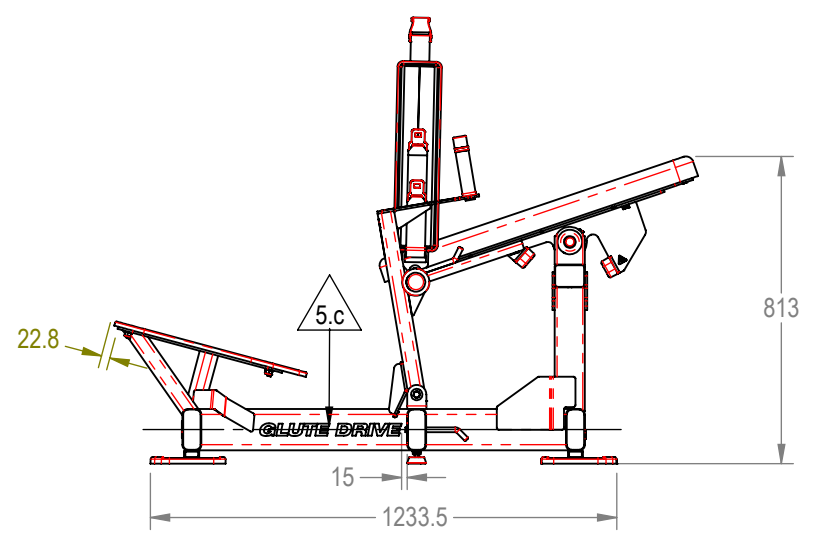
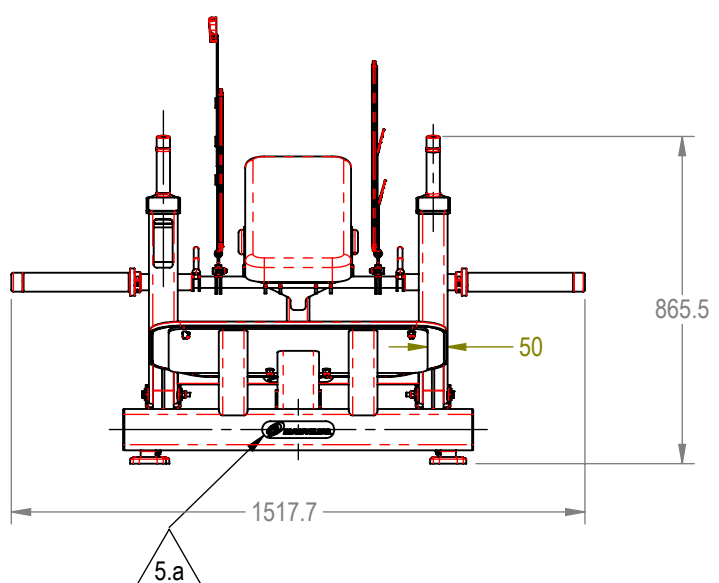
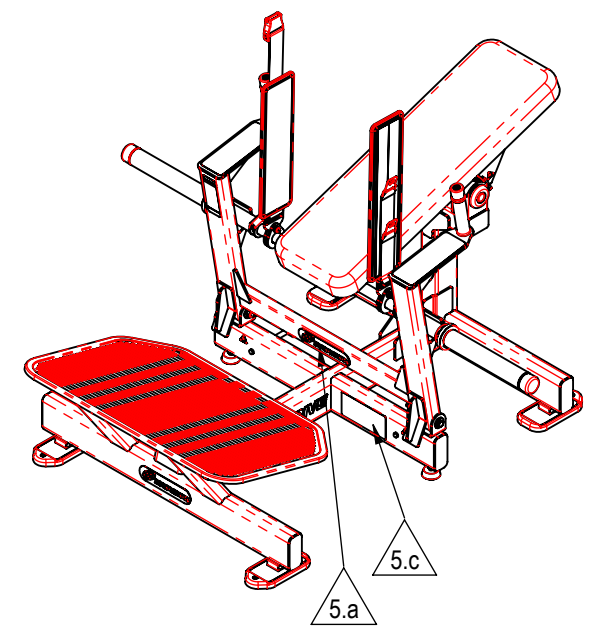
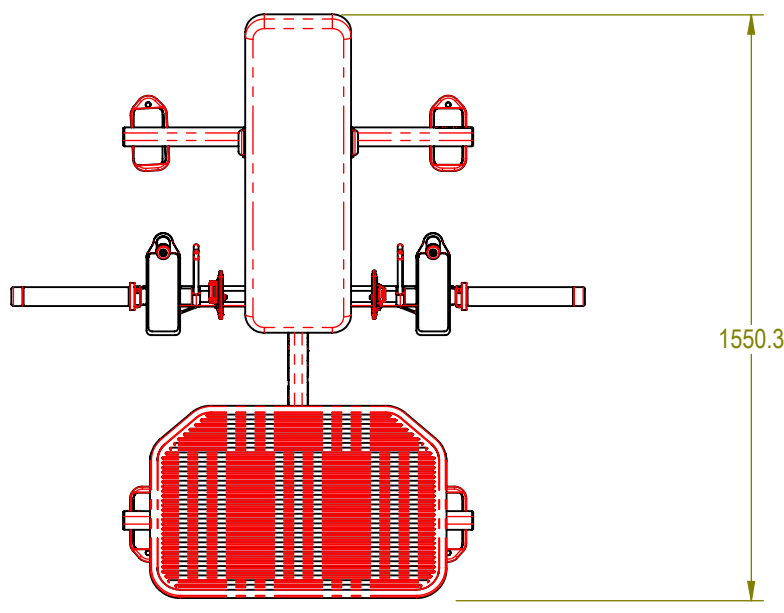


NOTES:

1. ASSEMBLE AND INSPECT PER SOP 620-7918.
2. COLOR DICTATED BY THE SALES ORDER.
  - a. COLOR: -XX COLOR DESIGNATOR AS SPECIFIED IN SOP 620-8222.
  - b. THE -XX CAN RESULT IN ONE COLOR FOR THE METAL SHROUD AND A DIFFERENT COLOR FOR THE METAL FRAME ALSO WITH A -XX LISTED ON THE BOM.
  - c. THE -00XX IS THE COLOR DESIGNATOR FOR UPHOLSTERY.
  - d. THE 5TH DESIGNATOR: "X" WITHIN -XXXXX DEFINES THE HEAD STRAP OR CUSTOM PRODUCTS BRAND. THIS IS SPECIFIED ON SALES ORDERS.
  - e. <PARA >THE -XXXXX IS CREATED BY COMBINING THE -XX, -00XX AND THE 5TH DESIGNATOR.
3. ALL X'S SHOULD BE DEFINED ON THE SALES ORDER.
4. TORQUE SPECIFICATIONS:
  - a. 6mm - 10 to 13.5 N-m, 8 to 10 lbs-ft
  - b. 8mm 25.5 to 28.5 N-m, 19 to 21 lbs-ft
  - c. 10mm - 55.5 to 58 N-m, 41 to 43 lbs-ft
5. STICKER PLACEMENT, PRIOR TO APPLYING STICKERS WASH/WIPE USING ALCOHOL (ISOPROPYL), AMMONIA AND/OR A 5% SODIUM HYPOCHLORITE TO WATER SOLUTION (CLOROX).
  - a. STICKER TO BE PLACED ON CENTER LINE OF TUBE HEIGHT AND WIDTH.
  - b. STICKER TO BE PLACED ON CENTER LINE OF TUBE WIDTH.
  - c. STICKER TO BE PLACED ON CENTER LINE OF TUBE HEIGHT.

REVISION HISTORY				
REV	DATE	DESCRIPTION	ECO	BY
A	7/12/2018	RELEASE FOR PRODUCTION	15983	RLH
B	9/10/2018	UPDATES TO PN'S: 731-8220-XX,731-8254-XXXX,731-8351-XX, IS 731-8166-XX WAS 731-8166, IS 731-8271-XX WAS 731-8271	16012	RLH
C	10/19/2018	REMOVE (4) 731-2522, IS 731-8365 WAS 731-8243, CHANGE FOOT PLATE TO RUBBER COVERED FOOT PLATE	16026	RLH
D	11/2/2018	CHANGES MADE TO 731-8254-XXXX	16034	RLH



**DOCUMENT STATUS:  
ECO**

NOTICE OF PROPRIETARY INFORMATION  
THIS DOCUMENT SHALL NOT BE REPRODUCED NOR SHALL THE INFORMATION CONTAINED HEREIN BE USED BY OR DISCLOSED TO OTHER EXCEPT AS EXPRESSLY AUTHORIZED BY CORE HEALTH & FITNESS, LLC.

CLASS OF WORK	UNLESS OTHERWISE SPECIFIED DIMS ARE IN mm. TOLERANCES FOR MEASURE OF LENGTH ARE:							ANGLES = ±2°
	0.5 to 3	> 3 to 6	> 6 to 30	> 30 to 120	> 120 to 400	> 400 to 1000	> 1000 to 2000	
FINE	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	----
MEDIUM X	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
COARSE	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4
VERY COARSE	----	±0.5	±1	±1.5	±2.5	±4	±6	±8

MATERIAL  
SEE BOM

FINISH  
SEE NOTES

VENDOR: LAND AMERICA

P/N:

THIRD ANGLE PROJECTION



DRAWN	INITIAL Randy Hansen	DATE 11/9/2018
CHECKED		
APPROVED		
	U.O.M.	MM

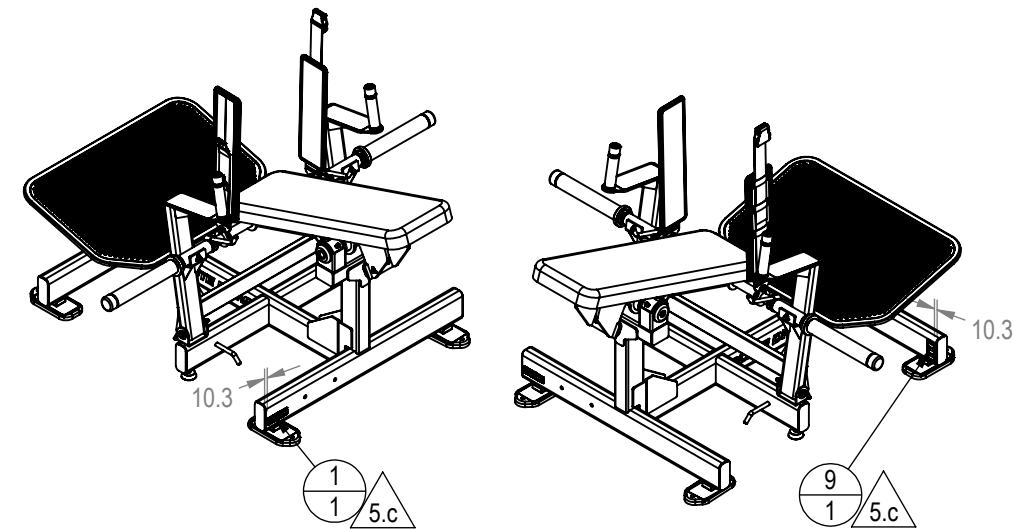
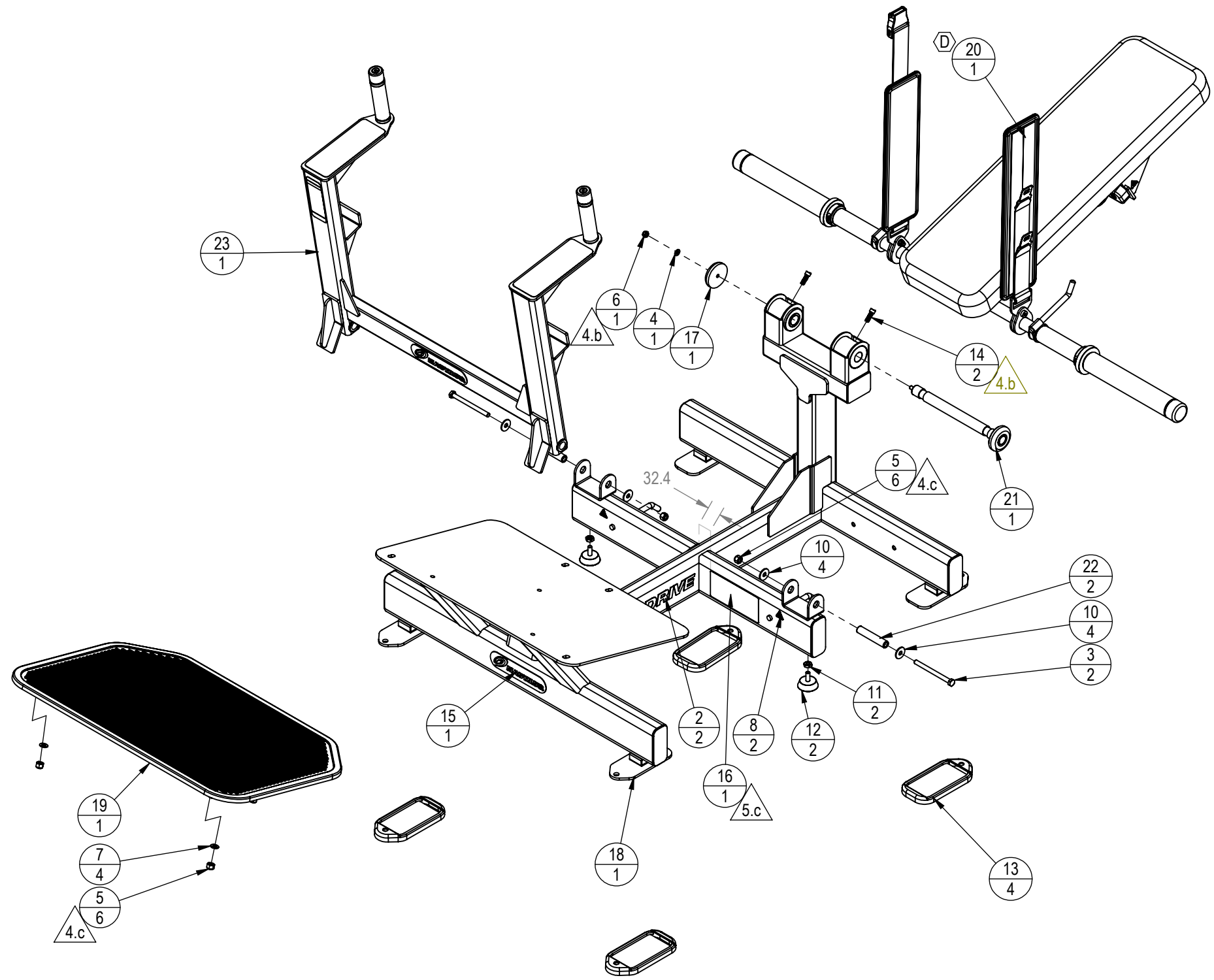
**CORE HEALTH & FITNESS, LLC**  
4400 NE 77th Ave., Suite 300  
Vancouver, WA 98662

CORE PART NO	REV
<b>NP-L1131-XXXXX</b>	<b>D</b>
TITLE <b>NP, GLUTE DRIVE</b>	
SCALE: 1:20	SHEET 1 OF 2   SHEET SIZE: B

9 8 7 6 5 4 3 2 1

J  
I  
H  
G  
F  
E  
D  
C  
B  
A

J  
I  
H  
G  
F  
E  
D  
C  
B  
A



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	050-5457	Label, S/N, Non-Powered, Primary, Core H&F	1
2	050-5594	BADGE, NAME, GLUTE DRIVE	2
3	110-3805	SCREW, M10x1.5, 120mm, HHC, HE, AS, ZC, GR12.9	2
4	731-0355	WASHER, PLAIN, M8, NARROW	1
5	731-0363	NUT, M10X1.5, NYLOC	6
6	731-0365	NUT, M8 X 1.25, NYLOC JAM	1
7	731-0367	WASHER, PLAIN, M10	4
8	731-0512	STICKER, WARNING, PINCH	2
9	731-0517	STICKER, WARNING, BOLT DOWN	1
10	731-2346	WASHER, M10, FENDER, BZ	4
11	731-2446	NUT, 3/8 -16, JAM	2
12	731-2447	FOOT, ADJ, 3/8-16	2
13	731-2647	FOOT, LONG, LEVERAGE	4
14	110-3568	SCREW, M8x1.25, 25mm, SHC, HK, AS, BEC, NP, Gr 12.9	2
15	731-7311	STICKER, NAUTILUS, DECO, 45MMX191MM	1
16	731-7920	STICKER, WARNING, NP STANDARD INSTRUCTIONS	1
17	731-8307-XX	CAP, END, M8, 65MM, LARGE CB	1
18	731-8220-XX	WELD, BASE, GLUTE DRIVE	1
19	731-8365	ASSY, FOOT PAD, GLUTE DRIVE	1
D	731-8254-XXXX	ASSY, SEAT BACK W/BAR	1
21	731-8271-XX	WELD, SHAFT, PIVOT, GLUTE DRIVE	1
22	731-8304	SHAFT, PIVOT, BAR CATCH	2
23	731-8351-XX	ASSY, BAR CATCH, GLUTE DRIVE	1

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CORE PART NO	REV
<b>NP-L1131-XXXX</b>	<b>D</b>
TITLE	
NP, GLUTE DRIVE	
SCALE: 1:12	SHEET 2 OF 2   SHEET SIZE: B

9 8 7 6 5 4 3 2 1