

Assembly Parts Lists

Part number information in the following table is meant to help you identify the parts in the drawings. They are not intended for use in ordering replacement parts. To order replacement parts, refer to Appendix C.

Table 5-1. Part Identifier List

Part #:	Description:	Qty:
10011-070	Decal, Ground	1
12497	Contact Plate, CHR	4
12506	Adhesive Transfer Tape, 5 MIL	4
22016	Screw, .375-16x2.50 Hex Hd Cap	3
22027	Washer, Split Lock .250	8
22077	.375 Nut, Hex	2
22160	Screw, #6 x.38 Thread Forming Phillips	1
22845	Washer, 1 1/4 x 17/32	4
22878	Screw, Set 0.25-28x0.375	2
23729	Washer, Split Lock 3/8	3
27068	Bracket, Actuator	1
27069	Assembly, Bracket, Actuator	1
27300	Felt, Adhesive-Backed	6
27350	Decal, StairMaster Right, 2100	1
27351	Decal, StairMaster Left, 2100	1
27377	Washer, M8, Flat Stainless	16
27378	Washer, M6, Flat Stainless	4
27379	M8 x 1.25 x 16 Button Head	10
27386	Assembly, Cable C50 ErgoBar	1
27388	Flywheel, Cast	1
27410	Plate, Motor Mounting	1
27415	Plug, Hole, Rib-Lock	2
27417	Roller Assembly, Drive	1
27424	Block, Grade Nut	1
27425	Support, Grade Weldment, Machined	2
27426	Assembly, Nutplate, Foot	2
27430	Bracket Assembly, Tensioner	1
27436	Guard, Foot	1
27441	Washer, Shoulder Isolation	4
27443	Bushing Spanner	2
27444	Bushing Shoulder	2
27458	Drive Belt, Poly-V	1
27467	Pulley Assembly, Rear	1
27469	Retainer Cover	14
27477	Hood	1

Part #:	Description:	Qty:
27478	Cover Trim, Front	1
27485	Weldment, Grade	1
27487	Drive Motor, AC Variable	1
27488	Assembly, VSD, 2100	1
27489	Plug, 1.50 Sheet Metal	2
27490	Weldment, Upright	1
27535	Bed, Slider, 612/2100	1
27536	Extrusion, Sldewall Cover	2
27537	M3 x .50 x 12 Screw, Sem, PHP, Ext Star	12
27540	Washer, M3, Flat, Zinc Plated	6
27541	Bushing, Bronze	2
27542	M6 x1.0 x 16 Button Head	10
27543	Compression Mount, Long	10
27544	Compression Mount, Deck	8
27551	Wheel, Polyoefin	2
27552	Rotary Tensioner	1
27556	Bushing, Grade Adjust	2
27559	M8 x 1.25 x 70 Button Head	8
27561	M8 x 1.25 Hex Nut	6
27562	Washer, .490 x 1.063 x .093, Neoprene	8
27563	M8 x 1.25 x 60 Hex Head Cap	8
27564	Washer, M8, Flat Fender, Zinc Plated	18
27565	Washer, M6, Flat, Black Oxide	2
27566	Washer, M6, Split Lock Black	2
27567	M6 x 1.0 x 16, Button Head Black	2
27568	Washer, M8, Flat, Black Oxide	2
27569	M8 x 1.25 .90 Hex Head Cap, Black	2
27570	Clamp, VSD Board	1
27571	Pad, VSD Clamp	1
27573	Nut, M5 x 0.8 Hex	2
27574	M5 x 0.80 x 50 Hex Head Cap	2
27575	Washer, M6 Flat, Wide Zinc Plated	16
27576	M6 x 1.00 x 35 Hex Head Cap	14
27577	M6 x 1.00 x16 Hex Head Cap	4
27578	Washer, M6 Split Lock	8

Part #:	Description:	Qty:
27579	Washer, M6, Flat Zinc Plated	2
27582	Rivet, .1875 Dia x .375 Grip, Black	14
27583	Guide Wire .500	10
27585	Washer, .406 x 1.25 x .047 Steel Zinc	5
27586	Spacer Nylon	4
27587	Washer, M10 Flat Zinc Plated	4
27588	Washer, M10 Split Lock	4
27590	M8 x 1.25 x 20 Hex Head Cap	28
27591	Washer, M8, Flat Zinc Plated	36
27592	Washer m8 Split Lock	64
27593	M8 x 1.25 .25 Hex Head Cap	10
27594	.25-20 x .75 Thread Cutting, Hex Washer Hd	8
27595	Plate, Grade Nut Block, Mounting	1
27601	Insert, Threaded, Metric 6MM	18
27602	Insert, Treaded, Metric 8MM	6
27605	M10 x 1.50 x 30 Hex Head Cap	4
27612	Screw M3 x 0.5 x 10, Self Tapping Pan Hd Torx	6
27631	Housing ErgoBar, Left Upper	1
27632	Housing ErgoBar, Left Lower	1
27633	Housing ErgoBar, Right Upper	1
27634	Housing ErgoBar, Right Lower	1
27640	Belt, Walking	1
27641	Wire Harness, Contact Heart Rate	1
27646	Machined Extrusion Right Hand	1
27647	Machined Extrusion Left Hand	1
27648	Assembly, Endcap, Siderail Left	1

Part #:	Description:	Qty:
27649	Assembly, EndCap, Siderail Right	1
27650	Weldment, Rear Frame Support	1
27654	Leveling Pad (.500-13 UNC-2A x 1.88 BASE)	2
27660	Assembly, Upright Support RH	1
27665	PCBA, ErgoBar	1
27666	Grill, Front Cover	1
27675	Assembly, Retainer, Front Roller Shaft	2
27676	Spacer, Soft Deck	2
27677	Siderail, Stiffner Assembly LH	1
27678	Siderail, Stiffner Assembly RH	1
27679	Assembly, Upright Support LH	1
27680	Housing ErgoBar Mid Upper	1
27681	Housing ErgoBar Mid Lower	1
27682	Logo, StairMaster	1
27684	Weldment, Controller Support	1
27689	Steel Headframe Assembly	1
27764	Screw, Thread Forming #6-32 x .375	4
27903	Decal, Magnetic Switch 2100	1
27912	Keypanel, ErgoBar	1
27951	Assembly Cable, Lower C50 Comm	1
27952	Assembly Cable, Upper C50 Comm	1
27959	Assembly Config Cable	1
28390	EndCap, Round 2"	2
35901-033	M6 x 1.00 x 16 Hex Head Cap	2
36209	Insert, Threaded, Metric, 6MM	4

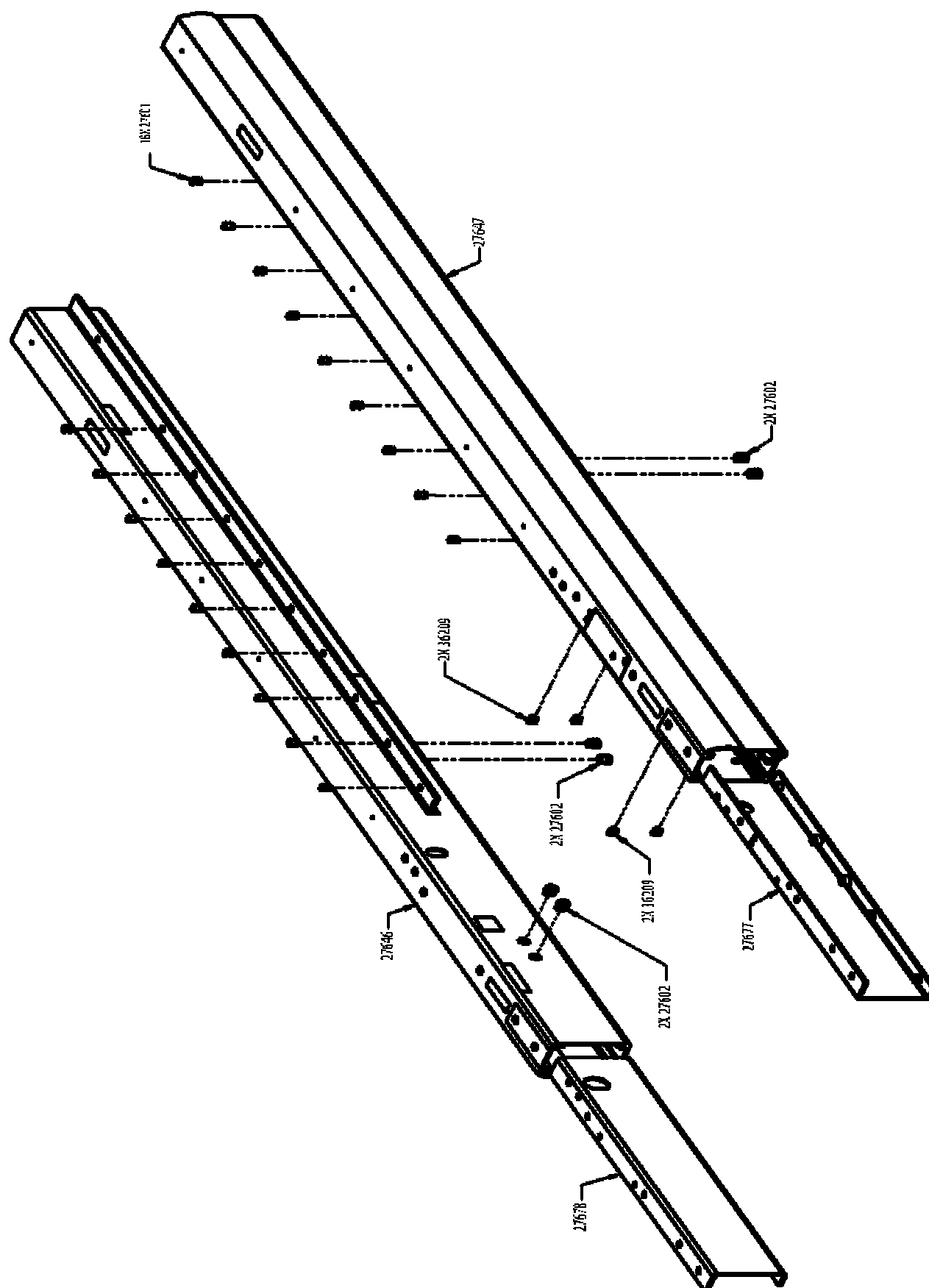
Assembly Drawings Overview

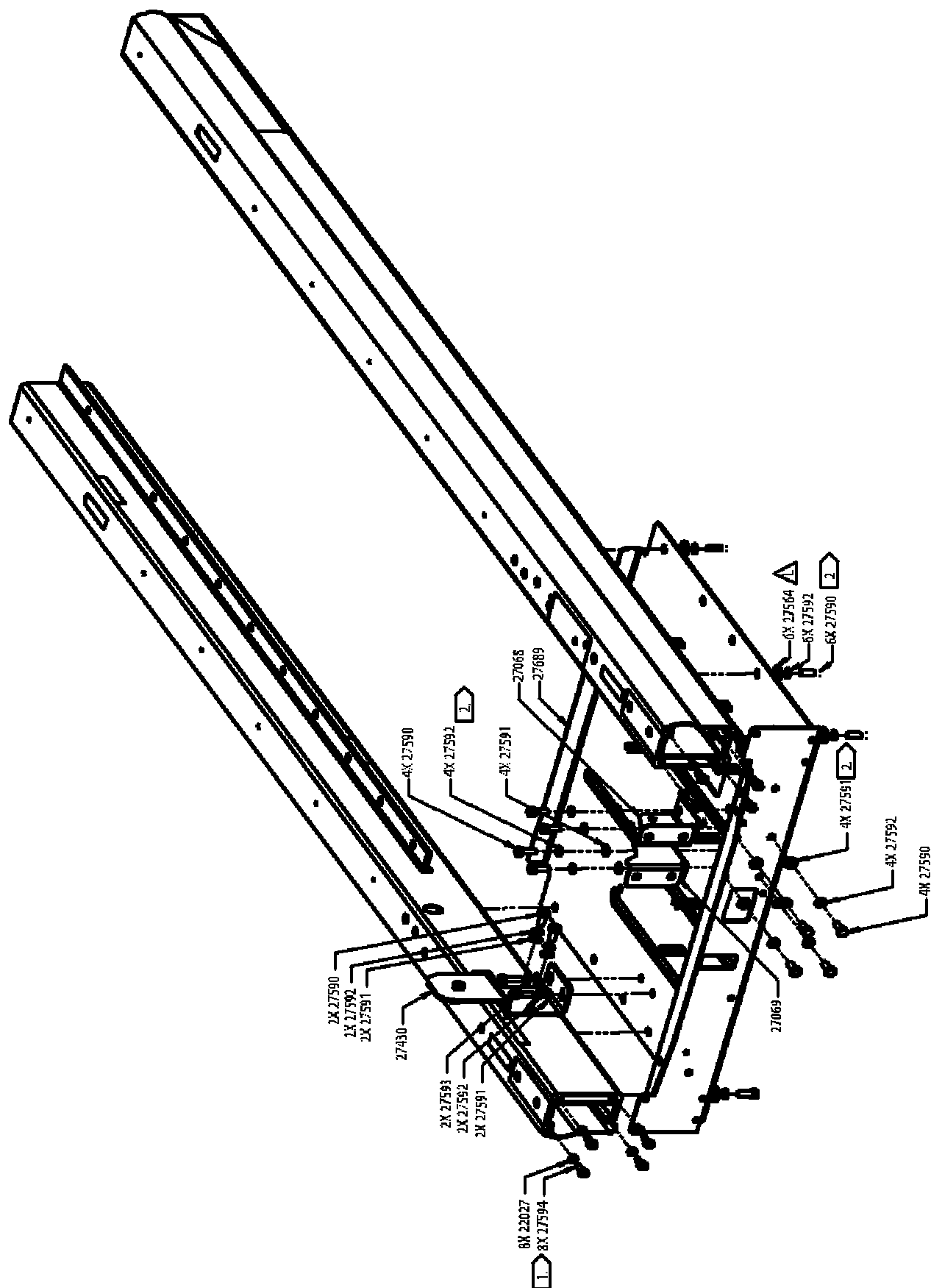
The information in the table below refers to specific notes, represented by  found on the drawings in the section. Refer to these notes when replacing parts because they mention critical torque specs.

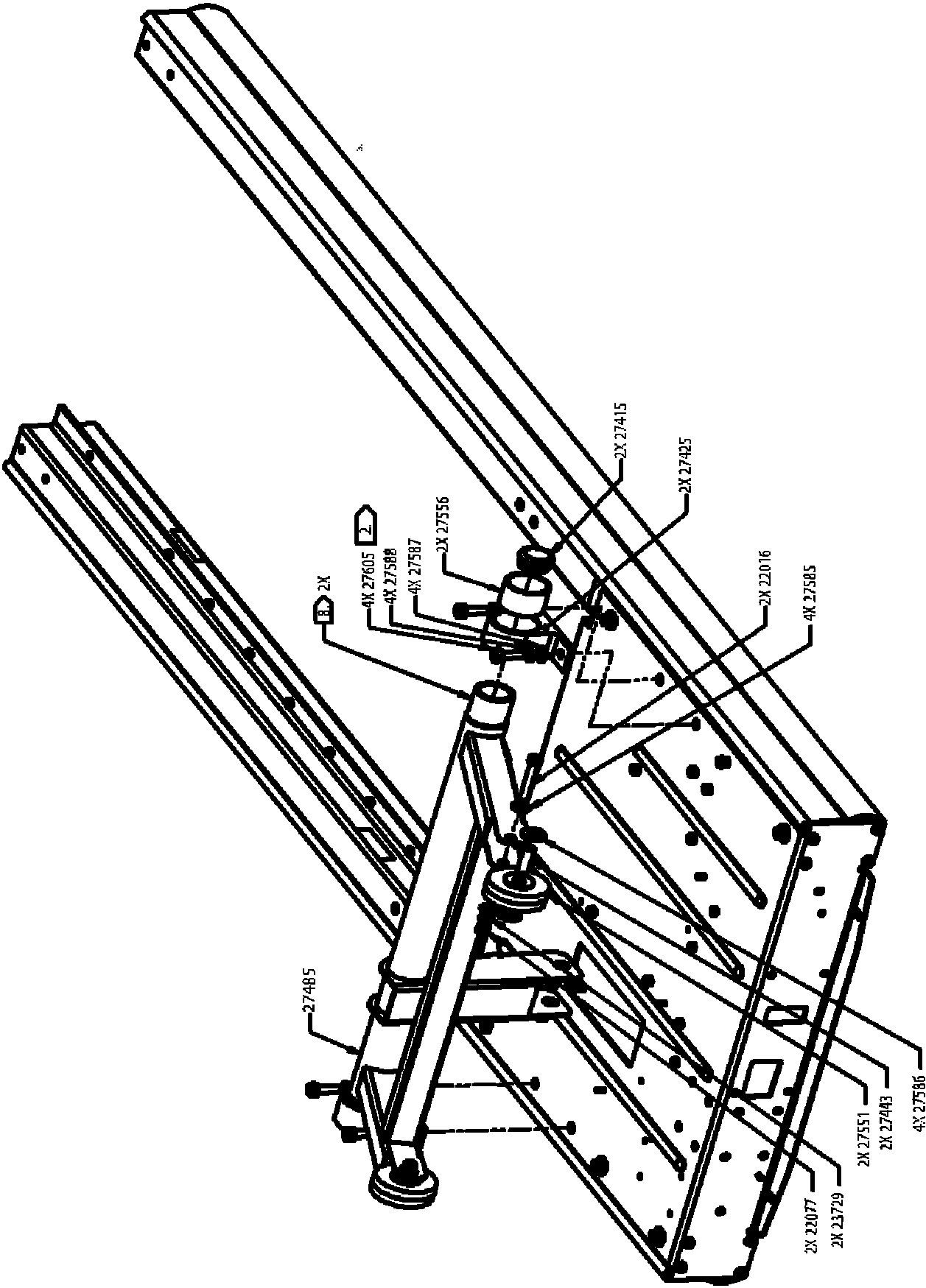
The symbol  throughout the drawings refers to the assembly revision.

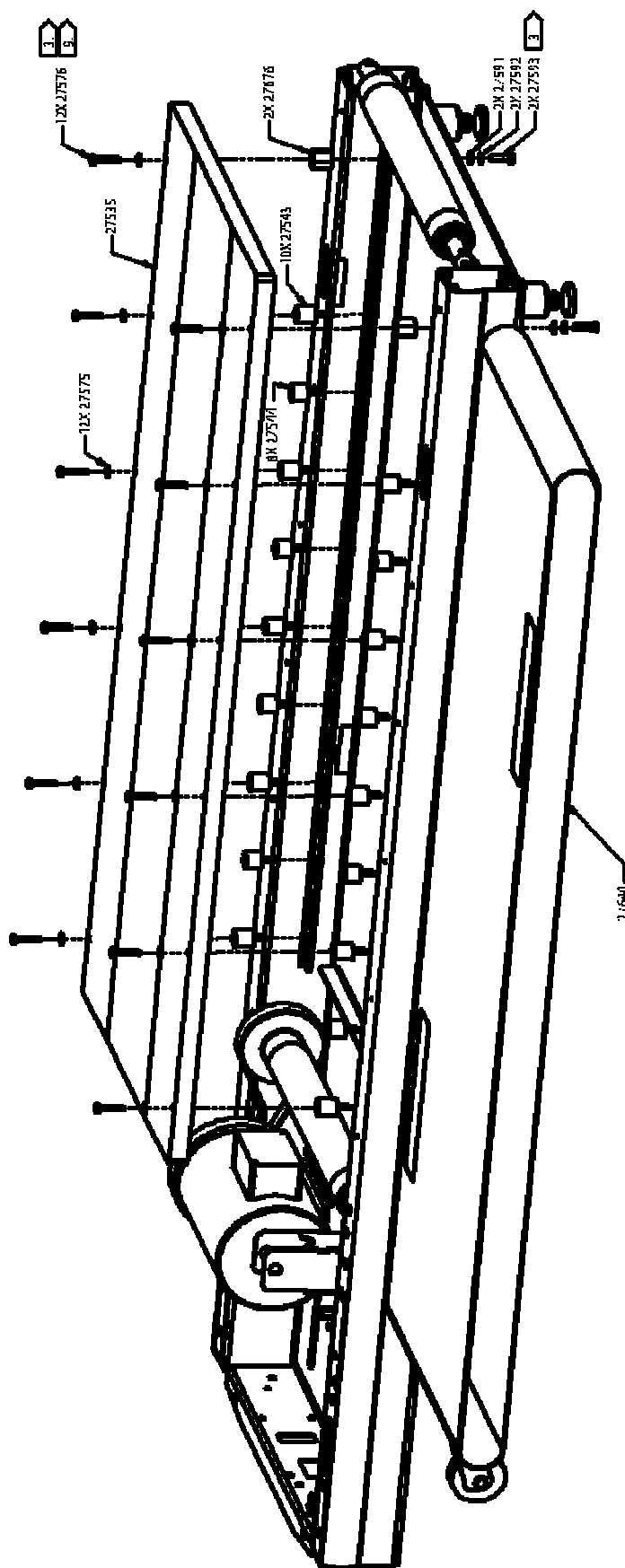
Table 5–2. Notes Pertaining to Assembly Drawings

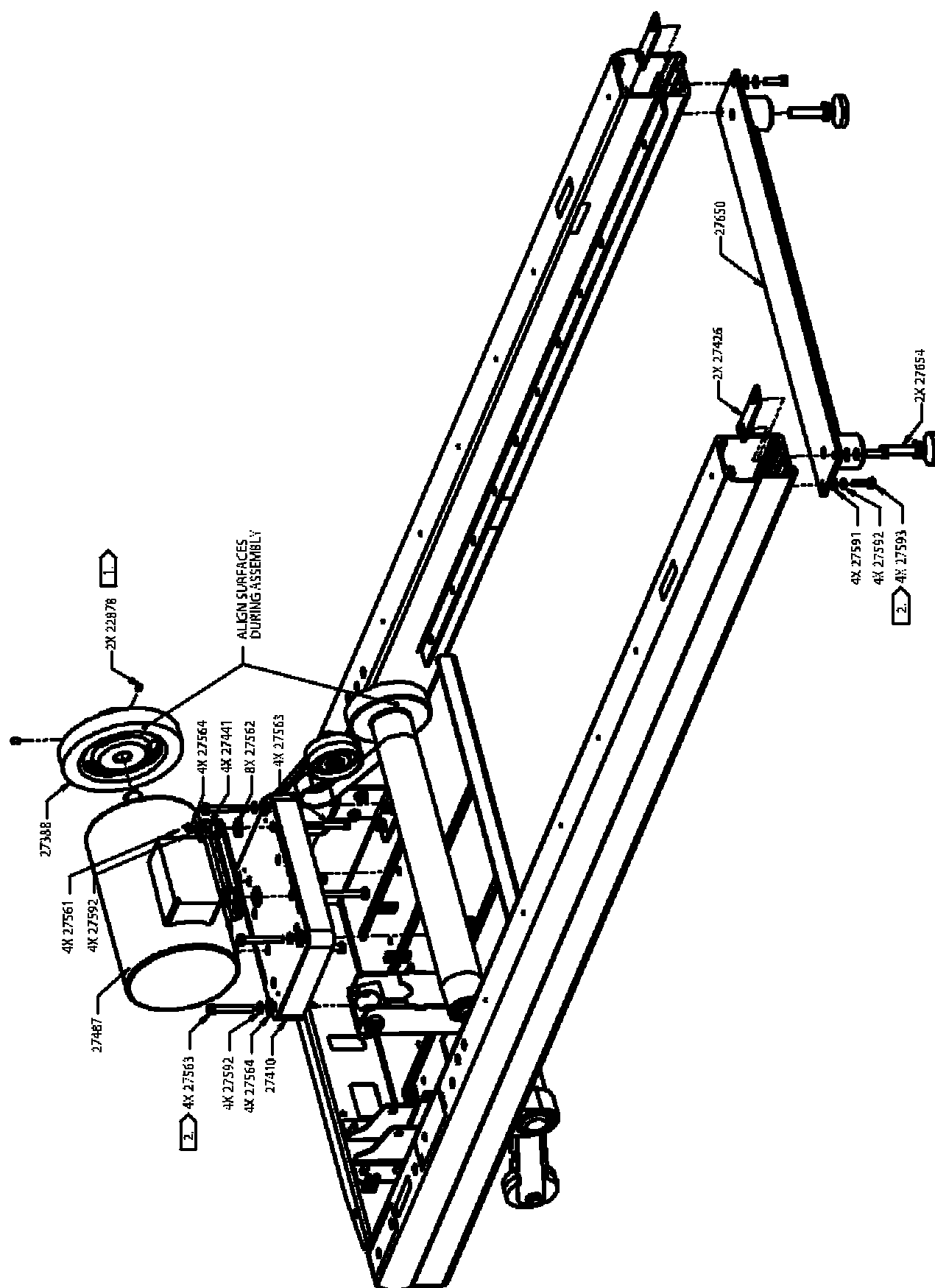
Note No.	Note
1.	Torque fastener to 70 inch pounds (8 Nm).
2.	Torque fastener to 188 inch pounds (21 Nm).
3.	Torque fastener to 35 inch pounds (4 Nm).
4.	Torque fastener to 240 inch pounds (27 Nm).
5.	Torque fastener to 10 inch pounds (1 Nm).
6.	Torque fastener to 44 inch pounds (5 Nm).
7.	Torque fastener to 16 inch pounds (9 Nm).
8.	Apply grease to the surface before assembly.
9.	Apply Hemon 423 to the threads before assembly.
10.	Torque fastener to 60 inch pounds (7 Nm).
11.	Torque fastener to 30 inch pounds (3 Nm).
12.	Cut to 2 inch (5 cm). Apply to top center EndCap rib
13.	Apply Silicone sealant Part Number 62998 at cable slot on Part Number 27680.
14.	Seal cable on Part Number 27912 at opening in Part Number 27680 with Silicone sealant Part Number 62998.

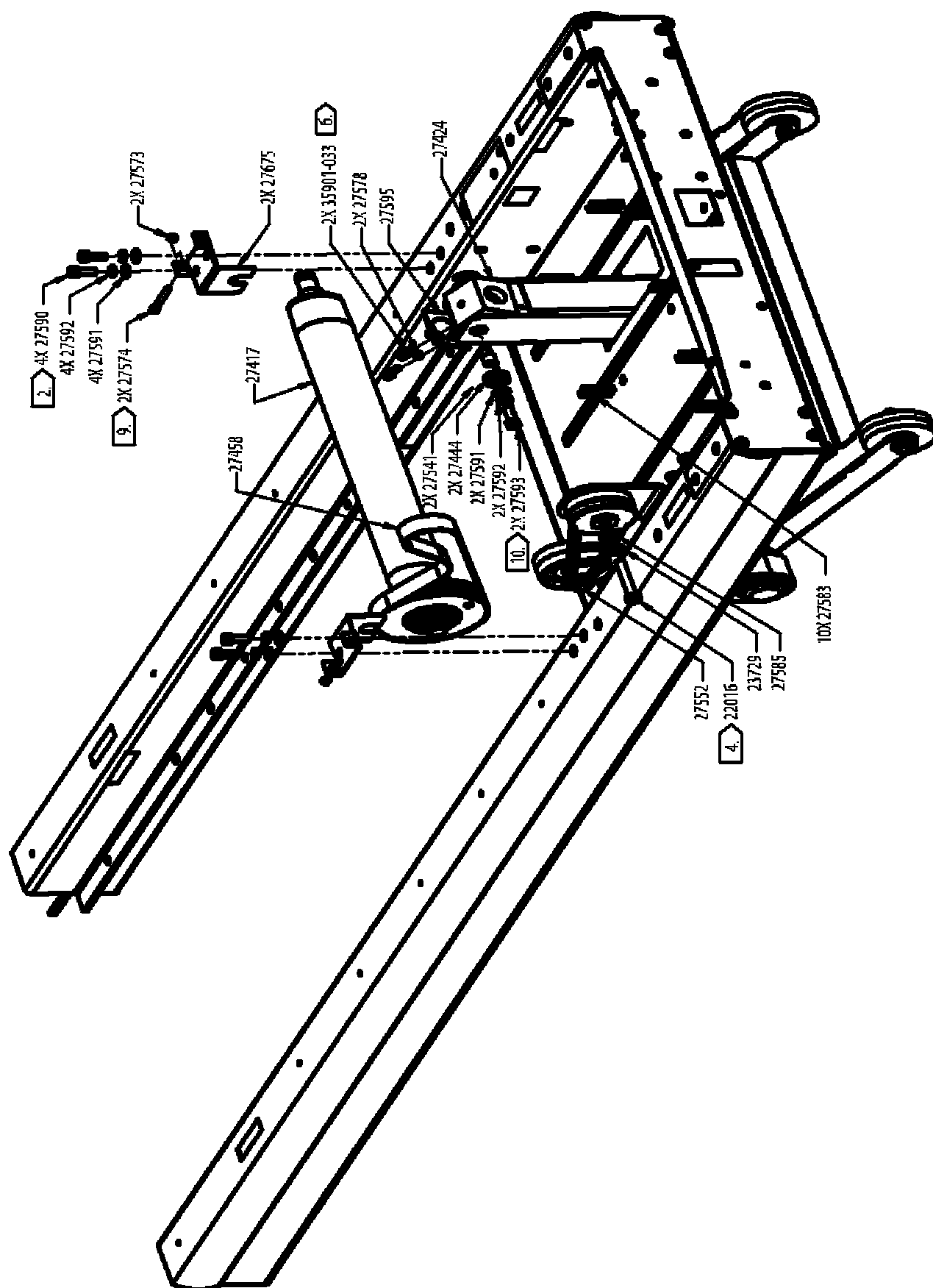


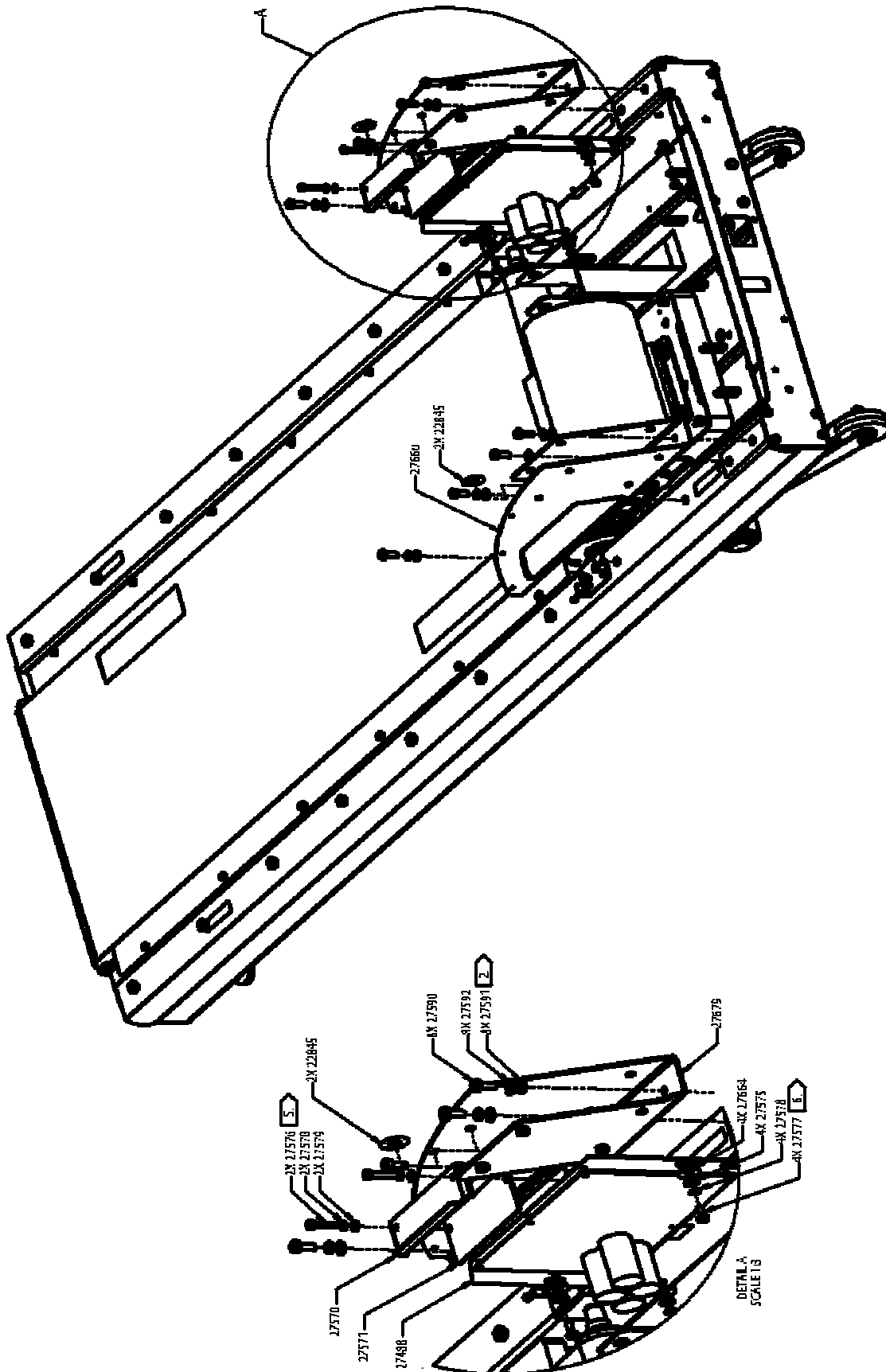


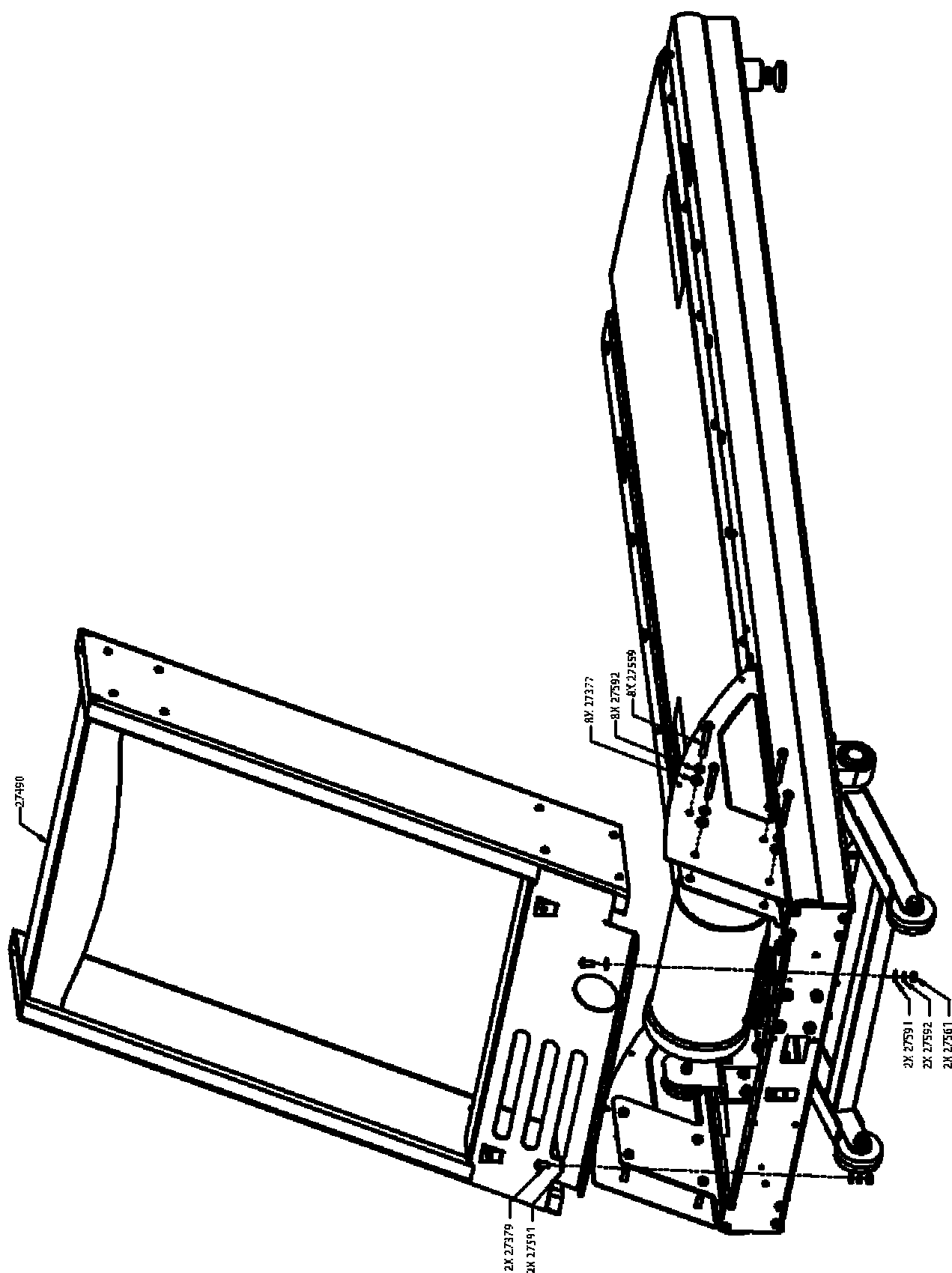


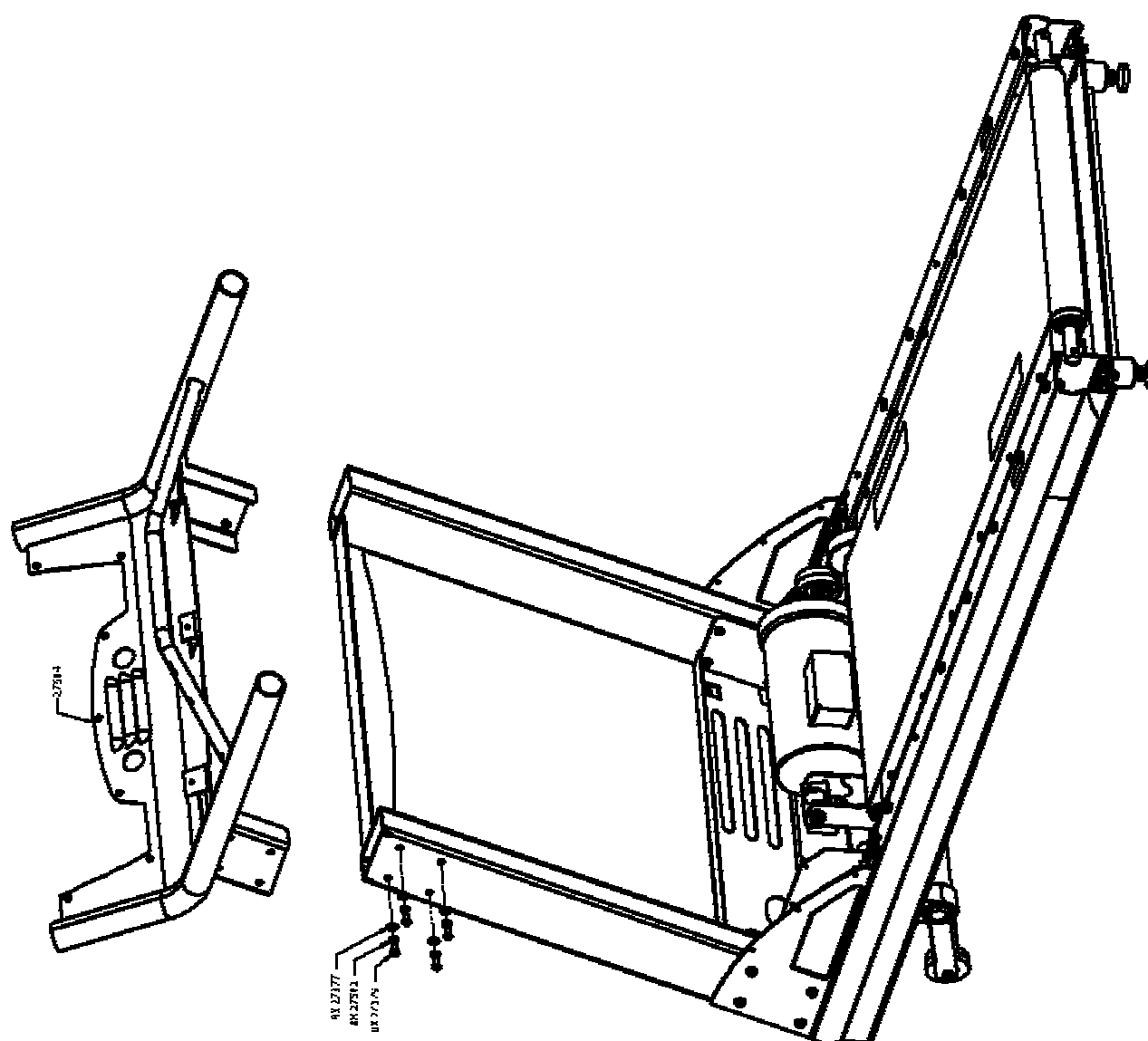


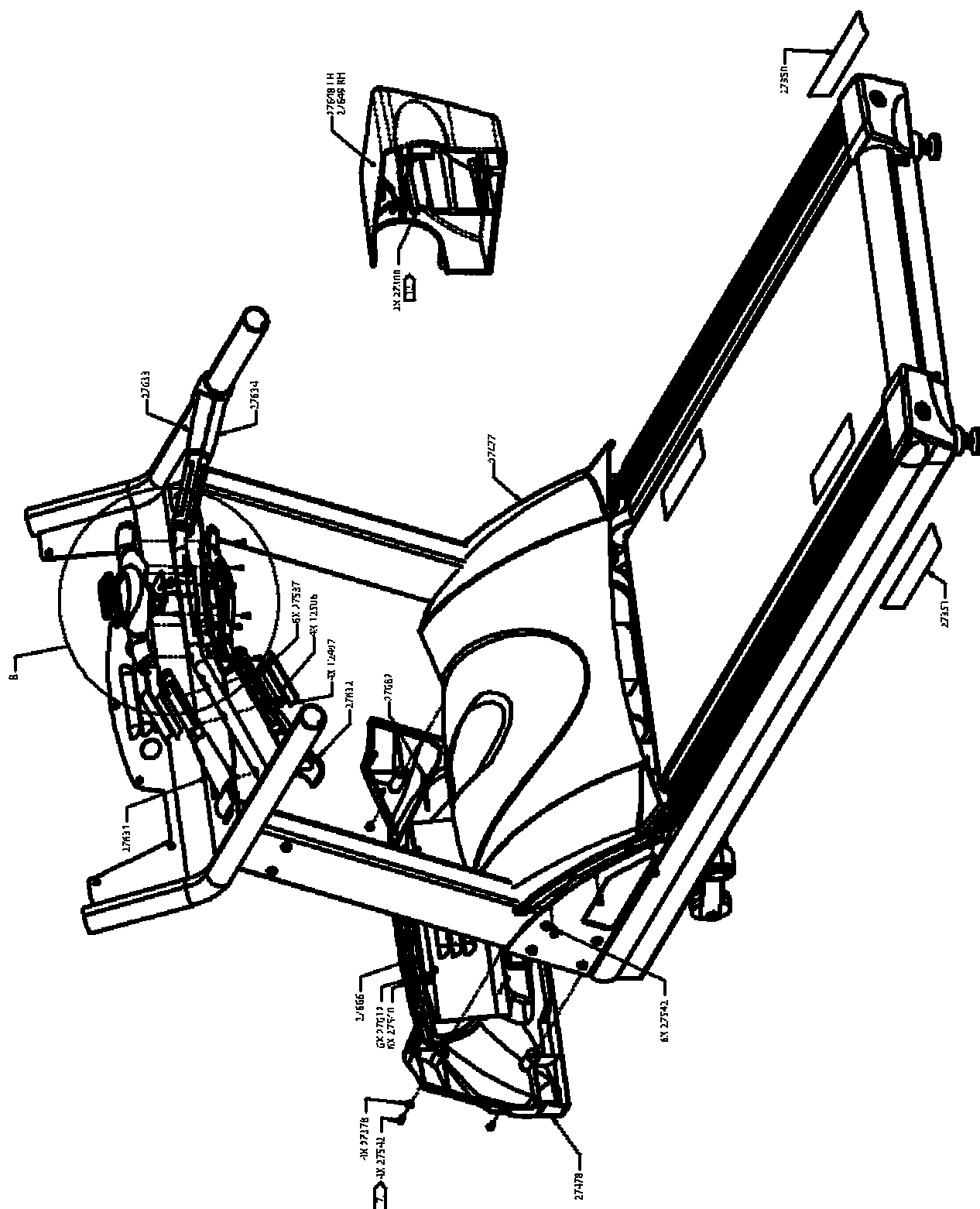


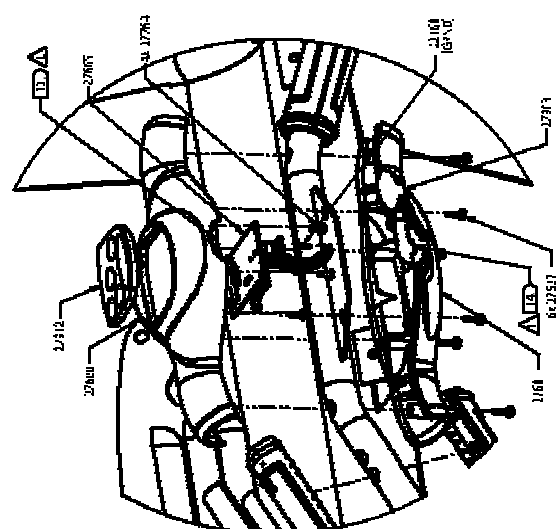
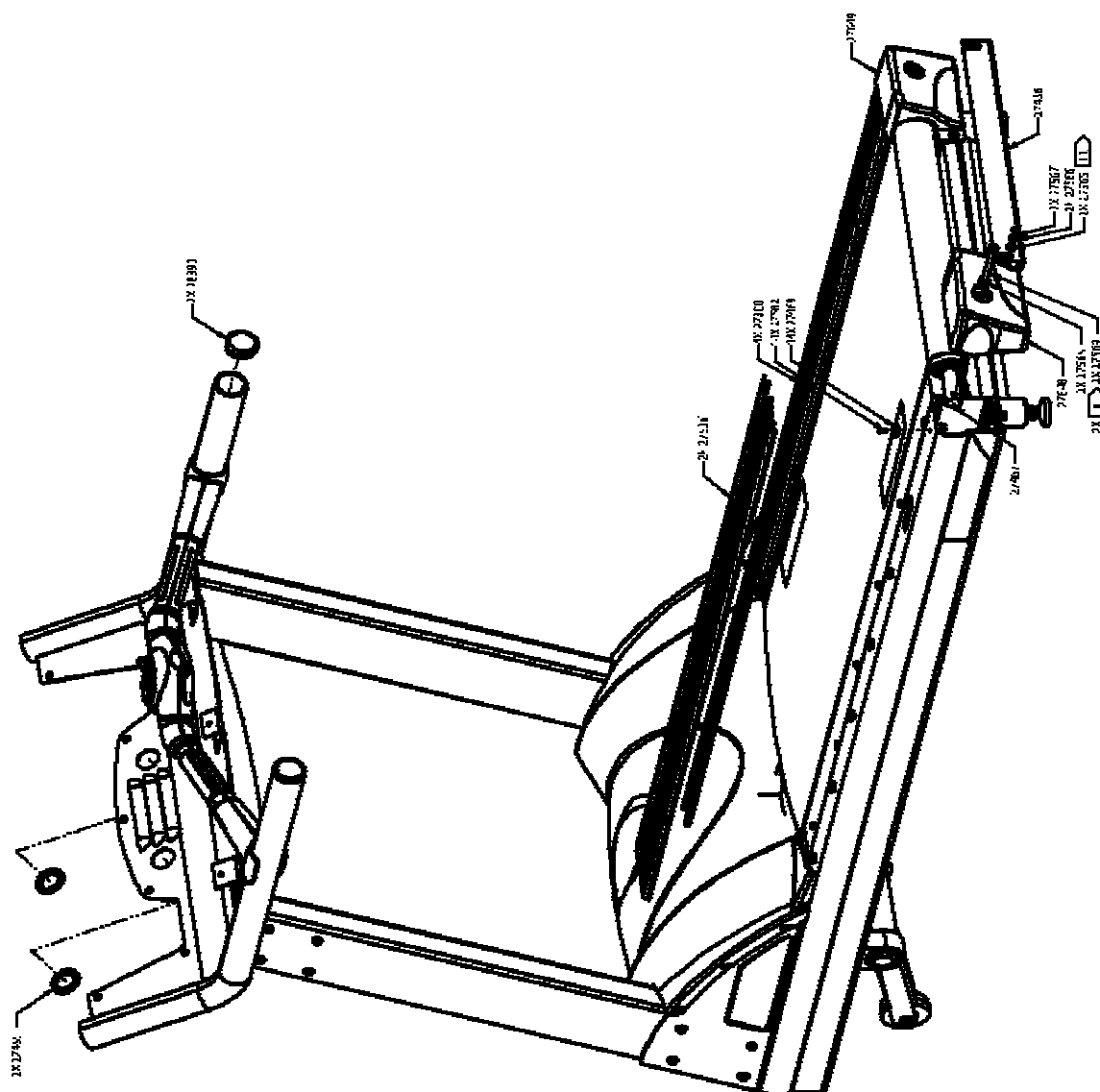




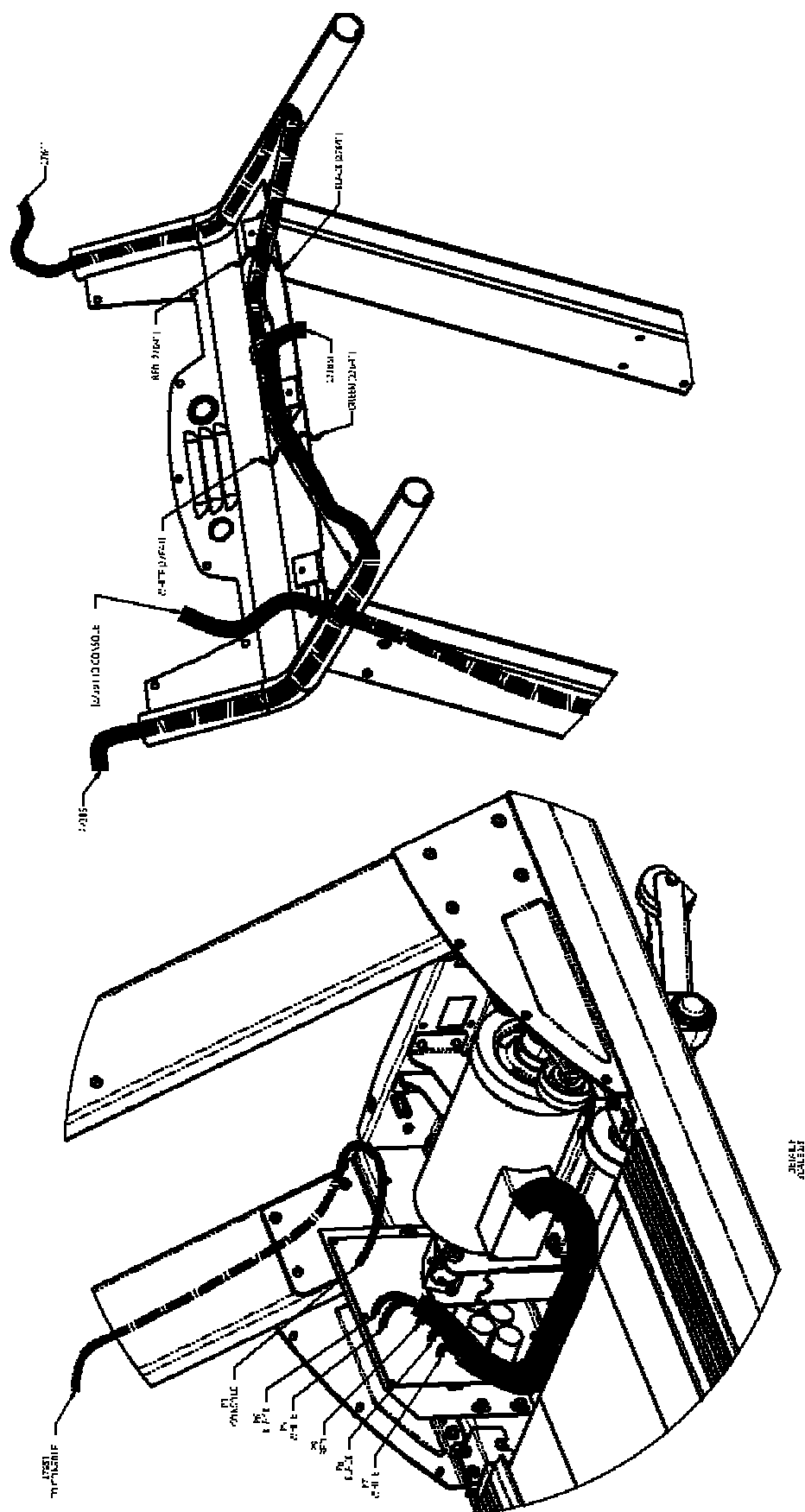


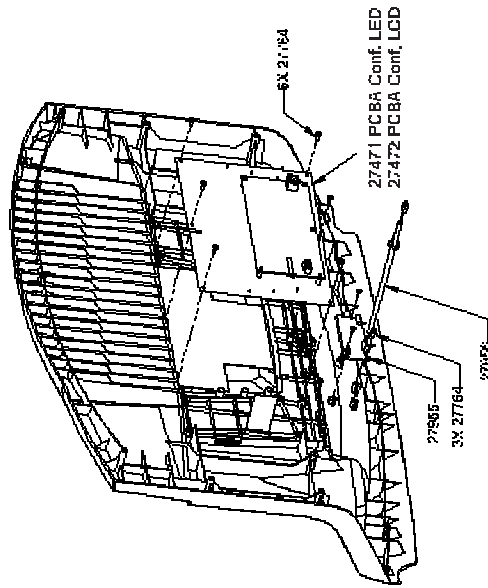
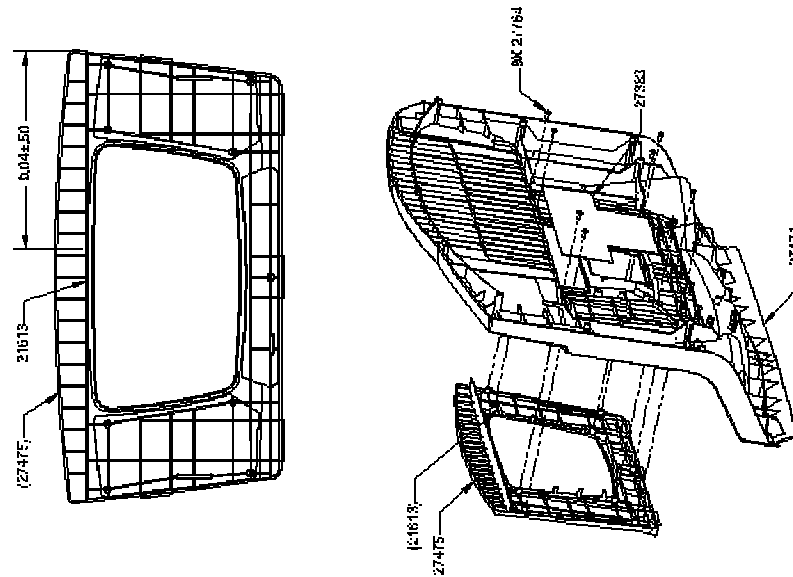






DETAIL 4
SCALE 1:2





Detail A: Confirm the placement of 3 jumpers across PC0, PC3 and PC5 located in the upper right hand corner of the PCBA. These jumpers identify the correct grade and speed configuration for the product.

