

## Recommendations for the construction of a GTKA tournament plate by the material expert Bernd Weber (Status: 10 July 2023)

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- **Material and tool requirements** (see also Fig. 1)

- Have chipboard (waterproof if possible) and the surrounding band of wooden slats cut to size at a carpenter or DIY store, see last page for dimensions.
- Approx. 20 - 28 screws (e.g., Spax screws) between 3.5 x 40 mm and 4.5 x 50 mm.
- Water-soluble wood glue or white glue (Ponal, Henkel, approx. 400 - 450 grams) is preferable for gluing the felt; alternatively, Ovalit textile wallpaper glue (Henkel) can be used. The felt absorbs a small amount of the wood glue in the contact area, which additionally glues the felt fibers in the lower area. Pattex or silicone are less suitable, as these only fix the felt at the contact points and this leads to a higher footing of the felt.
- If possible, use a colored pencil with a metal tip to make it easier to draw the lines. The most common pen is the Pentel correction pen (12 ml, enough for approx. 10 plates), the Edding 780 pen (approx. 6 - 8 plates) is also suitable, although its lines fade somewhat faster. Less suitable are the pens with a felt tip, e.g., Edding 750.
- 1 pair of tournament goals, available from the original manufacturer Mieg for approx. 40 € or from the GTKA material service.
- Original felt (100% wool) for heavy use, available from the original manufacturer Mieg for approx. 60 € or from the GTKA material service.
- The following tools and aids are needed: Drilling machine, drill bits with a diameter of 3.5/4.0 mm and 8 mm, jigsaw (alternatively fretsaw), sandpaper, rasp, cutter (sharp knife), meter rule, pencil and a piece of straight strip for spreading the glue.

- **Obtain material**

When cutting the bands, it is recommended that the length of the longitudinal bands corresponds to the length of the panel, the transverse bands then each have the length of the panel width plus 2 x band thickness.

## • Working step 1

First check and prepare the chipboard and bands for a perfect fit. Mark the cut-outs in the area of the goalkeeper controls in the short boards and cut them out with a jigsaw, hacksaw or powder saw or alternatively cut small bars. If necessary, rework the cut surfaces with a wood rasp and round off all edges with sandpaper. Then mark the holes for the fastening screws (Spax) at a distance of 20 to 25 cm and drill them with a drill in the nominal diameter according to the screw designation and countersink them slightly.

## • Working step 2

When everything is prepared, the next step is to apply glue to the chipboard generously, over the entire surface and, above all, evenly (Fig. 2). A flat lath, strip, ... with a length of 25 - 50 cm is suitable for spreading.

## • Working step 3

The most critical part is the application of the felt, which requires 2 people. One (A) has the task of holding the felt slightly under tension while the other (B) aligns the felt, attaches it to the chipboard and spreads it into the glue. The felt is spread out, each person takes 2 corners of the narrow sides of the felt. A and B face each other on the narrow sides of the plate. A and B spread the felt over the chipboard. B arranges the felt widthwise and places it in the glue with an overhang of about 0.5 cm beyond the chipboard at the cross edge of the chipboard. A holds the felt slightly under tension and especially the rest of the felt away from the glue, while B carefully spreads the felt 3 - 5 cm deep into the glue at the edge with his fingers. Any wrinkles in this first strip should be removed immediately by peeling it off and pressing it on again. Starting from this first strip, !!! evenly from the middle to the outside !!! spread one finger-length strip after the other into the glue (Fig. 3) until the whole felt is applied. A always keeps the felt under tension so that no wrinkles appear. If any do appear, immediately pull the felt up to the folds and spread it into the glue again.

## • Working step 4

Pay particular attention to this: The pressure with the fingers on the felt should always be the same, as the felt absorbs more or less glue with different pressure. It is also important to avoid pressure marks caused by tool rests, supports, etc. after the felt has been applied and before the glue has hardened as this would lead to an uneven playing surface.

## • Working step 5

The protruding felt is cut off with a sharp knife, cutter, ... (Fig. 4), but it can also be clamped between the chipboard and the band. The prepared bands are placed one after the other lengthwise from the top to the edge of the board and moved downwards until the band is flush with the underside of the chipboard. In this position, the band is screwed on with Spax screws.

## • Working step 6

Do not start applying the lines until the glue from the felt application has hardened. When using Ponal, this takes approx. 30 - 60 minutes. First, mark all the corner points (and corresponding auxiliary points if the lines are longer than the ruler/ledge used) with a dot as a marker. These are then connected to each other (Fig. 5). For circle cut-outs and circles, make cardboard templates if no suitable plates, pots, tins, lids, ... (Fig. 6) are available.

## • Working step 7

For potential felt dealers, sales are reduced by a factor of about 3 if the felt in the heavily used goal area is additionally coated with Ponal (Fig. 7). The durability of the felt increases by about this factor; the goalkeeper's box then does not wear through the felt.

## • Working step 8

The goals are placed at the goal line and the position of the 4 fixing holes is marked on the felt. From the felt side, drill a hole with a diameter of 3.5 mm through the chipboard at each of these markings. From the underside, drill the holes for the screw heads (so that the tabletop is not scratched) about 5 mm deep with an 8 mm diameter drill. Then, from below, insert the screws through the board and the fixing holes of the gates, screw on one nut each and tighten firmly (Fig. 8).

## Last but not least ...

you need a ball, two game pieces, two goalkeepers, a good - but not too good - opponent and the fun can begin. In case of unforeseen problems or general questions about panel building, technology and tuning, telephone support is available on +49 7361 44987.



# German Tipp-Kick Association

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## • Estimated cost of materials

Material costs per tournament plate (as of 2023)	for one table
Chipboard, 19 mm, 124 x 80 cm, waterproof	approx. 15 €
Surrounding band of wooden slats	approx. 10 €
GTKA goals	38 €
Felt	39 €
Glue Ponal (approx. 8 € for a can with 760 gram)	approx. 8 €
Screws	approx. 5 €
Pentel white color pencil (approx. 5 € for 10 plates)	approx. 5 €
SUM	approx. 120 €

## • Time required

First plate	approx. 2 hours
With practice, from approx. 10 plates	approx. 1 hour
With a lot of practice	approx. 30 minutes

If you need less than 15 minutes per plate, please call +49 7361 44987.

## • Storage of tournament plates

Due to the protruding goals, it is not advisable to simply stack the tables with mounted goals on top of each other. Due to the weight of one table of approx. 16 kg, the weight of e.g., 6 tables stacked on top of each other is approx. 100 kg. Although the tables and goals used in the GTKA basically belong to the category "indestructible", such a load is too much for the goals in the long run. Since the constant assembly and disassembly of the goals is too time-consuming, the use of hard Styrodur panels with a thickness of 8 - 10 cm and dimensions of 50 x 100 cm has proven to be the best transport and storage protection between the tables. At a cost of approx. € 2.50 per panel, these are a very inexpensive way of simplifying table handling and effectively protecting them during storage and transport.

# HAVE FUN BUILDING THE PLATES!

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Bild 1



Bild 2



Bild 3



Bild 4



Bild 5



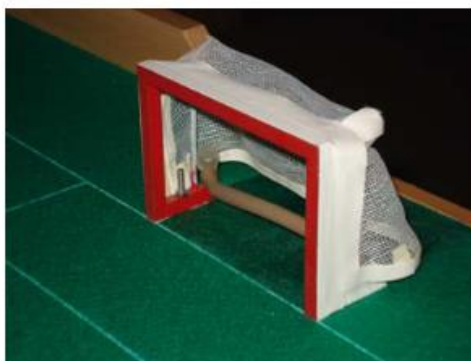
Bild 6



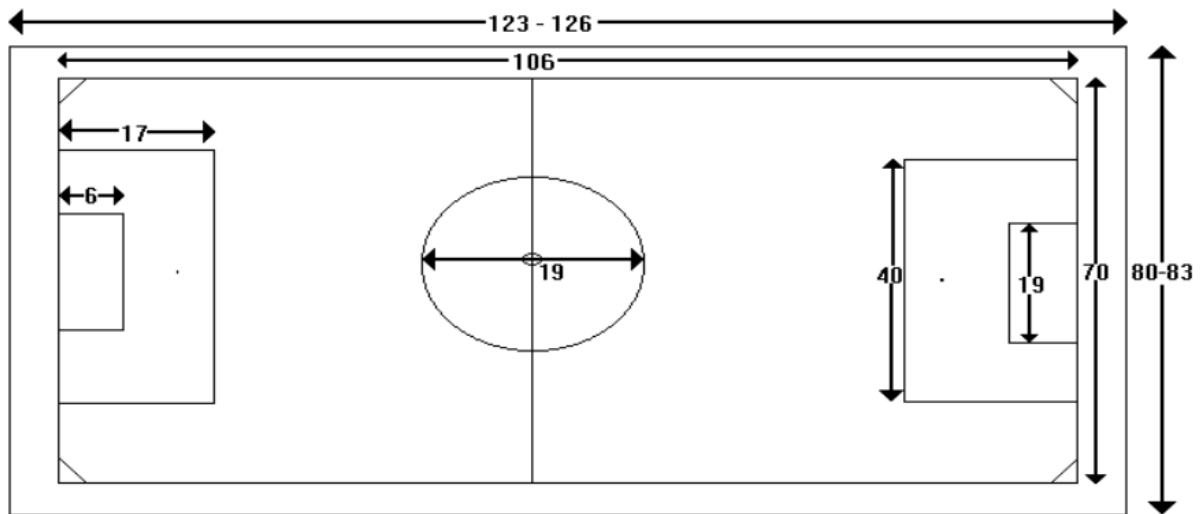
Bild 7



Bild 8



## The exact dimensions of the pitch



Playing table length 123 - 126 cm

Playing table width 80 - 83 cm

Pitch length 106 cm

Pitch width 70 cm

Penalty area length 17 cm

Penalty area width 40 cm

Goal area length 6 cm

Goal area width 19 cm

Diameter of center circle 19 cm

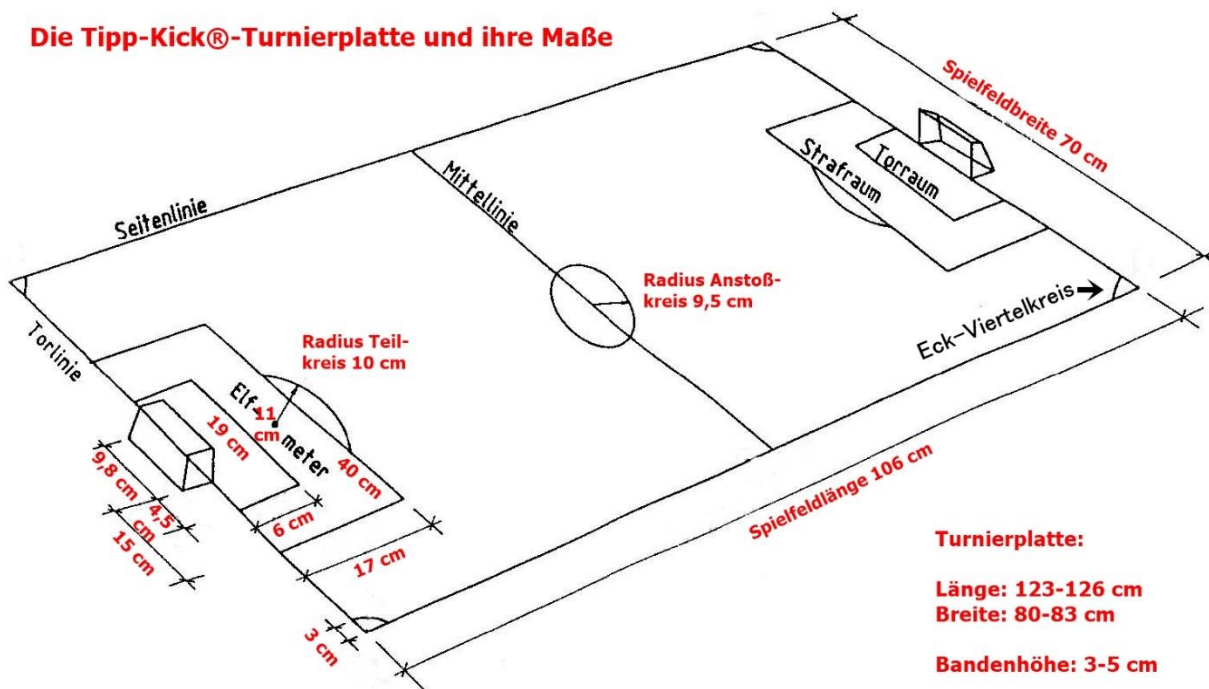
Distance of penalty point 11 cm

Radius corner playing surface 3 cm

Height of the board (above the pitch) 3 - 5 cm

Cut-out in the board behind the goal (for goalkeeper control) 19 - 22 cm

## Die Tipp-Kick®-Turnierplatte und ihre Maße



The finished result

