



1-800-527-7510

## **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' BLEACHER

## STEP 1 FRAME ASSEMBLY

1. Place the long Cross Braces 81 1/2" and medium Cross Braces 75 3/4" together- flat side to flat side, then bolt the center hole using Bolt (ITEM DD), Washers (ITEM Z), Lockwashers (ITEM AA) and Hex Nut (ITEM BB) (see figure 2).
2. Attach Cross Braces to Frames (ITEM C) as shown in Figures 1 & 2.
3. Check frame for squareness and tighten all nuts and bolts.

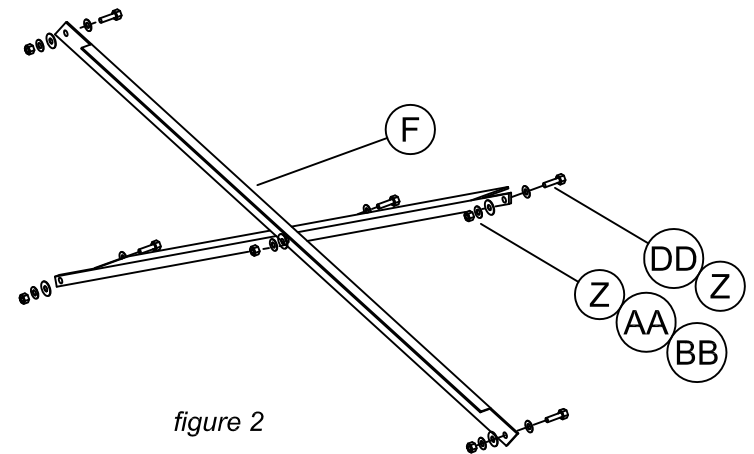


figure 2

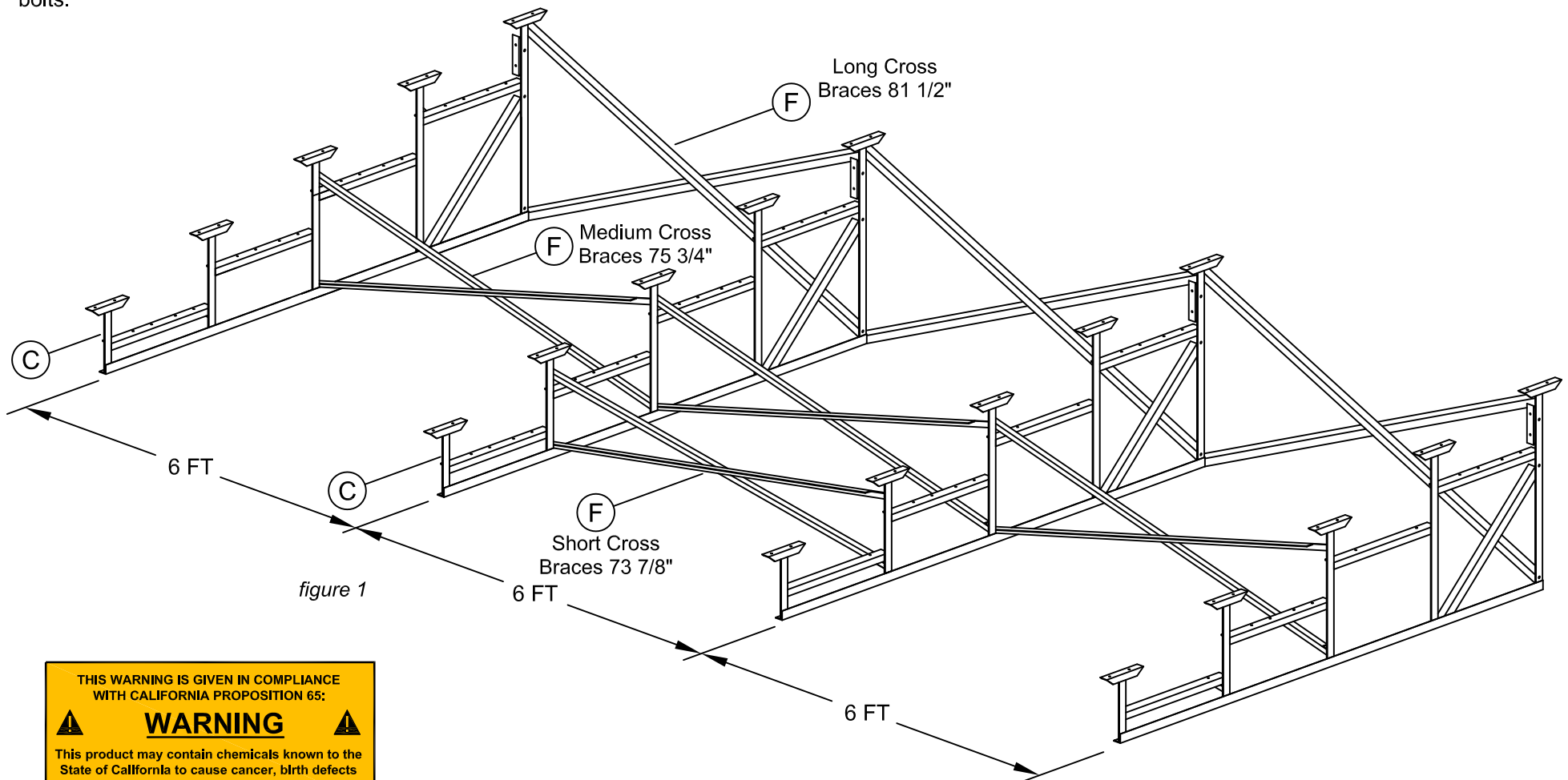


figure 1



# 5 ROW - 70 SEAT - 21' BLEACHER

## STEP #3

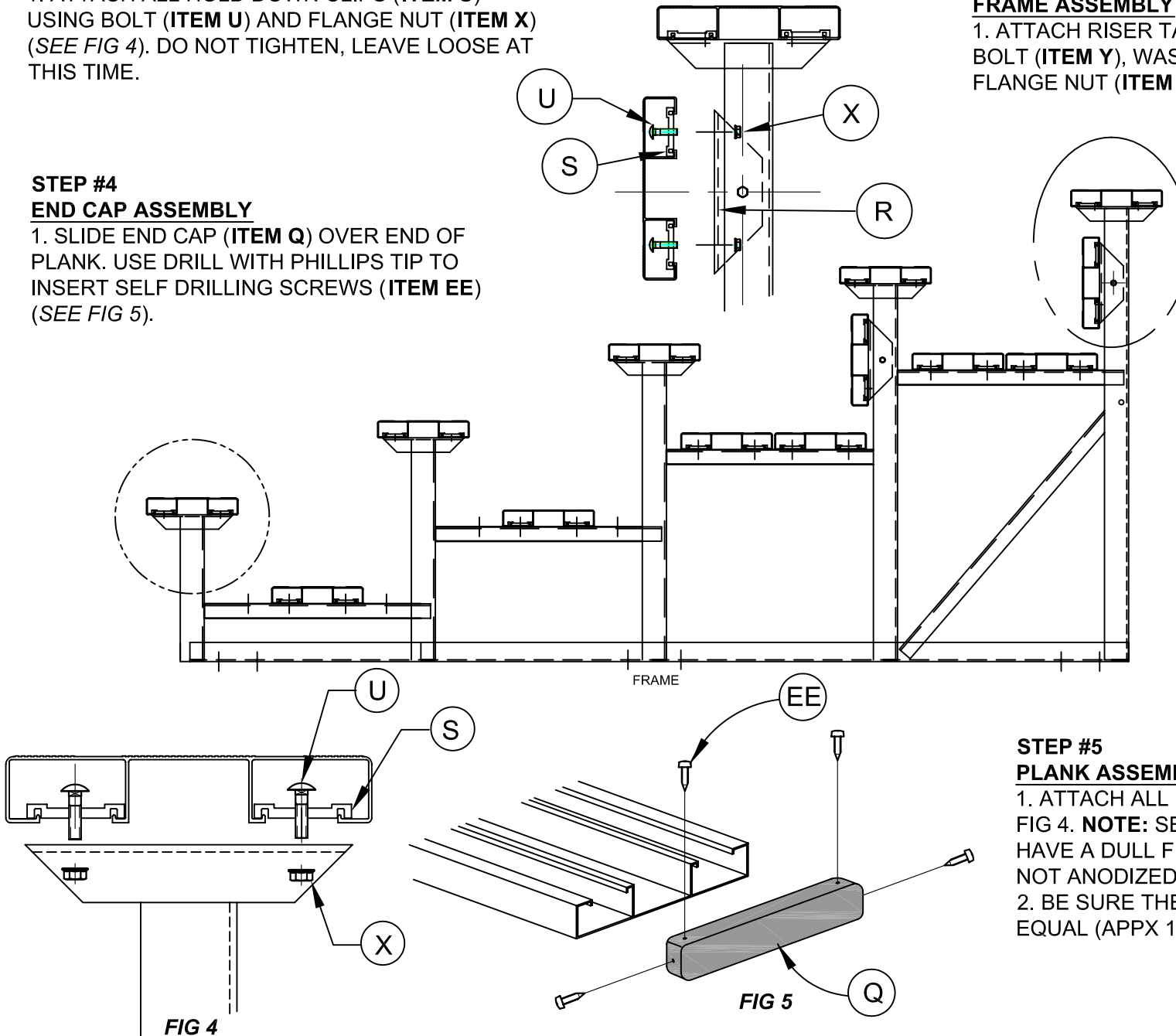
### PLANK ASSEMBLY

1. ATTACH ALL HOLD DOWN CLIPS (ITEM S) USING BOLT (ITEM U) AND FLANGE NUT (ITEM X) (SEE FIG 4). DO NOT TIGHTEN, LEAVE LOOSE AT THIS TIME.

## STEP #4

### END CAP ASSEMBLY

1. SLIDE END CAP (ITEM Q) OVER END OF PLANK. USE DRILL WITH PHILLIPS TIP TO INSERT SELF DRILLING SCREWS (ITEM EE) (SEE FIG 5).



## STEP #2

### FRAME ASSEMBLY

1. ATTACH RISER TABS (ITEM R) USING BOLT (ITEM Y), WASHER (ITEM W) AND FLANGE NUT (ITEM X) (SEE FIG 3).

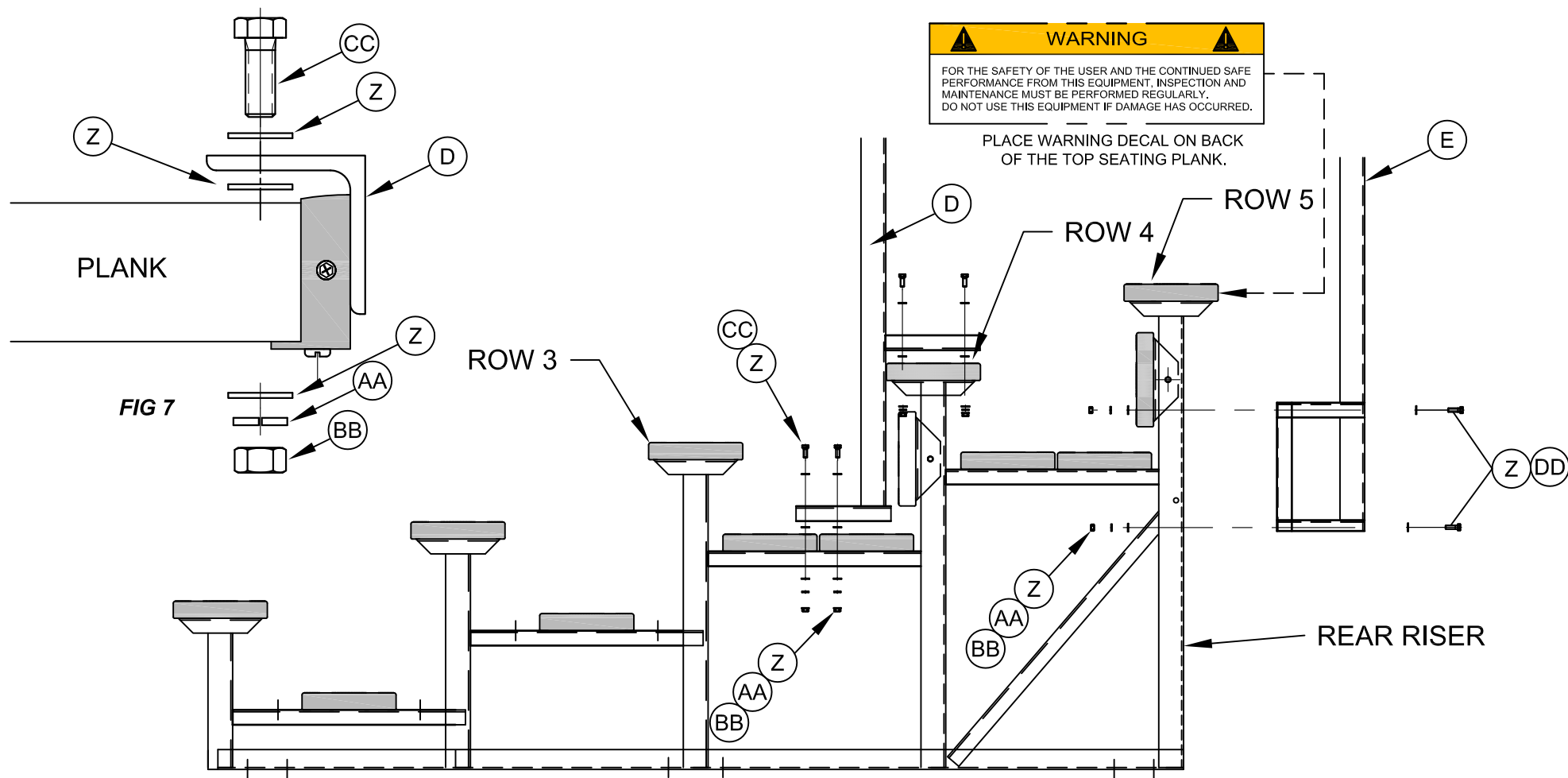
## STEP #5

### 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.

FIG 5

# 5 ROW - 70 SEAT - 21' BLEACHER



## STEP #6

### SIDE FENCE SUPPORT ASSEMBLY

1. **NOTE:** THERE IS A LEFT AND A RIGHT SIDE SUPPORT (ITEM D).
2. POSITION SIDE SUPPORTS (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 SUPPORT TO PLANKS AS SHOWN IN FIG 6 & 7. REPEAT ON OTHER SIDE OF BLEACHER.

FIG 6

## STEP #7

### BACK FENCE SUPPORT ASSEMBLY

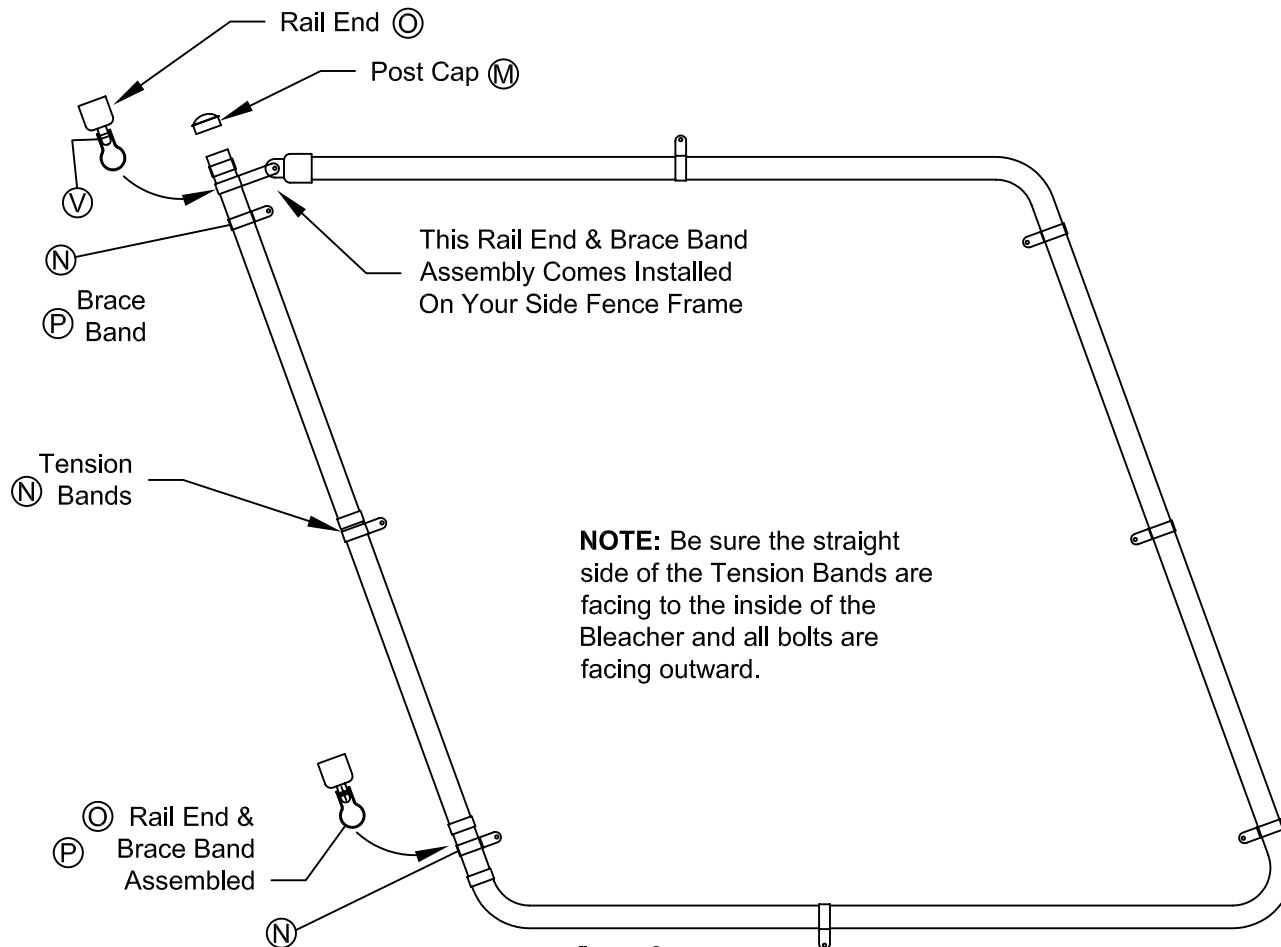
1. BOLT THE BACK SUPPORT (ITEM E) TO EACH REAR RISER AS SHOWN IN FIG.-6.

## 5 ROW - 70 SEAT - 21' BLEACHER

### STEP #8

#### SIDE FENCE ASSEMBLY

1. REFER TO FIG-8 AND INSTALL 11 TENSION BANDS (**ITEM N**) AND 2 BRACE BANDS (**ITEM P**) ATTACH THESE TO 2 RAIL ENDS (**ITEM O**) USING HARDWARE (**ITEM V**) AS SHOWN. **NOTE:** KEEP THE STRAIGHT SIDE OF THE TENSION BANDS-N ALL ON THE SAME SIDE OF THE FENCE FRAME. REPEAT ON THE SECOND SIDE FENCE FRAME REVERSING THE TENSION BANDS.
2. UNROLL THE 12 FOOT ROLL OF FENCE MATERIAL (**ITEM J**). MEASURE 6 FEET AND UNBEND TOP & BOTTOM OF A SINGLE WIRE TO BE REMOVED. IN A CIRCULAR MOTION REMOVE THIS SINGLE WIRE TO CREATE 2 - 6 FOOT PIECES OF FENCE SEE FIG 9.



3. NOW ON A FLAT SURFACE, PLACE ONE OF THE 6' SECTIONS OF FENCE MATERIAL OVER THE FENCE FRAME AS SHOWN IN FIG-10.
4. INSERT A TENSION BAR (**ITEM K**) INTO THE CHAIN LINK BY WEAVING IT THROUGH THE FENCE PARALLEL TO THE FRAME TUBE. PLACE TENSION BAR (**ITEM K**) SO THAT YOU WILL HAVE APPX 3/4" WHEN YOU CUT OFF EXCESS MATERIAL. REPEAT PROCEDURE ON OPPOSITE SIDE OF FENCE FRAME (SEE FIG.-10).
5. USING BOLT CUTTERS CUT FENCE OUTSIDE OF TENSION BARS; CUT EVERY OTHER WIRE AND BEND EXPOSED WIRE AROUND TENSION BAR (SEE FIG-11).

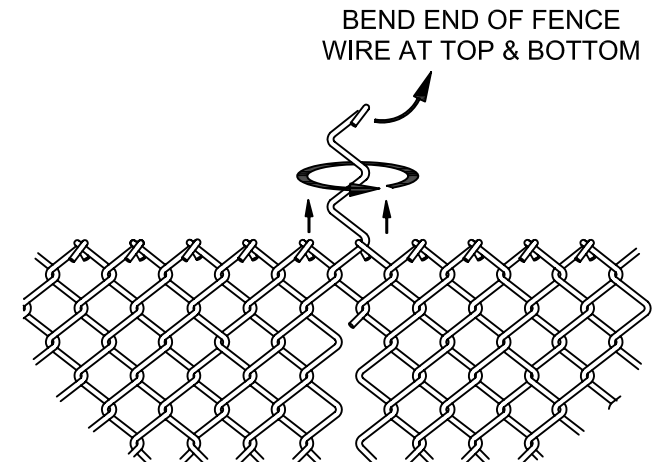


figure 8

## 5 ROW - 70 SEAT - 21' BLEACHER

### STEP #8 SIDE FENCE ASSEMBLY

6. With Tension Bar in place attach Tension Bands (**ITEM N**) to Tension Bars using Bolt and Nut (**ITEM V**) (see *Figure 12*).
7. Secure Fence material to top and bottom of Fence Frame using Aluminum Tie Wires (**ITEM T**) (see *Figure 12*).
8. Repeat Step #8 (3 thru 7) on the second Side Frame.

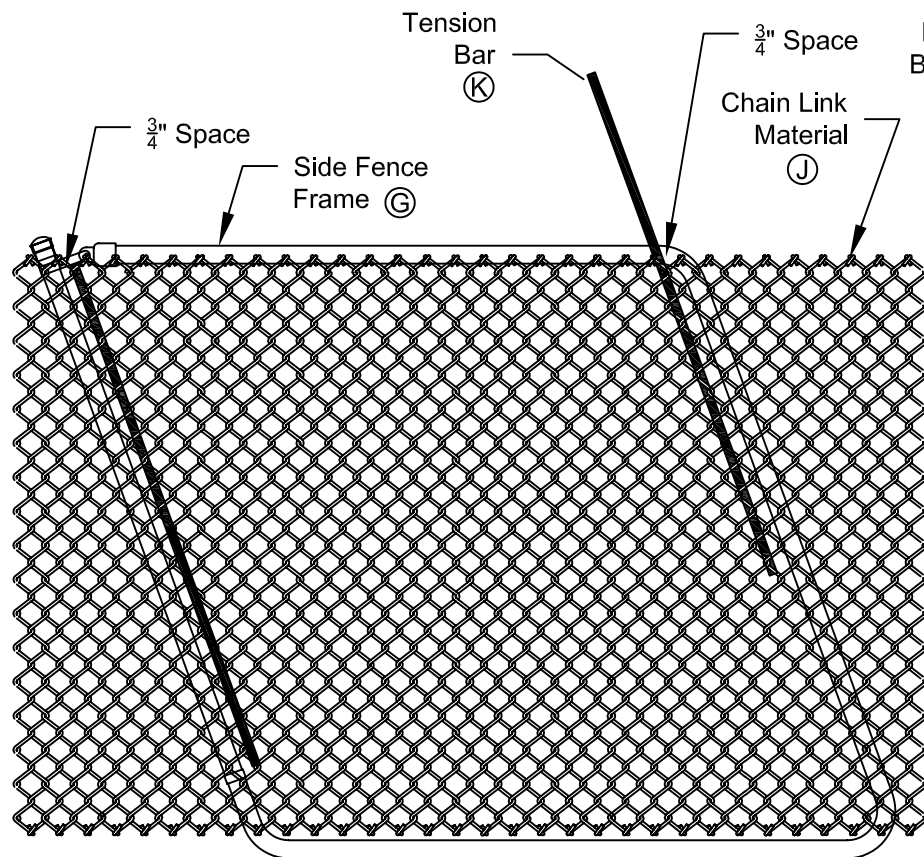


figure 10

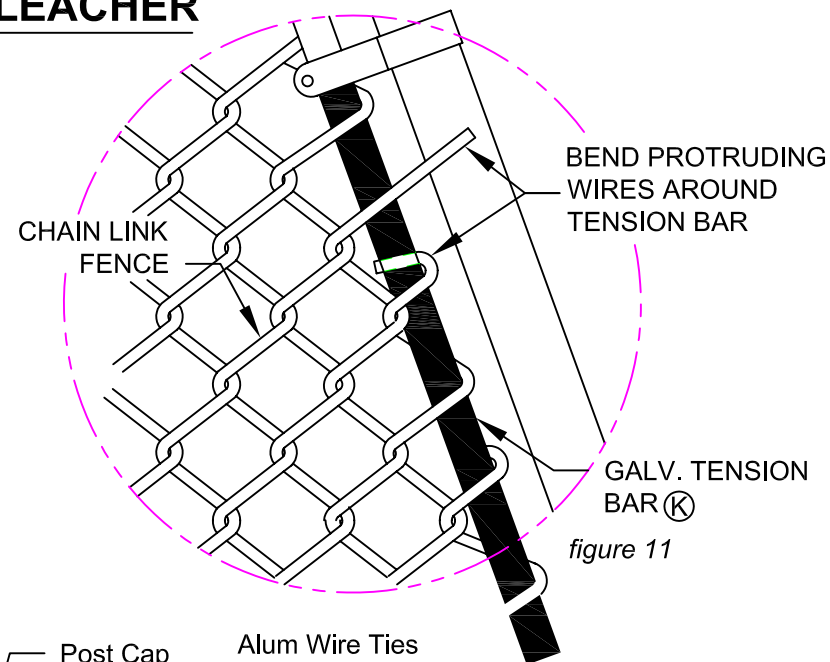


figure 11

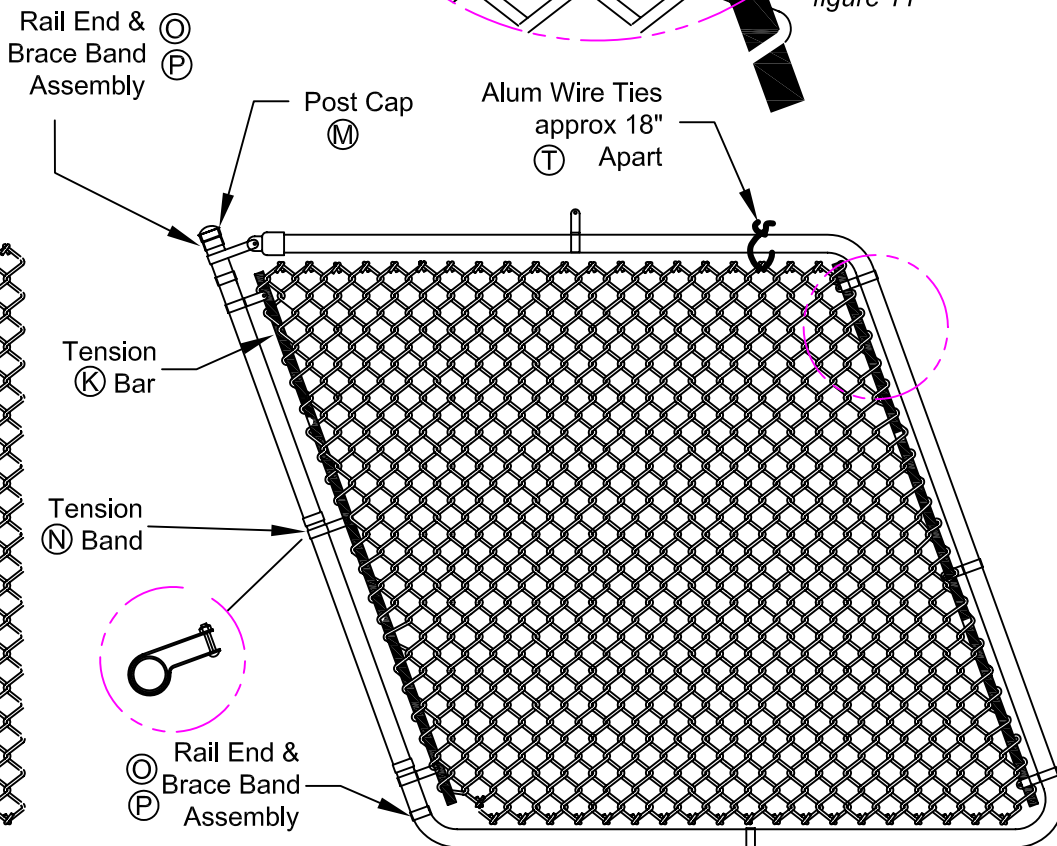


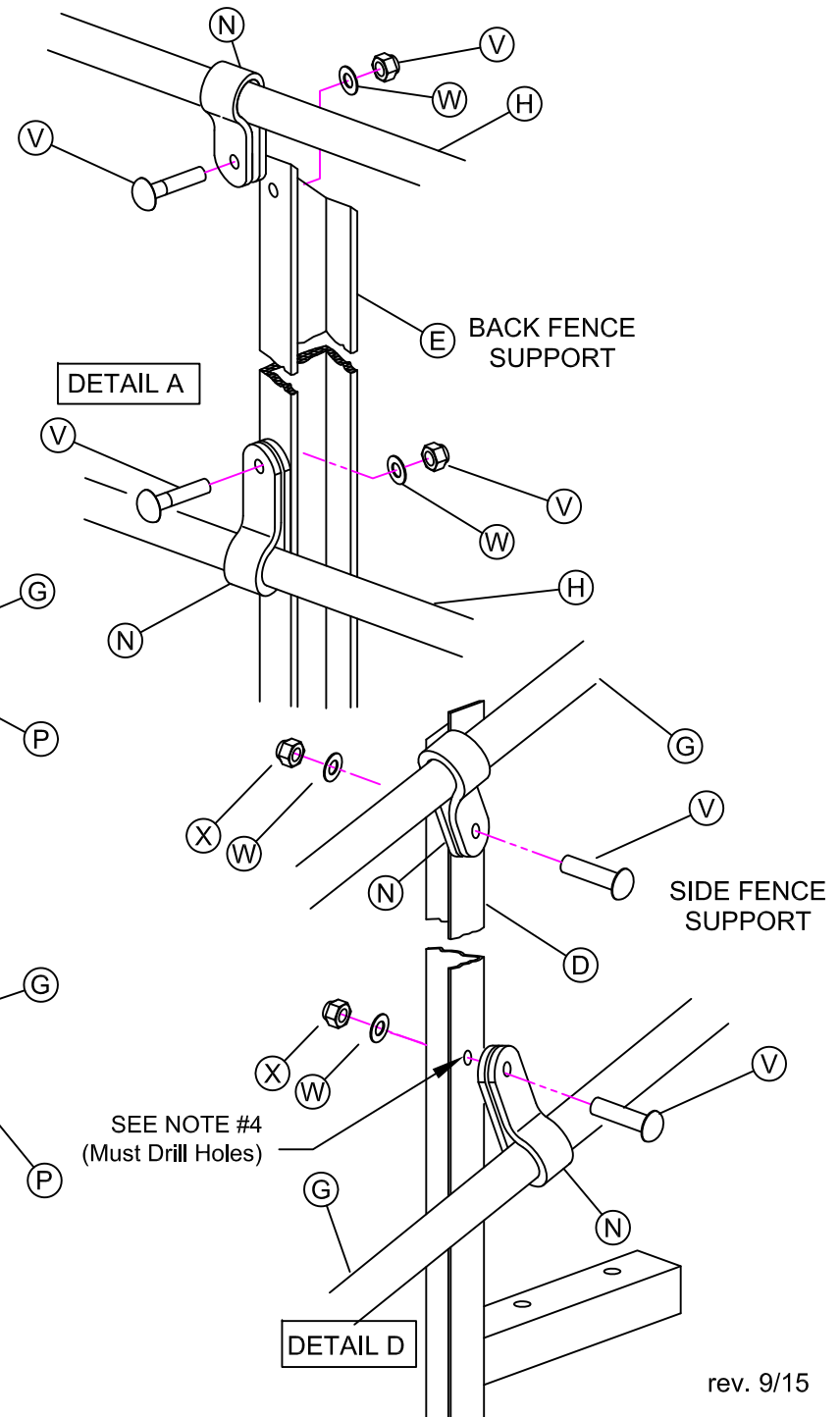
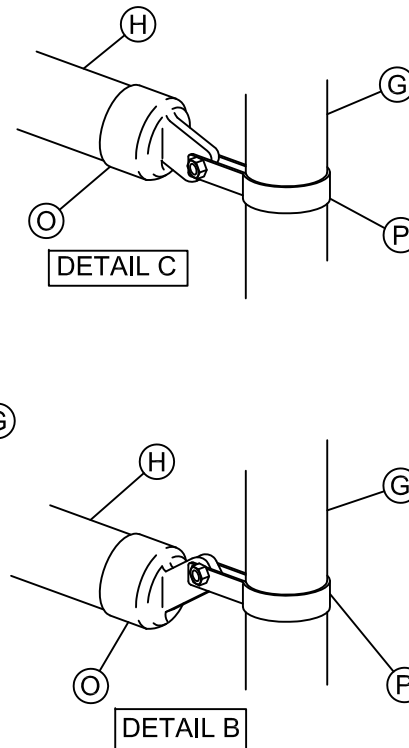
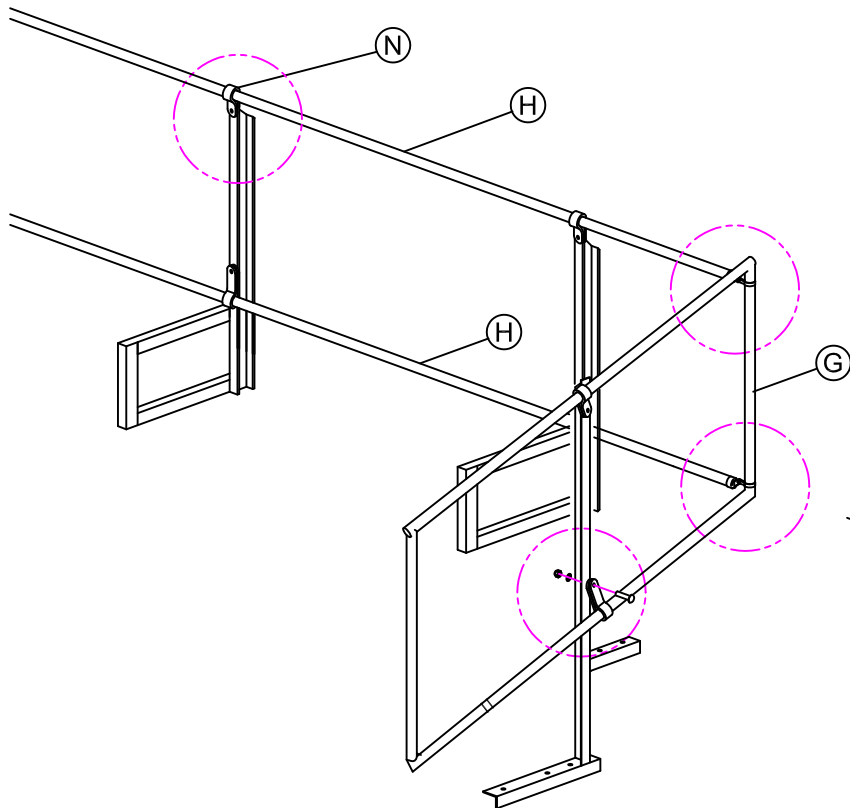
figure 12

# 5 ROW- 70 SEAT- 21' BLEACHER

## STEP #9

### BACK GUARD RAIL & SIDE FENCE PANEL INSTALLATION

1. Slide 4 Tension Bands (**ITEM N**) on each of the Guard Rail Tubes (**ITEM H**).
2. Bolt Tension Bands (**ITEM N**) to the Back Fence Supports (see *Detail A*).  
**Do Not Tighten At This Time**
3. Place the Side Fence Panels in place on the outside of supports and insert Guard Rail Tubes (**ITEM H**) into Rail Ends (**ITEM O**) (see *Details B & C*).
4. Square up 2 Tension Bands (**ITEM N**) with Side Fence Support and mark hole placement. Drill  $\frac{3}{8}$ " Dia. hole in Support and attach Tension Bands (see *Detail D*).



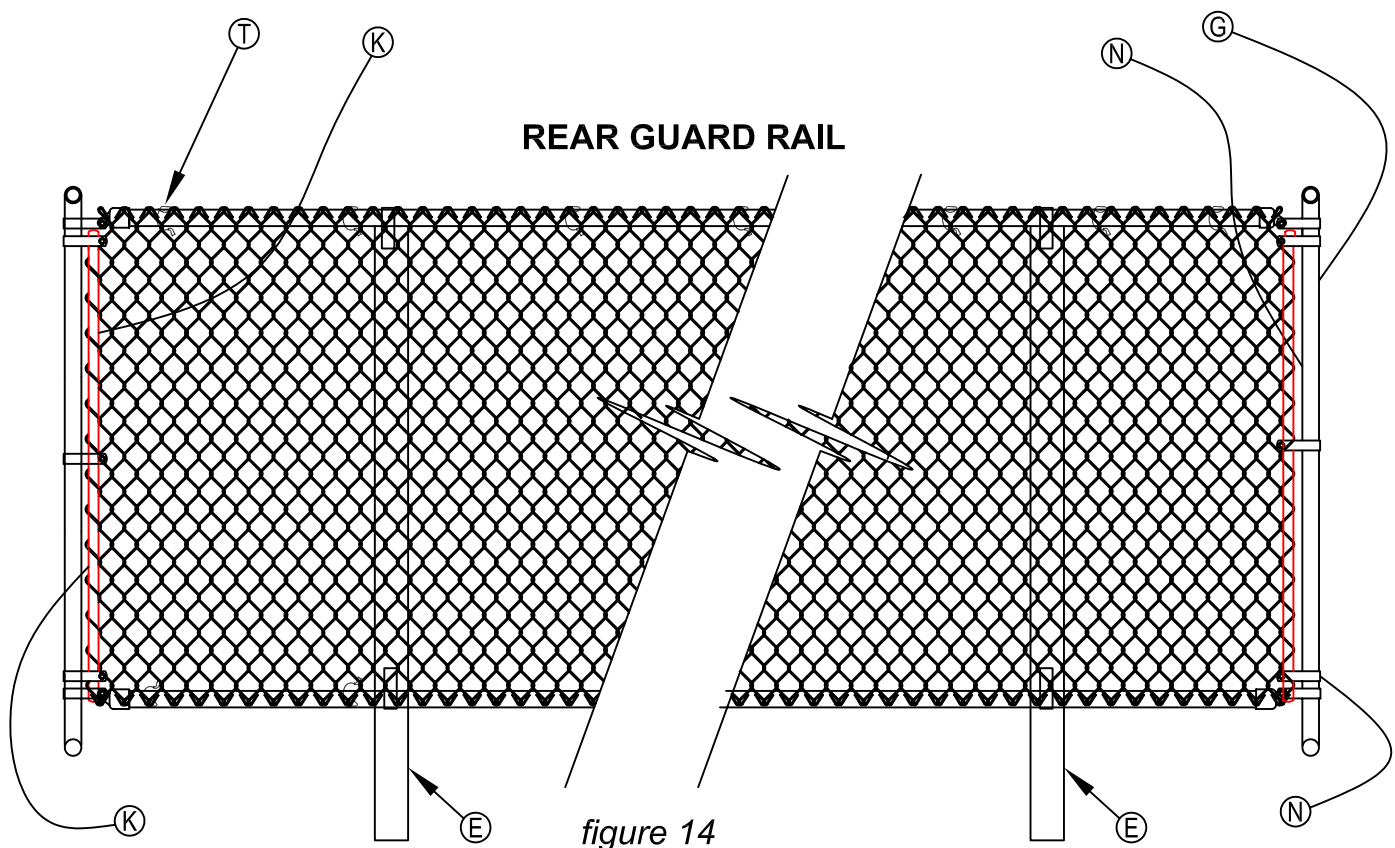


# 5 ROW - 70 SEAT - 21' BLEACHER

## **STEP #10**

### **INSTALLING REAR GUARD RAIL WIRE**

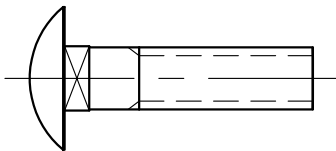
1. Unroll the 42" width roll of wire. The length of the wire will be longer than you need and will need to be shortened. Do not shorten until one end is attached and you know exactly where to shorten.
2. Weave the Tension Bar through one end. Now bolt in place on one end of the Side Panel using 3 Tension Bands (**ITEM N**), and Bolt w/Nut (**ITEM V**). Be sure bolts are facing away from the seating area.
3. With one end now bolted, stretch the wire to the other end. Determine where the Tension Bar needs to be placed and weave it through the wire.
4. Unbend the top and bottom of a single wire in a circular motion remove the wire to obtain proper length.
5. Stretch the wire and bolt this end using the Tension Bands and fasteners as on the other end.
6. Tie the top and bottom of the wire to the guard rail tubes using the aluminum Wire Ties (**ITEM T**) spaced approximately 18" apart.



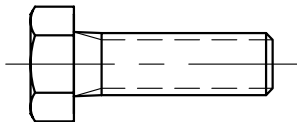


# 5 ROW - 70 SEAT - 21' BLEACHER **PARTS LIST**

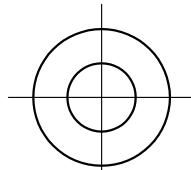
ITEM	DESCRIPTION	QTY	ITEM	DESCRIPTION	QTY
A	21' ANODIZED SEAT PLANK	5 EA	L	HARDWARE PACK	1 EA
B	21' MILL FINISH FOOT PLANK	8 EA		(HARDWARE PACK CONTENTS)	
C	5 ROW BLEACHER FRAME	4 EA	M	STEEL POST CAP	2 EA
D	SIDE FENCE SUPPORTS L & R	1 PR	N	TENSION BANDS 1 5/8"	30 EA
E	BACK FENCE SUPPORTS	4 EA	O	RAIL ENDS 1 5/8"	4 EA
F	X BRACES (14 pcs)	1 SET	P	BRACE BANDS 1 5/8"	4 EA
G	SIDE FENCE FRAME	1 SET	Q	PLANK END CAPS	26 EA
H	BACK GUARD RAIL TUBES 21'	1 PR	R	RISER TABS	8 EA
I	CHAINLINK FENCE 42" x 25'	1 ROLL	S	BOLT CLIPS	104 EA
J	CHAINLINK FENCE 48" x 12'	1 ROLL	T	ALUM WIRE TIES	100 EA
K	TENSION BARS	6 EA	U	CARRIAGE BOLT 5/16" x 1 1/4" ZINC	104 EA
	(2 each Short & 4 each Long)		V	CARRIAGE BOLT 5/16" X 1 1/4" w/NUT GALV	34 EA
			W	WASHER 5/16"	20 EA
			X	LOCKING FLANGE NUT	112 EA
			Y	HEX BOLT 5/16" x 1"	8 EA
			Z	WASHER 3/8"	94 EA
			AA	LOCK WASHER 3/8"	43 EA
			BB	HEX NUT 3/8"	43 EA
			CC	HEX BOLT 3/8" x 1"	8 EA
			DD	HEX BOLT 3/8" x 1 1/4"	35 EA
			EE	SELF DRILLING SCREW #8	104 EA



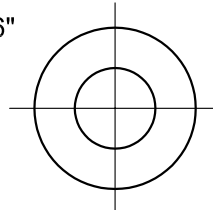
(U)  
Carriage Bolt  
5/16" x 1 1/4"  
104 each



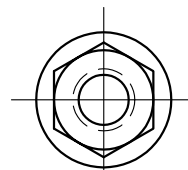
(Y)  
Hex Bolt 5/16" x 1"  
8 each



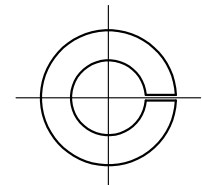
(W)  
Washer 5/16"  
20 each



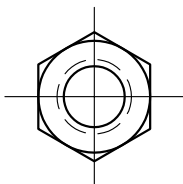
(Z)  
Washer 3/8"  
94 each



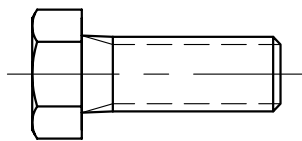
(X)  
Flange Nut  
112 each



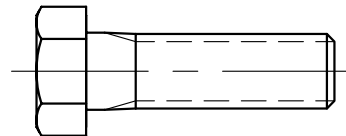
(AA)  
Lockwasher 3/8"  
43 each



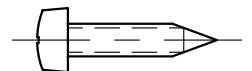
(BB)  
Hex Nut 3/8"  
43 each



(CC)  
Hex Bolt 3/8"  
8 each



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



(EE)  
Self Drilling Screw #8  
104 each