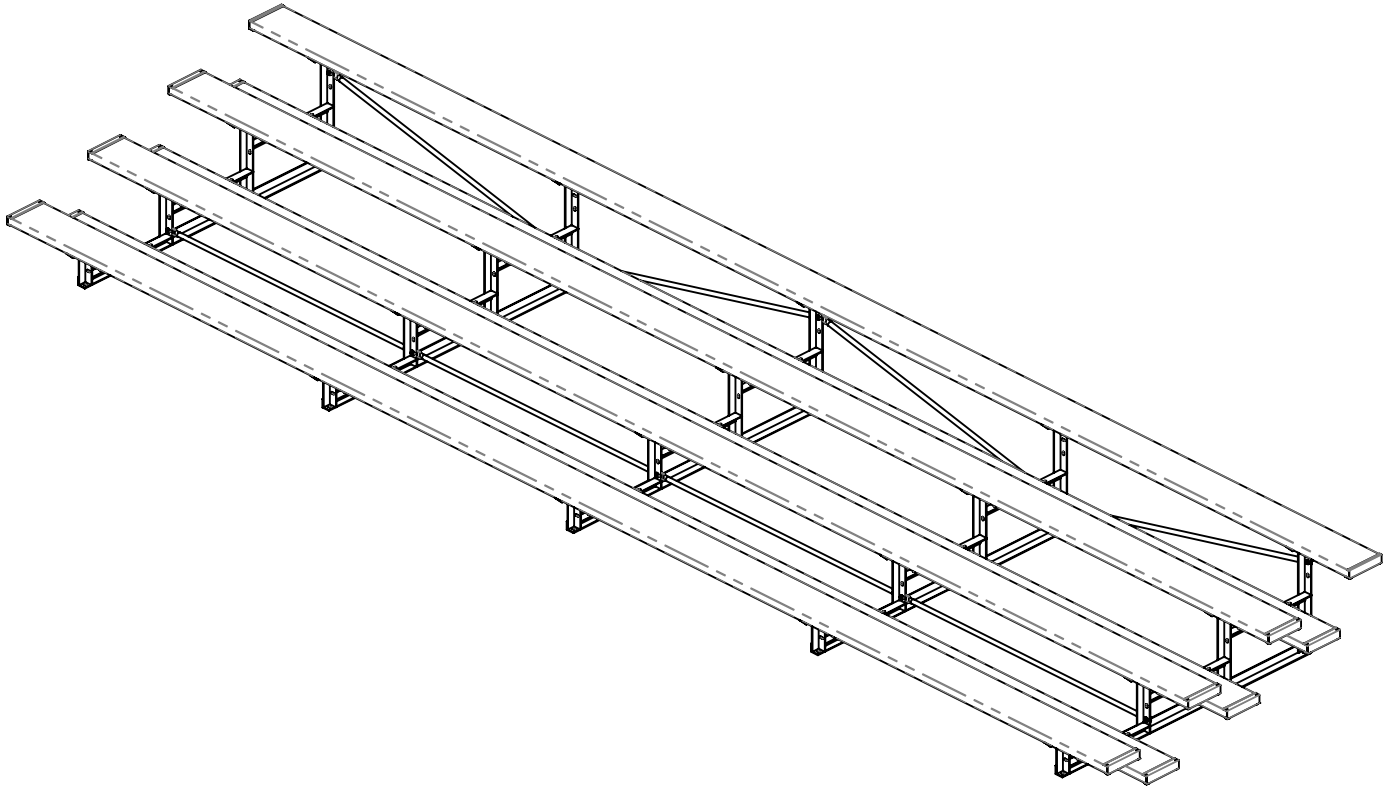


# STANDARD 4-ROW 27' BLEACHER

MODEL 1171-427G 4-ROW 27' STEEL  
MODEL 1171-427A 4-ROW 27' ALUMINUM

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



## SPECIFICATIONS:

Bleacher Frames are 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 27' 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.



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PRODUCT NAME

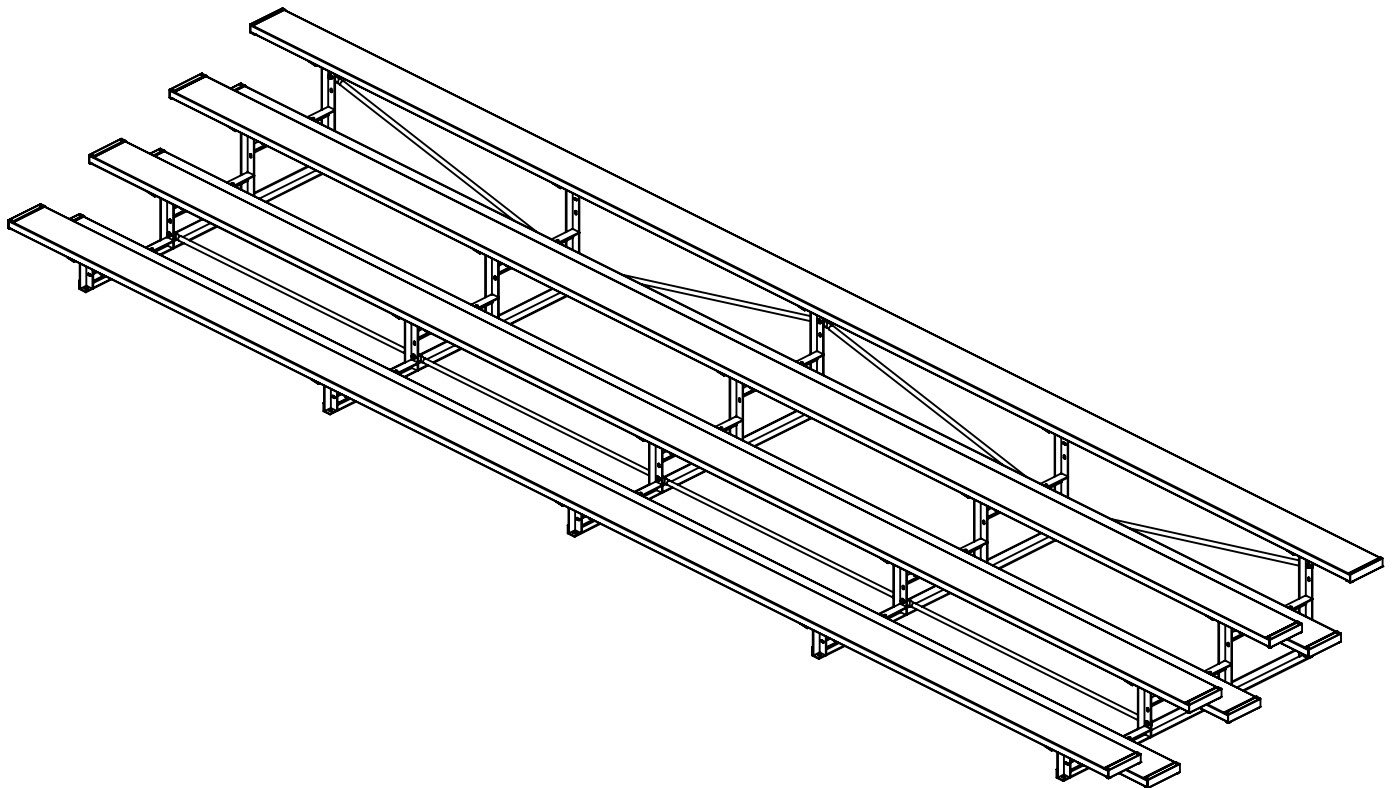
**4 ROW STANDARD 27FT**

MODEL NO.

**1171-427**

# BOM PARTS & FASTENERS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	ROW4A or ROW4G	BLEACHER 4-ROW STANDARD FRAME	5
2	CIBLB74.625	BLEACHER BRACE 74-5/8" LONG	8
3	CIBLB76.375	BLEACHER BRACE 76-3/8" LONG	4
4	RMPLK27-10	ALUMINUM PLANK 10"x 324" ANODIZED	7
5	VCIAECP	2"x10" ALUM. END CAP	14
6	VCIACLP	BOLT CLIP FOR 10" & 12" ALUMINUM PLANK	70
7	HWCB5161	5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC	70
8	HWLN516	5/16 NYLOK NUT ZINC	70
9	HWFLWA516	5/16 FLAT WASHER	70
10	HWHB38112	3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT	15
11	HWFLWA38	3/8" Flat Washer	30
12	HWLN38	3/8 NYLOK NUT ZINC	15
13	HWTEX1034	#10 x 3/4 SELF TAPPING SCREW	28



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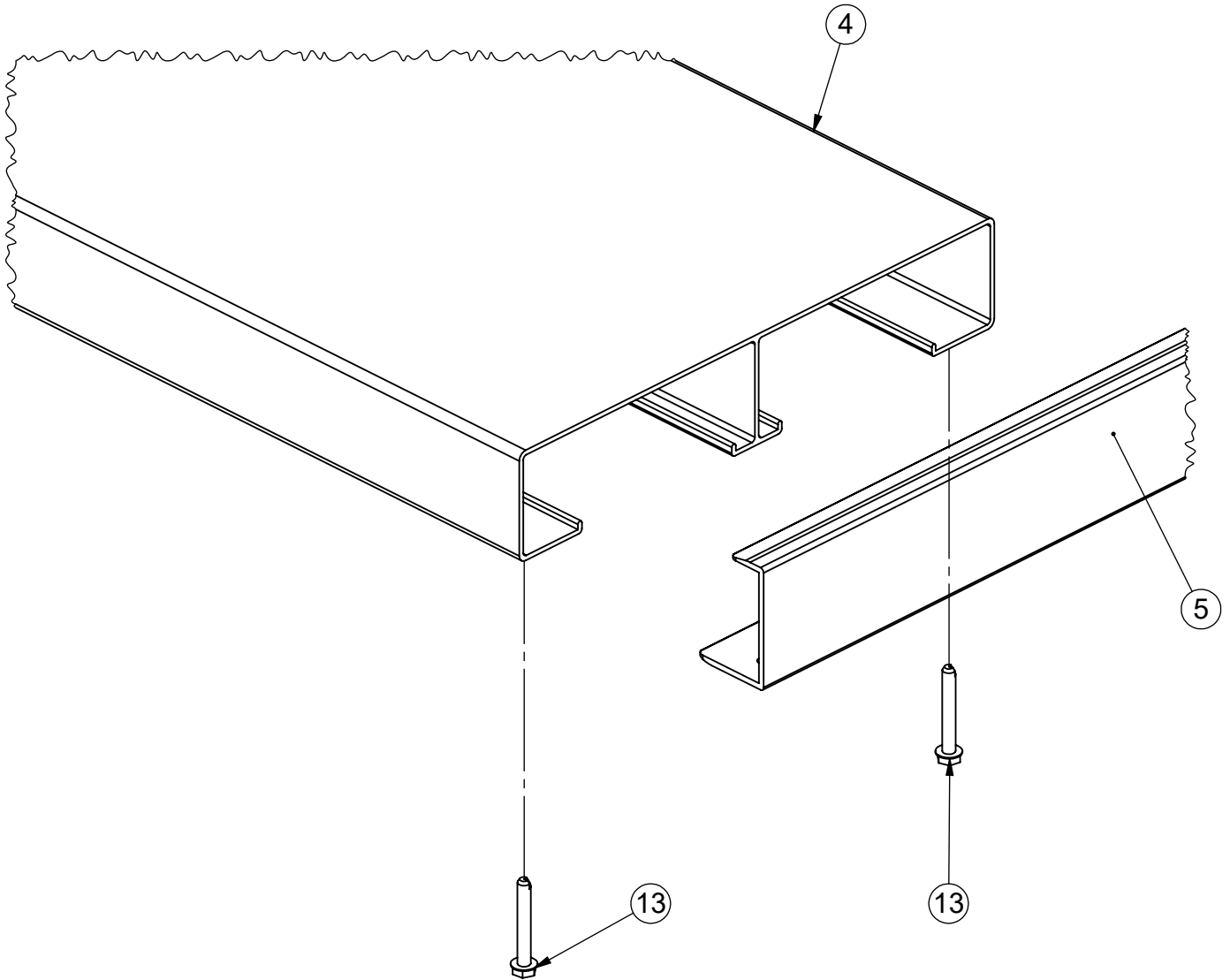
MODEL NO.

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



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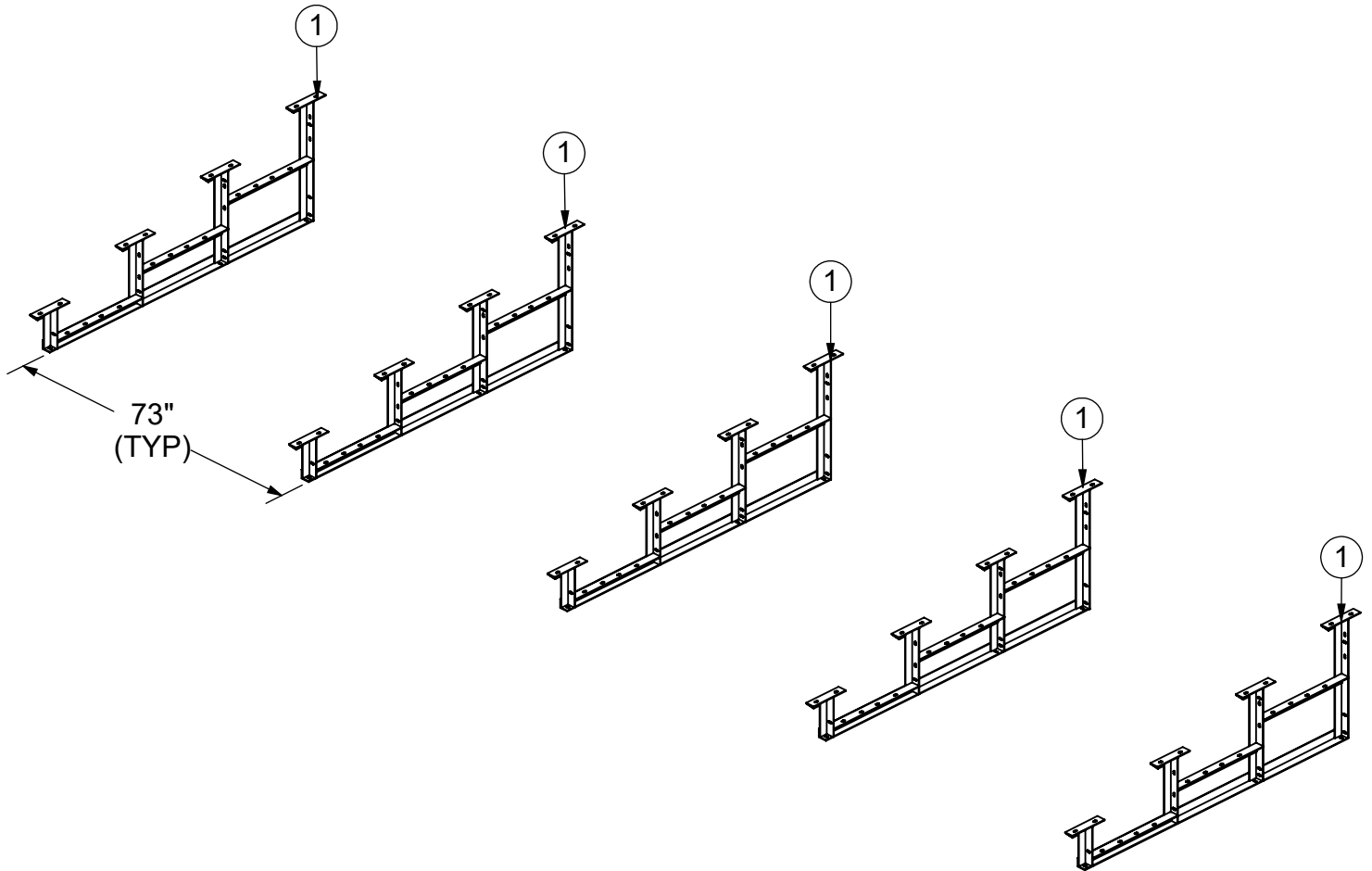
**4 ROW STANDARD 27FT**

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# INSTALLATION INSTRUCTIONS:

3) Locate the five bleacher 4-Row Standard Frame Item (1) and set on a level surface on 73" centers.



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**4 ROW STANDARD 27FT**

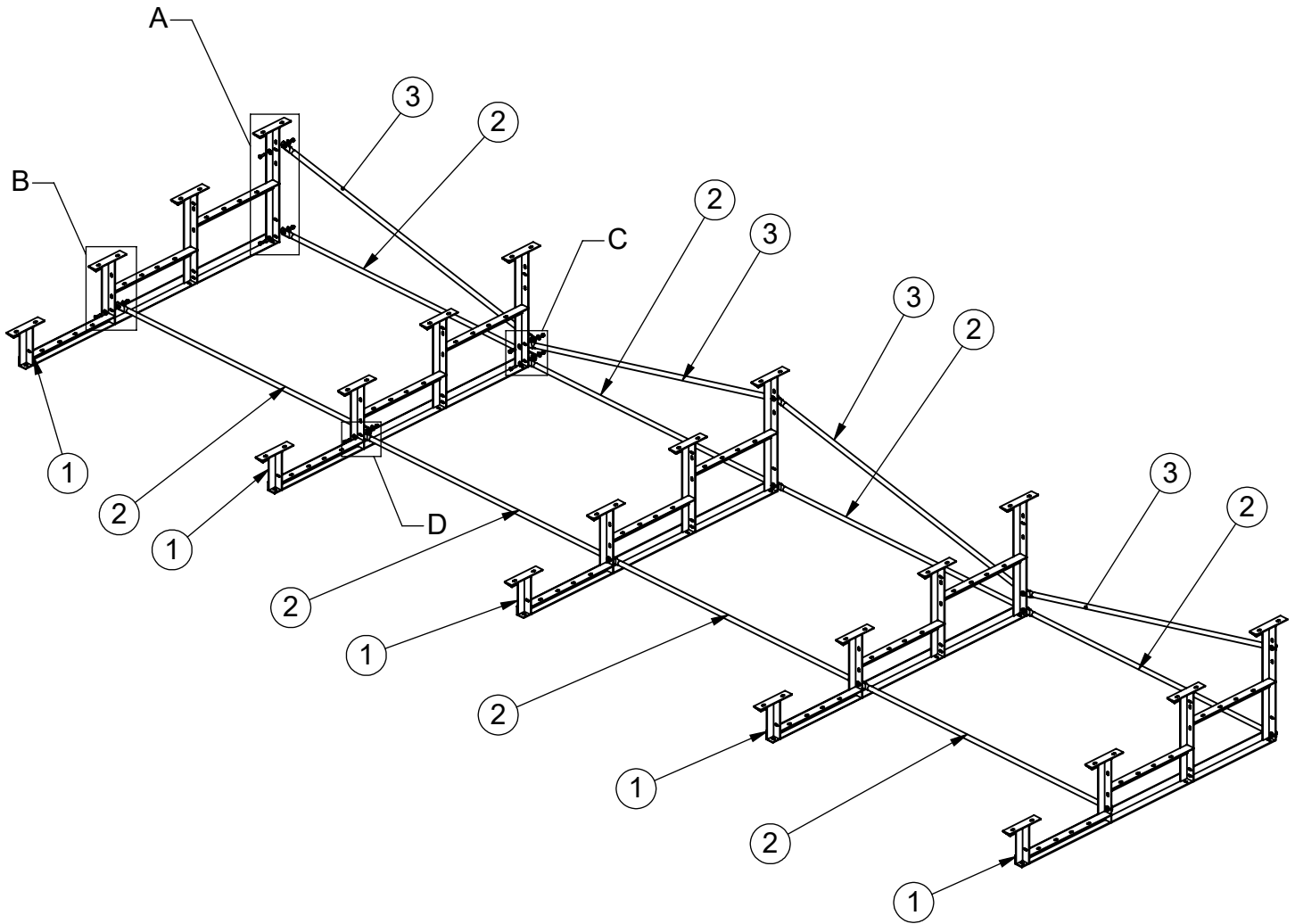
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# INSTALLATION INSTRUCTIONS:

4) To Install Braces: a) Locate four diagonal braces measuring 76-3/8" (3) and eight horizontal braces measuring 76-3/8" (2). Install on the backside of the Bleacher Frames using 3/8" x 1-1/2" Hex Bolt (10), Washers (11), and Lock Nut (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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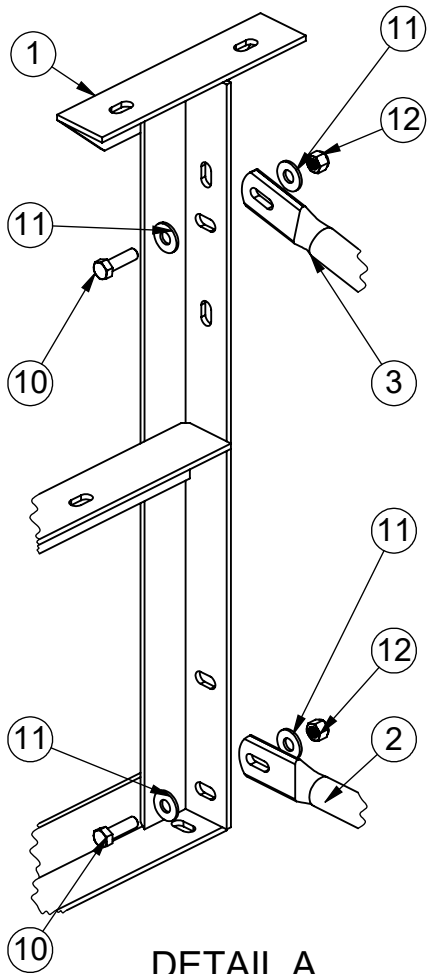
Sheet: 5 of 10

PRODUCT NAME

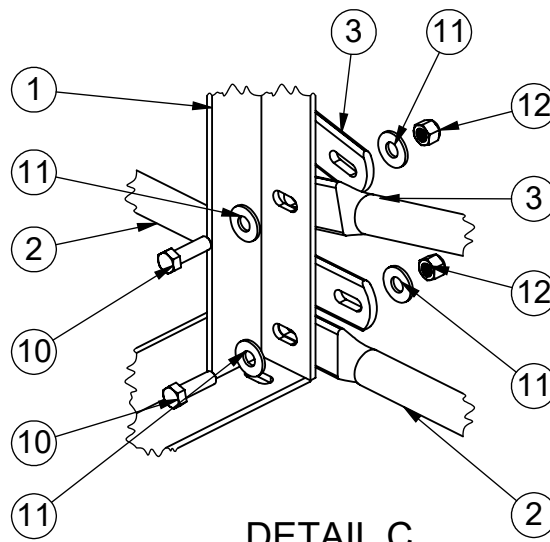
4 ROW STANDARD 27FT

MODEL NO.

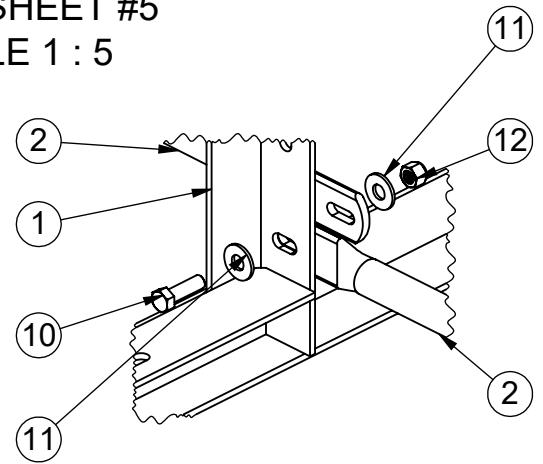
1171-427



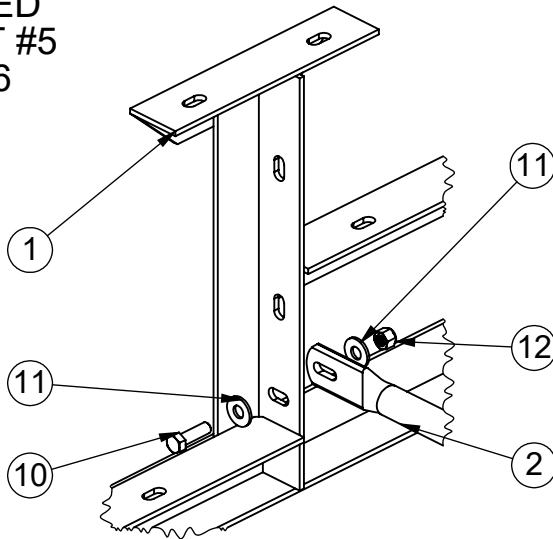
DETAIL A  
ENLARGED  
FROM SHEET #5  
SCALE 1 : 6



DETAIL C  
ENLARGED  
FROM SHEET #5  
SCALE 1 : 5



DETAIL D  
ENLARGED  
FROM SHEET #5  
SCALE 1 : 5



DETAIL B  
ENLARGED  
FROM SHEET #5  
SCALE 1 : 6



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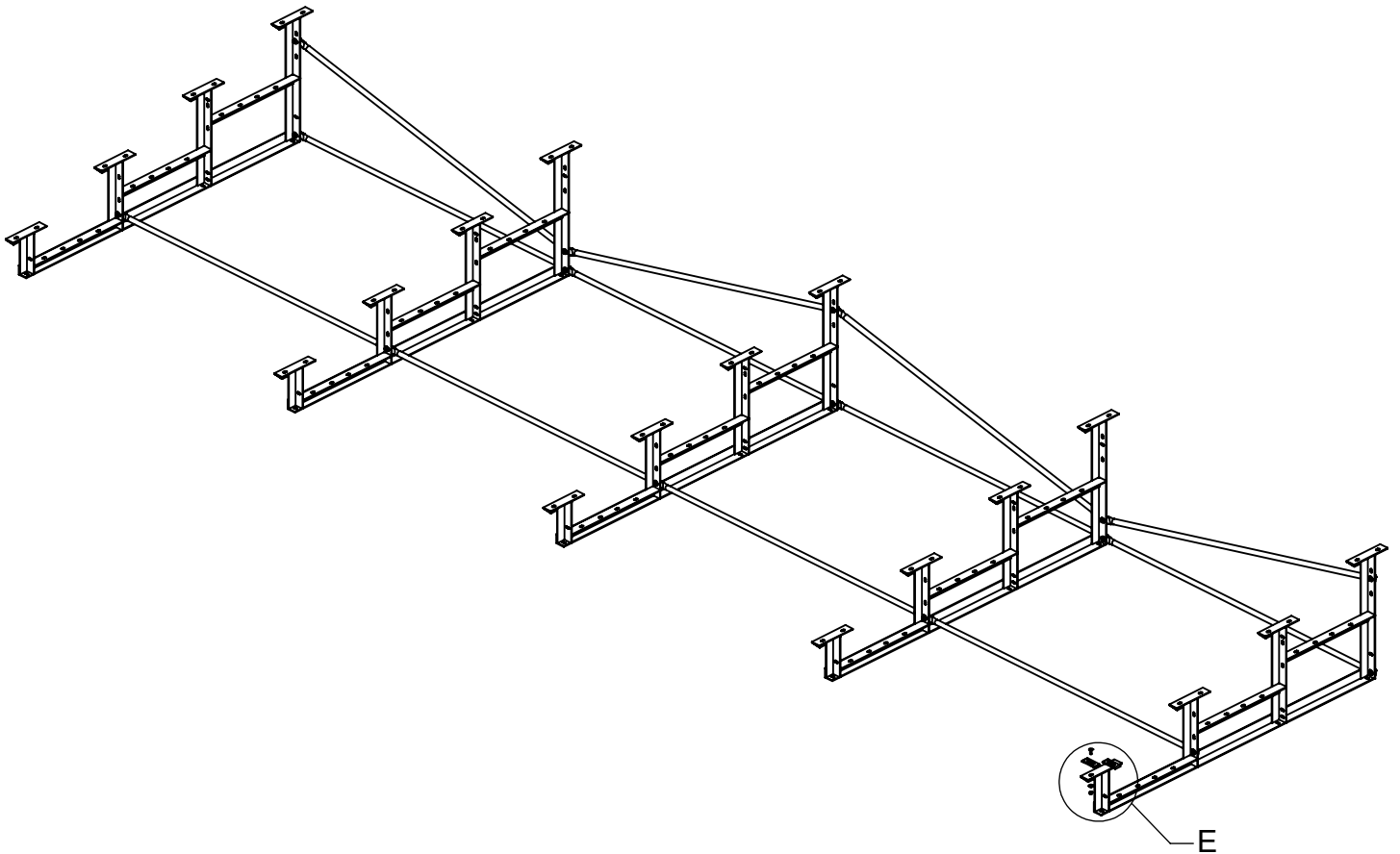
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# INSTALLATION INSTRUCTIONS:

5) To Install Seat and Foot Planks: a) First install the Bolt Clip For 10" & 12" Aluminum Plank (6) using 5/16" x 1" carriage bolts (7), washer (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 (6) perpendicular to the frames.



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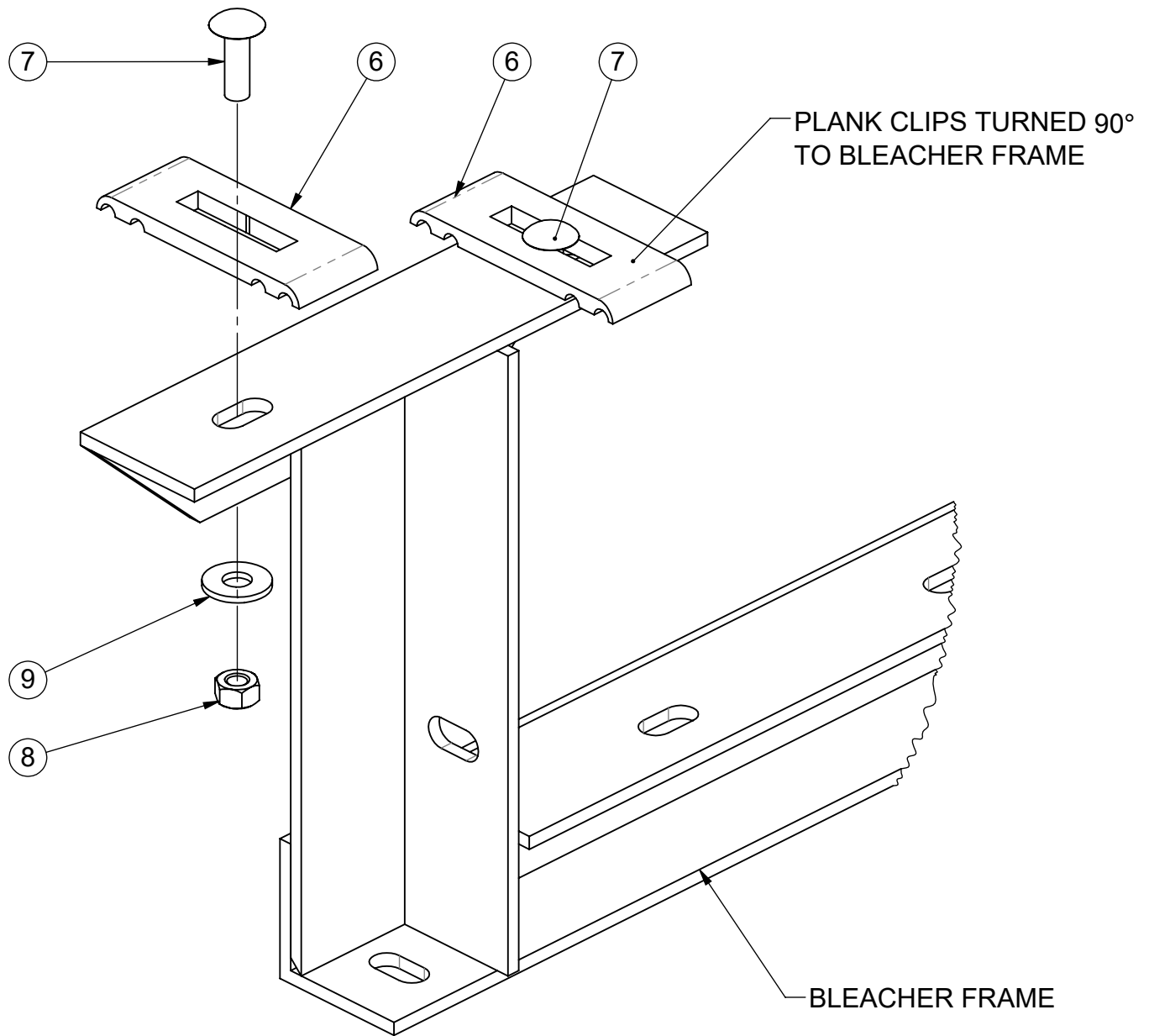
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**4 ROW STANDARD 27FT**

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DETAIL E  
 ENLARGED  
 FROM SHEET #7  
 SCALE 1 : 2



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**4 ROW STANDARD 27FT**

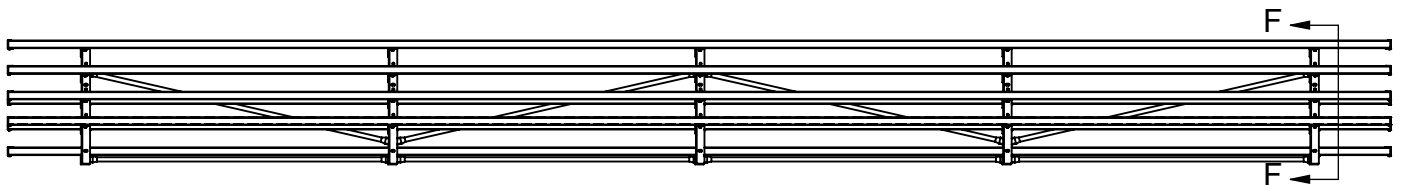
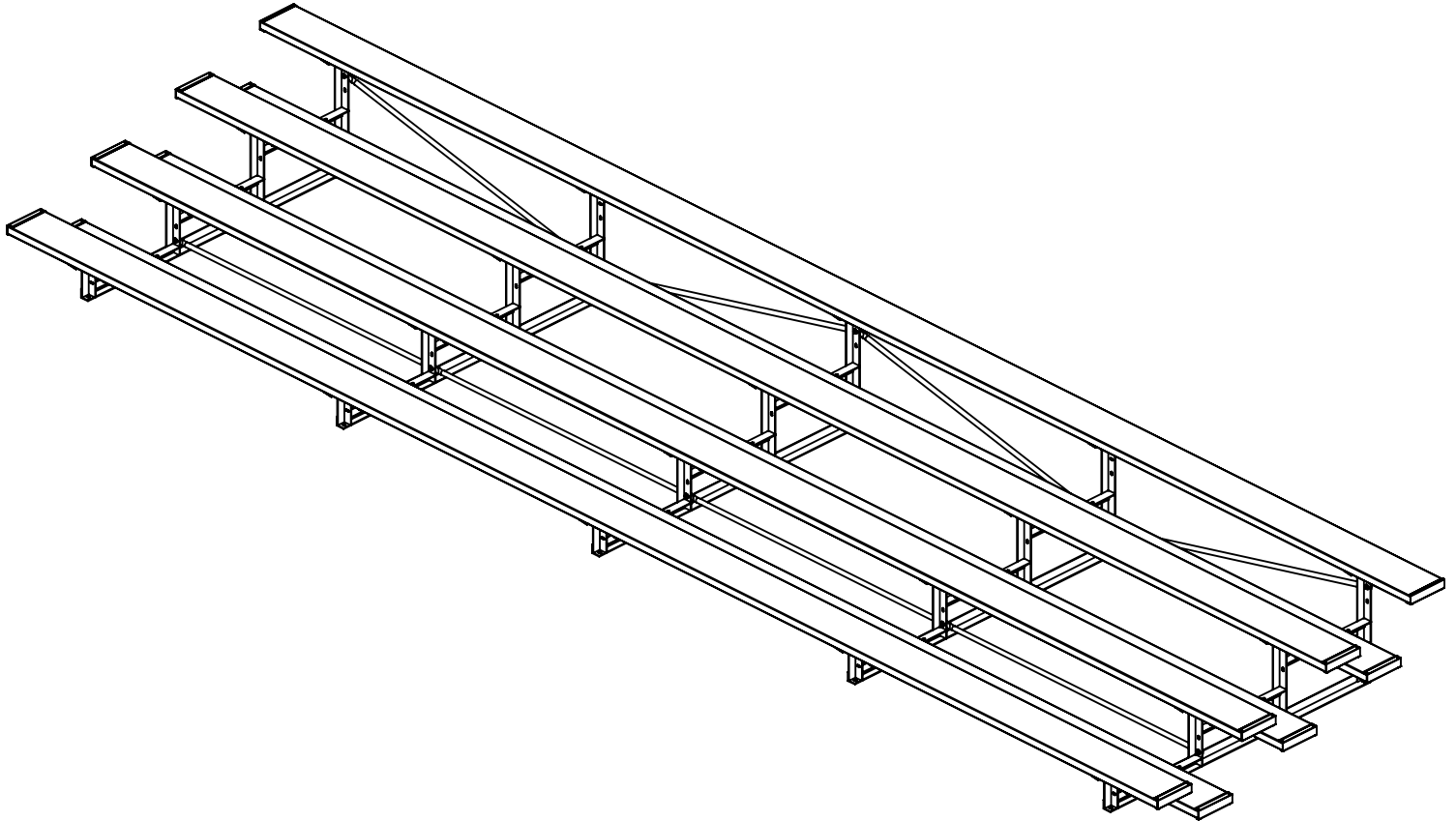
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# INSTALLATION INSTRUCTIONS:

6) Position seat Planks and Foot Planks on the supports so the Bolt Clips (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 (6) to 90° so they engage the planks. To Secure Planks to Frames center planks on frames Items (1) . Tighten all hardware on frames and planks securely.



FRONT VIEW



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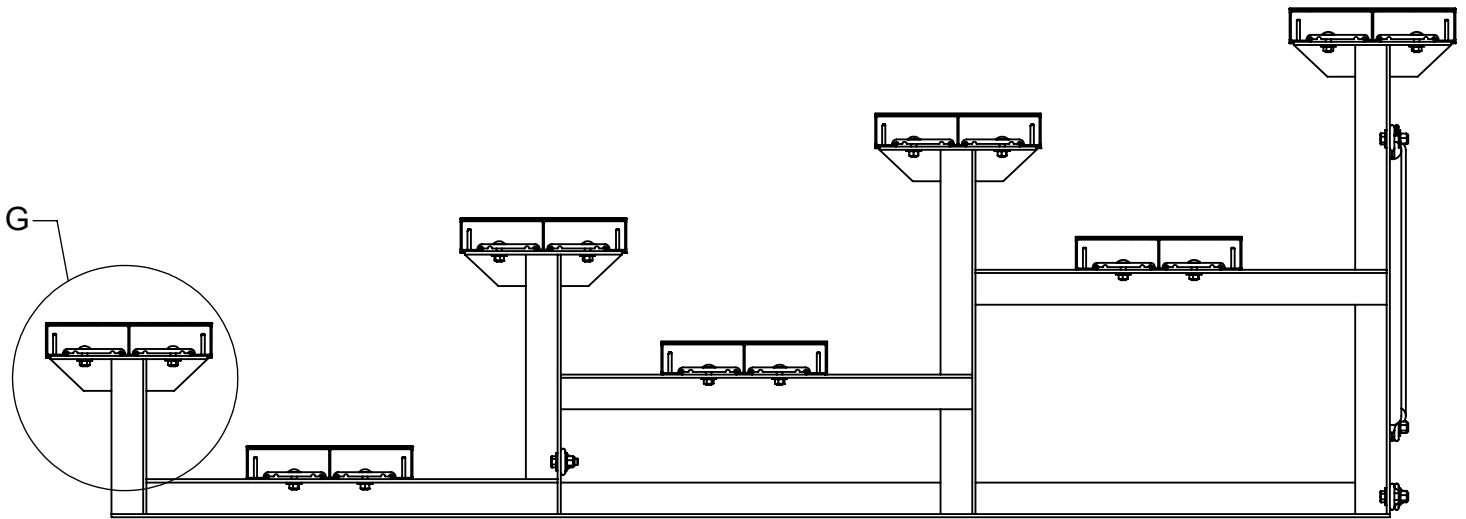
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4 ROW STANDARD 27FT

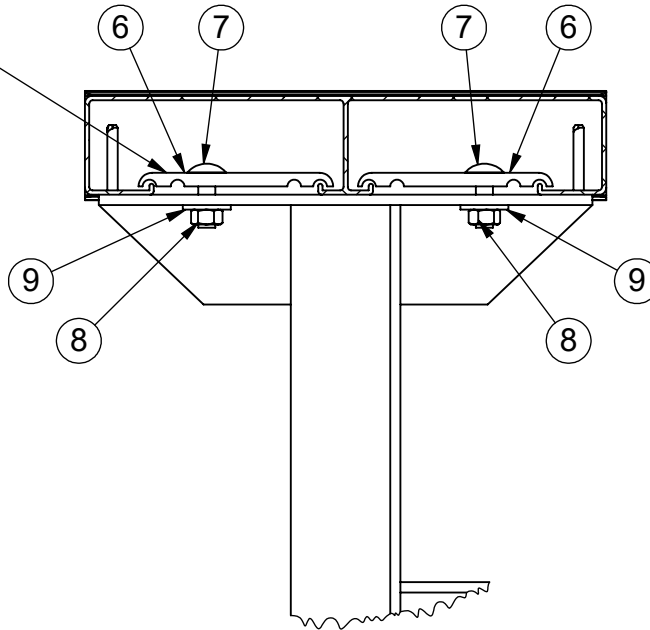
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SECTION F-F  
FROM SHEET #9  
SCALE 1 : 11

PLANK CLIP TURNED  
90° TO ENGAGE PLANK



DETAIL G  
SCALE 2 : 7



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