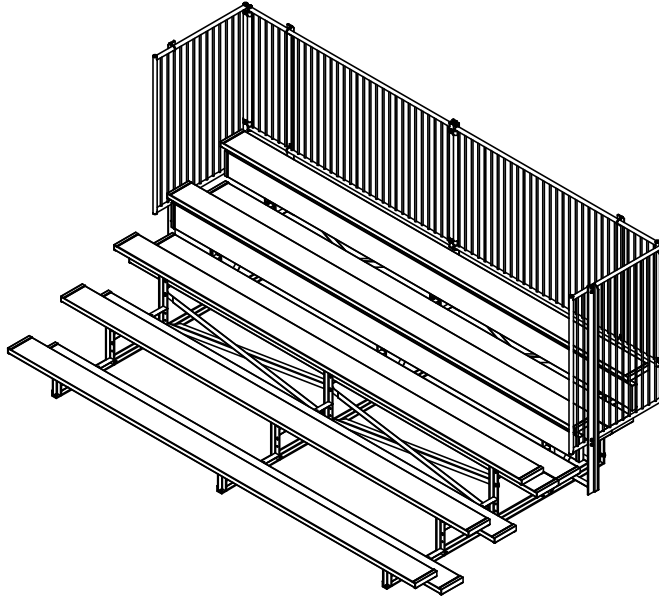


STANDARD SERIES 5-ROW 15' BLEACHER

MODEL 1171-515MESHG 5-ROW 15' STEEL WITH MESH GUARDRAIL
MODEL 1171-515MESH 5-ROW 15' ALUMINUM WITH MESH GUARDRAIL

MODEL 1171-515VBGRG 5-ROW 15' STEEL WITH VBGR GUARDRAIL
MODEL 1171-515VBGRA 5-ROW 15' ALUMINUM WITH VBGR GUARDRAIL
(VBGR = VERTICAL BAR GUARDRAIL)

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.

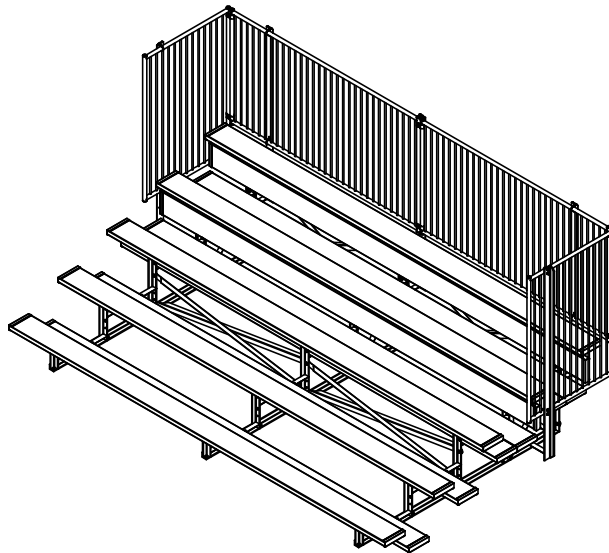
Seat and Foot Planks: Nominal 2" x 10" x 15' extruded, ribbed aluminum. The edges and tops of planks shall be ribbed. The ribbed pattern, non-slip surface, is designed for safety and comfort. All exposed ends shall have aluminum caps fastened to the underside of the plank. Planks secure to each frame 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.

| | | |
|---|-----------------|----------------------------|
|  | Date: 7/26/2017 | PRODUCT NAME |
| | Rev: A | 5 ROW STANDARD 15FT |
| | Drawn: BDYE | MODEL NO. |
| | Sheet: 1 of 16 | 1171-515 |

BOM PARTS & FASTENERS

| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|----------------------------|---|------|
| 1 | ASA-500-1171-515,521,527-A | BLEACHER 5-ROW STANDARD FRAME | 3 |
| 2 | ASA-0510-1100-1000-G | RIGHT F-FRAME PANEL SUPPORT | 1 |
| 3 | ASA-0511-1100-1000-G | REAR F-FRAME PANEL SUPPORT | 3 |
| 4 | ASA-0512-1100-1000-G | LEFT F-FRAME PANEL SUPPORT | 1 |
| 5 | ASA-0514-1100-1000-G | RAILING SIDE PANEL | 2 |
| 6 | ASA-0515-1100-1000-G | RAILING LONG REAR PANEL | 2 |
| 7 | L-0019-1171-1005-83.375-A | STANDARD BLEACHER BRACE 5TH ROW | 4 |
| 8 | L-0020-1171-1003-76-A | STANDARD BLEACHER BRACE 3RD ROW | 4 |
| 9 | PL-1100-180-10-A-A | ALUMINUM PLANK ANODIZED 10"x 180" | 5 |
| 10 | PL-1100-180-10-A-M | ALUMINUM PLANK 10"x 180" | 8 |
| 11 | VCIAECP | 2"x10" ALUM. END CAP | 26 |
| 12 | VCIACLP | BOLT CLIP FOR 10" & 12" ALUMINUM PLANK | 78 |
| 13 | PL-0043-1000-G | PANEL CLAMP | 10 |
| 14 | HWCB5161 | 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC | 66 |
| 15 | HWCB5163 | 5/16-18 X 3 CARRIAGE BOLT ZINC (600) | 12 |
| 16 | HWCB38212 | 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) | 6 |
| 17 | HWUB516112 | 5/16 X 1-1/2 X 2-11/16 U BOLT | 8 |
| 18 | HWFLWA516 | 5/16 FLAT WASHER | 98 |
| 19 | HWLN516 | 5/16 NYLOK NUT ZINC | 98 |
| 20 | HWFLWA38 | 3/8" Flat Washer | 65 |
| 21 | HWLN38 | 3/8"-16 LOCK NUT | 37 |
| 22 | HWHB38114 | 3/8-16 X 1 1/4 GR5 C/S ZINC HEX BOLT (1000) | 31 |
| 23 | HWTEX1034 | #10 x 5/8 SELF TAPPING SCREW | 52 |



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 2 of 16

PRODUCT NAME

5 ROW STANDARD 15FT

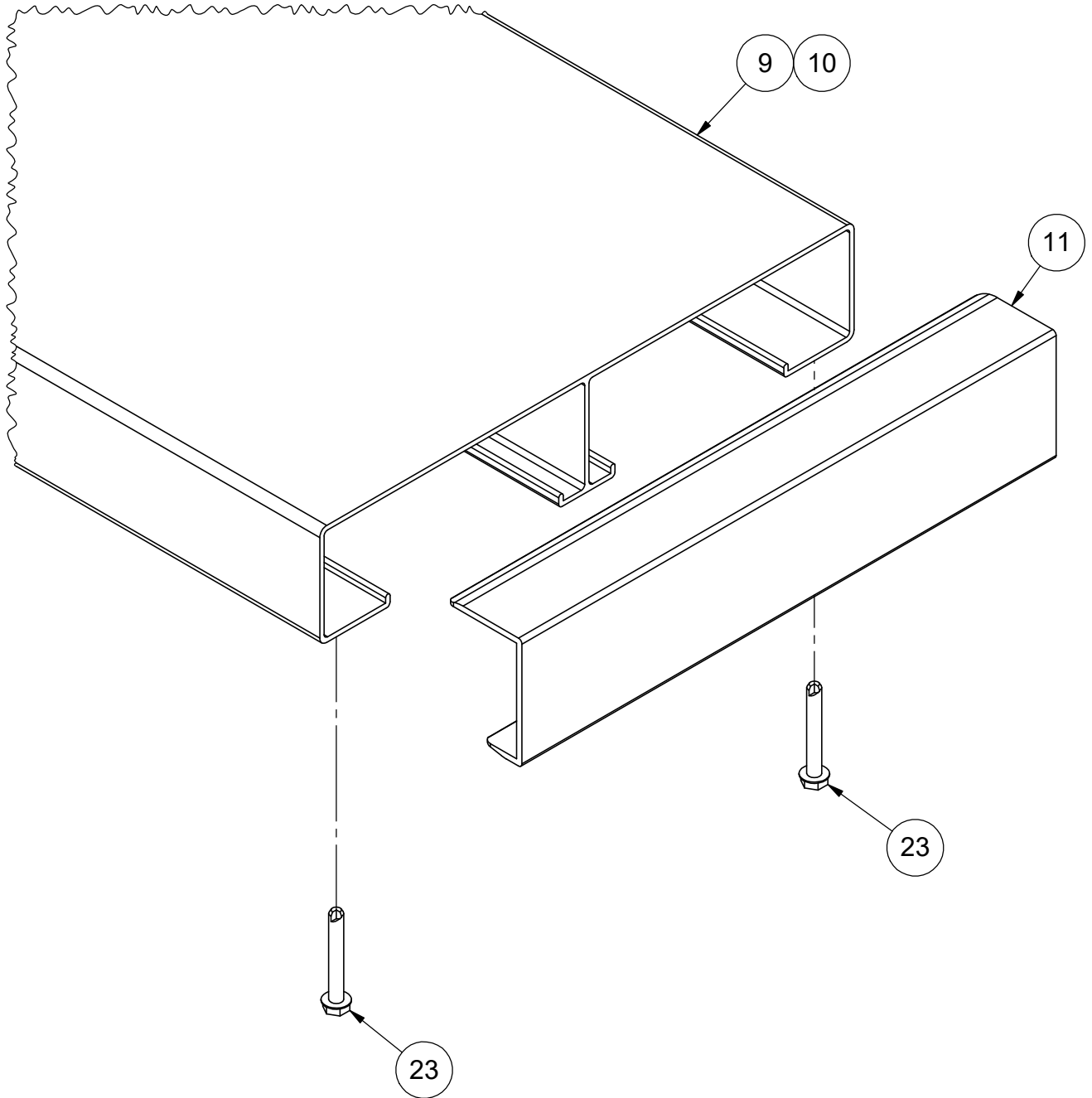
MODEL NO.

1171-515

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(11) . Align and assemble all end caps to aluminum planks. Secure using #10 x 3/4" Item(23) self-tapping screw in two locations on the underside of the clip/plank.



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 3 of 16

PRODUCT NAME

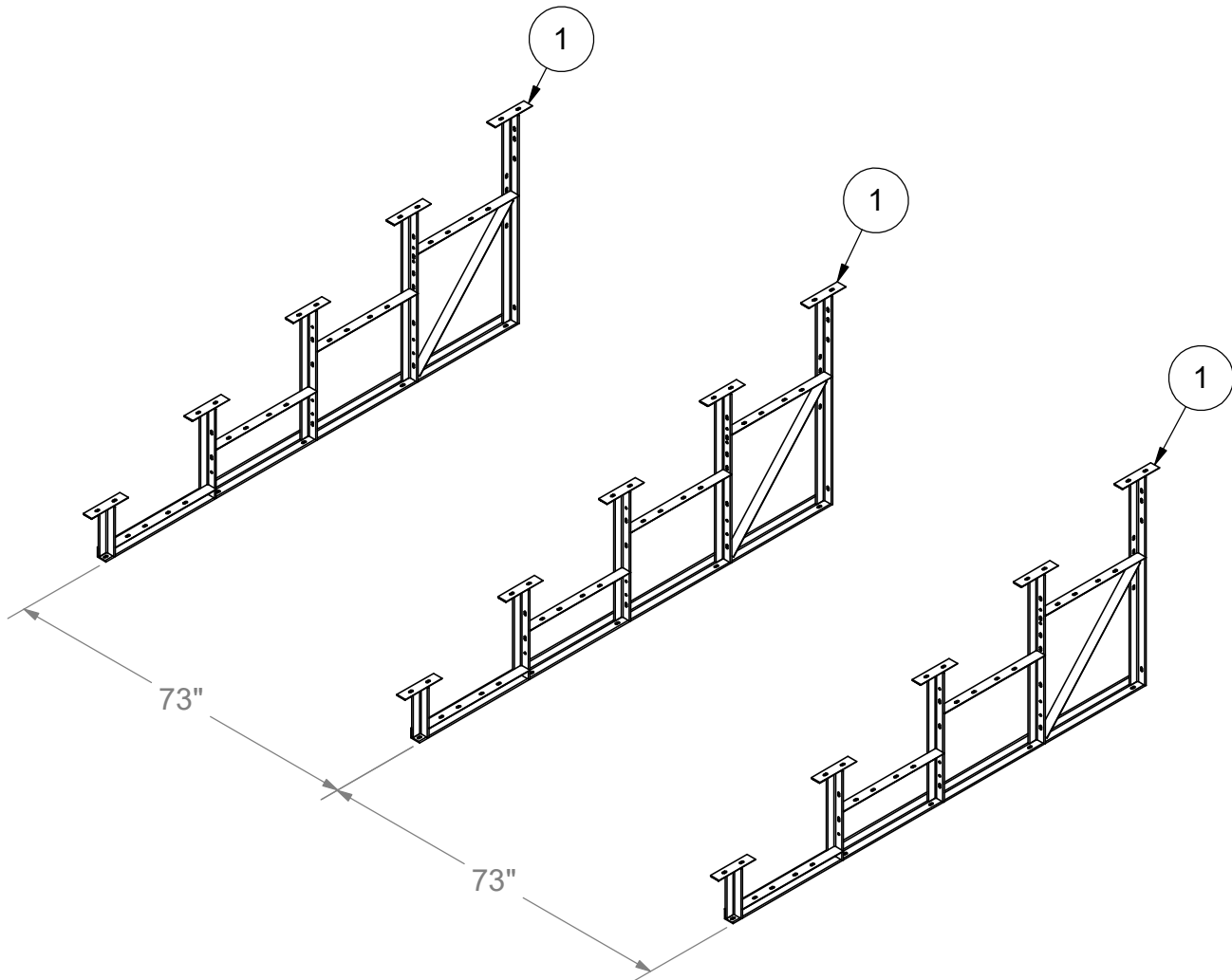
5 ROW STANDARD 15FT

MODEL NO.

1171-515

INSTALLATION INSTRUCTIONS:

3) Locate the three Bleacher 5-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 16

PRODUCT NAME

5 ROW STANDARD 15FT

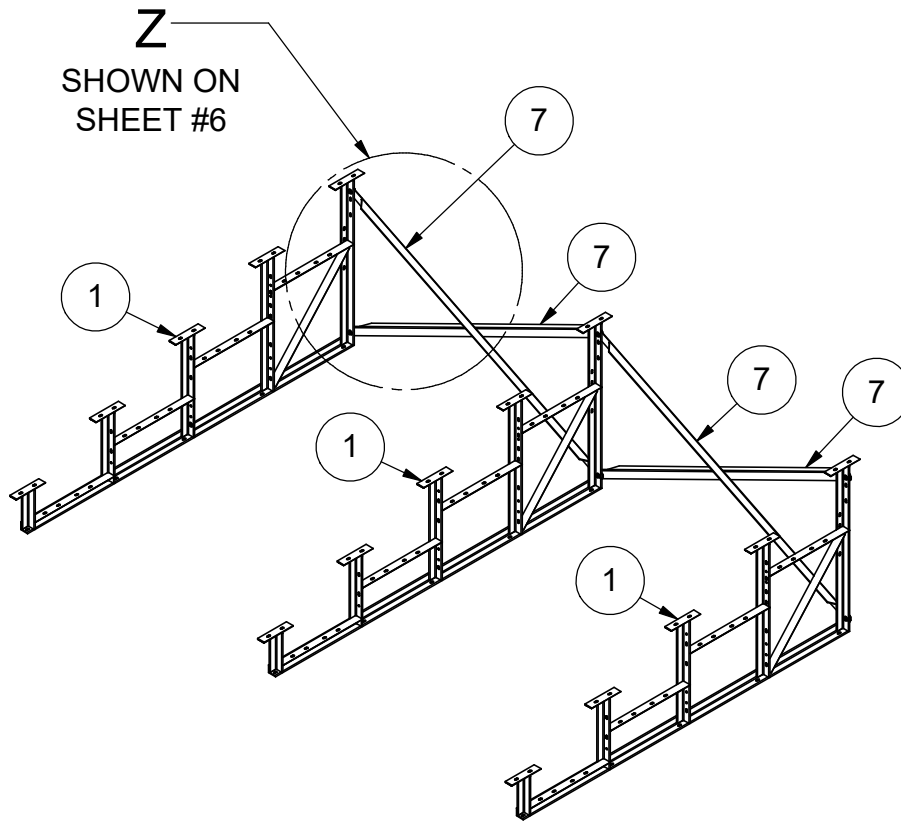
MODEL NO.

1171-515

INSTALLATION INSTRUCTIONS:

4) To Install Cross Braces: a) Locate two sets of diagonal braces measuring 2" x 2" x 83 3/8" Item (7) . Install on the backside of the Bleacher Frames using 3/8" x 1-1/4" Hex Bolt Item (22) , Washers Item (20) , and Lock Nut Item (21) 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

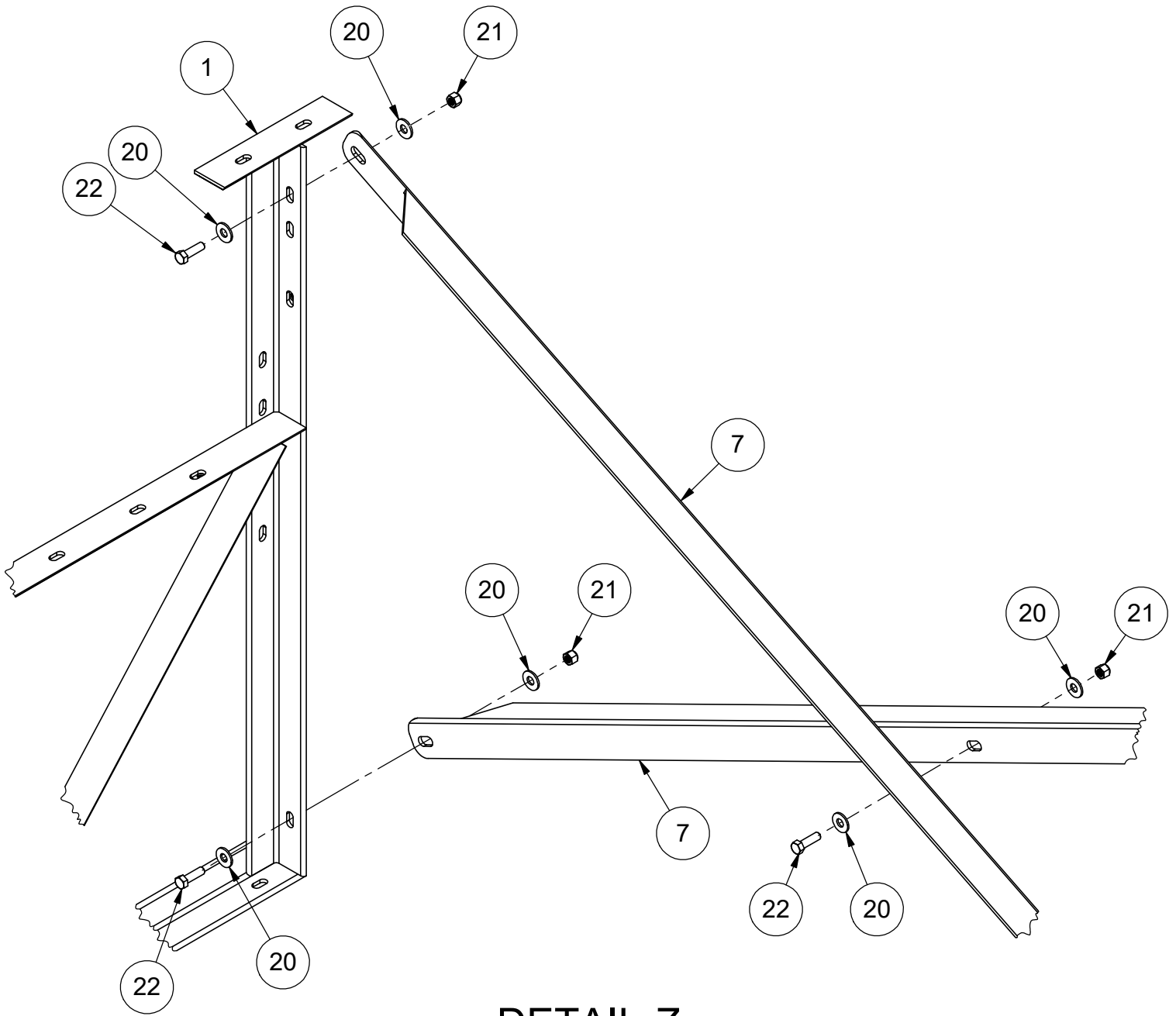
Sheet: 5 of 16

PRODUCT NAME

5 ROW STANDARD 15FT

MODEL NO.

1171-515



DETAIL-Z

ENLARGED
FROM SHEET #5



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 6 of 16

PRODUCT NAME

5 ROW STANDARD 15FT

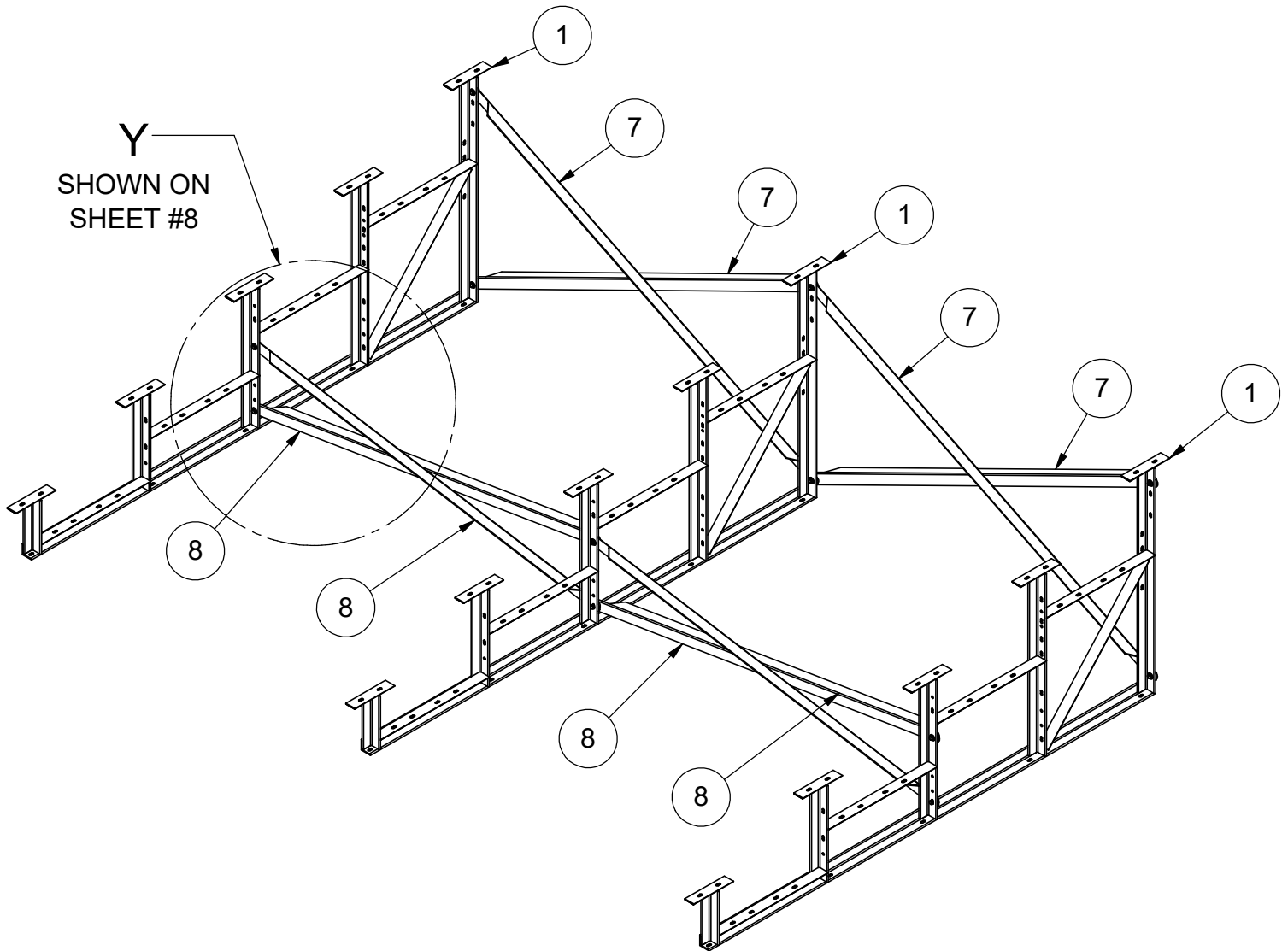
MODEL NO.

1171-515

INSTALLATION INSTRUCTIONS:

5) To Install Cross Braces: a) Locate seven of diagonal braces measuring 2" x 2" x 76" Item (8) . Install on the backside of the third row of Bleacher Frames using 3/8" x 1-1/4" Hex Bolt Item (22) , Washers Item (20) , and lock nut Item (21) for the top, bottom slots and center between Braces. Repeat steps to assemble remaining three 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

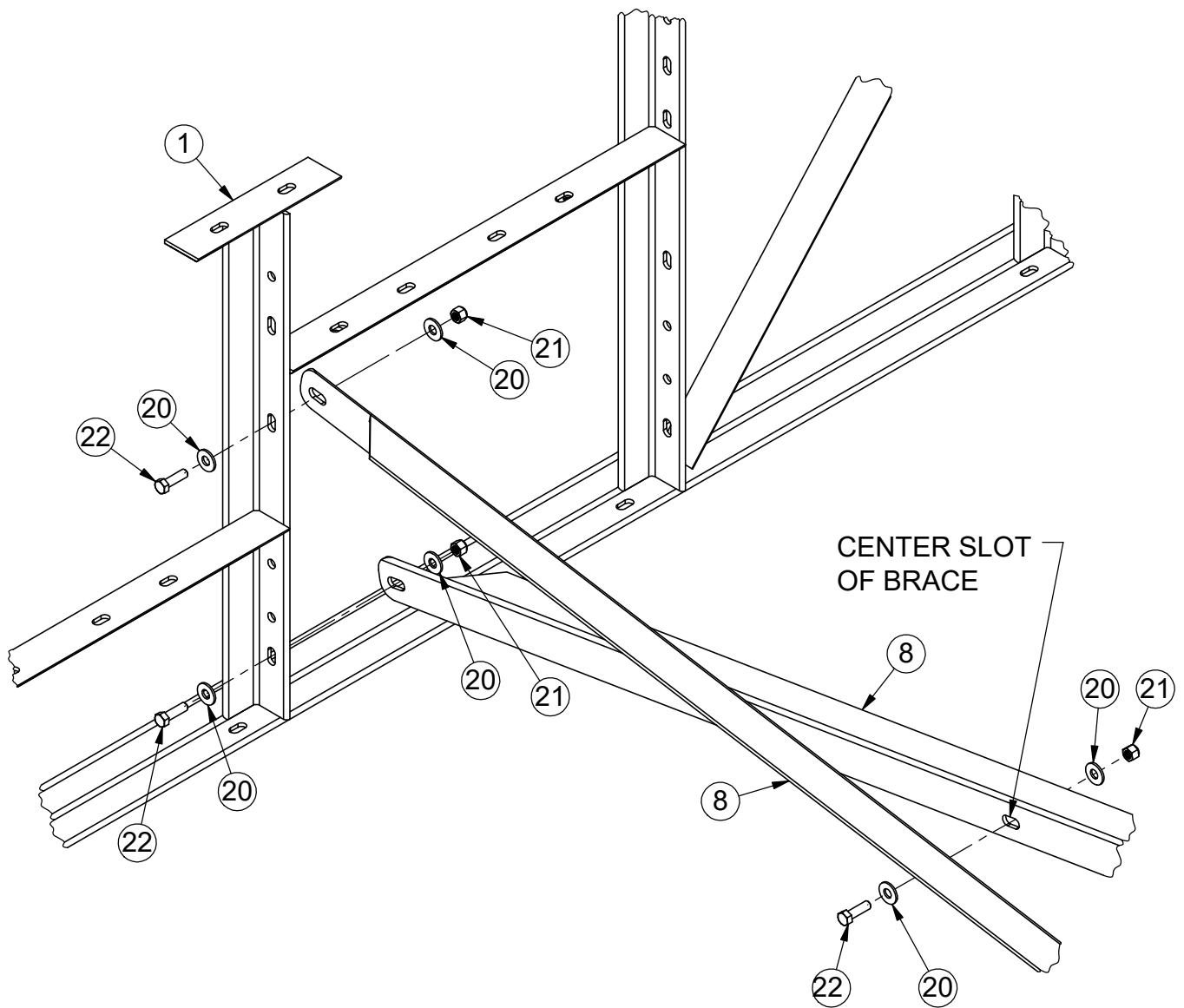
Sheet: 7 of 16

PRODUCT NAME

5 ROW STANDARD 15FT

MODEL NO.

1171-515



DETAIL-Y
 ENLARGED
 FROM SHEET #7



Date: 7/26/2017
 Rev: A
 Drawn: BDYE
 Sheet: 8 of 16

PRODUCT NAME

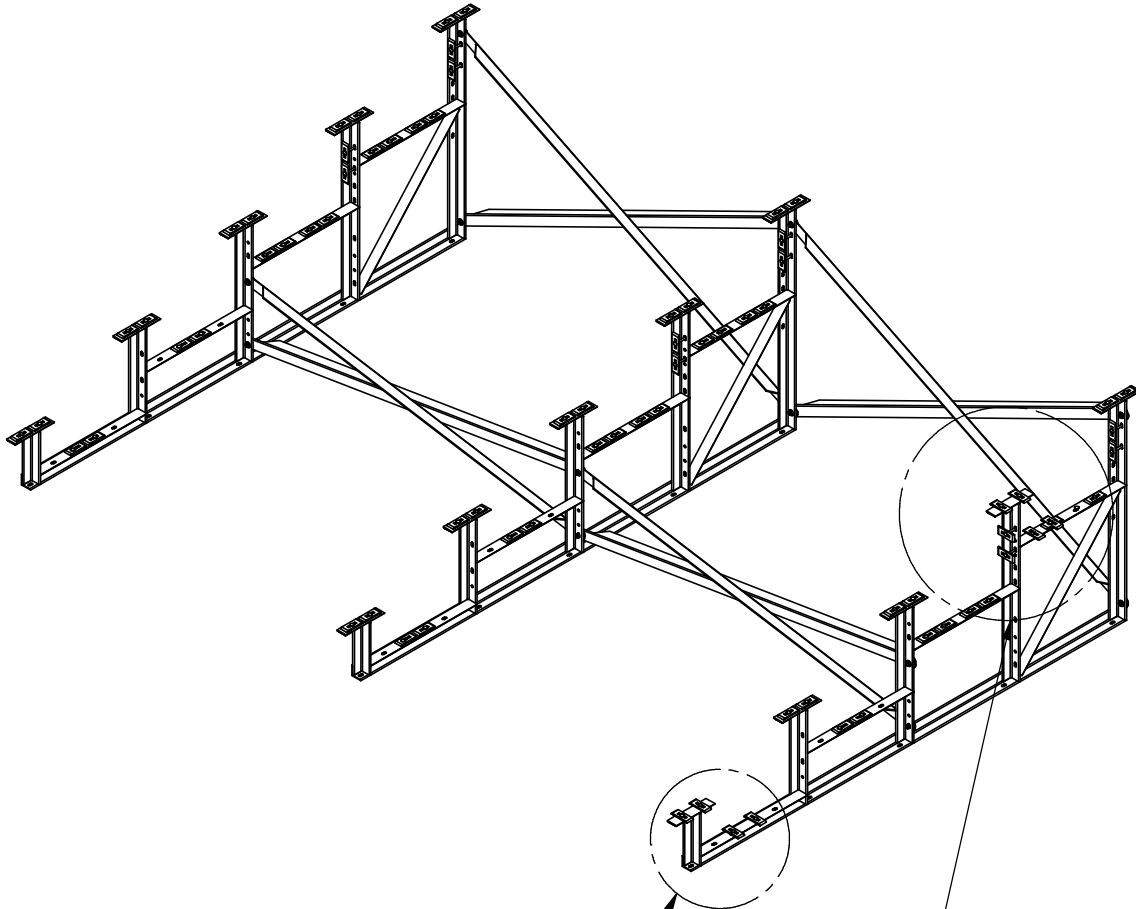
5 ROW STANDARD 15FT

MODEL NO.

1171-515

INSTALLATION INSTRUCTIONS:

6) To Install Seat and Foot Planks: a) First install the Bolt Clip For 10" & 12" Aluminum Plank Item (12) using 5/16" x 1" carriage bolts Item (14), washer Item (18), and lock nuts (19) on top of the seat and foot board supports. To install clips for riser planks using 5/16" x 3" carriage bolts Item (15), washer Item (18), and lock nuts (19). Give nuts about 3/4 turn (just enough to secure). Turn Bolt Clips Item (12) perpendicular to the frames.



DETAIL-W
SHOWN ON
SHEET # 10

DETAIL-X
SHOWN ON
SHEET # 10



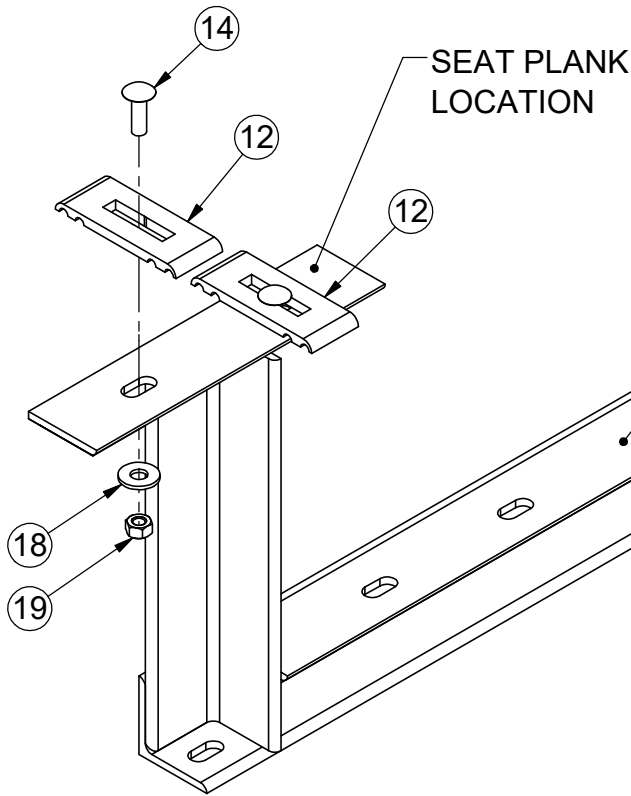
Date: 7/26/2017
Rev: A
Drawn: BDYE
Sheet: 9 of 16

PRODUCT NAME

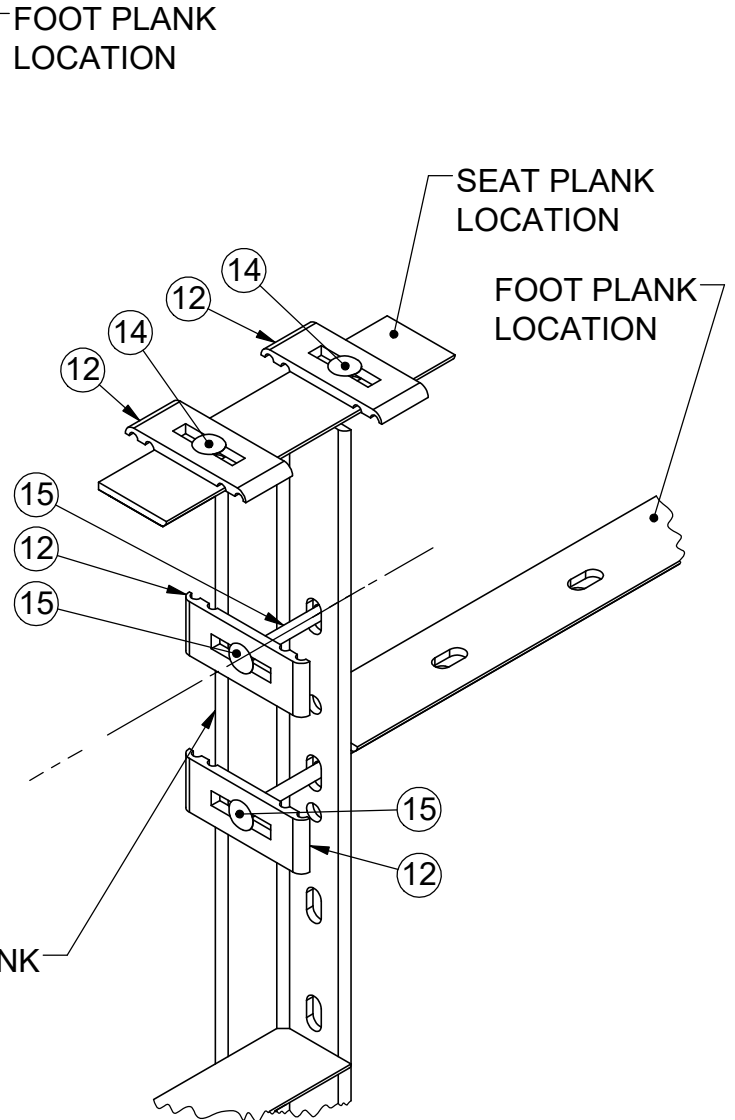
5 ROW STANDARD 15FT

MODEL NO.

1171-515



DETAIL-W
 ENLARGED
 FROM SHEET #9



DETAIL-X
 ENLARGED
 FROM SHEET #9

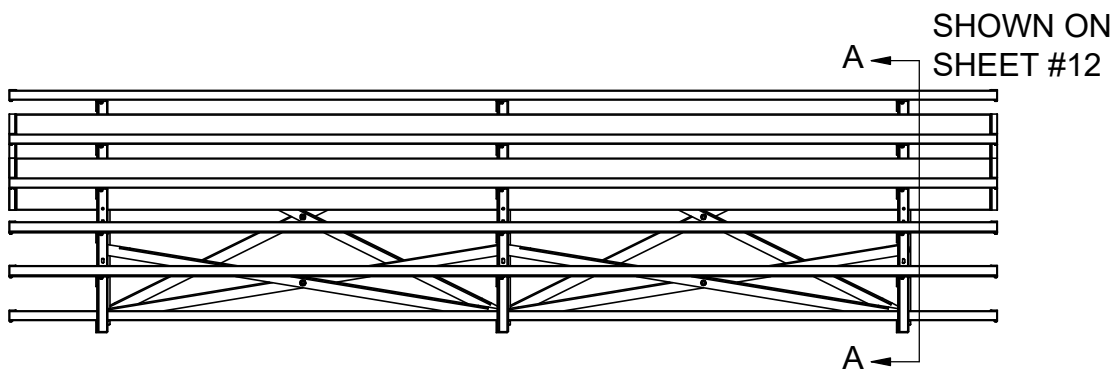
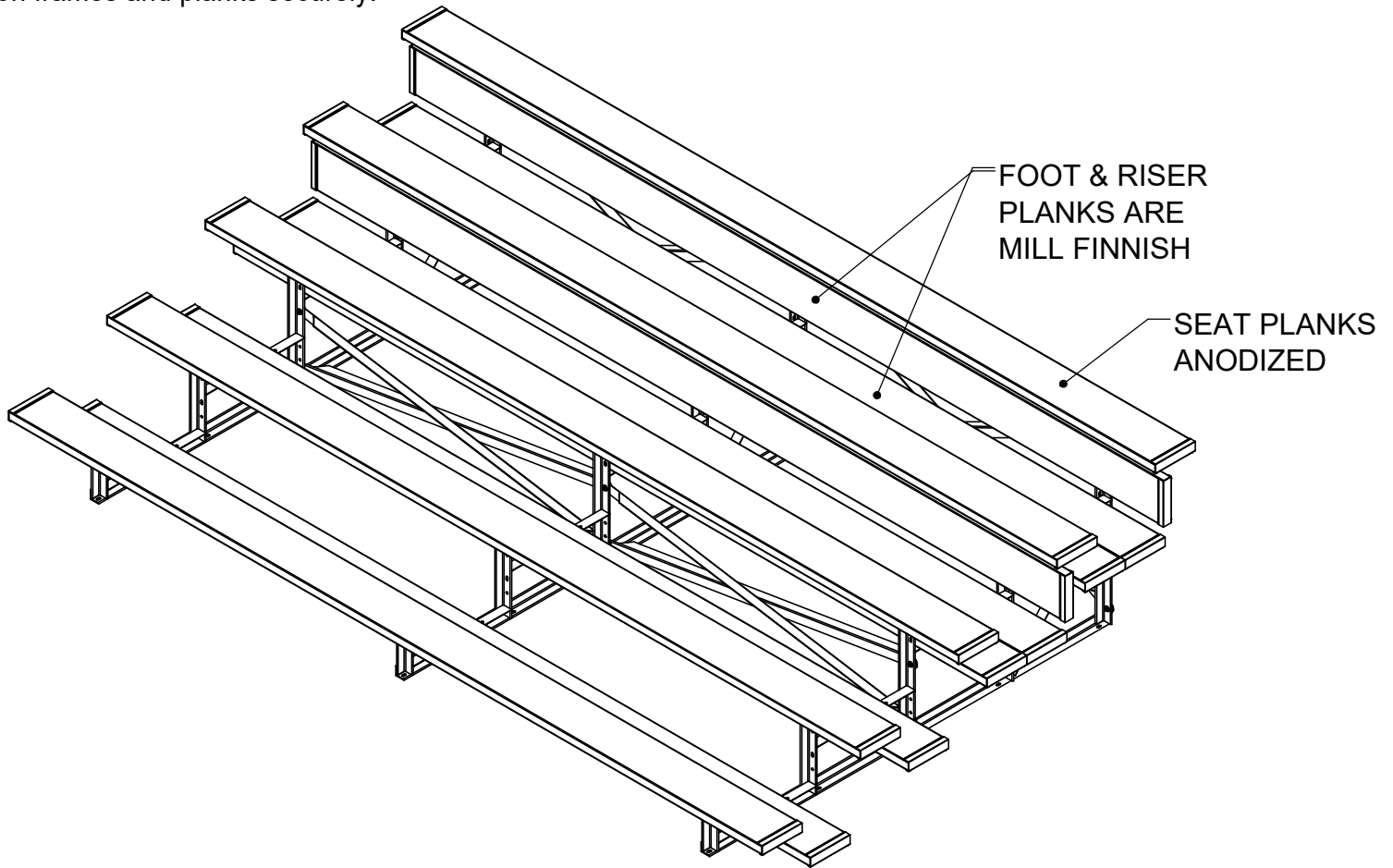


Date: 7/26/2017
 Rev: A
 Drawn: BDYE
 Sheet: 10 of 16

PRODUCT NAME
5 ROW STANDARD 15FT
 MODEL NO.
1171-515

INSTALLATION INSTRUCTIONS:

7) Position seat Planks, Foot Planks and Riser Planks on the supports so the Bolt Clips Item (12) 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 (12) 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.



FRONT VIEW



Date: 7/26/2017

Rev: A

Drawn: BDYE

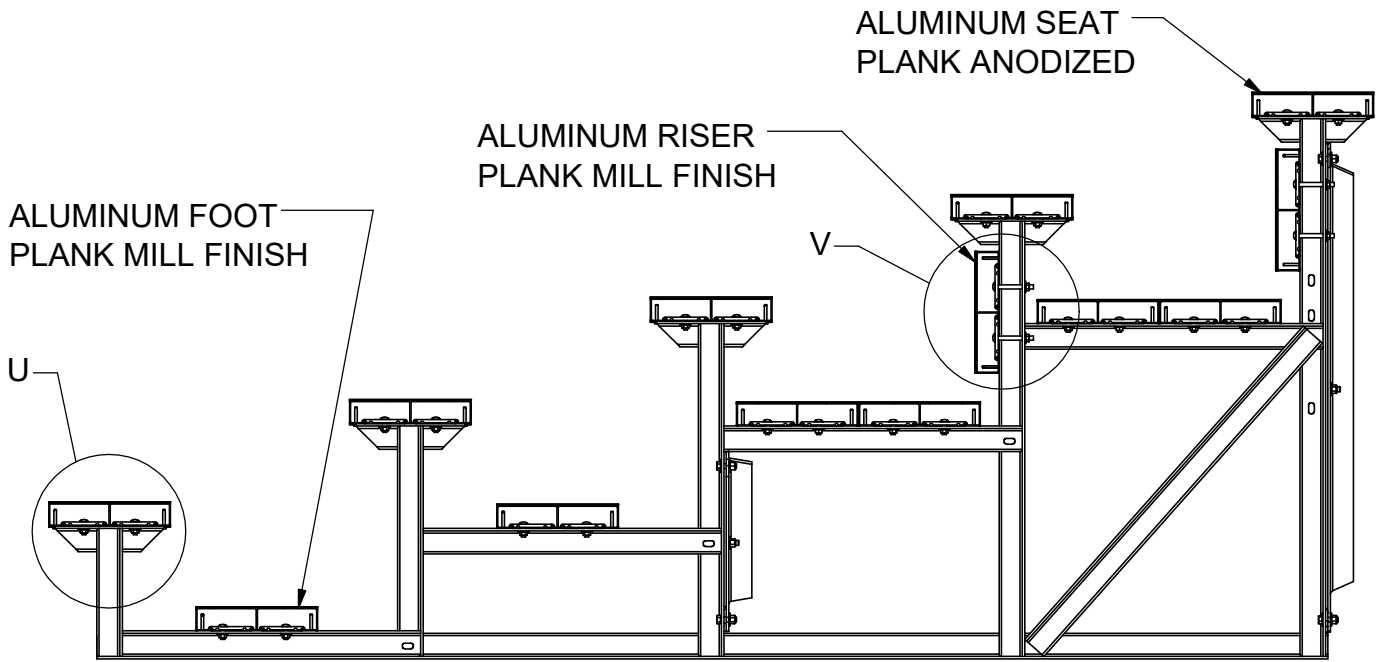
Sheet: 11 of 16

PRODUCT NAME

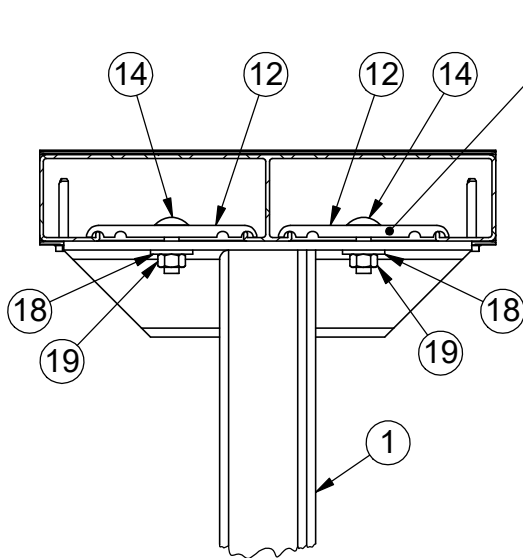
5 ROW STANDARD 15FT

MODEL NO.

1171-515



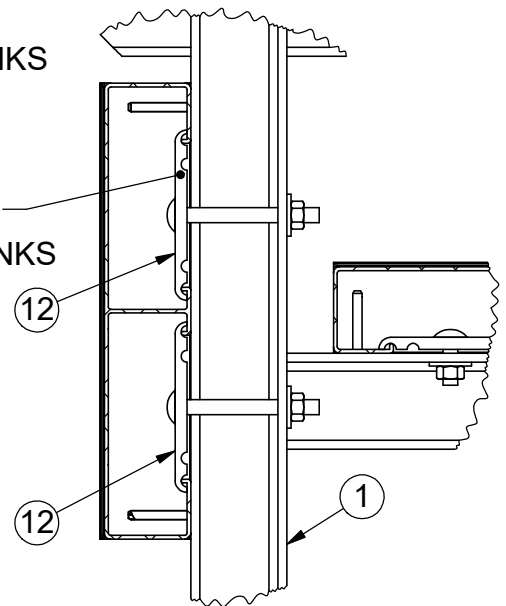
SECTION A-A
FROM SHEET #11



DETAIL U
ENLARGED

BLOT CLIPS TURNED
90° TO ENGAGE PLANKS

BLOT CLIPS TURNED
90° TO ENGAGE PLANKS



DETAIL V
ENLARGED



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 12 of 16

PRODUCT NAME

5 ROW STANDARD 15FT

MODEL NO.

1171-515

INSTALLATION INSTRUCTIONS:

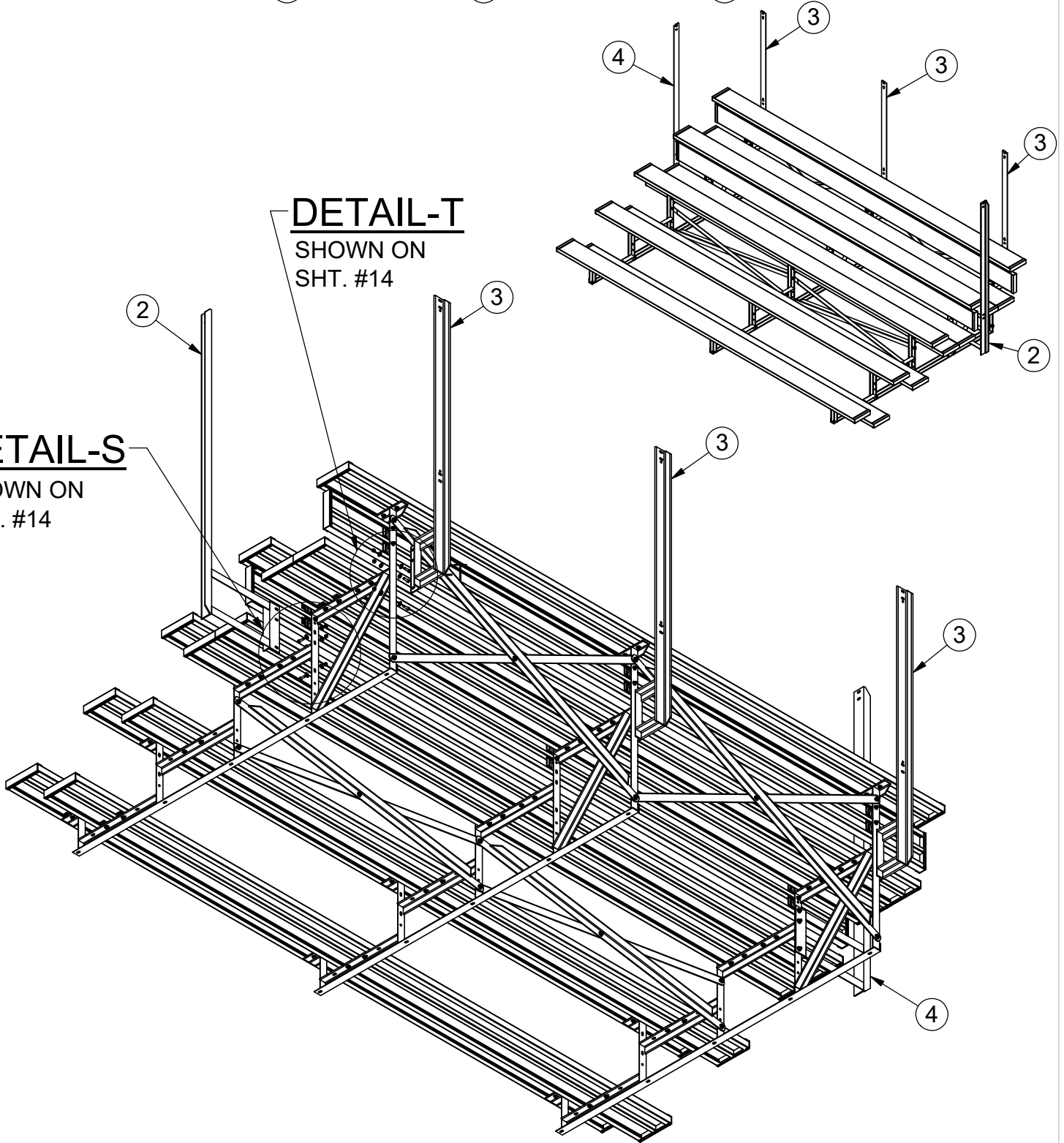
8) Install Right, Left and Rear F-Frame Panel Support Items (2) (3) (4) . Attach to Bleacher Frames with 3/8" x 1-1/4" hex bolts Item(22) , washers Item(20) and lock nuts Item(21) .

DETAIL-T

SHOWN ON
SHT. #14

DETAIL-S

SHOWN ON
SHT. #14



Date: 7/26/2017

Rev: A

Drawn: BDYE

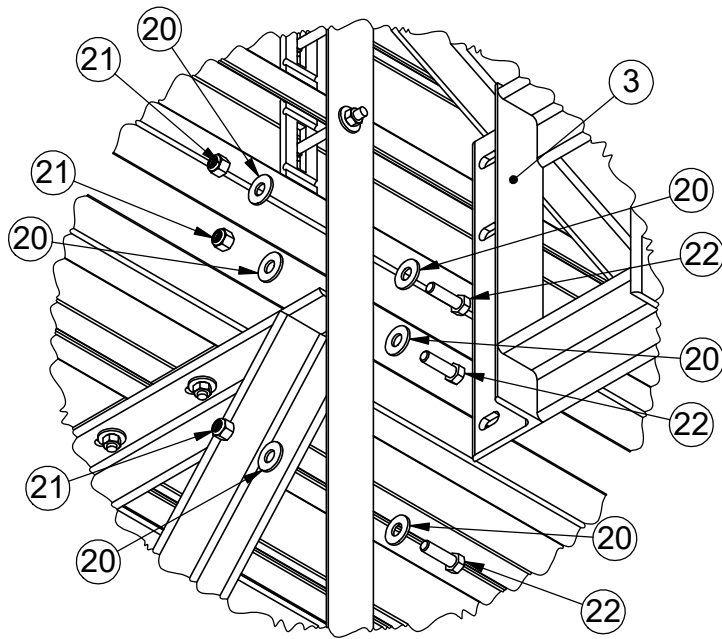
Sheet: 13 of 16

PRODUCT NAME

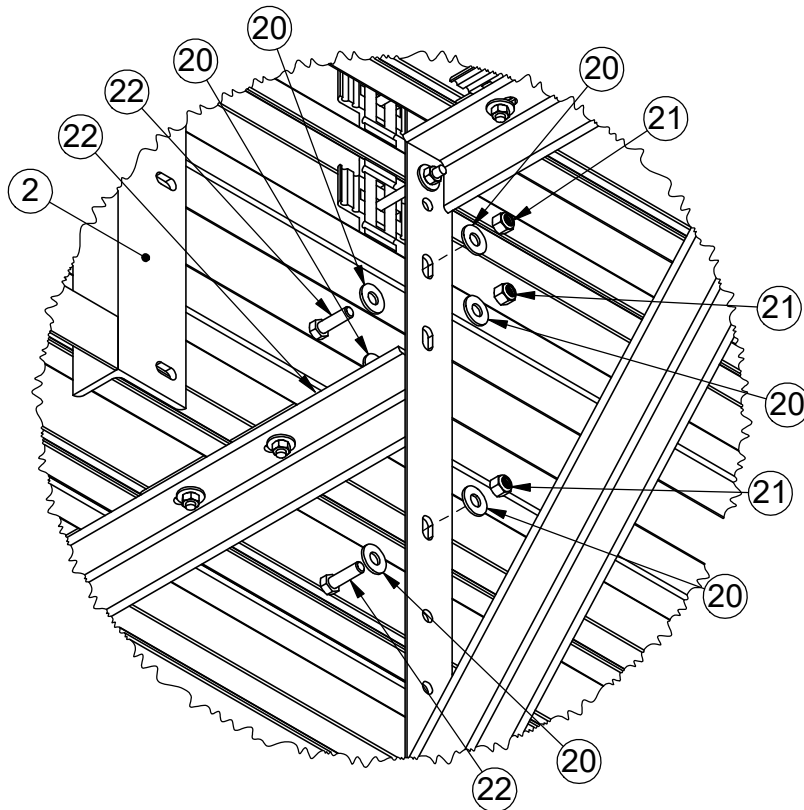
5 ROW STADARD 15FT

MODEL NO.

1171-515



DETAIL-T
ENLARGED



DETAIL-S
ENLARGED



Date: 7/26/2017

Rev: A

Drawn: BDYE

Sheet: 14 of 16

PRODUCT NAME

5 ROW STADARD 15FT

MODEL NO.

1171-515

INSTALLATION INSTRUCTIONS:

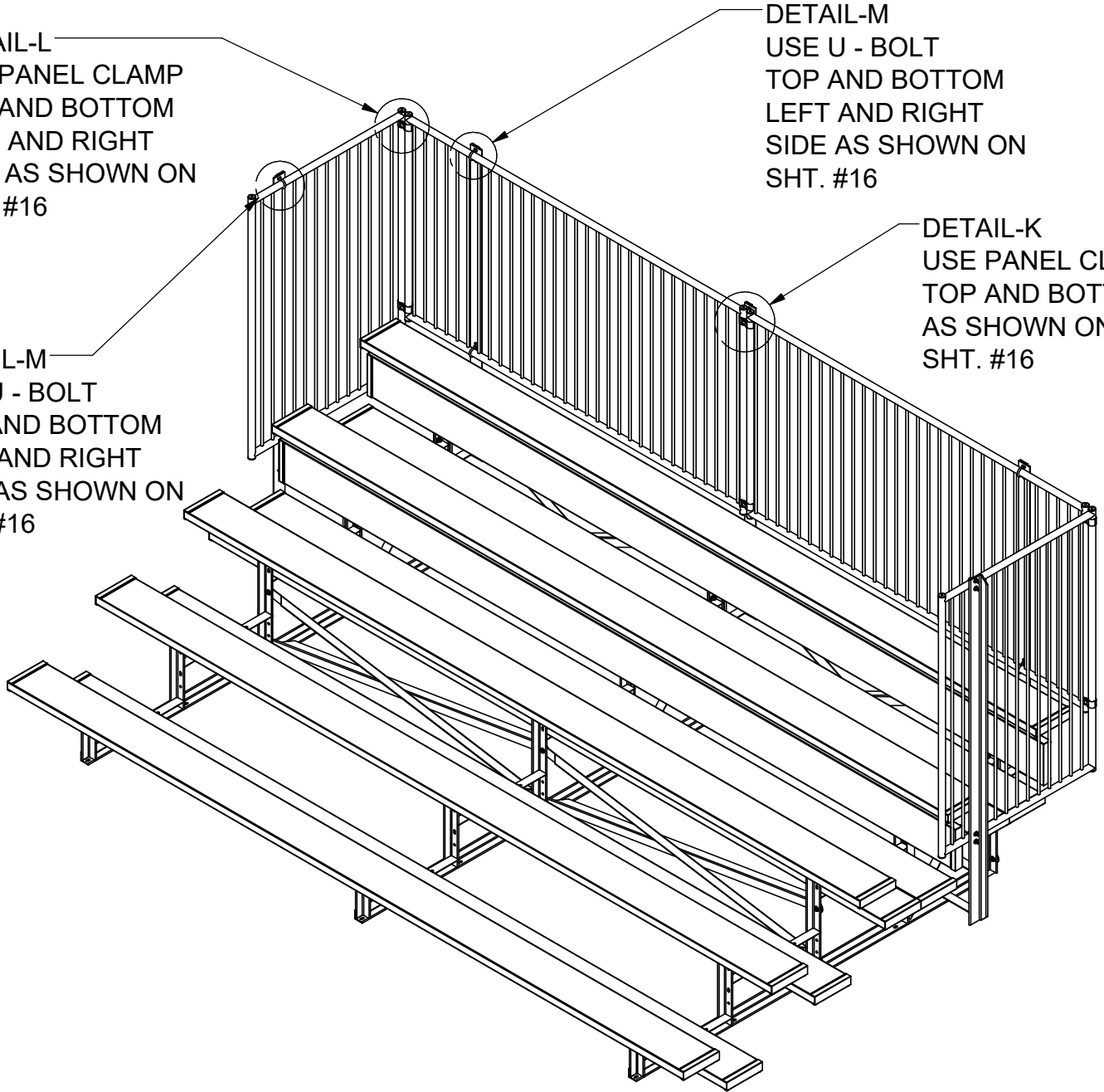
9) Install Railing Side and Rear Panels Items (5) (6) . Attach Railing Side Panel Item (5) to Right F-Frame Panel Support Item (2) with 5/16" U-Bolt Item (18) , washers Item (16) and lock nuts Item (17) Attach Railing Rear Long Panel Item (6) to Rear F-Frame Panel Support Item (3) using 5/16" U-Bolt Item (18) , washers Item (16) , lock nuts Item (17) , Panel Clamp Item (13) , 3/8" x 2-1/2" Carriage bolts Item (19) , washers Item (20) and lock nuts Item (21) . Repeat with the rest of the Railing Panels.

DETAIL-L
USE PANEL CLAMP
TOP AND BOTTOM
LEFT AND RIGHT
SIDE AS SHOWN ON
SHT. #16

DETAIL-M
USE U - BOLT
TOP AND BOTTOM
LEFT AND RIGHT
SIDE AS SHOWN ON
SHT. #16

DETAIL-K
USE PANEL CLAMP
TOP AND BOTTOM
AS SHOWN ON
SHT. #16

DETAIL-M
USE U - BOLT
TOP AND BOTTOM
LEFT AND RIGHT
SIDE AS SHOWN ON
SHT. #16



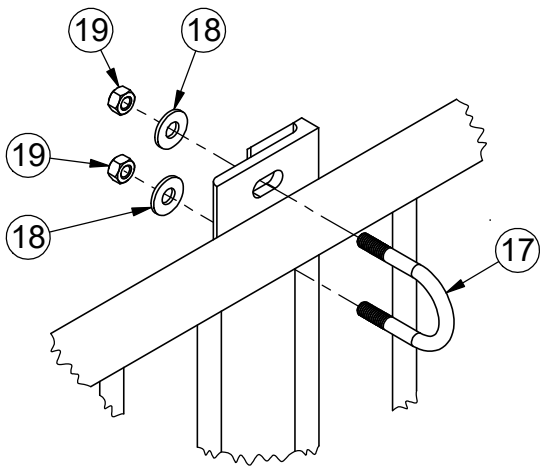
Date: 7/26/2017
Rev: A
Drawn: BDYE
Sheet: 15 of 16

PRODUCT NAME

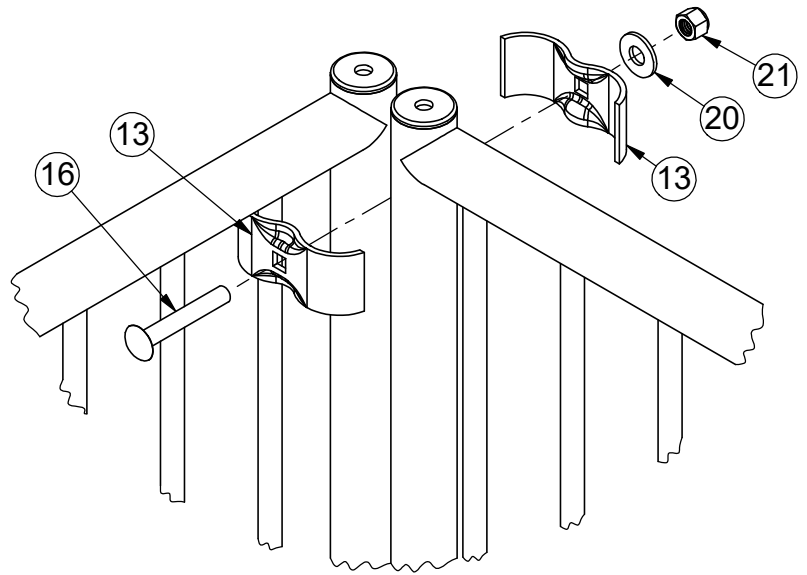
5 ROW STANDARD 15FT

MODEL NO.

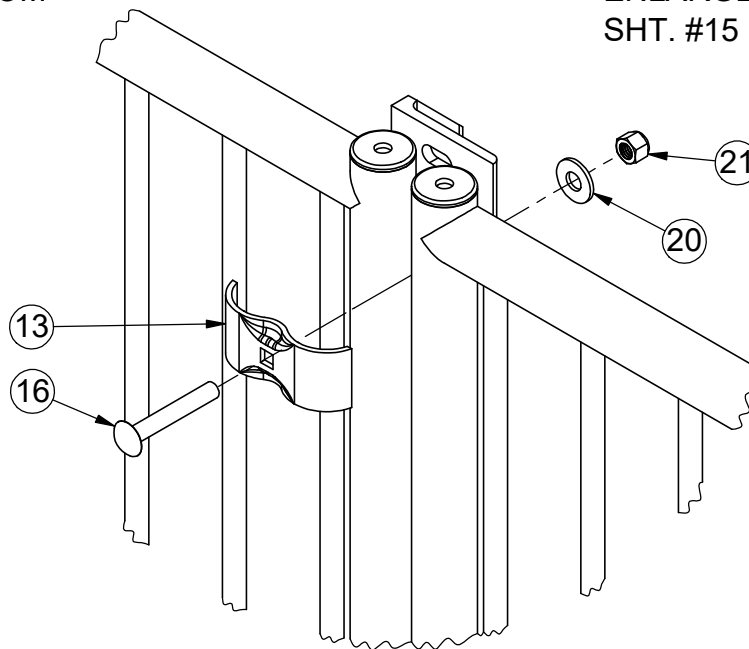
1171-515



DETAIL-M
ENLARGED FROM
SHT. #15



DETAIL-L
ENLARGED FROM
SHT. #15



DETAIL-K
ENLARGED FROM
SHT. #15

INSTALLATION INSTRUCTIONS:

15) 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: 16 of 16

PRODUCT NAME

5 ROW STANDARD 15FT

MODEL NO.

1171-515