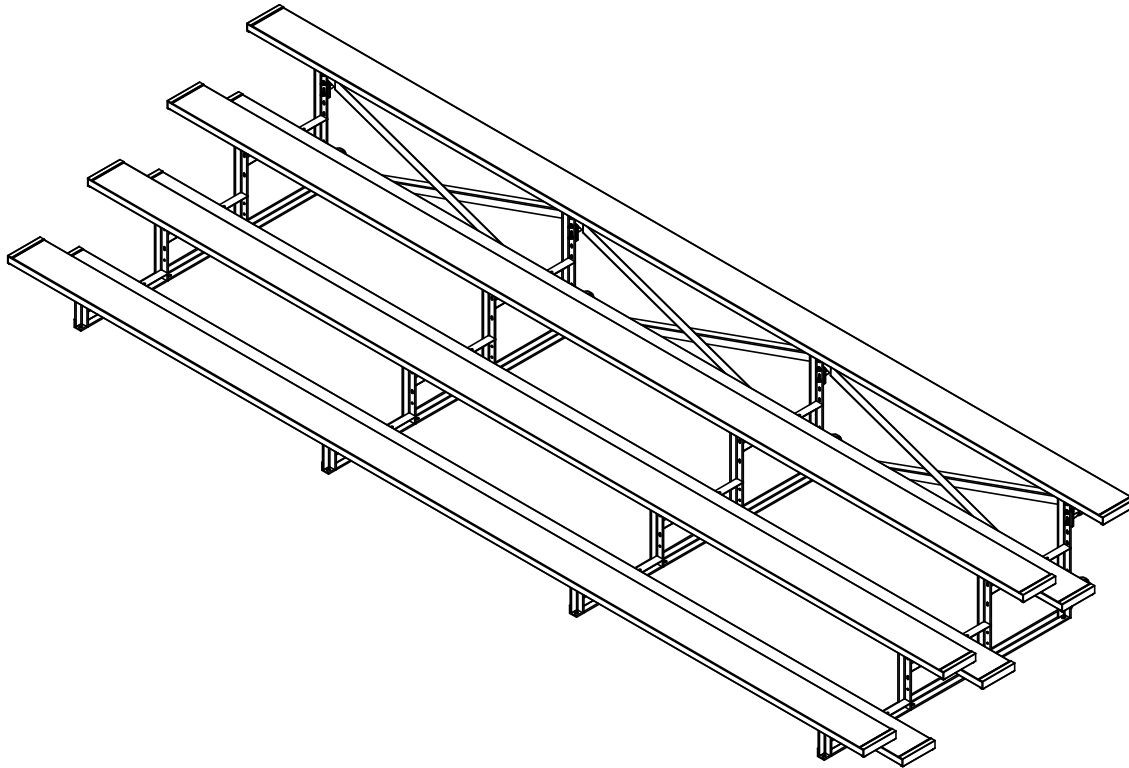


# STANDARD 4-ROW 21' BLEACHER

MODEL 1171-421TRG 4-ROW 21' STEEL  
MODEL 1171-421TRA 4-ROW 21' 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 21' 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.



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 1 of 11

## PRODUCT NAME

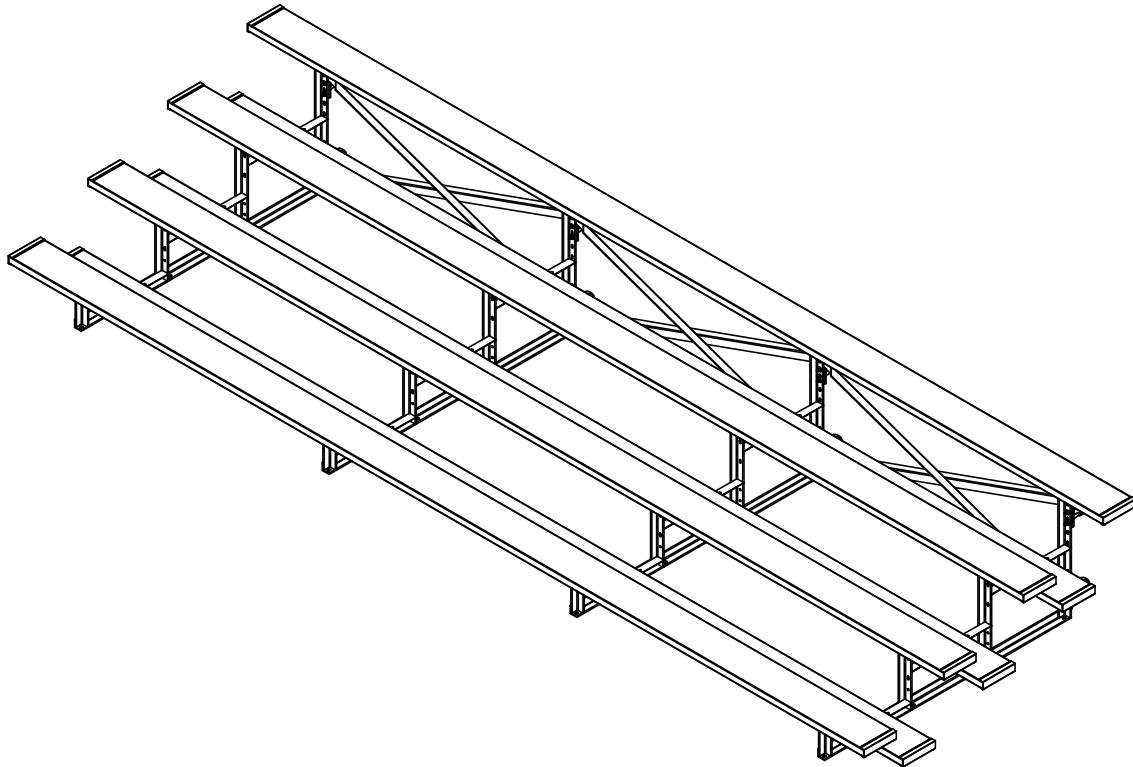
# 4 ROW STANDARD 21FT

MODEL NO.

# 1171-421TRA & TRG

# BOM PARTS & FASTENERS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	ASA-500-1171-415,421,427-A	BLEACHER 4-ROW STANDARD FRAME	4
2	L-0018-1171-1004-79.5-A	STANDARD BLEACHER BRACE 4TH ROW	6
3	PL-1100-252-10-A-A	ALUMINUM PLANK ANODIZED 10"X 252"	4
4	PL-1100-252-10-A-M	ALUMINUM PLANK MILLED 10"X 252"	3
5	VCIAECP	2"X10" ALUM. END CAP	14
6	VCIALCP	BOLT CLIP FOR 10" & 12" ALUMINUM PLANK	56
7	HWCB5161	5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC	56
8	HWLN516	5/16 NYLOK NUT ZINC	56
9	HWFLWA516	5/16" FLAT WASHER	56
10	HWHB38114	3/8-16 X 1 1/4 GR5 C/S ZINC HEX BOLT (1000)	11
11	HWFLWA38	3/8" Flat Washer	54
12	HWLN38	3/8"-16 LOCK NUT	27
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	6
16	VCITIPNROLLPLATE	TIP N ROLL MOUNTING PLATE	8
17	HWBH38112	3/8 X 1-1/2 BUTTON HEAD SOCKET CAP SCREW SS 18.8	16



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 2 of 11

PRODUCT NAME

**4 ROW STANDARD 21FT**

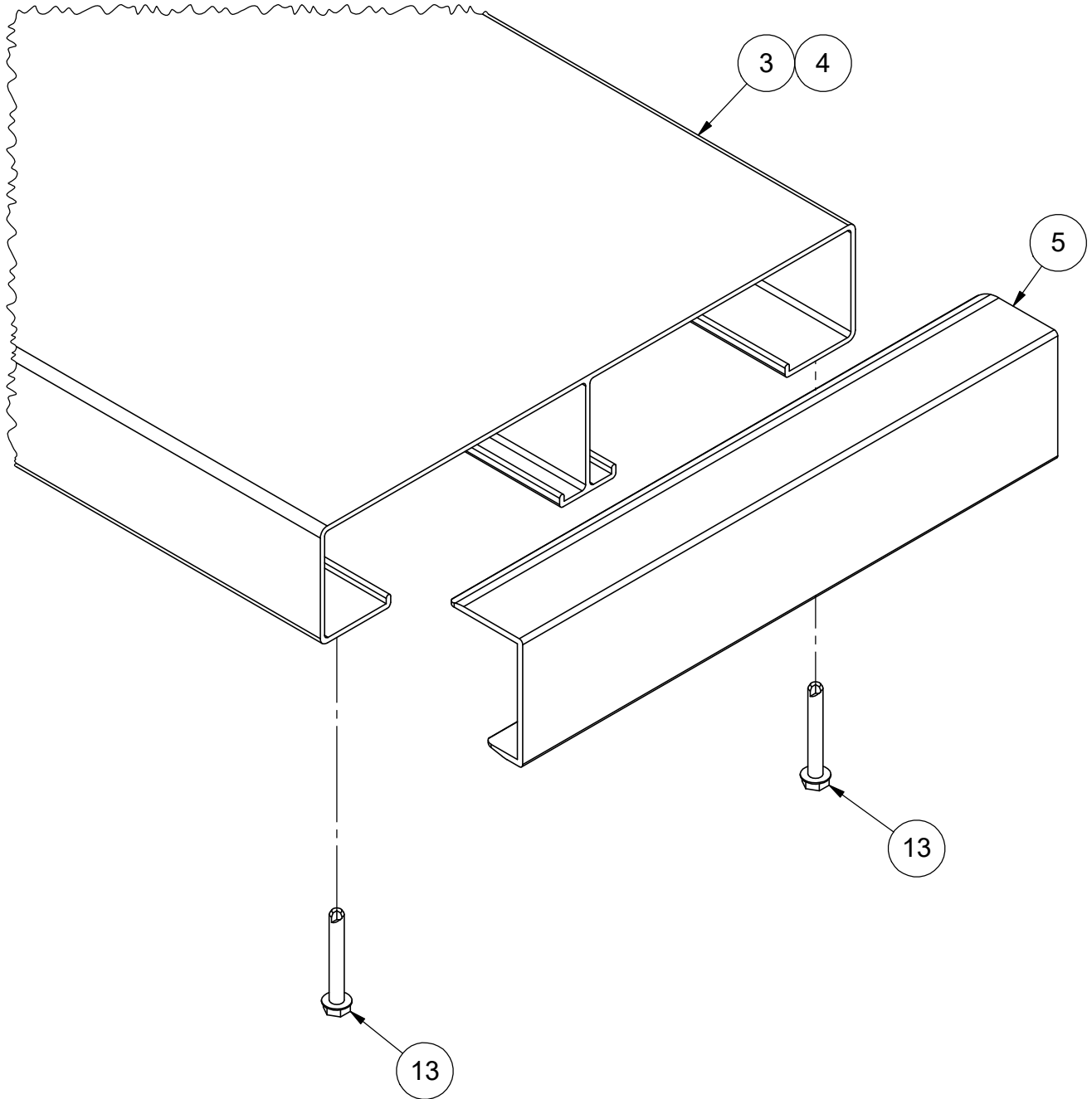
MODEL NO.

**1171-421TRA & 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.



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 3 of 11

PRODUCT NAME

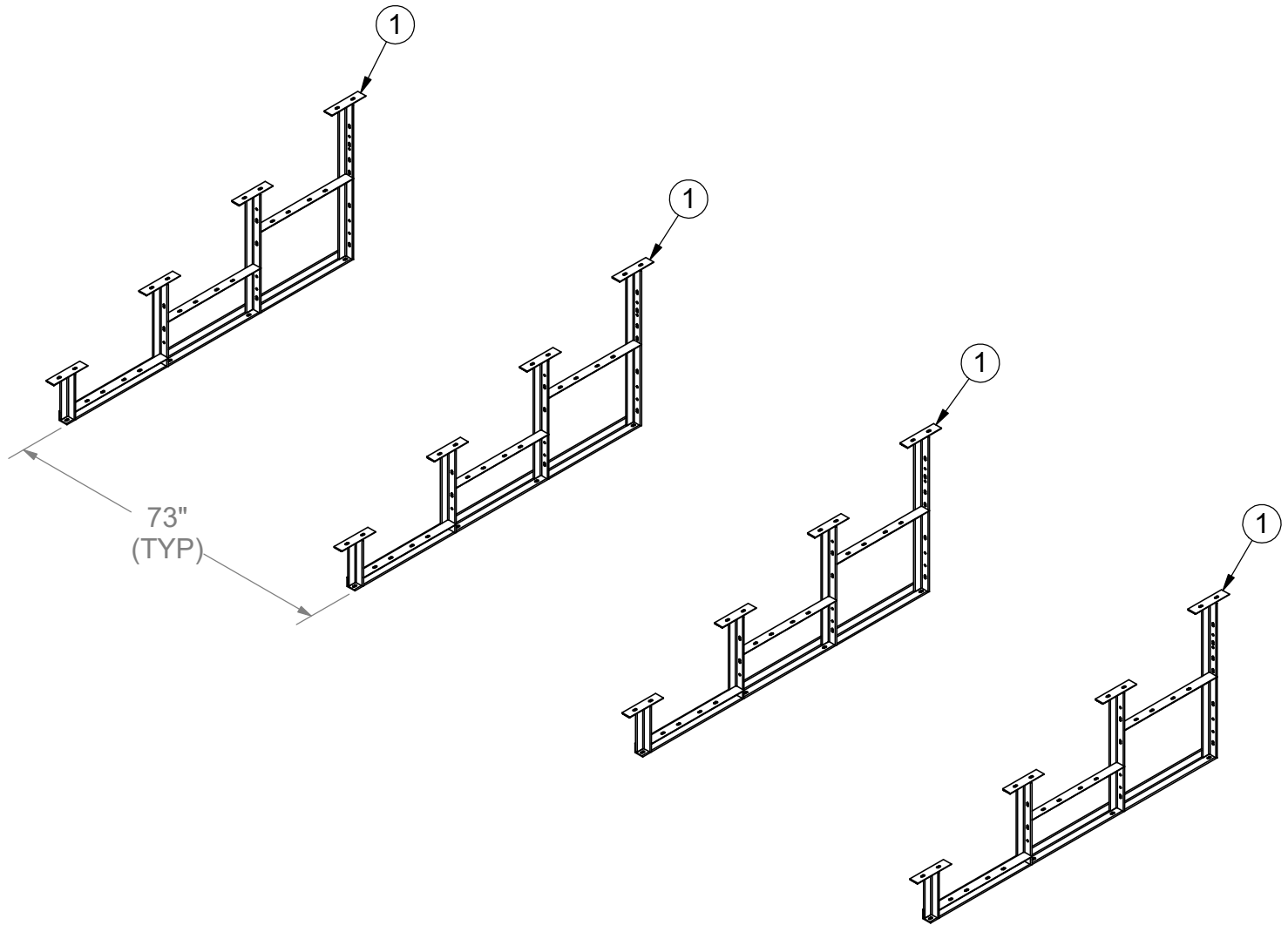
4 ROW STANDARD 21FT

MODEL NO.

1171-421TRA & TRG

# INSTALLATION INSTRUCTIONS:

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



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 4 of 11

PRODUCT NAME

**4 ROW STANDARD 21FT**

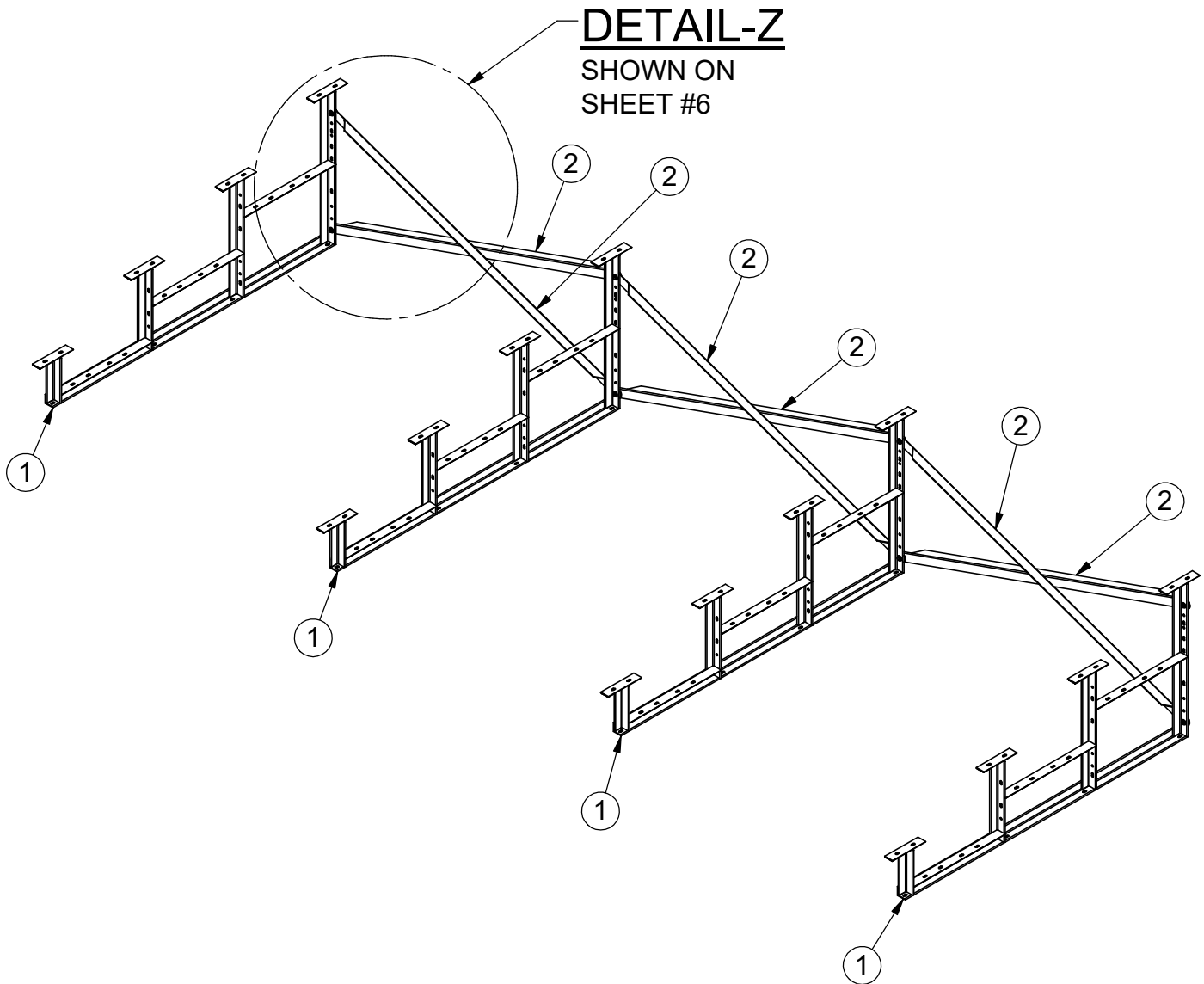
MODEL NO.

**1171-421TRA & TRG**

# INSTALLATION INSTRUCTIONS:

4) To Install Cross Braces: a) Locate three 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.



Date: 7/26/2017

Rev: A

Drawn: BDYE

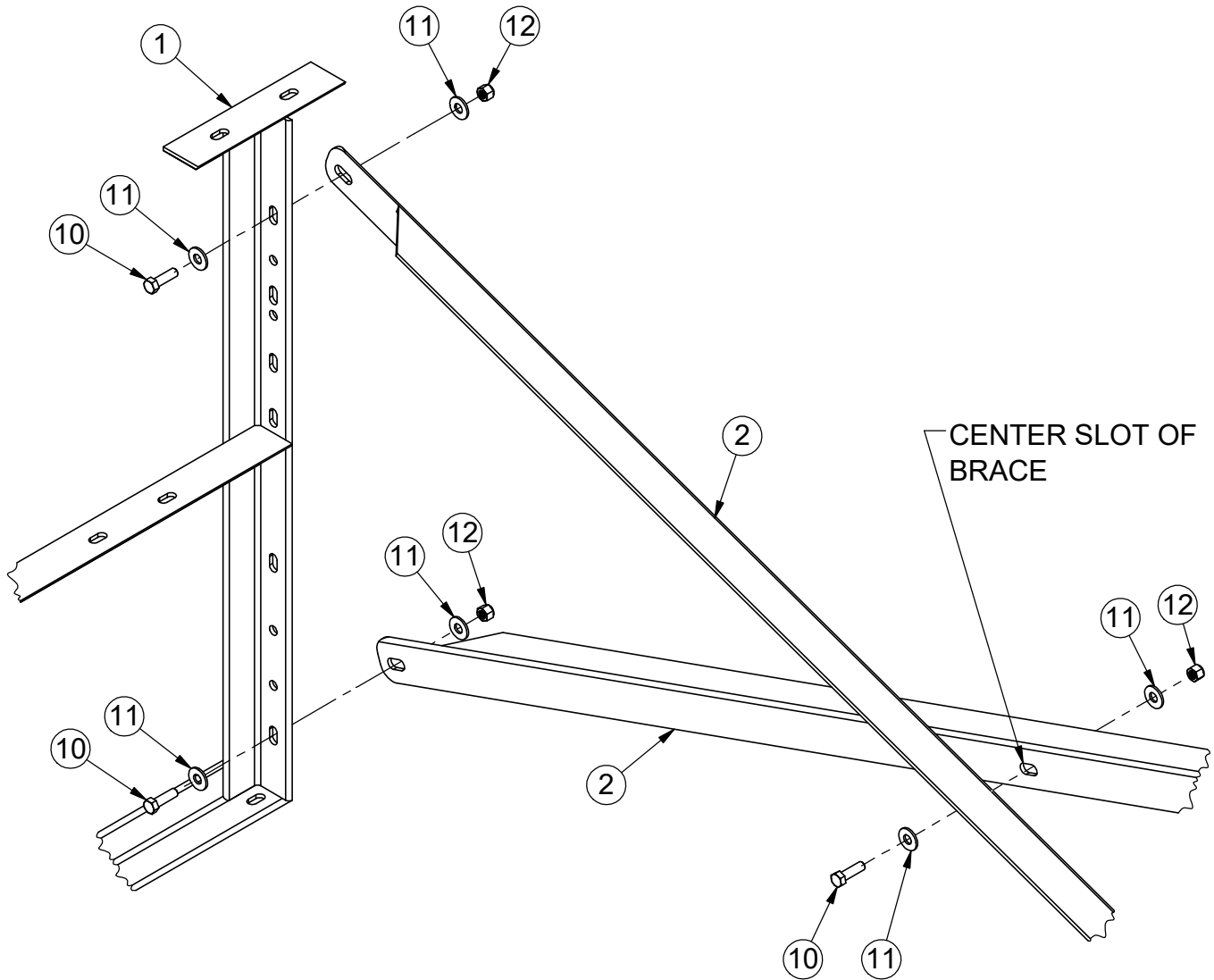
Sheet: 5 of 11

PRODUCT NAME

**4 ROW STANDARD 21FT**

MODEL NO.

**1171-421TRA & TRG**



## DETAIL-Z

ENLARGED  
FROM SHEET #5



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 6 of 11

PRODUCT NAME

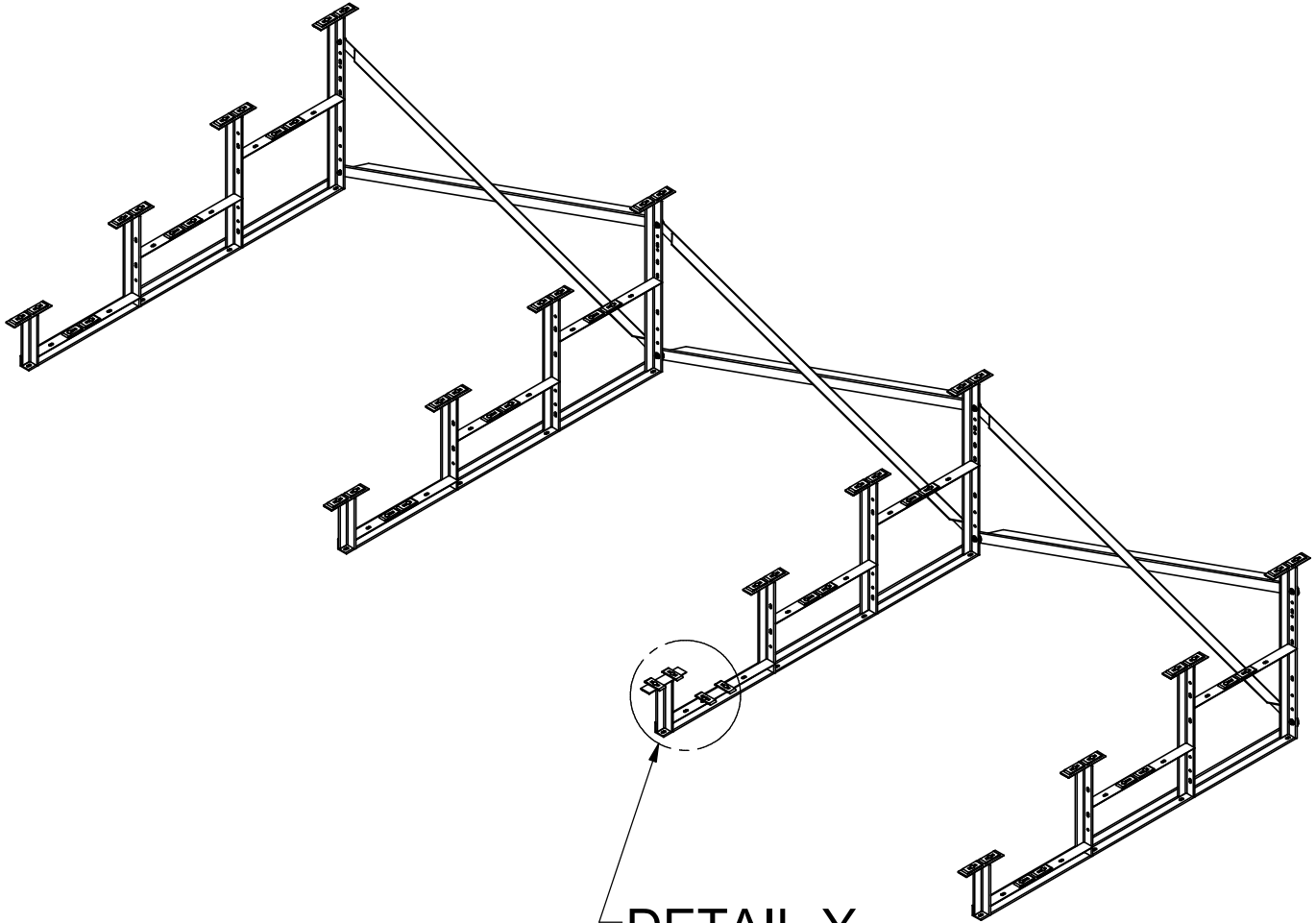
**4 ROW STANDARD 21FT**

MODEL NO.

**1171-421TRA & 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 8, and lock nuts 9 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.



DETAIL-Y

SHOWN ON  
SHEET #8



Date: 7/26/2017

Rev: A

Drawn: BDYE

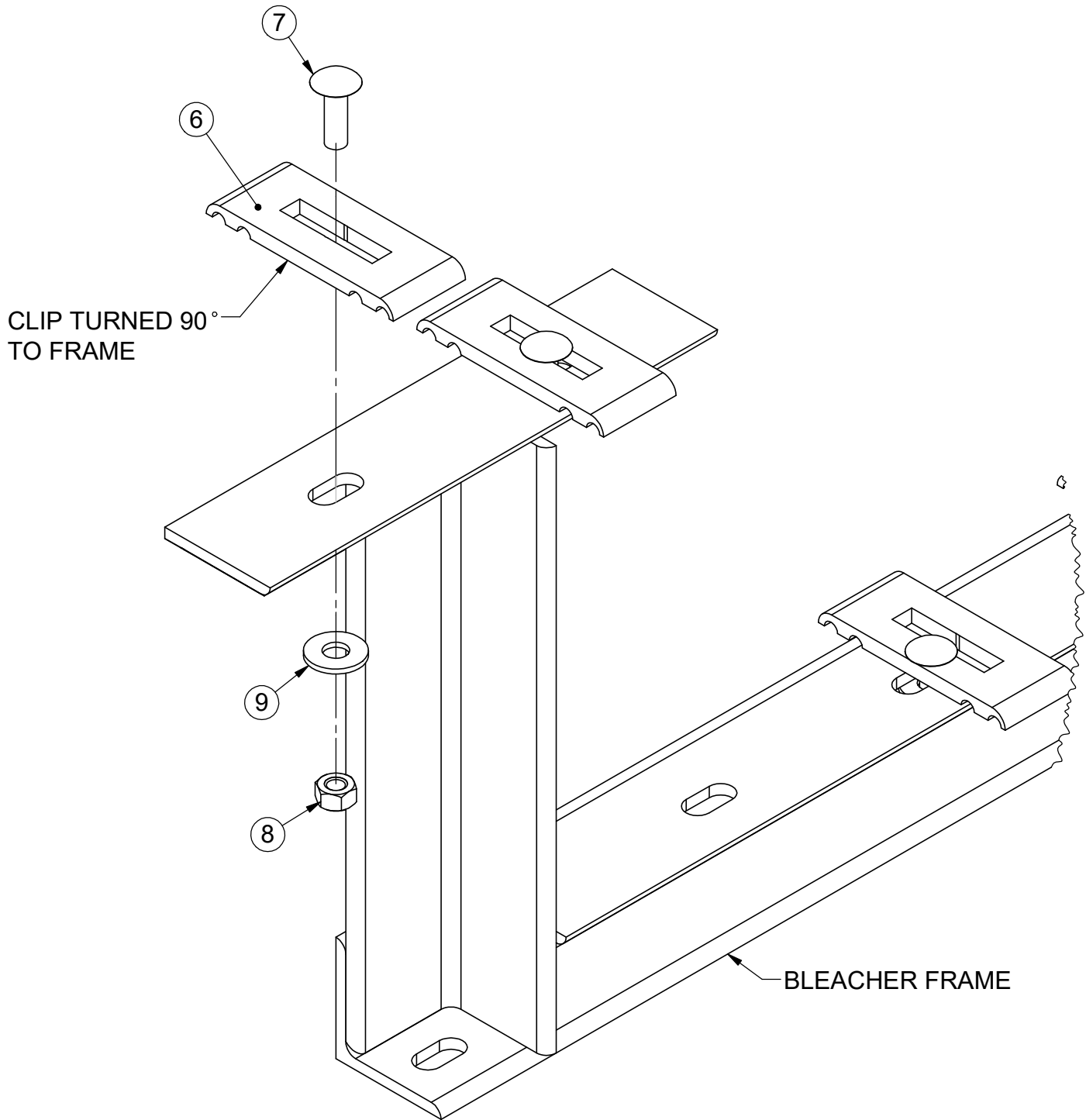
Sheet: 7 of 11

PRODUCT NAME

4 ROW STANDARD 21FT

MODEL NO.

1171-421TRA & TRG



**DETAIL-Y**  
 ENLARGED  
 FROM SHEET #7



Date: 7/26/2017  
 Rev: A  
 Drawn: BDYE  
 Sheet: 8 of 11

**PRODUCT NAME**

**4 ROW STANDARD 21FT**

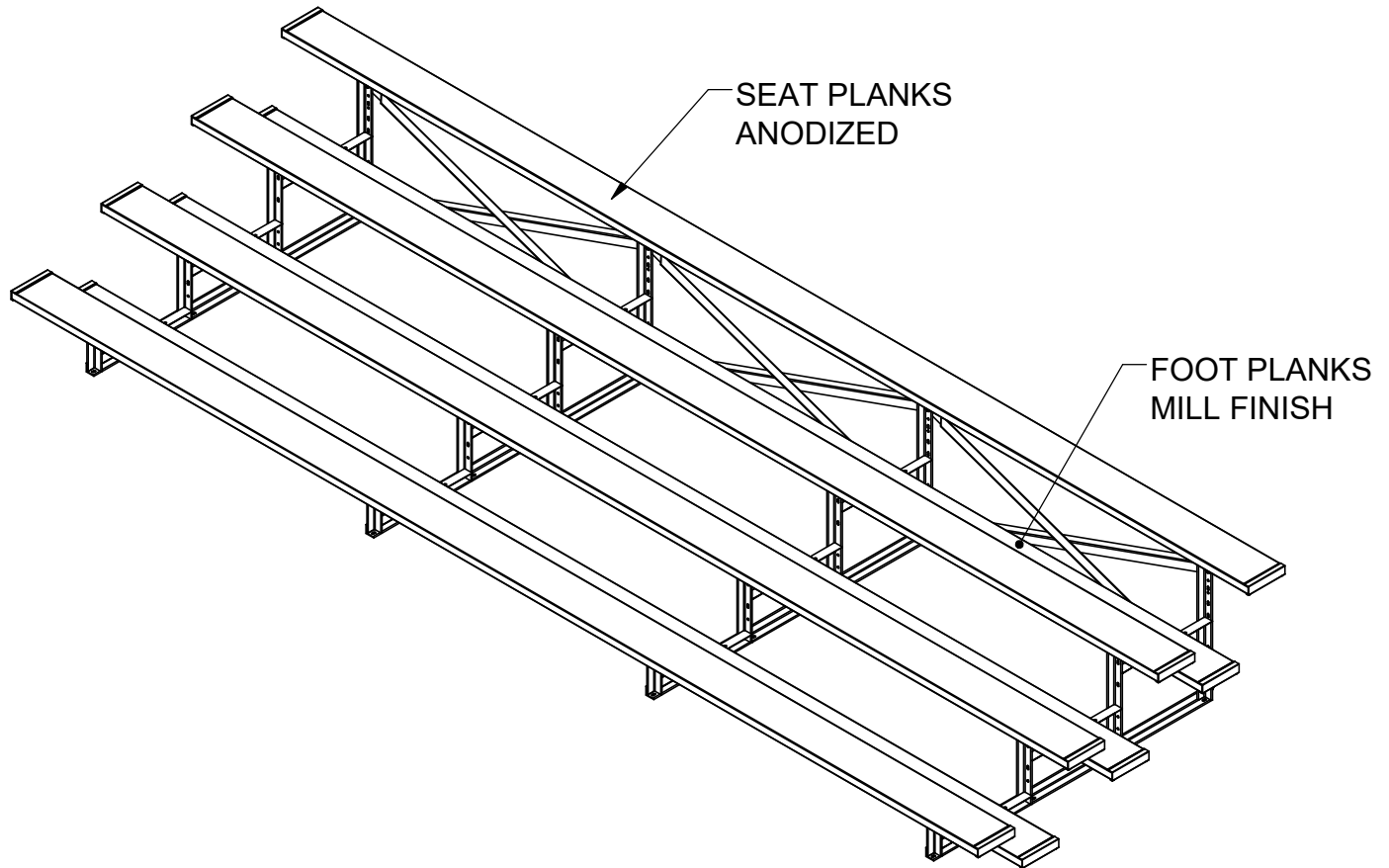
**MODEL NO.**

**1171-421TRA & TRG**



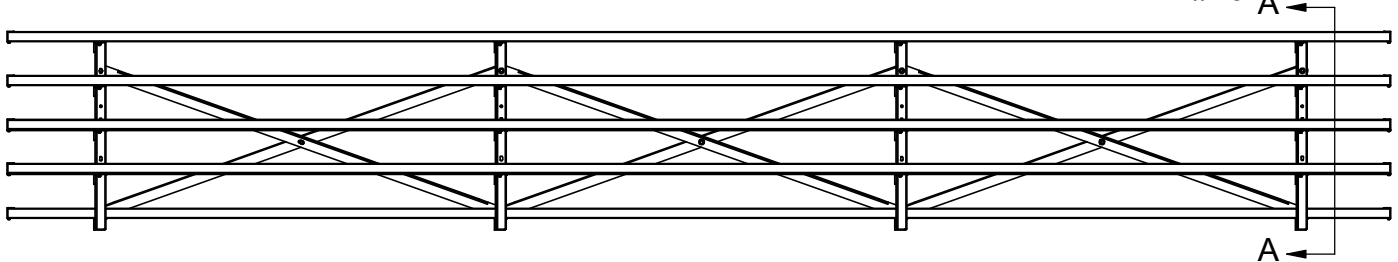
# INSTALLATION INSTRUCTIONS:

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



Date: 7/26/2017

Rev: A

Drawn: BDYE

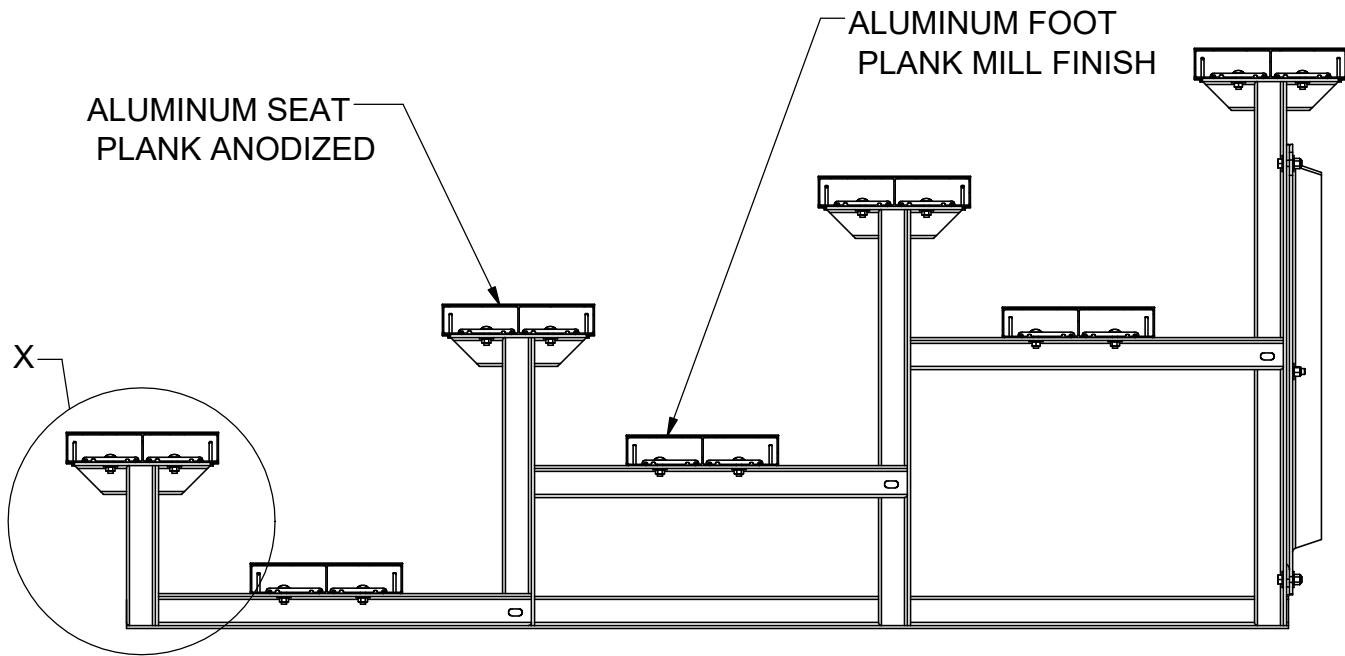
Sheet: 9 of 11

PRODUCT NAME

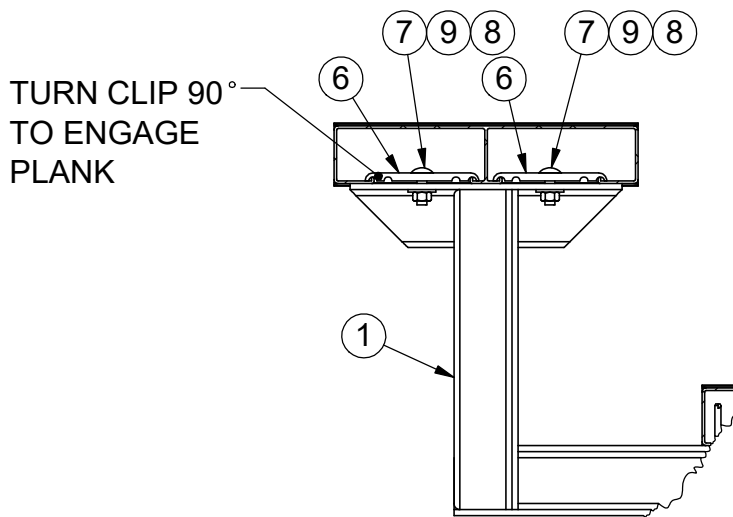
4 ROW STANDARD 21FT

MODEL NO.

1171-421TRA & TRG



**SECTION A-A**



**DETAIL X**  
ENLARGED

**INSTALLATION INSTRUCTIONS:**

7) 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.



Date: 7/26/2017  
 Rev: A  
 Drawn: BDYE  
 Sheet: 10 of 11

**PRODUCT NAME**

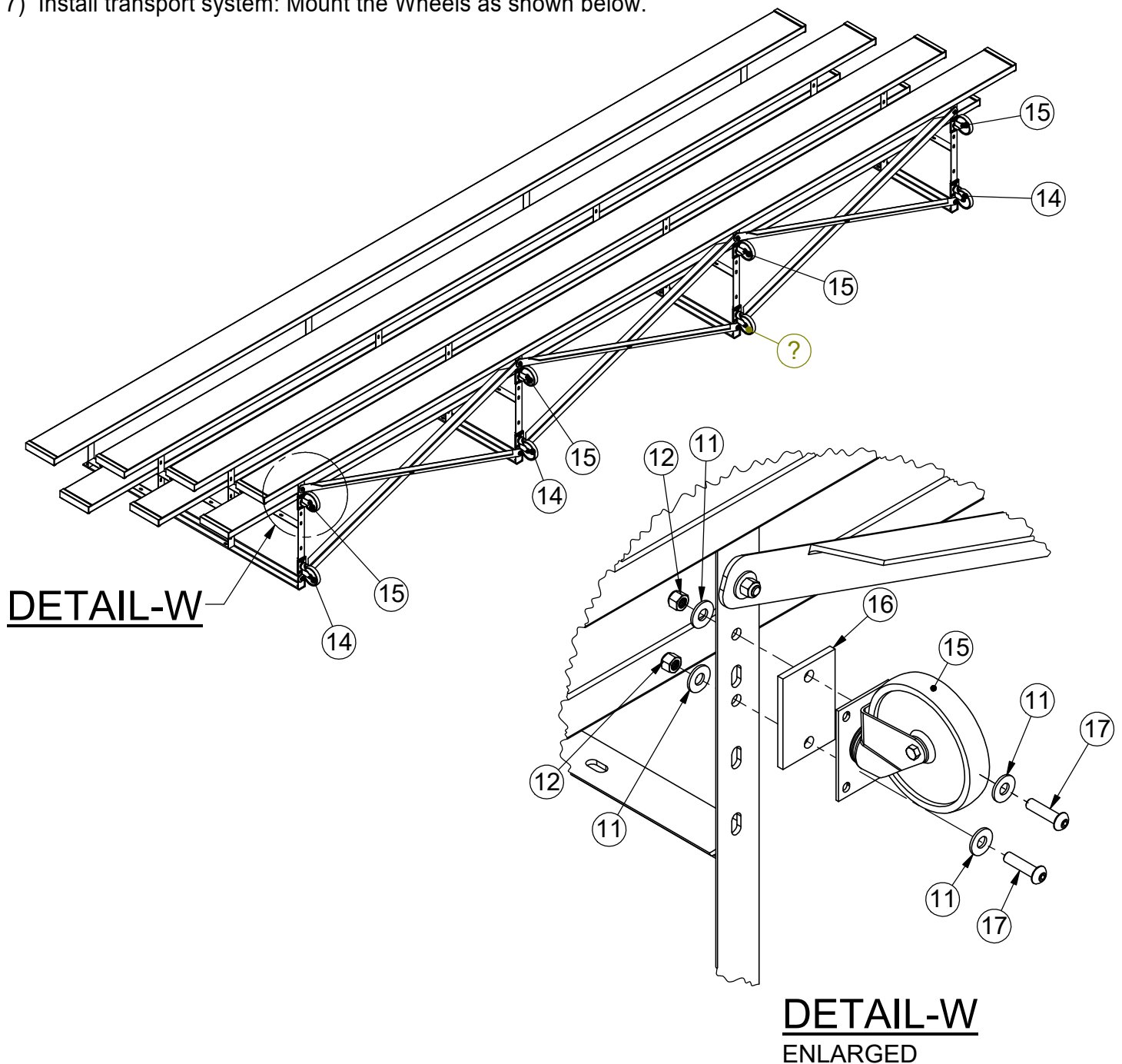
**4 ROW STANDARD 21FT**

**MODEL NO.**

**1171-421TRA & TRG**

## INSTALLATION INSTRUCTIONS:

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



DETAIL-W

DETAIL-W  
ENLARGED

## 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.



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 11 of 11

PRODUCT NAME

4 ROW STANDARD 21FT

MODEL NO.

1171-421TRA & TRG