

Bleacher assembly manual

Steps 1 to 3

English version

This edition combines the three supplied assembly drawings. Dimensions, item numbering and fastener sizes are retained unchanged.

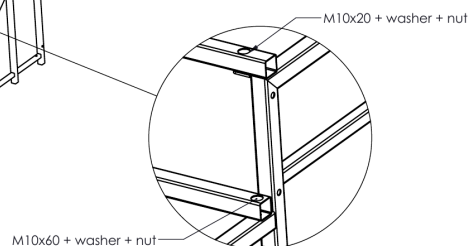
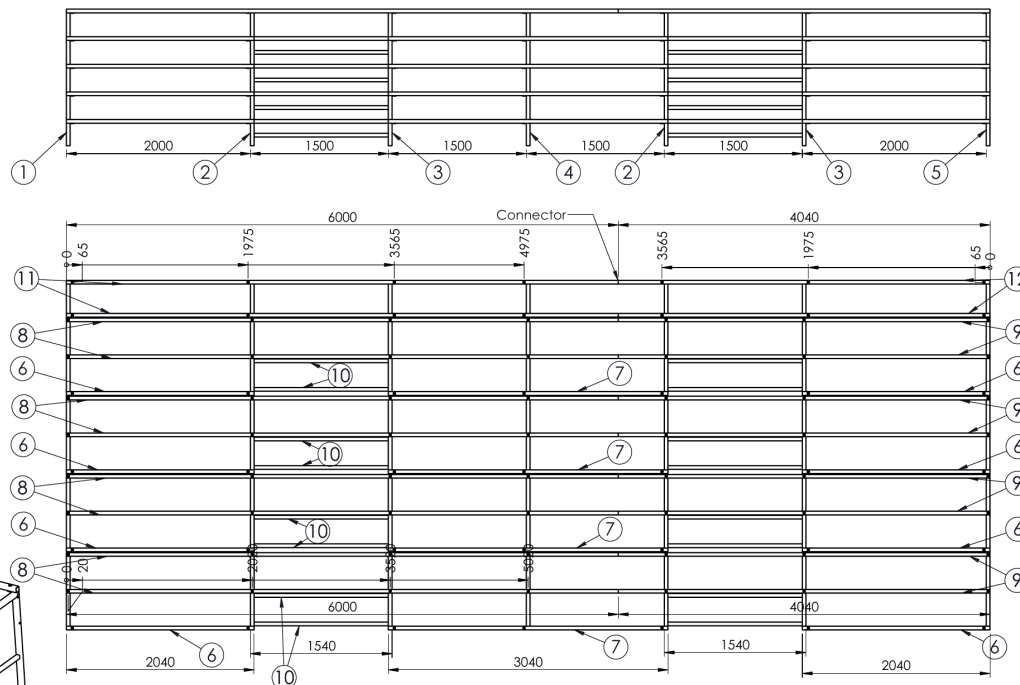
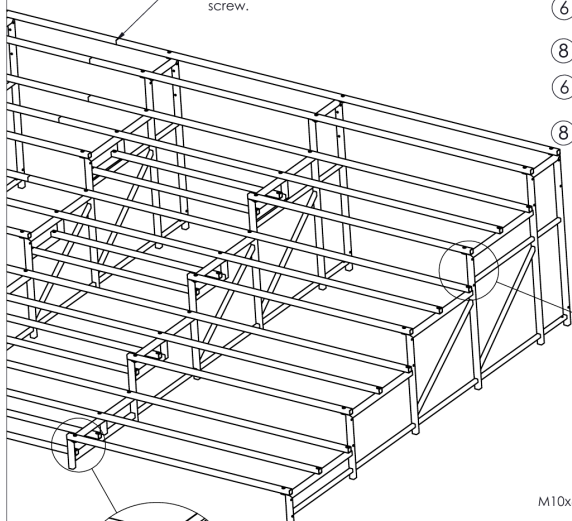
1**Base frames and
platform beams****2****Struts, guardrails and
frame completion****3****Anti-slip panels, bench
boards and fastening**

STEP 1 - Base frames and platform beams

Original assembly drawing - item numbering and dimensions correspond with the parts list on the next page.

12	Platform beam (40x40) L=4040 - 1	2
11	Platform beam (40x40) L=6000 - 1	2
10	Platform beam (40x40) L=1540	16
9	Platform beam (40x40) L=4040	8
8	Platform beam (40x40) L=6000	8
7	Platform beam (40x40) L=3040	4
6	Platform beam (40x40) L=2040	8
5	Frame 5-rows, S300, G850 - right	1
4	Frame 5-rows, S300, G850 - intermediate right	1
3	Frame 5-rows, S300, G850 - steps right	2
2	Frame 5-rows, S300, G850 - steps left	2
1	Frame 5-rows S300, G850 - left	1
L.P.	Configuration Name	STEP I

Slide the profile connector into the joint and fasten it using a 6.3x25 self-drilling screw.



	Name	Signature	Date	Weight[kg]	TITLE
Drawn	G.Górka		14.09.2026		
Checked	A.Żuchowski		14.09.2026	Size	
Approved	T.Bargiel		14.09.2026	A4	
MTB GROUP ul. Mickiewicza 40, 32-400 Myślenice				REV: 0	Drawing no.
				Scale	STEP I
					Art. no.

STEP 1 - Parts and fastening

Assembly notes

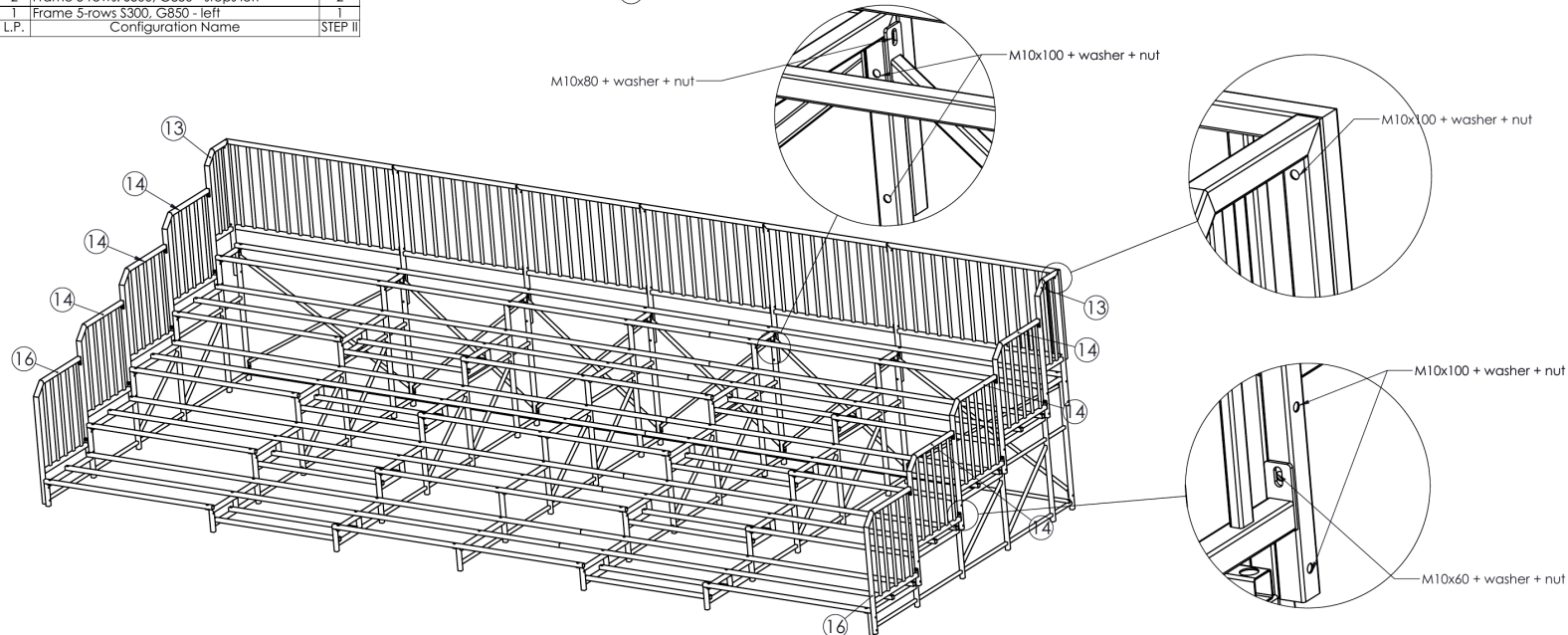
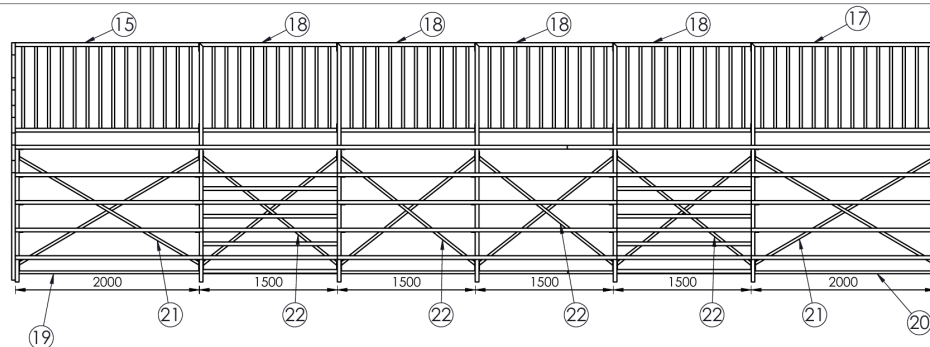
- Slide the profile connector into the joint and fasten it using a 6.3x25 mm self-drilling screw.
- Fasteners according to the drawing: M10x20 and M10x60, each with washer and nut.

Nr.	Description	Qty
12	Platform beam (40x40) L=4040 - 1	2
11	Platform beam (40x40) L=6000 - 1	2
10	Platform beam (40x40) L=1540	16
9	Platform beam (40x40) L=4040	8
8	Platform beam (40x40) L=6000	8
7	Platform beam (40x40) L=3040	4
6	Platform beam (40x40) L=2040	8
5	Frame 5-rows S300, G850 - right	1
4	Frame 5-rows S300, G850 - intermediate right	1
3	Frame 5-rows S300, G850 - steps right	2
2	Frame 5-rows S300, G850 - steps left	2
1	Frame 5-rows S300, G850 - left	1

STEP 2 - Struts, guardrails and frame completion

Original assembly drawing - item numbering and dimensions correspond with the parts list on the next page.

22	Strut 1500 R5	4
21	Strut 2000 R5	2
20	Square tube 30x30, L=4030	1
19	Square tube 30x30, L=6000	1
18	Rear guardrail L1500	4
17	Corner barrier L2040	1
16	Side rail - 1 row	2
15	Rear connecting barrier L2000	1
14	Intermediate side rail	6
13	Supplementary side rail	2
12	Platform beam (40x40) L=4040 - 1	2
11	Platform beam (40x40) L=6000 - 1	2
10	Platform beam (40x40) L=1540	16
9	Platform beam (40x40) L=4040	8
8	Platform beam (40x40) L=6000	8
7	Platform beam (40x40) L=3040	4
6	Platform beam (40x40) L=2040	8
5	Frame 5-rows, S300, G850 - right	1
4	Frame 5-rows, S300, G850 - intermediate right	1
3	Frame 5-rows, S300, G850 - steps right	2
2	Frame 5-rows, S300, G850 - steps left	2
1	Frame 5-rows S300, G850 - left	1
L.P. Configuration Name		STEP II



Name	Signature	Date	Weight[kg]	TITLE
Drawn	G. Górka	14.09.2026		
Checked	A. Żuchowski	14.09.2026	Size	
Approved	T. Bargiel	14.09.2026	A4	
MTB GROUP		REV: 0	Drawing no.	Art. no.
ul. Mickiewicza 40, 32-400 Myślenice		Scale	STEP II	

STEP 2 - Parts and fastening

Assembly notes

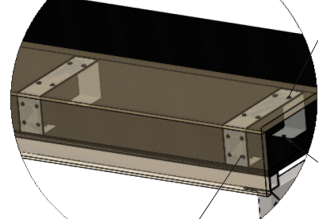
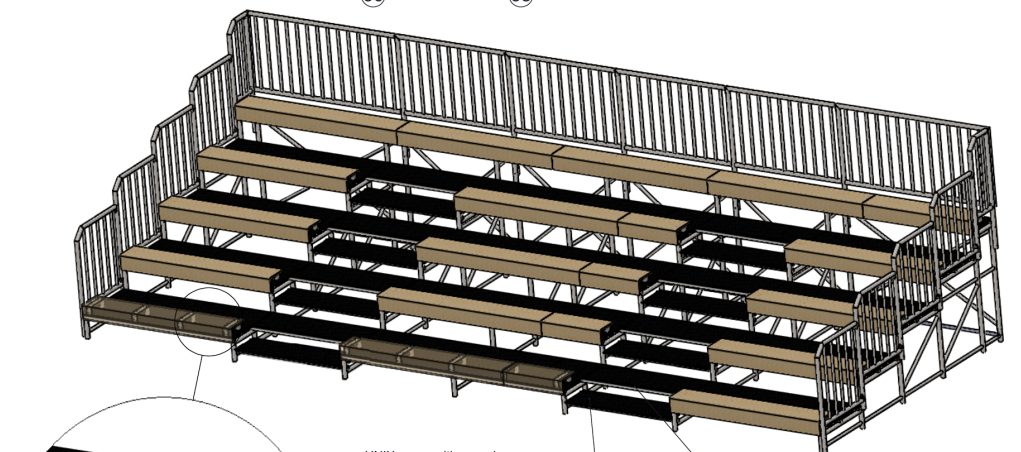
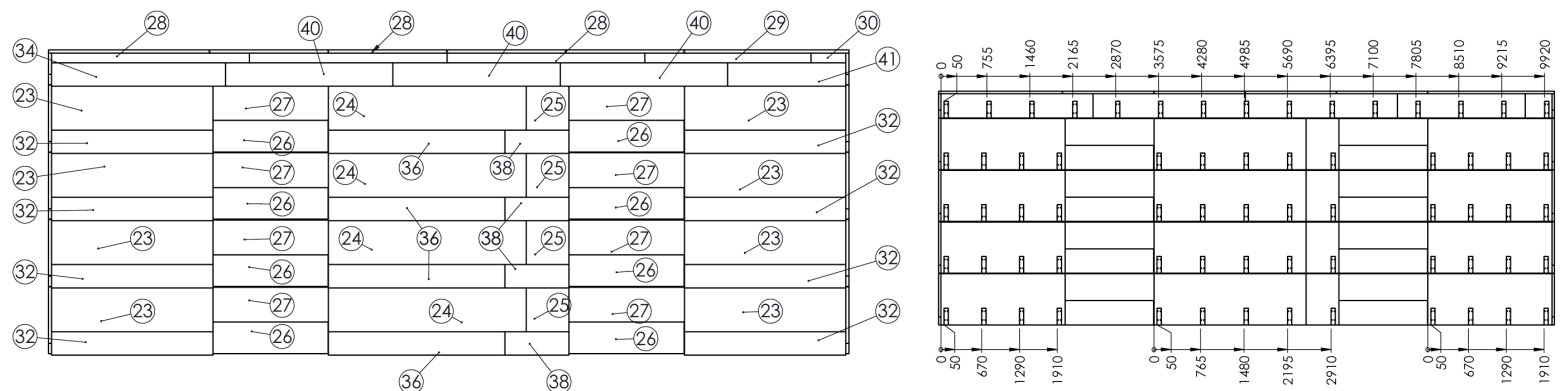
- Install the struts, rear guardrails and side rails at the numbered positions shown in the assembly drawing.
- Fasteners according to the drawing: M10x60, M10x80 and M10x100, each with washer and nut.

Nr.	Description	Qty
22	Strut 1500 R5	4
21	Strut 2000 R5	2
20	Square tube 30x30, L=4030	1
19	Square tube 30x30, L=6000	1
18	Rear guardrail L1500	4
17	Corner barrier L2040	1
16	Side rail - 1 row	2
15	Rear connecting barrier L2000	1
14	Intermediate side rail	6
13	Supplementary side rail	2
12	Platform beam (40x40) L=4040 - 1	2

Nr.	Description	Qty
11	Platform beam (40x40) L=6000 - 1	2
10	Platform beam (40x40) L=1540	16
9	Platform beam (40x40) L=4040	8
8	Platform beam (40x40) L=6000	8
7	Platform beam (40x40) L=3040	4
6	Platform beam (40x40) L=2040	8
5	Frame 5-rows S300, G850 - right	1
4	Frame 5-rows S300, G850 - intermediate right	1
3	Frame 5-rows S300, G850 - steps right	2
2	Frame 5-rows S300, G850 - steps left	2
1	Frame 5-rows S300, G850 - left	1

STEP 3 - Anti-slip panels, bench boards and fastening

Original assembly drawing - item numbering and dimensions correspond with the parts list on the next page.



UNIX screw with a washer
head threaded 6x16

Ribbed aluminum
Angle bracket fastened with 4.2x16 screws

Phosphated screw 3.5x25mm,
10 pieces per plywood

M8x40
Nut M8
Washer

UNIX screw with a washer
head threaded 6x16

43	Bench 170x18	=1495	1
42	Bench 170x18	=1495	1
41	Bench 295x18	=1495	1
40	Bench 295x18	=1495	1
39	Bench 170x18	=1495	1
38	Bench 295x18	=1495	1
37	Bench 170x18	=1495	1
36	Bench 295x18	=1495	1
35	Bench 170x18	=1495	1
34	Bench 295x18	=1495	1
33	Bench 170x18	=1495	1
32	Bench 295x18	=1495	1
31	Bench 170x18	=1495	1
30	Anti-slip plywood 440x400		1
29	Anti-slip plywood 2100x400		1
28	Anti-slip plywood 2500x400		1
27	Anti-slip plywood 1450x440		1
26	Anti-slip plywood 1455x400		1
25	Anti-slip plywood 540x840		1
24	Anti-slip plywood 2500x840		1
23	Anti-slip plywood 2040x840		1
22	Strut 1500 R5		1
21	Strut 2000 R5		1
20	Square tube 30x30, L=4030		1
19	Square tube 30x30, L=6000		1
18	Rear guardrail L1500		1
17	Rear connecting barrier L2000		1
16	Corner barrier L2040		1
15	Side rail - 1 row		1
14	Intermediate side rail		1
13	Supplementary side rail		1
12	Platform beam 40x40, L=4040 - 1		1
11	Platform beam 40x40, L=6000 - 1		1
10	Platform beam 40x40, L=1540		1
9	Platform beam 40x40, L=4040		1
8	Platform beam 40x40, L=6000		1
7	Platform beam 40x40, L=3040		1
6	Platform beam 40x40, L=2040		1
5	Frame 5-rows, S300, G850 - right		1
4	Frame 5-rows, S300, G850 - intermediate right		1
3	Frame 5-rows, S300, G850 - steps right		1
2	Frame 5-rows, S300, G850 - steps left		1
1	Frame 5-rows, S300, G850 - left		1
L.P. Configuration Name			ILOSC

Name	Signature	Date	Weight[kg]	TITLE
Drawn	G. Górka	14.09.2026		
Checked	A. Żuchowski	14.09.2026	Size	
Approved	T. Bargiel	14.09.2026	A4	
MTB GROUP		REV: 0	Drawing no.	Art. no.
ul. Mickiewicza 40, 32-400 Myślenice		Scale	STEP III	

STEP 3 - Parts and fastening

Assembly notes

- Ribbed aluminium: fasten the angle bracket with 4.2x16 mm screws.
- Use phosphated 3.5x25 mm screws: 10 pieces per plywood panel.
- Other fastening according to the detail drawing: UNIX 6x16 washer-head screw and M8x40 with M8 nut and washer.

Nr.	Description	Qty
43	Bench 170x18, L=1495	1
42	Bench 170x18, L=2115	3
41	Bench 295x18, L=1495	1
40	Bench 295x18, L=2115	3
39	Bench 170x18, L=810	4
38	Bench 295x18, L=810	4
37	Bench 170x18, L=2230	4
36	Bench 295x18, L=2230	4
35	Bench 170x18, L=2200	1
34	Bench 295x18, L=2200	1
33	Bench 170x18, L=2040	8
32	Bench 295x18, L=2040	8
31	Seat bracket	67
30	Anti-slip plywood 440x400	1
29	Anti-slip plywood 2100x400	1
28	Anti-slip plywood 2500x400	3
27	Anti-slip plywood 1460x440	8
26	Anti-slip plywood 1455x400	8
25	Anti-slip plywood 540x840	4
24	Anti-slip plywood 2500x840	4
23	Anti-slip plywood 2040x840	8
22	Strut 1500 R5	4

Nr.	Description	Qty
21	Strut 2000 R5	2
20	Square tube 30x30, L=4030	1
19	Square tube 30x30, L=6000	1
18	Rear guardrail L1500	4
17	Rear connecting barrier L2000	1
16	Corner barrier L2040	1
15	Side rail - 1 row	2
14	Intermediate side rail	6
13	Supplementary side rail	2
12	Platform beam (40x40) L=4040 - 1	2
11	Platform beam (40x40) L=6000 - 1	2
10	Platform beam (40x40) L=1540	16
9	Platform beam (40x40) L=4040	8
8	Platform beam (40x40) L=6000	8
7	Platform beam (40x40) L=3040	4
6	Platform beam (40x40) L=2040	8
5	Frame 5-rows S300, G850 - right	1
4	Frame 5-rows S300, G850 - intermediate right	1
3	Frame 5-rows S300, G850 - steps right	2
2	Frame 5-rows S300, G850 - steps left	2
1	Frame 5-rows S300, G850 - left	1