

### Installation and Assembly Instructions



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

<b>27' ALUMINUM BLEACHER 8 ROW WITH AISLE AND HAND RAIL</b>			
FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	1 OF 16	GSNB0827WA 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

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DATE	SHT. NO.	PART NO.	REV
5/27/2014	2 OF 16	GSNB0827WA ai	

MATERIAL LIST				
ITEM	QTY	PART NUMBER	DESCRIPTION	LENGTH
1	14	198011026-27	PLANK, FOOT 10" MILL FINISH X 27'	324.00 in
2	1	198011026-27AN	PLANK, SEAT 10" ANNODIZED X 27'	324.00 in
3	7	198011026-AN	PLANK, SEAT 10" ANNODIZED	171.00 in
4	7	198011026-AN	PLANK, SEAT 10" ANNODIZED	99.00 in
5	9	198011027-27	PLANK, RISER 6" MILL FINISH X 27'	324.00 in
6	7	198011032	PLANK, AISLE STEP 5.5" MILL FINISH	57.00 in
7	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	120.00 in
8	2	1166-17-00	TUBE,RND,1.66 OD X 0.065 WALL GALV	129.00 in
9	2	1166-17-00	TUBE,RND,1.66 OD X 0.065 WALL GALV	144.00 in
10	2	1166-17-00	TUBE,RND,1.66 OD X 0.065 WALL GALV	324.00 in
11	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	38.75 in
12	2	1166-17-00	TUBE,RND,1.660 OD X 0.065 WALL GALV	44.00 in
13	28	101051052	U-BOLT, 5/16-18 X 1.75 X 2.688 GALV	
14	68	108011049	ALUM WIRE TIE 9 GA X 8.5" LONG	
15	5	498011020	REAR GUARD WELDMENT	
16	4	498011025	BAR, SIDE REAR TENSION (46 IN)	
17	2	498011026	BAR, SIDE FRONT TENSION (40 IN)	
18	5	498011029	FRAME WELDMENT 5 ROW	
19	18	498011030	BRACE ANGLE - 75.44 LONG	
20	12	498011031	BRACE ANGLE - 78.62" LONG	
21	58	498011033	END CAP, BLEACHER SEAT	
22	18	498011034	END CAP, BLEACHER RISER	
23	370	498011035	MOUNTING CLIP	
24	8	498011076	PLASTIC CAP, 1.62 TUBE	
25	2	498011092	BRACE ANGLE - 74.00" LONG	
26	5	498011095	FRAME WELDMENT 8 ROW ADDER	
27	3	498011111	SIDE RAIL WELDMENT, LH	
28	3	498011112	SIDE RAIL WELDMENT, RH	
29	40	498011125	BLEACHER RISER MOUNTING ANGLE	
30	21	498011133	BLEACHER STEP MOUNTING ANGLE	
31	8	498011139	#3 ELBOW, 1-5/8" O.D. TUBING	
32	1	498011140	HAND RAIL WELDMENT 3 STEP	
33	1	498011142	HAND RAIL WELDMENT 2 STEP	
34	12	498011148	PLATE, SIDE RAIL CLAMP	
35	8	498011149	ANGLE, HAND RAIL CLAMP	
36	14	498011183	END CAP SHORT	
37	2	498011327	CHAIN LINK 8 ROW SIDE GUARD	
38	18	651653934	HEAVY TENSION BAND, 1-5/8"	
39	180	6044-11-00	1/8" POP RIVET	
40	33.250 ft	921041001	ABRASIVE ANTISLIP TAPE 2" WIDE	
41	370	501-5-18-16G	BOLT, CARRIAGE 5/16-18 UNC X 1 GALV	
42	18	501-6-16-24G	BOLT, CARRIAGE 3/8-16 UNC X 1.5 GALV	
43	40	502-5-18-16G	HEX BOLT, 5/16-18 UNC X 1 GALV	
44	90	502-6-16-16G	HEX BOLT, 3/8-16 UNC X 1 GALV	
45	32	502-6-16-40G	HEX BOLT, 3/8-16 UNC X 2.5 GALV	
46	466	548-5-18G	HEX NUT, SERRATED FLANGE 5/16-18 GALV	
47	140	548-6-16G	HEX NUT, SERRATED FLANGE 3/8-16 GALV	
48	8	561-6G	FLAT WASHER 3/8 GALV	
49	27.500 ft	FENCE	42" GALVANIZED CHAIN-LINK FENCE	

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DATE	SHT. NO.	PART NO.	REV
5/27/2014	3 OF 16	GSNB0827WA ai	

1. Pre-assemble the frame sections by bolting together the 5 row frame and 8 row adder frame. Use the 3/8" x 1" hex bolts and 3/8" whixlock nuts. Three (3) are required at each frame connection. Make sure all six bolts and nuts are securely tightened. Repeat the process for all four (4) frame sections.

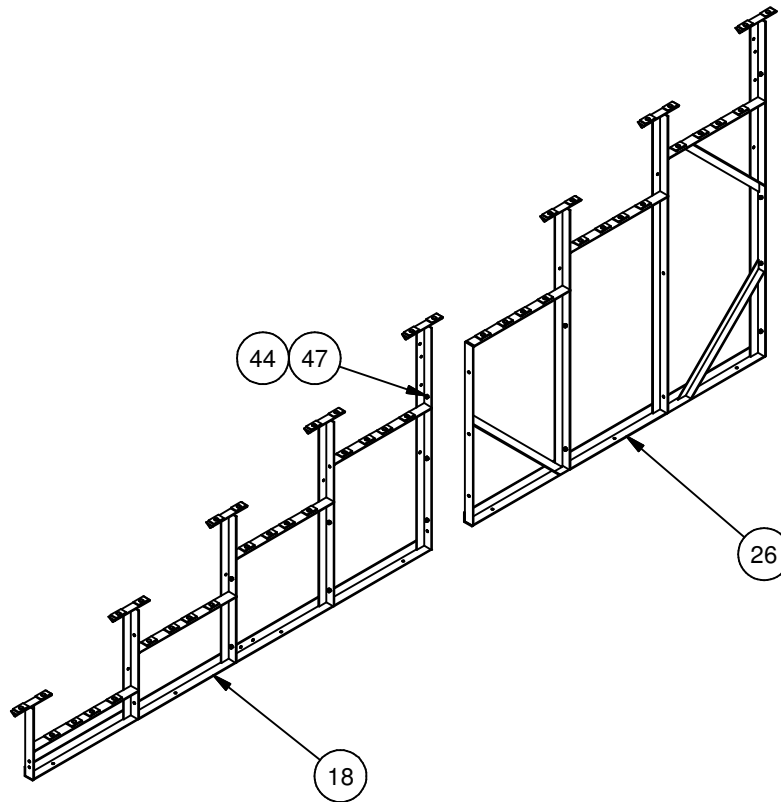


Figure 1

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.

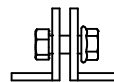
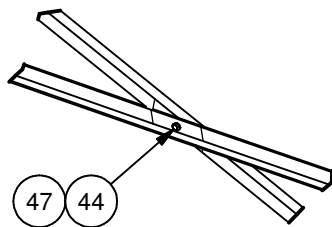


Figure 2

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	4 OF 16	GSNB0827WA ai	

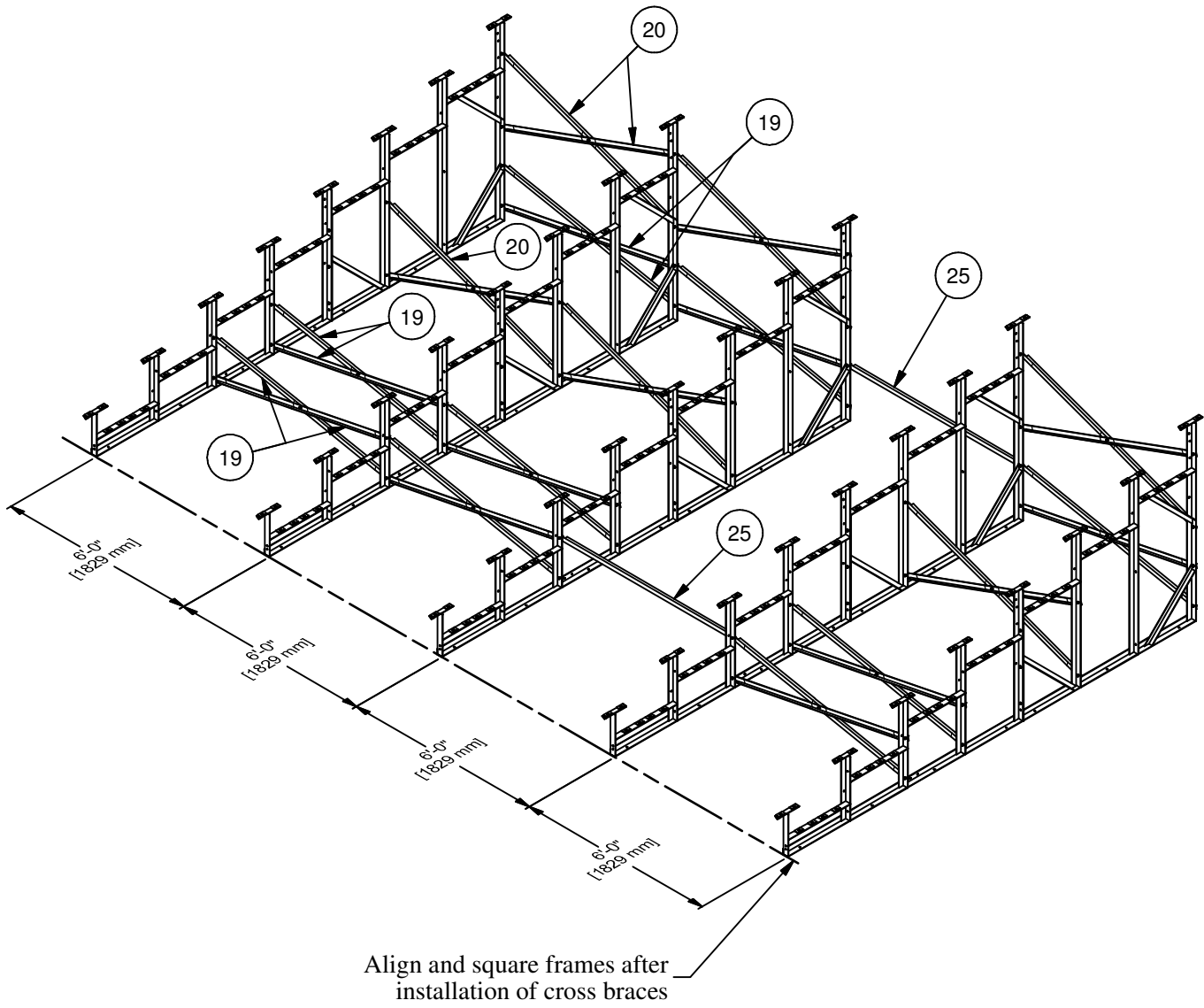


Figure 3

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 3,4,6, and 8. Refer to figure 3 for item number and page 2 for brace angle length. NOTE: Cross braces are located in the end bays and either bay 2 or bay 3. Straight spacer braces are located in bay 2 or bay 3 at row 3 and row 8 only. If the cross braces are going to be located in bay 2, the straight braces must be located in bay 3. However, if the cross braces are going to be located in bay 3, the straight braces must be located in bay 2. After all braces are installed, square the frame and make sure the front of the frame is in line.

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DATE	SHT. NO.	PART NO.	REV
5/27/2014	5 OF 16	GSNB0827WA ai	

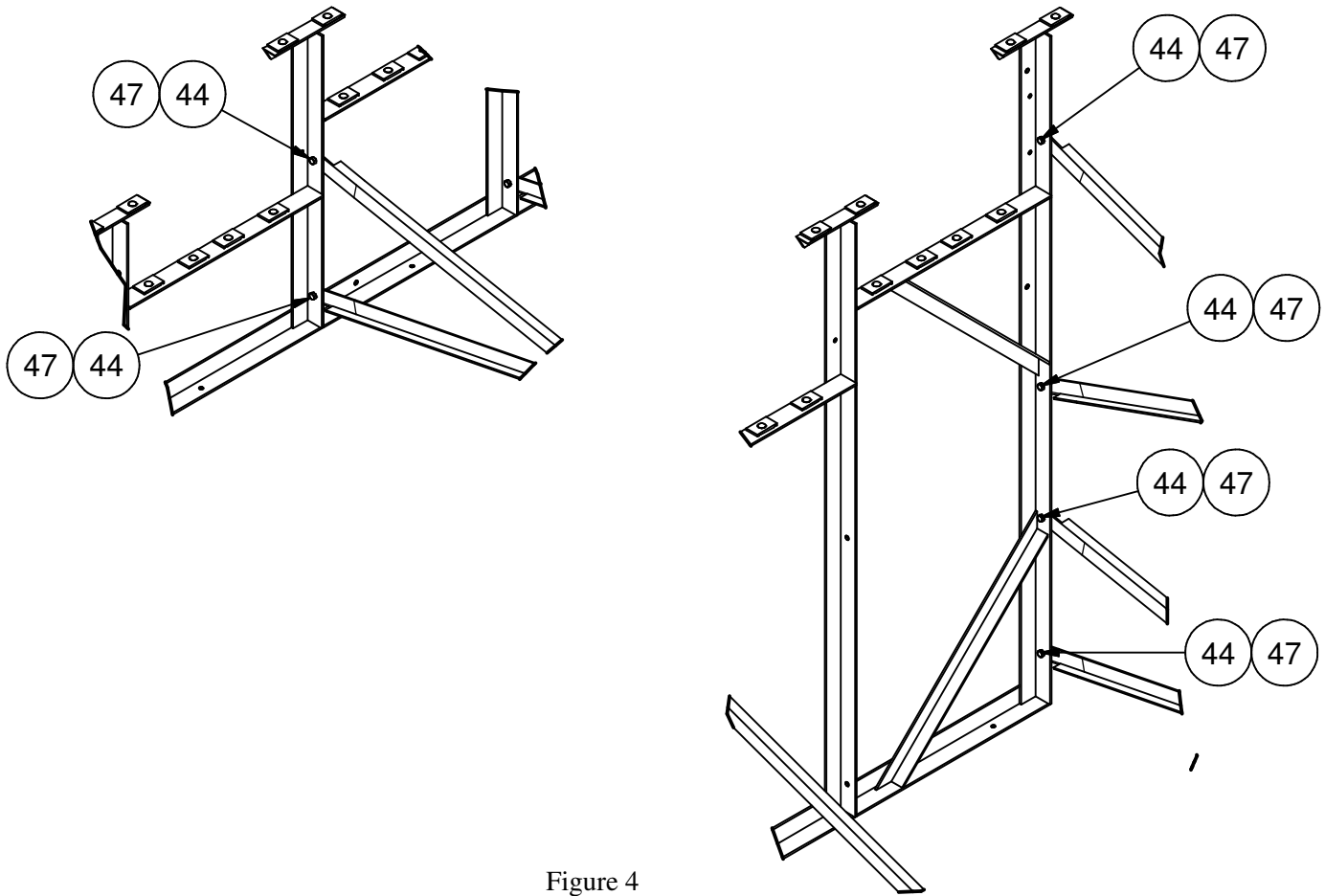


Figure 4

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 rivet to retain the end caps. See Figure 5.

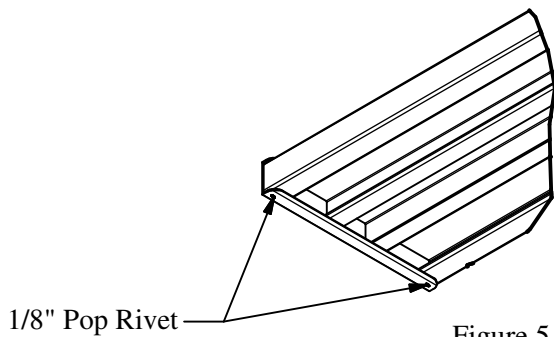


Figure 5

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	6 OF 16	GSNB0827WA 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.

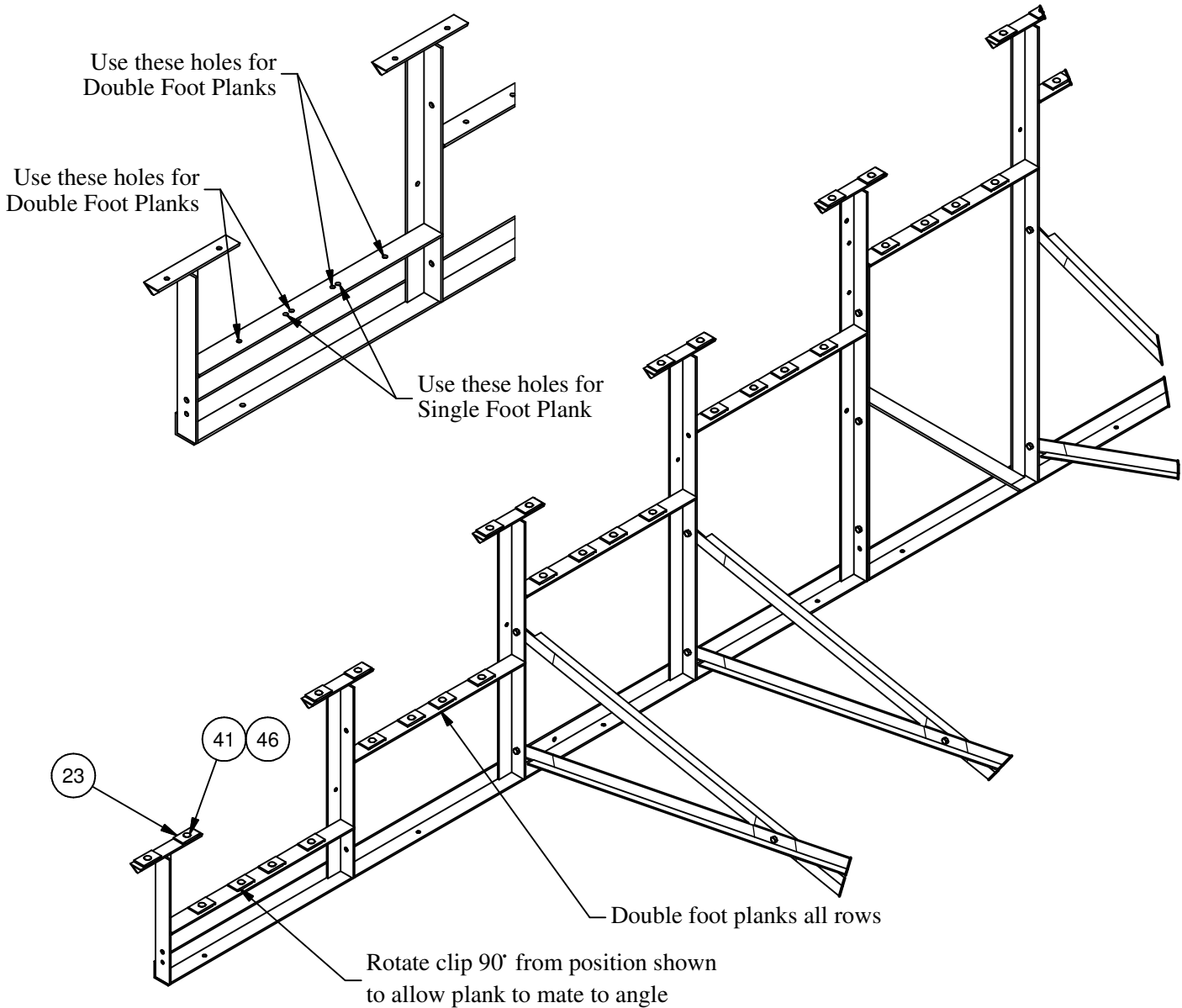


Figure 6

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

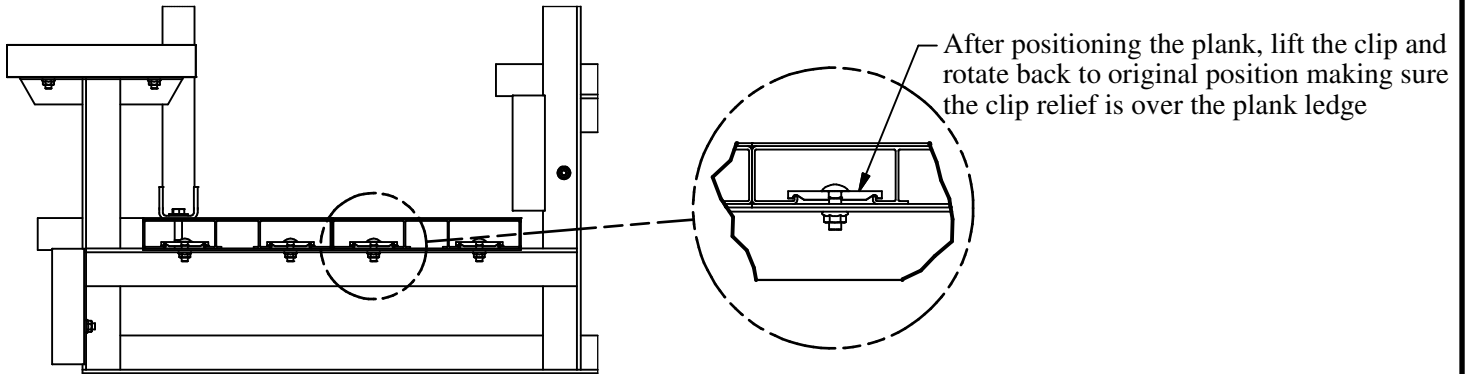
Install all foot planks before installing riser planks. Install the riser planks then install the seat planks.

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	7 OF 16	GSNB0827WA 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.

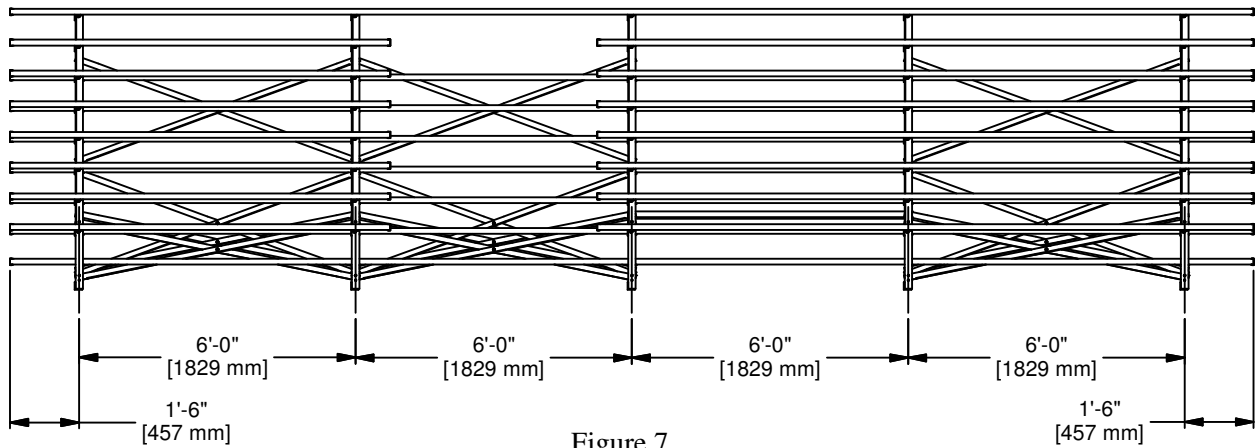
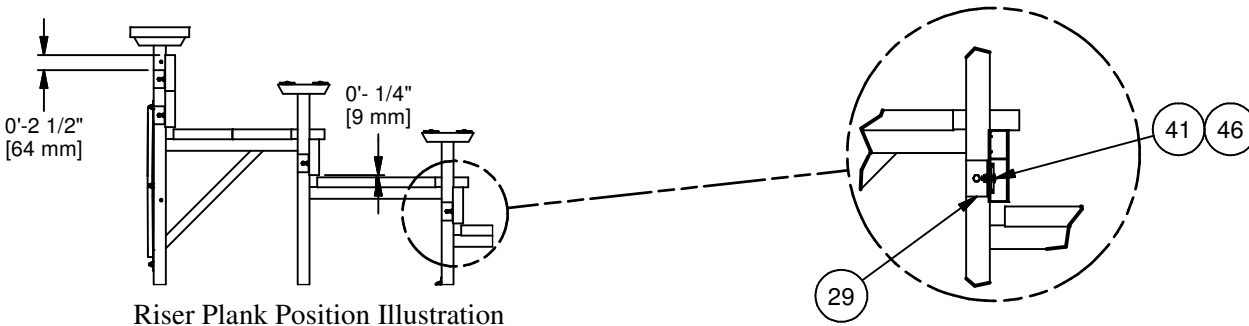


Figure 7

7. Install the riser planks on the 2nd through 8th 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

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	8 OF 16	GSNB0827WA ai	



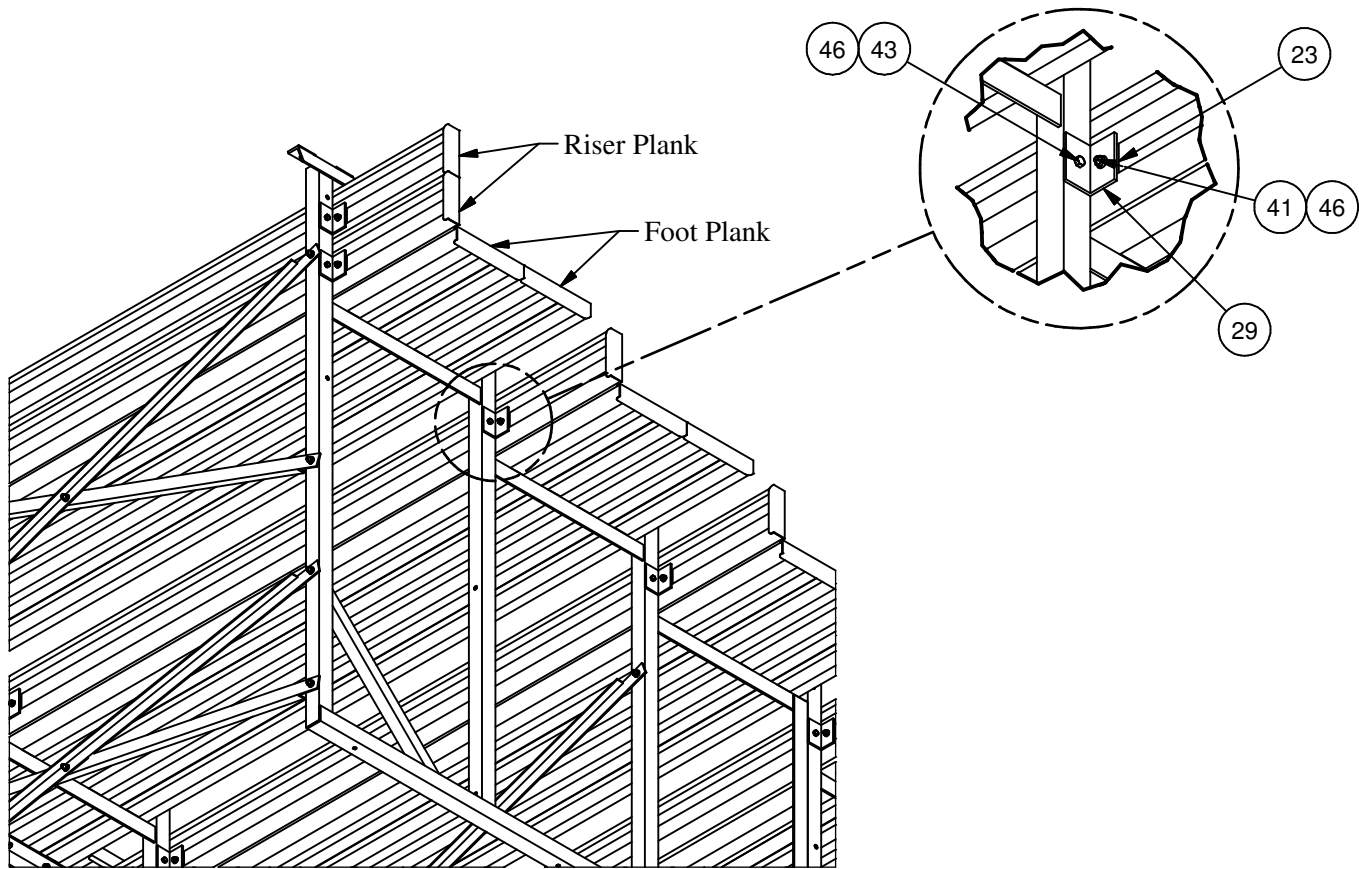


Figure 8

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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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	9 OF 16	GSNB0827WA 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.

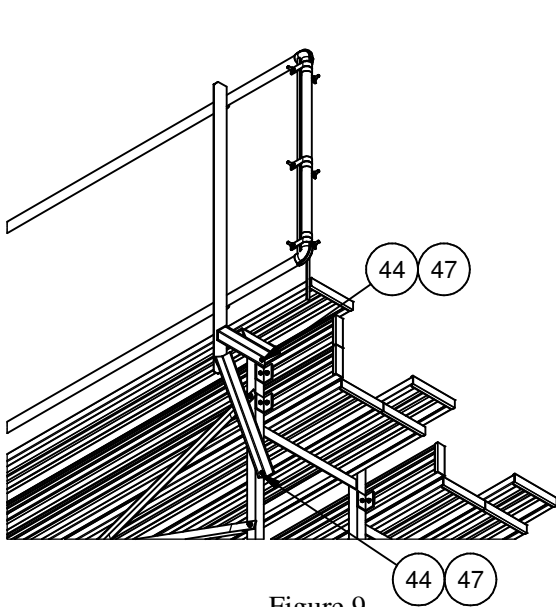


Figure 9

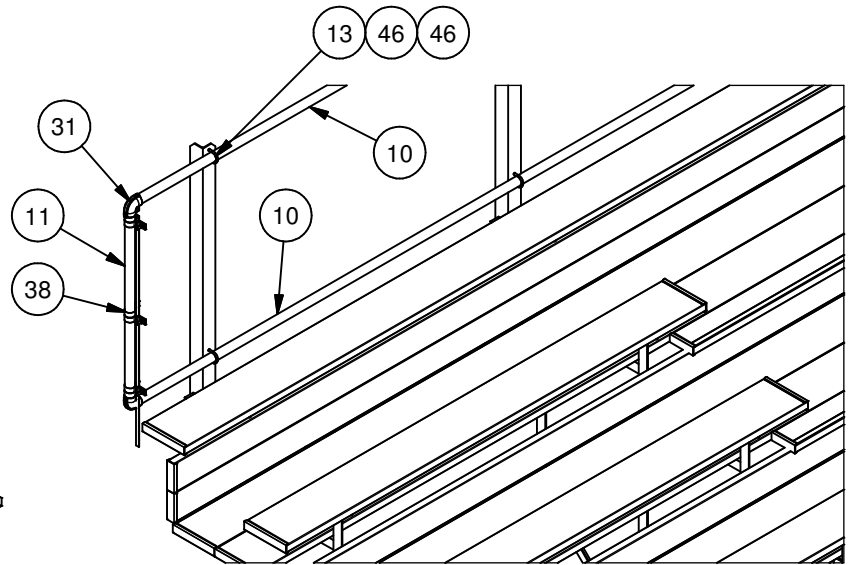
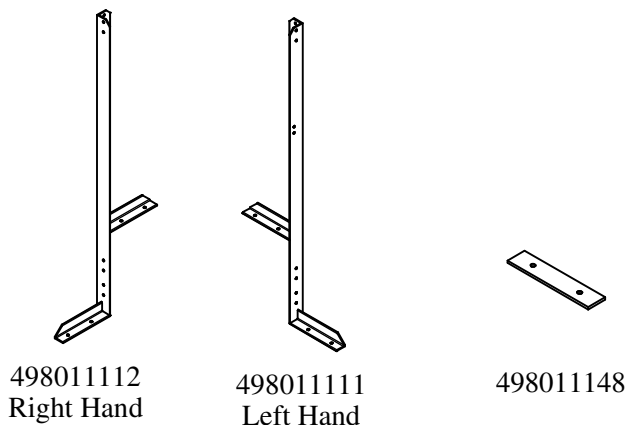


Figure 10

13. Attach the 27' 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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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	10 OF 16	GSNB0827WA ai	

16. Install the side rail weldments onto the ends of the bleacher. Locate one vertical on the top row, 6th 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.

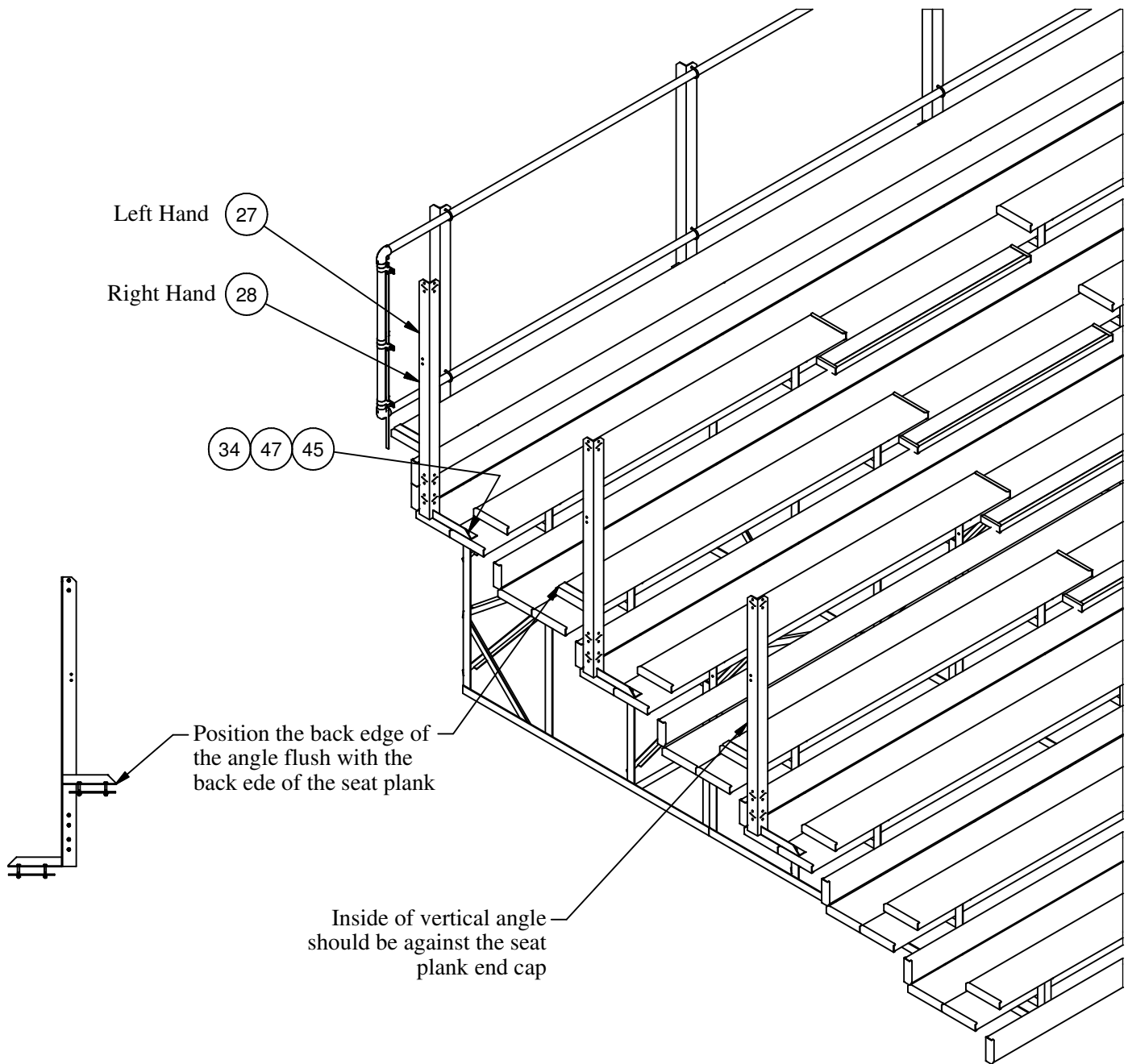


Figure 11

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Noblesville, IN 46060

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	11 OF 16	GSNB0827WA ai	

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

Install the 144.0" 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 129.0" 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 120.0" 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.

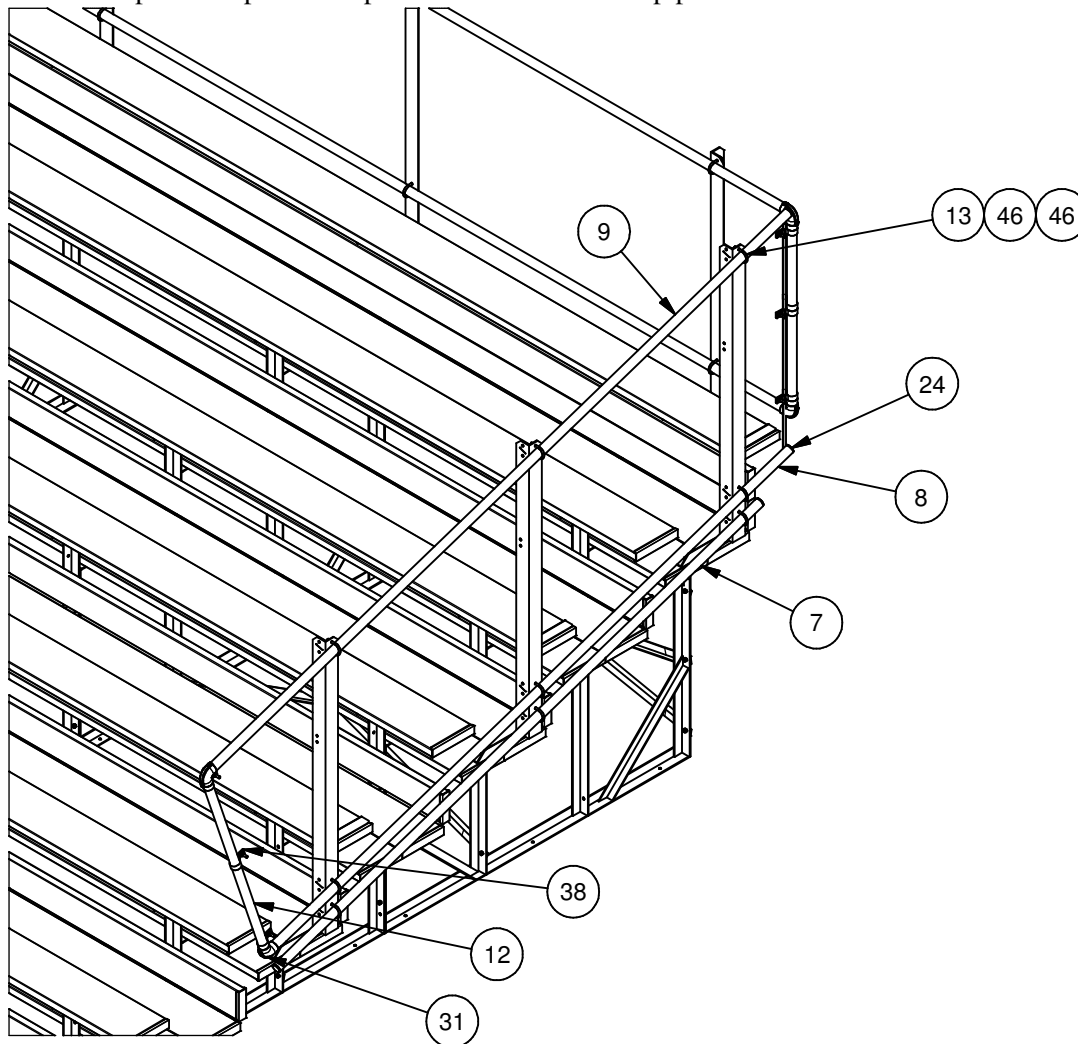


Figure 12

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Noblesville, IN 46060

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FILE LOC. Q:\Inventor Files\

DATE

5/27/2014

SHT. NO.

12 OF 16

PART NO.

GSNB0827WA ai

REV

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.

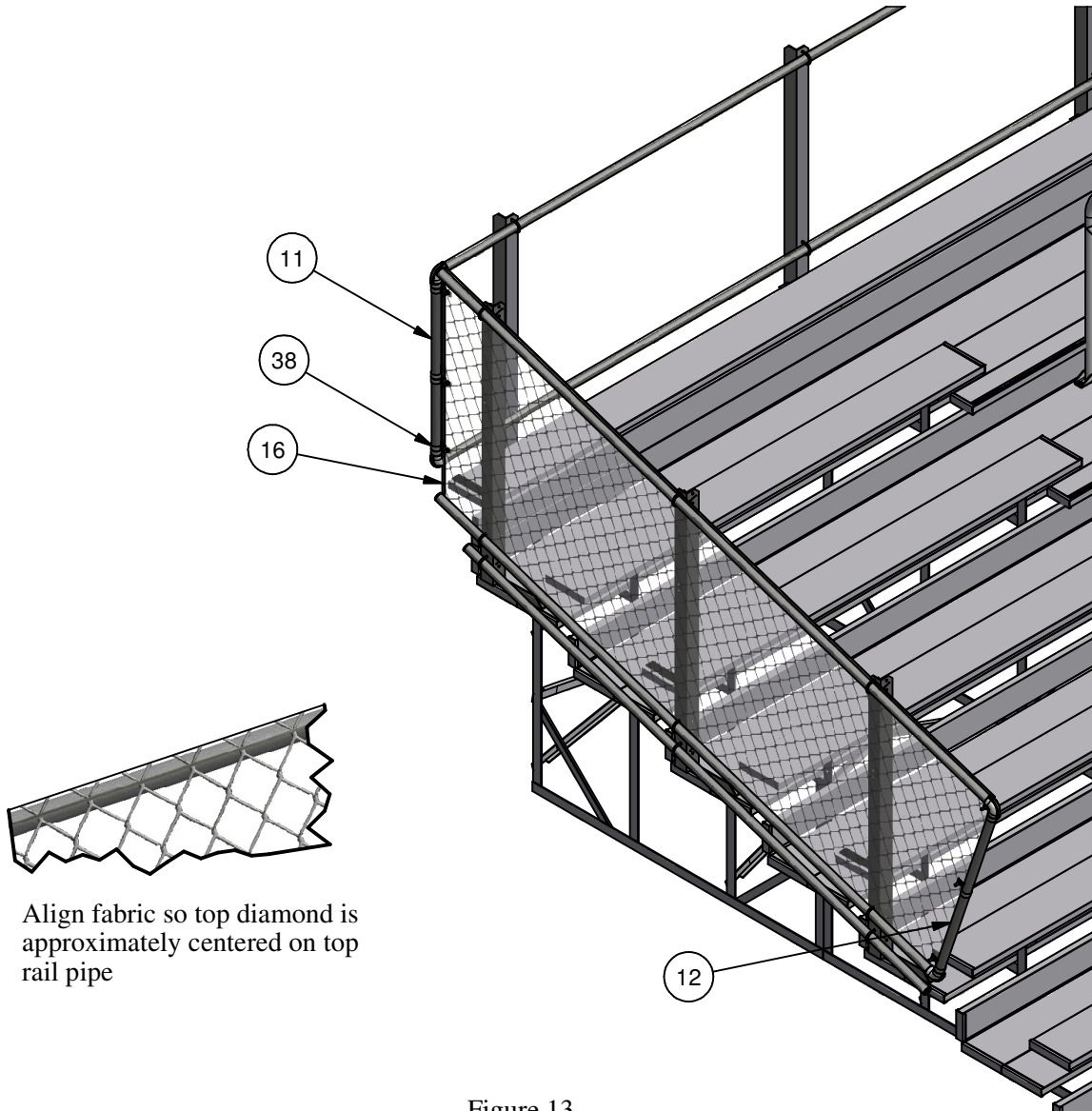


Figure 13

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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DATE	SHT. NO.	PART NO.	REV
5/27/2014	13 OF 16	GSNB0827WA ai	

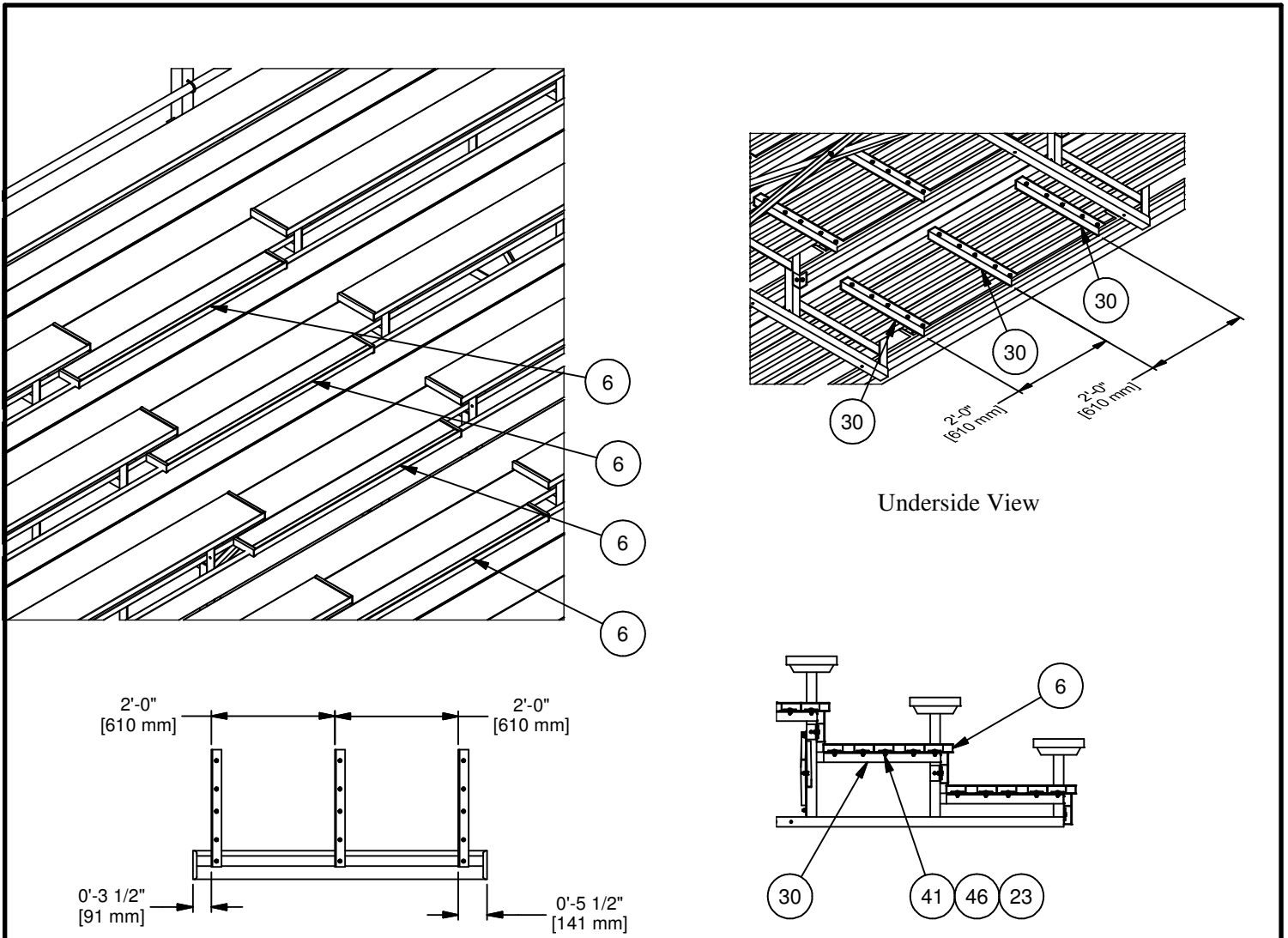


Figure 14

20. Attach three (3) bleacher step mounting angles (Item 30) 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 3, 5 and 6, and 8 and nine. See figure 15 for reference.

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	14 OF 16	GSNB0827WA ai	



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.

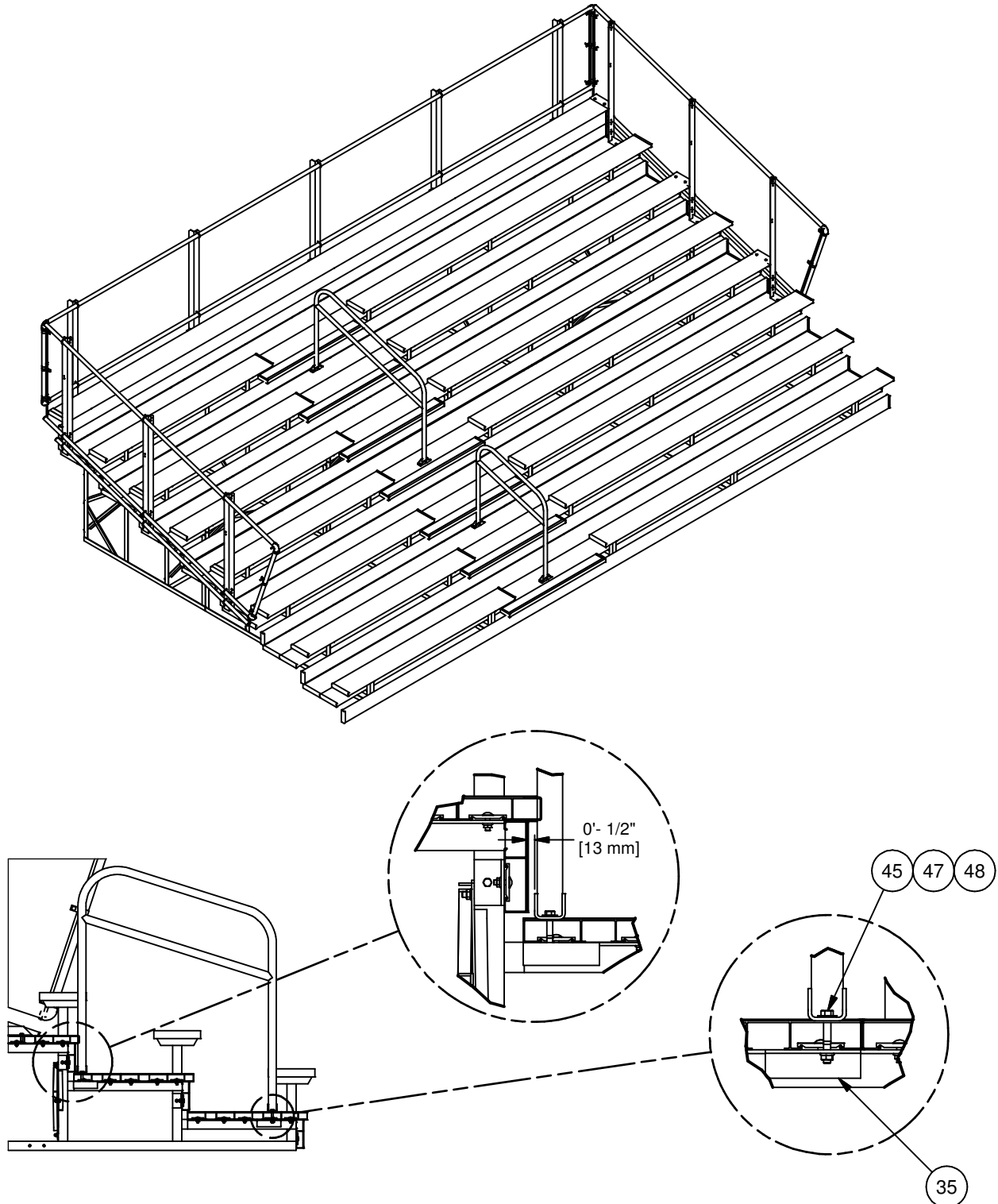


Figure 15

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	15 OF 16	GSNB0827WA ai	

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 35) across the space on the foot plank and insert the 3/8" bolt before installing and tightening the nut.

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

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

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FILE LOC. Q:\Inventor Files\			
DATE	SHT. NO.	PART NO.	REV
5/27/2014	16 OF 16	GSNB0827WA ai	