Locate the required parts for each assembly procedure.
2. Assemble the rafters and frame, and square the frame.
3. Prepare and attach end panels.
4. Attach main cover and Twist-of-the-Wrist assembly.

ATTENTION: Position purlins evenly during the frame assembly. Use the rafter pipe joints as guides when installing the end clamps, cross connectors, and purlins. Saddle all purlins (except the top, center purlin) in the joint created by the separate rafter pipes. See details in the Quick Start Guide.



Actual frame may differ from frame shown.

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LAY OUT THE BUILDING SITE

After the site is prepared, lay out the building site.

Taking these steps **before** assembling the shelter saves time and ensures that the structure is positioned as desired.

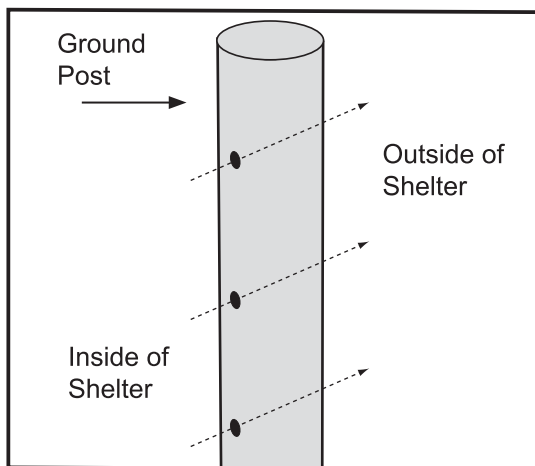
Ground posts must be driven to the proper depth. Width of the shelter is measured from the center of one ground post to the center of the remaining ground post.

SQUARE THE SITE

Gather the parts:

- Ground posts (#102675)
 - 5/16" x 2-1/2" machine bolts
 - 5/16" nuts
1. Identify a corner where a ground post will be positioned and drive the first ground post into the ground.

NOTE: Insert the ground post driver into the top of the ground post to protect the post and drive the post into the ground. *The top of the post will be one (1) foot above the finished grade when properly driven.*



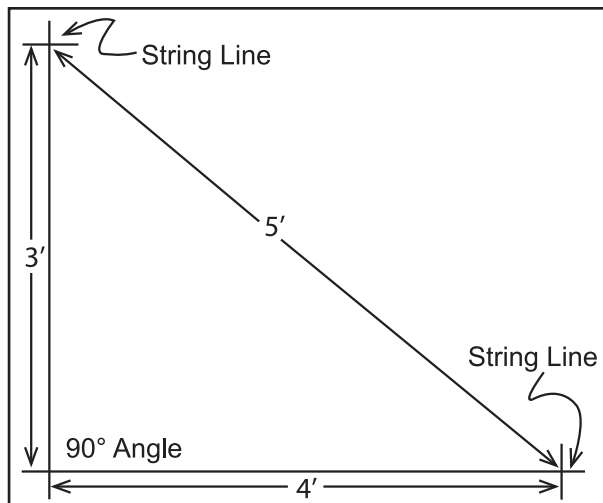
ATTENTION: Position the pre-drilled holes facing to the inside/outside of the shelter so they can be aligned with the bolt holes in the rafter legs.

To align the bolt holes in the ground posts with those in the rafter *after driving the ground posts*, insert a tapered rod or pry bar into a ground post bolt hole and turn the post using the rod or pry bar.

2. After the first corner ground post is in place, string a line the width of the building (center-to-center) and drive the second ground post into the ground just enough to hold it in place.
3. Use a transit or line level to drive the second corner post to the same depth as the first ground post.

4. String a line at least as long as the building from the first stake at 90°.

NOTE: A transit can be used to ensure an accurate 90° angle, or the 3-4-5 rule can be used. Refer to diagram. Using multiples of 3-4-5 such as 6-8-10 or 12-16-20 helps to maintain an accurate 90° angle.



5. After squaring the position of the building, measure the length and drive the next corner ground post.
6. Repeat the same step for the last corner post.

NOTE: The distance measured diagonally between corner posts must be equal for the building to be square.

7. Check all dimensions (and adjust if needed) before driving the remaining posts to the required height.
8. After all corner posts are accurately installed, tie a string line between the tops of the corner ground posts on the same side of the shelter. The string is used to identify the tops of all remaining ground posts. The string must remain tight and level.
9. Use a tape measure to mark the 48" on-center locations of the remaining ground posts.
10. Drive the remaining ground posts into the ground at the required 48" on-center width and the height identified by the string.

NOTE: Verify that the holes in the ground posts are in the proper position and that each post is plumb and driven to the correct depth.

After the rafters have been assembled, the rafter ends are secured to the ground post using the upper hole.

The bottom two (2) holes on the ground post are used for the optional baseboards.

11. Continue with the **Rafter Assembly** steps that follow.

ASSEMBLING THE HIGH TUNNEL FRAME COMPONENTS

NOTE: Assistance is required to assemble the high tunnel frame.

RAFTER ASSEMBLY

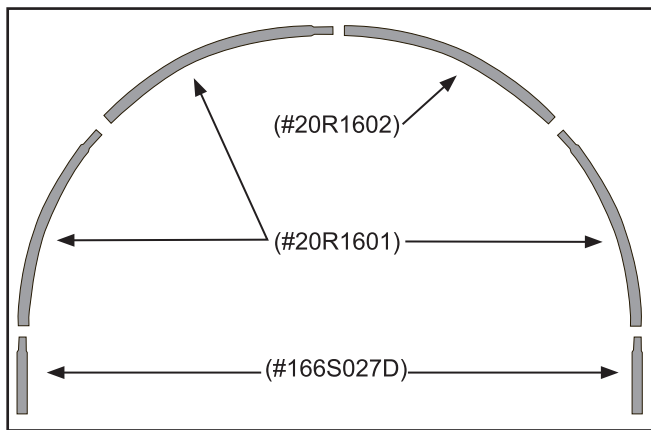
Gather the parts:

- Rafter pipe #20R1601
- Rafter pipe #20R1602
- Rafter pipe #166S027D
- End clamps
- Tek screws
- Nut setter (3/8" x 2-9/16 magnetic)

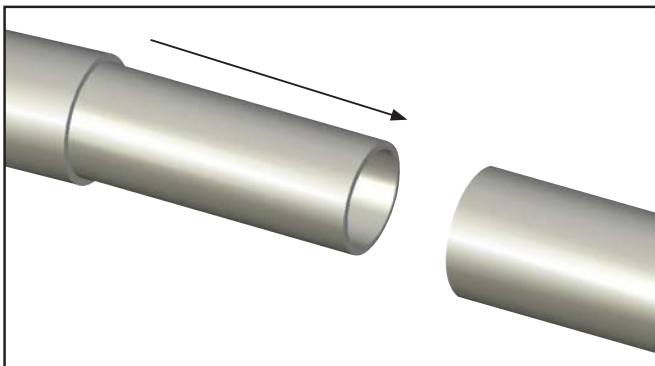
Rafter Assembly Procedure

Each rafter assembly consists of six (6) rafter sections: three (3) swaged sections, one (1) non-swaged (plain) section, and a pair of swaged extensions.

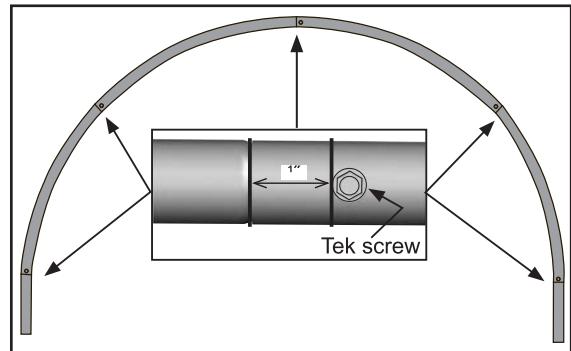
1. Select the six (6) pipes needed to assemble a rafter and arrange these on a flat surface as shown below for assembly.



2. Slide the swaged portion of each rafter pipe into the plain end of the pipe as shown.



3. With the main rafter pipes seated at each joint and the rafter positioned on a flat surface, secure each joint with a single self-tapping Tek screw.



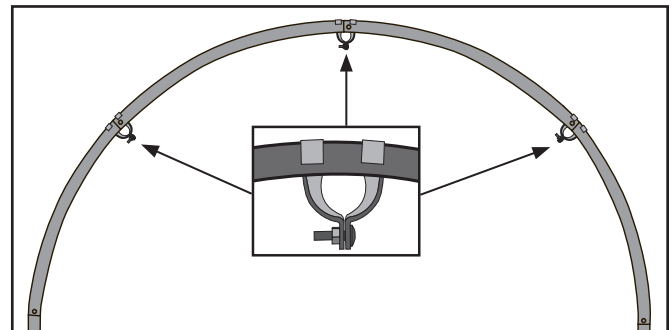
ATTENTION: Do not secure the drilled leg pipes until rafter is secured to the ground posts. This allows holes in rafter legs to be aligned with those in ground post. Install the screws so they will not touch the cover once it is installed. This is typically on the backside of the rafter, which will be the surface visible from the *inside* of the high tunnel once the frame is assembled.

4. Assemble rafters as described and continue with the additional steps to complete the assembly of the two (2) end rafters.

END RAFTER ASSEMBLY

In addition to the steps in the previous procedure, complete the following steps *for the two (2) end rafters only*.

1. Take one of the assembled rafters and place it on a flat surface.
2. Slide three (3) end clamps onto the rafter in the locations noted below. (Do not secure the clamps to the rafter at this time. These clamps will be repositioned during the frame assembly when the purlins are added.)



NOTE: Position all clamps as shown. Use a piece of duct tape (if desired) to keep each clamp from sliding when the rafter is lifted into position.

View of the end rafter and clamps as shown from the *outside* when the frame is assembled.

3. Repeat the same procedure for the final end rafter.
4. Continue with the **Frame Assembly** instructions that follow.

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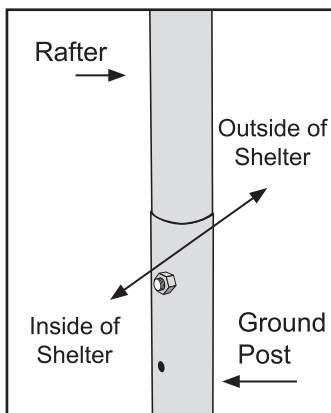
FRAME ASSEMBLY

Gather the parts:

- All rafter assemblies
- Pipe 1.315" x 75" swaged (#131S075)
- Pipe 1.315" x 73.5" plain (#131P0735)
- 5/16" x 2-1/2" machine bolts (#FAG336B)
- 5/16" Nuts (#FALB02B)
- Lifts, ladders, and assistants

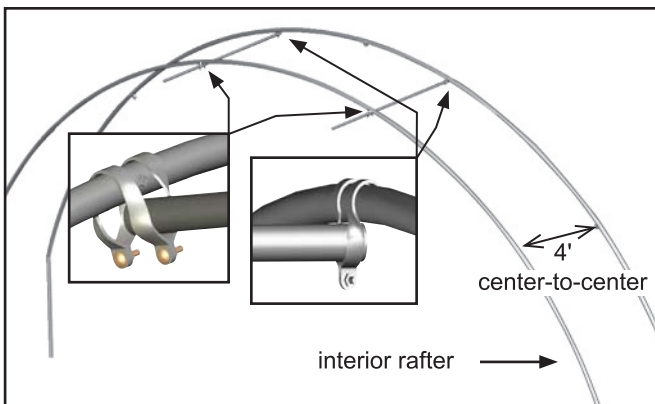
Frame Assembly Procedure

1. Using the proper lifts and with assistance, carefully stand the first end rafter assembly and place the leg pipes into the first set of ground posts.



IMPORTANT: Brace the first rafter in position as needed to keep it from moving. Bracing is removed *after* additional rafters are installed and secured to the other rafters.

2. Secure the leg pipes to the ground posts using the 5/16" x 2-1/2" machine bolts and nuts.
3. Place an interior rafter assembly into a second set of ground posts. Secure the leg pipes to the ground posts as previously described.
4. Position two (2) cross connectors near the top of the interior rafter assembly as shown below.



5. Take two (2) swaged 75" purlin sections and insert each through an upper clamp on the end rafter and through the cross connectors near the top of the interior (or second) rafter as shown above.

6. Verify that both rafters are plumb and properly spaced (4' on center).
7. Tighten the upper cross connectors on the interior rafter and tighten the end clamps near the top of the end rafter to secure the first purlin pipes.

NOTE: Do not allow the purlin to extend beyond the end of the end rafter. See diagram below.

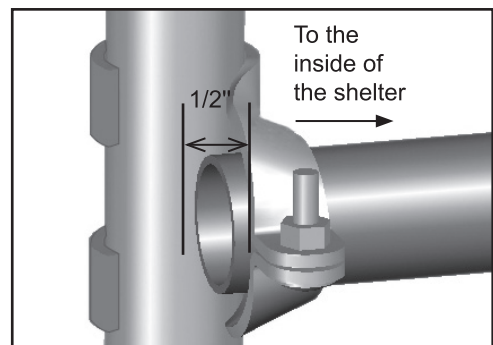
8. Continue adding rafters and purlin pipe until the frame is assembled. Secure all purlin splices using Tek screws. See Step 10.

NOTE: Each purlin assembly consists of 1.315" x 75" (#131S075) swaged pipes (number is determined by shelter length) and one (1) 1.315" x 73.5" (#131P0735) plain pipe.

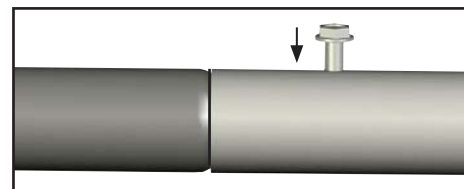
9. Finish each purlin run using the plain, shorter pipe (#131P0735), and use the final end rafter to complete the assembly.

NOTE: If the last end rafter is plumb and the purlin run extends beyond the end of the rafter, cut the last section of purlin pipe to the required length. Typically purlin pipes *do not* require cutting. *Verify that you have the correct plain pipes before you decide to cut any pipe to complete the purlin runs.*

CAUTION: To prevent cover damage, the ends of the purlins should extend no more than 1/2" past the end clamp. Position the bolt side of the end clamps toward the "inside" of the shelter (the same side as the purlin).



10. Once all rafters are set and all purlins are in place and secured, return to each pipe splice of each purlin run and install a Tek screw through the pipes to secure the joints if this was not completed during assembly.



11. Return to each rafter and, using Tek screws, secure the joint between the lower rafter legs (drilled pipe) and the upper rafter pipes and continue with the following procedure.

BASEBOARD INSTALLATION (RECOMMENDED)

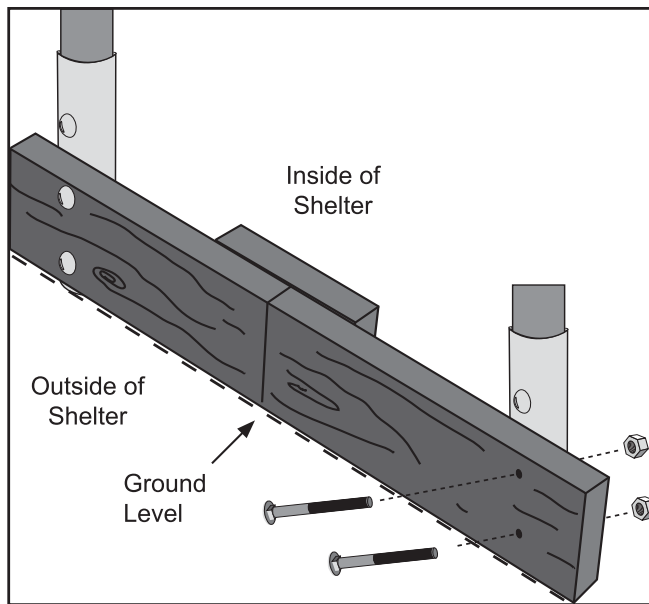
Gather the parts:

- Treated or recycled plastic lumber (supplied by customer). **Recommended: 2" x 6"**.
- 1/4" x 4" carriage bolts and nuts (may not work for baseboards with a thickness greater than 1-1/2")



NOTE: The following procedure describes one way to install the recommended baseboards. The size and type of the baseboard you choose may require the use of alternative steps. When properly installed, baseboards run the length of the frame.

On the outside of the frame, attach the first baseboard to the ground posts using the 1/4" x 4" carriage bolts (FAH009B) and nuts (FALB01B). Continue adding baseboards to complete the first run. Splices are made between posts as shown. Use a short section of baseboard to secure separate baseboards at a splice.



NOTE: The boards should be at ground level or slightly into grade to prevent the shelter from sinking and to create a seal along the bottom. After installing the baseboards, continue with these instructions.

This baseboard is *not included* with the shipment and must be supplied by the customer. Treated or recycled plastic lumber works well for a baseboard.

Recommended dimension: 2" x 6".

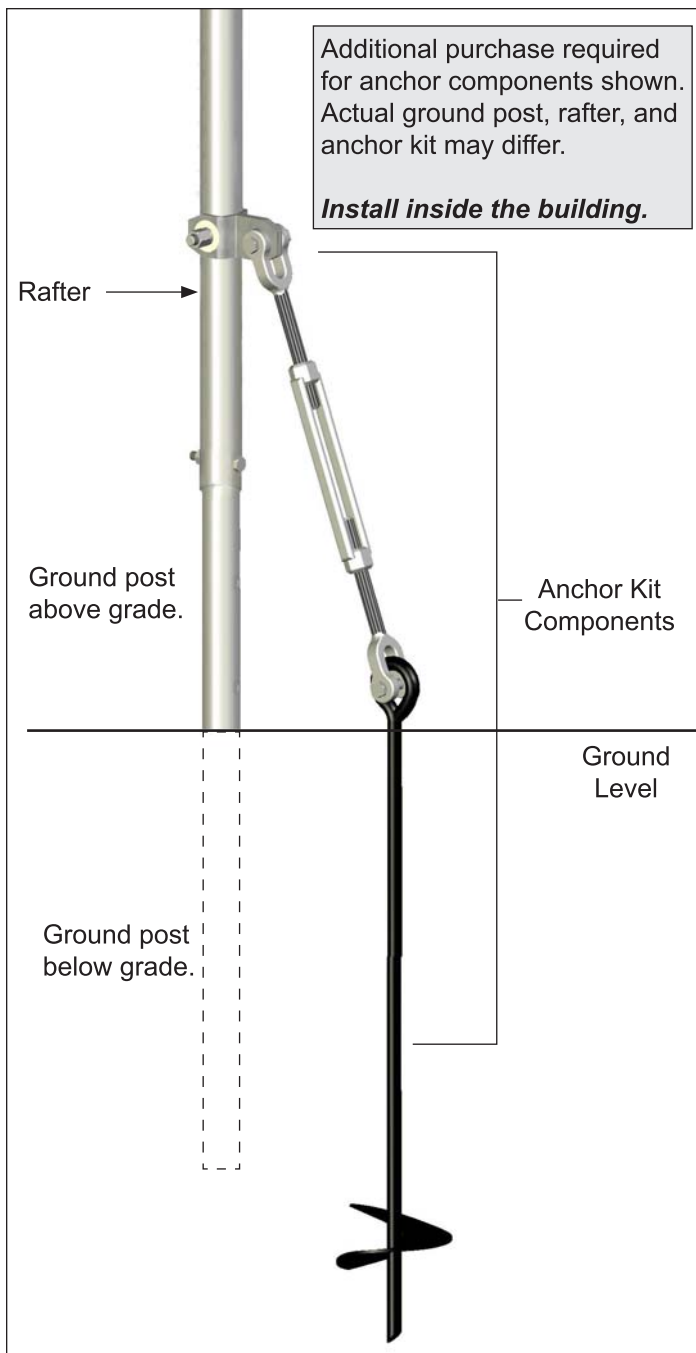
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ANCHOR ASSEMBLED FRAME

At this point, anchor frame. Consult the MUST READ document for anchoring information and suggestions. Call customer service at 1-800-245-9881 for additional anchoring information if needed.

⚠ CAUTION: Anchor assembly is an integral part of construction. Improper anchoring may cause instability and failure of structure to perform as designed. Failing to anchor shelter properly will void the manufacturer's warranty and may cause serious injury and damage. **Anchor frame before you continue.**

ATTENTION: If ground posts were set in concrete, skip this section. If ground posts were driven into place *and not set in concrete*, read the information on this page and anchor the high tunnel **before continuing**.



AFTER ANCHOR INSTALL: FRAME CHECK BEFORE COVER INSTALLATION

1. Inspect frame for sharp edges or fasteners that could damage cover.
2. Verify frame members are properly secured and bolts and pipe straps tight.
3. Recheck frame assembly for sharp edges, clamps, and bolts that may interfere with cover installation. *File smooth or tape sharp edges as needed.*
4. Reposition clamps and bolts as needed and tape all rafter pipe joints with duct tape to protect cover material.



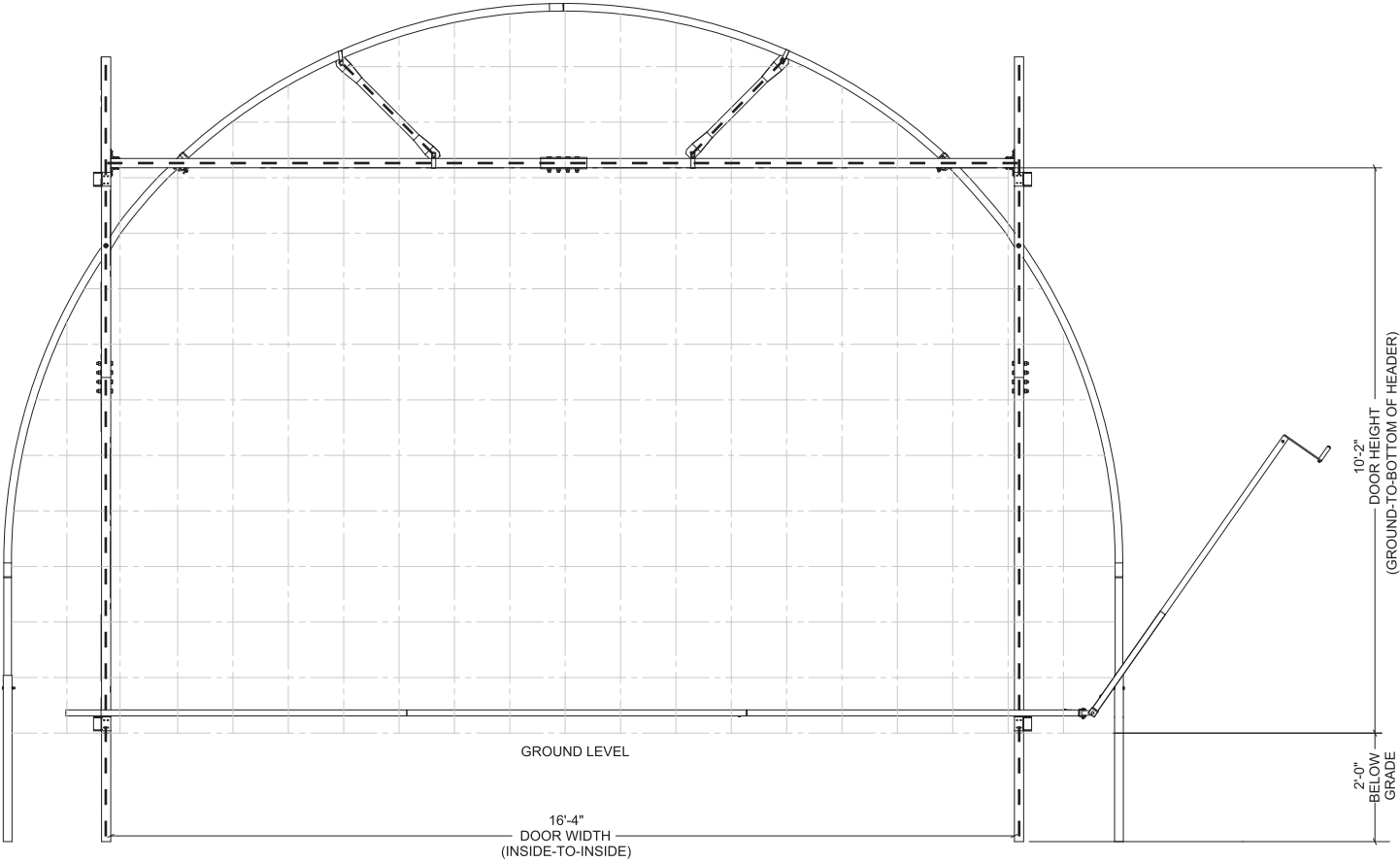
5. Verify main building frame is properly and adequately anchored.
6. Continue with the next procedure.

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116670 ENDWALL HEADER KIT — 20' WIDE ROUND PREMIUM HIGH TUNNEL (additional purchase required)

If the 116670 endwall header kit was purchased for this high tunnel, consult those instructions now to assemble and install the kit components. Complete the assembly as noted in those instructions and return to this manual as instructed.

ATTENTION: If the 116670 endwall header kit *was not purchased*, continue with the instructions on the next page to install the customer-supplied frame materials for the roll-up panel.



ATTENTION: Some components shown in the diagram above are included with the main building; others are included with the endwall header kit. Dashed lines show the frame kit components and installed locations.

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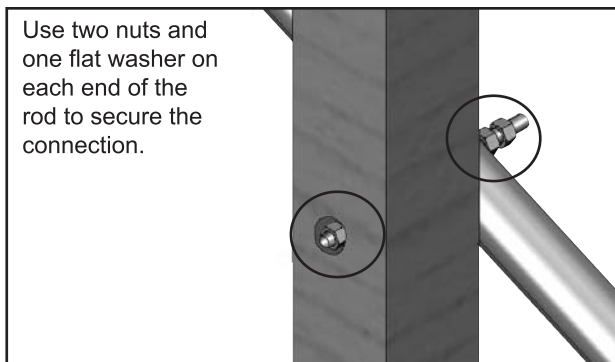
END FRAME ASSEMBLY – CUSTOMER-SUPPLIED

Use these steps to assemble end wall supports and connecting hardware. See post comment on page 4.

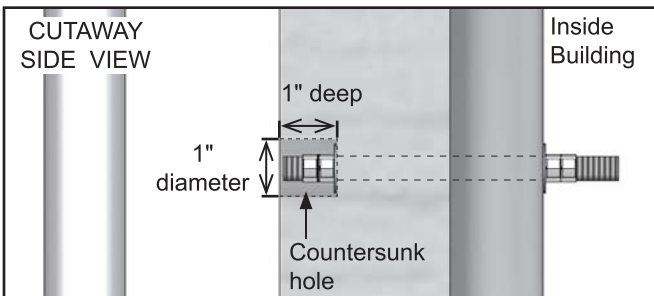
1. Using the dimensions shown on the End Framing Details diagram in the Quick Start section, set the customer-supplied 4" x 4" posts.

NOTE: Use recognized construction practices when setting the customer-supplied 4" x 4" posts.

2. After setting the posts, install the header. Consult the End Framing - Connections Details diagram in the Quick Start section.
3. Secure posts to end rafters as shown. Consult End Framing diagrams in the Quick Start section for details.



NOTE: Do not exceed 8" when cutting the individual lengths of rod from the bulk 3/8" threaded rod. Cut the threaded rod after installation. *To prevent conflicts with the end panel, countersink the "head" of the threaded rod so that it is below the surface of the customer-supplied support.*



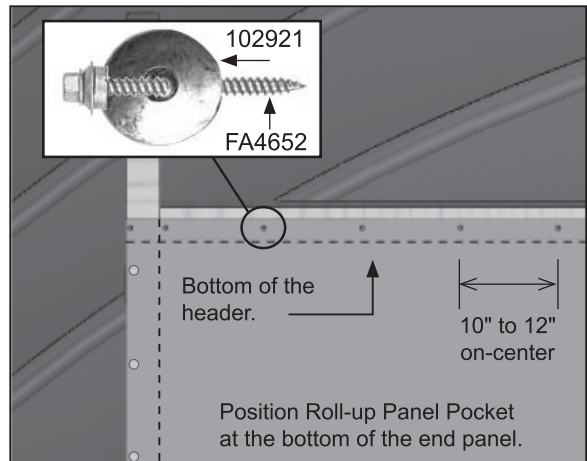
4. Repeat the steps to install the support posts and header for the remaining end wall.
5. Continue by installing the roll-up panel and guide posts.

ROLL-UP PANEL INSTALLATION (QED108181)

Before attaching the guide posts, attach each roll-up panel to the customer-supplied end framing (4" x 4") using FA4652 wood screws and neo-bonded washers. Complete these steps to install the roll-up panel conduit and hardware.

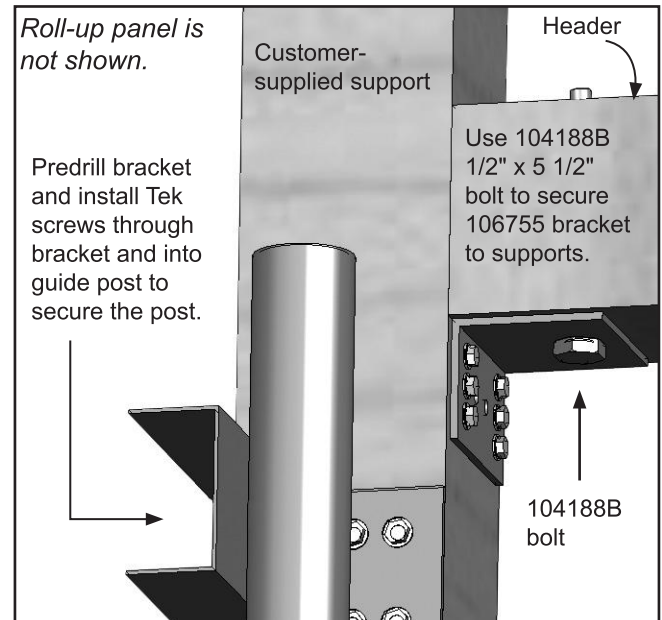
1. Take one roll-up panel, move to one end of the frame, and unfold the panel.

2. With assistance, lift and center the panel into position against the 4" x 4" end frame and attach the top to the header using wood screws and neo-bonded washers.



NOTE: Verify that the lower edge of the panel is on the ground before securing the upper edge to the header.

3. Refer to the End Framing diagram located in the Quick Start section to assemble the guide posts. Secure each pipe joint using a Tek screw.
4. Install the guide posts and brackets over the roll-up panel.



ROLL-UP PANEL INSTALLATION (continued)

5. Use the pipe diagrams on the End Framing Details diagram to assemble the crank up assembly.
6. Secure each splice using a Tek screw and cover the Tek screw with duct tape to protect the panel pocket.
7. Insert the assembly into the panel pocket. Verify that the assembly runs between the guide post and the wooden support posts. Allow a few inches to extend beyond the panel opposite the crank handle to keep the conduit in place during operation.
8. With the assembly in the proper position, flip up the skirt at the bottom of the panel to secure the conduit to the end panel using the CC6212 fabric clips and Tek screws. Divide the clips evenly between the two panels and space clips evenly along each conduit.
9. Cut a vertical slice in the skirt to fit around the lower guide post assembly bracket if needed. Do not cut through the end panel.
10. Test the roll-up panel.

NOTE: Verify that the 3/8" threaded rod that secures the customer-supplied end frame to the end rafter is sunk below the post surface (recommended) or has been cut off and taped to protect the panel.

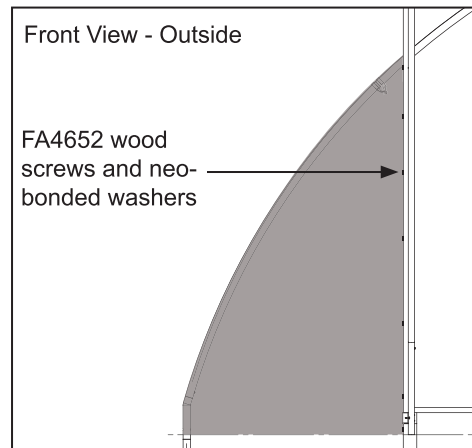
11. Repeat the steps to install the remaining roll-up panel.
12. Next, attach the end panel material to the end frame and end rafter.

END PANEL INSTALLATION—Use DCC4931 Material

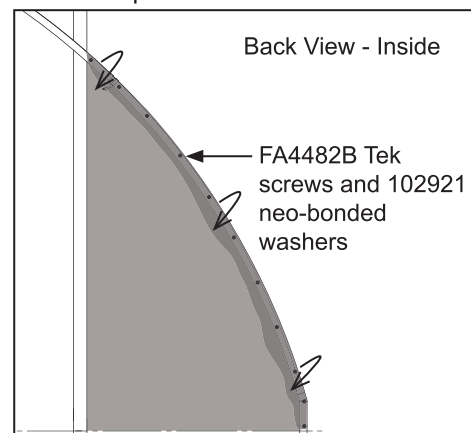
Consult the diagrams at the back of this manual to view the areas to cover and the basic material cut patterns for these areas. Use these steps to cut and attach the material to the end wall frame.

1. Measure the area of the end wall that needs to be covered and cut a section from the bulk DCC4931 material. Allow extra to achieve the best fit.

NOTE: Due to differences in construction methods and customer-supplied support materials, the customer determines the best way to prepare the bulk material for installation.
2. Set the prepared material in place and attach it to the end frame using FA4652 wood screws and neo-bonded washers.



3. Wrap end panel material around the end rafter and attach to the backside of the rafter using FA4482B Tek screws and neo-bonded washers (102921). **DO NOT** attach to the top of the end rafter.



4. Repeat the steps to cut and attach additional material to cover the remaining areas of the end wall.
5. Repeat these steps to cut and attach the door frame panels. See Door Frame Panel Location diagram in Quick Start section.
6. After installing all end panel and door frame panel sections, install the main cover.

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ATTENTION: For those who purchased the 116670 endwall header kit, continue with these instructions at this point once those instructions are completed.

MAIN COVER INSTALLATION

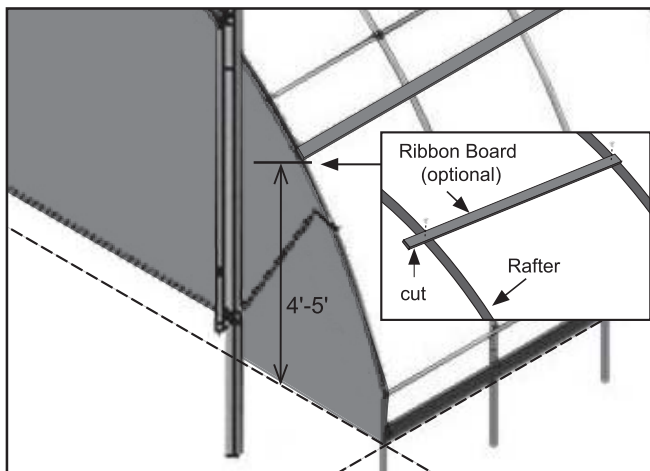
The steps to install the main cover include:

1. Attach poly latch U-Channel (102197) along the high tunnel sides and tops of the high tunnel end rafters using FA4482B Tek screws.
2. Pull main cover over the frame.
3. Attach the main cover to the end rafters using the poly latch wire spring.
4. Stretch and attach main cover to the sides of the frame.
5. Install roll-up side kits and test the operation of the twist-of-the-wrist assembly.

INSTALL POLY LATCH U-CHANNEL (102197)

1. Measure the desired height (4'-5') to identify the top of the roll-up sides. Attach poly latch channel at approximately 4'-5' above the ground on both sides.

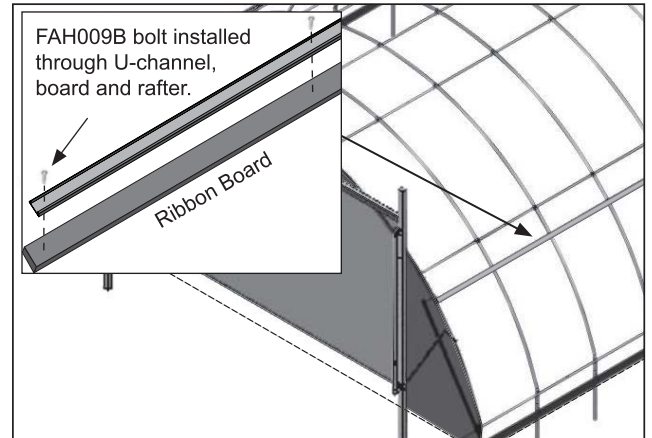
Attaching a ribbon board to the rafters and then attaching the poly-latch U-Channel (102197) to the ribbon board is recommended for the best results. Consult the diagram below for clarification.



NOTE: Ribbon board and baseboard (recommended) shown in the diagram above *are not included* and are supplied by the customer. Use the supplied FAH009B (1/4" x 4") carriage bolts and FALB01B (1/4") nuts to secure the ribbon board and U-Channel to the rafter. **Do not use Tek screws to attach U-Channel to wood.** Customer-supplied wood screws can be used to secure the U-Channel to ribbon board.

If no ribbon board is used, attach one section of the poly latch U-Channel to the side of the frame using Tek screws. Attach U-Channel flush with the outside edge of the end rafter at each end of the assembled frame.

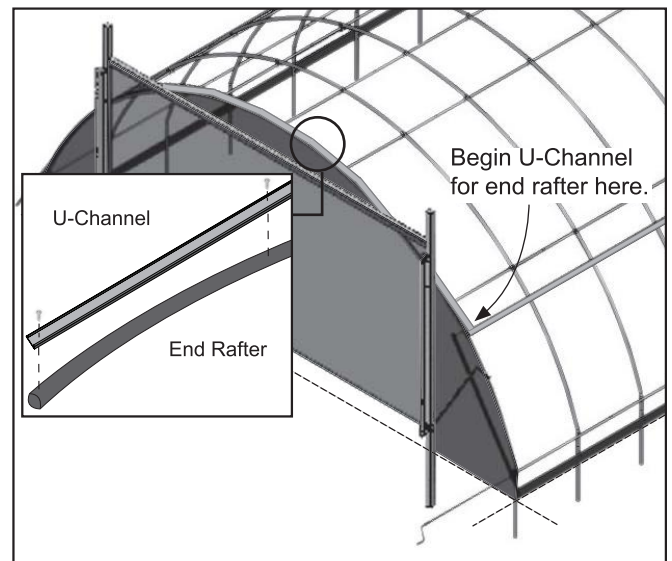
2. Continue to attach the U-Channel sections to the rafters (or ribbon board if used) and work toward the other end of the frame. Cut the last section of U-Channel to the required length so that it is flush with the outside edge of the end rafter.



NOTE: Inset shows the use of a ribbon board. U-channel can be attached directly to rafters using FA4482B Tek screws when ribbon board is not used.

3. Repeat these steps for the remaining side.
4. After attaching the poly latch U-Channel to the sides of the frame, use Tek screws to attach the U-Channel to the top of one end rafter. **Space screws at 24".**

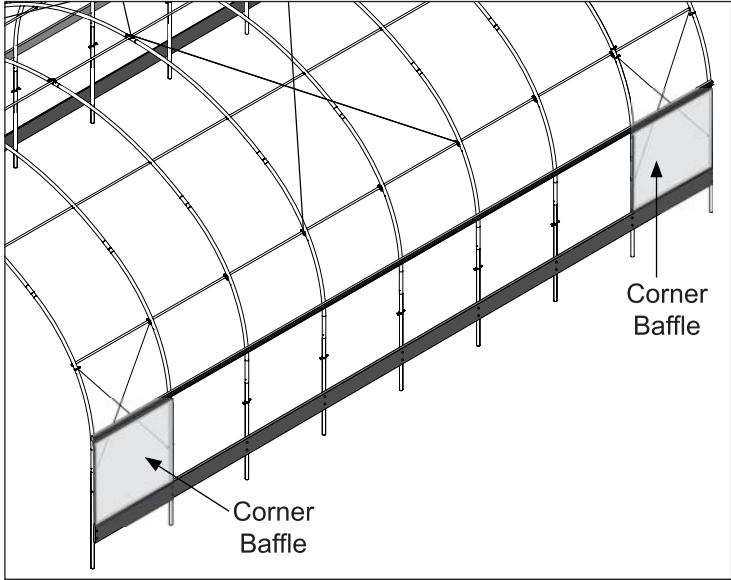
ATTENTION: The poly latch U-Channel will bend with the curve of the rafter as it is attached. The U-Channel spans from the poly latch U-Channel attached to one side of the frame to the U-Channel attached to the other side of the frame.



5. Repeat the steps to attach the U-Channel to the top of the remaining end rafter.

INSTALL CORNER BAFFLES

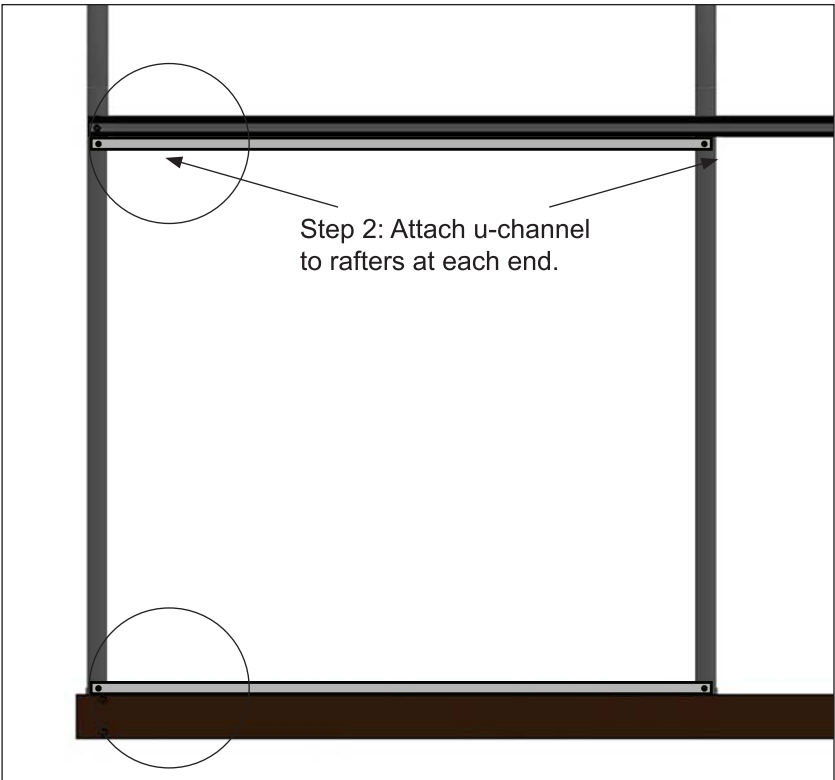
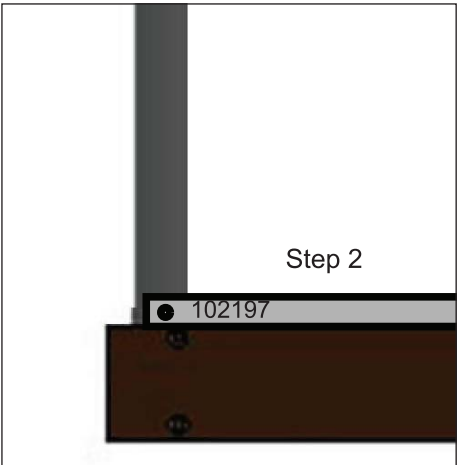
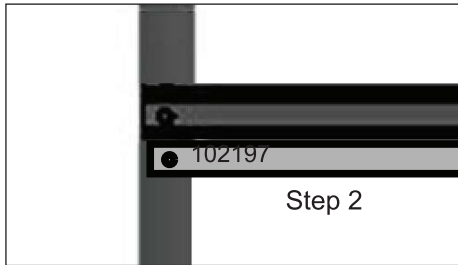
If you do not want corner baffles installed, skip this section and continue with the next page. Corner baffles for roll-up sides can be installed later; however, it is easier to install before installing cover, roll-up panels, and anti-billow ropes.



- REQUIRED PARTS:**
- 102197 U-channel
 - 102198A Poly-Coated Spring Wire
 - 108654 6' Wide 6 MIL Film
 - FA4482B Tek Screws

Complete these steps to install a baffle at each corner of the assembled frame.

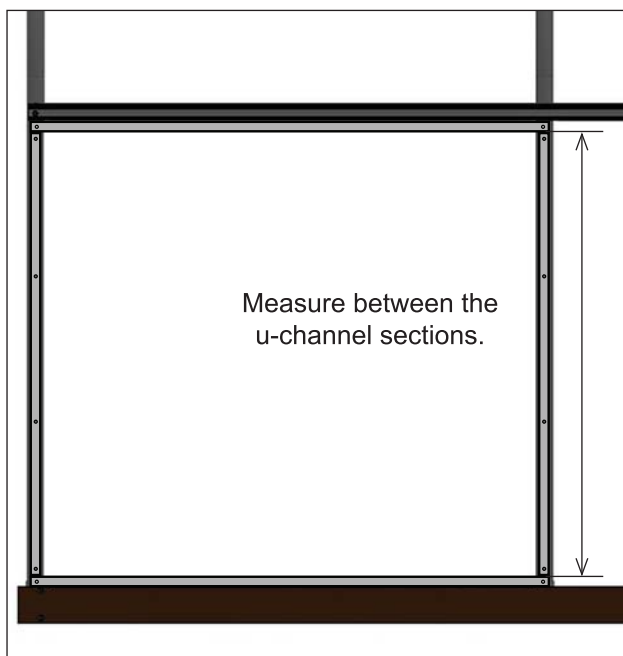
1. Locate four (4) pieces of 102197 single u-channel, additional 102198A spring wire, and the 108654 roll of 6 mil film.
2. At one corner, cut and attach the 102197 u-channel to the end rafter and first interior rafter as shown. Install these horizontal runs of single u-channel above the baseboards and below the single u-channel.



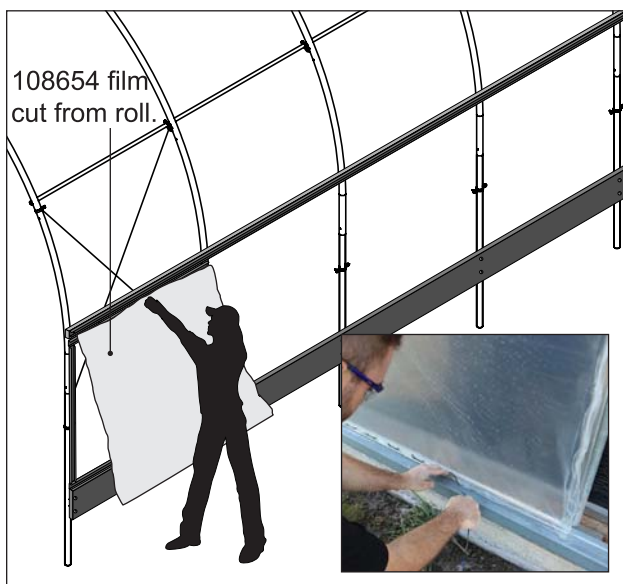
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INSTALL CORNER BAFFLES (continued)

3. Measure the distance between the upper and lower single u-channel installed in Step 2. Cut two additional u-channel sections to this length and attach these vertical runs to the end rafter and interior rafter. *Space Tek screws (FA4482B) approximately 12" on-center. Vertical channel runs may consist of multiple small lengths of available u-channel.*



4. Take the 108654 roll of 6 mil film and cut a piece to cover the end bay opening framed by the single u-channel. Roll out the film and measure length to determine the best way to cut the film. You need four (4) identical panels from the film roll.
5. With assistance, secure the film panel in the u-channel using the 102198A wire spring.



6. Trim the film as needed and repeat the steps to install all remaining corner baffles.
7. After installing all baffles, continue with the next procedure.

INSTALL MAIN COVER

Gather the parts:

- Main cover
- Ropes long enough to reach over the frame (provided by customer)
- U-Channel Spring (#102198)
- Box cutter or utility knife

Assembly Procedure

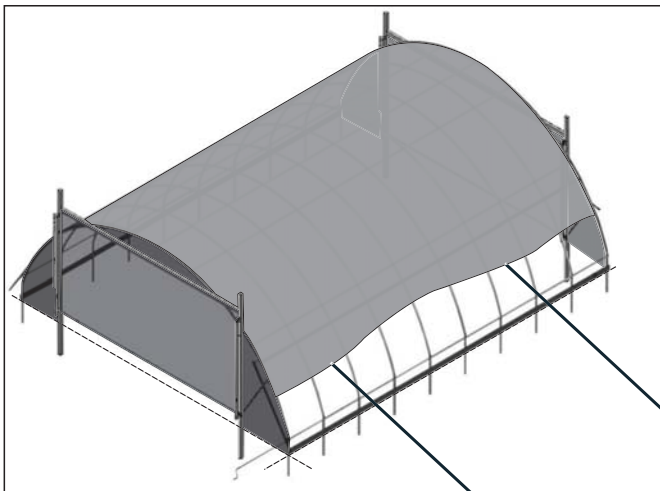
After attaching the poly latch U-Channel to the frame, unpack the main cover and pull into place. Ropes or straps are typically used to pull the main cover onto and over the frame. Ropes may not be needed for some buildings.

⚠ WARNING: To prevent damage to the cover and to prevent serious personal injury, DO NOT attempt to install the main cover on windy or stormy days.

1. Unpack the main cover and position it at the base along one side of the frame.
2. Make small holes along the edge of the cover at evenly spaced intervals and tie rope to the cover. (The length of the cover determines the number of holes that are needed to attach the ropes.)

NOTE: The ropes must be long enough to reach over the top of the building to the other side. Long buildings will require additional ropes to prevent tearing the main cover when it is pulled into place.

3. After tying the ropes to the main cover, throw the ropes over the top of the frame and pull the cover into place. Center cover side-to-side and end-to-end.



Shelter shown above may be a different length than the actual model.

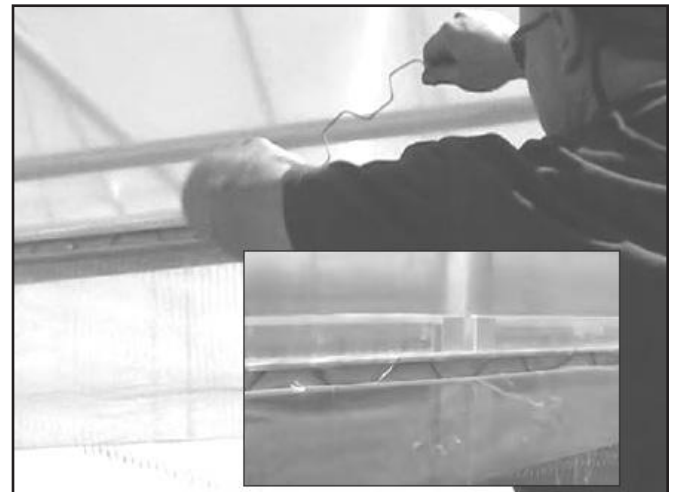
IMPORTANT: To prevent damage to the main cover during installation, additional personnel and lifts may be needed.

4. Once the main cover is in place and centered on the frame, begin at the peak of one end rafter and install the wire spring into the U-Channel to secure the cover.

ATTENTION: Center the main cover front to back and side-to-side to ensure that enough cover material is present to lock into the U-Channel. *The excess cover along each side is rolled up when the roll-up side assemblies are installed.*

The rope can remain in place to temporarily secure the cover if needed. Remove the ropes as the cover is secured to the frame.

Photos show installing the spring into the U-Channel on the outside of a frame. The process is the same for the U-Channel attached to the top of the end rafters.



5. Continue adding the spring into the U-Channel at the top of the first end rafter. Ensure that an even amount of the cover is exposed and maintained along the edge of the frame as it is attached.

NOTE: The cover material is cut longer/wider than is required to cover the frame. For easier installation, allow approximately 10" to extend past the edge of the end rafter as the cover is secured in place.

6. Continue down both edges of the first end rafter until the entire end of the main cover is secured in place.
7. Stretch the cover to the other end of the building and repeat the steps to secure the main cover in the U-Channel.

NOTE: Pull the cover tight as the wire spring is inserted into the U-Channel.

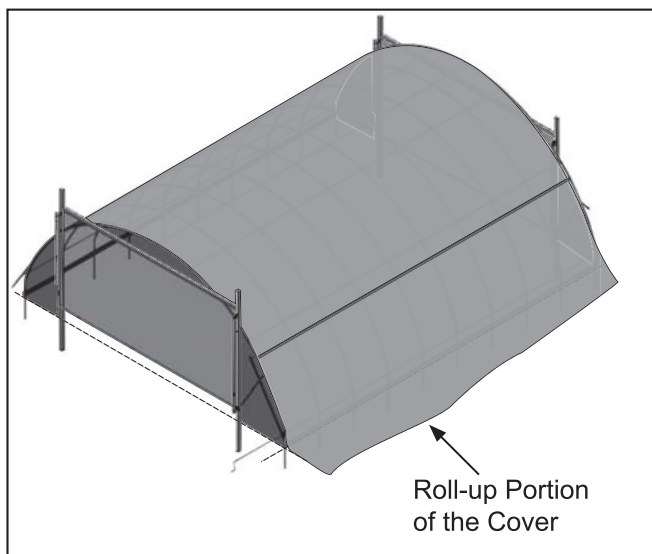
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- After the cover is stretched end-to-end and secured using the spring and U-Channel, move to one side of the frame and repeat the steps to anchor the main cover to the first side.

Begin at one end of the U-Channel and work toward the other. It is also possible to begin at the middle of each side and work toward each end.

NOTE: Maintain an even length along the side. The final stretching of the cover takes place when the last side is secured.

- After securing the first side, move to the remaining side and secure it in place.



IMPORTANT: DO NOT REMOVE TOO MUCH OF THE EXCESS COVER MATERIAL AT EACH END. Some excess main cover material—the material that extends beyond the end rafters—should remain in place. If the main cover needs stretched in the future, remove the spring from the U-Channel, grasp the excess material, pull the cover tight, and reinstall the spring.

The excess material along the sides is rolled up in the roll-up side assembly.

- Once the main cover is installed and secured in the U-Channel, continue with the **Install the Roll-up Side Assemblies** procedure.

INSTALL THE ROLL-UP SIDE ASSEMBLIES

The instructions below describe how to install a single roll-up sidewall assembly for one side of the frame. The procedure is repeated for the remaining side.

The procedures to install the roll-up side include the following:

- Assemble the roll-up side conduit.
- Attach the roll-up conduit to the bottom of the main cover.
- Assemble the Twist-of-the-Wrist assembly and attach it to the frame and the roll-up side.
- Install the Anti-Billow Rope system.
- Test the operation of the roll-up side.

INSTALL THE ROLL-UP SIDE CONDUIT

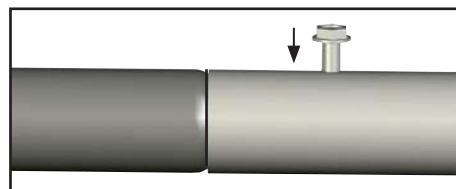
Gather the parts:

- Pipe 1.315" x 75" Swaged 17 GA (#131S075)
- Pipe 1.315" x 73.5" Plain 17 GA (#131P0735)
- Tek Screws

The roll-up side conduit assembly is attached to the bottom of the roll-up side cover material. This assembly runs the length of the frame and serves as the center pipe that the roll-up cover wraps around when it is opened to ventilate the shelter.

Complete these steps to assemble the roll-up side conduit.

- Locate all sections of pipe needed to assemble the cover conduit.
- Insert the swaged end of each pipe into the plain end of another pipe until the conduit is assembled.
- Secure each pipe joint with a Tek screw.



- Place the assembled conduit at the base of the side where the end of the main cover is located.

NOTE: Duct tape Tek screws to prevent damage to main cover.

- Continue with the procedure that follows to attach the conduit to the main cover.

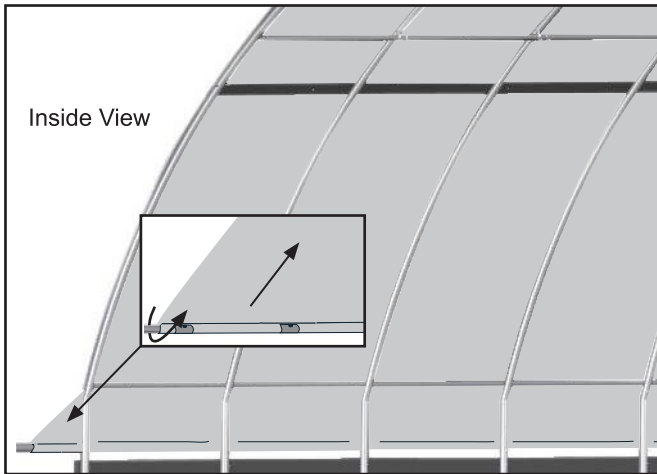
ATTACH CONDUIT TO MAIN COVER ROLL-UP SIDE

Gather the parts:

- Assembled conduits
- Fabric clips #CC6212 (Divide quantity in half.)
- Tek Screws

To this point, the main cover should be secured to the frame and the excess cover along both sides should be hanging down along the side of the frame.

1. Unfold the remaining portion of the main cover (if needed) and evenly stretch it out on the ground along the frame.
2. Roll the assembled cover conduit onto the edge of the main cover. Allow conduit to extend beyond the rafter at the end where you plan to install the gearbox for operation.



Shelter shown above may be a different model. Drawing used for illustration only.

3. Secure the cover material to the conduit with Tek screws and fabric clips evenly spaced along the conduit.
4. Continue to roll the conduit until the excess cover material is wound around the conduit.
5. With the excess cover material rolled up on the conduit assembly, continue with the **Twist-of-the-Wrist Assembly** procedure.

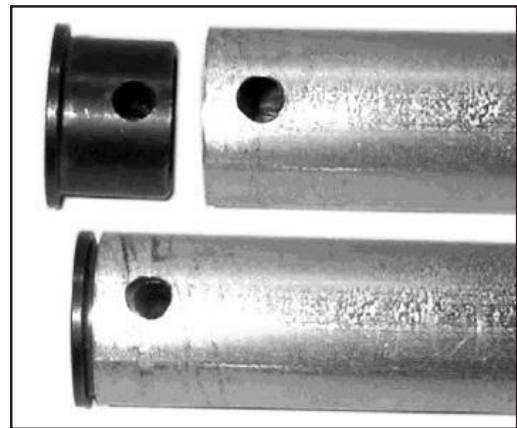
TWIST-OF-THE-WRIST ASSEMBLY

Gather the parts:

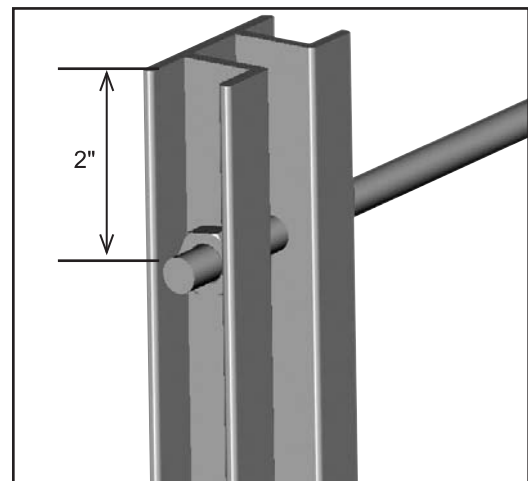
- Aluminum channel (102570)
- Drive handle (102480)
- Gearbox (103496) and gearbox drive (102717)
- Mounting plate (103544)
- Bearing (102569) and threaded rod (FAK26)
- 1/4" X 2" carriage bolts and 1/4" nuts
- 3/8" nuts and washers

The Twist-of-the-Wrist Assembly is designed to roll up a portion of the sides of the structure. The following steps describe the assembly and its installation.

1. Drill a 5/16" hole through the cover conduit 1/2" from the end of the conduit.
2. Insert a tubing adapter into the conduit and align the holes of the adapter with the drilled holes in the conduit.



3. Select the aluminum channel and drill a 3/8" hole through the channel approximately 2" from the end and attach a threaded rod using a 3/8" nut on each side of the channel.



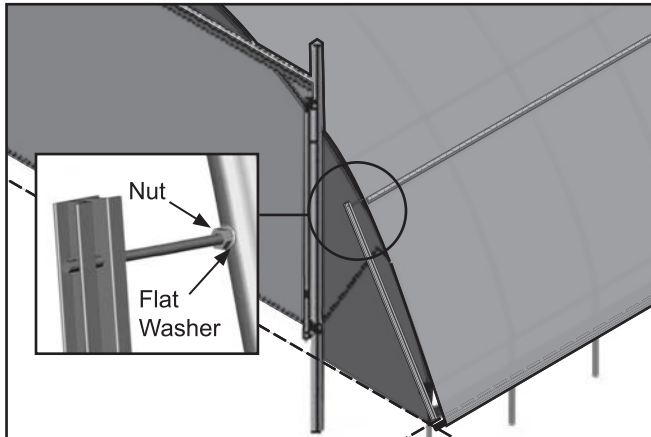
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TWIST-OF-THE-WRIST ASSEMBLY (continued)

- Position the channel along the end rafter at the end of the building where the Twist-of-the-Wrist assembly will be located.

NOTE: Verify that the lower end of the channel is slightly off the ground to allow it to move freely when the panel is rolled up and down.

- Secure the upper end of the channel by drilling a 3/8" hole through the end rafter and attach as shown. The lower end of the channel will "float" and is not attached.



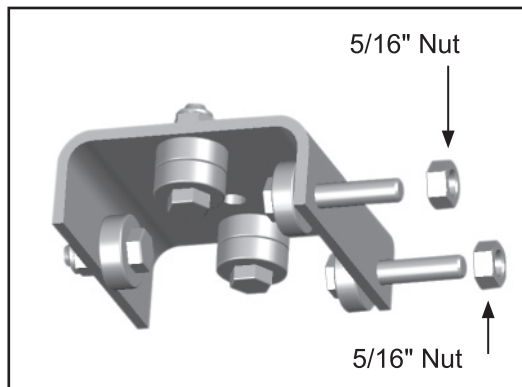
NOTE: Install a flat washer between the nut and the end panel. Panel is not shown in the insert.

- Select the bearing bracket and attach the bearings as needed. (In some instances, the bearings may come already attached.) Assemble as follows:

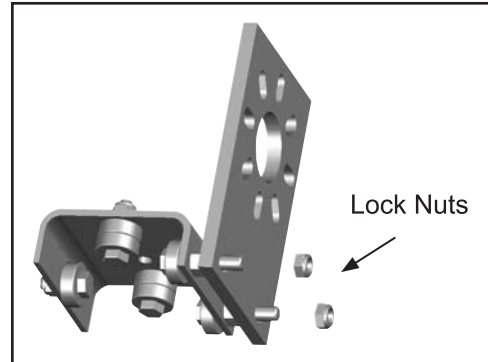
Single bearings are attached to the sides of the bracket and double bearings to the middle portion of the bracket. Use 1/4" hex bolts and locknuts as needed. Install a flat washer on both sides of each bearing to insure proper operation of bearings and the assembly.

Install the longer bolts with bearings on the side of the bracket that has the two holes. Install these *before* installing the double bearing assemblies. See the figures below.

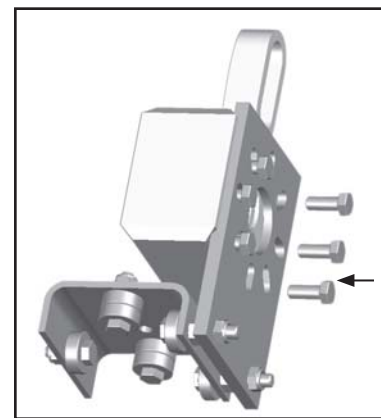
- For the spacers on the long bolts, insert a 5/16" nut over each bolt. *These nuts are used as spacers only.*



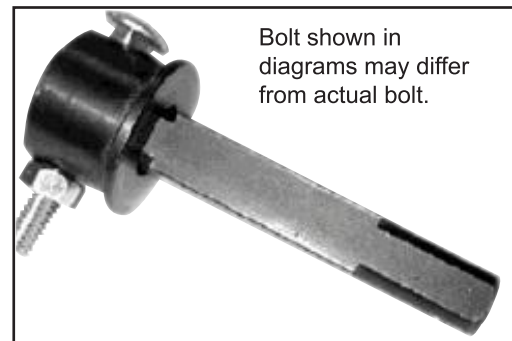
- Slide the Twist-of-the-Wrist mounting plate over the long bolts and secure the plate with two lock nuts.



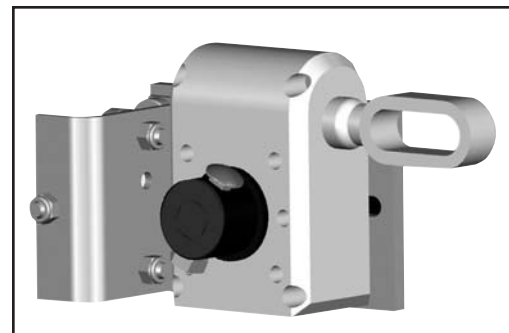
- Attach the Twist-of-the-Wrist gearbox to the mounting plate using hex head bolts.



- Using a 1/4" x 2" bolt (FAG308B) and nut (FALB01B), attach the square shaft to a tubing adapter.



- Slide the square shaft through the Twist-of-the-Wrist gearbox.

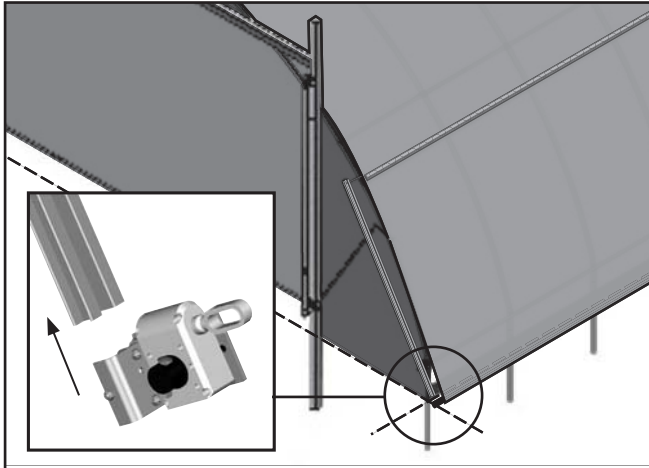


TWIST-OF-THE-WRIST ASSEMBLY (Continued)

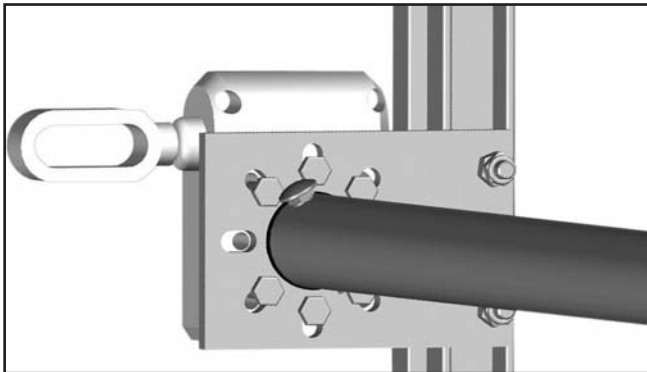
- Slide the Twist-of-the-Wrist assembly onto the aluminum channel from the ground end. (This is the free end of the channel.)



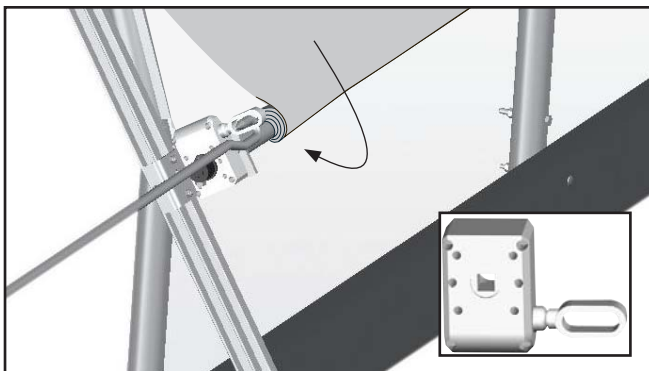
Space below is reserved for customer notes.



- Roll the cover conduit up to the Twist-of-the-Wrist assembly.
- Attach the conduit to the square shaft of the assembly by inserting a 1/4" bolt through the hole in the conduit and tubing adapter. Add and tighten the 1/4" nuts



- Attach the crank handle to the Twist-of-the-Wrist assembly. (Cover is not shown in the above diagram.)



- Test the operation of the Twist-of-the-Wrist assembly.

NOTE: If the cover rolls in the desired direction, but you want to turn the crank in the opposite direction for the same result, unbolt, reposition the gearbox, and remount it *on the same side of the mounting bracket.*

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INSTALL ANTI-BILLOW ROPES

ANTI-BILLOW ROPE INSTALLATION

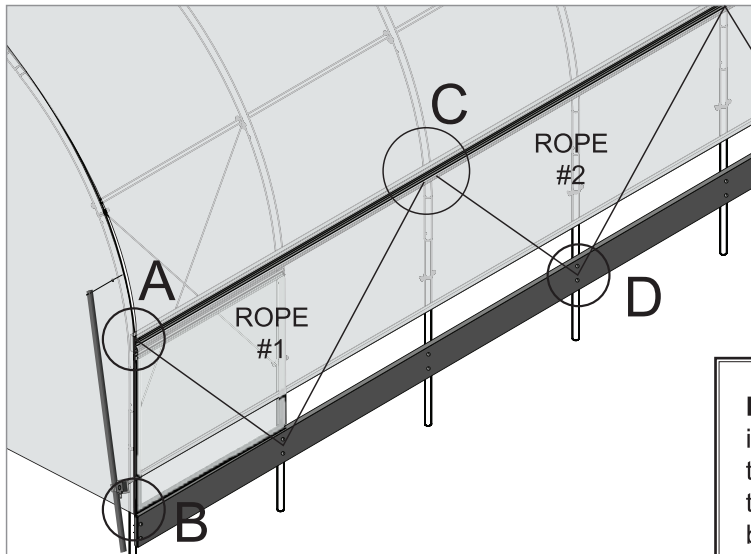
TO PREVENT DAMAGE AND POSSIBLE INJURY, INSTALL ANTI-BILLOW ROPES **IN SHORT LENGTHS** ALONG EACH SIDE. DO NOT INSTALL AS A SINGLE LENGTH TIED AT EACH END. DOING SO WILL RESULT IN A LOOSE SIDE PANEL IF SINGLE ROPE BREAKS. **CONSULT THE SIDE PROFILE DIAGRAM FOR YOUR FRAME LENGTH IN THE QUICK START SECTION FOR ROPE PATTERN AND ROPE HOOK LOCATIONS.**

Follow these general steps to attach the 117063 rope hooks and install the anti-bilow ropes:

1. Determine the location of rope hooks and the number of anti-bilow ropes for each side using the Side Profile diagram in the Quick Start section for your frame length.
2. Attach the 117063 rope hooks using wood screws for wood and Tek screws for metal. Be sure to note where one rope stops and the next rope begins.
3. Take the CC5525 (1/4") rope and install it in short lengths along each side. Pull tight to keep panels in place.
4. Test the operation of the roll-up side.
5. Repeat to install the anti-bilow rope for the remaining side once the panel is installed.
6. With all anti-bilow ropes installed, continue with the next page.



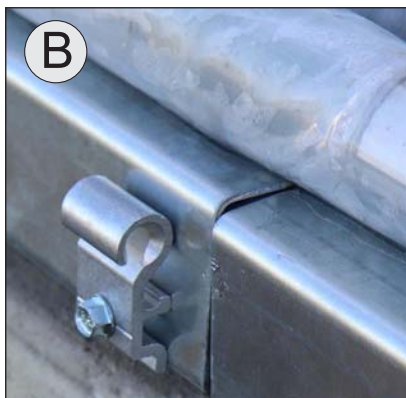
C



D



A



B

NOTE: In those instances when two ropes terminate at the baseboard or lower position (D), install the rope snaps and rope as shown in these photos.



Photos show using optional hat channel for baseboards.



INSTALL ROLL-UP PANEL ROPES

The roll-up panel ropes are laced through the roll-up panel. These ropes wrap around hook lags that are screwed into the sides of the door frame. When installed correctly, these ropes help to keep the roll-up panel in place when it is fully or partially closed. These steps describe one way to lace the roll-up panel.

Gather the parts:

- Hook lags (#FAX120)
- Rope (#CC5505)
- Zipper extension pole (#CC2235)

1. Beginning on the *outside of a door frame*, attach a hook lag between the first two grommet holes below the bracket. Position the open end of the hook lag towards the end panel.

IMPORTANT: Screw hook lags into the sides of the door frame, not the front. *Do not screw into the roll-up panel.*

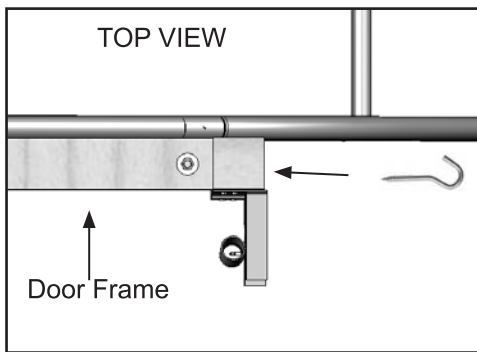
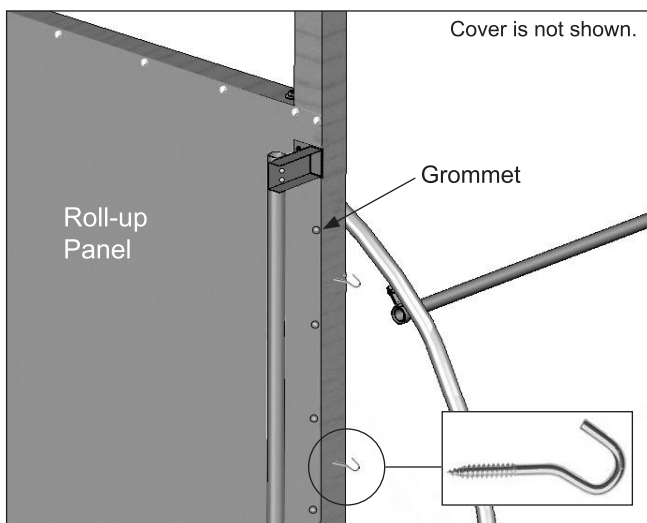
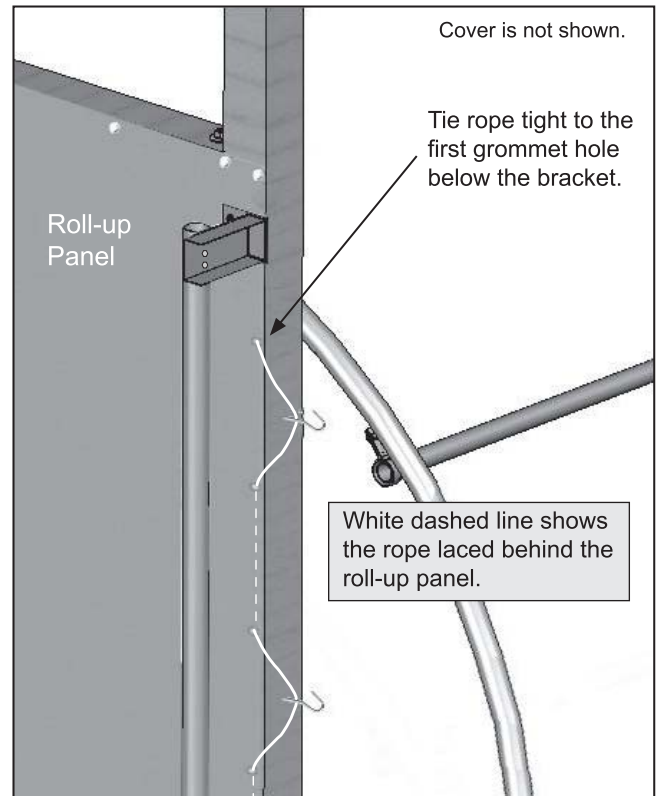


Photo shows the open end of the hook lag facing the end panels.

2. Install a hook lag at every other grommet interval as shown in the diagram below. Use five (5) hooks for each side.



3. Tie a length of rope to the first grommet hole below the guide post bracket, loop it around the first hook lag, and lace it back through the next grommet. Repeat this process until the rope is through the last grommet.



4. Leaving some slack, loosely tie the rope off at the bottom grommet hole.
5. Repeat steps 1 through 4 for the other side of the door frame.
6. Once the ropes on both sides are laced and hooked in the correct position, untie the rope at the bottom grommet holes, pull tight to remove excess slack, and tie off at the bottom grommet holes.
7. Repeat for the remaining end.

NOTE: Use the included zipper extension pole (CC2235) to unhook the rope to open the roll-up panel. The pole can also be used to loop the rope back onto the hook lags when the roll-up panel is closed.

8. Read the shelter care and maintenance information that follows.

GROWSPAN™ ROUND PREMIUM HIGH TUNNELS

SHELTER CARE AND MAINTENANCE

Proper care and maintenance of the shelter is important. Check the following items periodically to properly maintain the shelter:

- Regularly check the main cover and panels (if equipped) to see that these remain tight and in proper repair.
- Check connections and all fasteners to verify that they remain tight.
- Do not climb or stand on the frame at anytime.
- Remove debris and objects that may accumulate on the cover. Use tools that will not damage the cover when removing debris.
- Remove snow to prevent excess accumulation. Use tools that will not damage the cover when removing snow.
- Check the contents of the high tunnel to verify that nothing is touching the cover or the side panels that could cause damage.
- Check the anchoring system to ensure that all components are tight and in good repair.
- If the shelter is moved, inspect all parts and connections before reassembling.
- For replacement or missing parts, call 1-800-245-9881 for assistance.

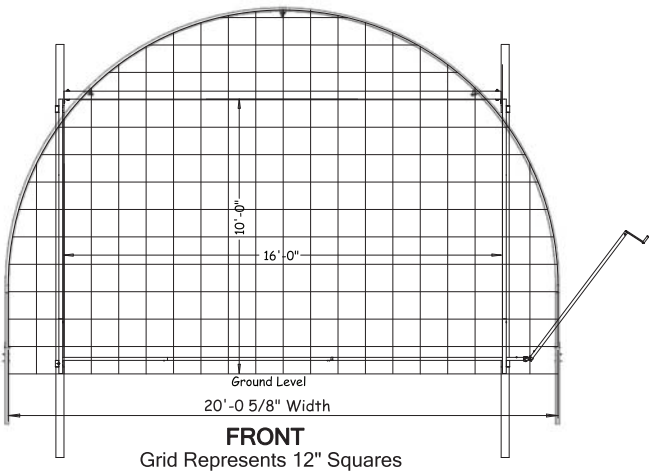


Space below is reserved for customer notes.



QUICK START GUIDE

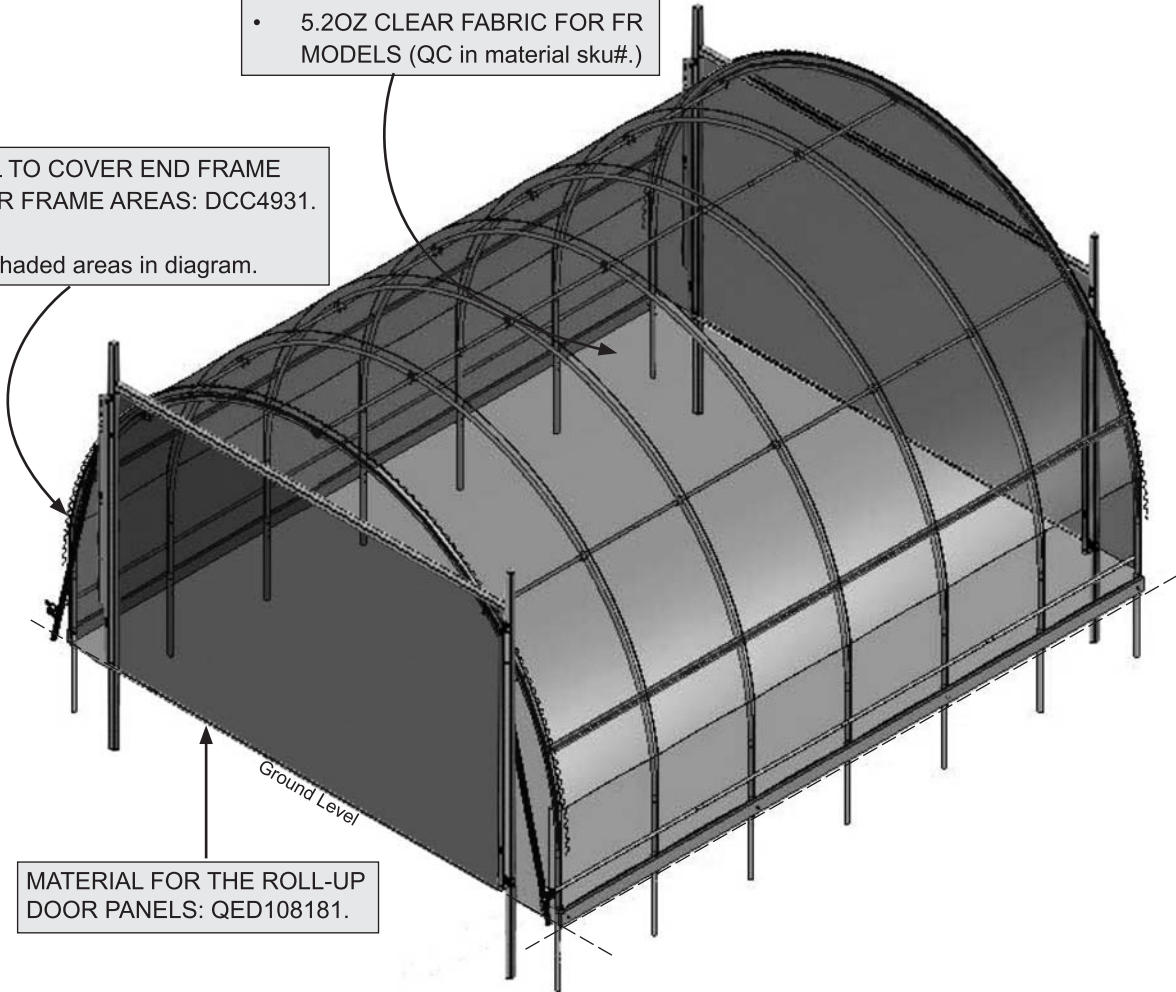
20' Wide Round Premium High Tunnel



MATERIAL IDENTIFICATION DIAGRAM

COVER MATERIAL
• 6ml FILM FOR CR MODELS
• 5.2OZ CLEAR FABRIC FOR FR MODELS (QC in material sku#.)

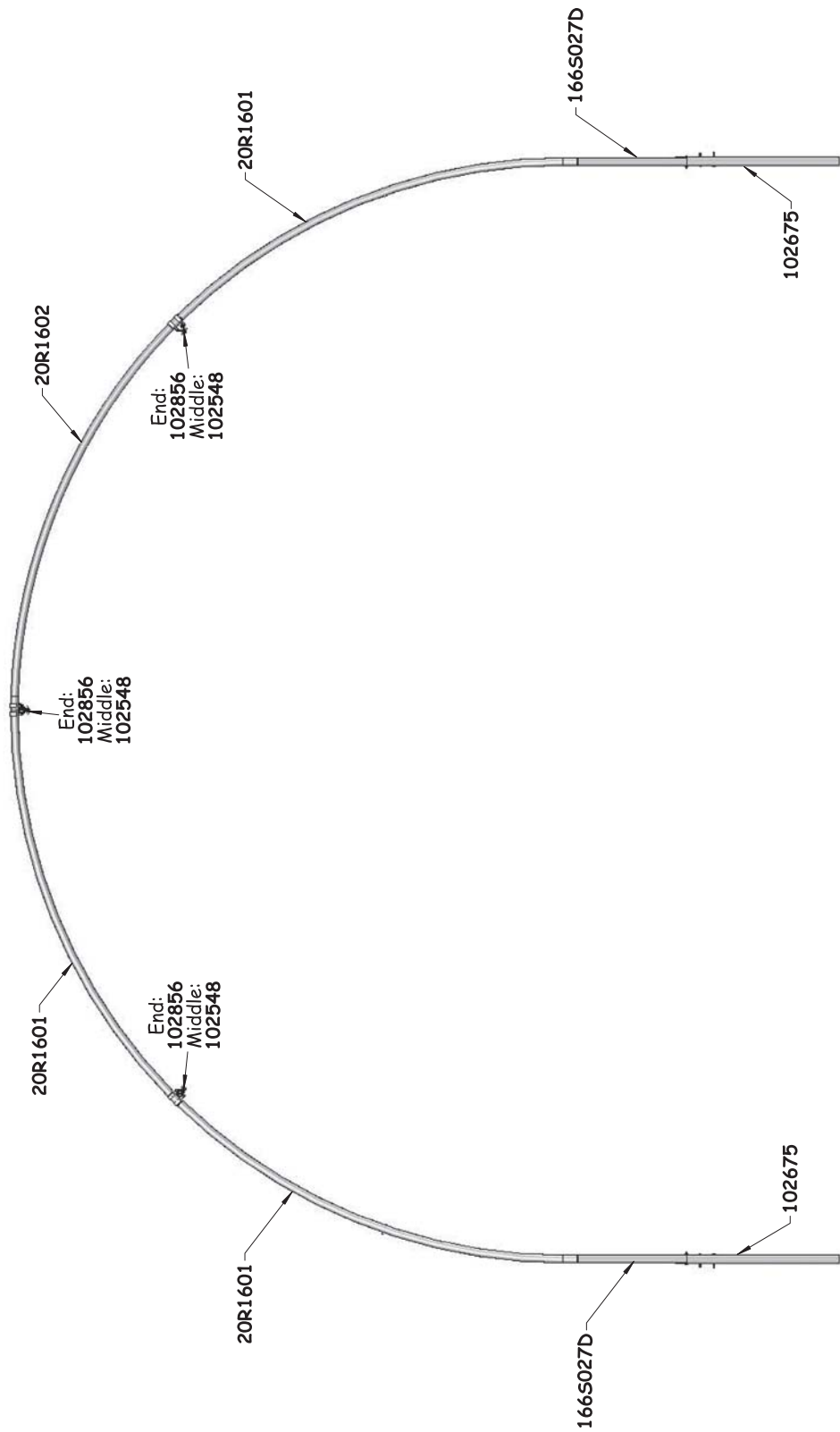
MATERIAL TO COVER END FRAME AND DOOR FRAME AREAS: DCC4931.
See dark shaded areas in diagram.



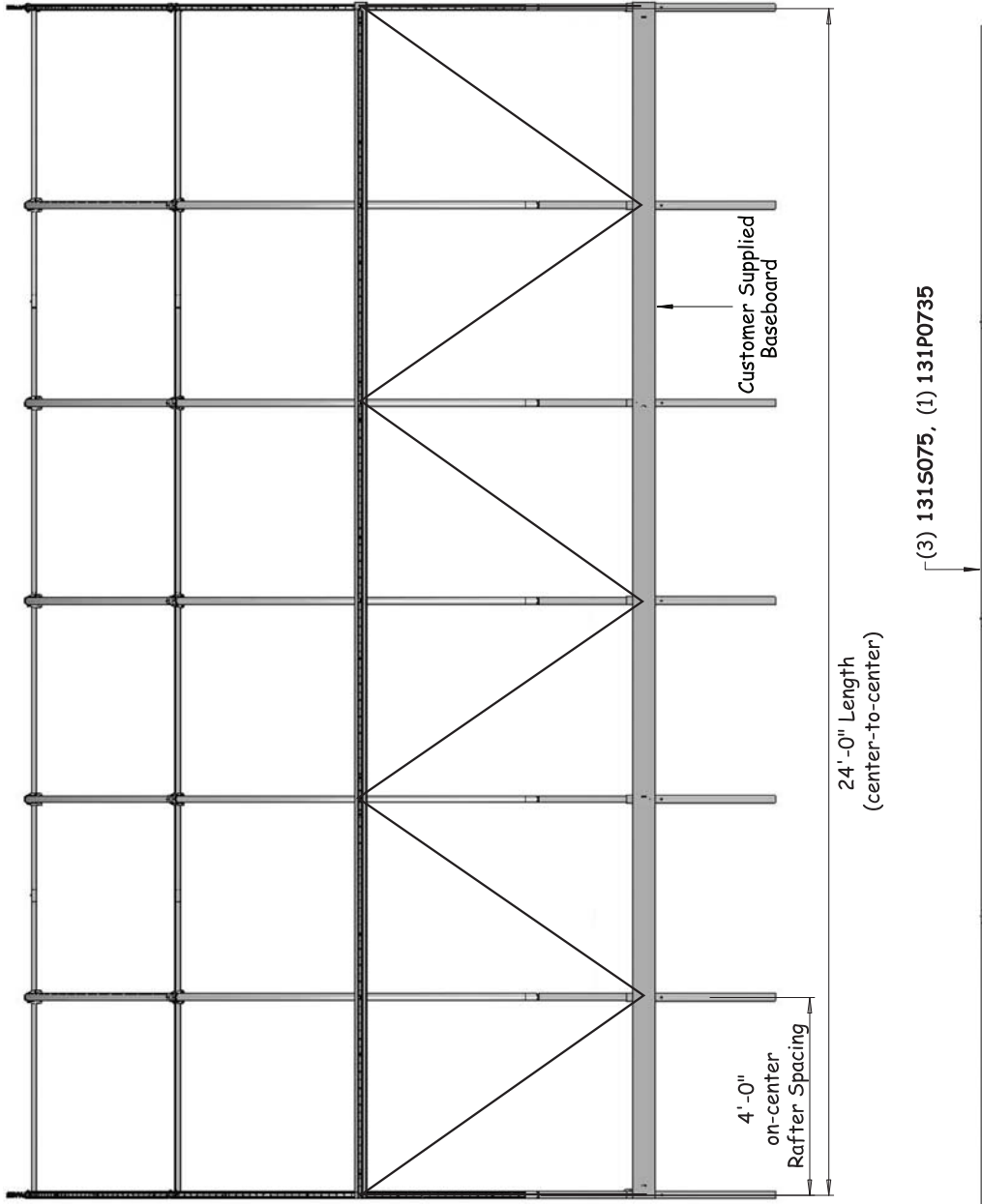
MATERIAL FOR THE ROLL-UP DOOR PANELS: QED108181.

Frame shown may differ in length from actual frame.

FRONT PROFILE



SIDE PROFILE - PB01670R4

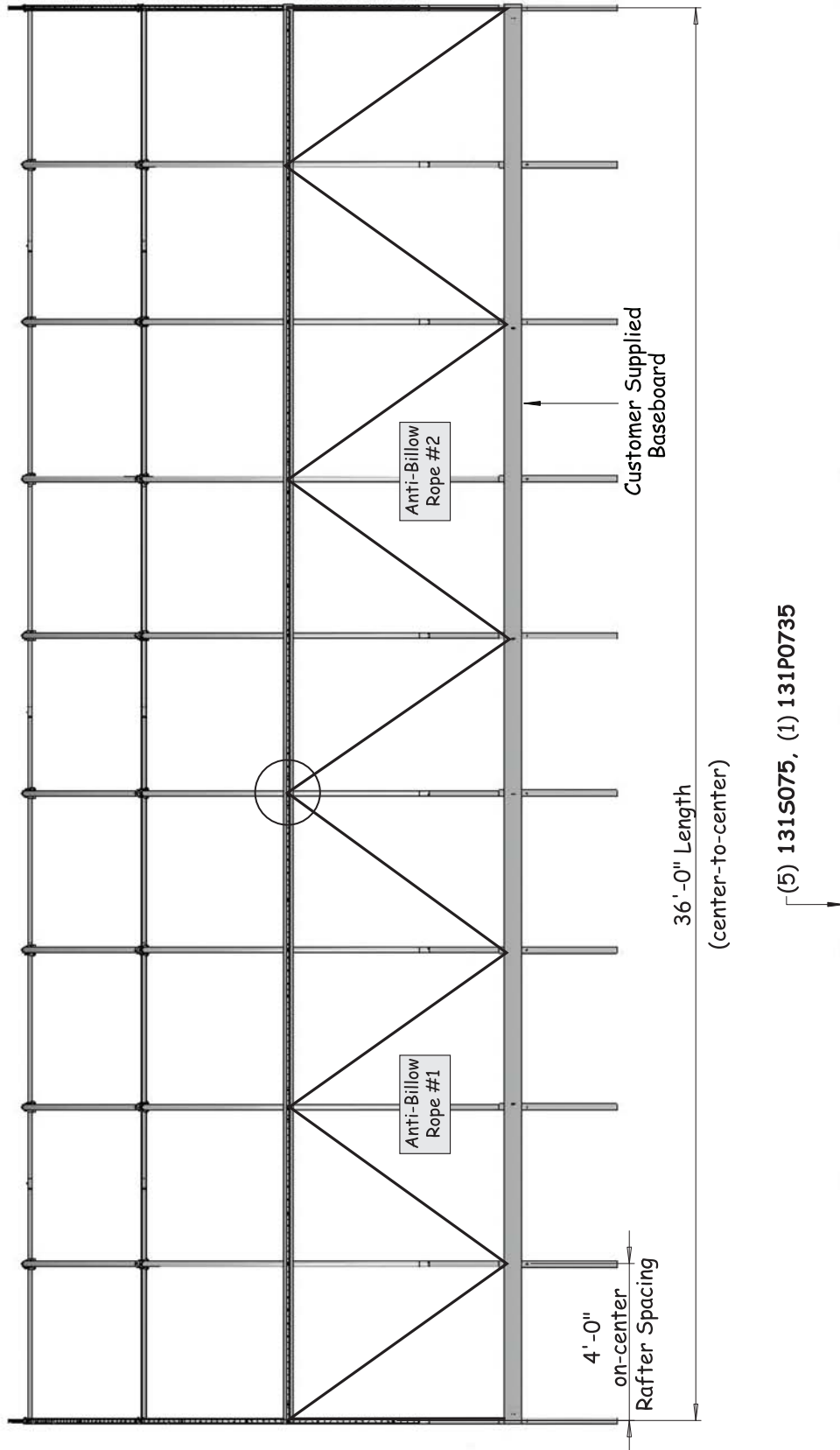


ANTI-BILLOW ROPES PER SIDE

This frame length requires one (1) anti-billow ropes and nine (9) 117063 EZ-Snap Rope Clips **per side**.

ATTENTION: TO PREVENT DAMAGE AND POSSIBLE INJURY, INSTALL THE ANTI-BILLOW ROPE IN SHORT LENGTHS ALONG EACH SIDE OF THE FRAME. DO NOT INSTALL AS A SINGLE LENGTH TIED AT EACH END. DOING SO WILL RESULT IN A LOOSE SIDE PANEL SHOULD THE ROPE BREAK DURING STRONG WINDS.

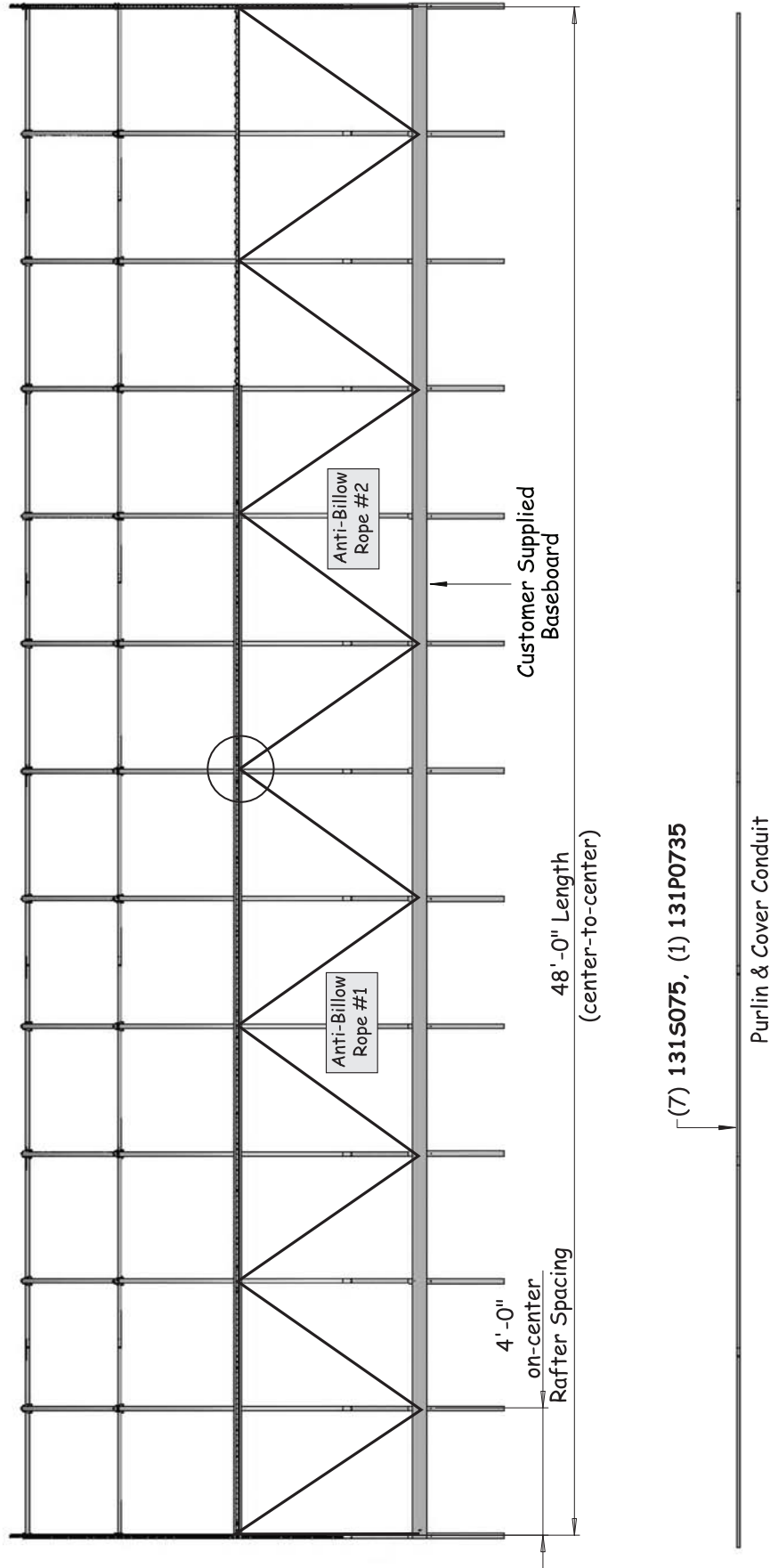
SIDE PROFILE - PB01675R4



ANTI-BILLOW ROPES PER SIDE
 This frame length requires two (2) anti-billow ropes and thirteen (13) 117063 EZ-Snap Rope Clips **per side**. Circled point shows the end of each rope and the location of two (2) 117063 EZ-Snap Rope Clips.

ATTENTION: TO PREVENT DAMAGE AND POSSIBLE INJURY, INSTALL THE ANTI-BILLOW ROPE IN SHORT LENGTHS ALONG EACH SIDE OF THE FRAME. DO NOT INSTALL AS A SINGLE LENGTH TIED AT EACH END. DOING SO WILL RESULT IN A LOOSE SIDE PANEL SHOULD THE ROPE BREAK DURING STRONG WINDS.

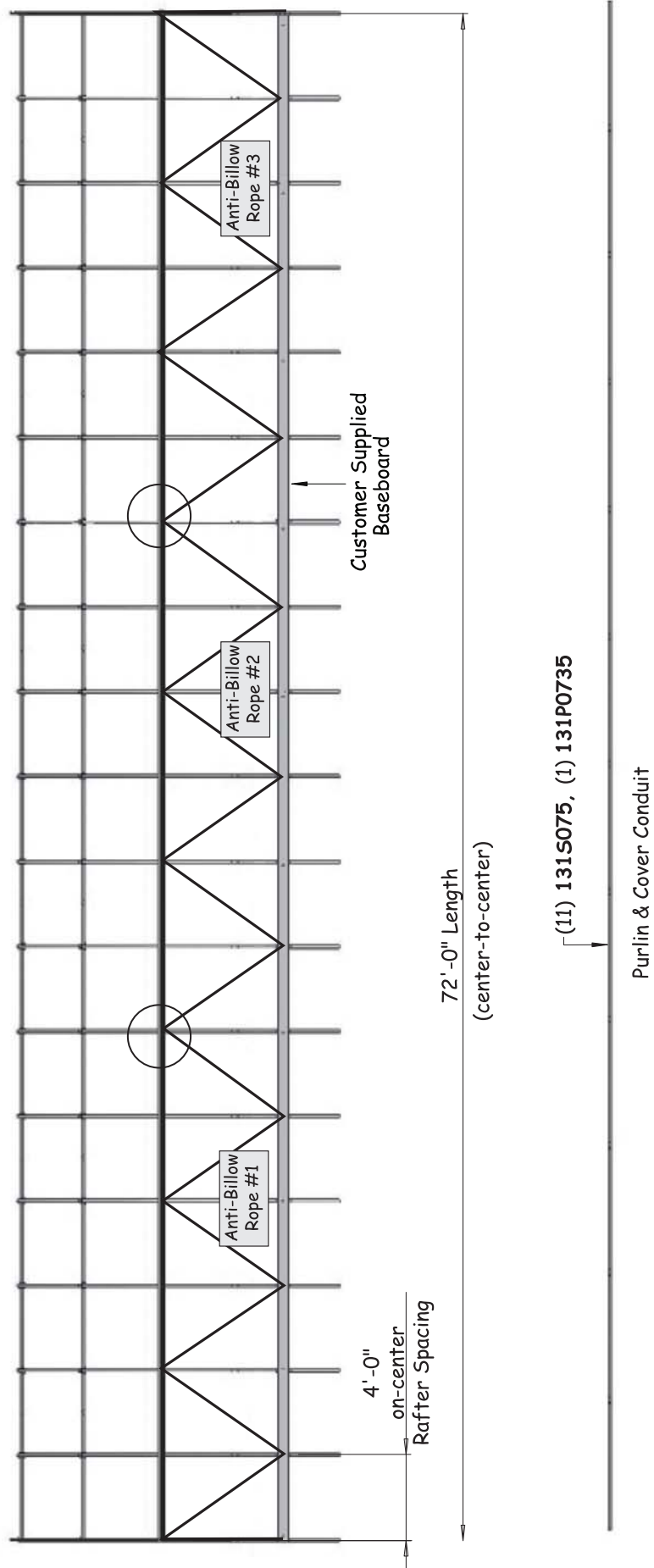
SIDE PROFILE - PB01680R4



ATTENTION: TO PREVENT DAMAGE AND POSSIBLE INJURY, INSTALL THE ANTI-BILLOW ROPE IN SHORT LENGTHS ALONG EACH SIDE OF THE FRAME. DO NOT INSTALL AS A SINGLE LENGTH TIED AT EACH END. DOING SO WILL RESULT IN A LOOSE SIDE PANEL SHOULD THE ROPE BREAK DURING STRONG WINDS.

ANTI-BILLOW ROPES PER SIDE
 This frame length requires two (2) anti-billow ropes and fourteen (14) 117063 EZ-Snap Rope Clips **per side**. Circled point shows the end of each rope and the location of two (2) 117063 EZ-Snap Rope Clips.

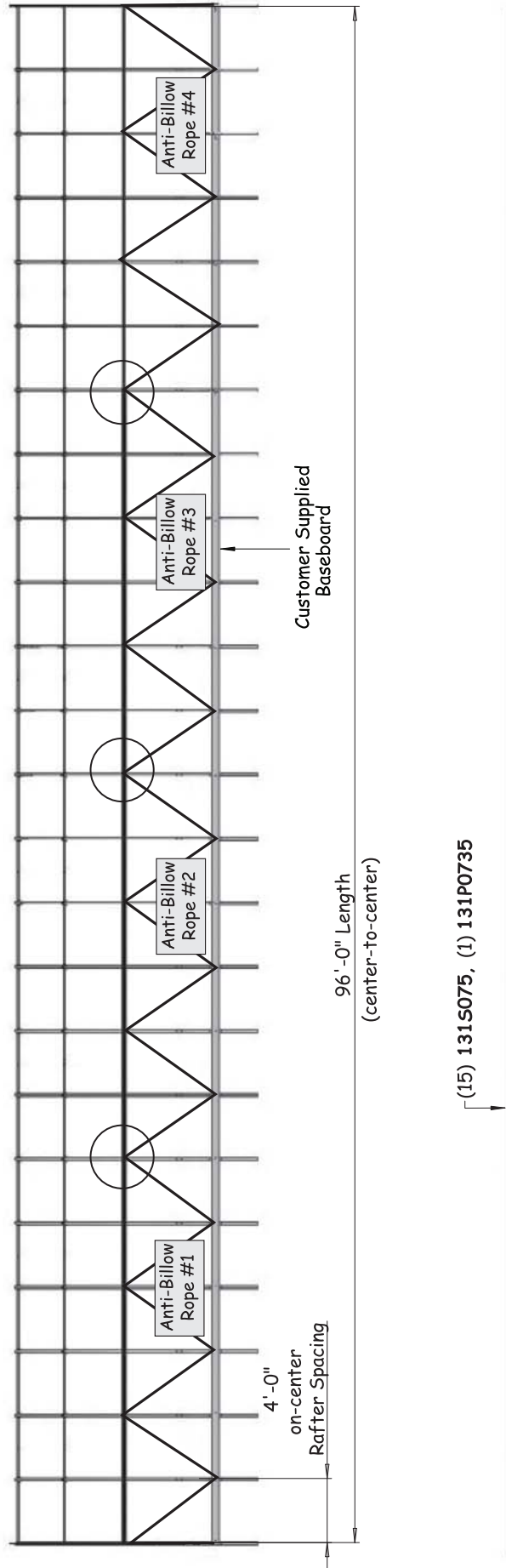
SIDE PROFILE - PB01685R4



ANTI-BILLOW ROPES PER SIDE
 This frame length requires three (3) anti-billow ropes and twenty-three (23) 117063 EZ-Snap Rope Clips **per side**. Circled point shows the end of each rope and the location of two (2) 117063 EZ-Snap Rope Clips.

ATTENTION: TO PREVENT DAMAGE AND POSSIBLE INJURY, INSTALL THE ANTI-BILLOW ROPE IN SHORT LENGTHS ALONG EACH SIDE OF THE FRAME. DO NOT INSTALL AS A SINGLE LENGTH TIED AT EACH END. DOING SO WILL RESULT IN A LOOSE SIDE PANEL SHOULD THE ROPE BREAK DURING STRONG WINDS.

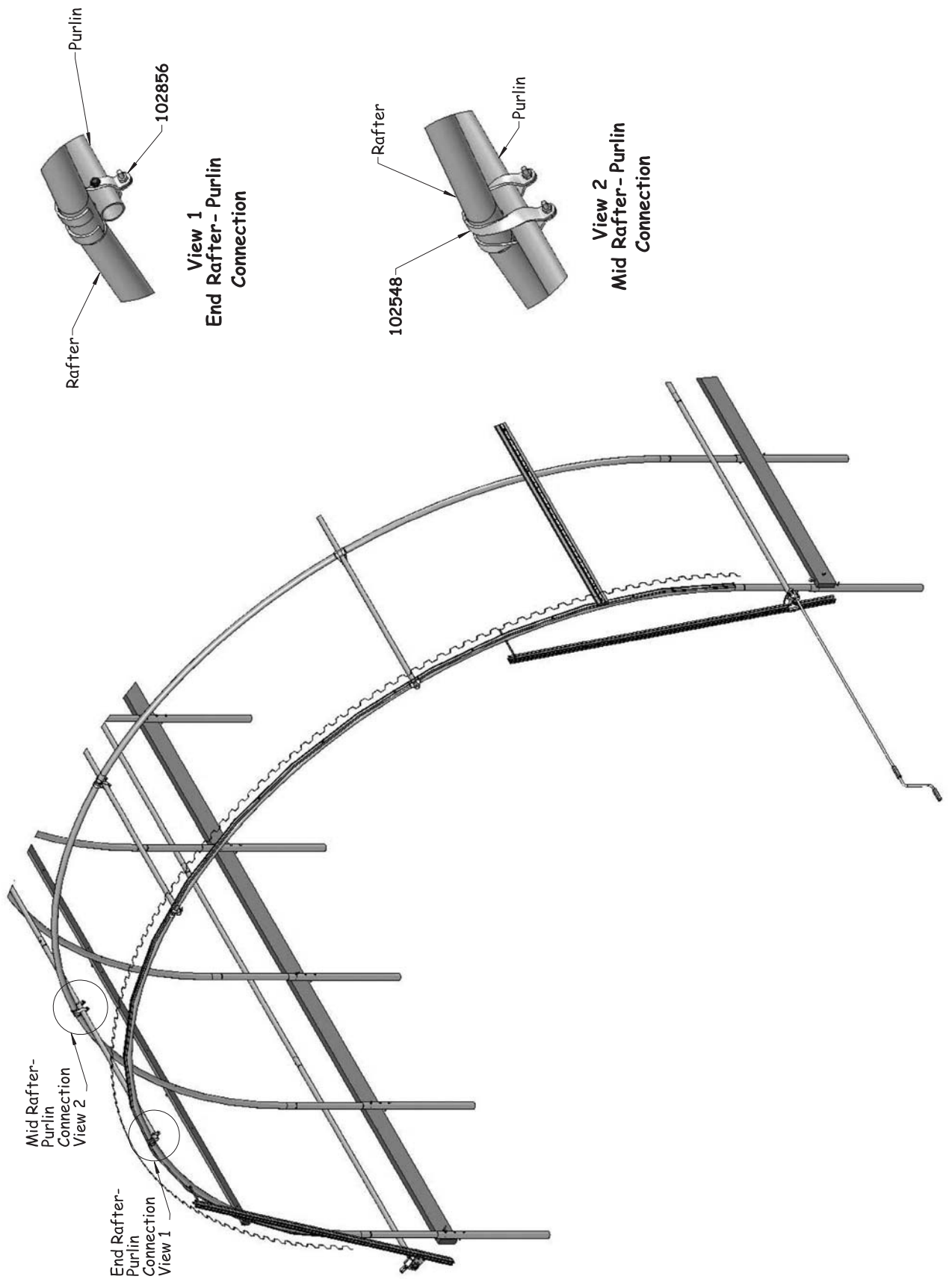
SIDE PROFILE - PB01690R4



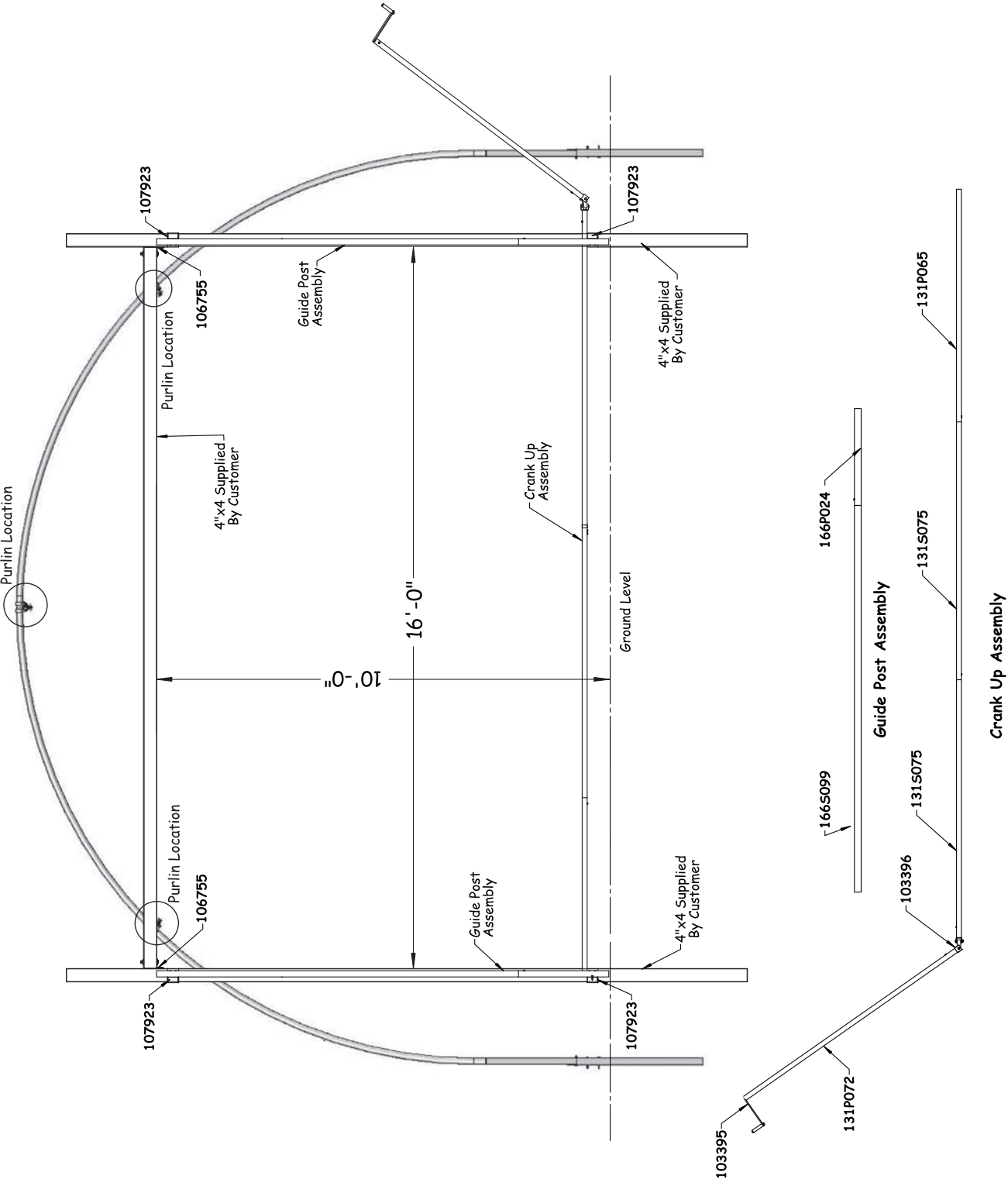
ATTENTION: TO PREVENT DAMAGE AND POSSIBLE INJURY, INSTALL THE ANTI-BILLOW ROPE IN SHORT LENGTHS ALONG EACH SIDE OF THE FRAME. DO NOT INSTALL AS A SINGLE LENGTH TIED AT EACH END. DOING SO WILL RESULT IN A LOOSE SIDE PANEL SHOULD THE ROPE BREAK DURING STRONG WINDS.

ANTI-BILLOW ROPES PER SIDE
 This frame length requires four (4) anti-billow ropes and thirty (30) 117063 EZ-Snap Rope Clips **per side**. Circled point shows the end of each rope and the location of two (2) 117063 EZ-Snap Rope Clips.

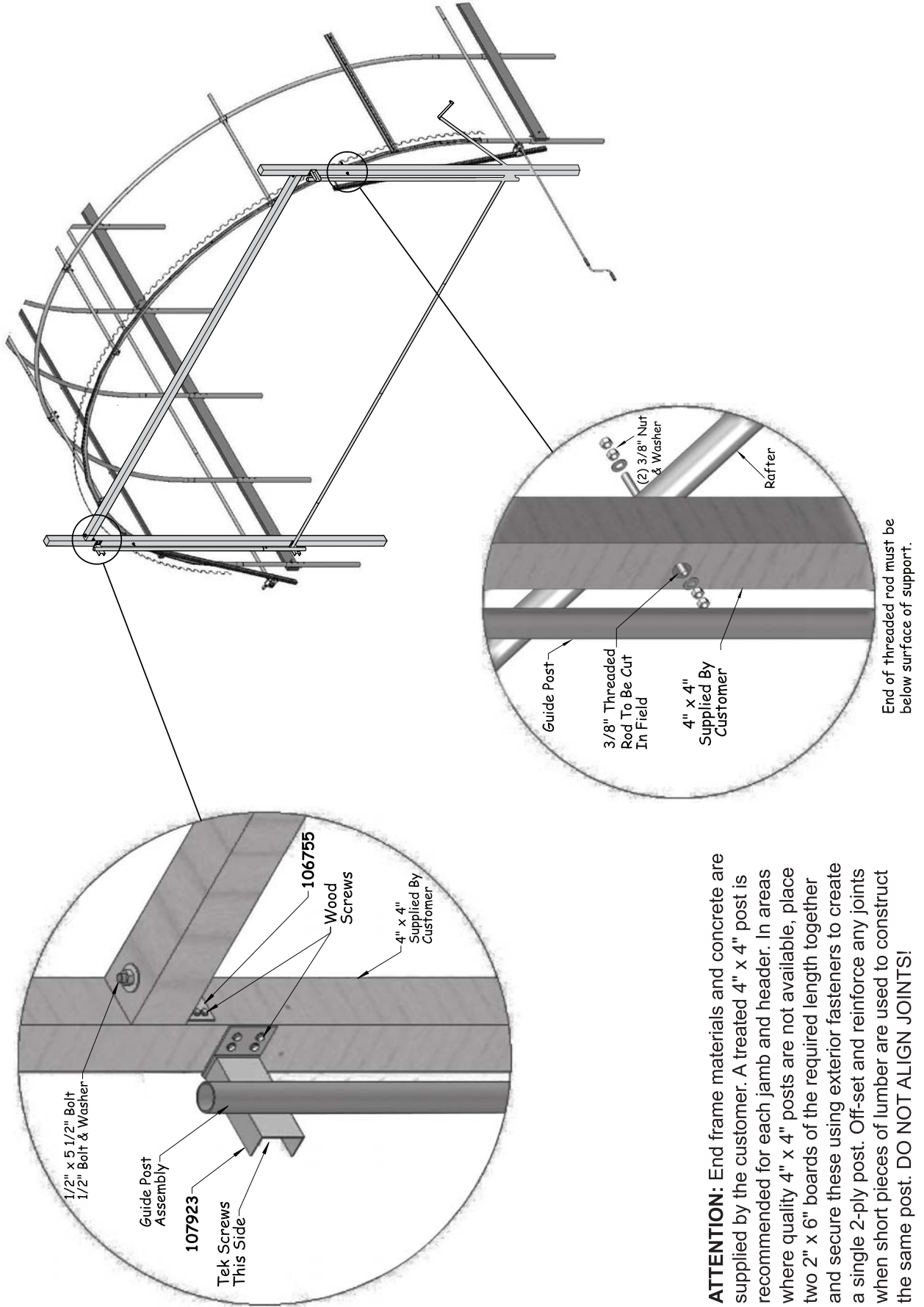
CONNECTIONS AND DETAILS



END FRAMING



END FRAMING - CONNECTION DETAILS

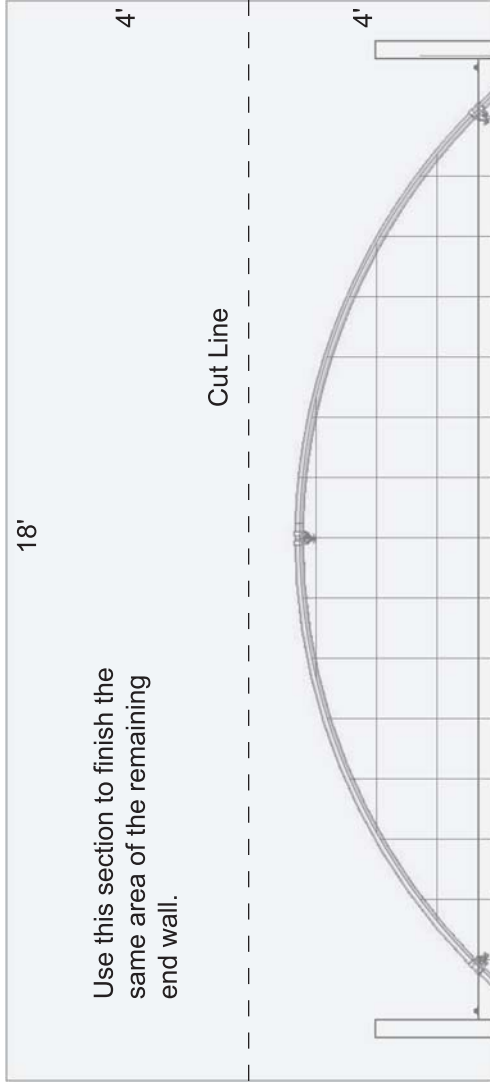


ATTENTION: End frame materials and concrete are supplied by the customer. A treated 4" x 4" post is recommended for each jamb and header. In areas where quality 4" x 4" posts are not available, place two 2" x 6" boards of the required length together and secure these using exterior fasteners to create a single 2-ply post. Off-set and reinforce any joints when short pieces of lumber are used to construct the same post. **DO NOT ALIGN JOINTS!**

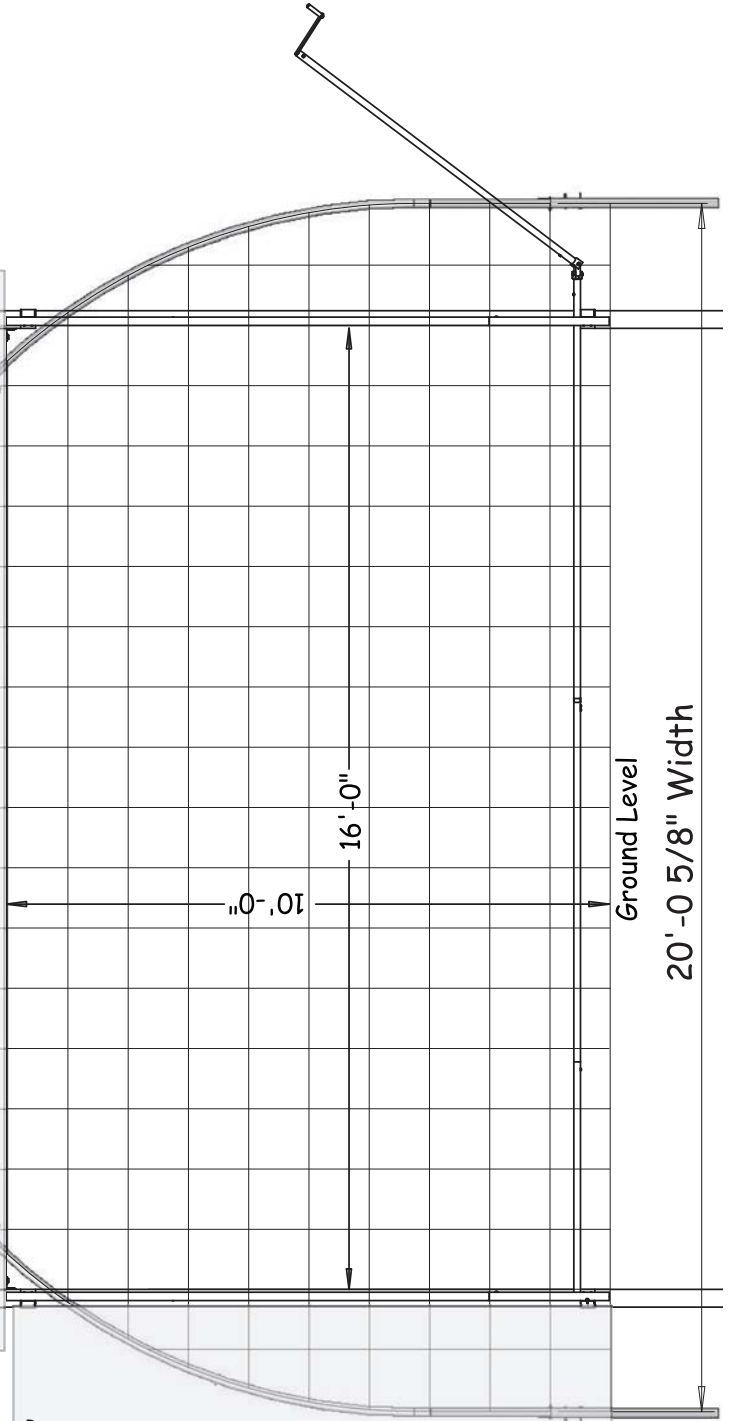
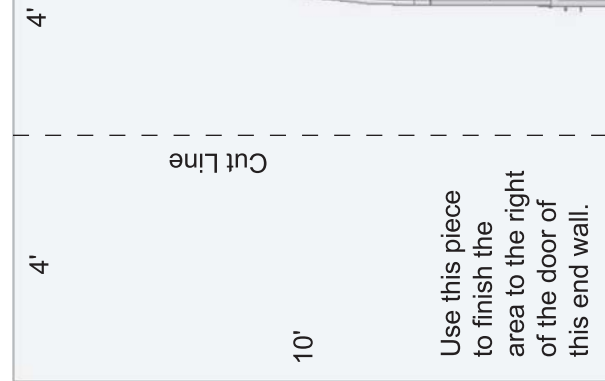
CUT DCC4931 MATERIAL FOR END PANELS

ATTENTION: Measure all areas before cutting the end panel material. Adjustments made during construction may cause dimensions to vary. Dimensions noted are approximate.

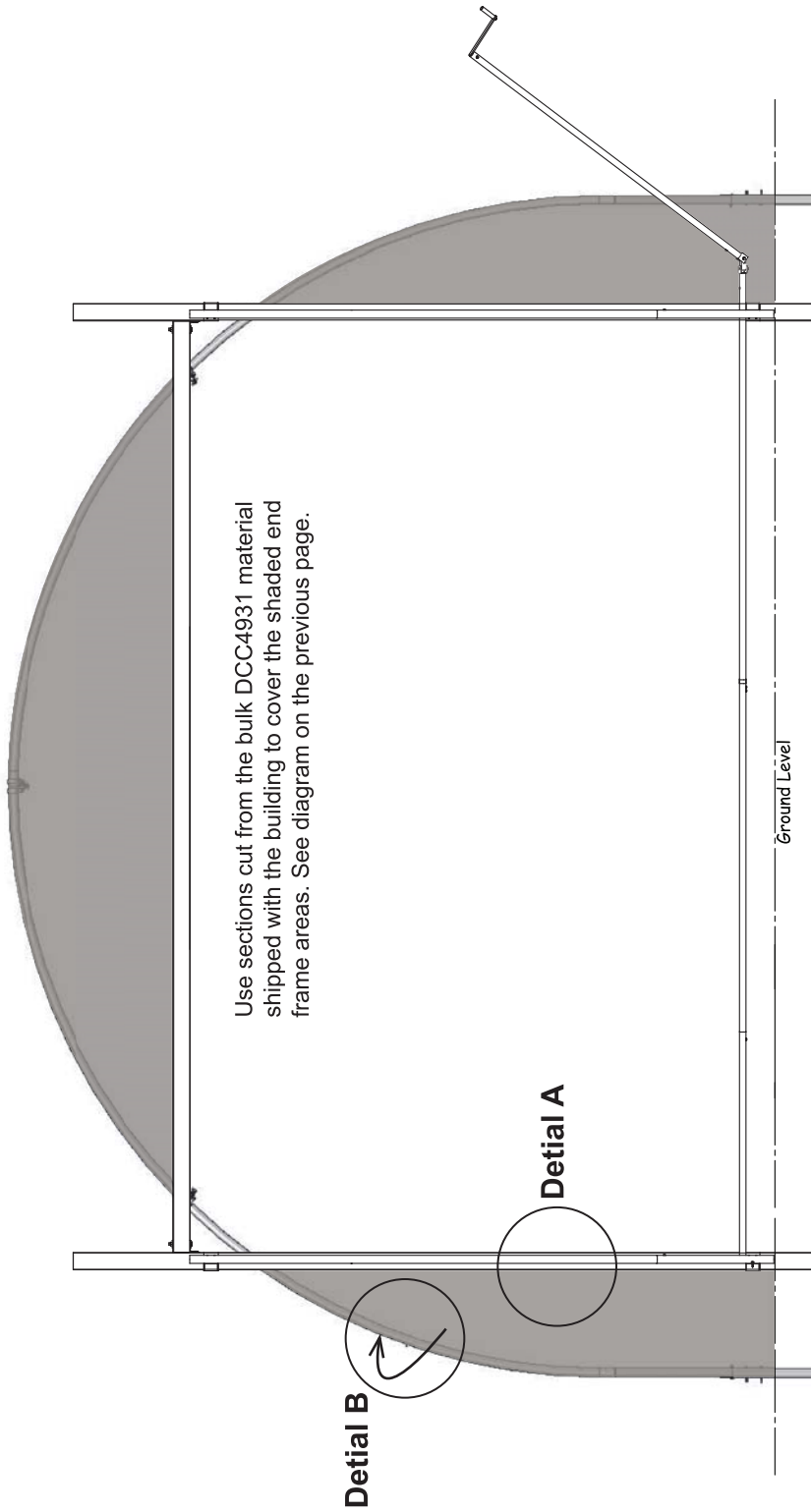
Cut an 8' x 18' piece of DCC4931 and cut this piece in half as shown.



Cut an 8' x 10' piece of DCC4931 and cut this piece in half as shown.

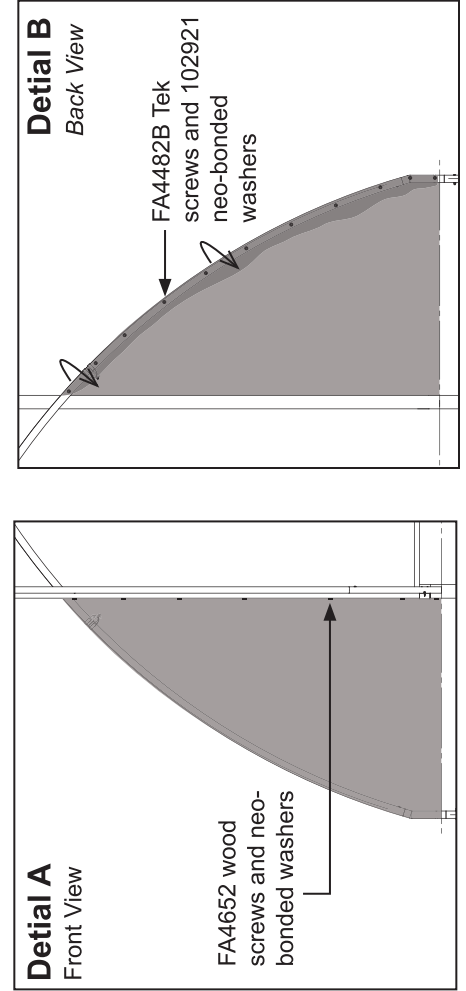


END PANEL LOCATION DIAGRAM

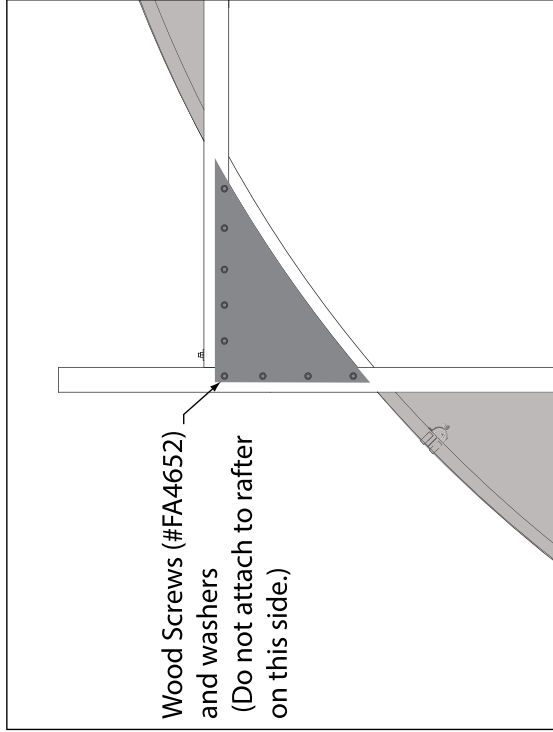
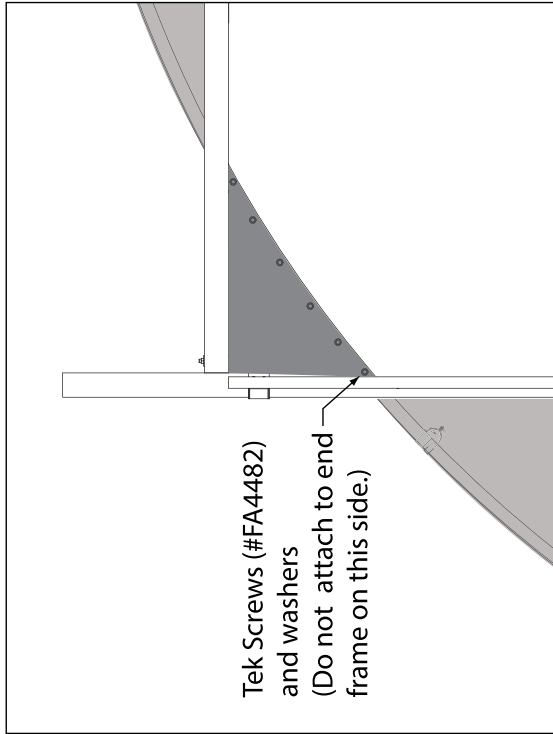


ATTENTION: The shaded areas identify where to install the end panel material. Measure each area, cut a section from the bulk DCC4931 material, and attach the material to the end frame.

For best results, cut a rectangular piece of material to cover a section and trim the piece to size after attaching it to the frame.



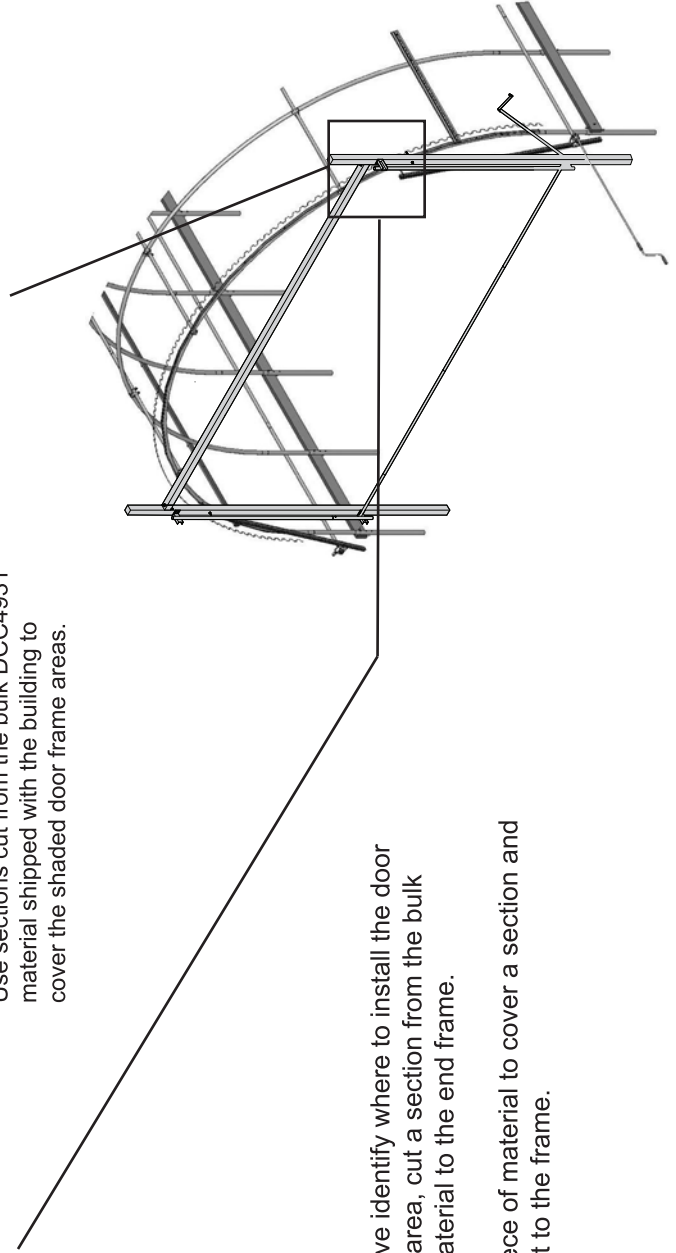
DOOR FRAME PANEL LOCATION DIAGRAM



Front View

Back View

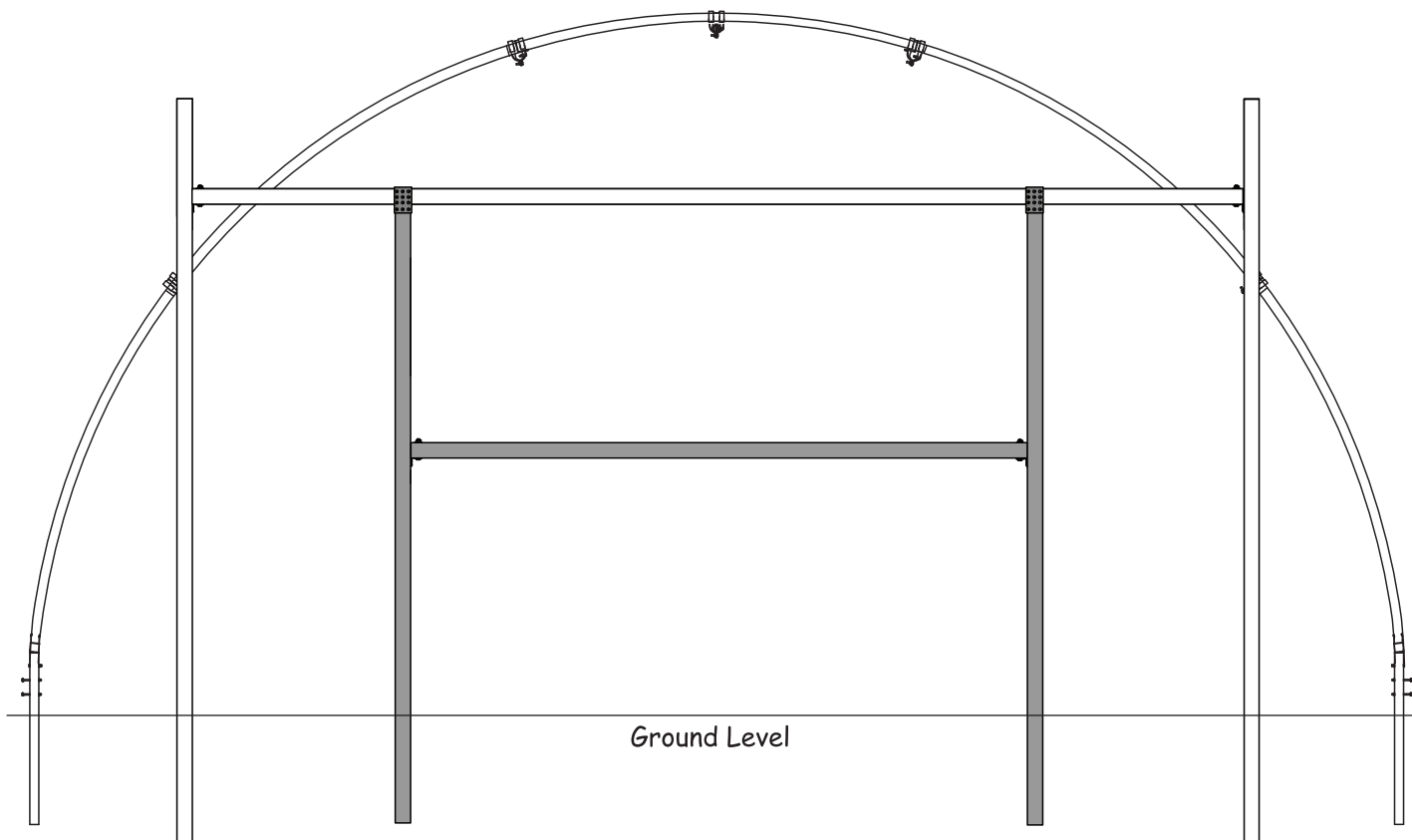
Use sections cut from the bulk DCC4931 material shipped with the building to cover the shaded door frame areas.



ATTENTION: The shaded areas above identify where to install the door frame panel material. Measure each area, cut a section from the bulk DCC4931 material, and attach the material to the end frame.

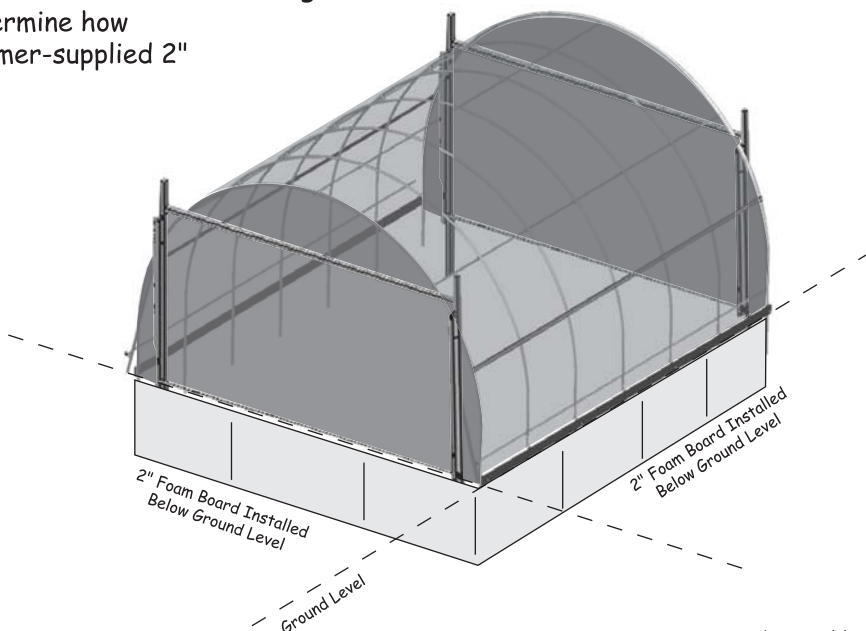
For best results, cut a rectangular piece of material to cover a section and trim the piece to size after attaching it to the frame.

Suggestions: Winterizing the High Tunnel



Using customer-supplied materials, create "H" bracing within the roll-up end panel frame to support the panel during winter months and strong winds. Secure horizontal support using pins for easy removal. Vertical bracing can remain throughout the year if spaced according to needs.

For added cold protection below ground, bury 2" foam insulation board down to the frost line around the perimeter of the building. Consult a qualified construction contractor **before erecting the high tunnel*** to determine how best to install the customer-supplied 2" insulation board.



*Actual high tunnel may differ.



Space below is reserved for customer notes.