



# FUSION 4

MODULAR GYM SYSTEM

## UPPER BODY UNIT

# OWNER'S MANUAL



SERIAL NUMBER HERE

DATE OF PURCHASE



**BATCA**  
fitness systems · usa

# INSTRUCTIONS

CONGRATULATIONS ON THE PURCHASE OF YOUR NEW FUSION 4 UPPER BODY STATION. 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 MULTI-STATION 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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## FRAME COMPONENTS

ITEM	PART NO.	DESCRIPTION	QTY
1	BFM-10566	RIGHT VERTICAL SUPPORT	1
2	BFM-10593	REAR BASE	1
3	BFM-10753	MIDDLE FRAME ASSEMBLY	1
4	BFM-10770	FRONT BASE SUPPORT	1
5	BFM-10583	TOP SWIVEL PULLEY HOLDER	2
6	BFM-10567	LEFT VERTICAL SUPPORT	1
7	BFM-10299	TOP WEIGHT PLATE	1
8	BFM-51082	SHROUD	2
9	BFM-51487	GUIDE ROD HOLDER	1
10	BFM-51051	GUIDE ROD	2
11	BFM-50256	WEIGHT STACK PLATE	19
12	BFM-50529	RUBBER DONUT	2
13	BFM-10733	RIGHT SWING ARM ASSEMBLY	1
14	BFM-10737	LEFT SWING ARM ASSEMBLY	1
15	BFM-10735	RIGHT PRESS ARM ASSEMBLY	1
16	BFM-10736	LEFT PRESS ARM ASSEMBLY	1
17	BFM-51148	1" ARM SHAFT	1
18	BFM-51080	SPACER	1
19	BFM-10741	SEAT FRAME ASSEMBLY	1
20	BFM-10580	BACK CHROME ADJUSTMENT	1
21	BFM-10577	8" ADJUSTMENT SLEEVE	1
22	BFM-10579	10" CHROME ADJUSTMENT	1
23	BFM-50931	THREADED AXLE	1
24	BFM-10755	PRESS ARM CABLE LOCKOUT	1
25	BFM-10611	CRISS-CROSS FREE FLOATER	1
26	BFM-10133	FREE FLOATER	2
27	BFM-50345	4-1/2" PULLEY COVER	2
28	BFM-51022	1-1/4" PULLEY SPACER	6
29	BFM-50505	3-1/2" PULLEY COVER	8
30	BFL-50197	MIDDLE FRAME CONNECTOR PLATE	2

## ACCESSORIES

ITEM NO.	PART NO.	DESCRIPTION	QTY
31	BFM-51173	WEIGHT STACK PULL PIN	1
32	BFM-10771	PRESS ARM LOCK	1
33	BFC-10103	STRAP HANDLE	2

## UPHOLSTERY

ITEM NO.	PART NO.	DESCRIPTION	QTY
34	BFU-10118	BOTTOM PAD	1
35	BFU-10119	HEAD PAD	1
36	BFU-10120	BACK PAD WITH LUMBAR	1
37	BFU-50189	7" UPHOLSTERY ROLLER	2

## CABLES

ITEM	PART NO.	DESCRIPTION	QTY
38	CAB-13022	WEIGHT STACK TO CABLE TIE OUT	1
39	CAB-13030	FUSION FLOATING PULLEY CABLE	1
40	CAB-13031	FUSION LAT PULL TO CABLE LOCKOUT	2
86	CAB-13032	FUSION LAT PULL TO FUNCTIONAL ARM	2

## HARDWARE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY	ITEM NO.	PART NUMBER	DESCRIPTION	QTY
41	BFH-50253	BEVELED LEVELER	2	60	BFP-51653	SHCS 3/8"-16 x 1-1/4"	4
42	BFH-50337	WAVY WASHER	4	61	BFH-50173	3-1/2" PULLEY	16
43	BFH-50165	1" SNAP RING	6	62	BFH-50174	4 1/2" PULLEY	6
44	BFH-50149	3/8" JAM NUT	2	63	BFH-50250	1-1/4" SHOULDER BOLT	3
45	BFP-52394	SHCS 3/8"-16 x 2-1/2"	2	64	BFH-50267	5/16" NYLOCK	3
46	BFP-51799	SHCS 3/8"-16 x 5"	4	65	BFP-51752	SHCS 3/8"-16 x 2-1/4"	8
47	BFP-51756	SHCS 3/8"-16 x 5-1/4"	6	66	BFH-50204	3/8" CURVED WASHER	4
48	BFH-50146	3/8" FLAT WASHER	74	67	BFH-50203	1/2" CURVED PULLEY SPACER	8
49	BFH-50147	3/8" LOCK WASHER	14	68	BFP-51759	SHCS 3/8"-16 x 2"	4
50	BFH-50157	3/8" NYLOCK	39	69	BFP-51750	SHCS 3/8"-16 x 2-3/4"	8
51	BFP-52340	SHCS 3/8"-16 x 3/4"	2	70	BFP-51753	SHCS 3/8"-16 x 4-3/4"	6
52	BFP-52401	BHSCS 3/8"-16 x 1/2"	4	71	BFH-50622	ROLLER END CAP	2
53	BFH-50144	FHSCS 3/8"-16 x 3/4"	2	72	BFP-52430	BHSCS 3/8"-16 x 3/4"	2
54	BFH-50220	SHAFT COLLAR	2	73	BFP-52398	SHCS 3/8"-16 x 7"	1
55	BFP-52400	SHCS 1/2"-13 x 4 1/4"	1	74	BFP-52397	SHCS 1/2"-13 x 3"	1
56	BFH-51201	SHCS 1/2"-13 x 3 1/2"	1	87	BFH-50192	WEIGHT STACK DECALS	1
57	BFP-51747	SHCS 3/8"-16 x 3"	2	88	BFH-50262	SILICON GEL PACK	1
58	BFH-50251	1/2" FLAT WASHER	2				

## FUNCTIONAL ARM COMPONENTS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
74	BFM-10573	FUNCTIONAL ARM MOUNT	1
75	BFM-10571	USER RIGHT FUNCTIONAL ARM	1
76	BFM-10572	USER LEFT FUNCTIONAL ARM	1
77	BFM-10582	FUNCTIONAL ARM SWIVEL PULLEY	2

## FUNCTIONAL ARM HARDWARE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
79	BFH-50146	3/8" FLAT WASHER	16
80	BFH-50157	3/8" NYLOCK	14
81	BFH-50173	3-1/2" PULLEY	8
82	BFP-51752	SHCS 3/8"-16 x 2-1/4"	8
83	BFP-51759	SHCS 3/8"-16 x 2"	6

## FUNCTIONAL ARM ACCESSORIES

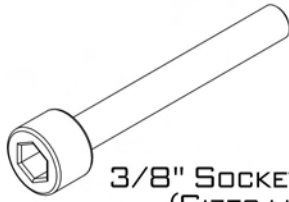
ITEM NO.	PART NUMBER	DESCRIPTION	QTY
84	BFH-10103	STRAP HANDLE	2

## CABLES

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
85	CAB-13032	FUSION LAT PULL TO FUNCTIONAL ARM	2

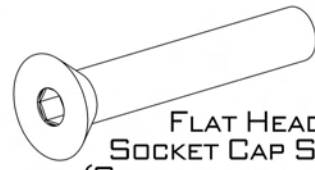
## TOOLS REQUIRED

- 1/2" WRENCH
- 9/16" WRENCH
- 9/16" RATCHET
- 3/4" WRENCH
- 3/4" RATCHET
- ALLEN WRENCH SET
- TAPE MEASURE
- SNAP RING PLIERS



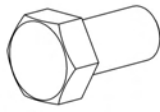
**3/8" SOCKET HEAD CAP SCREW**  
(SIZES LISTED IN CHART)

PART #	BOLT SIZE
BFP-52340	3/8" x 3/4"
BFP-52376	3/8" X 1"
BFP-51653	3/8" x 1 1/4"
BFP-51697	3/8" x 1 1/2"
BFP-51759	3/8" x 2"
BFP-51752	3/8" x 2 1/4"
BFP-51750	3/8" x 2 3/4"
BFP-51747	3/8" x 3"
BFP-51748	3/8" x 3 1/4"
BFP-51760	3/8" x 3 1/2"
BFP-52345	3/8" x 4"
BFP-51884	3/8" X 4 1/4"
BFP-51751	3/8" x 4 1/2"
BFP-51753	3/8" x 4 3/4"
BFP-51799	3/8" x 5"
BFP-51756	3/8" x 5 1/4"
BFP-52364	3/8" x 6"

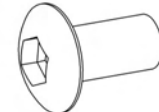


**FLAT HEAD SOCKET CAP SCREW**  
(SIZES LISTED IN CHART)

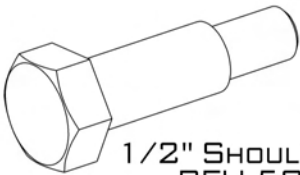
PART #	BOLT SIZE
BFH-50144	FHSCS 3/8"-16 x 1"
BFP-52377	FHSCS 3/8" x 2"
BFH-50145	FHSCS 3/8"-16 x 2 1/4"
BFP-52374	FHSCS 3/8" x 2 3/4"



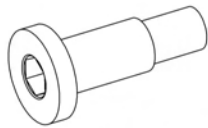
**HEX HEAD CAP SCREW (HCS) 3/8" x 3/4"**  
(BFH-50254)



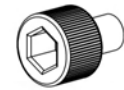
**BUTTON HEAD SOCKET CAP SCREW (BHSCS) 3/8" x 3/4"**  
BFP-52430



**1/2" SHOULDER BOLT**  
BFH-50249



**1 1/4" SHOULDER BOLT**  
BFH-50250



**ZINC PLATED SHCS 5/16" x 1/2"**  
(BFP-52372)



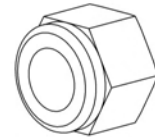
**5/16"-18 NYLOCK**  
BFH-50267



**3/8"-16 THIN NYLOCK**  
BFH-50247



**3/8"-16 NYLOCK**  
BFH-50157



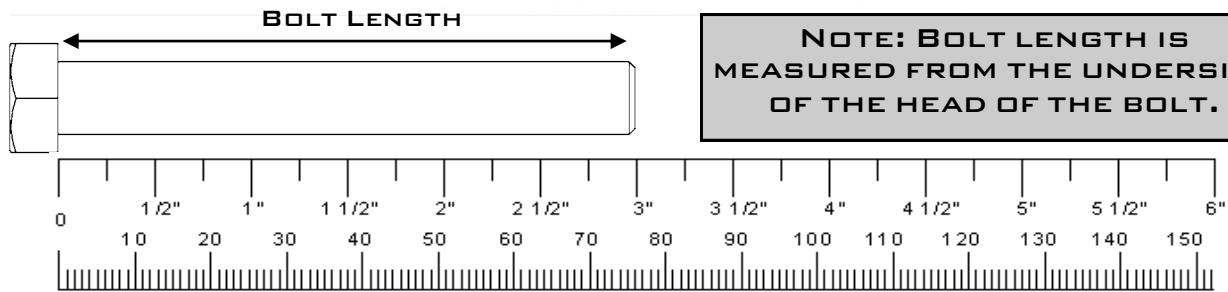
**1/2"-13 NYLOCK**  
BFH-50251

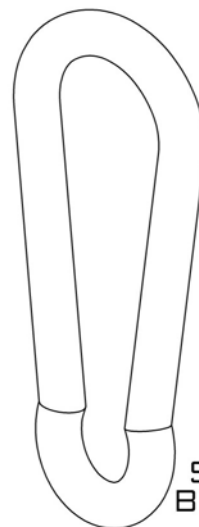
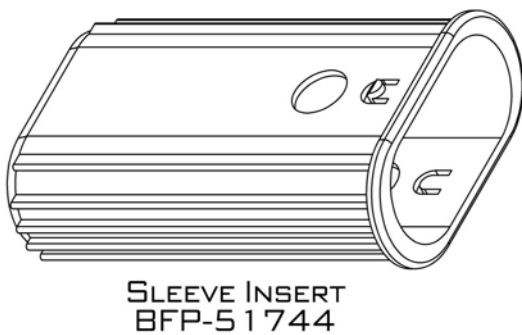
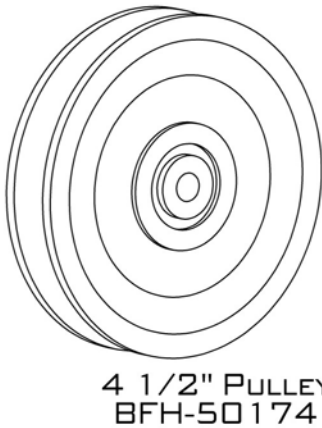
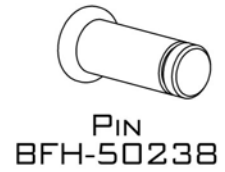
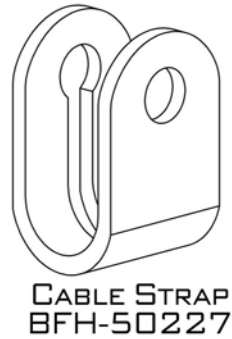
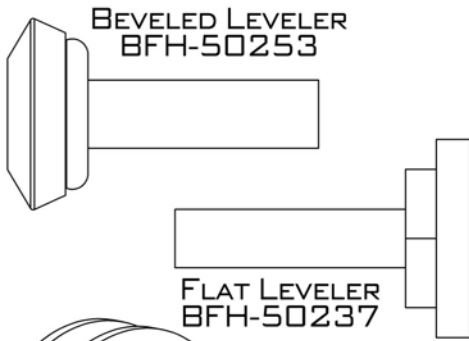


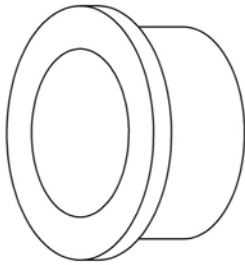
**1/2" JAM NUT**  
BFH-50256



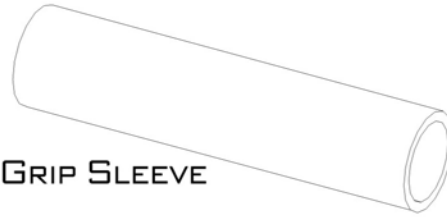
**3/8" JAM NUT**  
BFH-50149



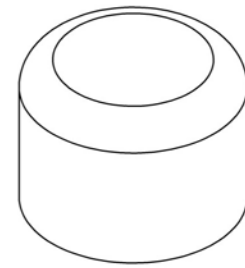




1" BRONZE BUSHING  
BFH-50101



GRIP SLEEVE



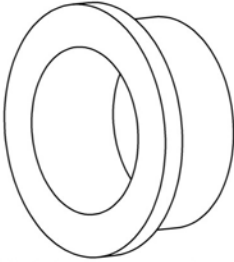
1" OUTER PLASTIC CAP  
BFH-50111



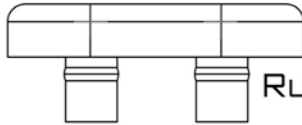
GRIP CAP



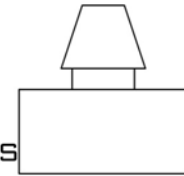
GRIP COLLAR



1" BRONZE BUSHING X 1/2 L  
BFH-50297



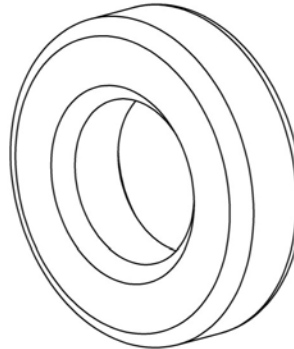
RUBBER BUMPERS  
BFH-50222



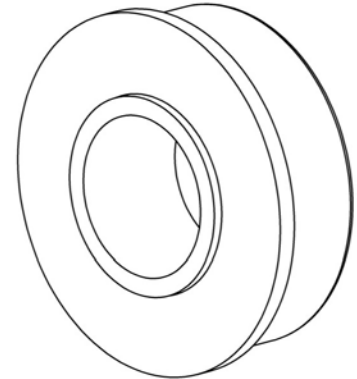
BFH-50200



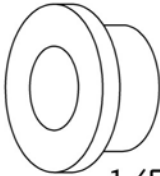
5/8" BRONZE BUSHING  
BFH-50102



RADIAL BEARING  
BFH-50602



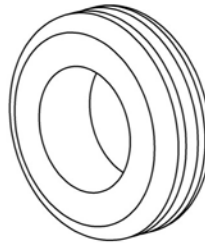
FLANGED RADIAL BEARING  
BFP-51949



1/2" BRONZE BUSHING  
BFH-50103



CABLE PIVOT BUSHING  
BFH-50248



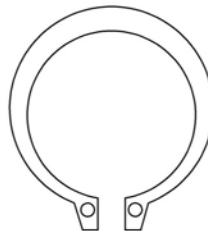
RUBBER GROMMET  
BFH-50199



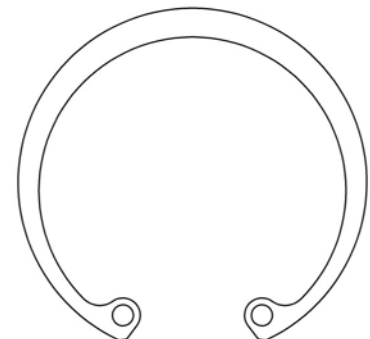
SHORT 1/2" BUSHING  
BFH-50244



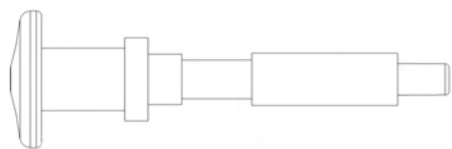
1/2" SNAP RING  
BFH-50166



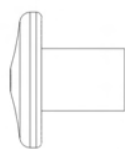
1" SNAP RING  
BFH-50165



2 1/2" SNAP RING  
BFH-50604



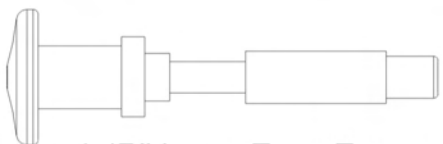
3/8" LONG PULL PIN  
BFM-51176



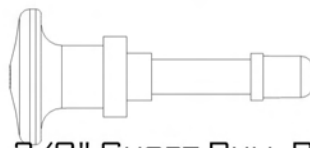
PULL PIN HANDLE  
BFM-51181



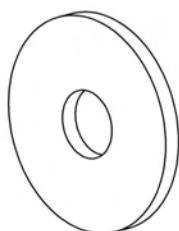
PLASTIC END CAP  
(BFP-52101)



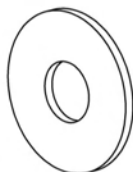
1/2" LONG PULL PIN  
BFM-51172



3/8" SHORT PULL PIN  
BFM-51175



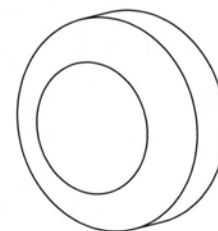
3/8" FENDER WASHER  
BFH-50242



3/8" FLAT WASHER  
BFH-50146



3/8" CURVED WASHER  
BFH-50204



SCREW CAP COVER  
BFH-50112



SCREW CAP WASHER  
BFH-50113



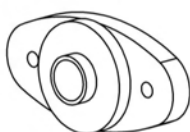
3/8" LOCK WASHER  
BFH-50147



MAGNETIC WEIGHT STACK PIN  
BFM-51173



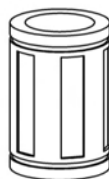
BAR CATCH RUBBER  
SLEEVE  
BFH-50240



SIDE MOUNTED  
FLANGE BEARING  
BFH-50171

**ITEMS NOT SHOWN.**

PART #	DESCRIPTION
BFH-50259	MIDNIGHT BLACK PAINT
BFH-50278	SILVER METALLIC PAINT
BFH-50198	LARGE LOGO
BFH-50236	FOAM GRIP
BFH-50262	SILICON GEL PACK
BFC-10101	1 INCH CHAIN
BFC-10102	12 INCH CHAIN



LINEAR BEARING  
BFH-50627



BEARING RETAINING  
CLIP  
BFH-50628





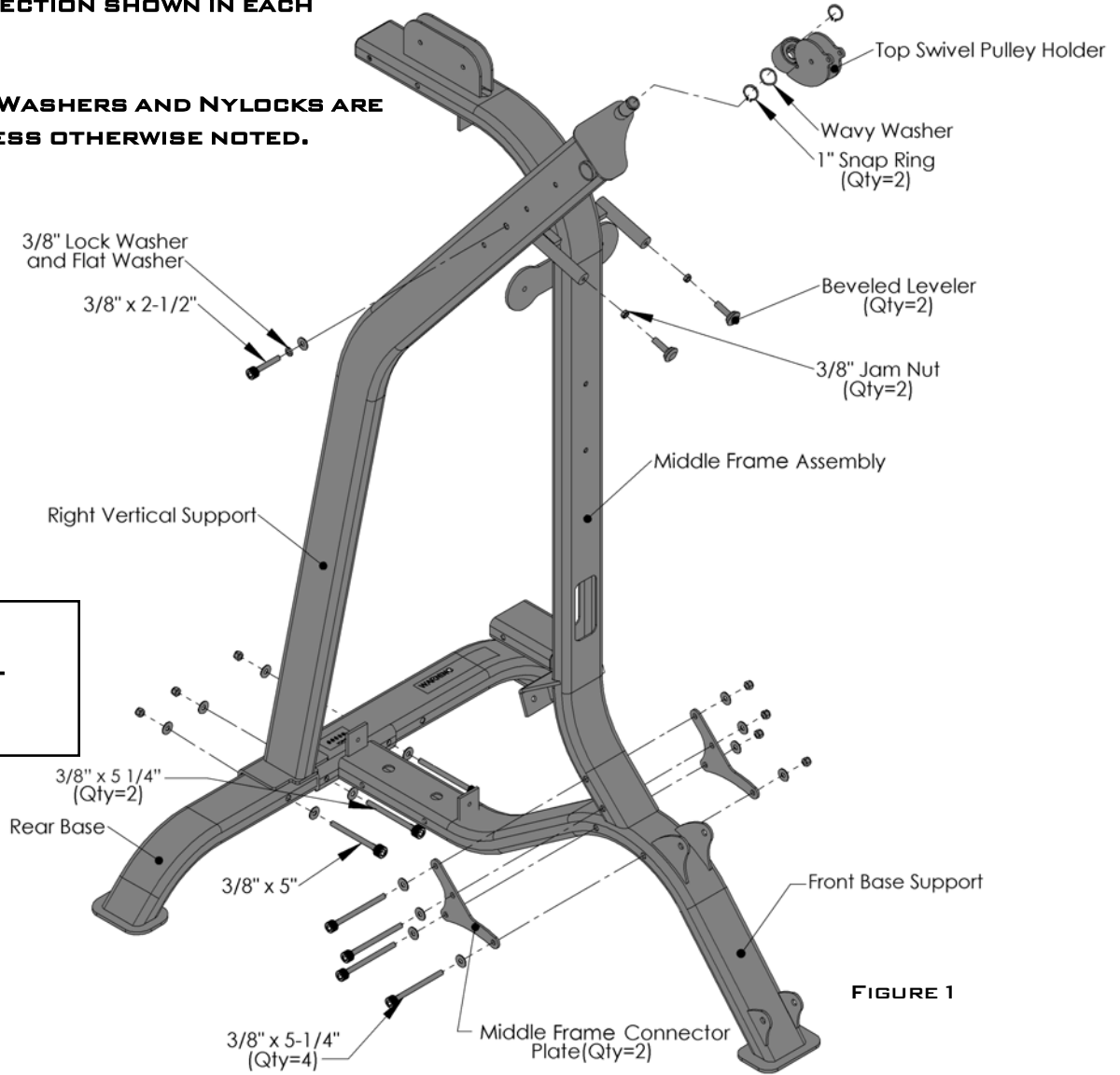
**PLEASE FOLLOW ALL DIRECTIONS VERY CAREFULLY FOR PROPER INSTALLATION.**

**STEP 1:**



**NOTE: FOR A MORE CONSISTENT APPEARANCE, POSITION ALL BOLTS IN THE DIRECTION SHOWN IN EACH FIGURE.**

- **ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.**



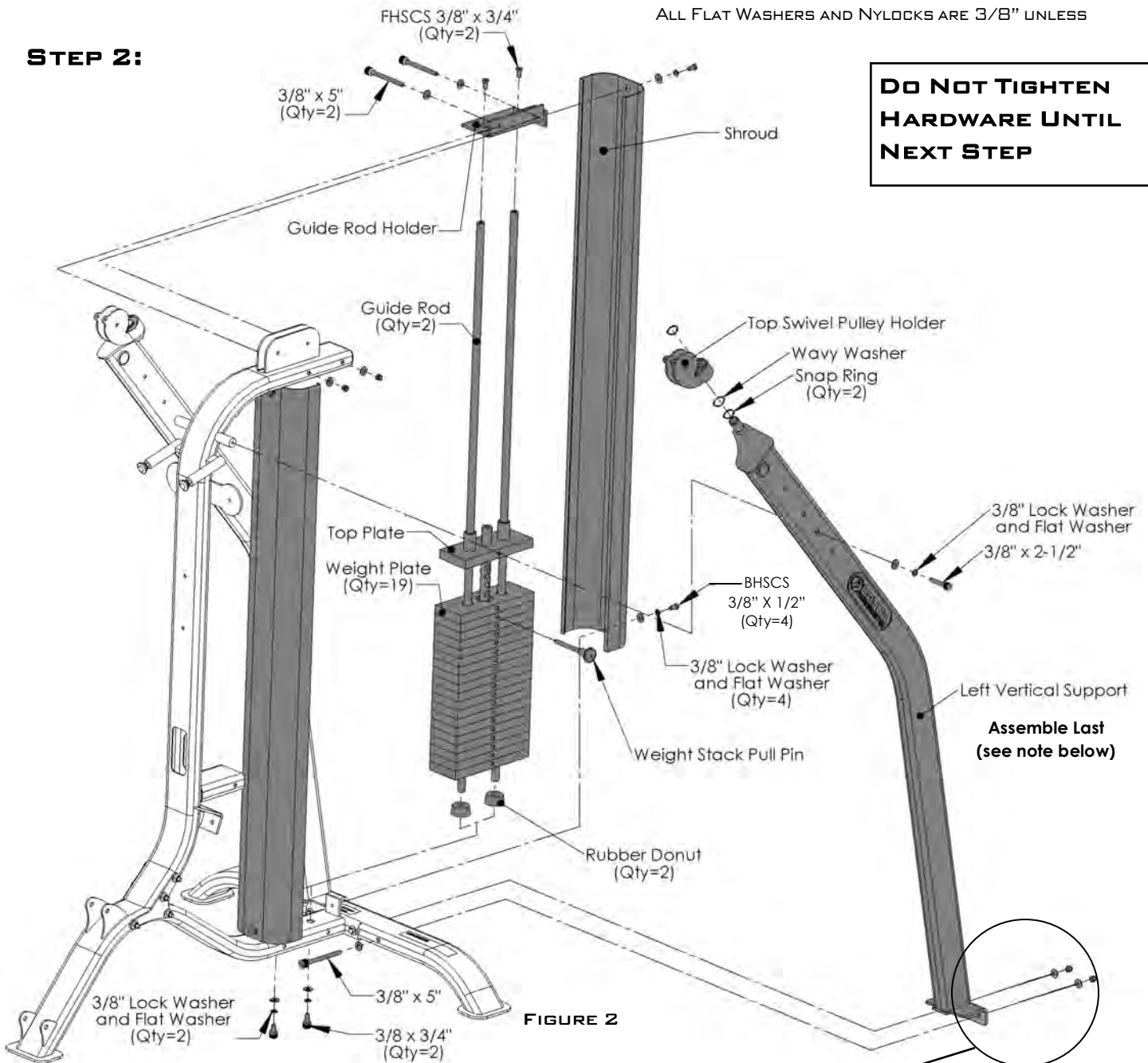
**DO NOT TIGHTEN  
HARDWARE UNTIL  
NEXT STEP**

**FIGURE 1**

ITEM #	PART #	DESCRIPTION	QTY	ITEM #	PART #	DESCRIPTION	QTY
1	BFM-10566	RIGHT VERTICAL SUPPORT	1	44	BFH-50149	3/8" JAM NUT	2
2	BFM-10593	REAR BASE	1	45	BFP-52394	SHCS 3/8"-16 x 2 1/2"	1
3	BFM-10753	MIDDLE FRAME ASSEMBLY	1	46	BFP-551799	SHCS 3/8"-16 x 5"	1
4	BFM-10770	FRONT BASE SUPPORT	1	47	BFP-51756	SHCS 3/8"-16 x 5 1/4"	6
5	BFM-10583	TOP SWIVEL PULLEY HOLDER	1	48	BFH-50146	3/8" FLAT WASHER	15
30	BFL-50197	MIDDLE FRAME CONNECTOR PLATE	2	49	BFH-50147	3/8" LOCK WASHER	1
41	BFH-50253	BEVELED LEVELER	2	50	BFH-50157	3/8" NYLOCK	7
42	BFH-50337	WAVY WASHER	1				
43	BFH-50165	1" SNAP RING	2				

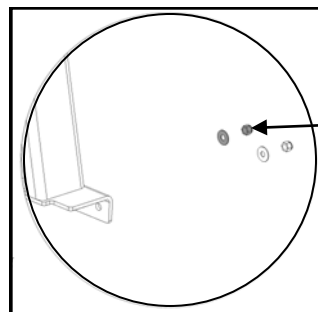
**STEP 2:**

**DO NOT TIGHTEN  
HARDWARE UNTIL  
NEXT STEP**



**FIGURE 2**

ITEM #	PART #	DESCRIPTION	QTY
5	BFM-10583	TOP SWIVEL PULLEY HOLDER	1
6	BFM-10567	LEFT VERTICAL SUPPORT	1
7	BFM-10299	TOP WEIGHT PLATE	1
8	BFM-51082	SHROUD	2
9	BFM-51487	GUIDE ROD HOLDER	1
10	BFM-51051	GUIDE ROD	2
11	BFM-50256	WEIGHT STACK PLATE	19
12	BFM-50529	RUBBER DONUT	2
31	BFM-51173	WEIGHT STACK PULL PIN	1
42	BFH-50337	WAVY WASHER	1
43	BFH-50165	1" SNAP RING	2
45	BFP-52394	SHCS 3/8"-16 x 2 1/2"	1
46	BFP-51799	SHCS 3/8"-16 x 5"	3
48	BFH-50146	3/8" FLAT WASHER	13



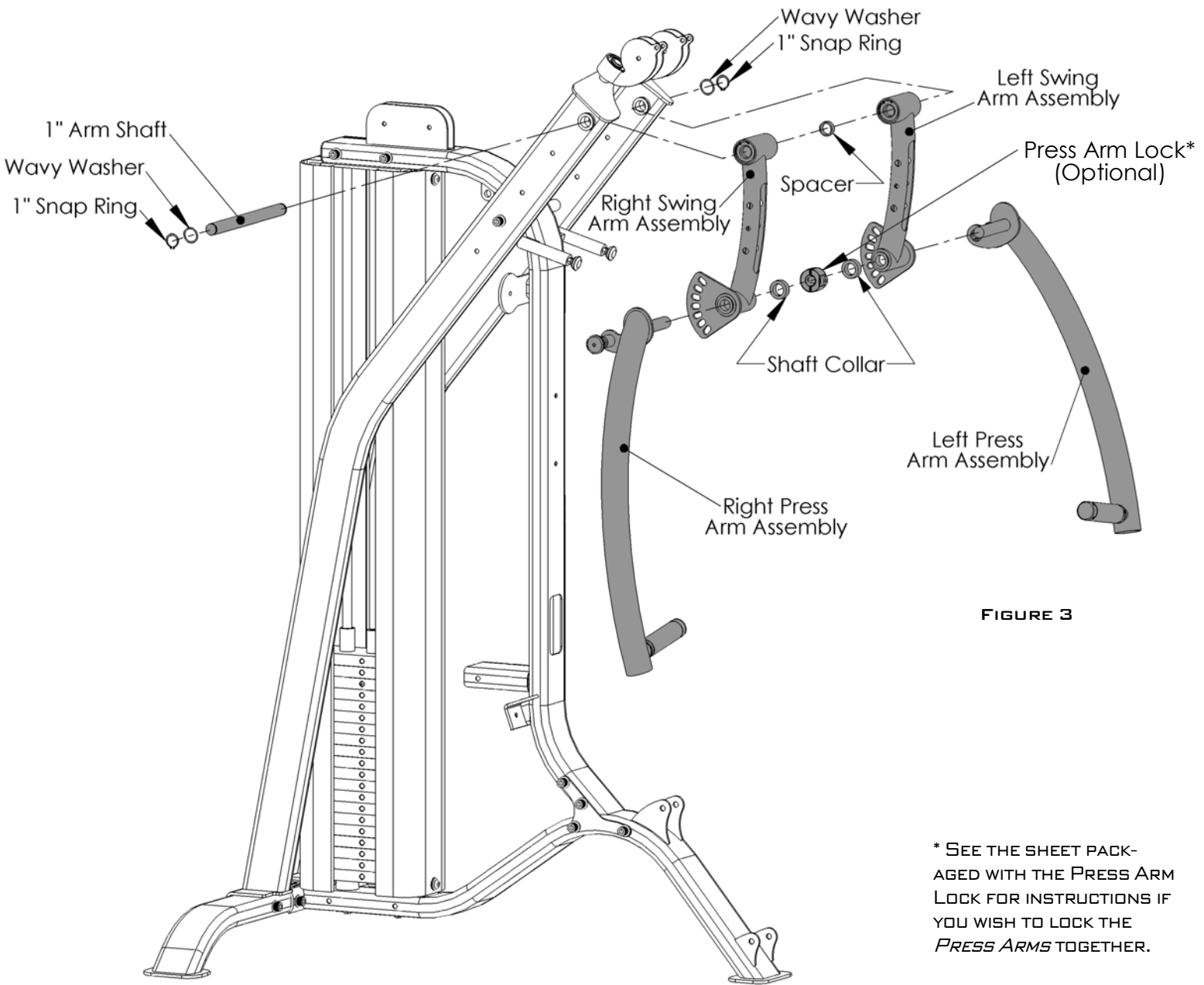
THIS 3/8" NYLOCK AND FLAT WASHER ARE FROM STEP 1.

**DO NOT** REMOVE THE NYLOCK OR INSTALL THE LEFT VERTICAL SUPPORT UNTIL THE WEIGHT STACK AND THE SHROUDS HAVE BEEN COMPLETELY ASSEMBLED.

ITEM #	PART #	DESCRIPTION	QTY
49	BFH-50147	3/8" LOCK WASHER	7
50	BFH-50157	3/8" NYLOCK	3
51	BFP-52340	SHCS 3/8"-16 x 3/4"	2
52	BFP-52401	BHSCS 3/8"-16 x 1/2"	4
53	BFH-50144	FHSCS 3/8"-16 x 3/4"	2

**STEP 3:**

**MAKE SURE ALL  
HARDWARE IS  
TIGHTENED BEFORE  
NEXT STEP.**



**FIGURE 3**

\* SEE THE SHEET PACKAGED WITH THE PRESS ARM LOCK FOR INSTRUCTIONS IF YOU WISH TO LOCK THE PRESS ARMS TOGETHER.

ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.

ITEM #	PART #	DESCRIPTION	QTY
13	BFM-10733	RIGHT SWING ARM ASSEMBLY	1
14	BFM-10737	LEFT SWING ARM ASSEMBLY	1
15	BFM-10735	RIGHT PRESS ARM ASSEMBLY	1
16	BFM-10736	LEFT PRESS ARM ASSEMBLY	1
17	BFM-51148	1" ARM SHAFT	1
18	BFM-51080	SPACER	1

Item #	Part #	Description	Qty
32	BFM-10771	PRESS ARM LOCK	1
42	BFH-50337	WAVY WASHER	2
43	BFH-50165	1" SNAP RING	2
54	BFH-50220	SHAFT COLLAR	2

**STEP 4:**

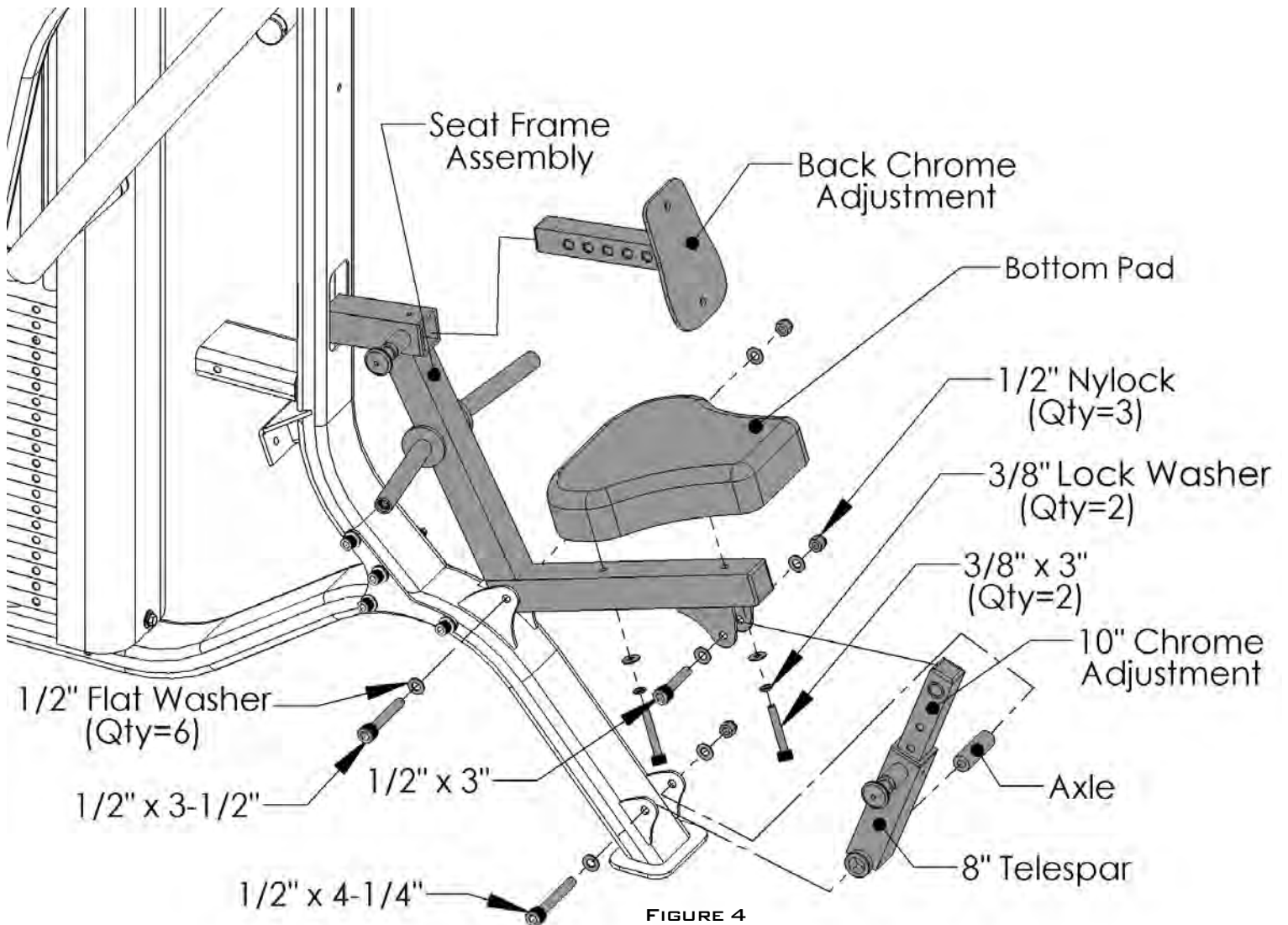


FIGURE 4

ITEM #	PART #	DESCRIPTION	QTY
34	BFU-50118	BOTTOM PAD	1
19	BFM-10741	SEAT FRAME ASSEMBLY	1
20	BFM-10580	BACK CHROME ADJUSTMENT	1
21	BFM-10577	8" ADJUSTMENT SLEEVE	1
22	BFM-10579	10" CHROME ADJUSTMENT	1
23	BFM-50931	THREADED AXLE	1
48	BFH-50146	3/8" FLAT WASHER	2
49	BFH-50147	3/8" LOCK WASHER	2
55	BFP-52400	SHCS 1/2"-13 x 4 1/4"	1
56	BFH-51201	SHCS 1/2"-13 x 3 1/2"	1
57	BFP-52397	SHCS 3/8"-16 x 3"	2
58	BFH-50251	1/2" FLAT WASHER	2
50	BFH-50157	3/8" NYLOCK	2
74	BFH-50136	SHCS 1/2"-13 x 3"	1



**NOTE: MAKE SURE THE *BOTTOM PAD* IS BOLTED ON BEFORE THE *SEAT FRAME ASSEMBLY* IS INSTALLED.**

ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.

**STEP 5:**



**NOTE: IF FUNCTIONAL ARM OPTION IS PURCHASED THEN SKIP THIS STEP**

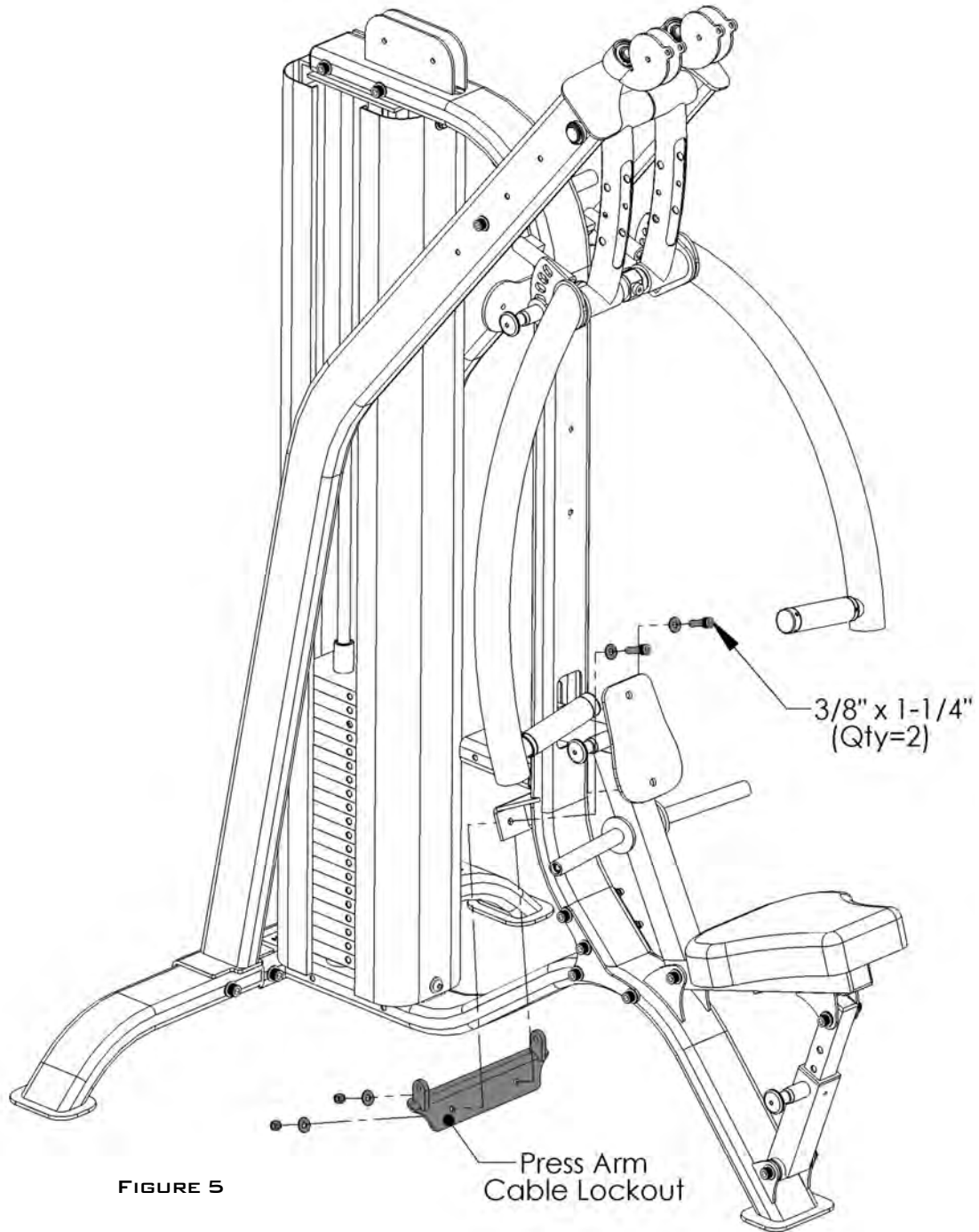


FIGURE 5

ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.

ITEM #	PART #	DESCRIPTION	QTY
24	BFM-10755	PRESS ARM CABLE LOCKOUT	1
48	BFM-50146	3/8" FLAT WASHER	4
50	BFM-50157	3/8" NYLOCK	2
60	BFP-51653	SHCS 3/8"-16 x 1 1/4"	2

# CABLE ROUTING

## STEP 6:



**NOTE: EACH CABLE WITH A THREADED BOLT ON EITHER END MUST BE THREADED AT LEAST 1/2" INTO ITS ATTACHMENT.**

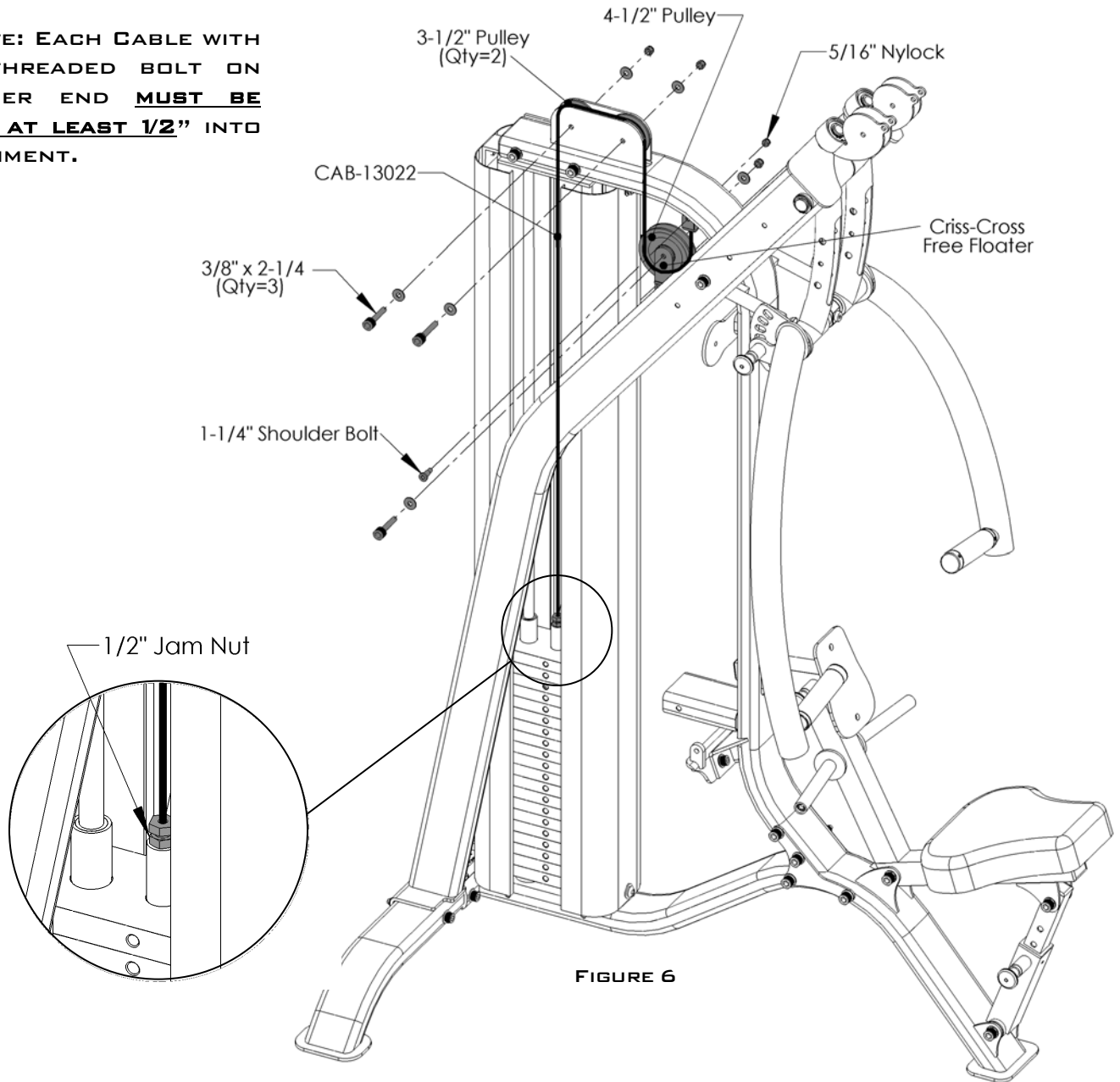
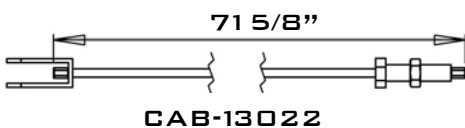


FIGURE 6

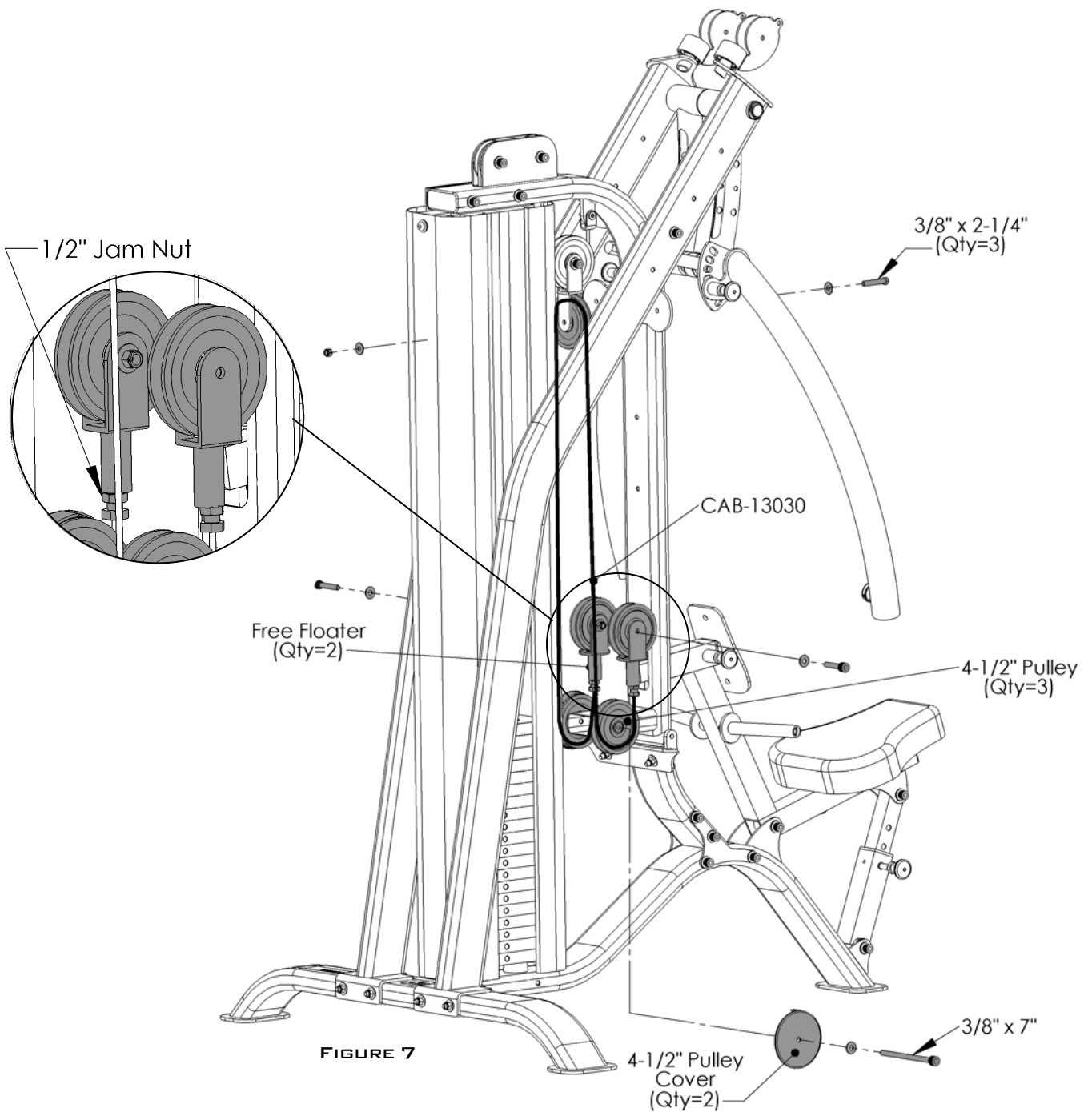


CAB-13022

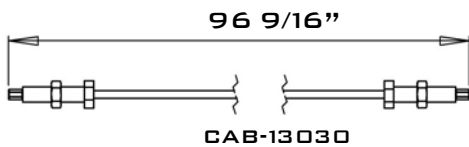
ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.

ITEM #	PART #	DESCRIPTION	QTY
25	BFM-10611	CRISS-CROSS FREE FLOATER	1
38	CAB-13022	WEIGHT STACK TO CABLE TIE OUT	1
48	BFH-50146	3/8" FLAT WASHER	6
50	BFH-50157	3/8" NYLOCK	3
61	BFH-50173	3 1/2" PULLEY	2
62	BFH-50174	4 1/2" PULLEY	1
63	BFH-50250	1 1/4" SHOULDER BOLT	1
64	BFH-50267	5/16" NYLOCK	1
65	BFP-51752	SHCS 3/8"-16 x 2 1/4"	3

**STEP 7:**



**FIGURE 7**



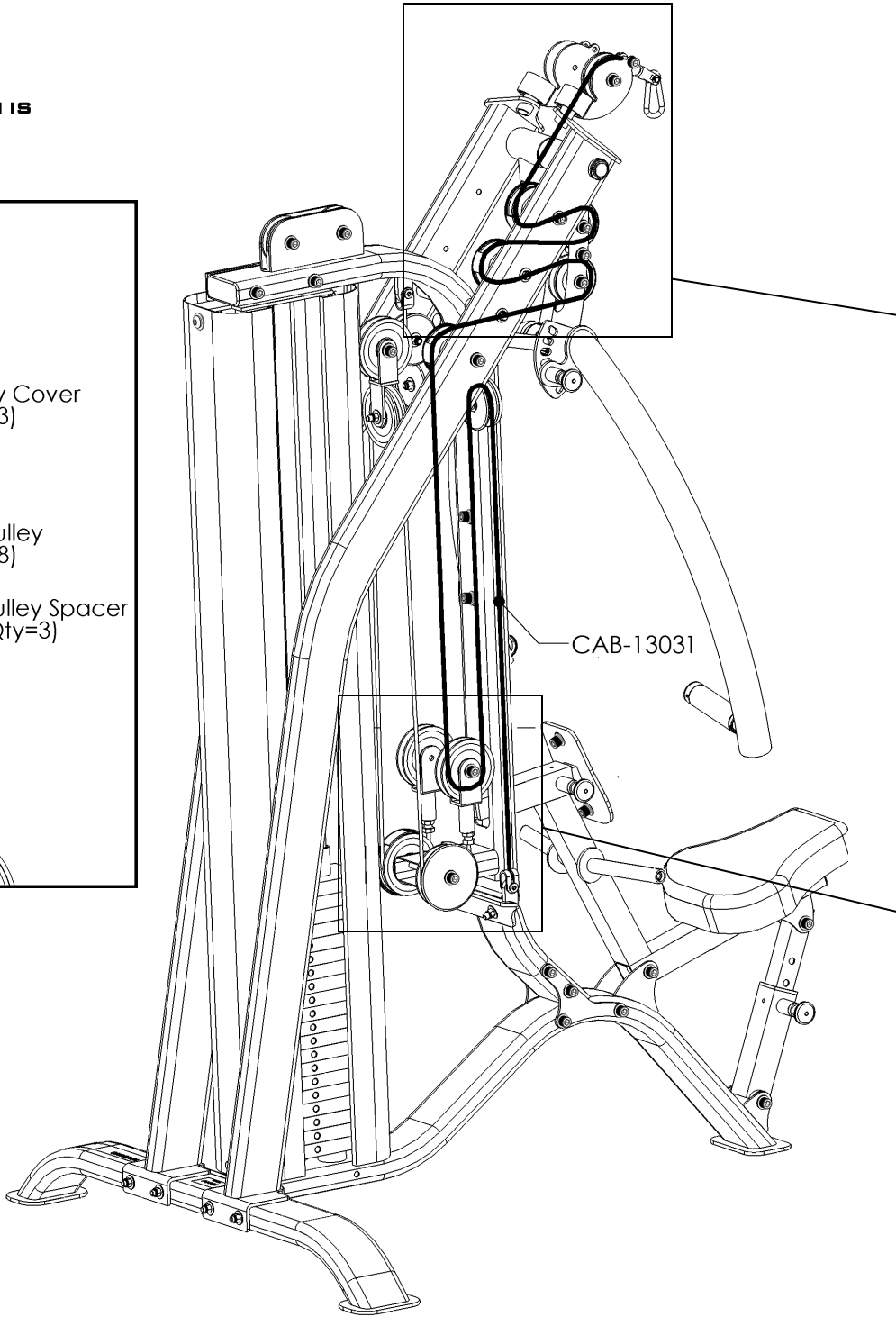
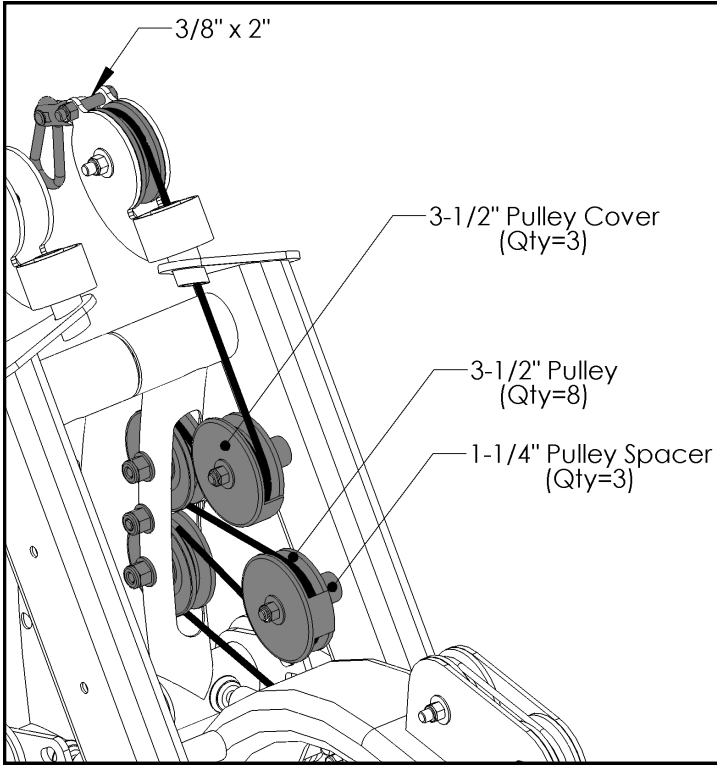
ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.

ITEM #	PART #	DESCRIPTION	QTY
26	BFM-10133	FREE FLOATER	2
27	BFM-50345	4 1/2" PULLEY COVER	2
39	CAB-13030	FUSION FLOATING PULLEY CABLE	1
45	BFP-51653	SHCS 3/8"-16 x 2 1/4"	3
48	BFH-50146	3/8" FLAT WASHER	8
50	BFH-50157	3/8" NYLOCK	4
62	BFH-50174	4 1/2" PULLEY	5
73	BFP-52398	SHCS 3/8"-16 x 7"	1

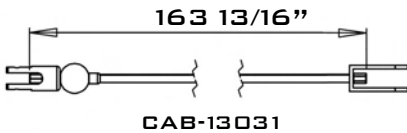
**STEP 8:**



**NOTE: IF FUNCTIONAL ARM OPTION IS PURCHASED SKIP THIS STEP.**



**NOTE: EACH CABLE WITH A THREADED BOLT ON EITHER END MUST BE THREADED AT LEAST 1/2" INTO ITS ATTACHMENT.**



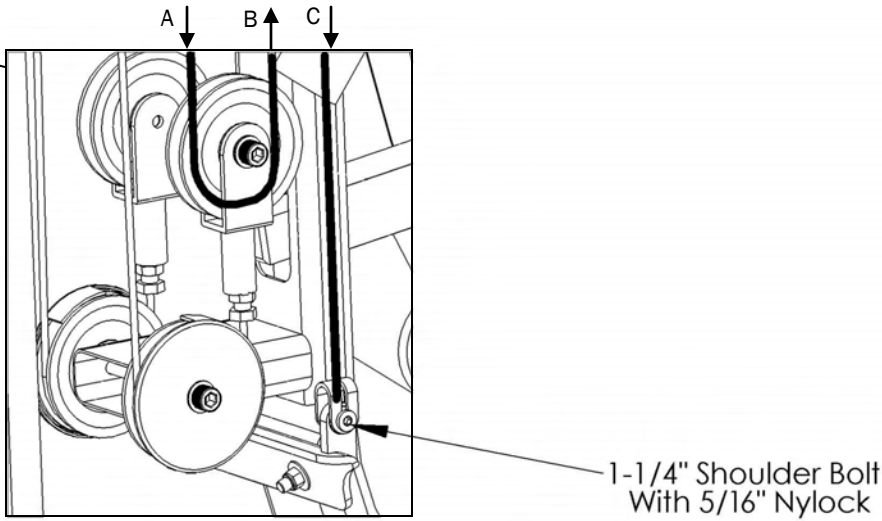
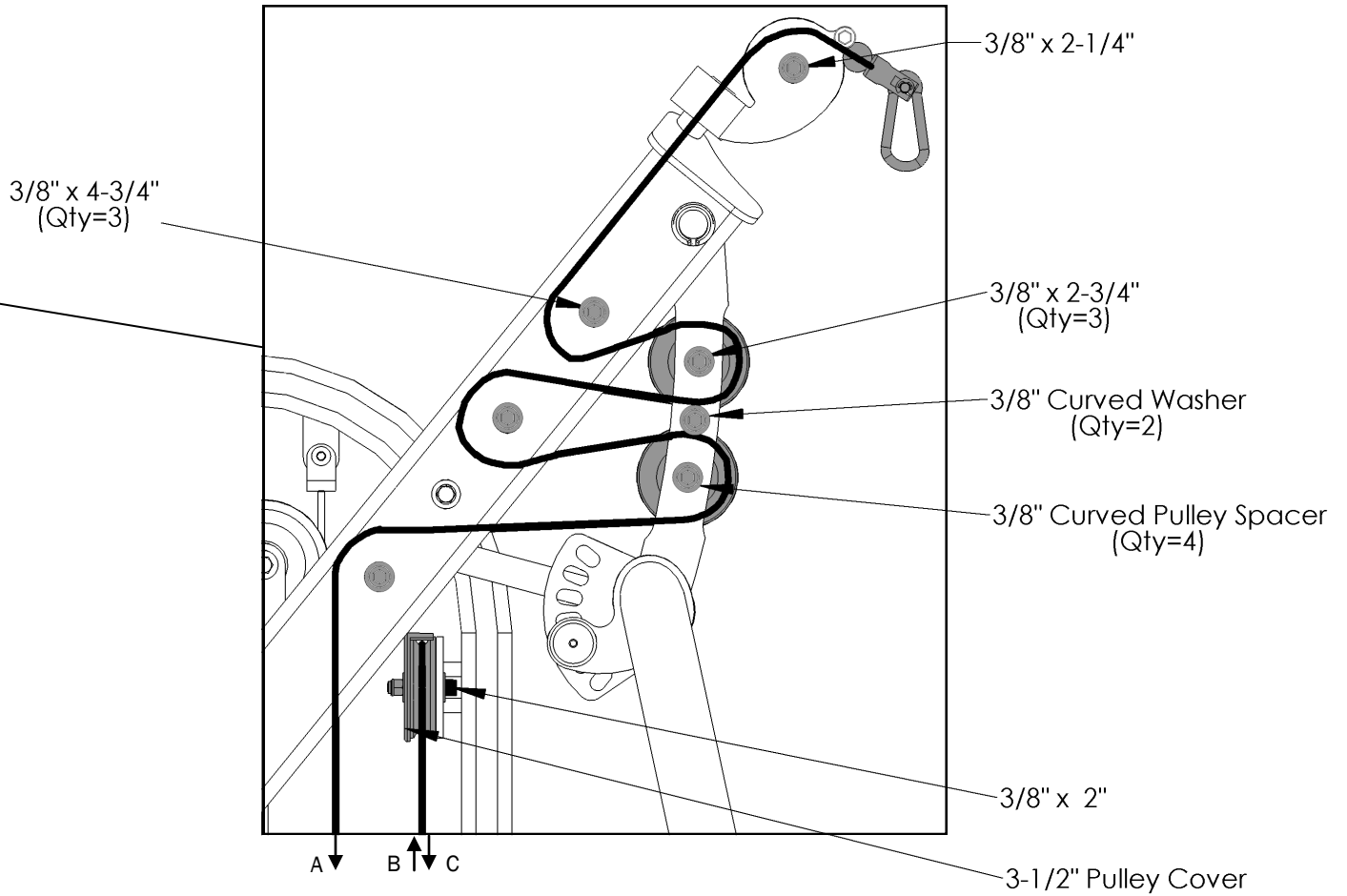
**ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.**

ITEM #	PART #	DESCRIPTION	QTY
40	CAB-13031	FUSION LAT PULL TO CABLE LOCKOUT	1
28	BFM-51022	1 1/4" PULLEY SPACER	3
29	BFM-50505	3 1/2" PULLEY COVER	4
48	BFH-50146	3/8" FLAT WASHER	10
50	BFH-50157	3/8" NYLOCK	9
61	BFH-50173	3 1/2" PULLEY	7
63	BFH-50250	1 1/4" SHOULDER BOLT	1

ITEM #	PART #	DESCRIPTION	QTY
64	BFH-50267	5/16" NYLOCK	1
66	BFH-50204	3/8" CURVED WASHER	2
67	BFH-50203	3/8" CURVED PULLEY SPACER	4
68	BFP-51759	SHCS 3/8"-16 x 2"	2
69	BFP-51750	SHCS 3/8"-16 x 2 3/4"	3
65	BFP-51752	SHCS 3/8"-16 x 2 1/4"	1
70	BFP-51753	SHCS 3/8"-16 x 4 3/4"	3



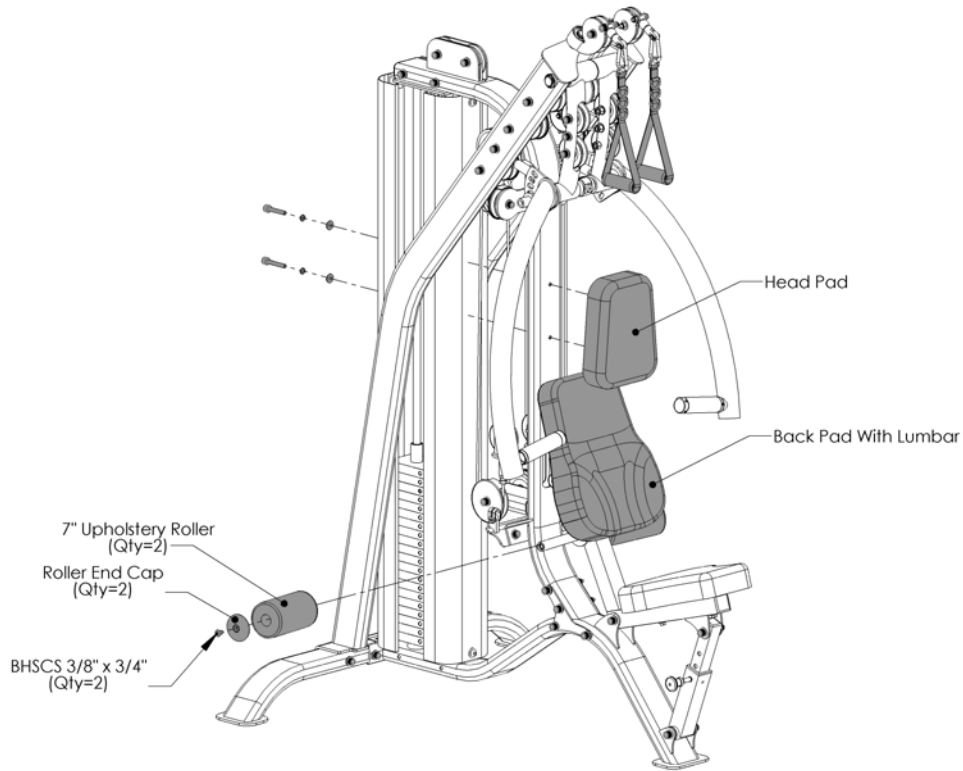
**STEP 8 CONTINUED:**



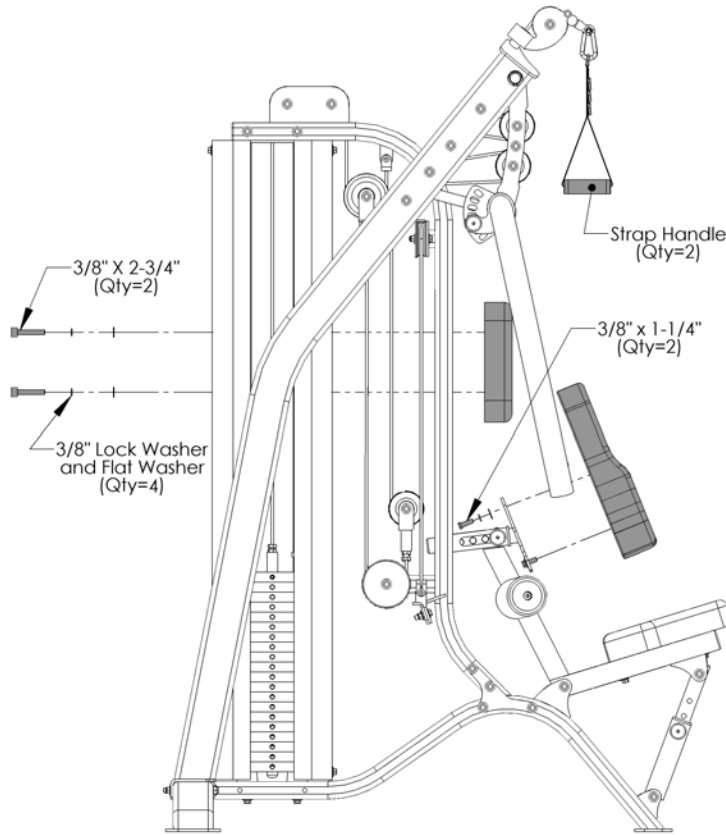
ALL FLAT WASHERS AND NYLOCKS ARE 3/8"  
UNLESS OTHERWISE NOTED.

**STEP 9: REPEAT FOR ALTERNATE SIDE OF FUSION. USE SAME BILL OF MATERIALS FROM STEP 8 FOR STEP 9. USE CAB-13031, FUSION LAT PULL TO CABLE LOCKOUT.**

**STEP 10:**



**FIGURE 10**



ITEM #	PART #	DESCRIPTION	QTY
33	BFC-10103	STRAP HANDLE	2
35	BFU-10119	HEAD PAD	1
36	BFU-10120	BACK PAD WITH LUMBAR	1
37	BFU-50189	7\"/>	

ITEM #	PART #	DESCRIPTION	QTY
49	BFH-50147	3/8\"/>	

ALL FLAT WASHERS AND NYLOCKS ARE 3/8\"/>

# FUNCTIONAL ARM OPTION

## STEP 11:

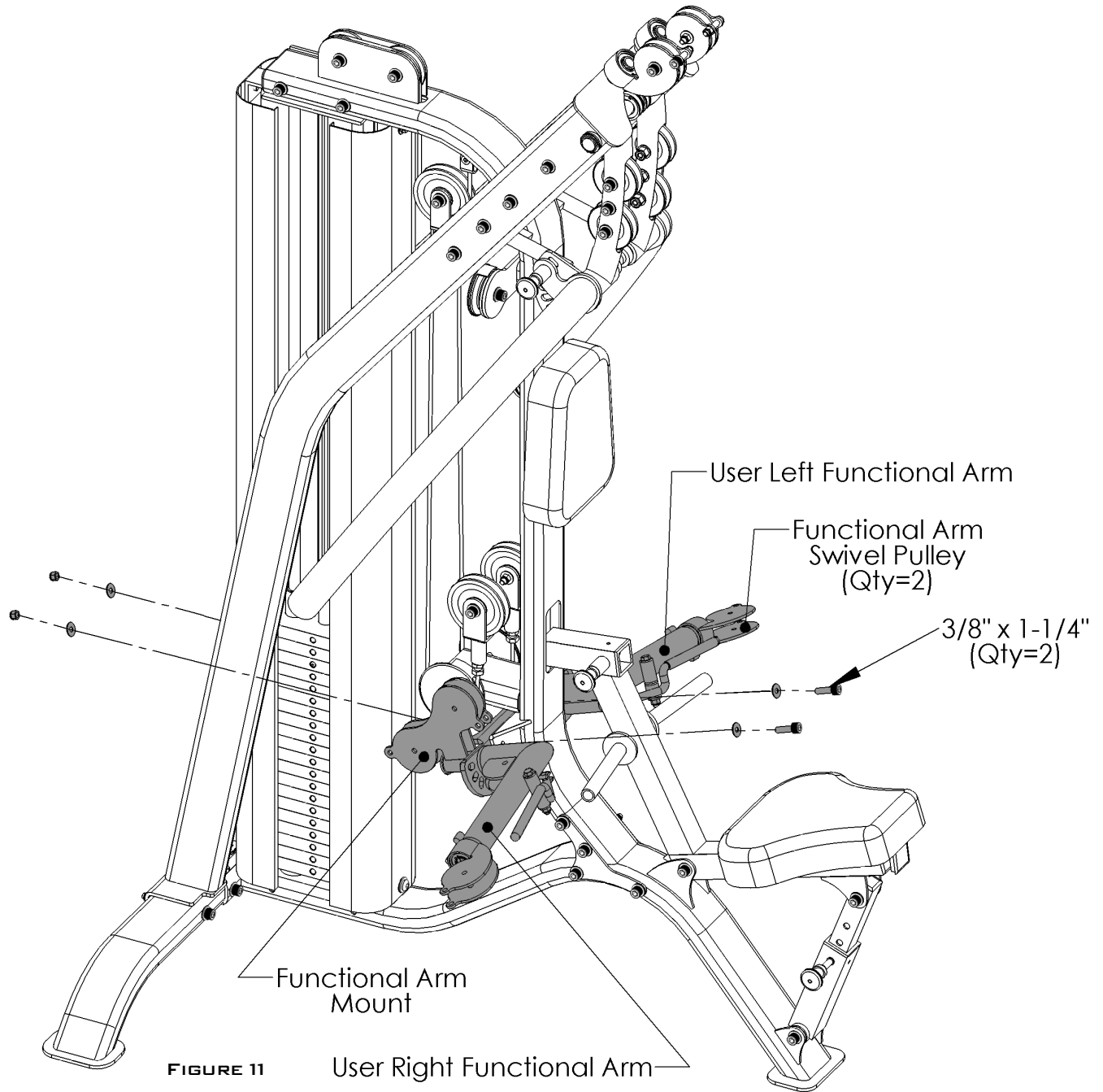


FIGURE 11

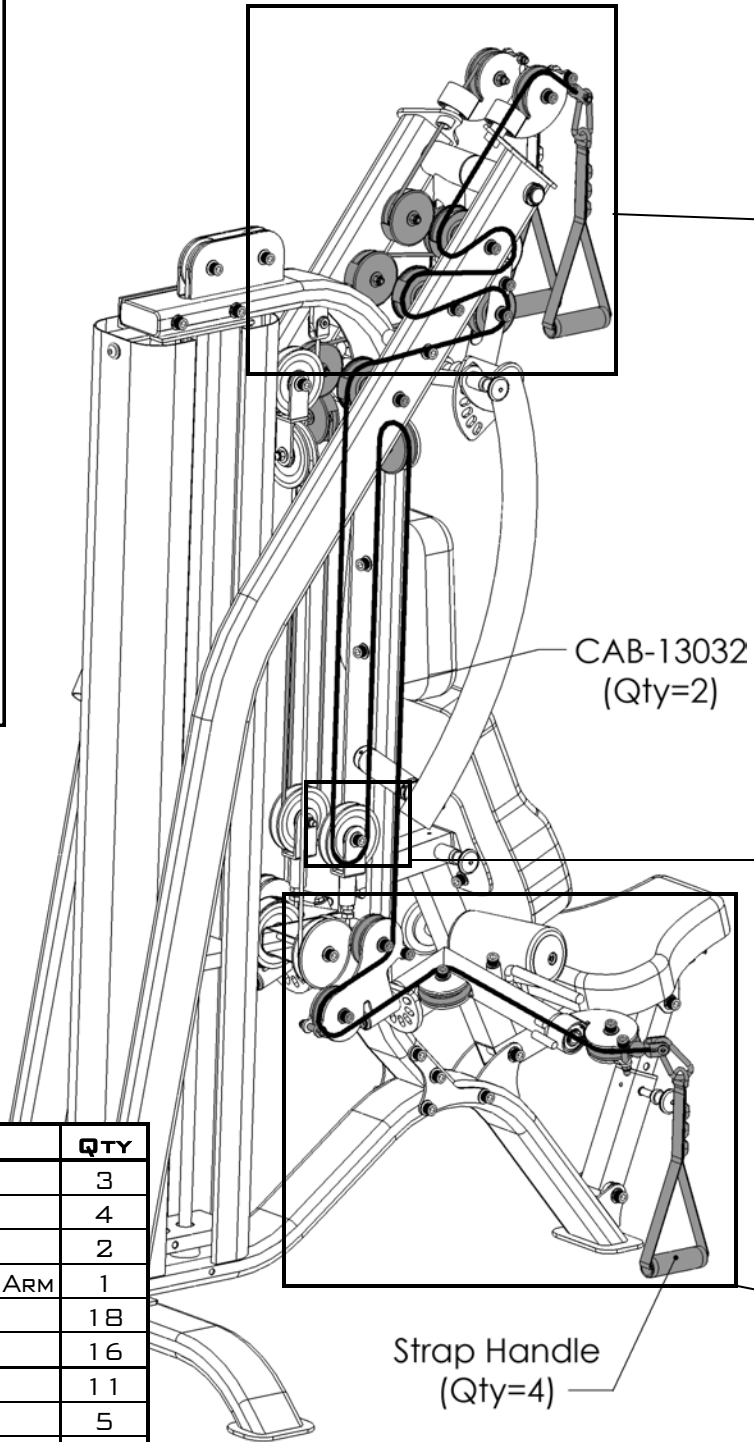
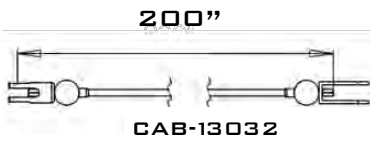
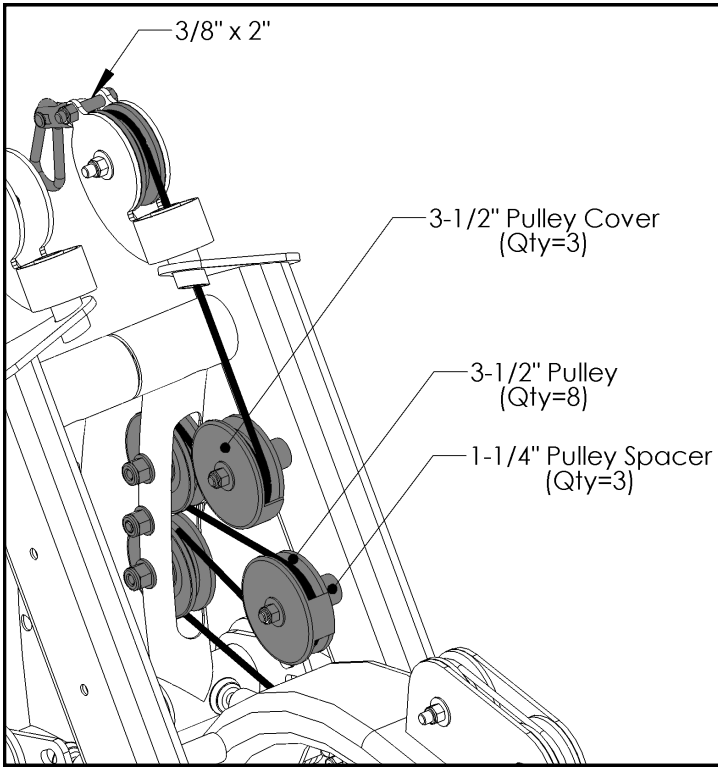
ITEM #	PART #	DESCRIPTION	QTY
74	BFM-10573	FUNCTIONAL ARM MOUNT	1
75	BFM-10571	USER RIGHT FUNCTIONAL ARM	1
76	BFM-10572	USER LEFT FUNCTIONAL ARM	1
77	BFM-10582	FUNCTIONAL ARM SWIVEL PULLEY	2
48	BFH-50146	3/8" FLAT WASHER	4
50	BFH-50157	3/8" NYLOCK	2
60	BFP-51653	SHCS 3/8"-16 x 1 1/4"	2

ALL FLAT WASHERS AND NYLOCKS ARE 3/8"  
UNLESS OTHERWISE NOTED.

**STEP 12:**



**NOTE: EACH CABLE WITH A THREADED BOLT ON EITHER END MUST BE THREADED AT LEAST 1/2" INTO ITS ATTACHMENT.**

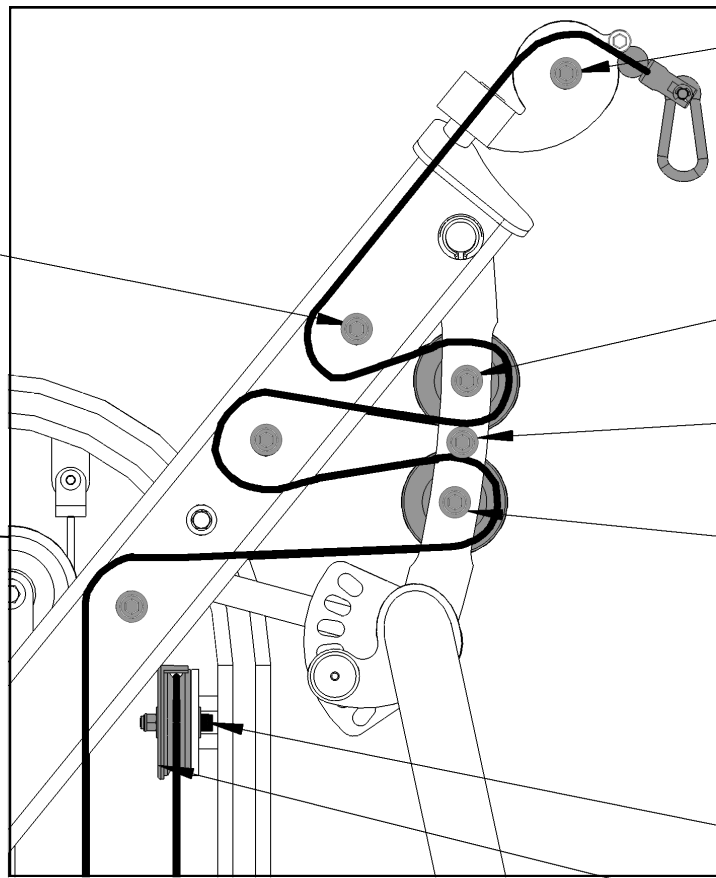


**ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.**

ITEM #	PART #	DESCRIPTION	QTY
28	BFM-51022	1 1/4" SPACER	3
29	BFM-50505	3 1/2" PULLEY COVER	4
33	BFC-10103	STRAP HANDLE	2
86	CAB-13032	FUSION LAT PULL TO FUNCTIONAL ARM	1
48	BFH-50146	3/8" FLAT WASHER	18
50	BFH-50157	3/8" NYLOCK	16
61	BFH-50173	3 1/2" PULLEY	11
65	BFP-51752	SHCS 3/8"-16 X 2 1/4"	5
66	BFH-50204	3/8" CURVED WASHER	2
67	BFH-50203	1/2" CURVED PULLEY SPACER	4
68	BFP-51759	SHCS 3/8"-16 X 2"	5
69	BFP-51750	SHCS-3/8"-16 X 2-3/4"	3
70	BFP-51753	SHCS 3/8"-16 X 4 3/4"	3

**STEP 12 CONTINUED:**

3/8" x 4-3/4"  
(Qty=3)



3/8" x 2-1/4"

3/8" x 2-3/4"  
(Qty=3)

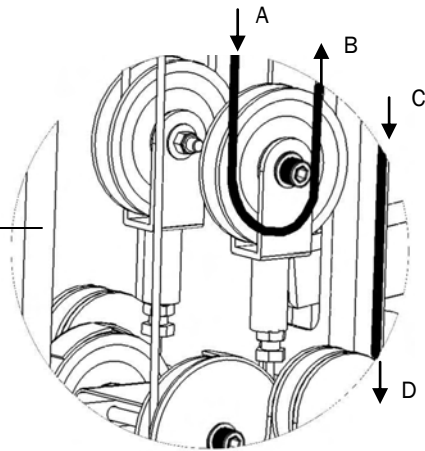
3/8" Curved Washer  
(Qty=2)

3/8" Curved Pulley Spacer  
(Qty=4)

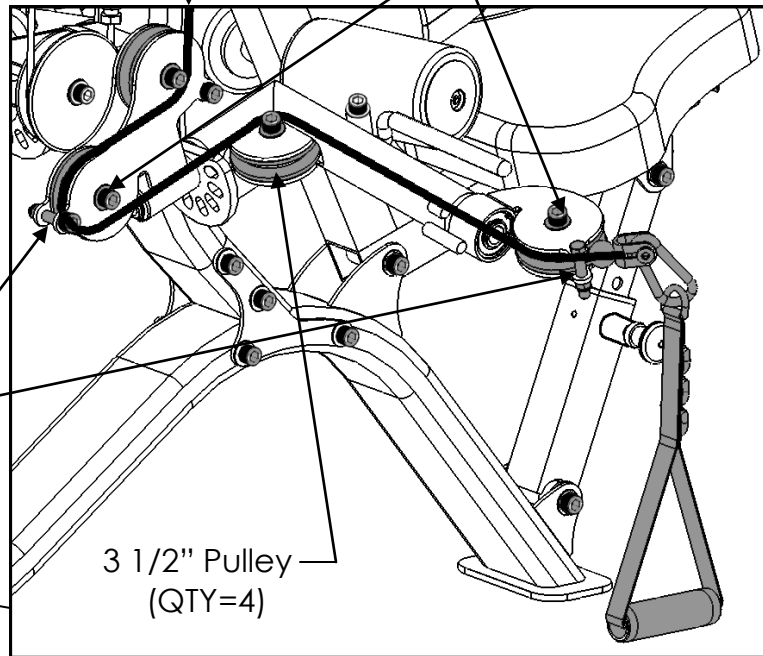
3/8" x 2"

3-1/2" Pulley Cover

A ↓ B ↓ C ↓



3/8" x 2 1/4"  
(Qty=4)



3/8" x 2"  
(Qty=3)  
No Washers

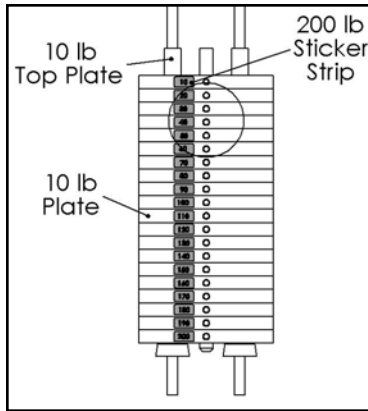
3 1/2" Pulley  
(QTY=4)

ALL FLAT WASHERS AND NYLOCKS ARE 3/8" UNLESS OTHERWISE NOTED.

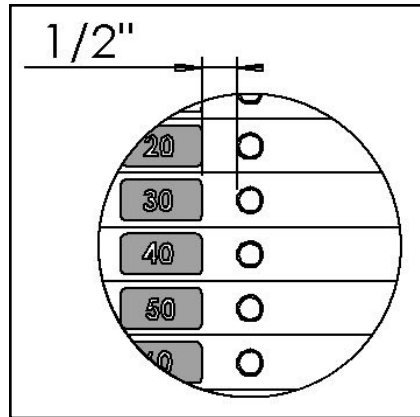
**STEP 13: REPEAT FOR ALTERNATE SIDE OF FUSION. USE SAME BILL OF MATERIALS FROM STEP 12 FOR STEP 13. USE CAB-13032, FUSION LAT PULL TO FUNCTIONAL ARM.**

## STEP 14:

### WEIGHT STACK DECALS:



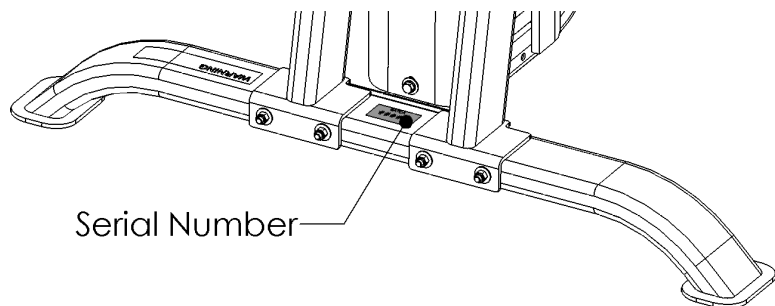
200lb Stack (Standard)



### GUIDE ROD LUBRICATION:

- **CLEAN** GUIDE RODS WITH A LINT-FREE CLOTH AND APPLY A THIN LAYER OF SILICON LUBRICANT (PART # BFH-50262) TO EACH GUIDE ROD. THIS WILL ENSURE A GLASS SMOOTH PERFORMANCE FROM YOUR WEIGHT STACK.

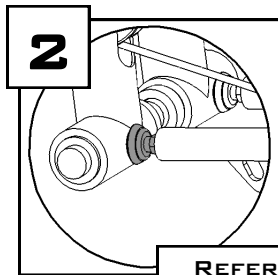
### SERIAL NUMBER:



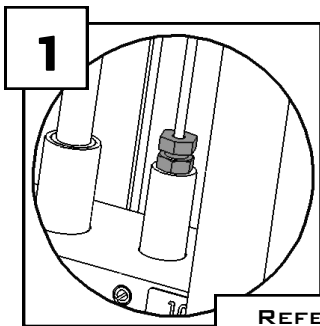
- **RECORD** YOUR SERIAL NUMBER ON THE FRONT OF THIS MANUAL AND KEEP FOR YOUR RECORDS. THE SERIAL NUMBER CAN BE FOUND ON THE BACK OF THE CAGE AS SEEN IN THE FIGURE.

# Cable Adjustments

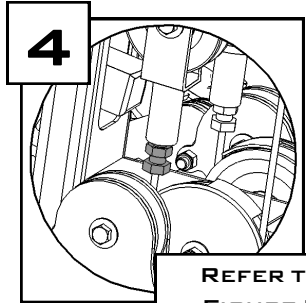
- **ADJUST** CABLES TO PROPER TENSION FROM ANY OF THE LOCATIONS SHOWN BELOW.
- **HOW TO BEGIN:** IN ORDER TO GET THE PROPER TENSION IN YOUR CABLES, IT IS RECOMMENDED THAT YOU FOLLOW THE SEQUENCE 1-5 AS SHOWN ON PAGES 24 AND 25. THE NUMBERS FOR THIS SEQUENCE CAN BE FOUND IN THE UPPER LEFT CORNER OF EACH OF THE DETAILED VIEWS. EACH DETAILED VIEW BELOW WILL REFER YOU TO THE ORIGINAL FIGURE FOR MORE DETAILED INFORMATION. FOLLOW THE DETAILED INFORMATION FOUND IN EACH REFERENCED FIGURE.
- **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.



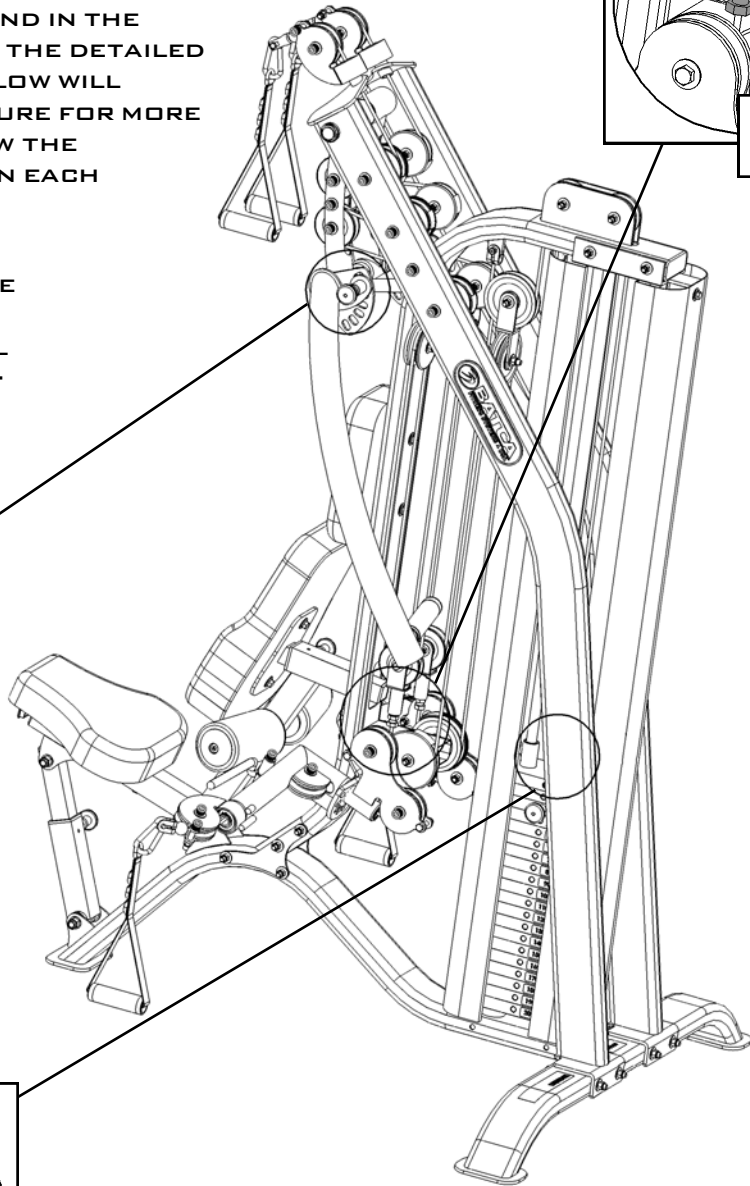
2  
REFER TO  
FIGURE 8  
AND 11



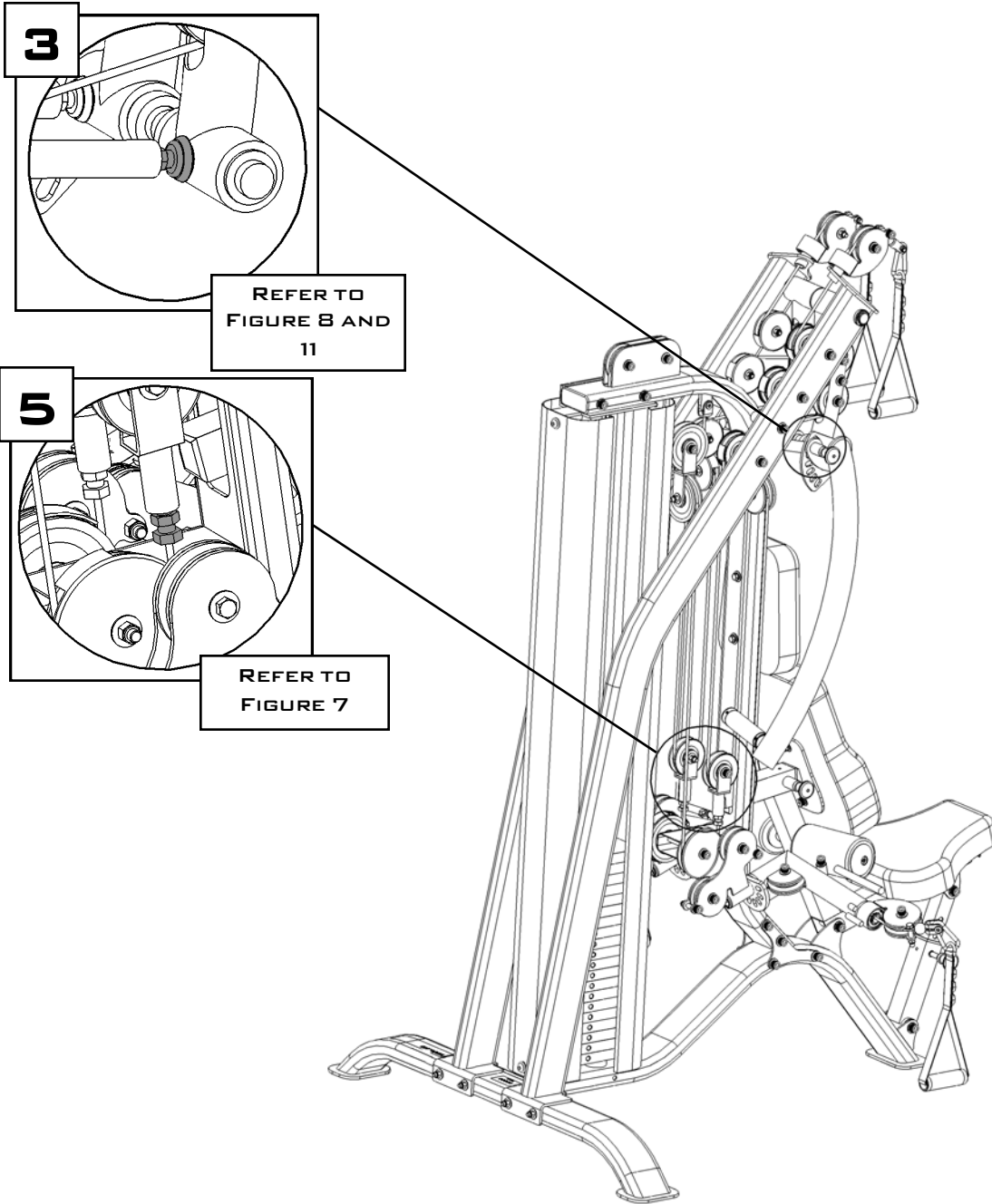
1  
REFER TO  
FIGURE 6



4  
REFER TO  
FIGURE 7



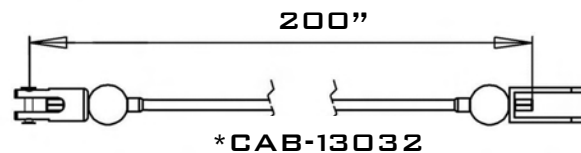
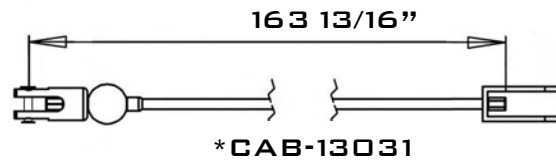
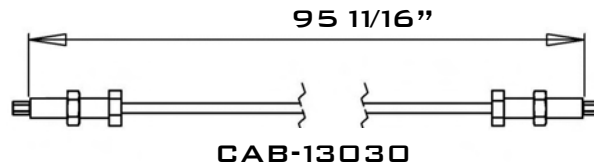
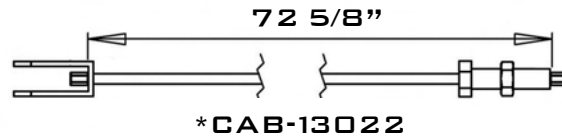
**NOTE:** ALL CABLES WITH THREADED ADJUSTABLE ENDS MUST HAVE AT LEAST 1/2" OF THE THREADS THREADED INTO ITS COUNTERPART. IT IS VERY IMPORTANT THAT THE 1/2" JAM NUT BE WRENCH TIGHTENED TO THE COUNTERPART TO ENSURE THAT THE THREADED ADJUSTABLE END OF THE CABLE DOES NOT BACK OUT OF ITS COUNTERPART.



**NOTE: ALL LEVELERS SHOULD HAVE AT LEAST 1/2" OF THE THREADS THREADED IN TO ITS COUNTERPART. IT IS VERY IMPORTANT THAT THE 3/8" JAM NUT BE WRENCH TIGHTENED TO THE COUNTERPART TO ENSURE THAT THE LEVELER DOES NOT BACK OUT OF THE COUNTERPART.**



# CABLE COMPARISON CHART



## CABLES

ITEM	PART NUMBER	DESCRIPTION	QTY
38	CAB-13022	WEIGHT STACK TO CABLE TIE OUT	1
39	CAB-13030	FUSION FLOATING PULLEY CABLE	1
40	CAB-13031	FUSION LAT PULL TO CABLE LOCKOUT	2
86	CAB-13032	FUSION LAT PULL TO FUNCTIONAL ARM	2

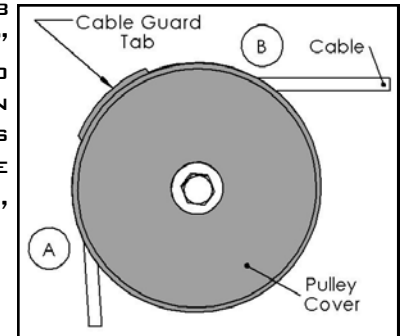


NOTE: CABLES CAB-13022, CAB-13031, AND CAB-13032 HAVE REMOVABLE CABLE STRAP (BFH- 50227) ENDS TO MAKE CABLE ROUTING EASIER. THE CABLE STRAP ENDS CAN BE FOUND PACKAGED WITH THE HARDWARE.

# FINAL ASSEMBLY AND TROUBLESHOOTING

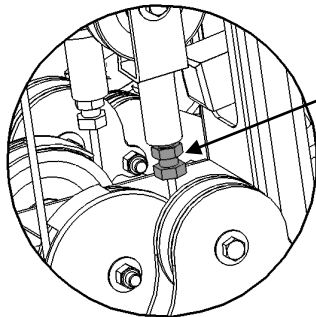
## IMPORTANT - CHECK THESE COMPONENTS BEFORE USING GYM:

- **POSITION** THE CABLE GUARD TAB ON THE PULLEY COVER SO THAT THE TAB PREVENTS THE CABLE FROM COMING OUT OF IT'S TRACK ON THE 3 1/2" PULLEY. AN EXAMPLE OF THIS POSITIONING CAN BE SEEN IN THE FIGURE TO THE RIGHT. THE CABLE GUARD TAB SHOULD BE POSITIONED SO THAT IT IS IN THE MIDDLE OF THE CABLE WRAP ON THE 3 1/2" PULLEY, BETWEEN POINTS "A" AND "B". THIS WILL ALLOW BETTER PROTECTION AND PREVENT THE CABLE FROM RUBBING THE CABLE GUARD TAB. REFER TO STEPS 8, 9, 12, AND 13.



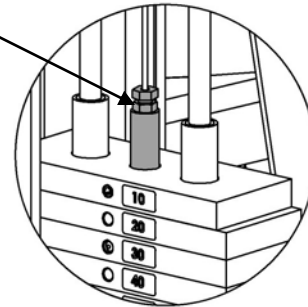
PULLEY COVER  
BFM-50345

- 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. REFER TO STEPS 6, 7, 8, 9, 12, AND 13. SEE FIGURES BELOW.



FREE FLOATER W/  
LOCKOUT

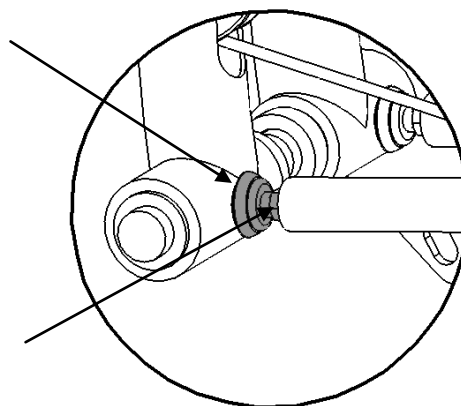
1/2" JAM  
NUT



TOP PLATE

- EACH ADJUSTMENT LEVELER **MUST BE THREADED 1/2"** INTO ITS COUNTERPART. EACH MUST BE SECURED WITH A 3/8" JAM NUT TO ENSURE A SAFE PROPER CONNECTION. REFER TO STEPS 3, 8, 9, 12, AND 13. SEE FIGURES BELOW.

BEVELED LEVELER



3/8" JAM NUT

# 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. EACH PILLOW BLOCK BEARING AND FLANGE BEARING HAS A GREASE FITTINGS THAT MUST BE LUBRICATED REGULARLY. USE GENERAL PURPOSE BEARING GREASE AND FOLLOW THE SCHEDULE BELOW.

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
<b>CLEAN</b>					
UPHOLSTERY		X			
HAND GRIPS		X			
ROLLER PADS		X			
GUIDE RODS			X		
CHROME SLIDES			X		
FRAME			X		
<b>INSPECT</b>					
OVERALL	X				
SAFETY DECALS	X				
CABLES	X				
CABLE TENSION			X		
PULLEYS	X				
HARDWARE	X				
STOPS	X				
UPHOLSTERY	X				
HAND GRIPS			X		
FRAME			X		
BUSHINGS		X			
BEARINGS		X			
<b>LUBRICATE</b>					
GUIDE RODS			X		
BEARINGS					1
<b>REPLACE</b>					
CABLES					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.

## **WHAT IS NOT COVERED**

THIS WARRANTY DOES NOT COVER DAMAGE, WHICH RESULTS FROM SHIPPING, MISUSE, ABUSE, NEGLIGENCE, 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.

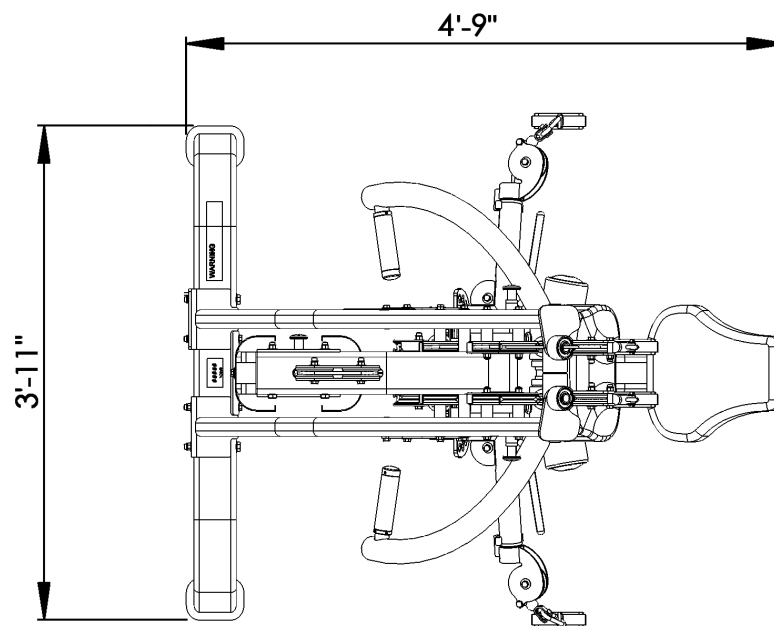
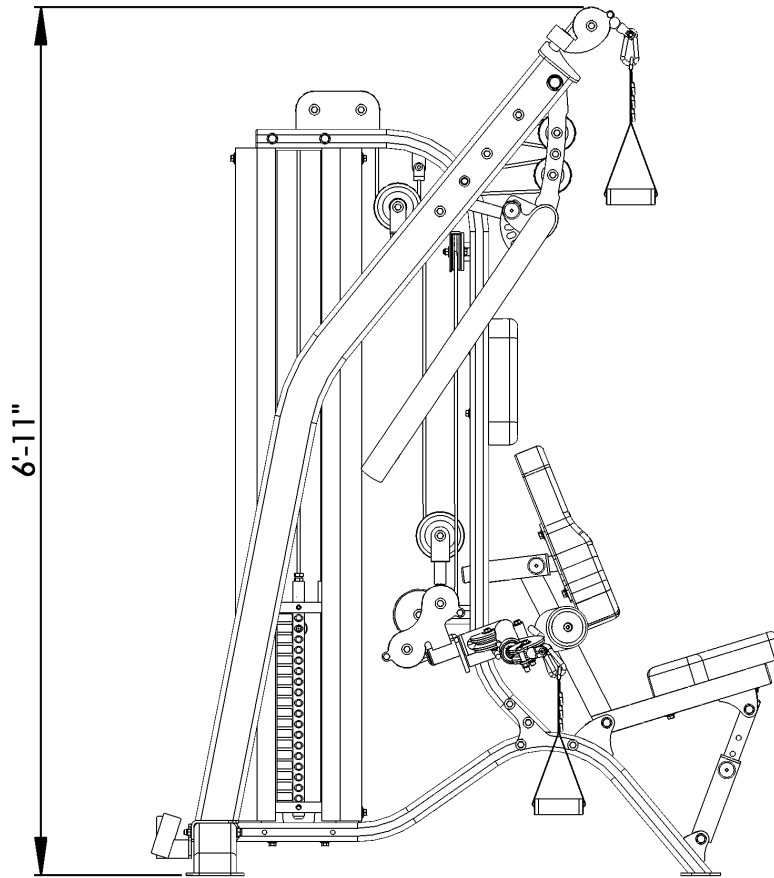
THE PURCHASER IS RESPONSIBLE FOR SHIPPING THE DEFECTIVE PART BACK TO THE FACTORY. REPAIR OR REPLACEMENT IS THE EXCLUSIVE AND SOLE REMEDY OF THE PURCHASER. LABOR CHARGES ASSOCIATED WITH PARTS CHANGEDOVERS ARE NOT COVERED BY THIS WARRANTY. PROOF OF PURCHASE, SERIAL NUMBER, MODEL NUMBER AND DATE OF PURCHASE 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.



## LAYOUT DIAGRAM

THE FUSION WITH LEG PRESS HAS A LAYOUT DIMENSION OF 3'-11" (WIDTH) X 4'-9" (LENGTH) X 6'-11" (HEIGHT). THERE SHOULD BE A MINIMUM OF 18", PREFERABLY 24", OF WORKING SPACE AROUND THE ENTIRE UNIT.