

### Installation and Assembly Instructions



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

#### 21' TRANSPORTABLE ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

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## *Introduction/Liability Disclaimers*

Thank you for your purchase of the Transportable Aluminum Bleacher. 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	1	198011026-21AN	PLANK, SEAT 10" ANNODIZED X 21'	252.00 in
3	8	198011026-9AN	PLANK, SEAT 10" ANNODIZED X 8.25'	99.00 in
4	5	198011027-21	PLANK, RISER 6" MILL FINISH X 21'	252.00 in
5	4	198011032	PLANK, AISLE STEP 5.5" MILL FINISH	57.00 in
6	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	252.00 in
7	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	38.75 in
8	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	42.00 in
9	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	44.00 in
10	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	51.00 in
11	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	66.00 in
12	20	101051052	U-BOLT, 5/16-18 X 1.75 X 2.688 GALV	
13	44	108011049	ALUM WIRE TIE 9 GA X 8.5" LONG	
14	4	498011020	REAR GUARD WELDMENT	
15	4	498011025	BAR, SIDE REAR TENSION (46 IN)	
16	2	498011026	BAR, SIDE FRONT TENSION (40 IN)	
17	4	498011029	FRAME WELDMENT 5 ROW	
18	4	498011030	BRACE ANGLE - 75.44 LONG	
19	4	498011031	BRACE ANGLE - 78.62" LONG	
20	34	498011033	END CAP, BLEACHER SEAT	
21	10	498011034	END CAP, BLEACHER RISER	
22	184	498011035	MOUNTING CLIP	
23	8	498011076	PLASTIC CAP, 1.62 TUBE	
24	2	498011092	BRACE ANGLE - 74.00" LONG	
25	2	498011111	SIDE RAIL WELDMENT, LH	
26	2	498011112	SIDE RAIL WELDMENT, RH	
27	20	498011125	BLEACHER RISER MOUNTING ANGLE	
28	12	498011133	BLEACHER STEP MOUNTING ANGLE	
29	8	498011139	#3 ELBOW, 1-5/8" O.D. TUBING	
30	1	498011140	HAND RAIL WELDMENT 3 STEP	
31	8	498011148	PLATE, SIDE RAIL CLAMP	
32	4	498011149	ANGLE, HAND RAIL CLAMP	
33	8	498011183	END CAP SHORT	
34	2	498011326	CHAIN LINK 5 ROW SIDE GUARD	
35	18	651653934	HEAVY TENSION BAND, 1-5/8"	
36	108	6044-11-00	1/8" POP RIVET	
37	19.000 ft	921041001	ABRASIVE ANTISLIP TAPE 2" WIDE	
38	184	501-5-18-16G	BOLT, CARRIAGE 5/16-18 UNC X 1 GALV	
39	18	501-6-16-24G	BOLT, CARRIAGE 3/8-16 UNC X 1.5 GALV	
40	20	502-5-18-16G	HEX BOLT, 5/16-18 UNC X 1 GALV	
41	46	502-6-16-16G	HEX BOLT, 3/8-16 UNC X 1 GALV	
42	20	502-6-16-40G	HEX BOLT, 3/8-16 UNC X 2.5 GALV	
43	244	548-5-18G	HEX NUT, SERRATED FLANGE 5/16-18 GALV	
44	84	548-6-16G	HEX NUT, SERRATED FLANGE 3/8-16 GALV	
45	21.500 ft	FENCE	42" GALVANIZED CHAIN-LINK FENCE	
46	2	498011396	AXLE BRACKET FRAME BRACE	
47	2	498011397	TRANSPORT ANGLE STANDARD LENGTH	
48	2	498011395	AXLE BRACKET WELDMENT	
49	2	498011399	PULL TUBE GUIDE PLATE	
50	1	498011400	ANGLE, PULL POINT BRACKET	
51	6	561-6G	FLAT WASHER 3/8 GALV	

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1. Layout all parts and check against the BOM on page 3.

2. 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 2. When assembling the 10 row bleachers, there are two lengths of braces required. Make sure equal length braces are paired in this step.

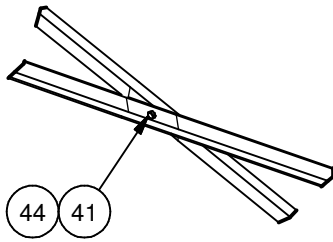


Figure 1

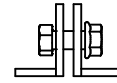


Figure 2

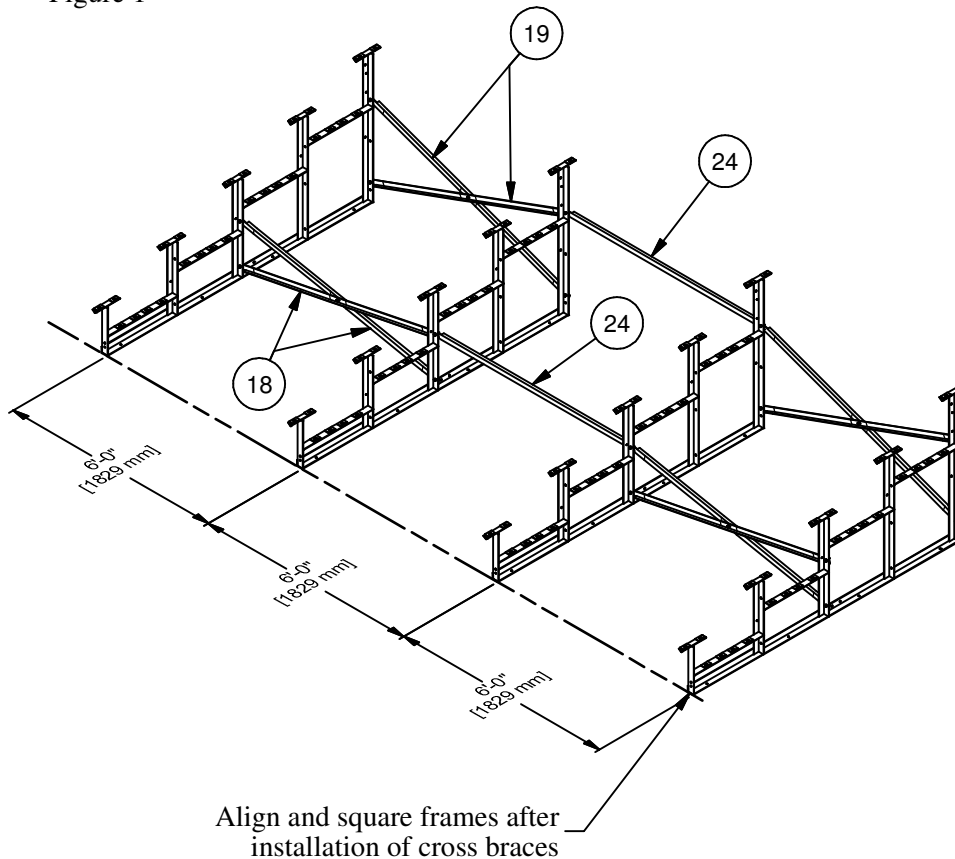


Figure 3

3. Lay out the Frame weldments approximately 6' apart. Refer to figure 3 for proper frame spacing. Install the brace sub-assemblies from step 2 using the 3/8" x 1" hex bolts and 3/8" whizlock nuts as shown in Figure 4. Cross braces are connected to the frames at verticals 3 and 5. Refer to figure 3 for item number and page 2 for brace angle length. NOTE: Cross braces are located in the end bays. Straight spacer braces are located in the center bay at row 3 and row 5 only. After all braces are installed, square the frame and make sure the front of the frame is in line.

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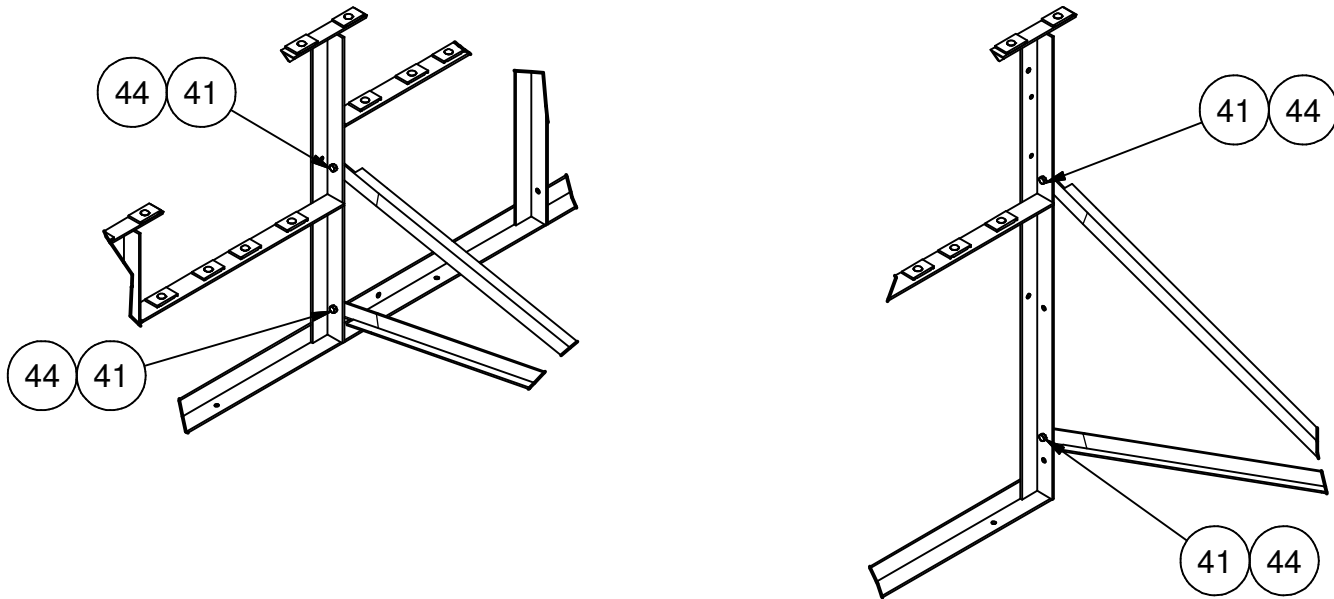


Figure 4

4. 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 5.

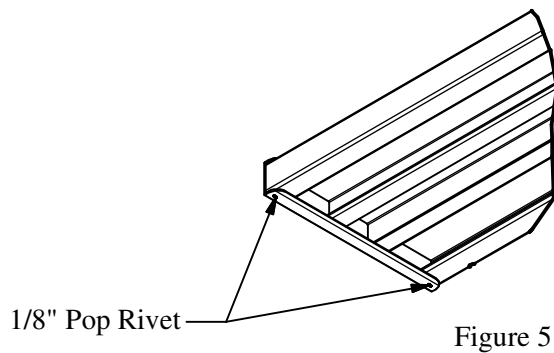


Figure 5

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5. 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.

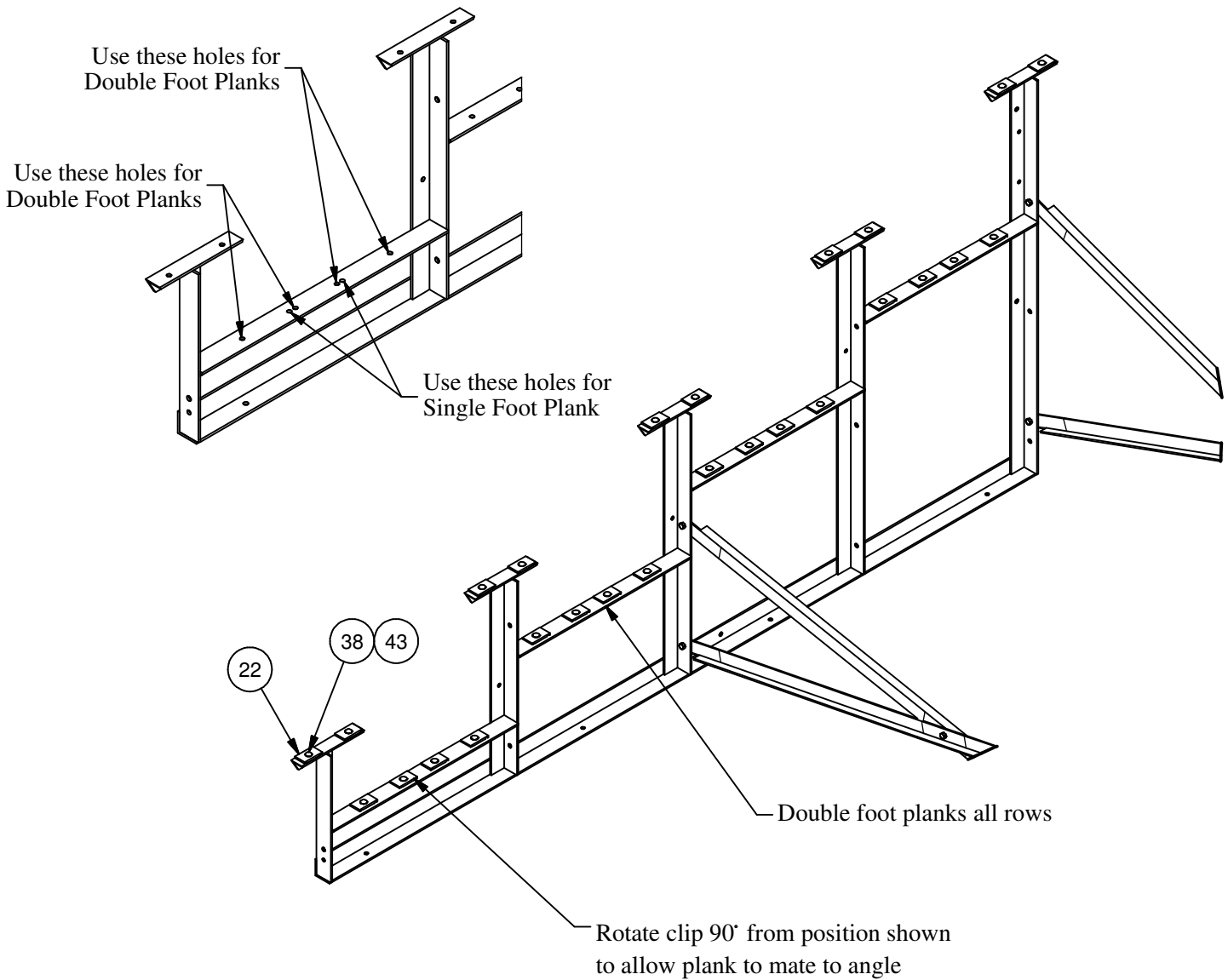


Figure 6

Note: Double foot planks are used on all foot rows. All rows must use double foot planks and riser planks.

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

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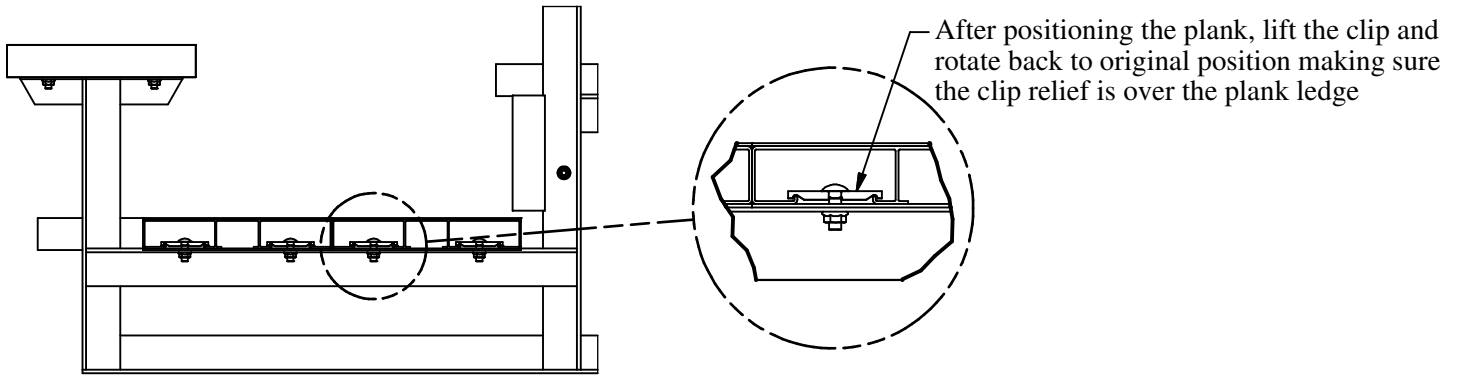
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Plank Clip Illustration

6. Before tightening the foot plank bolts, align all the planks and make sure the planks are centered on the assembled frame. See Figure 7 for reference dimensions.

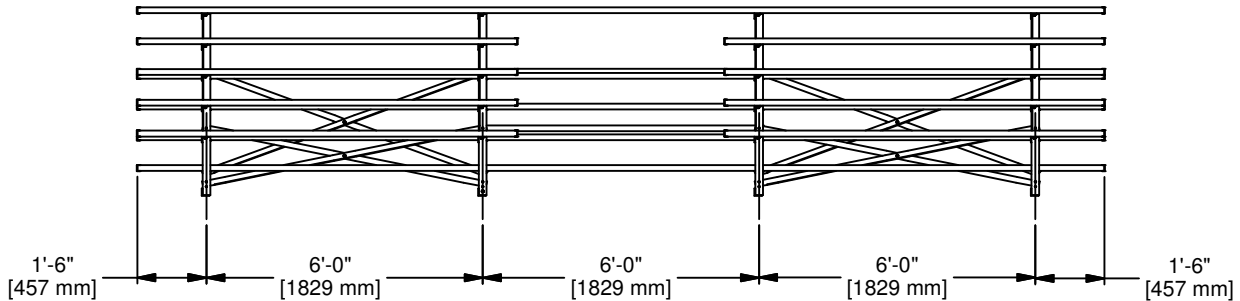
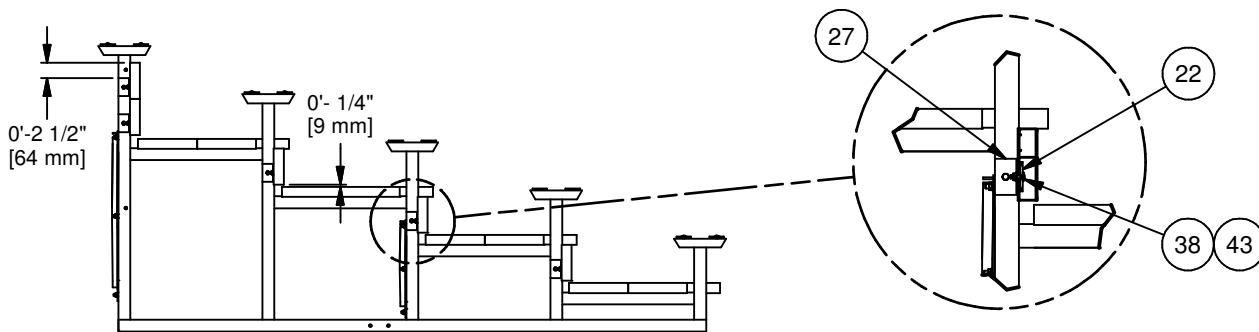


Figure 7

7. Install the riser planks on the 2nd through 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. Note: Two (2) angles are used on the top row verticals. 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 8.

8. 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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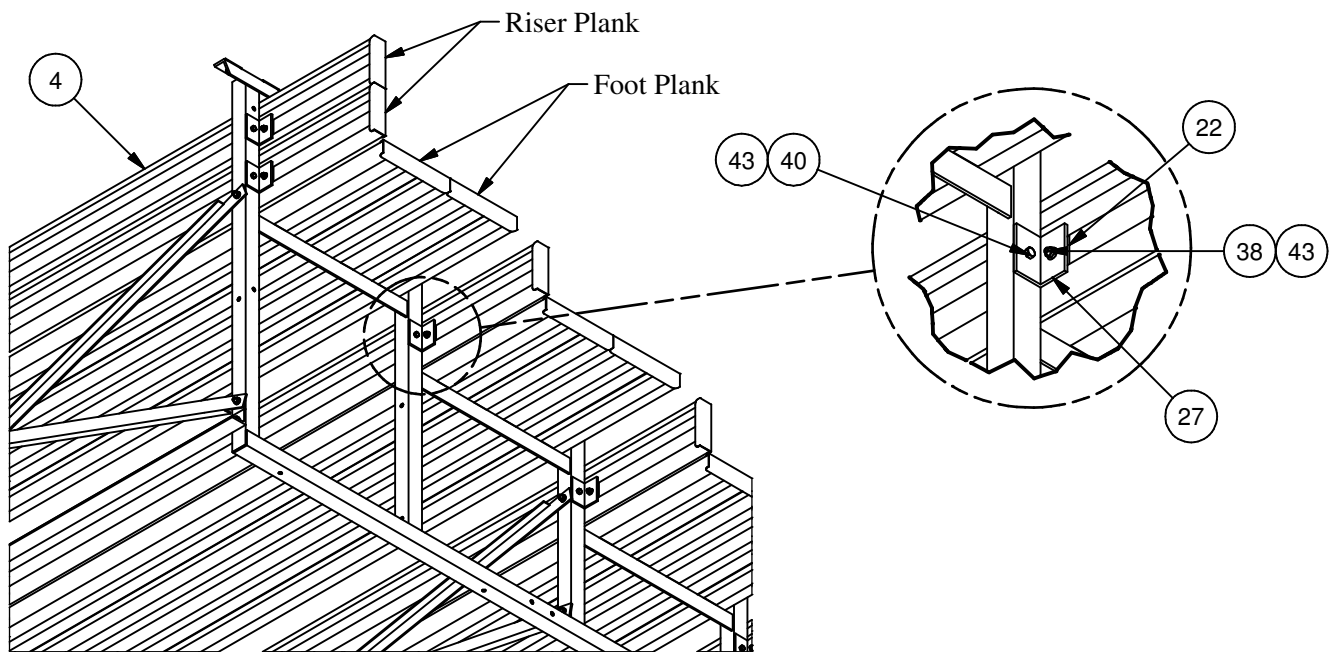


Figure 8

9. Install the seat planks using the mounting clips, 5/16" x 1" carriage bolts, and 5/16" whizlock as shown in figure 6. Note: these mounting clips, bolts, and nuts are required at every frame position.

10. 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.

11. Check all bolted connections and insure all bolts are securely tightened.

The bleacher portion of the assembly is now complete except for the hand rails and aisle step planks.

The following instructions will guide you in the installation and attachment of the guard rail, fencing, hand rails and aisle step planks.

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12. 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.

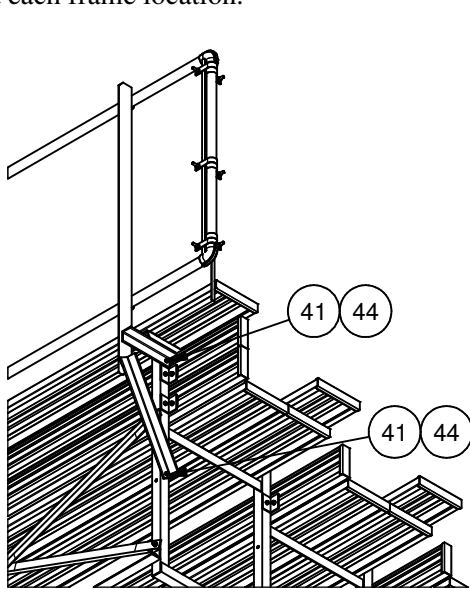


Figure 9

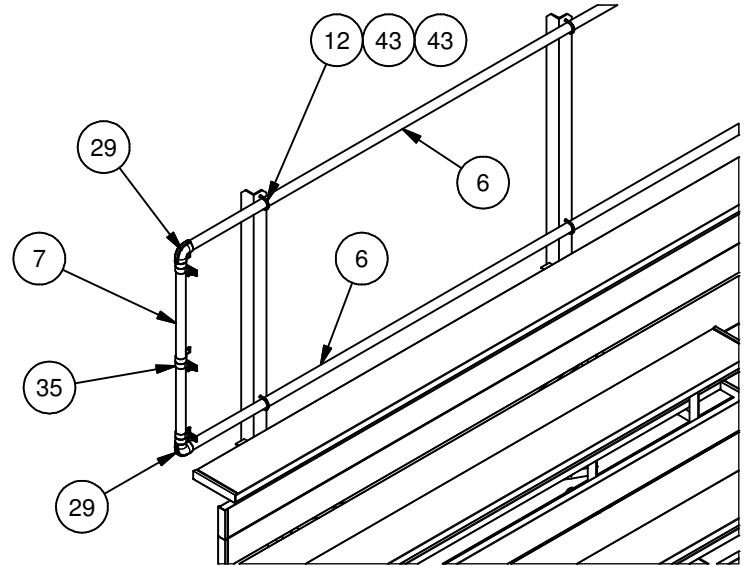
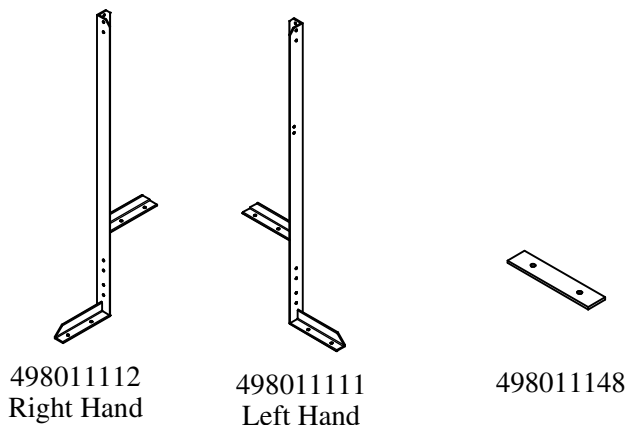


Figure 10

13. 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.

14. 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.

15. 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.



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16. Install the side rail weldments onto the ends of the bleacher. Locate one vertical on the top row and 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.

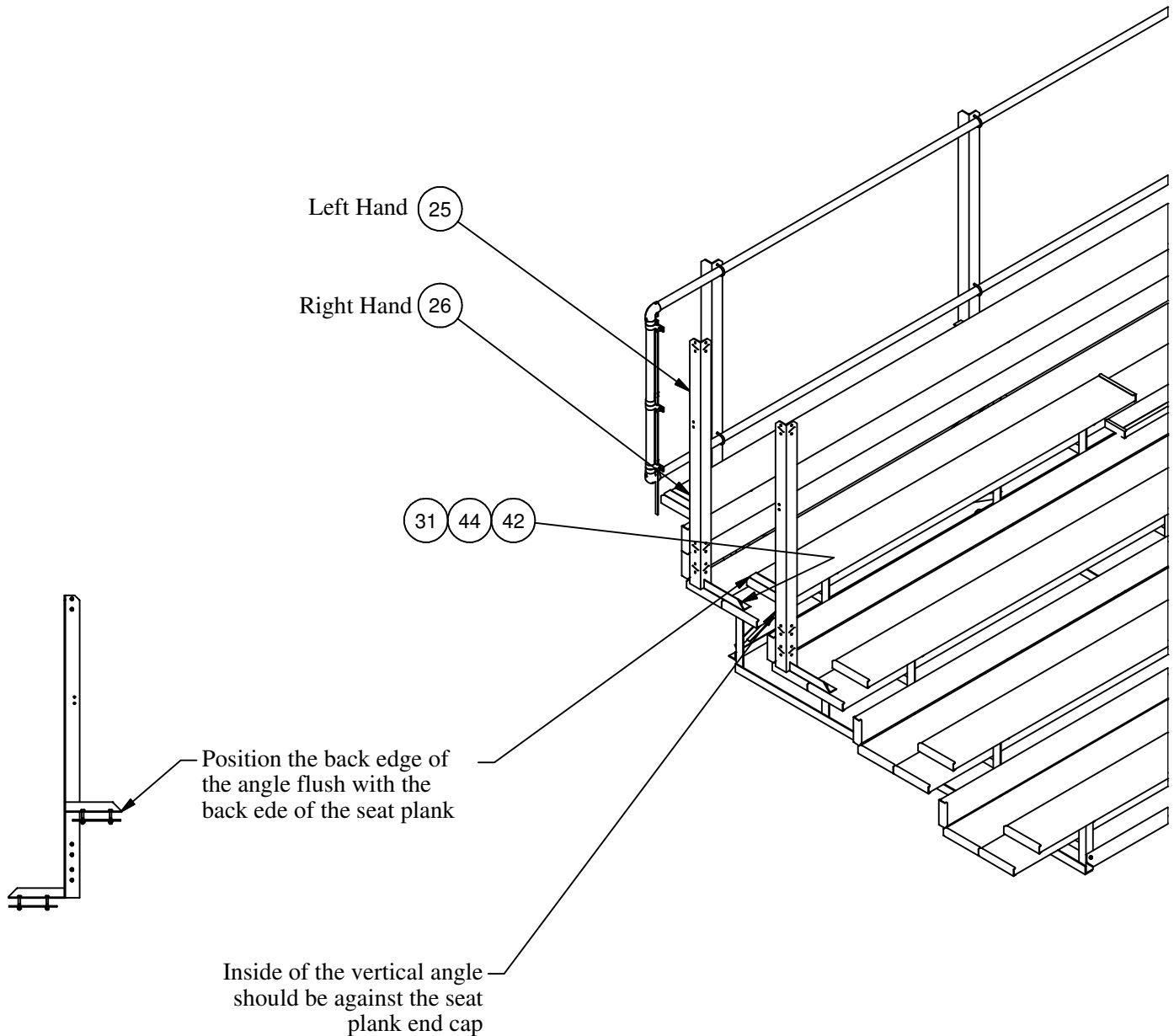


Figure 11

### Installation and Assembly Instructions



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

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.

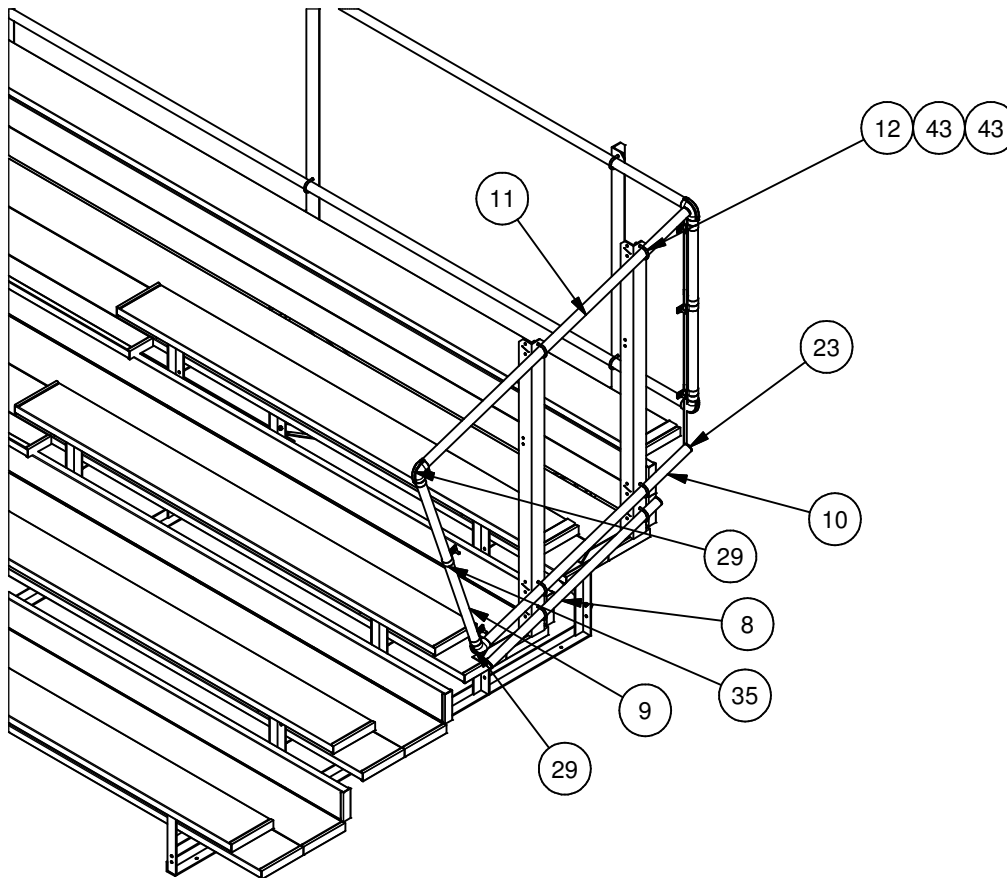


Figure 12

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18. Install the side chain link sections using the heavy tension bands and the 46" 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.

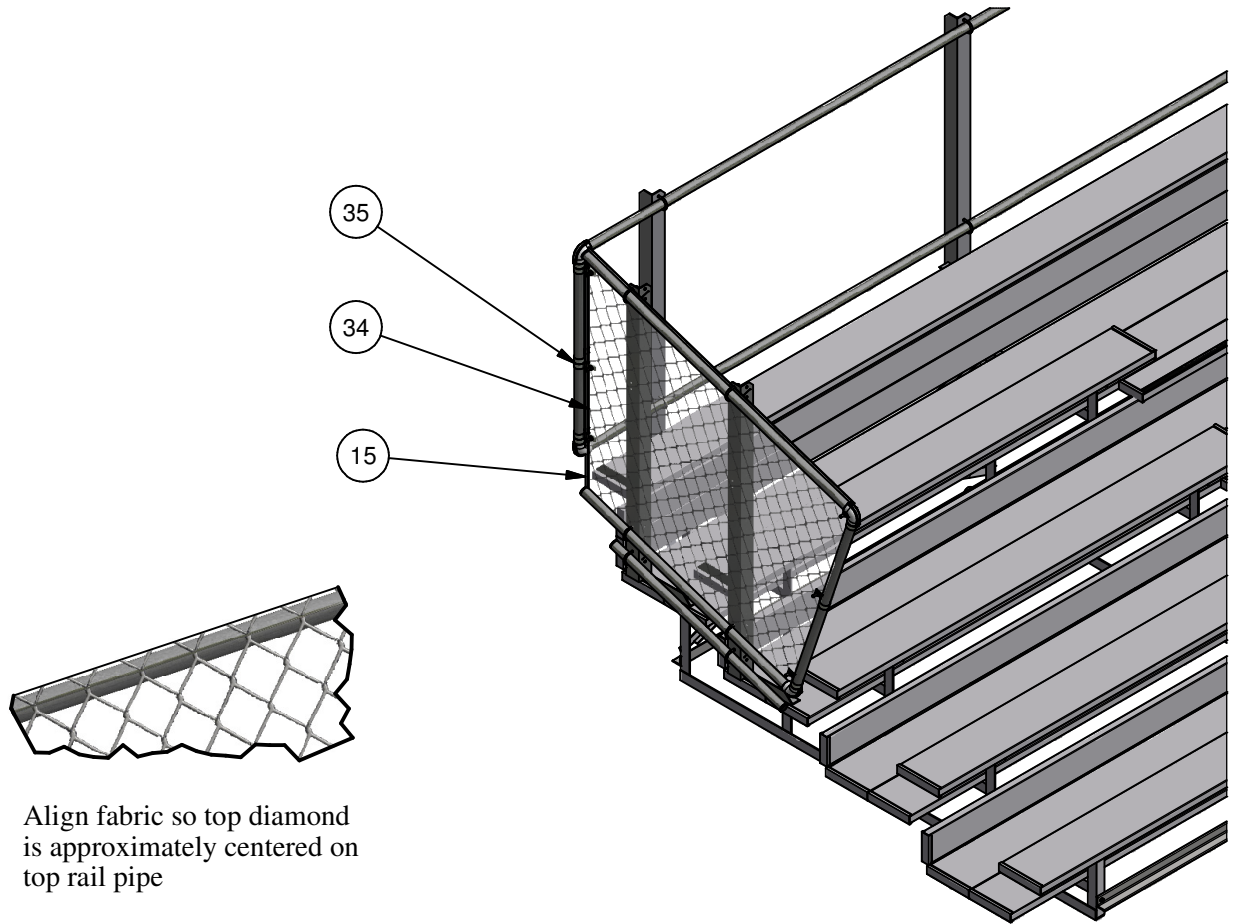


Figure 13

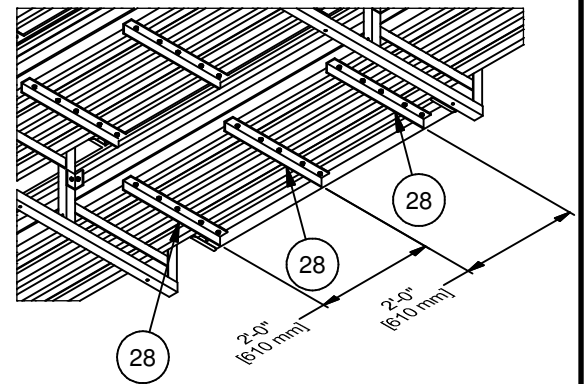
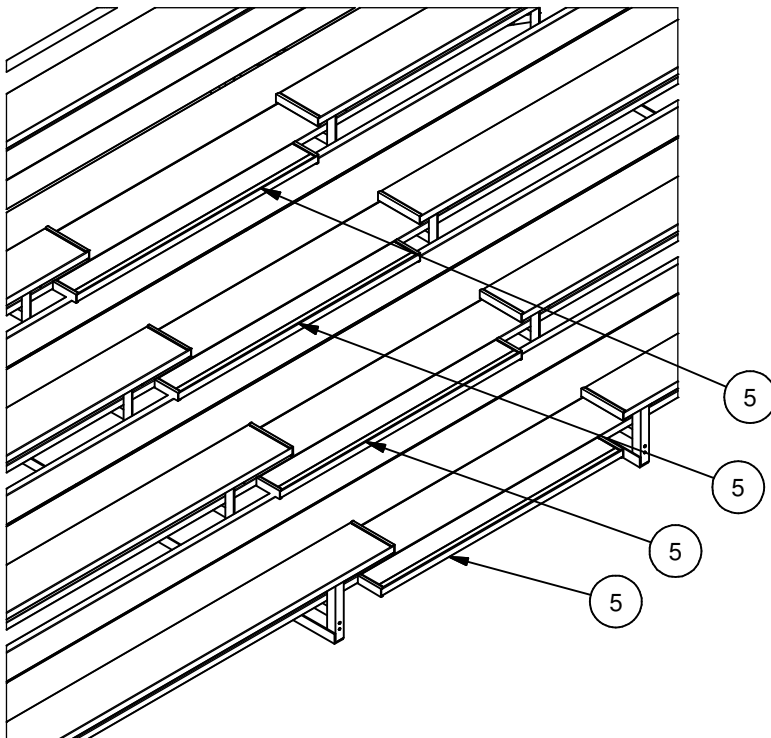
19. Install the 42" wide chain link to the rear of the bleacher. Using the 40" long tension bars. The tension bars are pre-installed on the chain link fabric at the factory. Start at one end and attach the tension bar to the vertical end pipe using (3) tension bands. Pull the fencing along the back of 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.

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Underside View

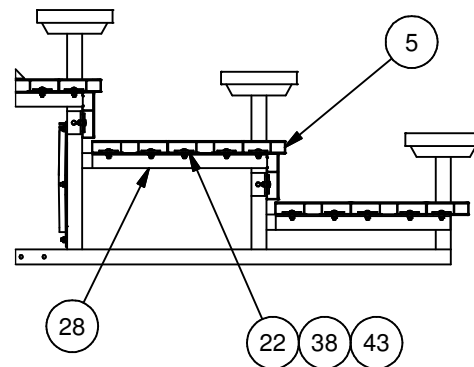
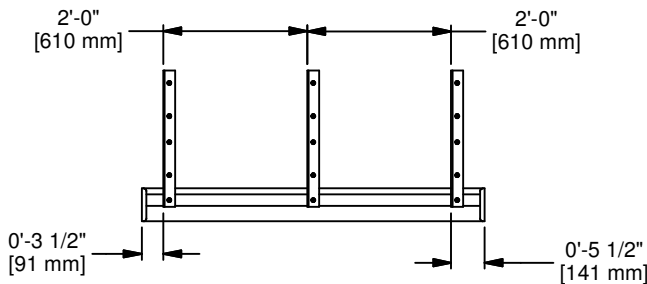


Figure 14

20. Attach three (3) bleacher step mounting angles (Item 28) to the riser step plank making sure the center angle bolt holes are in the center of the plank. Refer to Figure 14 for reference dimensions. The angles are attached with a mounting clip and a 5/16" x 1" carriage bolt and 5/16" whizlock nut. Do not fully tighten the nuts at this time. Slide the three mounting angles through the gap between the riser plank and the foot plank. Center the step plank on the aisle opening between seat planks. From the underside of the bleacher, attach each of the step mounting angles to the bottom of the foot planks using mounting clips, 5/16" x 1" carriage bolts, and 5/16" whizlock nuts. Four (4) are required per each mounting angle. Make sure the step plank is fully seated against the foot plank, centered on the aisle opening, and the mounting angles are pushed against the riser plank. Tighten all the nuts securely. Repeat the process for each aisle row.

21. Install the hand rails in the center of the aisle. The hand rails will be located at foot rows 2 and 4. See figure 15 for reference.

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22. Position the upper leg of the hand rail 1/2" in front of the riser plank. Mark the holes in the mounting flange on the foot plank. Also mark the holes in the lower leg mounting flange on that foot plank. Drill a 7/16" hole through the foot plank at each marked hole location.

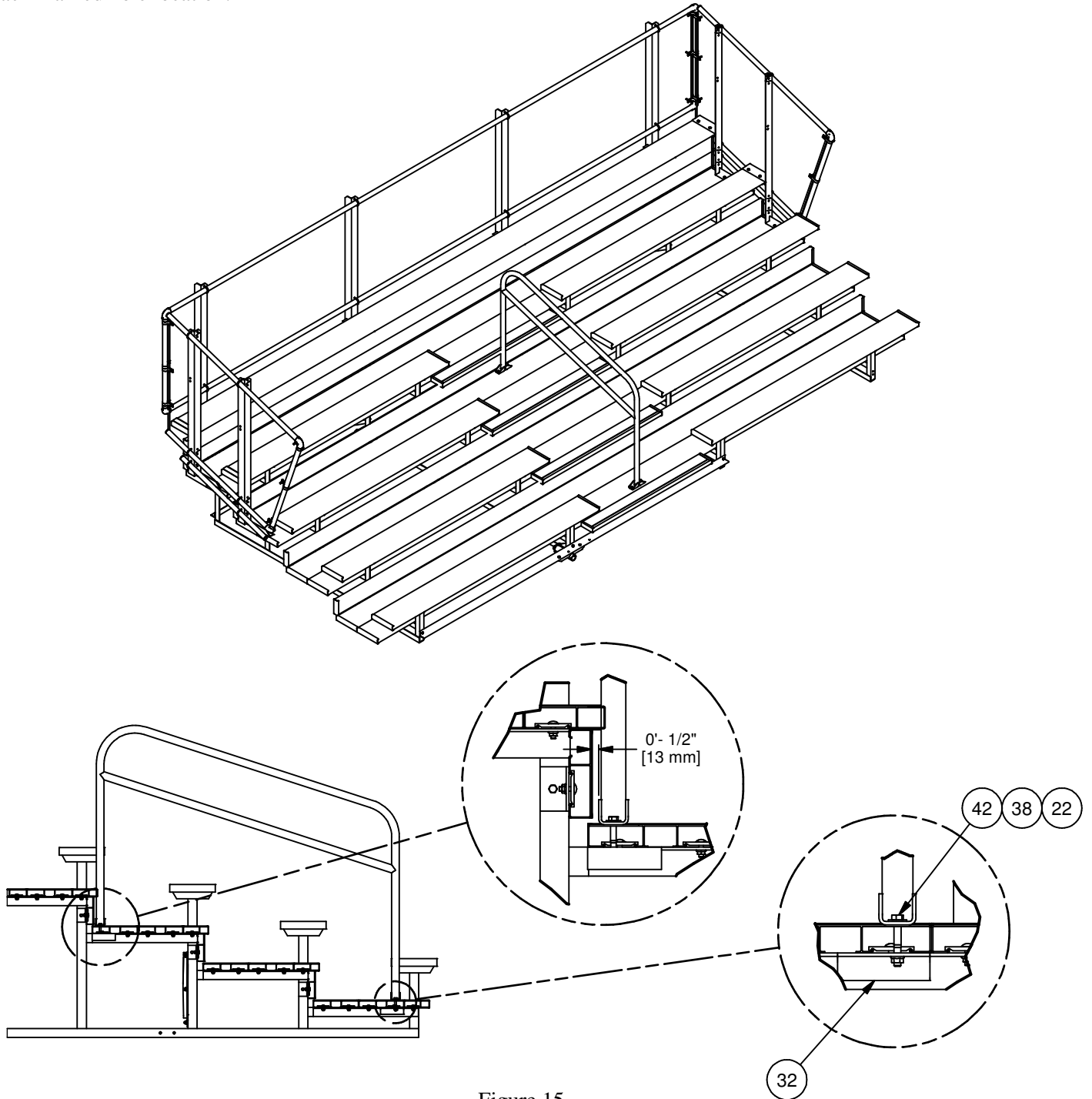


Figure 15

23. Install the hand rails using a 3/8" x 2-1/2" hex bolt, 3/8" flat washer, and 3/8" whizlock nut at each mounting flange hole location. On the underside of the foot plank, position the angle, hand rail clamp (Item 32) across the space on the foot plank and insert the 3/8" bolt before installing and tightening the nut.

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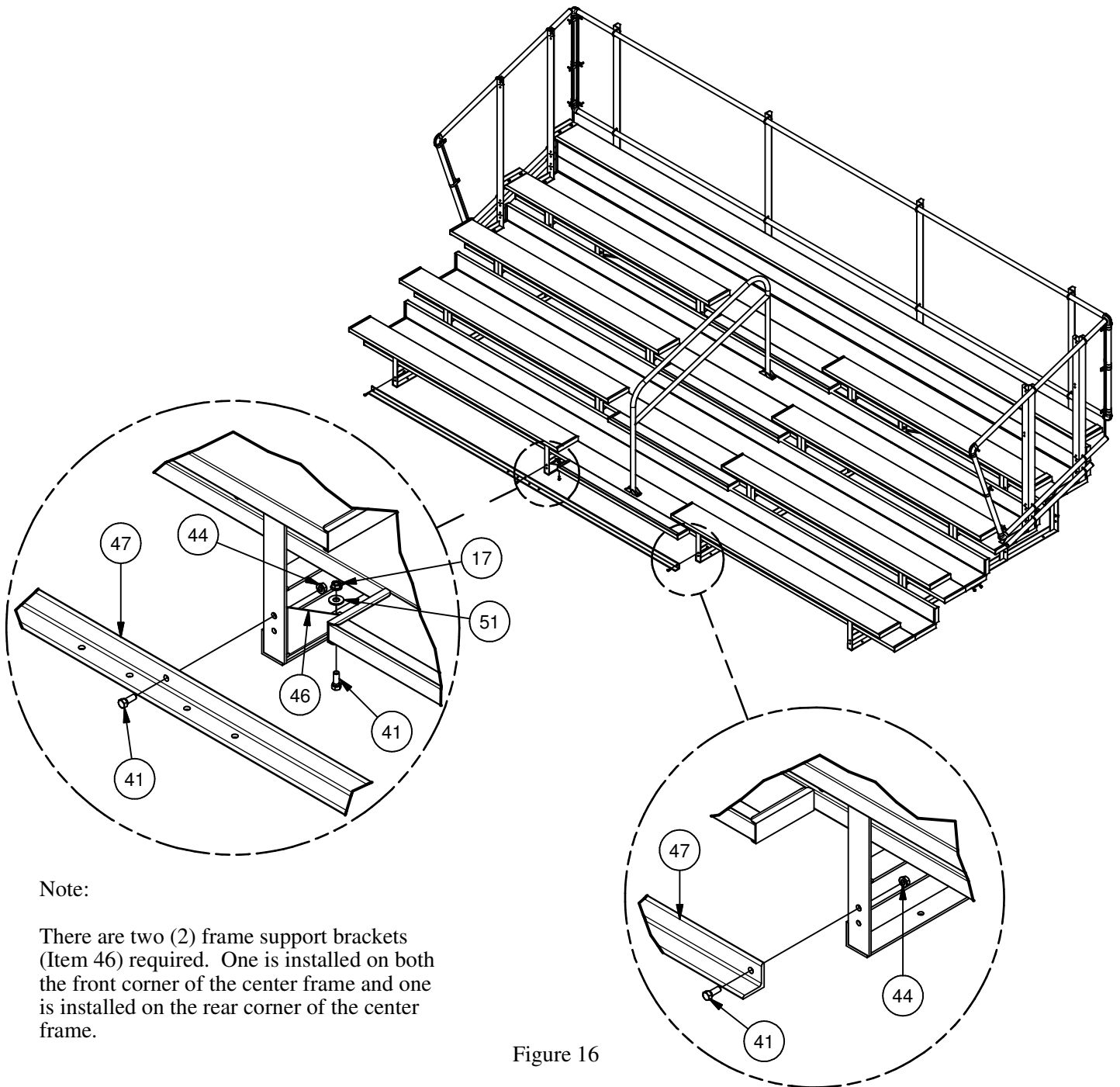
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24. Recheck all bolted connections to make sure all bolts and nuts are tightened securely. The bleacher assembly is now complete.

25. Install the transport axle support angles on the front and rear of the frames. On the front frame, use the top hole in each frame for mounting the angle. There is only one hole in the rear frame for mounting the angles. Before installing the bolt in the center, first install the frame support bracket (Item 46) onto the center frame as shown in Figure 16.



Note:

There are two (2) frame support brackets (Item 46) required. One is installed on both the front corner of the center frame and one is installed on the rear corner of the center frame.

Figure 16

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Refer to Figure 17 for the next two steps.

26. Install the pull tube guide plate (Item 49) onto the second frame from the end.

27. Install the pull tube guide plate (Item 49) and the pull point bracket (Item 50) onto the first frame.

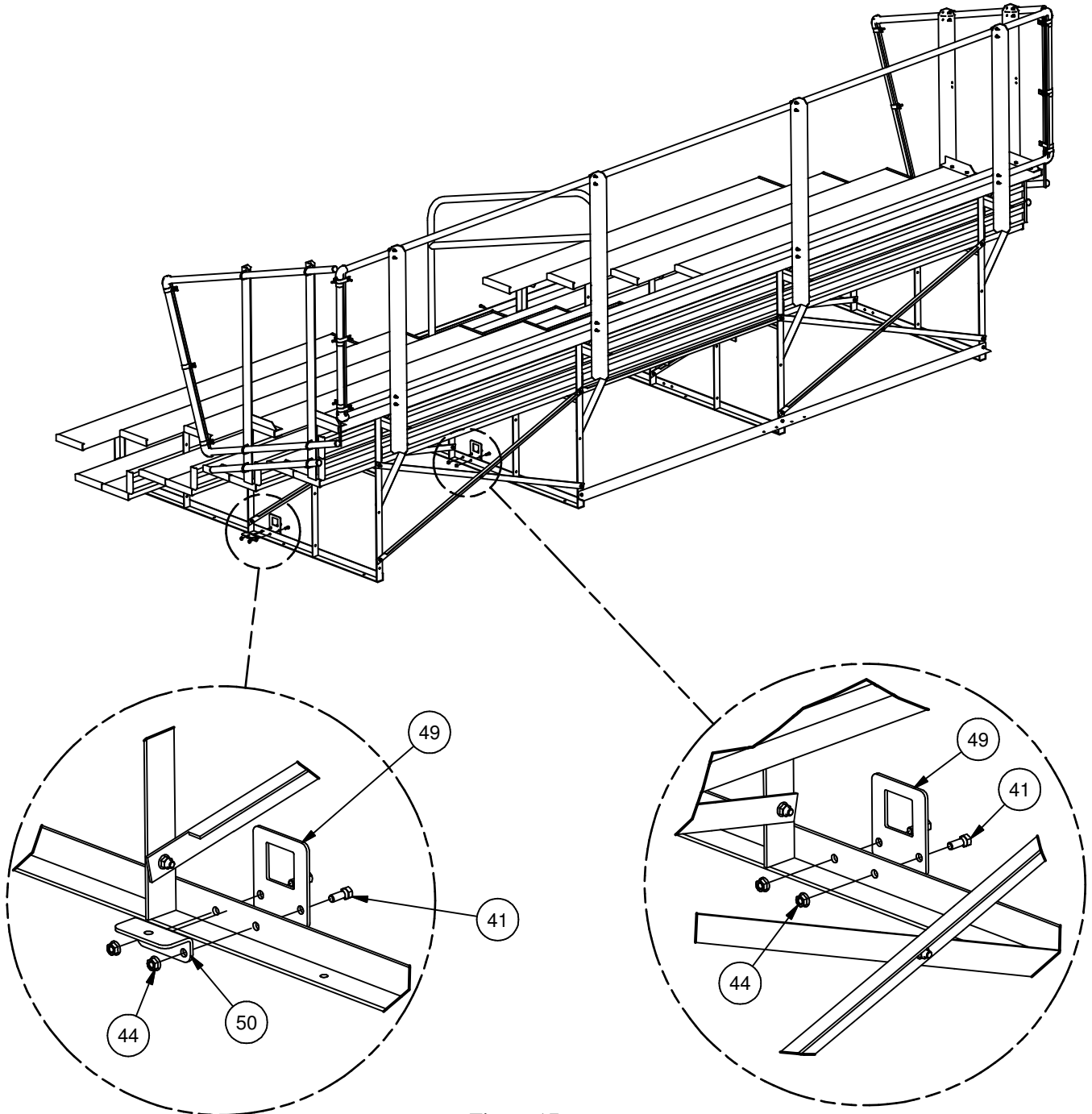


Figure 17

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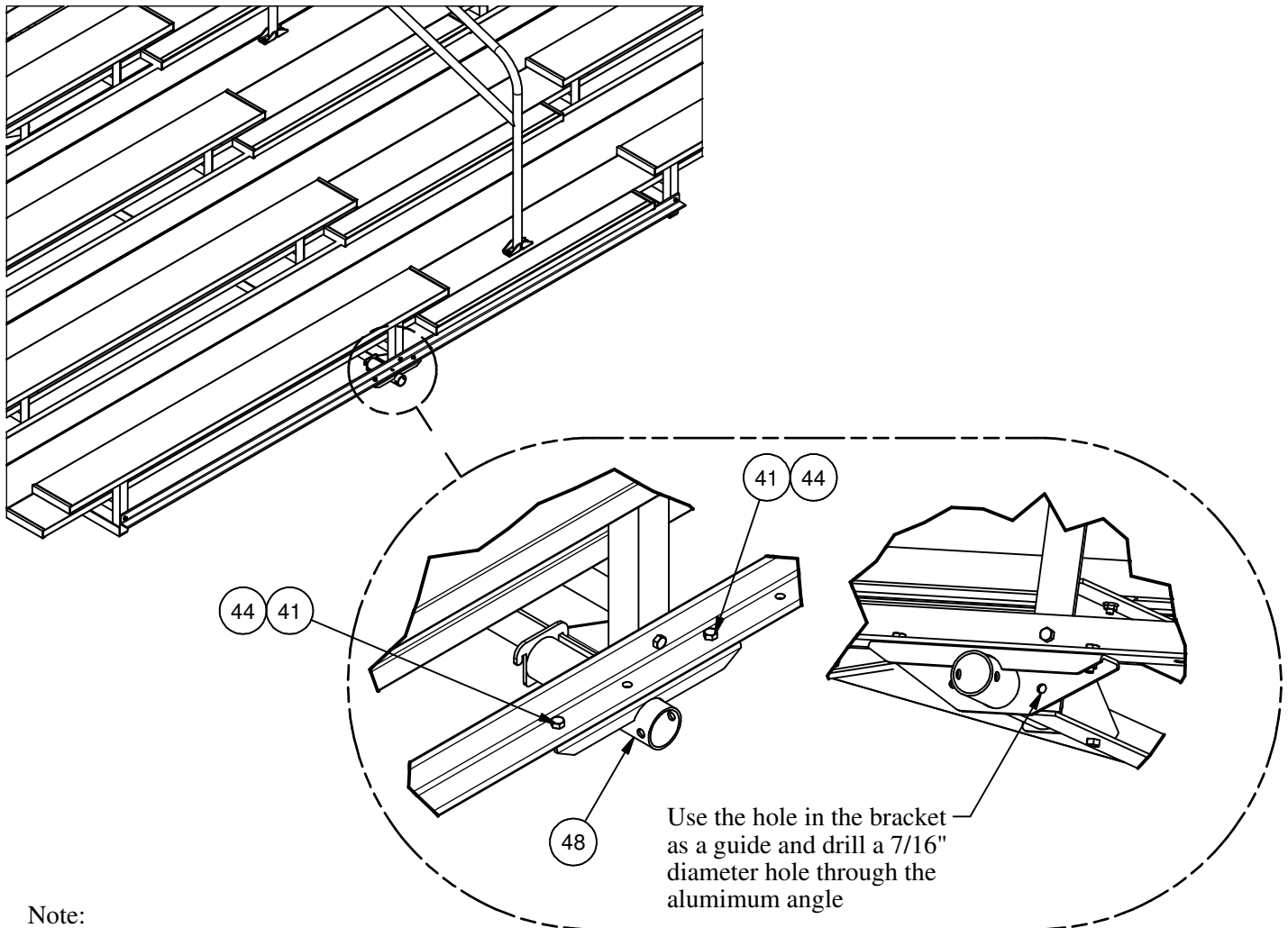
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28. Install the transport axle support brackets (Item 48) on the front and rear of the frames. Slide the notch in the rear plate over the vertical lip of the frame angle and then pull the flange face up to the transport support angle installed earlier. Install two 3/8 x 1" hex bolts through the bracket holes. Install two 3/8" whizlock nuts and tighten securely. Install a 3rd 3/8 x 1" through the face of the flange and the aluminum frame angle. Note, it may be necessary to drill a hole through the aluminum angle. Refer to Figure 18.



Note:

There are two (2) axle support brackets (Item 48) required. One is installed on both the front corner of the center frame and one is installed on the rear corner of the center frame.

Use the hole in the bracket as a guide and drill a 7/16" diameter hole through the aluminum angle

After the hole has been drilled through the aluminum angle, install a 3/8 x 1" hex bolt through the bracket flange, aluminum angle, and frame support bracket. Install a 3/8" whizlock nut and tighten securely.

Figure 18

29. Assembly is now complete. Check all bolted connections are tight.

**Installation and Assembly Instructions**



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