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**Apparatus and method for assembling a press box through the use of modular componentry**

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## ABSTRACT OF THE DISCLOSURE

A press box generally made from a plurality of modules assembled together wherein each module includes a plurality of tubes or beams and columns arranged to form a box-like frame structure. The modules can be connected to one another in a vertical or horizontal arrangement. Roof modules may be secured to the uppermost module and all modules are secured together. Nuts and bolts, welding, or other means can be used to secure connector plates on the box-like frames to corresponding connector plates or to secured adjacent tubes of different press box modules. The box-like modules can include a doorway, electrical wiring, windows, tables, counters, lights, flooring, ceilings, and be accessible by staircase. Balconies may be secured to one side of the modules as desired. The modules may be individually assembled in a first location, transported to a second location and secured to one another to form a press box.

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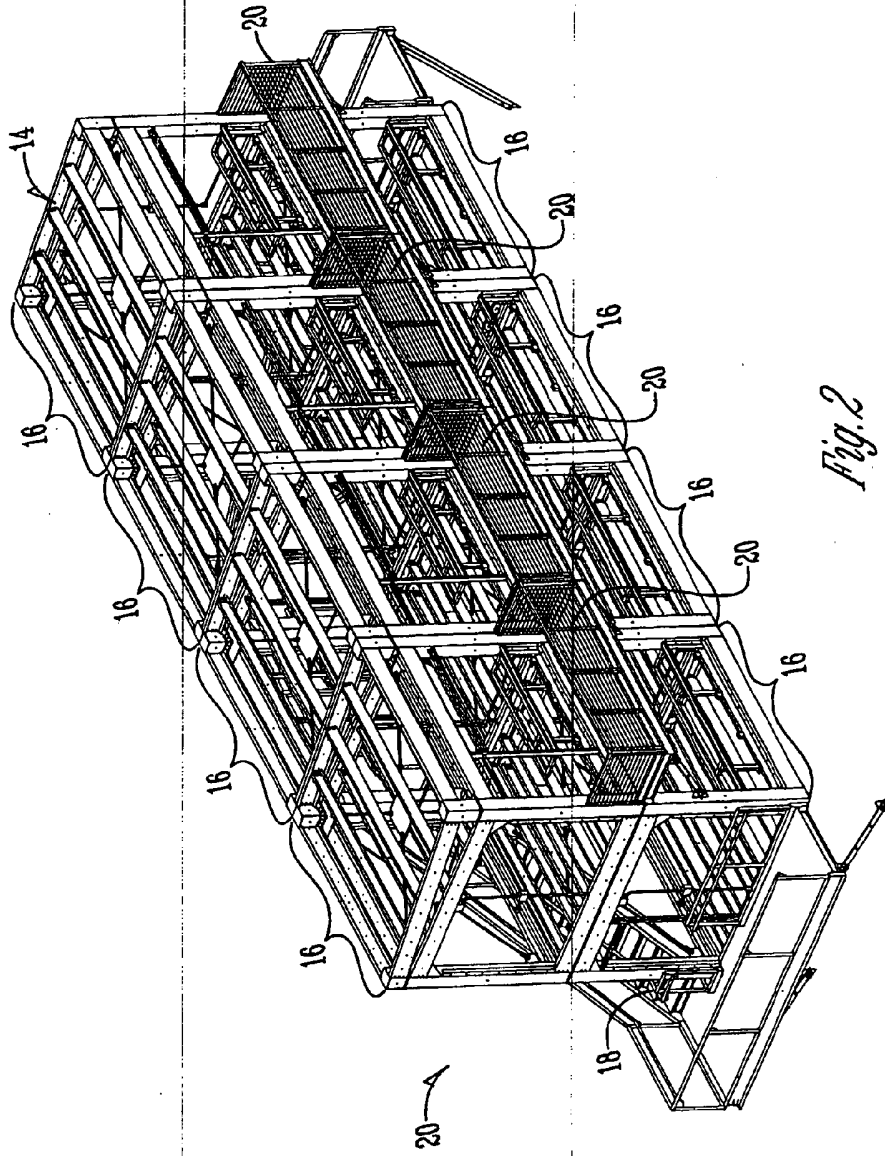


Fig. 2

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**AUSTRALIA**  
**PATENTS ACT 1990**  
**COMPLETE SPECIFICATION**

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INVENTION TITLE:

Apparatus and method for assembling a press box through the use of modular componentry

The following statement is a full description of this invention, including the best method of performing it known to me/us:-

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## BACKGROUND OF THE INVENTION

### 5 Field of the Invention

The present invention relates generally to an apparatus and method for use in construction of a press box. Press boxes are typically employed at football, soccer, track or racing stadiums. More particularly, though not exclusively, the present invention relates to an apparatus and method for constructing such press boxes in modular fashion.

### 10 Problems in the Art

As is noted in U.S. Patent No. 6,457,281 to Teron, the construction industry has been relatively slow in adopting new and developing technology. Generally, the construction industry has remained very labor intensive and of a handicraft nature. The end result is that construction projects are still expensive endeavors in terms of both money and  
15 time.

The Teron patent, mentioned above, attempts to overcome the labor and time intensive nature of the construction industry through the use of pre-cast concrete monolithic units. While such units can be cast in a variety of shapes and sizes, each casting forms a solid structural wall that is not easily prone to adaptation. For example, the use of  
20 windows or doors requires separate in-fill panels as such cannot be readily integrated into a pre-cast structure of concrete. Therefore, it is desirable to have a modular building system in which various wall structures, including doors and windows, can be easily added.

In the world of spectator events, press boxes are ideally located above the area of action. For example, in a high school football field setting, the press box is usually situated  
25 to one side of the field above all of the bleachers. Many press boxes also have more than one level from which to view the activity of interest. For these and other reasons, it is desirable to have modular units which are stackable without the need for additional supporting structures.

Whether a press box is used for a football, soccer, track, or other sporting event,  
30 several common features are desirable. For example, every press box will need some sort of viewing area as well as a plurality of counters, tables, chairs and other features typically used by the occupants thereof. Because the features of the press box do not tend to vary

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greatly whether the press box is used for football, soccer, or in conjunction with any other sporting arena, it is desirable to have a modular unit for constructing press boxes that easily incorporates many of the standard and desirable features of press boxes in use today.

5 Many arenas in use today are built with the assistance of public funds. Public funding is typically only awarded after a bidding process. During the bidding process, price, efficiency, and quality of the end product are of prime concern. It is therefore desirable to be able to offer a press box and method of constructing the same that minimizes production costs, increases production efficiency, and can be easily adapted to accommodate all of the customers demands. There is therefore a need for an apparatus and  
10 method of constructing a press box which avoids these and other problems.

#### Features of the Invention

A general feature of the present invention is the provision of an apparatus and method for constructing a press box which overcomes the problems found in the prior art.

15 A further feature of the present invention is the provision of an apparatus and method for constructing a press box which is easily adaptable for use in many different arenas.

Another feature of the present invention is the provision of an apparatus and method for constructing a press box which allows the press box to be easily customized for any particular customers desires.

20 A still further feature of the present invention is the provision of an apparatus and method for constructing a press box, which allows the press box to include windows, doors, balconies, benches, seats and other features at a variety of locations.

A further feature of the present invention is the provision of an apparatus and method for constructing a press box, which uses modular units.

25 Another feature of the present invention is the provision of an apparatus and method for constructing a press box which incorporates modular units that are stackable.

A still further feature of the present invention is the provision of an apparatus and method for constructing a press box which simplifies the on-site construction process.

30 Another feature of the present invention is the provision of an apparatus and method for constructing a press box which minimizes assembly time.

A still further feature of the present invention is the provision of an apparatus and method for constructing a press box which minimizes construction costs.

Another feature of the present invention is the provision of an apparatus and method for constructing a press box which allows additions to be made to existing  
5 structures easily.

These, as well as other features and advantages of the present invention, will become apparent from the following specification and claims.

#### SUMMARY OF THE INVENTION

The present invention generally comprises an apparatus and method for  
10 constructing a press box through the use of a plurality of press box modules. In one embodiment, a plurality of press box modules are formed offsite. Each press box module generally includes a box-like frame having a number of structural supports built therein. Preferably, each press box module is of a standardized size and shape such that one module  
15 may be easily stacked upon another module in a block like fashion.

When assembled, each module preferably includes a plurality of steel columns or steel tubes at its corners. The steel columns are connected to one another by steel beams which may be secured to the columns through welding, screws, or any other well known method. Each column is preferably topped with a connector plate that acts as both a supporting platform and a means for connecting various modules in a vertical arrangement.  
20 Each module also includes a plurality of side beams that provides structural support. Each beam is preferably half of an I-beam or generally C-shaped. This presents the outer edge of the module with a flat surface. By keeping the outer surfaces flat, beams in different modules can be easily connected by including a plurality of corresponding holes in each beam and securing the beams there through. Securement can be performed with nuts and  
25 bolts, welding or any other known securing means.

In another embodiment, construction is further simplified by using steel tubing for both the columns and beams. The added strength associated with the use of steel tubing allows construction of the modules to be done with minimal reinforcing materials. This allows for an open cross-section and thereby provides limitless opportunity for walk ways,  
30 placement of doors, windows, benches, electrical fittings and other desirable interior appointments. Using a plurality of steel tubing also minimizes the variety of materials

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needed, allowing for increased efficiency in both ordering and construction. These modules, formed primarily of steel tubing, can be secured to one another using welding, nuts and bolts or any other known securing means.

Using either of the above mentioned embodiments, the modules can be rapidly assembled and stacked to form a press box of any desirable shape or size. Because easily modifiable framing elements are used instead of pre-cast structures, various elements are easily added to a press box module. For example, door jambs can be created using L-arm structural steel members, aluminum framing, or wood. In a similar fashion, window sills can be arranged to accommodate a variety of window sizes and shapes without the need to alter the pre-existing box frame. Each of these elements may be secured to the box frame of the pieces directly or of suitable connector pieces.

Each box frame also preferably includes flooring at a pre-determined and consistent level in each box frame. The flooring is generally formed from a plurality of flooring joist secured between the flooring beams by plurality of connector tabs. The flooring joist may be made of wood or metal or even adapted to support concrete slabs. In a similar manner, ceiling joist preferably run along the top of the box frame.

After the flooring construction is completed, a variety of built-in componentry can be added. For example, if the customer desires a countertop underneath the window or viewing area, a counter can be pre-installed. Additionally, electrical conduit including a plurality of electrical boxes and switchboxes at desired locations may be inserted before wall finishing is completed

On the top of the uppermost press box module, it is typically desirable to include a roof structure. The roof structure or roof module may be formed from either a column and beam or the steel tubing arrangement. In the column and beam arrangement, the roof module preferably includes a plurality of connector plates corresponding to the connector plates on the top of the press box module. This allows for nut and bolt connections to be easily made. Alternatively, in the steel tubing arrangement, the roof module may be easily welded to the tubing of the press box module below. Either arrangement can be secured together and to the corresponding box module below using any known method.

Pre-assembling the roof module allows it to be easily connected with minimal on-site customization. Each roof module may include a roof that is angled at a pre-determined



level and generally includes a plurality of roofing beams or additional tubes having connector tabs secured thereto. Between the roofing beams or tubes are a plurality of roofing struts that support the actual roofing material. By connecting the roof beams or tubes between two roof columns or additional tubes of varying heights, the roof angle can  
5 be controlled.

Additional structures may be added to the outside of the press box modules, including a staircase for upper level access, and balconies if outdoor viewing is desirable. Both the balconies and the staircases may be easily bolted or otherwise connected to each press box module as desired. Balconies may be preinstalled before all of the modules are  
10 assembled into the final press box. Once modules are assembled or stacked, a balcony accessible in one module may be supplementally supported through a beam connection to a lower module. Additional structural supports may be used throughout the modules, including gusset plates with corresponding bracing rods. These keep the modules in  
15 tension and therefore minimize the amount of structural flex that may be inherent in each box frame.

Once all of the individual modules are assembled, standard finishing materials such as drywall, carpeting, lighting, etc. may be applied to give the interior of the press box the desired appearance. Further, after module assembly is complete, siding material may be added to give the outside of the press box a finished appearance.

## 20 BRIEF DESCRIPTION OF THE DRAWINGS

The various features and advantages of the invention will become more apparent from the following description of the preferred embodiments of the same wherein references made to drawings including:

Figure 1 is a perspective view of one embodiment of the modular press box in  
25 assembled form as would be installed at an arena.

Figure 2 is a front view of the press box module assembly of Figure 1.

Figure 3 is an exploded view of one embodiment of the press box module assembly showing individual modules separated from one another.

Figure 4 is an exploded view of another embodiment of the press box module  
30 assembly showing individual modules separated from one another.

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Figure 5 is a side view of a typical roof tube, ceiling tube or flooring tube to which connector tabs have been installed.

Figure 6 is a cross-sectional view of the sidewall of one embodiment of a press box module in finished form.

5 Figure 7 is a cross-sectional view of the connection between one embodiment of the roof module and one embodiment of the press box module.

Figure 8 is a cross-sectional view of one embodiment of the flooring installed in a press box module.

#### DETAILED DESCRIPTION OF THE INVENTION

10 Referring now to Figure 1, there is illustrated a perspective view of the modular press box 10 installed in conjunction with a series of bleachers 12 at a stadium 14. The press box 10 is preferably made from a variety of steel structures, including steel tubes, beams, columns, L-arm members, plates, brackets, rods, etc. Alternatively, other materials, such as aluminum, wood, composites, or plastic materials may be substituted as desired so  
15 long as the strength and integrity of the press box 10 is not compromised. As is shown in Figure 1, the press box 10 is built up of a variety of press box modules 16. The modules 16 may be arranged to provide an elongated structure with one or more floors as shown.

A typical press box 10 is placed in an elevated position to allow the members of the press, announcers, coaching staff, and other individuals the desired advantage point. Any  
20 number of press box modules 16 may be used until the desired height is reached. Alternatively, the press box modules 16 and the press box 10 in its entirety may be elevated on a supporting platform or base structure, so long as the desired advantage point is reached. A preferred supporting platform (not shown) is constructed of steel beams or columns which are reinforced using a plurality of gusset plates and bracing rods. As the  
25 typical vantage point is an elevated one, stairs 18 may be secured to one or more press box modules 16 so that access to the press box 10 may be had from ground level. Alternatively, an elevator (not shown) may be assembled and secured as desired.

Referring now to Figure 2, each press box module 16 may include a balcony 20 secured thereto. Each press box module 16 may be designed to include its own balcony 20,  
30 to have no balcony 20, or to have a balcony 20 that connects with the balconies 20 of other modules 16. Also shown in Figures 1 – 4 are a plurality of roof modules 22. By stacking

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the individual press box modules 16 in the desired arrangement and securing roof modules 22 on the uppermost press box module 16, the desired final shape of the press box 10 can be realized.

5 As many sporting events have a very limited off-season time period, it is desirable to keep on-site assembly time to a minimum. By using preformed press box modules 16 in conjunction with preformed roof modules 22, on-site assembly time can be easily managed and minimized. Thus, a module press box 10 can be easily assembled during the off-season time available causing minimal inconvenience to the purchasing customer.

10 As is shown in Figures 3 and 4, each of the modules 16 may be formed by creating a box-like frame structure. For example, Figure 3 illustrates that square steel tubing, preferably  $\frac{1}{4}$  inch thick, 8 inch by 8 inch steel tubing, is using to form a plurality of columns 24 placed at the corners of the box-like frame structure. Each of the columns 24 are connected to one another through the use of a plurality of beams 26. The beams 26 are preferably generally C-shaped as shown. A cross-sectional view of one such beam 26 is  
15 shown in Figure 6.

Additionally, beam support brackets (not shown) may be secured between the beam 26 and the column 24 to provide additional structural strength if needed. The support brackets are preferably steel plates that are simply welded in place once the beam 26 has been secured to the column 24. The beam 26 may be secured to the column 24 through  
20 welding, bracketry, or any other known method. Additionally, when it is known a customer will not desire to passthrough the beam 26 and column 24 arrangement, i.e. that it will be a solid wall, additional bracing materials may be employed. For example, as shown in Figure 1, a plurality of gusset plates 32 are secured to the corners of the beam 26 and column 24 assembly. A central gusset plate 32 allows a plurality of bracing rods 30 to be  
25 connected to enhance the rigidity of the overall wall formed by the beams 26 and columns 24.

In another embodiment of the present invention, the press box module 16 using steel tubing 25 in place of the columns 24 and beams 26 as shown in Figure 4. Using 8 inch by 8 inch  $\frac{1}{4}$  inch thick steel tubing allows for construction of press box modules 16  
30 without the need for additional bracing materials. This arrangement maximizes the interior space of the press box module 16 while minimizing construction time and cost.

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A wall formed by either the beams 26 and columns 24, as shown in Figure 3, or the tubing 25, as shown in Figure 4, may also be fitted to include a variety of additional elements. For example, as shown in Figure 4, a door jamb 34 has been installed. The door jamb 34 generally includes a plurality of L-arm or other bracketry 40 arranged to  
5 accommodate the desired door size. The door jamb 34 is generally made by using a header 36 and retaining member 38 which can be spot welded into place or alternatively screwed into the tubes 25 or beam 26 and post 24. Alternatively, the bracketry 40 can be arranged merely to accommodate the desired opening between rooms in the press box 10.

Typically one module will become one room in the press box 10. However, the  
10 open wall provided by the beam 26 and column 24 arrangement or the tube 25 arrangement, allows multiple modules 16 to be assembled to form one room. Alternatively, rooms may be broken up in any desired fashion.

Additionally, other features may be added to the press box module 16. A counter  
42, shown in Figures 3 and 6 may be installed in any desired location. As is shown in  
15 Figure 6, it is usually desirable in a press box 10 to have a counter 42 close to a window 52. The counter 42 can be secured directly to the flooring 58 such that the countertop 56 abuts against the window wall. As is also shown in Figure 6, the flooring 58 is generally secured to the beam 26 through the use of an L-arm bracket 40. The L-arm bracket 40 is preferably a steel member that is supplementally supported through one or more support tabs 66,  
20 generally shown in Figure 5.

Referring again to Figure 3, electrical conduit 46 as well as corresponding electrical  
boxes 48 and switch boxes 50 may be placed as desired throughout the box-frame structure of any press box module 16. Preferably, the electrical and countertop work is not performed until the floor 58 has been formed.

25 The floor 58 is generally secured in the same manner as the deck or balcony 20. As is shown in Figure 6, the flooring 58 or balcony 20 is formed by initially welding a plurality of support tabs 66 to the inside of C-shaped beam 26. Next, an L-arm bracket 40 is welded or otherwise secured to the beam 26 and support tabs 66. Preferably, an aluminum deck structure or concrete slab 58 is secured to the L-arm brackets 40 through  
30 the use of a puddle weld, cement screws or other securing means. When this arrangement is to be used for a flooring section, the aluminum deck or concrete slab 58 provides a solid

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surface over which carpet, tile, or other desired flooring material may be placed. As is also shown in Figures 3 and 4, flooring support joists 80 may be secured in a similar fashion. The flooring beams 82, also the bottom beams 26 or bottom tubes 25, may be fitted with a plurality of flooring connector tabs 84 to accommodate a plurality of transversely placed  
5 flooring joists 80. The flooring connector tabs 84 are preferably secured to the flooring beams 82 or bottom beams 26 or tubes 25 through welding, though any other securing method may be used.

10 Preferably, the flooring tabs 84 have a plurality of holes therein that correspond to a plurality of holes in the flooring joists 80. This allows the flooring joists 80 to be rapidly assembled into proper position using nuts and bolts, though any type of securing method may be used. The flooring joists 80 thereby provide additional support to the decking or flooring material 58 previously discussed. Ceiling joists 86 may be similarly installed between ceiling beams 88, the upper most beams 26 or upper most tubes 25, using ceiling connector tabs 90.

15 Alternatively, the flooring 58 may be secured on top of I-beam flooring joists 80 and the flooring beams 82 made from bottom tubes 25 as is shown in Figure 8. The shape of the steel tubing 25 provides for additional support for the flooring 58 eliminating some of the additional supports required for the beam 26 and column 24 arrangement. A C-channel member 83 having a flat outer edge may be placed to meet the end of the flooring  
20 58. This provides a finished outer surface that may be easily adapted for finishing materials.

Referring again to Figure 6, a window 52 may be installed into a wall of the press box 10 by employing smaller C-shaped steel bracketry to form a window seal 44. Wood framing 54 may be used to ensure a weather tight fit of the window 52. Again, the open  
25 area format of the beam 26 and column 24 wall arrangement or the tube 25 wall arrangement allows a wide variety of shapes and sizes for the window 52. Once the window 52 has been installed, closure plates, typically provided by a siding supplier, can be employed to ensure the wall is weather tight.

During assembly of the beam 26 and column 24 arrangement of the individual press  
30 box modules 16 and referring to Figure 7, a plurality of connector plates 70 are preferably placed on the upper and lower portions of the columns 24 or at other alternative locations

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as desired. Preferably, the connector plates are 14 inch square, ¼ inch thick steel plates that have a plurality of holes therein. Each connector plate 70 is identical such that the connector plates 70 from one module 16 may easily align with the connector plates 70 of another module 16. In order to minimize assembly time and ease installation, the  
5 connector plate 70 are substantially larger than the cross-sectional area of the columns 24. It is in this access area that hangs over the column 24, that holes may be placed.

As is also shown in Figure 7, when the roof module 22 or any other module 16 is formed in the beam 26 and column 24 arrangement, they may be assembled by matching up the holes in the connector plates 70 and securing the upper connector plate 70 to the lower  
10 connector plate 70 with a plurality of bolts 64 and nuts 62. As is also shown in Figure 7, the column 24 may include an additional bracket or gusset plate 32 to which bracing rods 30 may be installed as previously discussed. This allows the columns 24 to put pressure on the beams 26, thereby strengthening the overall rigidity of the entire box-frame press box module 16.

15 As the connector plates are used to secure the various press box modules 16 together in a vertical arrangement, so the beams 26 can be used to secure the press box modules 16 in a horizontal arrangement. As is shown in Figure 7, the beams 26 of the press box module 16 include a plurality of holes through which bolts 64 and nuts 62 can be secured.

20 Alternatively, when the tube 25 arrangement of the press box module 16 is used, the modules may be simply stacked on top of one another or side by side and then they are preferably welded together, preferably using a ¼ inch stitch weld every 2 inches. Any other connection means including welding, screws, etc. can be employed to secure one press box module 16 to another press box module 16 in a vertical arrangement. Thus, it  
25 can be seen how the various press box modules 16 can be added to form a press box 10 of any shape or size.

As is shown in Figure 3, the roof module 22, consists generally of two pairs of roof columns 76. One pair of roof columns 76 is at a pre-determined height with the other pair of roof columns 76 being at a slightly greater height. In this manner, the roof module 22  
30 can have a roof of any desired slope. In between the roof columns 76, roof beams 74 are placed. As is shown, the roof beams 74 are similar to the ceiling beams 88 and flooring

beams 82 in that a plurality of connector tabs 78 are welded thereto. The outer ends of the roof beams 74 have been mitered to correspond with the desired slope of the roof. In between the roof beams 74 are a plurality of roofing struts 72. The roofing struts 72 are secured to the connector tabs 78 through the use of screws, bolts and nuts, welding, or any other connective means.

Alternatively, the roof module 22 may be formed using steel tubes 25 as is shown in Figure 4. The roof columns and beams are formed of steel tubes 74 cut to the desired length and angled or mitered to provide the desired roof shape. As is shown in Figure 5, the connector tabs 78 are placed on the tubes 25 in the same manner as the connector tabs 84 and 90 for the flooring and ceiling respectively.

After each of the press box modules 16 are completed in the desired fashion and assembled to form the press box 10, finishing materials, such as carpeting, siding, insulation, drywall, paint, wallpaper, lighting, etc. may be installed according to the customer's specifications. The manner of installing all of these elements over an existing steel frame structure is well known in the art.

By making the internal framework in modular form, the entire process may be expedited while still providing the customer with a high quality, customizable end product. It is preferred that the individual press box modules 16 are prefabricated as much as possible at the shop or first location. This would include building in almost all of the electrical systems, heating and ventilation systems, flooring systems, doors, benches and countertops as desired. Once assembly of the individual press box modules 16 is completed to the extent possible, the modules are transported to the construction site or second location. Preferably, the modules 16 are loaded onto a semi-truck trailer for transport. By using the box-frame styles mentioned herein, the size of the individual press box modules 16 can be limited to the height and width allowed to travel down interstate highways without the need for special permits or warning vehicles.

At the construction site, the individual modules 16 are unloaded and placed into the desired position. They are then secured together as previously discussed and staircases 18, balconies 20, and other exterior appointments are added. The roof modules 22 are added and the exterior finishing, including roofing and siding may be completed. The final interior appointments and well-known press box components, including lights, sound

systems, computers, chairs, wall finishing materials, and any other customer desired appointments can be added on site to produce the press box 14 desired by the customer. In this manner, it can be seen that the modular approach to building a press box 10 saves time, money and minimizes inconvenience for the customer.

5           The modular press box 14 also allows for additions to be easily made. After completing a full press box 14, individual modules 16, 22 can be added by simply removing the exterior appointments to expose the steel beam, column or tube. Then additional modules can be connected in the usual fashion and exterior appointments re-attached to form a new and expanded press box 14.

10           A general description of the present invention as well as a preferred embodiment of the present invention has been set forth above. Those skilled in the art to which the present invention pertains will recognize and be able to practice additional variations in the methods and systems described which fall within the teachings of this invention. Accordingly, all such modifications and additions are deemed to be within the scope of the  
15 invention which is to be limited only by the claims appended hereto.

Throughout this specification and the claims which follow, unless the context requires otherwise, the word "comprise", and variations such as "comprises" and "comprising", will be understood to imply the inclusion of a stated integer or step or group of integers or steps but not the exclusion of any other integer or step or group of integers or steps.

The reference to any prior art in this specification is not, and should not be taken as, an acknowledgement or any form of suggestion that that prior art forms part of the common general knowledge in Australia.



THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS :

1. A modular press box for quick installation at a desired location, the press box comprising: a first module having a box structure and associated press box components; a  
5 second module with other associated press box components and designed to fit the first module when placed on it so that the two form an integrated press box.
2. The modular press box of claim 1 wherein the first module includes a window.
- 10 3. The modular press box of claim 1 wherein the first module includes a door.
4. The modular press box of claim 1 wherein the first module includes a first connector plate having a plurality of holes and the second module includes a second connector plate having a plurality of holes that correspond in number and arrangement to  
15 the holes of the first connector plate.
5. The modular press box of claim 1 wherein the second module is a roof module.
6. The modular press box of claim 5 wherein the roof module includes a first pair of  
20 columns and a second pair of columns wherein the second pair of columns are taller than the first pair of columns.
7. The modular press box of claim 1 wherein the first module includes a floor.
- 25 8. The modular press box of claim 1 further comprising a stair case secured to the first module.
9. The modular press box of claim 1 further comprising a balcony secured to the side  
30 of the first module.

10. The modular press box of claim 1 further comprising a balcony secured to the side of the second module.
11. A method of constructing a modular press box, the method comprising: assembling  
5 a first module at a first location; assembling a second module at a first location; transporting the first module and the second module to a second location; connecting the first module to the second module at the second location to form a press box.
12. The method of constructing a press box of claim 10 wherein electrical conduit is  
10 installed in the first module.
13. The method of constructing a press box of claim 10 wherein a window is installed in the first module.
- 15 14. The method of constructing a press box of claim 10 wherein a door is installed in the first module.
15. The method of constructing a press box of claim 10 wherein a counter is installed in the first module.  
20
16. The method of constructing a press box of claim 10 wherein a floor is installed in the first module.
17. A method of assembling a press box in modular form; the method comprising:  
25 forming a first box frame; forming a second box frame; installing a floor support in the first box frame; installing a ceiling support in the first box frame; installing a window sill in the first box frame; securing the second box frame beside the first box frame; installing the second box frame and the first box frame in proximity to bleachers in a sports stadium.
- 30 18. The method of assembling a press box of claim 17 further comprising installing siding on the first box frame.

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19. The method of assembling a press box of claim 17 wherein the first box frame includes a first connector beam having a plurality of holes and the second box frame includes a second connector beam having a plurality of holes.
- 5 20. The method of assembling a press box of claim 19 wherein the holes of the first connector beam correspond in number and arrangement to the holes of the second connector beam.
- 10 21. The method of assembling a press box of claim 17 wherein the first box frame is welded to the second box frame.

22. A modular press box substantially as hereinbefore described with reference to the drawings and/or Examples.
23. A method of assembling a press box substantially as hereinbefore described with reference to the drawings and/or Examples.
24. The steps, features, compositions and compounds disclosed herein or referred to or indicated in the specification and/or claims of this application, individually or collectively, and any and all combinations of any two or more of said steps or features.

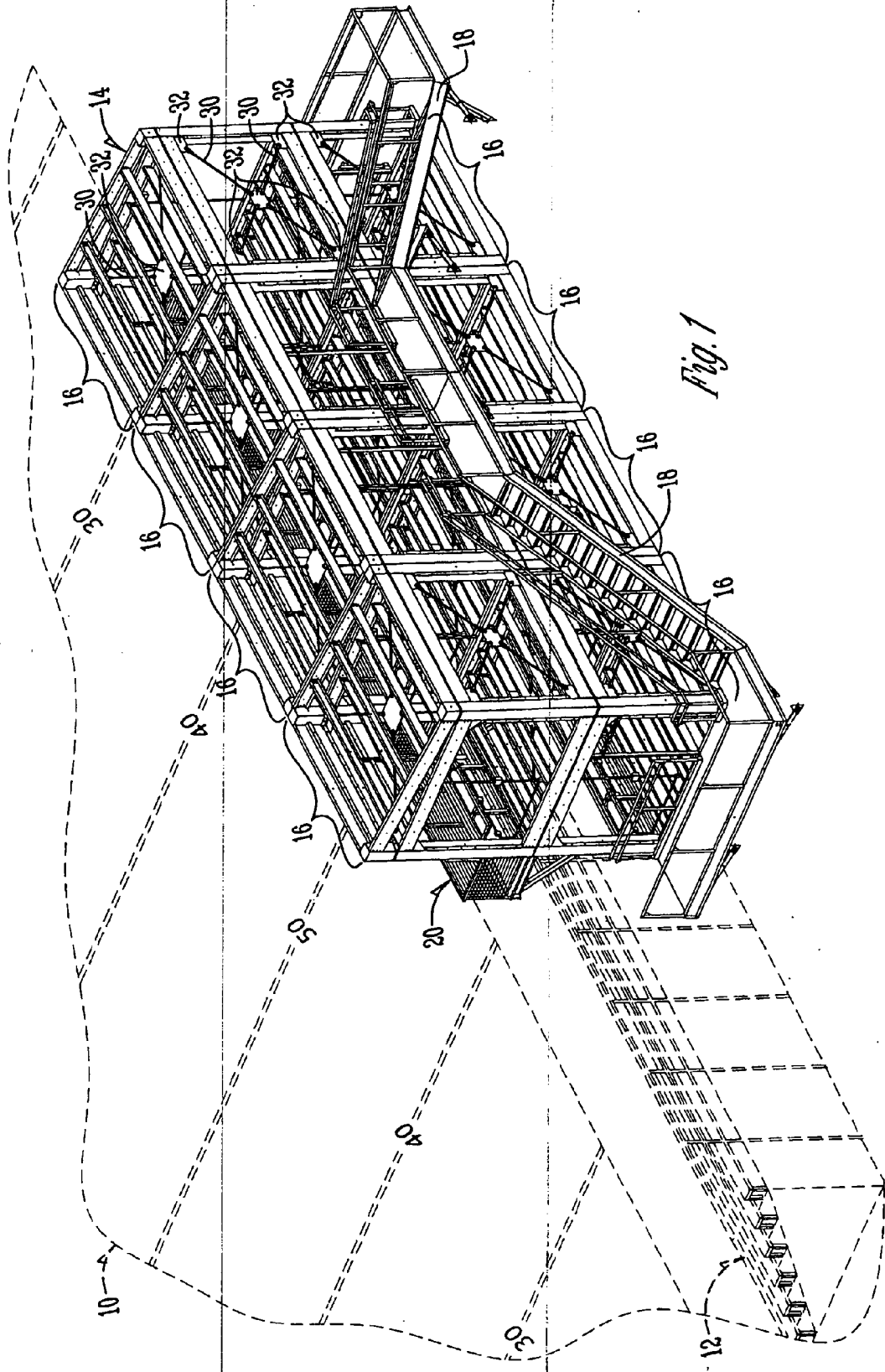
DATED this TENTH day of DECEMBER 2003

Jeffrey L. Johnson

by DAVIES COLLISON CAVE  
Patent Attorneys for the applicant(s)

Informals

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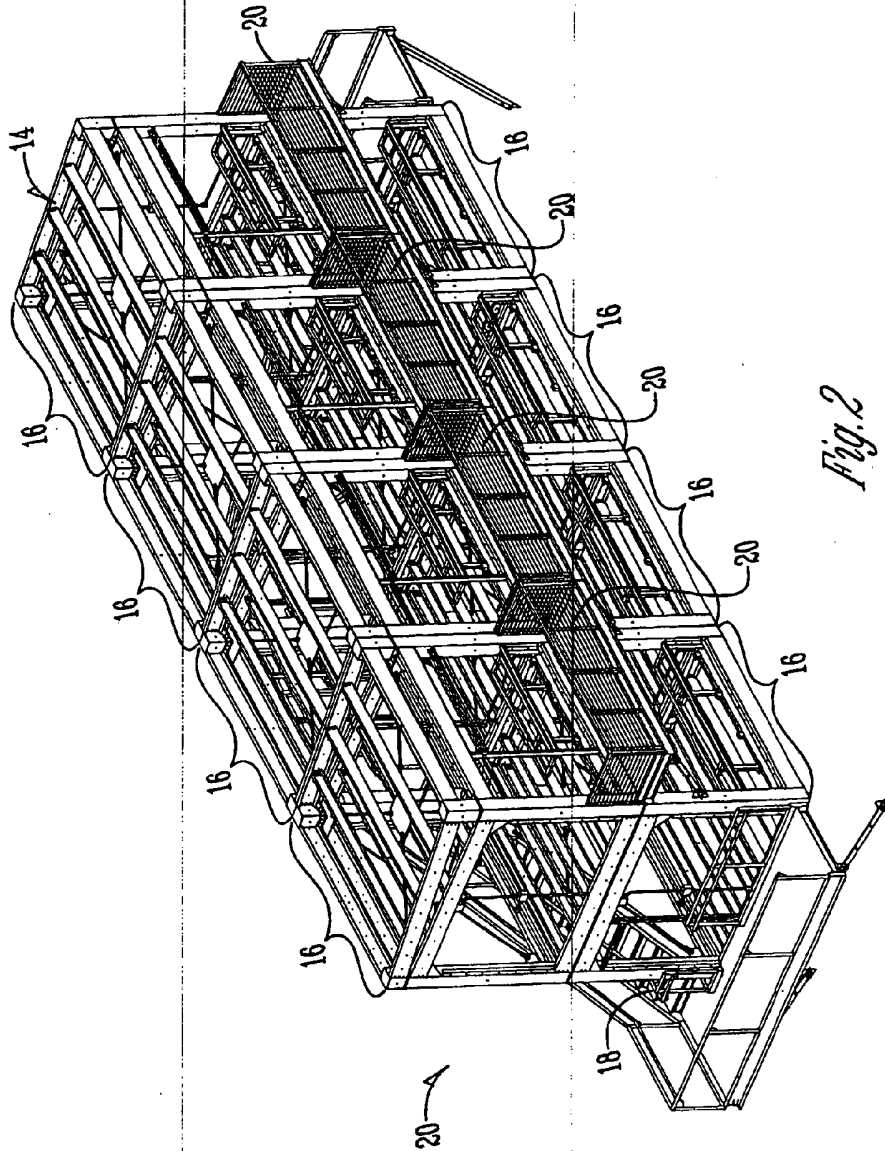


Fig. 2

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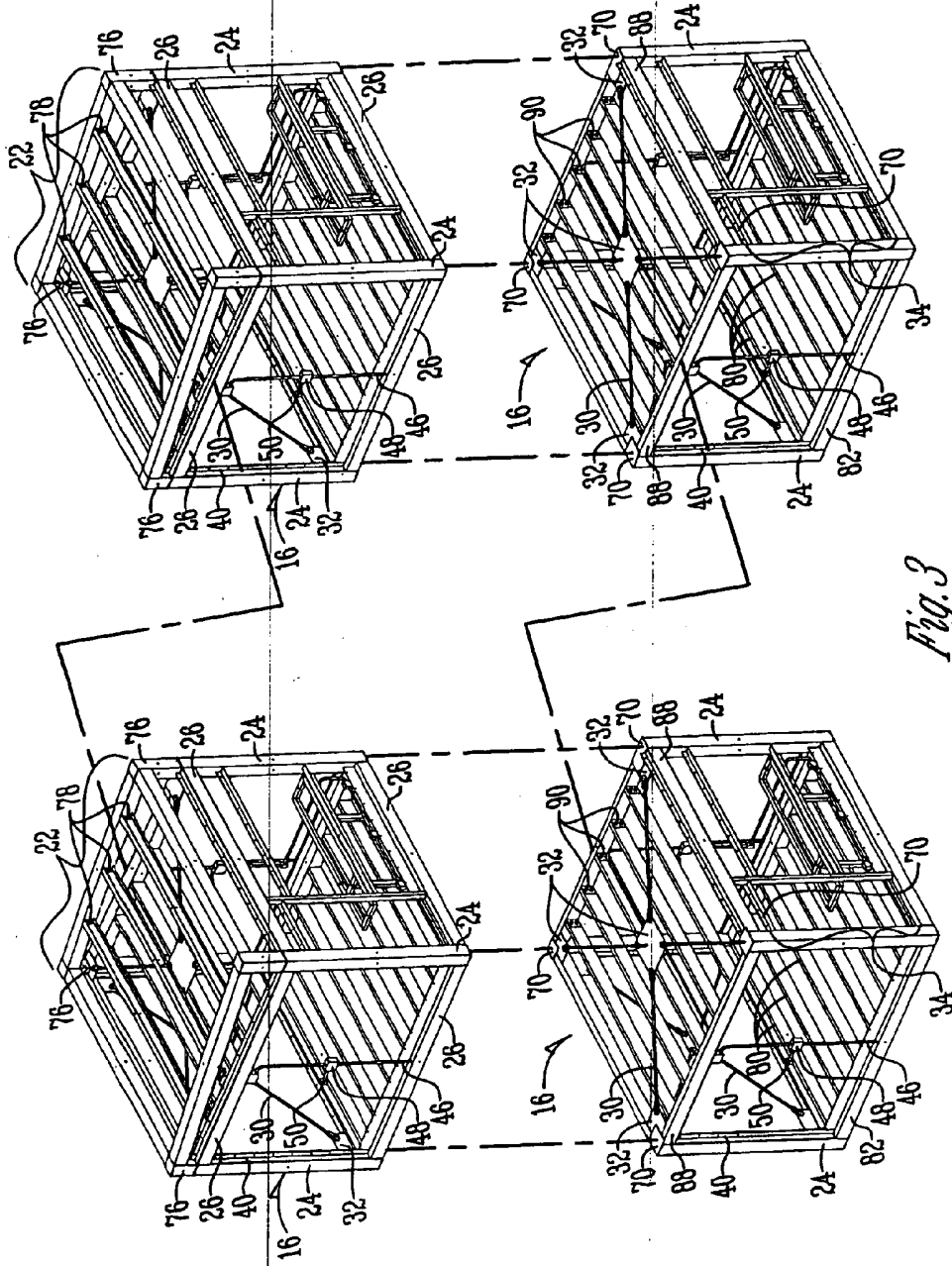


Fig. 3

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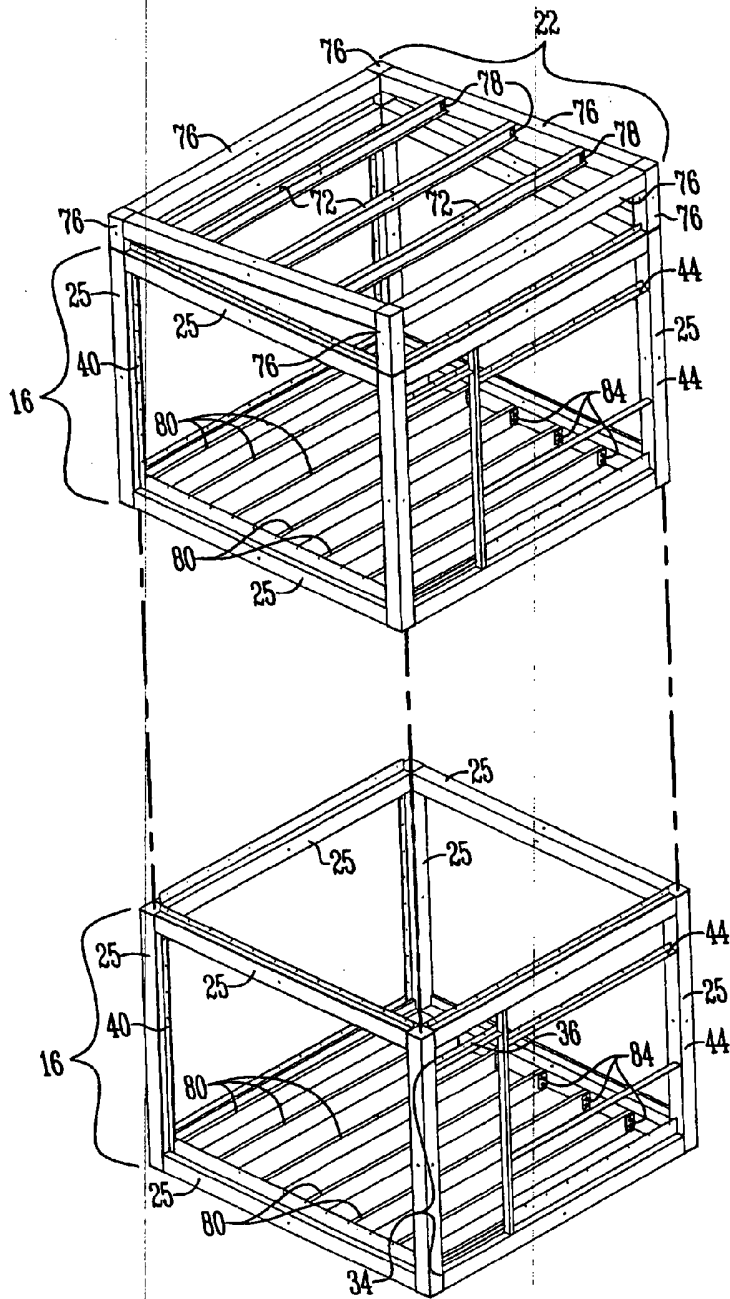
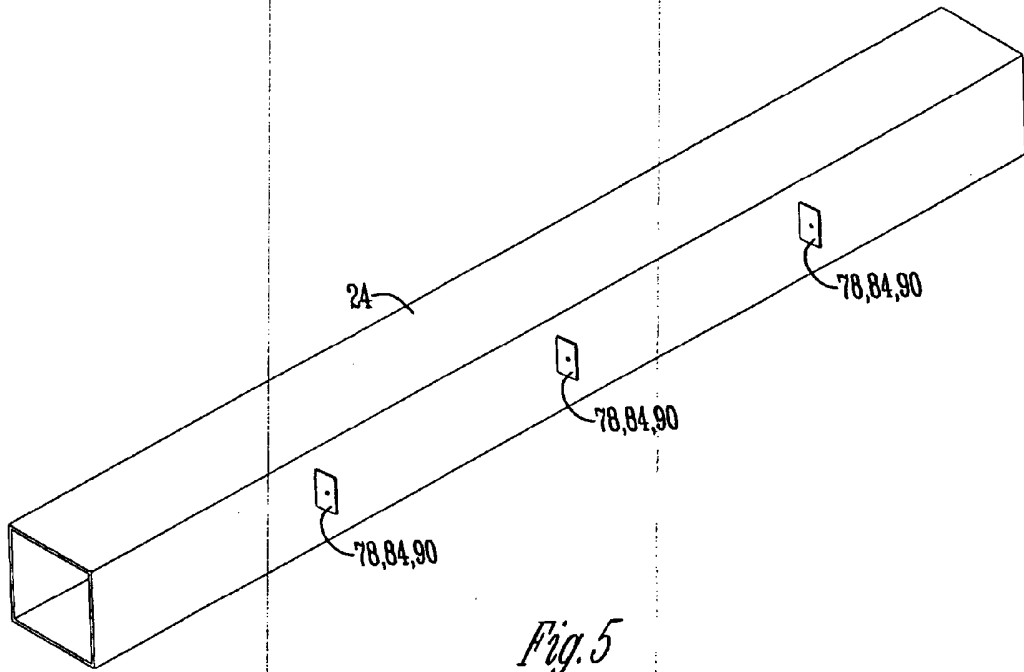


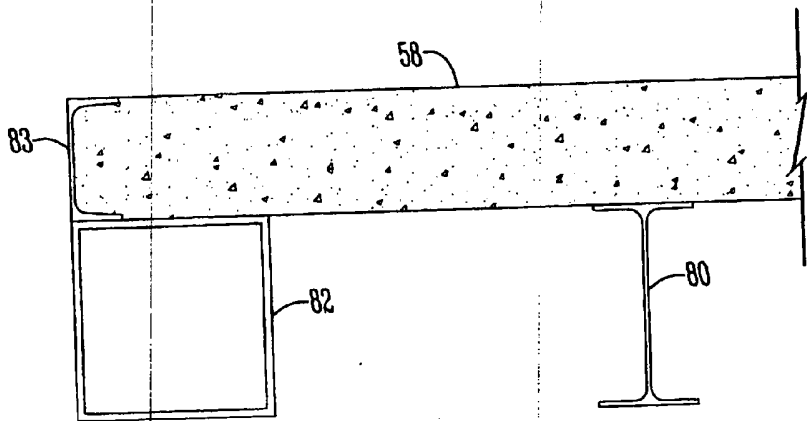
Fig. 4



5/6



*Fig. 5*



*Fig. 8*

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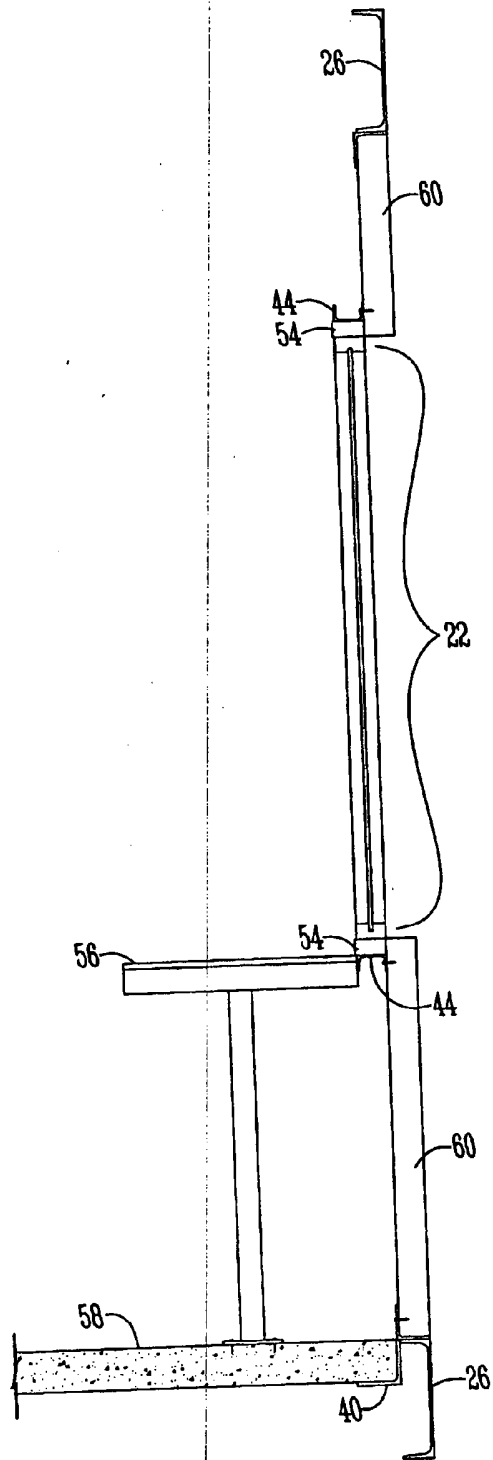


Fig. 6

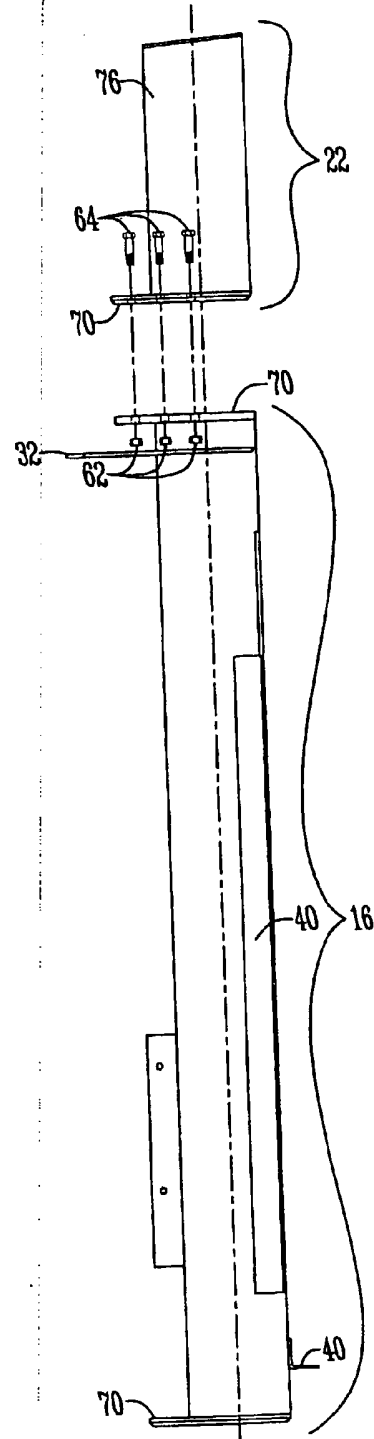


Fig. 7