

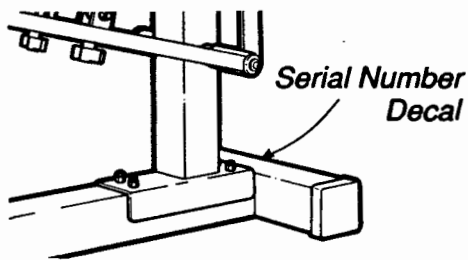
STEP USA II TM

DUAL ACTION MOTIVATIONAL STEPPER • INDEPENDENT STEPPING ACTION

PRO-FORM[®]

Model No. PF105110

Serial No. _____



QUESTIONS?

As a manufacturer, we are committed to providing you complete customer satisfaction. If you have questions, or find there are missing or damaged parts, we will guarantee you complete satisfaction through direct assistance from our factory. TO AVOID UNNECESSARY DELAYS, PLEASE CALL DIRECT TO OUR TOLL-FREE CUSTOMER HOT LINE. The trained technicians on our Customer Hot Line will provide immediate assistance, free of charge to you.

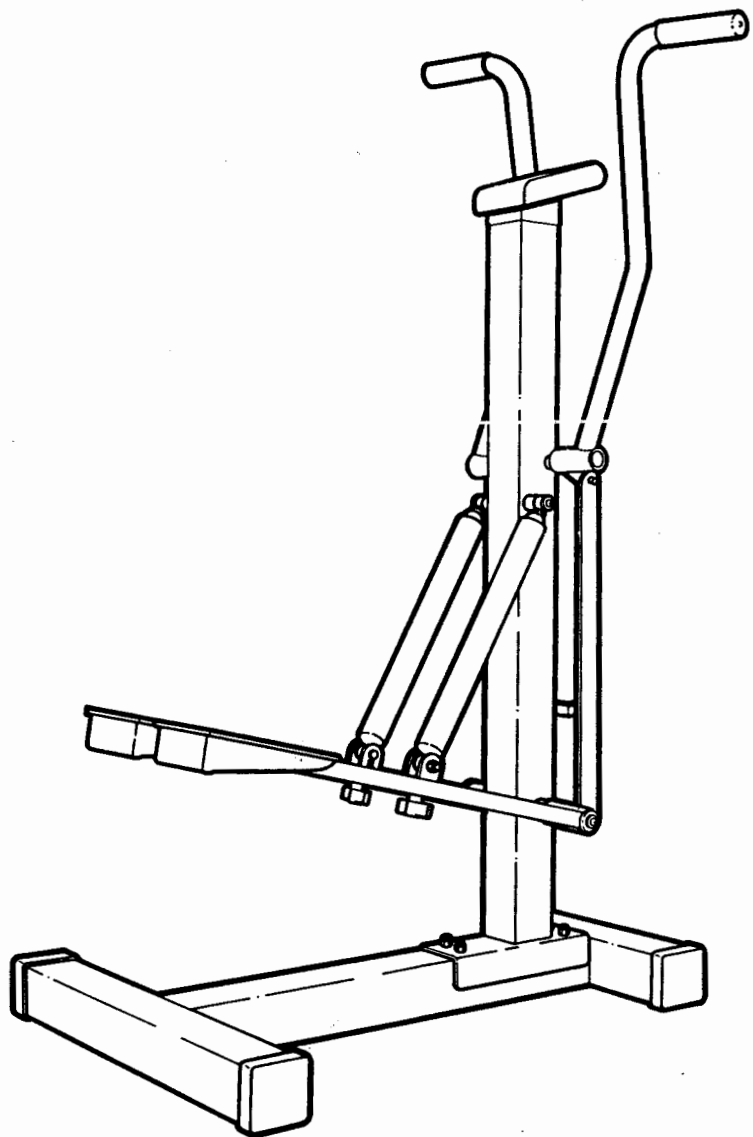
CUSTOMER HOT LINE:

1-800-999-3756

Mon.-Fri., 6 a.m.-6 p.m. MST.

CAUTION:

Read all safety precautions and instructions in this manual carefully before using this equipment. Save this manual for future reference.



OWNER'S MANUAL

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IMPORTANT SAFETY PRECAUTIONS

1. Position the stepper on a level surface. The electronic monitor must be out of direct sunlight or the LCD display may be damaged.
2. Make sure that all parts are tightened securely before each workout.
3. Always wear appropriate clothing and shoes when using the stepper.
4. Always hold the handlebars when using the stepper. Keep hands away from the link arms when stepping.
5. Keep small children away from the stepper during use.
6. The resistance cylinders may become hot after a period of use. Allow the cylinders to cool before touching them.
7. Use the stepper only as described in this manual.

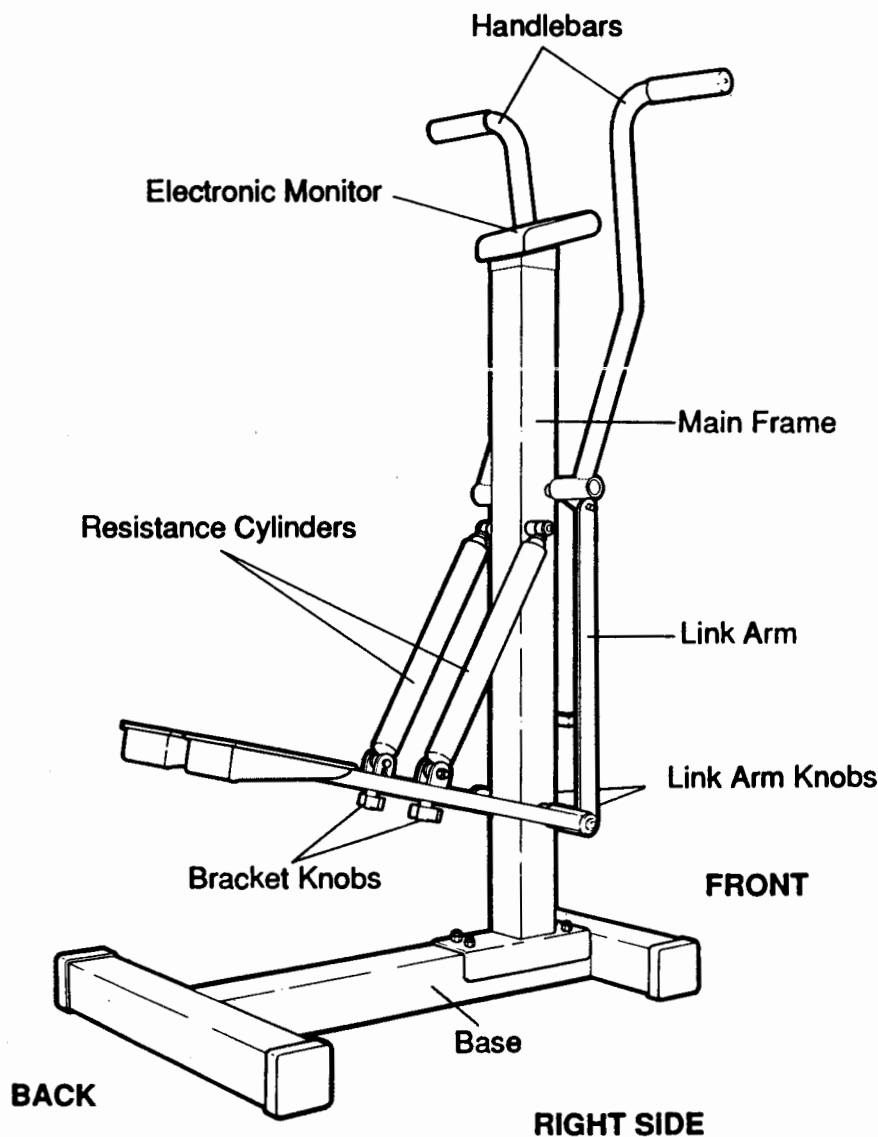
WARNING: Before beginning this or any exercise program, consult your physician. This is especially important for individuals over the age of 35 or persons with pre-existing health problems. Read all instructions before using. Pro Form assumes no responsibility for personal injury or property damage sustained by or through the use of this product.

BEFORE YOU BEGIN

Thank you for selecting the STEP USA II stepper. The STEP USA II blends advanced engineering with innovative styling to provide you with an effective form of low-impact, cardiovascular exercise in the convenience of your own home.

For your safety and benefit, **read this manual carefully before using this equipment.** If you have additional questions, please call our Customer Service Department toll-free at **1-800-999-3756**, Monday - Friday, 6 a.m. - 6 p.m. Mountain Time (excluding holidays). To help us assist you quickly, please note the product model number and serial number before calling. The model number is printed on the front cover of this manual. The serial number is recorded on a decal affixed to the product (see the drawing on the front cover).

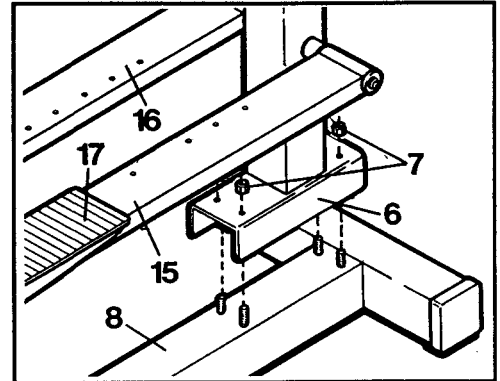
Before reading further, please review the drawing below and familiarize yourself with the parts labeled.



ASSEMBLY

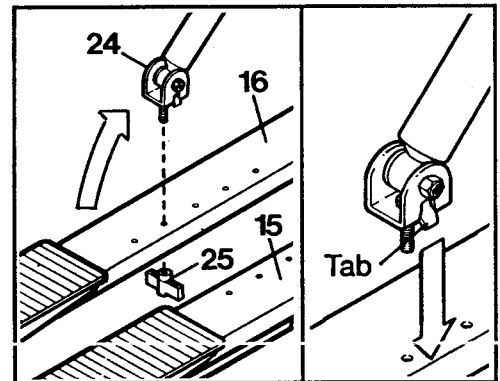
Remove all parts from the packing carton. **Make sure that all parts are included before disposing of the packing materials.** Read each step carefully before beginning. Assembly can be completed using an adjustable wrench and a phillips screwdriver (not included).

1. Turn the Base (8) so the threaded ends of the bolts are upward. Rotate the Pedals (15, 16) to the position shown, so that the Foot Pads (17) are on top of the Pedals (see the drawing). Attach the Main Frame (6) to the Base with four Nylock Nuts (7).



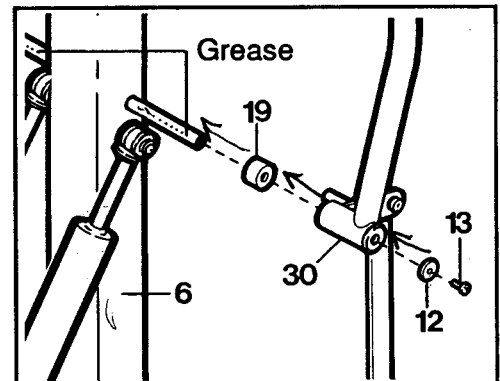
2. Lift the Left Pedal (16) and insert the left Cylinder Bracket (24) through one of the holes in the Pedal. (The tab on the Bracket must be against the inside of the Pedal.) Tighten a Bracket Knob (25) onto the end of the Cylinder Bracket.

Attach the right Cylinder Bracket to the Right Pedal (15) in the same manner (not shown).



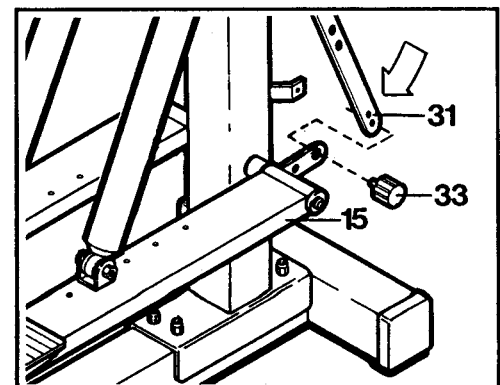
3. Grease both ends of the handlebar axle on the Main Frame (6). Slide a Cylinder Spacer (19) and the Right Handlebar (30) onto the right handlebar axle. Note: The recessed end of the Spacer must be toward the Frame. Attach the Handlebar with a Washer (12) and Bolt (13).

Attach the Left Handlebar in the same manner (not shown).



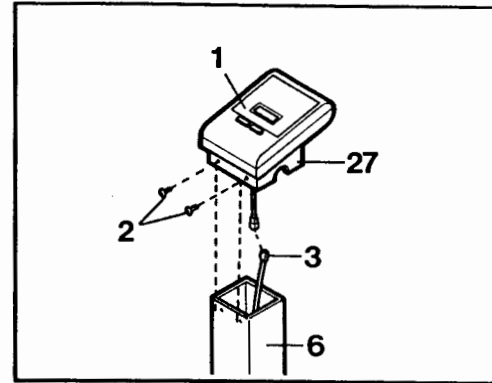
4. Attach the right Link Arm (31) to the Right Pedal (15) with a Link Arm Knob (33). Note: There are two holes at the lower end of the Link Arm. The lower hole raises the Handlebars (not shown) while the upper hole lowers the Handlebars. Choose the one which is most comfortable for you.

Attach the left Link Arm in the same manner (not shown).



5. Connect the Sensor Wire (3) to the wire protruding from the Electronic Monitor (1). Attach the Monitor Bracket (27) to the top of the Main Frame (6) with the two Mount Screws (2).

Be sure that all parts are tightened before using the stepper.



OPERATION AND ADJUSTMENT

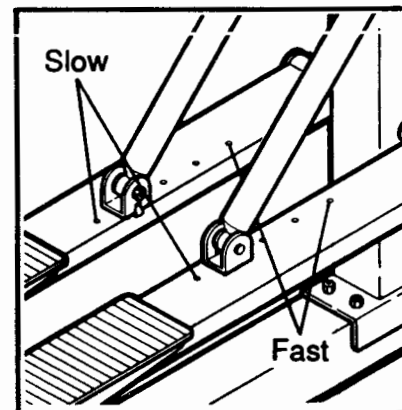
Hold the handlebars with an overhand grip. Step onto the pedals and let both pedals sink to the floor. Begin stepping by alternately pressing the right and left pedals down with a rapid, continuous motion. Because the pedals move independently, it is important to maintain a continuous motion. Change the height of your step or the stepping resistance as necessary until you can comfortably maintain a continuous motion (see ADJUSTING STEPPER RESISTANCE). For an effective aerobic workout, exercise physiologists recommend taking relatively short, rapid steps at low resistance.

As you step, you can exercise the upper leg muscles by keeping your feet flat on the pedals. To focus on the calf muscles, rise on your toes as you step. Whether standing erect or leaning forward slightly, always keep your back straight to avoid injury.

ADJUSTING STEPPER RESISTANCE

The resistance of the stepper can be adjusted by moving the cylinder brackets to different holes in the stepper pedals. There are five resistance levels. To change the resistance, first remove the bracket knobs from the cylinder brackets. Move the cylinder brackets to the desired holes in the pedals, and re-attach the bracket knobs.

WARNING: The resistance cylinders may become hot during use. Allow the cylinders to cool before touching them.

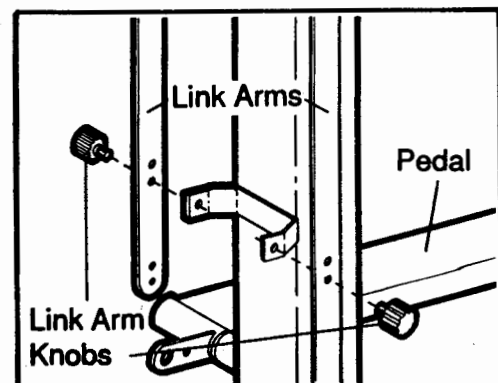


HANDLEBAR OPERATION

The handlebars are designed to be used either in a stationary position, for stepping exercise only, or in a dual-action position, adding upper-body exercise to your workout.

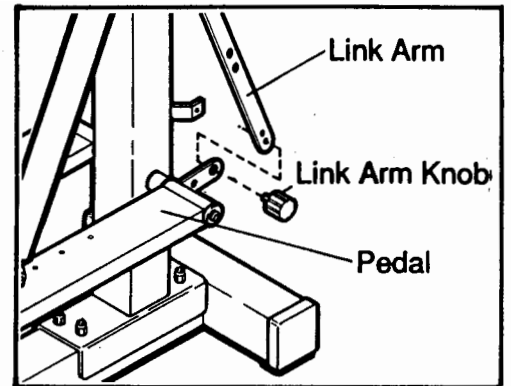
STATIONARY MODE

To convert the handlebars to the stationary position, first disconnect the link arms from the pedals by removing the link arm knobs. Align the holes in the middle of the link arms with the holes in the bracket on the front of the frame. Secure the link arms to the bracket using the link arm knobs. Note: There are two holes in the middle of each link arm. The lower hole raises the handlebars, while the upper hole lowers the handlebars. Choose the one which is most comfortable for you.



DUAL-ACTION MODE

To convert the handlebars to the dual-action mode, first disconnect the link arms from the frame by removing the link arm knobs. Attach the link arms to the pedals using the link arm knobs. There are two holes at the lower end of each link arm. The lower hole raises the handlebars, while the upper hole lowers the handlebars. Choose the one which is most comfortable for you.



ELECTRONIC MONITOR OPERATION

The simple-to-operate electronic monitor features five different modes to provide you with feedback as you exercise. Please read the instructions below before using the monitor.

DESCRIPTION OF THE MODES

SPEED- Displays your stepping speed, in steps per minute.

TIME- Displays the elapsed time. Note: The time will be counted only while you are stepping. If you stop for ten seconds or longer, the time will hold until you resume stepping.

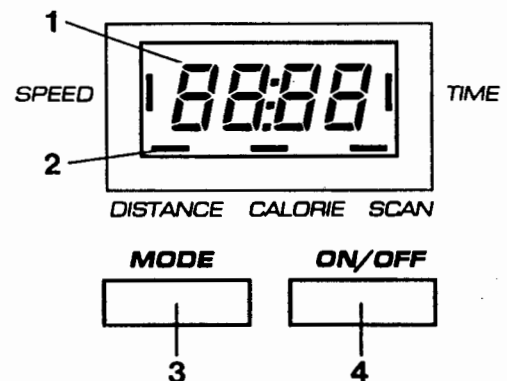
DISTANCE- Displays the total number of steps you have completed.

CALORIE- Displays the total number of Calories you have burned. Note: If your stepping speed is very fast or very slow, the actual number of Calories you have burned will be slightly higher or lower than the number shown.

SCAN- Displays the SPEED, TIME, DISTANCE and CALORIE modes, for 5 seconds each, in a repeating cycle.

MONITOR DIAGRAM

1. LED display- Display for all modes.
2. Mode indicator- Shows which mode is currently selected.
3. Mode button- Selects modes.
4. On/off button- Turns the power on and off.



MONITOR OPERATION

Two AA-size batteries (not included) are required for operation.

1. To turn the power on, press the on/off button, or simply begin stepping.

2. Select one of the five modes:
 - A. SCAN- When the power is turned on, the SCAN mode will be selected automatically. A mode indicator will appear by the word "SCAN." The SPEED, TIME, DISTANCE and CALORIE modes will be displayed, for five seconds each, in a repeating cycle. A second mode indicator will show which mode is currently displayed.
 - B. SPEED, TIME, DISTANCE or CALORIE- The SPEED, TIME, DISTANCE or CALORIE modes can be selected by repeatedly pressing the mode button. Modes are selected in the following order: SPEED, TIME, DISTANCE, CALORIE, SCAN.
3. When you are finished exercising, press the on/off button to turn the power off. Note: The monitor has an "auto shut-off" feature to prevent the batteries from being drained when the stepper is not in use. If the stepper pedals are not moved and the monitor buttons are not pressed for four minutes, the power will shut off automatically.

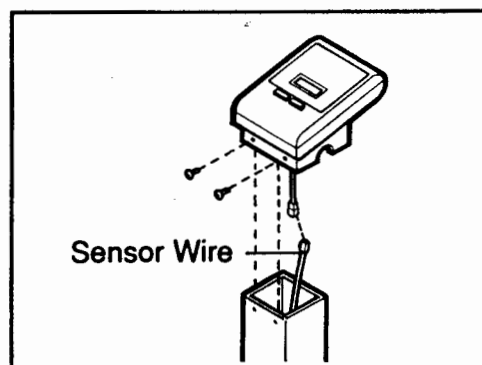
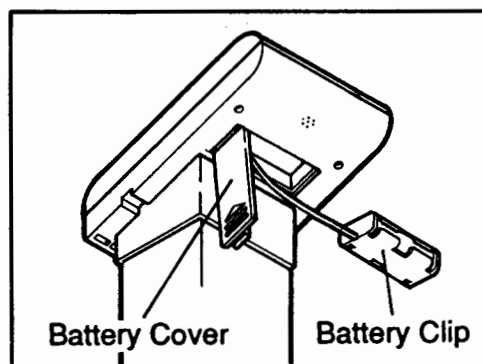
TROUBLE-SHOOTING AND MAINTENANCE

Most stepper problems can be solved by following the simple steps below. If further assistance is needed, please call our Customer Service Department toll-free at 1-800-999-3756, Monday through Friday, 6 a.m. until 6 p.m. Mountain Time (excluding holidays).

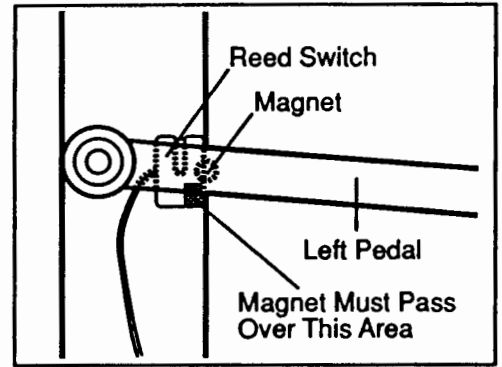
Inspect and tighten all parts of the stepper regularly. The stepper can be cleaned using a soft cloth and mild, non-abrasive detergent. Do not allow liquid to come in contact with the electronic monitor.

TROUBLE-SHOOTING THE ELECTRONIC MONITOR

1. If the electronic monitor does not function properly, the batteries should be replaced. Most problems are the result of weak batteries. Two "AA"-size batteries are required (alkaline batteries are recommended). The battery compartment is located in the underside of the monitor. Open the battery cover and carefully remove the battery clip. Insert two new batteries, in the directions shown on the inside of the battery clip. Close the battery cover.
2. If the monitor displays incorrect feedback, the sensor wire should be checked. Remove the screws from the monitor bracket, and lift the monitor off of the stepper. Make sure the sensor wire is plugged fully into the wire protruding from the monitor. Reattach the monitor to the stepper.



3. If the monitor still displays incorrect feedback, the reed switch should be repositioned. Hold the left pedal down. Carefully pull the reed switch off of the fastener strip. Position the reed switch on the fastener strip so that the magnet on the left pedal passes directly over the area shaded in the drawing at the right. Reposition the reed switch until the monitor displays correct feedback.



LUBRICATING THE STEPPER

The pedals, resistance cylinders and handlebars should be lubricated every six months. Remove the pedals, resistance cylinders and handlebars from the frame. Lubricate the axles on the frame with a petroleum-based grease. Reattach the pedals, resistance cylinders and handlebars. (See the EXPLODED DRAWING on page 11 for help, if necessary.)

CONDITIONING GUIDELINES

The following guidelines will help you to plan and regulate a personal fitness program. Remember that adequate rest and good nutrition are essential to the success of your fitness program. **Before beginning this or any exercise program, consult your physician.**

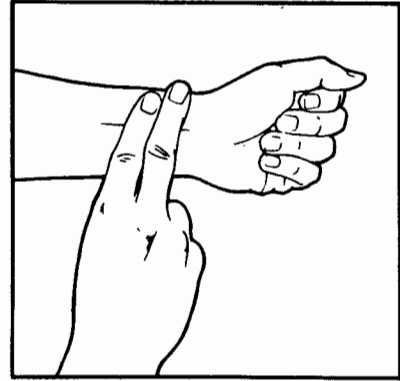
EXERCISE INTENSITY

To maximize the benefits from exercising, your level of exertion must exceed mild demands, while falling short of causing breathlessness and fatigue. The proper level of exertion can be determined using the heart rate as a guide. For effective aerobic exercise, the heart rate must be maintained at a level between 70% and 85% of your maximum heart rate. This is your "training zone." You can find your training zone by consulting the table below. Training zones are listed for both conditioned and unconditioned persons according to age. Use the column that is appropriate for you.

AGE	UNCONDITIONED TRAINING ZONE (BEATS/MIN)	CONDITIONED TRAINING ZONE (BEATS/MIN)	AGE	UNCONDITIONED TRAINING ZONE (BEATS/MIN)	CONDITIONED TRAINING ZONE (BEATS/MIN)
20	138-167	133-162	55	127-155	122-149
25	136-166	132-160	60	126-153	121-147
30	135-164	130-158	65	125-151	119-145
35	134-162	129-156	70	123-150	118-144
40	132-161	127-155	75	122-147	117-142
45	131-159	125-153	80	120-146	115-140
50	129-156	124-150	85	118-144	114-139

During the first few weeks of your exercise program, keep your heart rate near the low end of your training zone. Over the course of a few months, gradually increase your heart rate until it reaches the high end of your training zone. As your condition improves, a greater workload will be required in order to raise your heart rate to your training zone.

The easiest way to measure your heart rate is to stop exercising and place two fingers on your wrist as shown. Carefully take a six-second heart beat count. Add a 0 to the result to find your heart rate. (A six-second count is used because your heart rate will drop rapidly after you stop exercising.) Compare your heart rate to your training zone. If your heart rate is below your training zone, increase your level of exertion. If your heart rate is too high, decrease your level of exertion.



WORKOUT PATTERN

Every workout should consist of 5 important parts: 1. Resting, 2. Warming up, 3. Training zone exercise, 4. Cooling down, 5. Resting. Warming up should be a part of every workout, preparing the body for exercise by increasing circulation, delivering more oxygen to the muscles, and raising body temperature. 5-10 minutes of stretching will provide a good warm-up. After warming up, begin exercising with low intensity. After a few minutes, increase the intensity of your exercise to raise your heart rate to your training zone for a period of 20-30 minutes. To aid circulation, and help prevent soreness, finish your workout with 5-10 minutes of stretching or light exercise.

EXERCISE FREQUENCY

To maintain or improve your condition, you must work out 2-3 times per week following the pattern described above. A day of rest between workouts is recommended. After several months of exercise, the number of workouts can be increased to 4-5 per week. The key to a successful program is **CONSISTENCY**.

PART LIST- Model No. PF105110

Rev. 12/91

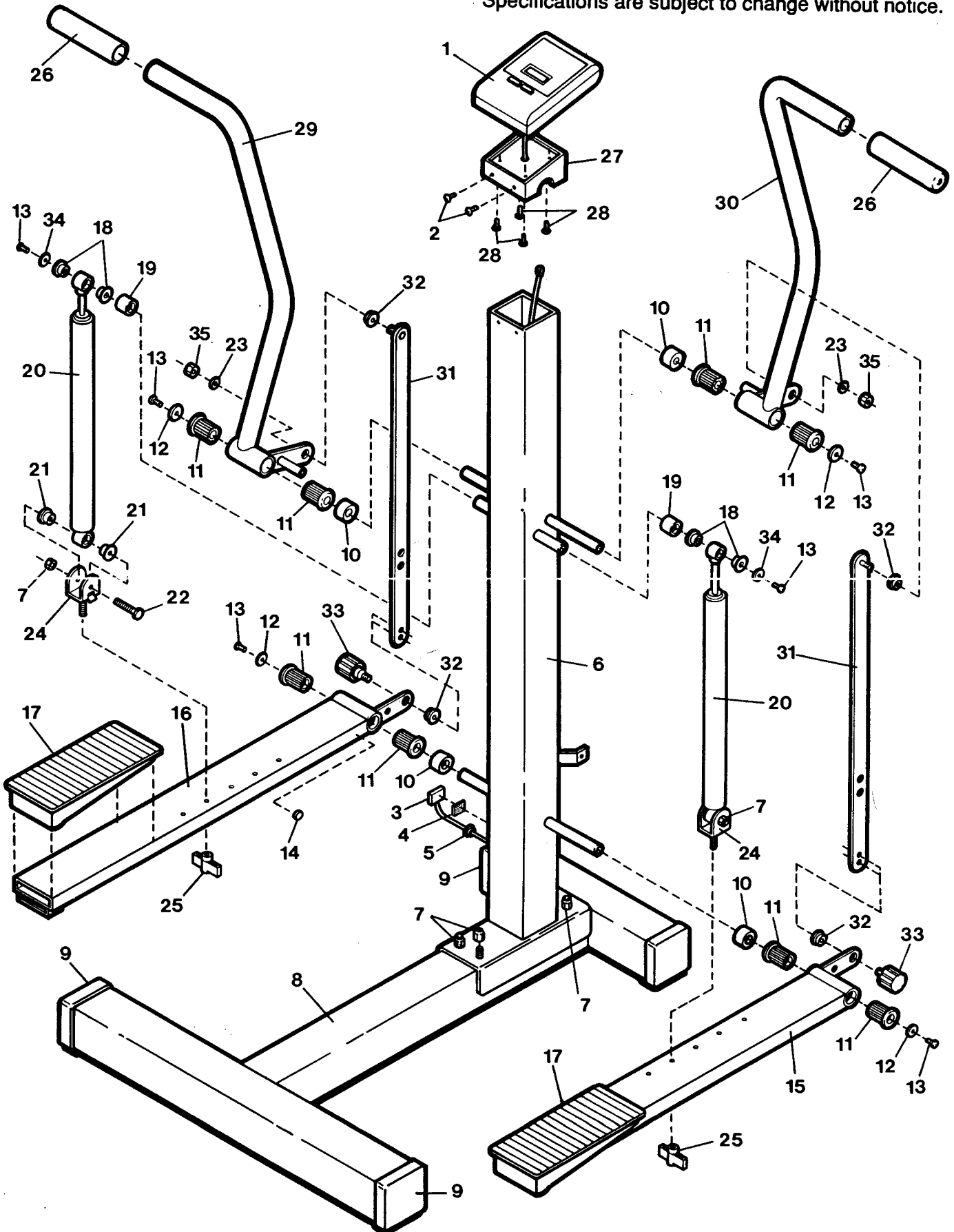
Key No.	Qty.	Description	Key No.	Qty.	Description
1	1	Electronic Monitor	20	2	Resistance Cylinder
2	2	Bracket Screw	21	4	Lower Cylinder Bushing
3	1	Sensor Wire/Reed Switch	22	2	Bracket Bolt
4	1	Fastener Strip	23	2	Handlebar Washer
5	1	Grommet	24	2	Cylinder Bracket
6	1	Main Frame	25	2	Bracket Knob
7	6	Nylock Nut	26	2	Handgrip
8	1	Base	27	1	Monitor Bracket
9	4	Base Endcap	28	4	Monitor Screw
10	4	Spacer	29	1	Left Handlebar
11	8	Bushing	30	1	Right Handlebar
12	4	Washer	31	2	Link Arm
13	6	Bolt	32	4	Bronze Bushing
14	1	Magnet	33	2	Link Arm Knob
15	1	Right Pedal	34	2	Cylinder Washer
16	1	Left Pedal	35	2	Thin Nylock Nut
17	2	Foot Pad	#	1	Owner's Manual
18	4	Upper Cylinder Bushing	#	1	Grease
19	2	Cylinder Spacer	#	1	Allen Wrench

Note: "#" indicates a non-illustrated part. Specifications are subject to change without notice. See the back cover for information about ordering replacement parts.

EXPLODED DRAWING- Model No. PF105110

Rev. 12/91

Specifications are subject to change without notice.



ORDERING REPLACEMENT PARTS

Replacement parts can be ordered by calling our Customer Service Department toll-free at **1-800-999-3756**, during our business hours: Monday - Friday, 6 a.m. - 6 p.m., Mountain Time. When ordering parts, please be prepared to give the following information:

1. The **MODEL NUMBER** of the product (PF105110).
2. The **NAME** of the product (Pro Form STEP USA II).
3. The **SERIAL NUMBER** of the product (see the front cover of this manual).
4. The **KEY NUMBER** of the part(s) from page 10 of this manual.
5. The **DESCRIPTION** of the part(s) from page 10 of this manual.

LIMITED WARRANTY

PRO FORM Fitness Products, Inc. ("Pro Form"), warrants this product to be free from defects in workmanship and material, under normal use and service conditions, for a period of ninety (90) days from the date of purchase. This warranty extends only to the original purchaser. PRO FORM's obligation under this warranty is limited to replacing or repairing, at PRO FORM's option, the product at one of its authorized service centers. All products for which warranty claim is made must be received by PRO FORM at one of its authorized service centers with all freight and other transportation charges prepaid, accompanied by sufficient proof of purchase. All returns must be pre-authorized by PRO FORM. This warranty does not extend to any product or damage to a product caused by or attributable to freight damage, abuse, misuse, improper or abnormal usage or repairs not provided by an PRO FORM authorized service center or for products used for commercial or rental purposes. No other warranty beyond that specifically set forth above is authorized by PRO FORM.

PRO FORM IS NOT RESPONSIBLE OR LIABLE FOR INDIRECT, SPECIAL OR CONSEQUENTIAL DAMAGES ARISING OUT OF OR IN CONNECTION WITH THE USE OR PERFORMANCE OF THE PRODUCT OR OTHER DAMAGES WITH RESPECT TO ANY ECONOMIC LOSS, LOSS OF PROPERTY, LOSS OF REVENUES OR PROFITS, LOSS OF ENJOYMENT OR USE, COSTS OF REMOVAL, INSTALLATION OR OTHER CONSEQUENTIAL DAMAGES OF WHATSOEVER NATURE. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES. ACCORDINGLY, THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

THE WARRANTY EXTENDED HEREUNDER IS IN LIEU OF ANY AND ALL OTHER WARRANTIES AND ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE IS LIMITED IN ITS SCOPE AND DURATION TO THE TERMS SET FORTH HEREIN. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS. ACCORDINGLY, THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

This warranty gives you specific legal rights. You may also have other rights which vary from state to state.

PRO FORM FITNESS PRODUCTS, INC., 1500 S. 1000 W., Logan, UT 84321-9813