



# FUSION 3

PERSONAL GYM

Revision 8  
JULY 2020

## Owner's Manual



Serial Number Here

Date of Purchase



# Instructions

Congratulations on the purchase of your new Batca Fusion 3 Personal Gym. 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

## Table of Contents

	<u>Page</u>		<u>Page</u>
Instructions	2	Leg Press Attachment	30
Hardware Blister Packs	3-6	Cable Tension and Adjustments	31-32
Main Frame Assembly	7-16	Weight Stack Decals and Serial Number	33
Cable Routing	17-21	Final Assembly and Troubleshooting	34
Upholstery	22-23	Maintenance	35
Leg Press Option	24-30	Warranty	36
Leg Press Cable Routing	28	Floor plan Layout	37-38

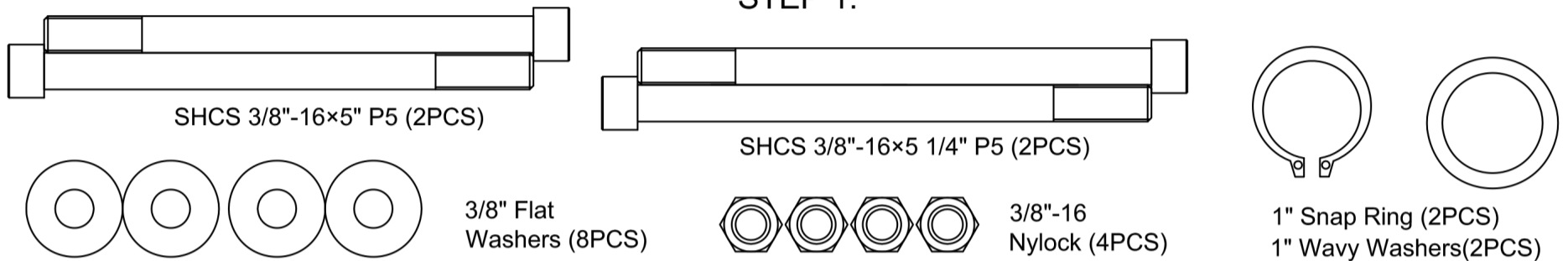
# Tools Required

- 9/16" Wrench/Ratchet
- 1/2" Wrench/Ratchet
- Metric Allen Wrench Set (M10, M8, M6, M4)
- Utility Knife
- 3/4" Wrench
- Tape Measure
- Snap Ring Pliers

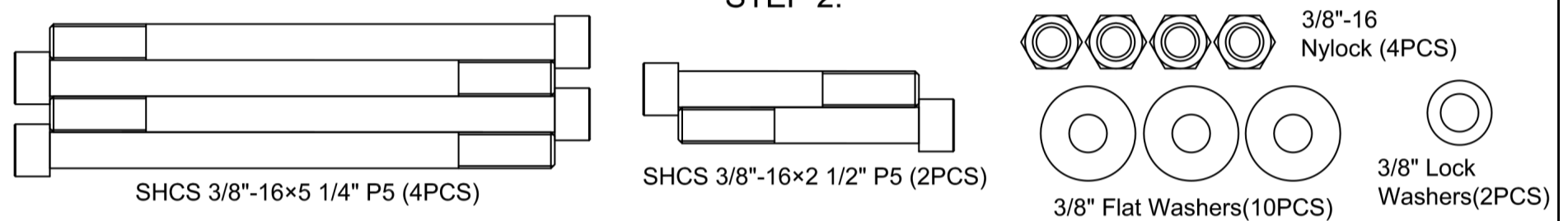
# Hardware Blister Packs

## Fusion 3 (5-1)

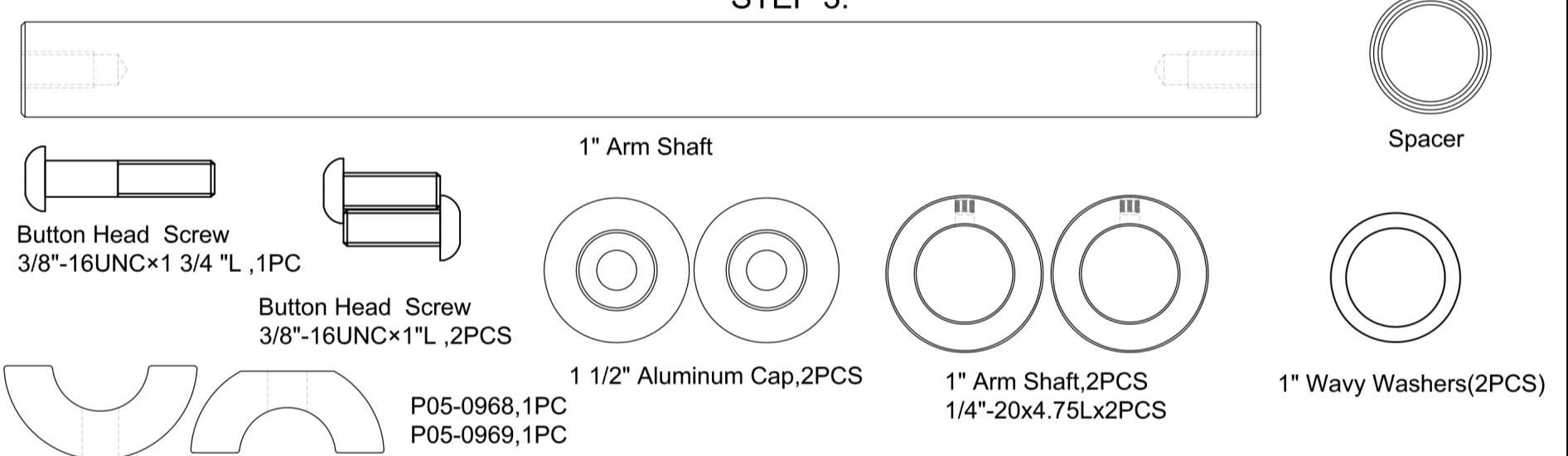
### STEP 1:



### STEP 2:



### STEP 3:



# Hardware Blister Packs

## Fusion 3 (5-2)

**STEP 5:**

SHCS 3/8"-16x5" P5 (2PCS)  
 FHSCS 3/8"-16x3/4" (2PCS)  
 SHCS 3/8"-16x3/4" (2PCS)  
 3/8" Lock Washers (Black) (6PCS)  
 Button Head Screw 3/8"-16x1/2" (4PCS)  
 M3 (1PC)  
 M5 (2PCS)  
 M6 (2PCS)  
 3/8"-16 Nylock (Black) (2PCS)  
 3/8" Flat Washers (Black) (10PCS)

**STEP 6:**

SHCS 3/8"x1 1/4" (2PCS)  
 3/8" Flat Washers (Black) (4PCS)  
 3/8"-16 Nylock (Black) (2PCS)

**STEP 7:**

SHCS 3/8"-16x5 1/2" P5 (2PCS)  
 3" Axle  
 SHCS 1/2"-13x4 1/4" P5 (1PC)  
 1/2" - 13 Nylock (Black) (1PCS)  
 1/2" Flat Washers (Black) (2PCS)  
 FHSCS 3/8"x1" (2PCS)  
 3/8" Flat Washers (Black) (6PCS)  
 3/8"-16 Nylock (Black) (4PCS)

**STEP 8:**

SHCS 1/2"-13x3" P5 (1PCS)  
 SHCS 1/2"-13x3 1/2" P5 (1PCS)  
 SHCS 3/8"-16x3" P5 (2PCS)  
 1/2" Flat Washers (Black) (4PCS)  
 3/8" Flat Washers (Black) (2PCS)  
 3/8" Lock Washers (Black) (2PCS)  
 1/2" - 13 Nylock (Black) (2PCS)

**STEP 9:**

FHSCS 5/16"-18x1" (2PCS)  
 SHCS 3/8"-16x2" P5 (1PCS)  
 1" Wavy Washers (Black)(2PCS)  
 3/8"-16 Nylock (Black) (1PCS)  
 M8  
 M10  
 2 9/16" Axle

## Fusion 3 (5-3)

**STEP 10:**

SHCS 3/8" x 3"L (3PCS)  
 1" Wavy Washers (Black) (1PCS)  
 1" Snap Ring (Black) (1PC)  
 2" Axle  
 3/8" Flat Washers (Black) (6PCS)  
 Red Pivot Point Cap, 1PC  
 3/8"-16 Nylock (Black) (3PCS)  
 Button Head Screw 3/8"-16UNCx1"L, 1PC

**STEP 11:**

SHCS 3/8"-16x2 1/4" P5 (3PCS)  
 3/8"-16 Nylock (Black) (3PCS)  
 5/16" x 1 1/4" Shoulder Bolt (1PC)  
 5/16"-18 Nylock(U.C.P) (1PC)  
 Cable Strap (1PC)  
 3/8" Flat Washers (Black) (6PCS)

**STEP 12:**

SHCS 3/8"-16x2 1/4"(3PCS)  
 3/8"-16 Nylock (Black) (3PCS)  
 3/8" Flat Washers (Black) (6PCS)

**STEP 13:**

SHCS 3/8"-16x5 1/4" P5 (2PCS)  
 3/8" Flat Washers(Black) (4PCS)  
 3/8"-16 Nylock (Black) (2PCS)

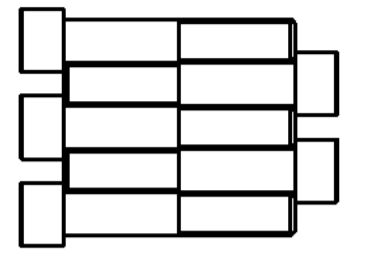
**STEP 14:**

SHCS 3/8"-16x2 1/2" P5 (1PCS)  
 SHCS 3/8"-16x2 1/4" P5 (1PCS)  
 SHCS 3/8"-16x2" P5 (2PCS)  
 Cable Strap (1PC)  
 5/16"-18 Nylock(U.C.P) (1PC)  
 5/16"x1 3/8" Shoulder Bolt (1PC)  
 SHCS 3/8"-16x1 3/4" P5 (1PCS)  
 3/8" Lock Washer (Black) (1PC)  
 3/8" Flat Washers (Black) (7PCS)  
 3/8" Pulley Spacer (1PC)  
 5/16" Pulley Spacer (1PC)  
 3/8"-16 Nylock (Black) (4PCS)

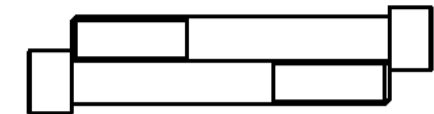
# Hardware Blister Packs

## Fusion 3 (5-4)

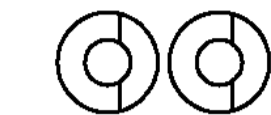
STEP 15:



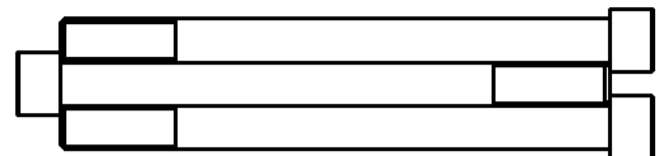
SHCS 3/8"-16x2" P5 (5PCS)



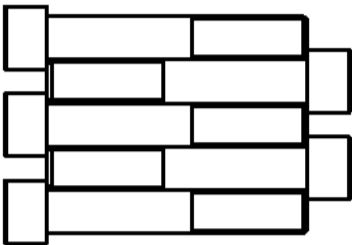
SHCS 3/8"-16x2 3/4" P5 (2PCS)



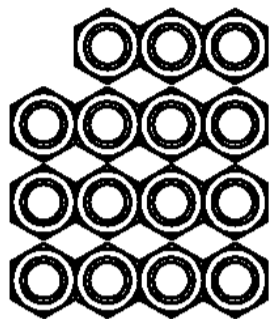
3/8" Curved Washers (2PCS)



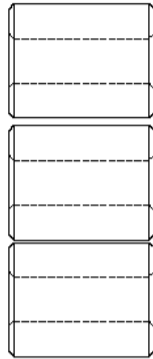
SHCS 3/8"-16x4 3/4" P5 (3PCS)



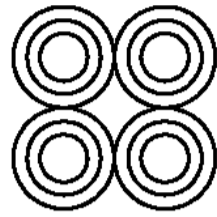
SHCS 3/8"-16x2 1/4" P5 (5PCS)



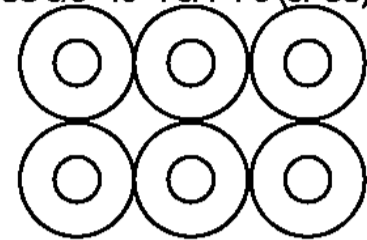
3/8" Lock Nut (15PCS)



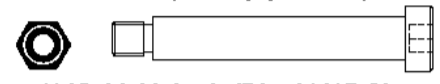
1 1/4" Spacer (3PCS)



1/2" Curved Pulley Spacer (4PCS)



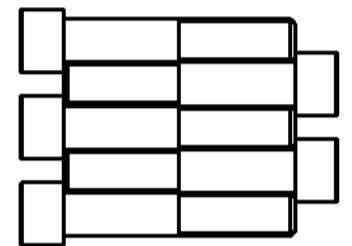
3/8" Flat Washers(Black) (18PCS)



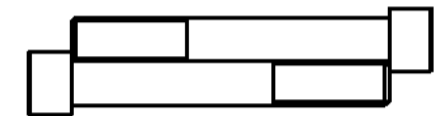
5/16"-18 Nylock (Black)(1PC)

5/16"x64.3L Shoulder Bolt (1PC)

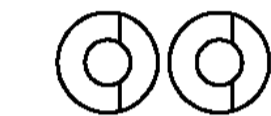
STEP 16:



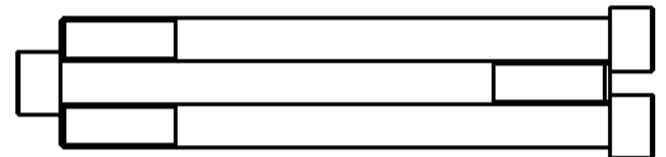
SHCS 3/8"-16x2" P5 (5PCS)



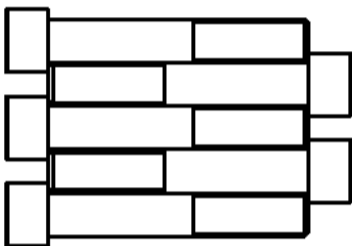
SHCS 3/8"-16x2 3/4" P5 (2PCS)



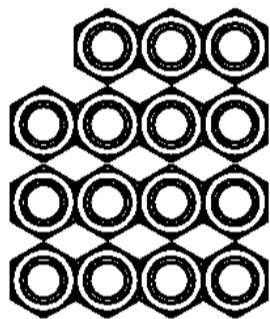
3/8" Curved Washers (2PCS)



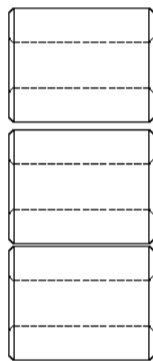
SHCS 3/8"-16x4 3/4" P5 (3PCS)



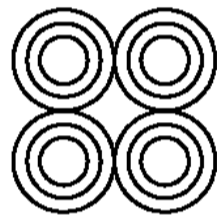
SHCS 3/8"-16x2 1/4" P5 (5PCS)



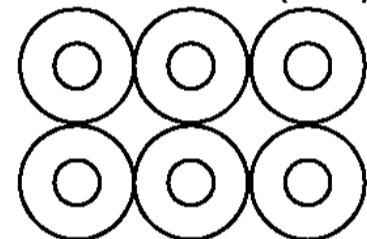
3/8" Lock Nut (15PCS)



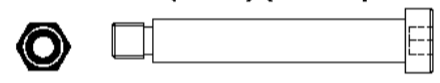
1 1/4" Spacer (3PCS)



1/2" Curved Pulley Spacer (4PCS)



3/8" Flat Washers(Black) (18PCS)

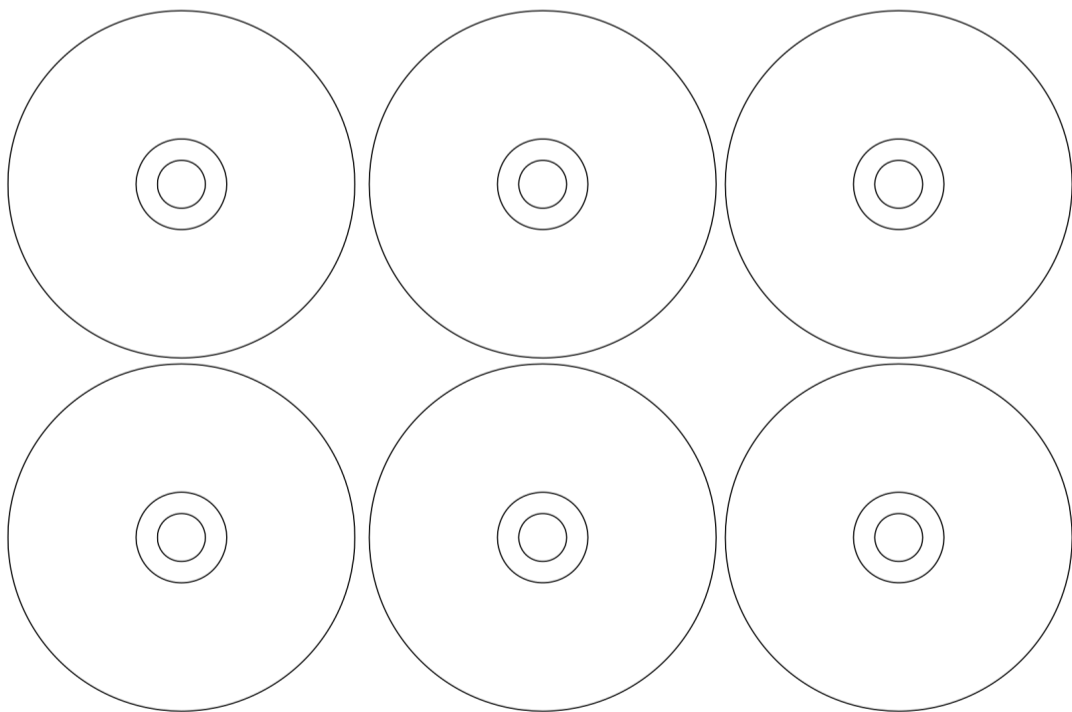


5/16"-18 Nylock (Black)(1PC)

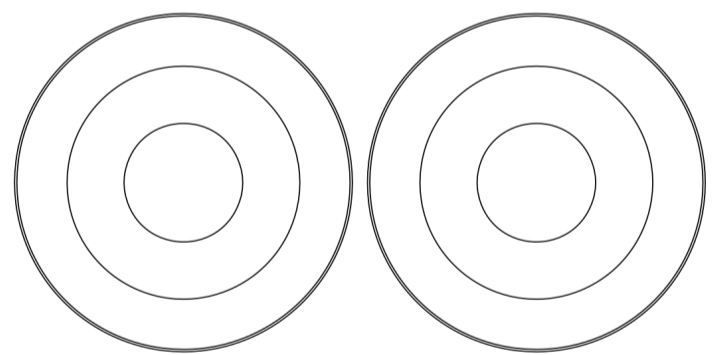
5/16"x64.3L Shoulder Bolt (1PC)

## Fusion 3 (5-5)

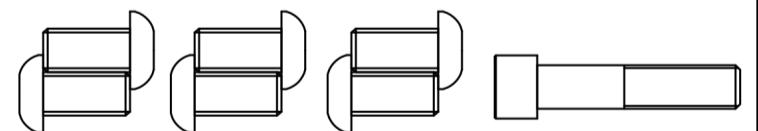
STEP 17:



Upholstery Cap,6PCS



3" Plastic Washer,4PCS

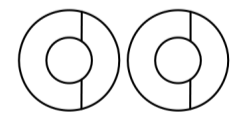


Button Head Screw  
3/8"-16UNCx3/4" L(6PCS)

SHCS 3/8" x 1 3/4" L (1PCS)



3/8"-16 Nylock  
(Black) (1PC)

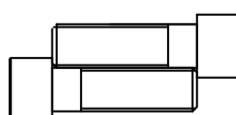


3/8" Curved Washers  
(Black) (2PCS)

STEP 18:



SHCS 3/8"-16x2 3/4" P5 (2PCS)



SHCS 3/8"-16x1 1/4" P5 (2PCS)



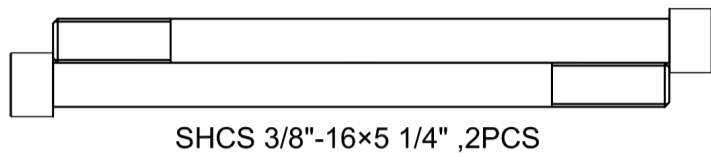
3/8" Flat Washers (Black) (4PCS)



3/8" Lock Washers  
(Black) (4PCS)

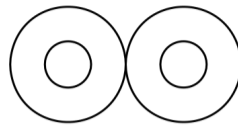
# Hardware Blister Packs

## Fusion leg press



SHCS 3/8"-16x5 1/4" ,2PCS

### STEP 19:

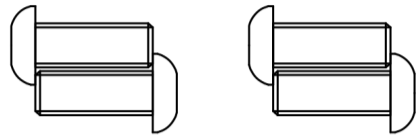
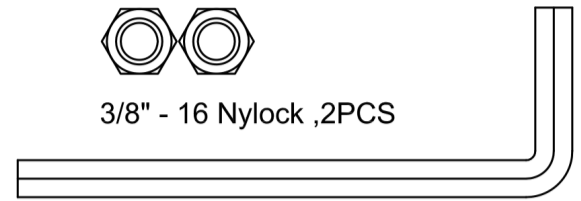


3/8" Flat Washers ,4PCS



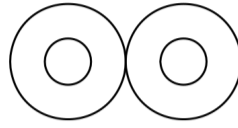
3/8" - 16 Nylock ,2PCS

M8



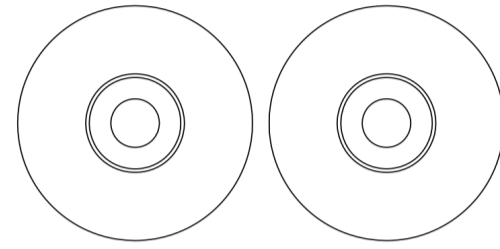
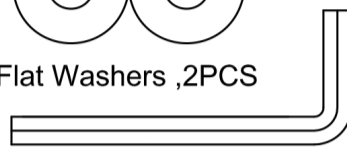
Button Head Screw  
3/8"-16UNCx1"L ,4PCS

### STEP 22:

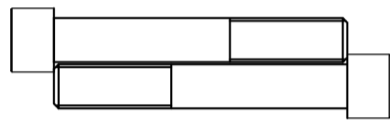


3/8" Flat Washers ,2PCS

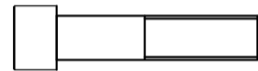
M6



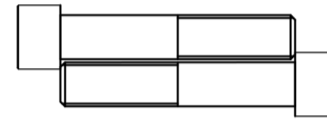
2" Aluminum Cap ,2PCS



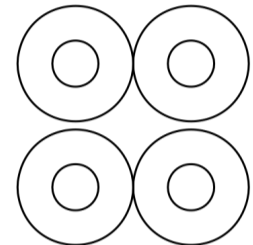
SHCS 3/8"-16x2 1/2" ,2PCS



SHCS 3/8"-16x1 3/4" ,1PC



SHCS 3/8"-16x2" ,2PCS



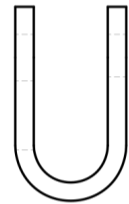
3/8" Flat Washers ,4PCS



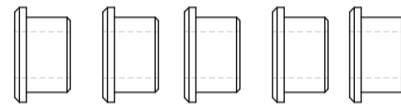
5/16"x1 3/8"  
Shoulder Bolt ,1PCS



5/16" - 18 Nylock ,1PCS



Cable Strap ,1PCS



3/8" Pulley Spacer ,5PCS

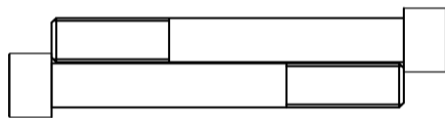


3/8" Lock Washers ,1PCS



3/8" - 16 Nylock ,4PCS

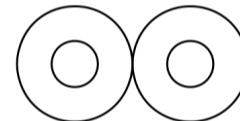
### STEP 24:



SHCS 3/8"-16x3" ,2PCS



SHCS 3/8"-16x1 1/4" ,2PCS



3/8" Flat Washers ,4PCS



3/8" Lock Washers ,4PCS

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

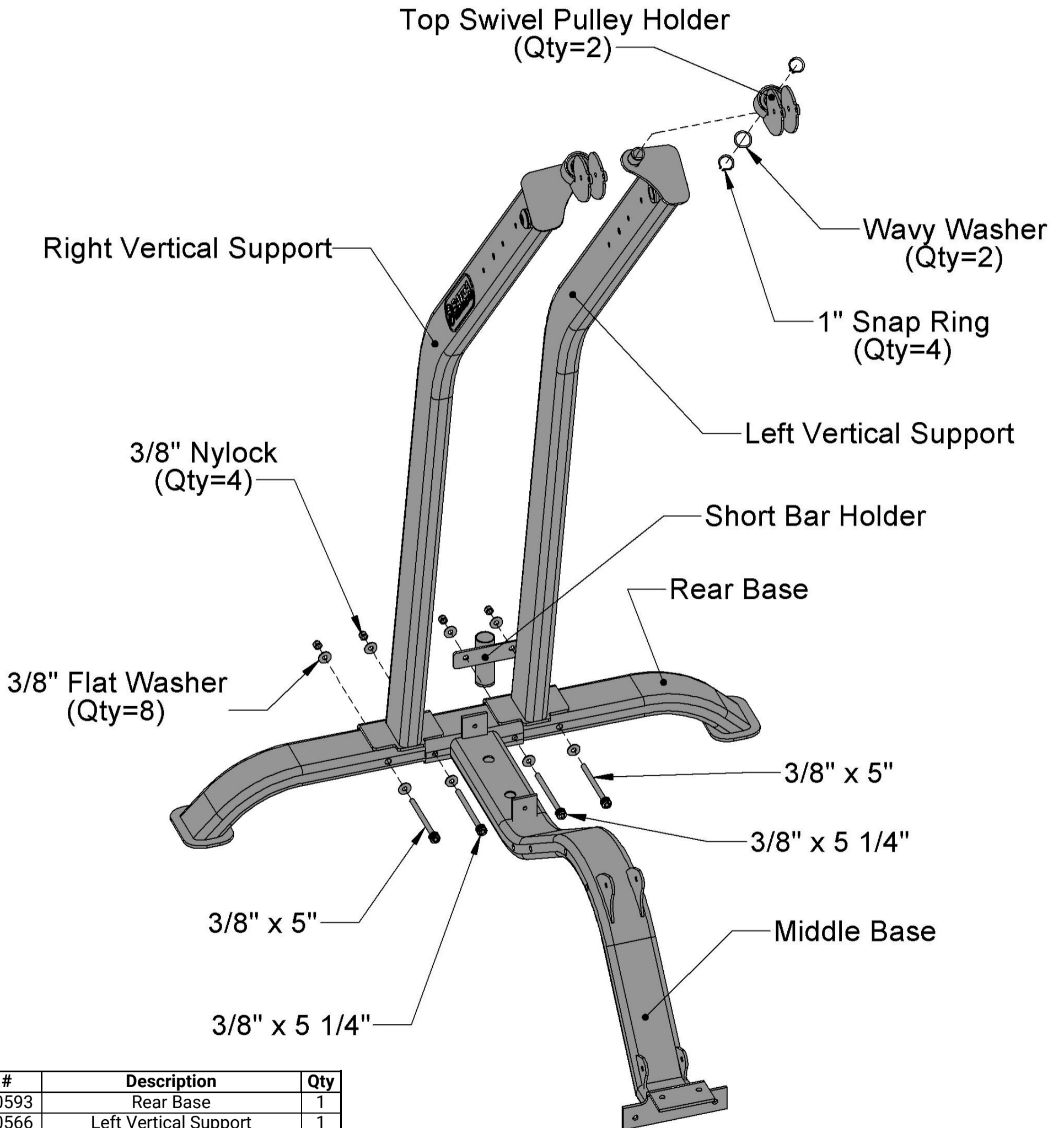


**Step 1:**

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

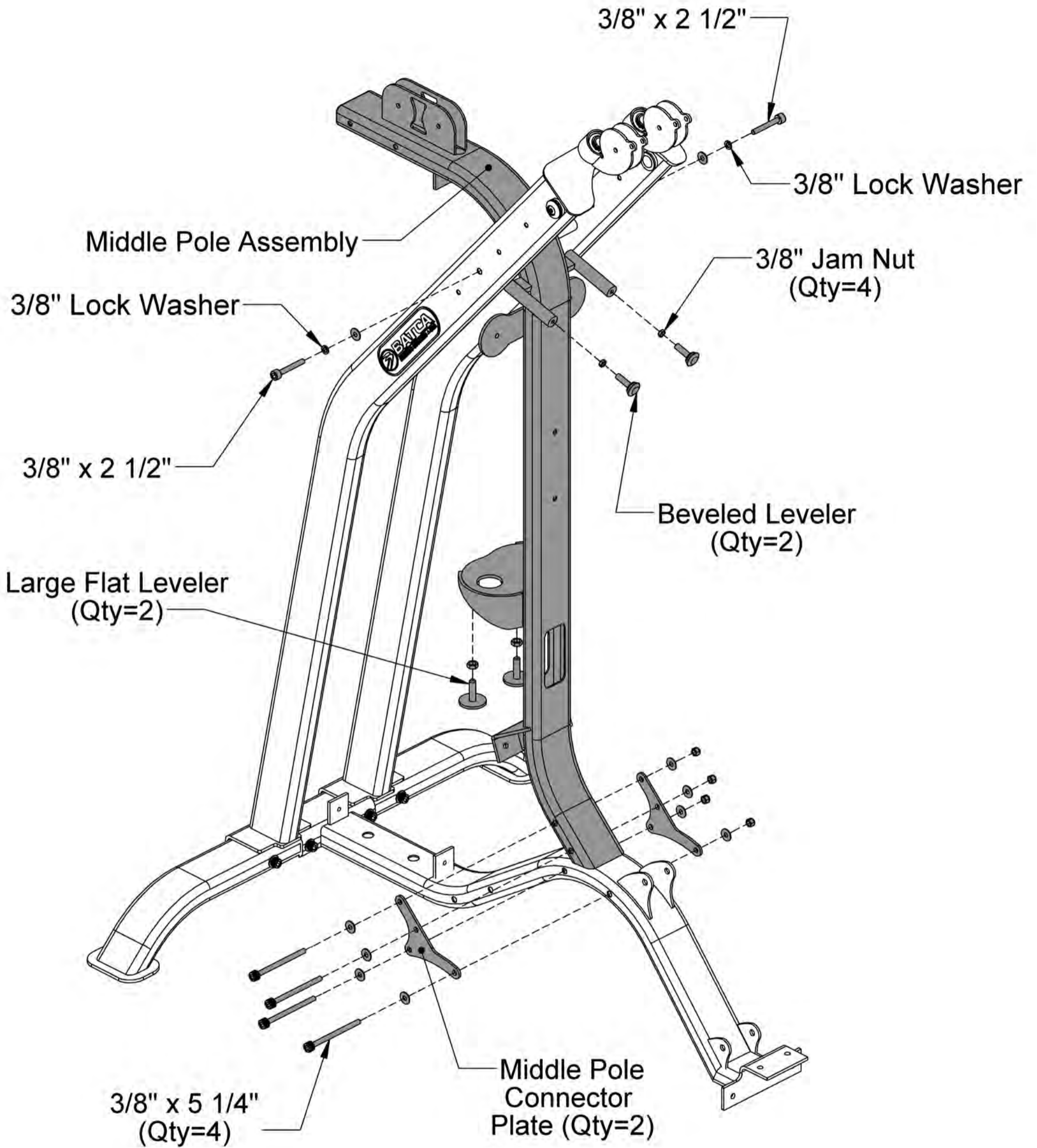
All Flat Washers and Nylocks are 3/8" unless otherwise noted. Anywhere a washer is against the round side of a tube there is to be a 3/8" **CURVED WASHER** instead of a 3/8" **FLAT WASHER**.

**DO NOT TIGHTEN BOLTS UNTIL STEP 4**



Part #	Description	Qty
BFM-10593	Rear Base	1
BFM-10566	Left Vertical Support	1
BFM-10567	Right Vertical Support	1
BFM-10568	Middle Base	1
BFM-10583	Top Swivel Pulley	2
BFH-50165	1" Snap Ring	4
BFH-50146	3/8" Flat Washer (Black)	8
BFH-50157	3/8"-16 Nylock (Black)	4
BFP-51756	SHCS 3/8"-16 X 5 1/4" P5	2
BFP-51799	SHCS 3/8"-16 X 5" P5	2
BFH-50337	Wavy Washer	2
BFM-11038	Short Bar Holder	1

**Step 2:**  **DO NOT TIGHTEN BOLTS UNTIL STEP 4**

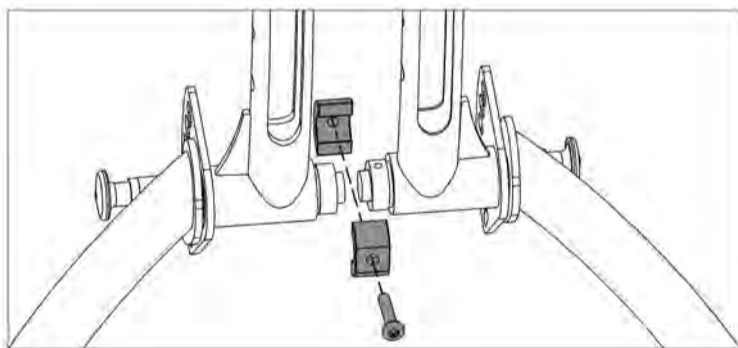
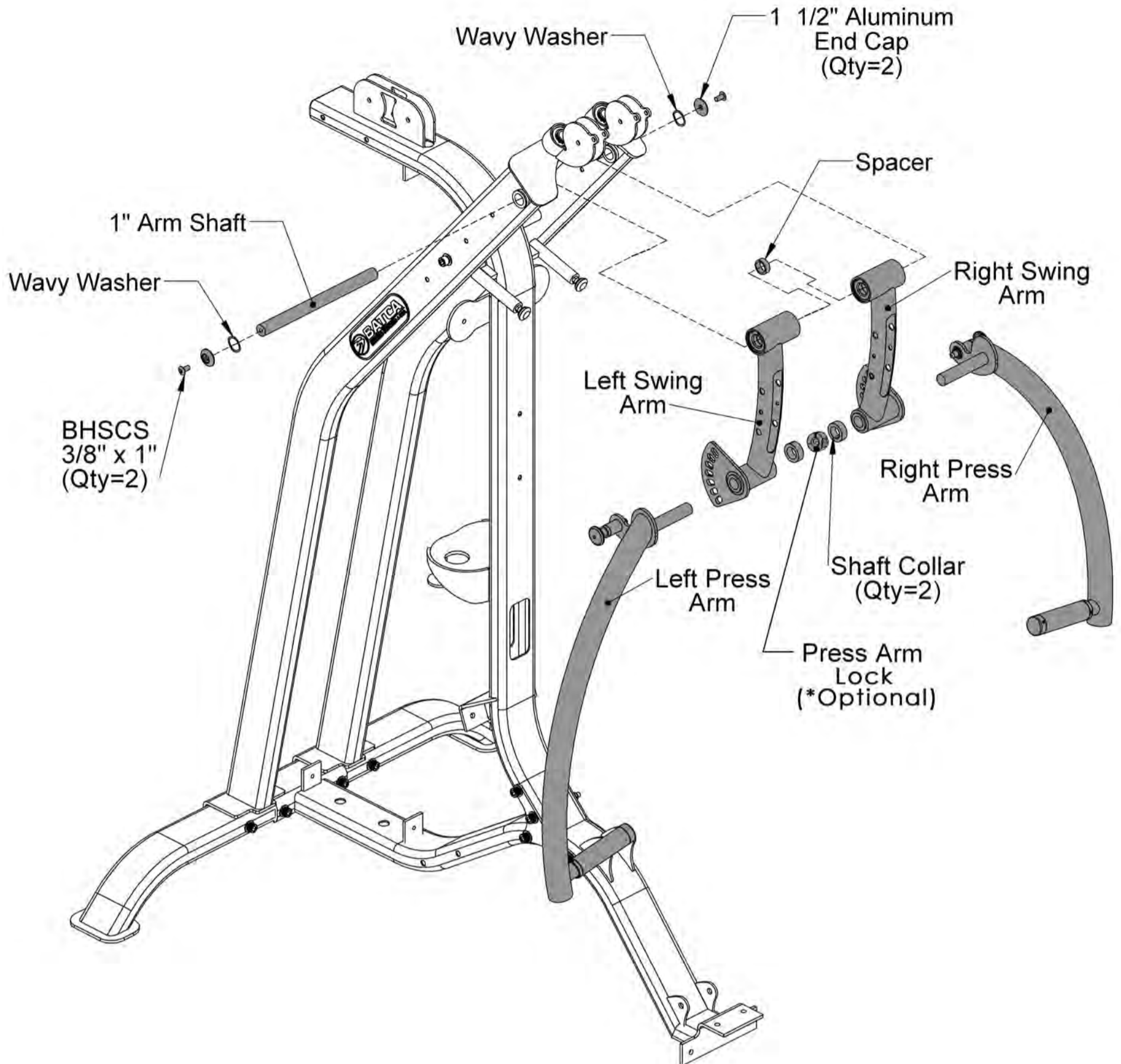


Part #	Description	Qty
BFM-10569	Middle Pole Assembly	1
BFL-50197	Middle Pole Connector Plate	2
BFH-50146	3/8" Flat Washer (Black)	10
BFH-50157	3/8"-16 Nylock (Black)	4
BFP-51756	SHCS 3/8"-16 X 5 1/4" P5	4
BFH-50147	3/8" Lock Washer (Black)	2
BFP-52394	SHCS 3/8"-16 X 2 1/2" P5	2
BFH-50253	Beveled Leveler	2
BFH-50149	3/8"-16 Jam Nut (Zinc)	4
BFH-50339	Large Flat Leveler	2

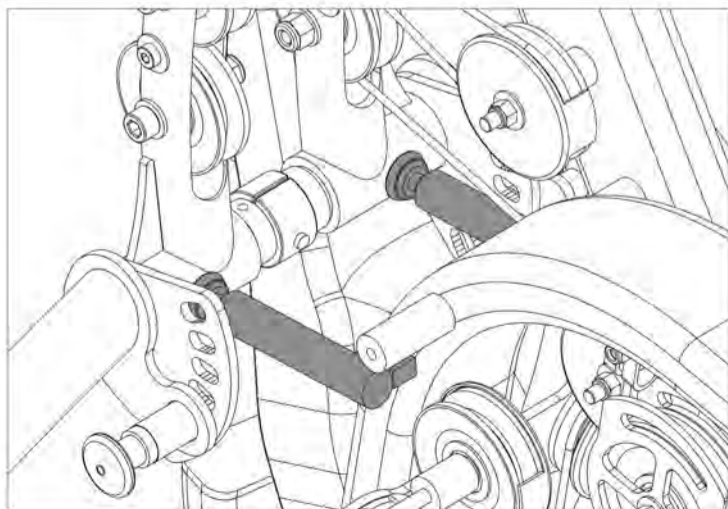
All Flat Washers and Nylocks are 3/8" unless otherwise noted.



**Step 3:**  **DO NOT TIGHTEN BOLTS UNTIL STEP 4**



The **Press Arm Lock** is an *\*optional* component that allows the user to connect both press arms so they are engaged at the same time. If the user would rather have each press arm operate independently then do not install the **Press Arm Lock**.

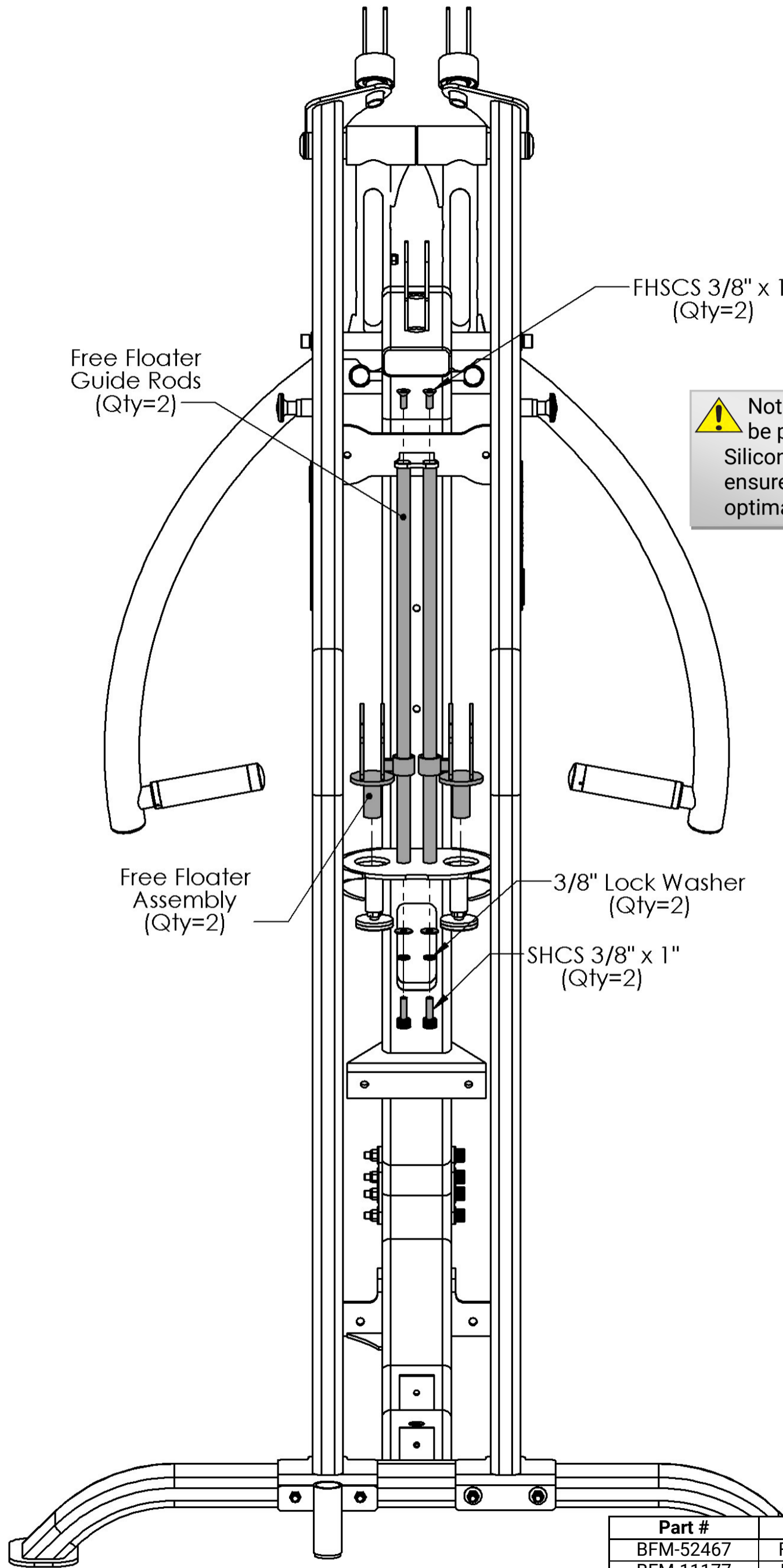



It is crucial to make sure the **Small Beveled Levelers** behind the press arms are adjusted equally so there is the same amount of thread showing on each side. This ensures the starting position of each press arm is exactly the same. This will help prolong the life of the cables and machine when adjusted properly

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

Part #	Description	Qty
BFM-10771	Press Arm Lock (Optional)	1
BFM-10736	Right Press Arm Assembly	1
BFM-10737rev1	Right Swing Arm Assembly	1
BFM-10733rev1	Left Swing Arm Assembly	1
BFM-10735	Left Press Arm Assembly	1
BFM-51080	.45" Spacer	1
BFM-51148	1" Arm Shaft	1
BFH-50337	Wavy Washer	2
BFH-50620	BHSCS 3/8" x 1"	2
BFM-52421	1 1/2" Aluminum Cap	2
BFH-50220	1" Shaft Collar	2

**Step 4:**  **DO NOT TIGHTEN BOLTS UNTIL STEP 5**



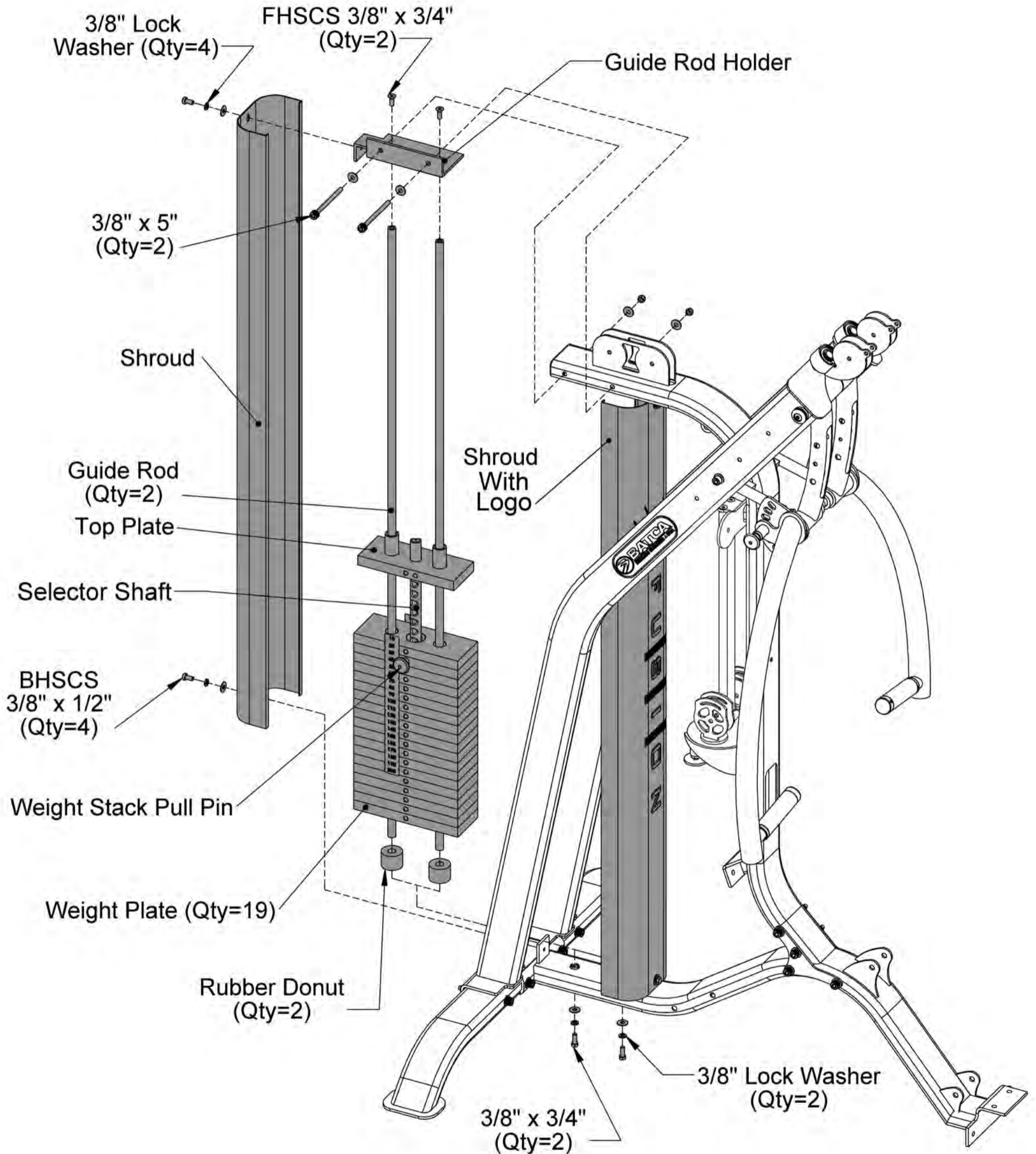
 **Note:** Each Guide Rod must be properly Lubed with a Silicone Based Teflon Gel to ensure smooth operation and optimal performance.

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

Part #	Description	Qty
BFM-52467	Free Floater Guide Rod	2
BFM-11177	Free Floater Assembly	2
BFP-52376	SHCS 3/8" x 1"	2
BFH-50144	FHSCS 3/8" x 1"	2
BFH-50147	3/8" Lock Washer	2
BFH-50146	3/8" Flat Washer	2

**Step 5:**  **Tighten all bolts before moving on**

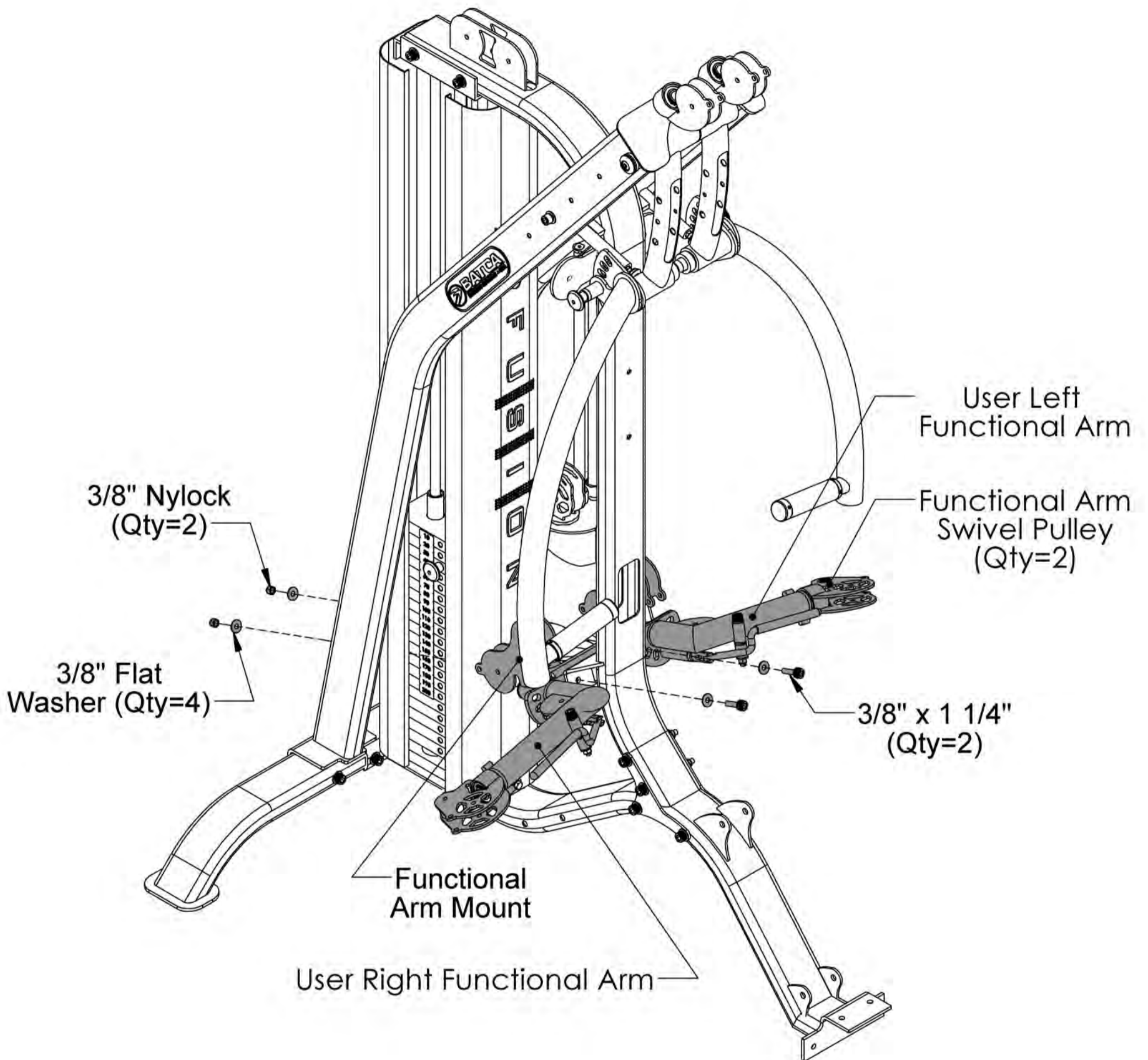
NOTE: It is important to install the front shroud **BEFORE** installing the weight stack on the machine. The Front Shroud has the Fusion Logo decal on it. If this is not installed **BEFORE** the weight stack on this step, the weight stack will have to be completely removed later in order to install the Front Shroud. **THERE IS NO OTHER WAY** to install the front shroud once the weight stack has been put on the machine. **DO NOT** wait until the end of assembly to install the Front Shroud.



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

Part #	Description	Qty	Part #	Description	Qty
BFM-51044	Guide Rod Holder	1	BFM-52410	Weight Stack Shroud w/Logo	1
BFM-50529	Rubber Donut	2	BFM-50258	Selector Shaft	1
BFM-50256	Weight Plate	19	BFH-50192	Weight Stack Decals	2
BFM-51051	Guide Rod	2	BFP-52340	SHCS 3/8"-16 X 3/4"	2
BFM-51082	Weight Stack Shroud	1	BFP-51799	SHCS 3/8"-16 X 5" P5	2
BFH-50146	3/8" Flat Washer (Black)	10	BFM-51173	Weight Stack Pull Pin	1
BFH-50157	3/8"-16 Nylock (Black)	2	BFH-50630	FHSCS 3/8"-16 X 3/4"	2
BFH-50147	3/8" Lock Washer (Black)	6	BFP-52401	BHSCS 3/8"-16 X 1/2"	4
BFM-10299	Top Plate	1			

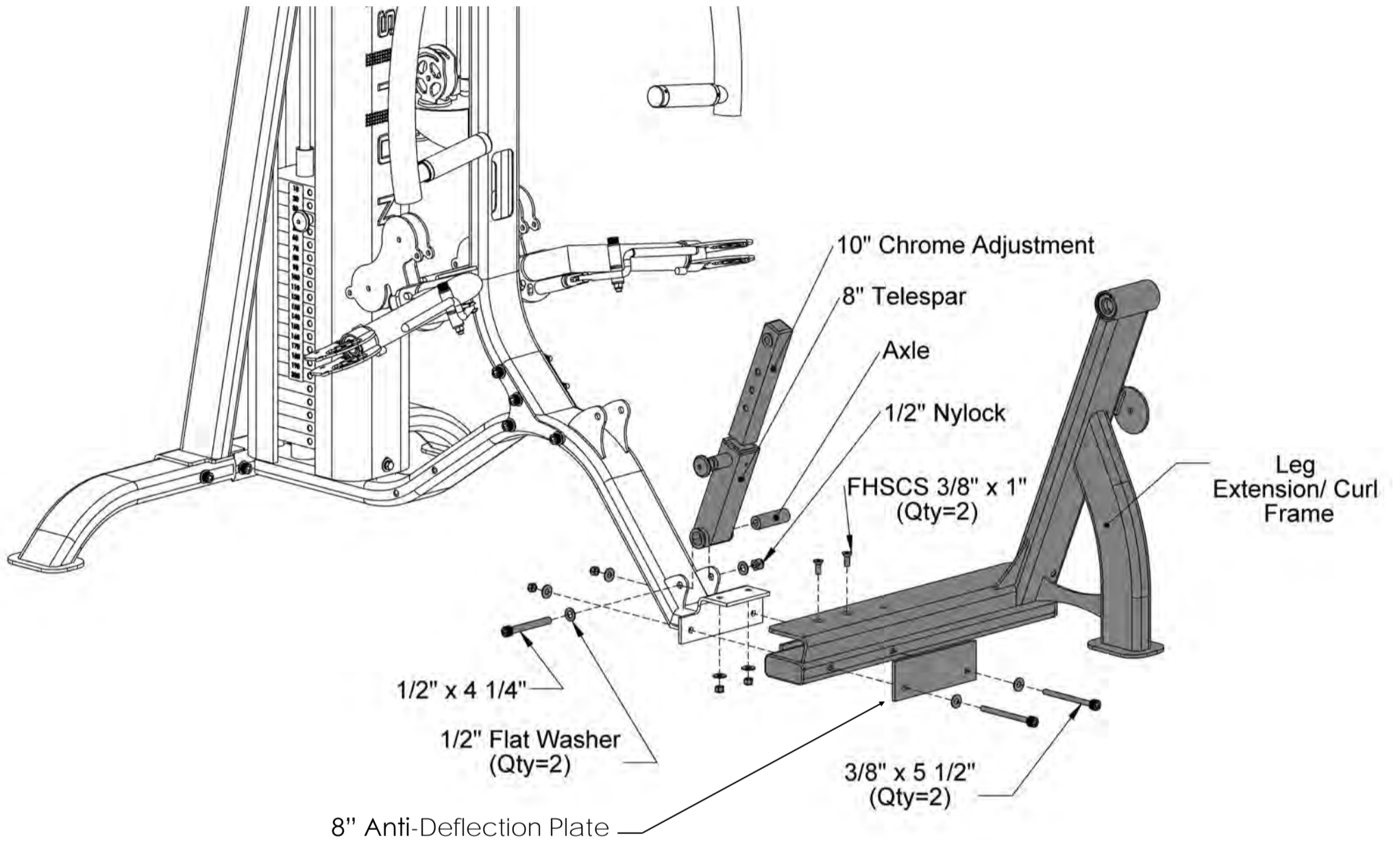
## Step 6:



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

Part #	Description	Qty
BFM-10573	Functional Arm Mount	1
BFM-10571	User Right Functional Arm	1
BFM-10572	User Left Functional Arm	1
BFM-10582rev1	Functional Arm Swivel Pulley	2
BFH-50146	3/8" Flat Washer (Black)	4
BFH-50157	3/8"-16 Nylock (Black)	2
BFP-51653	SHCS 3/8"-16 1 1/4" P5	2

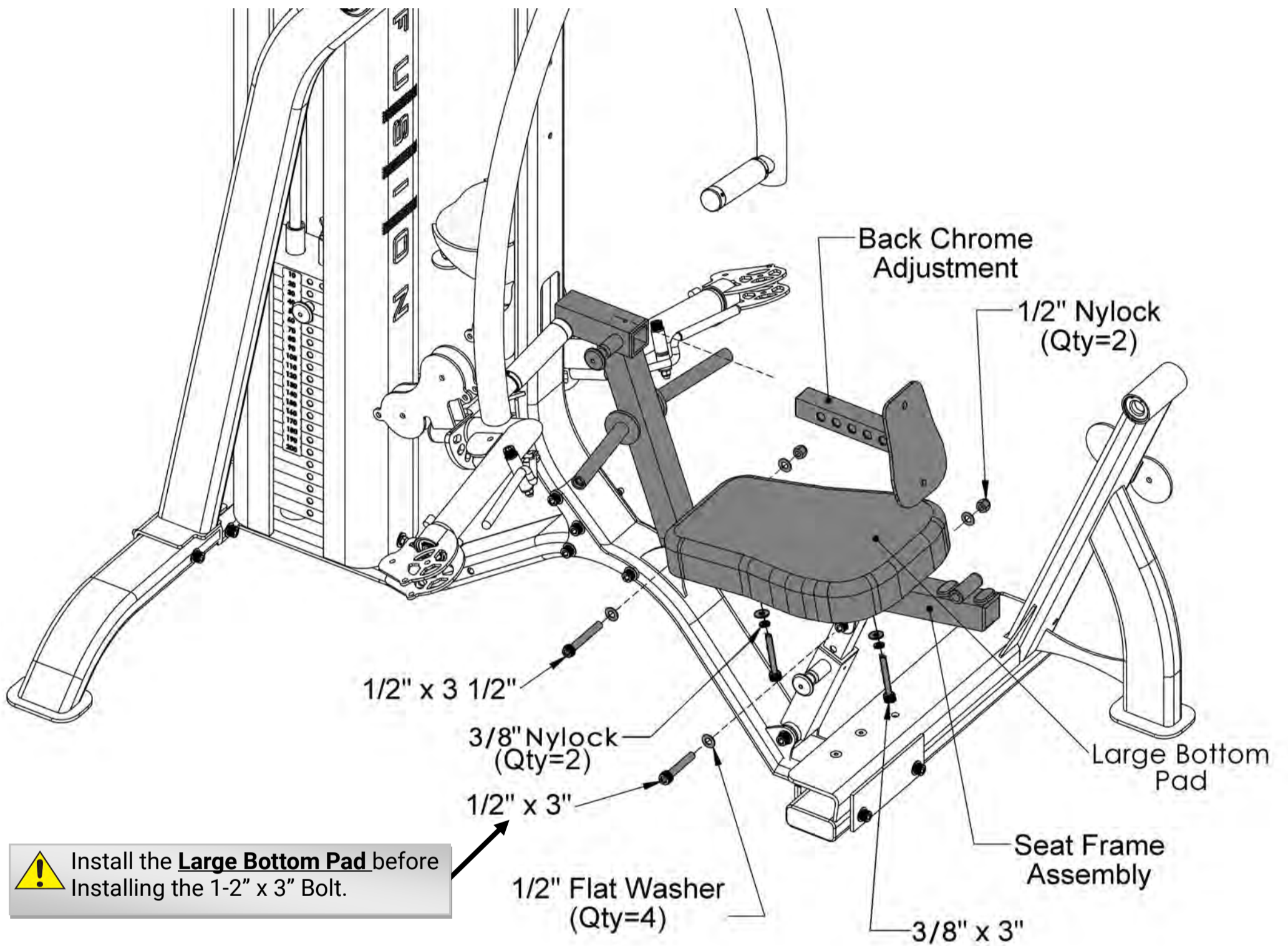
## Step 7:



Part #	Description	Qty
BFM-10577	8" Telespar	1
BFM-10579	10" Chrome Adjustment	1
BFM-10581	Leg Extension/ Curl Frame	1
BFM-51143	8" Anti-Deflection Plate	1
BFH-50146	3/8" Flat Washer (Black)	6
BFH-50157	3/8"-16 Nylock (Black)	4
BFH-50251	1/2" Flat Washer Black	2
BFP-51884	SHCS 1/2-13 X 4 1/4 P5	1
BFH-50155	1/2"-13 Nylock (Black)	1
BFP-52396	SHCS 3/8"-16 X 5 1/2"	2
BFH-50144	FHSCS 3/8"-16 X 1"	2
BFM-50931	3" Axle	1

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

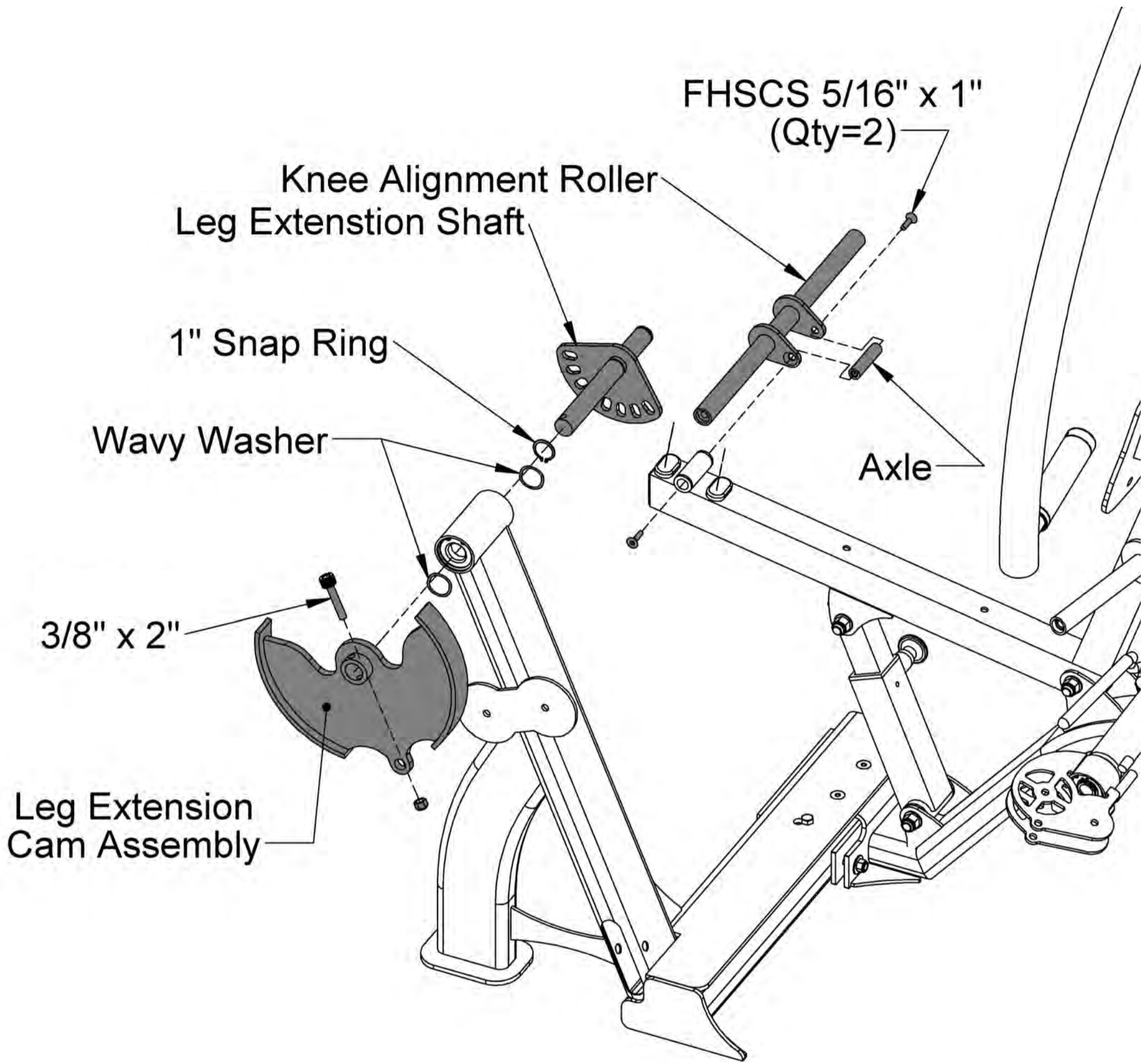
## Step 8:



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

Part #	Description	Qty
BFM-10578	Seat Frame Assembly	1
BFM-10580	Back Chrome Adjustment	1
BFP-50130	Large Bottom Pad	1
BFH-50251	1/2" Flat Washer (Black)	4
BFP-51747	SHCS 3/8" x 3"	2
BFP-51760	SHCS 1/2"-13 X 3 1/2"	1
BFP-51747	SHCS 1/2"-13 X 3" P5	1
BFH-50155	1/2"-13 Nylock (Black)	2
BFH-50146	3/8" Flat Washer	2
BFH-50147	3/8" Lock Washer	2

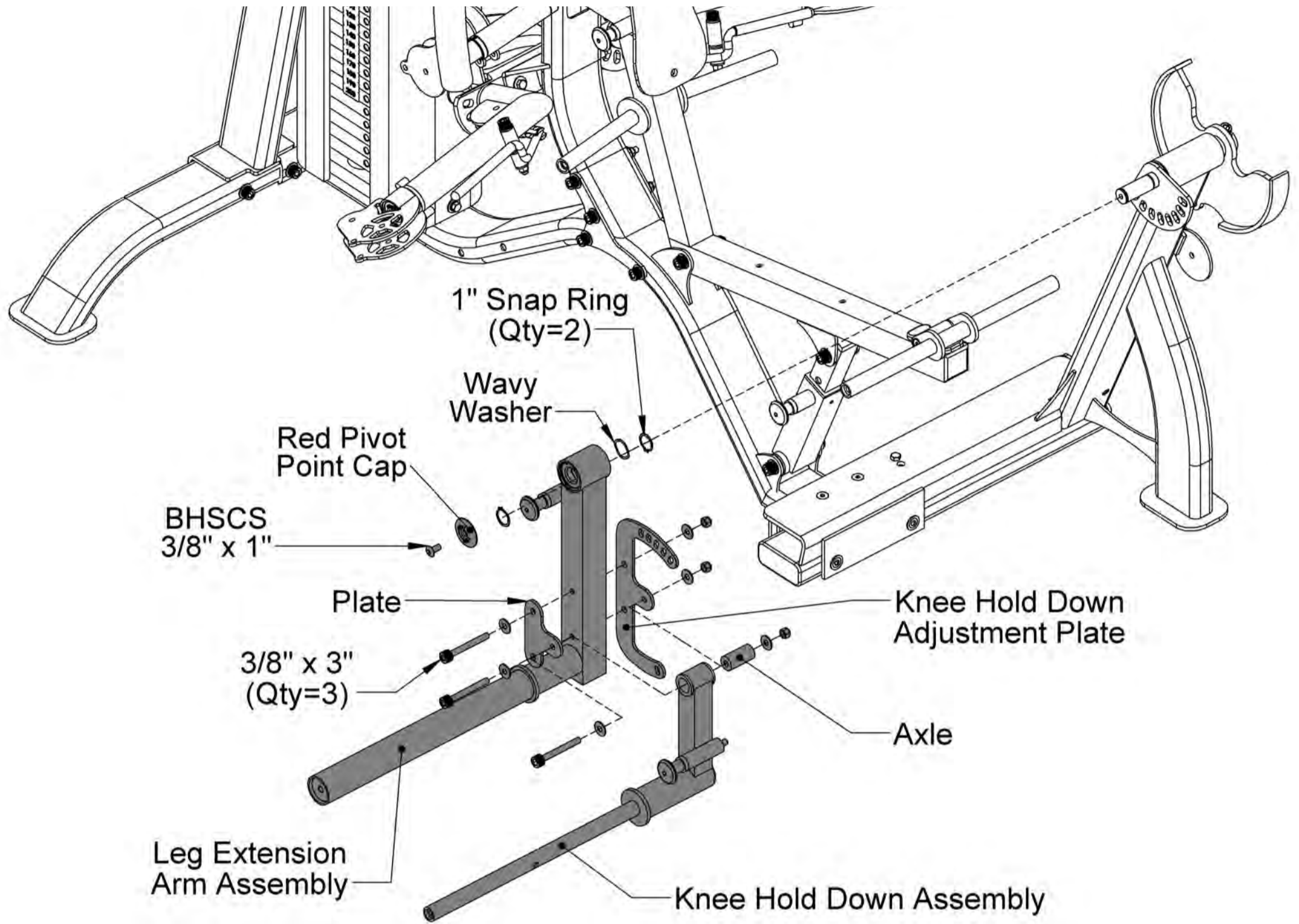
**Step 9:**



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

Part #	Description	Qty
BFM-10141	Knee Alignment Roller	1
BFM-10584	Leg Extension Shaft	1
BFM-10585	Leg Extension Cam Assembly	1
BFH-50165	1" Snap Ring	1
BFH-50157	3/8"-16 Nylock (Black)	1
BFP-51759	SHCS 3/8"-16 X 2"	1
BFH-50245	FHSCS 5/16"-18 X 1"	2
BFM-50222	2 9/16" Axle	1
BFH-50337	Wavy Washer	2

## Step 10:



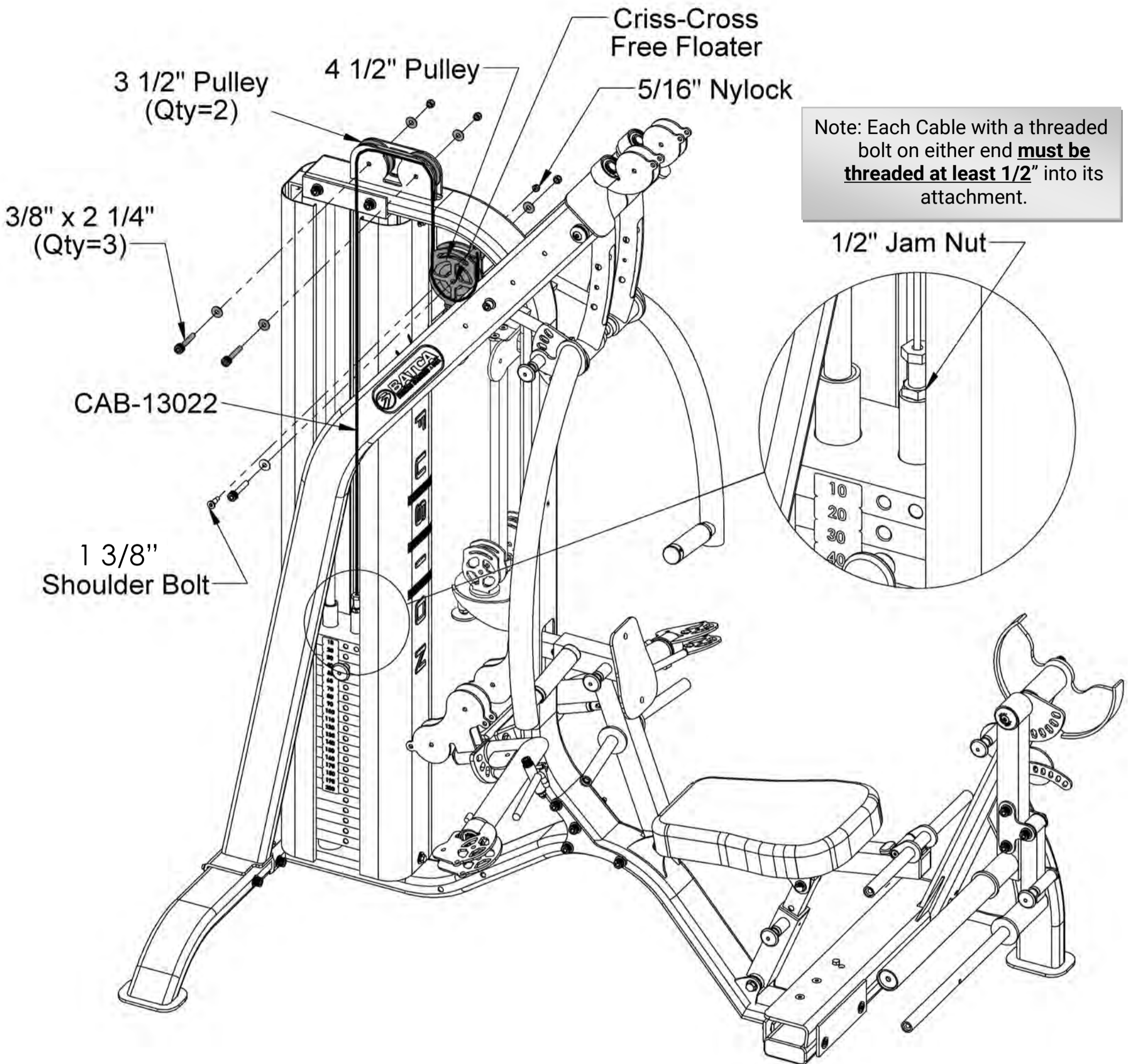
Part #	Description	Qty
BFM-10586	Leg Extension Arm Assembly	1
BFL-50207	Hold Down Adjustment Plate	1
BFL-50211	Plate	1
BFM-10587	Knee Hold Down Assembly	1
BFM-51094	2" Axle	1
BFH-50165	1" Snap Ring	2
BFH-50146	3/8" Flat Washer (Black)	6
BFH-50157	3/8"-16 Nylock (Black)	3
BFP-51747	SHCS 3/8"-16 X 3" P5	3
BFH-50337	Wavy Washer	1
BFH-50620	BHSCS 3/8" x 1"	1
BFM-52422	Red Pivot Point Cap	1

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

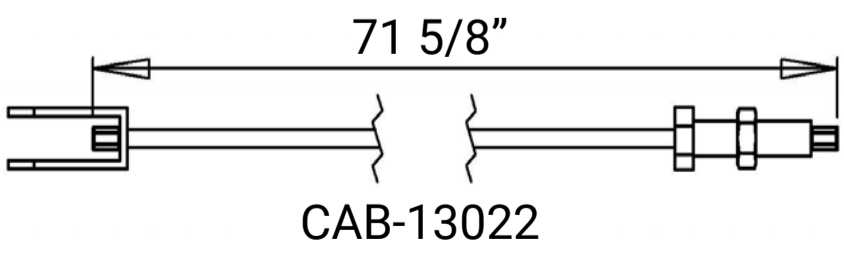


# Cable Routing

## Step 11:



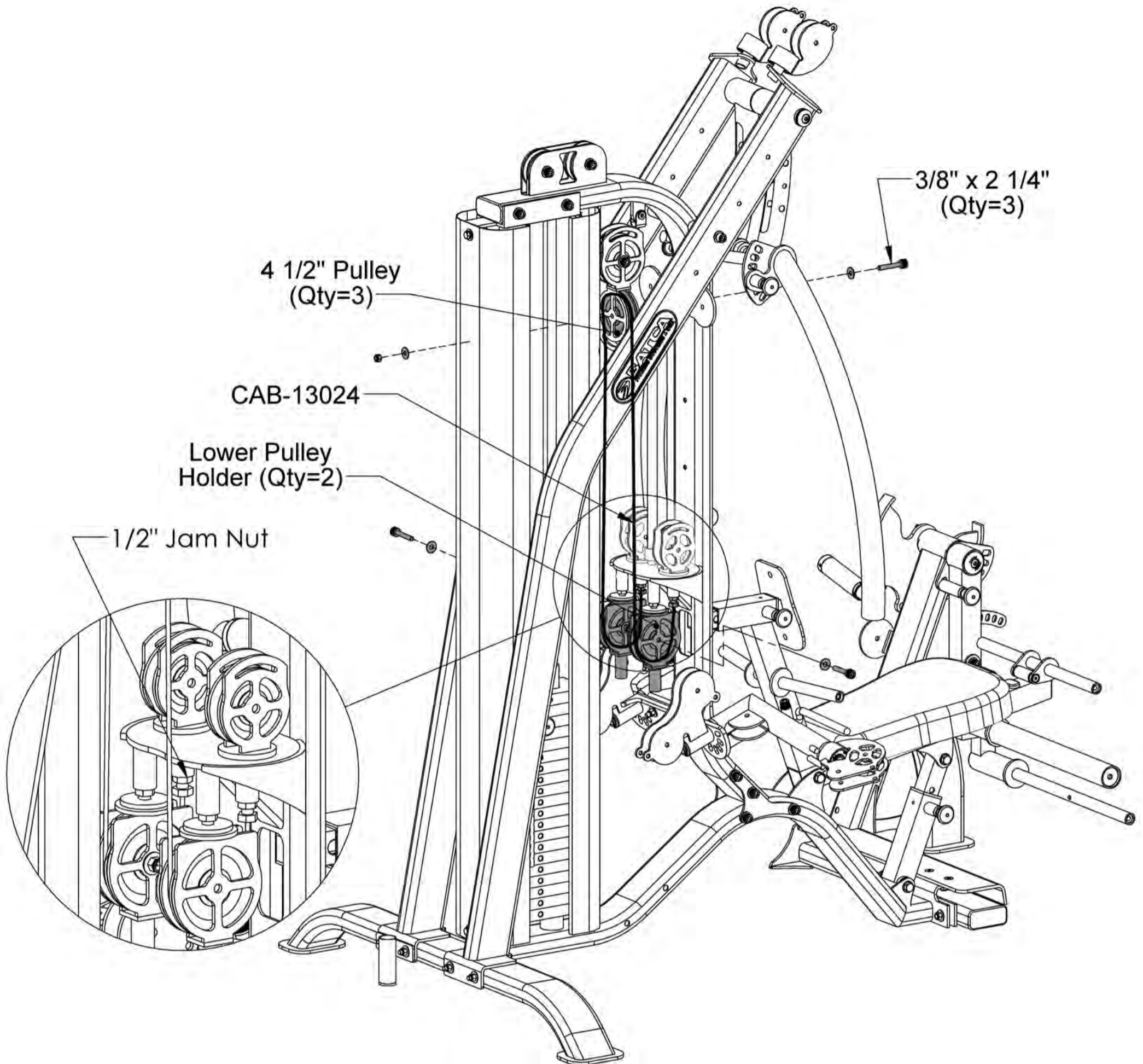
Note: Each Cable with a threaded bolt on either end **must be threaded at least 1/2"** into its attachment.



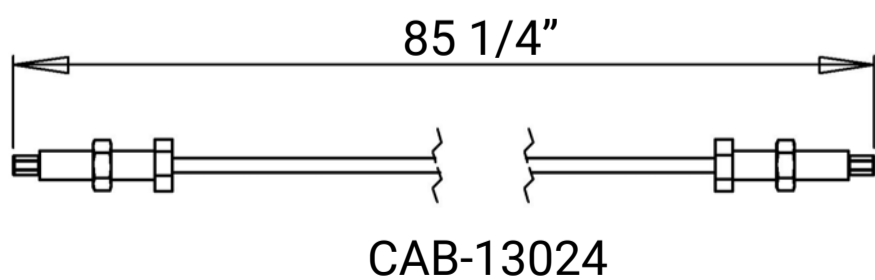
Part #	Description	Qty
BFH-50173	3 1/2" Pulley	2
BFH-50146	3/8" Flat Washer (Black)	6
BFP-51752	SHCS 3/8"-16 X 2 1/4" P5	3
BFH-50157	3/8"-16 Nylock (Black)	3
BFH-50256	1/2" Jam Nut	1
BFM-10611	Criss-Cross Free Floater	1
BFH-50174	4 1/2" Pulley	1
CAB-13022	Fusion Weight Stack to Cable Tie Out	1
BFH-50351	1 3/8" Shoulder Bolt	1
BFH-50267	5/16"-18 Nylock (Zinc)	1

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.

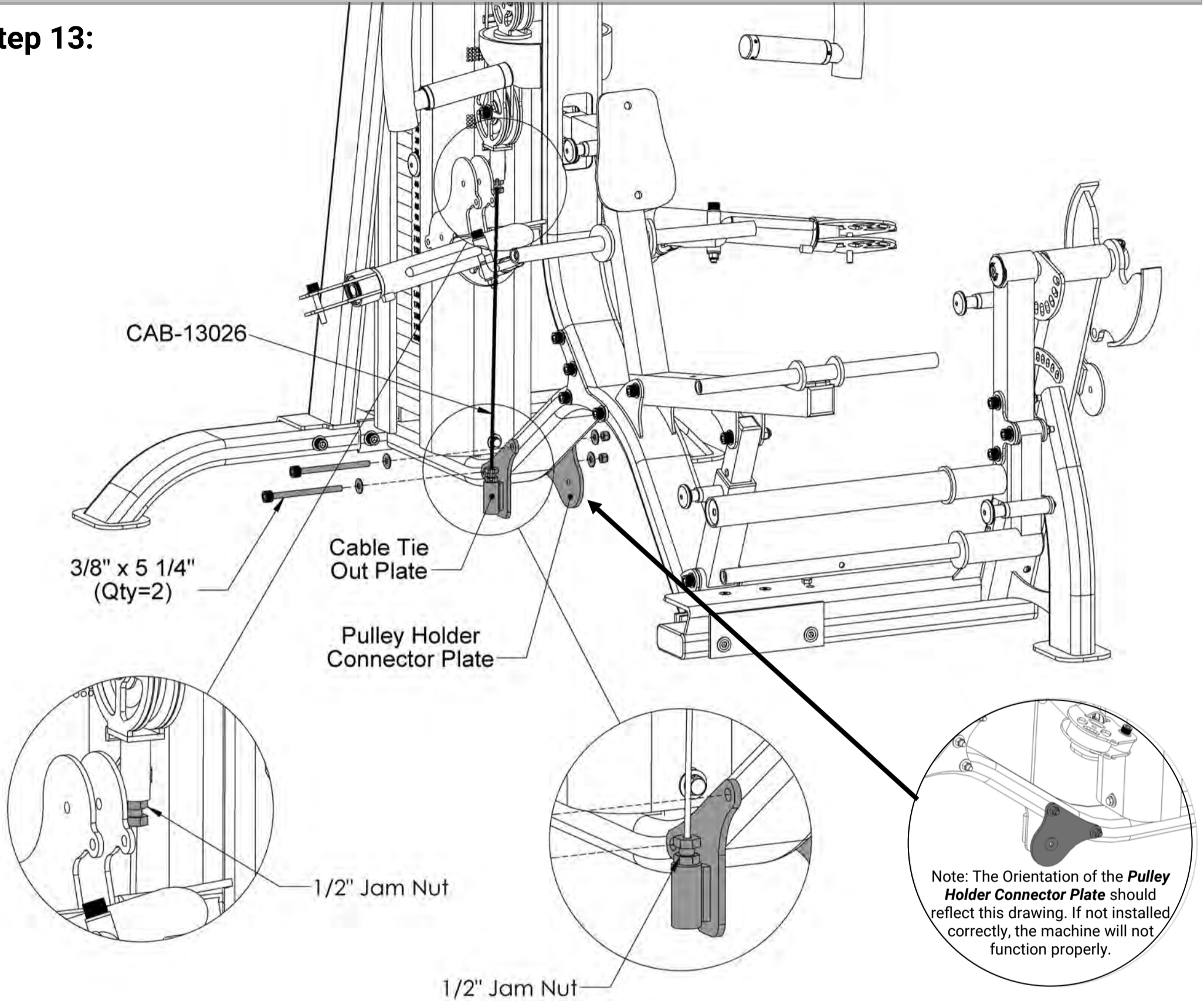


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

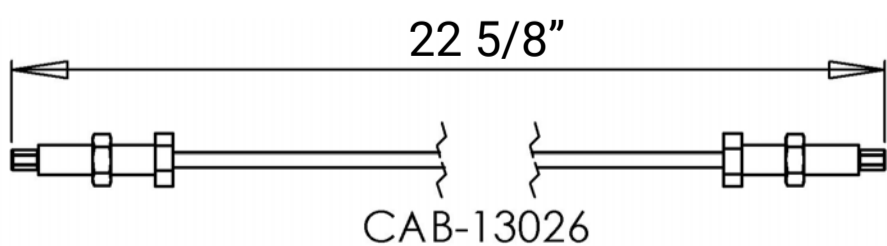
Item #	Part #	Description	Qty
56	BFH-50146	3/8" Flat Washer (Black)	6
57	BFP-51752	SHCS 3/8"-16 X 2 1/4" P5	3
58	BFH-50157	3/8"-16 Nylock (Black)	3
92	BFH-50256	1/2" Jam Nut	2
93	BFM-10609rev1	Pulley Holder	2
95	BFH-50174	4 1/2" Pulley	3
96	BFM-10610rev1	Lower Pulley Holder	2
103	CAB-13024	Fusion Floating Pulley Cable	1

**⚠ Note: If Leg Press Option is purchased, skip this step and install the Pulley Holder Connector Plate (from this step) and CAB-13025 Leg Extension Cable (from next step) when the Leg Press is attached to the machine on page 30. The Cable Tie Out Plate and Tie Out Cable from this step should not be installed if the Leg Press has been purchased.**

**Step 13:**



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

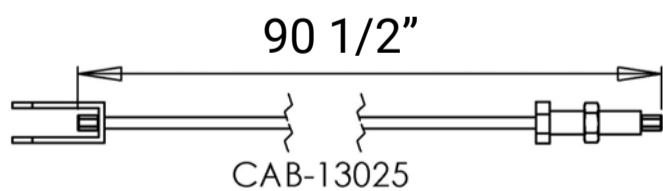
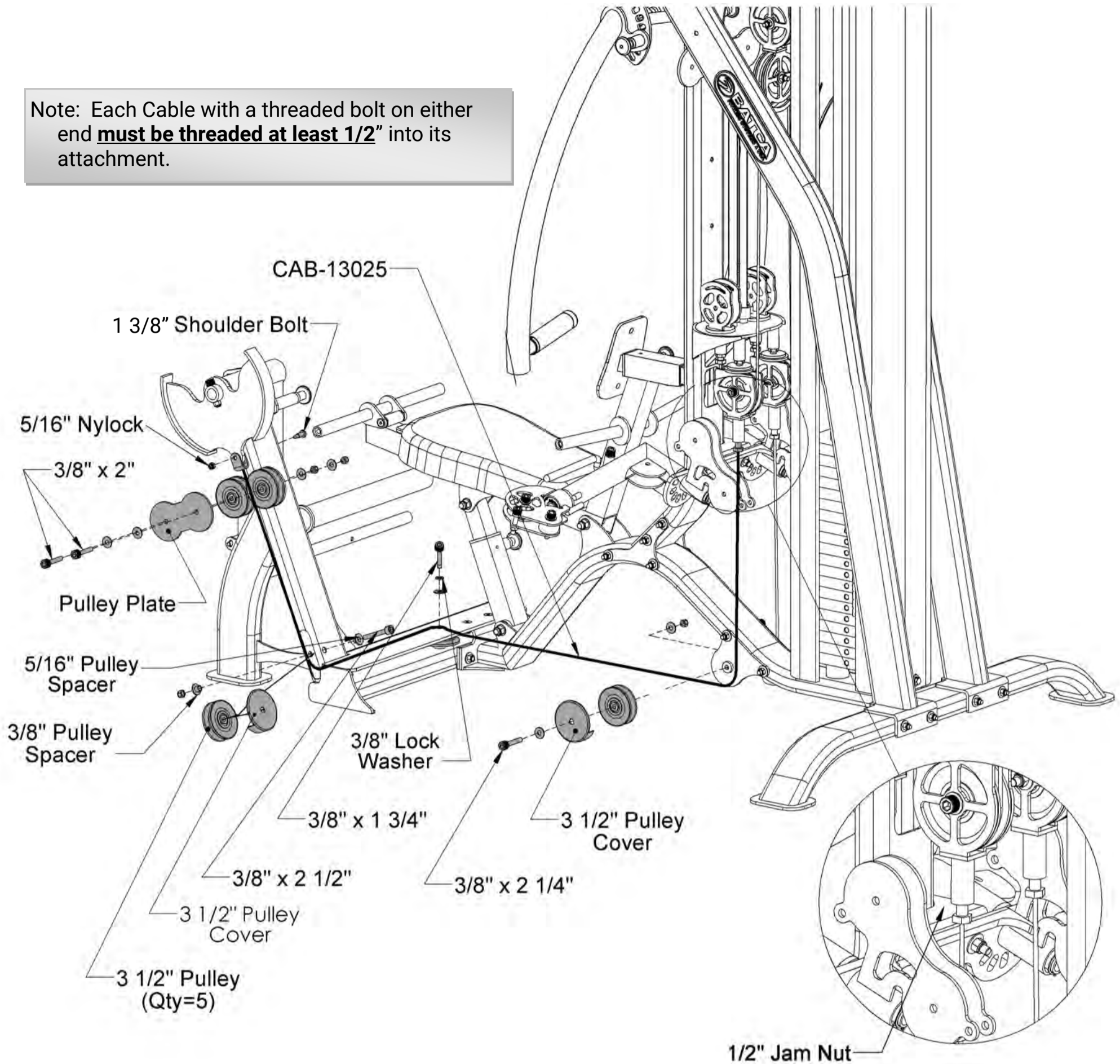


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

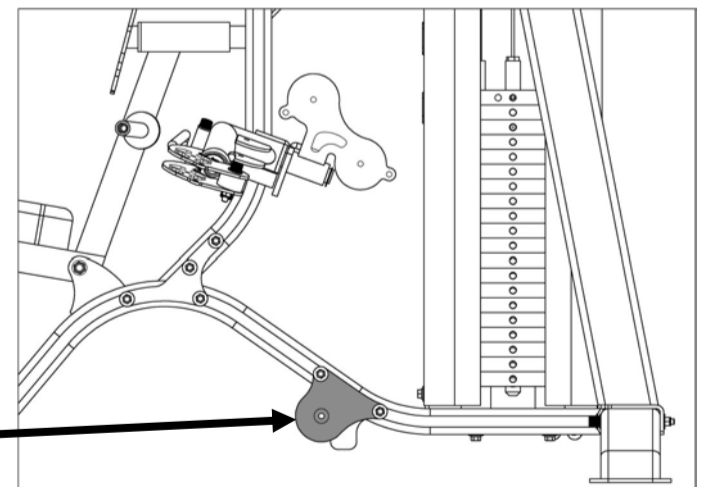
Part #	Description	Qty
BFL-50203	Pulley Holder Connector Plate	1
BFH-50146	3/8" Flat Washer (Black)	4
BFH-50157	3/8"-16 Nylock (Black)	2
BFP-51756	SHCS 3/8"-16 X 5 1/4" P5	2
BFH-50256	1/2" Jam Nut	2
BFM-10612	Cable Tie Out Plate	1
CAB-13026	Fusion Tie Out Cable	1

## Step 14:

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



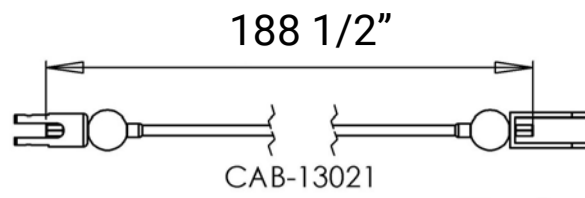
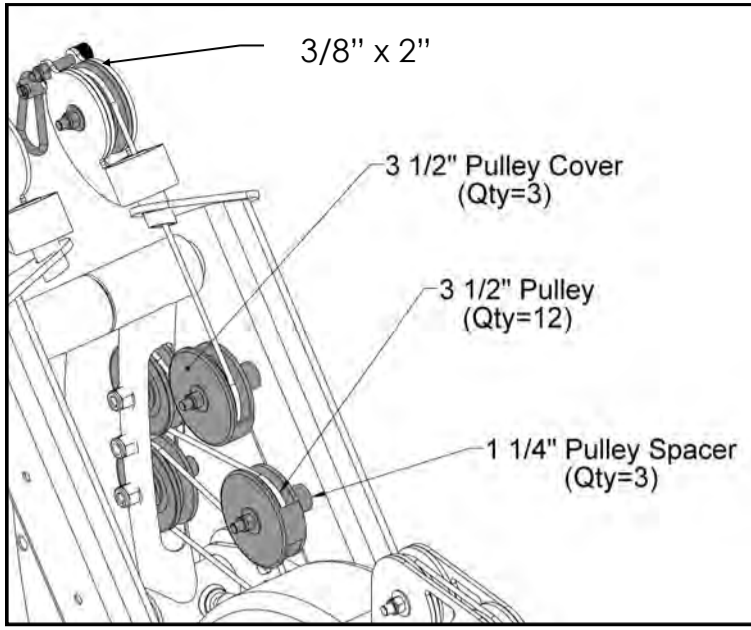
If you have adjusted the cable system and it appears your cable may be too short or the **Free Floating Pulleys** directly behind the back pad of the chest press station are not at the same level (one appears much lower than the other), please double check the orientation of the **Pulley Holder Connector Plate** from step 13. It should reflect this drawing. There is a spacer welded to the **Pulley Holder Connector Plate**. The spacer should be facing away from the machine if installed properly.



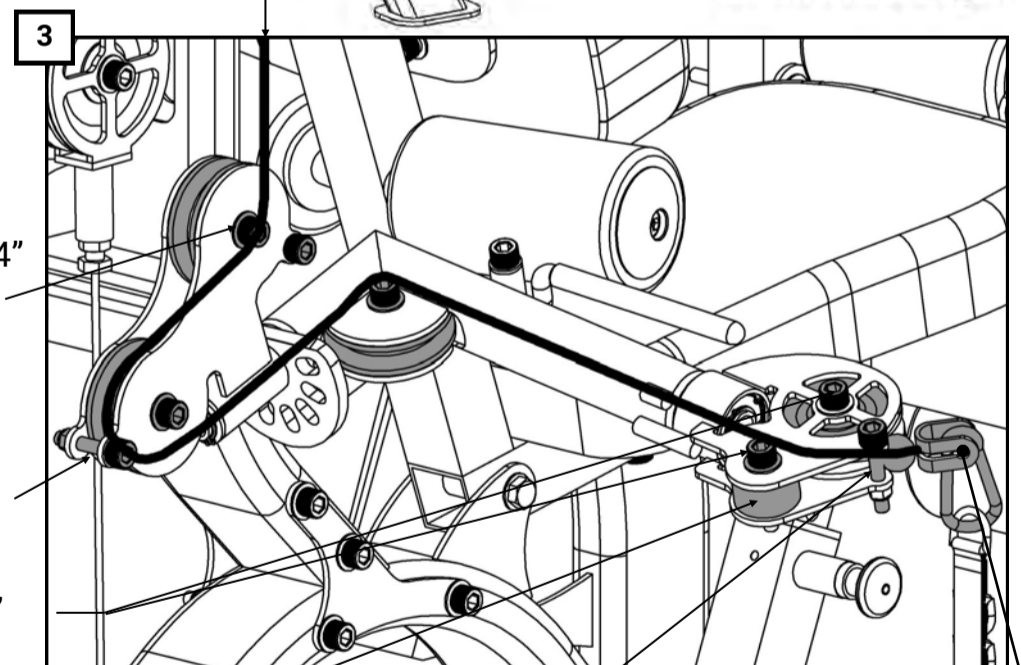
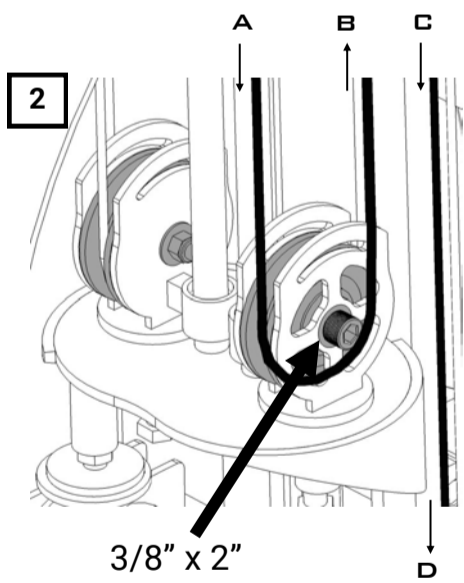
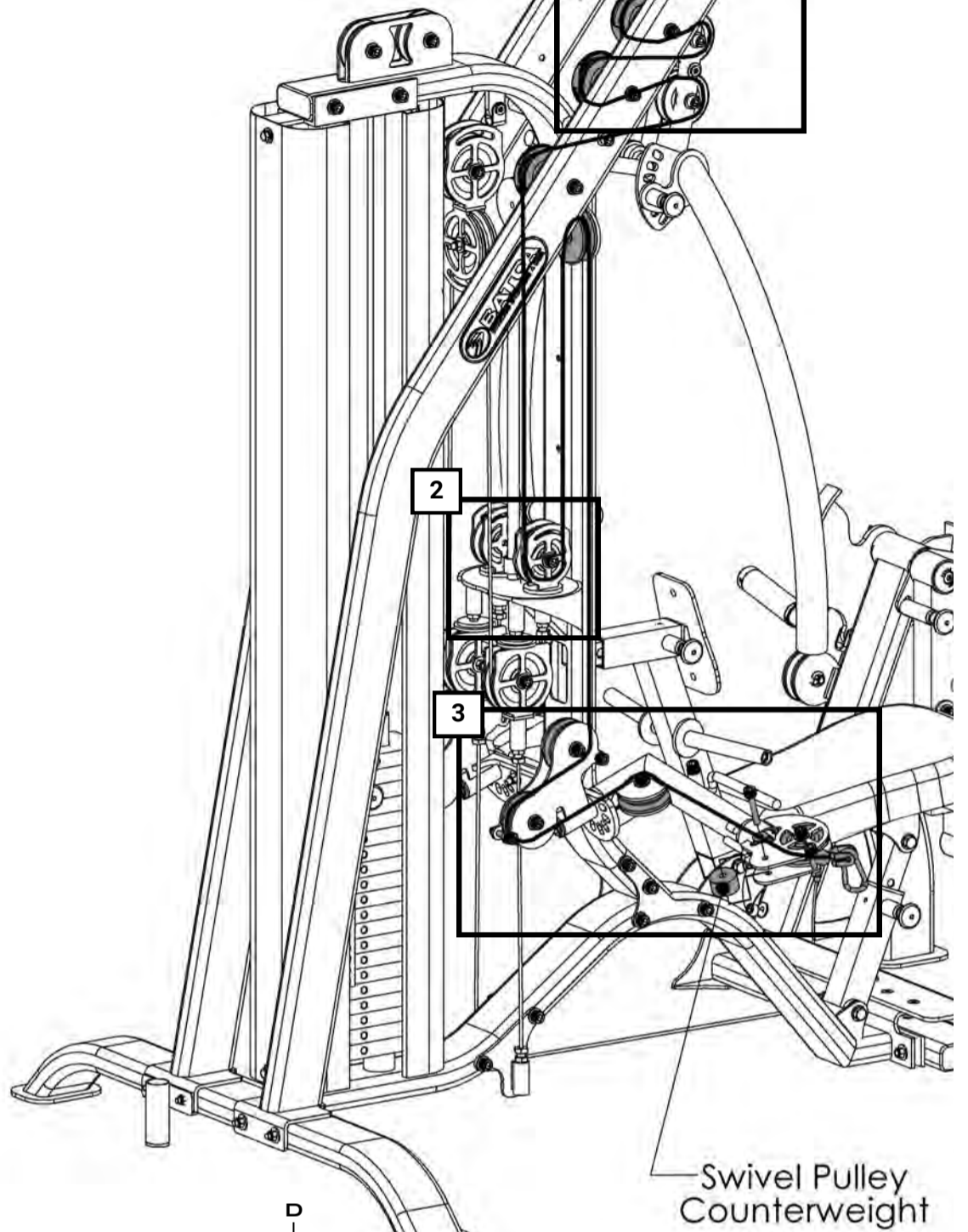
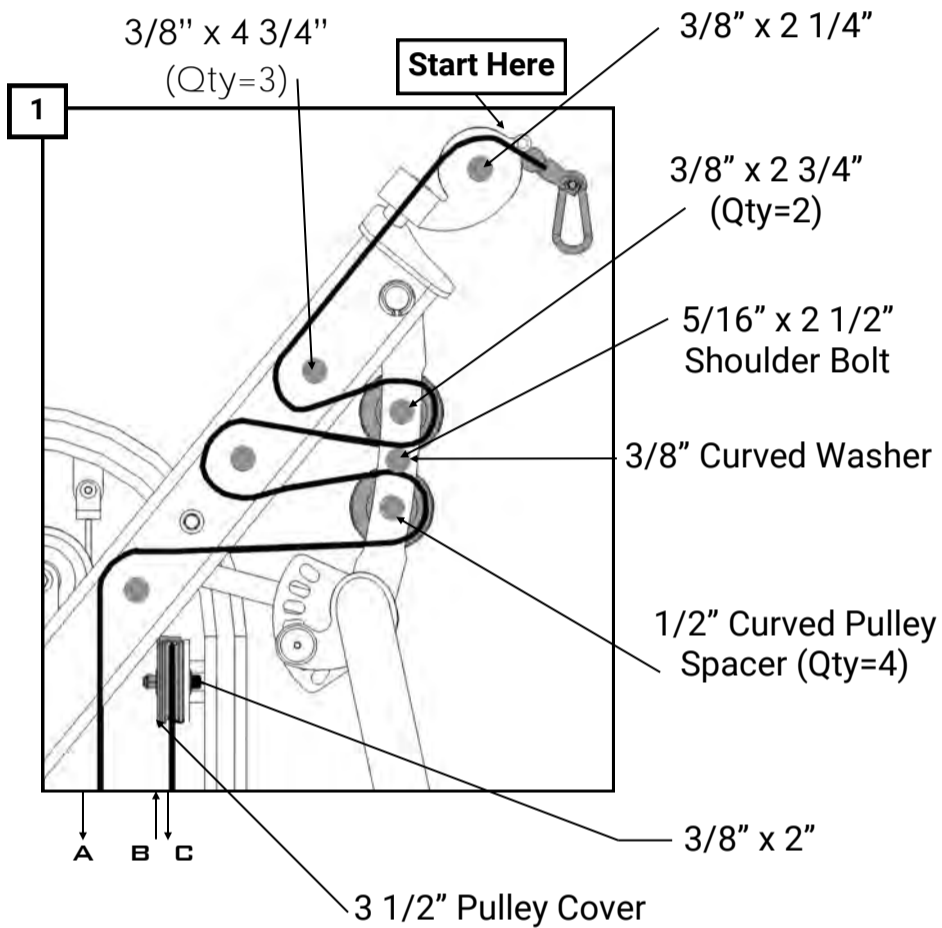
All Flat Washers and Nylocks are 3/8\"/>

Part #	Description	Qty	Part #	Description	Qty
BFH-50173	3 1/2" Pulley	5	BFH-50605	3/8" Pulley Spacer	1
BFH-50147	3/8" Lock Washer (Black)	1	BFP-52394	SHCS 3/8"-16 X 2 1/2"	1
BFL-50221	Pulley Plate	1	BFM-50505	3 1/2" Pulley Cover	2
BFH-50146	3/8" Flat Washer (Black)	7	BFH-50256	1/2" Jam Nut	1
BFP-51752	SHCS 3/8"-16 X 2 1/4" P5	1	CAB-13025	Fusion Leg Extension Cable	1
BFH-50157	3/8"-16 Nylock (Black)	4	BFH-50351	1 3/8" Shoulder Bolt	1
BFP-51759	SHCS 3/8"-16 X 2" P5	2	BFH-50267	5/16"-18 Nylock (Zinc)	1
BFP-52397	SHCS 3/8"-16 1 3/4" P5	1	BFH-52553	5/16" Pulley Spacer	1

## Step 15:



Start Routing Here

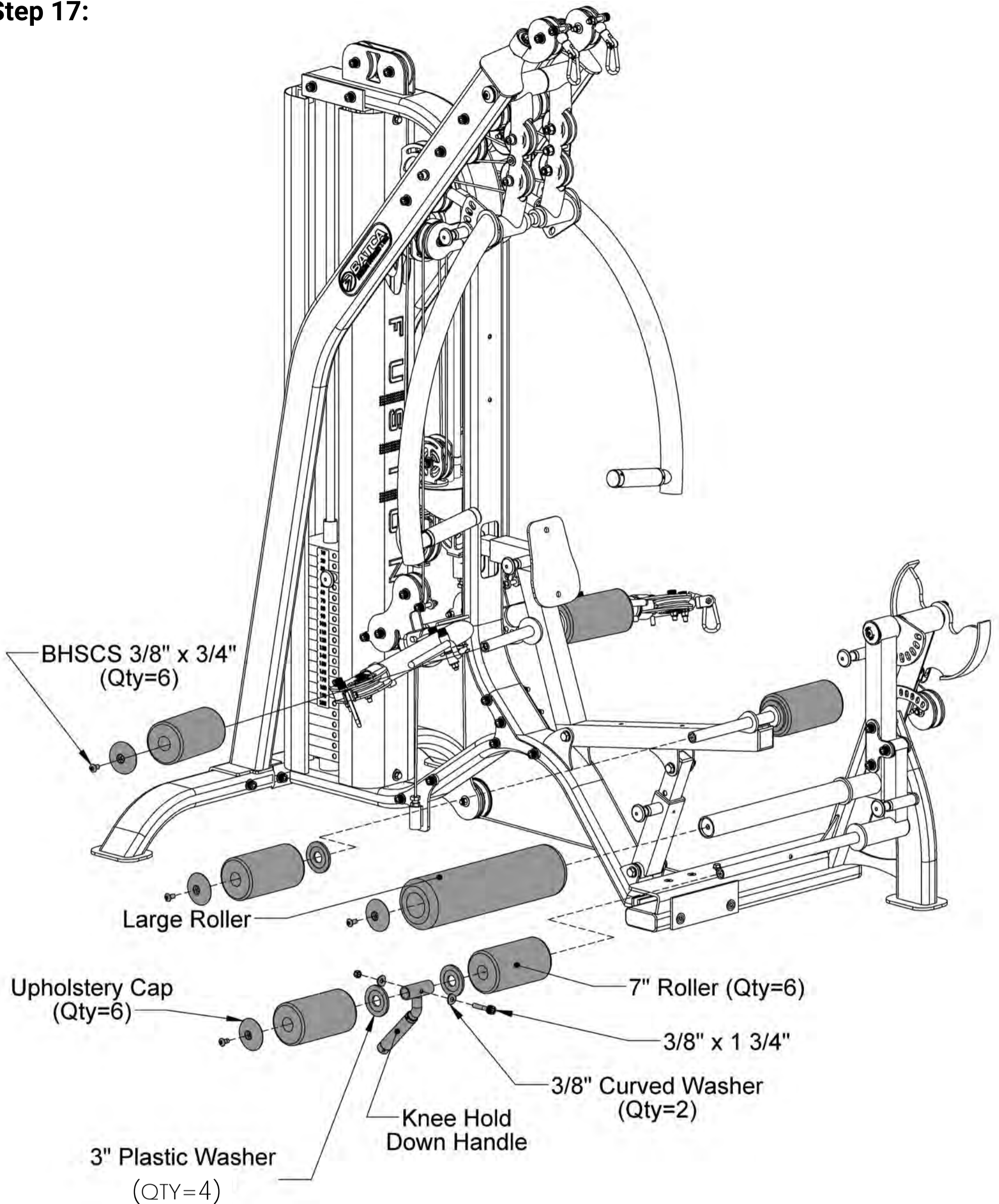


**Assembly Tip:** In order to prevent any cable twisting route the cable around each pulley individually and pull it all the way through before routing around the next pulley in the cable routing sequence. If this is not done properly, damage and twisting to the cable can occur. Also, remove cable end before routing. Make sure the cable is tight and there is even tension on both of the Cab-13021 cables that will be installed during this step. If these two cables do not have the same tension this could cause problems that may effect the operation of the machine. A list of all the available cable adjustment locations is on pages 22-23 as a guide to properly adjust the cable tension throughout the machine.

**Step 16:** Repeat for alternate side of Fusion. Use same Bill of Materials from Step 15 for Step 16. Use CAB-13021, Fusion Lat Pull to Functional Arm.

Part #	Description	Qty	Part #	Description	Qty
BFM-51022	1 1/4" Spacer	3	BFP-51759	SHCS 3/8"-16 X 2" P5	5
BFH-50173	3 1/2" Pulley	12	BFP-51753	SHCS 3/8"-16 X 4 3/4" P5	3
BFH-50146	3/8" Flat Washer (Black)	20	BFM-50505	3 1/2" Pulley Cover	4
BFP-51752	SHCS 3/8"-16 X 2 1/4"	5	CAB-13021	Fusion Lat Pull to Functional Arm	1
BFH-50157	3/8"-16 Nylock (Black)	16	BFH-50203	1/2" Curved Pulley Spacer	4
	5/16" x 2 1/2" Shoulder Bolt		BFH-50204	3/8" Curved Washer (Black)	2
BFM-52435	Bolt	1	BFH-50351	1 3/8" Shoulder Bolt	1
BFP-51750	SHCS 3/8"-16 X 2 3/4"	2	BFH-50267	5/16"-18 Nylock (Zinc)	1


## Step 17:

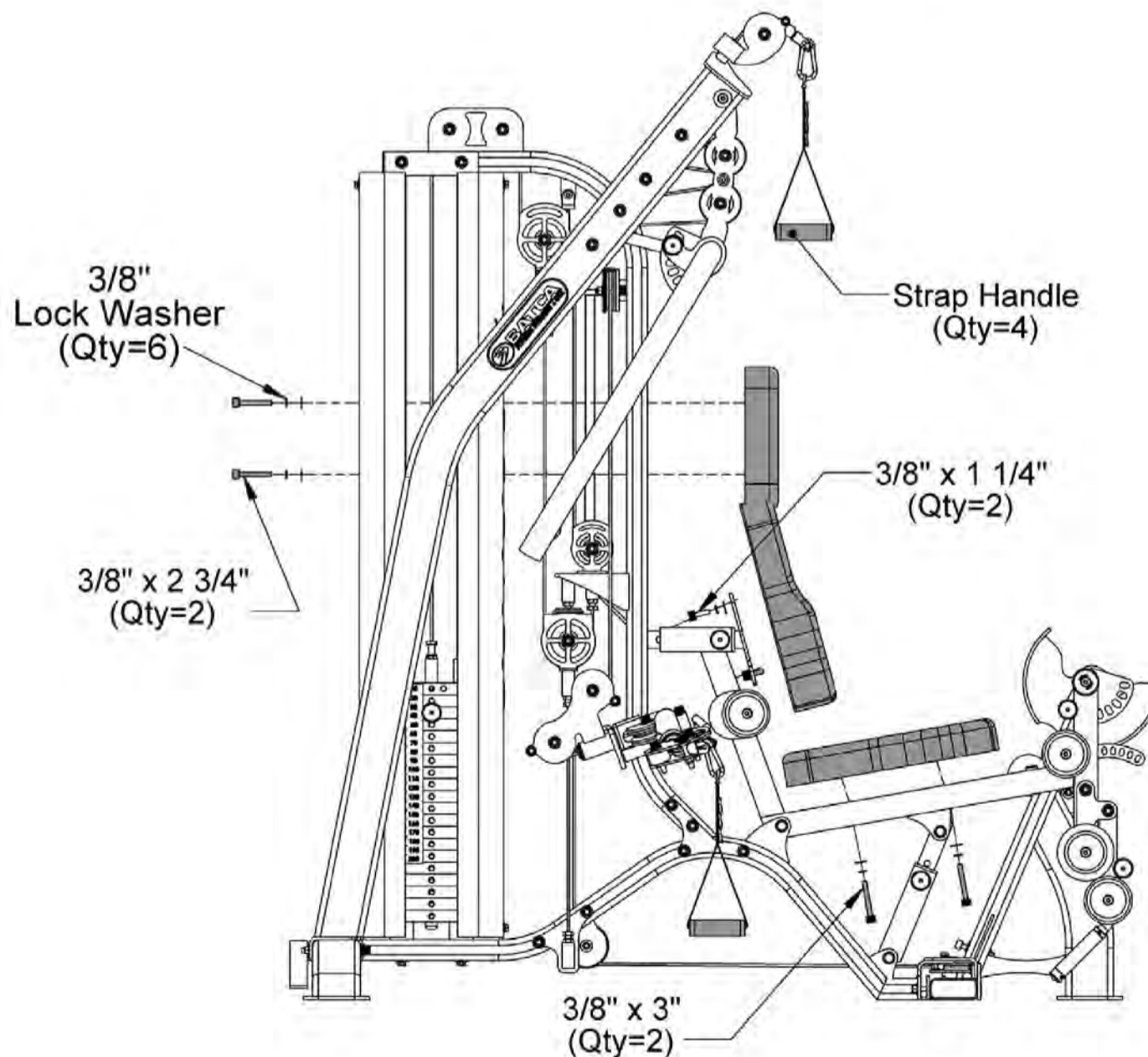
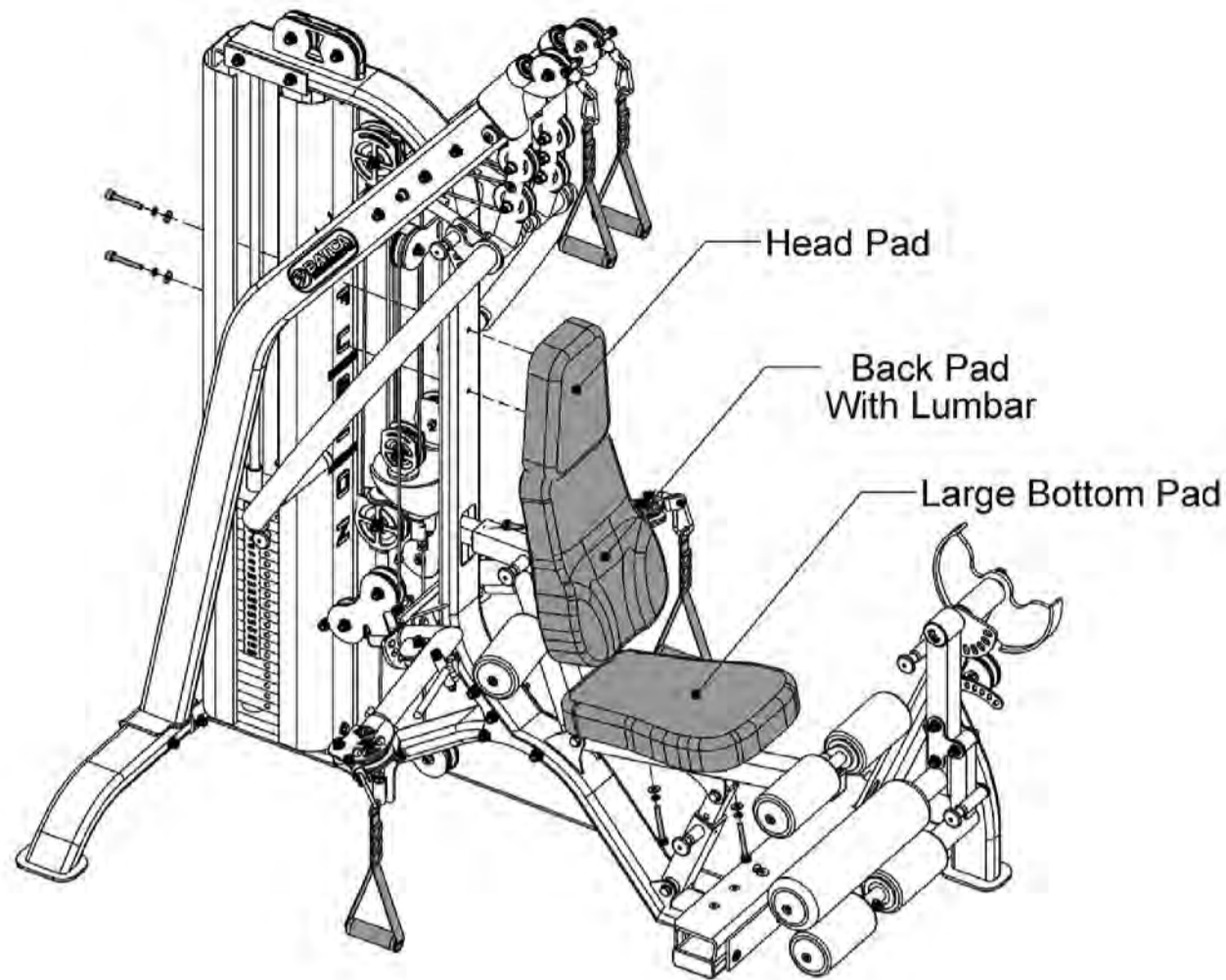


Part #	Description	Qty
BFH-50221	3" Plastic Washer	4
BFU-50189	7" Roller	6
BFU-50187	Large Roller	1
BFM-10588	Knee Hold Down Handle	1
BFH-50157	3/8"-16 Nylock (Black)	1
BFP-52397	SHCS 3/8"-16 X 1 3/4" P5	1
BFH-50204	3/8" Curved Washer	2
BFH-50620	BHSCS 3/8"-16 X 3/4" P5	6
BFH-50622	Upholstery Cap	6

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

## Step 18:

 Please double check each pad for correct positioning and location. If the pads are not installed with the correct orientation and in the right location, it will directly effect the workout. Please especially make sure the seat pads for the leg extension/leg curl and for the leg press portion of the machine are turned the right way.

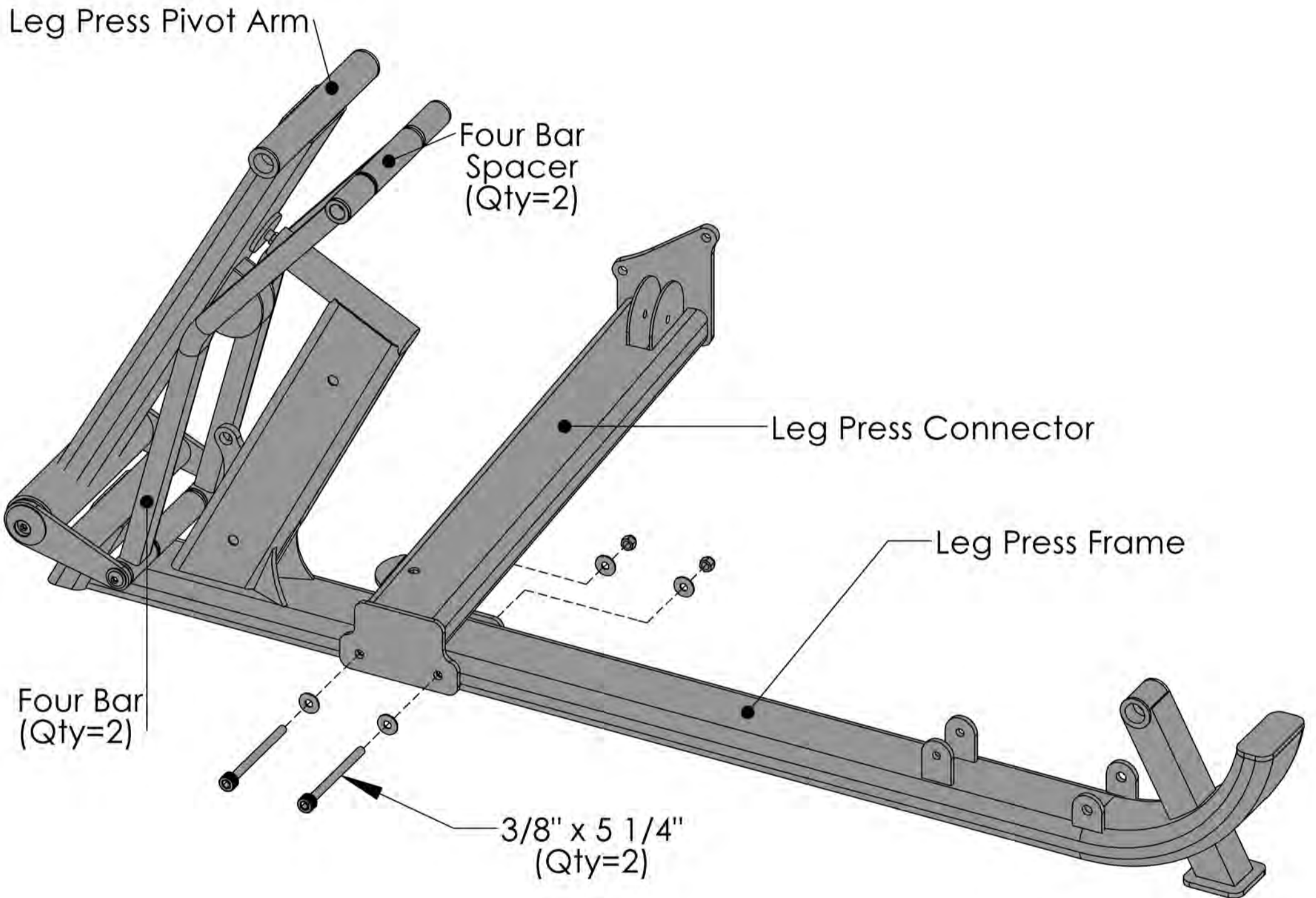


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFP-52137	Head Pad	1
BFP-52136	Back Pad With Lumbar	1
BFH-50146	3/8" Flat Washer (Black)	4
BFH-50147	3/8" Lock Washer (Black)	4
BFP-51653	SHCS 3/8"-16 x 1 1/4" P5	2
BFP-51750	SHCS 3/8"-16 X 2 3/4" P5	2
BFC-10103	Strap Handle	4

# Leg Press Option


**Step 19:**  Note: This step may be pre-assembled

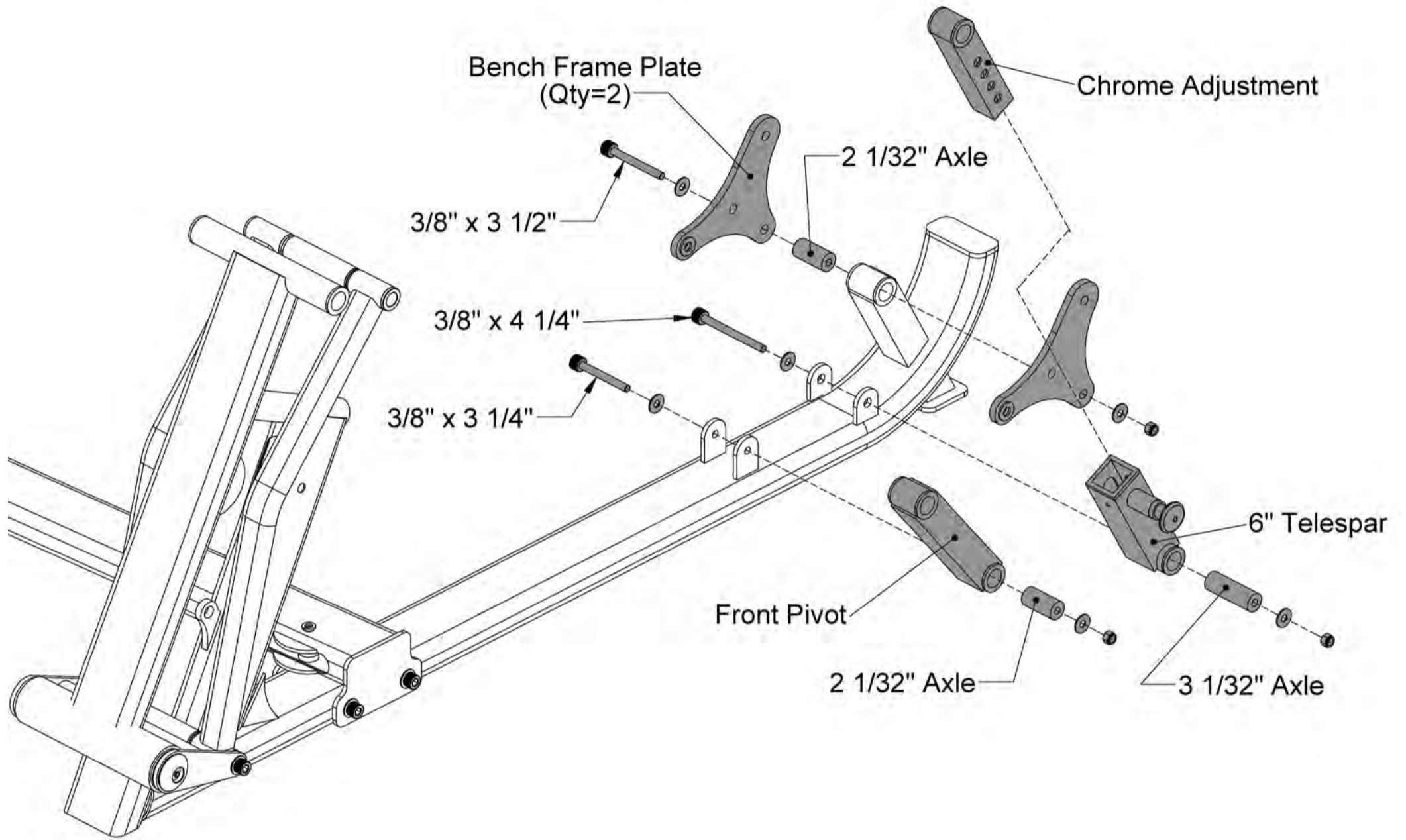


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

Part #	Description	Qty
BFM-10605rev1	Leg Press Frame	1
BFM-10575	Leg Press Connector	1
BFH-50146	3/8" Flat Washer (Black)	4
BFP-51756	SHCS 3/8"-16 X 5 1/4" P5	2
BFH-50157	3/8"-16 Nylock (Black)	2
BFP-10918	Four Bar	2
BFP-52029	Four Bar Spacer	2
BFP-10919	Leg Press Pivot Arm	1




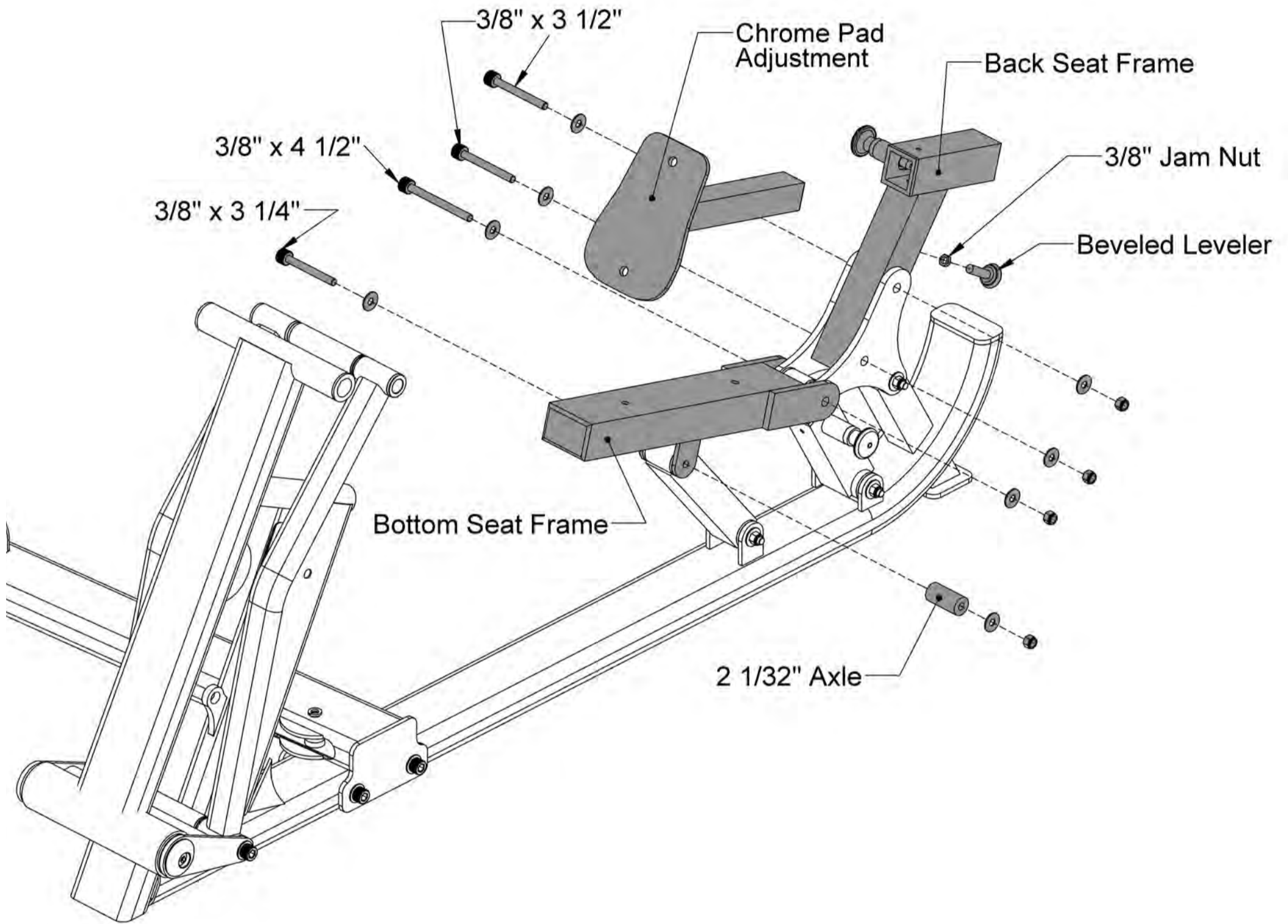
**Step 20:**  Note: This step may be pre-assembled



Part #	Description	Qty
BFM-51157	3 1/32" Axle	1
BFM-51155	2 1/32" Axle	2
BFM-10596	6" Telespar	1
BFL-50219	Bench Frame Plate	2
BFM-10595	Chrome Adjustment	1
BFM-51130	Front Pivot	1
BFH-50146	3/8" Flat Washer (Black)	6
BFP-51760	SHCS 3/8"-16 X 3 1/2"	1
BFP-51748	SHCS 3/8"-16 X 3 1/4"	1
BFP-51884	SHCS 3/8"-16 X 4 1/4"	1
BFH-50157	3/8"-16 Nylock (Black)	3

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

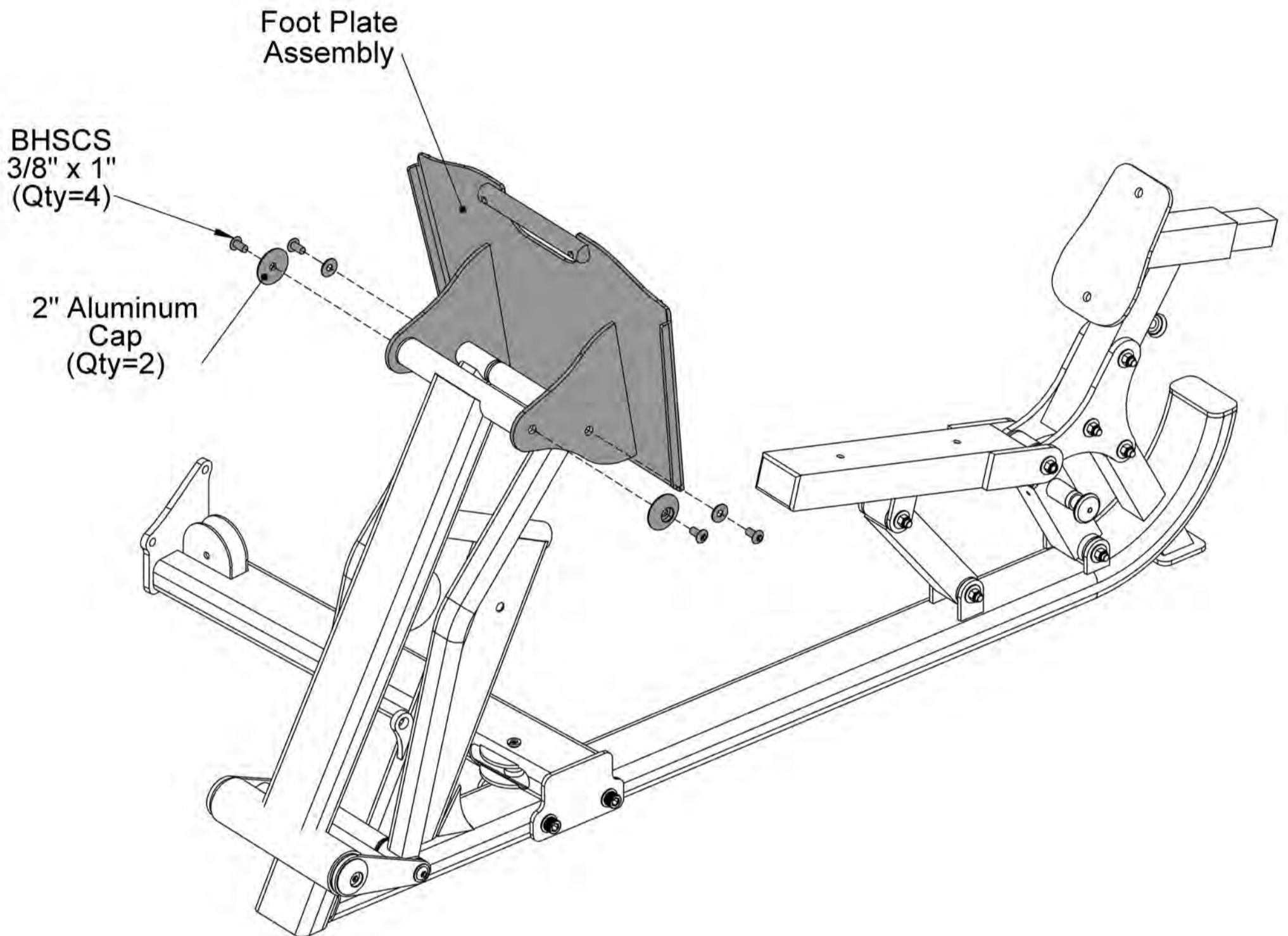
**Step 21:**  Note: This step may be pre-assembled



Part #	Description	Qty
BFM-51155	2 1/32" Axle	1
BFM-10598	Bottom Seat Frame	1
BFM-10106	Chrome Pad Adjustment	1
BFM-10597	Back Seat Frame	1
BFH-50146	3/8" Flat Washer (Black)	8
BFP-51760	SHCS 3/8"-16 X 3 1/2" P5	2
BFP-51751	SHCS 3/8"-16 X 4 1/2" P5	1
BFP-51748	SHCS 3/8"-16 X 3 1/4" P5	1
BFH-50149	3/8"-16 Jam Nut (Zinc)	1
BFH-50253	Beveled Leveler	1
BFH-50157	3/8"-16 Nylock (Black)	4

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

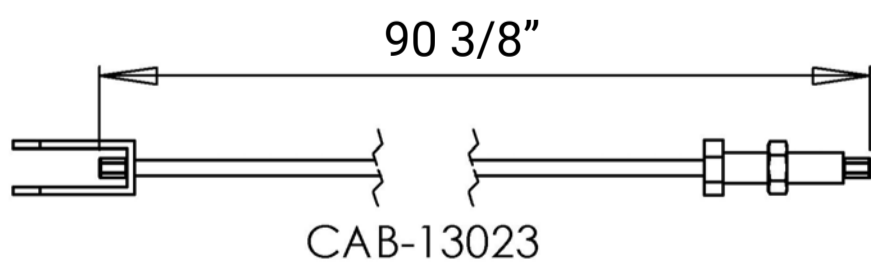
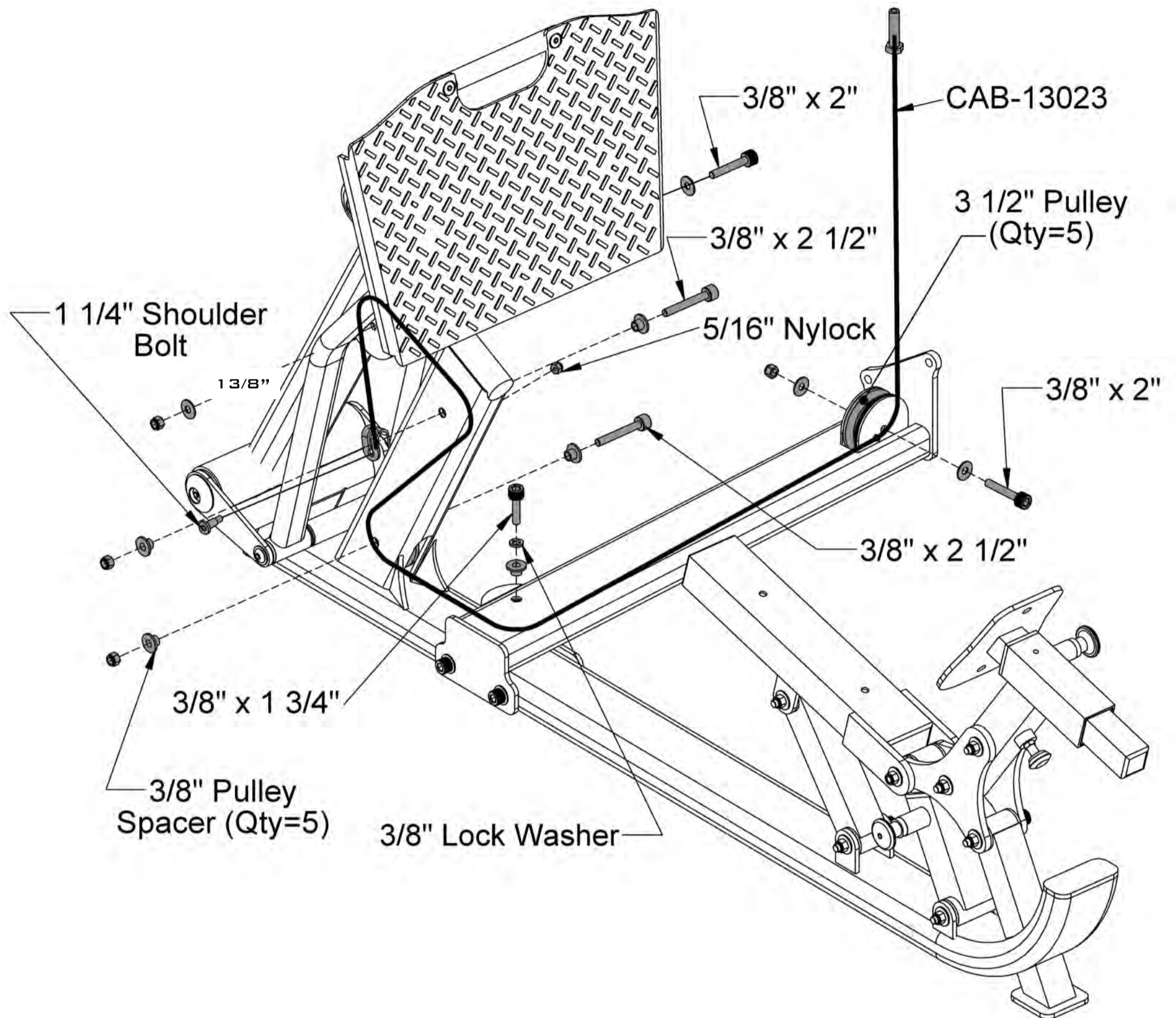
## Step 22:



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

Part #	Description	Qty
BFH-50146	3/8" Flat Washer (Black)	2
BFP-10916	Foot Plate Assembly	1
BFP-51696	2" Aluminum Cap	2
BFH-50620	BHSCS 3/8" x 1"	4

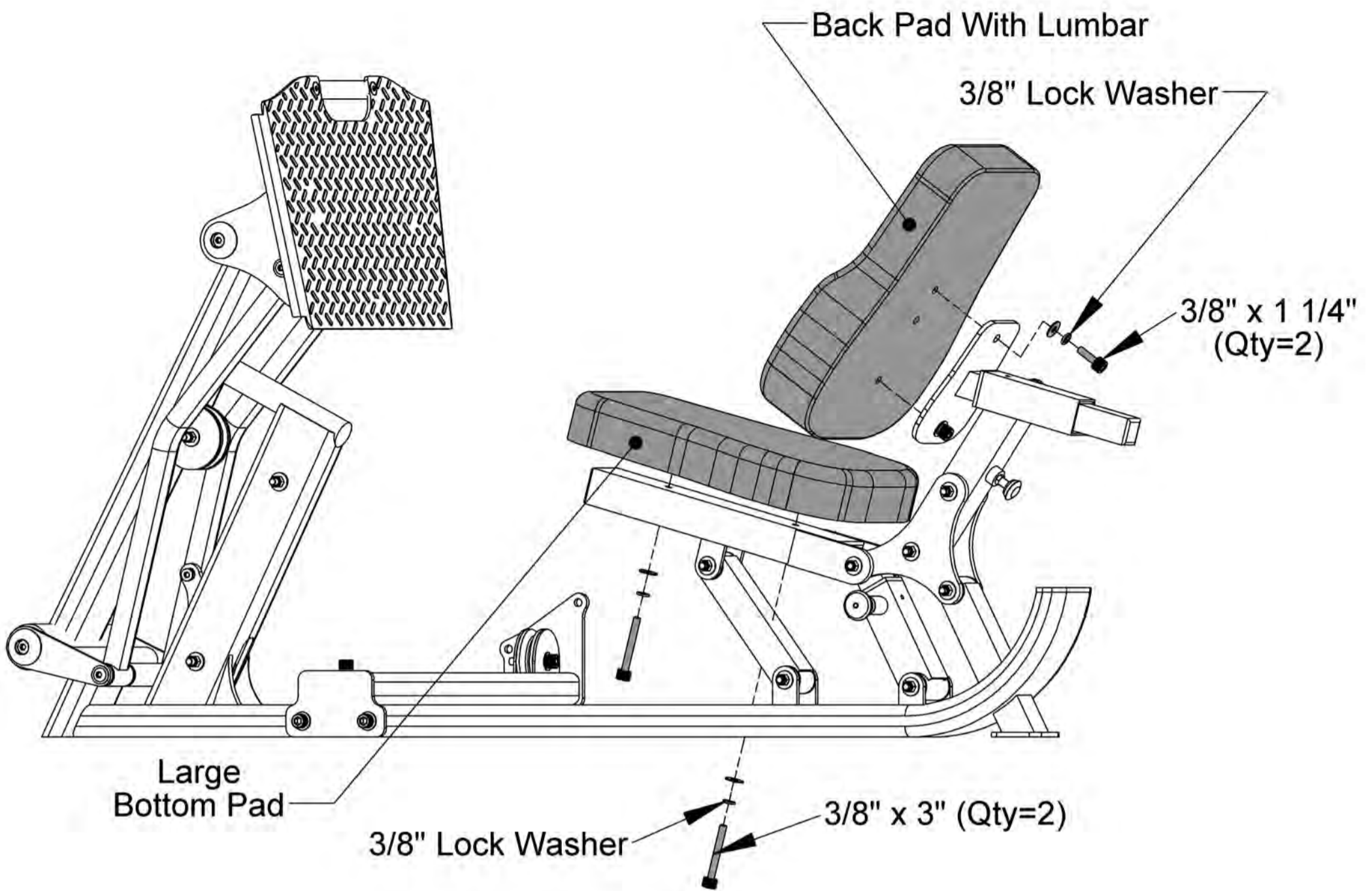
## Step 23:



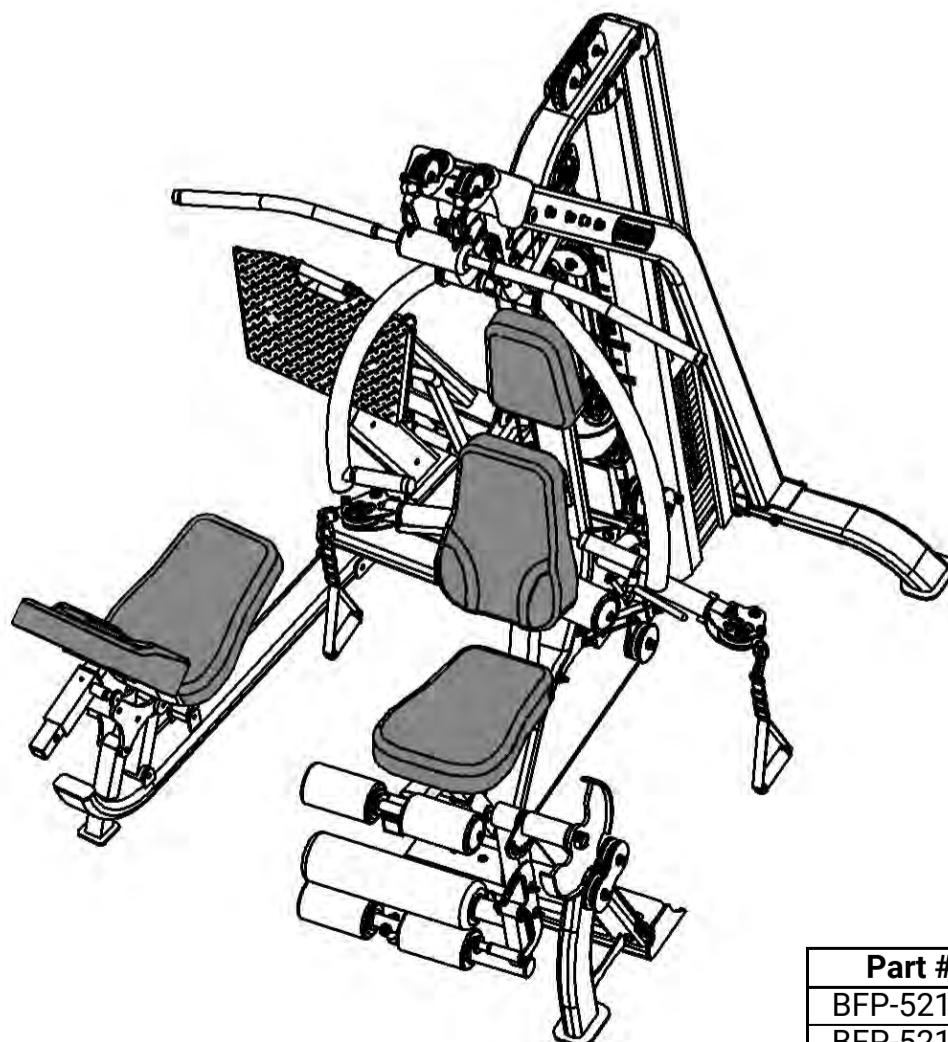
Part #	Description	Qty
BFH-50146	3/8" Flat Washer (Black)	4
BFH-50147	3/8" Lock Washer (Black)	1
BFH-50605	3/8" Pulley Spacer	5
BFP-52394	SHCS 3/8"-16 X 2 1/2"	2
BFP-52397	SHCS 3/8"-16 1 3/4" P5	1
BFP-51759	SHCS 3/8"-16 X 2" P5	2
BFH-50157	3/8"-16 Nylock (Black)	4
BFH-50173	3 1/2" Pulley	5
CAB-13023	Fusion Leg Press Cable	1
BFH-50351	1 3/8" Shoulder Bolt	1
BFH-50267	5/16"-18 Nylock (Black)	1

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

## Step 24:



**!** Please double check each pad for correct positioning and location. If the pads are not installed with the correct orientation and in the right location, it will directly effect the workout. Please especially make sure the seat pads for the leg extension/leg curl and for the leg press portion of the machine are turned the right way.

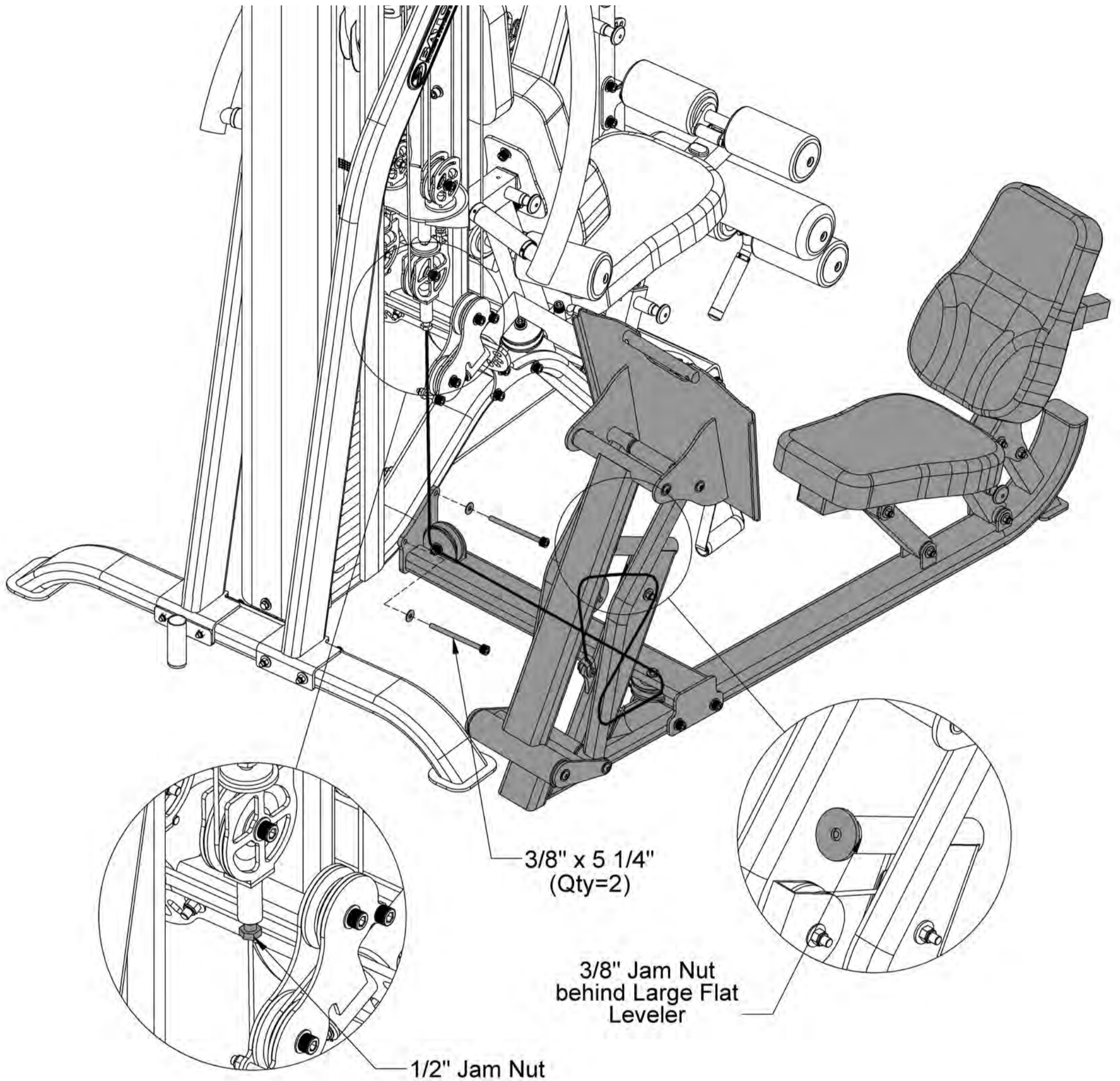


Part #	Description	Qty
BFP-52130	Large Bottom Pad	1
BFP-52136	Back Pad With Lumbar	1
BFH-50146	3/8" Flat Washer (Black)	4
BFH-50147	3/8" Lock Washer (Black)	4
BFP-51653	SHCS 3/8"-16 X 1 1/4"	2
BFP-51747	SHCS 3/8"-16 X 3" P5	2

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

## Step 25:

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

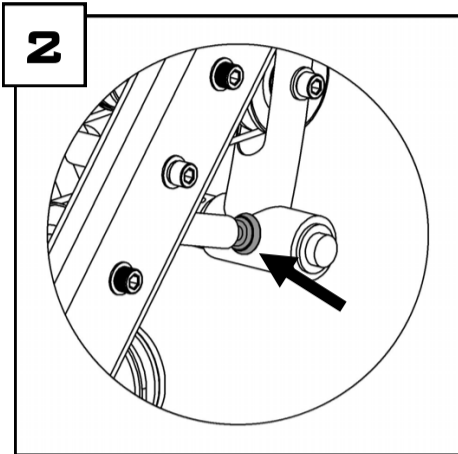


All Flat Washers and Nylocks are 3/8" unless otherwise noted.

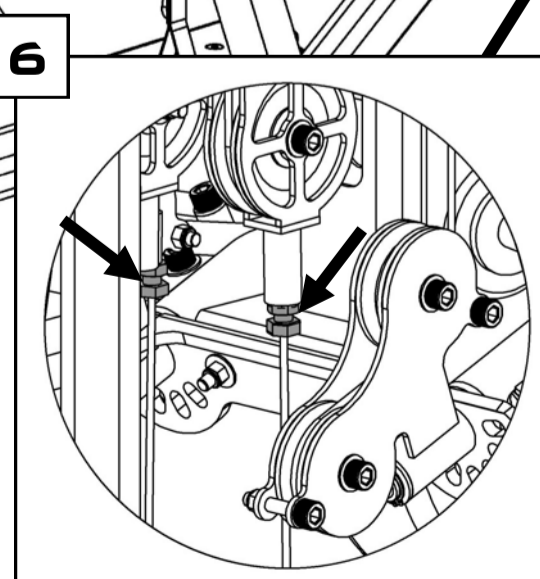
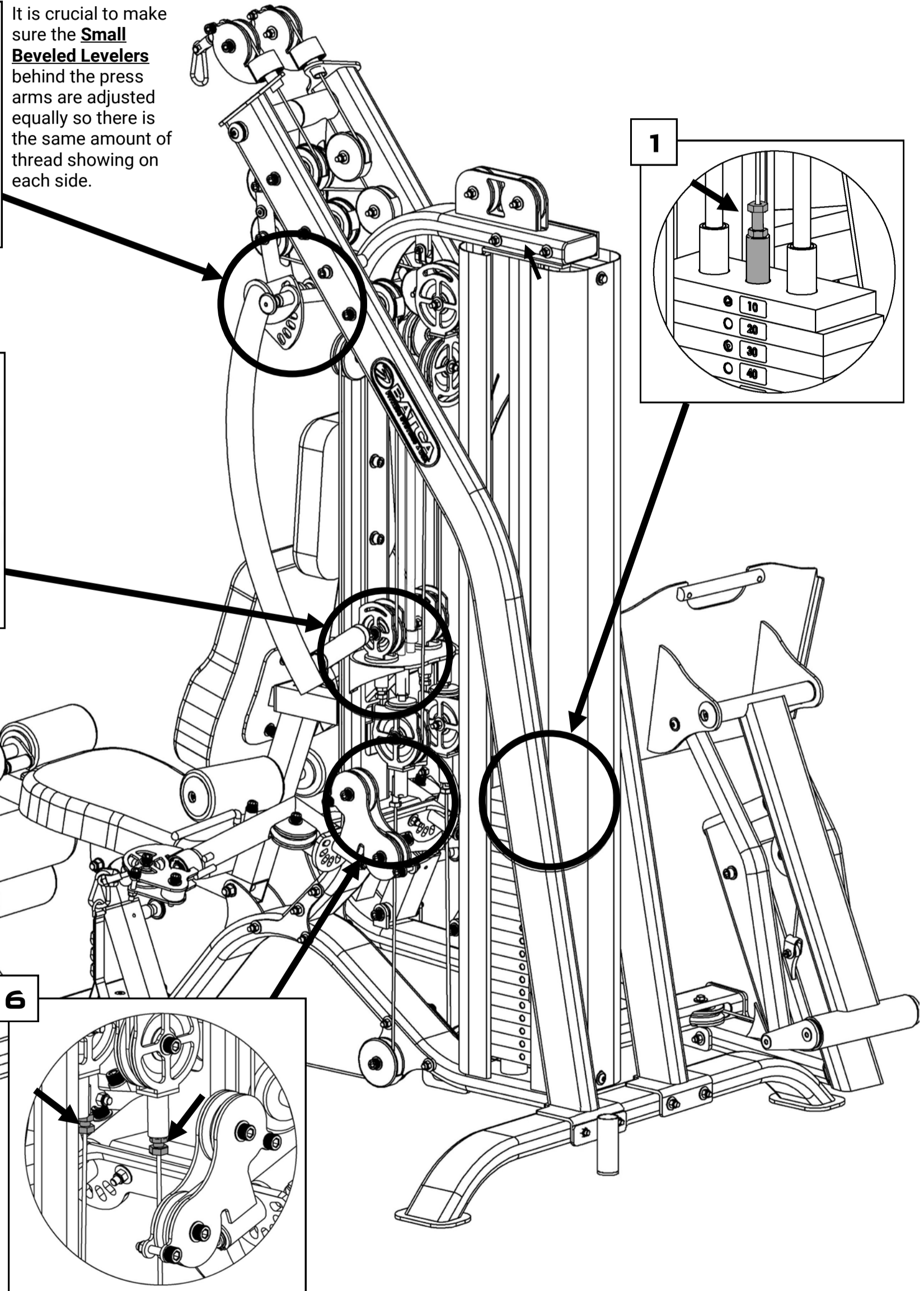
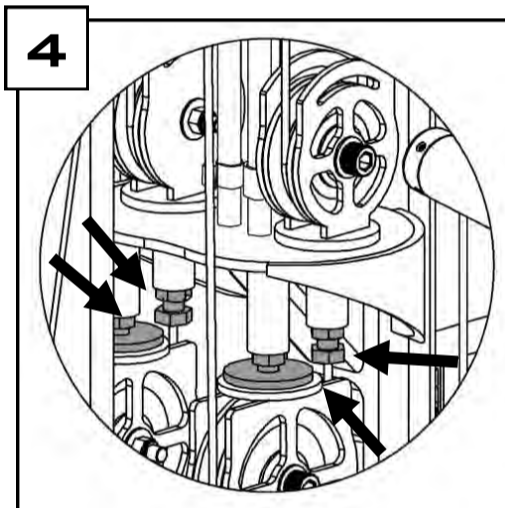
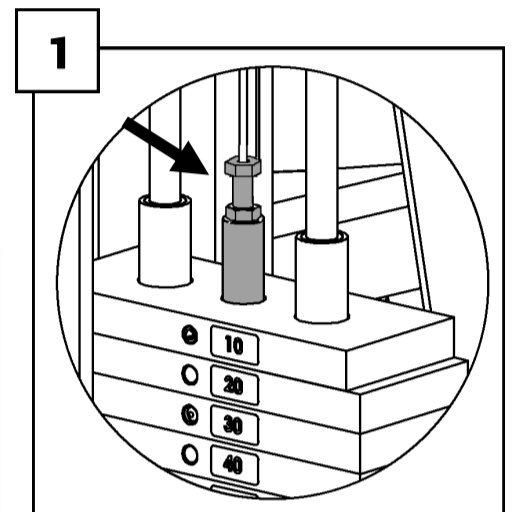
Part #	Description	Qty
BFH-50146	3/8" Flat Washer (Black)	4
BFH-50157	3/8"-16 Nylock (Black)	2
BFP-51756	SHCS 3/8"-16 X 5 1/4"	2
BFH-50256	1/2" Jam Nut	1
BFH-50149	3/8"-16 Jam Nut	1

# 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 27 and 28. 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.
- When adjusted properly, the adjustments in Figures 4, 5, and 6, on each side of the machine respectively should appear to have the same amount of threads screwed into their counterparts.
- **Note:** All Levelers and 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.

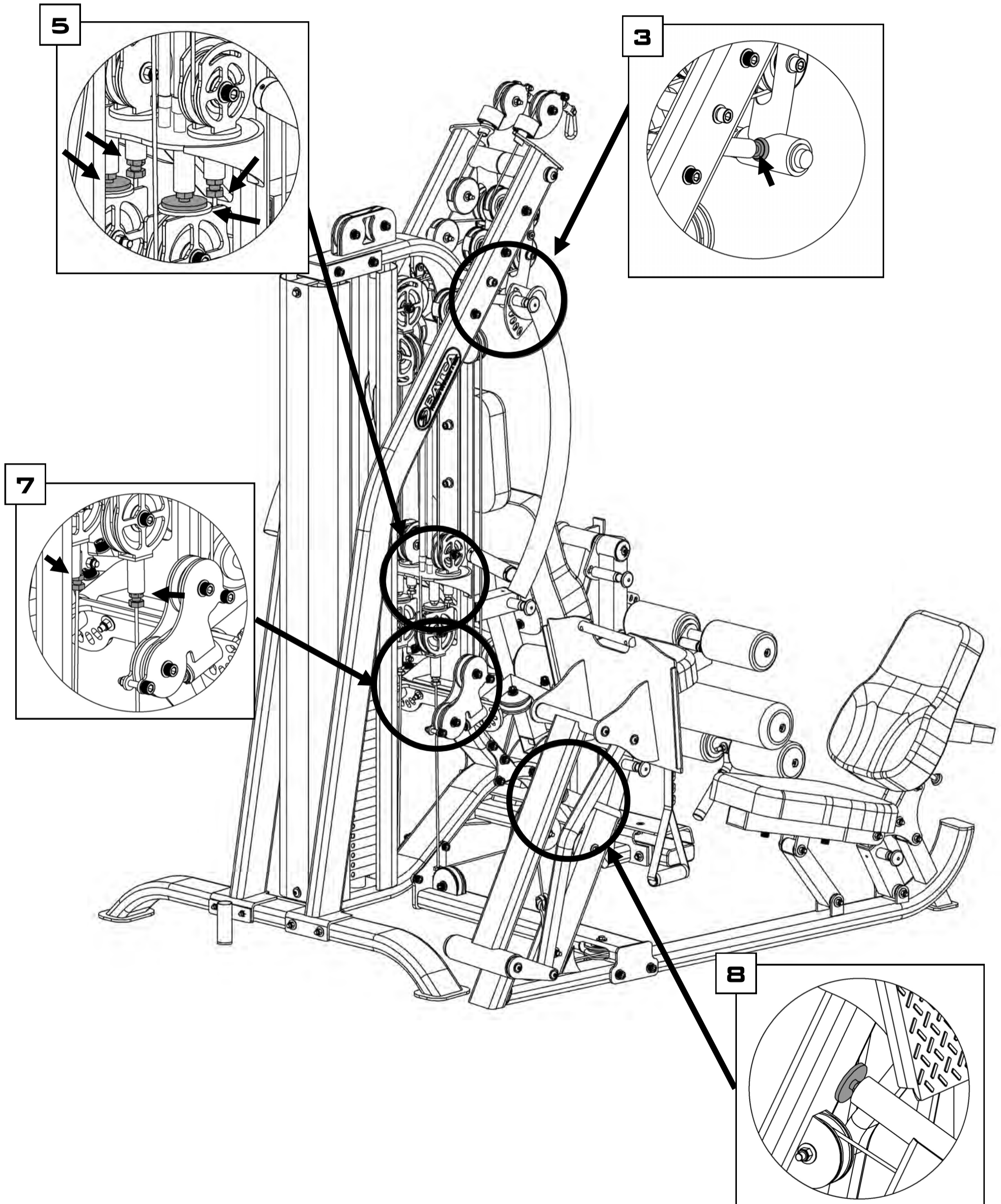


It is crucial to make sure the **Small Beveled Levelers** behind the press arms are adjusted equally so there is the same amount of thread showing on each side.



**ASSEMBLY TIP (Adjustments 4,5, and 6):** The adjustments for the four Free Floating Pulleys should be adjusted evenly on both sides of the cable system. The two Lower Free Floating Pulleys should be just barely underneath the large flat leveler and not pressed tightly against them. There should not be a large visible gap between the Lower Free Floating Pulleys and the large flat levelers. The Lower Free Floating Pulleys should engage the large flat levelers as soon as the upper body exercises are being used. The two Upper Free Floating Pulleys should also be barely above the central hub. There should not be a large visible gap between them. The Upper Free Floating Pulleys should engage the central hub as soon as the lower body exercises are being used. All the adjustments for this area of the machine should be the same as their counterpart on the opposite side of the cable system.

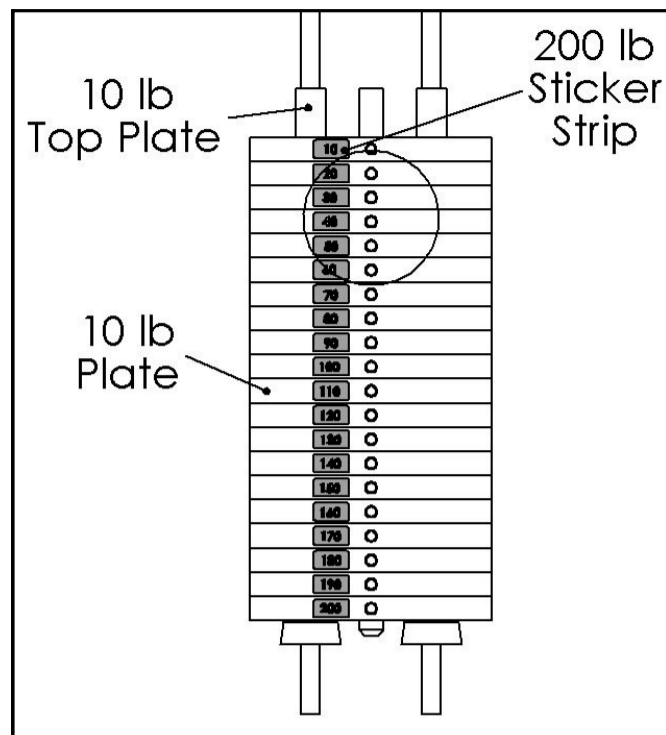
- Note: All levelers should have at least 1/2" of the threads threaded into its counterpart. It is very important that the 3/8" Jam Nut be wrench tightened to the counterpart to ensure that the leveler does not back out of the counterpart.



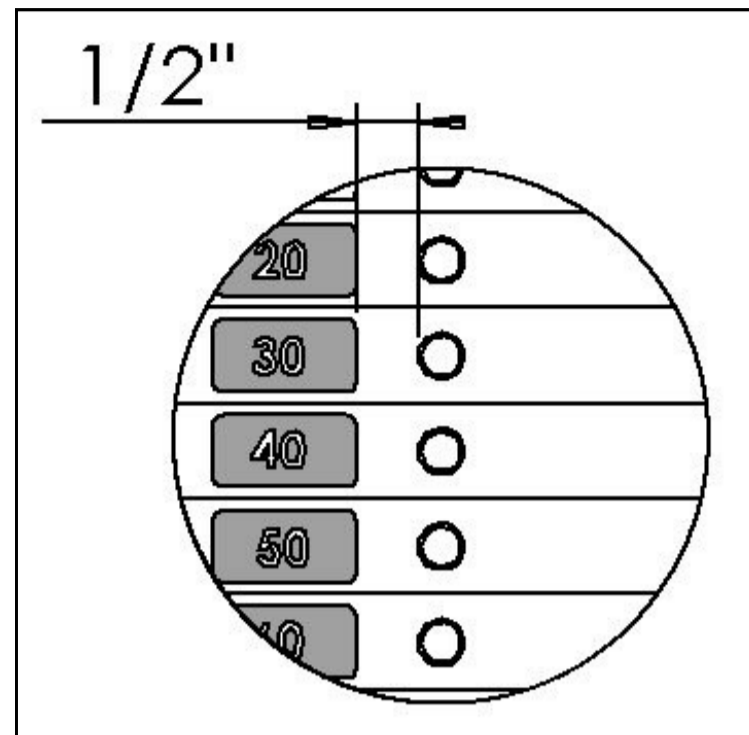


# Final Assembly and Troubleshooting

## Weight Stack Decals:



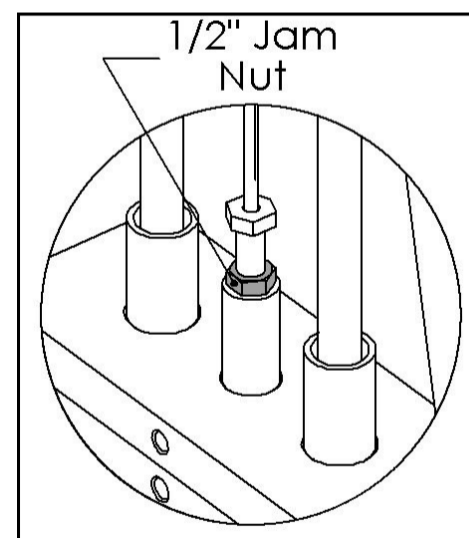
200lb Stack



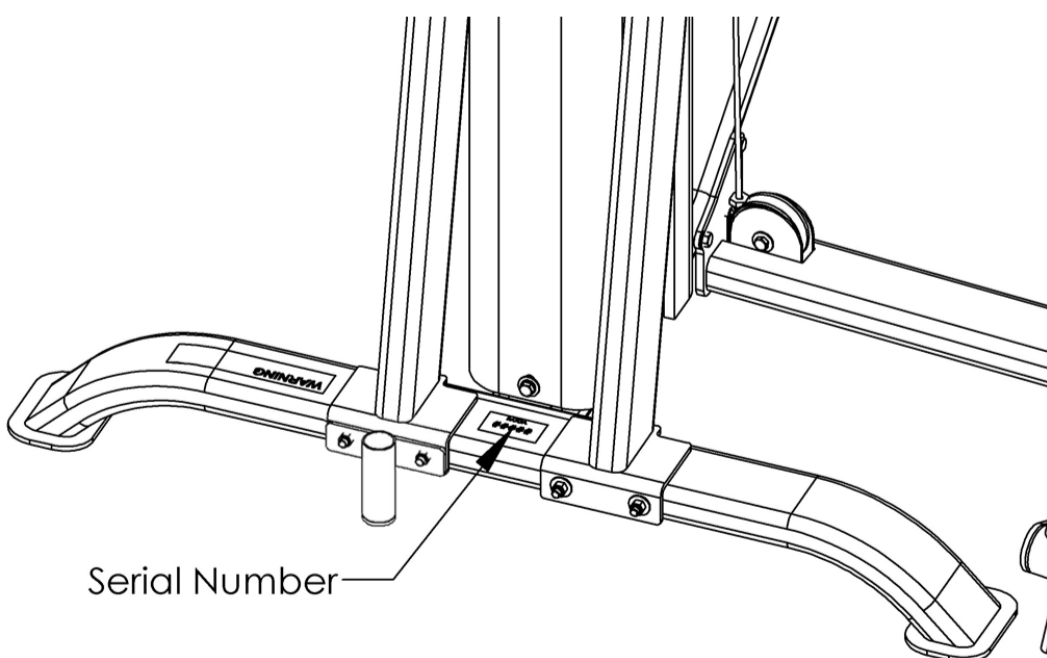
**!** The weight stack decals should be installed with a gap of 1/2" between the edge of the decals and the side of the holes for the weight stack pin. This spacing is critical because a larger gap between the decal and the center pin hole could result in the weight stack decals being covered by shrouds. It is helpful to use a 1" strip of painters tape to install the decals straight by lining up the edge of the piece of tape with the center of the hole in the plates and use the other side of the tape as a guide for applying the decals. The stacks shown in the diagram above are our standard 200 lb weight stacks where all 20 plates are 10lbs. The decals used for the standard weight stack should be labeled 10-200. If the medical 175 lb weight stacks were purchased, the top five plates will be 5 lbs. The decals used for the medical weight stacks should be labeled 5-175 and are typically packaged with the weight stacks themselves.

## IMPORTANT - Check These Components Before Using Gym:

- 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.



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.

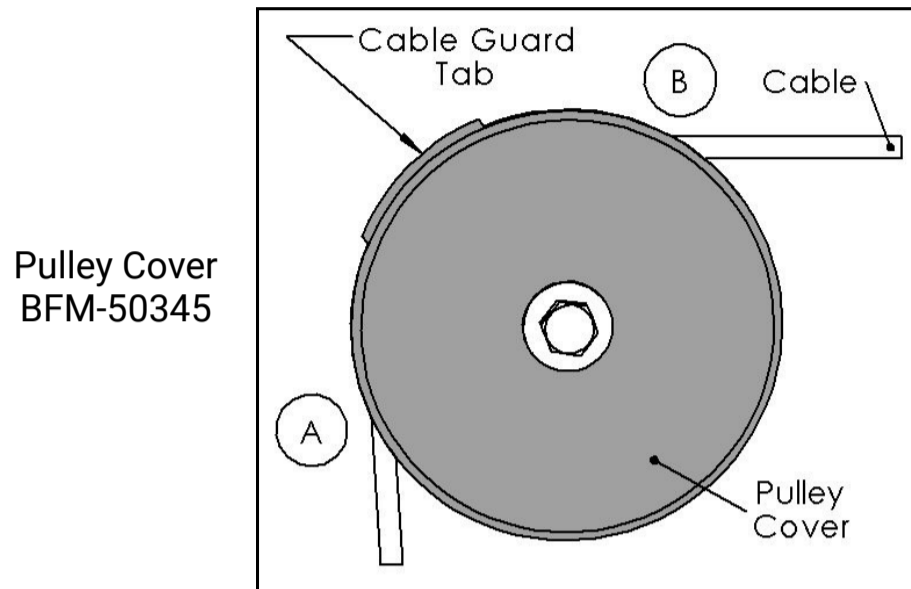
## Guide Rod

- 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.

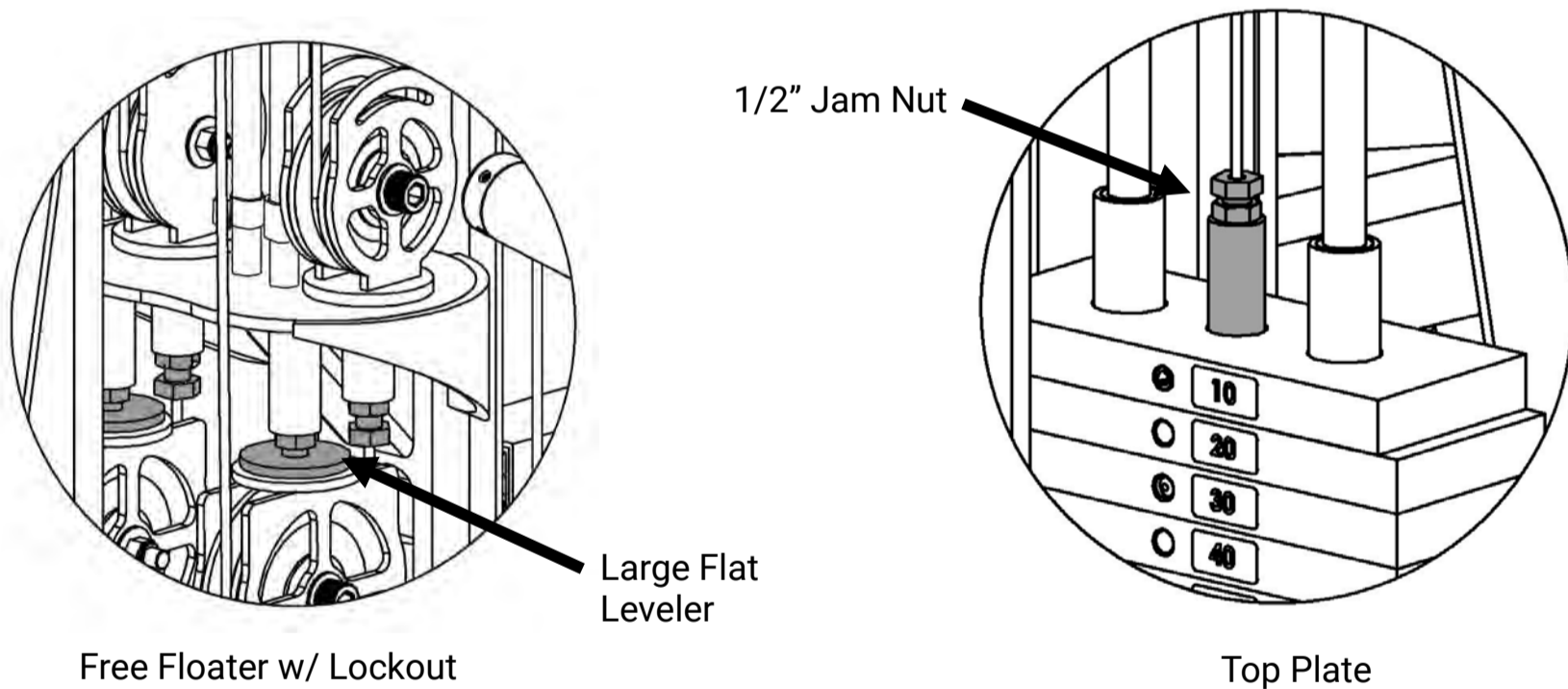
# Final Assembly and Troubleshooting

## **IMPORTANT - Check These Components Before Using Gym:**

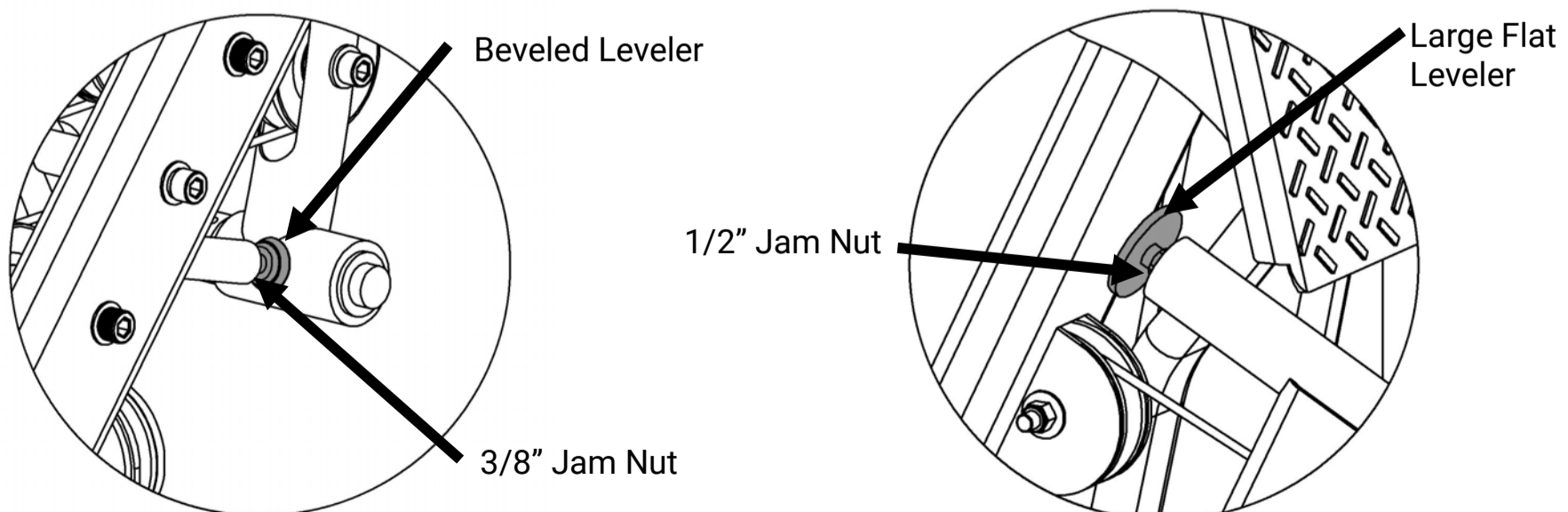
- **Position** the cable guard tab on the Pulley Cover so that the tab prevents the cable from coming out of its track on the 3 1/2" Pulley. An example of this positioning can be seen in the figure to the right. The cable guard tab should be positioned so that it is in the middle of the cable wrap on 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 14, 15, and 16.



- 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 10-15 and 24. See Figures below.



- 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, 14-15, and 22. 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.

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					1

# 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.

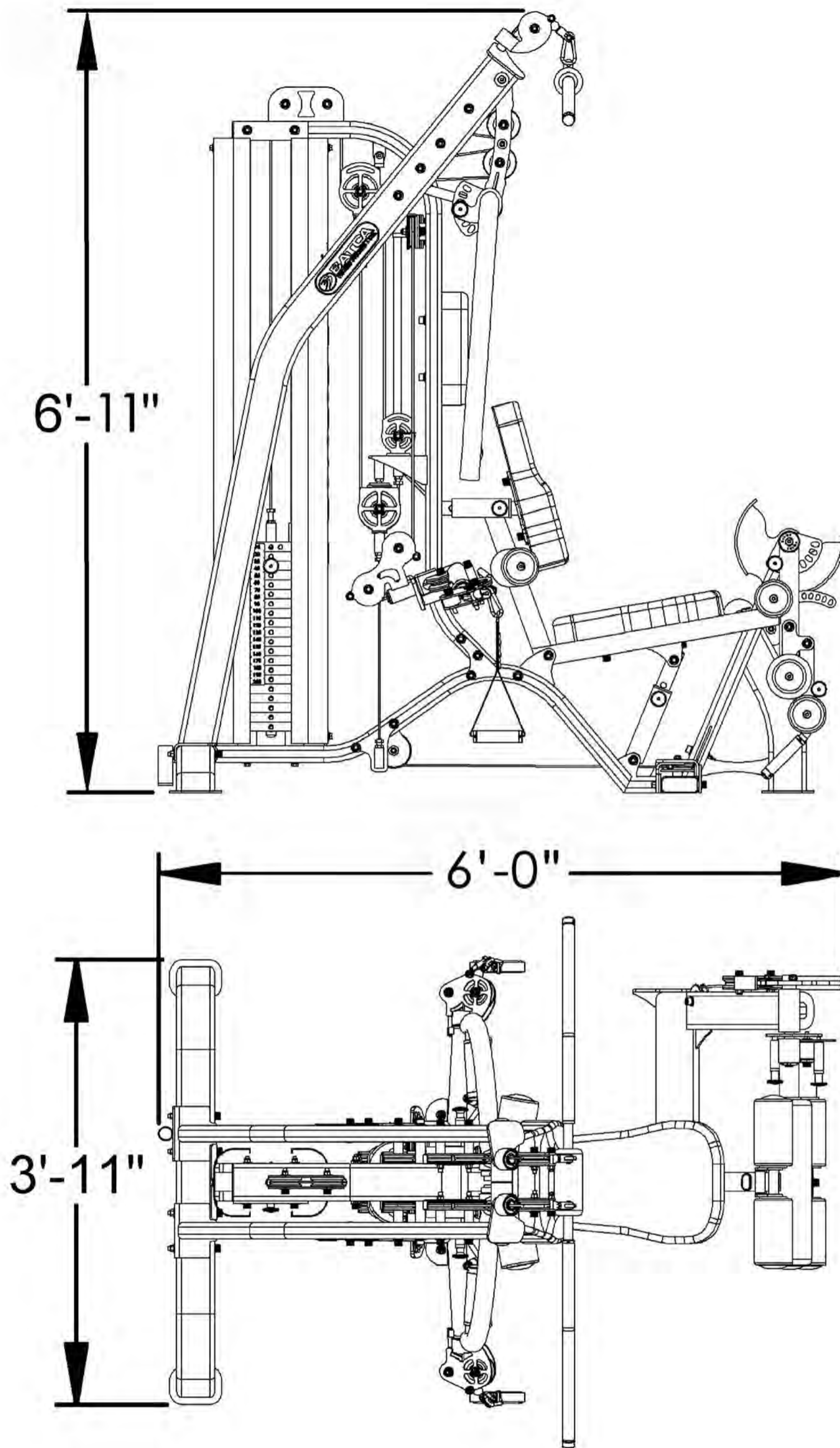
Batca Fitness Systems  
1207 N. New Hope Road  
Raleigh, NC 27610  
(919) 255-1233

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

Please keep this for your records.

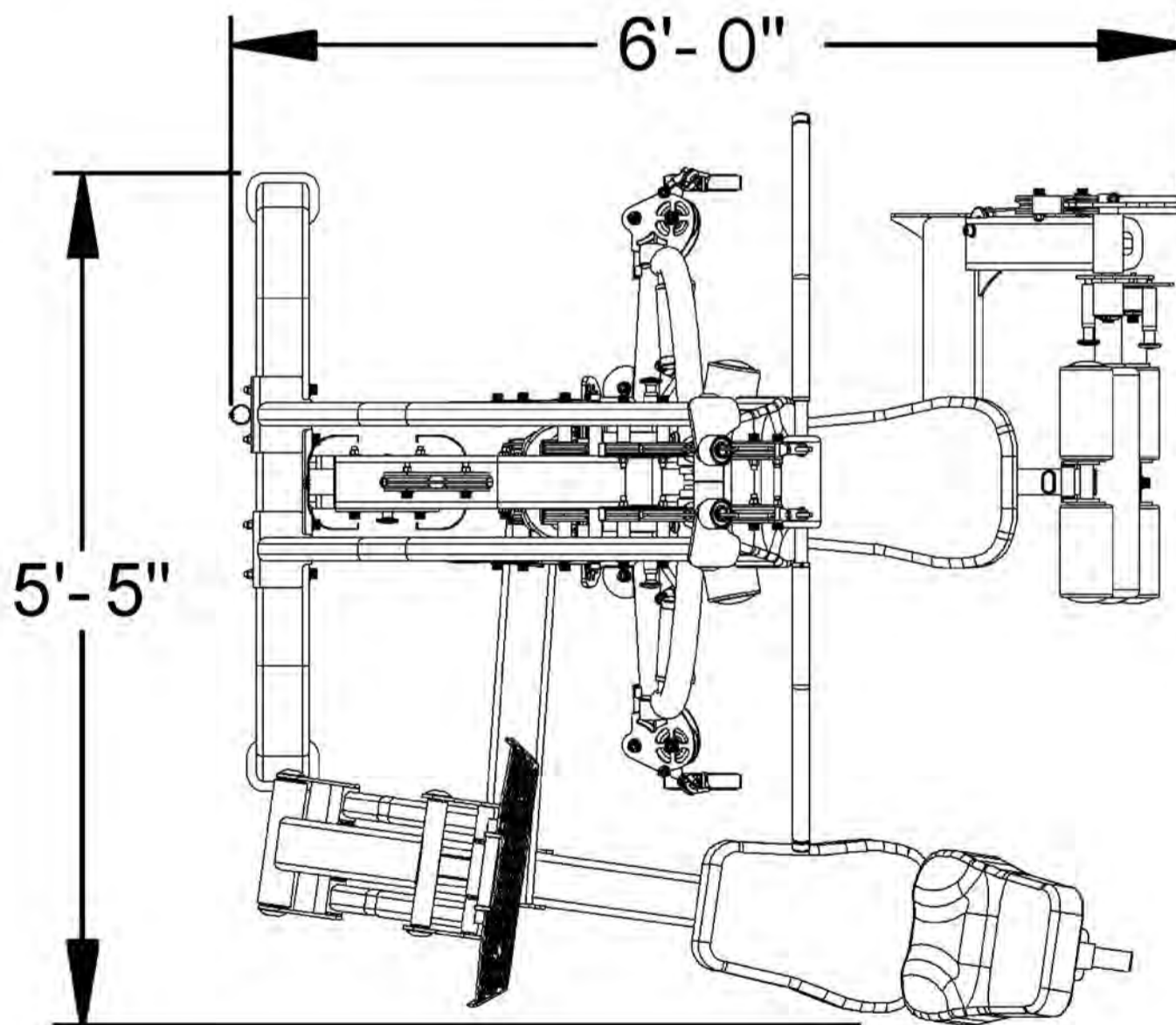
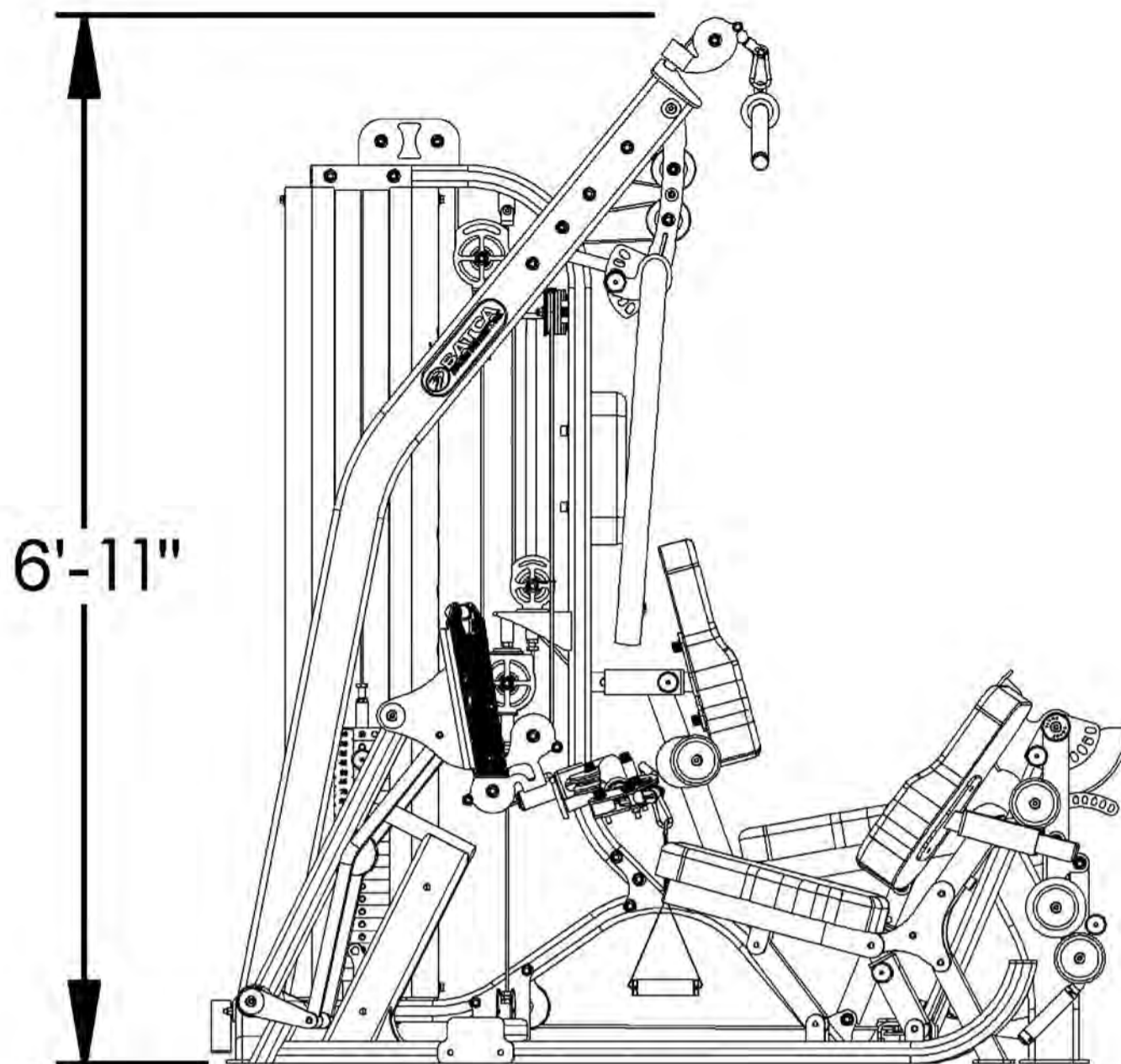


Scan the QR Code to  
register your new  
BATCA Product online!



### Layout Diagram without Leg Press

The Fusion without Leg Press has a layout dimension of 3'-11" (width) x 6'-0" (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 6'-0" (length) x 6'-11" (height). There should be a minimum of 18", preferably 24", of working space around the entire unit.