

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	1 OF 16	GSNB0515WA ai	

## *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

### **Installation and Assembly Instructions**



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

<b>15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL</b>			
FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000			
DATE	SHT. NO.	PART NO.	REV
5/23/2014	2 OF 16	GSNB0515WA ai	

MATERIAL LIST

ITEM	QTY	PART NUMBER	DESCRIPTION	LENGTH
1	4	198011026-12AN	PLANK, SEAT 10 " ANNODIZED X 12 FT	144.00 in
2	8	198011026-15	PLANK, FOOT 10" MILL FINISH X 15'	180.00 in
3	1	198011026-15AN	PLANK, SEAT 10" ANNODIZED X 15'	180.00 in
4	6	198011027-15	PLANK, RISER 6" MILL FINISH X 15'	180.00 in
5	4	198011032	PLANK, AISLE STEP 5.5" MILL FINISH	44.00 in
6	2	1166-17-00	TUBE,RND,1.66 OD X 0.065 WALL GALV	180.00 in
7	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	38.75 in
8	1	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	42.00 in
9	1	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	43.00 in
10	1	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	44.00 in
11	1	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	51.00 in
12	1	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	66.00 in
13	1	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	79.50 in
14	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	96.00 in
15	23	101051052	U-BOLT, 5/16-18 X 1.75 X 2.688 GALV	
16	37	108011049	ALUM WIRE TIE 9 GA X 8.5" LONG	
17	4	498011020	REAR GUARD WELDMENT	
18	4	498011025	BAR, SIDE REAR TENSION (46 IN)	
19	2	498011026	BAR, SIDE FRONT TENSION (40 IN)	
20	3	498011029	FRAME WELDMENT 5 ROW	
21	26	498011033	END CAP, BLEACHER SEAT	
22	12	498011034	END CAP, BLEACHER RISER	
23	180	498011035	MOUNTING CLIP	
24	9	498011076	PLASTIC CAP, 1.62 TUBE	
25	1	498011111	SIDE RAIL WELDMENT, LH	
26	2	498011112	SIDE RAIL WELDMENT, RH	
27	2	498011116	BRACE ANGLE - 63.75" LONG	
28	2	498011117	BRACE ANGLE - 67.5" LONG	
29	20	498011125	BLEACHER RISER MOUNTING ANGLE	
30	2	498011132	BRACE ANGLE - 62" LONG	
31	12	498011133	BLEACHER STEP MOUNTING ANGLE	
32	6	498011139	#3 ELBOW, 1-5/8" O.D. TUBING	
33	10	498011148	PLATE, SIDE RAIL CLAMP	
34	2	498011179	AISLE SIDE RAIL WELDMENT, LH	
35	8	498011183	END CAP SHORT	
36	1	498011185	AISLE FRAME WELDMENT 5 ROW	
37	1	498011326	CHAIN LINK 5 ROW SIDE GUARD	
38	1	498011329	CHAIN LINK 5 ROW AISLE SIDE GUARD	
39	3	498011330	#82A HANDRAIL BRACKET	
40	3	498011331	ANGLE, HANDRAIL MOUNT	
41	1	498011337	HAND RAIL 5 ROW 15' WITH AISLE	
42	2	498011340	BRACE ANGLE - 40.75 LONG	
43	2	498011341	BRACE ANGLE - 46.5" LONG	
44	1	498011346	WELDMENT, HANDRAIL SUPPORT	
45	2	498011347	FLEXIBLE ELBOW 1-1/4" PIPE SIZE	
46	18	651653934	HEAVY TENSION BAND, 1-5/8"	
47	92	6044-11-00	1/8" POP RIVET	
48	14.720 ft	921041001	ABRASIVE ANTISLIP TAPE 2" WIDE	
49	6	291-10-16-16	SCREW, HEX HD SELF DRILL #10 X 1	
50	180	501-5-18-16G	BOLT, CARRIAGE 5/16-18 UNC X 1 GALV	
51	18	501-6-16-24G	BOLT, CARRIAGE 3/8-16 UNC X 1.5 GALV	
52	28	502-5-18-16G	HEX BOLT, 5/16-18 UNC X 1 GALV	
53	31	502-6-16-16G	HEX BOLT, 3/8-16 UNC X 1 GALV	
54	20	502-6-16-40G	HEX BOLT, 3/8-16 UNC X 2.5 GALV	
55	254	548-5-18G	HEX NUT, SERRATED FLANGE 5/16-18 GALV	
56	69	548-6-16G	HEX NUT, SERRATED FLANGE 3/8-16 GALV	
57	15.500 ft	FENCE	42" GALVANIZED CHAIN-LINK FENCE	

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.

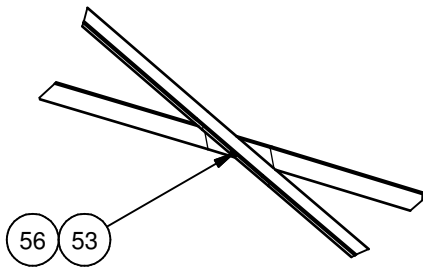
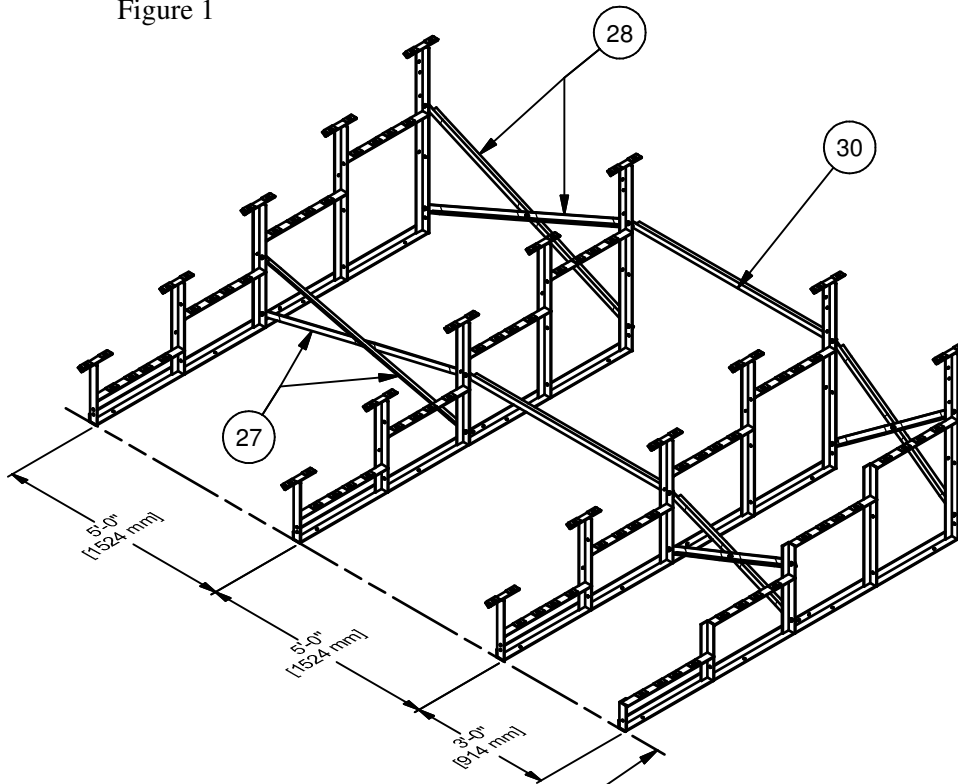


Figure 1



Figure 2



Align and square frames after installation of cross braces

Figure 3

3. Lay out the Frame weldments approximately 5' 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 3,4,6,9,and 10. 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 center bay at row 3 and row 10 only. After all braces are installed, square the frame and make sure the front of the frame is in line.

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	4 OF 16	GSNB0515WA ai	

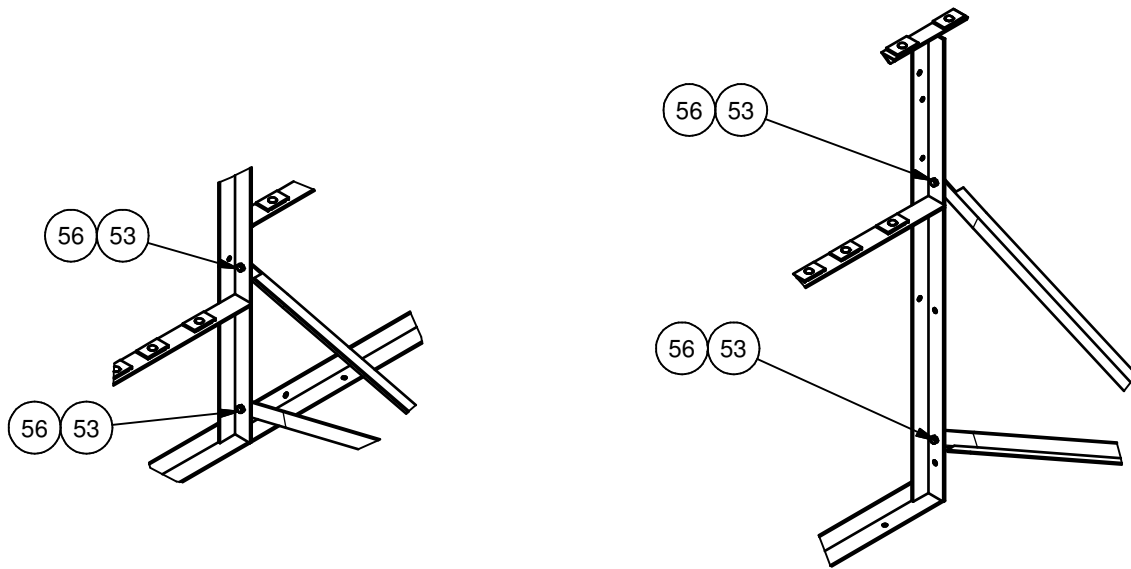


Figure 4

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.

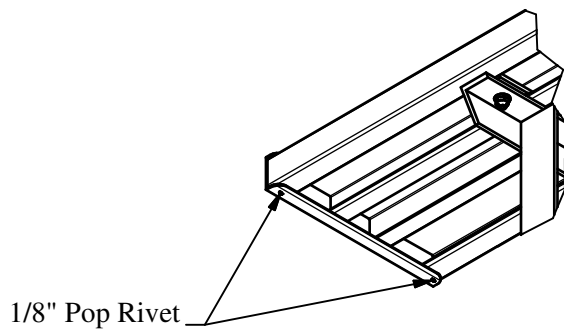


Figure 5

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	5 OF 16	GSNB0515WA ai	

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.

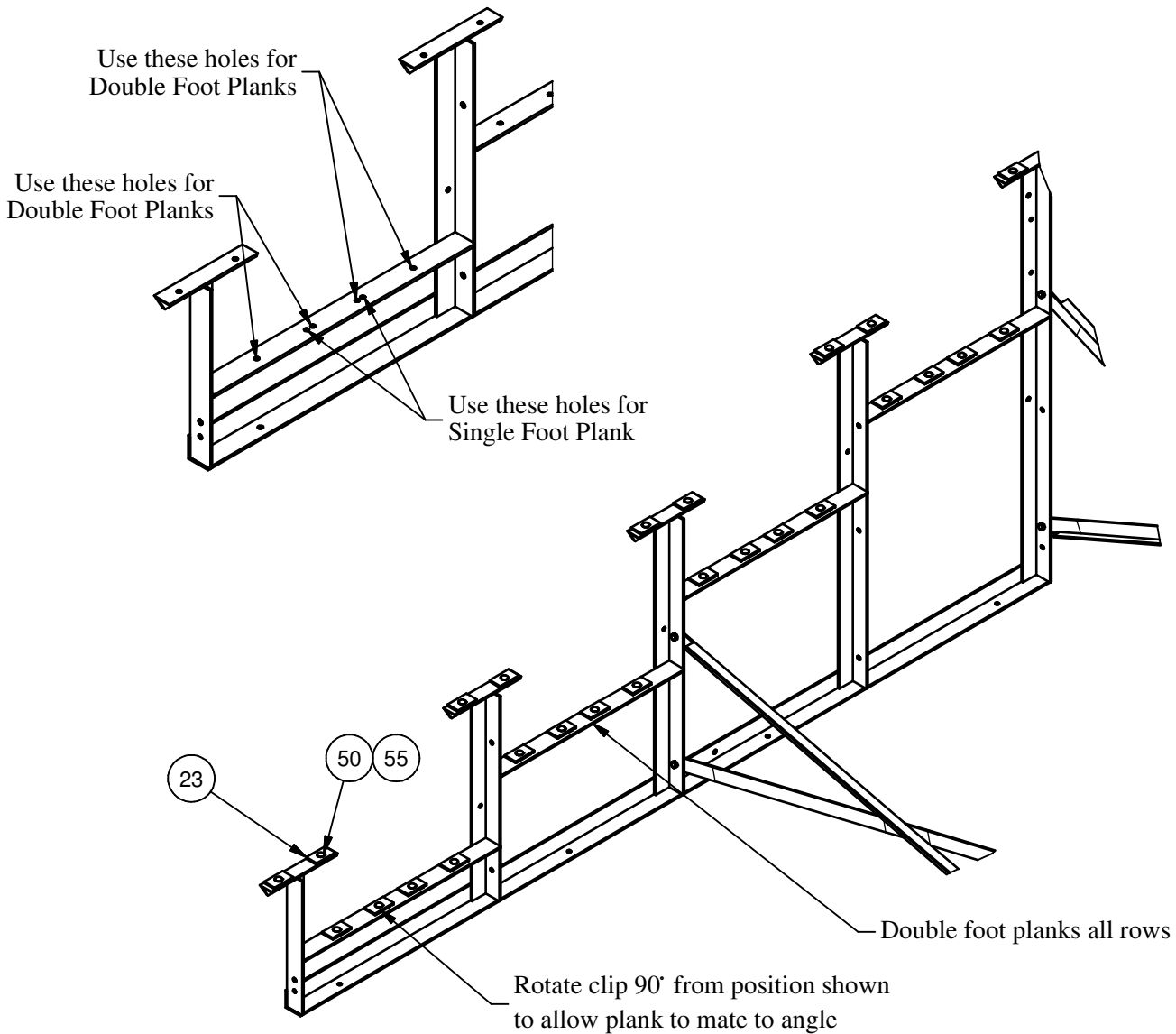


Figure 6

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.

### Installation and Assembly Instructions

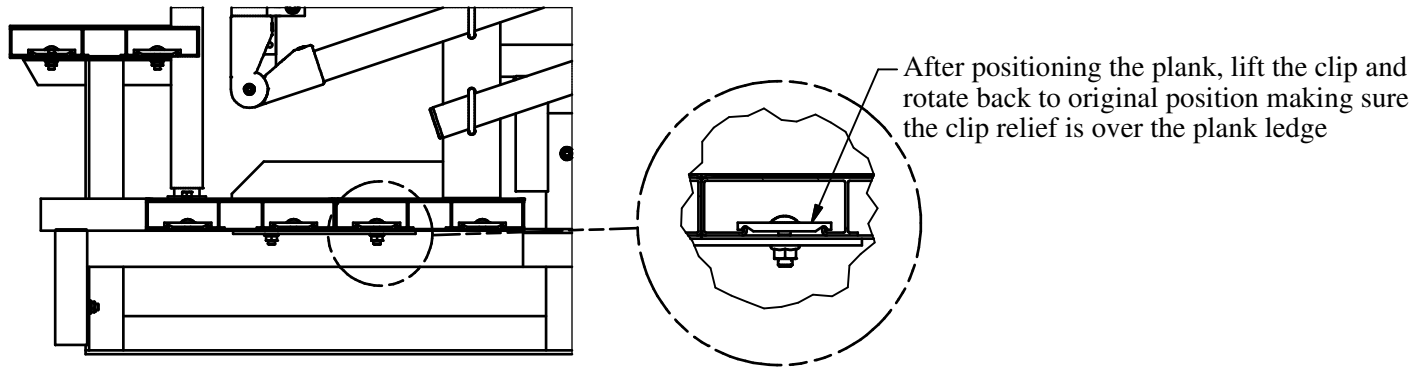


Gared Holdings, LLC  
9200 E. 146th St.  
Noblesville, IN 46060

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	6 OF 16	GSNB0515WA ai	



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.

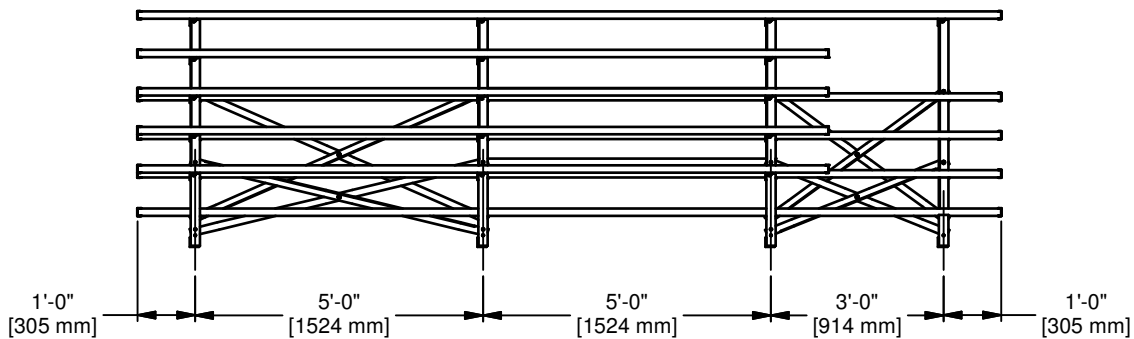
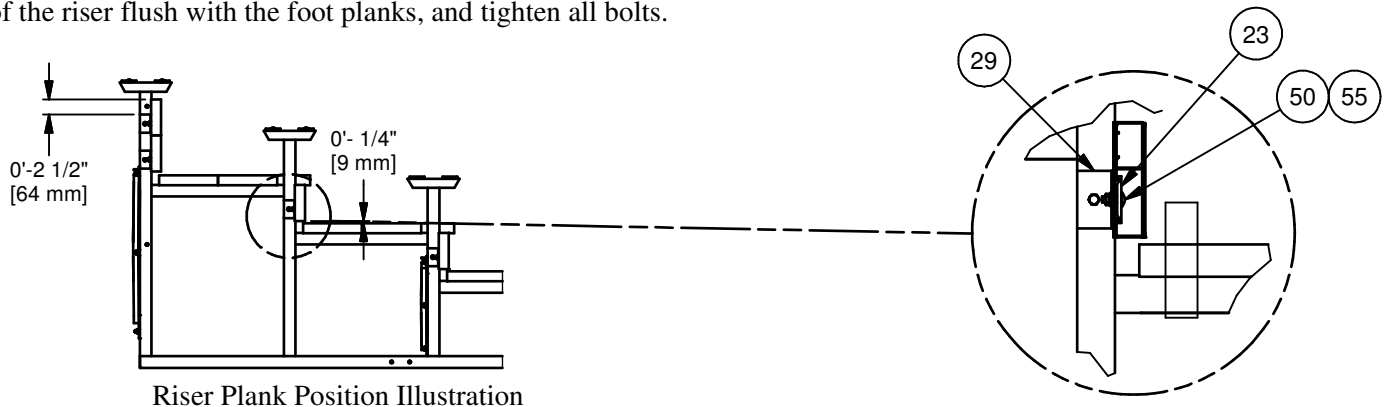


Figure 7

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. Angle clips are not required on the first row. Connect the first row riser to the first row upright with mounting clips, 5/16" carriage bolts and 5/16" nuts only.

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

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE  
5/23/2014

SHT. NO.  
7 OF 16

PART NO.  
GSNB0515WA ai

REV

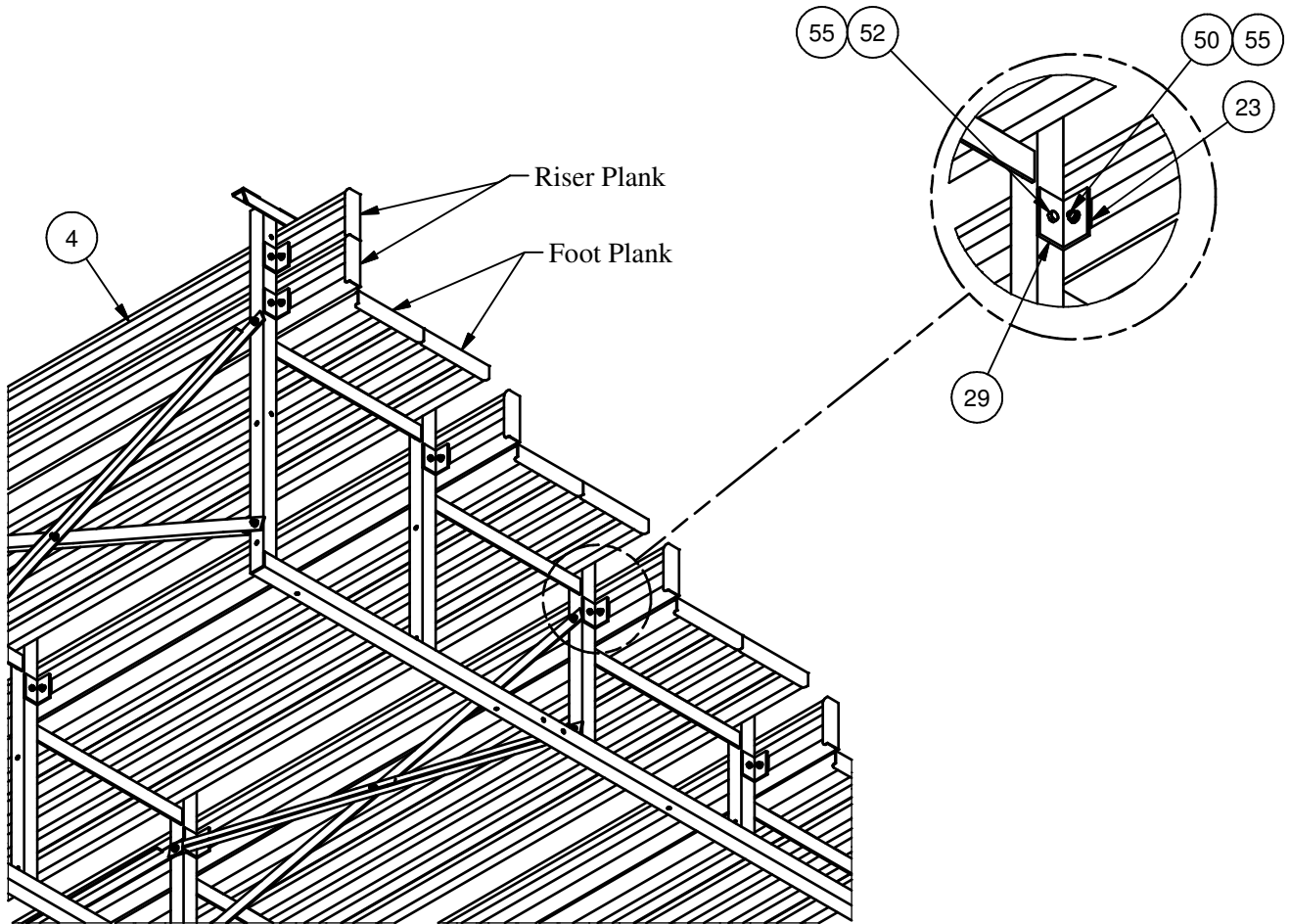


Figure 8

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.

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	8 OF 16	GSNB0515WA ai	



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.

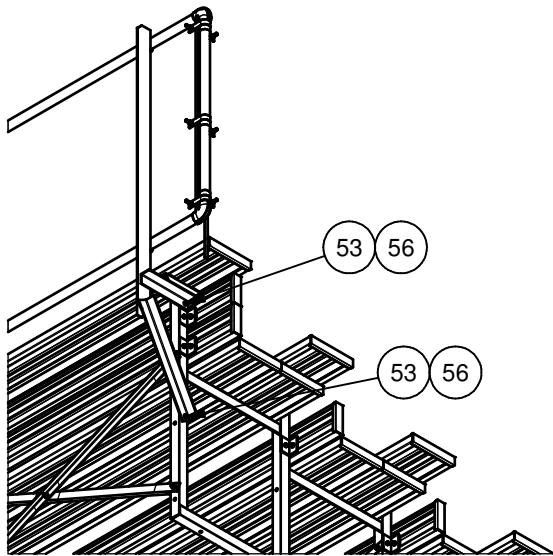


Figure 9

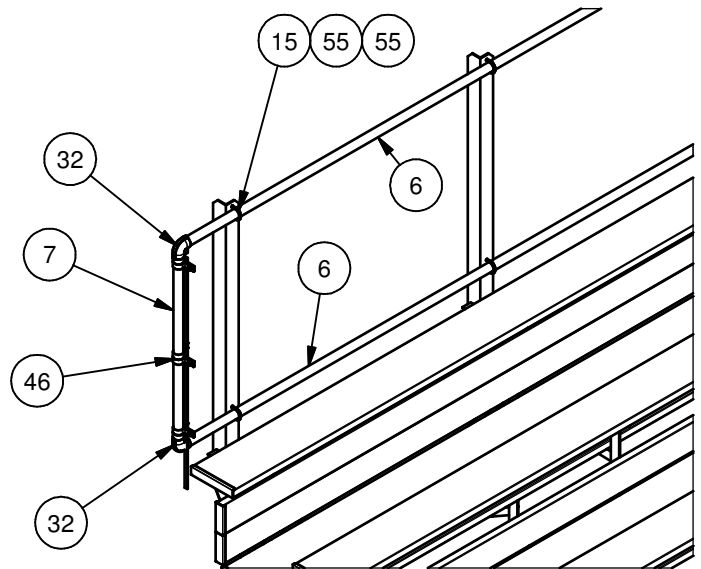
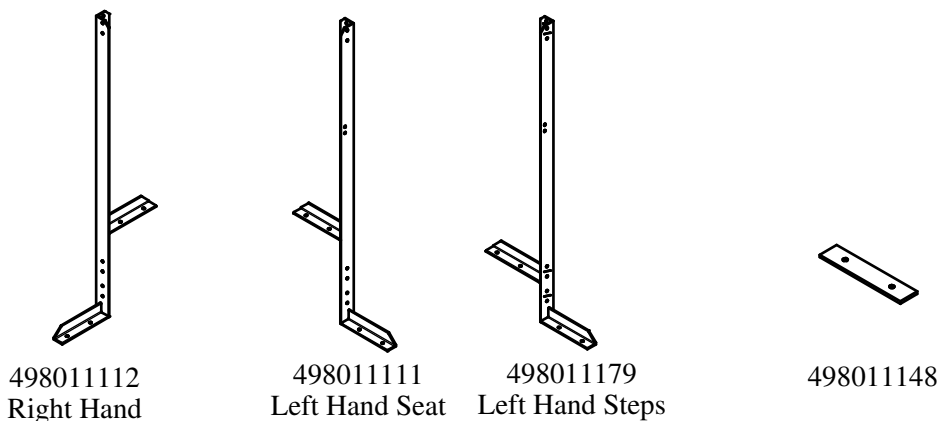


Figure 10

13. Attach the 15' 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.



### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	9 OF 16	GSNB0515WA ai	

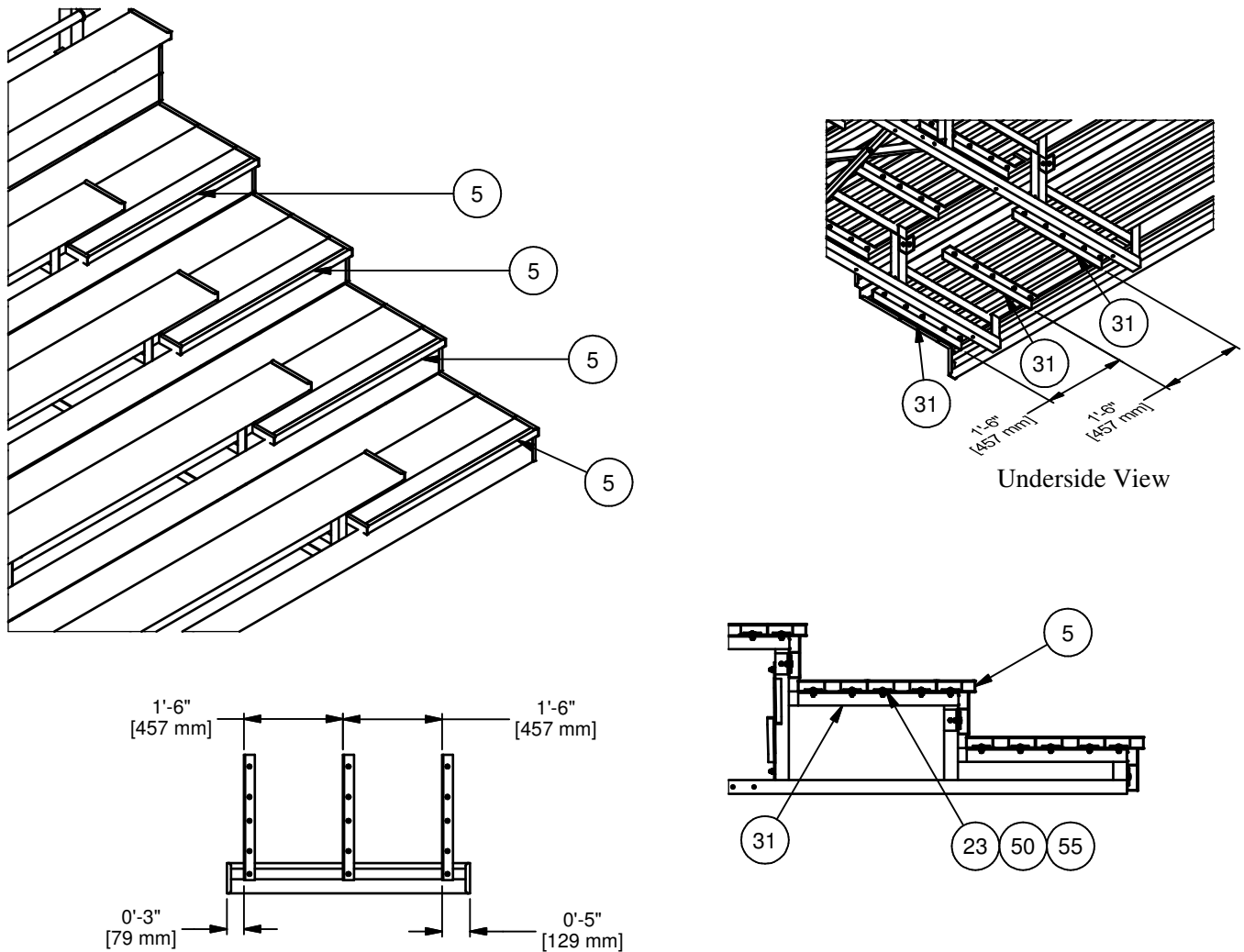


Figure 11

16. Attach three (3) bleacher step mounting angles (Item 32) to the riser step plank making sure the center angle bolt holes are in the center of the plank. Refer to Figure 11 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.

17. Tighten all the nuts securely. Repeat the process for each aisle row.

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	10 OF 16	GSNB0515WA ai	

18. Install the RH side rail weldments onto the end of the bleacher. Locate one vertical on the top row, and 4th row. Position the verticals as shown in Figure 12. 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.

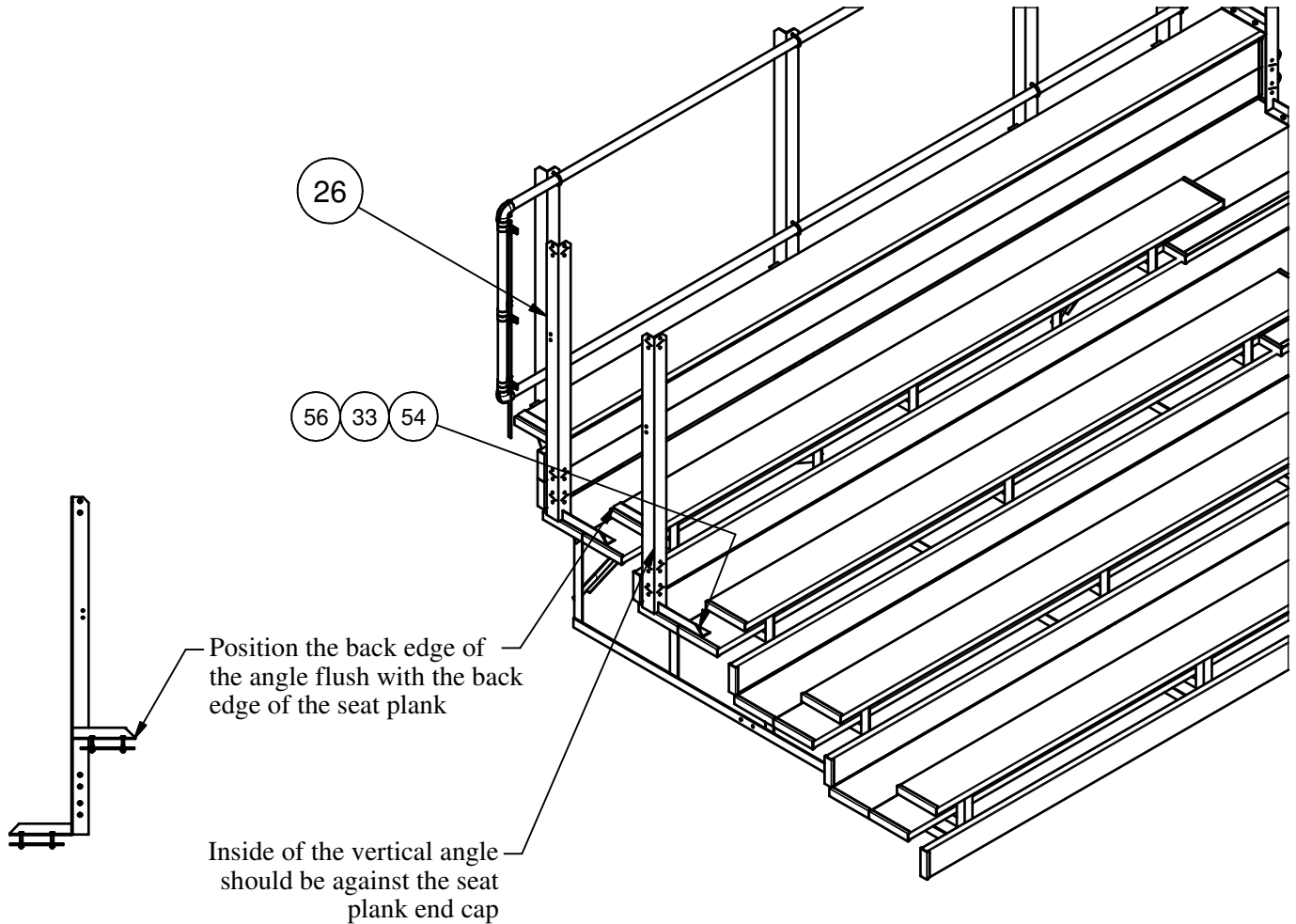


Figure 12

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	11 OF 16	GSNB0515WA ai	

19. Install the LH side rail weldments onto the aisle end of the bleacher. Locate one seat vertical on the top row and two aisle verticals on the 4th row, and on the 2nd row. Position the verticals as shown in Figure 13. On the top row vertical, use the holes in the angles as guides and drill the four 3/8" holes through the seat plank (2 holes) and the foot planks (2 holes). On the remaining verticals, use the holes in the angles as guides and drill the four 3/8" holes through the foot planks (2 holes each level).

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.

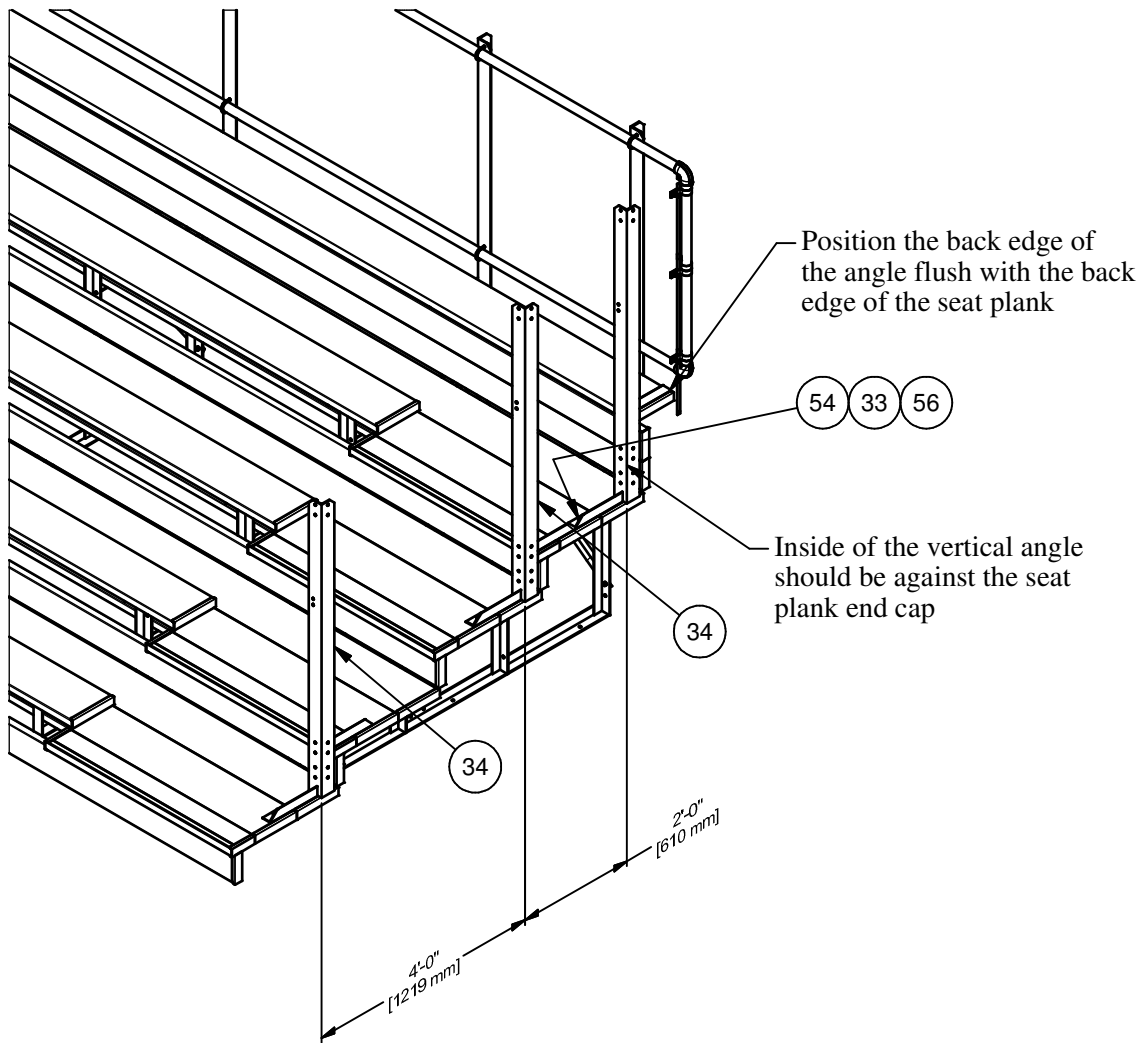


Figure 13

### Installation and Assembly Instructions



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

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	12 OF 16	GSNB0515WA ai	

20. Install the side guard rail pipes on the seat 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.

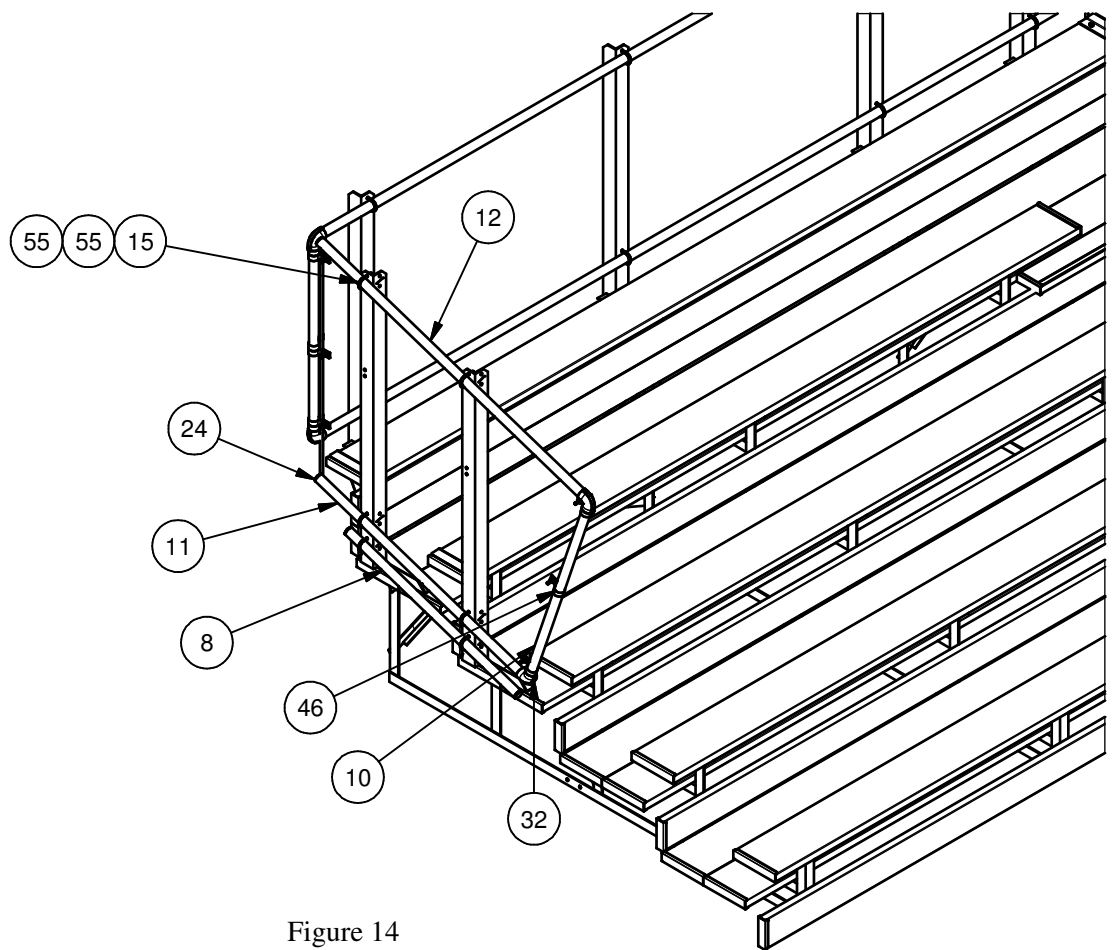


Figure 14

## Installation and Assembly Instructions



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

### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE  
5/23/2014

SHT. NO.  
13 OF 16

PART NO.  
GSNB0515WA ai

REV

21. Install the side guard rail pipes on the aisle end of the bleacher.

Install the 96.0" 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 96.0" 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 43.0" long tube to the pipes installed in the last step using the flexible 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 79.5" 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.

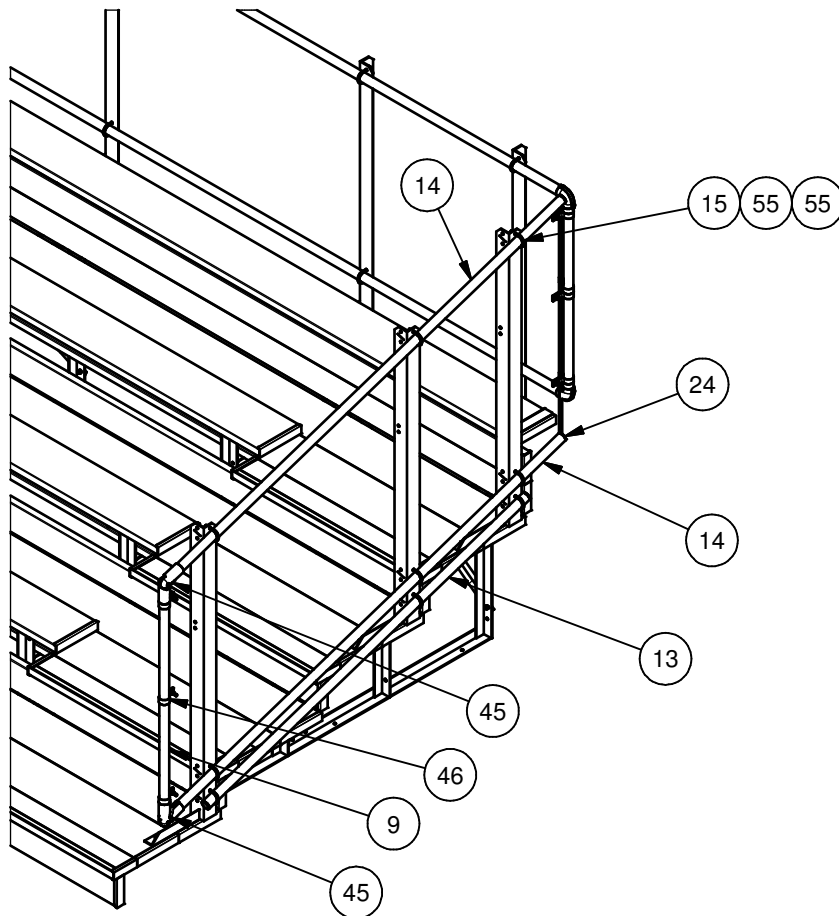


Figure 15

### Installation and Assembly Instructions



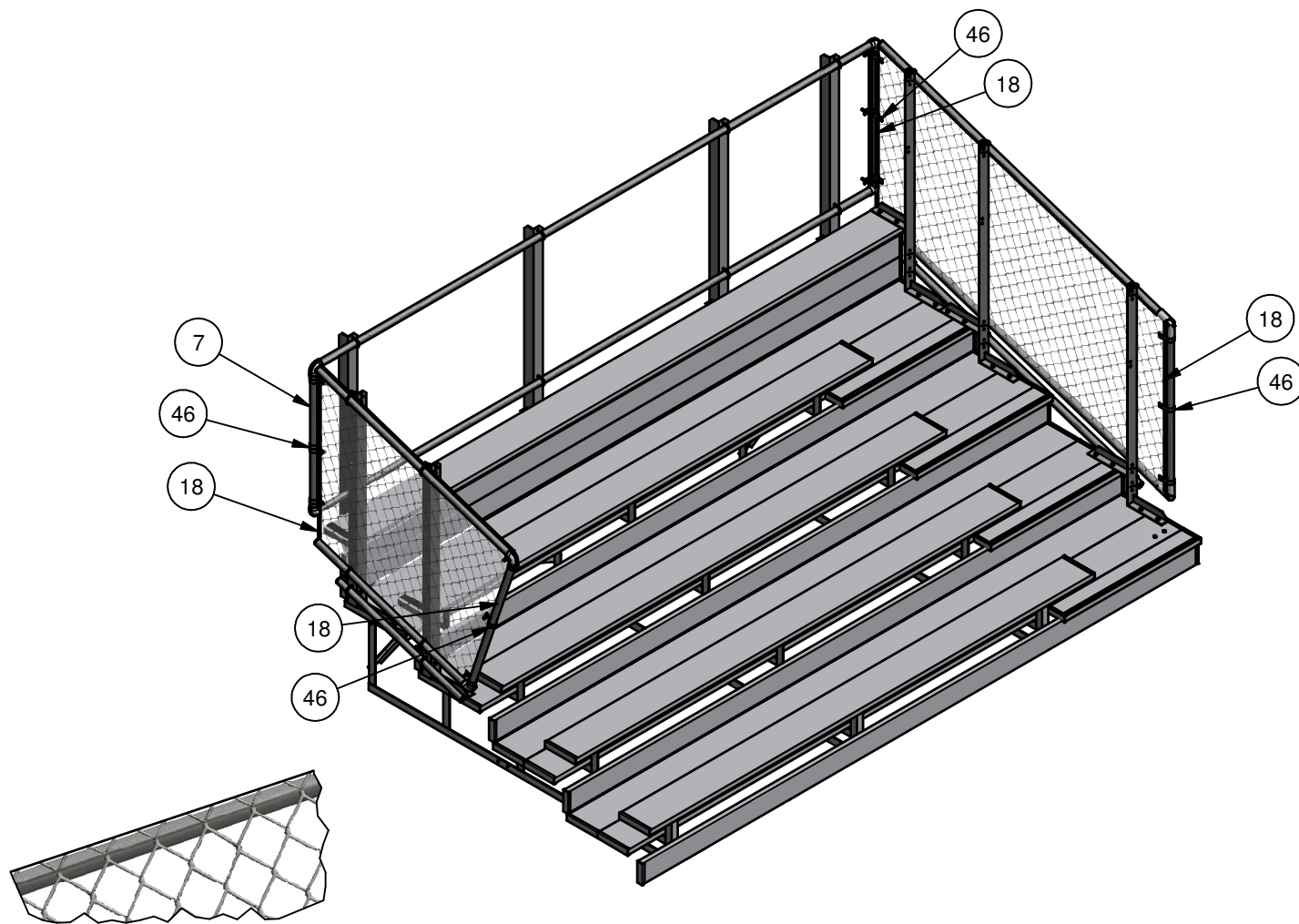
Gared Holdings, LLC  
9200 E. 146th St.  
Noblesville, IN 46060

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	14 OF 16	GSNB0515WA ai	

22. 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.



Align fabric so top diamond is approximately centered on top rail pipe

Figure 16

23. 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.

### Installation and Assembly Instructions



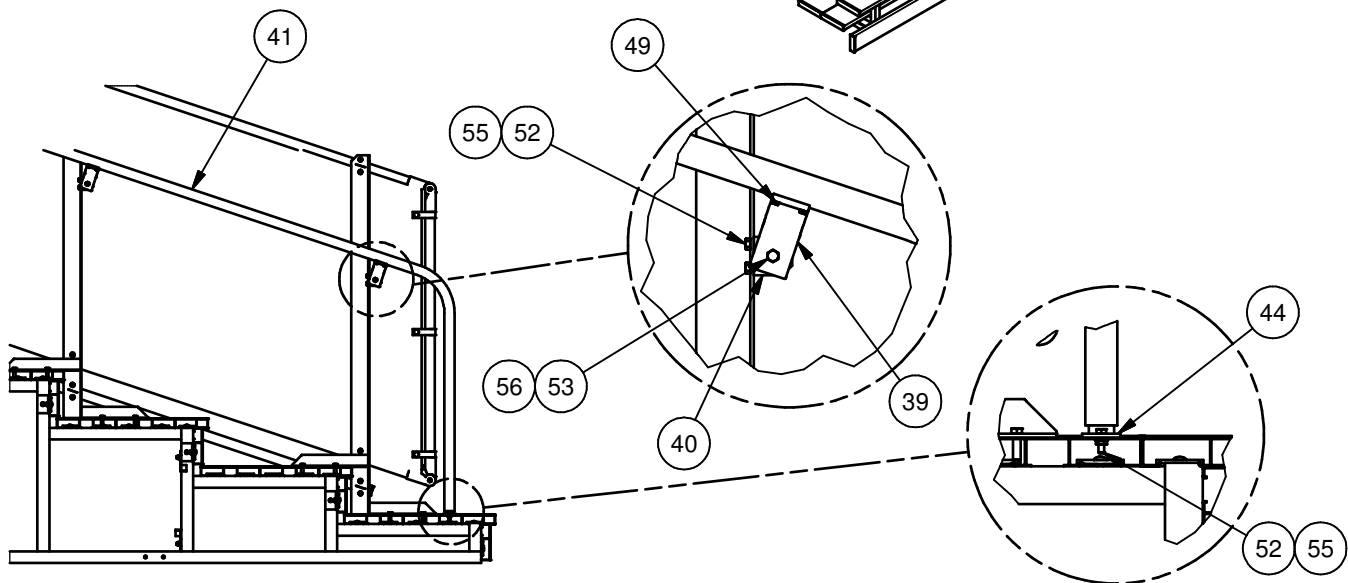
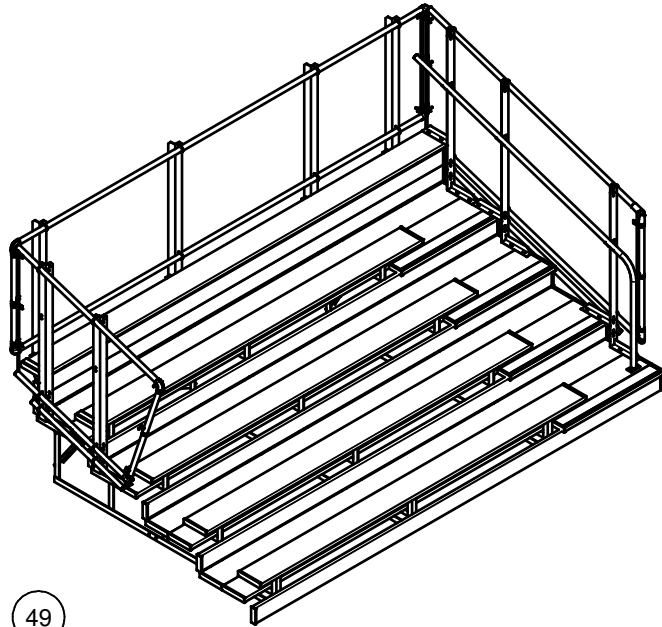
Gared Holdings, LLC  
9200 E. 146th St.  
Noblesville, IN 46060

#### 15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL

FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000

DATE	SHT. NO.	PART NO.	REV
5/23/2014	15 OF 16	GSNB0515WA ai	

24. Install the hand rail mounting angles onto each vertical using the 5/16" x 1" hex bolts and 5/16" whizlock nuts (2 are required at each vertical). Install the #82 handrail bracket onto each handrail mounting angle using a 3/8" x 1" hex bolt and 3/8" whizlock nut. Do not tighten the 3/8" bolts at this time. Position the handrail support bracket on the first footplank. Slide the short section of the handrail over the handrail support bracket tube and then position the long section of the handrail onto the #82 brackets at each vertical. Temporarily clamp the hand rail to two of the #82 brackets to hold its position. Mark the holes in the lower leg mounting flange on the foot plank. Drill a 7/16" hole through the foot plank at each marked hole location. Install two 3/8" x 1" hex bolts through the mounting bracket and foot plank, and secure with two 3/8" whizlock nuts. Install two #10 x 1" self drilling screws through the holes in the #82 bracket and into the hand rail at each vertical position. Install the plastic end cap in the end of the hand rail.



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

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

### Installation and Assembly Instructions



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

<b>15' ALUMINUM BLEACHER 5 ROW WITH AISLE AND HAND RAIL</b>			
FILE LOC. Q:\Inventor Files\Installation Instructions\490,000,000			
DATE	SHT. NO.	PART NO.	REV
5/23/2014	16 OF 16	GSNB0515WA ai	