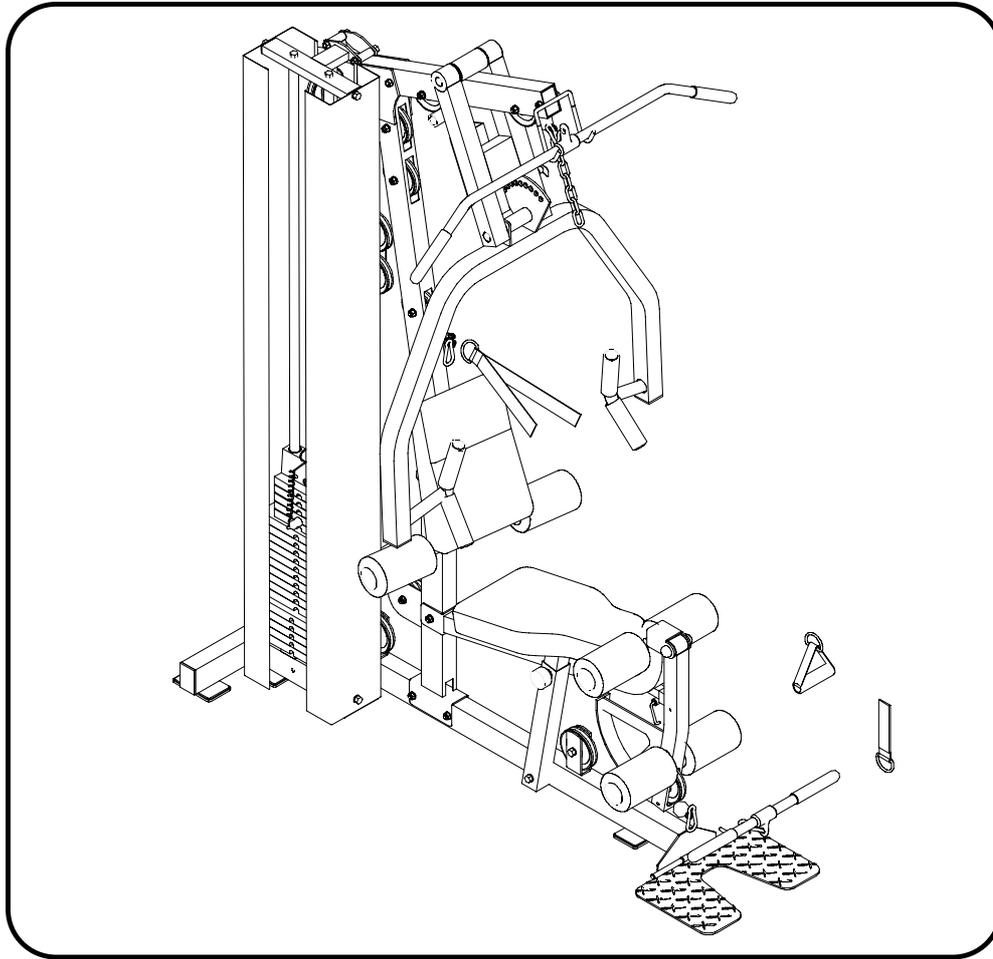


**POWER** **LIFETIME KEYS WARRANTY** **SYSTEM**



**KPS-1500**  
**HOME GYM 1500**



Questions?  
Call our toll free Keys Fitness Helpline  
**1-800-683-1236**

**keysfitness.com**

O W N E R ' S M A N U A L



THANK YOU for making this Power System unit a part of your exercise program. Keys Fitness and our Power System Series assures the very best in value, appearance, durability and biomechanics.

This manual will guide you through the assembly process. If at any time you are having trouble with the assembly or use of this product, then please contact us at our Keys Fitness Helpline. We have trained service technicians on site to take care of you, our valued customer.

---

#### REGISTRATION CARD

To avoid unnecessary delays in warranty parts and to insure that a permanent record of your purchase is on file with our company, be sure to send in the warranty registration card or register on-line at [www.keysfitness.com](http://www.keysfitness.com) within 10 days of purchase.

---

POWER SYSTEM SERIES

MODEL: KPS-1500

**QUESTIONS?**

**CALL**

**1-800-683-1236**

**Monday-Friday**

**8:30-5:30 Central Time**

***When calling please have the following product information available:***

- Product Series
- Model #
- Part Number
- Part Description

# BEFORE YOU START

Prior to assembly, remove components from the box and verify that all the listed parts were supplied.

---

## SAFETY INFORMATION WARNING!

Before using this unit or starting any exercise program, consult your physician. This is especially important for persons over the age of 35 and/or persons with pre-existing health problems. Keys Fitness Products LP assumes no responsibility for personal injury or property damage sustained by or through the use of this product.

It is the owner's responsibility to ensure that all users of this unit have read the Owner's Manual and are familiar with safety information and precautions.

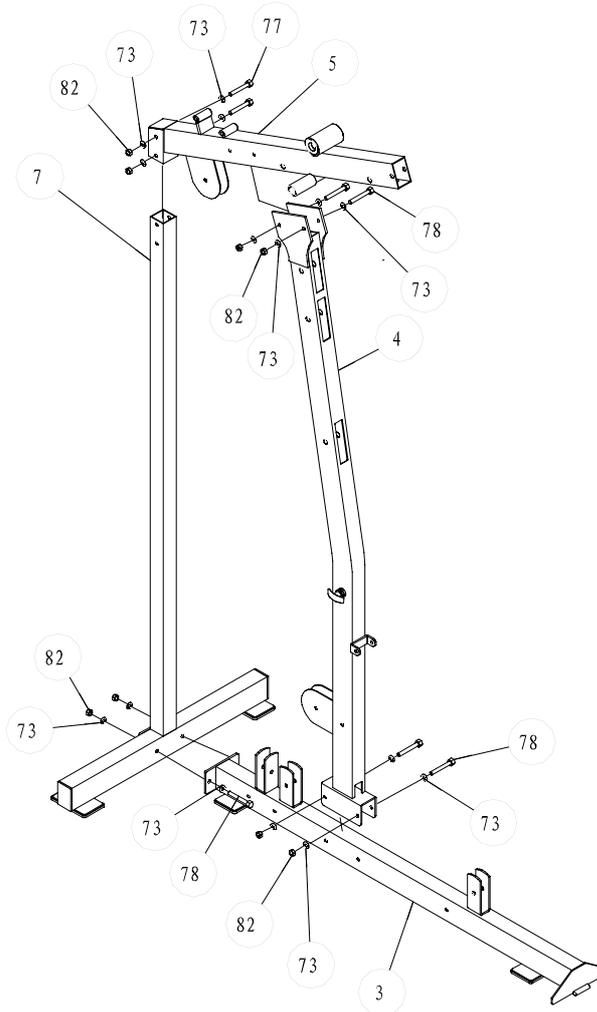
---

## SAFETY PRECATIONS

- This Power System unit should only be used on a level surface and is intended for indoor use only. Keys Fitness recommends an equipment mat be placed under the unit to protect the floor or carpet and for easier cleaning.
- Wear comfortable, good-quality walking or running shoes and appropriate clothing. Do not use this unit with bare feet, sandals, socks or stockings!
- Always examine your unit before using to ensure all parts are in working order.
- Do not leave children unsupervised near or on the unit.
- Service to your Power System unit should only be performed by an authorized service representative, unless authorized and/or instructed by a Keys Fitness technician. Failure to follow these instructions will void the warranty.

# ASSEMBLY

**NOTE: Hand tighten bolts and nylon nuts until machine is fully assembled.**



## STEP 1

Connect Base Frame (3) to Rear Upright (7) and Main Upright (4) using:

4 x (78) Bolt

8 x (73) Washer

4 x (82) Nylon Nut

Slide Main Top Frame down onto Rear Upright (7) and Main Upright (4) using:

2 x (77) Bolt

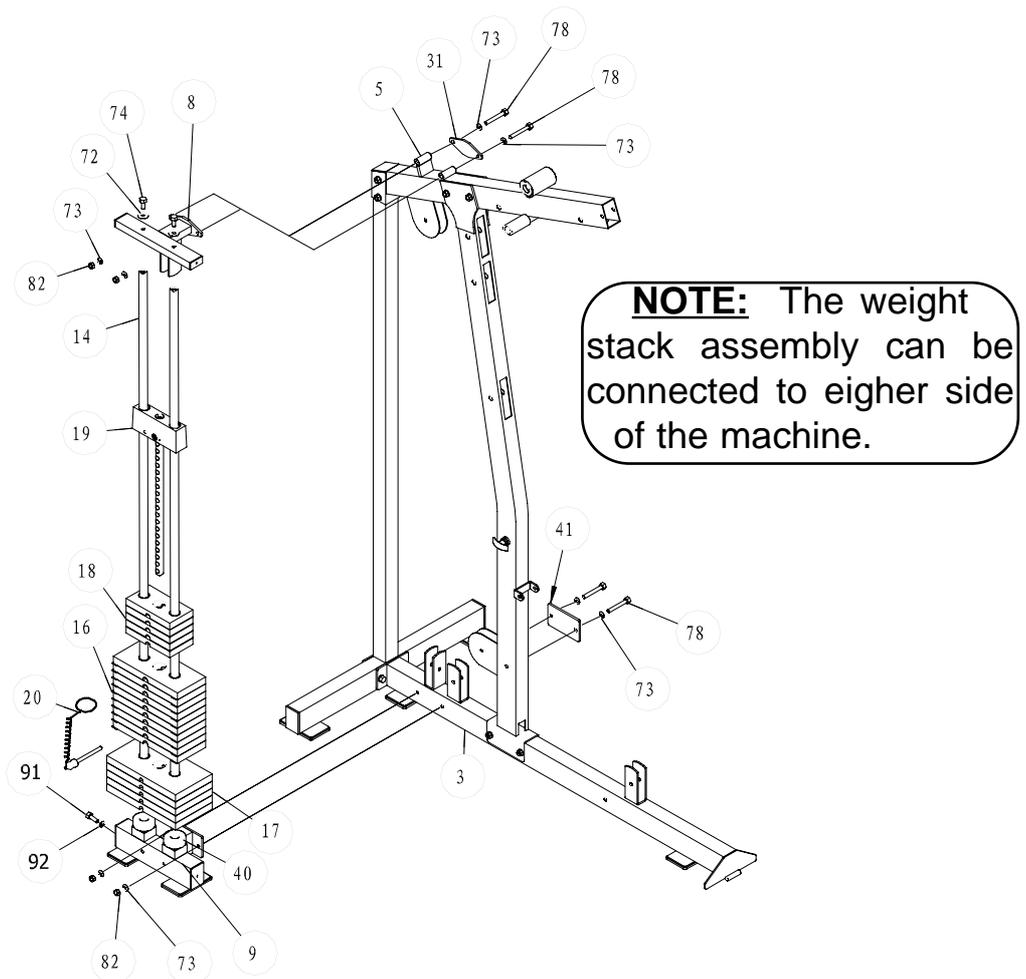
8 x (73) Washer

2 x (78) Bolt

4 x (82) Nylon Nut

# ASSEMBLY

**NOTE:** Hand tighten bolts and nylon nuts until machine is fully assembled.



## STEP 2

Attach Base Frame for Weight (9) to Base Frame (3) using:

- |                       |                    |
|-----------------------|--------------------|
| 1 x (41) Square Plate | 2 x (78) Bolt      |
| 4 x (73) Washer       | 2 x (82) Nylon Nut |

Screw Bolt (91) and Washer (92) into rear of Base Frame for Weight (9). Slide Guide Rods (14) down into Base Frame for Weight (4) and slide on the following:

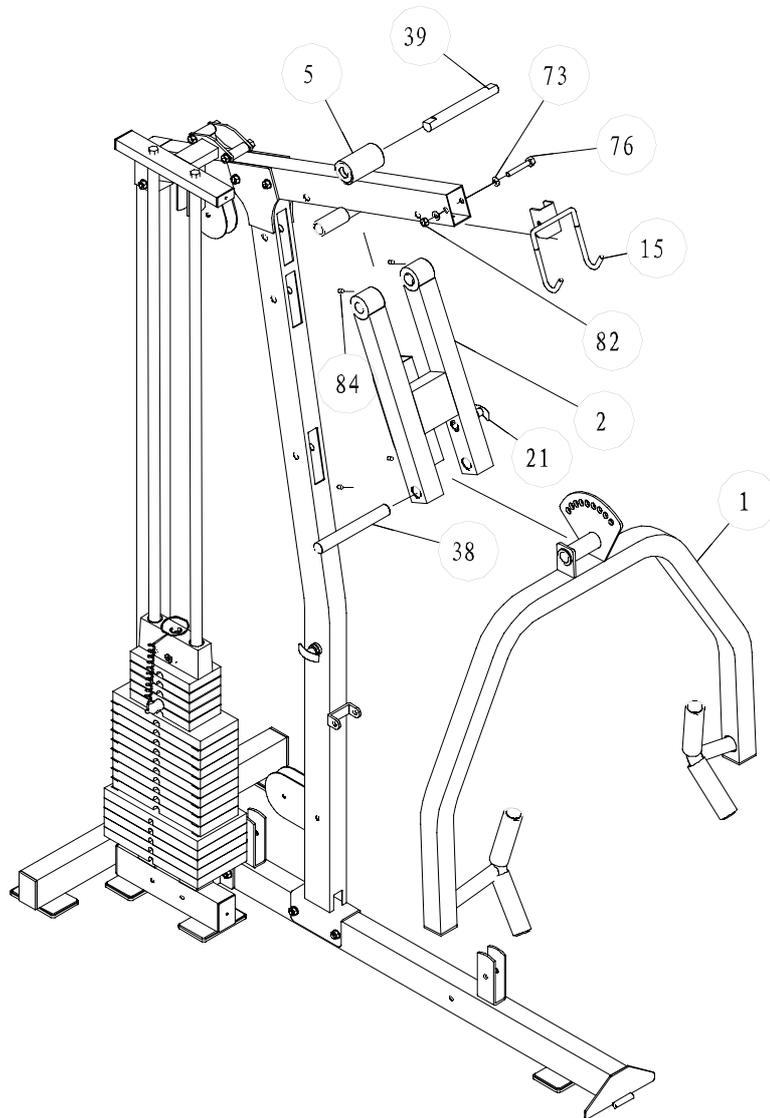
- |                              |                             |
|------------------------------|-----------------------------|
| 2 x (40) Weight Stack Bumper | 5 x (17) 15 lb plate        |
| 9 x (16) 10 lb plate         | 5 x (18) 5 lb plate         |
| 1 x (19) Top Plate           | 1 x (8) Top Guide Rod Frame |

Secure Guide Rods (14) to Top Guide Rod Frame (8) then connect to Main Top Frame using:

- |                 |                     |
|-----------------|---------------------|
| 2 x (74) Bolt   | 2 x (72) Big Washer |
| 1 x (31) Plate  | 2 x (78) Bolt       |
| 4 x (73) Washer | 2 x (82) Nylon Nut  |

# ASSEMBLY

**NOTE: Hand tighten bolts and nylon nuts until machine is fully assembled.**



## STEP 3

Secure Press Arm Support (2) to Main Top Frame (5) using:

1 x (39) Press Arm Shaft      2 x (84) Screw

Secure Press Arm (1) to Press Arm Support (2) using:

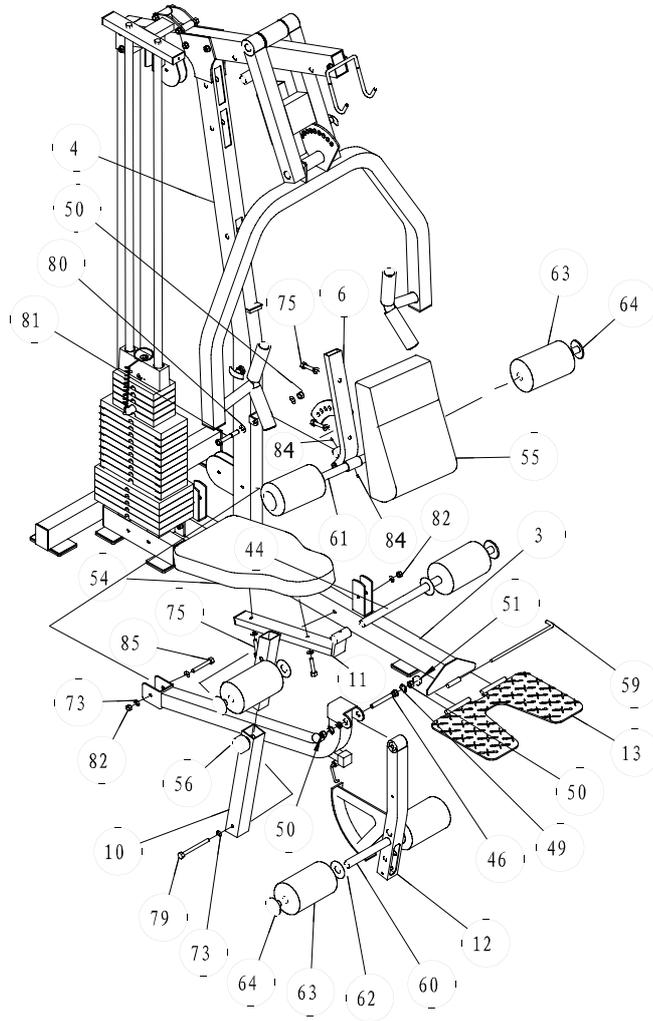
1 x (38) Press Arm Shaft      1 x (21) Long Pop Pin  
2 x (84) Screw

Connect Lat Bar Hook (15) to Main Top Frame (5) using:

1 x (76) Bolt                      2 x (73) Washer  
1 x (82) Nylon Nut

# ASSEMBLY

**NOTE: Hand tighten bolts and nylon nuts until machine is fully assembled.**



## STEP 4

Complete Back Pad (55) assembly using:

- |                             |                       |
|-----------------------------|-----------------------|
| 1 x (6) Back Pad Support    | 2 x (75) Bolt         |
| 1 x (81) Bolt               | 2 x (80) Washer       |
| 1 x (50) Nylon Nut          | 1 x (21) Long Pop Pin |
| 1 x (61) Long Foam Tube     | 2 x (84) Screw        |
| 2 x (63) Upholstered Roller | 2 x (64) Big Plug     |

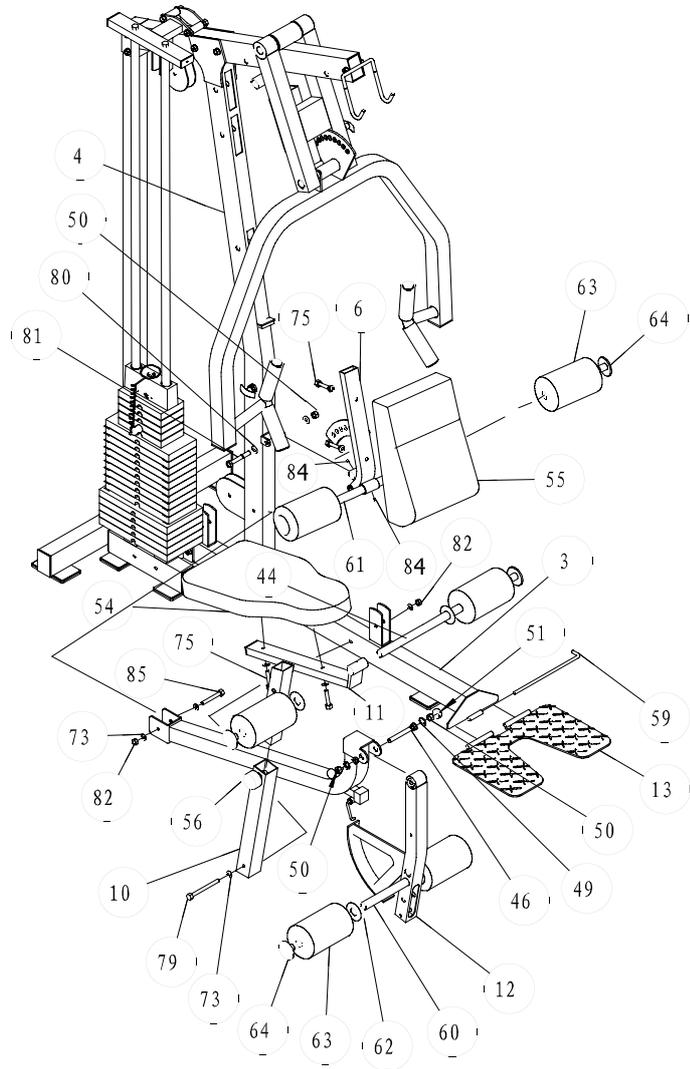
Complete Seat Pad (54) and Frame connection using:

- |                              |                    |
|------------------------------|--------------------|
| 1 x (10) Seat Pad Receptacle | 1 x (78) Bolt      |
| 4 x (73) Washer              | 2 x (82) Nylon Nut |
| 1 x (79) Bolt                | 2 x (75) Bolt      |
| 1 x (11) Seat Pad Support    | 1 x (56) Pop Pin   |

**STEP 4 CONTINUED ON PAGE 6**

# ASSEMBLY

**NOTE: Hand tighten bolts and nylon nuts until machine is fully assembled.**



## STEP 4 (Continued)

Complete Leg Ext/Curl (12) to Seat Pad Receptacle (10) using:

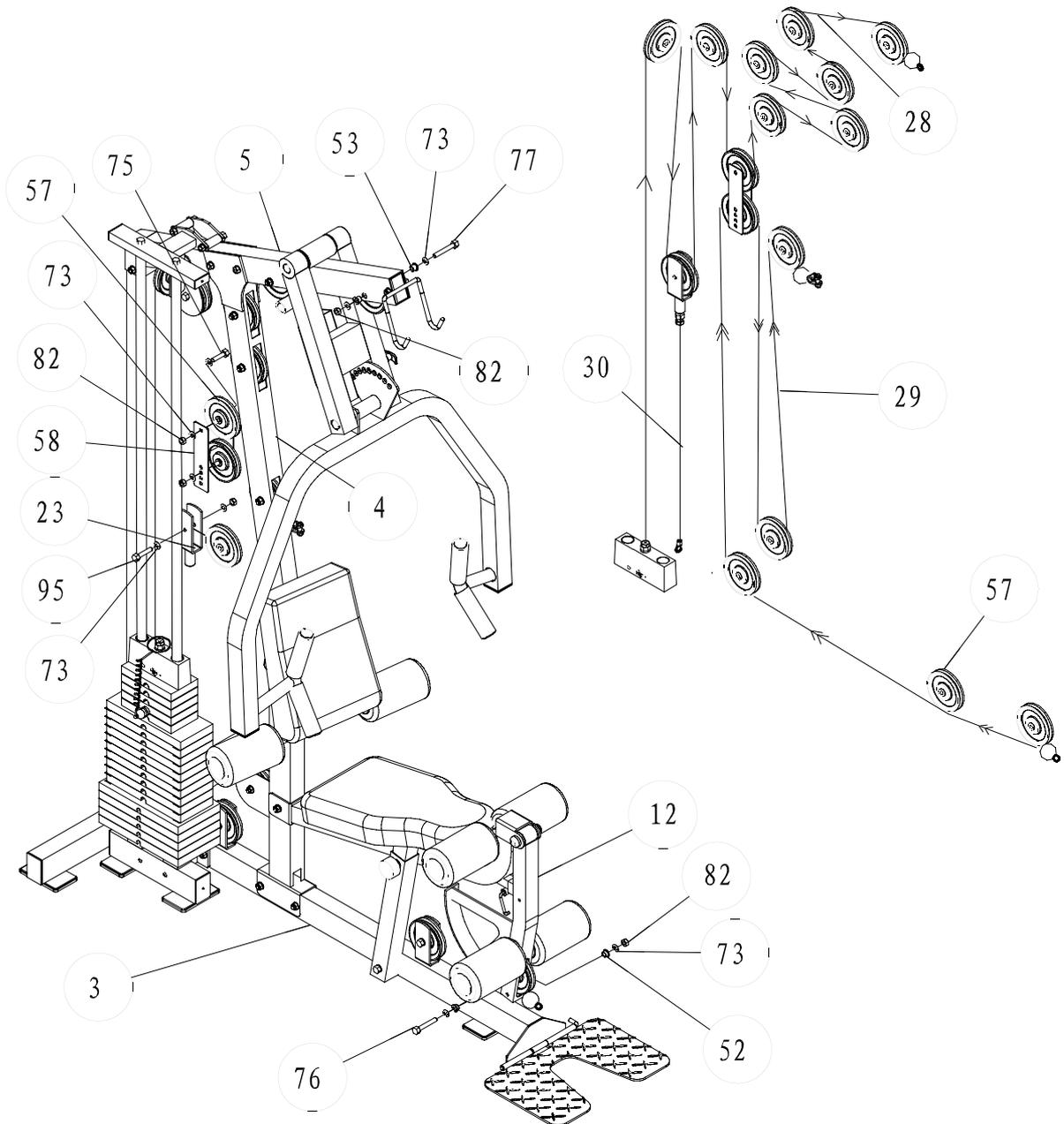
- |                              |                         |
|------------------------------|-------------------------|
| 2 x (51) Semi-Ball End Cap   | 2 x (50) Nylon Nut      |
| 1 x (46) Leg Extension Shaft | 2 x (49) Concave Washer |
| 2 x (60) Foam Tube           | 4 x (62) Plastic Washer |
| 4 x (63) Upholstered Roller  | 4 x (64) Big Plug       |
| 1 x (85) Screw               |                         |

Connect Foot Plate (13) to Base Frame (3) using:

- 1 x (59) Long "L" Pin

# ASSEMBLY

**NOTE: Hand tighten bolts and nylon nuts until machine is fully assembled.**

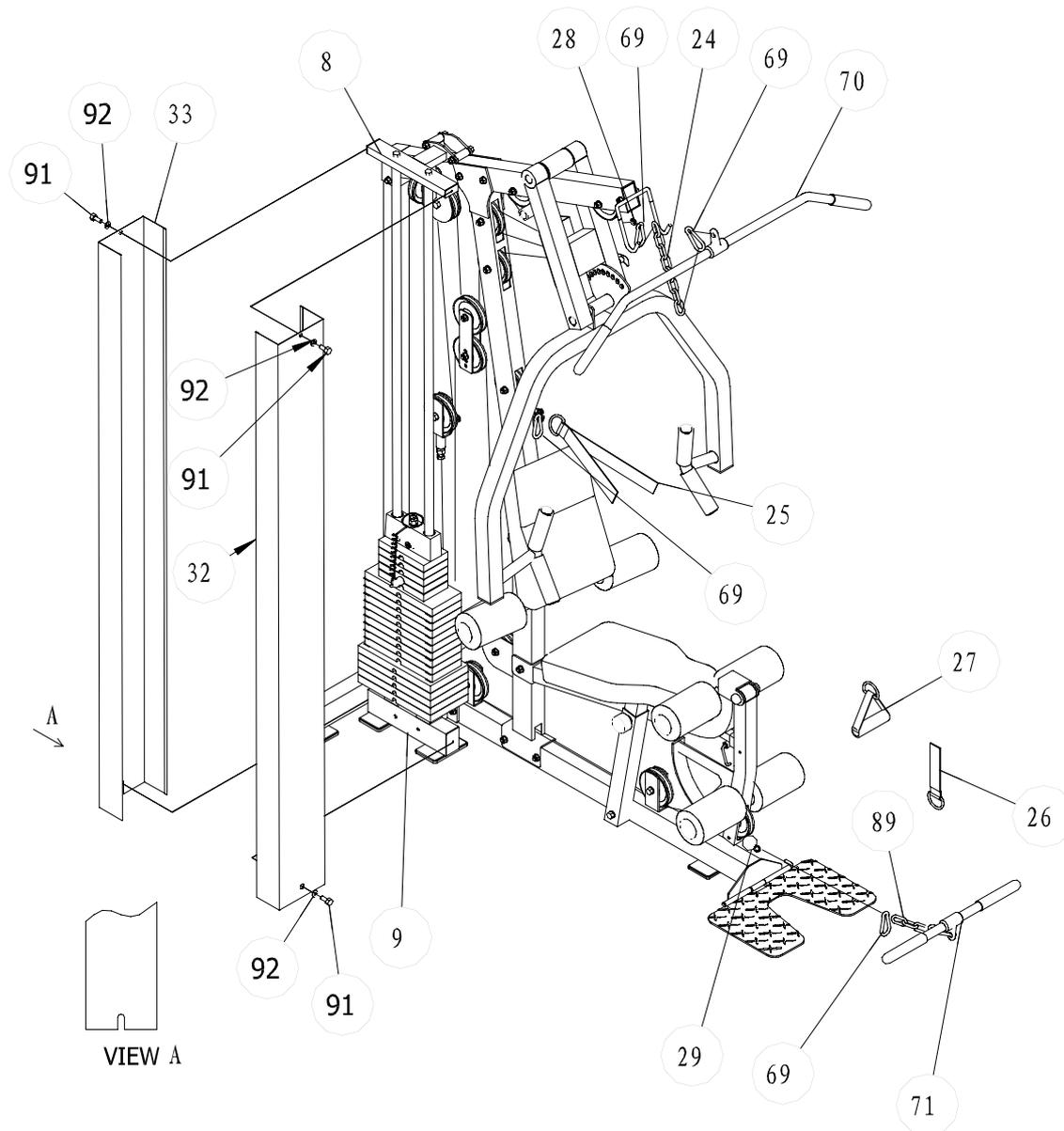


## STEP 5

Complete Cable (30,28,29) assembly using the following:

- |                               |                                  |
|-------------------------------|----------------------------------|
| 16 x (57) Pulley              | 16 x (82) Nylon Nut              |
| 10 x (53) Short Pulley Spacer | 2 x (52) Long Pulley Spacer      |
| 2 x (58) Pulley Plate         | 1 x (23) Pulley Bracket w/Spacer |
| 36 x (73) Washer              | 5 x (77) Bolt                    |
| 5 x (75) Bolt                 | 1 x (76) Bolt                    |
| 5 x (95) Bolt                 |                                  |

# ASSEMBLY



**TIGHTEN ALL BOLTS AND NUTS BEFORE PROCEEDING.**

## STEP 6

Slide Shroud w/Slot (33) down into bolt (View A) at rear of weight stack and secure to Top Guide Rod Frame (8) using:

1 x (91) Bolt

1 x (92) Washer

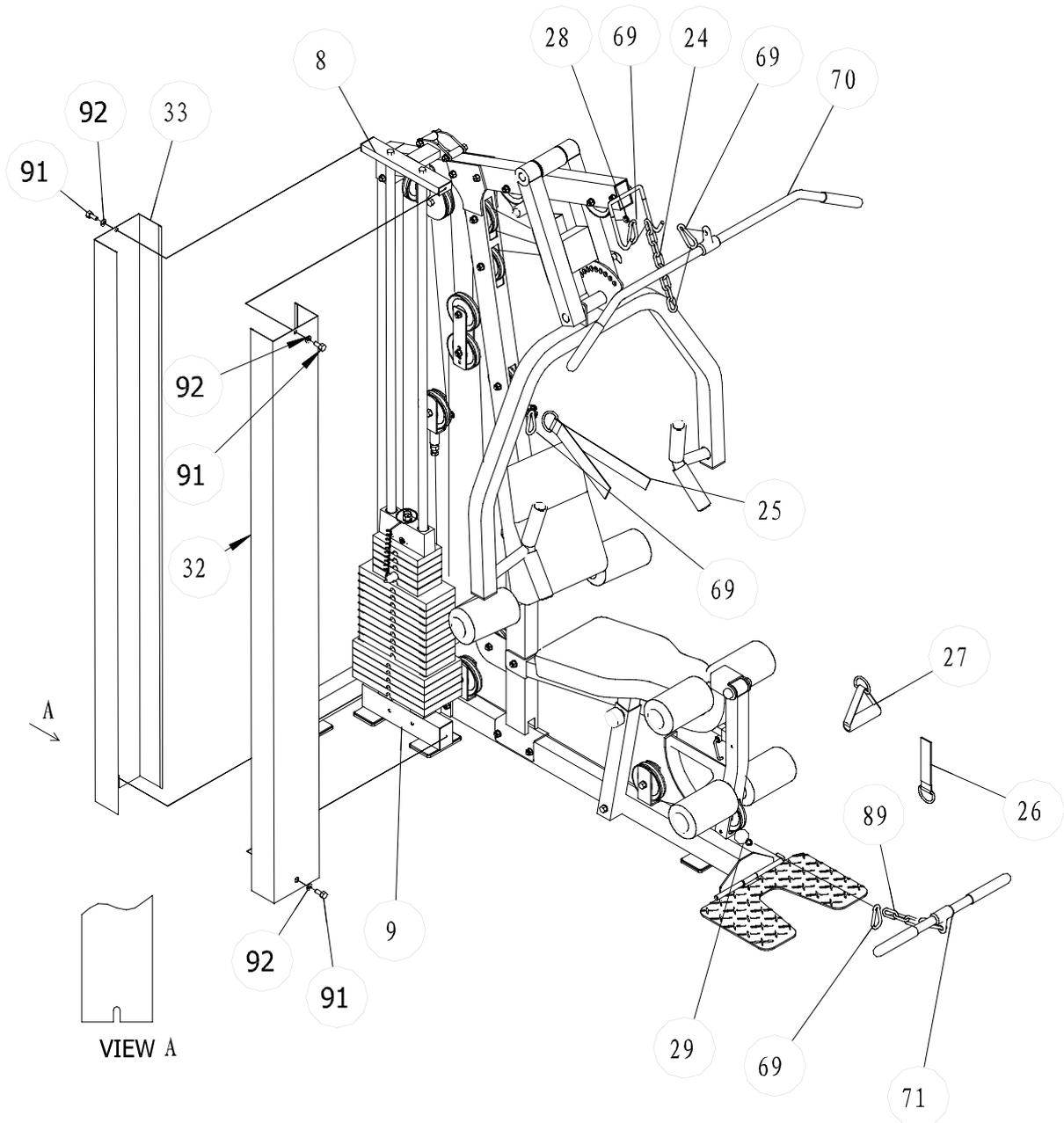
Secure Shroud (32) to Top Guide Rod Frame (8) and Base Frame for Weight (9) using:

2 x (91) Bolt

2 x (92) Washer

**STEP 6 CONTINUED ON PAGE 9**

# ASSEMBLY



## STEP 6 Continued

Connect attachments as pictured above for various exercises using:

- |                          |                              |
|--------------------------|------------------------------|
| 3 x (69) Gear Clip       | 1 x (24) Chain               |
| 1 x (89) Chain           | 1 x (70) Long Lat Bar        |
| 1 x (25) Abdominal Strap | 1 x (27) Single Handle Strap |
| 1 x (26) Ankle Strap     | 1 x (71) Short Bar           |

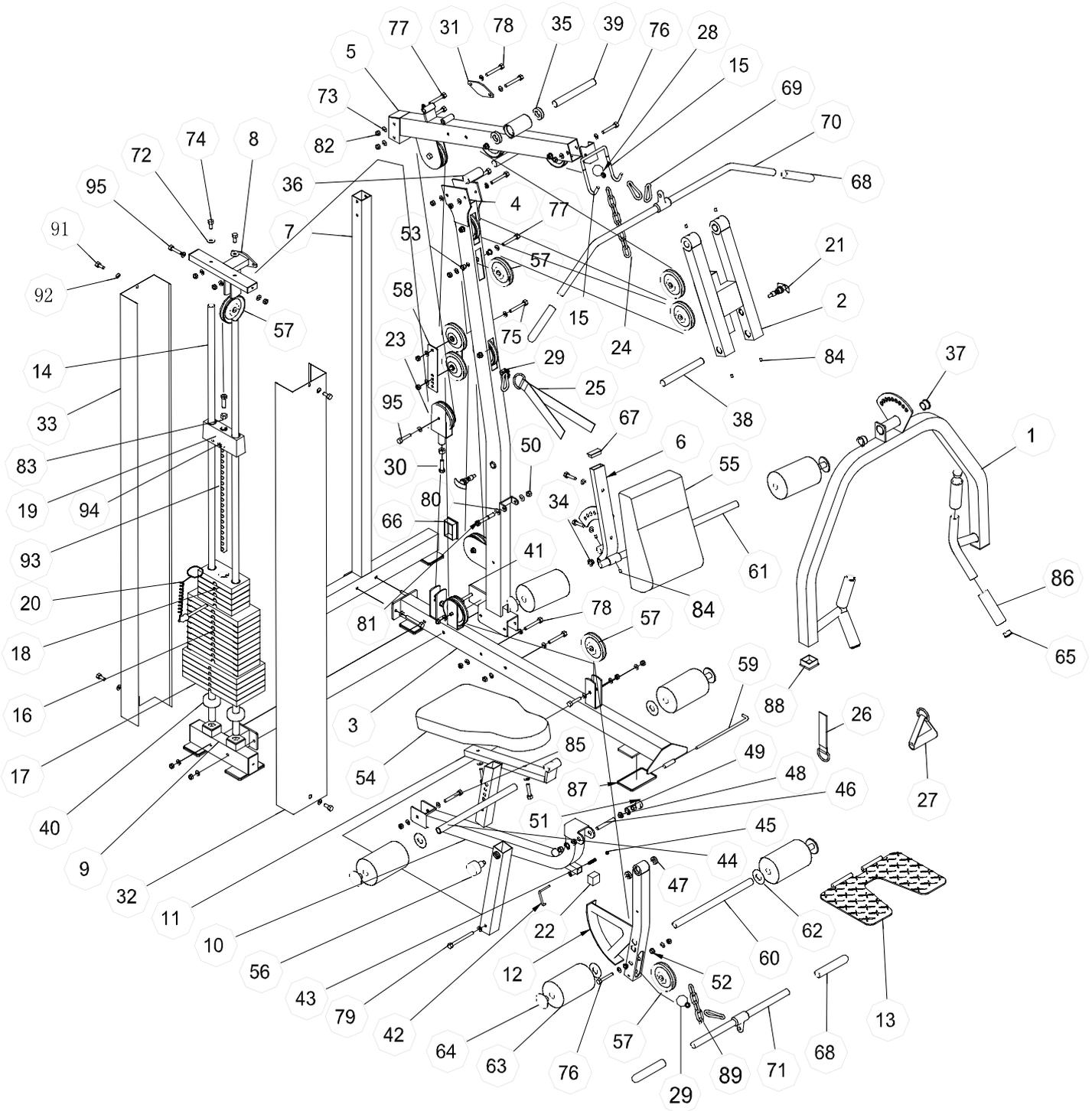
## PARTS LIST

<u>#</u>	<u>Description</u>	<u>Qty</u>	<u>#</u>	<u>Description</u>	<u>Qty</u>
1	Press Arm	1	46	Leg Extension Shaft	1
2	Press Arm Support	1	47	Bearing ID 12	2
3	Base Frame	1	48	Leg Extension Bushing	2
4	Main Upright	1	49	Concave Washer 12.5	2
5	Main Top Frame	1	50	Nylon Nut M12	3
6	Back Pad Support	1	51	Semi-Ball End Cap	2
7	Rear Upright	1	52	Long Pulley Spacer	2
8	Top Guide Rod Frame	1	53	Short Pulley Spacer	10
9	Base Frame for Weight	1	54	Seat Pad	1
10	Seat Pad Support Receptacle	1	55	Back Pad	1
11	Seat Pad Support	1	56	Pop Pin	1
12	Leg Extension/Curl	1	57	Pulley 4.5"	16
13	Foot Plate	1	58	Pulley Plate	2
14	Guide Rod	2	59	Long "L" Pin	1
15	Lat Bar Hook	1	60	Foam Tube	1
16	10lb Plate	9	61	Long Foam Tube	1
17	15lb Plate	5	62	Plastic Washer	4
18	5lb Plate	5	63	Upholstered Roller Pad	6
19	Top Plate	1	64	Big Plug 25	6
20	Weight Pin	1	65	Plug 32	4
21	Long Pop Pin	2	66	Plug 76.2x50.8	2
22	End Cap Bumper	1	67	Plug 25x50	2
23	Pulley Bracket w/Shaft	1	68	Lat Bar Grip	4
24	Chain 5	1	69	Gear Clip	5
25	Abdominal Strap	1	70	Long Lat Bar	1
26	Ankle Strap	1	71	Short Bar	1
27	Single Handle Strap	1	72	Big Washer	2
28	Chest Press Cable	1	73	Washer	72
29	Lower Pulley Cable	1	74	Bolt M10x25	2
30	Replacement - Leg Press Cable	1	75	Bolt M10x45	10
31	Plate	1	76	Bolt M10x65	2
32	Shroud	1	77	Bolt M10x70	7
33	Shroud w/Slot	1	78	Bolt M10x75	10
34	Bronze Bushing ID 12	2	79	Bolt M10x115	1
35	Bearing ID 25	2	80	Washer 12	2
36	Rubber Tube for Stop	2	81	Bolt M12x80	1
37	Bronze Bushing ID 25.4	2	82	Nylon Nut M10	32
38	Press Arm Shaft ADJ OD 25.4	1	83	Jam Nut 1/2"	2
39	Press Arm Shaft w/Gap OD 25	1	84	Screw M8	7
40	Weight Stack Bumper	2	85	Screw M6	1
41	Square Plate	1	86	Handle Grip	4
42	"U" Shape Pin	1	87	Base Pad	6
43	Small Spring	1	88	Plug 50.8x50.8	2
44	Washer 6	1	89	Chain 12	1
45	Nylon Nut M6	1	91	Bolt M8x25	4

# PARTS LIST

<b>#</b>	<b>Description</b>	<b>Qty</b>
92	Washer 8	4
93	Selector Rod	1
94	Screw Bolt M12x35	1
95	Bolt M10x50	5

# EXPLODED VIEW



# KEYS FITNESS PRODUCTS, L.P. POWER SYSTEM SERIES LIFETIME WARRANTY



This Warranty applies in the United States and Canada to products manufactured or distributed by Keys Fitness Products, LP ("Keys") under the KEYS brand name. The warranty period to the original purchaser is lifetime of the original purchaser.

Keys warrants that the Product you have purchased for non-commercial, personal, family, or household use from Keys or from an authorized Keys reseller is free from defects in materials or workmanship under normal use during the warranty period. Your sales receipt, showing the date of purchase of the Product, is your proof of purchase. This warranty only extends to you, the original purchaser. It is not transferable to anyone who subsequently purchases the Product from you.

It excludes expendable parts (wear items). Wear items pertain to components that might need to be replaced due to normal wear and tear. These items vary per product but will include grips, chains, cables, pads, upholstery, pulleys, bearings, etc. Please contact a Keys customer service representative for specifics on wear items. This Warranty becomes VALID ONLY if the product is purchased through a Keys Fitness authorized dealer unless otherwise authorized by Keys Fitness in writing and must be assembled / installed according to the instructions included with the Product.

During the warranty period Keys will repair or replace (at Keys' option) the product if it becomes defective, malfunctions, or otherwise fails to conform with this Warranty under normal use. In repairing the Product, Keys may replace defective parts, or at the option of Keys, serviceable used parts that are equivalent to new parts in performance. All exchanged parts and Products replaced under this warranty will become the property of Keys. Keys reserves the right to change manufacturers of any part to cover any existing warranty.

This warranty DOES NOT COVER shipping charges, export taxes, custom duties and taxes, or any other charges associated with transportation of the parts or Product. To obtain warranty service, you must contact a Keys authorized retailer, service technician or Keys Fitness at our phone number located in this manual. Any parts determined to be defective must be returned to Keys to obtain warranty service. You must prepay any shipping charges, export taxes, custom duties and taxes, or any other charges associated with transportation of the parts or Product. In addition, you are responsible for insuring any parts or Product shipped or returned. You assume the risk of loss during shipment. You must present Keys with proof-of-purchase documents (including the date of purchase). Any evidence of alteration, erasing or forgery of proof-of-purchase documents will be cause to void this Warranty.

This Warranty does not extend to any product not purchased from Keys or from an authorized Keys reseller. This Limited Warranty does not extend to any Product that has been damaged or rendered defective; (a) as a result of accident, misuse, or abuse; (b) by the use of parts not manufactured or sold by Keys; (c) by modification of the Product or normal wear and tear; (d) operation on incorrect power supplies; or (e) as a result of service by anyone other than Keys, or an authorized Keys warranty service provider. Product on which the serial number has been defaced or removed is not eligible for warranty service. Should any Product submitted for warranty service be found ineligible, an estimate of repair cost will be furnished and the repair will be made if requested by you upon Keys' receipt of payment or acceptable arrangements for payment.

EXCEPT AS EXPRESSLY SET FORTH IN THIS WARRANTY, KEYS MAKES NO OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. KEYS EXPRESSLY DISCLAIMS ALL WARRANTIES NOT STATED IN THIS LIMITED WARRANTY. ANY IMPLIED WARRANTIES THAT MAY BE IMPOSED BY LAW ARE LIMITED TO THE TERMS OF THIS LIMITED WARRANTY. NEITHER KEYS NOR ANY OF ITS AFFILIATES SHALL BE RESPONSIBLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS OR THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATIONS OR EXCLUSION MAY NOT APPLY TO YOU. This Limited Warranty gives you specific legal rights and you may also have other rights that may vary from state to state. This is the only express warranty applicable to Keys-branded products. Keys neither assumes nor authorizes anyone to assume for it any other express warranty.

PLEASE SEND IN THE INCLUDED WARRANTY CARD OR REGISTER ON-LINE AT [www.keysfitness.com](http://www.keysfitness.com) WITHIN TEN (10) DAYS OF PURCHASE TO REGISTER YOUR UNIT WITH KEYS FITNESS PRODUCTS, LP. MAIL WARRANTY CARD TO: KEYS FITNESS PRODUCTS, PO BOX 551239, DALLAS, TX 75355



**Keys Fitness Products, L.P.**  
**4009 Distribution Drive, Suite 250**  
**Garland, Texas 75041**  
**Customer Service: 1-800-683-1236**

**keysfitness  com**