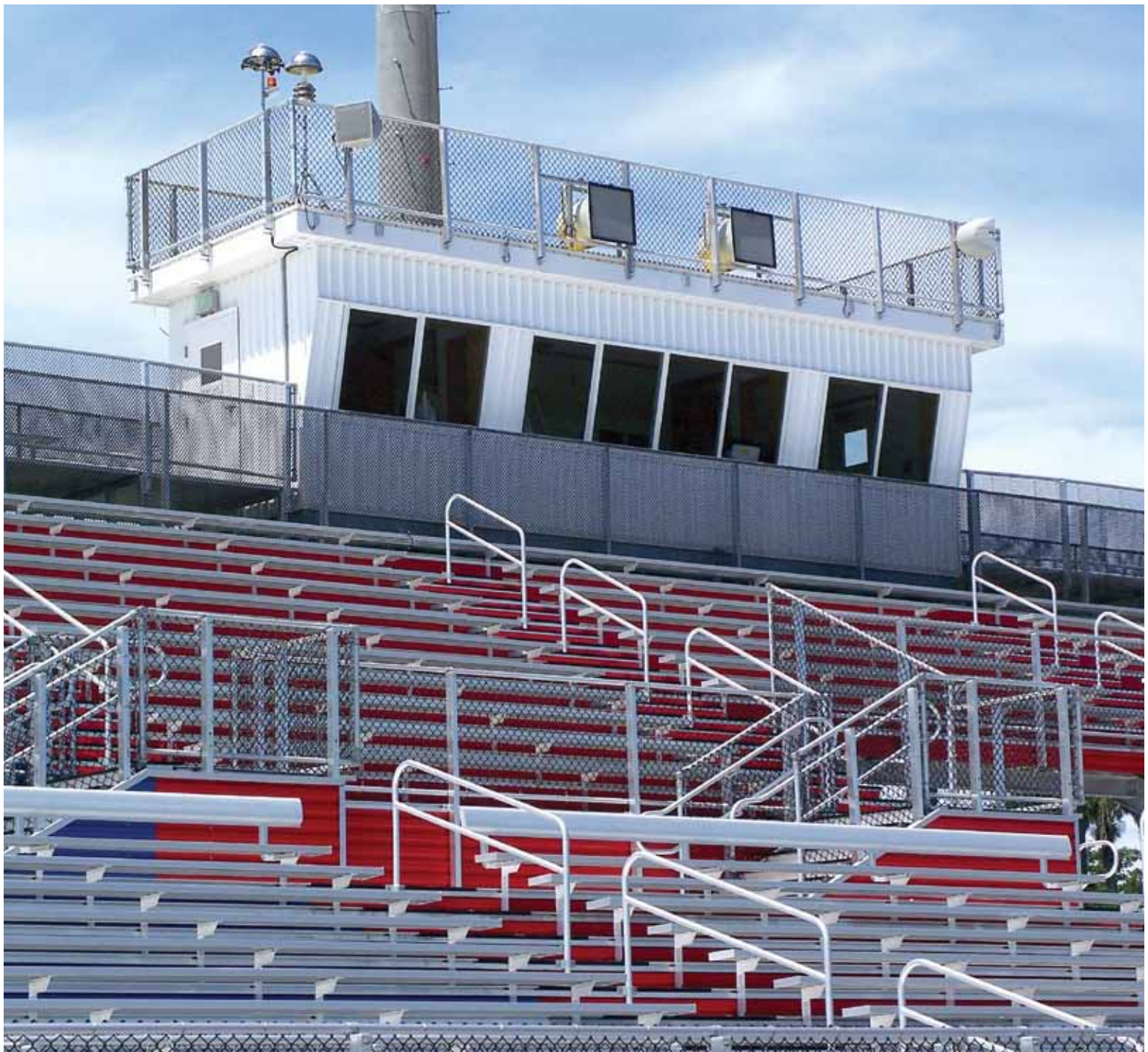
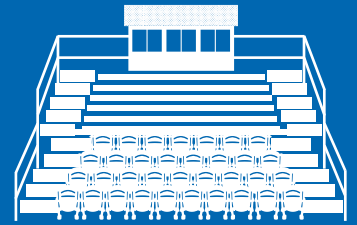


Grandstands

Stadium and Bleacher Solutions



www.allstarbleachers.com



About All Star Bleachers, Inc.

Industry Leader

All Star Bleachers is proud to have been offering complete, innovative seating systems and services since 1946. Our wide range of capabilities include far more than the design and fabrication of individual projects. All Star Bleachers offers full technical support from the initial design stages of planning through all phases of engineering, fabrication and construction.

Our grandstands are custom-designed and incorporate features such as All Star Bleachers' Champion™ line of stadium and arena seating, tiered seating areas, press boxes, and free-standing or integrated roofs. These grandstands are in use at many high schools and universities, as well as in motor speedways such as those located in Daytona, Talladega and Darlington.

Images of All Star Bleachers manufacturing facility located in Lakeland, FL.



Cover Image: Pahokee High School football grandstand, located in Pahokee, Florida, features red and blue powder coated risers and seats 3,066 spectators.



Our Facility

All Star Bleachers has designed and engineered the highest quality seating system solutions in our 55,000 square foot manufacturing facility, located in the heart of Florida, for over 50 years.

Today, All Star Bleachers employs 50 full time team members including a department of designers with support of professional structural engineers.

All Star Bleachers strives to provide excellent service, products and on-time performance. For the most advanced products and services available in the aluminum bleacher industry, turn to All Star Bleachers.

Customer Service

All Star Bleachers' Customer Service staff is a customer friendly, knowledgeable team that is dedicated to excellence in service delivery and communication. The team is based out of All Star Bleachers' Lakeland, FL headquarters utilizing state-of-the-art manufacturing software system.

Our goal is to provide professional, courteous, timely and accurate service to every customer in a fair, consistent and accessible manner. All Star Bleachers' distributor partners and customers are our number one priority.



Contents



QuickShip Program 8 Strategic Locations

All Star Bleachers leads the industry in delivering affordable, quality seating products...Quick, with reduced shipping costs. This is accomplished by producing standard bleachers, Champion seating, and team benches in bulk and warehousing them at eight QuickShip Distribution Centers.

- 3 to 5 row bleachers in 4 different lengths
- bleacher tip-n-roll kits and tow kits
- 3 team benches in 3 different lengths



Grandstands

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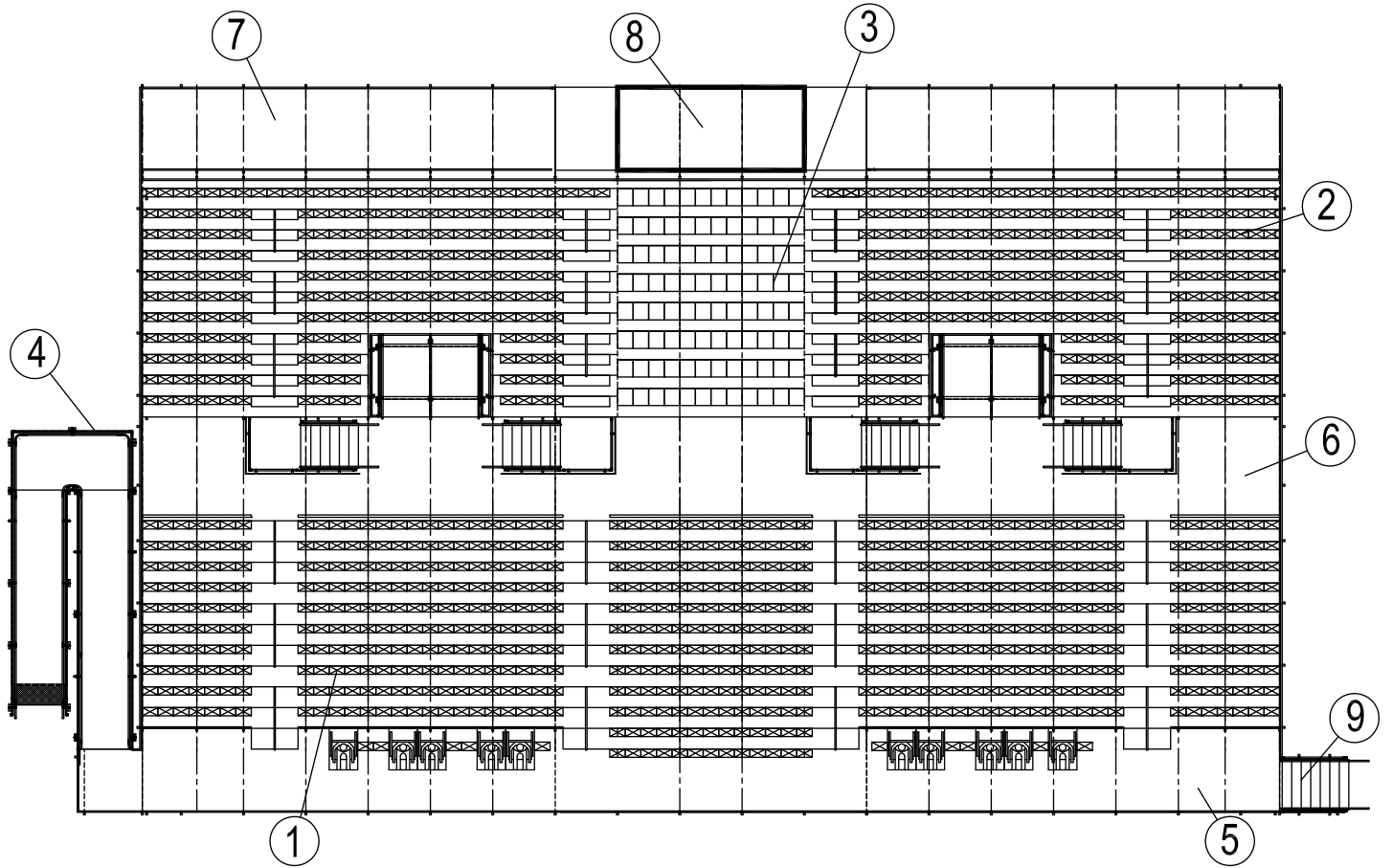
Leadership in Energy and Environmental Design

LEED initiatives drive the construction of environmentally sound and sustainable projects more than ever before. While the US Green Building Council does not certify or endorse individual products or materials, how they're made and where you source them can help your project meet its LEED certification objective.

Generally speaking, our aluminum products contain from 80% to nearly 90% total recycled content and our steel products contain approximately 85% total recycled content.

Grandstands

Plan View

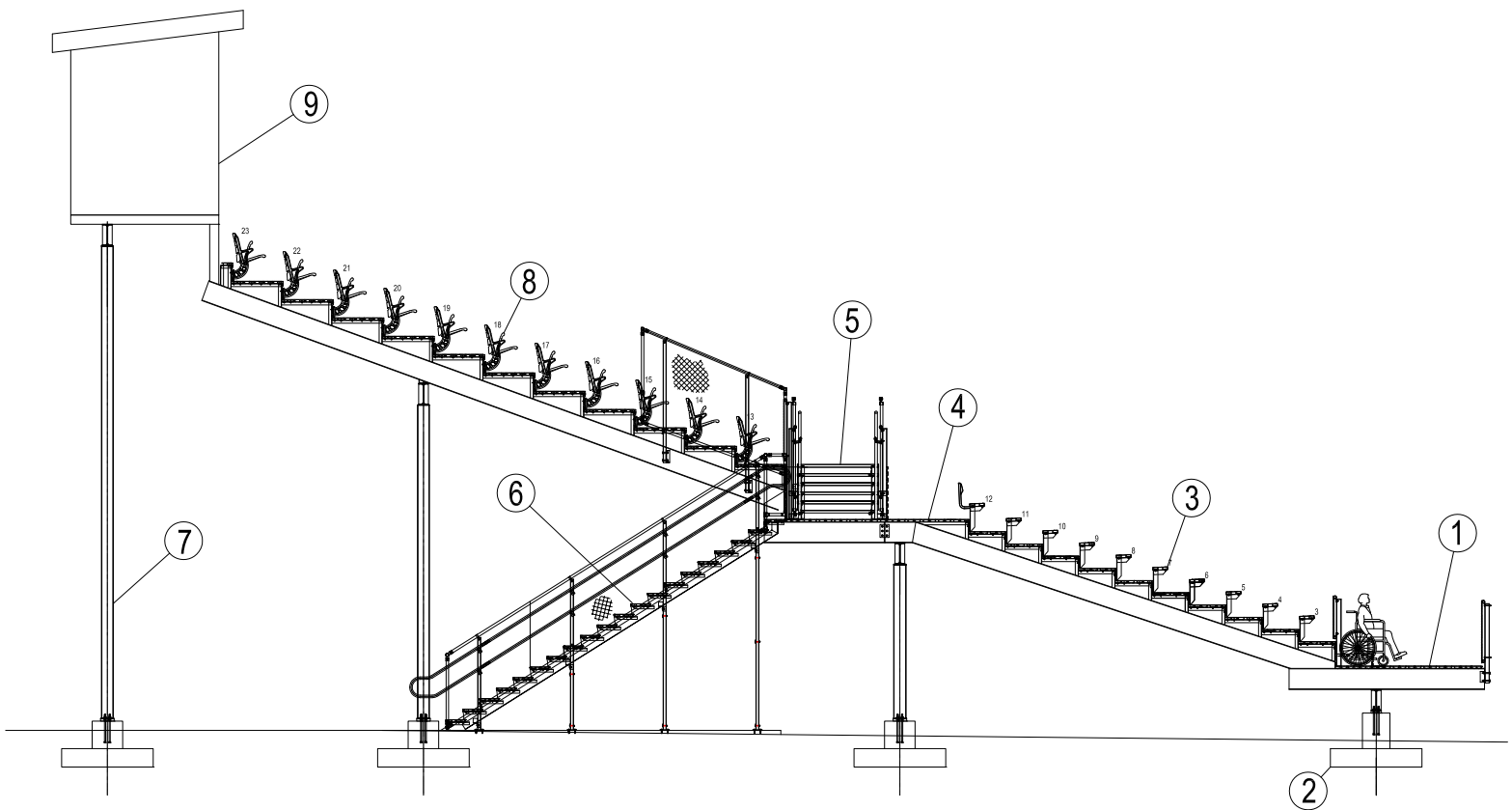


KEY

1. Standard 8/24 seating
2. Standard 12/24 seating
3. VIP 12/33 seating
4. Ramps
5. Front walkway
6. Mid cross walkway
7. Rear walkway
8. Press box
9. Stair



Grandstands Elevation Model



KEY

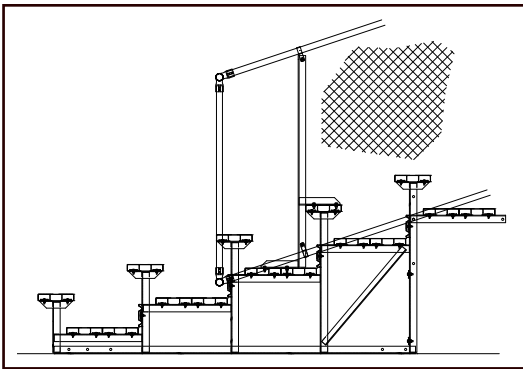
1. Front walkway
2. Foundations
3. Standard 8/24 seating
4. Mid cross walkway
5. Stair
6. Vomitory
7. Column
8. VIP 12/33 seating
9. Press box

Design Options

Elevation

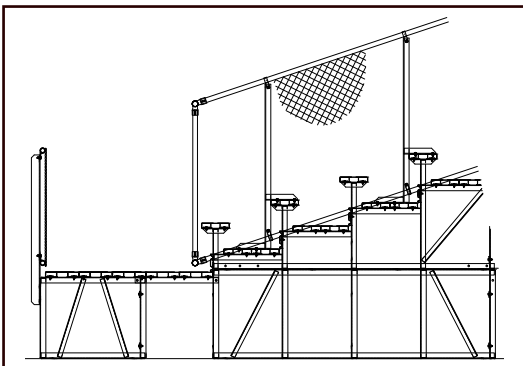
Non-elevated

Non-elevated bleachers are designed so that those seated on the first row place their feet on the ground. Non-elevated bleachers are typically the most affordable option.



Elevated

Elevated bleachers are raised off of the ground allowing for crosswalks, vomitories, and ADA ramps. Elevated bleachers offer a better, elevated view.



Design Options Under Structure



Angle Frame

Available in elevated and non-elevated versions, All Star Bleachers' permanent angle frame bleachers offer maximum strength and low maintenance cost.

Angle Frame bleachers are either attached to a concrete foundation or can be anchored using earth anchors. All units must be anchored to meet wind load requirements and require a level site.

This seating option also gives the freedom of expansion as seating needs grow.



I-Beam

All Star Bleachers design custom I-Beam structures that deliver long life, low maintenance and a great visitor experience.

Columns are typically placed 18 feet apart but design options can accommodate concessions, restrooms and other storage facilities under the stadium. I-Beam structures are fabricated from wide flange steel shapes, hot-dipped galvanized after fabrication, and are anchored to concrete foundations.

These structures offer the most design flexibility. The design could be adapted to accommodate site and terrain configurations.

Design Options

Decking

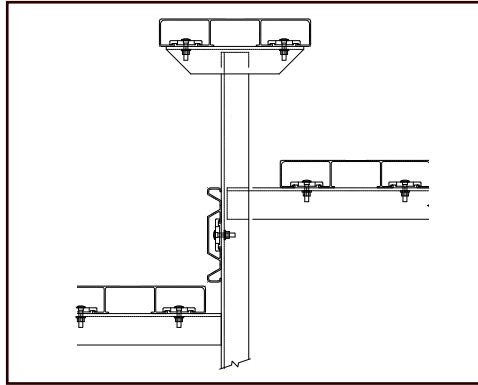
Semi-Closed Deck. Consists of a seat plank, tread planks and a riser plank arranged to reject a 4" sphere. Size of tread/riser planks depends upon desired riser height and tread depths. Tread plank vertical height: 1.75".

Closed Deck. Consists of a tread-mounted seat plank and a combination of tread or riser mounted planks to form a completely closed riser and tread. Tread plank vertical height: 1.75".

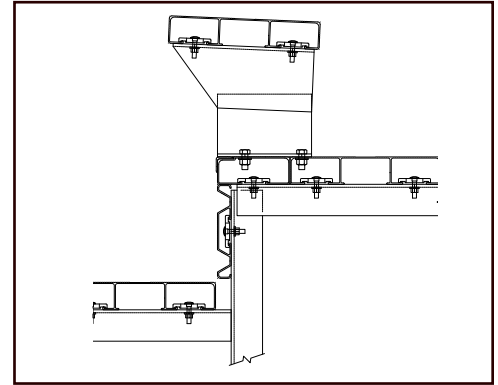
Non-Penetrating Interlocking Deck. Provides deck attachments without penetrating the aluminum extrusions. All attachments can be installed from above. Can be incorporated into the welded deck system.

Interlocking Deck. Used to stiffen 1.5" vertical-height planks. The extrusion includes a lock joint feature, which joins the planks to each other.

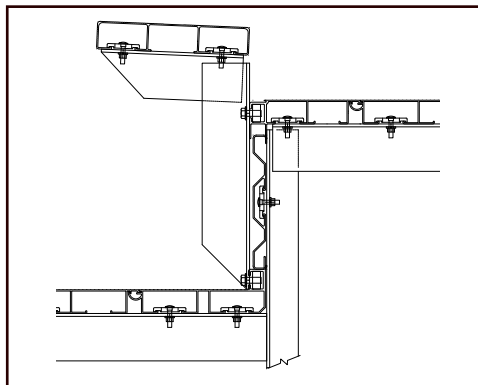
Welded Deck System. Consists of a tread or riser-mounted seat plank with a combination of interlocking riser inserts. The tread planks are longitudinally shop welded, forming rigid, drip-free panels. Tread plank vertical height: 1.5".



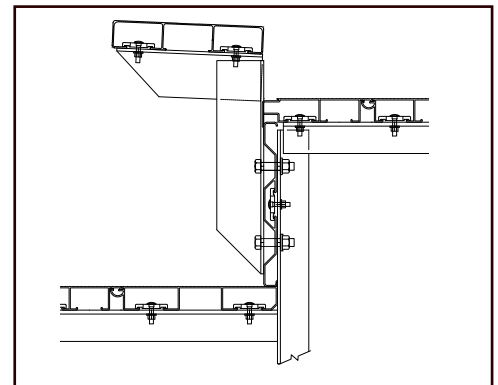
Semi-Closed Deck



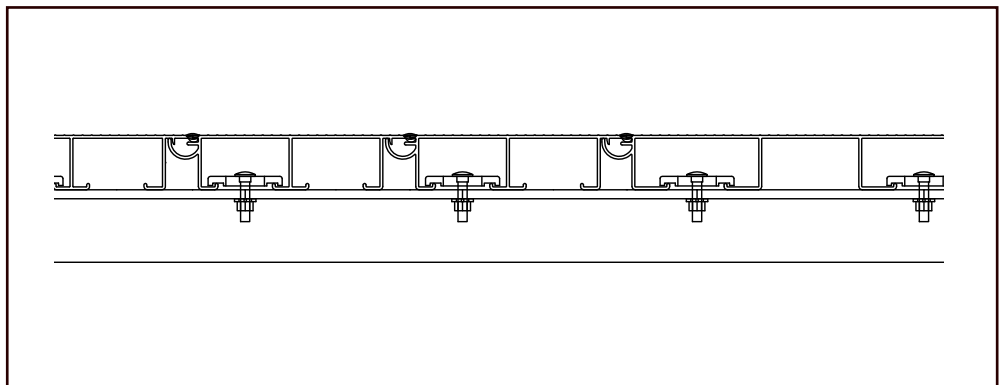
Closed Deck



Non-Penetrating Interlocking Deck



Interlocking Deck



Welded Deck



Design Options

Fencing and Closure Panels



Powder Coated Aluminum Picket Rail



Galvanized Chain Link Fence



Vinyl Chain Link Fence



Powder Coated Aluminum Closure Panels



Poly Closure Panels



Aluminum Anodized Closure Panels

Design features can be added to grandstands and bleachers to create a custom look. These enhancements allow the seating system to fit in perfectly with the overall design scene.

All Star Bleachers' designers and engineers can assist in customizing grandstands and bleachers by utilizing various guardrail and fencing options as well as a variety of closure panels. Finish options include galvanized steel, anodized and powder coated aluminum.

Options and features include:

- Picket Guardrails
- Chain Link Fence
- Closure Panels
- Powder Coated Risers and Backrest
- Contoured Seating Plank

Champion™ Stadium and Arena Seating

The Champion line of stadium and arena seating is the industry's newest state-of-the-art, solid injection molded polypropylene. Our engineers have developed winning designs that are both lightweight and strong. We use the same high-impact plastic that the automobile industry uses to manufacture car bumpers, not hollow plastic shells like other seating manufacturers.

Whether your system is made of steel, aluminum, concrete, or wood; the Champion line can be securely mounted to most surfaces.

Champion seating is:

- Manufactured in the USA
- Solid injection molded
- Fade resistant with maximum U.V. inhibitors
- Constructed with non-corrosive hardware



hollow
construction



solid
construction



Stadium



Arena



Bleacher



Sport



Quarterback



Spectator



Champion™ Stadium and Arena Seating



Solid Injection Molded

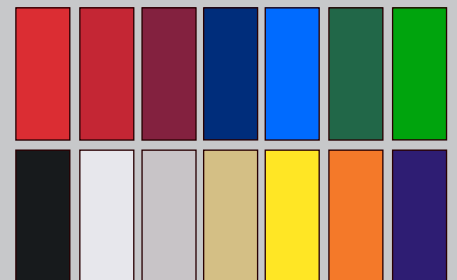
All Star Bleachers is proud to lead the stadium and arena seating industry with our solid injection molded Champion line. While blow molded seats are the most common option in the industry, we believe it is important to not only offer a seat with a modern design but one that can withstand the harshness of varying environmental elements and wear from spectators.

While solid injection molded products may require a more significant commitment initially, the Champion line of stadium and arena seating is designed and tested to provide enduring comfort and long-lasting durability.



14 Designer Colors

The entire line of Champion seating is available in 14 standard colors. If your design requires a color outside of our standard colors, custom colors are available.



Design Options

Press Box

Press Boxes

All Star Bleachers offers a wide variety of press boxes for local, national, or international media to cover game day and record the events as they happen.

Features include:

- Customized interiors reflect the individual needs of the client
- Prefabricated so most sizes can be delivered to job site in one piece
- Easy installation with crane
- Sizes vary from 12' to 60' with larger sizes available if needed
- Depth of press box can be designed to meet specific client requirements
- Complies with all state pre-approval and inspection requirements
- Designed to meet International Building Code & National Electric Code

Optional upgrades include:

- Filming platforms with steel railing and protective roof
- Covered exterior patios
- Slanted and/or non-reflective windows
- Interior elevated spectator platform



Services Design



image courtesy of Barnes and Company, Architects

All Star Bleachers is committed to providing guidance and offering our vast project experience and design expertise from the initial project idea to construction. Whether it's a football stadium or raceway arena, professional sports association or local fairgrounds, no matter the required seating capacity, or site conditions, All Star Bleachers provides comprehensive design services that turn ideas into reality.

In addition to budget estimates and proposal drawings, All Star Bleachers can assist in creating revenue generating features to your venue such as the Champion™ line of stadium and arena seating or VIP suites.

- **Custom Design**
- **Value Engineering**
- **Design Build Processes**
- **Budget Estimates**
- **Design Proposals**
- **Pre-Construction Services**
- **Proposal Drawings**

Services

Project Development

All Star Bleachers is dedicated to engineering and manufacturing the highest quality spectator seating systems using the most cutting edge technology available in the market today.

Our experienced and qualified team members represent over 75 years of cumulative experience in engineering custom bleachers and grandstands. They have engineered seating solutions for a wide range of clients, including private and public schools and universities, municipalities, federal agencies, youth advocacy agencies, as well as contractors and architects.

All Star Bleachers' physical plant is state of the art in the bleacher and grandstand industry with an immense raw materials inventory and QuickShip capabilities.

Our bleachers and grandstands are fabricated by our certified and experienced fabrication team.

- **Engineering**
- **Engineering Drawings**
- **Project Schedules**
- **Project Management and Coordination**
- **Fabrication/Manufacturing**



Services Construction



In addition to designing, engineering, and manufacturing the highest quality spectator seating systems, All Star Bleachers provides complete Construction Management and Administration services. All Star Bleachers can provide owner representation during the construction phase, coordinate submittals, change orders and monthly invoicing.

Our expertise includes establishing and maintaining quality control and providing detailed progress reports, keeping the entire project team fully informed of the project status and providing complete close-out documentation.

All Star Bleachers also provides installation, expansion, renovation, and ADA refurbishment services. Whether it's a new installation or an extensive renovation to an existing structure, All Star Bleachers can assist in the design and construction of any size project.

- **Construction Management and Administration**
- **Installation**
- **Concrete Foundations**
- **Expansion and Renovation**
- **ADA Refurbishing**

Specifications

Grandstands

PART 1 GENERAL

1.1 SYSTEM DESCRIPTION

- A. Provide labor, material, equipment and supervision necessary to design, fabricate and install permanent steel grandstands including the following:
1. Steel Substructure
 2. Decking System
 3. Concrete Foundations
 4. Press Box Support Structure
 5. Press Box

1.2 QUALITY ASSURANCE

- A. Manufacturer: All Star Bleachers, Inc. 6550 New Tampa Highway Lakeland, FL 33815, (800) 875-3141 or (863) 687-3141 Fax: (813) 628-4254
- B. Manufacturer Qualifications: Manufacturer must have ten years experience in the manufacture of bleachers and grandstands; welders must be AWS certified.
- C. Installer Qualifications: Factory trained and experienced in the proper installation of grandstands.
- D. Source Quality Control: Mill Test Certification

1.3 SUBMITTALS

- A. Manufacturer's product data: Submit manufacturer's descriptive product data for project.
- B. Shop Drawings: Manufacturer to submit shop drawings sealed by registered professional engineer and schedules for type, location, quality, and details of steel and aluminum components required for the project.
- C. Certificates:
1. Insurance Certificate
 2. Bid Bond
- D. Product Sample: Submit one 18-inch seat sample.
- E. Color Sample: If applicable, submit sample.

1.4 SITE CONDITIONS

- A. Field Sites:
1. Owner to make site accessible
 2. Owner to verify locations and bench marks
- B. Underground utility Line: Owner to clearly mark all underground utilities and obstructions.
- C. Soil Report: Furnished by Owner

1.5 WARRANTY

All Star Bleachers, Inc. warrants its permanent grandstand to be free from defect in materials and workmanship in the course of manufacturing for a period of one year beginning at Date of Substantial Completion of projects installed by All

Star Bleachers, Inc. or beginning at Date of Initial Delivery of product for projects installed by others. Installation of said products by All Star Bleachers, Inc. personnel or proper installation by others is covered by the one-year warranty. This warranty excludes any other defects resulting from abnormal use in service, accidental or intentional damage or any occurrences beyond All Star Bleachers, Inc. control.

PART 2 PRODUCTS

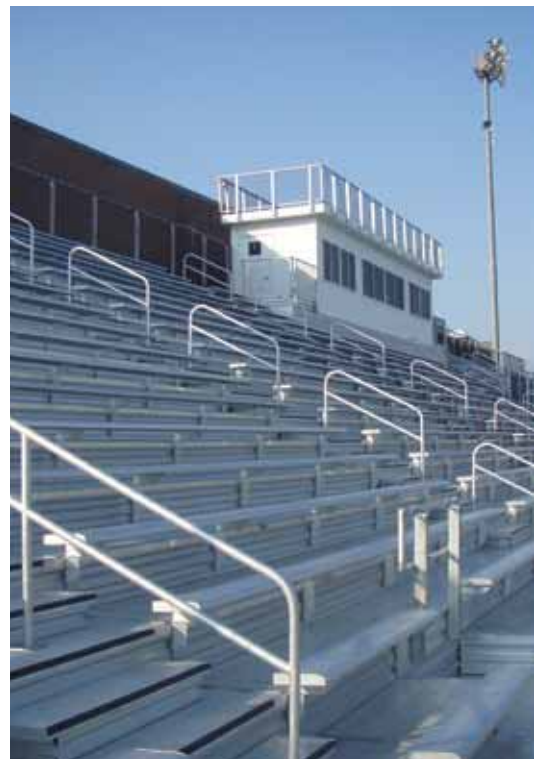
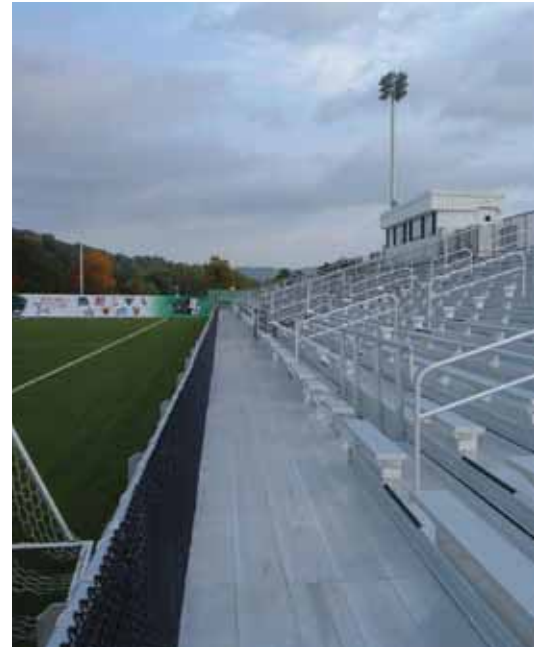
2.1 ACCEPTABLE MANUFACTURER

- A. All Star Bleachers, Inc.

2.2 PERMANENT STEEL GRANDSTAND

A. Product Description:

1. Clear Span, I-beam: Vertical columns are placed 18' on center laterally and "as required" on center front to back. All horizontal beams are wide flange. Traverse bays are free of cross-bracing the total length of the grandstand.
2. Stringers: Stringers are wide flange with angle rise and depth fabrication and are placed at 6' on center.
3. Front walkway: 54" in clear depth, elevated 4' above grade. Each seat is 17" above it's respective tread.
4. Entry Stairs: Provide entry stairs to conform to local codes.
5. Aisles: Width of aisles is 48" or conforms to local codes.
6. Decking: Standard Rises: 8", 9 3/4", 11 1/4" or 13 1/4". Recommended tread depths: Chairs, 33", Bench Seating with backrest, 30", Bench Seating, 26".
 - a. Semi-Closed Deck
 - b. Closed Deck
 - c. Non-Penetrating Interlocking Deck
 - d. Interlocking Deck
 - e. Welded Deck
7. Guardrailing: To be at all sides of bleacher, entry stairs and ramps, portals and landings. Railing shall be 1 5/8" O.D. anodized aluminum pipe with end caps at ends of straight runs and elbows at corners. All guardrails shall be secured to angle risers by galvanized fasteners. Railing shall be 42" above walkways and entrances. Railing shall be 42" above the center of any adjacent seat. Guardrailing shall include 9 gauge galvanized chain link fencing fastened in place with aluminum ties.



Specifications

Grandstands



8. Press Box:
 - a. Press Box can be independently supported, but support structure is connected to grandstand.
 - b. Press Box: Specifications available upon request.
9. Handicap Provision: Design to incorporate ramps and wheelchair spaces within the grandstand system in accordance with applicable building codes and ADA.
- B. Materials/Finishes:
 1. Substructure: ASTM steel only
 - a. Galvanized Steel: Structural fabrication with ASTM-A36/A992 steel. Shop connections are seal welds. After fabrication all steel is hot dipped galvanized to ASTM-A123 specifications.
 2. Seating/Planking:
 - a. All Star Bleachers' Champion Stadium and Arena Seating and Stanchions: Solid injection molded polypropylene.
 - b. Seat Planks, Riser Planks, Backrest: Extruded aluminum alloy, 6063-T6 clear anodized 204R1 finish. Optional Finish: Powder coated colors.
 - c. Tread Planks: Extruded aluminum alloy, 6063-T6 mill finish.
 - d. Joint Sleeve Assembly: Extruded aluminum alloy 6063-T6, mill finish.
 3. Accessories:
 - a. Channel Fit Caps: Aluminum alloys, 6063-T6, clear anodized 204R1, AA-M10C22S31, Class II.
 - b. Hardware:
 - 1) Bolts, Nuts: Hot-dipped galvanized.
 - 2) Tie down clip assembly: Aluminum alloy 6061-T6.
 - 3) Structural Hardware: Hot-dipped galvanized ASTM-A325. No connections are classed as slip critical.
- C. Fabrication:
 1. Design Load:
 - a. Live Load: 100 p.s.f. 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 Local code
 - f. Wind Load: Per Local code
 2. All connections made in shop to be shop welded.
 - a. Manufactured by certified welders conforming to AWS standards.

2.3 ANGLE FRAME BLEACHERS

- A. Product Description
 1. Frames are spaced 6'-0" on center and are laterally joined by cross-bracing as required to satisfy design loading.
 2. Units are offered in standard 3, 4, 5, 10, and 15 row elevated and non-elevated units. Standard widths are 15', 21', and 27'. Custom units are available in other widths.
 3. Transportability: 3 and 4 row units can be equipped with 4" non-marring castors to allow the bleacher to be tipped and rolled away. 3, 5, 10, and 15 row units can be equipped with a wheel set (4.80 x 12 tires) and galvanized steel tongue which will allow the units to be towed. 2" x 6" pressure treated mudsills are required for site conditions with poor soil bearing capacity.
 4. For elevated units: Front walkway is 54" in clear width, elevated 30", 36", 42" or 48" above grade.
- B. Materials/Finishes
 1. Substructure:
 - a. Galvanized Steel Angle: Structural fabrication with ASTM-A36 steel. Shop connections are seal welds. After fabrication all steel is hot dipped galvanized to ASTM-A123 specifications.
 2. Aluminum Angle: Structural fabrication with mill finish, aluminum angle (6061-T6 alloy) Shop connections are welded to AWS D1.2 certifications.

PART 3 EXECUTION

3.1 INSTALLATION

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

3.2 FIELD QUALITY CONTROL

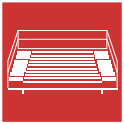
- A. Foundation: Footings for the grandstand shall provide sufficient bearing area at bottom to support all loads of the grandstand. Depth and design of footings shall be determined by local soil conditions. Hot-dipped galvanized anchor bolts shall be secured in the concrete footings. Concrete shall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

3.3 CLEAN-UP

- A. Clean up all debris caused by work of this section.

All Star Bleachers

Products and Services



Bleachers

All Star Bleachers manufactures a wide variety of standard code bleachers. Perfect for indoor and outdoor use, All Star's bleachers are ideal for gymnasiums, indoor or outdoor basketball, volleyball, swimming pools, tennis courts, softball and soccer. These bleachers are durable, economical, and maintenance-free, ideal for fields and playing courts of any kind. Available framing in galvanized steel or lightweight aluminum at standard lengths of 7'6", 15', 21' and 27'. Custom lengths are also available.



Grandstands

All Star Bleachers creates grandstand solutions that deliver long life, low maintenance, and a great visitor experience for clients ranging from high schools to professional sports associations. These grandstands are designed to seat hundreds to tens of thousands. All Star Bleachers offers full technical support from the initial design stages of planning through all phases of engineering, fabrication and construction.



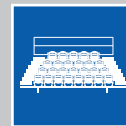
Press Boxes

All Star Bleachers offers a wide variety of press boxes for local, national, or international media. They are prefabricated and can be delivered to the project site in one piece and customized interiors reflect the individual needs of the client.



Services

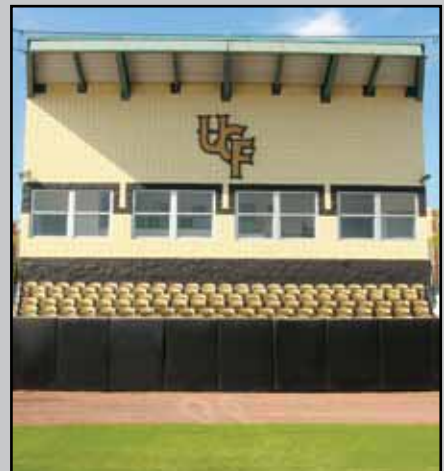
All Star Bleachers can help with the renovation, expansion, or refurbishment of your tired and worn stadium from any manufacturer. Whether you need to expand by adding traditional bleachers or want to upgrade to stadium seating, All Star Bleachers can assist in the design and construction of any size project.



Stadium Seating

All Star Bleachers' Champion line of stadium seating is the industry's newest state-of-the-art, solid injection molded polypropylene. We use the same high-impact plastic that the automobile industry uses to manufacture car bumpers, not hollow plastic shells like other seating manufacturers.

With 6 seating options, we are confident that the Champion series will meet any application requirement or price point.



Metal Fabrication Group

Corporate Information



Industrial Manufacturing Company (IMC)

The parent company of All Star Bleachers and its affiliates in the Metal Fabrication Group is Industrial Manufacturing Company (IMC). IMC and its international arm, IMCI, are a proud family of companies that produce a wide variety of innovative products for industry. With more than 3,500 employees and 30 worldwide manufacturing, sales and distribution facilities, it produces aircraft and aerospace ducting systems, gears, lubrication systems, bleachers, steel and plastic lockers, storage systems, steel mezzanines, high-performance strainers, car and truck components, industrial hoses and industrial expansion joints.

Although each IMC and IMCI company operates independently, common to all of them is a profound respect for the integrity of established industrial principles and a practical openness to applications of new technology. With individual histories spanning decades – and in two cases more than a century – the IMC and IMCI companies are time-tested leaders in their national and global markets.

Each IMC and IMCI subsidiary strives to tailor its products and services to the wishes of its customers, and each company's success has been built on the development of enduring customer relationships. They take pride in providing not only products of consistently high quality, but also in flexible and responsive service and in realistically competitive prices.

Penco Products, Inc.

Penco Products, Inc. is a leader in the design, engineering and fabrication

of storage products and accessories. With over 135 years of experience manufacturing metal storage products, our products are built to the highest standard of fit, finish and function. When it comes to lockers, Penco offers the broadest range of steel and plastic lockers. All Penco lockers are manufactured in the United States.

Visit www.pencoproducts.com

Schmidt Structural Products, Inc.

For over 40 years, Schmidt Structural Products, Inc. (formerly W.A. Schmidt) has designed, manufactured and installed structural steel mezzanines to vertically expand floor space quickly and economically. A mezzanine can double or even triple existing space at up to 80% less than the cost of a building addition.

Visit www.schmidtstructural.com

Quality Metal Products

Established in 1958, Quality Metal Products (QMP) is located in the West Midlands, the historical heartland of manufacturing in the UK. QMP designs and manufactures storage equipment and outdoor shelters for use in the workplace. Its metal fabricated products include lockers, storage cabinets, modular drawers, work benches, bicycle racks and shelters. Market sectors served by QMP include educational, health, and government facilities, as well as offices, manufacturing companies, retail outlets, sports arenas and community parks.

Visit www.QMP.uk.com



www.allstarbleachers.com



A View to all the Action

All Star Bleachers is proud to have been offering complete, innovative seating systems and services since 1946. All Star Bleachers offers full technical support from the initial design stages of planning through all phases of engineering, fabrication and construction.

All Star Bleachers strives to provide excellent service, products and on-time performance. For the most advanced products and services available in the aluminum bleacher industry, turn to All Star Bleachers.



Corporate Headquarters/ Manufacturing Facility

6550 New Tampa Highway
Lakeland, FL 33815
800.875.3141

QuickShip Distribution Centers

Midwest

Indiana QuickShip
2602 Innovation Court
Fort Wayne, IN 46818

West

Utah QuickShip
4080 West Farm Road
Salt Lake City, UT 84088

Northeast

Pennsylvania QuickShip
3820 Hempland Road
Mountville, PA 17554

Southeast

North Carolina QuickShip
1301 Penco Drive
Hamilton, NC 27840

South

Tennessee QuickShip
5355 Distriplex Farms Drive
Memphis, TN 38141

Florida QuickShip
6550 New Tampa Highway
Lakeland, FL 33815

Texas

Texas QuickShip
6615 Roxburgh, Suite 200
Houston, TX 77041

North

Canada QuickShip
6460 Kennedy Road, Unit B
Mississauga, ONT L5T2X4

ALL STAR BLEACHERS, INC.

PHONE: 800-875-3141 • FAX: 813-628-4254 • E-MAIL: info@allstarbleachers.com



Mixed Sources

Product group from well-managed forests, controlled sources and recycled wood or fiber

www.fsc.org Cert no. BV-COC-05471
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Grandstands 01-10 ASB