

BOM FOR ASSEMBLY 21320		
COMPONENT	DESCRIPTION	QTY
13580	WASHER, #8 SAE FLAT	2
18012	COVER, LOWER, RH, 4600	1
18013	COVER, LOWER, LH, 4600	1
18072	RIVET, PERM.	19
20006	SPROCKET, BS14 #41 CHAIN	1
20008	LINK, MASTER, #41	1
20157	LINK, MASTER, #40	2
20188	MOUNT, SHOCK	2
20195	BEARING, CLUTCH	2
20196	BEARING, NEEDLE I ID X1-1/4 OD X1/2	2
20197	WASHER, THRUST	8
20198	BEARING, THRUST	4
20199	CHAIN, STEP	2
20205	ALTERNATOR	1
20206	SNAPRING, ODI, 125, ID, 906	1
20213	RING, SNAP, .75	2
20214	SNAPRING, .375	2
20329	LINK, DOUBLE PITCH	2
20423	TYRAP, 1/8 X 7.515	2
20507	POWER CORD, EUROPEAN	1
20576	SPROCKET, 13T	2
20768	CONNECTOR, SPRING CHAIN	2
20785	ASSY, DRIVE SHAFT, SPRING PIN	1
20787	HUB, DRIVE, PM	1
21017	DECAL, CAUTION, 4000PT/CT, ENGLISH	1
21093	SPRING, PETAL RETURN	2
21192	RETAINER, PEDAL CHAIN	2
21204	ASSY, DIODE	1
21273	DECAL, DISTRIBUTOR, GERMAN	1
21349	ASSY, ARM, LEVELING	2
21350	ASSY, ARM, PEDAL, L.H., PB	1
21351	ASSY, ARM, PEDAL, R.H., PB	1
21366	WASHER, THRUST, .63 ID	4
21448	SCREW, .375-16 X 4.50, HEX HD CAP	1
21452	DECAL, SIDE COVER, 4400 PT	2
21462	WASHER, FLAT, .375	4
21463	SNAPRING, .375, SS	2
21487	DECAL, LEG LEVELING	1
21501	WELDMENT, MAIN FRAME, 2400/4400	1
21510	COVER, UPPER, RH	1
21511	COVER, UPPER, LH	1
21514	COVER, MID	1
21518	belt, poly-v, 430j6	1
21519	PULLEY, SPRING, 4200/4400	2
21529	belt, hfd, 8mm, 80mm	1
21530	HUB, ECCENTRIC, 2400/4400	1
21531	shaft, first red	1
21578	GROMMET, NECK, 2400/4400	1
21590	BRACE, ALTERNATOR, 4400 PT6/CL	1
21592	SPACER, ALTERNATOR, 4400 PT/CL	1
21597	PULLEY, ALTERNATOR, 1.044 DIA	1
21600	bearing, ball, 17mm x 30mm	2
21616	INSERT, NECK, 2400/4400	1
21654	key, woodruff, #605, .188, .625	1
21657	WASHER, THRUST, .688 X .125	3
21673	INSTRUCT., INSTALL INJ MOLD CVR	1
21774	PIN, HITCH	2
21793	ASSY, PEDAL, RH, CL, SYS, V2	1
21794	ASSY, PEDAL, LH, CL, SYS, V2	1
22026	SCREW, 1/4-20 X 1.00, HEX HD CAP	8
22029	NUT, .375-16, NYLON INSERT	1
22030	WASHER, 3/8 USS FLAT	2
22032	NUT, 5/16-18 NC NYLON INSERT HEX	2

BOM FOR ASSEMBLY 21320		
COMPONENT	DESCRIPTION	QTY
22036	NUT .25/20 NYLON INSERT	9
22047	WASHER, .250, FLAT	7
22070	WASHER, .312 SPLIT LOCK	1
22075	WASHER, .312 USS FLAT	9
22093	SCREW, .312-18 X .75, HEX HD CAP	5
22138	WASHER, .250 INTERNAL LOCK	4
22140	WASHER, ODI, 00, ID, 63	2
22141	SNAPRING OD, .715, ID, .595	2
22143	SNAPRING, .375	2
22150	SCREW, #10-24 X .38 ZINC PLATED	1
22175	SCREW, .250-20 X 3.00, HEX HD CAP	1
22191	WASHER, SHOULDER, .38	2
22272	PAD, PEDAL, LH	1
22273	PAD, PEDAL, RH	1
22326	PIN, CLEVIS	2
22347	chain, transmission	1
22375	DECAL, S/M, BC, 1.6 X 1.5	1
22569	MANUAL, OWNER'S, 42/4400PT/CL, ENG	1
22663	SCREW, #6 X .50, PHIL TYPE T	4
22847	RIVET, KIT(10 PER)	1
22878	SET SCREW, .25-28X.38	1
22930	ASSY., LOAD RESISTOR, 4400 PT	1
22983	WASHER, SHOULDER, .25 ID	2
23054	NUT, #8-32, NYLON INSERT	2
23354	SNAP RING, 17MM	1
23638	WASHER, SPACER	2
23719	pin, roll, 3/16x1.5	1
23816	LABEL, WARNING, POWER CONNECTOR	1
23842	SPROCKET, 8MM, HTD, 80 TOOTH	1
23853	TOOL, REMOVAL, COVERS FASTENERS	1
24000	PULLEY, HTD, POLY-V, 8.00 DIA	1
24271	SCREW, .312-18 X 3.00, HEX HD CAP	2
24307	CONNECTOR, POWER	1
24323	CLIP, CABLE, ADHESIVE BACKING	5
24326	DECAL, DOM COMPLIANCE	1
24381	P/S, PS-7, 3 PIN	1
24666	bracket, mounting, covers	2
24747	bearing, needle, 17x23x12	2
25079	SCREW, #8 X 3/8 LG, TYP A, PAN/HD, PH	2
25454	SCREW, .25-20 X .75, HEX	4
25978	WHEEL, 3 IN. DIA.	2
27797	SPACER, C40 CONSOLE	1
27827	ASSY, CABLE, C40 CL	1
(27775)	CONSOLE ASSEMBLY, C40	1

Digitally signed by
CATHEY CLARK
 cn=CATHEY CLARK,
 o=STAIRMASTER,
 c=US
 Date: 2002.02.12
 15:34:39 -0600'
 Reason: Document is released

REVISIONS			
REV	DESCRIPTION	DATE	DRAFTER
AN	REVISED PER ECO #4153	11/5/98	VF
△	REVISED PER ECO #3895	11/10/98	VF
△	REVISED PER ECO #4413	4/2/99	VF
△	REVISED PER ECO #7038	6/16/99	BH
△	REVISED PER ECO #7128	9/17/99	RH
△	REVISED PER ECO #7421	8/1/00	RH
△	REVISED PER ECO #8023	5/21/01	RH
△	REVISED PER ECO #808701	8/9/01	RH
△	REVISED PER ECO #8155	10/16/01	RH
△	REVISED PER ECO #8190	10/31/01	RH
△	REVISED PER ECO #8344	4/29/02	RH
△	REVISED PER ECO #8509	1/29/03	RH

- NOTES:
- DELETED
 - APPLY BEARING GREASE PRIOR TO ASSEMBLY.
 - LUBRICATE WITH GREASE BEFORE ASSEMBLING : STEP CHAIN CONNECTION POINTS, PEDAL ARM SHAFTS, LEVELING ARM SHAFTS, SPRING PULLEY SHAFTS, AND PEDAL SHAFTS.
 - LUBRICATE WITH 10W-30 WT OIL: STEP CHAIN, RETURN SPRING, TRANSMISSION CHAIN, AND SPRING PULLEY EXTERIOR (LIGHTLY)
 - CENTER 6 GROOVE POLY-V BELT IN MIDDLE OF ALTERNATOR AND POLY-V PULLEYS.
 - DELETED
 - DELETED
 - MODEL LEVEL ITEM, REFERENCE MODEL LEVEL BOM 4400 PT
 - MODEL LEVEL ITEM, REFERENCE MODEL LEVEL BOM 4200 PT
 - MODEL LEVEL ITEMS, POWER ADAPTER (20859, JAPAN ONLY) AND POWER CORD (EUROPEAN SHOWN FOR REFERENCE) ARE FOR INTERNATIONAL 220V APPLICATIONS AS ADDITIONAL NON-INSTALLED PARTS TO REPLACE EXISTING POWER CORD AT TIME OF INSTALLATION
 - MODEL LEVEL ITEMS OWNER'S MANUAL (ENGLISH SHOWN FOR REFERENCE), FASTENERS (22847) AND REMOVAL TOOL (23853) AND COVER INSTALLATION INSTRUCTIONS ARE TO BE PACKAGED SEPARATELY AND SHIPPED WITH MACHINE PER MANUFACTURING GUIDELINES.
 - MODEL LEVEL SERIAL NUMBER DECAL TO BE PLACED TOP CENTER OF TUBE, READABLE FROM FRONT OF MACHINE.
 - MODEL LEVEL ITEM. PLACE CLIPS (5X) AGAINST RIBS AS SHOWN.
 - MODEL LEVEL ITEM, 120V MACHINE ONLY.
 - NONE
 - MODEL LEVEL ITEM, DECALS SHOWN IN ENGLISH/DOMESTIC.
 - MODEL LEVEL ITEM, DOMESTIC SHOWN FOR REFERENCE.
 - MODEL LEVEL ITEM, (GERMAN DISTRIBUTOR DECAL SHOWN FOR REFERENCE).
 - MODEL LEVEL ITEM, SEE B.O.M. FOR CONSOLE PART NUMBER
 - MODEL LEVEL ITEM, DECALS SHOWN IN 4400 PT ENGLISH.
 - REFER TO FINAL BOM.
 - TORQUE TO 21 FT. LB.

COVER/FINISH CHART		
P/N	DASH #	COVER/FINISH
21320	-00	N/A
21320	-01	BLACK COVER, WHITE POWDERCOAT
21320	-11	GREY COVER, WHITE POWDERCOAT
21320	-02	TEXTURED BLACK POWDERCOAT
21320	-03	BLACK COVER, WRINKLE BLACK P/C
21320	-13	GREY COVER, WRINKLE BLACK P/C
21320	-04	GLOSS BLACK POWDERCOAT
21320	-05	OUTSIDE PROCESS, SEE NOTES

* SUFFIX DETERMINED BY P/N #21501

TOLERANCES		UNLESS OTHERWISE SPECIFIED:	
.X ±.1	ANGLES:	1. DO NOT SCALE DRAWING	PROOF/PUR MFR
.XX ±.03	BENT ±.2"	2. ALL DIMENSIONS ARE IN INCHES	MG. ENGR
.XXX ±.010	MACHINED ±0°30'	3. ALL DIMENSIONS APPLY BEFORE PLATING OR COATING	DRSN. ENGR
CONFIDENTIAL & PROPRIETARY		4. REMOVE ALL BURRS BREAK SHARP EDGES - 020 MAY ALL MACHINED SURFACES	ENGR. MGR
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FINISH	N/A
SEE CHART	

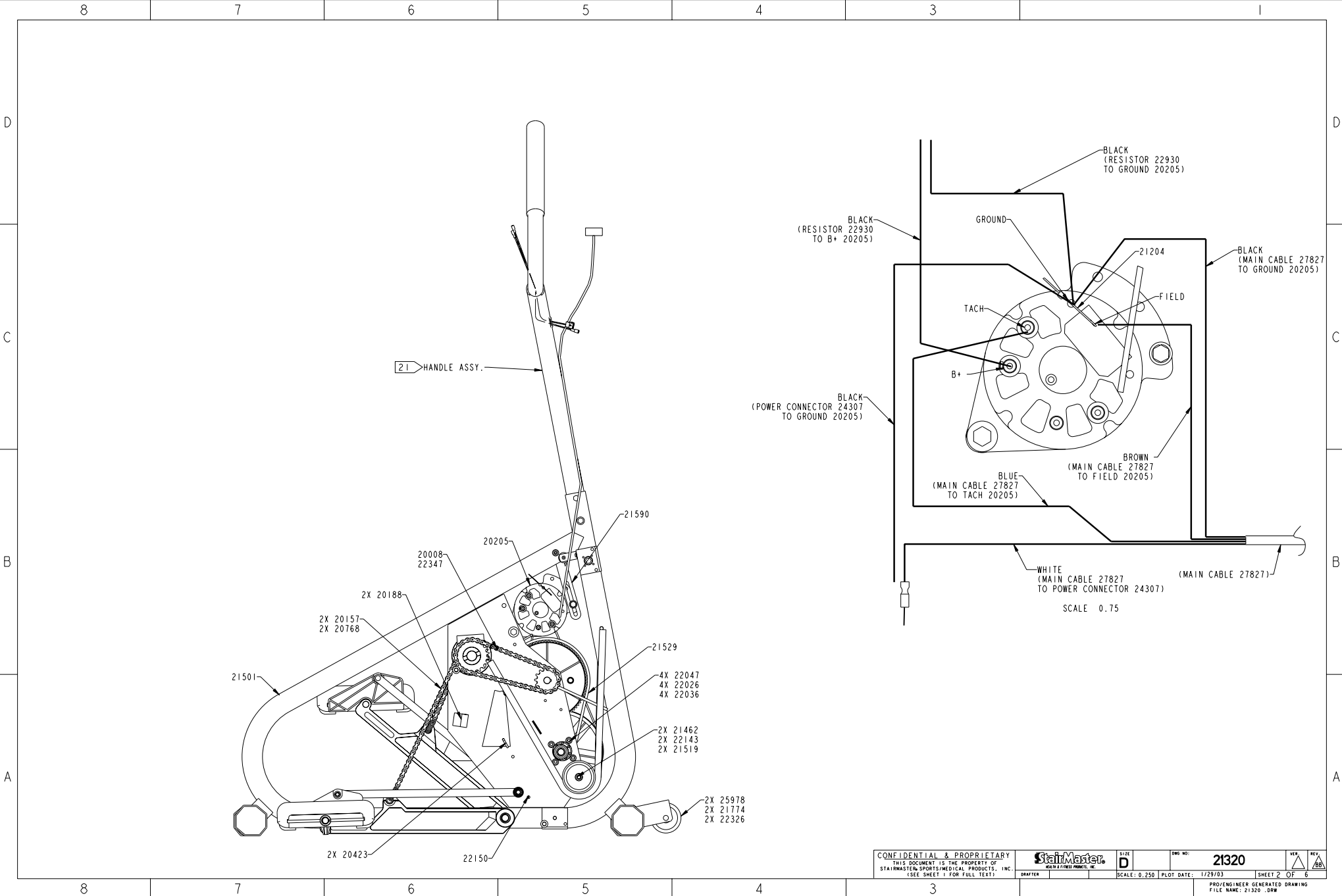
StairMaster HEALTH & FITNESS PRODUCTS, INC.

ASSEMBLY, FINAL, 4400 PT

SIZE: 125
 RELEASED FOR PRODUCTION ECO 2401
 Dwg No: 21320

SCALE: 0.250 | PLOT DATE: 1/29/03 | SHEET 1 OF 6

PRO/ENGINEER GENERATED DRAWING FILE NAME: 21320 - DWG



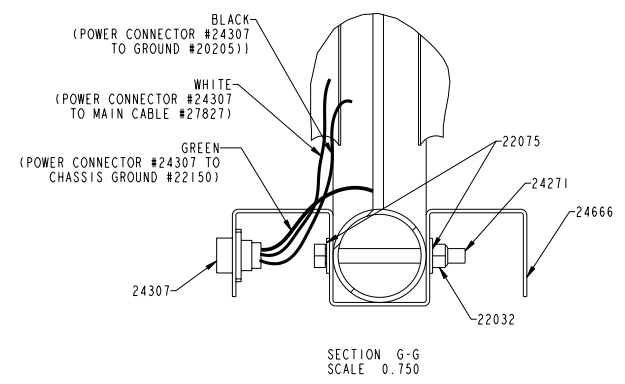
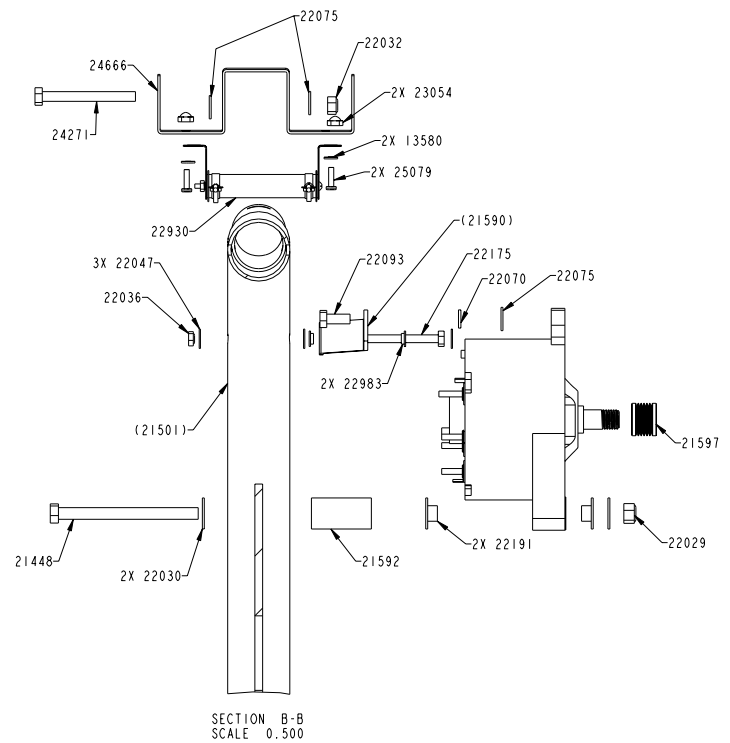
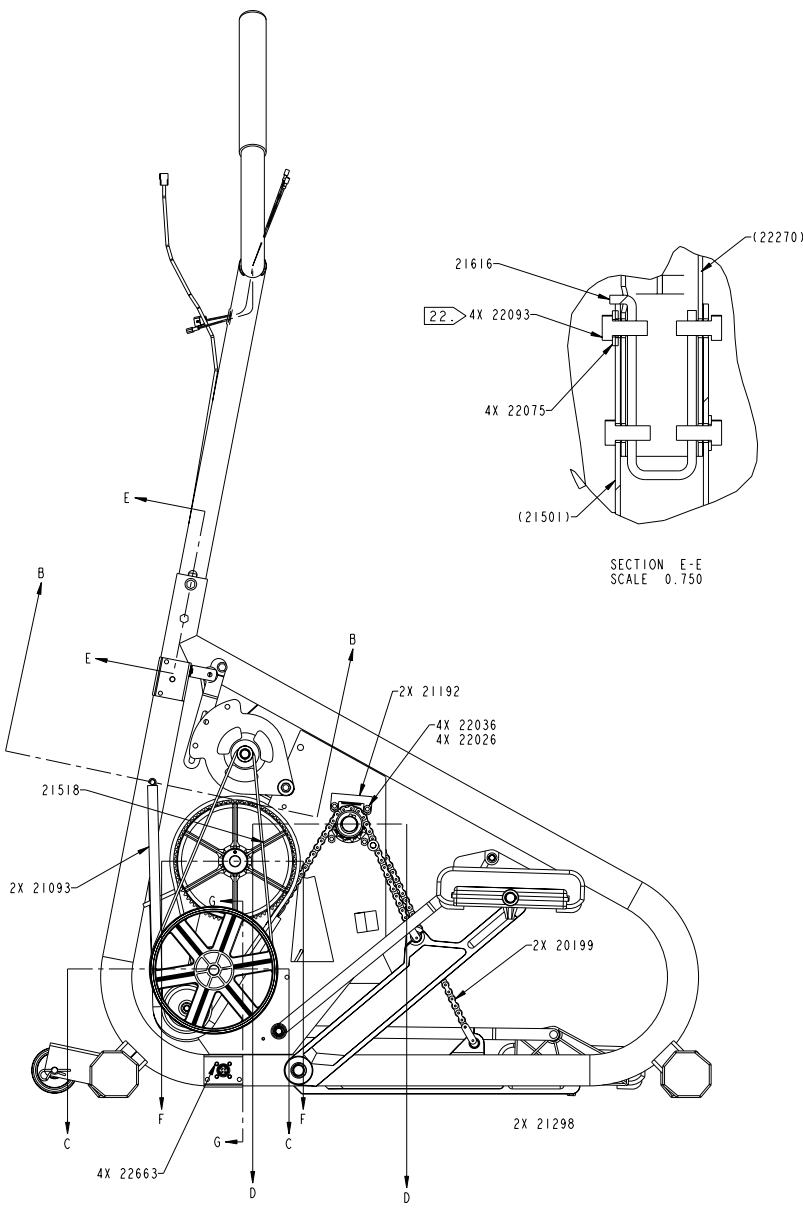
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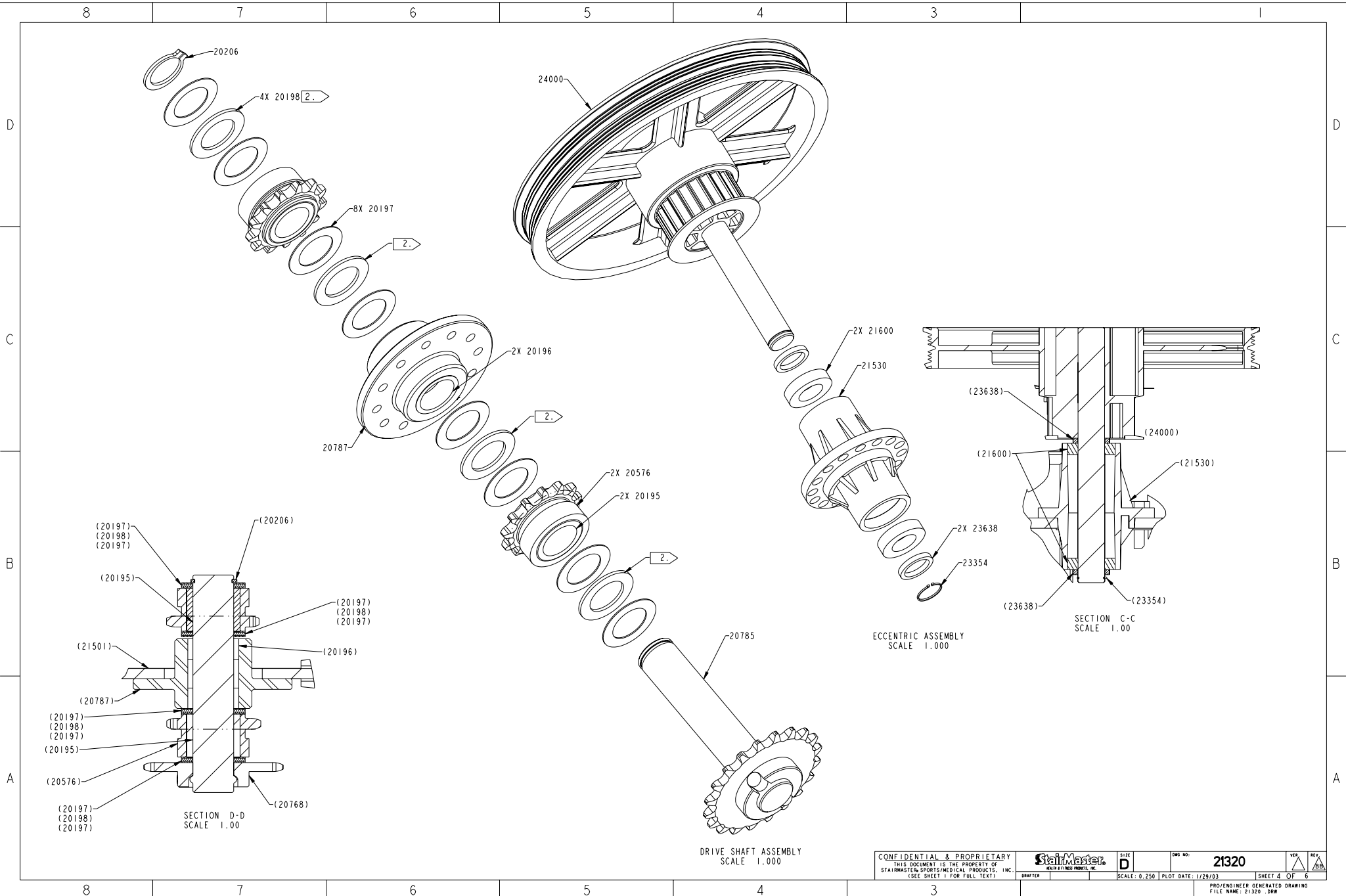
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DRAFTER PART #112210000	SCALE: 0.250	PLOT DATE: 11/29/03	SHEET 3 OF 6		
PRO/ENGINEER GENERATED DRAWING FILE NAME: 21320.DWG					

8 7 6 5 4 3



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DRAFTER NAME: J. J. JONES, JR.	SCALE: 0.250	PLOT DATE: 11/29/03	SHEET 4 OF 6			
PRO/ENGINEER GENERATED DRAWING FILE NAME: 21320.DWG						

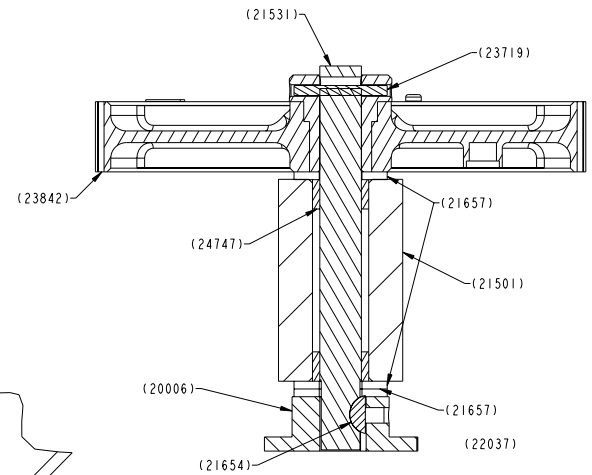
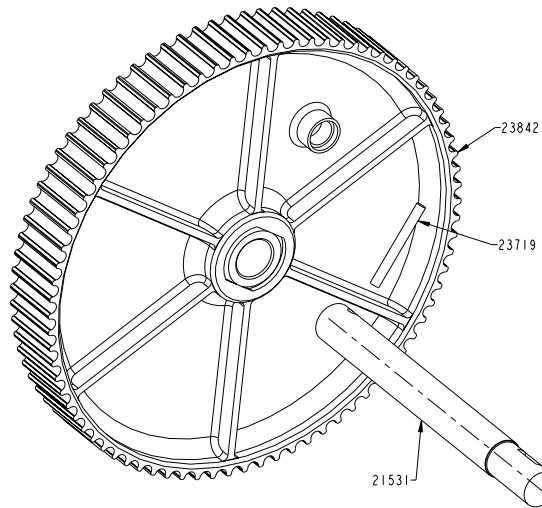
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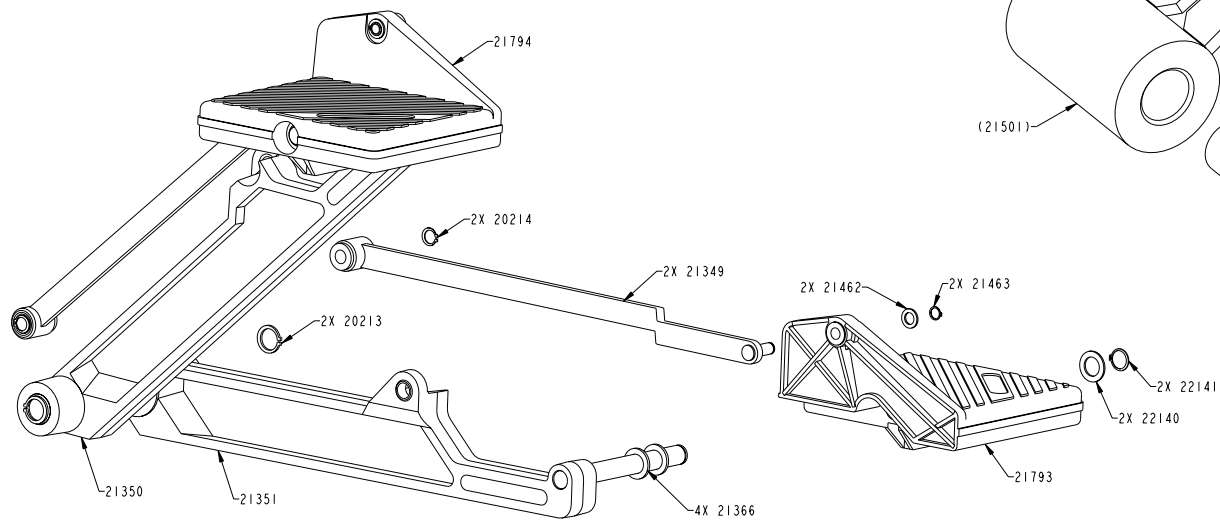
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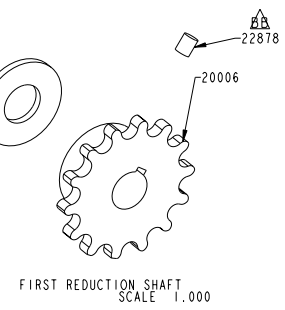
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SECTION F-F
SCALE 1.00



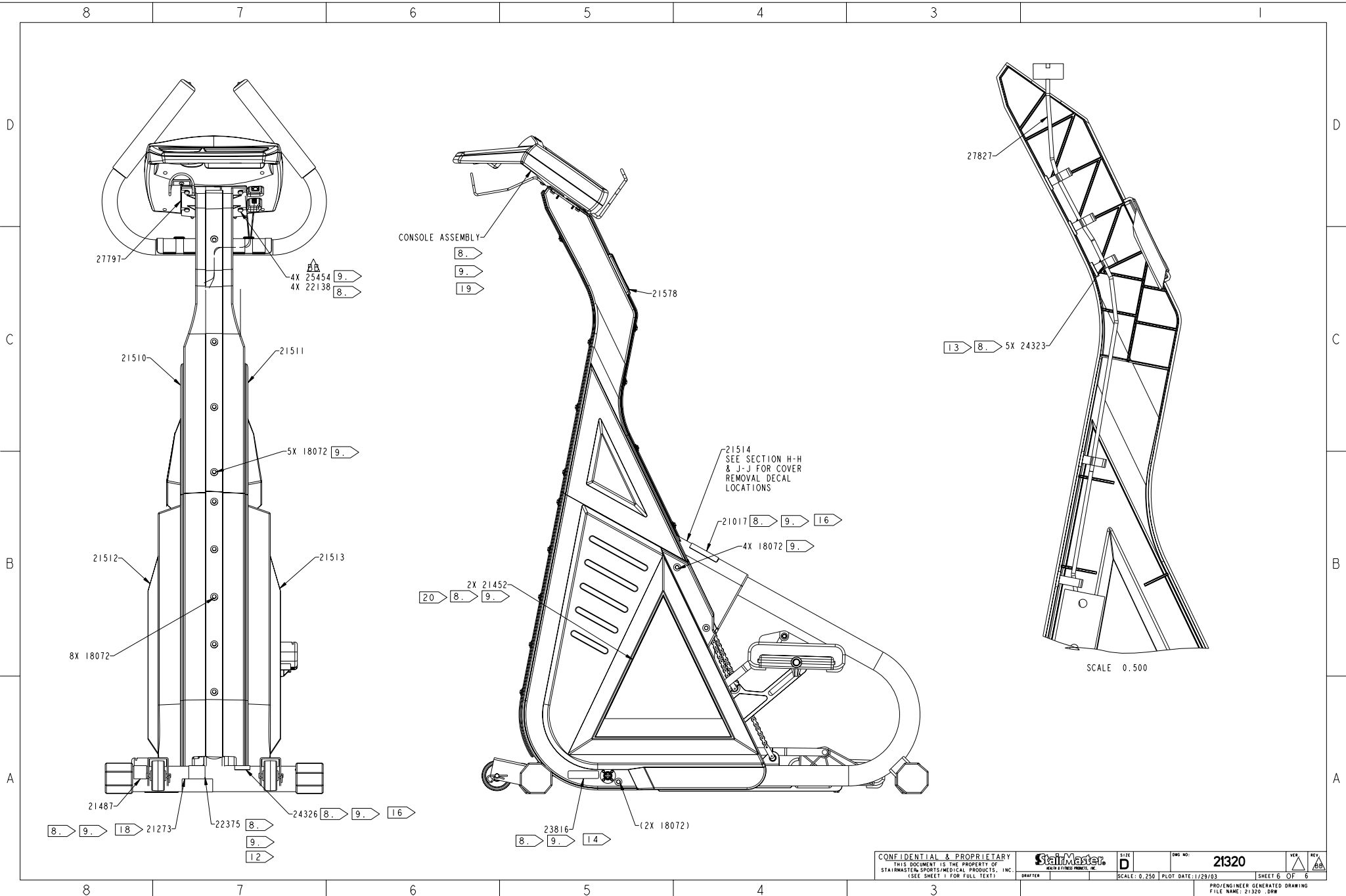
PEDAL SHAFT ASSEMBLY
LEFT PEDAL SHOWN UNEXPLODED
SCALE 0.50

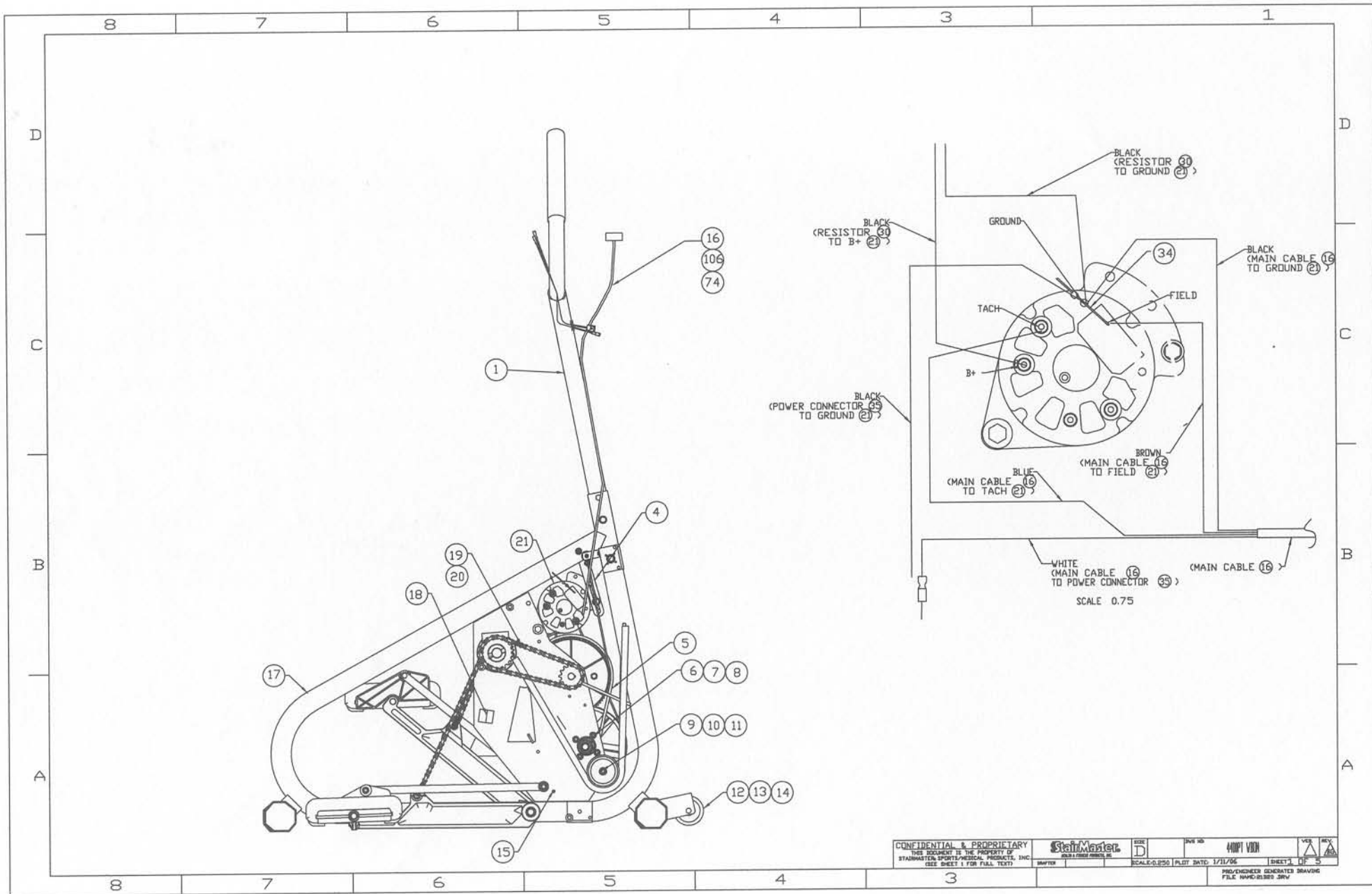


FIRST REDUCTION SHAFT
SCALE 1.000

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DRAFTER [Blank]	SCALE: 0.500	PLOT DATE: 1/29/03	SHEET 5 OF 6		

8 7 6 5 4 3

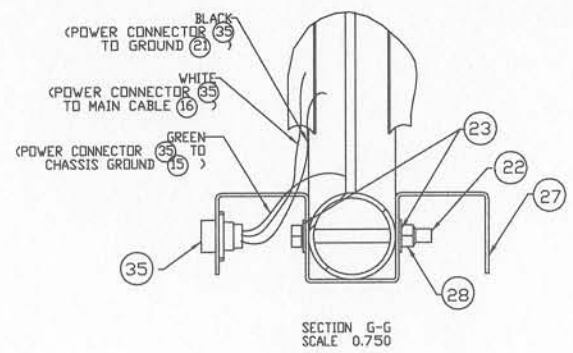
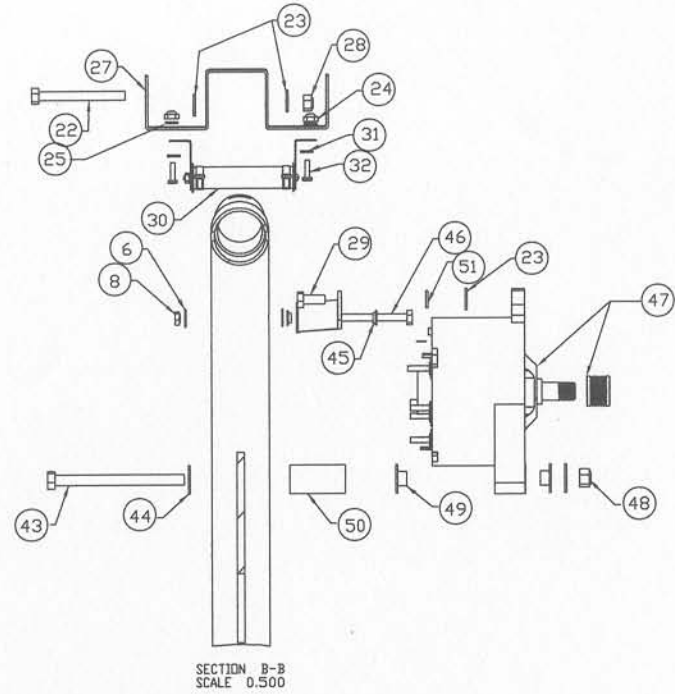
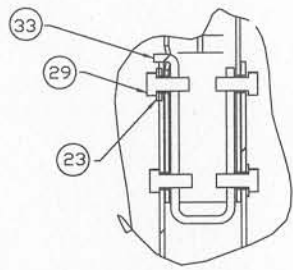
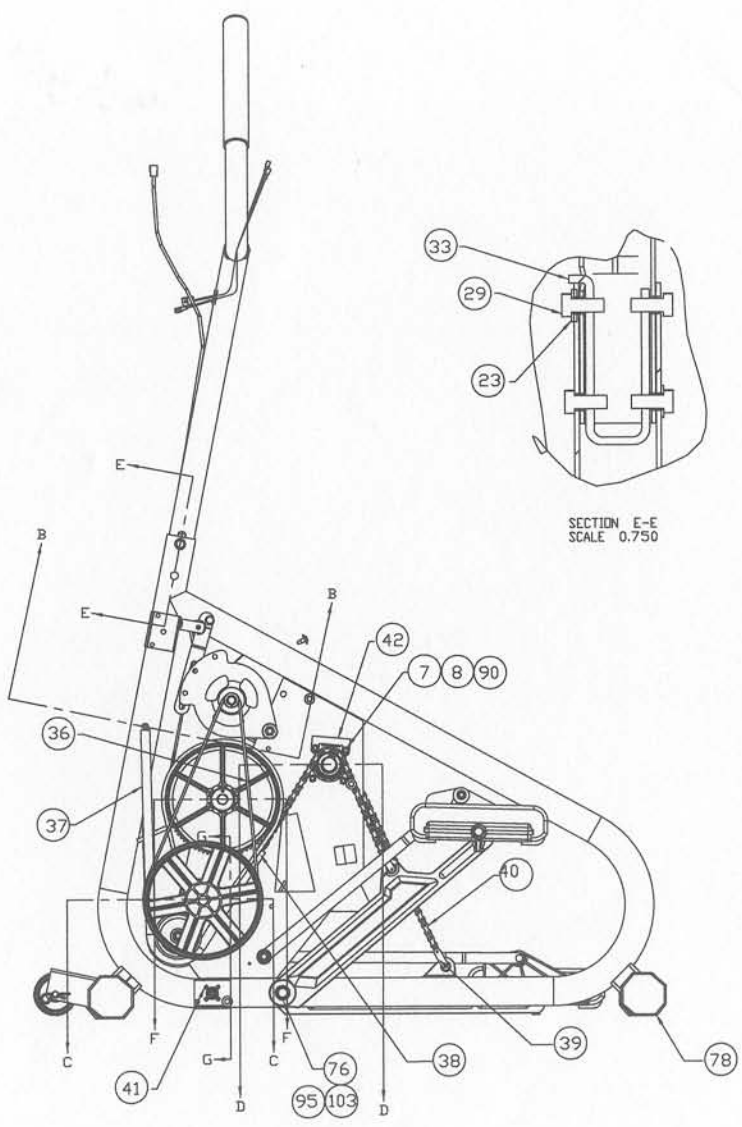




8 7 6 5 4 3 1

D
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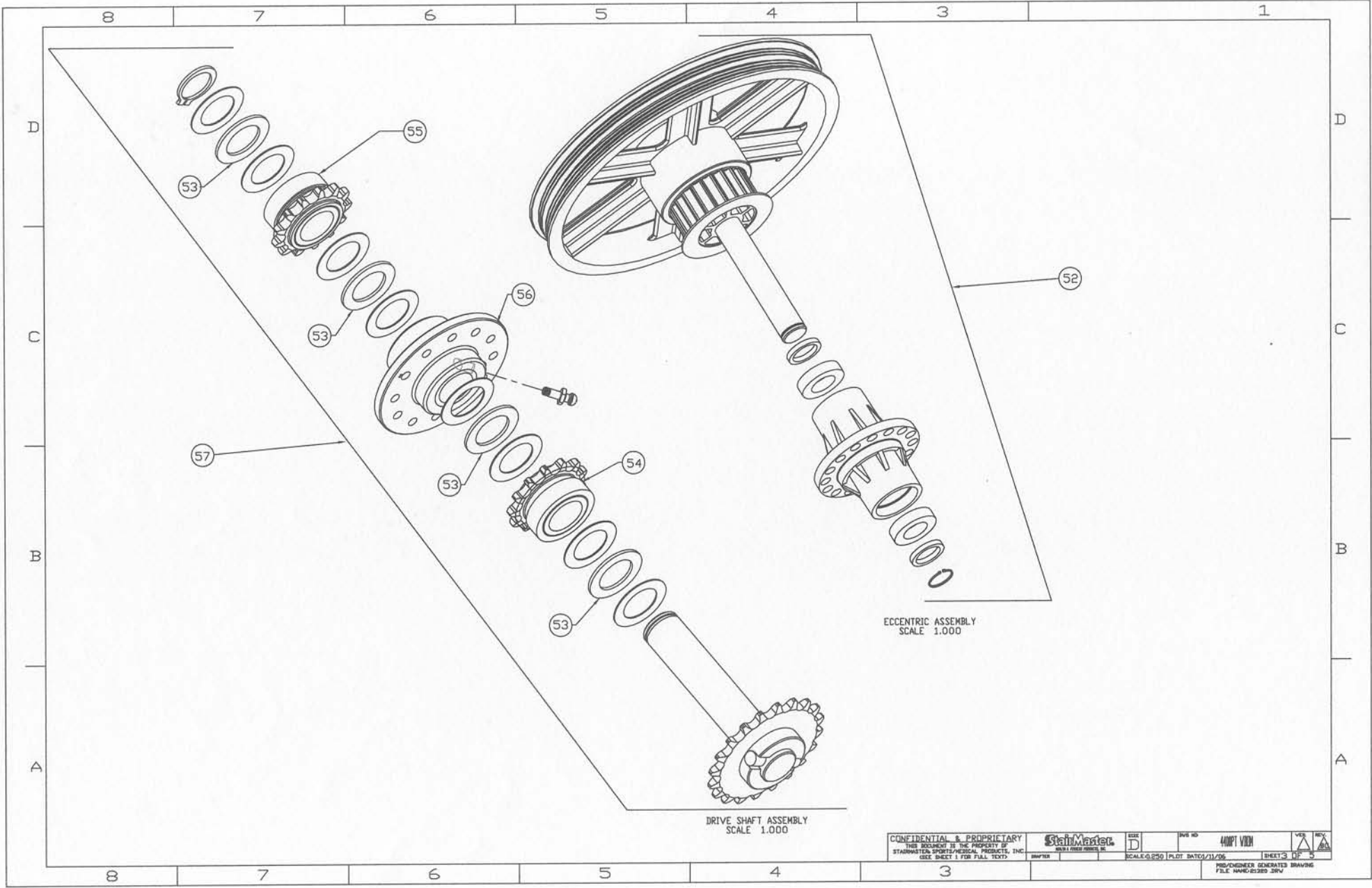
D
C
B
A



BLACK
(POWER CONNECTOR 35
TO GROUND 21)

WHITE
(POWER CONNECTOR 35
TO MAIN CABLE 16)

GREEN
(POWER CONNECTOR 35
TO CHASSIS GROUND 15)



ECCENTRIC ASSEMBLY
SCALE 1.000

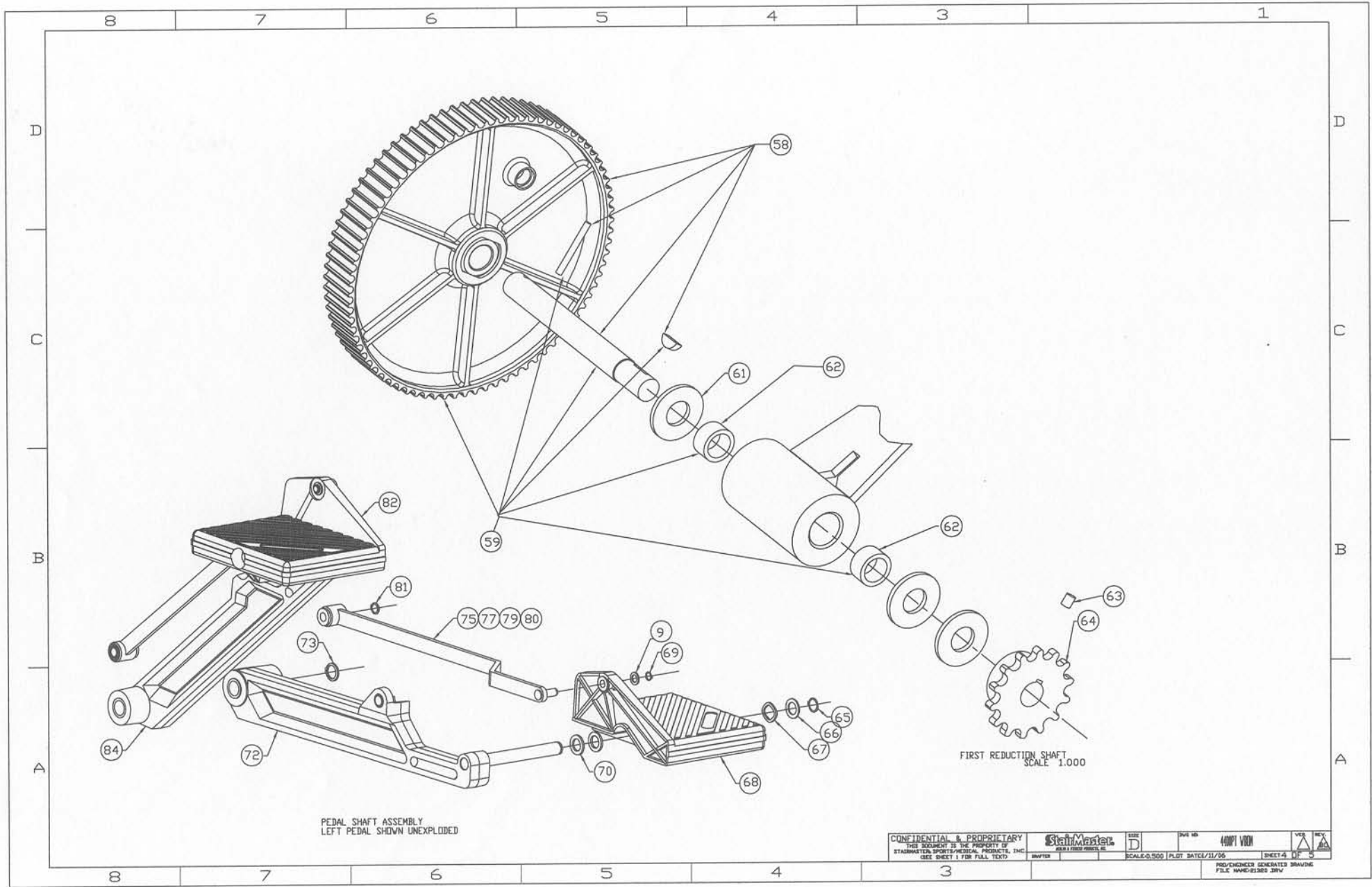
DRIVE SHAFT ASSEMBLY
SCALE 1.000

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SIZE	D	DWG NO	440P1 V02H	VER	REV
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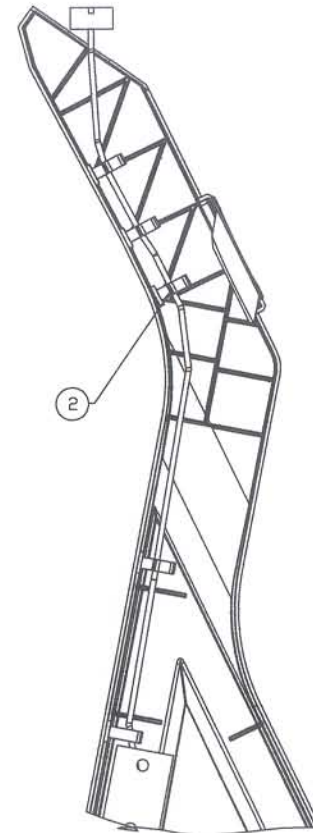
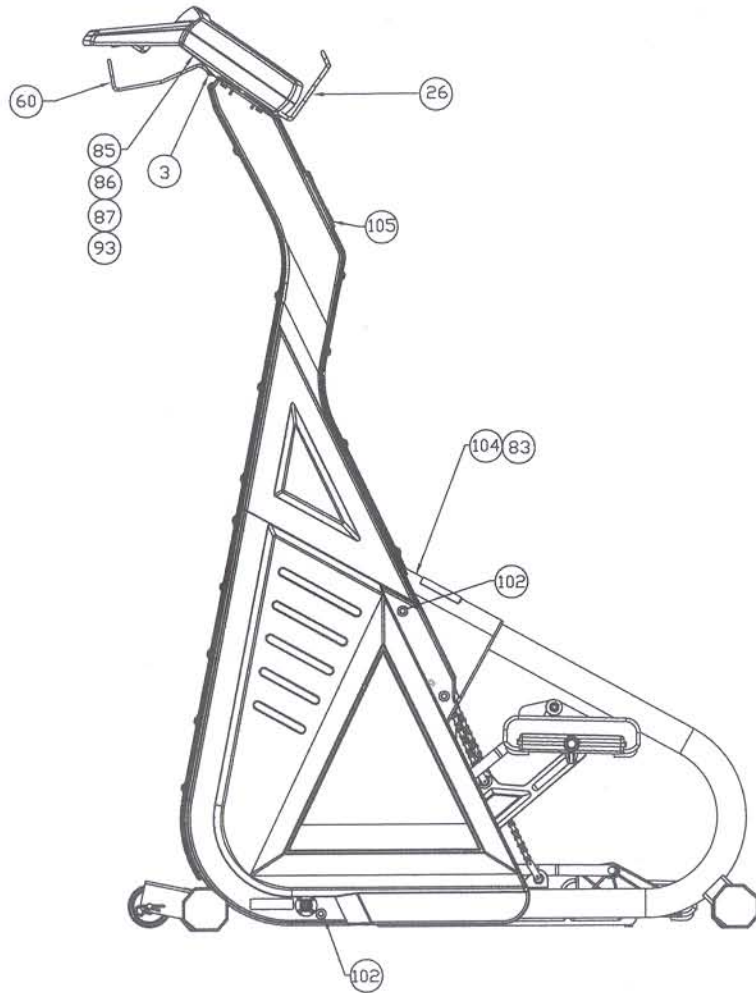
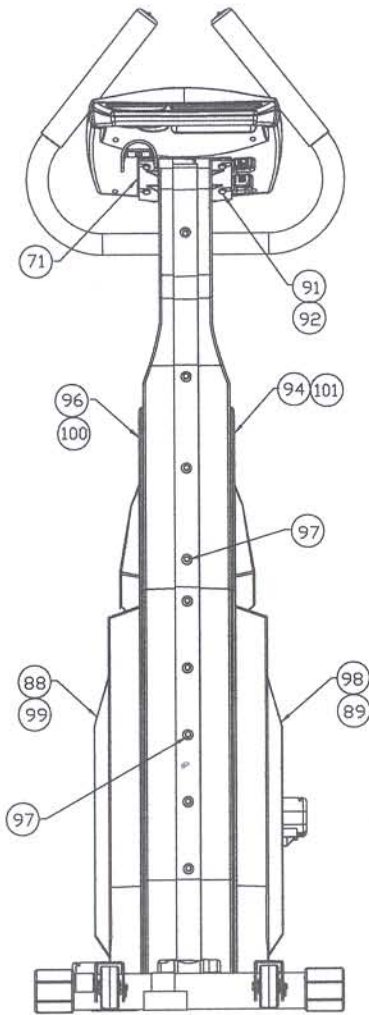
PRO/ENGINEER GENERATES DRAWING
FILE NAME: CSD03.DWG



PEDAL SHAFT ASSEMBLY
LEFT PEDAL SHOWN UNEXPLODED

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DRAWN: [initials]		PRE-ENGINEER GENERATED DRAWING FILE: 44071-0000.DWG			

COVERS NOT AVAILABLE FOR 4400PT THAT ARE PRE 3/96, PLEASE ORDER SM24863-06K (COVER UPGRADE W/NECK WELDMENT)



SCALE 0.500

4400PT, DOMESTIC, WB.O.M., BLACK

SKU: #SM120003 (BLACK) #SM120013 (GREY)

<u>REF NO.</u>	<u>PSE NO:</u>	<u>DESCRIPTION</u>
1	SM24803-03	ASSY,NECK,44PT/CL W/INJ CVR,WB
2	SM24323	CLIP,CABLE,ADHESIVE BACKING
3	SM25244	SCREW,.250-20X.50 BUTTON HD CP
4	SM21590-03	BRACE,ALTERNATOR,4400 PT/CL,WB
5	SM21529	BELT,HTD,8MM,800MM LONG
6	SM22047	WASHER,FLAT,1/4 ID X 5/8 OD
7	SM22026	SCREW,.250-20X1.00,HEX HD CAP
8	SM22036	NUT,.250-20,NYLON INSERT
9	SM21462	SCREW,1/4-20X3/8",BUTTON HD SO
10	SM22143	RING,SNAP, 3/8"
11	SM21519	PULLEY,SPRING,4200/4400
12	SM25978	KIT,WHEEL
13	SM21774	PIN,HITCH
14	SM22326	PIN,CLEVIS
15	SM22150	SCREW,#10-24 X .38 ZINC PLATED
16	SM27827	ASSY.CABLE, C40 4400/4600PT, (8/01 to Present)
17	SM21437-03	(CS)MAINFRAM,T2,4400PT/CL/2400
18	SM20188	MOUNT, SHOCK
19	SM20008	LINK,MASTER,#41
20	SM22347	CHAIN,TRANSMISSION,4200/4400
21	SM20205	ALTERNATOR,PRESTOLITE,1992
22	SM24271	SCREW,.312-18X3.00,HEX HD CAP
23	SM22075	WASHER,.312 USS FLAT
24	SM23054	NUT,#8-32,NYLON INSERT
25	SM13580	WASHER,#8 SAE FLAT
26	SM27791-03	WIREFORM,MAGAZINE HOLDER
27	SM24666-03	BRACKET,MNT,CVR,CL SYS,CL,W/B
28	SM22032	NUT,5/16-18 NC NYLON INSRT HEX
29	SM22093	SCREW,.312-18X.75,HEX HD CAP
30	SM22930	ASSY,LOAD RESISTOR,4400 PT
31	SM23609	WASHER,FLAT,#8 FENDER,
32	SM25079	SCREW,8-32 NC X .62 PHIL PAN
33	SM21616	INSERT,NECK,2400/4400
34	SM21204	ASSY,FIELD,DIODE
35	SM24307	ASSY,MAIN POWER HARNESS
36	SM21518	BELT,POLY-V,430J6
37	SM21093	SPRING, PEDAL RETURN
38	SM20157	KIT,MASTER LINK
39	SM21298	LINK, DOUBLE PITCH W/SLEEVE
40	SM20199	CHAIN,STEP CHN4ON P 37
41	SM22663	SCREW,#6 X .50 PHIL,TYPE T
42	SM21192	RETAINER, PEDAL CHAIN
43	SM21448	SCREW,.375-16 x 4.50 HEX HD CP
44	SM22030	WASHER, 3/8 USS FLAT

45	SM22983	WASHER, SHOULDER, .25 ID, NYLON
46	SM22175	SCREW, .250-20X3.00, HEX HD CAP
47	SM21508	(CS)ASSY, ALT. PULLEY, 4400PT T2
48	SM22029	NUT, .375-16, NYLON INSERT
49	SM22191	WASHER, SHOULDER, .38 I.D.
50	SM21592-05	SPACER, ALTERNATOR, 4400 PT/CL
51	SM22070	WASHER, .312 SPIT LOCK
52	SM24897	(CS)ASSY, ECCENTRIC SHAFT
53	SM20198	BEARING, THRUST
54	SM10383	(CS)ASSY, SPROCKET RH
55	SM10382	(CS)ASSY, SPROCKET LH
56	SM10400	(CS)ASSY, DRIVE, HUB
57	SM10485	(CS)ASSY, DRIVE HUB & SHAFT
58	SM22618	(CS)ASSY, SPROCKET, 80T
59	SM40216	KIT, FIRST REDUCTION
60	SM27783-03	WIREFORM ASSY, WATER BOTTLE
61	SM21657	WASHER, .688 I.D. X .125 THICK
62	SM24747	BEARING, NEDL, DRWN CUP, 17x23x12
63	SM22878	SCREW, SET, SOCKET, .250-28 X .38
64	SM20006	SPROCKET, BS14 #41 CHAIN
65	SM22141	RING, SNAP, 5/8", ZINC PLATED
66	SM22140	WASHER, FLAT 1.00 OD X .63 ID
67	SM12446	WASHER, WAVE, .751 I.D.
68	SM21793	ASSY, PEDAL, RH, CL SYS, V2
69	SM21463	RING, SNAP, 3/8", SS
70	SM21366	WASHER, THRUST, .63 ID
71	SM27797	SPACER, C40 MOUNTING
72	SM10989-03	(CS)ASSY, ARM, PEDAL, RH, PB, W/B P
73	SM20213	RING, SNAP 3/4"
74	SM21417	ASSY, MAIN CABLE, 4400 PT, HM, C5 (2/96 to 8/01)
75	SM10991-03	(CS)ASSY, ARM, LEVELING, PB, W/BPD
76	SM22363	ASSEMBLY, HUB/SHAFT, PRESSFIT
77	SM21286K	KIT, LEVELING ARM UPGRADE, LT
78	SM24329	CAP, LEG, LEVEL ADJUST, OCT
79	SM21285K	KIT, LEVELING ARM UPGRADE, RT
80	SM40184	KIT, LEVEL ARM
81	SM20214	RING, SNAP 3/8"
82	SM21794	ASSY, PEDAL, LH, CL SYS, V2
83	SM24954-07	(CS)COVER, MID, W/DECALS, GREY
84	SM10990-03	(CS)ASSY, ARM, PEDAL, LH, PB W/B P
85	SM27775-20	CONSOLE, ASSEMBLY, C40, ENG
86	SM27130	PCB ASSY, C40 PROCESS(M128)NON-
87	SM27792	KIT, C40 OVERLAY
88	SM18074	CVR, LWR, RH, 44PT, GREY
89	SM18075	CVR, LWR, LH, 44PT, GREY
90	SM27078	KIT, DRIVE HUB MOUNTING
91	SM25454	BOLT, 1/4-20 X .75, HEX HEAD
92	SM22138	WASHER, .250 INTERNL TOOTH LOCK
93	SM40070-001	PCBA, DISPLAY, CJ40
94	SM21511-06	COVER, UPPER, LH, INJ MOLDED
95	SM21239	(CS)SHAFT, ARM, PEDAL, NICKL PLTE, (1/96 to 2/97)
96	SM21510-06	COVER, UPPER, RH, INJ MOLDED

97	SM22847	RIVET KIT (10 PER)
98	SM27058-06	(CS)COVER,LH W/DECAL,4400PT,BLK
99	SM27057-06	(CS)COVER,RH W/DECAL,4400PT,BLK
100	SM21510-07	COVER,UPPER,RH,INJ MOLD,GRY
101	SM21511-07	COVER,UPPER,LH,INJ MOLD,GRY
102	SM22086	RIVET,PANELS, PLASTIC
103	SM22280	(CS)KEY,3/16 SQ X 1.250 LONG,Pedal shaft, (1/96 to 2/97)
104	SM24954-06	(CS)COVER,MID,W/DECALS,BLK
105	SM21578	GROMMET,NECK,2400/4400
106	SM21403	ASSY.,MAIN CABLE,4400PT,C2, (1/95 to 2/96)
Not shown	SM20001	REDUCER, SPEED,TRANSMISSION,(PRE-11/95)
Not shown	SM20200	CHAIN, TRANSMISSION CHN411 61, (PRE-11/95)
Not shown	SM20202	BELT,POLY-V,200J6, (PRE-11/95)
Not shown	SM20547	BRACKET,TRANSMISSION, (PRE-11/95)
Not shown	SM20808	PAD, RUBBER TRANSMISSION, (PRE-11/95)
Not shown	SM21094	PULLEY,SPRING, OLD STYLE 4400PT, (PRE-11/95)
Not shown	SM21245	PULLEY,TRANSMISSION,440PT, (PRE-11/95)
Not shown	SM22181K	KIT,TOUCH-UP PAINT,WRKLBLACK
Not shown	SM21287	ASSY, TRANS W/PULLEY AND SPROCKET, (PRE-11/95)
Not shown	SM21436-03	(CS)MAINFRAME,BISON,4400PT/CL, (PRE-11/95)
Not shown	SM21676-03	CLAMP,HANDRAIL,4400/2400,BLACK
Not shown	SM22569	MNUAL,OWNRS,42/44/4600PT/CL,EN, (C5 console)
Not shown	SM22867	MANUAL 4600 C-40
Not shown	SM23802	ASSY,LOAD RESISTOR, (PRE-7/95)
Not shown	SM23853	TOOL, REMOVAL, COVER FASTENERS
Not shown	SM24246	RACK,READING (C3/C4/C5), (PRE-8/01)
Not shown	SM24381	POWER SUPPLY,PS-7,3-PIN
Not shown	SM24557	BRUSH ASSY,ALTERNATOR,PRESTOLT