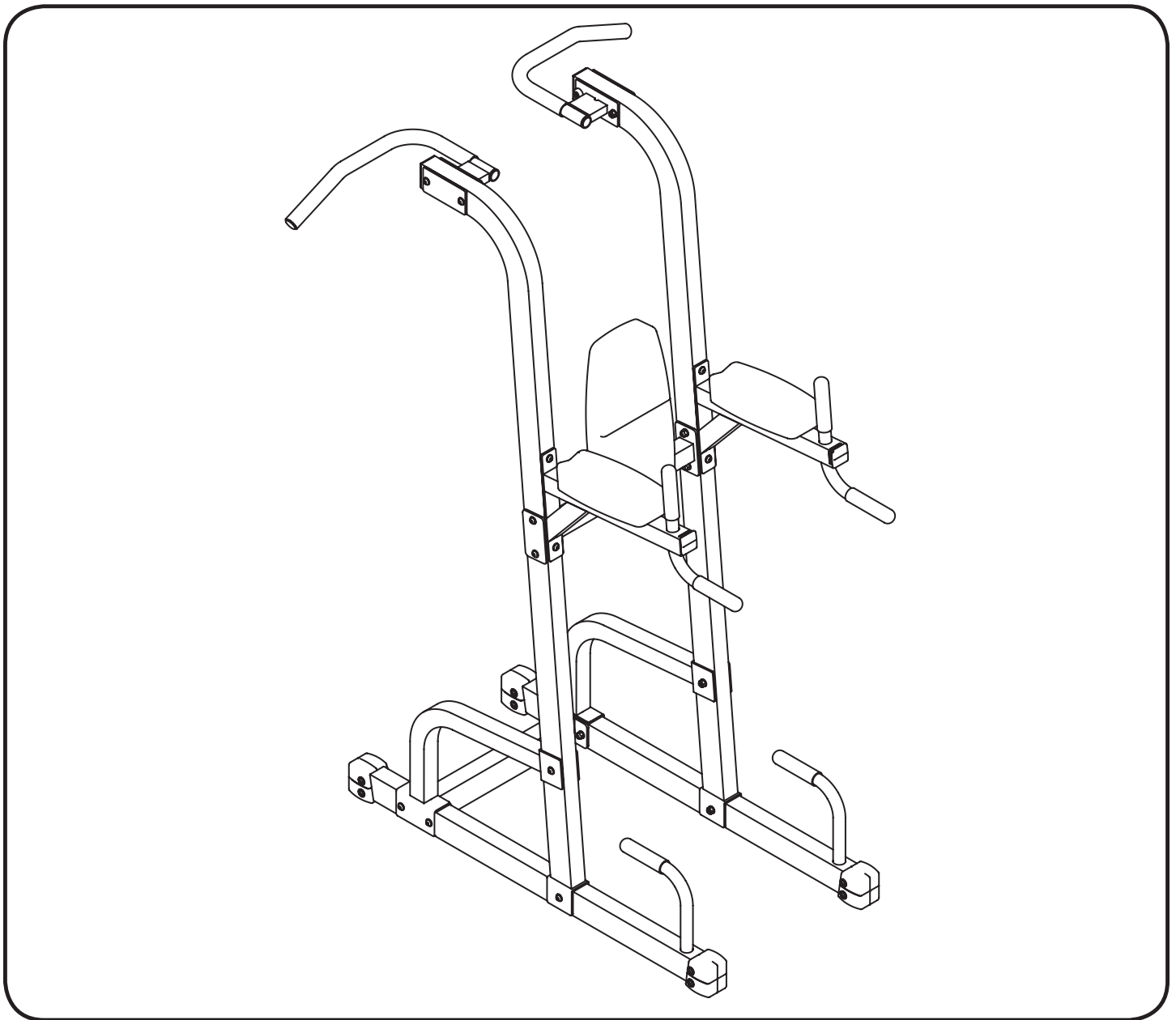




XM-7617

POWER TOWER

Owner's Manual



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NOTE: Hand tighten bolts and nylon nuts until machine is fully assembled.

Prior to assembly, remove components from the box and verify that all the listed parts were supplied.

SAFETY INFORMATION WARNING!

Before using this unit or starting any exercise program, consult your physician. This is especially important for persons over the age of 35 and/or persons with pre-existing health problems. XMARK Fitness assumes no responsibility for personal injury or property damage sustained by or through the use of this product.

It is the owner's responsibility to ensure that all users of this unit have read the Owner's Manual and are familiar with safety information and precautions.

SAFETY PRECAUTIONS

- This unit should only be used on a level surface and is intended for indoor use only. XMARK Fitness recommends an equipment mat be placed under the unit to protect the floor or carpet and for easier cleaning.
- Wear comfortable, good-quality walking or running shoes and appropriate clothing. Do not use this unit with bare feet, sandals, socks or stockings!
- Always examine your unit before using to ensure all parts are in working order.
- Do not leave children unsupervised near or on the unit.
- Service to your unit should only be performed by an authorized service representative, unless authorized and/or instructed by a XMARK Fitness technician. Failure to follow these instructions will void the warranty.

Before You Start



THANK YOU for making this unit a part of your exercise program. XMARK Fitness assures the very best in value, appearance, durability and biomechanics.

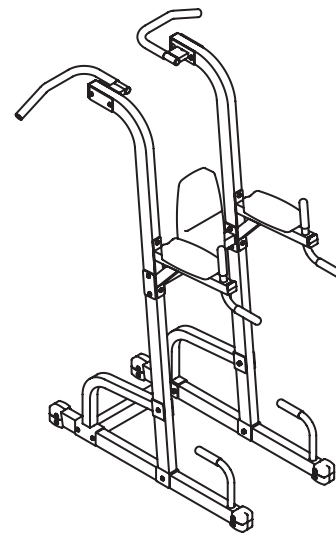
This manual will guide you through the assembly process. If at any time you are having trouble with the assembly or use of this product, then please contact us at our XMARK Fitness help line. We have trained service technicians on site to take care of you, our valued customer.

REGISTRATION CARD

To avoid unnecessary delays in warranty parts and to insure that a permanent record of your purchase is on file with our company, be sure to send in the warranty registration card or register online at www.xmarkfitness.com within 10 days of purchase.

MAILING ADDRESS

XMARK Fitness
7501 Trammel Drive
Shreveport, LA 71108



XMARK FITNESS SERIES
MODEL: XM-7617

QUESTIONS?
CALL 1-800-719-4605

Monday-Friday
8:30 a.m.-5:00 p.m.
(Central Standard Time)

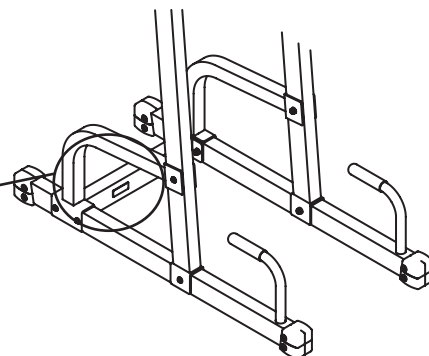
When calling please have the following product information available:

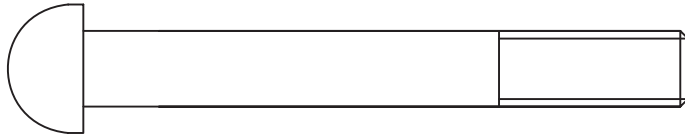
Model Name :

Date Mfg.:

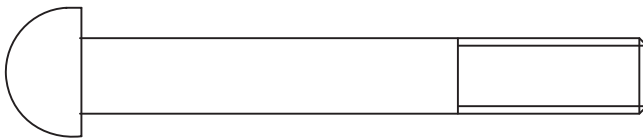
Serial #

Model Name Decal Location

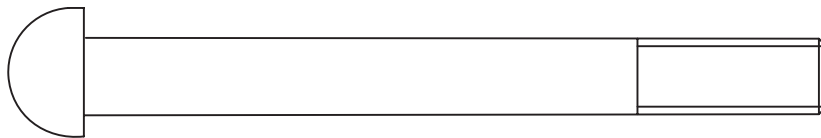




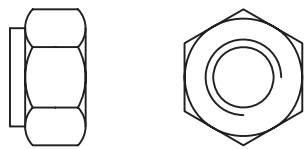
[23#] M10*80 8pcs



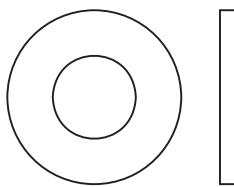
[22#] M10*75 8pcs



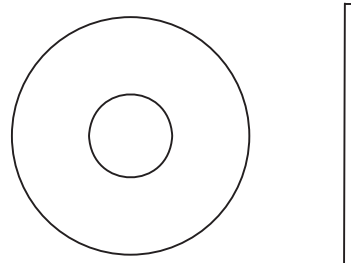
[24#] M10*100 4pcs



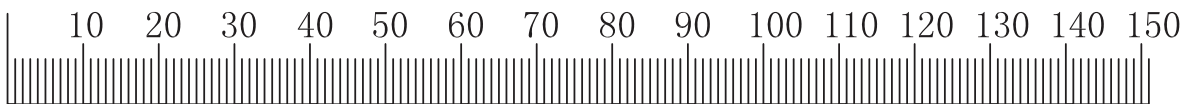
[25#] M10 20pcs



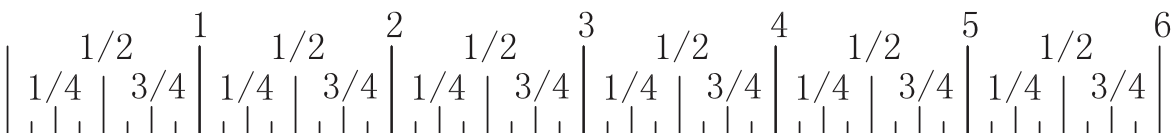
[19#] Ø11*Ø23*2 42pcs



[21#] Ø11* Ø30*2 4pcs



Millimeters



Inches

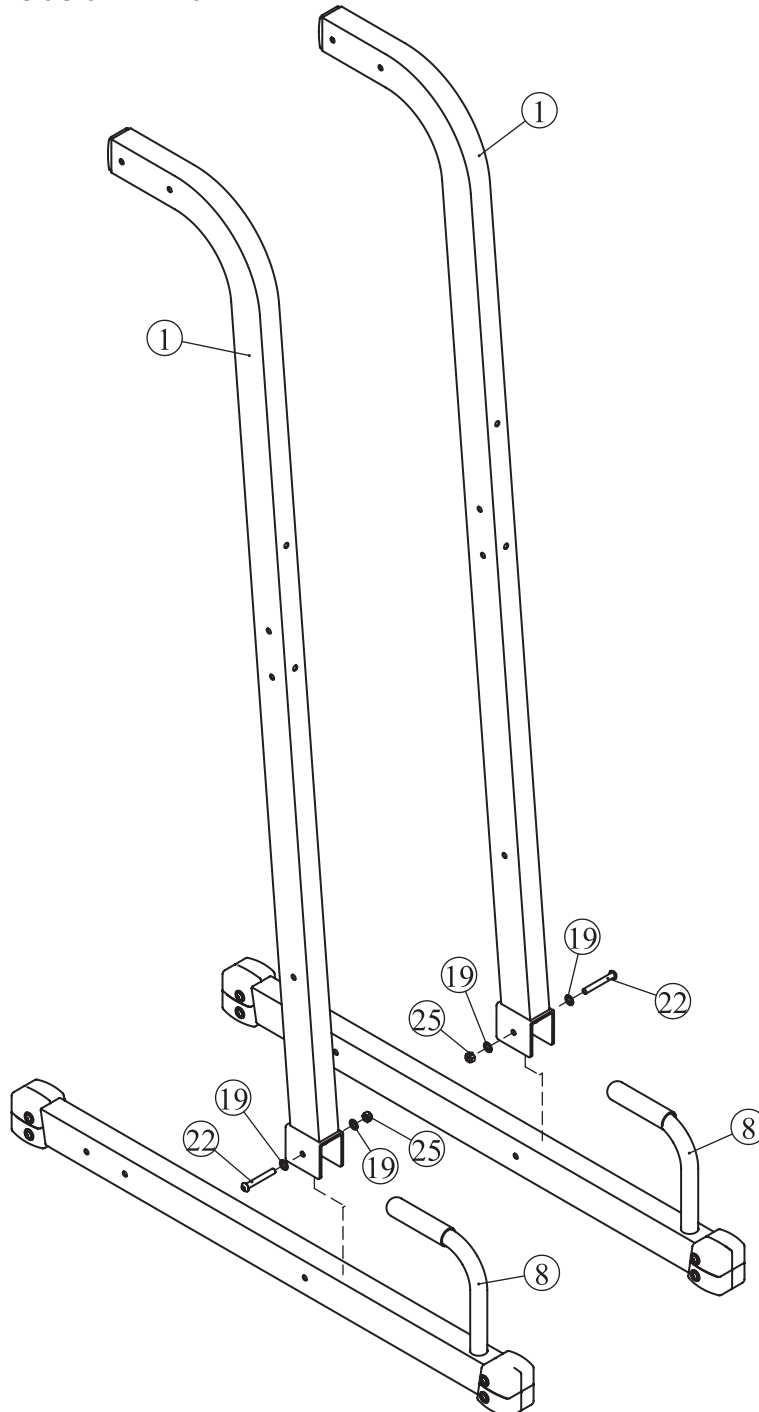
NOTE: Hand tighten bolts and Nylon Lock nuts until machine is fully assembled.

Step 1

Connect Upright Frame (#1) to Base Frame (#8) using:

- one M10*75 Button Head Cap Screw (#22)
- two $\Phi 11*\Phi 23*2$ Flat Washer (#19)
- one M10 Nylon Locknut (#25)

Repeat Step 1 for other side of XM-7617.



NOTE: Hand tighten bolts and Nylon Lock nuts until machine is fully assembled.

Step 2

Connect Back Pad Support Frame (#5) to both Upright Frames (#1) using:

- four M10*80 Button Head Cap Screw (#23)
- eight $\Phi 11*\Phi 23*2$ Flat Washer (#19)
- four M10 Nylon Locknut (#25)
- two Small Plates (#11)

NOTE: Small Plates (#11) are to be placed on the outside of the machine.

Connect Left and Right Angle Supports (#2, #3) to Base Frame (#8) and Cross Frame (#9) using:

- four M10*80 Button Head Cap Screw (#23)
- eight $\Phi 11*\Phi 23*2$ Flat Washer (#19)
- four M10 Nylon Locknut (#25)

Connect Left and Right Angle Supports (#2, #3) to Upright Frame (#1) using:

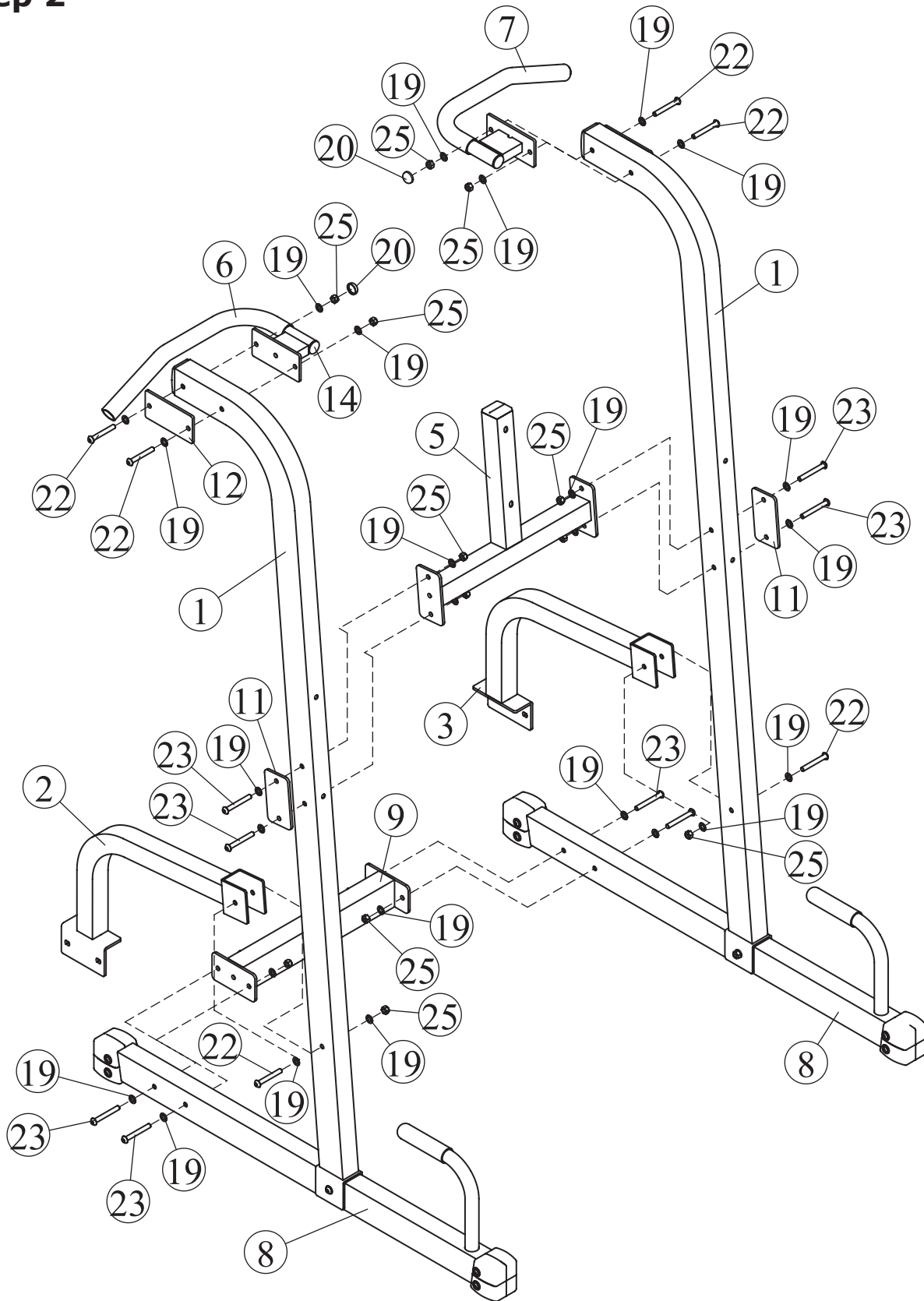
- two M10*75 Button Head Cap Screw (#22)
- four $\Phi 11*\Phi 23*2$ Flat Washer (#19)
- two M10 Nylon Locknut (#25)

Connect Right and Left Chin-Up Bars (#6, #7) to Upright Frames (#1) using:

- four M10*75 Button Head Cap Screw (#22)
- eight $\Phi 11*\Phi 23*2$ Flat Washer (#19)
- four M10 Nylon Locknut (#25)
- two Bolt cap (#20)
- two Big Plates (#12)

NOTE: Big Plates (#12) are to be placed on the outside of the machine.

Step 2

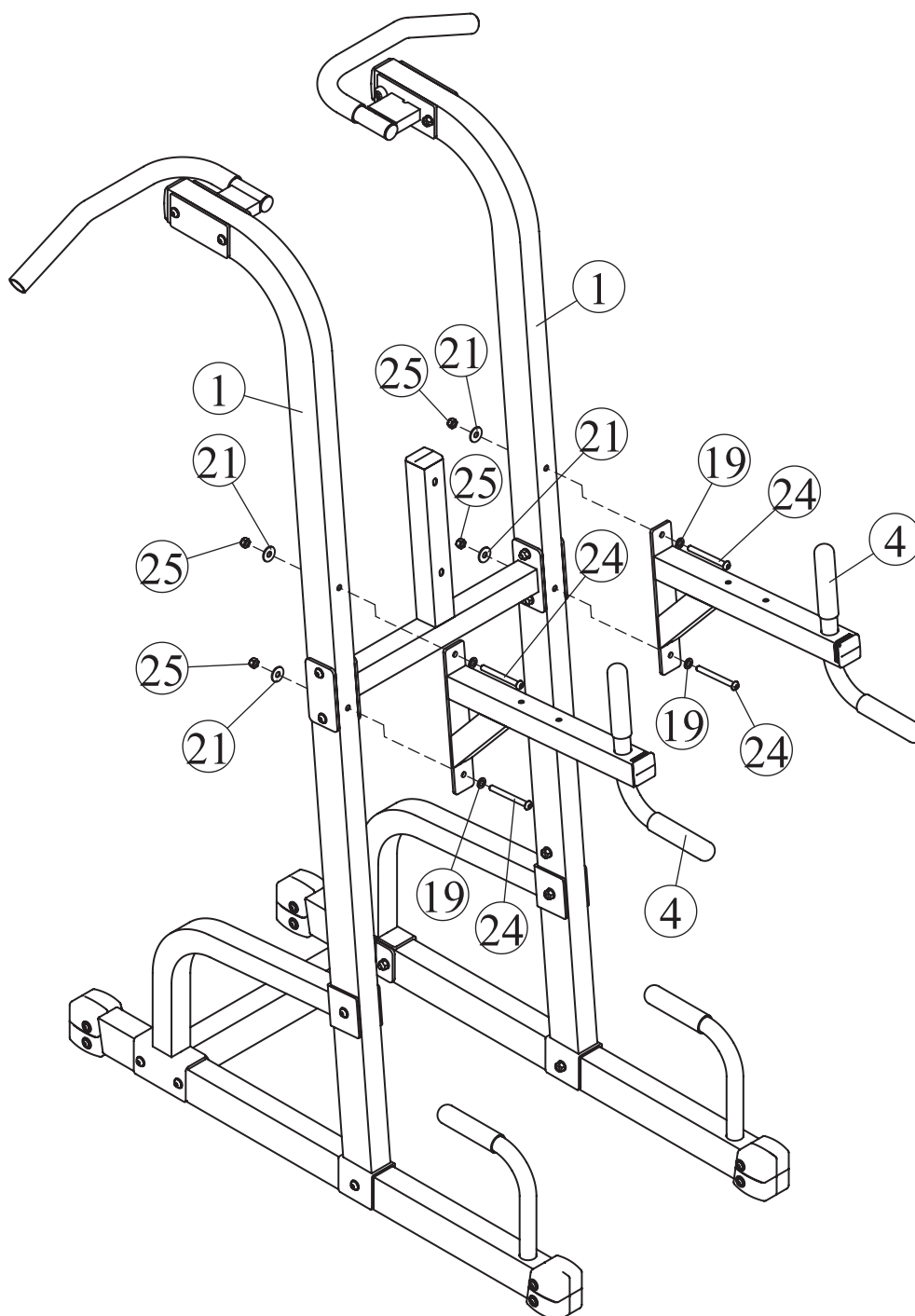


NOTE: Hand tighten bolts and Nylon Lock nuts until machine is fully assembled.

Step 3

Connect Elbow Pad Support Frame (#4) to Upright Frame (#1) using:

- four M10*100 Button Head Cap Screw (#24)
- four $\Phi 11 \times \Phi 23 \times 2$ Flat Washer (#19)
- four Big Washer (#21)
- four M10 Nylon Locknut (#25)



NOTE: Wrench Tighten bolts and Nylon Locknuts.

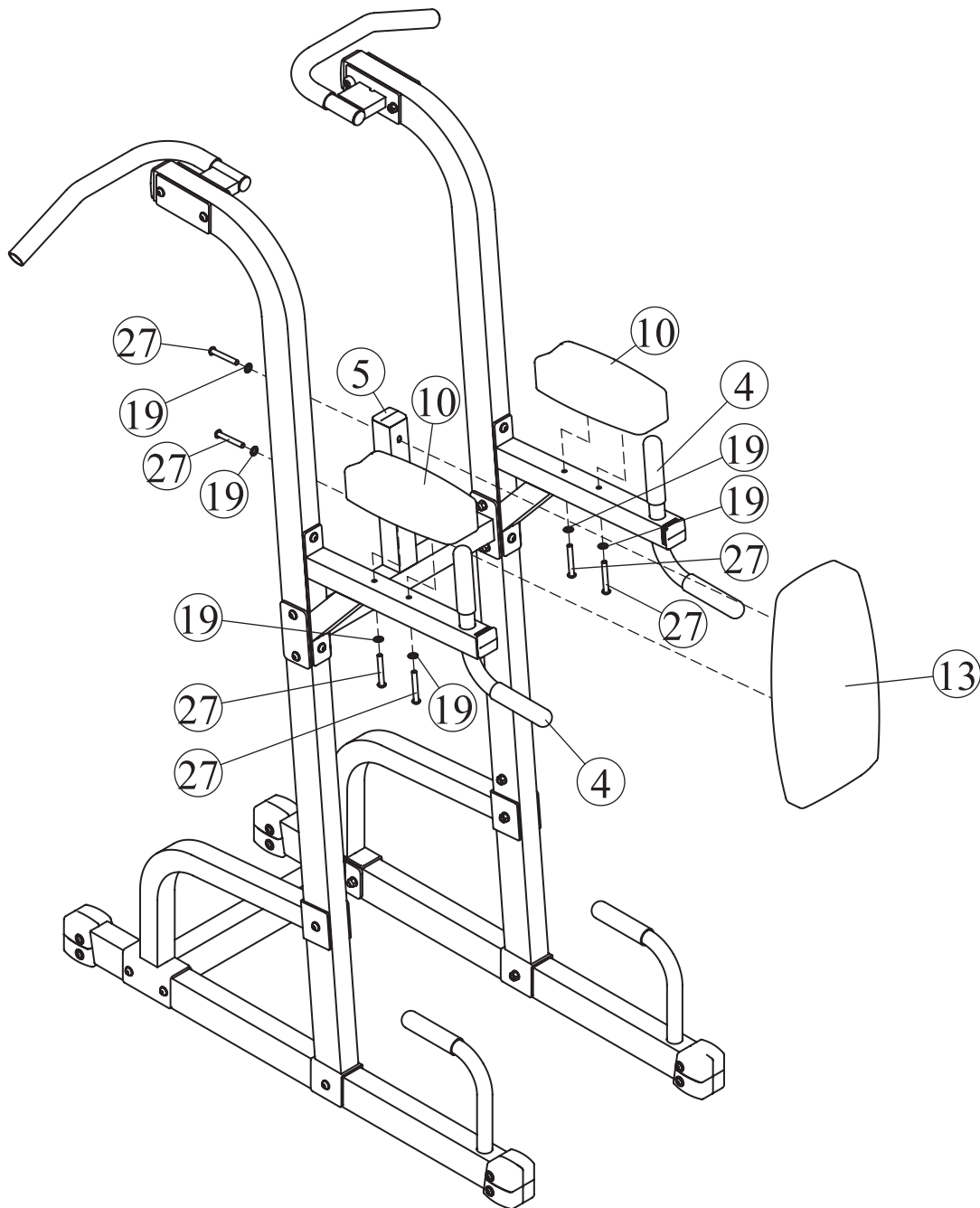
Step 4

Connect Back Pad (#13) to Back Pad Support Frame (#5) using:

- two M10*72 Button Head Cap Screw (#27)
- two $\Phi 11*\Phi 23*2$ Flat Washer (#19)

Connect Elbow Pads (#10) to Elbow Pad Support Frames (#4) using:

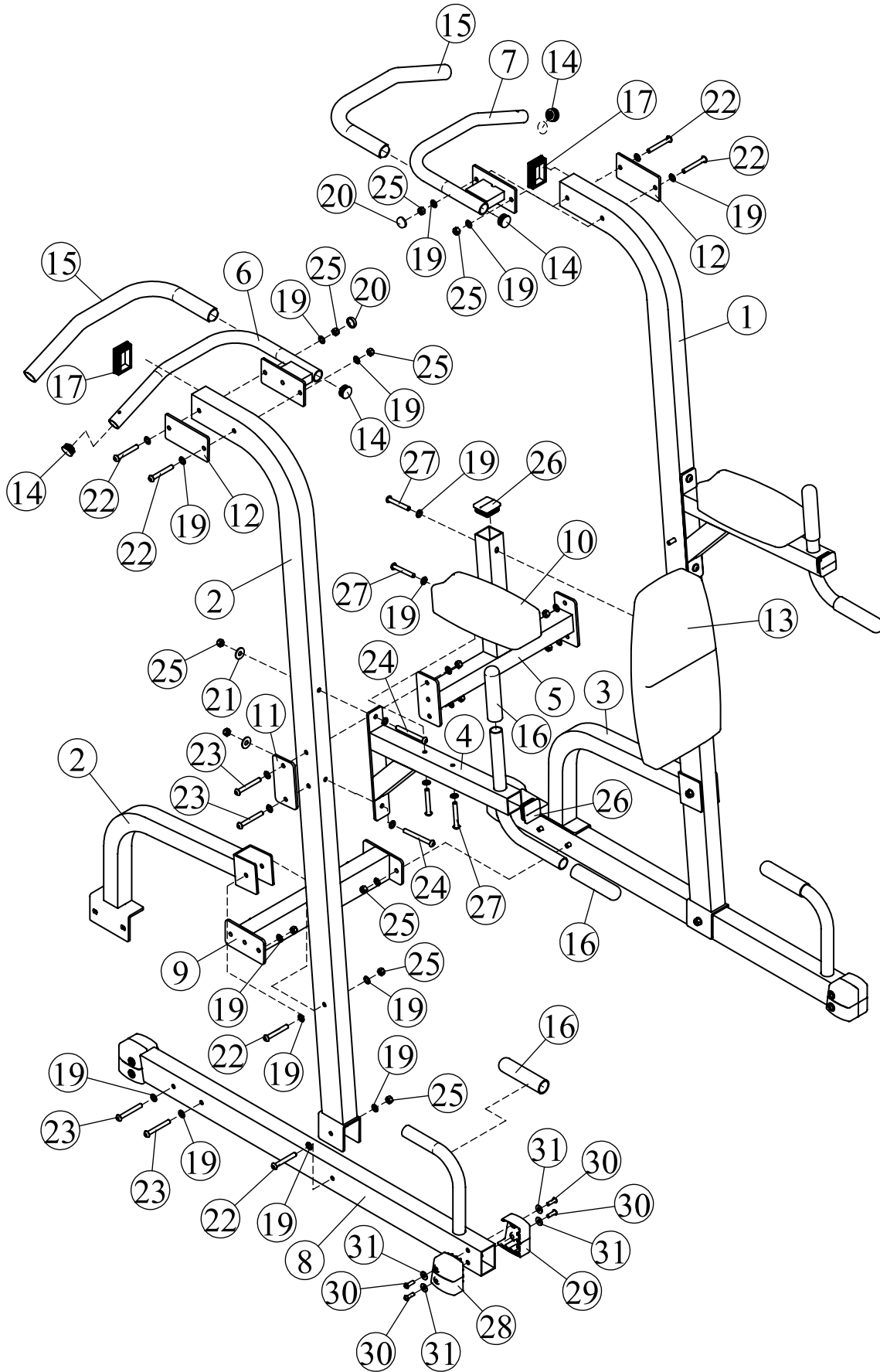
- four M10*72 Button Head Cap Screw (#27)
- four $\Phi 11*\Phi 23*2$ Flat Washer (#19)



XM-7617 Parts List

Ref #	Part #	Description	Qty
1	P00081	Upright Frame	2
2	P00502	Left Angle Support	1
3	P00503	Right Angle Support	1
4	P00082	Elbow Pad Support Frame	2
5	P00504	Back Pad Support Frame	1
6	P00505	Right Chin-Up Bar	1
7	P00506	Left Chin-Up Bar	1
8	P00312	Base Frame	2
9	P00507	Cross Frame	1
10	P00083	Elbow Pad	2
11	P00667	Small Plate	2
12	P00508	Big Plate	2
13	P00084	Back Pad	1
14	P00018	Plug 32	4
15	P00509	Grip	2
16	P00510	Grip	6
17	P00249	Plug 50.8*76.2	2
19	P00032	Flat Washer $\Phi 11*\Phi 23*2$	42
20	P00557	Bolt Cap	2
21	P00033	Big Washer $\Phi 11*\Phi 30*2$	4
22	P00612	Button Head Cap Screw M10*75	8
23	P00613	Button Head Cap Screw M10*80	8
24	P00589	Button Head Cap Screw M10*100	4
25	P00561	Nylon Locknut M10	20
26	P00183	Plug 50.8	3
27	P00611	Button Head Cap Screw M10*72	6
28	P00152	Foot Cap, Right 50.8*76.2 XM Series	4
29	P00155	Foot Cap, Left 50.8*76.2 XM Series	4
30	P00636	Button Head Cap Screw M8*25	16
31	P00037	Flat Washer $\Phi 9*\Phi 22*2$	16
32	P00560	Hex Key S=6	1
33	P00022	Wrench 17-19	1
34	H00020	Bolt Pack, XM-7617	1
35	M00025	Owner's Manual XM-7617	1

Exploded View



XMARK FITNESS LIMITED LIFETIME WARRANTY

This Warranty applies only in the United States and Canada to products manufactured or distributed by XMARK Fitness under the XMARK Fitness brand name. This product is backed by a lifetime warranty, excluding only expendable parts such as paint, finish and vinyl. This warranty extends only to you, the original purchaser. It is not transferable to anyone who subsequently purchases the product from you.



XMARK Fitness warrants that the product you have purchased for non-commercial, personal, family, or household use from XMARK Fitness is free from defects in materials or workmanship under normal use during the warranty period. Your sales receipt, showing the date of purchase of the product, is your proof of the date of purchase. This warranty becomes VALID ONLY if the product is assembled / installed according to the instructions / directions included with the product.

- In a light institutional setting, XMARK Fitness will extend a one year limited parts warranty and a lifetime frame warranty to the original purchaser.
- During the warranty period XMARK Fitness will repair or replace (at XMARK Fitness' option) the product if it becomes defective, malfunctions, or otherwise fails to conform with this Warranty under normal use. In repairing the product, XMARK Fitness may replace defective parts with new, or at the option of XMARK Fitness, serviceable used parts that are equivalent to new parts in performance. All exchanged parts and products replaced under this warranty will become the property of XMARK Fitness. XMARK Fitness reserves the right to change manufacturers of any part to cover any existing warranty.
- This warranty DOES NOT COVER shipping charges, export taxes, custom duties and taxes, or any other charges associated with transportation of the parts or product. To obtain warranty service, you must contact an XMARK Fitness customer service representative at our phone number located in this manual. Any parts determined to be defective must be returned to XMARK Fitness to obtain warranty service. You must prepay any shipping charges, export taxes, custom duties and taxes, or any other charges associated with transportation of the parts or product. In addition, you are responsible for insuring any parts or product shipped or returned. You assume the risk of loss during shipment. You must present XMARK Fitness with proof-of-purchase documents (including the date of purchase). Any evidence of alteration, erasure, or forgery of proof-of-purchase documents will be cause to void this warranty.
- This warranty does not extend to any product not purchased from XMARK Fitness. This Limited / Lifetime Warranty does not extend to any product that has been damaged or rendered defective; (a) as a result of accident, misuse, or abuse; (b) by the use of parts not manufactured or sold by XMARK Fitness; or (c) by modification of the product. Product on which the serial number has been defaced or removed is not eligible for warranty service. Should any product submitted for warranty service be found ineligible, an estimate of repair cost will be furnished and the repair will be made if requested by you upon XMARK Fitness' receipt of payment or acceptable arrangements for payment.

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This Limited / Lifetime Warranty gives you specific legal rights and you may also have other rights that may vary from state to state. This is the only express warranty applicable to XMARK Fitness branded products. XMARK Fitness neither assumes nor authorizes anyone to assume for it any other express warranty.



XMARK Fitness

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Shreveport, LA 71108

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