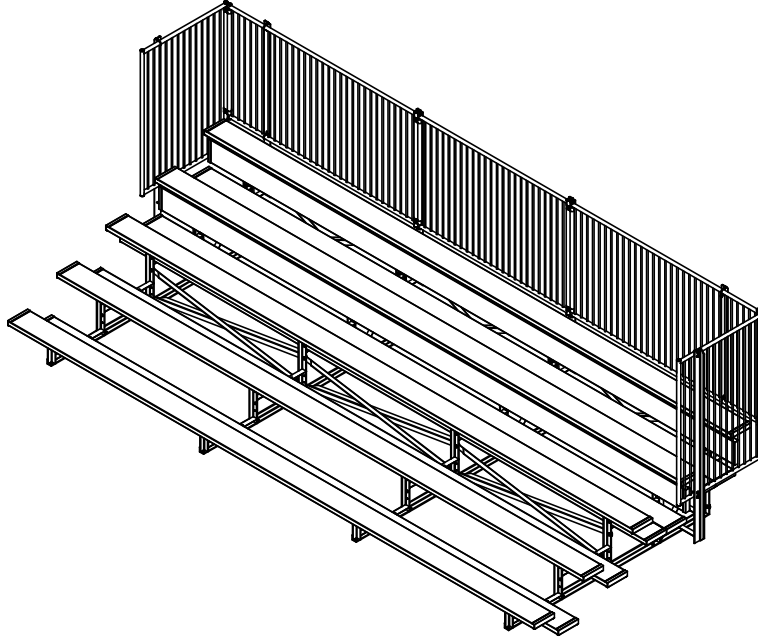


STANDARD SERIES 5-ROW 21' BLEACHER

- MODEL 1171-521MESHG 5-ROW 21' STEEL WITH MESH GUARDRAIL
MODEL 1171-521MESHA 5-ROW 21' ALUMINUM WITH MESH GUARDRAIL

MODEL 1171-521VBGRG 5-ROW 21' STEEL WITH VBGR GUARDRAIL
MODEL 1171-521VBGRA 5-ROW 21' 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 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.



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PRODUCT NAME

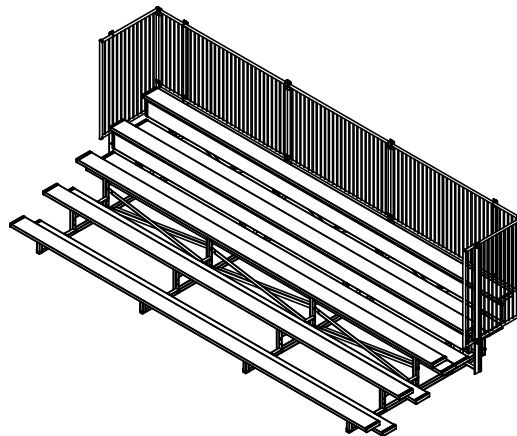
5 ROW STANDARD 21FT

MODEL NO.

1171-521

BOM PARTS & FASTENERS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	ASA-500-1171-515,521,527-A	BLEACHER 5-ROW STANDARD FRAME	4
2	ASA-0510-1100-1000-G	RIGHT F-FRAME PANEL SUPPORT	1
3	ASA-0511-1100-1000-G	REAR F-FRAME PANEL SUPPORT	4
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	ASA-0516-1100-1000-G	RAILING SHORT REAR PANEL	1
8	L-0019-1171-1005-83.375-A	STANDARD BLEACHER BRACE 5TH ROW	6
9	L-0020-1171-1003-76-A	STANDARD BLEACHER BRACE 3RD ROW	6
10	PL-0043-1000-G	PANEL CLAMP	12
11	PL-1100-252-10-A-A	ALUMINUM PLANK ANODIZED 10"x 252"	5
12	PL-1100-252-10-A-M	ALUMINUM PLANK MILL 10"x 252"	8
13	VCIAECP	2"x10" ALUM. END CAP	26
14	VCIACLP	BOLT CLIP FOR 10" & 12" ALUMINUM PLANK	104
15	HWCB5161	5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC	88
16	HWCB38212	3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500)	8
17	HWCB5163	5/16-18 X 3 CARRIAGE BOLT ZINC (600)	16
18	HWFLWA516	5/16 FLAT WASHER	112
19	HWLN516	5/16 NYLOK NUT ZINC	112
20	HWUB516112	5/16 x 1-1/2 x 2-11/16 U bolt	8
21	HWFLWASS38	3/8" FLAT WASHER	96
22	HWLN38	3/8"-16 LOCK NUT	48
23	HWHB38114	3/8-16 X 1 1/4 GR5 C/S ZINC HEX BOLT (1000)	40
24	HWTEX1034	#10 x 5/8 SELF TAPPING SCREW	52



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PRODUCT NAME

5 ROW STANDARD 21FT

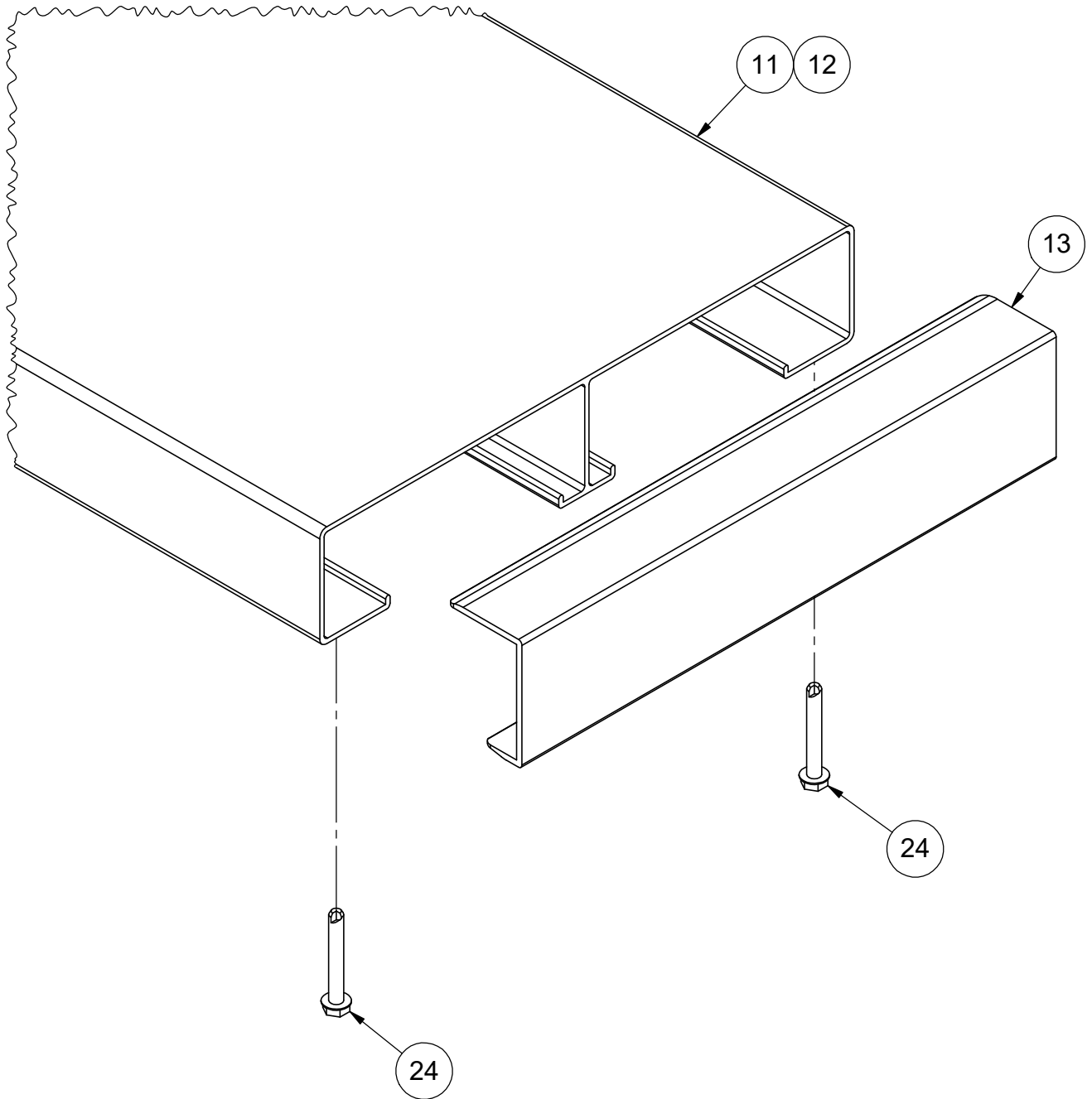
MODEL NO.

1171-521

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 (13) . Align and assemble all end caps to aluminum planks. Secure using #10 x 3/4" Item (24) self-tapping screw in two locations on the underside of the clip/plank.



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PRODUCT NAME

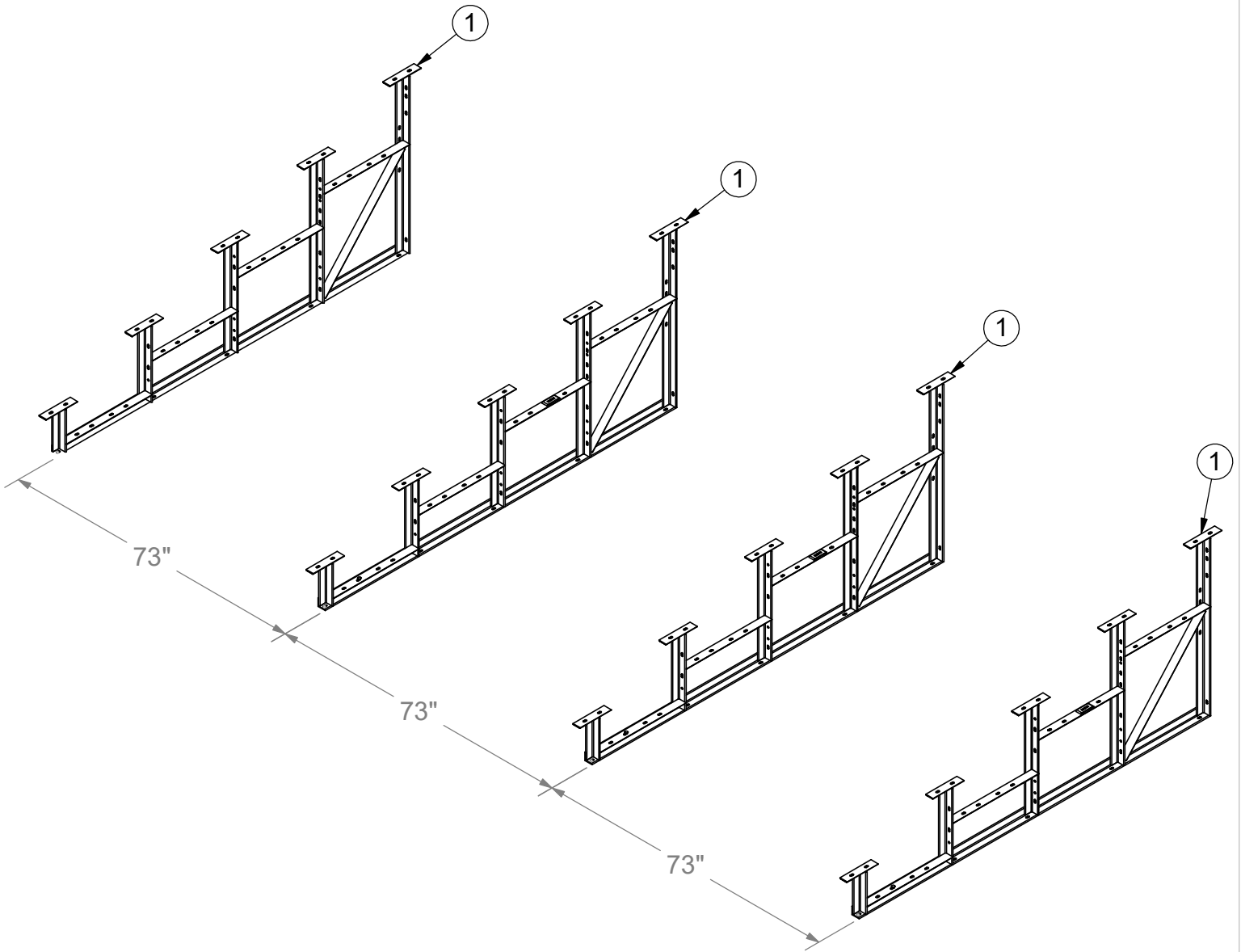
5 ROW DELUXE 21FT

MODEL NO.

1186-521

INSTALLATION INSTRUCTIONS:

3) Locate the five Bleacher 5-Row Standard Frame Item **1** and set on a level surface on 73" centers.



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PRODUCT NAME

5 ROW STANDARD 21FT

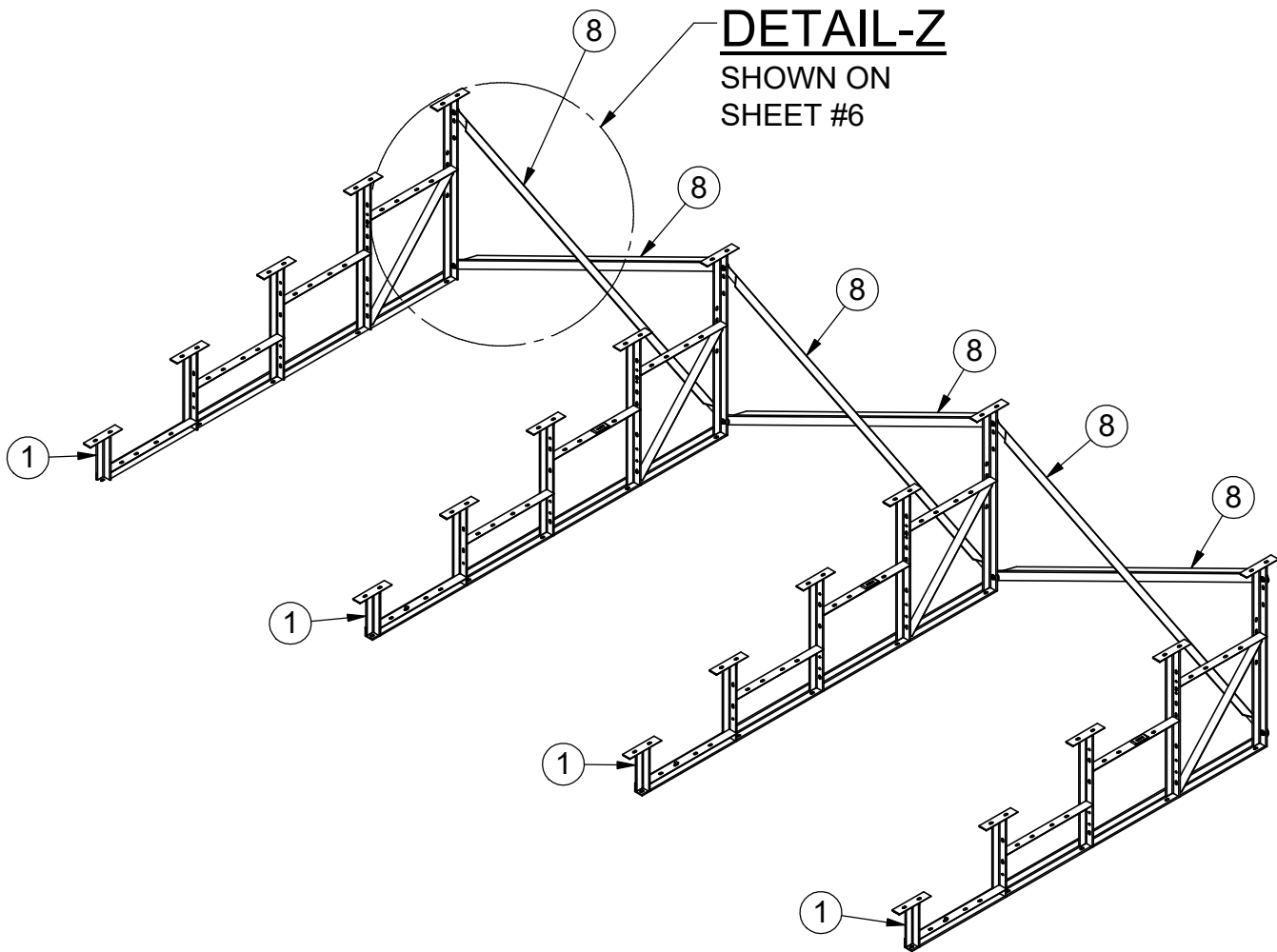
MODEL NO.

1171-521

INSTALLATION INSTRUCTIONS:

4) To Install Cross Braces: a) Locate three sets of diagonal braces measuring 2" x 2" x 83 3/8" Item (8) . Install on the backside of the Bleacher Frames using 3/8" x 1-1/4" Hex Bolt Item (23) , Washers Item (21) , and Lock Nut Item (22) 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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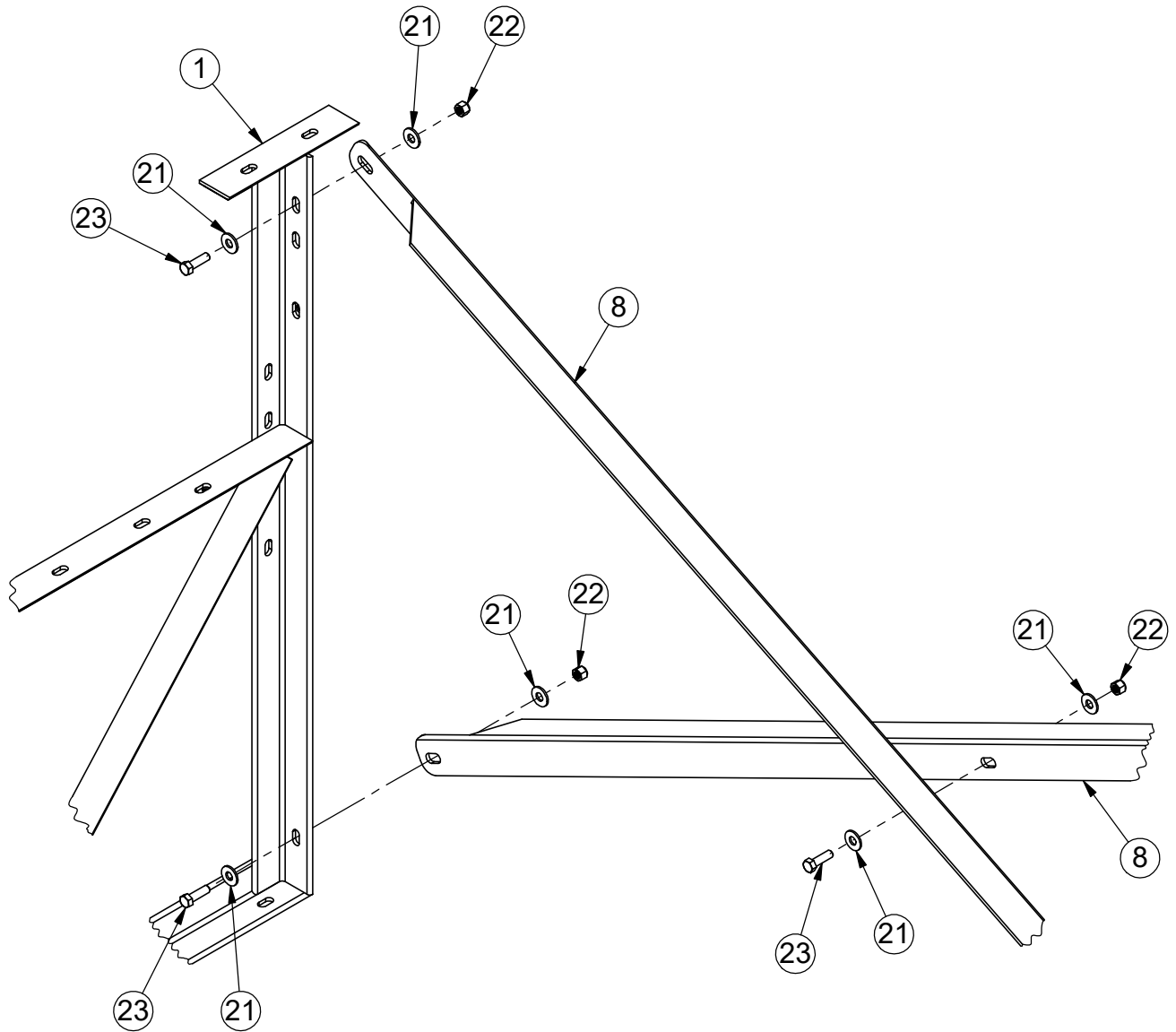
Sheet: 5 of 16

PRODUCT NAME

5 ROW STANDARD 21FT

MODEL NO.

1171-521



DETAIL-Z

ENLARGED
FROM SHEET #5



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PRODUCT NAME

5 ROW STANDARD 21FT

MODEL NO.

1171-521

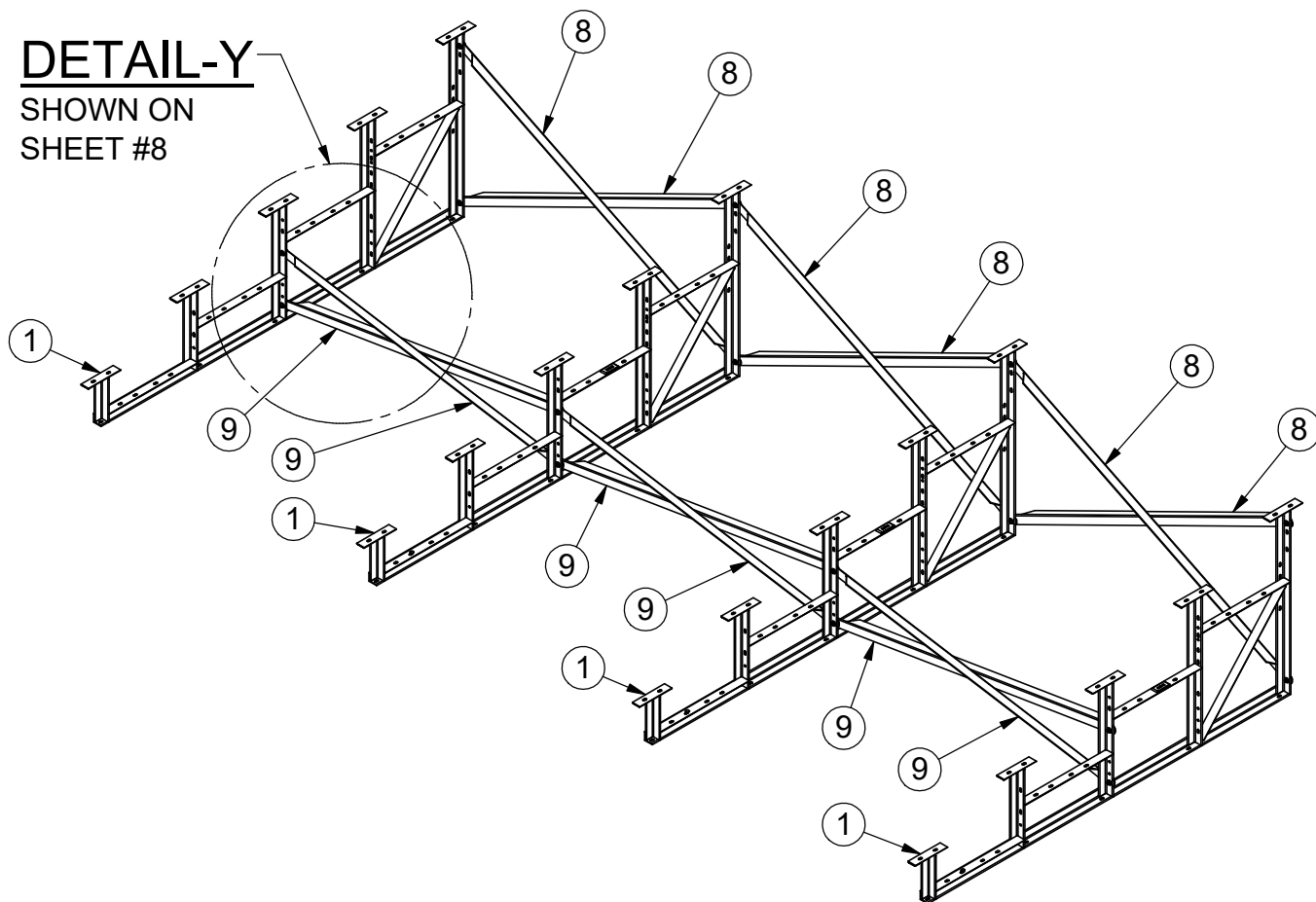
INSTALLATION INSTRUCTIONS:

5) To Install Cross Braces: a) Locate three sets of diagonal braces measuring 2" x 2" x 76" Item **(9)** . Install on the backside of the third row of Bleacher Frames using 3/8" x 1-1/4" Hex Bolt Item **(23)** , Washers Item **(21)** , and lock nut Item **(22)** for the top, bottom slots and center between Braces. 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.

DETAIL-Y

SHOWN ON
SHEET #8



ITEM **(23)** 11 QTY.

ITEM **(21)** 22 QTY.

ITEM **(22)** 11 QTY.



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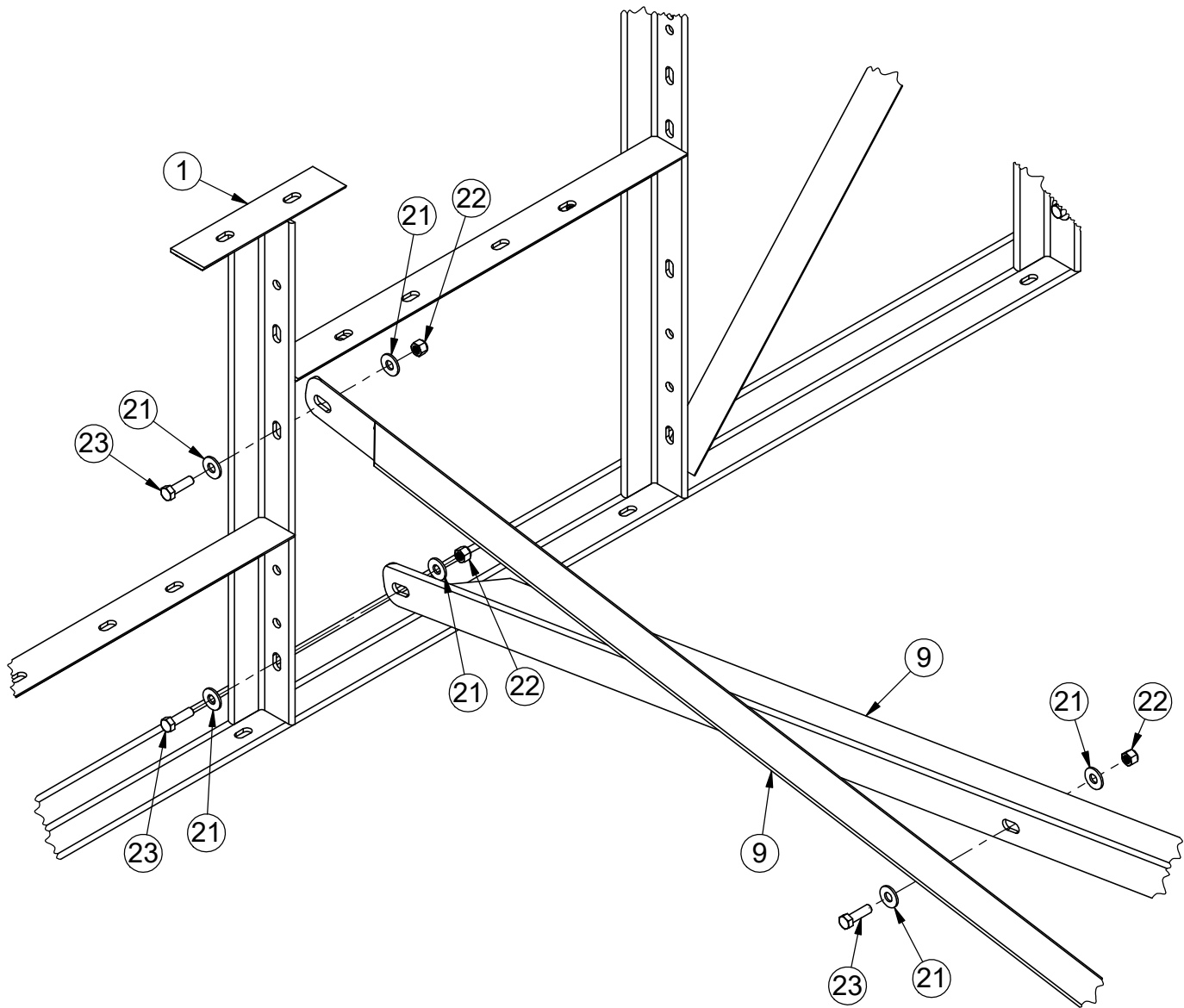
Sheet: 7 of 16

PRODUCT NAME

5 ROW STANDARD 21FT

MODEL NO.

1171-521



DETAIL-Y
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 FROM SHEET #7



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PRODUCT NAME

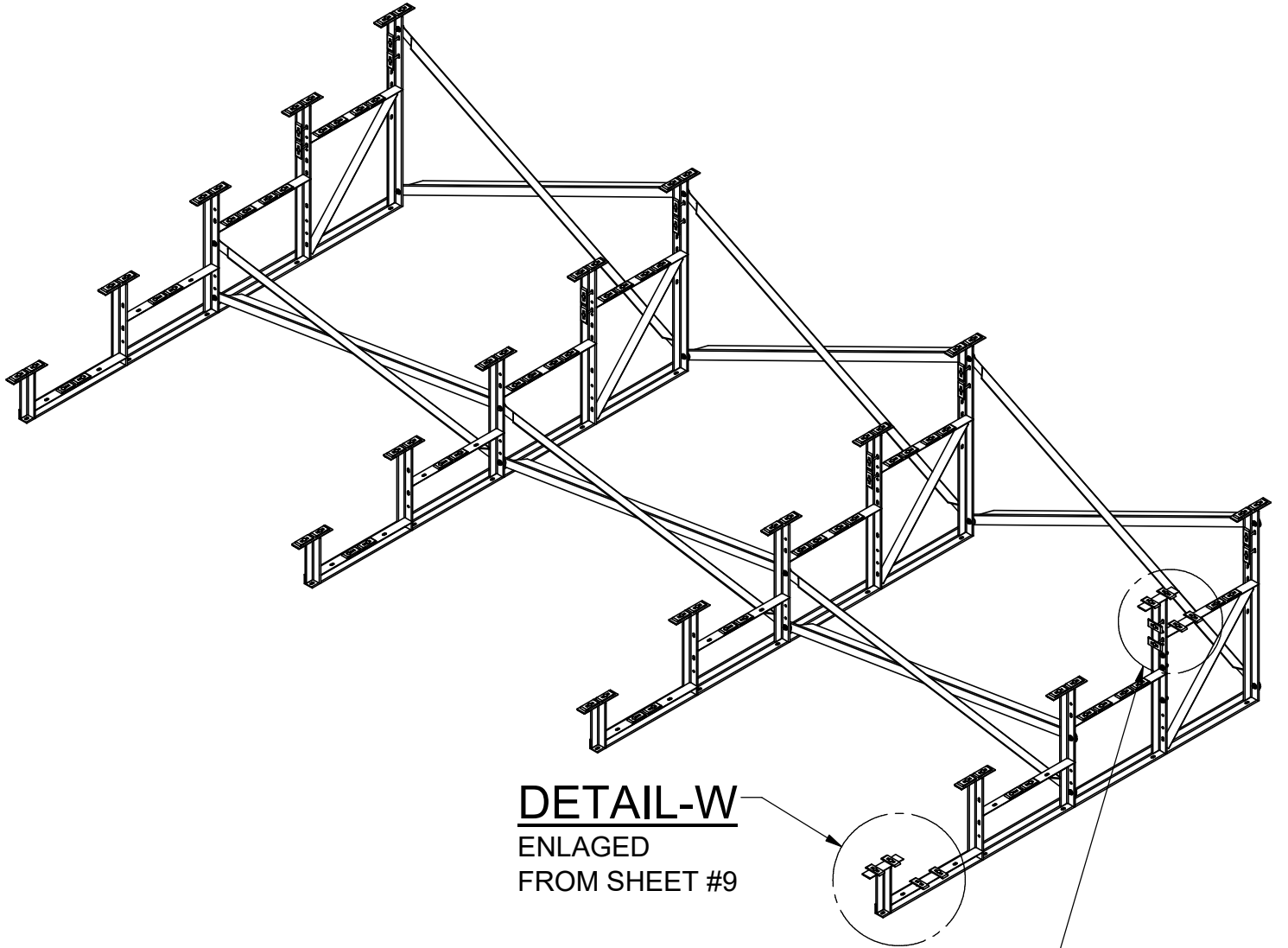
5 ROW STANDARD 21FT

MODEL NO.

1171-521

INSTALLATION INSTRUCTIONS:

6) To Install Seat and Foot Planks: a) First install the Bolt Clip For 10" & 12" Aluminum Plank Item (14) using 5/16" x 1" carriage bolts Item (15), 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 (17), washer Item (18), and lock nuts (19). Give nuts about 3/4 turn (just enough to secure). Turn Bolt Clips Item (14) perpendicular to the frames.



DETAIL-W
ENLARGED
FROM SHEET #9

DETAIL-X
ENLARGED
FROM SHEET #9



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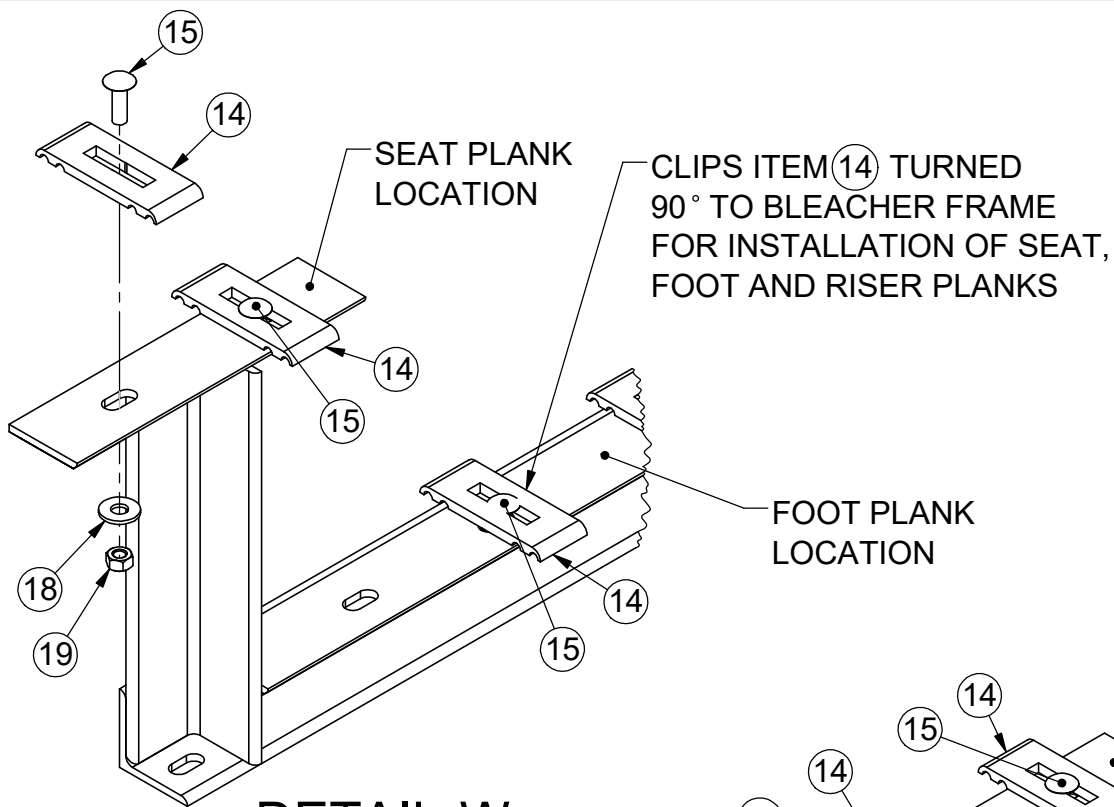
Sheet: 9 of 16

PRODUCT NAME

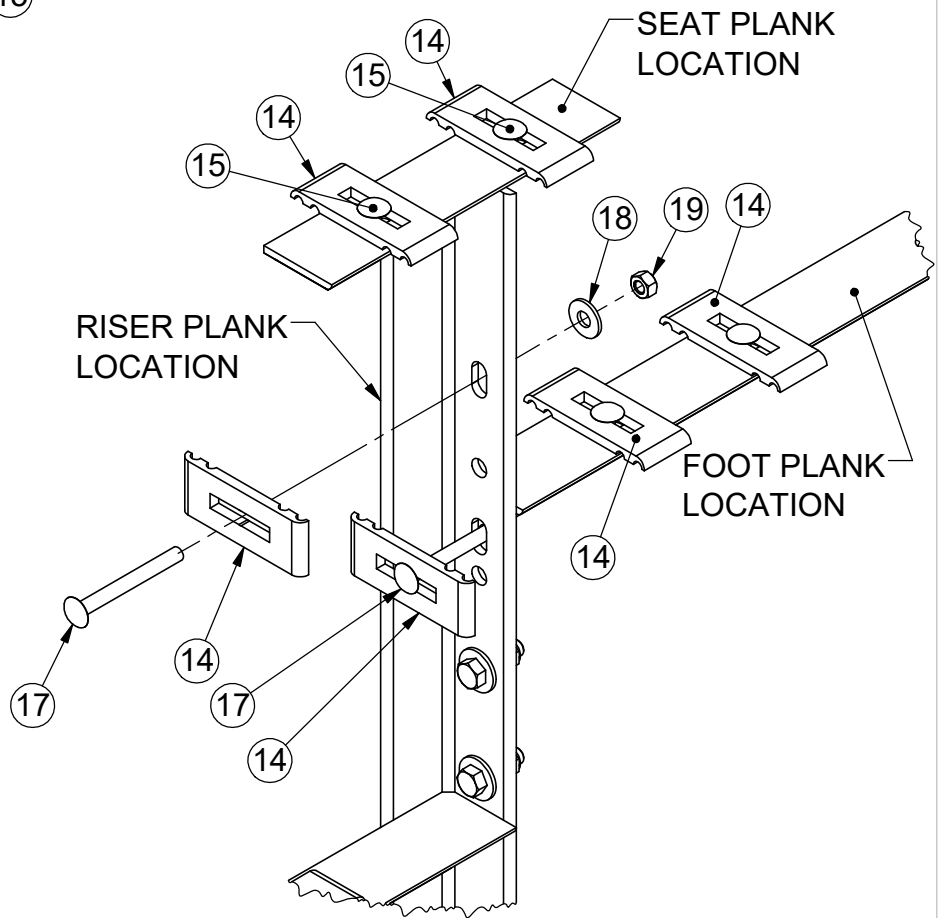
5 ROW STANDARD 21FT

MODEL NO.

1171-521



DETAIL-W
ENLARGED
FROM SHEET #9



DETAIL-X
ENLARGED
FROM SHEET #9



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PRODUCT NAME

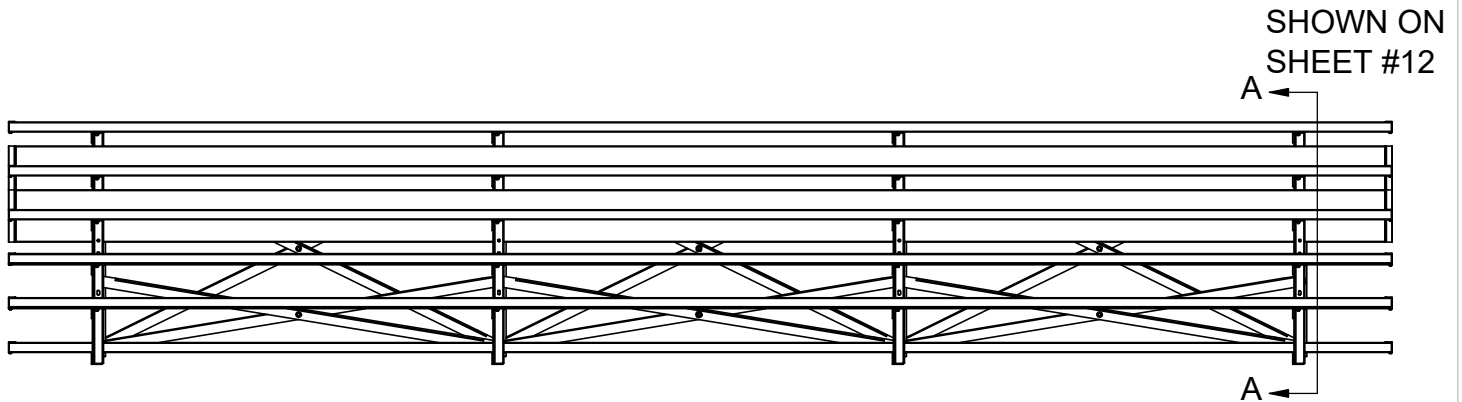
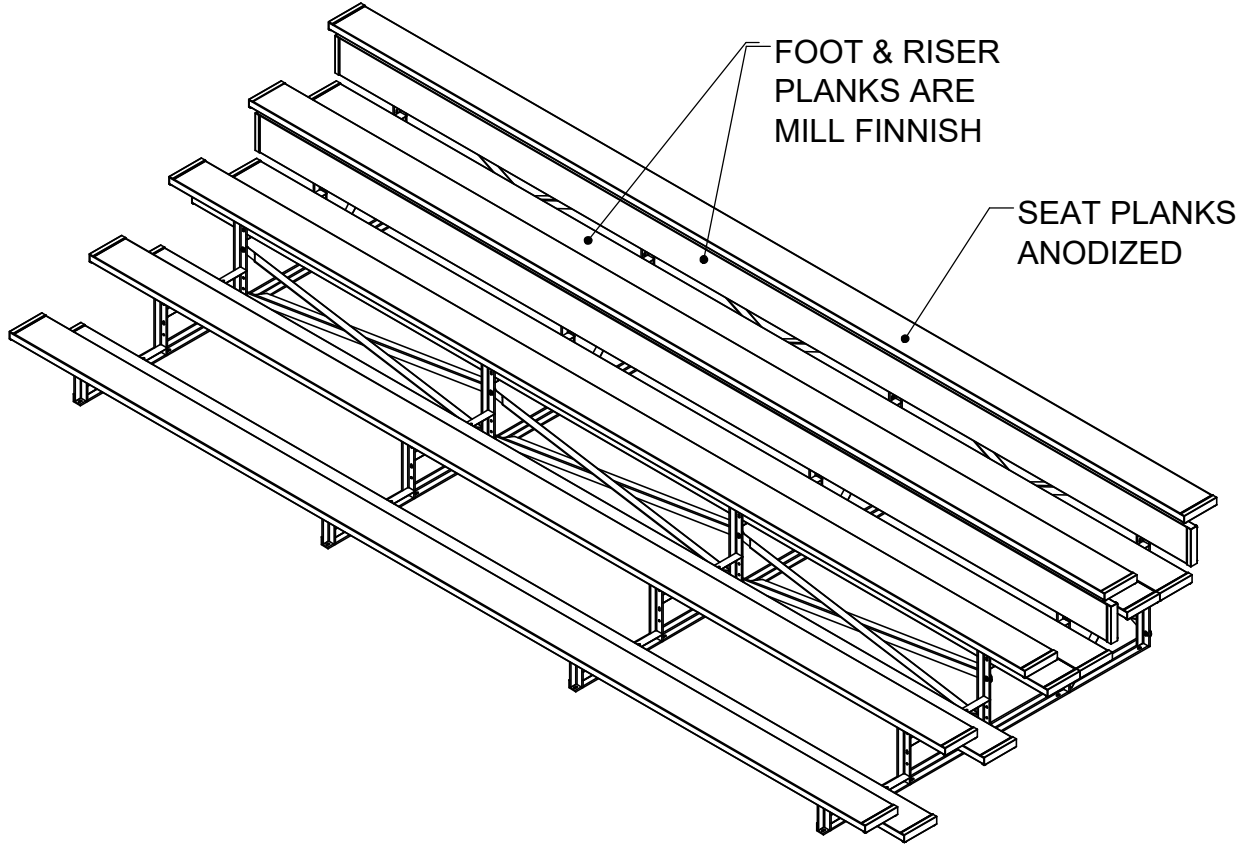
5 ROW STANDARD 21FT

MODEL NO.

1171-521

INSTALLATION INSTRUCTIONS:

7) Position seat Planks, Foot Planks and Riser Planks on the supports so the Bolt Clips Item (14) 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 (14) 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



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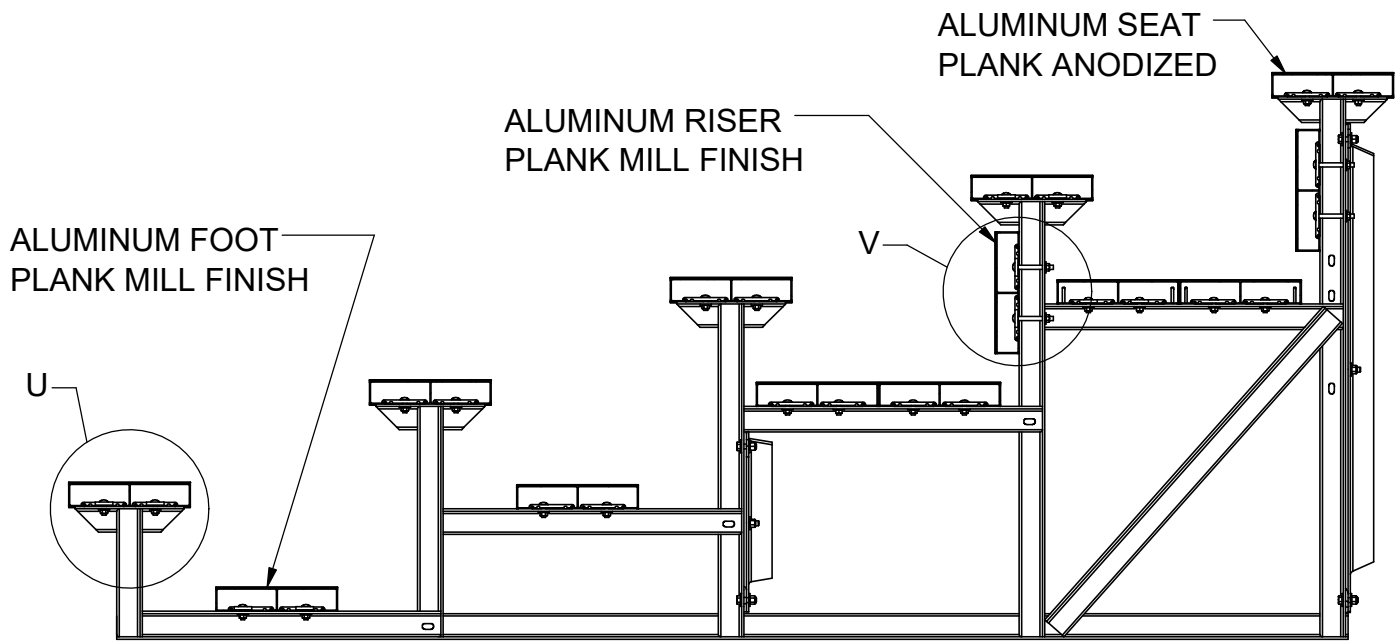
Sheet: 11 of 16

PRODUCT NAME

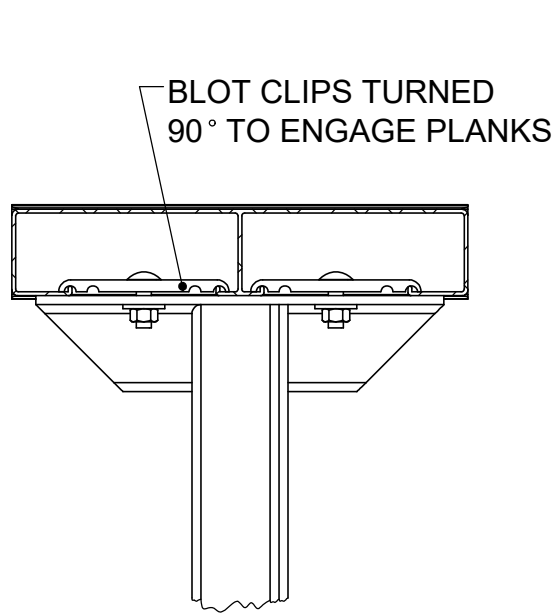
5 ROW STANDARD 21FT

MODEL NO.

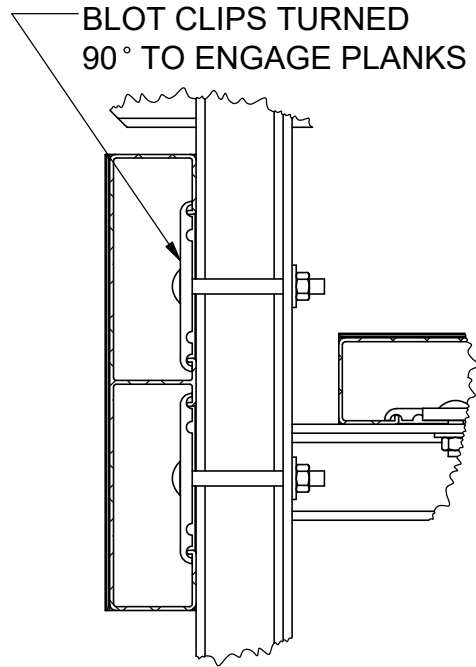
1171-521



SECTION A-A



DETAIL U
ENLARGED



DETAIL V
ENLARGED

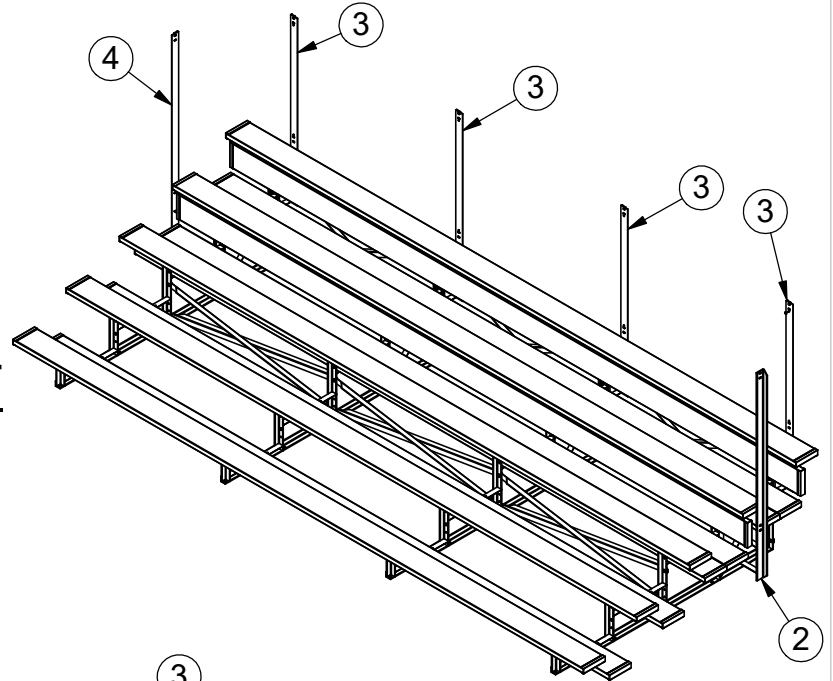


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PRODUCT NAME
5 ROW STANDARD 21FT
 MODEL NO.
1171-521

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(23) , washers Item(21) and lock nuts Item(22) .

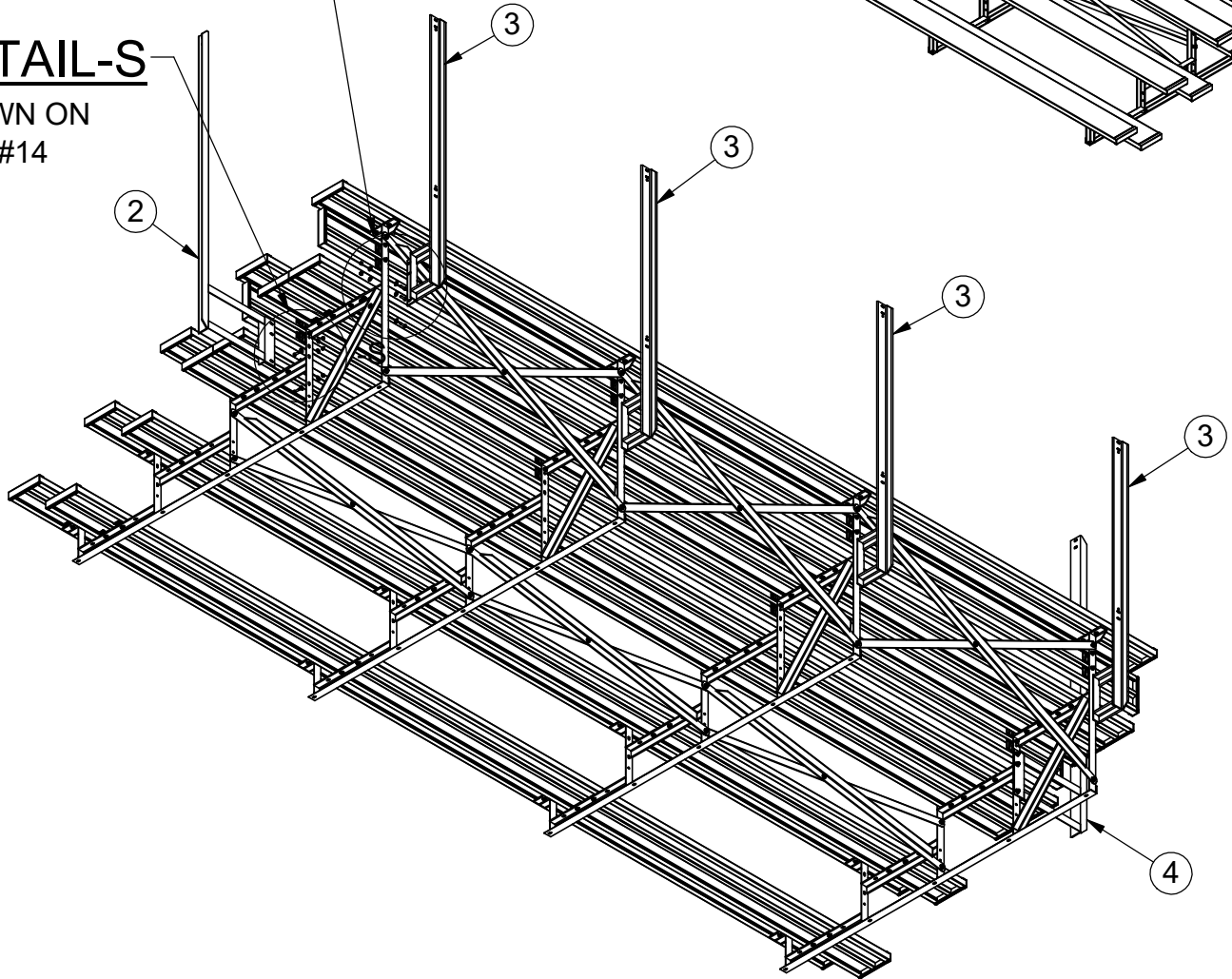


DETAIL-T

SHOWN ON
SHT. #14

DETAIL-S

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SHT. #14



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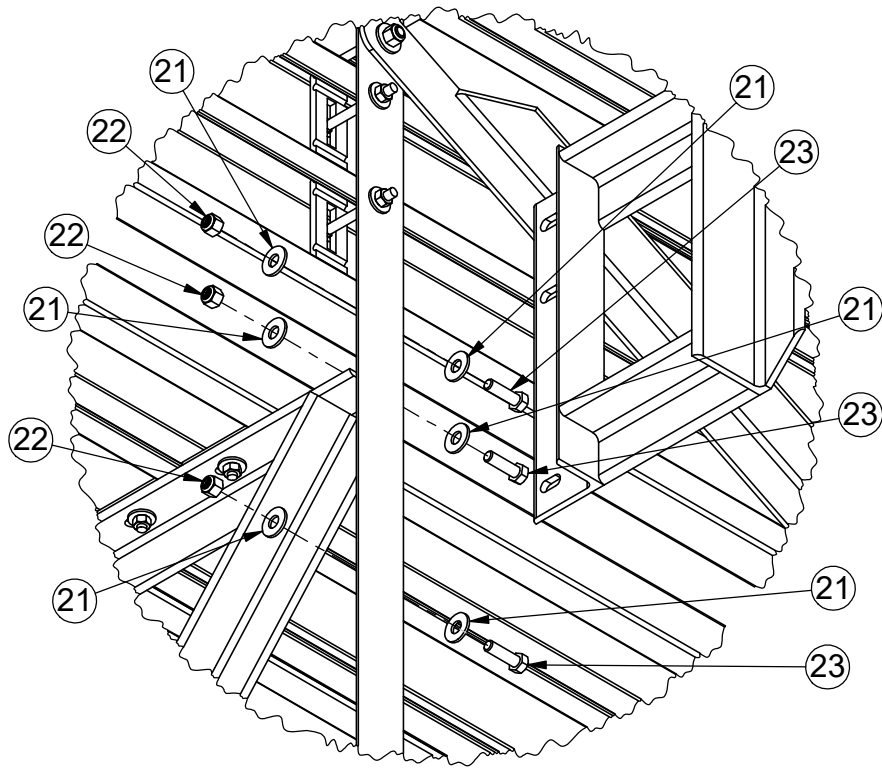
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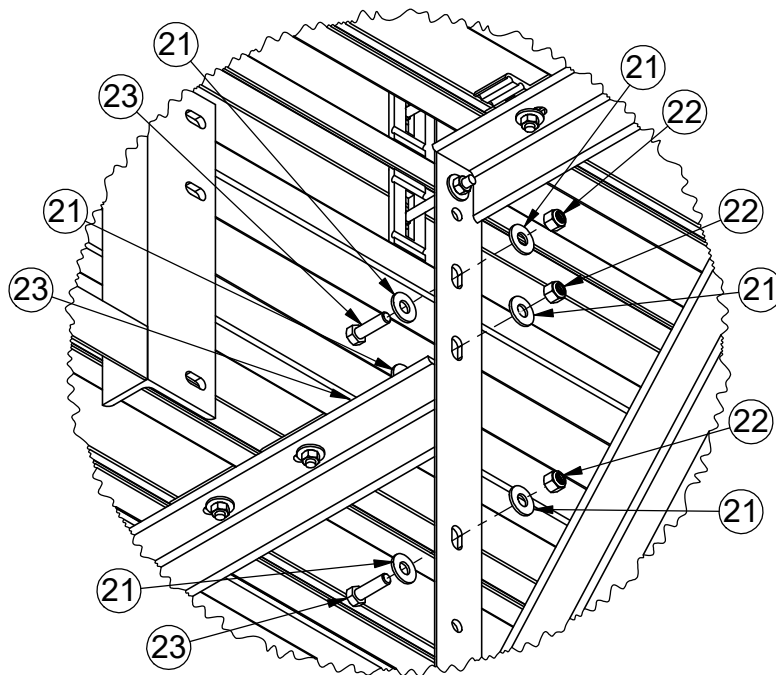
5 ROW STADARD 21FT

MODEL NO.

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DETAIL-T
ENLARGED



DETAIL-S
ENLARGED



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PRODUCT NAME

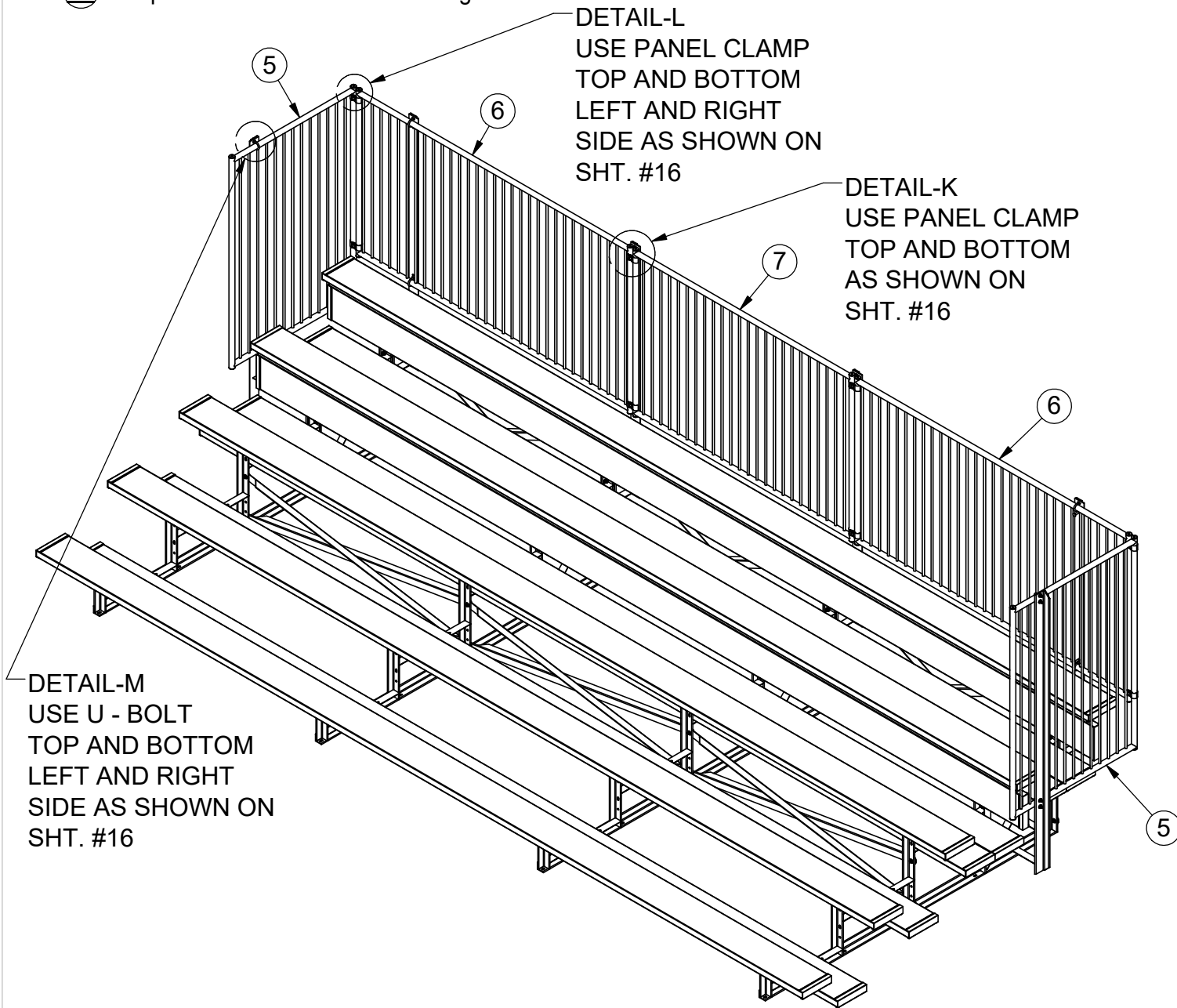
5 ROW STADARD 21FT

MODEL NO.

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INSTALLATION INSTRUCTIONS:

9) Install Railing Side and Rear Panels Items (5) (6) (7) . Attach Railing Side Panel Item (5) to Right F-Frame Panel Support Item (2) with 5/16" U-Bolt Item (20) ,washers Item (18) and lock nuts Item (19) Attach Railing Rear Long Panel Item (6) to Rear F-Frame Panel Support Item (3) using 5/16" U-Bolt Item (20) ,washers Item (18) ,lock nuts Item (19) , Panel Clamp Item (10) , 3/8" x 2-1/2" Carriage bolts Item (16) , washers Item (21) and lock nuts Item (22) . Repeat with the rest of the Railing Panels.



ITEM (21) 8 QTY.

ITEM (22) 8 QTY.



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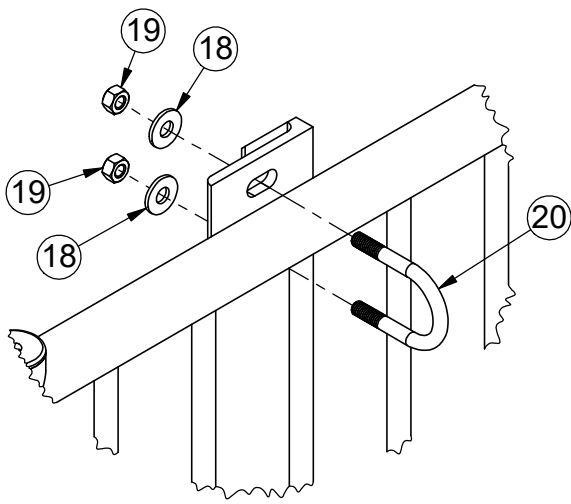
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PRODUCT NAME

5 ROW STANDARD 21FT

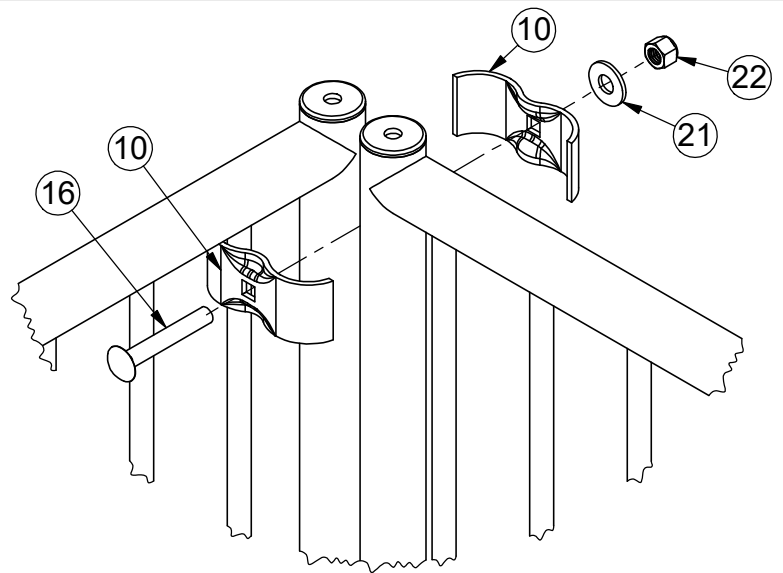
MODEL NO.

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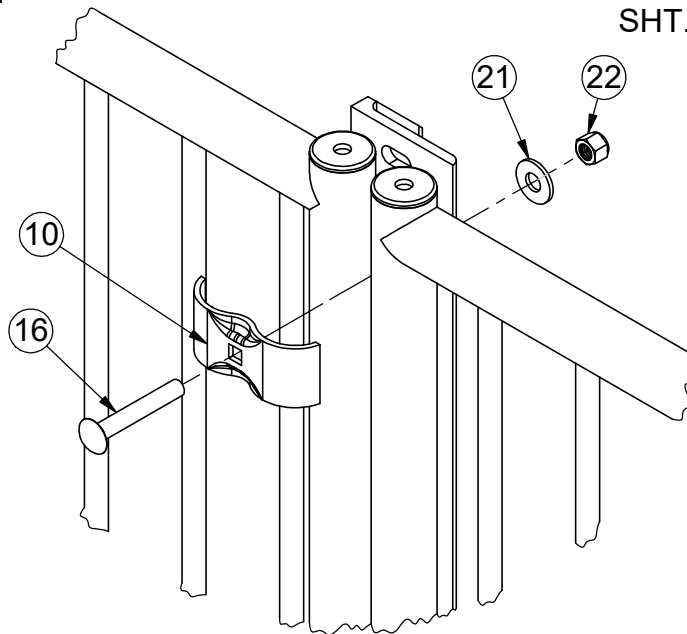
DETAIL-M

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.



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