



Generation 2  
November 2025

## LD-1 Chest Press/Pec Fly Owner's Manual



Serial Number Here
Date of Purchase



# Instructions

Congratulations on the purchase of your new Batca LD-1 Chest Press/Pec Fly. This gym will provide you with a lifetime of enjoyment to meet your strength training needs. Batca Fitness Systems strives to build the best quality gyms and to package these gyms in such a way to avoid any damage during shipping.

In order to get started with your assembly you should first familiarize yourself with this manual. It is recommended that you read through each step thoroughly before you begin. Begin by opening your boxes and separating all of your parts. Verify that all parts are accounted for and have no damage. When all parts are accounted for, you may begin your assembly. Some items may have been pre-assembled for your convenience. Please note that hardware quantities shown reflect total quantities for your gym and may not reflect actual quantities in each bag. Assemble your gym on a solid level surface. This will ensure the best possible performance, function, and safety for the gym and your workout.

Assemble your gym according to the step by step instructions found in this manual. Failure to do so will void your warranty and may result in personal injury. After assembly, you should check each station to ensure correct operation. If a problem arises, recheck your assembly with these instructions to verify correct assembly. If you are unable to correct a problem or have questions with your assembly please contact your authorized Batca dealer.

## Warning

Batca Fitness Systems has built this gym to give you a safe, effective and enjoyable workout. However, there is a risk assumed by individuals who use this type of equipment. It is very important that all warnings and instructions are read and followed before beginning any exercise program.

It is also very important to read and follow the preventative maintenance schedule described in this manual. If any of the warning labels or stickers are worn, faded, torn, scratched or missing they should be replaced immediately.

**WARNING: There is a risk assumed by individuals who use this type of equipment. To minimize risk always follow these rules.**

- 1) It is essential that you consult with your physician before beginning any exercise program.
- 2) Inspect equipment before each use for loose, worn, or frayed parts (including cables, nuts and bolts). Replace parts at first signs of wear (use only genuine BATCA replacement parts). Use of equipment that is damaged, worn, frayed or not completely assembled on a solid, level surface may result in injury.
- 3) Make sure all adjustment pins are fully engaged before using equipment.
- 4) Keep all parts of the body and clothing outside the path of any moving parts of the gym. Be alert to the possibility of injury. Do not be careless.
- 5) Minors and children should not be allowed to play on or around this gym.
- 6) If you have any questions on proper use or maintenance of this gym, do not hesitate to call your local BATCA FITNESS SYSTEMS distributor or BATCA FITNESS SYSTEMS at (919) 255-1233. [www.batcafitness.com](http://www.batcafitness.com)

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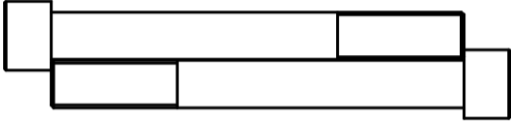
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# Tools Required

- 9/16" Wrench/Ratchet
- Metric Allen Wrench Set (M8, M6, M4)
- 3/4" Wrench
- Tape Measure

## Hardware Blister Pack

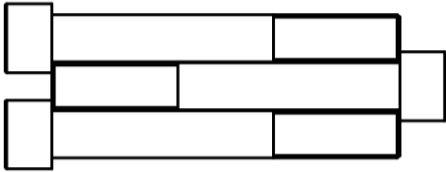
### STEP 1:



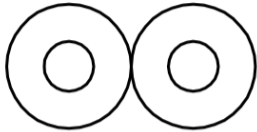
SHCS 3/8"-16X3-1/4",2pcs



1/2"Pulley  
Spacer ,2pcs



SHCS 3/8"-16X2-3/4",3pcs



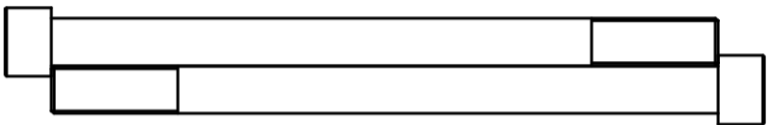
3/8" Flat  
Washers, 8pcs



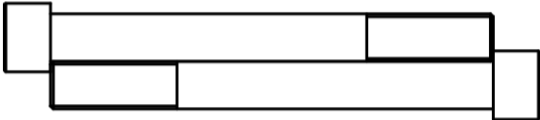
3/8"-16 Nylock, 5pcs

M8

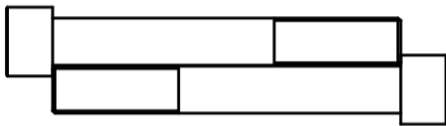
### STEP 2:



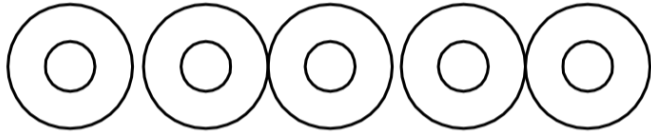
SHCS 3/8"-16X5-1/4",2pcs



SHCS 3/8"-16X3-1/2",2pcs



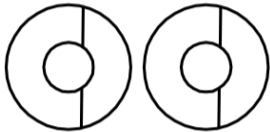
SHCS 3/8"-16X2-3/4",2pcs



3/8" Flat Washers, 10pcs

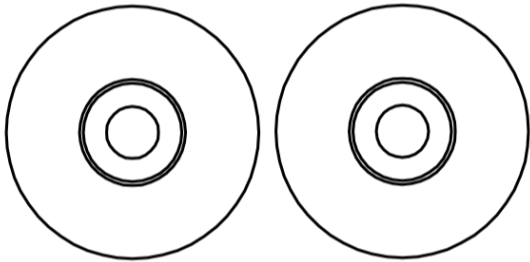


3/8"-16 Nylock, 6pcs

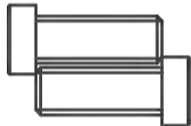


3/8" Curved Washers,2pcs

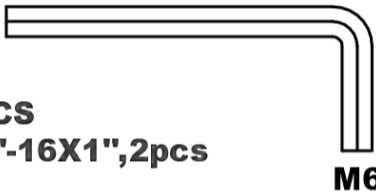
### STEP 3:



Small Aluminum  
End Cap ,2pcs  
BFP-51696

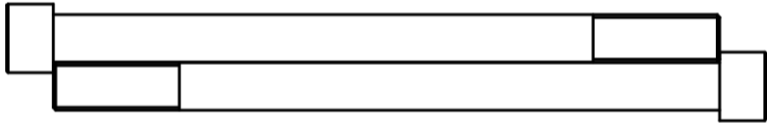


SHCS  
3/8"-16X1",2pcs



M6

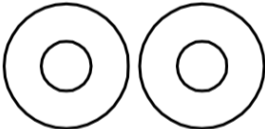
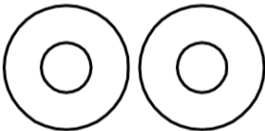
### STEP 4:



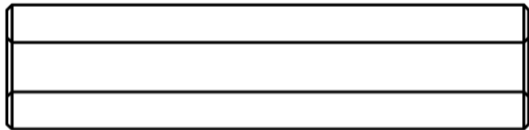
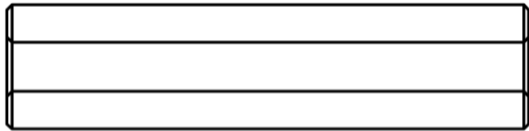
SHCS 3/8"-16X5-1/4",2pcs



3/8"-16 Nylock, 2pcs



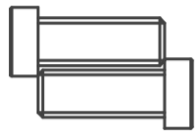
3/8" Flat Washers, 4pcs



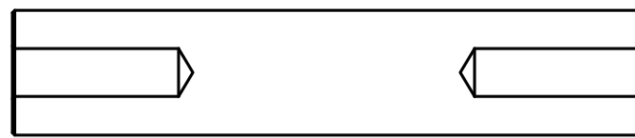
BEP-51736 ,Axle ,2pcs

# Hardware Blister Pack

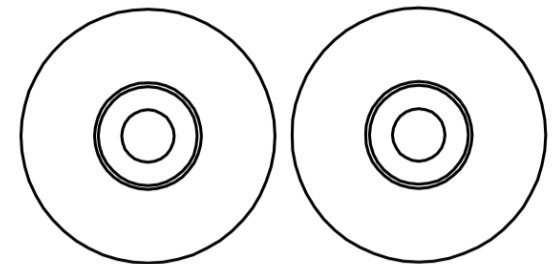
## STEP 5:



**SHCS**  
3/8"-16X1",2pcs

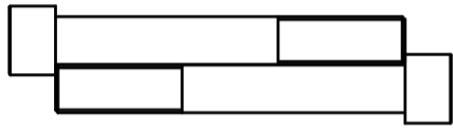


**BEP-51699 1" Foot Assist  
Axle**



**Small Aluminum End Cap ,2pcs  
BFP-51696**

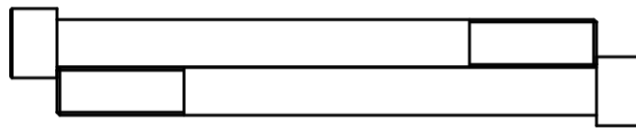
## STEP 6:



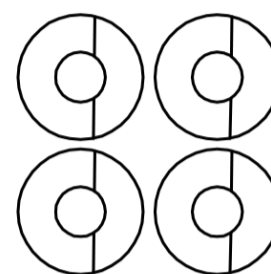
**SHCS 3/8"-16X2-3/4",2pcs**



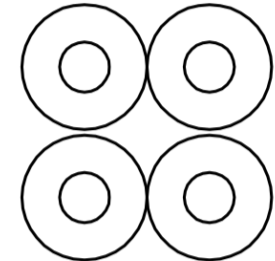
**3/8"-16 Nylock, 4pcs**



**SHCS 3/8"-16X4-1/4",2pcs**

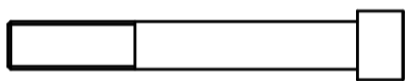


**3/8" Curved Washers,4pcs**

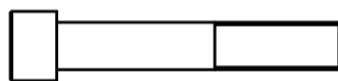


**3/8" Flat  
Washers, 4pcs**

## STEP 7:



**SHCS 3/8"-16X2-3/4",1pc**



**SHCS 3/8"-16X2-1/4",1pc**

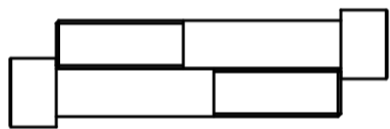


**3/8"-16 Nylock, 2pcs**

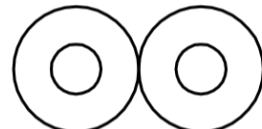


**3/8" Flat Washers, 2pcs**

## STEP 8:



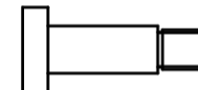
**SHCS 3/8"-16X2-1/4", 2pcs**



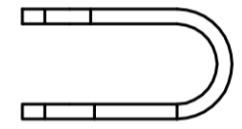
**3/8" Flat Washers, 4pcs**



**5/16"-18 Nylock ,1pc  
3/8"-16 Nylock, 2pcs**

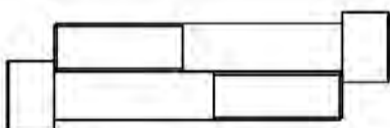


**1 1/4"Shoulder  
Bolt, 1pc**

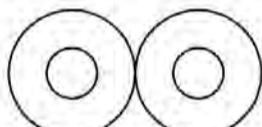


**BTH-50227  
Cable Strap, 1pc**

## STEP 9:



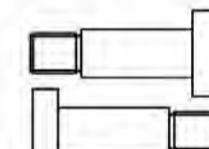
**SHCS 3/8"-16X2-1/4", 2pcs**



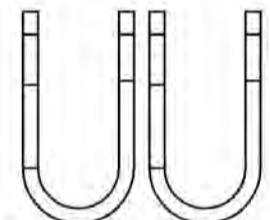
**3/8" Flat  
Washers, 4pcs**



**3/8"-16 Nylock, 2pcs  
5/16"-18 Nylock ,2pcs**

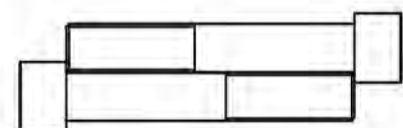


**1 1/4"Shoulder  
Bolt, 2pcs**

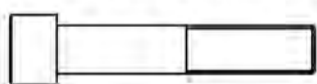


**BTH-50227  
Cable Strap, 2pcs**

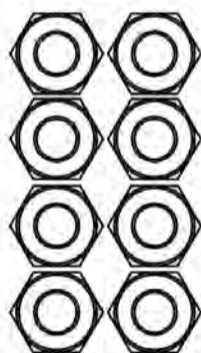
## STEP 10:



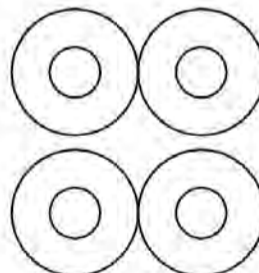
**SHCS 3/8"-16X2-1/4", 2pcs**



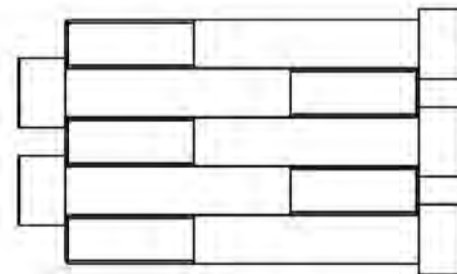
**SHCS 3/8"-16X2",1pc**



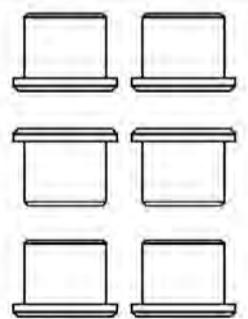
**3/8"-16 Nylock, 8pcs**



**3/8" Flat Washers, 8pcs**

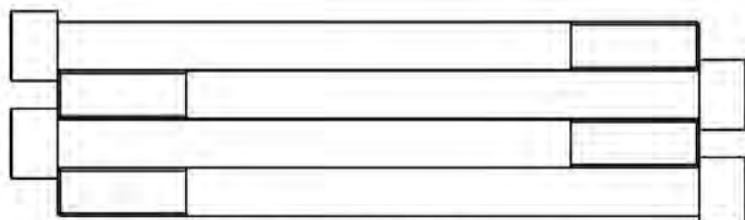


**SHCS 3/8"-16X2-3/4",5pcs**

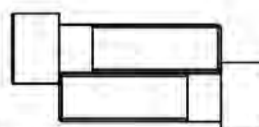


**1/2"Pulley  
Spacer ,6pcs**

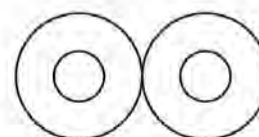
## STEP 11:



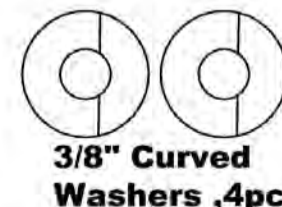
**SHCS 3/8"-16X5",4pcs**



**SHCS  
3/8"-16X1-1/4",2pcs**



**3/8" Flat  
Washers, 2pcs**

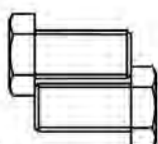


**3/8" Curved  
Washers ,4pcs**

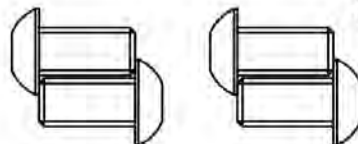


**3/8" Lock  
Washers ,6pcs**

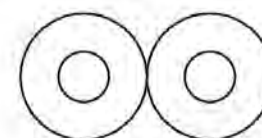
## STEP 12:



**HCS  
3/8"-16X3/4",2pcs**



**BHSCS 3/8"-16X3/4",4pcs**



**3/8" Flat Washers, 4pcs**



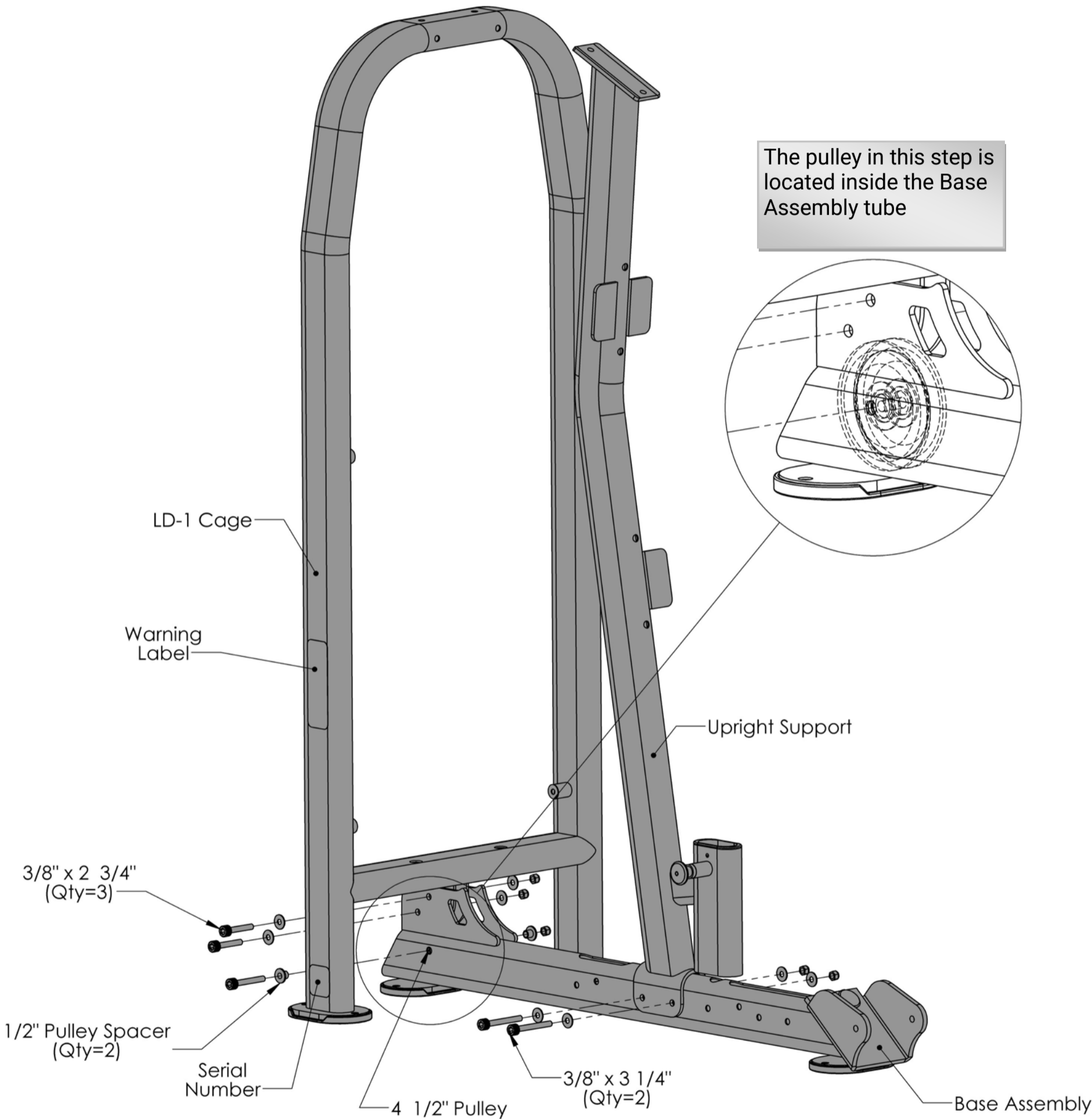
Step 1:

**Note: Please Position Hardware in the same direction as shown in the figure. This will make future steps easier to assemble**

**All Flat Washers and Nylocks are 3/8" unless otherwise noted.** Anywhere a washer is against the round side of a tube there is to be a **3/8" CURVED WASHER** instead of a **3/8" FLAT WASHER**.



**DO NOT TIGHTEN BOLTS UNTIL STEP 2**

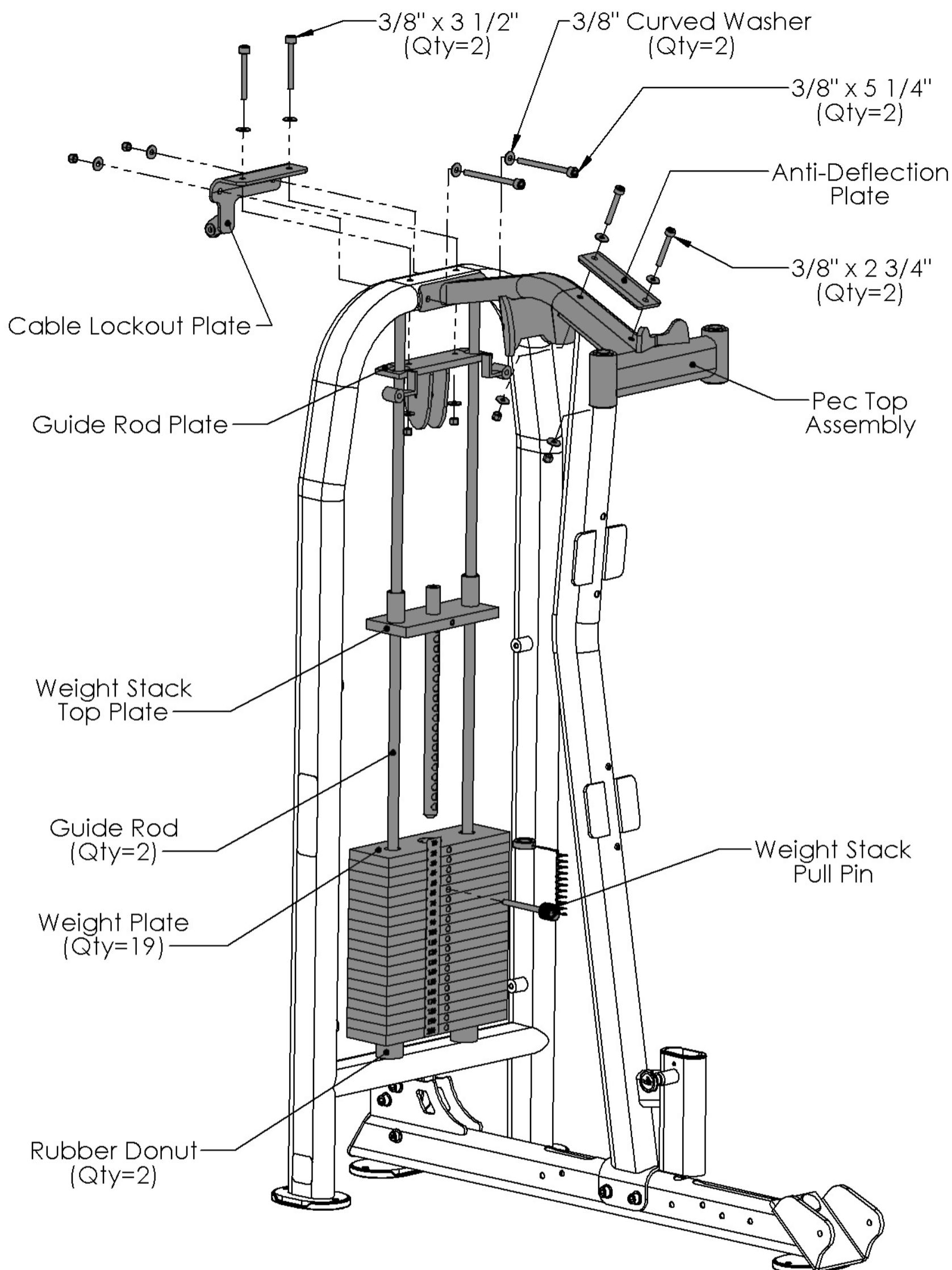


Part #	Description	Qty
BFP-10824	LD-1 Cage	1
BFP-10823	Base Assembly	1
BFP-10828	Upright Support	1
BFH-50174	4 1/2" Pulley	1
BFP-51750	SHCS 3/8" x 2 3/4"	3
BFP-51748	SHCS 3/8" x 3 1/4"	2
BFP-51746	1/2" Pulley Spacer	2
BFH-50146	3/8" Flat Washer	8
BFH-50157	3/8" Nylock	5

## Step 2:



**Make sure all bolts are tightened before moving on**

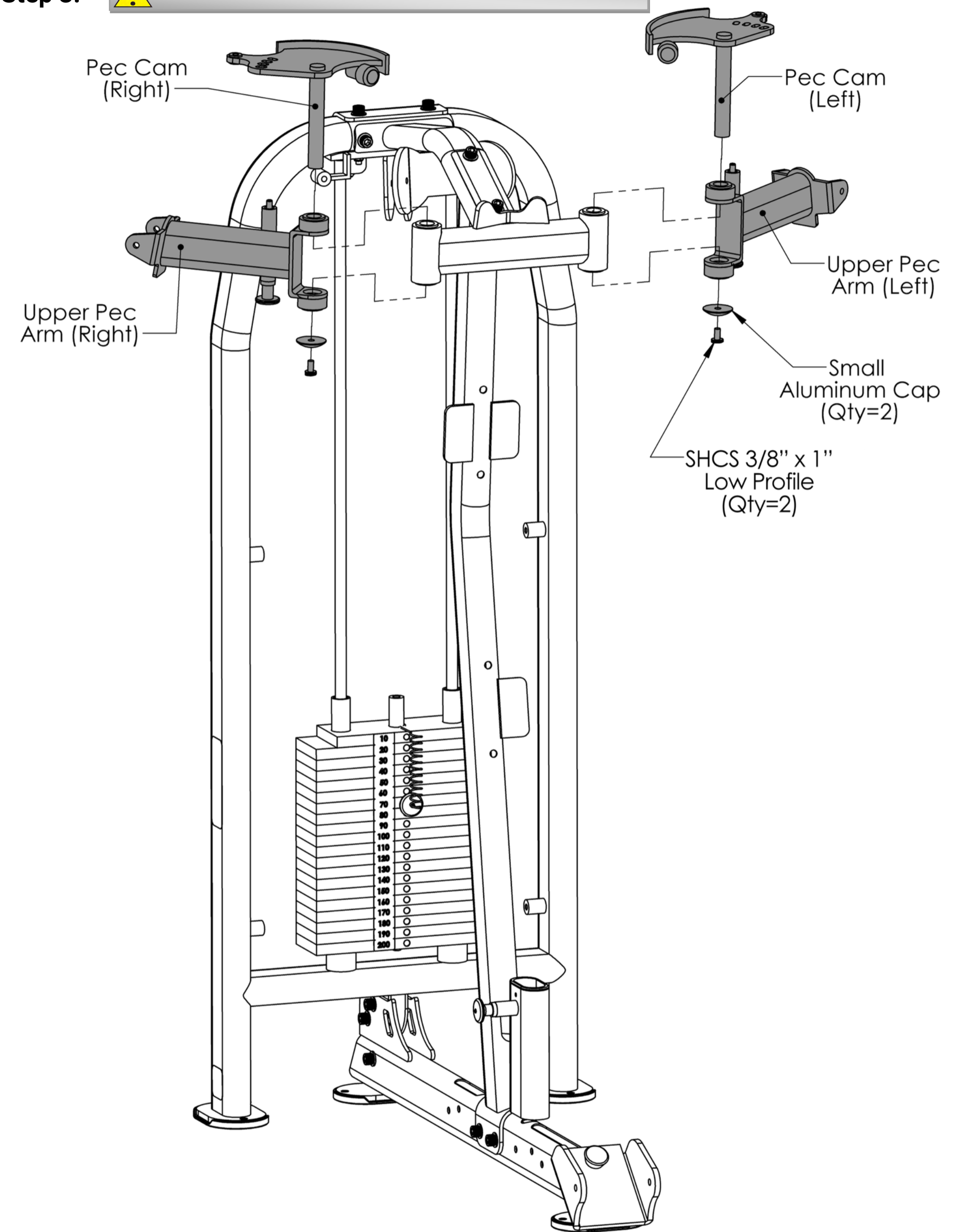


Part #	Description	Qty
BFP-10829	Pec Top Assembly	1
BFP-10839	Cable Lockout Plate	1
BFP-10827	Guide Rod	2
BFP-51745	Guide Rod Plate	1
BFP-51719	Anti-Deflection Plate	1
BFM-10413	Weight Stack Top Plate	1
BFM-50632	Weight Stack Plate	19
BFM-53079	Weight Stack Pull Pin	1
BFM-50529	Rubber Donut	2
BFP-51748	SHCS 3/8" x 2 3/4"	2
BFP-51760	SHCS 3/8" x 3 1/2"	2
BFP-51756	SHCS 3/8" x 5 1/4"	2
BFH-50146	3/8" Flat Washer	10
BFH-50157	3/8" Nylock	6
BFH-50204	3/8" Curved Washer	2

All Flat Washers and Nylocks are 3/8" unless otherwise noted. Anywhere a washer is against the round side of a tube there is to be a **3/8" CURVED WASHER** instead of a **3/8" FLAT WASHER**.

Step 3:

 Make sure all bolts are tightened before moving on

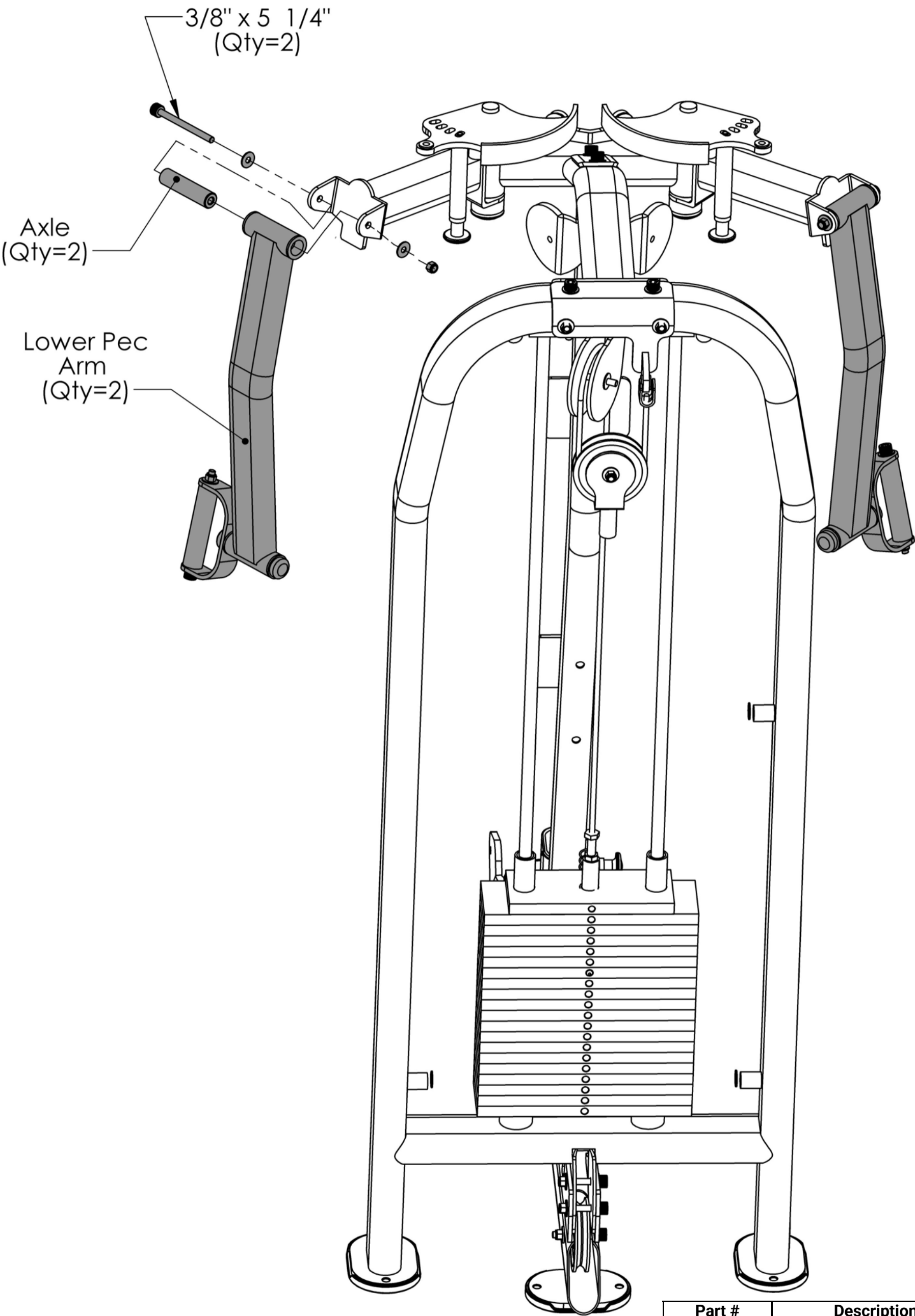


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFP-10834	Pec Cam (Right)	1
BFP-10833	Pec Cam (Left)	1
BFP-10830	Upper Pec Arm (Right)	1
BFP-10831	Upper Pec Arm (Left)	1
BFP-51738	Small Aluminum Cap	2
BFH-50665	SHCS 3/8" x 1" - Low Profile	2

Step 4:

**NOTE:** Pec Fly Handles should be facing the front of the machine. Make sure all bolts are tightened before moving on

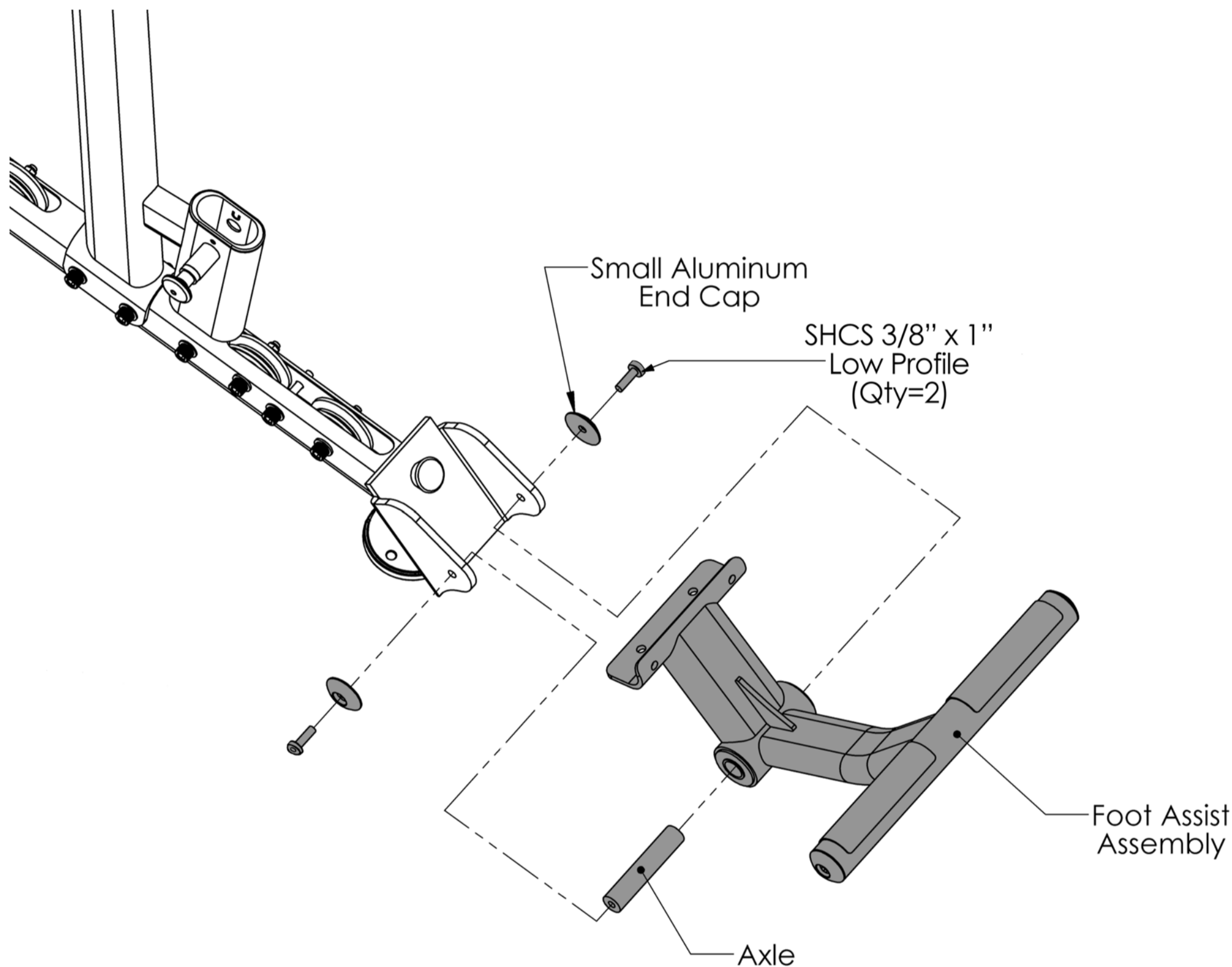


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFP-10832R	Right Lower Pec Arm	1
BFP-10832L	Left Lower Pec Arm	1
BFP-51736	1" Pec Arm Axle	2
BFP-51756	SHCS 3/8" x 5 1/4"	2
BFH-50146	3/8" Flat Washer	4
BFH-50157	3/8" Nylock	2

Step 5:

 Make sure all bolts are tightened before moving on

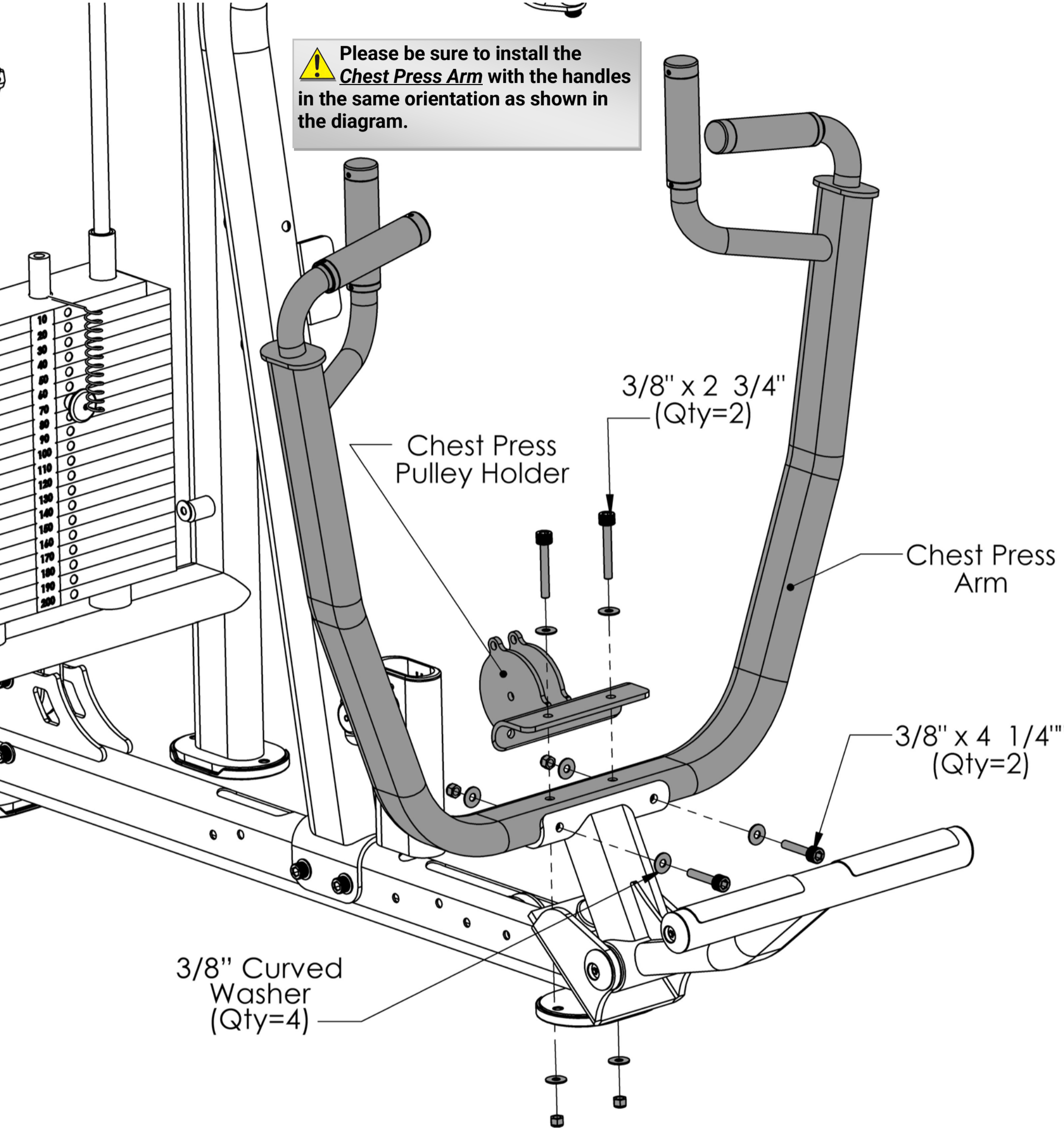


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFP-10825	Foot Assist Assembly	1
BFP-51699	1" Foot Assist Axle	1
BFP-51696	Small Aluminum End Cap	2
BFH-50665	SHCS 3/8" x 1" - Low Profile	2

Step 6:

 Make sure all bolts are tightened before moving on

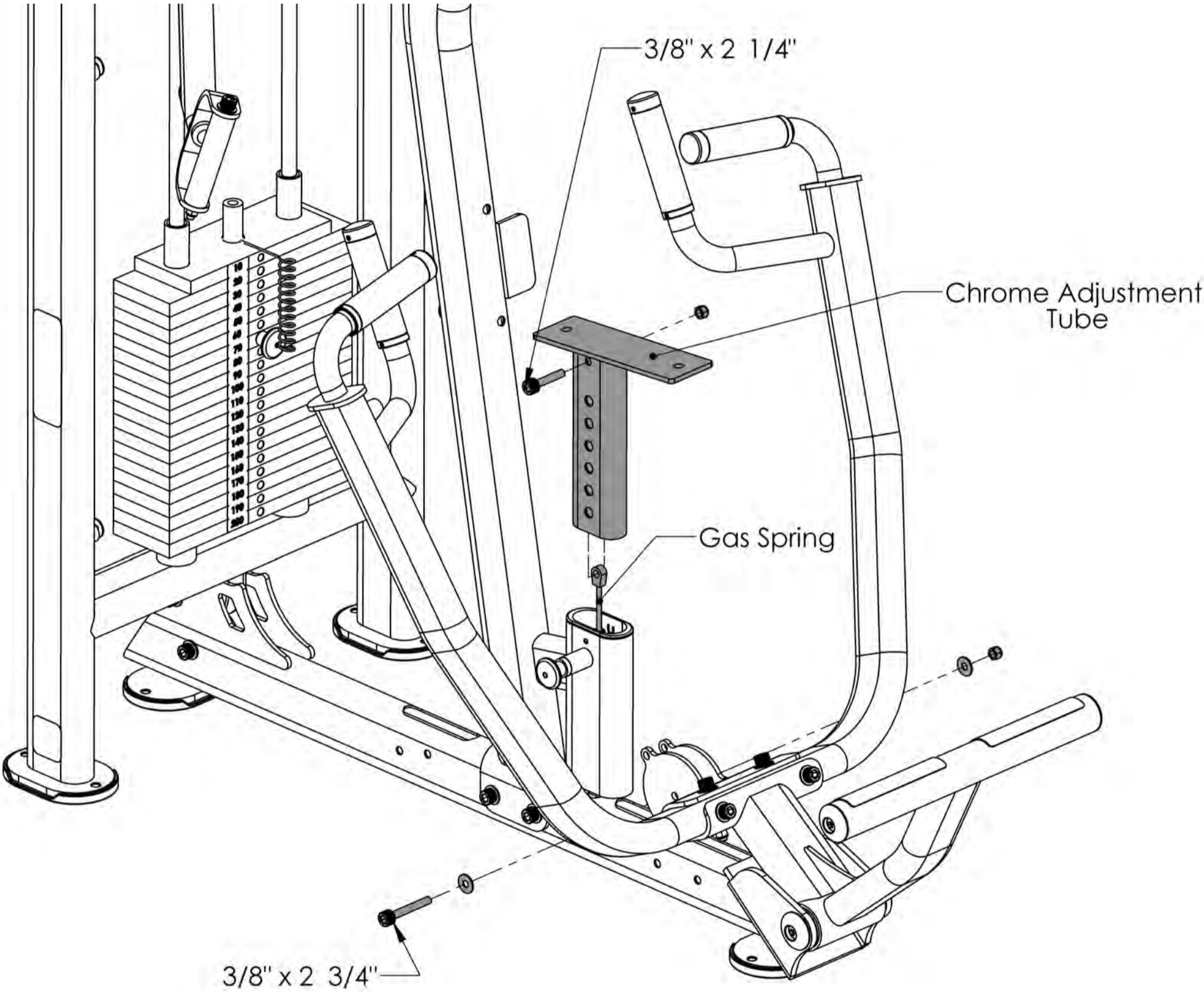



All Flat Washers and Nylocks are 3/8" unless otherwise noted. Anywhere a washer is against the round side of a tube there is to be a **3/8" CURVED WASHER** instead of a **3/8" FLAT WASHER**.

Part #	Description	Qty
BFP-10826	Chest Press Arm	1
BFP-10837	Chest Press Pulley Holder	1
BFP-51750	SHCS 3/8" x 2 3/4"	2
BFP-51884	SHCS 3/8" x 4 1/4"	2
BFH-50146	3/8" Flat Washer	4
BFH-50157	3/8" Nylock	4
BFH-50204	3/8" Curved Washer	4

Step 7:

 Make sure all bolts are tightened before moving on

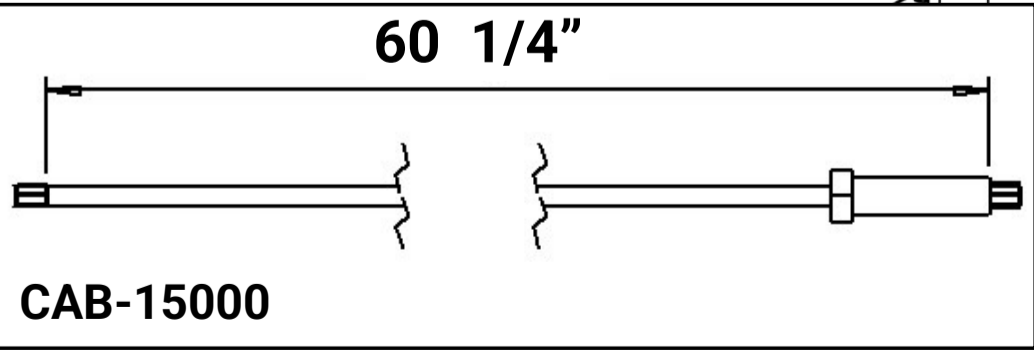
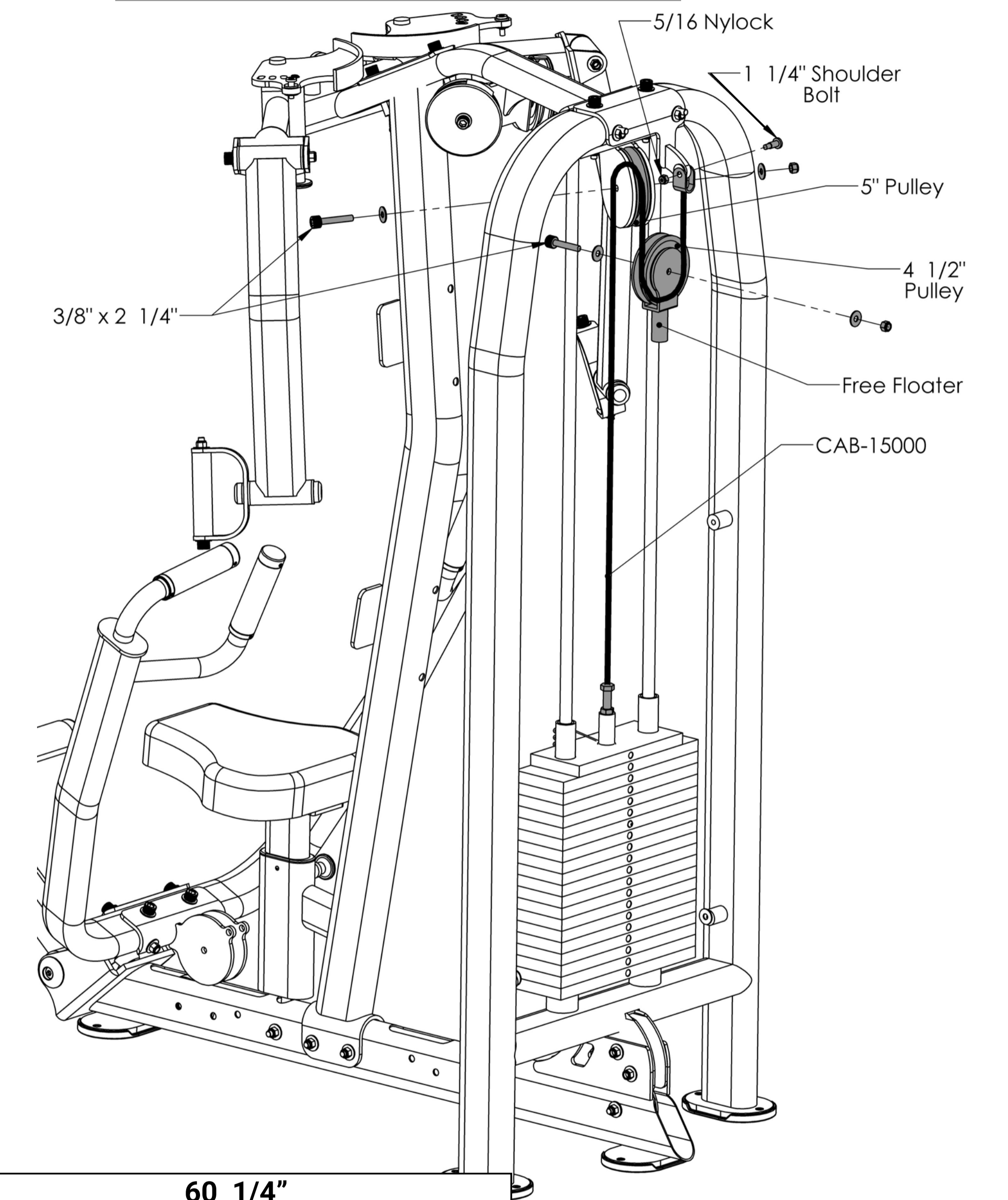


 Make sure this bolt goes through the bottom and top holes of the Gas Spring

All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFP-10836	Chrome Adjustment Tube	1
BFH-50210	Gas Spring	1
BFP-51752	SHCS 3/8" x 2 1/4"	1
BFP-51750	SHCS 3/8" x 2 3/4"	1
BFH-50146	3/8" Flat Washer	2
BFH-50157	3/8" Nylock	2

Step 8:  Make sure all bolts are tightened before moving on

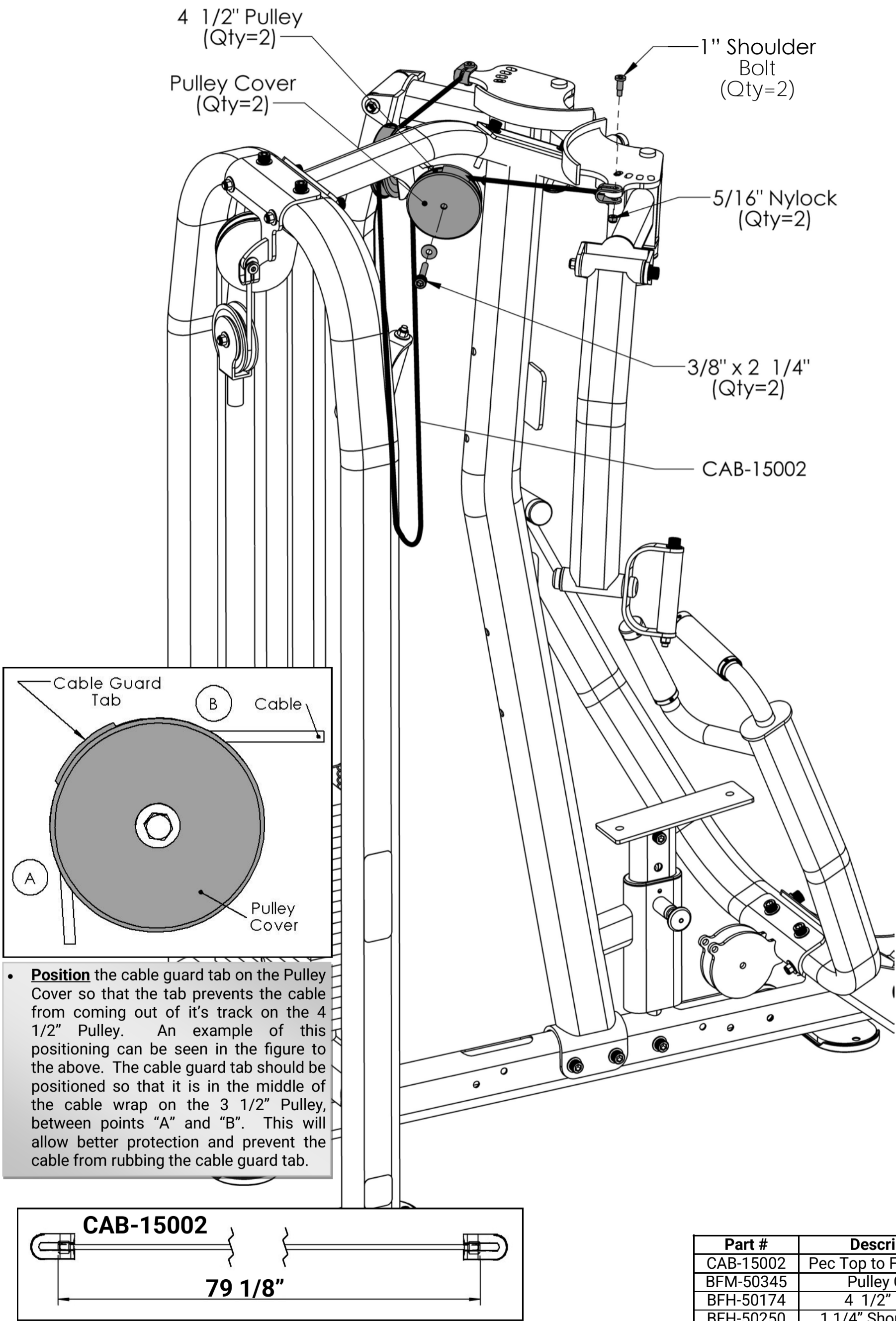


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
CAB-15000	Weight Stack to Free Floater	1
BFP-10838	Free Floater	1
BFH-50174	4 1/2" Pulley	1
BFH-50530	5" Pulley	1
BFH-50250	1 1/4" Shoulder Bolt	1
BFP-51752	SHCS 3/8" x 2 1/4"	2
BFH-50267	5/16" Nylock	1
BFH-50146	3/8" Flat Washer	4
BFH-50157	3/8" Nylock	2

Step 9:

 Make sure all bolts are tightened before moving on

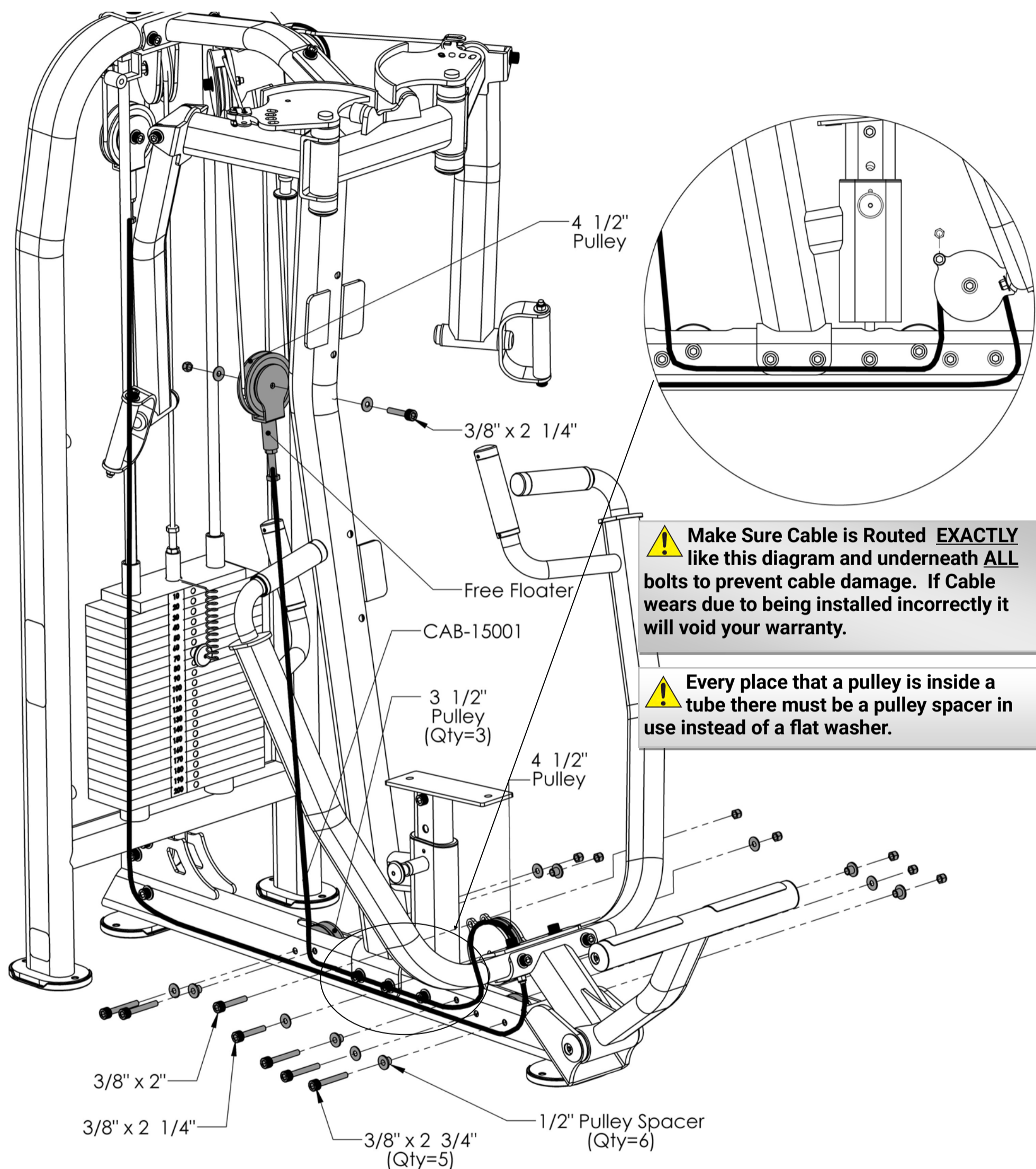


All Flat Washers and Nylocks are 3/8" unless otherwise noted.


Part #	Description	Qty
CAB-15002	Pec Top to Free Floater	1
BFM-50345	Pulley Cover	2
BFH-50174	4 1/2" Pulley	2
BFH-50250	1 1/4" Shoulder Bolt	2
BFP-51752	SHCS 3/8" X 2 1/4"	2
BFH-50267	5/16" Nylock	2
BFH-50146	3/8" Flat Washer	4
BFH-50157	3/8" Nylock	2

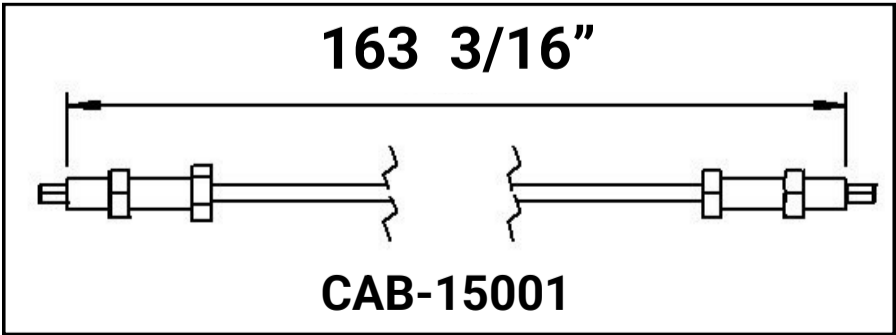
Step 10:

 Make sure all bolts are tightened before moving on



 Make Sure Cable is Routed **EXACTLY** like this diagram and underneath **ALL** bolts to prevent cable damage. If Cable wears due to being installed incorrectly it will void your warranty.

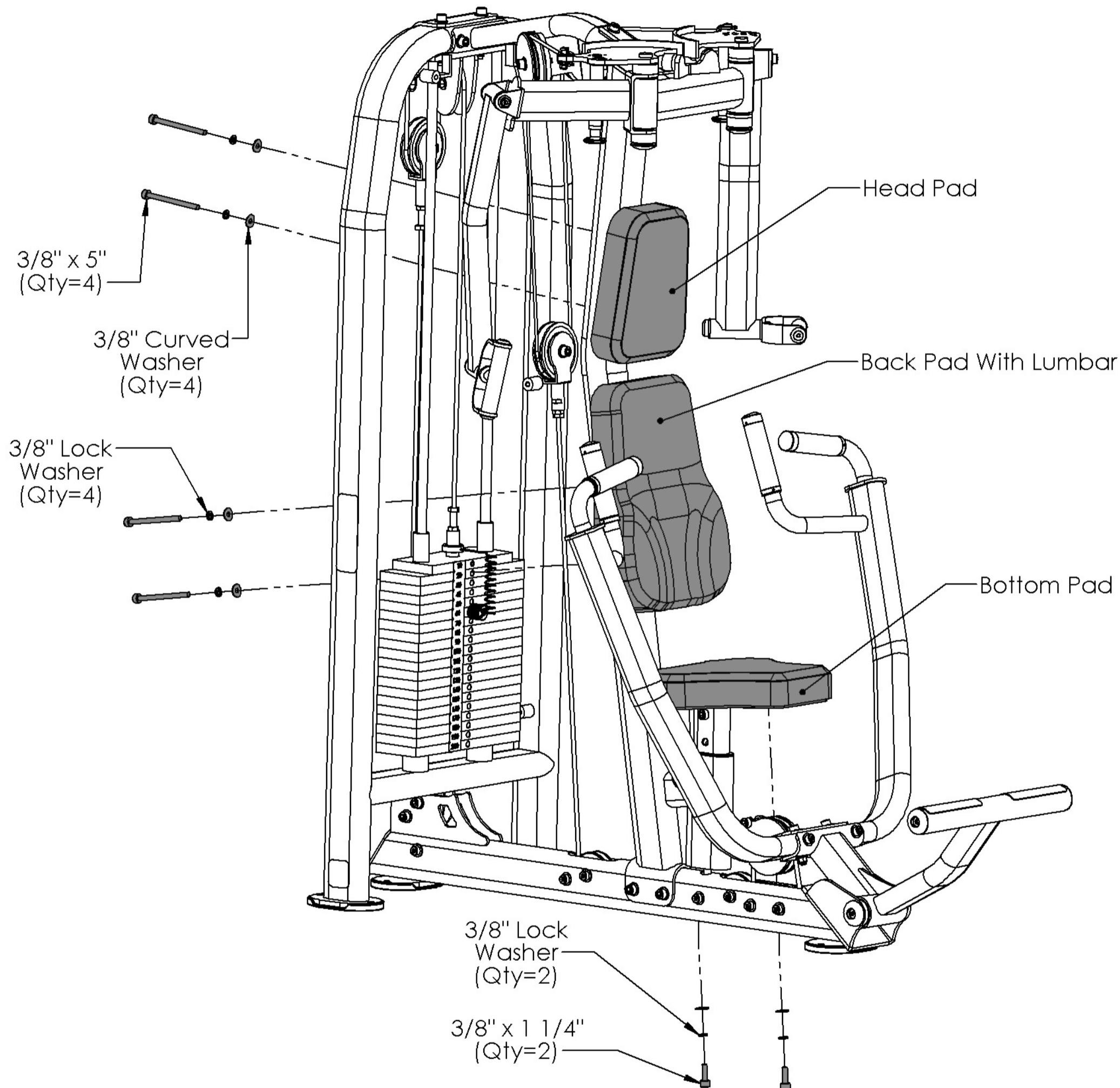
 Every place that a pulley is inside a tube there must be a pulley spacer in use instead of a flat washer.



All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
CAB-15001	Free Floater to Free Floater Cable	1
BFP-10838	Free Floater	1
BFH-50173	3 1/2" Pulley	3
BFH-50174	4 1/2" Pulley	2
BFP-51746	1/2" Pulley Spacer	6
BFP-51759	SHCS 3/8" x 2"	1
BFP-51752	SHCS 3/8" X 2 1/4"	2
BFP-51750	SHCS 3/8" x 2 3/4"	5
BFH-50146	3/8" Flat Washer	8
BFH-50157	3/8" Nylock	8

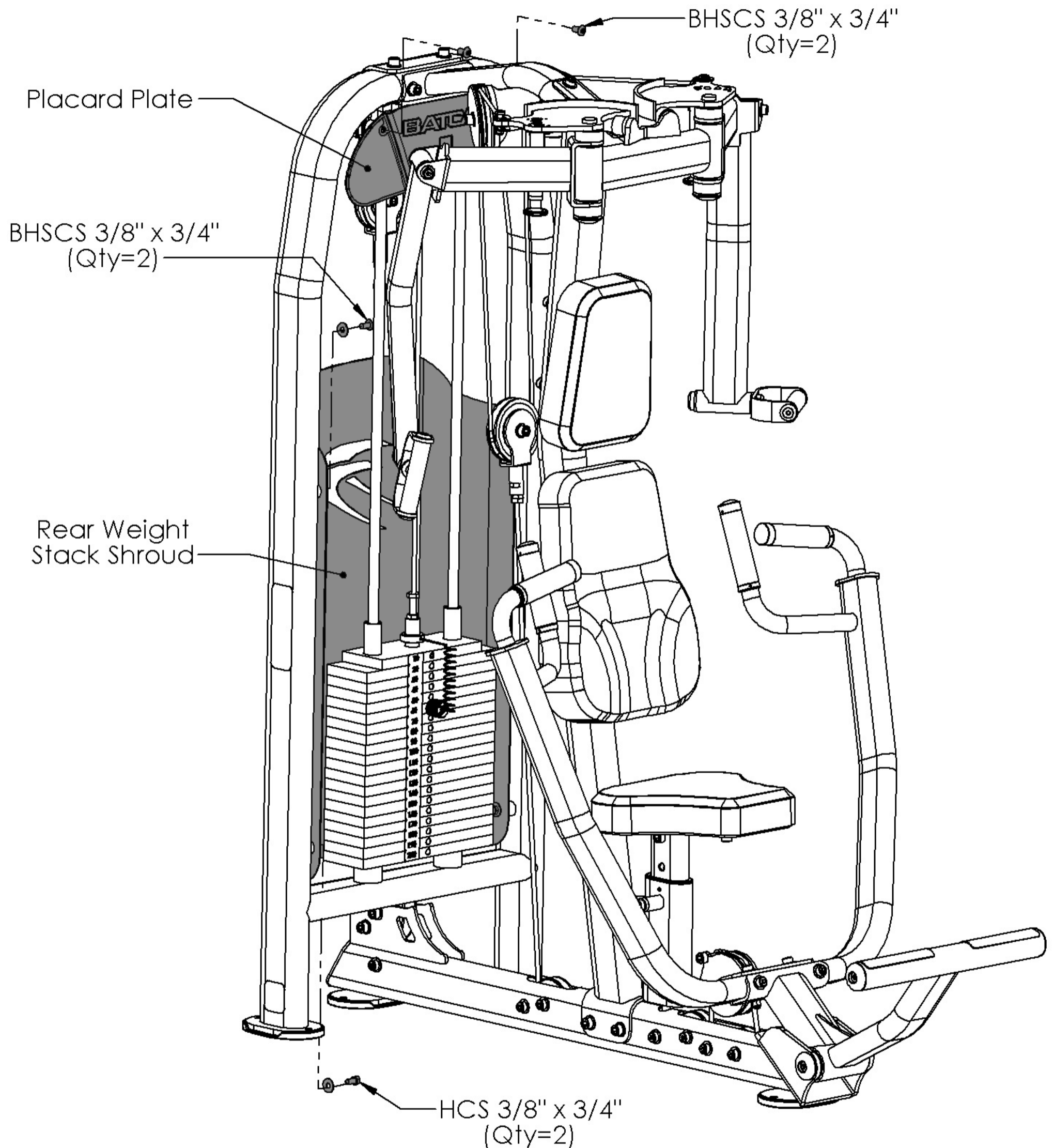
**Step 11:**  **Make sure all bolts are tightened before moving on**



All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFU-10187	Head Pad	1
BFU-10189	Back Pad With Lumbar	1
BFU-10186	Bottom Pad	1
BFP-51653	SHCS 3/8" x 1 1/4"	2
BFP-51799	SHCS 3/8" X 5"	4
BFH-50147	3/8" Lock Washer	6
BFH-50146	3/8" Flat Washer	2
BFH-50204	3/8" Curved Washer	4

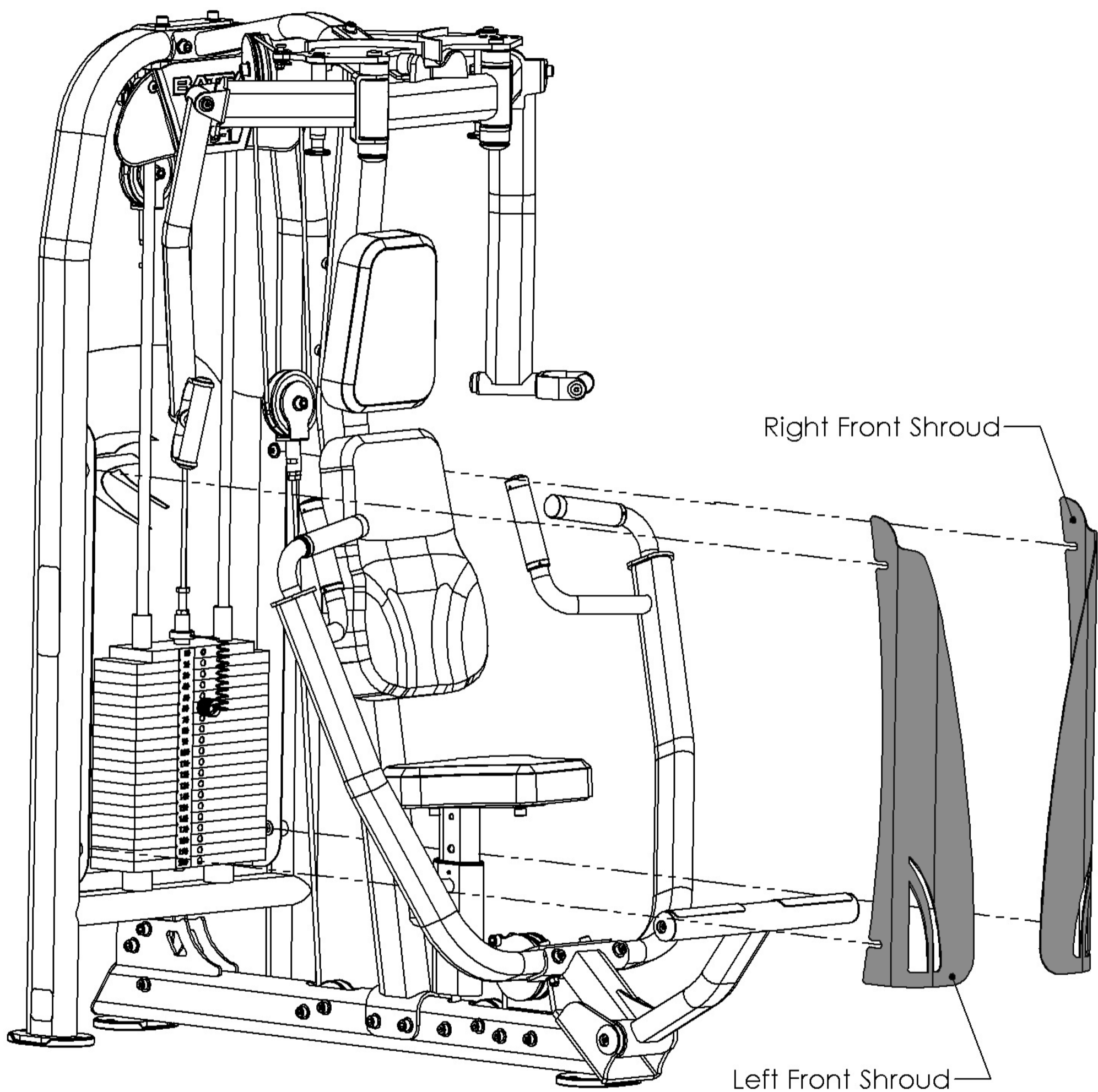
**Step 12:**  **DO NOT** tightened the four bolts for the Rear Weight Stack Shroud until next step.



All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFM-11301	LD-1 Placard Plate	1
BFP-51740	Rear Weight Stack Shroud	1
BFH-50254	HCS 3/8" x 3/4"	2
BFP-52430	BHSCS 3/8" x 3/4"	4
BFH-50146	3/8" Flat Washer	4

Step 13:  Make sure all bolts are tightened before moving on

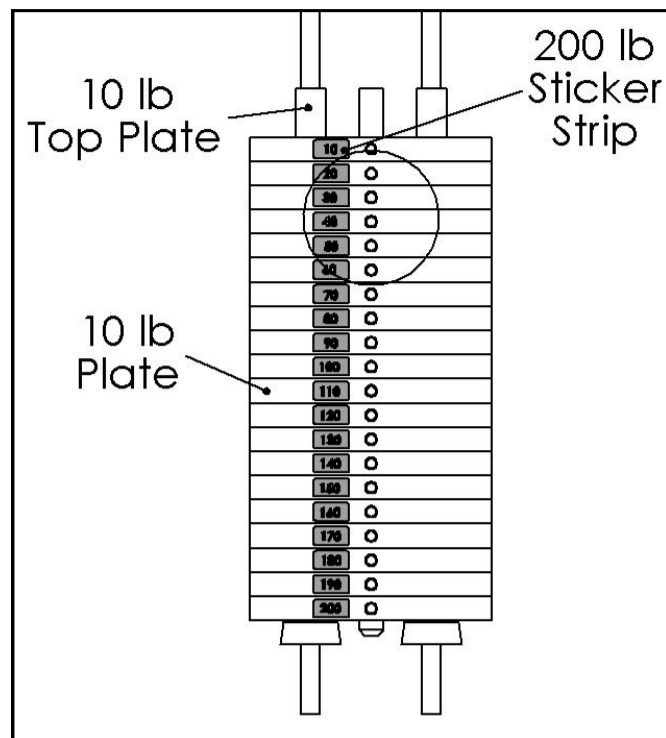


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

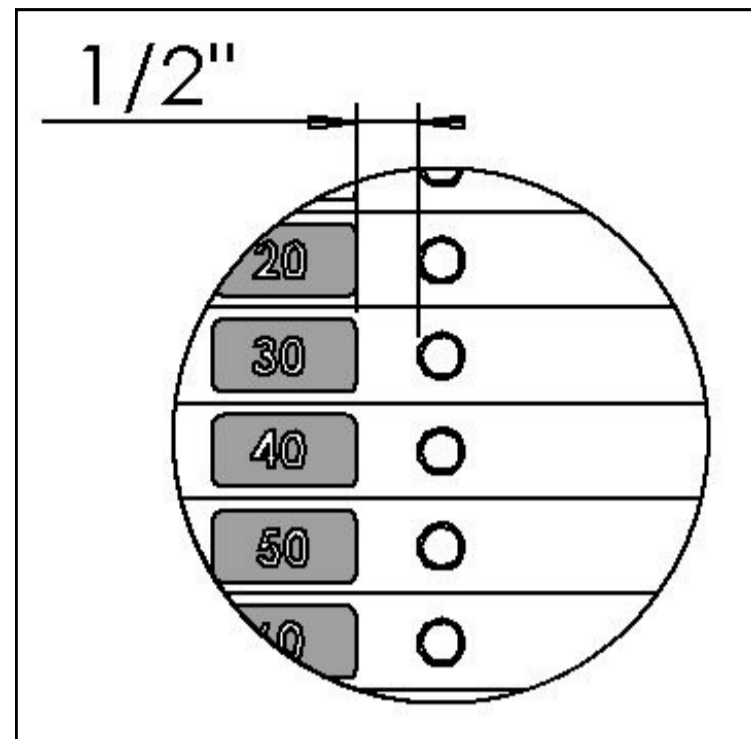
Part #	Description	Qty
BFP-51742	Front Weight Stack Shroud (Right)	1
BFP-51741	Front Weight Stack Shroud (Left)	1

# Final Assembly and Troubleshooting

## Weight Stack Decals:

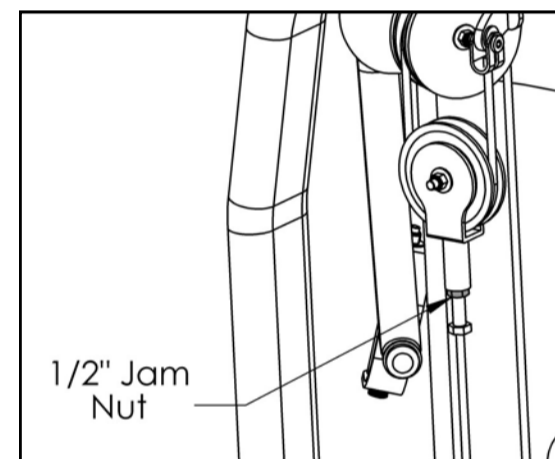


200lb Stack

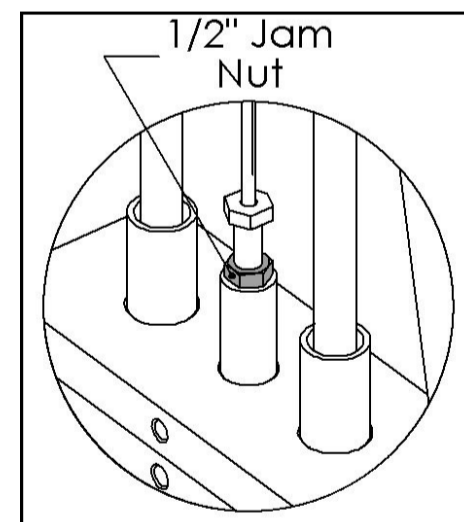


## IMPORTANT - Check These Components Before Using

- Each Cable with a threaded bolt on either end **must be threaded at least 1/2"** into its attachment, whether it be a Free Floater, Lockout Free Floater, or the Top Plate of the weight stack. Each must also be secured with a 1/2" Jam Nut to ensure a safe and proper connection.



Free Floater



Top Plate



- Record** your serial number on the front of this manual and keep for your records. The serial number can be found on the side of the cage as seen in the figure to the left.

## Guide Rod

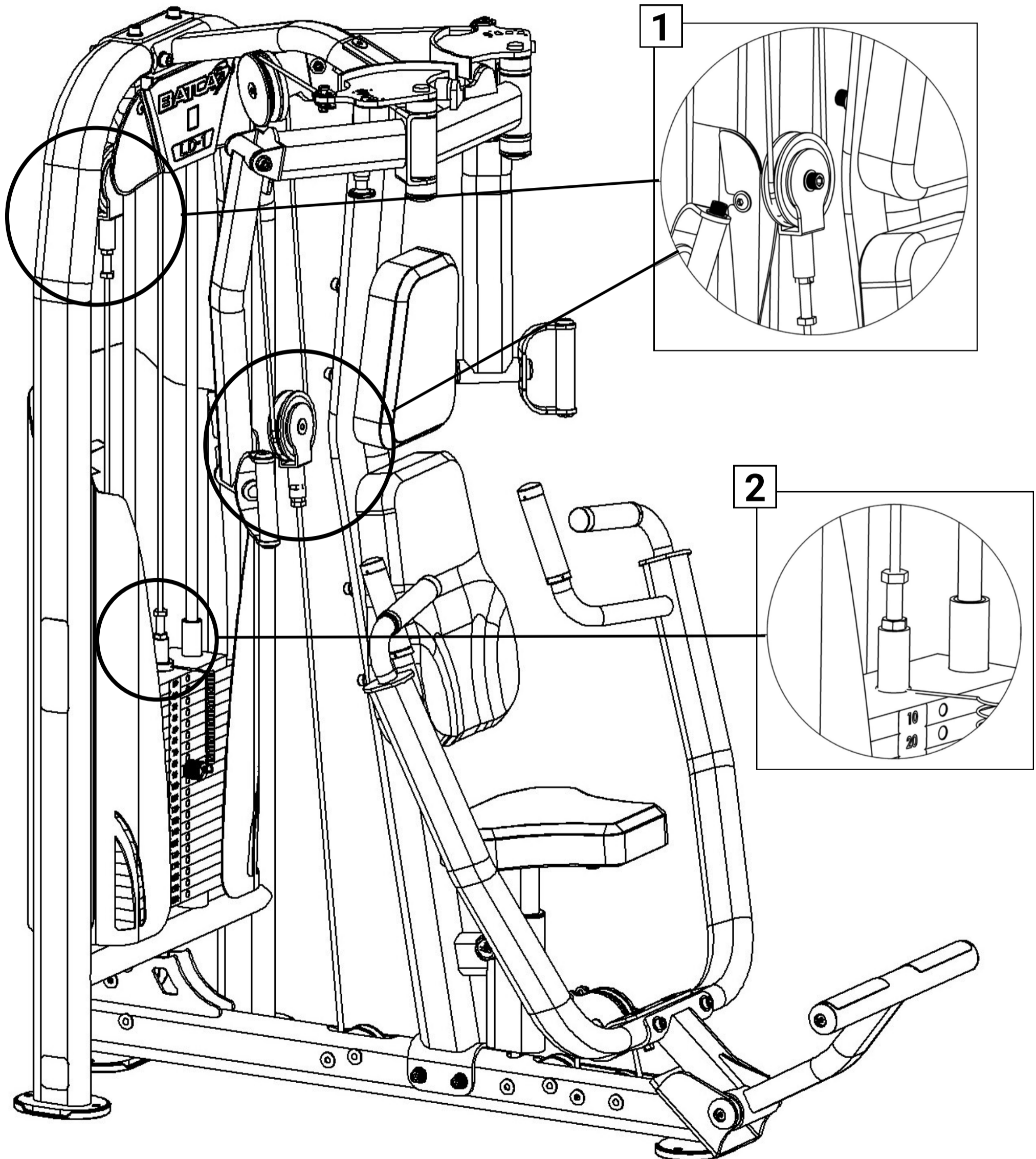
- Clean guide rods with a lint-free cloth and apply a thin layer of silicone lubricant (Part # BFH-50262) to each guide rod. This will ensure a glass smooth performance from your weight stack.

# Cable Adjustments

- **Adjust** cables to proper tension from any of the locations shown below.

**⚠ Note:** All cables with threaded adjustable ends must have at least 1/2" of the threads threaded in to its counterpart. It is very important that the 1/2" Jam Nut be wrench tightened to the counterpart to ensure that the threaded adjustable end of the cable does not back out of its counterpart.

- **Note:** If the top plate raises off of the second plate in the weight stack, then the cable tension is too tight. You will need to take some of the tension out to lower the Top plate flush with the second plate.



# Preventive Maintenance

Batca Fitness Systems strives to give you the very best in quality, performance and safety through carefully engineered designs and excellent workmanship. In order to maintain this high level of quality the preventative maintenance schedule below should be followed.

Clean upholstery, grips, and roller pads with mild soap and water generally after every use. The guide rods, chrome slides and frame should be cleaned with a cotton cloth. Upon cleaning the guide rods, a thin layer of Silicone or Teflon gel should be applied to each rod to ensure a glass smooth performance.

An overall inspection should be done before each workout. If the warning and safety decals are worn or have been removed they should be replaced immediately. The cables and cable systems should be inspected for signs of wear and proper tension. In order to check cables properly you should carefully run the cable through your fingertips, checking for signs of wear, cracks, burs and thinning spots. Replace any part at first signs of wear. Cables should be adjusted for proper tension. See assembly instructions for this detail. All hardware, stops, and adjustments should be checked and tightened as required.

The guide rods on your machine should be cleaned and lubricated regularly. This will ensure a glass smooth performance from your weight stack. A thin layer of either Silicone or Teflon gel should applied to each rod.

Although cables should be inspected daily, it is important that ALL cables be replaced as directed in the schedule below. Please note that at any first sign of wear the cable should be replaced immediately.

If there are any questions concerning maintenance, please contact your local Batca dealer or contact Batca Fitness Systems directly at:

Batca Fitness Systems  
(919) 255-1233  
www.batcafitness.com

	Daily		Weekly		Monthly		Quarterly		Years	
	Commercial	Home	Commercial	Home	Commercial	Home	Commercial	Home	Commercial	Home
<b>Clean</b>										
Upholstery	X			X						
Hand Grips	X			X						
Roller Pads	X			X						
Guide Rods			X			X				
Chrome Slides			X			X				
Frame			X			X				
<b>Inspect</b>										
Overall	X	X								
Safety Decals	X	X								
Cables	X	X								
Cable Tension			X			X				
Pulleys	X	X								
Hardware	X	X								
Stops	X	X								
Upholstery	X	X								
Hand Grips			X			X				
Frame			X			X				
Bushings	X			X						
Bearings	X			X						
<b>Lubricate</b>										
Guide Rods			X			X				
Bearings							As Needed			1
<b>Replace</b>										
Cables									1	3

# Limited Lifetime Warranty

## **What is covered**

### For Residential Use:

Batca Fitness Systems warrants all of its products against defects in manufacturing, materials and workmanship under normal use and service for one year from date of purchase including paint, chrome, upholstery and grips. Batca Fitness Systems also warrants all cables, belts, bolts, nuts, caps, plugs, bumpers, washers, levelers, decals, gas springs and other hardware for three years after date of purchase; all moving parts, including pulleys, bushings, bearings and pull pins for five years after date of purchase and warrants the frame and all welded parts for the lifetime of the original purchaser.

### For Commercial Use:

Batca Fitness Systems warrants all of its products against defects in manufacturing, materials and workmanship under normal use and service for six months from date of purchase including paint, chrome, upholstery and grips. Batca Fitness Systems also warrants all cables, belts, bolts, nuts, caps, plugs, bumpers, washers, levelers, decals, gas springs and other hardware for one year after date of purchase; all moving parts, including pulleys, bushings, bearings and pull pins for three years after date of purchase and warrants the frame and all welded parts for ten years after date of purchase.

## **What is not covered**

This warranty does not cover damage, which results from shipping, misuse, abuse, neglect, carelessness, modification or alteration, accident, fire, flood, "acts of God" or other contingencies beyond the control of Batca Fitness Systems. This warranty also does not cover deterioration from wear and tear or exposure or any defect, which would not have happened if instructions in the owner's manual had been followed. Improper installation, improper assembly or follow-up maintenance along with installation of parts or accessories not originally intended for products of Batca Fitness Systems are also not covered by this warranty. Only genuine Batca parts should be used for replacement, repair, and maintenance for this warranty to apply.

Defective parts will be repaired or replaced at Batca Fitness Systems option, without parts charge to the purchaser. All returns require a return authorization prior to acceptance of repair work. Batca Fitness Systems reserves the right to make design changes without any prior notification and shall not be responsible for incidental or consequential damages.

The purchaser is responsible for shipping the defective part back to the factory. Repair or replacement is the exclusive and sole remedy of the purchaser. Labor charges associated with parts changeovers are not covered by this warranty. Proof of purchase, serial number, model number and date of purchase will be required along with all pertinent information of the alleged damage.

This warranty applies only to the original purchaser and is not transferable. Claims under this warranty must be made directly to Batca Fitness Systems.

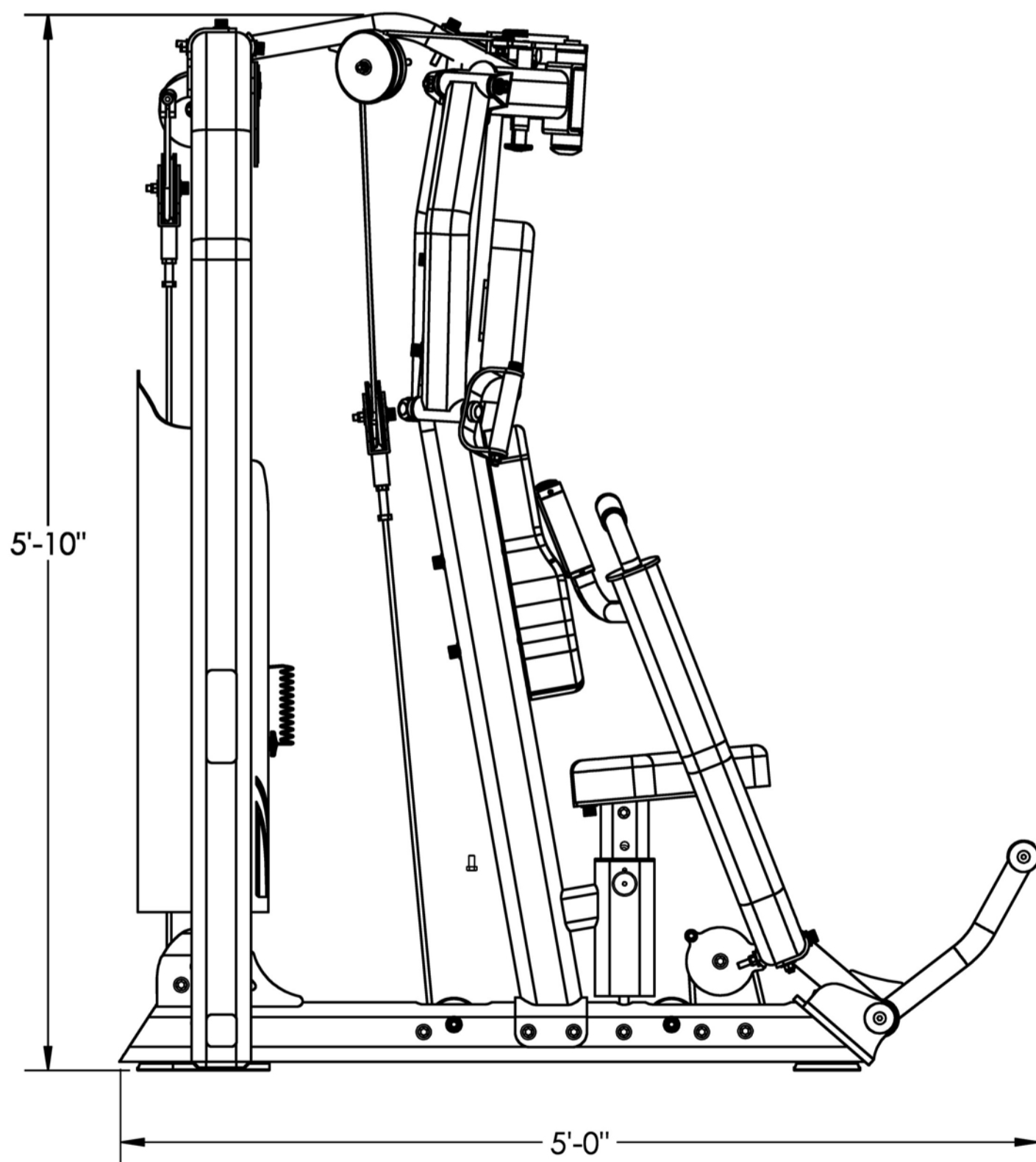
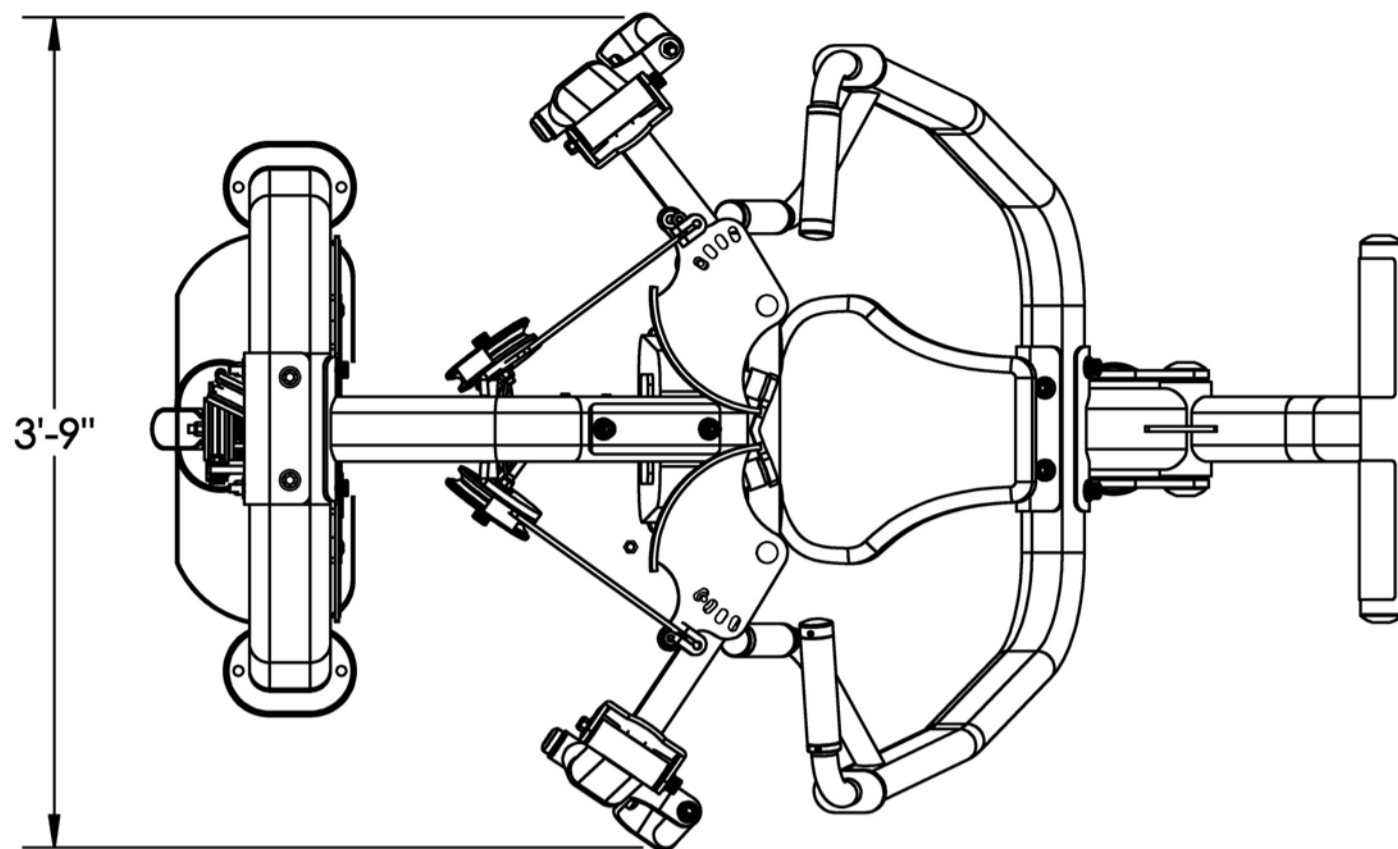
Batca Fitness Systems  
1207 N. New Hope Road  
Raleigh, NC 27610  
(919) 255-1233

[www.batcafitness.com](http://www.batcafitness.com)

Please keep this for your records.



Scan the QR Code to  
register your new  
BATCA Product online!



## Layout Diagram

The LD-1 has a layout dimension of 3'-9" (width) x 5'-0" (length) x 5'-10" (height). There should be a minimum of 18", preferably 24", of working space around the entire unit.