

# STADIUMS, GRANDSTANDS AND BLEACHERS SINCE 1946.

SOUTHERN BLEACHER COMPANY



World class custom facilities for every sport and entertainment budget



1.800.433.0912 [WWW.SOUTHERNBLEACHER.COM](http://WWW.SOUTHERNBLEACHER.COM)

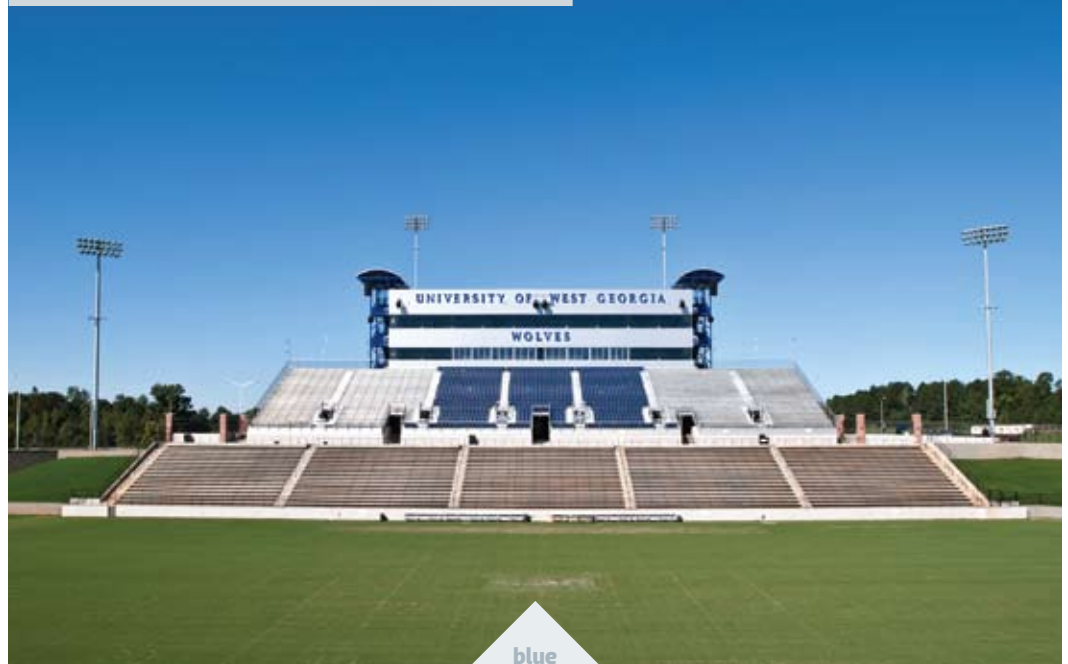
## MANUFACTURING

**Southern Bleacher's support services include seating layout, building code reviews, budget estimates, plan approval assistance, specifications and technical drawings.**

Southern Bleacher Company has over six decades of expertise in the manufacturing of world class sports and entertainment venues. From the initial stages to completion, Southern Bleacher will work with you and your committee in creating a facility that will stand the test of time to ensure your investment. You will benefit from our considerable design experience in addressing critical building code requirements and the verification of sight lines. Our many valuable services include providing seating layouts, building code reviews, budget estimates, plan approval assistance, specifications and technical drawings.

No matter the size, scope and type of project - professional, collegiate or a secondary school sports facility, our expertise and dedication to excellence will result in world class stadiums, grandstands and bleachers for your client's budget. ■

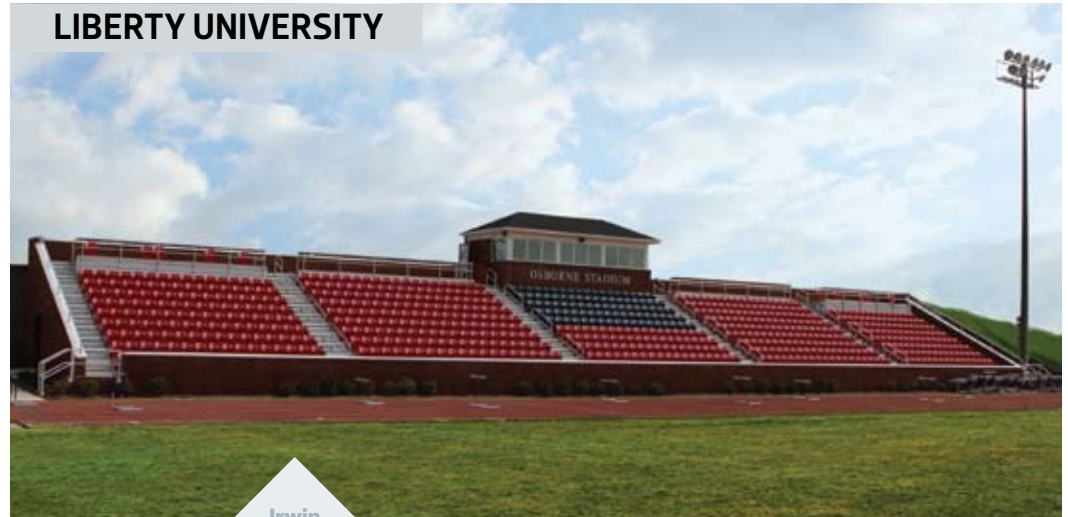
## UNIVERSITY OF WEST GEORGIA



blue  
Interkal chair  
vip section

CARROLLTON, GEORGIA - 6,680 seat Horizontal Beam Grandstand. Interlock 2000 decking. Designed by Southern A&E L.L.C. Manufactured and installed by Southern Bleacher. Pressbox by others. The home of UWG Wolves football and Womens soccer. **NOTE:** The lower section is bench seating on concrete. Photo: Steve Hogben Photography

## LIBERTY UNIVERSITY



Irwin  
chairs in  
team colors

LYNCHBURG, VIRGINIA - 868 seat Horizontal Beam grandstand. Tongue & Groove 2001 decking. 868 Irwin chairs. Designed, manufactured and installed by Southern Bleacher. Pressbox by others. Osborne Stadium is the home of Flames soccer and track. Photo: stoneblueproductions.com

Visit our website...  
[www.southernbleacher.com](http://www.southernbleacher.com)

## COVER PROJECT

### *Madisonville CISD*

MADISONVILLE, TEXAS - 2,729 seat Horizontal Beam grandstand. Tongue & Groove decking. 8'x54' pressbox with a 10' covered platform. Designed, manufactured and installed by Southern Bleacher. The home of Mustangs football and track.

Photo: Glen Davis, Legendary Portraits.

one

## PETAL SCHOOL DISTRICT

PETAL, MISSISSIPPI  
Home Side - 5,999 seat  
Horizontal Beam grandstand.  
Interlock 2000 decking,  
3,001 Irwin chairs. 8'x126'  
sloped front pressbox.  
Visitor Side - 2,096 seats.  
Interlock 2000 decking.  
Designed by Landry and  
Lewis Architects, P. A.  
Manufactured and installed  
by Southern Bleacher.  
The home of Panther  
football. **NOTE:** Sloped front  
pressboxes offer greater  
visibility Photos: Vista Studios

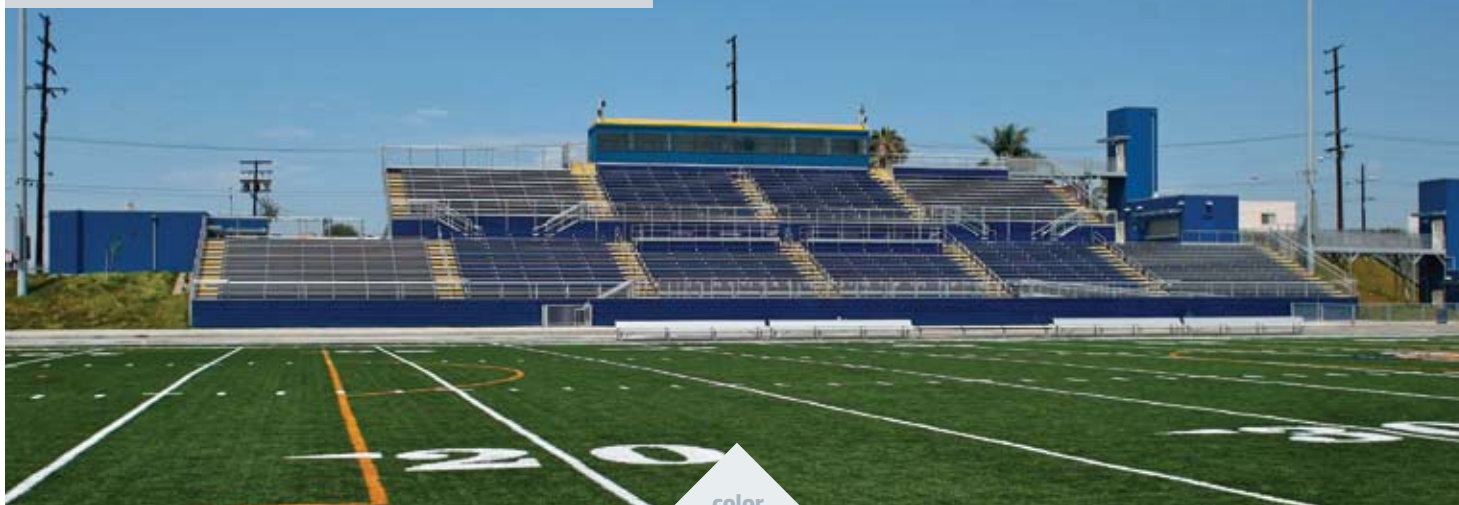


## TEAM COLOR - PETAL



**Team colors add excitement and help build fan loyalty. We offer a variety of seating options that provide colorful and creative solutions.**

## LOS ANGELES SOUTHWEST COLLEGE



color  
backrests and  
step risers

LOS ANGELES, CALIFORNIA - 2,522 seat Horizontal Beam grandstand. Interlock 2000 decking. Royal backrests with gold step risers. 10'x66' pressbox. Designed by Sillman Wright Architects. Manufactured and installed by Southern Bleacher. The home of LASC Cougars football and track. Photo: Richardson Photography, Inc.

two

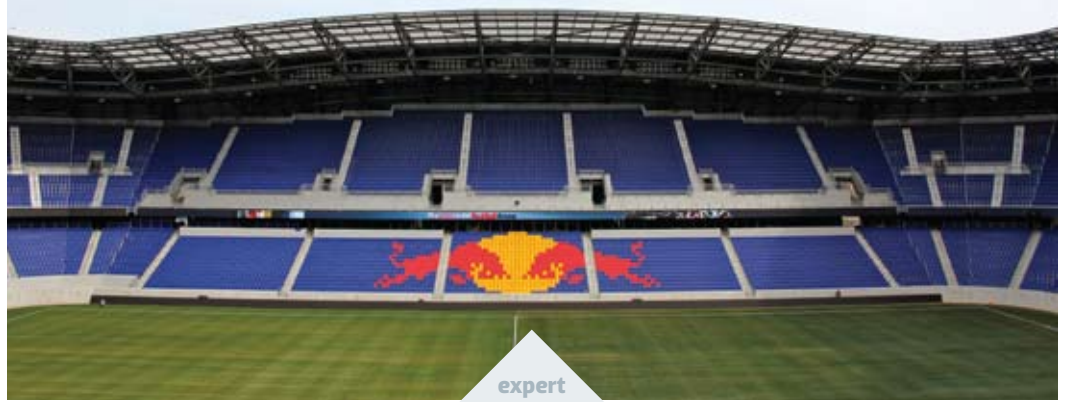
## PRODUCT PRESENTATION

---

**Venue options include Clear-Span foundations, integral roof systems, skyboxes and suites, pressboxes, mitered designs, stadium additions, decking and seating options.**

Your stadium project is greatly enhanced when you work with our professionals. With years of experience and great fans of all sport, they are the most knowledgeable in the industry. We can help define your stadium with the amenities that today's sports enthusiasts and owners expect. Our industry leading concourse design with a Clear-Span foundation offers excellent accessibility for under-stadium storage, concessions, meeting rooms and secure passageways. Southern Bleacher can incorporate pressboxes, mezzanines and suites into your facility. And our extensive range of combinable seating systems enables you to be creative while meeting design requirements and your budget. For the best value, with industry defining innovations that appeal to owners and fans alike, Southern Bleacher is the best choice for your project. ■

### RED BULL ARENA



expert  
mitered  
design

HARRISON, NEW JERSEY - 25,000 seat Mitered stadium. Interlock 2000 decking. Designed by Rossetti. Southern Bleacher fabricated the substructure and decking. Home of the New York Red Bulls professional soccer. **NOTE:** Thanks to our skill with mitered projects, it is only 21 feet from the touchline to the first rows. Photo: [intervisionnewmedia.com](http://intervisionnewmedia.com)

**This addition to an existing basic grandstand features a unique pressbox design and a vip seating section finished with team color that completely changes the appearance.**

### PRESSBOX - HIDALGO



### HIDALGO INDEPENDENT SCHOOL DISTRICT



addition  
to 30 year old  
grandstand

HIDALGO, TEXAS - 590 seat, 10 row addition. Tongue & Groove decking. 250 Interkal chairs and 340 bench seats. 10'x42' pressbox with covered upper deck and arched awnings. Designed by Vitetta Group, Inc. Manufactured and installed by Southern Bleacher. The home of Pirates football and track. **NOTE:** The original grandstand was built by Southern Bleacher in 1980. Photo: Michael Fuego

three

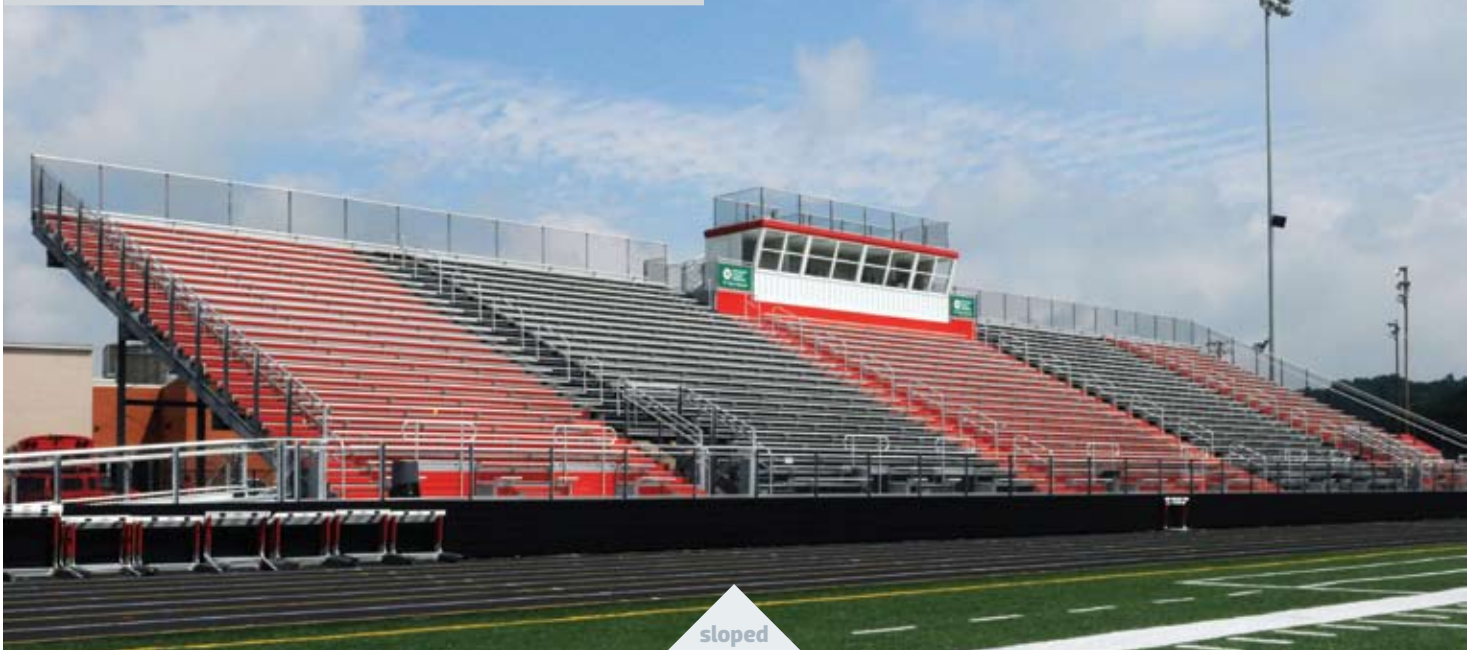
## UNIVERSITY OF NOTRE DAME



stone  
enhancement  
of stadium

SOUTH BEND, INDIANA - 2,006 seat Horizontal Beam grandstand. Interlock 2000 decking, Irish blue seat backs. Designed by Ratio Architects. Manufactured and installed by Southern Bleacher. Pressbox by others. Arlotta Stadium is the home of Fighting Irish Lacrosse. **NOTE:** The addition of stone creates permanence and blends the grandstand into the campus' existing architectural style. Photo: BKR Studio Inc

## MASON COUNTY BOARD OF EDUCATION



sloped  
front  
pressbox

POINT PLEASANT, WEST VIRGINIA - 2,400 seat Horizontal Beam grandstand. Tongue & Groove decking, 8'x36' sloped front pressbox. Designed by Thrasher Engineering, Inc. Manufactured and installed by Southern Bleacher. The home of Big Blacks football and Big Blacks/Lady Knights track. **NOTE:** Excellent use of team colors on step risers. Photo: Ashley Watts Photography

## USES APPLICATIONS

**Our stadiums and bleachers are designed to meet any budget, yet exceed expectations in every component. We work with the best aluminum extrusion companies in the U.S. Our aluminum is stringently monitored for strength and hardness.**

Southern Bleacher Company is the nation's largest and oldest stadium, grandstand and bleacher manufacturer. Our projects are in place at the top professional sports venues, collegiate and secondary schools, rodeo and equestrian arenas, fairgrounds, NASCAR tracks and private entertainment venues.

Southern Bleacher builds world class stadiums that offer your client excellent value. The significant life-cycle cost advantage of our stadiums is a major consideration for any budget. A Southern Bleacher stadium is a rock solid investment for sports programs and venues of every variety and size. ■

## ROWAN UNIVERSITY



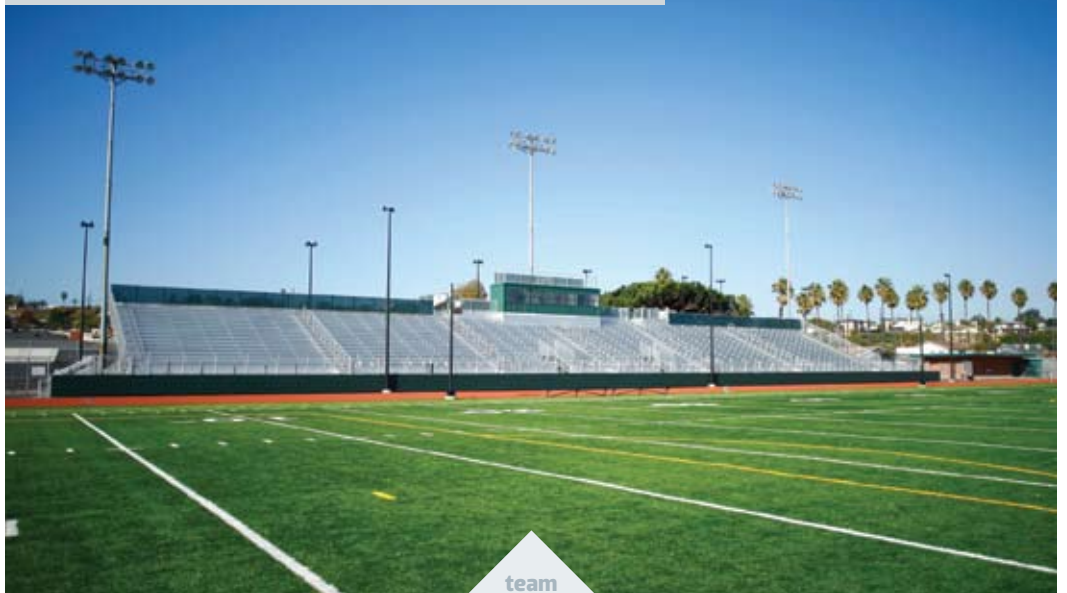
unique  
cantilever  
roofs

GLASSBORO, NEW JERSEY – 2,847 seat Horizontal Beam grandstand. Interlock 200 decking, 10'x54' sloped front pressbox. Designed by Clarke Caton Hintz. Manufactured and installed by Southern Bleacher. The home of the Rowan Owls football, soccer, lacrosse, field hockey and track. Photo: KSN Images

### Contact us three ways...

VISIT OUR WEB SITE: [www.southernbleacher.com](http://www.southernbleacher.com) E-MAIL US: [info@southernbleacher.com](mailto:info@southernbleacher.com)  
or CALL TOLL FREE: 1.800.433.0912

## TORRANCE UNIFIED SCHOOL DISTRICT

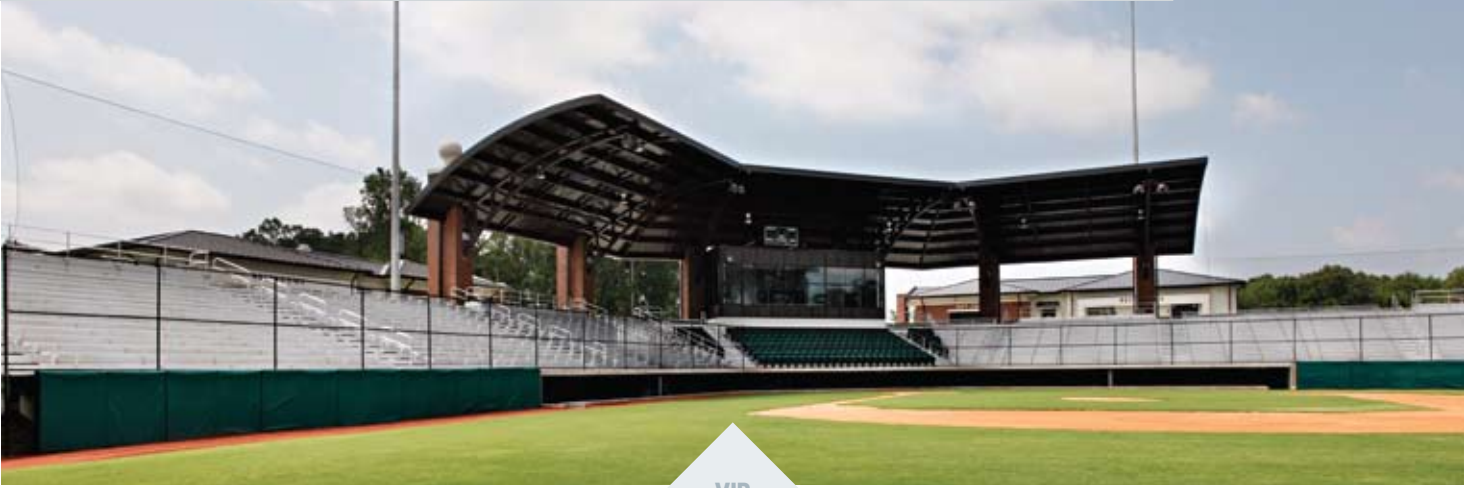


team  
color used on  
pressbox

TORRANCE, CALIFORNIA – 2,214 seat Horizontal Beam grandstand. Tongue & Groove decking, 8'x36' pressbox. Designed by Westberg + White, Inc. Manufactured and installed by Southern Bleacher. The home of Tartar football and track. NOTE: Team color pressbox adds personality to any facility. Photo: Richardson Photography, Inc.

five

## LITTLE LEAGUE INTERNATIONAL - SOUTHEASTERN REGIONAL FACILITY



VIP  
seating section

WARNER ROBINS, GEORGIA - 2,432 seat Mitered stadium. Interlock 2000 decking. 238 Interkal chairs. Designed by JMA Architecture. Manufactured and installed by Southern Bleacher. Pressbox and roof by others. Photo: Ken Krakow

**Southern Bleacher's mitered projects ensure ample seat dimensions and good lines of sight for spectators.**

Critical seating layouts include miters so the stadium conforms to the perimeter of the playing field.

## SINTON INDEPENDENT SCHOOL DISTRICT

SINTON, TEXAS - 726 seat Mitered grandstand. Interlock 2000 decking. 348 Interkal chairs and 366 bench seats with backrests. 8'x24' pressbox. Designed by Ferrell/Brown & Associates, Inc. Manufactured and installed by Southern Bleacher. The home of Pirate softball. NOTE: Closed ends on roof prevent birds from roosting. Photos: Tumlinson Photography



## USEABLE SPACE - SINTON



**The space under mitered stadiums and Horizontal Beam grandstands can be used for storage, locker or meeting rooms.**



## PRODUCT INNOVATIONS

**Elite Seat, Elite Seat II and Vertical Rail are great enhancements to any venue.**

Elite Seat and our new Elite Seat II are designed for comfort and versatility. Both versions offer a colorful option with aluminum plank seating and are easily adaptable for use in existing indoor and outdoor facilities. Elite Seats are an economical choice for seating options with longevity. The Elite Seat is a UV-protected, blow-molded plastic seat. The Elite Seat II offers even more comfort with a soft, cushioned pad on top of the seat. Both versions are mechanically fastened to the aluminum bench. Both Elite Seat and Elite Seat II are available in a variety of colors.

Our Vertical Rail is an attractive alternative to the traditional chain link guard rail. Vertical Rail offers a clean, attractive and stylish safety option. It enhances entrance and exit ramps and portals. It creates a pleasing contrast with the horizontal lines of the decking. The aluminum pickets can be finished with our Dur-Kyn paint system for a lively and individualized appearance. They can also be anodized (black, bronze, clear) for the most durable, long-lasting finish available. ■

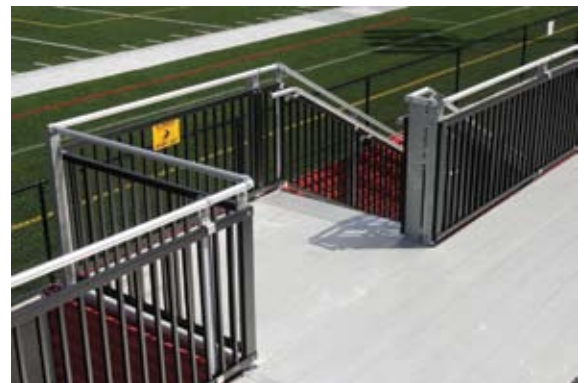
*The industry leader in stadium innovations...*

## SOUTHERN BLEACHER'S ELITE SEAT AND ELITE SEAT II

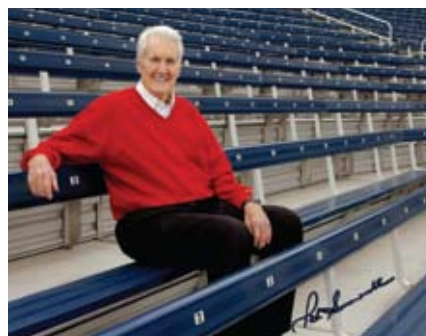


The Southern Bleacher Elite Seat was chosen as a "Best New Product" when it debuted. The molded Elite Seat offers a colorful and comfortable option for aluminum bench seating. The Elite Seat II takes our innovation and makes it even better with the addition of a soft, cushioned pad on top of the molded plastic seat. Both the Elite Seat and Elite Seat II are perfect for indoor or outdoor facilities. They are an affordable enhancement to venues with day long events.

## SOUTHERN BLEACHER'S VERTICAL RAIL



Our innovative Vertical Rail is an elegant alternative to standard chain link. This versatile safety feature can be left in a natural anodized aluminum or painted with a powder-coated finish in a variety of colors. Vertical Rail offers a unique element with which to customize your venue.



**"Southern Bleacher is the first player to sign when it's time to build your new sports facility." - PAT SUMMERALL**

Over six decades with no endorsements save our satisfied customers is something we take pride in. But the opportunity to be affiliated with Mr. Pat Summerall - whose name is synonymous with great sporting events was simply too good to pass up. Thanks Pat! Photo: Legendary Portraits



## USES APPLICATIONS

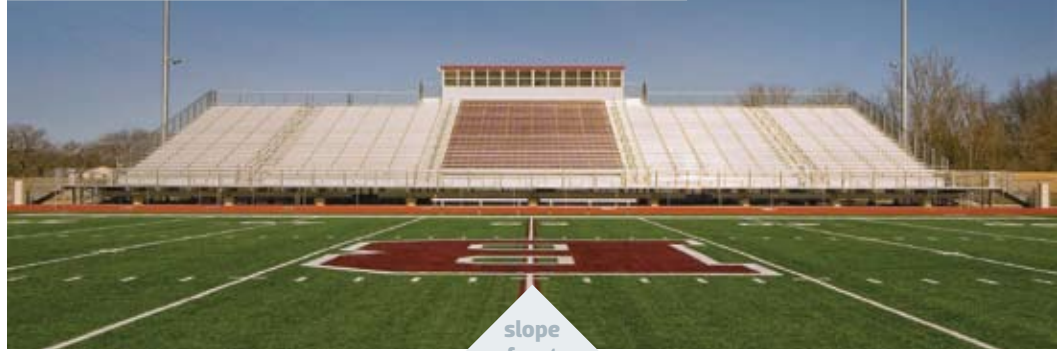
---

**With over six decades of experience, the experts at Southern Bleacher understand the myriad of unique challenges posed by sporting venues.**

We think you'll agree – with our vast experience in manufacturing stadiums, grandstands and bleachers, Southern Bleacher understands the intricate details of the design and planning of sporting and entertainment venues.

In addition, Southern Bleacher's long list of satisfied clients is a testament to how we conduct our business. We take great pride in treating our clients with respect and honesty and we conduct our business with integrity and class. Not all companies can state this. Want to see more? You can spark your imagination by visiting our website at [www.southernbleacher.com](http://www.southernbleacher.com). When you're ready to begin, call us toll free or send an e-mail to [info@southernbleacher.com](mailto:info@southernbleacher.com). Our dedicated sales professionals are the most knowledgeable in the stadium, grandstand and bleacher industry. Each one of them can help you create a facility that celebrates sport in all its forms. ■

## BOWIE INDEPENDENT SCHOOL DISTRICT



slope  
front  
pressbox

BOWIE, TEXAS – 2,444 seat Horizontal Beam grandstand. Tongue & Groove decking. 1,818 bench seats and 600 bench seats with backrests in Bowie maroon. 8'x48' sloped front pressbox. Designed by CADCO Architects -Engineers, Inc. Manufactured and installed by Southern Bleacher. The home of Jackrabbits football and track.

Photo: Glen Davis, *Legendary Portraits*

## JACKSBORO INDEPENDENT SCHOOL DISTRICT



Interkal  
chairs in tiger  
purple

JACKSBORO, TEXAS – 2,029 seat Horizontal Beam grandstand. Tongue & Groove decking. 1,464 bench seats and 549 chairs. Designed by Harper Perkins Architect, Inc. Manufactured and installed by Southern Bleacher. Pressbox by others. The home of Tigers football and track. Photo: Glen Davis, *Legendary Portraits*

## UNIVERSITY OF SOUTHERN MISSISSIPPI



Irwin  
chairs in  
black

HATTIESBURG, MISSISSIPPI – 521 seat Mitered stadium. Tongue & Groove decking. 235 Irwin chairs. 14'x45' pressbox. Designed by JMS Architect. Manufactured and installed by Southern Bleacher. The Southern Miss Softball Complex is the home of the Lady Eagles. Photo: Vista Studios

**COMPONENT  
PARTS**

---  
**DECKING  
SEATING**

**Our Interlock 2000 decking system is an excellent alternative to costly concrete venues. It is also 64% stronger than welded decking.**

**Ask about great chair details like college mascots and logos, they add team spirit.**

**We are a major supplier of seating components for concrete facilities. Contact us with your project requirements.**

**We are the industry leader in innovative decking and seating options.**

## Decking options...

**INTERLOCK 2000**



**TONGUE and GROOVE 2001**



**CLOSED-DECK ALUMINUM**



**FULL PLANK**



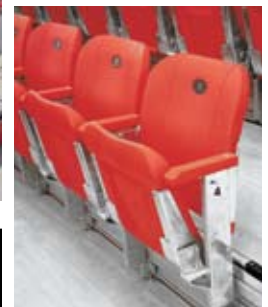
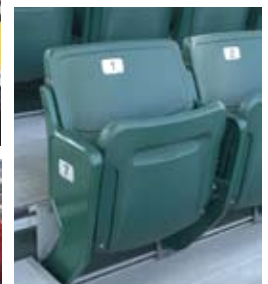
Decking Arrangements: Interlock 2000 decking system is our custom extrusion system comprised of continuous interlocking aluminum die shapes. The Tongue and Groove decking system with symmetrical extruded aluminum shapes provides a closed deck with added rigidity. Both systems are choice selections for their superior reduction in deflection. Closed-Deck aluminum decking system arranges planks edge-on-edge with no open spaces. Full-Plank decking arrangement permits a 3" open space directly under the seat. All of our decking systems feature a pattern of raised, parallel ridges that more than satisfies OSHA, ANSI, ADA and federal guidelines for floor traction. Southern Bleacher offers soundly designed decking systems to fit your project and your budget. ■

## Seating options...

**BENCH SEATING WITH OPTIONAL BACKRESTS:** We offer several widths and profiles in our bench seating. Our bench seating can be enhanced with a wider tread depth. Backrests can add to the comfort level. For a truly customized stadium, seating sections can be highlighted with color.

**ELITE SEAT/ELITE SEAT II:** See page seven for our newest innovations.

**PLASTIC MOLDED CHAIRS:** Your stadium can be designed with a wide variety of seating components, including plastic stadium chairs from select manufacturers. Samples, drawings and dimensions for these chairs are available on request. ■



Southern Bleacher's featured plastic molded chairs are Interkal (green) Ducharme (orange) and Irwin (red).

## OVERALL PRODUCT IN PLACE

Southern Bleacher's permanent steel grandstands provide spectators comfortable and secure seating. Our Horizontal Beam and Leg Truss designs are the most versatile steel substructure grandstands available.

**INSTALLATION:** Southern Bleacher manufactures and installs grandstands using highly trained personnel. Welders are certified by the American Welding Society and the Canadian Welding Bureau. All factory connections are welded, while field erection is bolted. Concrete footings are designed based on soil reports.

**COMPONENTS/PARTS:** Steel substructures: The steel substructure of Southern Bleacher's permanent stadiums utilizes wide-flange beams. Southern Bleacher's designs are backed by state-registered professional engineers.

**MATERIALS/FINISHES:** Steel substructures: Southern Bleacher's finish is a hot-dip galvanized coating according to ASTM-A123 specifications as a standard, maintenance-free product. Other specified finishes are available.

**COMPONENTS/PARTS:** Seating arrangements: We offer aluminum bench seating with backrests; our stadium chair options include several plastic chairs from select vendors.

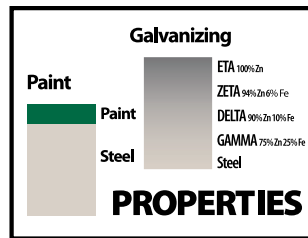
**COATINGS/SURFACES:** Standard and custom paint colors are available on our aluminum seat planks, backrests and riser planks. Pigmented, organic coating meets the Architectural Aluminum Manufacturers Association spec. 603.8-92.

**CODES/CERTIFICATION:** With confirmation of the applicable building codes, Southern Bleacher will prepare drawings and specifications accordingly.

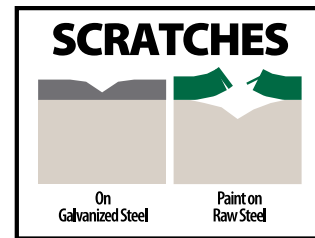
**OPERATION/MAINTENANCE:** We recommend that the Owner conduct annual inspections to ensure safe conditions. A professional engineer or registered architect should also perform biennial inspections based on text from the current NFPA 102-97 Edition. ■

## THE BENEFITS OF GALVANIZING

### Galvanized-Coated substructures



Galvanizing is a metallurgical bonding, not just a superficial finish.

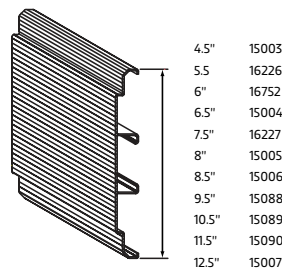


Scratches on painted steel require frequent touch-ups. Galvanized steel is abrasion-resistant and self-healing.

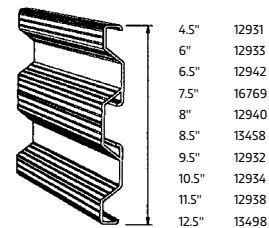
Southern Bleacher protects our steel substructure with a hot-dip galvanized coating. This process helps to protect and ensure a long life for your investment. Our Cotton Bowl renovation/expansion, TCU Lupton Baseball Stadium and Texas Motor Speedway were awarded the prestigious American Galvanizers Association's Excellence in Galvanizing "Most Distinguished Award."

### Aluminum components

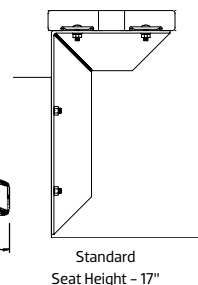
#### FLAT RISER PLANK



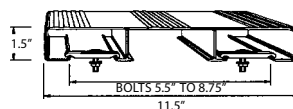
#### RIBBED RISER PLANK



#### L BRACKET



#### SEAT PLANK 2x12 - 7878

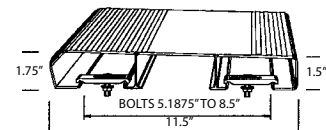


Seat Plank is also available in:  
2x10 - 7758 (9.5 width)

#### RS SEAT PLANK

Note: RS Plank has a radius nose and a slope to the rear to allow for ergonomic comfort and water drainage.

#### 2x12RS - 13315



RS Seat Plank is also available in:  
2x10RS - 17627 (9.5 width)  
2x11RS - 17626 (10.5 width)

**Additional aluminum component parts are available.  
Call with any technical questions.**

ten

# PERMANENT GRANDSTAND SPECIFICATIONS

## SOUTHERN BLEACHER COMPANY

### SECTION 13125 PERMANENT GRANDSTANDS

#### PART 1 - GENERAL

##### 1.01 SYSTEM DESCRIPTION

- A. Provide labor, material, equipment and supervision necessary to complete installation of permanent steel grandstand, including the following: (SELECT ITEMS WHICH APPLY)
1. Steel Substructure
  2. Decking System
  3. Concrete Foundation
  4. Press Box Support Structure
  5. Press Box

##### 1.02 QUALITY ASSURANCE

- A. Manufacturer Qualifications: Manufacturers must have ten years of experience in the manufacture of bleachers and grandstands; manufacturer must exhibit proof of business existence for past five years with documentation; welders must be AWS certified.
- B. Installer Qualifications: Experienced in the proper installation of grandstands.
- C. Source Quality Control: Mill Test Certification.

##### 1.03 SUBMITTALS

- A. Manufacturer's Product Data: Submit manufacturer's descriptive product data for project.
- B. Shop Drawings: Manufacturer to submit shop drawings sealed by a registered engineer and shall be of sufficient clarity to indicate the location, nature and extent of the work proposed and show in detail that it will conform to the applicable code and relevant laws.
- C. Certificates:
1. Insurance Certificate
  2. Bid Bond
- D. Product Sample: Submit one 18-inch seat sample.
- E. Color Sample: If applicable, submit sample.

##### 1.04 SITE CONDITIONS

- A. Field Site:
1. Owner to make site accessible.
  2. Owner to verify site locations, benchmarks.
- B. Underground Utility Line: Owner to clearly mark all underground utilities and obstructions and Owner to relocate all that conflict with grandstand.
- C. Soil Test: Furnished by Owner.

##### 1.05 BUILDING CODES

- A. Must meet or exceed all State and Local applicable codes and in compliance with the International Building Code adopted by the jurisdiction and CABO/ANSI A117.1 Barrier Free Subcode.

##### 1.06 WARRANTY

- A. Permanent Grandstand shall be under warranty for a period of one year beginning at Date of Substantial Completion for Projects installed by Manufacturer. The Grandstand is warranted to be free from defect in materials and workmanship in the course of manufacture. This warranty excludes any other defects resulting from abnormal use in service, accidental or intentional damage or any occurrences beyond Manufacturer's control.

##### 1.07 MAINTENANCE

- A. Owner is to conduct annual inspection and required maintenance of grandstand to assure safe conditions. It is also recommended that a professional engineer or registered architect perform inspections biennially.

#### PART 2 - PRODUCTS

##### 2.01 ACCEPTABLE MANUFACTURERS

- A. Southern Bleacher Company (800) 433-0912. Horizontal Beam Design. Other manufacturers seeking to be approved must submit product literature on horizontal beam design to the Owner for review and receive approval from Owner seven days prior to bid date.

##### 2.02 PERMANENT STEEL GRANDSTAND

- A. Product Description
1. Horizontal Beam Design: Gross seating capacity of \_\_\_\_\_ rows, and \_\_\_\_\_ feet long.  
Press Box Support Structure \_\_\_\_\_ x \_\_\_\_\_  
Press Box \_\_\_\_\_ x \_\_\_\_\_
  2. Vertical columns are placed 18 feet 0 inches on center laterally and \_\_\_\_\_ feet on center front to back.
  3. Horizontal beams are wide flange beams.
  4. Traverse bays are free of crossbracing the total length of the grandstand.
  5. Stringers are wide flange with steel angle rise and depth fabrication and are placed 6 feet on center.
  6. Front Walkway:
    - a. Clear width \_\_\_\_\_ inches.
    - b. Elevated \_\_\_\_\_ feet above grade at benchmark.
  7. Entry stairs to be firmly anchored to uniformly poured concrete bases.
    - a. Stair rise: \_\_\_\_\_ inches with aluminum closure and contrasting aluminum stair nose.
    - b. Stair tread depth: \_\_\_\_\_ inches.
    - c. Guardrails: As required by code.
    - d. Stairs to have handrail extension. The handgrip portion of handrails shall not be less than 1 1/2 inches or more than 2 inches in cross-sectional dimension or the shape shall provide

an equivalent gripping surface. The handgrip portion of handrails shall have a smooth surface with no sharp corners. The top of handrails and handrail extensions shall be placed not less than 34 inches or more than 38 inches above the nosing of treads and landings. Where handrails are not continuous between flights, the handrails shall extend horizontally at least 12 inches beyond the top riser and continue to slope for the depth of one tread beyond the bottom riser. Ends shall be returned or shall terminate in newel posts or safety terminals.

##### 8. Aisles:

- a. Aisles with seating on both sides to have discontinuous mid-aisle handrails. The handrails shall be discontinuous with breaks at intervals not to exceed five rows. These breaks shall have a clear width of at least 22 inches and not greater than 36 inches horizontally.
- b. Anodized aluminum handrails with rounded ends to be provided with an intermediate handrail below the main handrail.
- c. Aluminum tread nosing of contrasting color on aisle steps.
- d. Halfsteps shall be provided for riser heights above 8 inches.
- e. Halfsteps shall provide equal rise and run throughout aisle. Each shall have aisle nosing with non-skid black powder coated finish or other paint system meeting AAMA 603.8-92 specifications with a hardness rating of 2H and riser closure with clear anodized finish.
- f. Aisles with a riser height of non-uniformity shall be indicated with distinctive markings as required by code.

##### 9. Decking:

- a. Rise per row \_\_\_\_\_ inches, depth per row \_\_\_\_\_ inches.
- b. Each seat 17 inches above its respective tread.
- c. Mill Aluminum Decking Arrangement [SELECT ONE]
  - (1) INTERLOCK Aluminum Decking System
  - (2) Tongue-and-Groove System
  - (3) Closed Deck Aluminum Arrangement
  - (4) Full-Plank Arrangement

##### Seating Selection [SELECT ALL WHICH APPLY]

- (1) Anodized Aluminum Bench Seat [SELECT ONE, STANDARD PLANKS ARE NOTED]
  - (a) 2 x 10 (standard), Die #7758 with height of 1 1/2".
  - (b) 2 x 12 (standard), Die #7878 with height of 1 1/2".
  - (c) 2 x 10 RS, Die #17627 with height of 1 9/16" (back), 1 3/4" (front).
  - (d) 2 x 11 RS, Die #17626 with height of 1 1/2" (back), 1 3/4" (front).
  - (e) 2 x 12 RS, Die #13315 with height of 1 1/2" (back), 1 3/4" (front).
- (2) Anodized Aluminum Backrest 2 x 6, Die #7969 with height of 5 1/2".
- (3) Stadium Chair Model \_\_\_\_\_, as manufactured by \_\_\_\_\_
  - (a) Manual Lift, Self-rising or Fixed
  - (b) Quantity \_\_\_\_\_, Width \_\_\_\_\_.

10. Guardrailing: To be at all sides of bleacher, entry stairs and ramps, portals, and landings. Railing to be anodized aluminum with end plugs at ends of straight runs and/or elbows at corner. All guardrails shall be secured to angle rail risers by galvanized fasteners. Railing shall be at heights as required by code for its location on the grandstand. Guardrailing shall include intermediate railing, or galvanized chain link fencing fastened in place with galvanized fasteners and aluminum ties.
11. Cross Aisles: Clear width \_\_\_\_\_ inches.

##### 12. Ramps:

- a. Slope: 1 in 12.
- b. Guardrails: As required by code plus toeboard.
- c. Handrail: Ramps to have handrail extension. The handgrip portion of handrails shall not be less than 1 1/2 inches or more than 2 inches in cross-sectional dimension or the shape shall provide an equivalent gripping surface. The handgrip portion of handrails shall have a smooth surface with no sharp corners. The top of handrails and handrail extensions shall be placed not less than 34 inches or more than 38 inches above the ramp surface. Where handrails are not continuous between runs, the handrail shall extend horizontally above the landing 12 inches minimum beyond the top and bottom ramps. Ends shall be returned or shall terminate in newel posts or safety terminals.

##### 13. Handicap provision:

- a. Quantity of wheelchair spaces: \_\_\_\_\_
- b. Riser area adjacent to wheelchair spaces to have intermediate construction so 4 inch sphere cannot pass through opening.

##### B. Materials/Finishes:

1. Substructures:
  - a. Structural shapes meet one of the following ASTM specifications: A36, A36/A572 grade 50, A572 grade 50, A529-50, or A500 grade B.
  - b. Shop connections are seal welds.
  - c. After fabrication, all steel is hot-dipped galvanized to ASTM-A-123 specifications.
  - d. Painted steel finish is unacceptable.

##### 2. Extruded Aluminum:

- a. Seat Planks, Backrests and Riser Planks are extruded aluminum alloy, 6063-T6.
    - (1) Clear anodized 204R1, AA-M10C22A31, Class II finish
    - (2) Coating (Optional with additional cost):
      - (a) Factory applied, baked-on Kynar or Hylar/acrylic resin based paint coating, Dur-Kyn, as manufactured by the Valspar Corporation. Dur-Kyn meets or exceeds the physical and performance properties of AAMA 2603. (Specify color).
  - b. Tread planks are extruded aluminum alloy 6063-T6 mill finish.
  - c. Railing and Backrest Stanchions: Extruded aluminum alloy, 6063-T6 clear anodized 204R1, AA-M10C22A31, Class II.
3. Accessories:
- a. Channel End Caps: Aluminum alloy 6063-T6, clear anodized 204R1, AA-M10C22A31, Class II.
  - b. Cast End Caps: Aluminum 319 alloy, cast finish. (Required for backrest and RS plank only)
  - c. Hardware:
    - (1) Bolts, Nuts: Hot-dipped galvanized or mechanically galvanized.
    - (2) Hold-down Clip Assembly: Aluminum alloy 6005A-T6, mill finish.
    - (3) Structural Hardware: Equal to or greater than hot-dipped galvanized ASTM-A307. No connections utilizing high strength bolts are classed as slip critical.
  - d. Aisle Nose and Stair Nose: Aluminum alloy, 6063-T6, non-skid black powder coated finish or other paint system meeting AAMA 603.8-92 specifications with a hardness rating of 2H.

##### C. Fabrication:

1. Design Load:
  - a. Tread and Seat Area: 100 psf uniform live load.
  - b. Seat (Vertical): 120 lbs/lf.
  - c. Seat (Horizontal Sway): 24 lbs/lf parallel and 10 lbs/lf perpendicular to seat.
  - d. Handrail and Guardrail: 50 lbs/lf in any direction.
  - e. Handrail and Guardrail: 200 lbs concentrated in any direction.
  - f. Snow Loads: As per state adopted code.
  - g. Wind Loads: As per state adopted code.
  - h. Seismic Loads: As per state adopted code.
2. All manufactured connections to be shop welded.
  - a. Manufactured by certified welders conforming to AWS Standards.

These specifications serve as a template only and items listed may or may not apply to your project. Please call a Southern Bleacher representative at 800-433-0912 for technical assistance in preparing specifications.

##### OPTIONAL ITEMS AVAILABLE:

1. Kynar paint for aluminum products.
  2. Enhanced Traction System: Shot blasted and anodized walking surface for a minimum coefficient of slip of .80.
  3. Full line of fixed chair seating available.
  4. Custom color for aisle and stair contrasting nosing.
  5. Vertical Picket Rail Systems (available in galvanized steel or an assortment of aluminum finishes).
  6. Elite Seat - plastic blow molded, UV protected plastic seat used to individualize seating sections.
  7. Seat Numbers:
    - a. Decal with black lettering on aluminum field.
    - b. Rows: Numerals or alphabetical letters.
    - c. Seat Numbers: Numerals.
- 2.03 PRESS BOX [SPECS INSERTED HERE]

#### PART 3 - EXECUTION

##### 3.01 INSTALLATION

- A. All work performed by technicians experienced in bleacher seating installation.
- B. Project as per approved shop drawings.

##### 3.02 FIELD QUALITY CONTROL

- A. Foundation: Footings for the grandstand shall provide sufficient bearing area at bottom to support all loads of the grandstand. Depth and design of footings shall be determined by Owner supplied soil test. Hot-dipped galvanized anchor bolts shall be secured in the concrete footings. Concrete shall attain working strength of 3,000 psi.

##### 3.03 CLEAN-UP

- A. Clean up all debris caused by work of this section. All specifications are subject to change without notice to allow for Southern Bleacher's policy of continuous product improvement.
- B. The Owner, Architect and Contractor acknowledge and accept that mill finish aluminum as specified will have water stains present from transportation and storage during installation. Removal of these stains is not part of this contract.
- C. Stand to be broom cleaned at completion.

Specs: Custom PG (07/2010)



Post Office Box One, Graham, Texas 76450-9976

T: (800) 433-0912 T: (940) 549-0733

F: (940) 549-1365 E: info@southernbleacher.com

W: www.southernbleacher.com

Member  
BETTER BUSINESS BUREAU OF  
NORTH CENTRAL TEXAS

BROCHURE S/12 © 2010