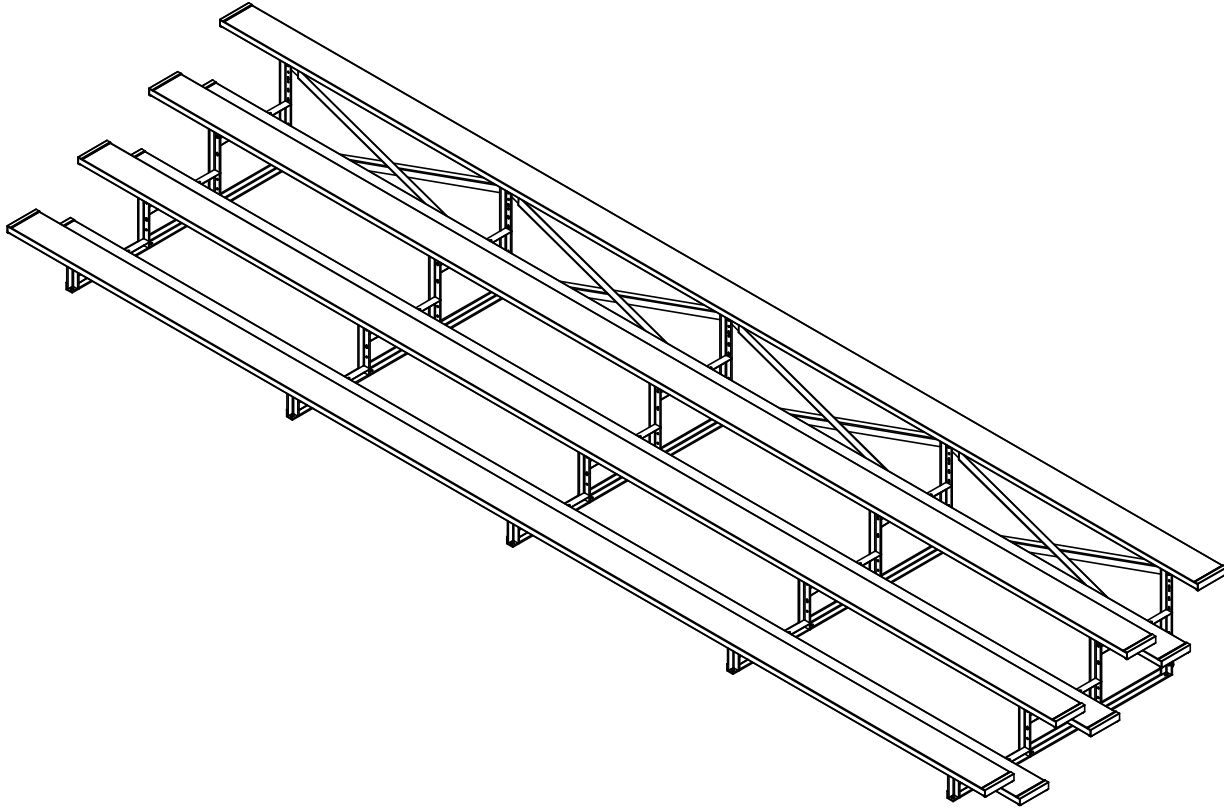


STANDARD 4-ROW 27' BLEACHER

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

Standard Series designed for dependability and trouble-free maintenance. Featuring 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 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. All welds shall be ground smooth.



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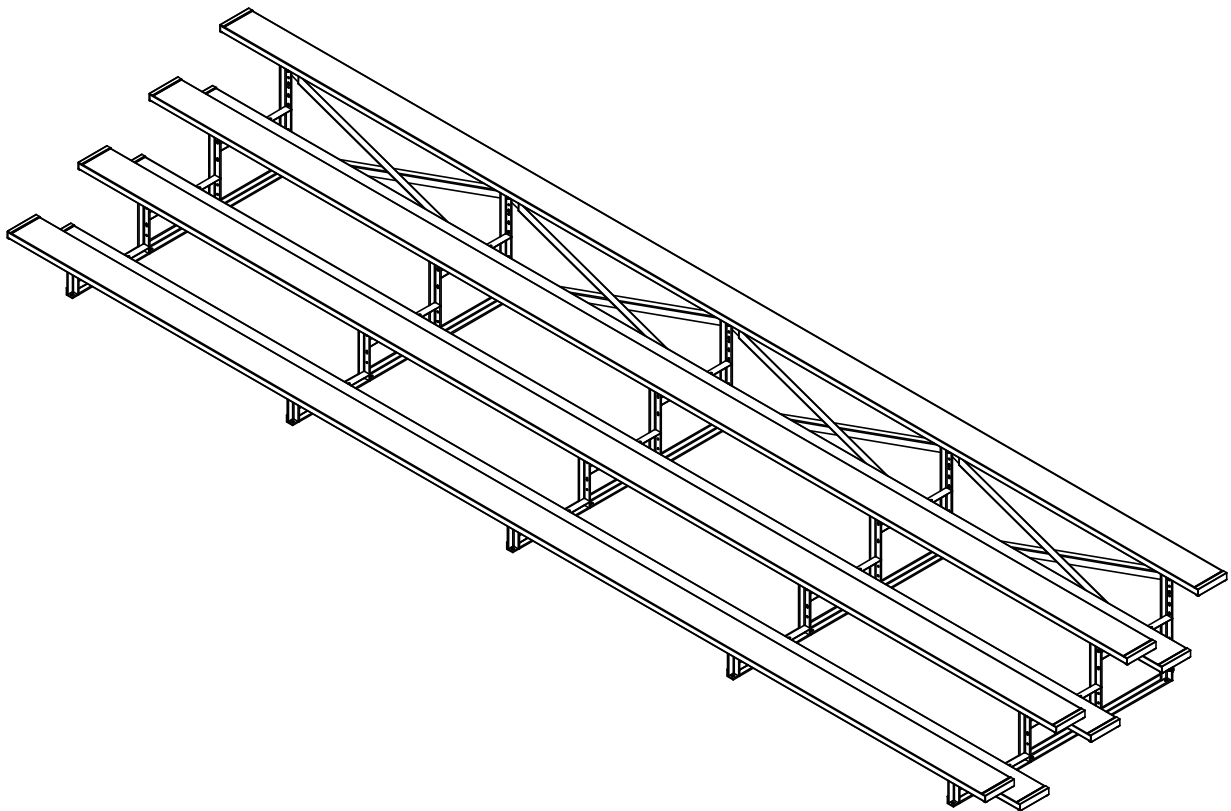
4 ROW STANDARD 27FT

MODEL NO.

1171-427

BOM PARTS & FASTENERS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	ASA-500-1171-415,421,427-A	BLEACHER 4-ROW STANDARD FRAME	5
2	L-0018-1171-1004-79.5-A	STANDARD BLEACHER BRACE 4TH ROW	8
3	PL-1100-324-10-A-A	ALUMINUM PLANK 10"x 324"ANODIZED	4
4	PL-1100-324-10-A-M	ALUMINUM PLANK 10"x 324"DO NOT ANODIZED	3
5	VCIAECP	2"x10" ALUM. END CAP	14
6	VCIALCP	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	HWHB38114	3/8-16 X 1 1/4 GR5 C/S ZINC HEX BOLT (1000)	14
11	HWFLWA38	3/8" Flat Washer	28
12	HWLN38	3/8"-16 LOCK NUT	14
13	HWTEX1034	#10 x 5/8 SELF TAPPING SCREW	28



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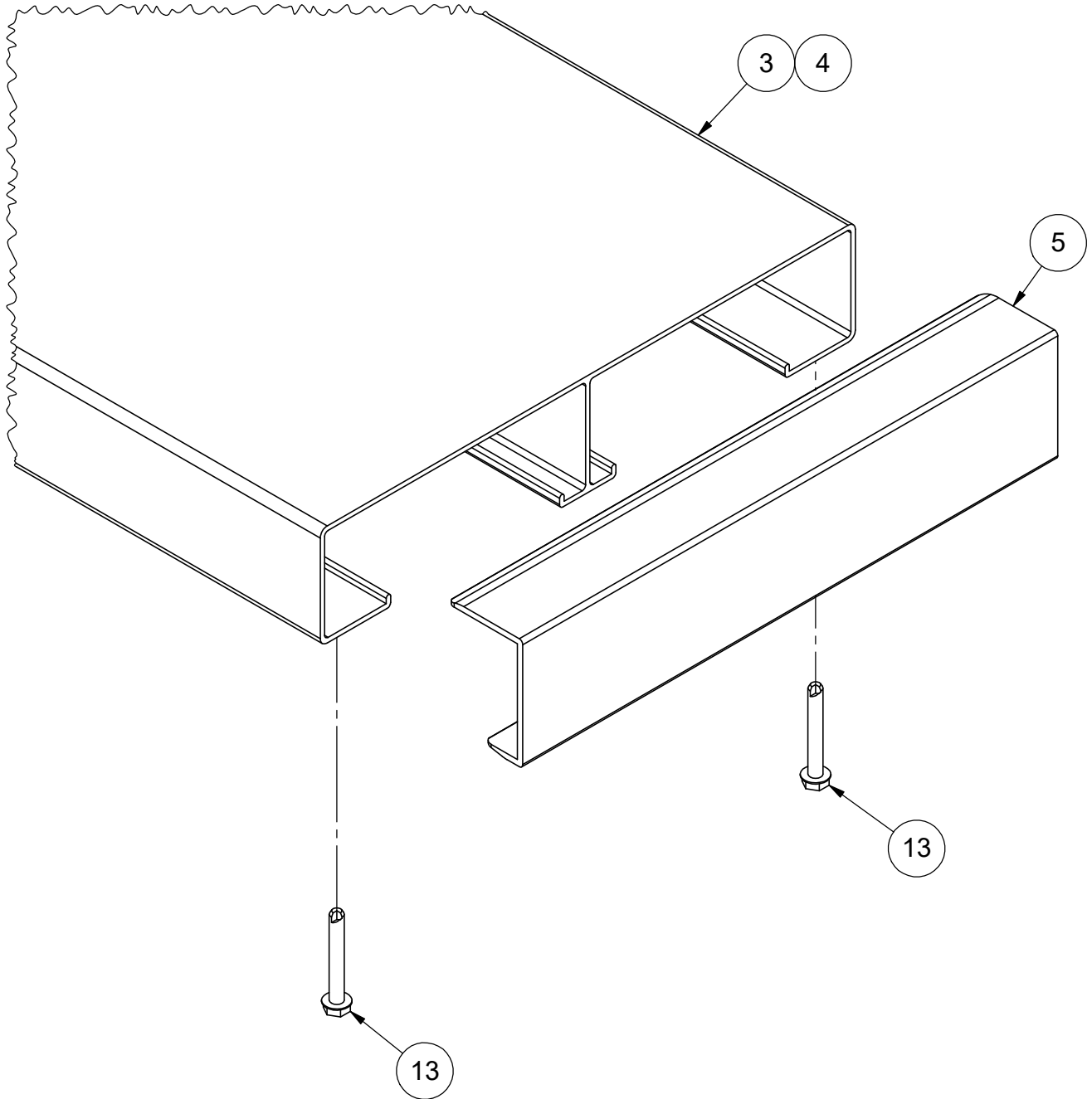
MODEL NO.

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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 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.



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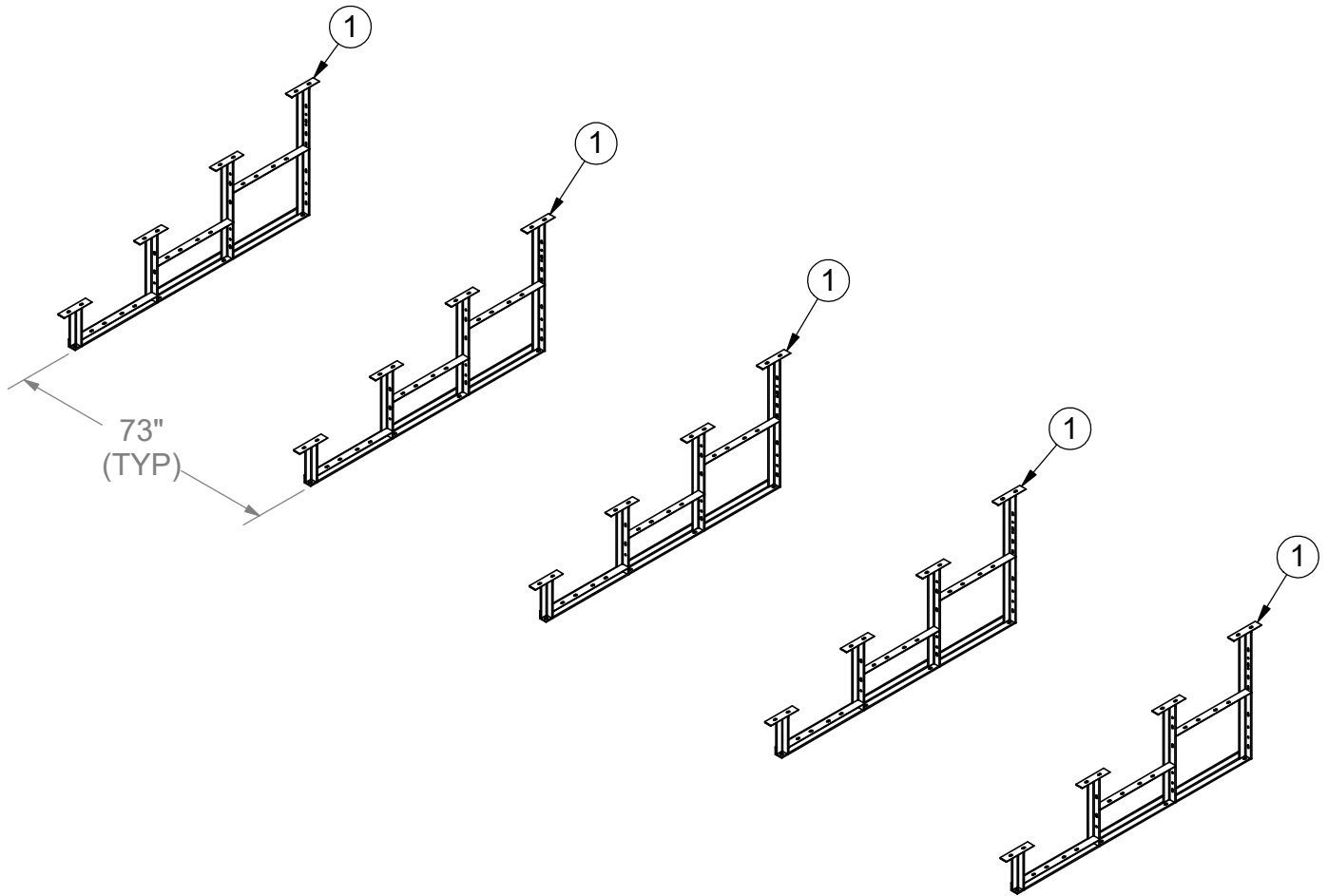
4 ROW STANDARD 27FT

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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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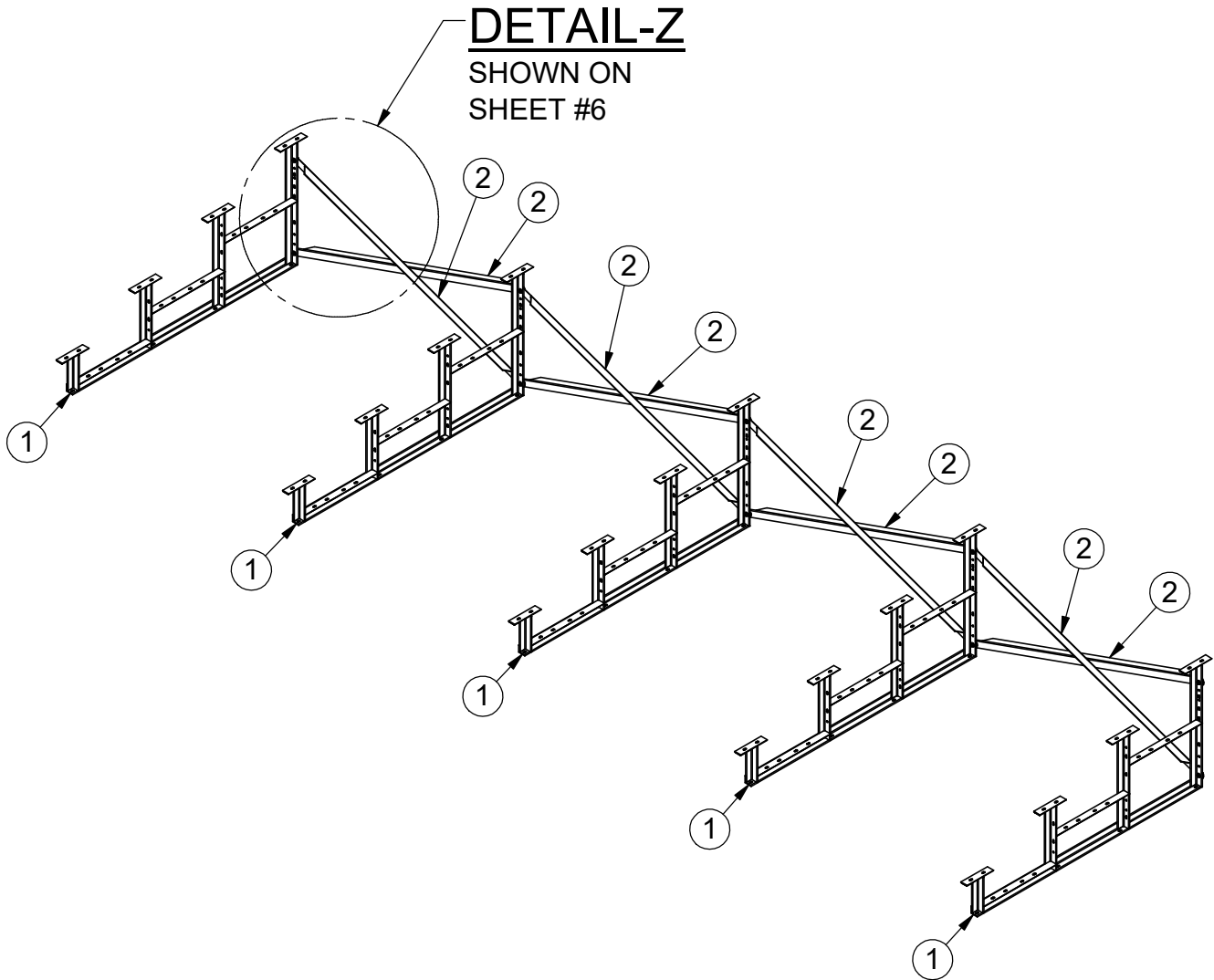
MODEL NO.

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INSTALLATION INSTRUCTIONS:

4) To Install Cross Braces: a) Locate four sets of diagonal braces measuring 2" x 2" x 79 1/2" 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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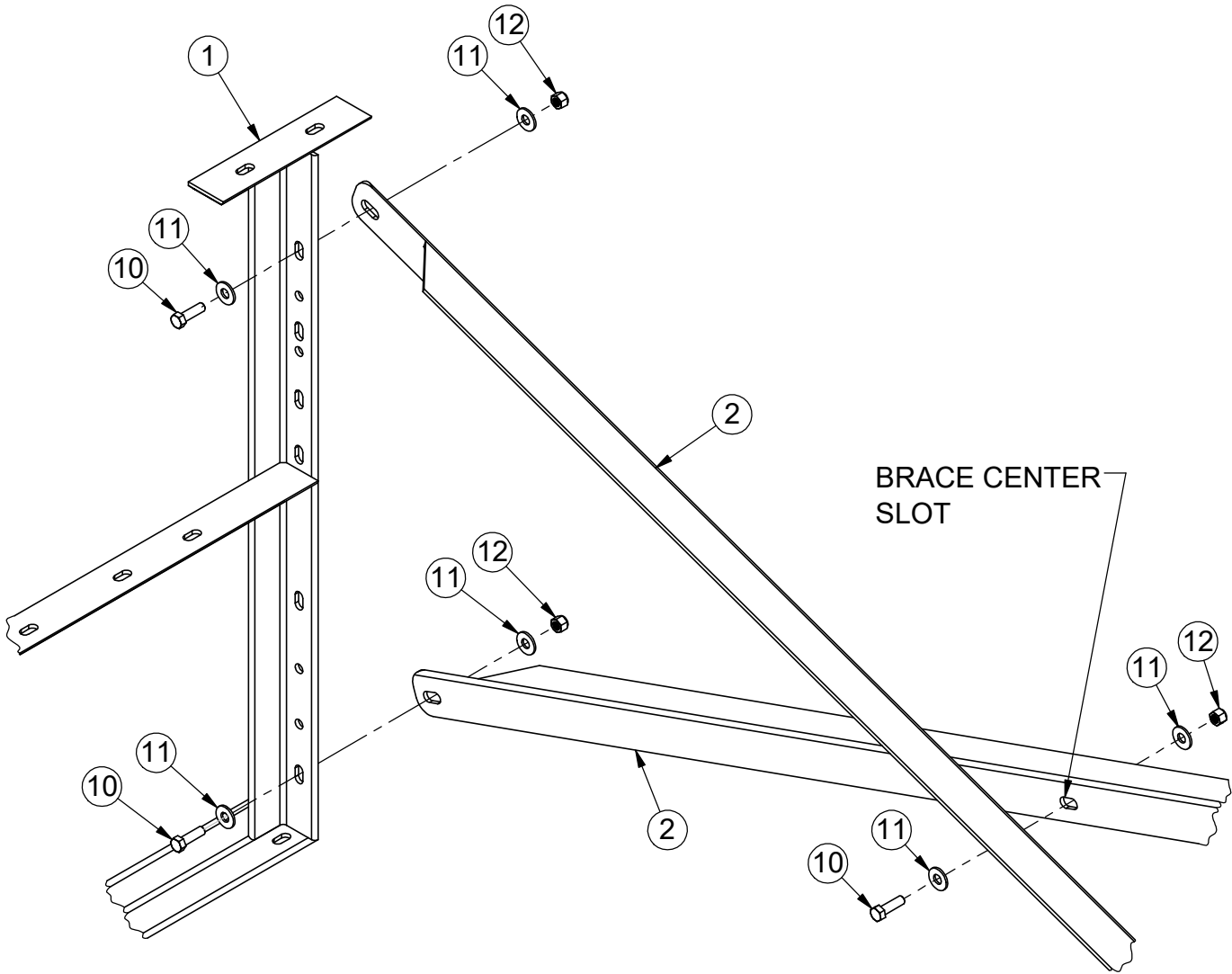
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4 ROW STANDARD 27FT

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DETAIL-Z

ENLARGED
FROM SHEET #5



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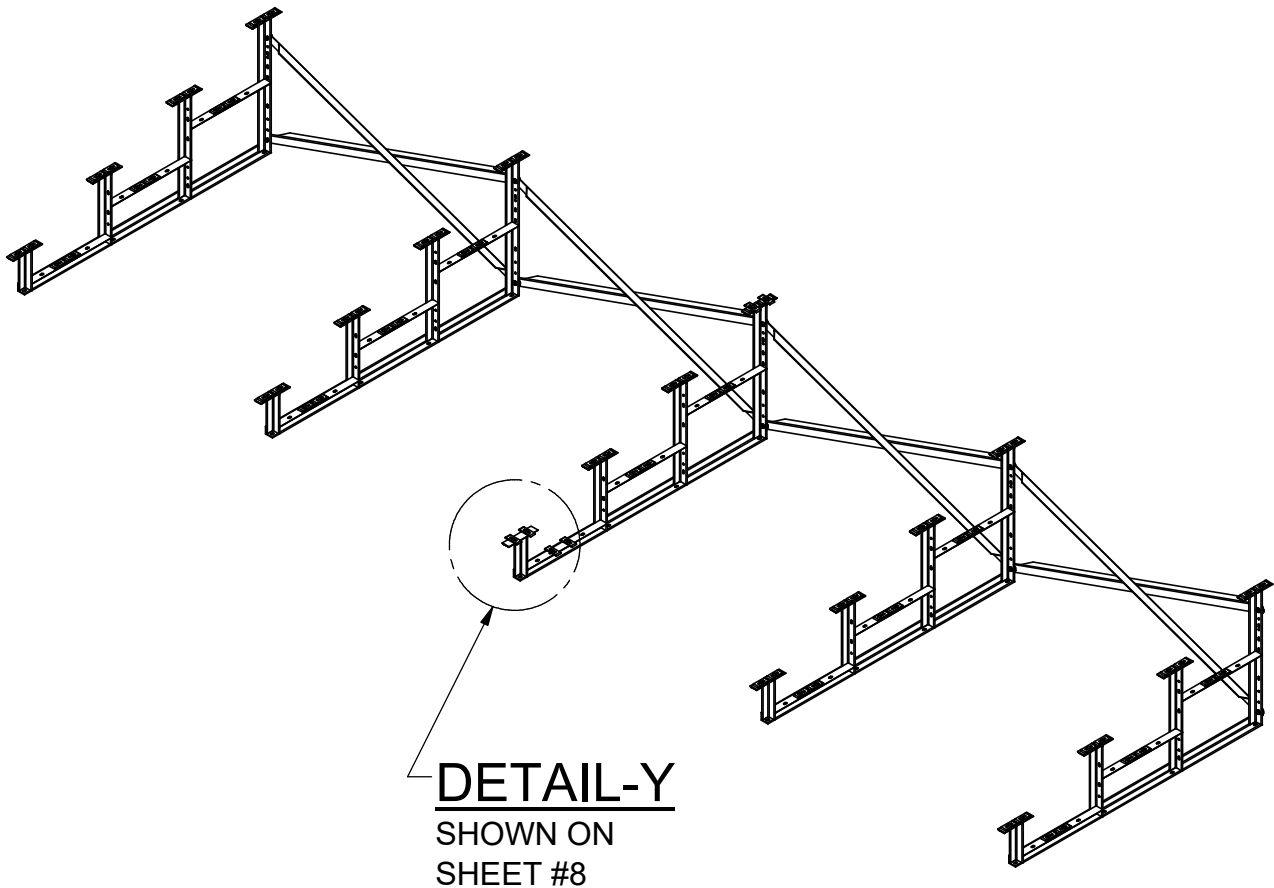
4 ROW STANDARD 27FT

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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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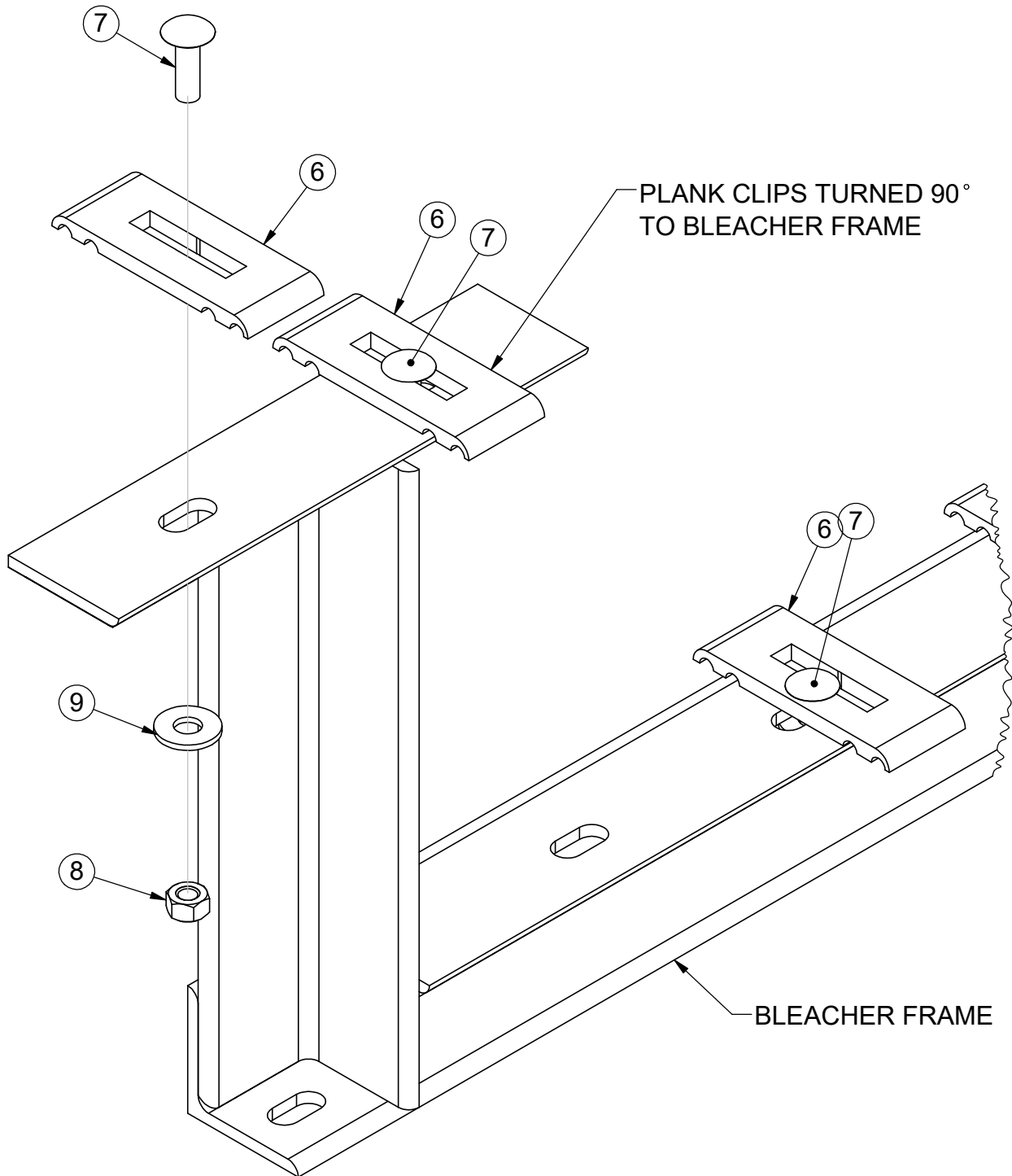
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4 ROW STANDARD 27FT

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DETAIL-Y
 ENLARGED
 FROM SHEET #7



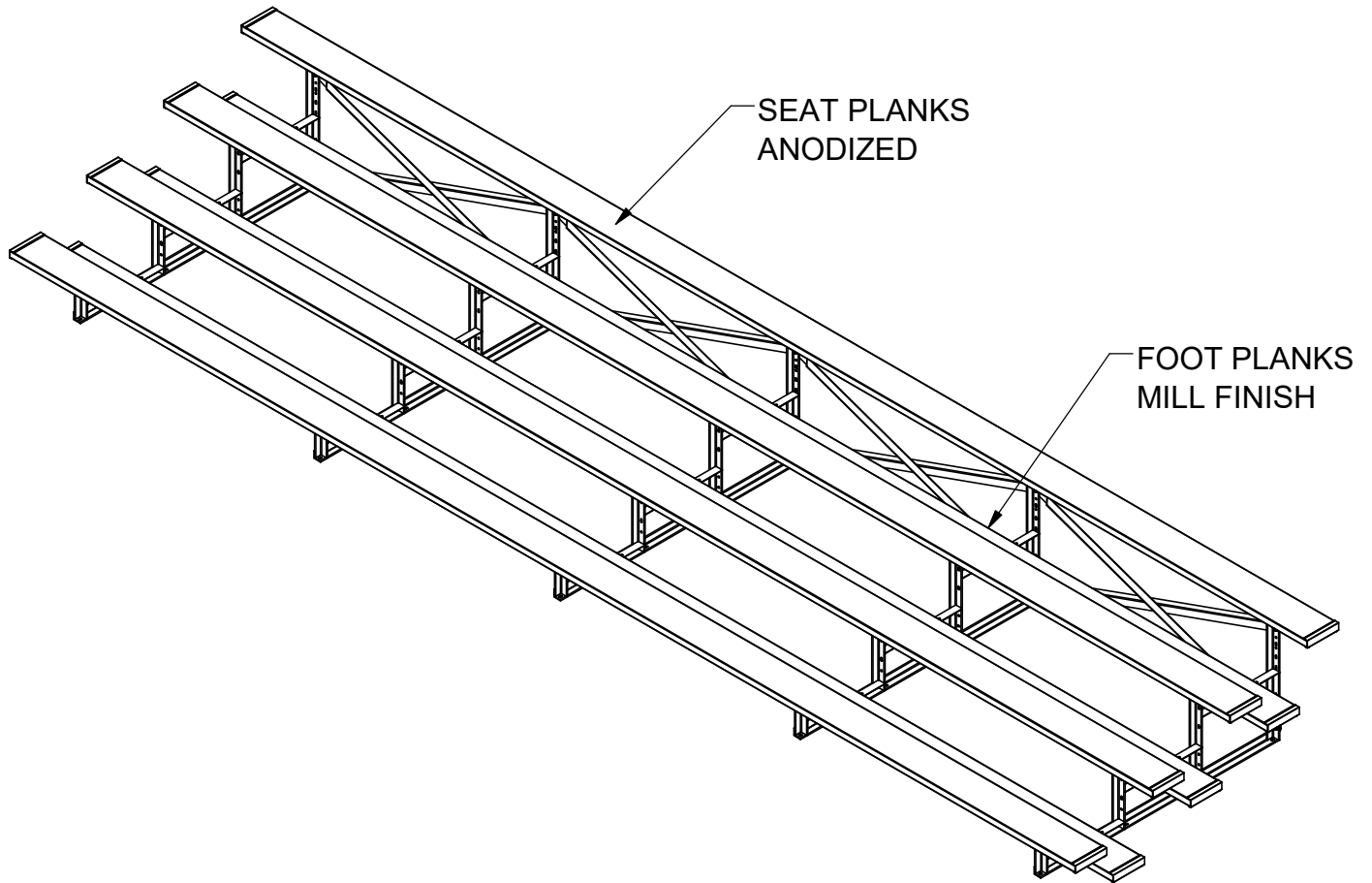
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PRODUCT NAME
4 ROW STANDARD 27FT

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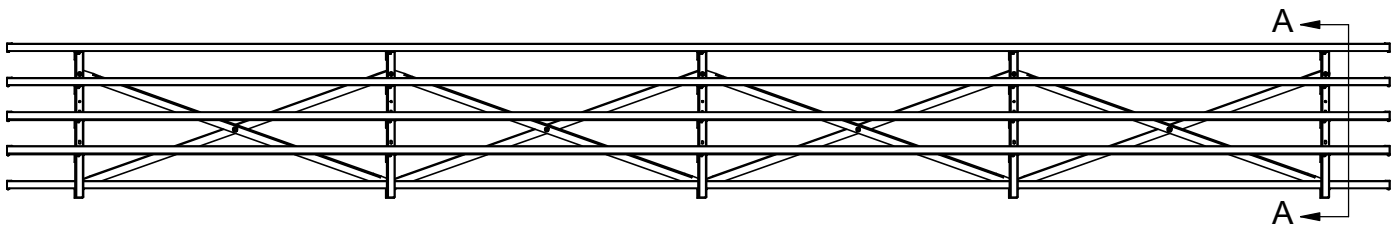
INSTALLATION INSTRUCTIONS:

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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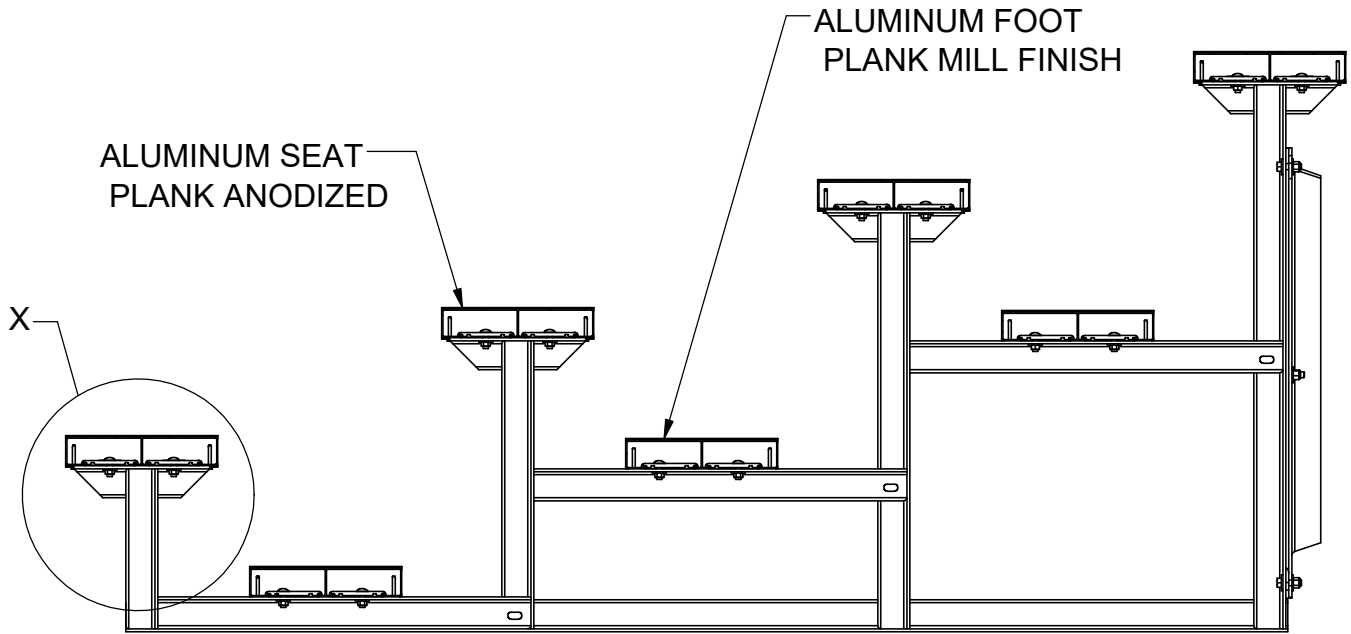
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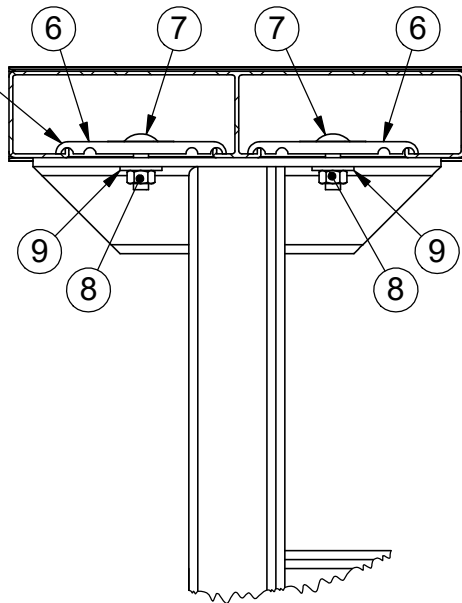
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SECTION A-A

PLANK CLIP TURNED 90° TO ENGAGE PLANK



DETAIL-X
ENLARGED



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MODEL NO.
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