

# Foot Actuator [002-1730-0x]

## Applies to Models:

630 (-010 thru -013)  
630 (-020 thru -023)  
631-001

## Special Tools:

none

Language of origin: English



### WARNING

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

### Note

If possible, run foot section to the full down position.

### Note

The 631-001 does not have a seat mounting board.

### Step: 1

- Remove seat / back upholstery.
- Remove four screws, seat mounting board, and seat cover plate.
- Disconnect wire connections J2 and J3 from Motor Control Hub PC Board.

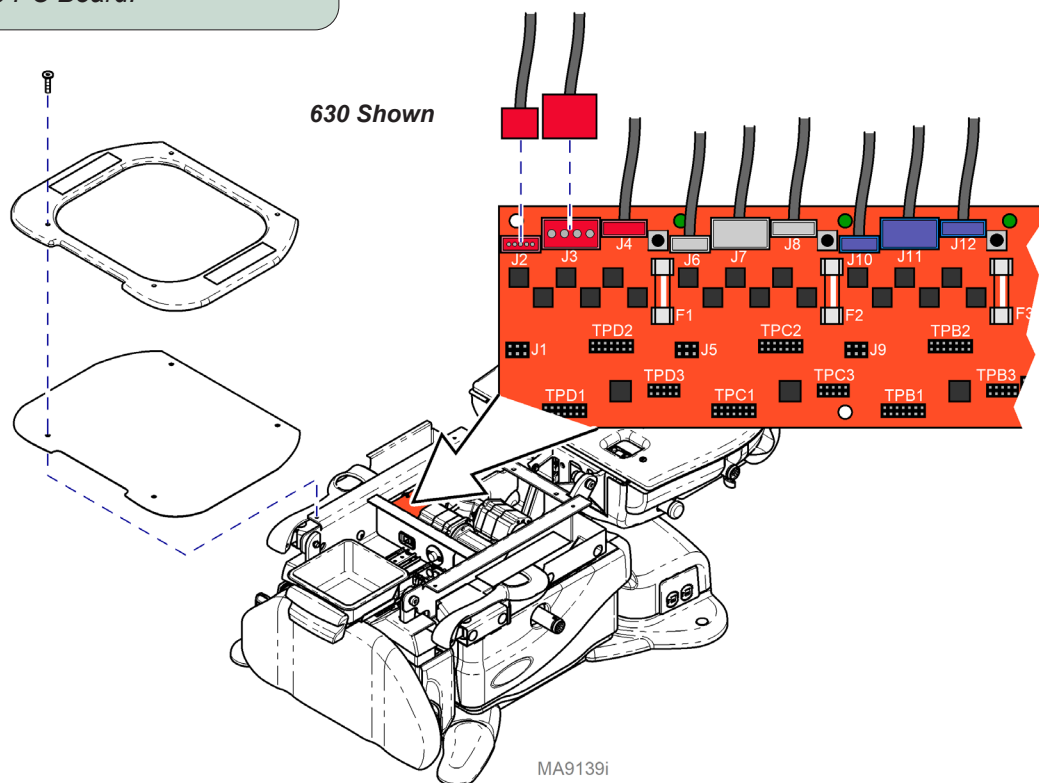


### Equipment Alert

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



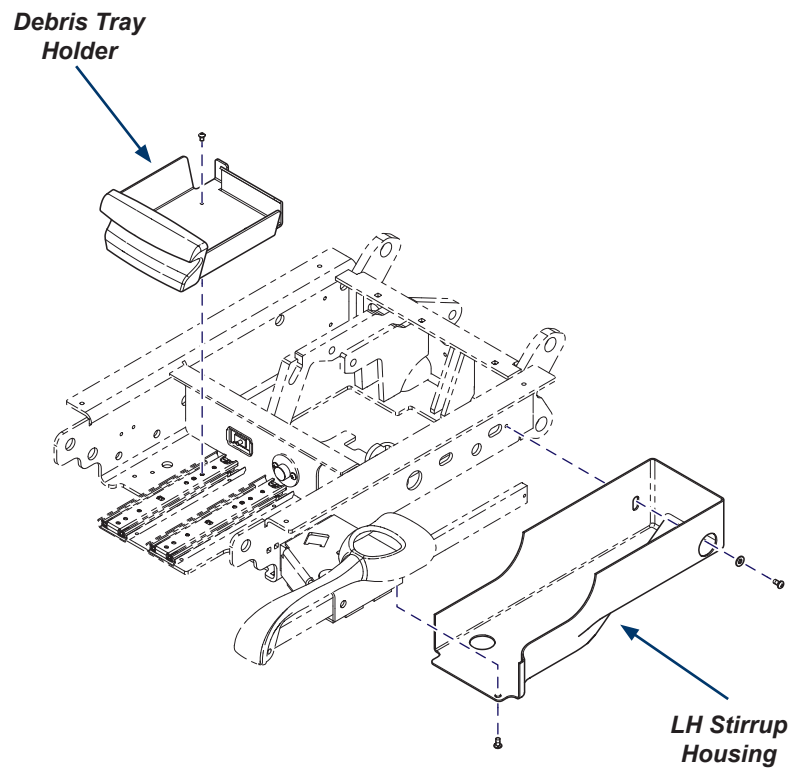
Replace Foot Actuator



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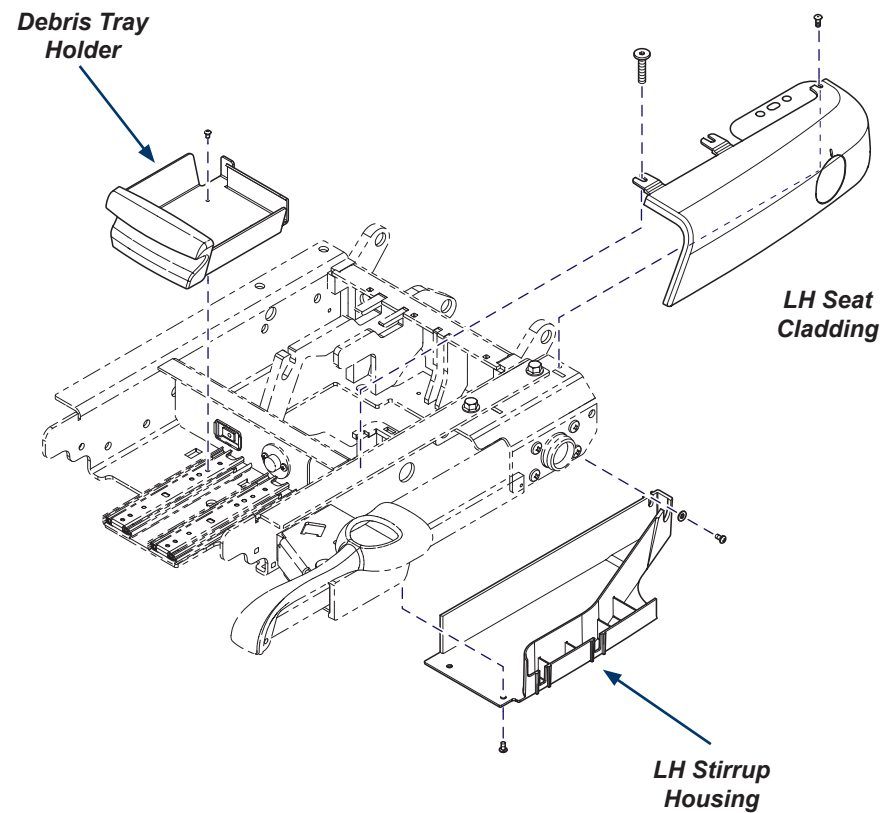
### Step: 2 (630 Models)

- A) Remove four screws and debris tray holder.
- B) Remove two screws and LH stirrup housing.



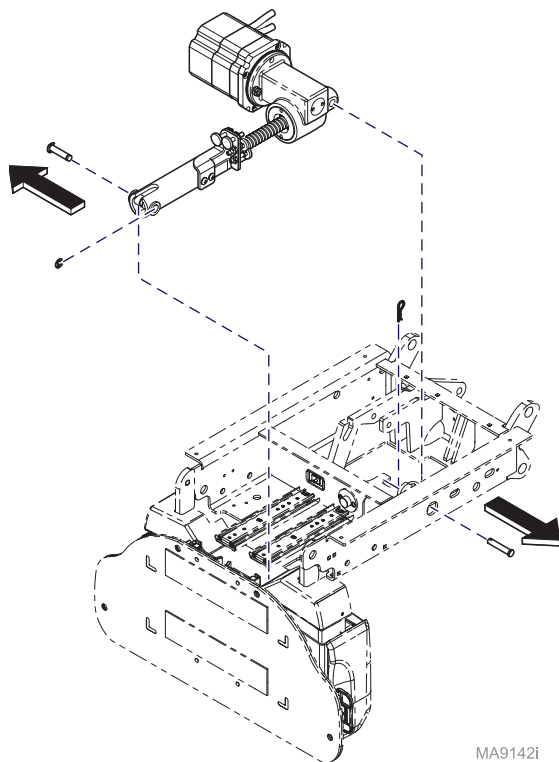
### Step: 2 (631-001)

- A) Remove four screws and debris tray holder.
- B) Remove three screws and LH seat cladding.
- C) Remove three screws and LH stirrup housing.

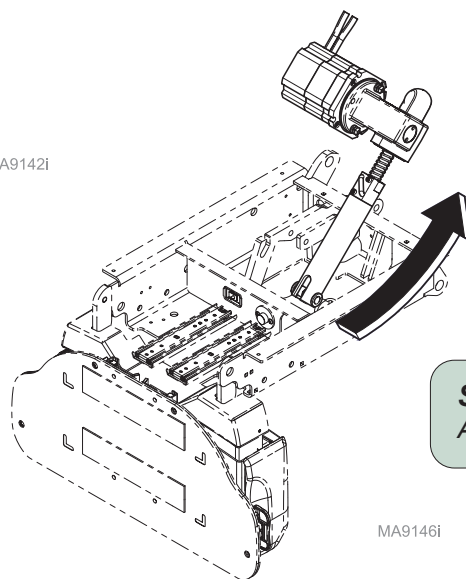


### Step: 3

- A) Remove e-ring and clevis pin from foot end of actuator.
- B) Remove cotter pin and clevis pin from head end of actuator.



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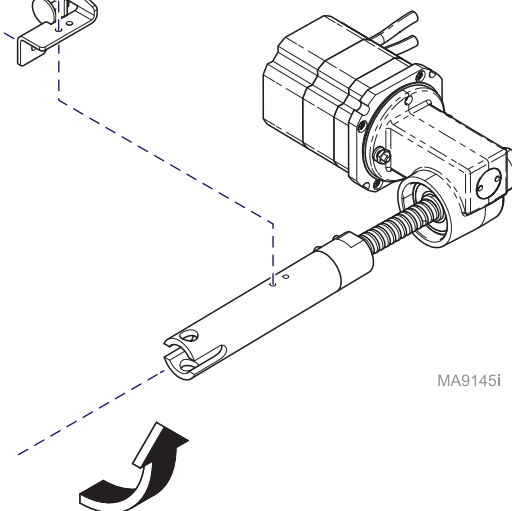
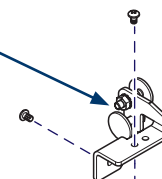


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### Step: 4

Rotate shaft, then remove three screws and limit stop bracket.

Limit Stop  
Bracket



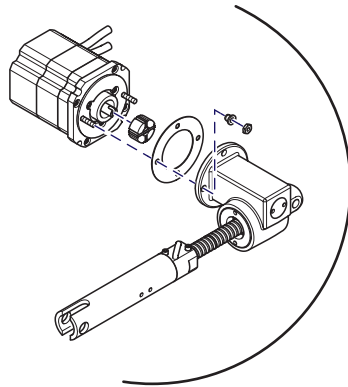
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### Step: 5

Angle head end of actuator upward and remove.

### Note

If replacing only the actuator / coupler, refer to the illustration below.  
If replacing complete actuator assembly, go directly to Step 6.



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### Equipment Alert

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



### Equipment Alert

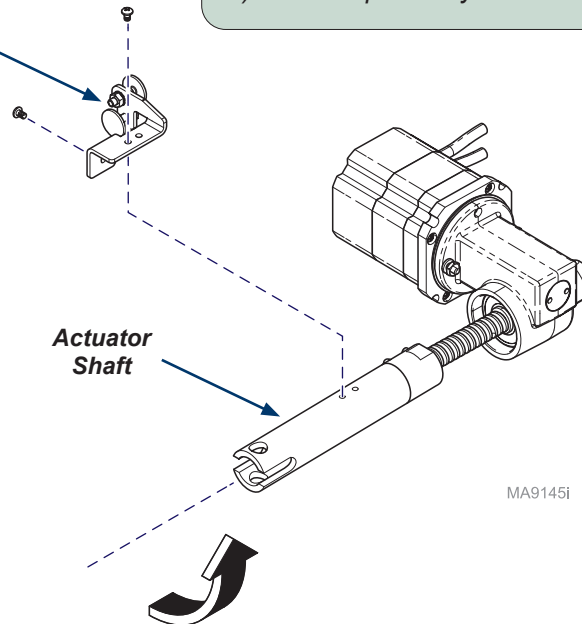
Anytime the limit switch wires or the actuator wires are disconnected, the chair must be calibrated.

### Step: 6

- A) Angle actuator into seat weldment.
- B) Install clevis pin at head end of actuator and secure with cotter pin.
- C) From full in, spin actuator shaft outward three rotations.
- D) Install limit stop bracket and secure with three screws.
- E) Install clevis pin at foot end of actuator and secure with e-ring.
- F) Position debris tray holder and secure with four screws.
- G) Position LH stirrup housing and secure with screws.
- H) Position LH seat cladding and secure with screws. (631-001 only)
- I) Connect wire connections to J2 and J3 on Motor Control Hub PC Board, then secure wires with cable ties.
- J) Calibrate chair.
- K) Position seat cover plate, and seat mounting board, then secure with four screws.
- L) Install upholstery.

Limit Stop  
Bracket

Actuator  
Shaft



MA9145i

# 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”.

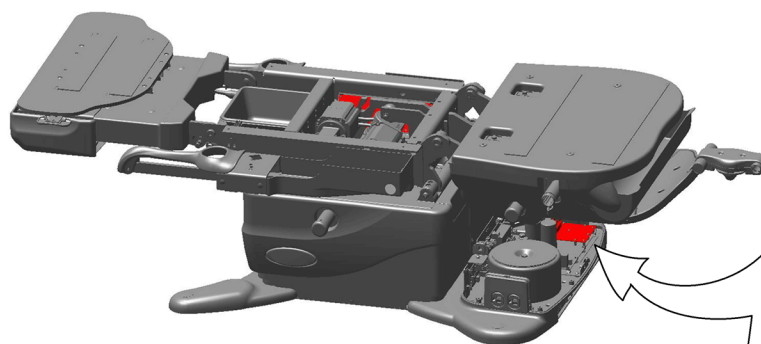
You **must** calibrate the chair in the following situations:

- 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

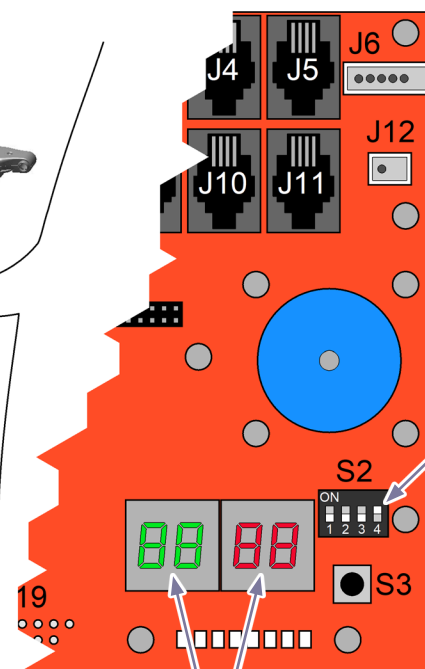
## Note

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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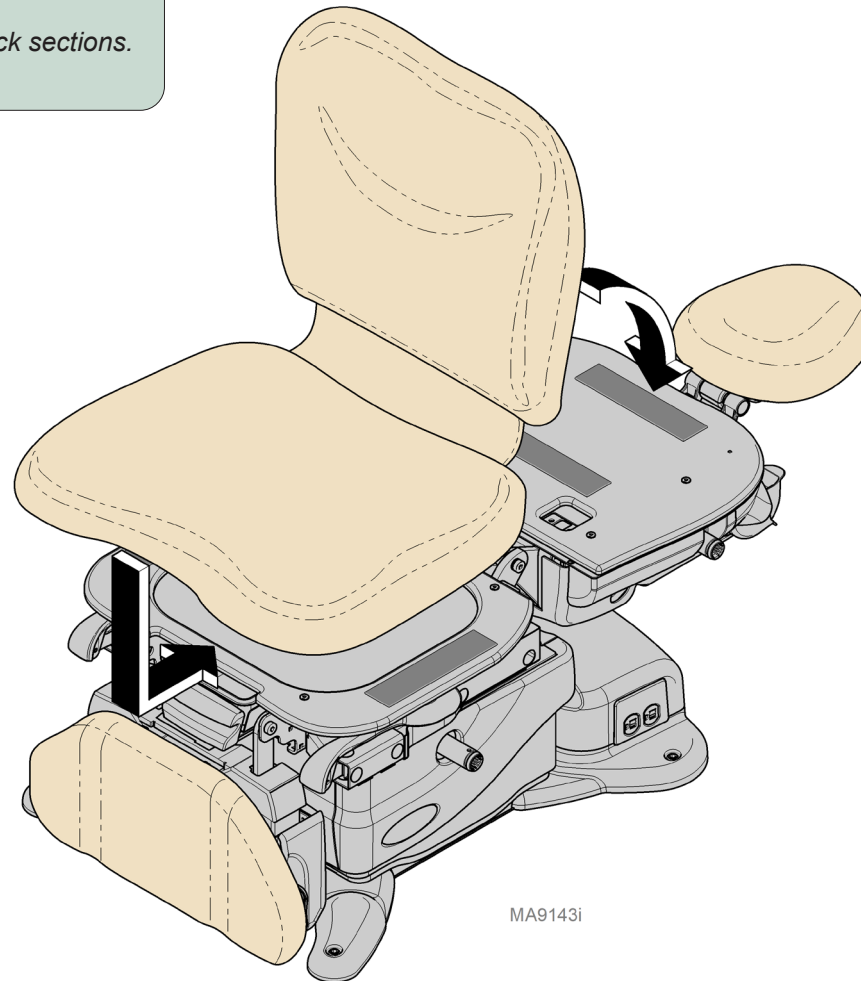
Digital  
Display

Switch  
Number  
Four

## 630 Models

### **To install seat / back upholstery...**

- A) Position back section of chair flat.
- B) Position front of seat section against seat mounting board.
- C) Press seat section down firmly.
- D) Position top of back section against the top of the back mounting board.
- E) Check for a consistent gap between seat and back sections.
- F) Press back section down firmly.



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**To install seat / back upholstery...**

- A) Place the seat section on the chair insuring that the front is up against the seat plate and centered.
- B) Press on seat section firmly to secure.
- C) Raise back section fully up to engage the upholstery to the top of the back plate.
- D) Press on back section firmly to secure.

