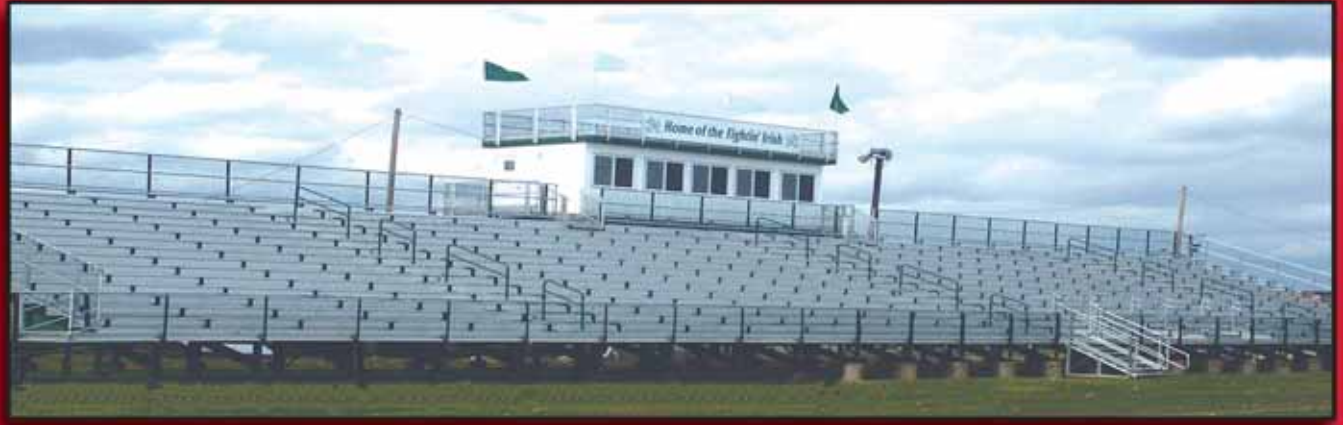




*America's Most Trusted Bleacher Company*



Manufacturers of Quality

# **ALUMINUM BLEACHERS**

**BENCHES • PICNIC TABLES • PRESS BOXES**  
**REPLACEMENT SEATING & INSTALLATION**



# TIP N' ROLL BLEACHERS

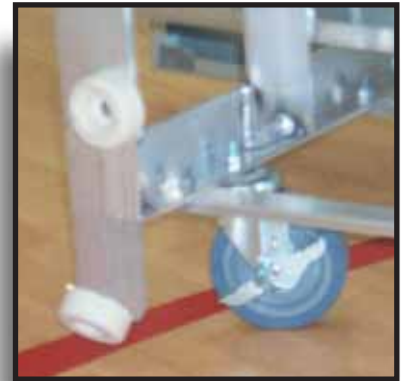
The perfect solution to your auxiliary seating needs.



3 Row Tip N' Roll Preferred

Our Tip N' Roll bleacher is easily tipped up onto its swivel casters for movement and storage when not in use.

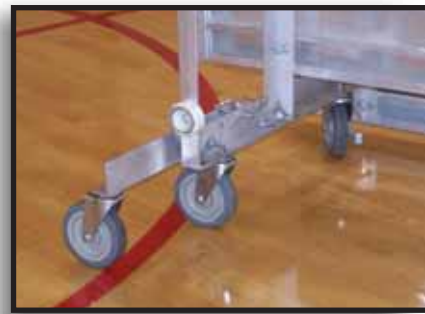
*When in use, the non-marring rubber foot pads not only keep the unit in place, but won't damage expensive gym floors. Caster brakes keep the bleacher from rolling when stored.*



Foot Pads & Casters



4 Row Tip N' Roll Standard

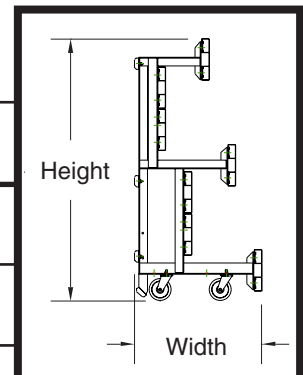


4 Row Tip N' Roll w/Outrigger

*Safety outrigger with casters are included on 4 row models for added stability when tipped up for movement.*

- \* Standard – Single (1) 2" X 10" Mill Finish Aluminum Foot Plank
- \* Preferred – Double (2) 2" X 10" Mill Finish Aluminum Foot Plank

ROWS	MODEL	1st SEAT HEIGHT	RISE	SEAT	OVERALL	
					WIDTH	HEIGHT
2	TIP N ROLL	17"	8"	2 X 10	2' - 2"	3' - 0"
3	TIP N ROLL	16"	6"	2 X 10	2' - 5"	5' - 0"
3	LOW RISE T&R	12"	6"	2 X 12	2' - 0"	4' - 2"
4	LOW RISE T&R	12"	6"	2 X 12	2' - 6"	7' - 1"



Tip N' Roll Bleachers are under 30" high, therefore most building and safety codes don't require guardrail. Please consult your local official for compliance.

Tip N' Roll Bleachers are available in many lengths, up to 24' in 2 & 3 row, and 15' in 4 row.

**WARNING:** Tip N' Roll Bleachers should only be tipped up indoors due to possible wind hazards. Responsible adult use only for all tipping and movement.

# LOW-RISE BLEACHERS

## 3 & 4 ROW SYSTEMS

Guardrail, aisles, risers not required by most building & safety codes

- 12" wide seat
- Top seat under 30" high
- First seat under 12" high
- 6" rise/24" run per row
- 3 & 4 Row Low Rise Bleachers are also available as Tip N' Roll (page 2) or Transportable (page 6).



**4 Row Low Rise Standard**

- \*Standard – Single (1) 2" X 10" Aluminum Foot Plank.
- \*Preferred – Double (2) 2" X 10" Aluminum Foot Plank.

**Low Rise Bleachers Available In Many Lengths.**

**Note:** Some spectators may prefer the higher seat heights as offered in our Non-Elevated Bleachers (see pages 4 & 5).

**LESS COST. . . AND MEETS BUILDING & SAFETY CODES.**

## 5 ROW SYSTEMS

Aisles not required by most building & safety codes

- Vertical Picket Guardrail & Top Row riser (2" X 10") Included
- Other Features - Same As Above 3 & 4 Row Models



**5 Row Low Rise Preferred**

*All bleachers should be anchored to resist wind loads. Please contact your local code authority for compliance with your applicable codes.*

# NON-ELEVATED BLEACHERS

## STANDARD BLEACHERS:



**3 Row Standard**

### 3 ROW SYSTEMS

Guardrail, risers not required by most building & safety codes.

- 16" first seat height
- 6" rise/24" run per row
- Top seat under 30" high
- 2 X 10 aluminum seat plank
- (1) 2 X 10 aluminum foot plank

### 5 - 10 ROW SYSTEMS

- 17" first seat height
- 8" rise/24" run per row
- 2 X 10 anodized aluminum seats
- Chainlink guardrail included  
(Optional vertical picket guardrail)
- (1) 2 X 10 aluminum foot plank under seat rows 2-3
- (2) 2 X 10 aluminum foot plank under seat rows 4 & up
- 1 X 6 riser plank under seat row 4 & up
- 2 X 10 riser plank top row

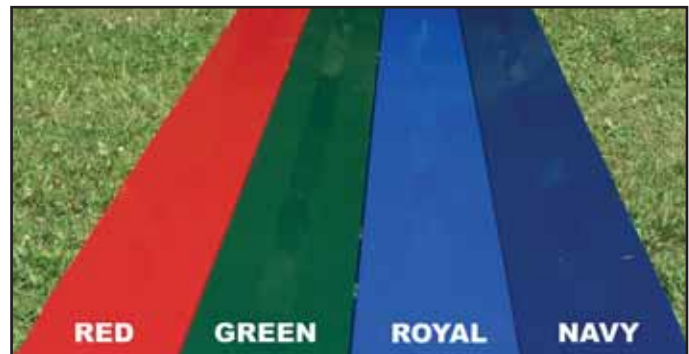


**5 Row Standard**

### POWDER COATED SEAT PLANK IN 4 POPULAR COLORS...

*(Stocked in 15' Lengths)*

**CUSTOM COLORS FOR SEATS OR RISERS ARE ALSO AVAILABLE.**



Actual Color May Vary.

*All bleachers should be anchored to resist wind loads. Please contact your local code authority for compliance with your applicable codes.*

# NON-ELEVATED BLEACHERS

## **PREFERRED** BLEACHERS:

### 3 - 10 ROW SYSTEMS



*5 Row Preferred*

Our "PREFERRED" models include all of the features of our "STANDARD" models, plus:

- Double (2) 2 X 10 Foot Planks on all rows.

ALL NON-ELEVATED BLEACHERS ARE AVAILABLE WITH EITHER GALVANIZED STEEL OR ALUMINUM ANGLE FRAMES.

## **DELUXE** BLEACHERS:

### 3 - 15 ROW SYSTEMS

Our "DELUXE" models include all of the features of our "PREFERRED" models, plus:

- Aisles with Handrails
- Riser Plank on all Rows



*5 Row Deluxe*



*10 Row Deluxe*

*All bleachers should be anchored to resist wind loads. Please contact your local code authority for compliance with your applicable codes.*

# TRANSPORTABLE BLEACHERS

Don't confuse portable bleachers with bleachers you'd like to move around your grounds. Our **Transportable Bleachers** are designed specifically to withstand the rigors of movement.

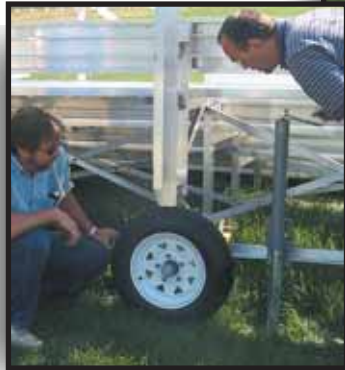
Each **Transportable Bleacher** is fitted with a galvanized steel horizontal lifting brace, and has extra bracing to stabilize the bleacher when transported.

- \* **Aluminum or Galvanized Steel Frames with Aluminum Plank**
- \* **5 & 10 Row Models Available in 15', 21' & 24' length**



**5 Row (Non-Elevated) Transportable**

For up to  
5 Row  
Non-Elevated  
Models.



**Light Duty Kit**

**Order one Transport Kit to  
move several transportable  
bleachers.**



**10 Row (Non-Elevated) Transportable**



**Heavy Duty Kit**

For 10 Row  
Non-Elevated  
& All Elevated  
Models.

*All transportable units include ground sills, but may need to be anchored to resist wind and/or to meet local codes.*

**WARNING:** Transportable bleachers are not intended for use on any public roadway. 5 mph maximum recommended speed limit.

# ELEVATED BLEACHERS

For events where elevated bleachers provide better viewing for your spectators.

Elevated bleachers include:

- Anodized Aluminum Seat Planks
- (2) Aluminum Foot Planks
- Riser Plank Under Every Seat
- Chainlink Guardrails
- Front Walkways w/Entry Stairs
- Aisles w/Handrails
- Optional A.D.A. Wheelchair Seating, Accessibility Ramps



**5 Row Elevated Bleacher with  
Optional Vertical Picket Guardrail**

***Elevated bleachers are available in 3 - 20 rows,  
at most any length.***



**10 Row Elevated Bleacher with Powder-Coated Seat & Riser,  
Press Box, A.D.A. Ramp & Stair Access**

# OPTIONAL FEATURES

Choose from a variety of features to enhance the safety and comfort of your spectators.



**Powder Coated Seat & Riser Plank**



**A.D.A. Wheelchair Seating**

**Vertical Picket Guardrail**



**A.D.A. Accessibility Ramps**



**Pre-fabricated Press Box**

Contact our expert staff early in your planning stages. We provide free consultation and assistance with configurations, lead times, prices and budgets to suit your needs.

# REPLACEMENT SEATING

***IF YOUR OLD BLEACHERS LOOK LIKE THIS. . .***



***WE CAN MAKE THEM LOOK LIKE THIS. . .***



Many old or unsafe bleachers can be retrofitted using the existing framework by adding aluminum planking to replace deteriorated wood planks and to close up unsafe gaps.

No more looking for broken or weak wooden planks when you renovate with low maintenance aluminum.

We offer expert assistance in planning your renovation, and have a variety of aluminum plank profiles which can provide solid adaptation to most existing understructures.

***Update your old unsafe bleachers to today's building and safety codes.***

***Don't wait for a costly accident to fix your bleachers.  
Call us soon for a free consultation!***

# ALUMINUM BENCHES & PICNIC TABLES

## BENCHES



Whether it's your local high school football team or the biggest game in professional football... insist on "The Best Seat In The House".



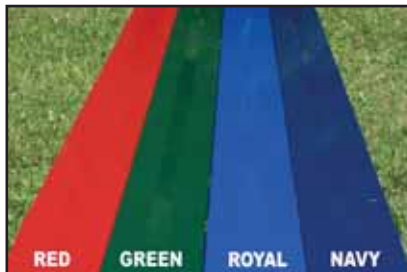
PORTABLE OR PERMANENT, WITH OR WITHOUT BACKREST



PORTABLE WITH BACKREST, PORTABLE W/O BACK SHOWN WITH OPTIONAL RUBBER FOOT PADS



PORTABLE WITH BACKREST & SHELF



POWDER COATED SEAT/BACKREST AVAILABLE IN 4 POPULAR COLORS. STOCKED IN 15' LENGTHS.

## PICNIC TABLES

These durable, anodized aluminum picnic tables have galvanized steel pipe legs for low maintenance & long term use.

STANDARD = 1 5/8" O.D. Legs

HEAVY-DUTY = 2 3/8" O.D. Legs

*You can leave them outdoors all year!*



Many lengths & wheelchair accessible models available!

# BENCH STYLES

*Many Lengths Available.*

## Aluminum seats/backrests with aluminum legs:



"DA" Portable Bench w/o Back



"DB" Portable Bench (Dbl. Wide) w/o Back



"DD" Permanent Bench w/o Back



"DE" Locker Room Bench w/o Back



"DF" Portable Bench w/o Back



"DG" Portable Bench w/ Back



"DGS" Portable Bench w/ Backrest & Shelf



"DBRA" Add/On Backrest (Angle) (Backrest Only)



"DBRE" Add/On Backrest (Channel) (Backrest Only)

---

## Aluminum seats/backrests with galvanized steel legs:



"PD" Permanent Bench w/o Back



"PB" Permanent Bench (Str. Leg) w/Back



"PE" Surface Mount Bench w/o Back



"PG" Portable Bench w/ Back

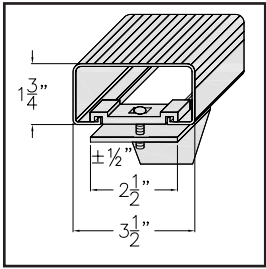


"PH" Surface Mount Bench w/ Back

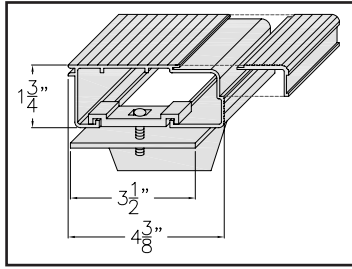


"PI" Portable Bench w/o Back

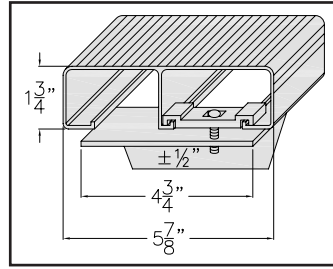
# ALUMINUM PLANK & BRACKETS



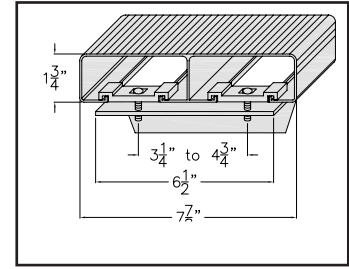
**2 x 4**



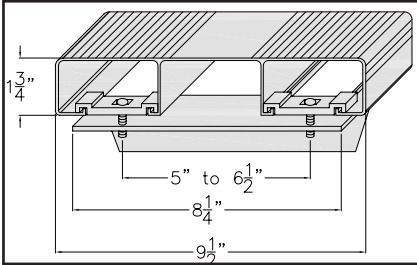
**2 x 5**



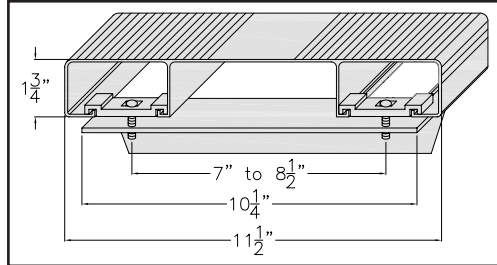
**2 x 6**



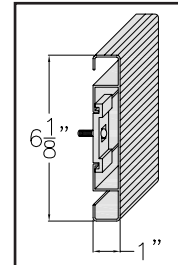
**2 x 8**



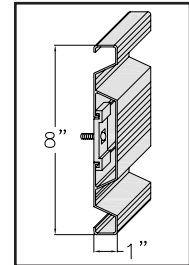
**2 x 10**



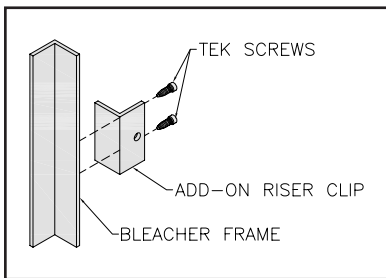
**2 x 12**



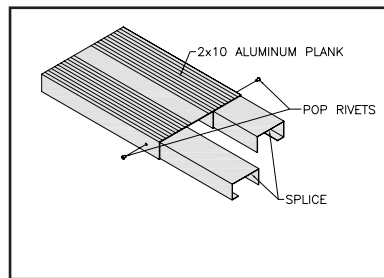
**1 x 6**



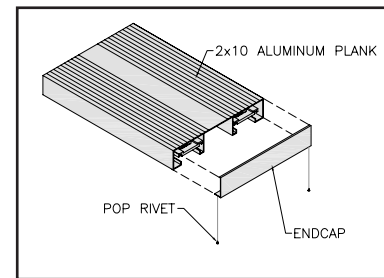
**1 x 8**



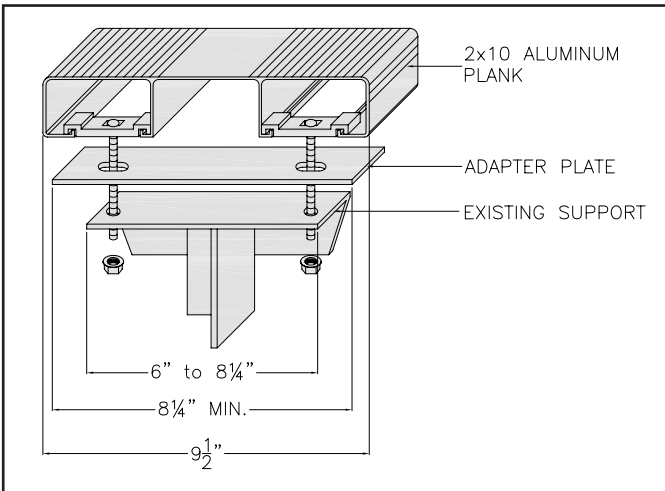
**RISER BRACKET**



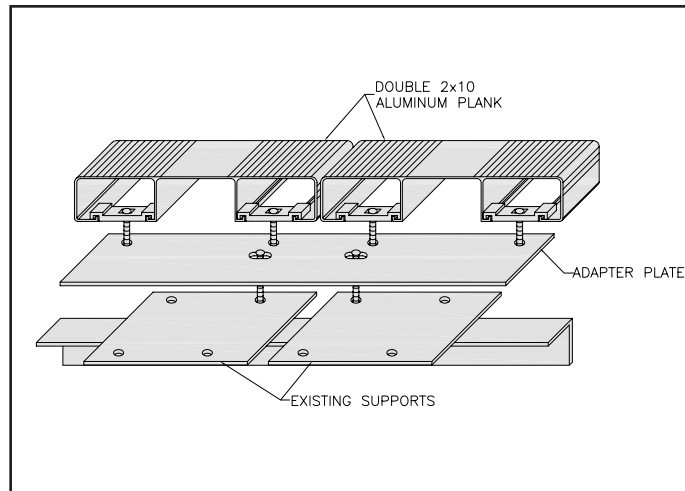
**SPLICE**



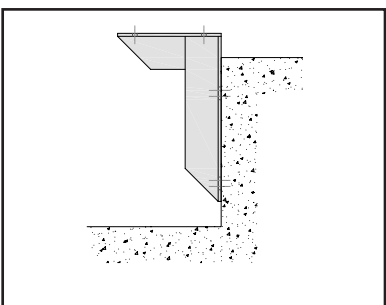
**END CAP**



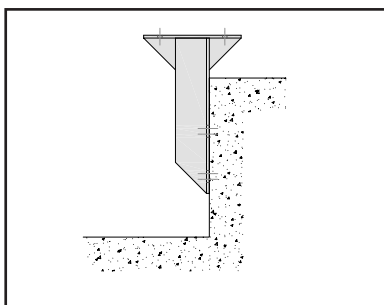
**SEAT ADAPTER PLATE**



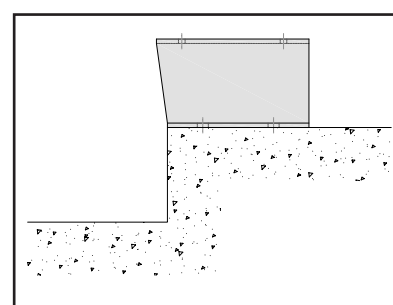
**DOUBLE FOOT ADAPTER PLATE**



**"L" BRACKET**

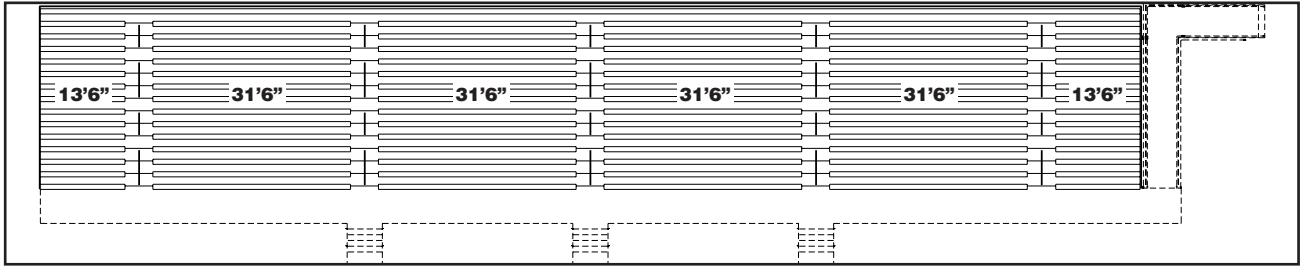


**"T" BRACKET**



**"Z" BRACKET**

# SEATING CHART



15 Row x 175' 6" (1545 seats, or 1469 + 14 HC)

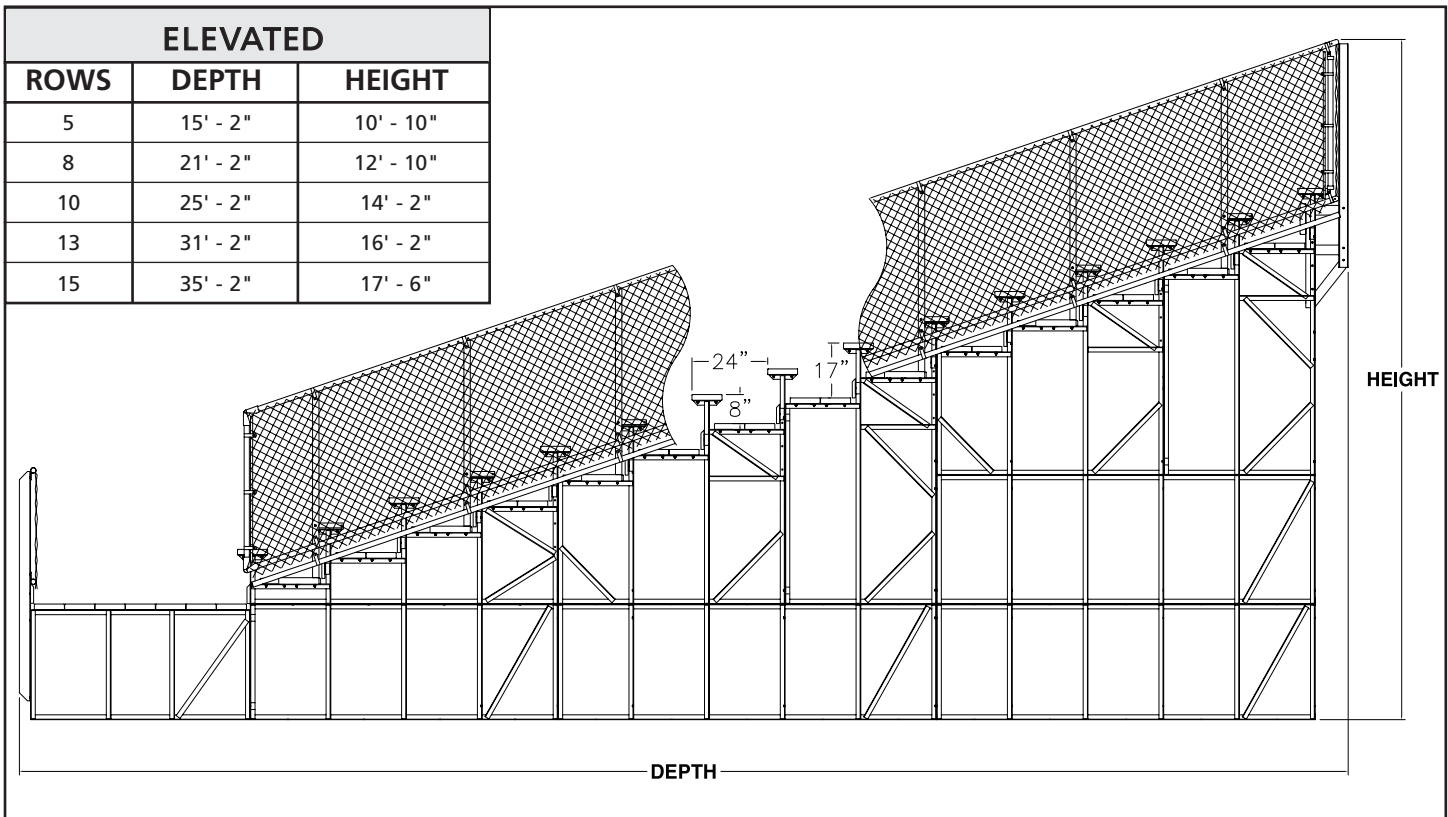
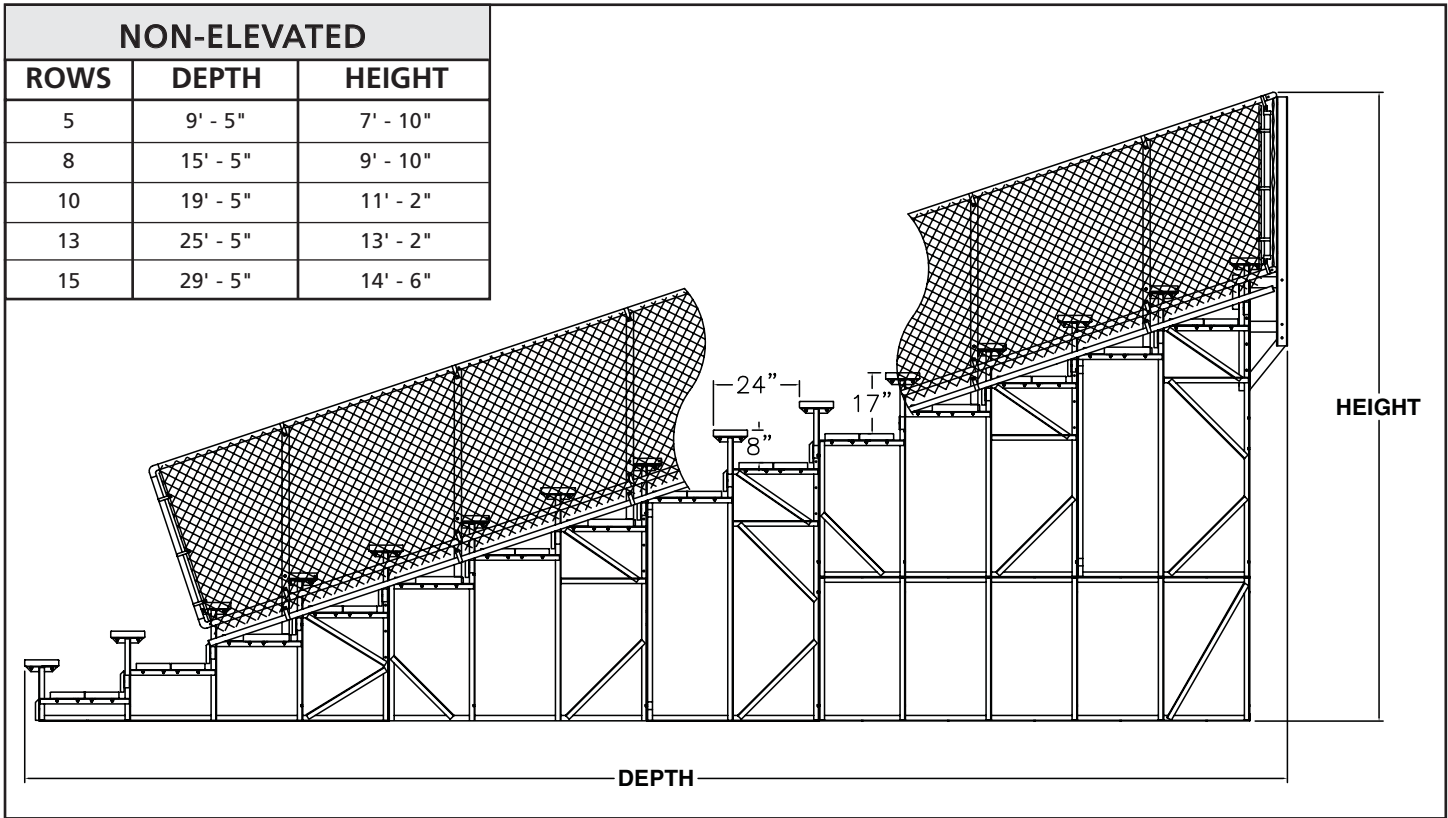
Qty of Rows	Overall Bleacher Length	Qty Seats Without Aisles	Qty Seats With Aisles		
			No. of Aisles	Without Wheelchairs	With Wheelchairs
2	7' - 6"	10	N/A	N/A	N/A
2	15'	20	N/A	N/A	N/A
2	21'	30	N/A	N/A	N/A
3	15'	30	N/A*	N/A	N/A
3	21'	42	1*	36	N/A
3	24'	48	1*	42	N/A
4	15'	40	N/A*	N/A	N/A
4	21'	56	1*	47	N/A
4	24'	64	1*	60	N/A
5	15'	50	1*	42	30 + 2 HC
5	21'	70	1*	58	38 + 4 HC
5	27'	90	1*	74	54 + 4 HC
8	15'	80	1	66	54 + 2 HC
8	21'	112	1	91	68 + 4 HC
8	27'	144	1	116	96 + 4 HC
10	15'	100	1	82	70 + 2 HC
10	21'	140	1	113	88 + 4 HC
10	27'	180	1	144	124 + 4 HC
10	55' - 6"	N/A	2	316	284 + 5 HC
10	91' - 6"	N/A	3	529	497 + 6 HC
10	133' - 6"	N/A	4	782	740 + 8 HC
10	175' - 6"	N/A	5	1035	983 + 10 HC
15	61' - 6"	N/A	2	531	495 + 6 HC
15	91' - 6"	N/A	3	789	743 + 8 HC
15	121' - 6"	N/A	4	1047	989 + 10 HC
15	175' - 6"	N/A	5	1545	1,469 + 14 HC

**Many other lengths available**

\* Aisles not required with Low Rise Models

N/A = Not Available

# DIMENSIONS FOR BLEACHERS



Dimensions are approximate.

# ARCHITECTURAL SPECIFICATIONS

## SECTION 13125

### ANGLE FRAME BLEACHERS

#### PART 1 - GENERAL

##### 1.01 SECTION INCLUDES

- A. Design and fabrication of angle frame bleachers

##### 1.02 QUALITY ASSURANCE

- A. Manufacturer: National Recreation Systems, Inc.  
P.O. Box 11487 Fort Wayne, In 46858-1487
- B. Manufacturer Qualifications: Manufacturer must have a minimum of ten years experience in the design and manufacture of bleachers.
- C. Welders must conform to AWS standards.
- D. Source Quality Control: Mill Test Certification.
- E. Codes and Standards: 2003 International Building Code

##### 1.03 WARRANTY

- A. Warranty shall guarantee bleachers to be free from defect in materials and workmanship for a period of 1 year under normal use. Warranty period shall begin on date of completion for projects installed by manufacturer, or its subcontractors, OR warranty period shall begin on date of final delivery on projects installed by others.
- B. Anodized finish of plank extrusions shall be covered by a 5 year warranty against loss of structural strength or finish deterioration due to exposure to weather conditions or UV rays. Discoloration of mill finish aluminum due to galvanic reaction not covered.

##### 1.04 ENGINEERING

- A. Engineering certifications and calculations by a Registered Professional Engineer will be provided upon request, for a fee.

#### PART 2 – PRODUCTS

##### 2.01 ACCEPTABLE MANUFACTURER

- A. National Recreation Systems, Inc.

##### 2.02 DESIGN

- A. Applicable Codes:  
INTERNATIONAL BUILDING CODE (IBC), 2003 EDITION
  - B. Design Loads:
    - 1. Live Loads: Uniform loading - Structure = 100 psf  
Uniform loading - Seat and Foot plank = 120 plf
    - 2. Sway Loads: Perpendicular to seats = 10 plf  
Parallel to seats = 24 plf
    - 3. Guardrail Loads: Uniform vertical load = 100 plf  
Uniform horizontal load = 50 plf  
Concentrated horizontal load = 200 pounds
    - 4. \*Wind Loads: Basic design wind speed = 150 mph  
(exposure "B")
- \*Note: Bleacher must be anchored to meet wind loads above

##### 2.03 ANGLE FRAME BLEACHERS

- A. Quantity and Size: Shall consist of \_\_\_ unit(s)  
\_\_\_ rows high x \_\_\_' - \_\_\_" long.  
Net seating capacity per unit \_\_\_ + \_\_\_ HC  
(excluding aisles, based on 18" per seat).
- B. Framework: Prefabricated aluminum angle or galvanized steel angle at max. 6' spacing joined by means of aluminum angle cross bracing.
- C. Shop connections: Welded to meet AWS standards and local code requirements
- D. Joint Sleeve Assembly: Internal splices, where required shall be two per joint, and shall penetrate the joint a minimum of 8" in each direction and be riveted at one end only to allow for contraction and expansion.
- E. Rise and Depth Dimensions: 8" vertical rise and 24" tread depth, Seat height is 17" above its respective tread. (except low rise & 3 row models)

#### PART 2 – PRODUCTS (CONT)

- F. Seats: Nominal 2" x 10" anodized aluminum with anodized end caps.
- G. Treads: Nominal one (1) or optional two (2) 2" x 10" mill finish aluminum with anodized end caps.
- H. Risers: Nominal 2" x 10" mill finish aluminum with end caps on top row. Nominal 1" x 6" mill finish aluminum with end caps on all other rows.
- I. Aisles: Aisle footboards shall be of aluminum alloy 6063-T6 and be of mill finish with contrasting aisle markings. Three aisle stiffener angles shall be used to strengthen the aisle step. There shall be \_\_\_ aisle(s) \_\_\_" wide.
- J. Aisle Handrail: Anodized aluminum pipe with intermediate rail.
- K. Entry Stairs: \_\_\_ set(s) of entry stairs, \_\_\_" in height. Guardrail and handrails shall be provided as required.
- L. Front walkway: \_\_\_" in height and \_\_\_" in clear width, \_\_\_ 2 x 10 mill finish aluminum planks and 1 x 6 toeboard.
- M. Guardrail: Rails shall be anodized aluminum tube with end plugs and elbows where required. All Rails shall be secured to support with galvanized fasteners. Top rails at sides, rear and front shall be 42" above the leading edge of seat or walking surfaces. Rear rail support members shall be aluminum channel, side and front rail support shall be aluminum angle.
  - 1. Chainlink System: Fencing shall consist of 9 gauge, 2" mesh galvanized chainlink fabric, heavy duty tension bands, tension bars, brace bands, combo rail endcaps, and wire ties.
  - 2. Vertical Picket System: Aluminum pipe and bar anodized after fabrication & attached to supports with galvanized fasteners.
- N. Handicapped Accessibility(where applicable): Shall be provided as required by the code listed above.

##### 2.04 MATERIALS / FINISHES

- A. Framework:
  - 1. Aluminum: Structural fabrication with aluminum alloy 6061-T6 mill finish. Each frame shall be unit-welded, using metal inert gas method, under guidelines by the American Welding Society. Galvanized Steel: ASTM A36/A & A529/A after fabrication all steel is hot dipped galvanized to ASTM A123 specifications. All crossbracing and horizontal bracing shall be aluminum angle 6061-T6 mill finish.
- B. Extruded Aluminum:
  - 1. Seat planks: Aluminum alloy 6063-T6, clear anodized 204R1, AA-M10C22A31, Class II with a wall thickness nominally .078" for impact and deformation resistance.
  - 2. Tread and Riser Planks: Aluminum alloy 6063-T6, mill finish with a wall thickness nominally .078" for impact and deformation resistance.
  - 3. Guardrail Pipe: 1.66 OD schedule 40 aluminum alloy 6105-T5, clear anodized 204R1, AA-M10C22A31, Class II.
  - 4. Handrail Pipe: 1.89 OD schedule 40 aluminum alloy 6105-T1, clear anodized 204R1, AA-M10C22A31, Class II.
- C. Accessories:
  - 1. Channel End Caps: Aluminum alloy 6063-T6, clear anodized 204R1, AA-M10C22A31, Class II.
  - 2. Hardware: Bolts and Nuts shall be hot dipped galvanized.
  - 3. Hold Down Clip Assembly: Aluminum alloy 6063-T6 mill finish.
  - 4. Joint Sleeve Assembly: Aluminum alloy 6061-T6, mill finish.

#### PART 3 – EXECUTION

##### 3.01 INSTALLATION

- A. Install bleacher unit in accordance with manufacturer written instructions and shop drawings.

Note: Building codes may vary from site to site. The customer is responsible for verification of local code requirements.

## JOIN THE LIST OF OUR SATISFIED CUSTOMERS TODAY . . .

Universities  
Colleges  
Elementary Schools  
Middle Schools  
High Schools  
Parks  
Camps  
Fairgrounds  
Little Leagues  
Football Fields  
Baseball Stadiums

Soccer Fields  
Softball Complexes  
Ice Arenas  
Outdoor Theaters  
Race Tracks  
Sports Arenas  
Tractor Pulls  
Resorts  
YMCA's & YWCA's  
Correctional Institutions  
Fire Departments

Country Clubs  
Military Bases  
Churches  
Playgrounds  
Waterparks  
Swimming Pools  
Tennis Courts  
Golf Courses  
Bowling Alleys  
BMX Tracks  
Auctions

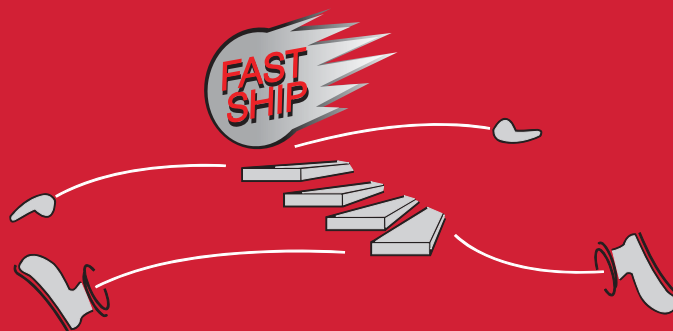
## . . . THESE NOTABLE INSTITUTIONS ALREADY HAVE!

Butler University  
Culver Military Academy  
Edwards Air Force Base  
Eli Lilly & Co.  
ESPN, Inc.  
Ft. Benjamin Harrison Army Base  
General Motors  
Great Lakes Naval Base  
Hoosier Horse Park  
Illinois State University  
Indiana University

Indianapolis Colts  
Ithaca College  
Lafayette College  
Los Alamos Nat'l Laboratory  
Louisiana State University  
Miami Dade Community College  
Minnesota Vikings  
N.F.L. Super Bowl XXVI  
Penn State University  
Purdue University

Randolph-Macon College  
Rose Hulman Institution of Tech.  
Tulane University  
Tuskegee University  
United States Post Office  
University of Chicago  
University of Findlay  
University of Maryland  
University of Notre Dame  
High Schools...  
Thousands Nationwide

Many items are now available  
with our "Fast Ship Service".  
Guaranteed to ship in 1-3  
business days or we pay  
the freight.



Manufactured By:



5120 Investment Drive  
Fort Wayne, IN 46808  
Phone: (260) 482-6023  
Toll Free: (888) 568-9064  
Fax: (260) 482-7449  
E-MAIL: [sales@bleachers.net](mailto:sales@bleachers.net)  
WEB SITE: [www.bleachers.net](http://www.bleachers.net)

Your Local Representative:

