



## WARRANTY AND MAINTENANCE SHEET

Before attempting assembly, examine the enclosed drawings; identify the various parts and their corresponding part numbers. Compare the parts and quantities with packing list, noting any discrepancies. The assembly drawings were designed to provide you with an easy to understand picture of the bleacher assembly. Should you have any difficulties in assembly, contact our customer service department at 1-800-527-7510.

### IMPORTANT NOTICE

These bleachers have been designed and manufactured to meet NFPA National Fire Protection Association and CPSC Consumer Product Safety Commission Standards for Safety. However, since local codes may vary, the purchaser of the product must be responsible for compliance with local or state codes pertaining to this product. The manufacturer, distributor, or any of their representatives assume no liability for code compliance.

### SURFACE PREPARATION

**ALL** bleachers **MUST** be installed on a solid, smooth and level surface. Manufacturer will not be responsible for any damage resulting from the use of this product on any irregular surface conditions. **ALL** bleachers with a top row seat over 30" from ground level **MUST** be anchored to a concrete pad or footer. Most local codes require permanent anchoring to concrete to meet wind load requirements. Please check your local codes. Bleachers with a top row seat less than 30" from ground level may remain portable however manufacturer strongly recommends attaching weather treated lumber Groundsills. Groundsills should be at least 2" x 6" lumber and attached with  $\frac{3}{8}$ " x 1  $\frac{1}{2}$ " lag screws (not provided).

### STORAGE

Assembled units shall be stored in usable position only, not tilted back on column. The manufacturer will not be responsible for damage or personal injury resulting from product being stored in any other position.

### MAINTAINANCE

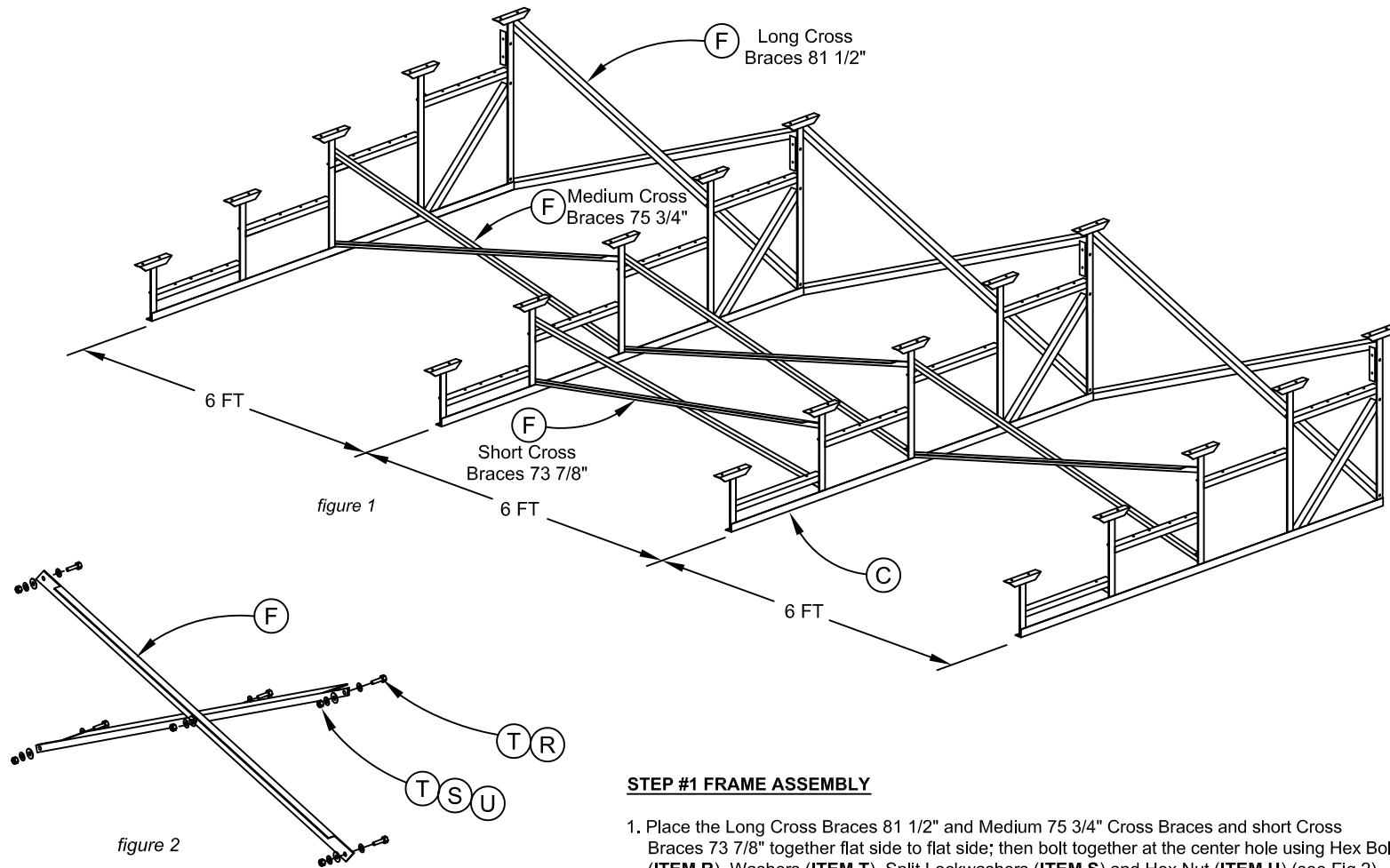
In order to assure continued spectator safety and comfort, an annual inspection of these bleachers is required. No warranties, specified or implied, will be honored on this product unless replacement parts are purchased from original manufacturer and unless inspection and maintainance records have been kept by the Owner. This annual inspection shall include, but is not limited to the following:

1. Bolt tightness (Bolts, nuts, set screws, etc).
2. Vertical and horizontal alignment of all component parts.
3. Any broken or damaged parts, whether from normal use or abuse.
4. End cap fit and condition (snug fit, unbroken condition).
5. Visual inspection of any and all welded connections.
6. Insure that the base angle is in full and continuous contact with supporting surface, i.e., turf, concrete, asphalt or grade.

### WARRANTY

All bleachers shall carry, after proper assembly and under normal use for the type of structure, a five (5) year warranty against all defects in materials and workmanship. In addition, all aluminum plank extrusions shall be covered by a one (1) year warranty against deterioration of anodized finish or loss of structural strength due specifically to constant exposure to changing weather and environmental conditions. Acts of vandalism or abuse shall render the conditions of these warranties null and void

# 5 ROW 70 SEAT 21 FT BLEACHER PREFERRED



## STEP #1 FRAME ASSEMBLY

1. Place the Long Cross Braces 81 1/2" and Medium 75 3/4" Cross Braces and short Cross Braces 73 7/8" together flat side to flat side; then bolt together at the center hole using Hex Bolt (ITEM R), Washers (ITEM T), Split Lockwashers (ITEM S) and Hex Nut (ITEM U) (see Fig 2).
2. Attach Cross Braces to Frames (ITEM C) as shown in Figures 1 and 2.
3. Check Frame for squareness and tighten all nuts and bolts.



# 5 ROW - 70 SEAT - 21' BLEACHER PREFERRED

## STEP #2 FRAME ASSEMBLY

1. Attach Riser Brackets (ITEM Y) using Bolt (ITEM P), Washer (ITEM O) and Locking Flange Nut (ITEM M) (See Fig 3).

## STEP #4 END CAP ASSEMBLY

1. Slide Poly End Cap (ITEM K) over end of Plank. Use drill with phillips tip to insert Self Drilling Screws (ITEM Q) (See Fig 5).

## STEP #3 PLANK ASSEMBLY

1. Attach all Aluminum Bolt Clips (ITEM N) using Bolt (ITEM L) and Locking Flange Nut (ITEM M) (see Fig 4). Do not tighten, leave loose at this time.

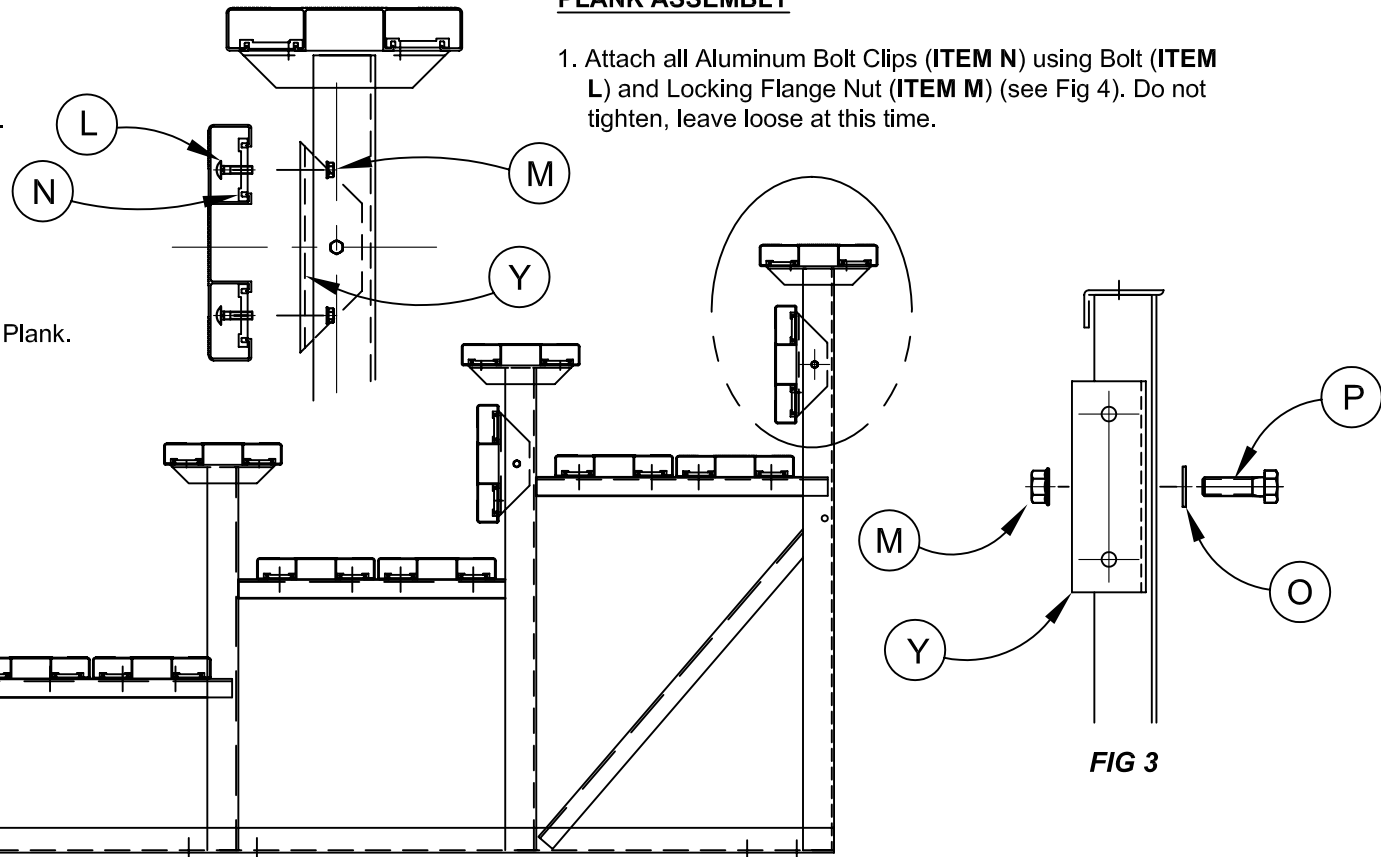


FIG 3

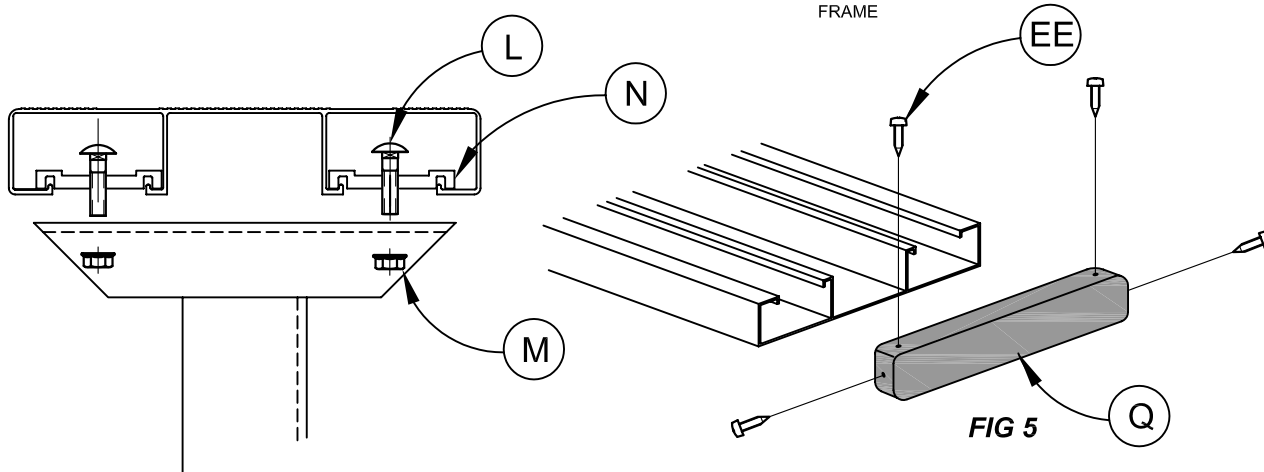
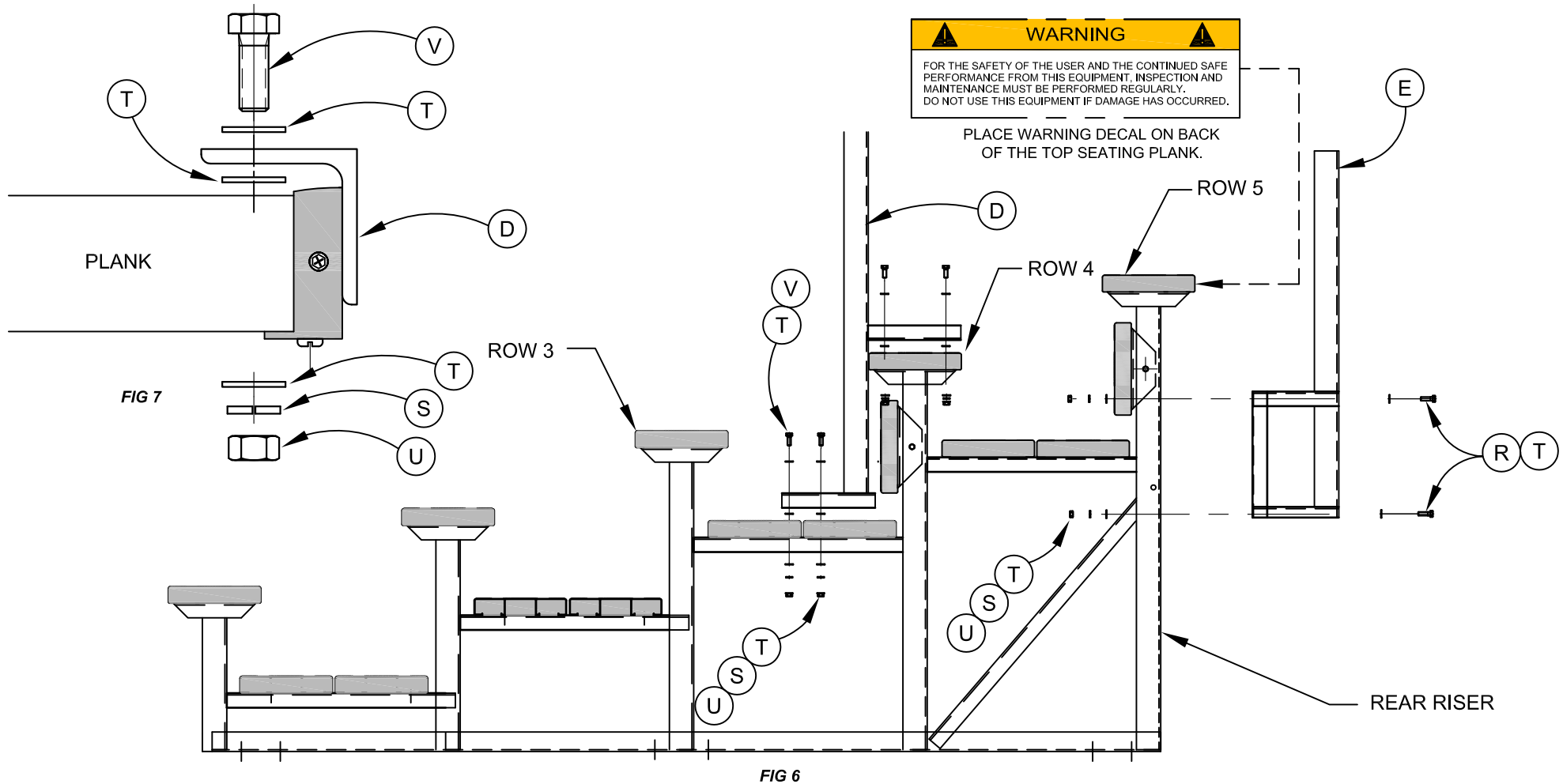


FIG 5

## STEP #5 PLANK ASSEMBLY

1. Attach all planks to frame as shown in Fig 4.  
**NOTE:** Seat Planks are anodized and have a dull finish and foot planks are not anodized and have a shiny finish.
2. Be sure the overhang of each plank is equal (appx 17"). Tighten all planks.

## 5 ROW - 70 SEAT - 21' BLEACHER PREFERRED



### **STEP #6** **GUARD RAIL SIDE POST**

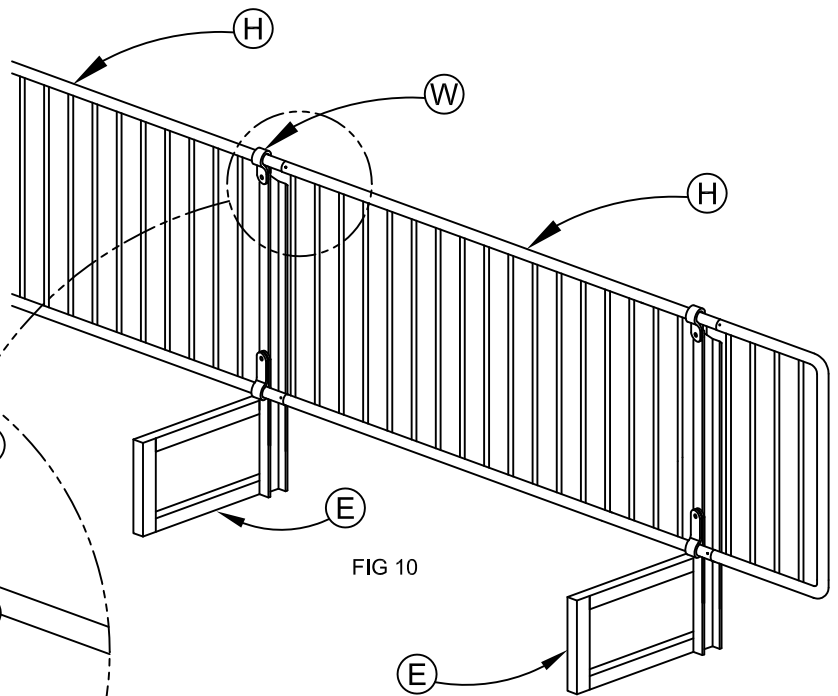
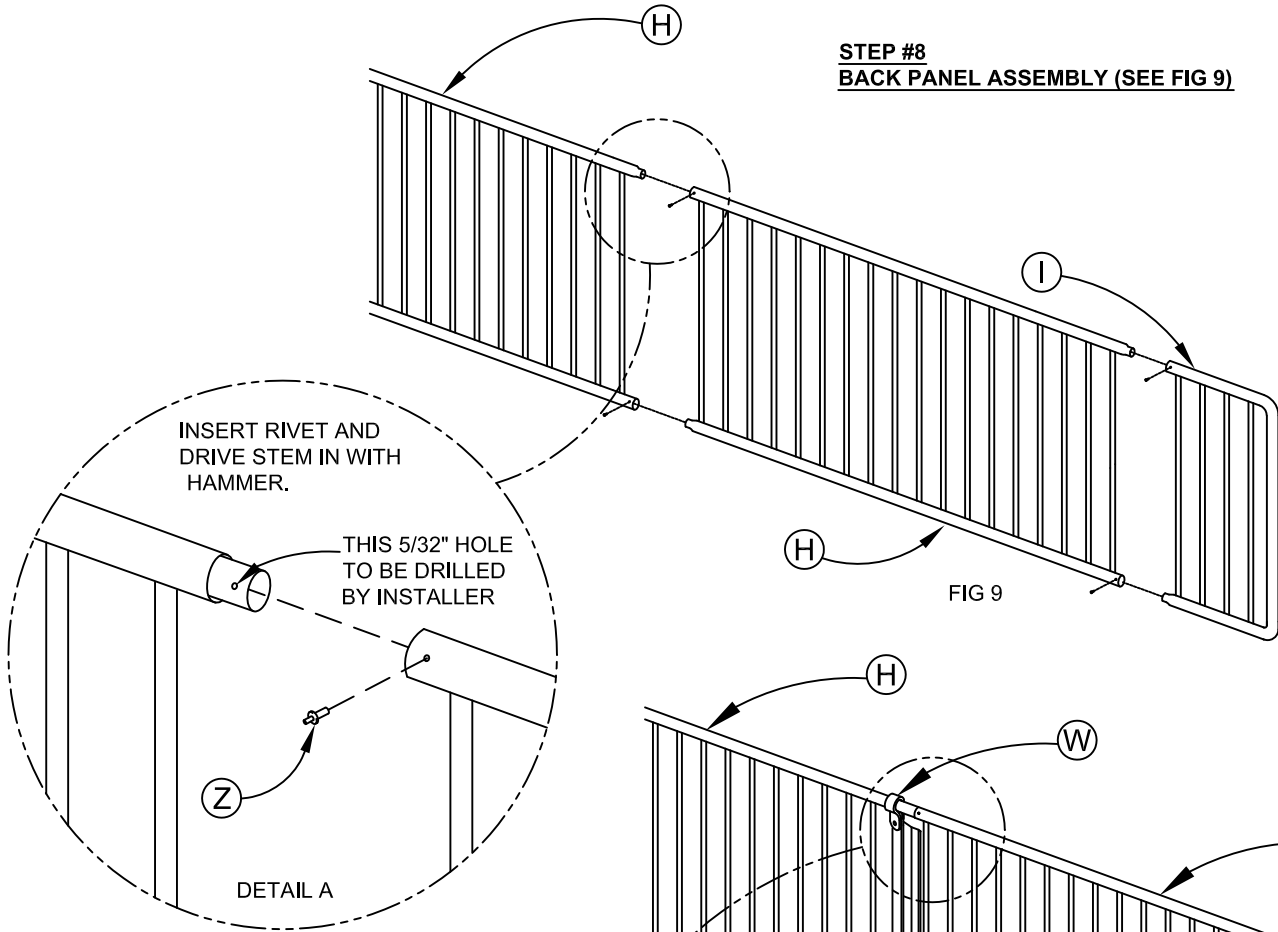
1. **NOTE:** There is a Left and a Right Guard Rail Side Posts (**ITEM D**).
2. Position Side Posts (**ITEM D**) as shown in Fig 6 & 7. Once in position on Planks, mark location of holes on Planks.
3. Drill a 3/8" dia. hole in the 4 locations you marked.
4. Bolt Side Post to Planks as shown in Fig 6 & 7. Repeat on other side of bleacher.

### **STEP #7** **GUARD RAIL BACK POST**

1. Bolt the Guard Rail Back Post (**ITEM E**) to each rear riser as shown in Fig 6.

# 5 ROW- 70 SEAT- 21' BLEACHER PREFERRED

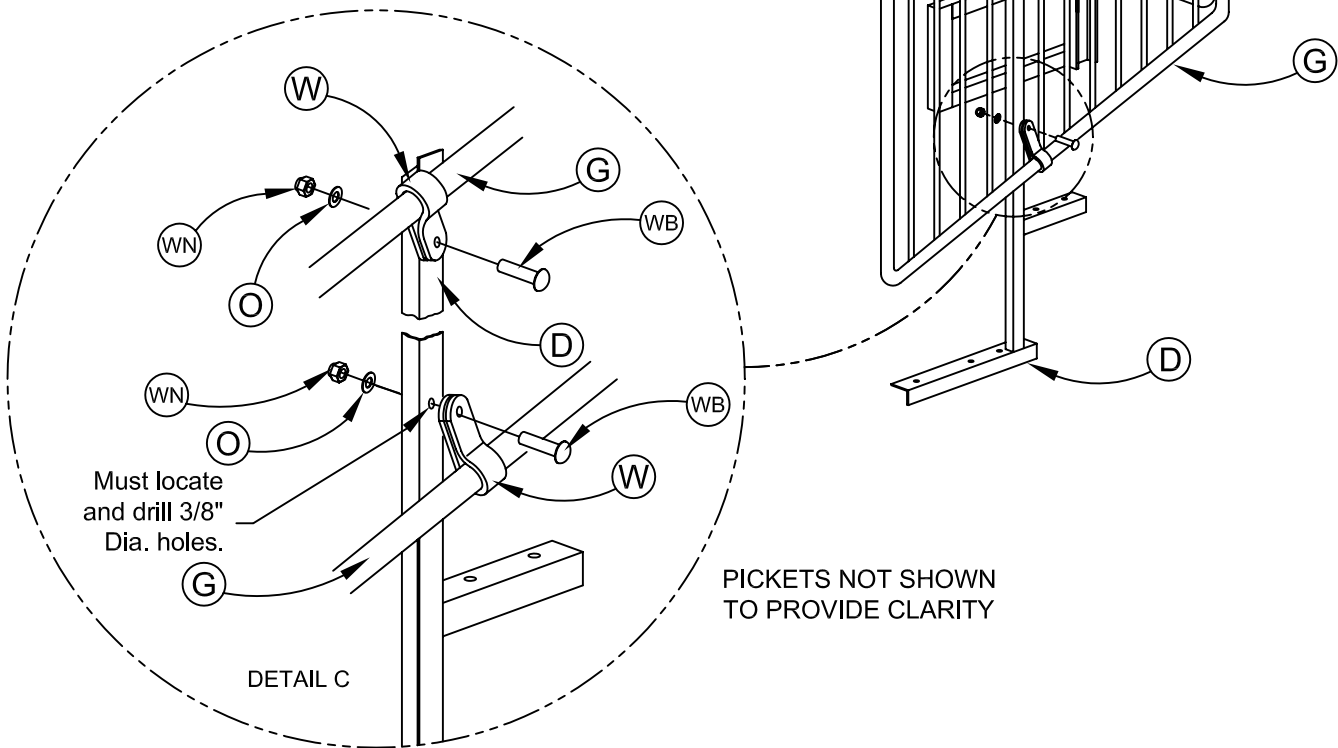
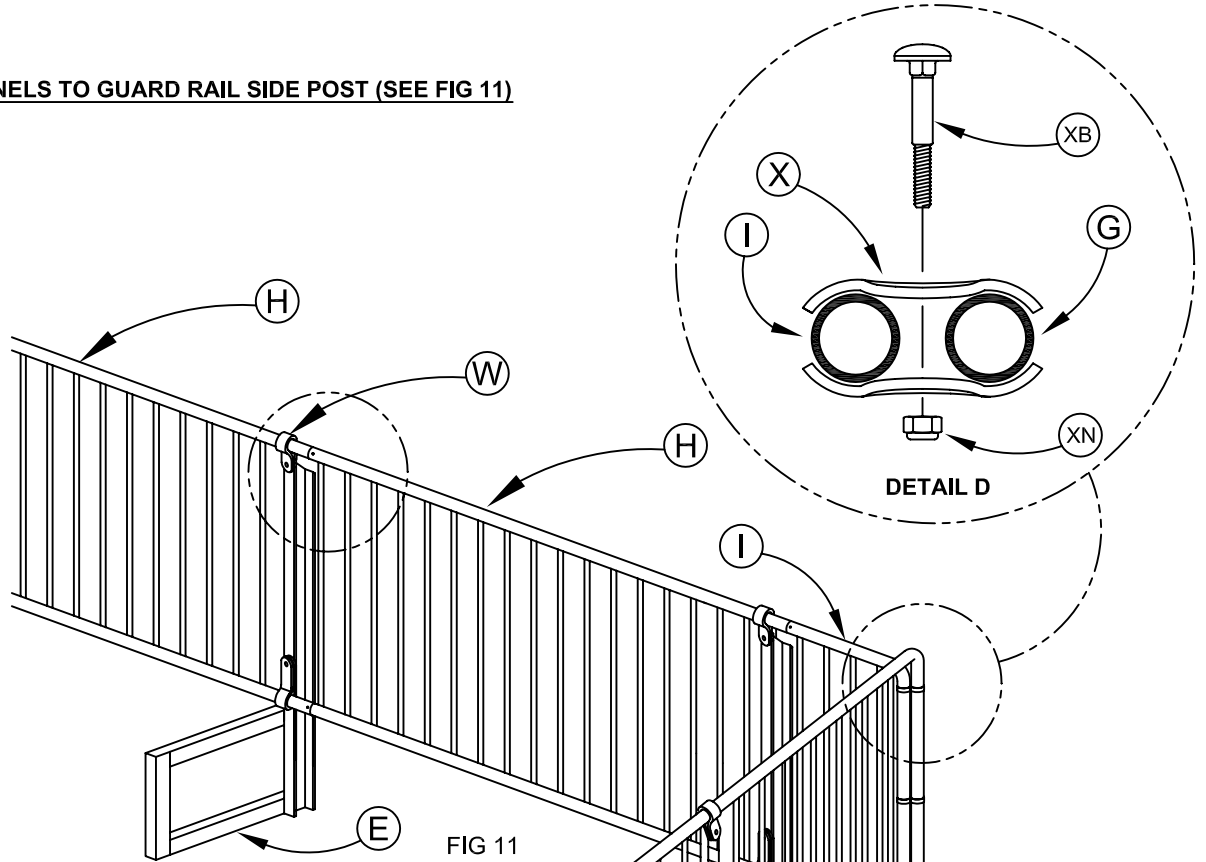
## STEP #8 BACK PANEL ASSEMBLY (SEE FIG 9)



## STEP #9 ATTACHING BACK PANEL TO GUARD RAIL BACK POST (SEE FIG 10)

# 5 ROW- 70 SEAT- 21' BLEACHER PREFERRED

**STEP #10**  
**ATTACHING SIDE PANELS TO GUARD RAIL SIDE POST (SEE FIG 11)**

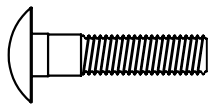


PICKETS NOT SHOWN  
 TO PROVIDE CLARITY

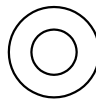
## 5 ROW - 70 SEAT - 21' BLEACHER PREFERRED PARTS LIST

ITEM	DESCRIPTION	QTY	ITEM	DESCRIPTION	QTY
A	21' ANODIZED SEAT PLANK	5 EA	J	HARDWARE PACK (HARDWARE PACK CONTENTS)	1 EA
B	21' MILL FINISH FOOT PLANK	10 EA	K	POLY END CAPS	30 EA
C	5 ROW BLEACHER FRAME	4 EA	L	CARRIAGE BOLT .312 X 1.25	120 EA
D	GUARD RAIL SIDE POSTS LEFT AND RIGHT	1 PR	M	LOCKING FLANGE NUT .312	128 EA
E	GUARD RAIL BACK POST	4 EA	N	ALUMINUM BOLT CLIPS	120 EA
F	X BRACES (14 PCS)	1 SET	O	FLAT WASHER .312	20 EA
G	SIDE PANEL	1 PR	P	HEX BOLT .312 X 1.0	8 EA
H	BACK PANEL	3 EA	Q	SELF DRILLING SCREW #8	120 EA
I	BACK PANEL EXTENSION	1 PR	R	HEX BOLT .375 X 1.25	35 EA
			S	SPLIT LOCK WASHER .375	43 EA
			T	FLAT WASHER .375	94 EA
			U	HEX NUT .375	43 EA
			V	HEX BOLT .375 X 1.0	8 EA
			W	TENSION BAND	12 EA
			WB	GALVANIZED CARRIAGE BOLT .312	12 EA
			WN	GALVANIZED HEX NUT .312	12 EA
			X	PANEL CLAMPS	6 EA
			XB	GALVANIZED CARRIAGE BOLT .375	6 EA
			XN	GALVANIZED HEX NUT .375	6 EA
			Y	RISER BRACKETS	8 EA
			Z	ALUMINUM DRIVE RIVET 5/32 X 13/32	16 EA

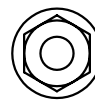
FOR IDENTIFICATION ONLY. NOT TO SCALE



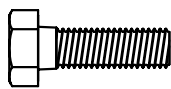
(L)  
Carriage Bolt  
5/16" x 1 1/4"  
120 each



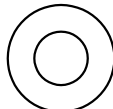
(O)  
Washer 5/16"  
20 each



(M)  
Flange Nut  
128 each



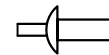
(P)  
Hex Bolt 5/16" x 1"  
8 each



(T)  
Washer 3/8"  
94 each



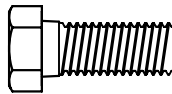
(S)  
Lockwasher 3/8"  
43 each



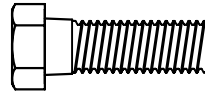
(Z)  
Aluminum Drive Rivet  
5/32" X 13/32"  
16 each



(U)  
Hex Nut 3/8  
43 each



(V)  
Hex Bolt 3/8"  
8 each



(R)  
Hex Bolt 3/8" x 1 1/4"  
35 each



(Q)  
Self Drilling Screw #8  
120 each