

IM 540

ASSEMBLY INSTRUCTIONS

FOUR STACK MACHINE

540-OSI

TOOLS REQUIRED

- 1 6' STEP LADDER
- 1 TAPE MEASURE OR RULER
- 1 SOCKET WRENCH w/ 7/16 & 9/16
- 1 SET, SMALL ALLEN WRENCHES
- OPEN END WRENCHES 7/16 & 9/16
- 1 SMALL ADJUSTABLE WRENCH
- 1 PLIERS
- 1 MALLET OR HAMMER

Loop/Ball → Bolt

PRE-ASSEMBLY INSTRUCTIONS

- TWO PEOPLE ARE REQUIRED FOR SAFER AND EASIER ASSEMBLY.
- SEPARATE AND IDENTIFY ALL PARTS.
- SEPARATE AND IDENTIFY ALL NUTS, BOLTS, WASHERS, AND OTHER HARDWARE ITEMS BY SIZE.
- ALL BOLTED ASSEMBLIES REQUIRES A FLAT WASHER ON BOTH SIDES OF THE ASSEMBLY, UNLESS NOTED OTHERWISE.
- DO NOT TIGHTEN BOLTS ALL THE WAY, UNTIL THE MAIN ASSEMBLY (FIGURE ONE) IS COMPLETELY ASSEMBLED. THIS ALLOWS THE MACHINE TO ADJUST TO THE CONTOURS OR UNEVENNESS OF THE FLOOR.

IMAGE

6063 Frantz Road Suite 103 Dublin, OH 43017

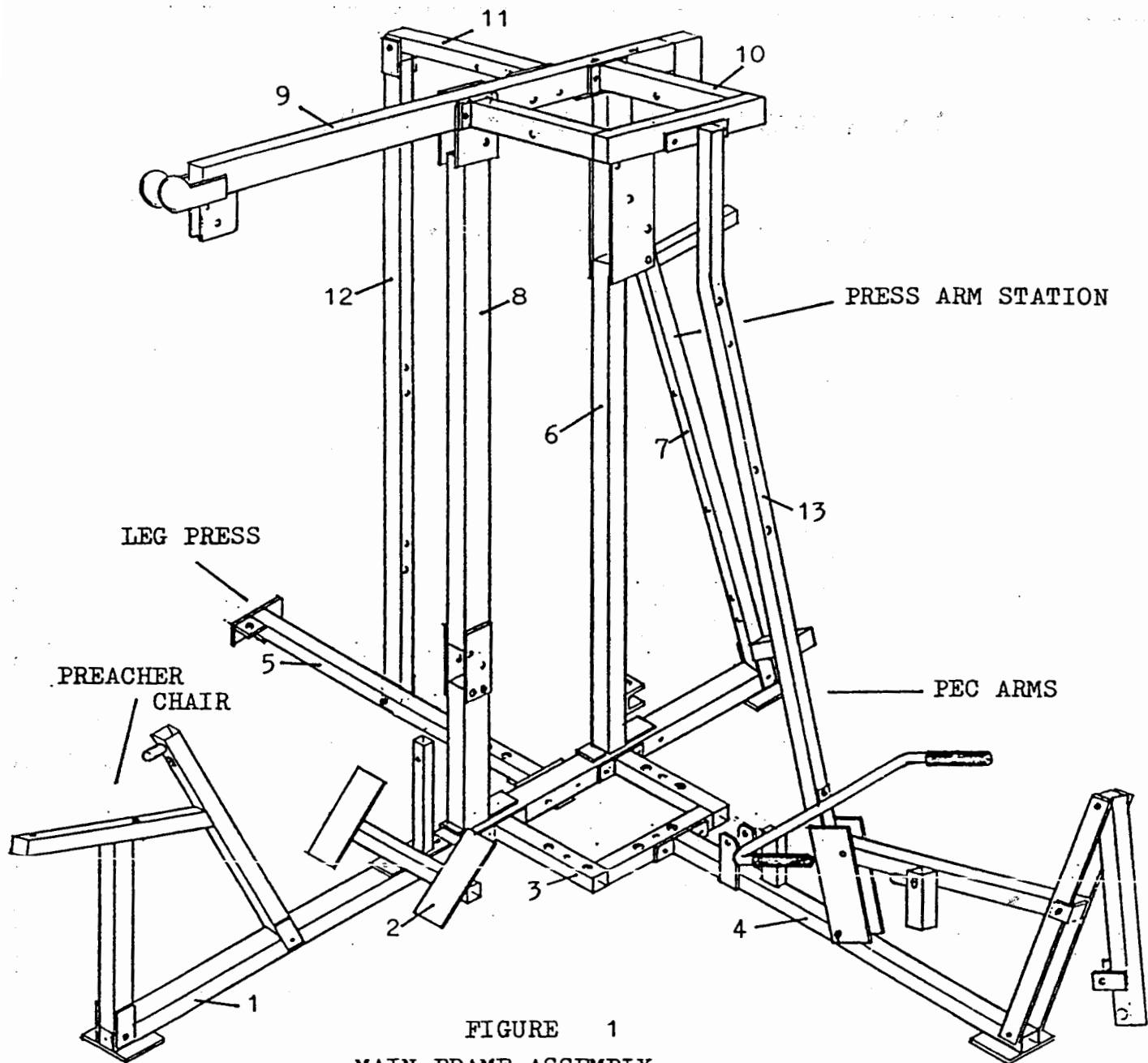


FIGURE 1
MAIN FRAME ASSEMBLY

ITEM	PART NO.	QUANTITY	DESCRIPTION
1	540-01	1	Main Base
2	540-02	1	Foot Press
3	540-03	1	Base Weight Frame
4	540-04	1	Pec Base
5	540-05	1	Leg Press Base
6	540-06	1	Press Arm Vertical
7	540-07	1	Press Arm - Seat Back
8	540-08	1	Preacher Chair Vertical
9	540-09	1	Main Top
10	540-10	1	Top Weight Frame
11	540-11	1	Leg Press - Top Tie
12	540-12	1	Leg Press Vertical
13	540-13	1	Pec Vertical

MAIN FRAME ASSEMBLY

FIGURE ONE

A) BASE

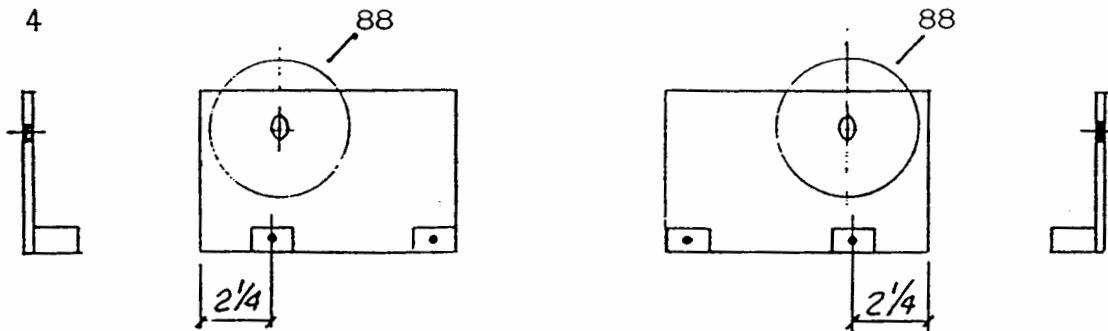
- 1 Bolt (2) to (1) Use two 2 3/4" bolts, running from the bottom of (1), through bar of (2). Do not use flat washers on the bottom side. Add flat washers and lock nuts to secure
- 2 Attach (3) to (1) as shown, pads down. At this time, use four 2 3/4" bolts, with washers, and nuts. This is a temporary connection that will be changed later, when other parts will be added, using these common holes.
- 3 Bolt (4) to (3), as shown, using two 2 3/4" bolts.
- 4 Bolt (5) to (1) using two 2 3/4" bolts This finishes the Base.

REMEMBER ALL BOLTS SHOULD NOT BE TIGHTENED AT THIS TIME, JUST SNUGGED UP.

B) FRAME

- 1 Bolt (6) to (1) This requires the removal of two 2 3/4" bolts, mentioned in number 2 above. Use two 3 1/4" bolts to secure (6), (1), and (3).
- 2 Bolt (7) to (1) with one 3" bolt Bolt the top of (7) to (6), as shown, with another 3" bolt.
- 3 Remove the other 2 3/4" bolts holding (3) to (1), Position (8) over these common holes and secure with two 3 1/4" bolts.
- 4 Position (9) on top of (6) and through the two plates of (8). Line up the holes of (9) with the holes in the top bar of (6). Fasten with two 4" bolts.
- 5 Run two 3 1/4" bolts through (8) from the far side and through (9). Number (10) attaches to these bolts in the front. Use two 2 3/4" bolts on the other side of (10) to fasten it to (9).
- 6 Bolt (11) to (9), as shown, using two 2 3/4" bolts.
- 7 Bolt (12) to (11) with one 3" bolt at the top one 4 1/2" bolt to (5) at the bottom. NOTE: (12) is on the far side of (5).
- 8 Bolt (13) to (4) with one 3" bolt. The top of (13) is another temporary connection. Use two 2 3/4" bolts, at this time to fasten.
9. TIGHTEN ALL BOLTS.

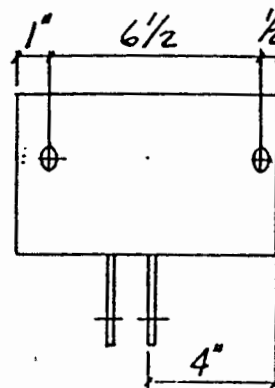
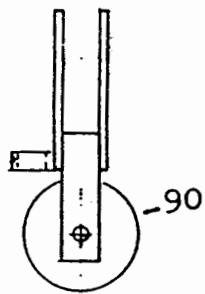
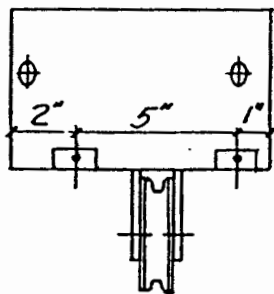
This completes the Main Frame Assembly.



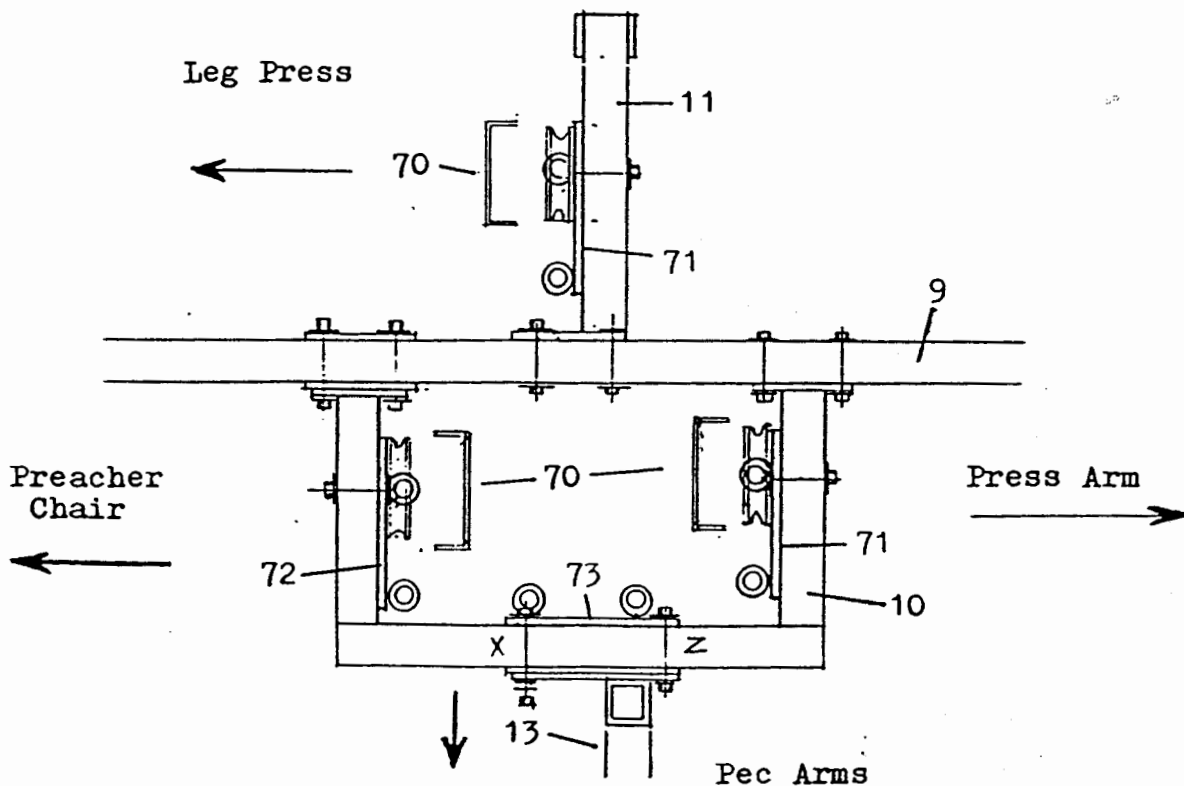
(1) for Press Arm
(1) for Leg Press
Part No. 71

(1) for Preacher Chair
Part No. 72

TOP WEIGHT GUIDES



(1) for Pec Arm Part No. 73



WEIGHT GUIDE ASSEMBLY
(TOP VIEW)

FIGURE 2

INSTALLING THE WEIGHTS

FIGURE TWO

NOTE: WEIGHT RODS SHOULD BE LUBRICATED LIGHTLY WITH SOME HOUSEHOLD PRODUCT SUCH AS 3 IN 1 OIL, VASELINE, ETC.

NOTE: THE INDEXING HOLES OF THE WEIGHTS SHOULD ALL BE FACING IN THE DIRECTION THAT IS INDICATED BY THE ARROWS.

A) PRESS ARM WEIGHTS

1. Center two rubber cushions (74) over the large holes in the Base Weight Frame (3). Insert two Weight Guide Rods through the cushions and into the Weight Frame. One man can tip the rods forward and hold them about a foot down from the top. The other man can start adding the weights 3 or 4 at a time, allowing them to rest on the holder's hands. The holder can then slide them down, removing his hands about a foot from the bottom. Continue this process until you have 20 weights in place. Top it off with the Weight Cap (79).
2. Add the Top Weight Guide (71) to the Weight Rods and bolt it, as shown, to the upper weight frame. At this time use a 2 3/4" bolt.
3. Insert the Index Rod (77) through the center hole of the Weight Cap. Line up the top hole of the Index Rod with the hole in the Weight Cap. Tighten the allen bolt in the Weight Cap to lock in the weights.

B) PEC ARM WEIGHTS

1. Follow the same process mentioned above in loading the weights.
2. To install the Weight Guide (73) you will have to remove the bolts that holds (13) to (10). The Weight Guide (73) straddles (10) on the bottom side and (13) lays against it on the outside. Use one 3 1/2" bolt designated by "x" coming from the inside, with two flat washers and nut. The other bolt "z" is 3 1/4".

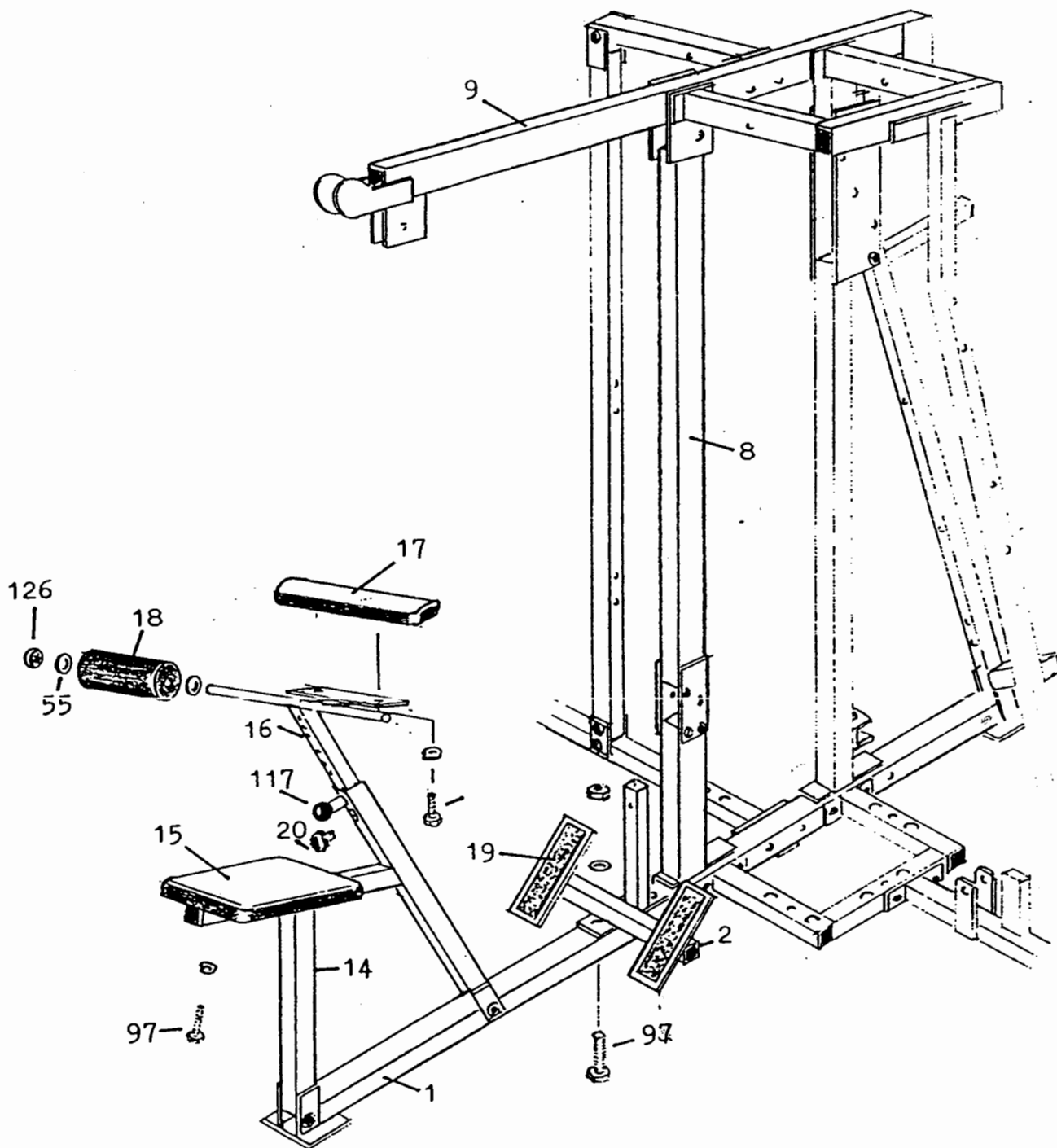
C) PREACHER CHAIR WEIGHTS

1. Load the weights.
2. Use Weight Guide (72) to lock in the weights. At this time use one 2 3/4" bolt.

D) LEG PRESS WEIGHTS

1. Load the weights.
2. Use Weight Guide (71) to lock in the weights. Use one 2 3/4" bolt as a temporary fastener.

This completes installation of the weights.



PREACHER CHAIR ASSEMBLY
FIGURE THREE

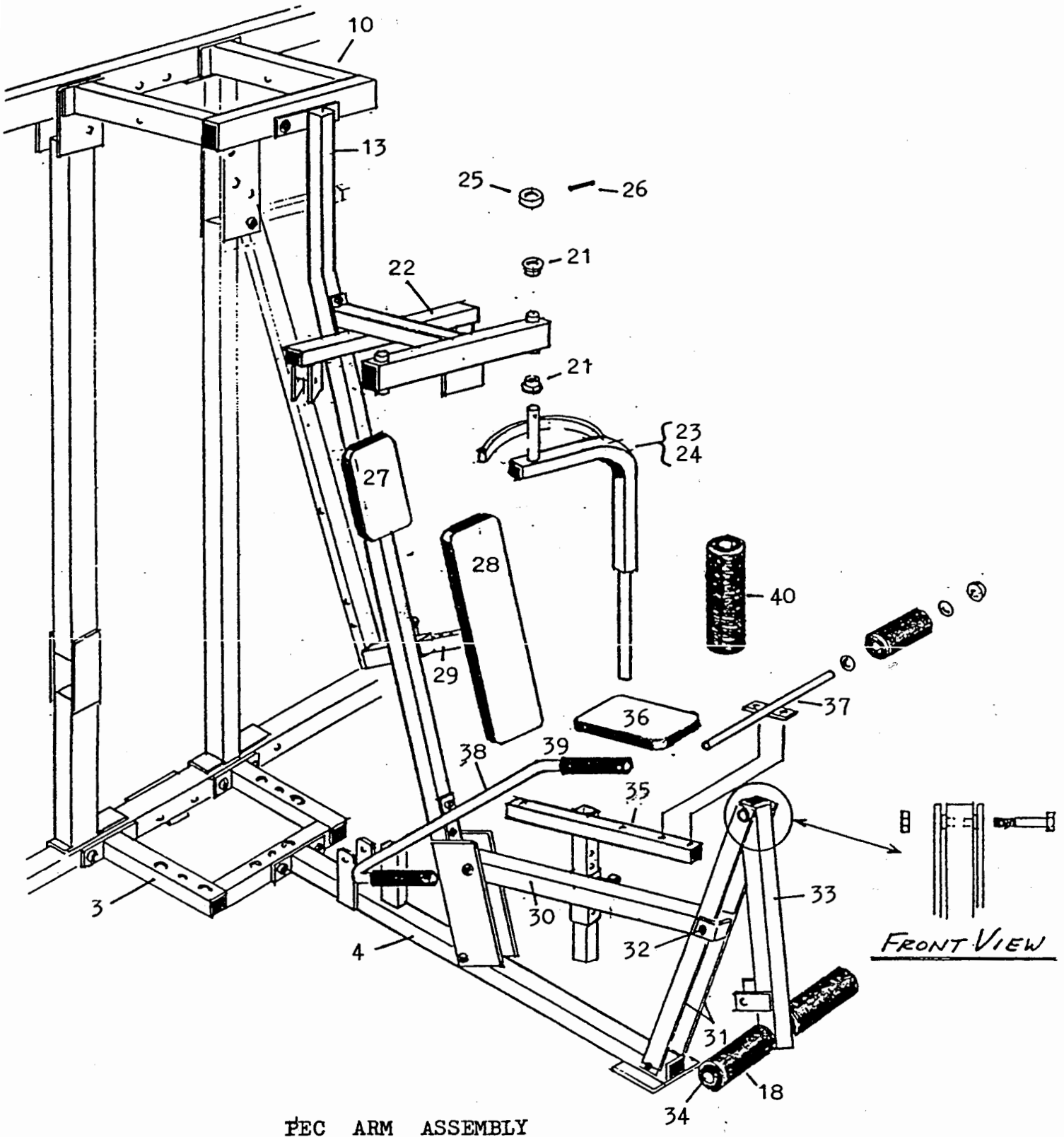
PREACHER CHAIR ASSEMBLY

FIGURE THREE

ITEM	QUANTITY	DESCRIPTION
14	1	Preacher Chair Frame
15	1	Seat Pad x
16	1	Adjustable Arm Curl
17	1	Arm Curl Pad
18	2	Roller Pad
19	2	Non Skid Strip
20	1	Tightening Knob

1. Bolt (14) to (1) using two 3" bolts.
2. Bolt (15) to (14) with two 2 3/4" bolts and two lock washers. NOTE: The lock washers should be next to the bolt heads.
3. Slide (16) into (14). Pull out on the Pop Pin (117) to allow (16) to go down. Release Pop Pin when desired level is reached. Add Tightening Knob (20) to secure.
4. Bolt (17) to (16) using two 1" bolts with lock washers.
5. Add the two adhesive backed, non skid strips (19) to the Foot Press.
6. Add the two Roller Pads (18) as follows: one 3/4 washer, the Roller Pad, another 3/4 washer, and secure with a Push nut (126).

NOTE: HAIR SPRAY ON THE RODS WILL HELP IN INSTALLATION OF ALL ROLLER PADS AND HANDLE GRIPS. THIS ALSO HELPS TO BOND THE PARTS TOGETHER.



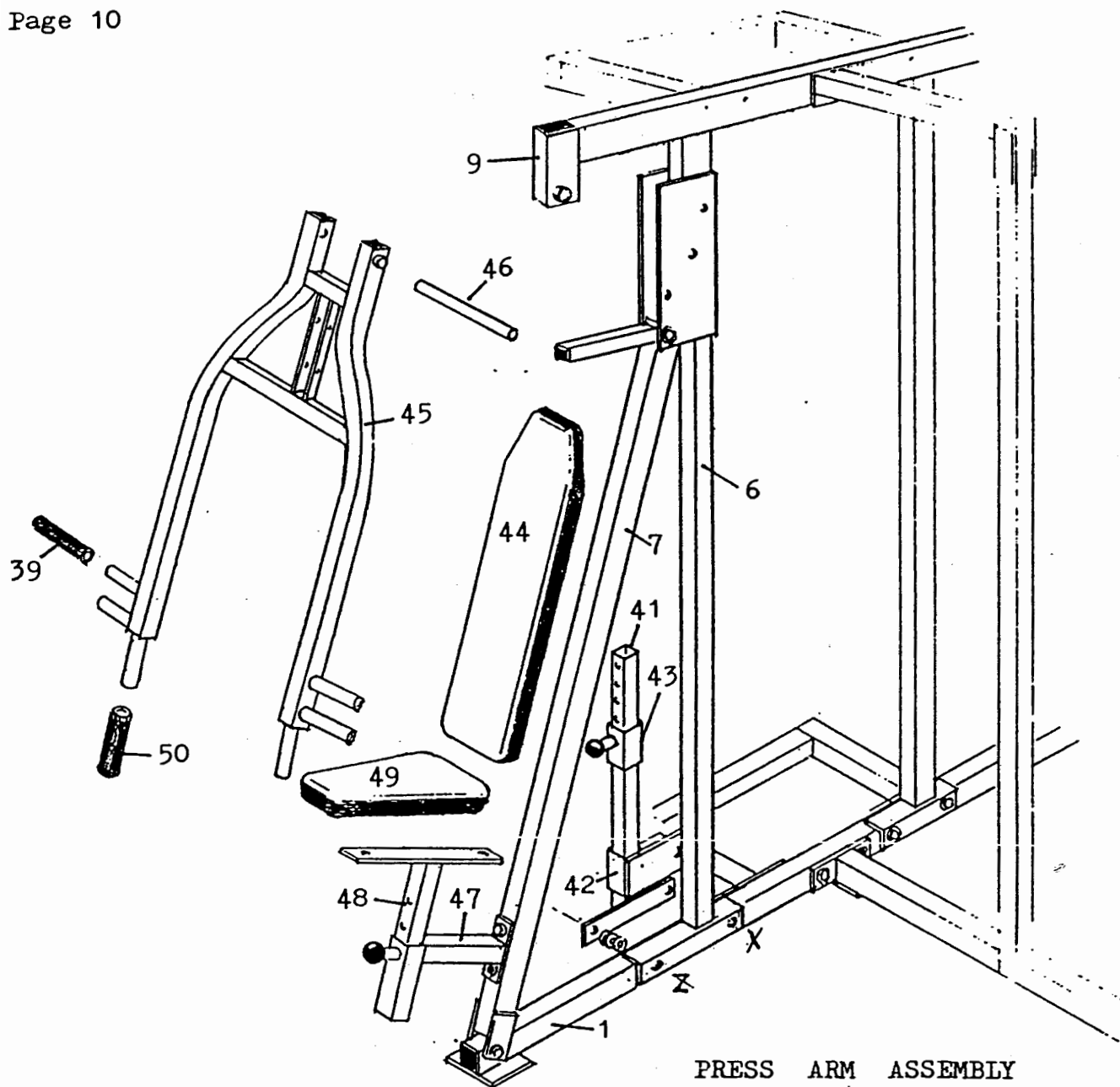
PEC ARM ASSEMBLY

FIGURE FOUR

PEC ARM ASSEMBLY
FIGURE FOUR

ITEM	QUANTITY	DESCRIPTION
21	4	Bronze Bushing - 1"
22	1	Pec Arm Mount
23	1	Left Pec Arm (shown)
24	1	Right Pec Arm
25	2	Collar - 1" I.D.
26	2	Drive Pin
27	1	Head Pad x
28	1	Back Pad x
29	1	Pec Back Pad Holder
30	1	Pec Seat Mount
31	2	Pec Seat Front Support Bar
32	1	Stop Angle
33	1	Extension Tube
34	1	Roller Tube
35	1	Pec Seat Holder
36	1	Seat Pad x
37	1	Roller Tube Mount
38	1	Pec Handle Bar
39	2	Handle Grip
40	2	Pec Arm Roller Pad

1. Bushings are pre-assembled in (22).
2. Bolt (22) to (13) using two 2 3/4" bolts.
3. Run shaft of Pec Arm (23) up through the bushings in the Pec Mount (22). Add the Collar (25) and line up with the hole in the shaft. Drive the Pin (26) in to lock in place. Add the other arm the same way.
4. Bolt (27) to (13) with two 2 3/4" bolts with lock washers.
5. Bolt (29) to (28) with two 1" bolts and lock washers. Slide in place as shown.
6. Bolt (30) to (13) with one 3" bolt as shown. Bolt the two Support Bars (31) to (4) with 3" bolt. NOTE: THE BOTTOM HOLES OF THESE TWO BARS HAVE A 3/4" EDGE DISTANCE. THE BARS ARE NOT SYMMETRICAL SO MAKE SURE ALL HOLES LINE UP. THE HOLE WHERE (30) TIES INTO THESE BARS IS 16" UP FROM THE BOTTOM. Slide (30) between these bars, add the Stop Angle (32) and fasten with one 3 1/4" bolt.
7. The Extension Tube (33) has two bushings that are already in place. Put this between the two bars at the top, as shown, and fasten with one 1/2 x 3" bolt.
8. Slide Roller Tube (34) through (33) at the bottom and add Roller Pads as you did on the Preacher Chair.
9. Bolt (37) to (35) using two 2 3/4" bolts. Add Roller Pads.
10. Bolt (38) to (13) with two 2 3/4" bolts. Slide on Grips (39).
11. Slide the Pec Arm Roller Pads (40) on (23) and (24).



PRESS ARM ASSEMBLY

FIGURE FIVE

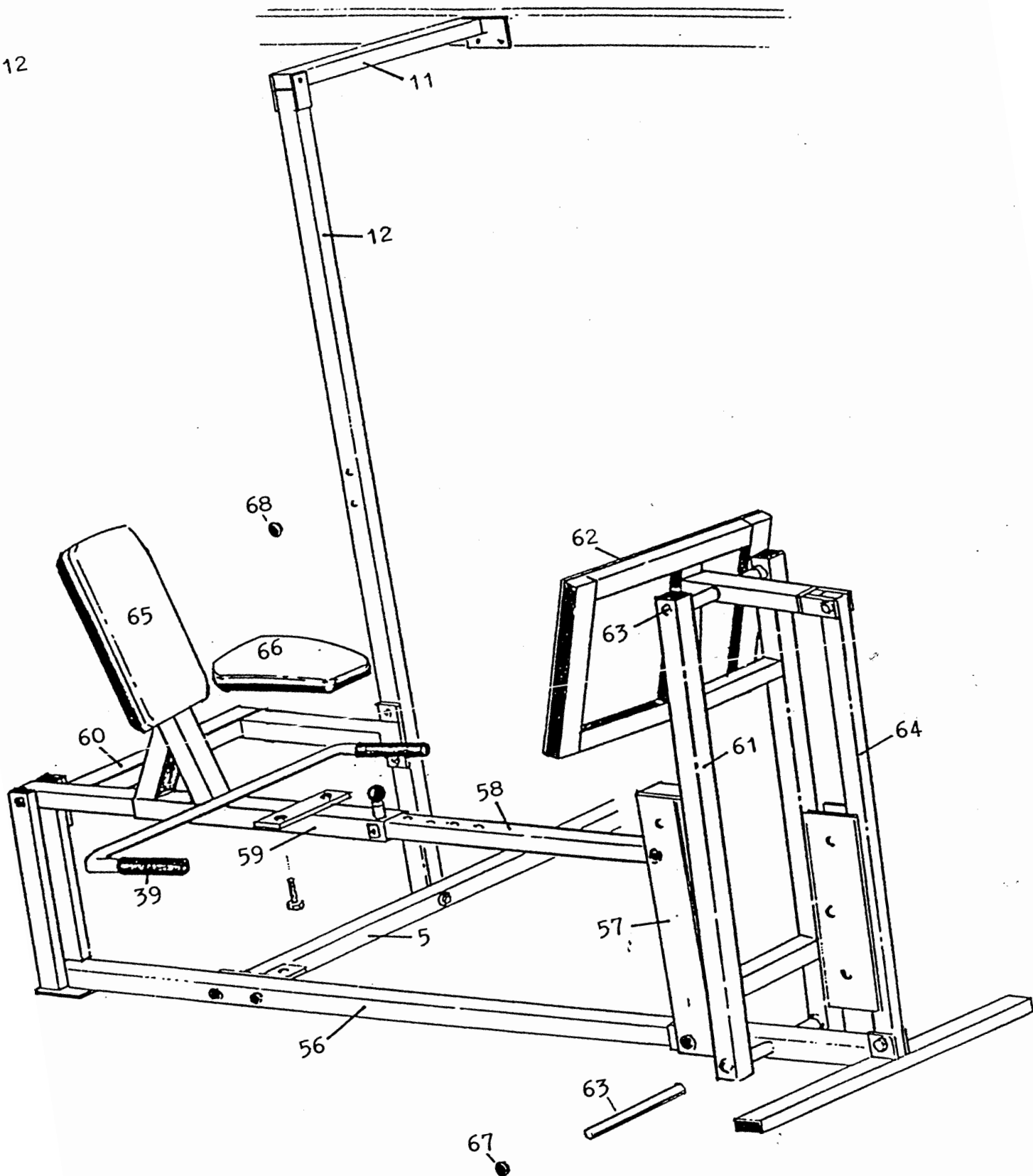
ITEM	PART NO.	QUANTITY	DESCRIPTION
41	540-41	1	Adjustable Stop Tube
42	540-42	1	Bottom Slide
43	540-43	1	Top Slide
44	540-44	1	Press Arm - Back Pad
45	540-45	1	Press Arm
46	540-46	1	Press Arm Pin 1" x 9 3/4
47	540-47	1	Press Arm - Seat Holder
48	540-48	1	Press Arm - Seat Bracket
49	540-49	1	Seat Pad
50	540-50	2	Handle Grip 1 1/2 x 5

PRESS ARM ASSEMBLY

FIGURE FIVE

1. Carefully remove the bolts marked "x" and "z". Now position the Adjustable Stop Tube (41) as shown. Run one 3 1/4" bolt through the holes designated by the "x". At "z" run another 3 1/4" bolt through (6), (1), and then add three washers between (1) and (41). Fasten with washers and lock nuts in the usual way.
2. Next, slide (42) down (41) as shown.
3. Add (43) next by pulling out on the pop pin to allow it to go down where you want it.
4. Bolt the Back Pad (44) to (7) using two 2 3/4" bolts with lock washers.
5. Mount (45) to (9) using the Pin (46). NOTE: THE HANDLES OF THE PRESS ARM (45) TILT TOWARD THE CENTER OF THE MACHINE. After the pin is centered in (45) and (9), tighten the allen bolts in the collars that are welded to (45).
6. Bolt (47) to (7) using two 2 3/4" bolts.
7. Bolt (48) to (49) using two 1" bolts with lock washers. Slide (48) into (47) pulling out on the pop pin to allow the seat to drop to the position you desire.
8. Add Grips: four (39) and two (50).

This completes the Press Arm Assembly.



LEG PRESS ASSEMBLY
FIGURE SIX

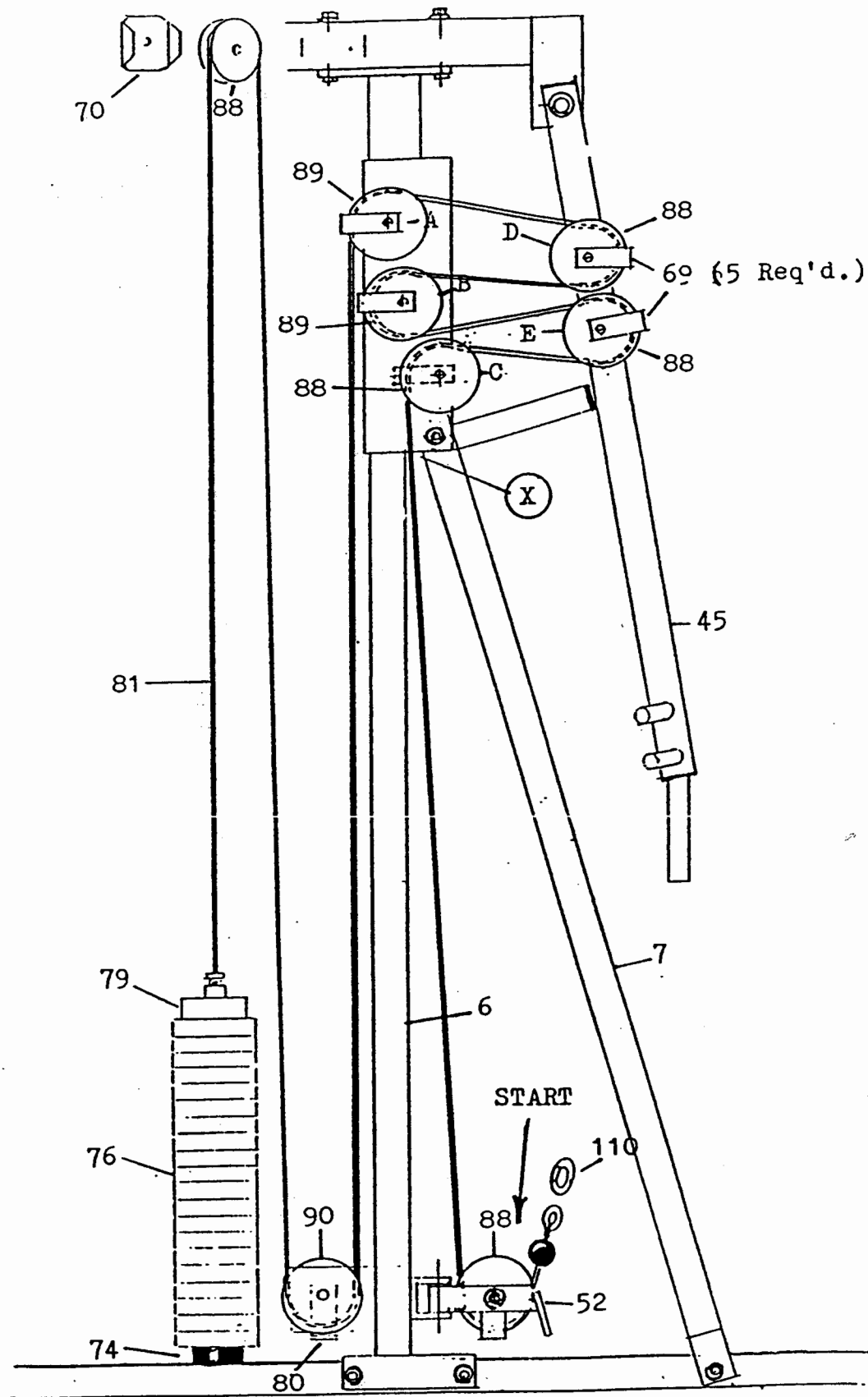
LEG PRESS ASSEMBLY

FIGURE SIX

ITEM	QUANTITY	DESCRIPTION
56	1	Leg Press - Main Base
57	1	Base Extensiion
58	1	Seat Adjustment Tube
59	1	Seat Holder
60	1	Side Support
61	1	Pivot Frame
62	1	Push Deck
63	2	Pivot Frame Pin - 3/4 x 10 1/4
64	1	Pivot Arm
65	1	Back Pad x
66	1	Seat Pad x
67	4	Plastic Plug 13/16
68	4	Plastic plug 7/16

1. Slide (56) into (57) lining up the two end holes on each piece. Bolt together using one 3" bolt and one 2 1/2" bolt.
2. Bolt this assembly to (5), as shown, using two 2 3/4" bolts.
3. Bolt (60) to (12) using two 2 3/4" bolts. Number 60 also bolts to (56) and (58). At this time, just use the lower hole, bolting (60) to (56) with a 4" bolt.
4. Slide (59) onto (58) as shown. Set the back of this assembly on the ledge of the Main Base (56). The front of this goes between the two bars of the Base Extension (57). Line up the hole in (58) with the lower holes in (57). Since (58) is smaller than the distance between the two upright bars, it will require two 3/8 flat washers on both sides of (58), as you are bolting it up. Use one 3" bolt to make this connection. Add Seat Back (65) using two 2 3/4" bolts with lock washers and the Seat Pad using two 1" bolts with lock washers.
5. The back side of (58) is between (56) and (60). Once again, four washers are to be used to center (58). Use another 4" bolt for this connection.
6. (61) mounts to (57) at the base. Use one pin 3/4 x 10 1/4 (63) to secure. At the top, tie in the Push Deck (62), as shown. Use the other pin (63) for this connection. Make sure that these pins are centered and lock them in place by tightening the allen bolts on the collars of (61).
7. (64) sets between the two short bars of (57) at the bottom. Use one 1/2 x 2 1/2 bolt for this connection. At the top, it goes between the 1/2" bars of (62). Use one 1/2 x 3" bolt to make this connection.
8. Push the four 13/16 plastic plugs into the outer holes of (61). Pop in the 7/16 Plastic Plugs into the four blank holes on (12). (both sides)

This completes the Leg Press Assembly.



PRESS ARM CABLE ASSEMBLY
FIGURE SEVEN

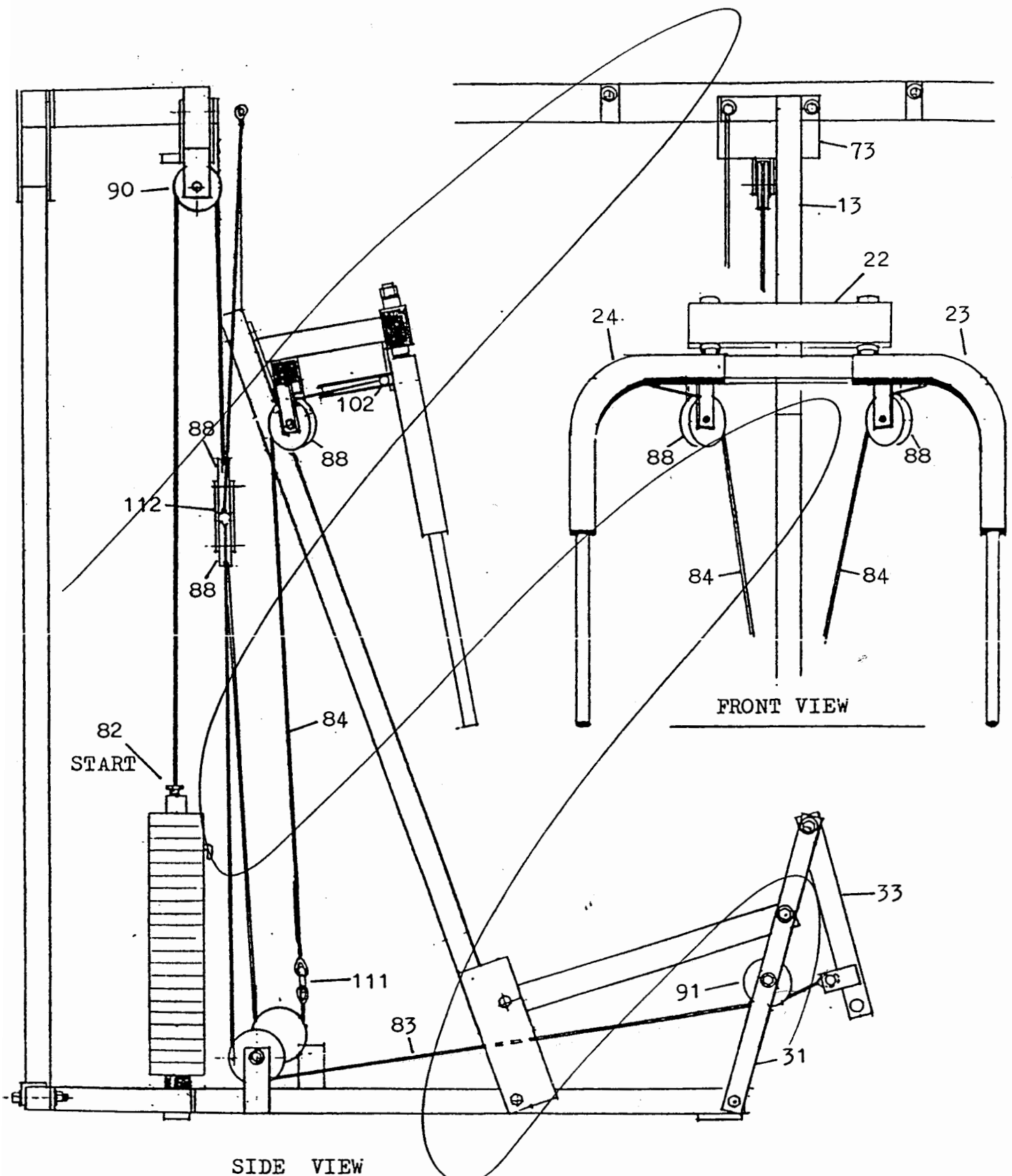
STRINGING THE CABLE

PRESS ARM CABLE ASSEMBLY

FIGURE SEVEN

ITEM	QUANTITY	DESCRIPTION
52	1	Swivel Pulley - Small
69	5	Cable Guide - Long
70	1	Pulley Cover
80	1	Cable Guide - Short
81	1	Cable - Press Arm - 338"
88	5	Pulley 4 1/2" w/ 1" Bushing
89	2	Pulley 4 1/2" w/ 2" Bushing
90	1	Pulley 3 1/2" w/ 1" Bushing
110	1	Snap Link - Large

1. Because of the pinch point, designated "x", and the size of the ball on the end, you must begin stringing the cable where it says "START".
2. First, mount the small Swivel Pulley (52) to the bracket, welded to (6). Use one 1/2 x 3" bolt, with washers, top and bottom, and fastened with lock nut.
3. Run the entire length of the cable through the pinch point (x). Install Pulley (88) designated "C" in this manner. One Spacer (108), Pulley, two washers, and a Long Cable Guide (69) on the inside of (6). Use a 3" bolt to secure. NOTE: THE CABLE SHOULD BE AROUND THE PULLEYS AS YOU PUT THEM IN PLACE.
4. Loop cable over Pulley (88) designated (E) and install inside the bars of the Press Arm, as shown. Add the Long Cable Guide, as you bolt it up, using a 2 1/4" bolt
5. Follow the same procedure at (B) except, use a 4 1/2" x 2 Pulley (89) and fasten with a 3 1/4" bolt with a long cable guide.
6. Install (D) in the same way as (E).
7. Pulley (A) is mounted in the same manner as (B).
8. The cable continues around (A) down around a 3 1/2 x 1" Pulley that mounts to the Bottom Slide (42) - (Figure 5). Add the short cable guide to a 1 3/4" bolt and fasten to the Bottom Slide.
9. Cable goes up and around 4 1/2 x 1" Pulley (88) and is en-caged with Pulley Cover (70). Refer to Figure Two, Press Arm. You will have to remove the 2 3/4" bolt that holds the Top Weight Guide (71). Run a 4" bolt, with washer, from the outside of the Top Weight Frame (10) through, picking up the Pulley (with the cable in place) and the pulley cover (70). Add another washer and lock nut to fasten.
10. Screw threaded end of the cable into the Weight Cap (79). Tighten allen bolt in the weight cap to lock the weights in. Adjust for proper tension.



PEC ARM CABLE ASSEMBLY
FIGURE EIGHT

PEC ARM CABLE ASSEMBLY

FIGURE EIGHT

ITEM	QUANTITY	DESCRIPTION
73	1	Top Weight Guide - Pec
82	1	Cable - Main Pec 106"
83	1	Cable - Lower Pec 158"
84	2	Cable - Pec Arm 57"
88	6	Pulley 4 1/2" w/ 1" Bushing
90	1	Pulley 3 1/2" w/ 1" Bushing
91	1	Pulley 3 1/2" w/ 2" Bushing
111	1	Snap Link - Small
112	2	Floating Pulley Plate

1. Start with the Main Cable (82). Bolt end into the Weight Cap about half way. Run the cable up around Pulley (90).
2. The cable is looped around (90) and slid between the two lower bars of the Pec Top Weight Guide (73). Secure with a 2" bolt.
3. Assemble Floating Pulley by using the two plates (112) and one Pulley (88) tied together with one 1 3/4" bolt, washers, and a lock nut. The cable comes down and around this pulley and goes back to the top and ties in, as shown in the front view. The cable end slips over the 3 1/2" bolt, mentioned in Figure Two. Just add a washer and another nut to lock in.
4. The next cable to add is the Lower Pec (83). Start this by looping the cable over a 4 1/2 x 1" pulley (88) with the ball to the far side. Slide this up into the bottom side of the Floating Pulley. Fasten with one 1 3/4" bolt.
5. The ball end of this cable goes around a 4 1/2 x 1" pulley on the far side, as shown. The other end of this cable, hanging down, also wraps around a 4 1/2 x 1" pulley. Line up both these pulleys and mount them between the two bars sticking up from the Pec Base. Use one 3" bolt for this assembly.
6. The end of this cable goes forward under one 3 1/2 x 2" Pulley (91) mounted between the two Pec Seat Support Bars (31). Use a 3" bolt to secure this pulley. The eye of this cable goes between the the bars welded to the Extension Tube. Use a 2 3/4" bolt to secure.

PREACHER CHAIR CABLE ASSEMBLY

FIGURE NINE

ITEM	QUANTITY	DESCRIPTION
53	1	Hi Lat Bar
54	1	Lo Lat Bar
69	1	Cable Guide - Long
70	1	Pulley Cover
85	1	Cable - Main Preacher - 115"
86	1	Cable - Lower Preacher - 123 3/4"
88	4	Pulley - 4 1/2" w/ 1" Bushing
89	2	Pulley - 4 1/2" w/ 2" Bushing
110	2	Snap Link - Large
112	2	Floating Pulley Plate

1. Bolt the threaded end of the Main Cable (85) into the Weight Cap about half way.
2. Remove the 2 3/4" bolt that holds the Top Weight Guide (72). Refer to Figure Two. Replace it with a 4" bolt, with washer, coming from the outside, through the weight guide, pulley (88), (with the cable looped over it) and through the Pulley Cover (70). Secure with another washer and a lock nut.
3. Make up another Floating Pulley (112) as mentioned in the Pec Cable instructions. Loop the cable around this, as shown.
4. Go up around a 4 1/2 x 2" Pulley (89) mounted between the top bars of the Preacher Chair Vertical (8). Run a 3 1/4" bolt, with washer, through Long Cable Guide (69) and through the pulley (89) and secure on the other side with washer and nut.
5. The end of the cable loops around a 4 1/2 x 1" pulley that is mounted between the bars on the bottom side of the Main Top. Use a 2" bolt for this connection. Add another 2" bolt at the top to act as a cable retainer.
6. Using a Large Snap Link (110) connect the eye of the cable and the Hi Lat Bar (53).
7. On the Lower Cable (86), start with looping the cable around a 4 1/2 x 2" Pulley (89) and mounting, as shown. Use a 3" bolt for this connection.
8. Next loop the cable around a 4 1/2 x 1" Pulley (88) and fasten it in the bottom of the floating pulley, mentioned in number 3 above. Use a 1 3/4" bolt.
9. The end of the cable slips over an existing bolt on the base and is held in place by adding a washer and lock nut.
10. Hook the Lo Lat Bar (54) up in the way as the Hi Lat Bar, mentioned above in number 6. NOTE: THE LO LAT BAR CAN BE STORED IN THE VERTICAL TUBE OF THE FOOT PRESS (2), WHEN NOT IN USE.
11. Adjust for proper tension.

LEG PRESS CABLE ASSEMBLY

FIGURE TEN

ITEM	QUANTITY	DESCRIPTION
51	1	Large Swivel Pulley
57	1	Base Extension
64	1	Pivot Arm
70	3	Pulley Cover
87	1	Cable - Leg Press 320"
88	8	Pulley 4 1/2" w/ 1" Bushing
91	1	Pulley 3 1/2" w/ 2" Bushing

1. Bolt Large Swivel Pulley (51) on top of the angle welded to (56). Use a 1/2 x 3" bolt, with washer, through the top and on through the angle. Add another washer and lock nut to secure. Loop the balled end of the cable around a 4 1/2 x 1" pulley and mount it inside the Swivel Pulley, as shown. Use a 2" bolt. Another 2" bolt is added after the cable is in place as a cable retainer.
2. A 4 1/2 x 1" pulley must be mounted between the uprights of the Base. Remove the lower 4" bolt, install the pulley with the cable, and re-assemble.
3. The cable now extends to the other end, as shown. Loop cable around a 4 1/2 x 1" pulley. Pulley sets between the plates of the Pivot Arm (64) at the (A) position. Use a 1 3/4" bolt.
4. Next, loop the cable around a 3 1/2 x 2" Pulley (91) and mount between the uprights of the Base Extension (57) using a 3" bolt, at the (B) position.
5. The cable goes up around a 4 1/2 x 1" pulley (C) and down and around another 4 1/2 x 1" pulley (D). You will have to temporarily remove the pulley marked (A) to get the cable behind it and down around the (D) pulley. Use 1 3/4" bolts to fasten pulleys C and D. Replace pulley (A) and secure.
6. Cable now comes back and around a 4 1/2 x 1" pulley (E) that mounts to the bar welded to the Base Leg Press Tie. Loop cable around pulley, with a pulley cover (70) on top, and bolt in place with a 1 3/4" bolt.
7. Next, it goes back around a 4 1/2 x 1" pulley and up. A pulley cover goes over this pulley also. Use a 3 1/2" bolt for this connection.
8. Remove the 2 3/4" bolt holding the Top Weight Guide (71). Refer to figure two. Run a 4" bolt with washer from the outside of the Top Tie (11) through the Weight Guide. Add a 4 1/2 x 1" pulley with the cable looped around it. Put the Pulley cover on and secure it with another washer and locknut.
9. The threaded end of the cable now bolts into the Weight Cap. Adjust the tension.
10. A large Snap Ring (110) clips in the open eye of the cable.

FINAL ASSEMBLY AND CHECKS

1. MAKE SURE ALL BOLTS ARE TIGHT.
2. ADD TIGHTENING KNOBS (20) TO THE NUTS WELDED ADJACENT TO THE POP PINS.
3. ADJUST ALL CABLES SO THEY DO NOT SAG.
4. SNAP THE BLACK END CAPS INTO THE ENDS OF THE TUBES.
5. PUT THE FOUR "L" PINS (WEIGHT INDEX PINS) INTO THE WEIGHTS WHERE YOU WOULD WANT THEM
6. ATTACH THE WEIGHT DECALS ON ALL THE WEIGHTS. START WITH THE ONE AT THE TOP CONTINUE UNTIL YOU HAVE ALL 20 ON. REPEAT FOR EACH WEIGHT STACK.
7. MAKE SURE ALL GRIPS AND ROLLER PADS ARE IN PLACE AND SECURE
8. CHECK THAT ALL SEAT PADS AND SEAT BACKS ARE FASTENED TIGHTLY.

REPAIR PARTS

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

PRODUCT FOUR STACK MACHINE

MODEL NUMBER 540-DSI

PART NUMBER

PART DESCRIPTION

CONTACT: IMAGE
6063 FRANTZ ROAD
SUITE 103
COLUMBUS, OHIO 43017

ITEM	PART NUMBER	QUANTITY	DESCRIPTION
1	540-001	1	MAIN BASE
2	540-002	1	FOOT PRESS
3	540-003	1	LOWER WEIGHT FRAME
4	540-004	1	PEC BASE
5	540-005	1	LEG PRESS BASE
6	540-006	1	PRESS ARM VERTICAL
7	540-007	1	PRESS ARM - SEAT BACK
8	540-008	1	PREACHER CHAIR VERTICAL
9	540-009	1	MAIN TOP
10	540-010	1	TOP WEIGHT FRAME
11	540-011	1	LEG PRESS TOP TIE
12	540-012	1	LEG PRESS VERTICAL
13	540-013	1	PEC VERTICAL
14	540-014	1	PREACHER CHAIR FRAME
15	540-015	1	PREACHER CHAIR - SEAT PAD

16	540-016	1	ADJUSTABLE ARM CURL
17	540-017	1	ARM CURL PAD
18	540-018	1	ROLLER PAD 4 X 8
19	540-019	2	NON SKID STRIP
20	540-020	6	TIGHTENING KNOB
21	540-021	6	BRONZE BUSHING 1"
22	540-022	1	PEC ARM MOUNT
23	540-023	1	LEFT PEC ARM - SHOWN
24	540-024	1	RIGHT PEC ARM
25	540-025	2	LOCKING COLLAR - 1 1/2" O.D. X 1 1/16 I.D.
26	540-026	2	LOCKING PIN
27	540-027	1	PAD - X
28	540-028	1	PAD - X
29	540-029	1	PEC BACK PAD HOLDER
30	540-030	1	PEC SEAT MOUNT
31	540-031	2	PEC SEAT SUPPORT BAR
32	540-032	1	PEC STOP ANGLE
33	540-033	1	EXTENSION TUBE
34	540-034	1	ROLLER TUBE
35	540-035	1	PEC SEAT HOLDER
36	540-036	1	PAD - X
37	540-037	1	ROLLER TUBE MOUNT
38	540-038	1	PEC HANDLE BAR
39	540-039	8	GRIP - 1" X 5"
40	540-040	2	PEC ARM ROLLER PAD - 4" X 16"
41	540-041	1	ADJUSTABLE STOP TUBE
42	540-042	1	BOTTOM SLIDE
43	540-043	1	TOP SLIDE
44	540-044	1	PAD - X
45	540-045	1	PRESS ARM
46	540-046	1	PRESS ARM PIN 1 X 9 3/4
47	540-047	1	PRESS ARM - SEAT HOLDER
48	540-048	1	PRESS ARM - SEAT BRACKET
49	540-049	1	PAD - X
50	540-050	2	GRIP 1 1/2" X 5"
51	540-051	1	SWIVEL PULLEY - LARGE
52	540-052	1	SWIVEL PULLEY - SMALL
53	540-053	1	HI LAT BAR - 48"
54	540-054	1	LO LAT BAR - 20"
55	540-055	12	WASHER 3/4 - FOR ROLLER PADS
56	540-056	1	LEG PRESS - MAIN BASE
57	540-057	1	BASE EXTENSION
58	540-058	1	SEAT ADJUSTMENT TUBE
59	540-059	1	SEAT HOLDER
60	540-060	1	SIDE SUPPORT
61	540-061	1	PIVOT FRAME
62	540-062	1	PUSH DECK
63	540-063	2	PIN 3/4 X 10 1/4
64	540-064	1	PIVOT ARM
65	540-065	1	PAD - X
66	540-066	1	PAD - X
67	540-067	4	PLASTIC PLUG 13/16
68	540-068	4	PLASTIC PLUG 7/16
69	540-069	6	CABLE GUIDE - LONG
70	540-070	5	PULLEY COVER
71	540-071	2	TOP WEIGHT GUIDE
72	540-072	1	TOP WEIGHT GUIDE - PREACHER CHAIR
73	540-073	1	TOP WEIGHT GUIDE - PEC ARM

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74	540-074	8	WEIGHT CUSHION
75	540-075	8	WEIGHT GUIDE ROD
76	540-076	80	WEIGHT - 10 POUNDS EACH
77	540-077	4	WEIGHT INDEX ROD
78	540-078	4	WEIGHT INDEX PIN (L PIN)
79	540-079	4	WEIGHT CAP
80	540-080	1	CABLE GUIDE - SHORT
81	540-081	1	CABLE - PRESS ARM 338"
82	540-082	1	CABLE - MAIN PEC 106"
83	540-083	1	CABLE - LOWER PEC 158"
84	540-084A	10	CABLE - PEC ARM 109 109 ³ / ₄
85	540-085	1	CABLE - MAIN PREACHER 115 119
86	540-086	1	CABLE - LOWER PREACHER 123 3/4"
87	540-087	1	CABLE - LEG PRESS 320"
88	540-088	23	PULLEY - 4 1/2 W/ 1" BUSHING
89	540-089	4	PULLEY - 4 1/2 W/ 2" BUSHING
90	540-090	2	PULLEY - 3 1/2 W/ 1" BUSHING
91	540-091	2	PULLEY - 3 1/2 W/ 2" BUSHING
92	540-092	1	BOLT 3/8 - 16 X 4 1/2 HEX
93	540-093	8	BOLT 3/8 - 16 X 4" HEX
94	540-094	6	BOLT 3/8 - 16 X 3 1/2 HEX
95	540-095	5	BOLT 3/8 - 16 X 3 1/4 HEX
96	540-096	27	BOLT 3/8 - 16 X 3" HEX
97	540-097	24	BOLT 3/8 - 16 X 2 3/4 HEX
98	540-098	4	BOLT 3/8 - 16 X 2 1/4 HEX
99	540-099	11	BOLT 3/8 - 16 X 2" HEX
100	540-100	10	BOLT 3/8 - 16 X 1 3/4 HEX
101	540-101	8	BOLT 3/8 - 16 X 1" HEX
102	540-102	2	BOLT 1/4 - 20 X 1" HEX
103	540-103	1	BOLT 1/2 - 13 X 3 1/2 HEX
104	540-104	8	FLAT WASHER 1/2
105	540-105	197	FLAT WASHER 3/8
106	540-106	4	FLAT WASHER 1/4
107	540-107	2	FLAT WASHER 1"
108	540-108	1	SPACER 3/8 X 1/2
109	540-109	4	LOCK NUT 1/2" REGULAR
110	540-110	4	SNAP LINK - LARGE
111	540-111	1	SNAP LINK - SMALL
112	540-112	4	FLOATING PULLEY PLATE
114	540-114	4	WEIGHT DECAL SETS
115	540-115	2	LOCK NUT 1/4
116	540-116	86	LOCK NUT 3/8
117	540-117	6	POP PIN
119	540-119	4	BRONZE BUSHING 3/4" I.D.
120	540-120	6	BRONZE BUSHING 1/2" I.D.
121	540-121	6	PLASTIC CAP 3 X 2
122	540-122	17	PLASTIC CAP 2 X 2
123	540-123	7	PLASTIC CAP 2 X 1
124	540-124	3	PLASTIC CAP 1 3/4 X 1 3/4
125	540-125	1	PLASTIC CAP 1 1/2 X 1 1/2
126	540-126	6	PUSH NUT (ROLLER PADS)
127	540-127	1	LOCK NUT 1/2 THIN

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540-113A

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PEC PULLEY PLATE