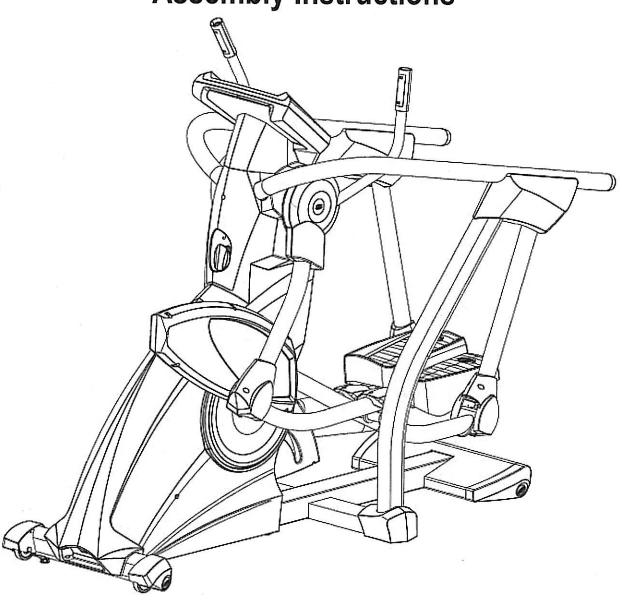


EV716/EV718 Ellipticals Assembly Instructions



PN 000-3603 REV C

IMPORTANT!

Please read assembly instructions completely before beginning.

- Due to the elliptical trainer's size and weight, the unit requires two people to move and assemble.
- Carefully unpack the machine.
- After the elliptical is assembled, read through your Owner's Manual for complete safety information, installation requirements and operating instructions.

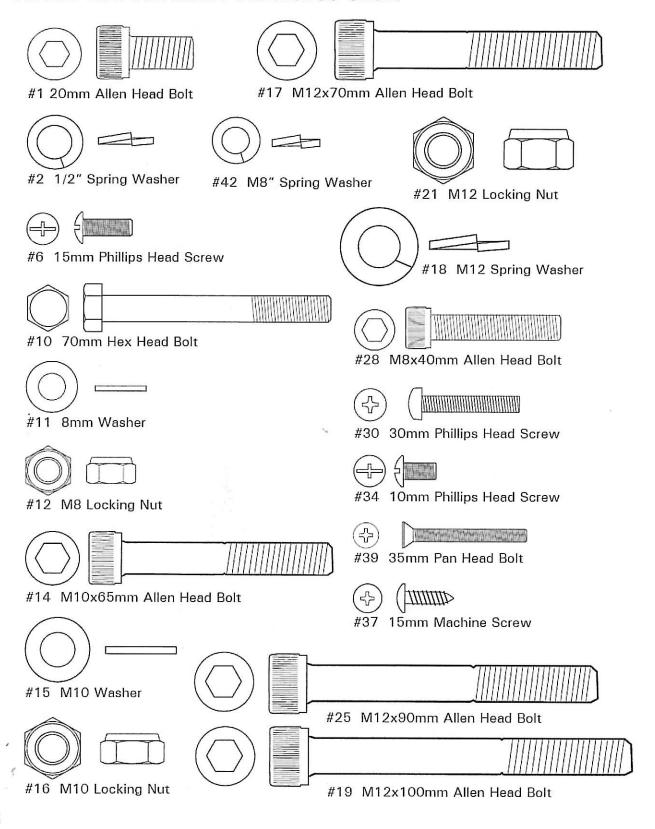
Required Assembly Tools

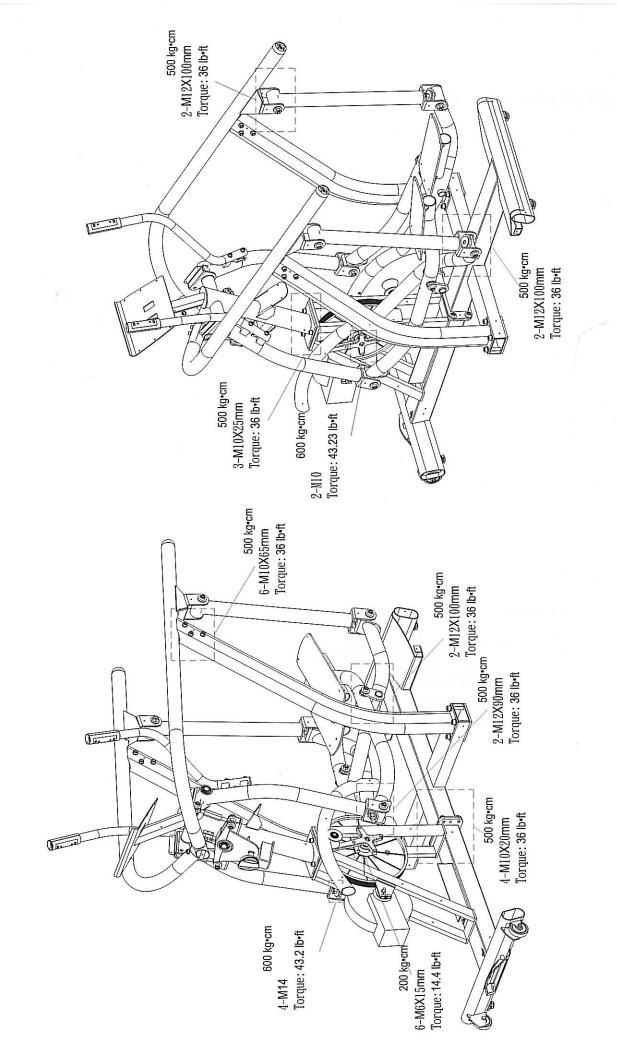
- Torque Wrench
- 10 mm Allen Wrench
- 13 mm Box Wrench
- 19mm Socket
- 6 mm Allen Wrench
- Adjustable Wrench
- 17mm Socket
- 8 mm Allen Wrench
- Long and short #2 Phillips Screw Drivers
- 3/8" drive ratchet with 6mm, 8mm, and 10mm hex bit sockets will speed the assembly process greatly.

Hardware Contents

Item Number	Item Description	Quantity
1	20mm Allen Head Bolt	4
2	1/2" Spring Washer	4
6	15mm Phillips Head Screw	36
10	70mm Hex Head Bolt	2
11	8mm Washer	4
12	M8 Locking Nut	2
14	M10x65 mm Allen Head Bolt	6
15	M10 Washer	12
16	M10 Locking Nut	6
17	M12x70mm Allen Head Bolt	8
18	M12 Spring Washer	8
19	M12x100mm Allen Head Bolt	4
21	M12 Locking Nut	6
25	M12x90mm Allen Head Bolt	2
28	M8x40mm Allen Head Bolt	4
30	30mm Phillips Head Screw	6
34	10mm Phillips Head Screw	13
37	15mm Machine Screw	2
39	35mm Pan Head Bolt	6
42	M8 Spring Washer	4

Actual Size Hardware Reference Chart



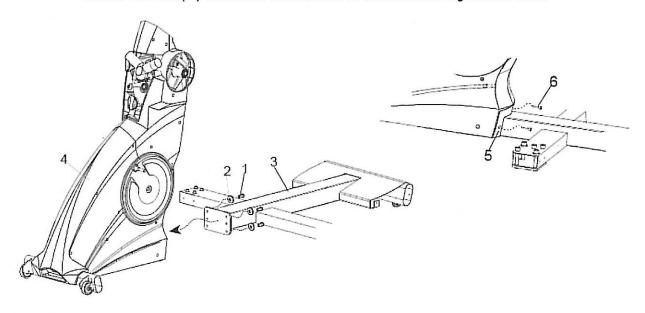


Step 1 - Attach Rear Frame

Assembly Procedure

- Use four 20mm Allen Bolts (#1) and four 1/2" Spring Washers (#2) to attach the rear frame (#3) to the Base Unit (#4).
- Use two 15mm Phillips Head Screws (#6) to attach the plastic Flange Cover (#5) to the Rear Frame (#3).

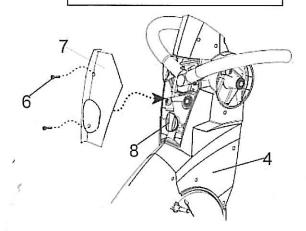
TIP: The Base Unit (#4) can be tilted forward about an inch while inserting the Allen Bolts.

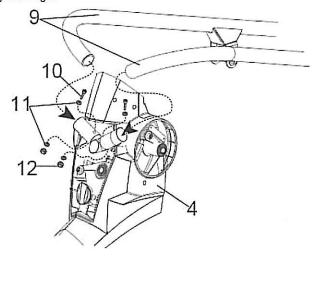


Step 2 - Attach Side Rails

- Unthread lockout knob (#8) and remove linkage cover (#7).
- Use two 70mm Hex Head Bolts (#10), four M8 Washers (#11) and two M8 Locking Nuts (#12) to attach the left and right Side Rails (#9) to the Base Unit (#4). Leave hardware only hand-tight.

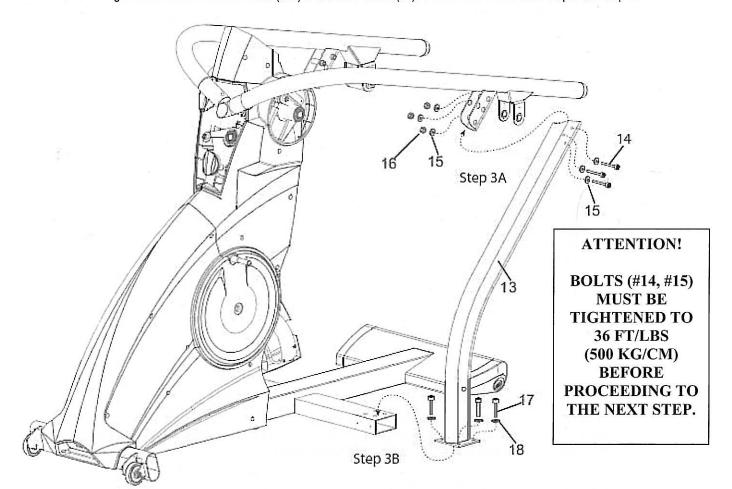
NOTE: Take care not to drop parts into the shroud, as you will have to disassemble the entire shroud to get them out.





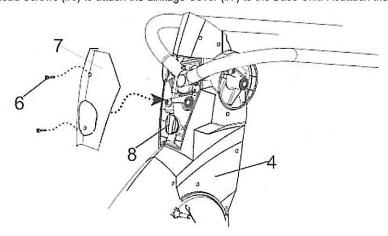
Step 3 - Attach Support Uprights to Side Rails

- 3A. Use six M10x65mm Allen Head Bolts (#14), twelve M10 Washers (#15), and six M10 Locking Nuts (#16) to attach the Left and right Support Uprights (#13) to the Left and Right Side Rails (#9). Leave hardware only hand-tight.
- 3B. Use eight M12x70mm Allen Head Bolts (#13) to the Rear Frame (#3). Secure all hardware from Step 2 and Step 3.



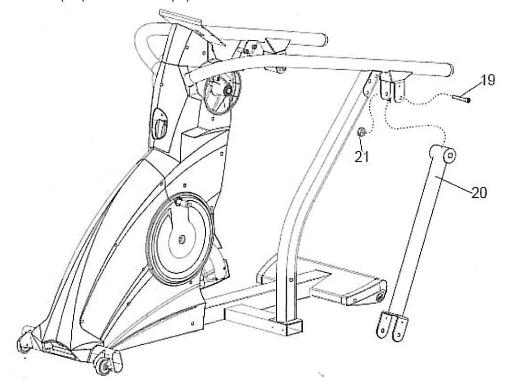
Step 4 - Attach Linkage Cover

Use two 15mm Phillips Head Screws (#6) to attach the Linkage Cover (#7) to the Base Unit. Reattach the Lockout Knob (#8).



Step 5 - Attach Swing Arms

• Use two M12x100mm Allen Head Bolts (#19) and two M12 Locking Nuts (#21) to attach the Left and Right Swing Arms (#20) to the Side Rails (#9).



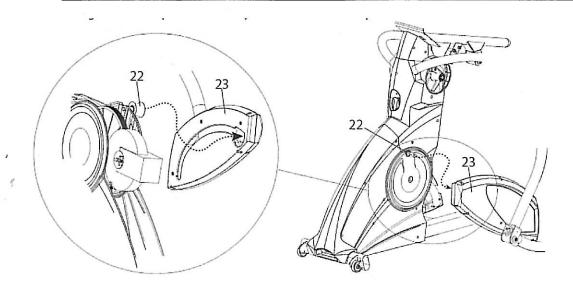
ATTENTION!

BOLT (#19) MUST
BE TIGHTENED
TO 36 FT/LBS
(500 KG/CM)
BEFORE
PROCEEDING TO
THE NEXT STEP.

Step 6 - Attach Pod Assembly

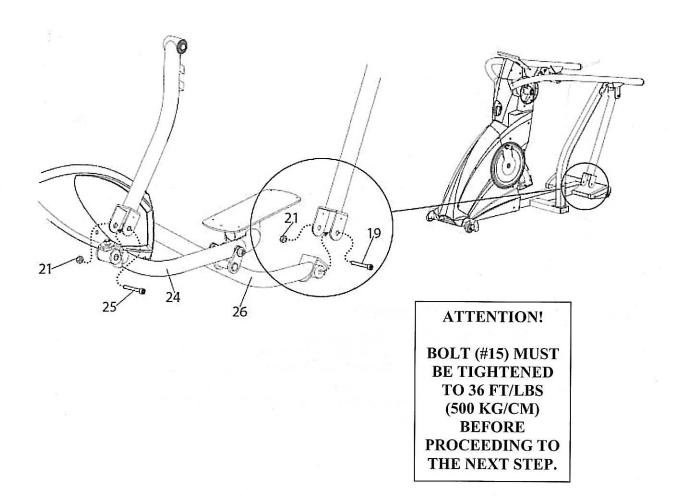
- Feed the Left Side Roller Wheel (#22) through the round opening in the front of the Pod Assembly (#23). The Pod Assembly may rest on the ground before moving to Step 7. Do not yet install Right Side Pod Assembly.
- Use ten 15mm Phillips Head Screws (#6) with blue Loctite on them to install the Left & Right Foot Pedals (#38).

NOTE: Use ten 15mm screws with blue Loctite on them to install the foot pedals. A drawing of the foot pedal assembly can be found in Step 9.



Step 7 - Attach Connecting Arm Pivots

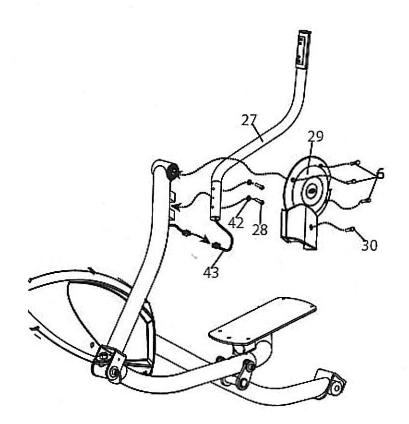
- Use one M12x90mm Allen Head Bolt (#25) and one M12 Locking Nut (#21) to attach the Front Connecting Arm Pivot (#24).
- Use on M12x100mm Allen Head Bolt (#19) and one M12 Locking Nut (#21) to attach the Rear Connecting Arm Pivot (#26).
- Repeat Step 6 and Step 7 for the Right Side Pod Assembly.



Step 8 - Attach Upper Body Arms

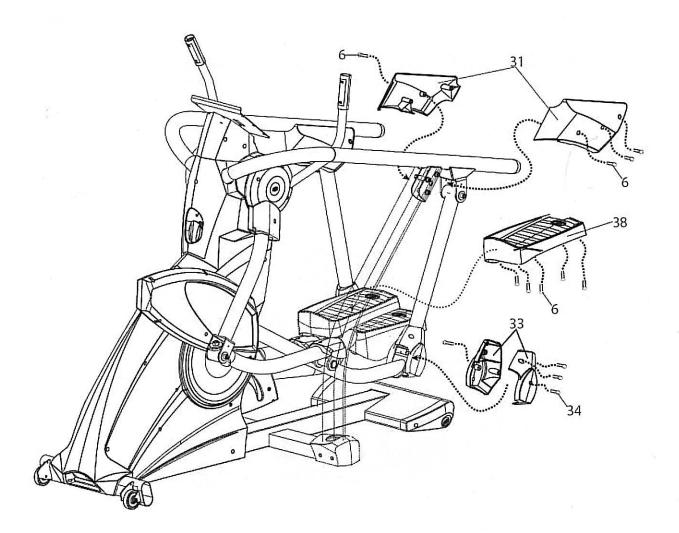
- Plug the Right and Left Fingertip Control Wires (#43) into the wire coming from the Base Unit. Each handle has its own
 control wire that must plug into the base unit wire. To avoid damage to the unit, do not allow the arm to hang freely from
 the wiring assembly.
- Use four M8x 40mm Allen Head Bolts (#28) and four M8 Spring Washers (#42) to attach the Left & Right Upper Body Arms (#27).
- Use six 15mm Phillips Head Screws (#6) and six 30mm Phillips Head Screws (#30) to attach the Left and Right Arm Covers (#29).

NOTE: Only one #30 screw is shown in the picture below. You must install three #30 screws in this step.



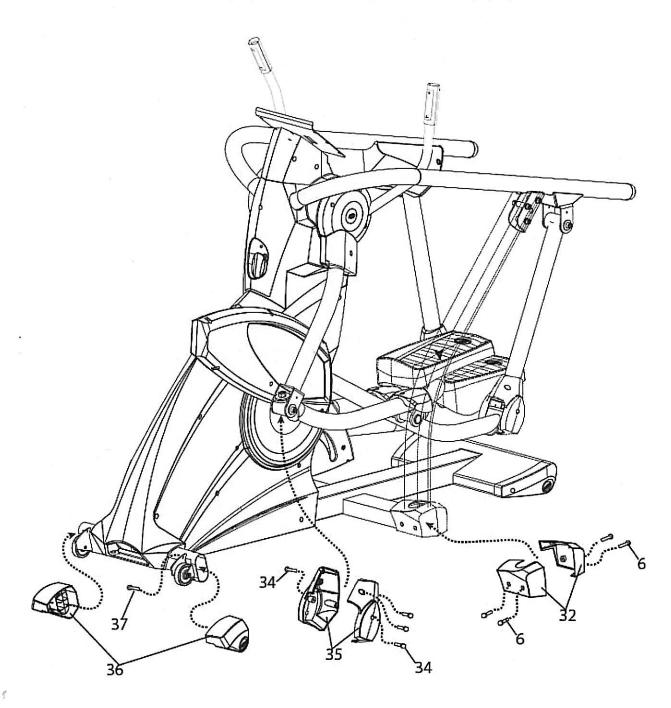
Step 9 - Install Pivot Covers and Foot Pedals

- Use eight 15mm Phillips Head Screws (#6) to install the Left and Right Swing Army Pivot Covers (#31). Use eight 10mm Phillips Head Screws (#34) to install the Left and Right Rear Pivot Covers (#33).



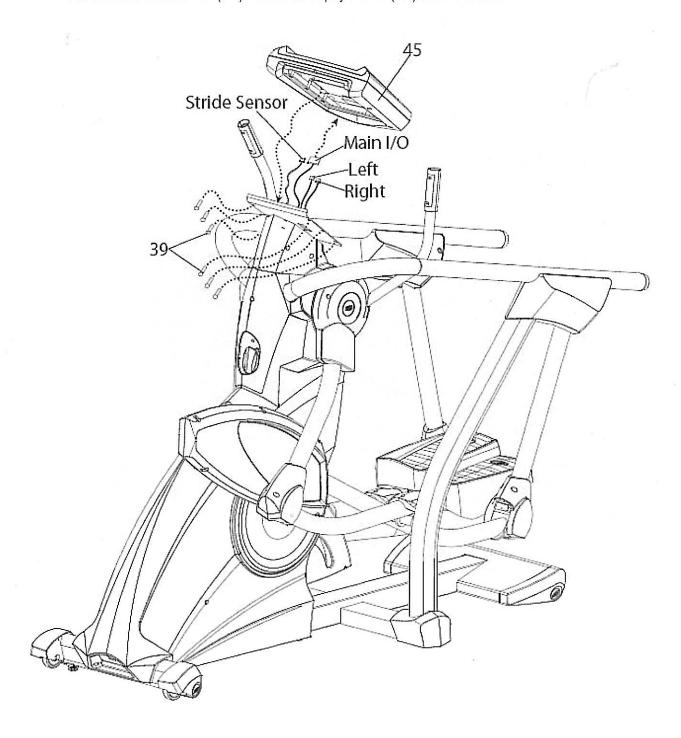
Step 10 - Install Pivot Covers and End Caps

- Use eight 15mm Phillips Head Screws (#6) to install the Left and Right Upright Caps (#32).
- Use eight 10mm Phillips Head Screws (#34) to install the Left and Right Front Pivot Covers (#35).
- Use two 15mm Machine Screws (#37) to install the Left and Right Stabilizer End Caps (#36).



Step 11 - Install Computer Console

- Plug the Left Hand Grip Control Wire labeled as "LEFT" into the connector on the back of the Computer Console (#38) labeled as "LT GRIP".
- Plug the Right Hand Grip Control Wire labeled as "RIGHT" into the connector on the back of the Computer Console (#38) labeled as "RT GRIP".
- Plug the large Main Control Wire into the back of the Computer Console labeled as "MAIN I/O".
- Plug the last wire assembly, the Stride Sensor Control Wire into the back of the computer console, labeled as "STRIDE SENS".
- Use six 35mm Pan Head Bolts (#39) to attach the Display Console (#45) to the Base Unit.



Assembly of your Nautilus Pro Series Elliptical is complete!

Please refer to your Pro Series Owners Manual for information on proper use of your Elliptical.

For more information visit our website at www.nautilus.com or call 800-864-1270.