# Bleacher Specifications

Non-Elevated Aluminum Angle Frame

**SECTION 13125**

**NON-ELEVATED ALUMINUM ANGLE FRAME BLEACHERS**

**PART 1 - GENERAL**

**1.01 SECTION INCLUDES**

A. Design and fabrication of Non-Elevated angle frame bleachers

**1.02 QUALITY ASSURANCE**

A. Distributor: BuiltRiteBleachers.com
5077 Northampton Drive, Fort Myers, FL 33919

B. Manufacturer Qualifications: Manufacturer must have a minimum of ten years experience in the design and manufacture of bleachers.

C. Welders must conform to AWS standards.

D. Source Quality Control: Mill Test Certification.

E. Codes and Standards: 2012/2015 International Building Code / ICC 300 2012.

**1.03 WARRANTY**

A. Warranty shall guarantee bleachers to be free from defect in materials and workmanship for a period of 1 year under normal use. Warranty period shall begin on date of completion for projects installed by manufacturer, or its subcontractors, **OR** warranty period shall begin on date of final delivery on projects installed by others.

B. Anodized finish of plank extrusions shall be covered by a **5 year** warranty against loss of structural strength or finish deterioration due to exposure to weather conditions or UV rays. Discoloration of mill finish aluminum due to galvanic reaction not covered.

**1.04 PRODUCT LIABILITY INSURANCE**

A. Product liability insurance is carried for the life of the product in the amount of $ 2,000,000.

**1.05 ENGINEERING**

A. Engineering certifications and calculations by a Registered Professional Engineer will be provided upon request at an additional fee.

**PART 2 – PRODUCTS**

**2.01 ACCEPTABLE DISTRIBUTOR**

A. BuiltRiteBleachers.com

**2.02 DESIGN**

A. Applicable Codes:
INTERNATIONAL BUILDING CODE (IBC), 2012/2015 EDITION / ICC 300 2012
Except aisle and handicapped requirements

B. Design Loads:

1. Live Loads: Uniform loading - Structure = 100 psf
Uniform loading - Seat and Foot plank = 120 plf
2. Sway Loads: Perpendicular to seats = 10 plf
Parallel to seats = 24 plf
3. Guardrail Loads: Uniform vertical load = 100 plf
Uniform horizontal load = 50 plf
Concentrated horizontal load = 200 pounds
4. ***Wind Loads: Basic design wind speed = 150 mph (exposure “B”)

***Note: Bleacher must be anchored to meet wind loads above**

**2.03 NON-ELEVATED ANGLE FRAME BLEACHERS**

A. Quantity and Size: Shall consist of 1 unit(s) 8 rows high x 21 long.
Net seating capacity per unit 112 (excluding aisles, based on 18" per seat).

B. Framework: Prefabricated aluminum angle spaced at 6' - 0" intervals joined by means of aluminum angle cross bracing.

C. Shop connections: Welded to meet AWS standards and local code requirements

D. Joint Sleeve Assembly: Internal splices, where required shall be two per joint, and shall penetrate the joint a minimum of 8” in each direction and be riveted at one end only to allow for contraction and expansion.
E. Rise and Depth Dimensions: 8” vertical rise and 24” tread depth, Seat height is 17” above its respective tread.
F. Seats: Nominal 2” x 10” anodized aluminum with anodized end caps.
G. Treads: Nominal two (2) 2” x 10” mill finish aluminum with anodized end caps on rows 2 & up.
H. Risers: Nominal two (2) 1” x 6” mill finish aluminum with mill finish end caps on top row.
Nominal 1” x 6” mill finish aluminum with mill finish end caps on rows 4 & up.
I. Guardrail: Rails shall be anodized aluminum vertical picket panels attached to support members. Rear rail support member to be aluminum channel. Side rail support member to be aluminum angles. Standard AA-M10C223A31(204R1). Panels shall consist of 1-5/8" O.D. round tube and extruded aluminum 5/8" square. Panels shall attach to rail support members by means of 5/16" dia. u-bolts, lock washers, and nuts. Panels shall connect together using internal splice and rivet. End panels shall be terminated using aluminum elbows, and aluminum round tube mechanically fastened.

**2.04 MATERIALS / FINISHES**

A. Framework:
1. Aluminum: Structural fabrication with aluminum alloy 6061-T6 mill finish. Each frame shall be unit-welded, using metal inert gas method, under guidelines by the American Welding Society. After fabrication all steel is hot dipped galvanized to ASTM A-123 specifications. All crossbracing and horizontal bracing shall be aluminum alloy 6061-T6 mill finish.

B. Extruded Aluminum:
1. Seat planks: Aluminum alloy 6063-T6, clear anodized 204R1, AA-M10C22A31, Class II With a wall thickness nominally .078" for impact and deformation resistance.
2. Tread and Riser Planks: Aluminum alloy 6063-T6, mill finish. With a wall thickness nominally .078” for impact and deformation resistance.
3. Guardrail Pipe: 1-5/8 OD schedule 40 aluminum alloy 6105-T5, clear anodized 204R1, AA-M10C22A31, Class II.

C. Accessories:
1. Channel End Caps: Aluminum alloy 6063-T6, clear anodized 204R1,AA-M10C22A31,Class II.
2. Hardware: Bolts and Nuts shall be hot dipped galvanized.
3. Hold Down Clip Assembly: Aluminum alloy 6063-T6 mill finish.
4. Joint Sleeve Assembly: Aluminum alloy 6061-T6, mill finish.

**PART 3 – EXECUTION**

**3.01 INSTALLATION**

A. Install bleacher unit in accordance with manufacturer written instructions and shop drawings.

**Note: Building codes may vary from site to site. The customer is responsible for verification of local code requirements.**