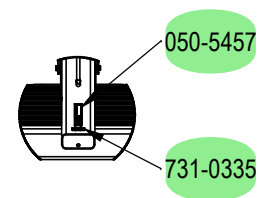
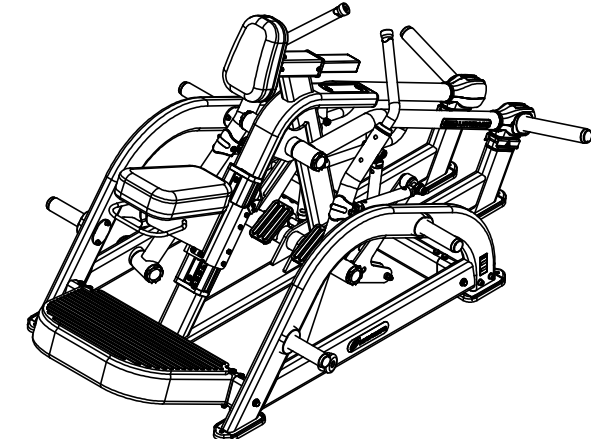
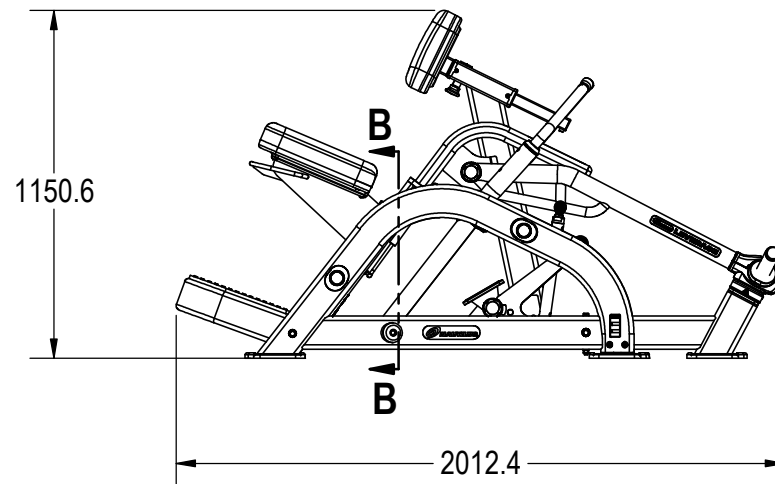
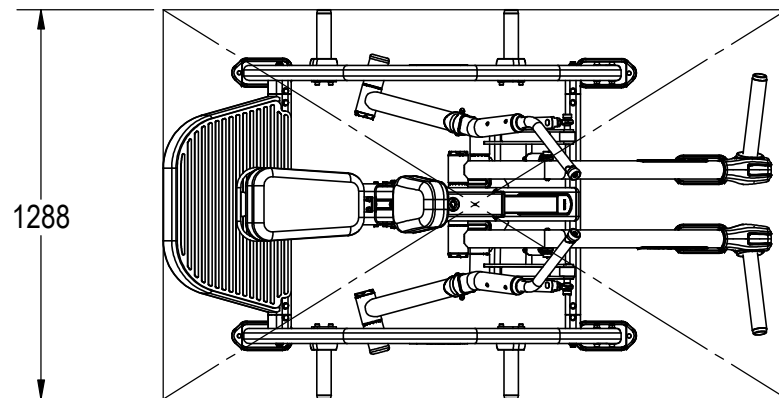


NOTES:

1. ASSEMBLE AND INSPECT PER SOP 620-7918.
2. APPLY DESIGNATED THREAD LOCKER TO SPECIFIED ITEMS IN NUMEROUS LOCATIONS WHERE THE ITEM IS USED.
 - a. VERIFY THAT MATING THREADS ARE FREE OF ANY DEBRIS OR OIL RESIDUES AND APPLY LOCTITE 242 (BLUE) THREAD LOCKER OR ENGINEERING APPROVED EQUIVALENT.
 - b. VERIFY THAT MATING THREADS ARE FREE OF ANY DEBRIS OR OIL RESIDUES AND APPLY LOCTITE 262 (RED) THREAD LOCKER OR ENGINEERING APPROVED EQUIVALENT.
3. TAPERED ROLLER BEARING ASSEMBLY:
 - a. BEFORE MOUNTING; PACK BEARINGS WITH GENERAL PURPOSED LITHIUM GRADE 2 GREASE OR ENGINEERING APPROVED EQUIVALENT.
4. TAPERED BEARING NUT LOCKING PROCESS:
 - a. APPLY INITIAL TORQUE OF: 40-42 FT-LBS TO SQUARE AND SEAT BEARINGS.
 - b. LOOSEN LOCK NUT.
 - c. APPLY FINAL TORQUE OF 7-9 FT-LBS.
 - d. CLOCK THE LOCK NUT TO ALIGN WITH HOLE IN PIVOT SHAFT AND INSTALL COTTER PIN.
5. COLOR DICTATED BY THE SALES ORDER:
 - a. COLOR: -XX COLOR DESIGNATOR AS SPECIFIED IN SOP 620-200-112.
 - 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
 - e. STRAP OR CUSTOM PRODUCTS BRAND. THIS IS SPECIFIED ON SALES ORDERS.
 - f. THE -XXXXX IS CREATED BY COMBINING THE -XX, -00XX AND THE 5TH DESIGNATOR.
 - g. ALL X'S SHOULD BE DEFINED ON THE SALES ORDER.



SECTION B-B



REVISION HISTORY

REV	DATE	DESCRIPTION	ECO	BY
A	4/26/16	INITIAL RELEASE	15309	KY
B	8/29/2016	REPLACE BUTTON HEAD SCREWS WITH HEX HEAD STYLE SCREWS IN CRITICALLY IDENTIFIED LOCATIONS. RIVET NUTS REMOVED FROM CRITICAL LOCATIONS AND NECESSARY WELDED ASSEMBLIES REPLACED TO ALLOW THRU BOLT FASTENING FEATURES THAT REQUIRE LOCKING NUTS. UPDATED NOTES TO INCLUDE THREAD LOCK, TORQUE PROCESS, & BEARING ASSEMBLY. SPECIFIED LOCATIONS WHERE NEW NOTES APPLY. REMOVED VARYING QUANTITIES OF THE FOLLOWING ITEMS: 718-5249, 730-2882, 731-0350, 731-0352, 731-0359, 731-0368, 731-1456-01, 731-2612, 731-2613, 731-2614, 731-2640, 731-2755, 731-2756, 731-2816-XX, 731-2817-XX, 731-2819, 731-2820, 731-2835, 731-2838, 731-2840, 731-3859, 731-6449-XX, 731-6451-XX, 731-7321, 731-7322. ADDED VARYING QUANTITIES OF THE FOLLOWING: 000-0077, 110-3373, 110-3576, 110-3781, 110-3784, 110-3919, 110-3930, 110-3931, 731-0652, 731-1448, 731-1462, 731-2299-XX, 731-2640-XX, 731-2835-XX, 731-2838-XX, 731-3452, 731-4864, 731-5330, 731-5565, 731-5806, 731-7311, 731-7706, 731-7716, 731-7743, 731-7804, 731-7810-XX, 731-7811-XX, 731-7812-XX, 731-7813-XX, 731-7814-XX, 731-7815-XX.	15538	JO
C	8/9/2017	ADD 731-7941 (2), 731-5810 (4), IS: 731-5752 (4) 731-0225(2) WAS: 731-0225 (6)	15776	RLH
D	12/14/2017	REPLACE LEFT & RIGHT BELLCRANK (731-7812-XX & 731-7813-XX) WITH NEW BELLCRANKS (731-8211-XX & 731-8212-XX) THAT PROVIDE GREATER CLEARANCE WITH OTHER MOVING PARTS WHILE THE PRODUCT IS IN USE. NEW BELLCRANKS ARE NOW KITS WITH TAPERED BEARINGS AND HARDWARE INCLUDED.	15838	JO

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:							ANGLES = ±2°
	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

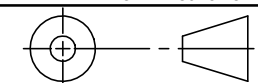
MATERIAL
SEE BOM

FINISH
N/A

VENDOR: N/A

P/N: N/A

THIRD ANGLE PROJECTION



DRAWN	INITIAL	DATE
CHECKED	KEY	4/26/16
APPROVED		

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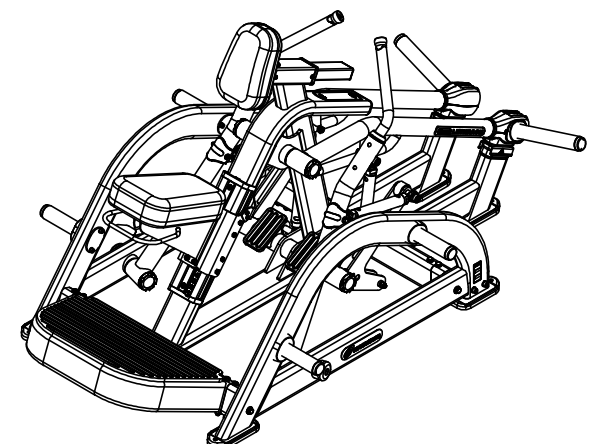
CORE PART NO
NP-L3004-XXXX

REV
D

TITLE
LEVERAGE, LOW ROW

SCALE: 1:25 SHEET 1 OF 7 SHEET SIZE: B

9				8				7				6				5				4				3				2				1			
J	ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.	J														
	1	000-0077	SCREW,M6x1.0,10mm,HHC,HE,CS	4	48	731-0646	STICKER, 1-7, 210MM X 14MM	1	95	731-6104	Slotted Hex Nut,Low,M16X1.5mm	6																							
	2	050-5457	Label, S/N, Non-Powered, Primary, Core H&F	1	49	731-0842	ASSY, BRG, TAPER, 30205	4	96	731-6107	PIN, COTTER,3.2mmDIA x 32mm LONG	6																							
	3	110-3373	Screw, M10x1.5, 85mm, SHC, HK, AS, NKL, Gr-10.9	2	50	731-0867	SHROUD, SEAT BOTTOM, VERT. ROW	1	97	731-6430	BAR, PIVOT AXLE, L2, LONG	6																							
	4	110-3402	SCREW, #8-18, 3/4", HI-LOW, PHT, PH, CS, BO	6	51	731-0870	SHROUD, CHEST PAD, ROW	1	98	731-6454-XX	WELDMENT, BENT, L2,WEIGHT FRAME, ONE PIECE,LEFT	1																							
I	5	110-3576	SCREW, M8-1X55, SHHM, HE, SS	2	52	731-1448	NUT,M8x1.25,ACORN	2	99	731-6455-XX	WELDMENT, BENT, L2,WEIGHT FRAME, ONE PIECE,RIGHT	1																							
	6	110-3781	SCREW,M8x1.25,40mm,HHC,HE,AS,ZC,GR12.9	8	53	731-1450	SCREW,M8 X 1.25,75mm,SHC,HK,AS,ZP	8	100	731-6617	SPACER, STIFFENING, LEVERAGE	4																							
	7	110-3936	SCREW,M10x1.5,70mm,HHC,HE,AS,ZC,GR12.9	2	54	731-1462	SCREW,M8 X 1.25,80mm,BHC,HK,AS, NKL	2	101	731-6618	SLEEVE, COMPRESSION, LEVERAGE	4																							
	8	110-3973	NUT,M10X1.5,AS,ZC,NYLON	2	55	731-1918	SHOE, GRIP	2	102	731-6619	INSERT, THREADED, LEVERAGE	4																							
	9	110-4037	M10x1.5x70MM HSHCS	4	56	731-2299-XX	PLATE,MOUNT,WGT HOLDER,BLANK	4	103	731-7108	ASSEMBLY, ARM COUPLING, LEVERAGE	2																							
	10	731-0076	PULL PIN, SEAT ADJ	1	57	731-2575	ASSEMBLY, FOOT PAD, LEVERAGE	1	104	731-7111	WASHER,M16,30mmOD,1mmTHK	4																							
H	11	731-0077	LINKAGE,PULL PIN,SEAT ADJ	2	58	731-2591	O-RING 30X3.55-A	4	105	731-7311	STICKER,NAUTILUS,DECO,45MMX191MM	2																							
	12	731-0209	CAP, END, 110 X 50	1	59	731-2592	SEAL,HOUSING	4	106	731-7317	PLACARD,ROW,LEVERAGE 2	1																							
	13	731-0225	SCREW,M3.5 X 9.5,SELF TAPPING	2	60	731-2595	TAPPER ROLLER BEARING, 30304 GB 297-94	4	107	731-7683	END CAP, BEARING,SEAL,NAUT.	4																							
	14	731-0287	NUT,M8x1.25,NYLOCK	1	61	731-2596	O-RING, BEARING CAP SEAL	4	108	731-7706	SCREW,M10x1.5,130mm,HHC,HE,AS,ZC,GR12.9	8																							
G	15	731-0335	STICKER, MADE IN CHINA, IP	1	62	731-2606	DIE CAST END CAP, L2	2	109	731-7716	ROD END, M16x2.0, MALE	8																							
	16	731-0355	WASHER,PLAIN,M8,NARROW	32	63	731-2607	WEDGE,END CAP,	2	110	731-7743	KIT, COUPLER, O-RING	2																							
	17	731-0363	NUT,M10X1.5,NYLOC	14	64	731-2608	BOLT, M8X70mm HSHCS	2	111	731-7804	KIT, LEVERAGE EMBLEM, NAU. LOGO	2																							
	18	731-0364	SCREW,M8 X 1.25,45MM,BHC,HK	1	65	731-2609	BASE,HANDLE GRIP,ARMS,L2	2	112	731-7810-XX	MID FRAME, LOW ROW,V2	1																							
	19	731-0365	NUT,M8 X 1.25,NYLOC JAM	10	66	731-2610	PLATE,BENT,PIVOT RING	2	113	731-7811-XX	WELDMENT, PEDESTAL, LOW ROW, V2	1																							
F	20	731-0367	WASHER,PLAIN,M10	38	67	731-2616	NUT,JAM,M16X2.0	8	114	731-7814-XX	WELDMENT, WEIGHT ARM, LOW ROW, V2, L	1																							
	21	731-0373	WASHER,PLAIN,M6	4	68	731-2622	BAR,BUSHING,MISS-ALIGNMENT	4	115	731-7815-XX	WELDMENT, WEIGHT ARM, LOW ROW, V2, R	1																							
	22	731-0382	ROLL PIN,M6 X 20mm	4	69	731-2624	SHOULDER BOLT B18.3.3M-10X40 SHCC	2	116	731-7941-KT	KIT,COVER,TUBE ADJ SLEEVE,S SIDE	2																							
	23	731-0397	SCREW,M8x1.25,25mm,FHM,HK,AS,GR12.9,NKL,FT	3	70	731-2639	TRIM RING, LEVERAGE,	2	117	731-8211-XX	KIT, BELL CRANK + COMPONENTS, R	1																							
	24	731-0510	STICKER,SEAT ADJ,1-9	1	71	731-2640-XX	WELD,FOOT,MAX RACK,RH	2	118	731-8212-XX	KIT, BELL CRANK + COMPONENTS, L	1																							
E	25	731-0517	STICKER, WARNING, BOLT DOWN	2	72	731-2647	FOOT,LONG,LEVERAGE	6																											
	26	731-0530	SPRING,SEAT ADJ,SEAT 1	1	73	731-2762	RUBBER BUMPER	2																											
	27	731-0555-XX	WELD,MOUNT,TROLLEY,SEAT	1	74	731-2822-XX	ARM, ROW, RIGHT	1																											
	28	731-0557	SPACER,WHEEL,TROLLEY	8	75	731-2825-XX	ARM,ROW,LEFT	1																											
	29	731-0560	ASSY,WHEEL,41M DIA,TROLLEY	8	76	731-2835-XX	WELDMENT, LINK, LONG, LOW ROW	2																											
D	30	731-0561	WASHER,M8,1MM THK	8	77	731-2838-XX	WELDMENT, LINK, SHORT, LOW ROW	2																											
	31	731-0562	NUT,M8 X 1.25,NYLOC	10	78	731-2845	WELD, SUPPORT, PAD, CHEST, ROW,L2	1																											
	32	731-0564	EXTRUSION,TROLLEY,SEAT	1	79	731-2856	PLASTIC WEIGHT HORN COVER TRIM INSERT	2																											
	33	731-0565	SCREW,M4x0.7,22mm,FHM,AS,GR12.9,NKL,ST	8	80	731-2857	PLASTIC WEIGHT HORN COVER TOP	1																											
	34	731-0566	CAP,EXTRUSION,SEAT,TOP	2	81	731-2858	PLASTIC WEIGHT HORN COVER BOTTOM	1																											
C	35	731-0567	BAR,ADJ,SEAT	1	82	731-2866	PLASTIC,WEIGHT HORN COVER,TOP	1																											
	36	731-0570	SCREW,M8x1.25,16mm,SHC,HK,AS,GR12.9,NKL,FT	16	83	731-2867	PLASTIC,WEIGHT HORN COVER BOTTOM	1																											
	37	731-0574-XX	MOUNT,SHOCK,SEAT	1	84	731-2872-XX	WELD, MOUNT, SEAT, LEVERAGE, ROW	1																											
	38	731-0577	ASSY,SHOCK,SEAT SLED,30LBS	1	85	731-2904	ASSY,PULL PIN,ADJ,RED	1																											
B	39	731-0582	SETSCREW, M8 X 1.25, 10mm, CUP	4	86	731-3452	O-RING, 19mm ID, 3.5mm GAUGE	4																											
	40	731-0629	ASSY,HANDLE,SEAT,ROW	1	87	731-4864	CAP,END,65MM,LARGE CB	2																											
	41	731-0633	ASSY,BRACKET,SEAT ADJ,ROW	1	88	731-5256	WELD,WEIGHT HORN,SINGLE	4																											
	42	731-0634	LINKAGE, SEAT ADJ, ROW	1	89	731-5259	BUMPER,STOP,WGT	6																											
	43	731-0635-00XX	ASSY, SEAT BOTTOM, ROW	1	90	731-5272	CAP,PLUG,WEIGHT HORN,BLANK	6																											
	44	731-0637	RING,BEAUTY,ADJ,PAD	1	91	731-5330	SCREW,M8x1.25,25,SHC,HK,AS,12.9,ZP,FT	4																											
A	45	731-0642-00XX	ASSY, CHEST PAD, ROW	1	92	731-5565	SCREW,M10x1.5,80,HHC,HE,AS,12.9,ZP,PT	4																											
	46	731-0643	PLUG, TUBE, 60MM X 40MM	1	93	731-5725	RIVET NUT, HEX HEAD,M8	7																											
	47	731-0644	BUMPER,CHEST PAD,ROW	1	94	731-5806	WASHER,M8,HAT	4																											

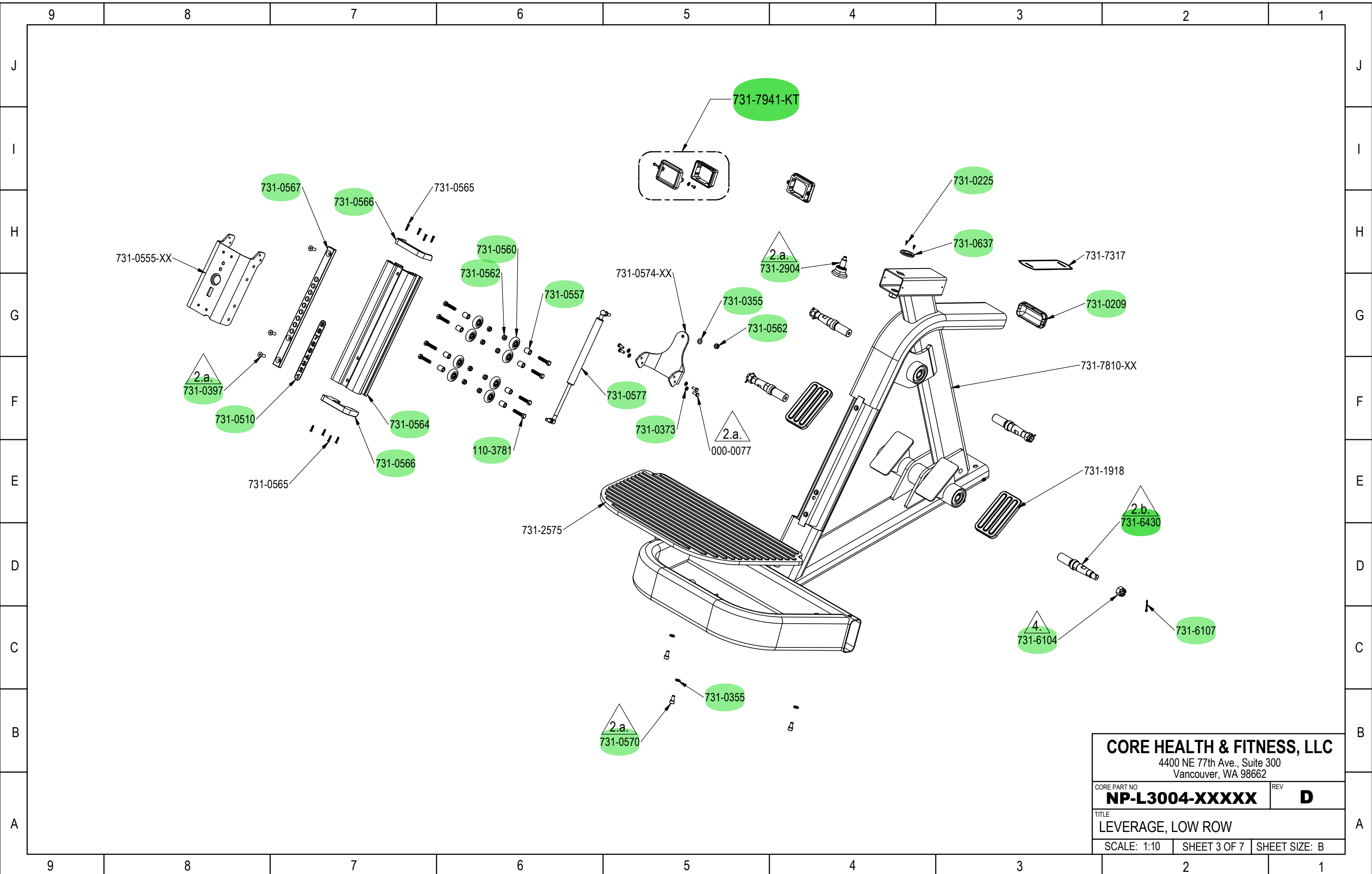


CORE HEALTH & FITNESS, LLC
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CORE PART NO. **NP-L3004-XXXXX** REV **D**

TITLE **LEVERAGE, LOW ROW**

SCALE: 1:25 SHEET 2 OF 7 SHEET SIZE: B

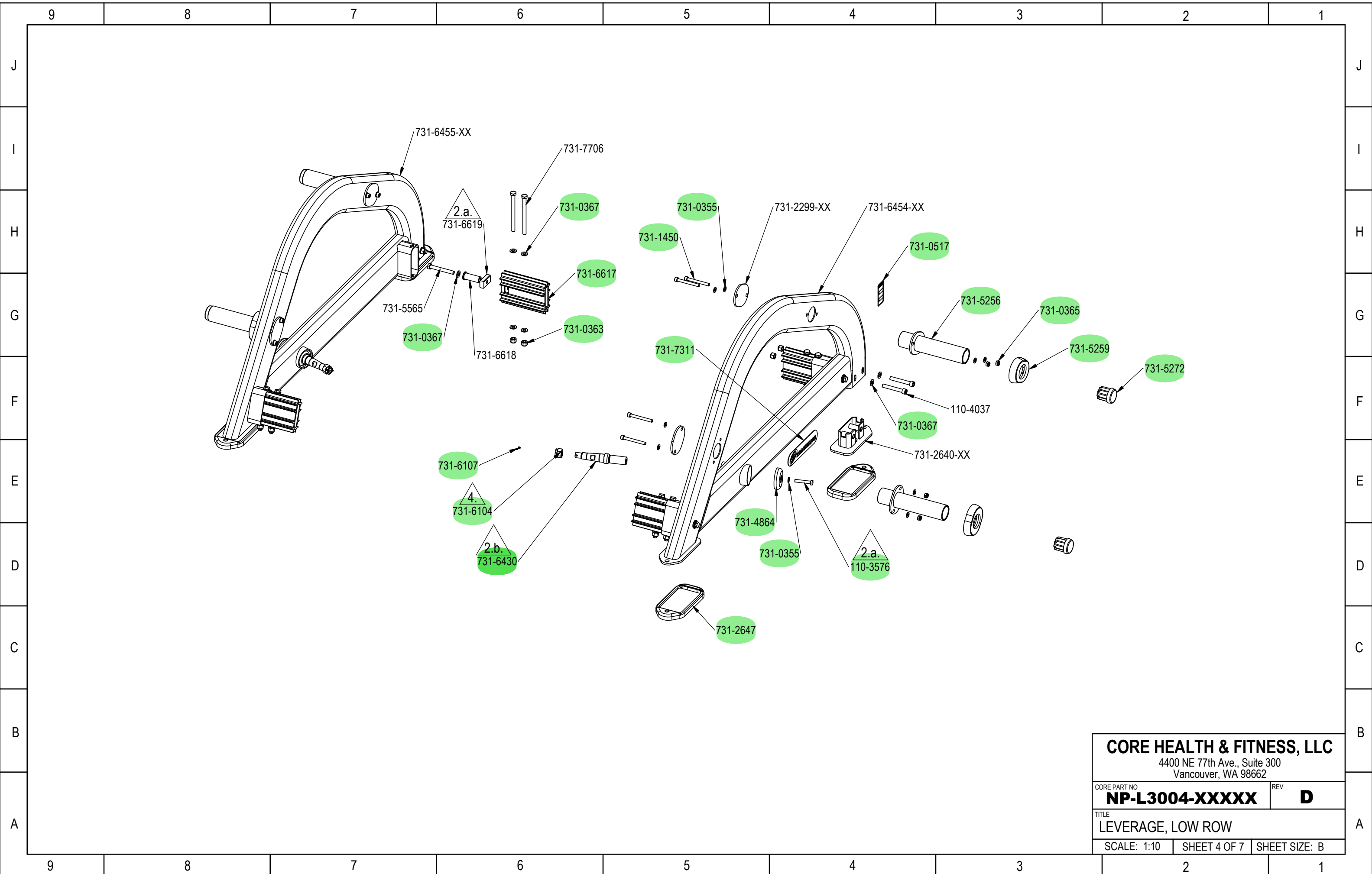


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CORE PART NO
NP-L3004-XXXXX REV **D**

TITLE
LEVERAGE, LOW ROW

SCALE: 1:10 SHEET 3 OF 7 SHEET SIZE: B

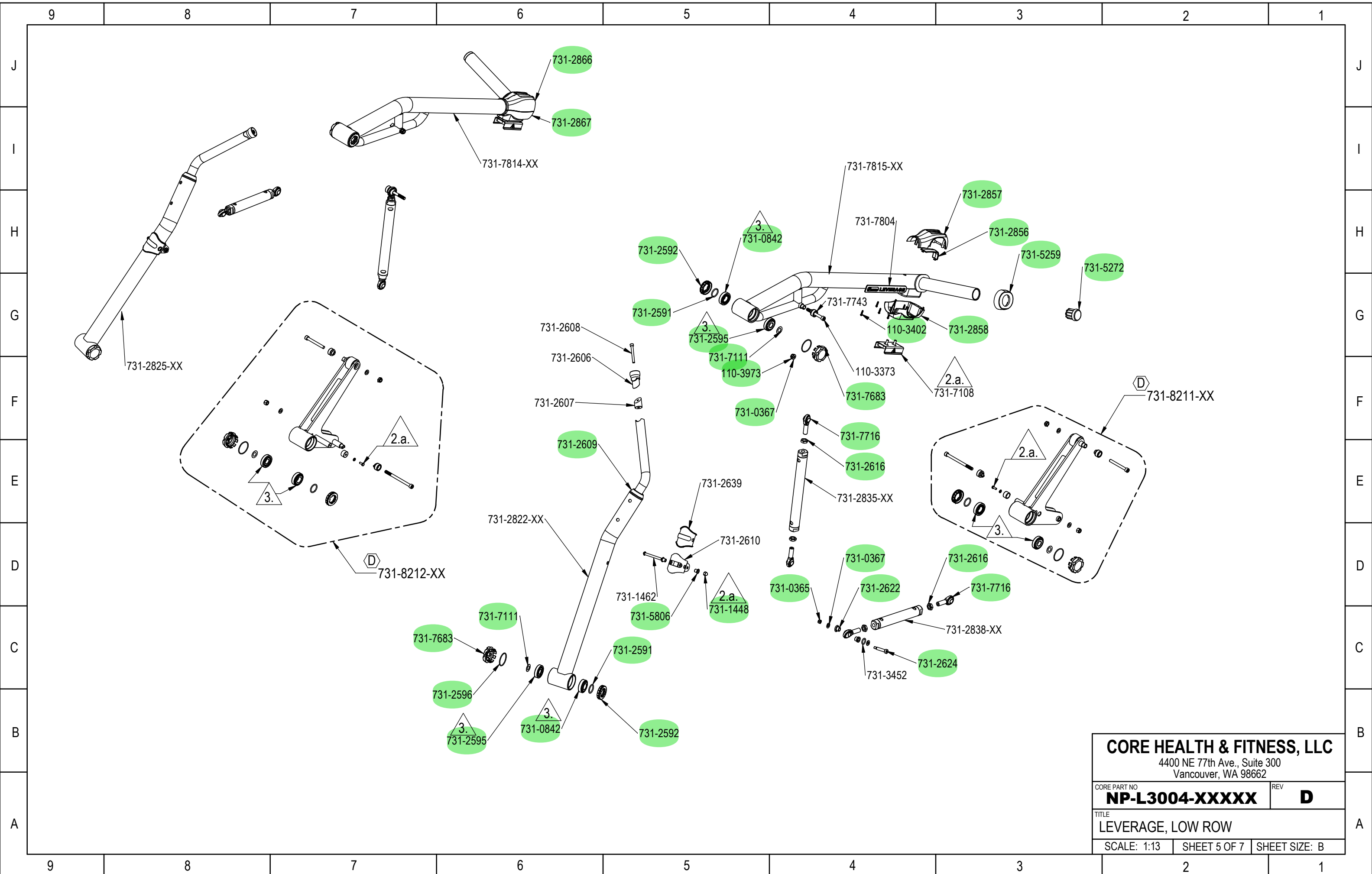


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CORE PART NO **NP-L3004-XXXXX** REV **D**

TITLE **LEVERAGE, LOW ROW**

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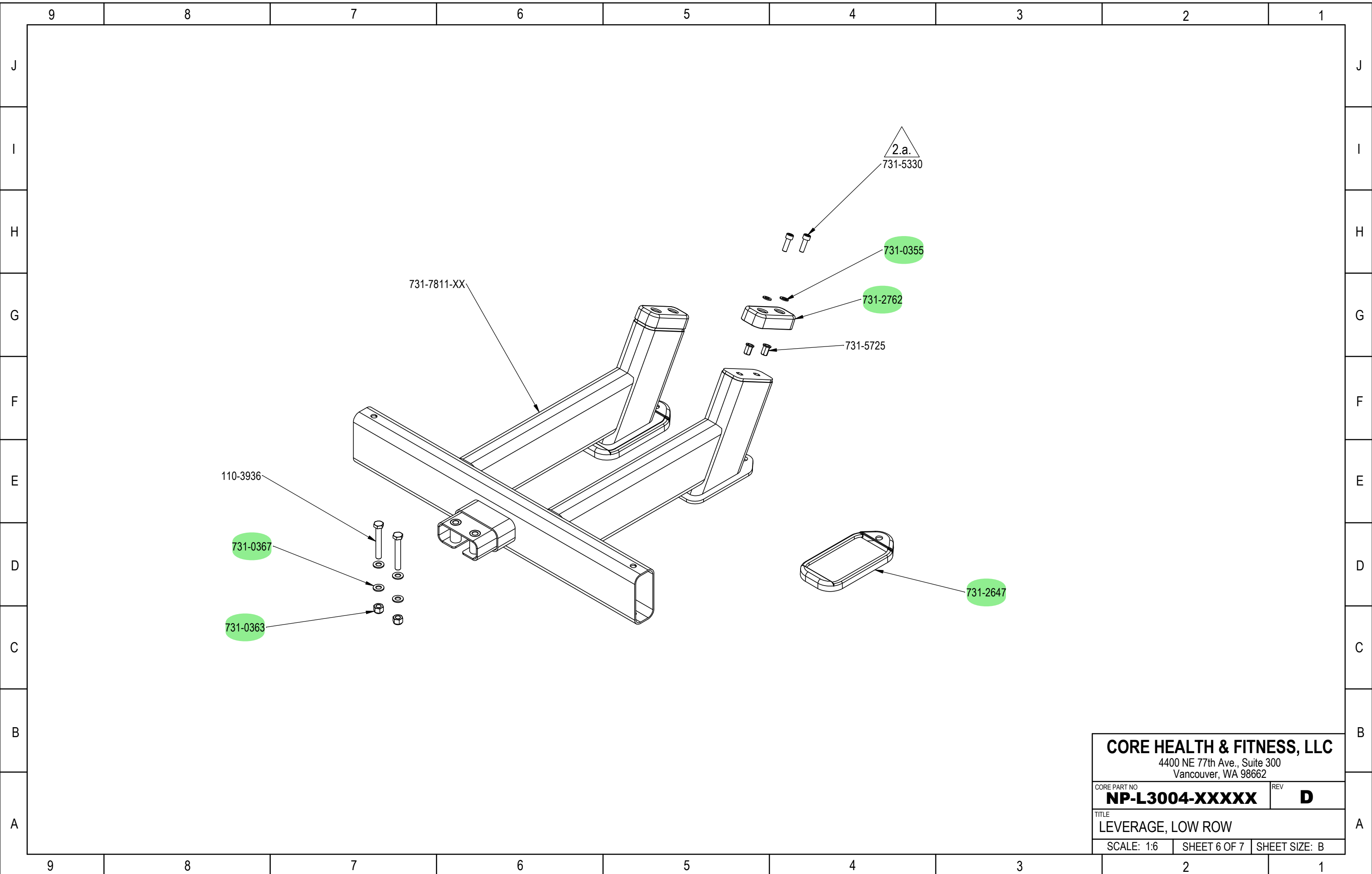


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CORE PART NO
NP-L3004-XXXXX REV **D**

TITLE
LEVERAGE, LOW ROW

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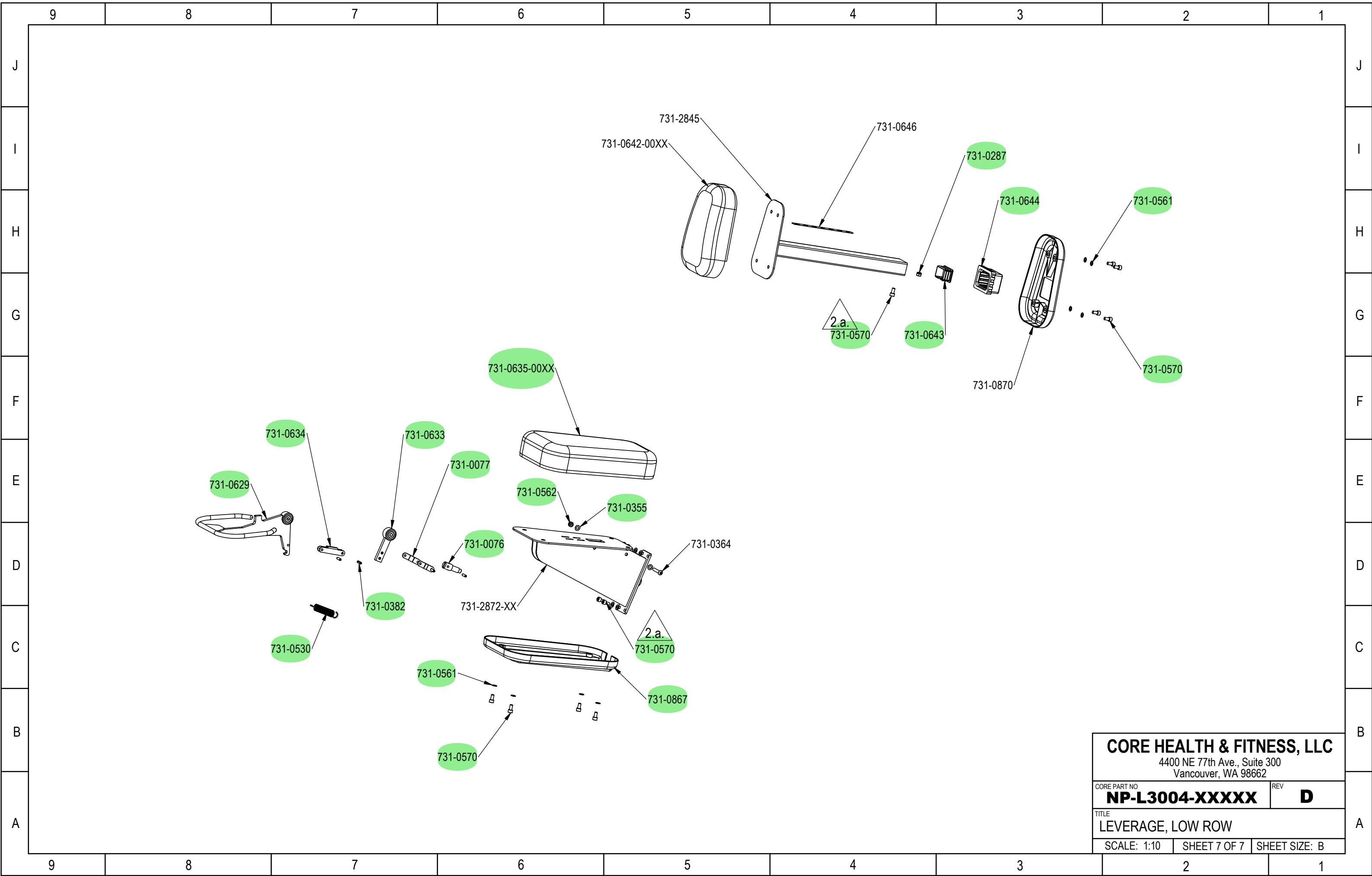


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CORE PART NO	NP-L3004-XXXX	REV	D
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TITLE	LEVERAGE, LOW ROW		
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SCALE: 1:6	SHEET 6 OF 7	SHEET SIZE: B
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CORE PART NO	REV
NP-L3004-XXXX	D

TITLE
LEVERAGE, LOW ROW

SCALE: 1:10	SHEET 7 OF 7	SHEET SIZE: B
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