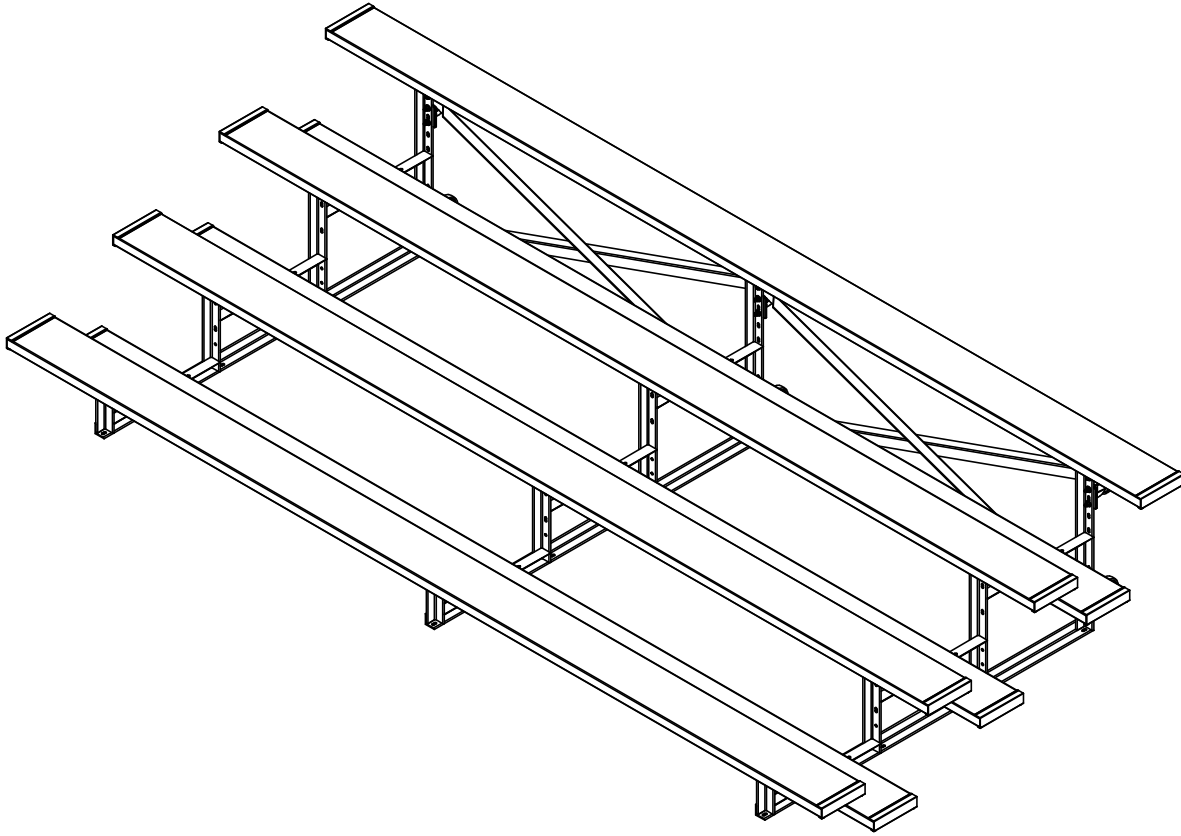


STANDARD 4-ROW 15' BLEACHER

MODEL 1171-415TRG 4-ROW 15' STEEL
MODEL 1171-415TRA 4-ROW 15' ALUMINUM

Standard Series designed for dependability and trouble-free maintenance. Featuring 8" rise from row to row with nominal 10" aluminum planks and optional 2" x 6" ground sills



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.

Standard Series Bleachers conform to the requirements of ICC 300-2012.

Seat and Foot Planks: Nominal 2" x 10" x 15' extruded, ribbed aluminum. The edges and tops of planks shall be ribbed. The ribbed pattern, non-slip surface, is designed for safety and comfort. 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 the plank against movement under a horizontal force of 400 lbs. All hardware is provided.

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



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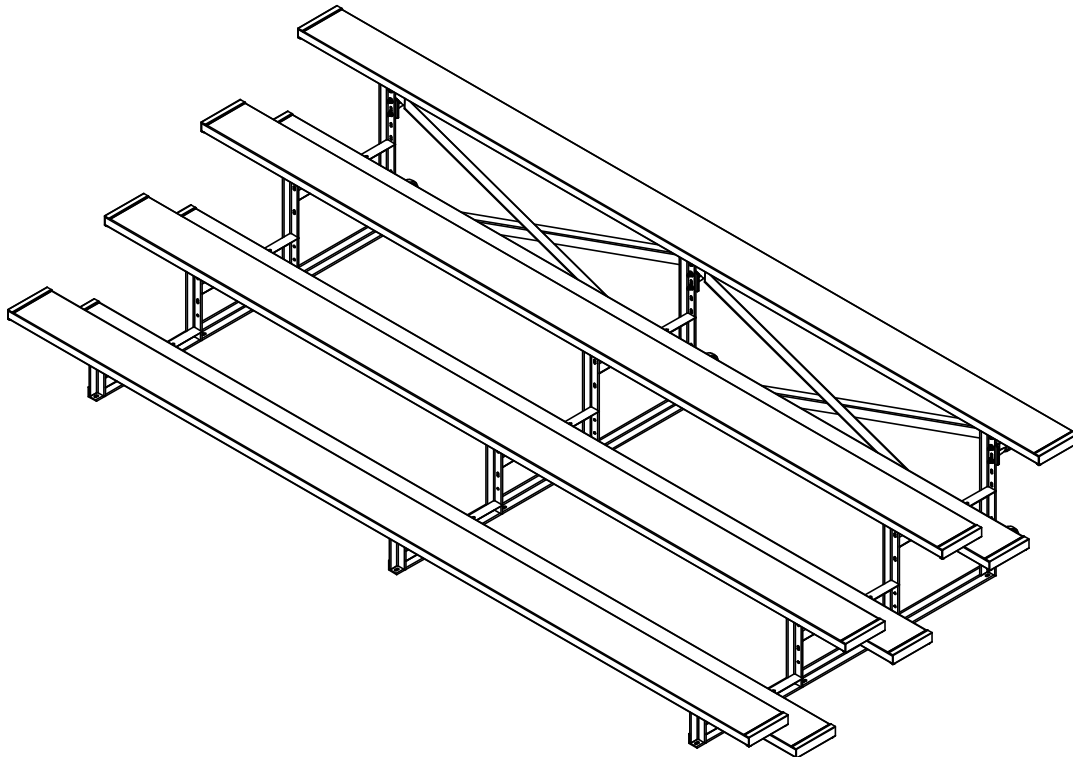
4 ROW STANDARD 15FT

MODEL NO.

1171-415TRA & TRG

BOM PARTS & FASTENERS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	ASA-500-1171-415,421,427-A	BLEACHER 4-ROW STANDARD FRAME	3
2	L-0018-1171-1004-79.5-A	STANDARD BLEACHER BRACE 4TH ROW	4
3	PL-1100-180-10-A-A	ALUMINUM PLANK ANODIZED 10"X 180"	4
4	PL-1100-180-10-A-M	ALUMINUM PLANK MILLED 10"X 180"	3
5	VCIAECP	2"X10" ALUM. END CAP	14
6	VCIACL P	BOLT CLIP FOR 10" & 12" ALUMINUM PLANK	42
7	HWCB5161	5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC	42
8	HWLN516	5/16 NYLOK NUT ZINC	42
9	HWFLWA516	5/16" FLAT WASHER	42
10	HWHB38114	3/8-16 X 1 1/4 GR5 C/S ZINC HEX BOLT (1000)	8
11	HWFLWA38	3/8" Flat Washer	40
12	HWLN38	3/8"-16 LOCK NUT	20
13	HWTEX1034	#10 X 5/8 SELF TAPPING SCREW	28
14	VCITIPNROLLBRAKE	5" X 1" RUBBER SWIVEL CASTER WHEEL LOCKING	2
15	VCITIPNROLLSWIVEL	5" X 1" RUBBER SWIVEL CASTER WHEEL	4
16	VCITIPNROLLPLATE	TIP N ROLL MOUNTING PLATE	6
17	HWBH38112	3/8 X 1-1/2 BUTTON HEAD SOCKET CAP SCREW SS 18.8	12



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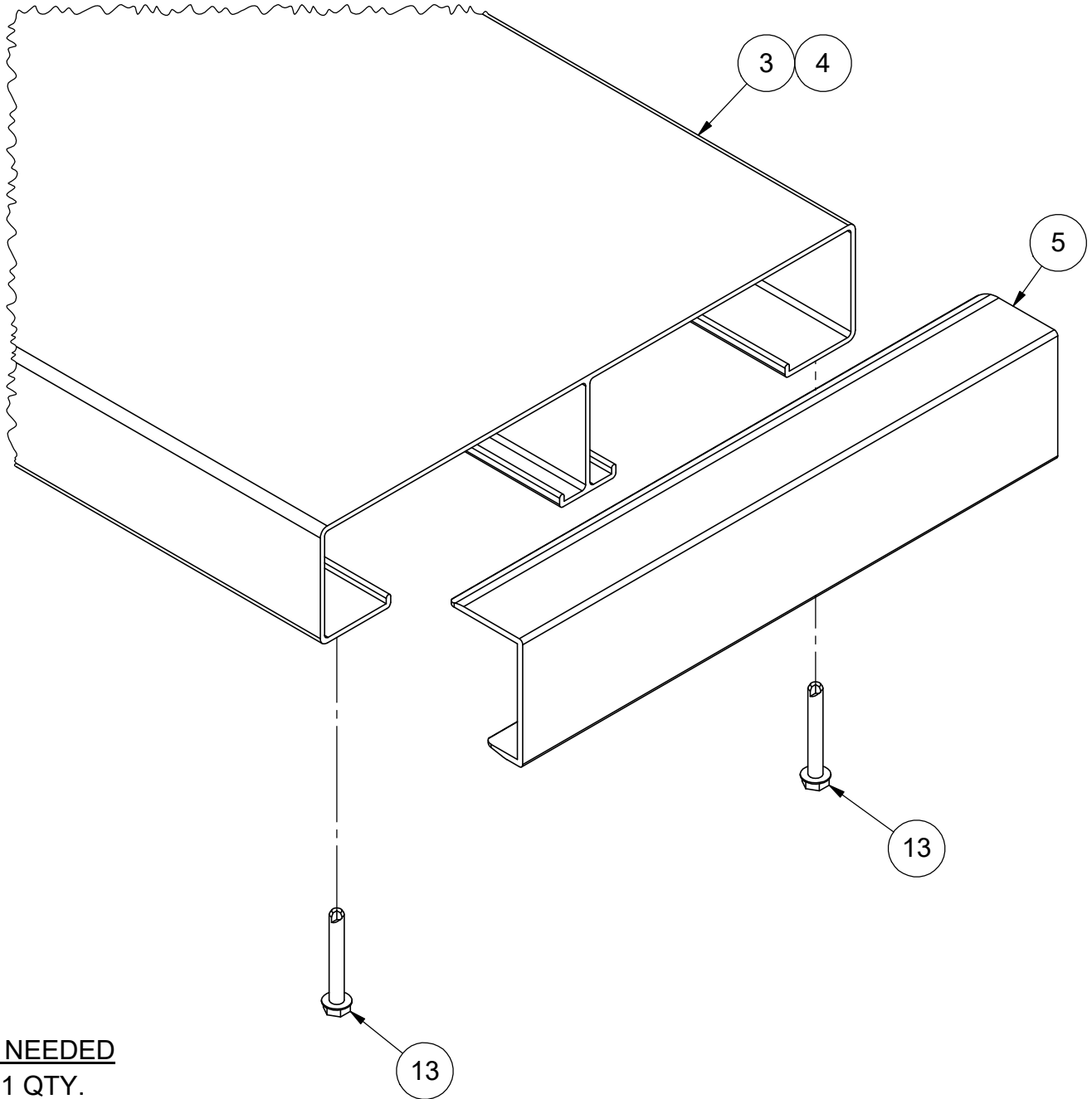
MODEL NO.

1171-415TRA & TRG

INSTALLATION INSTRUCTIONS:

1) Check materials received with the BOM to make sure that all components are included and to assure that the unit is complete.

2) Installing End Caps Item on Seat and Foot Planks: 2" x 10" end caps Item (5) . Align and assemble all end caps to aluminum planks. Secure using #10 x 3/4" Item (13) self-tapping screw in two locations on the underside of the clip/plank.



FASTNERS NEEDED
ITEM (13) 21 QTY.



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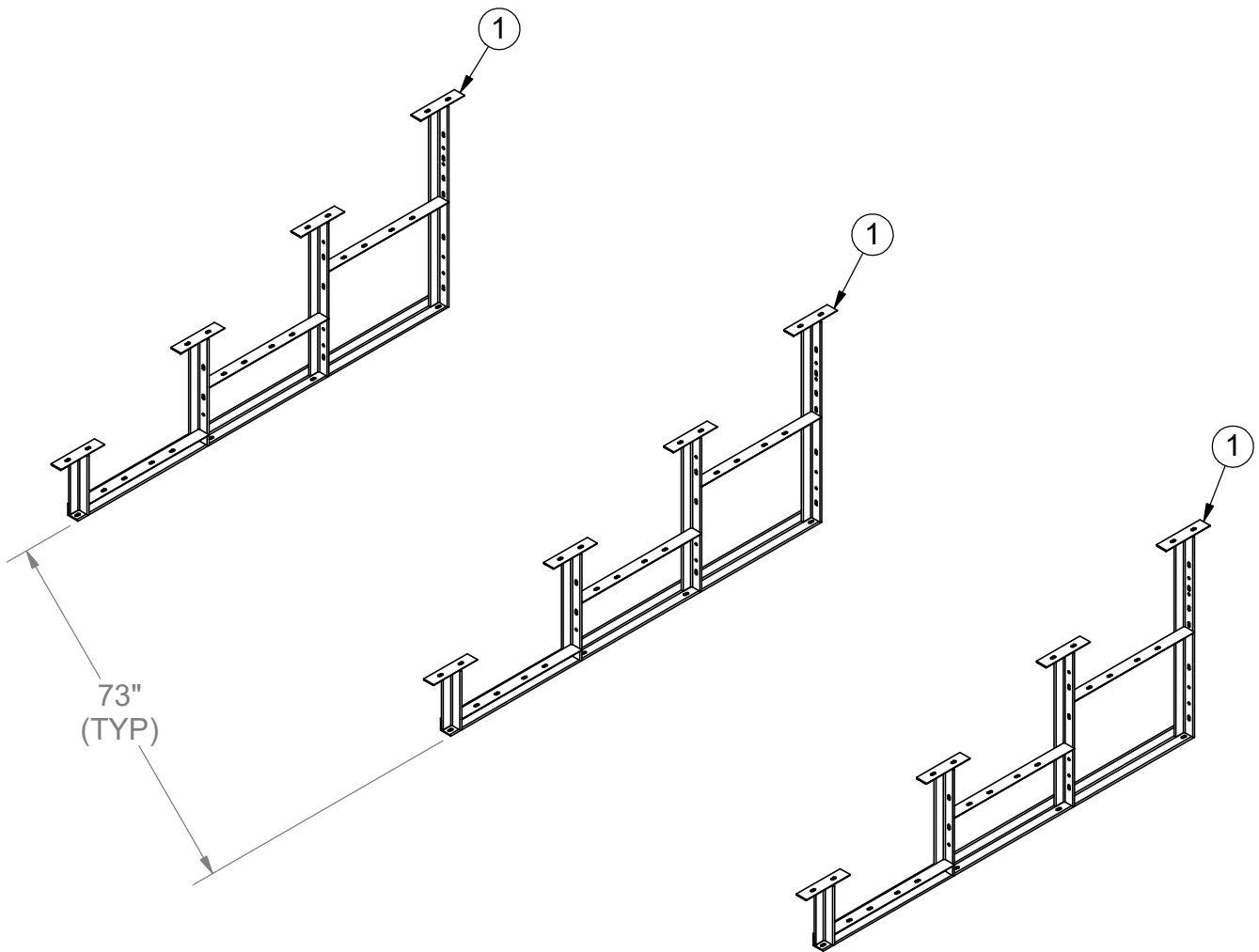
4 ROW STANDARD 15FT

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INSTALLATION INSTRUCTIONS:

3) Locate the three Bleacher 3-Row Standard Frame Item ① and set on a level surface on 73" centers.



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PRODUCT NAME

4 ROW STANDARD 15FT

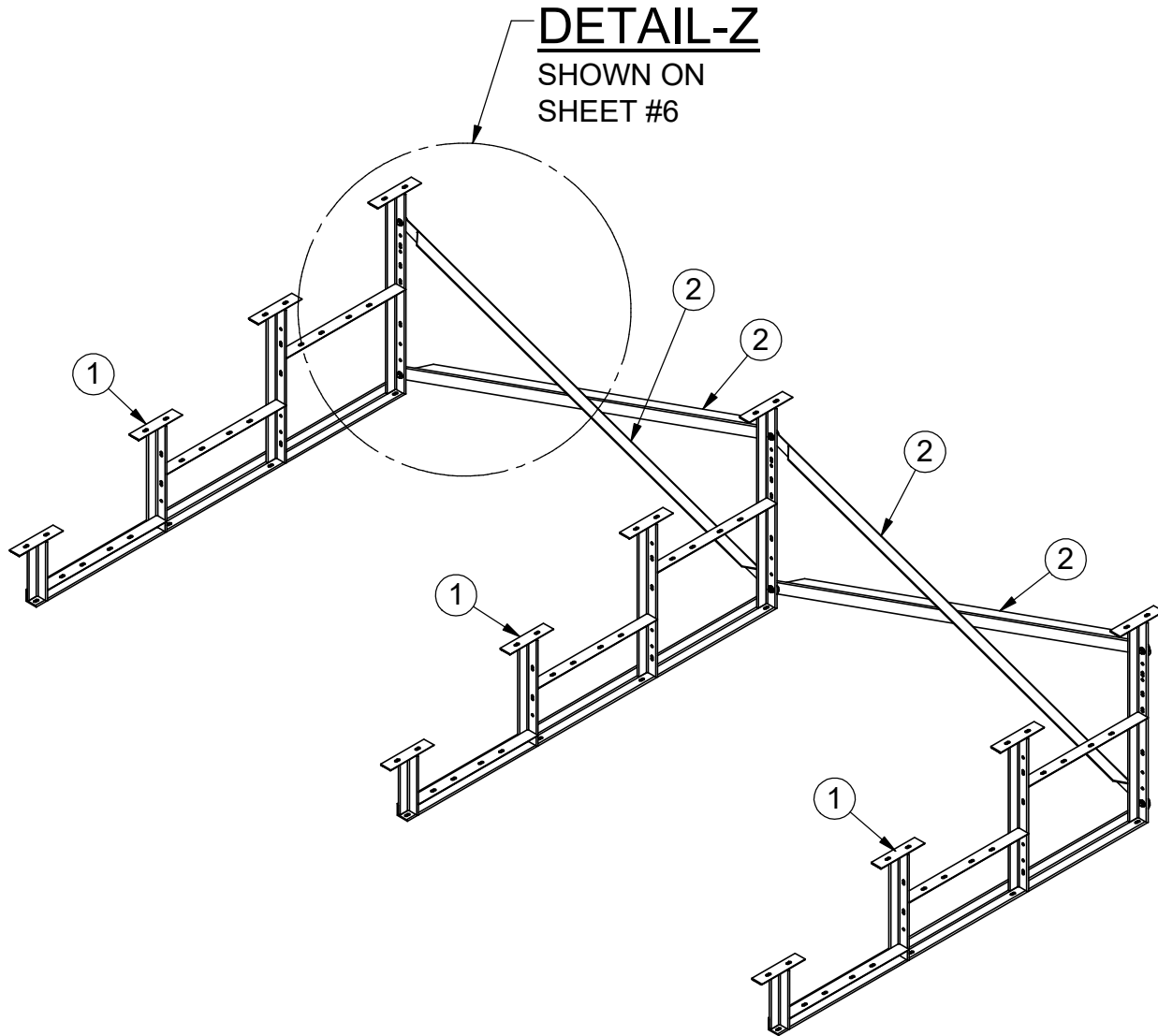
MODEL NO.

1171-415TRA & TRG

INSTALLATION INSTRUCTIONS:

4) To Install Cross Braces: a) Locate two sets of diagonal braces measuring 2" x 2" x 79.5" Item (2) . Install on the backside of the Bleacher Frames using 3/8" x 1-1/4" Hex Bolt Item (10) , Washers Item (11) , and Lock Nut Item (12) provided using the top and bottom slots in the frame and center of Braces as shown. Repeat steps to assemble remaining sets of cross braces to the other bleacher frames. 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.



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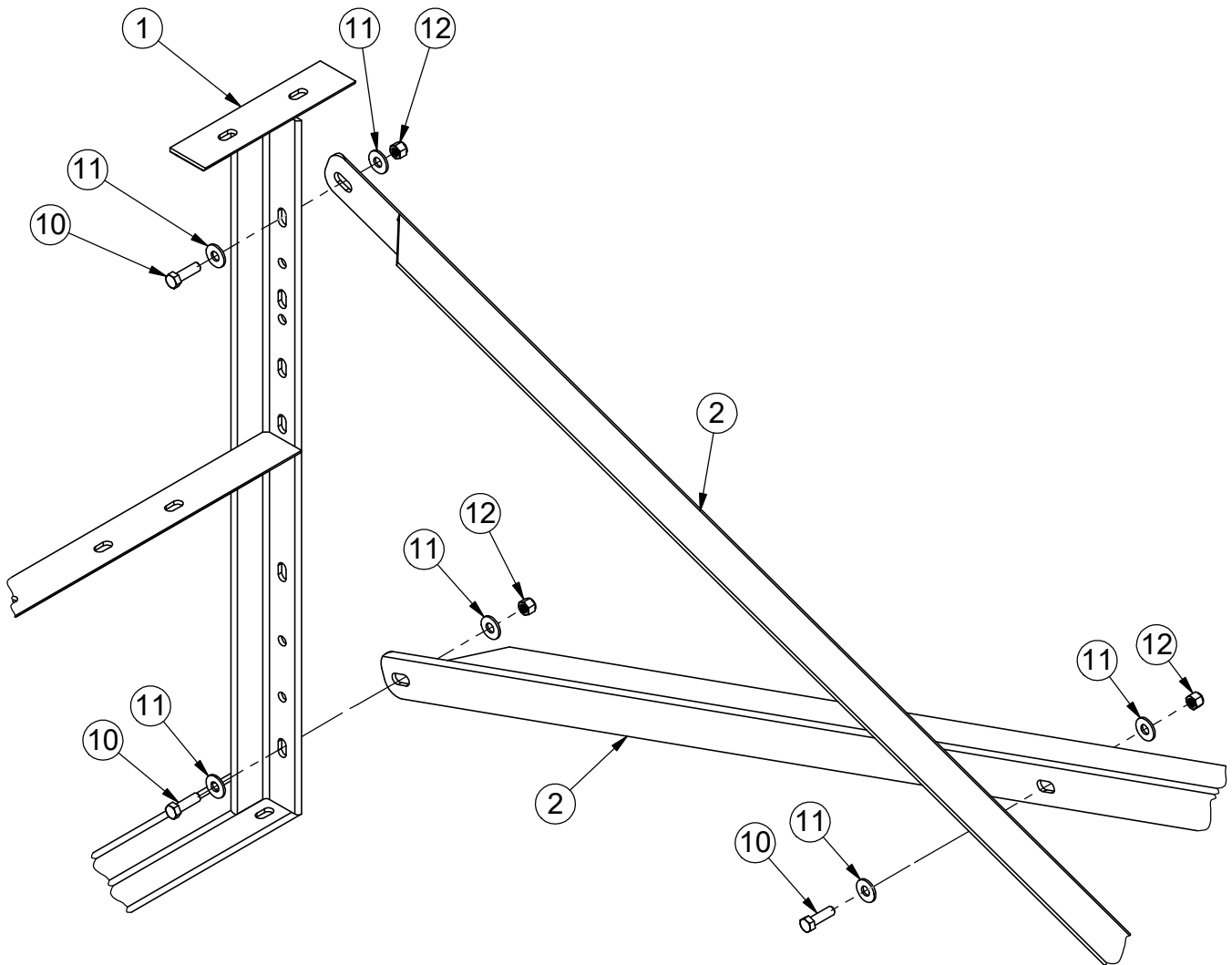
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PRODUCT NAME

4 ROW STANDARD 15FT

MODEL NO.

1171-415TRA & TRG



DETAIL-Z
 ENLAGED
 FROM SHEET #5



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PRODUCT NAME

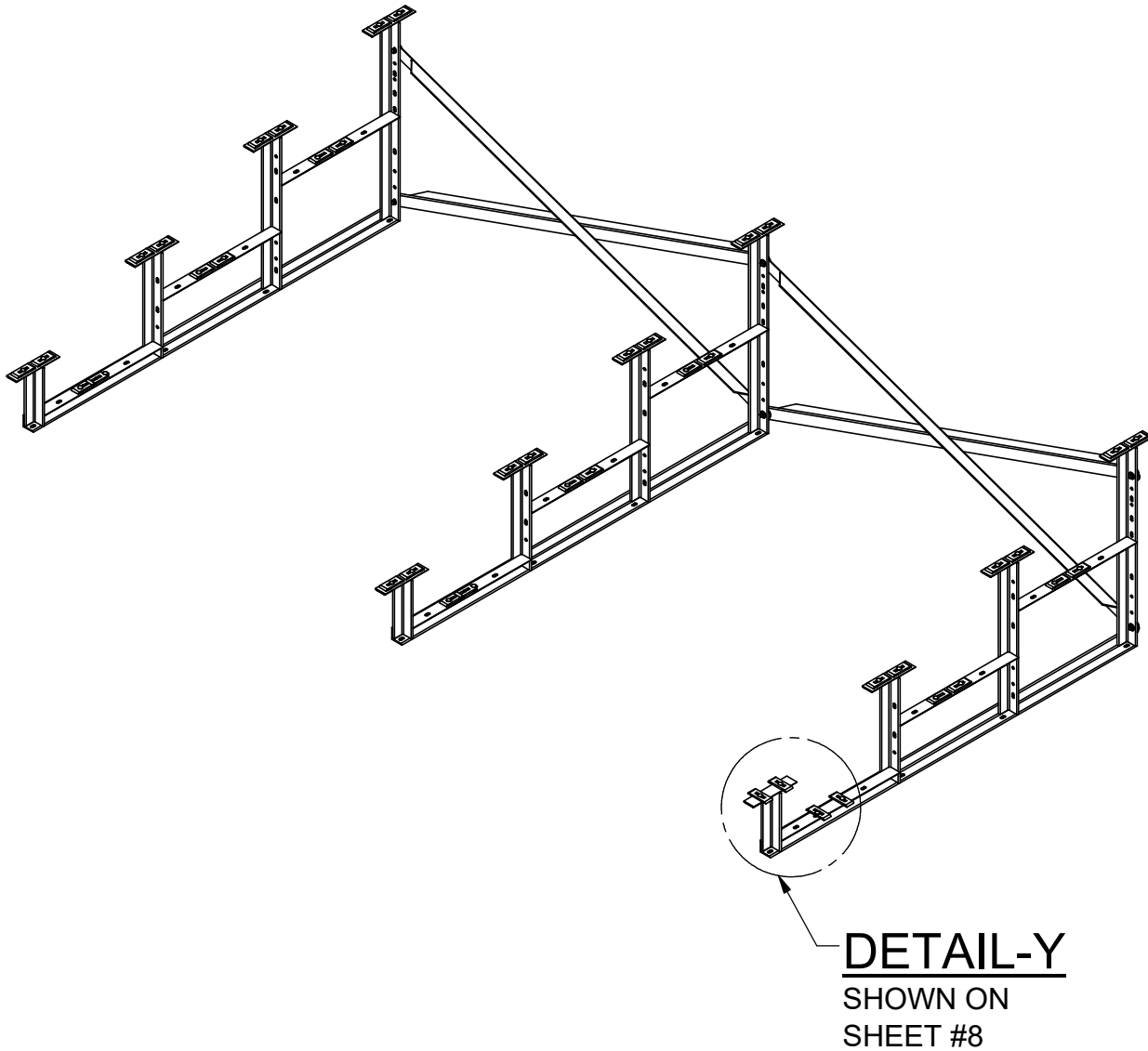
4 ROW STANDARD 15FT

MODEL NO.

1171-415TRA & TRG

INSTALLATION INSTRUCTIONS:

5) To Install Seat and Foot Planks: a) First install the Bolt Clip For 10" & 12" Aluminum Plank Item (6) using 5/16" x 1" carriage bolts Item (7), washer Item (9), and lock nuts (8) on top of the seat and foot board supports. Give nuts about 3/4 turn (just enough to secure). Turn Bolt Clips Item (6) perpendicular to the frames.



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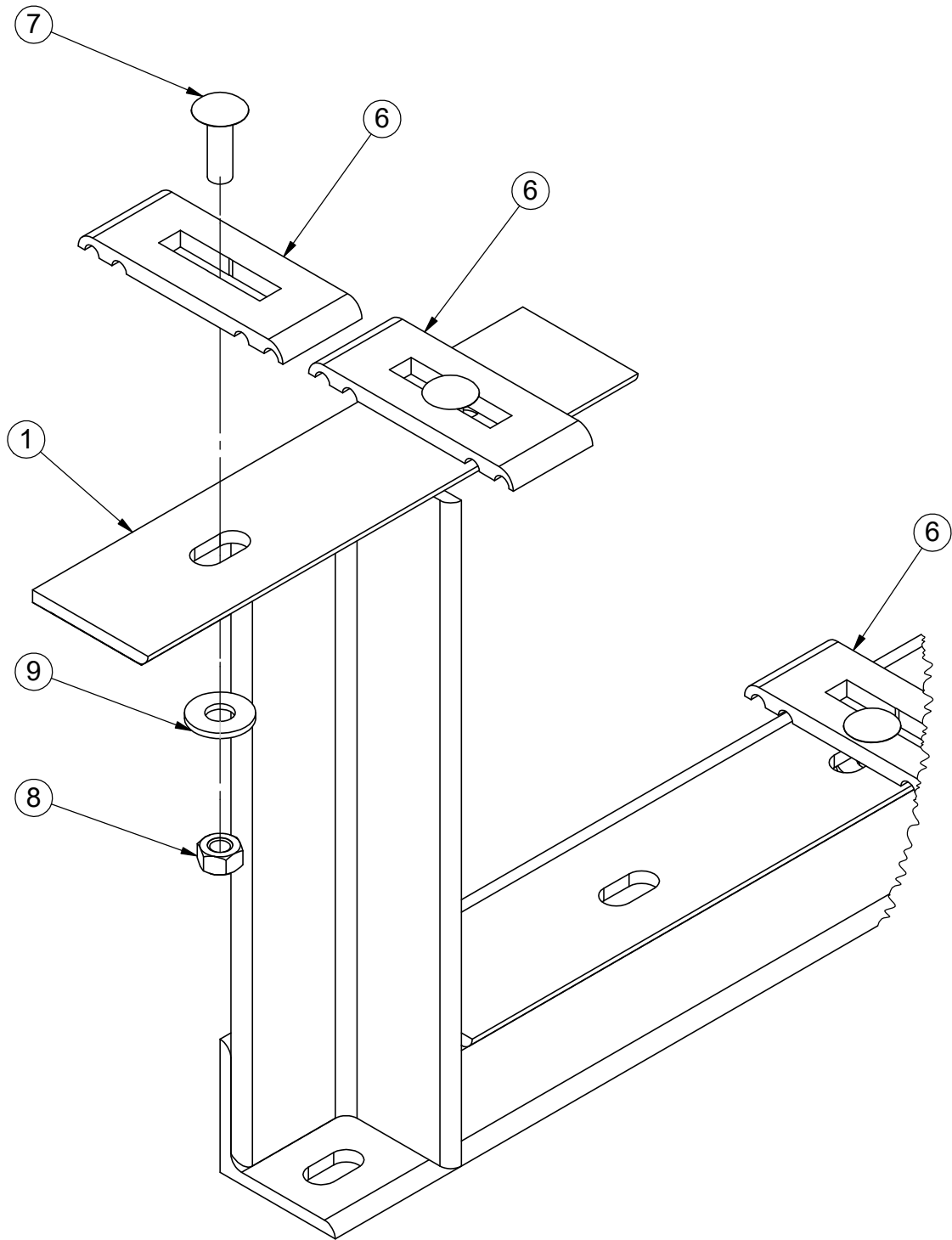
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PRODUCT NAME

4 ROW STANDARD 15FT

MODEL NO.

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DETAIL-Y
 ENLARGED
 FROM SHEET #7



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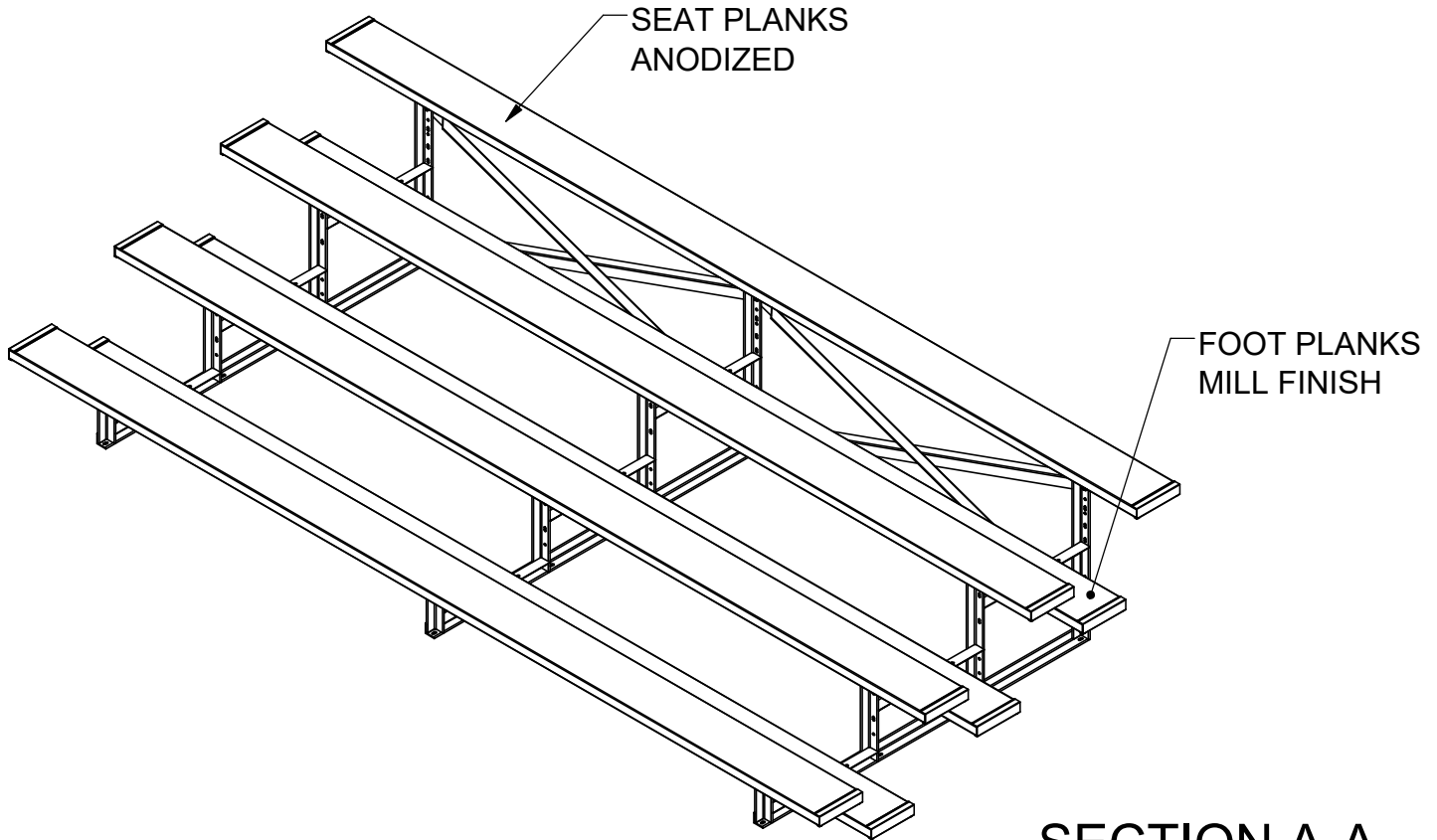
4 ROW STANDARD 15FT

MODEL NO.

1171-415TRA & TRG

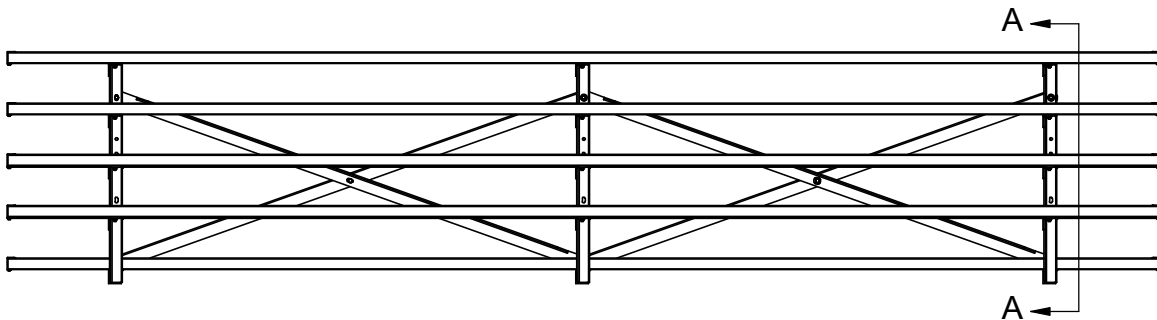
INSTALLATION INSTRUCTIONS:

6) Position seat Planks and Foot Planks on the supports so the Bolt Clips Item ⑥ are between the slots in the bottom of Planks. Reach up underneath the Seat Plank, Foot Plank, and Riser Plank to rotate the Bolt Clips Item ⑥ to 90° so they engage the planks. To Secure Planks to Frames: a) Align the end of the planks on rows so they are approximately 16" from outside edge of plank to center Seat frame Item ① . Tighten all hardware on frames and planks securely.



SECTION A-A

SHOWN ON
SHEET #10



FRONT VIEW



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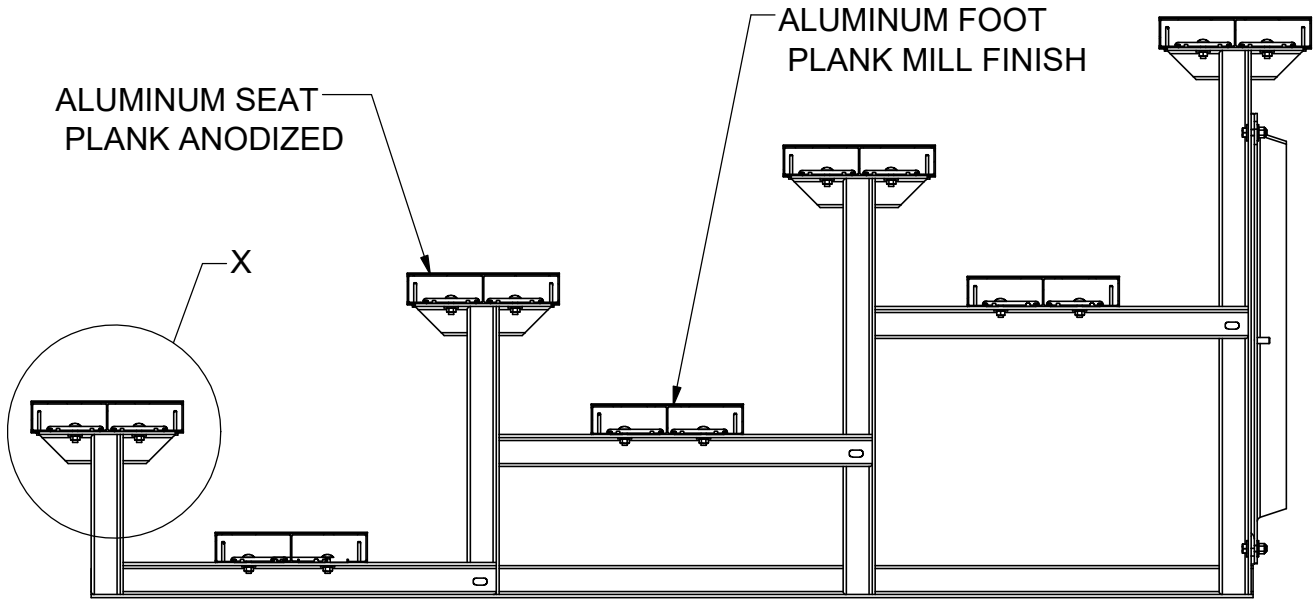
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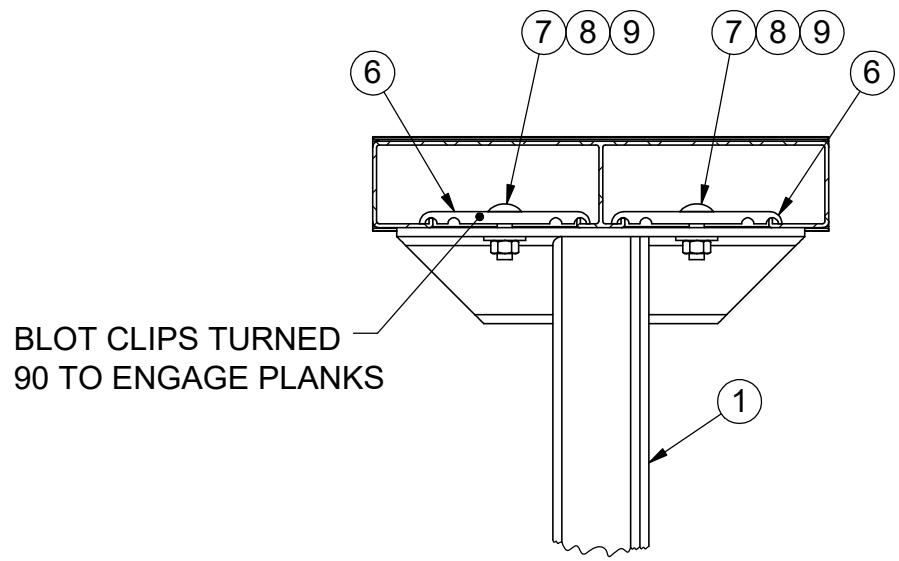
4 ROW STANDARD 15FT

MODEL NO.

1171-415TRA & TRG



SECTION A-A



DETAIL X
ENLARGED



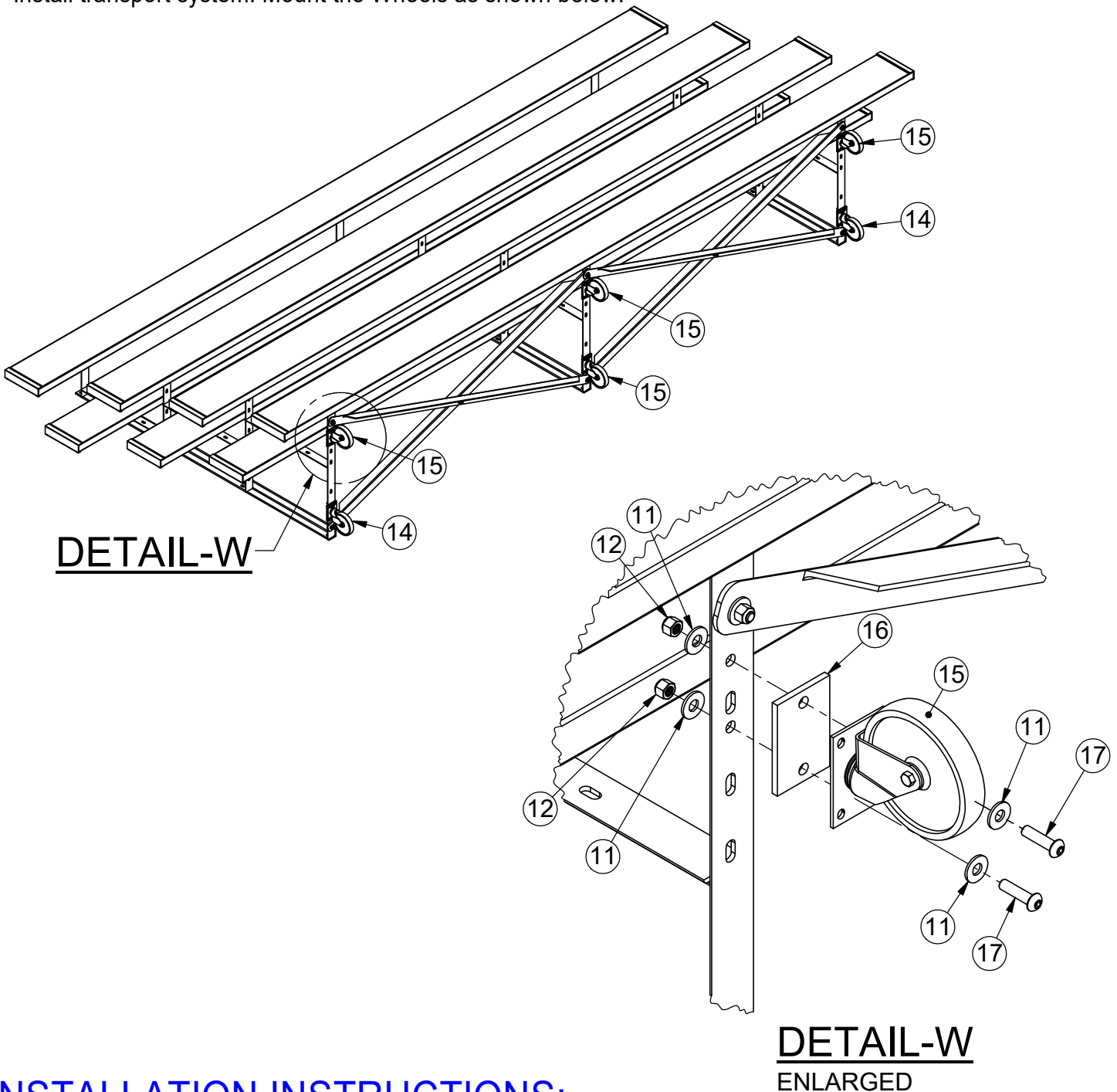
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PRODUCT NAME
4 ROW STANDARD 15FT

MODEL NO.
1171-415TRA & TRG

INSTALLATION INSTRUCTIONS:

7) Install transport system: Mount the Wheels as shown below.



INSTALLATION INSTRUCTIONS:

8) Installing (Optional) Ground Sills (wood measuring 2" x 6" x 9'-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 (4) 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 1-1/4" lag bolts and flat washers provided.



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PRODUCT NAME

4 ROW STANDARD 15FT

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