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**NOTICE:** This document provides important safety instructions, adjustments, and general troubleshooting information for the maintenance of the Nautilus™ E618 Elliptical Fitness Machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**



**This icon means a potentially hazardous situation which, if not avoided, could result in death or serious injury. Read and understand all Warnings on this machine.**

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## **Important Safety Instructions**



**This icon means a potentially hazardous situation which, if not avoided, could result in death or serious injury. Read and understand all Warnings on this machine.**

**Before servicing or using this equipment, obey the following warnings:**



**Read and understand the Service Manual before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.**

### **⚠ DANGER**

**To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and/or the machine and wait 5 minutes before cleaning, maintaining or repairing the machine. Place the power cord in a secure location.**

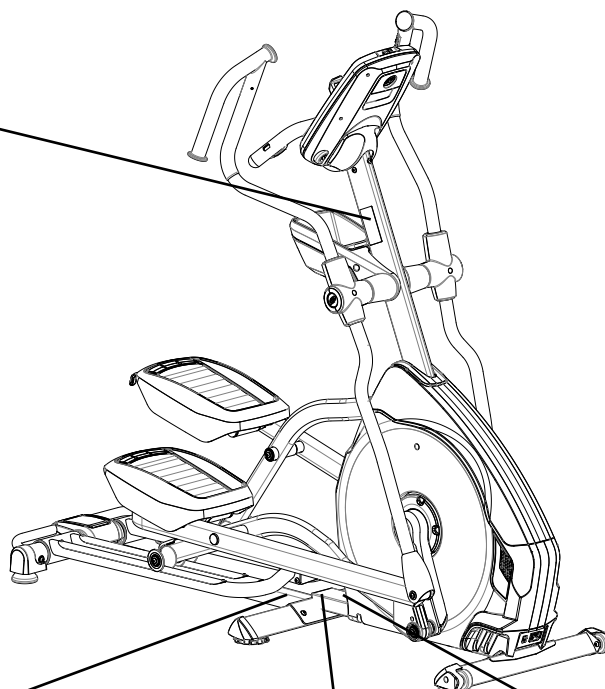
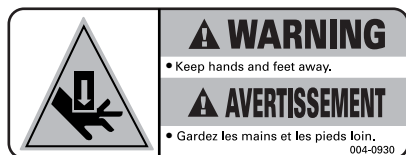
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not put the machine back in service until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.
- Connect this machine to a properly grounded outlet only (see Grounding Instructions).
- Keep the power cord away from heat sources and hot surfaces.
- Do not operate where aerosol products are being used.
- To disconnect, turn all controls to the off position, then remove plug from outlet.

# SAFETY WARNING LABELS AND SERIAL NUMBER

## WARNING!

- Injury or death is possible if caution is not used while using this machine.
- Keep children and pets away.
- Read and follow all warnings on this machine.
- Refer to the Owner's Manual for additional warnings and safety information.
- The heart rate displayed is an approximation and should be used for reference only.
- Not intended for use by anyone under 14 years of age.
- The maximum user weight for this machine is 350 lbs ( 158 kg ).
- This machine is for home use only.
- Consult a physician prior to using any exercise equipment.

(The label on the product is available in English and French Canadian only.)



Serial Number

Product Specification

## Reading the Product Specification Decal

The Manufacture Date on the Product Specification Decal is a date code: YY/WW (year/week).

|                             |  |  |  |
|-----------------------------|--|--|--|
| Manufacture Date Code: YYWW |  |  |  |
| Date De Manufacture: YYWW   |  |  |  |
|                             |  |  |  |
|                             |  |  |  |

## FCC Compliance

- ⚠ Changes or modifications to this unit not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.**

The machine and power supply comply with Part 15 of the FCC rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

**Note:** This machine and power supply have been tested and found to comply with the limits for a Class B digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications.

However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

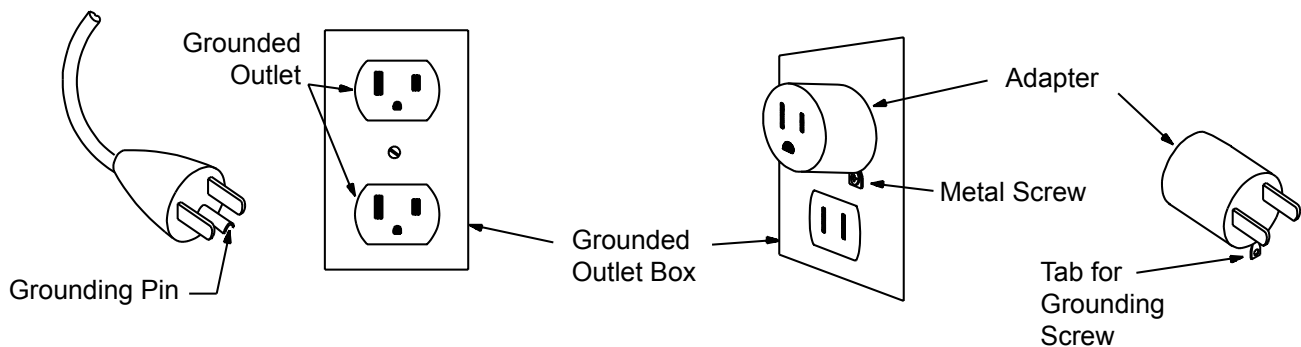
## Grounding Instructions

This product must be grounded. If it should malfunction or break down, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This product is equipped with a cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

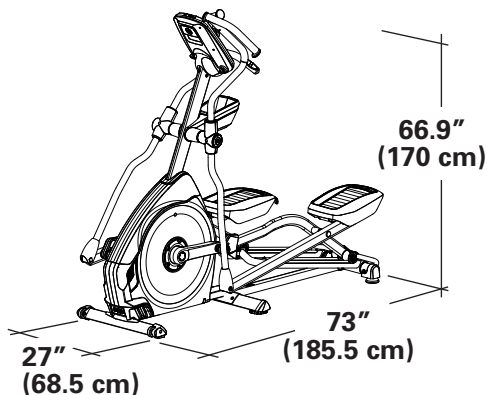
**⚠ DANGER** Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with a qualified electrician or serviceman if you are in doubt as to whether the product is properly grounded. Do not modify the plug provided with the product – if it will not fit the outlet, have a proper outlet installed by a qualified electrician.

This machine is for use on a nominal 120-V circuit, and has a grounding plug that looks like the plug illustrated below. A temporary adapter that looks like the adapter illustrated may be used to connect this plug to a 2-pole receptacle as shown if a properly grounded outlet is not available.

The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green colored rigid ear, lug, or the like extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box cover. Whenever the adapter is used, it must be held in place by a metal screw.



## Specifications



**Maximum User Weight:** 350 lbs. (158.8 kg)

**Maximum Pedal Height - with full incline:** 28" (72 cm)

**Machine Weight:** 209.7 lbs. (95.1 kg)

### Power Requirements:

Operating Voltage: 120V AC @60Hz

Operating Current: 2 A

Heart Rate Chest Strap: 1 CR2032 battery



DO NOT dispose of this product as refuse. This product is to be recycled. For proper disposal of this product, please follow the prescribed methods at an approved waste center.

# MAINTENANCE

Read all maintenance instructions fully before you start any repair work. In some conditions, an assistant is required to do the necessary tasks.

**⚠ Equipment must be regularly examined for damage and repairs. The owner is responsible to make sure that regular maintenance is done. Worn or damaged components must be repaired or replaced immediately. Only manufacturer supplied components can be used to maintain and repair the equipment.**

**If at any time the Warning labels become loose, unreadable or dislodged, contact Nautilus Customer Service for replacement labels.**

**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and the machine and wait 5 minutes before cleaning, maintaining or repairing the machine. Place the power cord in a secure location.

## Daily:

Before each use, examine the exercise machine for loose, broken, damaged, or worn parts. Do not use if found in this condition. Repair or replace all parts at the first sign of wear or damage. After each workout, use a damp cloth to wipe your machine and Console free of moisture.

**Note:** Avoid excessive moisture on the Console.

**NOTICE:** If necessary, only use a mild dish soap with a soft cloth to clean the Console. Do not clean with a petroleum based solvent, automotive cleaner, or any product that contains ammonia. Do not clean the Console in direct sunlight or at high temperatures. Be sure to keep the Console free of moisture.

## Weekly:

Check for smooth roller operation. Wipe the machine to remove dust, dirt, or grime. Clean the rails and surface of the rollers with a damp cloth.

Apply silicone lubricant to a dry cloth and wipe the rails to eliminate roller noise.

**⚠ Silicone lubricant is not intended for human consumption. Keep out of reach of children. Store in a safe place.**

**Note:** Do not use petroleum based products.

## Monthly or after 20 hours:

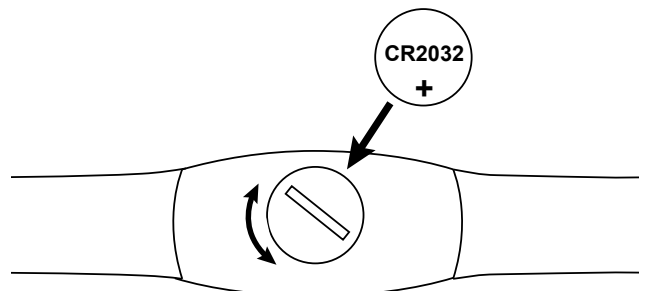
Make sure all bolts and screws are tight. Tighten as necessary.

## Heart Rate Chest Strap Battery Replacement

The heart rate (HR) chest strap uses a CR2032 battery.

**⚠ Do not perform this procedure outdoors or in moist or wet locations.**

1. Using a coin, loosen the slotted cover on the battery bay. Remove the cover and battery.
2. When replacing the battery, insert it in the battery bay with the + symbol facing up.
3. Reinstall the cover on the strap.
4. Discard the old battery. Dispose of in accordance with local regulations and/or at approved recycling centers.
5. Inspect your chest strap to ensure function.



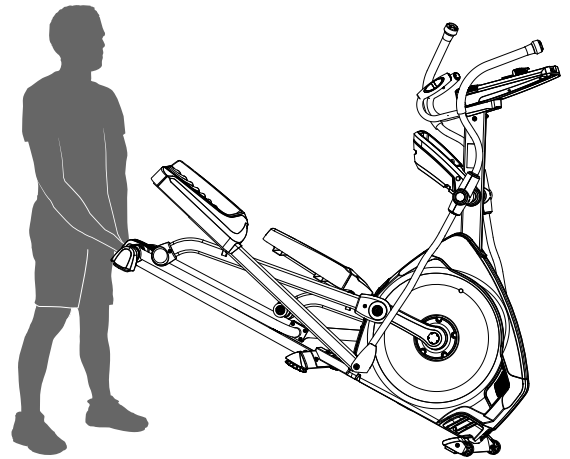
**⚠ Do not use until the equipment has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

## Moving the Machine

**!** The machine may be moved by one or more persons depending on their physical abilities and capacities. Make sure that you and others are all physically fit and able to move the machine safely.

1. Remove the power cord.
2. Use the Transport Handle to carefully lift the machine onto the transport rollers.
3. Push the machine into position.
4. Carefully lower the machine into position.

**NOTICE:** Be careful when you move the elliptical. Abrupt motions can affect the computer operation.



## Leveling the Machine

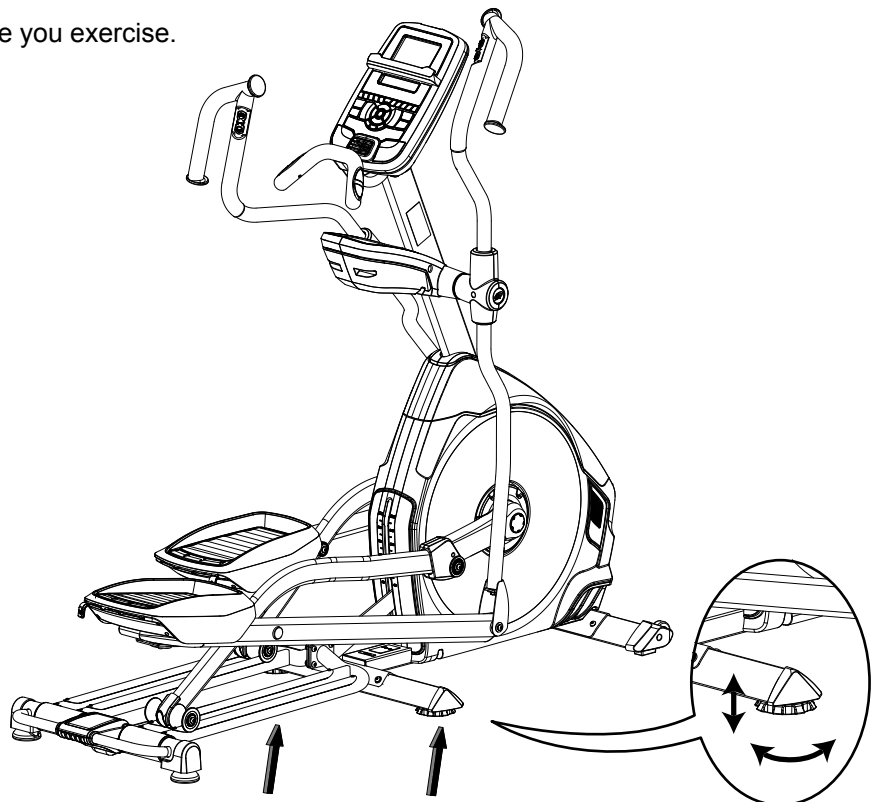
The machine needs to be leveled if your workout area is uneven or if the Rail Assembly is slightly off the floor. To adjust:

1. Place the machine in your workout area.
2. Safely stand on the back of the Rail Assembly for approximately 20 seconds.
3. Step off the machine.
4. Loosen the locking nuts and adjust the levelers until they all contact the floor.

**!** Do not adjust the levelers to such a height that they detach or unscrew from the machine. Injury to you or damage to the machine can occur.

5. Adjust until the machine is level. Tighten the locking nuts.

Make sure the machine is level and stable before you exercise.



## CONNECTIVITY

### Bluetooth® Connectivity with the “Nautilus Trainer™” Fitness App

This fitness machine is equipped with Bluetooth® connectivity and can wirelessly sync with the “Nautilus Trainer™” Fitness App on supported devices. The Software App syncs with your fitness machine to track total calories burned, time, distance, and more. It records and stores every workout for quick reference. Plus, it automatically syncs your workout data with MyFitnessPal® and Under Armour® Connected Fitness to make hitting your daily calorie goal easier than ever! Track your results and share with friends and family.

1. Download the free Software App, named Nautilus Trainer™. The software app is available on the App Store and Google Play™.

**Note:** For a complete list of supported devices, review the software app on the App Store or Google Play™.

2. Follow the instructions on the Software App to sync your device to your exercise machine.
3. To sync your workout data with MyFitnessPal® or Under Armour® Connected Fitness, click on the desired program and login with your information.

**Note:** The “Nautilus Trainer™” Fitness App will automatically sync your workouts after the initial syncing.

### Workout with Other Fitness Apps

This fitness machine has integrated Bluetooth® connectivity which allows it to work with a number of digital partners. For our latest list of supported partners, please visit: [www.nautilus.com/partners](http://www.nautilus.com/partners)

### USB Charging

If a USB Device is attached to the USB Port, the Port will attempt to charge the Device.

**Note:** Depending on the amperage of device, the power supplied from the USB Port may not be enough to operate the Device and charge it at the same time.

# TROUBLESHOOTING

| Condition/Problem                                                 | Things to Check                                 | Solution                                                                                                                                                                                                                 |
|-------------------------------------------------------------------|-------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| No display/partial display/<br>unit will not turn on              | Check electrical (wall) outlet                  | Make sure unit is plugged into a functioning wall outlet.                                                                                                                                                                |
|                                                                   | Check connection at front of unit               | Connection should be secure and undamaged. Replace adapter or connection at unit if either are damaged.                                                                                                                  |
|                                                                   | Check data cable integrity                      | All wires in cable should be intact. If any are visibly crimped or cut, replace cable.                                                                                                                                   |
|                                                                   | Check data cable connections/orientation        | Be sure cable is connected securely and oriented properly. Small latch on connector should line up and snap into place.                                                                                                  |
|                                                                   | Check console display for damage                | Check for visual sign that console display is cracked or otherwise damaged. Replace Console if damaged.                                                                                                                  |
|                                                                   | Console Display                                 | If Console only has partial display and all connections are fine, replace the Console.                                                                                                                                   |
|                                                                   |                                                 | If the above steps do not resolve the problem, contact Customer Service (if inside US/Canada) or your local distributor (if outside US/Canada).                                                                          |
| Unit operates but Contact HR not displayed                        | HR cable connection at Console                  | Be sure cable is connected securely to Console.                                                                                                                                                                          |
|                                                                   | HR cable box connection                         | Be sure cables from handlebars and cable to Console are secure and undamaged.                                                                                                                                            |
|                                                                   | Sensor grip                                     | Be sure hands are centered on HR sensors. Hands must be kept still with relatively equal pressure applied to each side.                                                                                                  |
|                                                                   | Dry or calloused hands                          | Sensors may have difficulty with dried out or calloused hands. A conductive electrode cream (heart rate cream) can help make better conduct. These are available on the web or at medical or some larger fitness stores. |
|                                                                   | Static Handlebar                                | If tests reveal no other issues, Static Handlebar should be replaced.                                                                                                                                                    |
| Unit operates but Telemetric HR not displayed                     | Chest Strap (optional)                          | Strap should be "POLAR®" compatible and uncoded. Make sure strap is directly against skin and contact area is wet.                                                                                                       |
|                                                                   | Chest Strap Batteries                           | If strap has replaceable batteries, install new batteries.                                                                                                                                                               |
|                                                                   | Check User Profile                              | Select the Edit User Profile option for the User Profile. Go to the WIRELESS HR setting and make sure that the current value is set to ON.                                                                               |
|                                                                   | Interference                                    | Try moving unit away from sources of interference (TV, Microwave, etc).                                                                                                                                                  |
|                                                                   | Replace Chest Strap                             | If interference is eliminated and HR does not function, replace strap.                                                                                                                                                   |
|                                                                   | Replace Console                                 | If HR still does not function, replace Console.                                                                                                                                                                          |
| Unit operates but Telemetric HR displayed incorrectly             | Interference                                    | Make sure that the HR receiver is not blocked by a personal electronic device in the left side of the media tray.                                                                                                        |
| No speed/RPM reading, Console displays "Please Stride" error code | Check data cable integrity                      | All wires in cable should be intact. If any are cut or crimped, replace cable.                                                                                                                                           |
|                                                                   | Check data cable connections/orientation        | Be sure cable is connected securely and oriented properly. Small latch on connector should line up and snap into place.                                                                                                  |
|                                                                   | Check magnet position (requires shroud removal) | Magnet should be in place on pulley.                                                                                                                                                                                     |
|                                                                   | Check Speed Sensor (requires shroud removal)    | Speed sensor should be aligned with magnet and connected to data cable. Realign sensor if necessary. Replace if there is any damage to the sensor or the connecting wire.                                                |

| Condition/Problem                                          | Things to Check                                                     | Solution                                                                                                                                                                  |
|------------------------------------------------------------|---------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Resistance does not change (machine turns on and operates) | Check Console                                                       | Check for visual sign that Console is damaged. Replace Console if damaged.                                                                                                |
|                                                            | Check data cable integrity                                          | All wires in cable should be intact. If any are visibly crimped or cut, replace cable.                                                                                    |
|                                                            | Check data cable connections/orientation                            | Be sure cable is connected securely and oriented properly. Reseat all connections. Small latch on connector should line up and snap into place.                           |
|                                                            | Resistance handlebar connection (requires handlebar shroud removal) | Be sure cable from left Upper Handlebar and cables to Console are secure and undamaged.                                                                                   |
|                                                            | Check Servo Motor (requires shroud removal)                         | If magnets move, adjust until they are within the proper range. Replace Servo Motor if not functioning properly.                                                          |
|                                                            | MCB (requires shroud removal)                                       | Replace MCB.                                                                                                                                                              |
|                                                            |                                                                     | If the above steps do not resolve the problem, contact Customer Service (if inside US/Canada) or your local distributor (if outside US/Canada).                           |
| Incline does not adjust (machine turns on and operates)    | Check Console                                                       | Check for visual sign that Console is damaged. Replace Console if damaged.                                                                                                |
|                                                            | Incline handlebar connection (requires handlebar shroud removal)    | Be sure cable from right Upper Handlebar and cables to Console are secure and undamaged.                                                                                  |
|                                                            | Lower and Upper I/O Cables (requires shroud removal)                | All wires in the cables should be intact. If any are cut or crimped, replace cable.                                                                                       |
|                                                            | Incline Adjuster Assembly (requires shroud removal)                 | Be sure Incline Adjuster Assembly is attached to Incline Motor drive screw.                                                                                               |
|                                                            |                                                                     | If the above steps do not resolve the problem, contact Customer Service (if inside US/Canada) or your local distributor (if outside US/Canada).                           |
| Console shuts off (enters sleep mode) while in use         | Check electrical (wall) outlet                                      | Make sure unit is plugged into a functioning wall outlet.                                                                                                                 |
|                                                            | Check connection at front of unit                                   | Connection should be secure and undamaged. Replace adapter or connection at unit if either are damaged.                                                                   |
|                                                            | Check data cable integrity                                          | All wires in the cable should be intact. If any are cut or crimped, replace cable.                                                                                        |
|                                                            | Check data cable connections/orientation                            | Be sure cable is connected securely and oriented properly. Small latch on connector should line up and snap into place.                                                   |
|                                                            | Reset machine                                                       | Unplug unit from electrical outlet for 3 minutes. Reconnect to outlet.                                                                                                    |
|                                                            | Check magnet position (requires shroud removal)                     | Magnet should be in place on pulley.                                                                                                                                      |
|                                                            | Check Speed Sensor (requires shroud removal)                        | Speed sensor should be aligned with magnet and connected to data cable. Realign sensor if necessary. Replace if there is any damage to the sensor or the connecting wire. |
| Console continuously cycles through program screens        | Console is in demonstration mode                                    | Hold down the PAUSE/END and Left button together for 3 seconds.                                                                                                           |

| Condition/Problem                                                                                                            | Things to Check                                                                | Solution                                                                                                                                                                                                    |
|------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Fan will not turn on or will not turn off                                                                                    | Check data cable integrity                                                     | All wires in cable should be intact. If any are cut or crimped, replace cable.                                                                                                                              |
|                                                                                                                              | Check data cable connections/orientation                                       | Be sure cable is connected securely and oriented properly. Small latch on connector should line up and snap into place.                                                                                     |
|                                                                                                                              | Reset machine                                                                  | Unplug unit from electrical outlet for 3 minutes. Reconnect to outlet.                                                                                                                                      |
| Fan will not turn on, but Console operates                                                                                   | Check for blockage of fan                                                      | Unplug unit from electrical outlet for 5 minutes. Remove material from fan. If necessary, detach the Console to help with removal. Replace the Console if unable to remove blockage.                        |
| Unit rocks/does not sit level                                                                                                | Check leveler adjustment                                                       | Adjust levelers until machine is level.                                                                                                                                                                     |
|                                                                                                                              | Check surface under unit                                                       | Adjustment may not be able to compensate for extremely uneven surfaces. Move machine to level area.                                                                                                         |
| Foot pedals loose/unit difficult to operate                                                                                  | Hardware                                                                       | Tightly secure all hardware on the Pedal Arms and Handlebar Arms.                                                                                                                                           |
| Drive train click/tick noise once per full crank revolution                                                                  | Check crank/pulley assembly                                                    | Disconnect left and right foot assemblies and rotate crank. If sound persists, replace crank/pulley assembly. If sound does not come from rotating crank, check foot assemblies and upper/lower handlebars. |
|                                                                                                                              | Check foot assemblies, leg assemblies, handlebar assemblies                    | Manually move foot, leg, and handlebar assemblies to isolate sound. Replace part making sound.                                                                                                              |
|                                                                                                                              | Check for loose hardware                                                       | Tightly secure all hardware on the Stabilizers and the base of the Console Mast.                                                                                                                            |
| Knocking sound during machine operation                                                                                      | Check hardware at junction between Lower Handlebar Arm and Pedal               | Make sure that the alignment tab on the Pivot Sleeve goes into the slot in the hole. Be sure the Pivot Sleeve extends through the opposite hole in the joint cover.                                         |
| Squeaking noise that appears a few minutes into a workout and normally will get progressively worse as the workout continues | Bolt that connects the swing arms to the axle running through the console mast | Loosen pivot rod bolt slightly until noise goes away. White lithium grease can also be applied for a temporary fix. Contact Customer Care for assistance.                                                   |
|                                                                                                                              | Roller squeaking on rail                                                       | Apply silicone lubricant to a dry cloth and wipe the rails to eliminate roller noise.                                                                                                                       |
| Workout results will not sync with Bluetooth® enabled device                                                                 | Current console mode                                                           | Machine must be in Idle Mode to sync. Push the PAUSE/END button until the Power-Up Mode screen is displayed.                                                                                                |
|                                                                                                                              | Total time of workout                                                          | A workout must be longer than 1 minute to be saved and posted by the Console.                                                                                                                               |
|                                                                                                                              | Fitness machine                                                                | Unplug unit from electrical outlet for 5 minutes. Reconnect to outlet.                                                                                                                                      |
|                                                                                                                              | Bluetooth® enabled device                                                      | Consult your device to be sure that the Bluetooth® wireless feature has been enabled on it.                                                                                                                 |
|                                                                                                                              | Fitness App                                                                    | Review Specifications of Fitness App and confirm your device is compatible.                                                                                                                                 |
|                                                                                                                              |                                                                                | Contact <a href="mailto:appsupport@nautilus.com">appsupport@nautilus.com</a> (if inside US/Canada) or your local distributor (if outside US/Canada) for further assistance.                                 |

| Condition/Problem                                                                                      | Things to Check | Solution                                                                                                                       |
|--------------------------------------------------------------------------------------------------------|-----------------|--------------------------------------------------------------------------------------------------------------------------------|
| Workout results not posting from Nautilus Trainer™ to MyFitnessPal® / Under Armour® Connected Fitness. | Sync accounts   | From the Menu icon on the Nautilus Trainer™ App, select the Sync to MyFitnessPal® or Under Armour® Connected Fitness.          |
|                                                                                                        | Sync fails      | Review account and password for MyFitnessPal® / Under Armour® Connected Fitness.                                               |
|                                                                                                        |                 | Contact appsupport@nautilus.com (if inside US/Canada) or your local distributor (if outside US/Canada) for further assistance. |

## Console Service Mode – x618 series Consoles

The Console Setup Mode lets you input the date and time, set the units of measurement to either English or Metric, change the machine type, control the sound settings ( on/ off), or see maintenance statistics (Total Run Hours – for service technician use only).

1. To go into the Console Setup Mode:

- For the later version of the console, hold down the PAUSE/END button and Increase (▲) button together for 3 seconds while in the Power-Up Mode.
- For the earlier version of the console, hold down the PAUSE/END button and Left button together for 3 seconds while in the Power-Up Mode.

**Note:** Push PAUSE/END to exit the Console Setup Mode and return to the Power-Up Mode screen.

2. The Console display shows the Date prompt with the current setting. To change, push the Increase/Decrease buttons to adjust the currently active value (flashing). Push the Left/Right buttons to change which segment is the currently active value (month / day / year).
3. Push OK to set.
4. The Console display shows the Time prompt with the current setting. Push the Increase/Decrease buttons to adjust the currently active value (flashing). Push the Left/Right buttons to change which segment is the currently active value (hour / minute / AM or PM).

5. Push OK to set.

6. The Console display shows the Units prompt with the current setting. To change, push OK to start the Units option. Push the Increase/Decrease buttons to change between “MILES” (Imperial English units) and “KM” (metric units).

**Note:** If the units change when there is data in User Statistics, the statistics convert to the new units.

7. Push OK to set.

8. The Console display shows the Sound Settings prompt with the current setting. Push the Increase/Decrease buttons to change between “ON” and “OFF”.

9. Push OK to set.

10. The Console display shows the TOTAL RUN HOURS for the machine.

To go to the next Console Setup Mode prompt, push the OK button.

To enter the Manufacturing Menu (MFG Menu):

- For the later version of the console, hold down the PAUSE/END button and Increase (▲) button together for 3 seconds while in the Power-Up Mode.
- For the earlier version of the console, hold down the PAUSE/END button and Left button together for 3 seconds while in the Power-Up Mode.

The Console display shows the Firmware Version string. Push the Up/Down buttons to move through the MFG Menu options. Push OK to make a selection.

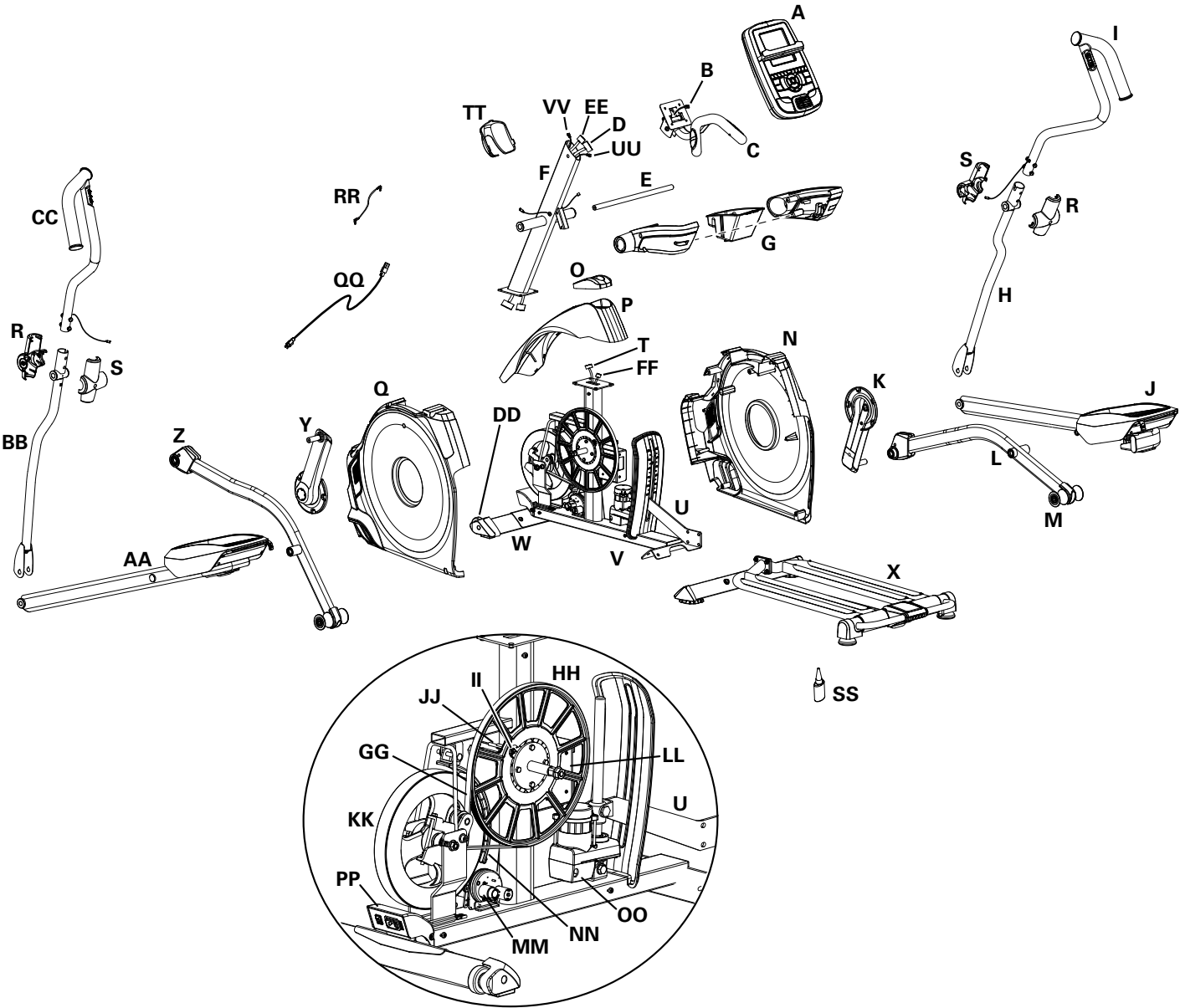
- a. ENTER MFG TEST – This option is intended for use on the manufacturing production line only. It is a chained series of tests similar to the tests listed below, but optimized to be run on the production line. This chained test should not be used anywhere but on the production line.
- b. DEBUG TERMINAL – Not used.
- c. MOVE LIFT – (E618 elliptical only) Used to adjust a new lift motor. The Console displays “UP MX DN MN RT CAL”: Up arrow will move the lift motor to the maximum position; Down arrow will move the lift motor to the minimum position; Right arrow will perform a lift motor calibration by moving the lift motor to its minimum and maximum position. Note: Lift motor calibration is no longer required, so calibration is not needed.
- d. RESET MFG NVM – Resets MFG NVM (non volatile memory). Must be run before lift motor calibration if a valid lift table exists in NVM (lift motor has been calibrated before).
- e. RUN BEEP TEST – Sounds each system beep / tone / sequence in order. Press any key to exit
- f. RUN BUTTON TEST – The Console display shows the function of each button as buttons are pressed. If the display shows an incorrect function, the overlay on the Console may be incorrect for that model. If the display does not show a function, the firmware version may be incorrect. No beeps are sounded during this test.  
To exit the test, push and hold one of the long key sequences (i.e. long Pause / End + Right or long Pause / End + Down).
- g. RUN LED TEST – Drives LEDs to the following states:
  - 1. All LEDs On 1 second
  - 2. All LEDs Off 1 second
  - 3. Sequence Segments 1 at a time – on 1 second, off 1 second
 Press any key to exit test
- h. RUN LCD TEST – Drives 3x5 and 1x5 LCD displays with the following patterns:
  - 1. All segments on
  - 2. All segments off
  - 3. Set individual segments one at a time until all segments are illuminated.
 Press any key to exit.
- i. RESET CONSOLE – Resets the data from user inputs. The Console setup, user records and workout records will be reset to defaults. This option does not reset MFG NVM (non volatile memory).

11. The Console display shows the Software Version prompt.

12. For the next prompt, push the OK button.

13 . The Console will display the Power-Up Mode screen.

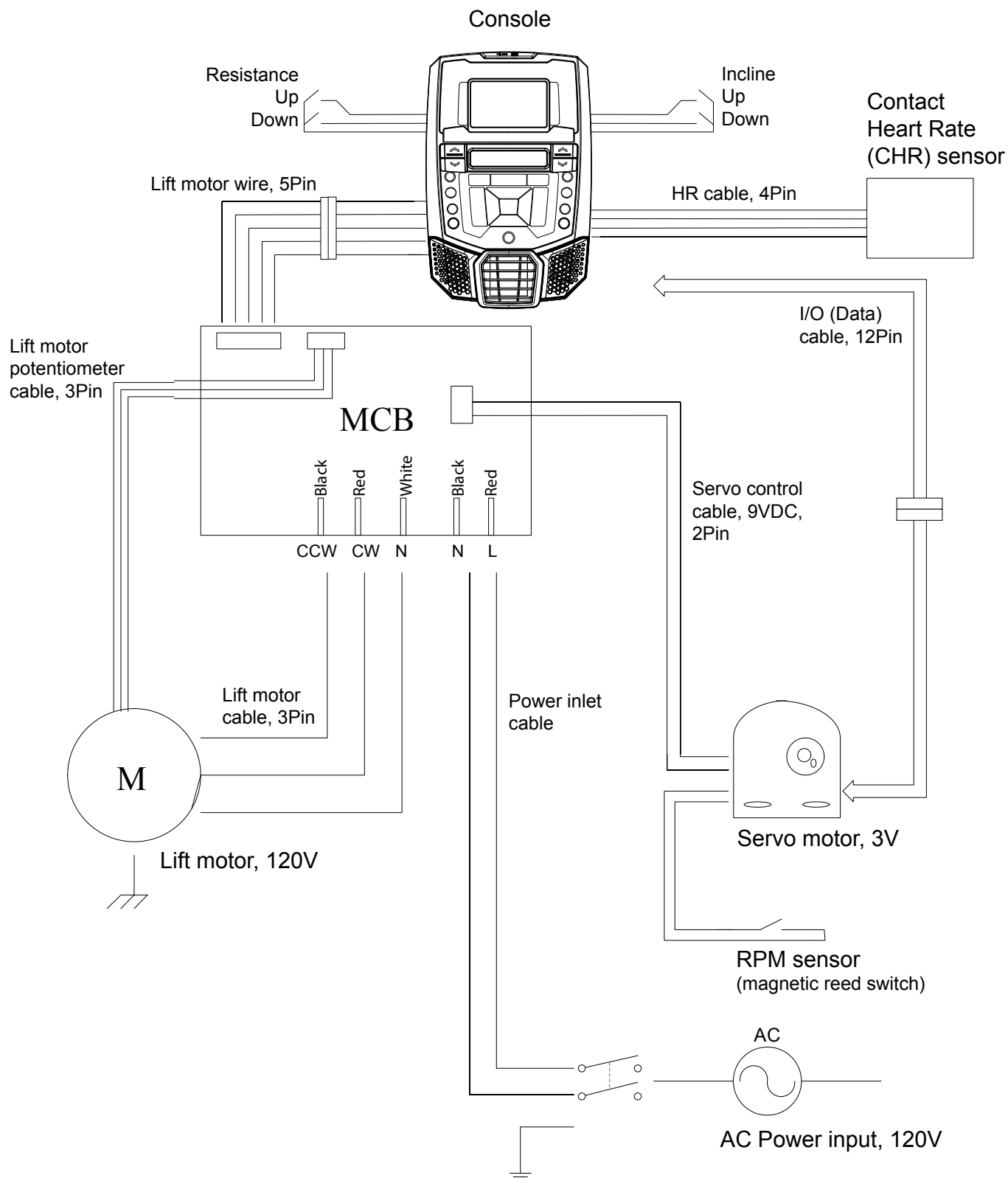
Maintenance Parts



|   |                            |    |                           |    |                                |
|---|----------------------------|----|---------------------------|----|--------------------------------|
| A | Console                    | Q  | Shroud, Left              | GG | Drive Belt                     |
| B | Heart Rate (HR) Cable      | R  | Handlebar Shroud, Outer   | HH | Drive Pulley                   |
| C | Handlebar, Static          | S  | Handlebar Shroud, Inner   | II | Speed Sensor Magnet            |
| D | Data (I/O) Cable, Upper    | T  | Data (I/O) Cable, Lower   | JJ | RPM (Speed) Sensor             |
| E | Arm Pivot Rod              | U  | Incline Adjuster Assembly | KK | Flywheel                       |
| F | Console Mast               | V  | Frame Assembly            | LL | Motor Control Board (MCB)      |
| G | Water Bottle Holder        | W  | Front Stabilizer          | MM | Servo Motor                    |
| H | Handlebar Arm, Lower Right | X  | Rail Assembly             | NN | Brake Assembly                 |
| I | Handlebar Arm, Upper Right | Y  | Crank Assembly, Left      | OO | Incline Motor Assembly         |
| J | Pedal Arm, Right           | Z  | Leg, Left                 | PP | Power Switch                   |
| K | Crank Assembly, Right      | AA | Pedal Arm, Left           | QQ | AC Power Cord                  |
| L | Leg, Right                 | BB | Handlebar Arm, Lower Left | RR | Media Cable                    |
| M | Roller                     | CC | Handlebar Arm, Upper Left | SS | Silicone Lubricant, Bottle     |
| N | Shroud, Right              | DD | Transport Wheel Assembly  | TT | Cover, Console Junction        |
| O | Shroud Cap                 | EE | Lift Motor Wire, Upper    | UU | Remote Incline Control Wire    |
| P | Shroud, Upper              | FF | Lift Motor Wire, Lower    | VV | Remote Resistance Control Wire |

## Electrical Layout

### NLS E618 Wiring Diagram



## Motor Control Board (MCB)



## ***REPLACEMENT PROCEDURE SKILL LEVEL***

|             |                                                           |
|-------------|-----------------------------------------------------------|
| Level I :   | Low - very little mechanical knowledge or exposure.       |
| Level II :  | Intermediate - some experience with mechanical procedures |
| Level III : | Advanced - knowledgeable about mechanical procedures      |

**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

**⚠** When disposing of old parts, obey the applicable local and provincial requirements.

For instructions to replace the following parts, please refer to the Assembly Manual for your machine:

- Power Cord

**NOTICE:** This document provides instructions for the calibration of the Brake tension on the Nautilus™ E618 Elliptical Fitness Machines.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

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- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



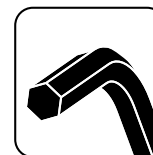
13mm open end wrench  
17mm open end wrench



Small flathead screwdriver



6mm hex wrench

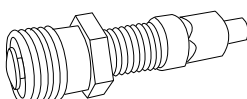


14mm socket and wrench



2.5" x 10" cardboard (3mm / 1/8" thick) and tape

Crank puller



1. Turn the power on to the machine.
2. Set the resistance level to the maximum setting on the Console.
3. Turn the power switch to off and disconnect all power and allow to sit for 5 minutes.

**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

4. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



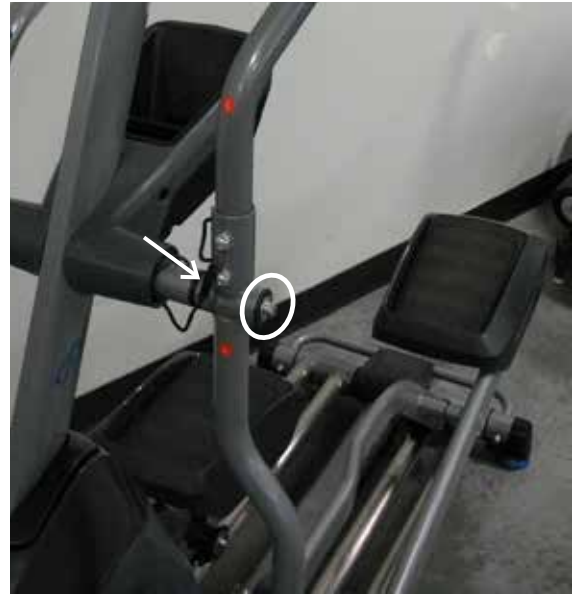
5. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



6. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

7. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



8. Using a 6mm hex wrench, loosen and remove the indicated hardware from the Left Crank Arm and Leg, and set it safely aside for reassembly. Remove the left Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



9. Using a small standard screwdriver, gently pry the cap off of the Left Crank Arm.

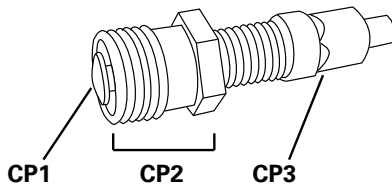


10. Using a 14mm socket and ratchet, remove the Lock Nut from the Left Crank Arm.



11. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



12. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

13. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

14. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.

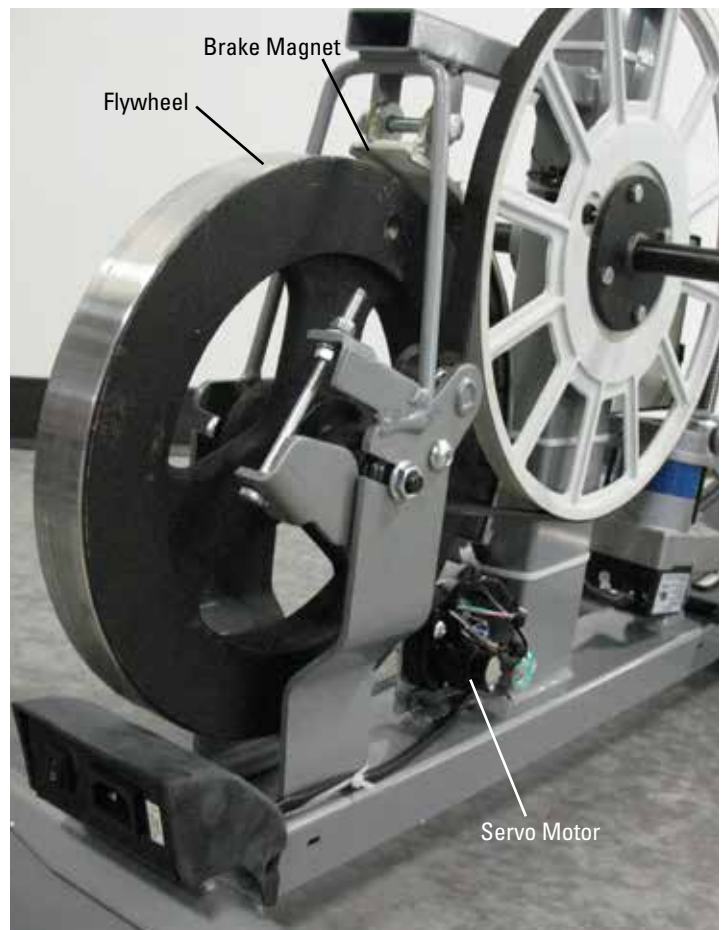


15. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.



16. Insert 2.5" x 10" cardboard between the Flywheel and the Brake Magnet, and tape the cardboard to the Brake Magnet.

**Note:** Be sure the cardboard covers all of the Brake Magnet.



17. To adjust the Brake tension, loosen the 2 hex head bolts and move the Servo Motor assembly until the closest point on the Brake Magnet is within 3.0mm (1/8") of the Flywheel. Tighten the bolts.

**Note:** If the cardboard is not 3mm (1/8") thick, you can use the pages of a paperback book to measure the gap. Approximately 36 pages (sheets) = 3mm.

18. Remove the cardboard from between the Brake Magnet and the Flywheel.

19. Before fully attaching the Shrouds, power up the machine to verify that the Magnet Arm can move freely, and that the Brake Magnet and Flywheel do not touch at the maximum resistance level.

**⚠ Machine is on. Current is active. There is risk of electrical shock. Be sure to keep fingers clear of all pinch hazards when you change the resistance level.**

20. Turn the power switch to off and disconnect all power and allow to sit for 5 minutes.

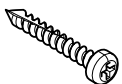
**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

21. Installation is the reverse procedure.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

**NOTICE:** This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.

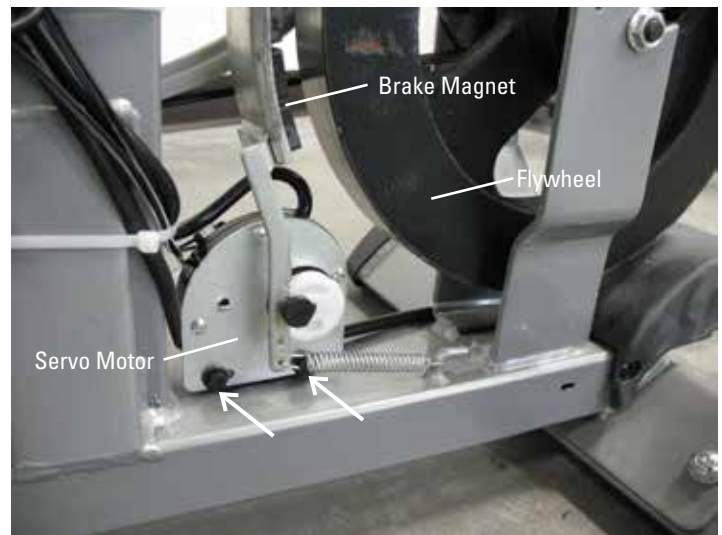


Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

22. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**⚠ Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

After adjusting the Brake Assembly, the resistance levels of the machine may be different. The user should adjust their workout levels accordingly.



**NOTICE:** This document provides instructions for the adjustment of the Drive Belt tension on the Nautilus™ E618 Elliptical fitness machine.

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- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
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### Tools Required (not included)

#2 Phillips screwdriver



10mm open end wrench (2)  
13mm open end wrench



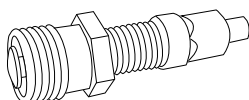
Small flathead screwdriver



14mm socket and wrench



Crank puller



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1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



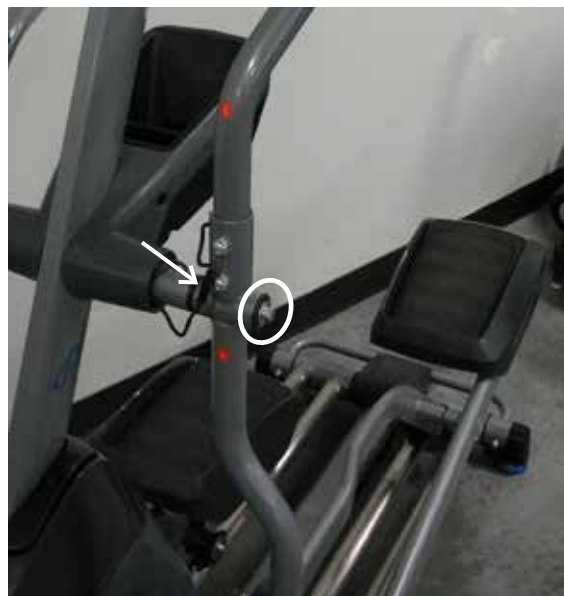
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Left Crank Arm and Leg, and set it safely aside for reassembly. Remove the left Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



9. Using a small standard screwdriver, gently pry the cap off of the Left Crank Arm.

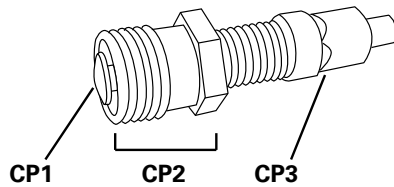


10. Using a 14mm socket and ratchet, remove the Lock Nut from the Left Crank Arm.



11. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



12. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

13. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

14. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.



**Note:** Your machine may not match the image. For reference only.

15. To test the Drive Belt tension:

- Push the Drive Belt downward at the midpoint (M) between the pulleys and measure the distance. The Drive Belt should have only 0.25" (0.64 cm) of give.

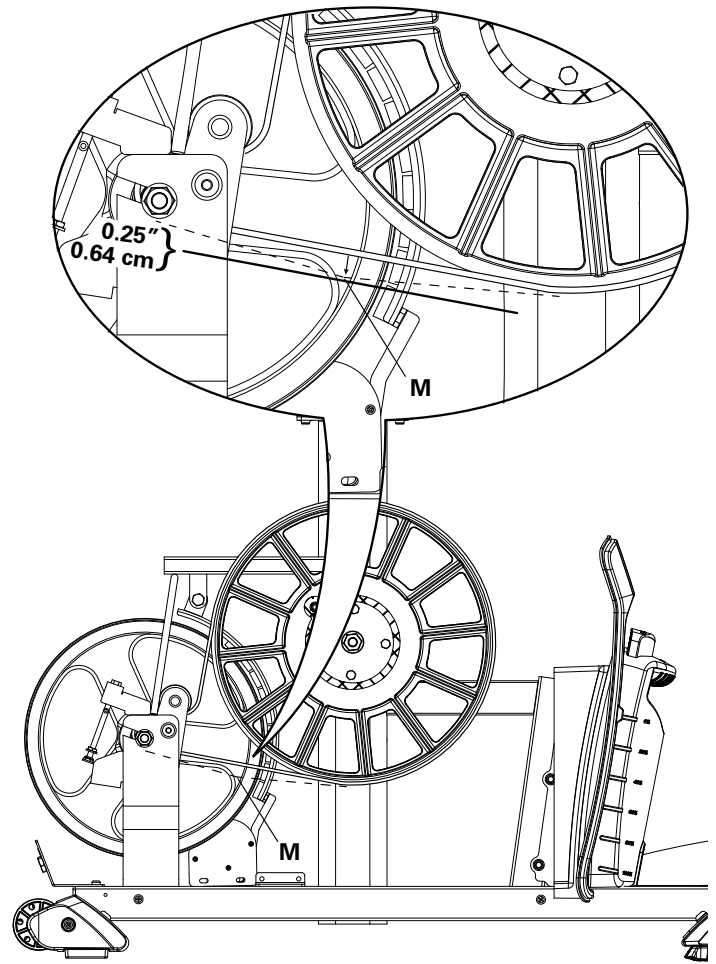
Or:

- Hold the edges of the Drive Belt at the midpoint (M) and twist it. The Drive Belt should turn only 90 degrees (1/4 turn, to vertical).



If the tension is correct, go to Step 19.

If the tension is too loose or too tight, adjust the nuts and bolt on the Tensioner Assembly (Idler Assembly).



16. To adjust the Tensioner Nuts on the Tensioner Bracket, use a 10mm open end wrench to hold the Tensioner Bolt steady and turn the nuts with a second 10mm open end wrench.

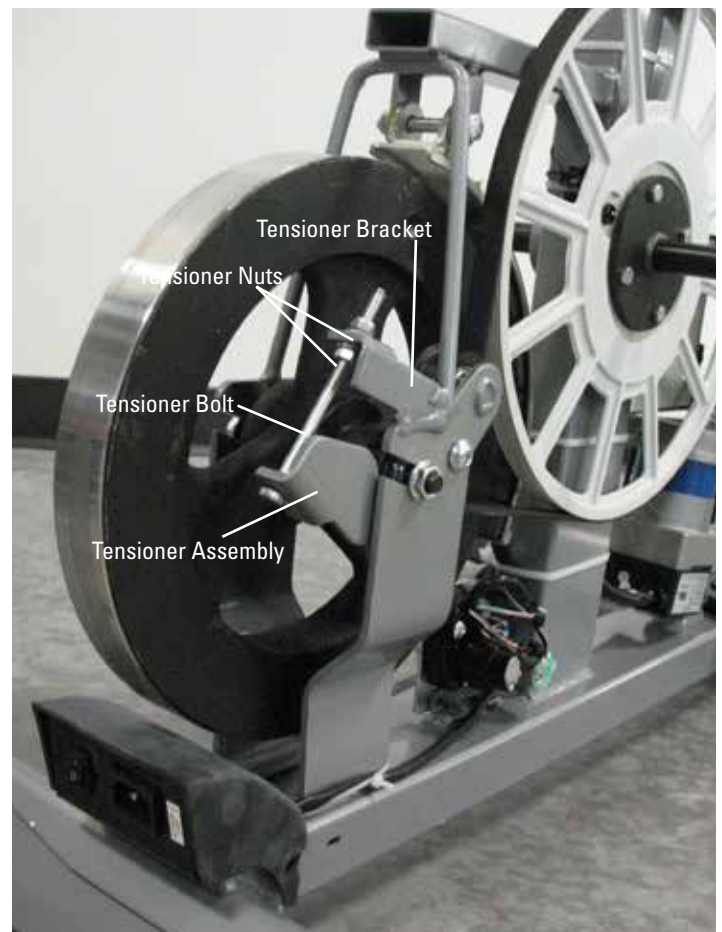
17. When the tension is correct, tighten the nuts against the Tensioner Bracket to hold the bolt and the Tensioner Assembly in position.

**Note:** This step may require two people.

18. Carefully turn the Right Crank Arm and check the movement of the Drive Belt. The Crank Arms and Flywheel should move as one.

**⚠ Be sure to keep fingers clear of all pinch hazards when you turn the Right Crank Arm.**

Adjust the belt tension again if necessary.

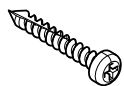


19. Installation is the reverse procedure.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first.

*NOTICE:* This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

20. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Tensioner Assembly on the Nautilus™ E618 Elliptical fitness machine.

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### Tools Required (not included)

#2 Phillips screwdriver



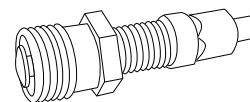
14mm socket and wrench



Small standard screwdriver



Crank puller



6mm hex wrench



10mm open end wrench  
13mm open end wrench  
17mm open end wrench



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1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



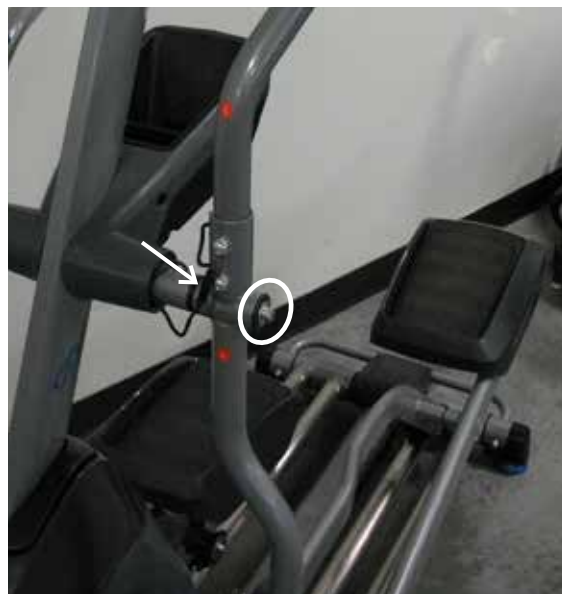
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Left Crank Arm and Leg, and set it safely aside for reassembly. Remove the left Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Using a small standard screwdriver, gently pry the cap off of the Left Crank Arm.

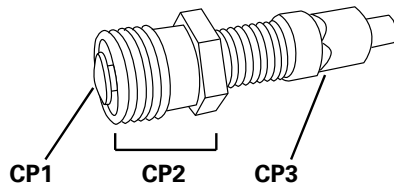


7. Using a 14mm socket and ratchet, remove the Lock Nut from the Left Crank Arm.



8. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



9. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

10. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

11. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.



12. Measure or mark on a piece of scrap paper the length from the end of the Tensioner Bolt to the outer Tensioner Nut. This will assist with re-assembly.

13. Using a 10mm wrench, loosen and remove the outer Tensioner Nut so the Tension Bolt can be released from the Tensioner Bracket.

14. Using a 6mm hex wrench and a 13mm wrench, remove the Tensioner Assembly Hardware (A) that attaches the Tensioner Assembly to the Frame Upright.

Note: Use the hex wrench to hold the bolt (A) in place on the outside and turn the nut from the inside.

15. Remove the Tensioner Assembly from the Frame Assembly and the Drive Belt.

16. Install the new Tensioner Assembly routing the Drive Belt correctly. Secure the hardware.

Note: Be sure to adjust the replacement Tensioner Bolt and Tensioner Nuts to the previous length.

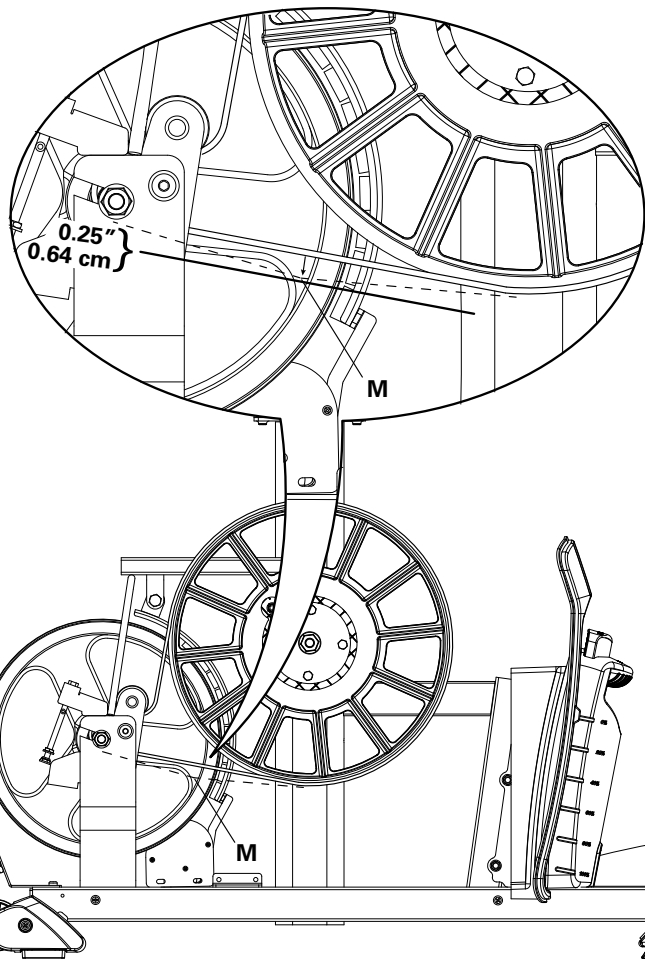
**Note:** Your machine may not match the image. For reference only.

17. To test the Drive Belt tension:

- Push the Drive Belt downward at the midpoint (M) between the pulleys and measure the distance. The Drive Belt should have only 0.25" (0.64 cm) of give.

Or:

- Hold the edges of the Drive Belt at the midpoint (M) and twist it. The Drive Belt should turn only 90 degrees (1/4 turn, to vertical).



If the tension is correct, go to Step 19.

If the tension is too loose or too tight, adjust the nuts and bolt on the Tensioner Assembly (Idler Assembly).

18. To adjust the Tensioner Nuts on the Tensioner Bracket, use a 10mm open end wrench to hold the Tensioner Bolt steady and turn the nuts with a second 10mm open end wrench.

19. When the tension is correct, tighten the nuts against the Tensioner Bracket to hold the bolt and the Tensioner Assembly in position.

**Note:** This step may require two people.

20. Carefully turn the Right Crank Arm and check the movement of the Drive Belt. The Crank Arms and Flywheel should move as one.

**!** Be sure to keep fingers clear of all pinch hazards when you turn the Right Crank Arm.

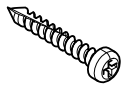
Adjust the belt tension again if necessary.

21. Installation is the reverse procedure.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

**NOTICE:** This step may require two people. Be sure not to crimp any cables.

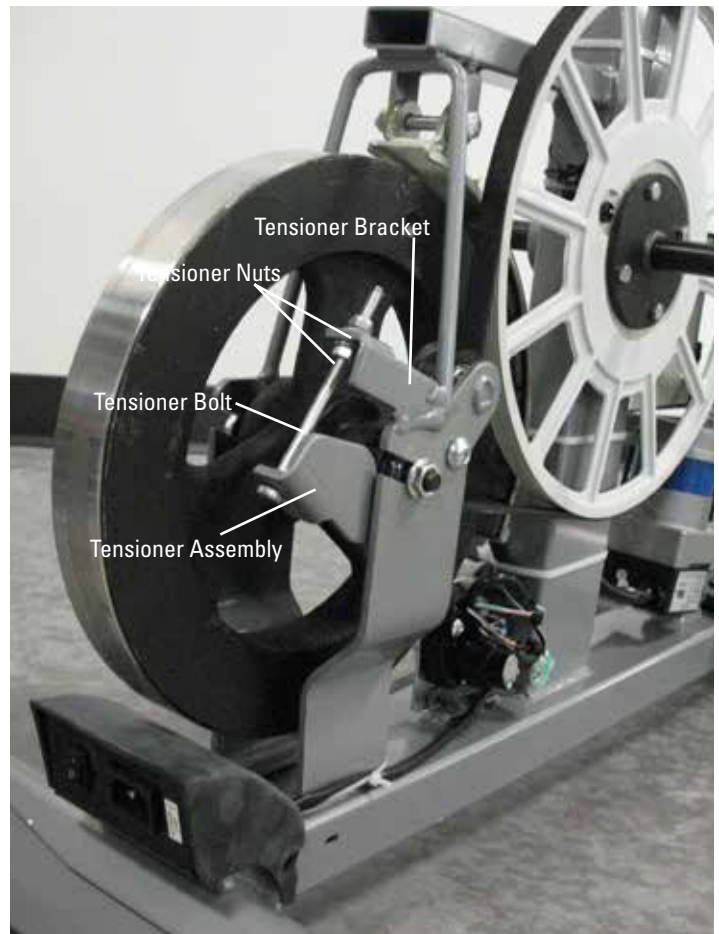
**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

22. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**!** Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.



**NOTICE:** This document provides instructions for the replacement of the Brake Assembly on the Nautilus™ E618 Elliptical fitness machine.

If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)

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### Important Safety Instructions - Before servicing or using this equipment, obey the following warnings:

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**! DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



13mm wrench  
17mm wrench



Small standard screwdriver



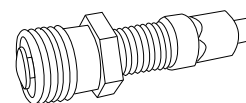
Needlenose pliers



6mm hex wrench



Crank puller



14mm socket and wrench



2.5" x 10" cardboard and tape



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



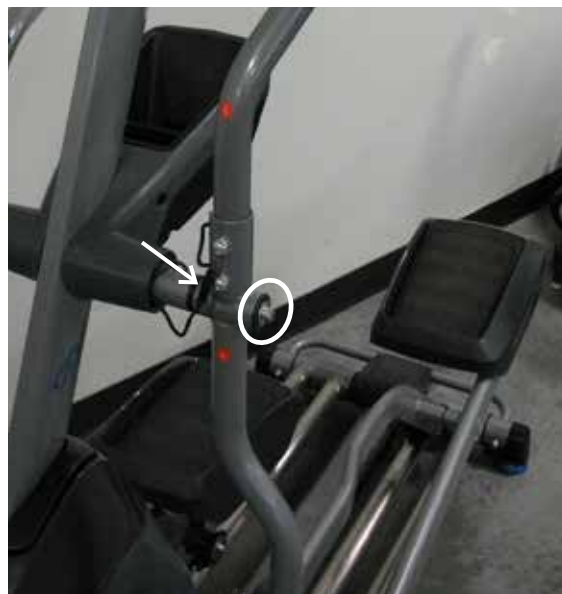
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Left Crank Arm and Leg, and set it safely aside for reassembly. Remove the left Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Using a small standard screwdriver, gently pry the cap off of the Left Crank Arm.

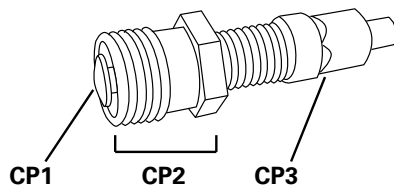


7. Using a 14mm socket and ratchet, remove the Lock Nut from the Left Crank Arm.



8. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



9. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

10. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

11. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.



12. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.



13. Insert 2.5" x 10" cardboard between the Flywheel and the Brake Magnet, and tape the cardboard to the Brake Magnet.

**Note:** Be sure the cardboard covers all of the Brake Magnet.



14. Use pliers to unhook the Tension Spring from the Main Frame. Pull back and release the Magnet Arm enough to disengage it from the Motor Pulley Shaft.

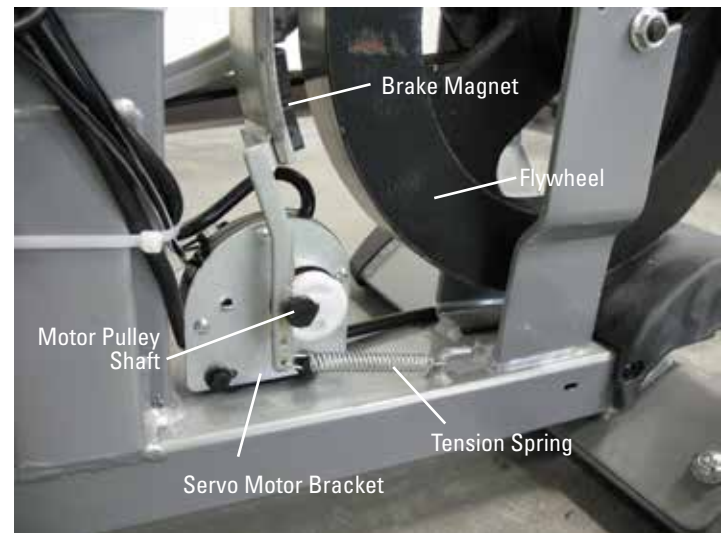
15. Loosen and remove the Brake Magnet Hardware that attaches the Brake Assembly to the Main Frame Bracket.

*NOTICE:* Hold the Brake Assembly so that it does not fall.  
Do not crimp the cables

16. Remove the Brake Assembly, and then the cardboard. Discard the old Brake Assembly.

17. Installation is the reverse procedure. Tape the cardboard to the new Brake Magnet. Be sure the cardboard will completely cover the new Brake Magnet before installation.

*NOTICE:* Do not crimp the cables.



18. Before fully attaching the Shrouds, power up the machine to verify that the Magnet Arm can move freely, and that the Brake Magnet and Flywheel do not touch at the maximum resistance level.

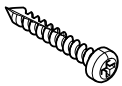
**⚠ Machine is on. Current is active. There is risk of electrical shock. Be sure to keep fingers clear of all pinch hazards when you change the resistance level.**

19. Installation is the reverse procedure.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

*NOTICE:* This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

20. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**⚠ Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

After replacing the Brake Assembly, the resistance levels of the machine may be different. The user should adjust their workout levels accordingly.

**NOTICE:** This document provides instructions for the replacement of the Console on the Nautilus™ E618 Elliptical fitness machine.

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**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



6mm hex wrench





To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and the machine and wait 5 minutes before cleaning, maintaining or repairing the machine. Place the power cord in a secure location.

1. To remove the Console Junction Cover, pinch the sides to release the side snaps, and then pivot it forward and off of the machine.



2. Using a 6mm hex wrench, remove the indicated hardware from the Console Mast.



3. Gently lift and remove the Console/Static Handlebar Assembly from the Console Mast and disconnect the four cables (the Input/Output, Lift Motor, Resistance Control, and Incline Control Cables) that come from the back of the Console.

**Note:** Do not let the Cables fall down inside the Console Mast. If necessary, use a rubber band or wire tie to secure them. This step may require two people.



4. Using a #2 Phillips screwdriver, remove the four indicated screws from the Console and remove the Static Handlebar.

**Note:** Be sure to observe how the cables route through the Static Handlebar from the Console before removing it to assist with re-assembly. Do not crimp the cables.

5. Installation is the reverse procedure.

**NOTICE:** Do not crimp the cables.

6. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

 **Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**



7. Plug the machine in and turn the power on to the machine.

### **Initial Setup**

During the first power-up, the Console should be setup with the date, time and your preferred measurement units.

8. Date: Push the Increase/Decrease buttons to adjust the currently active value (flashing). Push the Left/Right buttons to change which segment is the currently active value (month / day / year).

9. Push OK to set.

10. Time: Push the Increase/Decrease buttons to adjust the currently active value (flashing). Push the Left/Right buttons to change which segment is the currently active value (hour / minute / AM or PM).

11. Push OK to set.

12. Units of Measurement: Push the Increase/Decrease buttons to adjust between "MILES" (Imperial English) or "KM" (metric).

13. Push OK to set. The Console goes back to the Power-Up / Idle Mode screen.

14. Turn off the power switch and remove the power cord.

**NOTICE:** This document provides instructions for the replacement of the Console Mast and Water Bottle Holder on the Nautilus™ E618 Elliptical fitness machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

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- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



Small flathead screwdriver



13mm open end wrench



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. To remove the Console Junction Cover, pinch the sides to release the side snaps, and then pivot it forward and off of the machine.



2. Using a 6mm hex wrench, remove the indicated hardware from the Console Mast.



3. Gently lift and remove the Console/Static Handlebar Assembly from the Console Mast and disconnect the four cables (the Input/Output, Lift Motor, Resistance Control, and Incline Control Cables) that come from the back of the Console.

**Note:** Do not let the Cables fall down inside the Console Mast. If necessary, use a rubber band or wire tie to secure them. This step may require two people.



4. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



5. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware from the Lower Handlebar Arms and Pedals.

**⚠ Be aware that the Handlebar Arm will be loose and may pivot when the hardware is removed.**

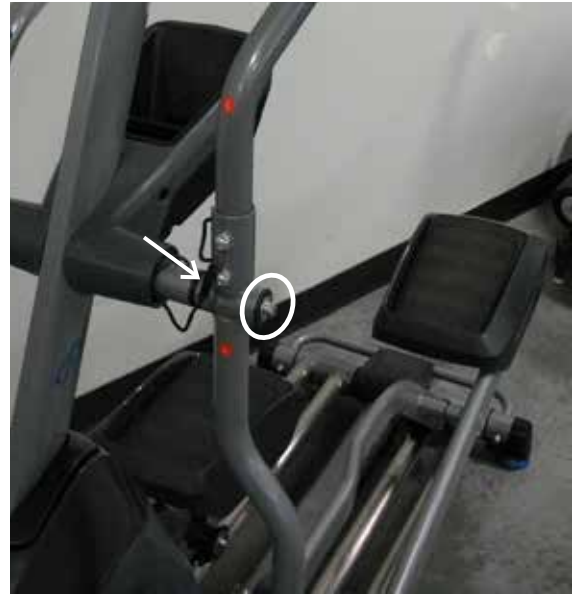
**Note:** To assist with reassembly, observe how the Pivot Sleeve engages flush with the Lower Handlebar Arm.



6. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

7. Using a 6mm hex wrench and a 13mm wrench, remove the hardware from the Lower Handlebar Arm and the Arm Pivot Rod. The hardware on both ends of the Arm Pivot Rod will need to be held to remove it.

8. Remove the Lower Handlebar Arms.



9. Using a #2 Phillips screwdriver, remove the 5 screws (3 indicated on left side, two on right side) from the Water Bottle Holder.

If you are only replacing the Water Bottle Holder—go to Step 14.

If you are replacing the Console Mast—continue to Step 10.

10. Remove the Arm Pivot Rod from the Console Mast and set it safely aside for reassembly.

**Note:** Be aware that the Arm Pivot Rod is coated with lubrication. Place it on a rag or piece of cardboard to contain the lubrication.



11. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Console Mast.

12. Using a 6mm hex wrench, remove the hardware (indicated) from the Console Mast. Slightly pull the Mast up and disconnect the cables. Set the hardware aside for reassembly.

**NOTICE:** Do not crimp the cables. Do not allow the cables to fall down into the Main Unit or into the Console Mast. This step may require two people.

13. Remove the Console Mast from the Upper Shroud.



14. Installation is the reverse procedure.

*NOTICE:* Do not crimp the cables. Do not allow the cables to fall down into the Console Mast.

15. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Crank Arms on the Nautilus™ E618 Elliptical fitness machine.

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- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
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### Tools Required (not included)

6mm hex wrench



14mm socket and wrench



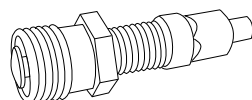
Small flathead screwdriver



13mm open end wrench



Crank puller



**⚠ DANGER**

To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.



**Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.**



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Crank Arm and Leg, and set it safely aside for reassembly. On each side of the machine, remove the Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Using a small standard screwdriver, gently pry the cap off of the Crank Arm.

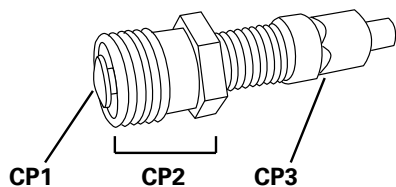


7. Using a 14mm socket and ratchet, remove the Lock Nut from the Crank Arm.



8. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



9. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

10. Installation is the reverse procedure.

**Note:** Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

11. Dispose of the old parts.

12. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**



**NOTICE:** This document provides instructions for the replacement of the Input/Output (I/O) Cable in the Console Mast on the Nautilus™ E618 Elliptical fitness machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

**⚠ This icon means a potentially hazardous situation which, if not avoided, could result in death or serious injury. Read and understand all Warnings on this machine.**

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### Important Safety Instructions - Before servicing or using this equipment, obey the following warnings:

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**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



4' (1.2m) length of string

Small flathead screwdriver



13mm open end wrench



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. To remove the Console Junction Cover, pinch the sides to release the side snaps, and then pivot it forward and off of the machine.



2. Using a 6mm hex wrench, remove the indicated hardware from the Console Mast.



3. Gently lift and remove the Console/Static Handlebar Assembly from the Console Mast and disconnect the four cables (the Input/Output, Lift Motor, Resistance Control, and Incline Control Cables) that come from the back of the Console.

**Note:** Do not let the Cables fall down inside the Console Mast. If necessary, use a rubber band or wire tie to secure them. This step may require two people.



4. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



5. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware from the Lower Handlebar Arms and Pedals.

**⚠ Be aware that the Handlebar Arm will be loose and may pivot when the hardware is removed.**

**Note:** To assist with reassembly, observe how the Pivot Sleeve engages flush with the Lower Handlebar Arm.



6. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

7. Using a 6mm hex wrench and a 13mm wrench, remove the hardware from the Lower Handlebar Arm and the Arm Pivot Rod. The hardware on both ends of the Arm Pivot Rod will need to be held to remove it.

8. Remove the Handlebar Arms.



9. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Console Mast.

10. Using a 6mm hex wrench, remove the hardware (indicated) from the Console Mast. Slightly pull the Console Mast up and disconnect the cables. Set the hardware aside for reassembly.

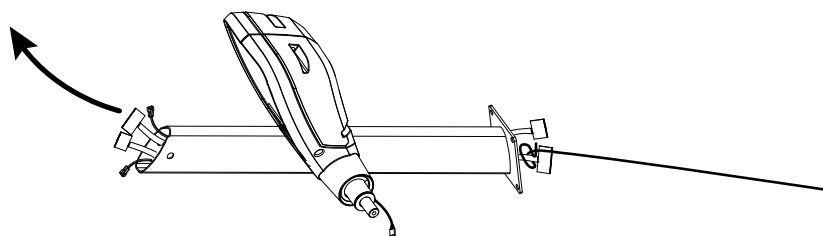
**NOTICE:** Do not crimp the cables. Do not allow the cables to fall down into the Main Unit or into the Console Mast. This step may require two people.

11. Remove the Console Mast from the Upper Shroud.



12. Tie a length of string to the end of the Input/Output (I/O) Cable at the base of the Console Mast. Hold the other end of the Input/Output (I/O) Cable and carefully pull it out of the Console Mast so that the string extends through the length of the Console Mast.

**NOTICE:** Hold the Lift Motor Wire so that you do not pull it out of the Console Mast. Do not crimp the cables.



13. Untie the string from the old Input/Output (I/O) Cable and discard the old cable.

14. Tie the end of the string at the base of the Cable Mast to one end of the replacement Input/Output (I/O) Cable. Hold the other end of the string and carefully pull the new Input/Output (I/O) Cable through the Cable Mast.

*NOTICE:* Hold the Lift Motor Wire so that you do not pull it out of the Console Mast. Do not crimp the cables.

15. Connect the new Input/Output (I/O) Cable to the Lower Input/Output (I/O) Cable from the Main Frame. Reconnect the other cable from the Mast and the Main Frame.

*NOTICE:* Do not crimp the cables. This step may require two people.

16. Reassembly is the reverse procedure.

*NOTICE:* Do not crimp the cables. Untie the string from the Lift Motor Wire. Do not allow the cables to fall down into the Console Mast.

Be sure the tabs in the Top Shroud snap into the Main Assembly.

17. Installation is the reverse procedure.

*NOTICE:* Do not crimp the cables. Do not allow the cables to fall down into the Console Mast.

18. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Flywheel and Drive Belt on the Nautilus™ E618 Elliptical fitness machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

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**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
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- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



14mm socket and wrench



Flathead screwdriver



10mm open end wrench  
13mm open end wrench  
17mm open end wrench

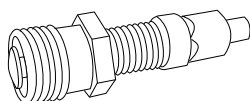


6mm hex wrench



2.5" x 10" cardboard and tape

Crank puller



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



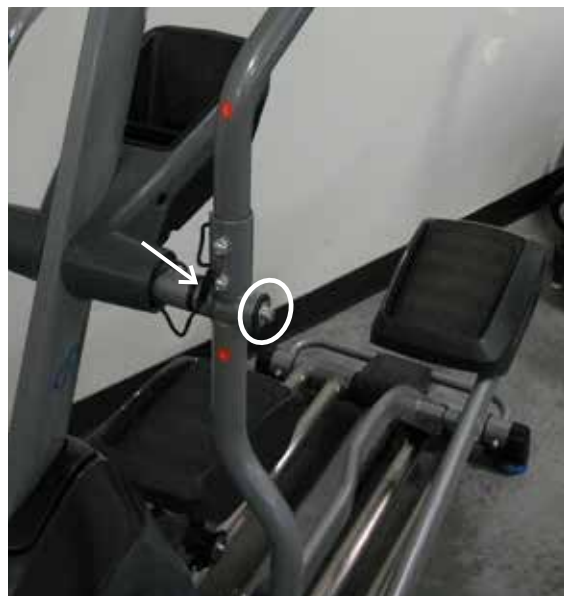
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Left Crank Arm and Leg, and set it safely aside for reassembly. Remove the left Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Using a small standard screwdriver, gently pry the cap off of the Left Crank Arm.

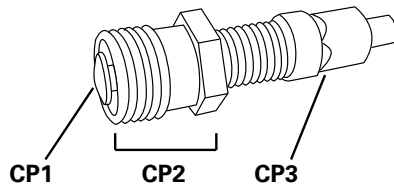


7. Using a 14mm socket and ratchet, remove the Lock Nut from the Left Crank Arm.



8. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



9. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

10. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

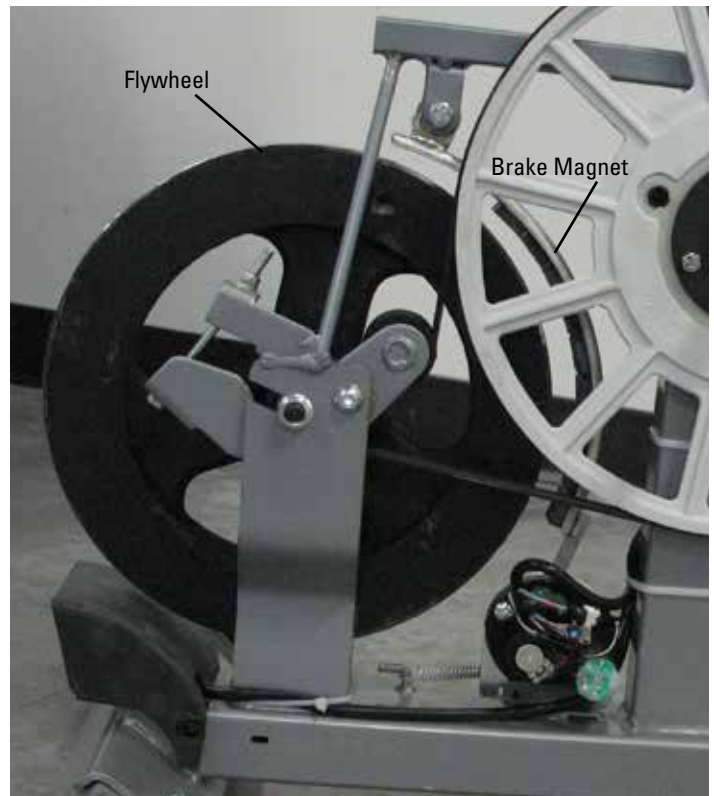
11. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.



12. Insert 2.5" x 10" cardboard between the Flywheel and the Brake Magnet, and tape the cardboard to the Brake Magnet.

**Note:** Be sure the cardboard covers all of the Brake Magnet.



13. Measure or mark a piece of scrap paper the length from the end of the Tensioner Bolt to the outer Tensioner Nut. This will assist with re-assembly.

14. Using a 10mm wrench, loosen and remove the outer Tensioner Nut so the Tension Bolt can be released from the Tensioner Bracket.

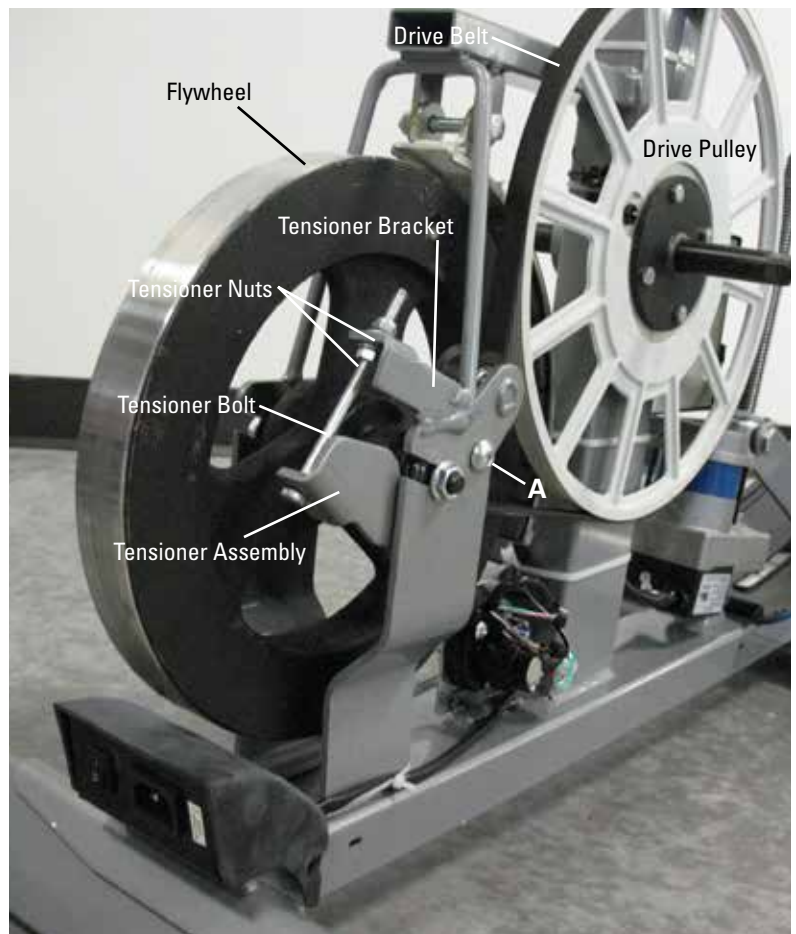
15. Using a 6mm hex wrench and a 13mm wrench, loosen the Tensioner Assembly Hardware (A) that attaches the Tensioner Assembly to the Frame Bracket.

**Note:** Use the hex wrench to hold the bolt in place on the outside and turn the nut from the inside.

16. Turn the Drive Pulley clockwise while forcing the Drive Belt to the outside to remove it. The belt will come off of the Drive Pulley.



**Keep fingers out of any pinch hazards when turning the Pulleys.**



17. To remove the indicated hardware (by oval) from the Flywheel, use a 17mm open end wrench to hold the nut on one side steady and remove the nut on the opposite side with the 17mm socket and wrench. Set the hardware safely aside.

18. Adjust the angle of the Tensioner Assembly to allow the Flywheel to move forward. Remove the Flywheel from the Frame Brackets and the Drive Belt.



**The Flywheel is heavy. This step may require two people.**

19. Remove the old Drive Belt after noting how to properly route the new Belt.

20. Hold the Flywheel near the Frame Brackets and put the new Drive Belt in position on the Flywheel Pulley. Put the Drive Belt in position around the Tensioner Assembly. Be sure that the upper portion of the Drive Belt is under the Tensioner Bearings on the Tensioner Assembly.

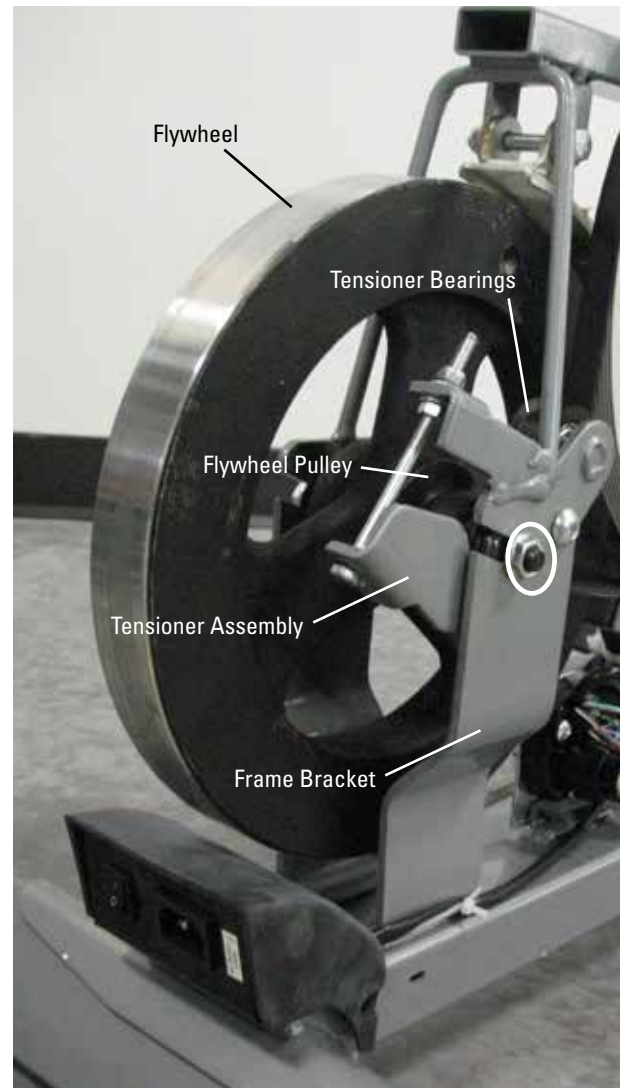


**The Flywheel is heavy. This step may require two people.**

21. Center the Flywheel Axle in the Frame Brackets and hand tighten the hardware on each end of the Flywheel Axle.

22. Put the Drive Belt onto the Drive Pulley. Make sure the Drive Belt is aligned on the Flywheel Pulley, Belt Tensioner and Drive Pulley.

23. Before you fully tighten the Flywheel hardware, adjust the Tensioner Bolt to the recorded length and tighten the hardware Tensioner Nuts. Make sure that the belt tension is correct.



**Note:** Your machine may not match the image. For reference only.

24. To test the Drive Belt tension:

- Push the Drive Belt downward at the midpoint (M) between the pulleys and measure the distance. The Drive Belt should have only 0.25" (0.64 cm) of give.

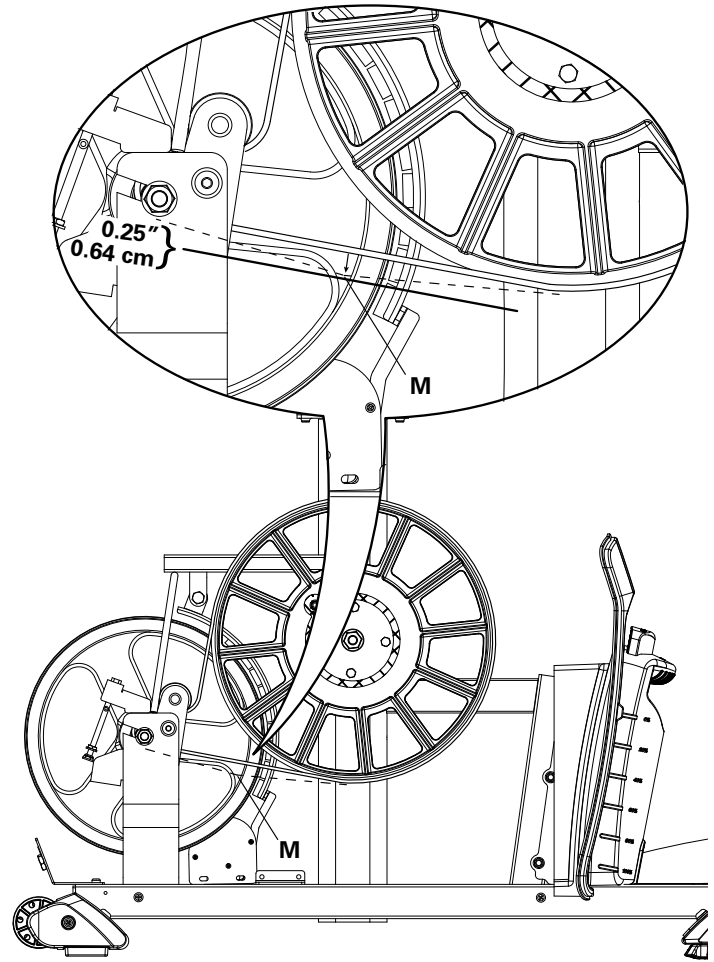
Or:

- Hold the edges of the Drive Belt at the midpoint (M) and twist it. The Drive Belt should turn only 90 degrees (1/4 turn, to vertical).



If the tension is correct, go to Step 26.

If the tension is too loose or too tight, adjust the nuts and bolt on the Tensioner Assembly (Idler Assembly).



25. To adjust the Tensioner Nuts on the Tensioner Bracket, use a 10mm open end wrench to hold the Tensioner Bolt steady and turn the nuts with a second 10mm open end wrench.

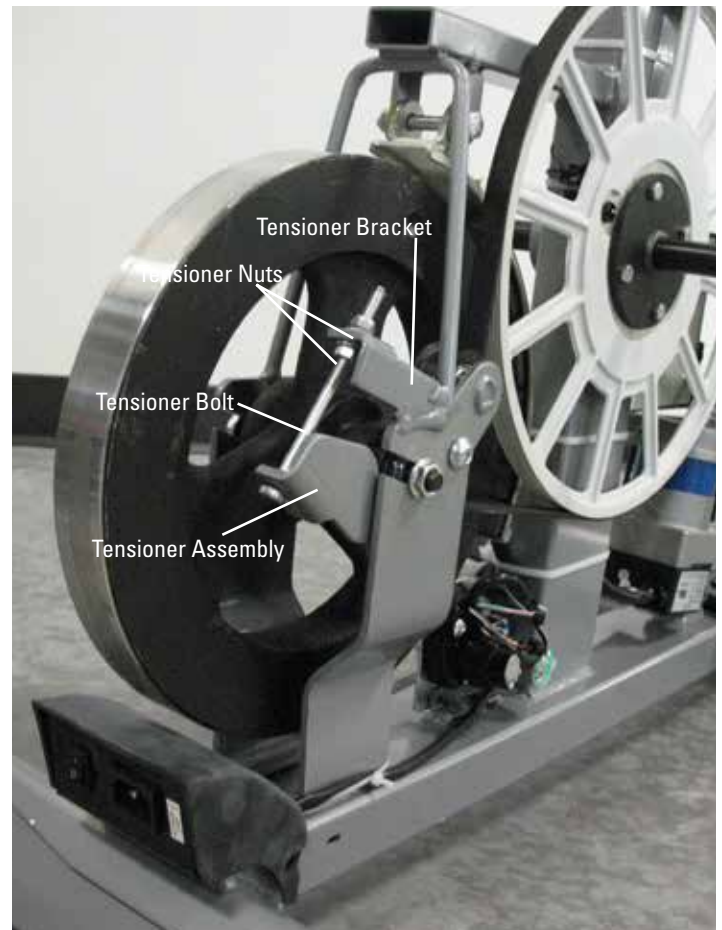
26. When the tension is correct, tighten the nuts against the Tensioner Bracket to hold the bolt and the Tensioner Assembly in position.

**Note:** This step may require two people.

27. Carefully turn the Right Crank Arm and check the movement of the Drive Belt. The Crank Arms and Flywheel should move as one.

**⚠ Be sure to keep fingers clear of all pinch hazards when you turn the Right Crank Arm.**

Adjust the belt tension again if necessary.



28. To tighten the Flywheel hardware use the 17mm open end wrench to hold the nut on one side steady and tighten the nut on the opposite side with the 17mm socket and wrench.

29. Before fully attaching the Shrouds, power up the machine to verify that the Magnet Arm can move freely, and that the Brake Magnet and Flywheel do not touch at the maximum resistance level.

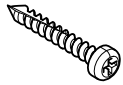
**!** **Machine is on. Current is active. There is risk of electrical shock. Be sure to keep fingers clear of all pinch hazards when you change the resistance level.**

30. Installation is the reverse procedure.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

*NOTICE:* This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

31. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**!** **Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**



**NOTICE:** This document provides instructions for the replacement of the Front Stabilizer on the Nautilus™ E618 Elliptical fitness machine.

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**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



Static solid object (like a book or box)



**⚠ DANGER**

To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

**NOTICE:** This procedure requires two or three people.

1. Place a static object (like a book or box) under the front of the main frame but not under the Front Stabilizer. The static object should not be compressible.

2. Loosen and remove the 2 bolts that attach the Front Stabilizer using a 6 mm hex key. Remove the Front Stabilizer.



3. Installation is the reverse procedure.

4. Dispose of the old part.

5. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.

**NOTICE:** This document provides instructions for the replacement of the Incline Adjuster Assembly on the Nautilus™ E618 Elliptical fitness machine.

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- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
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- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



14mm socket and wrench



Small standard screwdriver



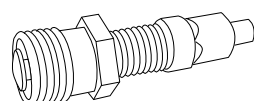
#2 Phillips screwdriver



13mm open end wrench  
17mm open end wrench  
18mm open end wrench



Crank puller



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



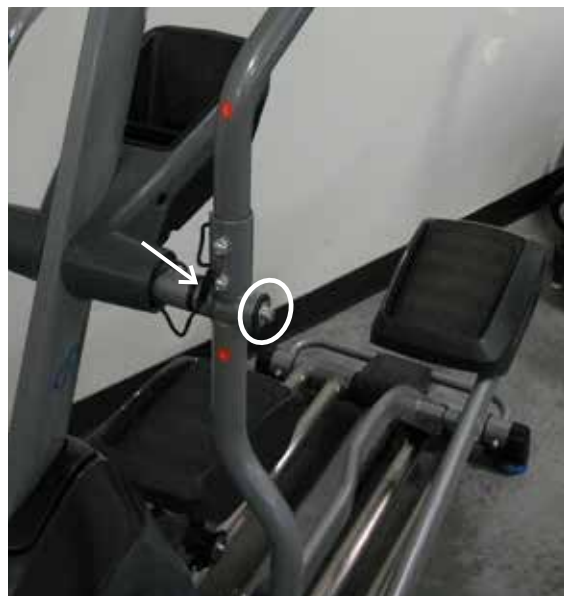
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Crank Arm and Leg, and set it safely aside for reassembly. On each side of the machine, remove the Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Bend the edges of the Top Shroud to disengage the inside tabs from the Main Assembly.



7. Using a small standard screwdriver, gently pry the cap off of the Crank Arm.

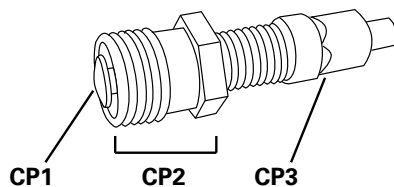


8. Using a 14mm socket and ratchet, remove the Lock Nut from the Crank Arm.



9. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



10. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

11. Using a #2 Phillips screwdriver, remove the 7 indicated screws (\*) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.

12. Bend the edges of the Top Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

13. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws below the Upper Shroud) that secure the Left Shroud. Remove the lower screws first. Slowly remove the Left Shroud.



14. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.

15. Using the 18mm open end wrench, remove the indicated bolts (with an oval) that attach the Incline Adjuster bracket to the Lift Motor Assembly. This will allow the Incline Adjuster Assembly to pivot.



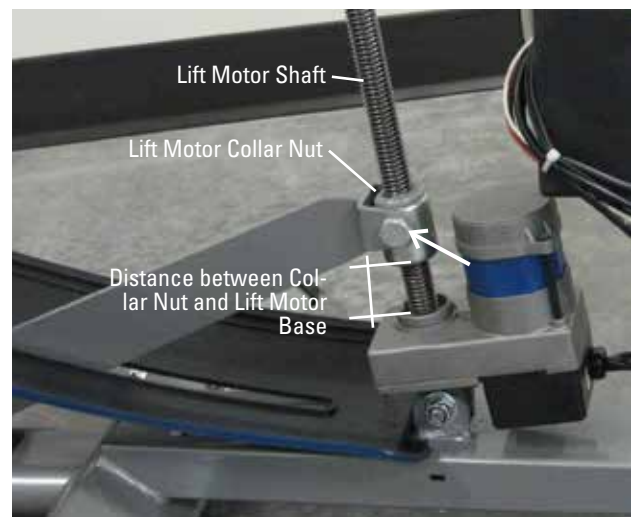
16. Count the number of threads showing on the Lift Motor Shaft between the Collar Nut and the Lift Motor base, and record the number.

17. Using the 18mm socket and wrench and 18mm open end wrench, loosen and remove the hex head bolts that attach the Incline Adjuster Assembly to the Lift Motor shaft. Set the bolts aside for reassembly.

18. Carefully remove the old Incline Adjuster Assembly and discard.

**Note:** Do not rotate the Lift Motor Collar Nut on the Shaft while the Incline Adjuster Assembly is not installed.

**NOTICE:** Do not crimp any cables.



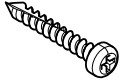
19. Installation is the reverse procedure.

**Note:** Be sure the number of threads showing on the Lift Motor shaft between the Collar Nut and the Lift Motor base is the same as the number recorded in Step 16. If the number is different, turn the collar nut until the thread count is the same.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

*NOTICE:* This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

20. Dispose of the old parts.

21. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Remote Incline or Resistance Cable to the Upper Handlebars on the Nautilus™ E618 Elliptical fitness machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

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### Important Safety Instructions - Before servicing or using this equipment, obey the following warnings:

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**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



4' (1.2m) length of string

Small flathead screwdriver



13mm open end wrench



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. To remove the Console Junction Cover, pinch the sides to release the side snaps, and then pivot it forward and off of the machine.



2. Using a 6mm hex wrench, remove the indicated hardware from the Console Mast.



3. Gently lift and remove the Console/Static Handlebar Assembly from the Console Mast and disconnect the four cables (the Input/Output, Lift Motor, Resistance Control, and Incline Control Cables) that come from the back of the Console.

**Note:** Do not let the Cables fall down inside the Console Mast. If necessary, use a rubber band or wire tie to secure them. This step may require two people.



4. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



5. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware from the Lower Handlebar Arms and Pedals.

**⚠ Be aware that the Handlebar Arm will be loose and may pivot when the hardware is removed.**

**Note:** To assist with reassembly, observe how the Pivot Sleeve engages flush with the Lower Handlebar Arm.



**Note:** The Remote Incline Cable is on the left side of the machine, and the Remote Resistance Cable on the right. The following photos show the Remote Incline Cable being replaced. If replacing the Remote Resistance Cable, perform the same steps but on the right side of the machine.

6. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

7. Using a 6mm hex wrench and a 13mm wrench, remove the hardware from the Lower Handlebar Arm and the Arm Pivot Rod. The hardware on both ends of the Arm Pivot Rod will need to be held to remove it.

8. Remove the Handlebar Arms.

9. Using a #2 Phillips screwdriver, remove the 5 screws (3 indicated on left side, two on right side) from the Water Bottle Holder.

10. Remove the indicated grommet (by arrow) from the Console mast that secures the Remote Incline Cable and remove it from the Cable.

11. Tie a length of string to the end of the Remote Incline Cable. Hold the other end of the Remote Incline Cable and carefully pull it out of the Console Mast so that the string extends through the Console Mast.

**NOTICE:** Do not crimp the cables.

12. Untie the string from the old Remote Incline Cable and discard the old cable.



13. Tie the end of the string out of the side of the Cable Mast to the upper end of the replacement Remote Incline Cable. Hold the other end of the string and carefully pull the new Remote Incline Cable through the Cable Mast.

*NOTICE:* Do not crimp the cables.

14. Untie the string from the new Remote Incline Cable.

15. Reassembly is the reverse procedure.

*NOTICE:* Do not crimp the cables. Untie the string from the Lift Motor Wire. Do not allow the cables to fall down into the Console Mast.

Be sure the tabs in the Top Shroud snap into the Main Assembly.

16. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Lift Motor on the Nautilus™ E618 Elliptical fitness machine.

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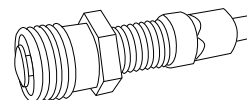
- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
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- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

Short #2 Phillips screwdriver



Crank puller



Small standard screwdriver



13mm open end wrench  
17mm open end wrench  
18mm open end wrench



6mm hex wrench



Utility knife or scissors to cut zipties  
Zipties  
Metric ruler or 35mm spacer

14mm socket and wrench



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



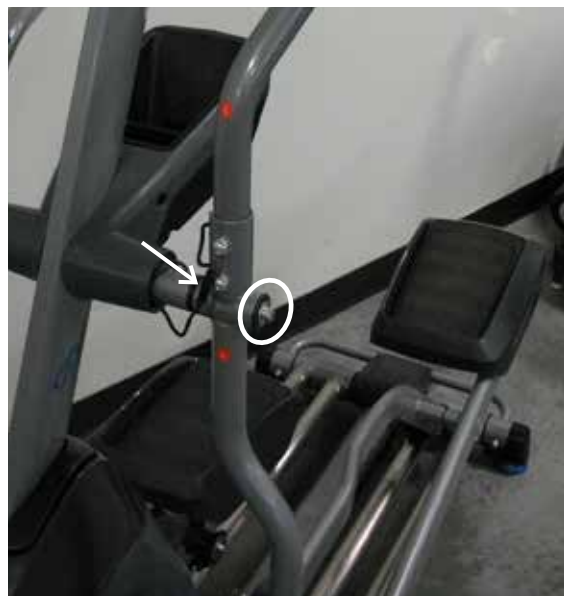
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Crank Arm and Leg, and set it safely aside for reassembly. On each side of the machine, remove the Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Bend the edges of the Top Shroud to disengage the inside tabs from the Main Assembly.



7. Using a small standard screwdriver, gently pry the cap off of the Crank Arm.

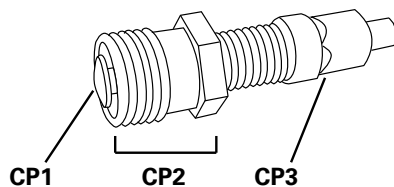


8. Using a 14mm socket and ratchet, remove the Lock Nut from the Crank Arm.



9. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



10. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

11. Using a #2 Phillips screwdriver, remove the 7 indicated screws (\*) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.

12. Bend the edges of the Top Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

13. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws below the Upper Shroud) that secure the Left Shroud. Remove the lower screws first. Slowly remove the Left Shroud.



14. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.

15. Using the 18mm open end wrench, remove the indicated bolts (with an oval) that attach the Incline Adjuster bracket to the Lift Motor Assembly. This will allow the Incline Adjuster Assembly to pivot.



16. Observe the cable routing from the Motor Control Board (MCB) Assembly on your machine.

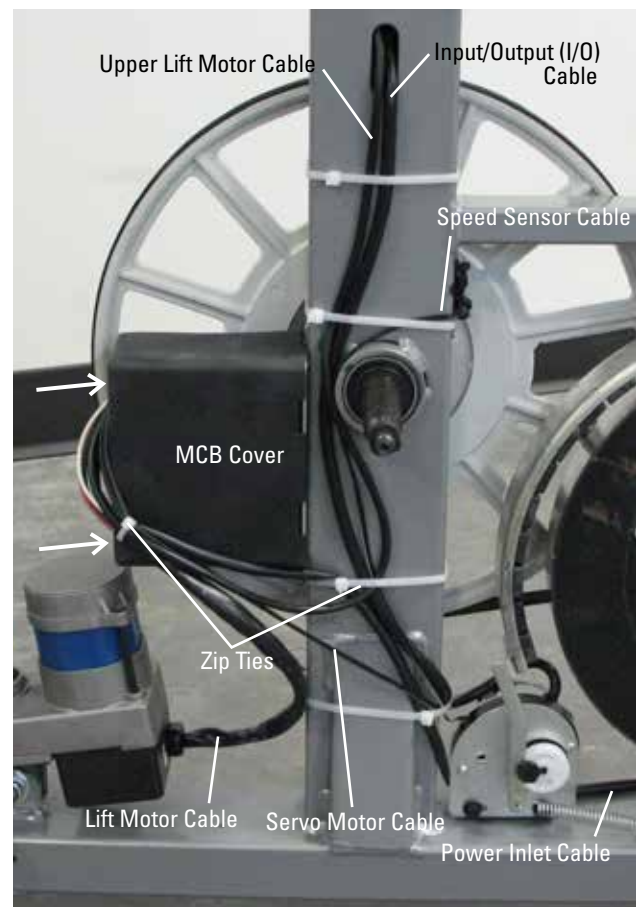
- Power Inlet Cable (Power switch to MCB)
- Lift Motor Cable, Lower (Lift Motor to MCB)
- Lift Motor Cable, Upper (MCB to Console)
- Servo Motor Cable (MCB to Servo Motor)
- Speed Sensor Cable (Speed Sensor to Servo Motor)
- Input/Output (I/O) Cable (Servo Motor to Console)

**Note:** Be sure to note where all cables are routed for re-assembly.

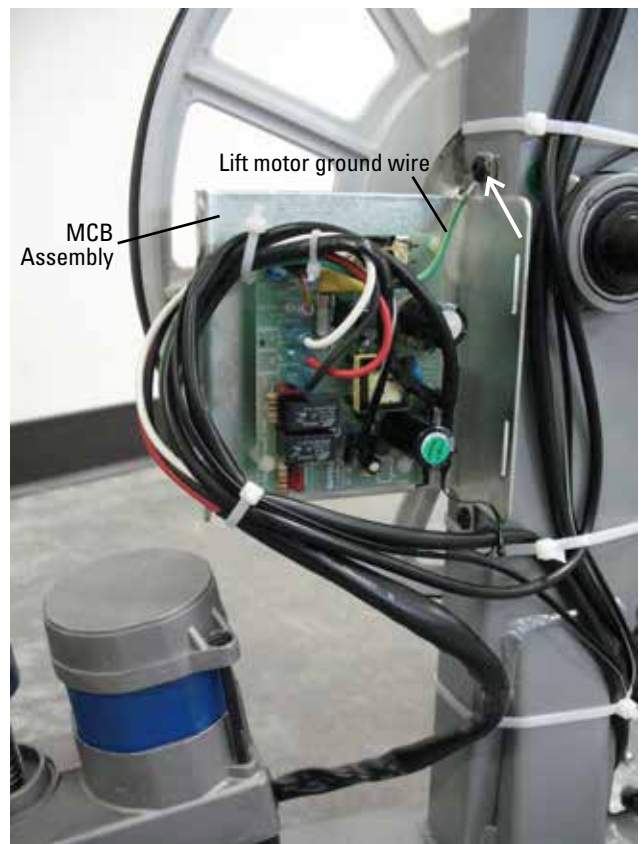
17. Remove the zipties that hold the cables.

18. Using a short #2 Phillips screwdriver, remove the indicated screws (by arrows) from the MCB cover. Carefully remove the MCB cover.

**NOTICE:** Do not crimp the cables.



19. Using a #2 Phillips screwdriver, remove the top screw to free the Lift Motor ground wire. Hand tighten the top screw to hold the MCB Assembly in position on the Frame until reassembly.



20. Disconnect the Lift Motor cable from the Motor Control Board after noting the connector locations.

**Note:** Be sure to note where all cables attach for re-assembly.



21. Using the 18mm socket and wrench and 18mm open end wrench, loosen and remove the indicated hex head bolts (by arrow) that attach the Incline Adjuster Assembly to the Lift Motor shaft. Set the bolts aside for reassembly.



22. Remove the indicated hardware (by arrow) that attaches the Lift Motor Assembly to the Frame.

**Note:** Do not rotate the Lift Motor Collar Nut on the Shaft while the Incline Adjuster Assembly is not installed.

**NOTICE:** Do not crimp any cables.

23. Remove old Lift Motor assembly, and discard.

24. Install the replacement Lift Motor assembly and hardware to the Frame.

25. Connect the Lift Motor cable to the proper locations on the MCB. Secure the cables with zipties.



**Use the top screw to attach the green Lift Motor ground wire to the Frame. Be sure not to crimp any cables.**

26. Turn the power on.



**Machine is on. Current is active. There is risk of electrical shock.**

27. From the Power Up Mode screen, push and hold down the PAUSE/STOP button and Right arrow button for about 3 seconds to go into the Console Setup Mode. The Console display will show the Edit Date screen with the current setting.

28. Push the OK button 4 times until the Console displays the TOTAL RUN HOURS screen.

29. Hold down the PAUSE/END button and Down button together for 3 seconds. The Console display shows the Firmware Version string.

30. Push the Down arrow button 2 times to go to the MOVE LIFT option and push OK to enter the lift options menu.

31. The console displays the UP MX DN MN RT CAL prompt. Push the Down arrow so that the Lift Motor turns to the lower limit.

32. When the motor has stopped turning, adjust the nut (A2) on the shaft (A1) to 35mm above the Lift Motor base, using a ruler or 35mm spacer.

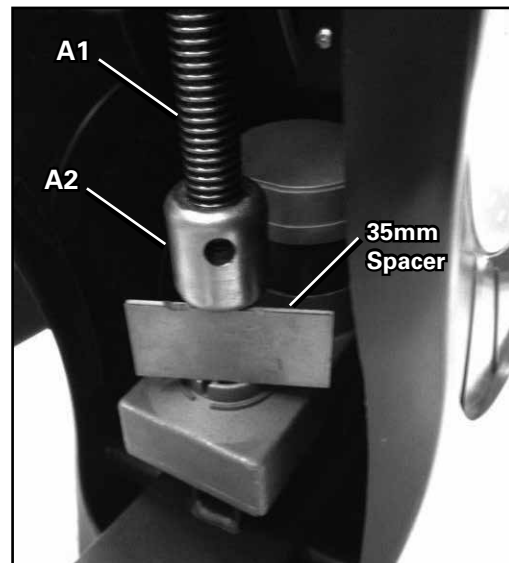
33. Adjust the nut (A2) upward away from the motor base until the holes in the nut align with the holes in the Incline Adjuster (J) bracket. Install the hex head bolts (K) to secure the bracket to the nut.

34. Push the OK button to exit the MOVE LIFT option. Push PAUSE/END to go back to the Power-Up Mode screen.

35. Push the 100% lift preset button to confirm correct operation. Push the 0% lift preset button to confirm correct operation.



**Disconnect all power and allow to sit for 5 minutes.**



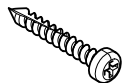
36. Reassembly is the reverse procedure. Secure the cables with zipties.

**NOTICE:** Do not crimp the cables.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first.

**NOTICE:** This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

37. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Lift Motor Wire in the Console Mast on the Nautilus™ E618 Elliptical fitness machine.

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- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



4' (1.2m) length of string

Small flathead screwdriver



13mm open end wrench



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. To remove the Console Junction Cover, pinch the sides to release the side snaps, and then pivot it forward and off of the machine.



2. Using a 6mm hex wrench, remove the indicated hardware from the Console Mast.



3. Gently lift and remove the Console/Static Handlebar Assembly from the Console Mast and disconnect the four cables (the Input/Output, Lift Motor, Resistance Control, and Incline Control Cables) that come from the back of the Console.

**Note:** Do not let the Cables fall down inside the Console Mast. If necessary, use a rubber band or wire tie to secure them. This step may require two people.



4. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



5. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware from the Lower Handlebar Arms and Pedals.

**⚠ Be aware that the Handlebar Arm will be loose and may pivot when the hardware is removed.**

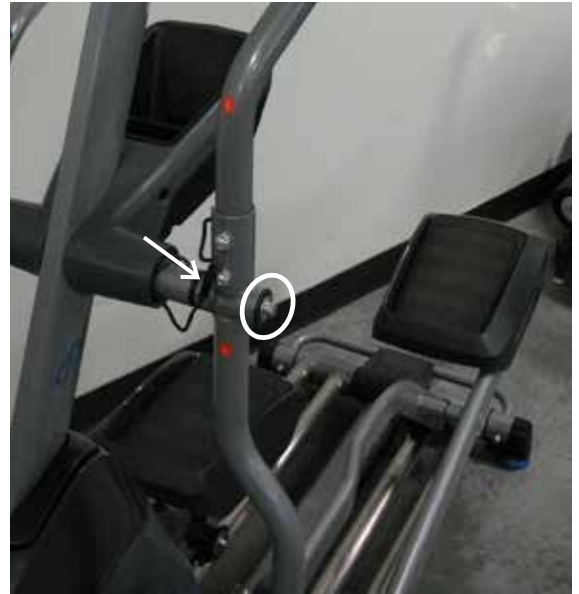
**Note:** To assist with reassembly, observe how the Pivot Sleeve engages flush with the Lower Handlebar Arm.



6. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

7. Using a 6mm hex wrench and a 13mm wrench, remove the hardware from the Lower Handlebar Arm and the Arm Pivot Rod. The hardware on both ends of the Arm Pivot Rod will need to be held to remove it.

8. Remove the Handlebar Arms.



9. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Console Mast.

10. Using a 6mm hex wrench, remove the hardware (indicated) from the Console Mast. Slightly pull the Console Mast up and disconnect the cables. Set the hardware aside for reassembly.

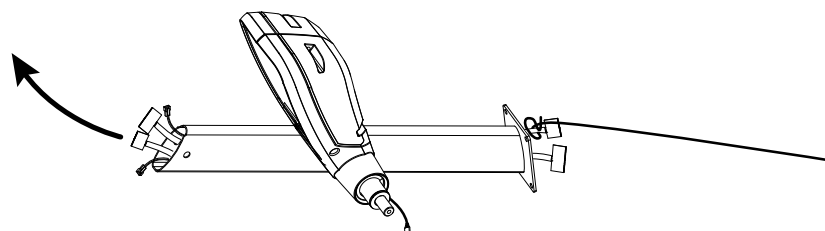
**NOTICE:** Do not crimp the cables. Do not allow the cables to fall down into the Main Unit or into the Console Mast. This step may require two people.

11. Remove the Console Mast from the Upper Shroud.



12. Tie a length of string to the end of the Lift Motor Wire at the base of the Console Mast. Hold the other end of the Lift Motor Wire and carefully pull it out of the Console Mast so that the string extends through the length of the Console Mast.

**NOTICE:** Hold the Input/Output (I/O) Cable so that you do not pull it out of the Console Mast. Do not crimp the cables.



13. Untie the string from the old Lift Motor Wire and discard the old cable.

14. Tie the end of the string at the base of the Cable Mast to one end of the replacement Lift Motor Wire. Hold the other end of the string and carefully pull the new Lift Motor Wire through the Cable Mast.

*NOTICE:* Hold the Input/Output (I/O) Cable so that you do not pull it out of the Console Mast. Do not crimp the cables.

15. Connect the new Lift Motor Wire to the Lift Motor Wire from the Main Frame. Reconnect the other cable from the Mast and the Main Frame.

*NOTICE:* Do not crimp the cables. This step may require two people.

16. Reassembly is the reverse procedure.

*NOTICE:* Do not crimp the cables. Untie the string from the Lift Motor Wire. Do not allow the cables to fall down into the Console Mast.

Be sure the tabs in the Top Shroud snap into the Main Assembly.

17. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Motor Control Board (MCB) on the Nautilus™ E618 Elliptical fitness machine.

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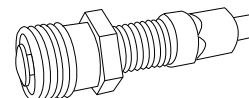
- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

Short #2 Phillips screwdriver



Crank puller



Standard screwdriver



Utility knife or scissors to cut zipties  
Zipties

6mm hex wrench



14mm socket and wrench



**⚠ DANGER**

To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.



**Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.**



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Left Crank Arm and Leg, and set it safely aside for reassembly. Remove the left Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Using a small standard screwdriver, gently pry the cap off of the Left Crank Arm.

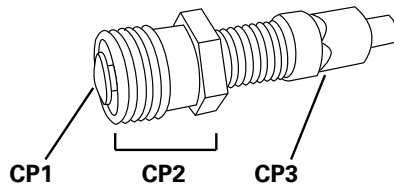


7. Using a 14mm socket and ratchet, remove the Lock Nut from the Left Crank Arm.



8. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



9. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

10. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

11. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.



12. Observe the cable routing from the Motor Control Board (MCB) Assembly on your machine.

- Power Inlet Cable (Power switch to MCB)
- Lift Motor Cable, Lower (Lift Motor to MCB)
- Lift Motor Wire, Upper (MCB to Console)
- Servo Control Wire (MCB to Servo Motor)
- Speed Sensor Cable (Speed Sensor to Servo Motor)
- Input/Output (I/O) Cable (Servo Motor to Console)

**Note:** Be sure to note where all cables are routed for re-assembly.

13. Remove the zipties that hold the cables.

14. Using a short #2 Phillips screwdriver, remove the indicated screws (by arrows) from the MCB cover. Carefully remove the MCB cover.

**NOTICE:** Do not crimp the cables.

15. Disconnect the cables from the Motor Control Board after noting their locations (see next page for detailed image).

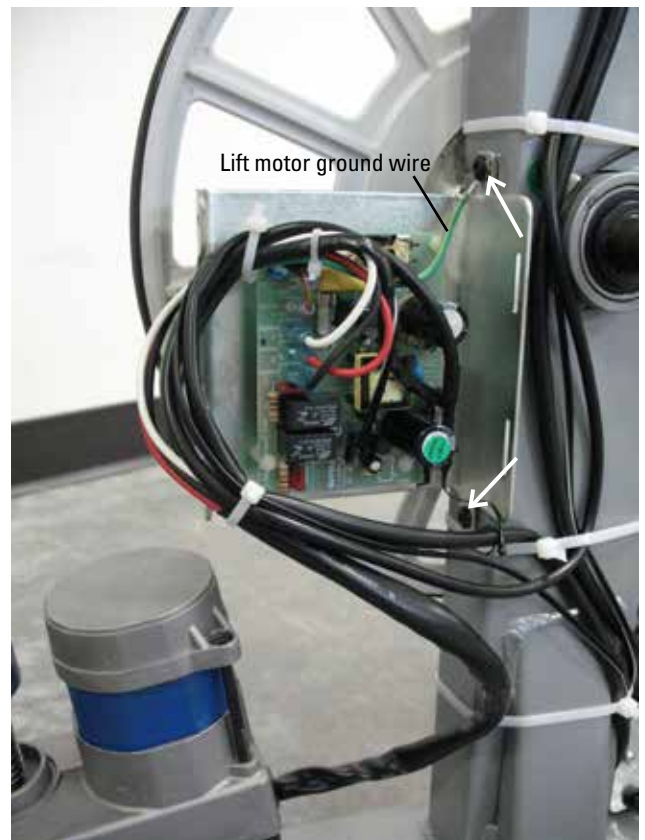
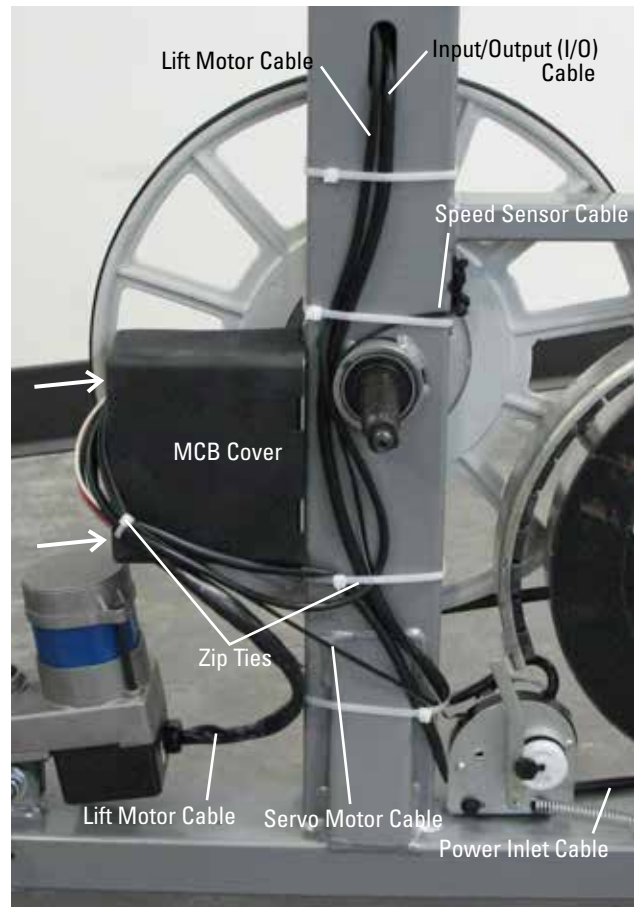
**Note:** Be sure to note where all cables attach for re-assembly.

16. Using a #2 Phillips screwdriver, remove the 2 indicated screws that attach the MCB Assembly to the Frame.

17. Remove the old MCB Assembly, and install the new MCB Assembly. Connect the cables to the MCB in their proper locations.



**Use the upper screw to attach the green Lift Motor ground wire to the Frame. Be sure not to crimp any cables.**



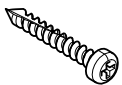


18. Reassembly is the reverse procedure. Secure the cables with zipties.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first.

**NOTICE:** This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

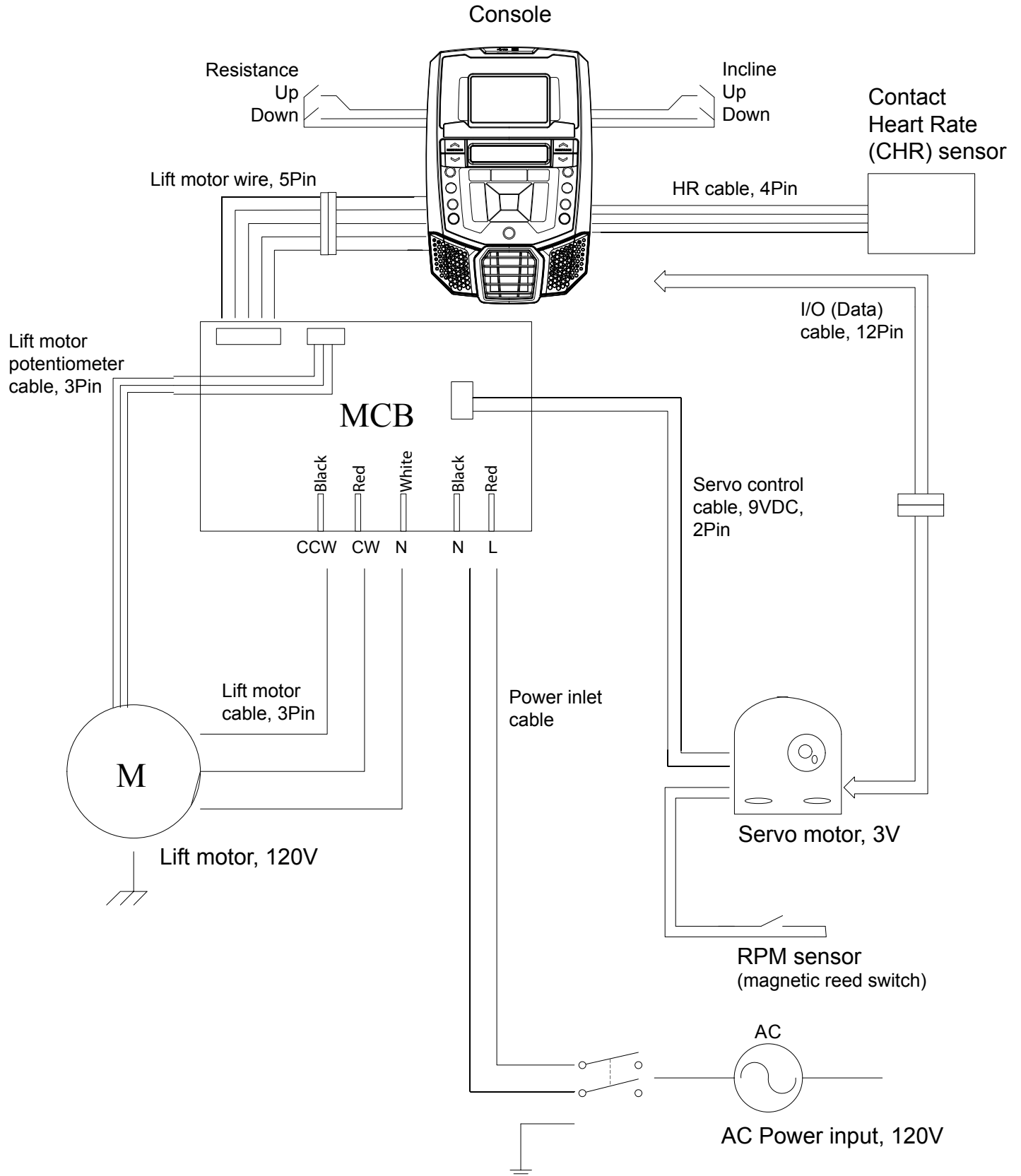
Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

19. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**⚠ Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**Note:** After replacing the MCB Assembly, the resistance levels of the machine may be different. The user should adjust their workout levels accordingly.

# NLS E618 Wiring Diagram



**NOTICE:** This document provides instructions for the replacement of the Pedals and Legs on the Nautilus™ E618 Elliptical fitness machine.

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- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
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### Tools Required (not included)

6mm hex wrench



13mm open end wrench



Small flathead screwdriver



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**Note:** This procedure shows the removal and replacement of the Left Pedal and Leg. To remove the Right Pedal and Leg, adjust the procedure accordingly.



1. Using a 6mm hex wrench and 13mm wrench, remove the indicated hardware from the Pedal.



2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware from the Lower Handlebar Arm and Pedal.

**⚠** Be aware that the Handlebar Arm will be loose and may pivot when the hardware is removed.

**Note:** To assist with reassembly, observe how the Pivot Sleeve engages flush with the Lower Handlebar Arm.



3. Remove the Pedal.

4. Using a 6mm hex wrench, remove the indicated hardware from the Crank Arm and Leg.

5. Remove the old Leg and replace with the new one.

6. Installation is the reverse procedure.

7. Discard the old parts.

8. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**



**NOTICE:** This document provides instructions for the replacement of the Power Switch Assembly on the Nautilus™ E618 Elliptical fitness machine.

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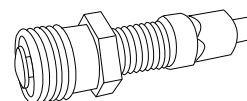
- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
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- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



Crank puller



Flathead screwdriver



13mm open end wrench  
17mm open end wrench



14mm socket and ratchet



6mm hex wrench



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



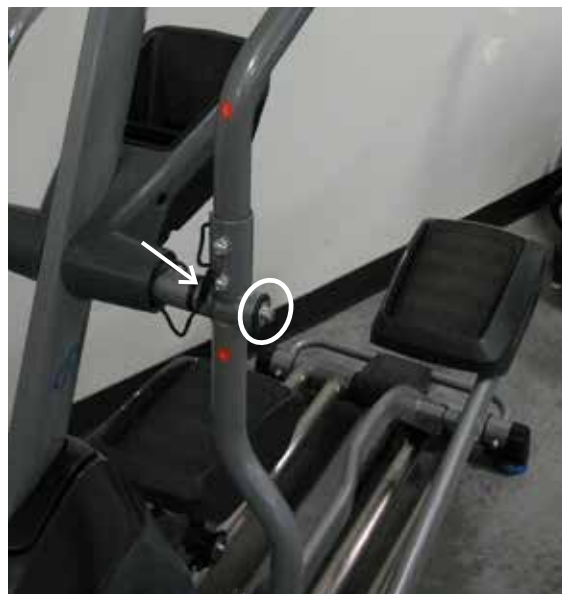
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Crank Arm and Leg, and set it safely aside for reassembly. On each side of the machine, remove the Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



9. Using a small standard screwdriver, gently pry the cap off of the Crank Arm.

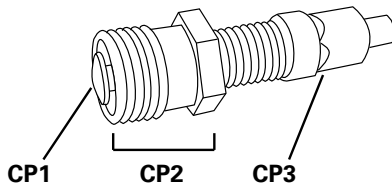


10. Using a 14mm socket and ratchet, remove the Lock Nut from the Crank Arm.



11. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



12. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

13. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

14. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.

15. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.



16. Loosen and remove the two screws (one indicated with an arrow) that attach the back cover of the Power Switch assembly to the sides of the Frame. Remove the back cover.

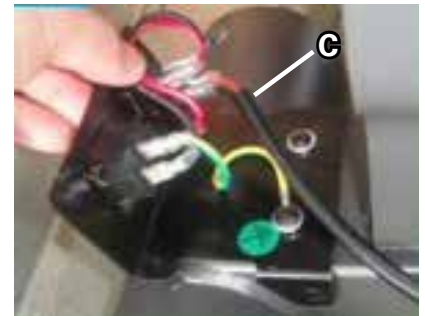
**NOTICE:** Do not crimp the cables.

**Note:** Your machine may not match the image. For reference only.



17. Carefully disconnect the Power Inlet cable (C) from the Power Switch assembly.

18. Loosen and remove the screws (D1, D2) that attach the Power Inlet bracket to the Frame. Remove and discard the old Power Switch assembly.



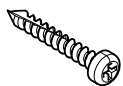
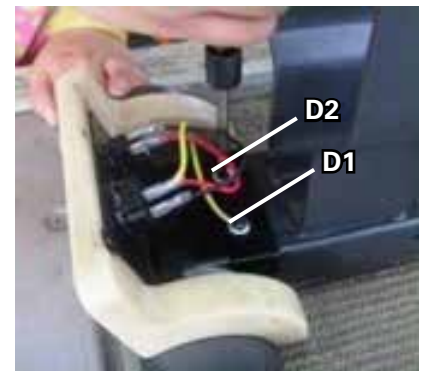
19. Installation is the reverse procedure.

**Note:** Use screw D1 to attach the green ground wire to the bracket and Frame. Be sure not to crimp any cables.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

**NOTICE:** This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

20. Dispose of the old parts.

21. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**!** Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.

**NOTICE:** This document provides instructions for the replacement of the Rail Assembly on the Nautilus™ E618 Elliptical fitness machine.

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- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
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- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
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### Tools Required (not included)

6mm hex wrench



Static solid object (like a book or box)

13mm open end wrench



Small flathead screwdriver



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1. Be sure the Incline Assembly on the Rail Assembly is fully lowered.

**⚠** Do not adjust the incline angle when on the machine.  
Be sure the area below the machine is clear before lowering.

Push the Incline Level Decrease (▼) button to change the incline angle of the rail assembly, or push the 0% Incline Level Quick Button.

**⚠** Disconnect all power and allow to sit for 5 minutes.



2. Carefully lift the Leg and Pedal together to move the Roller off the Rail and set it on the floor to the outside of the Rail Assembly. If you have access to the hardware that attaches the Incline Adjuster to the Rail Assembly, continue to Step 10.

If additional space is required for removal and installation, continue to Step 3.



3. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠ Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.**

**Note:** To assist with reassembly, observe how the Pivot Sleeve engages flush with the Lower Handlebar Arm.



5. Disconnect the Cable from the Upper Handlebar that goes into the Console Mast.

6. Using a 6mm hex wrench and a 13mm wrench, remove the hardware from the Lower Handlebar Arms and the Arm Pivot Rod.

**⚠ Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed.**

7. Remove the Handlebar Arm Assemblies and set them safely aside.



8. Using a 6mm hex wrench, remove the indicated hardware from the Crank Arm and Leg.

9. Remove the Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



10. Place a static object (like a book or box) under the back of the main frame but not under the Rail Assembly. The static object (\*) should not be compressible.

11. Using a 6mm hex wrench and a 13mm wrench, remove the 4 indicated screws that attach the Rail Assembly to the Frame Assembly.

**⚠** Be aware that the Frame Assembly may be unstable and slightly top heavy.

12. Remove the old Rail Assembly and replace with the new one.

**⚠** Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.

*NOTICE:* This step may require two people.

13. Installation is the reverse procedure.

**Note:** Remove the plastic scratch guard strips from the Rails. If necessary, apply silicone lubricant to a cloth and wipe the Rails to eliminate roller noise.

14. Dispose of the old parts.

15. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**⚠** Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.



**NOTICE:** This document provides instructions for the replacement of the Servo Motor on the Nautilus™ E618 Elliptical fitness machine.

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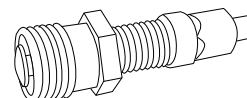
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- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



Crank puller



Flathead screwdriver



Needlenose pliers



3mm hex wrench  
6mm hex wrench



13mm open end wrench  
17mm open end wrench



14mm socket and wrench



2.5" x 10" cardboard and tape  
Utility knife or scissors to cut zipties  
4' (1.2m) length of string  
Zipties



1. With the machine turned on, set the resistance to the highest level.

2. Once the machine has reached the maximum resistance, turn off the machine and remove the power cord.

**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

3. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



5. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.



6. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.

7. Using a 6mm hex wrench, loosen and remove the indicated hardware from the Crank Arm and Leg, and set it safely aside for reassembly. On each side of the machine, remove the Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



8. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Console Mast.

9. Using a 6mm hex wrench, remove the hardware (indicated) from the Console Mast. Slightly pull the Mast up and disconnect the cables. Set the hardware and parts aside for reassembly.

**NOTICE:** Do not crimp the cables. Do not allow the cables to fall down into the Main Unit. This step may require two people.



10. Using a small standard screwdriver, gently pry the cap off of the Crank Arm.

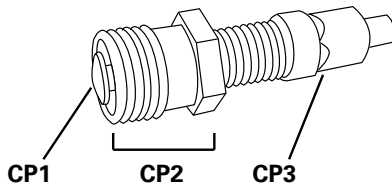


11. Using a 14mm socket and ratchet, remove the Lock Nut from the Crank Arm.



12. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



13. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

14. Using a #2 Phillips screwdriver, remove the 7 indicated screws (\*) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.

15. Bend the edges of the Top Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

16. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws below the Upper Shroud) that secure the Left Shroud. Remove the lower screws first. Slowly remove the Left Shroud.



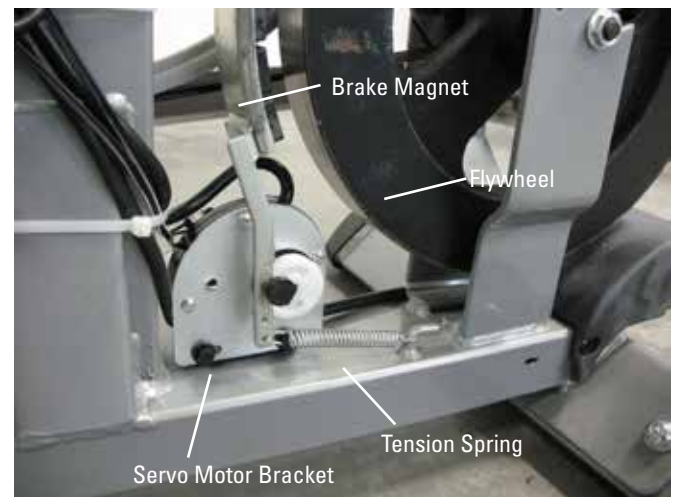
17. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.



18. Measure and mark the position of the Servo Motor Bracket on the Main Frame.

19. Insert 2.5" x 10" cardboard between the Brake Magnet and the Flywheel, and tape the cardboard to the Brake Magnet.

**Note:** Be sure the cardboard covers all of the Brake Magnet.

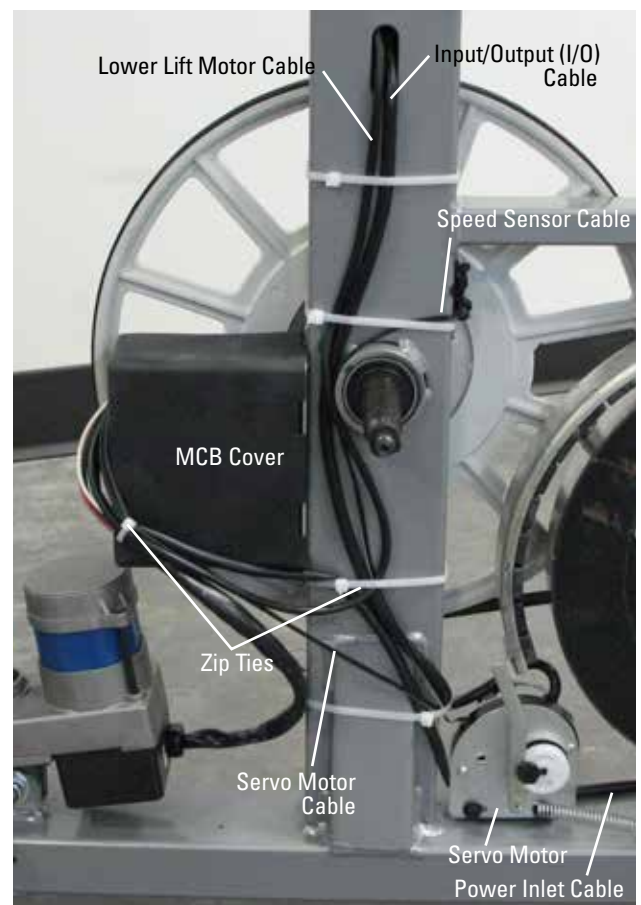


20. Observe the cable routing to the wiring harness on your machine. Disconnect the Speed Sensor Cable and Servo Motor Cable from the wiring harness.

21. Tie the length of string to the end of the Lower Input/Output (I/O) Cable at the top of the Mast mount. Remove the zipties that attach the Lower Input/Output (I/O) Cable to the Frame. Pull the cable and string down through the hole on the side of the Frame so that the string extends through the Frame.

**NOTICE:** Hold the Lower Lift Motor Wire so that you do not pull it out of the Mast. Do not crimp the cables.

22. Untie the string from the Lower Input/Output (I/O) Cable.



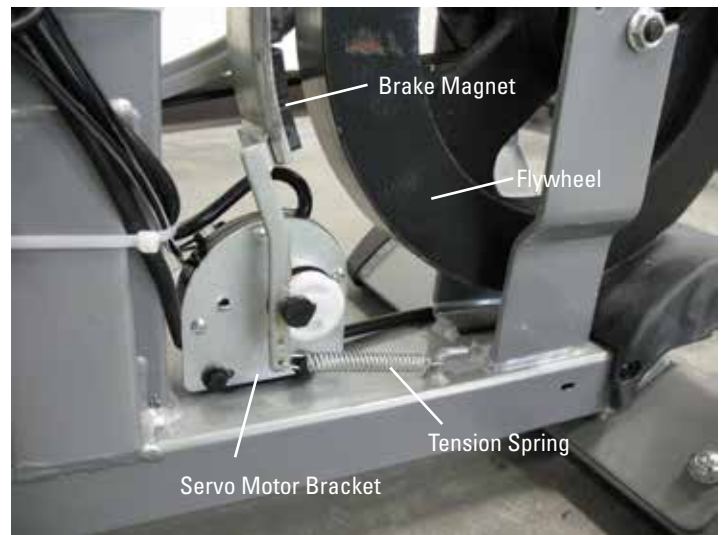
23. Use the pliers to unhook the Tension Spring from the Main Frame. Pull back and release the Brake Arm enough to disengage it from the Motor Pulley Shaft.

24. Loosen and remove the two socket head bolts from the Servo Motor.

25. Remove the Servo Motor and discard it.

26. Install the new Servo Motor and adjust it to previously recorded position.

**NOTICE:** Do not touch the Potentiometer. Do not crimp any cables.



27. Tie the end of the string at the hole in the Mast to the end of the Console Cable on the new Servo Motor. Carefully pull the cable through the hole to the top of the Console Mast mount. Untie the string and discard it.

**NOTICE:** Do not crimp the cables.

28. Reinstall the Console Mast with the Upper Shroud. Turn the power on.

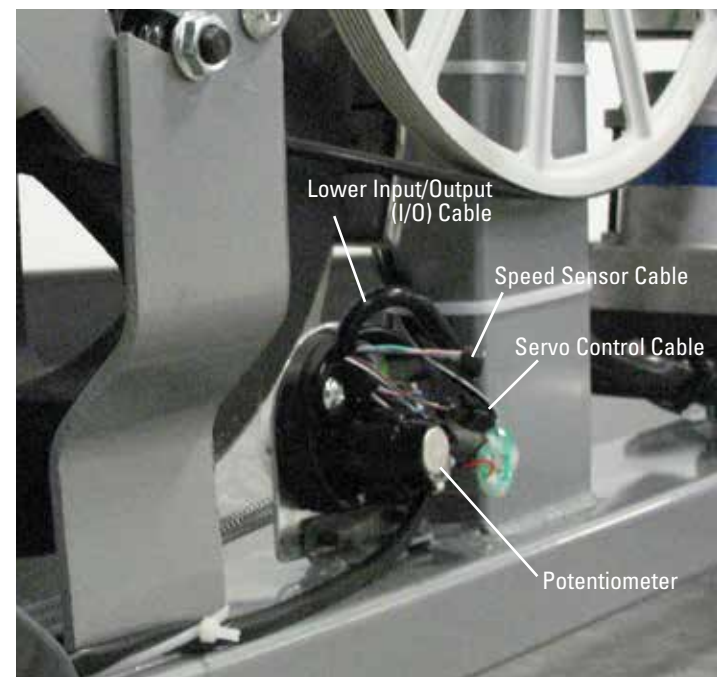


**Machine is on. Current is active. There is risk of electrical shock.**

29. Use the console to set the resistance to the highest level. Unplug the machine.

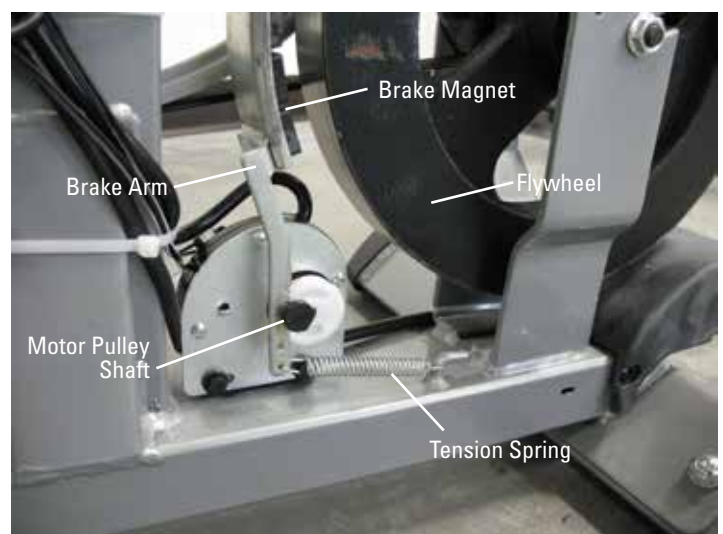


**Disconnect all power and allow to sit for 5 minutes.**



30. Put the Brake Arm back in position and connect the Tension Spring with the needlenose pliers.

**Note:** Before fully attaching the Shrouds, remove the cardboard from between the Brake Magnet and the Flywheel. Power up the machine to verify that the Magnet Arm can move freely, and that the Brake Magnet and Flywheel do not touch at the maximum resistance level. If necessary, refer to the “Set the Brake Tension” procedure.



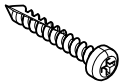
31. Installation is the reverse procedure.

**Note:** Be sure the number of threads showing on the Lift Motor shaft between the Collar Nut and the Lift Motor base is the same as the number recorded in Step 16. If the number is different, turn the collar nut until the thread count is the same.

Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

*NOTICE:* This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

32. Dispose of the old parts.

33. Inspect your machine to ensure that all hardware is tight and components are properly assembled.



**Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Shrouds on the Nautilus™ E618 Elliptical fitness machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

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### Important Safety Instructions - Before servicing or using this equipment, obey the following warnings:

**⚠ This icon means a potentially hazardous situation which, if not avoided, could result in death or serious injury. Read and understand all Warnings on this machine.**

**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



14mm socket and wrench



Small flathead screwdriver



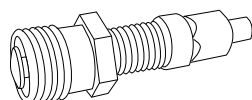
#2 Phillips screwdriver



13mm open end wrench



Crank puller



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



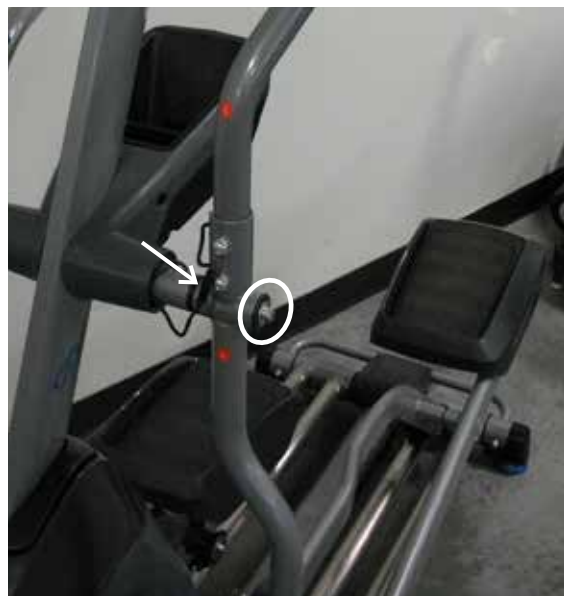
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex key, loosen and remove the indicated hardware from the Crank Arm and Leg, and set it safely aside for reassembly. On each side of the machine, remove the Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Top Shroud up the Mast.

If you are not replacing the Upper Shroud—go to Step 9.

7. Remove the hardware (indicated) from the Mast. Gently pull the Mast out and disconnect the cables. Set the hardware, Mast and Top Shroud safely aside.

**NOTICE:** Do not crimp the cables. This step may require two people.



8. Using a small standard screwdriver, gently pry the cap off of the Crank Arm.

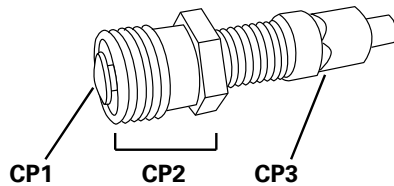


9. Using a 14mm socket and ratchet, remove the Lock Nut from the Crank Arm.



10. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



11. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

12. Bend the edges of the Top Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

13. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.



14. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.

If you are not replacing the Motorized Lift Cover—go to Step 18.

If you are replacing the Motorized Lift Cover — remove the indicated hardware (by oval) that attaches the Incline Adjuster Assembly to the Rail Assembly, using a 6mm hex wrench and a 13mm wrench.



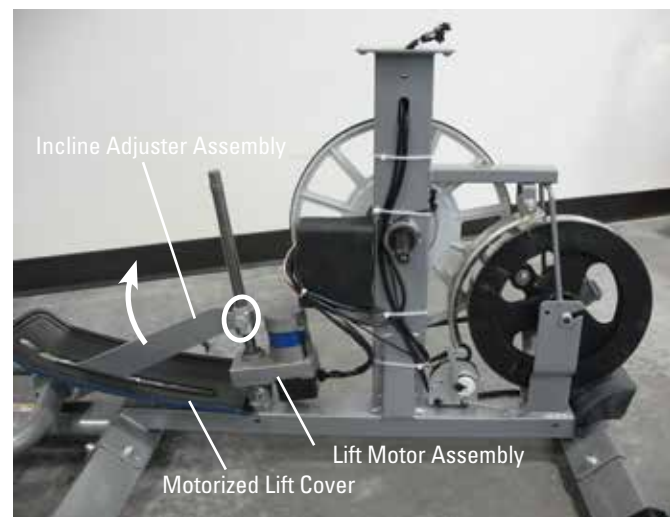
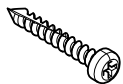
15. Using the 18mm open end wrench, loosen the indicated bolts that attach the Incline Adjuster bracket to the Lift Motor Assembly to allow the Incline Adjuster Assembly to pivot.

16. Tilt the end of the Incline Adjuster Assembly up, and remove the Motorized Lift Cover from the Incline Adjuster Assembly.

17. Installation is the reverse procedure. Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

**NOTICE:** This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

18. Dispose of the old parts.

19. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**⚠ Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**

**NOTICE:** This document provides instructions for the replacement of the Speed Sensor on the Nautilus™ E618 Elliptical fitness machine.

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**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



6mm hex wrench



10mm open end wrench  
13mm open end wrench



**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



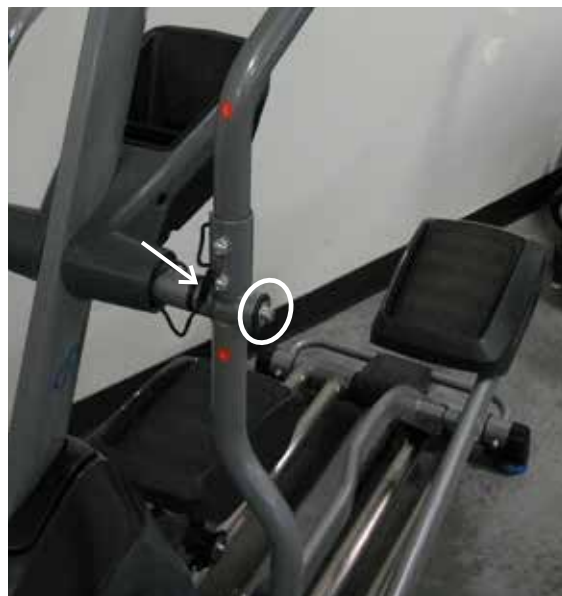
2. Using a 6mm hex wrench and a 13mm wrench, remove the indicated bolts from the Lower Handlebar Arms and Pedals. Set the hardware safely aside for reassembly.

**⚠** Be aware that the Handlebar Arms will be loose and may pivot when the hardware is removed. This step may require two people.



3. Disconnect the indicated Cable (with arrow) from the Upper Handlebar that goes into the Console Mast.

4. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware (by oval) from the Arm Pivot Rod. Remove the hardware and the Upper and Lower Handlebar Arms. Set them safely aside for reassembly.



5. Using a 6mm hex wrench, loosen and remove the indicated hardware from the Left Crank Arm and Leg, and set it safely aside for reassembly. Remove the left Leg and Pedal together from the Rail Assembly and set them safely aside for reassembly.

**NOTICE:** This step may require two people.



6. Using a small standard screwdriver, gently pry the cap off of the Left Crank Arm.

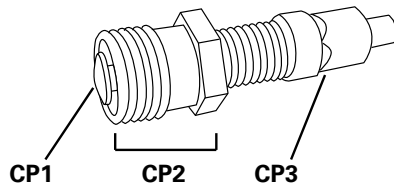


7. Using a 14mm socket and ratchet, remove the Lock Nut from the Left Crank Arm.



8. Thread the Crank Puller into the Crank Arm. When the Crank Puller is in the correct position, only 1-2 threads on the outer portion (CP2) of the Crank Puller should show.

**Note:** Be sure the end of the Bolt (CP1) of the Crank Puller is flush with the Nut (CP2) as shown, before use.



9. Using a wrench, turn the inner portion (CP3) of the Crank Puller clockwise. The Crank Arm will slide off as it is tightened.

**Note:** Be advised that it may take a lot of force to get the Crank Puller to start to slide off the Crank Arm.

10. Bend the edges of the Upper Shroud to disengage the inside tabs from the Main Assembly, and slide the Shroud Cap and Upper Shroud up the Mast.

11. Using a #2 Phillips screwdriver, remove the 7 indicated screws (arrows indicate screws under the Upper Shroud) from the Left Shroud and remove them. Remove the bottom screws first, and then the top screws. Slowly remove the Left Shroud.

**NOTICE:** Be sure not to crimp any cables.

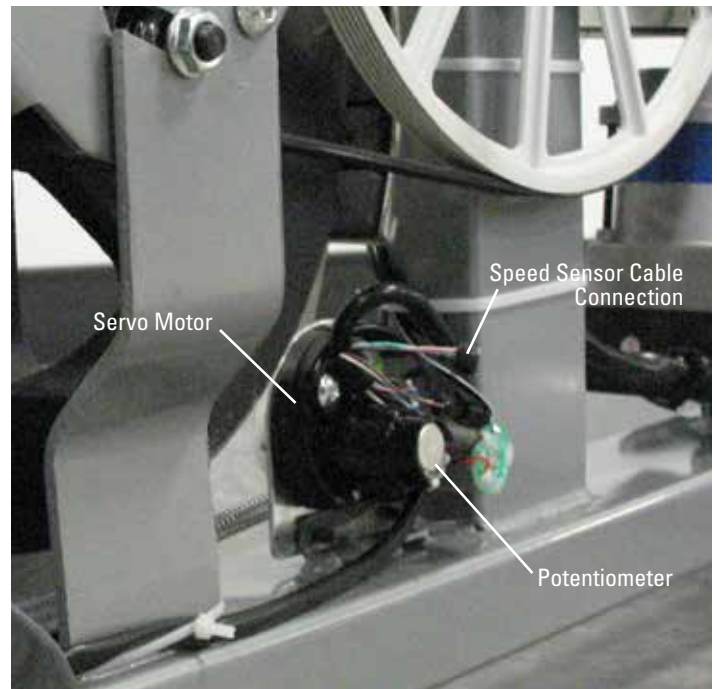


12. Using a #2 Phillips screwdriver, remove the 3 indicated screws (with arrows) that secure the Right Shroud. Remove the bottom screws first, and then the top screw. Slowly remove the Right Shroud.



13. Disconnect the Speed Sensor Cable from the Servo Motor wiring harness.

**NOTICE:** Do not touch the Potentiometer. Do not crimp any cables.



14. Observe the cable routing from the Speed Sensor Magnet to the Servo Motor wiring harness.

15. Remove the zip ties that attach the Speed Sensor Cable to the Frame.

**NOTICE:** Do not crimp the cables.

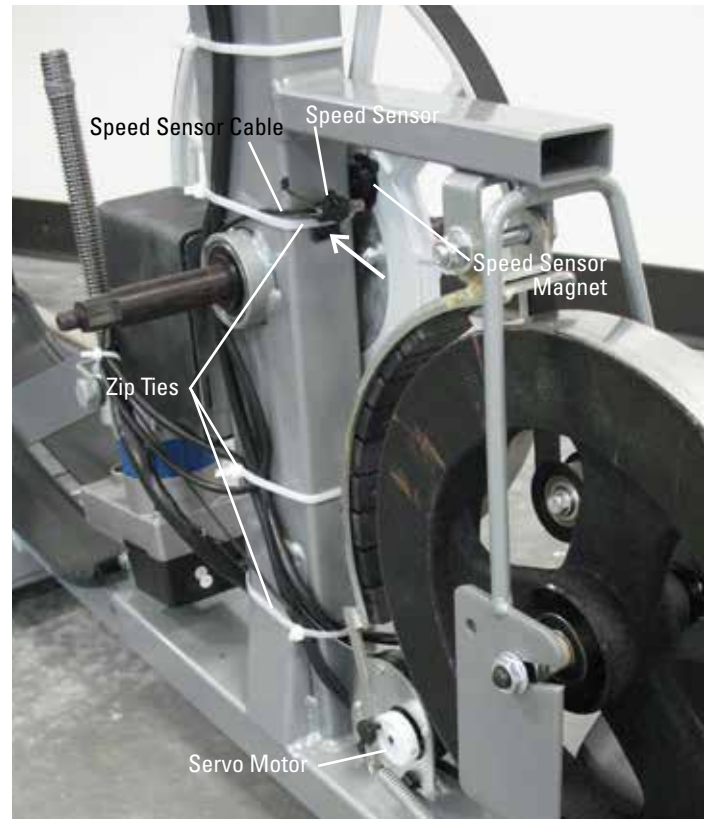
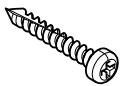
16. Using a #2 Phillips screwdriver, remove the indicated screw (by arrow) from the Speed Sensor Magnet.

17. Installation is the reverse procedure.

**Note:** Put the Left Shroud in position first to align the screws for the Right Shroud. Install the top screws first. Be sure the tabs in the Motorized Lift Cover snap into the Side Shrouds.

**NOTICE:** This step may require two people. Be sure not to crimp any cables.

**Note:** Self-tapping screws attach the Shrouds to the Frame.



Installation does not require the use of the crank puller. Be sure the Crank Arms are connected at 180° from each other.

18. Dispose of the old parts.

19. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**!** Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.

**NOTICE:** This document provides instructions for the replacement of the Static Handlebar Assembly on the Nautilus™ E618 Elliptical fitness machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

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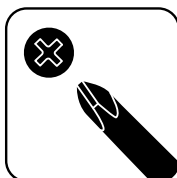
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**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
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- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

#2 Phillips screwdriver



6mm hex wrench





To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and the machine and wait 5 minutes before cleaning, maintaining or repairing the machine. Place the power cord in a secure location.

1. To remove the Console Junction Cover, pinch the sides to release the side snaps, and then pivot it forward and off of the machine.



2. Using a 6mm hex wrench, remove the indicated hardware from the Console Mast.



3. Gently lift and remove the Console/Static Handlebar Assembly from the Console Mast and disconnect the four cables (the Input/Output, Lift Motor, Resistance Control, and Incline Control Cables) that come from the back of the Console.

**Note:** Do not let the Cables fall down inside the Console Mast. If necessary, use a rubber band or wire tie to secure them. This step may require two people.



4. Using a #2 Phillips screwdriver, remove the four indicated screws from the Console and remove the Static Handlebar.

**Note:** Be sure to observe how the cables route through the Static Handlebar from the Console before removing it to assist with re-assembly. Do not crimp the cables.

5. Installation is the reverse procedure.

**NOTICE:** Do not crimp the cables.

6. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

 **Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**



**NOTICE:** This document provides instructions for the replacement of the Upper and Lower Handlebar Arms on the Nautilus™ E618 Elliptical fitness machine.

If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)

**!** This icon means a potentially hazardous situation which, if not avoided, could result in death or serious injury. Read and understand all Warnings on this machine.

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### Important Safety Instructions - Before servicing or using this equipment, obey the following warnings:

**!** This icon means a potentially hazardous situation which, if not avoided, could result in death or serious injury. Read and understand all Warnings on this machine.

**⚠ DANGER** To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

- Read and understand the Part Replacement Procedure before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.
- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine Nautilus replacement parts and hardware. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not use the machine until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex wrench



#2 Phillips screwdriver



Small flathead screwdriver



13mm open end wrench



**⚠ DANGER**

To reduce the risk of electrical shock or unsupervised usage of the equipment, always unplug the power cord from the wall outlet and wait 5 minutes before cleaning, maintaining or repairing this machine. Place the power cord in a secure location.

1. Using a #2 Phillips screwdriver, remove the 4 screws from each set (right and left) of the Handlebar Shrouds. After removing the hardware, pinch the Handlebar Shrouds to unsnap them from each other. Place them safely aside.



**Note:** This procedure shows the removal and replacement of the Left Upper and Lower Handlebar Arm. To remove the Right Handlebar, adjust the procedure accordingly.

2. Disconnect the Cable from the Upper Handlebar that goes into the Console Mast.



3. Using a 6mm hex wrench, remove the 4 screws (two indicated, two on other side of Handlebar) from the Upper Handlebar Arms.

4. Remove the Upper Handlebar Arm and set them safely aside.



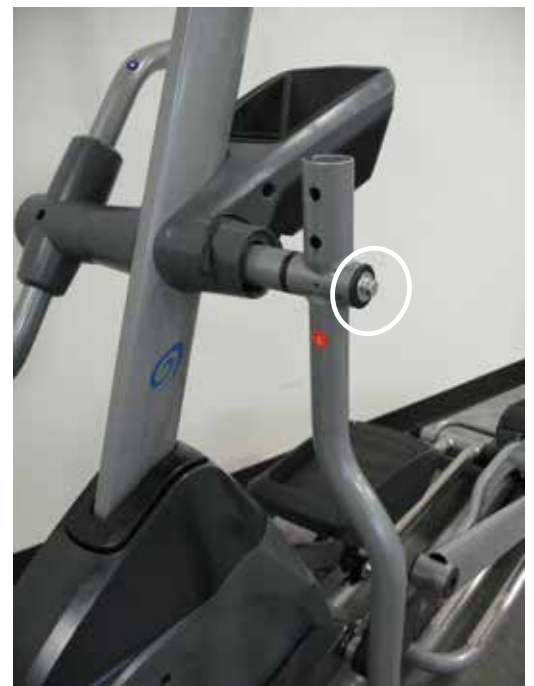
5. Using a 6mm hex wrench and a 13mm wrench, remove the indicated hardware from the Lower Handlebar Arms and Pedal.

**Note:** To assist with reassembly, observe how the Pivot Sleeve engages flush with the Lower Handlebar Arm.



6. Using a 6mm hex wrench and a 13mm wrench, remove the hardware from the Lower Handlebar Arm and the Arm Pivot Rod. The hardware on both ends of the Arm Pivot Rod will need to be held to remove it.

7. Remove the old Lower Handlebar Arm and replace with the new one.



8. Installation is the reverse procedure.

**!** Make sure the Upper Handlebar Arms are secure before you exercise.

9. Discard the old parts.

10. Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**!** Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.

**NOTICE:** This document provides instructions for the replacement of the Transport Wheels, Front Endcaps and Footpads on the Nautilus™ U618 Upright Bike, R618 Recumbent Bike, and E618 Elliptical Fitness Machine.

**If you need assistance, please contact Customer Service (if purchased in US/Canada) or your local distributor (if purchased outside US/Canada). To find your local distributor, go to: [www.nautilusinternational.com](http://www.nautilusinternational.com)**

**⚠ This icon means a potentially hazardous situation which, if not avoided, could result in death or serious injury. Read and understand all Warnings on this machine.**

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### Important Safety Instructions - Before servicing or using this equipment, obey the following warnings:

**⚠ Read and understand the Service Manual before working on the machine. Failure to obey the instructions and safety warnings could cause injury to the service technician or bystanders.**

**Disconnect all power to the machine before you service it.**

- Keep bystanders and children away from the product being serviced at all times.
- Make sure that the repair is done in an appropriate work space away from foot traffic and exposure to bystanders.
- Some components of the equipment can be heavy or awkward. Enlist the service of a second person when you do maintenance steps involving these components. Do not try to do heavy or awkward steps on your own.
- If replacement parts are necessary, use only genuine replacement parts and hardware supplied by Nautilus. Failure to use genuine replacement parts can cause a risk to users, keep the machine from operating correctly and void the warranty.
- Be sure that all warning stickers and instructional placards applied to the product stay present and in good condition when doing maintenance or replacing components. If at any time the Warning labels become loose, unreadable or dislodged, replace the labels. If purchased in US/Canada, contact Customer Service for replacement labels. If purchased outside US/Canada, contact your local distributor for them.
- Do not try to change the design or functionality of the machine being serviced as this can adversely affect user safety.
- Do not put the machine back in service until all shrouds, instructions, warning labels and correct functionality have been verified and tested for correct performance.

### Tools Required (not included)

6mm hex key



Static solid object (like a book or box)

#2 Phillips screwdriver (short)



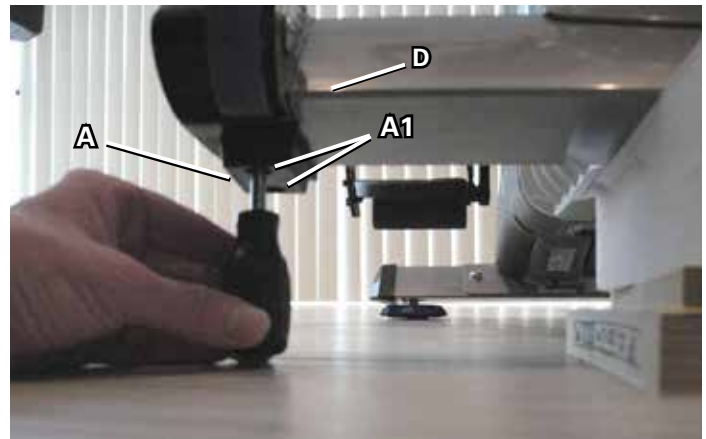
13mm open end wrench



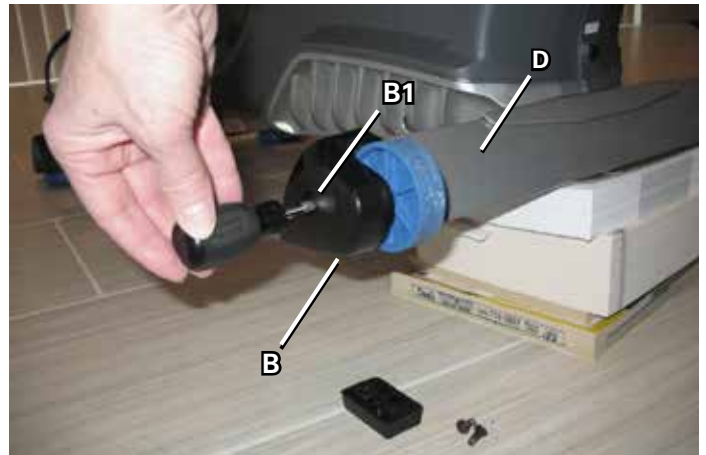
**Note:** Your machine may not match the image. For reference only.

1. Place a static object (like a book or box) under the front stabilizer (C). The static object should not be compressible.

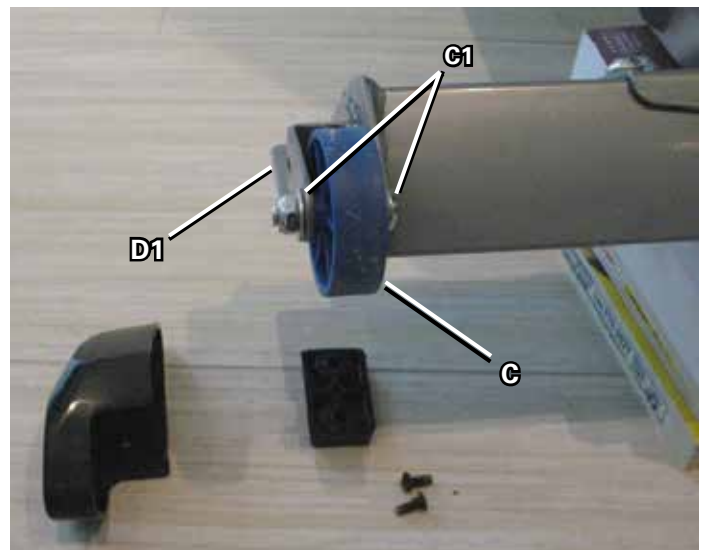
2. Using a short #2 Phillips screwdriver, loosen and remove the screws (A1) from the Footpad (A), and set them safely aside. Remove the Footpad from the front stabilizer (D). Set the Footpad and screws safely aside.



3. Loosen and remove the screw (B1) from the Endcap assembly (B) and set it safely aside. Remove the Endcap from the front stabilizer (D). Set the Endcap and screw safely aside.



4. Using the 6mm hex key and 13mm wrench, loosen and remove the hardware (C1) from the old Transport Wheel assembly (C). Remove the old Transport Wheel from the front stabilizer bracket (D1). Set the Transport Wheel and hardware safely aside.



5. Installation is the reverse procedure.

*NOTICE:* Before fully attaching the Endcap, be sure that the Transport Wheel can turn freely.

6. Dispose of the old parts.

## 7. Final Inspection

Inspect your machine to ensure that all hardware is tight and components are properly assembled.

**⚠ Do not use until the machine has been fully assembled and inspected for correct performance in accordance with the Owner's Manual.**