

# PLS1700 GLUTE PRESS COMPOSITE

 TRUE FITNESS



SCAN FOR UP-TO-DATE  
OWNER'S MANUAL



SCAN FOR  
ASSEMBLY VIDEO

MODEL PLS1700  
(MAN-PLS1700 REV04)

**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 inquiries 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.....	6
GENERAL CARE AND MAINTENANCE.....	8
COMMERCIAL MAINTENANCE SCHEDULE.....	9
COMPLIANCES.....	9
DIMENSIONS AND WEIGHTS.....	10
LABEL LOCATIONS.....	11
WARNING AND INTENDED USE LABELS.....	11

### ASSEMBLY INSTRUCTIONS

PREASSEMBLY CHECKLIST.....	13
ASSEMBLY STEPS.....	17

### PREVENTATIVE MAINTENANCE

DAILY INSPECTION AND MAINTENANCE.....	34
WEEKLY INSPECTION AND MAINTENANCE.....	34
OTHER SCHEDULED PREVENTATIVE MAINTENANCE.....	34
CLEANING THE EQUIPMENT.....	35

### WARRANTY INFORMATION

COMMERCIAL WARRANTY.....	36
WARRANTY DETAILS.....	37
WARRANTY REGISTRATION .....	38



## 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 / 20 kg.

## **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 lbs / 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:
  - 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.
- 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.

- 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, and chrome parts.
- 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.
- Exercise instruction labels—clean with soap and water as needed.
- 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

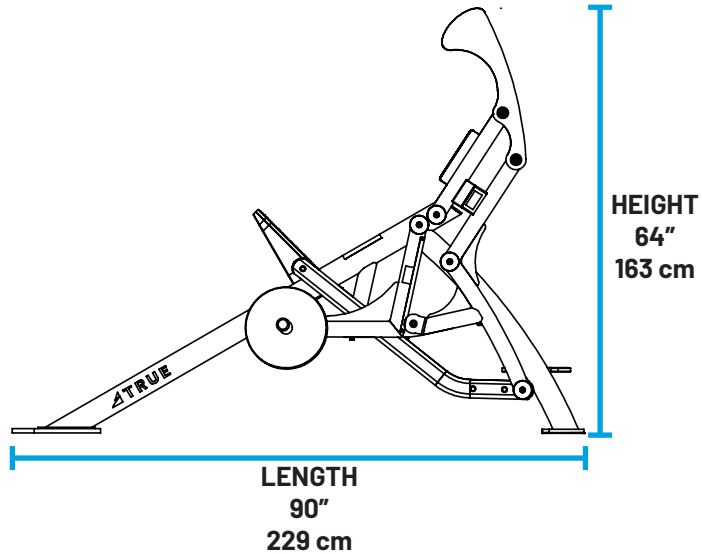
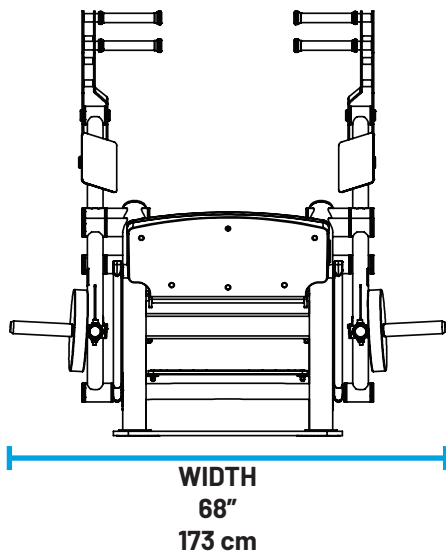
Commercial Maintenance Schedule					
	Daily	Weekly	Monthly	6 Months	Annually
Inspect all nuts and bolts and tighten if needed.		X			
Inspect safety catches, stop rods, and their fasteners. Replace at the first sign of wear.	X				
Inspect all anti-slip surfaces and replace as needed.		X			
Inspect all adjustment pins, set screws, and gas shocks if equipped.	X				
Inspect all accessory bars and handles.		X			
Inspect all safety and instructional decals.	X				
Clean and polish frame.	X				
Clean and polish chrome.	X				
Lubricate pivot bearings and linear bearings.				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).

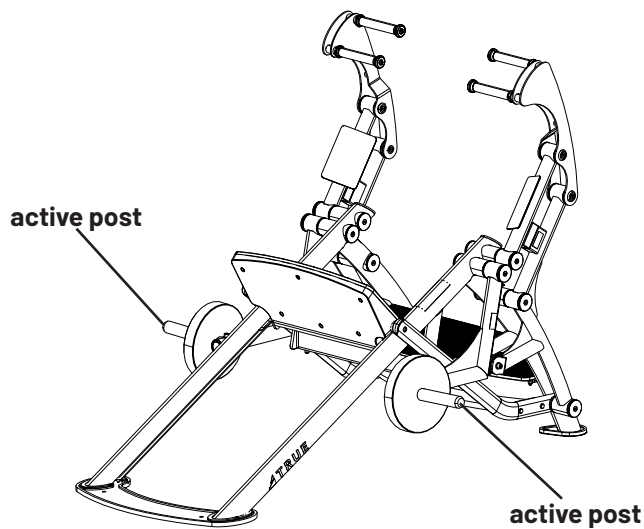
## DIMENSIONS AND WEIGHTS

- **ASSEMBLED DIMENSIONS (W X L X H)**  
68" x 90" x 64" / 173 cm x 229 cm x 163 cm



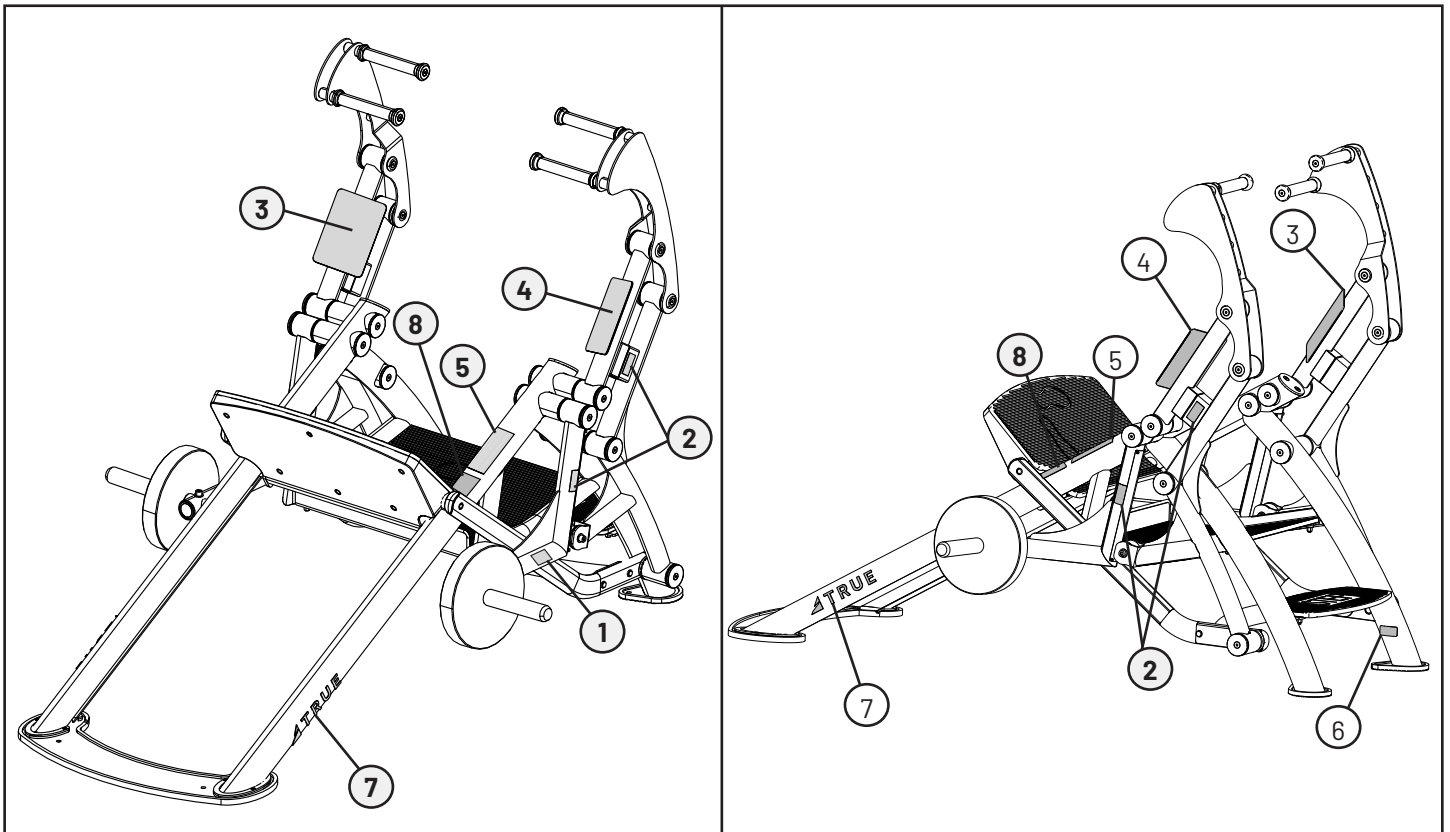
- **PRODUCT WEIGHT**  
631 lbs / 286 kg
- **MAXIMUM USER WEIGHT**  
400 lbs / 182 kg
- **MAXIMUM LOAD (USER WEIGHT + WEIGHT PLATES)**  
760 lbs / 345 kg

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-WRN-PLS003	LABEL, 4 PLATE WARNING	2
2	SD0301	PINCH POINT STICKER 64*32	4
3	LBL-PRO-PLS1700L	LABEL, PLS1700 PLACARD LEFT	1
4	LBL-PRO-PLS1700R	LABEL, PLS1700 PLACARD RIGHT	1
5	LBL-WRN-0022	LABEL, GENERAL WARNING	1
6	SPL-00-LBLSN	LABEL, SERIAL NUMBER	1
7	LBL-LOG-010BK	LABEL, 10" NEW TRUE LOGO, WHITE	2
8	LBL-MTN-PLS001	LABEL, MAINTENANCE	1


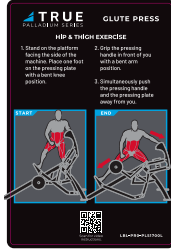
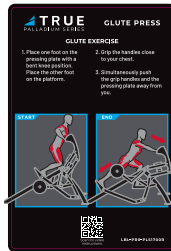
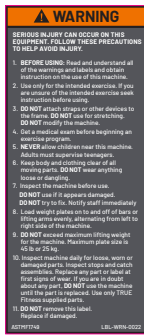
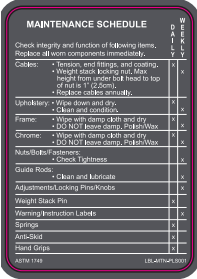




## WARNING AND INTENDED USE LABELS

**⚠ 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-WRN-PLS003 (Plate Weight)	

Part# and Description	Image
SD0301 (Pinch Warning)	
LBL-PRO-PLS1700L (Placard)	
LBL-PRO-PLS1700R (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:



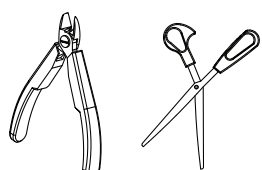
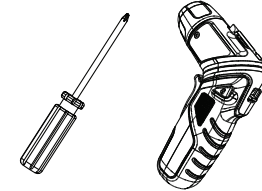
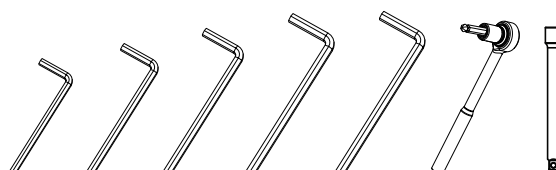
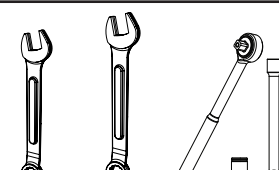
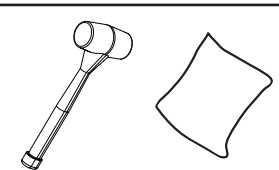
Use caution when assembling this product.  
Unpacking and assembling this product requires two or more people.



Use caution when unpacking this product. Avoid damage to the product.  
**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)	
5/32", 3/16", 7/32", 5/16", and 3/8" Allen Wrenches (supplied) (or ratcheting socket wrench with hex bits)	
9/16" and 3/4" Wrenches and Ratcheting Wrench with 9/16" Socket	
Rubber Mallet and Cloth	

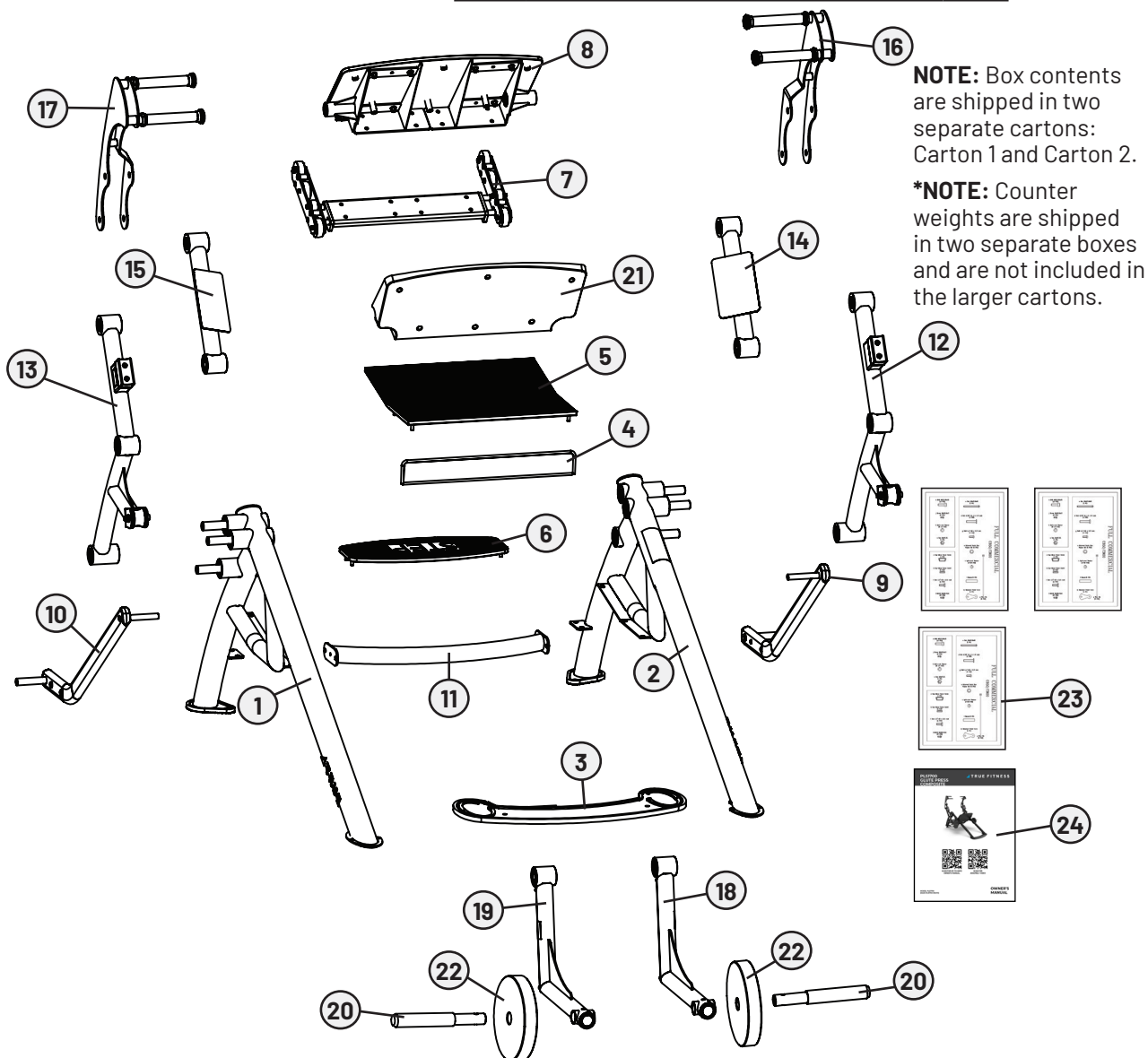


**THIS PRODUCT SHIPS IN MULTIPLE CARTONS.  
ENSURE YOU HAVE ALL PARTS SHOWN BEFORE  
ASSEMBLING THE EQUIPMENT.**

## BOX CONTENTS

ITEM	DESCRIPTION	QTY
1	MAIN FRAME, LEFT SIDE	1
2	MAIN FRAME, RIGHT SIDE	1
3	SUBASSEMBLY, REAR FOOT PLATE	1
4	HEEL PLATE	1
5	USER PLATFORM	1
6	FRONT STEP ASSEMBLY	1
7	CARRIAGE TROLLEY ASSEMBLY	1
8	FOOT PRESSING PLATE	1
9	LINKAGE ARM, RIGHT	1
10	LINKAGE ARM, LEFT	1
11	LINKAGE ARM, CROSS TIE	1
12	WEIGHT PRESSING ARM, RIGHT	1

ITEM	DESCRIPTION	QTY
13	WEIGHT PRESSING ARM, LEFT	1
14	SUBASSEMBLY, RIGHT PLACARD ARM	1
15	SUBASSEMBLY, LEFT PLACARD ARM	1
16	USER HANDLE, RIGHT	1
17	USER HANDLE, LEFT	1
18	WEIGHT ARM, RIGHT	1
19	WEIGHT ARM, LEFT	1
20	WEIGHT HORN	2
21	CARRIAGE, REAR COVER	1
22*	65 lbs. COUNTER WEIGHT*	2*
23	HARDWARE PACK	3
24	MANUAL	1

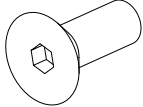
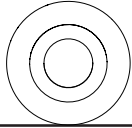
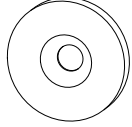
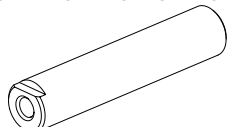
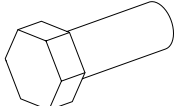
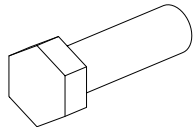
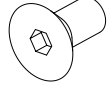
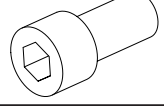
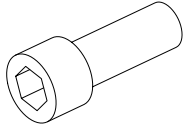


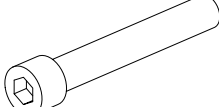
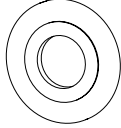
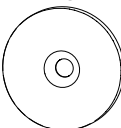
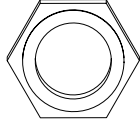
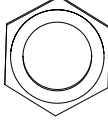
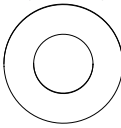
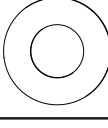
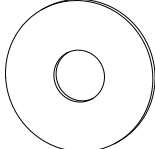


**THIS PRODUCT SHIPS IN MULTIPLE CARTONS.  
ENSURE YOU HAVE ALL PARTS SHOWN BEFORE  
ASSEMBLING THE EQUIPMENT.**



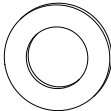
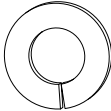
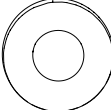
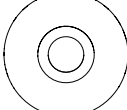
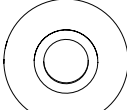
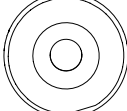
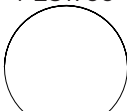
## HARDWARE PACK CONTENTS





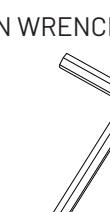
PLS1700 HARDWARE PACK		
ITEM	DESCRIPTION	QTY
C 658	FHCS, 3/8"-16 X 1" 	24
COMP-SC10056300	WASHER 51*20.2*5 	2
SC10053800	SHAFT END CAP, 48 X 6 	2
SC10056400	CONNECTING ROD 20*97 	4
C 445	HHS, 3/8"-16 X 1", GR5, ZP 	4
C 446	HHS, 3/8"-16 X 1-1/4", GR5, ZP 	8
C 959	FHCS, 1/4"-20 X 1/2" 	4
C 607	SHCS, 1/4"-20 X 1/2", ZP 	6
C 623	SHCS, 3/8"-16 X 1", ZP 	2

PLS1700 HARDWARE PACK		
ITEM	DESCRIPTION	QTY
C1015	SHCS 1/2"-13 X 3" 	2
COMP-SC10056000	WASHER 70.2 X 30.2 X 5 	12
SC10056500	SHAFT END CAP 70.2 X 6 	14
C 742	LOCK NUT, 3/8"-16 NYL, ZP 	18
C 766	LOCK NUT, 1/2"-13, NYL, JAM, ZP 	2
C 754C	WASHER, FLAT, 3/8", ZP 	30
C 755B	WASHER, FLAT, 1/2" SAE Z.P. 	4
C1091	WASHER, FLAT, M10 X 32MM OD OVERSIZE, ZP 	2




## HARDWARE PACK CONTENTS

PLS1700 HARDWARE PACK		
ITEM	DESCRIPTION	QTY
CC-36-011	WASHER, FLAT, M6, ZP 	6
C 747	LOCK WASHER, 1/4 SPLIT, ZP 	6
C1035	WASHER 23.5*10.5*7.1 	2
COMP-SC10056200	WASHER 70.2 X 20.2 X 5 	8
COMP-SC10056100	WASHER 70.2 X 25.2 X 5 	4
SC10056600	DECORATIVE CAP, BLACK ANODIZED 	8
SC1005-3-003	ASSEMBLY LUBRICANT, PLS1700 	1

PLS1700 HARDWARE PACK		
ITEM	DESCRIPTION	QTY
C1021	ALLEN WRENCH S 5/32 	1
C1585	ALLEN WRENCH S 3/16 	1
C1020	ALLEN WRENCH S 7/32 	2
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	
9/16" Wrench	

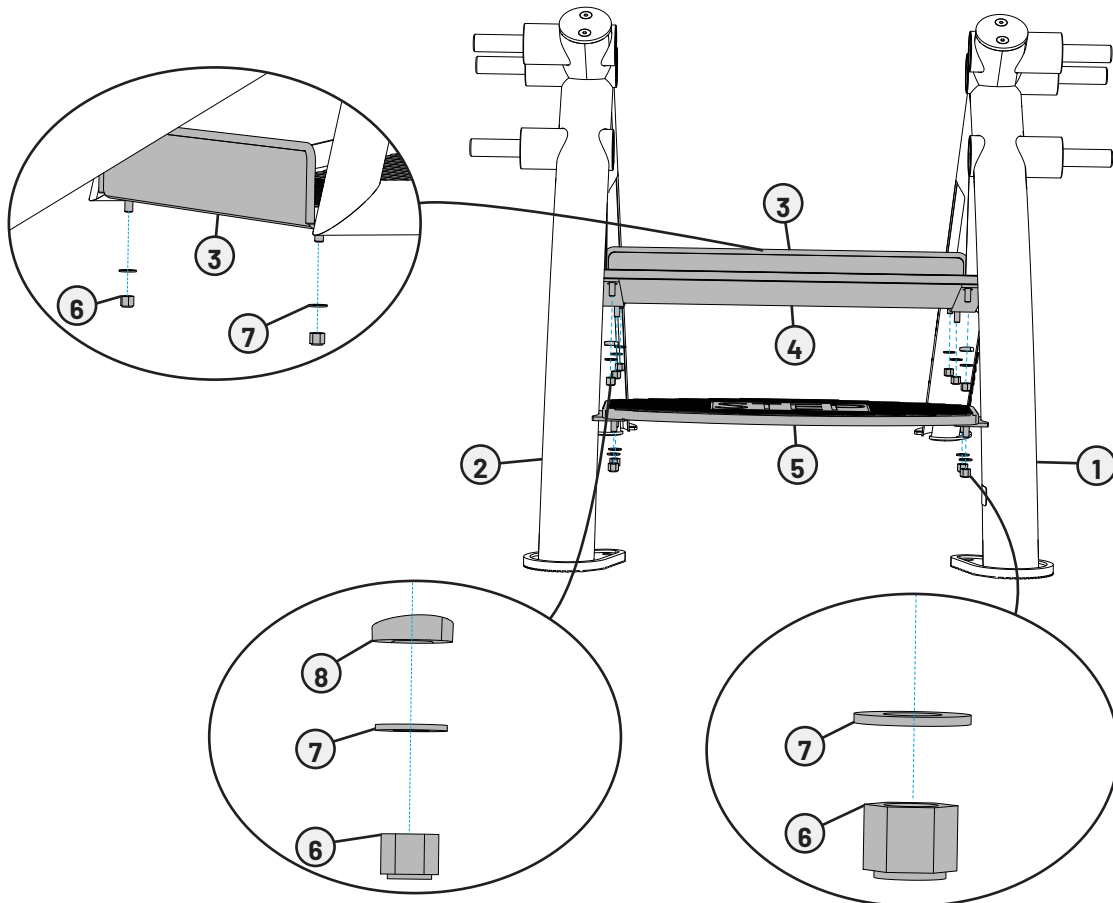
Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05MF000X-35	MAIN FRAME, LEFT SIDE	1
2	SC05MF100X-35	MAIN FRAME, RIGHT SIDE	1
3	SC05MF400X-35	HEEL PLATE	1
4	SC05MF300X-35	USER PLATFORM	1
5	SC05MF200X-35	FRONT STEP ASSEMBLY	1
6	C 742	LOCK NUT, 3/8"-16 NYL, ZP	10
7	C 754C	WASHER, FLAT, 3/8", ZP	10
8	C1035	WASHER 23.5*10.5*7.1	2

- Align the left and right main frames.
- Using an 9/16" open end wrench, attach the heel plate, user platform, and front step assembly to the left and right main frame using 10 lock nuts, 10 flat washers, and 2 washers.



**NOTE:** At least one person should hold the main frame, while another installs the heel plate, user platform, and front step assembly.

**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.



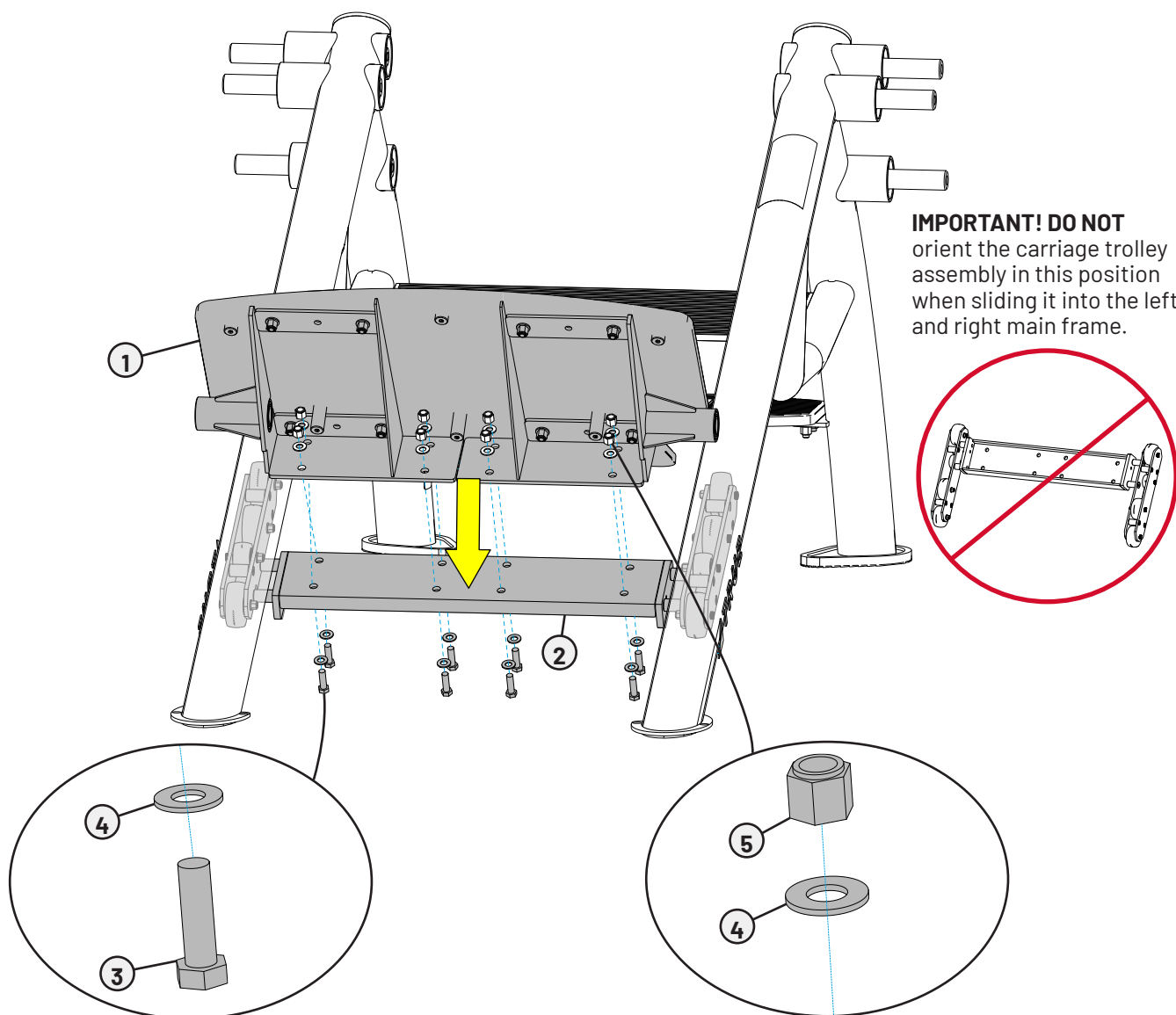
## STEP 2—ATTACH FOOT PRESSING PLATE

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



Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05MF500X-35	FOOT PRESSING PLATE	1
2	SC05MF600X-35	CARRIAGE TROLLEY ASSEMBLY	1
3	C 446	HHS, 3/8"-16 X 1-1/4", GR5, ZP	8
4	C 754C	WASHER, FLAT, 3/8", ZP	16
5	C 742	LOCK NUT, 3/8"-16 NYL, ZP	8

- Slide the carriage trolley assembly into the left and right main frame at the bottom as shown below.
- Using a 9/16" socket wrench and a 9/16" open end wrench, attach the foot pressing plate to the carriage trolley assembly using 8 hex head screws, 8 lock nuts, and 16 flat washers.

**NOTE:** At least one person should hold the carriage trolley assembly, while another installs the foot pressing plate.

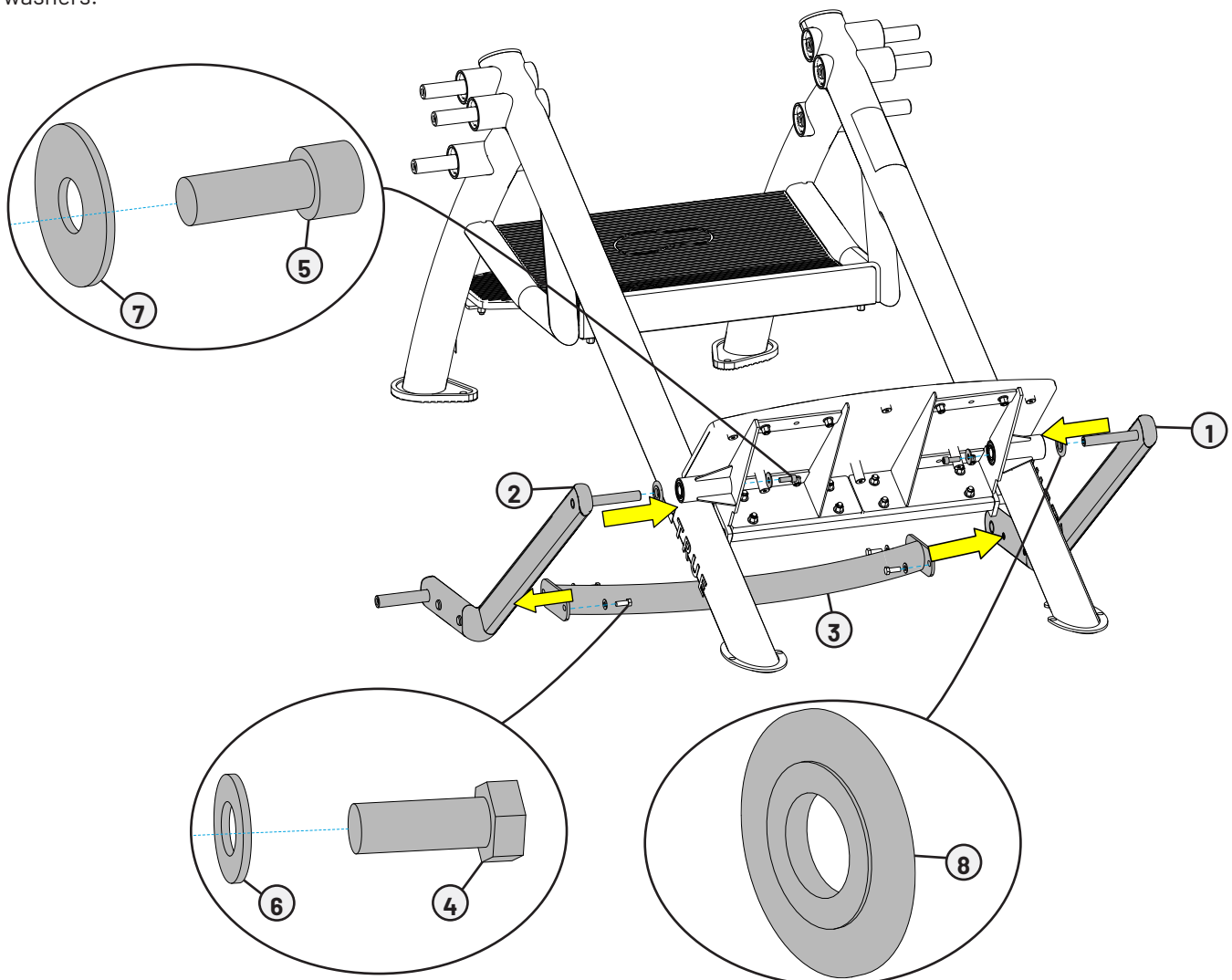


### STEP 3—ATTACH LINKAGE ARMS AND CROSS TIE

Tools Used in this Step	
5/16" Allen Wrench	
9/16" Socket Wrench	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05CF000X-35	LINKAGE ARM, RIGHT	1
2	SC05CF100X-35	LINKAGE ARM, LEFT	1
3	SC05CF200X-35	LINKAGE ARM, CROSS TIE	1
4	C 445	HHS, 3/8"-16 X 1", GR5, ZP	4
5	C 623	SHCS, 3/8"-16 X 1", ZP	2
6	C 754C	WASHER, FLAT, 3/8", ZP	4
7	C1091	WASHER, FLAT, M10 X 32MM OD OVERSIZE, ZP	2
8	COMP-SC10056300	WASHER 51*20.2*5	2

- Using a 5/16" allen wrench, attach the left and right linkage arms to the foot pressing plate using 2 hex screws, 2 flat washers, and 2 washers.
- Using a 9/16" socket wrench, attach the cross tie to the left and right linkage arms using 4 hex head screws and 4 flat washers.



## STEP 4—ATTACH WEIGHT PRESSING ARMS

### Tools Used in this Step

7/32" Allen Wrench



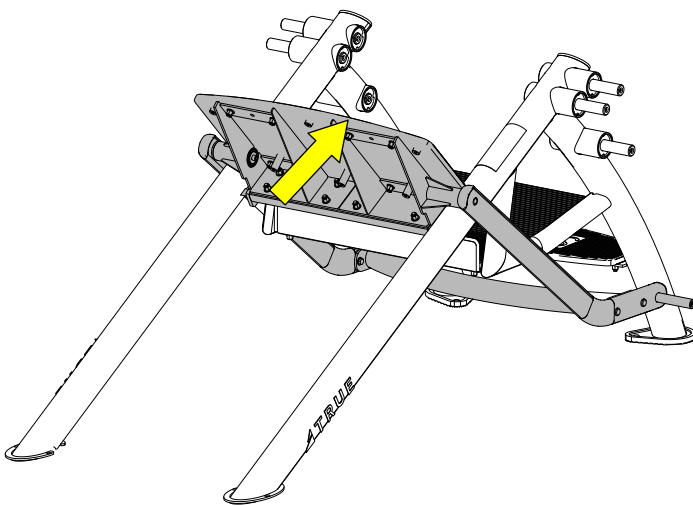
Cloth



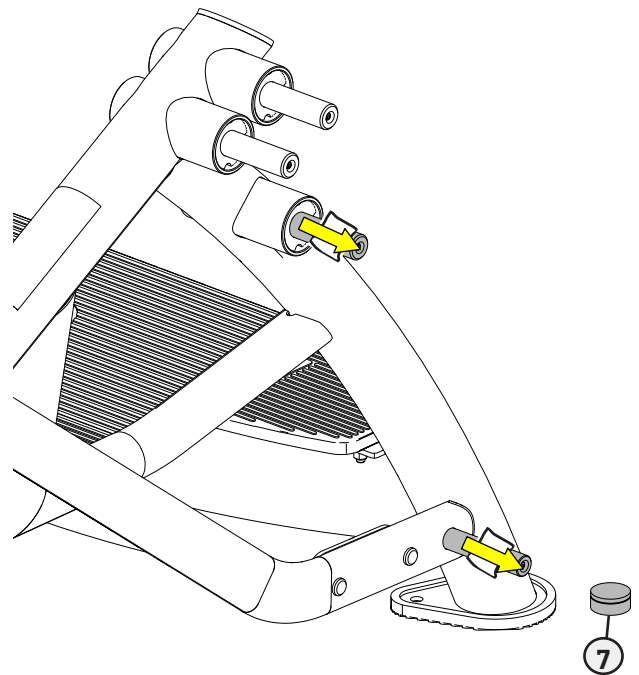
### Parts Used in this Step

ITEM	PART#	DESCRIPTION	QTY
1	SC05LK000X-35	WEIGHT PRESSING ARM, RIGHT	1
2	SC05LK100X-35	WEIGHT PRESSING ARM, LEFT	1
3	C 658	FHCS, 3/8"-16 X 1"	6
4	SC10056500	SHAFT END CAP 70.2 X 6	6
5	COMP-SC10056000	WASHER 70.2 X 30.2 X 5	4
6	COMP-SC10056100	WASHER 70.2 x 25.2 x 5	4
7	SC1005-3-003	ASSEMBLY LUBRICANT, PLS1700	1

A. Slide the carriage trolley assembly up the main frame.



B. Wipe all dirt and dust from the main frame shafts before lightly applying the assembly lubricant. Apply the lubricant to a cloth or paper towel and use it to wipe down the shafts on each side.

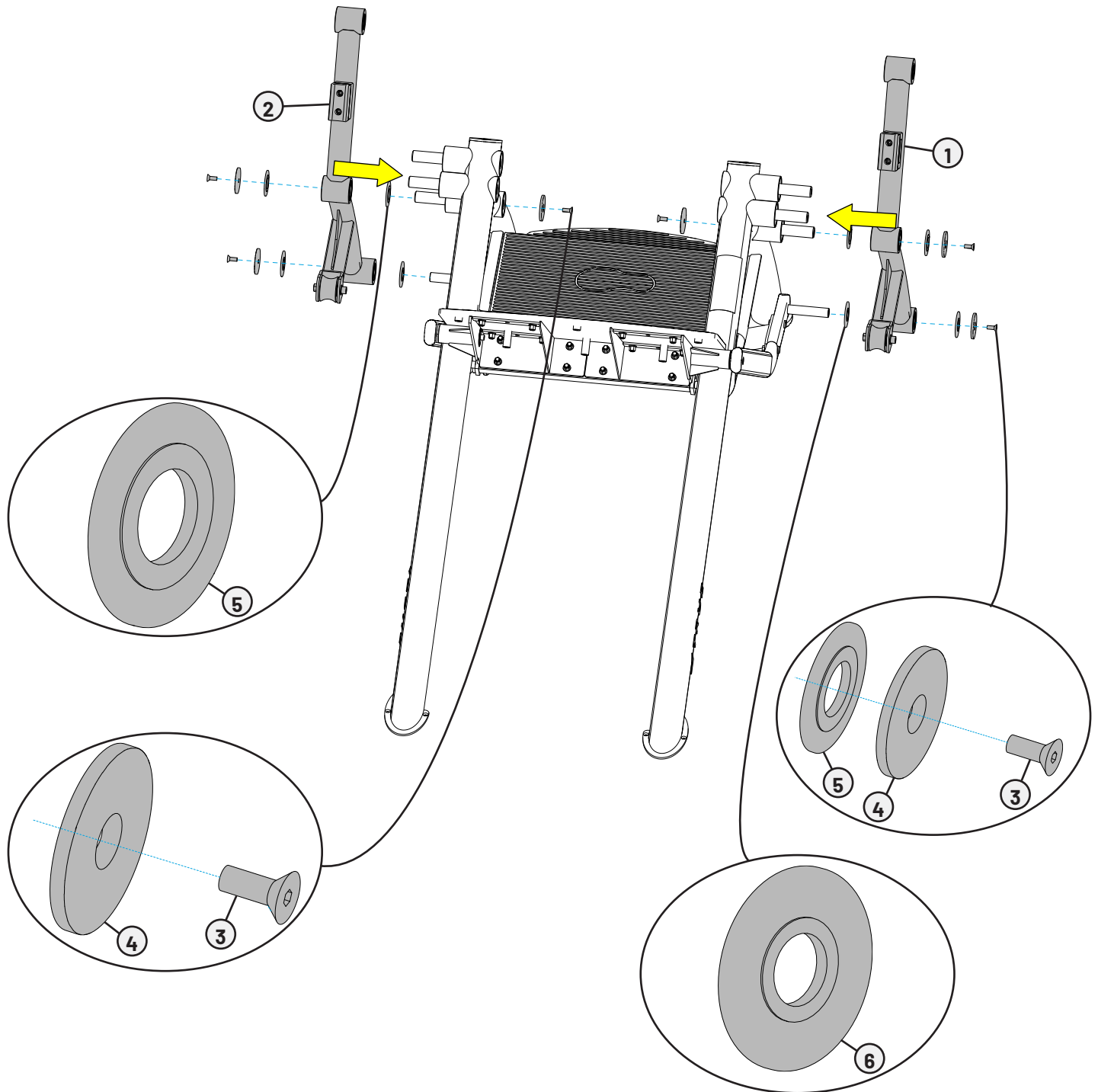




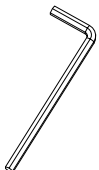
## STEP 4—ATTACH WEIGHT PRESSING ARMS CONTINUED

C. Using a 7/32" allen wrench, attach the left and right pressing arms to the main frame and linkage arms using 6 hex screws, 6 shaft end caps, and 8 washers.

**NOTE:** At least one person should hold the carriage trolley assembly, while another installs the weight pressing arms.



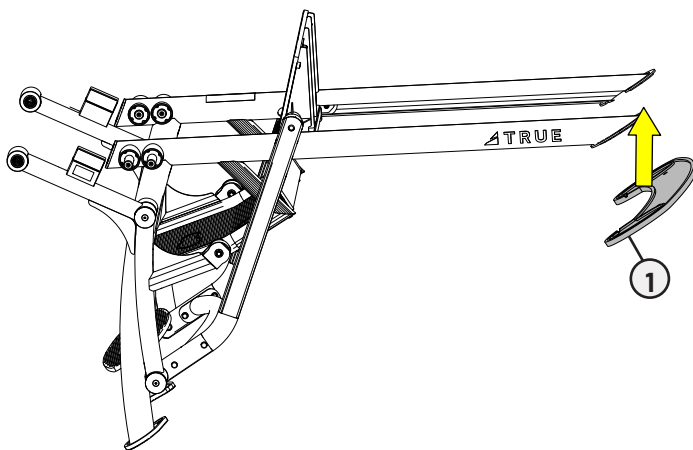
## STEP 5—ATTACH REAR FOOT PLATE

Tools Used in this Step	
5/32" Allen Wrench	

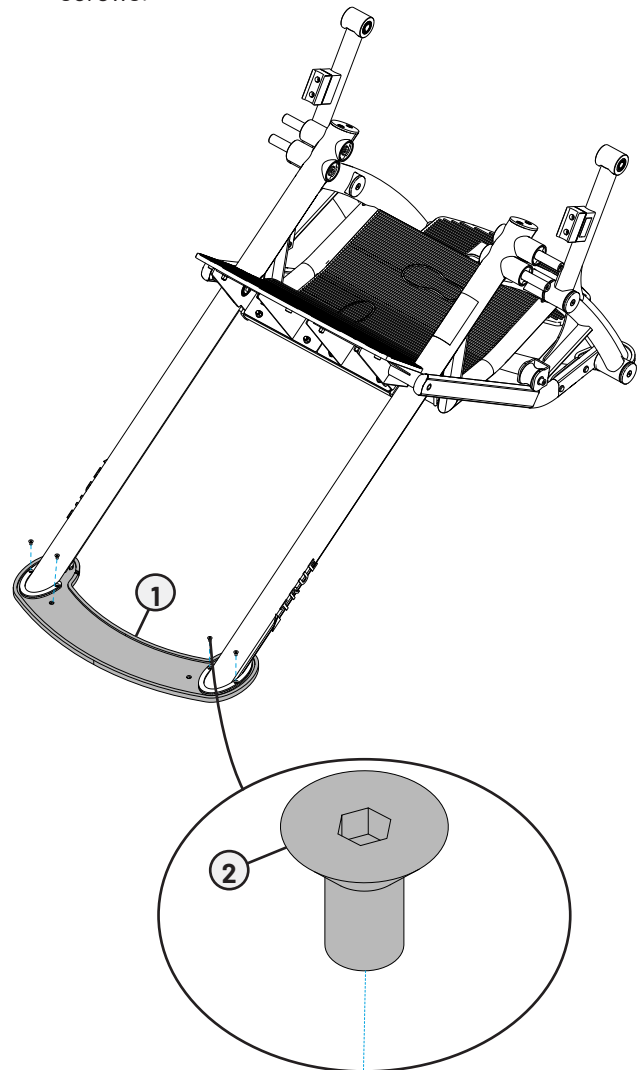
Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05CM100X-35	SUBASSEMBLY, REAR FOOT PLATE	1
2	C 959	FHCS, 1/4"-20 X 1/2"	4

- A. Rotate the main frame upwards and slide the rear foot plate into position under the left and right main frame.

**NOTE:** At least one person should hold the main frame, while the other aligns the rear foot plate into position.



- B. Rotate the main frame back down into its original position.
- C. Using a 5/32" allen wrench, attach the rear foot plate to the left and right main frame using 4 hex screws.

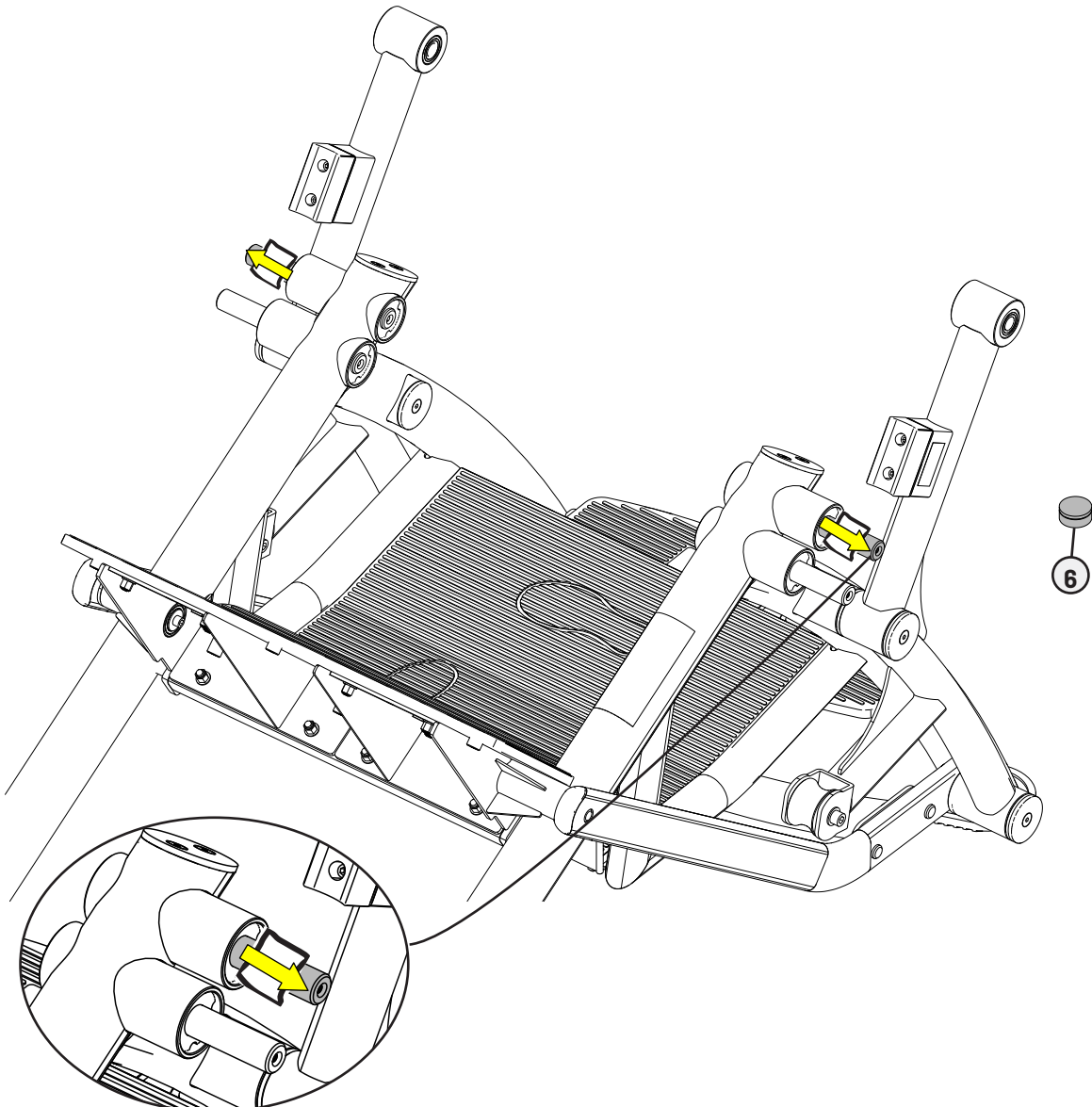


## STEP 6—ATTACH PLACARD ARMS

Tools Used in this Step	
7/32" Allen Wrench	
Cloth	

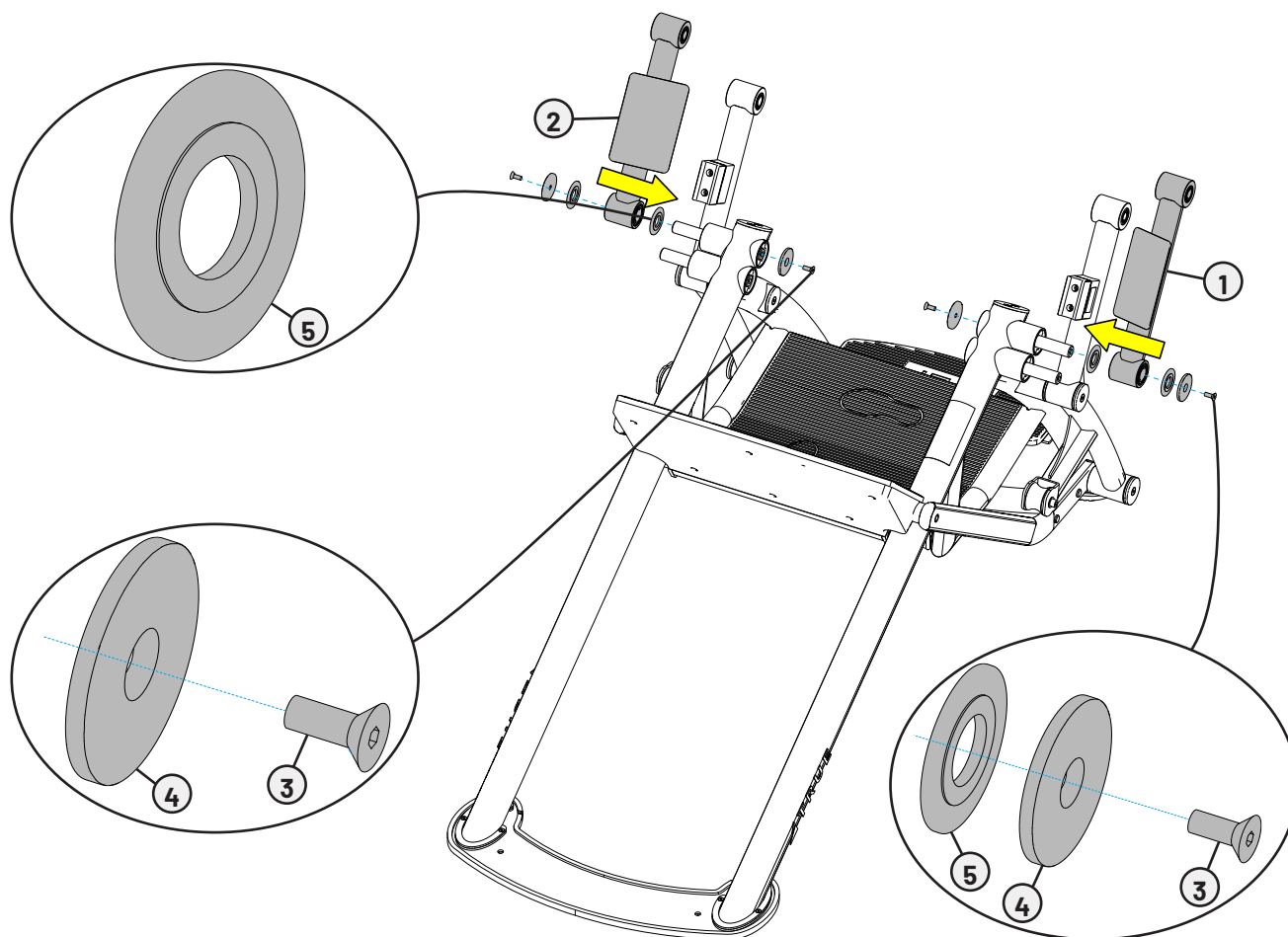
Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05LK200X-35	SUBASSEMBLY, RIGHT PLACARD ARM	1
2	SC05LK300X-35	SUBASSEMBLY, LEFT PLACARD ARM	1
3	C 658	FHCS, 3/8"-16 X 1"	4
4	SC10056500	SHAFT END CAP 70.2 X 6	4
5	COMP-SC10056000	WASHER 70.2 X 30.2 X 5	4
6	SC1005-3-003	ASSEMBLY LUBRICANT, PLS1700	1

- A. Wipe all dirt and dust from the main frame shafts before lightly applying the assembly lubricant. Apply the lubricant to a cloth or paper towel and use it to wipe down the shafts on each side.






## STEP 6—ATTACH PLACARD ARMS CONTINUED

- B. Using a 7/32" allen wrench, attach the left and right placard arms to the main frame using 4 hex screws, 4 shaft end caps, and 4 washers.

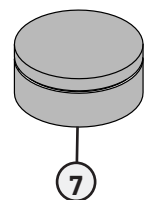
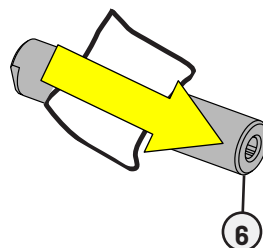
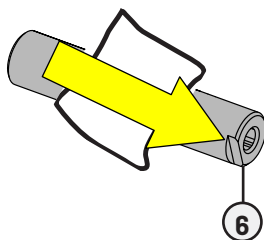
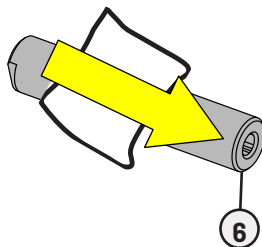
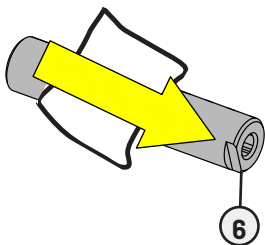


## STEP 7—ATTACH USER HANDLES

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

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05PA000X-35	USER HANDLE, RIGHT	1
2	SC05PA100X-35	USER HANDLE, LEFT	1
3	C 658	FHCS, 3/8"-16 X 1"	8
4	SC10056600	DECORATIVE CAP, BLACK ANODIZED	8
5	COMP-SC10056200	WASHER 70.2 X 20.2 X 5	8
6	SC10056400	CONNECTING ROD 20*97	4
7	SC1005-3-003	ASSEMBLY LUBRICANT, PLS1700	1

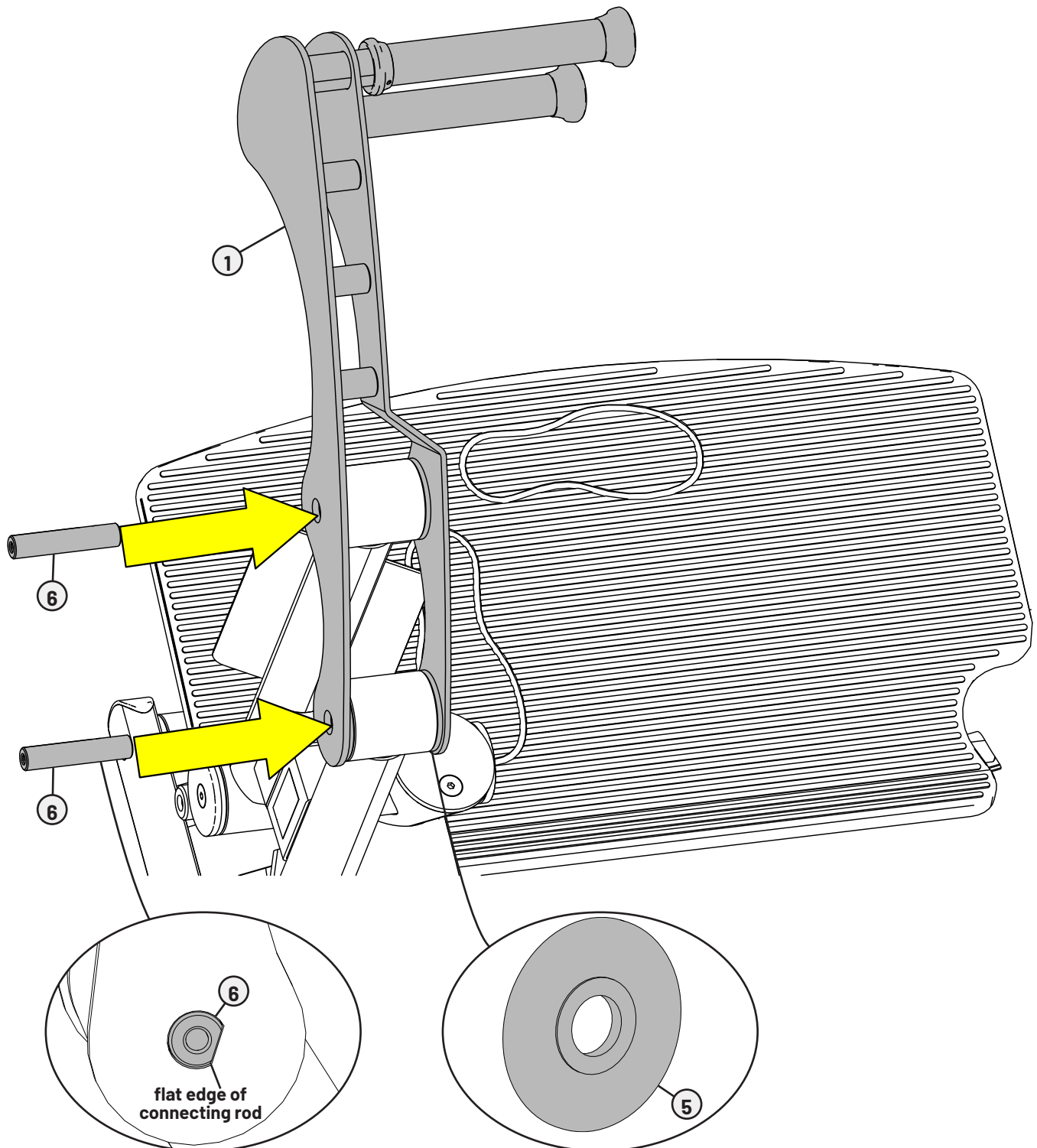
- A. Wipe all dirt and dust from the connecting rods before lightly applying the assembly lubricant. Apply the lubricant to a cloth or paper towel and use it to wipe down the 4 connecting rods.



## STEP 7—ATTACH USER HANDLES CONTINUED

- B. Align the user handles with the main frame.
- C. Line up the flat edges of the connecting rods with the user handles. Slide the 4 connecting rods through the user handles, using 8 washers on the inside of the user handles.
- D. Using a rubber mallet, lightly tap the connecting rods into the user handles.

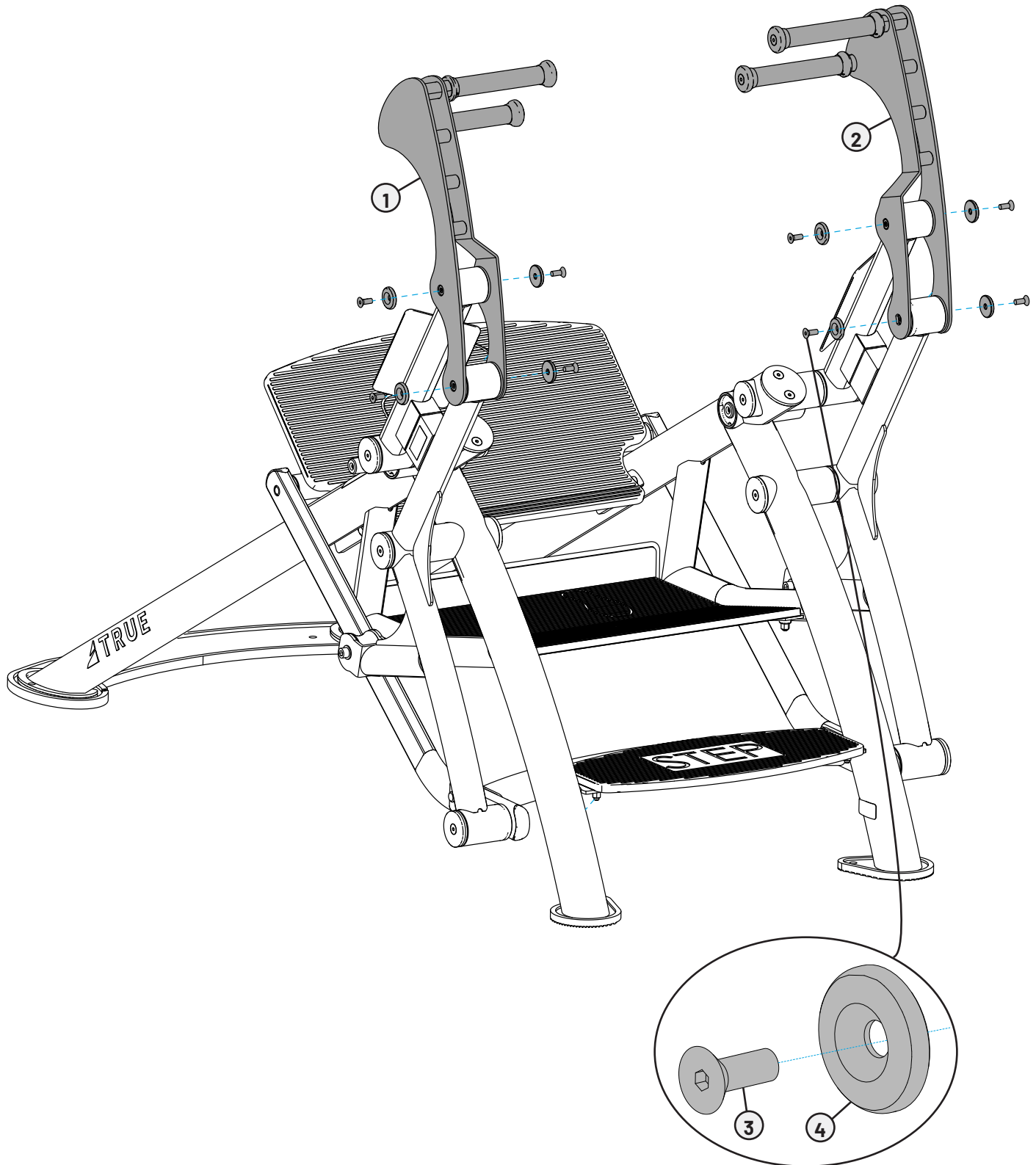
**NOTE:** At least one person should hold the user handles in place, while the other slides through the connecting rods.



## STEP 7—ATTACH USER HANDLES CONTINUED

E. Using a  $7/32$ " allen wrench, attach the left and right user handles to the main frame using 8 hex screws and 8 caps.

**NOTE:** At least one person should hold the user handles in place, while the installs the user handles.

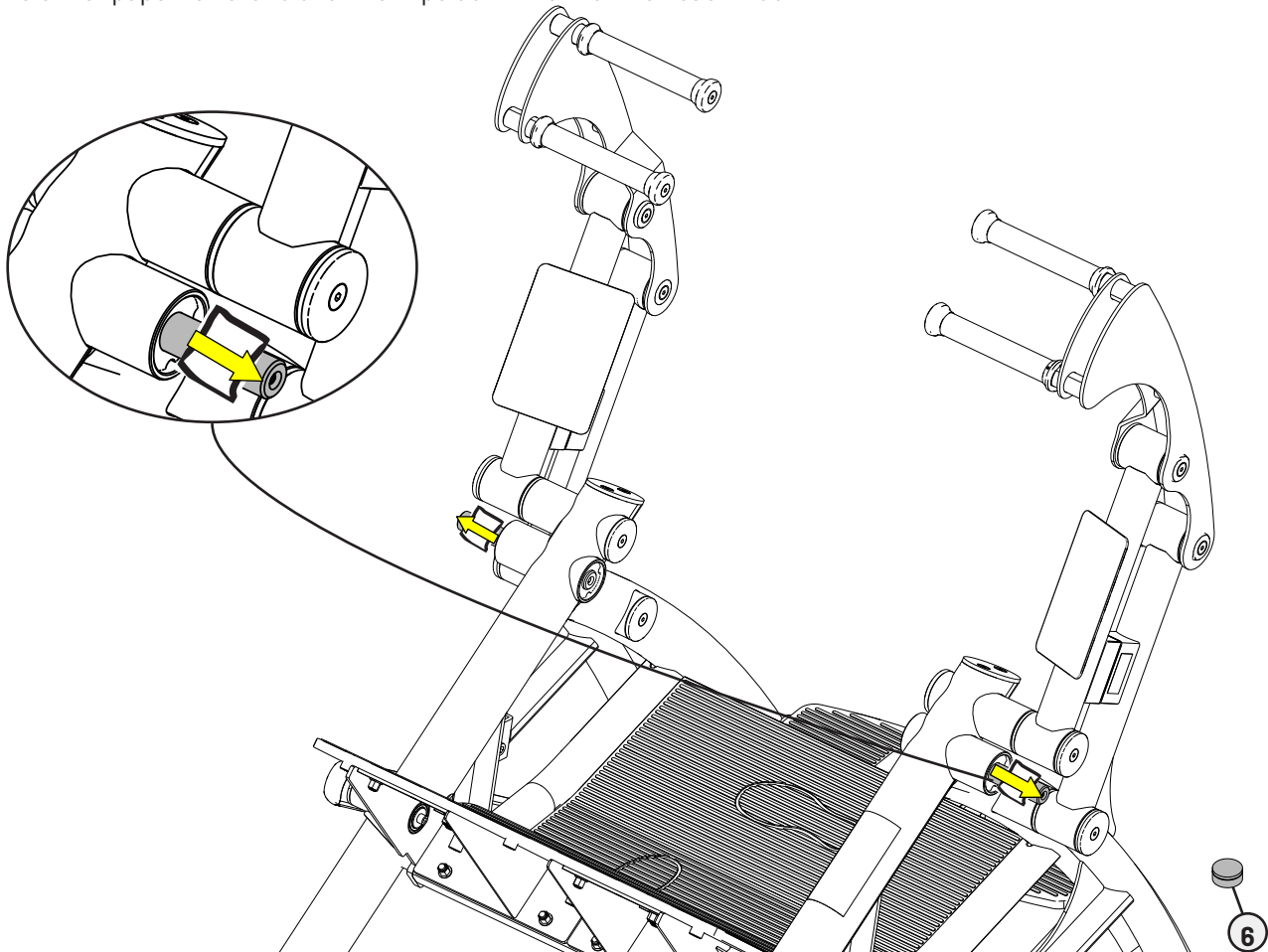


## STEP 8—ATTACH WEIGHT ARMS

Tools Used in this Step	
7/32" Allen Wrench	
Cloth	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05PA200X-35	WEIGHT ARM, RIGHT	1
2	SC05PA300X-35	WEIGHT ARM, LEFT	1
3	C 658	FHCS, 3/8"-16 X 1"	4
4	SC10056500	SHAFT END CAP 70.2 X 6	4
5	COMP-SC10056000	WASHER 70.2 X 30.2 X 5	4
6	SC1005-3-003	ASSEMBLY LUBRICANT, PLS1700	1

- A. Wipe all dirt and dust from the main frame shafts before lightly applying the assembly lubricant. Apply the lubricant to a cloth or paper towel and use it to wipe down the shafts on each side.

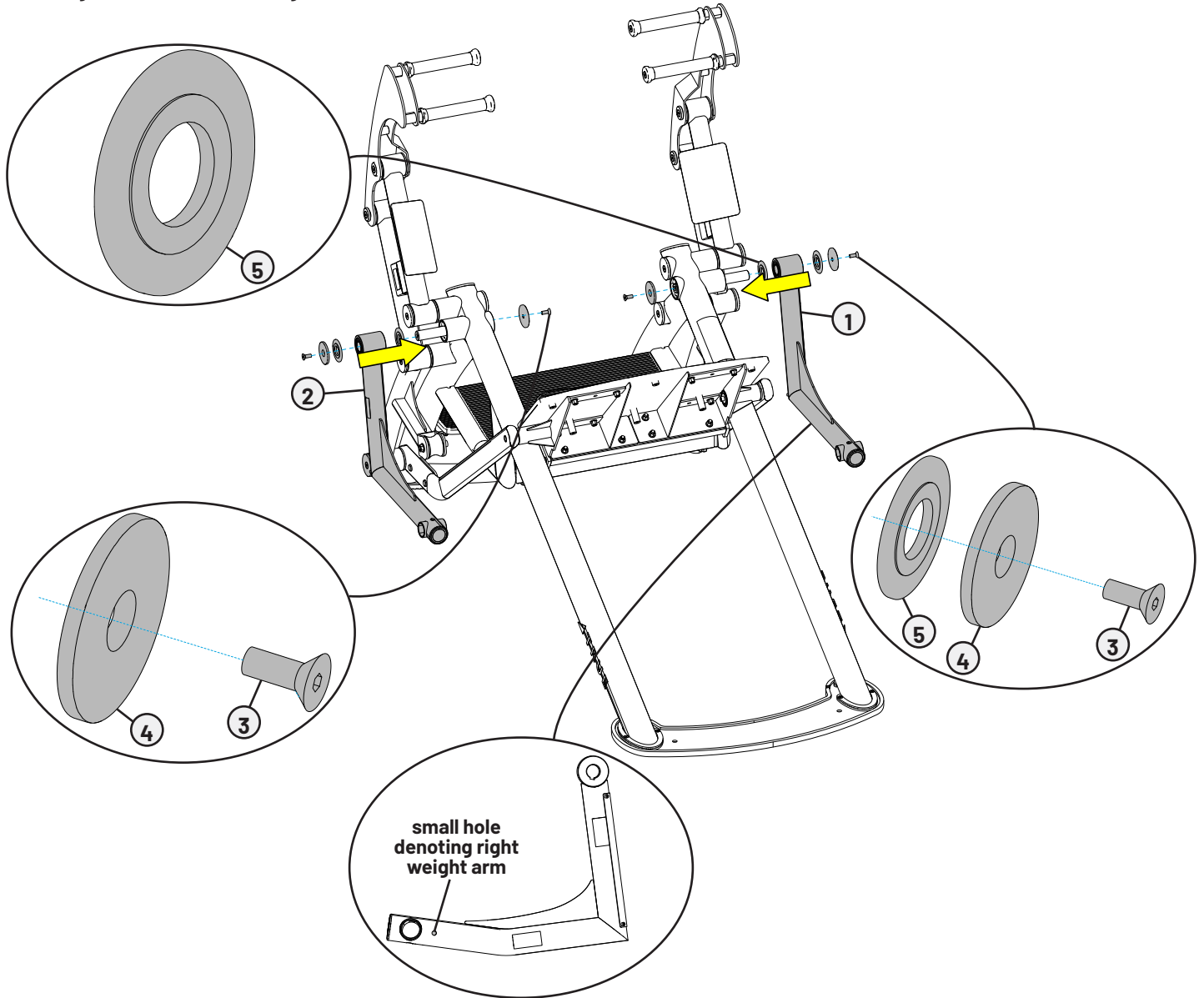




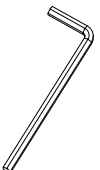

## STEP 8—ATTACH WEIGHT ARMS CONTINUED

B. Using a  $\frac{7}{32}$ " allen wrench, attach the left and right weight arms to the main frame using 4 hex screws, 4 shaft end caps, and 4 washers.

**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.



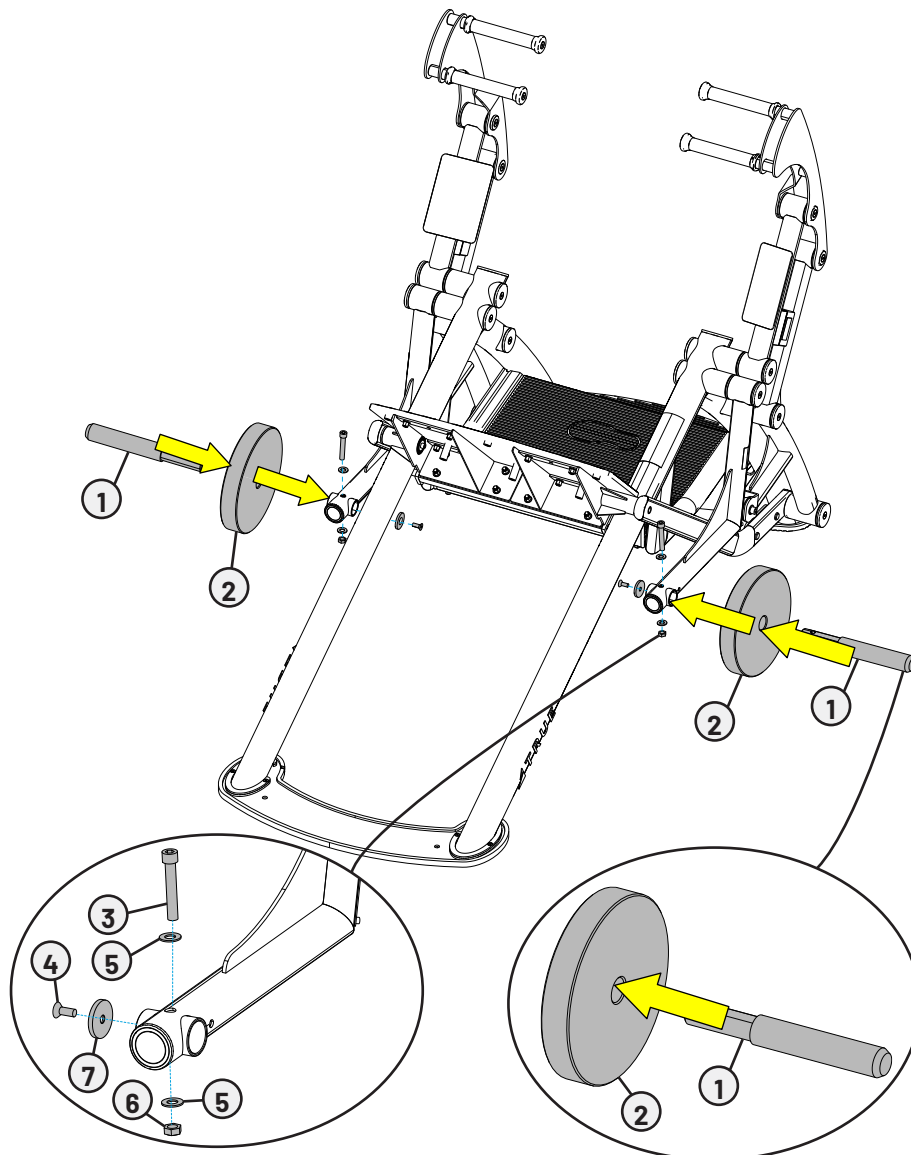
## STEP 9—ATTACH WEIGHT HORNS

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


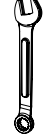
Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05MF700	WEIGHT HORN	2
2	CW65	65 LBS. COUNTER WEIGHT	2
3	C1015	SHCS 1/2"-13 X 3"	2
4	C 658	FHCS, 3/8"-16 X 1"	2
5	C 755B	WASHER, FLAT, 1/2" SAE Z.P.	4
6	C 766	LOCK NUT, 1/2"-13, NYL, JAM, ZP	2
7	SC10053800	SHAFT END CAP, 48 X 6	2

- Slide the weight horns through the counter weights and insert them into the left and right weight arms.
- Using a 3/8" allen wrench, a 3/4" open end wrench, and a 7/32" allen wrench,, attach the weight horns to the left and right weight arms using 2 socket head cap screws, 2 hex screws, 2 shaft end caps, 2 lock nuts, and 4 flat washers.

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

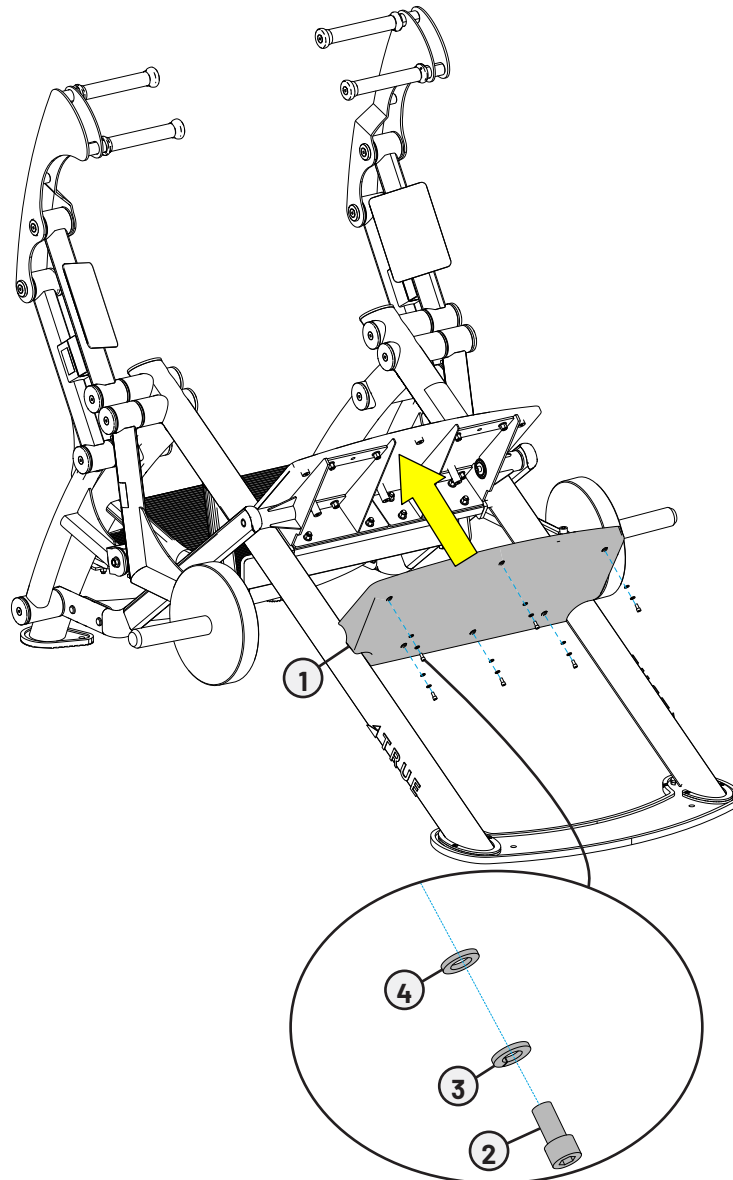


## STEP 10—ATTACH REAR COVER CARRIAGE

Tools Used in this Step	
3/16" Allen Wrench	
9/16" Wrench	

Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05MF700X	CARRIAGE, REAR COVER	1
2	C 607	SHCS, 1/4-20 X 1/2", ZP	6
3	C 747A	LOCK WASHER, 1/4 SPLIT, BLK	6
4	CC-36-011A	WASHER, FLAT, M6, BLK ZP	6

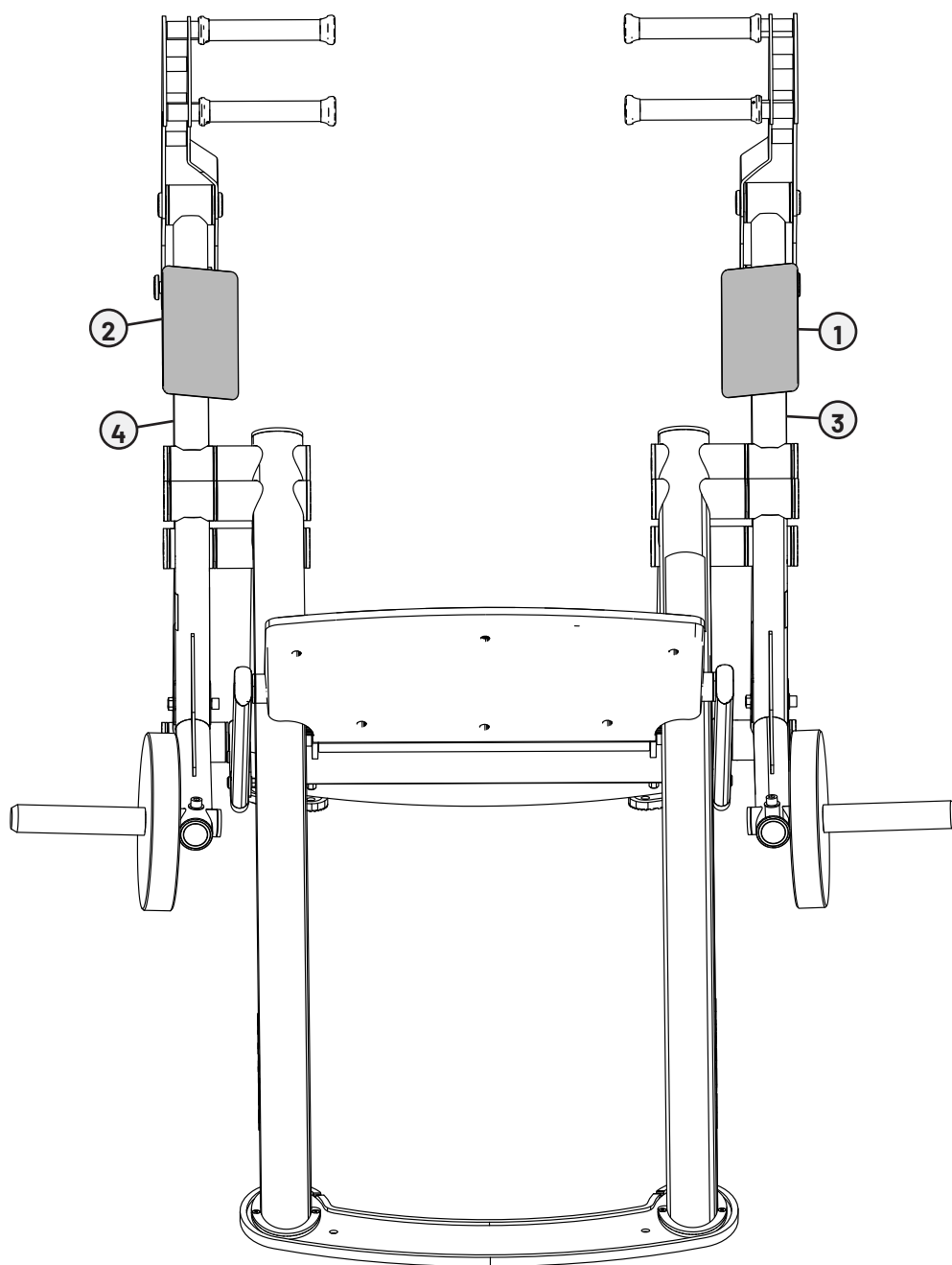
- A. Using a 9/16" wrench, fully tighten the main frame hardware from Step 1.
- B. Using a 3/16" allen wrench, attach the rear cover carriage to the foot pressing plate using 6 hex screws, 6 lock washers, and 6 flat washers.



## STEP 11—ATTACH PLACARD LABELS

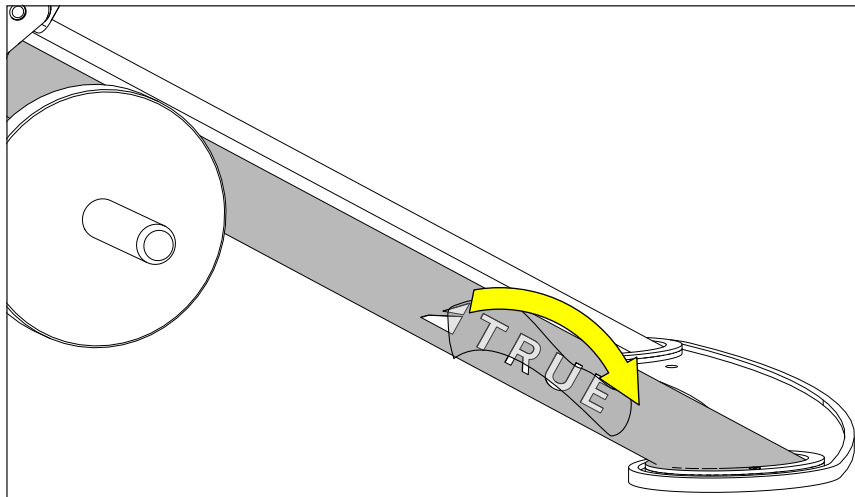
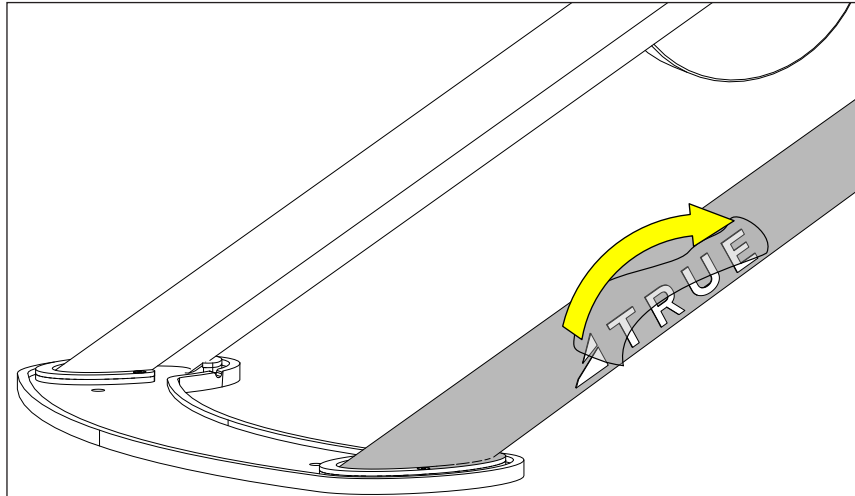
Parts Used in this Step			
ITEM	PART#	DESCRIPTION	QTY
1	SC05LK200X-35	SUBASSEMBLY, RIGHT PLACARD ARM	1
2	SC05LK300X-35	SUBASSEMBLY, LEFT PLACARD ARM	1
3	LBL-PRO-PLS1700R	PLS-1700 PLACARD RIGHT GLUTE EXERCISE	1
4	LBL-PRO-PLS1700L	PLS-1700 PLACARD LEFT THIGH EXERCISE	1

Attach the left and right placard labels to the corresponding placard arms.



## STEP 12—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 frame and chrome. (See cleaning the equipment.)
- Inspect all adjustment pins, set screws, and gas shocks if equipped.
- Inspect all safety and instructional decals.
- 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.

### 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, and plastic parts. 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

- **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.
- **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.

**⚠ 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

**ATTENTION OWNER'S:** To ensure you get the most out of your purchase and receive the full benefits of our warranty, you must register your product within 45 days of purchaser's receipt of this product.

### COMMERCIAL WARRANTY

#### CARDIO

WARRANTY ITEM	VAPOR, APEX	GRAVITY PLUS	GRAVITY	ADX, RO, SURGE
Frame*	7 Years (with registration)	7 Years (with registration)	7 Years (with registration)	5 Years (with registration)
Parts	3 Years	3 Years	3 Years	3 Years
Consoles	3 Years	3 Years	3 Years	2 Years
Labor**	2 Years (with registration)	2 Years (with registration)	1 Year (with registration)	1 Year (with registration)
Wear Items***	180 Days	180 Days	180 Days	90 Days

#### STRENGTH

WARRANTY ITEM	PALLADIUM, FUSE XL, FORCE, FITNESS LINE, ATLAS, XFT, XFW, MP, SM, FT, FS
Frame*	10 Years (with registration)
Parts	5 Years
Cables and Linear Bearings	1 Year
Labor**	1 Year (with registration)
Wear Items***	90 Days (6 Months for FORCE only)

#### FLEXIBILITY

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. Frame warranty will equal that of parts warranty unless, within 45 days of purchaser's receipt of this Product (A) the warranty is registered on-line or (B) if the form provided with equipment is filled in, signed by the original purchaser, and mailed to TRUE.

\*\*Labor warranty is available for equipment located within United States. TRUE Fitness equipment is automatically covered under a 6-month Limited Labor Warranty. This 6-month Limited Labor Warranty begins from the date of purchase shown by a valid receipt. If a valid receipt is not available, the 6-month Limited Labor Warranty period begins from the date of manufacture on the originally purchased equipment.

\*\*\*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 product registration requirements, terms, conditions, and complete coverage details.*



**ATTENTION OWNER'S:** To ensure you get the most out of your purchase and receive the full benefits of our warranty, you must register your product within 45 days of purchaser's receipt of this product.

## WARRANTY DETAILS

All TRUE Fitness products are distributed by TRUE and are warranted to the original product purchaser and the parts of the TRUE product (the "Product") listed below. During the applicable Warranty Period, the Product, under normal use and service, shall be free of manufacturing defects in workmanship and materials.

### 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).
- The "Warranty Period" for this limited warranty shall be for the duration forth in the applicable charts, beginning from the date of original purchase; provided, however, except to the extent prohibited by applicable law, the "Warranty Period" shall only be six months for labor (from the date of original purchase) unless, within 45 days of purchaser's receipt of this Product (A) the warranty is registered on-line or (B) if the form provided with equipment is filled in, signed by the original purchaser, and mailed to TRUE.
- 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.



**ATTENTION OWNER'S:** To ensure you get the most out of your purchase and receive the full benefits of our warranty, you must register your product within 45 days of purchaser's receipt of this product.

## WARRANTY REGISTRATION

Thank you for purchasing a TRUE product!

To ensure you get the most out of your purchase and receive the full benefits of our warranty, **you must register your product within 45 days of purchaser's receipt of this product.**

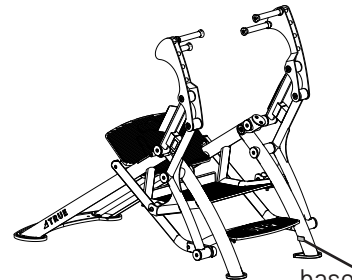
How to register your product:

- **Online:**  
Simply visit our website at [truefitness.com](http://truefitness.com) and register your product warranty in one simple step.
- **QR Code:**  
Scan the QR code below with your smartphone to be taken directly to the registration page.



- **By Mail:**  
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:**



base serial  
number location

**TRUE**  
TRUE FITNESS TECHNOLOGY, INC  
865 HOFF RD, ST LOUIS MISSOURI 63366 USA  
MODEL NO: PLSXXXX  
SERIAL NO: 25-PLSXX00000



### 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

