

987654321

NOTES:

1. ASSEMBLE AND INSPECT PER SOP 620-7918.

2. COLOR DICTATED BY THE SALES ORDER.

a. COLOR: -XX COLOR DESIGNATOR AS SPECIFIED IN SOP 620-8222.

b. THE -XX CAN RESULT IN ONE COLOR FOR THE METAL SHROUD AND A DIFFERENT COLOR FOR THE METAL FRAME ALSO WITH A -XX LISTED ON THE BOM.

c. THE -00XX IS THE COLOR DESIGNATOR FOR UPHOLSTERY.

d. THE 5TH DESIGNATOR: "X" WITHIN -XXXXX DEFINES THE HEAD STRAP OR CUSTOM PRODUCTS BRAND. THIS IS SPECIFIED ON SALES ORDERS.

e. THE -XXXXX IS CREATED BY COMBINING THE -XX, -00XX AND THE 5TH DESIGNATOR. ALL X'S SHOULD BE DEFINED ON THE SALES ORDER.

1462.5

2058.7

1241

324.5

1146

1952.6

REVISION HISTORY

REV	DATE	DESCRIPTION	ECO	BY
--	11/1/11	RELEASED @ LAND AMERCA		LA
A	5/24/2012	DRAWINGS RELEASED FOR PRODUCTION	13739	KEY
B	2/28/2014	MAKE ASSEMBLY TO MATCH LA PRODUCTION, MAKE ALL WEIGHT HORNS ONE PIECE CHROME PLATED ADD PARTS: 731-6095-XX,731-6093-XX,731-6091-XX,731-6090-XX,731-6089,731-6088,731-5960,731-5806,731-5777,731-5727,731-5272,731-5259,731-5256,731-3958,731-1462,731-1448 UPDATE PARTS: 731-3443-XX,731-3440-XX,731-3431-XX	14557	RLH
C	10/10/2014	ADDED 731-6104, 731-6107, 731-2969, 110-3624, 731-6430 REMOVED, 731-2578	14765	KY

DOCUMENT STATUS:

NOTICE OF PROPRIETARY INFORMATION

THIS DOCUMENT SHALL NOT BE REPRODUCED NOR SHALL THE INFORMATION CONTAINED HEREIN BE USED BY OR DISCLOSED TO OTHER EXCEPT AS EXPRESSLY AUTHORIZED BY CORE HEALTH & FITNESS, LLC.

CLASS OF WORK		UNLESS OTHERWISE SPECIFIED DIMS ARE IN mm. TOLERANCES FOR MEASURE OF LENGTH ARE:							MATERIAL SEE BOM
		0.5 to 3	> 3 to 6	> 6 to 30	> 30 to 120	> 120 to 400	> 400 to 1000	> 1000 to 2000	
FINE		±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	----
MEDIUM	X	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
COARSE		±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4
VERY COARSE		----	±0.5	±1	±1.5	±2.5	±4	±6	±8

FINISH
SEE NOTES

VENDOR: N/A

P/N: N/A

THIRD ANGLE PROJECTION

DRAWN

CHECKED

APPROVED

INITIAL

DATE

2/28/14

CORE PART NO

IP-L2004-XXXXX

TITLE

ASSY,LEV,DECLINE PRESS

SCALE: 1:20

SHEET 1 OF 8

SHEET SIZE: B

CORE HEALTH & FITNESS, LLC

4400 NE 77th Ave., Suite 300

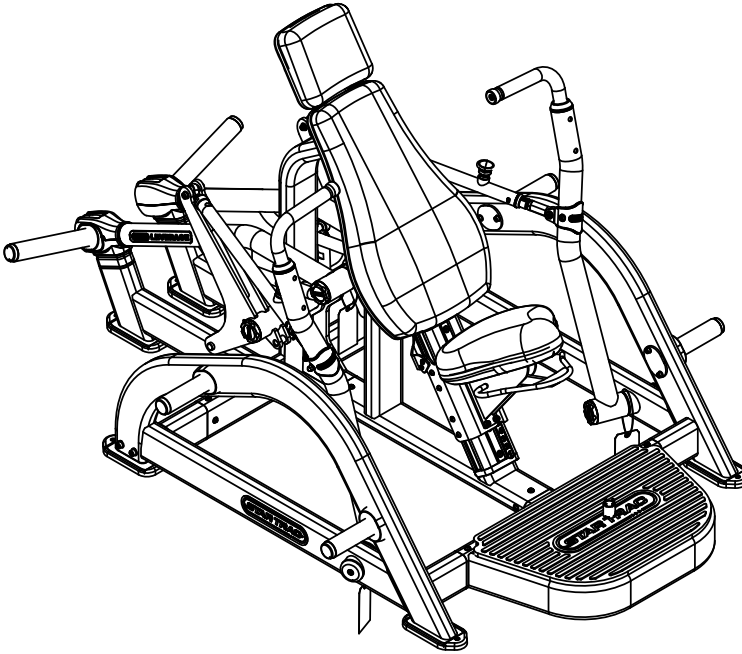
Vancouver, WA 98662

REV

C

987654321

9					8					7					6					5					4					3					2					1																																								
J	C	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	C	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	C	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	C	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	J																																																											
		1	110-3402	SCREW, #8-18, 3/4", HI-LOW, PHT, PH, CS, BO	6		53	731-2580	M10 X 65MM HSHCS	4		105	731-6430	BAR, PIVOT AXLE, L2, LONG	6																																																																	
I	C	2	110-3624	NUT, M24, NKL	2	C	54	731-2590	END CAP,BEARING, SEAL,	6	C	55	731-2591	O-RING 30X3.55-A	6	C	56	731-2592	SEAL,HOUSING	6	I																																																											
		3	718-5249	SCREW, M8 X 1.25mm, 55mm, BHC, HK, NP	2		57	731-2595	TAPPER ROLLER BEARING, 30304 GB 297-94	6			731-2596	O-RING, BEARING CAP SEAL	6			731-2606	DIE CAST END CAP, L2	2																																																												
		4	731-0022-00XX	ASSY,UPHOLSTERY,HEAD REST	1		58	731-2596	O-RING, BEARING CAP SEAL	6			731-2607	WEDGE,END CAP,	2			731-2608	BOLT, M8X70mm HSHCS	2																																																												
		5	731-0033	NUT, RIVET,M8 X 1.25	8		59	731-2606	DIE CAST END CAP, L2	2			731-2609	BASE,HANDLE GRIP,ARMS,L2	2			731-2610	PLATE,BENT,PIVOT RING	2																																																												
		6	731-0076	PULL PIN, SEAT ADJ	1		60	731-2607	WEDGE,END CAP,	2			731-2622	BAR,BUSHING,MISS-ALIGNMENT	6			731-2623	SHOULDER BOLT B18.3.3m-10X50 SHSS	2																																																												
		7	731-0077	LINKAGE,PULL PIN,SEAT ADJ	2		61	731-2608	BOLT, M8X70mm HSHCS	2			731-2624	SHOULDER BOLT B18.3.3M-10X40 SHCC	2			731-2639	TRIM RING	2																																																												
		8	731-0097-00XX	ASSY,SEAT BOTTOM,STD	1		62	731-2609	BASE,HANDLE GRIP,ARMS,L2	2			731-2640	WELD,FOOT,MAX RACK,RH	2			731-2647	FOOT,LONG,LEVERAGE	6																																																												
		H	C	9	731-0209		CAP, END, 110 X 50	1	C	63			731-2610	PLATE,BENT,PIVOT RING	2			C	70	731-2648-00XX		ASSY,BACK REST, STD,ONE COLOR	1	C	71	731-2649	LABEL, STAR TRAC,DECO,LARGE	2	H																																																			
10	731-0350			Screw, M10X1.5, 25mm, SHC, HK	4	64	731-2622	BAR,BUSHING,MISS-ALIGNMENT		6	72	731-2657-XX	WELDMENT,SHOULDER,FOOT REST	1	73	731-2755	LEVERAGE LOGO			2																																																												
11	731-0352			SCREW,M6X0.8,10MM,BHC,HK	4	65	731-2623	SHOULDER BOLT B18.3.3m-10X50 SHSS		2	74	731-2756	DBL STICK TAPE,LEVERAGE,LOGO	2	75	731-2762	RUBBER BUMPER			2																																																												
12	731-0355			WASHER,PLAIN,M8,NARROW	51	66	731-2624	SHOULDER BOLT B18.3.3M-10X40 SHCC		2	76	731-2856	PLASTIC WEIGHT HORN COVER TRIM INSERT	2	77	731-2857	PLASTIC WEIGHT HORN COVER TOP			1																																																												
13	731-0359			SCREW,M8 X 1.25,25mm,BHC,HK	26	67	731-2639	TRIM RING		2	78	731-2858	PLASTIC WEIGHT HORN COVER BOTTOM	1	88	731-2866	PLASTIC,WEIGHT HORN COVER,TOP			1																																																												
14	731-0363			NUT,M10X1.5,NYLOC	4	68	731-2640	WELD,FOOT,MAX RACK,RH		2	79	731-2867	PLASTIC,WEIGHT HORN COVER BOTTOM	1	80	731-2867	PLASTIC,WEIGHT HORN COVER BOTTOM			1																																																												
15	731-0364			SCREW, M8X1.25, 45mm, BHC, HK	1	69	731-2647	FOOT,LONG,LEVERAGE		6	81	731-2969	WASHER,M16,NP	6	82	731-3420-XX	LEVERAGE,MID FRAME,DECLINE			1																																																												
16	731-0365			NUT,M8 X 1.25,NYLOC JAM	13	70	731-2648-00XX	ASSY,BACK REST, STD,ONE COLOR		1	83	731-3431-XX	WELDMENT.L2 STOP,DECLINE	1	84	731-3440-XX	WELDMENT,ARM,RIGHT,INCLINE			1																																																												
G	C	17	731-0367	WASHER,PLAIN,M10	20	C	71	731-2649	LABEL, STAR TRAC,DECO,LARGE	2	C	85	731-3443-XX	WELDMENT,ARM,LEFT,DECLINE	1	C	86	731-3446	DECLINE ROM STRAIGHT ASSY	2	G																																																											
		18	731-0368	SCREW,M8 X 1.25,40mm,BHC,HK	8		72	731-2657-XX	WELDMENT,SHOULDER,FOOT REST	1			87	731-3449-001	PLACARD,DECLINE,LEVERAGE 2			1	88	731-3858		ASSY,LINK SHORT,180MM	2																																																									
		19	731-0373	WASHER,PLAIN,M6	4		73	731-2755	LEVERAGE LOGO	2			89	731-3958	LEVERAGE NUT TOOL			1	90	731-5256		WELD,WEIGHT HORN,SINGLE	4																																																									
		20	731-0382	ROLL PIN,M6 X 20mm	1		74	731-2756	DBL STICK TAPE,LEVERAGE,LOGO	2			91	731-5259	BUMPER,STOP,WGT			6	92	731-5272		CAP,PLUG,WEIGHT HORN,BLANK	6																																																									
		21	731-0383	Cover, Head Rest	1		75	731-2762	RUBBER BUMPER	2			93	731-5727	RIVET NUT,HEX HEAD,M8			3	94	731-5777		TAG, LEVERAGE, SHAFT, TAB WASHER	6																																																									
		22	731-0385	SHROUD, SEAT BOTTOM	1		76	731-2856	PLASTIC WEIGHT HORN COVER TRIM INSERT	2			95	731-5806	WASHER,M8,HAT			4	96	731-5960		TWIST TIE	6																																																									
		23	731-0397	SCREW,M8 X 1.25,25mm,FHM,HK	3		77	731-2857	PLASTIC WEIGHT HORN COVER TOP	1			97	731-6088	WELD,BELL CRANK,RIGHT,DECLINE			1	98	731-6089		WELD,BELL CRANK,LEFT,DECLINE	1																																																									
		24	731-0421	SCREW, M8 X 1.25, 30MM, SHC, HK, CS	17		78	731-2858	PLASTIC WEIGHT HORN COVER BOTTOM	1			99	731-6090-XX	WELD,WEIGHT STORAGE,RIGHT,DECLINE			1	100	731-6091-XX		WELD,WEIGHT STORAGE,LEFT,DECLINE	1																																																									
F	C	25	731-0510	STICKER,SEAT ADJ,1-9	1	C	88	731-2866	PLASTIC,WEIGHT HORN COVER,TOP	1	C	101	731-6093-XX	WELD,WEIGHT ARM,DECLINE,LEFT	1	C	102	731-6095-XX	WELD,WEIGHT ARM,DECLINE,RIGHT	1	F																																																											
		26	731-0550-01	COVER,SEAT BACK,STD.,LEFT	1		89	731-3958	LEVERAGE NUT TOOL	1			103	731-6104	Slotted Hex Nut,Low,M16X1.5mm			6	104	731-6107		PIN, COTTER,3.2mmDIA x 32mm LONG	6																																																									
		27	731-0550-02	COVER, SEAT BACK, STD, RIGHT	1		90	731-5256	WELD,WEIGHT HORN,SINGLE	4			C	103	731-6104			Slotted Hex Nut,Low,M16X1.5mm	6	C		104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																																							
		28	731-0555-XX	WELD,MOUNT,TROLLEY,SEAT	1		91	731-5259	BUMPER,STOP,WGT	6					C			103	731-6104				Slotted Hex Nut,Low,M16X1.5mm	6	C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																																			
		29	731-0557	SPACER,WHEEL,TROLLEY	8		92	731-5272	CAP,PLUG,WEIGHT HORN,BLANK	6									C				103	731-6104			Slotted Hex Nut,Low,M16X1.5mm	6	C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																															
		30	731-0560	ASSY,WHEEL,41M DIA,TROLLEY	8		93	731-5727	RIVET NUT,HEX HEAD,M8	3														C			103	731-6104			Slotted Hex Nut,Low,M16X1.5mm	6	C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																											
		31	731-0561	WASHER,M8,1MM THK	14		94	731-5777	TAG, LEVERAGE, SHAFT, TAB WASHER	6																		C			103	731-6104			Slotted Hex Nut,Low,M16X1.5mm	6	C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																							
		32	731-0562	NUT,M8 X 1.25,NYLOC	8		95	731-5806	WASHER,M8,HAT	4																						C			103	731-6104			Slotted Hex Nut,Low,M16X1.5mm	6	C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																			
33	731-0564	EXTRUSION,TROLLEY,SEAT	1	96	731-5960	TWIST TIE	6	C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm	6				C	104				731-6107															PIN, COTTER,3.2mmDIA x 32mm LONG			6																																									
34	731-0565	SCREW,M4X22,FHT,PH,AS,ZP	8	97	731-6088	WELD,BELL CRANK,RIGHT,DECLINE	1			C	103	731-6104									Slotted Hex Nut,Low,M16X1.5mm															6			C	104			731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																			
35	731-0566	CAP,EXTRUSION,SEAT,TOP	2	98	731-6089	WELD,BELL CRANK,LEFT,DECLINE	1					C	103	731-6104						Slotted Hex Nut,Low,M16X1.5mm	6	C														104							731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																			
36	731-0567	BAR,ADJ,SEAT	1	99	731-6090-XX	WELD,WEIGHT STORAGE,RIGHT,DECLINE	1							C	103			731-6104		Slotted Hex Nut,Low,M16X1.5mm	6				C	104																	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																			
37	731-0570	SCREW,M8 X1.25,16mm,SHC,HK	4	100	731-6091-XX	WELD,WEIGHT STORAGE,LEFT,DECLINE	1											C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm		6						C	104													731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																			
38	731-0574-XX	MOUNT,SHOCK,SEAT	1	101	731-6093-XX	WELD,WEIGHT ARM,DECLINE,LEFT	1													C	103		731-6104	Slotted Hex Nut,Low,M16X1.5mm			6						C	104									731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																			
39	731-0577	ASSY,SHOCK,SEAT SLED,30LBS	1	102	731-6095-XX	WELD,WEIGHT ARM,DECLINE,RIGHT	1																C	103			731-6104	Slotted Hex Nut,Low,M16X1.5mm			6						C	104					731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																			
40	731-0601	SPRING, EXTENSION, 2.0", 21 LBS	1	C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm																				6	C			103	731-6104			Slotted Hex Nut,Low,M16X1.5mm						6	C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																		
41	731-0672-XX	WELD,SEAT REST,MOUNT -5DEG	1			C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm							6	C										103					731-6104			Slotted Hex Nut,Low,M16X1.5mm						6			C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																																
42	731-0674	ASSY,HANDLE,SEAT ADJ -5DEG	1					C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm					6																C			103				731-6104	Slotted Hex Nut,Low,M16X1.5mm	6					C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																														
43	731-0842	ASSY, BRG, TAPER, 30205	6							C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm			6						C														103			731-6104	Slotted Hex Nut,Low,M16X1.5mm	6							C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																												
44	731-1030	PIN, SPLIT, 2MM X 12	1									C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm	6									C	103													731-6104	Slotted Hex Nut,Low,M16X1.5mm	6									C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																										
45	731-1265	CAP,END,65MM,NO GROOVE	2											C	103	731-6104		Slotted Hex Nut,Low,M16X1.5mm	6										C	103									731-6104	Slotted Hex Nut,Low,M16X1.5mm	6											C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																								
46	731-1448	NUT,M8x1.25,ACORN	2													C		103	731-6104	Slotted Hex Nut,Low,M16X1.5mm	6												C	103					731-6104	Slotted Hex Nut,Low,M16X1.5mm	6													C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																						
47	731-1450	SCREW,M8 X 1.25,75mm,SHC,HK,AS,ZP	8																C	103	731-6104		Slotted Hex Nut,Low,M16X1.5mm	6													C	103	731-6104	Slotted Hex Nut,Low,M16X1.5mm	6															C	104	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																				
48	731-1456-01	PLATE,MOUNT,WGT HOLDER,BLANK	4	C	103																731-6104		Slotted Hex Nut,Low,M16X1.5mm	6				C			103								731-6104	Slotted Hex Nut,Low,M16X1.5mm	6	C	104															731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																				
49	731-1462	SCREW,M8 X 1.25,80mm,BHC,HK,AS, NKL	2			C	103										731-6104				Slotted Hex Nut,Low,M16X1.5mm		6	C			103												731-6104	Slotted Hex Nut,Low,M16X1.5mm	6			C	104													731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																				
50	731-1713	PIN,CLEVIS,M6 X 22,15.9UL	1					C	103								731-6104				Slotted Hex Nut,Low,M16X1.5mm		6									C			103				731-6104	Slotted Hex Nut,Low,M16X1.5mm	6					C	104											731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																				
51	731-2416	STICKER,STARTRAC,70MM,DECO	2							C	103						731-6104				Slotted Hex Nut,Low,M16X1.5mm	6	C													103			731-6104	Slotted Hex Nut,Low,M16X1.5mm	6							C	104									731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																				
52	731-2575	ASSEMBLY, FOOT PAD, LEVERAGE	1									C	103				731-6104				Slotted Hex Nut,Low,M16X1.5mm	6			C	103													731-6104	Slotted Hex Nut,Low,M16X1.5mm	6									C	104							731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																				
9														8							7								6										5													4						3					2					1												



CORE HEALTH & FITNESS, LLC

4400 NE 77th Ave., Suite 300
Vancouver, WA 98662

CORE PART NO
IP-L2004-XXXXX

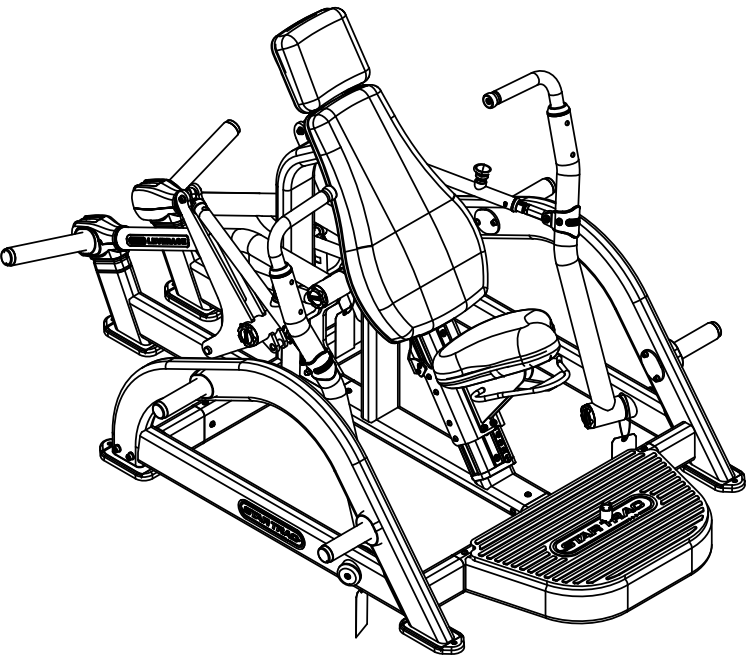
REV
C

TITLE
ASSY,LEV,DECLINE PRESS

SCALE: 1:20

SHEET 2 OF 8

SHEET SIZE: B



CORE HEALTH & FITNESS, LLC

4400 NE 77th Ave., Suite 300
Vancouver, WA 98662

CORE PART NO

IP-L2004-XXXXX

REV

C

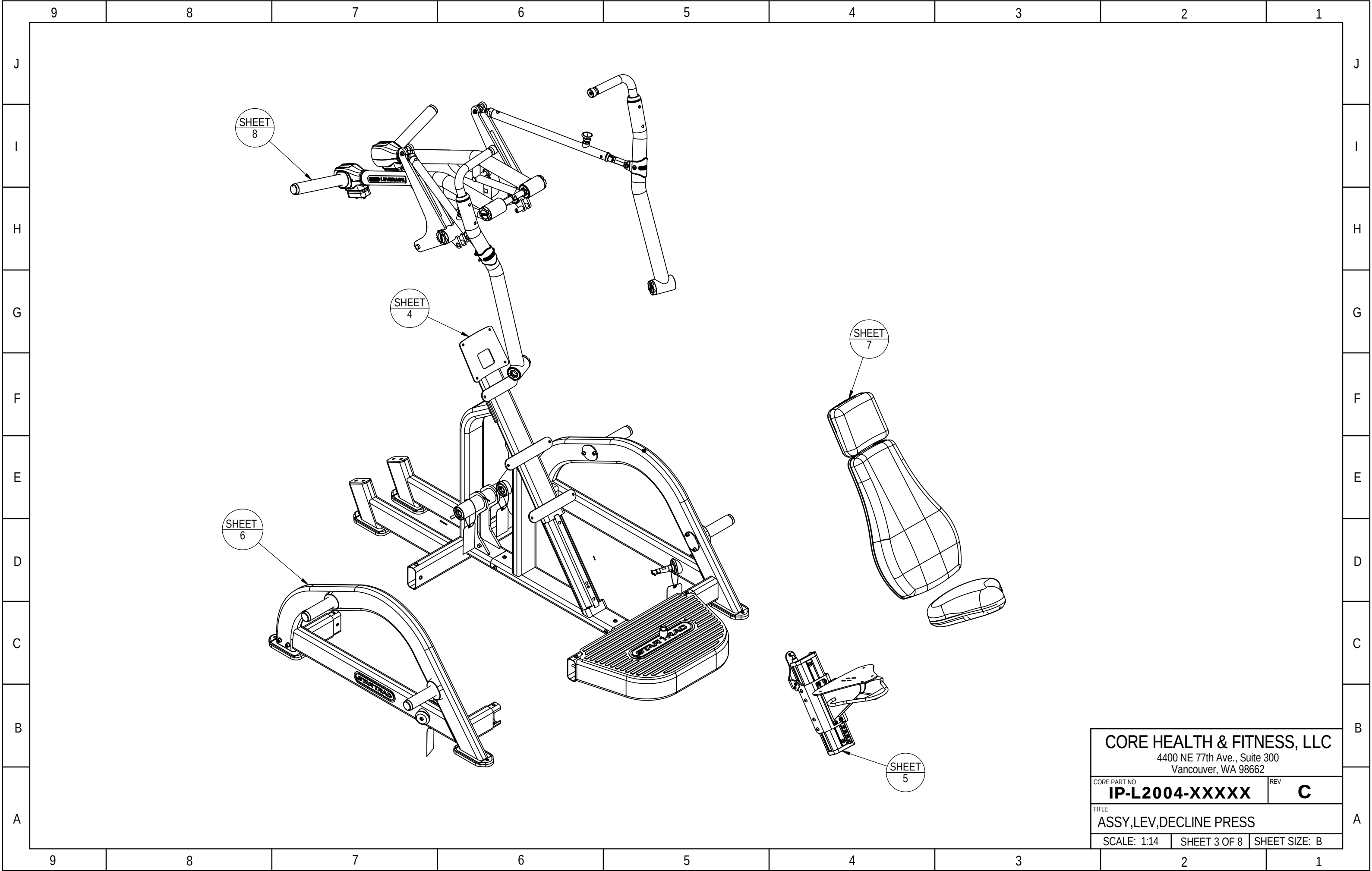
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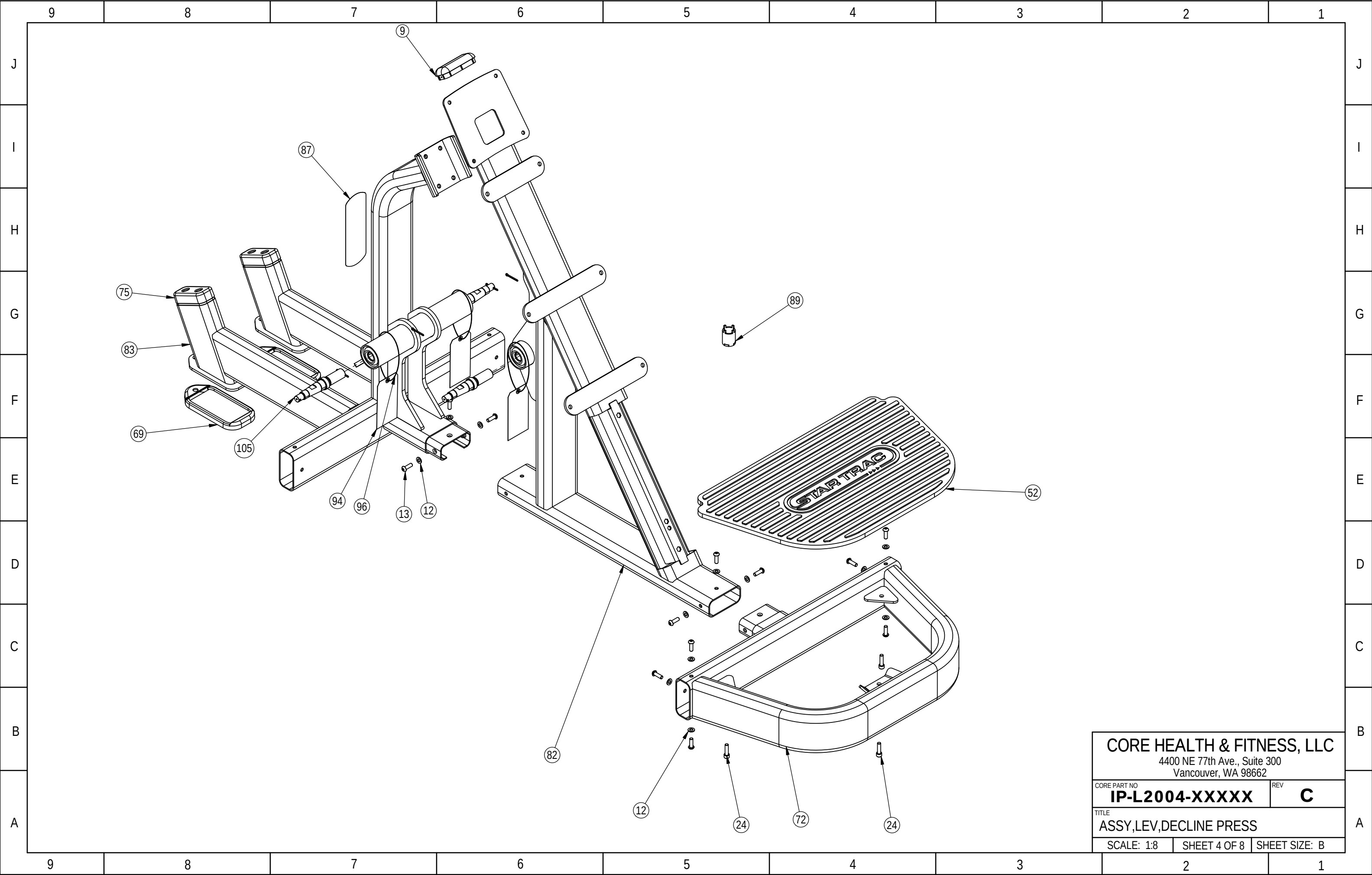
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SHEET 2 OF 8

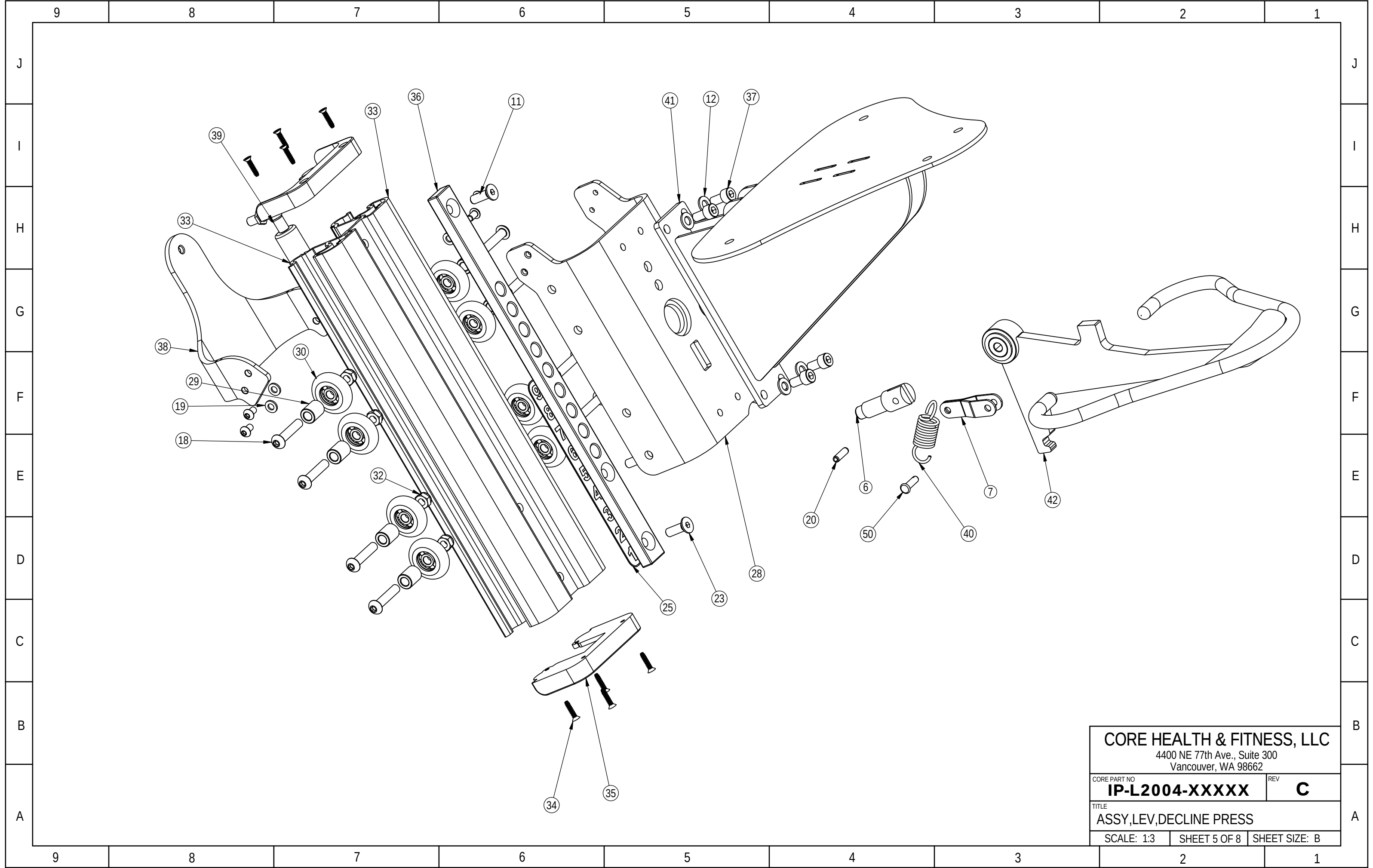
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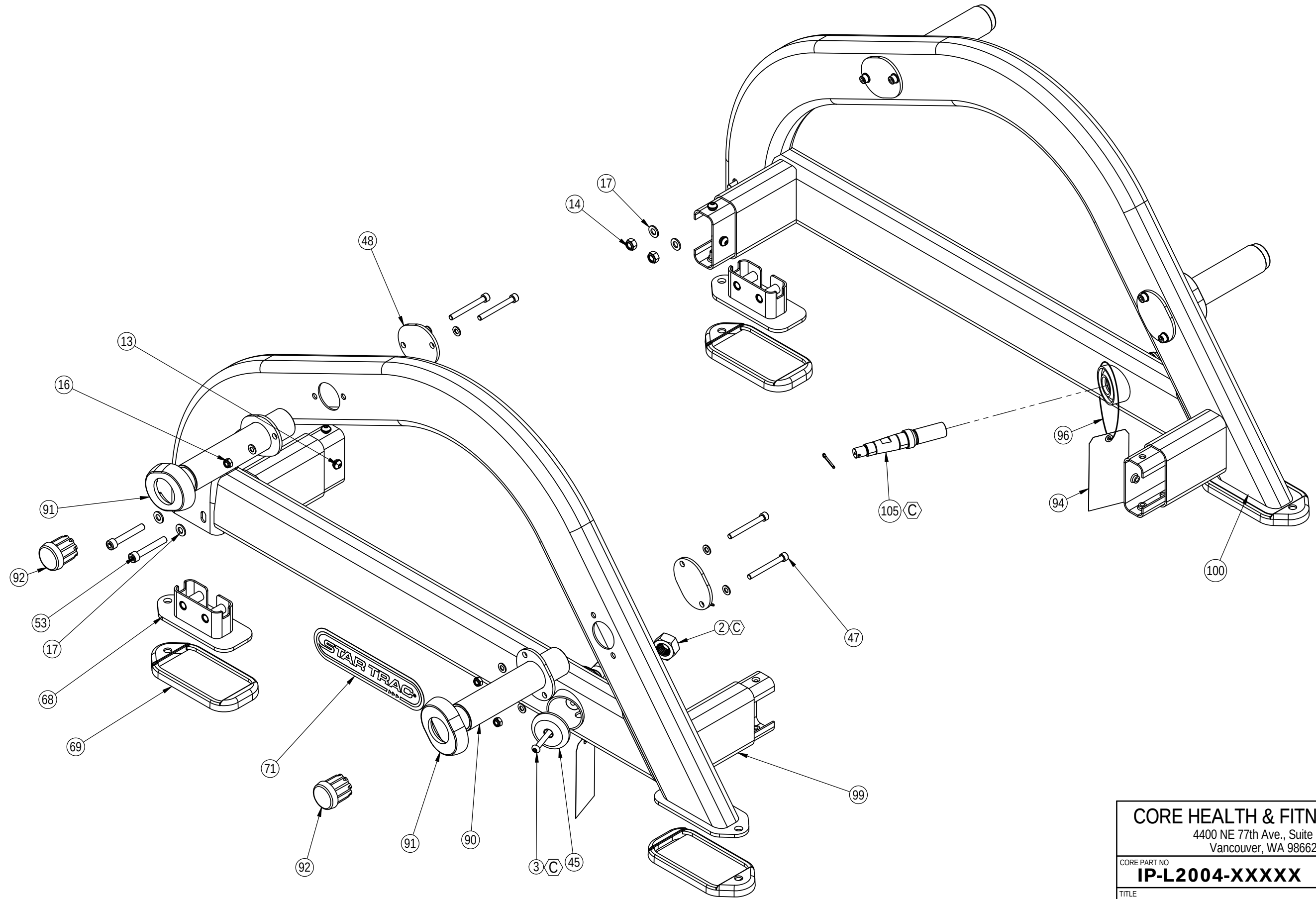
CORE HEALTH & FITNESS, LLC 4400 NE 77th Ave., Suite 300 Vancouver, WA 98662		
CORE PART NO	REV	
IP-L2004-XXXXX	C	
TITLE ASSY,LEV,DECLINE PRESS		
SCALE: 1:14	SHEET 3 OF 8	SHEET SIZE: B



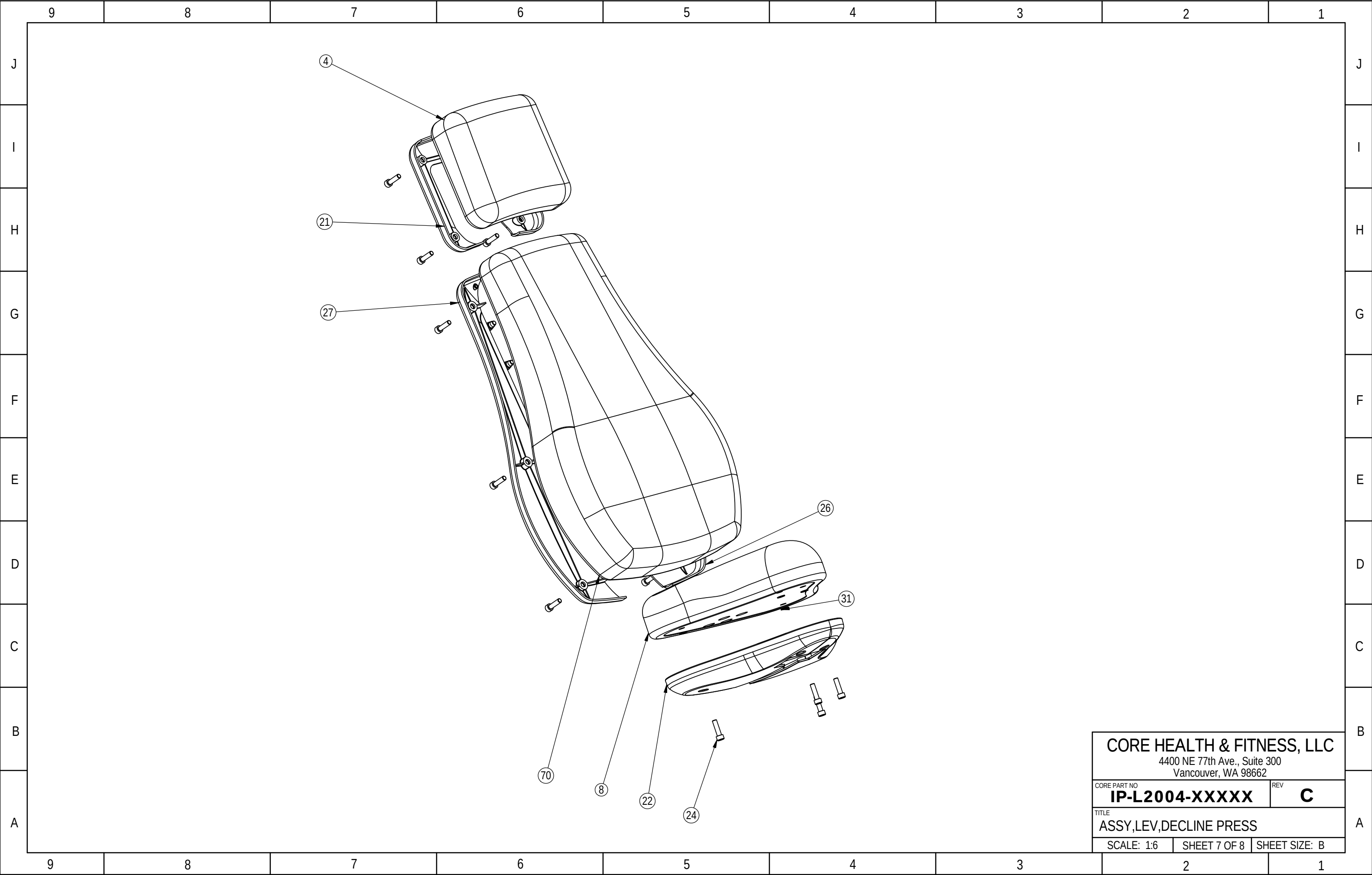
CORE HEALTH & FITNESS, LLC 4400 NE 77th Ave., Suite 300 Vancouver, WA 98662		
CORE PART NO	IP-L2004-XXXXX	REV C
TITLE ASSY,LEV,DECLINE PRESS		
SCALE: 1:8	SHEET 4 OF 8	SHEET SIZE: B



CORE HEALTH & FITNESS, LLC 4400 NE 77th Ave., Suite 300 Vancouver, WA 98662		
CORE PART NO	IP-L2004-XXXXX	REV C
TITLE ASSY,LEV,DECLINE PRESS		
SCALE: 1:3	SHEET 5 OF 8	SHEET SIZE: B



CORE HEALTH & FITNESS, LLC 4400 NE 77th Ave., Suite 300 Vancouver, WA 98662		
CORE PART NO	IP-L2004-XXXXX	REV C
TITLE ASSY,LEV,DECLINE PRESS		
SCALE: 1:6	SHEET 6 OF 8	SHEET SIZE: B



CORE HEALTH & FITNESS, LLC 4400 NE 77th Ave., Suite 300 Vancouver, WA 98662		
CORE PART NO	IP-L2004-XXXXX	REV C
TITLE ASSY,LEV,DECLINE PRESS		
SCALE: 1:6	SHEET 7 OF 8	SHEET SIZE: B

