

# Base Actuator [002-1728-0x]

## Applies to Models:

630 (-010 thru -013)  
630 (-020 thru -023)

## Special Tools:

Bungee Cord  
Scissors Lockout Bracket (provided)

Language of origin: English



### WARNING

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

### Step 1:

- Remove bottom shroud screws.
- Stretch a bungee cord (under seat) across top of base column.
- Lift shrouds, then attach bungee cord hooks under shrouds on both sides.

Note: It may be necessary to run the Tilt Up function to route bungee cord under seat section.



Replace Base Actuator  
V2200 thru V1460921



Replace Base Actuator  
V1460922 thru Present



### WARNING

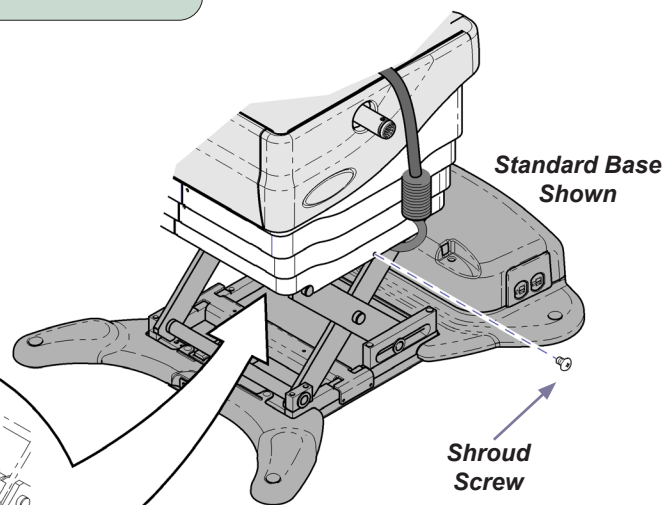
Ensure scissors lockout bracket is securely in place. Failure to do so may result in personal injury.

### Step 2:

- Raise base high enough to insert scissors lockout bracket between center rungs of scissors assembly.
- Lower base enough to secure lockout bracket in place.
- Disconnect chair from power source.

Note: The scissors lockout bracket may be placed in the front or the back of scissors assembly.

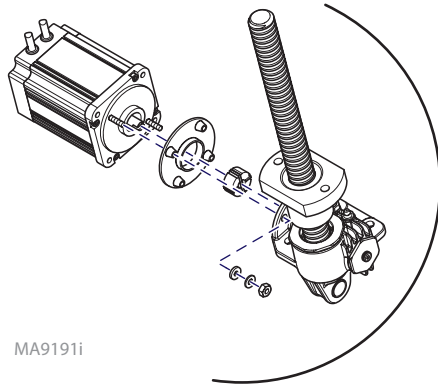
Scissors Lockout  
Bracket  
(included in kit)



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## Note

If replacing only the actuator / coupler, refer to the illustration below.  
If replacing complete actuator assembly, go directly to Step 3.

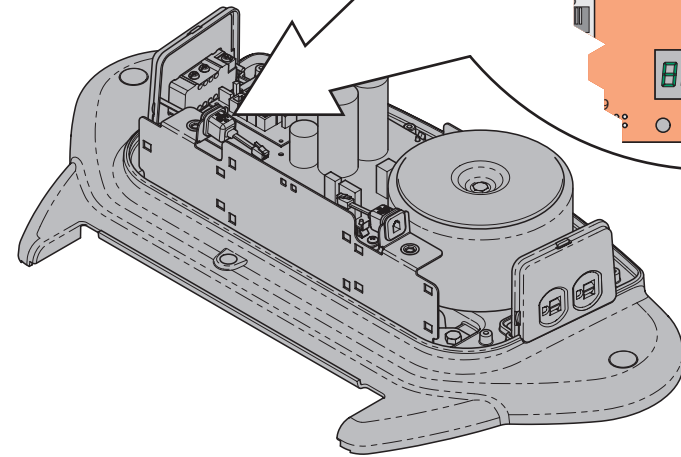
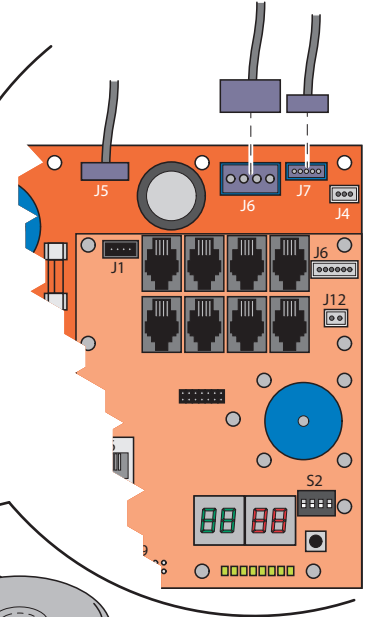


## Equipment Alert

The wire connections and wire routing must be put back in original locations before installing covers.

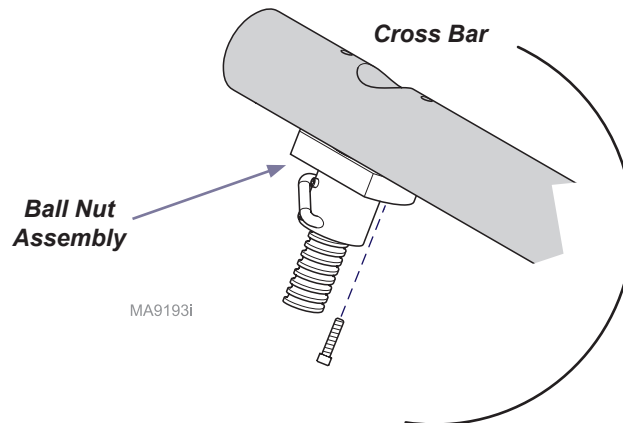
## Step 3:

- A) Remove base cover.
- B) Disconnect wire connections J6 and J7 from Power Supply PC Board.



## Step 4:

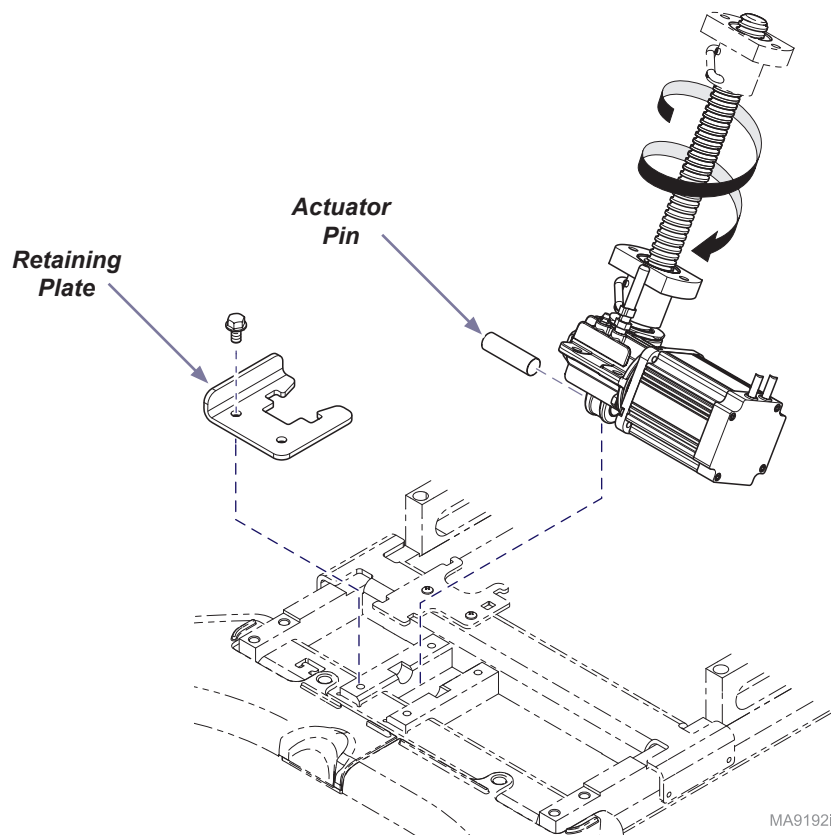
- A) Remove two mounting screws securing the ball nut assembly to cross bar.



## Serial Numbers: V2200 thru V1460921

### Step 5:

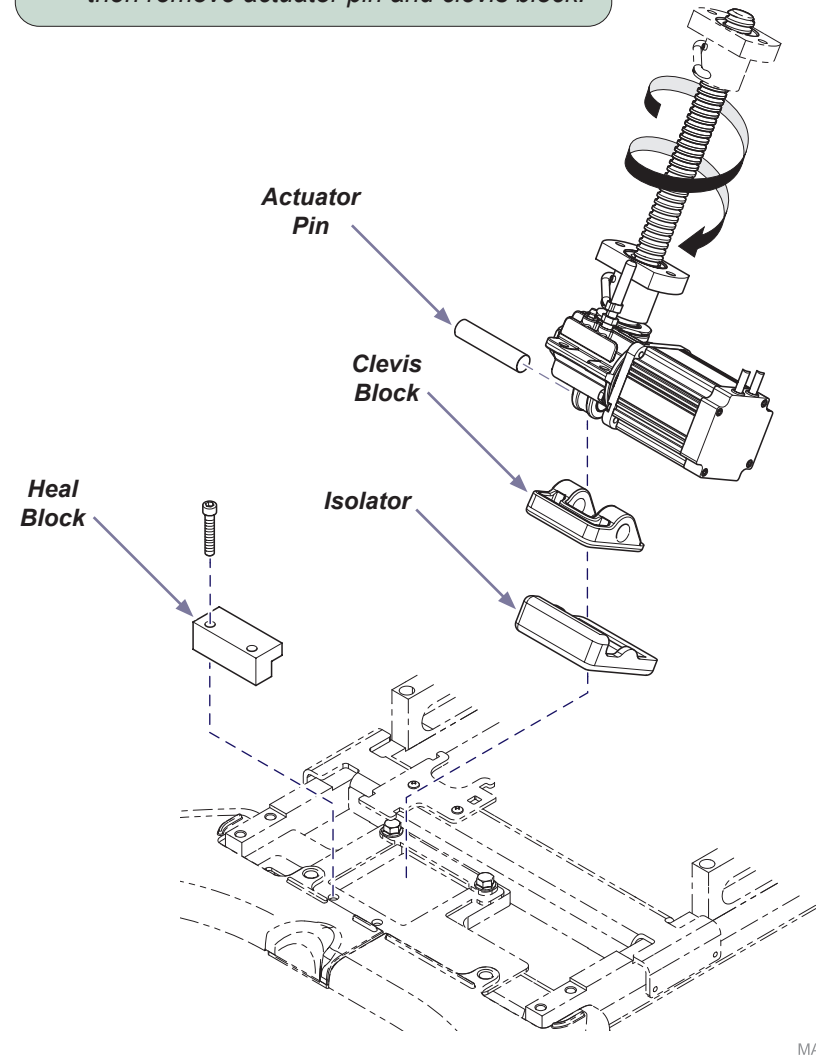
- A) Manually rotate the ball nut assembly to the bottom of the actuator shaft.
- B) Remove two screws, retaining plate and actuator pin.
- C) Remove base actuator.



## Serial Numbers: V1460922 thru Present

### Step 5:

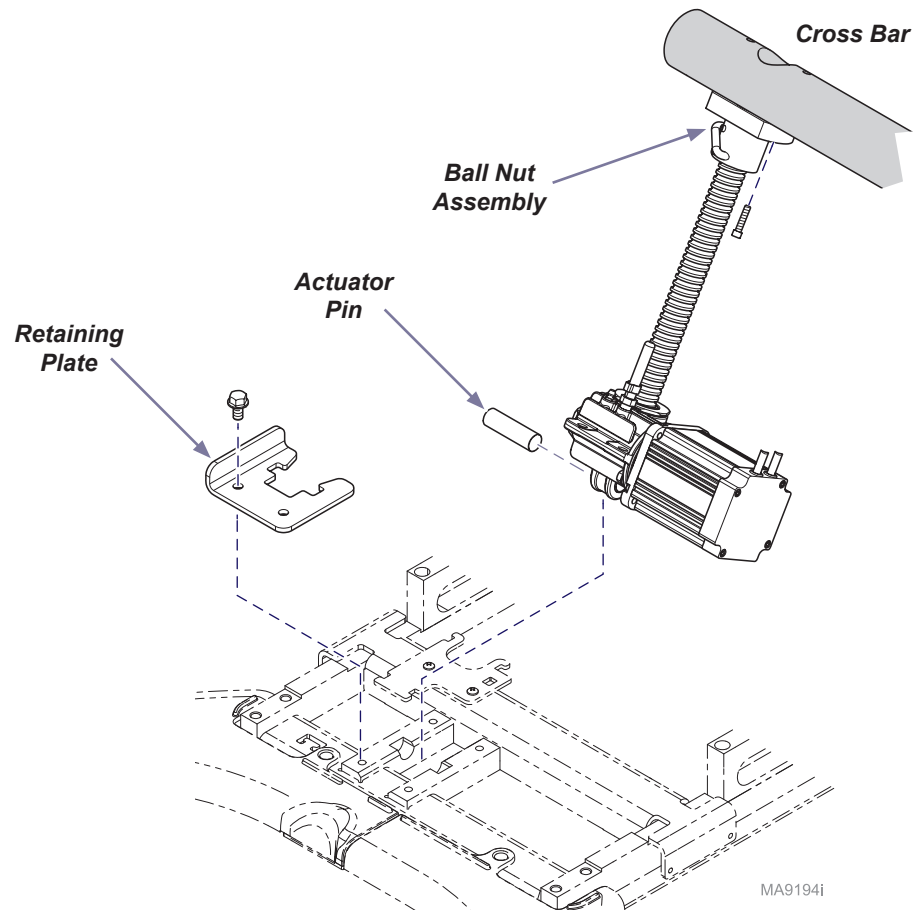
- A) Manually rotate the ball nut assembly to the bottom of the actuator shaft.
- B) Remove two screws and heal block.
- C) Lift up on base actuator and remove.
- D) Remove isolator from clevis block, then remove actuator pin and clevis block.



## Serial Numbers: V2200 thru V1460921

### Step 6:

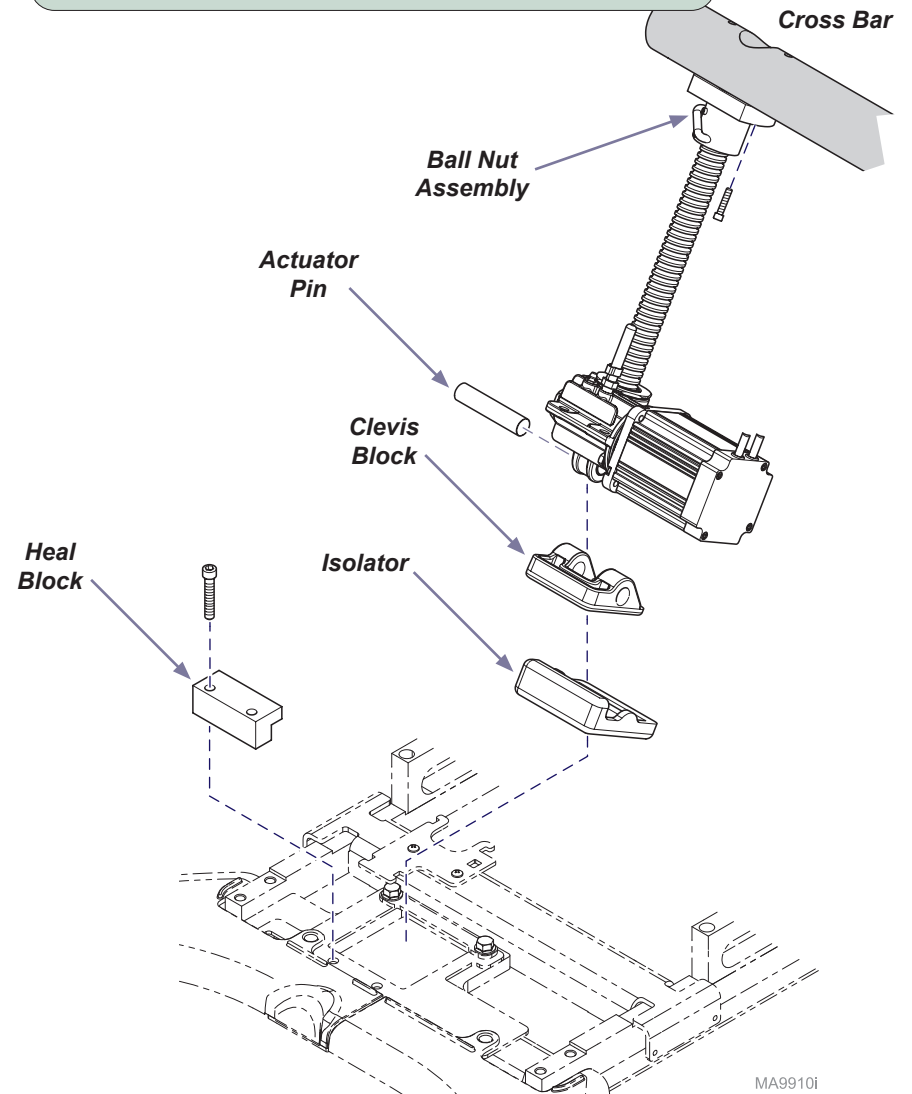
- A) Insert actuator shaft thru hole in cross bar.
- B) Position bottom of actuator with pin in slot.
- C) Manually rotate the ball nut assembly to the top of the actuator shaft and secure with two screws.
- D) Install retaining plate and secure with two screws.



## Serial Numbers: V1460922 thru Present

### Step 6:

- A) Install clevis block onto actuator with actuator pin.
- B) Install isolator onto clevis block.
- C) Insert actuator shaft thru hole in cross bar.
- D) Position bottom of actuator into base.
- E) Manually rotate the ball nut assembly to the top of the actuator shaft and secure with two screws.
- F) Install heal block and secure with two screws.





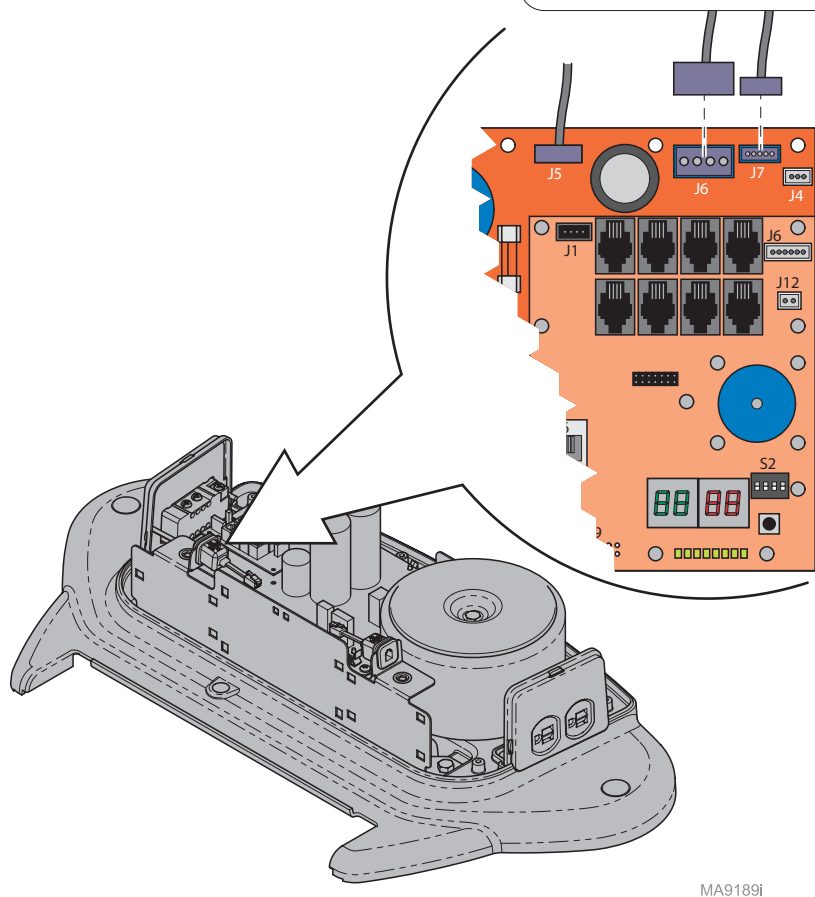
### Equipment Alert

The wire connections and wire routing must be put back in original locations before installing covers.



### Equipment Alert

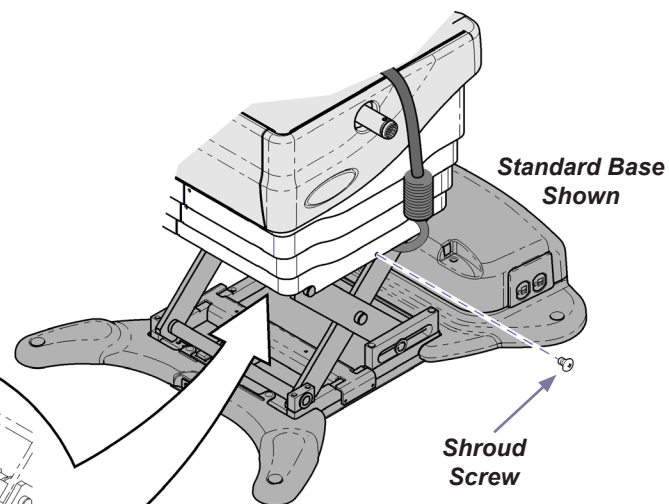
Anytime the limit switch wires or the actuator wires are disconnected, the chair must be calibrated.



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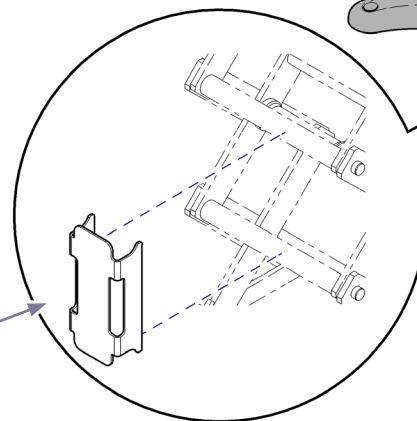
### Step 7:

- Connect wire connections to J6 and J7 on Power Supply PC Board, then secure wires with cable ties.
- Raise base and remove scissors lockout bracket.
- Lower base and reassemble shrouds.
- Calibrate chair.
- Install base cover.



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Scissors Lockout Bracket



## Base Cover

### Base Cover Removal / Installation

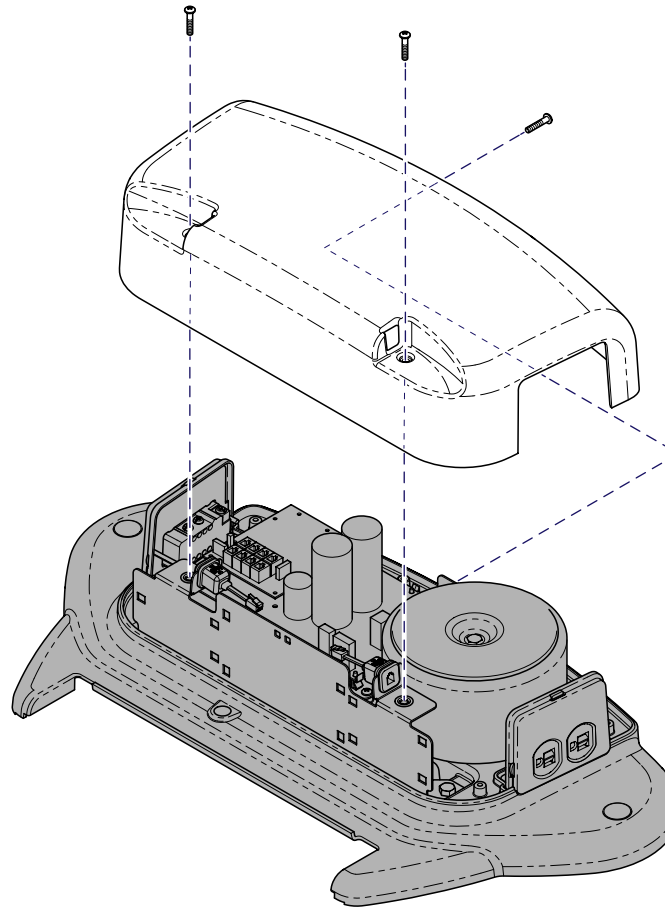


#### **WARNING**

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

#### **To remove base cover...**

- A) Remove three screws.
- B) Lift cover off of base.



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#### **To install base cover...**

- A) Position cover on base.
- B) Secure with three screws.

## 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”.

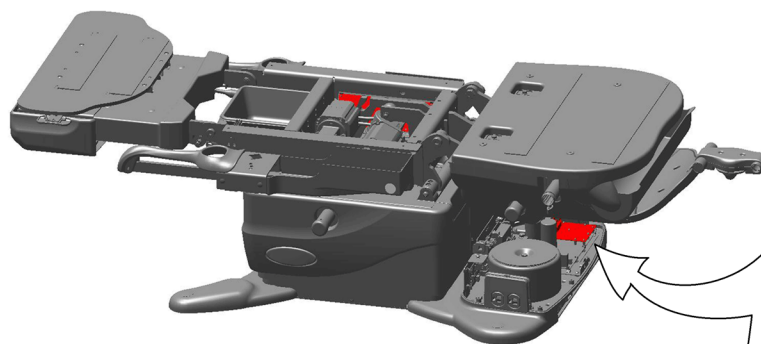
You **must** calibrate the chair in the following situations:

- 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.

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