

Revision 0

January 2007



**BATCA**  
fitness systems · usa

# Fusion 2

## Owner's Manual



**Record Serial Number Here**

**Date of Purchase**

Batca Fitness Systems

Tel. (919) 255-1233

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

# Instructions

Congratulations on the purchase of your new Fusion 2. 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 NO.	PART NO.	DESCRIPTION	QTY
1	BFM-10593	Rear Base	1
2	BFM-10566	Right Vertical Support	1
3	BFM-10567	Left Vertical Support	1
4	BFM-10568	Middle Base	1
5	BFM-10569	Middle Pole Assembly	1
6	BFM-51044	Guide Rod Holder	1
7	BFM-51022	1 1/4" Spacer	6
9	BFM-50529	Rubber Donut	2
10	BFM-50256	Weight Plate	19
12	BFM-51051	Guide Rod	2
13	BFM-10570	Right Arm Assembly	1
14	BFM-10574	Left Arm Assembly	1
15	BFM-10573	Functional Arm Mount	1
16	BFM-10571	User Right Functional Arm	1
17	BFM-10572	User Left Functional Arm	1
18	BFL-50197	Middle Pole Connector Plate	2
19	BFL-50203	Pulley Holder Connector Plate	1
20	BFM-10577	8" Telespar	1
21	BFM-10578	Seat Frame Assembly	1
24	BFM-10579	10" Chrome Adjustment	1
25	BFM-10141	Knee Alignment Roller	1
30	BFM-10580	Back Chrome Adjustment	1
33	BFM-10581	Leg Extension/ Curl Frame	1
35	BFM-51080	.45" Spacer	1
36	BFM-10582	Functional Arm Swivel Pulley	2
37	BFM-10583	Top Swivel Pulley Holder	2
38	BFM-51082	Weight Stack Shroud	2
39	BFM-10584	Leg Extension Shaft	1
40	BFM-10585	Leg Extension Cam Assembly	1
41	BFM-51084	1 1/4" OD x .120 Wall x .225" Spacer	1
42	BFM-10586	Leg Extension Arm Assembly	1
44	BFL-50207	Hold Down Adjustment Plate	1
45	BFL-50211	Plate	1
46	BFM-10587	Knee Hold Down Assembly	1
47	BFM-51094	2" Axle	1
48	BFM-10588	Knee Hold Down Handle	1
50	BFL-50221	Pulley Plate	1
53	BFM-51143	8" Anti-Deflection Plate	1
54	BFM-51148	1" x 13 3/16" Arm Shaft	1
77	BFM-50505	3 1/2" Pulley Cover	11
79	BFM-10603	Left Arm Adjustment Handle	1
80	BFM-10602	Right Arm Adjustment Handle	1
87	BFM-51158	1" OD x 25/64" ID Spacer	1
91	BFM-10607	Press Arm	2
93	BFM-10609	Pulley Holder	2
94	BFM-10611	Criss-Cross Free Floater	1
96	BFM-10610	Lower Pulley Holder	2
105	BFM-10612	Cable Tie Out Plate	1
107	BFM-10299	Top Plate	1
108	BFM-50258	Selector Shaft	1
121	BFM-50222	2 9/16" Axle	1
122	BFM-50931	3" Axle	1
123	BFM-51173	Weight Stack Pull Pin	1
180	BFM-51130	Front Pivot	1
185	BFM-51158	Spacer	1

# Accessories

ITEM NO.	PART NO.	DESCRIPTION	QTY
156	BFC-10103	Strap Handle	4

# Upholstery

ITEM NO.	PART NO.	DESCRIPTION	QTY
31	BFU-10117	Large Bottom Pad	1
11	BFU-10119	Head Pad	1
32	BFU-10120	Back Pad With Lumbar	1
43	BFU-50187	Large Roller	1
28	BFU-50189	7" Roller	6

# Hardware

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
8	BFH-50173	3 1/2" Pulley	31
22	BFH-50103	1/2" Flanged Bushing	4
23	BFH-50102	5/8" Flanged Bushing	2
26	BFH-50222	Rubber Bumper	2
27	BFH-50221	3" Plastic Washer	4
29	BFH-50252	Plastic Collar	6
34	BFH-50101	1" Flanged Bushing	28
49	BFH-50280	1" Round Plastic Cap	5
51	BFH-10002	Threaded Bearing	2
55	BFH-50165	1" Snap Ring	9
56	BFH-50146	3/8" Flat Washer (Black)	113
57	BFH-50122	HCS 3/8"-16 X 2 1/4" P5	21
58	BFH-50157	3/8"-16 Nylock (Black)	69
59	BFH-50270	HCS 3/8"-16 X 5 1/4" P5	8
60	BFH-50147	3/8" Lock Washer (Black)	16
61	BFH-50119	HCS 3/8"-16 X 1 1/4" P5	4
62	BFH-50124	HCS 3/8"-16 X 2 3/4" P5	8
63	BFH-50125	HCS 3/8"-16 X 3" P5	5
64	BFH-50251	1/2" Flat Washer (Black)	4
65	BFH-50138	HCS 1/2"-13 X 3 1/2" P5	1
66	BFH-50139	HCS 1/2"-13 X 4 1/4" P5	1
67	BFH-50136	HCS 1/2"-13 X 3" P5	1
68	BFH-50155	1/2"-13 Nylock (Black)	3
70	BFH-50121	HCS 3/8"-16 X 2" P5	12
72	BFH-50274	HCS 3/8"-16 X 4 3/4" P5	6
73	BFH-50285	HCS 3/8"-16 1 3/4" P5	2
74	BFH-50132	HCS 3/8"-16 X 5 1/2" P5	2
75	BFH-50605	3/8" Pulley Spacer	2
76	BFH-50123	HCS 3/8"-16 X 2 1/2" P5	3
92	BFH-50256	1/2" Jam Nut	6
95	BFH-50174	4 1/2" Pulley	4
98	BFH-50253	Beveled Leveler	2
99	BFH-50149	3/8"-16 Jam Nut (Zinc)	6
110	BFH-51174	Large Logo/Chrome & Red	2
111	BFH-50192	Weight Stack Decals	2

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
113	BFH-50250	1 1/4" Shoulder Bolt	2
114	BFH-50267	5/16"-18 Nylock (Black)	2
115	BFH-50144	FHSCS 3/8"-16 X 1"	2
116	BFH-50254	HCS 3/8"-16 X 3/4" P5	2
118	BFH-50279	HCS 3/8"-16 X 5" P5	4
119	BFH-50245	FHSCS 5/16"-18 X 1"	2
128	BFH-50188	Snap Hook	4
129	BFH-50211	2" Square Plastic Cap	1
130	BFH-50212	2" x 3" Plastic Cap	2
131	BFH-50215	1 1/2" Square Plastic Cap	6
133	BFH-50227	Cable Strap	5
136	BFH-50238	Pin	2
137	BFH-50239	Snap Ring	2
138	BFH-50244	1/2" Bronze Bushing	8
140	BFH-50248	13/32" Bushing	8
143	BFH-50297	1" Flanged Bushing x 1/2"L	2
144	BFH-50590	Plastic Sleeve	3
145	BFH-50602	1" ID Bearing	14
146	BFH-50604	2" Interior Snap Ring	26
147	BFH-50607	Pull Pin Threaded Cap	2
148	BFH-50608	5" Plastic Sleeve	1
149	BFH-50609	Molded Grip 1" ID	1
150	BFH-50611	2" Round Plastic Cap	3
151	BFH-50612	1 3/4" x 4" Rectangular Cap	4
152	BFH-50614	6" Rubber Grips	2
153	BFH-50618	Mounting Bracket	2
154	BFH-50203	1/2" Curved Pulley Spacer	8
155	BFH-50204	3/8" Curved Washer (Black)	8
181	BFH-50339	Large Flat Leveler	2
182	BFH-50337	Wavy Washer	5
183	BFH-50630	FHSCS 3/8"-16 X 3/4"	2
184	BFH-50631	HCS 3/8"-16 X 1/2" P5	4
186	BFH-50620	BHSCS 3/8"-16 X 3/4"	6
187	BFH-50622	Upholstery Cap	6

# Cables

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
101	CAB-13021	Fusion Lat Pull to Functional Arm	2
109	CAB-13022	Fusion Weight Stack to Cable Tie Out	1
103	CAB-13024	Fusion Floating Pulley Cable	1
104	CAB-13025	Fusion Leg Extension Cable	1
106	CAB-13026	Fusion Tie Out Cable	1

# Leg Press Components

ITEM NO.	PART NUMBER	DESCRIPTION	Qty
172	BFL-50128	Foot Plate	1
162	BFL-50219	Bench Frame Plate	2
165	BFM-10106	Chrome Pad Adjustment	1
158	BFM-10575	Leg Press Connector Assembly	1
169	BFM-10590	Foot Plate Pivot	1
167	BFM-10591	Leg Press Pivot Arm	1
163	BFM-10595	Chrome Adjustment	1
161	BFM-10596	6" Telespar	1

ITEM NO.	PART NUMBER	DESCRIPTION	Qty
166	BFM-10597	Back Seat Frame	1
164	BFM-10598	Bottom Seat Frame	1
157	BFM-10605	Leg Press Frame	1
170	BFM-50252	Four Bar	2
171	BFM-51149	9 1/2" Shaft	1
168	BFM-51150	5 3/4" Shaft	1
159	BFM-51155	2 1/32" Axle	3
160	BFM-51157	3 1/32" Axle	1
180	BFM-51130	Front Pivot	1

# Leg Press Hardware

ITEM NO.	PART NUMBER	DESCRIPTION	Qty
61	BFH-50119	HCS 3/8"-16 X 1 1/4" P5	2
70	BFH-50121	HCS 3/8"-16 X 2" P5	1
76	BFH-50123	HCS 3/8"-16 X 2 1/2" P5	2
63	BFH-50125	HCS 3/8"-16 X 3" P5	2
69	BFH-50126	HCS 3/8"-16 X 3 1/4" P5	2
82	BFH-50127	HCS 3/8"-16 X 3 1/2" P5	3
83	BFH-50130	HCS 3/8"-16 X 4 1/4" P5	1
84	BFH-50131	HCS 3/8"-16 X 4 1/2" P5	1
85	BFH-50145	FHSCS 3/8"-16 X 2 1/4"	3
56	BFH-50146	3/8" Flat Washer (Black)	34
60	BFH-50147	3/8" Lock Washer (Black)	4
99	BFH-50149	3/8"-16 Jam Nut (Zinc)	3
58	BFH-50157	3/8"-16 Nylock (Black)	22
55	BFH-50165	1" Snap Ring	4

ITEM NO.	PART NUMBER	DESCRIPTION	Qty
8	BFH-50173	3 1/2" Pulley	5
90	BFH-50249	1 3/4" Shoulder Bolt	2
113	BFH-50250	1 1/4" Shoulder Bolt	1
64	BFH-50251	1/2" Flat Washer (Black)	2
98	BFH-50253	Beveled Leveler	1
114	BFH-50267	5/16"-18 Nylock (Black)	1
59	BFH-50270	HCS 3/8"-16 X 5 1/4" P5	4
73	BFH-50285	HCS 3/8"-16 1 3/4" P5	1
75	BFH-50605	3/8" Pulley Spacer	5
89	BFH-50610	1 1/2" Shoulder Bolt	2
92	BFH-50256	1/2" Jam Nut	1
181	BFH-50339	Large Flat Leveler	1
182	BFH-50337	Wavy Washer	2
188	BFH-50338	Sleeve	2

## Cables

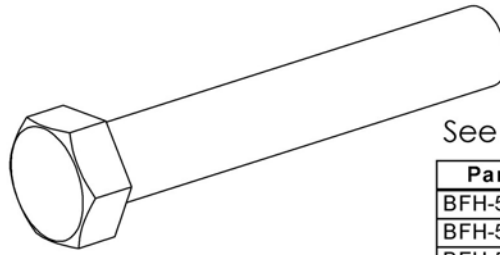
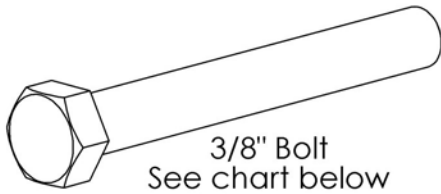
ITEM NO.	PART NUMBER	DESCRIPTION	Qty
102	CAB-13023	Fusion Leg Press Cable	1

## Upholstery

ITEM NO.	PART NUMBER	DESCRIPTION	Qty
173	BFU-10117	Large Bottom Pad	1
174	BFU-10120	Back Pad With Lumbar	1

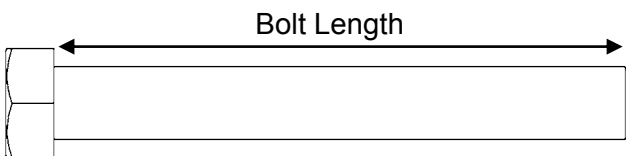
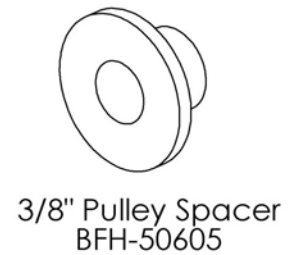
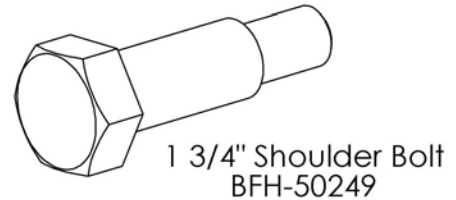
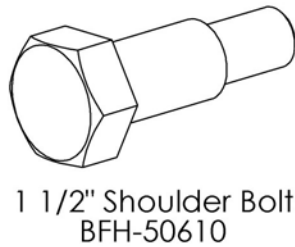
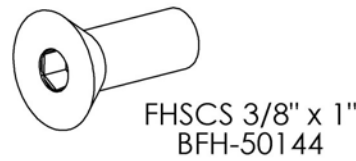
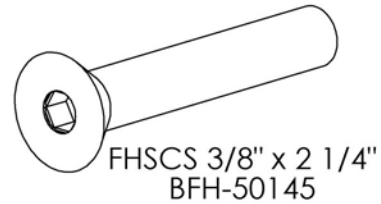
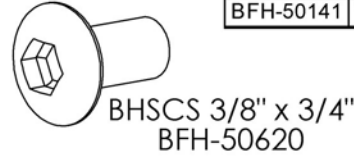
## Tools Required

- 1/2" Wrench
- 9/16" Wrench
- 9/16" Ratchet
- 3/4" Wrench
- 3/4" Ratchet
- Allen Wrench Set
- Tape Measure
- Snap Ring Pliers

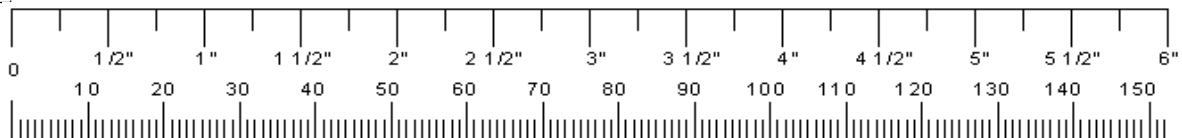


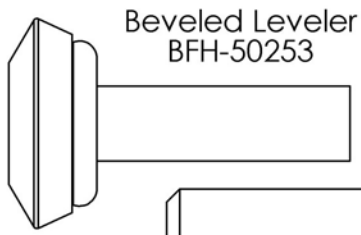
Part #	Size
BFH-50631	3/8" x 1/2"
BFH-50254	3/8" x 3/4"
BFH-50118	3/8" x 1"
BFH-50119	3/8" x 1 1/4"
BFH-50120	3/8" x 1 1/2"
BFH-50285	3/8" x 1 3/4"
BFH-50121	3/8" x 2"
BFH-50122	3/8" x 2 1/4"
BFH-50123	3/8" x 2 1/2"
BFH-50124	3/8" x 2 3/4"
BFH-50125	3/8" x 3"
BFH-50126	3/8" x 3 1/4"
BFH-50127	3/8" x 3 1/2"
BFH-50128	3/8" x 3 3/4"
BFH-50129	3/8" x 4"
BFH-50130	3/8" x 4 1/4"
BFH-50131	3/8" x 4 1/2"
BFH-50274	3/8" x 4 3/4"
BFH-50279	3/8" x 5"
BFH-50270	3/8" x 5 1/4"
BFH-50132	3/8" x 5 1/2"
BFH-50133	3/8" x 6 1/2"
BFH-50298	3/8" x 8 3/4"

Part #	Size
BFH-50135	1/2" x 2 3/4"
BFH-50136	1/2" x 3"
BFH-50137	1/2" x 3 1/4"
BFH-50138	1/2" x 3 1/2"
BFH-50139	1/2" x 4 1/4"
BFH-50140	1/2" x 4 1/2"
BFH-50141	1/2" x 5 1/2"

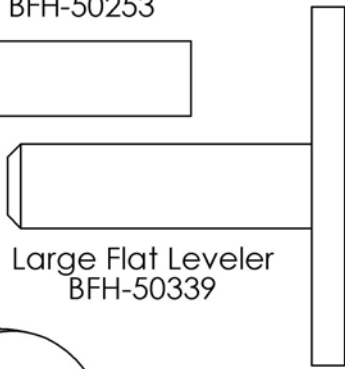


Note: Bolt length is measured from the underside of the head of the bolt.

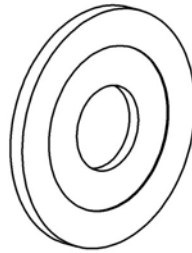




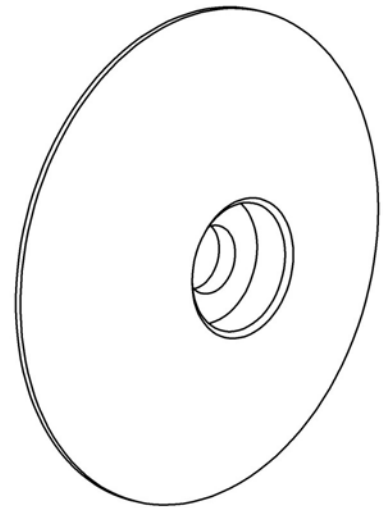
Beveled Level  
BFH-50253



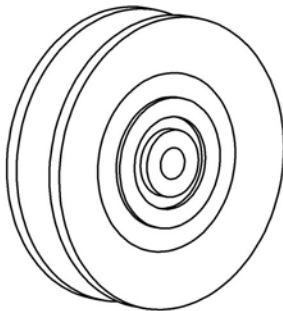
Large Flat Level  
BFH-50339



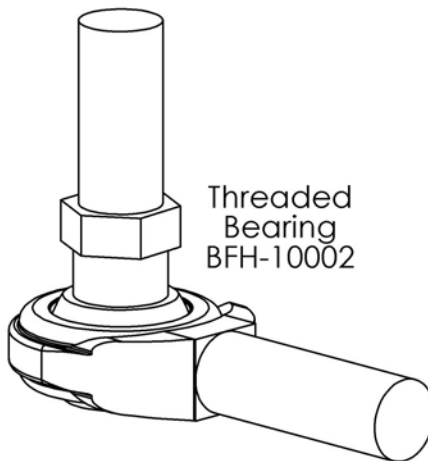
3" Plastic Washer  
BFH-50221



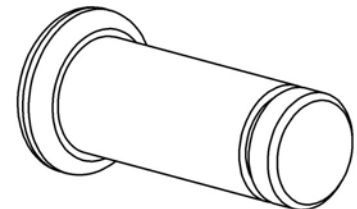
Upholstery Cap  
BFH-50622



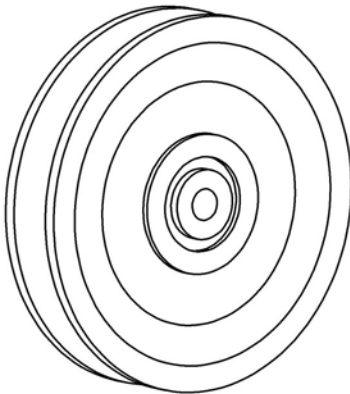
3 1/2" Pulley  
BFH-50173



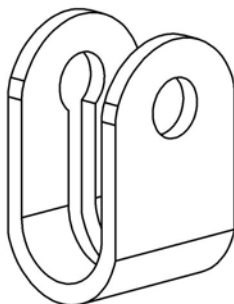
Threaded  
Bearing  
BFH-10002



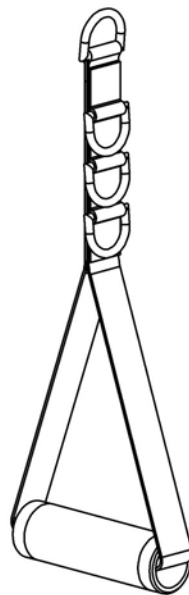
Pin  
BFH-50238



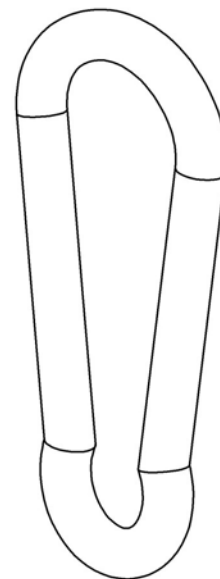
4 1/2" Pulley  
BFH-50174



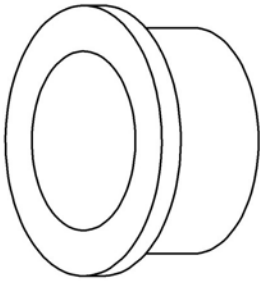
Cable Strap  
BFH-50227



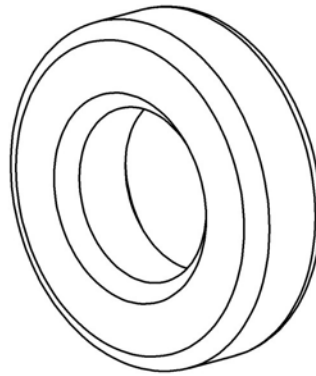
Strap Handle  
BFC-10103



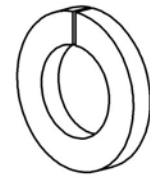
Snap Hook  
BFH-50188



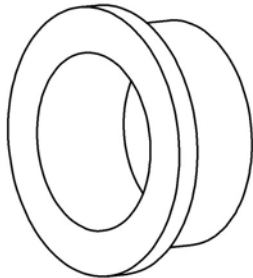
1" Bronze Bushing  
BFH-50101



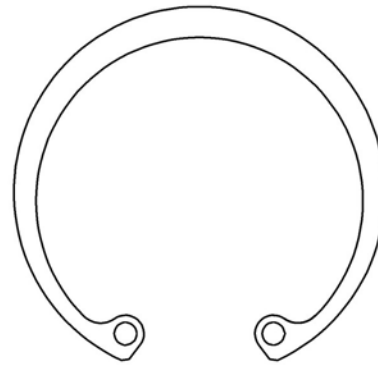
1" ID Bearing  
BFH-50602



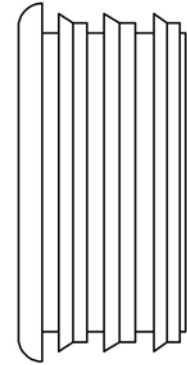
1/2" Lock Washer (Black)  
BFH-50613



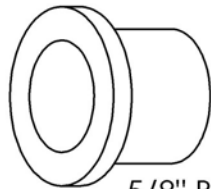
1" Bronze Bushing x 1/2 L  
BFH-50297



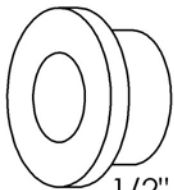
2" Internal Snap Ring  
BFH-50604



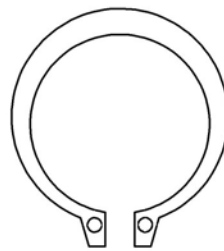
2" Round Plastic Cap  
BFH-50611



5/8" Bronze Bushing  
BFH-50102



1/2" Bronze Bushing  
BFH-50103



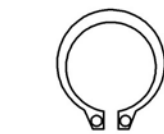
1" Snap Ring  
BFH-50165



1" Inner Plastic Cap  
BFH-50280



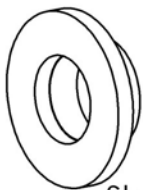
Cable Pivot Bushing  
BFH-50248



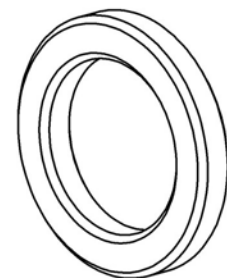
1/2" Snap Ring  
BFH-50166



Snap Ring  
BFH-50239

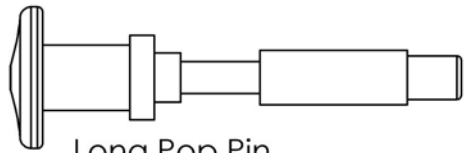


Short 1/2" Bushing  
BFH-50244

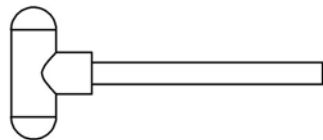


1/4" Sleeve  
BFH-50338

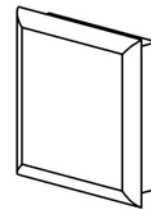




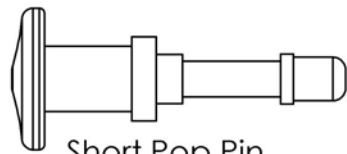
Long Pop Pin  
BFM-51172



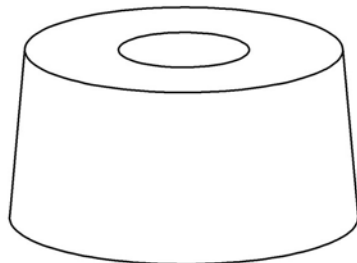
Magnetic Weight Stack Pin  
BFC-50127



Plastic Cap



Short Pop Pin  
BFM-51175



Rubber Donut  
BFM-50529

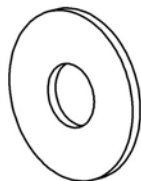
Part #	Size
BFH-50211	2" x 2"
BFH-50212	2" x 3"
BFH-50213	1 1/2" x 2"
BFH-50214	1 3/4" x 1 3/4"
BFH-50215	1 1/2" x 1 1/2"



Pop Pin Cap  
BFM-51181



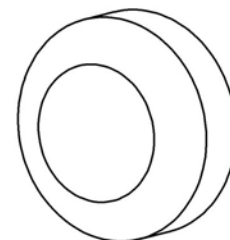
3/8" Curved Washer  
BFH-50204



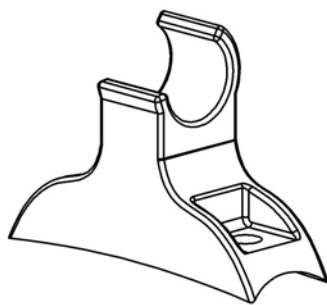
3/8" Flat Washer  
BFH-50146



1/2" Flat Washer  
BFH-50251



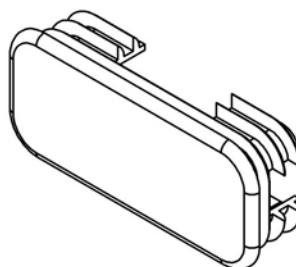
Screw Cap Cover  
BFH-50112



Mounting Bracket  
BFH-50618



3/8" Lock Washer  
BFH-50147



1 3/4" x 4" Rectangular Cap  
BFH-50612

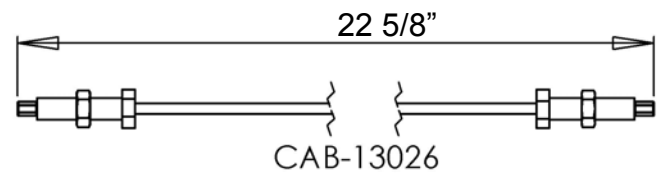
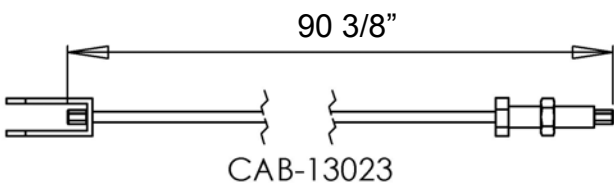
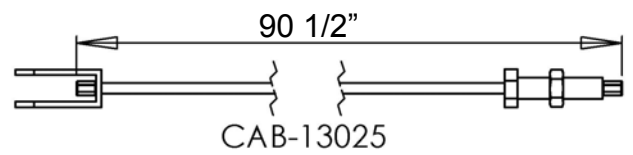
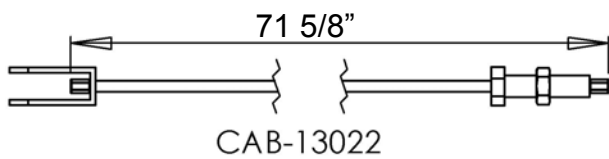
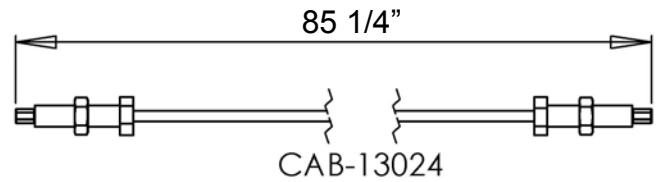
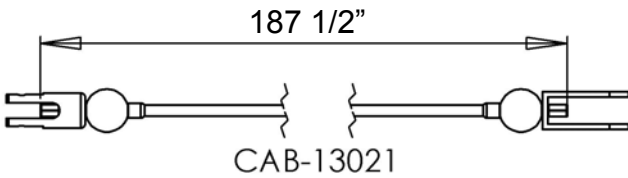


6" Rubber Grips (Yellow)  
BFH-50614

Items not shown.

BFH-50278	Silver Metallic Paint
BFH-50198	Large Logo
BFH-50197	Small Logo
BFH-50236	Foam Grip
BFH-50262	Silicon Gel Pack

# Cable Comparison Chart



## Cables

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
101	CAB-13021	Fusion Lat Pull to Functional Arm	2
109	CAB-13022	Fusion Weight Stack to Cable Tie Out	1
102	CAB-13023	Fusion Leg Press Cable	1
103	CAB-13024	Fusion Floating Pulley Cable	1
104	CAB-13025	Fusion Leg Extension Cable	1
106	CAB-13026	Fusion Tie Out Cable	1



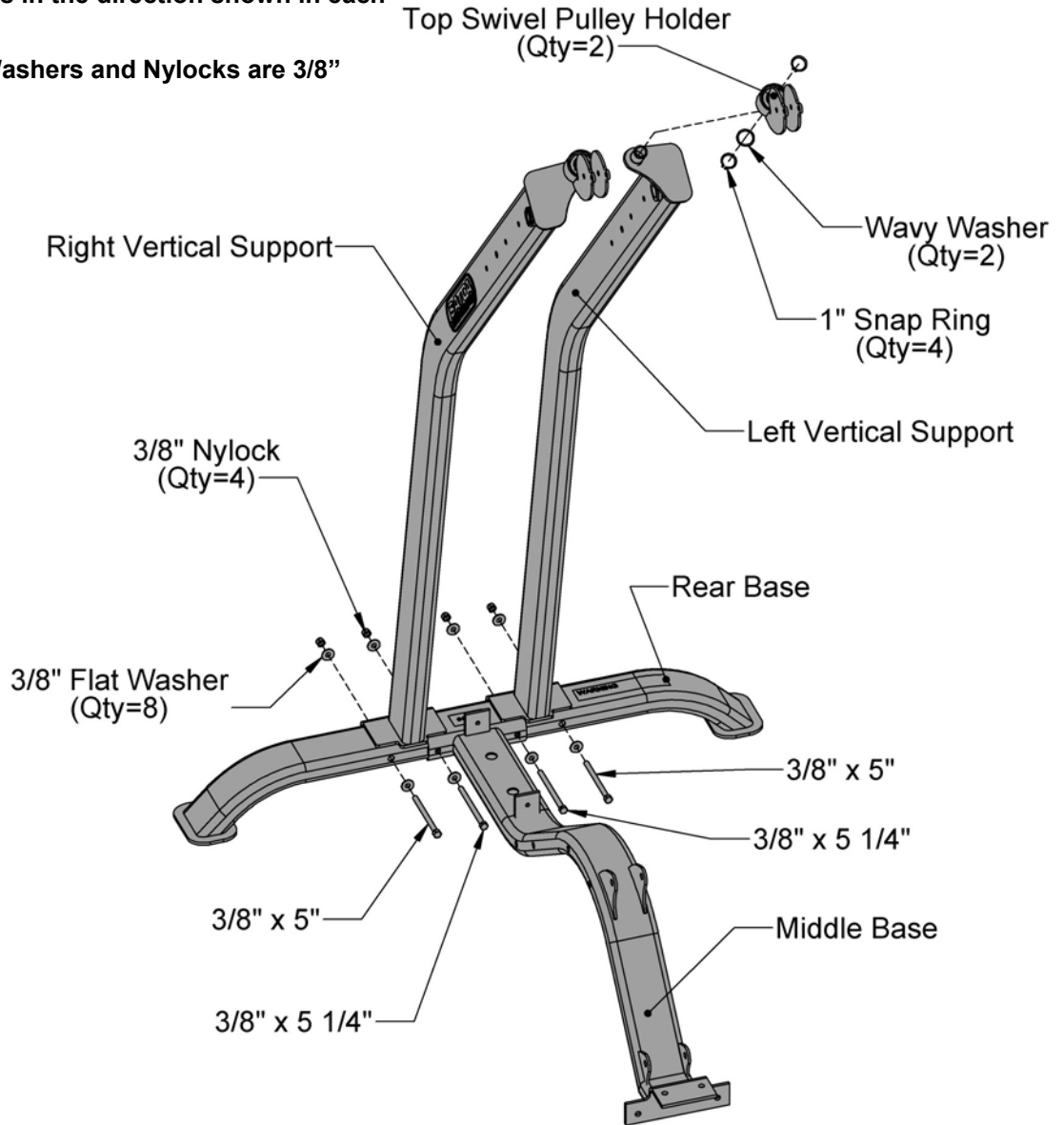
**PLEASE FOLLOW ALL DIRECTIONS VERY CAREFULLY FOR PROPER INSTALLATION.**

**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"

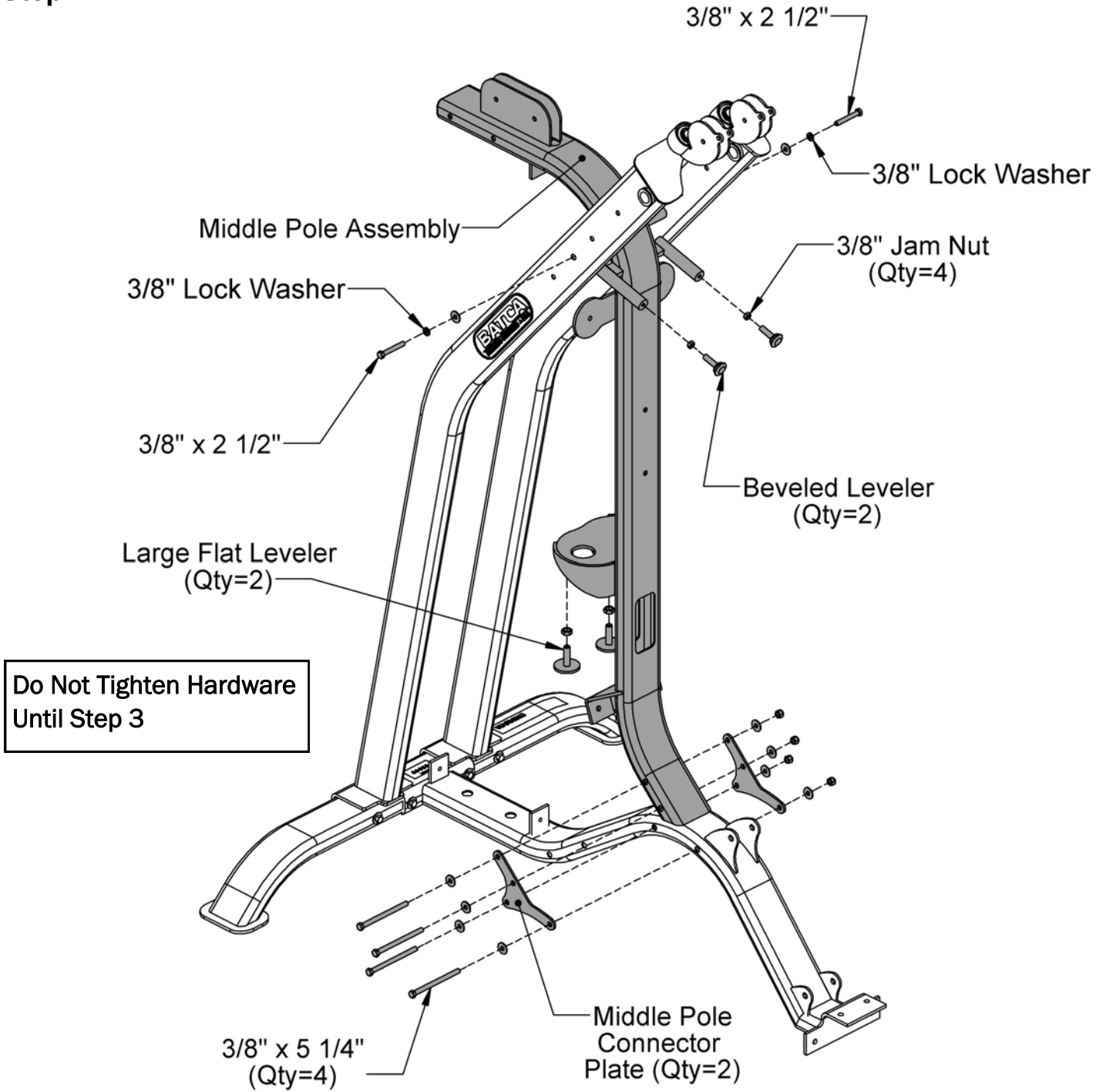


**Do Not Tighten Hardware Until Step 3**

Figure 1

Item #	Part #	Description	Qty
1	BFM-10593	Rear Base	1
2	BFM-10566	Left Vertical Support	1
3	BFM-10567	Right Vertical Support	1
4	BFM-10568	Middle Base	1
37	BFM-10583	Top Swivel Pulley	2
55	BFH-50165	1" Snap Ring	4
56	BFH-50146	3/8" Flat Washer (Black)	8
57	BFH-50157	3/8"-16 Nylock (Black)	4
58	BFH-50270	HCS 3/8"-16 X 5 1/4" P5	2
118	BFH-50279	HCS 3/8"-16 X 5" P5	2
182	BFH-50337	Wavy Washer	2

**Step 2:**



**Do Not Tighten Hardware Until Step 3**

Figure 2

Item #	Part #	Description	Qty
5	BFM-10569	Middle Pole Assembly	1
18	BFL-50197	Middle Pole Connector Plate	2
56	BFH-50146	3/8" Flat Washer (Black)	10
58	BFH-50157	3/8"-16 Nylock (Black)	4
59	BFH-50270	HCS 3/8"-16 X 5 1/4" P5	4
60	BFH-50147	3/8" Lock Washer (Black)	2
76	BFH-50123	HCS 3/8"-16 X 2 1/2" P5	2
98	BFH-50253	Beveled Leveler	2
99	BFH-50149	3/8"-16 Jam Nut (Zinc)	4
181	BFH-50339	Large Flat Leveler	2

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

**Step 3:**

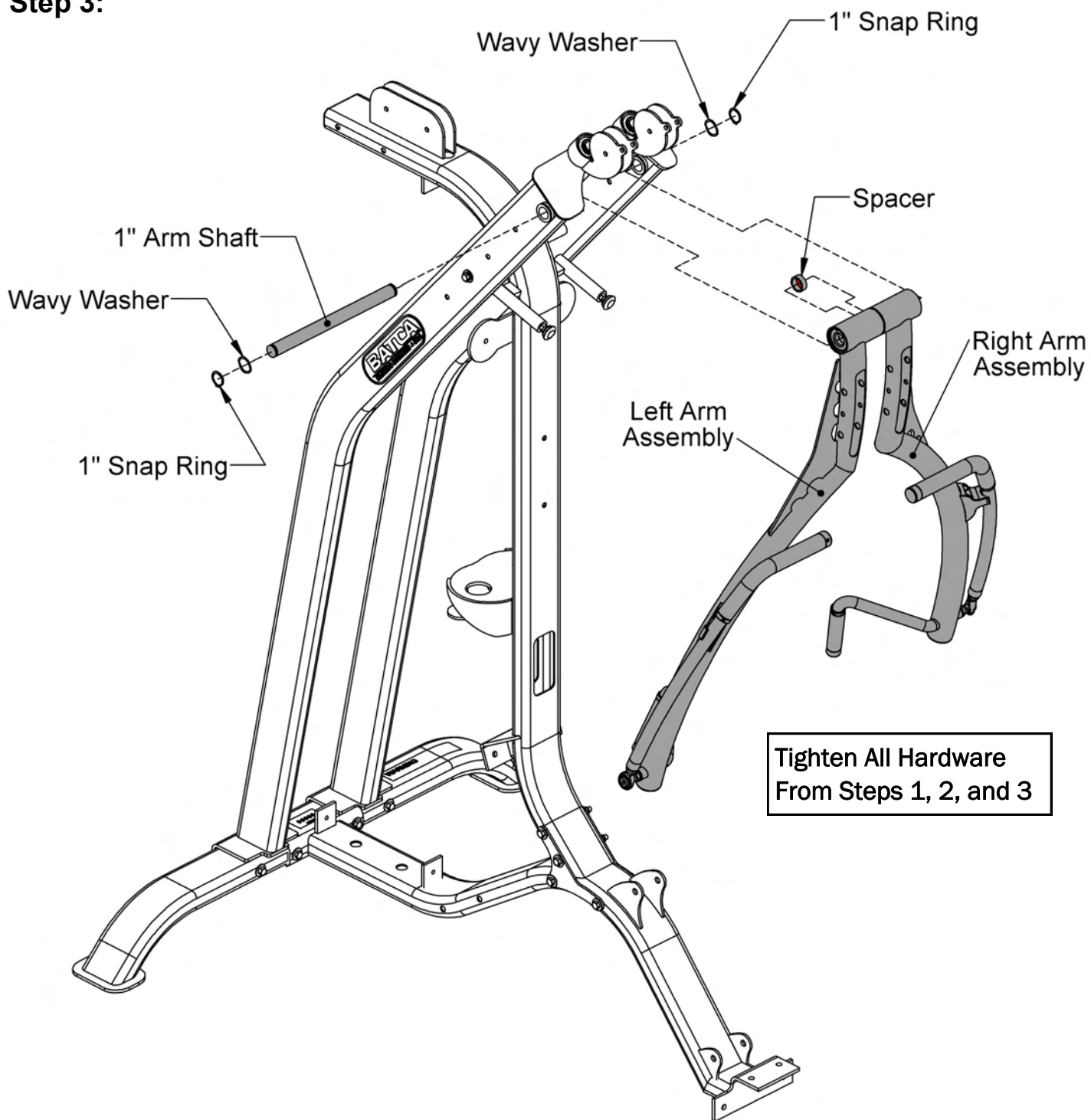


Figure 3

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

Item #	Part #	Description	Qty
13	BFM-10570	Right Arm Assembly	1
14	BFM-10574	Left Arm Assembly	1
35	BFM-51080	.45" Spacer	1
54	BFM-51148	1" Arm Shaft	1
55	BFH-50165	1" Snap Ring	2
182	BFH-50337	Wavy Washer	2

**Step 4:**

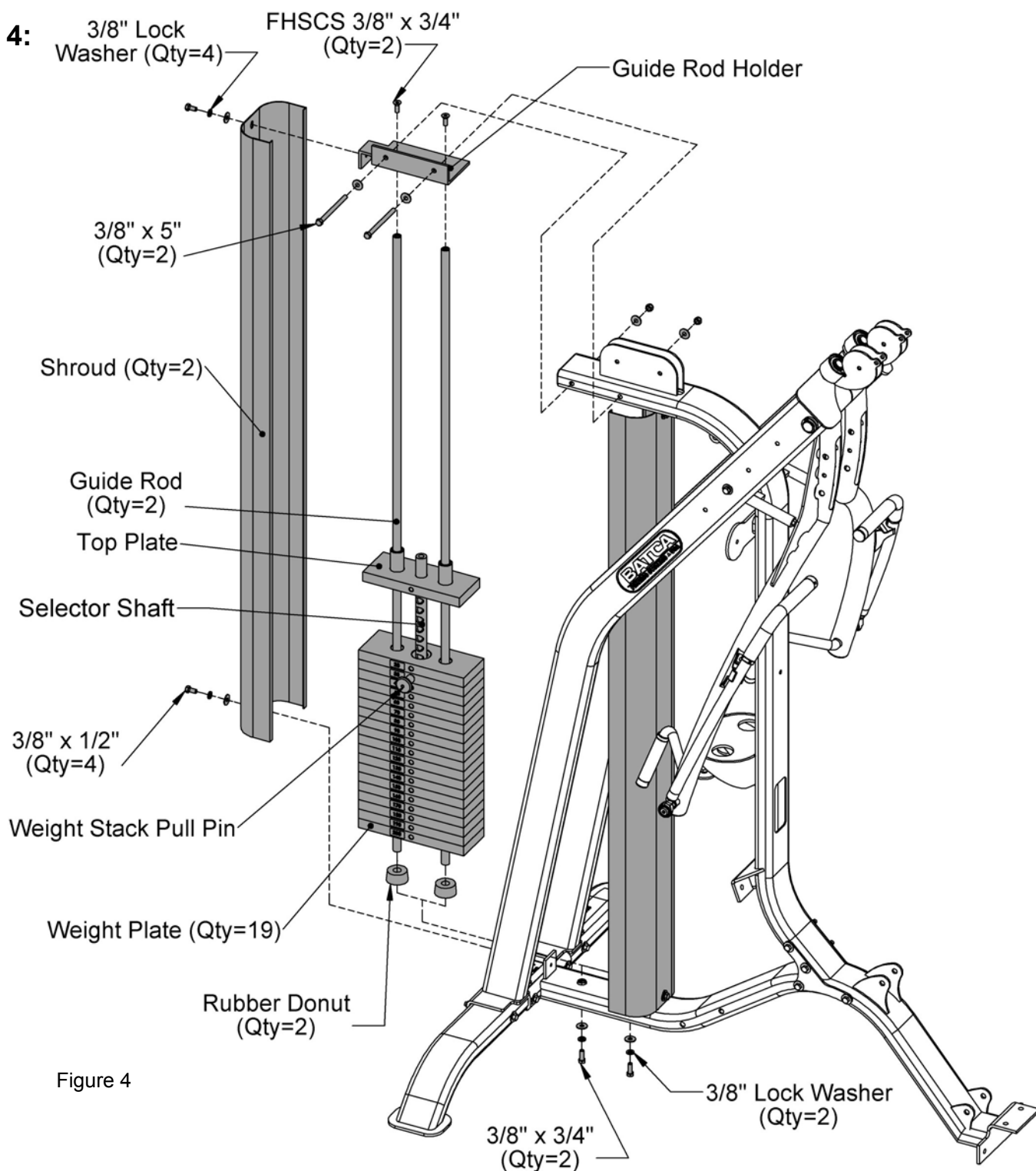


Figure 4

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

Item #	Part #	Description	Qty
6	BFM-51044	Guide Rod Holder	1
9	BFM-50529	Rubber Donut	2
10	BFM-50256	Weight Plate	19
12	BFM-51051	Guide Rod	2
38	BFM-51082	Weight Stack Shroud	2
56	BFH-50146	3/8" Flat Washer (Black)	10
58	BFH-50157	3/8"-16 Nylock (Black)	2
60	BFH-50147	3/8" Lock Washer (Black)	6

Item #	Part #	Description	Qty
107	BFM-10299	Top Plate	1
108	BFM-50258	Selector Shaft	1
111	BFH-50192	Weight Stack Decals	2
116	BFH-50254	HCS 3/8"-16 X 3/4" P5	2
118	BFH-50279	HCS 3/8"-16 X 5" P5	2
123	BFM-51173	Weight Stack Pull Pin	1
183	BFH-50630	FHSCS 3/8"-16 X 3/4"	2
184	BFH-50631	HCS 3/8"-16 X 1/2" P5	4

**Step 5:**

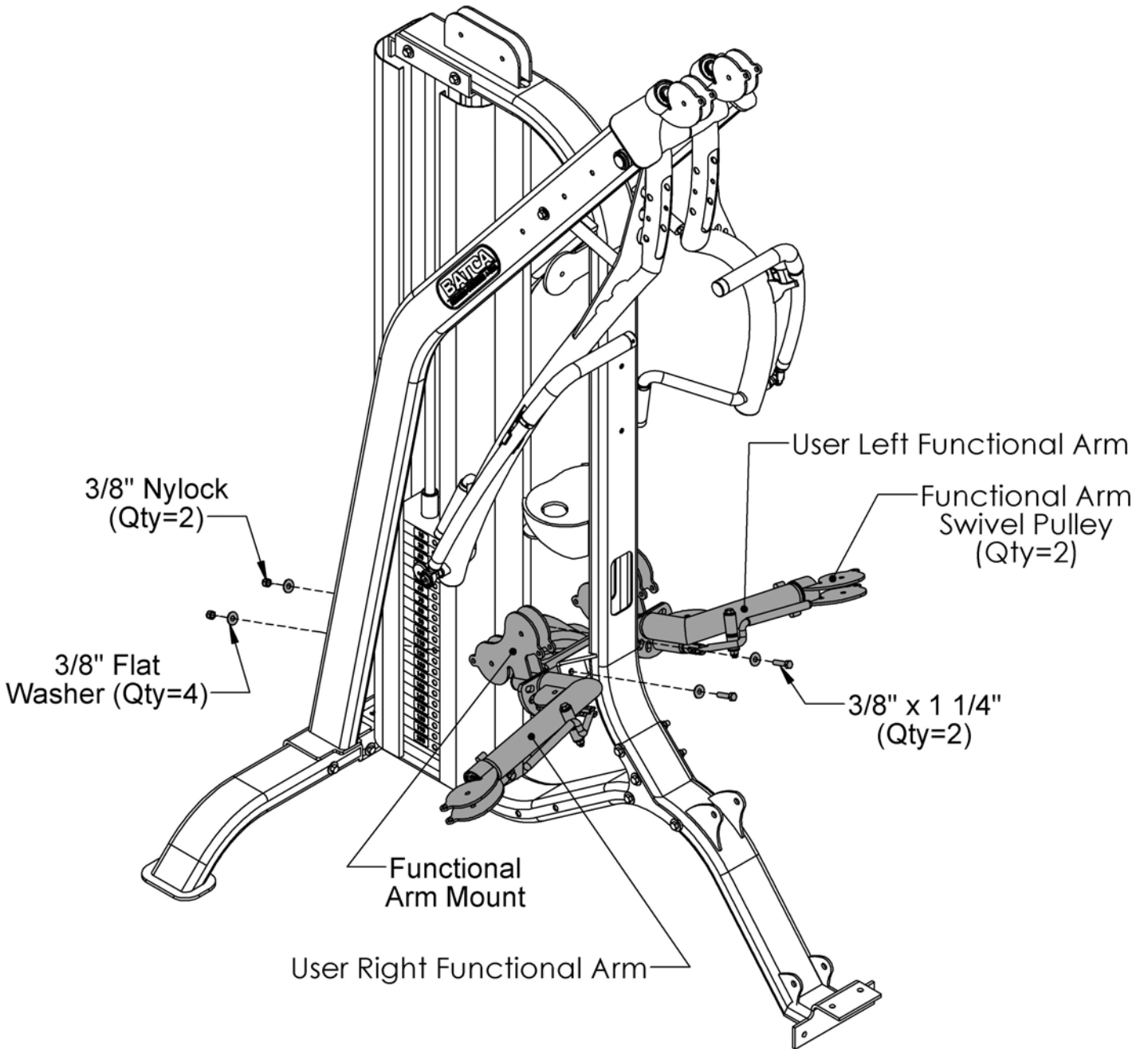


Figure 5

Item #	Part #	Description	Qty
15	BFM-10573	Functional Arm Mount	1
16	BFM-10571	User Right Functional Arm	1
17	BFM-10572	User Left Functional Arm	1
36	BFM-10582	Functional Arm Swivel Pulley	2
56	BFH-50146	3/8" Flat Washer (Black)	4
58	BFH-50157	3/8"-16 Nylock (Black)	2
61	BFH-50119	HCS 3/8"-16 1 1/4" P5	2

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

**Step 6:**

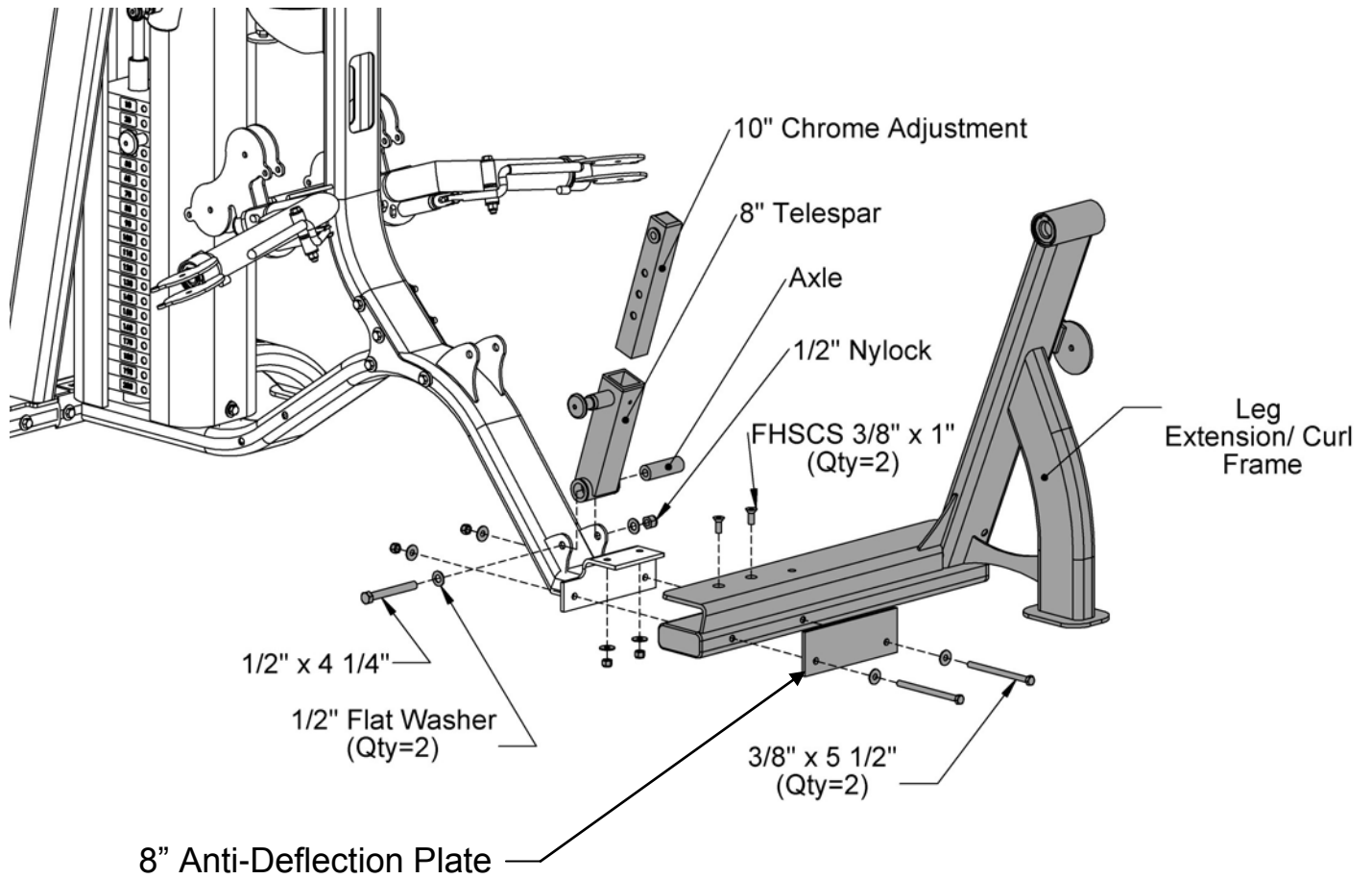


Figure 6

Item #	Part #	Description	Qty
20	BFM-10577	8" Telespar	1
24	BFM-10579	10" Chrome Adjustment	1
33	BFM-10581	Leg Extension/ Curl Frame	1
53	BFM-51143	8" Anti-Deflection Plate	1
56	BFH-50146	3/8" Flat Washer (Black)	6
58	BFH-50157	3/8"-16 Nylock (Black)	4
64	BFH-50251	1/2" Flat Washer Black	2
66	BFH-50139	HCS 1/2-13 X 4 1/4 P5	1
68	BFH-50155	1/2"-13 Nylock (Black)	1
74	BFH-50132	HCS 3/8"-16 X 5 1/2" P5	2
115	BFH-50144	FHSCS 3/8"-16 X 1"	2
122	BFM-50931	3" Axle	1

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



**Step 7:**

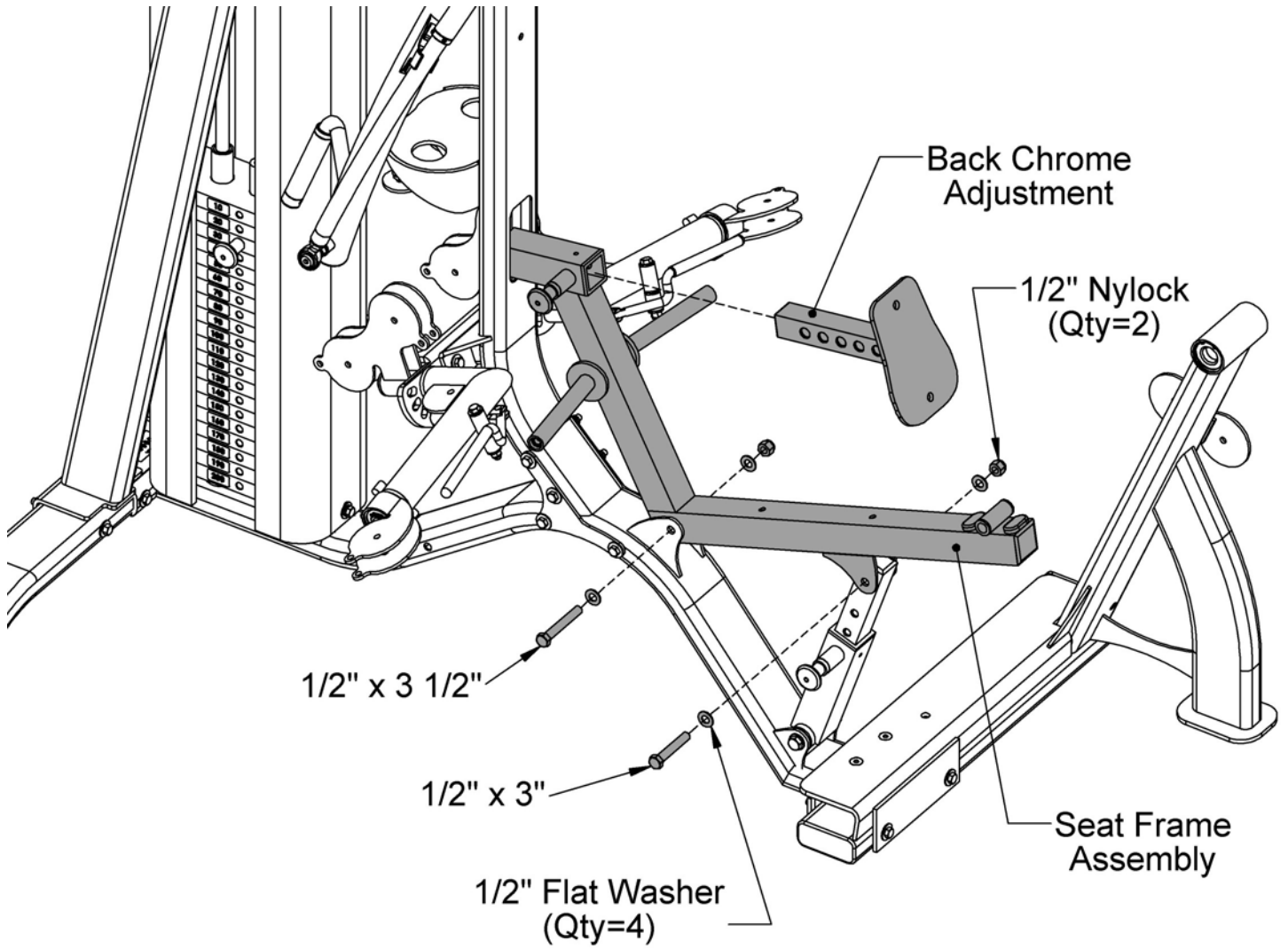


Figure 7

Item #	Part #	Description	Qty
21	BFM-10578	Seat Frame Assembly	1
30	BFM-10580	Back Chrome Adjustment	1
64	BFH-50251	1/2" Flat Washer (Black)	4
65	BFH-50138	HCS 1/2"-13 X 3 1/2" P5	1
67	BFH-50136	HCS 1/2"-13 X 3" P5	1
68	BFH-50155	1/2"-13 Nylock (Black)	2

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

**Step 8:**

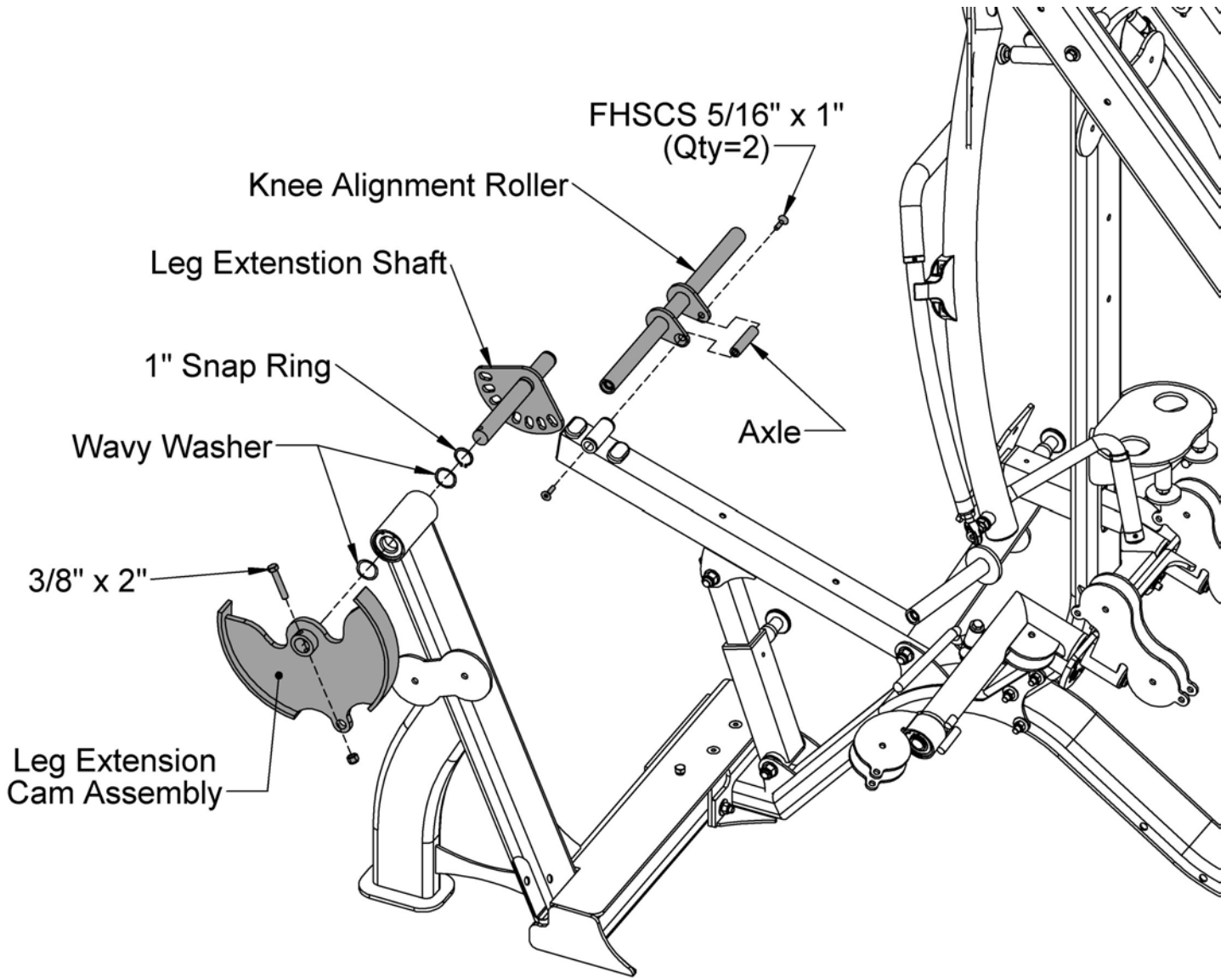


Figure 8

Item #	Part #	Description	Qty
25	BFM-10141	Knee Alignment Roller	1
39	BFM-10584	Leg Extension Shaft	1
40	BFM-10585	Leg Extension Cam Assembly	1
55	BFH-50165	1" Snap Ring	1
58	BFH-50157	3/8"-16 Nylock (Black)	1
70	BFH-50121	HCS 3/8"-16 X 2" P5	1
119	BFH-50245	FHSCS 5/16"-18 X 1"	2
121	BFM-50222	2 9/16" Axle	1
182	BFH-50337	Wavy Washer	2

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

## Step 9:

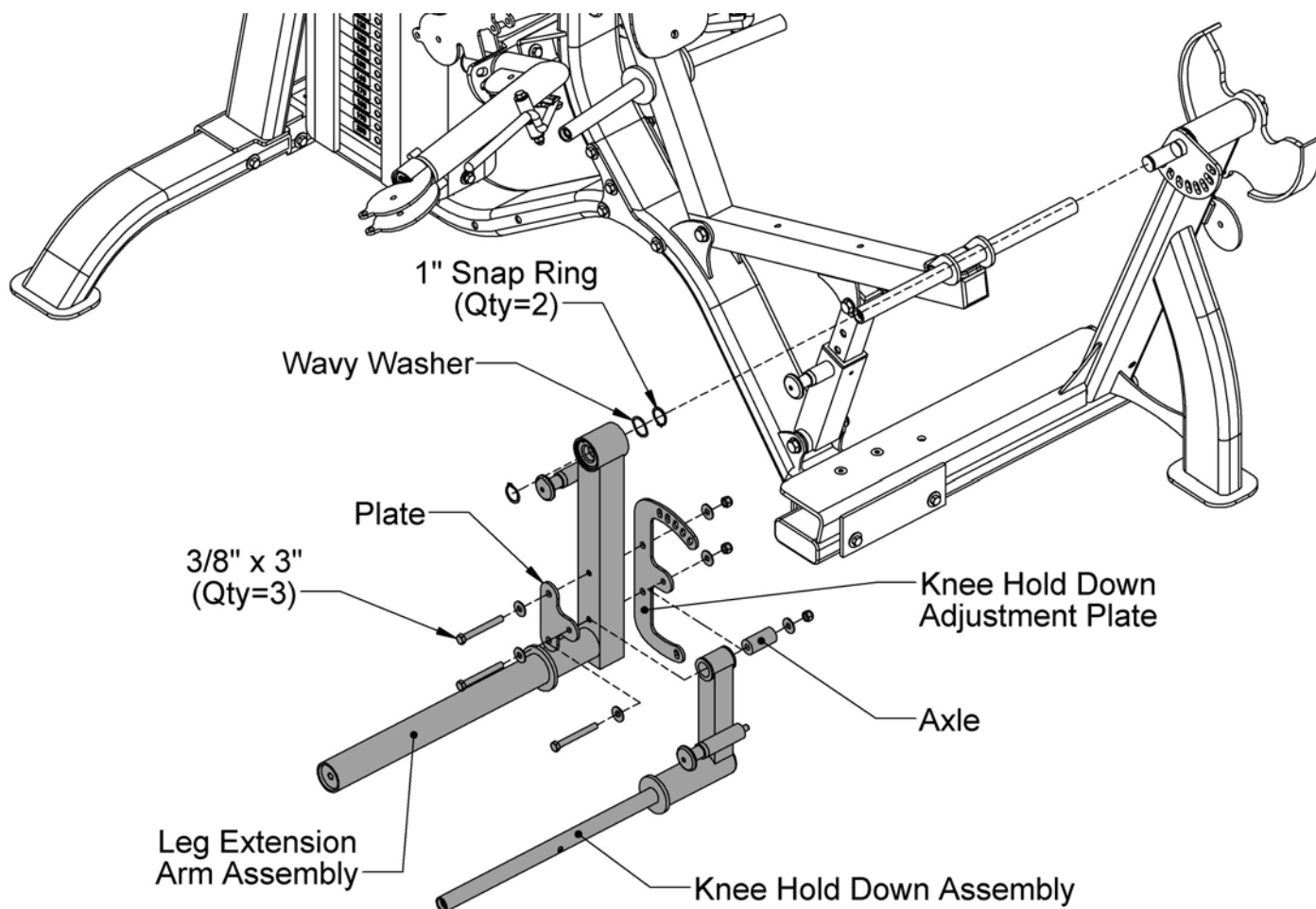


Figure 9

Item #	Part #	Description	Qty
42	BFM-10586	Leg Extension Arm Assembly	1
44	BFL-50207	Hold Down Adjustment Plate	1
45	BFL-50211	Plate	1
46	BFM-10587	Knee Hold Down Assembly	1
47	BFM-51094	2" Axle	1
55	BFH-50165	1" Snap Ring	2
56	BFH-50146	3/8" Flat Washer (Black)	6
58	BFH-50157	3/8"-16 Nylock (Black)	3
63	BFH-50125	HCS 3/8"-16 X 3" P5	3
182	BFH-50337	Wavy Washer	1

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

# Cable Routing

## Step 10:

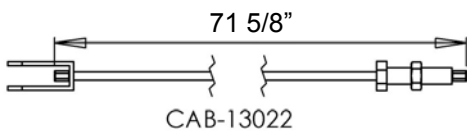
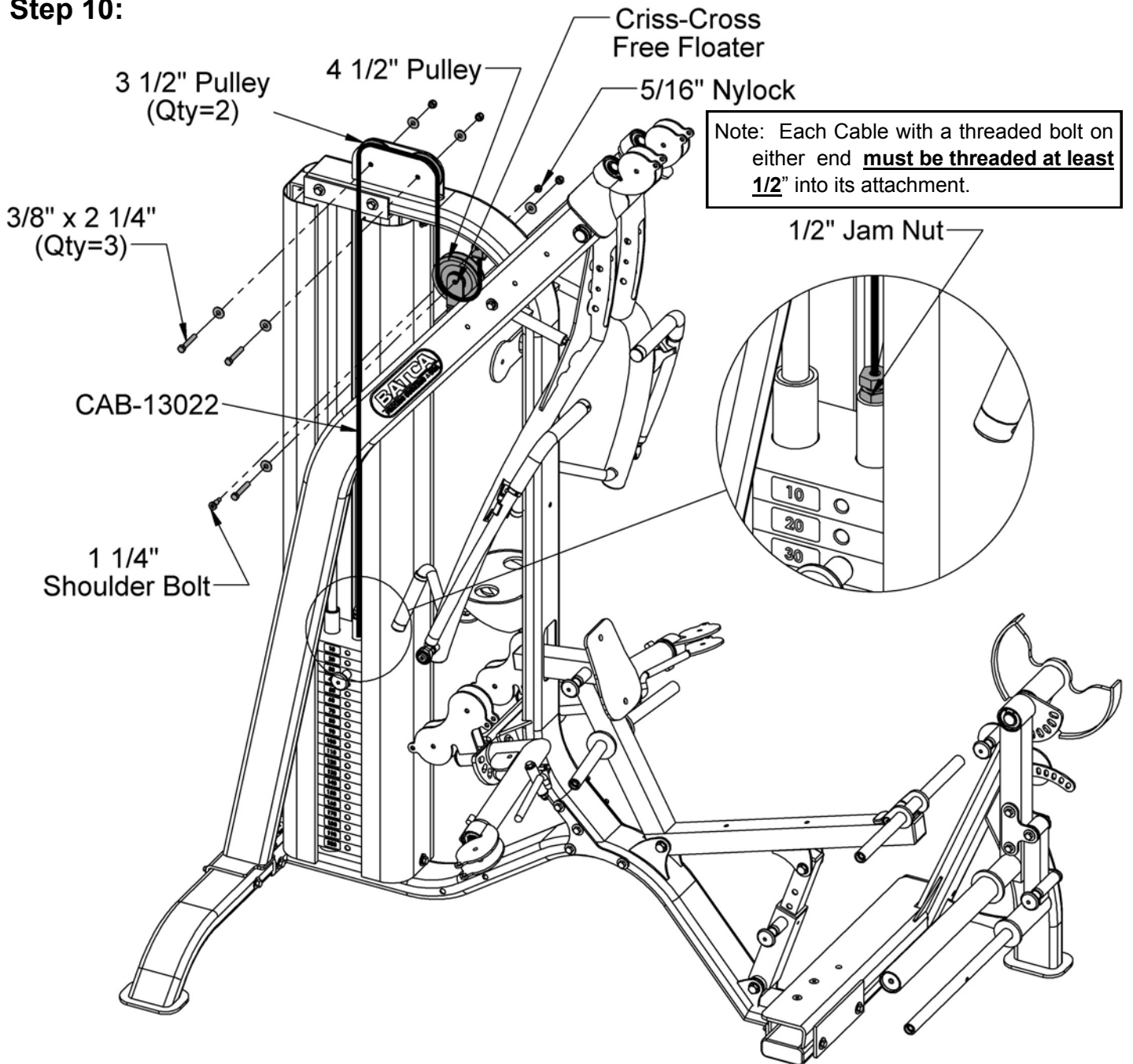


Figure 10

Item #	Part #	Description	Qty
8	BFH-50173	3 1/2" Pulley	2
56	BFH-50146	3/8" Flat Washer (Black)	6
57	BFH-50122	HCS 3/8"-16 X 2 1/4" P5	3
58	BFH-50157	3/8"-16 Nylock (Black)	3
92	BFH-50256	1/2" Jam Nut	1
94	BFM-10611	Criss-Cross Free Floater	1
95	BFH-50174	4 1/2" Pulley	1
109	CAB-13022	Fusion Weight Stack to Cable Tie Out	1
113	BFH-50250	1 1/4" Shoulder Bolt	1
114	BFH-50267	5/16"-18 Nylock (Black)	1

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

**Step 11:**

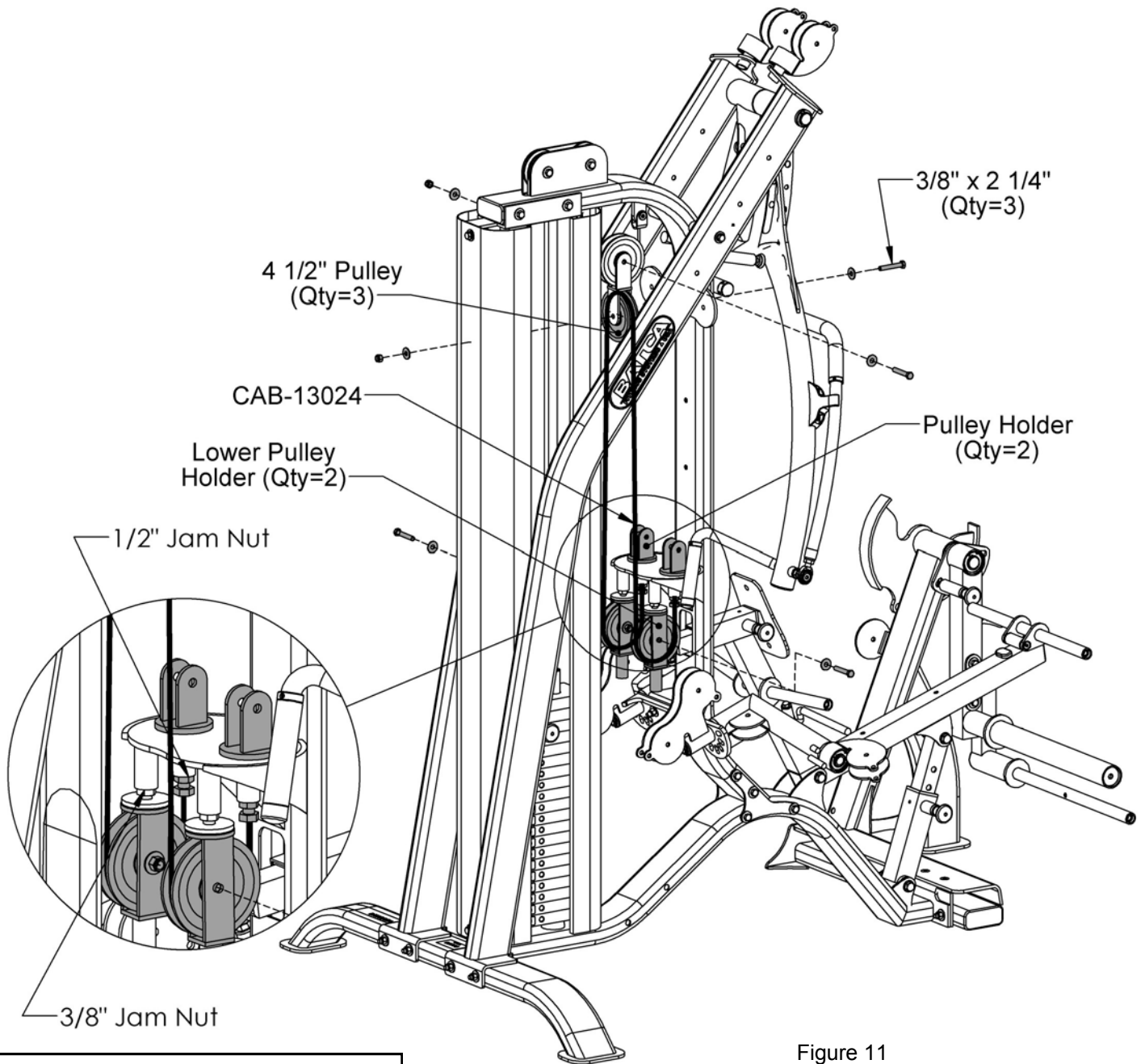
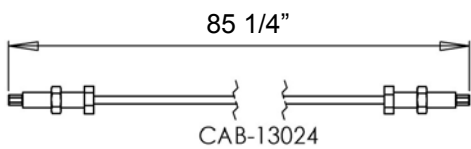


Figure 11

Note: Each Cable with a threaded bolt on either end **must be threaded at least 1/2"** into its attachment.



Item #	Part #	Description	Qty
56	BFH-50146	3/8" Flat Washer (Black)	6
57	BFH-50122	HCS 3/8"-16 X 2 1/4" P5	3
58	BFH-50157	3/8"-16 Nylock (Black)	3
92	BFH-50256	1/2" Jam Nut	2
93	BFM-10609	Pulley Holder	2
95	BFH-50174	4 1/2" Pulley	3
96	BFM-10610	Lower Pulley Holder	2
99	BFH-50149	3/8" Jam Nut	2
103	CAB-13024	Fusion Floating Pulley Cable	1

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

## Step 12:



**Note: If Leg Press Option is purchased skip this step and continue to Step 13 on Page 23.**

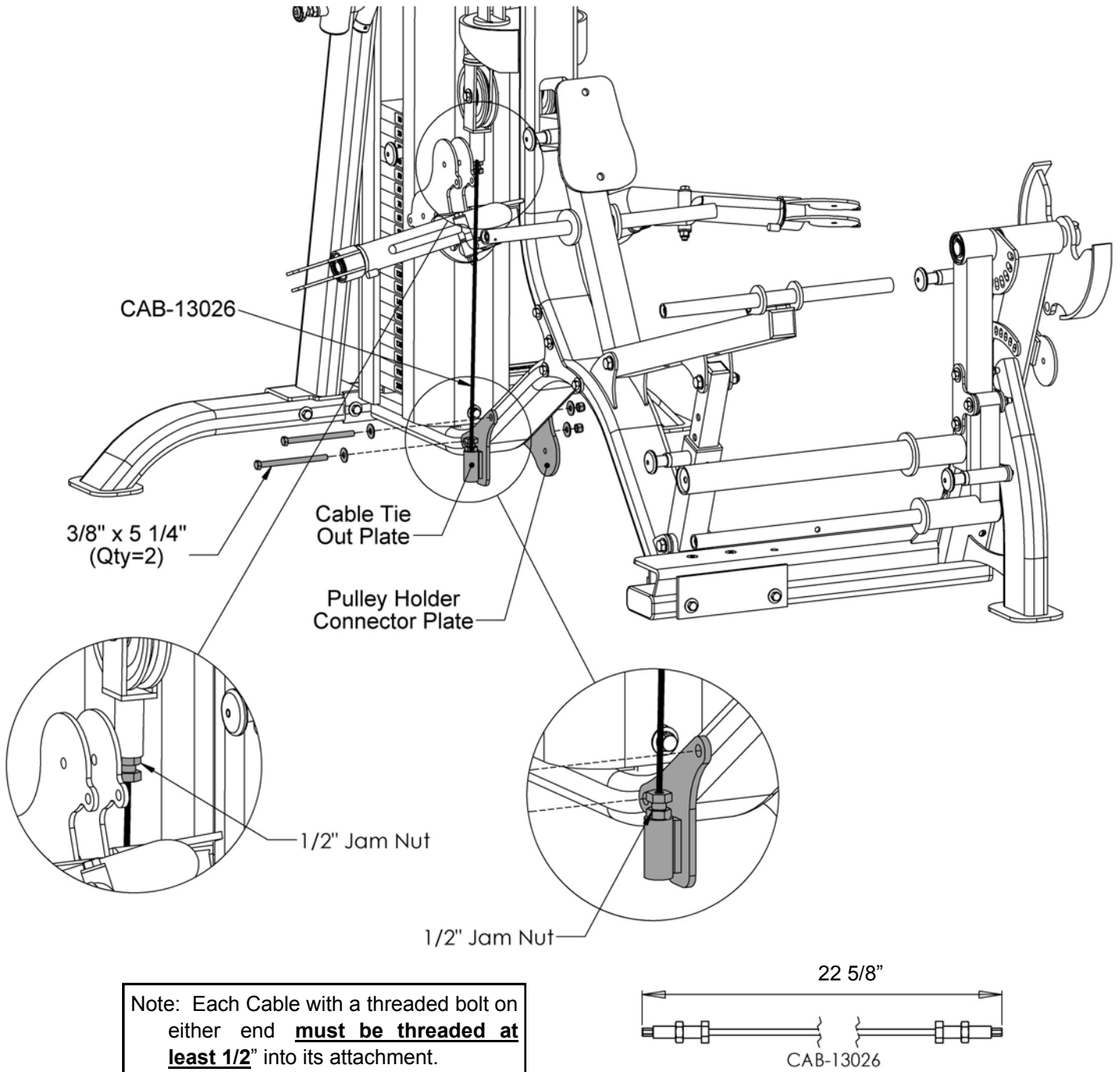


Figure 12

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

Item #	Part #	Description	Qty
19	BFL-50203	Pulley Holder Connector Plate	1
56	BFH-50146	3/8" Flat Washer (Black)	4
58	BFH-50157	3/8"-16 Nylock (Black)	2
59	BFH-50270	HCS 3/8"-16 X 5 1/4" P5	2
92	BFH-50256	1/2" Jam Nut	2
105	BFM-10612	Cable Tie Out Plate	1
106	CAB-13026	Fusion Tie Out Cable	1

### Step 13:



Note: If Leg Press Option is purchased later, remove CAB-13026 and Cable Tie-Out Plate from Step 12 on Page 22.

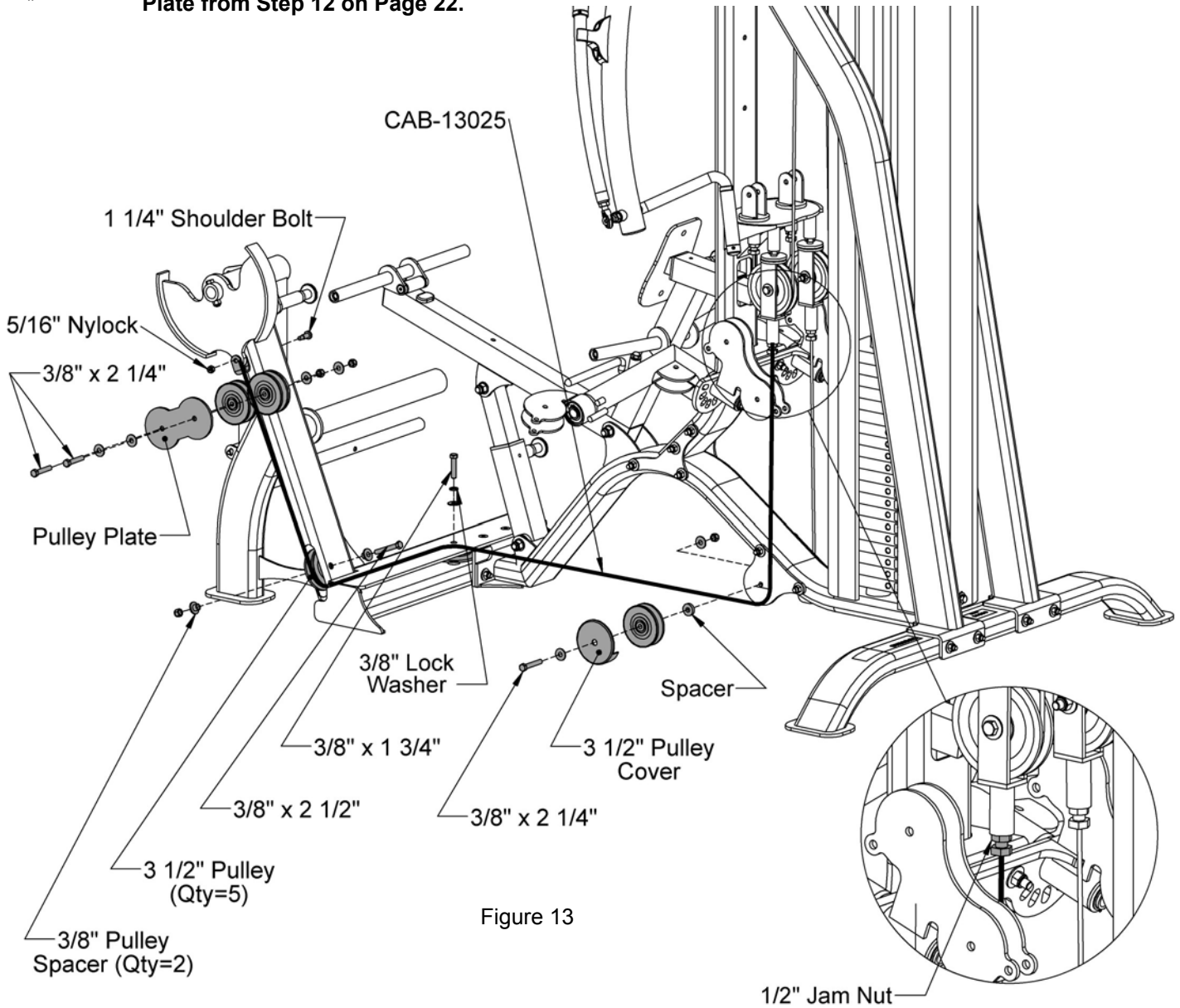
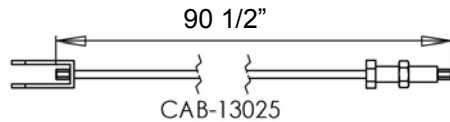


Figure 13



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
8	BFH-50173	3 1/2" Pulley	5
60	BFH-50147	3/8" Lock Washer (Black)	1
50	BFL-50221	Pulley Plate	1
56	BFH-50146	3/8" Flat Washer (Black)	7
57	BFH-50122	HCS 3/8"-16 X 2 1/4" P5	3
58	BFH-50157	3/8"-16 Nylock (Black)	4
70	BFH-50121	HCS 3/8"-16 X 2" P5	1
73	BFH-50285	HCS 3/8"-16 1 3/4" P5	1

Item #	Part #	Description	Qty
75	BFH-50605	3/8" Pulley Spacer	2
76	BFH-50123	HCS 3/8"-16 X 2 1/2" P5	1
77	BFM-50505	3 1/2" Pulley Cover	1
92	BFH-50256	1/2" Jam Nut	1
104	CAB-13025	Fusion Leg Extension Cable	1
113	BFH-50250	1 1/4" Shoulder Bolt	1
114	BFH-50267	5/16"-18 Nylock (Black)	1
185	BFM-51158	Spacer	1

**Step 14:**

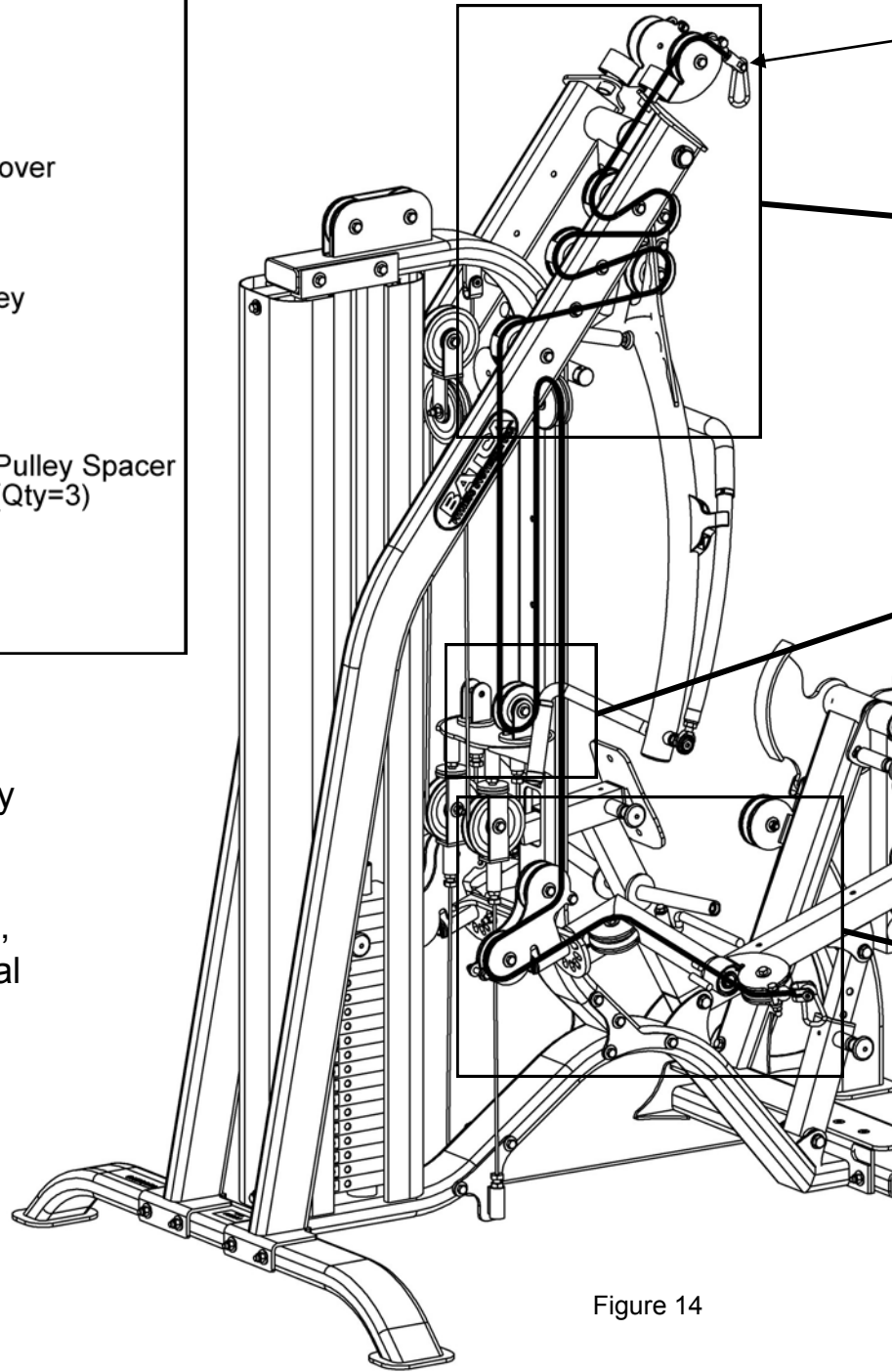
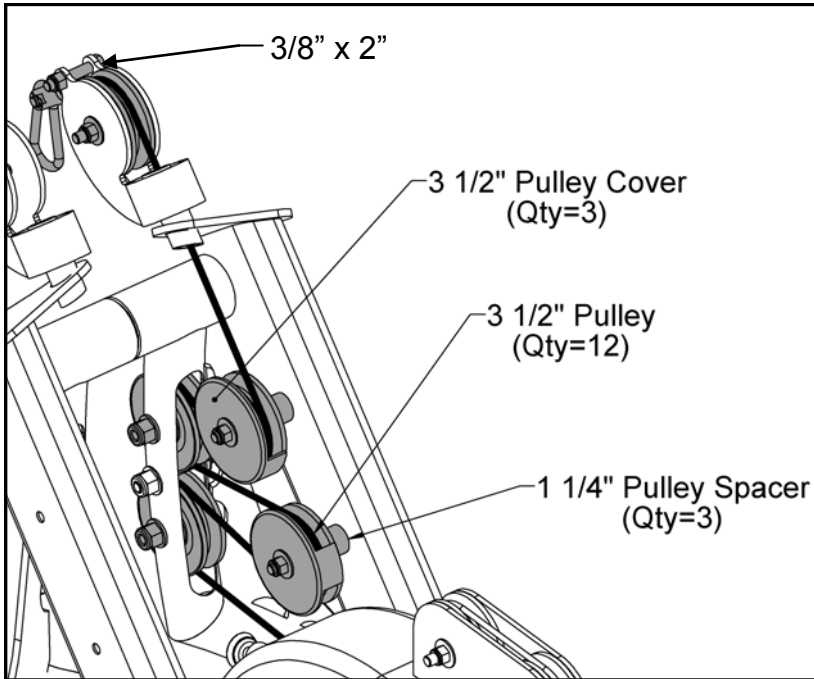
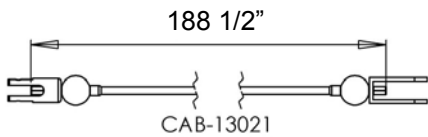


Figure 14

**Note:** Reverse side of Fusion to better see nuts, bolts, pulley spacers, and pulley's

**Note:** Cable used is CAB-13020, Fusion Lat Pull to Functional Arm User Right



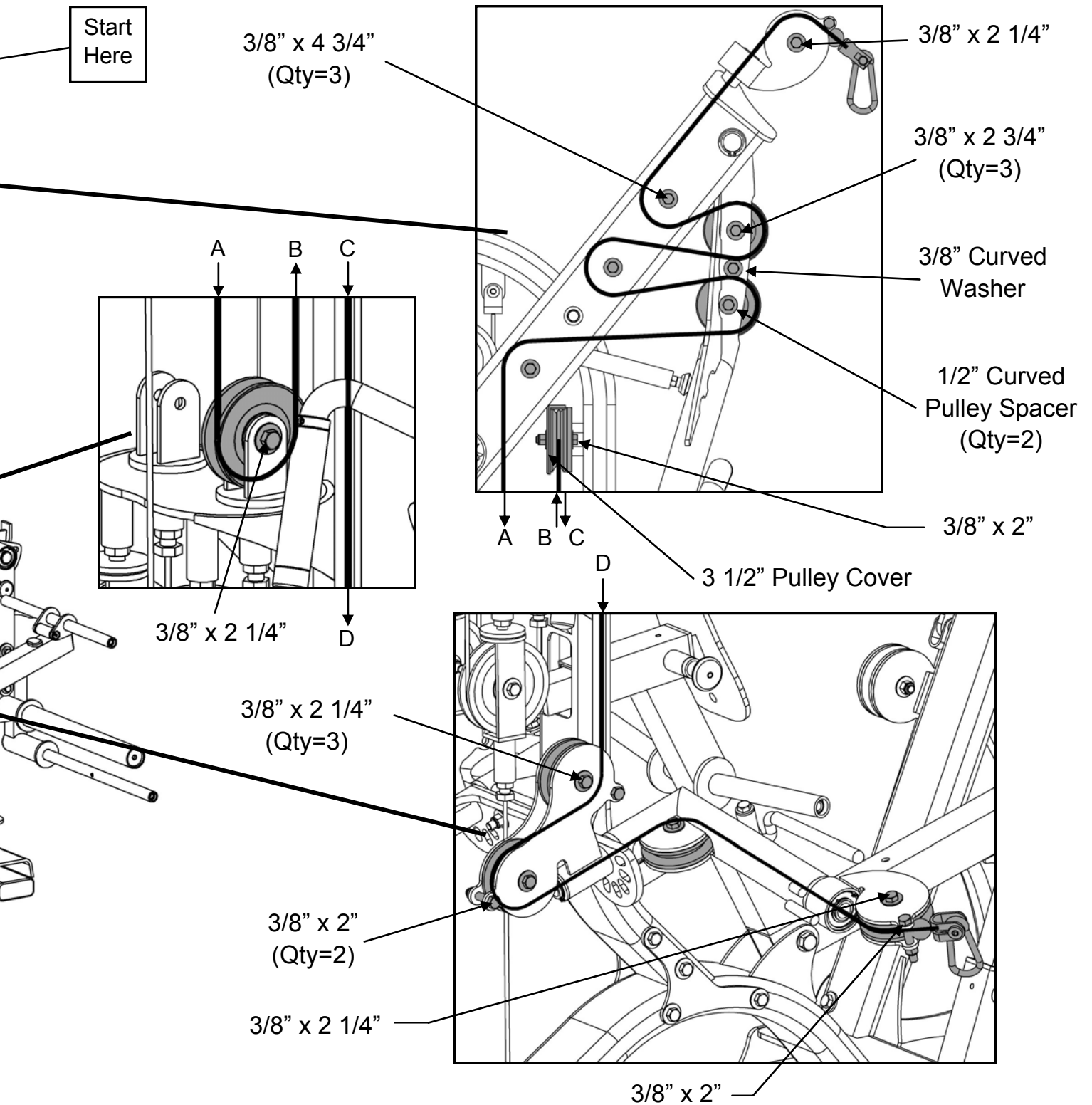
All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Item #	Part #	Description	Qty
7	BFM-51022	1 1/4" Spacer	3
8	BFH-50173	3 1/2" Pulley	12
56	BFH-50146	3/8" Flat Washer (Black)	20
57	BFH-50122	HCS 3/8"-16 X 2 1/4" P5	6
58	BFH-50157	3/8"-16 Nylock (Black)	17
62	BFH-50124	HCS 3/8"-16 X 2 3/4" P5	3

Item #	Part #	Description	Qty
70	BFH-50121	HCS 3/8"-16 X 2" P5	5
72	BFH-50274	HCS 3/8"-16 X 4 3/4" P5	3
77	BFM-50505	3 1/2" Pulley Cover	4
100	CAB-13021	Fusion Lat Pull to Functional Arm	1
154	BFH-50203	1/2" Curved Pulley Spacer	4
155	BFH-50204	3/8" Curved Washer (Black)	4



## Step 14: Continued



**Step 15:** Repeat for alternate side of Fusion. Use same Bill of Materials from Step 14 for Step 15. Use CAB-13021, Fusion Lat Pull to Functional Arm.

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

**Step 16:**

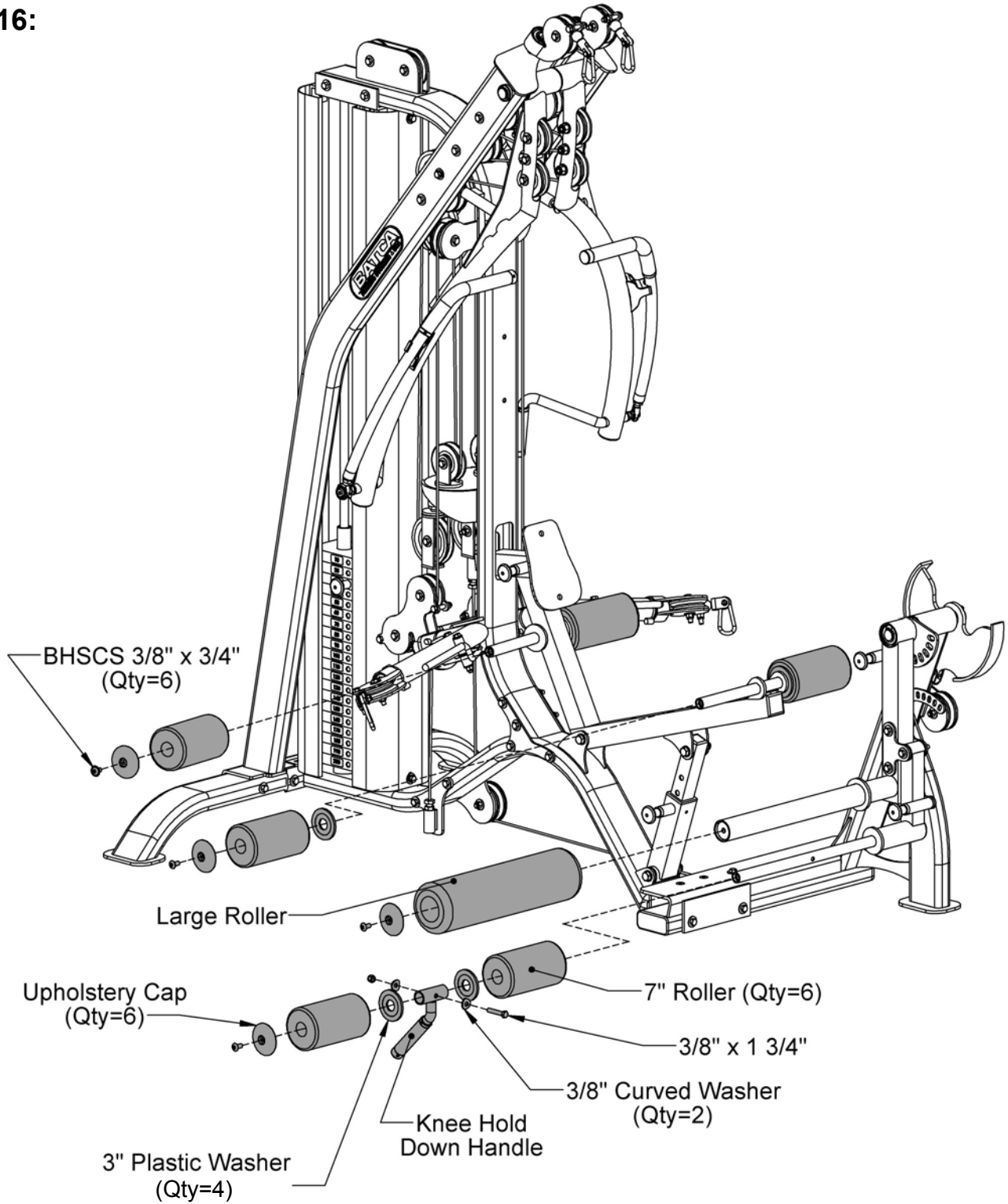


Figure 16

Item #	Part #	Description	Qty
27	BFH-50221	3" Plastic Washer	4
28	BFU-50189	7" Roller	6
43	BFU-50187	Large Roller	1
48	BFM-10588	Knee Hold Down Handle	1
58	BFH-50157	3/8"-16 Nylock (Black)	1
73	BFH-50285	HCS 3/8"-16 X 1 3/4" P5	1
155	BFH-50204	3/8" Curved Washer	2
186	BFH-50620	BHSCS 3/8"-16 X 3/4" P5	6
187	BFH-50622	Upholstery Cap	6

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

**Step 17:**

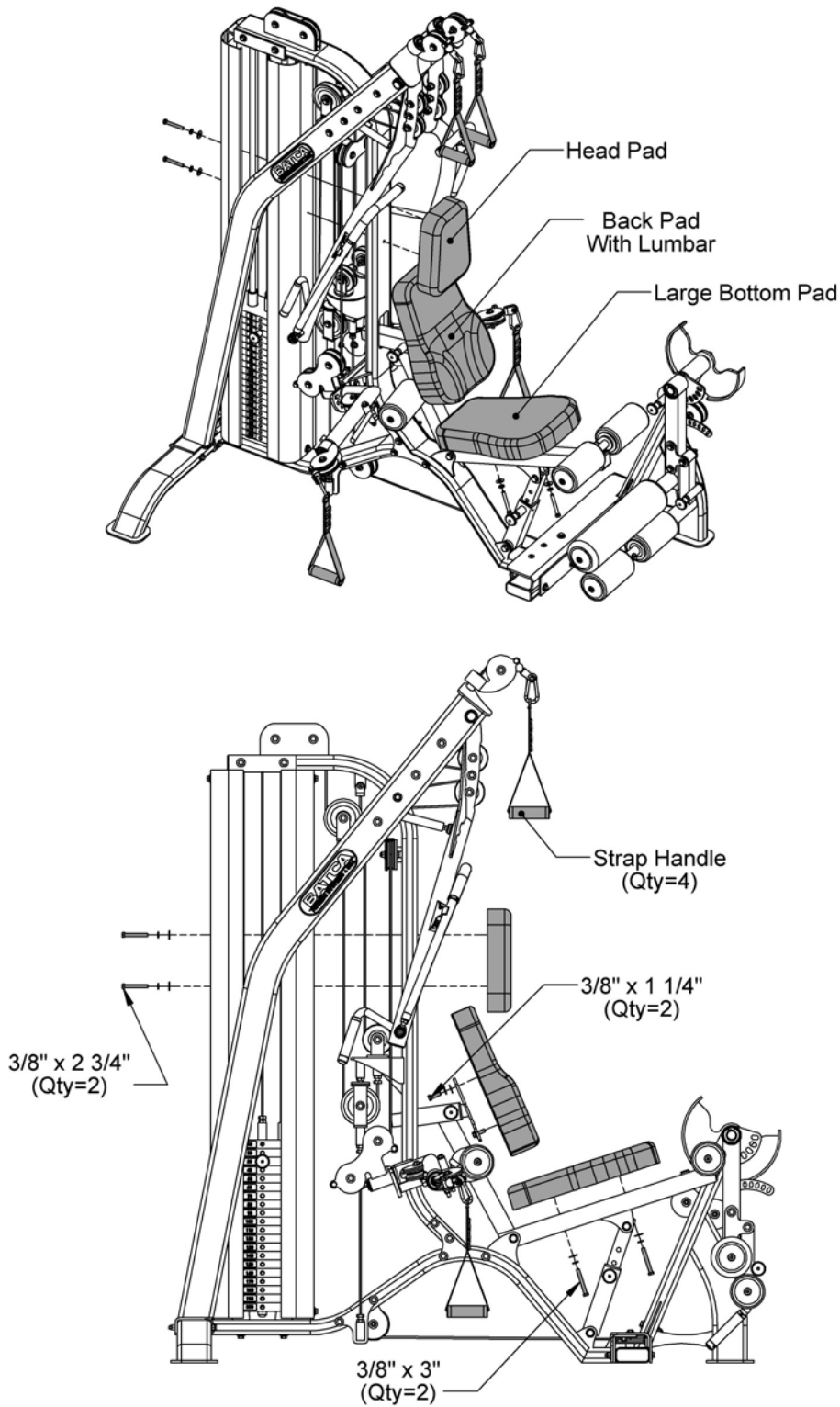


Figure 17

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

Item #	Part #	Description	Qty
11	BFU-10119	Head Pad	1
31	BFU-10117	Large Bottom Pad	1
32	BFU-10120	Back Pad With Lumbar	1
56	BFH-50146	3/8" Flat Washer (Black)	6
60	BFH-50147	3/8" Lock Washer (Black)	6
61	BFH-50119	HCS 3/8"-16 x 1 1/4" P5	2
62	BFH-50124	HCS 3/8"-16 X 2 3/4" P5	2
63	BFH-50125	HCS 3/8"-16 X 3" P5	2
156	BFC-10103	Strap Handle	4

# Leg Press Option

## Step 18:

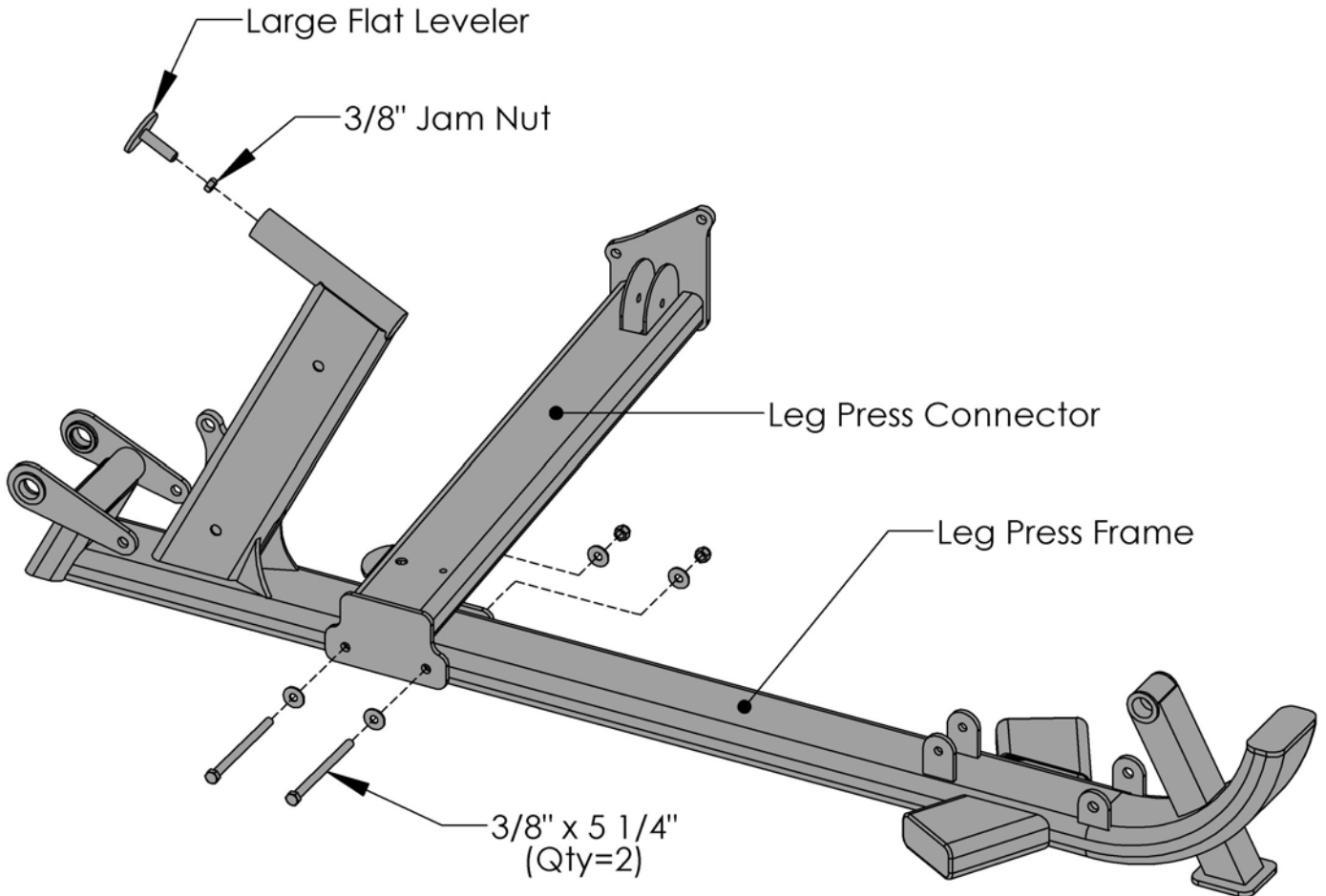


Figure 18

Item #	Part #	Description	Qty
157	BFM-10605	Leg Press Frame	1
158	BFM-10575	Leg Press Connector	1
56	BFH-50146	3/8" Flat Washer (Black)	4
59	BFH-50270	HCS 3/8"-16 X 5 1/4" P5	2
99	BFH-50149	3/8"-16 Jam Nut (Zinc)	1
58	BFH-50157	3/8"-16 Nylock (Black)	2
181	BFH-50339	Large Flat Leveler	1

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

## Step 19:



Note: This step may be pre-assembled

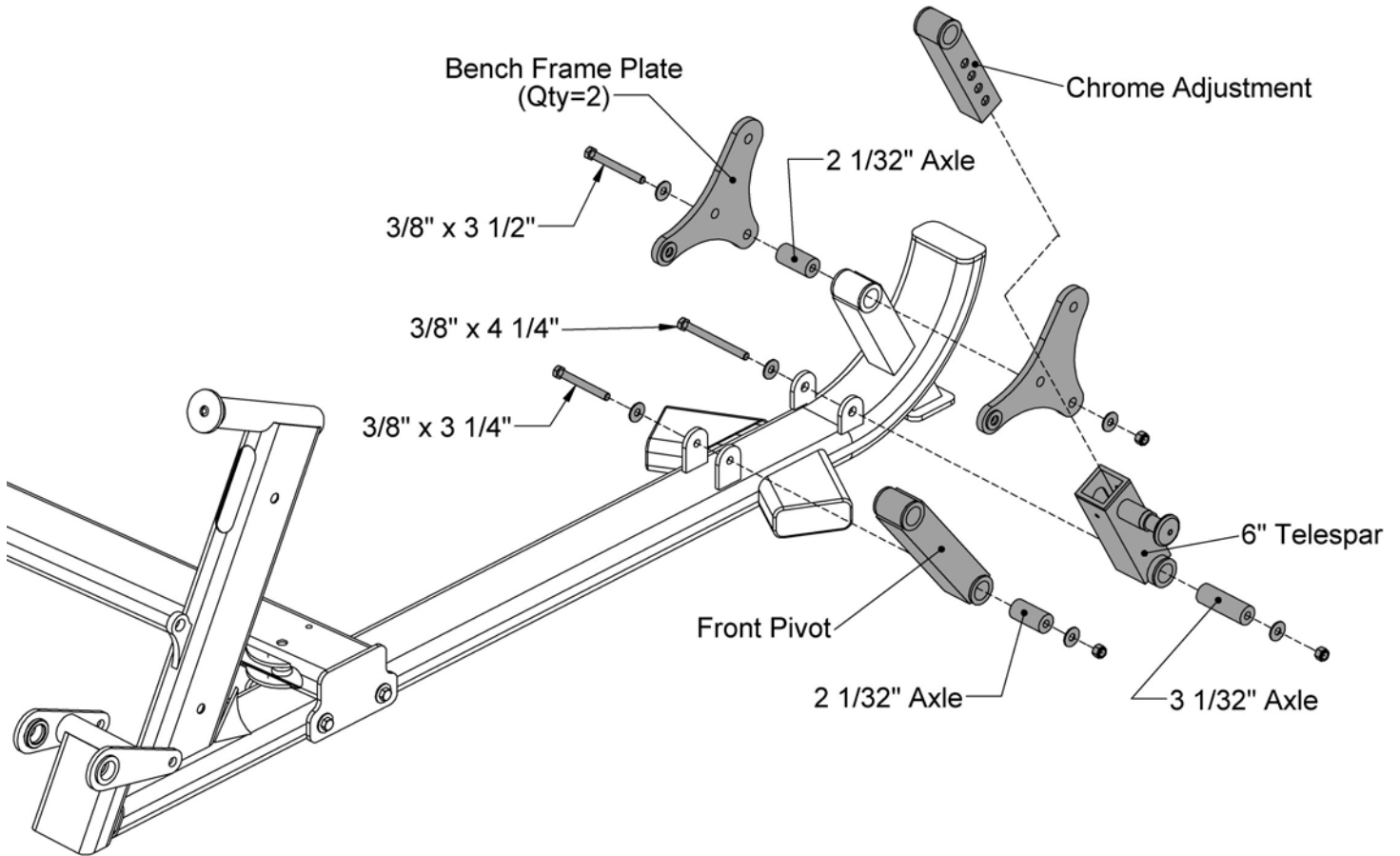


Figure 19

Item #	Part #	Description	Qty
160	BFM-51157	3 1/32" Axle	1
159	BFM-51155	2 1/32" Axle	2
161	BFM-10596	6" Telespar	1
162	BFL-50219	Bench Frame Plate	2
163	BFM-10595	Chrome Adjustment	1
180	BFM-51130	Front Pivot	1
56	BFH-50146	3/8" Flat Washer (Black)	6
82	BFH-50127	HCS 3/8"-16 X 3 1/2" P5	1
69	BFH-50126	HCS 3/8"-16 X 3 1/4" P5	1
83	BFH-50130	HCS 3/8"-16 X 4 1/4" P5	1
58	BFH-50157	3/8"-16 Nylock (Black)	3

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

## Step 20:



Note: This step may be pre-assembled

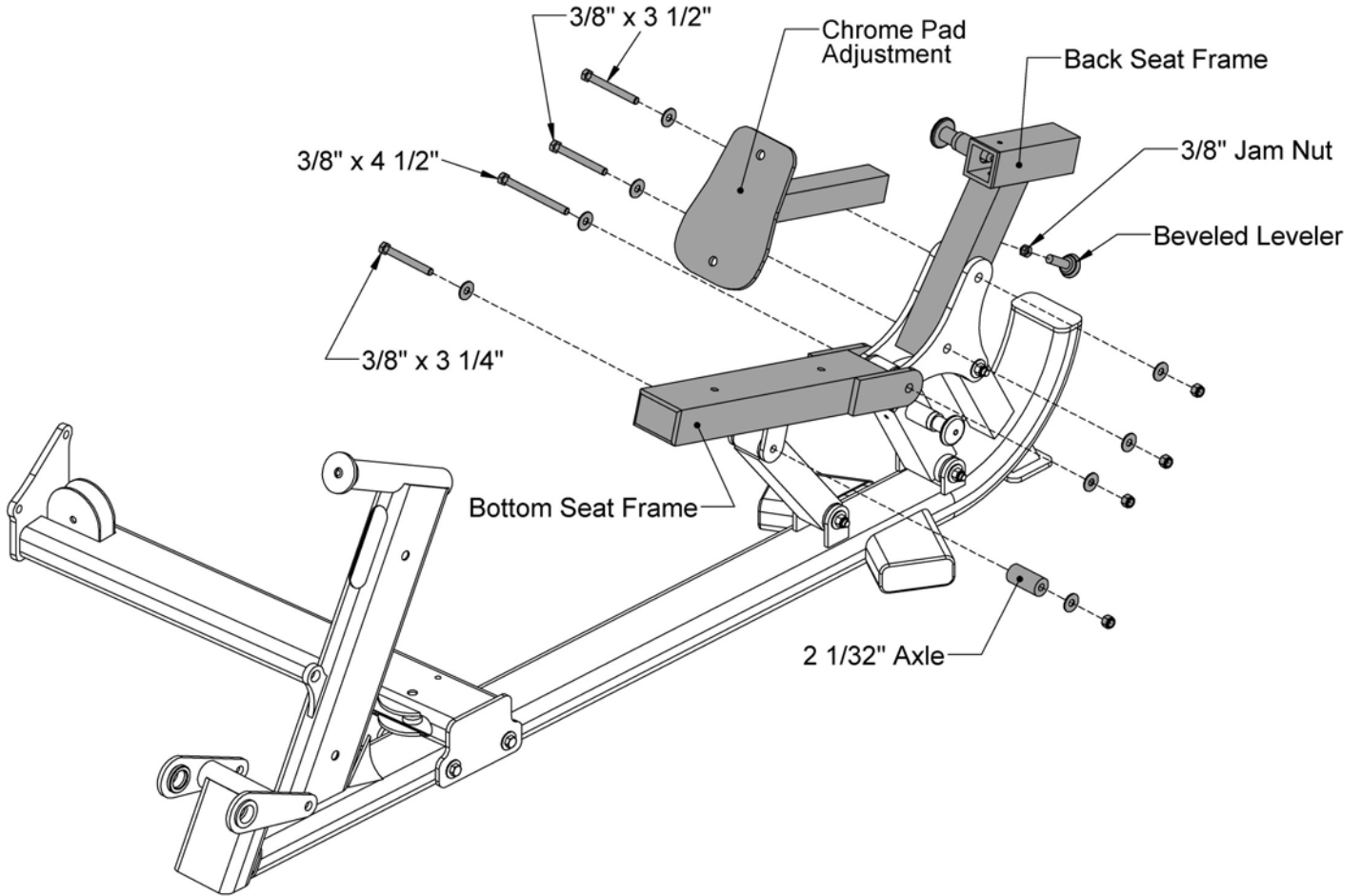


Figure 20

Item #	Part #	Description	Qty
159	BFM-51155	2 1/32" Axle	1
164	BFM-10598	Bottom Seat Frame	1
165	BFM-10106	Chrome Pad Adjustment	1
166	BFM-10597	Back Seat Frame	1
56	BFH-50146	3/8" Flat Washer (Black)	8
82	BFH-50127	HCS 3/8"-16 X 3 1/2" P5	2
84	BFH-50131	HCS 3/8"-16 X 4 1/2" P5	1
69	BFH-50126	HCS 3/8"-16 X 3 1/4" P5	1
99	BFH-50149	3/8"-16 Jam Nut (Zinc)	1
98	BFH-50253	Beveled Leveler	1
58	BFH-50157	3/8"-16 Nylock (Black)	4

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

# Step 21

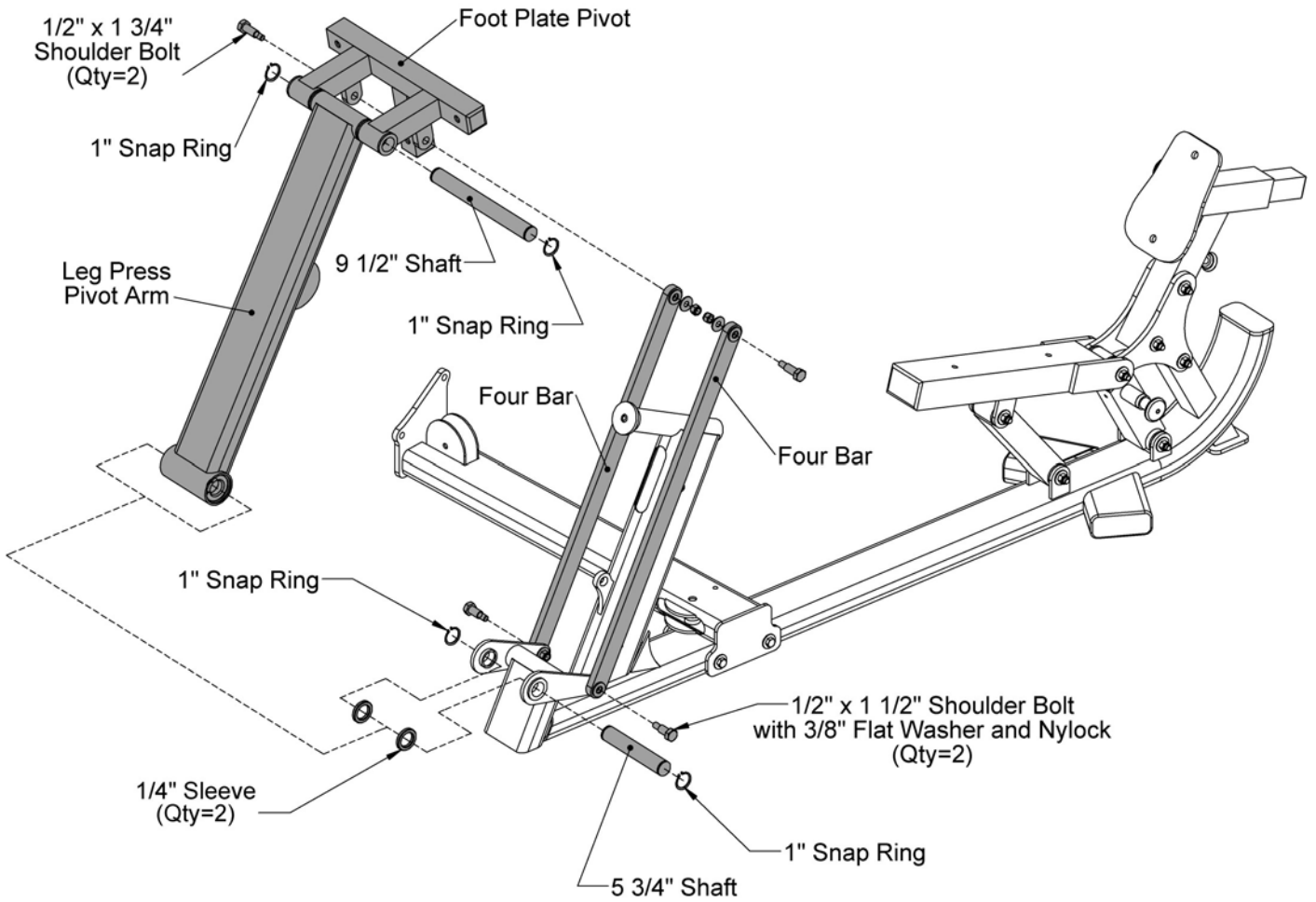


Figure 21

Item #	Part #	Description	Qty
167	BFM-10591	Leg Press Pivot Arm	1
168	BFM-51150	5 3/4" Shaft	1
169	BFM-10590	Foot Plate Pivot	1
170	BFM-50252	Four Bar	2
171	BFM-51149	9 1/2" Shaft	1
188	BFH-50338	1/4" Sleeve	2
56	BFH-50146	3/8" Flat Washer (Black)	4
89	BFH-50610	1/2" x 1 1/2" Shoulder Bolt	2
90	BFH-50249	1/2" x 1 3/4" Shoulder Bolt	2
58	BFH-50157	3/8"-16 Nylock (Black)	4
55	BFH-50165	1" Snap Ring	4

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

**Step 22:**

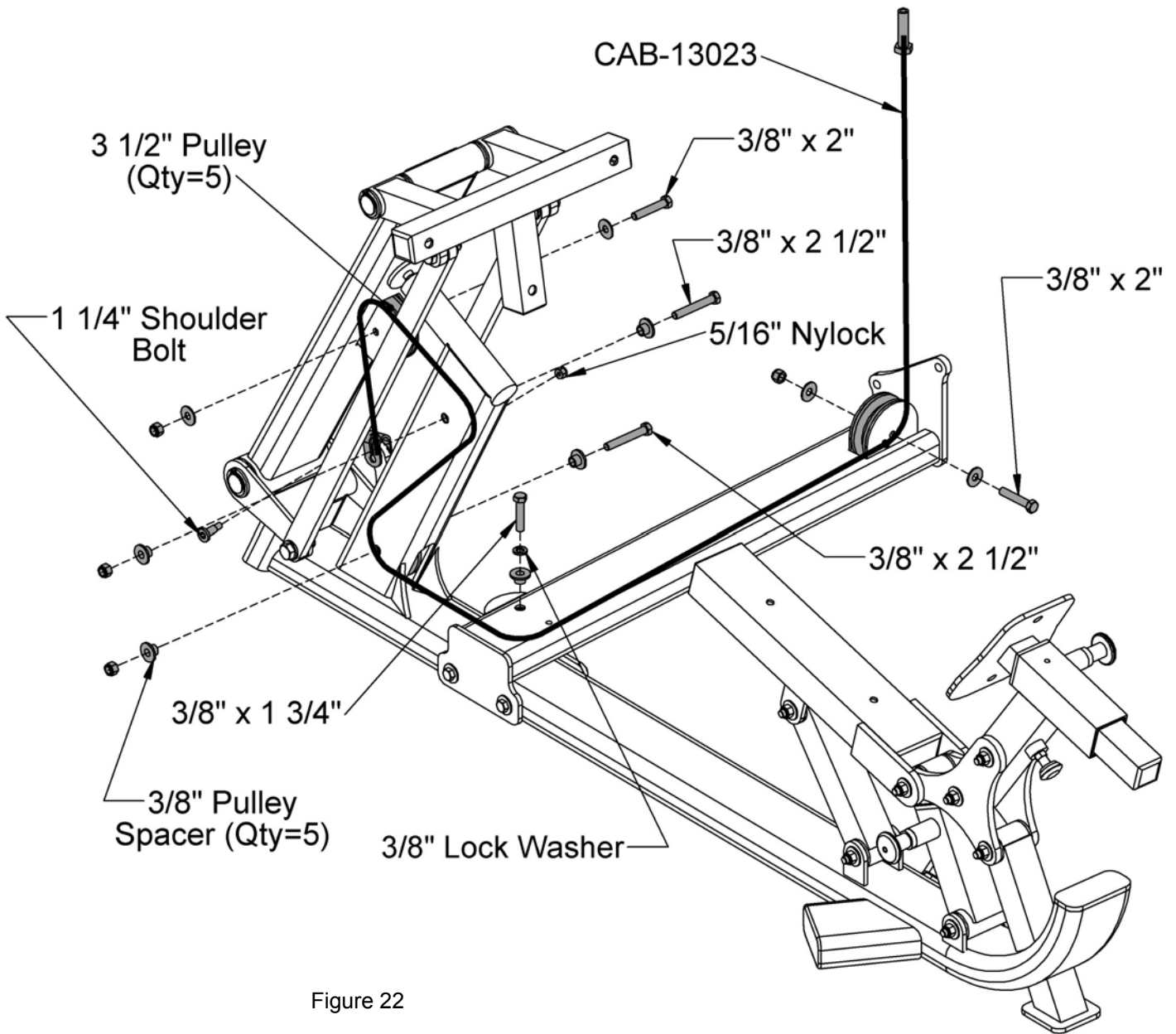
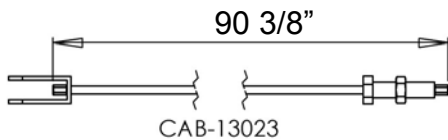


Figure 22



Item #	Part #	Description	Qty
56	BFH-50146	3/8" Flat Washer (Black)	4
60	BFH-50147	3/8" Lock Washer (Black)	1
75	BFH-50605	3/8" Pulley Spacer	5
76	BFH-50123	HCS 3/8"-16 X 2 1/2" P5	2
73	BFH-50285	HCS 3/8"-16 1 3/4" P5	1
70	BFH-50121	HCS 3/8"-16 X 2" P5	2
58	BFH-50157	3/8"-16 Nylock (Black)	4
8	BFH-50173	3 1/2" Pulley	5
102	CAB-13023	Fusion Leg Press Cable	1
113	BFH-50250	1 1/4" Shoulder Bolt	1
114	BFH-50267	5/16"-18 Nylock (Black)	1

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



**Step 23:**

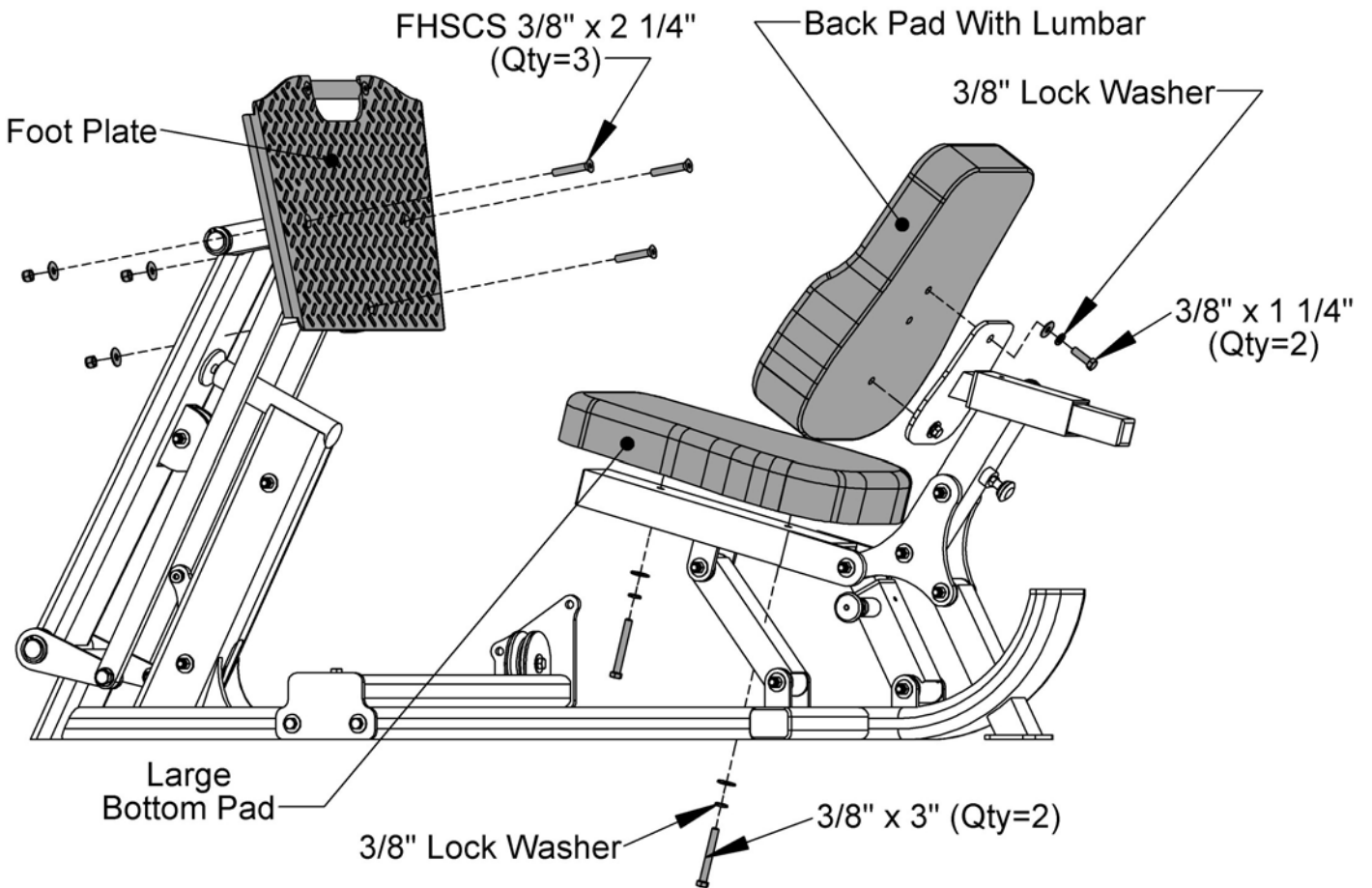
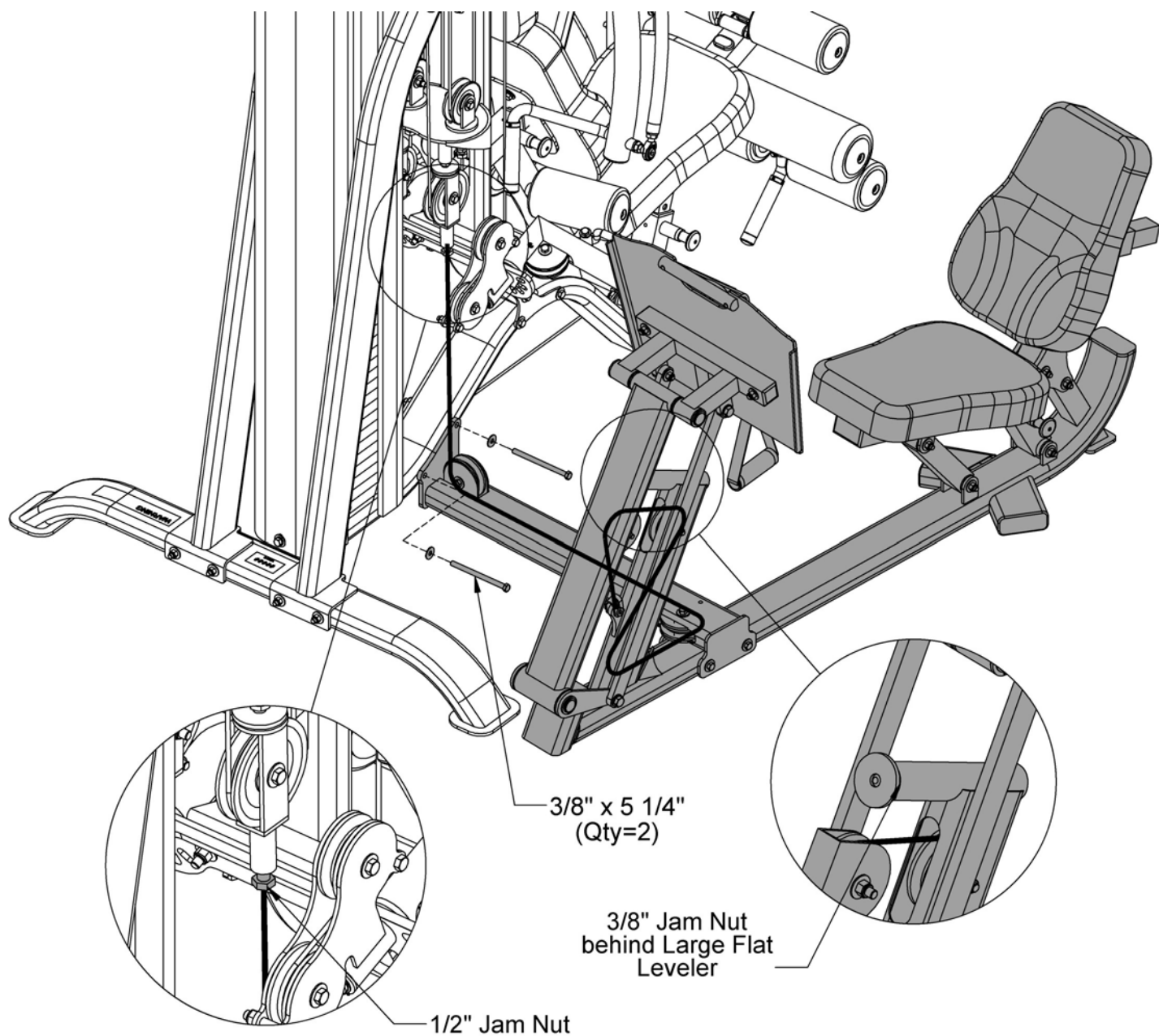


Figure 23

Item #	Part #	Description	Qty
172	BFL-50128	Foot Plate	1
173	BFU-10117	Large Bottom Pad	1
174	BFU-10120	Back Pad With Lumbar	1
56	BFH-50146	3/8" Flat Washer (Black)	4
60	BFH-50147	3/8" Lock Washer (Black)	4
61	BFH-50119	HCS 3/8"-16 X 1 1/4" P5	2
63	BFH-50125	HCS 3/8"-16 X 3" P5	2
85	BFH-50145	FHSCS 3/8"-16 X 2 1/4"	3
58	BFH-50157	3/8"-16 Nylock (Black)	3

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

## Step 24:



Note: Each Cable with a threaded bolt on either end **must be threaded at least 1/2"** into its attachment.

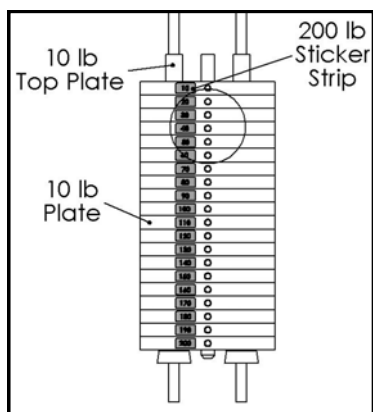
Figure 24

Item #	Part #	Description	Qty
56	BFH-50146	3/8" Flat Washer (Black)	4
58	BFH-50157	3/8"-16 Nylock (Black)	2
59	BFH-50270	HCS 3/8"-16 X 5 1/4" P5	2
92	BFH-50256	1/2" Jam Nut	1
99	BFH-50149	3/8"-16 Jam Nut	1

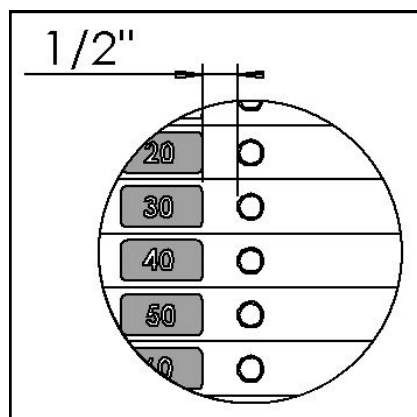
All Flat Washers and Nylocks are 3/8" unless otherwise noted.

## Step 25:

### Weight Stack Decals:



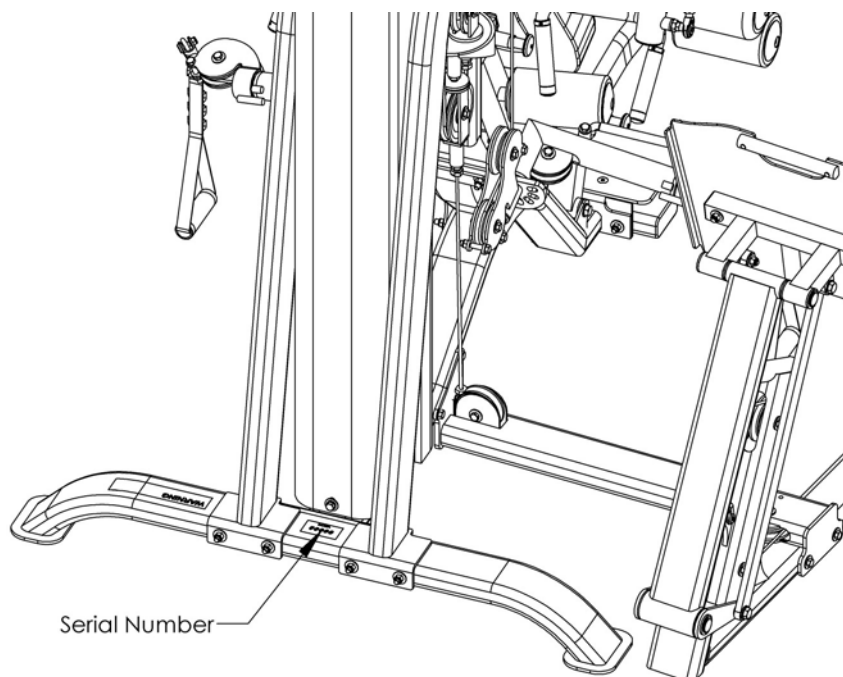
200lb Stack (Standard)



### 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.

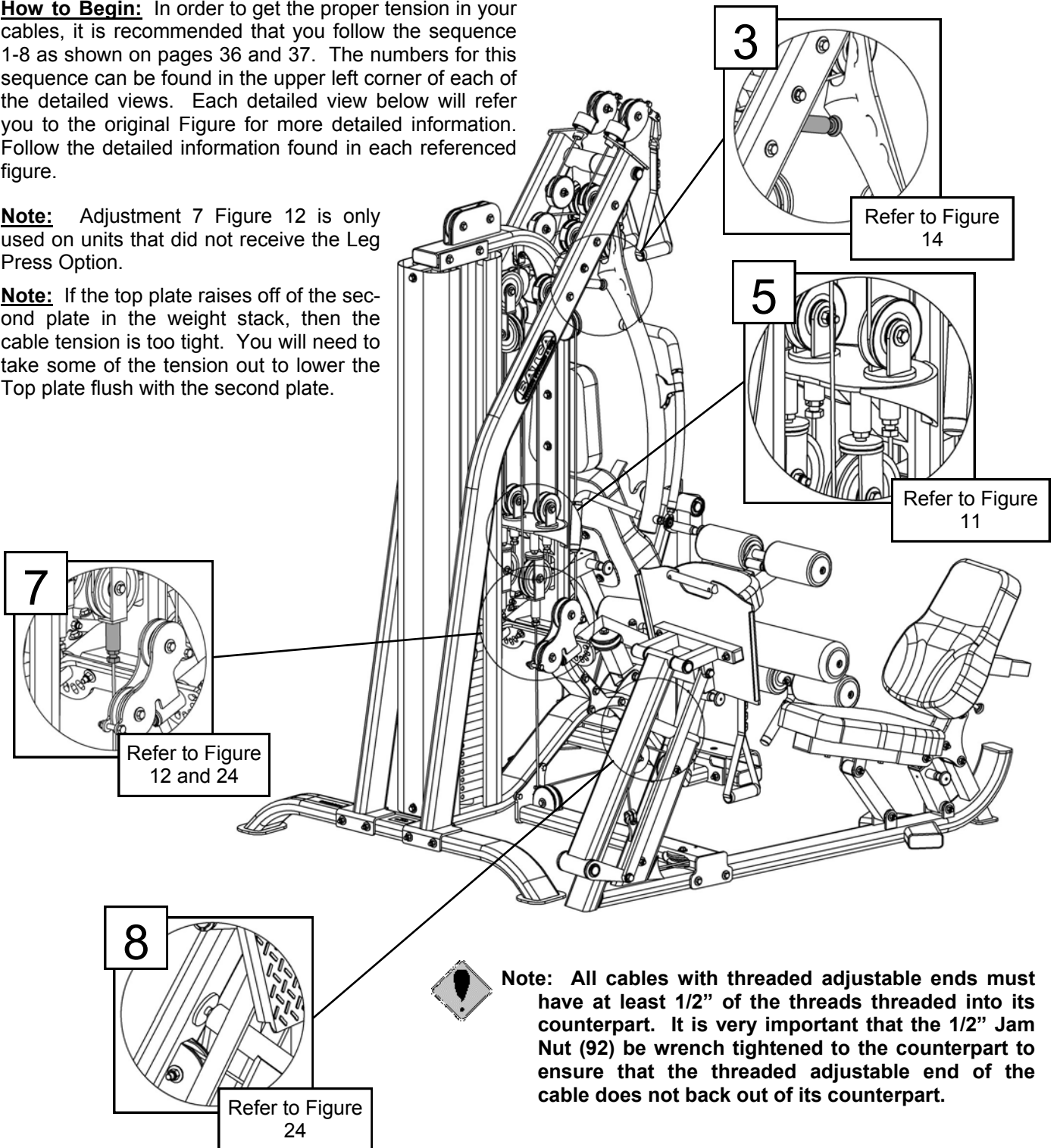
### Serial Number:



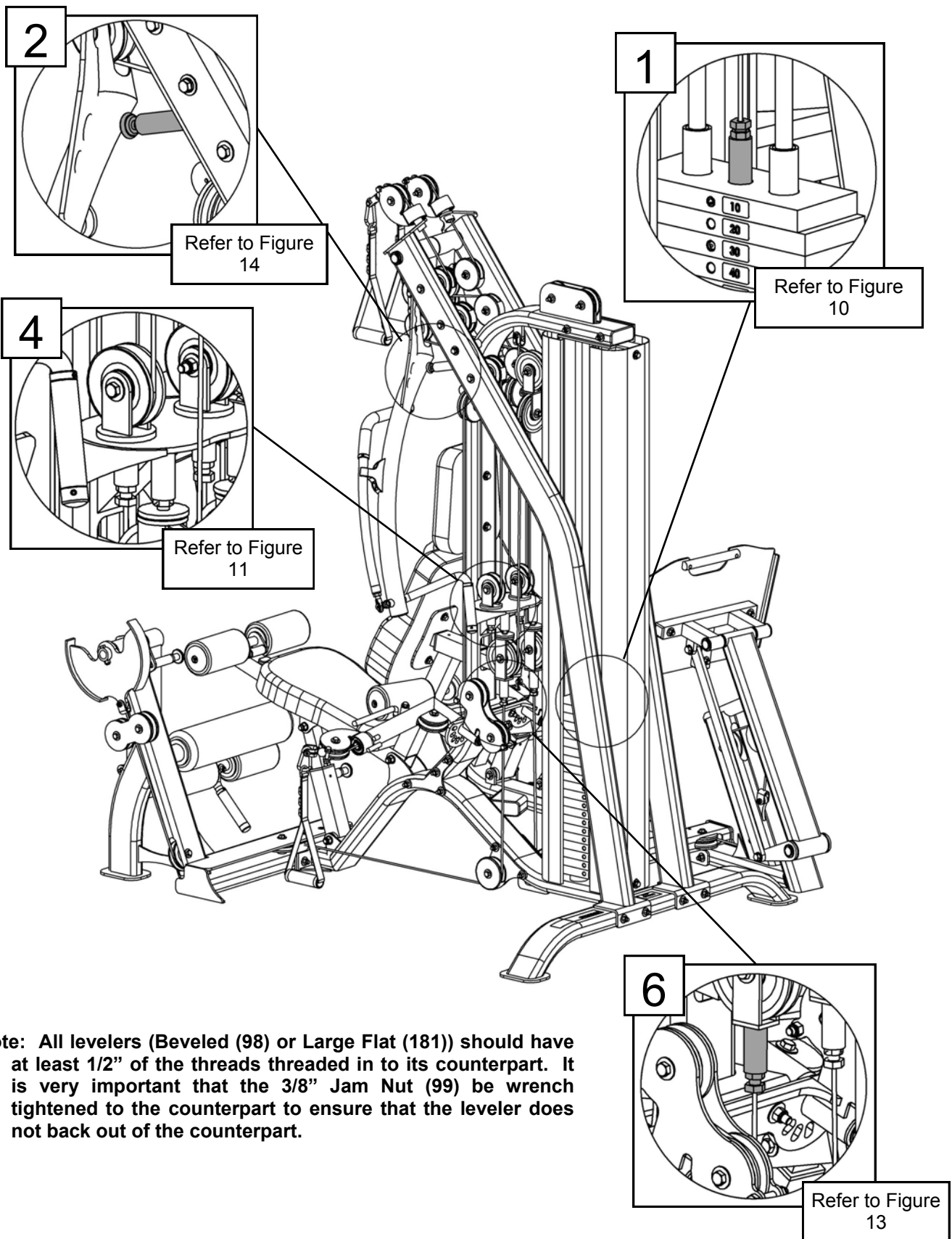
- **Record** your serial number on the front of this manual and keep for your records. The serial number can be found on the back of the cage as seen in the figure.

# 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 1-8 as shown on pages 36 and 37. 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:** Adjustment 7 Figure 12 is only used on units that did not receive the Leg Press Option.
- **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.



**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 (92) be wrench tightened to the counterpart to ensure that the threaded adjustable end of the cable does not back out of its counterpart.



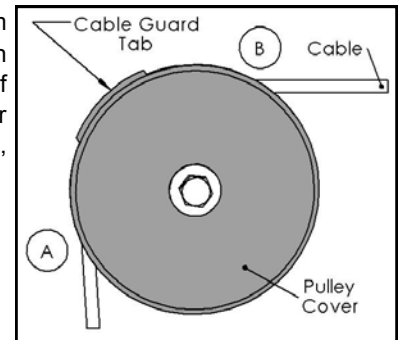
**Note:** All levelers (Beveled (98) or Large Flat (181)) should have at least 1/2" of the threads threaded in to its counterpart. It is very important that the 3/8" Jam Nut (99) be wrench tightened to the counterpart to ensure that the leveler does not back out of the counterpart.

# Final Assembly and Troubleshooting

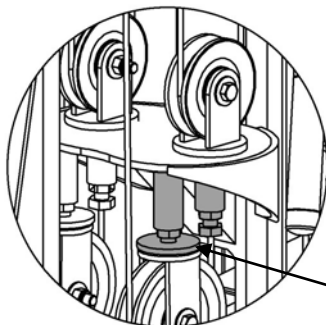
## IMPORTANT - Check These Components Before Using Gym:

- **Position** the cable guard tab on the Pulley Cover so that the tab prevents the cable from coming out of its 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 13, 14, and 15.

Pulley Cover  
BFM-50345

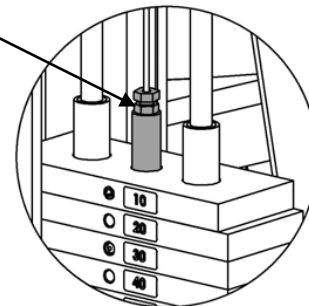


- Each Cable with a threaded bolt on either end **must be threaded at least 1/2"** into its attachment, whether it be a Free Floater, Lockout Free Floater, or the Top Plate of the weight stack. Each must also be secured with a 1/2" Jam Nut to ensure a safe and proper connection. Refer to Steps 11, 12, 13, and 24. See Figures below.



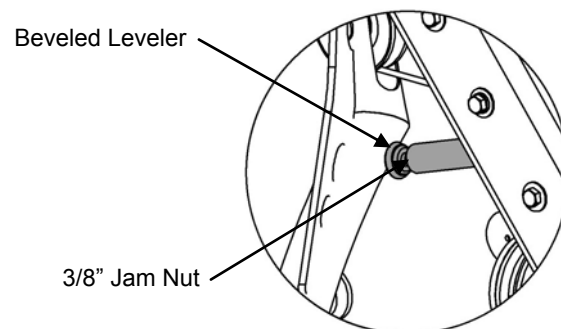
Free Floater w/ Lockout

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 2, 18, and 20. See Figures below.



# 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, 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.

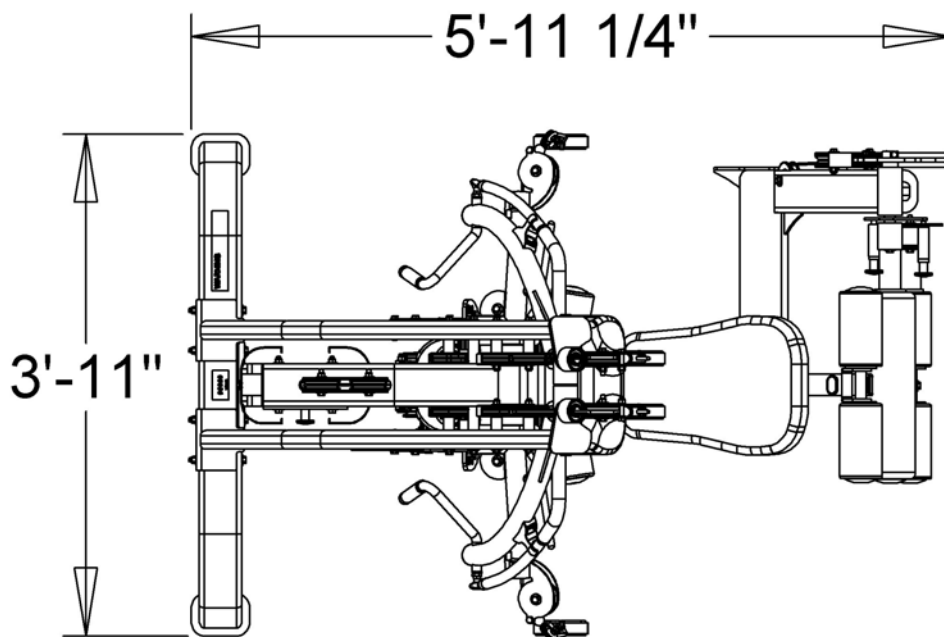
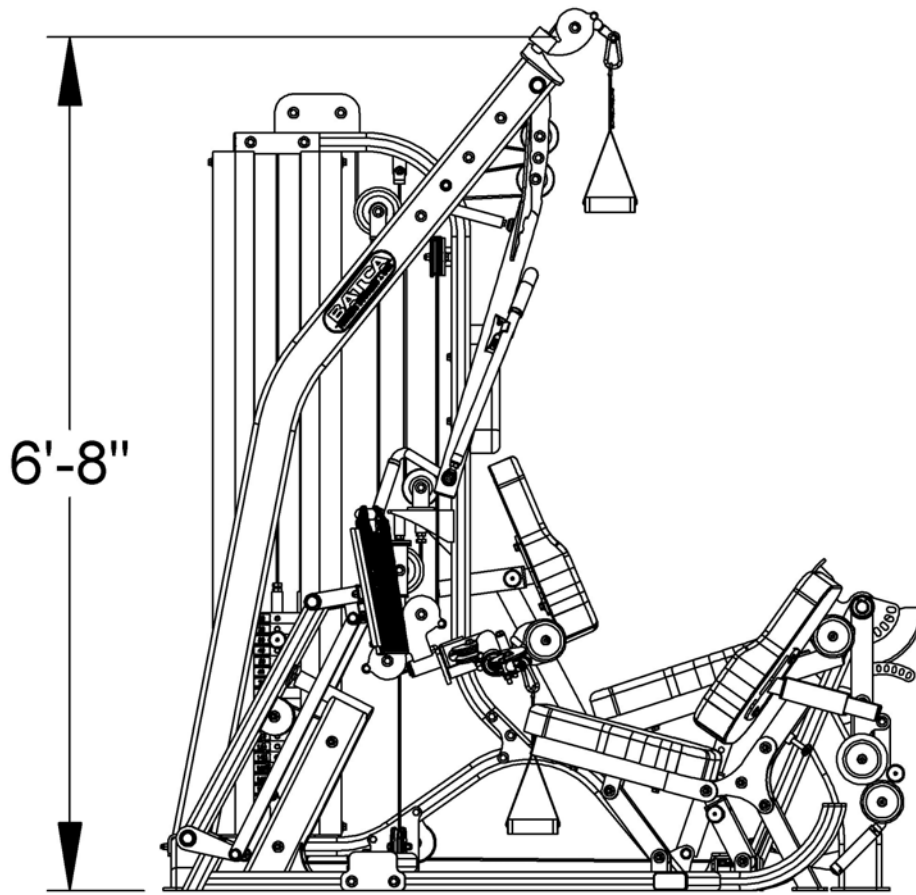
This warranty applies only to the original purchaser and is not transferable. Claims under this warranty must be made directly to Batca Fitness Systems.

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

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

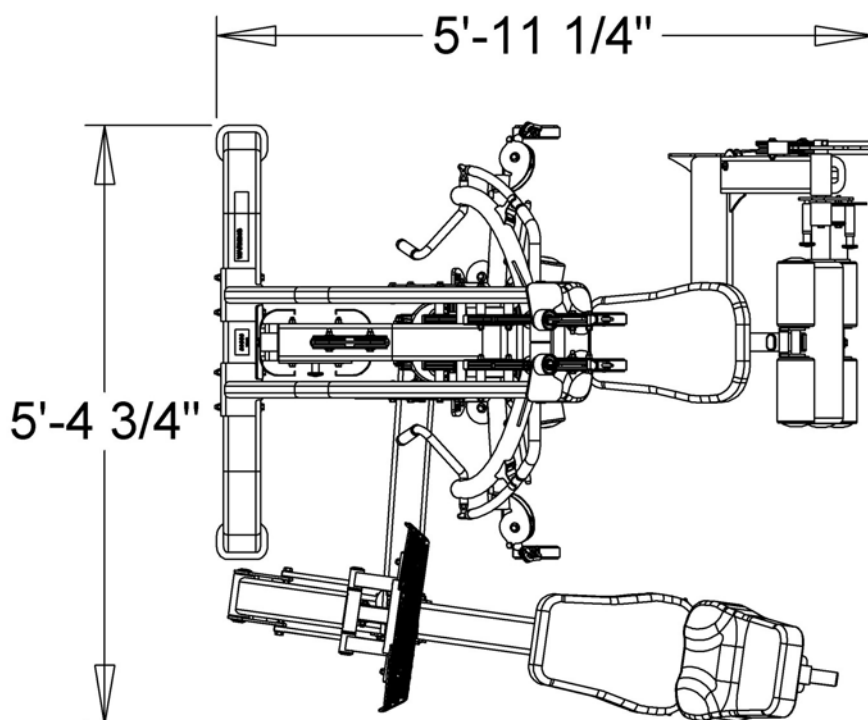
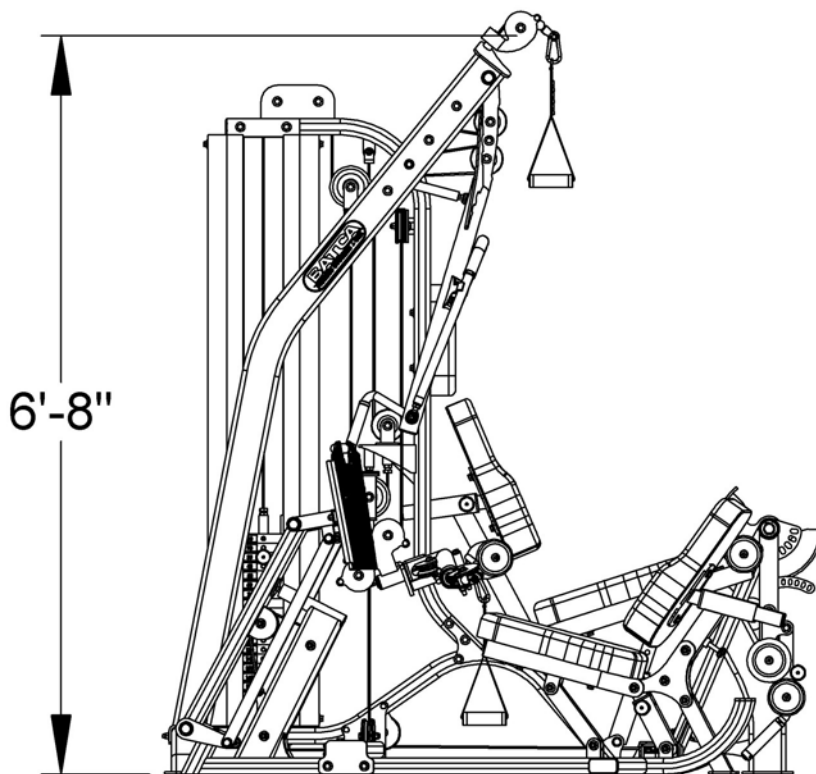
Please keep this for your records.





## Layout Diagram without Leg Press

The Fusion without Leg Press has a layout dimension of 3'-11" (width) x 5'-11 1/4" (length) x 6'-11" (height). There should be a minimum of 18", preferably 24", of working space around the entire unit.



## Layout Diagram with Leg Press

The Fusion with Leg Press has a layout dimension of 5'-5" (width) x 5'-11 1/4" (length) x 6'-11" (height). There should be a minimum of 18", preferably 24", of working space around the entire unit.