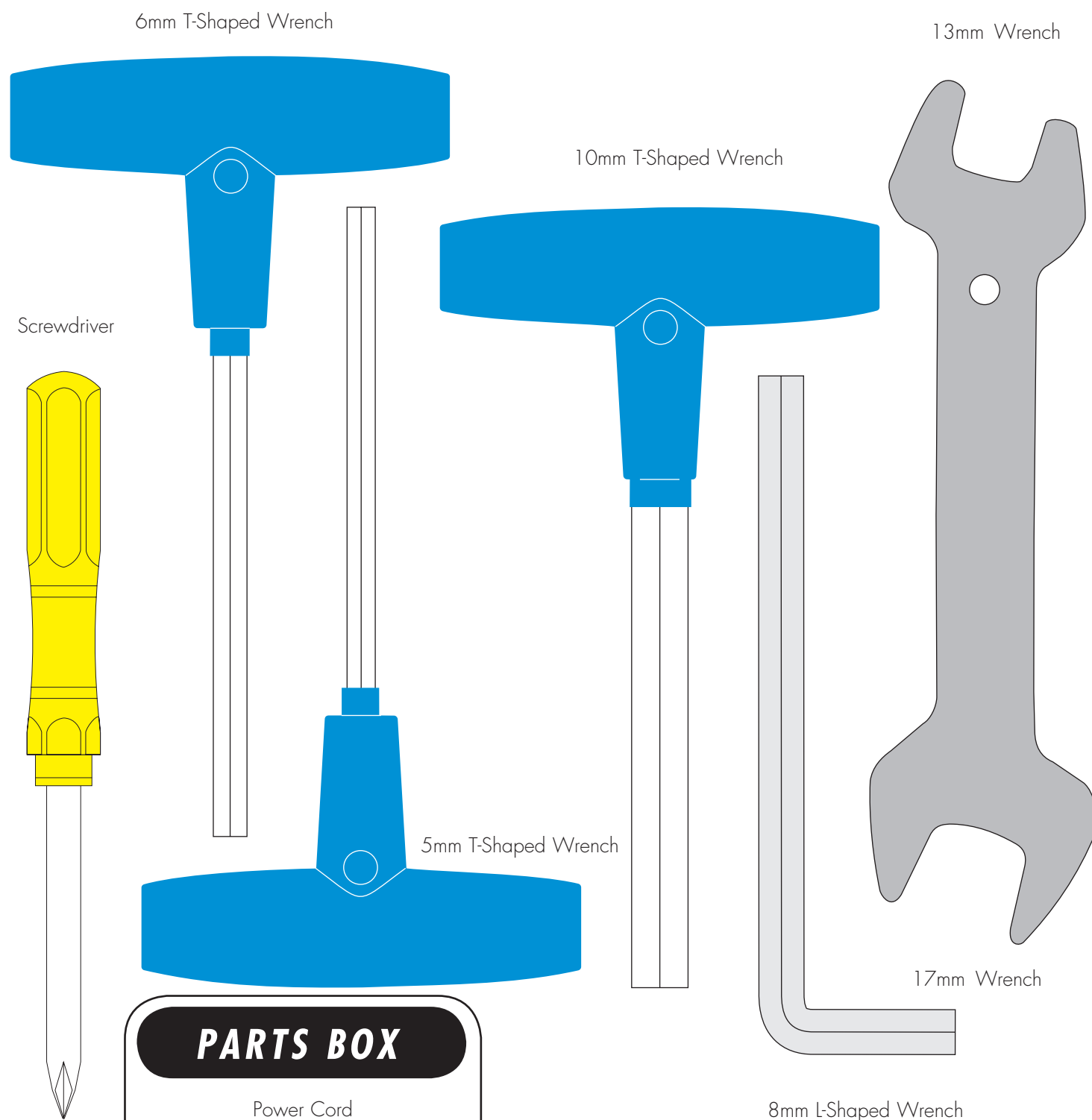


TOOLS & PARTS INCLUDED

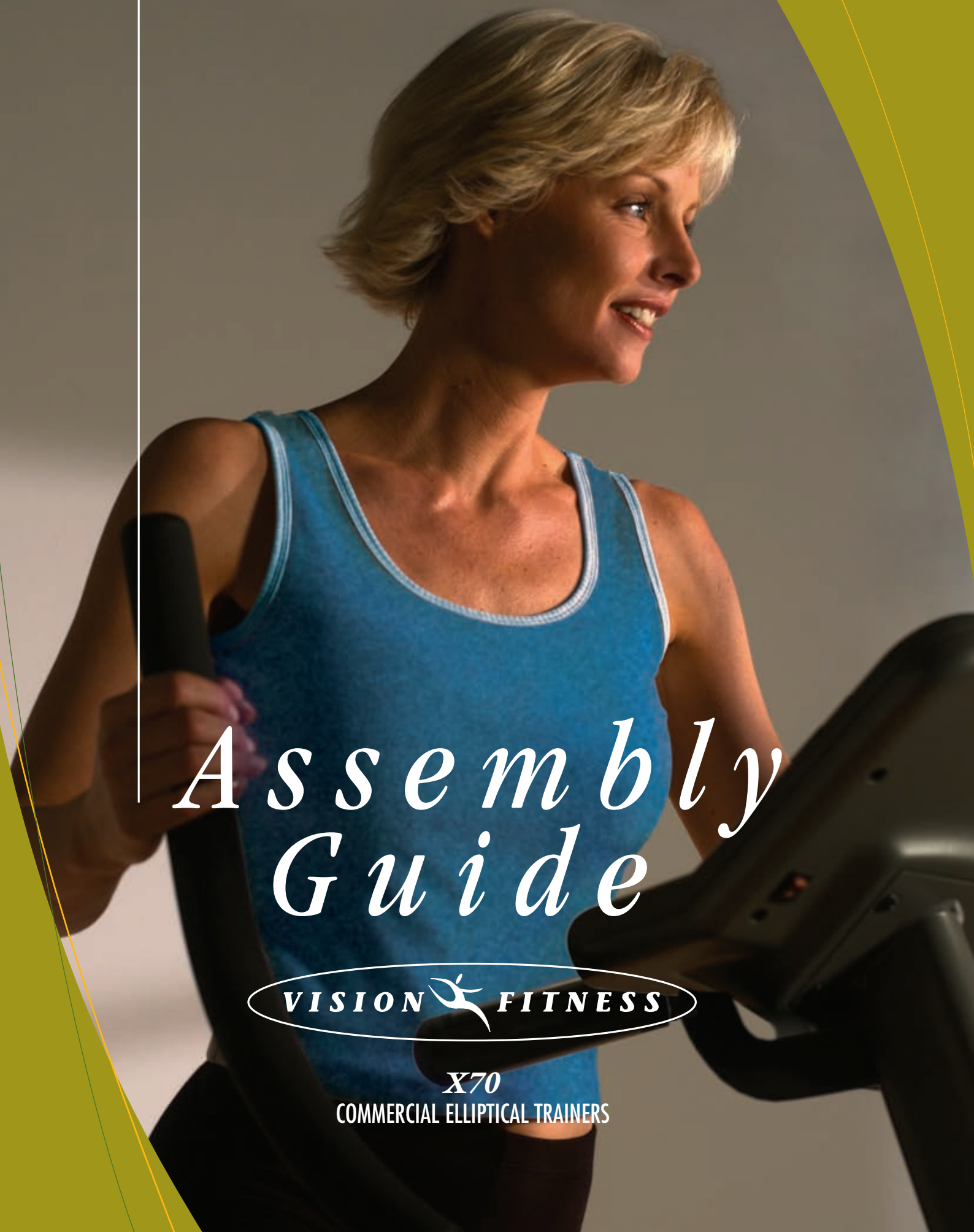


PARTS BOX

Power Cord
Console Mast Bracket
Console Mast Cover
Accessory Tray
Color-coded Hardware Bags
Owner's Guide
Assembly Guide
Warranty Card

500 South CP Avenue • P.O. Box 280 • Lake Mills, WI 53551
toll free 800.335.4348 • phone 920.648.4090 • fax 920.648.3373
www.visionfitness.com

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AG18.52PRD
REV4



Assembly Guide

VISION  FITNESS

X70
COMMERCIAL ELLIPTICAL TRAINERS

X70
COMMERCIAL ELLIPTICAL TRAINERS

To avoid possible damage to this Elliptical Trainer, please follow these assembly steps in the correct order. Before proceeding, find your new Elliptical Trainer's serial number located on the front axle tube, and enter here:

Refer to this number when calling for service, and enter this serial number on your Warranty Card and in your own records. Be sure to read your Owner's Guide before using your new Elliptical Trainer.
If any parts, hardware or tools are missing, please call 1.800.335.4348, Extension 12

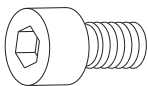
NOTE: It is recommended that you apply grease to the threads of each bolt and screw as you assemble your Elliptical Trainer to prevent loosening and noise. Also, during each assembly step, ensure that ALL bolts and screws are in place and partially threaded in before completely tightening any ONE bolt or screw.

HARDWARE INCLUDED

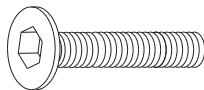
PINK BAG



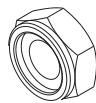
Spacer
Quantity: 4



M8x20L Socket Head Cap
Screw Quantity: 8



M10x50L Hex Socket Head
Cap Screw Quantity: 2

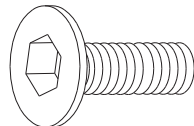


M10x1.25P Nylon
Nut Quantity: 2

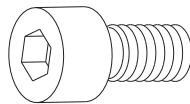
BLUE BAG



20.5x29x1.5t Wavy
Washer Quantity: 2



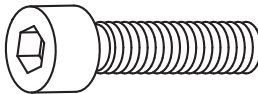
M8x20L Socket Head Cap
Screw Quantity: 2



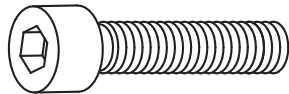
M8x10L Socket Head Cap
Screw Quantity: 4

HARDWARE INCLUDED

ORANGE BAG

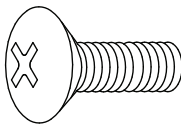


M10x70L Socket Head
Cap Screw Quantity: 2

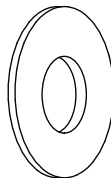


M8x80L Socket Head
Cap Screw Quantity: 1

BLACK BAG



M5x12L Socket Head
Cap Screw Quantity: 6

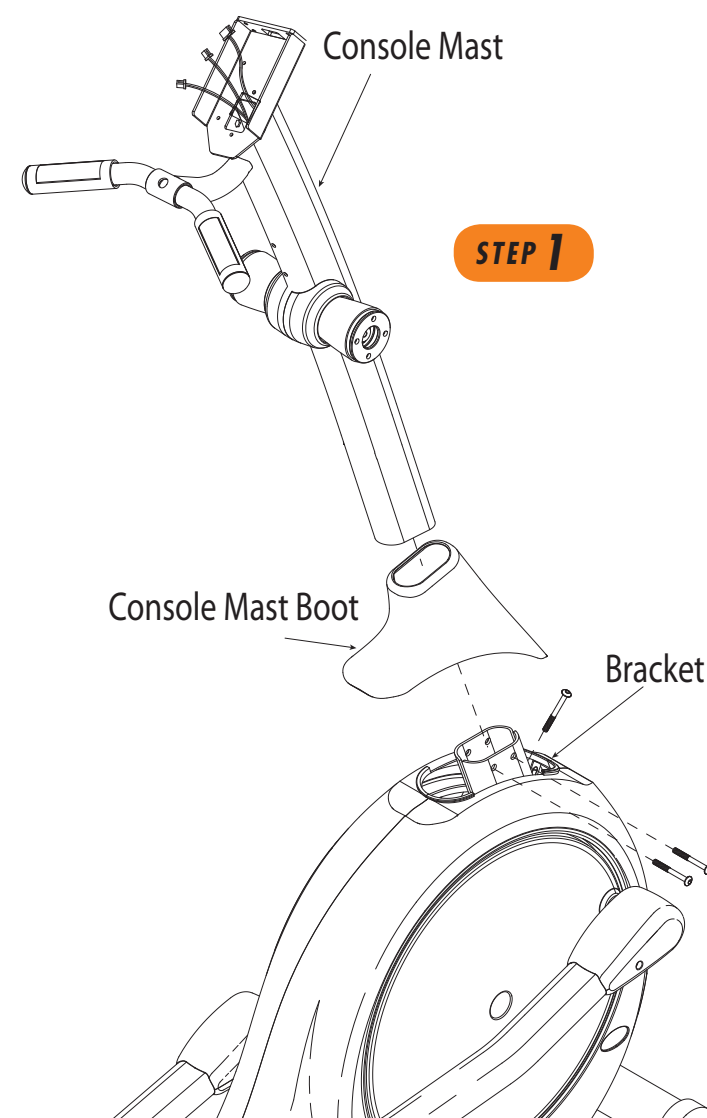


5.3x10x1.0t Washer
Quantity: 4

STEP 1

ORANGE BAG

- Place the console mast boot on the end of the console mast.
- Connect the wire tie that exits the bottom of the console mast to the wire harness that sits in the bracket at the top of the frame. Pull the wire tie and wire harness up through the console mast while at the same time inserting the console mast into the frame bracket.
- Secure the console mast to the frame with two capscrews (M10 x 70L). Tighten with the 8mm L-shaped wrench.
- Stabilize the console mast by inserting the socket head screw (M8x80L) to the front of the bracket. Tighten with the 8mm L-shaped wrench.
- Slide the console mast boot down the console mast and snap it in place so it integrates with the side covers.

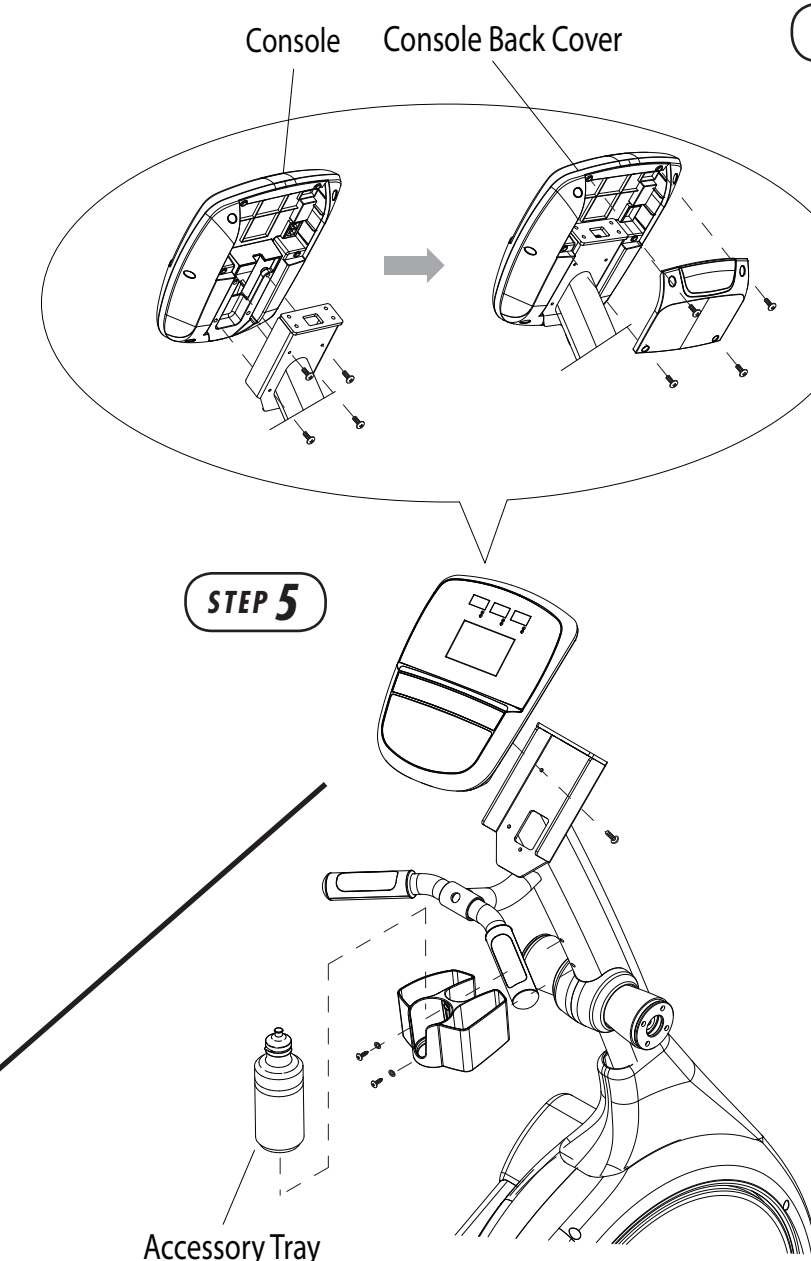


STEP 1

STEP 5

CONSOLE

- Remove the four mounting screws from the back of the console. Remove the four console back cover screws. Connect the wire harness and heart rate wires that come from the console mast into the plugs located in the back of the console. Attach the console to the mast with the four screws removed earlier.
- Plug in the 9-volt battery. Re-attach the console back cover with the four screws previously removed.
- Attach accessory tray to the console mast with the two included screws and screwdriver. Insert the water bottle.

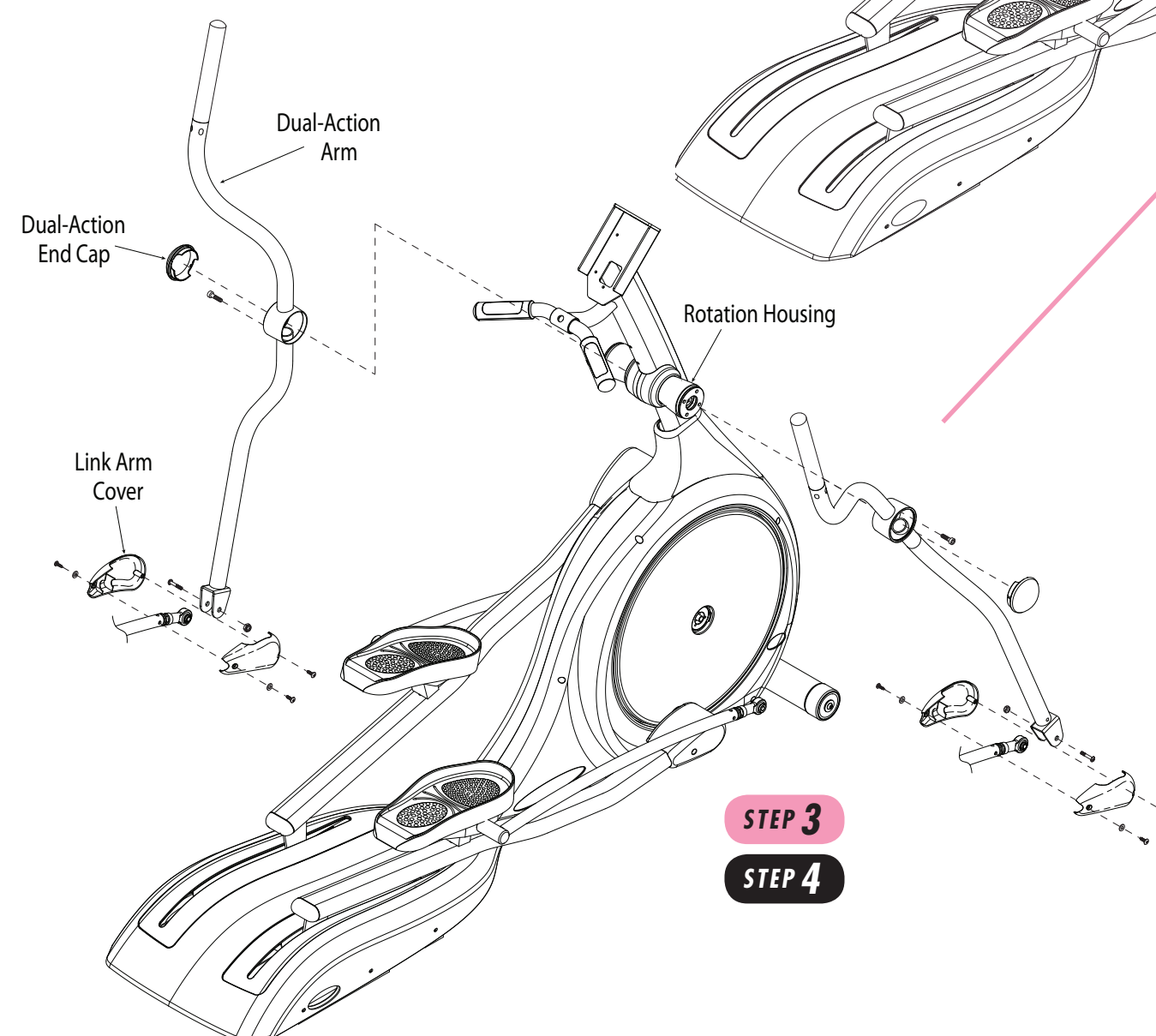


STEP 5

STEP 3

PINK BAG

- Connect the right dual-action arm to the right console mast rotation housing, being sure to line up the holes. Secure the dual-action arm in place with four screws (M8x20L) and tighten with the 6mm T-handled wrench. Snap the dual-action end cap into place.
- Make sure the spacers are inserted into the outside holes of the ball and socket joint of the lower link arm. Connect the right lower link arm to the right dual-action arm by lining up the holes on the end of each arm. Slide the screw (M10x50L) through the hole. Place a nut (M10) on the screw and tighten using the 17mm socket wrench and 6mm T-handled wrench.



STEP 3

STEP 4

STEP 4

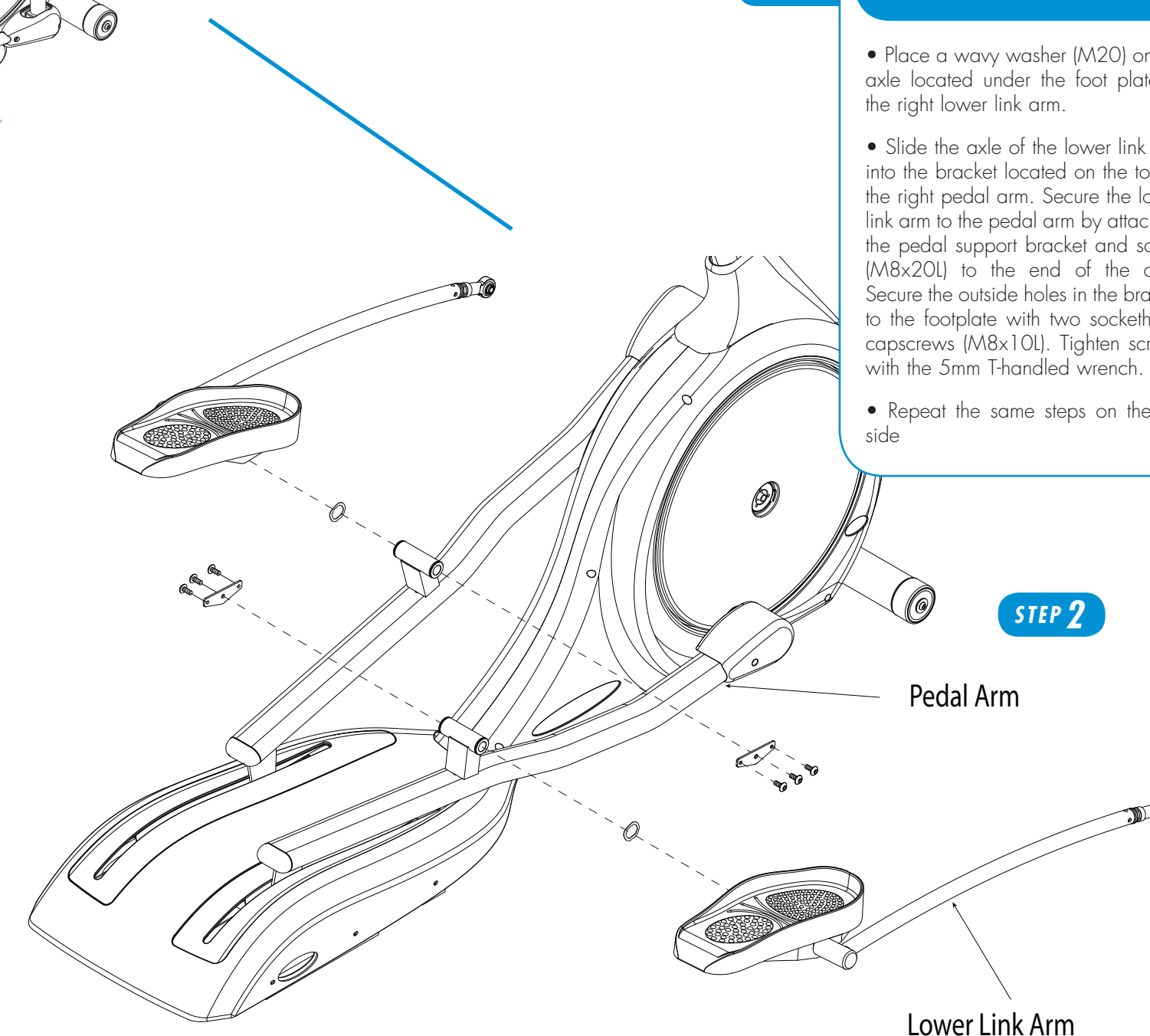
BLACK BAG

- Position the link arm cover over the joint of the lower link arm and dual-action arm. With a screw (M5x12L) and the screwdriver, connect the two halves of the cover through the hole located in the front of the cover. Attach the cover to each side of the lower link arm with the two washers (M5) and two screws (M5x12L).
- Repeat these same steps on the left side.

STEP 2

BLUE BAG

- Place a wavy washer (M20) on the axle located under the foot plate of the right lower link arm.
- Slide the axle of the lower link arm into the bracket located on the top of the right pedal arm. Secure the lower link arm to the pedal arm by attaching the pedal support bracket and screw (M8x20L) to the end of the axle. Secure the outside holes in the bracket to the footplate with two sockethead capscrews (M8x10L). Tighten screws with the 5mm T-handled wrench.
- Repeat the same steps on the left side.



STEP 2