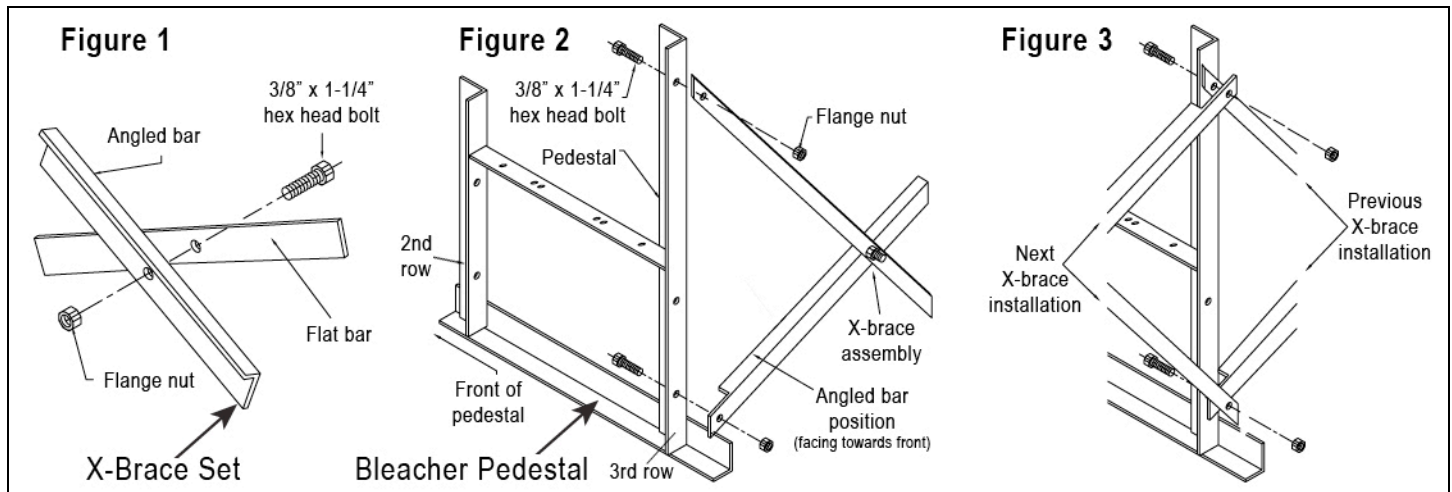


# 77000 Series Portable Bleachers - Three Row Assembly & Installation Instructions

Thank you for selecting Salsbury's aluminum portable bleachers. We are confident that the quality and construction of this product will provide years of maintenance free use.



## Preliminary Notes

There are two basic steps to assembly:

1. The bleacher pedestals must be assembled to the braces.
2. The seat planks and foot planks must be assembled to the bleacher pedestals.

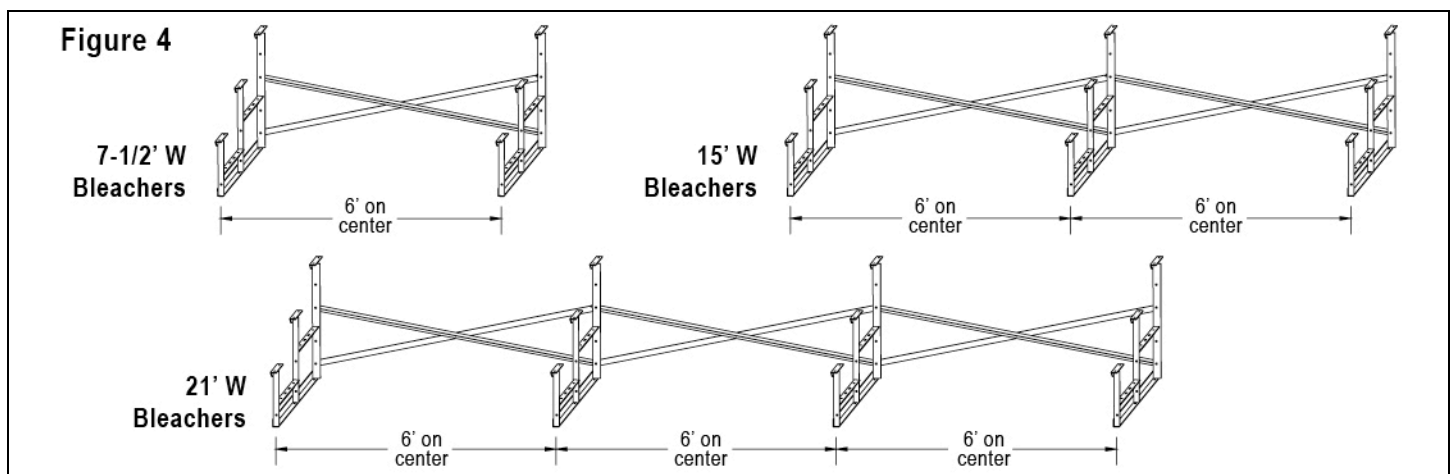
Three (3) seat planks and two (2) foot planks are provided for all models. 7-1/2' models come with two (2) pedestals, 15' models come with three (3) pedestals, and 21' models come with four (4) pedestals.

## Assembly

Assemble the X-brace sets. Each set consists of one flat bar and one angled bar. The angled bar should sit on top of the flat bar. See Figure 1. Insert a 3/8" x 1-1/4" hex head bolt through the center hole on both pieces and use a flange nut to assemble these parts together. Do not fully tighten as adjustments may need to be made when continuing on to the next step.

Next, build out the frame work of the bleachers. Begin by connecting one side of an X-brace onto the back of one of the pedestals using a 3/8" x 1-1/4" hex head bolt and flange nut. Be sure that the angled bar on the X-brace is facing toward the front of the pedestal. See Figure 2. Then attach opposite side of the X-brace to the back of another pedestal. If assembling 7-1/2' wide bleachers, your frame assembly is complete. Review Figure 4 to ensure proper frame work assembly before securely tightening all connections.

If assembling 15' wide and 21' wide bleachers, continue by connecting the next X-brace to the frame. To do this, place the next X-brace on top of the previous X-brace connection. See Figure 3. Repeat this process until all X-brace sets and pedestals have been connected to the frame. Review Figure 4 to ensure proper frame work assembly before securely tightening all connections.

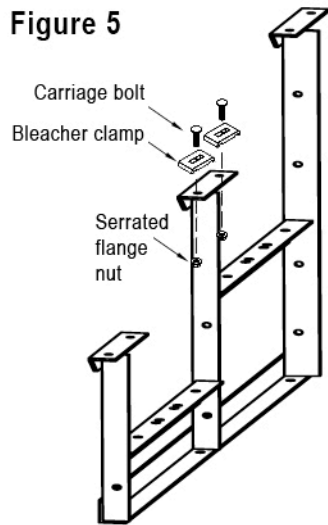


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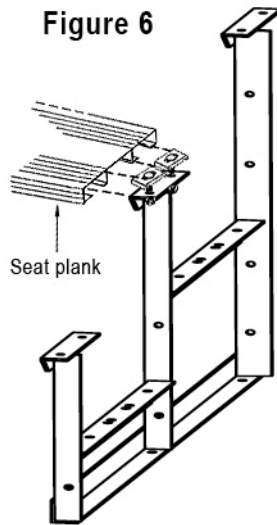
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# 77000 Series Portable Bleachers - Three Row Assembly & Installation Instructions

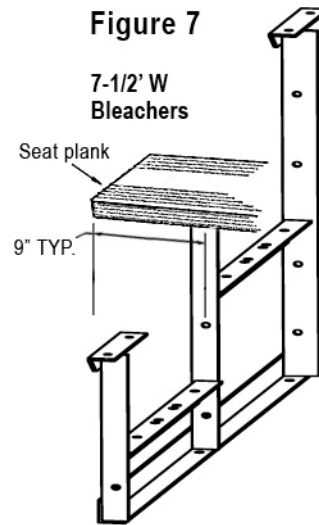
**Figure 5**



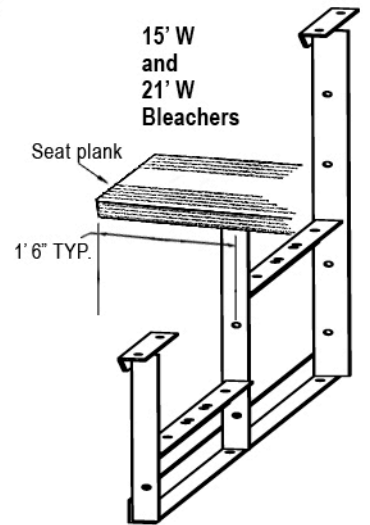
**Figure 6**



**Figure 7**



**15' W and 21' W Bleachers**



Next, install one of the 5/16" by 1-1/4" long carriage bolts through a bleacher clamp and loosely attach it to a pedestal with one of the 5/16" serrated flange nuts as shown in Figure 5. Do this with the remaining bleacher clamps in the first pedestal and repeat for remaining pedestal(s).

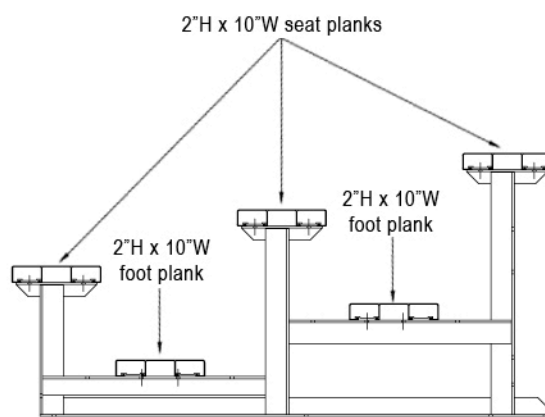
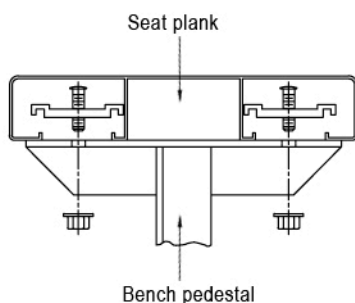
Align each of the bleacher clamps on the pedestals such that they can be inserted into the bottom of a seat plank as shown in Figure 6. Begin sliding the first seat plank between the clamps and pedestal. For 7-1/2' wide bleachers, position seat plank end 9" from center of the pedestal. For 15' and 21' wide benches, slide the seat plank into position 1'-6" from one end. See Figure 7.

Tighten all seat plank connections, ensuring that the bleacher clamps grip the inside lips of the seat plank. Also ensure that the square section of the carriage bolts are inside the square slots in the bleacher clamps while tightening the nuts, as shown in Figure 8.

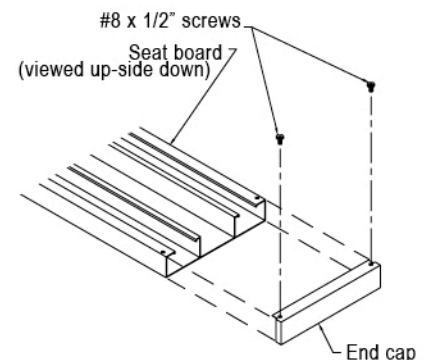
Repeat this process for all other seat planks and foot plank installations.

Install end caps on both ends of the seat planks and foot planks by inserting #8 1/2" screws on the under side of the planks. See Figure 9.

**Figure 8  
(side view)**



**Figure 9**



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