

# Southern Bleacher Company: Experience You Can Trust

 **Stadiums • Grandstands • Bleachers**



**WWW.SOUTHERNBLEACHER.COM  
800.433.0912**

## COVER PROJECTS



**Graham ISD**  
Graham, Texas



### DETAILS

Graham High School's Newton Field home side Horizontal Beam foundation grandstand features team color blue risers on each end and three red chair back center sections. Red step risers add contrast. The two 10' x 42' press boxes are completed with a video platform. The top press box's sloped front affords better views. The attached elevator offers easy access. Our Vertical Rail is an option over standard chain link. Home to Steers football, soccer, track and Lady Blues soccer and track, the grandstand seats 2,928 fans. The Newton Field grandstand was designed, manufactured and installed by Southern Bleacher.

*Photo: Glen Davis, Legendary Portraits*



**Delta State University**  
Cleveland, Mississippi



### DETAILS

The newly renovated baseball stadium at Delta State University is a perfect example of our mitered design. The venue features a 12' x 30' press box. With the addition of team color chair seats, press box facade and step risers, even the smallest project is unique. The canopy adds a nice architectural element as well as the practical advantages of protecting from sun or rain. Ferriss Field is the home of Statesmen baseball. The mitered stadium seats 478 fans in superior comfort. The project architect was Singleton Architects, P. A.

*Photo: Wiljax, Inc.*

**Since 1946, Southern Bleacher has set the standard for high school bleachers, college stadiums, fairgrounds, speedways and more. Fans in every U.S. state and Canada cheer from our grandstands.**

With more than three million seats to our name in the past five years alone, no one comes close to our experience. Financially sound with no influence from investors, our customers rest easy knowing we'll be here for decades to come. By not outsourcing our aluminum or steel fabrication, we control both quality and schedule, and a veteran project manager is your single point of contact, your advisor and ally, from your complimentary design through your stadium build and beyond. 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 first class stadiums, grandstands and bleachers for your budget. ■



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## PROFESSIONAL SOCCER



The number of U.S. high school soccer players more than doubled between 1990 and 2010, and by 2006, there were four million youth playing soccer in America - more than anywhere else in the world. Last year, high school soccer was the #4 sport for boys and overtook softball to become the #3 sport for girls.

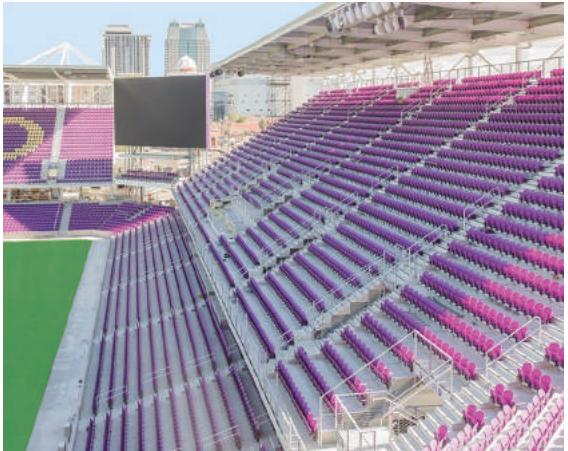
In addition to the many secondary school, collegiate and municipal park grandstands, Southern Bleacher has been building professional soccer stadiums since 1999.



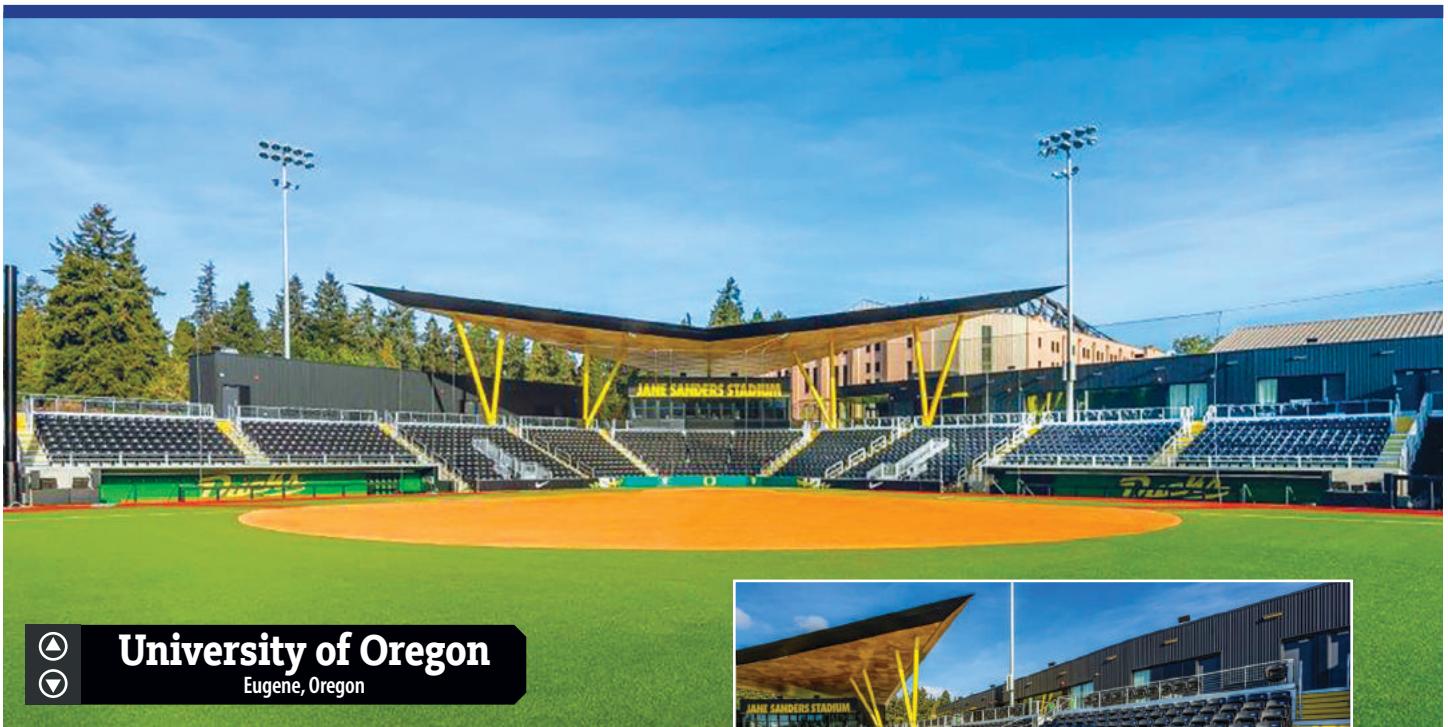
### DETAILS

The Orlando City Soccer Club's 25,500 seat complex is modeled after English premier league stadiums. Fan feedback was enlisted in the stadium design, which includes a supporter standing room only section with rails instead of seats. Seating in team purple and gold spell "Orlando" and city pride. The metal and concrete contrast well with the purple seating. The venue is home to Orlando City Lions and Orlando Pride games, plus national and college league soccer matches and concerts. Southern Bleacher helped raise Orlando's profile in the sports business market while completing the project on time and under budget. Project architect was Populous and C.T. HSU & Associates, P.A.

Photos: Aero Photo



## MITERED SOFTBALL STADIUM



### University of Oregon

Eugene, Oregon

#### DETAILS

Working with the architectural firm, SRG Partnership and Cameron McCarthy, Southern Bleacher created the soaring Jane Sanders Stadium for Ducks softball. The mitered venue is decked with our innovative Interlock 2000 system. It has 1,434 permanent chair seats with 500 of them covered by the wing-like canopy. Additionally the field was designed to accommodate 1,000 temporary seats behind center field. Dark green chairs, press box facade and canopy contrast sharply with team yellow step risers and canopy supports.

*Photo: Bishoff Photography*



Today's college (and high school) sports inspire even more passion, more loyalty, more throw-down, all-out fan fun than even many professional franchises. Spectators like that deserve the best seat in the house as much as their teams deserve a great place to play, and nobody delivers it like Southern Bleacher.

**Southern Bleacher venue options including integral roof systems, mitered designs, press boxes, sky boxes and suites, Clear-Span foundations and stadium additions. We are the industry innovators in 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 press boxes, 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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## CLEAR-SPAN FOUNDATION

### DETAILS

The "Rockpile" is home to Rockies football and track. Our Clear-Span foundation created the perfect frame for the unique "wrap" graphics around the outside of the stadium. An interesting note is that the design was chosen with input from the student body, to be inclusive of all.

The team red facade ties in to the red riser enhanced seating. This Clear-Span venue encloses concessions, bathrooms and ticket entry. Decking is our own Interlock 2000 decking system. The 10' x 54' press box features a sloped front and a video deck. The Rockpile seats 2,516 Rockies fans. The grandstand was designed, manufactured and installed by Southern Bleacher Company.

Photos: Tirotta Photo Productions



### TESTIMONIAL

*"The fans that we've drawn the last couple years necessitated it. Fans deserved it, and they also deserved all the other beautiful parts of the facility that are here tonight as well."*

JAMES CONDON  
PLYMOUTH HIGH SCHOOL PRINCIPAL

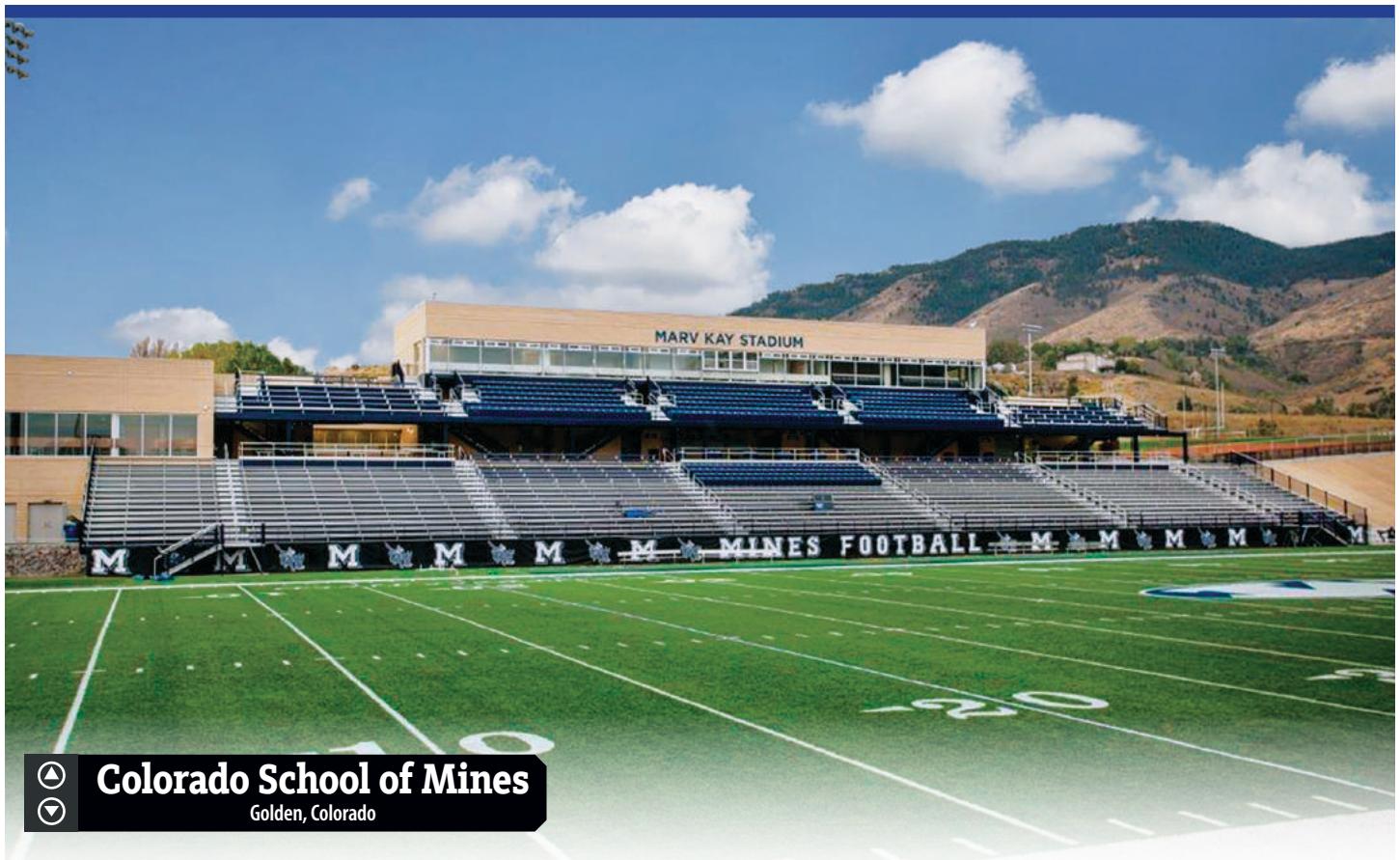


Plymouth Community School Corporation

Plymouth, Indiana



## HILLSIDE STADIUM



### Colorado School of Mines

Golden, Colorado

#### DETAILS

Colorado School of Mines' Marv Kay Stadium features two decks that have a variety of seating options. Team blue chairs, benches with blue seat backs and benches without backs. Team blue risers on the lower deck nicely balance the color throughout the venue. The entire substructure was galvanized and painted in team blue. Marv Kay Stadium seats 3,078 Mines football fans. Hillside stadiums are perfect in terrain that isn't.

The project architect was Heery International, Inc.

*Photo: Associated Photographics*

#### TESTIMONIAL

*"I mean this facility rates better than some (Division 1) places I've been."*

**GREGG BRANDON  
HEAD COACH, COLORADO SCHOOL OF MINES**

**Our small team of highly skilled regional representatives care for their customers from beginning to end. The man who takes your first call also designs your stadium. He works with your board, your architect and contractors and verifies quality, making sure every detail is right.**

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 first class stadiums that offer excellent value. A Southern Bleacher stadium is a rock solid investment for sports programs and venues of every variety and size. ■



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## MULTI SPORT STADIUM

Indianola Community Schools

Indianola, Iowa



Note: The press box is by others.

### DETAILS

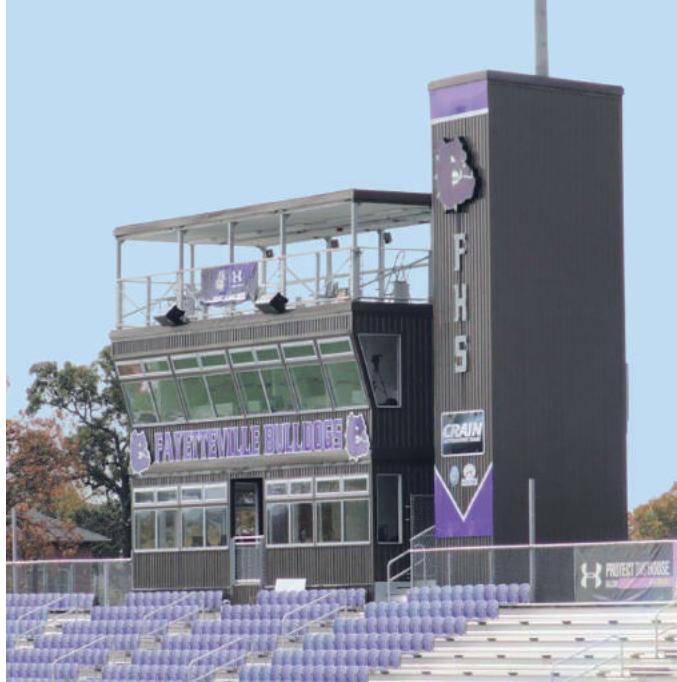
Southern Bleacher's Horizontal Beam design is an affordable and highly adaptable option for grandstands. Note how the tiered sections create visual interest. Grandstand decking is our Interlock 2000 decking system. Team purple risers and the front facade balance the bright metal and add team spirit. Indianola Stadium seats 2,970 fans of Indian football, soccer and track. The stadium was designed, manufactured and installed by Southern Bleacher. *Photos: Tim McConnell Fine Photography.*



The press box is a necessary addition to any grandstand or stadium. Southern Bleacher can work with your architect or committee to build the perfect press box. As you can see by the outside view, Southern Bleacher offers safety and security with galvanized steel support that is connected to the rear of the stadium and is independently supported by galvanized steel columns and a concrete foundation. Turn the page for details on our press boxes.

## PRESS BOX OPTIONS

We think press boxes are just one more way to express your venue's team spirit. Stacked press boxes with window choices like our sloped front, enhance the view of the field. Door placement is another option – front along with the standard end. An elevator that opens into each of the boxes and the video platform saves time and protects costly equipment. The expansive space offers room for team and sponsor signs.



Vertical glass windows with rolling security shutters. Custom Vertical Rail video platform.

Team color paneling adds individuality. The addition of a canopy is one of our options.

### PRESS BOXES

At Southern Bleacher, we are experts at creating a state-of-the-art press box perfectly designed for your venue. With our variety of options, press box possibilities are limitless. Southern Bleacher press boxes come standard with galvanized steel support that is connected to the rear of the stadium and is independently supported by galvanized steel columns and a concrete foundation.

Standard features are exteriors of 26-gauge R paneling for strength and durability. Interiors have anodized aluminum counter tops, acoustic ceiling tiles and fluorescent lighting. From there it is up to you. We offer several window options and interior enhancements for a press box as high or as low tech as you please.

A venue's press box is not only a necessary component, but it can add individuality and personality to any stadium or grandstand.

We offer a variety of exterior facade colors (you can download a chart from our website). Faux brick, stone and block facades can blend your venue into architectural surroundings or make a statement. Roof platform options include our Vertical Rail safety fencing in colors and also a colored vinyl-coated chain link. Look at the projects throughout the brochure for inspiration and ideas.

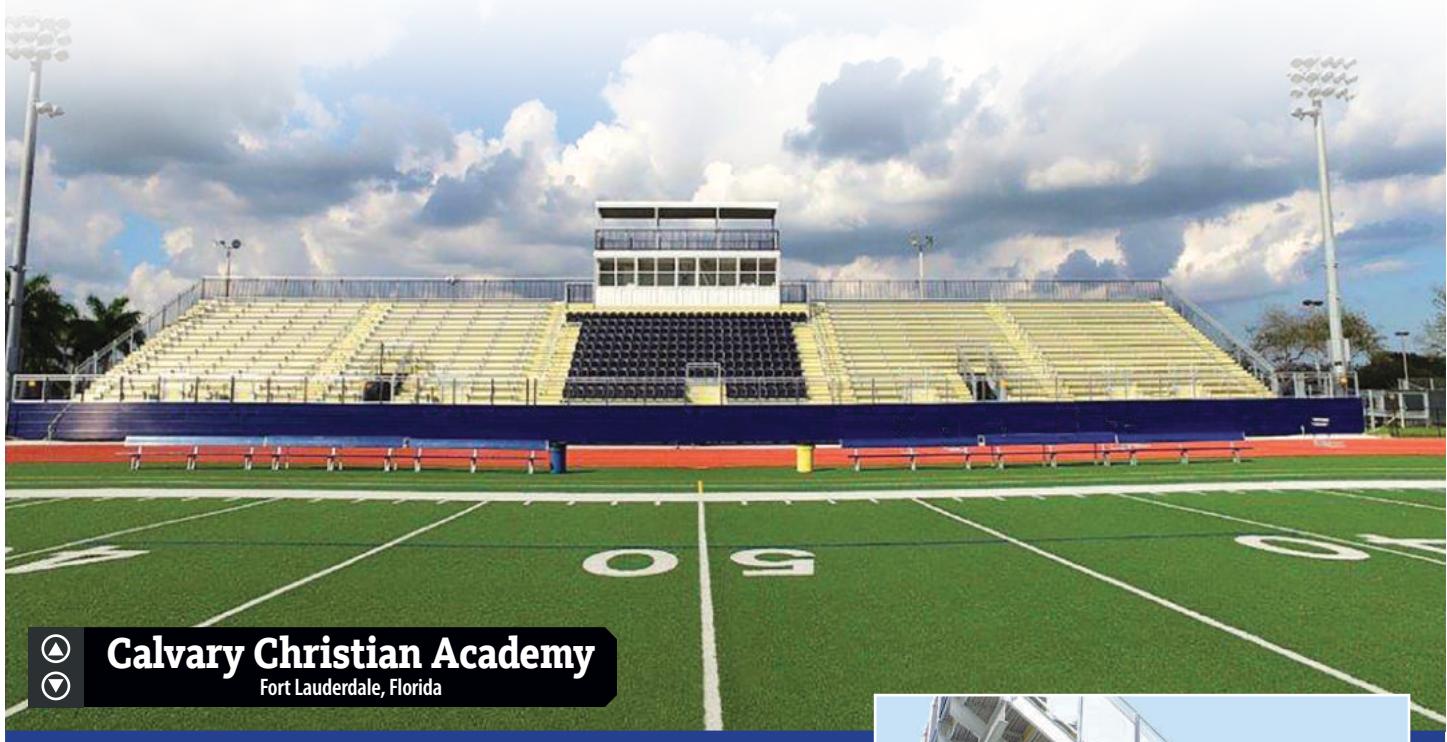
**A Southern Bleacher state-of-the-art press box or stadium sky box gives you the opportunity to add individual style to your venue while creating a high-value, functional space for announcers, media and special guests.**

Southern Bleacher's state-of-the-art press boxes are an opportunity to individualize a stadium. Press boxes are no longer an afterthought or a necessary addition. A Southern Bleacher press box will make a statement – it is up to you just how bold you want that statement to be. We offer a number of ways to create an individual look for your stadium sky box / press box, allowing you to create exactly the press box you envision: A wide variety of colors for exterior panels. Faux brick, stone and block facades to blend your venue into architectural surroundings or create a unique architectural statement. If you've opted for a roof platform, chain link or vertical rails safety fencing, including options for colored rails or colored vinyl-coated chain link. ■



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## FOOTBALL GRANDSTANDS



### Calvary Christian Academy

Fort Lauderdale, Florida

#### DETAILS

The CCA Eagles call this unique 1,534 seat football and track grandstand home. The venue shows extensive use of color in gold seat and step risers combined with blue chair seats and front facade. The bold look is sure to instill both fan and player pride. The grandstand features a 8' x 36' sloped front press box with a canopied video deck and our Vertical Rail guard along the top. Designed, manufactured and installed by Southern Bleacher. The detail shows our Horizontal Beam design substructure and Interlock 2000 decking system. *Photo: Aero Photo*



#### DETAILS

This project includes Home, Visitor and Band grandstands. Decking system is our Interlock 2000. The home grandstand (shown) features upper and lower decks. A VIP team blue chair section is accented with blue facades at the ends of the lower deck. Charging Wildcat Stadium is home to football and track. The home grandstand seats 3,026 fans. Note: Band grandstands are a popular addition: keeping sight lines free and with strategic placement, give bands more visibility and sound power. Architect was DLR Group and Taggart Foster Currence and Gray Architect.

*Photo: NWA Photography, Inc.*



### North Little Rock School District

North Little Rock, Arkansas



## MULTI-SPORT GRANDSTANDS



**Central Bucks School District**

Doylestown, Pennsylvania

### DETAILS

Patriot Stadium is home to Central Bucks East Patriot football, track and soccer. The 2,011 seat Leg-Truss design grandstand features our Interlock 2000 decking system and a 8' x 30' sloped front press box with video platform. As you can see, team blue facade, press box trim, step and seat risers create fan pride and excitement.

The project architect was Hayes Large Architects, LLP.

*Photo: KSN Images*

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

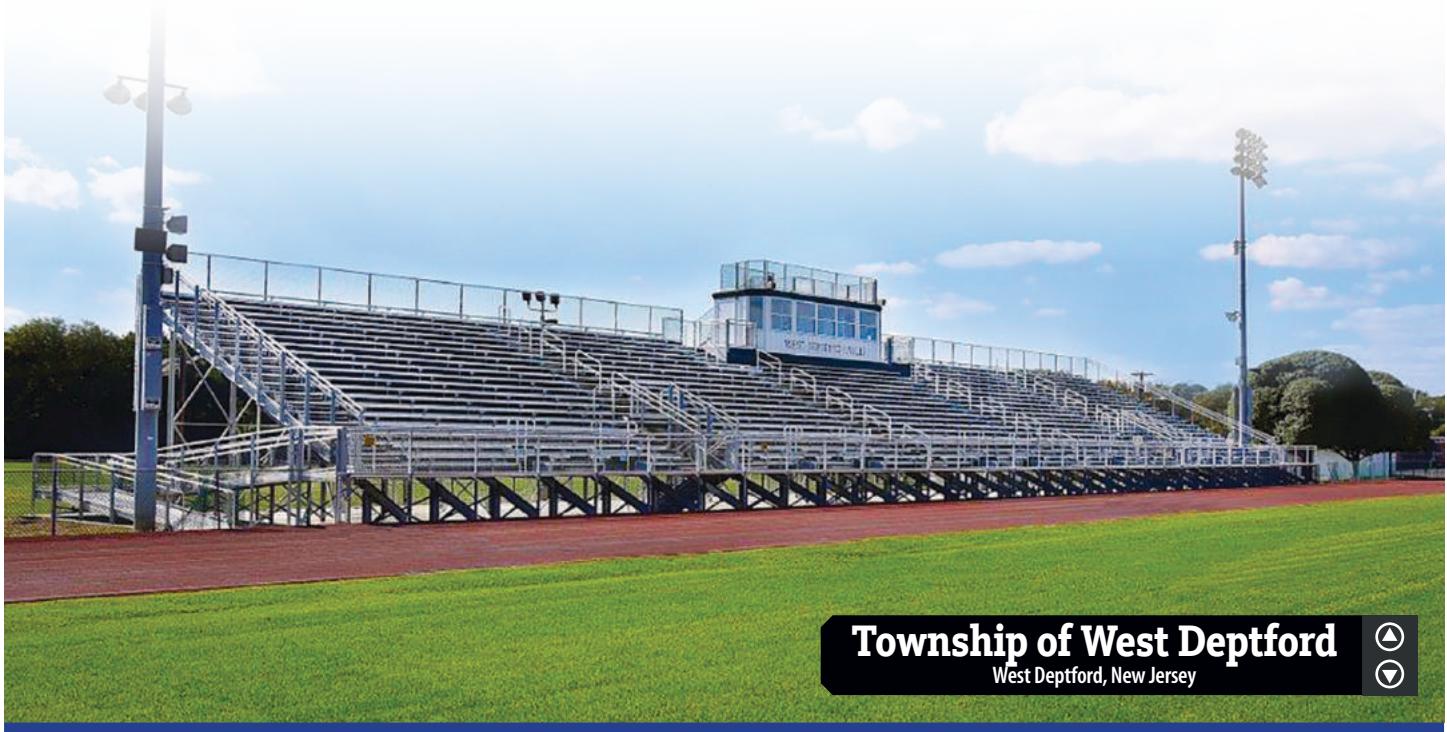
We think you'll agree – with our vast experience in manufacturing stadiums, grandstands and bleachers, Southern Bleacher understands the intricate details of the design and planning of sporting and entertainment venues.

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. ■



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## MULTI-SPORT GRANDSTANDS



### Township of West Deptford

West Deptford, New Jersey



As you can see above, Southern Bleacher crafts its grandstands to be accommodating to all fans. By doing so, your facility will be code compliant. Not addressing codes will cost time and money. Our experts will guide you through complicated regulations.

#### DETAILS

Pocahontas High School's Horizontal Beam grandstand seats 2,190 Redskin fans. It is decked with our Interlock 2000 decking system. Split seating decks offer spectators a field-level view or a higher vantage point. Center upper seating section features bench seating with team red backrests. Our sloped front press box is a popular option for an even better view of all the action. This press box is 8'x 42'. Designed, manufactured and installed by Southern Bleacher.

*Photo: Joey Glaub Fine Art Portraits*

#### DETAILS

This Leg-Truss grandstand puts fans of the West Deptford Eagle football team front and center. The grandstand seats 1,873 fans. It features our Tongue and Groove decking system and a 8' x 30' press box. Color press box trim, seat and step risers add individuality. Leg-Truss design grandstands are available with a range of custom options. Access ramps and wheel chair accommodations are just a few of the safety and comfort choices.

Project architect was Remington & Vernick Engineers. *Photo: KSN Images*

### Pocahontas School District

Pocahontas, Arkansas



## SOCER AND FOOTBALL



### Hockinson School District

Brush Prairie, Washington

#### DETAILS

The Hockinson High School Hawks call this 1,494 seat roofed Horizontal Beam grandstand home. Decking is our Interlock 2000 decking system. In areas with considerable amounts of rain, roofed venues are a necessity for fan comfort. Southern Bleacher can outfit your athletic field with every seating requirement – from fans to players, field-side to dugout. The project architect was GeoDesign, Inc.

*Photo: Glen Davis, Legendary Portraits*

#### TESTIMONIAL

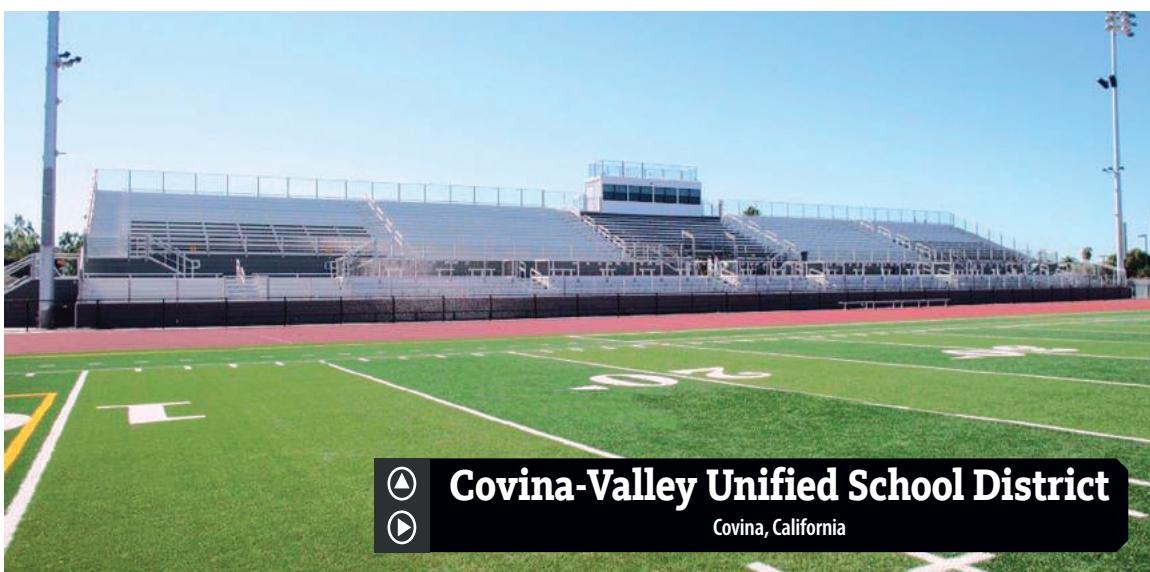
*"It's beautiful, It far exceeded my expectations."*

DICK SHEEHAN  
COVINA VALLEY UNION SCHOOL DISTRICT  
SUPERINTENDENT

#### DETAILS

Covina District Field, one of the oldest high school stadiums in the San Gabriel Valley, was completely refurbished by Southern Bleacher. The 2,551 seat stadium features our Tongue and Groove decking system and a 8' x 30' press box. Painted bench seat back rest sections in the center and both ends add team spirit. The venue is home to three high schools. Westberg and White Architects were project architects.

*Photo: Richardson Photography*



### Covina-Valley Unified School District

Covina, California

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## BASEBALL AND SOFTBALL

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### Huntington University

Huntington, Indiana



#### DETAILS

Huntington University's Forest Glen Park received a Southern Bleacher renovation. Our Leg-Truss design was the perfect choice for the baseball stadium, which is located in a wooded ravine. Decking is our Intelock 2000 decking system. Seating is comprised of 206 chairs in Forresters green and 152 bench seats.

The project architect was Design Collaborative. Photo: Media Wright, Inc.

Note: The press box is by others.



### University of Wisconsin–River Falls

River Falls, Wisconsin



#### DETAILS

Southern Bleacher's versatile Leg-Truss design brings the action right to the fans. The stadium features our Full Plank decking system. Our expertise in incredible sight lines keep spectators on the edge of their seats. All 320 seats with Falcon red painted back rests are the best in the house. The venue features an 8'x 24' press box. Ramer Field is home to NCAA Division III softball. The project architect was Ayres Associates. Photo: Stebbins Photography

## AQUATIC AND MULTI-SPORT

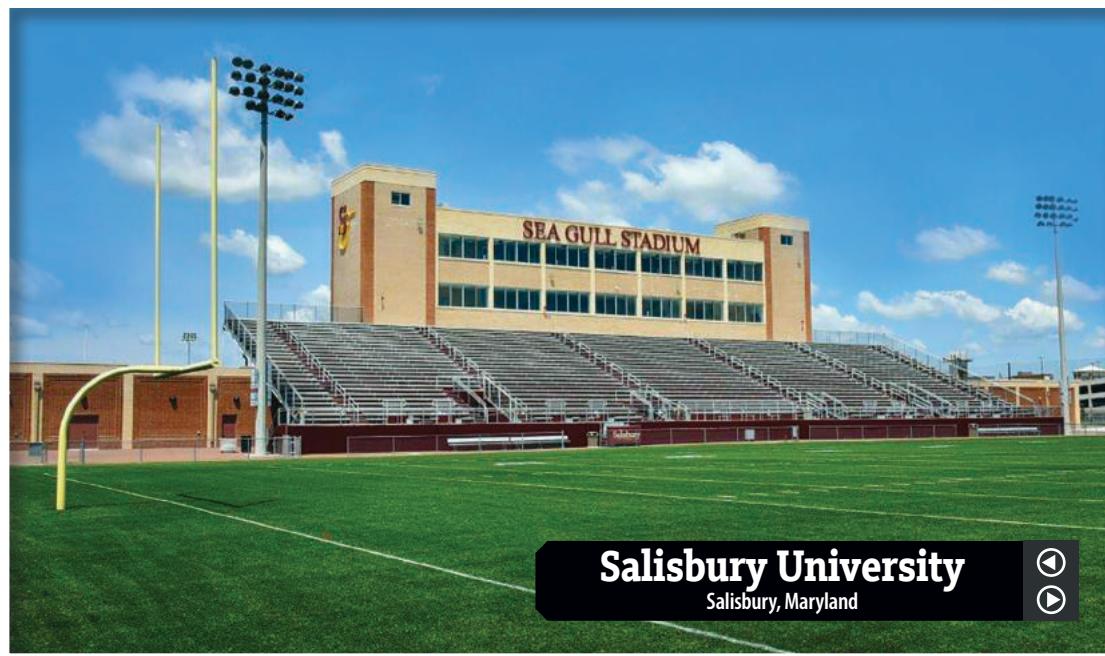


**Fresno Unified School District**

Fresno, California

### DETAILS

Hoover High School's Hoover Aquatic Center roofed Horizontal Beam grandstand features a ramp and stair configuration at one end and stairs at the opposite end. Decking is our Interlock 2000 decking system. The compact venue seats 218 and offers ample wheel chair seating. The aquatic center is home to Patriot swimming, water polo (boys and girls) and hosts Special Olympic events. The project architect was HMC Architects. *Photo: Terry O'Rourke*



**Salisbury University**

Salisbury, Maryland



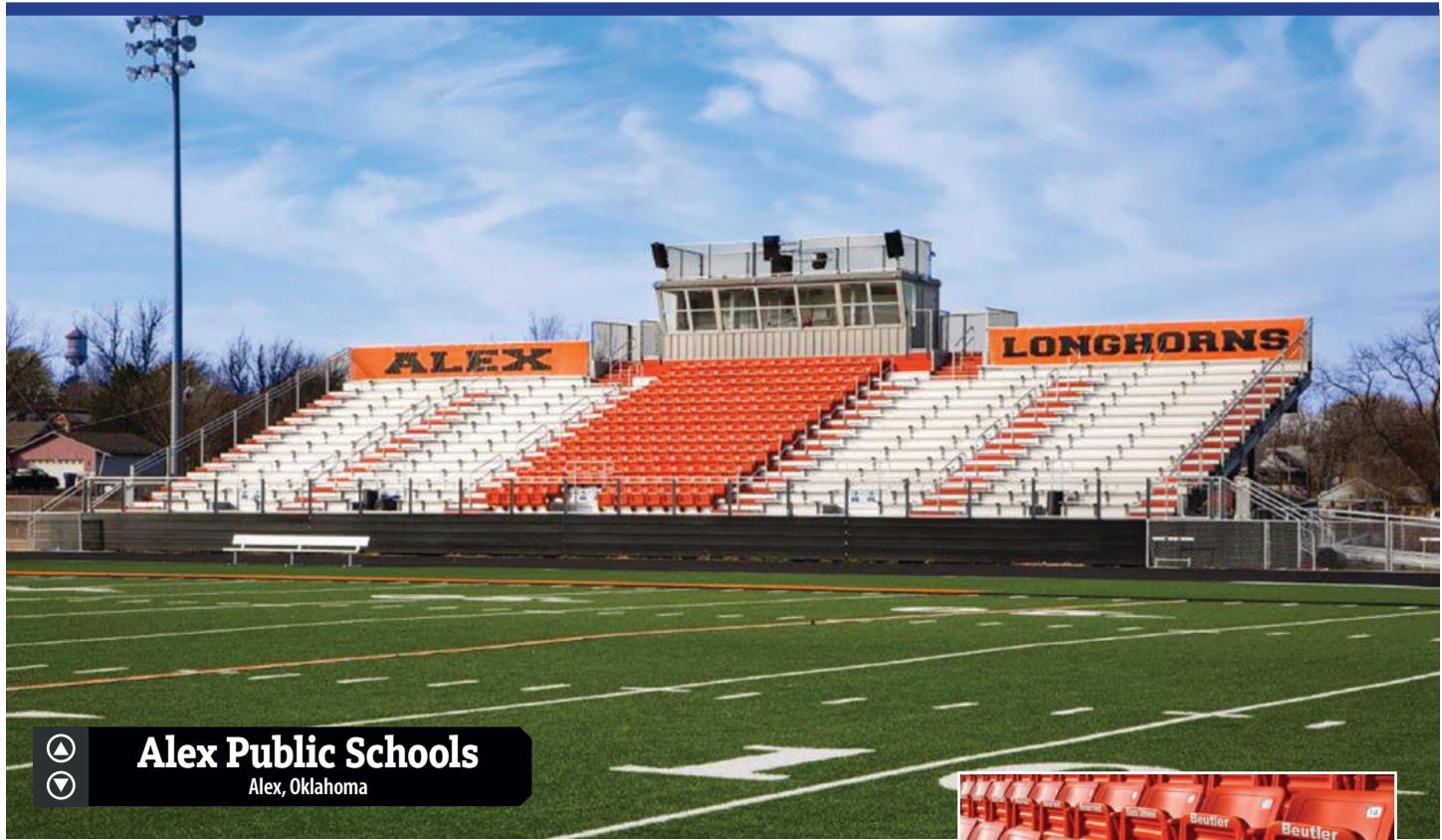
### DETAILS

Salisbury University expects to boost recruiting for their sports with the completion of their soaring Sea Gull Stadium. The stadium is decked with our innovative Interlock 2000 decking system. The 3,167 contour seats offer the best in comfort. The bold use of team maroon inspires players and fans alike. Sea Gull Stadium is home to men's football, women's field hockey, men's/women's lacrosse, soccer and track and field events. Project architect was GWWO, Inc.

*Photo: KSN Images*

Note: The press box complex is by others.

## FOOTBALL GRANDSTANDS



### Alex Public Schools

Alex, Oklahoma

#### DETAILS

Alex High School's Horizontal Beam grandstand is long on team spirit. The 731 seat venue is decked with our Tongue and Groove decking system and features a 190 seat VIP section with personalized chairs. This is a great way for their boosters to show some Longhorn pride and create revenue. Team orange step risers add extra color and safety. The 8' x 30' press box has our sloped glass front for better visibility and a video deck. The project architect was Design Architects Plus, Inc. *Photo: McNeese Stills + Motion*



### Santa Ana Unified School District

Santa Ana, California



#### DETAILS

Valley High School's expansive Sports Complex includes Southern Bleacher's multi-sport 2,099 seat Horizontal Beam grandstand. The venue is decked with our classic Tongue and Groove decking system. The 8' x 36' press box features our rolling security shutters and has a video platform. Falcon football and men's/women's soccer and track and field events play out before fans. Project architect was GB Architects.

*Photo: Richardson Photography*

## MULTI-SPORT GRANDSTANDS



### Abernathy ISD

Abernathy, Texas

#### DETAILS

Antelope stadium is an example of Southern Bleacher's Horizontal Beam and features our Tongue and Groove decking system. The VIP seating section with maroon seat backs add that all important color and team pride. The 8'x 36' sloped front press box also has a video deck. Note the field-side tan facade and the matching press box front that ties perfectly into the guard railing. 1,679 seat Antelope Stadium is home to Abernathy Antelope football and track. The project was designed, manufactured and installed by Southern Bleacher. *Photo: Anderson Photography*

Located in Texas, everyone at Southern Bleacher understands that high school football isn't a game. It's a legacy and a way of life. Southern Bleacher's high school football stadiums inspire team pride and give fans the best seat in town. If you're in the market for a stadium, expansion or upgrade, this brochure features examples of the best high school and college football stadiums in the country.



### Lawrence University

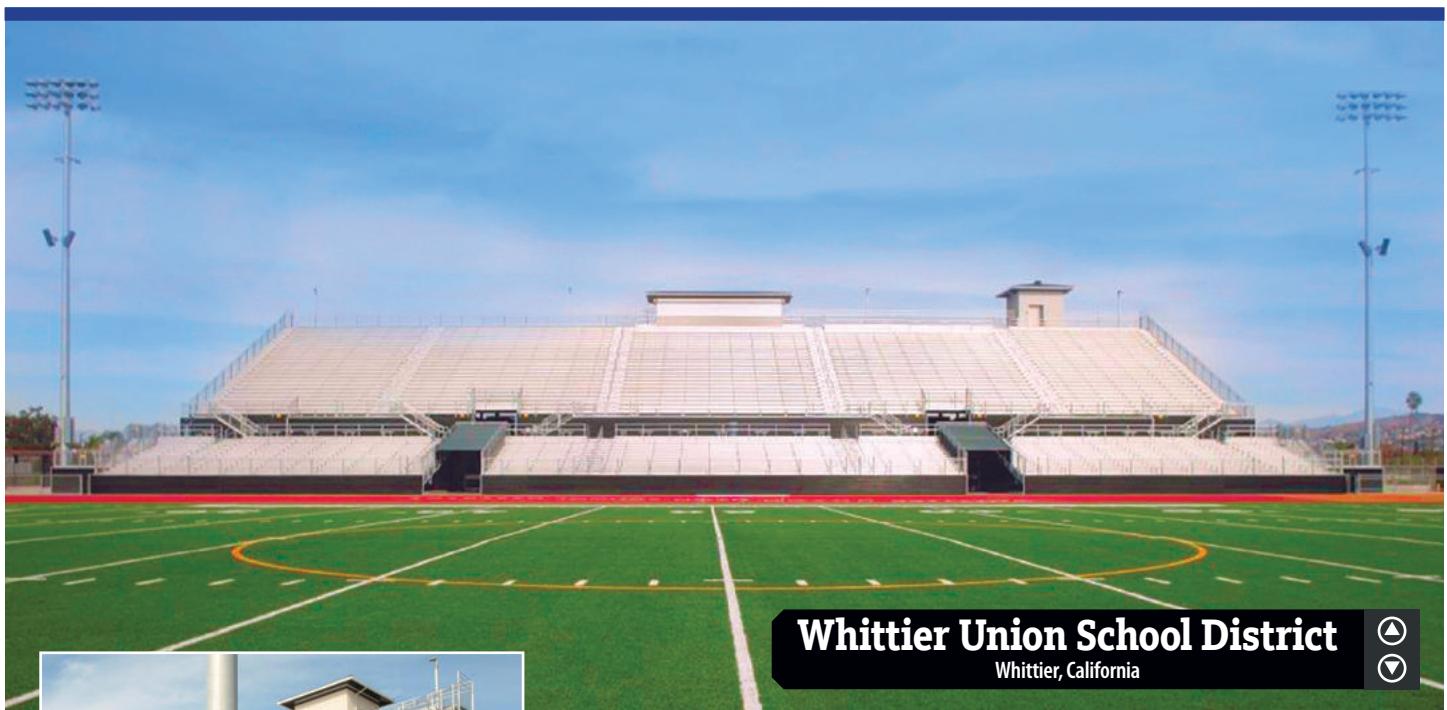
Appleton, Wisconsin

#### DETAILS

Note: The press box is by others.

Originally constructed in 1965 in a natural ravine, The Banta Bowl was renovated with a steel substructure over the existing concrete stand and decked with our Tongue and Groove decking system. Southern Bleacher's highly versatile Leg-Truss Hillside design was perfect for the terrain. The Banta Bowl seats 2,159 Viking football and men's/women's soccer fans. Note the covered seating sections flanking the press box. The project architect was Harris and Associates, Inc. *Photo: Ken Mar Photography, Inc.*

## MULTI-SPORT GRANDSTANDS



**Whittier Union School District**

Whittier, California



### DETAILS

The Pioneer High School stadium is another example of Southern Bleacher's Horizontal Beam foundation. The detail shows the underside of the stadium has been enclosed – providing space for concessions, locker and weight rooms, rest rooms and offices. The detail also illustrates how the split decks are reached by a common concourse and can be reached by stairs and code compliant ramps. Grandstand decking is our Interlock 2000 decking system. Note the rolling security shutters on the 9'x 36' press box and the elevator. The 4,993 seat

Dick Torres Memorial Stadium is home to Pioneer football and soccer.

Project architect was Flewelling and Moody Architects.

*Photo: Richardson Photography*

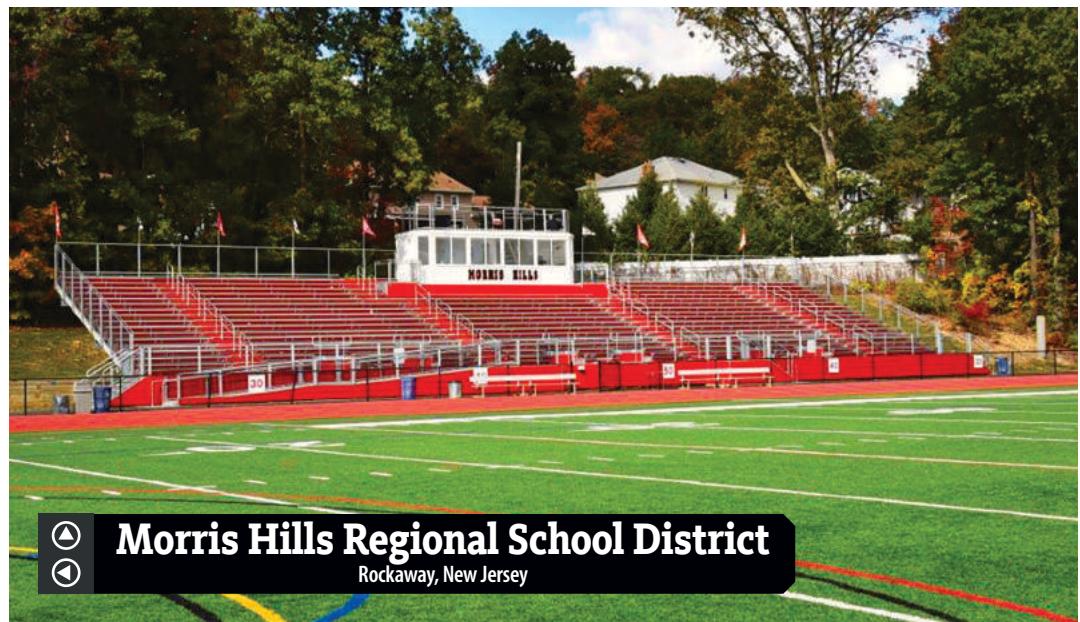


### DETAILS

Morris Hills High School's Horizontal Beam grandstand utilizes the scarlet in their team mascot to perfection. Decking is our Tongue and Groove decking system. Scarlet seat and step risers along with the front facade are balanced by the white with red trim 8'x 30' press box. The grandstand seats 1,177 Scarlet Knights football, soccer and track and field fans. The project architect was Faitlowitz and

Kosten Architects.

*Photo: KSN Images*



**Morris Hills Regional School District**

Rockaway, New Jersey



## MULTI-SPORT GRANDSTANDS



### Ouachita Parish School System

West Monroe, Louisiana

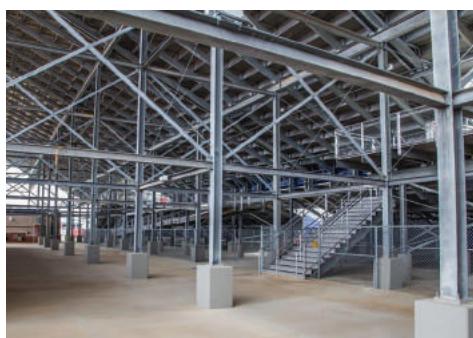
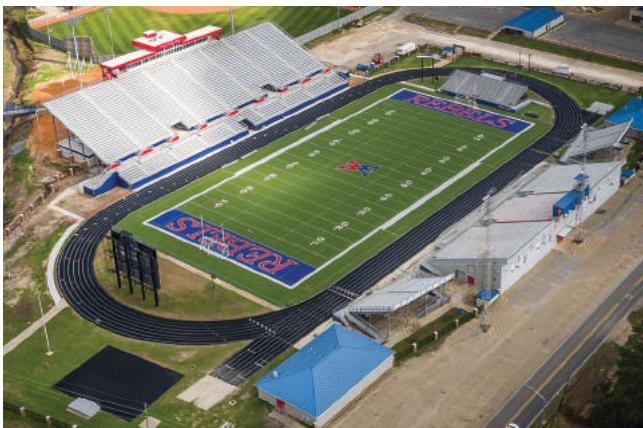
Note: The press box is by others.

#### DETAILS

West Monroe High School's Don Show Stadium is an example of our Horizontal Beam foundation design. This grandstand features split decks with our Interlock 2000 decking system. Wheel Chair sections offer companion seating. Team blue seat backs add comfort. The red step facades add color and individuality. The stadium seats 6,081 Rebel football and track fans. An interesting note, the stadium was mostly funded by the team's Rebel Booster Club.

The project architect was TBA Studio. Photo: Louisiana Helicam

Attention to detail can be found in every element of a Southern Bleacher project. From the field side to the substructure, our capabilities and pride in craftsmanship is evident for all to see.



## MULTI-SPORT GRANDSTANDS



**Donegal School District**

Mount Joy, Pennsylvania



### DETAILS

The Donegal Athletic Complex is another example of our Horizontal Beam foundation. Additionally, the exterior can be covered with a variety of custom treatments, from brick to material wraps like the Rockpile on page four. While the outside of the grandstand is finished with a brick and block facade, the field side of the stadium is boldly accented with gold risers and press box trim and black Vertical Rail and front facade. The grandstand is decked with our innovative Interlock 2000 decking system. The press box is 8' x 30' and features a video platform. The 1,332 seat grandstand is home to Indian football, field hockey, soccer and track and field. The project architect was Crabtree, Rohrbaugh Associates Architects.

*Photo: KSN Images*



**Lehighton Area School District**

Lehighton, Pennsylvania



### DETAILS

Lexington High School's Horizontal Beam grandstand seats 1,806 spectators in team maroon glory. Decking is our Tongue and Groove decking system. The step and seat risers, press box trim and field side facade feature the school color. The 8' x 30' sloped front press box has a video deck enclosed with our Vertical Rail. Indians football, field hockey, soccer and track and field are cheered to victory here. Architect was Spillman Farmer Architects.

*Photo: KSN Images*

# GRANDSTAND SPECIFICATIONS

## SECTION 133416 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 (1) year beginning at Date of Substantial Completion for Projects installed by Manufacturer. The warranty will provide for repair or replacement of failed components due to defect in materials and workmanship of installation for the specified period. 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 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.

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. Halfstep 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 Mill 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 9 1/16" (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 Hytar/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: 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 [SPEC'S 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 (05/2015)

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VISIT OUR WEB SITE:  
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