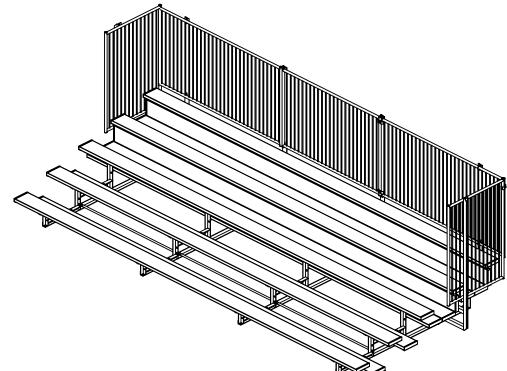
STANDARD SERIES 5-ROW 21' BLEACHER

MODEL 1171-521MESHG5-ROW 21' STEEL WITH MESH GUARDRAILMODEL 1171-521MESHA5-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 6" rise from row to row with nominal 10" aluminum planks and optional 2" x 6" ground sills



SPECIFICATIONS:

Bleacher Frames are fabricated from $2" \times 2" \times 3/16"$ steel or aluminum angle. Frames are welded into a single unit. Frames may have optional $2" \times 6"$ ground sills at every point where frames are in contact with the ground.

Standard Series Bleachers conform to the requirements of ICC 300-2012.

<u>Seat and Foot Planks</u>: 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.

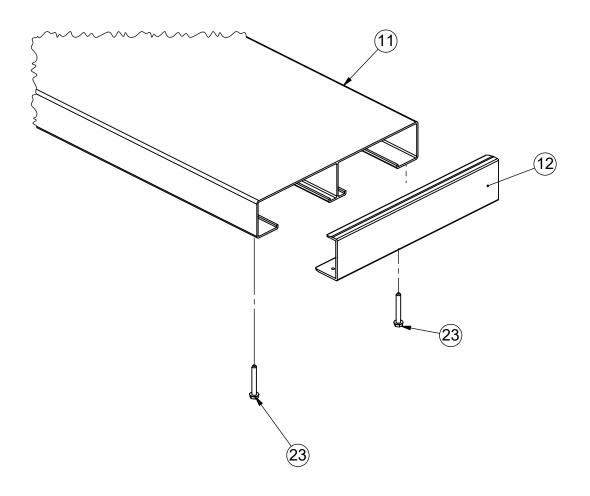
	Date: 4/13/2021 Rev: A		PRODUCT NAME 5 ROW STANDARD 21FT	
SPORT & SITE ELEMENTS FOR LIFE OUTSIDE	Drawn:	JBN	MODEL NO. 1171-521	
1-800-687-5768	Sheet:	1 of 16		

BOM PARTS & FASTENERS

NO.ROW5A OR ROW5GBLEACHER 5-ROW STANDARD FRAME42CIFFRAMES-LTLEFT F-FRAME PANEL SUPPORT13CIFFRAMERREAR F-FRAME PANEL SUPPORT44CIFFRAMES-RTRIGHT F-FRAME PANEL SUPPORT15CIVBGRSIDE OR VCIMESHPANELSIDE RAILING SIDE PANEL26CIVBGRREAR OR VCIMESHPANELREARRAILING LONG REAR PANEL27CIVBGRMID OR WMESHPANELMIDRAILING SHORT REAR PANEL18CIBLB76.375BLEACHER BRACE 76-3/8" LONG39CIBLB74.625BLEACHER BRACE 74-5/8" LONG610VCIPANELCLAMP1381-3/8" X 1-3/8" PANEL CLAMP CLAMPS - PAIR811RMPLK21-10ALUMINUM PLANK ANODIZED 10"x 252"1312VCIAECP2"x10" ALUM. END CAP26				
2 CIFFRAMES-LT LEFT F-FRAME PANEL SUPPORT 1 3 CIFFRAMER REAR F-FRAME PANEL SUPPORT 4 4 CIFFRAMES-RT RIGHT F-FRAME PANEL SUPPORT 1 5 CIVBGREAR ON VCIMESHPANELISDE RAILING SIDE PANEL 2 6 COVBGREAR ON VCIMESHPANELIMER RAILING SIDE PANEL 2 7 CIVBGRID ON WIESHPANELIMER RAILING SHORT REAR PANEL 1 8 CIBLB76.375 BLEACHER BRACE 76-3/8° LONG 3 9 CIBLB74.625 BLEACHER BRACE 76-3/8° LONG 6 10 VCIPAELCLAMP138 1-3/8° T-ANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10°x 252° 13 12 VCIACLP BOLT CLIP FOR 10° & 12° ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5161 5/16 FLAT WASHER 128 17 HWLWA516 5/16 NYLOK NUT ZINC 128 18 HWLMA516 5/16 NYLOK NUT ZINC (500) 40 21 HWHB38 <		PART NUMBER	DESCRIPTION	QTY.
3 CIFFRAMER REAR F-RAME PANEL SUPPORT 4 4 CIFFRAMES.RT RIGHT F-FRAME PANEL SUPPORT 1 5 CIVBGRREAR or VCIMESHPANELREAR RAILING SIDE PANEL 2 6 CIVBGRREAR or VCIMESHPANELREAR RAILING SHORT REAR PANEL 2 7 CIVBGRND or VCIMESHPANELREAR RAILING SHORT REAR PANEL 1 8 CIBL874.625 BLEACHER BRACE 76-5/8" LONG 3 9 CIBL874.625 BLEACHER BRACE 74-5/8" LONG 6 10 VCIPANELCLAMP138 1-3/8" X 1-3/8" PANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"x 252" 13 12 VCIAECP 2"X10" ALUM. END CAP 26 13 VCIAECP 2"X10" ALUM. END CAP 26 14 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (600) 16 14 HWCB3816 5/16 FLAT WASHER 128 14 HWCB3816 5/16 N 1-1/2 X 2-11/16 U bolt 12 14 HWCB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40	1	ROW5A OR ROW5G	BLEACHER 5-ROW STANDARD FRAME	4
4 CIFFRAMES-RT RIGHT F-FRAME PANEL SUPPORT 1 5 CIVBGRRIDE or VCIMESHPANELSIDE RAILING SIDE PANEL 2 6 CIVBGRRAD or VCIMESHPANELSIDE RAILING SIDE PANEL 2 7 CIVBGRAD or VCIMESHPANELARER RAILING LONG REAR PANEL 1 8 CIBLB76.375 BLEACHER BRACE 76-3/8" LONG 3 9 CIBLB76.325 BLEACHER BRACE 74-5/8" LONG 6 10 VCIPANELCLAMP138 1-3/8" X 1-3/8" PANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"x 252" 13 12 VCIACEOP 2"x10" ALUM. END CAP 26 13 VCIACEOP 2"x10" ALUM. END CAP 26 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 16 HWUN516 5/16 R-LAT WASHER 128 18 HWIN56 5/16 N-1/2 X 2-11/16 U bolt 128 19 HWB516112 5/16 X 1-1/2 X 2-11/16 U bolt 128 18 HWIN38 3/8" FLAT WASHER 96 14 HWIN38 3/8"-16 LOCK N	_	CIFFRAMES-LT	LEFT F-FRAME PANEL SUPPORT	1
5 CIVBGRSIDE OR VCIMESHPANELISDE RAILING SIDE PANEL 2 6 CIVBGRREAR OR VCIMESHPANELIMER RAILING SIDE PANEL 2 7 CIVBGRREAR OR VCIMESHPANELIMER RAILING SIDE PANEL 2 8 CIBLB76.375 BLEACHER BRACE 76-3/8* LONG 3 9 CIBLB74.625 BLEACHER BRACE 74-5/8* LONG 6 10 VCIPANELCLAMP138 1-3/8* X 1-3/8" PANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10*x 252" 13 12 VCIACEP 2*/10* ALUM PLANK ANODIZED 10*x 252" 13 14 RWCB161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 8 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5161 5/16 - 18 X 3 CARRIAGE BOLT ZINC (500) 16 17 HWFLX4516 5/16 FLAT WASHER 128 18 HWLN516 5/16 NYLOK NUT ZINC 128 19 HWUES16112 5/16 NYLOK NUT ZINC 128 19 HWLX38 3/8" FLAT WASHER 96 21 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 21 H	3	CIFFRAMER	REAR F-FRAME PANEL SUPPORT	4
6 CIVBGRREAR OR VCIMESHPANELREAR RAILING LONG REAR PANEL 2 7 CIVBGRMID OR WMESHPANELMID RAILING SHORT REAR PANEL 1 8 CIBL576.375 BLEACHER BRACE 76-3/8" LONG 3 9 CIBL574.625 BLEACHER BRACE 74-5/8" LONG 6 10 VCIPANELCLAMP138 1-3/8" X 1-3/8" PANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"X 252" 13 12 VCIACECP 2"X10" ALUM END CAP 26 13 VCIACEP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT ZINC (500) 8 15 HWCB3212 3/8-16 X 1/2 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 FLAT WASHER 128 19 HWUB513112 3/8-16 LOCK NUT ZINC 128 19 HWUB51611 12 11/2 CR5 C/S ZINC HEX BOLT (1000) 40 21 HWHB38112 3/8-16 LOCK NUT 11/2 CR5 C/S ZINC HEX BOLT (1000)	4	CIFFRAMES-RT	RIGHT F-FRAME PANEL SUPPORT	1
7 CIVBGRMID OR, WMESHPANELMID RAILING SHORT REAR PANEL 1 8 CIBLE76.375 BLEACHER BRACE 76-3/8" LONG 3 9 CIBLE74.625 BLEACHER BRACE 74-5/8" LONG 6 10 VCIPANELCLAMP138 1-3/8" X 1-3/8" PANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"x 252" 13 12 VCIACLP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (600) 16 14 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 NUTOK NUT ZINC 128 19 HWUB516/11/2 5/16 NUTOK NUT ZINC 128 19 HWUB316/11/2 5/16 I/4 VASHER 96 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWLS38 3/8" I 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 <	5	CIVBGRSIDE OR VCIMESHPANELSIDE	RAILING SIDE PANEL	2
8 CIBLB76.375 BLEACHER BRACE 76-3/8" LONG 3 9 CIBLB74.425 BLEACHER BRACE 74-5/8" LONG 6 10 VCIPANELCLAMP138 1-3/8" X 1-3/8" X 1-3/8" LANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"x 252" 13 12 VCIACLP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB36212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWUN51612 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 LAT WASHER 128 19 HWUR516 5/16 NYLOK NUT ZINC 128 19 HWUN38 3/8" FLAT WASHER 96 11 HWFLWA38 3/8" 16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWHEX1034 #10 x 3/4 SELF TAPPING SCREW 52	6	CIVBGRREAR OR VCIMESHPANELREAR	RAILING LONG REAR PANEL	2
9 CIBLB74.625 BLEACHER BRACE 74-5/8" LONG 6 10 VCIPANELCLAMP138 1-3/8" X 1-3/8" PANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"x 252" 13 12 VCIACLP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB3161 5/16-18 X 3 CARRIAGE BOLT ZINC (500) 16 17 HWFLWA516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 X 1 1/2 X 21/1/16 U bolt 122 19 HWUB316112 5/16 X 1 1/2 RS C/S ZINC HEX BOLT (1000) 40 13 HWHS38112 3/8" FLAT WASHER 96 21 HWHS38112 3/8" 16 LOCK NUT 48 22 HWHB38112 3/8" 16 X 1 1/2 GRS C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 FRODUCT NAME 24 HWHS34 74 THE 4/13/2021 Rew: A	7	CIVBGRMID OR WMESHPANELMID	RAILING SHORT REAR PANEL	1
10 VCIPANELCLAMP138 1:3/8' X 1:3/8' PANEL CLAMP CLAMPS - PAIR 8 11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"x 252" 13 12 VCIAECP 2'x10" ALUM. END CAP 26 13 VCIACLP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB3212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 X 1-1/2 X 2-11/16 U bolt 12 19 HWUBS16112 5/16 X 1-1/2 X 2-11/16 U bolt 12 20 HWFLWA38 3/8"-16 LOCK NUT 14 21 HWHS38112 3/8-16 X 1 1/2 GFS C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 FRODUCT NAME 22 HWHEX1034 #10 x 3/4 SELF TAPPING SCREW 52 FRODUCT NAME 5 TOW STANDARD 21FT MODEL NO. 117	8	CIBLB76.375	BLEACHER BRACE 76-3/8" LONG	3
11 RMPLK21-10 ALUMINUM PLANK ANODIZED 10"x 252" 13 12 VCIAECP 2"x10" ALUM. END CAP 26 13 VCIACLP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWUN516 5/16 N YLOK NUT ZINC 128 19 HWUB516112 5/16 X 1-1/2 X 2-11/16 U bolt 12 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWHB38112 3/8-16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GS C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 Date: 4/13/2021 PRODUCT NAME S ROW STANDARD 21FT Oute: A Intra-521	9	CIBLB74.625	BLEACHER BRACE 74-5/8" LONG	6
12 VCIAECP 2"x10" ALUM. END CAP 26 13 VCIACLP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT ZINC (500) 8 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB3161 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 NYLOK NUT ZINC 128 19 HWUB316112 5/16 LOCK NUT 12 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWLN38 3/8"-16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 PRODUCT NAME 24 HWHEX034 #10 x 3/4 SELF TAPPING SCREW 52 PRODUCT NAME 5 ROW STANDARD 21FT MODEL NO. 1171-521	10	VCIPANELCLAMP138	1-3/8" X 1-3/8" PANEL CLAMP CLAMPS - PAIR	8
13 VCIACLP BOLT CLIP FOR 10" & 12" ALUMINUM PLANK 104 14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB5163 5/16-18 X 1 CARRIAGE BOLT ZINC (500) 8 16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 NYLOK NUT ZINC 128 19 HWVB516112 5/16 X 1-1/2 X 2-11/16 U bolt 12 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWUN33 3/8" 16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 FRODUCT NAME 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 FRODUCT NAME 5 ROW STANDARD 21FT MODEL NO. 1171-521	11	RMPLK21-10	ALUMINUM PLANK ANODIZED 10"x 252"	13
14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWUN516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 NYLOK NUT ZINC 128 20 HWFLWA38 3/8" FLAT WASHER 128 19 HWUB516112 5/16 NYLOK NUT ZINC 128 20 HWFLWA38 3/8" FLAT WASHER 128 14 HWIN516 5/16 NYLOK NUT ZINC 128 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 PRODUCT NAME 5 TOW STANDARD 21FT MODEL NO. 1171-521	12	VCIAECP	2"x10" ALUM. END CAP	
14 HWCB5161 5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC 88 15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWUN516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 NYLOK NUT ZINC 128 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWUN516 5/16 NYLOK NUT ZINC 128 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWIB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 21 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 PRODUCT NAME 5 ROW STANDARD 21FT MOREL NO. 1171-521	13	VCIACLP		104
15 HWCB38212 3/8-16 X 2 1/2 CARRIAGE BOLT ZINC (500) 8 16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 NYLOK NUT ZINC 128 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWLN33 3/8"-16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GFS C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 PRODUCT NAME 24 MWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 PRODUCT NAME 5 ROW STANDARD 21FT MODEL NO. 1171-521	14	HWCB5161	5/16-18 X 1 CARRIAGE BOLT GRADE 2 ZINC	
16 HWCB5163 5/16-18 X 3 CARRIAGE BOLT ZINC (600) 16 17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 X 1-1/2 X 2-11/16 U bolt 12 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWLN38 3/8" FLAT WASHER 96 21 HWLN38 3/8"-16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 PRODUCT NAME 52 Otate: 4/13/2021 PRODUCT NAME 5 ROW STANDARD 21FT MODEL NO. 1171-521	15	HWCB38212		
17 HWFLWA516 5/16 FLAT WASHER 128 18 HWLN516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 x 1-1/2 x 2-11/16 U boit 12 20 HWFLWA38 3/8" FLAT WASHER 96 96 21 HWLN38 3/8" T-16 LOCK NUT 48 22 HWHB38112 3/8.16 X 1-1/2 SZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 OFFERENCE Date: 4/13/2021 Rev: A Drawn: JBN PRODUCT NAME 5 ROW STANDARD 21FT MODEL NO. MODEL NO.	16	HWCB5163		-
18 HWLN516 5/16 NYLOK NUT ZINC 128 19 HWUB516112 5/16 x 1-1/2 x 2-11/16 U bolt 12 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWLN38 3/8"-16 LOCK NUT 48 22 HWHB38112 3/8-16 LOCK NUT 48 21 HWHB38112 3/8-16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 Officient of the second state of the s				-
19 HWUB516112 5/16 x 1-1/2 x 2-11/16 U bolt 12 20 HWFLWA38 3/8" FLAT WASHER 96 21 HWLN38 3/8" FLAT WASHER 96 21 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 Image: With the second				
20 HWFLWA38 3/8" FLAT WASHER 96 21 HWLN38 3/8"-16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 <				
21 HWLN38 3/8"-16 LOCK NUT 48 22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 Image: Screw Screw Image: Screw Screw <t< td=""><td>-</td><td></td><td></td><td></td></t<>	-			
22 HWHB38112 3/8-16 X 1 1/2 GR5 C/S ZINC HEX BOLT (1000) 40 23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 Image: Second Screw Second Screw Image: Second Screw Second Screw Date: 4/13/2021 PRODUCT NAME Togo Screw Second Screw Date: 4/13/2021 PRODUCT NAME Togo Screw Screw Standard 21FT Model NO. Togo Screw Screw Standard 21FT				
23 HWTEX1034 #10 x 3/4 SELF TAPPING SCREW 52 Image: state of the				
Date: 4/13/2021 Rev: A Drawn: JBN MODEL NO. 1171-521				
Date: 4, 10/2021 Rev: A Drawn: JBN MODEL NO. 1171-521				
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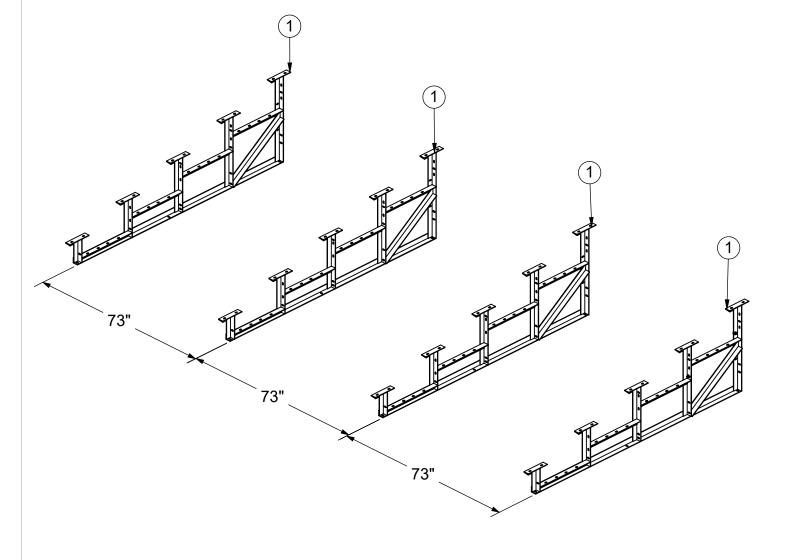
1) Check materials received with the BOM to make sure that all components are included and to assure that the unit is complete.

2) Installing End Caps Item on Seat and Foot Planks: 2" x 10" end caps Item (12). 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.



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



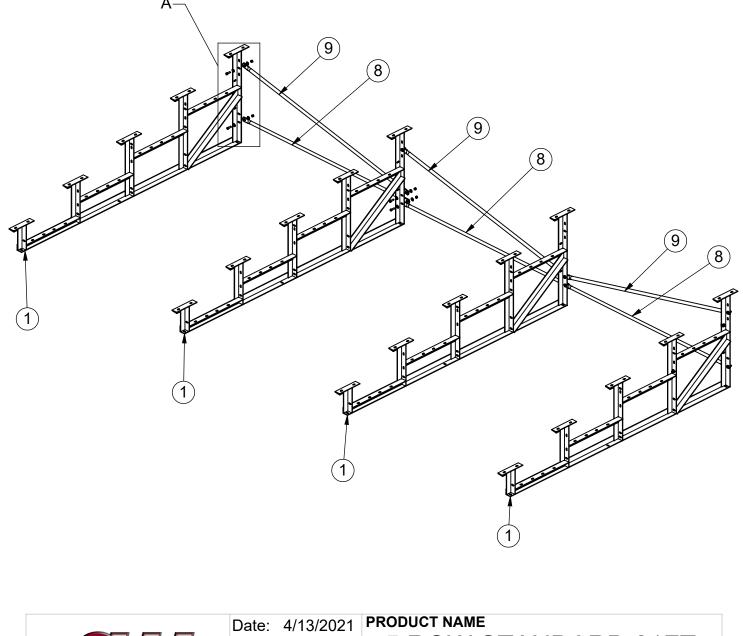
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INSTALLATION INSTRUCTIONS: 1171-521

4) To Install Cross Braces: a) Locate three diagonal braces measuring 76 3/8" Item (9) and three horizontal braces measuring 74-5/8" (8).

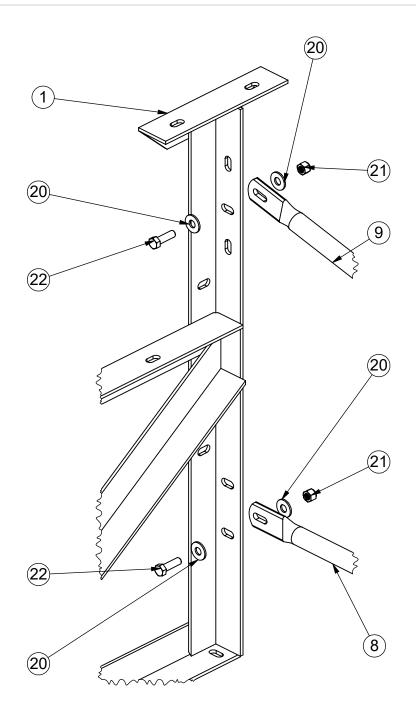
Install on the backside of the Bleacher Frames using 3/8" x 1-1/2" Hex Bolt Item (22), Washers Item (20), and Lock Nut Item (21) provided using the top and bottom slots in the frame and center of Braces as shown. Repeat steps to assemble remaining sets of cross braces to the other bleacher frames. At 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.





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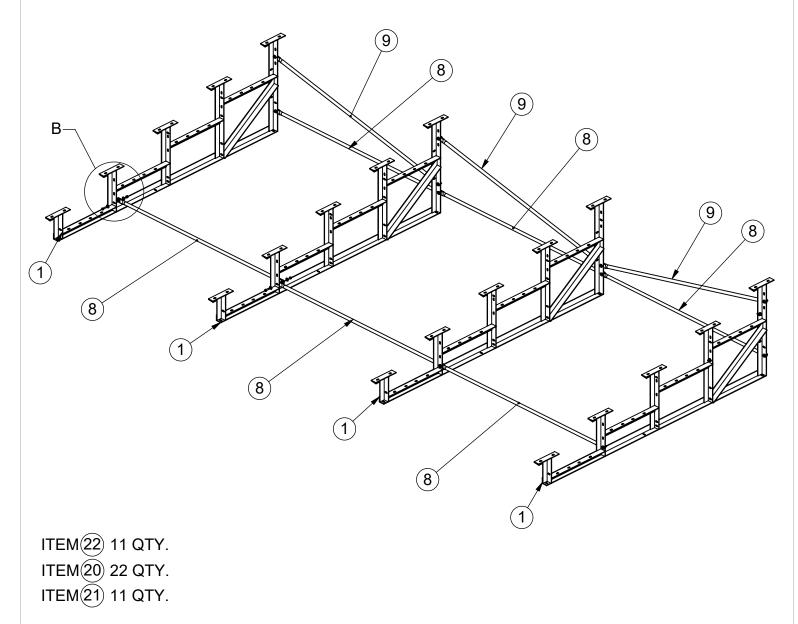


DETAIL A ENLARGED FROM SHEET #5 SCALE 1 : 5

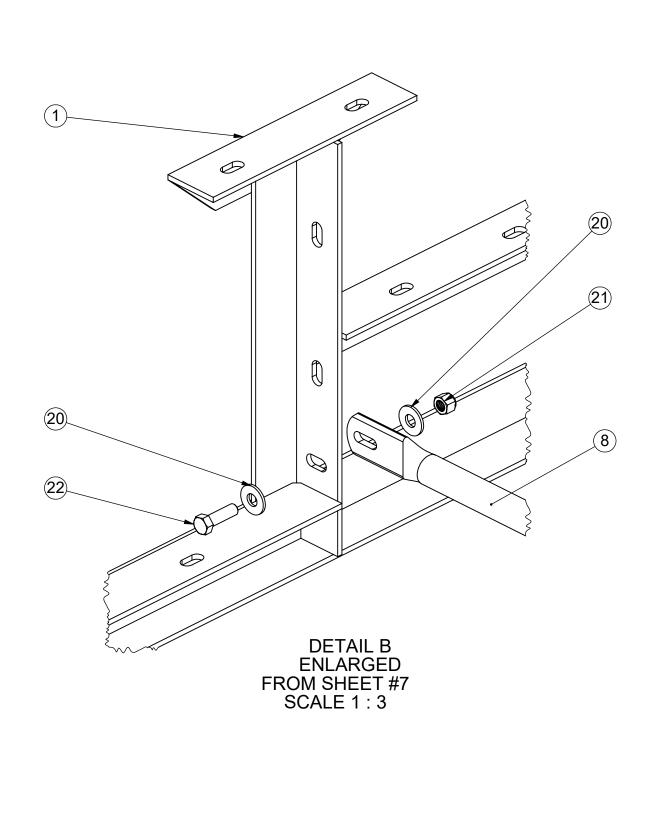
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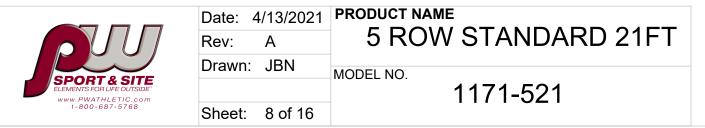
5) To Install Cross Braces: a) Locate three horizontal braces measuring 74-5/8" Item (8). Install on the backside of the second row of Bleacher Frames using 3/8" x 1-1/2" Hex Bolt Item (22), Washers Item (20), and lock nut Item (21) for the top,bottom slots and center between Braces. Repeat steps to assemble remaining 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.

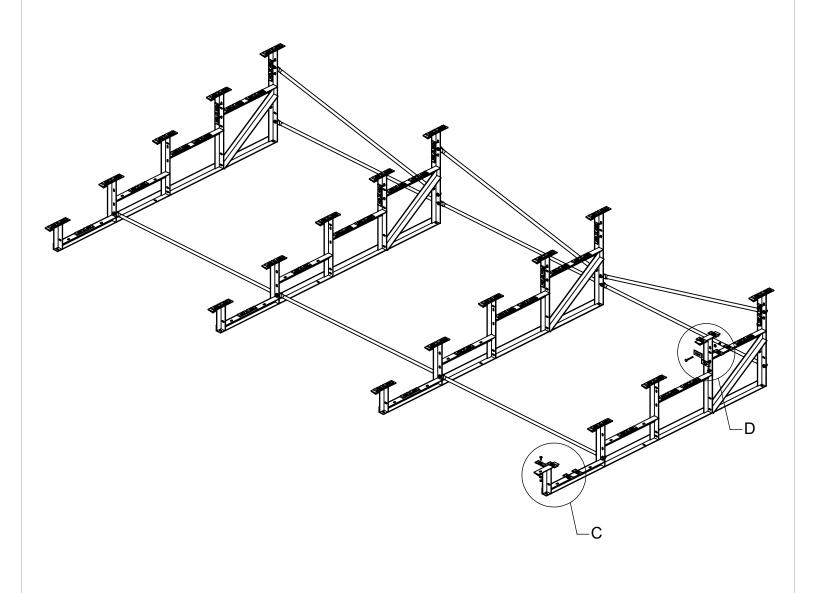


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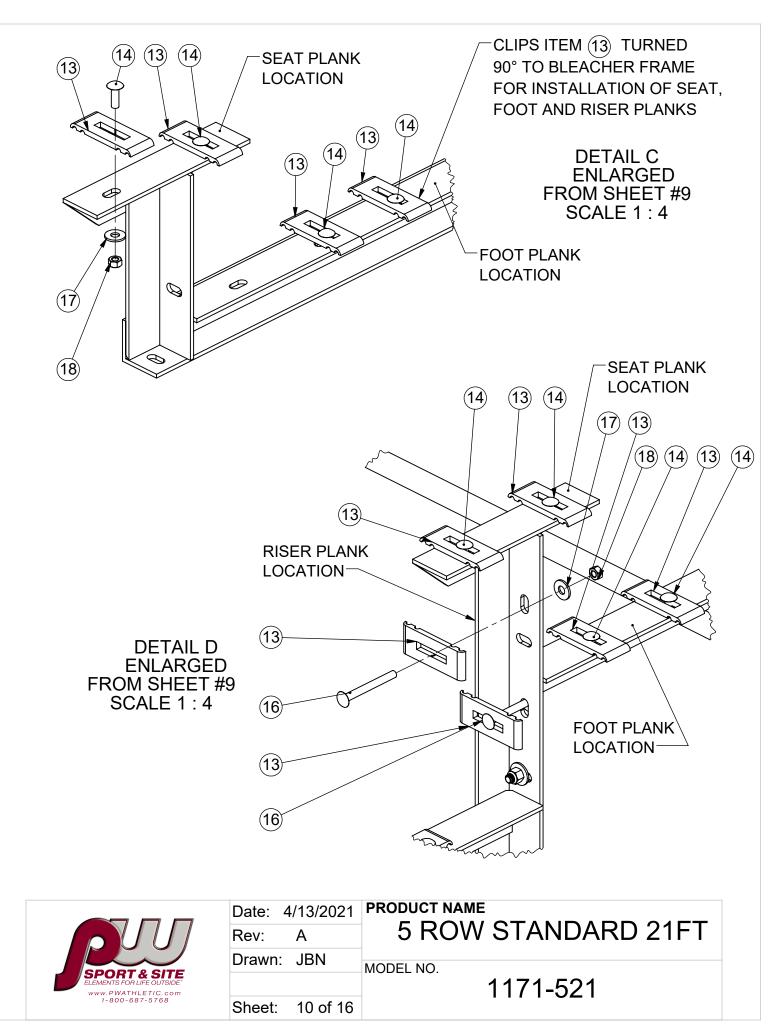




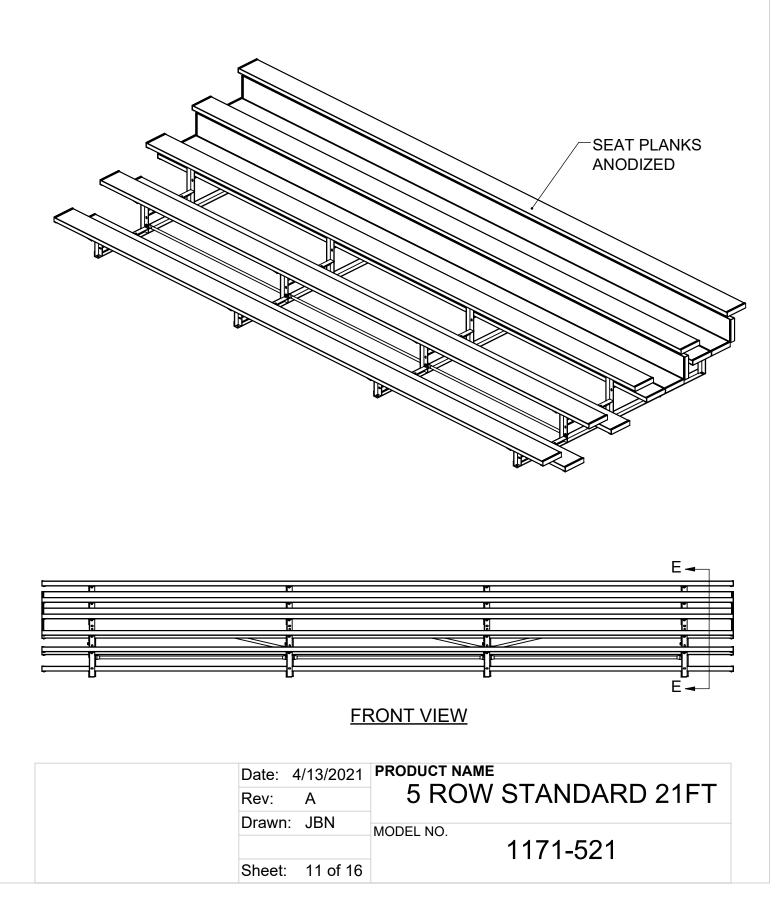
6) To Install Seat and Foot Planks: a) First install the Bolt Clip For 10" & 12" Aluminum Plank Item (13) using 5/16" x 1" carriage bolts Item (14), washer Item (17), and lock nuts (18) on top of the seat and foot board supports. To install clips for riser planks using 5/16" x 3" carriage bolts Item (16), washer Item (17), and lock nuts (18). Give nuts about 3/4 turn (just enough to secure). Turn Bolt Clips Item (13) perpendicular to the frames.

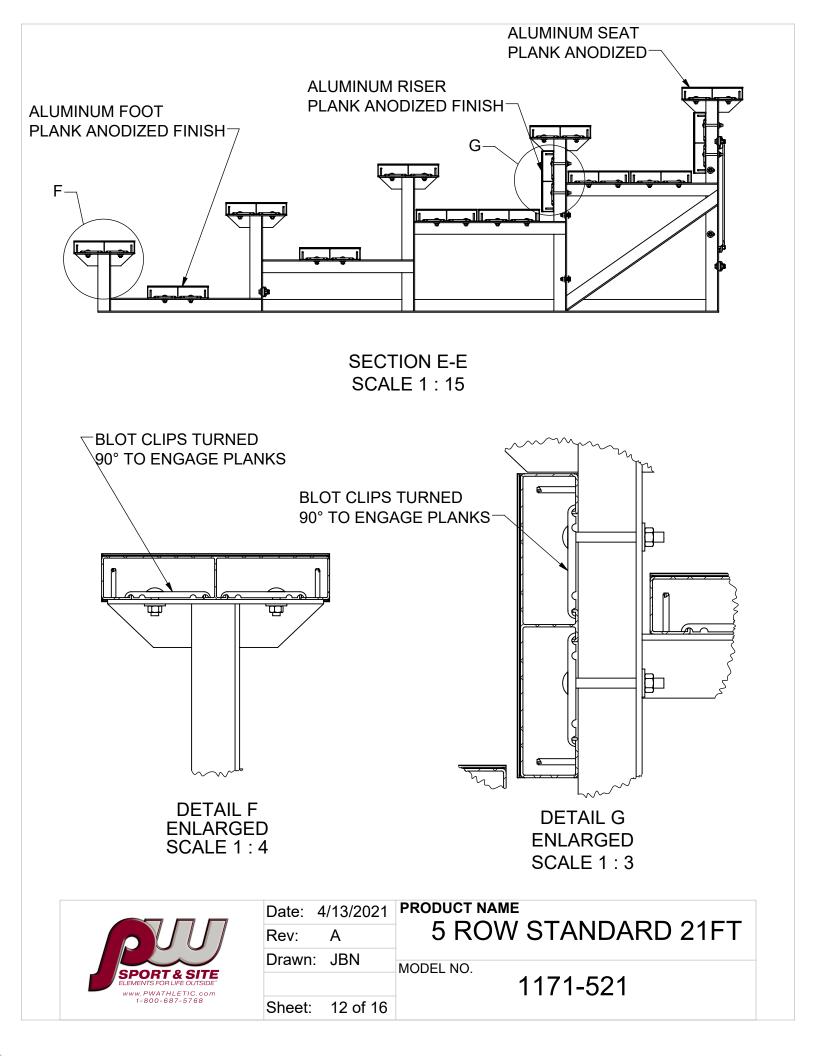


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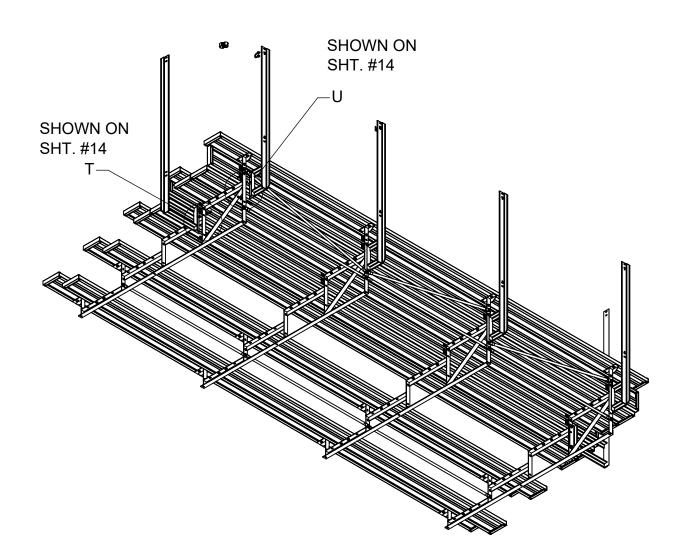


7) Position seat Planks, Foot Planks and Riser Planks on the supports so the Bolt Clips Item (13) are between the slots in the bottom of Planks. Reach up underneath the Seat Plank, Foot Plank, and Riser Plank to rotate the Bolt Clips Item (13) to 90° so they engage the planks. To Secure Planks to Frames center planks on frames Item (1). Tighten all hardware on frames and planks securely.

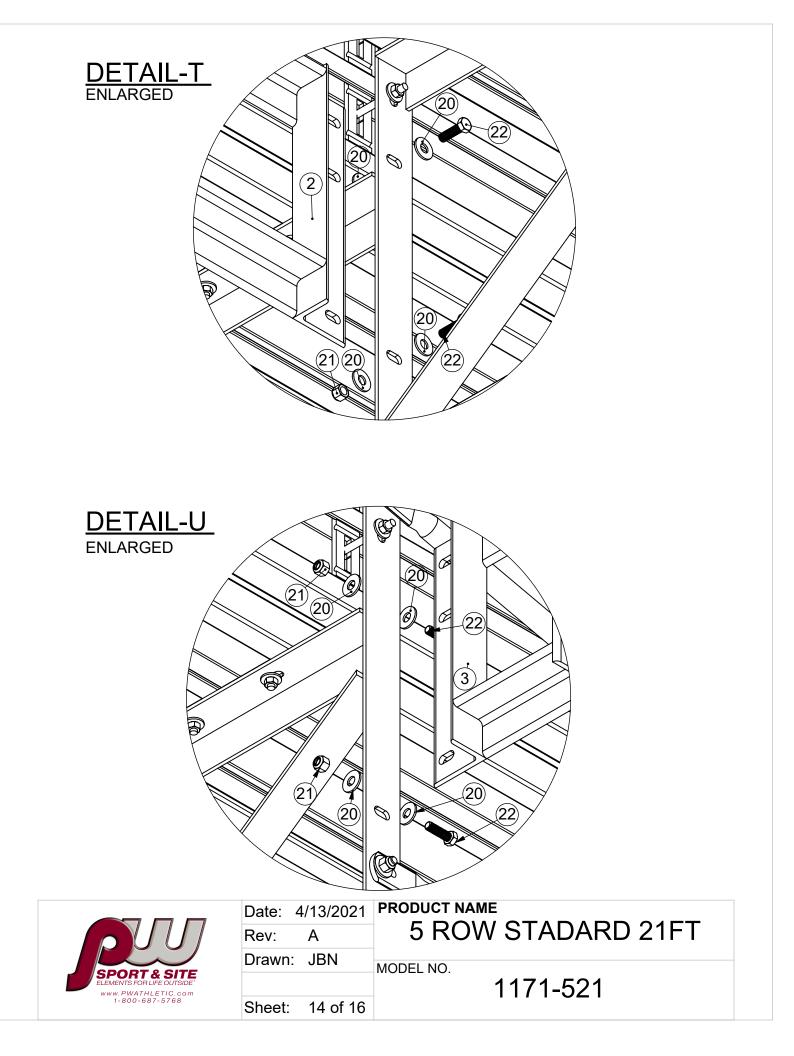




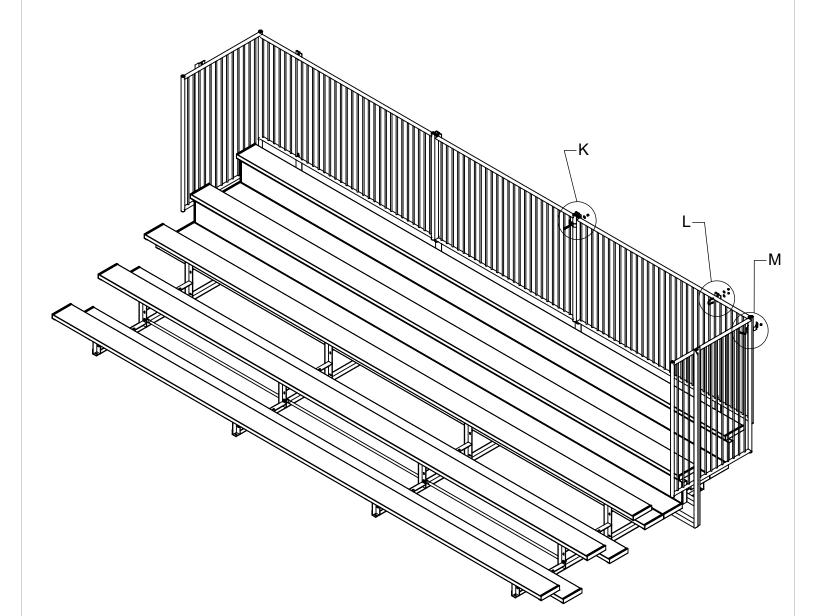
8) Install Right, Left and Rear F-Frame Panel Support Items (2) (3) (4). Attach to Bleacher Frames with 3/8" x 1-1/2" hex bolts Item (22), washers Item (20) and lock nuts Item (21).



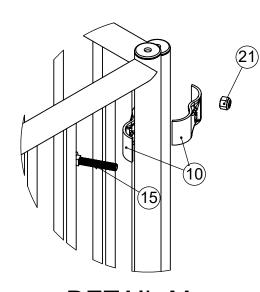
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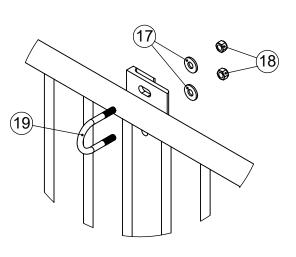
9) Install Railing Side and Rear Panels Items (5) (6) (7). Attach Railing Side Panel Item (5) to Right F-Frame Panel Support Item (2) with 5/16" U-Bolt Item (19), washers Item (17) and lock nuts Item (18) Attach Railing Rear Long Panel Item (6) to Rear F-Frame Panel Support Item (3) using 5/16" U-Bolt Item (19), washers Item (17), lock nuts Item (18), Panel Clamp Item (10), 3/8" x 2-1/2" Carriage bolts Item (15), washers Item (20) and lock nuts Item (21). Repeat with the rest of the Railing Panels.



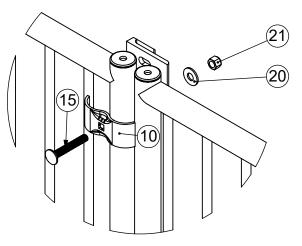
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DETAIL-L ENLARGED FROM SHT. #15



DETAIL-K ENLARGED FROM SHT. #15

INSTALLATION INSTRUCTIONS:

15) Installing (Optional) Ground Sills (wood measuring 2" x 6" x 8'-1"): 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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