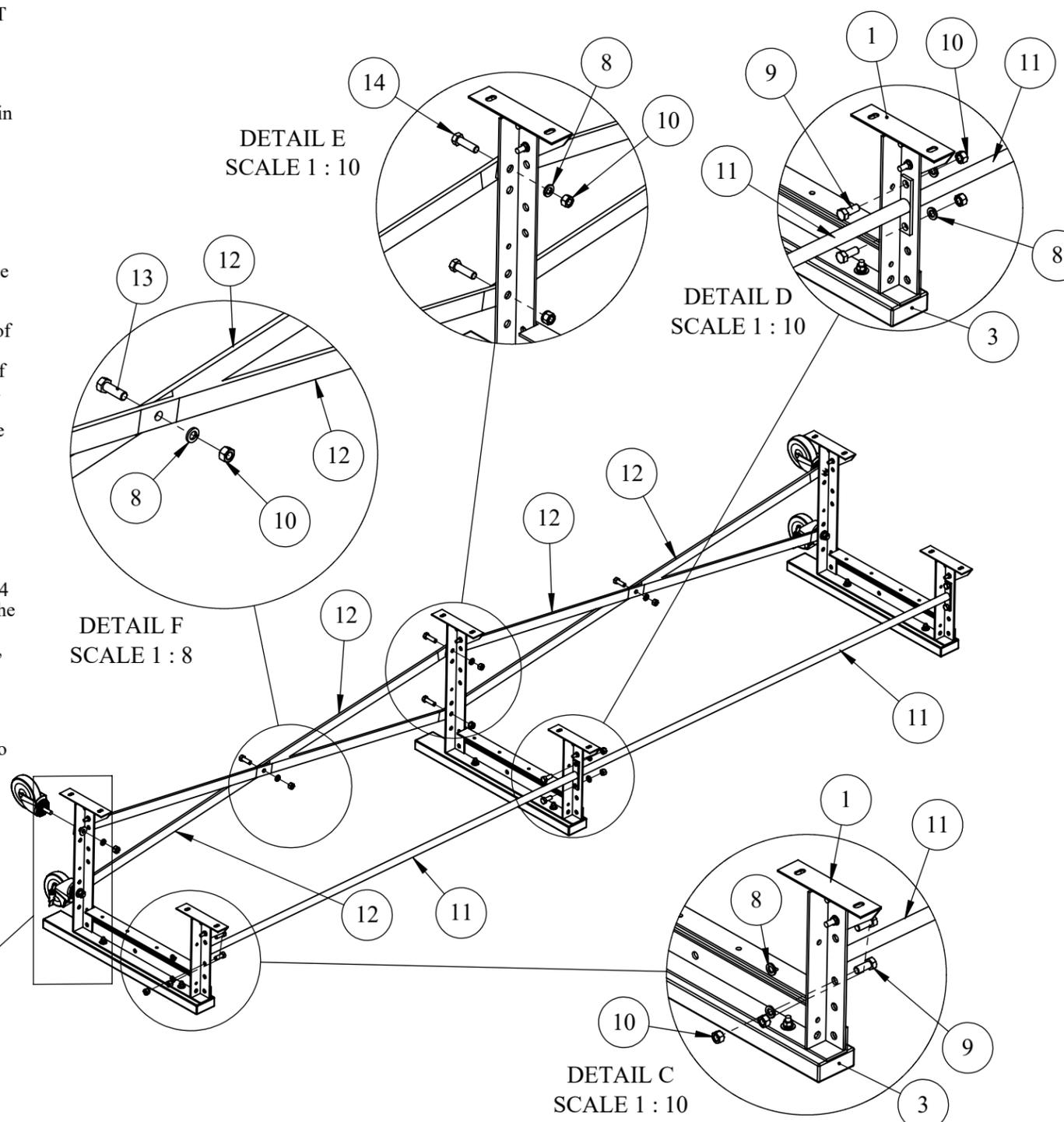


NOTE: LEAVE ALL NUTS AND BOLTS FINGER TIGHT UNTIL NOTED OTHERWISE.

- Match all of the braces together by length (74 1/2").
- 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 (2) sets 74 1/2" braces.
- 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!**
- 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.
- As shown in the spaces of the bleacher place a tube brace on the 1st row uprights. Attach them with two 1/2" x 1-1/4" 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.
- 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.
- 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.

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



ITEM NO.	PART NUMBER	DESCRIPTION	Frame Only/QTY.
1	BLA2TR-SA1	2 ROW ALUMINUM SEAT FRAME	3
2	CASTORB	CASTER FOR BLEACHERS W/BRAKE	2
3	IBL2TR-355	2"x4" RP MUDSILL 2 ROW T&R	3
4	CASTOR	CASTER FOR BLEACHERS W/O BRAKE	2
6	Regular FW 0.375	3/8" REGULAR FLAT WASHER	6
7	HNUT 0.3750-16-D-N	3/8"-16 HEX NUT	6
8	Regular LW 0.5	REG LOCKWASHE R 1/2"	10
9	HBOLT 0.5000-13x1.25x1.25-N	HEX BOLT 1/2"-13x 1 1/4"	8
10	HNUT 0.5000-13-D-N	1/2"-13 HEX LOCKNUT	10
11	IBLA-SA2	1ST ROW GALV BRACE ASSY	2
12	IBLA-7425	X BRACE 74 1/4"	4
13	HBOLT 0.5000-13x1.5x1.25-N	HEX BOLT 1/2"-13x 1 1/2"	2
14	HBOLT 0.5000-13x1.75x1.25-N	HEX BOLT 1/2"-13x 1 3/4"	2
15	Regular LW 0.375	LOCK WASHER 3/8"	6

DETAIL A SCALE 1 : 10

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

NAME	DATE	DRAWN DAT 3/11/2015
CHECKED		
ENG APPR.		
MFG APPR.		
Last Saved	4/15/2019 07:43:58	
COMMENTS:		

Kay Park Rec

TITLE:

DESC. **2 Row Aluminum 15' Tip and Roll**

S:\CADDRWGS\Solidworks\Bleachers\BLA\BLA Assemblies\Bleachers (17in)\

SIZE **B** PART NO. **BLA2A15TR** REV

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