

### Installation and Assembly Instructions



Gared Holdings, LLC  
 9200 E. 146th St.  
 Noblesville, IN 46060

<b>21' ALUMINUM BLEACHER 5 ROW WITH DOUBLE FOOT PLANKS</b>			
FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000			
DATE	SHT. NO.	PART NO.	REV
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## *Introduction/Liability Disclaimers*

Thank you for your purchase of the Fixed Aluminum Bleachers. This guide will provide information on the proper assembly and installation methods of your bleachers.

Please note that a Bill of Materials is being included with this guide. Please check that all of the parts called out on the Bill of Materials are present prior to beginning assembly. Please do not substitute for factory parts. Please contact the PSS or Gared Sports customer service department and allow them to determine if substitute parts are acceptable.

It is recommended that an individual who has been properly trained perform assembly and set up of the bleachers. No one under the age of 18 should attempt assembly or set up of the unit, unless properly supervised.

To prevent normal wear and tear from shortening the life of the unit, preventative maintenance inspections and repairs should be performed at least once per year. If the units are subject to high or unusual usage, inspections should be scheduled to occur more frequently. If items are found to be nonconforming, replacements can be ordered from PSS or Gared Sports or one of our authorized dealers. When contacting PSS or Gared Sports, please have information regarding the dealer/installer who sold the unit, the name of the project, and any applicable warranty information.

800-325-2682 -- Gared Customers  
800-848-8034 -- PSS Customers

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MATERIAL LIST				
ITEM	QTY	PART NUMBER	DESCRIPTION	LENGTH
1	8	198011026-21	PLANK, FOOT 10" MILL FINISH X 21'	252.00 in
2	5	198011026-21AN	PLANK, SEAT 10" ANNODIZED X 21'	252.00 in
3	3	198011027-21	PLANK, RISER 6" MILL FINISH X 21'	252.00 in
4	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	252.00 in
5	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	38.75 in
6	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	42.00 in
7	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	44.00 in
8	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	51.00 in
9	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	66.00 in
10	20	101051052	U-BOLT, 5/16-18 X 1.75 X 2.688 GALV	
11	44	108011049	ALUM WIRE TIE 9 GA X 8.5" LONG	
12	4	498011020	REAR GUARD WELDMENT	
13	4	498011025	BAR, SIDE REAR TENSION (50 IN)	
14	2	498011026	BAR, SIDE FRONT TENSION (43 IN)	
15	4	498011029	FRAME WELDMENT 5 ROW	
16	4	498011030	BRACE ANGLE - 75.44 LONG	
17	4	498011031	BRACE ANGLE - 78.62" LONG	
18	26	498011033	END CAP, BLEACHER SEAT	
19	6	498011034	END CAP, BLEACHER RISER	
20	116	498011035	MOUNTING CLIP	
21	8	498011076	PLASTIC CAP, 1.62 TUBE	
22	2	498011092	BRACE ANGLE - 74.00" LONG	
23	2	498011111	SIDE RAIL WELDMENT, LH	
24	2	498011112	SIDE RAIL WELDMENT, RH	
25	12	498011125	BLEACHER RISER MOUNTING ANGLE	
26	8	498011139	#3 ELBOW, 1-5/8" O.D. TUBING	
27	8	498011148	PLATE, SIDE RAIL CLAMP	
28	2	498011326	CHAIN LINK 5 ROW SIDE GUARD	
29	18	651653934	HEAVY TENSION BAND, 1-5/8"	
30	64	6044-11-00	1/8" POP RIVET	
31	116	501-5-18-16G	BOLT, CARRIAGE 5/16-18 UNC X 1 GALV	
32	18	501-6-16-24G	BOLT, CARRIAGE 3/8-16 UNC X 1.5 GALV	
33	12	502-5-18-16G	HEX BOLT, 5/16-18 UNC X 1 GALV	
34	28	502-6-16-16G	HEX BOLT, 3/8-16 UNC X 1 GALV	
35	16	502-6-16-40G	HEX BOLT, 3/8-16 UNC X 2.5 GALV	
36	168	548-5-18G	HEX NUT, SERRATED FLANGE 5/16-18 GALV	
37	62	548-6-16G	HEX NUT, SERRATED FLANGE 3/8-16 GALV	
38	21.500 ft	FENCE	42" GALVANIZED CHAIN-LINK FENCE	

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1. Pre-assemble the braces by laying them out in pairs. Place the angles in each pair back to back and connect with a 3/8" x 1" hex bolt and 3/8" Whizlock nut as shown in Figure 1. When assembling the 5 row bleachers, there are two lengths of braces required. Make sure equal length braces are paired in this step.

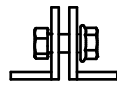
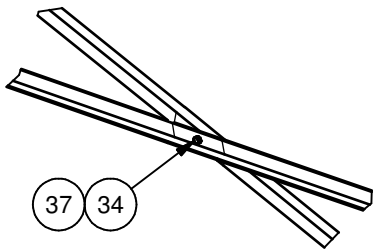
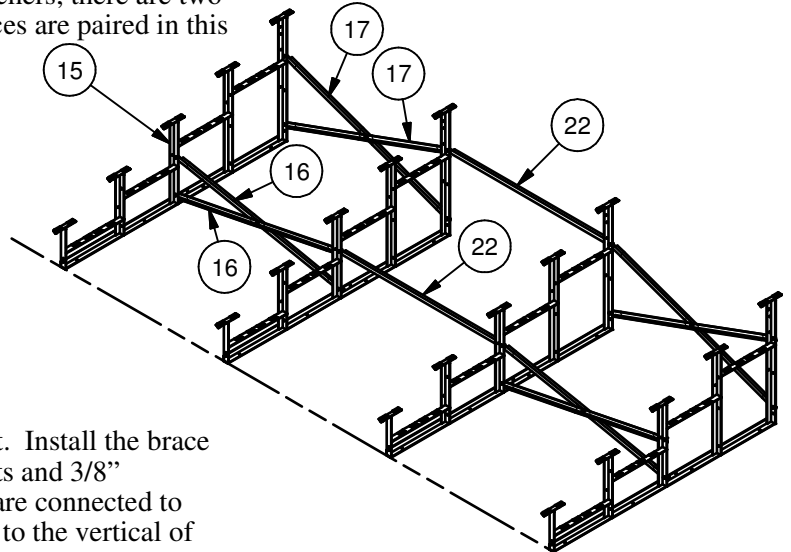


Figure 1



Align and square frames after installation of cross braces

2. Lay out the Frame weldments approximately 6' apart. Install the brace sub-assemblies from step 1 using the 3/8" x 1" hex bolts and 3/8" whizlock nuts as shown in Figure 2. The short braces are connected to the vertical of row 3 and the long braces are connected to the vertical of row 5. After all braces are installed, square the frame and make sure the front of the frame is in line.

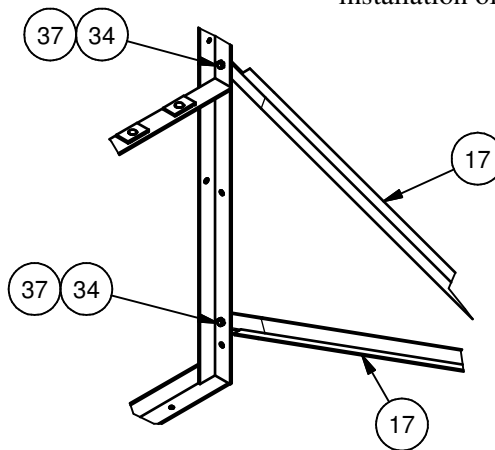
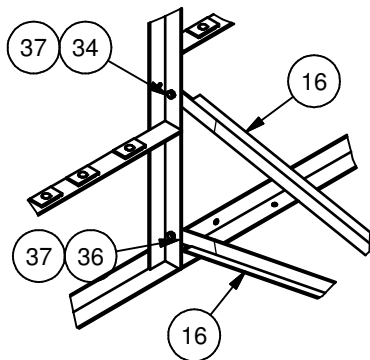


Figure 2

3. Install the end caps on each end of the seat planks, foot planks, and riser planks. Slide the end cap onto the plank with the holes on the underside of the plank. Using the holes in the end cap for a guide, drill a 1/8" hole and install the pop rivets to retain the end caps. See Figure 3.

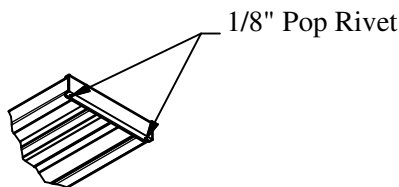


Figure 3

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4. Install the foot planks using the mounting clips, 5/16" carriage bolts, and 5/16" Whizlock. These mounting clips, bolts, and nuts are required at every frame position. Pre-install the mounting clips on the frame using the 5/16" x 1" carriage bolt and 5/16" whizlock nut. Only start the nuts a few threads to allow for the clips to be lifted and rotated into the channel of the bleacher plank.

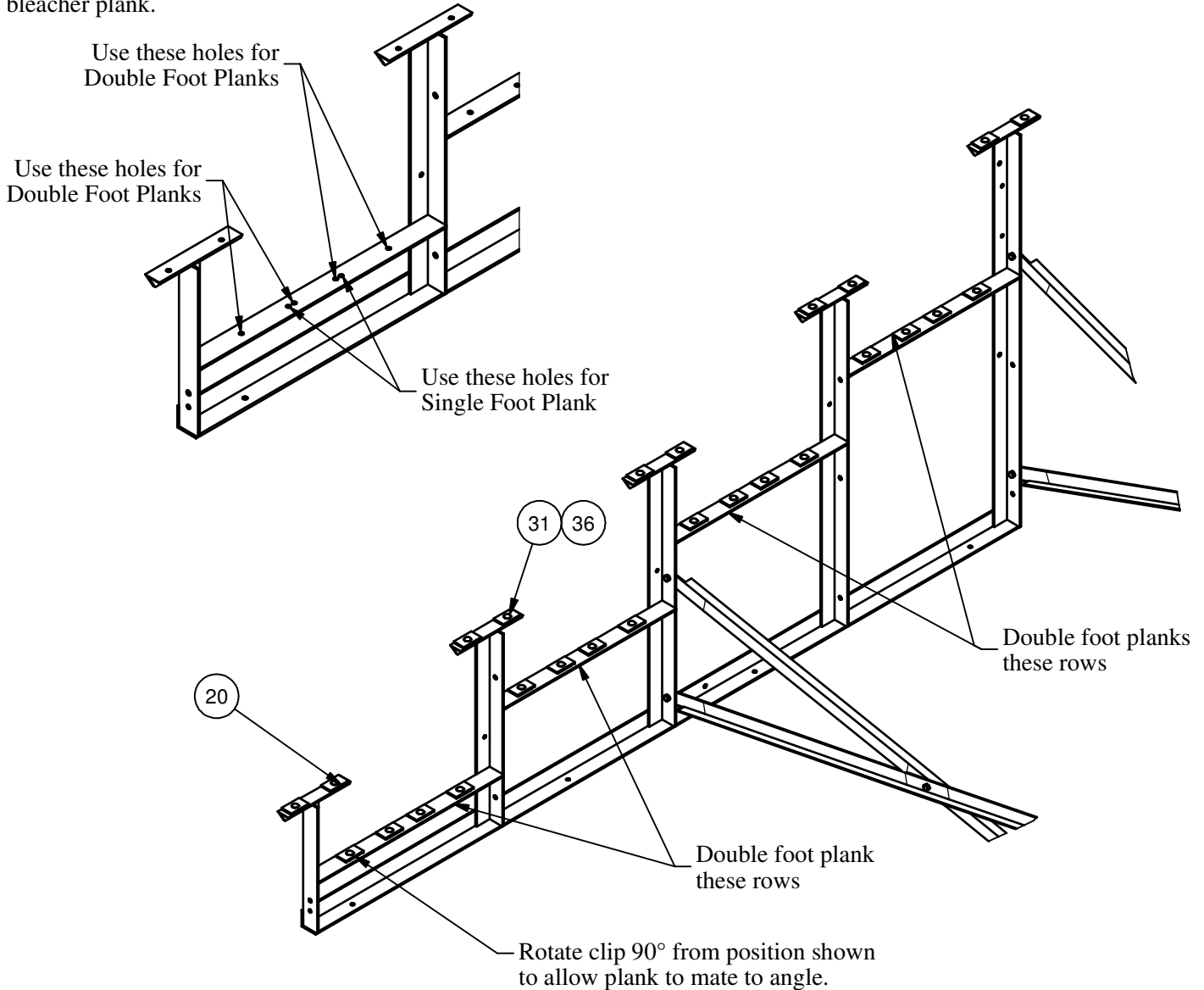


Figure 4

Note: Double foot planks are only used on all rows. All rows above the 3rd seating row must use riser planks.

Install all foot planks before installing riser planks. Install the riser planks then install the seat planks.

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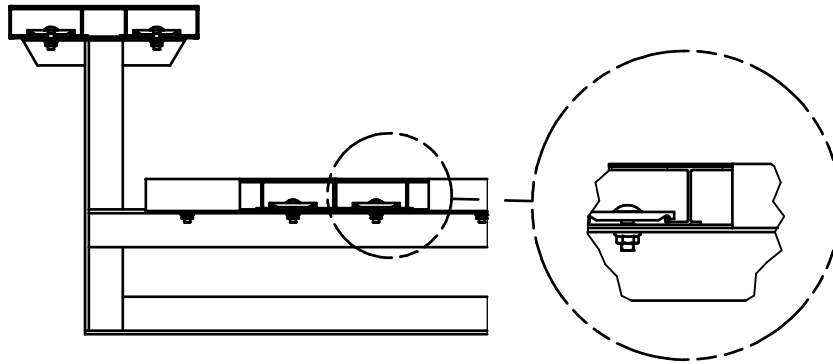


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Plank Clip Illustration

5. Before tightening the foot plank bolts, align all the planks and make sure the planks are centered on the assembled frame. See Figure 5 for reference dimensions.

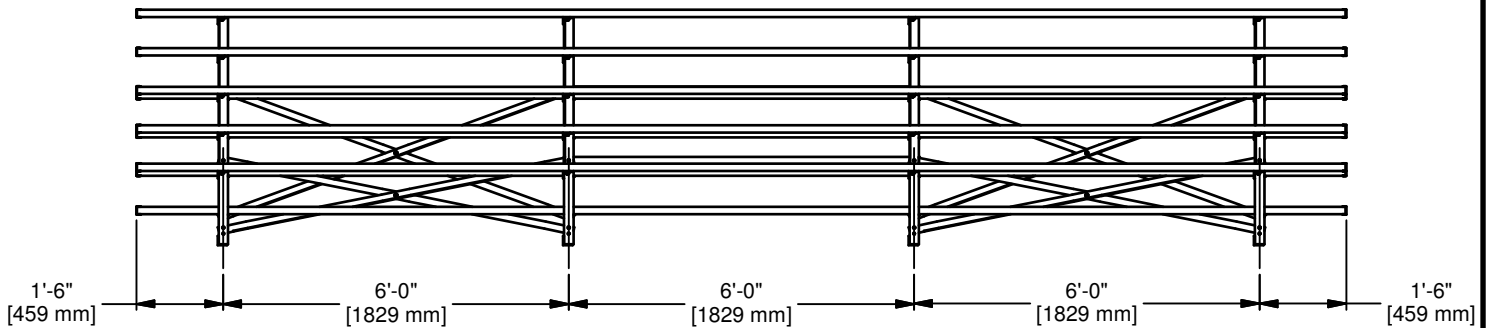
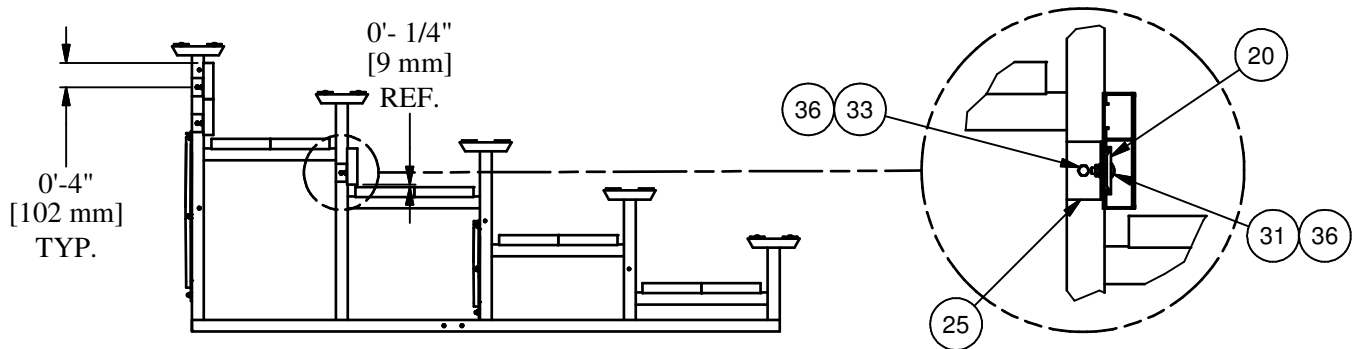


Figure 5

6. Install the riser planks on the 4th and 5th row seat vertical angles. First install the riser mounting angle onto the upright using the 5/16" x 1" hex bolt and 5/16" whizlock nut. Once all the mounting angles have been installed at all frame positions, loosely install the mounting clip with the 5/16" x 1" carriage bolt and 5/16" whizlock nut. See figure 6.

7. Install the riser planks onto the verticals using the same method as the foot planks. Rotate the clip to fit into the slot of the riser planks, then push it up and rotate it back to make sure the clip indent fits onto the riser plank ribs. Align the ends of the riser flush with the foot planks, and tighten all bolts.



Riser Plank Position Illustration

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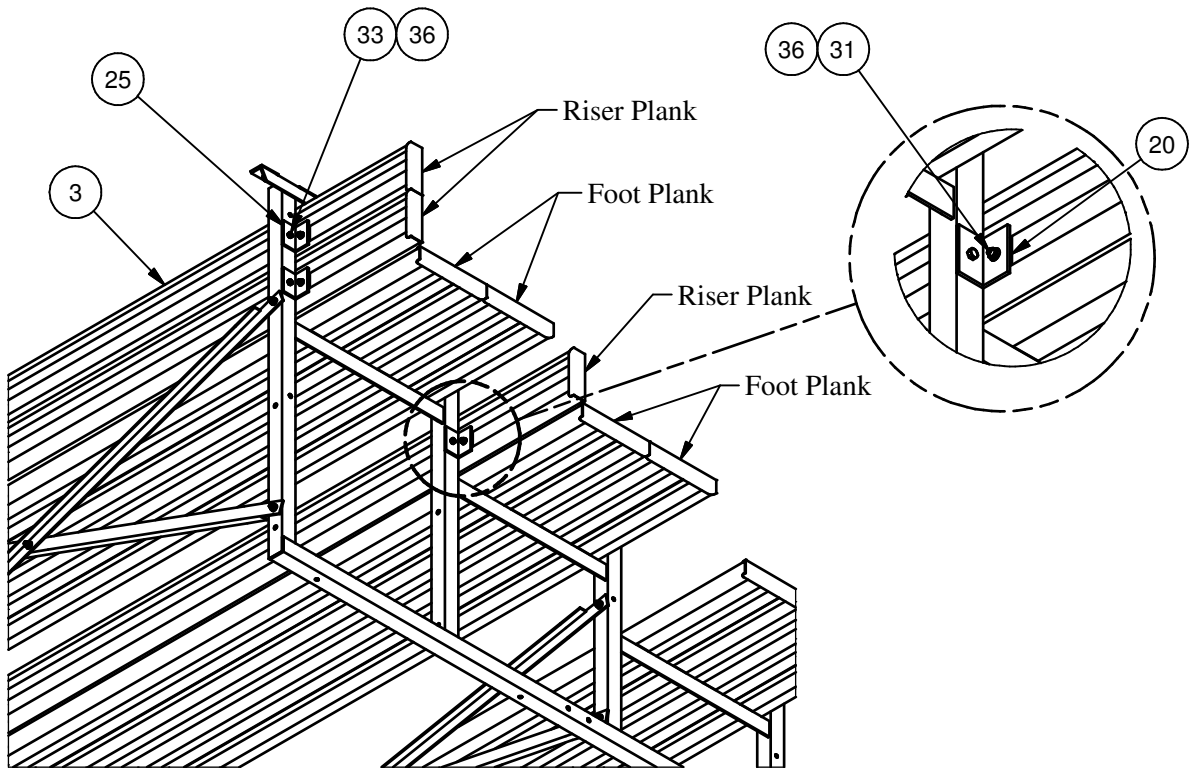


Figure 6

8. Install the seat planks using the mounting clips, 5/16" x 1" carriage bolts, and 5/16" whizlock as shown in figure 4. Note: these mounting clips, bolts, and nuts are required at every frame position.
9. Before tightening the seat plank bolts, align all the planks and make sure the planks are centered on the assembled frame. See Figure 5 for reference dimensions.
10. Check all bolted connections and insure all bolts are securely tightened.

The bleacher portion of the assembly is now complete.

The following instructions will guide you in the installation and attachment of the guard rail and fencing.

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11. Install the rear guard weldment on each frame using the 3/8" x 1" hex bolts and 3/8" whizlock nuts. One weldment is required at each frame location.

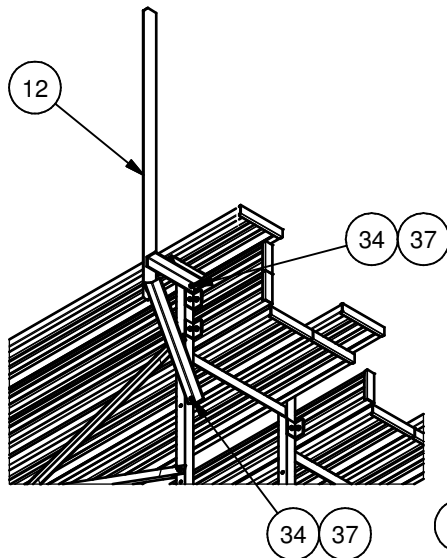


Figure 7

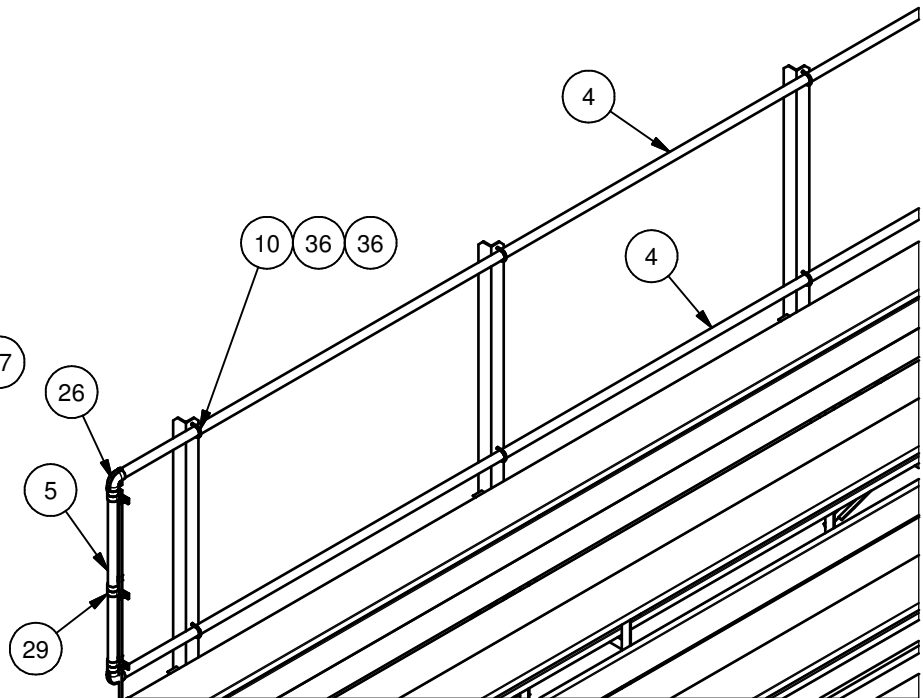
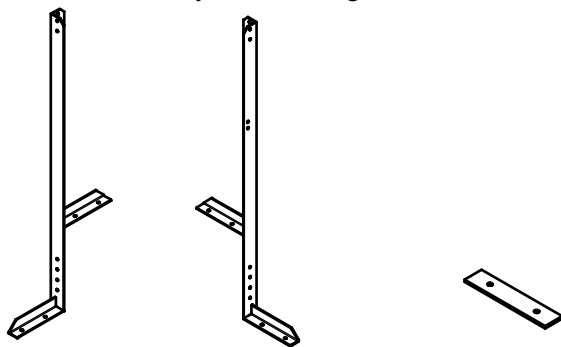


Figure 8

12. Attach the 21' long guard rail pipes onto the weldments using the 5/16" U-Bolts and 5/16" whizlock nuts. One pipe will be attached to the top hole locations on the weldment and one pipe will be attached to the bottom hole locations on the weldment. Before tightening the U-Bolts, make sure the ends of the pipes are flush with the ends of the bleacher seats. Tighten all U-Bolts.

13. Attach the 38.75" long tube to the pipes installed in the last step using the #3 elbows. Slide 6 heavy tension bands onto the pipe before adding the elbows. Alternate the position of the tension band so that 3 will have the flat side out on the side fence and the other three will have the flat side toward the back on the rear fence. Add an elbow to each end of the pipe and insert the elbows onto the long pipes and tighten all the set screws.

14. Before installing the side guard rails, lay out the parts to make sure the right hand weldments and left hand weldments are ready to be installed on the correct end of the bleacher. For the purposes of this installation, the right hand side is the right hand end of the bleacher as you are sitting on the seat. The parts required for installing the side guard upright are shown below.



498011112  
Right Hand

498011111  
Left Hand

498011148

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15. Install the side rail weldments onto the ends of the bleacher. Locate one vertical on the top row and one vertical on the 4th row. Position the verticals as shown in figure 9. Using the holes in the angles, drill the four 3/8" holes through the seat plank (2 holes) and the foot planks (2 holes). Attach the verticals using the 3/8" x 2.5" hex bolts and 3/8" whizlock nuts. Make sure the clamp plate is placed on the underside of the plank before installing the nuts. Tighten all bolts and nuts securely.

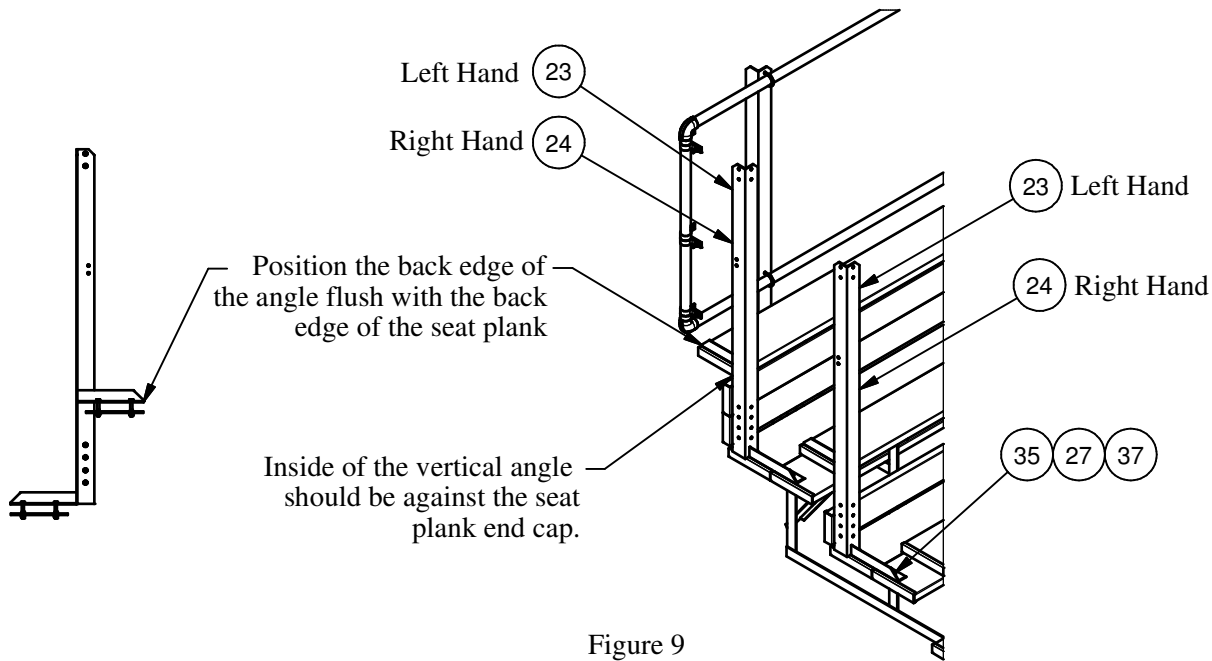


Figure 9

16. Install the side guard rail pipes on each end of the bleacher.

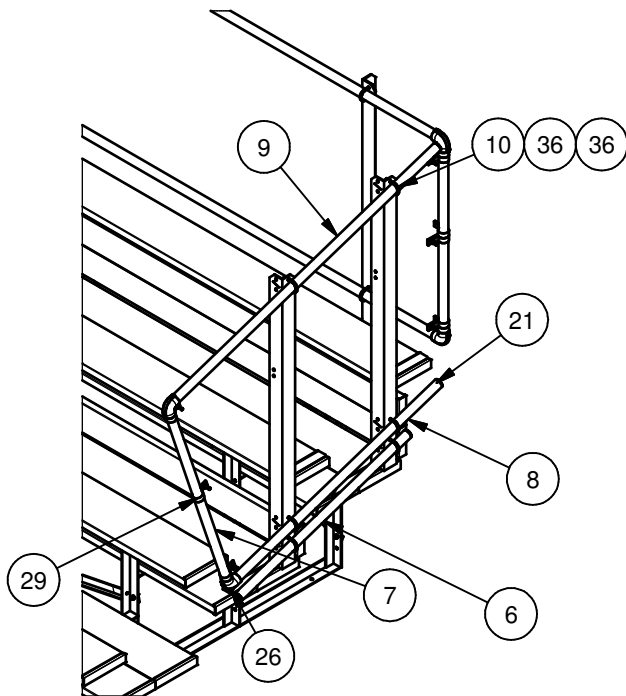


Figure 10

Install the 66.0" long pipe on the top set of holes in the vertical using the 5/16" U-Bolt and 5/16" whizlock nuts. The upper end of the pipe should be about 1" from the rear guard rail pipe. Tighten the U-Bolt nuts and install the plastic cap in the top end of the pipe.

Install the 51.0" long pipe on the center (top bottom) set of holes in the vertical using the 5/16" U-Bolt and 5/16" whizlock nuts. Do not tighten nuts.

Attach the 44.0" long tube to the pipes installed in the last step using the #3 elbows. Slide 3 heavy tension bands onto the pipe before adding the elbows. Insert an elbow on each end of the pipe and then insert the elbows onto the longer pipes and tighten all set screws. Now tighten the U-Bolt nuts on the lower pipe installed earlier.

Install the 42.0" long pipe on the bottom set of holes in the vertical using the 5/16" U-Bolt and 5/16" whizlock nuts. The lower end of the pipe should be flush with the elbow installed on the adjacent pipe. Tighten all U-Bolt nuts.

Install the plastic caps on all open ends of the installed pipes.

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17. Install the side chain link sections using the heavy tension bands and the 50" long tension bars. The tension bars are pre-installed in the chain link fence at the factory. Start with the bias end of the chain link fence at the rear of the side and attach the tension bar using (3) of the tension bands on the rear vertical. Attach the other tension bar to the front vertical pipe using (3) tension bands. It may be necessary to cut the fence before attaching the tension bar to the front vertical. Tie the chain link to the top and bottom horizontal pipes using the aluminum wire ties approximately 18" apart.

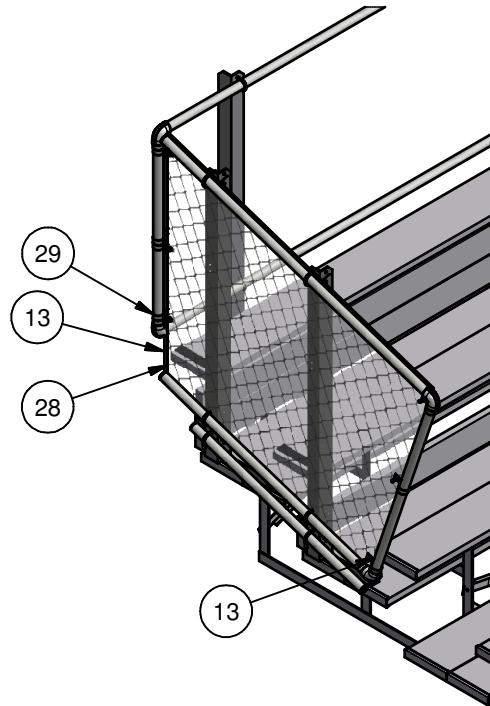


Figure 11

18. Install the 42" wide chain link to the rear of the bleacher. Using the 43" long tension bars. The tension bars are pre-installed on the chain link fabric at the factory. Start at one end and attach the tension bar to the vertical end pipe using (3) tension bands. Pull the fencing along the back of the bleacher and tie the chain link to the top and bottom horizontal pipes using the aluminum wire ties approximately 18" apart. At the opposite end, it may be necessary to cut the length of the fence. Attach the end of the cut fence to the opposite end pipe by attaching to the pipe using (3) tension bands.

19. Recheck all bolted connections to make sure all bolts and nuts are tightened securely.

20. Make sure the bleacher is positioned correctly and anchored in accordance with local conditions.

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