

DETAIL A
SCALE 1 : 8

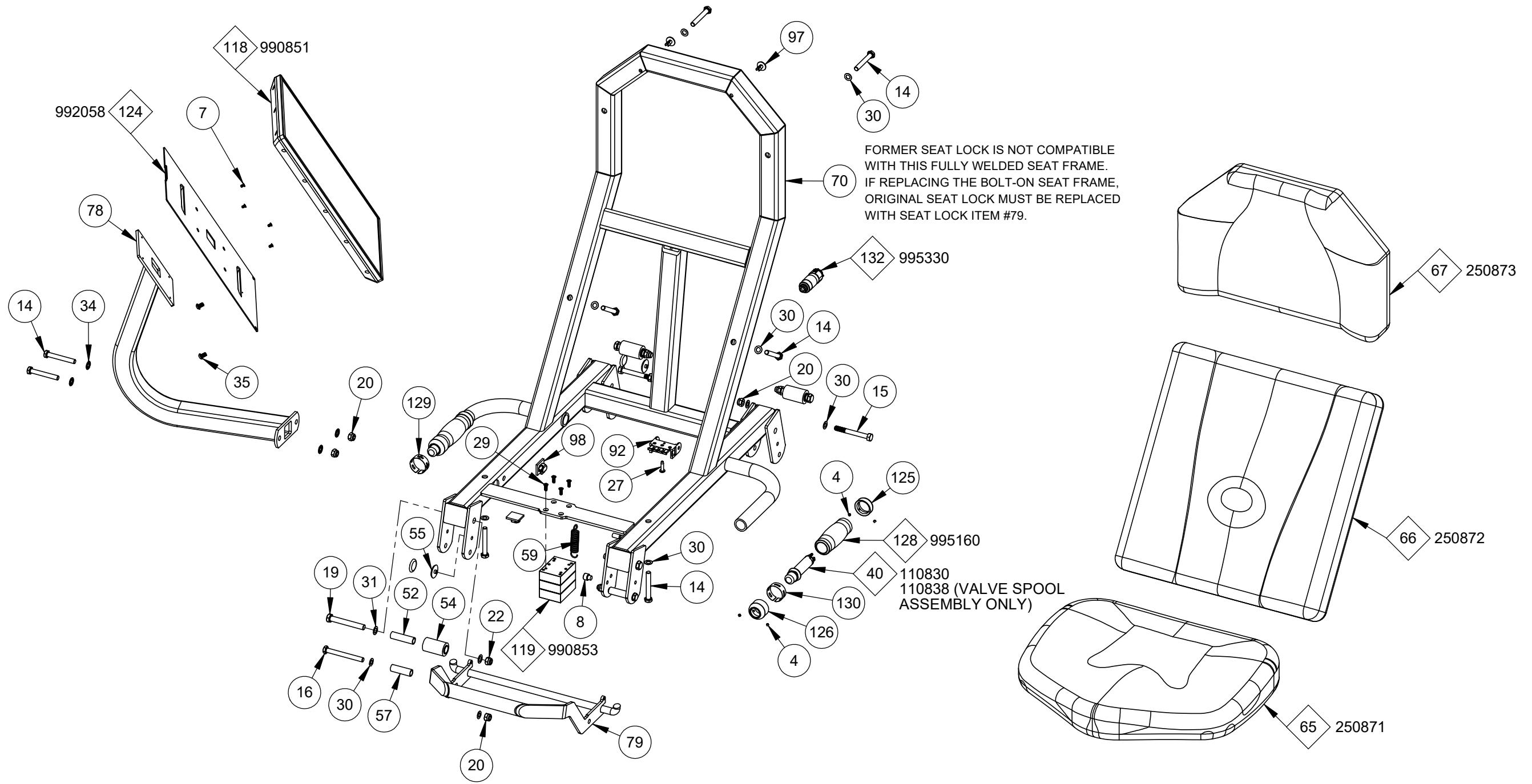
COMMONLY SERVICED COMPONENTS

NOTE:

THIS DRAWING COVERS: 2531B4 & 2531X4

KEISER <small>2470 South Cherry Ave. Phone: (559) 256-8000 Fresno, CA USA 93705-5004 Fax: (559) 256-8100 THE INFORMATION DISCLOSED HEREIN WAS ORIGINATED BY AND IS THE PROPERTY OF KEISER CORP. AND ALL PATENT, PROPRIETARY DESIGN, USE, SALE, MANUFACTURING, AND REPRODUCTION RIGHTS THERE TO ARE RESERVED BY KEISER CORP.</small>		ECO BY: JC	ECO ENGINEER: MP	ECO CHECK BY: LC	ECO DATE: 4/30/26	ECO: 4538
DIMENSIONS ARE IN INCHES DIMENSIONS IN [] ARE MILLIMETERS BREAK SHARP EDGES .005-.015 [.10-.40] MACHINED SURFACE FINISH IS 63 MICRONS [1.6 MICROMETERS]		PROJECT ENGINEER: LC	DRAWN BY: JC		ORIGINATION DATE: 11/21/24	
REV: C REFERENCE WM BOM REV G		MATERIAL:				MATERIAL #:
		TITLE: A400 LEG PRESS - SA			PART #: 2531X4-SA	REV: C

COMMONLY SERVICED COMPONENTS

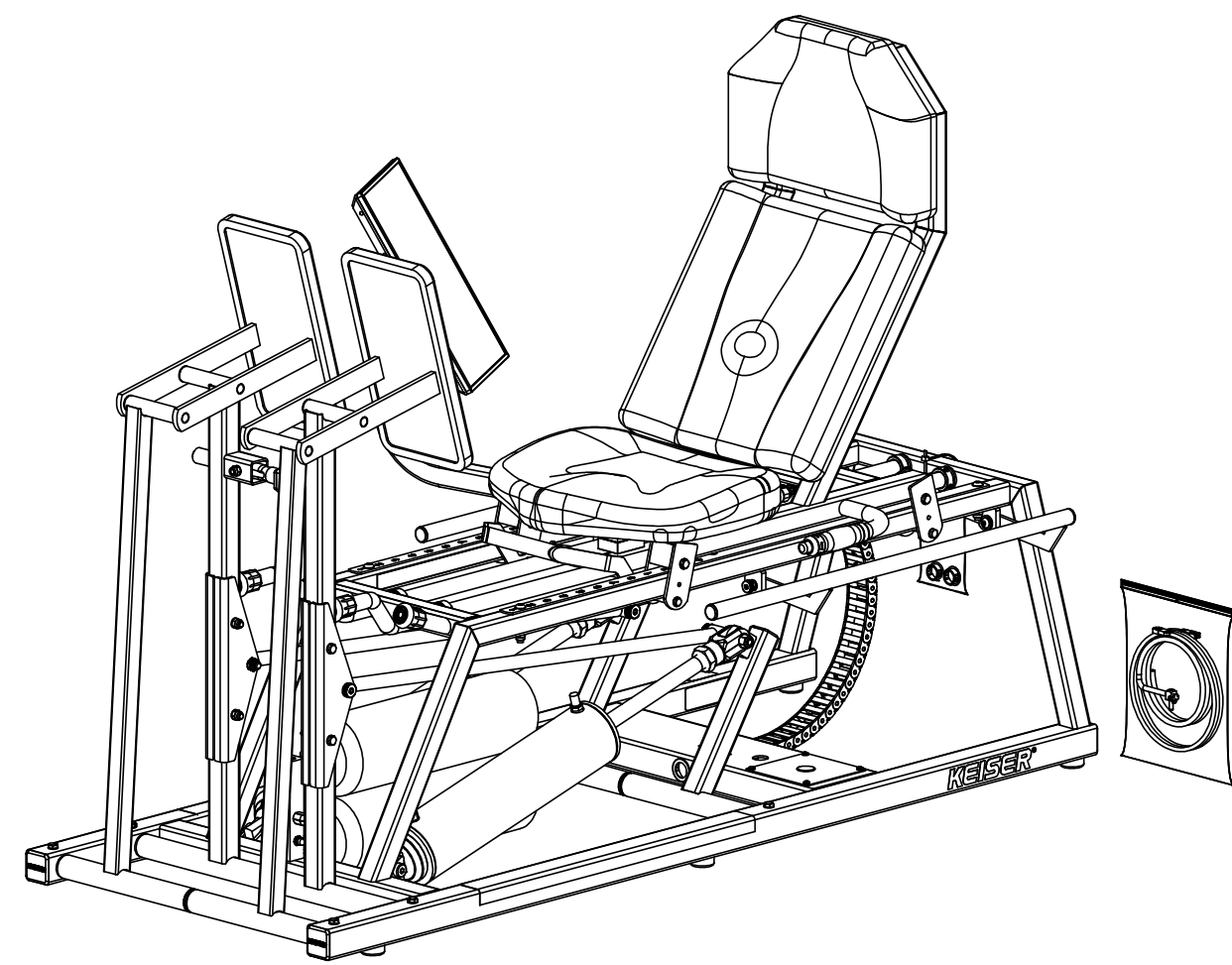


FORMER SEAT LOCK IS NOT COMPATIBLE WITH THIS FULLY WELDED SEAT FRAME. IF REPLACING THE BOLT-ON SEAT FRAME, ORIGINAL SEAT LOCK MUST BE REPLACED WITH SEAT LOCK ITEM #79.

SHEET: 2 OF 3 SIZE: B SCALE: 1:8 (DO NOT SCALE DRAWING) LAST SAVED: 4/30/2026

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		JC	MP	LC	4/30/26	4538
DIMENSIONS ARE IN INCHES DIMENSIONS IN [] ARE MILLIMETERS BREAK SHARP EDGES .005-.015 [.10-.40] MACHINED SURFACE FINISH IS 63 MICRONS [1.6 MICROMETERS]		PROJECT ENGINEER:		DRAWN BY:		ORIGINATION DATE:
		LC		JC		11/21/24
REV: C REFERENCE WM BOM REV G		MATERIAL:				MATERIAL #:
		TITLE: A400 LEG PRESS - SA				PART #: 2531X4-SA

ITEM NO.	QTY.	PART NO.	TITLE	ITEM NO.	QTY.	PART NO.	TITLE	ITEM NO.	QTY.	PART NO.	TITLE
1	3	8043	CON - 3/16 BARB X 1/8 BARB	64	1	250814X	MANIFOLD ASSY - A400	119	1	990853	VALVE BLOCK - A400
2	2	8155	ELBOW - 1/2C X 3/8M	65	1	250871	CUSHION - SEAT-A400	120	2	990856	CYL - XDCR-4000 X 12000
3	8	9001	PIN SPRING - 3/16 X 1/2	66	1	250872	CUSHION - BACK-A400	121	1	990862	KIT - INSTALLATION-A400
4	8	9014	SCREW - HSSS 8-32 X 1/8 SS	67	1	250873	CUSHION - HEAD-A400	122	1	990879	MODULE - POWER ENTRY-MDR
5	6	9026	SCREW - HSSS 5/16-18 X 1/4 ZP	68	1	250907	L EX ARM	123	1	990881	CKT BRD - PROCESSOR-A400-W SOFTWARE
6	2	9027	SCREW - HSSS 0313-18 X 0375 ZP	69	1	250908	R EX ARM	124	1	992058	PLATE - DISPLAY BACK-A400
7	4	9087	SCREW - CRFCHMS 6-32 X 1/4 SS	70	1	250911	FRAME - SEAT	125	2	995000	COLLAR - GRIP
8	1	9104	SCREW - SHCS 5/16-18 X 1/4 ZP	71	2	250913	DRAG LINK	126	2	995001	CAP - GRIP W HOLE
9	4	9112	SCREW - SBHCS-0375 16 X 2250 ZP	72	2	250915	PEDAL - FOOT-A420	127	1	995083	BUSHING - SNAP-1-3/8
10	2	9126	SCREW - SHSS 1/2 X 3/4 ZP	73	1	250919	L STOP HANDLE	128	2	995160	GRIP - MOLDED
11	2	9128	SCREW - SHSS 5/8 X 1-1/4 ZP	74	1	250920	R STOP HANDLE	129	1	995300	DECAL - TB-PLUS
12	2	9129	SCREW - SHSS 5/8 X 1 3/4 BLK	75	2	250921	COLLAR - CONNECTOR	130	1	995301	DECAL - TB-MINUS
13	2	9130	SCREW - SHSS 5/8 X 2 3/4 BLK	76	2	250923	LEVER ARM	131	1	995324	DECAL - MADE IN THE USA
14	8	9179	SCREW - HHCS 5/16-18 X 2-1/4 ZP	77	2	250929	EXERCISE ARM - A420	132	1	995330	FILTER - IN LINE-8MM PTC
15	2	9181	SCREW - HHCS 5/16-18 X 2 3/4 ZP	78	1	250933	DISPLAY MT - A400	133	1	995418	BAG - 4 X 6 X 4MIL-ZIP LOCK
16	2	9184	SCREW - HHCS 5/16-18 X 3 ZP	79	1	250938	SEAT LOCK - EXTENDED				
17	7	9205	SCREW - HHCS 3/8-16 X 2 ZP	80	1	250947	FRAME - MAIN-2531				
18	4	9207	SCREW - HHCS 3/8-16 X 2-1/2 ZP	81	2	252000	BRKT - DRAG LINK 1/2 H				
19	4	9208	SCREW - HHCS 3/8-16 X 2-3/4 ZP	82	2	252001	BRKT - DRAG LINK 5/8 H				
20	6	9226	NUT - HELN 5/16-18 ZP	83	1	252050	PLATE - COVER-PROCESSOR-A400				
21	8	9227	NUT - HRLN 3/8-16 ZP	84	4	252180	SHAFT - FOOT PEDAL				
22	19	9228	NUT - HELN 3/8-16 ZP	85	2	252242	SHAFT - LONG-ARM STOP				
23	4	9230	NUT - HEJN 1/2-13 ZP	86	1	252247	ROD - ARM LOCK				
24	2	9241	NUT - HELN 1/2-13 ZP	87	4	255051	CAP - Ø1-PL				
25	6	9255	SCREW - CRPHMS 6-32 X 1/4 ZP	88	2	255052	PLASTIC CONNECTOR				
26	6	9279	SCREW - SBHTS-TF 5/16-18 X 3/4 ZP	89	2	255053	SLEEVE BUSHING				
27	1	9285	SCREW - CRPHTS 10-24 X 3/4 ZP	90	1	255057	LOCKING SLEEVE				
28	2	9308	SCREW - CRPHMS 8-32 X 1/2 ZP	91	1	255060	CABLE CARRIER - LAY IN-29 LINKS				
29	4	9310	SCREW - CRFCHMS 8-32 X 1/2 ZP	92	1	255062	BRKT SET - CABLE CARRIER-DRILLED				
30	14	9353	WASHER - THIN-ACFT 0313 SS	93	2	255300	RED DOT				
31	36	9355	WASHER - FW-ACFT-3/8 SS	94	1	255301	DECAL - ARM STOP				
32	6	9366	WASHER - ITLW #6 ZP	95	2	255407	LONG SS SEAT STRIP				
33	4	9379	WASHER - ITLW 10	96	2	255420	FOOT PAD				
34	4	9389	WASHER - ITLW 5/16 ZP	97	2	265404	PLASTIC RIVET				
35	2	9506	SCREW - SBHCS M6X1 X 10 ZP	98	2	545055	ANCHOR - CABLE PL				
36	4	9546	SCREW - CRPHMS 10-32 X 5/16 SS	99	1	953098	TUBING - 8MM URETHANE-BLK				
37	1	105058	PLUG - DIA 1-CLEAR	100	1	953102	TUBING - .500 OD X .062 W-PE BLK				
38	6	105423	BUMPER - MOLDED GLIDE	101	1	953108	TUBING - 1/4 URETHANE BLK				
39	1	105443	DECAL - SN-STRENGTH-CE	102	1	955300	STRIP - PROTECTOR-4 INCH				
40	2	110830	ASSY - TB VALVE-DIG	103	1	955306	TAPE - 6.7 MIL UHMW-1" TRANSPARENT				
41	6	113040	SHOULDER SLEEVE - 1/2 X 1/2	104	2	962004	CON - 2MM-2-S				
42	4	115051	BEARING - FLANGE-0.500 ID	105	2	962005	CON - MOD - P-4P-4C				
43	16	115052	BEARING - FLANGE-0.625 ID	106	4	962006	CON - MOD-P-6P-4C				
44	4	115054	PLUG - 2 IN SQ-KEISER	107	2	962055	CON - 2MM-8-S				
45	4	115056	BEARING - FLANGE-0.625 ID-SHORT	108	1	962070	CON - 2.5MM-6-S				
46	2	115372	DECAL - KEISER LOGO-1 1/4" RED	109	2	962071	CON - S-20-24 AWG-CRIMP-TIN				
47	5	115404	PLUG - HOLE-1 DIA	110	1	962072	CON - 3MM-2-S				
48	28	115423	TIE - 8 IN-PL BLK	111	2	962073	CON - S-20-24 AWG-CRIMP-MOLEX				
49	1	115429	PLASTIC TIE - 10" RED	112	2	962074	CON - MOD-P-8P-8C				
50	6	115450	WASHER - FW .88 X .39 X .07 NP	113	1	964506	FILTER - FERRITE-310 OHM				
51	6	115451	SCREW - SBHCS 3/8-16 X 1-1/4 NP	114	1	966701	WIRE - CABLE-4-26 GA				
52	4	133040	TUBE - ROLLER	115	1	966712	WIRE - CABLE-2-22 GA				
53	16	135050	BEARING - FLANGE-1" ID	116	1	966717	WIRE - CABLE-8-24 GA				
54	4	135053	SEAT ROLLER - LONG	117	1	966746	WIRE - CABLE-4 CIRCUIT-MICROFIT-0.5M				
55	6	135055	STEM BUMPER	118	1	990851	DISPLAY MODULE - A400				
56	2	135056	CAP - 1.500 SQ-PL								
57	2	135403	SEAT SLEEVE								
58	4	135422	RUBBER CRUTCH TIP #20 BLK								
59	1	135424	SPRING - PEDAL								
60	3	152244	SHAFT - PIVOT								
61	2	155369	TANK - 300 CU IN-PAINTED								
62	1	170891	ASSY - MUFFLER-LONG								
63	2	222350	GRIP COLLAR - 1000 ID								

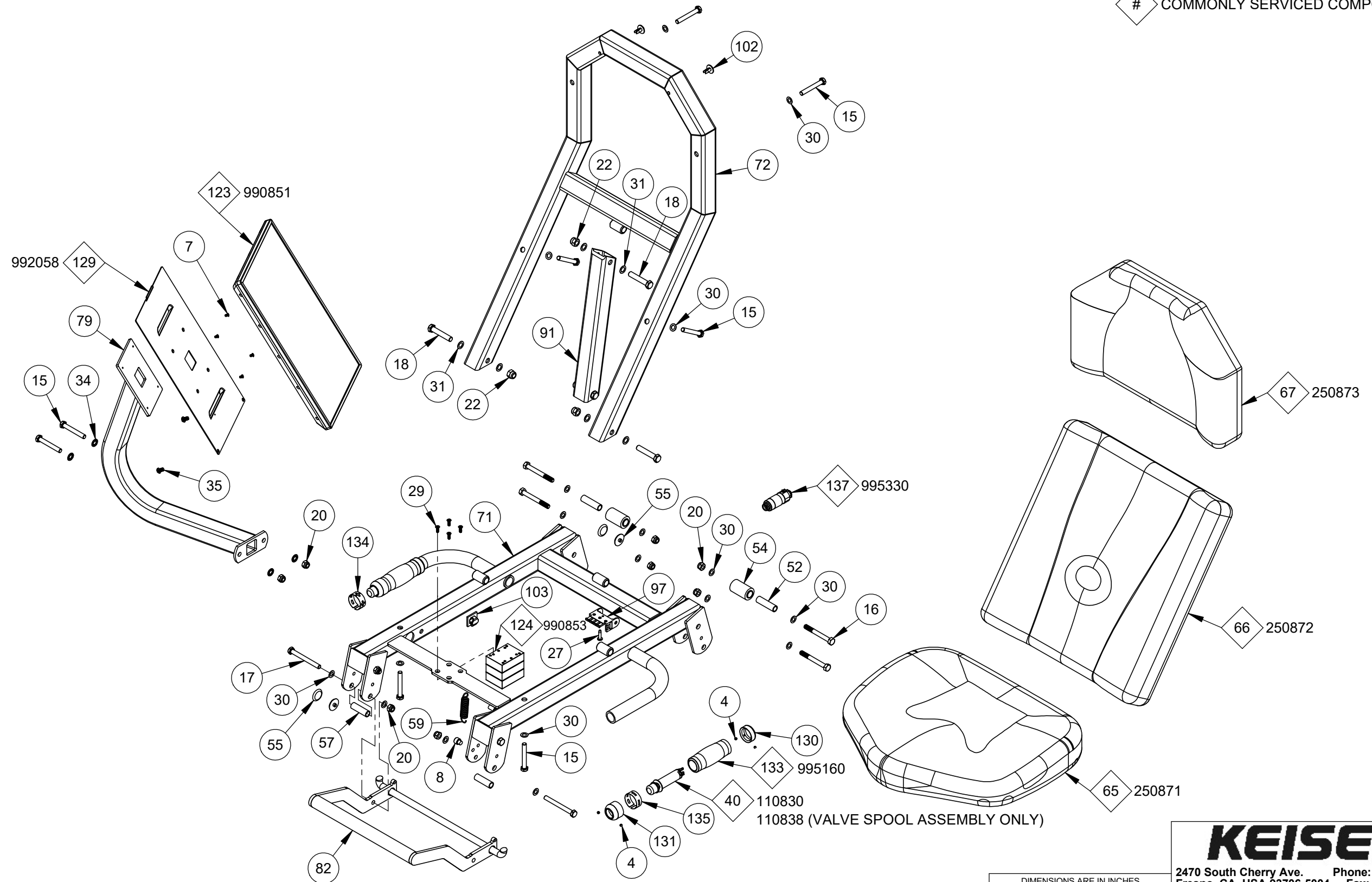


REV: C		REFERENCE WM BOM REV G	<p>KEISER 2470 South Cherry Ave. Phone: (559) 256-8000 Fresno, CA USA 93705-5004 Fax: (559) 256-8100 THE INFORMATION DISCLOSED HEREIN WAS ORIGINATED BY AND IS THE PROPERTY OF KEISER CORP. AND ALL PATENT, PROPRIETARY DESIGN, USE, SALE, MANUFACTURING, AND REPRODUCTION RIGHTS THERE TO ARE RESERVED BY KEISER CORP.</p>		ECO BY: JC	ECO ENGINEER: MP	ECO CHECK BY: LC	ECO DATE: 4/30/26	ECO: 4538
			DIMENSIONS ARE IN INCHES DIMENSIONS IN [] ARE MILLIMETERS BREAK SHARP EDGES .005-.015 [.10-.40] MACHINED SURFACE FINISH IS 63 MICRONS [1.6 MICROMETERS]		PROJECT ENGINEER: LC		DRAWN BY: JC		ORIGINATION DATE: 11/21/24
					MATERIAL: MATERIAL #:				
					TITLE: A400 LEG PRESS - SA			PART #: 2531X4-SA	REV: C

SHEET: 3 OF 3 SIZE: B SCALE: 1:12 (DO NOT SCALE DRAWING) LAST SAVED: 4/30/2026

2531X4-SA

COMMONLY SERVICED COMPONENTS



PRINTED ON: 9/12/2025

DIMENSIONS ARE IN INCHES
 DIMENSIONS IN [] ARE MILLIMETERS
 BREAK SHARP EDGES .005-.015 [.10-.40]
 MACHINED SURFACE FINISH IS
 63 MICROINCHES [1.6 MICROMETERS]
 DO NOT SCALE DRAWING

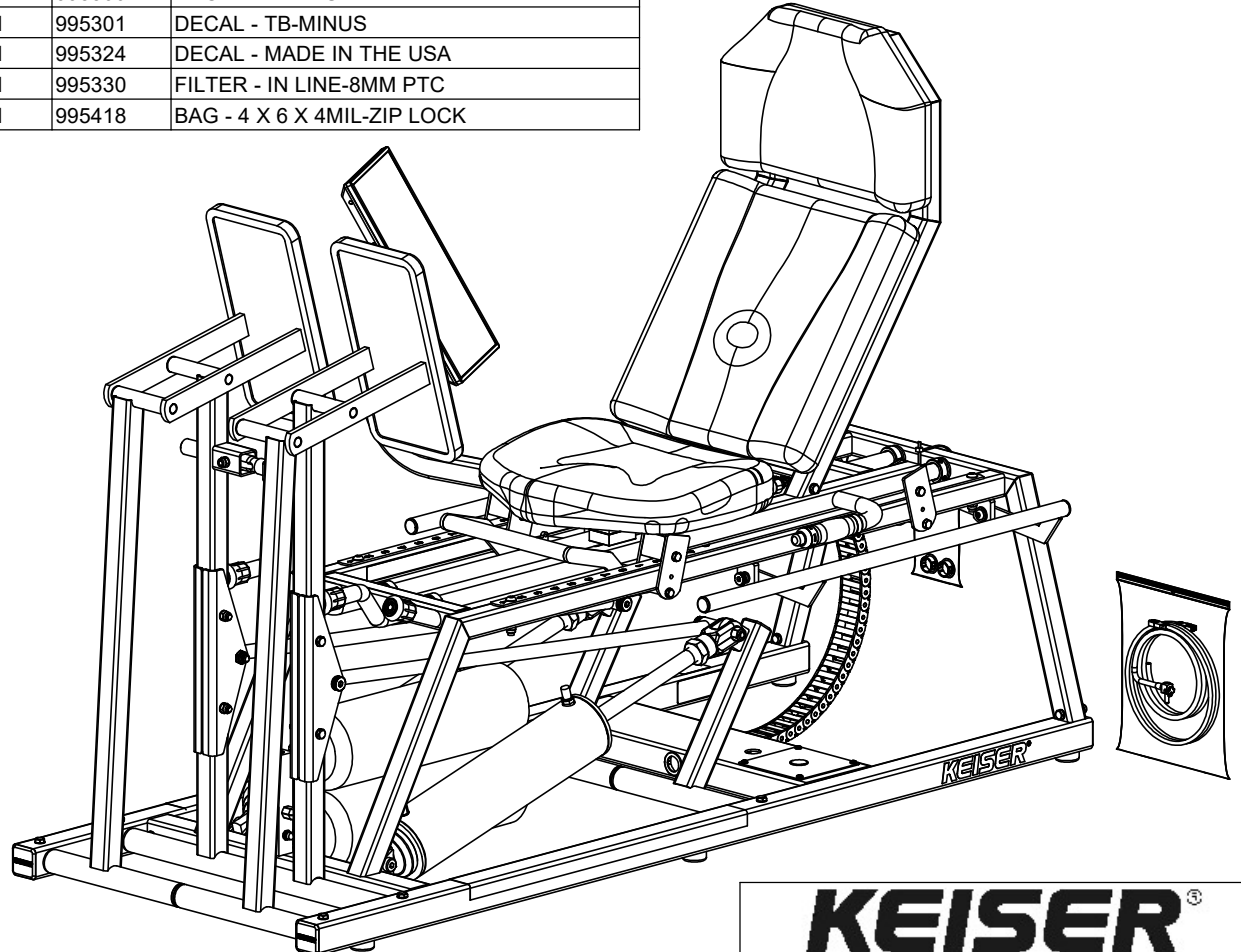
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 CORP.

B	4445	REFERENCE WM BOM REV F	JC	LC	9/12/25	
REV	ECO	REVISION DESCRIPTION	BY	CKD	DATE	

DRAWN BY:	JC	DATE DRAWN:	9/12/24	CHECKED BY:	LC	DATE CHECKED:	11/21/24
MATERIAL:							
RAW MAT:						MASS (Kg):	
SHEET 2 OF 3		SCALE:	1:8	DRAWING SIZE:	B	PART#: 2531X4-SA	
TITLE:		A400 LEG PRESS - SA					

2531X4-SA

ITEM NO.	QTY.	PART NO.	TITLE	ITEM NO.	QTY.	PART NO.	TITLE	ITEM NO.	QTY.	PART NO.	TITLE
1	3	8043	CON - 3/16 BARB X 1/8 BARB	62	1	170891	ASSY - MUFFLER-LONG	115	1	962072	CON - 3MM-2-S
2	2	8155	ELBOW - 1/2C X 3/8M	63	2	222350	GRIP COLLAR - 1000 ID	116	2	962073	CON - S-20-24 AWG-CRIMP-MOLEX
3	8	9001	PIN SPRING - 3/16 X 1/2	64	1	250814X	MANIFOLD ASSY - A400	117	2	962074	CON - MOD-P-8P-8C
4	8	9014	SCREW - HSSS 8-32 X 1/8 SS	65	1	250871	CUSHION - SEAT-A400	118	1	964506	FILTER - FERRITE-310 OHM
5	6	9026	SCREW - HSSS 5/16-18 X 1/4 ZP	66	1	250872	CUSHION - BACK-A400	119	1	966701	WIRE - CABLE-4-26 GA
6	2	9027	SCREW - HSSS 0313-18 X 0375 ZP	67	1	250873	CUSHION - HEAD-A400	120	1	966712	WIRE - CABLE-2-22 GA
7	4	9087	SCREW - CRFCHMS 6-32 X 1/4 SS	68	1	250907	L EX ARM	121	1	966717	WIRE - CABLE-8-24 GA
8	1	9104	SCREW - SHCS 5/16-18 X 1/4 ZP	69	1	250908	R EX ARM	122	1	966746	WIRE - CABLE-4 CIRCUIT-MICROFIT-0.5M
9	4	9112	SCREW - SBHCS-0375 16 X 2250 ZP	70	2	250909	EX ARM	123	1	990851	DISPLAY MODULE - A400
10	2	9126	SCREW - SHSS 1/2 X 3/4 ZP	71	1	250911	SEAT BOT	124	1	990853	VALVE BLOCK - A400
11	2	9128	SCREW - SHSS 5/8 X 1-1/4 ZP	72	1	250912	SEAT BACK	125	2	990856	CYL - XDCR-4000 X 12000
12	2	9129	SCREW - SHSS 5/8 X 1 3/4 BLK	73	2	250913	DRAG LINK	126	1	990862	KIT - INSTALLATION-A400
13	2	9130	SCREW - SHSS 5/8 X 2 3/4 BLK	74	2	250914	PEDAL - FOOT	127	1	990879	MODULE - POWER ENTRY-MDR
14	2	9166	SCREW - HHCS 3/8-16 X 6 1/2 ZP	75	1	250919	L STOP HANDLE	128	1	990881	CKT BRD - PROCESSOR-A400-W SOFTWARE
15	8	9179	SCREW - HHCS 5/16-18 X 2-1/4 ZP	76	1	250920	R STOP HANDLE	129	1	992058	PLATE - DISPLAY BACK-A400
16	6	9181	SCREW - HHCS 5/16-18 X 2 3/4 ZP	77	2	250921	COLLAR - CONNECTOR	130	2	995000	COLLAR - GRIP
17	2	9184	SCREW - HHCS 0313-18 X 3000 ZP	78	2	250923	LEVER ARM	131	2	995001	CAP - GRIP W HOLE
18	13	9205	SCREW - HHCS 3/8-16 X 2 ZP	79	1	250933	DISPLAY MT - A400	132	1	995083	BUSHING - SNAP-1-3/8
19	6	9207	SCREW - HHCS 3/8-16 X 2-1/2 ZP	80	1	250935	L BOT FRM - A400	133	2	995160	GRIP - MOLDED
20	10	9226	NUT - HELN 5/16-18 ZP	81	1	250936	R BOT FRM - A400	134	1	995300	DECAL - TB-PLUS
21	8	9227	NUT - HRLN 3/8-16 ZP	82	1	250938	SEAT LOCK - EXTENDED	135	1	995301	DECAL - TB-MINUS
22	25	9228	NUT - HELN 3/8-16 ZP	83	1	250941	WELDT - CROSS TUBE-A400	136	1	995324	DECAL - MADE IN THE USA
23	4	9230	NUT - HEJN 1/2-13 ZP	84	1	250947	FRAME - MAIN-TOP	137	1	995330	FILTER - IN LINE-8MM PTC
24	2	9241	NUT - HELN 1/2-13 ZP	85	2	252000	BRKT - DRAG LINK 1/2 H	138	1	995418	BAG - 4 X 6 X 4MIL-ZIP LOCK
25	6	9255	SCREW - CRPHMS 6-32 X 1/4 ZP	86	2	252001	BRKT - DRAG LINK 5/8 H				
26	6	9279	SCREW - SBHTS-TF 5/16-18 X 3/4 ZP	87	1	252050	PLATE - COVER-PROCESSOR-A400				
27	1	9285	SCREW - CRPHTS 10-24 X 3/4 ZP	88	4	252180	SHAFT - FOOT PEDAL				
28	2	9308	SCREW - CRPHMS 8-32 X 1/2 ZP	89	2	252242	SHAFT - LONG-ARM STOP				
29	4	9310	SCREW - CRFCHMS 8-32 X 1/2 ZP	90	1	252247	ROD - ARM LOCK				
30	22	9353	WASHER - THIN-ACFT 0313 SS	91	1	254171	BOT CTR TUBE - SEAT BACK				
31	48	9355	WASHER - FW-ACFT-3/8 SS	92	4	255051	CAP - Ø1-PL				
32	6	9366	WASHER - ITLW #6 ZP	93	2	255052	PLASTIC CONNECTOR				
33	4	9379	WASHER - ITLW 10	94	2	255053	SLEEVE BUSHING				
34	4	9389	WASHER - ITLW 5/16 ZP	95	1	255057	LOCKING SLEEVE				
35	2	9506	SCREW - SBHCS M6X1 X 10 ZP	96	1	255060	CABLE CARRIER - LAY IN-29 LINKS				
36	4	9546	SCREW - CRPHMS 10-32 X 5/16 SS	97	1	255062	BRKT SET - CABLE CARRIER-DRILLED				
37	1	105058	PLUG - DIA 1-CLEAR	98	2	255300	RED DOT				
38	6	105423	BUMPER - MOLDED GLIDE	99	1	255301	DECAL - ARM STOP				
39	1	105443	DECAL - SN-STRENGTH-CE	100	2	255407	LONG SS SEAT STRIP				
40	2	110830	ASSY - TB VALVE-DIG	101	2	255420	FOOT PAD				
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42	4	115051	BEARING - FLANGE-0.500 ID	103	1	545055	ANCHOR - CABLE PL				
43	16	115052	BEARING - FLANGE-0.625 ID	104	1	953098	TUBING - 8MM URETHANE-BLK				
44	4	115054	PLUG - 2 IN SQ-KEISER	105	1	953102	TUBING - .500 OD X .062 W-PE BLK				
45	4	115056	BEARING - FLANGE-0.625 ID-SHORT	106	1	953108	TUBING - 1/4 URETHANE BLK				
46	2	115372	DECAL - KEISER LOGO-1 1/4" RED	107	1	955300	STRIP - PROTECTOR-4 INCH				
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48	19	115423	TIE - 8 IN-PL BLK	109	2	962004	CON - 2MM-2-S				
49	1	115429	PLASTIC TIE - 10" RED	110	2	962005	CON - MOD - P-4P-4C				
50	6	115450	WASHER - FW .88 X .39 X .07 NP	111	4	962006	CON - MOD-P-6P-4C				
51	6	115451	SCREW - SBHCS 3/8-16 X 1-1/4 NP	112	2	962055	CON - 2MM-8-S				
52	4	133040	TUBE - ROLLER	113	1	962070	CON - 2.5MM-6-S				
53	16	135050	BEARING - FLANGE-1" ID	114	2	962071	CON - S-20-24 AWG-CRIMP-TIN				
54	4	135053	SEAT ROLLER - LONG								
55	6	135055	STEM BUMPER								
56	2	135056	CAP - 1.500 SQ-PL								
57	2	135403	SEAT SLEEVE								
58	4	135422	RUBBER CRUTCH TIP #20 BLK								
59	1	135424	SPRING - PEDAL								
60	3	152244	SHAFT - PIVOT								
61	2	155369	TANK - 300 CU IN-PAINTED								



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MATERIAL:		RAW MAT:		MASS (Kg):					
REV B		4445		REFERENCE WM BOM REV F		JC LC		9/12/25	
REV ECO				REVISION DESCRIPTION		BY CKD		DATE	
SHEET 3		OF 3		SCALE: 1:12		DRAWING SIZE: B		PART#: 2531X4-SA	

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