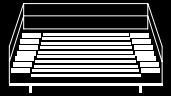


# 3 and 4 Row All Star Bleachers

## Assembly Instructions



Instructions are applicable to all 3 and 4 row All Star Bleachers. Three row item numbers: A6A3S7.5, A6A3S15, A6A3S21, A6A3S24, A6A3S27. Four row item numbers: A6A4S7.5, A6A4S15, A6A4S21, A6A4S24, A6A4S27.

### Step 1

#### Hardware, Parts, and Tools Needed

- The hardware kit includes 3/8" x 1 1/2" galvanized washers, hex nuts, and bolts, 3/16" x 3/16" pop rivets. The hardware is individually packaged inside the crated box.
- The parts include frames, horizontal sturt, tie down assemblies, 10" and 12" end caps, 10" mill finish foot deck plank, and 12" anodized seat plank.
- The tools required to assembly your bleachers include:

- gloves
- safety glasses
- measuring tape
- rubber mallet
- pop rivet gun
- screw gun with 1/4" nut driver
- SAE ratchet & socket set with 1/2" socket and 9/16" socket

### Step 2

#### Preparation

- Secure a location that is large enough for the assembly process. The assembly area must be level.

### Step 3

#### Attach Horizontal Strut

- Stand each frame up with approximately 6 feet of spacing between each frame. CAUTION: Do not leave frames in a "free-standing" position.

### Step 3 (continued)

- Insert 3/8" x 1 1/2" hex bolts through the frames as indicated in Figure 1. Each frame will accommodate two (2) bolts with a flat washer and hex nut for each bolt.
- Hold on to each frame until the horizontal strut is in place, assistance from another person is recommended.
- Place the horizontal strut on to the bottom rear of each frame. Secure each bolt with a flat washer and hex nut as indicated in Figure 1. Do not fully tighten until all bolts are in place.

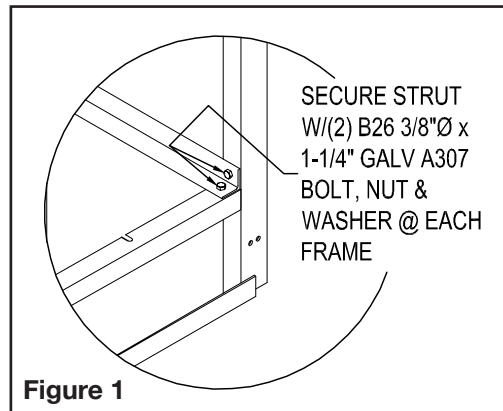


Figure 1

### Step 4

#### Attach End Caps

- Attach end caps to all seat plank and foot deck plank as indicated in Figure 2 with the wider flange on the bottom. Tap the channel end cap into place with a rubber mallet.
- Mechanically fasten with two (2) pop rivets through the bottom of each end cap through the bottom of the plank.

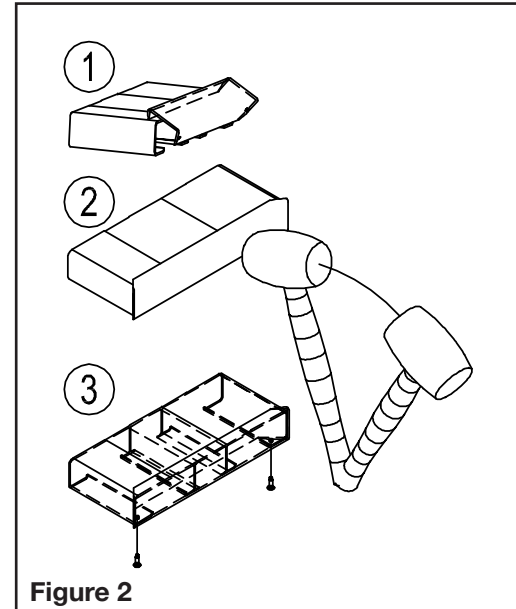


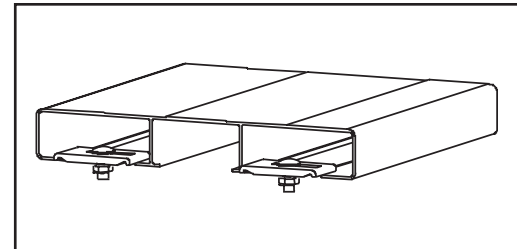
Figure 2

### Step 5

#### Placement of Foot Deck Planks and Seat Planks

**IMPORTANT:** All seat planks are anodized aluminum. Foot deck planks are mill finished aluminum. Anodized planks are duller in appearance and have a cleaner finish. Mill finished aluminum is brighter in appearance. Note the difference and separate accordingly.

- Insert two (2) tie down clip assemblies within all foot deck and seat planks at each frame location as indicated in Figure 3.



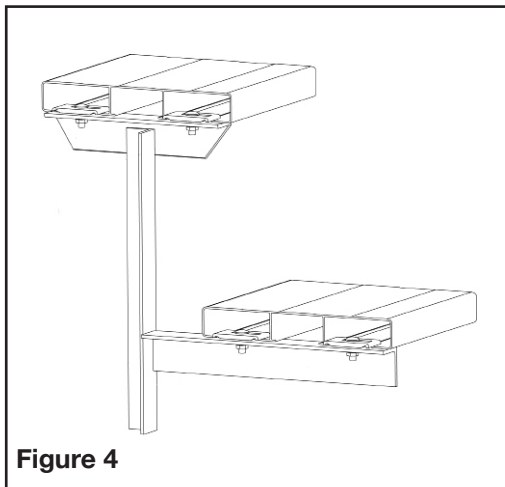
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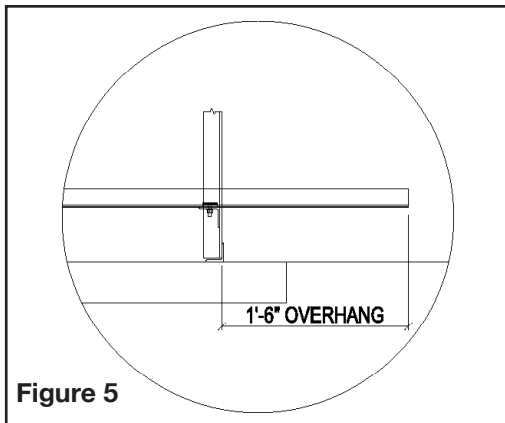
**Step 5 (continued)**

b. Make sure the tie down clip assemblies are saddled over the ribs on the bottom of the plank on both sides of each tie down clip assembly as indicated in Figure 4. Do not tighten the tie down clip assemblies until all foot deck and seat planks are in place and positioned properly over all frames.



**Figure 4**

c. Place foot deck plank on rows 2 through 4 (if applicable) tread support. Be sure to maintain proper overhang of 1'6" off of frame (Figure 5).

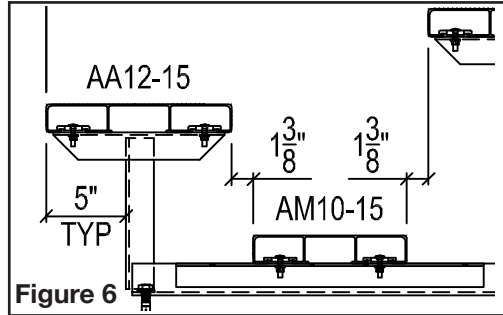


**Figure 5**

d. Position the lowest foot deck plank.

e. Each foot deck plank should align evenly between the back edge of the lower seat and the front edge of the upper seat support bracket as indicated in Figure 6.

**Step 5 (continued)**



**Figure 6**

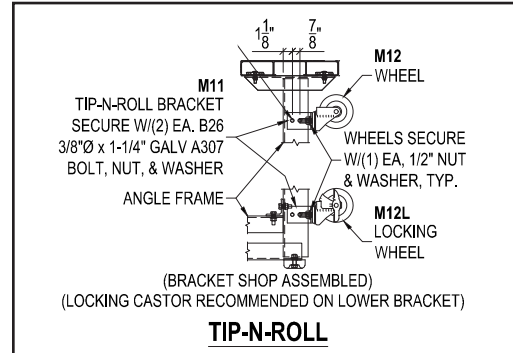
f. Continue installing all remaining foot deck plank.

g. Place seat plank on the top of each seat support bracket on rows 1 through 4 (if applicable) as indicated in Figure 4. Be sure to maintain proper overhang of 1'6" off of frame.

**Step 5 (continued)**

h. Once proper overhang of 1'6" has been verified and tie down assemblies are properly saddled over the ribs on the bottom of all foot deck and seat plank, tighten all tie down clip assemblies.

**Optional Accessories**



**Part List for 3 Row All Star Bleachers**

Part Number	Description	Quantity for Item Number				
		A6A3S7.5	A6A3S15	A6A3S21	A6A3S24	A6A3S27
A6A3D	6" Rise, 3 row bleacher frame assembly	2	3	4	5	5
AS06	2" x 2" x 3/16" x 6'2" (4 hole) strut	1	1	1	1	1
AB026	3/8" x 1/4" galvanized A307 bolt	4	6	8	10	10
AB087	#64 3/16" x 3/16" grip pop rivet	20	20	20	20	20
AM2	tie down assembly	20	30	40	50	50
AN04	3/8" nut	4	6	8	10	10
AW23	3/8" flat washer	4	6	8	10	10
AEC10	end cap for 10" foot deck plank	4	4	4	4	4
AEC12	end cap for 12" seat plank	6	6	6	6	6
AA12	12" anodized seat plank (7.5, 15, 21, 24, 27)	3	3	3	3	3
AM10	10" mill finish foot deck plank (7.5, 15, 21, 24, 27)	2	2	2	2	2

**Part List for 4 Row All Star Bleachers**

Part Number	Description	Quantity for Item Number				
		A6A3S7.5	A6A3S15	A6A3S21	A6A3S24	6A3S27
A6A4D	6" Rise, 4 row bleacher frame assembly	2	3	4	5	5
AS06	2" x 2" x 3/16" x 6'2" (4 hole) strut	1	1	1	1	1
AB026	3/8" x 1/4" galvanized A307 bolt	4	6	8	10	10
AB087	#64 3/16" x 3/16" grip pop rivet	28	28	28	28	28
AM2	tie down assembly	28	42	56	70	70
AN04	3/8" nut	4	6	8	10	10
AW23	3/8" flat washer	4	6	8	10	10
AEC10	end cap for 10" foot deck plank	6	6	6	6	6
AEC12	end cap for 12" seat plank	8	8	8	8	8
AA12	12" anodized seat plank (7.5, 15, 21, 24, 27)	4	4	4	4	4
AM10	10" mill finish foot deck plank (7.5, 15, 21, 24, 27)	3	3	3	3	3