NOTE: LEAVE ALL NUTS AND BOLTS FINGER TIGHT UNTIL NOTED OTHERWISE.

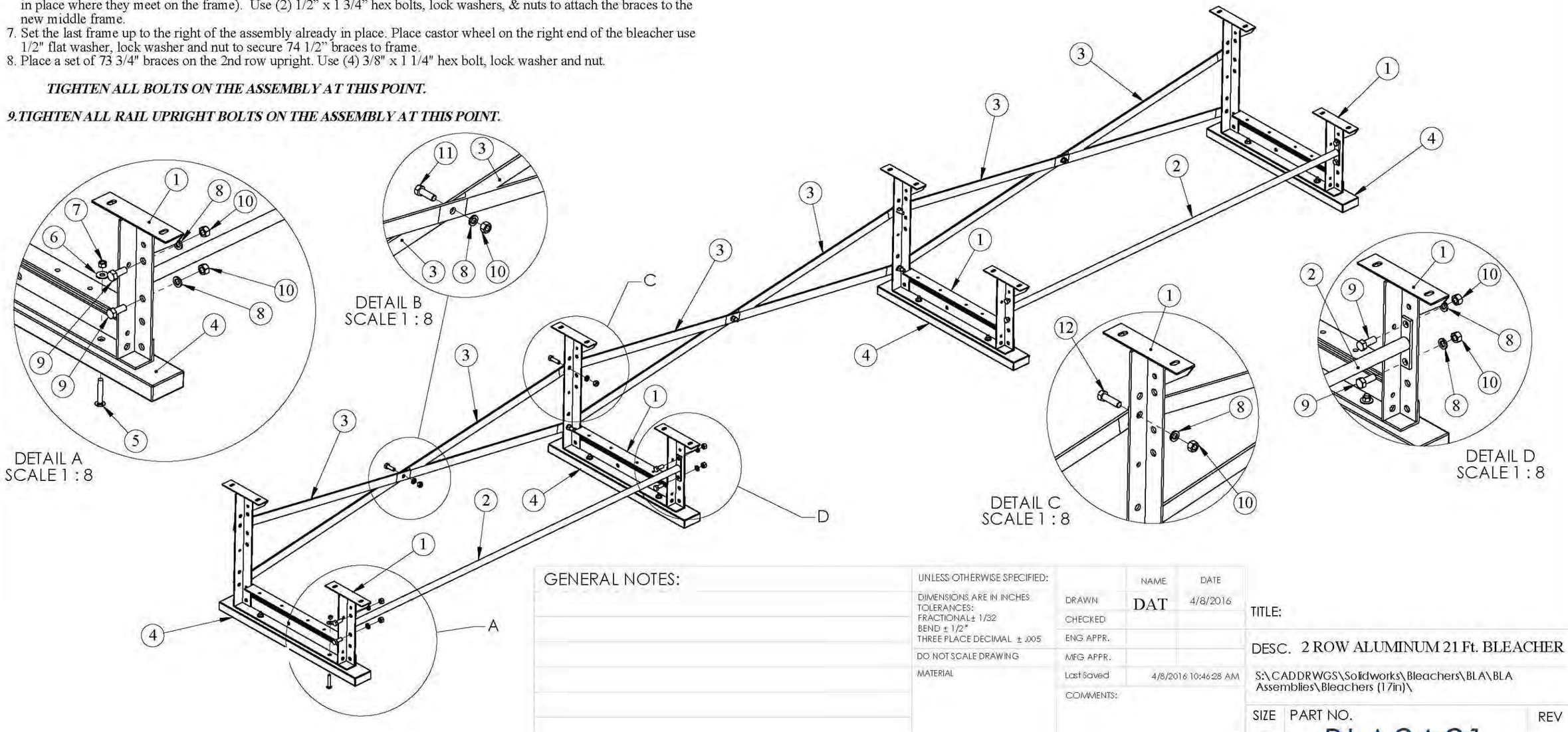
1. Match all of the braces together by length (74 1/2").

2. Now place 2 matching braces flat together, line up the holes in the middle, and put (1) 1/2" x 1 1/4" hex bolt through the holes. A lock washer and nut will secure the bolt onto the brace. You will end up with 3sets 47 1/2" braces.
3. Place a 2"x 4" mud sill on the bottom of each frame with the overhang at the rear of the bleacher as shown in **figure 1**. Be sure the countersunk side of the hole is facing away from the frame. Use 3/8"x 2 1/4" carriage bolt, lock washer and nut. The bolt should come up from the bottom of the sill. ***THESE CAN BE TIGHTENED NOW!***
4. Stand 2 of the frames approximately 6' apart and place a set of the 74 1/2" braces on one end between the frames at the 2nd upright on the frame as shown in **figure 1**. Place on left side of the frame castor wheels use 1/2" flat washers, lock washers and nuts..Place (2EA) 1/2" x 1 3/4" hex bolts, lock washers & nuts through the small brace and frame holes where they meet on the right side of the rame.
5. As shown in the spaces of the bleacher place a tube brace on the 1st row uprights. Attach them with two ½" x 1-¼" hex bolts, lock washers, and nuts on each end of the braces.Place 1/2" x 1-1/2" hex bolts through the tube brace and frame holes where they meet.
6. Place another frame on the right side of the set already in place (as you face the back of the bleacher). Place a set of the 74 1/2" braces on the 2nd row upright. (You will need to remove the 2 nuts & lock washers from the two braces already in place where they meet on the frame). Use (2) 1/2" x 1 3/4" hex bolts, lock washers, & nuts to attach the braces to the new middle frame.
7. Set the last frame up to the right of the assembly already in place. Place castor wheel on the right end of the bleacher use 1/2" flat washer, lock washer and nut to secure 74 1/2" braces to frame.
8. Place a set of 73 3/4" braces on the 2nd row upright. Use (4) 3/8" x 1 1/4" hex bolt, lock washer and nut.

TIGHTEN ALL BOLTS ON THE ASSEMBLY AT THIS POINT.

9.TIGHTEN ALL RAIL UPRIGHT BOLTS ON THE ASSEMBLY AT THIS POINT.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	BLATR2-SA1	2 ROW TIP AND ROLL ALUM FINAL ASSEMBLY	4
2	IBLA-SA2	1 ST ROW GALV BRACE ASSEMBLY	2
3	IBLA-7450	X Brace 74 1/2" Long	6
4	IBL2-355	2" x 4" 31.50" SYP TREAT MUD SILL	4
5	RHSSNBOLT 0.375-16x2.25x2.25-N	RHSSNBOLT 0.375-16x2.25x2.25-N	8
6	Regular FW 0.375	3/8" REGULAR FLAT WASHER	8
7	HNUT 0.3750-16-D-N	HEX NUT 3/8"-16	8
8	Regular LW 0.5	REG LOCKWASHER 1/2"	15
9	HBOLT 0.5000-13x1.25x1.25-N	HEX BOLT 1/2"-13x 1 1/4"	8
10	HNUT 0.5000-13-D-N	HEX NUT 1/2"-13	15
11	HBOLT 0.5000-13x1.5x1.5-N	HEX HEAD BOLT 1/2"-13x 1 1/2"	3
12	HBOLT 0.5000-13x1.75x1.75-N	HEX BOLT 1/2"-13x 1 3/4"	4



GENERAL NOTES:

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/32
BEND ± 1/2°
THREE PLACE DECIMAL ± .005
DO NOT SCALE DRAWING
MATERIAL

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DRAWN	DAT	4/8/2016
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TITLE:

DESC. 2 ROW ALUMINUM 21 Ft. BLEACHER

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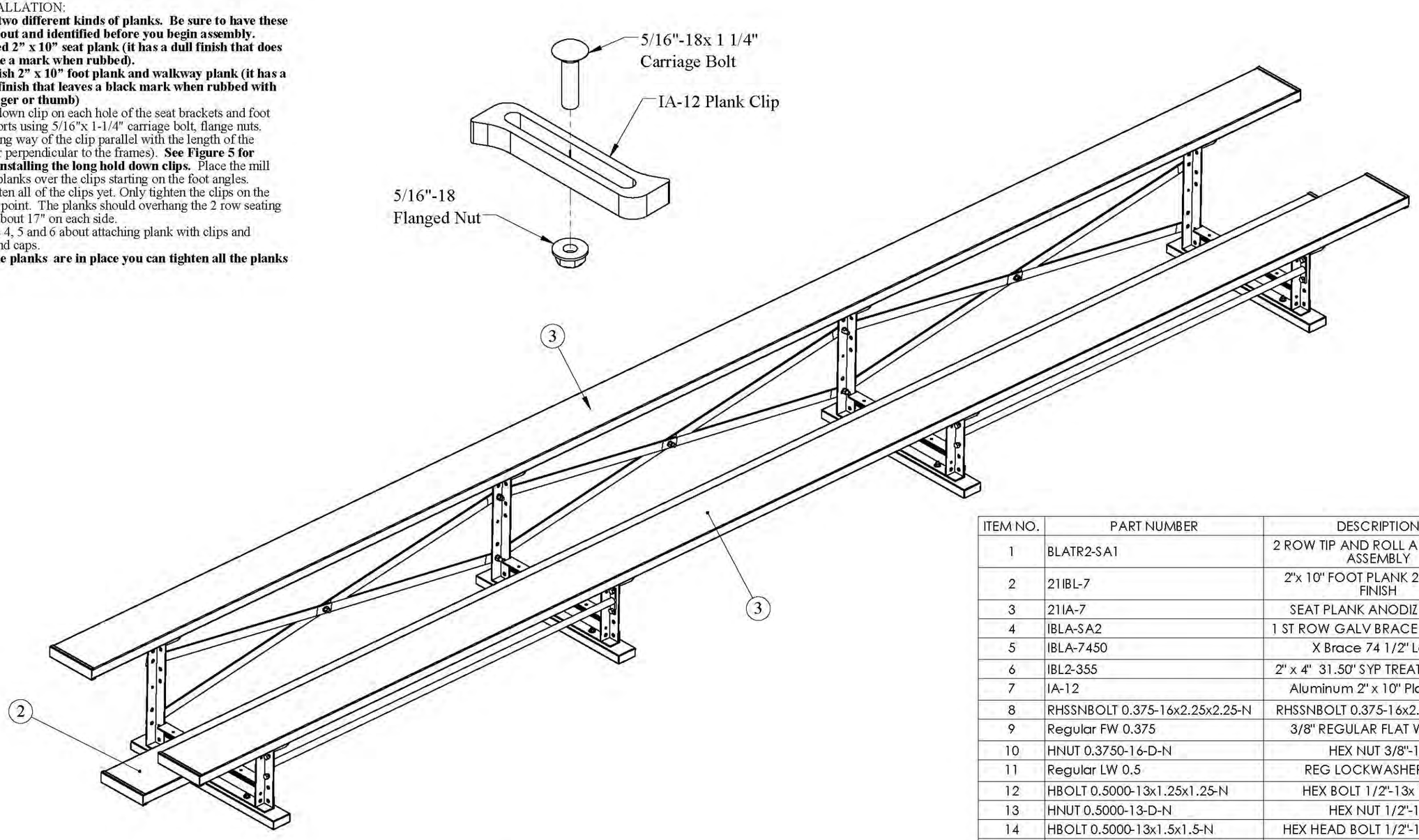
SIZE	PART NO.	REV
B	BLA2A21	

PLANK INSTALLATION:

10. There are two different kinds of planks. Be sure to have these separated out and identified before you begin assembly.
   a. Anodized 2" x 10" seat plank (it has a dull finish that does not leave a mark when rubbed).
   b. Mill finish 2" x 10" foot plank and walkway plank (it has a shinier finish that leaves a black mark when rubbed with your finger or thumb)

11. Put a hold down clip on each hole of the seat brackets and foot board supports using 5/16"x 1-1/4" carriage bolt, flange nuts. Keep the long way of the clip parallel with the length of the bleacher (or perpendicular to the frames). **See Figure 5 for details on installing the long hold down clips.** Place the mill finish foot planks over the clips starting on the foot angles.
12. Do not tighten all of the clips yet. Only tighten the clips on the ends at this point. The planks should overhang the 2 row seating frames by about 17" on each side.
13. See Figures 4, 5 and 6 about attaching plank with clips and installing end caps.
14. **Once all the planks are in place you can tighten all the planks now.**



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	BLATR2-SA1	2 ROW TIP AND ROLL ALUM FINAL ASSEMBLY	4
2	21IBL-7	2"x 10" FOOT PLANK 252" MILL FINISH	1
3	21IA-7	SEAT PLANK ANODIZED (21')	2
4	IBLA-SA2	1 ST ROW GALV BRACE ASSEMBLY	2
5	IBLA-7450	X Brace 74 1/2" Long	6
6	IBL2-355	2" x 4" 31.50" SYP TREAT MUD SILL	4
7	IA-12	Aluminum 2" x 10" Plank Clip	24
8	RHSSNBOLT 0.375-16x2.25x2.25-N	RHSSNBOLT 0.375-16x2.25x2.25-N	8
9	Regular FW 0.375	3/8" REGULAR FLAT WASHER	8
10	HNUT 0.3750-16-D-N	HEX NUT 3/8"-16	8
11	Regular LW 0.5	REG LOCKWASHER 1/2"	15
12	HBOLT 0.5000-13x1.25x1.25-N	HEX BOLT 1/2"-13x 1 1/4"	8
13	HNUT 0.5000-13-D-N	HEX NUT 1/2"-13	15
14	HBOLT 0.5000-13x1.5x1.5-N	HEX HEAD BOLT 1/2"-13x 1 1/2"	3
15	HBOLT 0.5000-13x1.75x1.75-N	HEX BOLT 1/2"-13x 1 3/4"	4

GENERAL NOTES:

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DIMENSIONS ARE IN INCHES
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FRACTIONAL± 1/32
BEND ± 1/2°
THREE PLACE DECIMAL ± .005

DO NOT SCALE DRAWING

MATERIAL

SHEET 2 OF 2

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SIZE	PART NO.	REV
B	BLA2A21	