



World class stadiums,  
grandstands and  
bleachers since 1946.

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



TOLL FREE 1.800.433.0912

Over six decades of  
experience guarantee  
client satisfaction.



 **Southern**<sup>®</sup>  
BLEACHER COMPANY Inc.

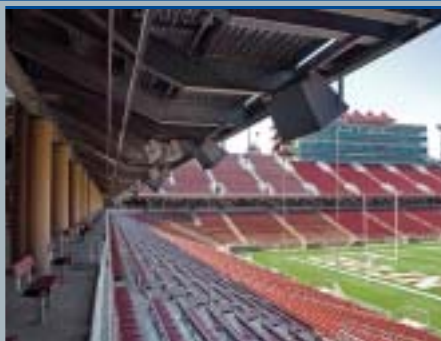
## NORTH CAROLINA STATE UNIVERSITY



RALEIGH, NC - Two 16 row by 93' upper grandstands with connecting catwalk that seats 1,712. Located on the north endzone at Carter-Finley Stadium. IL2K decking system. Designed by Corley Redfoot Zack, Inc. Manufactured and installed by Southern Bleacher. Photo: Mallin Photography

**Our dedication to excellence results in projects completed on time and within budget.**

## STANFORD UNIVERSITY



STANFORD, CA - Football stadium that seats 49,866. Improvements include reduction in seats, improved sight lines and egress/ingress, restroom, locker room and concession renovations and a new sky box. Designed by Hoover Associates. Manufactured and installed by Southern Bleacher.

Photo: Hawkeye Aerial Photography, ©06



## MANUFACTURING

Southern Bleacher Company celebrates over 60 years 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 and trends 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.

**Southern Bleacher's support services include seating layout, 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, Southern Bleacher's expertise and dedication to excellence will result in world class stadiums, grandstands and bleachers for your client season after season. ■



**Contact us three ways:**

VISIT OUR WEB SITE:

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SEND US AN E-MAIL:

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OR CALL TOLL FREE:

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#### UNIVERSITY OF MONTEVALLO

MONTEVALLO, AL - 11 row mitered Leg Truss baseball stadium that seats 444. Tongue and Groove 2001 decking system. Featuring 160 SOBCO 5000 chair seats in team color, and an 8' by 30' pressbox. Designed, manufactured and installed by Southern Bleacher.

Photo: Crow Studio

*We feature another mitered stadium on page six.*



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

#### VICKSBURG COMMUNITY SCHOOLS



VICKSBURG, MI - 24 row by 264' football/track stadium that seats 3,536. IL2K decking system. Featuring a 10' by 42' pressbox with sloping front and covered landings. Designed by Tower-Pinkster-Titus Associates. Manufactured and installed by Southern Bleacher.

Photo: People Places & Things Photography

## IMMACULATA UNIVERSITY



IMMACULATA, PA - 15 row by 140' track and field stadium that seats 1,142. IL2K decking system. Featuring 66 chairs and a 10' by 44' pressbox. Designed by Archer & Buchanan Architecture, LTD. Manufactured and installed by Southern Bleacher.

Photo: By KSN Imagery, Inc.

**Our Clear-Span designs set the industry standard.**

## CHANDLER USD # 80



CHANDLER, AZ - 21 row by 282' west side football/track stadium that seats 3,221. IL2K decking system. 8' by 54' pressbox with observation deck. Designed by Stichler Design Group. Manufactured and installed by Southern Bleacher. Photo: Tim Roberts Photography

## PRODUCT PRESENTATION

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.

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

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. ■



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CHAMBERSBURG, PA - 38 row by 210' football stadium that seats 4,420. IL2K decking system. Vertical Rail and a 8' by 42' sloped front pressbox. Designed by Crabtree Rohrbaugh & Associates. Manufactured and installed by Southern Bleacher.

Photo: Shatzer's Photo Studio

**Concourse designs with our Clear-Span foundation offer a variety of space saving and enhancing options for any size project.**

CREATING USABLE SPACE



*Pictured above are details of our Clear-Span foundation. Restrooms, locker rooms and concessions are easily integrated into this space saving design. With a Clear-Span foundation you are not limited by size in creating unique projects for your client. Note our Vertical Rail lining the stairs. It is an attractive alternative to chain link and provides architects with an additional cost effective design element.* Photos: Hawkeye Aerial Photography ©06

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## MILLER MOTOR SPORTS PARK



TOOELE UT - 10 row by 276' covered road course grandstand that seats 1,586. Full Plank decking system. Designed, manufactured and installed by Southern Bleacher.

Photo: Blakely Photography



**We are a proven performer  
in addressing formidable designs.**

## ALL SAINTS EPISCOPAL SCHOOL



FORT WORTH, TX - 15 row by 33' football and track elevated frame-type bleacher unit that seats 266. Optional exit ramp. Silver Edition frame-type bleacher is designed, manufactured and installed by Southern Bleacher. Our frame-type bleachers are the most functional, well designed and cost competitive seating systems in the industry.

Request a copy of our Silver Edition brochure. Photo: Glen Davis/Legendary Portraits

## USES / APPLICATIONS

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.

**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 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. ■



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AUSTIN COLLEGE



SHERMAN, TX - 7 row mitered baseball stadium that seats 528. Tongue and Groove 2001 decking system. 8' by 24' pressbox with observation deck. Designed, manufactured and installed by Southern Bleacher. Photo: Glen Davis/Legendary Portraits

*Critical seating layouts often include miters so the stadium conforms to the perimeter of playing fields. Our mitered designs ensure that ample seat dimensions and good lines of sight are maintained no matter what size the project.*

## Our mitered projects ensure ample seat dimensions and good lines of sight for spectators.

BULLOCH COUNTY BOARD OF EDUCATION



STATESBORO, GA - 29 row by 308' football stadium that seats 4,640. Full Plank decking system. Featuring 198 chairs and three 8' by 30' pressboxes with observation decks. Note the mid-level for egress. Designed by James W. Buckley and Associates, Inc. Manufactured and installed by Southern Bleacher. Photo: Lori Grice

*Southern Bleacher's qualified sales representatives have worked with hundreds of clients in the detailed planning and execution of their venues. Ask your sales representative for project references in your geographic area.*

## ELITE SEAT



*Our Elite Seat was chosen as a "Best New Product" when it debuted. The molded Elite Seat offers a colorful and comfortable option to aluminum benches. It is an affordable enhancement to venues with day long events.*

**We are the industry leader in stadium innovations.**

## VERTICAL RAIL SYSTEM



*Our innovative Vertical Rail is an elegant alternative to standard chain link. It offers the architect a unique element with which to customize.*

## PRODUCT INNOVATIONS

Our Elite Seat is designed for comfort and versatility. It offers a comfortable and colorful option over aluminum plank seating and is easily adaptable for use in existing facilities. The Elite Seat is an economical choice when selecting individual seating options with longevity. Our UV-protected, blow-molded plastic seat is mechanically fastened to the aluminum bench for maximum fan comfort and safety. The Elite Seat is available in a variety of colors.

**Southern Bleacher's innovative Elite Seat and Vertical Rail are great enhancements to any venue.**

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. ■



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OR CALL TOLL FREE:

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## USES / APPLICATIONS

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.

**With over 60 years of experience, the knowledgeable experts at Southern Bleacher understand the myriad of unique challenges posed by sporting venues.**

Want to see more world class projects? 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 the address below. 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 with your client and their fans. ■



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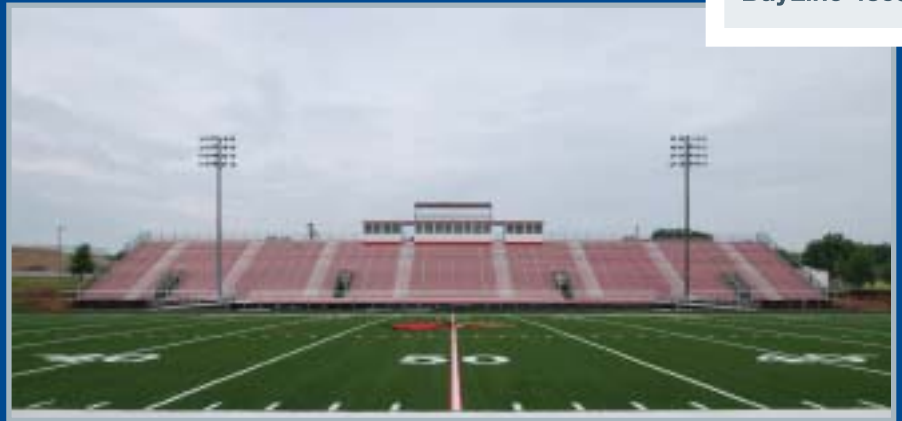
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OR CALL TOLL FREE:

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BuyLine 4853



### WEBB CITY R-7 SCHOOL DISTRICT

WEBB CITY, MO - 26 row by 300' home side football stadium that seats 4,100. IL2k decking system. Two 8' by 18' pressboxes and one 8' by 36' pressbox with canopy. All three have sloped fronts. Designed by Patterson Latimer Jones Brannon Denham, Inc. Manufactured and installed by Southern Bleacher. Photo: Tom Ewart/NWA Photography

**Southern Bleacher's over 60 years of experience wins hands down over our competitors.**

### RICHARD M BORCHARD REGIONAL FAIRGROUNDS



CORPUS CHRISTI / ROBSTOWN, TX - Top: 10 row by 177' Leg Truss bleacher that seats 872. IL2K decking system. Designed by Bullock Smith & Partners. Manufactured and installed by Southern Bleacher. Photo: Jeff Cave Photography

*Home arena of the Corpus Christi Hammerheads,  
a member of the Intense Football League.*

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## DECKING OPTIONS



INTERLOCK 2000



TONGUE AND GROOVE 2001



CLOSED-DECK ALUMINUM



FULL-PLANK

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

## SEATING OPTIONS



PLASTIC MOLDED CHAIR



DUCHARME CHAIR



SOBCO 5000 CHAIR



BENCH SEATING with OPTIONAL BACKRESTS

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



ELITE SEAT

## COMPONENTS PARTS DECKING

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 1/2" 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. ■

**We are the industry leader in decking and seating innovations.**

## COMPONENTS PARTS SEATING

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.

STADIUM CHAIRS: The SOBCO 5000 Series Aluminum Chair features armrests and a standard manual-rising seat bottom. Our many options include six standard widths, riser or floor mounts, and clear anodized or colored finishes in standard or custom colors.

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: See page seven for our newest seating innovation. ■



## 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-dipped 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; stadium chair options include the SOBCO 5000 Series Aluminum Stadium Chair and plastic chairs from select vendors.

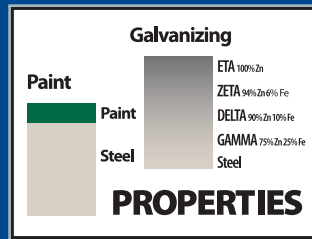
COATINGS/SURFACES: Standard and custom paint colors are available on our aluminum stadium chairs, seat planks, backrests and riser planks. Pigmented, organic coating meets the Architectural Aluminum Manufacturers Association spec. 603.8-92.

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

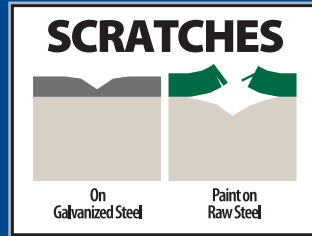
OPERATION/MAINTENANCE: We recommend that the Owner conduct annual inspections to ensure safe conditions. A professional engineer or registered architect should also perform biennial inspections based on text from the current NFPA 102-97 Edition.

**We strive to find the best stadium components in addition to our own innovations. Ask us about new products.**

13 34 16/SOU  
BuyLine 4853



*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.*

## Galvanized-Coated Substructure

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. Texas Motor Speedway and the TCU Lupton Baseball Stadium were awarded the prestigious American Galvanizers Association's Excellence in Galvanizing "Most Distinguished Award."

Contact us  
three ways:



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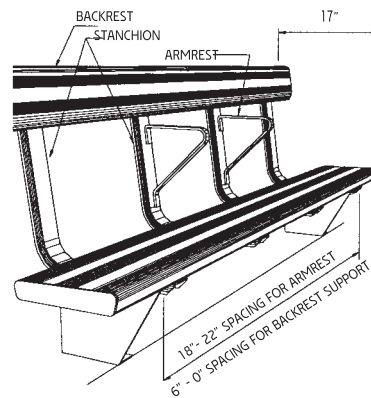
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**Additional aluminum component parts are available.  
Please call us with any technical questions.**

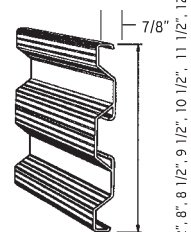
### BENCH SEATING

with Optional Back and Armrests



### RISER PLANKS

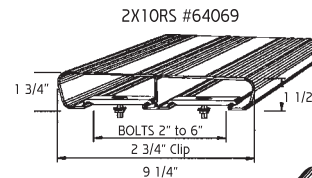
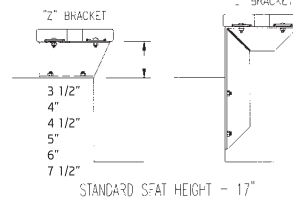
4 1/2"	#69144
6"	#69168
6 1/2"	#69143
8"	#69145
8 1/2"	#69346
9 1/2"	#69097
10 1/2"	#69146
11 1/2"	#69165
12 1/2"	#13498



Riser plank has structural design and contour which provides strength and style.

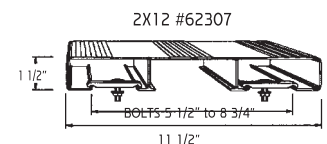
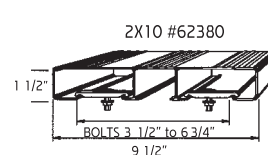
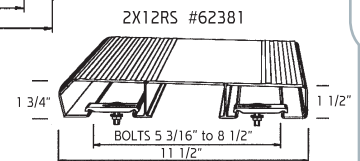
### ALUMINUM SEAT PLANKS

#### BRACKETS



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

Note: Additional aluminum component parts are available. Please call us!



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# Permanent Grandstand Specifications

## 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. Pressbox Support Structure
  5. Pressbox

#### 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/CWB certified; manufacturing capability according to various code compliances.
- 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. Owner confirms the Building Code that applies to this project is \_\_\_\_\_.

#### 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 require maintenance of grandstand to ensure 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. 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. Pressbox Support Structure \_\_\_\_\_ x \_\_\_\_\_ Pressbox \_\_\_\_\_ 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 per \_\_\_\_\_ Building Code with aluminum closure and contrasting aluminum stair nose.
  - b. Stair tread depth: \_\_\_\_\_ inches per \_\_\_\_\_ Building Code.
  - c. Guardrails on Stair to be \_\_\_\_\_ inches above leading edge of step with intermediate rail spacing at \_\_\_\_\_ inches.

- 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 corner. The top of handrails and handrail extensions shall be placed not less than 34 inches or more than 38 inches above the nosing of stairs and landings. Handrails shall be continuous the full length of the stairs and shall extend in the direction of the stair run not less than 12 inches beyond the bottom riser. Ends shall be returned or shall terminate in newel posts or safety terminals.

##### B. 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. (If Applicable) 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.

##### 9. Decking:

- a. Rise per row \_\_\_\_\_ inches, depth per row \_\_\_\_\_ inches.
- b. Each seat 17 inches above its respective tread.
- c. Decking Arrangement:
  - (1) Seats: \_\_\_\_\_ anodized aluminum.
  - (2) Treads: \_\_\_\_\_ mill-finished aluminum.
  - (3) Risers: \_\_\_\_\_ anodized-finished aluminum.
  - (4) Aisle extension: \_\_\_\_\_ mill-finished aluminum.
  - (5) Front walkway: \_\_\_\_\_ mill-finished aluminum.
  - (6) Entry stairs to be 2 x 12 mill-finished aluminum.
  - (7) Entry ramps to be mill-finished aluminum.

##### 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 on sides and back shall include 9-gauge galvanized chain link fencing fastened in place with galvanized fasteners and aluminum ties.

11. Cross Aisles:
  - a. Clear width inches.
  - b. Guardrail to be \_\_\_\_\_ inches above tread with intermediate rail spacing at \_\_\_\_\_ inches.
12. Ramps:
  - a. Slope: 1 in 12.
  - b. Guardrail to be 42 inches above ramp with 9-gauge galvanized chain link fence and 2 x 6 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. Handrails shall be continuous the full length of the ramp and shall extend in the direction of the ramp not less than 12 inches beyond the end of the ramp. Ends shall be returned or shall terminate in newel posts or safety terminals.

##### 11. Cross Aisles:

- a. Clear width inches.
- b. Guardrail to be \_\_\_\_\_ inches above tread with intermediate rail spacing at \_\_\_\_\_ inches.

##### 12. Ramps:

- a. Slope: 1 in 12.
- b. Guardrail to be 42 inches above ramp with 9-gauge galvanized chain link fence and 2 x 6 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. Handrails shall be continuous the full length of the ramp and shall extend in the direction of the ramp not less than 12 inches beyond the end of the ramp. 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, Stanchions, Riser Planks, and Railing are extruded aluminum alloy, 6063-T6.
    - (1) Clear anodized 204R1, AA-M10C22A31, Class II finish.
    - (2) Coating\*:

- 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. Powder-Coated or other paint system meeting AAMA 603.8-92 specifications with a hardness rating of 2H. (Specify color.)

- b. Tread planks are extruded aluminum alloy 6063-T6 mill finish.

##### 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, nonskid black powder-coated finish or other paint system meeting AAMA 603.8-92 specifications with a hardness rating of 2H. Optional: Specify Color.

##### C. Fabrication:

1. Design Load:
  - a. Live Load: 100 psf gross horizontal projection.
  - b. Lateral Sway Load: 24 plf seat plank.
  - c. Perpendicular Sway Load: 10 plf seat plank.
  - d. Live Load of Seat and Tread Planks: 120 plf.
  - e. Guardrail: Per \_\_\_\_\_ Building Code.
  - f. Windload: \_\_\_\_\_.
2. All manufactured connections to be shop welded.
  - a. Manufactured by certified welders conforming to AWS/CWB Standards.

Please call for specifications for your project.

##### Optional Items Available:

- (1) Kynar paint for aluminum products.
- (2) Powder coat for aluminum products.
- (3) Full line of fixed chair seating available in both plastic and aluminum.
- (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 fixed.
  - b. Rows: Numerals or alphabetical letters.
  - c. Seat Numbers: Numerals.

\* Optional with additional cost of materials and design fees.

### 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 improvements.

Specs: custom PG(05/2006)

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**Southern**  
BLEACHER COMPANY Inc.

Southern Bleacher Company



Member Better Business Bureau  
of North Central Texas

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