

NOTE:  
Please read all instructions  
carefully before using this  
product

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Model  
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Retain This  
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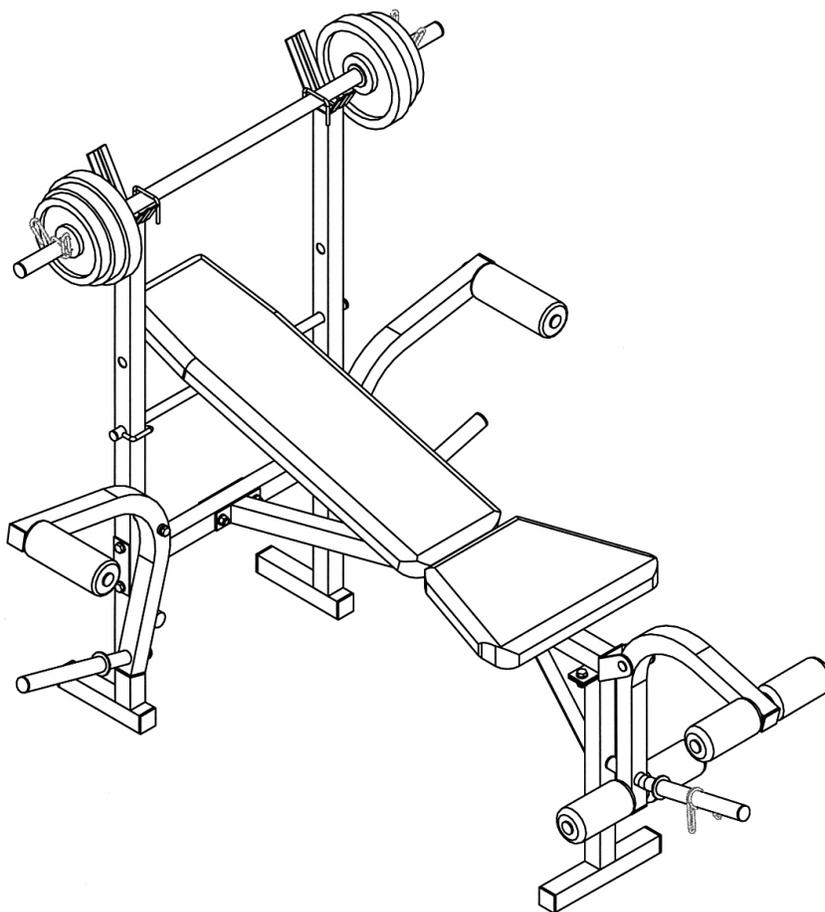
08-07-02

OWNER'S  
MANUAL

**IMPEx**  
FITNESS PRODUCTS

## POWERHOUSE BENCH

### PHC -265



### IMPEX FITNESS PRODUCTS

14777 DON JULIAN RD., CITY OF INDUSTRY, CA 91746

Tel: (800) 999-8899 Fax: (626) 961-9966

[www.impex-fitness.com](http://www.impex-fitness.com)

[info@impex-fitness.com](mailto:info@impex-fitness.com)

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## BEFORE YOU BEGIN

Thank you for selecting the POWERHOUSE PHC 265 BENCH by IMPEX FITNESS PRODUCTS. For your safety and benefit, read this manual carefully before using the machine. As a manufacturer, we are committed to provide you complete customer satisfaction. If you have any questions, or find there are missing or damaged parts, we guarantee you complete satisfaction through direct assistance from our factory. To avoid unnecessary delays, *please call our TOLL-FREE customer service number.* Our Customer Service Agents will provide immediate assistance to you.

**Toll-Free Customer Service Number**

**1-800-999-8899**

**Mon. - Fri. 9 a.m. - 5 p.m. PST**

**[www.impex-fitness.com](http://www.impex-fitness.com)**

**[info@impex-fitness.com](mailto:info@impex-fitness.com)**

## **IMPORTANT SAFETY NOTICE**

### **PRECAUTIONS**

This exercise machine is built for optimum safety. However, certain precautions apply whenever you operate a piece of exercise equipment. Be sure to read the entire manual before you assemble or operate your machine. In particular, note the following safety precautions:

1. **Keep children and pets away from the machine at all times. DO NOT leave children unattended in the same room with the machine.**
2. Only one person at a time should use the machine.
3. If the user experiences dizziness, nausea, chest pain, or any other abnormal symptoms, STOP the workout at once. CONSULT A PHYSICIAN IMMEDIATELY.
4. Position the machine on a clear, leveled surface. DO NOT use the machine near water or outdoors.
5. Keep hands away from all moving parts.
6. Always wear appropriate workout clothing when exercising. DO NOT wear robes or other clothing that could become caught in the machine. Running or aerobic shoes are also required when using the machine.
7. Use the machine only for its intended use as described in this manual. DO NOT use attachments not recommended by the manufacturer.
8. Do not place any sharp object around the machine.
9. Disabled person should not use the machine without a qualified person or physician in attendance.
10. Before using the machine to exercise, always do stretching exercises to properly warm up.
11. Never operate the machine if the machine is not functioning properly.
12. A spotter is recommended during exercise.

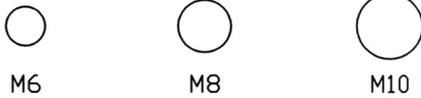
**WARNING: BEFORE BEGINNING ANY EXERCISE PROGRAM, CONSULT YOUR PHYSICIAN. THIS IS ESPECIALLY IMPORTANT FOR INDIVIDUALS OVER THE AGE OF 35 OR PERSONS WITH PRE-EXISTING HEALTH PROBLEMS. READ ALL INSTRUCTIONS BEFORE USING ANY FITNESS EQUIPMENT. IMPEX INC. ASSUMES NO RESPONSIBILITY FOR PERSONAL INJURY OR PROPERTY DAMAGE SUSTAINED BY OR THROUGH THE USE OF THIS PRODUCT.**

**SAVE THESE INSTRUCTIONS.**

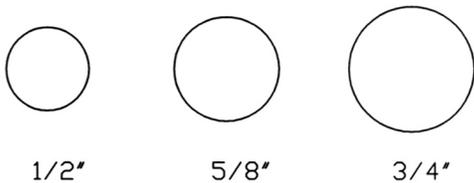
# HARDWARE IDENTIFIER

PLACE WASHER, END OF BOLT, OR SCREW ON CIRCLE TO CHECK FOR CORRECT SIZE.

## MILLIMETERS



## INCHES



## REPLACEMENT PARTS

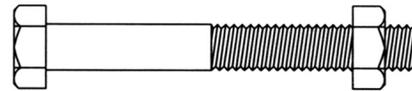
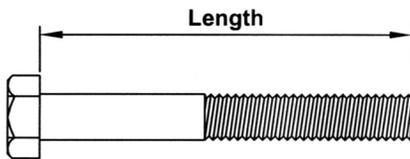
Thank you for purchasing IMPEX Product. Although we go to great effort to ensure the quality of our products, occasionally errors or omissions occur. Should you find either a defective or missing part in this product, please contact us for a replacement at the telephone number.

**QUESTION ?**

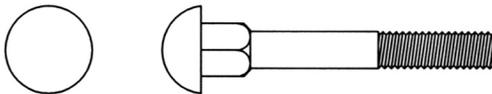


**1-800-999-8899**

**NOTE:** When installing a Aircraft Nut (also called Nylon or Lock Nut), Please use two adjustable wrenches to tighten down the Nut. Hold down the Bolt with one wrench, and use the other wrench to turn the Nut clockwise.



HEX HEAD BOLT



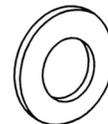
CARRIAGE BOLT



ALLEN BOLT



AIRCRAFT NUT



FLAT WASHER

# ASSEMBLY INSTRUCTION

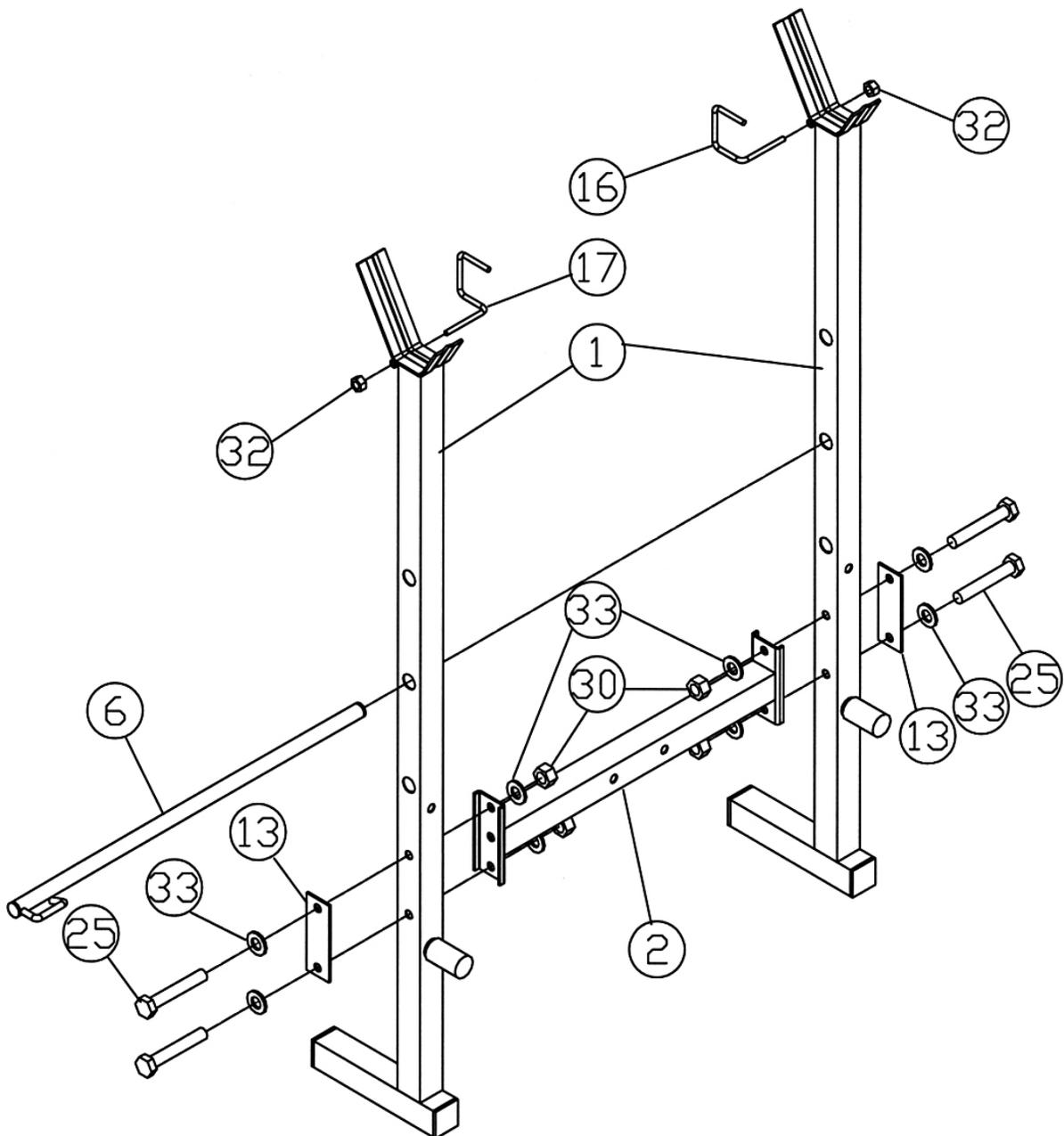
**Tools Required Assembling the Machine: Two Adjustable Wrenches.**

**NOTE:** It is strongly recommended two or more people assembling this machine to avoid possible injury.

## STEP 1 (See Diagram 1)

- A.) Connect the two Rear Upright Beams (#1) by the Cross Brace (#2) in the mid-span. Align the holes then secure each end of Cross Brace with one Bracket (#13), two M10 x 2 3/8" Hex Bolts (#25), four  $\varnothing \frac{3}{4}$ " Washers (#33), and two M10 Aircraft Nuts (#30).
- B.) Insert the Backrest Adjustment Bar (#6) through the selected holes on the Rear Upright Beams to obtain the desired Backrest incline.
- C.) Attach the Left and Right Safety Hooks (#16) & (#17) to the top of the Upright Beams. Secure each Hook with a M6 Aircraft Nut (#32).

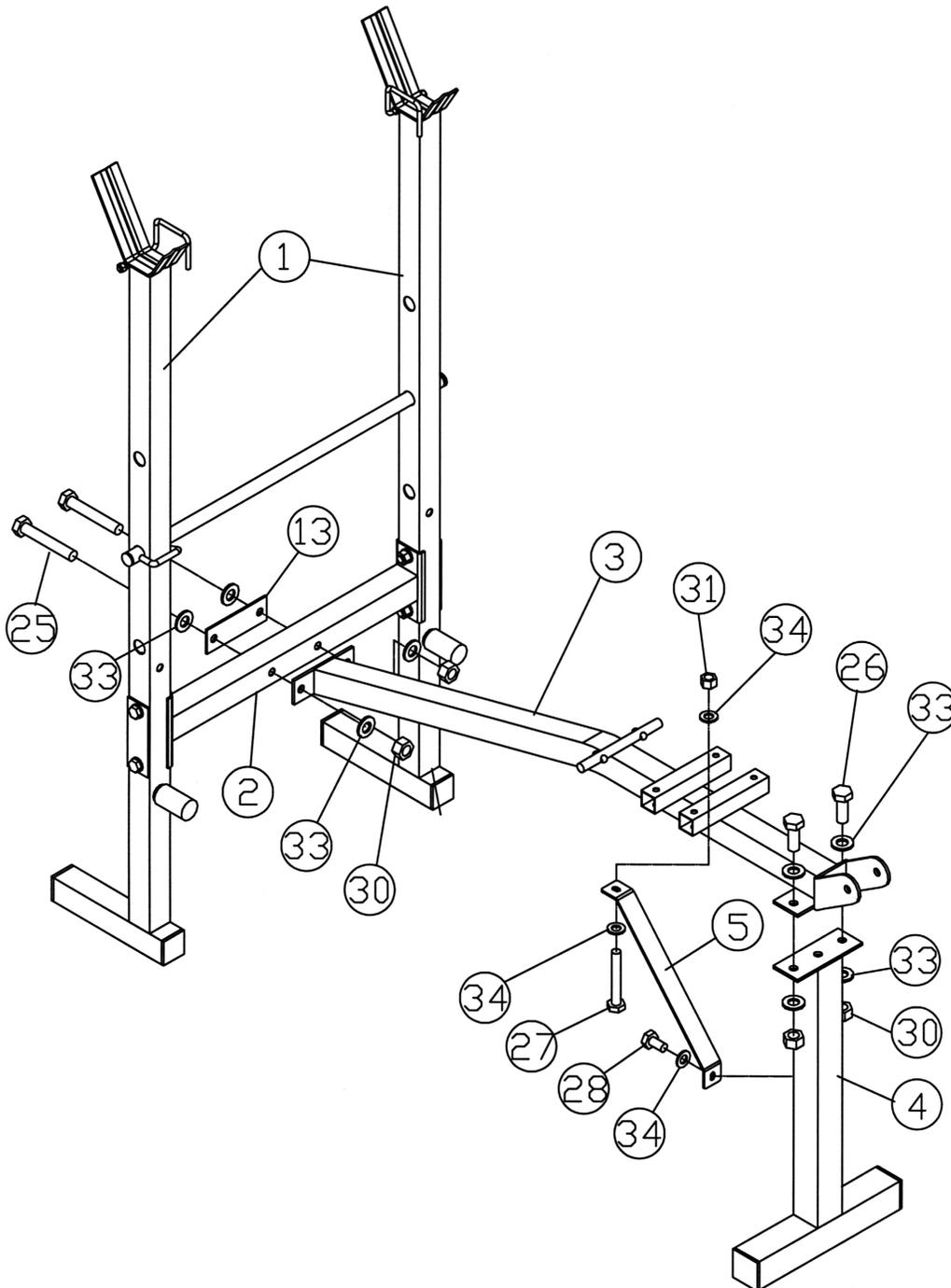
**DIAGRAM 1**



## STEP 2 (See Diagram 2)

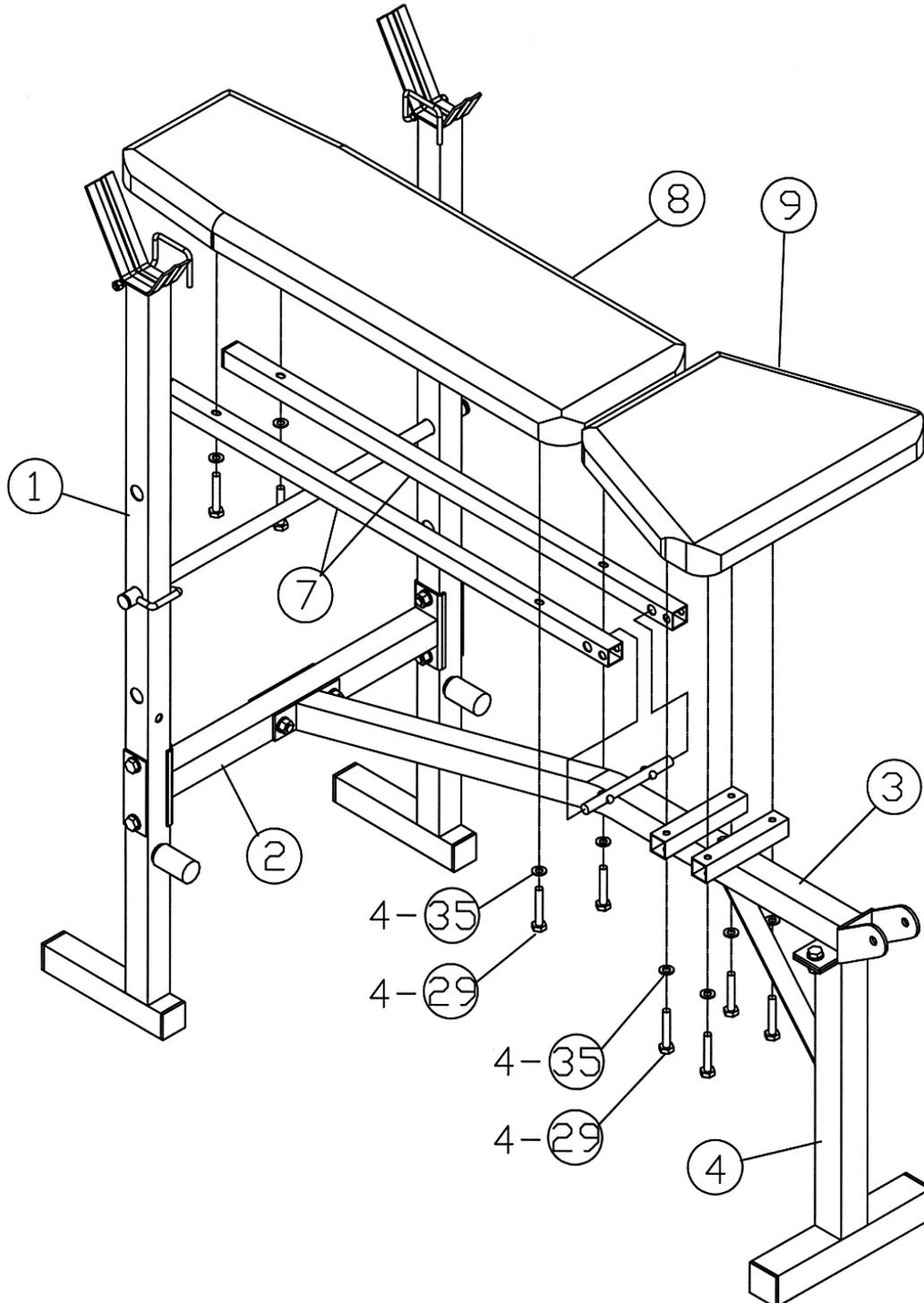
- A.) Attach the rear of the Main Seat Support (#3) to the Cross Brace (#2). Secure it with one Bracket (#13), two M10 x 2 3/8" Hex Bolts (#25), four  $\varnothing$  3/4" Washers (#33), and two M10 Aircraft Nuts (#30).
- B.) Attach the front of the Main Seat Support (#3) to the Front Support (#4). Secure them with two M10 x 1" Hex Bolts (#26), four  $\varnothing$  3/4" Washers (#33), and two M10 Aircraft Nuts (#30).
- C.) Attach one end of the Diagonal Support (#5) to the Main Seat Support (#3) and secure it with one M8 x 2 1/8" Hex Bolt (#27), two  $\varnothing$  5/8" Washers (#34), and one M8 Aircraft Nut (#31). Attach the other end of Diagonal Support (#5) to the Front Support (#4). Secure it with one M8 x 5/8" Hex Bolt (#28) and  $\varnothing$  5/8" Washer (#34).

## DIAGRAM 2



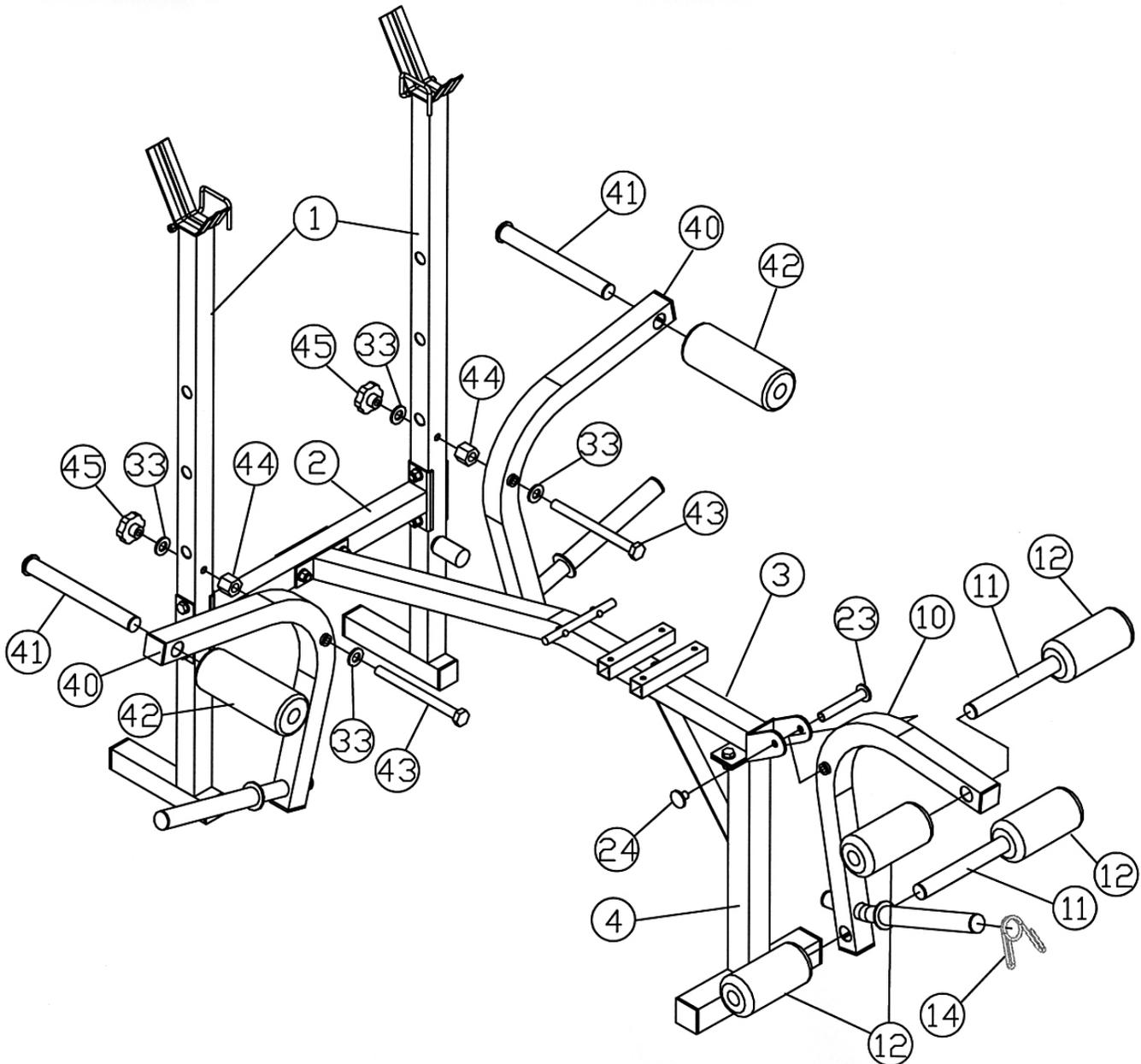
- A.) Attach the front holes on the Backrest Supports (#7) to the pivot on the Main Seat Support (#3). Place the other end of the Backrest Supports (#7) on the Backrest Adjustment Bar (#6). Place the Backrest Board (#8) onto the Backrest Supports (#7). Secure it with four M6 x 1 3/8" Hex Bolts (#29) and  $\varnothing$  1/2" Washers (#35).
- B.) Place the Seat Pad (#9) onto the Main Seat Support (#3). Secure it with four M6 x 1 3/8" Hex Bolts (#29) and  $\varnothing$  1/2" Washers (#35).

**DIAGRAM 3**



- A.) Attach the Leg Developer (#10) to the front of Main Seat Support (#3). Secure it with a Hex Socket Axle (#23) and Hex Socket Screw (#24). Attach one Spring Clip (#14) onto the weight post on the Leg Developer.
- B.) Insert the two Foam Roll Tubes (#11) halfway through the holes on the Leg Developer. Push four Foam Rolls (#12) onto the Foam Roll Tubes from both ends.
- C.) Attach a  $\text{\O}3/4$ " Washer (#33) onto a M10 x 4 1/2" Hex Bolt (#43). Insert the Bolt through the Butterfly (#40) and secure it with a M10 Regular Nut (#44). Insert the Bolt through the Upright Beam (#1) and secure it with a  $\text{\O}3/4$ " Washer (#33) and M10 Knob (#45).
- D.) Insert the Butterfly Foam Roll Tube (#41) through the hole on the Butterfly. Push the Butterfly Foam Roll (#42) onto the Tube.
- E.) Repeat Step C & D above to install the other side.

**DIAGRAM 4**





## PARTS LIST

KEY NO.	DESCRIPTION	Q'ty
1	Rear Upright Beam	2
2	Cross Brace	1
3	Main Seat Support	1
4	Front Support	1
5	Diagonal Support	1
6	Backrest Adjustment Bar	1
7	Backrest Support	2
8	Backrest Board	1
9	Seat Pad	1
10	Leg Developer	1
11	Foam Roll Tube	2
12	Foam Roll	4
13	Bracket	3
14	Spring Clip	3
15	Ø1" Sleeve	2
16	Left Safety Hook	1
17	Right Safety Hook	1
18	Bushing	6
19	1 ½" Square End Cap	12
20	1" Square End Cap	2
21	Ø 1" End Cap	16
22	Ø ¾" End Cap	2
23	Hex Socket Axle	1
24	Hex Socket Screw	1
25	M10x 2 3/8" Hex Bolt	6
26	M10 x 1" Hex Bolt	2
27	M8 x 2 1/8" Hex Bolt	1
28	M8 x 5/8" Hex Bolt	1
29	M6 x 1 3/8" Hex Bolt	8
30	M10 Aircraft Nut	8
31	M8 Aircraft Nut	1
32	M6 Aircraft Nut	2
33	Ø ¾" Washer	20
34	Ø 5/8" Washer	3
35	Ø ½" Washer	8
36	Weight Bar	1
37	Weight Plate 25#	2
38	Weight Plate 15#	2
39	Weight Plate 10#	2
40	Butterfly	2
41	Butterfly Foam Roll Tube	2
42	Butterfly Foam Roll	2
43	M10 x 4 ½" Hex Bolt	2
44	M10 Regular Nut	2
45	M10 Knob	2

# ***IMPEX INC.***

## **LIMITED WARRANTY**

IMPEX Inc. ("IMPEX") warrants this product to be free from defects in workmanship and material, under normal use and service conditions, for a period of two years on the Frame from the date of purchase. This warranty extends only to the original purchaser. IMPEX's obligation under this Warranty is limited to replacing or repairing, at IMPEX's option.

All returns must be pre-authorized by IMPEX. Pre-authorization may be obtained by calling IMPEX Customer Service Department at 1-800-999-8899. All freights on products returned to IMPEX must be prepaid by the customer. This warranty does not extend to any product or damage to a product caused by or attributable to freight damage, abuse, misuse, improper or abnormal usage or repairs not provided by an IMPEX authorized service center or for products used for commercial or rental purposes. No other warranty beyond that specifically set forth above is authorized by IMPEX.

IMPEX is not responsible or liable for indirect, special or consequential damages arising out of or in connection with the use or performance of the product or other damages with respect to any economic loss, loss of property, loss of revenues or profits, loss of enjoyments or use, costs of removal, installation or other consequential damages or whatsoever natures. Some states do not allow the exclusion or limitation of incidental or consequential damages. Accordingly, the above limitation may not apply to you.

The warranty extended hereunder is in lieu of any and all other warranties and any implied warranties of merchantability or fitness for a particular purpose is limited in its scope and duration to the terms set forth herein. Some states do not allow limitations on how long an implied warranty lasts. Accordingly, the above limitation may not apply to you.

This warranty gives you specific legal right. You may also have other rights which vary from state to state. **Register on-line at [www.impex-fitness.com](http://www.impex-fitness.com)**

**IMPEX INC.  
14777 Don Julian  
City of Industry, CA 91746**

### **ORDERING REPLACEMENT PARTS**

Replacement parts can be ordered by calling our Customer Service Department toll-free at **1-800-999-8899** during our regular business hours: Monday through Friday, 9 am until 5 pm Pacific standard time.

**[info@impex-fitness.com](mailto:info@impex-fitness.com)**

When ordering replacement parts, always give the following information.

1. Model
2. Description of Parts
3. Part Number
4. Date of Purchase