

VERSA

BLEACHER

ASSEMBLY INSTRUCTIONS



PRINTED IN USA

P/N: LL-204-92

Assembly Instructions Include:

Rev: 0

Step 1: Site Preparation

Step 2: Jack Assembly

Step 3: Connecting the
Vertical Starters

Step 4: Connecting the
Verticals

Step 5: Adding the Vertical
Diagonals

Step 6: Adding the Beams

Step 7: Adding the Support
Frames and
Walkboards

Step 8: Adding Guardrails

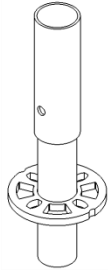
Step 9: Adding Seating

Step 10: Adding Handrails

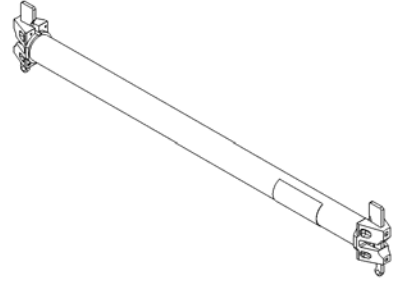
System Components



Leveling Jack



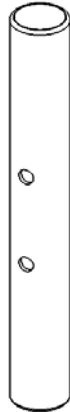
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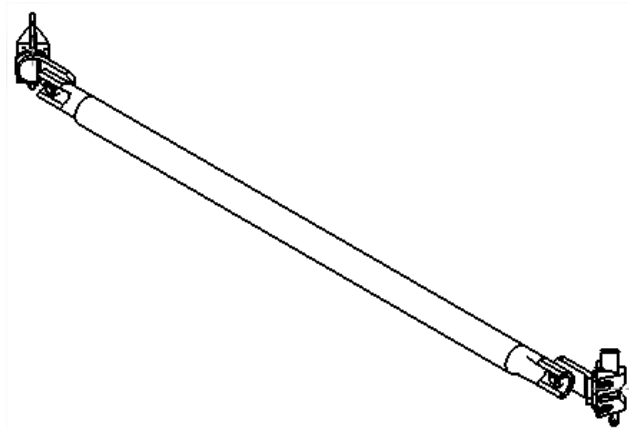
Horizontal



Verticals

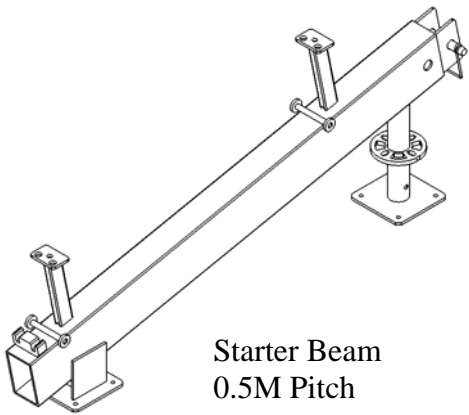


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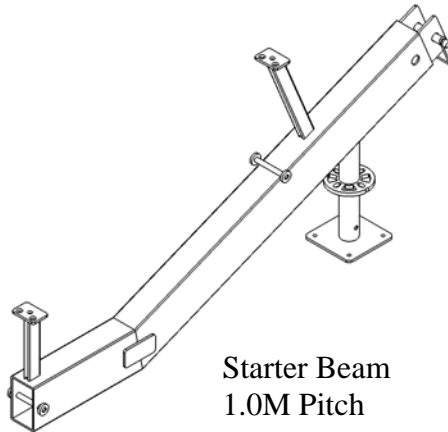


Vertical Diagonal

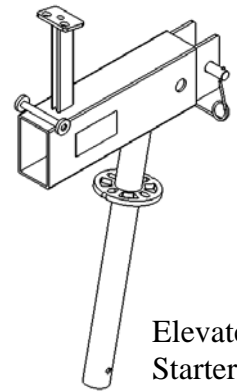
Bleacher Components



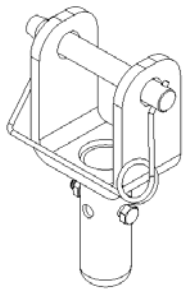
Starter Beam
0.5M Pitch



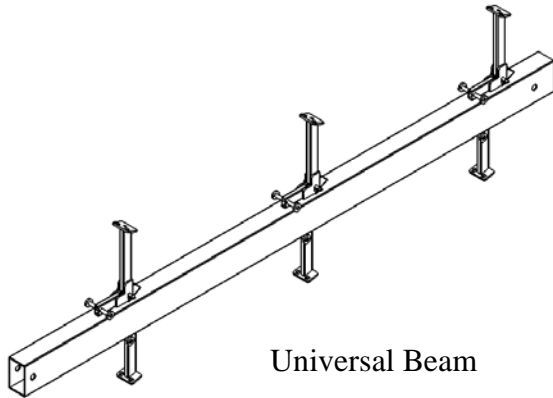
Starter Beam
1.0M Pitch



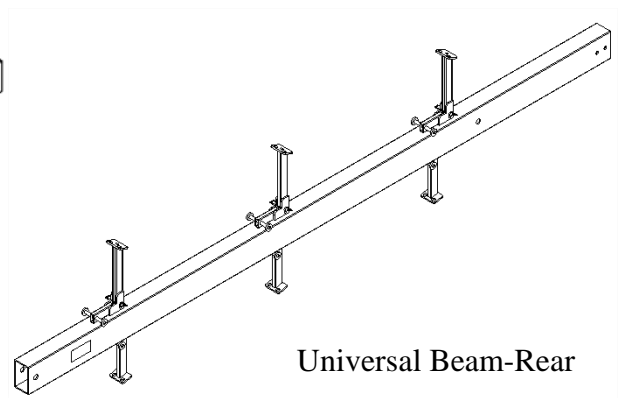
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Starter



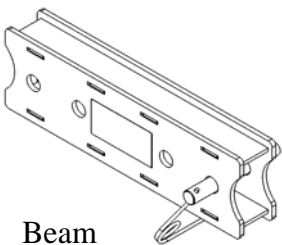
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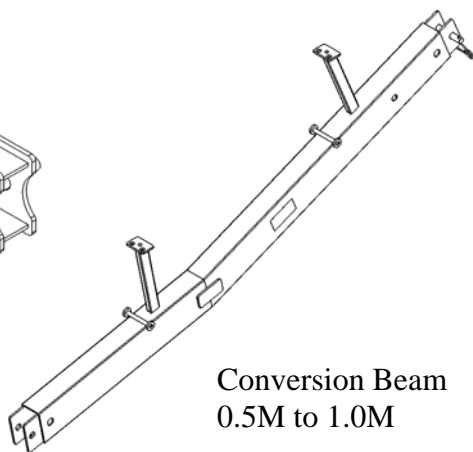
Universal Beam



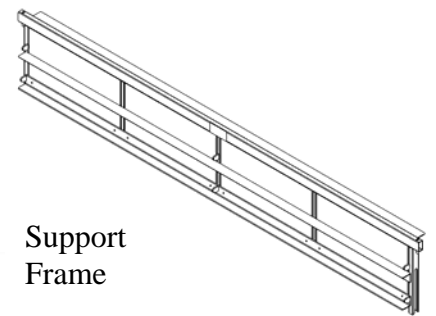
Universal Beam-Rear



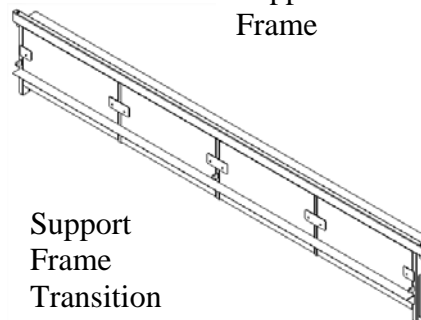
Beam
Insert



Conversion Beam
0.5M to 1.0M

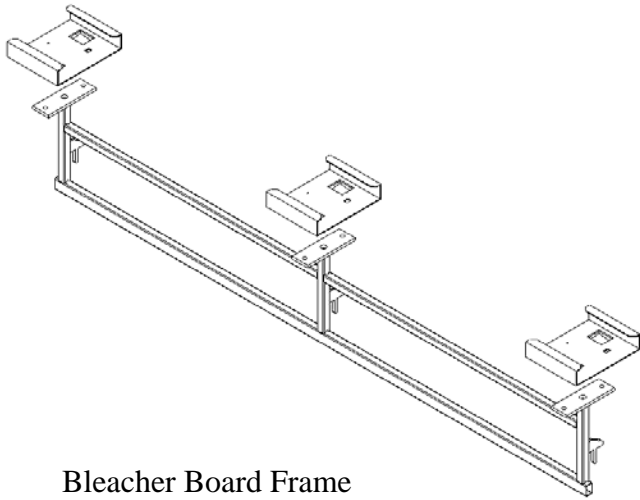


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Frame

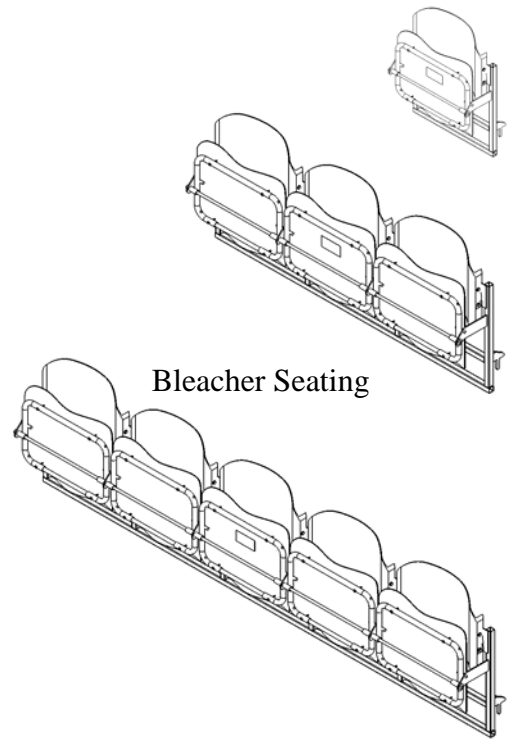


Support
Frame
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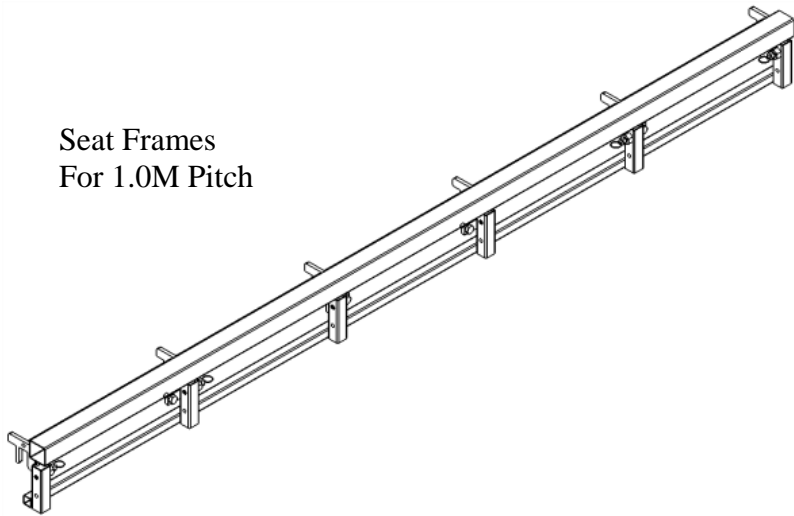
Bleacher Components



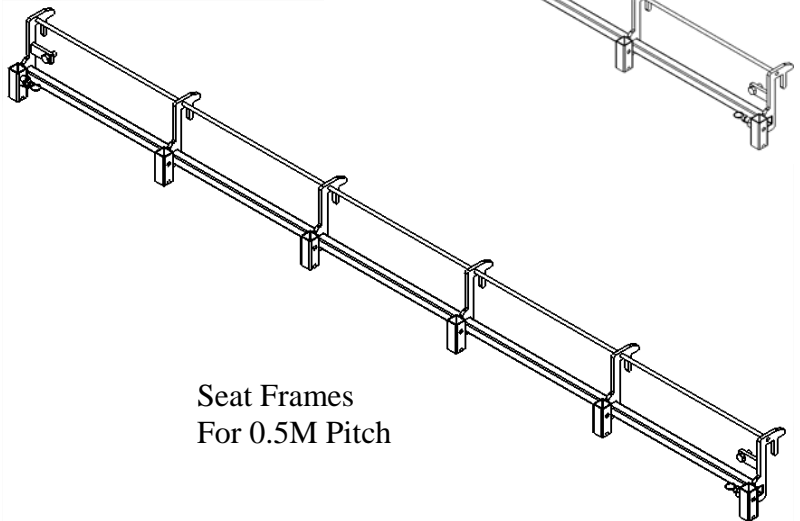
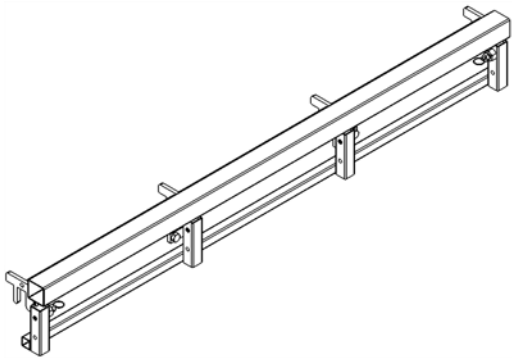
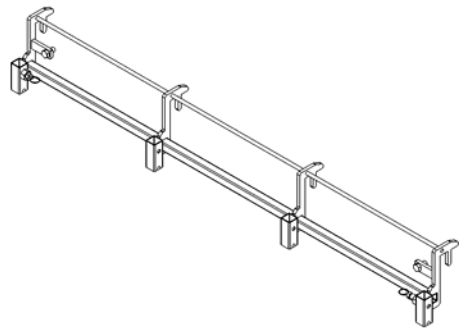
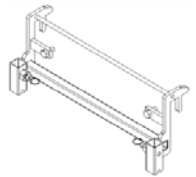
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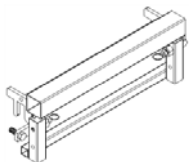
Bleacher Seating



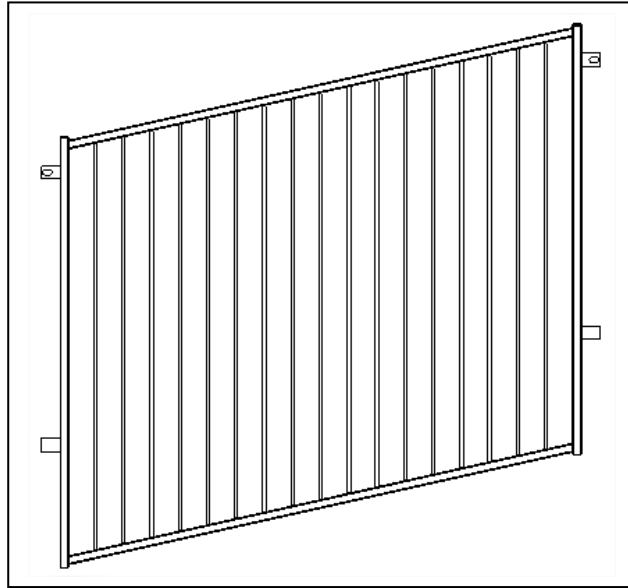
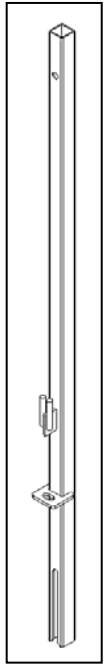
Seat Frames
For 1.0M Pitch



Seat Frames
For 0.5M Pitch



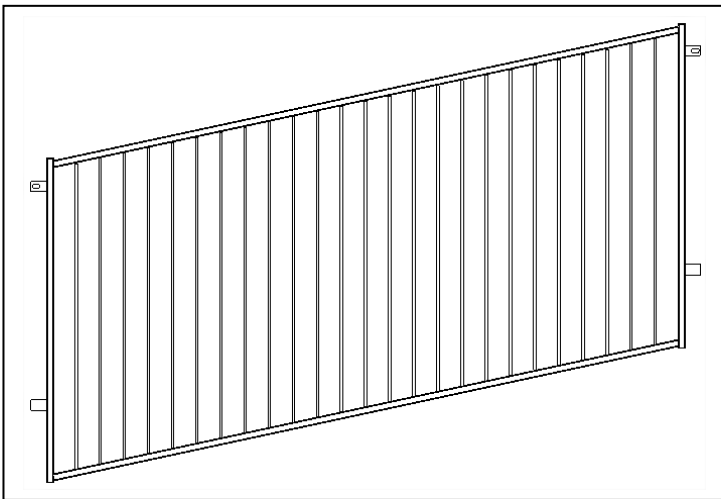
Bleacher Components



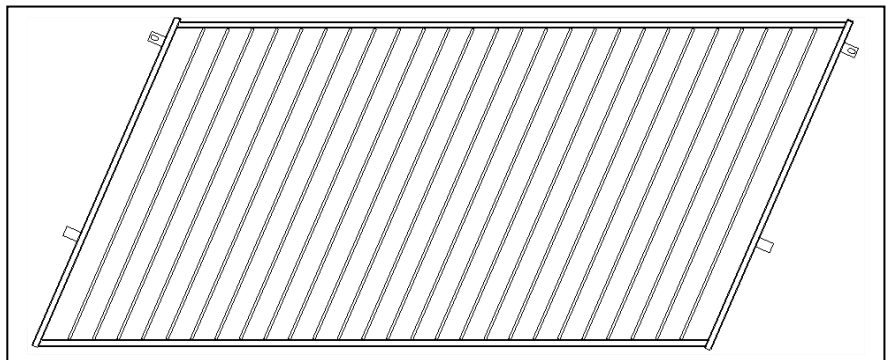
Side Front Guard Rail-0.5M Pitch

Side Guard Rail Post

Side Front Guard Rail-1.0M Pitch

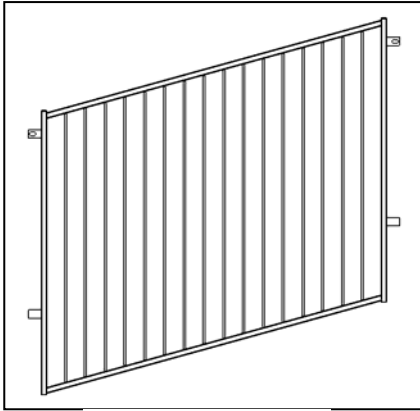


Side Guard Rail for 8ft Bay-0.5M Pitch

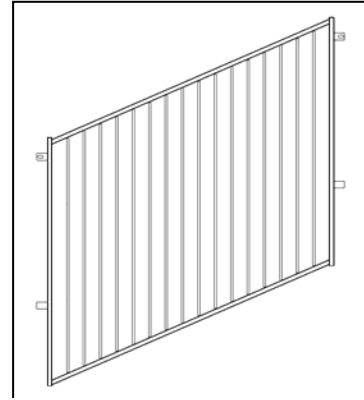


Side Guard Rail for 8ft Bay-1.0M Pitch

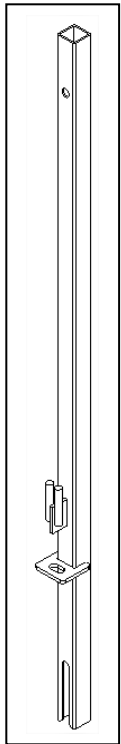
Bleacher Components



Side Guard Rail
For 5ft-4in Bay

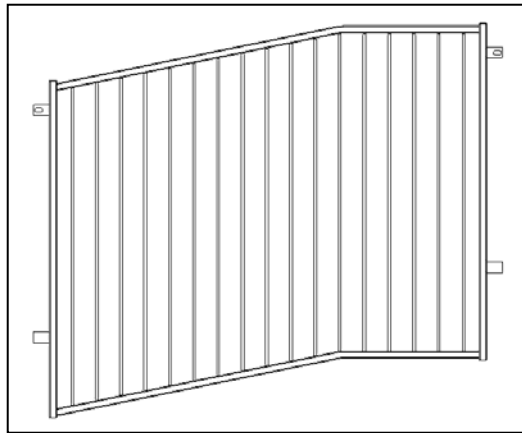


Side Guard Rail
Transition-0.5M to 1.0M Pitch

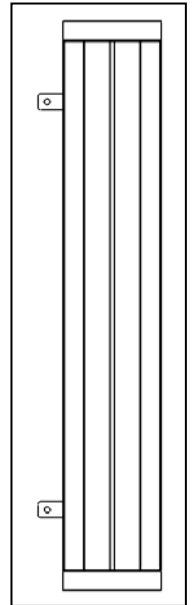


Rear Side Guard Rail Post

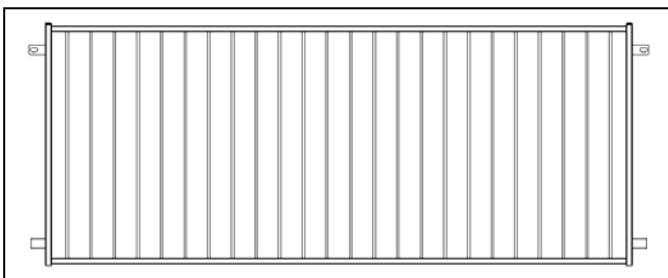
Side Rear Side Guard
Rail-1.0M Pitch



Side Rear Side Guard
Rail-0.5M Pitch



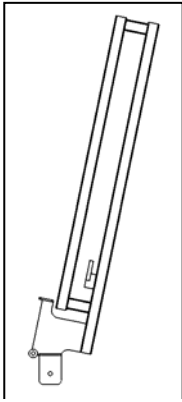
Guard Rail Filler



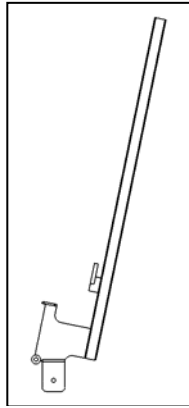
Rear Guard Rail-0.5M Pitch

Rear Guard Rail-1.0M Pitch

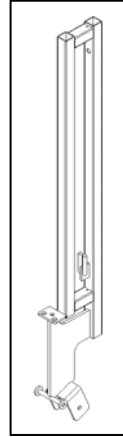
Bleacher Components



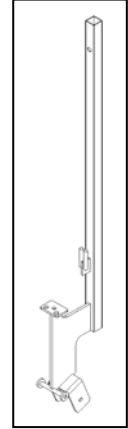
Rear Guard Rail
Corner Post
0.5M Pitch



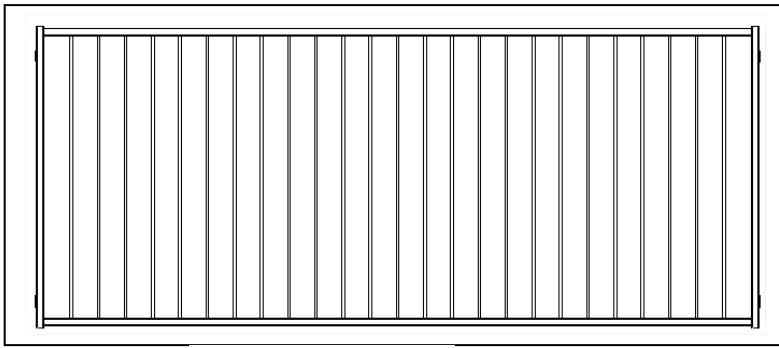
Rear Guard Rail
Center Post
0.5M Pitch



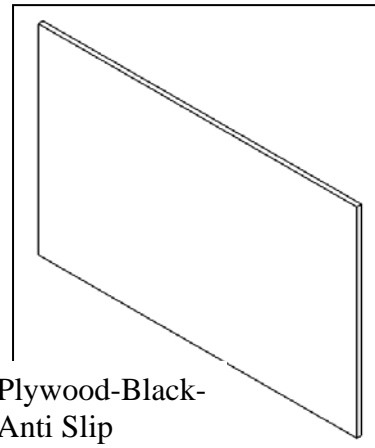
Rear Guard Rail
Corner Post
1.0M Pitch



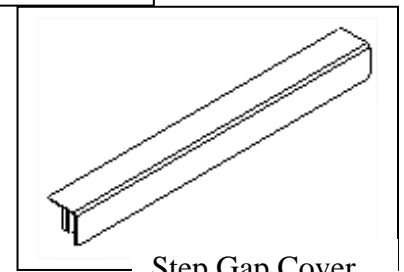
Rear Guard Rail
Center Post
1.0M Pitch



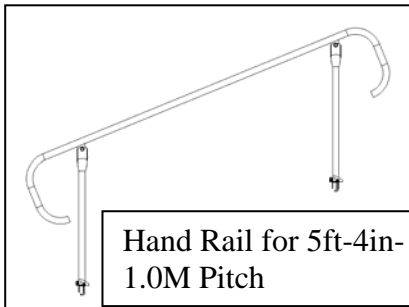
Front Guard Rail



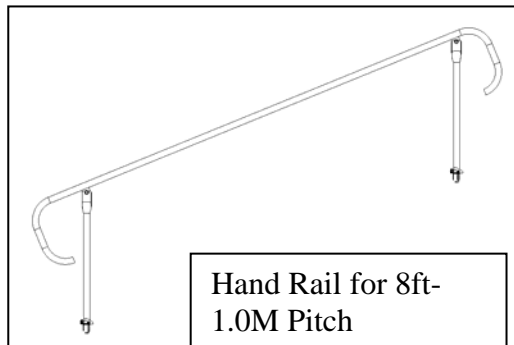
Plywood-Black-
Anti Slip



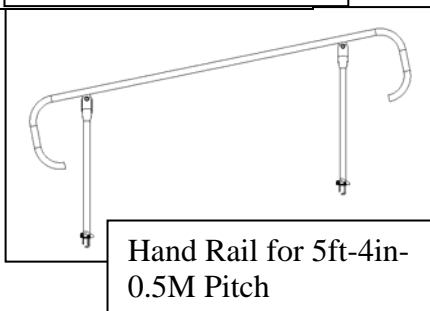
Step Gap Cover



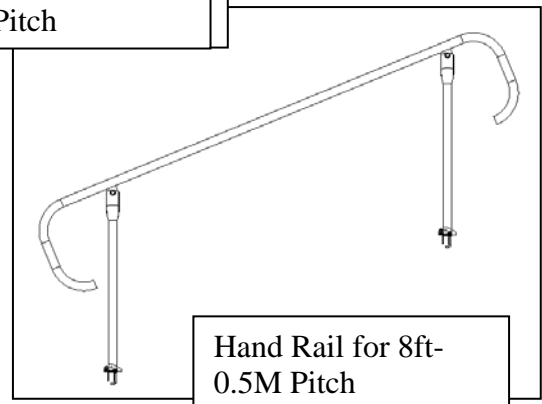
Hand Rail for 5ft-4in-
1.0M Pitch



Hand Rail for 8ft-
1.0M Pitch



Hand Rail for 5ft-4in-
0.5M Pitch



Hand Rail for 8ft-
0.5M Pitch

NOTE: The VERSA Bleacher has three pitch configurations:

1. **0.5M Pitch**

2. **1.0M Pitch**

3. **Combination 0.5M Pitch to 1.0M Pitch**

Step 1 Site Preparation

- A. Determine the exact location where the bleacher will be erected.

- B. Preplanning of the bleacher installation is very important. The bleacher footprint will require footers set on a 8ft x 8ft grid pattern. A row of 8ft x 5ft-4in will be used for a combination pitch set-up (See Fig. 1.1).

- C. For installation, the footers are required to distribute the weight of the structure. This will prevent the legs from sinking and ease the leveling.

- D. All footers should provide a level surface.

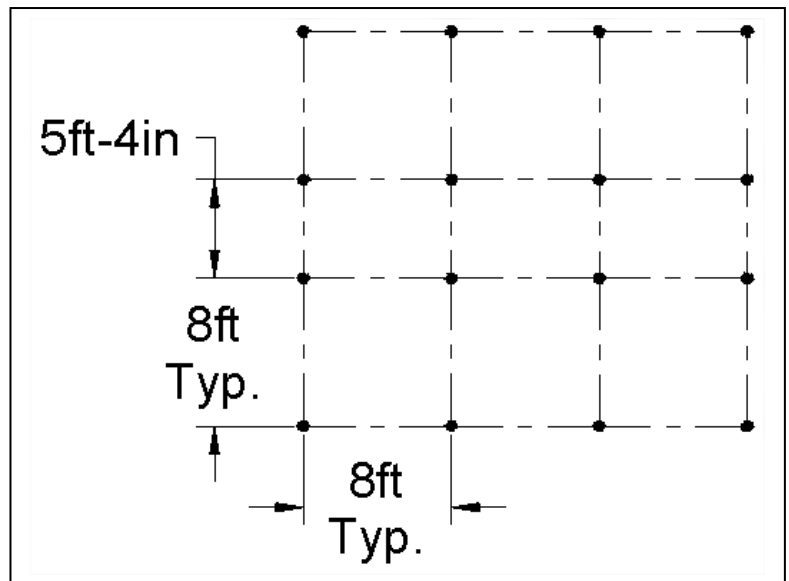
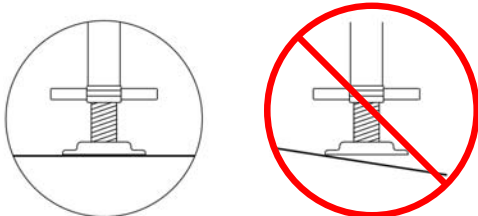


Fig. 1.1

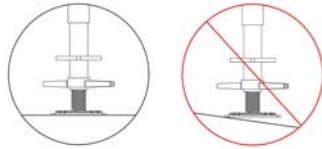


NOTE: It is recommended for permanent installations to use a level concrete surface as footers.

Step 2 Jack Assembly

A. Place the Jacks in the corners of every bay in respect to the assembly option being used.

- All Jacks should be placed only on horizontal and level surfaces.



- Additional footing support may be required to distribute the weight under each Jack, preventing the legs from sinking and providing a level area. A local “*qualified person*” should determine the exact type of support needed (*i.e. A person who, by possession of a recognizable degree or certificate of professional standing, or who by extensive knowledge, training, and experience, has successfully demonstrated the ability to solve problems related to the subject matter and work*). Always comply with local ordinances.

B. Set the Jack screws to an equal height by turning to raise or lower the Jack, if the assembly area is on uneven ground.

Fig. 2.1

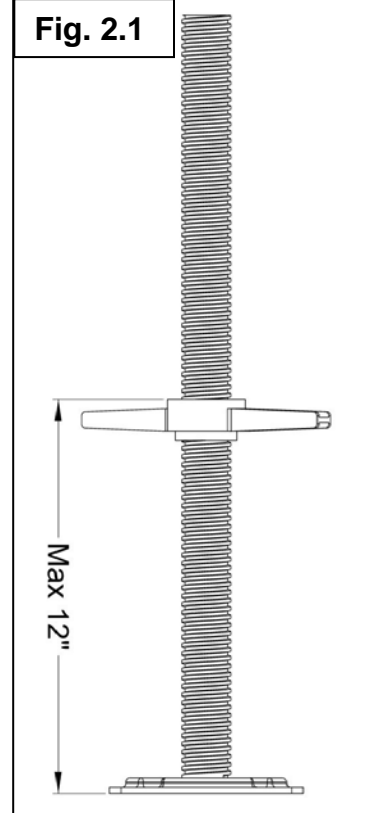
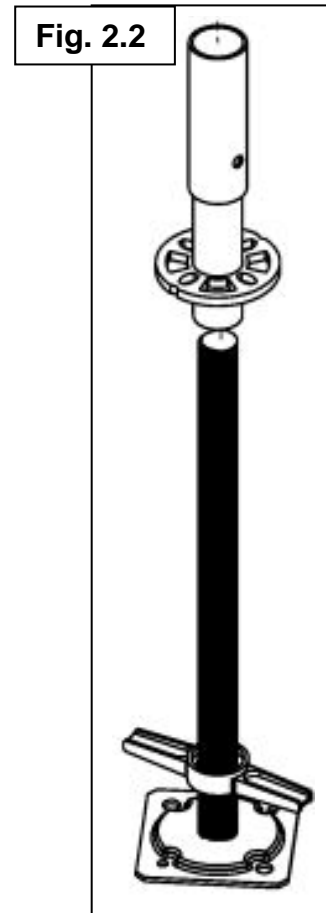


Fig. 2.2



Warning

The Jack should never exceed 12 inches.
See Figure 2.1.

C. Place the Vertical Starter over each Jack.
See Figure 2.2 for detail.

Step 3 Connecting the Vertical Starters

A. Determine the pitch of the bleacher (0.5M or 1.0M) to be erected and begin with that starter. Slide the end of the Horizontal into place over the narrow opening of the ring (see Fig. 3.1) of the Vertical Starter. Flip up the wedge and hammer firmly into place (see Fig. 3.2).

B. Begin connecting the Horizontals in one corner of the structure, creating a four-sided bay. Then expand on this bay along the side, then along the length until the entire structure is connected (see Fig. 3.3).

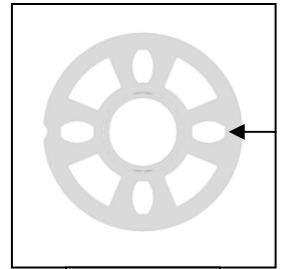


Fig. 3.1

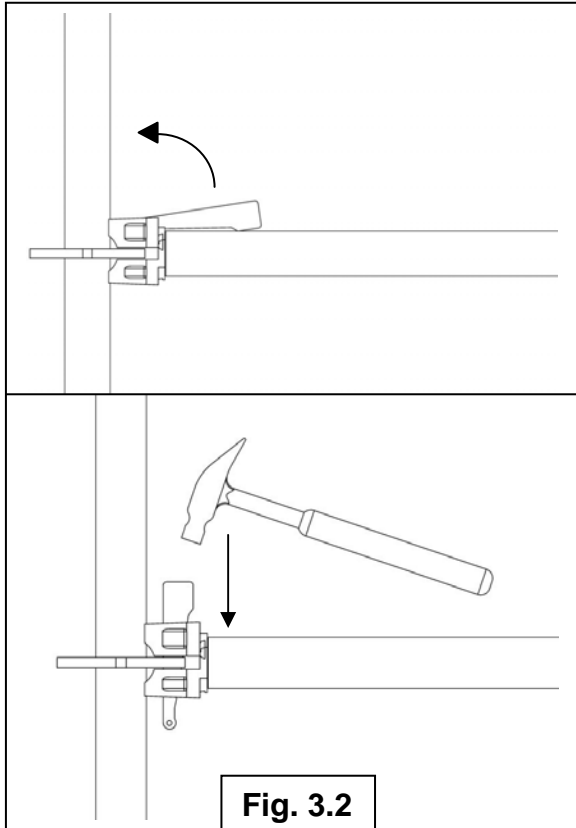


Fig. 3.2

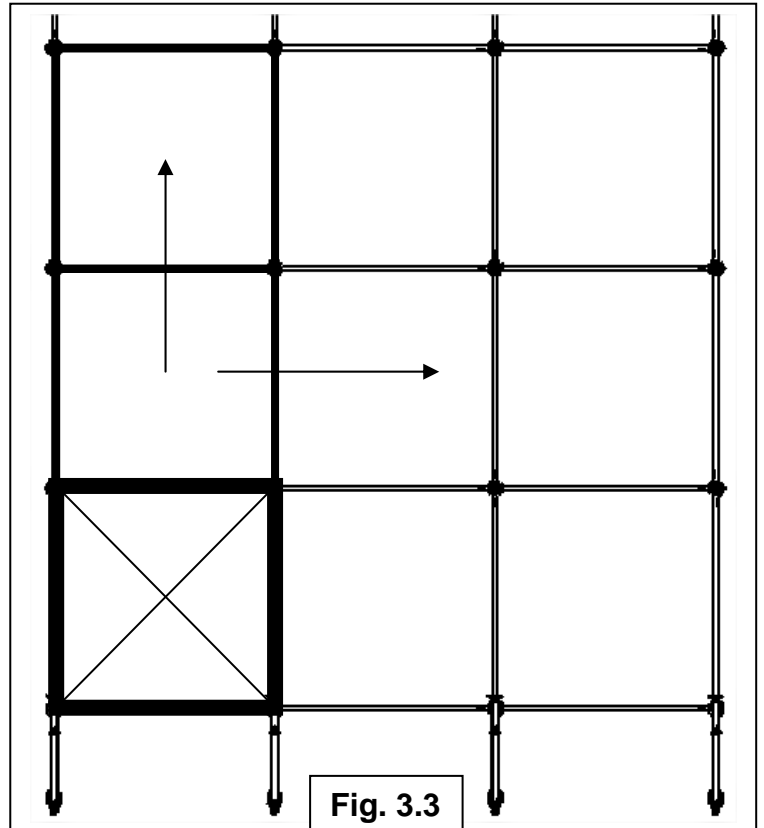


Fig. 3.3

C. When completing each bay, be sure the following conditions have been met:

- All corners are at 90° angles. Measure the distances diagonally between the corners of each bay to confirm. The two measurements should be equal.
- All Horizontals are level. Adjust the Jacks if necessary (see Fig. 3.4).

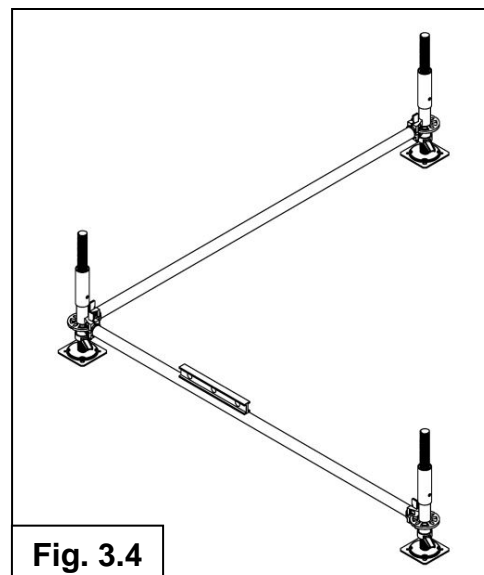


Fig. 3.4

Step 4 Connecting the Verticals

- A. Depending on the pitch of bleacher being erected, insert a 0.5M or 1.0M Vertical into each Vertical Starter in the first row. Each subsequent row Vertical will increase in length equal to the pitch. (Fig. 4.1)

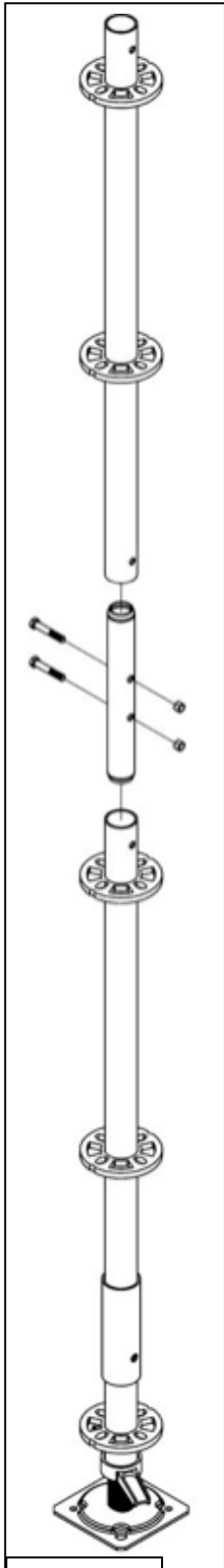
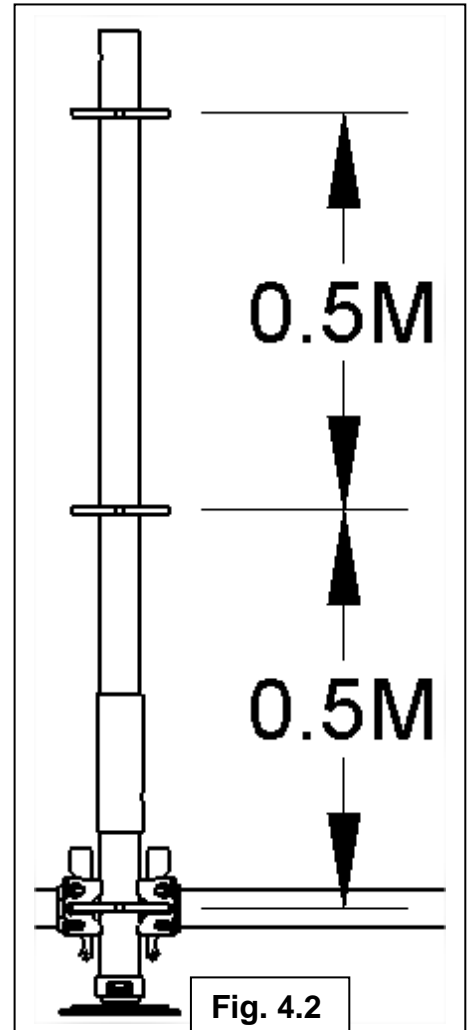
NOTE: The rings on the Verticals are spaced $\frac{1}{2}$ meter apart above the bottom ring (see Fig. 4.2). Horizontals must be connected to the bottom and top ring, as well as at least every 1-meter interval in between.

B. Slide the end of the Horizontal into place over the narrow opening of the ring of the Vertical Starter. Flip up the wedge and hammer firmly into place. (Reference Fig. 3.1 and Fig. 3.2).

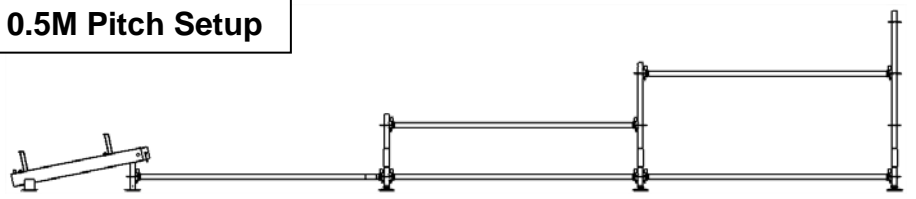
C. If increased height is desired place an Insert into the existing Vertical, and add an additional Vertical over the insert (see Fig. 4.3).

- Secure in place with a nut and bolt or spring rivet through the designated holes.
- Horizontals will need to be added at least every 1-meter interval.

D. Again, be sure that the structure is level and all corners are at 90° angles in the same way as in Step 3-C.



0.5M Pitch Setup



1.0M Pitch Setup

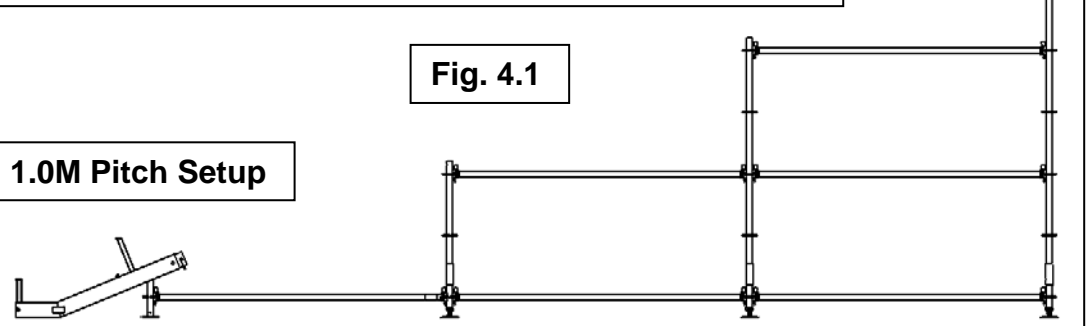


Fig. 4.3

Fig. 4.1

Step 5 Adding the Vertical Diagonals

A. On the rear corner Vertical, slide the top end of the Vertical Diagonal into place over the wide opening of the top ring (see Fig. 5.1). Attach the other end of the Vertical Diagonal to the bottom ring of the adjacent Vertical. Flip up the wedges and hammer firmly into place. If bleacher is taller than 2.0M, more Vertical Diagonals will be required (see Fig. 5.2).

B. Repeat the Vertical Diagonals on every other bay along the outside and inside of the structure (see Fig. 5.3). Dark lines represent Vertical Diagonal placement.

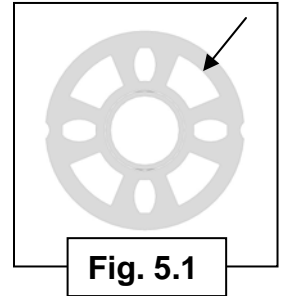


Fig. 5.1

NOTE:

All four sides of the rear corner bays must be braced with Vertical Diagonals.
All four sides of the front corner bays must be braced with Vertical Diagonals if bleacher is elevated.

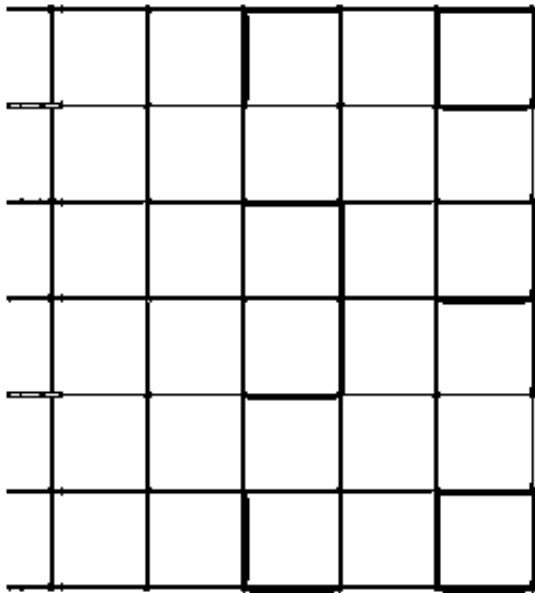


Fig. 5.3
Top View

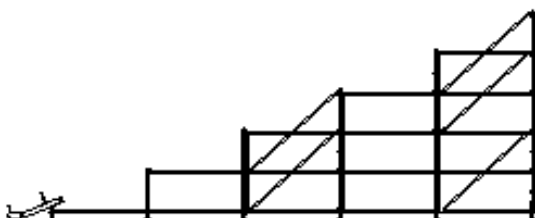
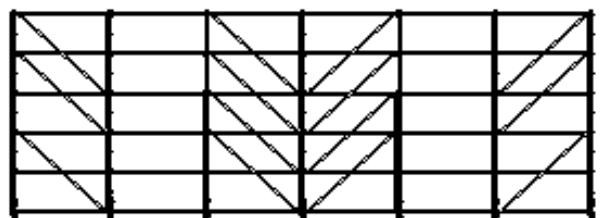
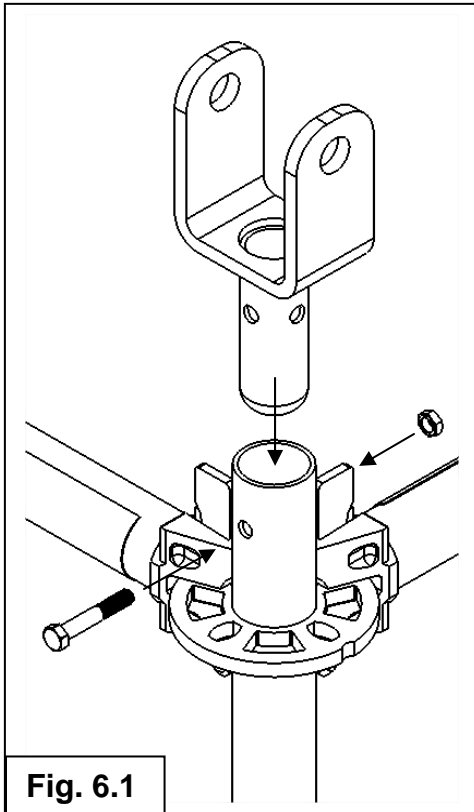


Fig. 5.2



Step 6 Adding the Beams

- A. Insert the Saddle into the top of each Vertical so that they are in line with the Starter Beam. Secure in place with bolt and nut (see Fig. 6.1).



- B. Slide the Universal Beam onto the tabs of the Starter Beam. Pin to Starter Beam and pin to Saddle.

- For 0.5M – The welded seat frame brackets are facing up and the pinned on seat frame brackets are removed for clearance (see Fig. 6.2).
- For 1.0M – The pinned on seat frame brackets are facing up and the welded seat frame brackets are facing down (see Fig. 6.3).

Fig. 6.2
0.5M Pitch

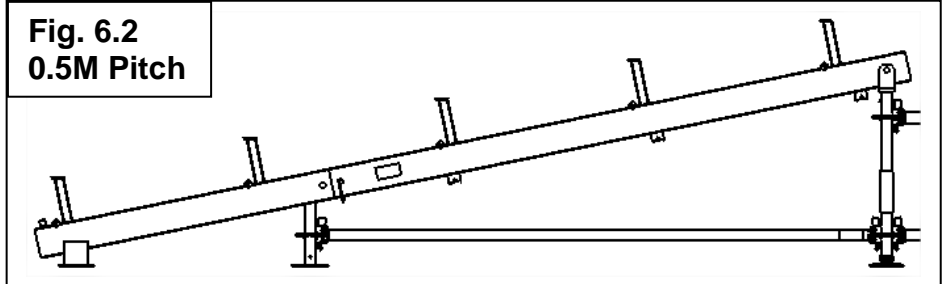
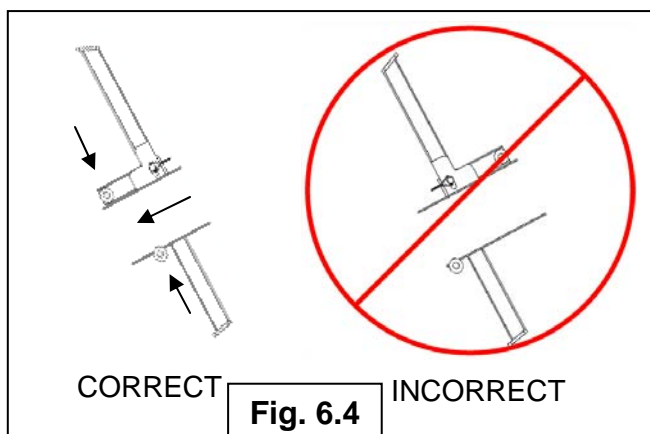
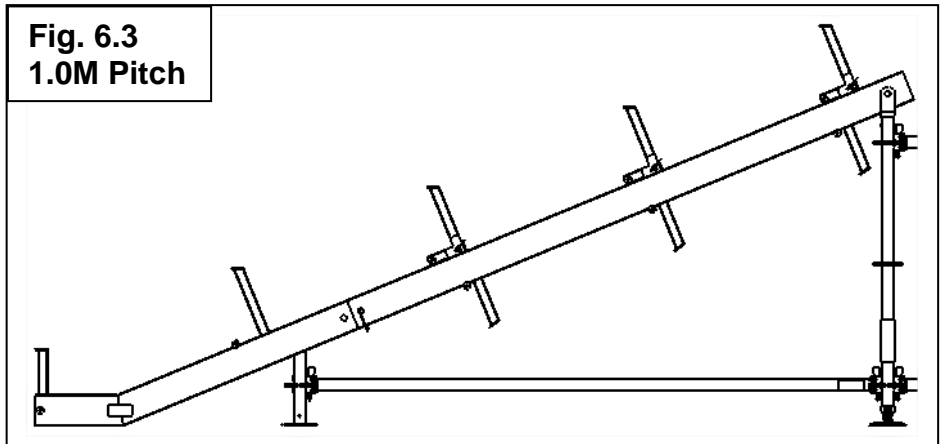


Fig. 6.3
1.0M Pitch



- C. Make sure the seat frame brackets are attached properly for the 1.0M pitch bleacher. Pin bracket with washer in same direction as welded washer (see Fig. 6.4). Make sure bracket is flush with beam tube.

D. Continue adding beams by inserting a Beam Insert into the end of the Universal Beam and pin into place.

- For 0.5M – Pin the third hole inserted into the beam (see Fig. 6.5).
- For 1.0M – Pin the second hole inserted into the beam (see Fig. 6.6).

Fig. 6.5
0.5M Pitch

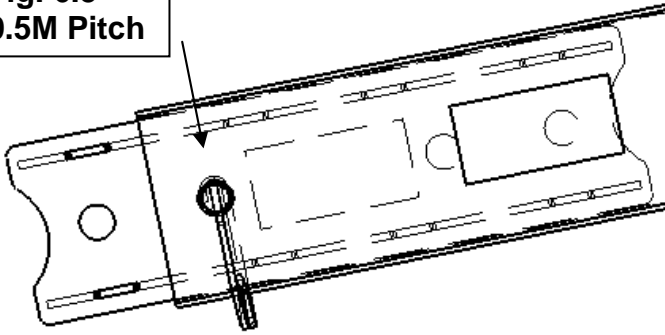
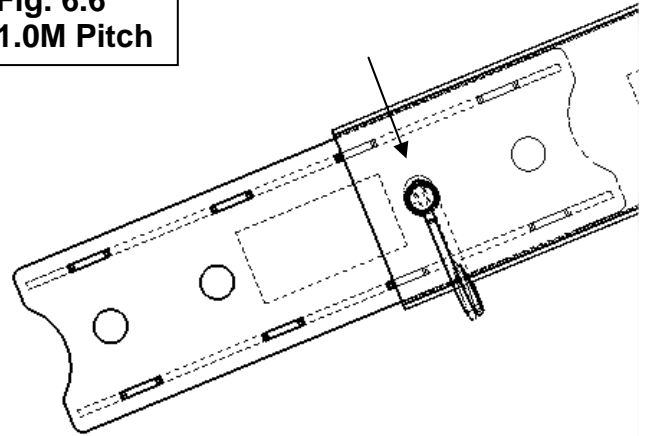


Fig. 6.6
1.0M Pitch



E. Insert Universal Beam with installed Beam Insert into the end of the previous beam. Pin opposite end in Saddle. See Figures 6.7 and 6.8.

NOTE: The Beam Insert will not fully go into the previous beam for the 1.0M pitch (see Enlarged View).

Use the Rear Universal Beam for the last one.

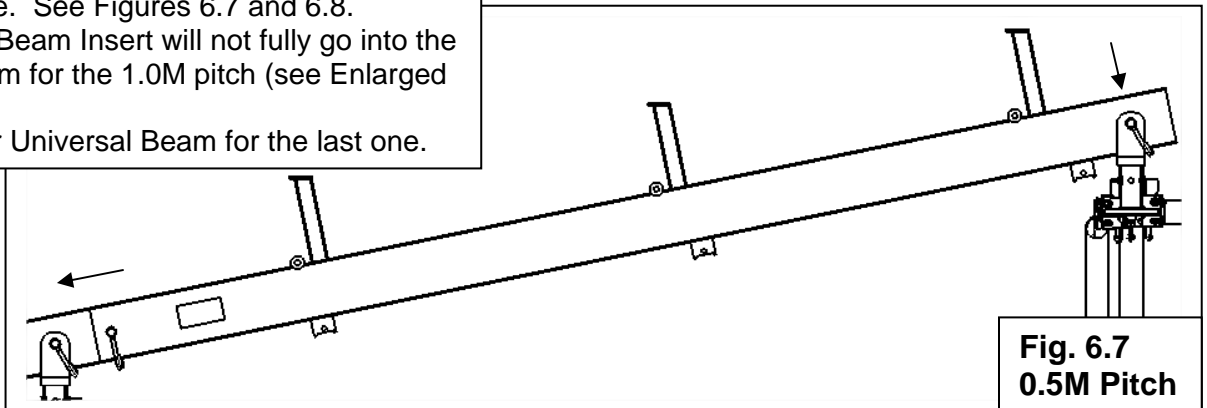


Fig. 6.7
0.5M Pitch

Enlarged View

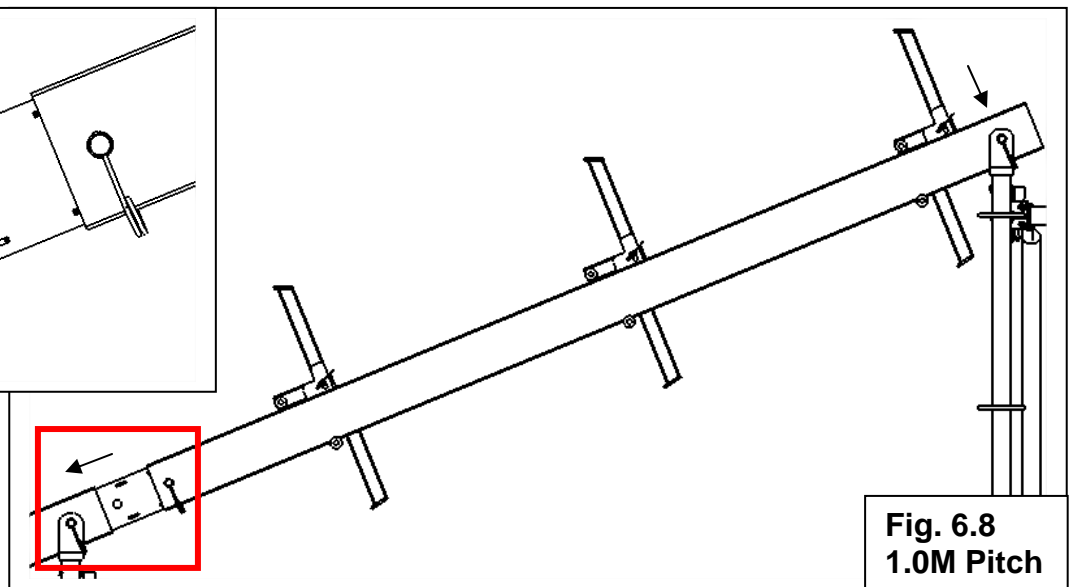
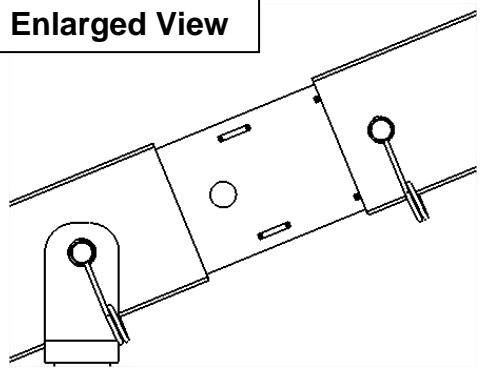
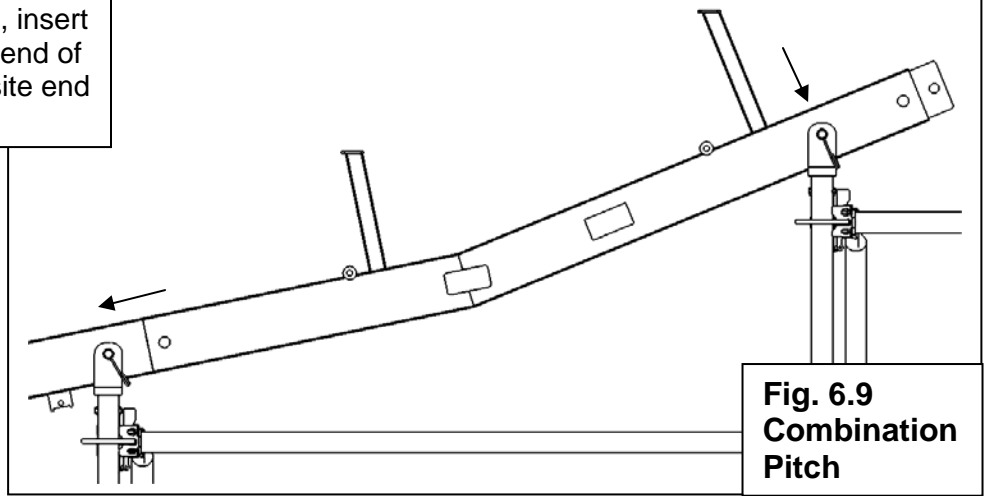


Fig. 6.8
1.0M Pitch

F. For a combination pitch set-up, insert the Conversion Beam into the end of the previous beam. Pin opposite end in Saddle (see Fig. 6.9).

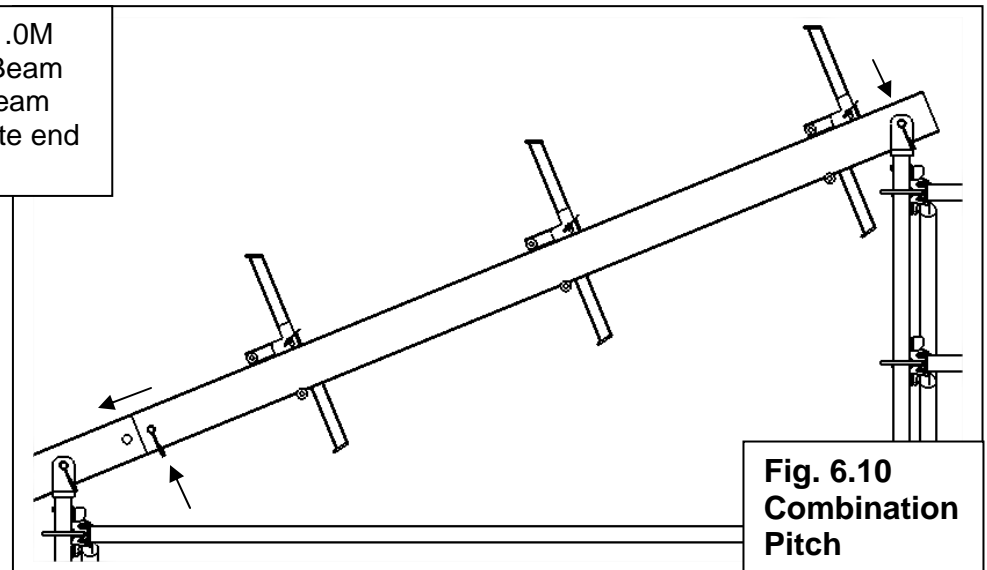
NOTE:

A Conversion Beam can only be used in a bay that is 5ft-4in.



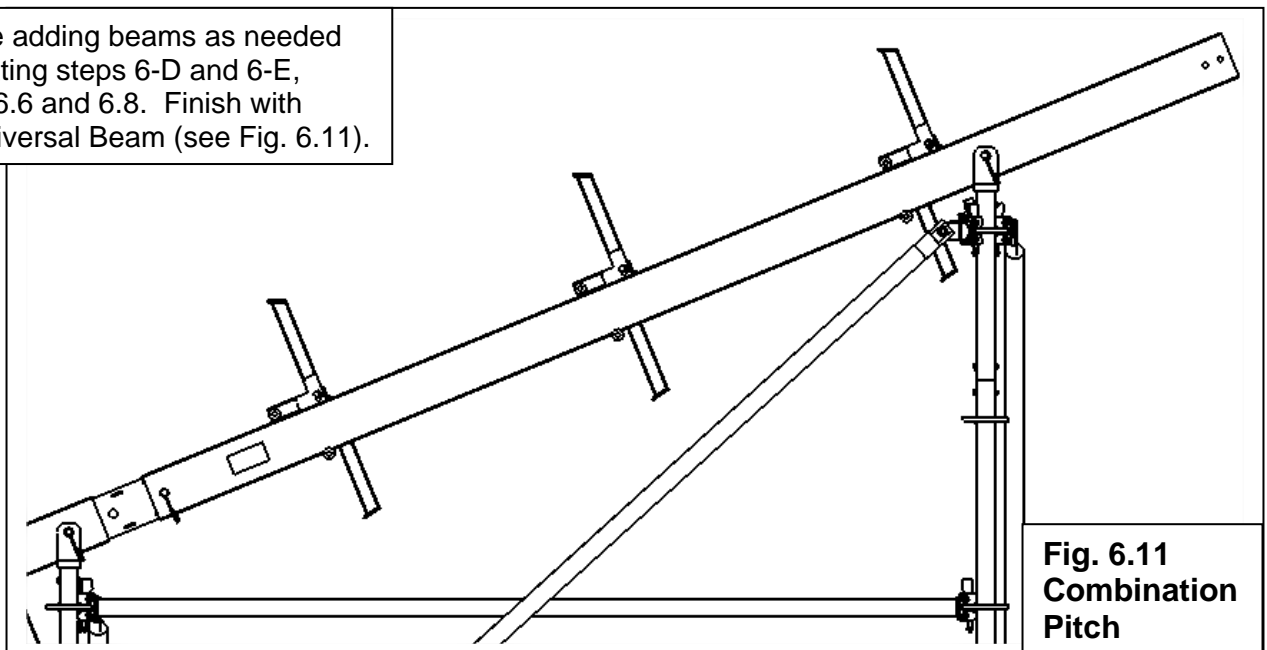
**Fig. 6.9
Combination
Pitch**

G. Continue adding beams as a 1.0M pitch set-up. Slide Universal Beam over tabs of the Conversion Beam and pin into place. Pin opposite end in Saddle (see Fig. 6.10).



**Fig. 6.10
Combination
Pitch**

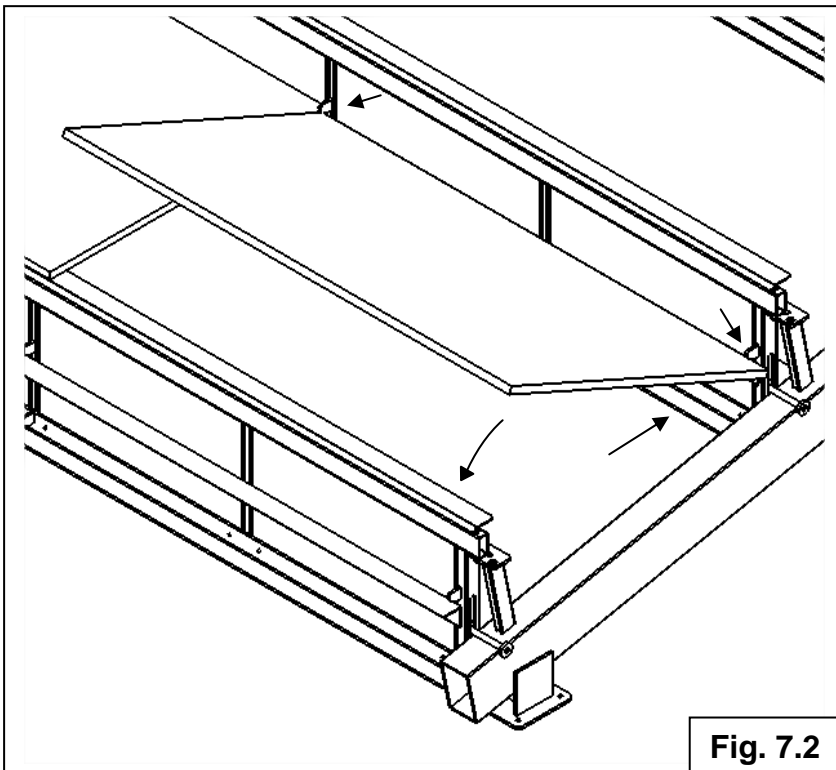
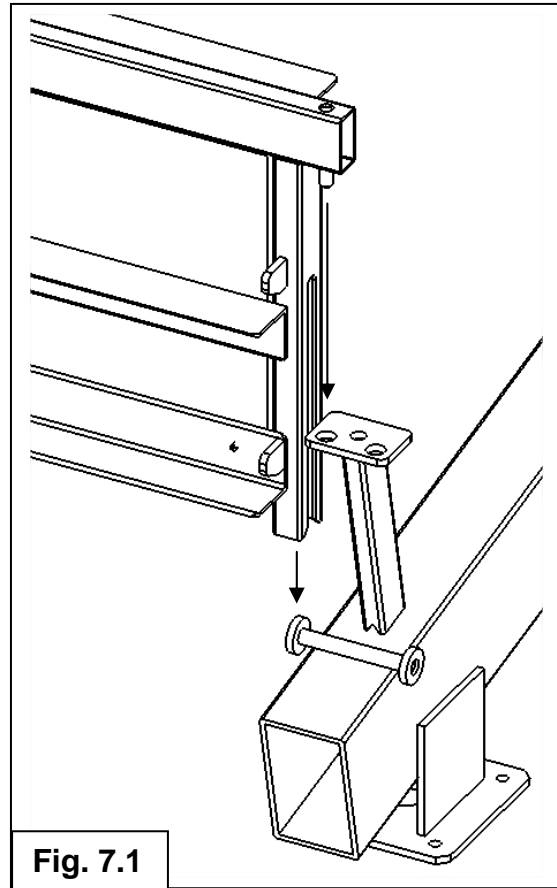
H. Continue adding beams as needed by repeating steps 6-D and 6-E, Figures 6.6 and 6.8. Finish with Rear Universal Beam (see Fig. 6.11).



**Fig. 6.11
Combination
Pitch**

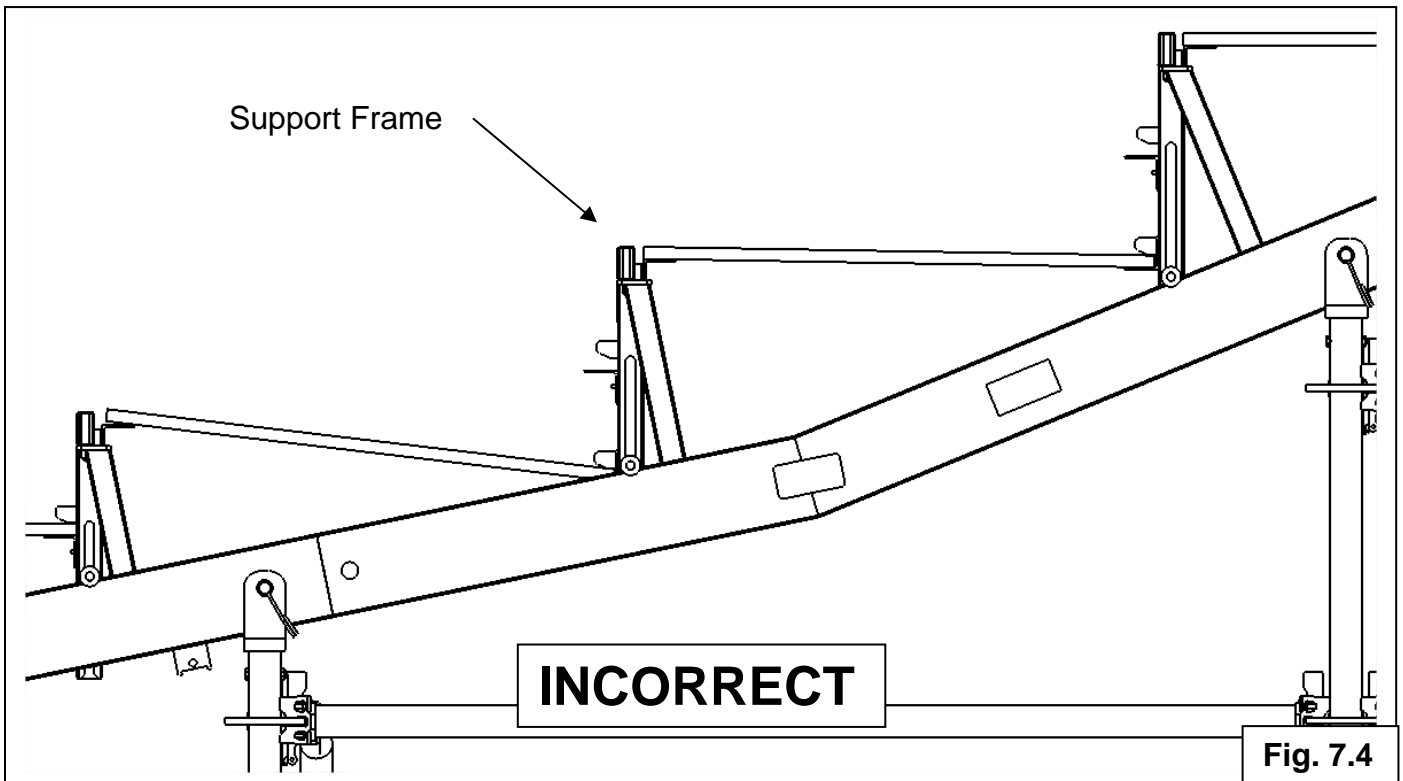
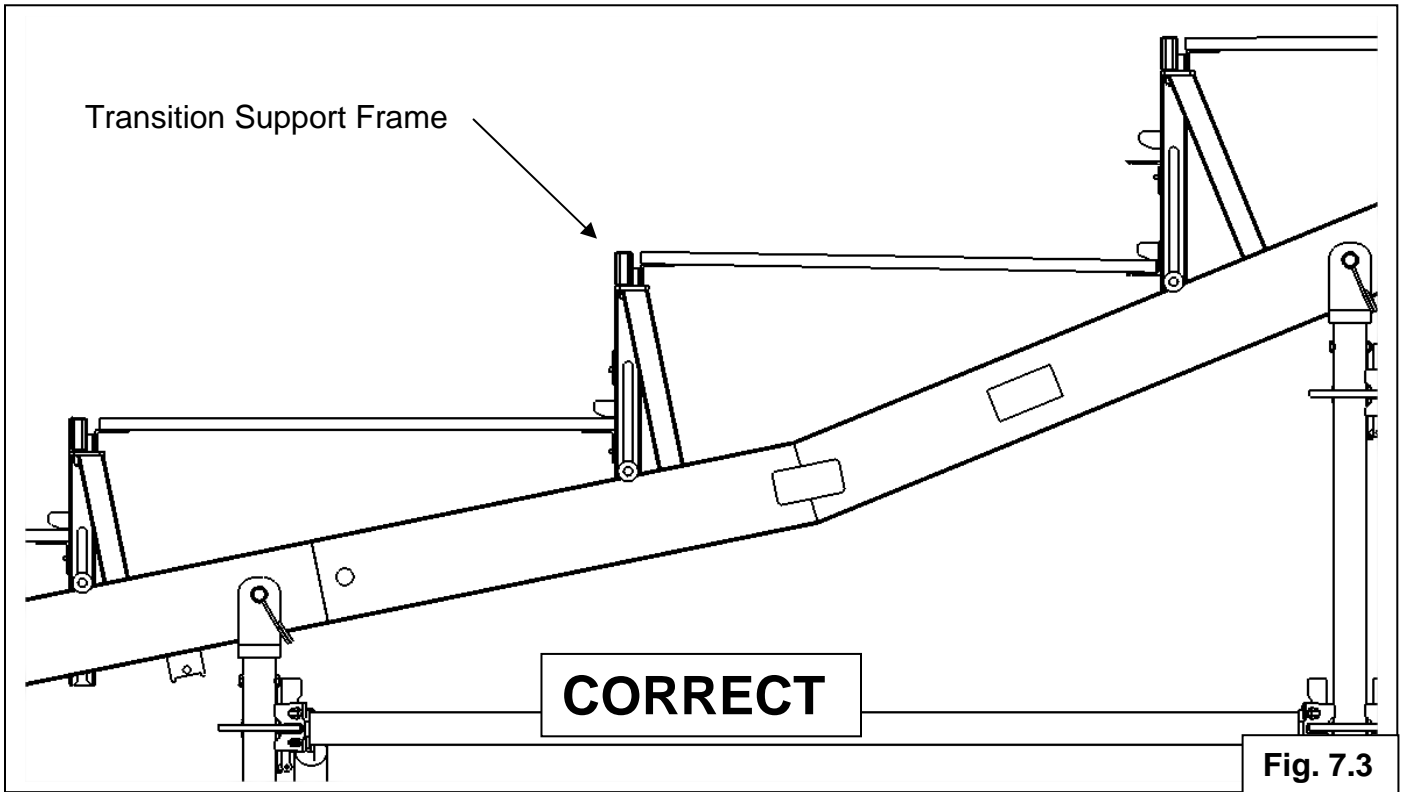
Step 7 Adding the Support Frames and Walkboards

- A. Add a Support Frame by placing the side frame tubes with the slot over the washer of the seat frame pin on the Beams. Slide the Support Frame down locating the pins in the holes of the seat frame brackets on the Beams. See Figure 7.1.



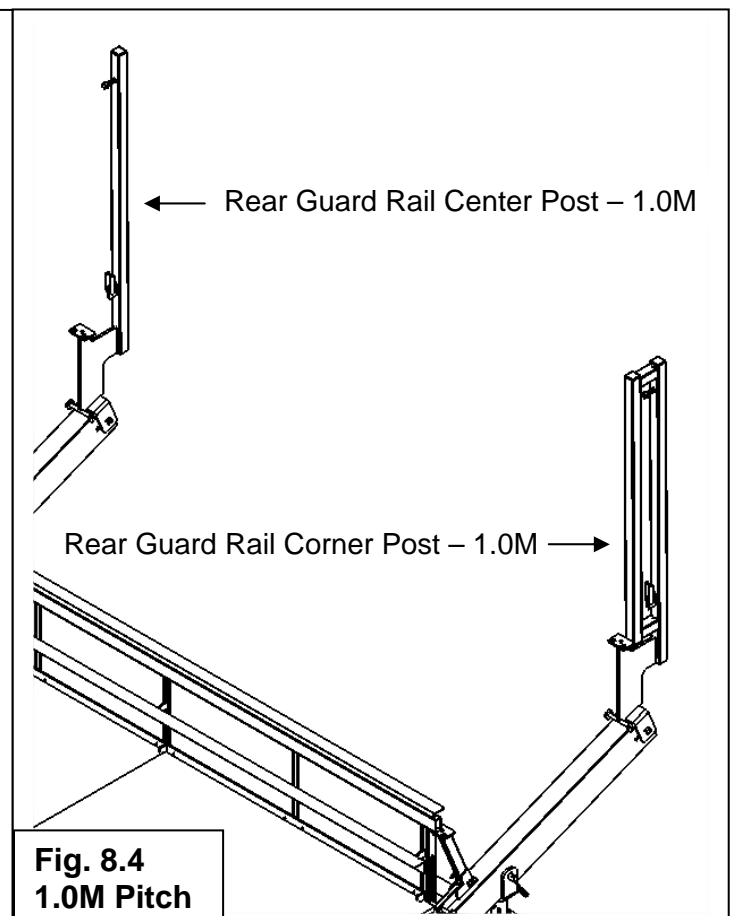
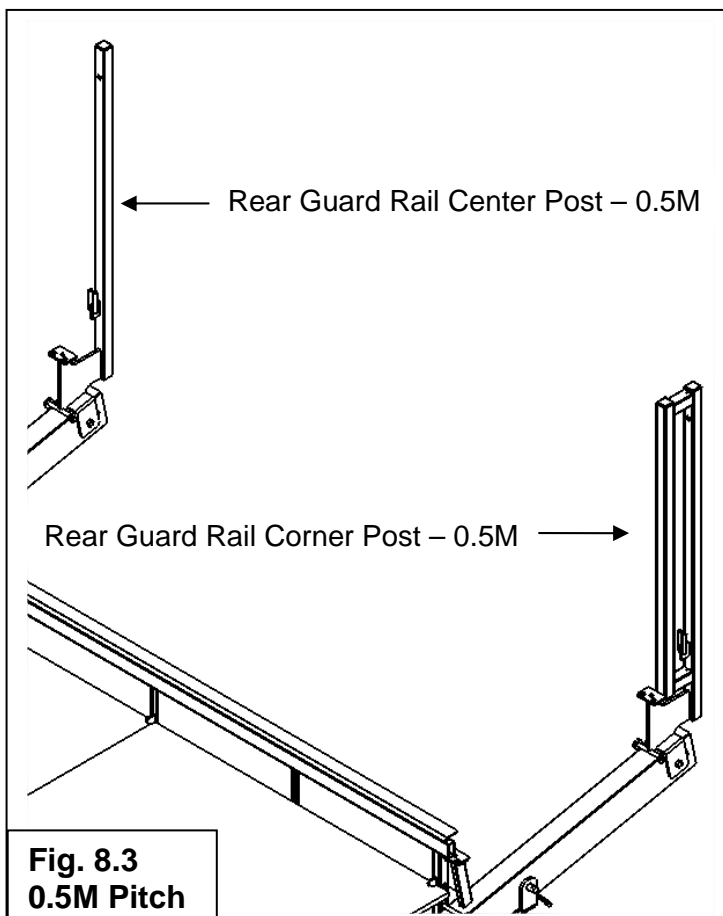
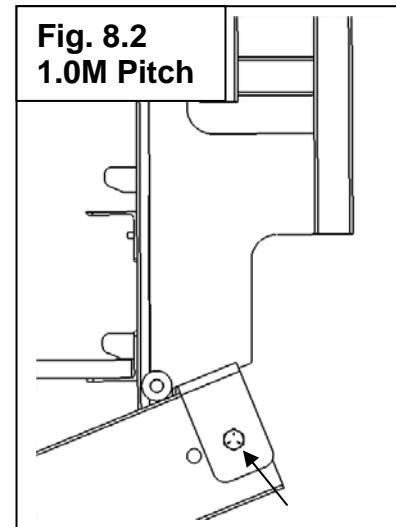
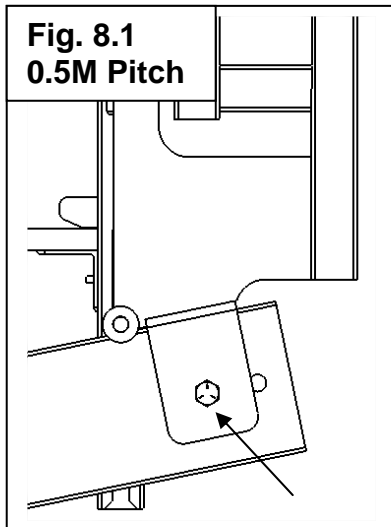
- B. Add a Support Frame to the next row. Add two plywood walkboards per frame by setting the board on the angle and sliding under the tabs (see Fig. 7.2).

C. If a combination pitch bleacher is being set up, a Transition Support Frame must be used on the first support frame bracket of the Conversion Beam. See Figures 7.3 and 7.4.

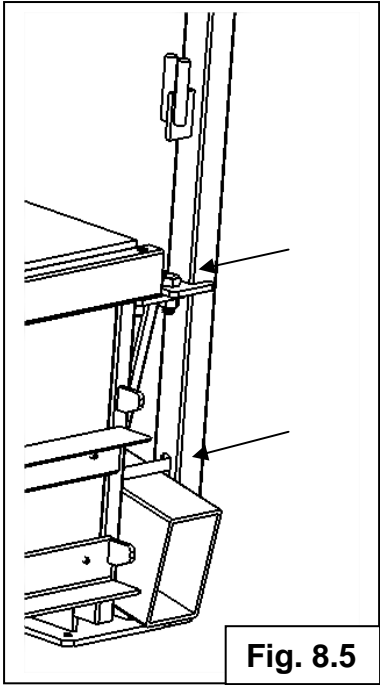


Step 8 Adding Guardrails

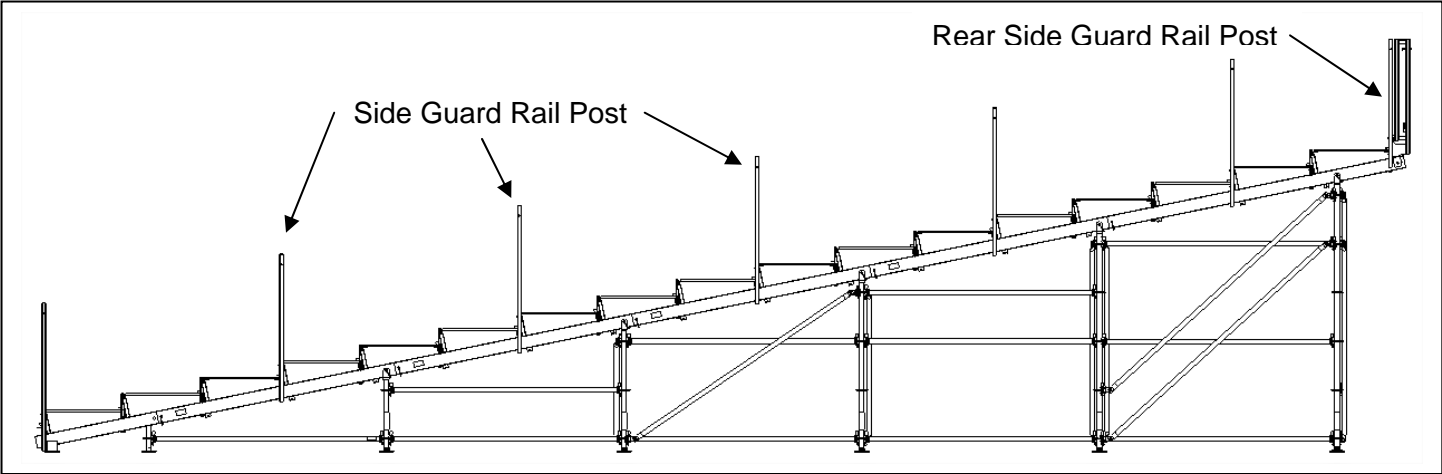
- A. The Rear Guard Rail Posts will need to be added to accommodate the last row of seating. Attach the appropriate guard rail post depending on the pitch of bleacher being set up.
- For 0.5M – Bolt Rear Guard Rail in second hole from end of Rear Universal Beam (see Fig. 8.1).
 - For 1.0M – Bolt Rear Guard Rail in first hole from end of Rear Universal Beam (see Fig. 8.2).
- NOTE:** The rear corners must use the Rear Guard Rail Corner Posts (see Figures 8.3 and 8.4).

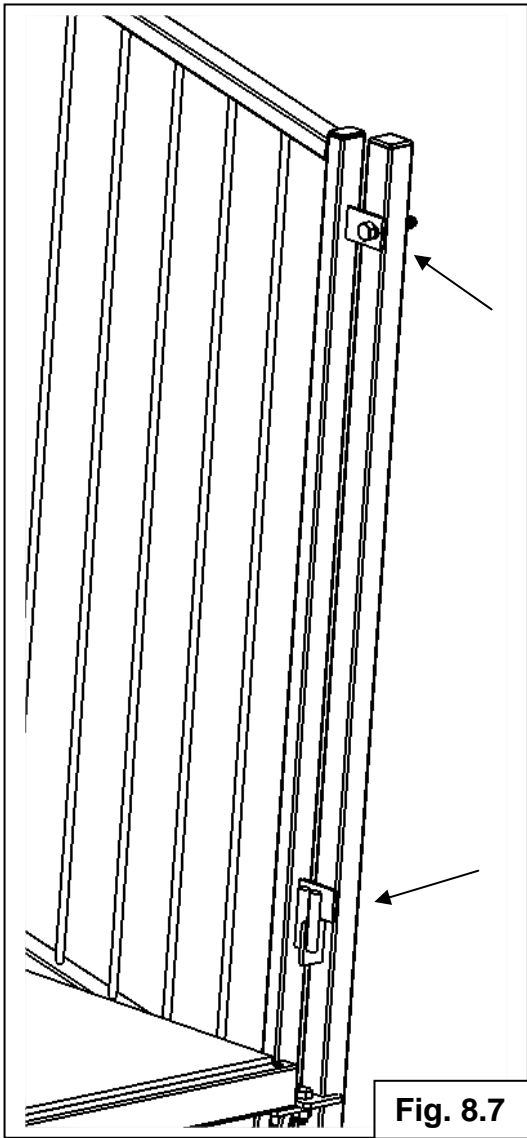


B. Add a Side Guard Rail Post by placing slotted tube over the washer of the seat frame pin on the Beams. Slide the Guard Rail Post down and bolt into place (see Fig. 8.5).



C. Attach a Side Guard Rail Post to every fourth washer of the seat frame pin. Attach a Rear Side Guard Rail Post to the washer of the Rear Guard Rail Corner Post (see Fig. 8.6).





D. Attach a Side Guard Rail by placing the tabs behind dowels on the Side Guard Rail Post. Bolt the upper tab of the Side Guard Rail to the Guard Rail Posts (see Fig. 8.7).

Fig. 8.7

E. Attach the Side Rear Guard Rail at the top (see Fig. 8.8).

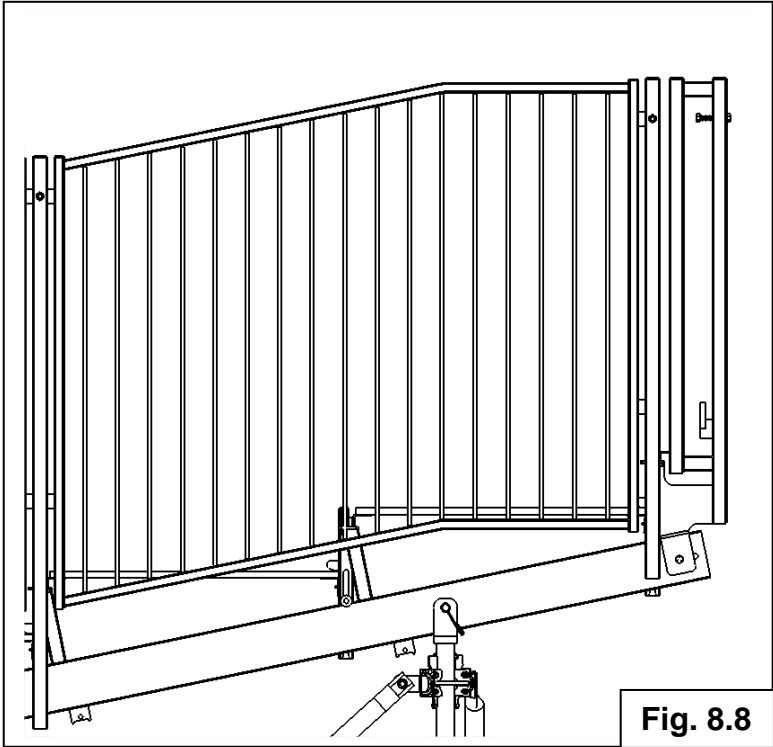
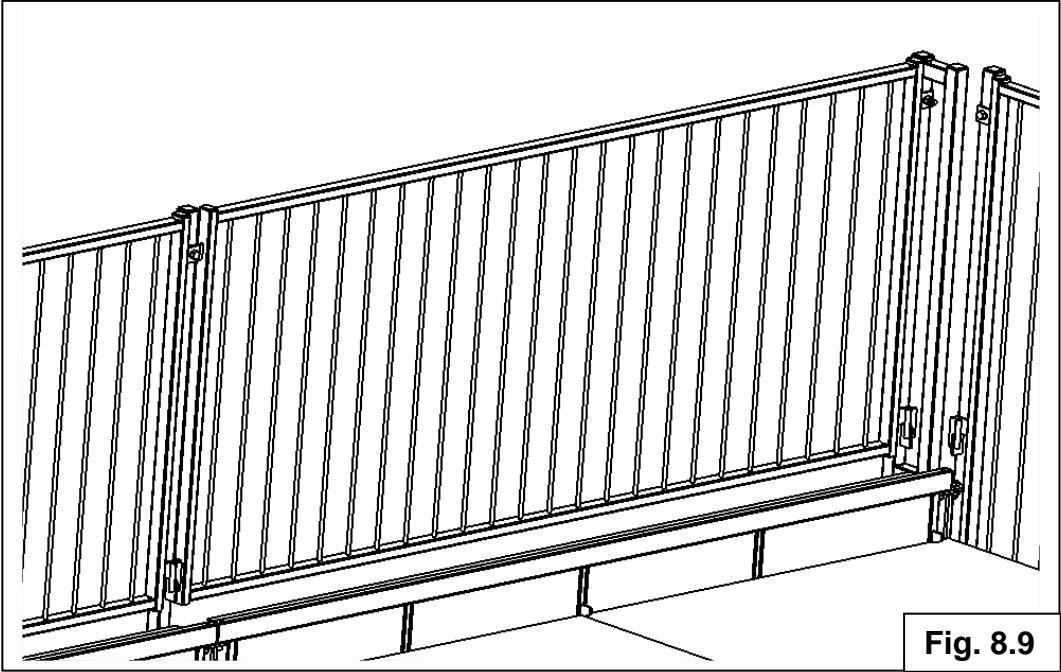


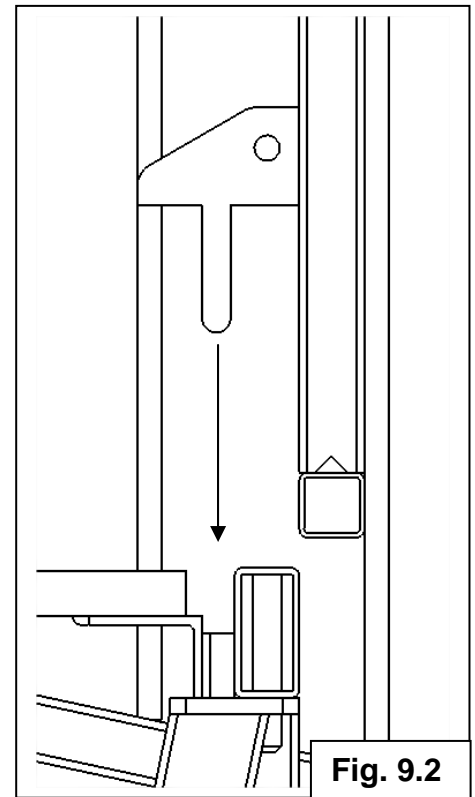
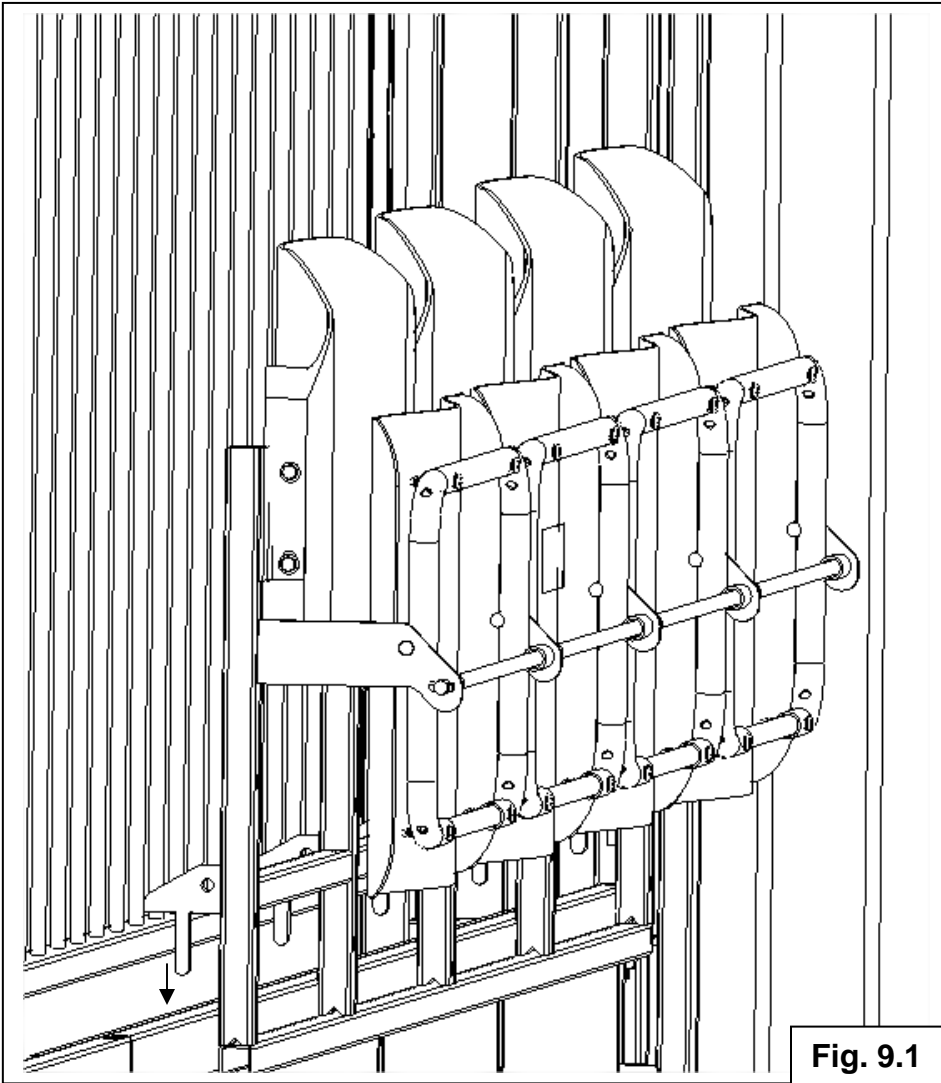
Fig. 8.8

F. Attach the Rear Guard Rail in the same manner (see Fig. 8.9).



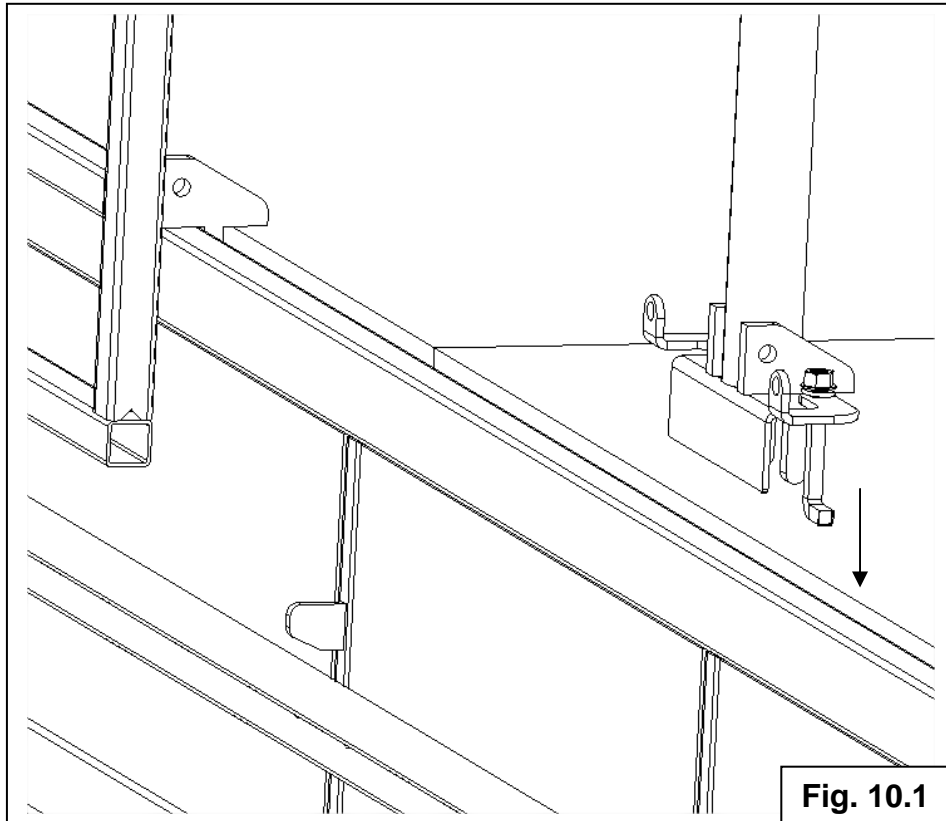
Step 9 Adding Seating

- A. Start at the top corner of the bleacher set up and begin adding the appropriate seat style frame. Slide the tabs of the seat frame into the slot of the Support Frame. See Figures 9.1 and 9.2.

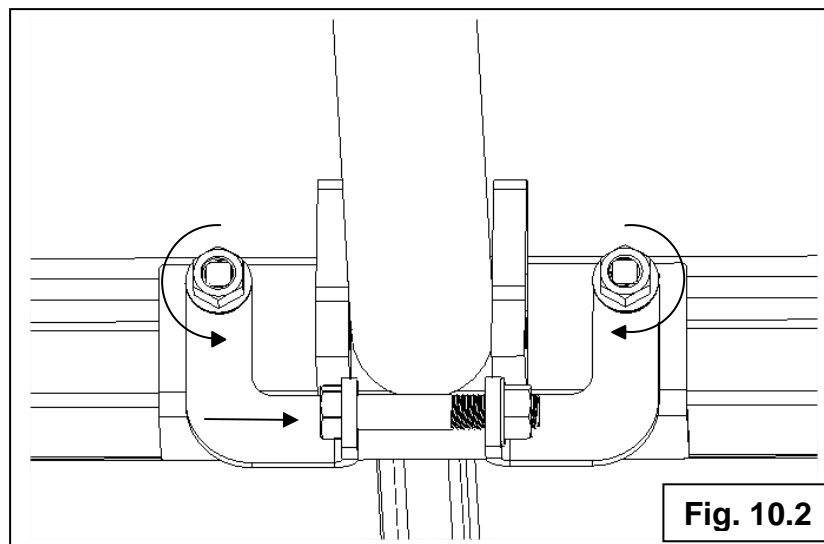


Step 10 Adding Handrails

- A. Add the appropriate pitch Handrail by placing the Square “L” Pin through the same slots that the seat frames were placed (see Fig. 10.1).



- B. Rotate tabs to engage “L” pins. Attach bolt and nut to prevent “L” pins from turning (see Fig. 10.2).



NOTE: Each setup will need to follow the local or state building code applicable for that location for all spacing details and installation requirements.