Replacing Chair Control and Column on all Concentrx® Chairs

These directions apply to the following Models:

Manager Chair:  Operator Stool:

454-111   454-120
454-111M  454-120M
454-131   454-122
454-131M  454-122M
454-117   454-160
454-117M  454-160M
454-137   454-162
454-137M  454-162M

1. Please read these directions completely through prior to replacing the chair control & column.

2. For replacement of the Twist-O-Matic assembly refer to Assembly Directions #939501013.

3. For replacement of the Pneumatic assembly refer to Assembly Direction #939501474.
1. Place chair on work bench in an inverted position. Remove retainer ring from center column and retain. Lift chair base off center column.

2. Remove (6) #8 screws and outer back shell from upholstered back.
3. Remove (7) #8 screws and outer back shell from upholstered seat. Remove (2) #10 screws and plastic cowl from chair iron and column assembly.

4. Remove (4) bolts and (4) hex nuts, (2) spacers and upholstered back upright from rear of chair control assembly (some models do not have spacers or nuts).
5. Remove (4) 1/4-20 bolts and chair control assembly from the upholstered seat assembly.

6. Make sure the new chair control assembly has color coordinated plastic parts matching those of the discarded chair control assembly.
7. Position the chair control assembly onto the upholstered seat assembly. Install the (2) shorter 1/4-20 bolts at the front of the chair control and leave loose. Push the rear of both side stretchers towards the rear pivot bearings to eliminate any clearance. With stretchers in this position secure to seat with (2) longer 1/4-20 screws. **IMPORTANT: Torque all (4) bolts to 50/60 in./lbs.**

8. FOR PNEUMATIC CHAIR CONTROLS ONLY
Activate the control button and note if contact is being made with the center button on the pneumatic cylinder through the control button push rod, which can be seen by looking through the cutout in the locking bracket located at the rear of the chair control. If the control button has any movement in excess of 1/16" before contact is made with the center button on pneumatic cylinder, the following adjustments are to be made:

A. Remove chair control from upholstered seat assembly. Refer back to Step 5.

B. Position chair control as shown below. Before making any adjustments push the rear of both side stretchers towards rear of pivot bearings as shown in Step 7.

C. Rotate set screw clockwise, using allen wrench until set screw contacts the center button.

D. Check movement of control button. If the control button moves from 0" to 1/16" before contact is made with center button on the pneumatic cylinder, the adjustment is correct.

E. Perform Step 7 and reassemble chair control onto upholstered seat. Proceed to Step 9.
9. Reassemble upholstered back upright (reversing Step 4) onto chair control using hardware that comes assembled to the control (either self-tapping screws or nuts, bolts and spacers). Torque bolts or screws to 72/80 in./lbs.

**NOTE:** At this time chair control irons with pneumatic cylinders must be temporarily placed onto the chair base.

Tilt upholstered back upright backward as far as it will tilt. This will test the pneumatic cylinder for proper adjustment. If the pneumatic cylinder activates by tilting action you must disassemble chair and readjust set screw (refer to Step 8 and back off slightly). Remove chair control from chair base.

10. Reverse Step 3 to reassemble plastic cowl and outer seat shell onto chair seat. When locating the outer seat shell onto chair seat there must be adequate clearance for the actuation of both the back lock button and the pneumatic button (if required).

11. Reverse Step 2 to reassemble outer back shell onto chair back.

12. Reverse Step 1 to reassemble chair base onto center column of chair.

**NOTE:** It is essential that lubricant be evident all around the outside surface of chair control column. If no lubricant is evident apply as noted above, using either Amoco Food Machinery Grease or Brush Lube.

13. Place chair on floor, stand on base and pull up on seat assembly to make certain the center column assemblies (Twist-O-Matic or Pneumatic) are properly positioned and secured. Check for swivel action, back adjustment and seat height adjustment.