

# 631-001 Machine Control PCB Kit [002-1748-08]

*Applies to Models:*  
631 (-001)

*Special Tools:*  
none



## **WARNING**

Always disconnect chair from power source before removing any covers. Failure to do so may result in personal injury.

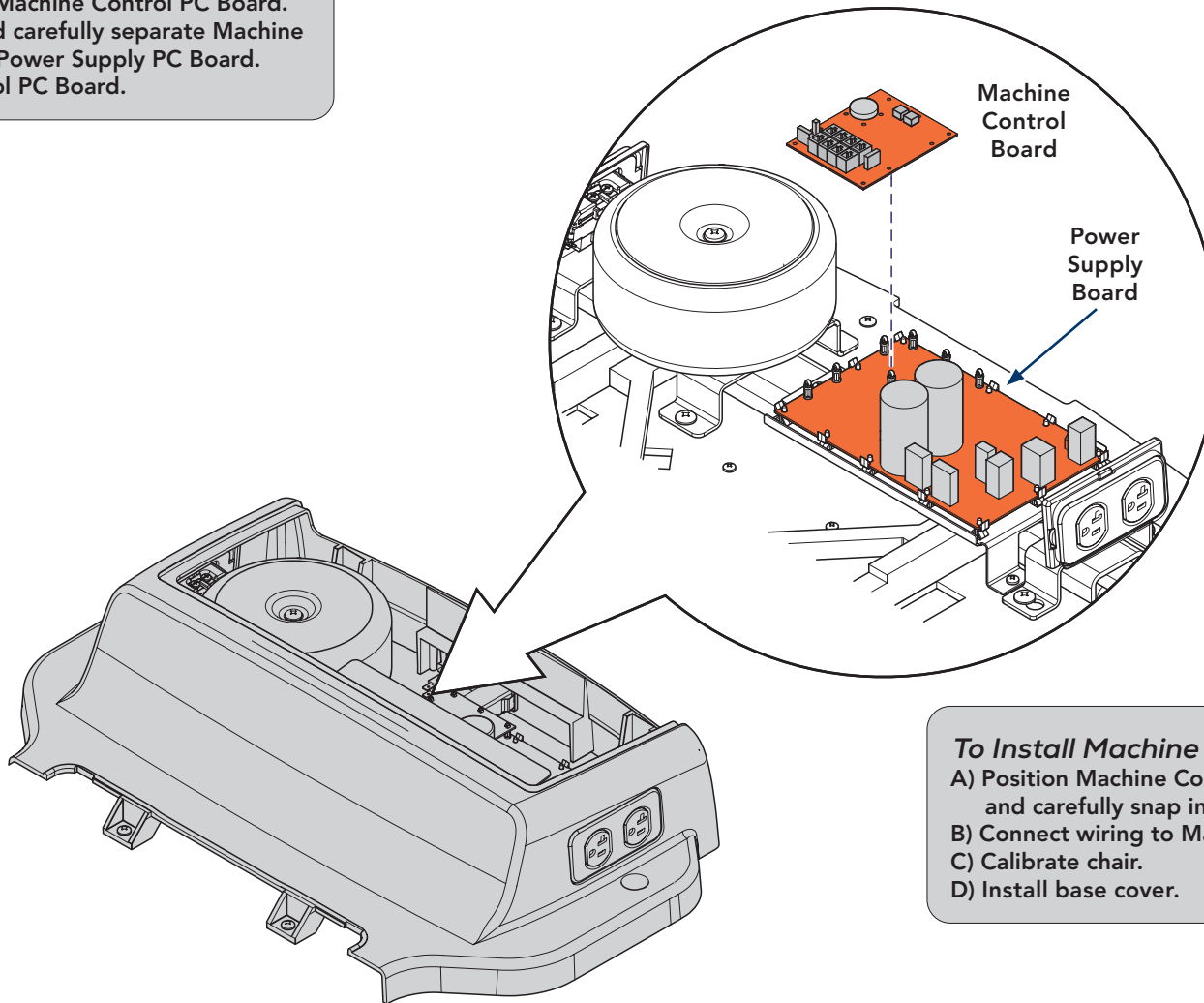
### *To Remove Machine Control PC Board...*

- Remove base cover.
- Disconnect wiring from Machine Control PC Board.
- Disengage standoffs and carefully separate Machine Control PC Board from Power Supply PC Board.
- Remove Machine Control PC Board.



### **Equipment Alert**

Anytime the PC Board is removed or the actuator wires are disconnected, the chair must be calibrated.



### *To Install Machine Control PC Board...*

- Position Machine Control PC Board, and carefully snap into place.
- Connect wiring to Machine Control PC Board.
- Calibrate chair.
- Install base cover.



## Base Cover

### Base Cover Removal / Installation

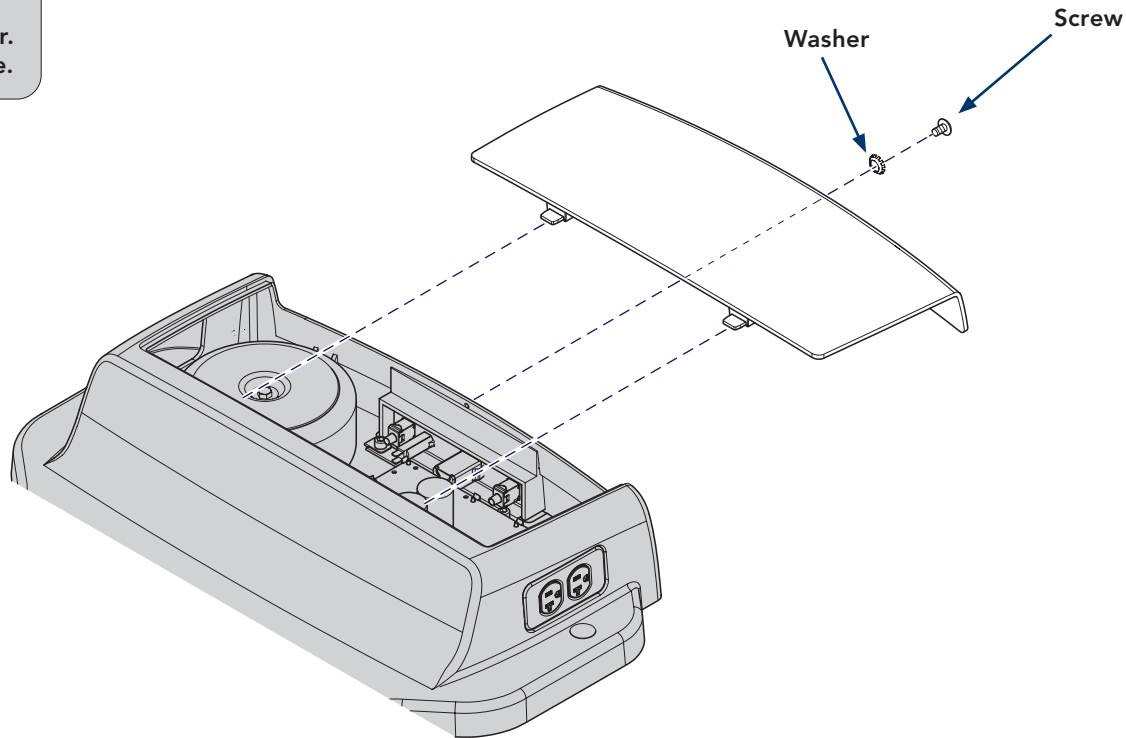


#### **WARNING**

Always disconnect chair from power source before removing any covers. Failure to do so may result in personal injury.

#### **Removal...**

- A) Remove one screw and lock washer.
- B) Slide cover back and lift off of base.



#### **Installation...**

- A) Align tabs and position cover on base.
- B) Secure with one screw and lock washer.

## Calibration Procedure

During the calibration procedure you will hear a steady pattern of “beeps” .  
The chair will run all functions (base, back, tilt, foot) to their minimum and maximum positions,  
then return to a lowered flat position.  
When calibration is complete, the chair will stop moving and you will hear three short “beeps”.

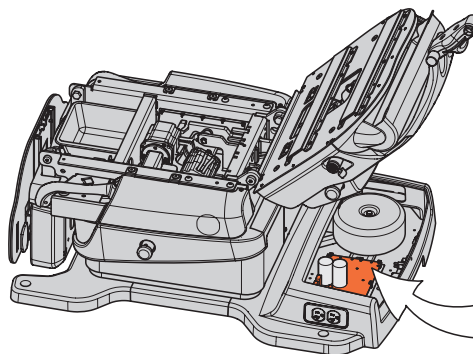
You must calibrate the chair in the following situations:

- After replacing Power Supply PC Board.
- After replacing Motor Control Hub PC Board.
- After replacing Machine Control Board.
- After replacing Base, Back, Tilt or Foot actuators.
- After a limit switch bracket is adjusted.
- When an error code indicates calibration is needed.



### Equipment Alert

Anytime the PC Board is removed or the actuator wires are disconnected, the chair must be calibrated.



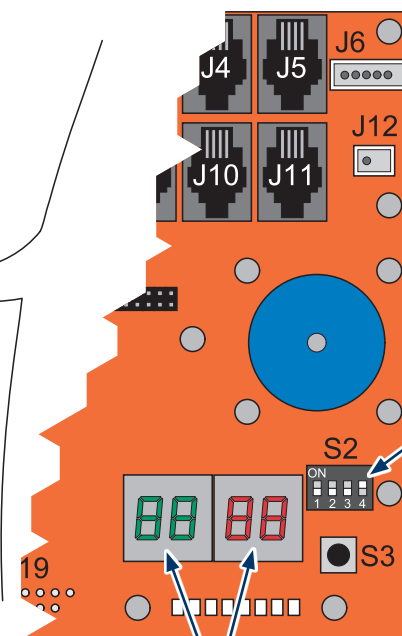
Machine  
Control  
Board

### Note

When S3 switch is pressed, then released you will hear a steady pattern of “beeps”. When calibration is completed you will hear three short beeps.

### To Calibrate...

- Slide foot section to highest stowed position.
- Unplug chair power cord.
- When the digital display darkens, move S2 switch number four to ON (up).
- Plug in chair power cord.
- When the digital display darkens, press and release S3 switch.
- When calibration is complete, unplug chair power cord.
- Move S2 switch number four to OFF (down).
- When the digital display darkens, plug in chair power cord.



Switch  
Number  
Four

Digital  
Display