

# PLS1500 FULL BODY PRESS COMPOSITE

 TRUE FITNESS



SCAN FOR UP-TO-DATE  
OWNER'S MANUAL



SCAN FOR  
ASSEMBLY VIDEO

MODEL PLS1500  
(MAN-PLS1500 REV02)

## OWNER'S MANUAL



## **IMPORTANT—PLEASE READ**

All products shown are prototype. Actual product delivered may vary. Product specifications, features, and software are subject to change without notice.

**For the most up-to-date version of this manual, please see our website: <https://truefitness.com/services-support/user-manuals/>**

## **CONTACTING OUR SUPPORT TEAM**

To contact TRUE for any of your pre or post installation questions, please call our toll-free numbers Monday - Friday 8:30am - 5:00pm (CST):

- Commercial Direct Customers and Corporate Accounts | 800.868.8783
- Retail Customers and Distributors | 800.883.8783

Or email us:

- Commercial Direct Customers and Corporate Accounts | [service.direct@truefitness.com](mailto:service.direct@truefitness.com)
- Retail Customers and Distributors | [service@truefitness.com](mailto:service@truefitness.com)
- Service International | [int.service@truefitness.com](mailto:int.service@truefitness.com)

When contacting TRUE, please have the following information ready:

- Serial Number of Unit
- Contact Information—Full Name, Email, and Phone Number
- Address of Facility or Residence
- Detailed Description Regarding Symptom of the Unit (along with pictures or video if applicable)

**NOTE:** Authorized service providers, dealers, and distributors may also use TRUE's online resource | [portal.truefitness.com](http://portal.truefitness.com).

## **CONTACTING OUR SALES TEAM**

Interested in owning more TRUE products? Please contact us with any product inquires so that we may direct you to the appropriate sales representative to help answer your questions.

- Phone | 800.426.6570
- Email | [sales@truefitness.com](mailto:sales@truefitness.com)
- Hours | Monday - Friday 8:30am - 5:00pm (CST)

## **REPORTING FREIGHT CLAIMS OR PARTS DAMAGE**

Unfortunately, sometimes materials can be damaged during shipment. If materials are damaged during shipment, please follow the guidelines below to determine the appropriate process for you to follow.

### **Severe Damage—Obvious damage to external packaging and internal product.**

Please refuse the shipment and it will be returned to TRUE by the carrier. Contact TRUE product support by calling 800.883.8783 or sales support by calling 800.426.6570 Monday-Friday during normal business hours to notify us that the shipment has been refused. Once we have received the damaged shipment, a replacement shipment will be sent to you. If the shipment comes in multiple boxes, only refuse boxes with damage.

### **Slight Damage—Minimal damage to external packaging with unknown internal damage to product.**

If the shipment has minimal damages and you are not sure if the actual product is damaged, you must sign the bill of lading as damaged when accepting the shipment. Once you have opened the box and you have determined something is indeed damaged, please gather the serial number, model number, description of damage, and photos of damage. Please make sure the photos include the damaged product as well as the damaged box the product arrived in. Contact TRUE product support ([service@truefitness.com](mailto:service@truefitness.com) | 800.883.8783) or TRUE sales support ([sales@truefitness.com](mailto:sales@truefitness.com) | 800.426.6570) Monday-Friday during normal business hours.

### **Concealed Damage—No damage to external packaging but internal damage to product.**

You may receive a shipment that looks intact and discover once the box has been opened that there are hidden damages. Please notify the carrier immediately. TRUE will not be able to file a claim if the carrier is not notified in a timely manner. Once you have called the carrier you will need to gather the serial number, model number, description of damage, and photos of damage. Contact TRUE product support ([service@truefitness.com](mailto:service@truefitness.com) | 800.883.8783) or TRUE sales support ([sales@truefitness.com](mailto:sales@truefitness.com) | 800.426.6570) Monday-Friday during normal business hours.



## TABLE OF CONTENTS

### SAFETY INSTRUCTIONS

IMPORTANT SAFETY INSTRUCTIONS—SAVE THESE INSTRUCTIONS.....	5
GENERAL CARE AND MAINTENANCE.....	7
COMMERCIAL MAINTENANCE SCHEDULE.....	8
COMPLIANCES.....	8
DIMENSIONS AND WEIGHTS.....	9
LABEL LOCATIONS.....	10
WARNING AND INTENDED USE LABELS.....	10

### ASSEMBLY INSTRUCTIONS

PREASSEMBLY CHECKLIST.....	12
ASSEMBLY STEPS.....	16

### PREVENTATIVE MAINTENANCE

DAILY INSPECTION AND MAINTENANCE.....	30
WEEKLY INSPECTION AND MAINTENANCE.....	30
OTHER SCHEDULED PREVENTATIVE MAINTENANCE.....	30
CLEANING THE EQUIPMENT.....	31

### WARRANTY INFORMATION

COMMERCIAL WARRANTY.....	32
WARRANTY DETAILS.....	33
WARRANTY REGISTRATION .....	34

## SAFETY INSTRUCTIONS

### IMPORTANT SAFETY INSTRUCTIONS—SAVE THESE INSTRUCTIONS

#### FACILITY AND USER SAFETY PRECAUTIONS

- Review and understand all of the warning labels affixed to this machine and on the facility safety sign.
- Be certain that the machine operation is understood before it is used. Refer to the instructional procedure label affixed to the machine.
- Make sure all users are properly trained on how to use this equipment. If this machine is being used in a commercial setting, end users may not have access to this owners manual. It is the responsibility of the facility to instruct users as to the proper usage of the equipment as well as making them aware of potential hazards. Maximum user weight is 400 lbs / 182 kg.
- Use each machine only for the intended exercise. Do not allow anyone to invent exercises not included on the instructional procedure label or the intended use label.
- Do not modify the machine.
- This equipment meets industry safety standards for stability when used for the intended exercise. Do not allow straps, resistance bands or other means to be attached to the framework of this machine to perform stretching or body weight exercises. This can result in machine instability and lead to serious crushing injuries.
- Keep children away from this equipment. Adults should closely supervise use by teenagers.
- It is recommended that users receive a thorough medical exam before commencing an exercise program. All medical issues should be reviewed to ensure that weight training will not aggravate pre-existing medical conditions.
- If the machine appears damaged or inoperable, contact a facility staff member to place an “OUT OF ORDER, DO NOT USE” sign on the machine until it is repaired. Only use TRUE supplied replacement components to service this machine.
- Instruct users not to wear loose or dangling clothes or have headphone wires hanging when using this equipment.
- Do not attempt to free any jammed assemblies by yourself as this may cause injury.
- On Plate Loaded and Free Weight machines:
  - Use of spotter(s). Instruct users to seek the advice of the facility staff as to the appropriate use of spotters when lifting. More than one spotter may be required depending upon the amount of weight being lifted.
  - Instruct users to load weight plates evenly and carefully to avoid tipping equipment and crushing injuries.
  - If the machine is equipped with safety stops or catches, inspect them and verify their proper operation before use and make sure they are securely in place before using or exiting the machine. Be certain members are instructed on how to operate and adjust all safety mechanisms.
  - This equipment is designed for standard olympic size weight plates with a 50mm bore (1.9”).
  - Do not exceed the maximum weight capacity of the machine. Maximum plate size is 45 lbs (25 kg).
- On Selectorized and cable equipped machines:
  - Do not allow users to perform any exercise by holding the end of the cable and/or the cable end fitting. Use only appropriate handles or attachments properly connected to the cable end.
  - Do not high-pin or double-pin the weight stack. Do not allow the machine to be used if the top plate or weight stack is pinned in a raised position. Use an assistant and carefully return the machine to the proper position with the cap plate resting on the top weight. Inspect the entire length of the cable to ensure that it is properly seated in all of the pulley grooves.
  - Do not allow the use of weight plates or dumbbells to be used as a means to add additional weight to the weight stacks. Use only the TRUE adder weight system specifically designed for the machine.

## INSTALLATION SAFETY PRECAUTIONS

- Read this installation manual entirely before assembling this equipment.
- Verify that there is adequate space surrounding this piece of equipment for safe access and operation. Installation must meet ADA requirements for accessibility.
- Install this piece of equipment on a solid level surface that does not deviate more than 1/8" over a 10' distance (or as defined and required by local building and architectural codes.)
- TRUE strongly recommends that all equipment be anchored to the floor to prevent movement and increase stability.
  - Due to the wide variation of flooring on which the unit can be installed, contact a qualified contractor to determine an appropriate fastening system for your floor.
  - Use 3/8" diameter hardware (10 mm) to anchor the machine. Anchors should have a minimum pull out force of 220 lb (110 kg) for each position.
  - When attaching the machine to the floor, if there is a gap between the machine foot and the floor, do not use the anchor to remove the gap as this can cause the machine frame to deform. Instead, place a shim between the bottom of the foot and the floor, then tighten the anchor.
  - Anchoring holes are provided on the feet of the frame. All anchoring locations must be used when anchoring the equipment to the floor.
- **DO NOT** install any fitness equipment near a pool, hot tub or other damp locations. Corrosion caused by installation in these locations can lead to premature failure of components.
- **Be sure all hardware is tight before using this machine.**
- **Some assembly materials may come preassembled in the carton. Refer to the Assembly Instructions for more information on disassembling any assembly materials before beginning assembly.**

## MAINTENANCE SAFETY PRECAUTIONS

- Refer to the maintenance schedule table in this manual for when to perform maintenance.
- Check the function of your machine DAILY by verifying the following:
  - If equipped with cables, inspect cables and end fittings for any signs of wear. Replace if worn, frayed, or damaged with TRUE replacement components.
  - Verify that all adjustments are possible and carried out with ease. Make sure that each adjustment pin inserts completely into each position without binding.
  - Verify that safety catches and stops are in proper working order and engaged.
  - Verify that the exercise is performed smoothly, free of noise, and/or binding.
  - If equipped with a weight stack, verify that the proper weight selector pin is in place.
- Check the function of your machine WEEKLY by verifying the following:
  - Nuts, Bolts, and Fasteners: check tightness weekly. If any hardware has become loose, retighten it, use Loctite® Threadlocker 242, or both.
  - Frames and Lifting Arms: Inspect weekly for integrity and function. Replace any component at first signs of wear. Use only TRUE supplied components.
- Replace any warning label at the first sign of wear. Labels and the facility safety sign may be obtained from TRUE.

## GENERAL CARE AND MAINTENANCE

### IMPORTANT

Preventative maintenance is crucial to maintaining the function and safety of this equipment. Your facility must establish written guidelines for preventative maintenance and keep written or online records of the maintenance performed on these products. As a minimum, the items presented in the SAFETY section of this document and the items that follow here, should be included in your maintenance program.

- Cables (if equipped)—inspect end fittings daily for wear. Inspect the entire length of the cable weekly. Replace cables at the first sign of wear and on an annual basis. If the cable tension has been adjusted, be certain that the cable nut is tight.
- Nuts, bolts, and fasteners—check tightness weekly. If any hardware has become loose, retighten and/or use Loctite® brand Threadlocker 242. Be sure all hardware is tight before using the machine.
- Safety catches—inspect catches, stop rods and their associated fasteners. Tighten any loose hardware and replace any components at first signs of wear.
- Frames—sweat, disinfecting sprays and spills can lead to corrosion which may lead to premature failure of components. Wipe all machines down with a damp cloth and dry completely each day. This includes painted parts, chrome parts and upholstered pads.
- Painted and chrome plated parts—use Simple Green with a dilution of 32:1 or similar cleaner for light dirt and grime. Use Turtle Wax Polishing Compound or a good car polish to remove heavier dirt and grease as well as for polishing. **DO NOT** use solvents, lacquer thinner, acetone or finger nail polish remover. For scuffs and marks that are not removed by the above methods use a soft scrub cleanser. Make sure all parts are dry upon completion.
- Weight stack enclosures (shrouds)(if equipped)—wipe down with a damp cloth as needed.
- Exercise instruction labels—clean with soap and water as needed.
- Guide rods (if equipped)—wipe all dirt and dust from the guide rods before applying a light application of Tri-Flow™ or other teflon spray lubricant. Spray the Tri-Flow™ on a rag and then wipe the guide rods with the rag. **DO NOT** use oil lubricants such as WD-40.

 **CAUTION:** Tri-Flow™ will stain carpet and clothing.

- Bronze bushings—check monthly for signs of wear and replace as needed.
- Linear bearing shafts—wipe any accumulation of dust or other contaminants from the shafts on a weekly basis. Apply a thin layer of a Teflon® (PTFE) grease on a weekly basis. TRUE recommends Magnalube® brand.
- When replacing any component, use only TRUE supplied parts.
- Be sure all hardware is tight before using the machine.

Retain these instructions for future reference. If you have any questions, do not hesitate to contact your TRUE dealer or TRUE product support (service@truefitness.com | 800.883.8783).



## COMMERCIAL MAINTENANCE SCHEDULE

Commercial Maintenance Schedule					
	Daily	Weekly	Monthly	6 Months	Annually
Inspect cables for wear, tension, and proper connection if equipped. Replace at the first sign of wear.	X				
Inspect cable length and cable end fittings. Replace at the first sign of wear.		X			
Inspect all nuts and bolts and tighten if needed.		X			
Inspect safety catches, stop rods, and their fasteners. Replace at the first sign of wear.	X				
Inspect all anti-slip surfaces and replace as needed.		X			
Inspect all adjustment pins, weight stack pins, set screws, gas shocks, snap links, and pulleys if equipped.	X				
Inspect all accessory bars and handles.		X			
Inspect all safety and instructional decals.	X				
Inspect all weight stack shields if equipped.	X				
Clean guide rods and lubricate with a teflon lubricant if equipped.		X			
Clean and condition upholstery.	X				
Clean and polish frame.	X				
Clean and polish chrome.	X				
Lubricate pivot bearings and linear bearings.				X	
Replace cables if equipped.					X

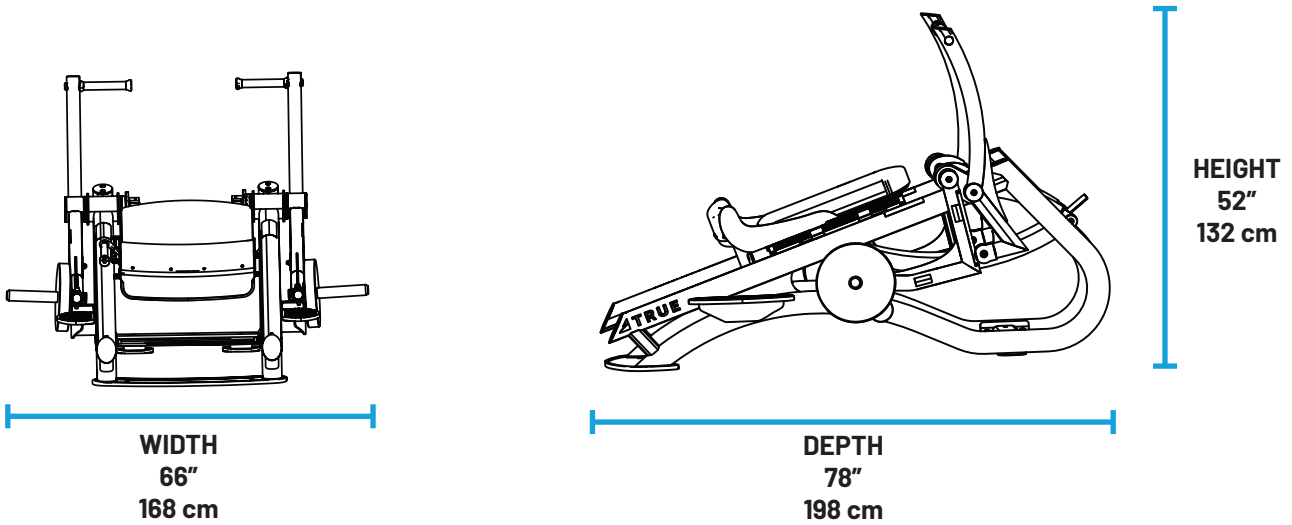
## COMPLIANCES

This equipment complies with all applicable codes and regulations. For a complete list of compliances, please visit [www.truefitness.com](http://www.truefitness.com).



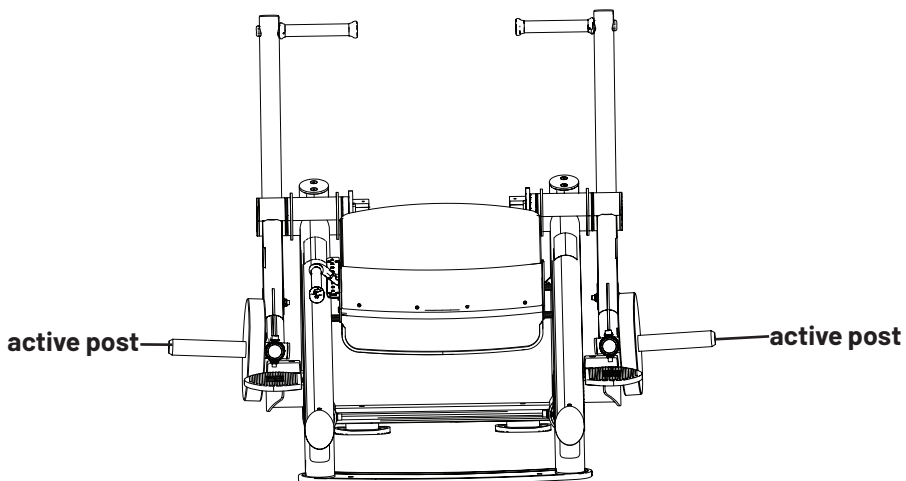
## DIMENSIONS AND WEIGHTS

- ASSEMBLED DIMENSIONS (W X D X H)**  
 66" x 78" x 52" / 168 cm x 198 cm x 132 cm



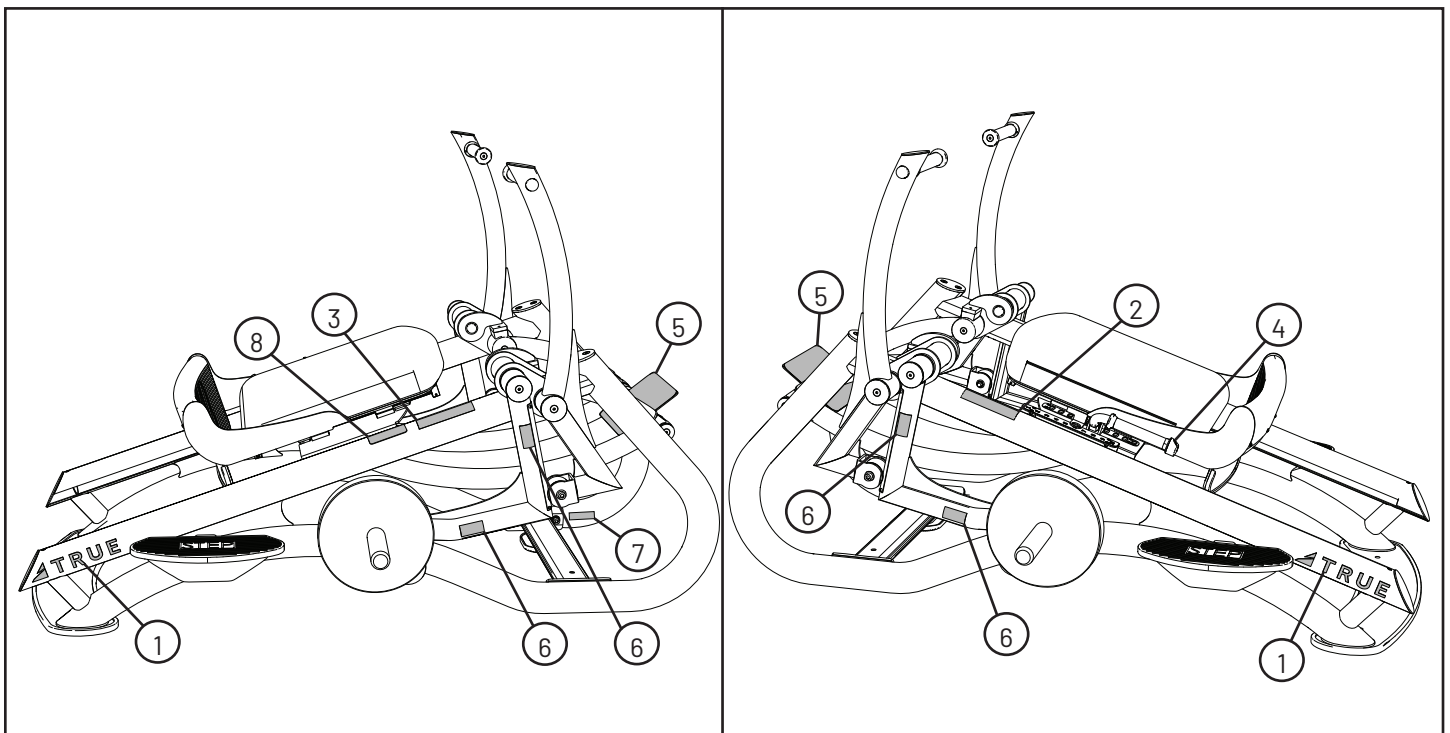
- PRODUCT WEIGHT**  
 616 lbs / 280 kg
- MAXIMUM USER WEIGHT**  
 400 lbs / 182 kg
- MAXIMUM LOAD (USER WEIGHT + WEIGHT PLATES)**  
 760 lbs / 345 kg

POST CAPACITY					
Number of Active Posts	Max 45LB. Plates Per Active Post	Total Weight Plates Allowed	Number of Storage Posts	Max 45LB. Plates Per Storage Post	Total Weight Plates Allowed
2	4	8	0	4	8



## LABEL LOCATIONS

Item	Part#	Description	Qty
1	LBL-LOG-010BK	LABEL, TRUE LOGO WHITE 10 IN	2
2	LBL-ADJ-PLS1500	FULL BODY PRESS ADJUSTMENT GUIDE STICKER	1
3	LBL-WRN-0022	GENERAL WARNING LABEL	1
4	LBL-ARW-SC00	CARRIAGE HANDLE DIRECTIONAL ARROW	1
5	LBL-PRO-PLS1500	PLS1500 PLACARD	1
6	SD0301	PINCH POINT STICKER	1
7	SPL-00-LBLSN	LABEL, SERIAL NUMBER	1
8	LBL-MTN-PLS001	LABEL, MAINTENANCE	1

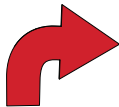

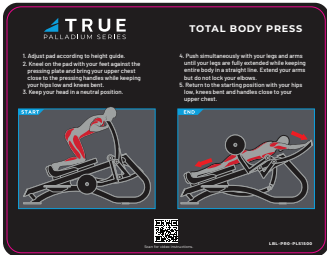

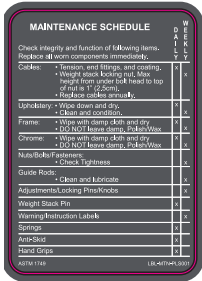




## WARNING AND INTENDED USE LABELS

**⚠ WARNING:** Replace all labels that may be worn, damaged, or missing.

To replace any worn or missing decals contact TRUE product support ([service@truefitness.com](mailto:service@truefitness.com) | 800.883.8783).

Part# and Description	Image																																	
LBL-ADJ-PLS1500 (Adjustment Guide)	<table border="1"> <thead> <tr> <th>HEIGHT</th> <th>METRIC</th> <th>LEVEL</th> </tr> </thead> <tbody> <tr> <td>5'2"</td> <td>155 cm</td> <td>1-2</td> </tr> <tr> <td>5'3"</td> <td>160 cm</td> <td>2-4</td> </tr> <tr> <td>5'5"</td> <td>165 cm</td> <td>3-5</td> </tr> <tr> <td>5'7"</td> <td>170 cm</td> <td>4-6</td> </tr> <tr> <td>5'9"</td> <td>175 cm</td> <td>5-7</td> </tr> <tr> <td>5'11"</td> <td>180 cm</td> <td>6-8</td> </tr> <tr> <td>6'0"</td> <td>185 cm</td> <td>7-9</td> </tr> <tr> <td>6'2"</td> <td>190 cm</td> <td>8-10</td> </tr> <tr> <td>6'3"</td> <td>195 cm</td> <td>9-10</td> </tr> <tr> <td>6'7"</td> <td>200 cm</td> <td>10</td> </tr> </tbody> </table>	HEIGHT	METRIC	LEVEL	5'2"	155 cm	1-2	5'3"	160 cm	2-4	5'5"	165 cm	3-5	5'7"	170 cm	4-6	5'9"	175 cm	5-7	5'11"	180 cm	6-8	6'0"	185 cm	7-9	6'2"	190 cm	8-10	6'3"	195 cm	9-10	6'7"	200 cm	10
HEIGHT	METRIC	LEVEL																																
5'2"	155 cm	1-2																																
5'3"	160 cm	2-4																																
5'5"	165 cm	3-5																																
5'7"	170 cm	4-6																																
5'9"	175 cm	5-7																																
5'11"	180 cm	6-8																																
6'0"	185 cm	7-9																																
6'2"	190 cm	8-10																																
6'3"	195 cm	9-10																																
6'7"	200 cm	10																																

Part# and Description	Image
LBL-ARW-SC00 (Directional Arrow)	
SD0301 (Pinch Point)	
LBL-PRO-PLS1500 (Placard)	
LBL-WRN-0022 (General Warning)	
LBL-MTN-PLS001 (Maintenance)	
SPL-00-LBLSN (Serial Number)	
LBL-LOG-010BK (Logo)	

## ASSEMBLY INSTRUCTIONS



**NOTE:** Supplemental video available on YouTube: <https://www.youtube.com/@TRUEFitnessservicevids>

### PREASSEMBLY CHECKLIST

#### ⚠ CAUTION:



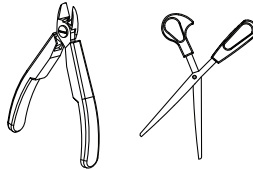
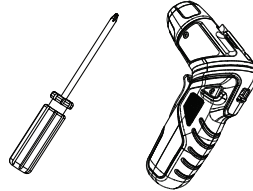
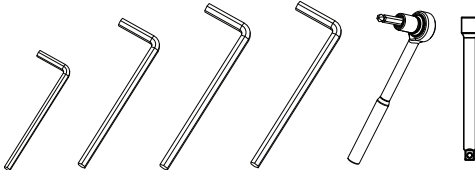
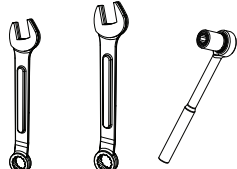
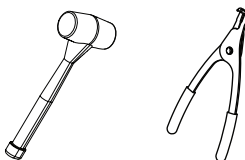
Use caution when assembling this product. Unpacking and assembling this product requires two or more people.

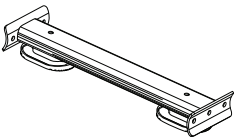
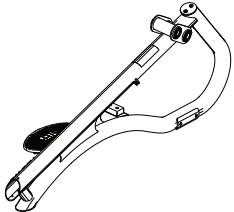
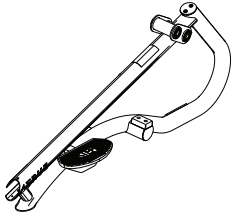
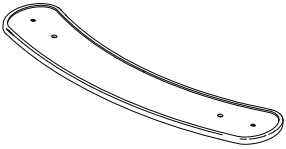
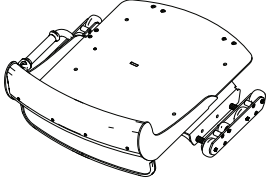


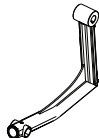


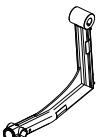
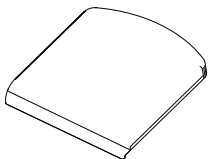
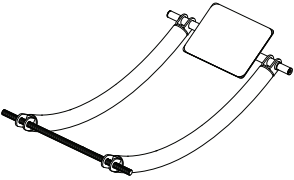

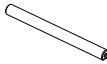




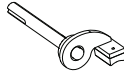



Use caution when unpacking this product. Avoid damage to the product and product pads. **DO NOT** use a box cutter. **DO NOT** slice into the packaging.

### VERIFY BOX CONTENTS

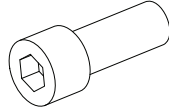
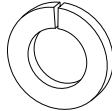
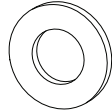
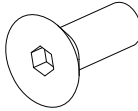
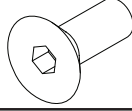
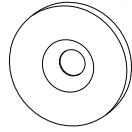
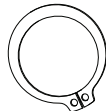
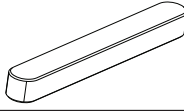
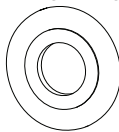
**IMPORTANT!** Please verify all box contents. If you have questions, or if there are any missing parts, contact product support ([service@truefitness.com](mailto:service@truefitness.com) | 800.883.8783).

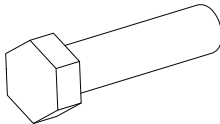
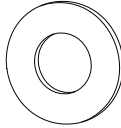
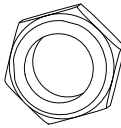
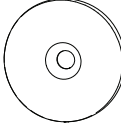
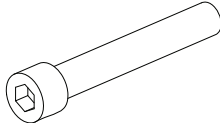
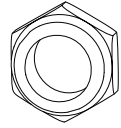
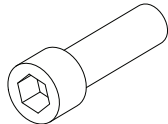
TOOLS NEEDED FOR ASSEMBLY	
Wire Cutters or Scissors (used in unboxing the machine)	
#2 Phillips Screwdriver or Electric Screwdriver (both are optional in unboxing the machine)	
1/8", 7/32", 5/16", and 3/8" Allen Wrenches (supplied) (or ratcheting socket wrench with hex bits)	
9/16" and 3/4" Wrenches and 9/16" Socket Wrench	
Rubber Mallet and External Retaining Ring Pliers	

BOX CONTENTS		
Item	Image	Qty
Front Main Frame		1
Left Main Frame		1
Right Main Frame		1
Foot Plate		1
Carriage Assembly		1
Left Press Bar		1
Right Press Bar		1
Left Weight Arm		1


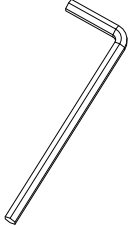
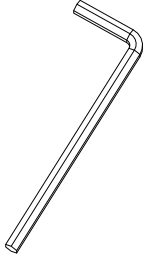
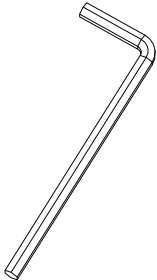
BOX CONTENTS		
Item	Image	Qty
Right Weight Arm		1
Knee Pad		1
Linkage Frame		1
Linkage Arms		2
Press Arm Axles		2
Axle Sleeves		2
Flange Bearings		2
Counter Weights		2
Weight Horns		2
Left Axle Assembly		1
Right Axle Assembly		1
Hardware pack		1
Manual		1

### HARDWARE PACK CONTENTS

PLS1500 HARDWARE PACK		
ITEM	DESCRIPTION	QTY
C 641	SHCS, 1/2"-13 X 1-1/4", ZP 	4
C 750	LOCK WASHER 13.5ID*21.3OD*2.5THK 	4
C 755B	WASHER, FLAT, 1/2" SAE Z.P. 	8
C 658	FHCS, 3/8"-16 X 1" 	12
C1017	FHSCS 10-24 X 1/2 	4
SC10053800	SHAFT END CAP, 48 X 6 	4
C1018	EXTERNAL RETAINING RING 23.2 X 1.2 THK 	2
C1014	FLAT KEY 10 x 8 x 80 	6
COMP- SC10056000	WASHER 70.2 X 30.2 X 5 	8

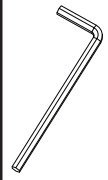
PLS1500 HARDWARE PACK		
ITEM	DESCRIPTION	QTY
C 447	HHS, 3/8"-16 X 1-1/2", GR5, ZP 	4
C 754C	WASHER, FLAT, 3/8", ZP 	12
C 766A	LOCK NUT, 3/8"-16 X 17/64", NYL 	4
SC10056500	SHAFT END CAP 70.2 X 6 	4
C1015	SHCS 1/2-13 X 3 	2
W0220	NYLOCK NUT 1/2-13 X 5/16 	2
C 624	SHCS, 3/8"-16 X 1-1/4", ZP 	4

### HARDWARE PACK CONTENTS

PLS1500 HARDWARE PACK		
ITEM	DESCRIPTION	QTY
C1022	ALLEN WRENCH S 1/8 	1
C1020	ALLEN WRENCH S 7/32 	1
C1019	ALLEN WRENCH S 5/16 	1
C1033	ALLEN WRENCH S 3/8 	1

## ASSEMBLY STEPS

### STEP 1—ASSEMBLE MAIN FRAME

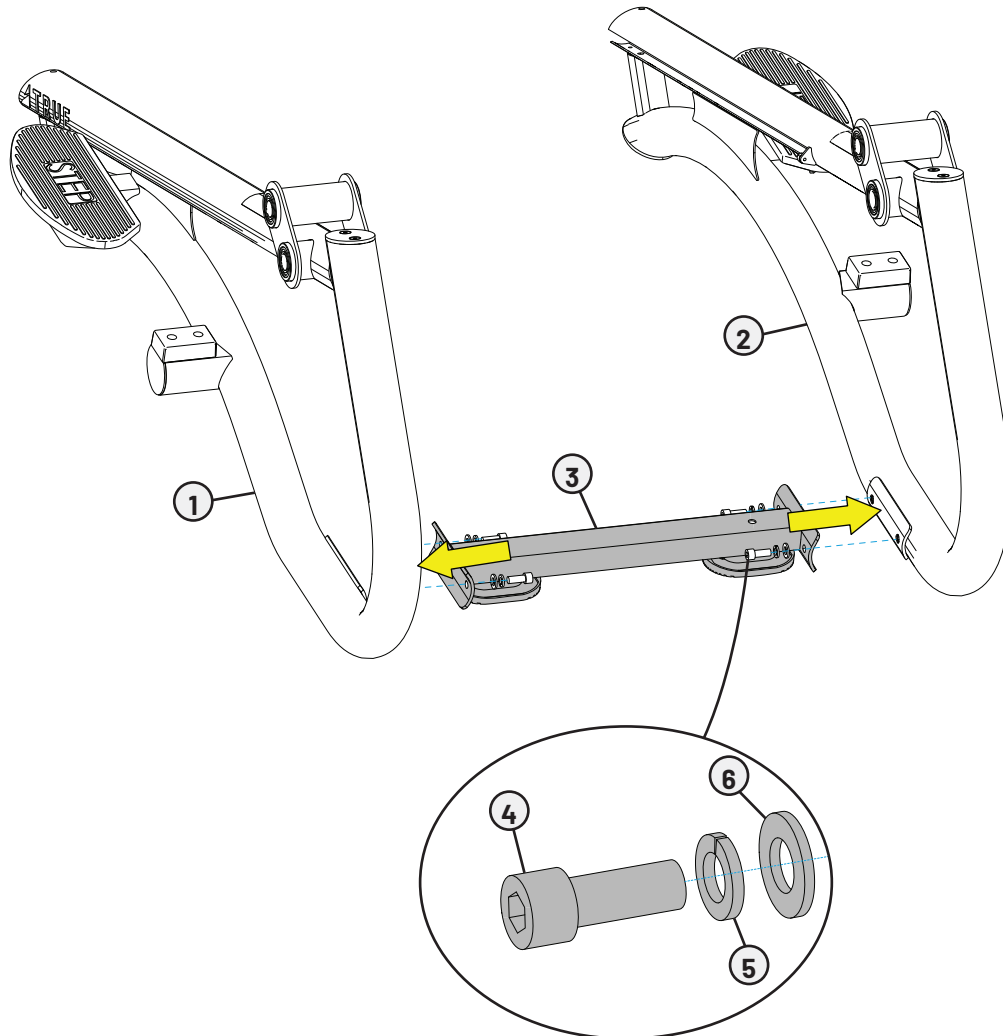
Tools Used in this Step	
3/8" Allen Wrench	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC10000100X-35	LEFT MAIN FRAME	1
2	SC00MF100X-35	RIGHT MAIN FRAME	1
3	SC00MF400X-35	FRONT MAIN FRAME	1
4	C 641	SHCS, 1/2"-13 X 1-1/4", ZP	4
5	C 750	LOCK WASHER 13.5ID*21.30D*2.5THK	4
6	C 755B	WASHER, FLAT, 1/2" SAE Z.P.	4

Using a 3/8" allen wrench, attach the front main frame to the left and right main frames using 4 socket head cap screws, 4 lock washers, and 4 flat washers.


**IMPORTANT! DO NOT fully tighten main frame hardware until step 10.**

**NOTE: All parts are labeled left and right according to the user's point-of-view when mounted on the machine. Failure to assemble parts using the correct orientation may compromise machine functionality.**





## STEP 2—ATTACH FOOT PLATE ASSEMBLY TO THE FRAME

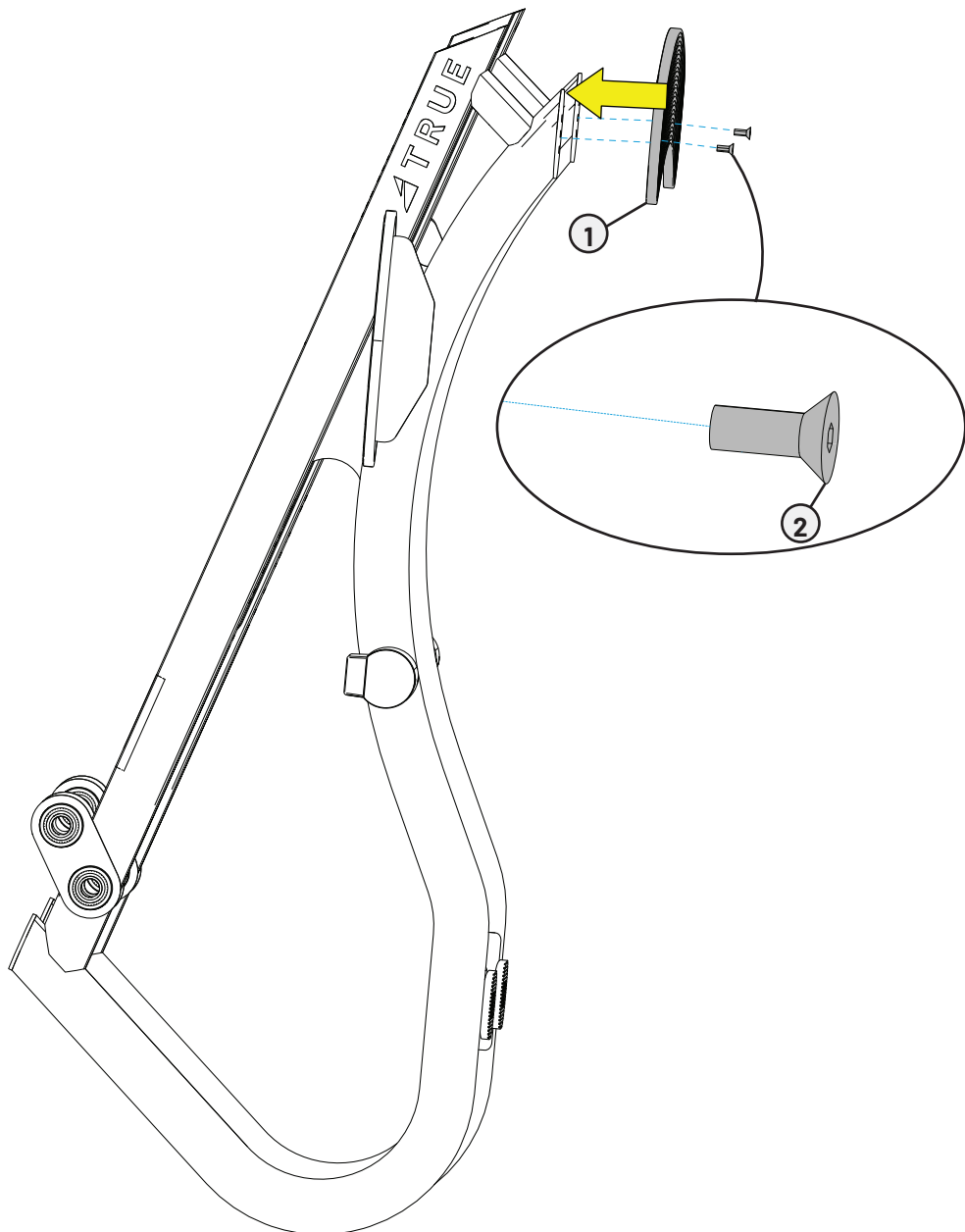
Tools Used in this Step	
7/32" Allen Wrench	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	COMP-SC00MF300X	FOOT PLATE	1
2	C 658	FHCS, 3/8"-16 X 1"	2


- A. Rotate the main frame backwards with the rear in the air.

**NOTE:** At least one person should hold the main frame, while another installs the foot plate assembly.

- B. Using a 7/32" allen wrench, attach the foot plate to the left and right main frame using 2 hex screws. Fully tighten the hardware.



### STEP 3—ATTACH CARRIAGE ASSEMBLY TO THE MAIN FRAME

Tools Used in this Step	
1/8" Allen Wrench	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC00MF200X-35	CARRIAGE ASSEMBLY	1
2	SC00CP000	FRAME END CAP LOWER	2
3	C1017	FHSCS 10-24 X 1/2	4

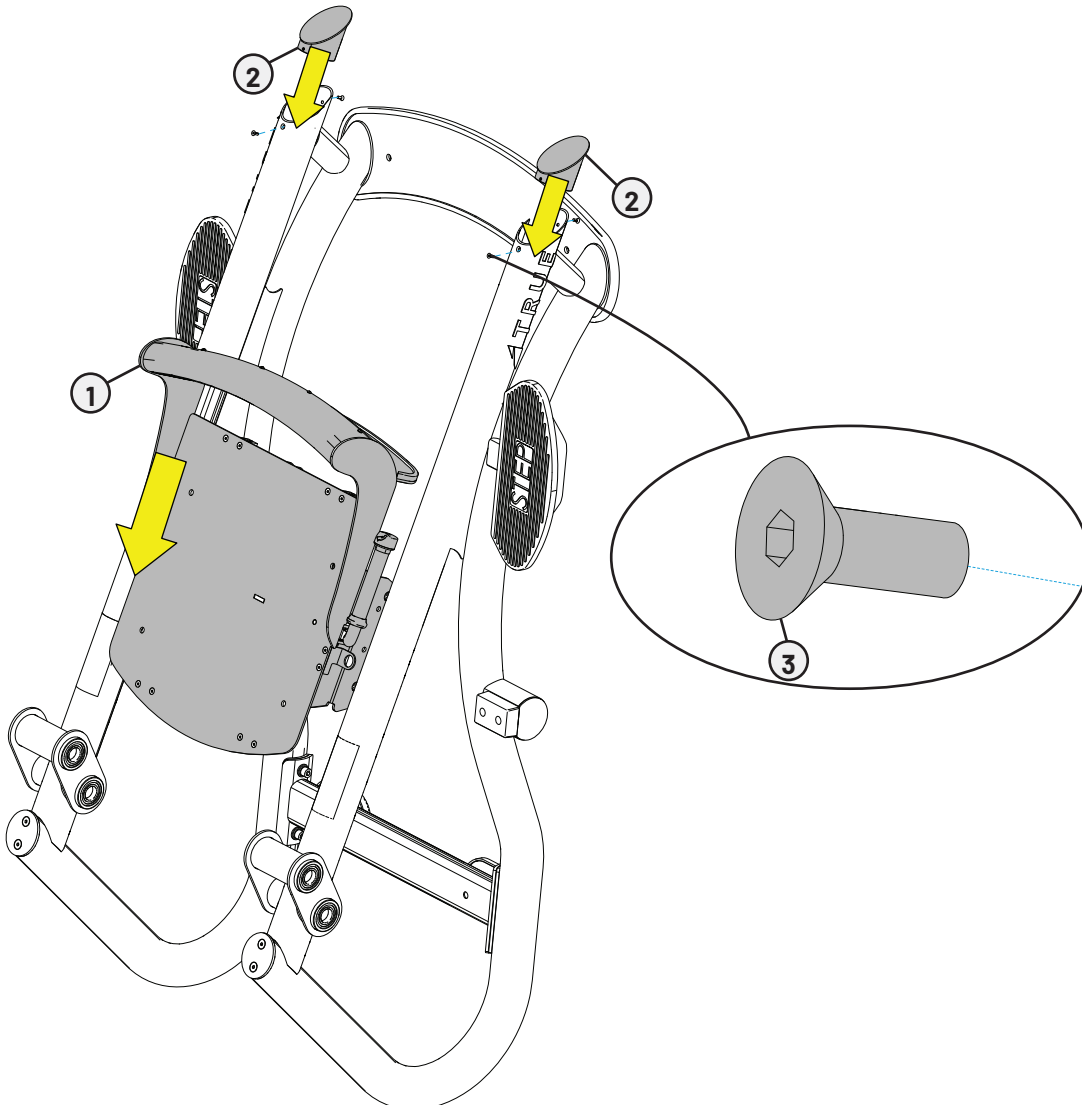
- Rotate the main frame backwards with the rear in the air.
- Slide the carriage assembly into the left and right main frame rails.
 

**NOTE:** At least one person should hold the main frame, while another attaches the carriage assembly.
- Using a 1/8" allen wrench, attach the 2 end caps to the left and right main frame rails using 4 hex screws.



**NOTE:** At least one person should hold the carriage assembly in place, while another installs the end caps.

**IMPORTANT! DO NOT lift the carriage assembly handle.**

**NOTE:** Do not use any lubricant inside of the main frame rails or directly on the carriage assembly wheels.



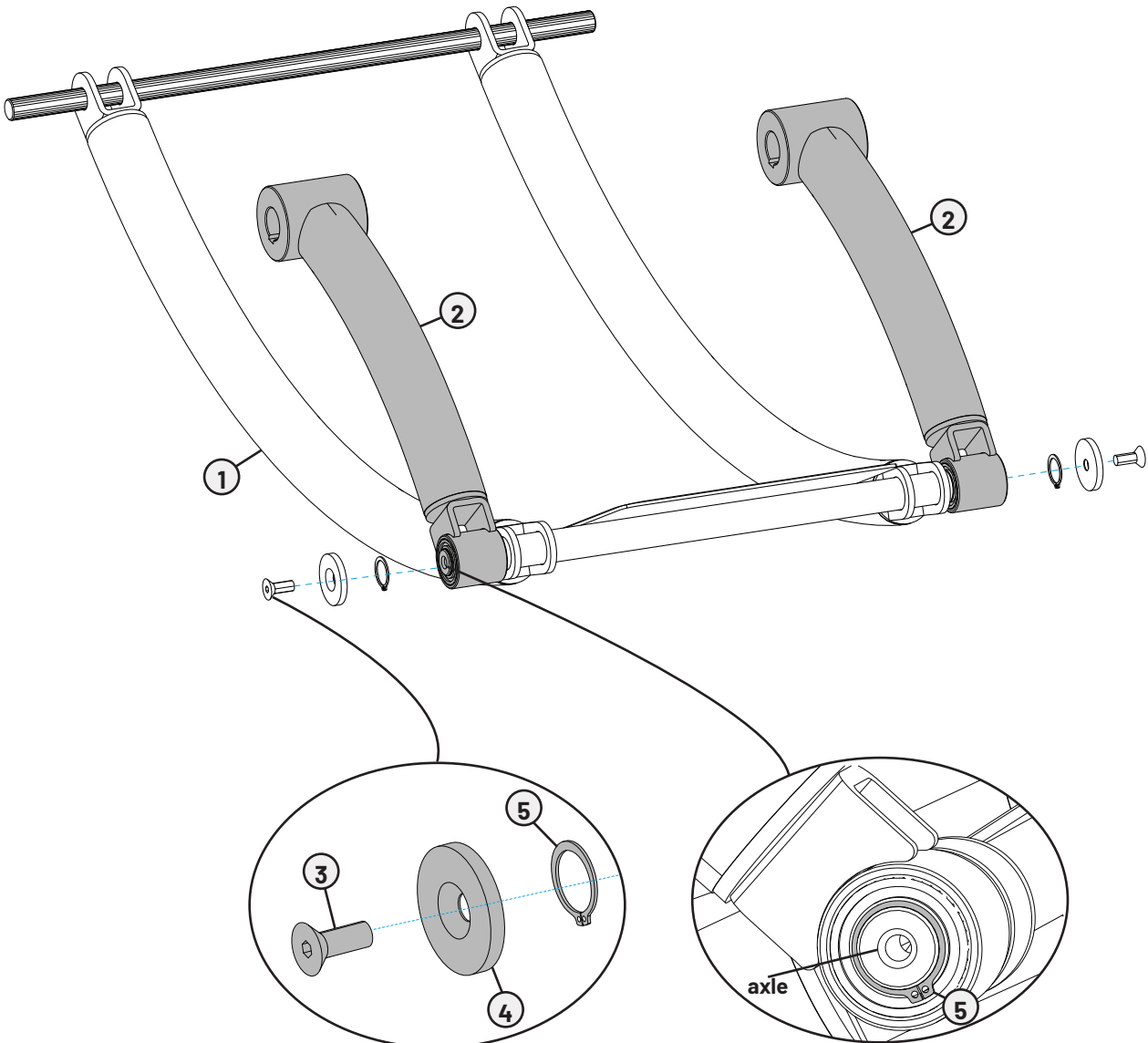
### STEP 4—ATTACH LINKAGE ARMS TO THE LINKAGE FRAME

Tools Used in this Step	
7/32" Allen Wrench	
External Retaining Ring Pliers	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC00LK000X-35	WELDMENT, CARRIAGE LINKAGE ARM	1
2	SC00LK100X-35	LINKAGE ARM	2
3	C 658	FHCS, 3/8"-16 X 1"	2
4	SC10053800	SHAFT END CAP, 48 X 6	2
5	C1018	EXTERNAL RETAINING RING 23.2 X 1.2 THK	2

Using a 7/32" allen wrench and external retaining ring pliers, attach the linkage arms to the linkage frame using 2 hex screws, 2 end caps, and 2 retaining rings.

**NOTE:** Be sure to attach the retaining rings to the axles on the linkage frame

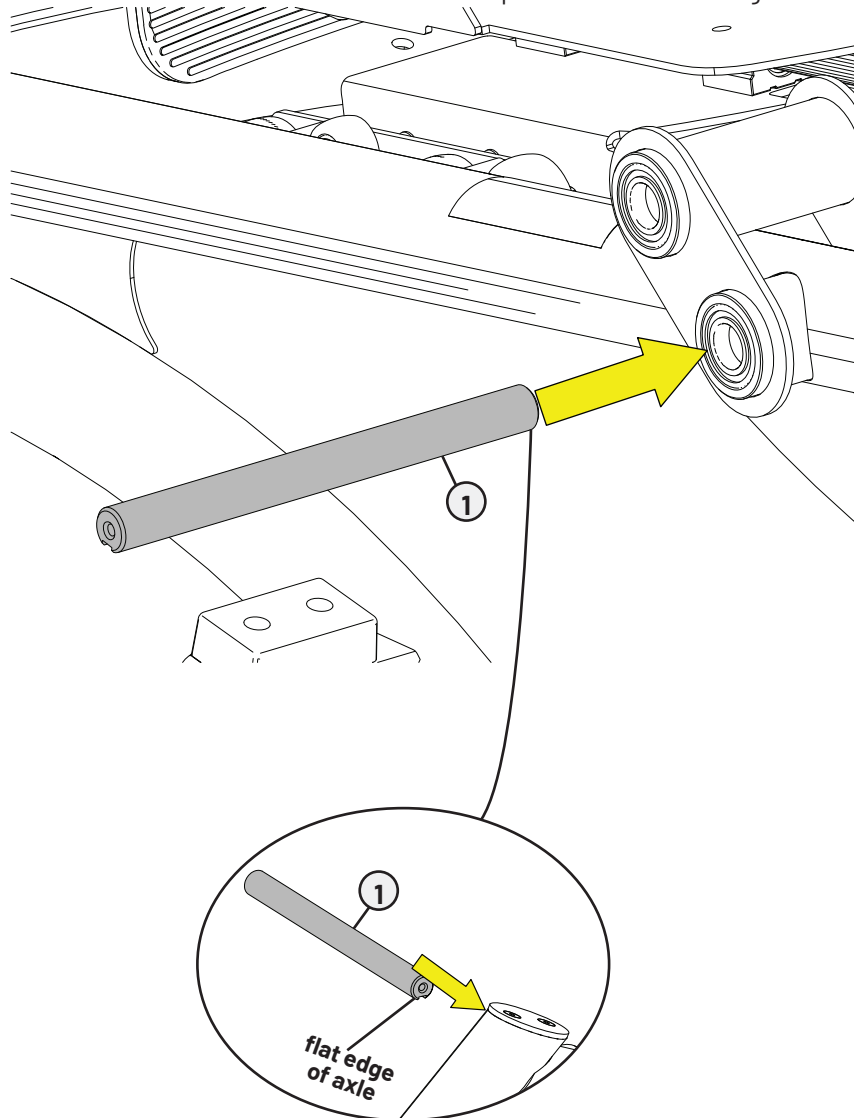


## STEP 5—INSERT PRESS ARM AXLES THROUGH THE MAIN FRAME

Tools Used in this Step	
7/32" Allen Wrench	
Rubber Mallet	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC00MF700	PRESSING ARM AXLE	2
2	C 658	FHCS, 3/8"-16 X 1"	2
3	C1014	FLAT KEY 10 x 8 x 80	2
4	SC10007000	SC1000 AXLE SLEEVE	2
5	COMP-SC10056000	WASHER 70.2 X 30.2 X 5	2

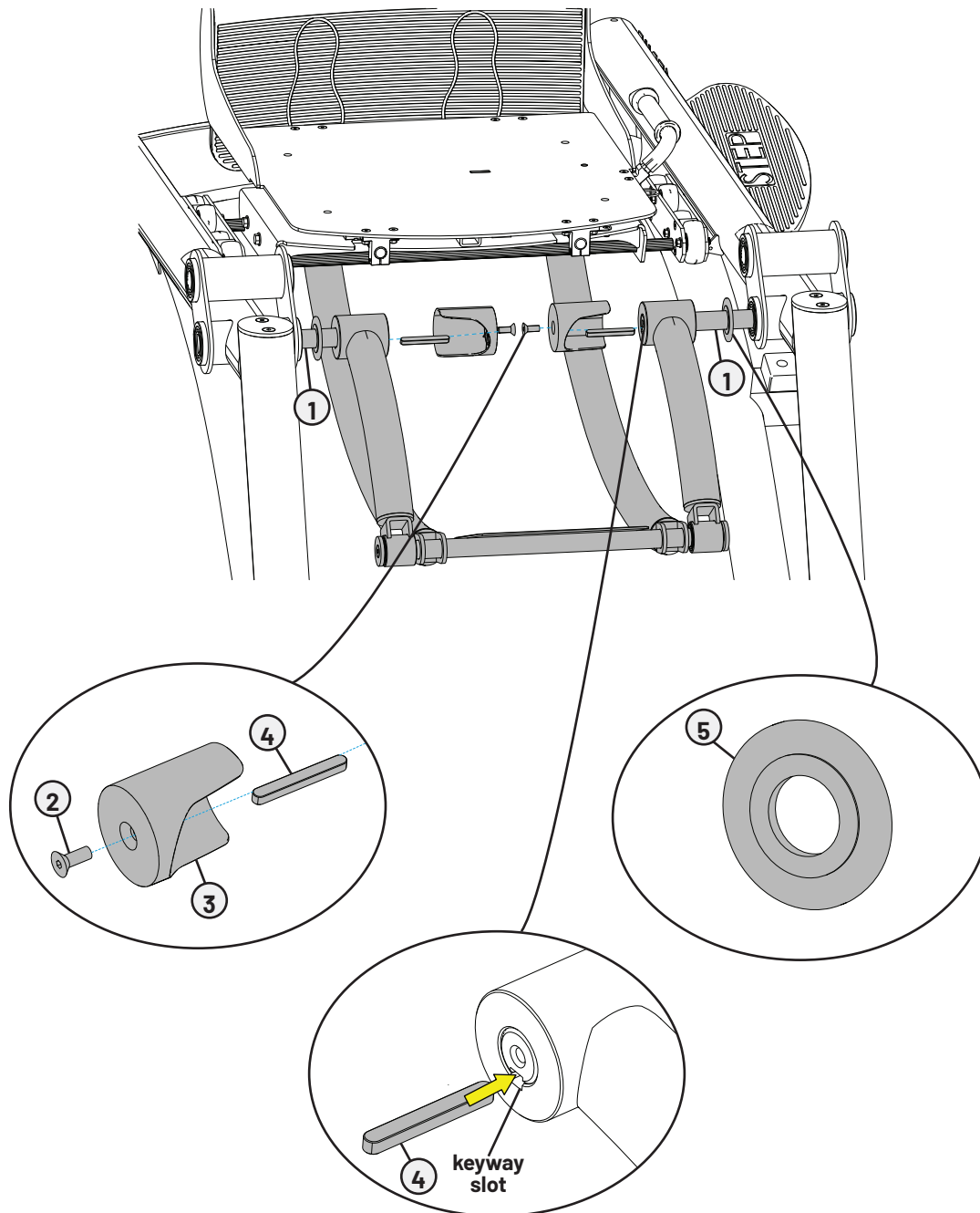
- A. Align the linkage arms with the main frame.
- B. Line up the flat edges of the axles with the main frame. Slide the press arm axles through the main frame on each side.





## STEP 5—INSERT PRESS ARM AXLES THROUGH THE MAIN FRAME CONTINUED

- C. Slide the press arm axles through 1 washer and the linkage arms on each side. Using a rubber mallet, lightly tap the press arm axles into the main frame on each side.
- D. Using a  $7/32$ " allen wrench, attach the linkage arms using 1 hex screw, 1 axle sleeve, and 1 flat key on each side.

**NOTE:** Be sure to insert the flat keys through the keyway slots on the linkage arms and axles.

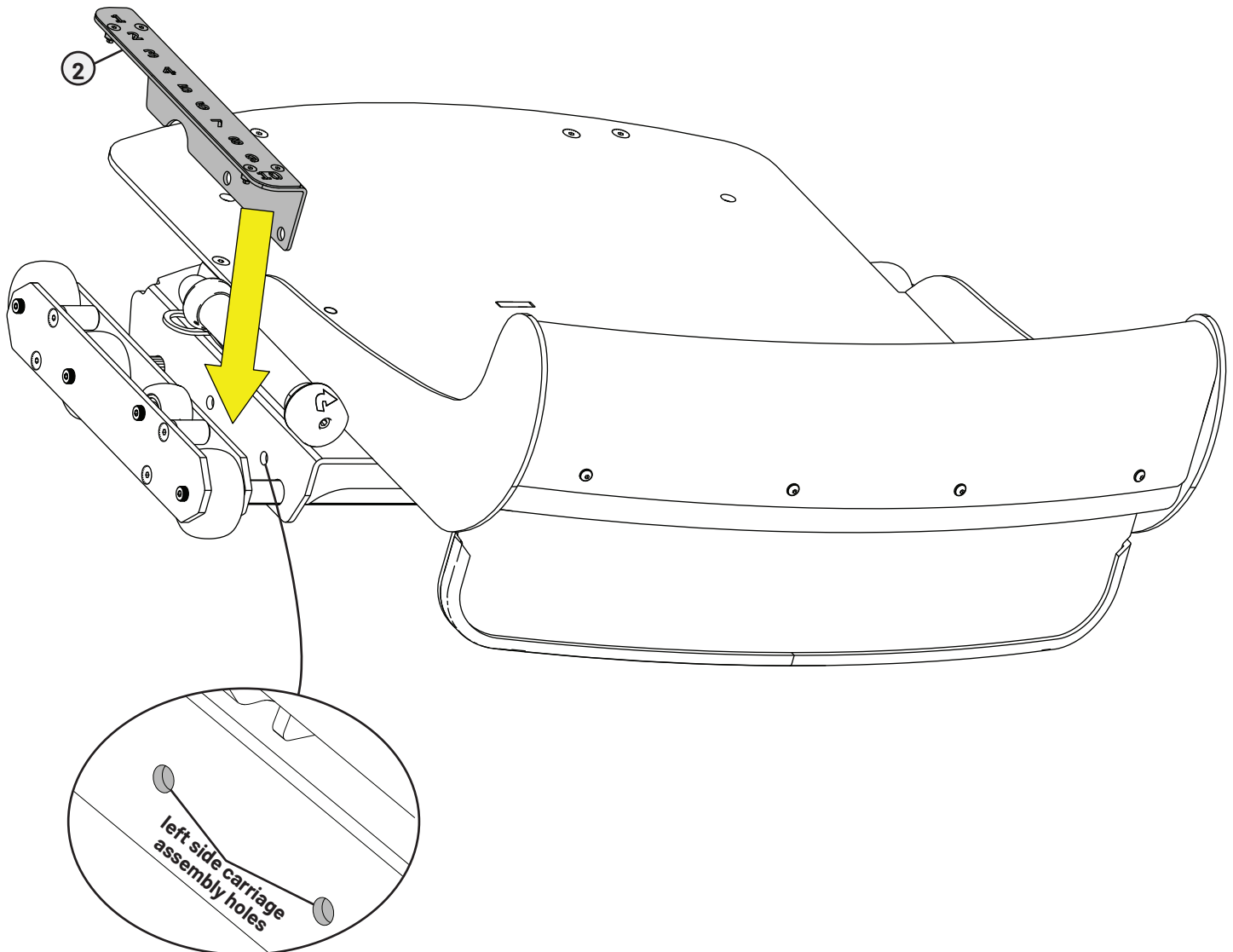


## STEP 6—ATTACH LINKAGE FRAME TO THE CARRIAGE ASSEMBLY

Tools Used in this Step	
9/16" Socket Wrench	
9/16" Wrench	

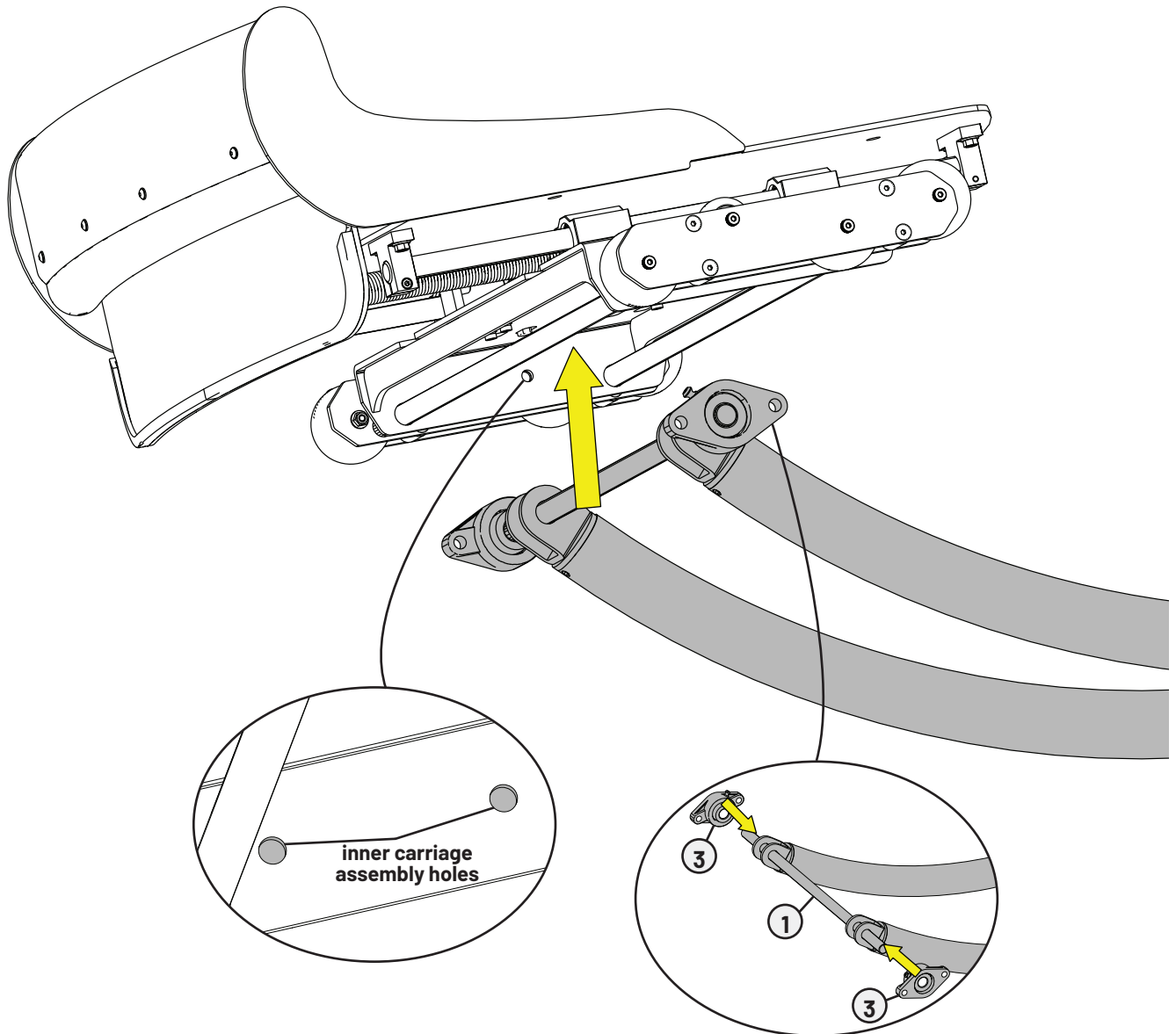
Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC00LK000X-35	WELDMENT, CARRIAGE LINKAGE ARM	1
2	COMP-SC00AJ000X-35	CARRIAGE POSITION INDICATOR	1
3	COMP-SC00MBR000	FLANGE MOUNT BALL BEARING, 3/4 I.D.	2
4	C 447	HHS, 3/8"-16 X 1-1/2", GR5, ZP	4
5	C 754C	WASHER, FLAT, 3/8", ZP	8
6	C 766A	LOCK NUT, 3/8"-16 X 17/64", NYL	4

A. Align the carriage position indicator with the holes on the left side of the seat carriage.



## STEP 6—ATTACH LINKAGE FRAME TO THE CARRIAGE ASSEMBLY CONTINUED

- B. Slide the 2 flange bearings onto the linkage frame.
- C. Align the linkage frame with the inner holes on the inside of the carriage assembly.

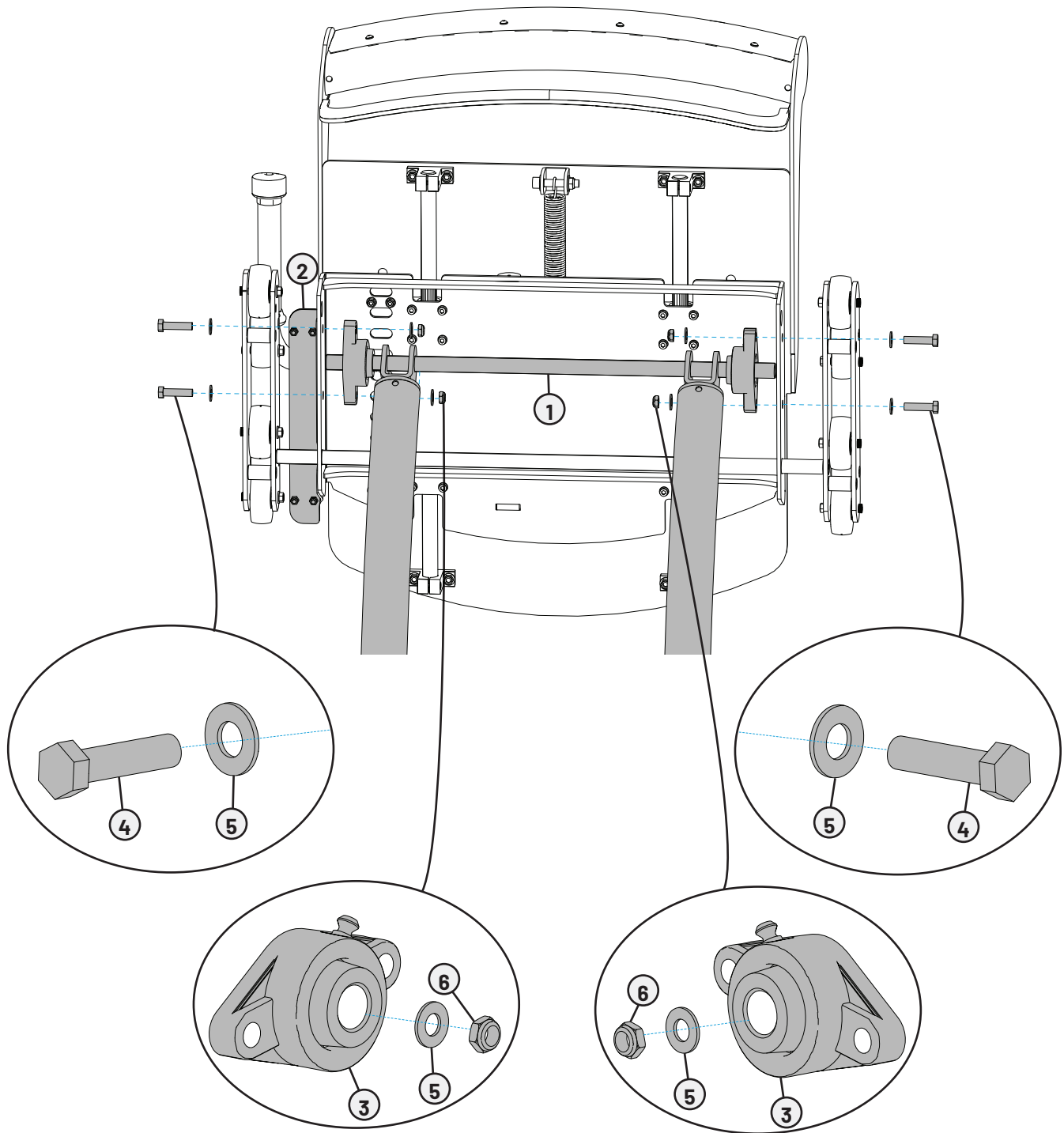


## STEP 6—ATTACH LINKAGE FRAME TO THE CARRIAGE ASSEMBLY CONTINUED

D. Using a 9/16" socket wrench and a 9/16" open end wrench, attach the linkage frame and carriage position indicator to the carriage assembly using 4 hex head screws, 8 flat washers, 4 lock nuts, and the 2 flange bearings.

**NOTE:** At least one person should hold the linkage frame and carriage position indicator in place, while the other installs the linkage frame and carriage position indicator from underneath the unit.

**NOTE:** Do not use the adjustment strip to adjust the carriage assembly while the machine is in use.





## STEP 7—ATTACH PRESS BARS TO THE MAIN FRAME

### Tools Used in this Step

7/32" Allen Wrench

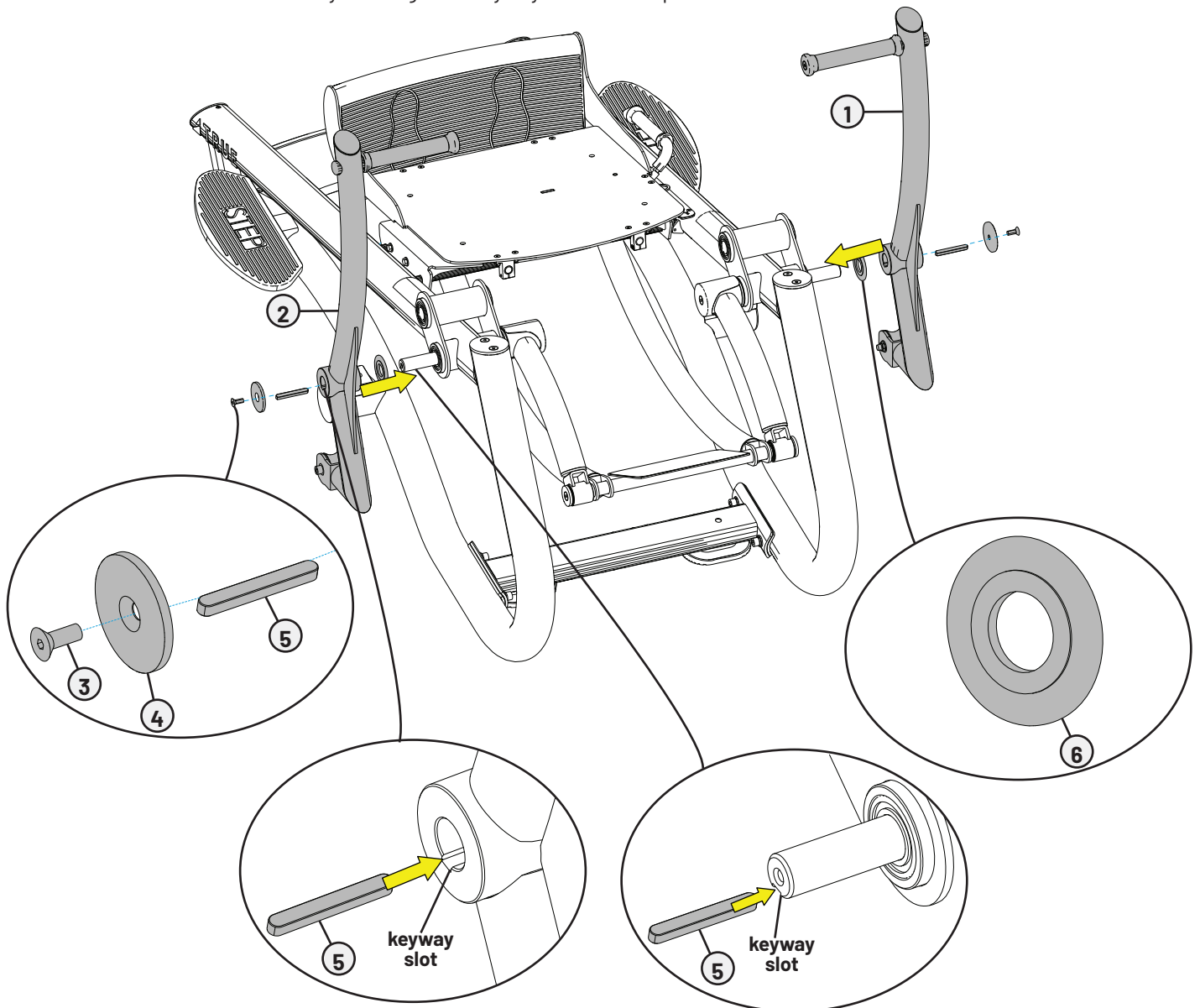


### Parts Used in this Step

ITEM	PART#	DESCRIPTION	QTY
1	SC00PB000X-35	LEFT PRESS BAR	1
2	SC00PB100X-35	RIGHT PRESS BAR	1
3	C 658	FHCS, 3/8"-16 X 1"	2
4	SC10056500	SHAFT END CAP 70.2 X 6	2
5	C1014	FLAT KEY 10 x 8 x 80	2
6	COMP-SC10056000	WASHER 70.2 X 30.2 X 5	2

Using a 7/32" allen wrench, attach the press bars to the press arm axles using 2 hex screws, 2 end caps, 2 flat keys, and 2 washers.

**NOTE:** Be sure to insert the flat keys through the keyway slots on the press bars and axles.

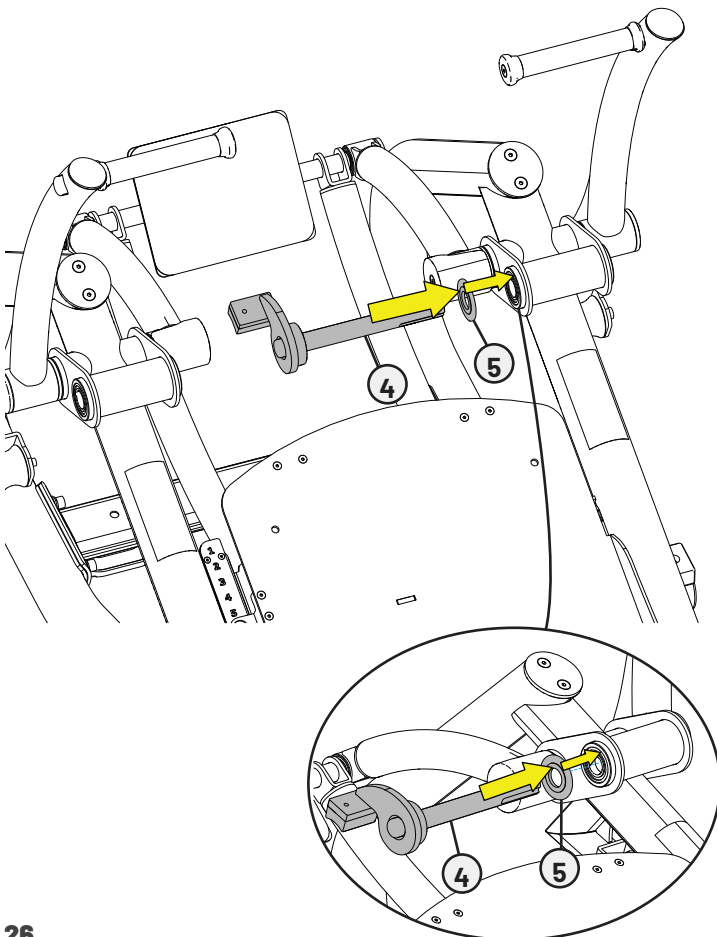


## STEP 8—ATTACH WEIGHT ARM ASSEMBLIES TO THE MAIN FRAME

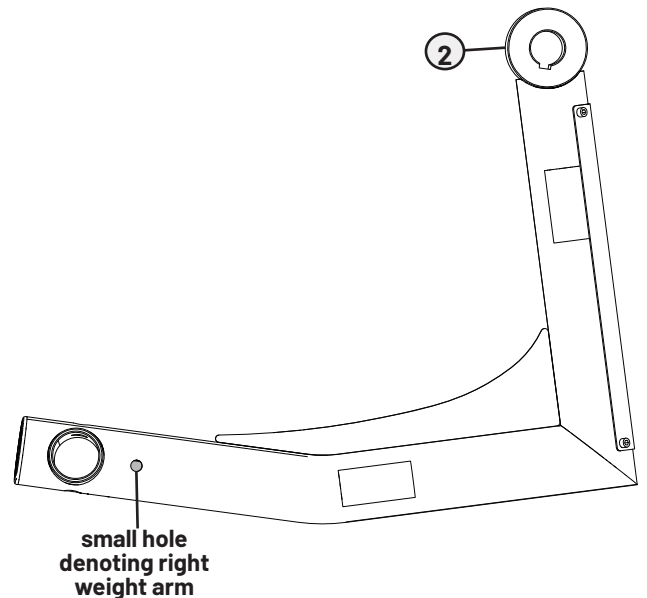
Tools Used in this Step	
7/32" and 3/8" Allen Wrench	
3/4" Wrench	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC00PA200X-35	LEFT WEIGHT ARM	1
2	SC00PA300X-35	RIGHT WEIGHT ARM	1
3	SC100073ASSY-35	SC1000 AXLE ASSEMBLY LEFT	1
4	SC100074ASSY-35	SC1000 AXLE ASSEMBLY RIGHT	1
5	COMP-SC10056000	WASHER 70.2 X 30.2 X 5	4
6	C 658	FHCS, 3/8"-16 X 1"	4
7	SC10056500	SHAFT END CAP 70.2 X 6	2
8	C1014	FLAT KEY 10 x 8 x 80	2
9	SC10053800	SHAFT END CAP, 48 X 6	2
10	C1015	SHCS 1/2-13 X 3	2
11	C 755B	WASHER, FLAT, 1/2" SAE Z.P.	4
12	W0220	NYLOCK NUT 1/2-13 x 5/16	2
13	SC00MF800	WEIGHT HORN	2
14	CW65	65 LBS. COUNTER WEIGHT	2

- A. Insert the left and right axle assembly into the left and right main frame, using 1 washer on each side.



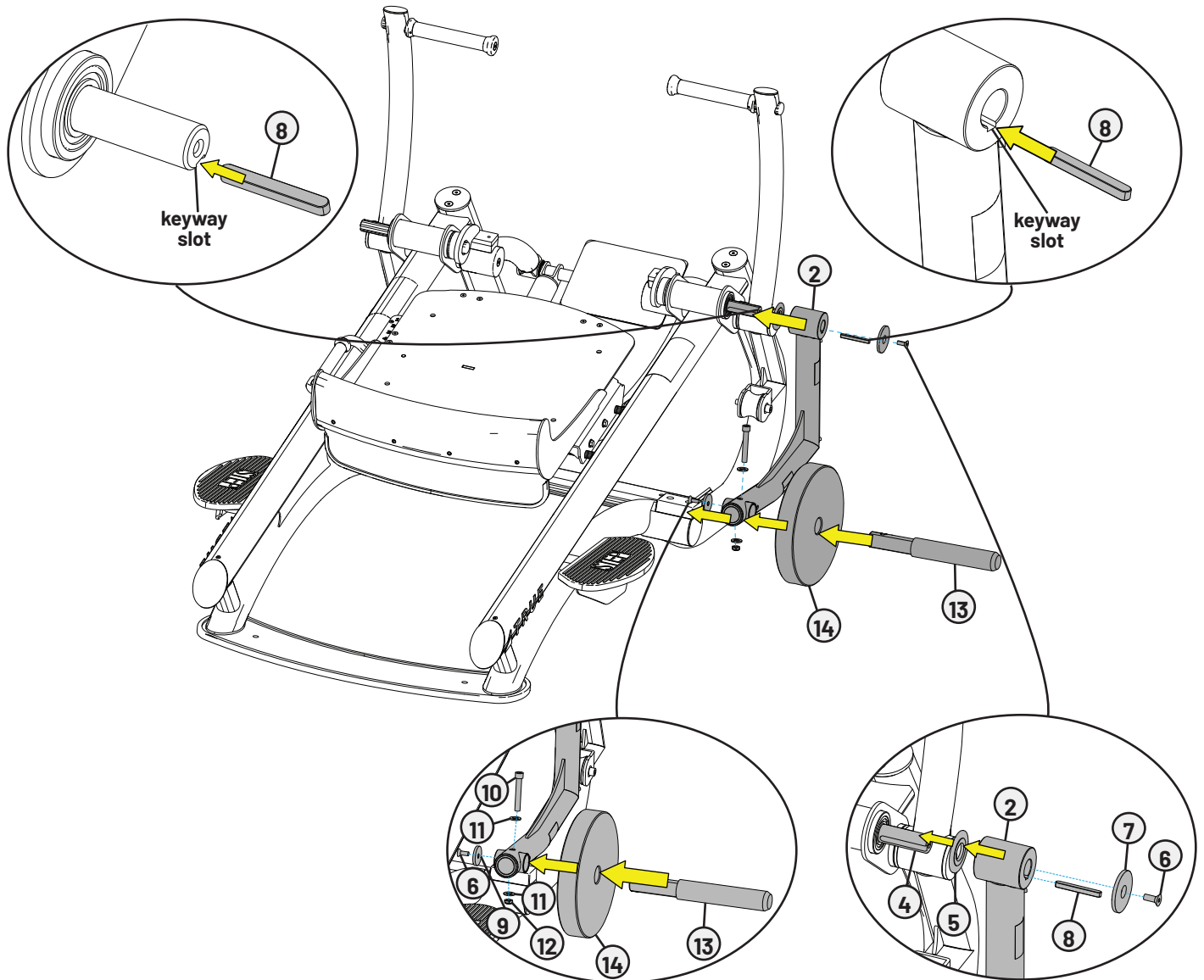
**NOTE:** There is a small hole on the end of the right weight arm where the weight horn is located that denotes it is the right weight arm. Confirm the weight arms are assembled on the corresponding main frames as incorrect assembly may cause the free weights to become dislodged.




## STEP 8—ATTACH WEIGHT ARM ASSEMBLIES TO THE MAIN FRAME CONTINUED

- B. Slide the left and right weight arms through the corresponding axles assemblies, using 1 washer on each side.
  - C. Using a 7/32" allen wrench, attach the left and right weight arms to the corresponding main frames using 1 hex screw, 1 end cap, 1 flat key, and 1 washer on each side.
- NOTE:** Be sure to insert the flat keys through the keyway slots on the weight arms and axles.
- D. Slide the weight horns through the counter weights and insert them into the left and right weight arms.
  - E. Using a 3/8" allen wrench, a 3/4" open end wrench, and a 7/32" allen wrench, secure the counter weights and weight horns in place using 1 socket head cap screw, 2 washers, 1 lock nut, 1 hex screw, and 1 end cap on each side.

**NOTE:** Both weight horns should rest at approximately a 3 degree upward angle to secure the counter weights in place.

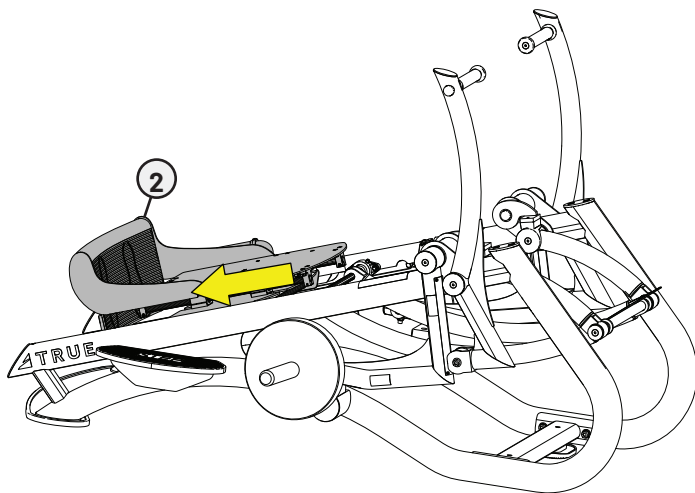


## STEP 9—ATTACH KNEE PAD ASSEMBLY TO THE CARRIAGE ASSEMBLY

Tools Used in this Step	
3/8" and 5/16" Allen Wrench	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
N/A	PLS1500 PAD KIT	PAD KIT PLS	1
PAD KIT HARDWARE			
1	COMP-SC00PD100X	KNEE PAD	1
2	SC00MF200X-35	CARRIAGE ASSEMBLY	1
3	C 624	SHCS, 3/8"-16 X 1-1/4", ZP	4
4	C 754C	WASHER, FLAT, 3/8", ZP	4

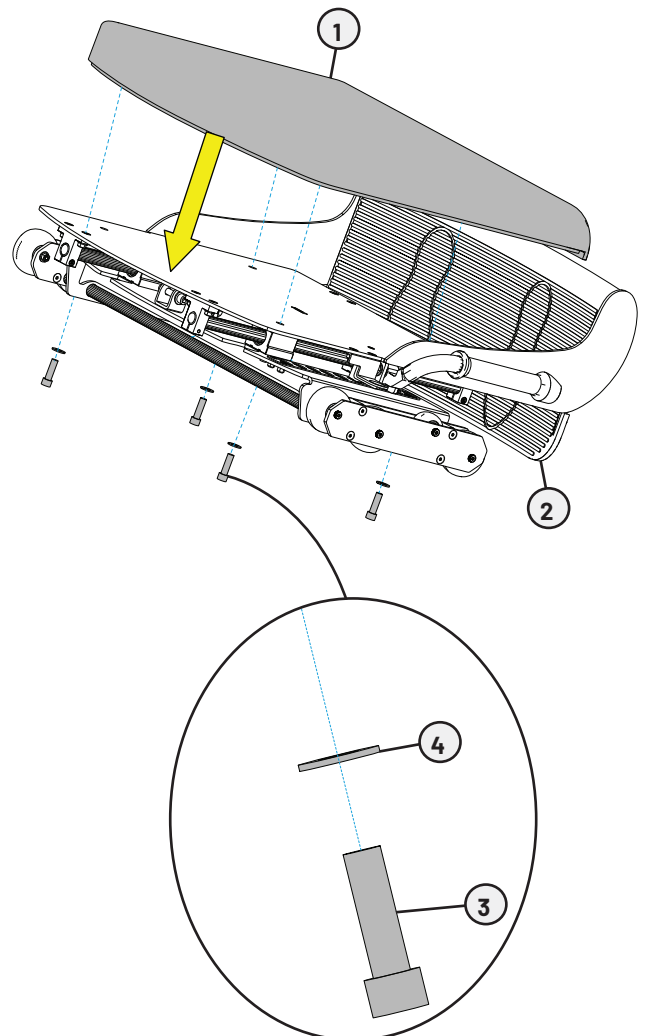
- Using a 3/8" allen wrench, fully tighten the main frame hardware from Step 1.
- Adjust the position of the carriage assembly by sliding it down the main frame.



- Using a 5/16" allen wrench, attach the knee pad to the carriage assembly using 4 socket head cap screws and 4 flat washers.

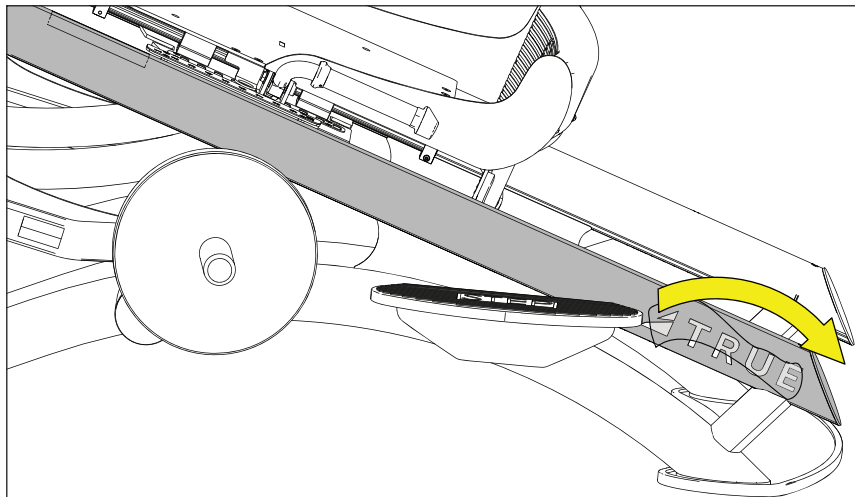
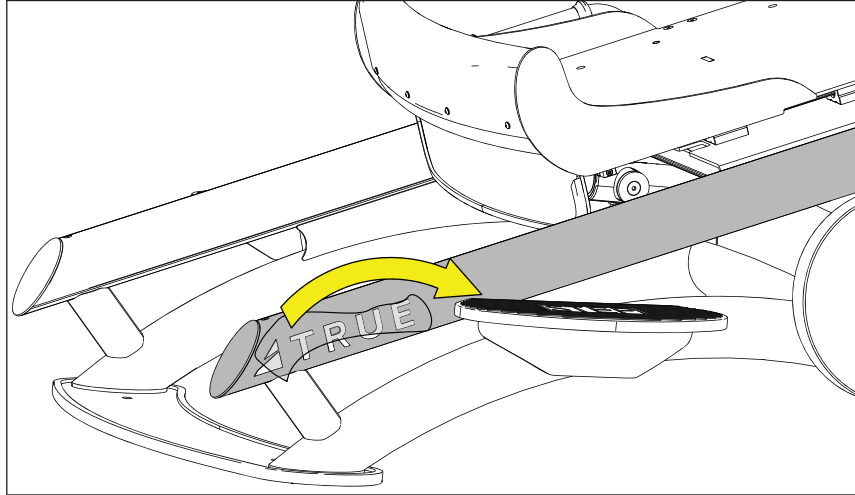
**NOTE:** At least one person should hold the carriage assembly in place, while another installs the knee pad.

- Slide the carriage assembly back into its original position.



## STEP 10—REMOVE PROTECTIVE FILM FROM LOGOS (IF APPLICABLE)

Remove the protective film from the logos on the left and right main frame rails.





## PREVENTATIVE MAINTENANCE

Preventative maintenance is crucial to maintaining the function and safety of this equipment. Your facility must establish written guidelines for preventative maintenance and keep written or online records of the maintenance performed on these products. As a minimum, the items presented in the Safety Instructions section of this document and the items that follow here, should be included in your maintenance program.

**IMPORTANT!** Always purchase replacement parts from TRUE. Many parts are tested and manufactured specifically for TRUE equipment. Use of unapproved parts may cause serious injury and/or void the limited warranty.

## DAILY INSPECTION AND MAINTENANCE

The following items are critical to the safety of users and maintenance staff as well as ensuring the optimum performance of the machines. These inspections should be performed each day before the equipment is subject to use. TRUE is not responsible for performing or scheduling regular maintenance or inspections.

- Inspect for cleanliness. Wipe and dry the upholstery, frame, and chrome. (See cleaning the equipment.)
- Inspect all adjustment pins, weight stack pins, set screws, gas shocks, snap links, and pulleys if equipped.
- Inspect all safety and instructional decals.
- Inspect all weight stack shields if equipped.
- Verify that rubber hand grips are intact and secure.
- Verify that anti-skid foot grips are intact and secure.

## WEEKLY INSPECTION AND MAINTENANCE

The following items are critical to the safety of users and maintenance staff as well as ensuring the optimum performance of the machines. These inspections should be performed each week. TRUE is not responsible for performing or scheduling regular maintenance or inspections.

- Verify that the adjustment pop pins retract easily and fully engage (when released) into each adjustment disc hole/slot. The pop pins are spring loaded so they should return to the engaged position when you release the knob.
- Verify that the adjustment pin disengages and engages freely when actuating the adjustment mechanism. Be sure that the adjustment pin inserts fully into the adjustment disc.
- Verify that all hardware is tight and that associated frame members are secure. Apply a few small drops of a thread locking compound such as Loctite® on any loose bolts.
- Inspect frame for integrity and function. Replace any components at the first sign of wear with only TRUE supplied parts.

## OTHER SCHEDULED PREVENTATIVE MAINTENANCE

TRUE recommends that scheduled maintenance be performed by a qualified service technician. Please contact your dealer or visit [www.truefitness.com](http://www.truefitness.com) to contact a local TRUE authorized service technician.

### Monthly

Clean guide rods and lubricate with a Teflon grease if equipped with guide rods.

### Every 6 Months

Lubricate pivot bearing and linear bearings with lithium grease.

## CLEANING THE EQUIPMENT

### Daily Cleaning

Wipe all machines with a water dampened cloth and dry completely. This includes painted parts, chrome plated parts (except guide rods), plastic parts, and upholstered pads. It is important not to leave parts damp. This will increase the potential for corrosion to occur.

**⚠ CAUTION:** Certain anti-bacterial cleaners and other harsh cleaning agents can induce corrosion on the machine components. These solutions can also dry out and cause cracking and splitting on the upholstery.

### Heavy Duty Cleaning

- Guide Rods (if equipped)—Clean and lubricate with a Teflon Spray. Be sure to coat the entire guide rod. Spraying lubricant into the cap plate bushings is also recommended.
- Chromed Adjustment Tubes—Wipe away dust and dirt before applying a Teflon spray lubricant. TRUE recommends using Tri-Flow™ or a similar brand.
- Linear Bearings—Clean the linear shaft and lubricate (as required) with Teflon based grease. Keeping linear bearings clean and lubricated is critical to long life and good performance.
- Painted Frames—If you have scuff marks, grease or a heavy dirt buildup on frame components, start with a mild soap solution or a diluted solution of a product such as Simple Green with a dilution of 32:1. If you cannot remove the marks using those methods, use a car polish/cleaner. **DO NOT** use solvents such as lacquer thinner, mineral spirits or acetone. For deeper scuff marks, use an automobile finish rubbing compound.
- Upholstery—For heavy duty cleaning, use a mild soap solution. This method should be sufficient in the majority of instances. In severe stain cases, you can use a solution of 5-10% household bleach diluted with water. Be sure to test an inconspicuous area first. **DO NOT** use chemical cleaners on the vinyl upholstery. You can also use a lanolin based hand cleaner to clean your upholstery. Wipe off after cleaning with a damp cloth and thoroughly dry.
- Plastic Parts—Use a mild soap solution to clean dirt and grease marks.
- Labels—Use a mild soap solution to clean dirt and grease marks.
- Shrouds—Use a mild soap solution to clean dirt and grease marks.

**⚠ CAUTION:** Do not use any acidic cleaners. Doing so will weaken the paint or powder coatings and may void the TRUE Warranty. Never pour or spray liquids on any part of the equipment. Allow the equipment to dry completely before using.

**⚠ CAUTION:** If you determine that the equipment needs service, make sure that the equipment cannot be used inadvertently and ensure other users know that the machine needs service.

To order parts or to contact a TRUE authorized service representative, please visit [www.truefitness.com](http://www.truefitness.com).



## WARRANTY INFORMATION

### COMMERCIAL WARRANTY

<b>CARDIO</b>				
WARRANTY ITEM	VAPOR, APEX	GRAVITY PLUS	GRAVITY	ADX, RO, SURGE
Frame*	7 Years	7 Years	7 Years	5 Years
Parts	3 Years	3 Years	3 Years	3 Years
Consoles	3 Years	3 Years	3 Years	2 Years
Labor**	2 Years	2 Years	1 Year	1 Year
Wear Items***	180 Days	180 Days	180 Days	90 Days

<b>STRENGTH</b>	
WARRANTY ITEM	PALLADIUM, FUSE XL, FORCE, FITNESS LINE, ATLAS, XFT, XFW, MP, SM, FT, FS
Frame*	10 Years
Parts	5 Years
Cables and Linear Bearings	1 Year
Labor**	1 Year
Wear Items***	90 Days

<b>FLEXIBILITY</b>	
WARRANTY ITEM	STRETCH
Parts	1 Year
Wear Items***	90 Days

Warranty does not cover damage or equipment failure resulting from or caused by improper assembly/installation, accident, misuse, abuse, unauthorized modification, or failure to provide reasonable and necessary maintenance.

\*Frame is the serialized base of the unit and does not include paint or coatings.

\*\*Labor is available for equipment located within United States and Canada.

\*\*\*Wear Items include: batteries, covers, caps, badges, paint, pedal straps, toe clips, elliptical pedal inserts, foot pads, Coax/TV, HDMI, USB, mirroring or Ethernet connections, and safety key.

**See Warranty Details for terms, conditions, and complete coverage details.**



## WARRANTY DETAILS

All TRUE Fitness products are distributed by TRUE and are warranted to the original registered product purchaser and the parts of the TRUE product (the "Product") listed below, under normal use and service, shall be free of manufacturing defects in workmanship and materials only for the specified period of time.

### NOTE:

- Standard shipping is included with warranty part replacement.
- Shipping for warranty frame or replacement is included for the period of three years from the original date of purchase.

### All Warranty Items are "LIMITED"

- This limited warranty does not cover damage or equipment failure resulting from or caused by improper assembly/ installation, failure to follow instructions and warnings in owner's manual, accident, misuse, abuse, unauthorized modification, failure to provide reasonable and necessary maintenance, software version upgrades, compatibility with third party/aftermarket hardware, software, applications, or websites.
- TRUE's liability shall under no circumstances exceed the actual amount paid by you for the product, nor shall TRUE under any circumstances be liable for any consequential, incidental, special or punitive damages or losses, whether direct or indirect.
- Some states or countries do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.
- TRUE will neither assume nor authorize any person to assure for us any other obligation or liability concerning the sale of this Product. Under no circumstances shall TRUE be liable under this warranty, or otherwise, of any damage to any person or property, including any lost profits or lost savings, for any special, indirect, secondary, incidental, or consequential damages arising out of the use of or inability to use this Product.
- This limited warranty, which is given expressly and in lieu of all other express warranties, constitutes the only warranty made by TRUE.
- The remedies described herein are your sole and exclusive remedies and TRUE's entire liability for any breach of this limited warranty.
- No one is authorized to change, modify, or extend the terms of this limited warranty.
- This limited warranty is in lieu of all other warranties of any kind either expressed or including but not limited to implied warranties of merchant.
- This limited warranty applies to the product only while the product remains in the possession of the original purchaser and is not transferable.
- This limited warranty becomes VALID ONLY if the Product is initially assembled/installed by a TRUE authorized dealer/ technician (if anyone other than a TRUE authorized dealer/technician initially assembles and installs the Product, this limited warranty will be void unless the written authorization of TRUE is first obtained).
- This limited warranty can be processed only if the warranty registration form is completed on-line; or if the form provided with equipment is filled in, signed by the original purchaser, and mailed to TRUE within 30 days of purchaser's receipt of this Product.
- All serial numbers must be intact on the Product for this limited warranty to be valid.
- Installation or download of any 3rd party or after-market products will result in voided warranty. This includes, but is not limited to, electrical and mechanical parts, software, or applications.
- TRUE will ship to an authorized service provider any new or rebuilt replacement part or component, or at our option, replace or refund the Product.
- Replacement parts are warranted for the remaining portion of the original warranty period.
- Proof/receipts of necessary maintenance may be required within 30 days of requested warranty part or service.
- This limited warranty does not apply to the performance of the heart rate accuracy will not be warranted as performance varies, based on user's physiology, age, method of use, and other external factors.



## WARRANTY REGISTRATION

Thank you for purchasing a TRUE product!

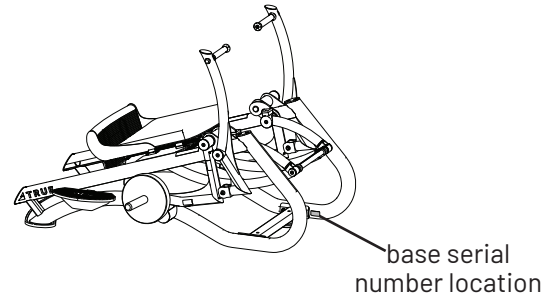
For warranty terms and conditions, see the complete owner's manual and assembly guide located at [truefitness.com](http://truefitness.com).

To validate your product warranty, you must register your product within 30 days of purchaser's receipt of this product.

To register your product:

- Go online to:  
<https://truefitness.com/services-support/warranty-registration/>  
OR
- Complete the information below and mail to:  
TRUE Product Support  
865 Hoff Road  
St. Louis, MO 63366

**PLEASE RETAIN THIS PORTION FOR YOUR RECORDS**  
**BASE SERIAL NUMBER:**  
**CONSOLE SERIAL NUMBER:**



### Warranty Registration

**Base Serial Number**

**Purchase Date**

**Company (if applicable)**

**Customer Name (First and Last)**

**Email Address**

**Phone Number**

**Street Address**

**City**

**State**

**Postal Code**

**Country**





CONTACT US  
service@truefitness.com  
1.800.883.8783

865 Hoff Road  
St. Louis, MO 63366

[TRUEFITNESS.COM](https://www.truefitness.com)

