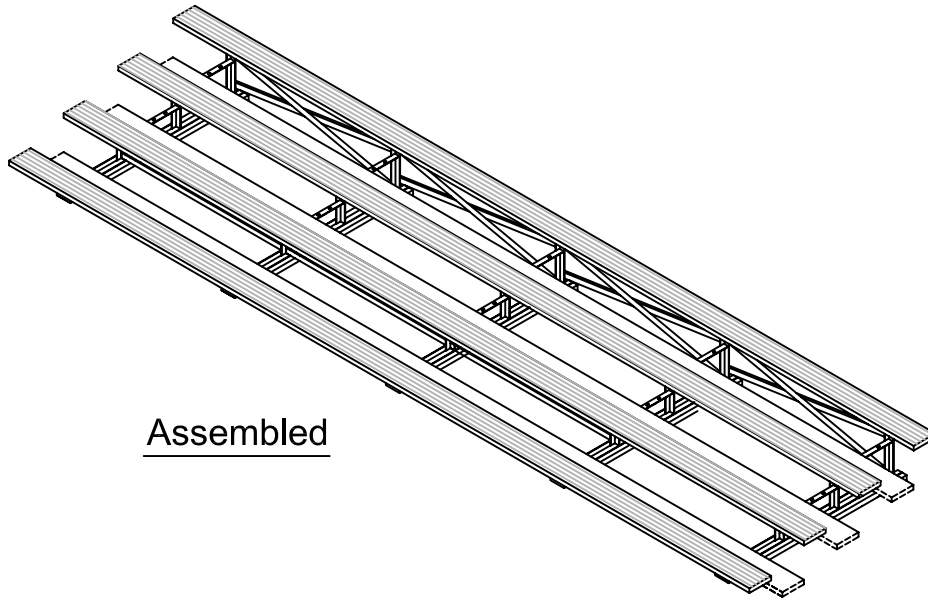


4-ROW BLEACHERS

- MODEL #1174-27 4 ROW 27' STEEL W/O GUARDRAILS (787 lbs)
- MODEL #1175-27 4 ROW 27' ALUMINUM W/O GUARDRAILS (534 lbs)



Assembled

Specifications:

Bleacher Frames, Horizontal and diagonal Bracing:

Fabricated from 2" x 2" x 3/16" steel or aluminum angle. Frames are welded into a single unit. (Frames may have optional 2" x 6" ground sills at every point where frames are in contact with the ground.)

Seat and Foot Planks: 2" x 10" x 27' extruded ribbed aluminum. The wall thickness at any point shall not be less than .080". The edges and tops of planks shall be ribbed. The ribbed pattern, non-slip surface, is designed for safety and comfort with a grooved anodized coating. All exposed ends shall have aluminum caps fastened to the underside of the plank. Planks secure to each frame with two friction-type aluminum mounting clips capable of securing plank against movement. (All hardware is provided.)

Finish: All fasteners shall be zinc plated. All welds ground smooth.

Note: Our three and four row bleachers are exempt from current guardrail rules because they are less than 30" high.



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4 ROW BLEACHERS


DWG. NO.

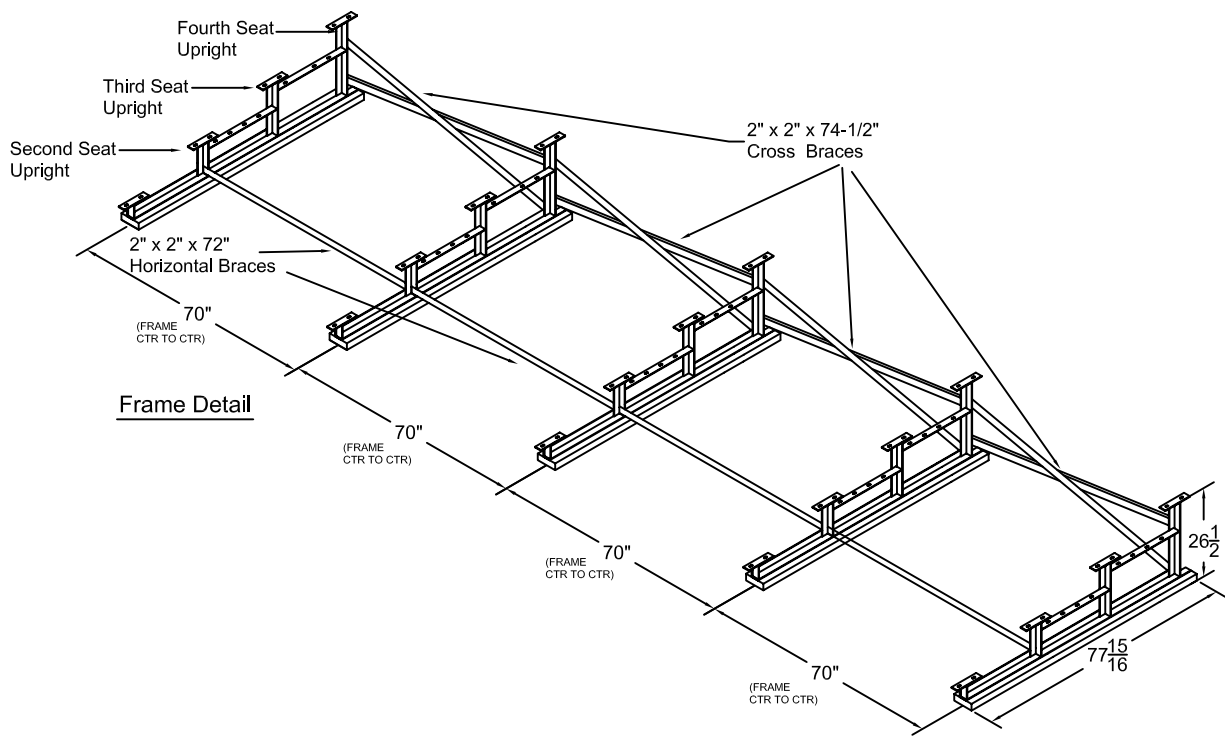
MODEL #1174-27 4 ROW 27' STEEL
MODEL #1175-27 4 ROW 27' ALUMINUM

SHEET
1 OF 4

INSTALLATION INSTRUCTIONS:

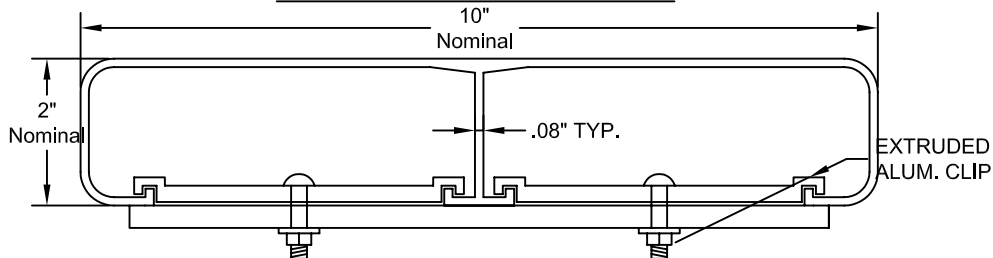
1. Check materials received with the parts list (Page 4) to make sure that all components are included and to assure that the unit is complete.
 2. Installing End Caps on seat and foot planks:
 - a. Locate (7) 2" x 10" x 27" seat and foot planks and (14) 2" x 10" end caps.
 - b. Align and assemble all end caps to aluminum planks. Secure using a #10 x 3/4" self-tapping screw in two locations on the underside of the plank. (See End Cap Detail)
 3. Locate five bleacher frames and set on a level surface on 70" centers. (See Frame Detail)
 4. To Install Cross Braces:
 - a. Locate two sets of cross & horizontal braces measuring 2" x 2" x 74-1/2". (See Frame Detail) Install on the backside of the 4th seat upright, using the top and bottom holes in the frame. Repeat steps to assemble second and third sets of cross braces to the other bleacher frames.
 - b. On the center bleacher frame at the top and bottom brace attachment locations where two diagonal braces attach at the same installation point, secure braces using 3/8" x 1-1/4" hex bolt, washers and lock nut provided. (See Detail B)
 - c. At the center point of the cross braces secure brace connection using 3/8" x 1-1/4" hex bolt, washer and locknut provided. (See Detail C)
 - d. Install 2" x 2" x 74-1/2" Horizontal braces below 2nd foot board support on the second seat upright with 3/8" x 1-1/4" hex bolts & 3/8" flat washer & nuts.
 - e. At all installation points install washers and nuts but leave hardware loose until assembly is complete for easy installation. Note: Two washers are provided to use at every hex bolt location.
 5. To install seat planks:
 - a. First install the plank clips using 5/16" x 1" carriage bolts, washer and lock nuts, on top of seat and foot board supports. Give nuts about 3/4 turn (just enough to secure). Turn plank clips perpendicular to the frames. (See Detail D)
 - b. Position seat planks on the seat supports so the plank clips are between the slots in the bottom of planks. See Detail E.
 - c. Reach up underneath the seat & foot planks and turn the plank clips to the position shown. (See Typical Cross Section Detail)
 6. To install foot planks:
 - a. Follow the steps as outlined in step 5 for installation of foot planks.
 7. To Secure Planks to Frames:
 - a. Align the end of the planks on rows so they are approximately 18" from outside edge of plank to center of bleacher frame to end of plank looking at the bleacher. (See Detail E) Tighten all hardware on frames & planks securely.
 8. Cut and peen all exposed bolt threads past 2 threads out of nut.
- Note: To insure proper installation, bolts used to secure seat, foot and riser planks must be tightened until the clips are firmly in contact with the plank. (See Typical Cross Section)
9. Installing (Optional) Ground sills (wood measuring 2" x 6" x 4'-6"):
 - a. Center one ground sill under each bleacher frame so the ends are evenly spaced and are centered from side to side. Mark the (2) hole locations in each bleacher frame on each of the ground sills and drill 1/4" x 1" deep pilot holes. Do Not drill completely through the ground sills.
 - b. Attach the ground sills to the bottom of the bleacher frames with 5/16" x 1-1/2" lag bolts and flat washers provided.

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		DATE: 5-4-04	<h2>4 ROW BLEACHERS</h2>	
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		REV: 2-28-07	DWG. NO.	MODEL #1174-27 4 ROW 27' STEEL
		MODEL #1175-27 4 ROW 27' ALUMINUM		

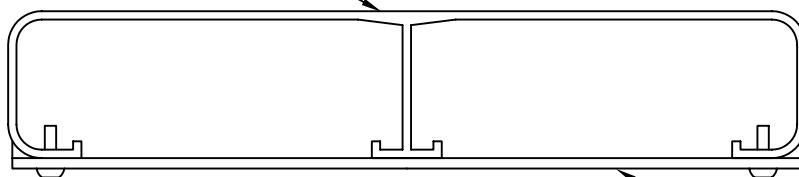


Frame Detail

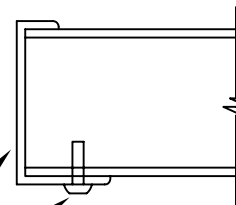
TYPICAL CROSS SECTION



ALUM. PLANK



END CAP
DETAIL



#10 X 3/4" self-tapping screw



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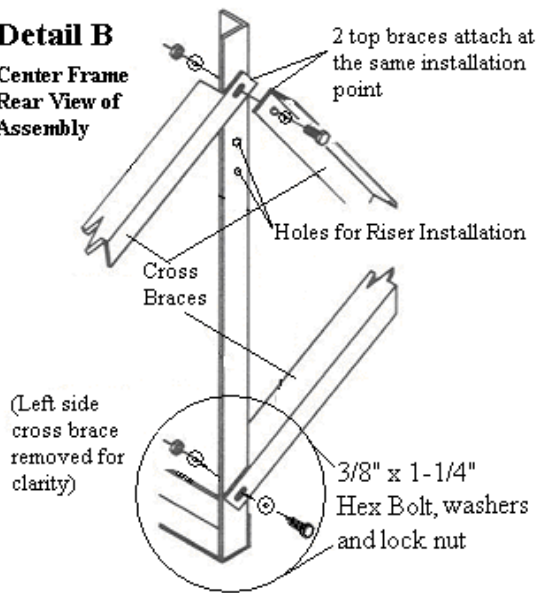
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4 ROW BLEACHERS

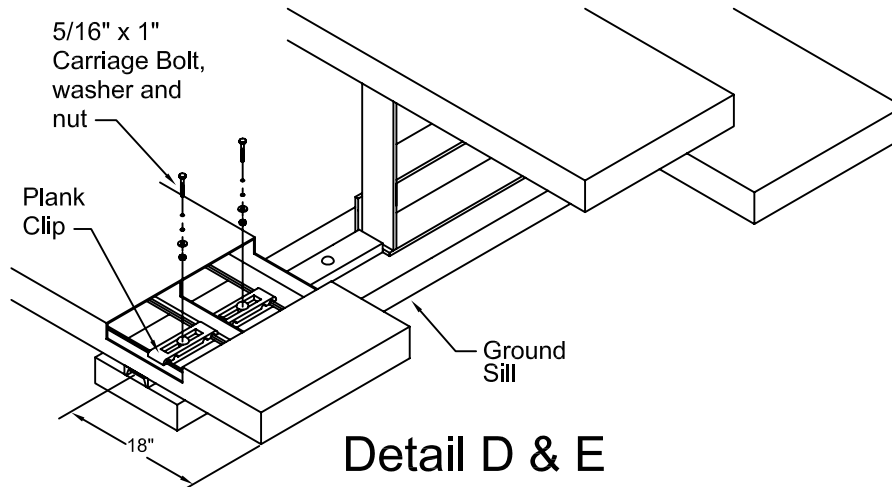
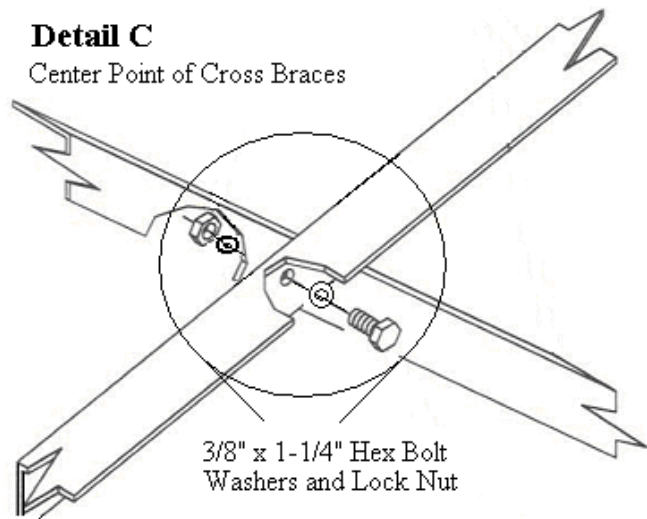
DWG. NO. MODEL #1174-27 4 ROW 27' STEEL
MODEL #1175-27 4 ROW 27' ALUMINUM

SHEET
3 OF 4

Detail B
Center Frame
Rear View of
Assembly



Detail C
Center Point of Cross Braces



Detail D & E

MATERIAL LIST	QTY
Aluminum Plank (27') anodized	7
4 row bleacher frame	5
Diagonal frame brace-74-1/2"	8
Diagonal frame brace-72"	4
Aluminum end cap (2" x 10")	14
#10 x 3/4" self tapping screw	28
Aluminum Plank clip	70

MATERIAL LIST	QTY
5/16" x 1" carriage bolt	70
5/16" flat washer	70
5/16" lock nut - nylock	70
3/8" x 1-1/4" hex bolt	19
3/8" flat washer	38
3/8" lock nut - nylock	19

OPTIONAL GROUND SILL HARDWARE

MATERIAL LIST	QTY
2" x 6" x 6'-6" Ground Sill	5
5/16" x 1-1/2" Lag Screws	15
5/16" Flat Washer	15



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4 ROW BLEACHERS

DWG. NO. MODEL #1174-27 4 ROW 27' STEEL
MODEL #1175-27 4 ROW 27' ALUMINUM

SHEET
4 OF 4