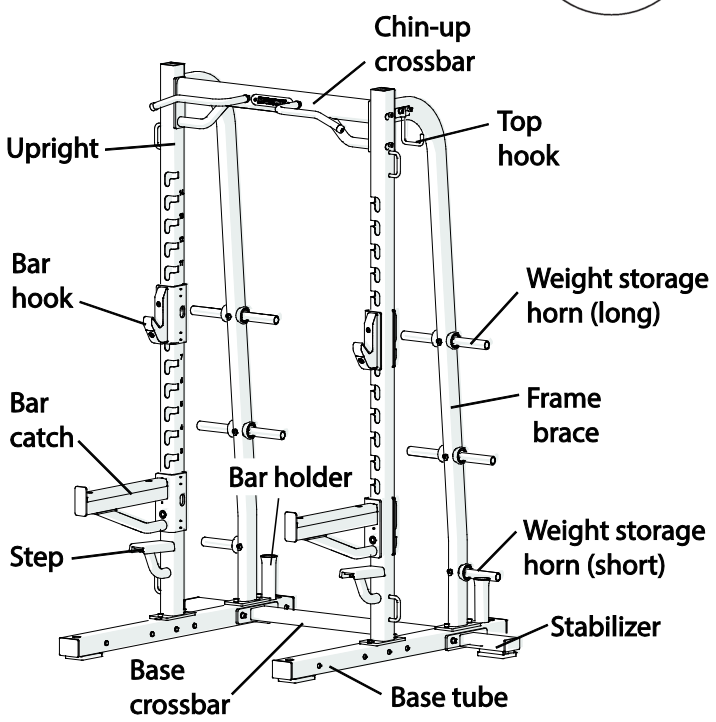
# Discovery™ Series Half Rack (611) Assembly Guide

To assemble your equipment, follow the steps in the order listed in this assembly guide. For more product information, visit us at *www.precor.com*.

**WARNING** **At least two people are required to assemble the equipment. DO NOT attempt assembly by yourself.**




## Assembly requirements

When assembling the equipment, we recommend you:

- Unpack the box and assemble the equipment close to where you plan to use it.
- Locate the equipment at least 79 inches (2 meters) away from walls or furniture on either side of the equipment, and 79 inches (2 meters) away from objects behind or in front of the equipment.
- Assemble the unit on a solid, flat surface, so that it remains level and stable.
- DO NOT move the equipment without assistance.

### Specifications

| | |
|---|---|
| **Equipment Dimensions:** | 72″ L x 61″ W x 98″ H ( 1800 mm L x 1550 mm W x 2500 mm H) |
| **Equipment Weight:** | 454 lb (206 kg) |

### Required tools

- Torque wrench
- Rubber mallet
- 10 mm hex bit

### Hardware kit

| | Component | Quantity |
|---|---|---|
| ❶ | Socket head cap bolt (M12 × 35 mm) | 24 |
| ❷ | Flat washer (13 x 26) | 28 |
| ❸ | Socket head cap bolt (M12 × 105 mm) | 4 |
| ❹ | Socket head cap bolt (M12 × 50 mm) | 2 |
| ❺ | Flat washer (13 x 20 mm) | 6 |

| Component | | Quantity |
|---|---|---|
| | Hex key (10 mm) | 1 |
| | Storage horn bumper | 10 |
| | Weight storage horn (short) | 2 |
| | Weight storage horn (long) | 4 |

## Begin assembly

If you have the space, Precor recommends that you completely assemble each side (Figure 1) on the floor and then raise them and attach the crossbars. If your space is limited, assemble the equipment where it will be used.

***Important*** *DO NOT fully tighten the fasteners until instructed to do so.*

### *To begin assembly with limited space:*

1. Position the base tubes on the floor (exactly where you plan to use the equipment) with the bolts facing outward and the bar holders where you want the back of the equipment to be.
2. Position the base crossbar between the base tubes and attach it to them using four bolts ❶ and four washers ❷.
3. Attach a stabilizer to each base tube using two bolts ❶ and two washers ❷.
4. Position an upright (it has a step attached to it) on a base tube (Figure 1) and secure it using two bolts ❶ and two washers ❷.
5. Position a frame brace on the base tube and attach it using two bolts ❶ and two washers ❷.
6. Attach the top of the frame brace to the upright using two bolts ❶ and two washers ❷.
7. Repeat Steps 1-6 to assemble the opposite side of the half rack.

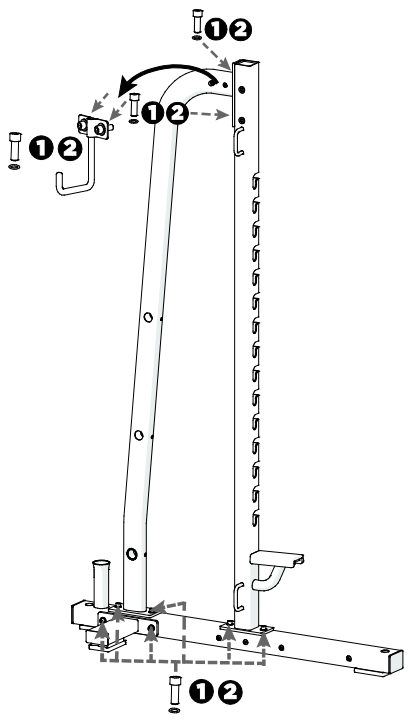



**Figure 1**

### *To attach the two sides of the equipment if assembled separately:*

1. Using Figure 1 as a guide, lay the following parts out on the floor: One base tube, one upright, one stabilizer and one frame brace.
2. Position an upright (it has a step attached to it) on a base tube (Figure 1) and secure it using two bolts ❶ and two washers ❷.
3. Position a frame brace on the base tube and attach it using two bolts ❶ and two washers ❷.
4. Attach the top of the frame brace to the upright using two bolts ❶ and two washers ❷.
5. Repeat Steps 1-4 to assemble the other side.
6. Raise both assembled sides and attach the base crossbar to the base tube of the other side assembly (Figure 2) using two bolts ❶ and two washers ❷.

### *To complete assembly:*

1. Position and attach the chin-up crossbar to each front upright using two bolts ❸ and two washers ❷.
2. Attach a top hook to each frame brace using two bolts ❶ and two washers ❷.

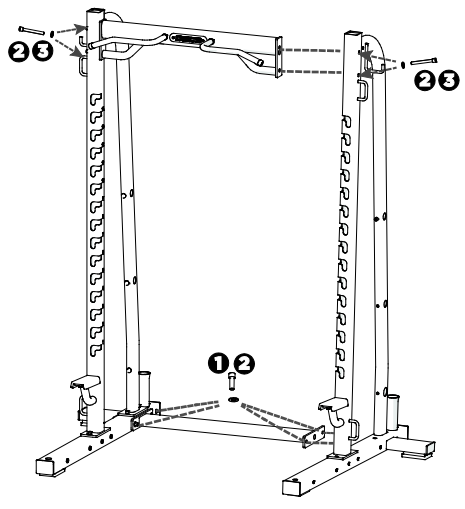



**Figure 2**

## Tighten the bolts

Tighten the bolts to 65 ft-lb (88 N-m) in the following order: ① through ⑭

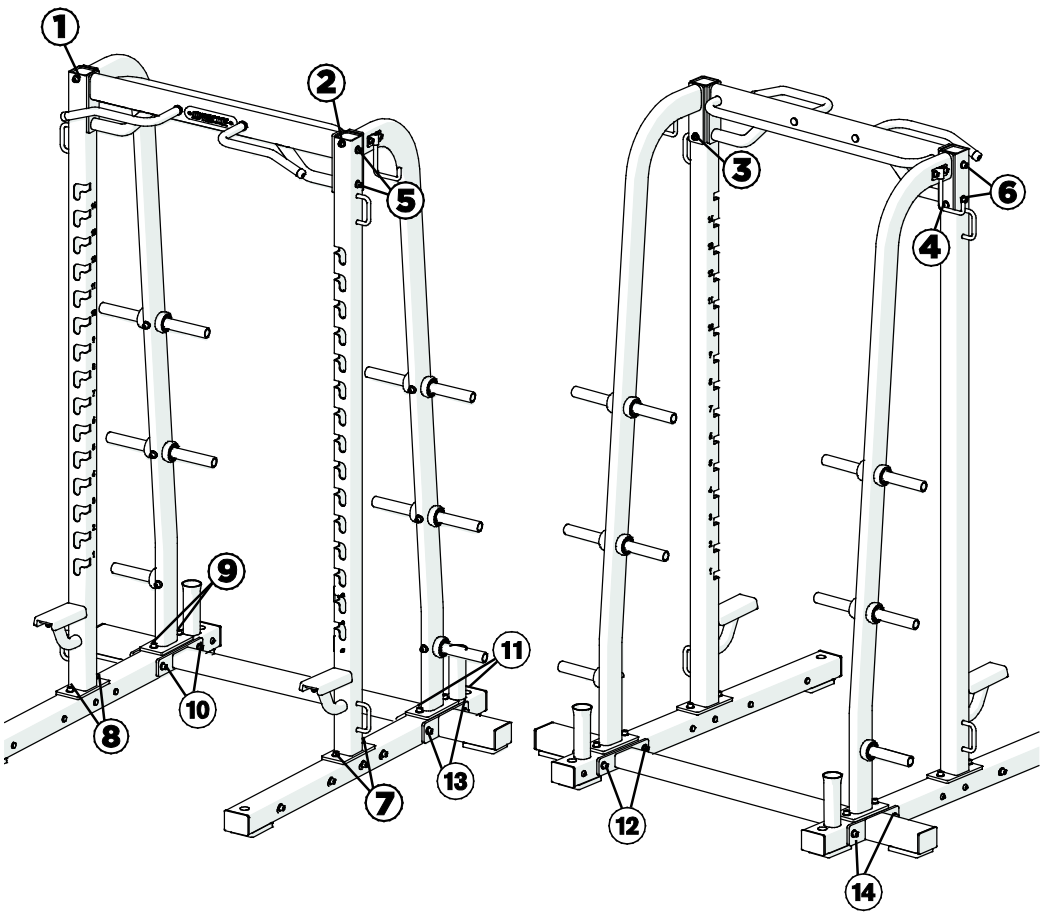



**Figure 3**

### *To attach a short weight storage horn:*

1. Insert the short weight horn into the hole in the equipment frame until it stops (Figure 4. If needed, use a rubber mallet to tap it gently into place.

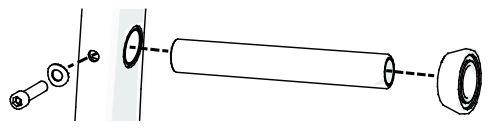


**Figure 4**

2. Secure the weight horn using a bolt ❹ and a washer ❺.
3. Push the storage horn bumper onto the horn with its wide side facing outward. If needed, use a weight plate to push the bumper against the equipment frame.
4. Repeat this procedure to attach the other weight horn.

### *To attach a long weight storage horn:*

1. Insert a long weight horn through the hole in the equipment frame (Figure 5).
2. Secure the weight horn using a bolt ❹ and a washer ❺.

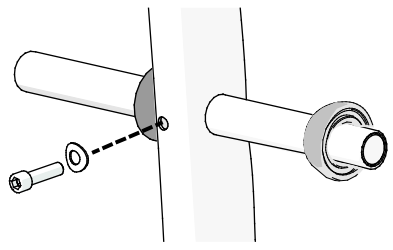


**Figure 5**

3. Push the storage horn bumpers onto the horn with their wide side facing outward. If needed, use a weight plate to push the bumper against the equipment frame.
4. Repeat this procedure to attach all long weight horns.

### *To attach the bar hooks and bar catches:*

1. Slide each bar hook into each front upright (Figure 6).
2. Fit each bar catch to the front upright on either side of the equipment (Figure 7).

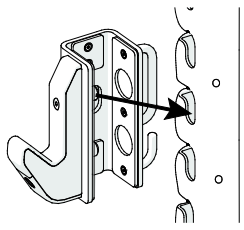


**Figure 6**

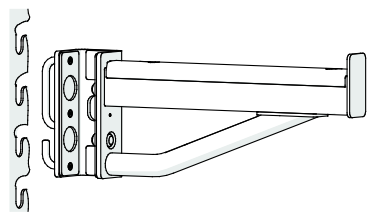


**Figure 7**

## Bolt the equipment to the floor

Precor recommends that the strength equipment be bolted down at all anchoring points. Bolting is made possible by removing the end caps at the frame base and exposing the mounting holes that accommodate the bolts (see the accompanying figure). Replace end caps when bolting is complete.

***Important*** *As floor materials vary, it is important that you consult a licensed contractor to advise you on proper bolting techniques and appropriate fastener types.*

*Standards occasionally change or are updated. Precor recommends that you keep apprised of your local industry standards. Precor shall not be held liable for failure to properly bolt the strength equipment to the floor.*

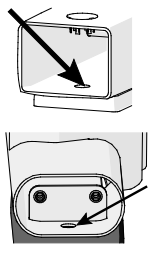


**Figure 8**


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