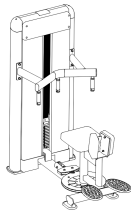


61A19 • Rotary Torso

INSTALLATION MANUAL



Before Installation

Before You Start

- 01 Read the instructions before assembly. Check that all parts are present and the quantities are correct. Report any missing or transit-damaged parts before installation.
- 02 Assemble the equipment correctly and follow all specified installation instructions.

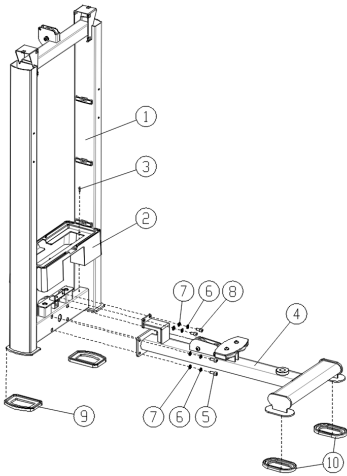
Tools Required

- Rubber Mallet
- Spirit Level
- Hex Keys
- Snap-Ring Pliers
- Adjustable Wrench
- 2 People

Assembly Notes

After assembly, understand all functions before use. Stop using the equipment immediately if a problem occurs to prevent injury or equipment damage. Resolve the problem before continuing and contact after-sales service if necessary.

Assembly



STEP 1, 2 & 3

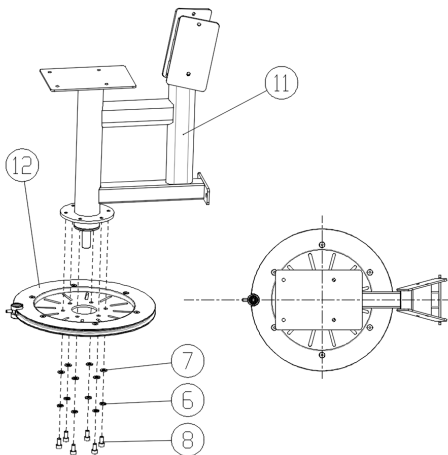
STEP 1
Attach the lower weight stack shroud (#2) to the weight stack frame (#1).

- HARDWARE**
- Socket Head Cap Screw (M5×16) (#3)

STEP 2
Attach the rotary torso base frame (#4) to the weight stack frame (#1).

- × 2
- HARDWARE**
- Socket Head Cap Screw (M10×25) (#5) × 4
 - Spring Washer (10) (#6) × 6
 - Flat Washer (10) (#7) × 6
 - Socket Head Cap Screw (M10×20) (#8) × 2

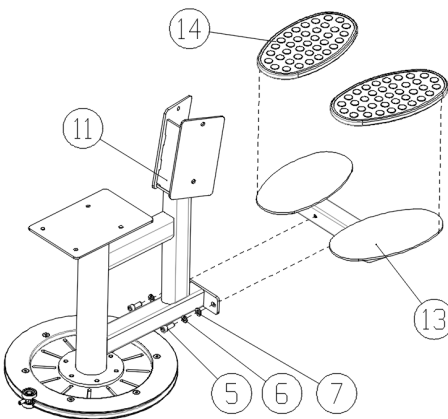
STEP 3
Install two weight stack frame foot pads (#9) on the weight stack frame (#1). Install two flat oval foot pads (#10) on the rotary torso base frame (#4).



STEP 4

ACTION
Attach the rotary torso main frame (#11) to the cable drum (#12). Position the main frame and cable drum relative to each other exactly as shown.

- HARDWARE**
- Socket Head Cap Screw (M10×20) (#8) × 6
 - Spring Washer (10) (#6) × 6
 - Flat Washer (10) (#7) × 6

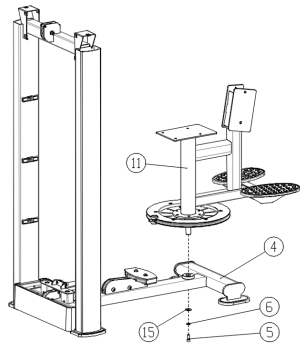


STEP 5 & 6

STEP 5
Install two oval step pads (#14) on the rotary torso footplate frame (#13).

STEP 6
Attach the rotary torso footplate frame (#13) to the rotary torso main frame (#11).

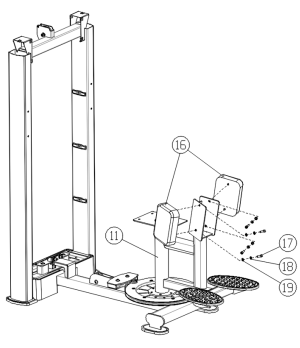
- HARDWARE**
- Socket Head Cap Screw (M10×25) (#5) × 2
 - Spring Washer (10) (#6) × 2
 - Flat Washer (10) (#7) × 2



STEP 7

ACTION
Attach the rotary torso main frame (#11) to the rotary torso base frame (#4).

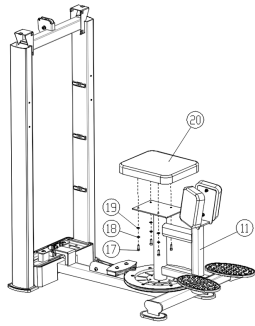
- HARDWARE**
- Socket Head Cap Screw (M10×25) (#5) × 1
 - Spring Washer (10) (#6) × 1
 - Large Washer (#15) × 1



STEP 8

ACTION
Attach two leg pads (#16) to the rotary torso main frame (#11).

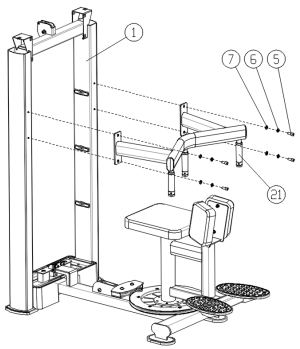
- HARDWARE**
- Socket Head Cap Screw (M8×25) (#17) × 4
 - Spring Washer (8) (#18) × 4
 - Flat Washer (8) (#19) × 4



STEP 9

ACTION
Attach the seat pad (#20) to the rotary torso main frame (#11).

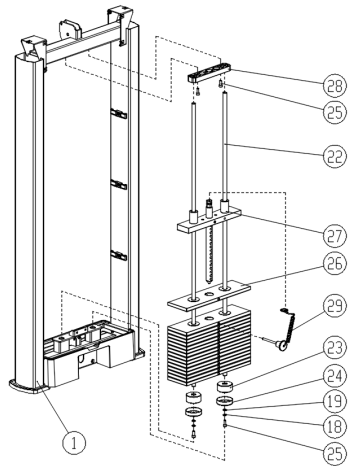
- HARDWARE**
- Socket Head Cap Screw (M8×25) (#17) × 4
 - Spring Washer (8) (#18) × 4
 - Flat Washer (8) (#19) × 4



STEP 10

ACTION
Attach the rotary torso handle frame (#21) to the weight stack frame (#1).

- HARDWARE**
- Socket Head Cap Screw (M10×25) (#5) × 4
 - Spring Washer (10) (#6) × 4
 - Flat Washer (10) (#7) × 4



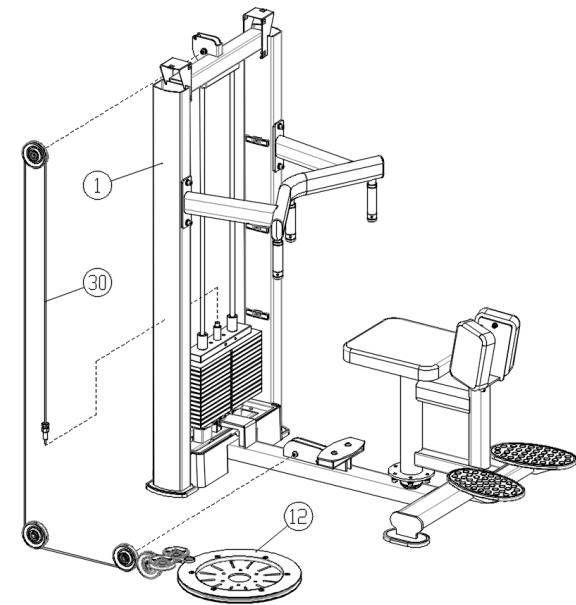
STEP 11 & 12

STEP 11
Slide two weight stack rubber cushions (#23) onto the two guide rods (#22). Attach two weight stack bases (#24) to the guide rods, then place them into the weight stack frame (#1). Fully tighten the bolts before continuing.

- HARDWARE**
- Socket Head Cap Screw (M8×20) (#25) × 2
 - Spring Washer (8) (#18) × 2
 - Flat Washer (8) (#19) × 2

STEP 12
Install 14 weight plates (#26) on the guide rods (#22) with the spacer side facing up. Install the guide block assembly (#27), insert the weight stack selector pin (#29) into the weight plates, and slide the guide rod fixing plate (#28) onto the guide rods. Attach the fixing plate (#28) to the weight stack frame (#1). Fully tighten the bolts before continuing.

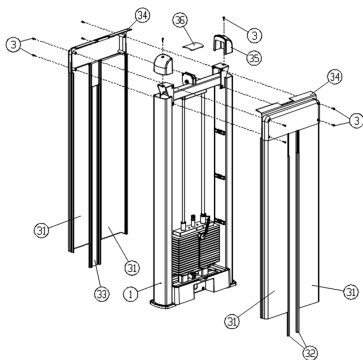
- HARDWARE**
- Socket Head Cap Screw (M8×20) (#25) × 2



STEP 13 & 14

STEP 13
Route the cable (#30) as shown. Remove the pre-installed pulleys before routing the cable, then reinstall them. Install the pulleys together with the cable.

STEP 14
Connect one end of the cable (#30) to the cable drum (#12), then connect the other end inside the weight stack frame (#1).



STEP 15, 16 & 17

STEP 15
Slide two decorative strips (#32) into two shroud panels (#31) and secure them to the weight stack frame (#1) with the shroud retaining plates. Slide the decorative panel (#33) into the shroud panels and secure it to the weight stack frame. Attach two upper weight stack shrouds (#34) to the weight stack frame.

- HARDWARE**
- Socket Head Cap Screw (M5×16) (#3) × 8

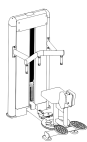
STEP 16
Attach two weight stack upright end caps (#35) to the weight stack frame (#1).

- HARDWARE**
- Socket Head Cap Screw (M5×16) (#3) × 2

STEP 17
Snap the upper shroud top cover (#36) onto the upper weight stack shrouds (#34).

FINAL CHECK

01 Important Note: After assembly, make sure the machine is level and vertical. Use a spirit level to check that the guide rods are vertical in both directions. If they are not vertical, loosen the necessary frame hardware, realign the frame, and retighten the bolts.



Parts List

Pre-assembled parts are not listed in this table.

NO.	PART / SPECIFICATION	QTY	NO.	PART / SPECIFICATION	QTY	NO.	PART / SPECIFICATION	QTY
1	Weight Stack Frame	1	13	Rotary Torso Footplate Frame	1	25	Socket Head Cap Screw (M8×20)	4
2	Lower Weight Stack Shroud	1	14	Oval Step Pad	2	26	Weight Plate	14
3	Socket Head Cap Screw (M5×16)	12	15	Large Washer	1	27	Guide Block Assembly	1
4	Rotary Torso Base Frame	1	16	Leg Pad	2	28	Guide Rod Fixing Plate	1
5	Socket Head Cap Screw (M10×25)	11	17	Socket Head Cap Screw (M8×25)	8	29	Weight Stack Selector Pin	1
6	Spring Washer (10)	19	18	Spring Washer (8)	10	30	Cable	1
7	Flat Washer (10)	18	19	Flat Washer (8)	10	31	Shroud Panel	4
8	Socket Head Cap Screw (M10×20)	8	20	Seat Pad	1	32	Weight Stack Decorative Strip	2
9	Weight Stack Frame Foot Pad	2	21	Rotary Torso Handle Frame	1	33	Weight Stack Decorative Panel	1
10	Flat Oval Foot Pad	2	22	Universal Weight Stack Guide Rod	2	34	Upper Weight Stack Shroud	2
11	Rotary Torso Main Frame	1	23	Weight Stack Rubber Cushion	2	35	Weight Stack Upright End Cap	2
12	Rotary Torso Cable Drum	1	24	Weight Stack Base	2	36	Upper Shroud Top Cover	1