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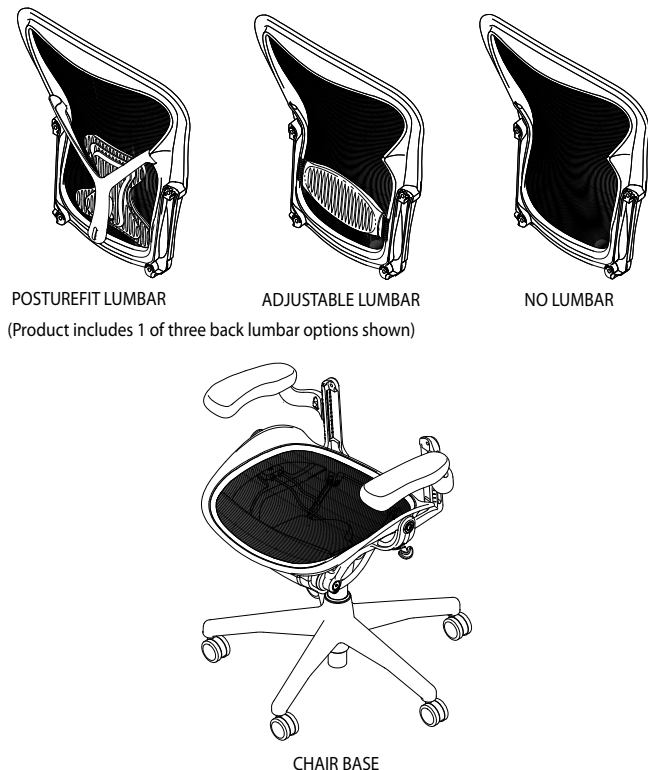
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# Service Parts

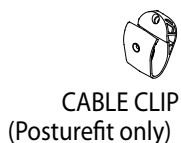
## **Aeron® Chairs Service Instructions**

# Aeron® "Knocked Down" Product Assembly

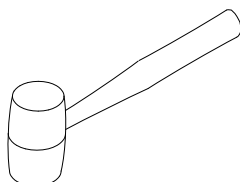
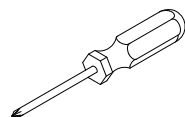
## PARTS INCLUDED



CABLE CLIP SCREW  
(Posturefit only)



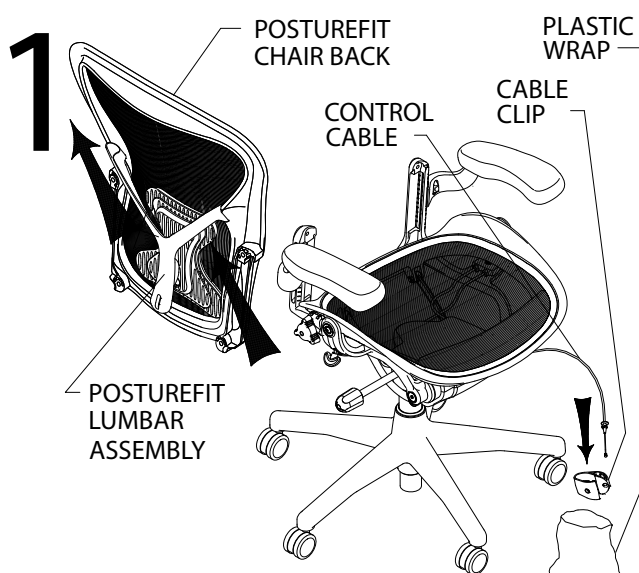
## TOOLS REQUIRED



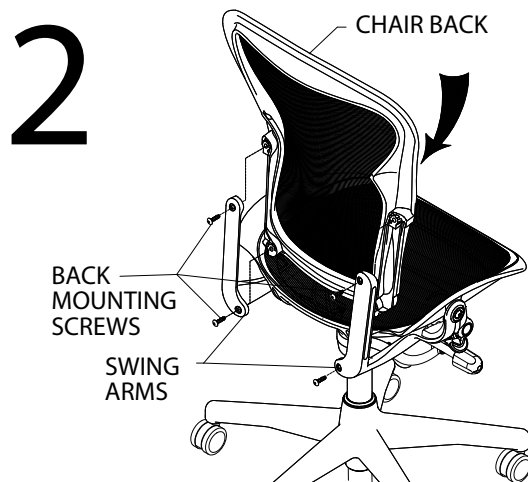
### NOTICE !

On product equipped with Posturefit lumbar begin assembly procedure with step 1. On all other product begin procedure by Referring to step 2.

## PROCEDURE



- 1.1 By hand, pull Posturefit lumbar assembly up and off inner slide rails on chair back. Set lumbar assembly aside.
- 1.2 Remove plastic wrap from end of control cable and remove cable clip from end of control cable, then proceed to step 2



- 2.1 Align mounting holes on chair back with mounting holes on swing arms, as shown.
- 2.2 Using assembly tool provided, install and tighten (4) back mounting screws to secure chair back to chair base.

### ⚠ WARNING

Install all 4 black attachment screws and tighten securely. Failure to comply may allow back to separate from chair causing personal injury.

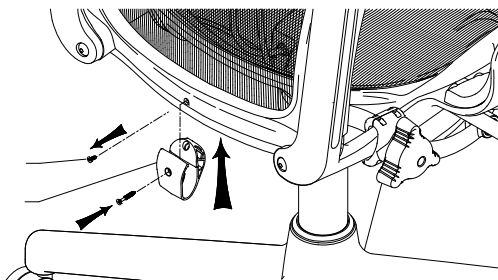
- 2.3 On chairs equipped with posturefit lumbar, proceed to step 3. On chairs equipped with adjustable lumbar proceed to step 6.

1B2YXX REV E



# 3

REMOVE BACK  
FRAME SCREW  
CABLE CLIP

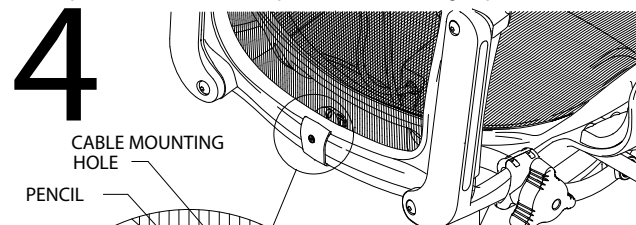


**NOTICE !** After April of 2007, all cable clips are "C" size chair cable clips. When installing these clips to an A or B size seat back, position and hold clip vertically when tightening mounting screw.

- 3.1 Remove and discard screw at bottom center of back frame.
- 3.2 Slide cable clip up onto bottom center of back frame and align mounting hole in clip with screw hole in back frame.
- 3.3 Secure cable clip to back frame with long cable clip screw provided in hardware pack, while holding clip vertical.

# 4

CABLE MOUNTING  
HOLE  
PENCIL



step 4-A

CONTROL  
CABLE  
END

CONTROL  
CABLE  
GROMMET

step 4-B

CABLE CLIP

- 4.1 Insert pencil through back fabric, inline with cable mounting hole in cable clip, to create an opening in in fabric. Then remove pencil from fabric. See step 4-A.
- 4.2 Route end of control cable under seat, making sure cable is routed over top all other control cables under seat.
- 4.3 from back side of clip, insert end of control cable through cable clip mounting hole and through hole in fabric. See step 4-B.
- 4.4 Insert control cable grommet into back side of cable clip and seat grommet completely into clip. See step 4-B.

# 5

POSTUREFIT LUMBAR  
ASSEMBLY WISHBONE

step 5-A

(USE RUBBER  
Mallet IF  
NECESSARY)

INNER  
SLIDE  
RAIL

INNER  
SLIDE  
RAIL

CABLE END

step 5-B

CONTROL  
MECHANISM

KEYHOLE SLOT

WISHBONE

- 5.1 Reinstall Posturefit lumbar assembly by sliding open slots on wishbone, down onto inner slide rails on chair back frame. If necessary, use rubber mallet to ensure lumbar assembly is completely seated onto slide rails. See step 5-A
- 5.2 Adjust control mechanism counter-clockwise to set posturefit at minimum support setting.
- 5.3 Depress base of wishbone on Posturefit lumbar assembly, and engage cable end into keyhole slot in wishbone. See step 5-B

# 6

ADJUSTABLE LUMBAR

INNER  
SLIDE  
RAIL

INNER  
SLIDE  
RAIL

- 6.1 Install adjustable lumbar to chair back frame by sliding lumbar onto inner slide rails, on inside of back frame.

# Aeron® Torque and Tool Specifications

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### WARNING

Support parts associated with fasteners that are to be removed for service or product damage and or personal injury may occur.

1. USING SPECIFIED TOOL SIZE, REMOVE FASTENING HARDWARE AND REPLACE. SOME FASTENERS WILL REQUIRE FURTHER INSTRUCTION FOR REMOVAL PROCEDURE, FOUND IN SERVICE PART INFORMATION MATERIAL. TORQUE FASTENERS TO SPECIFIED AMOUNTS. SEE FIGURE 1.

FASTENER: BACK SCREW  
TOOL SIZE: 5MM HEX BIT  
WITH RATCHET  
WRENCH

TORQUE SPEC: 70-100 IN-LBS.

FASTENER: SUPPORT SCREW  
TOOL SIZE: 13MM SOCKET WITH  
RATCHET WRENCH

TORQUE SPEC: 200-250 IN-LBS.

FASTENER: HIP PIVOT SCREW  
TOOL SIZE: 6MM HEX BIT  
WITH RATCHET  
WRENCH

TORQUE SPEC: 180-200 IN-LBS.

FASTENER: FRONT SEAT LINK  
TOOL SIZE: 6MM HEX BIT WITH  
RATCHET WRENCH

TORQUE SPEC: 120-150 IN-LBS.

FASTENER: ARM YOKE  
TOOL SIZE: T-27 TORX BIT WITH  
RATCHET WRENCH

TORQUE SPEC: 100-125 IN-LBS.

FASTENER: REAR SEAT LINK  
TOOL SIZE: 10MM SOCKET  
WITH RATCHET  
WRENCH

FASTENER: REAR SEAT LINK  
TOOL SIZE: 4MM HEX KEY

TIGHTEN NUT UNTIL FLUSH WITH  
END OF SCREW

FASTENER: RETAINING RING  
TOOL: RETAINING RING  
TOOL

FASTENER: TILT SET SCREW  
TOOL SIZE: 4MM HEX KEY

FASTENER: SWING ARM (PRE 9-16-96)  
TOOL SIZE: T-40 TORX BIT  
WITH RATCHET WRENCH

TORQUE SPEC: 120-150 IN-LBS.

FIGURE 1

# Aeron® Base Replacement

TOOLS NEEDED: MALLET  
BASE KNOCK-OFF TOOL  
STRAIGHT HEAD SCREWDRIVER

PROCEDURE:

1. INVERT CHAIR AND PLACE ON CLEAN WORK SURFACE.
2. PULL CASTERS/GLIDES FROM BASE, USING A ROCKING MOTION. SEE FIGURE 1.

NOTE: IF CASTER STEM REMAINS IN BASE, REMOVE STEM BY PRYING UP WITH STRAIGHT HEAD SCREWDRIVER. INSERT STEM INTO CASTER.

3. FOR BASE REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:

PLACE BASE KNOCK OFF TOOL OVER CYLINDER HUB. HOLD BASE IN ONE HAND WHILE HITTING KNOCK OFF TOOL WITH MALLET UNTIL DISENGAGED. REMOVE BASE AND DISPOSE OF PROPERLY. SEE FIGURE 2.

4. FOR REPLACEMENT BASE INSTALLATION, FOLLOW APPROPRIATE PROCEDURE BELOW:

INSTALL BASE OVER PNEUMATIC CYLINDER, PUSHING IT ON AS FAR AS POSSIBLE. SET CHAIR UPRIGHT AND SIT IN CHAIR, FORCING PNEUMATIC CYLINDER INTO PROPER POSITION IN BASE.

5. INSERT CASTERS/GLIDES INTO BASE UNTIL FULLY ENGAGED. SEE FIGURE 1.

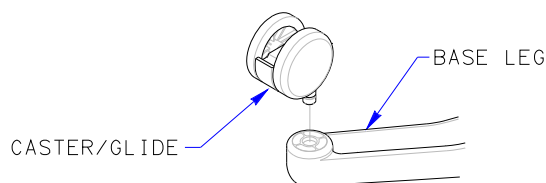


FIGURE 1

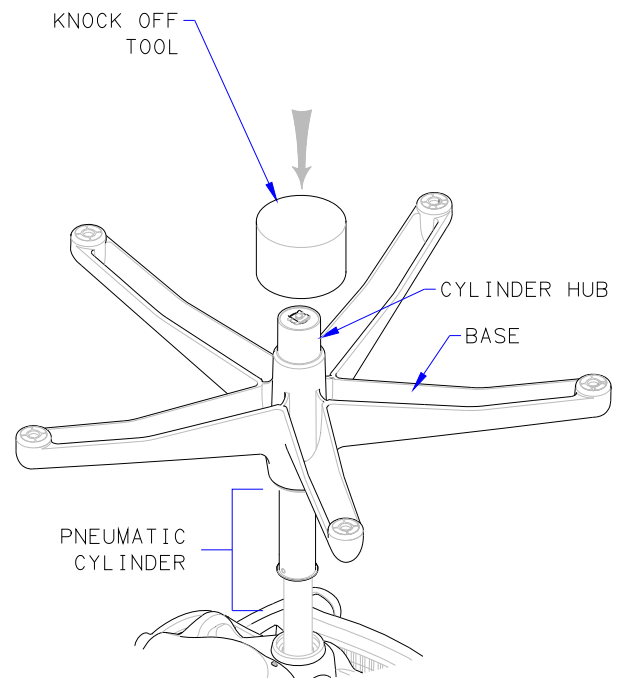
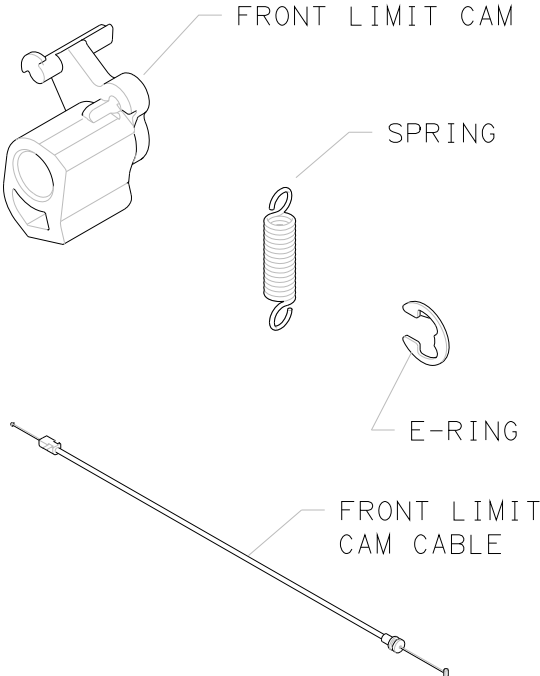


FIGURE 2

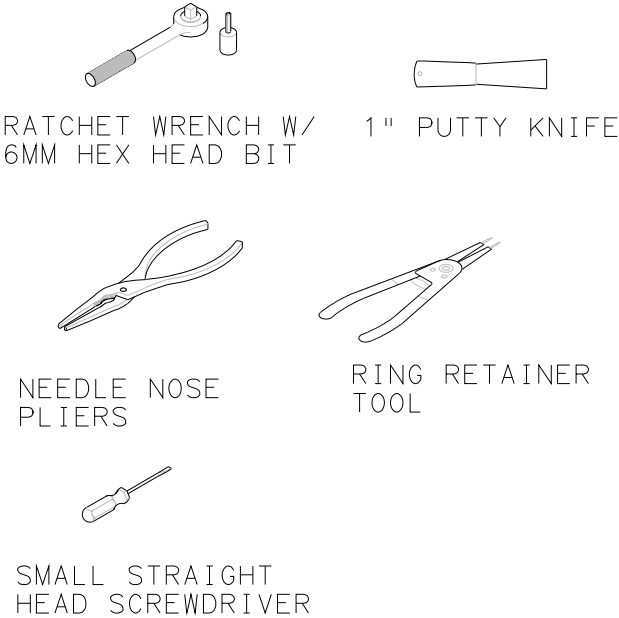
167201 REV E

# Aeron® Front Limit Cam Replacement

## PARTS INCLUDED



## TOOLS NEEDED



## PROCEDURE

1

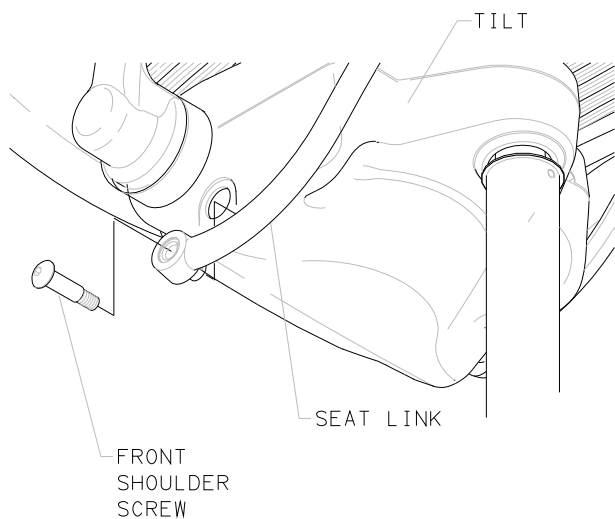
**NOTICE**  
If chair is manufactured after 3-09-04, complete steps 1-3 & go onto step 8b.

**NOTICE**  
Make sure fasteners are torqued to specified values.

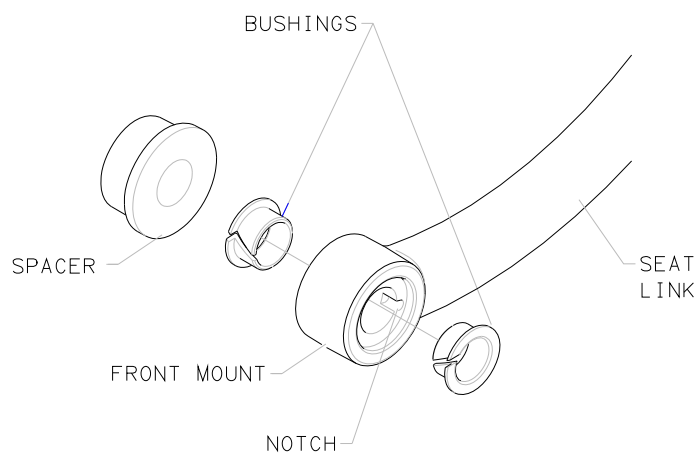
**CAUTION**  
Tilt tension must be put at the lowest position to install this service item.

**CAUTION**  
Forward tilt must not be in activated position before this service procedure begins.

174203 REV F



(OLDER VERSION)



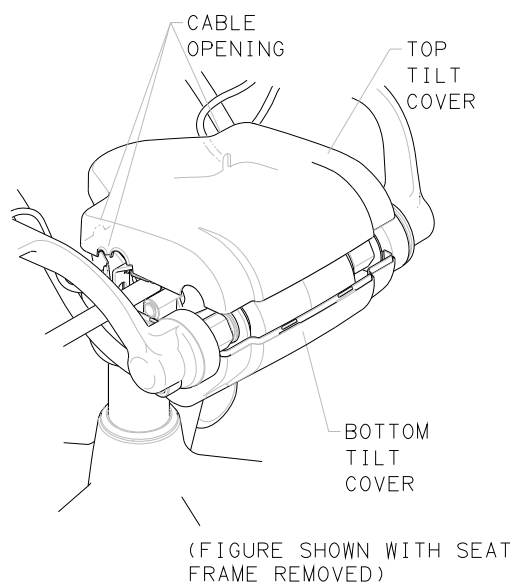
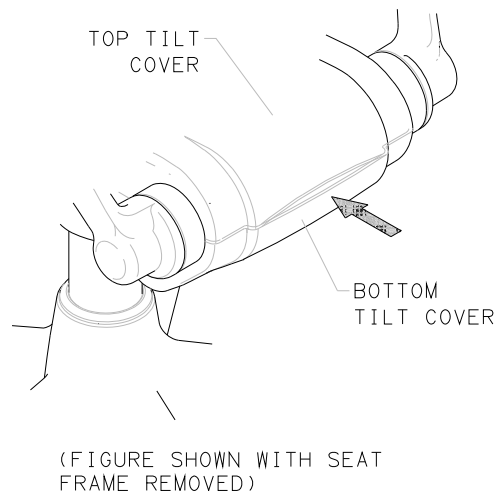
#### TO REMOVE :

1. While supporting seat link, use 6MM socket, ratchet wrench to remove sholder screw attaching seat link to tilt. Set aside shoulder screw. Let seat link hang. Remove spacers and or bushings if applicable and set aside. Repeat for opposite side.

#### TO REINSTALL :

1. Attach front mount of seat link to tilt with shoulder screw. Tighten and torque to 120-150 in-lbs.

2



#### CAUTION

Make sure all cables are routed through cable openings on tilt cover before snapping tilt cover in place or product damage occur.

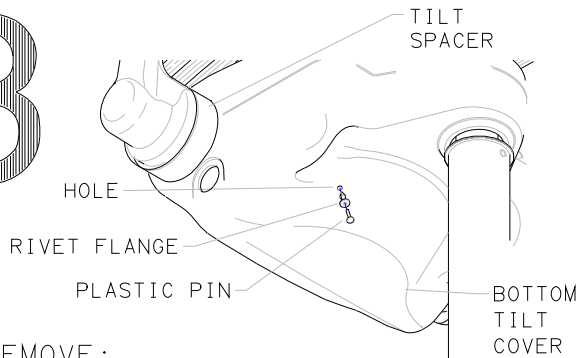
#### TO REMOVE :

1. Apply pressure on front of bottm tilt cover to start separation of tilt covers. Insert 1" putty knife between top and bottom covers and and twist to completely separate tilt covers. Set top tilt cover aside.

#### TO REINSTALL :

1. Place top tilt cover on tilt and align to bottom tilt cover. Route all cables through cable openings and snap covers together.

# 3



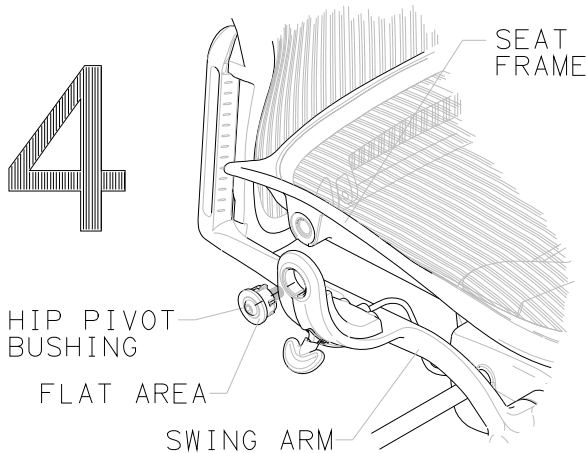
## TO REMOVE :

1. Using needle nose pliers, remove plastic pin from rivet flange from under side of lower tilt cover on left side and set aside.  
Using needle nose pliers, remove rivet flange from tilt cover and set aside. Let bottom cover rest on base. Older chairs secure cover with (2) phillipshead screws. Use #2 phillips head screwdriver to remove and set aside.

## TO REINSTALL :

1. Slide bottom tilt cover up to tilt. Make sure notches in tilt spacer grooves engage slots in tilt cover. If necessary, rotate tilt spacers to align notches with slots. Align hole in tilt cover to hole in tilt. Install rivet flange into tiltcover and tilt. Insert rivet pin into rivet flange.

# 4



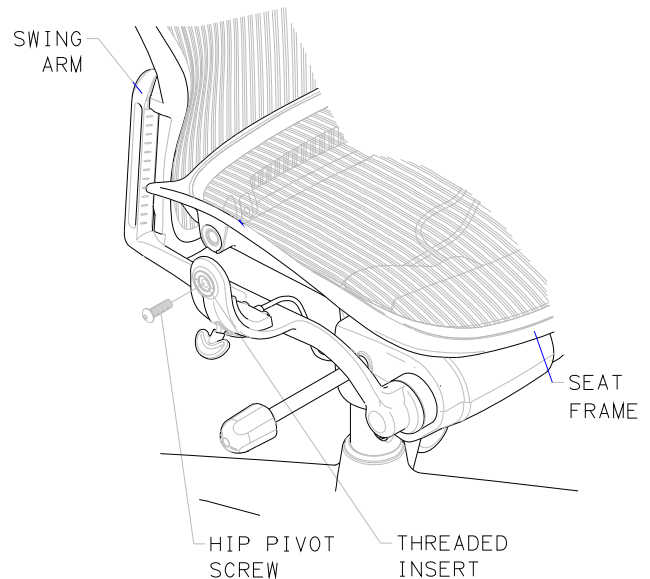
(FOR CHAIRS MANUFACTURED AFTER JUNE 4,2003)

## TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot bushing assembly from swing arm. Loosening pivot fastener will force hip pivot bushing assembly from swing arm. After hip pivot fastener has disengaged from seat frame, remove hip pivot bushing and set aside. Repeat for other side. Remove seat frame with b-links and set aside.

## TO REINSTALL :

1. Make certain flat area around fasteners head in hip pivot bushing is flat and aligned with bushing area. Repeat for other hip pivot bushing.
2. Lower seat in place. Align fastener in seat frame to mounting hole in swing arm and insert hip pivot bushing.
3. Insert other hip pivot fastener into swing arm aligning top and bottom guides into slots in swing arm opening.
4. Using 6MM head bit and ratchet wrench, partially thread hip pivot fastener into seat frame. Repeat for opposite side.
5. Secure fasteners of hip pivot bushing, drawing hip pivot bushing into seat frame. Torque fasteners to 180-200 lbs.



(FOR CHAIRS MANUFACTURED BEFORE JUNE 4,2003)

## TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot screw from each swing arm. If threaded insert turns with hip pivot screw, **STOP** immediately and do the following step: Tighten hip pivot screw into threaded insert as much as possible. Using a quick jerking motion with ratchet wrench. Back out hip pivot screw from threaded insert. If threaded insert turns with hip pivot screw, repeat process.

## CAUTION

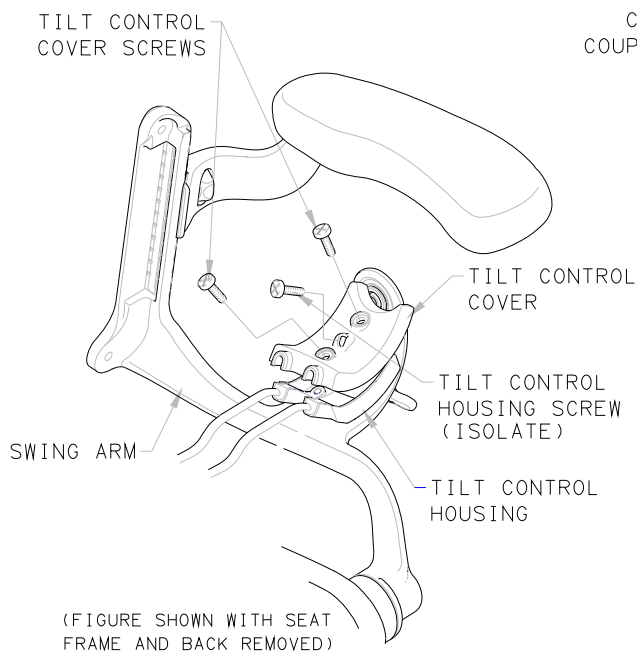
If threaded inserts turn while removing hip pivot screws from seat frame, **STOP IMMEDIATELY** and follow instructions.

174203 REV F

## TO REINSTALL :

1. Place seat frame between swing arms. Attach seat frame to swing arms with hip pivot screws. Tighten and torque to 180-200 in lbs.

# 5



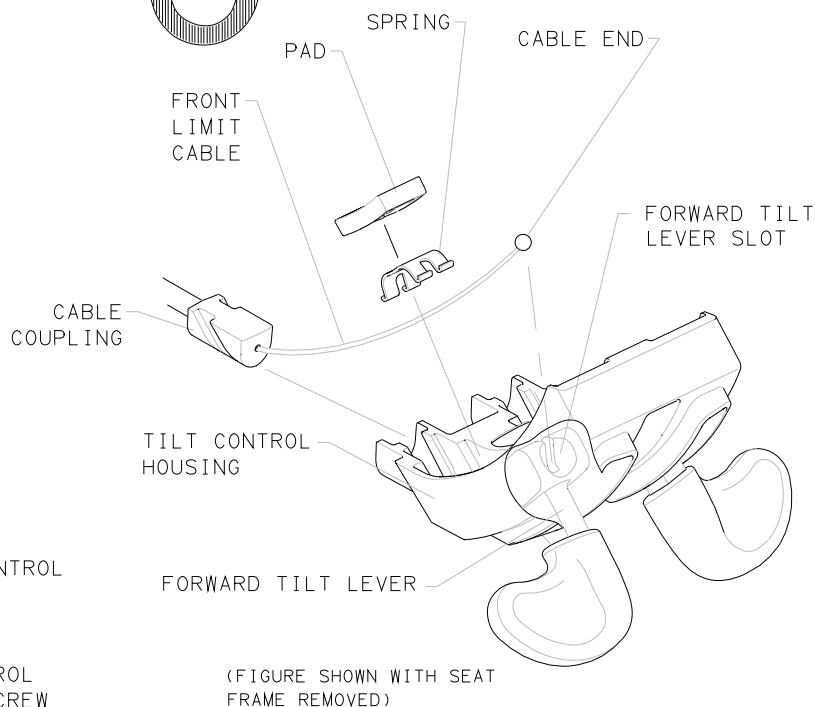
## TO REMOVE : (FOR CHAIRS MANUFACTURED BEFORE 3-9-04)

1. Using #2 phillips head screwdriver, remove and set aside screw tilt control to swing arm. Keep this screw isolated from all other hardware while undergoing this procedure. Remove and set aside (2) screws fastening tilt control cover to tilt control housing. Set aside tilt control cover.

## TO REINSTALL :

1. Using #2 phillips head screwdriver, secure tilt control cover on tilt control housing with (2) screws.
2. Using #2 phillips head screwdriver, secure tilt control to swing arm with screw.

# 6



## TO REMOVE : (FOR CHAIRS MANUFACTURED BEFORE 3-9-04)

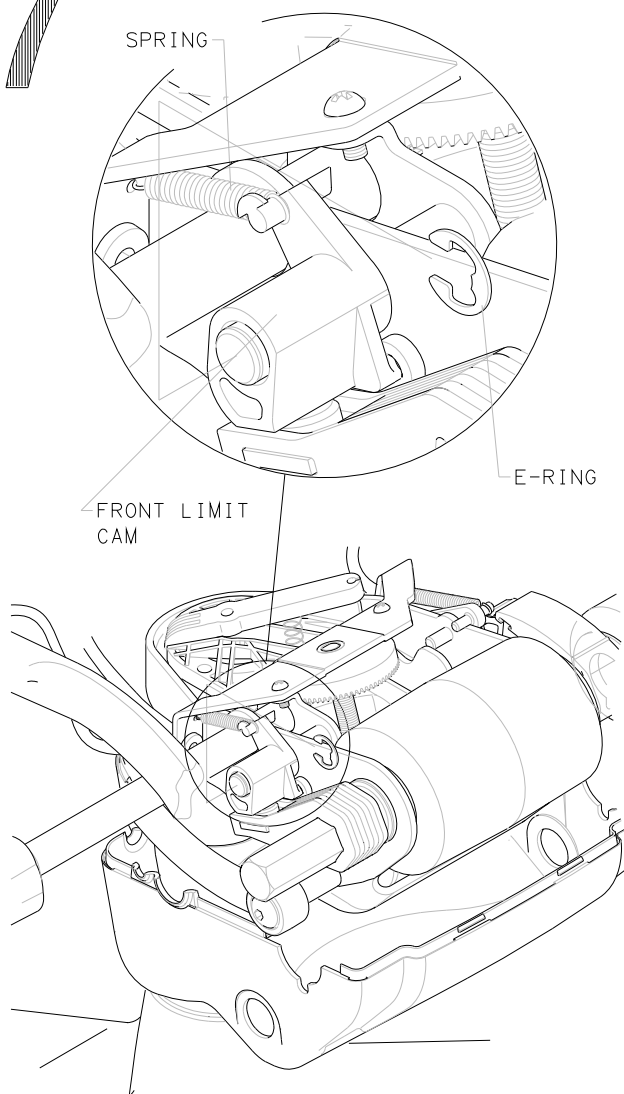
1. Remove and set aside pad and spring from forward tilt lever. Remove front limit cable from forward tilt lever lever.

## TO REINSTALL : (FOR CHAIRS MANUFACTURED BEFORE 3-9-04)

1. Slide replacement front limit cable coupling into slot in forward tilt lever. Insert spring over cable into cavity of lever. Place pad over spring. Proceed to reinstall of step 5, before proceeding to step 7.



# 7



(FIGURE SHOWN WITH SEAT FRAME REMOVED FROM PRE 3-9-04 CHAIR)

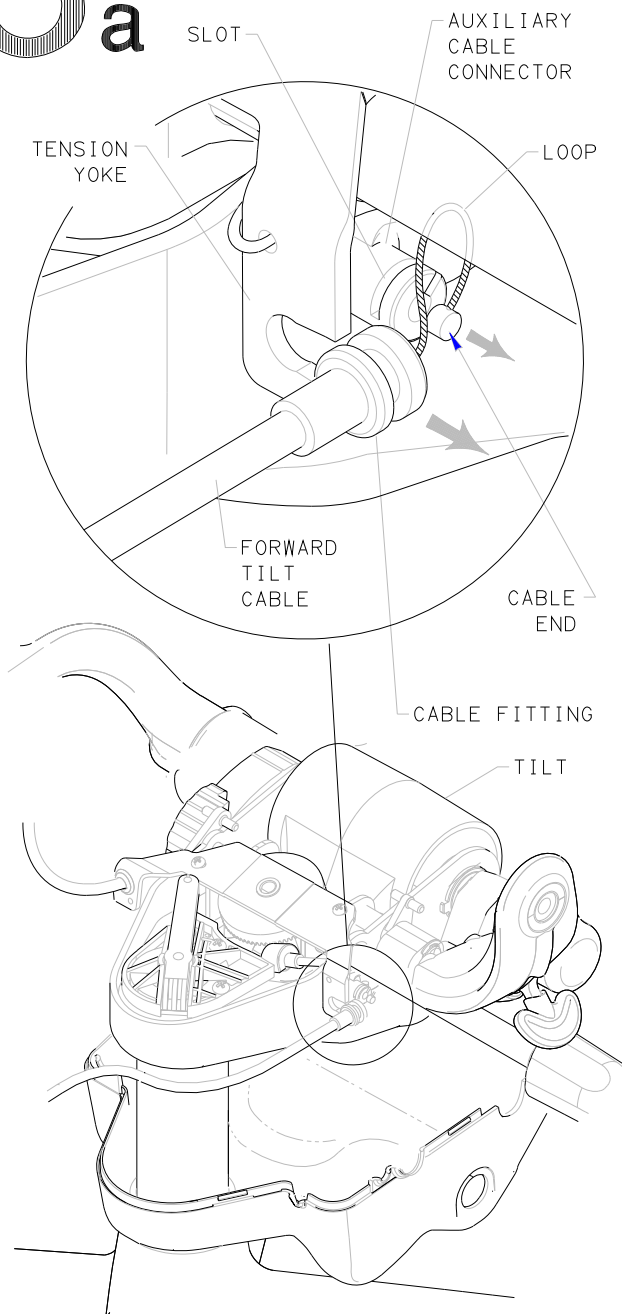
## TO REMOVE :

1. Using needle nose pliers, disengage spring from front limit cam. Using small straight head screwdriver remove E-ring holding front limit cam in place.

## TO REINSTALL :

1. Secure front limit cam with E-ring. Attach spring to front limit cam.

# 8a



(FOR CHAIRS MADE BEFORE 3-9-04)

(FIGURE SHOWN WITH SEAT FRAME REMOVED)

174203 REV F



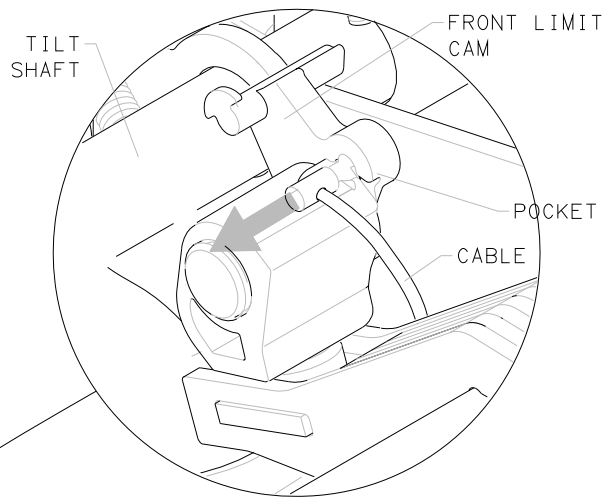
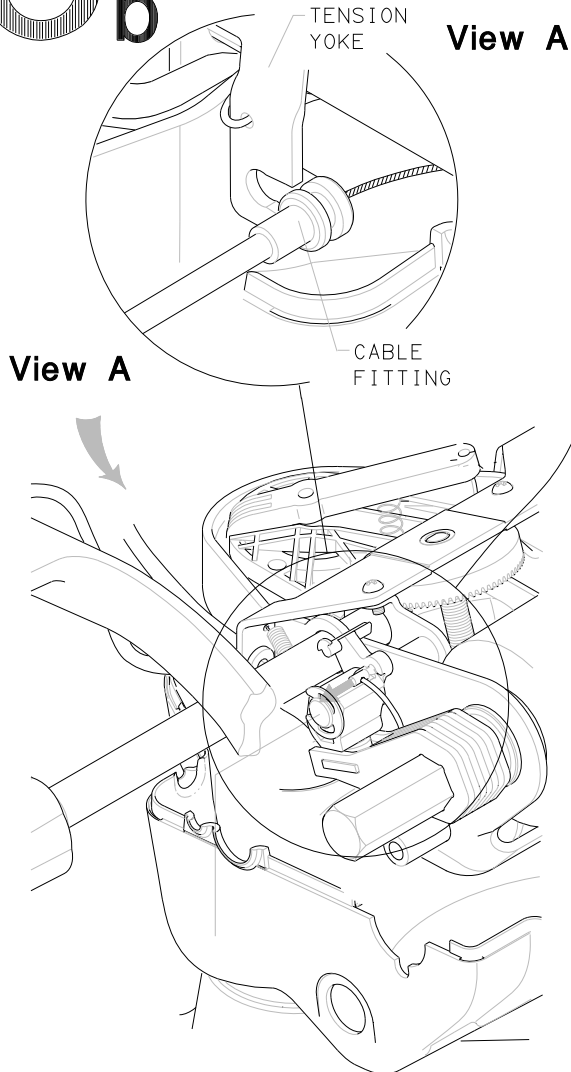
(FOR CHAIRS MADE BEFORE 3-9-04)  
TO REMOVE:

1. Use thumb pressure to remove forward tilt cable fitting (RH side) from tension yoke on tilt. Move cable forward to create loop and disengage cable end from auxiliary cable connector.

TO REINSTALL:

1. See instructions to reinstall "chairs made after 3-09-04 on this page.

**8b**



(FOR CHAIRS MADE AFTER 3-9-04)

TO REMOVE:

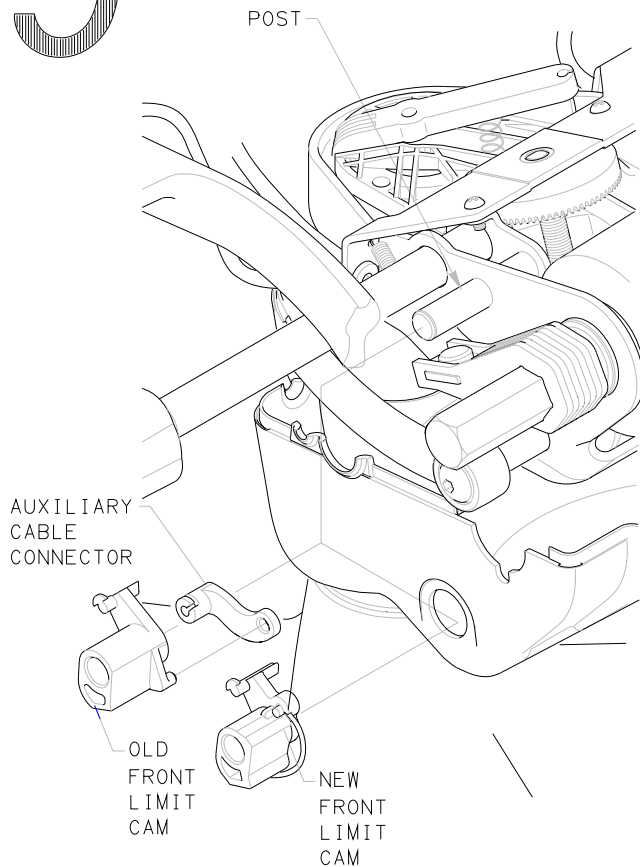
1. Use thumb pressure to remove forward tilt cable fitting (RH side) from tension yoke on tilt. Move cable forward to provide slack. Using needle nose pliers, slide cable from pocket in front limit cam.

TO REINSTALL:

1. Feed cable end under tilt shaft along side tilt housing along right side of front limit cam. Insert cable end into pocket on top of front limit cam. Wrap cable around rear of front limit cam, clockwise.
2. Using thumb pressure install replacement cable fitting into tension yoke on tilt.

(FOR CHAIRS MADE AFTER 3-9-04)

# 9



## WARNING

Tilt position must be maintained during the following procedure. Failure to do so may cause personal injury.



## WARNING

Tilt tension must be maintained during following procedure. Failure to do so may cause personal injury.

### TO REMOVE :

1. Apply downward pressure to top of back to relieve pressure from front limit cam. This tilt position must be maintained until replacement front limit cam is installed with E-ring.
2. Remove front limit cam and auxiliary cable connector if applicable, and dispose of properly.

### TO REINSTALL :

1. Slide front limit cam in position shown.
2. Refer back to steps 8 and 7, for installing cable, securing cable fitting and installing E-clip.

174203 REV F

# Aeron® Side Chair Base Replacement

TOOLS REQUIRED: RATCHET WRENCH  
6 MM HEX BIT  
5 MM HEX BIT  
AWL  
HAMMER  
TORQUE WRENCH, 200 IN-LBS CAPACITY

## PROCEDURE:

1. USING AWL AND HAMMER, DRIVE PINS FROM BASE HOLDING SEAT FRAME AND SET ASIDE. REMOVE BUMPERS FROM SEAT FRAME AND SET ASIDE. SEE FIGURE 1.

### CAUTION

If threaded inserts turn while removing screws from seat frame, STOP IMMEDIATELY and follow instructions.

2. USING 6MM HEX BIT AND RATCHET WRENCH, REMOVE SCREWS FROM BASE. IF THREADED INSERT TURNS WITH SCREW, STOP IMMEDIATELY AND DO THE FOLLOWING STEP. TIGHTEN SCREWS INTO THREADED INSERT AS MUCH AS POSSIBLE. USING A QUICK JERKING MOTION WITH RATCHET WRENCH, BACKOUT SCREW FROM THREADED INSERT. IF THREADED INSERT STILL TURNS WITH SCREW, REPEAT. REMOVE SEAT AND SET ASIDE. SET ASIDE SPACERS. SEE FIGURE 1.

3. IF CHAIR IS EQUIPPED WITH LUMBAR, REMOVE LUMBAR FROM BACK FRAME BY SLIDING CONNECTORS OF LUMBAR OFF TRAVEL RAILS OF BACK FRAME. SET LUMBAR ASIDE. SEE FIGURE 2.

### CAUTION

Support back frame while removing screws attached to swing arms. Failure to do so could allow back frame to fall causing product damage.

4. WHILE SUPPORTING BACK FRAME, USE RATCHET WRENCH AND 5MM HEX BIT TO REMOVE (4) SCREWS ATTACHING BACK FRAME TO BASE ASSEMBLY. SET ASIDE SCREWS. REMOVE BACK FRAME AND SET ASIDE. REMOVE LEFT AND RIGHT HAND FILLERS AND SET ASIDE. SEE FIGURE 2.
5. PROPERLY DISPOSE OF BASE.
6. PLACE LEFT AND RIGHT HAND FILLERS ON REPLACEMENT BASE, ALIGNING HOLES. PLACE BACK FRAME UP TO BASE ALIGNING HOLES. SECURE WITH SCREWS. TIGHTEN AND TORQUE SCREWS TO 70-100 IN-LB. SEE FIGURE 2.
7. IF CHAIR IS EQUIPPED WITH LUMBAR, ATTACH LUMBAR TO BACK FRAME BY ENGAGING EACH CONNECTOR ON LUMBAR TO TRAVEL RAILS OF BACK FRAME AND SLIDING DOWN. SEE FIGURE 2.
8. PLACE SEAT FRAME ALONG WITH SPACERS BETWEEN BASE AND SECURE WITH (2) SCREWS, USING 6MM HEX BIT AND RATCHET WRENCH. TORQUE SCREWS TO 180-200 IN LBS. SEE FIGURE 1.
9. USING HAMMER, DRIVE PINS INTO BASE THROUGH SEAT BRACKETS. SNAP BUMPERS IN PLACE OVER PINS. SEE FIGURE 1.

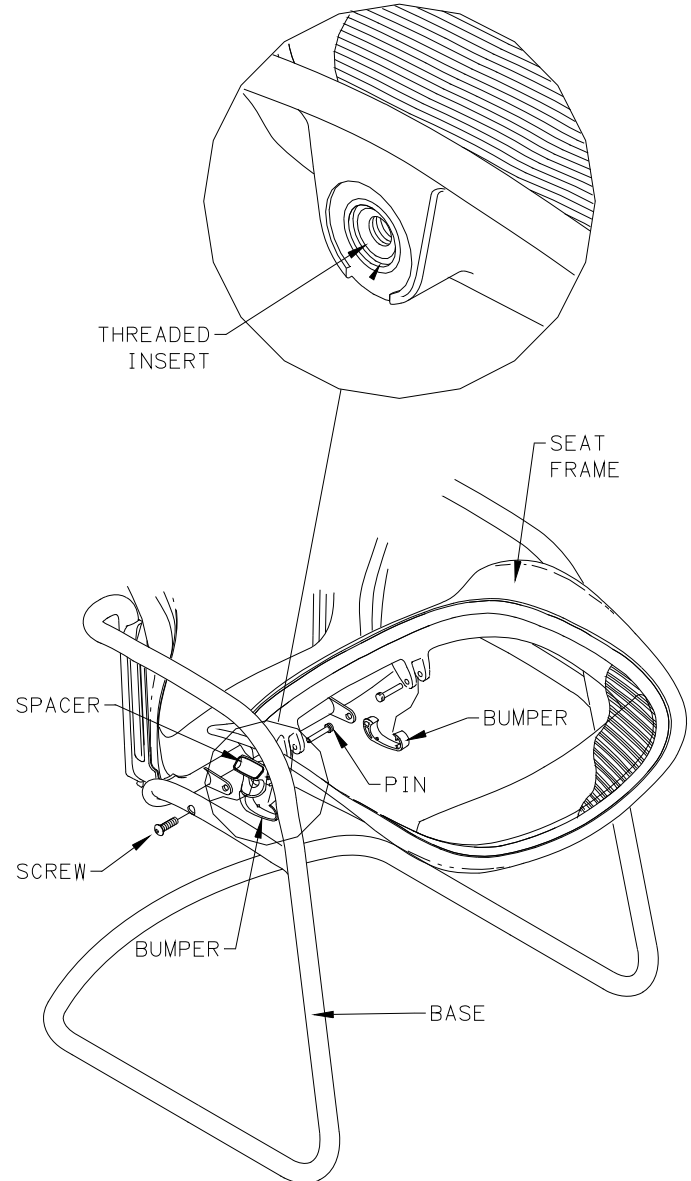


FIGURE 1

179163 REV A

# Aeron® Side Chair Base Replacement

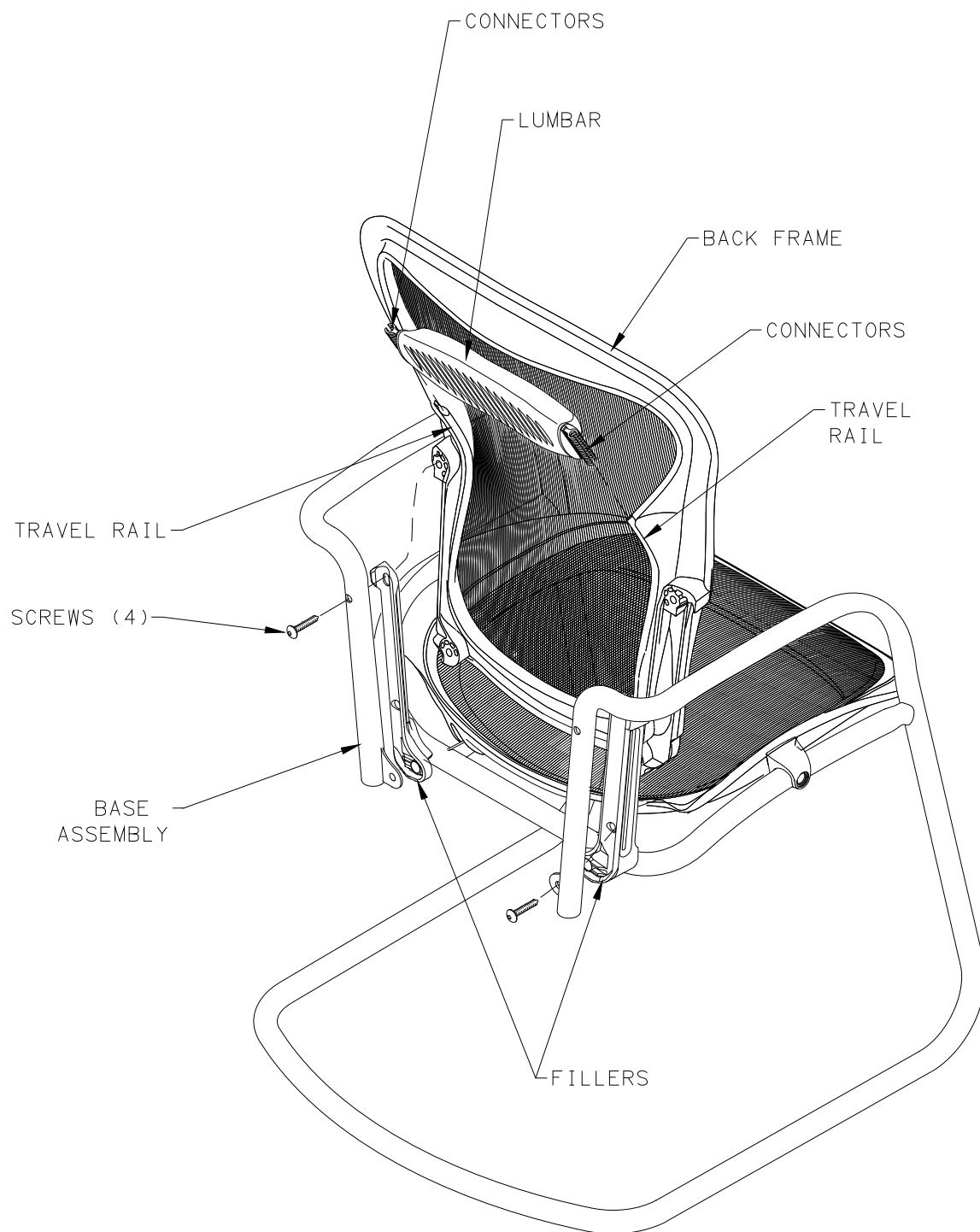


FIGURE 2

179163 REV B

# Aeron® Pneumatic Cartridge Replacement

TOOLS NEEDED: STRAIGHT HEAD SCREWDRIVER  
RETAINING NUT REMOVAL TOOL (OBTAIN FROM  
CUSTOMER SERVICE)  
RATCHET WRENCH

## PROCEDURE:

1. ADJUST SEAT HEIGHT TO LOWEST POSITION.
2. INVERT CHAIR AND PLACE ON CLEAN WORK SURFACE.
3. USING STRAIGHT SLOT SCREWDRIVER REMOVE RETAINER CLIP AND WASHER FROM SHAFT OF PNEUMATIC CARTRIDGE PROTRUDING FROM BASE AND DISCARD. SEE FIGURE 1.
4. REMOVE BASE FROM PNEUMATIC CYLINDER AND SET ASIDE. SEE FIGURE 1.
5. REMOVE BEARING ASSEMBLY AND BUMPER FROM PNEUMATIC CARTRIDGE SHAFT. SEE FIGURE 2.

### DANGER

Pneumatic cartridge is sealed under high pressure. Do not incinerate or crush. More information on disposal procedure can be obtained from: Stabilus

92 County Rd  
Colmar, Pa 18915

Telephone # 215-997-4126

Dispose of Properly

6. INSPECT RETAINER NUT FOR FRACTURES. IF REPLACEMENT IS NEEDED, REMOVE BEARING ASSEMBLY AND BUMPER FROM PNEUMATIC CARTRIDGE SHAFT. USING RETAINER NUT REMOVAL TOOL, REMOVE RETAINER NUT FROM CARRIER TUBE AND DISPOSE OF PROPERLY. DISASSEMBLE PNEUMATIC CARTRIDGE FROM CARRIER TUBE. REMOVE ANY PIECES OF BROKEN RETAINER NUT THAT MAY HAVE REMAINED INSIDE CARRIER TUBE. INSTALL PNEUMATIC CARTRIDGE AND REPLACEMENT RETAINER NUT INTO CARRIER TUBE. DO NOT OVER TIGHTEN RETAINER NUT. RETURN BEARING ASSEMBLY AND BUMPER TO PNEUMATIC CARTRIDGE SHAFT. SEE FIGURE 2.

### CAUTION

Do not overtighten retainer nut. Product damage may result.

7. REMOVE RETAINER CLIP, WASHER, BUMPER AND BEARING ASSEMBLY FROM SHAFT OF REPLACEMENT PNEUMATIC CARTRIDGE AND SET ASIDE. SEE FIGURES 1 & 2.
8. INSERT REPLACEMENT PNEUMATIC CARTRIDGE INTO CARRIER TUBE. SECURE WITH RETAINER NUT. DO NOT OVER TIGHTEN RETAINER NUT. INSTALL BUMPER AND BEARING ASSEMBLY OVER PNEUMATIC CARTRIDGE. SEE FIGURE 2.
9. INSTALL BASE OVER PNEUMATIC CYLINDER. SEE FIGURE 1.

10. PLACE WASHER OVER SHAFT OF PNEUMATIC CARTRIDGE PROTRUDING FROM BASE AND SECURE WITH RETAINER CLIP. SEE FIGURE 1.

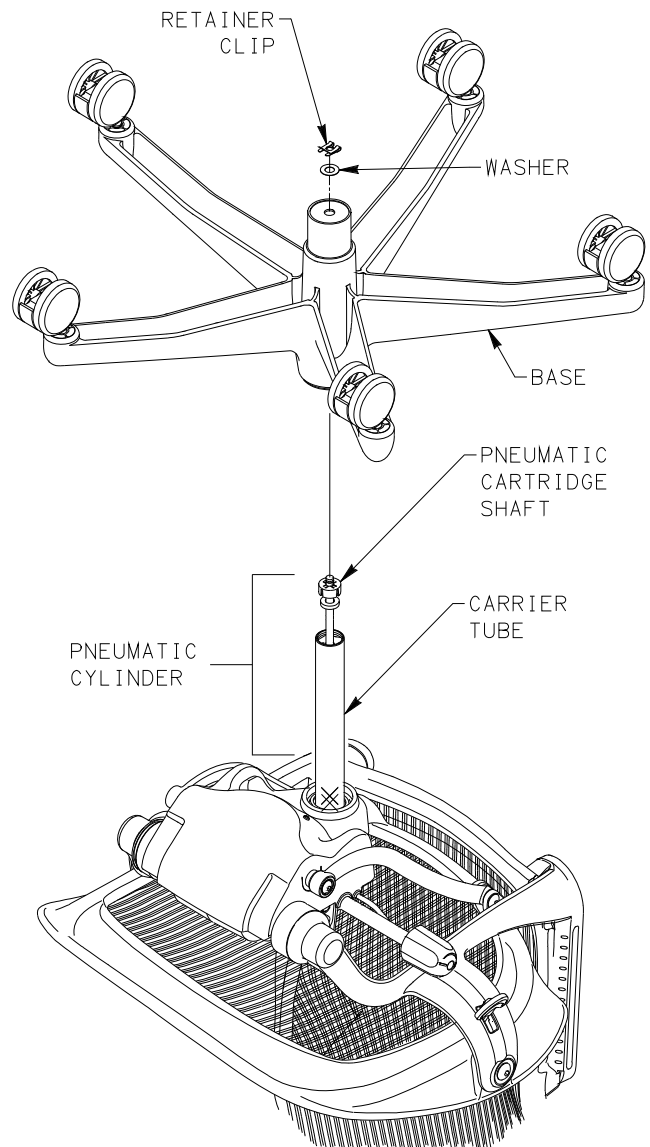


FIGURE 1

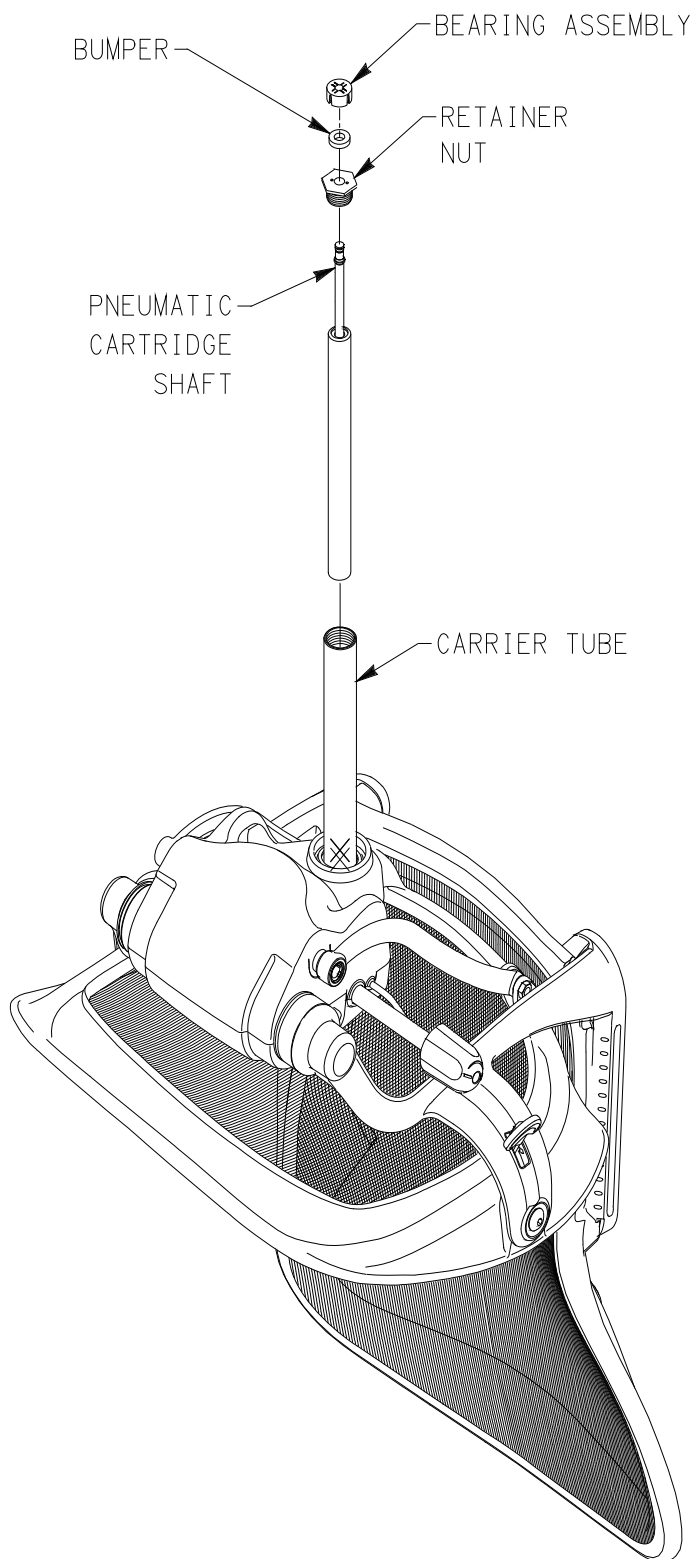


FIGURE 2

# Aeron® Pneumatic Cylinder Replacement

TOOLS NEEDED: RUBBER Mallet  
"LIFT OFF" TOOL  
PNEUMATIC/CYLINDER HUB CUSHION  
STEEL HAMMER

## PROCEDURE:

1. EXTEND CHAIR TO ITS HIGHEST POSITION.
2. INVERT CHAIR AND POSITION ON CLEAN WORK SURFACE.
3. PLACE BASE/CYLINDER KNOCK OFF TOOL OVER CYLINDER HUB. HOLD BASE WITH ONE HAND WHILE HITTING KNOCK OFF TOOL WITH RUBBER Mallet UNTIL DISENGAGING OCCURS. REMOVE BASE AND SET ASIDE. SEE FIGURE 1.
4. PLACE "LIFT OFF" TOOL ON PNEUMATIC CYLINDER BETWEEN ATTACHMENT TO BASE AND TELESCOPING MID SECTION. SECURE TOOL BY WRAPPING RUBBER BAND AROUND CYLINDER AND ATTACH TO HOOK END. SEE FIGURE 1.
5. WITH STEEL HAMMER HIT FLAT AREA OF TOOL UNTIL PNEUMATIC CYLINDER IS DISENGAGED FROM TILT.

## ⚠ DANGER

Pneumatic cartridge is sealed under high pressure. Do not incinerate or crush. More information on disposal procedure can be obtained from: Stabilus

92 County Rd  
Colmar, Pa 18915

Telephone # 215-997-4126

Dispose of Properly

6. PROPERLY DISPOSE OF PNEUMATIC CYLINDER.
7. INSERT REPLACEMENT PNEUMATIC CYLINDER IN TILT. SLIDE ON BASE. RAP ONCE WITH RUBBER Mallet. PLACE CHAIR IN UPRIGHT POSITION AND SIT IN IT TO SEAT TAPERS. SEE FIGURE 1.
8. ADJUST HEIGHT OF CHAIR TO INSURE PNEUMATIC CONTROL IS NOT OUT OF ADJUSTMENT.

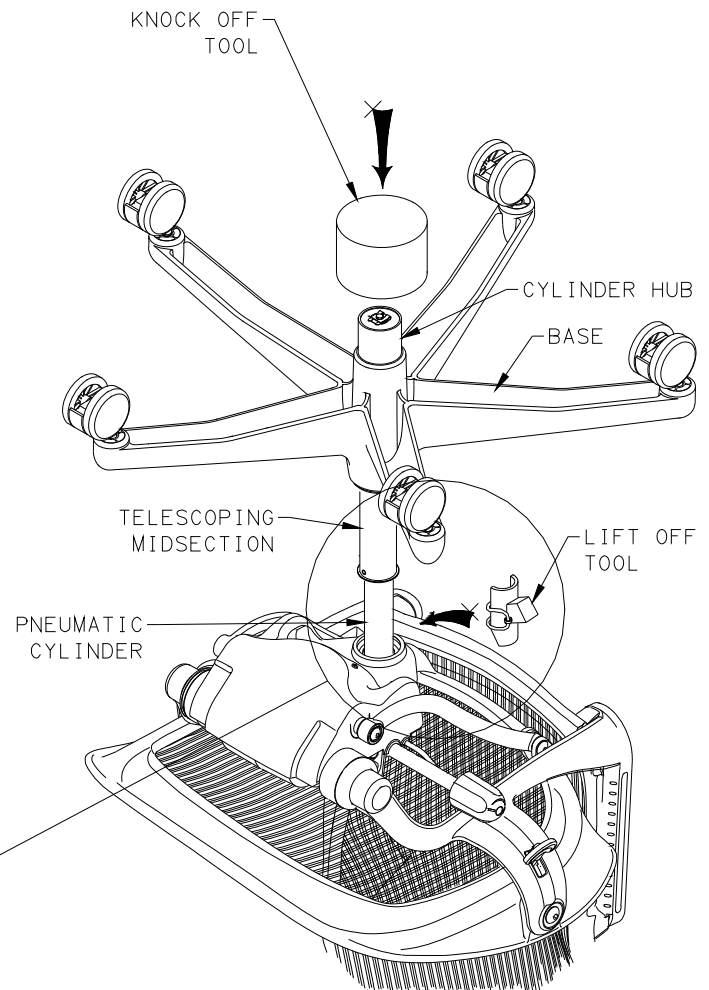
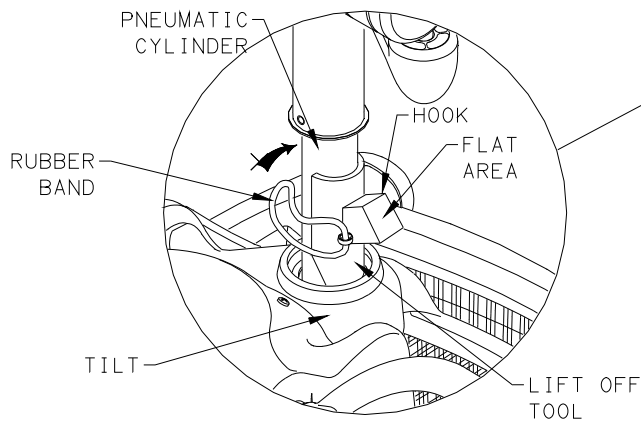


FIGURE 1

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# Aeron® Pneumatic Cable and Controls Replacement (for product before 4-10-02)

TOOLS REQUIRED: 1" PUTTY KNIFE  
PLIERS  
#2 PHILLIPS HEAD SCREWDRIVER  
4MM HEX KEY

## PROCEDURE:

### NOTICE

Before servicing chair, set seat height at mid range for pneumatic actuator adjustment during installation.

1. USING PLIERS, TWIST OFF PNEUMATIC KNOB FROM LEVER OF PNEUMATIC CONTROL. PROPERLY DISPOSE OF PNEUMATIC KNOB. SEE FIGURE 1.
2. USING SCREWDRIVER, REMOVE AND PROPERLY DISPOSE OF (2) SCREWS SECURING PNEUMATIC CONTROL AND COVER TO SWING ARM. PROPERLY DISPOSE OF COVER AND REMOVE PNEUMATIC CONTROL FROM SWING ARM AND LET HANG FREE. SEE FIGURE 2.
3. USING THUMB PRESSURE, PRESS FRONT OF BOTTOM TILT COVER TO START SEPARATION OF TILT COVERS. INSERT 1" PUTTY KNIFE BETWEEN TOP AND BOTTOM COVERS AND TWIST KNIFE TO COMPLETELY SEPARATE TILT COVERS. REMOVE TOP COVER AND SET ASIDE. SEE FIGURES 3 AND 4.
4. USING SCREWDRIVER, REMOVE AND SAVE (2) SCREWS SECURING PNEUMATIC ACTUATOR TO TILT. SEE FIGURE 5.
5. DEPRESS LEVER ON PNEUMATIC ACTUATOR AND DISENGAGE CABLE END FROM ACTUATOR LEVER. SEE FIGURE 5.
6. USING PLIERS, REMOVE CABLE FITTING FROM PNEUMATIC ACTUATOR. FEED CABLE END THROUGH CABLE ACCESS HOLE. REMOVE CABLE AND PNEUMATIC CONTROL AND DISPOSE OF PROPERLY. SEE FIGURE 5.

### NOTICE

Keep pneumatic control placed in swing arm with hand pressure until cover is in place and secure.

7. INSTALL PNEUMATIC CONTROL TO SWING ARM. WHILE KEEPING HAND PRESSURE ON PNEUMATIC CONTROL, INSTALL COVER AND SECURE WITH (2) SCREWS. SEE FIGURE 2.
8. PUSH REPLACEMENT PNEUMATIC KNOB ONTO LEVER UNTIL IT IS FELT TO LOCK IN PLACE. SEE FIGURE 7.
9. FEED CABLE THROUGH CABLE ACCESS HOLE IN RIGHT SIDE OF TILT AND SNAP CABLE FITTING INTO PNEUMATIC ACTUATOR. SEE FIGURE 5.
10. DEPRESS ACTUATOR LEVER AND WRAP CABLE, WITH SLEEVE, AROUND TRAVEL GUIDE. INSERT CABLE END INTO SLOT IN ACTUATOR LEVER WHILE POSITIONING SLEEVE INTO TRAVEL GUIDE. PRESS LOWER END OF SLEEVE SECURELY UNDER TAB ON TRAVEL GUIDE. RELEASE LEVER TO SECURE CABLE END TO LEVER. SEE FIGURE 5.

NOTE: BEFORE REINSTALLING PNEUMATIC ACTUATOR TO TILT, ROTATE SET SCREW COUNTERCLOCKWISE UNTIL IT IS FLUSH WITH UNDERSIDE OF ACTUATOR LEVER. SEE FIGURE 6.

11. REPOSITION PNEUMATIC ACTUATOR OVER MOUNTING HOLES IN TILT. REINSTALL AND TIGHTEN (2) SCREWS SECURING ACTUATOR. SEE FIGURE 3.
12. USING 4 MM HEX KEY, ROTATE SET SCREW CLOCKWISE UNTIL PNEUMATIC CYLINDER (AT MID RANGE POSITION) ACTIVATES, THEN ROTATE SET SCREW COUNTERCLOCKWISE 1 1/4 TURN. SEE FIGURE 6.

### CAUTION

Check to ensure all cables are routed through cable openings before assembling tilt cover halves. Failure to comply may cause product damage.

13. REPOSITION TOP TILT COVER OVER BOTTOM TILT COVER. MAKING SURE ALL CABLES ARE PROPERLY ROUTED THROUGH CABLE OPENINGS, SNAP COVER HALVES TOGETHER. SEE FIGURE 4.

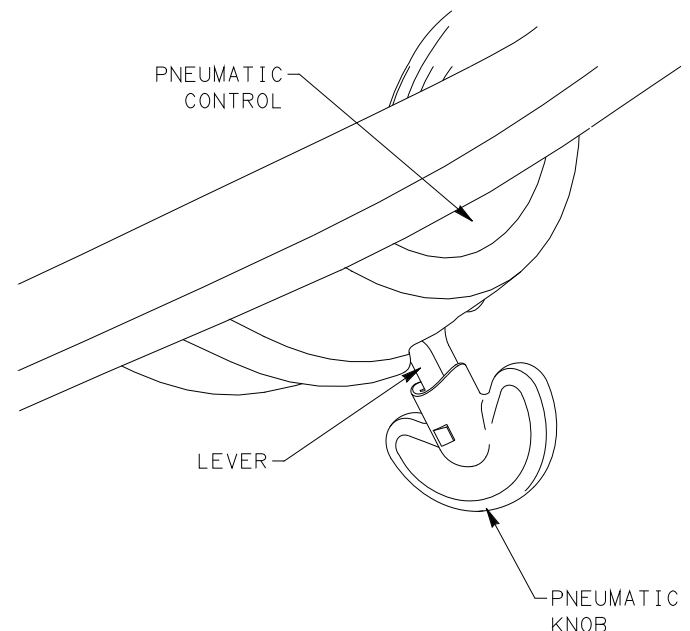


FIGURE 1

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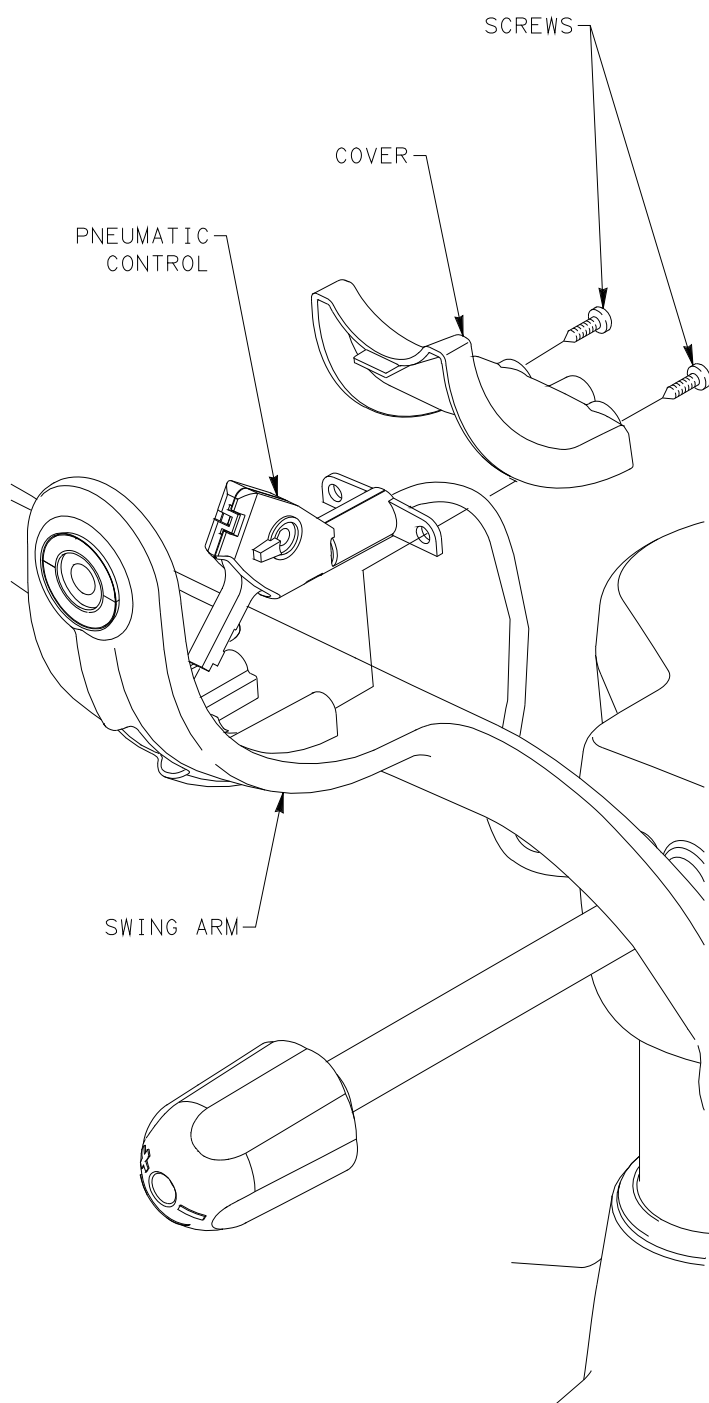


FIGURE 2

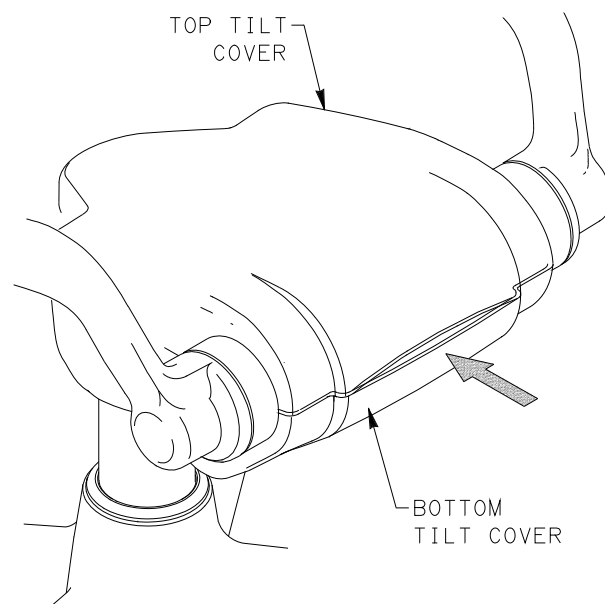


FIGURE 3

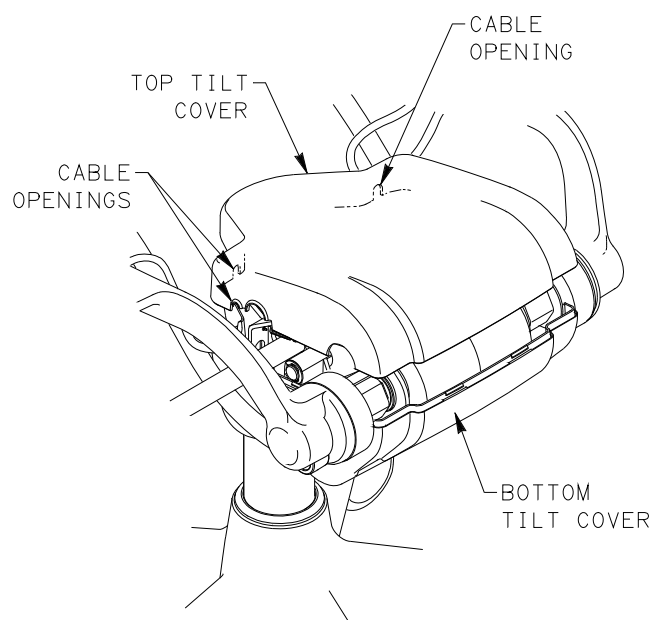


FIGURE 4

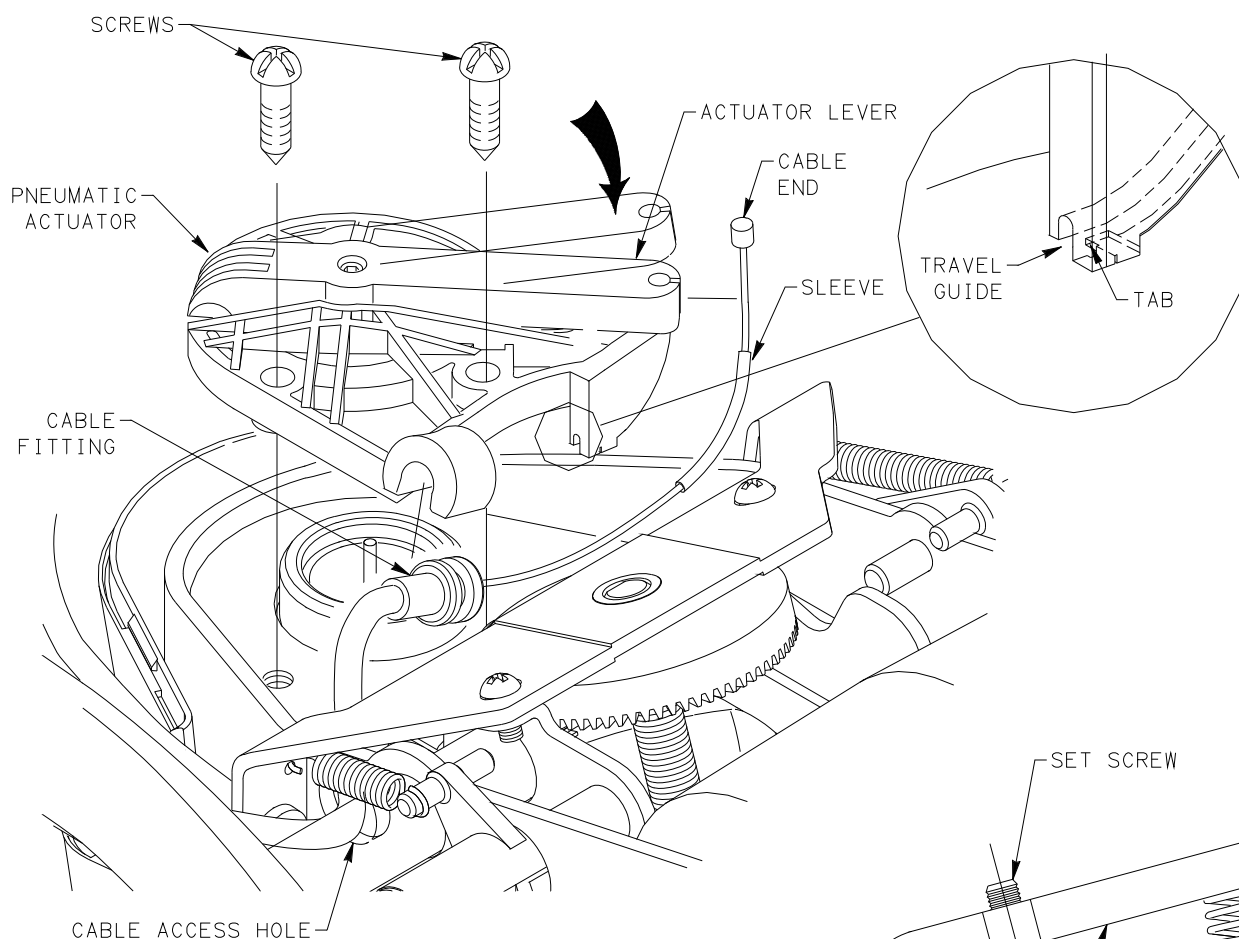


FIGURE 5

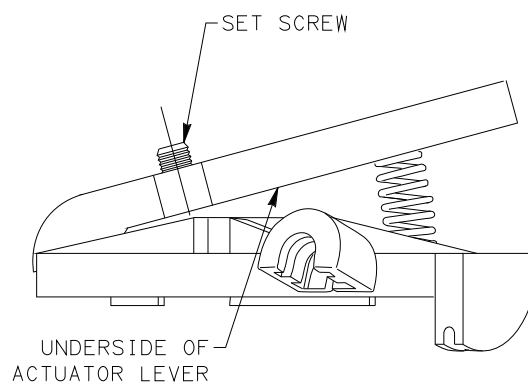


FIGURE 6

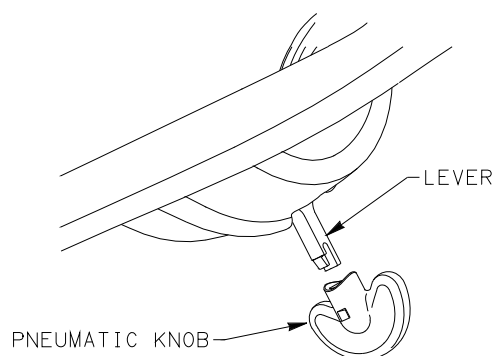
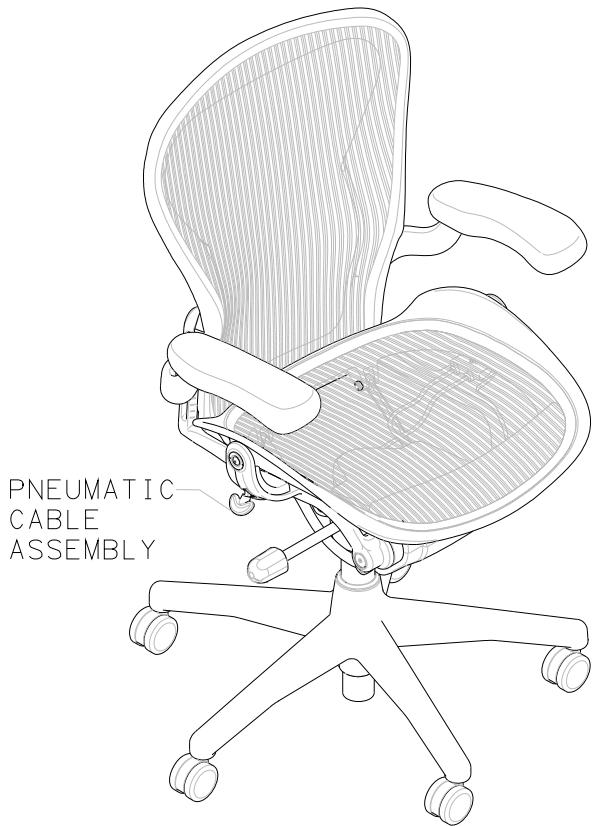


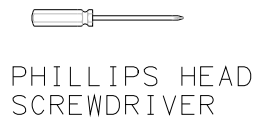
FIGURE 7

167205 REV C

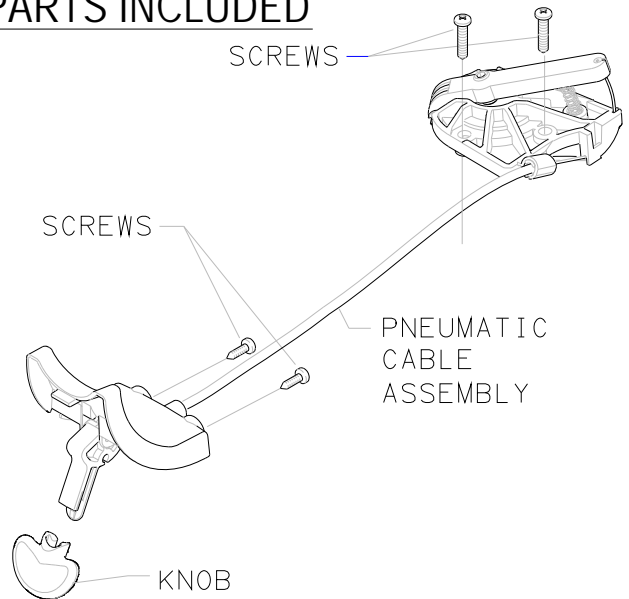
# Aeron® Pneumatic Cable Assembly Replacement



## TOOLS NEEDED

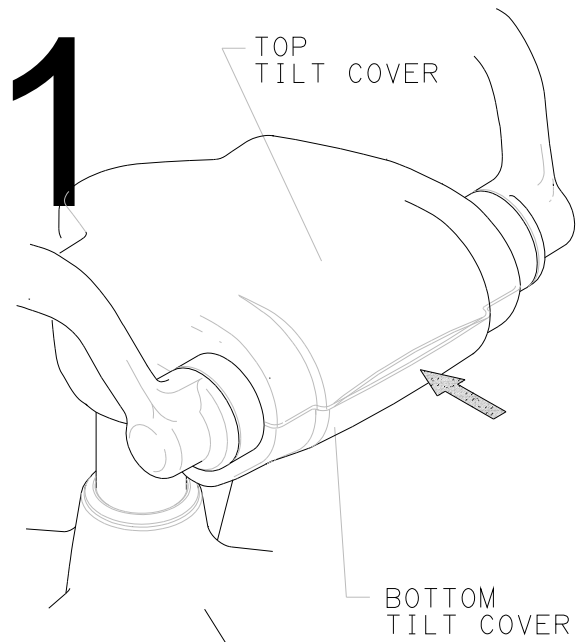


## PARTS INCLUDED



## PROCEDURE

NOTE: IF REFERENCING THIS INSTRUCTION SHEET FOR PNEUMATIC KNOB REPLACEMENT, REFER TO STEPS 4 & 6.



TO REMOVE :

1. USING THUMB PRESSURE, PRESS FRONT OF BOTTOM TILT COVER TO START SEPARATION OF TILT COVERS.

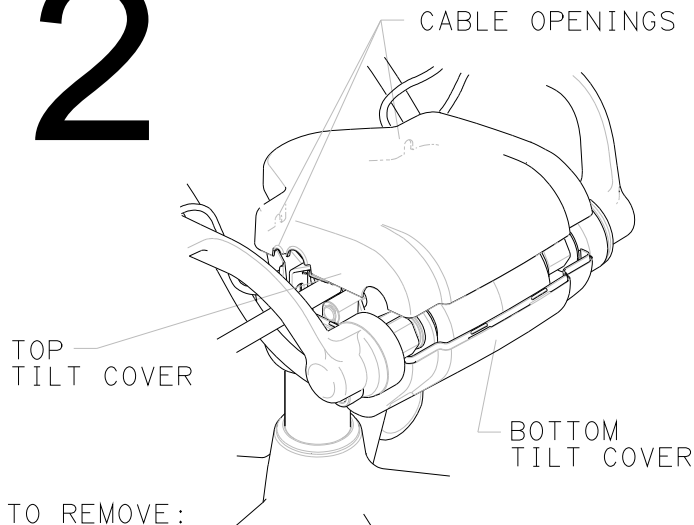
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# Aeron® Pneumatic Cable Assembly Replacement

## 2



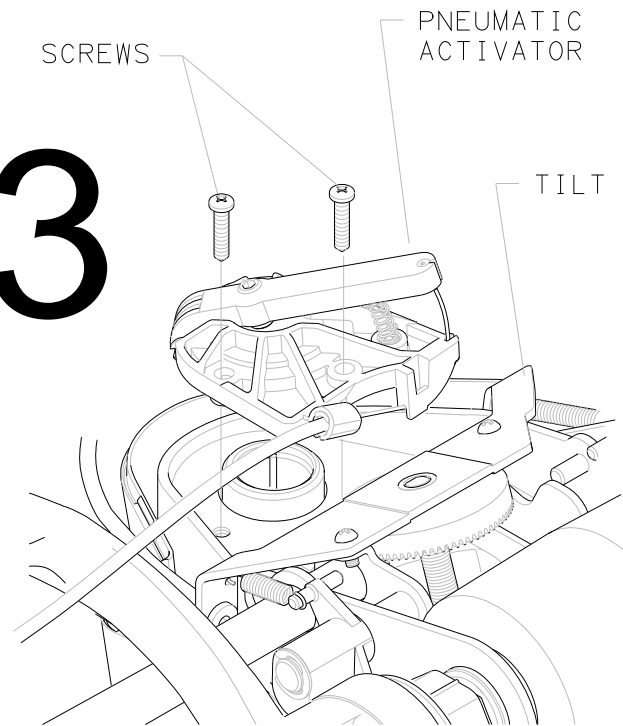
TO REMOVE :

1. INSERT 1" PUTTY KNIFE BETWEEN COVERS AND TWIST TO SEPERATE TOP FROM BOTTOM COVER. REMOVE TOP COVER AND SET ASIDE.

TO REINSTALL :

1. REPOSITION TOP TILT COVER OVER BOTTOM TILT COVER, MAKING SURE ALL CABLES ARE PROPERLY ROUTED THROUGH CABLE OPENINGS. SNAP COVER HALVES TOGETHER.

## 3



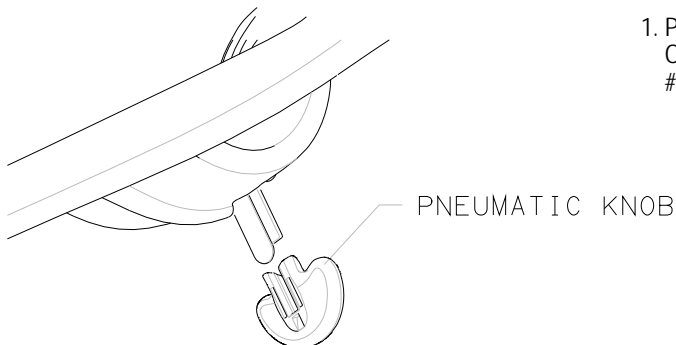
TO REMOVE :

1. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND DISCARD (2) SCREWS SECURING PNEUMATIC ACTUATOR TO TILT.

TO REINSTALL :

1. PLACE ACTUATOR END OF PNEUMATIC CABLE ASSEMBLY ON TOP OF TILT. SECURE WITH SCREWS PROVIDED USING #2 PHILLIPS HEAD SCREWDRIVER.

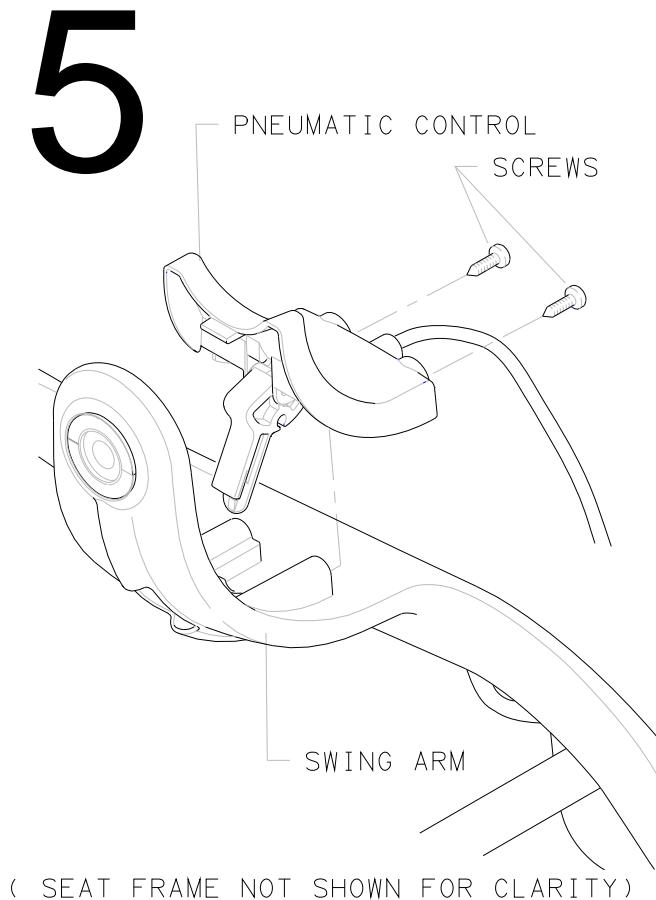
## 4



TO REMOVE :

1. USING PLIERS, PULL PNEUMATIC KNOB FROM CHAIR. PROPERLY DISPOSE OF PNEUMATIC KNOB.

# Aeron® Pneumatic Cable Assembly Replacement

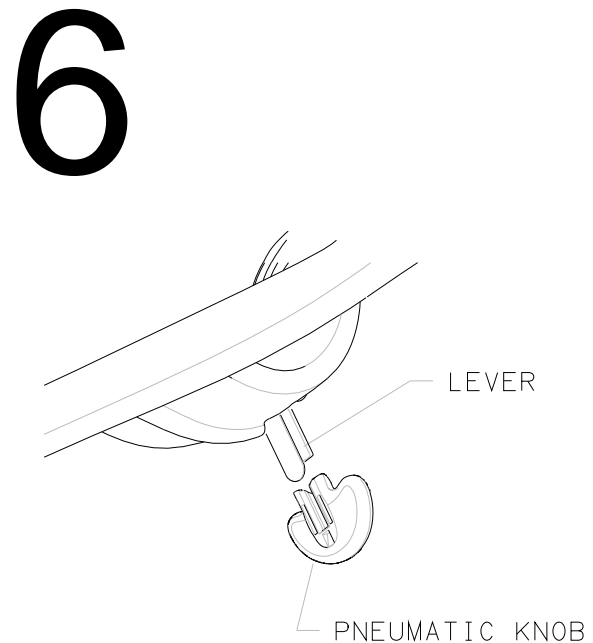


## TO REMOVE :

1. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND DISCARD (2) SCREWS SECURING PNEUMATIC CONTROL END TO SWING ARM.
2. REMOVE PNEUMATIC CABLE ASSEMBLY FROM CHAIR AND DISPOSE OF PROPERLY.

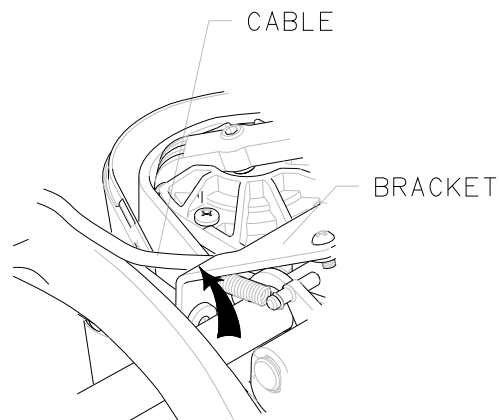
## TO REINSTALL :

1. ROUTE CABLE FROM TILT AS SHOWN, BEHIND BRACKET, AND INSERT PNEUMATIC CONTROL END INTO SWING ARM. SECURE WITH (2) SCREWS PROVIDED USING #2 PHILLIPS HEAD SCREWDRIVER.



## TO REINSTALL :

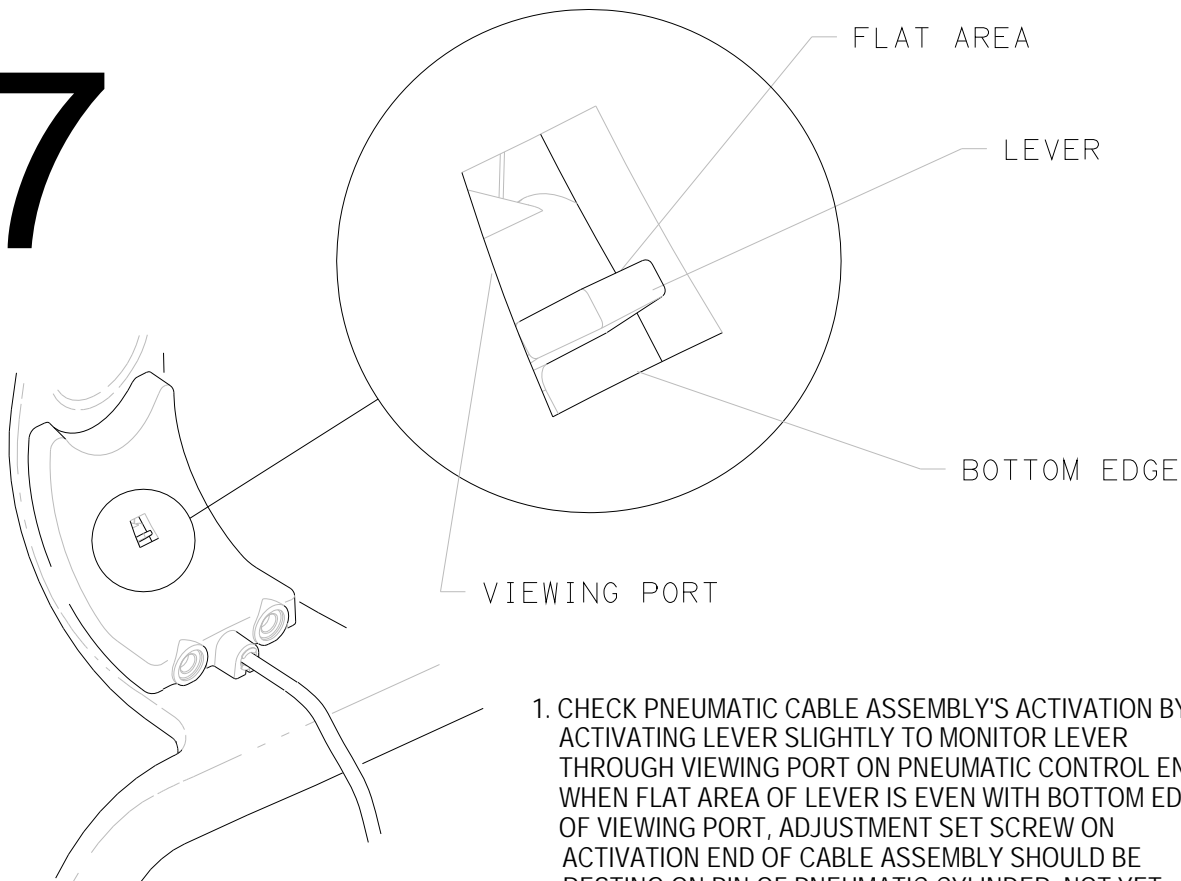
1. INSERT NEW KNOB ON LEVER. PUSH UNTIL IT "SNAPS" INTO PLACE.



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# Aeron® Pneumatic Cable Assembly Replacement

# 7



1. CHECK PNEUMATIC CABLE ASSEMBLY'S ACTIVATION BY ACTIVATING LEVER SLIGHTLY TO MONITOR LEVER THROUGH VIEWING PORT ON PNEUMATIC CONTROL END. WHEN FLAT AREA OF LEVER IS EVEN WITH BOTTOM EDGE OF VIEWING PORT, ADJUSTMENT SET SCREW ON ACTIVATION END OF CABLE ASSEMBLY SHOULD BE RESTING ON PIN OF PNEUMATIC CYLINDER, NOT YET ACTIVATED. ADJUST SET SCREW USING 4MM HEX KEY UNTIL THIS IS ACHIEVED.



# Aeron® Left Swing Arm Replacement

TOOLS REQUIRED: 10MM SOCKET  
RATCHET WRENCH  
4MM HEX KEY  
6MM HEX BIT  
5MM HEX BIT  
STRAIGHT HEAD SCREWDRIVER  
PLIERS  
#2 PHILLIPS HEAD SCREWDRIVER  
T-27 TORX BIT  
T-40 TORX BIT  
TORQUE WRENCH, 200 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### CAUTION

Support seat link while removing rear end of seat link from seat frame. Failure to do so could cause seat link to fall causing product damage.

1. WHILE SUPPORTING SEAT LINK, USE 10MM SOCKET, RATCHET WRENCH AND 4MM HEX KEY TO REMOVE NUT AND SCREW ATTACHING SEAT LINK TO SEAT FRAME. NOTE: OLDER CHAIRS HAVE SPACER AND BUSHINGS. REMOVE AND SET ASIDE. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 AND 2.

### CAUTION

If threaded inserts turn while removing screws from seat frame, STOP IMMEDIATELY and follow instructions.

2. TO REMOVE SEAT FRAME, FOLLOW APPROPRIATE PROCEDURE BELOW:

-USE RATCHET WRENCH AND 6MM HEX BIT TO REMOVE SCREW FROM SWING ARM. IF THREADED INSERT TURNS WITH SCREW, STOP IMMEDIATELY AND DO FOLLOWING STEP: TIGHTEN SCREWS INTO THREADED INSERT AS MUCH AS POSSIBLE. USING QUICK JERKING MOTION WITH RATCHET WRENCH, BACKOUT SCREW FROM THREADED INSERT. IF THREADED INSERT STILL TURNS WITH SCREW, REPEAT PROCESS. SEE FIGURE 3.

### WARNING

Support back frame while removing from swing arms. Failure to do so could allow back frame to fall causing product damage or personal injury.

3. WHILE SUPPORTING BACK FRAME, USE RATCHET WRENCH AND 5MM HEX BIT TO REMOVE AND SET ASIDE (4) SCREWS ATTACHING BACK FRAME TO SWING ARMS. REMOVE BACK FRAME AND SET ASIDE. SEE FIGURE 4.

### NOTICE

On adjustable arms, keep thumbwheel from spinning while disassembling.

### CAUTION

Support arm yoke while removing from swing arm. Failure to do so could cause product damage.

4. FOR ARM OPTION REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:

-ADJUSTABLE ARMS: WHILE SUPPORTING ARM YOKE AND HOLDING THUMBWHEEL USE RATCHET WRENCH AND T-27 TORX BIT TO REMOVE ARM YOKE. SET ASIDE THUMBWHEEL SCREW ASSEMBLY. SET ASIDE ARM YOKE WITH RELATED HARDWARE. NOTE: OLDER CHAIRS HAVE SPRING AND SPRING RETAINER. REMOVE AND DISPOSE OF PROPERLY. SEE FIGURE 5.

-FIXED ARMS: WHILE SUPPORTING ARM YOKE USE RATCHET WRENCH AND T-27 TORX BIT TO REMOVE ARM YOKE. SET ASIDE ARM YOKE, TORX HEAD SCREW AND RETAINING PLATE. USING STRAIGHT HEAD SCREWDRIVER PUSH OUT FILLER LOCATOR AND SET ASIDE. SEE FIGURE 7.

-NO ARM FILLERS: USING STRAIGHT HEAD SCREWDRIVER PUSH OUT NO ARM FILLER FROM SWING ARM AND SET ASIDE. SEE FIGURE 8.

### CAUTION

When removing screw holding tilt control to swing arm, isolate from other hardware. Failure to use same screw in same location will cause product damage.

5. IF CHAIR IS MANUFACTURED WITH BASIC TILT OPTION, PROCEED TO STEP 6. USING PLIERS, TWIST OFF APPROPRIATE TILT KNOB(S) FROM LEVER(S) OF TILT CONTROL. SEE FIGURE 9.
6. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SET ASIDE SCREW FASTENING TILT CONTROL OR TILT CONTROL COVER (BASIC TILT OPTION) TO SWING ARM. REMOVE TILT CONTROL AND LET HANG. IF CHAIR WAS EQUIPPED WITH BASIC TILT OPTION, SET TILT CONTROL COVER ASIDE. SEE FIGURE 10.
7. FOR SWING ARM REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:
  - CHAIRS MANUFACTURED BEFORE 9/16/96: USING T-40 TORX BIT AND RATCHET WRENCH, REMOVE CAP SCREW. REMOVE SWING ARM. PROPERLY DISPOSE OF SWING ARM AND CAP SCREW. SEE FIGURE 11.
  - CHAIRS MANUFACTURED AFTER 9-16-96: SLIDE SWING ARM FROM TILT AND DISPOSE OF PROPERLY. SEE FIGURE 12.
8. SLIDE REPLACEMENT SWING ARM ONTO HEX BAR, UP TO TILT SPACER, KEEPING SAME ORIENTATION TO HEX BAR AS OPPOSITE SWING ARM. SEE FIGURE 12.
9. IF CHAIR IS MANUFACTURED WITH BASIC TILT OPTION, PROCEED TO STEP 14. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SET ASIDE (2) SCREWS FASTENING TILT CONTROL COVER TO TILT CONTROL HOUSING. SET ASIDE TILT CONTROL COVER. SEE FIGURE 13.

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10. REMOVE TILT LIMITER LEVER ASSEMBLY FROM TILT CONTROL HOUSING. IF CHAIR IS MANUFACTURED WITH FORWARD TILT OPTION, REMOVE FORWARD TILT LEVER ASSEMBLY FROM TILT CONTROL HOUSING. SEE FIGURE 14.
11. REMOVE AND SET ASIDE PAD AND SPRING FROM LEVER. REMOVE CABLE FROM LEVER. PROPERLY DISPOSE OF LEVER. SEE FIGURE 15.
12. INSTALL REPLACEMENT LEVER INTO TILT CONTROL HOUSING USED FOR TILT LIMITER CONTROL. SLIDE CABLE COUPLING INTO TILT CONTROL HOUSING AND SLIDE CABLE INTO LEVER. INSERT SPRING OVER CABLE INTO CAVITY OF LEVER. PLACE PAD OVER SPRING. REPEAT PROCEDURE IF CHAIR WAS MANUFACTURED WITH FORWARD TILT OPTION. SEE FIGURE 15.
13. INSTALL TILT CONTROL COVER TO TILT CONTROL HOUSING AND SECURE WITH (2) SCREWS. SEE FIGURE 13.
14. INSTALL TILT CONTROL ONTO SWING ARM AND SECURE WITH SCREW. IF CHAIR IS EQUIPPED WITH BASIC TILT, INSTALL TILT CONTROL COVER AND PROCEED TO STEP 16. SEE FIGURE 10.
15. PUSH APPROPRIATE REPLACEMENT CONTROL KNOB(S) ONTO APPROPRIATE LEVER(S) OF TILT CONTROL UNTIL "CLICK" IS HEARD, INDICATING KNOB HAS LOCKED IN PLACE. SEE FIGURE 16.

#### NOTICE

On chairs with adjustable arms: Hold thumbwheel tight against inner wall of thumbwheel slot in arm yoke, closest to swing arm, while tightening Torx head screw.

16. FOR ARM OPTION INSTALLATION, FOLLOW APPROPRIATE PROCEDURE FROM BELOW:
  - ADJUSTABLE ARMS: INSERT JAMNUT, WASHER, BEARING AND THUMBWHEEL INTO ARM YOKE. KEEPING THUMBWHEEL IN PLACE IN THUMBWHEEL SLOT, INSTALL OUTER SLIDE BEARING TO END OF ARM YOKE AND POSITION ARM YOKE TO SWING ARM. INSTALL THUMBWHEEL SCREW ASSEMBLY TO ARM YOKE MAKING SURE THUMBWHEEL IS TIGHT AGAINST INNER WALL OF THUMBWHEEL SLOT. TIGHTEN TORX HEAD SCREW UNTIL ARM HOLDS POSITIONED HEIGHT. SEE FIGURES 5 AND 6.
  - FIXED ARM: NOTE ARROW INDICATING TOP OF FILLER LOCATOR PRIOR TO INSTALLATION TO SWING ARM. INSERT FILLER LOCATOR INTO SWING ARM AND SNAP INTO PLACE. POSITION ARM YOKE ON SWING ARM ENGAGING ARM YOKE WITH FILLER LOCATOR. INSTALL TORX HEAD SCREW AND RETAINING PLATE INTO ARM YOKE. TIGHTEN AND TORQUE SCREW TO 100-125 IN-LBS. SEE FIGURE 7.
  - NO ARM FILLER: NOTE ARROW INDICATING TOP OF NO ARM FILLER PRIOR TO INSTALLATION TO SWING ARM. INSERT NO ARM FILLER INTO SWING ARM UNTIL SNAPPED INTO PLACE. SEE FIGURE 8.
17. PLACE BACK FRAME AGAINST SWING ARMS ALIGNING HOLES. SECURE WITH SCREWS. TIGHTEN AND TORQUE SCREWS TO 70-100 IN-LB. SEE FIGURE 4.

18. PLACE SEAT FRAME BETWEEN SWING ARMS ALIGNING HOLES. SECURE SEAT TO SWING ARMS WITH HIP PIVOT SCREWS. TIGHTEN AND TORQUE TO 180-200 IN-LB. SEE FIGURE 3.

#### NOTICE

Older chairs have bushings and spacer which may have become dislodged from seat link while chair was serviced. Check unattached seat link ends to account for spacer, bushings and proper orientation of bushings before attaching to seat frame. Hold bushings in seat link while attaching to seat frame.

19. ATTACH SEAT LINK TO SEAT FRAME WITH SCREW AND NUT. TIGHTEN NUT UNTIL FLUSH WITH END OF SCREW. REPEAT FOR OPPOSITE SIDE. NOTE: SEAT LINKS IN OLDER CHAIRS HAVE SPACER AND BUSHINGS. MAKE CERTAIN SPACER AND ALL BUSHINGS ARE ACCOUNTED FOR AND BUSHES ARE ORIENTED TO NOTCH IN SEAT LINK. WHILE HOLDING BUSHINGS IN SEAT LINK, ATTACH SEAT LINK TO SEAT FRAME WITH SCREW, SPACER AND NUT. TIGHTEN NUT UNTIL FLUSH WITH END OF SCREW. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 AND 2.

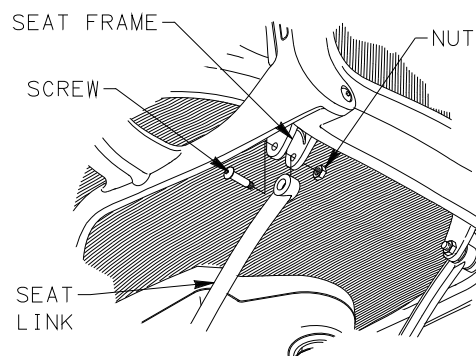


FIGURE 1  
(VIEWING FROM UNDERSIDE)

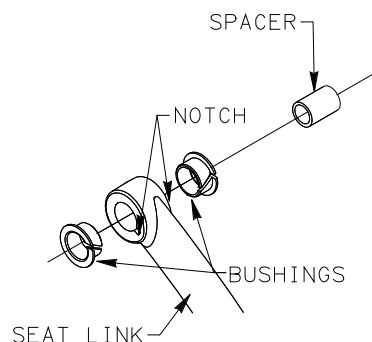


FIGURE 2  
(OLDER CHAIRS)



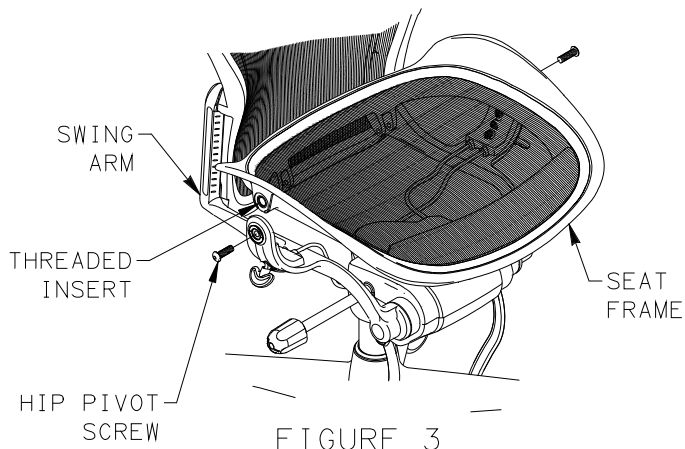


FIGURE 3

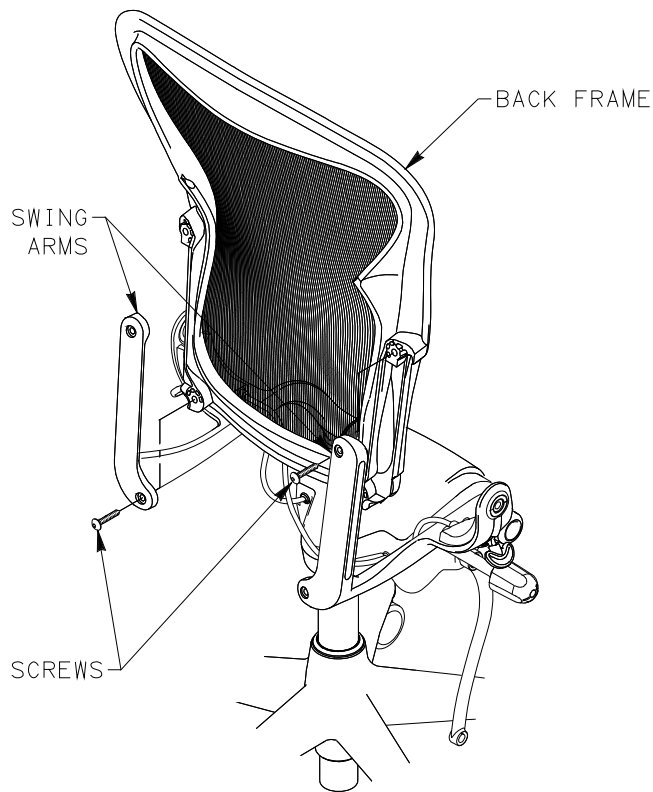
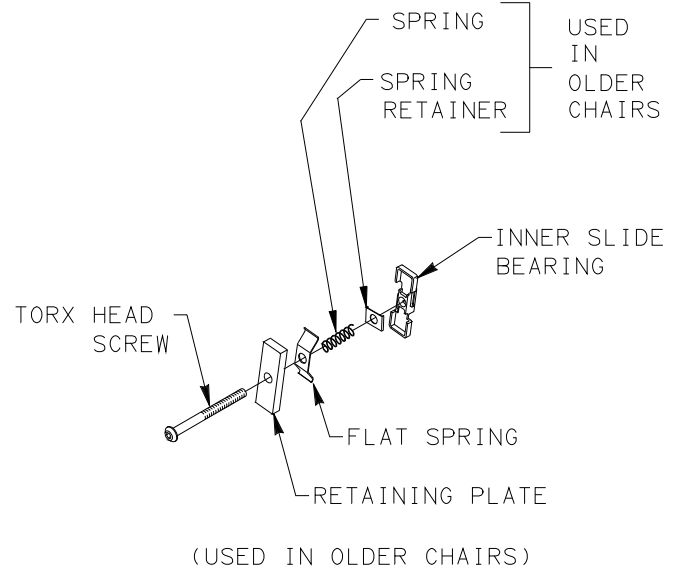


FIGURE 4

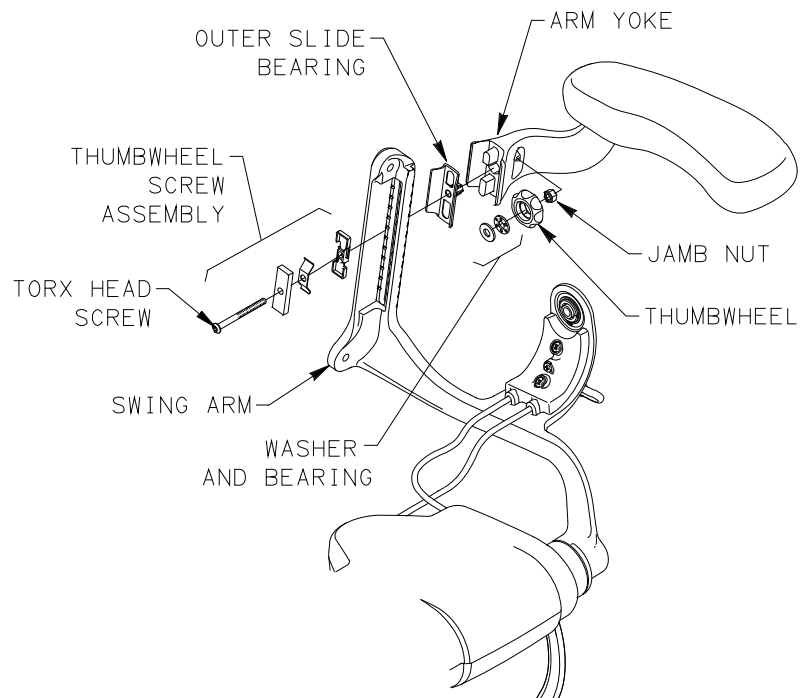
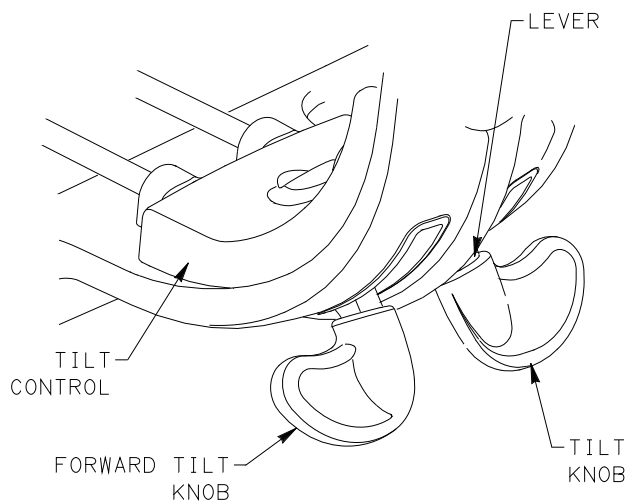
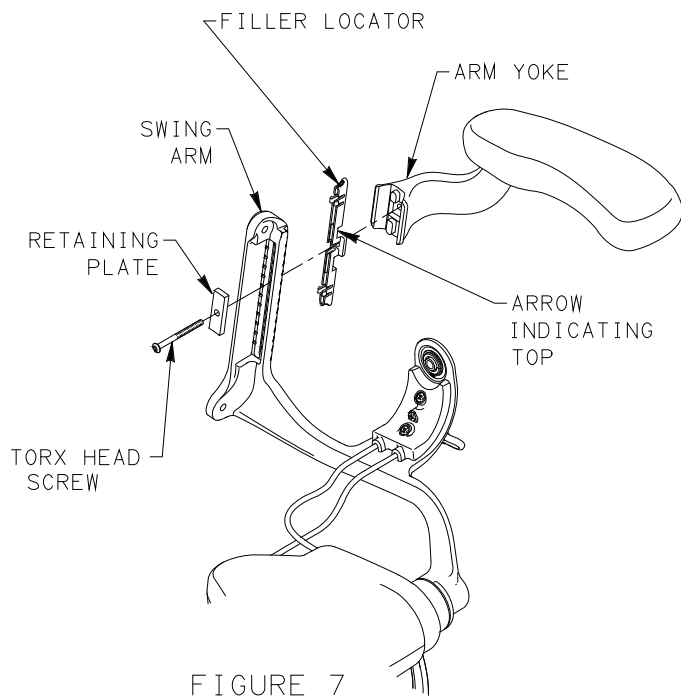
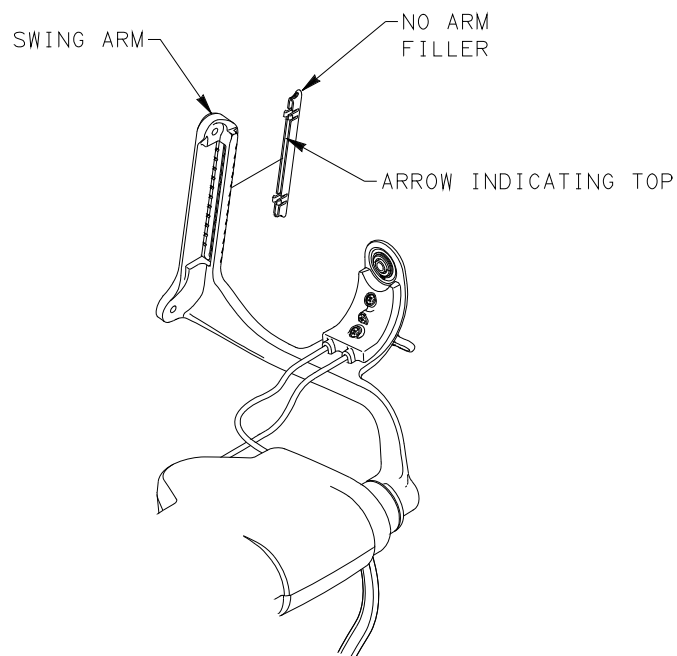
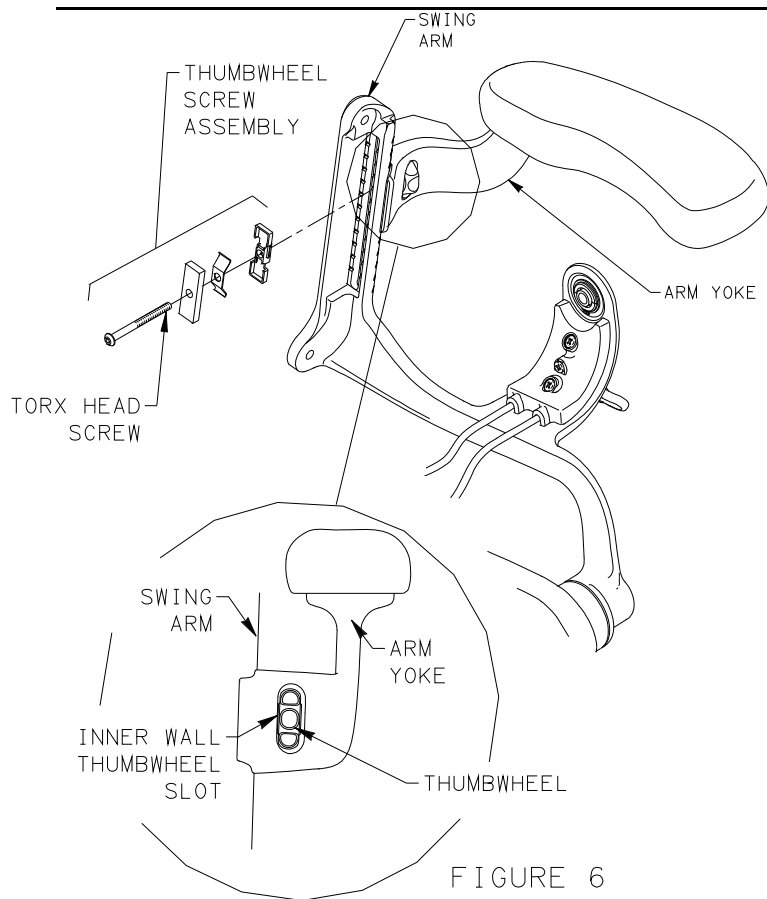


FIGURE 5



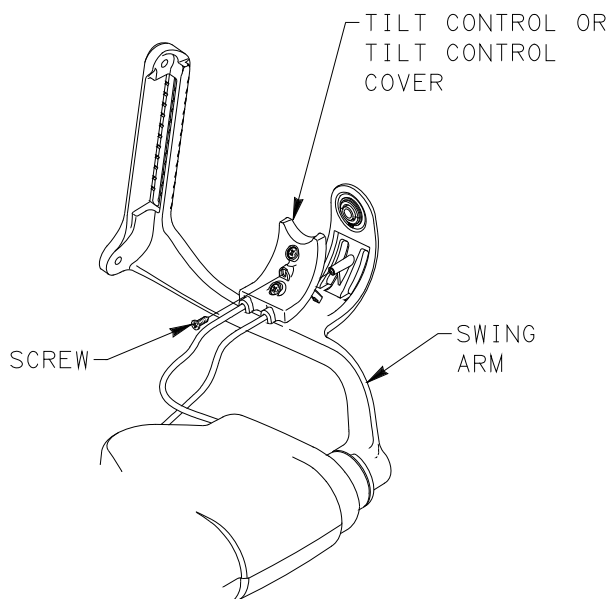


FIGURE 10

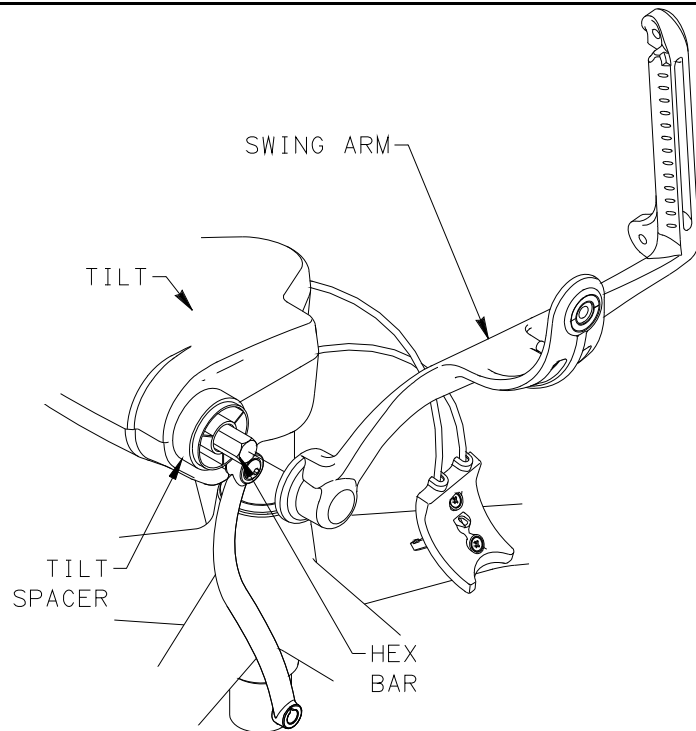


FIGURE 12

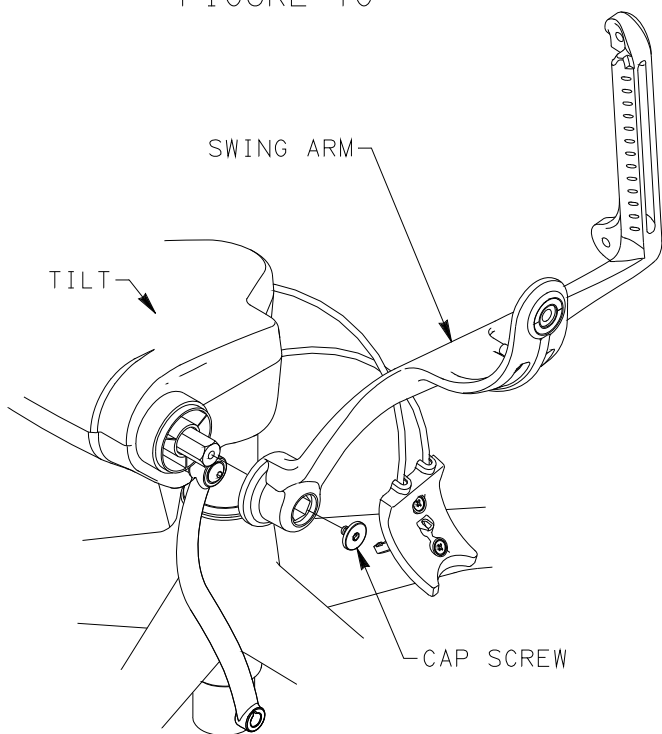


FIGURE 11

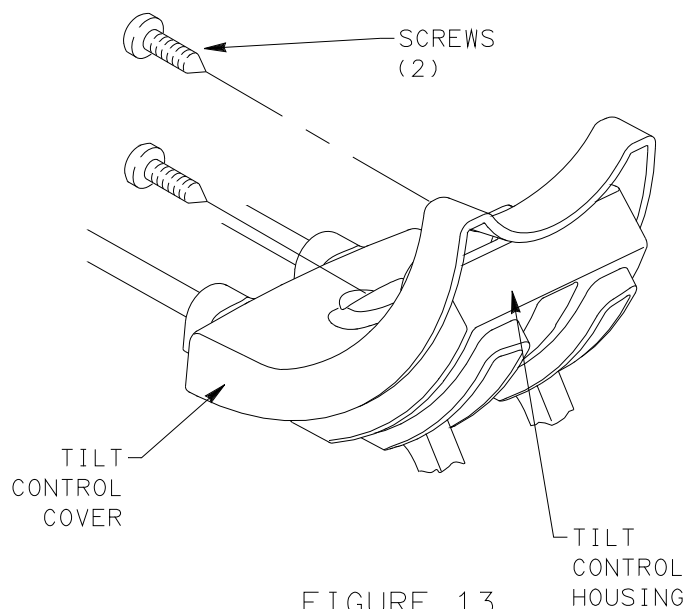


FIGURE 13

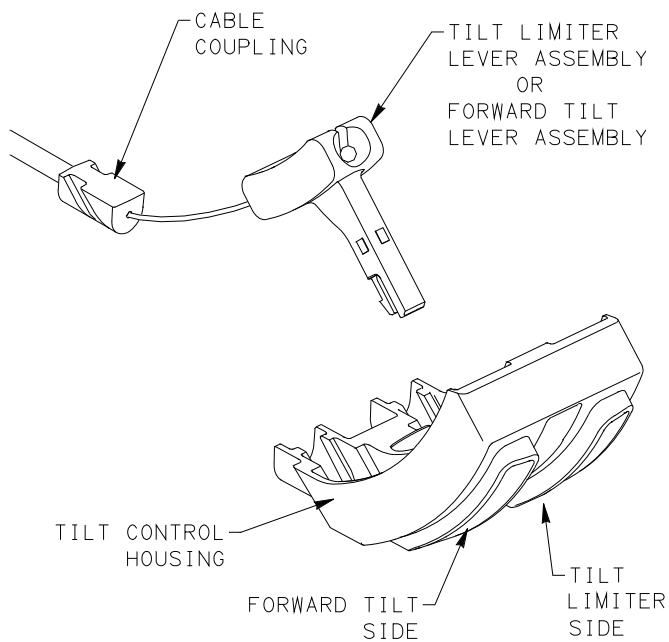


FIGURE 14

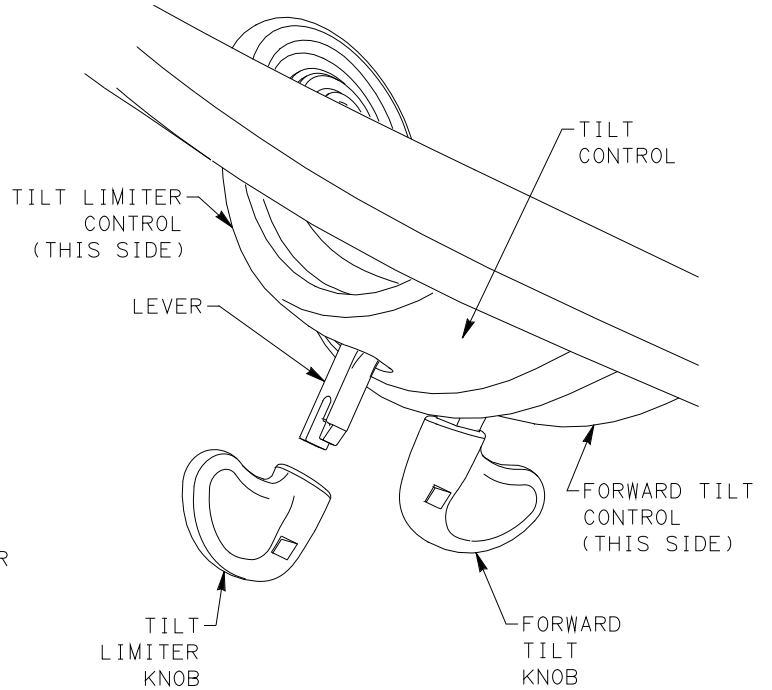


FIGURE 16

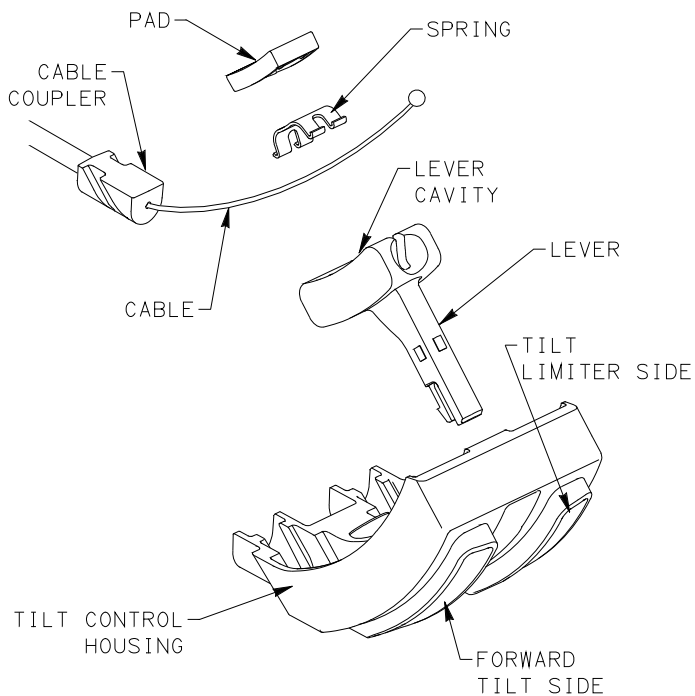


FIGURE 15

# Aeron® Right Swing Arm Replacement

TOOLS REQUIRED: 10MM SOCKET  
RATCHET WRENCH  
4MM HEX KEY  
6MM HEX BIT  
5MM HEX BIT  
STRAIGHT HEAD SCREWDRIVER  
PLIERS  
#2 PHILLIPS HEAD SCREWDRIVER  
T-27 TORX BIT  
T-40 TORX BIT  
TORQUE WRENCH, 200 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Fasteners must be torqued to specified values.

### CAUTION

Support seat link while removing rear end of seat link from seat frame. Failure to do so could cause seat link to fall causing product damage.

1. WHILE SUPPORTING SEAT LINK USE 10MM SOCKET, RATCHET WRENCH AND 4MM HEX KEY TO REMOVE NUT AND SCREW ATTACHING SEAT LINK TO SEAT FRAME. NOTE: OLDER CHAIRS HAVE SPACER AND BUSHINGS. SET ASIDE HARDWARE. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 AND 2.

### CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame, STOP IMMEDIATELY and follow instructions.

2. TO REMOVE SEAT FRAME, FOLLOW APPROPRIATE PROCEDURE BELOW:  
  
-USE RATCHET WRENCH AND 6MM HEX BIT TO REMOVE HIP PIVOT SCREW FROM EACH SWING ARM. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, STOP IMMEDIATELY AND DO THE FOLLOWING STEP: TIGHTEN HIP PIVOT SCREW INTO THREADED INSERT AS MUCH AS POSSIBLE. USING QUICK JERKING MOTION WITH RATCHET WRENCH, BACK OUT HIP PIVOT SCREW FROM THREADED INSERT. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, REPEAT PROCESS. SEE FIGURE 3.

### WARNING

Support back frame while removing from swing arms. Failure to do so could allow back frame to fall, causing product damage or personal injury.

3. WHILE SUPPORTING BACK FRAME, USE RATCHET WRENCH AND 5MM HEX BIT TO REMOVE (4) SCREWS ATTACHING BACK FRAME TO SWING ARMS. SET ASIDE SCREWS. REMOVE BACK FRAME AND SET ASIDE. SEE FIGURE 4.

### NOTICE

On adjustable arms, keep thumbwheel from spinning while disassembling.

### CAUTION

Support arm yoke while removing from swing arm. Failure to do so could cause product damage.

4. FOR ARM OPTION REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:

-ADJUSTABLE ARMS: WHILE SUPPORTING ARM YOKE AND HOLDING THUMBWHEEL USE RATCHET WRENCH AND T-27 TORX BIT TO REMOVE ARM YOKE. SET ASIDE THUMBWHEEL SCREW ASSEMBLY. SET ASIDE ARM YOKE WITH RELATED HARDWARE. NOTE: OLDER CHAIRS HAVE SPRING AND SPRING RETAINER. REMOVE AND DISPOSE OF PROPERLY. SEE FIGURE 5.

-FIXED ARMS: WHILE SUPPORTING ARM YOKE USE RATCHET WRENCH AND T-27 TORX BIT TO REMOVE ARM YOKE. SET ASIDE ARM YOKE, TORX HEAD SCREW AND RETAINER PLATE. USING STRAIGHT HEAD SCREWDRIVER PUSH OUT FILLER LOCATOR AND SET ASIDE. SEE FIGURE 7.

-NO ARM FILLERS: USING STRAIGHT HEAD SCREWDRIVER, PUSH OUT NO ARM FILLER FROM SWING ARM AND SET ASIDE. SEE FIGURE 8.

5. USING PLIERS TWIST OFF PNEUMATIC KNOB FROM LEVER OF PNEUMATIC CONTROL. PROPERLY DISPOSE OF PNEUMATIC KNOB. SEE FIGURE 9.
6. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND SET ASIDE (2) SCREWS AND COVER SECURING PNEUMATIC CONTROL. REMOVE PNEUMATIC CONTROL AND LET HANG. SEE FIGURE 10.
7. FOR SWING ARM REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:  
  
-CHAIRS MANUFACTURED BEFORE 9/16/96: USING T-40 TORX BIT AND RATCHET WRENCH REMOVE AND PROPERLY DISPOSE OF CAP SCREW HOLDING SWING ARM TO TILT. REMOVE SWING ARM AND DISPOSE OF PROPERLY. SEE FIGURE 11.  
  
-CHAIRS MANUFACTURED AFTER 9/16/96: SLIDE SWING ARM FROM TILT AND DISPOSE OF PROPERLY. SEE FIGURE 12.
8. SLIDE REPLACEMENT SWING ARM ON TO HEX BAR, UP TO TILT SPACER, KEEPING SAME ORIENTATION TO HEX BAR AS OPPOSITE ARM. SEE FIGURE 12.
9. UNSNAP COVER HALVES FROM LEVER AND SET ASIDE. SEE FIGURE 13.
10. PIVOT LEVER BACK TOWARD CABLE COUPLER UNTIL CABLE LINES UP WITH SLOT IN LEVER AND SLIDE LEVER OFF FROM CABLE. SEE FIGURE 14.
11. PIVOT REPLACEMENT LEVER TO LINE UP SLOT IN LEVER WITH CABLE AND SLIDE TOGETHER. SEE FIGURE 14.
12. INSTALL CABLE COUPLER INTO MATING CAVITY ON HALF OF COVER. INSERT LEVER INTO SAME HALF OF COVER. ATTACH OTHER COVER HALF TO EXISTING ASSEMBLY. SEE FIGURE 13.

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## NOTICE

Keep pneumatic control placed in swing arm with pressure until cover is in place and secure.

13. INSTALL PNEUMATIC CONTROL TO SWING ARM. WHILE KEEPING HAND PRESSURE ON PNEUMATIC CONTROL ASSEMBLY INSTALL COVER AND SECURE WITH (2) SCREWS. SEE FIGURE 10.

14. PUSH PNEUMATIC KNOB ONTO LEVER OF PNEUMATIC CONTROL UNTIL "CLICK" IS HEARD, INDICATING KNOB HAS LOCKED IN PLACE. SEE FIGURE 15.

## NOTICE

On chairs with adjustable arms: hold thumbwheel against inner wall of thumbwheel slot in arm yoke, closest to swing arm, while tightening Torx head screw.

15. FOR ARM OPTION INSTALLATION, FOLLOW APPROPRIATE PROCEDURE FROM BELOW:

-ADJUSTABLE ARMS: INSERT JAMB NUT, WASHER, BEARING AND THUMBWHEEL INTO ARM YOKE. KEEPING THUMBWHEEL IN PLACE IN THUMBWHEEL SLOT, INSTALL OUTER SLIDE BEARING TO END OF ARM YOKE AND POSITION ARM YOKE TO SWING ARM. INSTALL THUMBWHEEL SCREW ASSEMBLY TO ARM YOKE MAKING SURE THUMBWHEEL IS TIGHT AGAINST INNER WALL OF THUMBWHEEL SLOT. TIGHTEN TORX HEAD SCREW UNTIL ARM HOLDS POSITIONED HEIGHT. SEE FIGURES 5 AND 6.

-FIXED ARM: NOTE ARROW INDICATING TOP OF LOCATOR FILLER PRIOR TO INSTALLATION TO SWING ARM. INSERT LOCATOR FILLER INTO SWING ARM AND SNAP INTO PLACE. POSITION ARM YOKE ON SWING ARM ENGAGING ARM YOKE WITH LOCATOR FILLER. INSTALL TORX HEAD SCREW AND RETAINING PLATE INTO ARM YOKE. TIGHTEN AND TORQUE SCREW TO 100-125 IN-LBS. SEE FIGURE 7.

-NO ARM FILLER: NOTE ARROW INDICATING TOP OF NO ARM FILLER. INSERT NO ARM FILLER INTO SWING ARM UNTIL SNAPPED INTO PLACE. SEE FIGURE 8.

16. PLACE BACK FRAME AGAINST SWING ARMS ALIGNING HOLES. SECURE BACK FRAME WITH SCREWS. TIGHTEN AND TORQUE SCREWS TO 70-100 IN-LB. SEE FIGURE 4.

17. PLACE SEAT FRAME BETWEEN SWING ARMS ALIGNING HOLES. SECURE SEAT TO SWING ARMS WITH HIP PIVOT SCREWS. TIGHTEN AND TORQUE TO 180-200 IN-LB. SEE FIGURE 3.

## NOTICE

Older chairs have bushings and spacer which may have become dislodged from seat link while chair was serviced. Check unattached seat link ends to account for spacer, bushings and proper orientation of bushings before attaching to seat frame. Hold bushings in seat link while attaching to seat frame.

19. ATTACH SEAT LINK TO SEAT FRAME WITH SCREW AND NUT. TIGHTEN NUT UNTIL FLUSH WITH END OF SCREW. REPEAT FOR OPPOSITE SIDE. NOTE: SEAT LINKS IN OLDER CHAIRS HAVE SPACER AND BUSHINGS. MAKE CERTAIN SPACER AND ALL BUSHINGS ARE ACCOUNTED FOR AND BUSHES ARE ORIENTED TO NOTCH IN SEAT LINK. WHILE HOLDING BUSHINGS IN SEAT LINK, ATTACH SEAT LINK TO SEAT FRAME WITH SCREW, SPACER AND NUT. TIGHTEN NUT UNTIL FLUSH WITH END OF SCREW. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 AND 2.

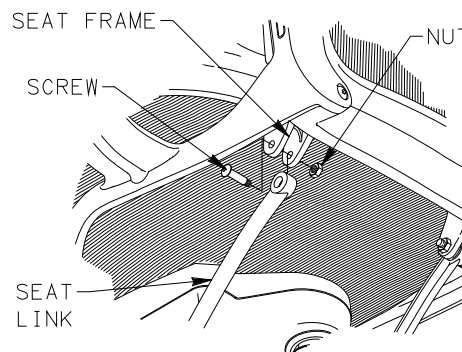


FIGURE 1  
(VIEWING FROM UNDERSIDE)

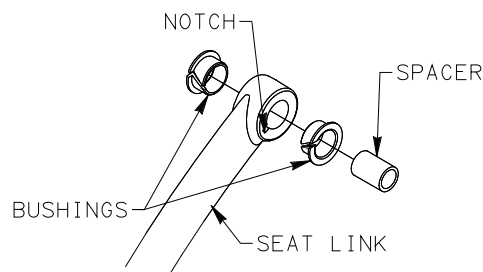


FIGURE 2  
(OLDER CHAIRS)

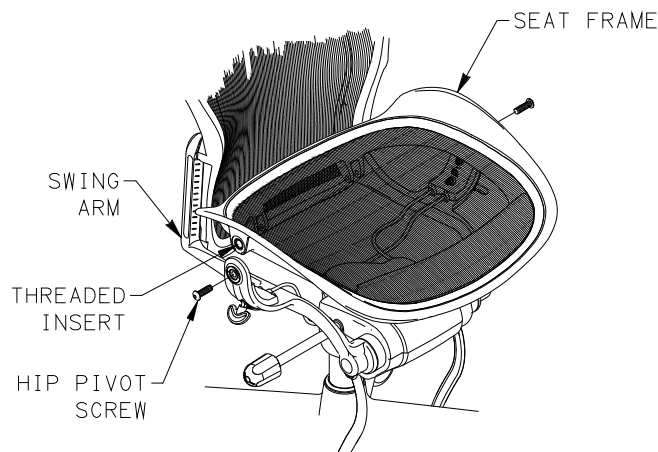


FIGURE 3

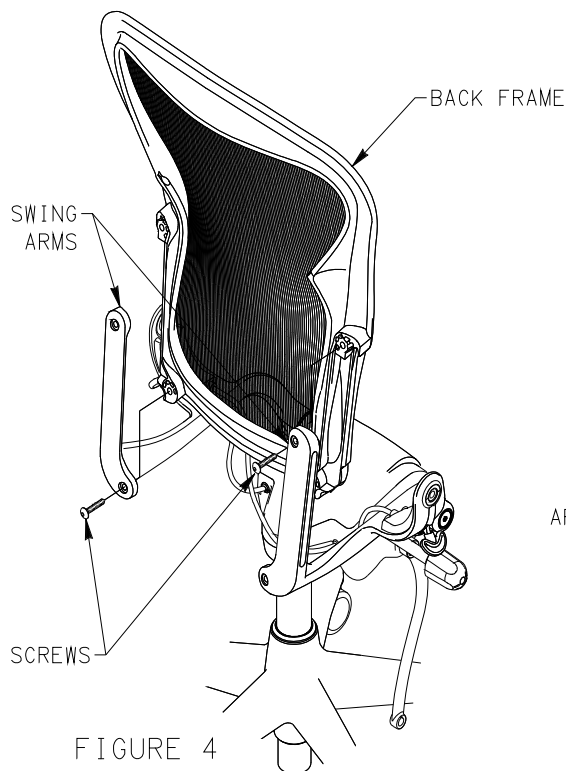


FIGURE 4

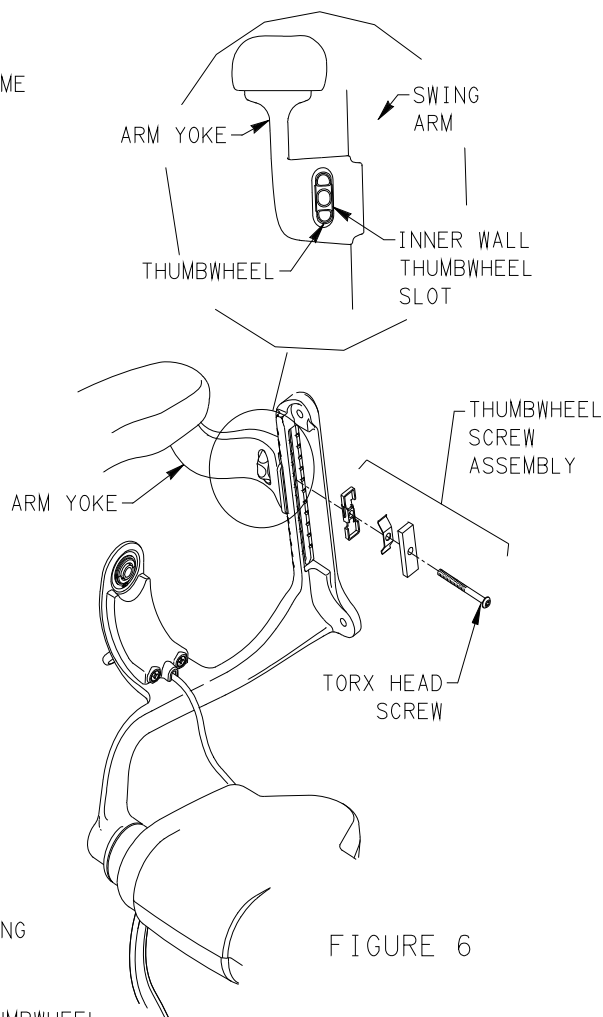


FIGURE 6

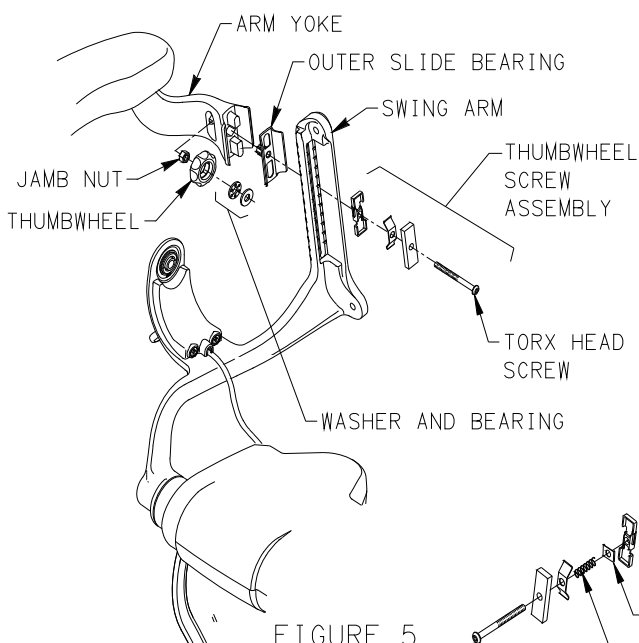
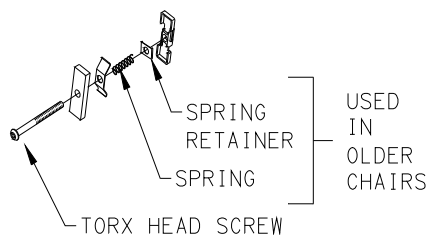


FIGURE 5



(USED IN OLDER CHAIRS)

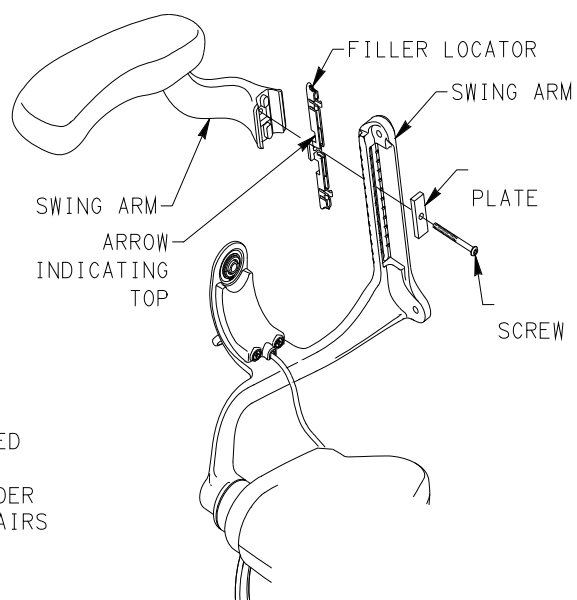
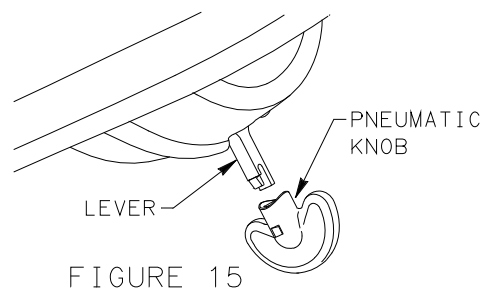
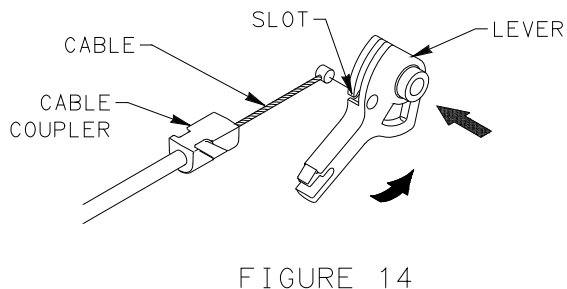
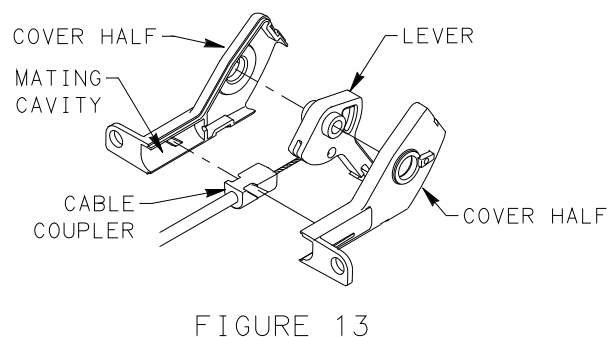
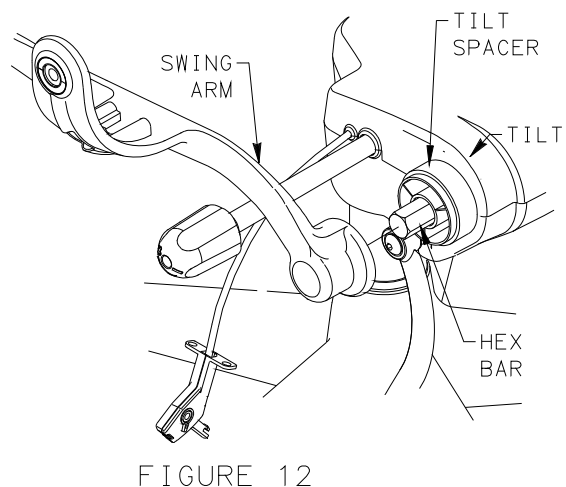
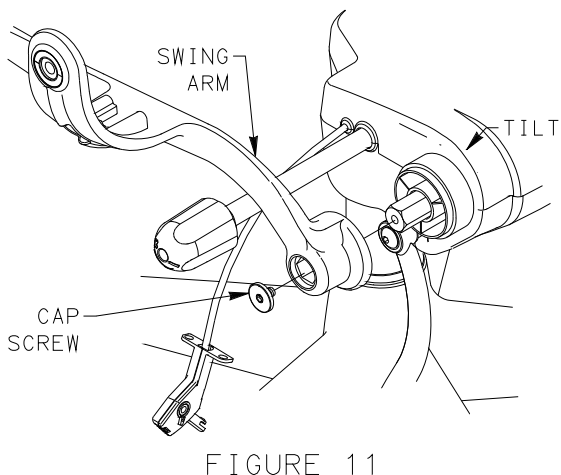
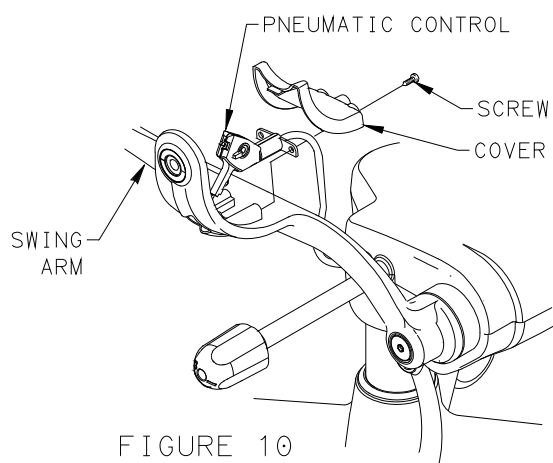
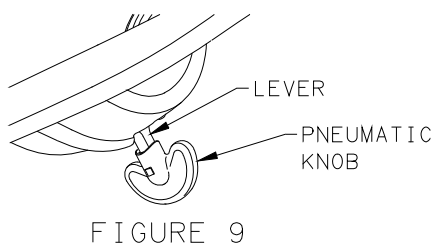
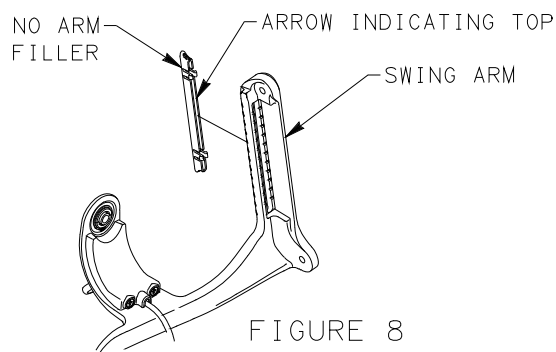
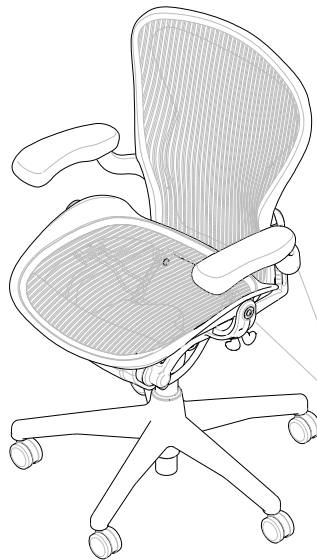


FIGURE 7



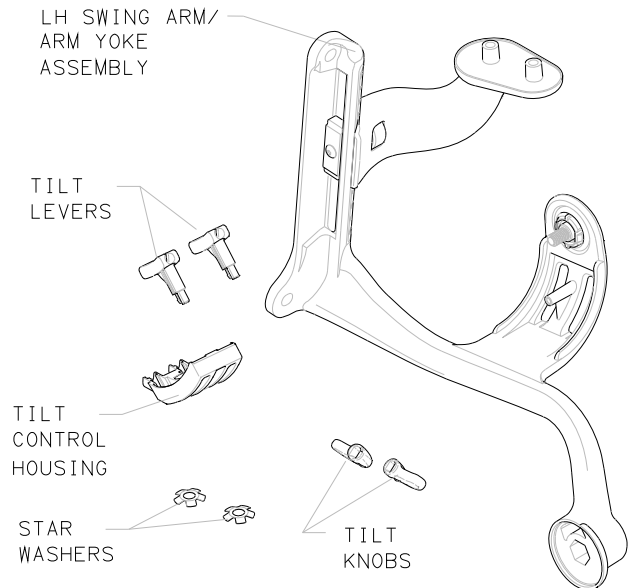


# Aeron® Left Hand Swing Arm/Arm yoke Replacement

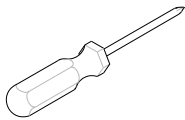


LH SWING ARM/  
ARM Yoke  
ASSEMBLY

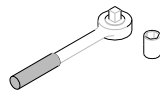
## PARTS INCLUDED



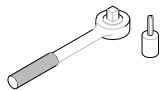
## TOOLS REQUIRED



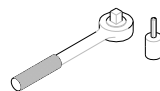
#2 PHILLIPS HEAD  
SCREWDRIVER



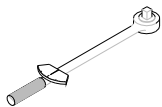
RATCHET WRENCH W/  
13MM SOCKET



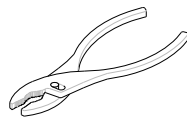
RATCHET WRENCH W/  
5MM HEX HEAD BIT



RATCHET WRENCH W/  
6MM HEX HEAD BIT



TORQUE WRENCH

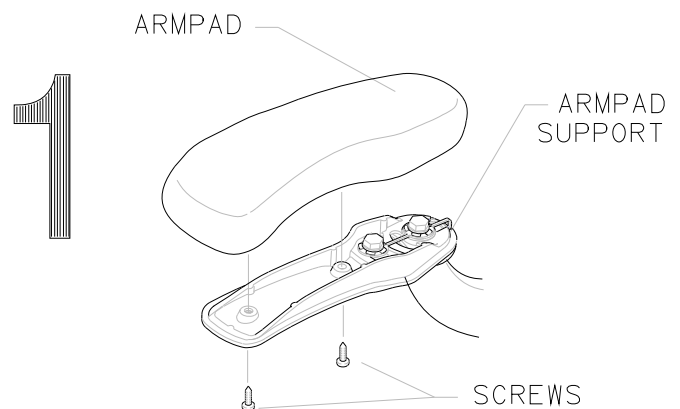


PLIERS

## PROCEDURE

### NOTICE

Make sure fasteners are torqued to specified values.



### TO REMOVE :

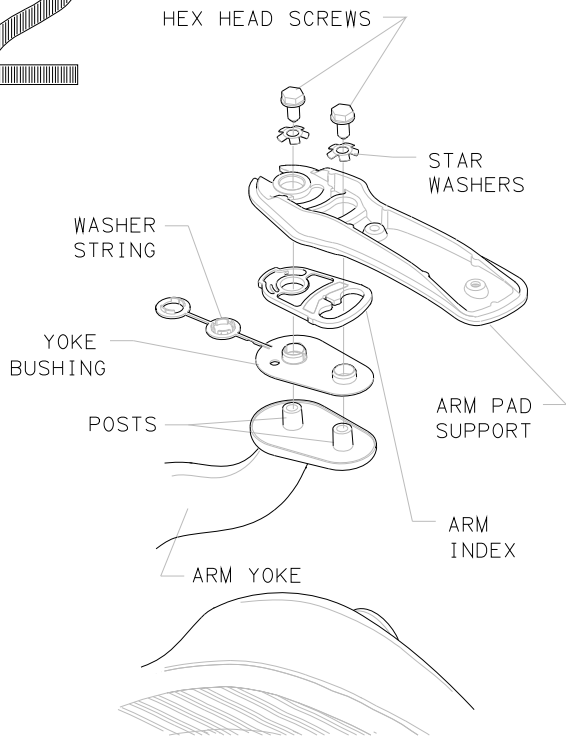
1. Using #2 phillips head screwdriver, remove screws securing arm pad to arm pad support.
2. Set arm pad and screws aside.

### TO REINSTALL :

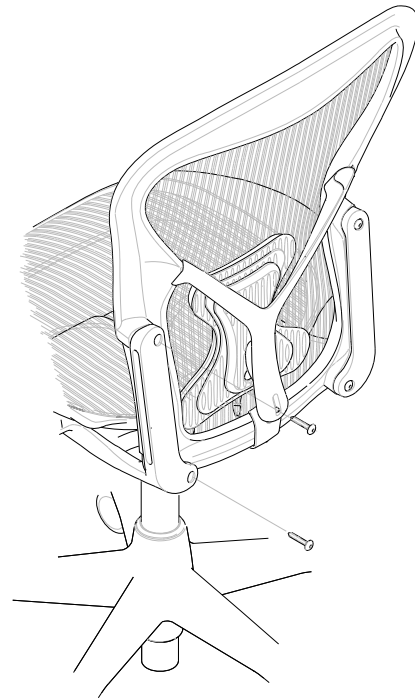
1. Place arm pad on arm yoke. Insert screws in arm pad support and secure arm pad using #2 phillips head screwdriver.

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# 2



# 3



## TO REMOVE :

1. Using 13mm socket and ratchet wrench, remove and set aside hex head screws. Properly dispose of star washers from arm pad support. Remove washer string from arm pad support. Remove arm pad support, arm index, yoke bushing from arm yoke and set aside.

## TO REINSTALL :

1. Place yoke bushing and arm index on arm yoke. Place arm pad support on arm yoke. Swing washer string set onto posts of arm yoke. Put in place replacement star washers. Secure with hex head screws. Tighten with 13mm socket and ratchet wrench. Torque to 200-250 in lbs. with 13mm socket and ratchet wrench.

## TO REMOVE :

1. Using ratchet wrench and 5MM, remove fasteners from left side of back and set aside.

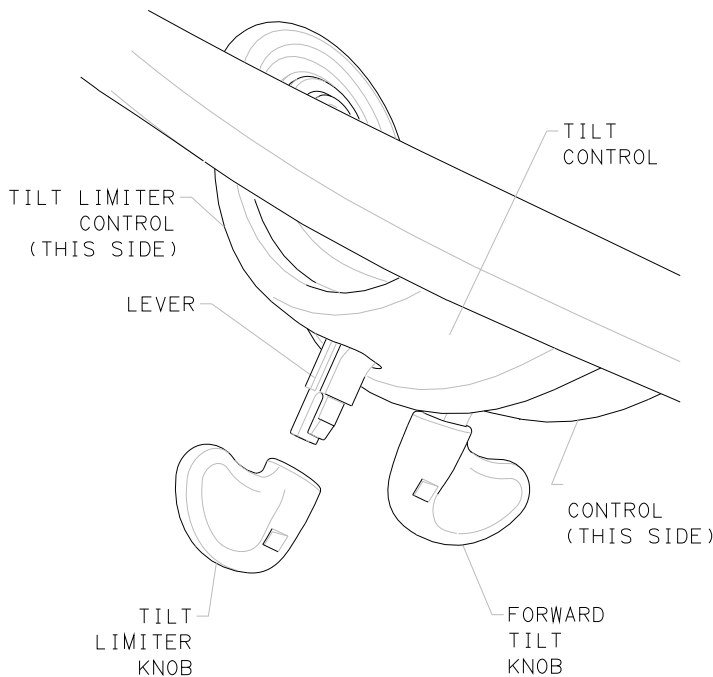
## TO REINSTALL :

1. Using ratchet wrench and 5MM hex bit, secure back to swing arm. Torque fasteners to 70-100 in lbs.

# 4 a

NOTICE  
IF CHAIR IS EQUIPPED WITH NO TILT OPTIONS,  
GO ONTO STEP 8.

FOR CHAIRS MANUFACTURED  
BEFORE 8-23-2004



TO REMOVE :

1. Using pliers, cut above knob(s) to separate knob from lever.  
Properly dispose of knob/s.

TO REINSTALL :

1. Push on appropriate knob/s until they click into place.

# 4 b

FOR CHAIRS MANUFACTURED  
AFTER 8-23-2004

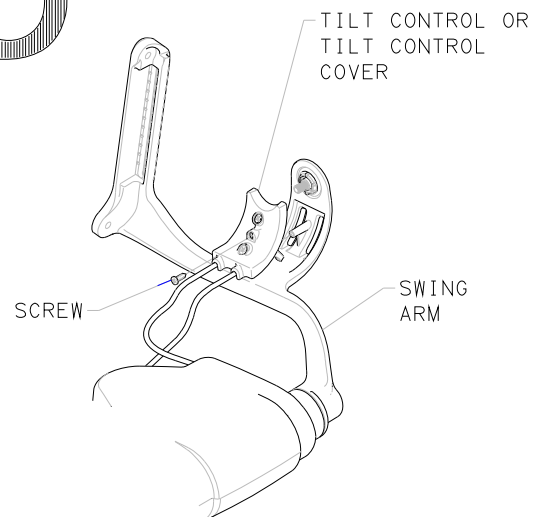
TO REMOVE :

1. Using hands, pull knob/s from control lever/s. Set knob/s aside.
2. Proceed to step 8.

TO REINSTALL :

1. Push on appropriate knob/s until they click into place.

# 5



(GRAPHIC SHOWN WITHOUT SEAT FRAME)

TO REMOVE :

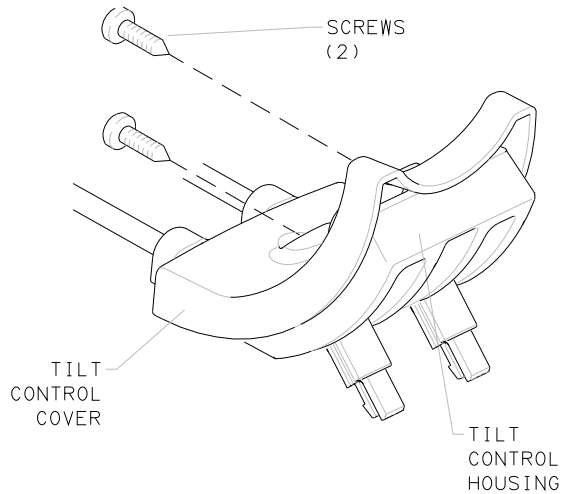
1. Using #2 phillips head screwdriver, remove and set aside fastener  
(and isolate) securing tilt control to swing arm.

TO REINSTALL :

1. Place tilt control on swing arm and secure with screw using  
#2 phillips head screwdriver.

1B16S1 REV B

# 6



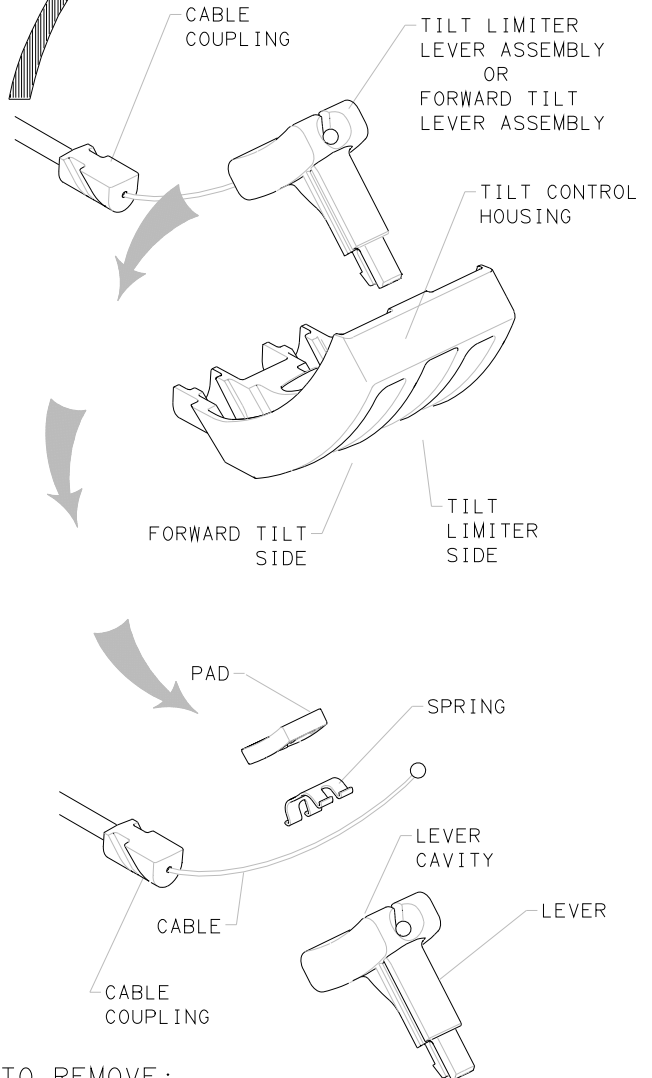
## TO REMOVE :

1. Using #2 phillips head screwdriver, remove and set aside (2) screws fastening tilt control cover to tilt control housing. Set aside tilt control cover.

## TO REINSTALL :

1. Install tilt control cover to tilt control housing and secure with (2) screws.

# 7



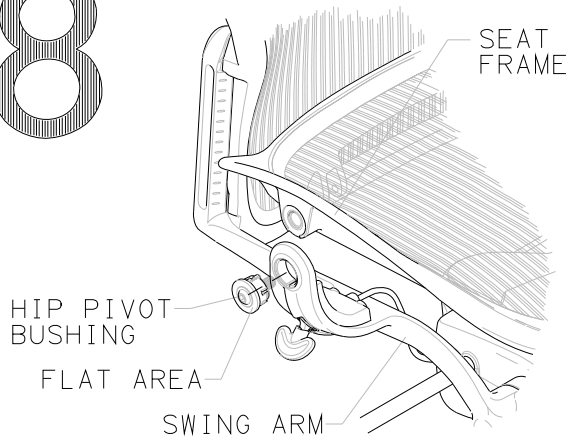
## TO REMOVE :

1. Remove tilt limiter lever / forward tilt lever assemblies from tilt control housing. Remove and set aside pad and spring from lever. Remove cable from lever. Properly dispose of lever (s) and tilt control housing.

## TO REINSTALL :

1. Slide cable into replacement lever. Insert spring over cable into cavity of lever. Place pad over spring. Using thumb and forefinger, hold lever assembly together. Insert cable coupling and lever assembly into tilt control housing.

8



(FOR CHAIRS MANUFACTURED AFTER JUNE 4, 2003)

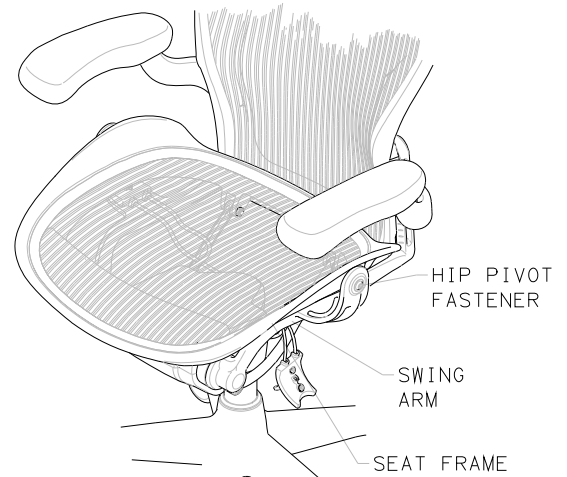
#### TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot bushing assembly from swing arm. Loosening pivot fastener will force hip pivot bushing assembly from swing arm. After hip pivot fastener has disengaged from seat frame, remove hip pivot bushing and set aside. Repeat for other side.
2. Remove seat frame with b links and set aside.

#### TO REINSTALL :

1. Make certain flat area around fasteners head in hip pivot bushing is flat and aligned with bushing area. Repeat for other hip pivot bushing.
2. Lower seat in place. Align fastener in seat frame to mounting hole in swing arm and insert hip pivot bushing.
3. Insert other hip pivot fastener into swing arm aligning top and bottom guides into slots in swing arm opening.
4. Using 6MM head bit and ratchet wrench, partially thread hip pivot fastener into seat frame. Repeat for opposite side.
5. Secure fasteners of hip pivot bushing, drawing hip pivot bushing into seat frame. Torque fasteners to 180-200 lbs.

9



(FOR CHAIRS MANUFACTURED BEFORE JUNE 4, 2003)

#### TO REMOVE :



#### CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame, **STOP IMMEDIATELY** and follow instructions.

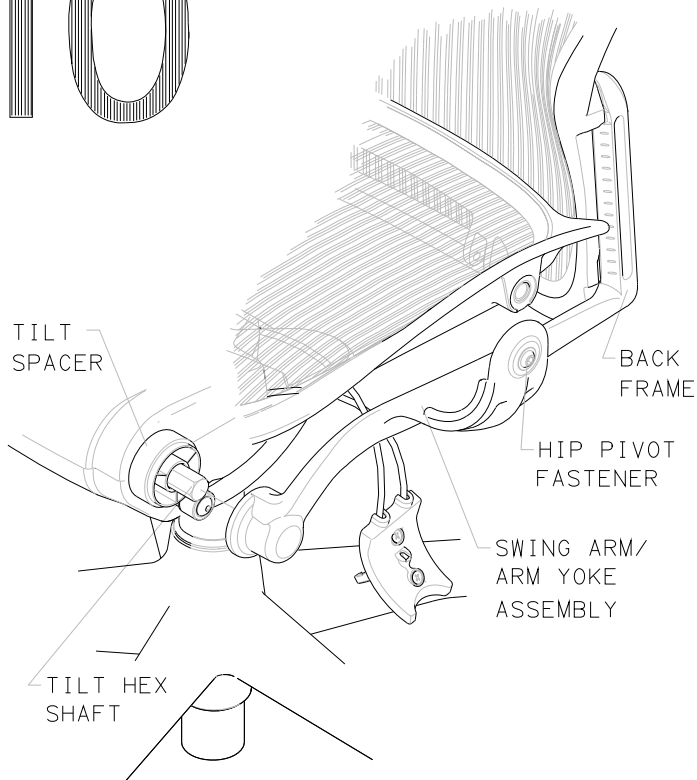
1. Using ratchet and 6MM hex bit, remove hip pivot screw from each swing arm. If threaded insert turns with hip pivot screw, **STOP** immediately and do the following step: Tighten hip pivot screw into threaded insert as much as possible. Using a quick jerking motion with ratchet wrench. Back out hip pivot screw from threaded insert. If threaded insert turns with hip pivot screw, repeat process.
2. Remove seat frame with b links and set aside.

#### TO REINSTALL :

1. Place seat frame between swing arms. Attach seat frame to swing arms with hip pivot screws. Tighten and torque to 180-200 in lbs.

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# 10



## TO REMOVE :

1. Slide off swing arm/arm yoke assembly from tilt hex shaft.  
Properly dispose of swing arm/arm yoke.

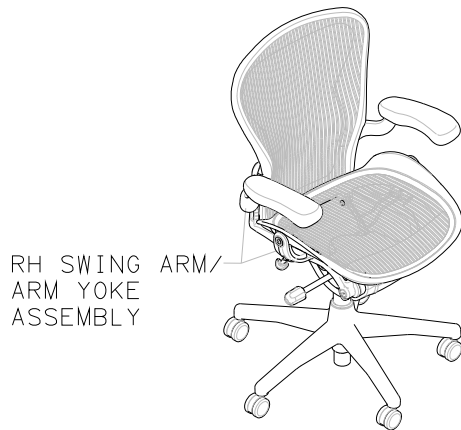
## TO REINSTALL :

1. Slide on replacement swing arm/arm yoke assembly to tilt hex shaft. Align orientation of swing arm to position of back frame. Swing arm should be tight against tilt spacer. Hip pivot fastener may pop out from its location.

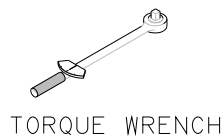
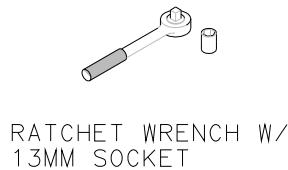
## ⚠ CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame,  
**STOP IMMEDIATELY** and follow instructions.

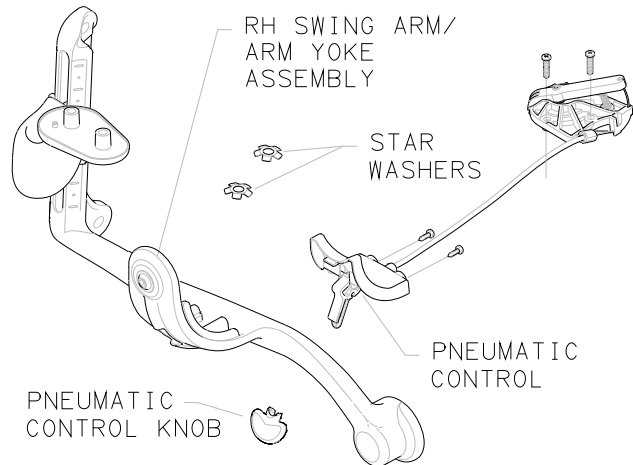
# Aeron® Right Hand Swing Arm/Arm yoke Replacement



## TOOLS REQUIRED



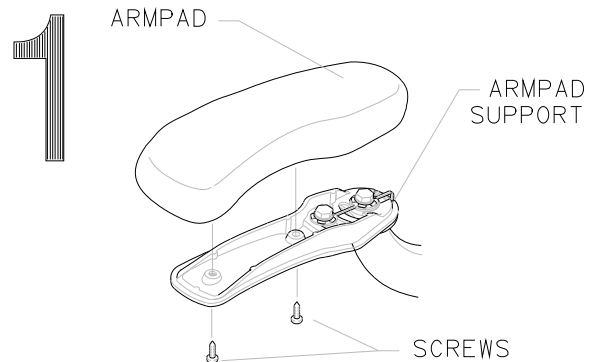
## PARTS INCLUDED



## PROCEDURE

### NOTICE

Make sure fasteners are torqued to specified values.



### TO REMOVE :

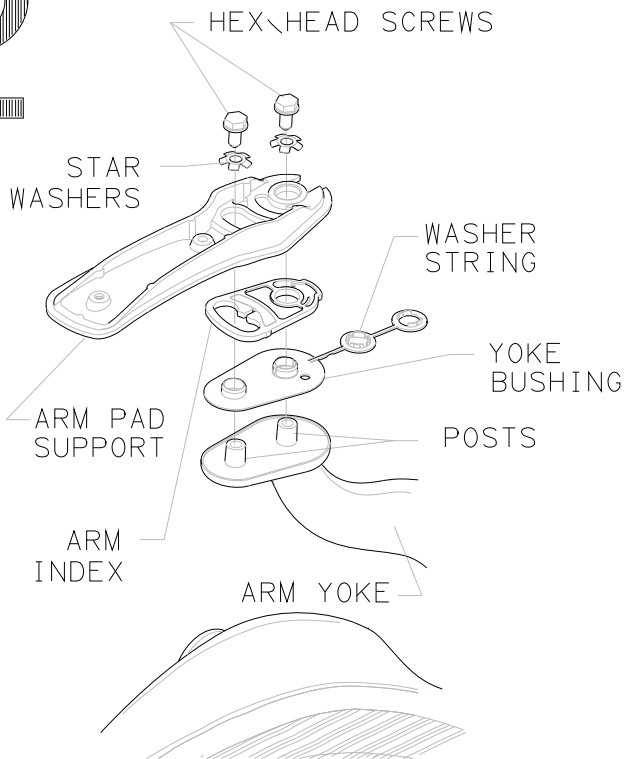
1. Using #2 phillips head screwdriver, remove screws securing arm pad to arm pad support.
2. Set arm pad and screws aside.

### TO REINSTALL :

1. Place arm pad on arm yoke. Insert screws in arm pad support and secure arm pad using #2 phillips head screwdriver.

1B1189 REV A

# 2



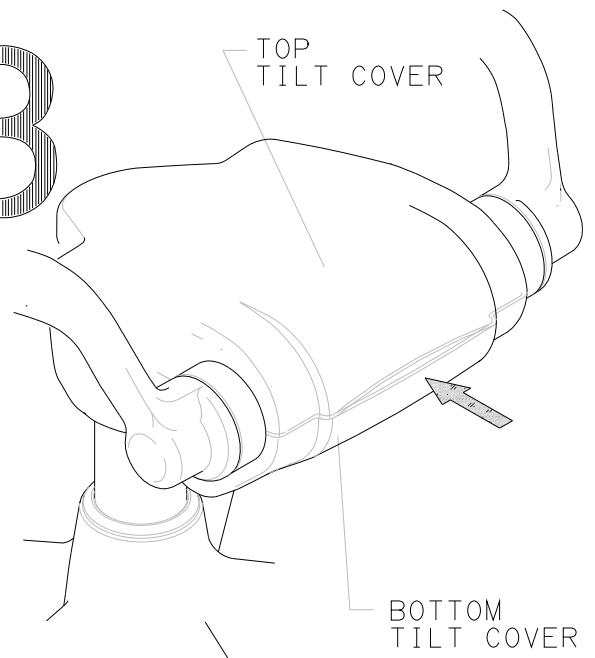
## TO REMOVE :

1. Using 13mm socket and ratchet wrench, remove and set aside hex head screws and properly dispose of star washers from arm pad support. Remove washer string from arm pad support. Remove arm pad support, arm index, yoke bushing from arm yoke and set aside.

## TO REINSTALL :

1. Place yoke bushing and arm index on arm yoke. Place arm pad support on arm yoke. Swing washer string set onto posts of arm yoke. Put in place replacement star washers. Secure with hex head screws. Tighten with 13mm socket and ratchet wrench. Torque to 200-250 in lbs.

# 3

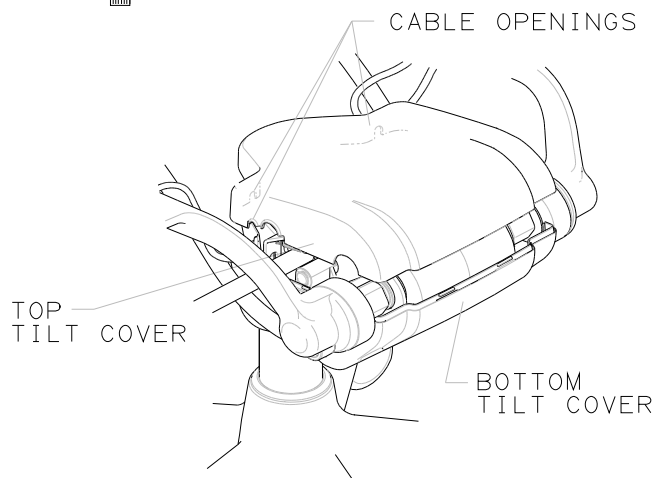


## TO REMOVE :

1. Using thumb pressure, press front of bottom tilt cover to start separation of tilt covers.



# 4



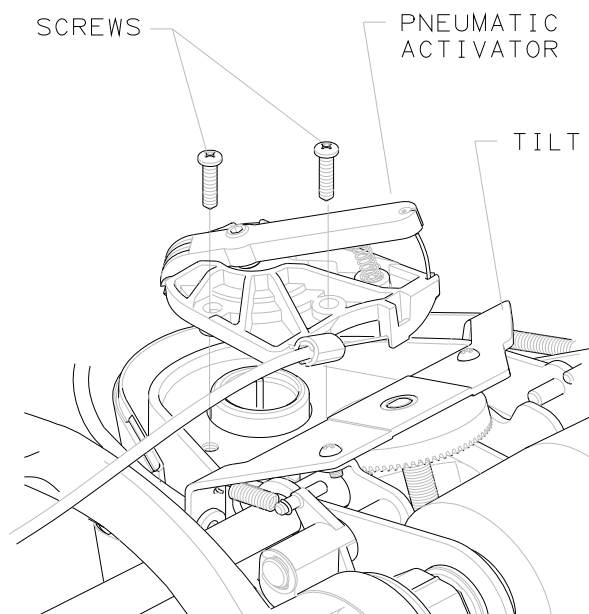
## TO REMOVE :

1. Insert 1" putty knife between covers and twist to separate top from bottom cover. Remove top cover and set aside.

## TO REINSTALL :

1. Reposition top tilt cover over bottom tilt cover, making sure all cables are properly routed through cable openings. Snap cover halves together.

# 5



## TO REMOVE :

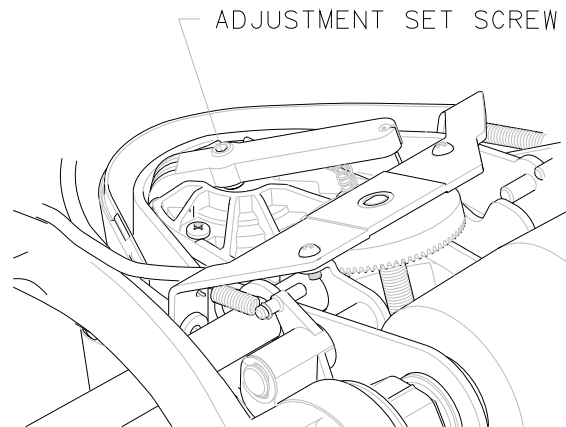
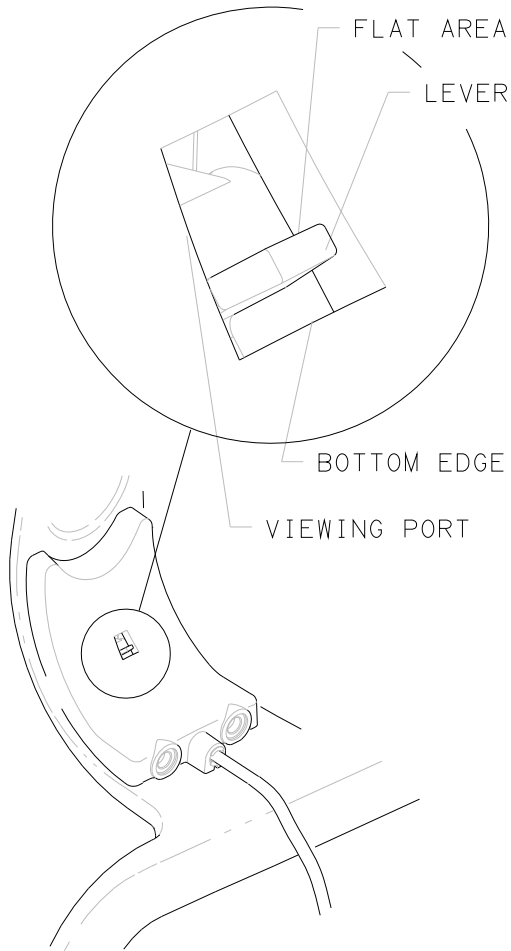
1. Using #2 phillips head screwdriver, remove and discard (2) screws securing pneumatic actuator to tilt.

## TO REINSTALL :

1. Place actuator end of pneumatic cable assembly on top of tilt. Secure with screws provided using #2 phillips head screwdriver.

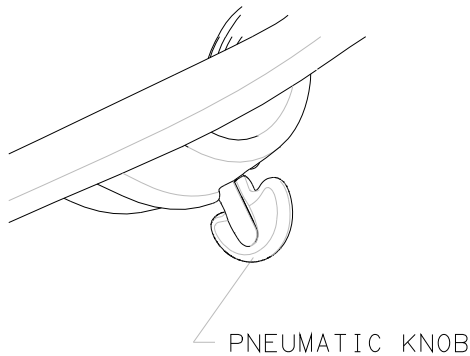
1B1189 REV A

TO ADJUST ACTIVATOR:



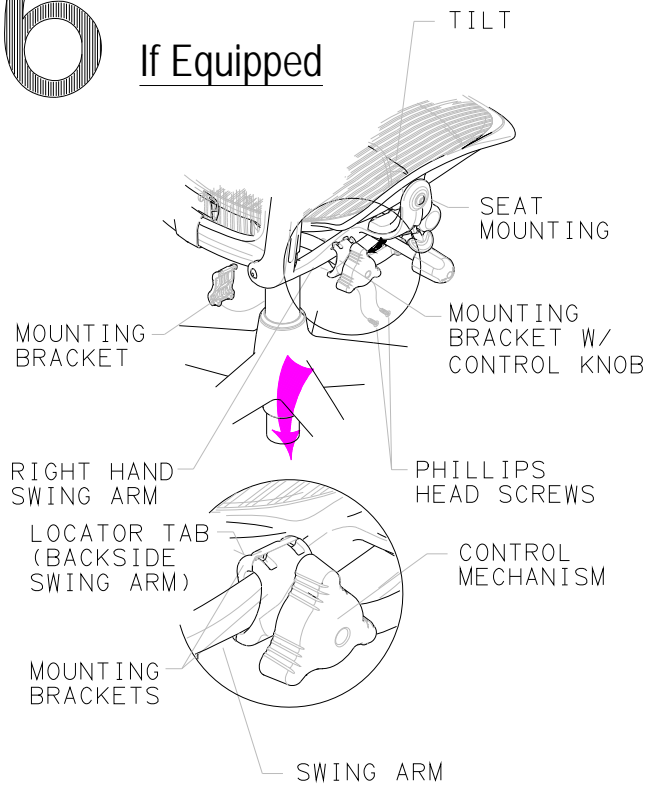
TO ADJUST ACTIVATOR:

1. Check pneumatic cable assembly's activation by activating lever slightly to monitor lever through viewing port on pneumatic control end. When flat area of lever is even with bottom edge of viewing port, adjustment set screw on activation end of cable assembly should be resting on pin of pneumatic cylinder, not yet activated. Adjust set screw using 4MM hex key until this is achieved.



# 6

## If Equipped



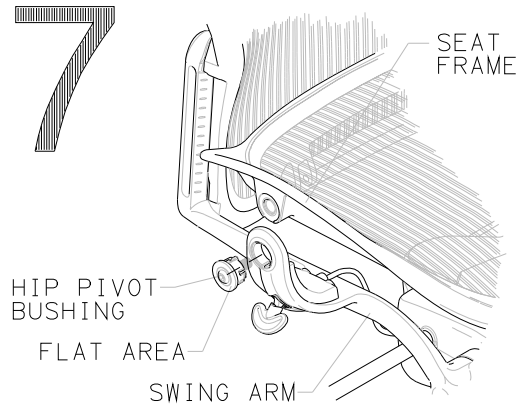
### TO REMOVE :

1. Using #2 phillips head screwdriver, remove screws fastening mounting bracket to control mechanism. Remove control mechanism from swing arm and let hang.

### TO REINSTALL :

1. Place control mechanism mounting halves over locator tab (on inside of swing arm). Hook back half onto front half over locator tab and secure with screws using #2 phillips head screwdriver.
2. Route cable from back of chair over tilt, looping back under right hand swing arm.
3. Route cable from control mechanism under right hand swing arm towards front of tilt turning towards back of chair.

# 7



### TO REMOVE :

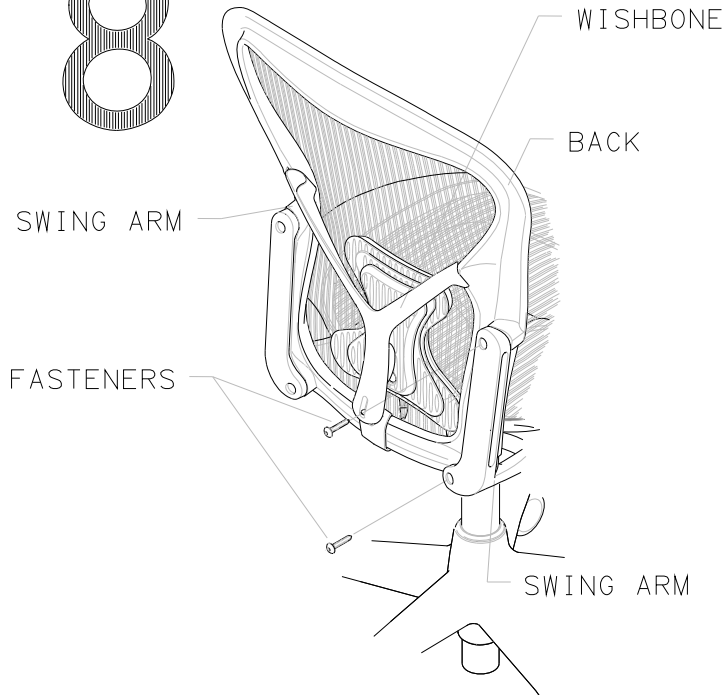
1. Using ratchet and 6MM hex bit, remove hip pivot bushing assembly from RH swing arm. Loosening hip pivot will force hip pivot bushing assembly from swing arm. After hip pivot fastener has disengaged from seat frame, remove hip pivot bushing and set aside.

### TO REINSTALL :

1. Make certain flat area around fasteners head in hip pivot bushing is flat and aligned with bushing area.
2. Align fastener in seat frame to mounting hole in swing arm.
3. Using 6MM head bit and ratchet wrench, thread hip pivot fastener into seat frame. Hip pivot bushing will draw into seat frame as it is tightened. Secure fastener into seat frame and torque to 180-200 in lbs.

1B1189 REV A

8



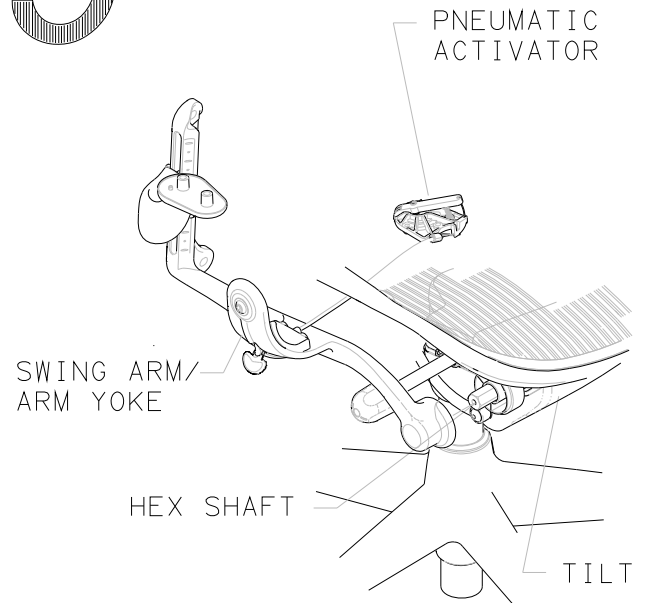
#### TO REMOVE :

1. Using ratchet wrench and 5MM, remove and set aside fasteners from right side of back.

#### TO REINSTALL :

1. Using ratchet wrench and 5MM hex bit, secure back to swing arm. Torque fasteners to 70-100 in lbs.

9



#### TO REMOVE :

1. Slide off swing arm/arm yoke assembly from tilt hex shaft. Properly dispose of swing arm/arm yoke.

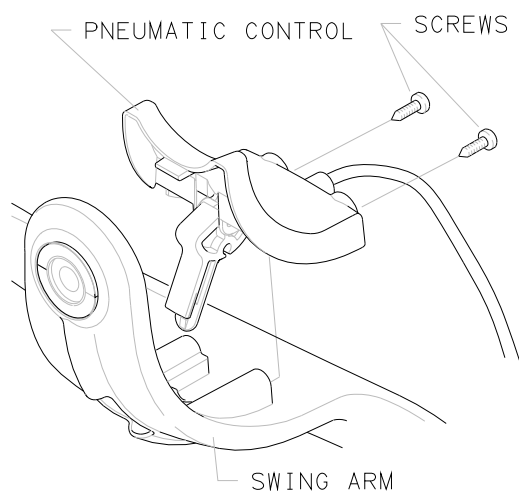
#### TO REINSTALL :

1. Slide on replacement swing arm/arm yoke assembly to tilt hex shaft. Align orientation of swing arm to position of back frame. Swing arm should be tight against tilt spacer. Hip pivot fastener may pop out from its location.

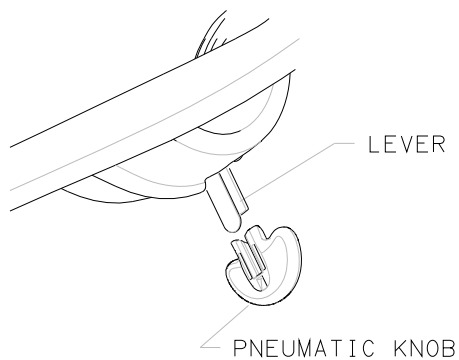
# 9

## Continued

TO INSTALL PNEUMATIC CONTROL :



(GRAPHIC SHOWN WITH SEAT REMOVED)



TO INSTALL PNEUMATIC CONTROL :

1. Insert pneumatic control end into swing arm. Secure with (2) screws provided using #2 phillips head screwdriver.
2. Insert new knob on lever. Push until it snaps into place.

1B1189 REV A

# Aeron® Arm Yoke Bearing Replacement

TOOLS REQUIRED: RATCHET WRENCH  
5MM HEX BIT  
T-27 TORX BIT  
TORQUE WRENCH, 100 IN-LBS CAPACITY

## PROCEDURE:

### ⚠ WARNING

Support back frame while removing from swing arms. Failure to do so could allow back frame to fall causing product damage or personal injury.

1. SUPPORT BACK FRAME. USING RATCHET WRENCH AND 5MM HEX BIT, REMOVE AND SET ASIDE (4) SCREWS ATTACHING BACK FRAME TO SWING ARMS. REMOVE BACK FRAME AND SET ASIDE. SEE FIGURE 1.

### ⚠ CAUTION

Support arm yoke while removing from swing arm. Failure to do so could cause product damage.

### NOTICE

To allow proper disassembly, keep thumbwheel from spinning.

2. WHILE SUPPORTING ARM YOKE AND HOLDING THUMBWHEEL, USE T-27 TORX BIT AND RATCHET WRENCH TO REMOVE ARM YOKE. SET ASIDE ARM YOKE WITH RELATED HARDWARE. SET ASIDE THUMBWHEEL SCREW ASSEMBLY. REMOVE INNER AND OUTER SLIDE BEARINGS AND DISPOSE OF PROPERLY. NOTE: OLDER CHAIRS HAVE SPRING AND SPRING RETAINER IN THUMBWHEEL SCREW ASSEMBLY. REMOVE AND DISPOSE OF PROPERLY. SEE FIGURE 2.
3. KEEPING THUMBWHEEL IN PLACE IN THUMBWHEEL SLOT, INSTALL REPLACEMENT OUTER SLIDE BEARING TO END OF ARM YOKE AND POSITION ARM YOKE TO SWING ARM. SEE FIGURES 2 AND 3.

### NOTICE

For proper assembly, keep thumbwheel tight against inner wall of thumbwheel slot in arm yoke, closest to swing arm while tightening Torx head screw.

4. ADD REPLACEMENT INNER SLIDE BEARING TO THUMBWHEEL SCREW ASSEMBLY AND INSTALL TORX HEAD SCREW INTO THUMBWHEEL MAKING SURE THUMBWHEEL IS TIGHT AGAINST INNER WALL OF THUMBWHEEL SLOT. TIGHTEN SCREW UNTIL ARM HOLDS POSITIONED HEIGHT. SEE FIGURES 2 AND 3.
5. PLACE BACK FRAME UP TO SWING ARMS ALIGNING HOLES. SECURE WITH SCREWS. USING TORQUE WRENCH AND 5MM HEX BIT, TORQUE SCREWS TO 70-100 IN-LBS. SEE FIGURE 1.

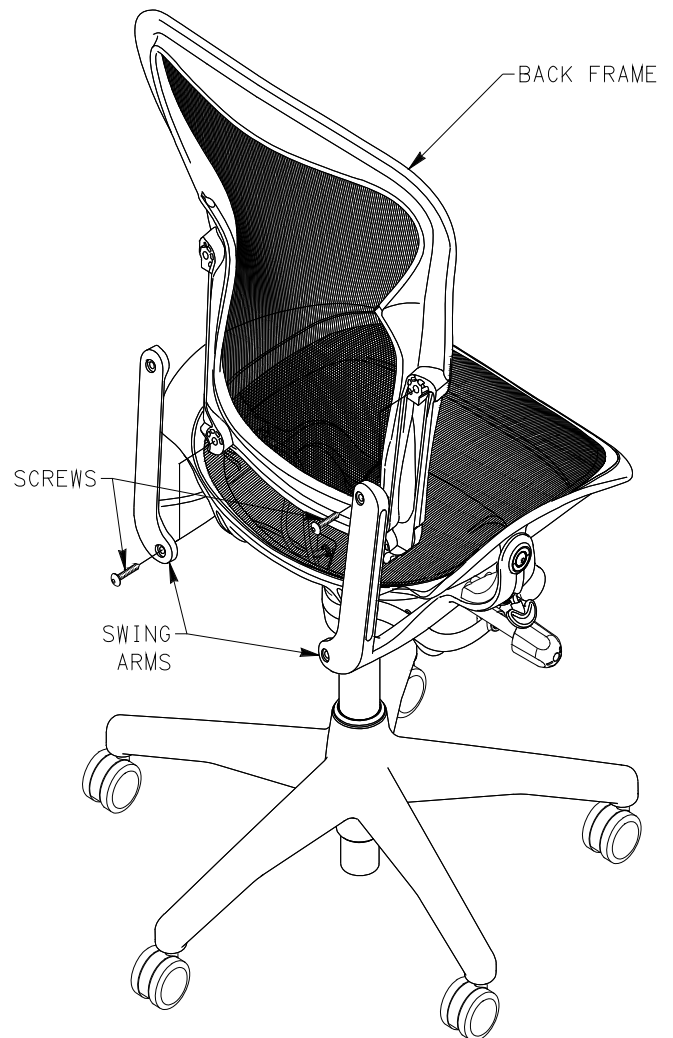


FIGURE 1

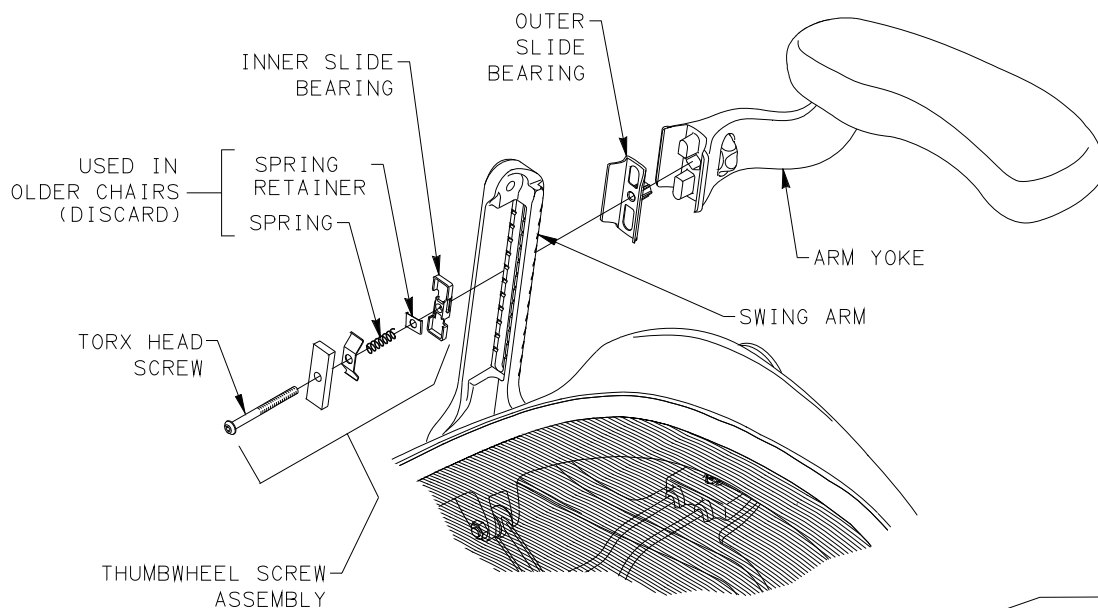


FIGURE 2

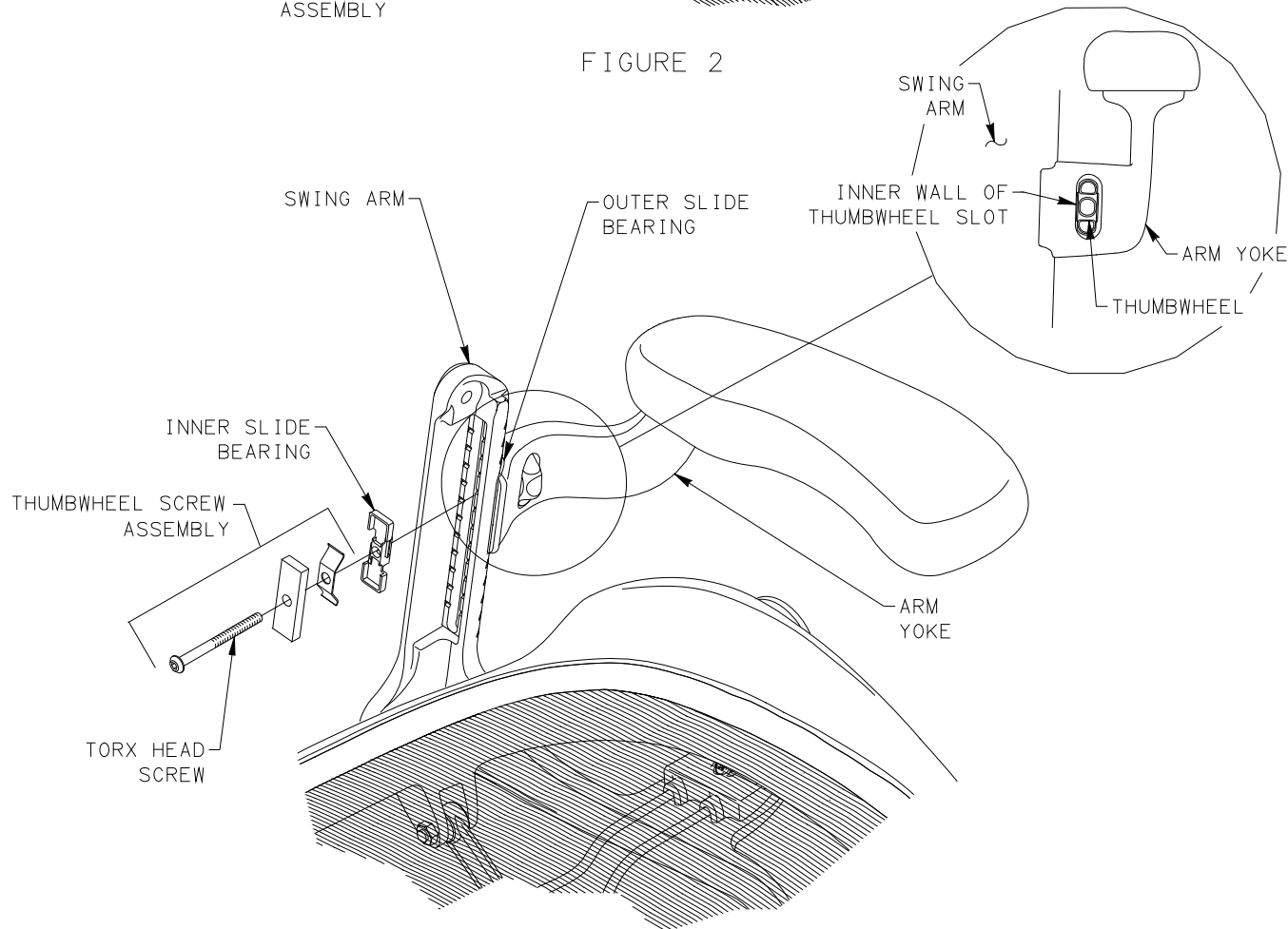


FIGURE 3

167214 REV C

# Aeron® Arm Pad Hardware Replacement

TOOLS REQUIRED: #2 PHILLIPS HEAD SCREWDRIVER  
13MM SOCKET  
RATCHET WRENCH  
PLIERS  
TORQUE WRENCH, 250 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

- ✗. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND SET ASIDE (2) SCREWS FASTENING ARM PAD TO ARM PAD SUPPORT. REMOVE ARM PAD BY PULLING UP AND PIVOTING BACK FROM FRONT EDGE. SET ARM PAD ASIDE. SEE FIGURE 1.

## INDEXING ARM PAD:

2. USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND PROPERLY DISPOSE OF HEX HEAD SCREWS, STAR WASHERS, AND NYLON WASHERS SECURING ARM PAD SUPPORT TO ARM YOKE. REMOVE ARM PAD SUPPORT FROM ARM YOKE. REMOVE AND PROPERLY DISPOSE OF TORSION SPRING FROM ARM PAD SUPPORT. SET ASIDE ARM PAD SUPPORT. REMOVE AND PROPERLY DISPOSE OF INDEX AND YOKE BUSHING. SEE FIGURE 2.

## FIXED ARM PAD:

3. USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND PROPERLY DISPOSE OF HEX HEAD SCREWS AND (4) NYLON WASHERS SECURING ARM PAD SUPPORT TO ARM YOKE. NOTE: OLDER CHAIRS HAVE (2) STEEL AND (2) NYLON WASHERS. REMOVE ARM PAD SUPPORT FROM ARM YOKE AND SET ASIDE. REMOVE AND PROPERLY DISPOSE OF VERTICALLY ADJUSTABLE SPACER. SEE FIGURE 3.

## INDEXING ARM PAD:

4. INSTALL REPLACEMENT YOKE BUSHING AND INDEX BUSHING TO ARM YOKE. INSTALL ARM PAD SUPPORT TO ARM YOKE. INSTALL REPLACEMENT NYLON WASHERS, STAR WASHERS ONTO ARM PAD SUPPORT. INSTALL REPLACEMENT HEX HEAD SCREWS. TIGHTEN AND TORQUE HEX HEAD SCREWS TO 200-250 IN-LBS. SEE FIGURE 2.
5. INSTALL TORSION SPRING INTO ARM PAD SUPPORT BY INSERTING CURVED END OF TORSION SPRING INTO OPEN CAVITY OF INDEX BUSHING THROUGH TORSION SPRING MOUNTING HOLE. TORSION SPRING SHOULD BE PARTIALLY SEATED INTO MOUNTING HOLE WITH FREE END OF TORSION SPRING RESTING ON SUPPORT CASTING. SEE FIGURE 4.

## FIXED ARM PAD:

6. INSTALL REPLACEMENT VERTICALLY ADJUSTABLE SPACER TO ARM YOKE WITH TAB POINTING TO OUTSIDE OF ARM YOKE. INSTALL ARM PAD SUPPORT TO ARM YOKE. INSTALL (4) REPLACEMENT NYLON WASHERS AND (2) HEX HEAD SCREWS TO ARM YOKE. TORQUE HEX HEAD SCREWS TO 200-250 IN-LBS. CONTINUE TO PROCEDURE 9. SEE FIGURE 3.

- ✗. GRASP FREE END OF TORSION SPRING WITH PLIERS. LOAD TORSION SPRING BY TWISTING SPRING AND POSITIONING FREE END OF TORSION SPRING AGAINST INSIDE VERTICAL SURFACE BETWEEN RETAINING BOSSES. SEE FIGURE 5.

8. INSTALL ARM PAD ONTO ARM PAD SUPPORT BY INSERTING TAB ON ARM PAD SUPPORT INTO SLOT IN ARM PAD AND PIVOTING DOWN ONTO ARM PAD SUPPORT. SECURE WITH SCREWS. SEE FIGURES 1 & 6.

9. REPEAT STEPS 1-9 FOR OPPOSITE SIDE.

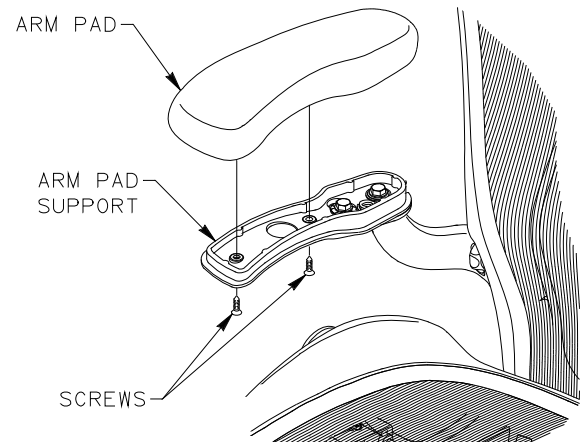


FIGURE 1

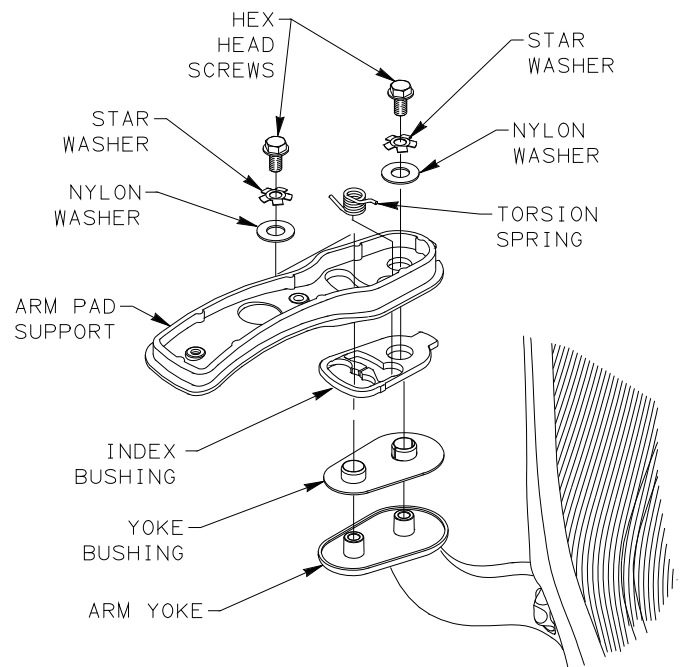


FIGURE 2



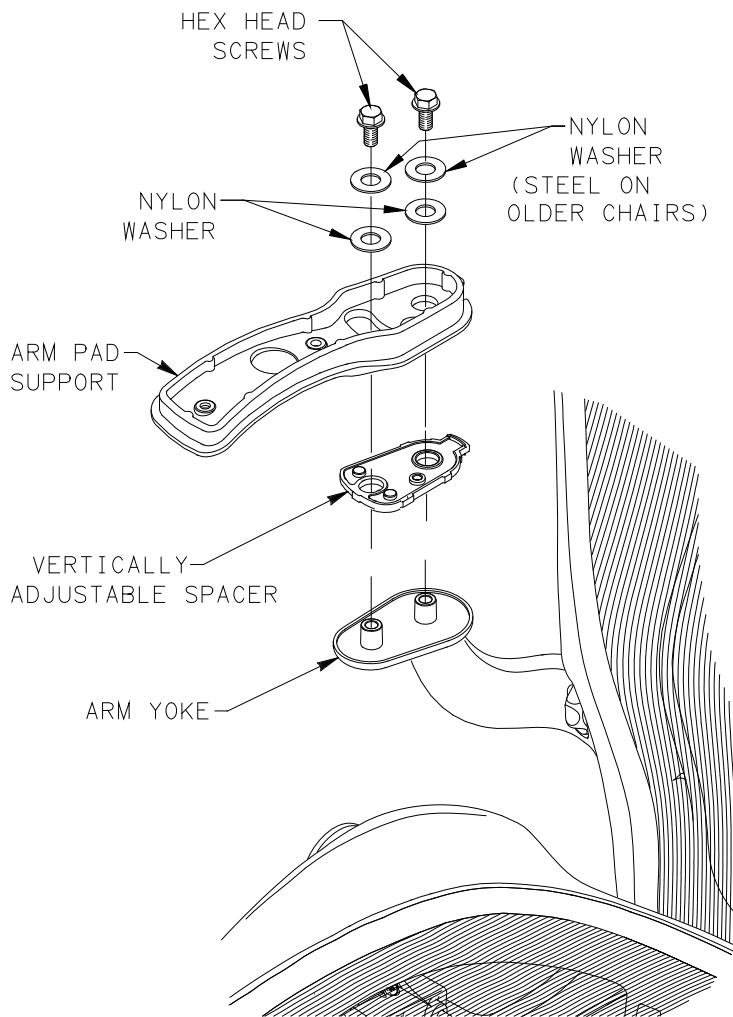


FIGURE 3

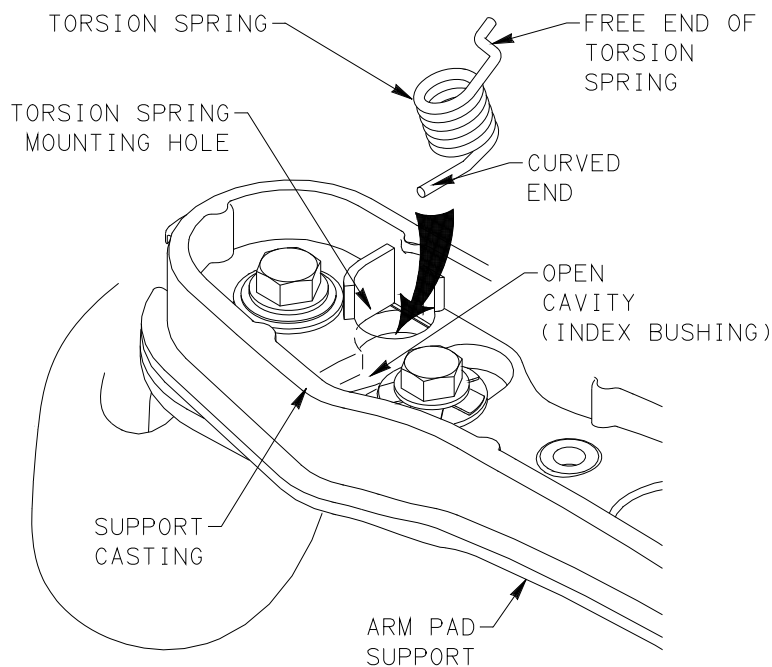


FIGURE 4

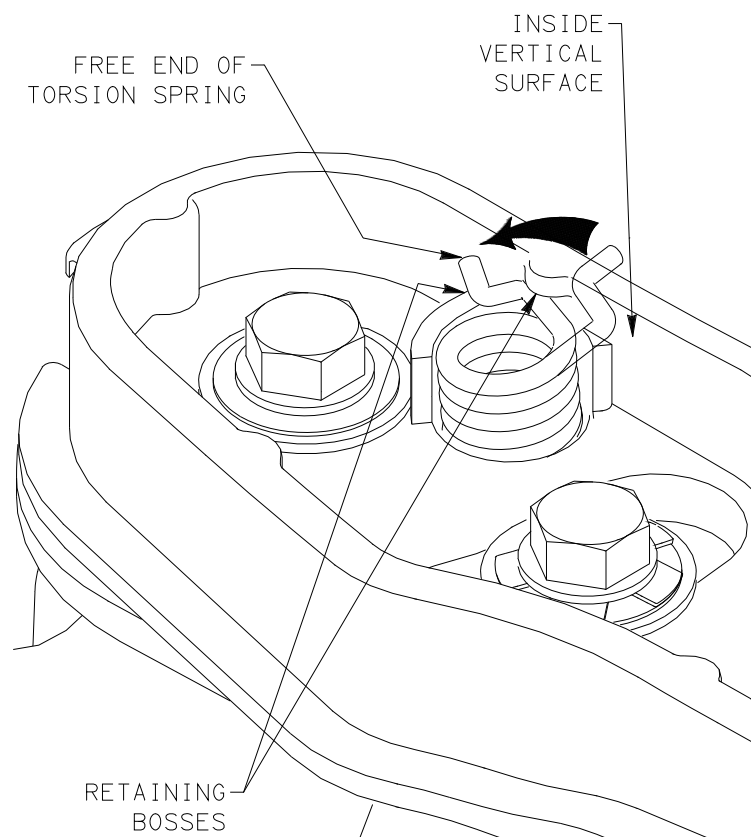


FIGURE 5

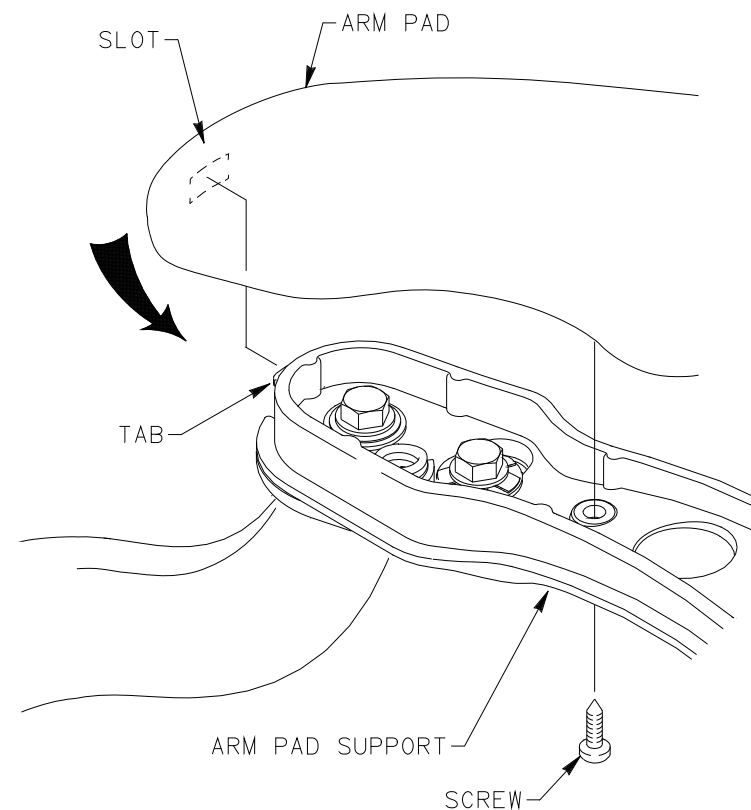


FIGURE 6

# Aeron® Arm Adjustment Hardware Replacement

TOOLS REQUIRED: RATCHET WRENCH  
5MM HEX BIT  
T-27 TORX BIT  
TORQUE WRENCH, 100 IN-LB CAPACITY

PROCEDURE:

## ⚠ WARNING

Support back frame while removing from swing arms. Failure to do so could allow back frame to fall causing product damage or personal injury.

1. SUPPORT BACK FRAME. USING RATCHET WRENCH AND 5MM HEX BIT, REMOVE AND SET ASIDE (4) SCREWS ATTACHING BACK FRAME TO SWING ARMS. REMOVE BACK FRAME AND SET ASIDE. SEE FIGURE 1.

## ⚠ CAUTION

Support arm yoke while removing from swing arm. Failure to do so could cause product damage.

## NOTICE

To allow proper disassembly, keep thumbwheel from spinning.

2. WHILE SUPPORTING ARM YOKE AND HOLDING THUMBWHEEL, USE T-27 TORX BIT AND RATCHET WRENCH TO REMOVE ARM YOKE. SET ASIDE ARM YOKE AND INNER AND OUTER BEARINGS. REMOVE THUMBWHEEL SCREW ASSEMBLY AND DISPOSE OF PROPERLY. NOTE: OLDER CHAIRS MAY HAVE SPRING AND SPRING RETAINER. REMOVE AND DISPOSE OF PROPERLY. SEE FIGURE 2.
3. REMOVE AND DISCARD THUMBWHEEL, JAMB NUT, WASHER AND BEARING FROM ARM YOKE. SEE FIGURE 2.
4. ASSEMBLE REPLACEMENT RETAINING PLATE AND FLAT SPRING TO TORX HEAD SCREW. ADD INNER SLIDE BEARING TO THUMBWHEEL SCREW ASSEMBLY LAST. SEE FIGURE 2.
5. INSTALL REPLACEMENT WASHER, BEARING, THUMBWHEEL AND JAMB NUT INTO ARM YOKE. SECURE THUMBWHEEL IN PLACE. SEE FIGURES 2 AND 3.

## NOTICE

For proper assembly, keep thumbwheel tight against inner wall of thumbwheel slot in arm yoke, closest to swing arm while tightening Torx head screw.

6. INSTALL OUTER SLIDE BEARING TO END OF ARM YOKE AND POSITION ARM YOKE TO SWING ARM. KEEPING THUMBWHEEL TIGHT AGAINST INNER WALL OF THUMBWHEEL SLOT, THREAD TORX HEAD SCREW, WITH ASSEMBLED HARDWARE, AS SHOWN INTO THUMBWHEEL. TIGHTEN SCREW UNTIL ARM YOKE HOLDS POSITIONED HEIGHT. DO NOT OVER TIGHTEN SCREW. SEE FIGURES 2 AND 3.

7. PLACE BACK FRAME UP TO SWING ARMS ALIGNING HOLES. SECURE WITH SCREWS. USING TORQUE WRENCH AND 5MM HEX BIT, TORQUE SCREWS TO 70-100 IN-LBS. SEE FIGURE 1.

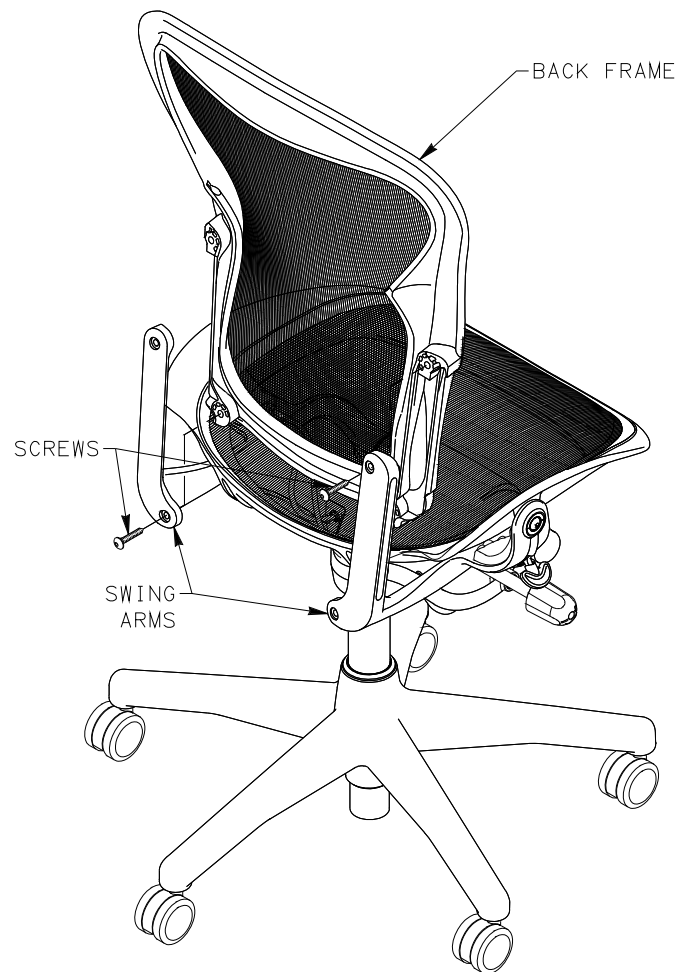


FIGURE 1

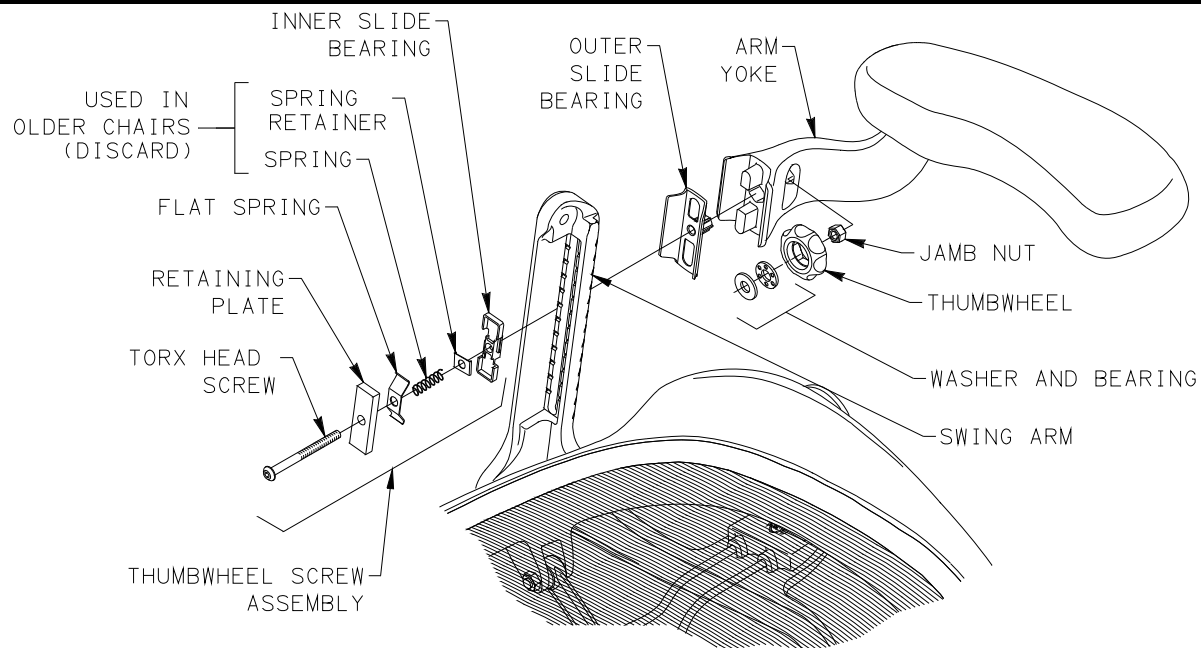


FIGURE 2

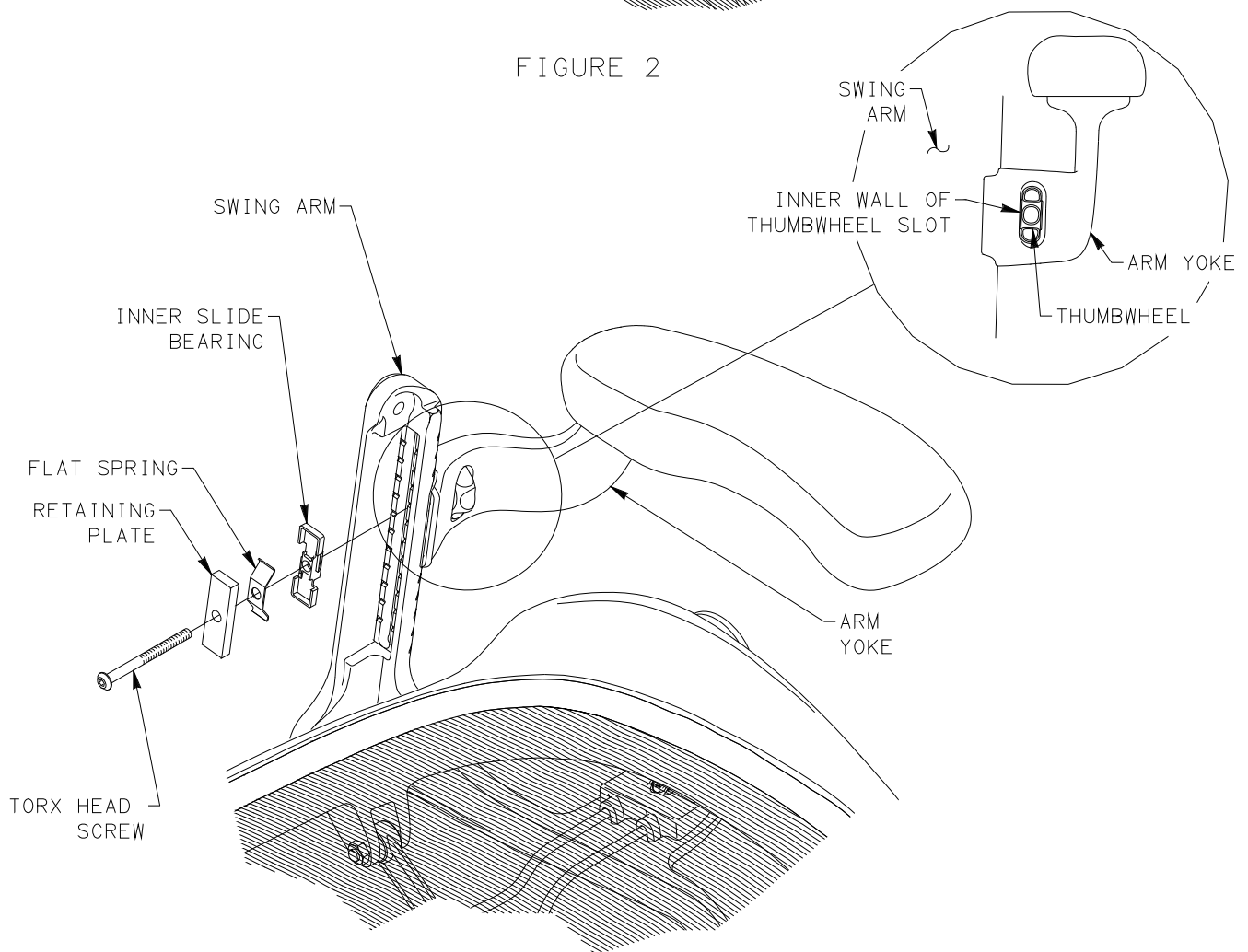
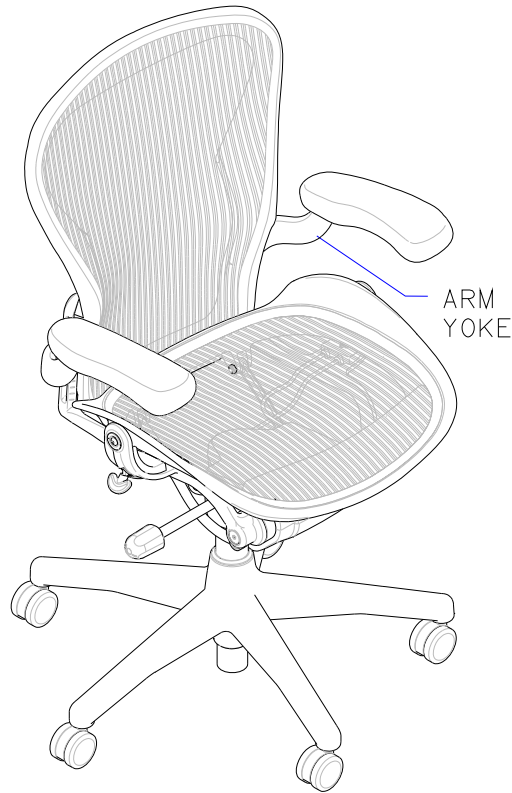
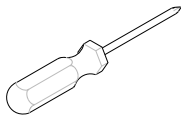


FIGURE 3

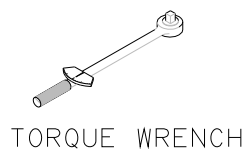
# Aeron® Adjustable Arm Yoke Pivoting Hardware Replacement



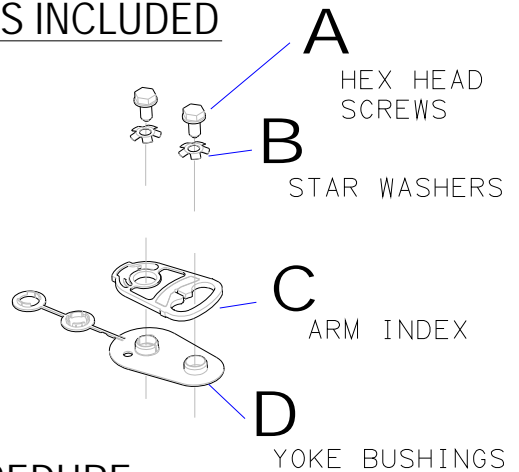
## TOOLS NEEDED



#2 PHILLIPS HEAD  
SCREWDRIVER

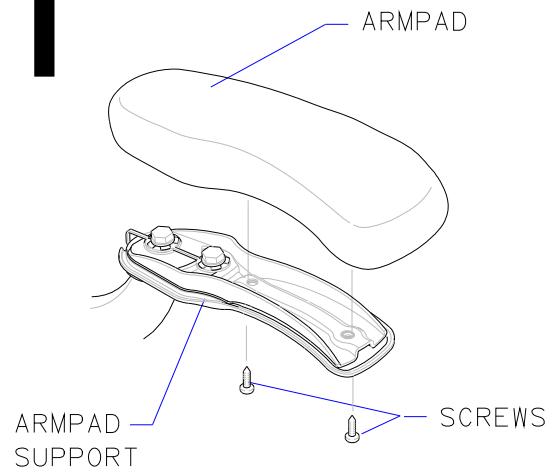


## PARTS INCLUDED



## PROCEDURE

# 1



### TO REMOVE :

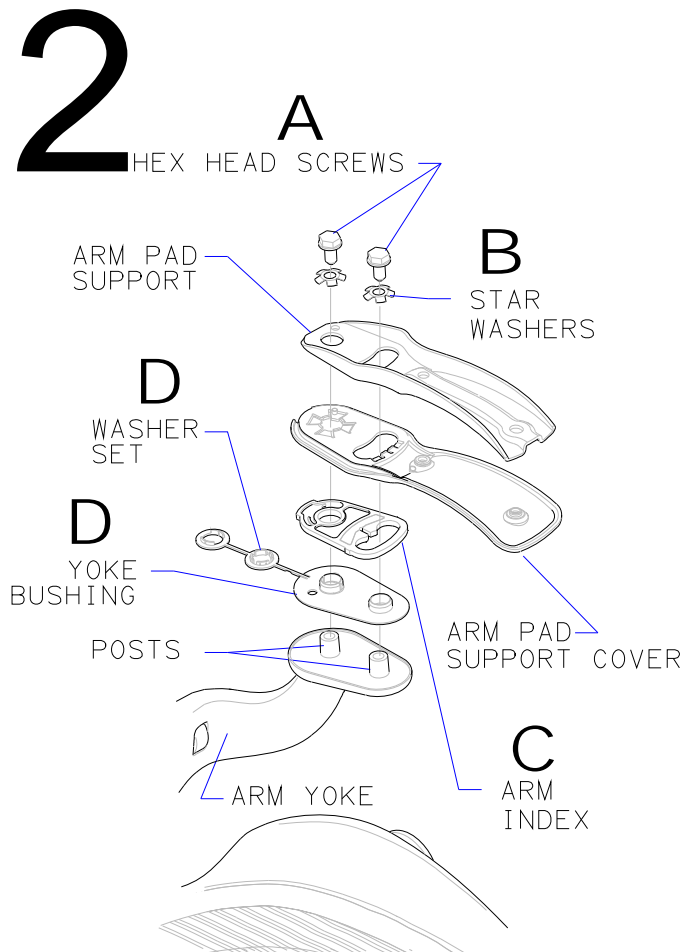
1. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE SCREWS SECURING ARM PAD TO ARM PAD SUPPORT.
2. SET ARM PAD AND SCREWS ASIDE. REPEAT PROCEDURE FOR OPPOSITE SIDE.

### TO REINSTALL :

1. PLACE ARM PAD ON ARM PAD SUPPORT. INSERT SCREWS IN ARM PAD SUPPORT AND SECURE ARM PAD USING #2 PHILLIPS HEAD SCREWDRIVER. REPEAT FOR OPPOSITE SIDE.

1B0F02 REV B

# Aeron® Adjustable Arm Yoke Pivoting Hardware Replacement



## TO REMOVE :

1. USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND PROPERLY DISPOSE OF HEX HEAD SCREWS (A) AND STAR WASHERS (B) FROM ARM PAD SUPPORT. REMOVE WASHER SET (D) FROM ARM PAD SUPPORT. REMOVE ARM PAD SUPPORT AND ARM PAD SUPPORT COVER AND SET ASIDE. REMOVE ARM INDEX (C), YOKE BUSHING (D) FROM ARM YOKE AND DISPOSE OF PROPERLY. REPEAT FOR OPPOSITE SIDE.

## TO REINSTALL :

1. PLACE YOKE BUSHING (D) AND ARM INDEX (C) ON ARM YOKE. PLACE ARM PAD SUPPORT COVER AND ARM PAD SUPPORT ON ARM YOKE. SWING WASHER SET (D) ONTO POSTS OF ARM YOKE. SECURE WITH STAR WASHERS (B) AND HEX HEAD SCREWS (A). TIGHTEN WITH 13MM RATCHET WRENCH. TORQUE TO 200-250 IN LBS. REPEAT FOR OPPOSITE SIDE.

1B0F02 REV B

# Aeron® Arm Pad Support Replacement (used on product before 10-07-2002)

TOOLS REQUIRED: #2 PHILLIPS HEAD SCREWDRIVER  
13MM SOCKET  
RATCHET WRENCH  
TORQUE WRENCH, 250 IN-LBS CAPACITY  
PLIERS

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

## NONADJUSTABLE ARM PAD SUPPORT REPLACEMENT:

1. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND SET ASIDE (2) SCREWS FASTENING ARM PAD TO ARM PAD SUPPORT. REMOVE ARM PAD BY PULLING UP AND PIVOTING BACK FROM FRONT EDGE. SET ARM PAD ASIDE. SEE FIGURES 1 & 5.
2. USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND SAVE HEX HEAD SCREWS WITH WASHERS, SECURING ARM PAD SUPPORT TO ARM YOKE. REMOVE AND PROPERLY DISPOSE OF ARM PAD SUPPORT. SEE FIGURE 2.
3. INSTALL REPLACEMENT ARM PAD SUPPORT TO ARM YOKE. REINSTALL HEX HEAD SCREWS WITH WASHERS. TIGHTEN AND TORQUE SCREWS TO 200-250 IN-LBS. SEE FIGURE 2.
4. INSTALL ARM PAD ONTO ARM PAD SUPPORT BY INSERTING TAB ON ARM PAD SUPPORT INTO SLOT IN ARM PAD AND PIVOTING DOWN ONTO ARM PAD SUPPORT. REINSTALL AND TIGHTEN SCREWS SECURING ARM PAD. SEE FIGURES 1 & 6.

## ADJUSTABLE ARM PAD SUPPORT REPLACEMENT:

1. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND SET ASIDE (2) SCREWS FASTENING ARM PAD TO ARM PAD SUPPORT. REMOVE ARM PAD BY PULLING UP AND PIVOTING BACK FROM FRONT EDGE. SET ARM PAD ASIDE. SEE FIGURES 1 & 6.
2. USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND SAVE HEX HEAD SCREWS, STAR WASHER, STEEL WASHER, AND NYLON WASHERS SECURING ARM PAD SUPPORT TO ARM YOKE. REMOVE ARM PAD SUPPORT FROM ARM YOKE. REMOVE TORSION SPRING FROM ARM PAD SUPPORT AND SET ASIDE. PROPERLY DISPOSE OF ARM PAD SUPPORT. SEE FIGURE 3.
3. INSTALL REPLACEMENT ARM PAD SUPPORT TO ARM YOKE AND REINSTALL NYLON WASHERS, STAR WASHER AND STEEL WASHER SECURING WITH HEX HEAD SCREWS. TIGHTEN AND TORQUE SCREWS TO 200-250 IN-LBS. SEE FIGURE 3.
4. INSTALL TORSION SPRING INTO ARM PAD SUPPORT BY INSERTING CURVED END OF TORSION SPRING INTO OPEN CAVITY OF INDEX BUSHING THROUGH TORSION SPRING MOUNTING HOLE. THE TORSION SPRING SHOULD BE PARTIALLY SEATED INTO MOUNTING HOLE WITH FREE END OF TORSION SPRING RESTING ON ARM PAD SUPPORT. SEE FIGURE 4.

5. GRASP FREE END OF TORSION SPRING WITH PLIERS. LOAD TORSION SPRING BY TWISTING SPRING AND POSITIONING FREE END OF TORSION SPRING AGAINST INSIDE VERTICAL SURFACE BETWEEN RETAINING BOSSES. SEE FIGURE 5.
6. INSTALL ARM PAD ONTO ARM PAD SUPPORT BY INSERTING TAB ON ARM PAD SUPPORT INTO SLOT IN ARM PAD AND PIVOTING DOWN ONTO ARM PAD SUPPORT. SECURE WITH SCREWS. SEE FIGURES 1 & 6.

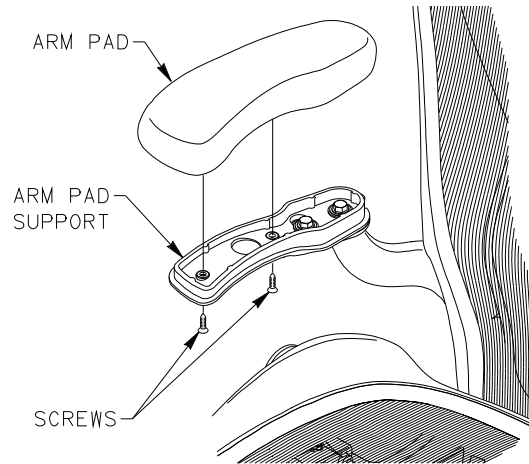


FIGURE 1

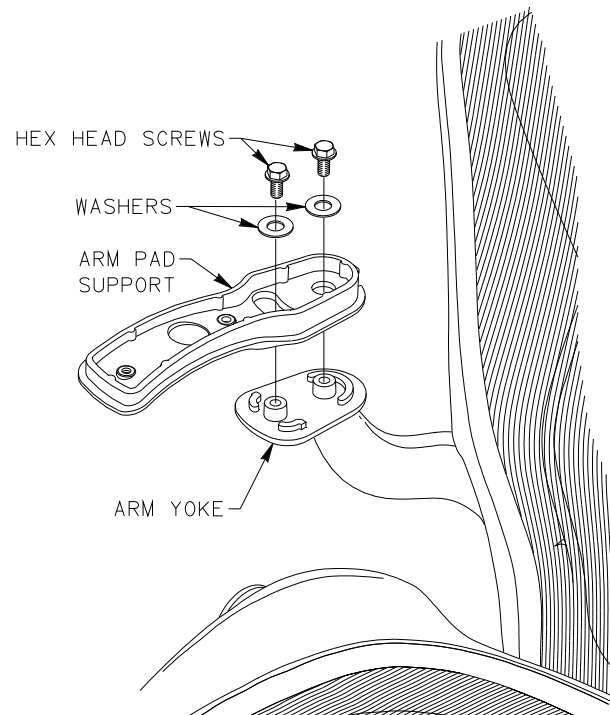


FIGURE 2

167213 REV C

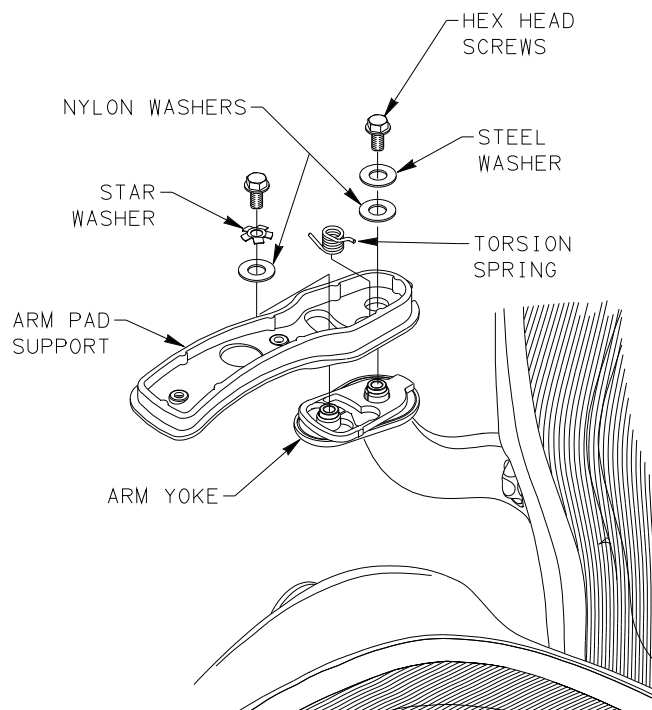


FIGURE 3

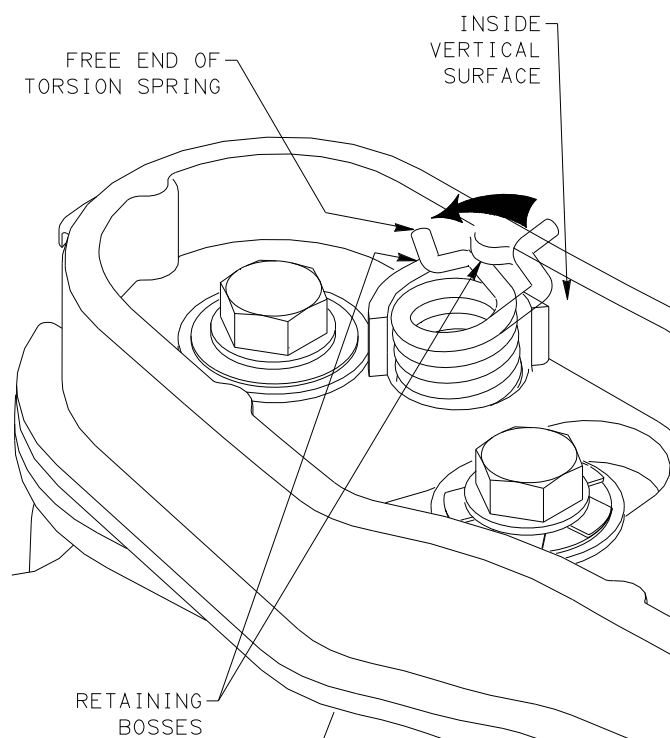


FIGURE 5

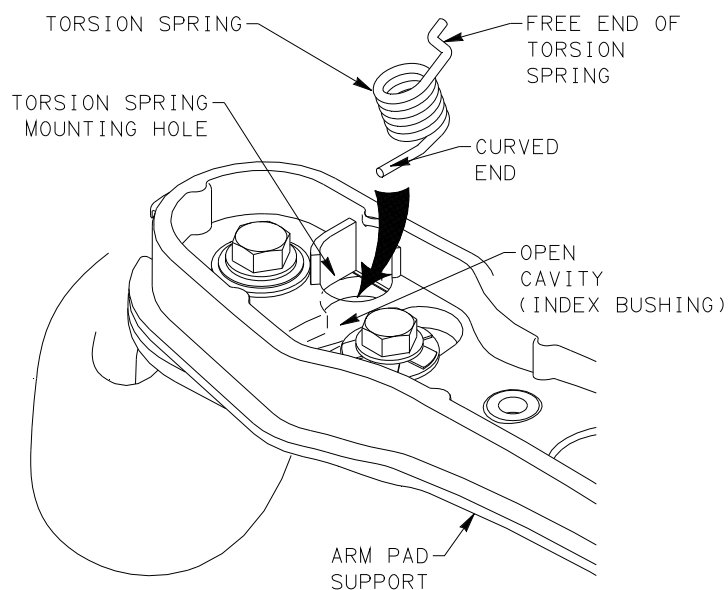


FIGURE 4

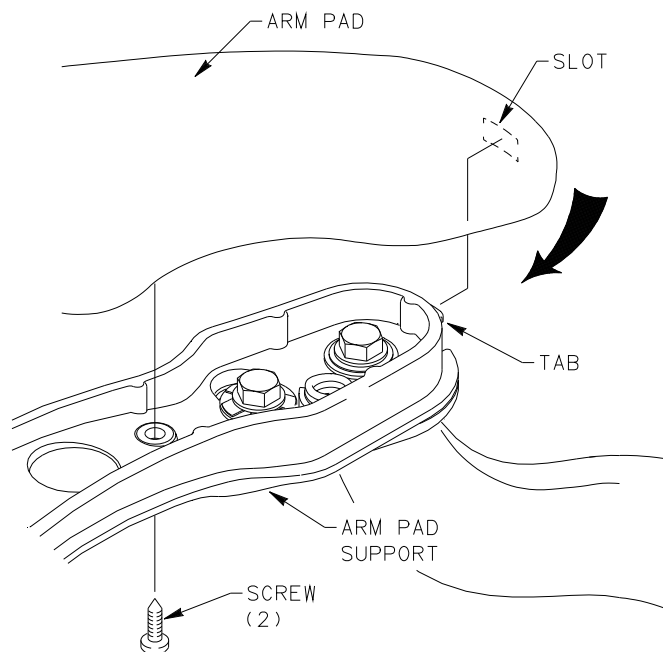
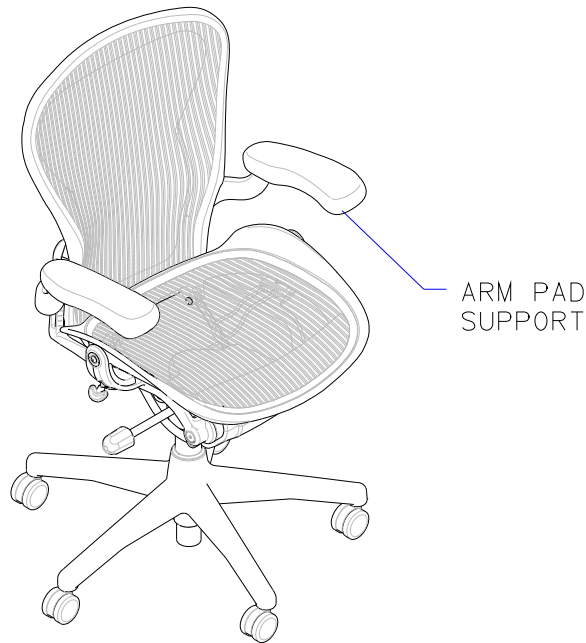


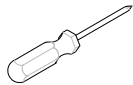
FIGURE 6

167213 REV C

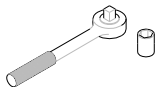
# Aeron® Arm Pad Support Replacement



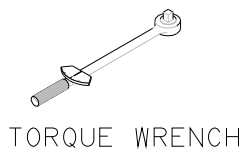
## TOOLS NEEDED



#2 PHILLIPS HEAD  
SCREWDRIVER

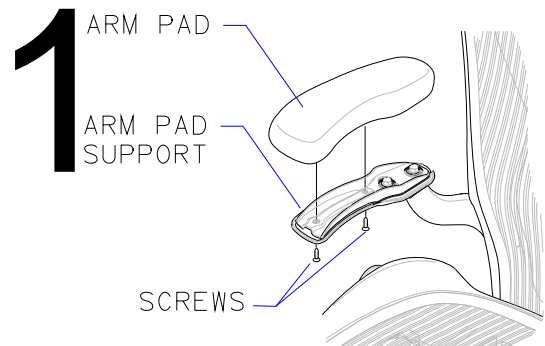
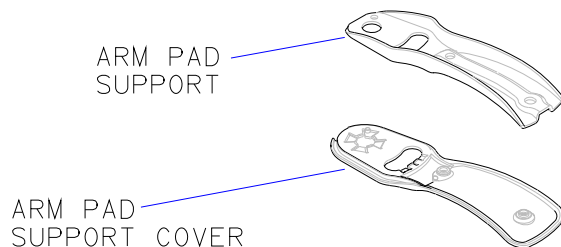


RATCHET WRENCH W/  
13MM SOCKET



TORQUE WRENCH

## PARTS INCLUDED



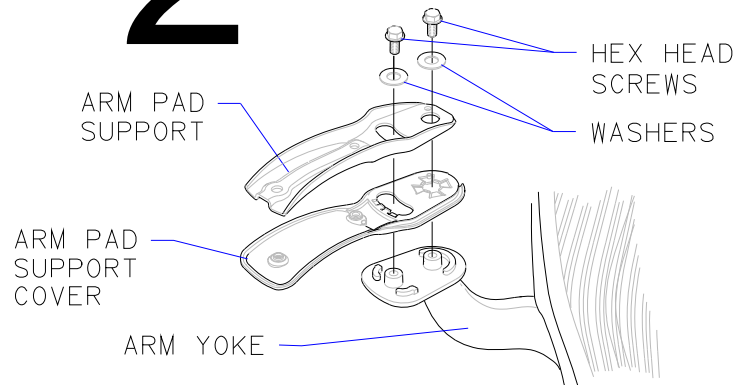
### TO REMOVE :

1. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SET ASIDE (2) SCREWS FASTENING ARM PAD TO ARM PAD SUPPORT. PULL ARM PAD UP FROM ARM PAD SUPPORT. SET ARM PAD ASIDE.

### TO REINSTALL :

1. PLACE ARM PAD ON ARM PAD SUPPORT. INSERT SCREWS IN ARM PAD SUPPORT AND SECURE ARM PAD USING #2 PHILLIPS HEAD SCREWDRIVER.

## 2 FIXED ARM PAD SUPPORT REPLACEMENT



### TO REMOVE :

1. USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND SET ASIDE HEX HEAD SCREWS WITH WASHERS, SECURING ARM PAD AND ARM SUPPORT COVER TO ARM YOKE. REMOVE AND PROPERLY DISPOSE OF ARM PAD SUPPORT AND ARM PAD SUPPORT COVER. NOTE: EARLIER VERSION WAS ONE PIECE ALUMINUM CASTING.

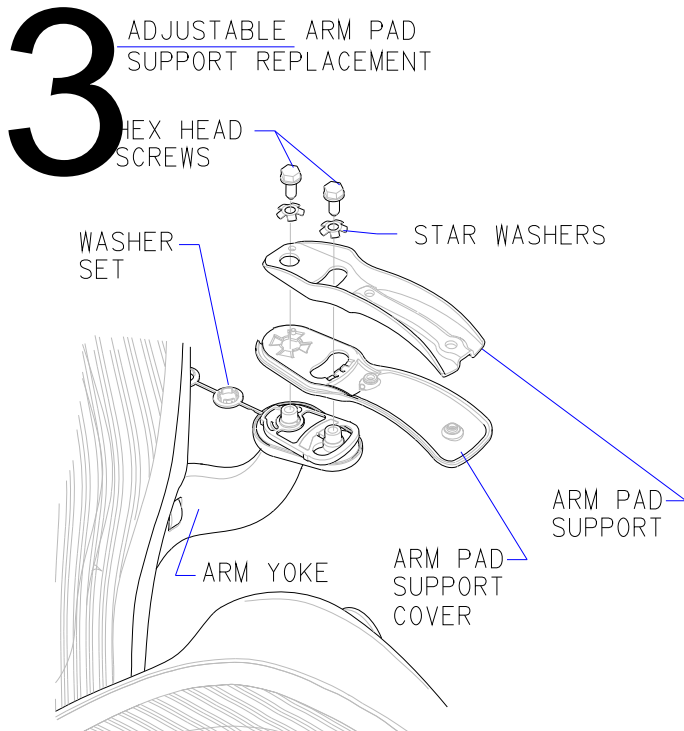
### TO REINSTALL :

2. INSTALL REPLACEMENT ARM SUPPORT COVER AND ARM PAD SUPPORT TO ARM YOKE AND SECURE WITH HEX HEAD SCREWS AND WASHERS. TIGHTEN AND TORQUE TO 200-250 IN LBS, USING TORQUE WRENCH.

1BOF01 REV B



# Aeron® Arm Pad Support Replacement



## TO REMOVE:

1. USING 13MM SOCKET AND RATCHET WRENCH, REMOVE HEX HEAD SCREWS, STAR WASHERS AND WASHER SET FROM ARM YOKE, SECURING ARM PAD SUPPORT. REMOVE ARM PAD SUPPORT AND ARM PAD SUPPORT COVER FROM ARM YOKE AND DISPOSE OF PROPERLY. NOTE: EARLIER VERSION WAS ONE PIECE ALUMINUM CASTING.

## TO REINSTALL:

1. PLACE REPLACEMENT ARM PAD SUPPORT COVER AND ARM PAD SUPPORT ON ARM YOKE. SWING OVER WASHER SET ON ARM PAD SUPPORT. REINSTALL STAR WASHERS AND HEX HEAD SCREWS. TIGHTEN AND TORQUE TO 200-250 IN LBS.

1B0F01 REV B

# Aeron® Arm Yoke Replacement

TOOLS REQUIRED: 5MM HEX BIT  
RATCHET WRENCH  
#2 PHILLIPS HEAD SCREWDRIVER  
13MM SOCKET  
T-27 TORX BIT  
TORQUE WRENCH WITH 250 IN-LBS CAPACITY  
PLIERS

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### ⚠ WARNING

Support back frame while removing screws used in attaching back frame to swing arms. Failure to do so could allow back frame to fall causing product damage or personal injury.

### ⚠ CAUTION

Support arm yoke while removing from swing arm. Failure to do so could cause product damage.

- ✂. WHILE SUPPORTING BACK FRAME USE 5MM HEX BIT AND RATCHET WRENCH, TO REMOVE (4) SCREWS ATTACHING BACK FRAME TO SWING ARMS. SET ASIDE SCREWS. REMOVE BACK FRAME AND SET ASIDE. SEE FIGURE 1.

2. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND SET ASIDE (2) SCREWS FASTENING ARM PAD TO ARM PAD SUPPORT. REMOVE ARM PAD BY PULLING UP AND PIVOTING BACK FROM FRONT EDGE. SET ASIDE ARM PAD. SEE FIGURE 2.

- ✂. FOR ARM PAD SUPPORT REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:

-FOR FIXED ARM, USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND SAVE HEX HEAD SCREWS WITH WASHERS, SECURING ARM PAD SUPPORT TO ARM YOKE. REMOVE AND SET ASIDE ARM PAD SUPPORT. SEE FIGURE 3.

-FOR VERTICALLY ADJUSTABLE ARM, USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND SAVE HEX HEAD SCREWS AND (4) NYLON WASHERS, SECURING ARM PAD SUPPORT TO ARM YOKE. REMOVE AND SET ASIDE ARM PAD SUPPORT AND VERTICALLY ADJUSTABLE SPACER. NOTE: OLDER CHAIRS MAY HAVE (2) STEEL AND (2) NYLON WASHERS. REMOVE AND SET ASIDE. SEE FIGURE 4.

-FOR ADJUSTABLE ARM, USING 13MM SOCKET AND RATCHET WRENCH, REMOVE AND SAVE HEX HEAD SCREWS, STAR WASHERS, AND NYLON WASHERS SECURING ARM PAD SUPPORT TO ARM YOKE. REMOVE ARM PAD SUPPORT FROM ARM YOKE AND SET ASIDE. REMOVE TORSION SPRING FROM ARM PAD SUPPORT AND SET ASIDE. REMOVE YOKE AND INDEX BUSHING FROM ARM YOKE AND SET ASIDE. SEE FIGURE 5.

### NOTICE

At disassembly, on adjustable arms, keep thumbwheel from spinning.

4. FOR ARM YOKE REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:

-FOR FIXED ARM, USING T-27 TORX BIT AND RATCHET WRENCH, REMOVE AND SET ASIDE TORX HEAD SCREW HOLDING ARM YOKE TO SWING ARM. REMOVE ARM YOKE AND DISPOSE OF PROPERLY. SEE FIGURE 6.

-FOR ADJUSTABLE ARM, WHILE SUPPORTING ARM YOKE AND HOLDING THUMBWHEEL, USE T-27 TORX BIT AND RATCHET WRENCH TO REMOVE ARM YOKE. SET ASIDE THUMBWHEEL SCREW ASSEMBLY. REMOVE ARM YOKE AND DISPOSE OF PROPERLY. NOTE: OLDER CHAIRS HAVE SPRING AND SPRING RETAINER. REMOVE AND DISPOSE OF PROPERLY. SEE FIGURE 7.

### NOTICE

Keep thumbwheel tight against inner wall of thumbwheel slot in arm yoke, closest to swing arm, while tightening Torx head screw.

- ✂. FOR ARM YOKE INSTALLATION, FOLLOW APPROPRIATE PROCEDURE BELOW:

-FOR FIXED ARM, INSTALL ARM YOKE TO SWING ARM. INSERT RETAINING PLATE AND TORX HEAD SCREW. TIGHTEN AND TORQUE TO 100-125 IN-LBS. SEE FIGURE 6.

-FOR VERTICALLY ADJUSTABLE AND FULLY ADJUSTABLE ARMS, INSTALL JAMB NUT INTO REPLACEMENT ARM YOKE. INSTALL WASHER AND BEARING INTO THUMBWHEEL. INSTALL THUMBWHEEL INTO THUMBWHEEL SLOT AND HOLD THUMBWHEEL ASSEMBLY IN PLACE. INSTALL OUTER SLIDE BEARING TO ARM YOKE AND POSITION ARM YOKE TO SWING ARM. WHILE HOLDING THUMBWHEEL AGAINST INNER WALL OF THUMBWHEEL SLOT, INSTALL THUMBWHEEL SCREW ASSEMBLY TO ARM YOKE. TIGHTEN TORX HEAD SCREW UNTIL ARM YOKE HOLDS POSITIONED HEIGHT. DO NOT OVERTIGHTEN. SEE FIGURES 7 AND 8.

- ✂. INSTALL ARM PAD SUPPORT AS FOLLOWS:

-FOR FIXED ARMS, INSTALL ARM PAD SUPPORT, (2) WASHERS, AND HEX HEAD SCREWS TO ARM YOKE. TORQUE SCREWS TO 200-250 IN-LBS. SEE FIGURE 3.

-FOR VERTICALLY ADJUSTABLE ARMS, INSTALL VERTICALLY ADJUSTABLE SPACER TO ARM YOKE WITH TAB POINTING TO OUTSIDE OF ARM YOKE. INSTALL ARM PAD SUPPORT, (4) NYLON WASHERS AND HEX HEAD SCREWS TO ARM YOKE. TORQUE SCREWS TO 200-250 IN-LBS. IF CHAIR HAS (2) STEEL WASHERS AND (2) NYLON WASHERS, INSTALL AS INSTRUCTED ABOVE.

-FOR ADJUSTABLE ARMS, INSTALL ARM INDEX BUSHING AND YOKE BUSHING ON ARM YOKE. TAB ON INDEX BUSHING IS TO BE POINTING TO OUTSIDE OF ARM YOKE. INSTALL ARM PAD SUPPORT TO ARM YOKE AND REINSTALL NYLON WASHERS AND STAR WASHERS SECURING WITH HEX HEAD SCREWS. TIGHTEN AND TORQUE SCREWS TO 200-250 IN-LBS. SEE FIGURE 5.

167211 REV E

✗ INSTALL TORSION SPRING INTO ARM PAD SUPPORT BY INSERTING CURVED END OF TORSION SPRING INTO OPEN CAVITY OF INDEX BUSHING THROUGH TORSION SPRING MOUNTING HOLE. TORSION SPRING SHOULD BE PARTIALLY SEATED INTO MOUNTING HOLE WITH FREE END OF TORSION SPRING RESTING ON ARM PAD SUPPORT. SEE FIGURE 9.

✗ GRASP FREE END OF TORSION SPRING WITH PLIERS. LOAD TORSION SPRING BY TWISTING SPRING AND POSITIONING FREE END OF TORSION SPRING AGAINST INSIDE VERTICAL SURFACE BETWEEN RETAINING BOSSES. SEE FIGURE 10.

7. INSTALL ARM PAD ONTO ARM PAD SUPPORT BY INSERTING TAB ON ARM PAD SUPPORT INTO SLOT IN ARM PAD AND PIVOTING DOWN ONTO ARM PAD SUPPORT. SECURE WITH SCREWS. SEE FIGURES 1 & 11.
8. PLACE BACK FRAME UP TO SWING ARMS ALIGNING HOLES. SECURE WITH SCREWS. TIGHTEN AND TORQUE SCREWS TO 70-100 IN-LBS. SEE FIGURE 1.

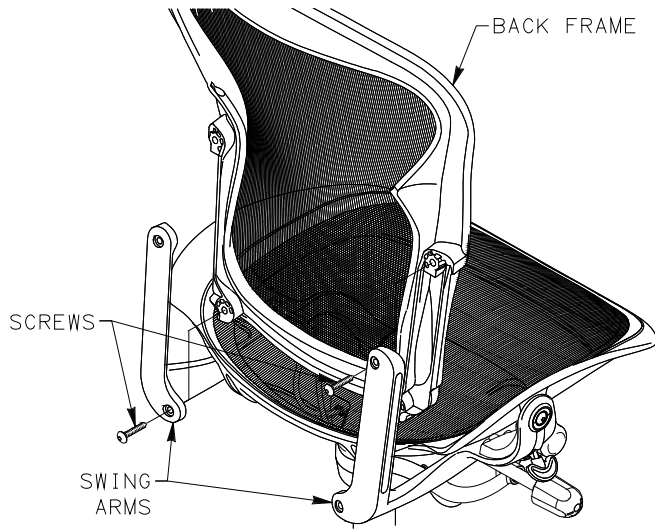


FIGURE 1

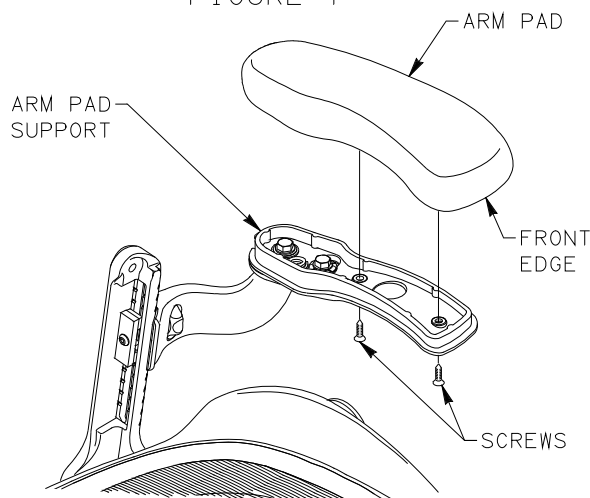


FIGURE 2

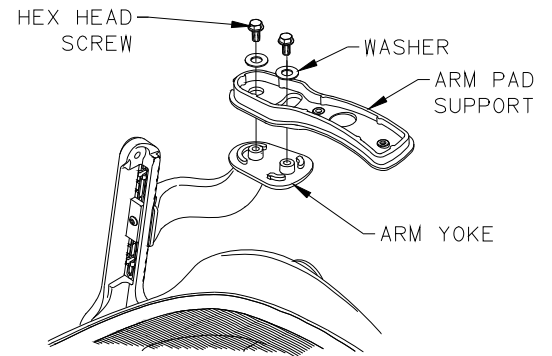


FIGURE 3  
(FIXED ARM)

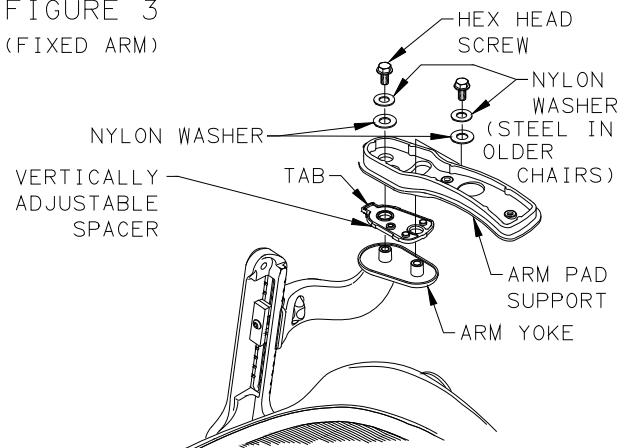


FIGURE 4  
(VERTICALLY ADJUSTABLE ARM)

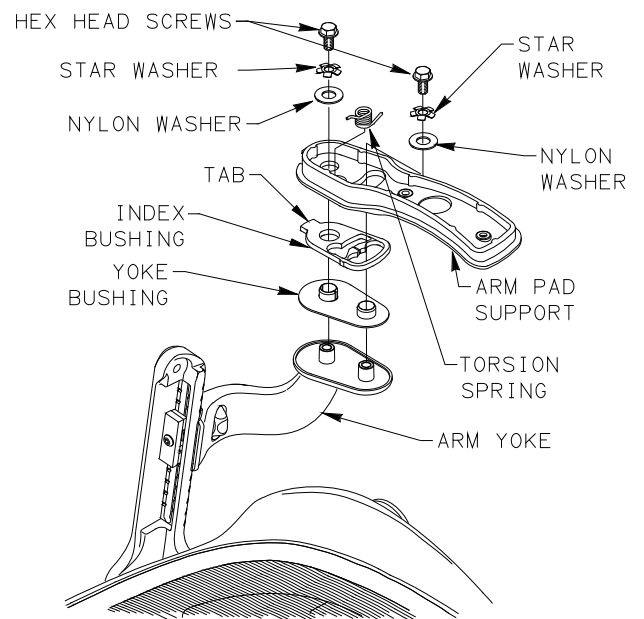


FIGURE 5  
(ADJUSTABLE ARM)

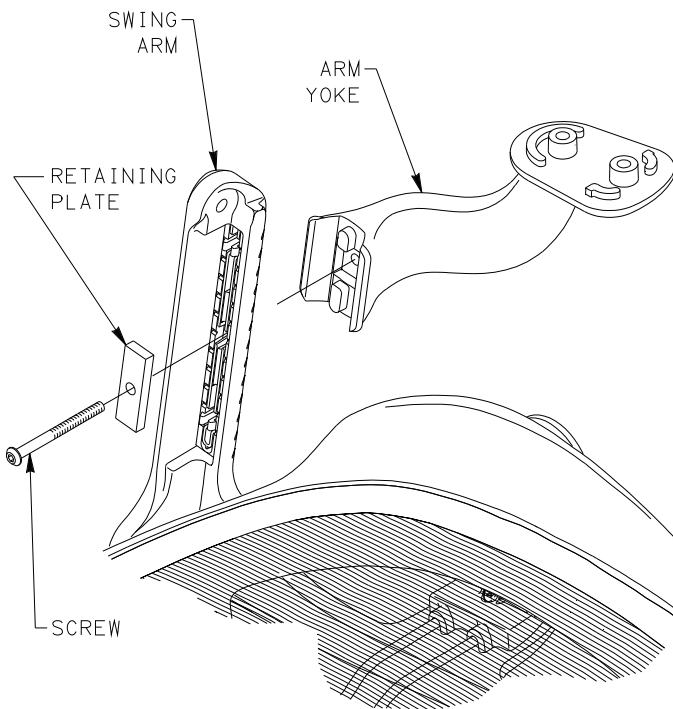


FIGURE 5  
(NON ADJUSTABLE ARM)

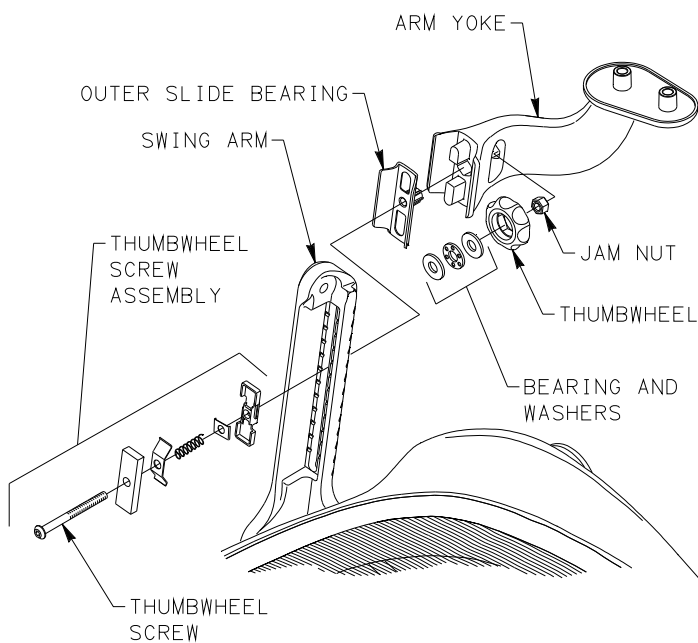


FIGURE 6  
(ADJUSTABLE ARM)

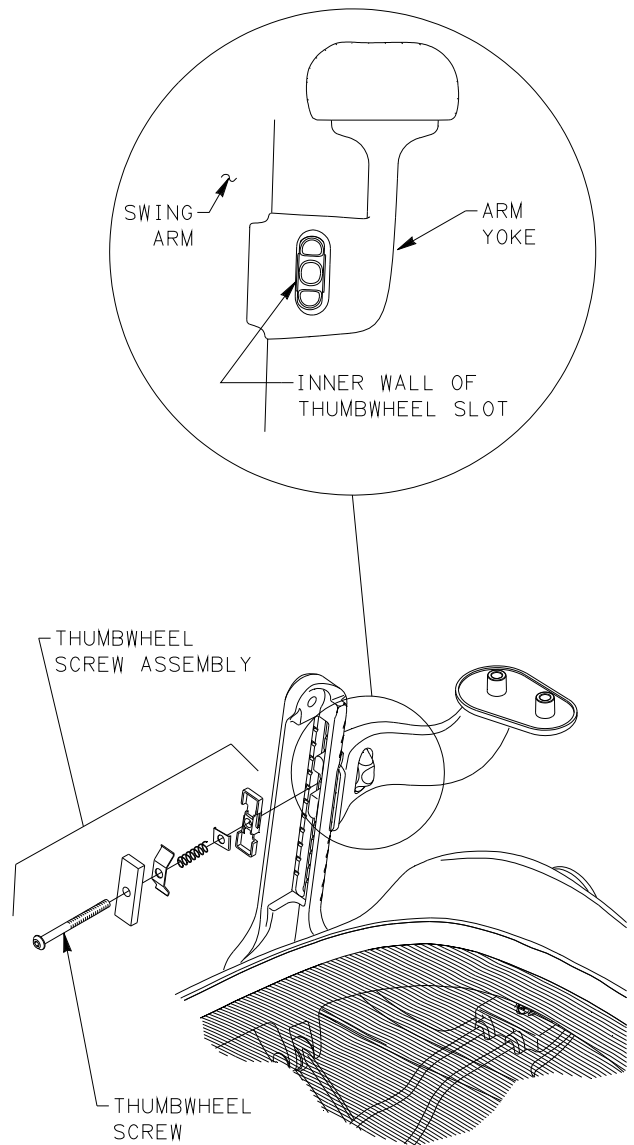


FIGURE 7

167211 REV C

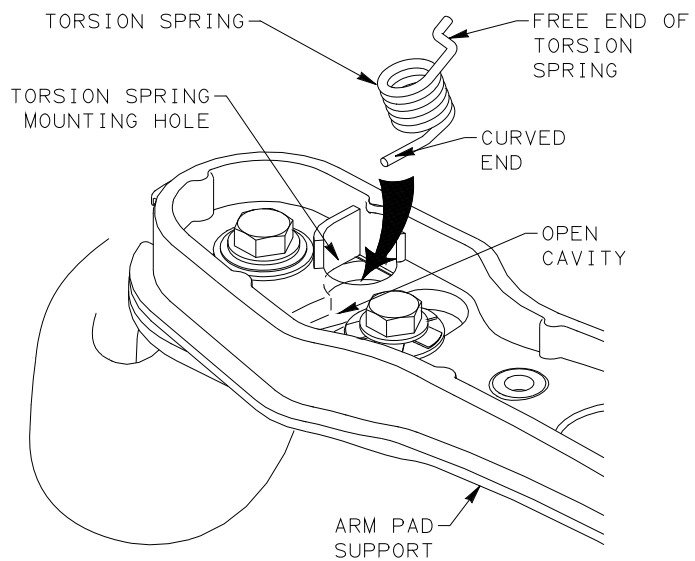


FIGURE 9

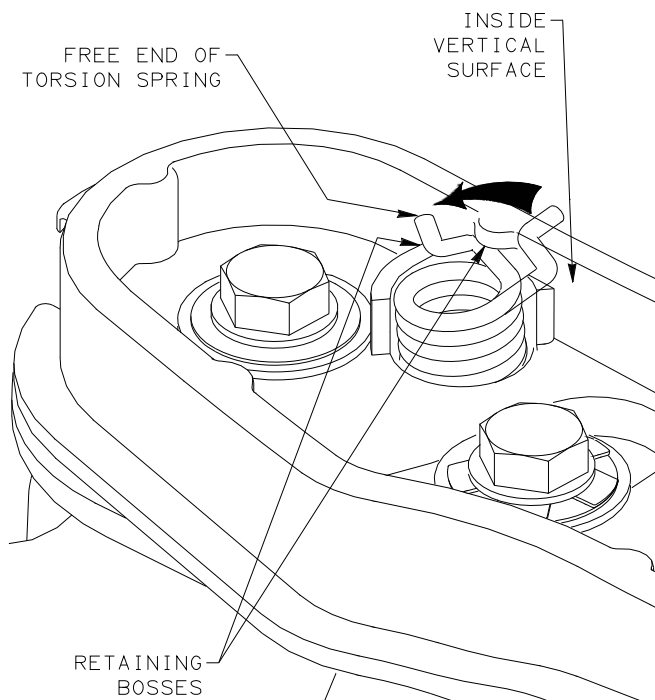


FIGURE 10

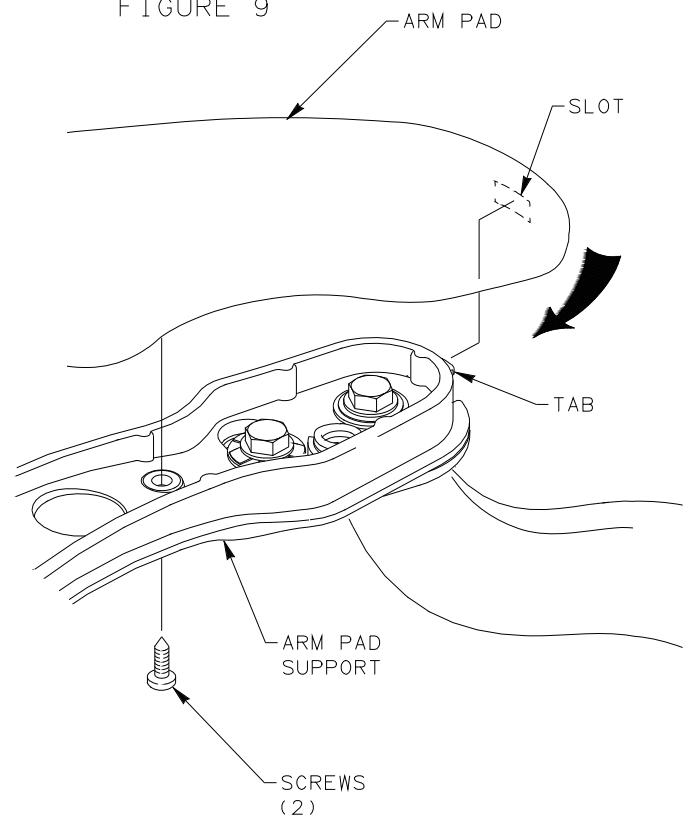


FIGURE 11

# Aeron® Seat Link Bushing Replacement

TOOLS REQUIRED: 10MM SOCKET  
RATCHET WRENCH  
4MM HEX KEY  
6MM HEX BIT  
TORQUE WRENCH, 150 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### CAUTION

Support seat link while removing seat link from chair. Failure to do so could cause seat link to fall causing product damage.

1. WHILE SUPPORTING SEAT LINK USE 10MM SOCKET, RATCHET WRENCH AND 4MM HEX KEY TO REMOVE NUT, SCREW AND SPACER ATTACHING SEAT LINK TO SEAT FRAME. SET ASIDE NUT, SCREW AND SPACER. REPEAT FOR OPPOSITE SIDE. SEE FIGURE 1.
2. WHILE SUPPORTING SEAT LINK USE 6MM HEX BIT AND RATCHET WRENCH TO REMOVE SHOULDER SCREW AND SPACER ATTACHING SEAT LINK TO TILT. SET ASIDE SHOULDER SCREW AND SPACER. REMOVE SEAT LINK WITH BUSHINGS. REPEAT FOR OPPOSITE SIDE. SEE FIGURE 1.
3. REMOVE AND DISCARD (4) BUSHINGS FROM SEAT LINK. INSERT (4) REPLACEMENT BUSHINGS INTO SEAT LINK ORIENTING BUSHINGS TO NOTCHED AREA IN SEAT LINK. REPEAT FOR OPPOSITE SIDE. SEE FIGURE 2.

### NOTICE

For ease of assembly, hold bushings in seat link while attaching to chair.

5. WHILE HOLDING BUSHINGS IN FRONT MOUNT OF SEAT LINK, ATTACH FRONT MOUNT OF SEAT LINK TO TILT WITH SPACER AND SHOULDER SCREW. TIGHTEN AND TORQUE SCREW TO 120-150 IN-LBS. REPEAT FOR OPPOSITE SIDE. SEE FIGURE 1.
6. MAKE CERTAIN SPACER AND ALL BUSHINGS ARE ACCOUNTED FOR AND BUSHINGS ARE ORIENTED TO NOTCH IN SEAT LINK. WHILE HOLDING BUSHINGS IN SEAT LINK, ATTACH SEAT LINK TO SEAT FRAME WITH SCREW, SPACER AND NUT. TIGHTEN NUT UNTIL FLUSH WITH END OF SCREW. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 AND 2.

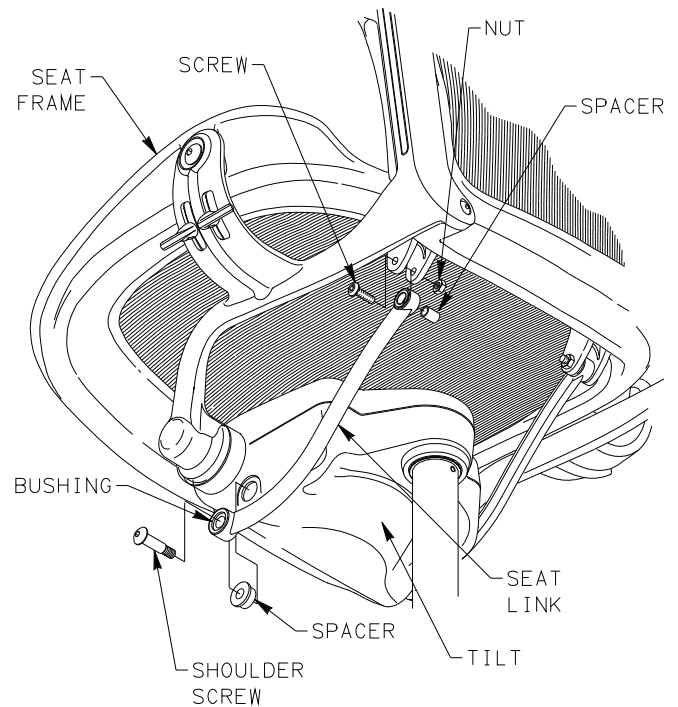


FIGURE 1  
(VIEWING FROM UNDERSIDE)

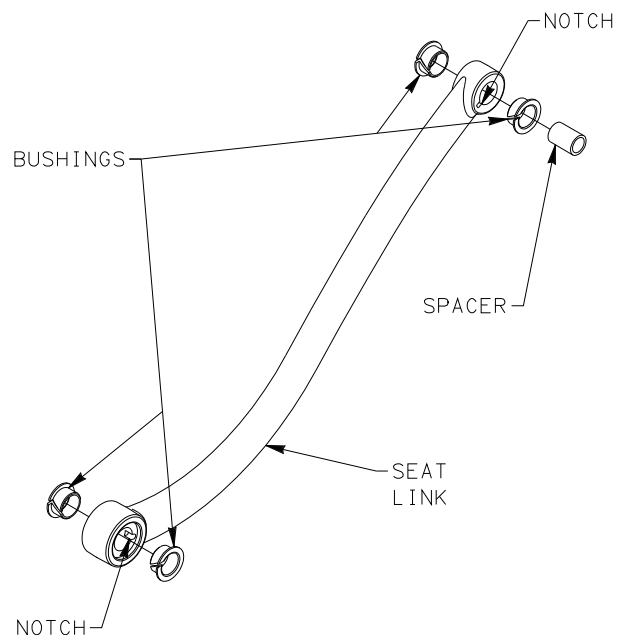


FIGURE 2

167210 REV B

# Aeron® Side Chair Seat Frame Replacement

TOOLS REQUIRED: 4MM HEX BIT  
(2) RATCHET WRENCHES  
10MM SOCKET HEAD  
6MM HEX BIT  
TORQUE WRENCH, 200 IN-LBS CAPACITY

## PROCEDURE:

1. USING 4MM HEX BIT WITH RATCHET WRENCH AND 10MM SOCKET HEAD WITH RATCHET WRENCH, REMOVE SHOULDER SCREW AND HEX NUT FROM REAR SEAT MOUNTS AND SET ASIDE. SET ASIDE BUMPERS. SEE FIGURE 1.

### CAUTION

If threaded inserts turn while removing screws from seat frame, STOP IMMEDIATELY and follow instructions.

2. USING 6MM HEX BIT AND RATCHET WRENCH, REMOVE SCREWS FROM BASE. IF THREADED INSERT TURNS WITH SCREW, STOP IMMEDIATELY AND DO THE FOLLOWING STEP. TIGHTEN SCREWS INTO THREADED INSERT AS MUCH AS POSSIBLE. USING A QUICK JERKING MOTION WITH RATCHET WRENCH, BACKOUT SCREW FROM THREADED INSERT. IF THREADED INSERT STILL TURNS WITH SCREW, REPEAT. REMOVE SEAT AND DISPOSE OF PROPERLY. SET ASIDE SPACERS AND SCREWS. SEE FIGURE 1.
3. PLACE REPLACEMENT SEAT FRAME ALONG WITH SPACERS BETWEEN BASE AND SECURE WITH (2) SCREWS, USING 6MM HEX BIT AND RATCHET WRENCH. TORQUE SCREWS TO 180-200 IN LBS. SEE FIGURE 1.
4. INSERT SHOULDER SCREW THROUGH SEAT MOUNT ON SEAT FRAME AND BASE. USING 4MM HEX BIT WITH RATCHET WRENCH AND 10MM SOCKET HEAD WITH RATCHET WRENCH, TIGHTEN SHOULDER SCREW AND HEX NUT AND TORQUE TO 180-200 IN LBS. SNAP BUMPERS IN PLACE OVER SHOULDER SCREWS AND BASE. SEE FIGURE 1.

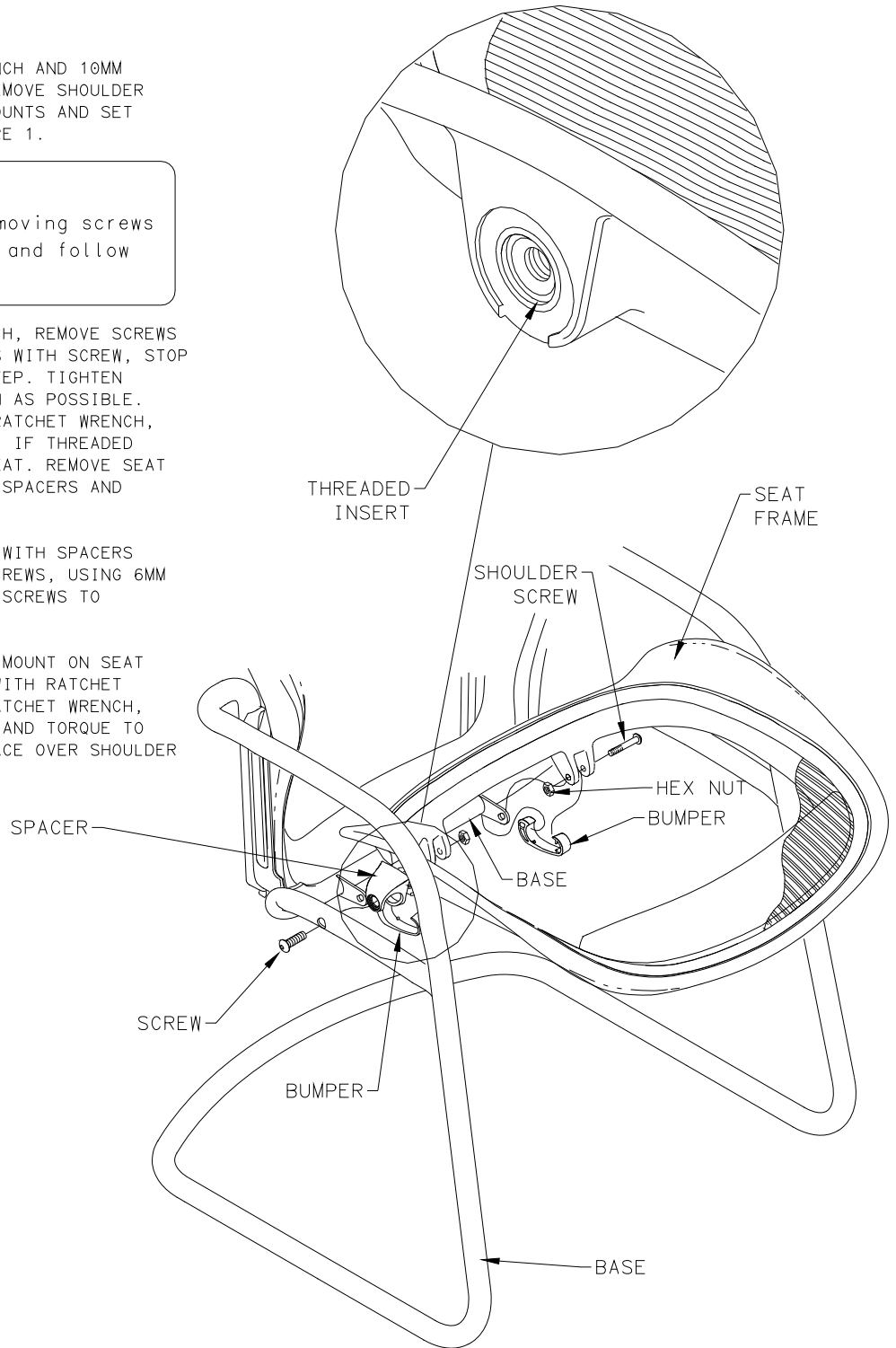


FIGURE 1

179162 REV B

# Aeron® Seat Link Replacement

TOOLS REQUIRED: 10MM SOCKET  
RATCHET WRENCH  
4MM HEX KEY  
6MM HEX BIT  
TORQUE WRENCH, 150 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### CAUTION

Support seat link while removing seat link from chair. Failure to do so could cause seat link to fall causing product damage.

1. WHILE SUPPORTING SEAT LINK USE 10MM SOCKET, RATCHET WRENCH AND 4MM HEX KEY TO REMOVE NUT, SCREW AND SPACER (IF PRESENT) ATTACHING SEAT LINK TO SEAT FRAME. SET ASIDE NUT, SCREW AND DISCARD SPACER. SEE FIGURE 1.
2. WHILE SUPPORTING SEAT LINK USE 6MM HEX BIT AND RATCHET WRENCH TO REMOVE SHOULDER SCREW AND SPACER (IF PRESENT) ATTACHING SEAT LINK TO TILT. SET ASIDE SHOULDER SCREW AND DISCARD SPACER. REMOVE SEAT LINK WITH BUSHINGS AND DISPOSE OF PROPERLY. SEE FIGURE 1.
3. ATTACH FRONT MOUNT OF SEAT LINK TO TILT WITH SHOULDER SCREW. TIGHTEN AND TORQUE SCREW TO 120-150 IN-LBS. SEE FIGURE 1.
4. ATTACH SEAT LINK TO SEAT FRAME WITH SCREW AND NUT. TIGHTEN NUT UNTIL FLUSH WITH END OF SCREW. REPEAT FOR OPPOSITE SIDE. SEE FIGURE 1.

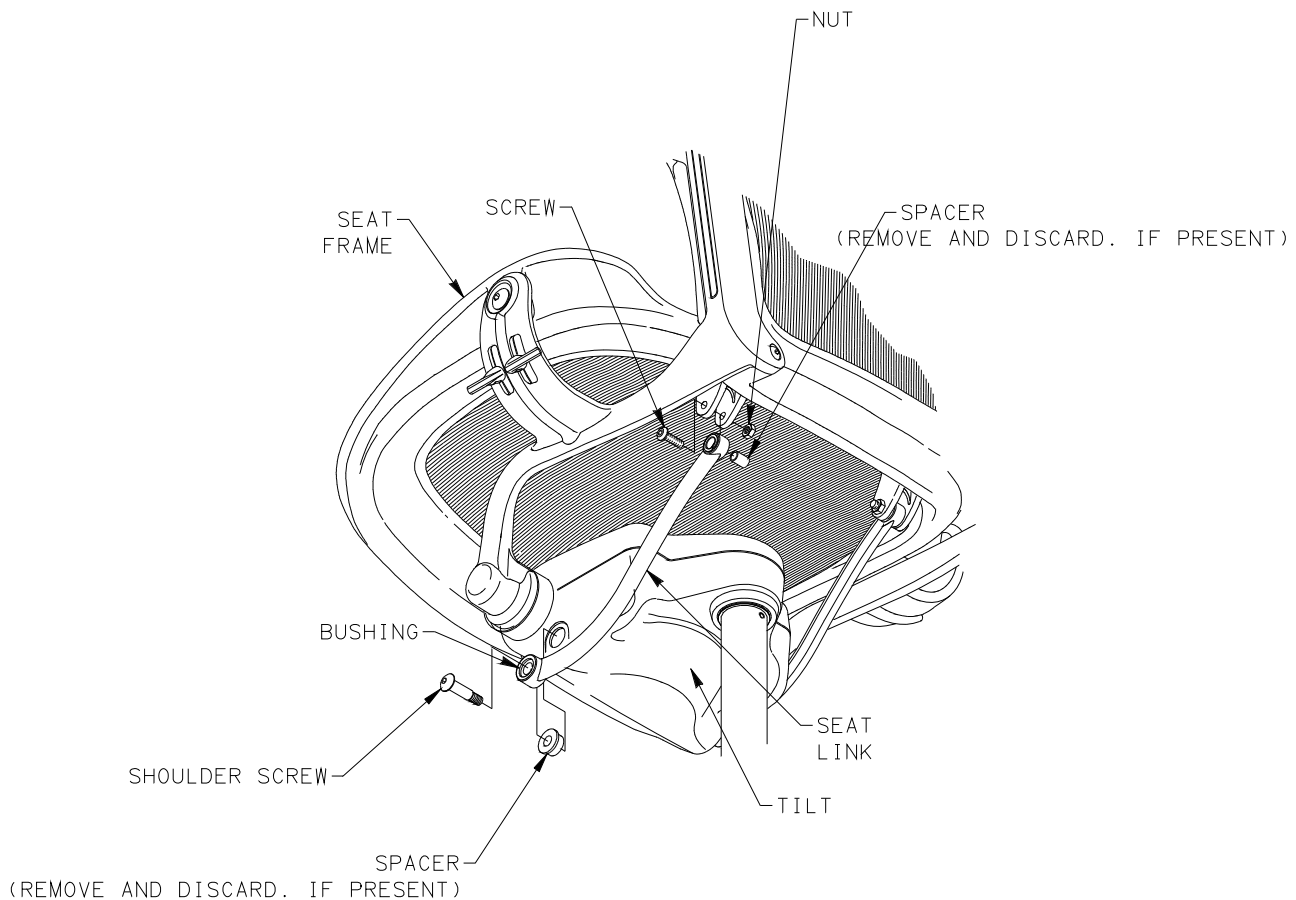


FIGURE 1  
(VIEWING FROM UNDERSIDE)

167209 REV C



# Aeron® Seat Frame Replacement

TOOLS REQUIRED: 10 MM SOCKET  
RATCHET WRENCH  
4 MM HEX KEY  
6 MM HEX BIT  
TORQUE WRENCH, 200 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### CAUTION

Support seat link while removing rear end of seat link from seat frame. Failure to do so could cause seat link to fall causing product damage.

1. WHILE SUPPORTING SEAT LINK, USE 10MM SOCKET, RATCHET WRENCH AND 4MM HEX KEY TO REMOVE NUT AND SCREW ATTACHING SEAT LINK TO SEAT FRAME. SET NUT AND SCREW ASIDE. NOTE ANY SPACER AND BUSHINGS (ON OLDER CHAIRS) AND SET ASIDE, IF DISLODGED. REPEAT FOR OPPOSITE SIDE. SEE FIGURE 1.

### CAUTION

Support seat frame while removing hip pivot screws attached to swing arms. Failure to do so could allow seat frame to fall causing product damage.

### CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame, STOP IMMEDIATELY and follow instructions.

2. TO REMOVE SEAT FRAME, FOLLOW APPROPRIATE PROCEDURE BELOW:

-USE RATCHET WRENCH AND 6MM HEX BIT TO REMOVE HIP PIVOT SCREW FROM EACH SWING ARM. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, STOP IMMEDIATELY AND DO THE FOLLOWING STEP: TIGHTEN HIP PIVOT SCREW INTO THREADED INSERT AS MUCH AS POSSIBLE. USING A QUICK JERKING MOTION WITH RATCHET WRENCH, BACK OUT HIP PIVOT SCREW FROM THREADED INSERT. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, REPEAT PROCESS. SEE FIGURE 2.

3. PLACE REPLACEMENT SEAT FRAME BETWEEN SWING ARMS. ATTACH SEAT FRAME TO SWING ARMS WITH HIP PIVOT SCREWS. TIGHTEN AND TORQUE TO 180-200 IN-LB. SEE FIGURE 2.

### NOTICE

On older chairs, bushings may become dislodged from seat links while chair is serviced. Check to ensure bushings are present and fully seated in seat links. Hold bushings in place when reinstalling seat links.

4. RECONNECT SEAT LINKS TO SEAT FRAME BY REINSTALLING SCREWS AND LOCK NUTS. ON OLDER CHAIRS, MAKE SURE SPACERS AND ALL BUSHINGS ARE PRESENT AND PROPERLY INSTALLED. IF NECESSARY, RESEAT BUSHINGS IN SEAT LINK END BY ORIENTING BUSHING WITH NOTCH IN SEAT LINK. USING 10 MM SOCKET, RATCHET WRENCH AND 4 MM HEX KEY, TIGHTEN LOCK NUT UNTIL FLUSH WITH END OF SCREW. SEE FIGURE 1.

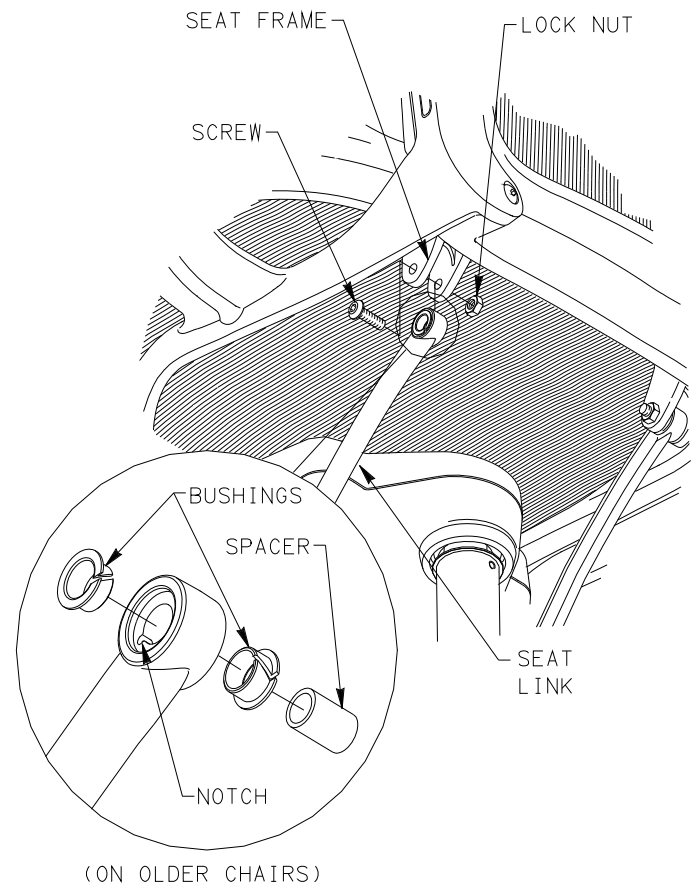


FIGURE 1  
(VIEWING FROM UNDERSIDE)

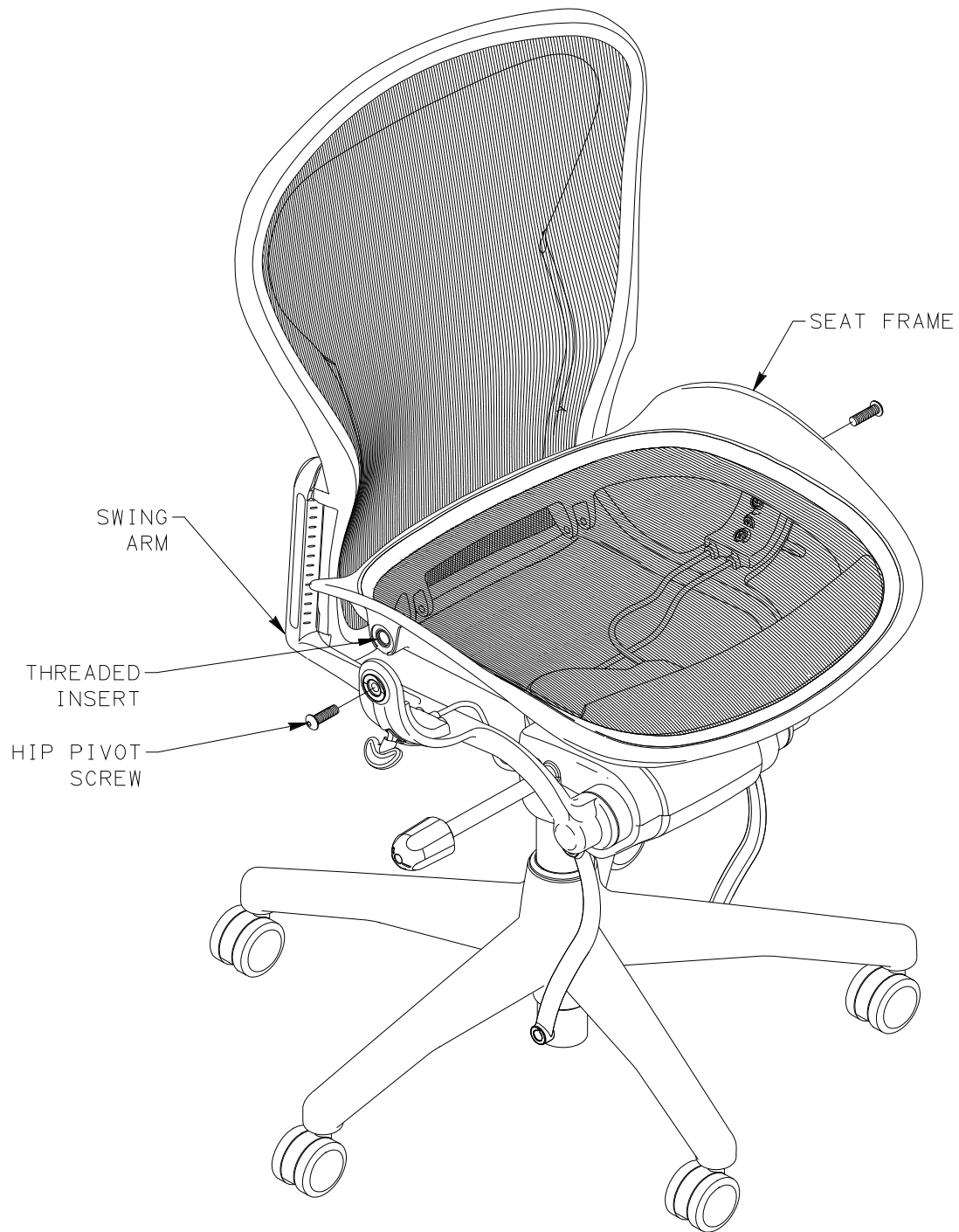


FIGURE 2

# Aeron® Seat Frame Bumper Installation

TOOLS REQUIRED: 10 MM SOCKET  
RATCHET WRENCH  
4 MM HEX KEY  
6 MM HEX BIT  
TORQUE WRENCH, 200 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### CAUTION

Support seat link while removing rear end of seat link from seat frame. Failure to do so could cause seat link to fall causing product damage.

1. WHILE SUPPORTING SEAT LINK, USE 10MM SOCKET, RATCHET WRENCH AND 4MM HEX KEY TO REMOVE NUT AND SCREW ATTACHING SEAT LINK TO SEAT FRAME AND SET ASIDE. NOTE: OLDER CHAIRS MAY HAVE SEAT LINKS WITH SPACER AND BUSHINGS. REMOVE AND SET ASIDE. SEE FIGURES 1 AND 2.

### CAUTION

Support seat frame while removing hip pivot screws attached to swing arms. Failure to do so could allow seat frame to fall causing product damage.

### CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame, STOP IMMEDIATELY and follow instructions.

2. TO REMOVE SEAT FRAME, FOLLOW APPROPRIATE PROCEDURE BELOW:

-USE RATCHET WRENCH AND 6MM HEX BIT TO REMOVE HIP PIVOT SCREW FROM EACH SWING ARM. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, STOP IMMEDIATELY AND DO FOLLOWING: TIGHTEN HIP PIVOT SCREW INTO THREADED INSERT AS MUCH AS POSSIBLE. USING QUICK JERKING MOTION WITH RATCHET WRENCH, BACK OUT HIP PIVOT SCREW FROM THREADED INSERT. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, REPEAT PROCESS. SEE FIGURE 3.

3. INSTALL SEAT BUMPER AROUND EDGE OF SEAT FRAME, BEING CERTAIN THAT BUMPER SNAPS SECURELY OVER EDGE IN ALL LOCATIONS AND THAT HOLES IN BUMPER ALIGN WITH HIP PIVOT SCREW HOLES IN SEAT FRAME. SEE FIGURE 4.
4. PLACE FRAME WITH SEAT BUMPER BETWEEN SWING ARMS. ATTACH SEAT FRAME TO SWING ARMS WITH HIP PIVOT SCREWS. TIGHTEN AND TORQUE TO 180-200 IN-LB. SEE FIGURE 5.

### NOTICE

In older chairs, bushings and spacer may have become dislodged from seat link while end was detached. Check unattached seat link ends to account for spacer, bushings and proper orientation of bushings before attaching to chair.

### NOTICE

In older chairs, hold bushings in seat link while attaching to seat frame.

5. ATTACH SEAT LINK TO SEAT FRAME WITH SCREW AND NUT. TIGHTEN NUT UNTIL FLUSH WITH END OF SCREW. REPEAT FOR OPPOSITE SIDE. NOTE: FOR OLDER CHAIRS, MAKE CERTAIN SPACER AND ALL BUSHINGS ARE ACCOUNTED FOR AND BUSHINGS ARE ORIENTED TO NOTCH IN SEAT LINK. WHILE HOLDING BUSHINGS IN SEAT LINK, ATTACH SEAT LINK TO SEAT FRAME WITH SCREW, SPACER AND NUT. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 AND 2.

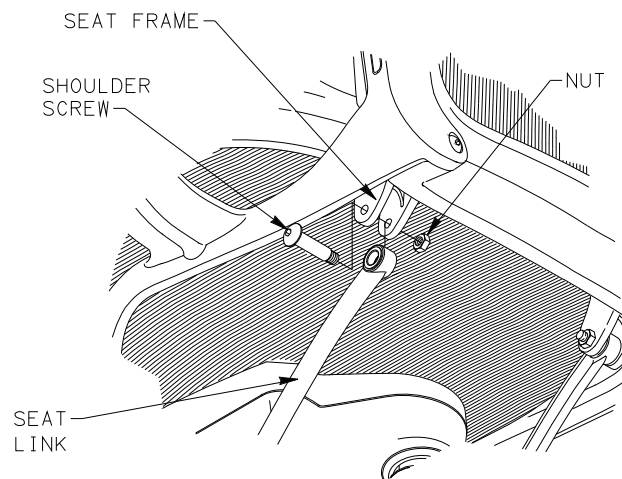


FIGURE 1  
(VIEWING FROM UNDERSIDE)

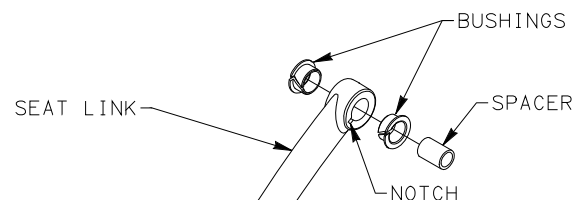


FIGURE 2  
(IN OLDER CHAIRS)

182897 REV A

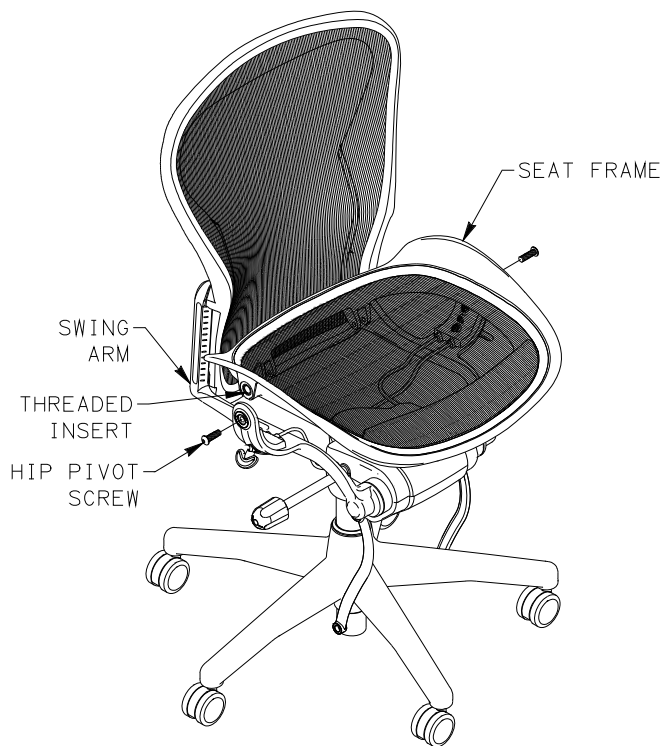


FIGURE 3

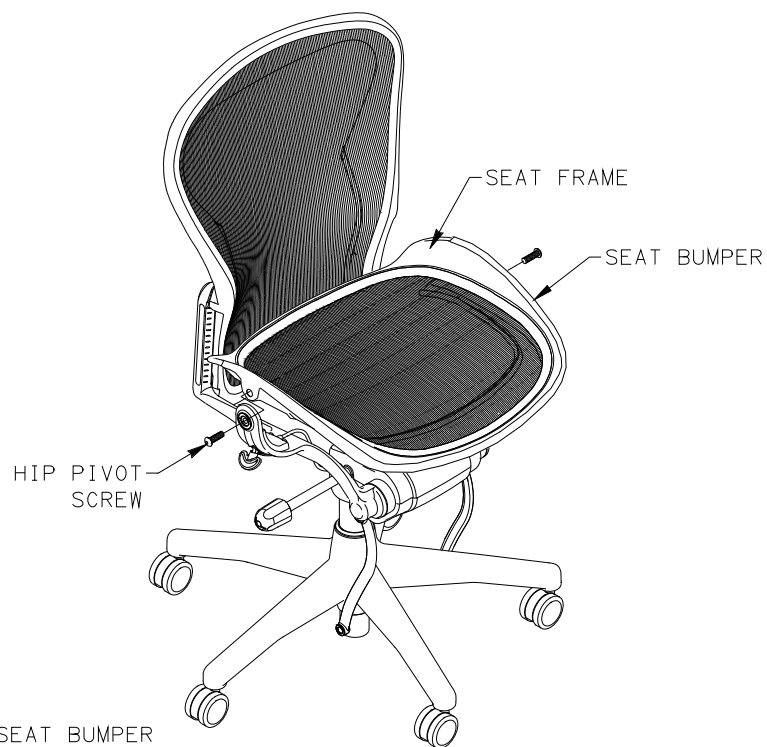


FIGURE 5

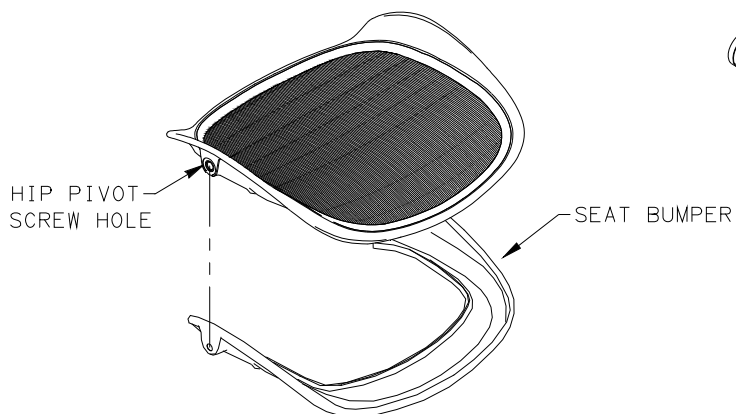


FIGURE 4

182897 REV A

# Aeron® Foam Seat Frame Cushion Replacement

## PROCEDURE :

### ⚠ CAUTION

Replace cushion by hand without tools. avoid sharp objects such as rings from contacting pellicle. Failure to comply may result in product damage.

1. BY HAND, GRASP FOAM SEAT FRAME CUSHION AT ONE END AND PULL CUSHION OUT FROM BETWEEN SEAT FRAME AND PELLICLE AND DISPOSE OF PROPERLY. REMOVE DOUBLE SIDED TAPE FROM SEAT FRAME AND DISCARD. SEE FIGURE 1.
2. DETERMINE PROPER ORIENTATION OF REPLACEMENT FOAM SEAT FRAME CUSHION BEFORE INSTALLING INTO SEAT FRAME. SEE FIGURE 2.
3. POSITION REPLACEMENT FOAM SEAT FRAME CUSHION CENTRALLY UNDER PELLICLE AND, WITH FINGER PRESSURE ONLY, INSERT CUSHION BETWEEN SEAT FRAME AND PELLICLE, WORKING SMALL AREAS FROM CENTER OF CUSHION OUTWARD TOWARDS EACH END. SEE FIGURE 3.

### ⚠ CAUTION

Do not adjust installed cushion by pulling at edges or ends. Failure to comply may result in product damage.

4. INSERT FINGERS BETWEEN CUSHION AND PELLICLE, AND WORK FRONT EDGE OF CUSHION FORWARD TO MINIMIZE "BUNCHING" OF CUSHION. SEE FIGURE 3
5. WHEN PROPERLY INSTALLED, GROOVE ON UNDERSIDE OF CUSHION SHOULD REST UNIFORMLY ON LIP OF SEAT FRAME. FRONT EDGE OF CUSHION SHOULD HAVE A UNIFORM SPACING (VIEWED THROUGH PELLICLE) OF APPROXIMATELY 1/2" FROM PELLICLE BEAD. SEE FIGURES 2 AND 3.

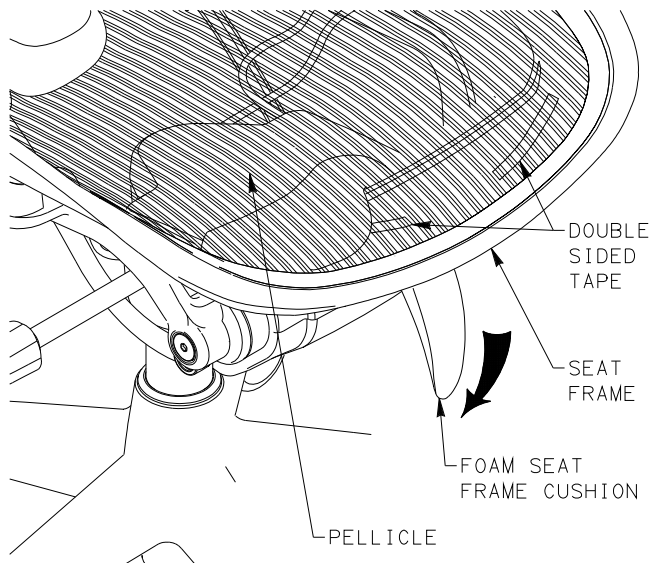


FIGURE 1

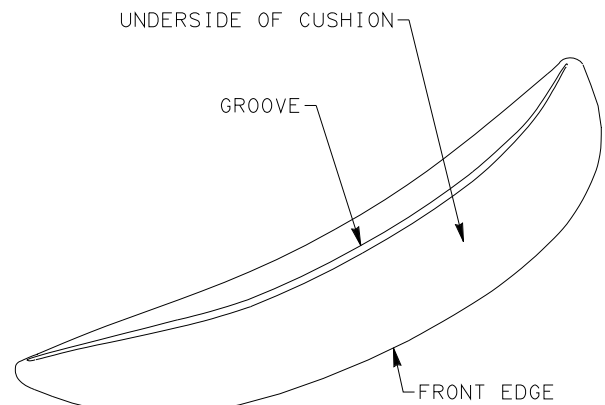


FIGURE 2

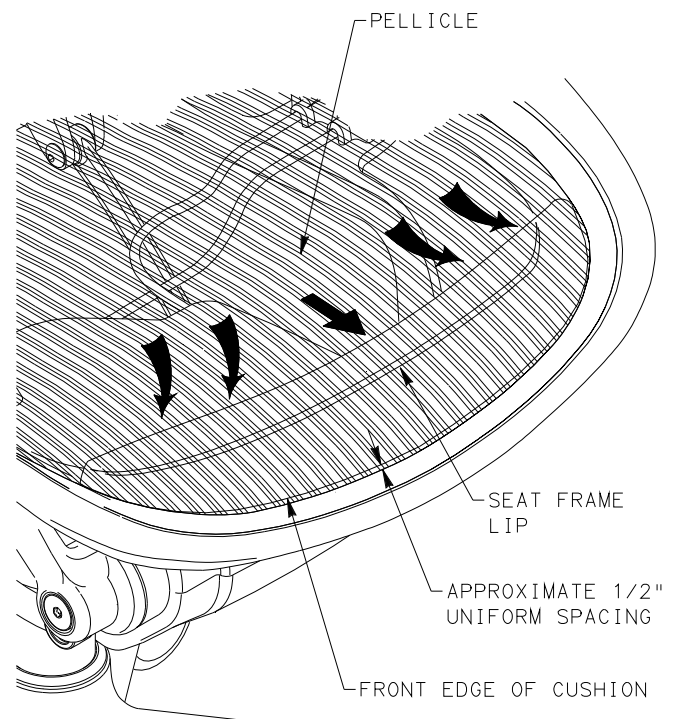


FIGURE 3

170265 REV B

# Aeron® Back Frame Replacement

TOOLS REQUIRED: RATCHET WRENCH  
5 MM HEX BIT  
TORQUE WRENCH, 100 IN-LBS CAPACITY

## PROCEDURE:

1. IF CHAIR IS EQUIPPED WITH LUMBAR, REMOVE LUMBAR FROM BACK FRAME BY SLIDING CONNECTORS OF LUMBAR OFF TRAVEL RAILS OF BACK FRAME. SET LUMBAR ASIDE. SEE FIGURE 1.

### ⚠ WARNING

Support back frame while removing screws attached to swing arms. Failure to do so could allow back frame to fall causing product damage or personal injury.

2. WHILE SUPPORTING BACK FRAME, USE RATCHET WRENCH AND 5MM HEX BIT TO REMOVE (4) SCREWS ATTACHING BACK FRAME TO SWING ARMS. SET ASIDE SCREWS. REMOVE BACK FRAME AND DISPOSE OF PROPERLY. SEE FIGURE 2.
3. PLACE REPLACEMENT BACK FRAME UP TO SWING ARMS ALIGNING HOLES. SECURE WITH SCREWS. TIGHTEN AND TORQUE SCREWS TO 70-100 IN-LB. SEE FIGURE 2.
4. IF CHAIR IS EQUIPPED WITH LUMBAR, ATTACH LUMBAR TO BACK FRAME BY ENGAGING EACH CONNECTOR ON LUMBAR TO TRAVEL RAILS OF BACK FRAME AND SLIDING DOWN. SEE FIGURE 1.

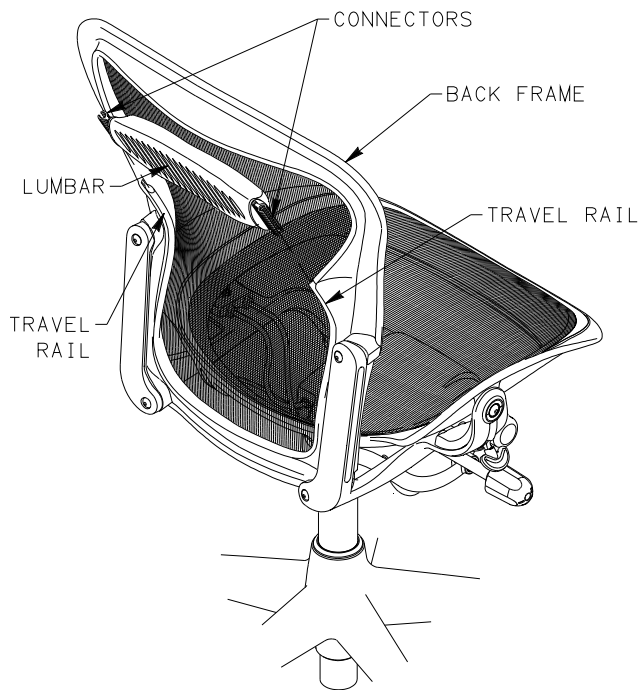


FIGURE 1

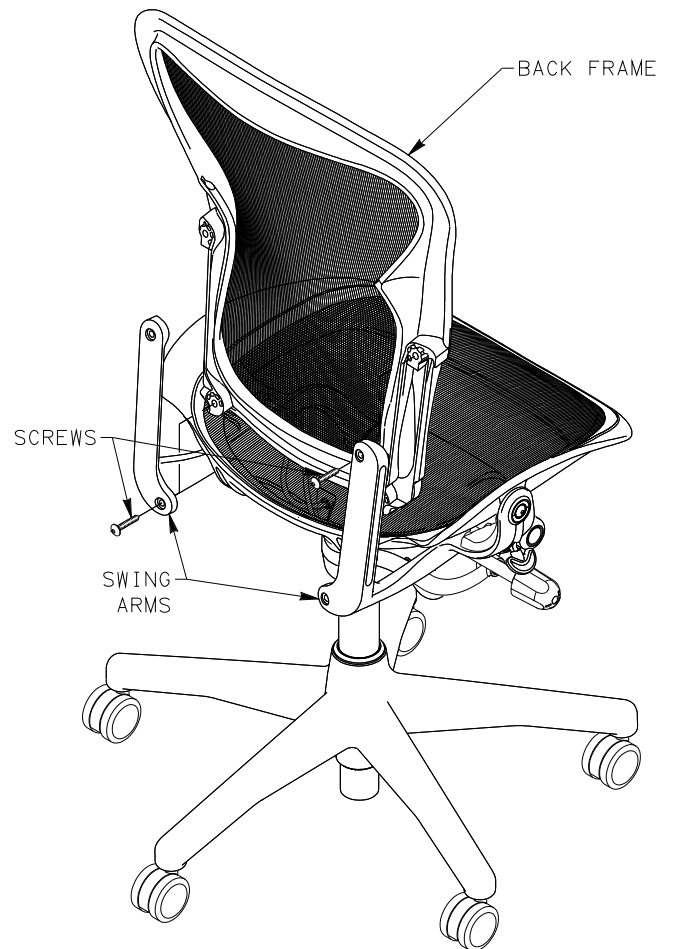


FIGURE 2

167219 REV C

# Aeron® Back Frame Bumper Installation

TOOLS REQUIRED: RATCHET WRENCH  
5 MM HEX BIT  
TORQUE WRENCH, 100 IN-LBS CAPACITY

## PROCEDURE:

1. IF CHAIR IS EQUIPPED WITH LUMBAR, REMOVE LUMBAR FROM BACK FRAME BY SLIDING CONNECTORS OF LUMBAR OFF TRAVEL RAILS OF BACK FRAME. SET LUMBAR ASIDE. SEE FIGURE 1.

### WARNING

Support back frame while removing screws attached to swing arms. Failure to do so could allow back frame to fall causing product damage or personal injury.

2. WHILE SUPPORTING BACK FRAME, USE RATCHET WRENCH AND 5MM HEX BIT TO REMOVE (4) SCREWS ATTACHING BACK FRAME TO SWING ARMS. SET ASIDE SCREWS. REMOVE BACK FRAME. SEE FIGURE 2.
3. INSTALL BACK BUMPER AROUND EDGE OF BACK FRAME, BEING CERTAIN THAT BUMPER SNAPS SECURELY OVER EDGE IN ALL LOCATIONS AND THAT HOLES IN BUMPER ALIGN WITH SCREW HOLES IN BACK FRAME. SEE FIGURE 3.

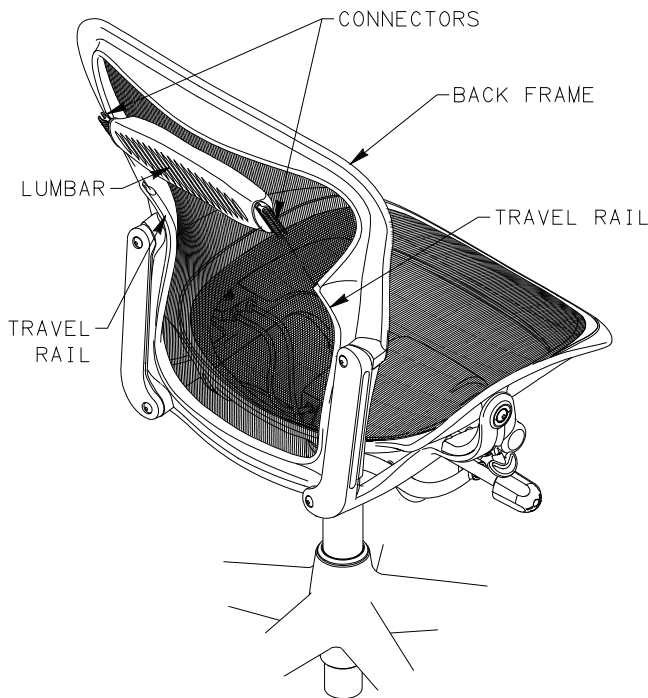


FIGURE 1

4. PLACE BACK FRAME WITH BACK BUMPER UP TO SWING ARMS ALIGNING HOLES. SECURE WITH SCREWS. TIGHTEN AND TORQUE SCREWS TO 70-100 IN-LB. SEE FIGURE 4.
5. IF CHAIR IS EQUIPPED WITH LUMBAR, ATTACH LUMBAR TO BACK FRAME BY ENGAGING EACH CONNECTOR ON LUMBAR TO TRAVEL RAILS OF BACK FRAME AND SLIDING DOWN. SEE FIGURE 1.

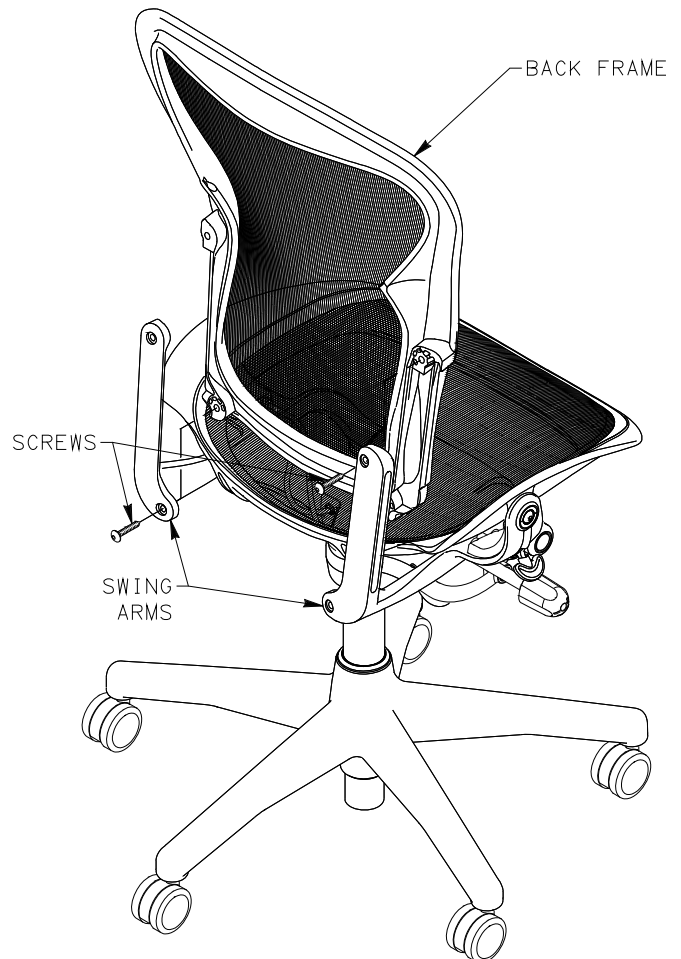


FIGURE 2

182896 REV A

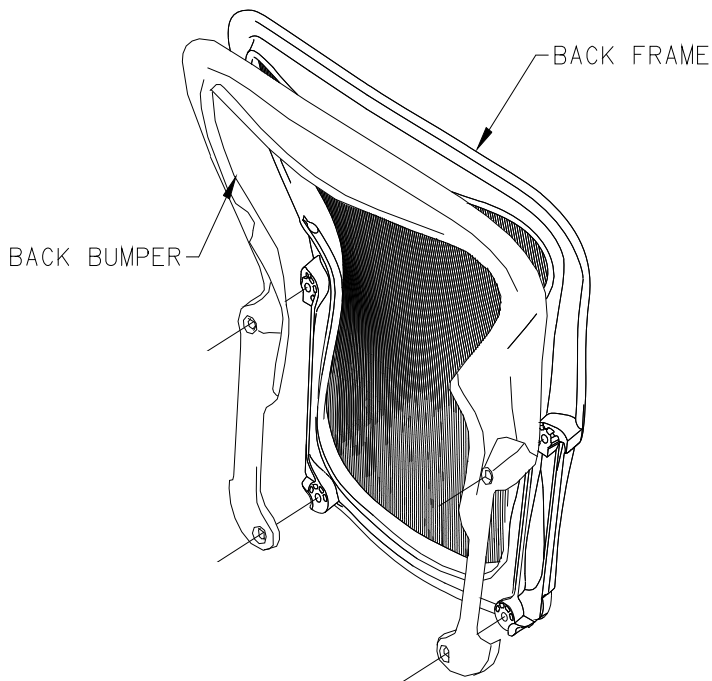


FIGURE 3

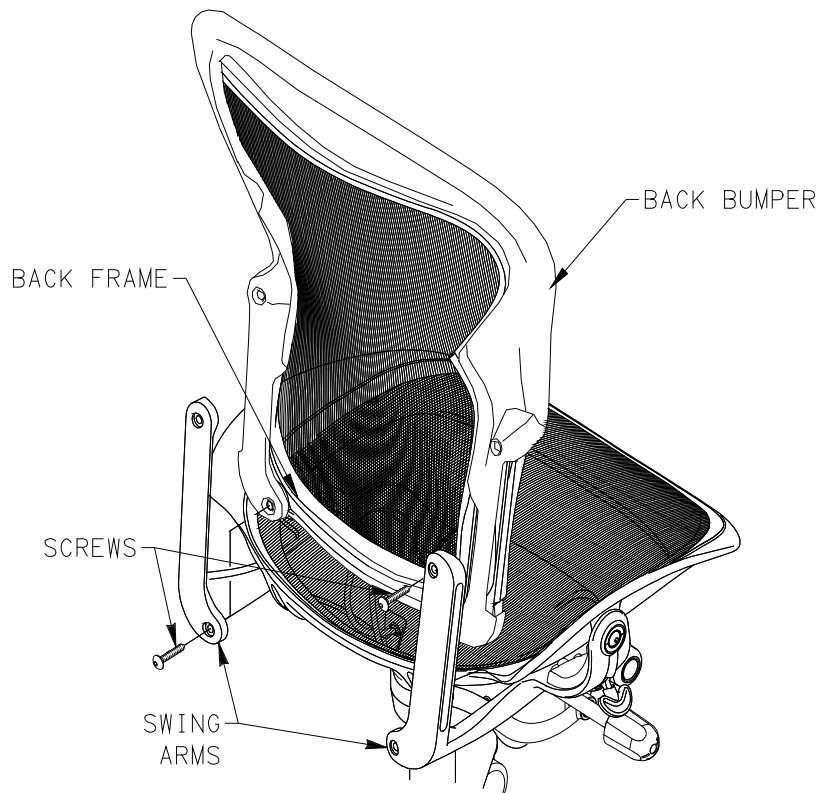


FIGURE 4

182896 REV A



# Aeron® Side Chair Back Frame Replacement

TOOLS REQUIRED: RATCHET WRENCH  
5 MM HEX BIT  
TORQUE WRENCH, 100 IN-LBS CAPACITY

## PROCEDURE:

1. IF CHAIR IS EQUIPPED WITH LUMBAR, REMOVE LUMBAR FROM BACK FRAME BY SLIDING CONNECTORS OF LUMBAR OFF TRAVEL RAILS OF BACK FRAME. SET LUMBAR ASIDE. SEE FIGURE 1.

### CAUTION

Support back frame while removing screws attached to swing arms. Failure to do so could allow back frame to fall causing product damage.

### CAUTION

Top back frame screws are longer than bottom back frame screws and must be used only in top holes. Failure to do so could cause product damage.

2. WHILE SUPPORTING BACK FRAME, USE RATCHET WRENCH AND 5MM HEX BIT TO REMOVE (4) SCREWS, 2 LONGER SCREWS AT TOP AND 2 SHORTER SCREWS AT BOTTOM, ATTACHING BACK FRAME TO BASE ASSEMBLY. SET ASIDE SCREWS. REMOVE BACK FRAME AND DISPOSE OF PROPERLY. REMOVE LEFT AND RIGHT HAND FILLERS AND SET ASIDE. SEE FIGURE 1.
3. PLACE LEFT AND RIGHT HAND FILLERS ON BASE, ALIGNING HOLES. PLACE REPLACEMENT BACK FRAME UP TO BASE ASSEMBLY ALIGNING HOLES. SECURE WITH SCREWS, MAKING CERTAIN THAT LONGER SCREWS ARE USED AT TOP AND SHORTER SCREWS ARE USED AT BOTTOM. TIGHTEN AND TORQUE SCREWS TO 70-100 IN-LBS. SEE FIGURE 1.
4. IF CHAIR IS EQUIPPED WITH LUMBAR, ATTACH LUMBAR TO BACK FRAME BY ENGAGING EACH CONNECTOR ON LUMBAR TO TRAVEL RAILS OF BACK FRAME AND SLIDING DOWN. SEE FIGURE 1.

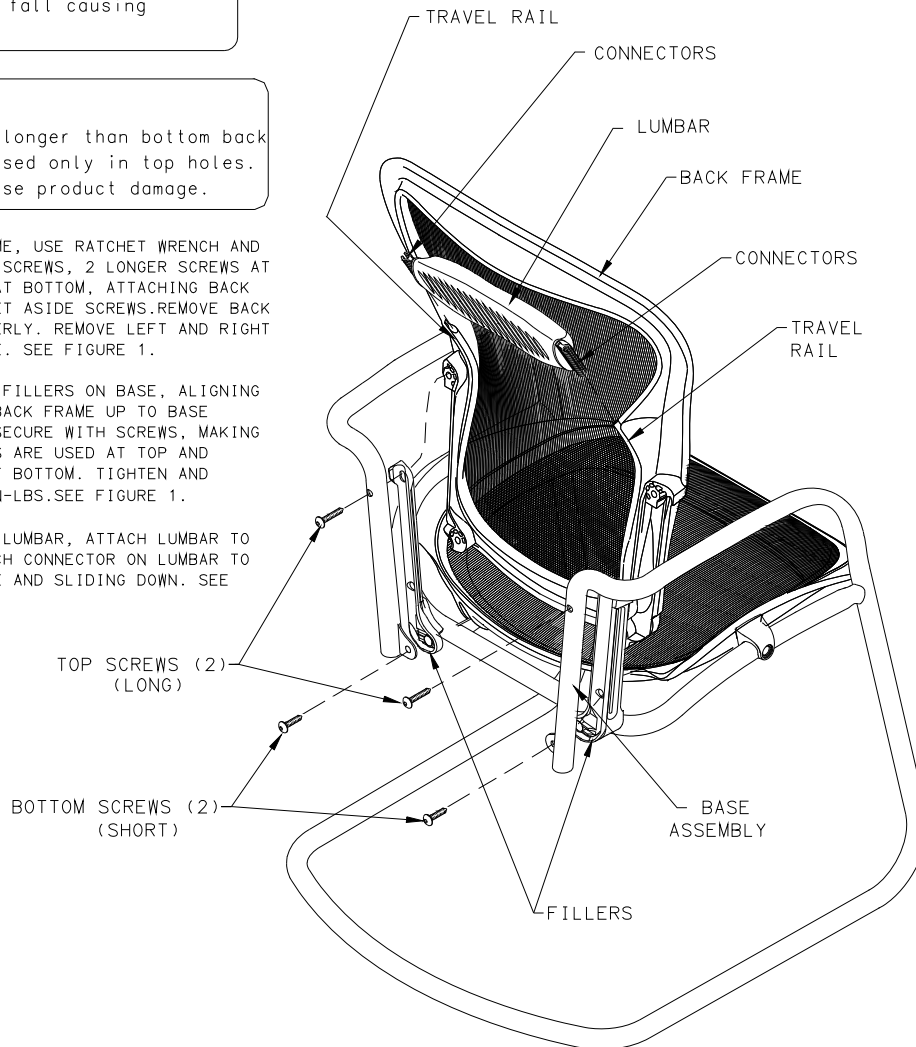
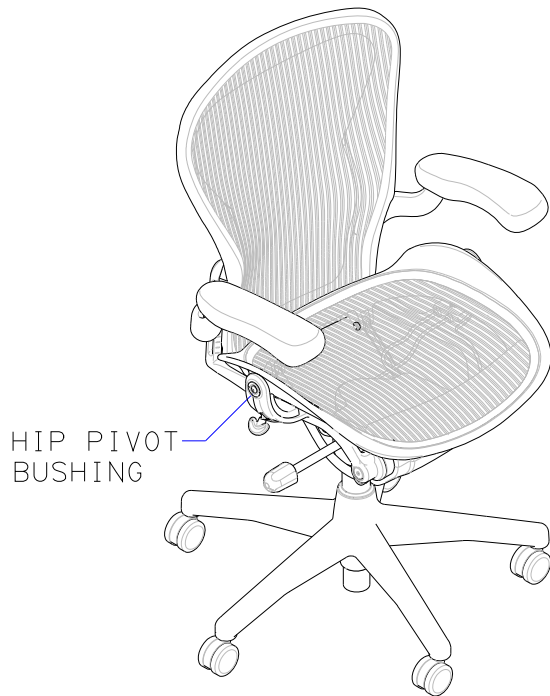


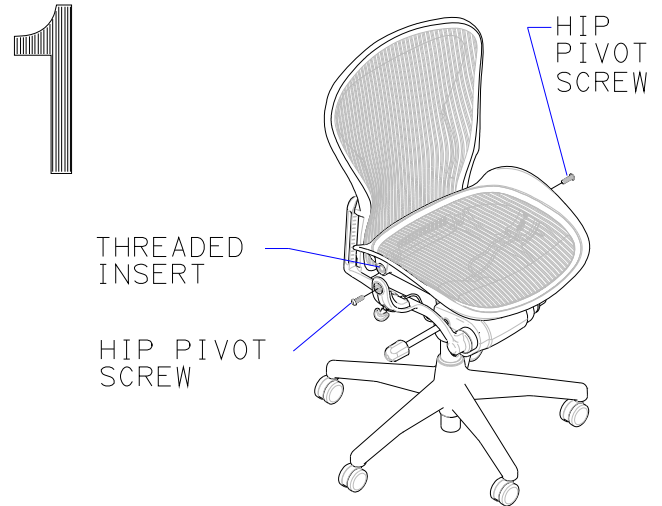
FIGURE 1

179161 REV B

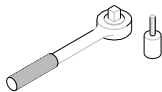
# Aeron® Hip Pivot Bushing Assembly Replacement



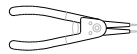
## PROCEDURE



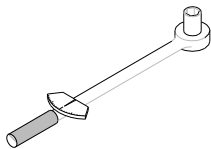
## TOOLS NEEDED



RATCHET WRENCH W/  
6 MM HEX HEAD BIT



RING RETAINER  
TOOL



TORQUE WRENCH

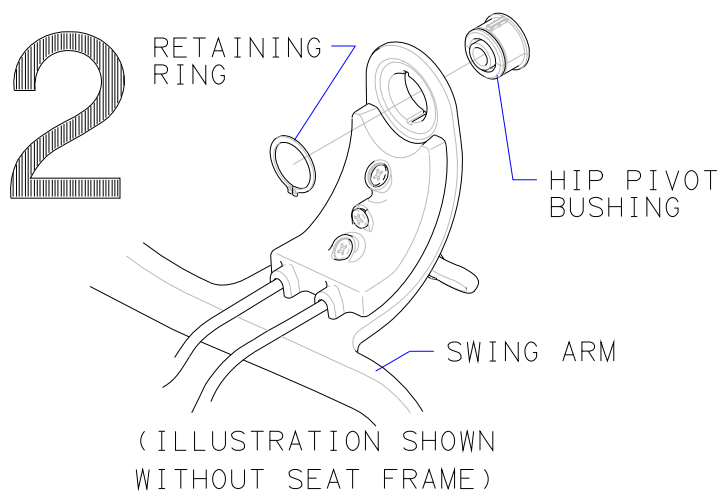
## PARTS INCLUDED



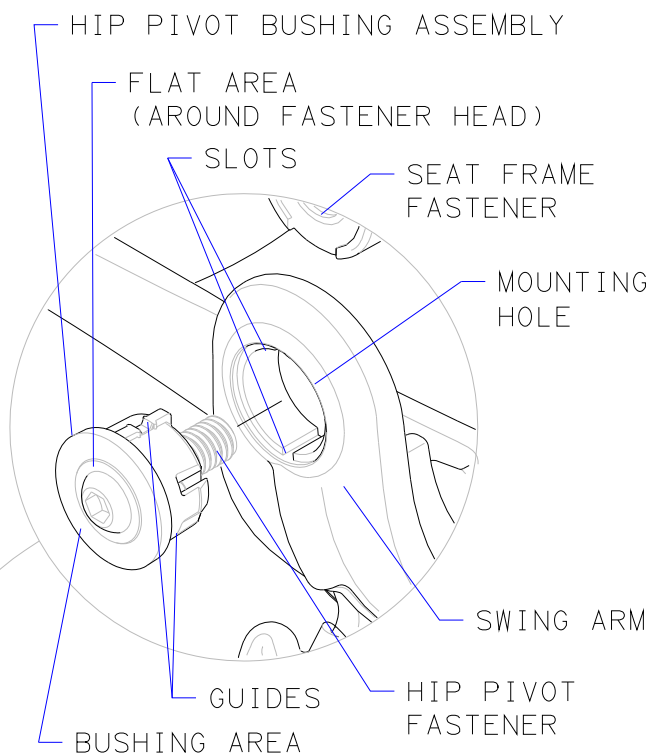
TO REMOVE SEAT FRAME (FOR CHAIRS MANUFACTURED BEFORE JUNE 4, 2003)

1. USING RATCHET WRENCH AND 6 MM HEX BIT, REMOVE HIP PIVOT SCREW FROM EACH SWING ARM. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, STOP IMMEDIATELY AND PROCEED WITH FOLLOWING STEP: TIGHTEN HIP PIVOT SCREW INTO THREADED INSERT AS MUCH AS POSSIBLE. USING A QUICK JERKING MOTION WITH RATCHET WRENCH, BACK OUT HIP PIVOT SCREW FROM THREADED INSERT. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, REPEAT PROCESS.

167208 REV D

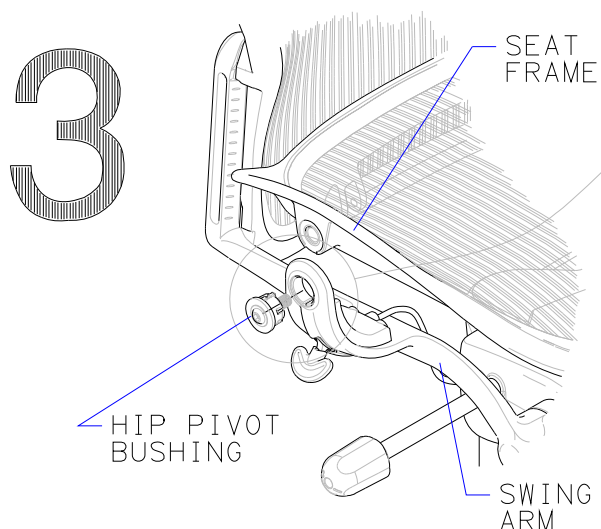


1. PIVOT SEAT UPWARD ALLOWING ACCESS TO RETAINING RING.
2. USING RETAINING RING TOOL, REMOVE RETAINING RING FROM HIP PIVOT BUSHING ON INSIDE OF SWING ARM. PROPERLY DISPOSE OF RETAINING RING. FORCE OUT HIP PIVOT BUSHING ASSEMBLY FROM INSIDE OF SWING ARM. PROPERLY DISPOSE OF HIP PIVOT BUSHING. REPEAT FOR OPPOSITE SIDE.



#### TO REINSTALL: (FOR ALL CHAIRS)

1. MAKE CERTAIN FLAT AREA AROUND FASTENERS HEAD IN HIP PIVOT BUSHING IS FLAT AND ALIGNED WITH BUSHING AREA .
2. LOWER SEAT IN PLACE. ALIGN FASTENER IN SEAT FRAME TO MOUNTING HOLE IN SWING ARM.
3. INSERT HIP PIVOT FASTENER INTO SWING ARM ALIGNING TOP AND BOTTOM GUIDES INTO SLOTS IN SWING ARM OPENING.
4. USING 6 MM HEAD BIT AND RATCHET WRENCH, PARTIALLY THREAD HIP PIVOT FASTENER INTO SEAT FRAME, REPEAT FOR OPPOSITE SIDE.
5. SECURE FASTENERS OF HIP PIVOT BUSHING, DRAWING HIP PIVOT BUSHING INTO SEAT FRAME. TORQUE FASTENERS TO 180-200 IN LBS.



#### TO REMOVE SEAT FRAME (FOR CHAIRS MANUFACTURED AFTER JUNE 4, 2003)

1. USING RATCHET WRENCH AND 6MM HEX BIT, REMOVE HIP PIVOT BUSHING ASSEMBLY FROM SWING ARM. LOOSENING PIVOT FASTENER WILL FORCE HIP PIVOT BUSHING ASSEMBLY FROM SWING ARM. AFTER HIP PIVOT FASTENER HAS DISENGAGED FROM SEAT FRAME, REMOVE HIP PIVOT BUSHING AND DISPOSE OF PROPERLY. REPEAT FOR OTHER SIDE.

167208 REV D

# Aeron® Tilt Cover Replacement

TOOLS REQUIRED: 1" PUTTY KNIFE  
STRAIGHT HEAD SCREWDRIVER  
6MM HEX BIT  
RATCHET WRENCH  
#2 PHILLIPS HEAD SCREWDRIVER  
TORQUE WRENCH, 150 IN-LB CAPACITY

PROCEDURE:

## NOTICE

Make sure fasteners are torqued to specified values.

1. APPLY THUMB PRESSURE ON FRONT OF BOTTOM TILT COVER TO START SEPARATION OF TILT COVERS. INSERT 1" PUTTY KNIFE BETWEEN TOP AND BOTTOM COVERS AND TWIST TO COMPLETELY SEPARATE HALVES. REMOVE TOP COVER AND DISPOSE OF PROPERLY. SEE FIGURE 1 AND 2.
2. INVERT CHAIR AND PLACE ON CLEAN WORK SURFACE.
3. USING STRAIGHT HEAD SCREWDRIVER REMOVE RETAINER CLIP AND WASHER FROM SHAFT OF PNEUMATIC CARTRIDGE PROTRUDING FROM BASE AND SET ASIDE. SEE FIGURE 3.
4. FOR BASE REMOVAL, FOLLOW APPROPRIATE PROCEDURE BELOW:  
  
-STANDARD CYLINDER: REMOVE BASE FROM PNEUMATIC CYLINDER AND SET ASIDE. SEE FIGURE 3.  
  
-HIGH PERFORMANCE CYLINDER (TELESCOPING MIDSECTION):  
SLIDE BASE OFF AS FAR AS IT WILL GO. TURN BASE SLOWLY COUNTERCLOCKWISE MAINTAINING SLIGHT UPWARD TENSION WHILE HOLDING TELESCOPING MIDSECTION IN PLACE. WHEN A DEPRESSION IS FELT, CONTINUE TURNING WITH SLIGHT UPWARD PRESSURE. IF BASE WILL NOT TURN AFTER DEPRESSION IS FELT, TURN BASE IN OTHER DIRECTION. SEPARATE BASE FROM TELESCOPING MIDSECTION AND SET ASIDE. SEE FIGURE 3.

## CAUTION

Do not overtighten retainer nut. Product damage may result.

INSPECT RETAINER NUT FOR FRACTURES. IF REPLACEMENT IS NEEDED, REMOVE BEARING ASSEMBLY AND BUMPER FROM PNEUMATIC CARTRIDGE SHAFT. USING RETAINER NUT REMOVAL TOOL, REMOVE RETAINER NUT FROM CARRIER TUBE AND DISPOSE OF PROPERLY. DISASSEMBLE PNEUMATIC CARTRIDGE AND TELESCOPING MIDSECTION FROM CARRIER TUBE. REMOVE ANY PIECES OF BROKEN RETAINER NUT THAT MAY HAVE REMAINED INSIDE CARRIER TUBE. INSTALL TELESCOPING MIDSECTION, PNEUMATIC CARTRIDGE AND REPLACEMENT RETAINER NUT TO CARRIER TUBE. DO NOT OVER TIGHTEN RETAINER NUT. RETURN BEARING ASSEMBLY AND BUMPER TO PNEUMATIC CARTRIDGE SHAFT. SEE FIGURE 4.

5. USING 6MM HEX BIT AND RATCHET WRENCH, REMOVE FRONT SHOULDER SCREW AND SET SHOULDER SCREW ASIDE. NOTE ANY SPACER AND BUSHINGS (USED ON OLDER CHAIRS). REMOVE SPACER, IF PRESENT, FROM BOTTOM TILT COVER AND SET ASIDE. PIVOT SEAT LINK BACK. SET ASIDE ANY DISLODGED BUSHINGS. REPEAT FOR OPPOSITE SIDE. SEE FIGURE 5.

6. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND DISCARD (2) SCREWS SECURING LOWER TILT COVER. SLIDE TILT COVER PAST PNEUMATIC CYLINDER AND DISPOSE OF PROPERLY. SEE FIGURE 6.
7. SLIDE REPLACEMENT LOWER TILT COVER OVER PNEUMATIC CYLINDER AND ONTO TILT. MAKE SURE NOTCHES IN TILT SPACER ENGAGE SLOTS IN TILT COVER. IF NECESSARY, ROTATE TILT SPACERS TO ALIGN NOTCHES WITH SLOTS. ALIGN (2) HOLES IN TILT COVER WITH HOLES IN TILT. INSTALL (2) SCREWS AND TIGHTEN. SEE FIGURE 6.

## NOTICE

On older chairs, bushings may become dislodged from seat links while chair is serviced. Check to ensure bushings are present and fully seated in seat links. Hold bushings in place when reinstalling front of seat links.

8. RECONNECT SEAT LINKS TO TILT BY HAND THREADING SHOULDER SCREWS THROUGH SEAT LINK ENDS UNTIL THREADED SNUG IN TILT HOUSING. ON OLDER CHAIRS, MAKE SURE SPACERS AND ALL BUSHINGS ARE PRESENT AND PROPERLY INSTALLED. IF NECESSARY, RESEAT BUSHINGS IN SEAT LINK END BY ORIENTING BUSHING WITH NOTCH IN SEAT LINK. USING 6 MM HEX BIT AND TORQUE WRENCH, TORQUE SHOULDER SCREWS TO 120-150 IN-LBS. SEE FIGURE 5.
9. FOR BASE INSTALLATION, FOLLOW APPROPRIATE PROCEDURE BELOW.  
  
-STANDARD CYLINDER: INSTALL BASE OVER PNEUMATIC CYLINDER. SEE FIGURE 3.  
  
-HIGH PERFORMANCE CYLINDER (TELESCOPING MIDSECTION):  
DEPRESS RETAINER ON TELESCOPING MIDSECTION WHILE INSTALLING BASE OVER PNEUMATIC CYLINDER. SEE FIGURE 3.
10. INSTALL WASHER AND RETAINER CLIP TO SHAFT OF PNEUMATIC CARTRIDGE. SEE FIGURE 3.
11. STAND CHAIR IN UPRIGHT POSITION.

## CAUTION

Make sure all cables are routed through cable openings on tilt cover before snapping tilt cover in place or product damage may occur.

12. PLACE TOP TILT COVER ON TILT AND ALIGN WITH BOTTOM TILT COVER. ROUTE ALL CABLES THROUGH CABLE OPENINGS AND SNAP COVERS TOGETHER. SEE FIGURE 2.

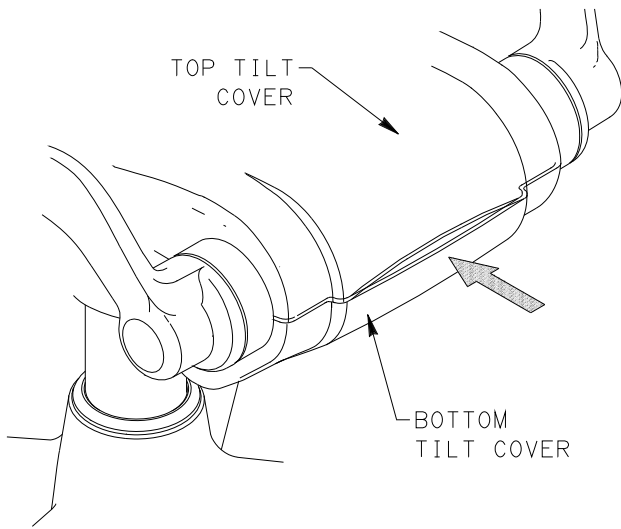


FIGURE 1

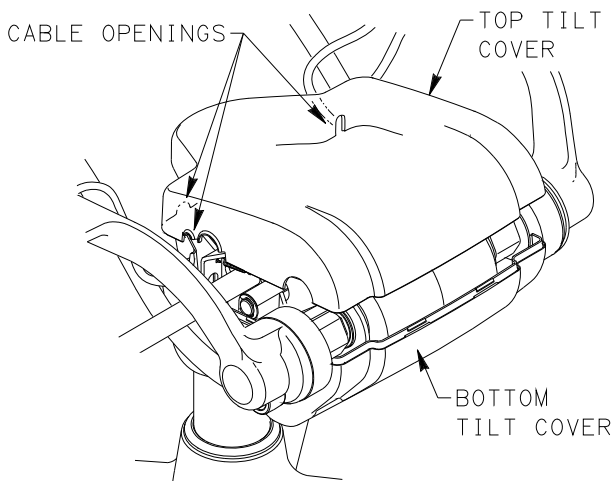


FIGURE 2

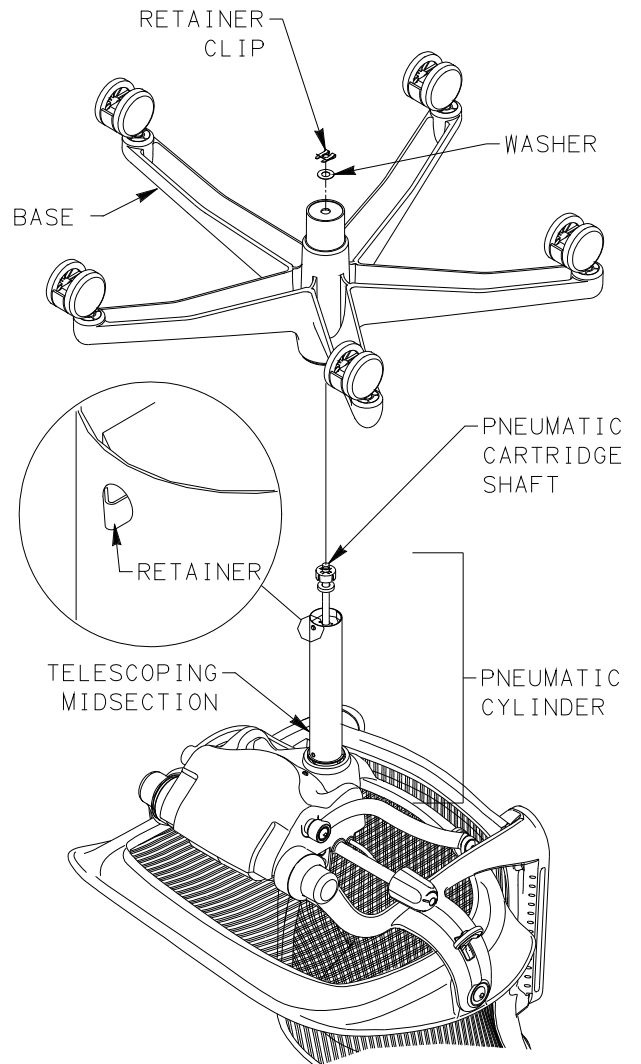


FIGURE 3

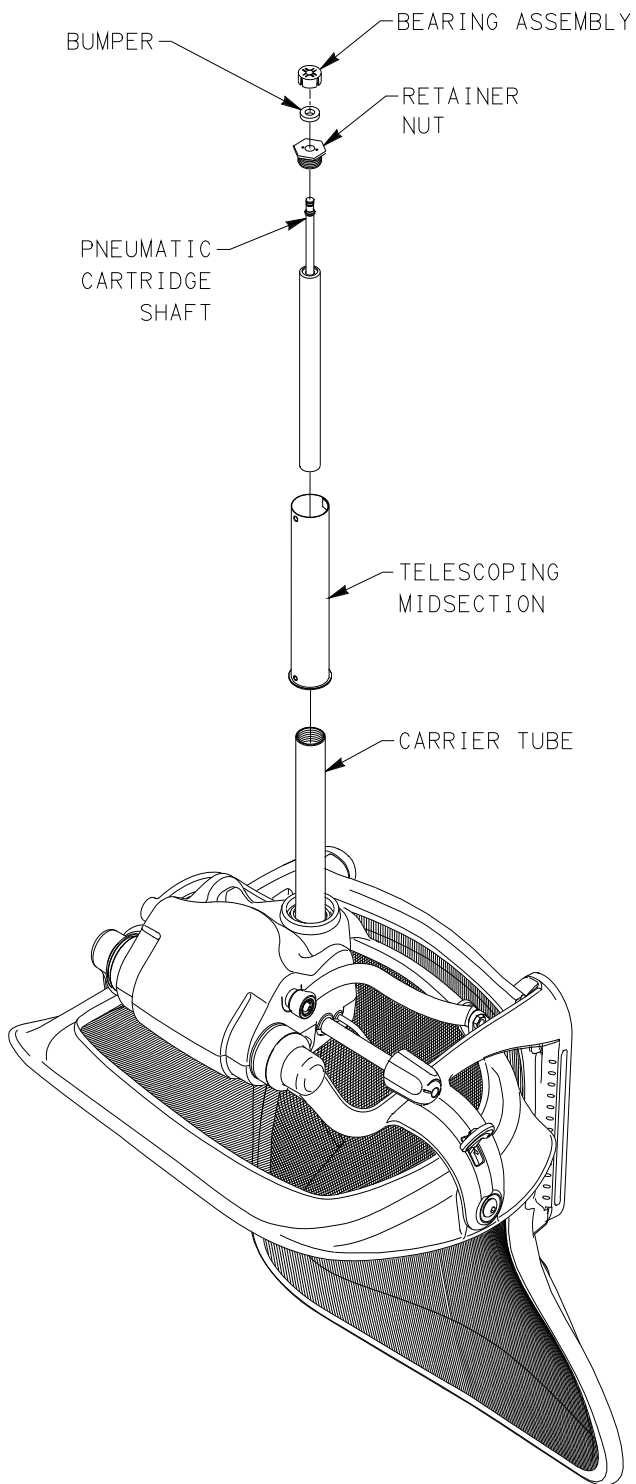


FIGURE 4

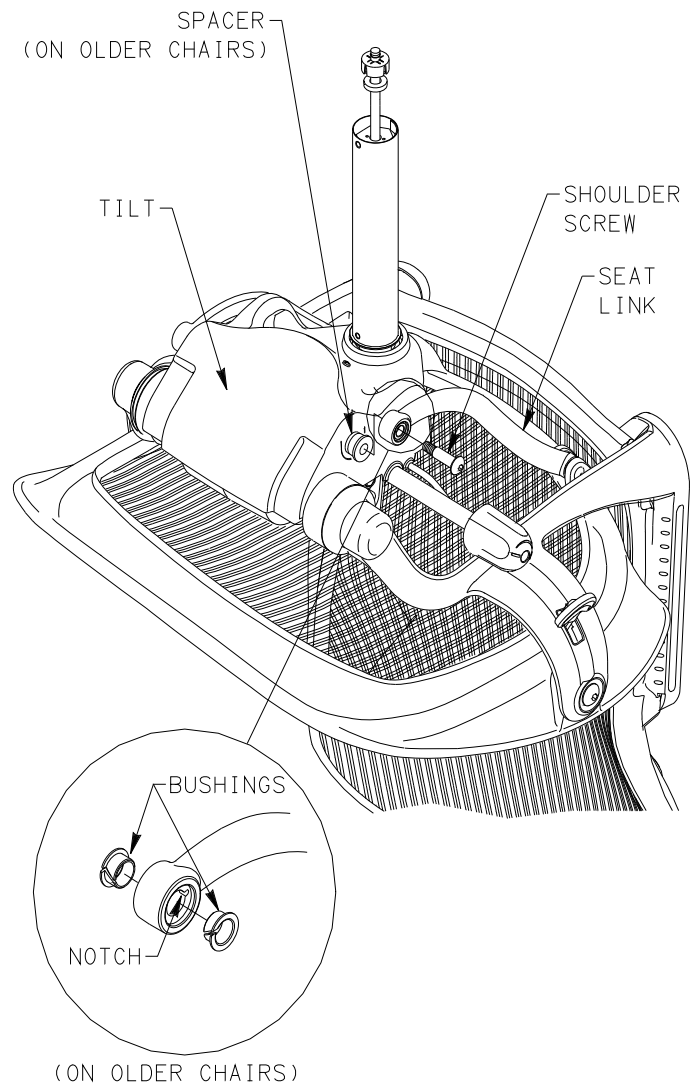


FIGURE 5

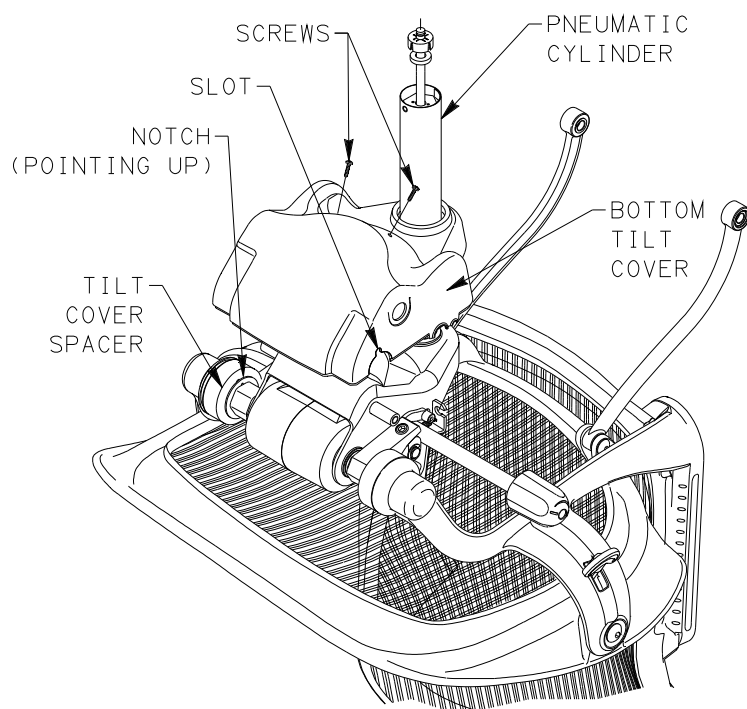
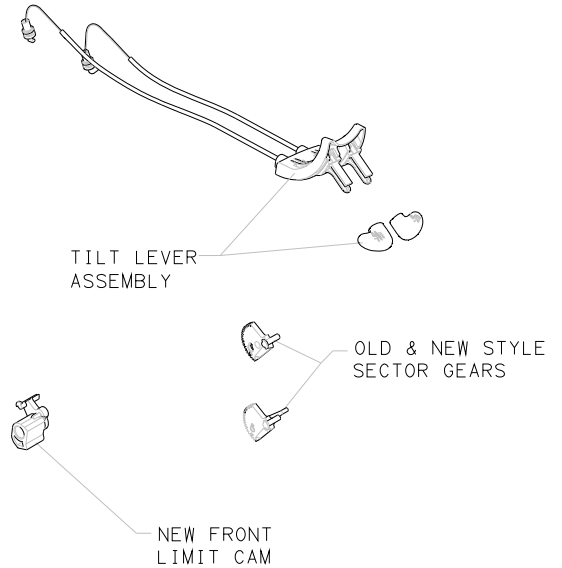


FIGURE 6

# Aeron® Tilt Control Replacement

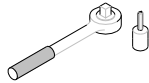
## PARTS INCLUDED



## TOOLS NEEDED



1" PUTTY KNIFE



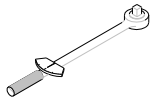
RATCHET WRENCH W/  
6MM HEX HEAD BIT



PHILLIPS HEAD  
SCREWDRIVER



PLIERS



TORQUE WRENCH



NEEDLENOSE  
PLIERS

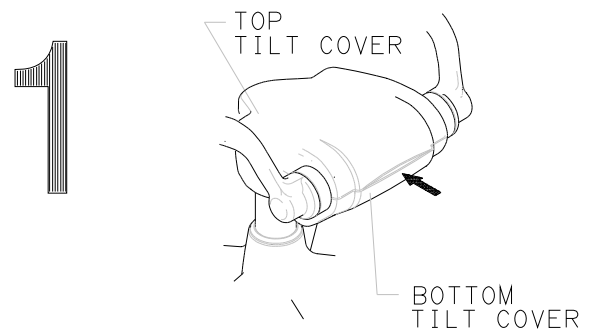
## PROCEDURE

### NOTICE

FOR CHAIRS WITH NO TILT OPTION, GO ON TO STEP 7.

### NOTICE

TILT LIMITER MUST BE IN RELEASED POSITION TO SERVICE. (TILT LIMITER LEVER ALL THE WAY DOWN).



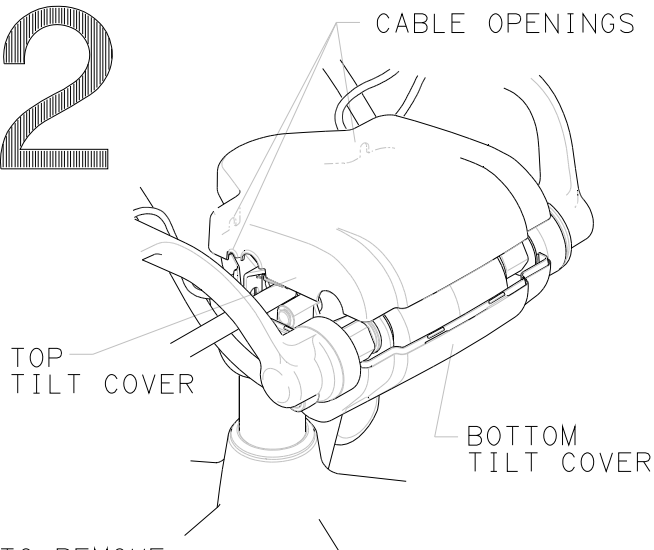
### TO REMOVE :

1. Using thumb pressure, press front of bottom tilt cover to start separation of tilt covers.

167206 REV



# 2



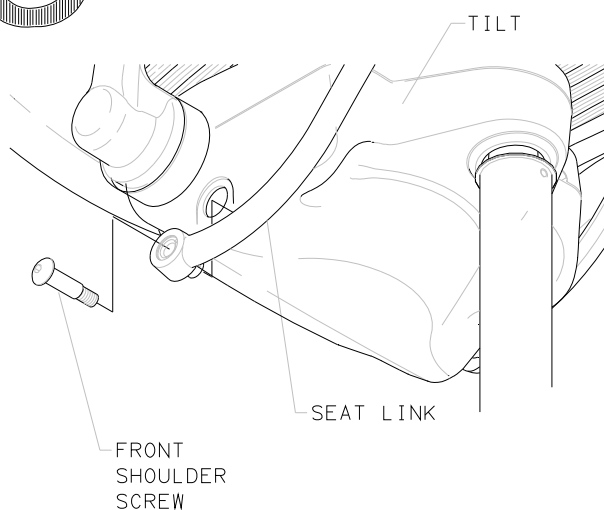
TO REMOVE :

1. Insert 1" putty knife between covers and twist to separate top from bottom cover. Remove top cover and set aside.

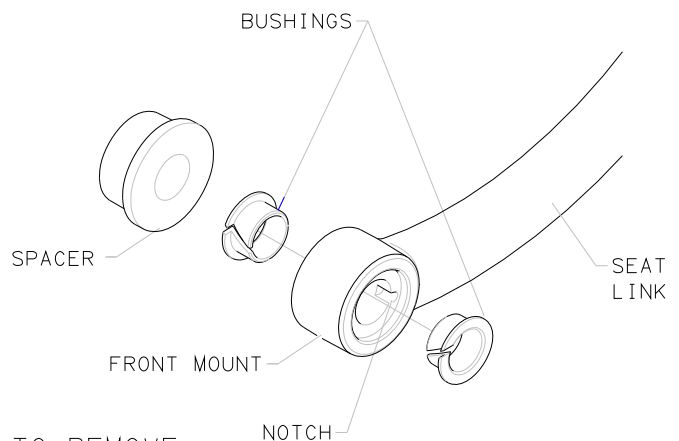
TO REINSTALL :

1. Reposition top tilt cover over bottom tilt cover, making sure all cables are properly routed through cable openings. Snap cover halves together.

# 3



(OLDER VERSION)



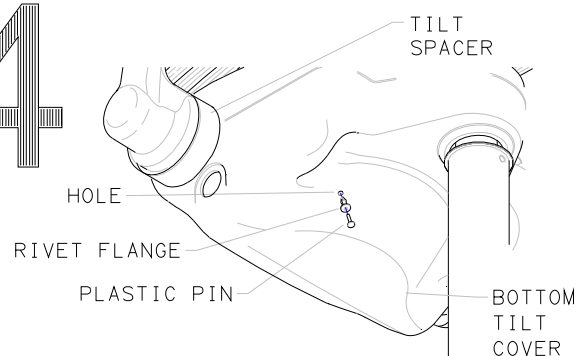
TO REMOVE :

1. While supporting seat link, use 6MM socket, ratchet wrench to remove shoulder screw attaching seat link to tilt. Set aside shoulder screw. Let seat link hang. Remove spacers and or bushings if applicable and set aside. Repeat for opposite side.

TO REINSTALL :

1. Attach front mount of seat link to tilt with shoulder screw. Tighten and torque to 120-150 in-lbs.

# 4



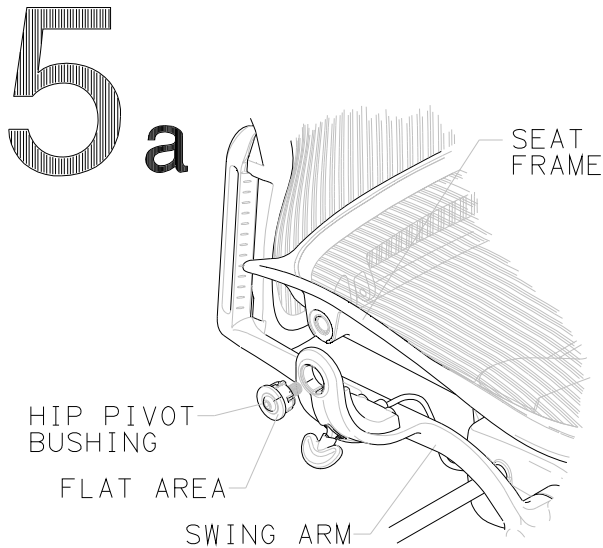
TO REMOVE :

1. Using needle nose pliers, remove plastic pin from rivot flange. Pull tilt cover from tilt.

TO REINSTALL :

1. Slide bottom tilt cover up to tilt. Make sure notches in tilt spacer grooves engage slots in tilt cover. If necessary, rotate tilt spacers to align notches with slots. Align hole in tilt cover to hole in tilt. Install rivet flange into tiltcover and tilt. Insert rivet pin into rivet flange.

(FOR CHAIRS MANUFACTURED AFTER JUNE 4, 2003)



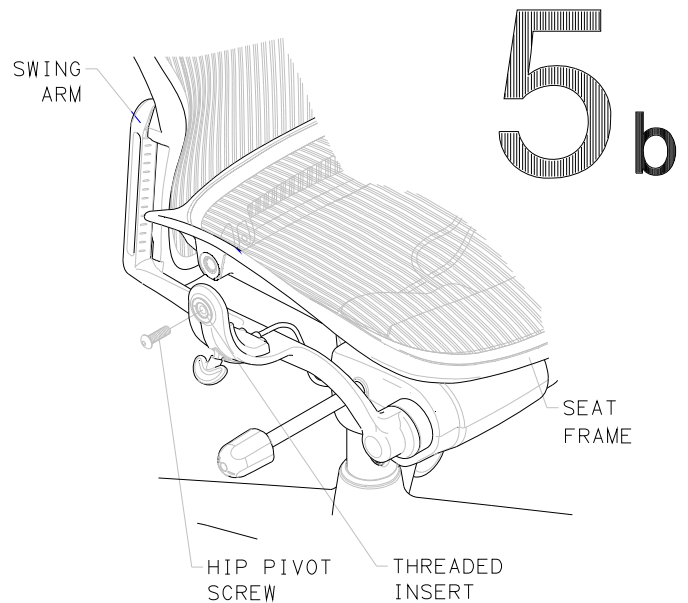
TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot bushing assembly from swing arm. Loosening pivot fastener will force hip pivot bushing assembly from swing arm. After hip pivot fastener has disengaged from seat frame, remove hip pivot bushing and set aside. Repeat for other side. Remove seat frame with b-links and set aside.

TO REINSTALL :

1. Make certain flat area around fasteners head in hip pivot bushing is flat and aligned with bushing area. Repeat for other hip pivot bushing.
2. Lower seat in place. Align fastener in seat frame to mounting hole in swing arm and insert hip pivot bushing.
3. Insert other hip pivot fastener into swing arm aligning top and bottom guides into slots in swing arm opening.
4. Using 6MM head bit and ratchet wrench, partially thread hip pivot fastener into seat frame. Repeat for opposite side.
5. Secure fasteners of hip pivot bushing, drawing hip pivot bushing into seat frame. Torque fasteners to 180-200 lbs.

(FOR CHAIRS MANUFACTURED BEFORE JUNE 4, 2003)



TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot screw from each swing arm. If threaded insert turns with hip pivot screw, **STOP** immediately and do the following step: Tighten hip pivot screw into threaded insert as much as possible. Using a quick jerking motion with ratchet wrench. Back out hip pivot screw from threaded insert. If threaded insert turns with hip pivot screw, repeat process.

#### ⚠ CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame, **STOP IMMEDIATELY** and follow instructions.

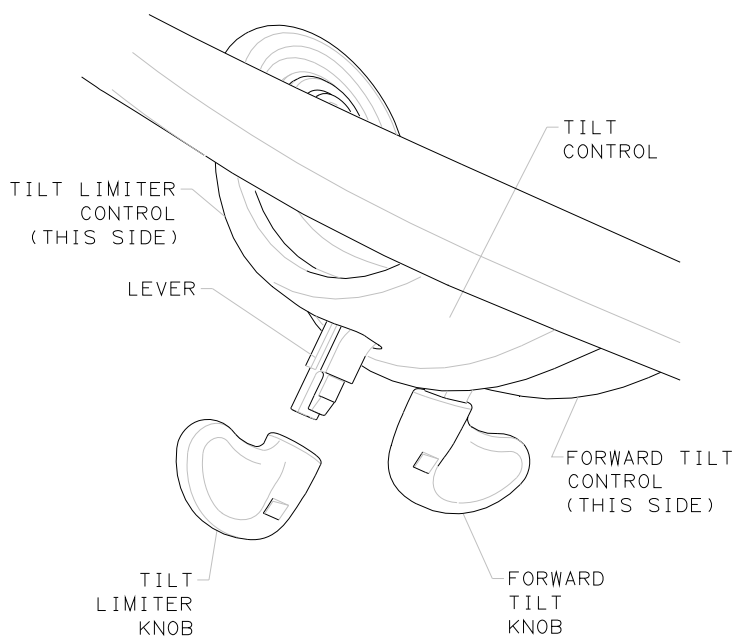
TO REINSTALL :

1. Place seat frame between swing arms. Attach seat frame to swing arms with hip pivot screws. Tighten and torque to 180-200 in lbs.

167206 REV H

# 6 a

FOR CHAIRS MANUFACTURED  
BEFORE 8-23-2004



## TO REMOVE :

1. Using pliers, twist knob(s) to separate knob from lever. Properly dispose of knob/s.

# 6 b

FOR CHAIRS MANUFACTURED  
AFTER 8-23-2004

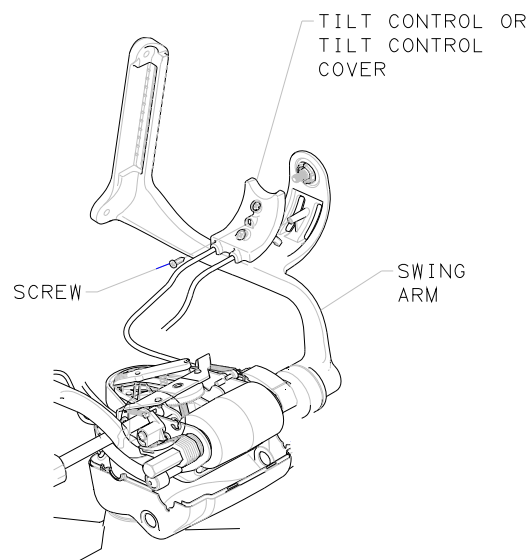
## TO REMOVE :

1. Using hands, pull knob/s from control lever/s. Properly dispose of knobs.

## TO REINSTALL :

1. Push on appropriate knob/s until they click into place.

# 7



## TO REMOVE :

1. Using #2 phillips head screwdriver, remove and set aside fastener securing tilt control to swing arm.

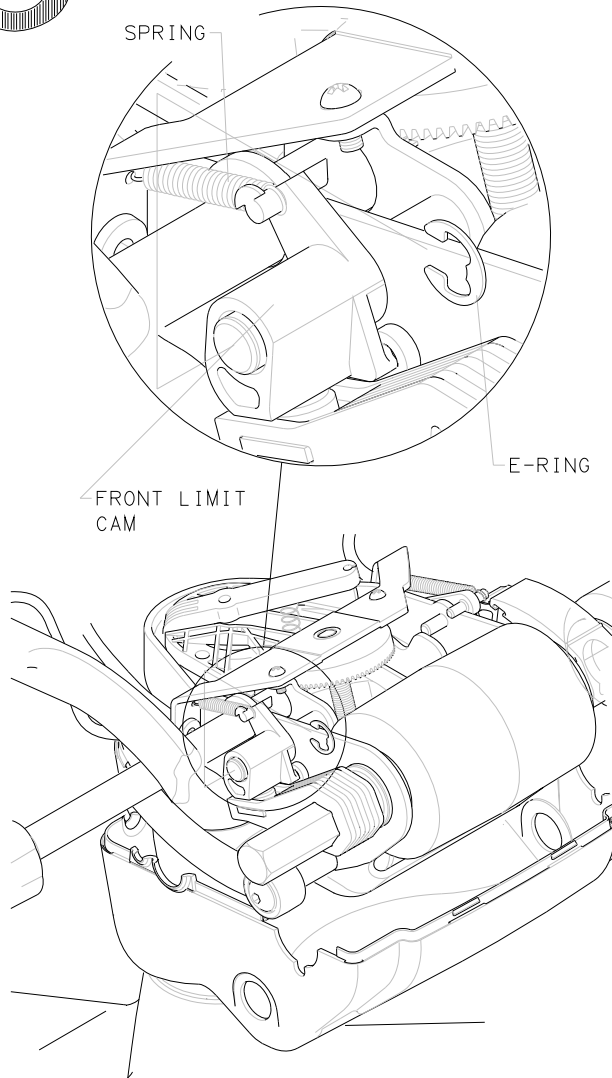
**Note:** When removing tilt cover only (no tilt option), seat frame does not need to be removed.

## TO REINSTALL :

1. Place appropriate tilt control on swing arm and secure with screw using #2 phillips head screwdriver.

# 8

## If Equipped



(FIGURE SHOWN WITH SEAT FRAME  
REMOVED FROM PRE 3-9-04 CHAIR)

### TO REMOVE :

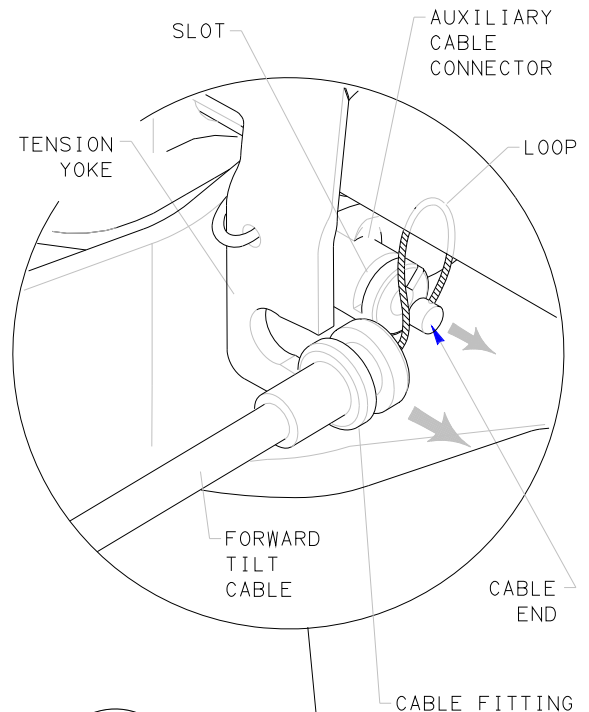
1. If equipped, with forward tilt lever, proceed with steps 8-10, otherwise, go on to step 11. Using needle nose pliers, disengage spring from front limit cam. Using small straight head screwdriver, remove, E-ring holdign front limit cam in place.

### TO REINSTALL :

1. Secure front limit cam with E-ring. Attach spring to front limit cam.

# 9a

(FOR CHAIRS MADE BEFORE 3-9-04)



(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

167206 REV H

## TO REMOVE :

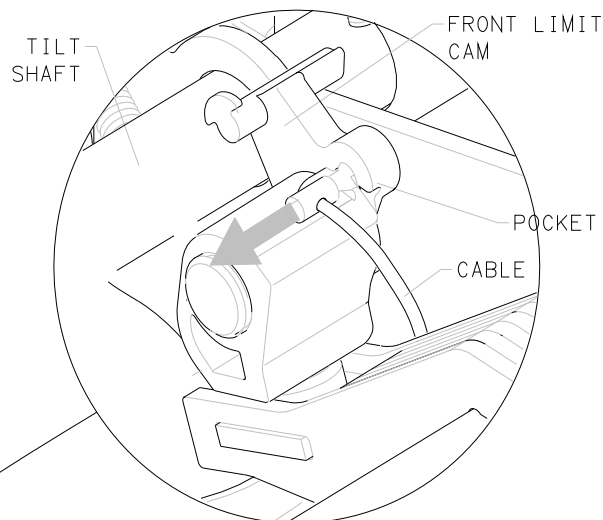
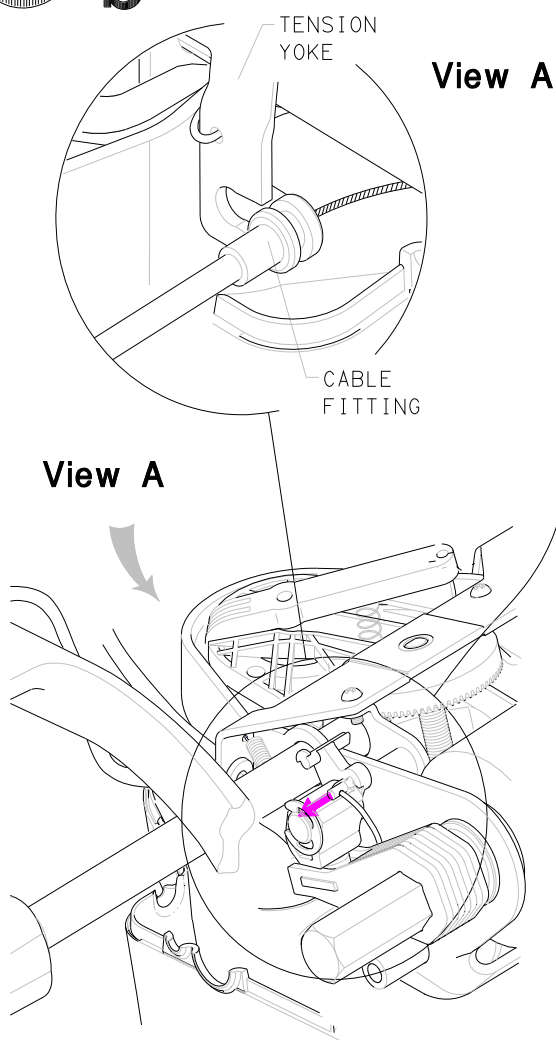
1. Use thumb pressure to remove forward tilt cable fitting (RH side) from tension yoke on tilt. Move cable forward to create loop and disengage cable end from auxiliary cable connector.

## TO REINSTALL :

1. See instructions, "9b", to reinstall "chairs made after 3-09-04.

# 9b

(FOR CHAIRS MADE AFTER 3-9-04)

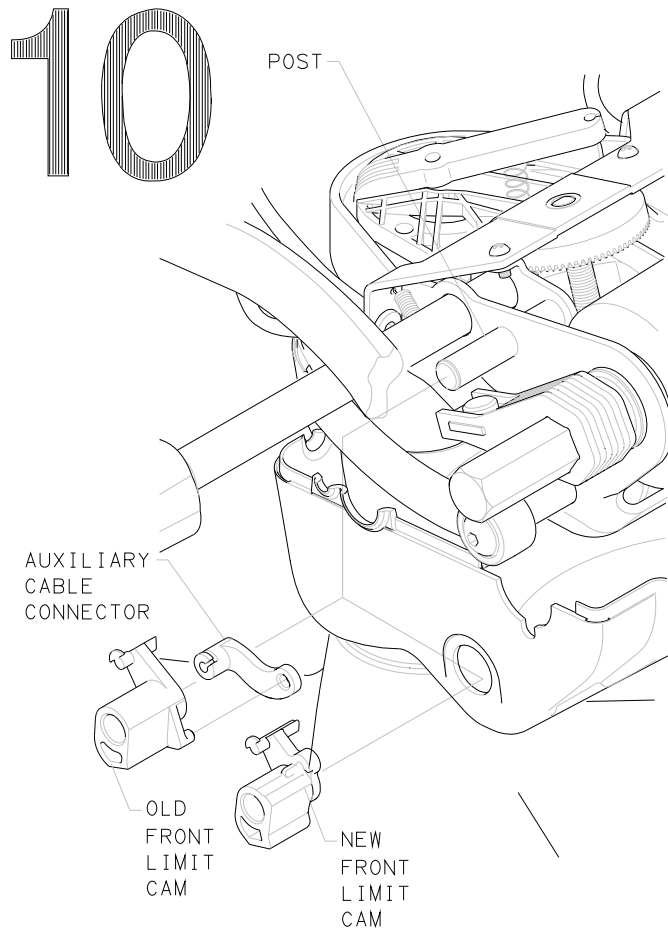


## TO REMOVE :

1. Use thumb pressure to remove forward tilt cable fitting (RH side) from tension yoke on tilt. Move cable forward to provide slack. Using needle nose pliers, slide cable from pocket in front limit cam.

## TO REINSTALL :

1. Feed cable end under tilt shaft along side tilt housing along right side of front limit cam. Insert cable end into pocket on top of front limit cam. Wrap cable around rear of front limit cam, clockwise.
2. Using thumb pressure install replacement cable fitting into tension yoke on tilt.



## WARNING

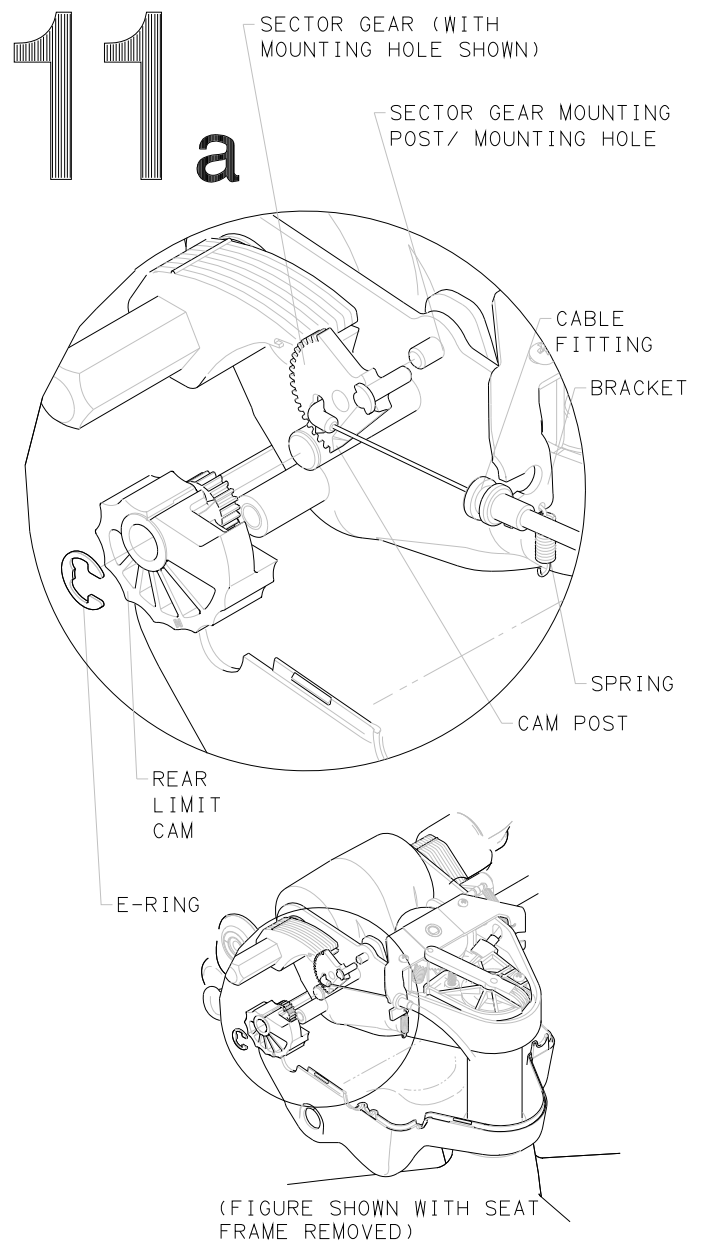
Tilt tension must be maintained during following procedure. Failure to do so may cause personal injury.

## TO REMOVE :

1. Apply downward pressure to top of chair back to relieve pressure from front limit cam. This position must be maintained until front limit cam is installed with E-ring.
2. Remove front limit cam and auxiliary cable connector if applicable, and dispose of properly.

## TO REINSTALL :

1. Slide front limit cam in position shown.
2. Refer back to steps 8 and 9b, for installing cable, securing cable fitting and installing E-clip.

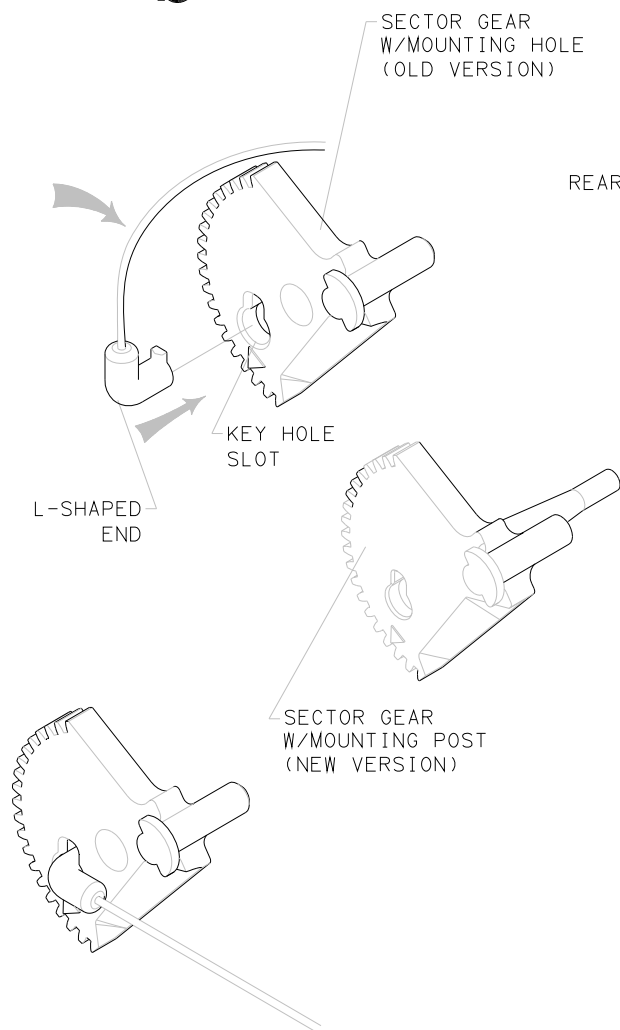


## TO REMOVE :

1. Tilt limiter must be in released position (tilt limiter lever all the way down.) Using small needle nose pliers, remove spring from sector gear and let hang down.
2. Using small straight head screwdriver, remove e-ring securing sector gear. Remove rear limit cam and set aside. Remove sector gear with cable attached, from sector gear post/mounting hole and dispose of properly.

167206 REV H

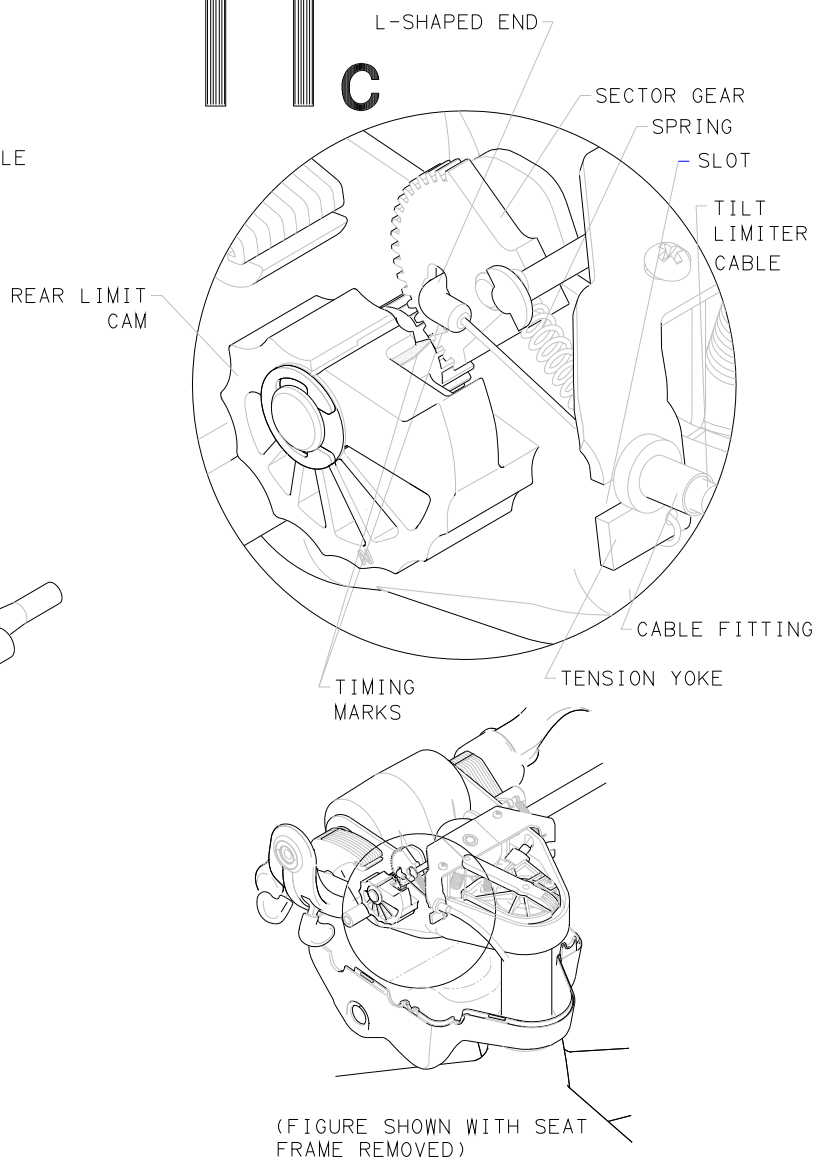
# 11b



## TO REINSTALL :

1. Select appropriate sector gear, one that pivots on post of tilt (older version) or one with intragrel pivoting post that inserts in tilt (newer version).
2. Insert L-shaped end of replacement tilt limiter cable into keyhole slot in replacement gear.

# 11c



## TO REINSTALL :

1. Slide sector gear and attached tilt limiter cable onto sector gear post/mounting hole. Attach spring to sector gear. See figure 11a.
2. Slide rear limit cam on cam post, aligning timing marks on sector gear and rear limit cam. secure with e-ring.
3. Slide tilt limiter cable fitting into slot on end of tension yoke. See figure 11a.



# Aeron® Tilt Control Knob and Lever Replacement

TOOLS REQUIRED: PLIERS  
6MM HEX BIT  
RATCHET WRENCH  
#2 PHILLIPS HEAD SCREWDRIVER

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values

1. USING PLIERS, TWIST OFF APPROPRIATE TILT KNOB(S) FROM LEVER(S) OF TILT CONTROL. SEE FIGURE 1.
2. USING 6MM HEX BIT AND RATCHET WRENCH, LOOSEN SEAT FRAME MOUNTING SCREW ENOUGH TO DISENGAGE SCREW FROM SEAT FRAME. SEE FIGURE 2.

### CAUTION

When removing screw holding tilt control to swing arm, isolate from other hardware. Failure to use same screw in same location will cause product damage.

3. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SET ASIDE SCREW FASTENING TILT CONTROL TO SWING ARM. KEEP THIS SCREW ISOLATED FROM ALL OTHER HARDWARE WHILE UNDERGOING THIS PROCEDURE. SEE FIGURE 2.
4. LIFT SEAT FRAME SLIGHTLY FOR ACCESS TO TILT CONTROL. REMOVE TILT CONTROL FROM SWING ARM. REST SEAT FRAME ON SWING ARM. SEE FIGURE 2.
5. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SET ASIDE (2) SCREWS FASTENING TILT CONTROL COVER TO TILT CONTROL HOUSING. SET ASIDE TILT CONTROL COVER. SEE FIGURE 3.
6. REMOVE TILT LIMITER LEVER / FORWARD TILT LEVER ASSEMBLIES FROM TILT CONTROL HOUSING. SEE FIGURE 4.
7. REMOVE AND SET ASIDE PAD AND SPRING FROM LEVER. REMOVE CABLE FROM LEVER. PROPERLY DISPOSE OF LEVER(S). SEE FIGURE 5.
8. INSTALL REPLACEMENT LEVER INTO APPROPRIATE SIDE OF TILT CONTROL HOUSING.

NOTE: WHEN REPLACING LEVERS ON CHAIRS MANUFACTURED BEFORE 9-17-02, PROPERLY DISPOSE OF TILT CONTROL HOUSING AND EXCHANGE WITH REPLACEMENT.

SLIDE CABLE COUPLING INTO TILT CONTROL HOUSING AND SLIDE CABLE INTO LEVER. INSERT SPRING OVER CABLE INTO CAVITY OF LEVER. PLACE PAD OVER SPRING. SEE FIGURE 5.

9. INSTALL TILT CONTROL COVER TO TILT CONTROL HOUSING AND SECURE WITH (2) SCREWS. SEE FIGURE 3.
10. LIFT SEAT FRAME SLIGHTLY AND INSTALL REPLACEMENT TILT CONTROL INTO SWING ARM. SEE FIGURE 2.
11. SECURE TILT CONTROL TO SWING ARM WITH SCREW. SEE FIGURE 2.

12. REINSERT SCREW SECURING SEAT FRAME TO SWING ARM. TORQUE SCREW TO 175-225 IN-LBS. SEE FIGURE 2.
13. PUSH APPROPRIATE REPLACEMENT CONTROL KNOB(S) ONTO APPROPRIATE LEVER(S) OF TILT CONTROL UNTIL A "CLICK" IS HEARD, INDICATING THE KNOB HAS LOCKED IN PLACE. SEE FIGURE 6.

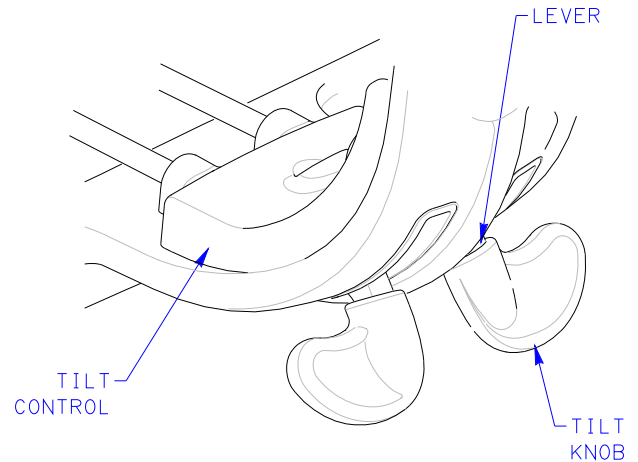


FIGURE 1

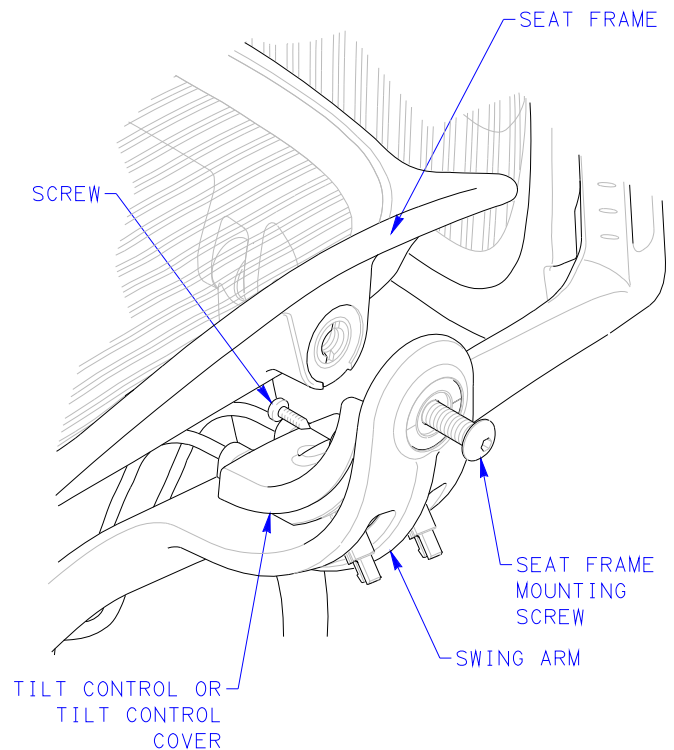


FIGURE 2

173118 REV D



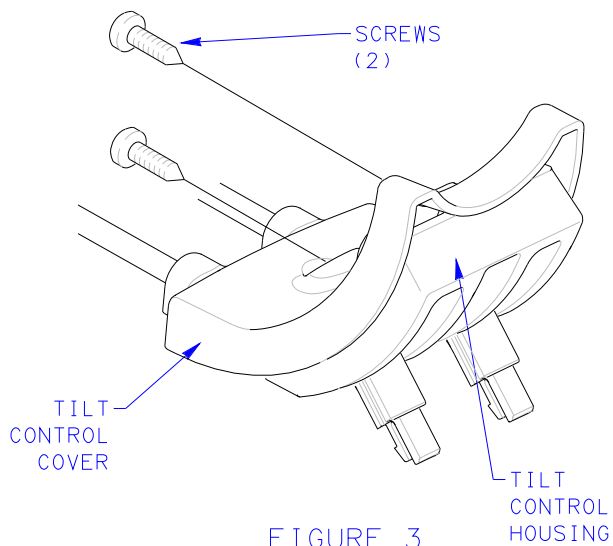


FIGURE 3

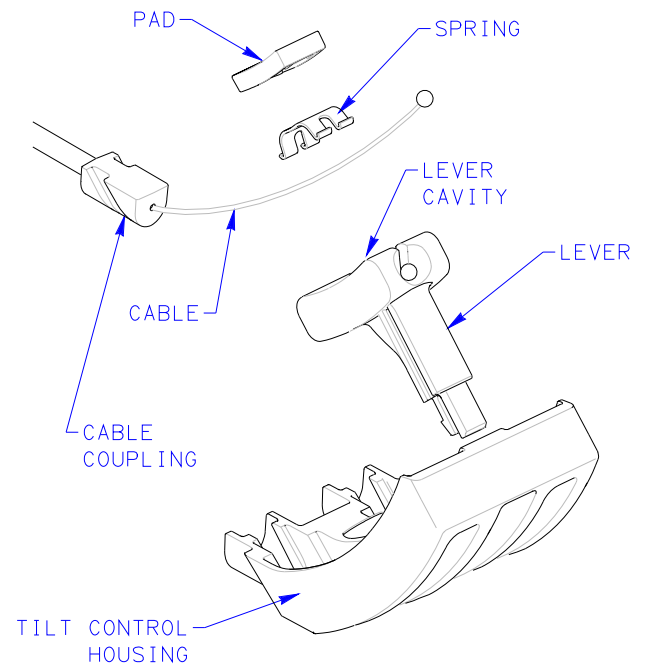


FIGURE 5

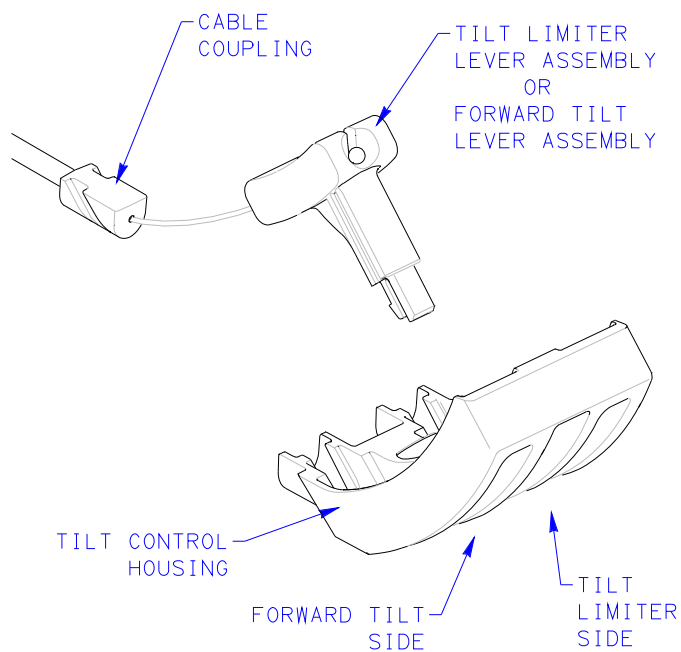


FIGURE 4

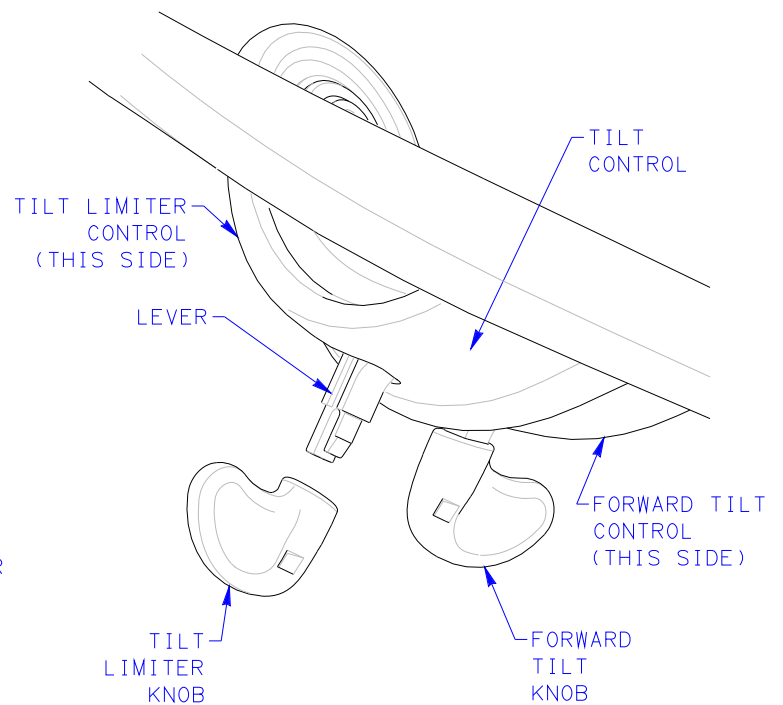


FIGURE 6

173118 REV D

# Aeron® Sector Gear & Tilt Limiter Cable Replacement

TOOLS REQUIRED: 6MM HEX BIT  
RATCHET WRENCH  
1" PUTTY KNIFE  
#2 PHILLIPS HEAD SCREWDRIVER  
SMALL NEEDLE NOSE PLIERS  
STRAIGHT HEAD SCREWDRIVER  
TORQUE WRENCH, 225 IN-LB CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### CAUTION

Support seat link while removing seat link from chair. Failure to comply may cause seat link to fall causing product damage.

1. WITH SEAT LINK SUPPORTED AND USING 6MM HEX BIT AND RATCHET WRENCH, REMOVE AND SAVE FRONT SHOULDER SCREW.

NOTE: IF SPACER IS USED BETWEEN TILT COVER AND SEAT LINK, REMOVE SPACER AND SET ASIDE. IF BUSHINGS USED IN SEAT LINK BECOME DISLODGED, SET ASIDE.

LET SEAT LINK HANG FREE. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 & 2.

### CAUTION

If threaded inserts turn while removing hip pivot screw from seat frame, STOP IMMEDIATELY and follow instructions.

2. USE RATCHET WRENCH AND 6MM HEX BIT TO REMOVE HIP PIVOT SCREW FROM SWING ARM. IF THREADED INSERT TURNS WITH HIP PIVOT SCREW, STOP IMMEDIATELY AND DO FOLLOWING: TIGHTEN HIP PIVOT SCREW INTO THREADED INSERT AS MUCH AS POSSIBLE. USING QUICK JERKING MOTION WITH RATCHET WRENCH, BACKOUT HIP PIVOT SCREW. IF THREADED INSERT STILL TURNS WITH HIP PIVOT SCREW, REPEAT PROCESS. REPEAT FOR OPPOSITE SIDE AND REMOVE SEAT WITH ATTACHED SEAT LINKS. SEE FIGURE 4.
3. APPLY THUMB PRESSURE ON FRONT OF BOTTOM TILT COVER TO START SEPARATION OF TILT COVERS. INSERT 1" PUTTY KNIFE BETWEEN TOP AND BOTTOM COVERS AND TWIST TO COMPLETELY SEPARATE TILT COVERS. SET TOP TILT COVER ASIDE. SEE FIGURES 5 & 6.
4. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND SET ASIDE (2) SCREWS SECURING BOTTOM TILT COVER TO TILT. REST BOTTOM TILT COVER ON CHAIR BASE. SEE FIGURE 7.

### NOTICE

Tilt Limiter must be in released position to service. (Tilt limiter lever all the way down).

5. TILT LIMITER MUST BE IN RELEASED POSITION (TILT LIMITER LEVER ALL THE WAY DOWN). USING SMALL NEEDLE NOSE PLIERS, REMOVE SPRING FROM SECTOR GEAR AND LET HANG DOWN. SEE FIGURE 8.

6. USING SMALL STRAIGHT HEAD SCREWDRIVER, REMOVE E-RING SECURING REAR LIMIT CAM AND SET ASIDE. REMOVE REAR LIMIT CAM AND SET ASIDE. REMOVE SECTOR GEAR, WITH CABLE ATTACHED, FROM SECTOR GEAR POST AND LET HANG. SEE FIGURE 9.

### CAUTION

When removing screw holding tilt control to swing arm, isolate from other hardware. Failure to use same screw in same location will cause product damage.

7. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SET ASIDE SCREW FASTENING TILT CONTROL TO SWING ARM. KEEP THIS SCREW ISOLATED FROM ALL OTHER HARDWARE WHILE UNDERGOING THIS PROCEDURE. SEE FIGURE 10.
8. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SET ASIDE (2) SCREWS FASTENING TILT CONTROL COVER TO TILT CONTROL HOUSING. SET ASIDE TILT CONTROL COVER. SEE FIGURE 10.
9. REMOVE AND SET ASIDE PAD AND SPRING FROM TILT LIMITER LEVER. REMOVE TILT LIMITER CABLE FROM TILT LIMITER LEVER. PROPERLY DISPOSE OF TILT LIMITER CABLE AND ATTACHED SECTOR GEAR. SEE FIGURE 11.
10. SELECT APPROPRIATE SECTOR GEAR, ONE THAT PIVOTS ON POST OF TILT (OLDER VERSION) OR ONE WITH INTEGRAL PIVOTING POST THAT INSERTS IN TILT (NEWER VERSION). INSERT L-SHAPED END OF REPLACEMENT TILT LIMITER CABLE INTO KEYHOLE SLOT IN REPLACEMENT GEAR. SEE FIGURE 12.
11. SLIDE SECTOR GEAR AND ATTACHED TILT LIMITER CABLE ONTO SECTOR GEAR POST/SECTOR GEAR MOUNTING HOLE. ATTACH SPRING TO SECTOR GEAR. SEE FIGURES 13 & 14.
12. SLIDE REAR LIMIT CAM ON CAM POST, ALIGNING TIMING MARKS ON SECTOR GEAR AND REAR LIMIT CAM. SECURE WITH E-RING. SEE FIGURE 14.
13. SLIDE REPLACEMENT TILT LIMITER CABLE COUPLING INTO SLOT IN TILT LIMITER LEVER. INSERT SPRING OVER CABLE INTO CAVITY OF LEVER. PLACE PAD OVER SPRING. SEE FIGURE 11.
14. INSTALL TILT CONTROL COVER ON TILT CONTROL HOUSING AND SECURE WITH (2) SCREWS. SEE FIGURE 10.
15. SECURE TILT CONTROL TO SWING ARM WITH SCREW. SEE FIGURE 10.

### CAUTION

Make sure all cables are routed through cable penings on tilt cover before snapping tilt cover in place or product damage may occur.

183970 REV C

15. SLIDE BOTTOM TILT COVER UP TO TILT. MAKE SURE NOTCHES IN TILT SPACER GROOVES ENGAGE SLOTS IN TILT COVER. IF NECESSARY, ROTATE TILT SPACERS TO ALIGN NOTCHES WITH SLOTS. ALIGN (2) HOLES IN TILT COVER TO HOLES IN TILT. REINSTALL (2) SCREWS AND TIGHTEN. SEE FIGURE 7.
16. PLACE TOP TILT COVER ON TILT AND ALIGN TO BOTTOM TILT COVER. ROUTE ALL CABLES THROUGH CABLE OPENINGS AND SNAP COVERS TOGETHER. SEE FIGURE 6.
17. PLACE SEAT FRAME WITH ATTACHED SEAT LINKS BETWEEN SWING ARMS. INSERT SCREWS SECURING SEAT FRAME TO SWING ARM. TORQUE SCREW TO 175-225 IN-LBS. SEE FIGURE 4.

#### NOTICE

On older chairs, bushings may become dislodged from seat link while chair is serviced. Check all unattached seat link ends to account for bushings and proper orientation of bushings before attaching to chair.

#### NOTICE

On older chairs, hold bushings in seat link while mounting to chair.

18. ALIGN MOUNTING HOLE OF SEAT LINK TO THAT OF TILT AND HAND THREAD FRONT SHOULDER SCREW. IF CHAIR WAS EQUIPPED WITH SPACERS AND BUSHINGS, MAKE SURE ALL BUSHINGS ARE ACCOUNTED FOR AND ORIENTED TO NOTCH IN SEAT LINK BEFORE INSTALLING AND SPACERS ARE INSTALLED BETWEEN SEAT LINKS AND TILT COVER. TORQUE SCREW TO 120-150 IN-LBS. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1-3.

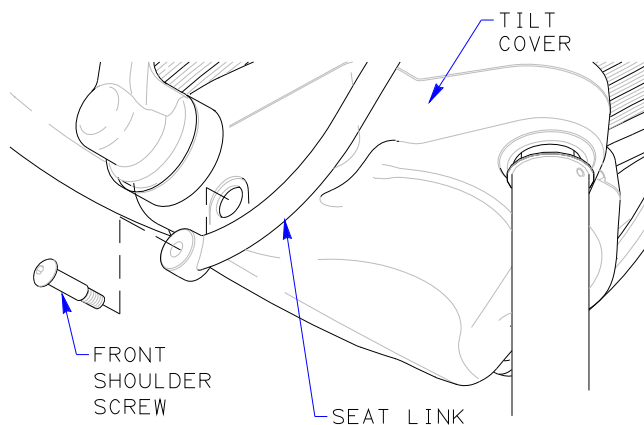


FIGURE 1

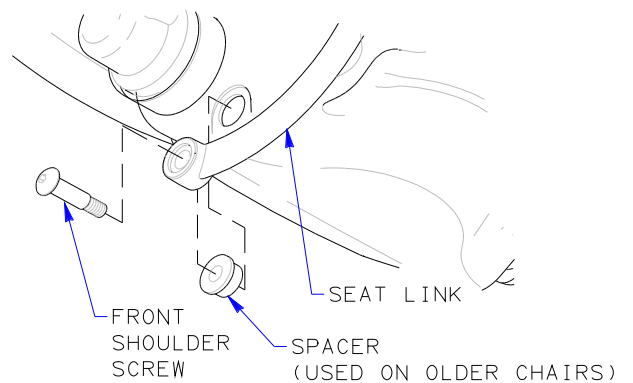


FIGURE 2

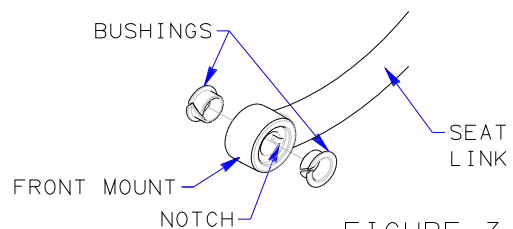


FIGURE 3

(FIGURE SHOWN FOR OLDER CHAIRS)

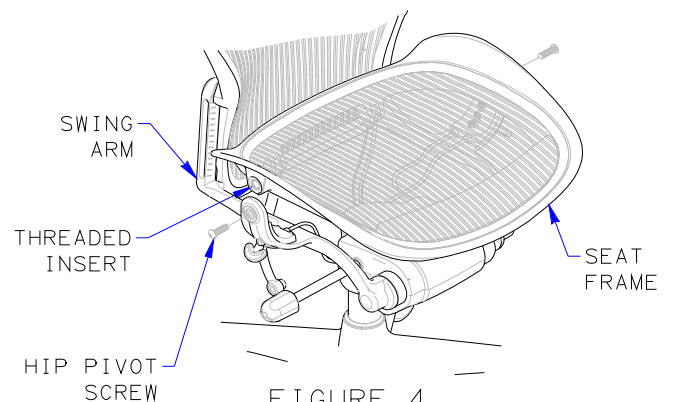


FIGURE 4

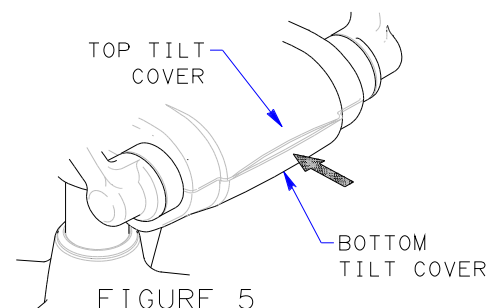


FIGURE 5

(FIGURE SHOWN WITH SEAT FRAME REMOVED)

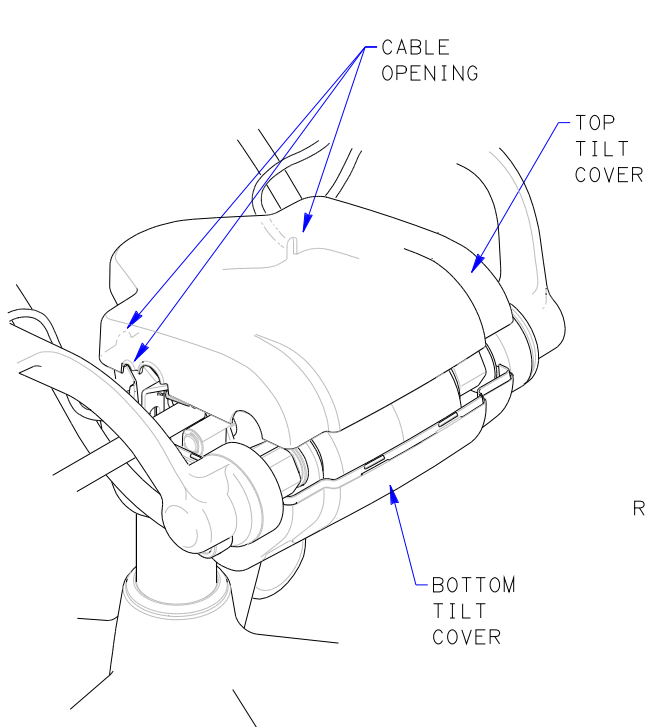


FIGURE 6  
(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

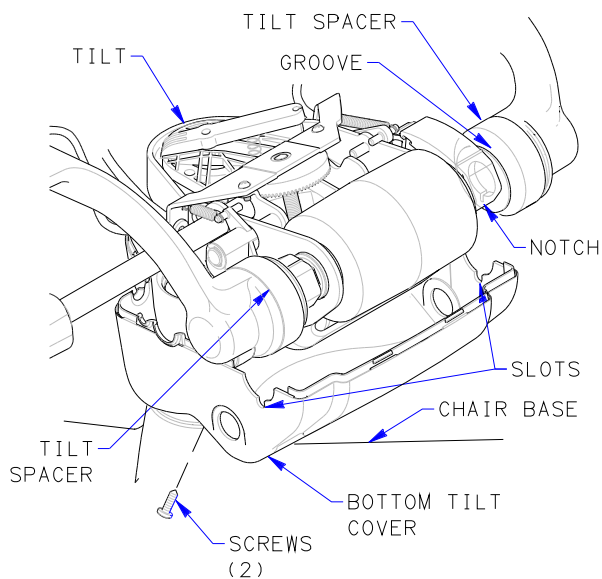


FIGURE 7  
(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

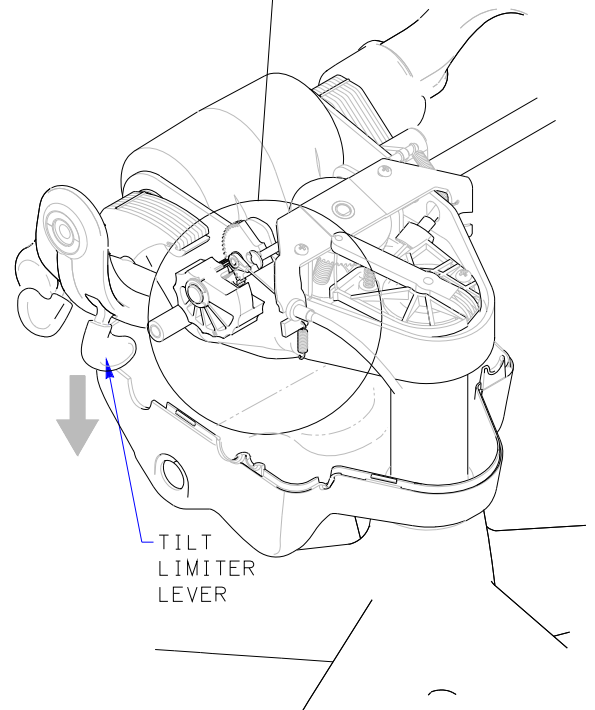
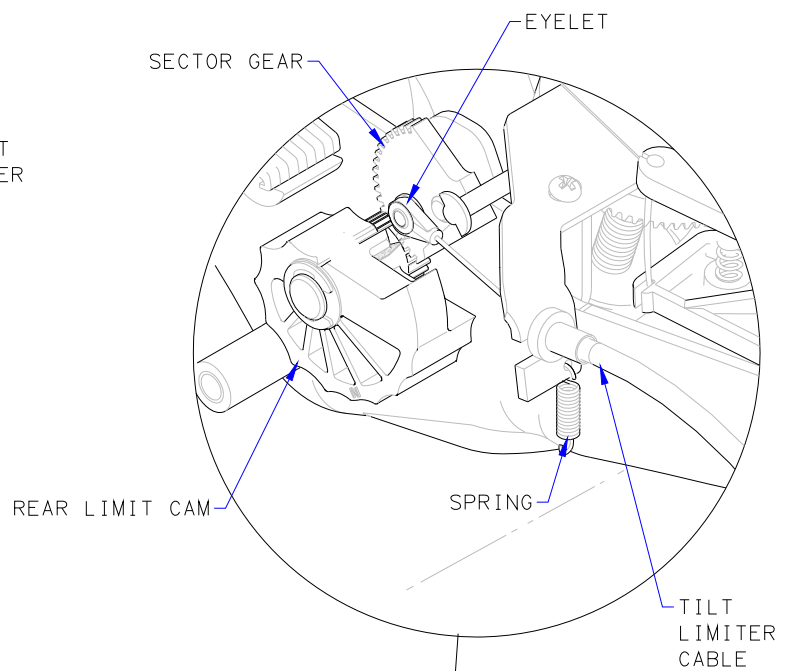


FIGURE 8  
(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

183970 REV C

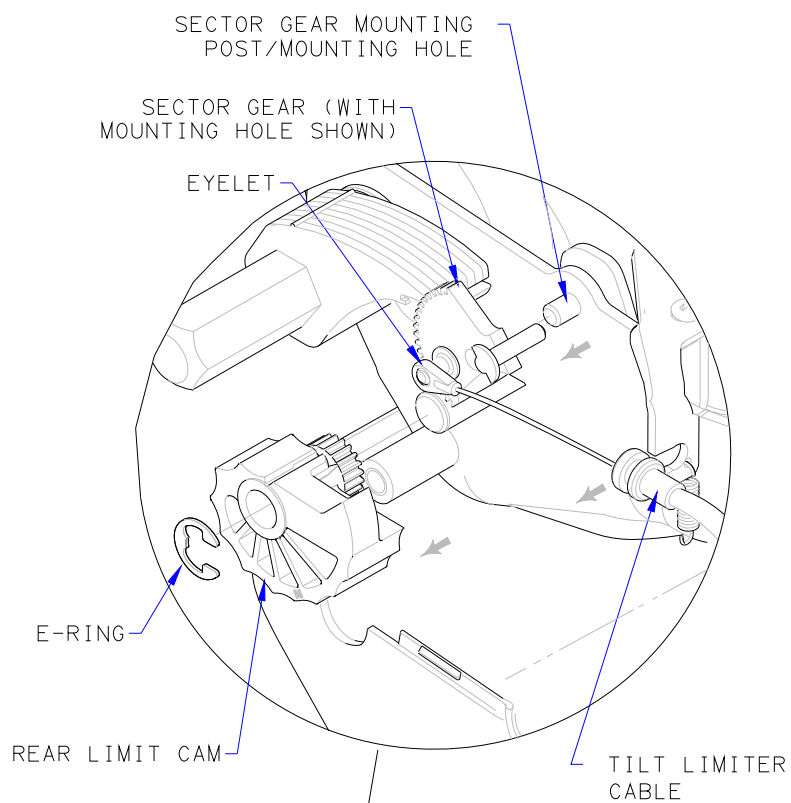


FIGURE 9

(FIGURE SHOWN WITH SEAT FRAME REMOVED)

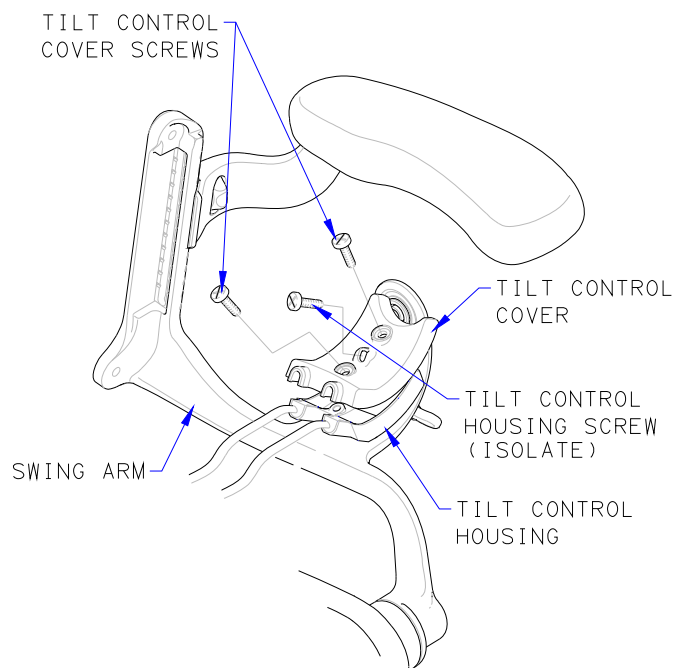


FIGURE 10

(FIGURE SHOWN WITH SEAT FRAME AND BACK REMOVED)

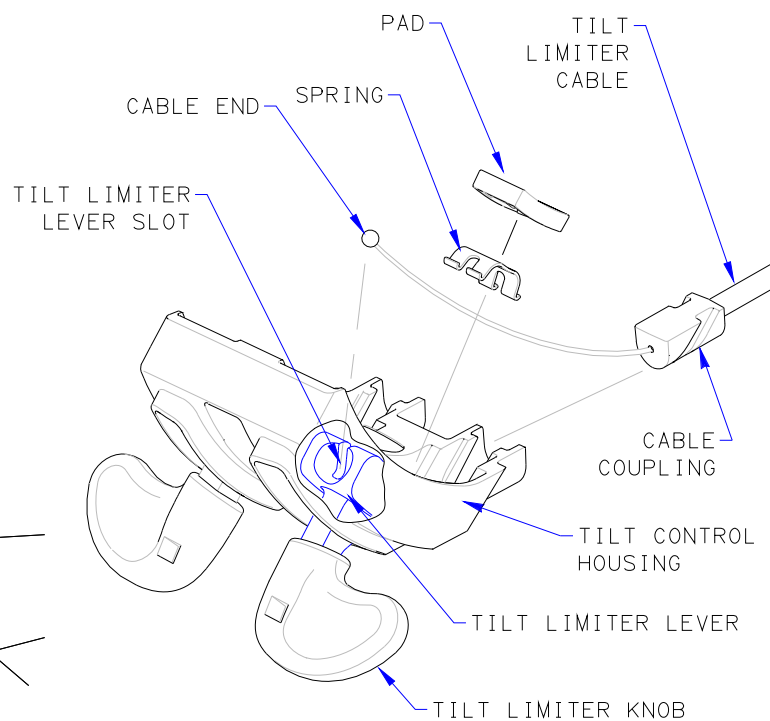


FIGURE 11

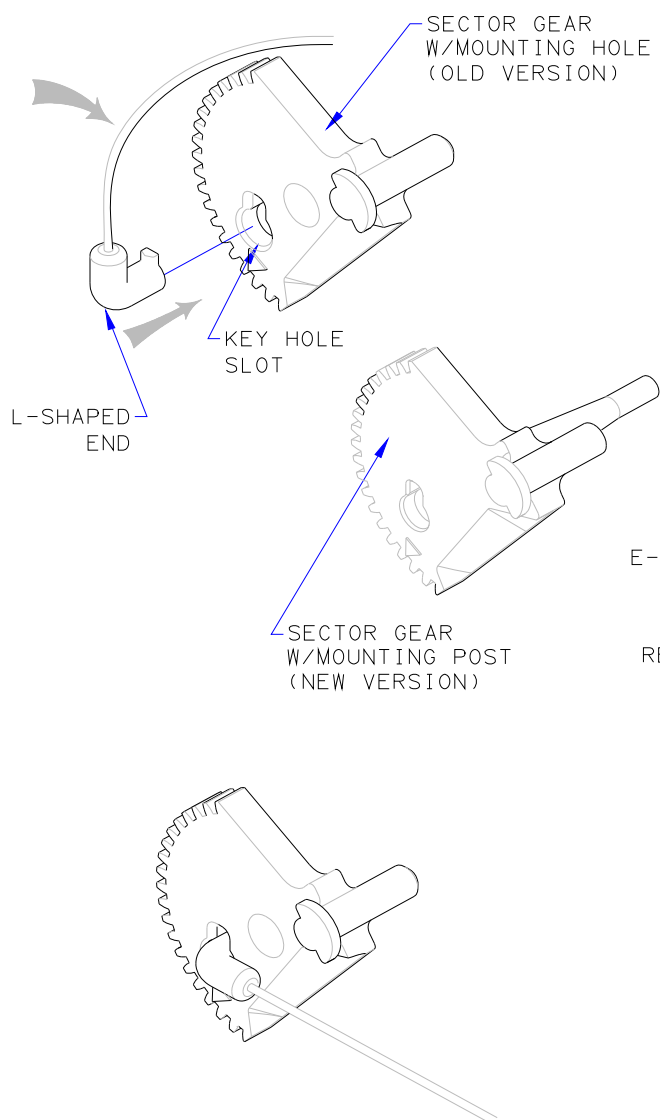


FIGURE 12

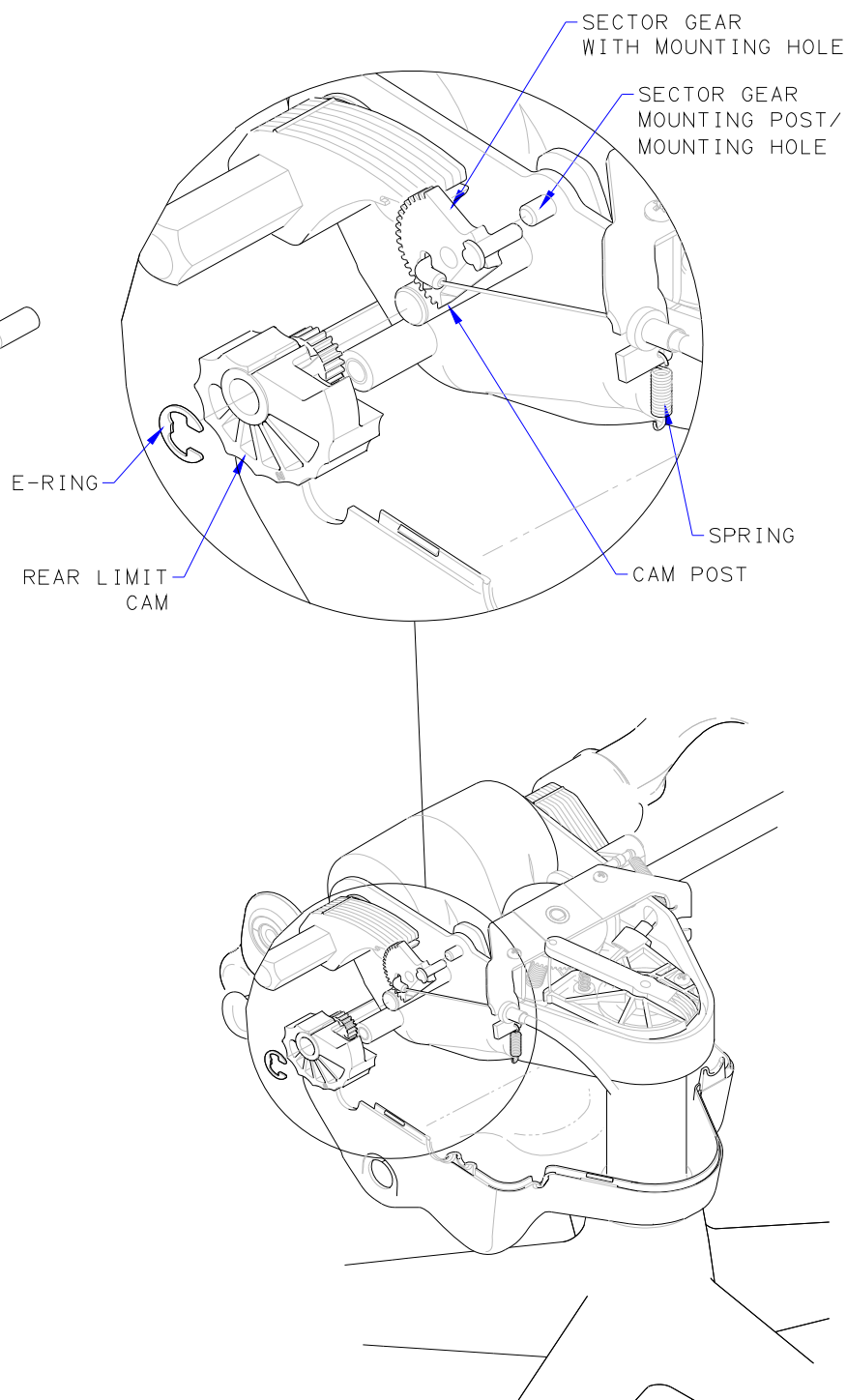


FIGURE 13

(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

183970 REV C

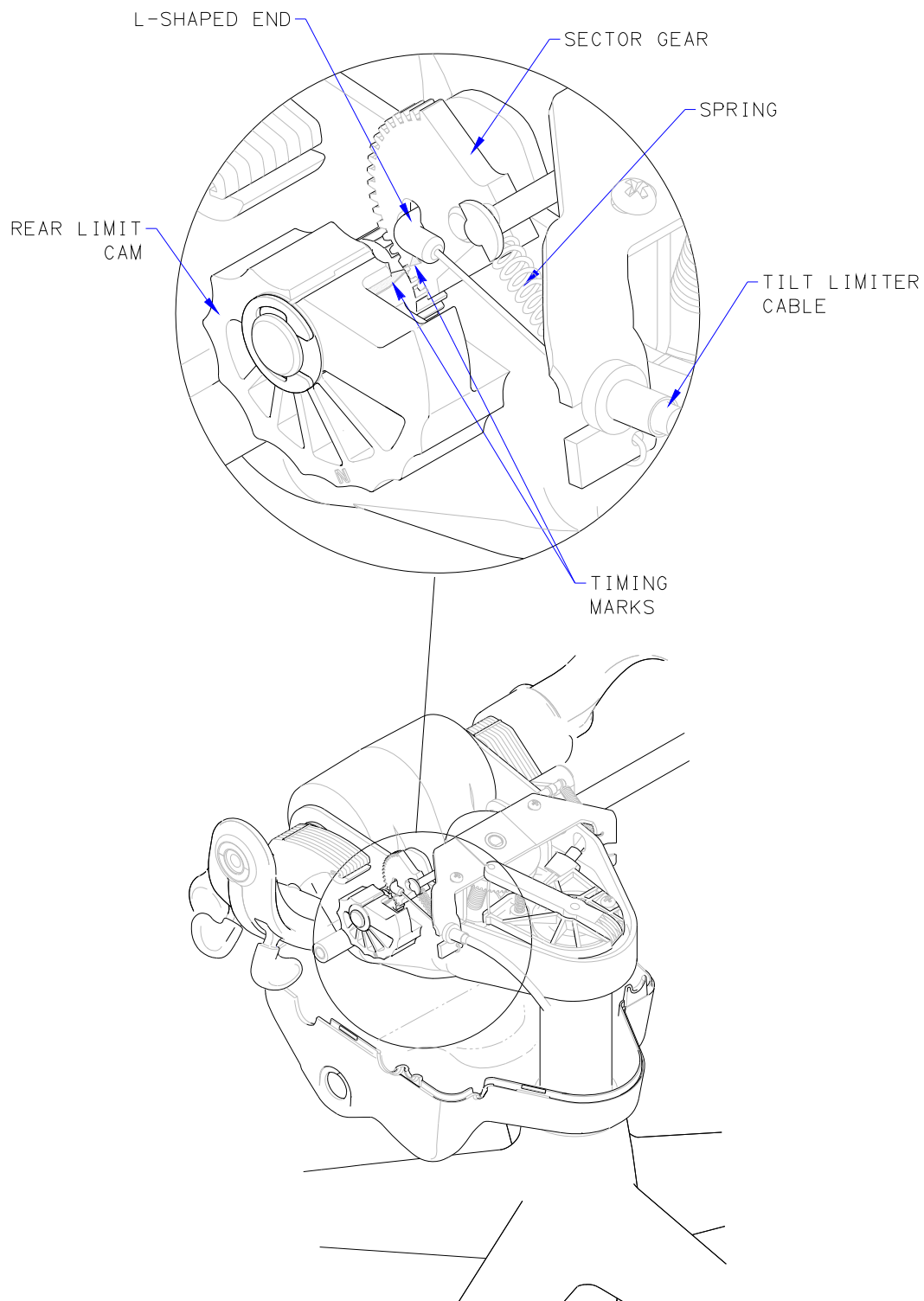
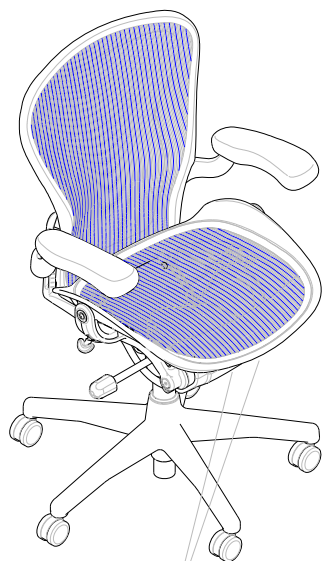


FIGURE 14

(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

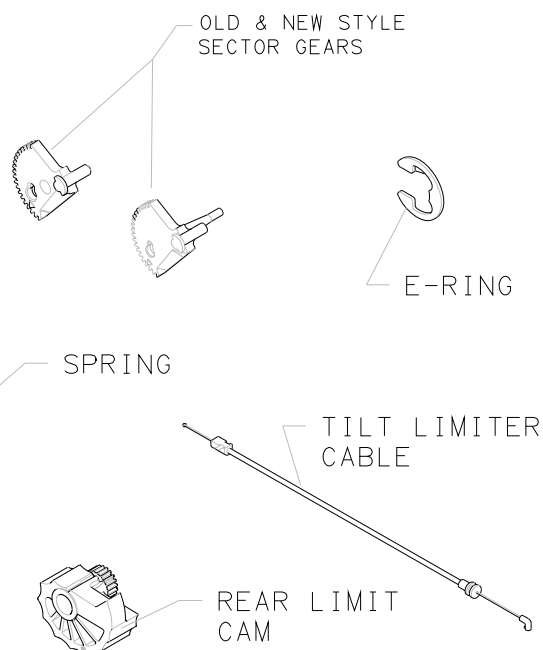


# Aeron® Rear Limit Cam, Tilt Sector Gear & Cable Replacement

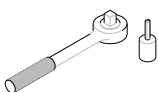


REAR LIMIT CAM,  
TILT SECTOR GEAR &  
CABLE

## PARTS INCLUDED



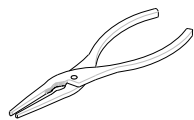
## TOOLS NEEDED



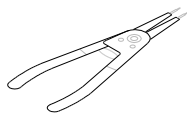
RATCHET WRENCH W/  
6MM HEX HEAD BIT



1" PUTTY KNIFE



KNEEDLE NOSE PLIERS



RING RETAINER  
TOOL



#2 PHILLIPS  
HEAD SCREWDRIVER

## PROCEDURE

### NOTICE

Make sure fasteners are torqued to specified values.



### CAUTION

Tilt tension must be put at the lowest position to install this service item.

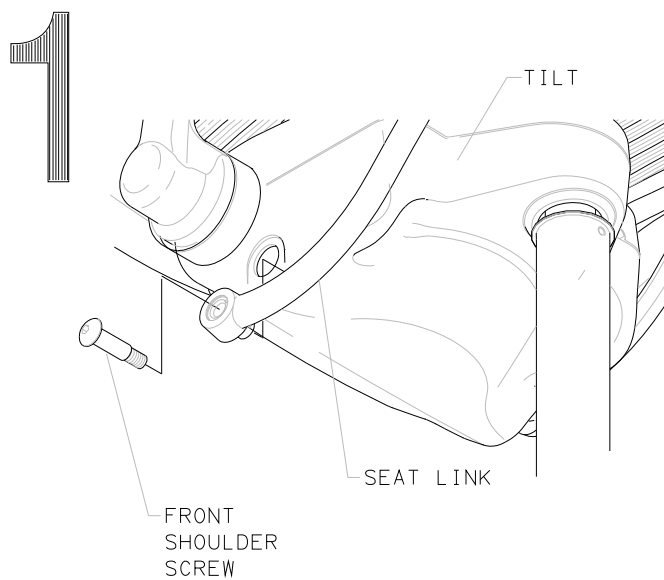


### CAUTION

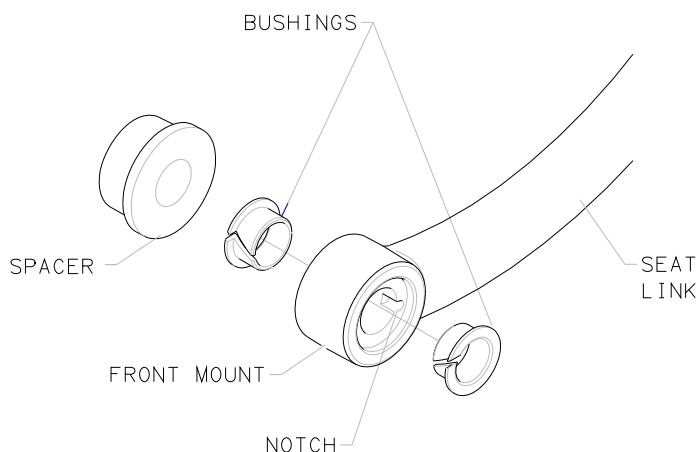
Forward tilt must not be in activated position before this service procedure begins.

184790 REV D





(OLDER VERSION)

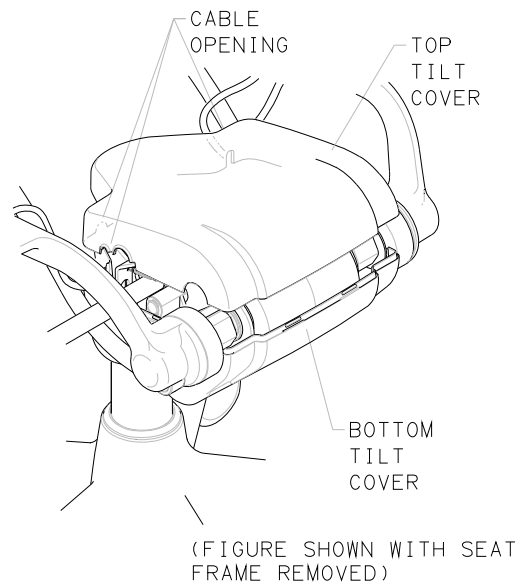
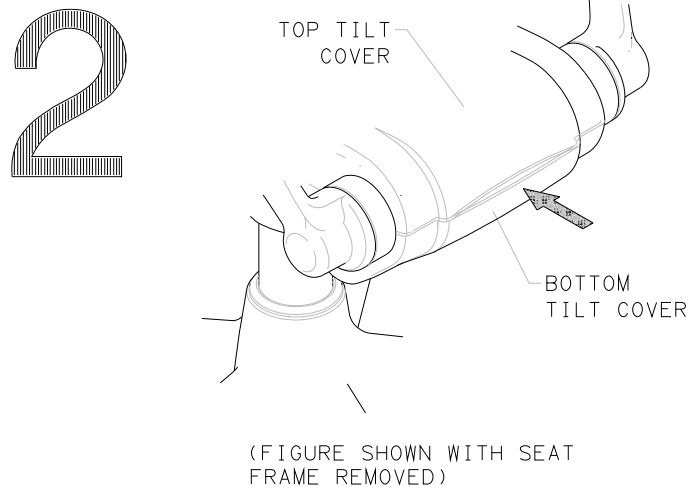


TO REMOVE :

1. While supporting seat link, use 6MM socket, ratchet wrench to remove shoulder screw attaching seat link to tilt. Set aside shoulder screw. Let seat link hang. Remove spacers and or bushings if applicable and set aside. Repeat for opposite side.

TO REINSTALL :

1. Attach front mount of seat link to tilt with shoulder screw. Tighten and torque to 120-150 in-lbs.



#### ⚠ CAUTION

Make sure all cables are routed through cable openings on tilt cover before snapping tilt cover in place or product damage occur.

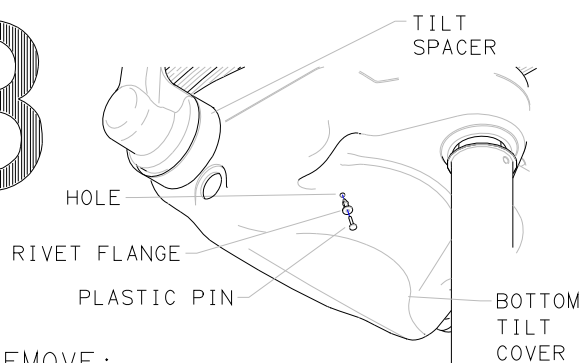
TO REMOVE :

1. Apply pressure on front of bottom tilt cover to start separation of tilt covers. Insert 1" putty knife between top and bottom covers and twist to completely separate tilt covers. Set top tilt cover aside.

TO REINSTALL :

1. Place top tilt cover on tilt and align to bottom tilt cover. Route all cables through cable openings and snap covers together.

# 3

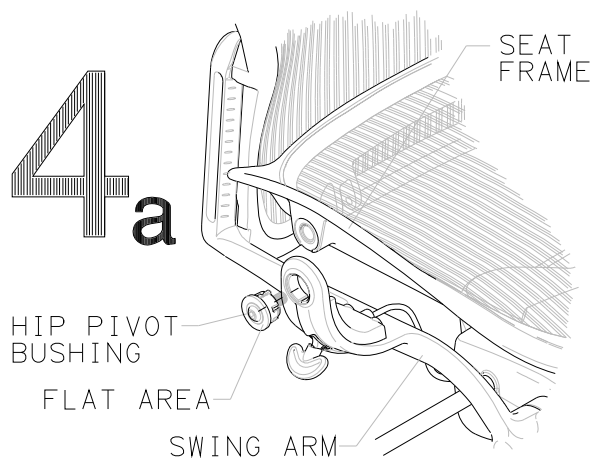


## TO REMOVE :

1. Using needle nose pliers, remove plastic pin from rivet flange from under side of lower tilt cover on left side and set aside. Using needle nose pliers, remove rivet flange from tilt cover and set aside. Let bottom cover rest on base. Older chairs secure cover with (2) phillipshead screws. Use #2 phillips head screwdriver to remove and set aside.

## TO REINSTALL :

1. Slide bottom tilt cover up to tilt. Make sure notches in tilt spacer grooves engage slots in tilt cover. If necessary, rotate tilt spacers to align notches with slots. Align hole in tilt cover to hole in tilt. Install rivet flange into tiltcover and tilt. Insert rivet pin into rivet flange.



(FOR CHAIRS MANUFACTURED AFTER JUNE 4,2003)

(FOR CHAIRS MANUFACTURED AFTER MARCH 9 ,2004, GO ON TO STEP 7)

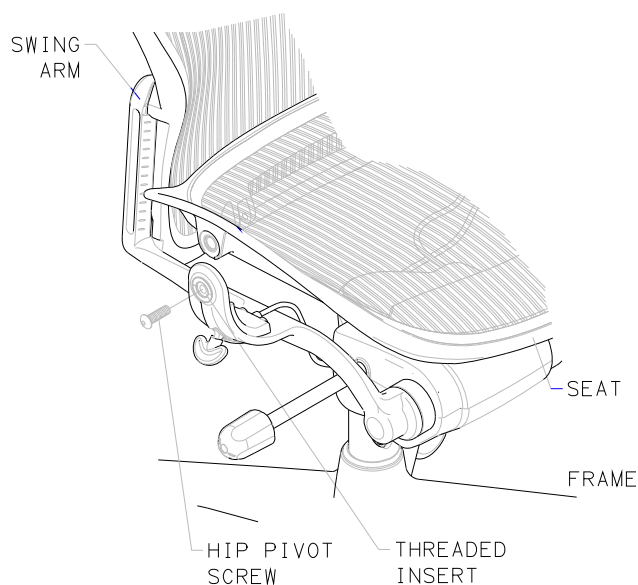
## TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot bushing assembly from swing arm. Loosening pivot fastener will force hip pivot bushing assembly from swing arm. After hip pivot fastener has disengaged from seat frame, remove hip pivot bushing and set aside. Repeat for other side. Remove seat frame with b-links and set aside.

## TO REINSTALL :

1. Make certain flat area around fasteners head in hip pivot bushing is flat and aligned with bushing area. Repeat for other hip pivot bushing.
2. Lower seat in place. Align fastener in seat frame to mounting hole in swing arm and insert hip pivot bushing.
3. Insert other hip pivot fastener into swing arm aligning top and bottom guides into slots in swing arm opening.
4. Using 6MM head bit and ratchet wrench, partially thread hip pivot fastener into seat frame. Repeat for opposite side.
5. Secure fasteners of hip pivot bushing, drawing hip pivot bushing into seat frame. Torque fasteners to 180-200 lbs.

# 4b



(FOR CHAIRS MANUFACTURED BEFORE JUNE 4,2003)

184790 REV D

## TO REMOVE :

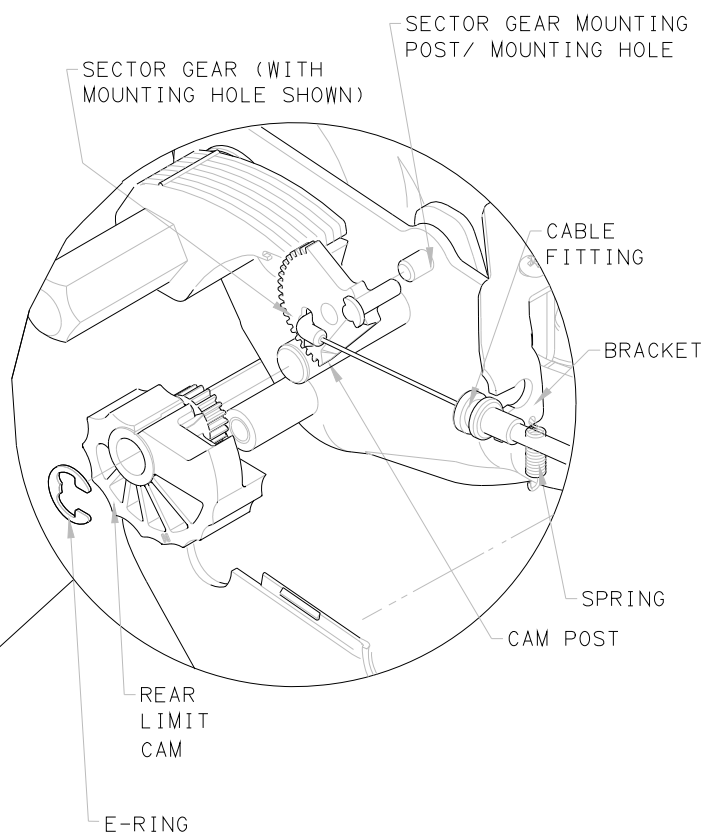
1. Using ratchet and 6MM hex bit, remove hip pivot screw from each swing arm. If threaded insert turns with hip pivot screw, **STOP** immediately and do the following step: Tighten hip pivot screw into threaded insert as much as possible. Using a quick jerking motion with ratchet wrench. Back out hip pivot screw from threaded insert. If threaded insert turns with hip pivot screw, repeat process.

### CAUTION

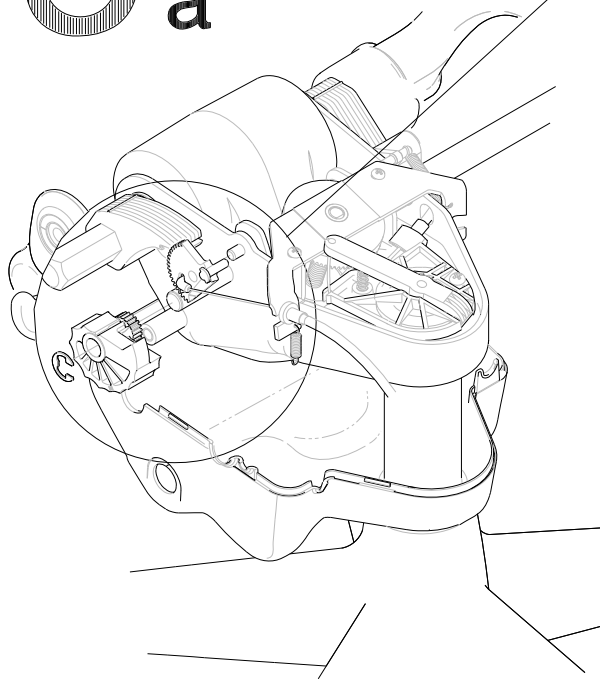
If threaded inserts turn while removing hip pivot screws from seat frame, **STOP IMMEDIATELY** and follow instructions.

## TO REINSTALL :

1. Place seat frame between swing arms. Attach seat frame to swing arms with hip pivot screws. Tighten and torque to 180-200 in lbs.



# 5 a



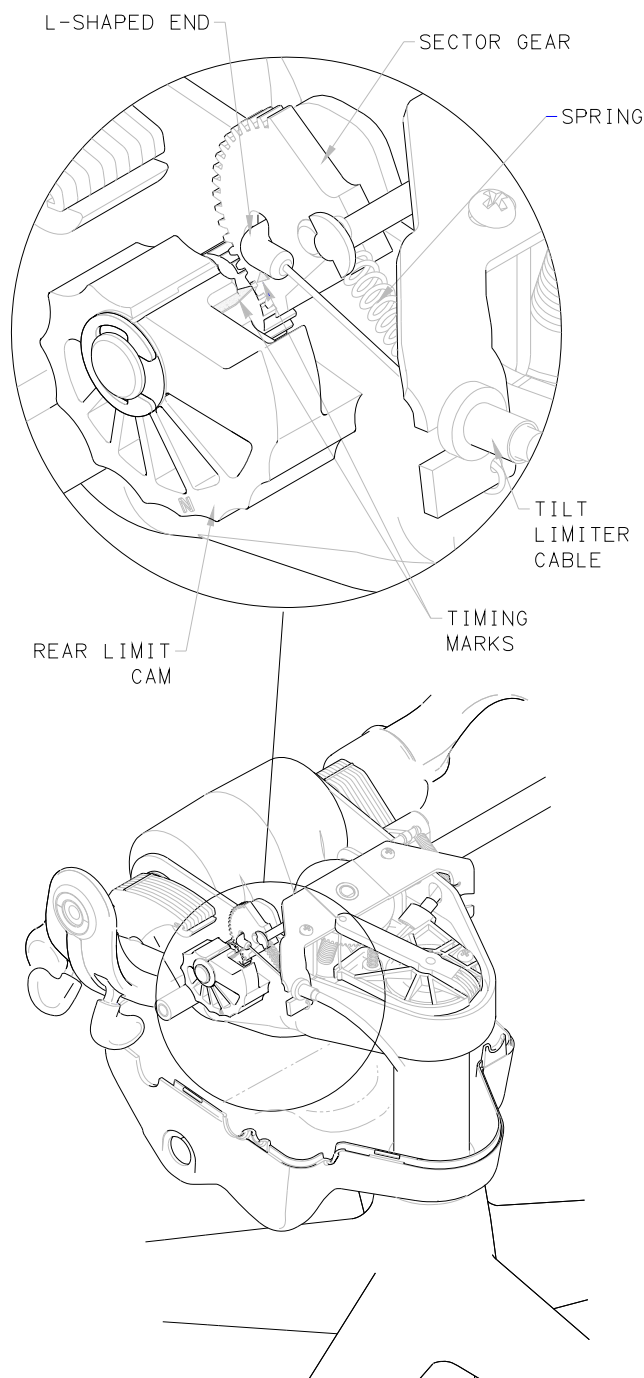
## TO REMOVE :

1. Tilt limiter must be in released position (tilt limiter lever all the way down.) Using small needle nose pliers, remove spring from sector gear and let hang down.
2. Using small straight head screwdriver, remove e-ring securing rear limit cam and set aside. Remove rear limit cam and dispose of properly. Remove sector gear, with cable attached from sector gear post and let hang. If chair is manufactured after 8-23-04, remove sector gear from cable and dispose of properly. See figure in step 8.

## TO REINSTALL :

1. Slide sector gear and attached tilt limiter cable onto sector gear post/sector gear mounting hole. Attach spring to sector gear.

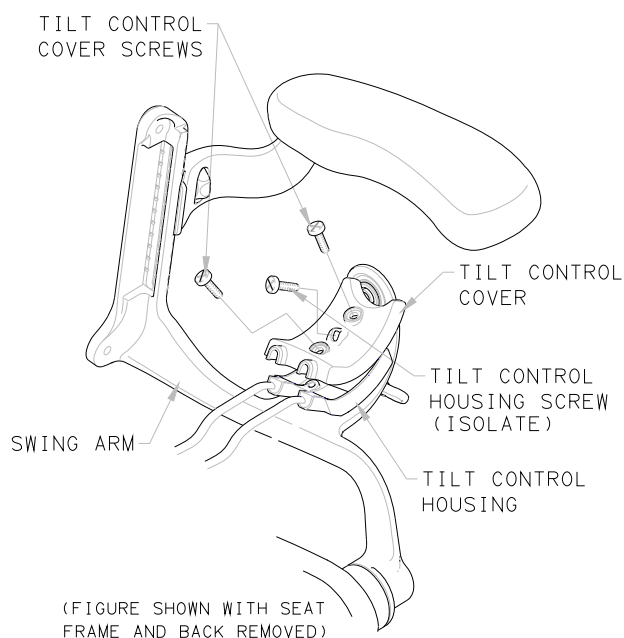
# 5b



## TO REINSTALL :

1. Slide rear limit cam on cam post, aligning timing marks on sector gear and rear limit cam. Secure with e-ring.
2. Slide tilt limiter cable mounting flange into slot on end of tension yoke.

# 6



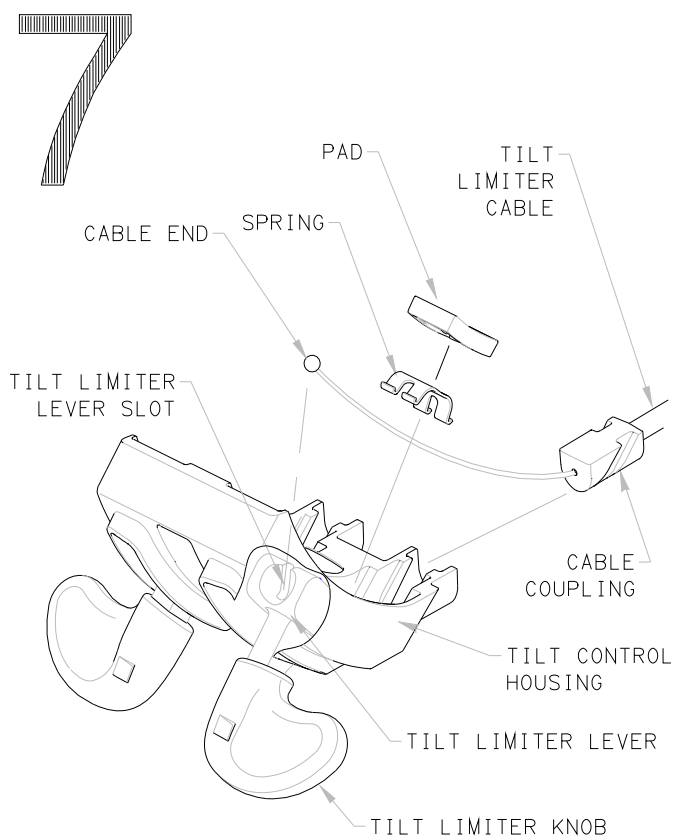
## TO REMOVE : (FOR CHAIRS MANUFACTURED BEFORE 8-23-04)

1. Using #2 phillips head screwdriver, remove and set aside screw tilt control to swing arm. Keep this screw isolated from all other hardware while undergoing this procedure. Remove and set aside (2) screws fastening tilt control cover to tilt control housing. Set aside tilt control cover.

## TO REINSTALL :

1. Using #2 phillips head screwdriver, secure tilt control cover on tilt control housing with (2) screws.
2. Using #2 phillips head screwdriver, secure tilt control to swing arm with screw.

184790 REV D

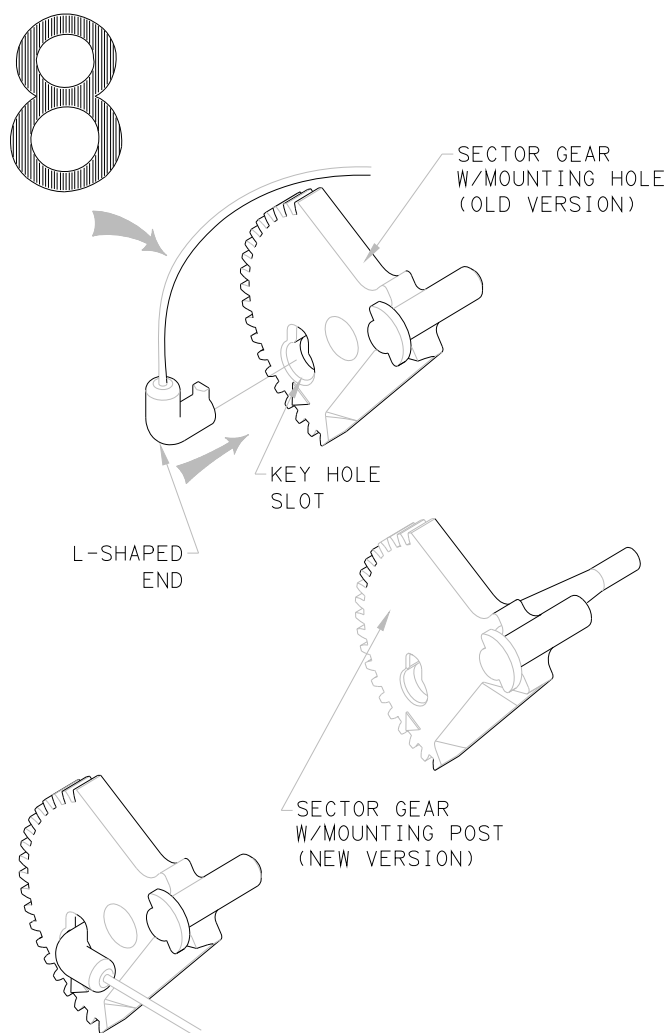


TO REMOVE: (FOR CHAIRS MANUFACTURED BEFORE 8-23-04)

1. Remove and set aside pad and spring from tilt limiter lever. Remove tilt limiter cable from tilt limiter lever.

TO REINSTALL: (FOR CHAIRS MANUFACTURED BEFORE 8-23-04)

1. Slide replacement tilt limiter cable coupling into slot in tilt limiter lever. Insert spring over cable into cavity of lever. Place pad over spring.



TO REINSTALL:

1. Select appropriate sector gear, one that pivots on post of tilt (older version) or one with integral pivoting post that inserts in tilt (newer version).
2. Insert L-shaped end of replacement tilt limiter cable into keyhole slot

# Aeron® Bumper & Set Screw Replacement

TOOLS REQUIRED: 6MM HEX BIT  
RATCHET WRENCH  
1" PUTTY KNIFE  
#2 PHILLIPS HEAD SCREWDRIVER  
1/4" DRILL BIT  
DRILL MOTOR  
ADJUSTABLE PLIERS  
1/4" ALLEN WRENCH  
TORQUE WRENCH WITH 150 IN-LBS CAPACITY

## PROCEDURE:

### NOTICE

Make sure fasteners are torqued to specified values.

### CAUTION

Support seat link when removing seat link from chair. Failure to comply may cause seat link to fall causing product damage.

1. WITH SEAT LINK SUPPORTED AND USING 6MM HEX BIT AND RATCHET WRENCH, REMOVE AND SAVE FRONT SHOULDER SCREW.

NOTE: IF SPACER IS USED BETWEEN TILT COVER AND SEAT LINK, REMOVE SPACER AND SET ASIDE. IF BUSHINGS USED IN SEAT LINK BECOME DISLODGED, SET ASIDE.

LET SEAT LINK HANG FREE. REPEAT FOR OPPOSITE SIDE. SEE FIGURES 1 & 2.

2. APPLY THUMB PRESSURE ON FRONT OF BOTTOM TILT COVER TO START SEPARATION OF TILT COVERS. INSERT 1" PUTTY KNIFE BETWEEN TOP AND BOTTOM COVERS AND TWIST TO COMPLETELY SEPARATE TILT COVERS. SET TOP TILT COVER ASIDE. SEE FIGURES 4 & 5.
3. USING #2 PHILLIPS HEAD SCREWDRIVER REMOVE AND SET ASIDE (2) SCREWS SECURING BOTTOM TILT COVER TO TILT. REST BOTTOM TILT COVER ON CHAIR BASE. SEE FIGURE 6.

## REPLACING BUMPER

## PROCEDURE:

### NOTICE

Tilt Limiter must be in released position to service. (Tilt limiter lever all the way down).

### CAUTION

Keep drill bit aligned with bumper or drill bit will grab steel edges of rear limit arm.

4. USING 1/4" DRILL BIT AND DRILL MOTOR, DRILL OUT "T" AREA OF BUMPER. STEEL REAR LIMIT ARM WILL ACT AS GUIDE FOR DRILL BIT. SEE FIGURE 7.

5. REMOVE OLD BUMPER AND DISPOSE OF PROPERLY. INSERT PROPERLY ORIENTATED REPLACEMENT BUMPER BY HAND AS FAR AS POSSIBLE. CONTINUE APPLYING PRESSURE USING PAIR OF ADJUSTABLE PLIERS UNTIL BUMPER IS FLUSH WITH REAR LIMIT ARM. SEE FIGURE 8.
6. WITH 1/4" ALLEN WRENCH, REMOVE SET SCREW LOCATED IN FRONT LIMIT ARM AND REPLACE IT WITH REPLACEMENT SET SCREW. SEE FIGURE 9.
7. ADJUST REAR LIMIT ARM SO PROFILE OF BUMPER IS ALIGNED WITH NEUTRAL LOBE OF REAR LIMIT CAM (NEUTRAL LOBE IS DESIGNATED WITH "N" ON SIDE OF REAR LIMIT CAM). ADJUST SET SCREW IN FRONT LIMIT ARM UNTIL PEAK "A" JUST CLEARS BUMPER DURING ROTATION AND PEAK "B" PREVENTS REAR LIMIT CAM FROM TRAVELING TO NEXT LOBE. CHECK ADJUSTMENT BY THRUSTING REAR LIMIT LEVER UP AND DOWN FIRMLY. REAR LIMIT CAM SHOULD MOVE FREELY DURING ROTATION WITHOUT LOCKING UP ON REAR LIMIT ARM. SEE FIGURES 9 & 10.

### CAUTION

Make sure all cables are routed through cable openings on tilt cover before snapping tilt cover in place or product damage may occur.

8. SLIDE BOTTOM TILT COVER UP TO TILT. MAKE SURE NOTCHES IN TILT SPACER GROOVES ENGAGE SLOTS IN TILT COVER. IF NECESSARY, ROTATE TILT SPACERS TO ALIGN NOTCHES WITH SLOTS. ALIGN (2) HOLES IN TILT COVER TO HOLES IN TILT. REINSTALL (2) SCREWS AND TIGHTEN. SEE FIGURE 6.
9. PLACE TOP TILT COVER ON TILT AND ALIGN TO BOTTOM TILT COVER. ROUTE ALL CABLES THROUGH CABLE OPENINGS AND SNAP COVERS TOGETHER. SEE FIGURE 5.

### NOTICE

On older chairs, bushings may become dislodged from seat link while chair is serviced. Check all unattached seat link ends to account for bushings and proper orientation of bushings before attaching to chair.

### NOTICE

On older chairs, hold bushings in seat link while mounting to chair.

10. ALIGN MOUNTING HOLE OF SEAT LINK TO THAT OF TILT AND HAND THREAD FRONT SHOULDER SCREW. IF CHAIR WAS EQUIPPED WITH SPACERS AND BUSHINGS, MAKE SURE ALL BUSHINGS ARE ACCOUNTED FOR AND ORIENTED TO NOTCH IN SEAT LINK BEFORE INSTALLING AND SPACERS ARE INSTALLED BETWEEN SEAT LINKS AND TILT COVER. TORQUE SCREW TO 120-150 IN-LBS. SEE FIGURES 1-3.

180929 REV B

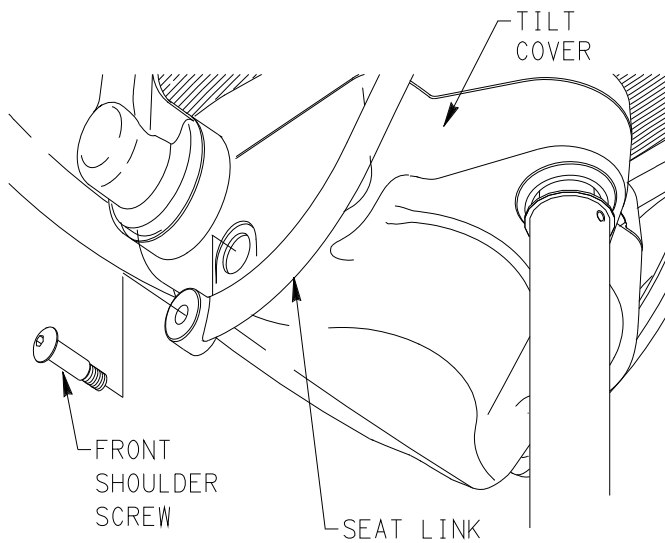


FIGURE 1

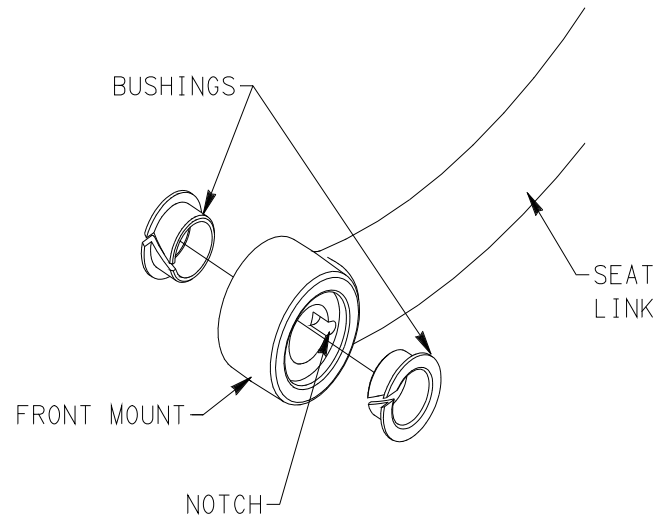


FIGURE 3

(FIGURE SHOWN FOR OLDER CHAIRS)

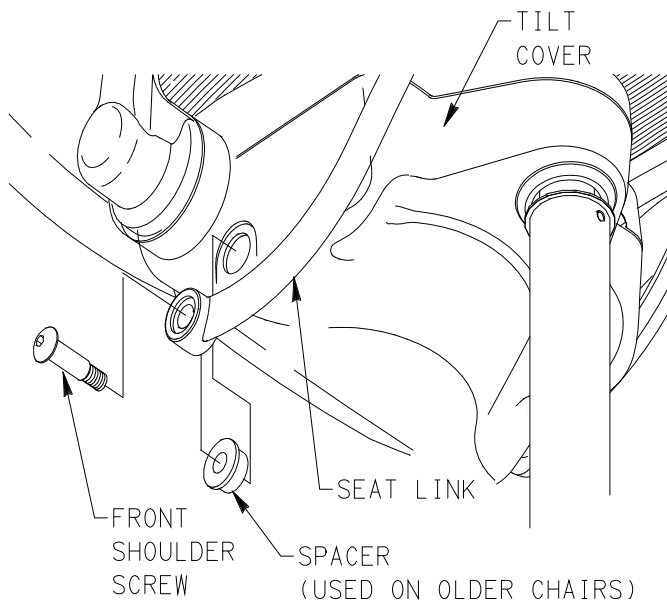


FIGURE 2

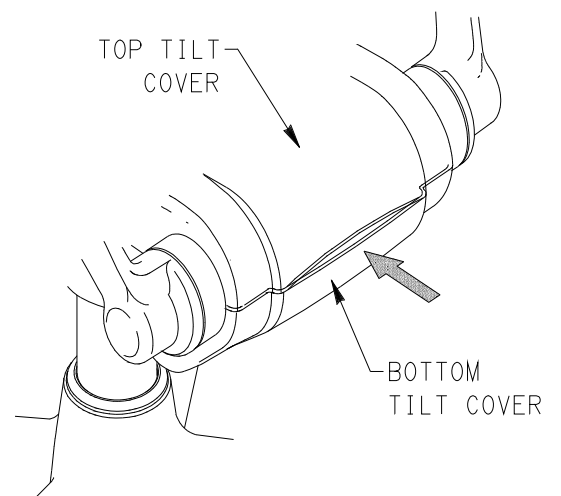


FIGURE 4

(FIGURE SHOWN WITH SEAT FRAME REMOVED)

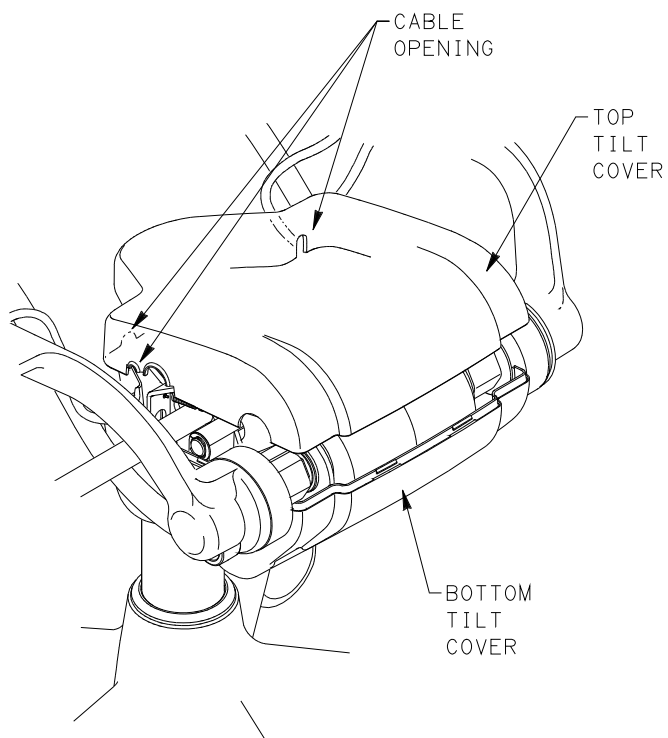


FIGURE 5  
(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

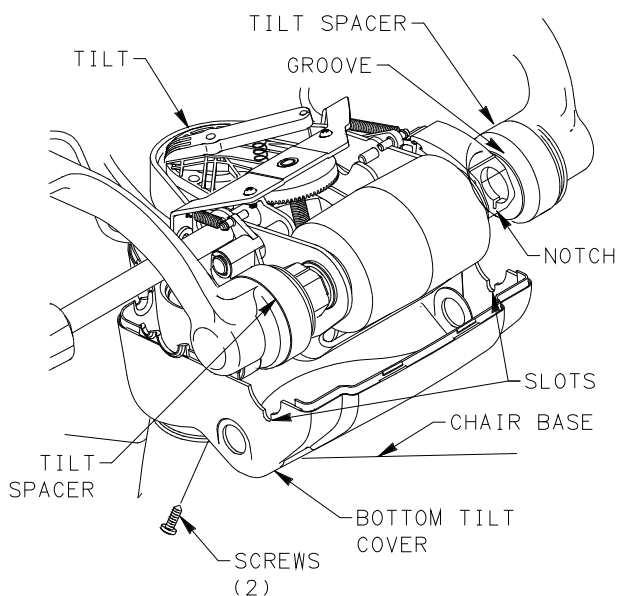


FIGURE 6  
(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

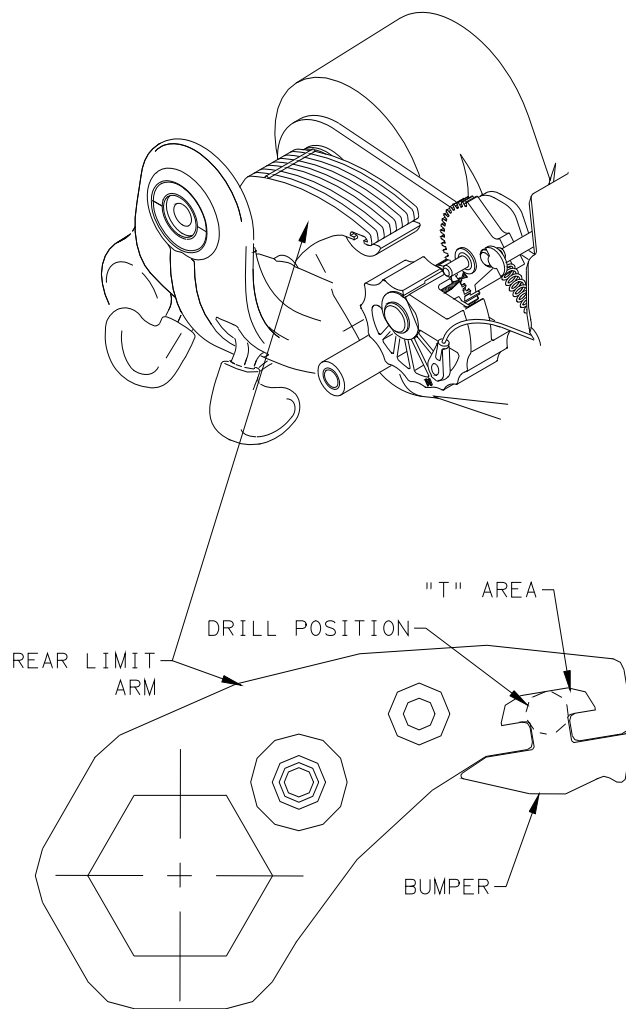


FIGURE 7

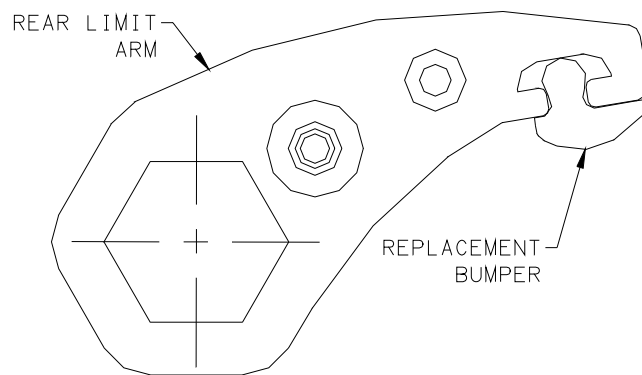


FIGURE 8

180929 REV B



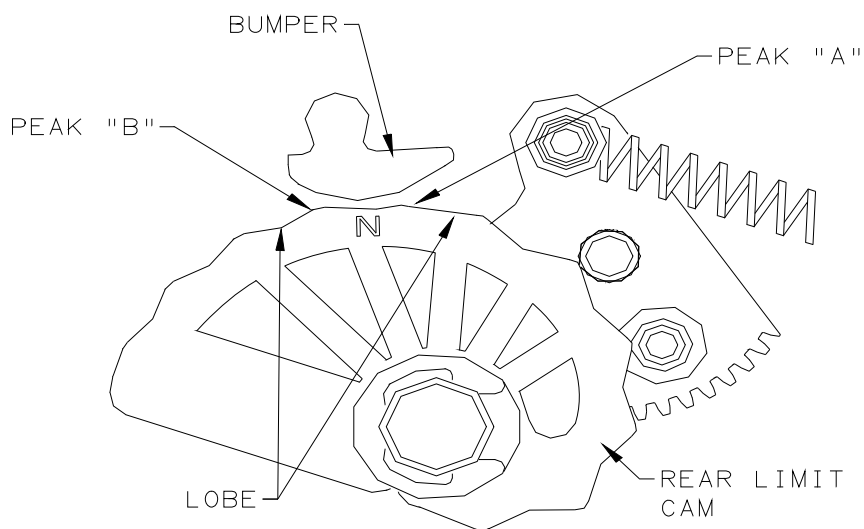


FIGURE 9

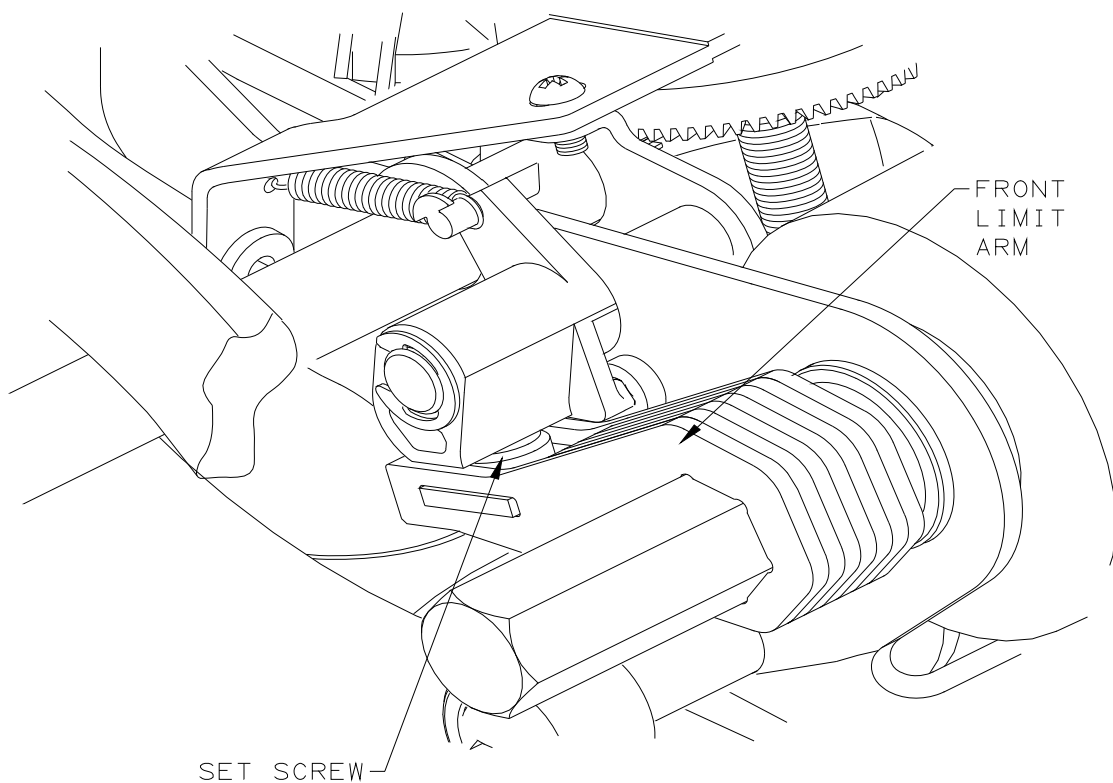


FIGURE 10

# Aeron® Bevel Gear & Tension Shaft Replacement

TOOLS NEEDED: 1" PUTTY KNIFE  
#2 PHILLIPS HEAD STUB SCREWDRIVER OR  
T-20 TORX BIT W/1/4" RATCHET DRIVE  
NEEDLE NOSE PLIERS

## PROCEDURE:

### ⚠ WARNING

Tilt tension must be set to the lowest setting before any servicing begins. Failure to do so may cause personal injury.

1. APPLY THUMB PRESSURE ON FRONT OF BOTTOM TILT COVER TO START SEPARATION OF TILT COVERS. INSERT 1" PUTTY KNIFE BETWEEN TOP AND BOTTOM COVERS AND TWIST TO COMPLETELY SEPARATE HALVES. REMOVE TOP COVER AND SET ASIDE. SEE FIGURES 1 AND 2.
2. IF CHAIR IS EQUIPPED WITH TILT LIMITER, USE FINGER PRESSURE TO REMOVE CABLE FITTING FROM TENSION YOKE ON TILT AND LET HANG. SEE FIGURE 3.
3. IF CHAIR IS EQUIPPED WITH FORWARD TILT OPTION, USE FINGER PRESSURE TO REMOVE CABLE FITTING FROM TENSION YOKE ON TILT AND LET HANG. SEE FIGURE 4.
4. USING #2 PHILLIPS STUB SCREWDRIVER OR T-20 TORX BIT AND 1/4" RATCHET DRIVE, REMOVE (2) SCREWS HOLDING TENSION YOKE TO TILT. SEE FIGURE 5.
5. REMOVE TENSION YOKE FROM TENSION SCREW AND PIVOT TOWARD FRONT OF CHAIR. SEE FIGURE 6.

### NOTICE

If shims were used, make certain all shims are removed from bevel gear (top and bottom) before disposing of gear and shims.

6. REMOVE TENSION SCREW BUSHING, SHIMS (IF USED) AND BEVEL GEAR. MAKE CERTAIN ALL SHIMS ARE REMOVED FROM BEVEL GEAR (TOP AND BOTTOM). PROPERLY DISPOSE OF BEVEL GEAR AND SHIMS (IF USED). SEE FIGURE 6.
7. USING NEEDLE NOSE PLIERS, REMOVE E-RING/SPRING GEAR CLIP FROM TENSION SHAFT AND DISPOSE OF PROPERLY. PULL OUT TENSION SHAFT FROM TILT AND DISPOSE OF PROPERLY. MAKE CERTAIN TENSION SHAFT BUSHINGS REMAIN IN TENSION SHAFT TUBE. SEE FIGURE 7.
8. INSERT REPLACEMENT TENSION SHAFT INTO TENSION SHAFT TUBE. MAKE CERTAIN TENSION SHAFT BUSHING (INSIDE TILT) IS FLUSH AGAINST GUSSET PLATE WHEN TENSION SHAFT IS PROTRUDING THROUGH GUSSET PLATE. SECURE TENSION SHAFT WITH REPLACEMENT SPRING GEAR CLIP. BRUSH ON LUBRICANT (PROVIDED WITH SERVICE KIT), TO PINION GEAR TEETH. SEE FIGURE 7.
9. BRUSH ON LUBRICANT TO BEVEL GEAR TEETH AND PLACE ON TENSION SCREW. SEE FIGURE 6.
10. PLACE TENSION YOKE OVER TENSION SCREW, ALIGNING HOLES IN GUSSET PLATE. INSERT SCREWS AND TIGHTEN. IF CHAIR IS EQUIPPED WITH FORWARD TILT OPTION OR TILT LIMITER, CHECK TO MAKE SURE SPRING(S) HAVE REMAINED SECURE. SEE FIGURE 5.

11. IF CHAIR IS EQUIPPED WITH FORWARD TILT OPTION, USE FINGER PRESSURE TO INSTALL CABLE FITTING INTO TENSION YOKE. SEE FIGURE 4.

12. IF CHAIR IS EQUIPPED WITH TILT LIMITER, USE FINGER PRESSURE TO INSTALL CABLE FITTING INTO TENSION YOKE. SEE FIGURE 3.

### ⚠ CAUTION

Make sure all cables are routed through cable openings on tilt cover before snapping tilt cover in place or product damage may occur.

13. PLACE TILT COVER ON TILT AND ALIGN TO BOTTOM TILT COVER. ROUTE ALL CABLES THROUGH CABLE OPENINGS AND SNAP COVERS TOGETHER. SEE FIGURE 2.

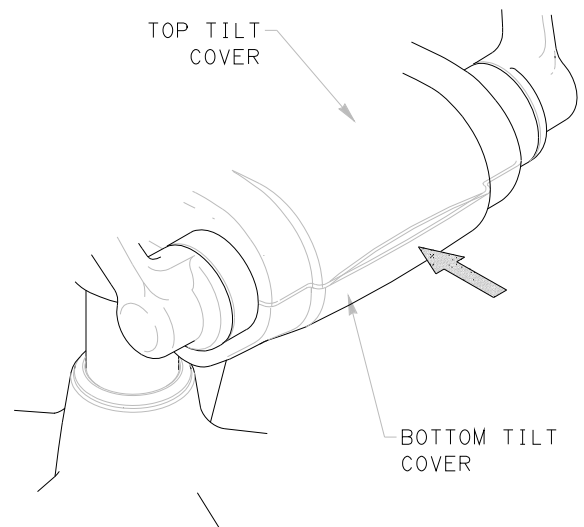


FIGURE 1

174204 REV C

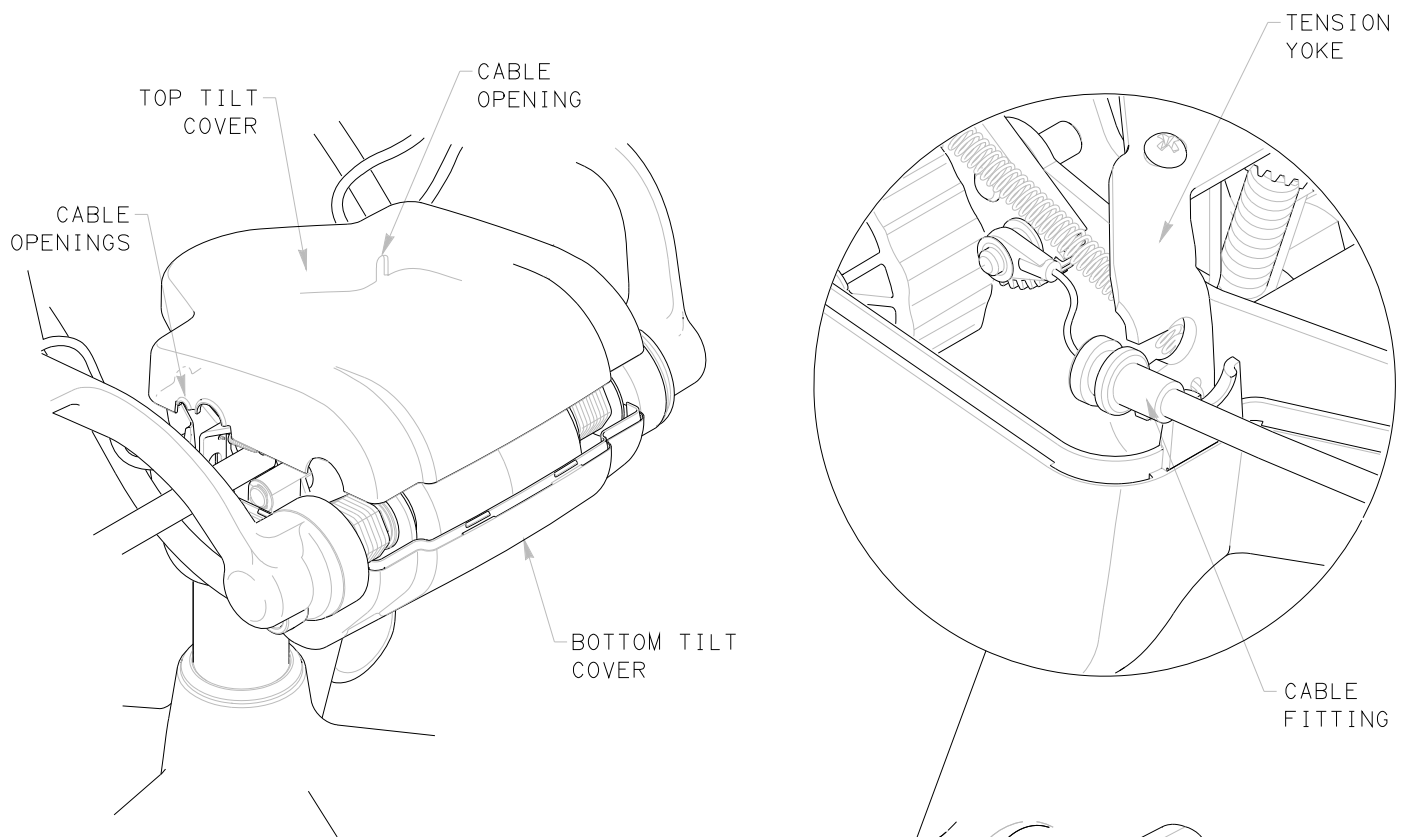


FIGURE 2

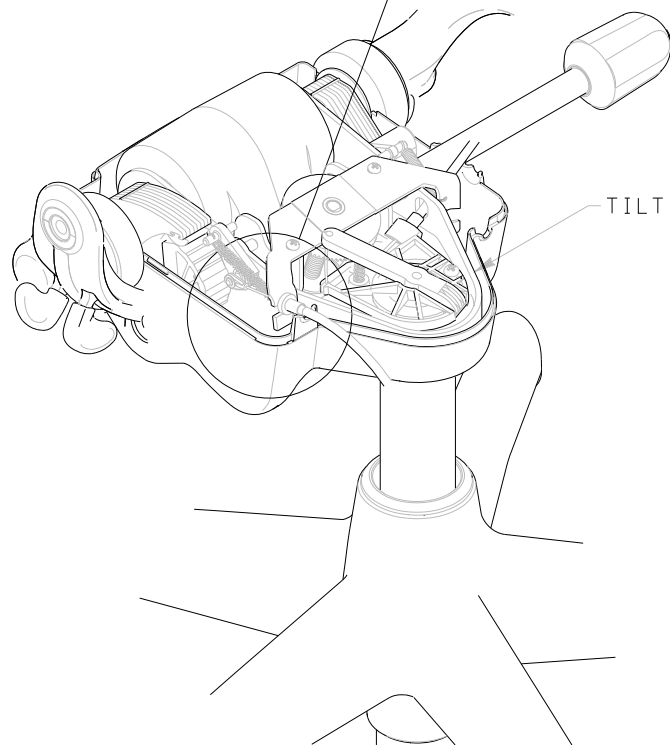


FIGURE 3

(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

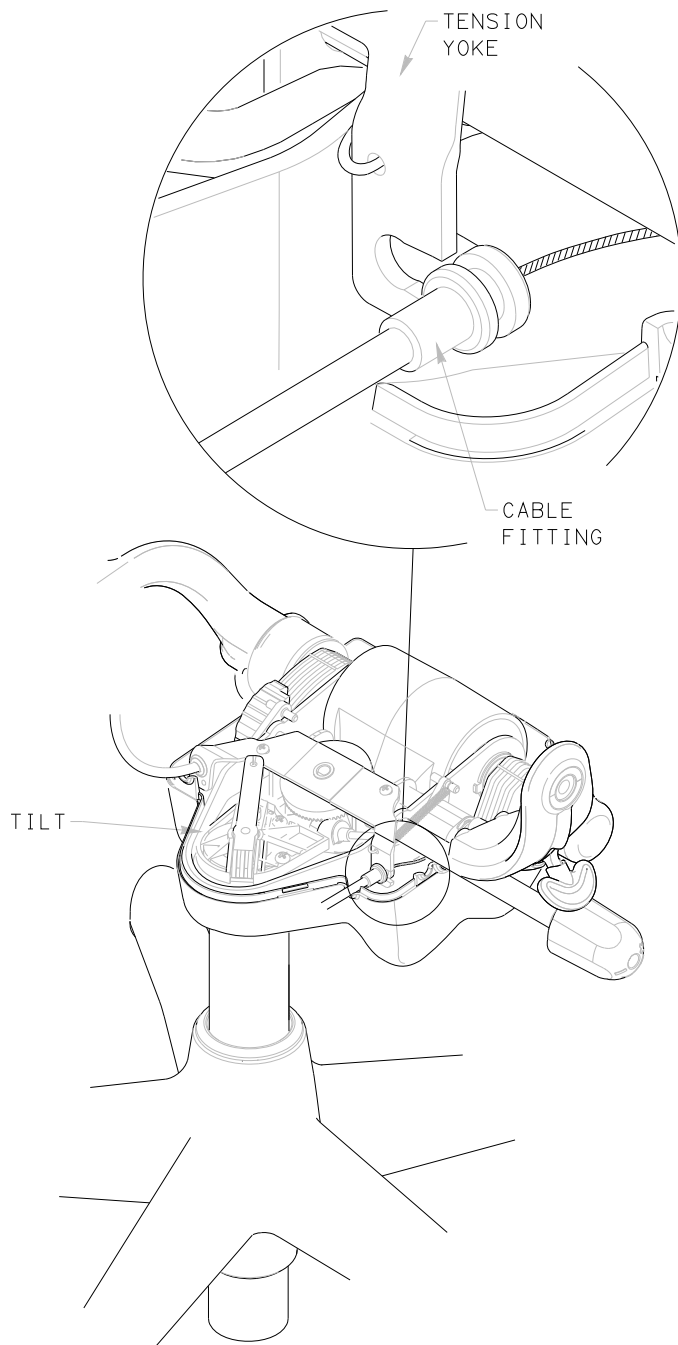


FIGURE 4  
(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

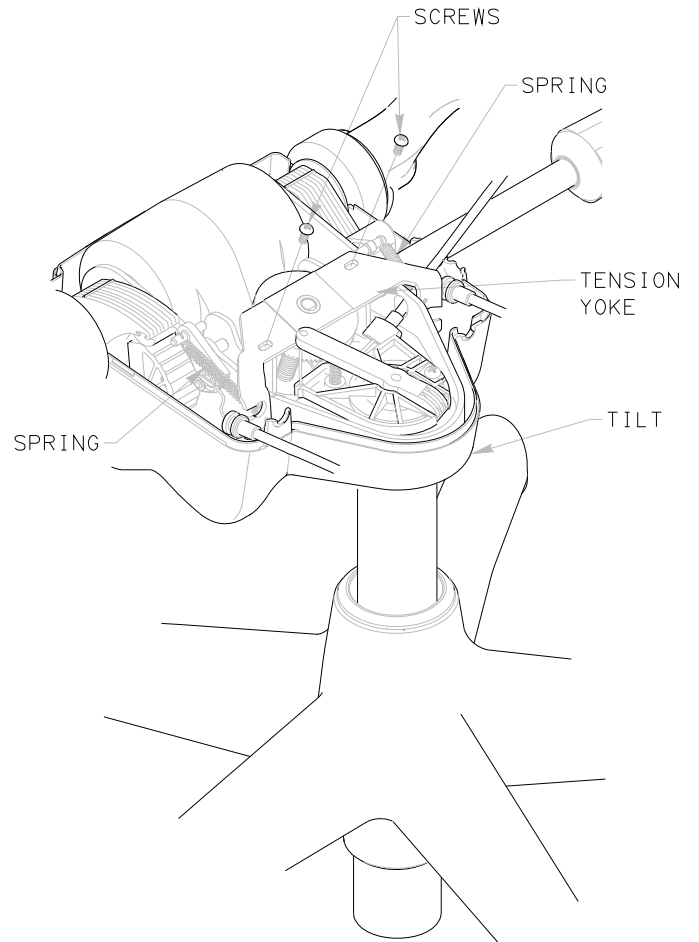


FIGURE 5  
(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

174204 REV C

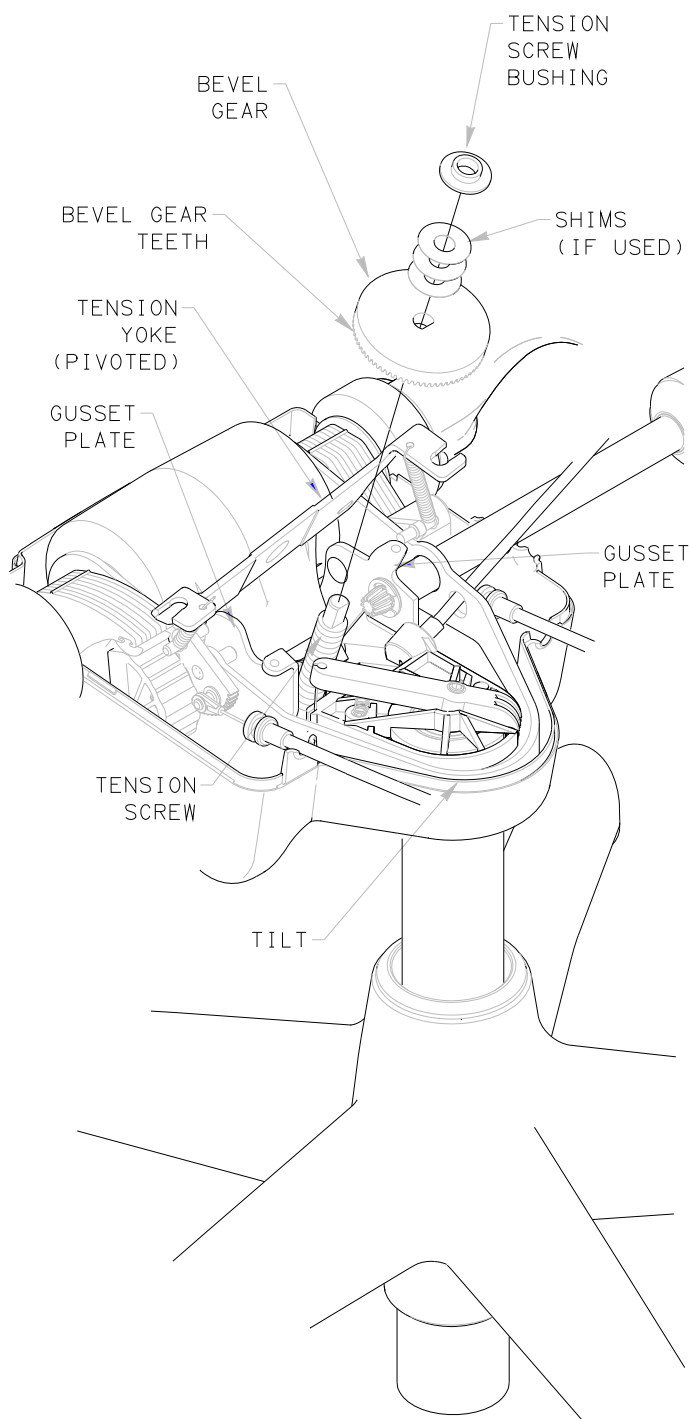


FIGURE 6

(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

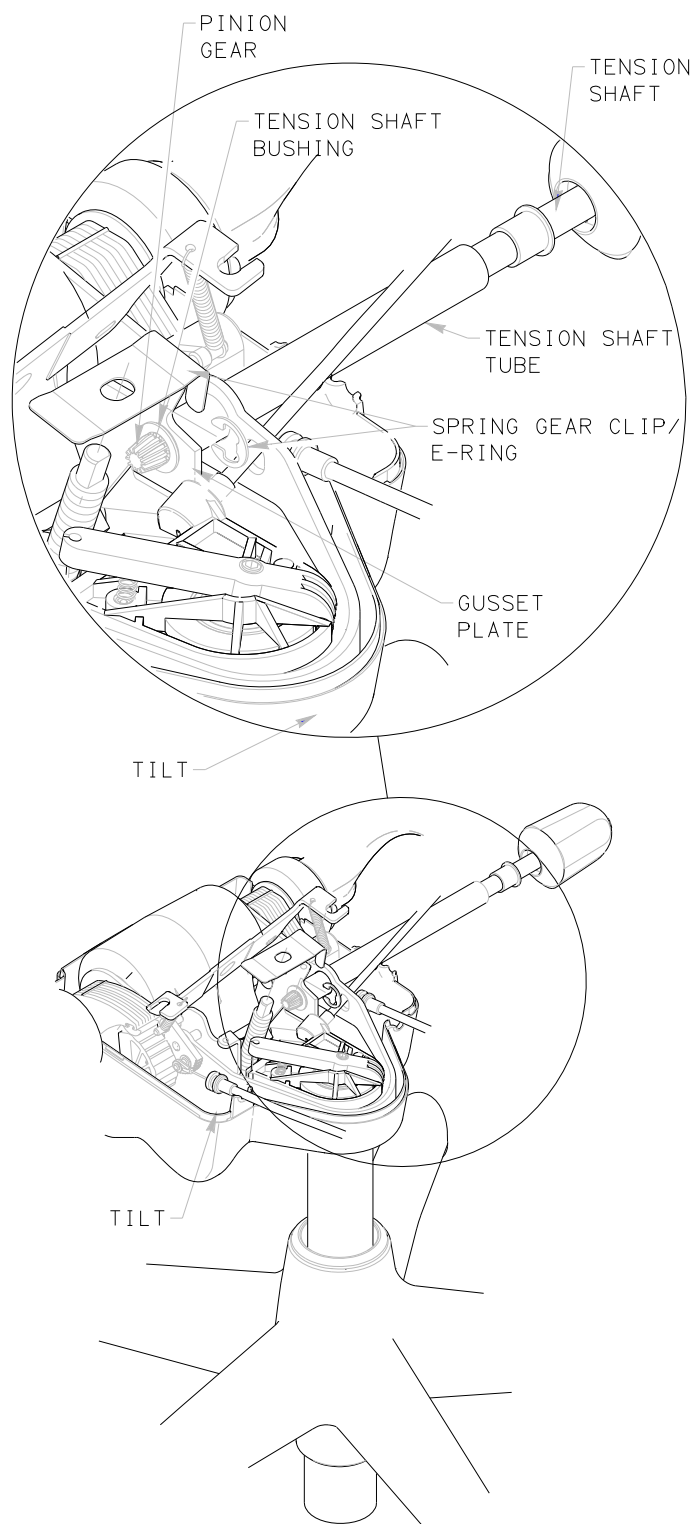


FIGURE 7

(FIGURE SHOWN WITH SEAT  
FRAME REMOVED)

# Aeron® Pneumatic Actuator Replacement (for product before 4-10-02)

TOOLS REQUIRED: 1" PUTTY KNIFE  
#2 PHILLIPS HEAD SCREWDRIVER  
4MM HEX KEY  
PLIERS

PROCEDURE:

## NOTICE

Before servicing chair, set seat height at mid range for pneumatic actuator adjustment during installation.

1. USING THUMB PRESSURE, PRESS FRONT OF BOTTOM TILT COVER TO START SEPARATION OF TILT COVERS. INSERT 1" PUTTY KNIFE BETWEEN COVERS AND TWIST KNIFE TO SEPARATE TOP AND BOTTOM COVERS. REMOVE TOP COVER AND SET ASIDE. SEE FIGURES 1 AND 2.
  2. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND DISCARD (2) SCREWS SECURING PNEUMATIC ACTUATOR TO TILT. SEE FIGURE 3.
  3. DEPRESS LEVER ON PNEUMATIC ACTUATOR AND DISENGAGE CABLE END FROM ACTUATOR LEVER. SEE FIGURE 3.
  4. USING PLIERS, REMOVE CABLE FITTING FROM ACTUATOR AND DISCARD ACTUATOR. SEE FIGURE 3. ACTUATOR. SEE FIGURE 3.
  5. INSTALL REPLACEMENT PNEUMATIC ACTUATOR BY FIRST SNAPPING CABLE FITTING INTO ACTUATOR. SEE FIGURE 3.
  6. DEPRESS ACTUATOR LEVER AND WRAP CABLE, WITH SLEEVE, AROUND TRAVEL GUIDE. INSERT CABLE END INTO SLOT IN ACTUATOR LEVER WHILE POSITIONING SLEEVE INTO TRAVEL GUIDE. PRESS LOWER END OF SLEEVE SECURELY UNDER TAB ON LOWER END OF TRAVEL GUIDE. RELEASE LEVER TO SECURE CABLE END TO LEVER. SEE FIGURE 3.
- NOTE: IF NECESSARY, ADJUST SET SCREW SO THAT IT IS FLUSH WITH UNDERSIDE OF ACTUATOR LEVER, BEFORE INSTALLING ACTUATOR. SEE FIGURE 4.
7. ATTACH PNEUMATIC ACTUATOR TO TILT WITH (2) SCREWS (PROVIDED). TIGHTEN SCREWS. SEE FIGURE 3.
  8. USING 4 MM HEX KEY, ROTATE SET SCREW SLOWLY CLOCKWISE UNTIL PNEUMATIC CYLINDER (AT MID RANGE POSITION) ACTIVATES, THEN ROTATE SET SCREW COUNTERCLOCKWISE 1 1/4 TURN. SEE FIGURE 4.

## NOTICE

Check to ensure all cables are routed through cable openings before assembling tilt cover halves. Failure to comply may cause product damage.

9. REPOSITION TOP TILT COVER OVER BOTTOM TILT COVER, MAKING SURE ALL CABLES ARE PROPERLY ROUTED THROUGH CABLE OPENINGS. SNAP COVER HALVES TOGETHER. SEE FIGURES 1 AND 2.

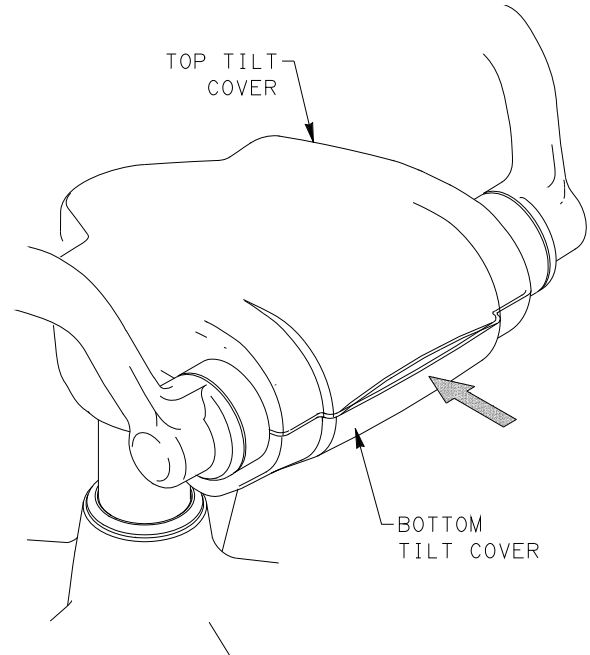


FIGURE 1

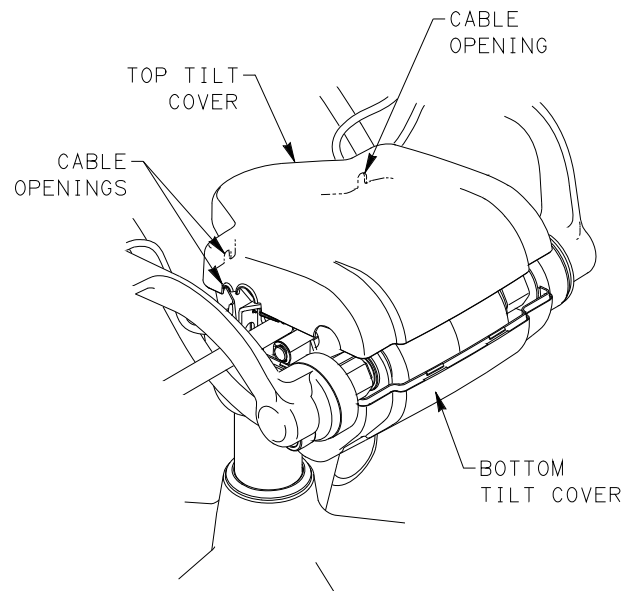


FIGURE 2

170197 REV B

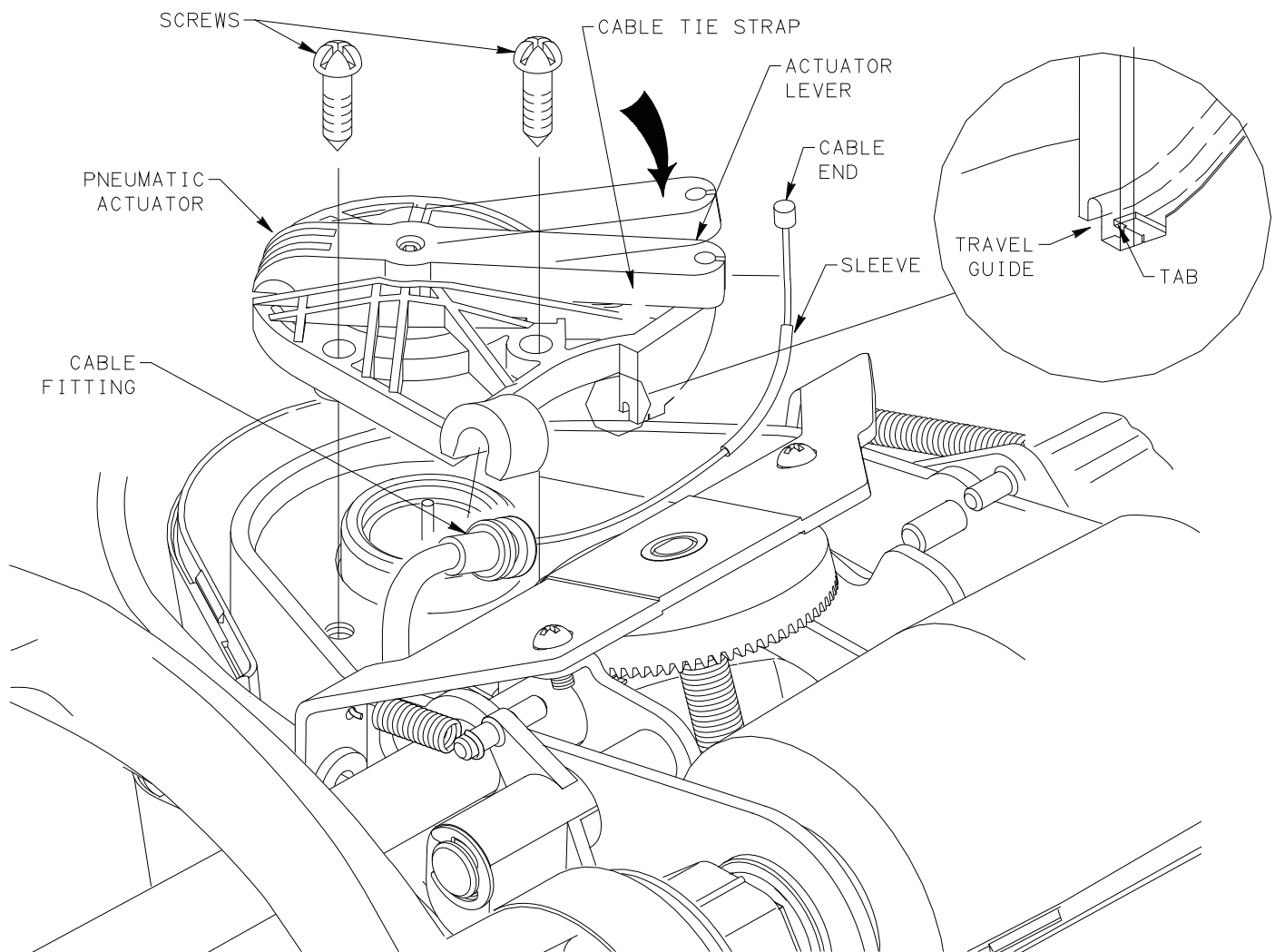


FIGURE 3

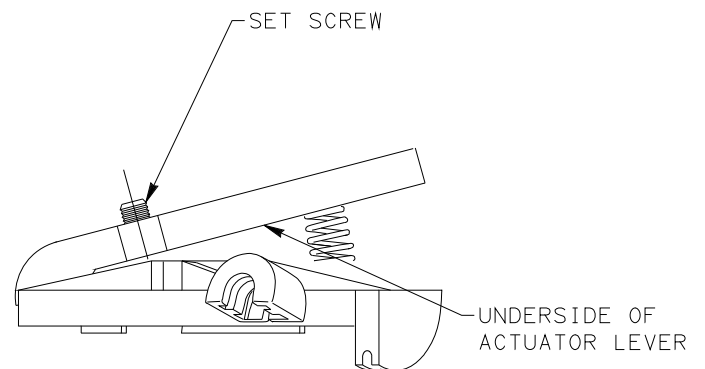


FIGURE 4

# Aeron® Pneumatic Knob and Lever Replacement (for product before 4-10-02)

TOOLS REQUIRED: PLIERS  
#2 PHILLIPS HEAD SCREWDRIVER

## PROCEDURE:

1. USING PLIERS, TWIST OFF PNEUMATIC KNOB FROM LEVER OF PNEUMATIC CONTROL. PROPERLY DISPOSE OF PNEUMATIC KNOB. SEE FIGURE 1.
2. USING #2 PHILLIPS HEAD SCREWDRIVER, REMOVE AND SAVE (2) SCREWS SECURING PNEUMATIC CONTROL AND COVER TO SWING ARM. SET ASIDE COVER. SEE FIGURE 2.
3. REMOVE PNEUMATIC CONTROL FROM SWING ARM AND UNSNAP COVER HALVES FROM LEVER. SEE FIGURES 2 & 3.
4. PIVOT LEVER BACK TOWARD CABLE COUPLER UNTIL CABLE LINES UP WITH SLOT IN LEVER AND SLIDE LEVER OFF FROM CABLE. SEE FIGURE 4.
5. PIVOT REPLACEMENT LEVER TO LINE UP SLOT IN LEVER WITH CABLE AND SLIDE TOGETHER. SEE FIGURE 4.
6. INSTALL CABLE COUPLER INTO MATING CAVITY ON HALF OF COVER. INSERT LEVER INTO SAME HALF OF COVER. ATTACH OTHER COVER HALF TO EXISTING ASSEMBLY. SEE FIGURE 3.

## NOTICE

For ease of assembly, keep pneumatic control placed in swing arm with hand pressure until cover is in place and secure.

7. INSTALL PNEUMATIC CONTROL TO SWING ARM. WHILE KEEPING HAND PRESSURE ON PNEUMATIC CONTROL, INSTALL COVER AND SECURE WITH (2) SCREWS. SEE FIGURE 2.
8. PUSH REPLACEMENT PNEUMATIC KNOB ONTO LEVER OF PNEUMATIC CONTROL UNTIL A "CLICK" IS HEARD, INDICATING THE KNOB HAS LOCKED IN PLACE. SEE FIGURE 5.

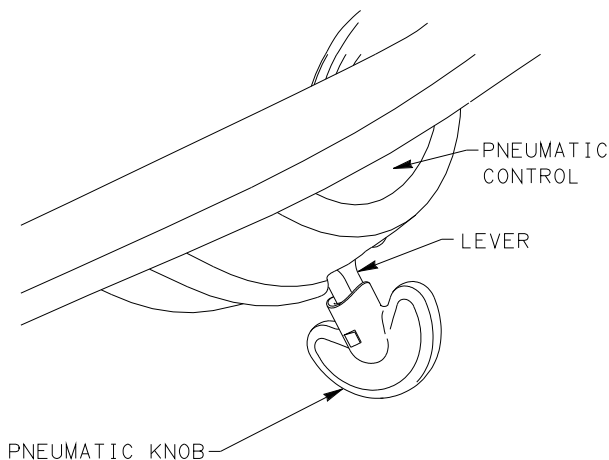


FIGURE 1

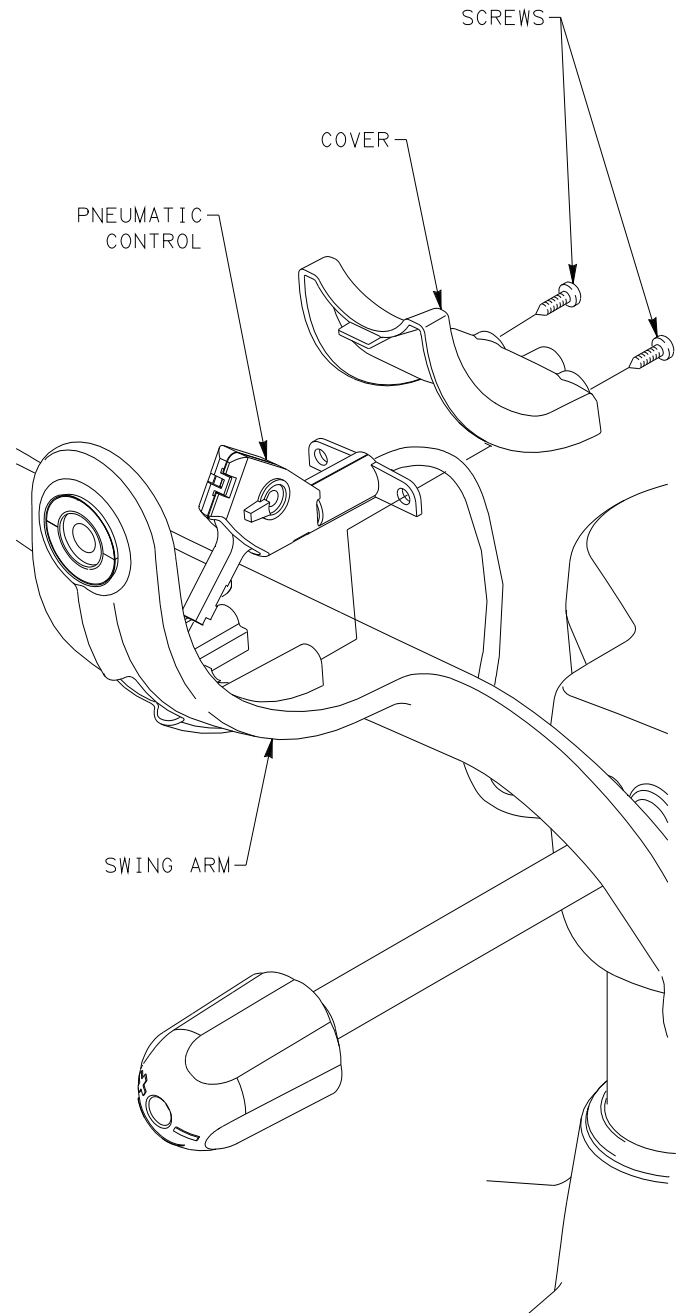


FIGURE 2

(SEAT FRAME NOT SHOWN FOR CLARITY)

173221 REV C



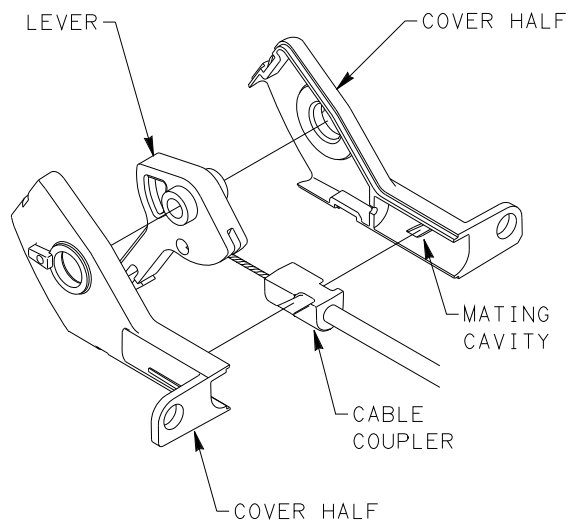


FIGURE 3

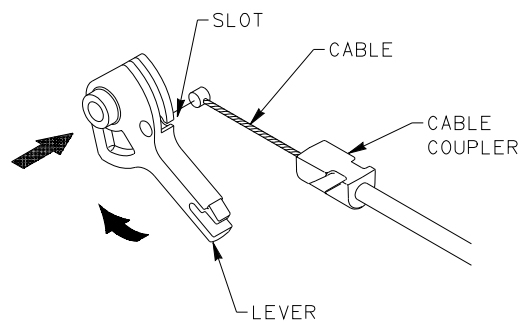


FIGURE 4

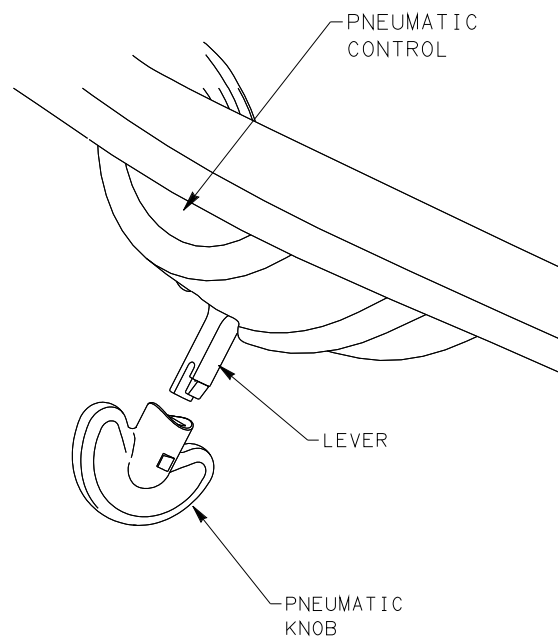
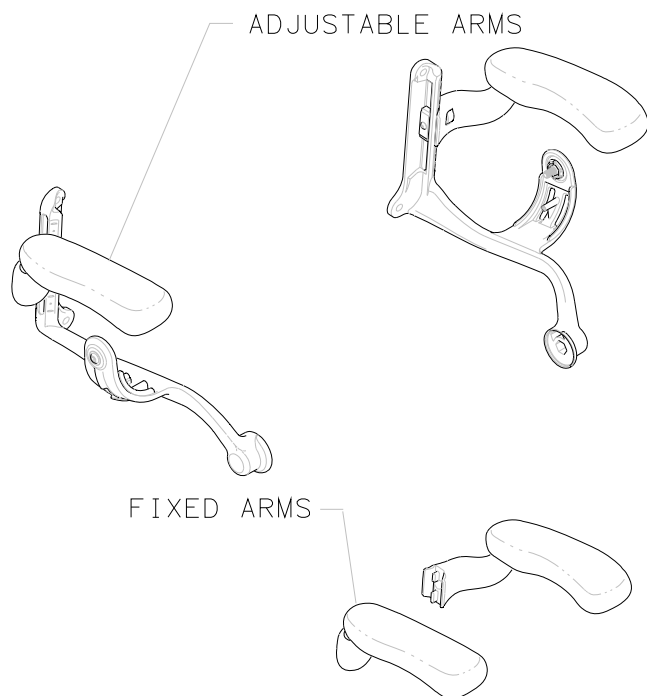


FIGURE 5

173221 REV C

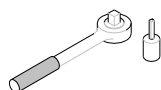
# Aeron® Arm Option Conversion



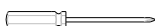
## TOOLS NEEDED



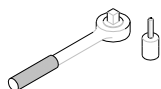
1" PUTTY KNIFE



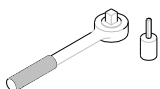
RATCHET WRENCH W/  
6MM HEX HEAD BIT



PHILLIPS HEAD  
SCREWDRIVER



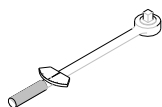
RATCHET WRENCH W/  
T-27 HEX HEAD BIT



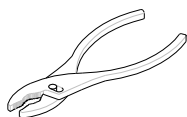
RATCHET WRENCH W/  
5MM HEX HEAD BIT



4MM HEX KEY



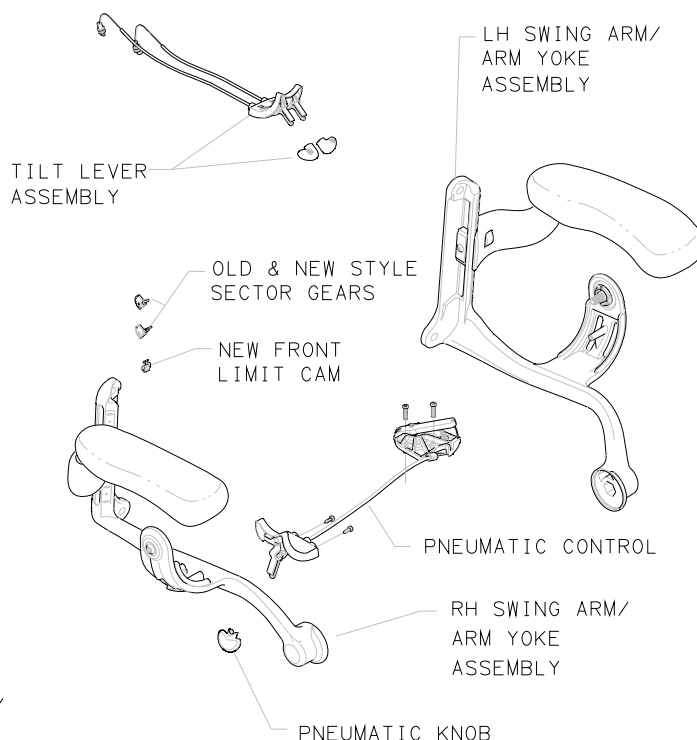
TORQUE WRENCH



PLIERS

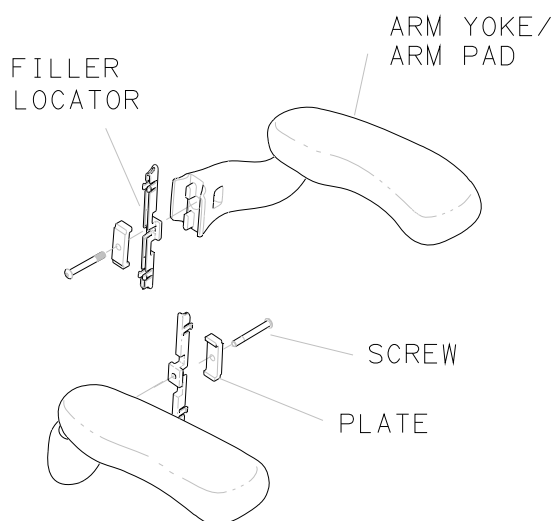
## PARTS INCLUDED

### ADJUSTABLE ARMS



## PARTS INCLUDED

### FIXED ARMS



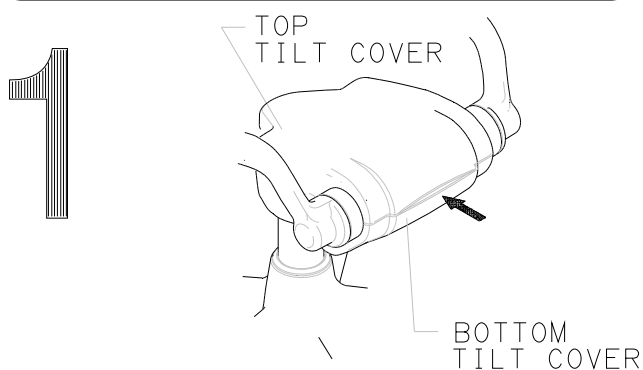
167225 REV H

## PROCEDURE

The following procedures are for installing adjustable arms. To install Fixed Arms, to a no arm chair, go on to steps 5 - 7 & 19.

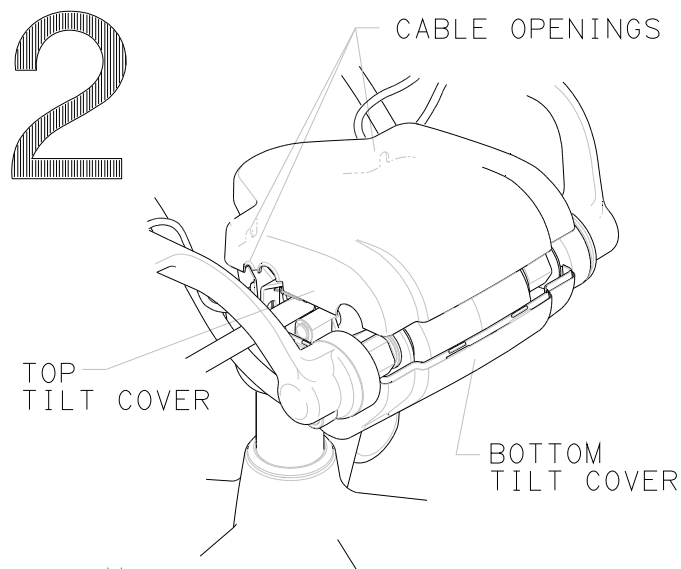
### NOTICE

TILT LIMITER MUST BE IN RELEASED POSITION TO SERVICE. (TILT LIMITER LEVER ALL THE WAY DOWN).



TO REMOVE :

1. Using thumb pressure, press front of bottom tilt cover to start separation of tilt covers.

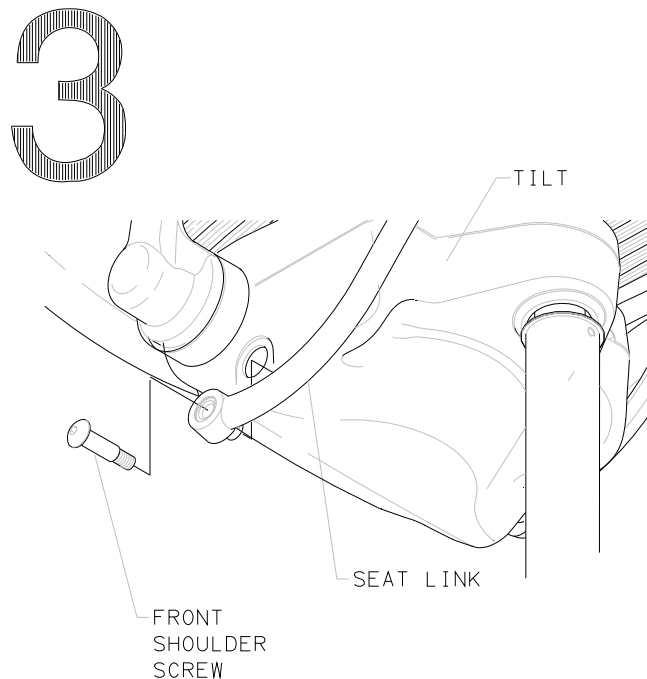


TO REMOVE :

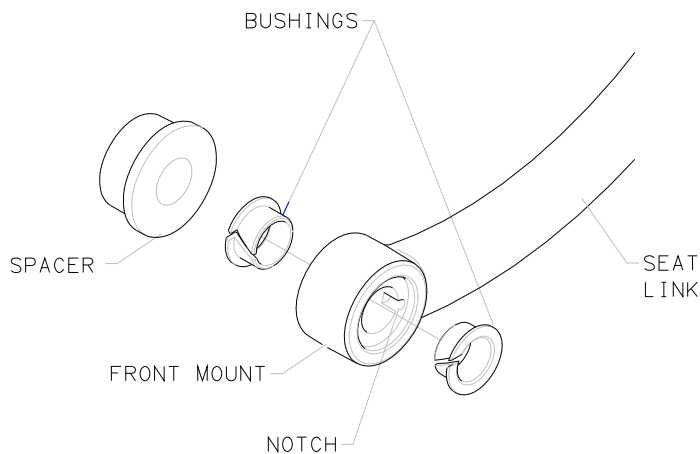
1. Insert 1" putty knife between covers and twist to separate top from bottom cover. Remove top cover and set aside.

TO REINSTALL :

1. Reposition top tilt cover over bottom tilt cover, making sure all cables are properly routed through cable openings. Snap cover halves together.



(OLDER VERSION)



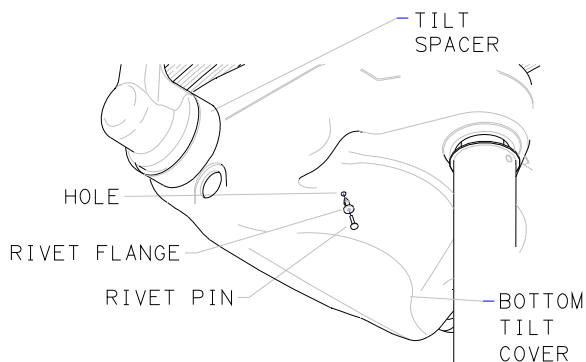
TO REMOVE :

1. While supporting seat link, use 6MM hex bit and ratchet wrench to remove front shoulder screw attaching seat link to tilt. Set aside shoulder screw. Let seat link hang. Remove spacers and or bushings if applicable and set aside. Repeat for opposite side.

TO REINSTALL :

1. Attach front mount of seat link to tilt with shoulder screw. Tighten and torque to 120-150 in-lbs.

# 4



## TO REMOVE :

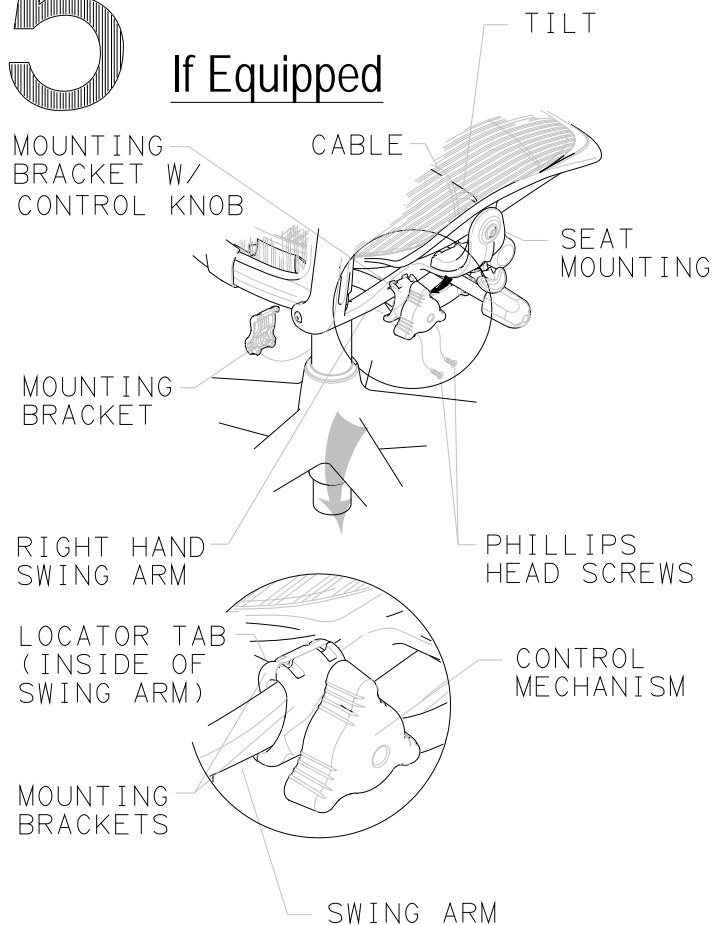
1. Using needle nose pliers, remove plastic pin from rivet flange. Pull tilt cover from tilt.

## TO REINSTALL :

1. Slide bottom tilt cover up to tilt. Make sure notches in tilt spacer grooves engage slots in tilt cover. If necessary, rotate tilt spacers to align notches with slots. Align hole in tilt cover to hole in tilt. Install rivet flange into tiltcover and tilt. Insert rivet pin into rivet flange.

# 5

## If Equipped



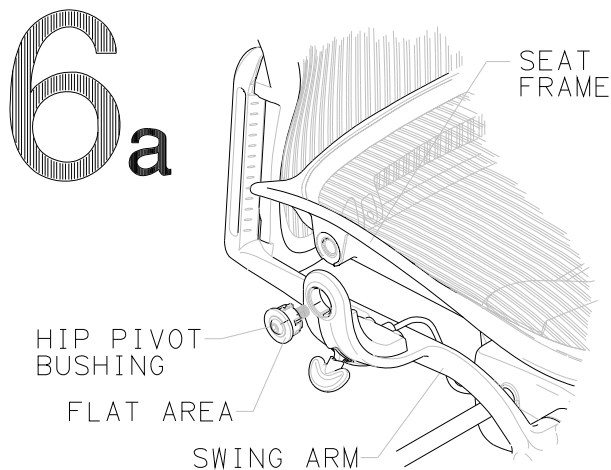
## TO REMOVE :

1. Using #2 phillips head screwdriver, remove and set aside screws fastening mounting bracket to right hand swing arm. Remove control mechanism from swing arm and let hang.

## TO REINSTALL :

1. Place control mechanism mounting halves over locator tab (on inside of swing arm). Hook back half onto front half over locator tab and secure with screws using #2 phillips head screwdriver.
2. Route cable from back of chair over tilt, looping back under right hand swing arm.

167225 REV H



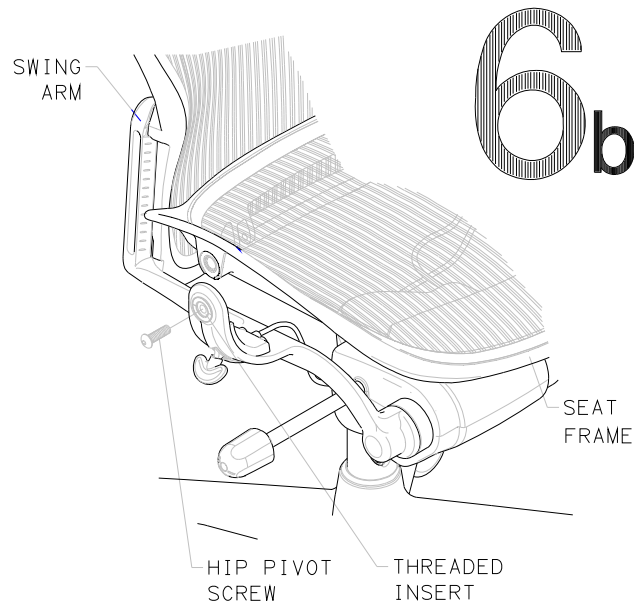
(FOR CHAIRS MANUFACTURED AFTER JUNE 4, 2003)

#### TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot bushing assembly from swing arm. Loosening pivot fastener will force hip pivot bushing assembly from swing arm. After hip pivot fastener has disengaged from seat frame, remove hip pivot bushing and set aside. Repeat for other side. Remove seat frame with b-links and set aside.

#### TO REINSTALL :

1. Make certain flat area around fasteners head in hip pivot bushing is flat and aligned with bushing area. Repeat for other hip pivot bushing.
2. Lower seat in place. Align fastener in seat frame to mounting hole in swing arm and insert hip pivot bushing.
3. Insert other hip pivot fastener into swing arm aligning top and bottom guides into slots in swing arm opening.
4. Using 6MM head bit and ratchet wrench, partially thread hip pivot fastener into seat frame. Repeat for opposite side.
5. Secure fasteners of hip pivot bushing, drawing hip pivot bushing into seat frame. Torque fasteners to 180-200 lbs.



(FOR CHAIRS MANUFACTURED BEFORE JUNE 4, 2003)

#### TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot screw from each swing arm. If threaded insert turns with hip pivot screw, **STOP** immediately and do the following step: Tighten hip pivot screw into threaded insert as much as possible. Using a quick jerking motion with ratchet wrench. Back out hip pivot screw from threaded insert. If threaded insert turns with hip pivot screw, repeat process.

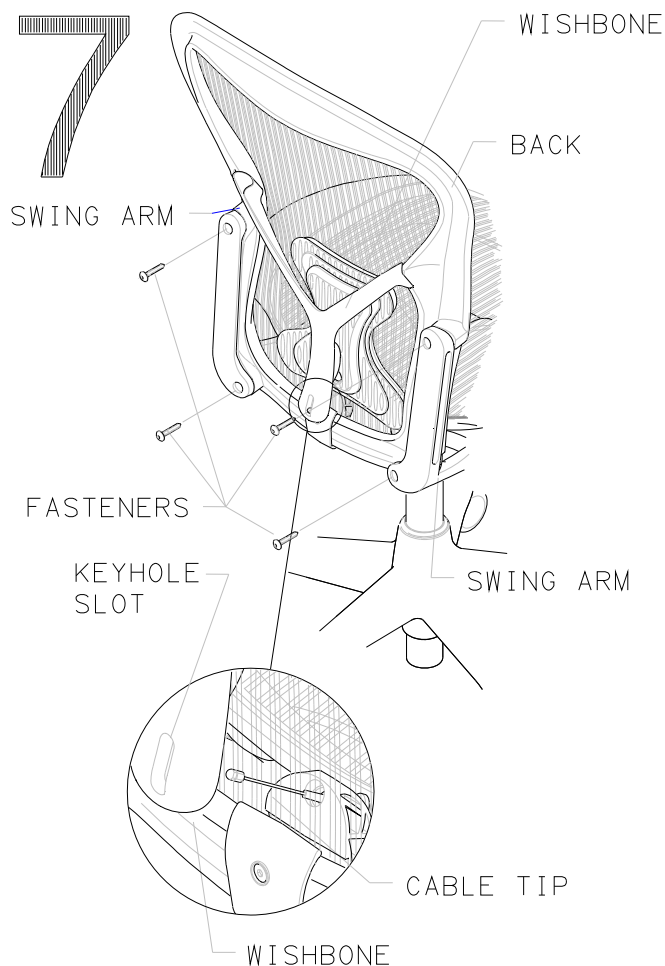


#### CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame, **STOP IMMEDIATELY** and follow instructions.

#### TO REINSTALL :

1. Place seat frame between swing arms. Attach seat frame to swing arms with hip pivot screws. Tighten and torque to 180-200 in lbs.



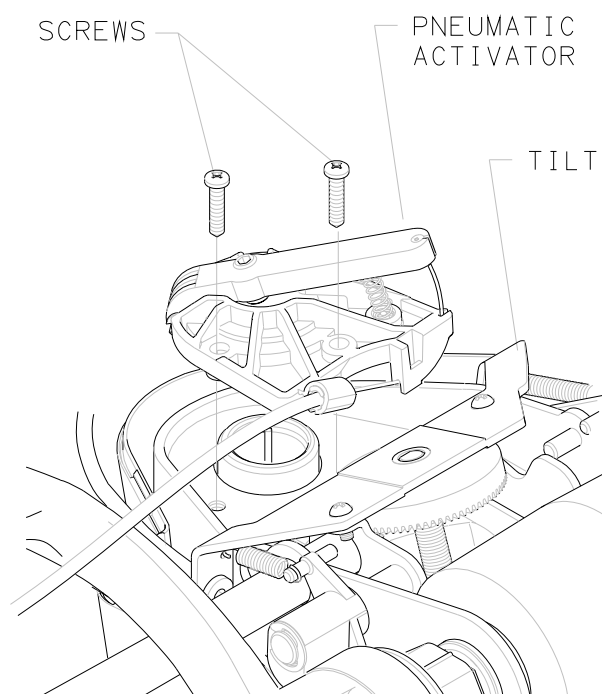
#### TO REMOVE :

1. Using ratchet wrench and 5MM hex bit, remove and set aside fasteners from right and left side of back. Remove and set aside back and attached control mechanism (if equipped).

#### TO REINSTALL :

1. Using ratchet wrench and 5MM hex bit, secure back to swing arm. Torque fasteners to 70-100 in lbs.
2. Note: Cable may become disconnected. To reattach after back is attached, press base of wishbone and place cable top in wishbone keyslot.

8



#### TO REMOVE :

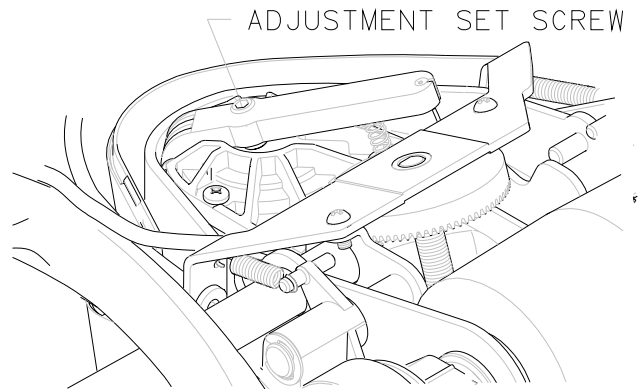
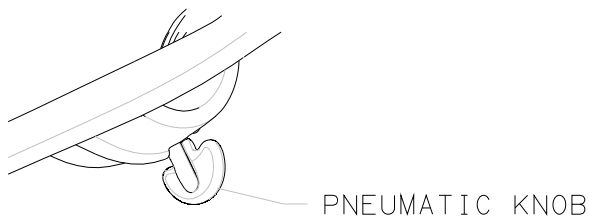
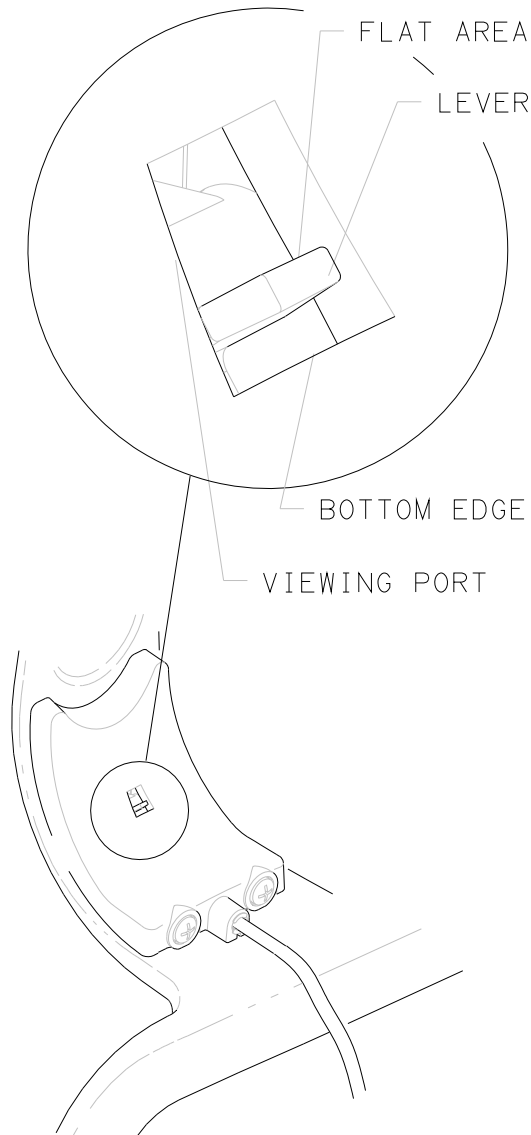
1. Using #2 phillips head screwdriver, remove and discard (2) screws securing pneumatic actuator to tilt.

#### TO REINSTALL :

1. Place pneumatic activator on top of tilt. Secure with screws provided using #2 phillips head screwdriver.

167225 REV H

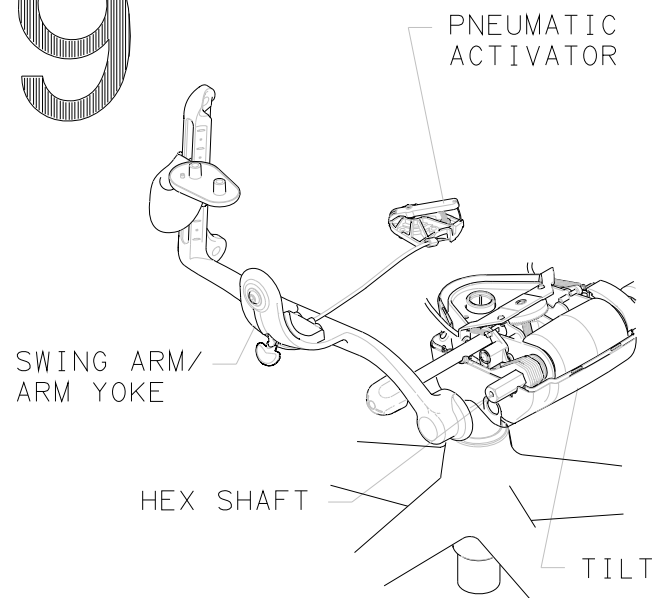
TO ADJUST ACTIVATION:



TO ADJUST ACTIVATION:

1. Check pneumatic activator function by activating lever slightly to monitor lever through viewing port on pneumatic control end. When flat area of lever is even with bottom edge of viewing port, adjustment set screw on pneumatic activator should be resting on pin of pneumatic cylinder, not yet activated. Adjust set screw using 4MM hex key until this is achieved.

9



TO REMOVE :

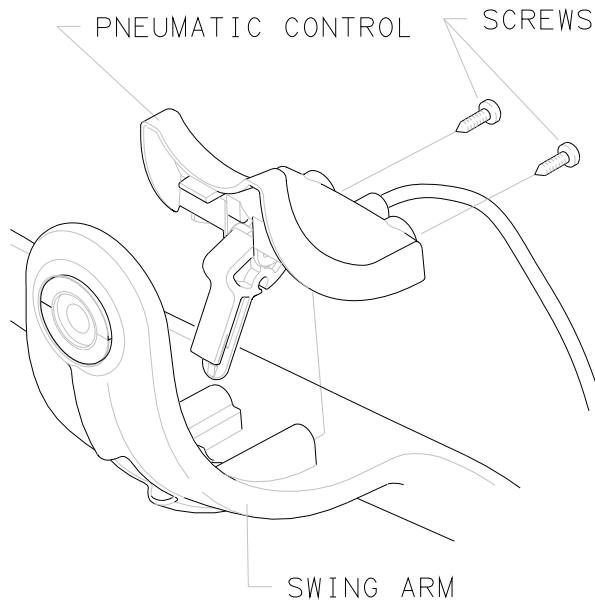
1. Slide right hand swing arm / arm yoke from hex shaft on tilt. Properly dispose of swing arm / arm yoke/pneumatic control.

TO REINSTALL :

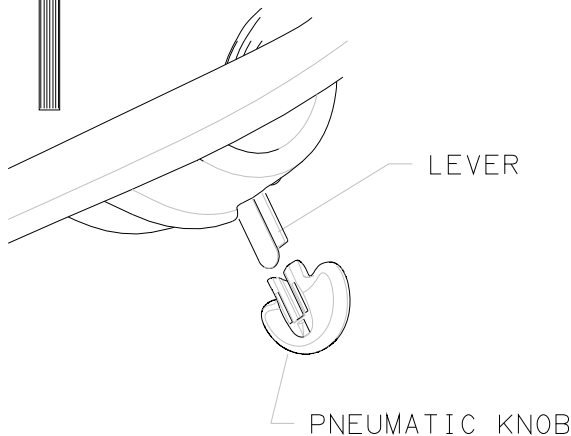
1. Slide replacement swing arm/arm yoke on to tilt hex shaft.
2. Refer to reinstallation of step 8 to attach pneumatic activator.

# 10

TO INSTALL PNEUMATIC CONTROL:



# 11

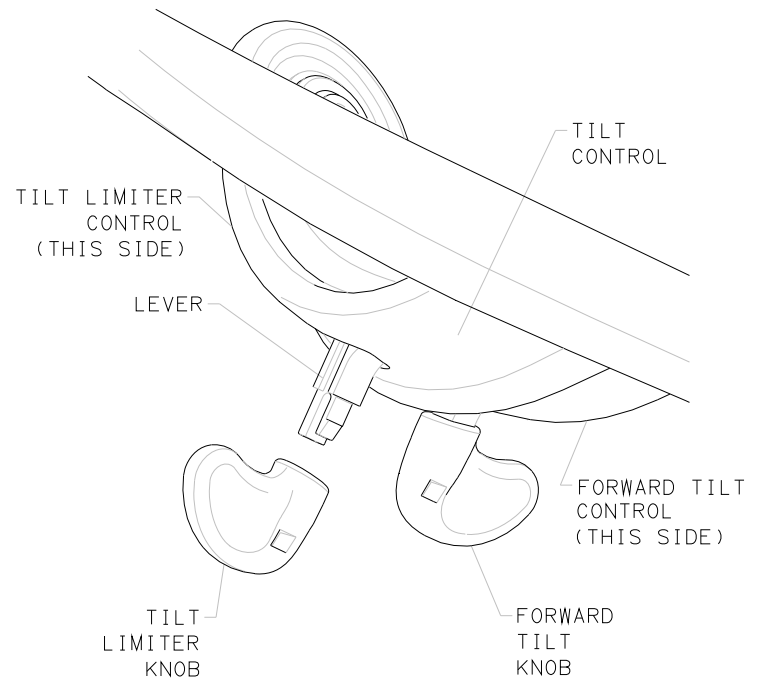


TO INSTALL PNEUMATIC CONTROL:

1. Insert pneumatic control end into swing arm. Secure with (2) screws provided using #2 phillips head screwdriver.
2. Insert new knob on lever. Push until it snaps into place.

# 12 a

FOR CHAIRS MANUFACTURED BEFORE 8-23-2004



TO REMOVE :

1. Using pliers, cut above knob(s) to separate knob from lever. Properly dispose of knob/s.

167225 REV H



# 12<sub>b</sub>

FOR CHAIRS MANUFACTURED AFTER 8-23-04

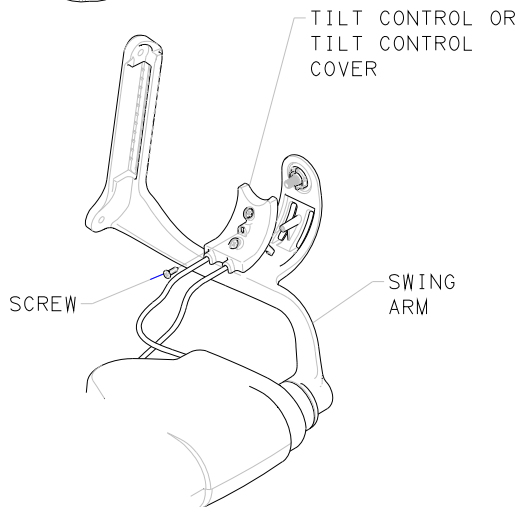
## TO REMOVE :

1. Using hands, pull knob/s from control lever/s. Properly dispose of knobs.

## TO REINSTALL :

1. Push on appropriate replacement knob/s until they click into place.

# 13<sub>a</sub>



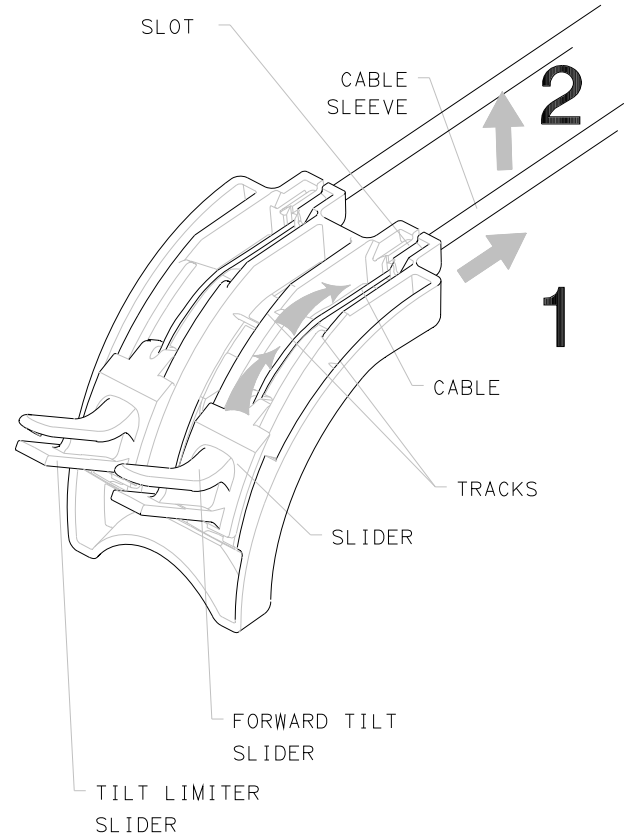
## TO REMOVE :

1. Using #2 phillips head screwdriver, remove and set aside fastener securing tilt control to swing arm. (Keep this screw isolated).

## TO REINSTALL :

1. Place tilt control on swing arm and secure with isolated screw using #2 phillips head screwdriver.

# 13<sub>b</sub>

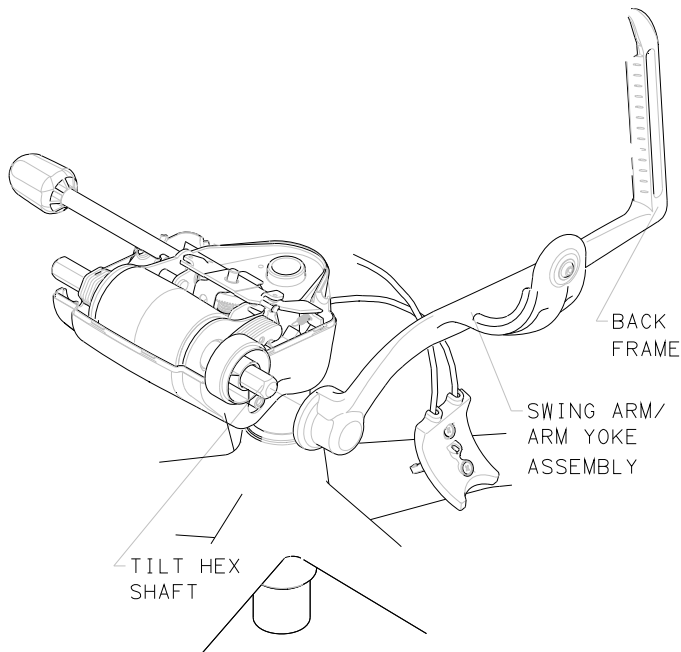


## MODIFYING TILT CONTROL :

Modify tilt control to accommodate chair options. If chair is fully optioned, no action is required. If chair is only equipped with tilt limiter, remove forward tilt cable and lever. If tilt was equipped with no options, remove both levers and cables.

1. Pull cable sleeve out from control housing, followed by pulling cable through slot.
2. Slide slider to open end of track and out. Properly dispose of slider and cable.

# 14



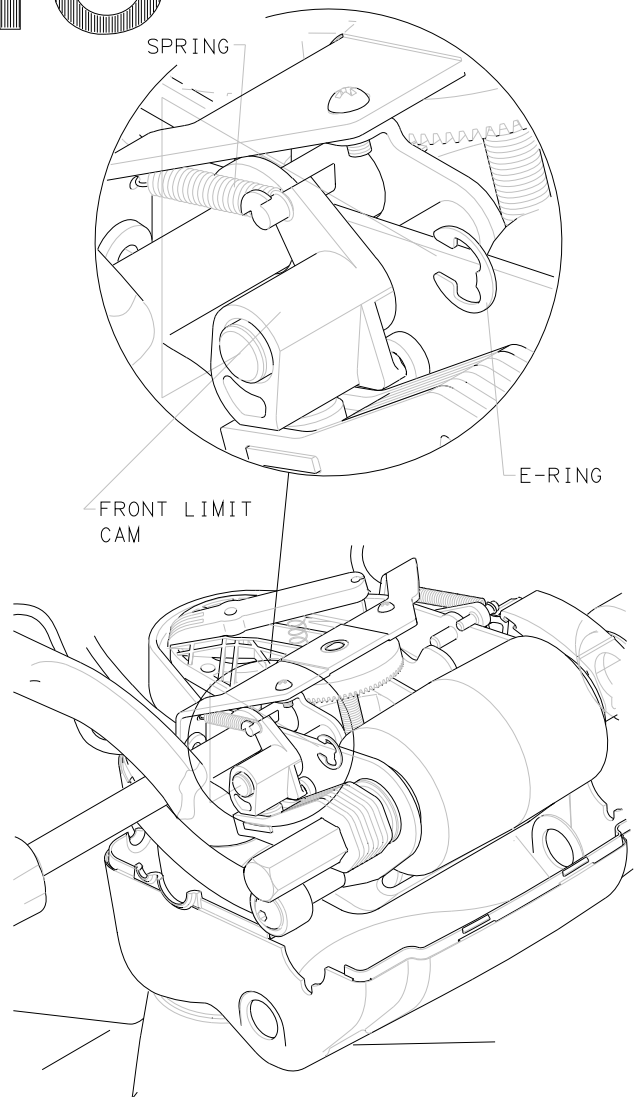
## TO REMOVE :

1. Slide left hand swing arm/arm yoke assembly off from tilt hex shaft.

## TO REINSTALL :

1. Slide on replacement swing arm/arm yoke assembly to tilt hex shaft.

# 15



(FIGURE SHOWN WITH SEAT FRAME  
REMOVED FROM PRE 3-9-04 CHAIR)

## TO REMOVE :

1. Using needle nose pliers, disengage spring from front limit cam. Using small straight head screwdriver remove E-ring holding front limit cam in place.

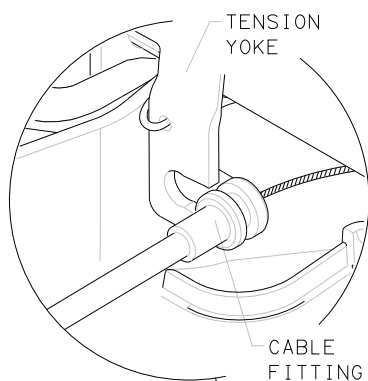
## TO REINSTALL :

1. Secure front limit cam with E-ring. Attach spring to front limit cam.

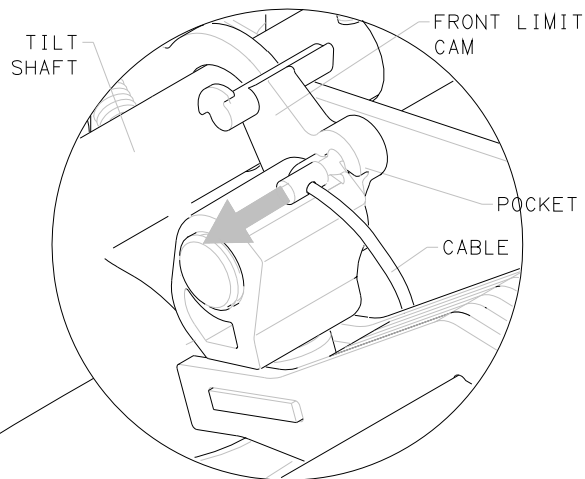
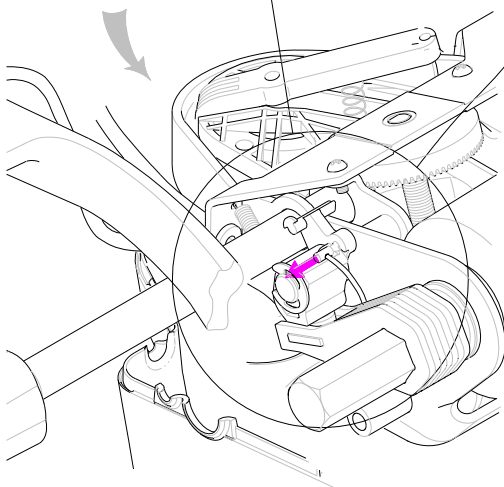
167225 REV H

# 16 b

(FOR CHAIRS MADE AFTER 3-9-04)



**View A**



## TO REMOVE :

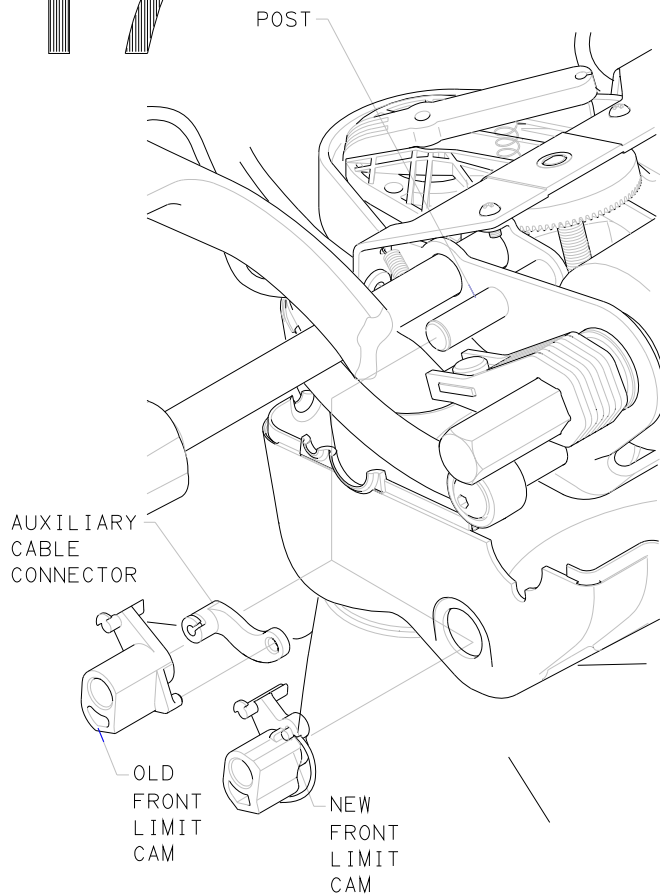
1. Use thumb pressure to remove forward tilt cable fitting (RH side) from tension yoke on tilt. Move cable forward to provide slack. Using needle nose pliers, slide cable from pocket in front limit cam.

## TO REINSTALL :

1. Feed cable end under tilt shaft along side tilt housing along right side of front limit cam. Insert cable end into pocket on top of front limit cam. Wrap cable around rear of front limit cam, clockwise.
2. Using thumb pressure install replacement cable fitting into tension yoke on tilt.

167225 REV H

# 17



## WARNING

Tilt tension must be maintained during following procedure. Failure to do so may cause personal injury.

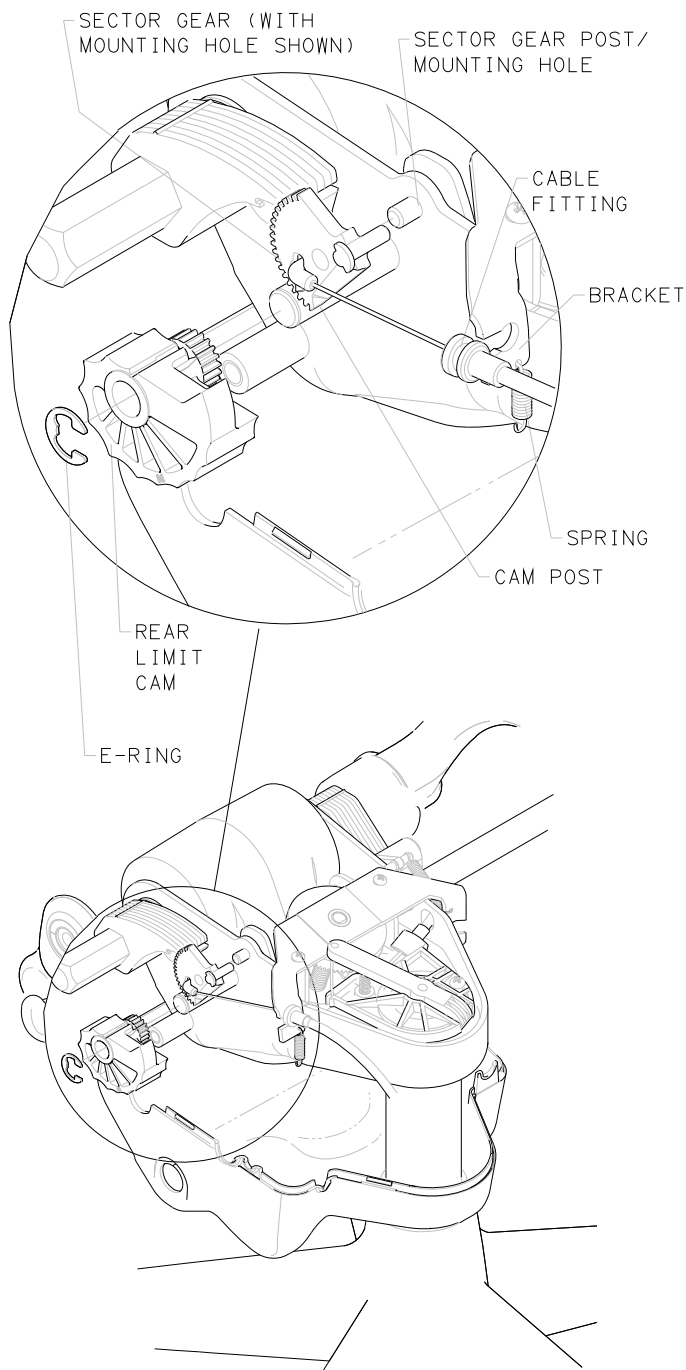
## TO REMOVE :

1. Apply downward pressure to top of chair back to relieve pressure from front limit cam. This position must be maintained until front limit cam is installed with E-ring.
2. Remove front limit cam and auxiliary cable connector if applicable, and dispose of properly.

## TO REINSTALL :

1. Slide front limit cam in position shown.
2. Refer back to steps 8 and 15,16b, for installing cable, securing cable fitting and installing E-clip.

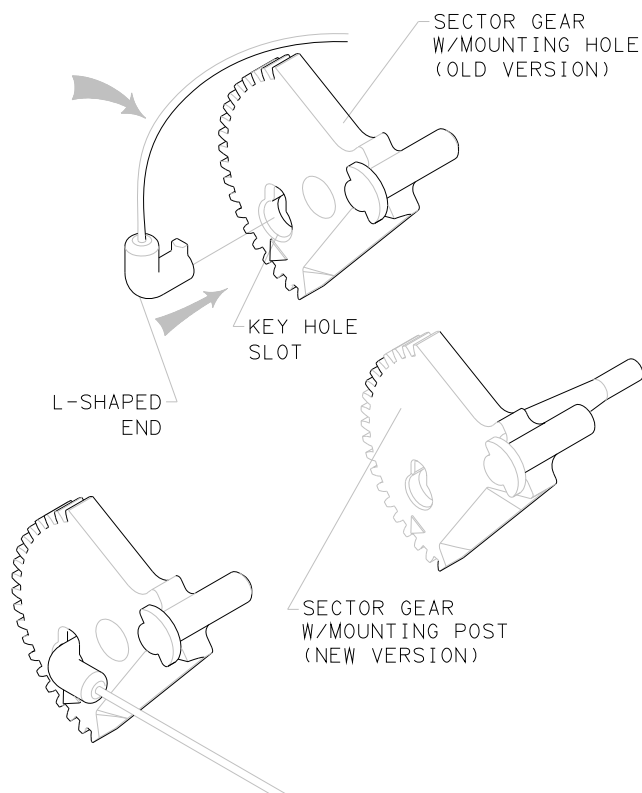
# 18<sub>a</sub>



## TO REMOVE :

1. Tilt limiter must be in released position (tilt limiter lever all the way down.) Using small needle nose pliers, remove spring from sector gear and let hang down.
2. Using small straight head screwdriver, remove e-ring securing sector gear. Remove rear limit cam and set aside. Remove sector gear with cable attached, from sector gear post/mounting hole and dispose of properly.

# 18<sub>b</sub>

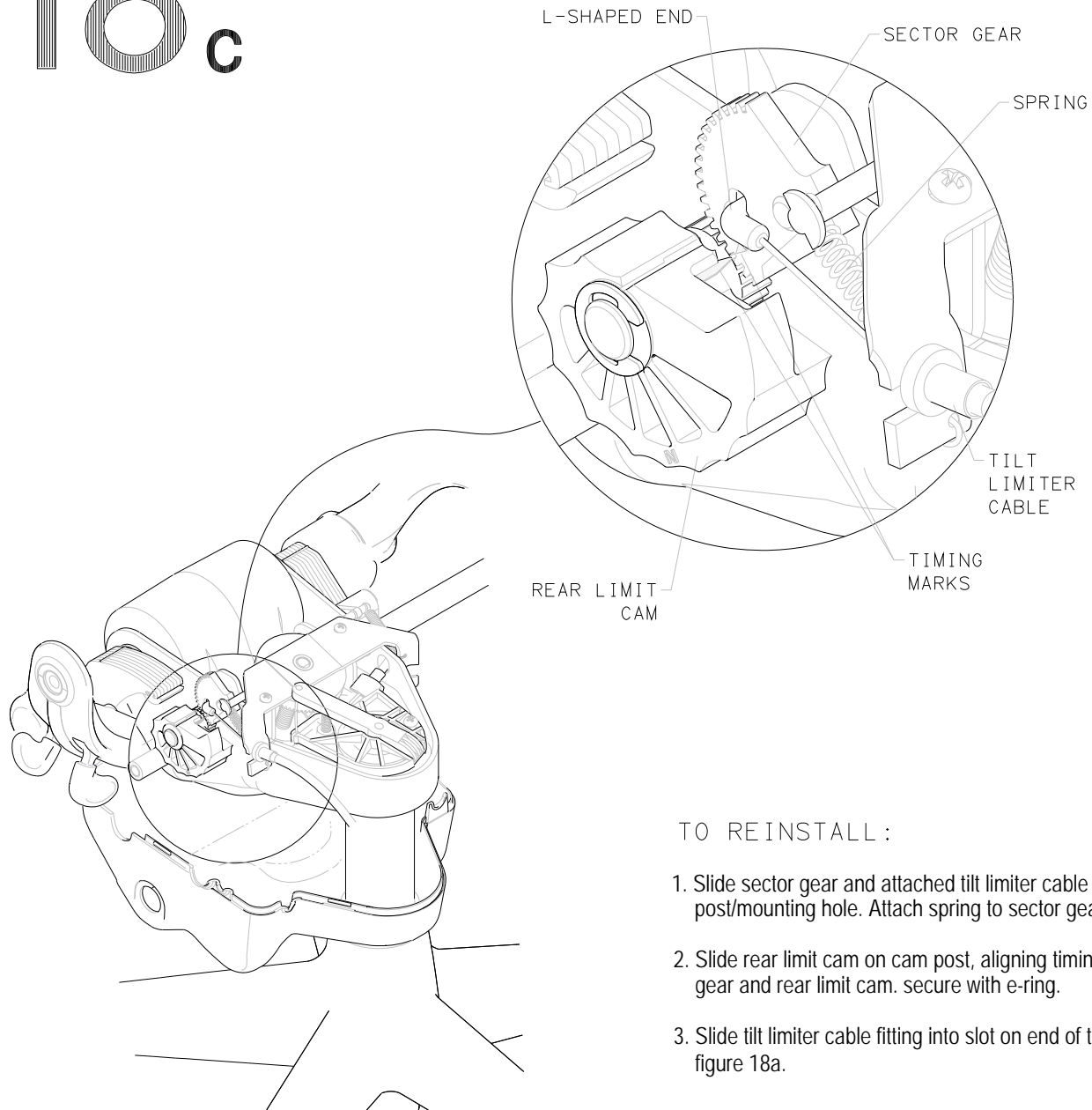


## TO REINSTALL :

1. Select appropriate sector gear, one that pivots on post of tilt (older version) or one with integral pivoting post that inserts in tilt (newer version).
2. Insert L-shaped end of replacement tilt limiter cable into keyhole slot in replacement sector gear.

167225 REV H

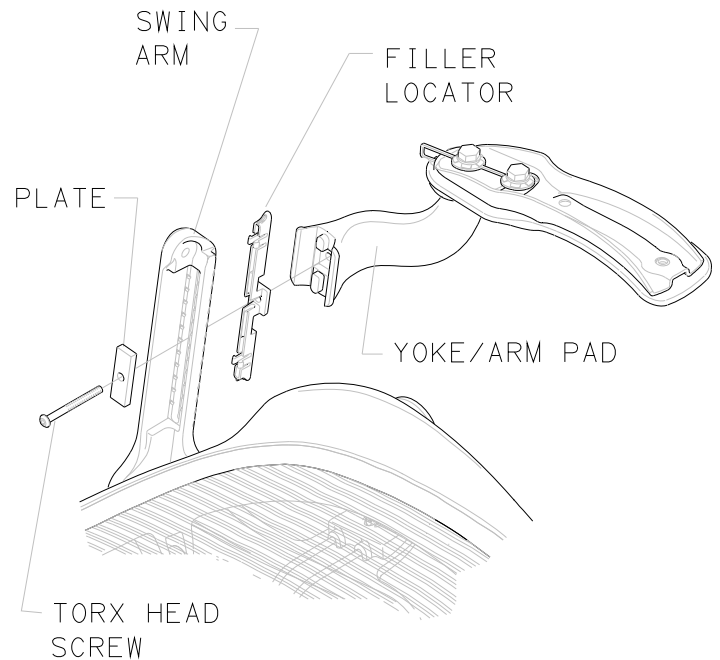
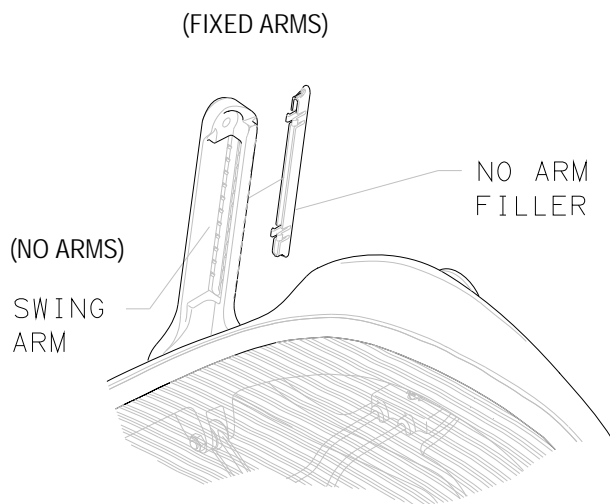
# 18<sub>c</sub>



## TO REINSTALL :

1. Slide sector gear and attached tilt limiter cable onto sector gear post/mounting hole. Attach spring to sector gear. See figure 18a.
2. Slide rear limit cam on cam post, aligning timing marks on sector gear and rear limit cam. secure with e-ring.
3. Slide tilt limiter cable fitting into slot on end of tension yoke. See figure 18a.

# 19

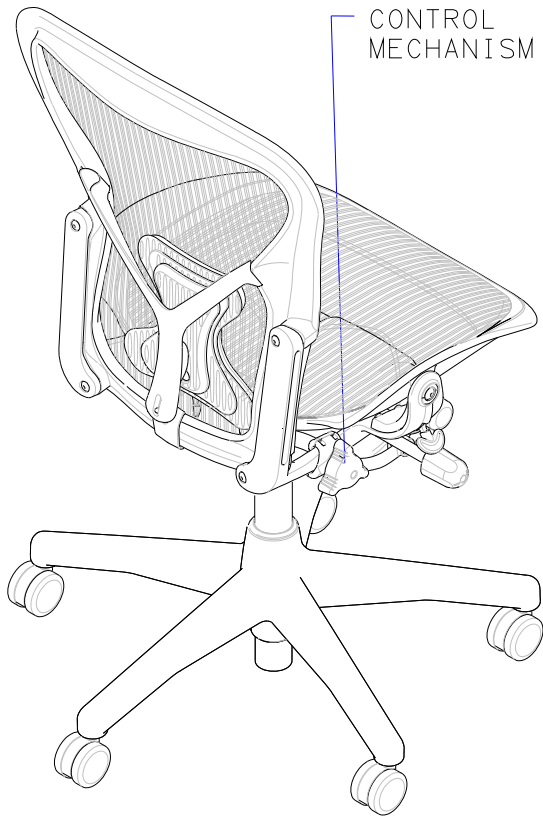


## TO REMOVE/INSTALL :

1. Using phillips head screwdriver, push out no arm filler from swing arm and dispose of properly. Repeat for opposite side.
2. Snap filler locators into swing arm.
3. Install yoke/arm pad to swing arm with plate and torx head screw using T-27 torx bit and ratchet wrench. Repeat for opposite side.
4. Refer back to steps 6 and 4, to complete reassembly.

167225 REV H

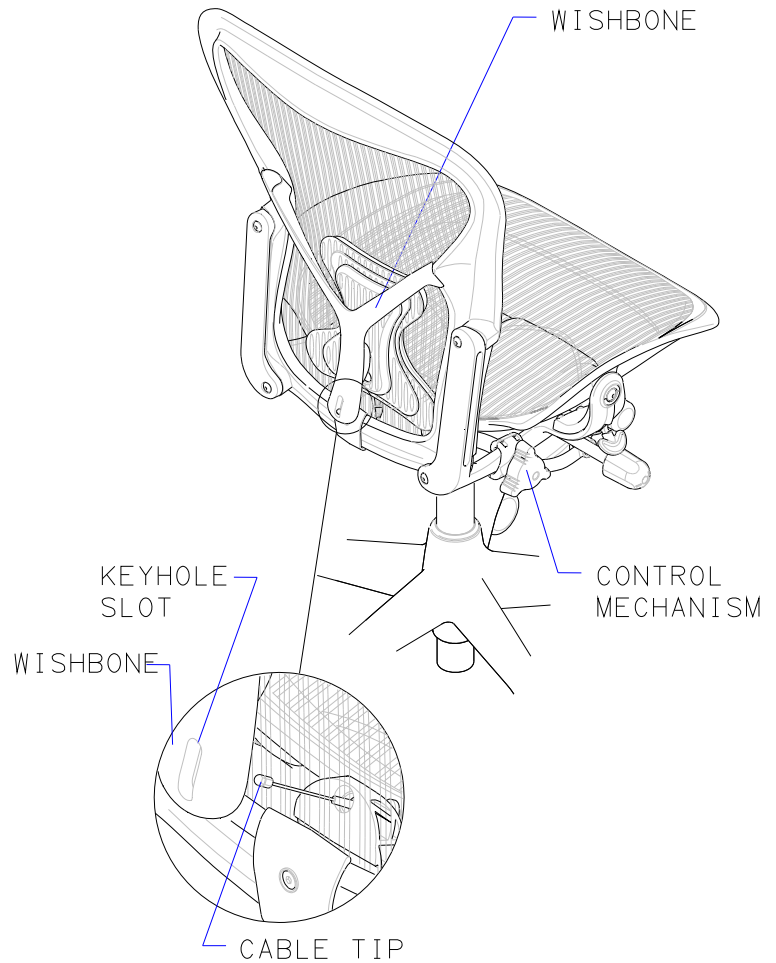
# Aeron® PostureFit Clip and Screw Replacement



CONTROL  
MECHANISM

## PROCEDURE

1



WISHBONE

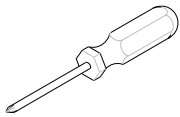
CONTROL  
MECHANISM

KEYHOLE  
SLOT

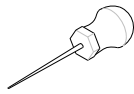
WISHBONE

CABLE TIP

## TOOLS NEEDED



#2 PHILLIPSHEAD  
SCREWDRIVER



AWL

## PARTS INCLUDED



CLIP

SCREW



### TO REMOVE:

1. Adjust control mechanism COUNTERCLOCKWISE so control is at lowest setting.
2. Depress base of wishbone and disconnect cable tip from keyhole slot in wishbone.

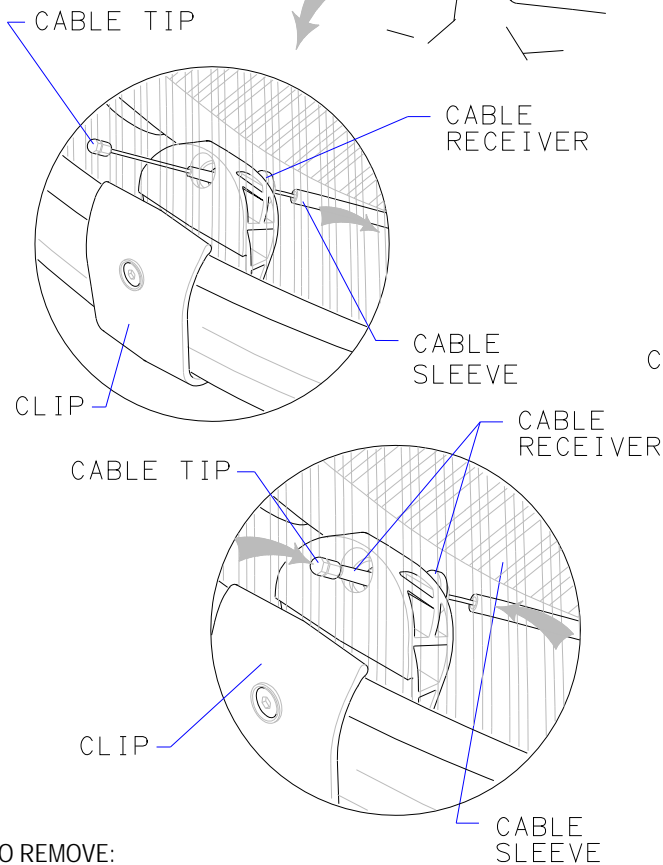
### TO REINSTALL:

1. Depress base of wishbone and place cable tip in wishbone keyhole slot.

1BONK5 REV B

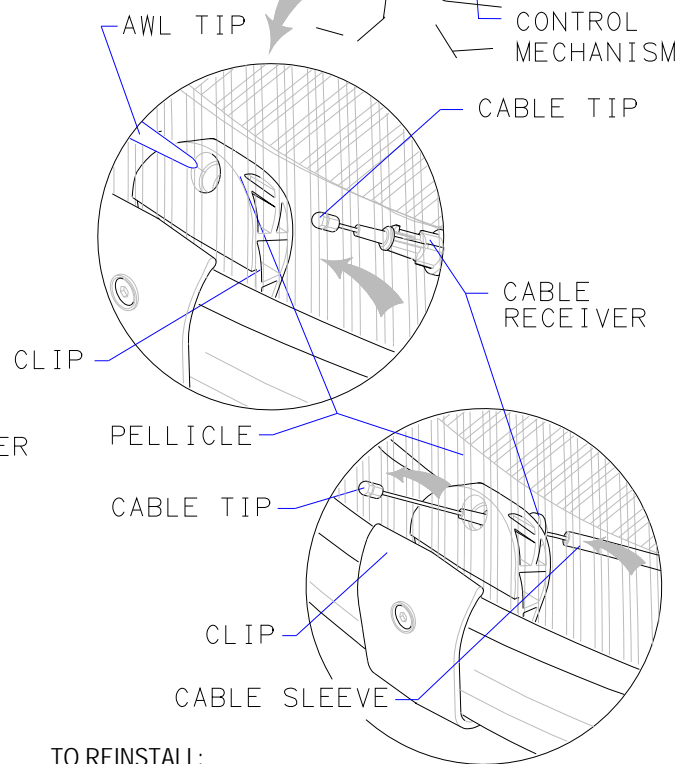


BACK —  
FRAME



1. Pull cable sleeve from cable receiver.
2. Pull cable so cable tip rests on end of cable receiver.
3. Push cable tip with forefinger to dislodge cable receiver from clip.

BACK  
FRAME

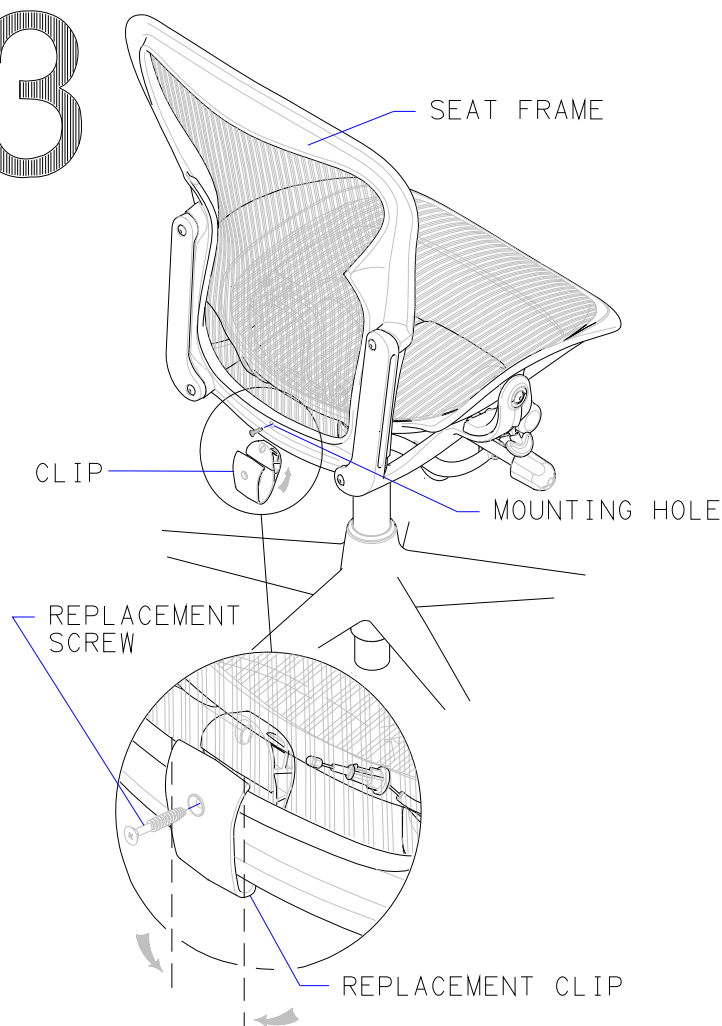


1. Adjust control mechanism COUNTERCLOCKWISE, so control is at lowest setting.
2. Carefully insert awl into pellicle and remove to create opening where cable tip will pass through.
3. Slide cable receiver towards cable tip and insert into clip, poking cable tip through pellicle opening.
4. Slide cable sleeve into cable receiver.



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# 3



TO REMOVE:

1. Using #2 phillips head screwdriver, remove screw from clip.
2. Remove clip from back frame. Properly dispose of clip and screw.

TO REINSTALL:

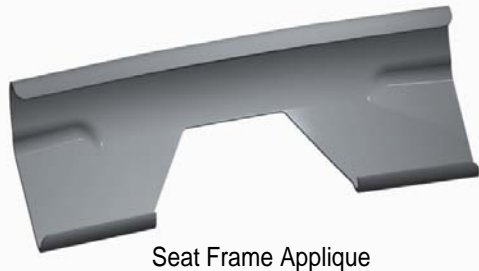
**NOTICE !** After April of 2007, all replacement cable clips are the "C" size chair cable clips. When installing these clips to an A or B size seat frame make sure clip is positioned vertically when tightening replacement screw to secure clip.

1. Place replacement clip over back frame aligning clip screw hole to back frame mounting hole. Insert replacement screw, hold clip in vertical position and tighten replacement screw.

1BONK5 REV B

# Aeron® PostureFit Seat Frame Applique Installation

## PARTS INCLUDED

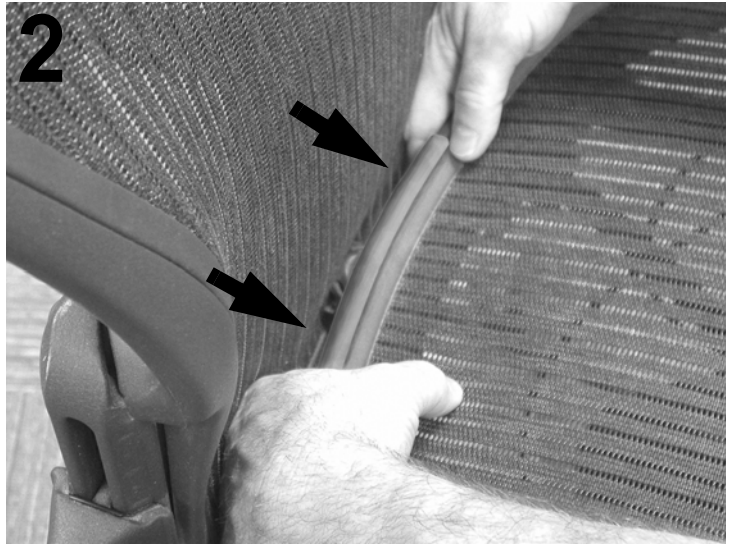


## NO TOOLS REQUIRED:

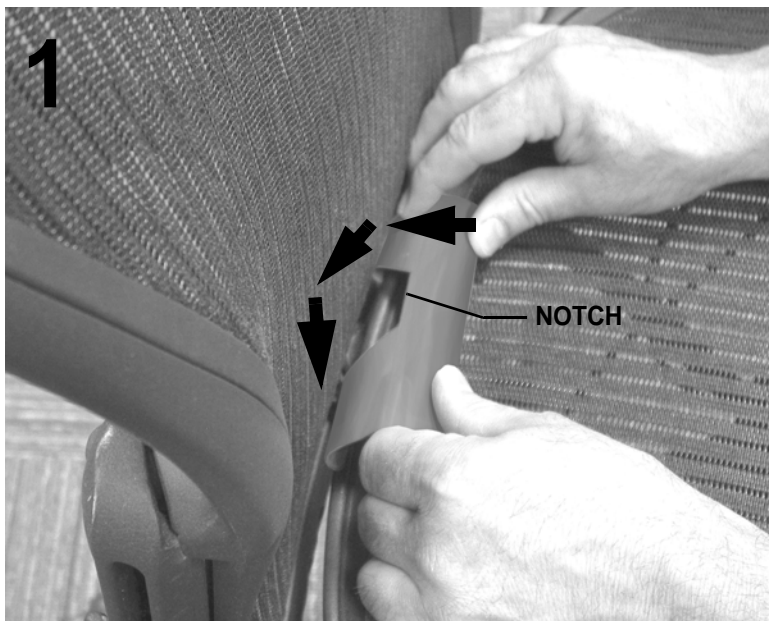


### NOTICE

Adjust Posture Fit control knob to lowest setting before starting procedure.



2.1 Engage long formed (upper) edge of applique onto upper rim of seat frame. Roll applique around seat frame and snap formed edges on each side of notch, onto lower seat frame rim.

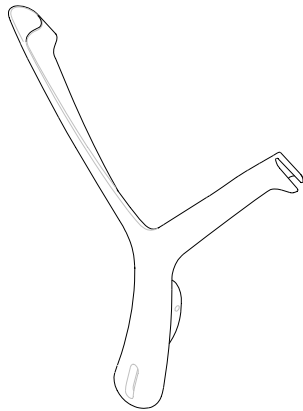


1.1 Install seat frame applique over seat frame at rear center of frame, so that notch straddles posture fit control cable.



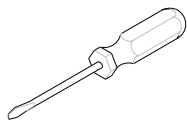
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# Aeron® PostureFit Wishbone Replacement



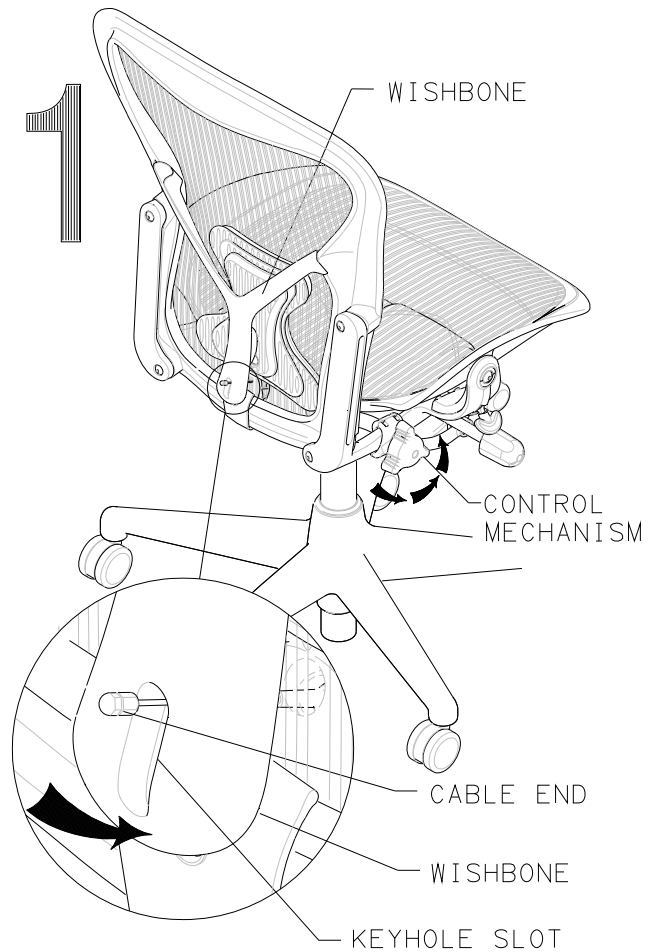
WISHBONE

## PARTS INCLUDED



(QTY 2) STRAIGHT  
HEAD SCREWDRIVER

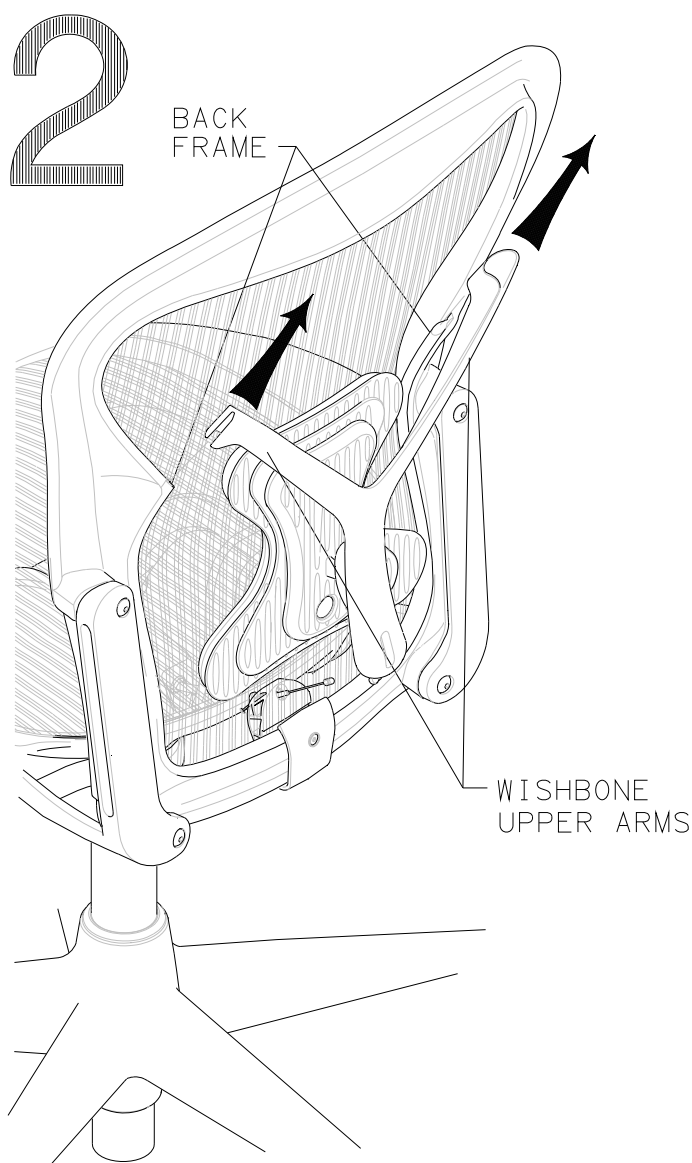
## TOOLS REQUIRED



### CABLE DISCONNECT:

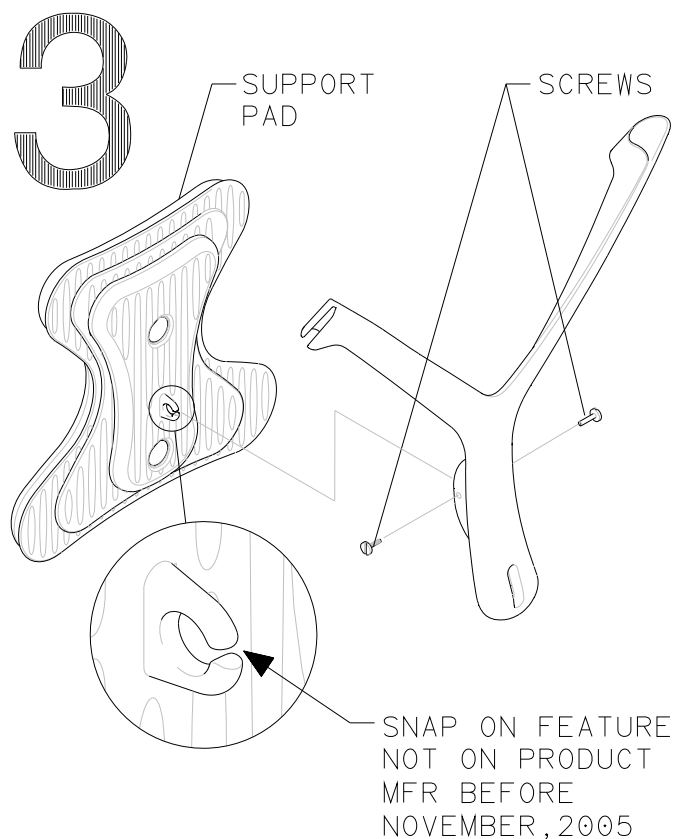
- 1.1 Adjust control mechanism counter-clockwise to set posturefit at minimum support setting.
- 1.2 Depress base of wishbone and disconnect cable end from keyhole slot in wishbone.

1BOM6M REV B



#### WISHBONE REMOVAL:

- 2.1 By hand, grasp wishbone upper arms and slide wishbone, with support pad, up off back frame.



#### WISHBONE REPLACEMENT:

- 3.1 Using screwdrivers, remove and save screws from wishbone. Set support pad aside and dispose of old wishbone properly.

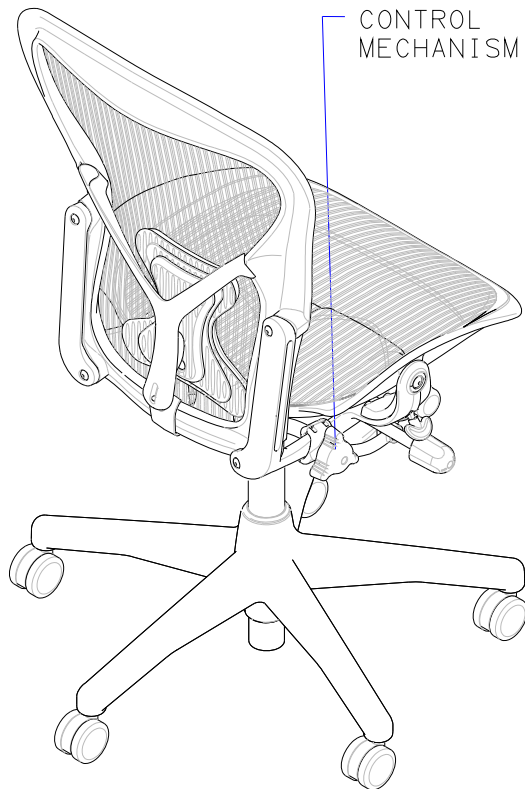
NOTE: Support pads manufactured before November, 2005, do not have the snap on feature that allows removal or installation of pad with screws installed in wishbone.

- 3.2 Install replacement wishbone to support pad, reinstalling screws as necessary for type of pad present.

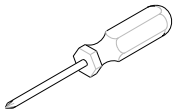
#### REASSEMBLY NOTES:

1. By hand, install replacement wishbone and support pad to back frame. Seat wishbone completely onto back frame.
2. Reconnect control mechanism cable to keyhole slot in wishbone.

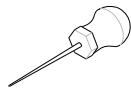
# Aeron® PostureFit Control Mechanism Replacement



## TOOLS NEEDED

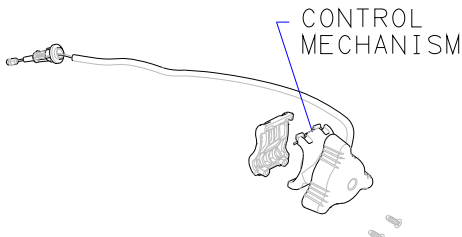


#2 PHILLIPSHEAD  
SCREWDRIVER



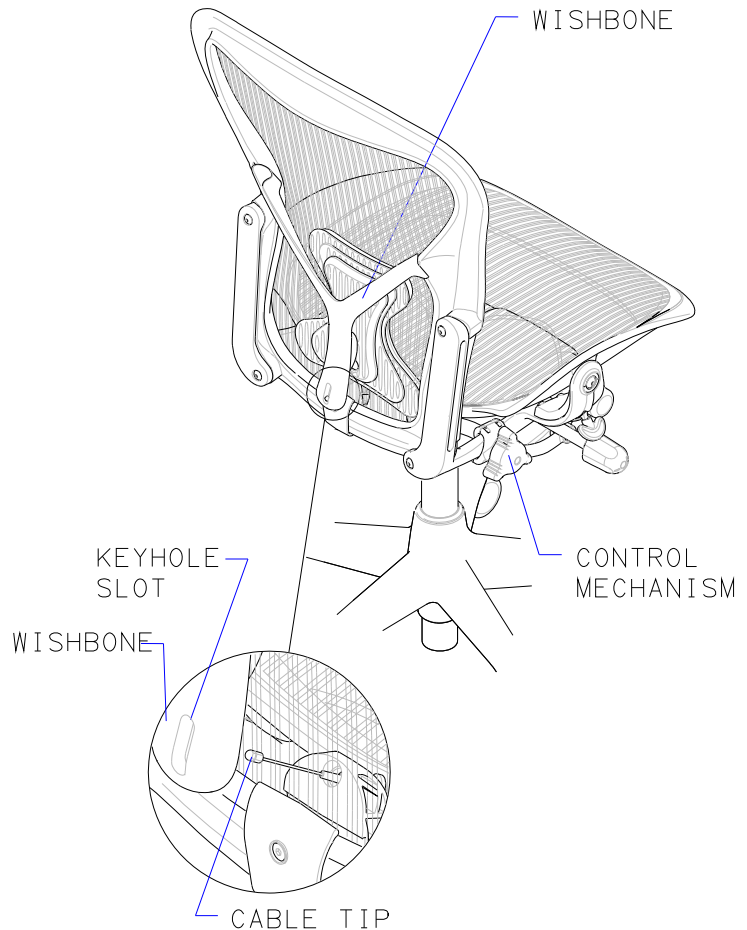
AWL

## PARTS INCLUDED



## PROCEDURE

1



### TO REMOVE:

1. Adjust control mechanism COUNTERCLOCKWISE so control is at lowest setting.
2. Depress base of wishbone and disconnect cable tip from keyhole slot in wishbone.

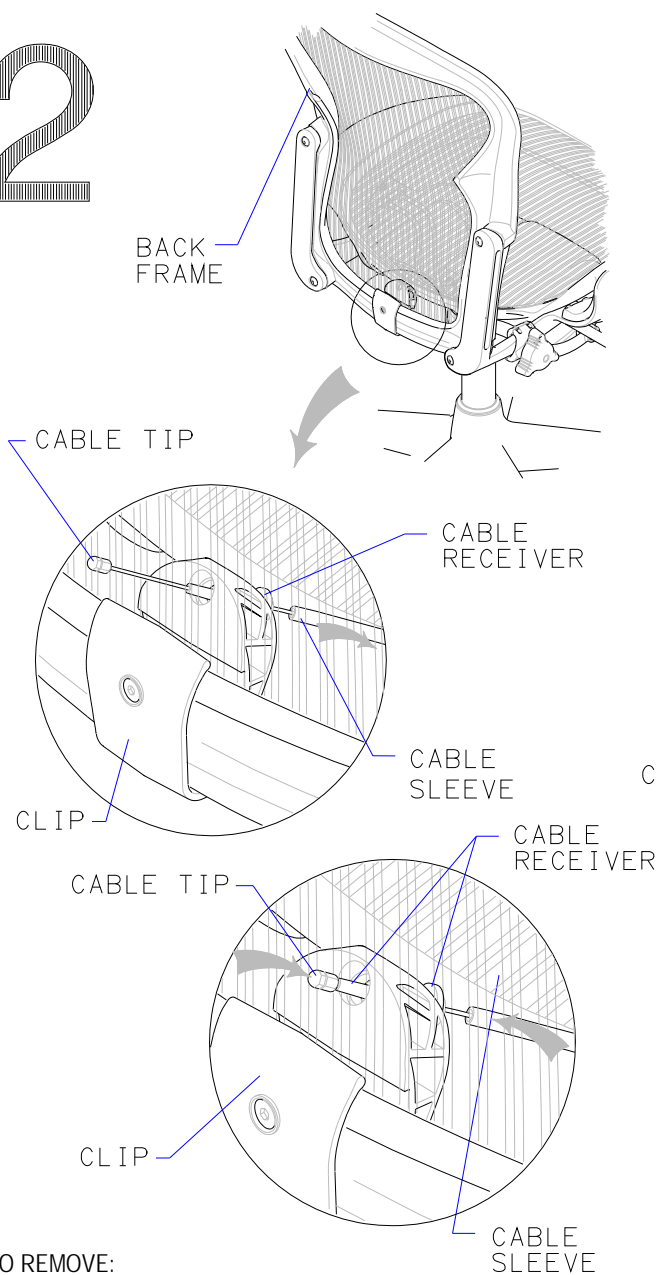
### TO REINSTALL:

1. Depress base of wishbone and place cable tip in wishbone keyhole slot.

1B0M6P REV A



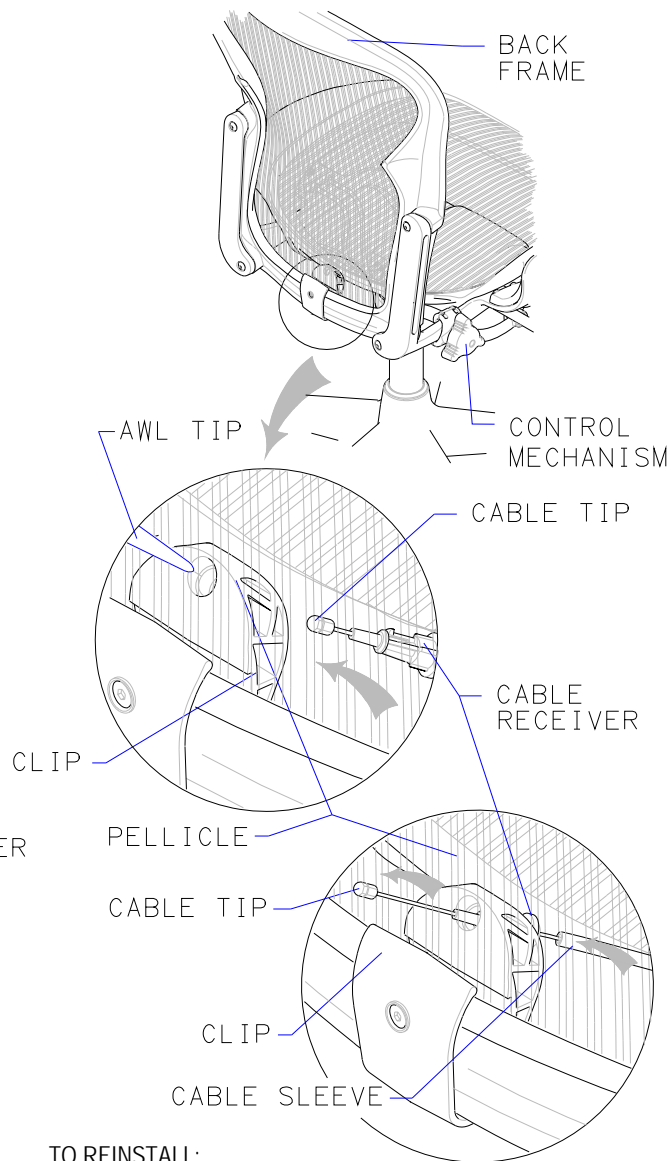
# 2



## TO REMOVE:

1. Pull cable sleeve from cable receiver.
2. Pull cable so cable tip rests on end of cable receiver.
3. Push cable tip with forefinger to dislodge cable receiver from clip.

NOTE: TAKE SPECIAL CARE NOT TO SNAG CABLE TIP WHEN PASSING THROUGH PELLICLE.

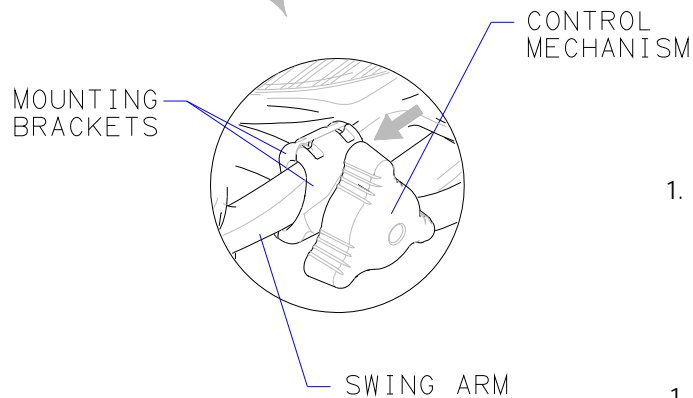
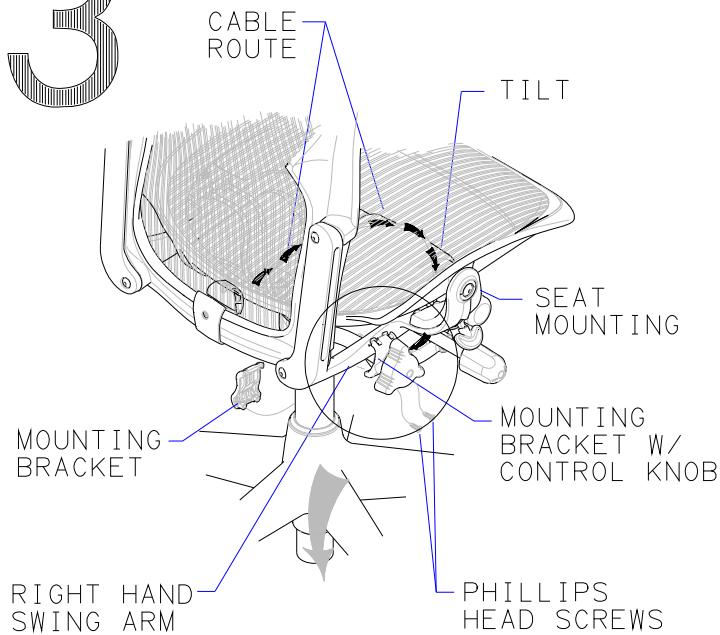


## TO REINSTALL:

1. Adjust control mechanism COUNTERCLOCKWISE, so control is at lowest setting.
2. Carefully insert awl into pellicle and remove to create opening where cable tip will pass through.
3. Slide cable receiver towards cable tip and insert into clip, poking cable tip through pellicle opening.
4. Slide cable sleeve into cable receiver.

NOTE: TAKE CARE NOT KINK CABLE WHILE INSERTING.

# 3



## TO REMOVE:

1. Using #2 phillips head screwdriver, remove screws fastening mounting bracket to control mechanism. Remove control mechanism from swing arm. Properly dispose of control mechanism and screws.

## TO REINSTALL:

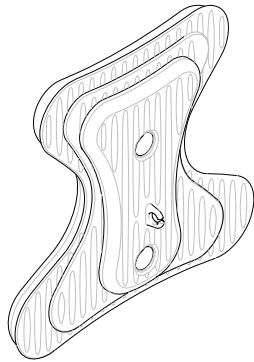
1. Place mounting bracket with control knob of control mechanism approximately (1") back from seat mounting of swing arm. Hook on other half of mounting bracket. Insert phillips head screws. Tighten screws using #2 phillips head screwdriver to secure mounting brackets to each other. DO NOT TIGHTEN to swing arm at this time.
2. Slide mounting brackets back on swing arm until they wedge in place. Tighten screws.
3. Route cable from control mechanism under right hand swing arm towards front of tilt turning towards back of chair.

1BOM6P REV A



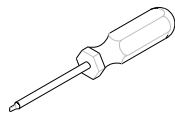
# Aeron® PostureFit Support Pad Replacement

## PROCEDURE:



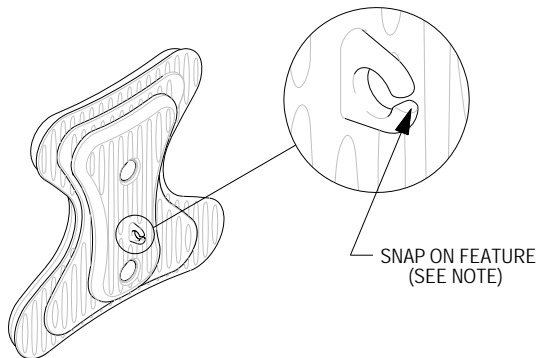
POSTUREFIT SUPPORT PAD

## PARTS INCLUDED

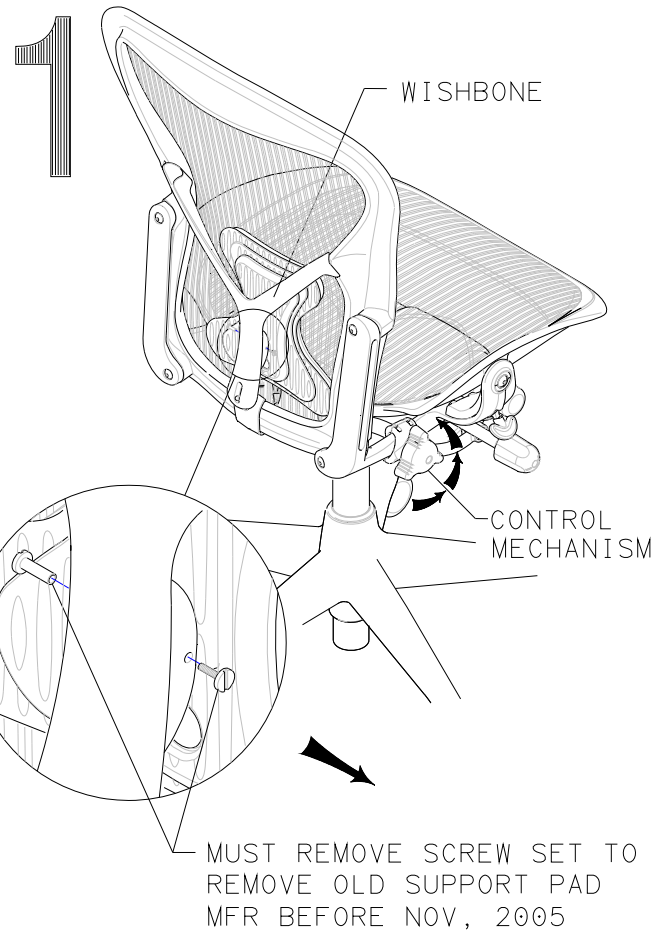


(QTY 2) STRAIGHT  
HEAD SCREWDRIVER

## TOOLS REQUIRED



NOTE: Product manufactured before November, 2005 does not have snap on feature which allows removal or installation of support pad without removing 2-piece screw set that secures support pad to wishbone.

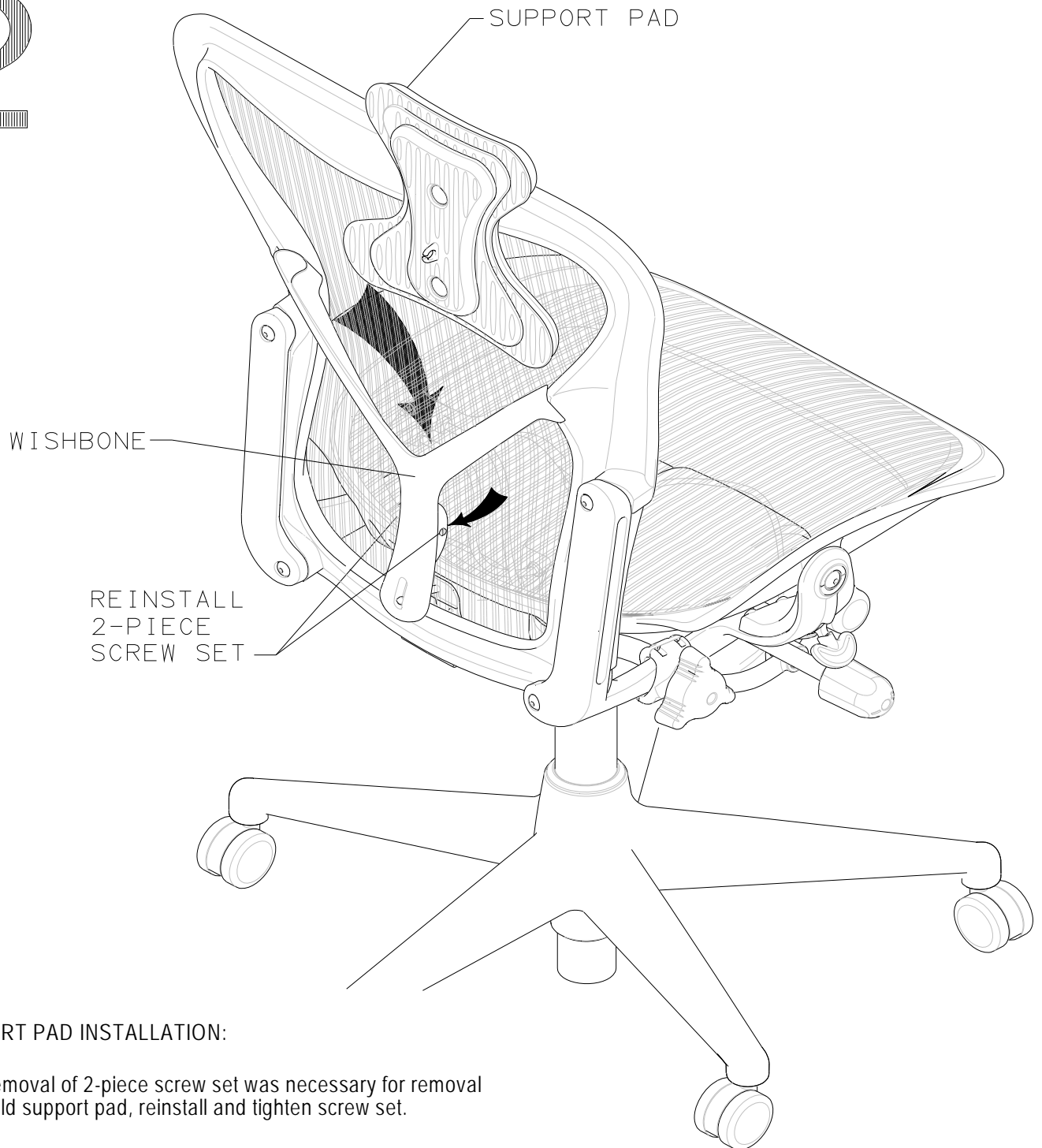


## SUPPORT PAD REMOVAL:

- 1.1 Adjust control mechanism counter-clockwise to set posturefit wishbone at minimum support setting.
- 1.2 Determine if pad being replaced is equipped with snap on feature by applying hand pressure between wishbone and installed support pad. If support pad does not snap free, remove and save 2-piece screw set using (2) straighthead screwdrivers.
- 1.3 Remove old support pad from wishbone and dispose of pad, properly.

1BOM6N REV B

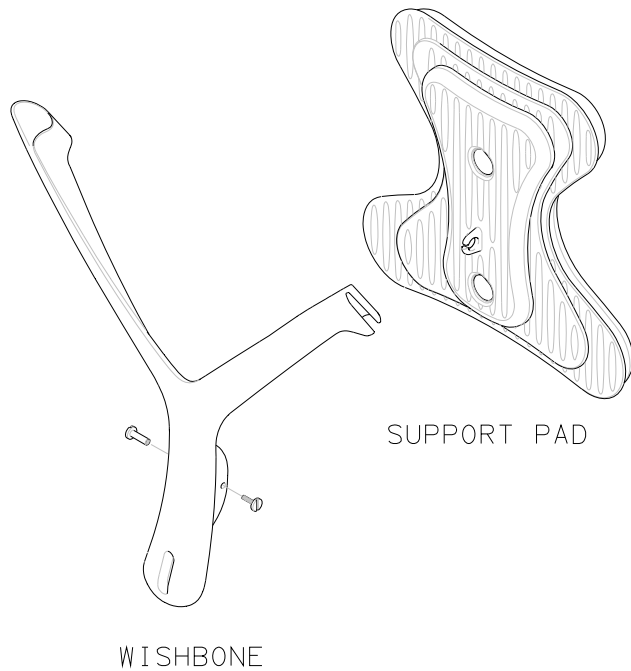
# 2



## SUPPORT PAD INSTALLATION:

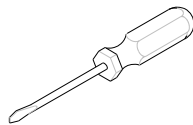
- 2.1 If removal of 2-piece screw set was necessary for removal of old support pad, reinstall and tighten screw set.
- 2.2 Place support pad between wishbone and back pellicle. Press support pad into back pellicle and slide pad down until snap on feature aligns with 2-piece screw set, then engage snap on feature onto screw set.

# Aeron® PostureFit Wishbone/Support Pad Replacement



NOTE: Actual parts may or may not be assembled.

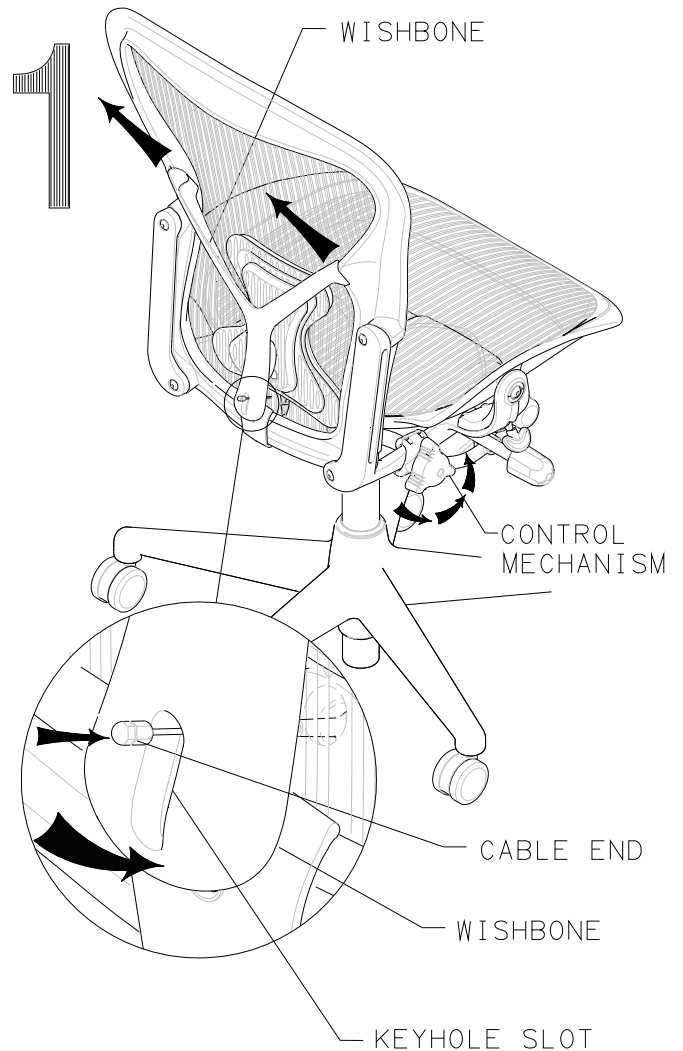
## PARTS INCLUDED



(QTY 2) STRAIGHT  
HEAD SCREWDRIVER  
(as required)

## TOOLS REQUIRED

## PROCEDURE

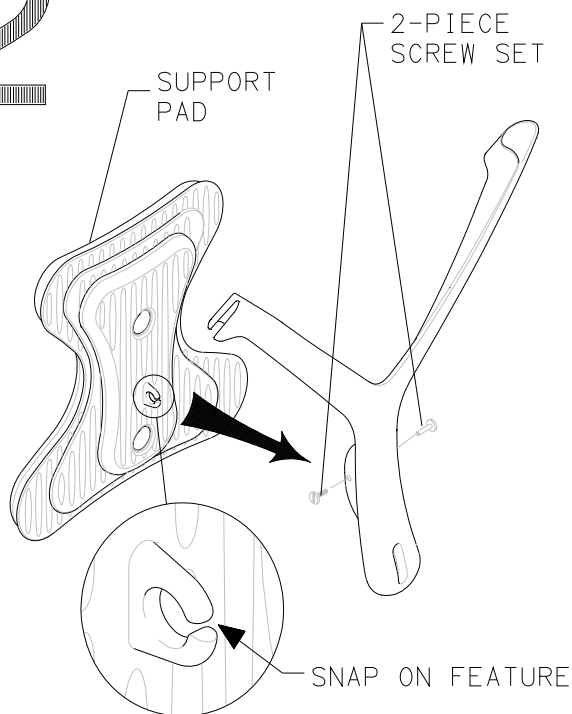


### WISHBONE/SUPPORT PAD ASSEMBLY REMOVAL:

- 1.1 Adjust control mechanism counter-clockwise to set posturefit at minimum support setting.
- 1.2 Depress base of wishbone and disconnect cable end from keyhole slot in wishbone.
- 1.3 By hand, grasp upper wishbone arms and slide wishbone, with support pad, up off back frame. Dispose of old wishbone and support pad properly.

1BONKS REV B

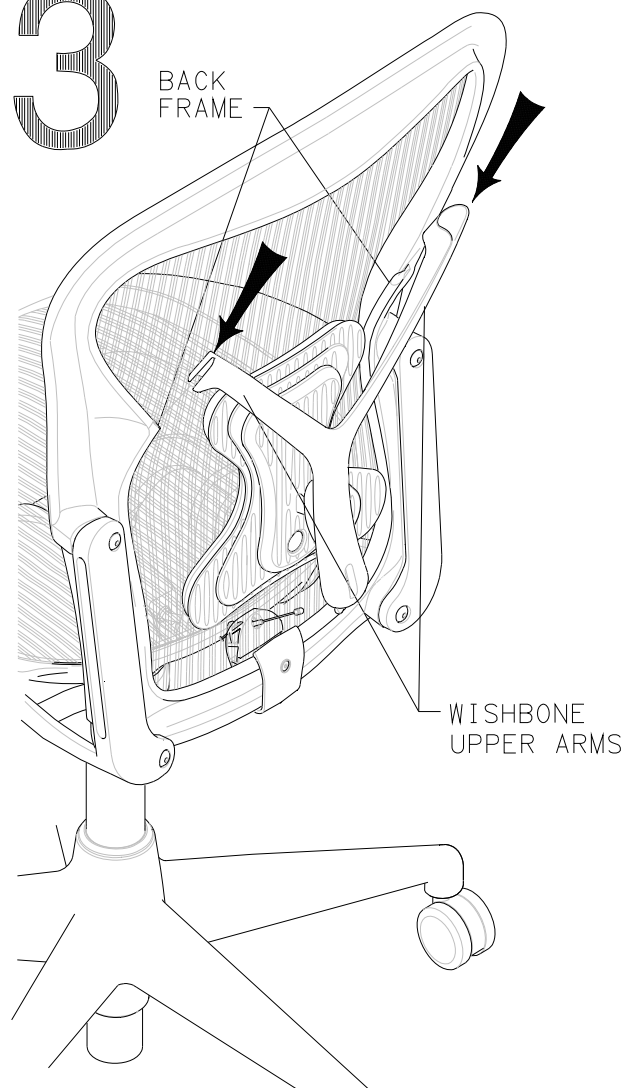
# 2



## WISHBONE ASSEMBLY, (AS REQUIRED):

- 2.1 Using screwdrivers, assemble 2-piece screw set to wishbone as shown.
- 2.2 Install support pad to wishbone by engaging snap on feature onto installed 2-piece screw set.

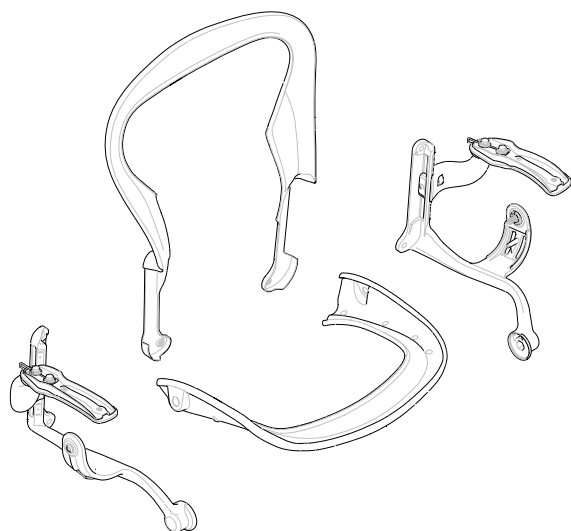
# 3



## WISHBONE INSTALLATION:

- 3.1 By hand, grasp wishbone upper arms and slide wishbone, with support pad, down onto back frame, as shown. Make sure wishbone is completely seated on back frame.
- 3.2 Reconnect control mechanism cable to keyhole slot in wishbone.

# Aeron® Frame Applique Installation



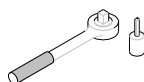
## TOOLS NEEDED



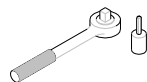
PHILLIPS HEAD  
SCREWDRIVER



1" PUTTY KNIFE



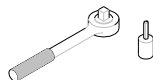
RATCHET WRENCH W/  
6MM HEX HEAD BIT



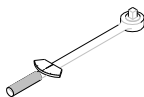
RATCHET WRENCH W/  
5MM HEX HEAD BIT



4MM HEX KEY



RATCHET WRENCH W/  
T-27 TORX BIT



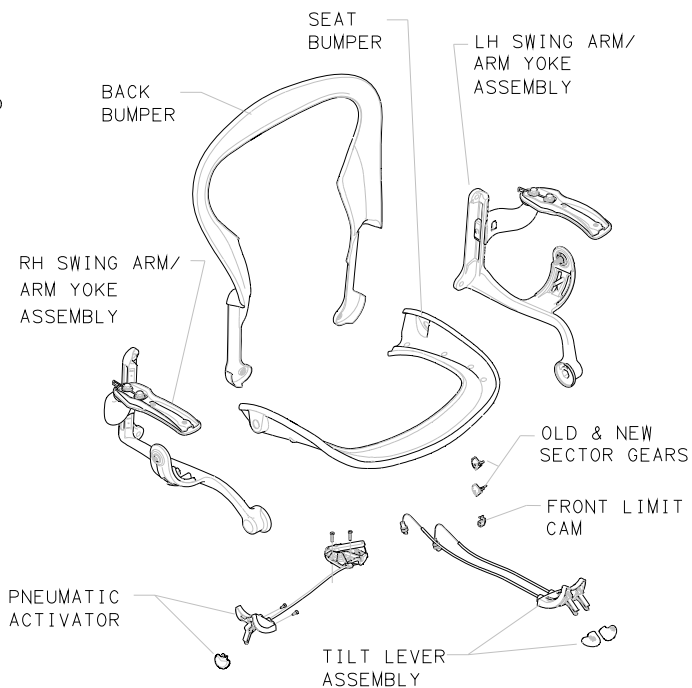
TORQUE WRENCH



PLIERS

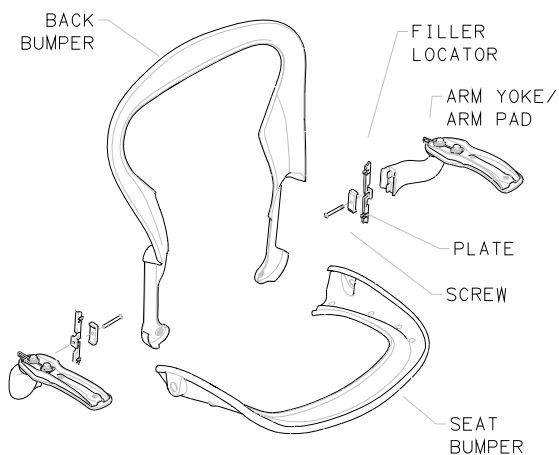
## PARTS INCLUDED

### ADJUSTABLE ARMS



## PARTS INCLUDED

### FIXED ARMS



1B1KCS REV B

## PROCEDURE

Remove sticker from all Aeron chairs.

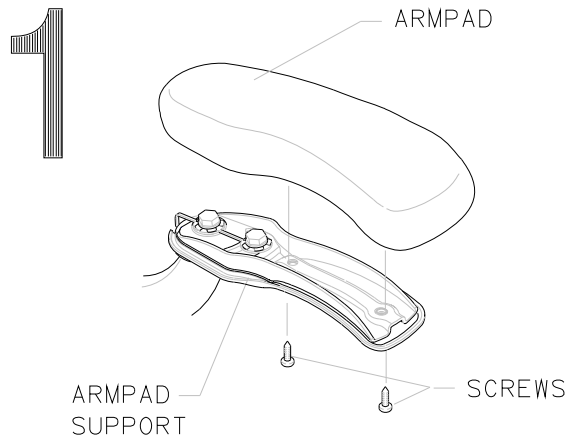
### NOTICE

THIS ARTICLE IS MANUFACTURED FOR USE IN PUBLIC OCCUPANCIES AND MEETS THE FLAMMABILITY REQUIREMENTS FOR CALIFORNIA BUREAU OF HOME FURNISHINGS TECHNICAL BULLETIN 133. CARE SHOULD BE EXERCISED NEAR OPEN FLAME OR WITH BURNING CIGARETTES.

### NOTICE

TILT LIMITER MUST BE IN RELEASED POSITION TO SERVICE. (TILT LIMITER LEVER ALL THE WAY DOWN).

The following procedures are for products with adjustable arms. For Fixed Arms, to a no arm chair, go on to steps 6-10 & 23.

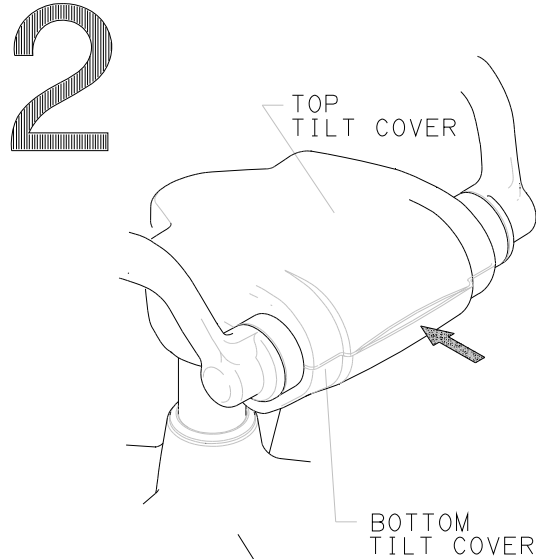


#### TO REMOVE :

1. Using #2 phillips head screwdriver, remove screws securing arm pad to arm pad support.
2. Set arm pad and screws aside. Repeat procedure for opposite side.

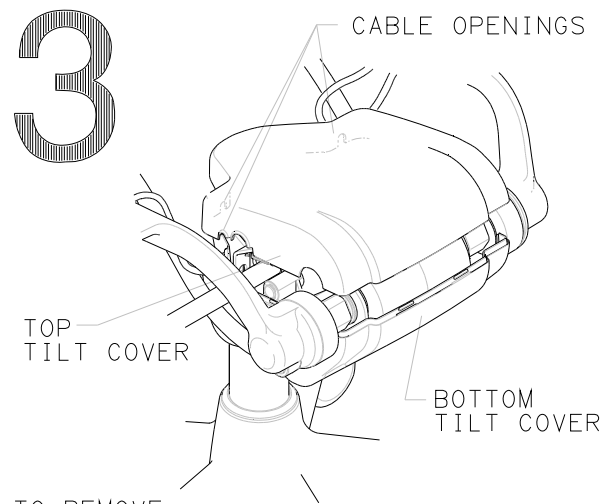
#### TO REINSTALL :

1. Place arm pad on arm pad support. Insert screws in arm pad support and secure arm pad using #2 phillips head screwdriver. repeat for opposite side.



#### TO REMOVE :

1. Using thumb pressure, press front of bottom tilt cover to start separation of tilt covers.



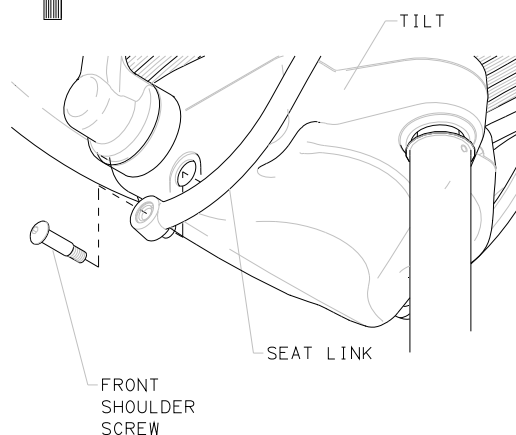
#### TO REMOVE :

1. Insert 1" putty knife between covers and twist to separate top from bottom cover. Remove top cover and set aside.

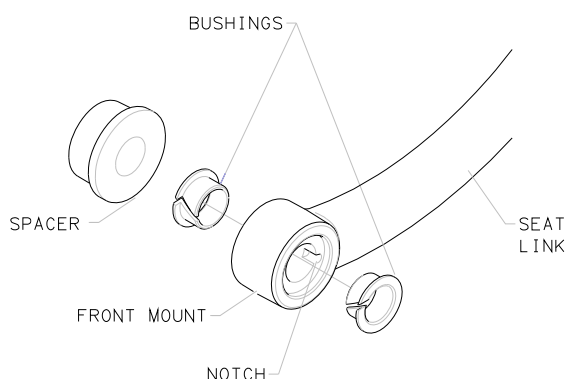
#### TO REINSTALL :

1. Reposition top tilt cover over bottom tilt cover, making sure all cables are properly routed through cable openings. Snap cover halves together.

# 4



(OLDER VERSION)



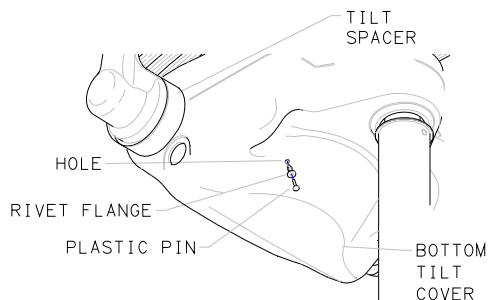
## TO REMOVE :

1. While supporting seat link, use 6MM socket, ratchet wrench to remove shoulder screw attaching seat link to tilt. Set aside shoulder screw. Let seat link hang. Remove spacers and or bushings if applicable and set aside. Repeat for opposite side.

## TO REINSTALL :

1. Attach front mount of seat link to tilt with shoulder screw. Tighten and torque to 120-150 in-lbs.

# 5



## TO REMOVE :

1. Using needle nose pliers, remove plastic pin from rivet flange from under side of lever tilt cover on left side and set aside. Using needle nose pliers, remove rivet flange from tilt cover and set aside. Let bottom cover rest on base. Older chairs secure cover with (2) phillipshead screws. Use #2 phillips head screwdriver to remove and set aside.

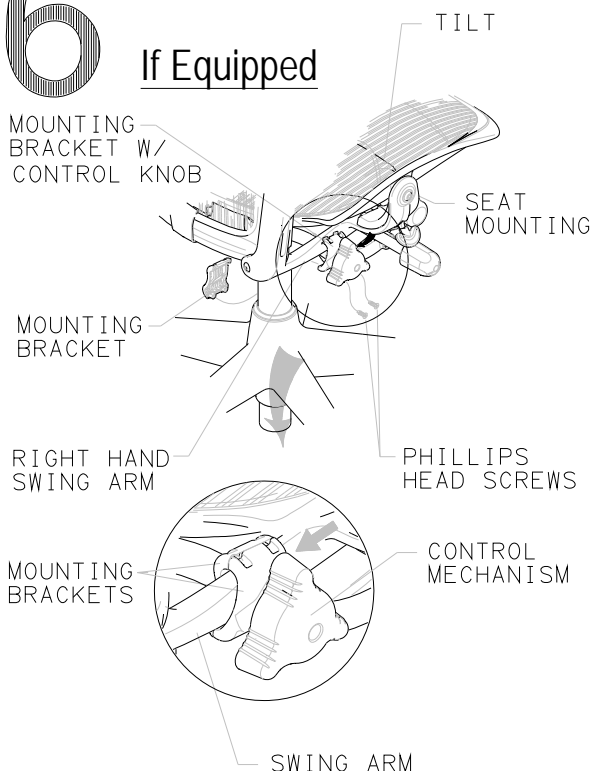
## TO REINSTALL :

1. Slide bottom tilt cover up to tilt. Make sure notches in tilt spacer grooves engage slots in tilt cover. If necessary, rotate tilt spacers to align notches with slots. Align hole in tilt cover to hole in tilt. Install rivet flange into tiltcover and tilt. Insert rivet pin into rivet flange.

1B1KCS REV B

# 6

## If Equipped



### TO REMOVE :

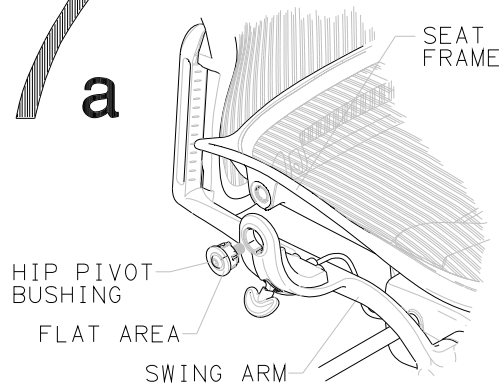
1. Using #2 phillips head screwdriver, remove and set aside screws fastening mounting bracket to control mechanism. Remove control mechanism from swing arm and let hang.

### TO REINSTALL :

1. Place control mechanism mounting halves over locator tab (on inside of swing arm). Hook back half onto front half over locator tab and secure with screws using #2 phillips head screwdriver.
2. Route cable from back of chair over tilt, looping back under right hand swing arm.

# 7

## a



(FOR CHAIRS MANUFACTURED AFTER JUNE 4,2003)

### TO REMOVE :

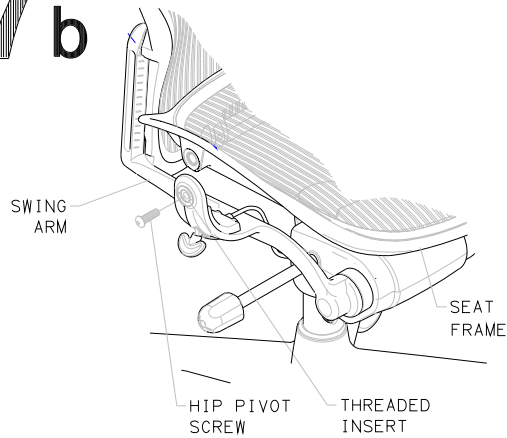
1. Using ratchet and 6MM hex bit, remove hip pivot bushing assembly from swing arm. Loosening pivot fastener will force hip pivot bushing assembly from swing arm. After hip pivot fastener has disengaged from seat frame, remove hip pivot bushing and set aside. Repeat for other side. Remove seat frame with b-links and set aside.

### TO REINSTALL :

1. Make certain flat area around fasteners head in hip pivot bushing is flat and aligned with bushing area. Repeat for other hip pivot bushing.
2. Lower seat in place. Align fastener in seat frame to mounting hole in swing arm and insert hip pivot bushing.
3. Insert other hip pivot fastener into swing arm aligning top and bottom guides into slots in swing arm opening.
4. Using 6MM head bit and ratchet wrench, partially thread hip pivot fastener into seat frame. Repeat for opposite side.
5. Secure fasteners of hip pivot bushing, drawing hip pivot bushing into seat frame. Torque fasteners to 180-200 lbs.



# 7b



(FOR CHAIRS MANUFACTURED BEFORE JUNE 4, 2003)

## TO REMOVE :

1. Using ratchet and 6MM hex bit, remove hip pivot screw from each swing arm. If threaded insert turns with hip pivot screw, **STOP** immediately and do the following step: Tighten hip pivot screw into threaded insert as much as possible. Using a quick jerking motion with ratchet wrench. Back out hip pivot screw from threaded insert. If threaded insert turns with hip pivot screw, repeat process.
2. Remove seat frame with b links and set aside.

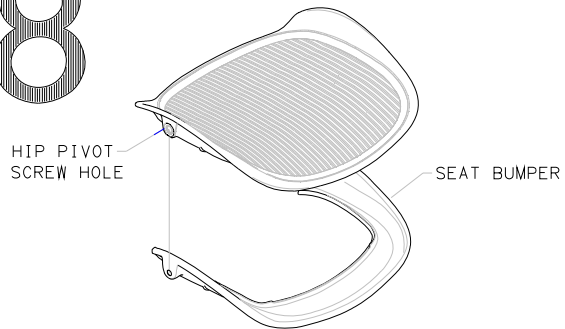
### ⚠ CAUTION

If threaded inserts turn while removing hip pivot screws from seat frame, **STOP IMMEDIATELY** and follow instructions.

## TO REINSTALL :

1. Place seat frame between swing arms. Attach seat frame to swing arms with hip pivot screws. Tighten and torque to 180-200 in lbs.

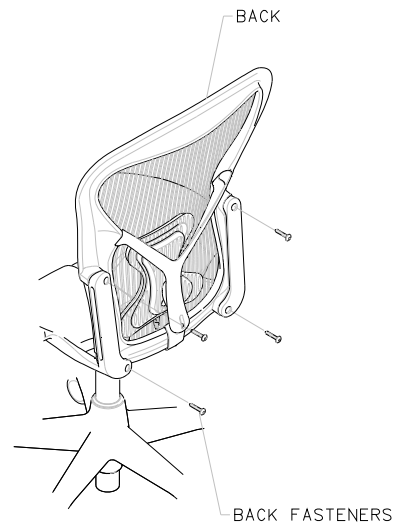
# 8



## TO INSTALL :

1. Install seat bumper around edge of seat frame, being certain that bumper snaps securely over edge in all locations and that holes in bumper align with hip pivot screw holes in seat frame.

# 9



## TO REMOVE :

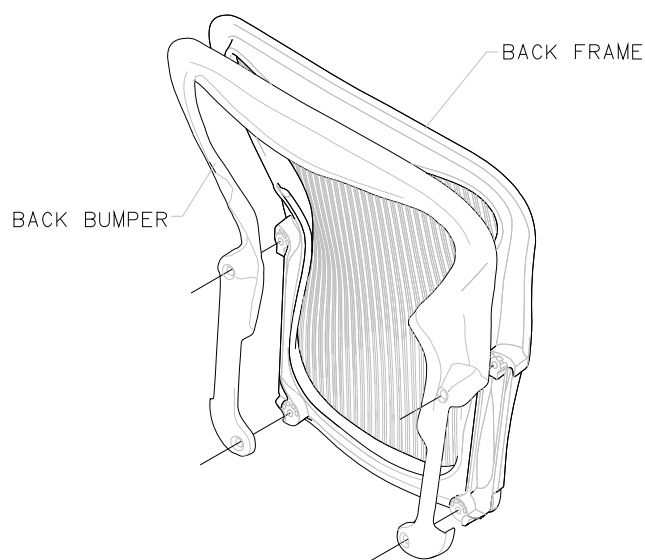
1. Using ratchet wrench and 5MM, remove and set aside fasteners from right and left side of back. Remove and set aside back and attached control mechanism (if equipped).

## TO REINSTALL :

1. Using ratchet wrench and 5MM hex bit, secure back to swing arm. Torque fasteners to 70-100 in lbs.

1B1KCS REV B

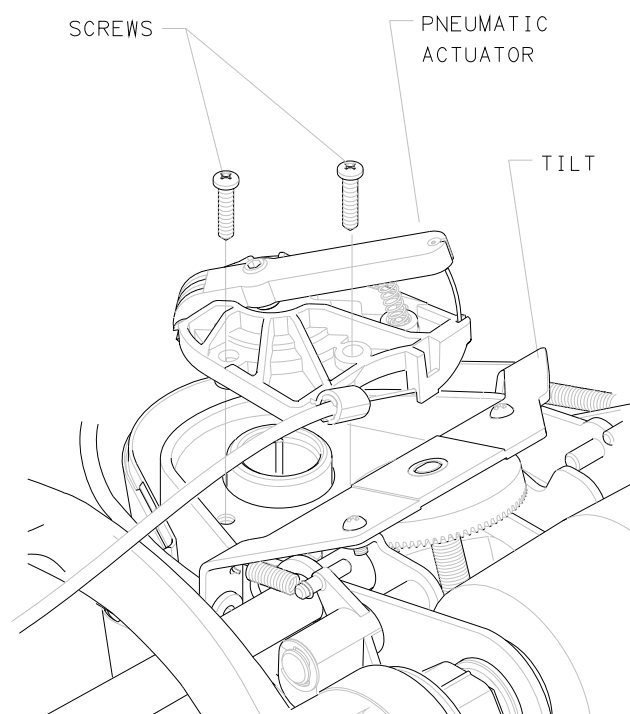
# 10



## TO INSTALL :

1. Install back bumper around edge of back frame, being certain that bumper snaps securely over edge in all locations and that holes in bumper align with screw holes in back frame.

# 11



## TO REMOVE :

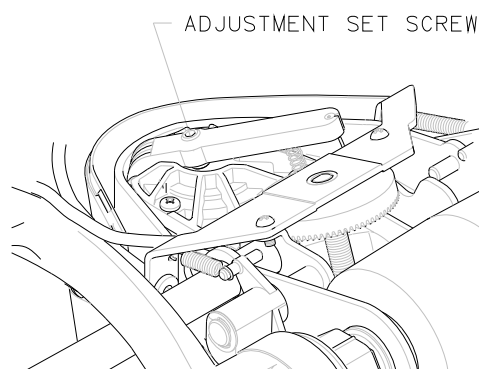
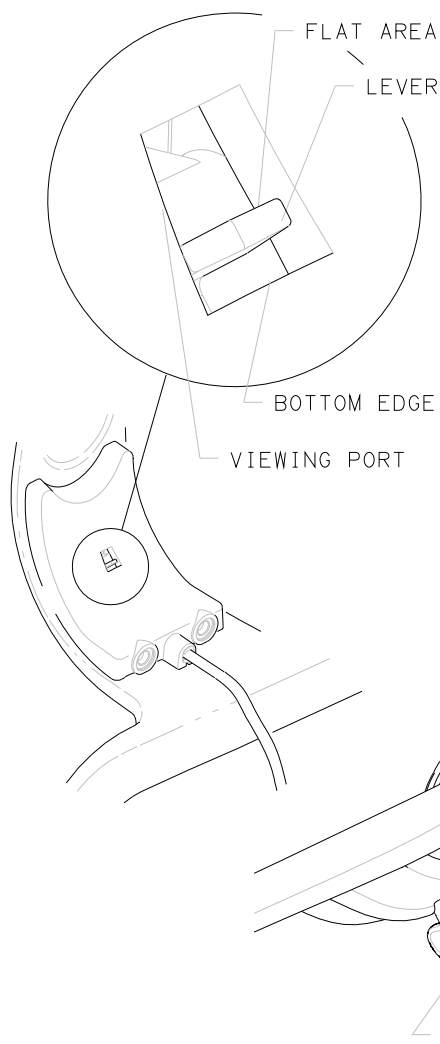
1. Using #2 phillips head screwdriver, remove and discard (2) screws securing pneumatic actuator to tilt.

## TO REINSTALL :

1. Place actuator end of pneumatic cable assembly on top of tilt. Secure with screws provided using #2 phillips head screwdriver.

# 12

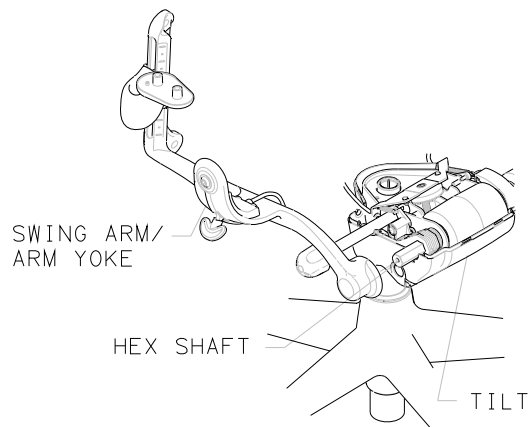
TO ADJUST ACTIVATION:



1. Check pneumatic cable assembly's activation by activating lever slightly to monitor lever through viewing port on pneumatic control end. When flat area of lever is even with bottom edge of viewing port, adjustment set screw on activation end of cable assembly should be resting on pin of pneumatic cylinder, not yet activated. Adjust set screw using 4MM hex key until this is achieved.
2. Refer back to installation of each step to reassemble chair.

1B1KCS REV B

# 13



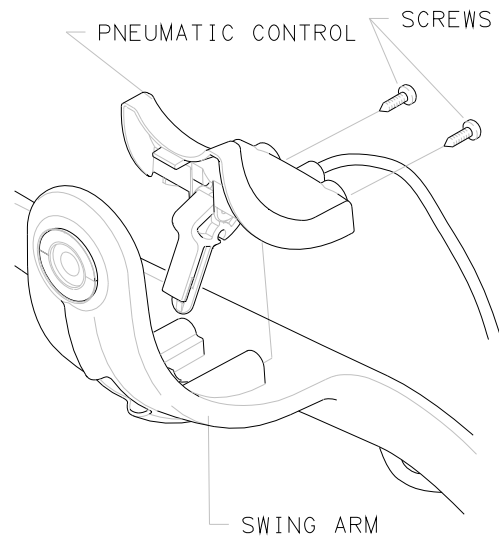
## TO REMOVE :

1. Slide right hand swing arm / arm yoke from hex shaft on tilt. properly dispose of swing arm / arm yoke.

## TO REINSTALL :

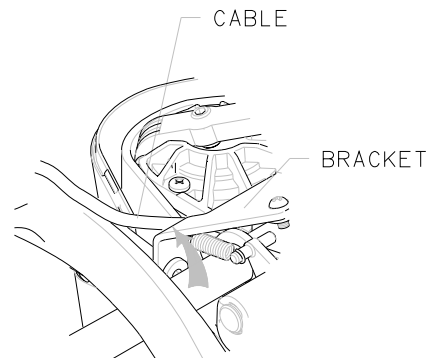
1. Slide replacement swing arm/arm yoke on to tilt hex shaft.
2. Refer to reinstallation in step 11 to attach pneumatic actuator.

# 14

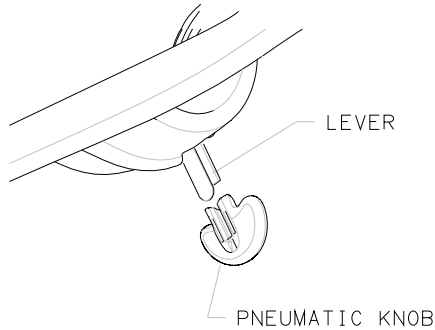


## TO REINSTALL :

1. ROUTE CABLE FROM TILT AS SHOWN, BEHIND BRACKET, AND INSERT PNEUMATIC CONTROL END INTO SWING ARM. SECURE WITH (2) SCREWS PROVIDED USING #2 PHILLIPS HEAD SCREWDRIVER.



# 15



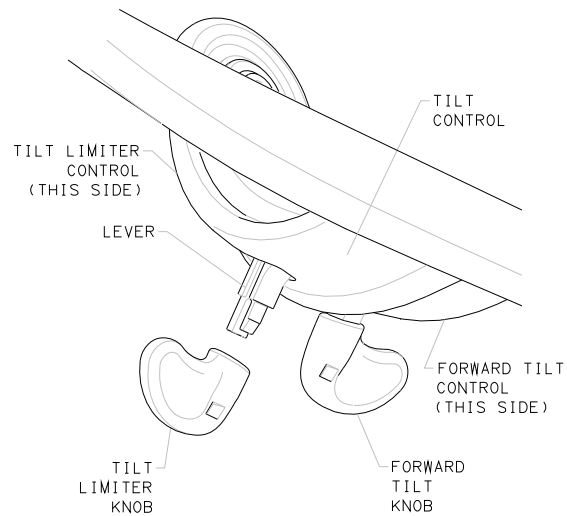
TO REINSTALL :

1. INSERT NEW KNOB ON LEVER. PUSH UNTIL IT "SNAPS" INTO PLACE.

# 16 a

NOTICE  
IF CHAIR IS EQUIPPED WITH NO TILT OPTIONS,  
GO ONTO STEP 17a,b, & 18.

FOR CHAIRS MANUFACTURED  
BEFORE 8-23-2004



TO REMOVE :

1. Using pliers, cut above knob(s) to separate knob from lever. Properly dispose of knob/s.

1B1KCS REV B

# 16 b

FOR CHAIRS MANUFACTURED  
AFTER 8-23-2004

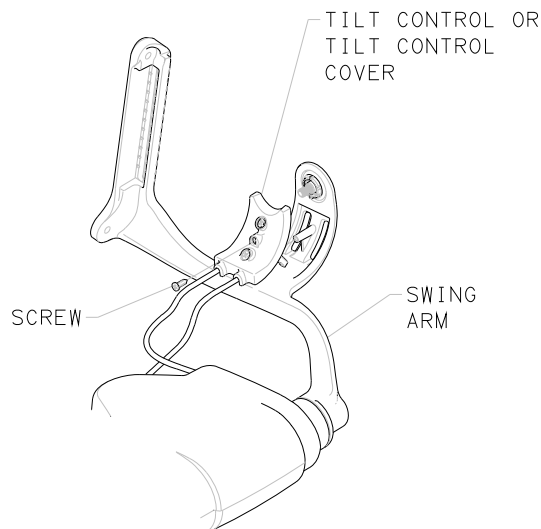
TO REMOVE :

1. Using hands, pull knob/s from control lever/s. Properly dispose of knob/s.

TO REINSTALL :

1. Push on appropriate knob/s until they click into place.

# 17 a



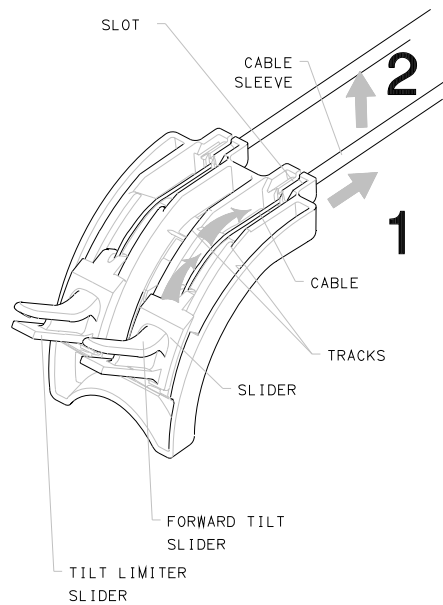
TO REMOVE :

1. Using #2 phillips head screwdriver, remove and set aside fastener securing tilt control to swing arm. Keep this screw isolated.

TO REINSTALL :

1. Place tilt control on swing arm and secure with screw using #2 phillips head screwdriver.

# 17<sub>b</sub>

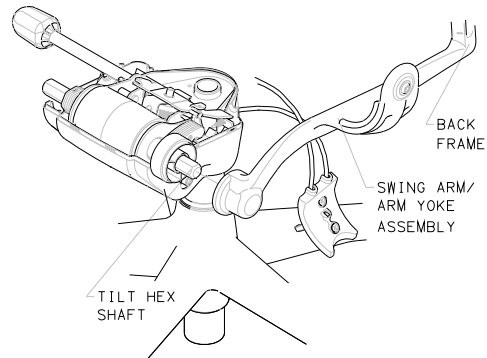


## MODIFYING TILT CONTROL :

Modify tilt control to accommodate chair options. If chair is fully optioned, no action is required. If chair is only equipped with tilt limiter, remove forward tilt cable and lever. If tilt was equipped with no options, remove both levers and cables.

1. Pull cable sleeve out from control housing, followed by pulling cable through slot.
2. Slide slider to open end of track and out. Properly dispose of slider and cable.

# 18



## TO REMOVE :

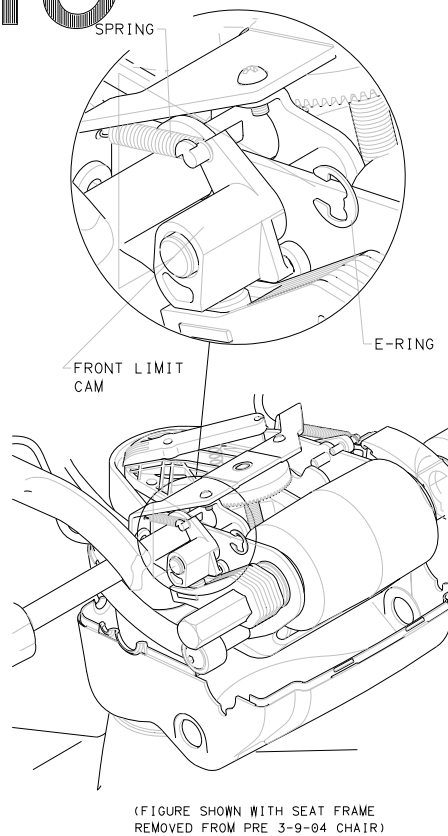
1. Slide left hand off swing arm/arm yoke assembly from tilt hex shaft.

## TO REINSTALL :

1. Slide on replacement swing arm/arm yoke assembly to tilt hex shaft. Align orientation of swing arm to position of back frame. Refer back to each step in the opposite order to reassemble chair.

1B1KCS REV B

# 19



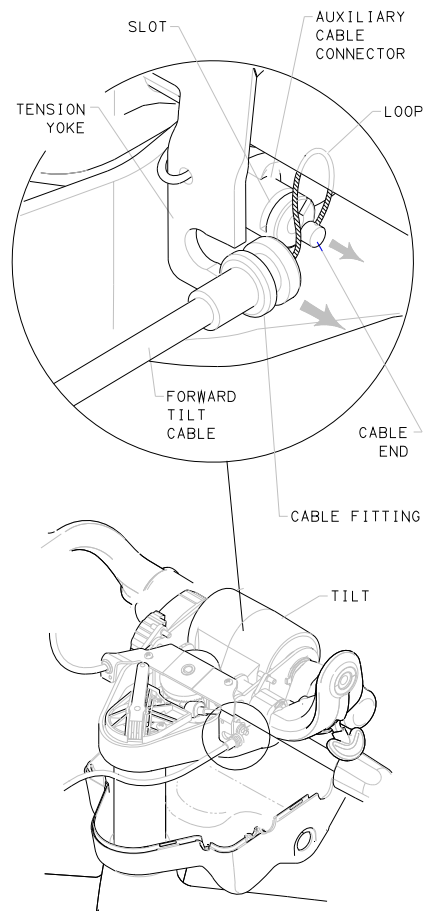
## TO REMOVE :

1. Using needle nose pliers, disengage spring from front limit cam. Using small straight head screwdriver remove E-ring holding front limit cam in place.

## TO REINSTALL :

1. Secure front limit cam with E-ring. Attach spring to front limit cam.

# 20<sub>a</sub>



(FIGURE SHOWN WITH SEAT FRAME REMOVED)



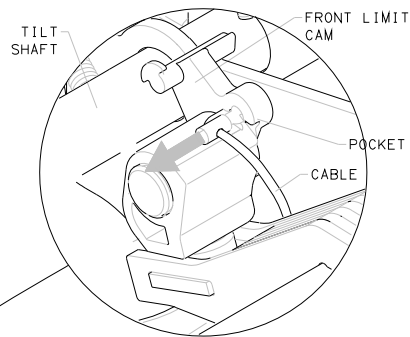
# 20<sup>b</sup>

(FOR CHAIRS MADE BEFORE 3-9-04)  
TO REMOVE:

1. Use thumb pressure to remove forward tilt cable fitting (RH side) from tension yoke on tilt. Move cable forward to create loop and disengage cable end from auxiliary cable connector.

TO REINSTALL:

1. See instructions to reinstall "chairs made after 3-09-04 on this page.

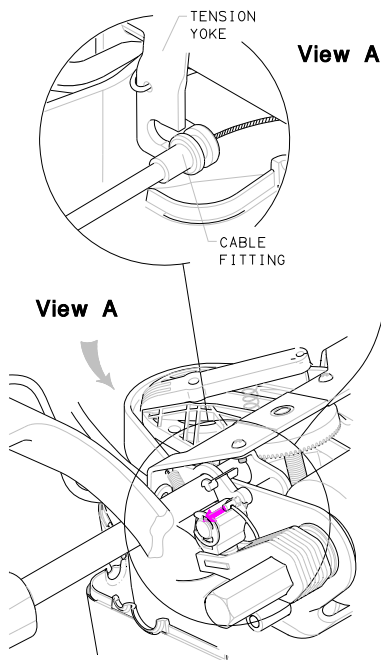


(FOR CHAIRS MADE AFTER 3-9-04)  
TO REMOVE:

1. Use thumb pressure to remove forward tilt cable fitting (RH side) from tension yoke on tilt. Move cable forward to provide slack. Using needle nose pliers, slide cable from pocket in front limit cam.

TO REINSTALL:

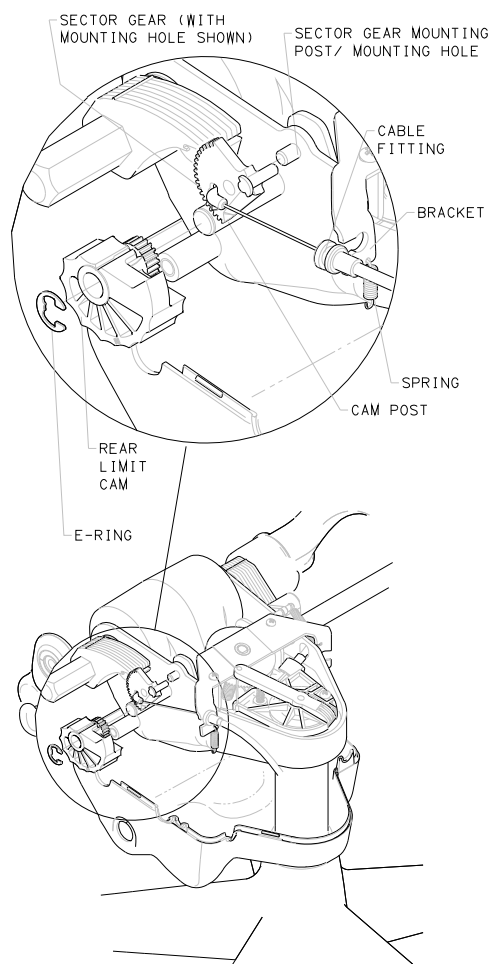
1. Feed cable end under tilt shaft along side tilt housing along right side of front limit cam. Insert cable end into pocket on top of front limit cam. Wrap cable around rear of front limit cam, clockwise.
2. Using thumb pressure install replacement cable fitting into tension yoke on tilt.



(FOR CHAIRS MADE AFTER 3-9-04)

1B1KCS REV B

# 21a



## TO REMOVE :

1. Tilt limiter must be in released position (tilt limiter lever all the way down.) Using small needle nose pliers, remove spring from sector gear and let hang down.
2. Using small straight head screwdriver, remove e-ring securing rear limit cam and set aside. Remove rear limit cam and set aside. Remove sector gear, with cable attached, from sector gear post and let hang.

## TO REINSTALL :

1. Slide sector gear and attached tilt limiter cable onto sector gear post/sector gear mounting hole. Attach spring to sector gear.
2. Slide rear limit cam on cam post, aligning timing marks on sector gear and rear limit cam. secure with e-ring.
3. Slide tilt limiter cable mounting flange into slot on end of tension yoke.

# 21<sub>b</sub>

L-SHAPED END

SECTOR GEAR

SPRING

TILT LIMITER CABLE

REAR LIMIT CAM

TIMING MARKS

## TO REINSTALL:

1. Slide sector gear and attached tilt limiter cable onto sector gear post/sector gear mounting hole. Attach spring to sector gear.
2. Slide rear limit cam on cam post, aligning timing marks on sector gear and rear limit cam. secure with e-ring.
3. Slide tilt limiter cable mounting flange into slot on end of tension yoke.

# 22

SECTOR GEAR  
W/MOUNTING HOLE  
(OLD VERSION)

KEY HOLE  
SLOT

L-SHAPED  
END

SECTOR GEAR  
W/MOUNTING POST  
(NEW VERSION)

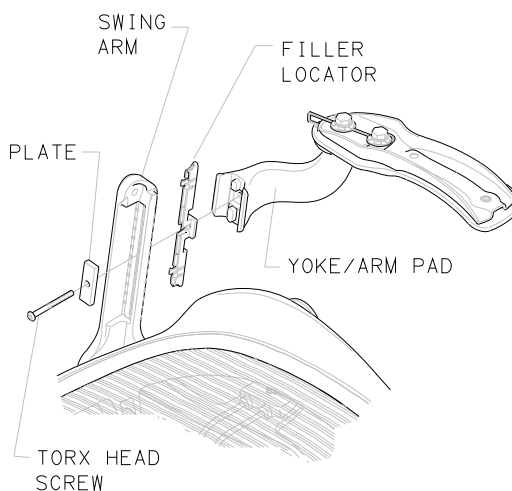
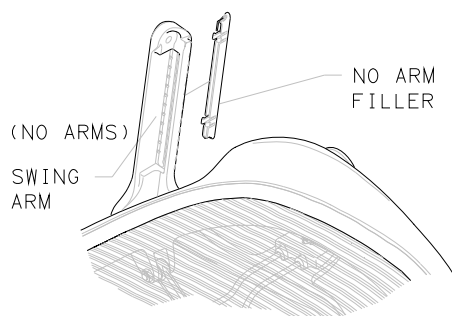
1B1KCS REV B

#### TO REINSTALL :

1. Select appropriate sector gear, one that pivots on post of tilt (older version) or one with integrrel pivoting post that inserts in tilt (newer version).
2. Insert L-shaped end of replacement tilt limiter cable into keyhole slot in replacement gear.

# 23

(FIXED ARMS)

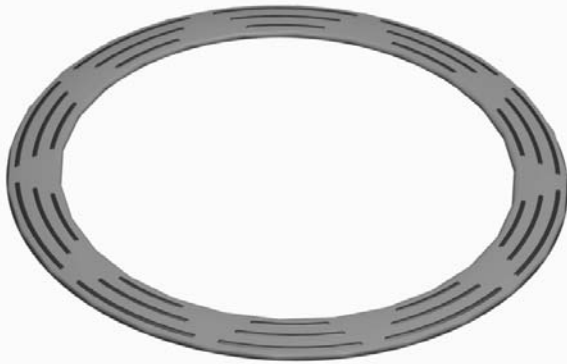


#### TO REMOVE/INSTALL :

1. Using phillips head screwdriver, push out no arm filler from swing arm and dispose of properly. Repeat for opposite side.
2. Snap into place filler locators into swing arm.
3. Install yoke/arm pad to swing arm with plate and torx head screw using T-27 torx bit and ratchet wrench. Repeat for opposite side.
4. Refer back to steps 6 -10, to complete reassembly.

# Aeron® Stool Foot Ring Cover Replacement

## PARTS INCLUDED:



Foot Ring Assembly  
(fasteners included)

1

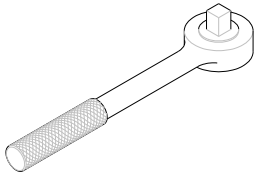


FOOT RING  
COVER  
SCREWS

1.1 Lay stool on it's back on clean soft material or carpeted surface.

1.2 Using #2 Phillips screwdriver, remove and discard (10) screws securing foot ring cover to foot ring.

## TOOLS REQUIRED:



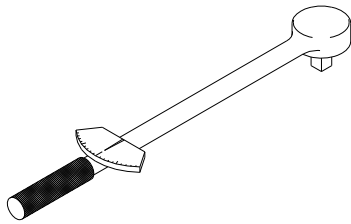
Ratchet



6 mm Hex Bit



5 mm Hex Bit

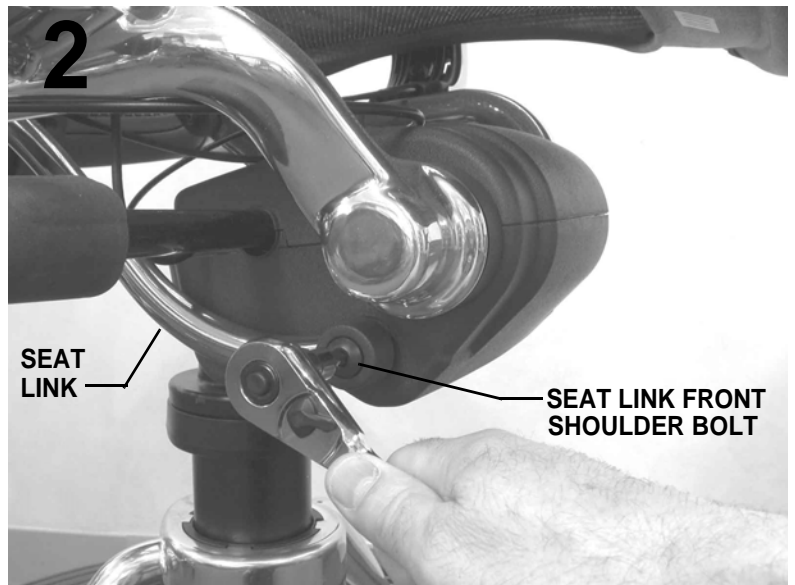


Torque Wrench



#2 Phillips Screwdriver

2



SEAT  
LINK

SEAT LINK FRONT  
SHOULDER BOLT

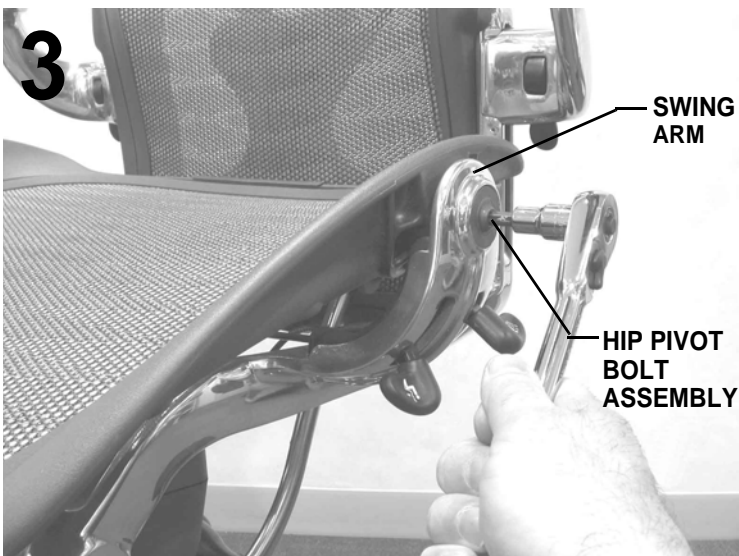
**NOTE:** To avoid any potential damage to pneumatic cylinder internal components, set stool height to it's lowest setting before beginning service procedure.

2.1 Return stool to upright position. Using ratchet and 6 mm hex bit, remove and save seat link front shoulder bolt securing seat link to tilt housing.

2.2 Repeat step 2.1 for opposite seat link.



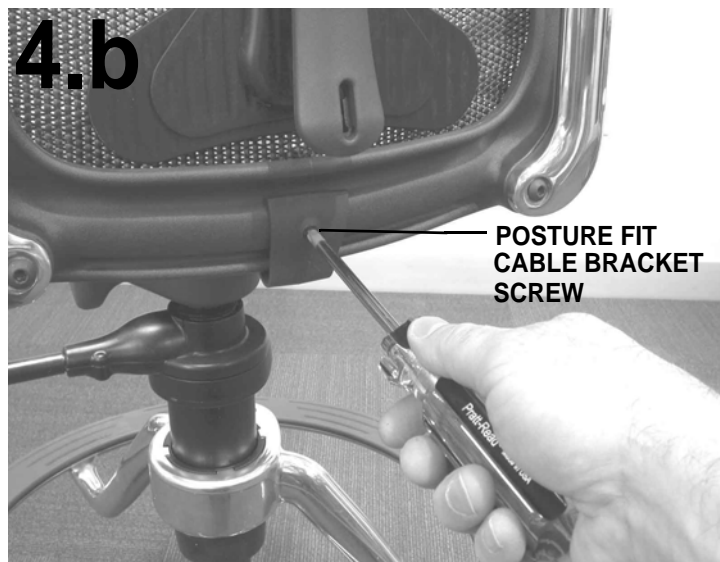
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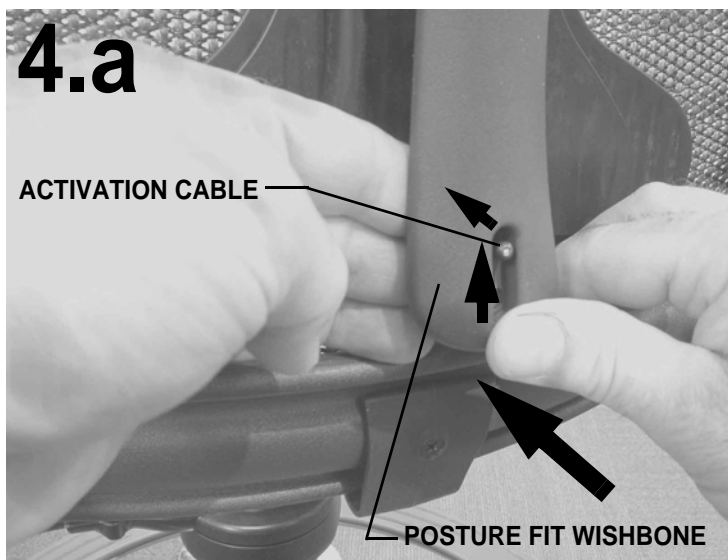
- 3.1 Using 6 mm hex bit, unthread hip pivot bolt assembly from seat frame. Unthreading of first hip pivot bolt will force hip pivot bolt assembly to dislodge from swing arm. Set hip pivot bolt assembly aside,
- 3.2 Unthread opposite hip pivot bolt assembly while supporting free side of seat frame.
- 3.3. Remove seat assembly with seat links and set it aside.

4.2 Press in on wishbone to dislodge end of activation cable from keyhole slot in wishbone.

4.3 Slide activation cable up and disengage cable from wishbone by sliding cable out of wishbone.

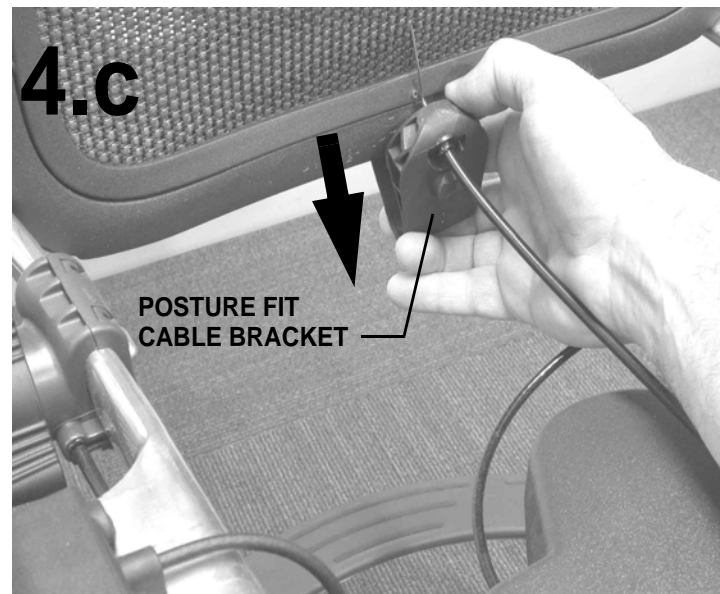


4.4 Using Phillips screwdriver, remove and save screw securing Posture Fit cable bracket to chair back frame.

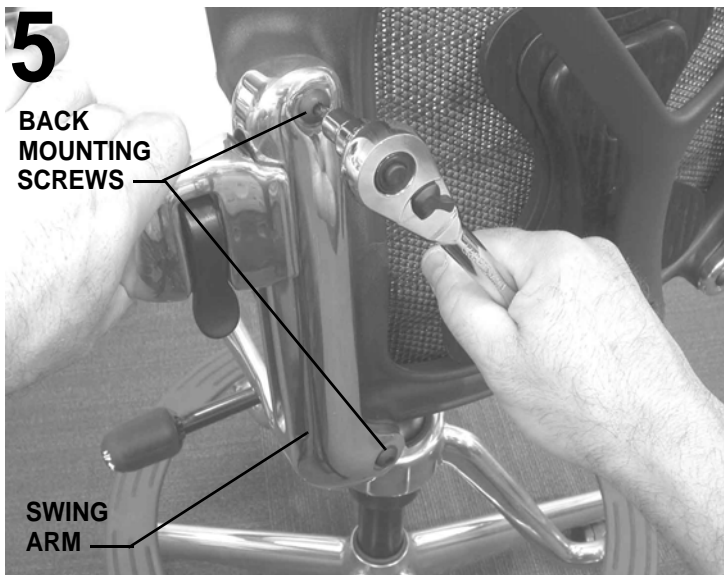


**NOTE:** For any chairs without posture fit lumbar option, proceed to step 5.

4.1 Set Posutre Fit lumbar tension to it's lightest setting to move lumbar pad away from seat back.



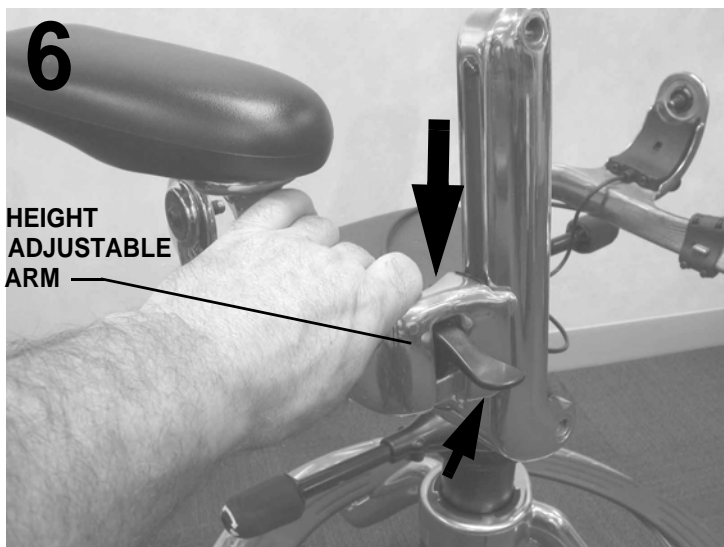
4.5 Grasp Posture Fit cable bracket and remove it from chair back frame. Allow cable end to pull free from pellicle material and let cable and bracket hang free.



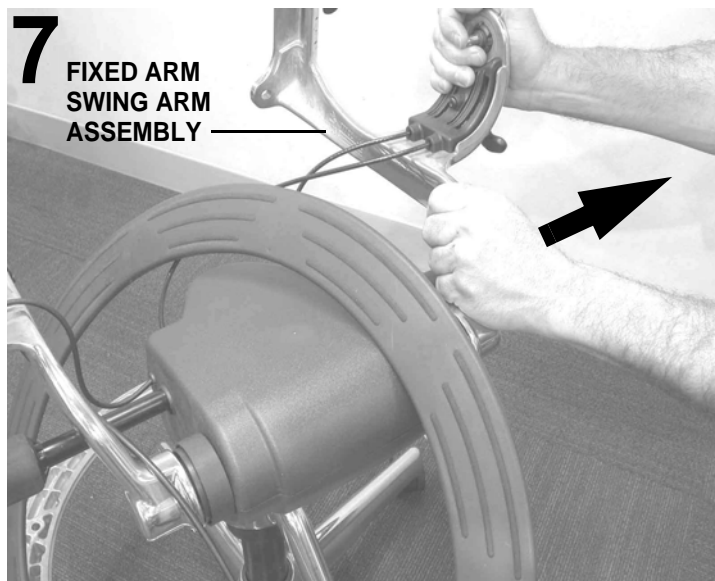
5.1 Using ratchet and 5 mm hex bit, remove and save (4) back mounting screws, securing back assembly to swing arms.

5.2 Remove back assembly from swing arms and set it aside

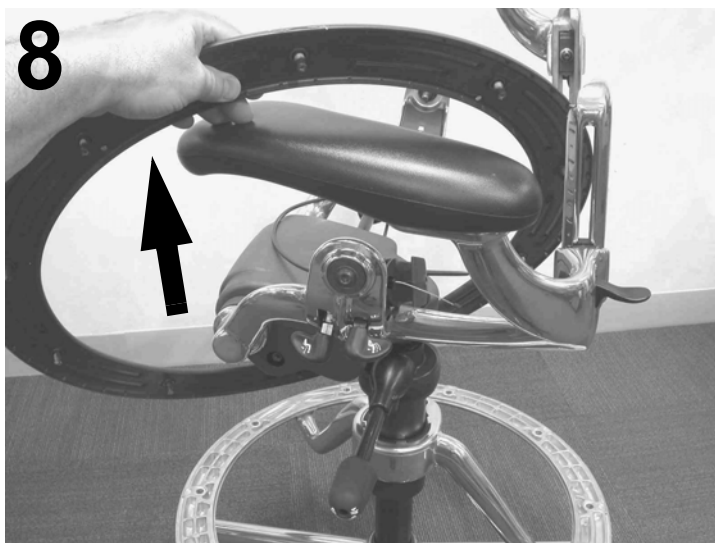
**NOTE:** Either step 6 or 7 is acceptable method of providing clearance for removal of foot ring cover over upper portion of chair.



6.1 On chairs with height adjustable arms, loosen one arm and set it to lowest height position to allow clearance for foot ring cover removal



7.1 On chairs with fixed arms, temporarily remove (1) swing arm by sliding arm off hex shaped swing arm shaft.



8.1 Position one side of foot ring cover up under lower tilt cover and lift the opposite side over upper portion of chair.

8.2 Dispose of old foot ring cover properly.

8.3 Install replacement foot ring cover in reverse sequence of step 8.1 and secure foot ring cover to foot ring with screws provided.

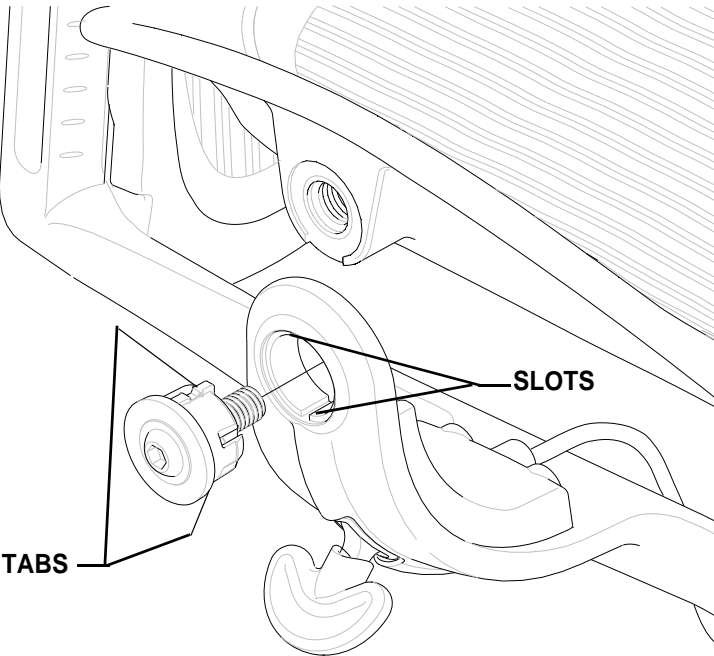


# Reassembly Notes:

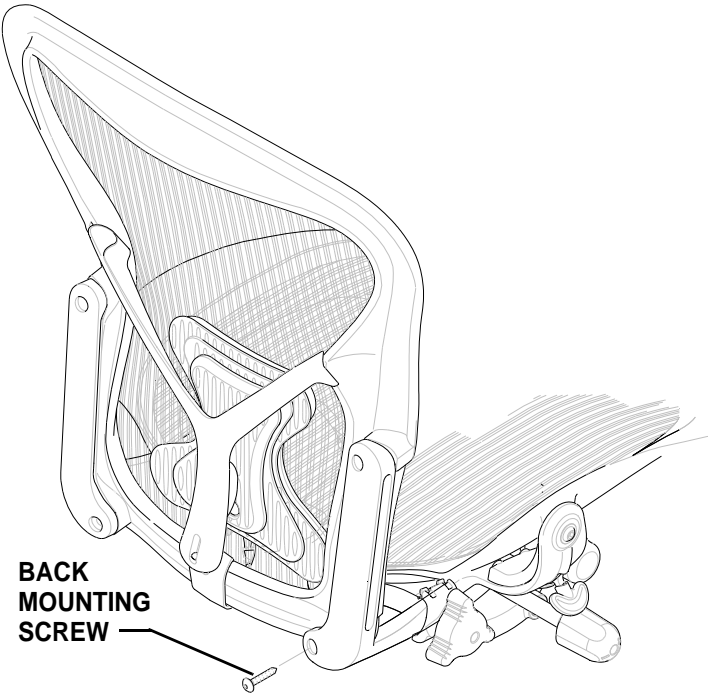
Reverse disassembly steps, referring to figures and sequence as necessary, and as noted below.

**NOTE:** Make sure noted fasteners are torqued to values specified. Failure to comply can cause unsafe usage of product.

**NOTE:** Use caution when reinstalling back mounting screws to avoid damaging threads in chair back. Failure to comply can result in damage to product



When reinstalling dislodged hip pivot bolt assembly make sure (2) small tabs on outside of assembly engage (2) small slots in swing arm. Retightening of bolt will draw hip pivot assembly back into swing arm



# Fastener Torque Values:

FASTENER DESC.	TORQUE
HIP PIVOT BOLT ASSEMBLY	180 -200 IN-LBS
BACK MOUNTING SCREWS	70 -100 IN-LBS
SEAT LINK SHOULDER BOLT	120 -150 IN-LBS



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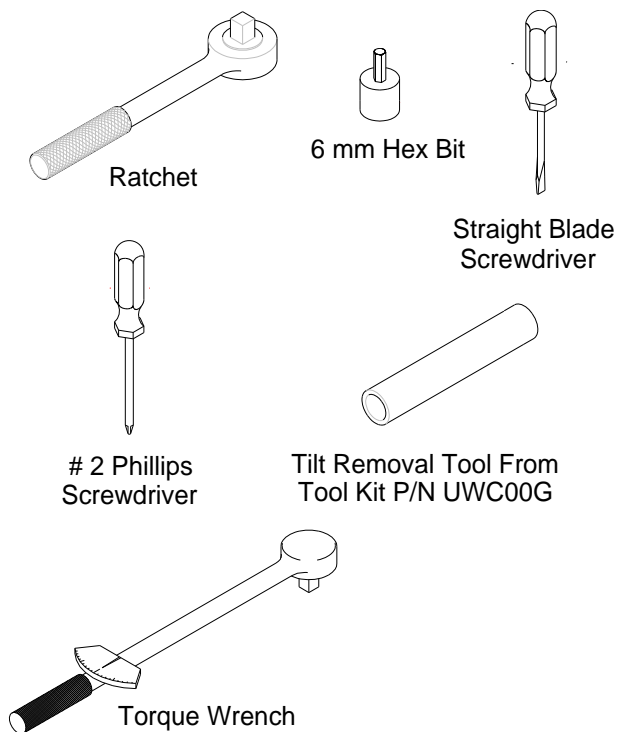
# Aeron® Stool Foot Ring Replacement

## PARTS INCLUDED:

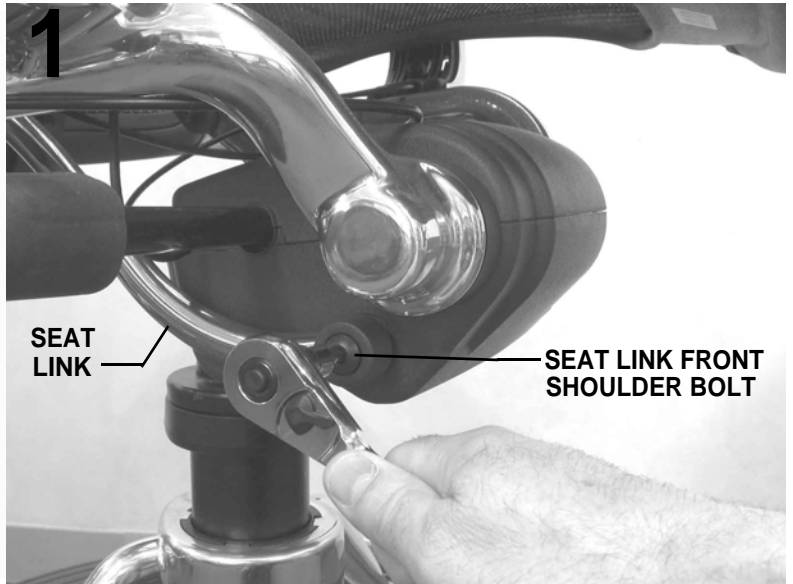


Foot Ring Subassembly

## TOOLS REQUIRED:



**NOTE:** To help minimize risk of damaging pneumatic cylinder internal components, set stool height to it's lowest setting before beginning service procedure.

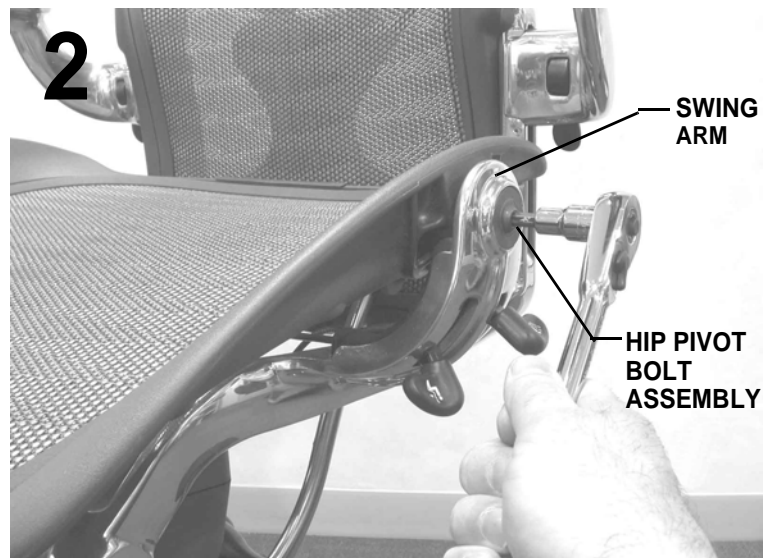


SEAT LINK

SEAT LINK FRONT SHOULDER BOLT

1.1 Using ratchet and 6 mm hex bit, remove and save seat link front shoulder bolt, securing seat link to tilt housing.

1.2 Repeat step 1.1 for opposite seat link.



2

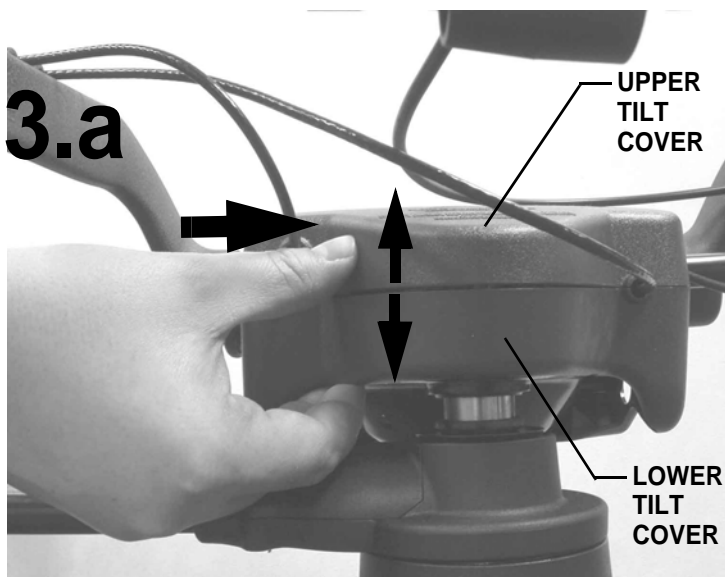
SWING ARM

HIP PIVOT BOLT ASSEMBLY

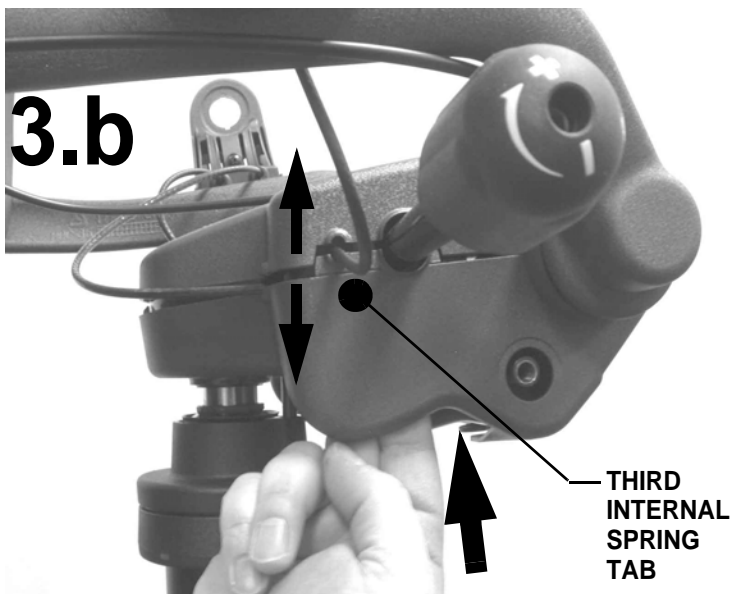
2.1 Using 6 mm hex bit, unthread hip pivot bolt assembly from seat frame. Unthreading of first hip pivot bolt will force hip pivot bolt assembly to dislodge from swing arm. Set hip pivot bolt assembly aside.

2.2 Unthread opposite hip pivot bolt assembly while supporting free side of seat frame.

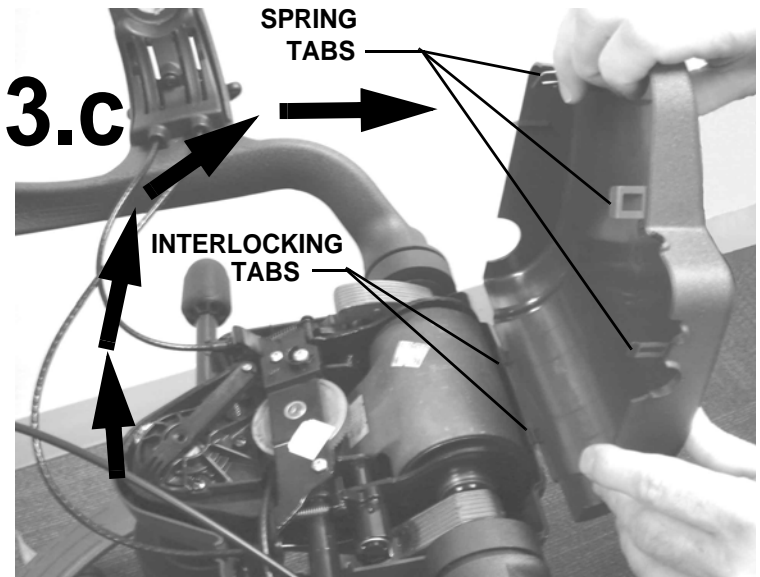
2.3 Remove seat assembly with links and set it aside.



**3.a.1** On left side of tilt covers, press in on upper tilt cover with thumb, while holding lower cover with fingers, as shown. This will shift upper cover and dislodge 2 of 3 internal spring tabs securing covers together. As upper cover shifts and tabs disengage, push upper cover up with thumb, to begin separation of covers.

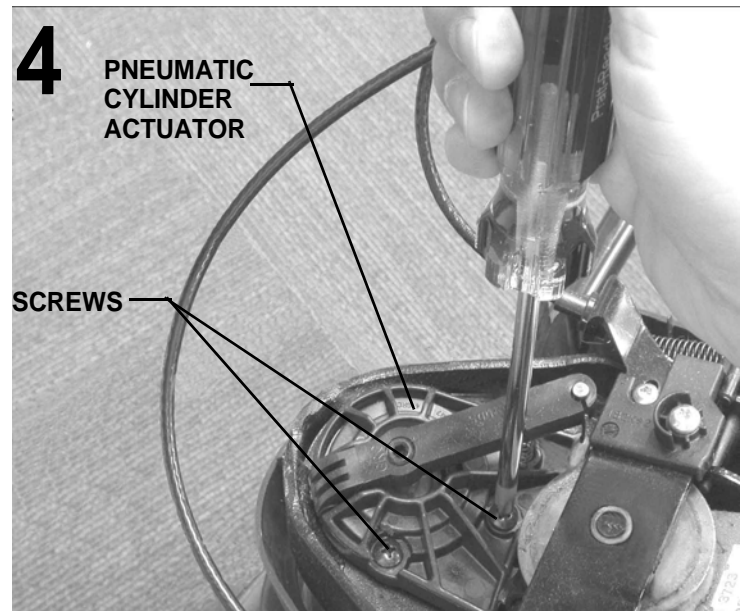


**3.b.1** At right side of tilt covers, insert finger(s) behind lower cover, as shown, and disengage third and last spring tab



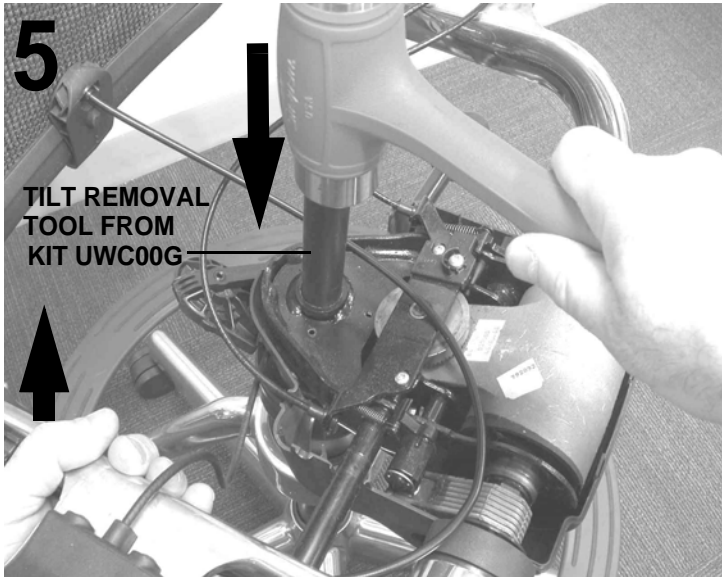
**3.c.1** With all internal spring tabs disengaged, rotate upper tilt cover forward to disengage (2) interlocking tabs at front of covers.

**3.c.2** Remove upper cover and set it aside.



**4.1** Using #2 Phillips screwdriver, remove and save (2) screws securing pneumatic cylinder actuator to top of tilt.

**4.2** Remove actuator from top of tilt and let it hang free.



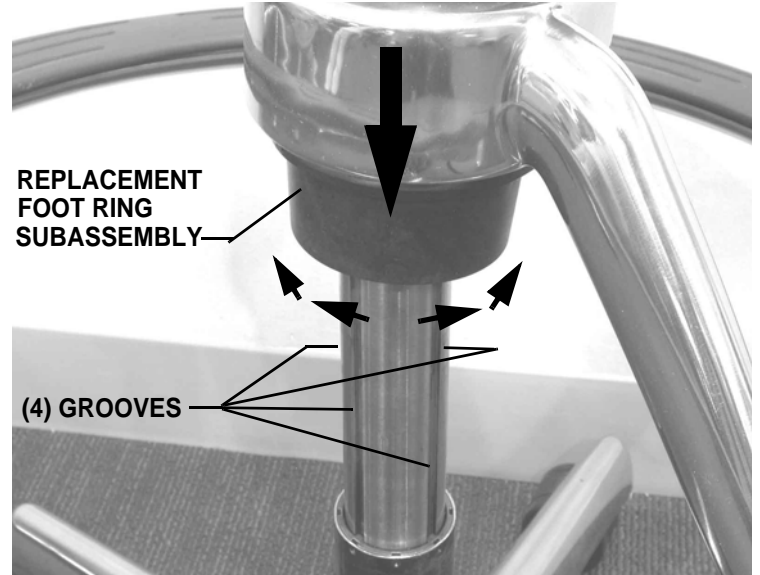
5.1 Place tilt removal tool from kit, onto top of pneumatic cylinder with hole in end of tool towards cylinder.

5.2 Support stool slightly off floor by swing arm(s) and strike removal tool sharply with a 2-lb hammer until tilt is unseated from end of pneumatic cylinder.

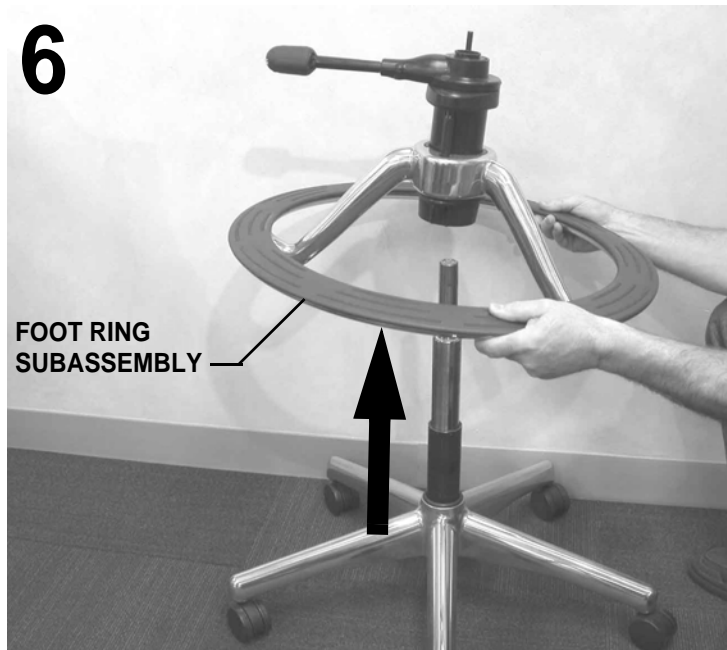
5.3 Set upper portion of chair aside on padded surface.

## Reassembly Notes:

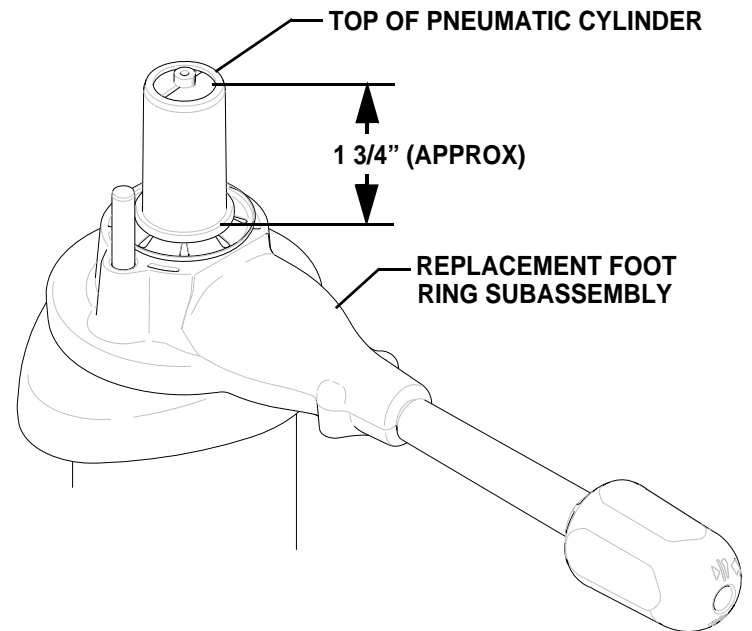
Reverse disassembly steps, referring to figures and sequence as necessary, and as noted below.



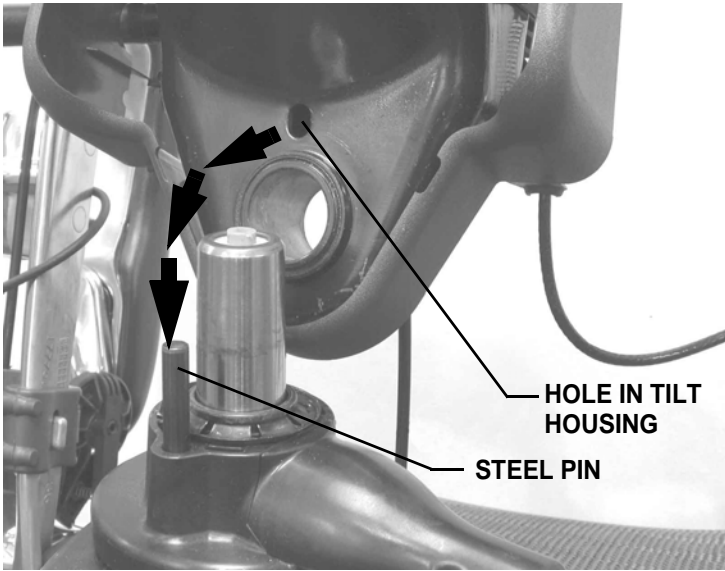
When installing replacement foot ring subassembly, rotate subassembly to engage (4) internal guides into (4) grooves in pneumatic cylinder.



6.1 Remove foot ring subassembly from pneumatic cylinder and dispose of it properly.



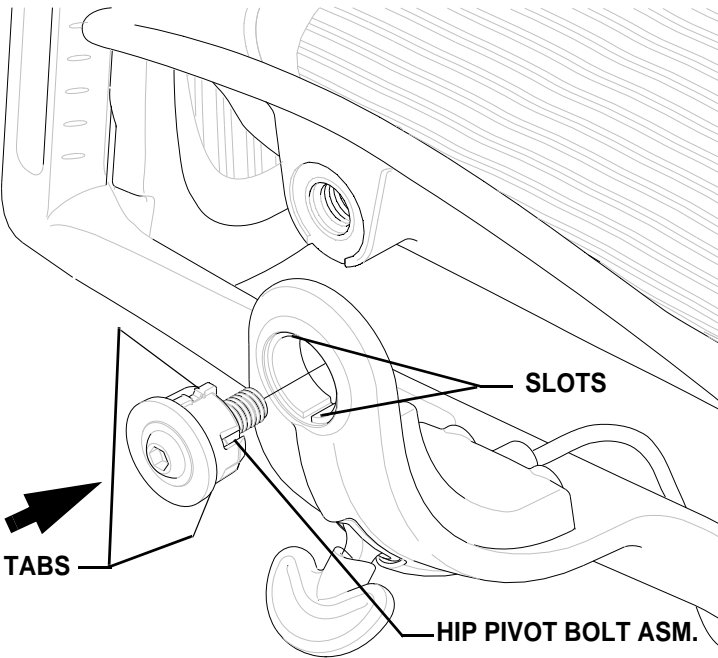
After installing foot ring subassembly, check to ensure subassembly is fully seated on pneumatic cylinder. Refer to dimension noted in figure above to confirm



When reinstalling upper portion of stool to foot ring sub-assembly, hole in bottom of tilt housing must engage steel pin on foot ring subassembly.

**NOTE:** reseating of tilt assembly to pneumatic cylinder is acheived by sitting in chair after reassembly is completed.

**NOTE:** make sure noted fasteners are torqued to values specified. Failure to comply can cause unsafe usage of product.



When reinstalling dislodged hip pivot bolt assembly make sure (2) small tabs on outside of assembly engage (2) small slots in swing arm. Retightening of bolt will draw hip pivot assembly back into swing arm

## Fastener Torque Values:

FASTENER DESC.	TORQUE
HIP PIVOT BOLT ASSEMBLY	180 -200 IN-LBS
SEAT LINK SHOULDER BOLT	120 -150 IN-LBS

# Aeron® Stool Gearbox Replacement

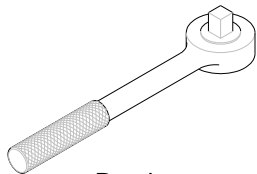
## PARTS INCLUDED:

Push Nut fastener

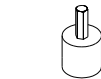


gearbox Assembly

## TOOLS REQUIRED:



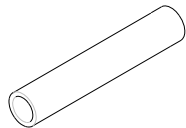
Ratchet



6 mm Hex Bit



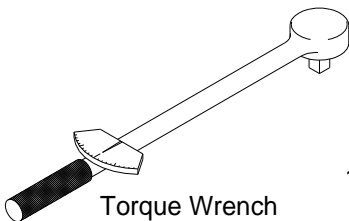
#2 Phillips  
Screwdriver



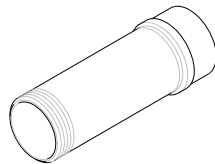
Herman Miller Tilt Removal  
Tool From Kit No UWC00G



Straight Head  
Screwdriver

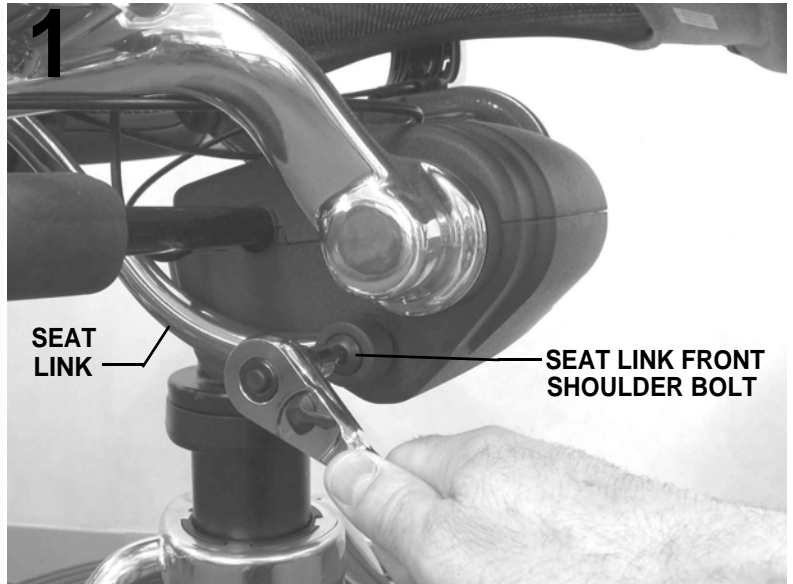


Torque Wrench



1 1/2" Dia. X 4" long Standard  
Pipe Nipple W/End Cap

**NOTE:** To help minimize risk of damaging pneumatic cylinder internal components, set stool height to it's lowest setting before beginning service procedure.



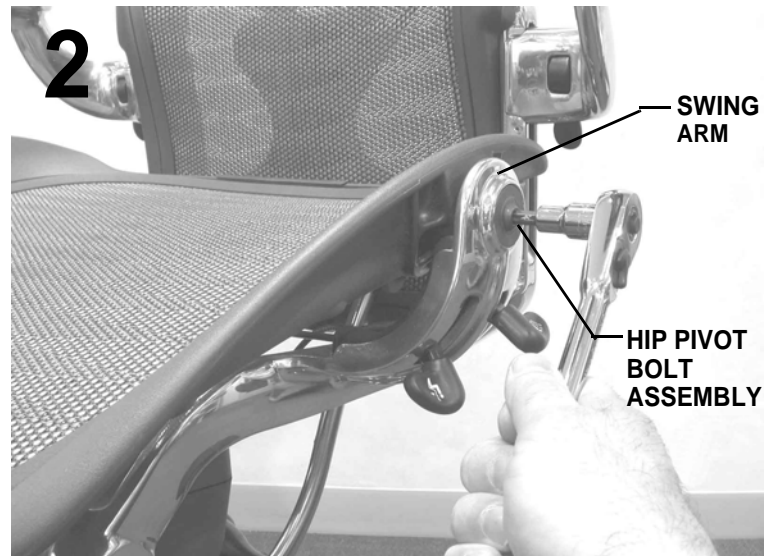
1

SEAT  
LINK

SEAT LINK FRONT  
SHOULDER BOLT

1.1 Using ratchet and 6 mm hex bit, remove and save seat link front shoulder bolt, securing seat link to tilt housing.

1.2 Repeat step 1.1 for opposite seat link.



2

SWING  
ARM

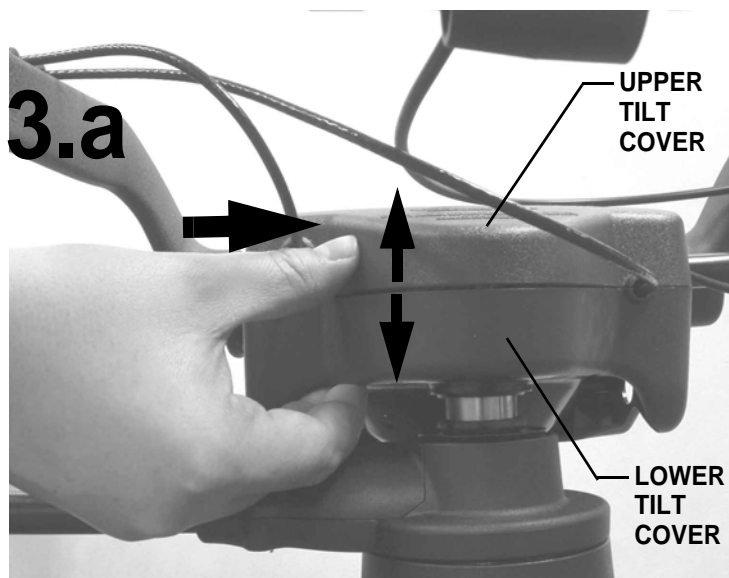
HIP PIVOT  
BOLT  
ASSEMBLY

2.1 Using 6 mm hex bit, unthread hip pivot bolt assembly from seat frame. Unthreading of first hip pivot bolt will force hip pivot bolt assembly to dislodge from swing arm. Set hip pivot bolt assembly aside.

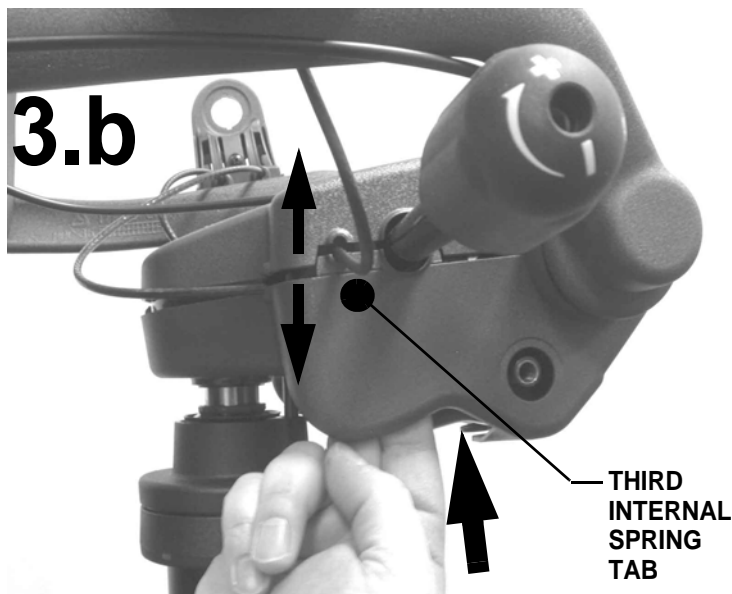
2.2 Unthread opposite hip pivot bolt assembly while supporting free side of seat frame.

2.3 Remove seat assembly with links and set it aside.

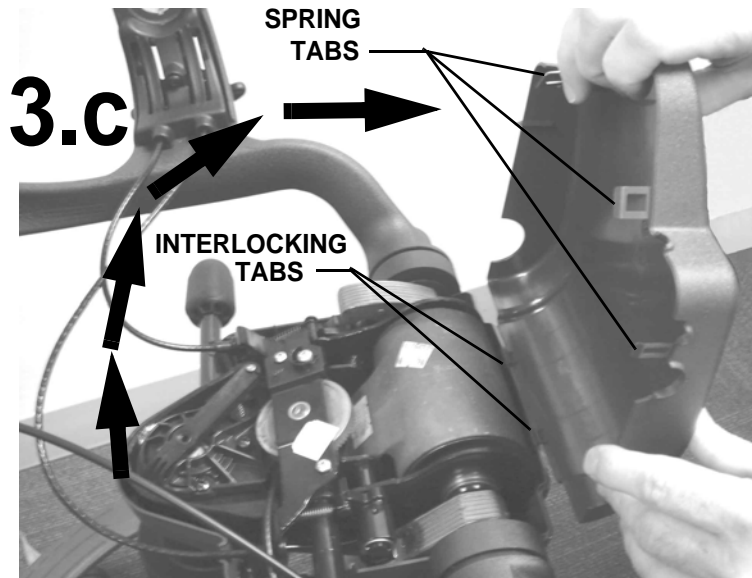




**3.a.1** On left side of tilt covers, press in on upper tilt cover with thumb, while holding lower cover with fingers, as shown. This will shift upper cover and dislodge 2 of 3 internal spring tabs securing covers together. As upper cover shifts and tabs disengage, push upper cover up with thumb, to begin separation of covers.

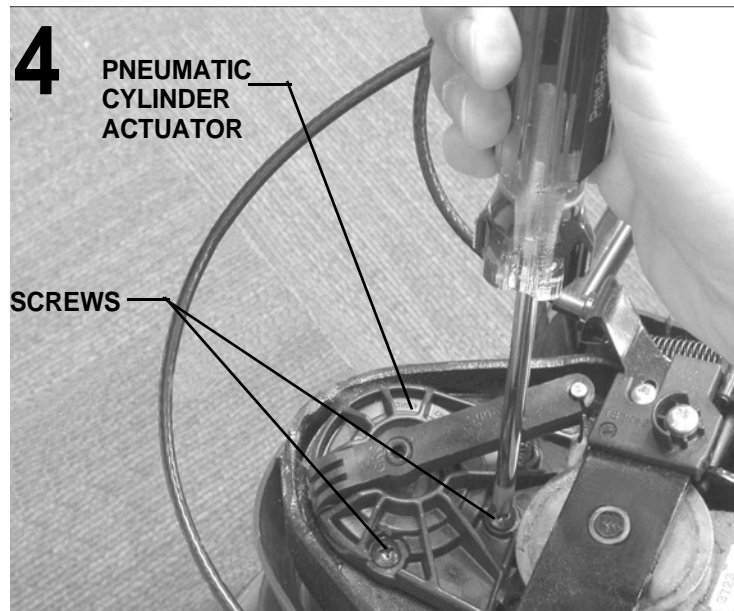


**3.b.1** At right side of tilt covers, insert finger(s) behind lower cover, as shown, and disengage third and last spring tab



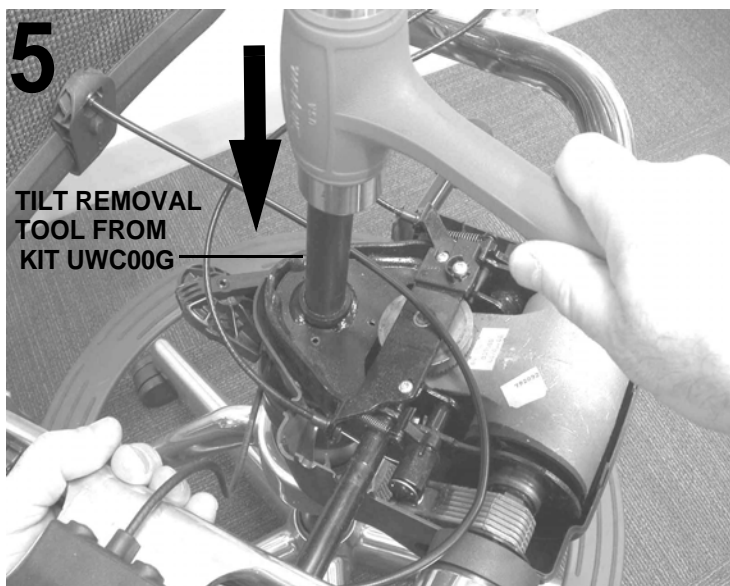
**3.c.1** With all internal spring tabs disengaged, rotate upper tilt cover forward to disengage (2) interlocking tabs at front of covers.

**3.c.2** Remove upper cover and set it aside.



**4.1** Using #2 Phillips screwdriver, remove and save (2) screws securing pneumatic cylinder actuator to top of tilt.

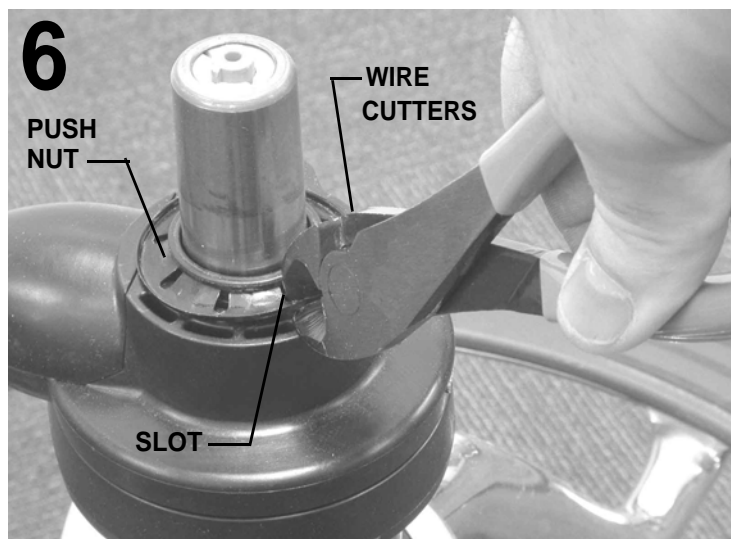
**4.2** Remove actuator from top of tilt and let it hang free.



5.1 Place tilt removal tool from kit, onto top of pneumatic cylinder with hole in end of tool towards cylinder.

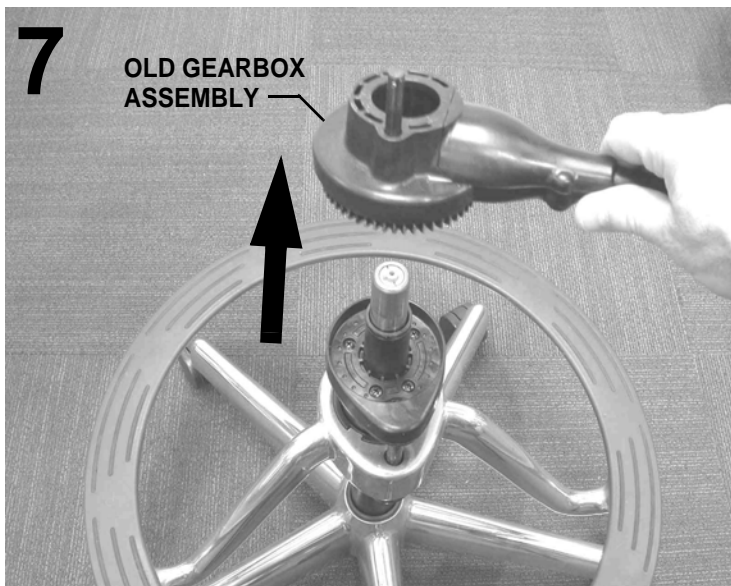
5.2 Support stool slightly off floor by swing arm(s) and strike removal tool sharply with a 2-lb hammer until tilt is unseated from end of pneumatic cylinder.

5.3 Set upper portion of chair aside on padded surface.

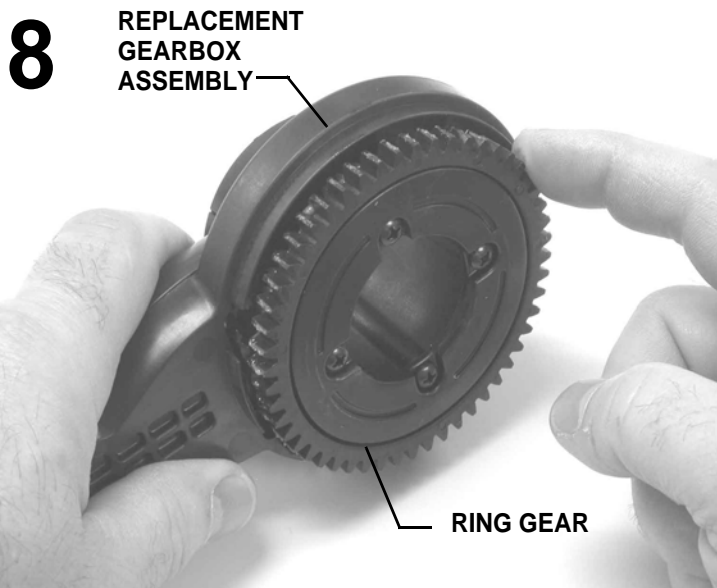


6.1 Locate push nut securing gearbox assembly to foot-ring subassembly. At any slot in push nut, snip through push nut to separate it.

6.2 Grasp free end of separated push nut with wire cutters and remove and discard it.



7.1 Remove old gearbox assembly from lower gear housing on foot ring assembly and dispose of it properly.

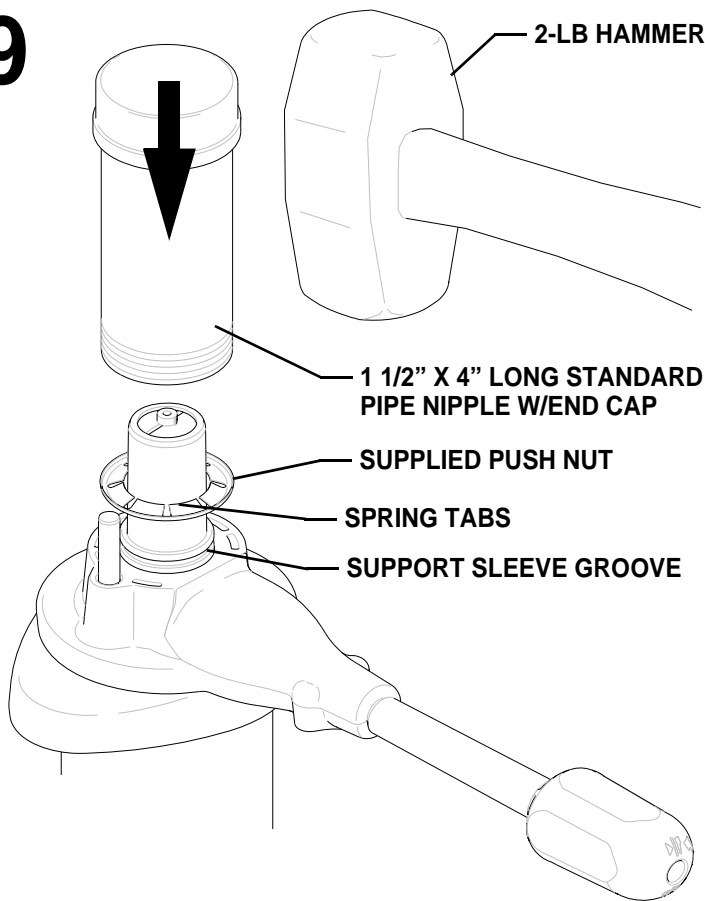


8.1 Apply a light coat of supplied lube to gearbox ring gear before installing gearbox assembly.

8.2 Before installing replacement gearbox, inspect small driven gear in lower housing on foot ring for damage or excessive wear. Replace as needed.

8.3 With supplied lube applied to ring gear, install replacement gearbox assembly onto foot ring sub-assembly.

9



9.1 Place supplied push nut onto support sleeve, with push nut spring tabs angling upward, as shown.

**CAUTION:** Use light striking force with tools noted. Excessive force may result in product damage.

9.2 Place a 1 1/2 inch diameter x 4 inch long standard pipe nipple w/end cap, onto push nut. Using 2-lb hammer, drive push nut down onto support sleeve until it is fully engaged in support sleeve groove. Make sure all spring tabs are engaged in groove.

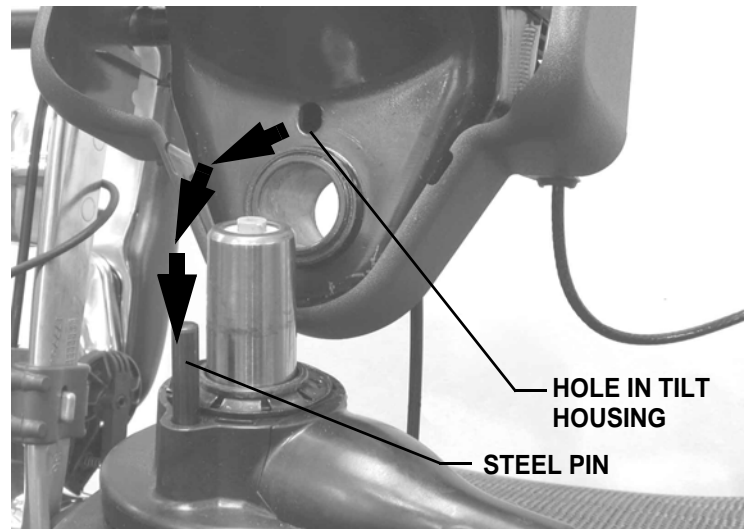
## Reassembly Notes:

Reverse disassembly steps, referring to figures and sequence as necessary, and as noted below.

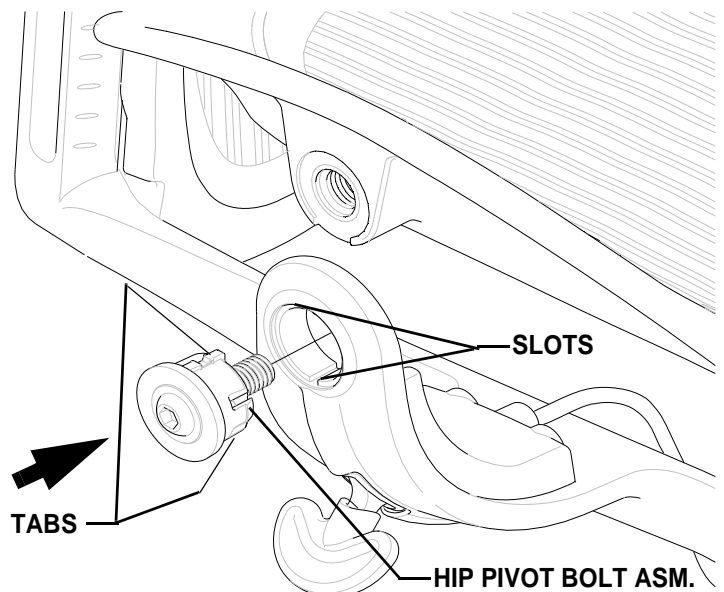
**NOTE:** Make sure noted fasteners are torqued to values specified. Failure to comply can cause unsafe usage of product.

## Fastener Torque Values:

FASTENER DESC.	TORQUE
HIP PIVOT BOLT ASSEMBLY	180 -200 IN-LBS
SEAT LINK SHOULDER BOLT	120 -150 IN-LBS



When reinstalling upper portion of stool to foot ring sub-assembly, hole in bottom of tilt housing must engage steel pin on gearbox assembly.



When reinstalling dislodged hip pivot bolt assembly make sure (2) small tabs on outside of assembly engage (2) small slots in swing arm. Retightening of bolt will draw hip pivot assembly back into swing arm.

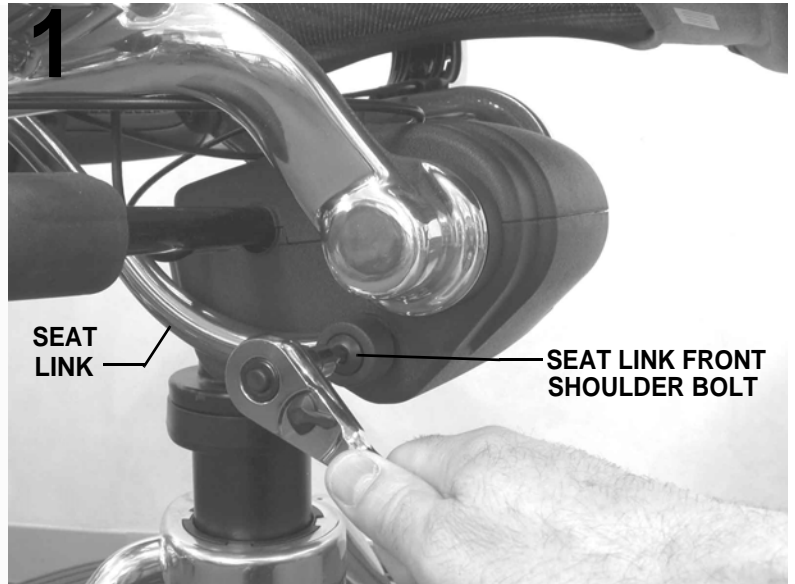


# Aeron® Stool Pneumatic Cylinder Replacement

## PARTS INCLUDED:



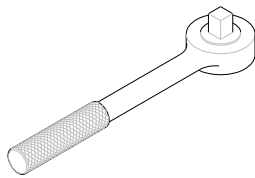
Pneumatic Cylinder Assembly



1.1 Using ratchet and 6 mm hex bit, remove and save seat link front shoulder bolt, securing seat link to tilt housing.

1.2 Repeat step 1.1 for opposite seat link.

## TOOLS REQUIRED:



Ratchet



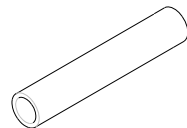
6 mm Hex Bit



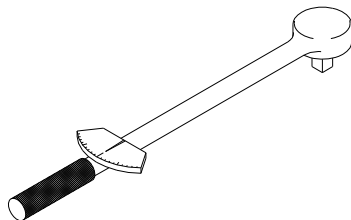
Straight Blade Screwdriver



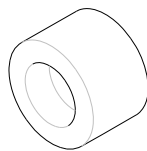
# 2 Phillips Screwdriver



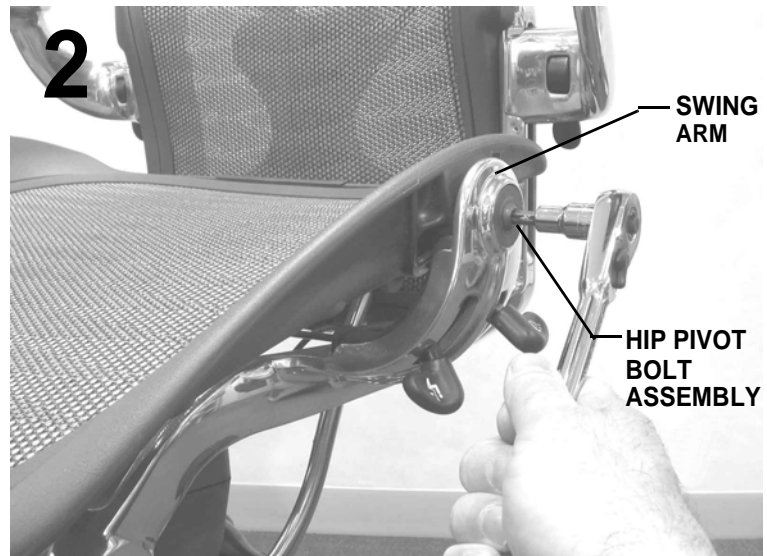
Tilt Removal Tool From Tool Kit P/N UWC00G



Torque Wrench



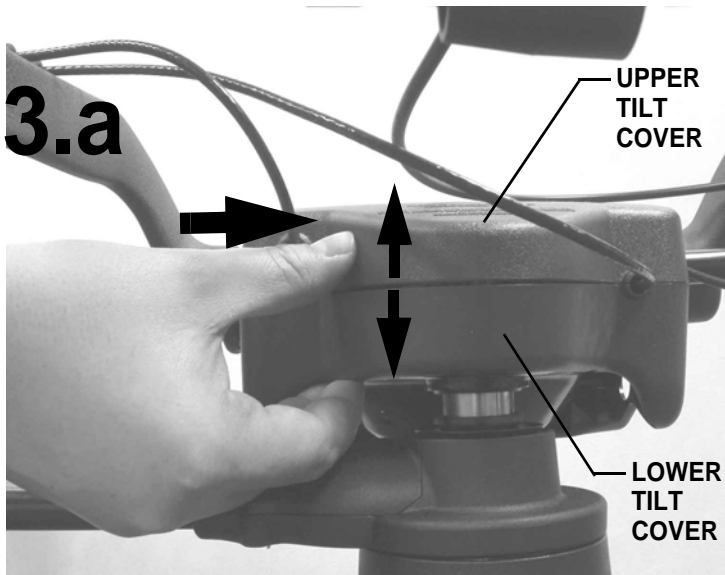
Base Removal Tool From Tool Kit P/N 254502



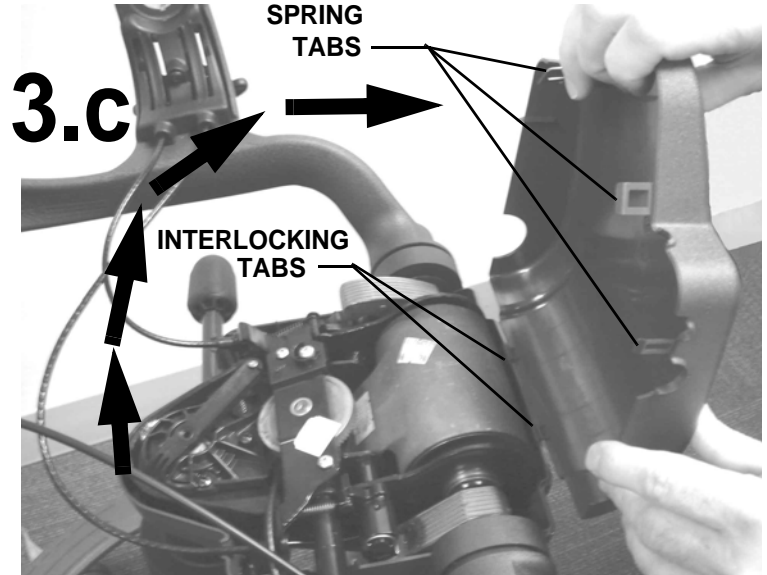
2.1 Using 6 mm hex bit, unthread hip pivot bolt assembly from seat frame. Unthreading of first hip pivot bolt will force hip pivot bolt assembly to dislodge from swing arm. Set hip pivot bolt assembly aside.

2.2 Unthread opposite hip pivot bolt assembly while supporting free side of seat frame.

2.3 Remove seat assembly with links and set it aside.

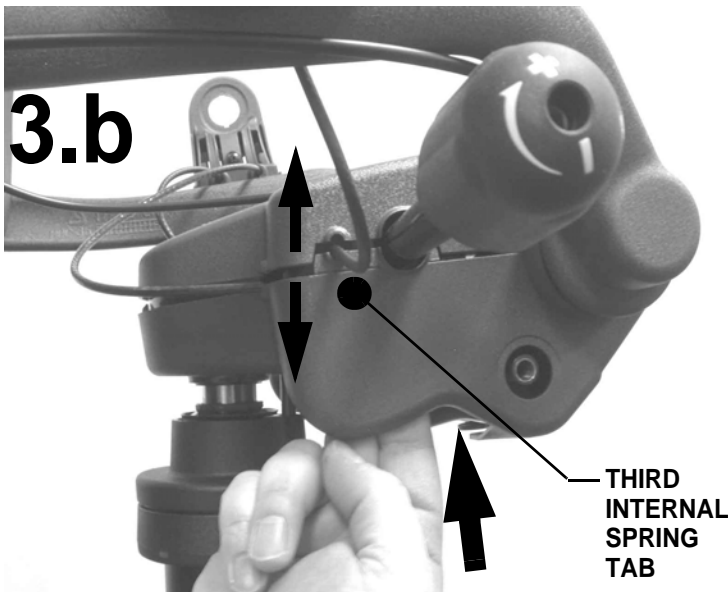


**3.a.1** On left side of tilt covers, press in on upper tilt cover with thumb, while holding lower cover with fingers, as shown. This will shift upper cover and dislodge 2 of 3 internal spring tabs securing covers together. As upper cover shifts and tabs disengage, push upper cover up with thumb, to begin separation of covers.

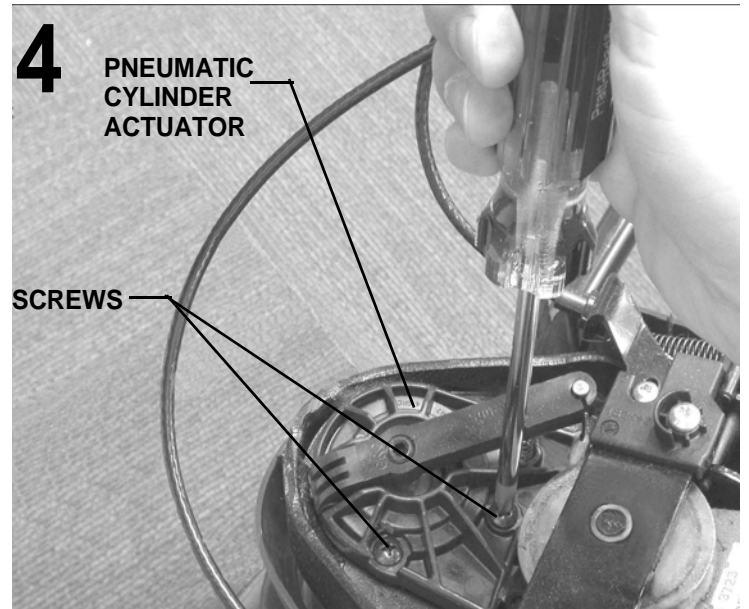


**3.c.1** With all internal spring tabs disengaged, rotate upper tilt cover forward to disengage (2) interlocking tabs at front of covers.

**3.c.2** Remove upper cover and set it aside.

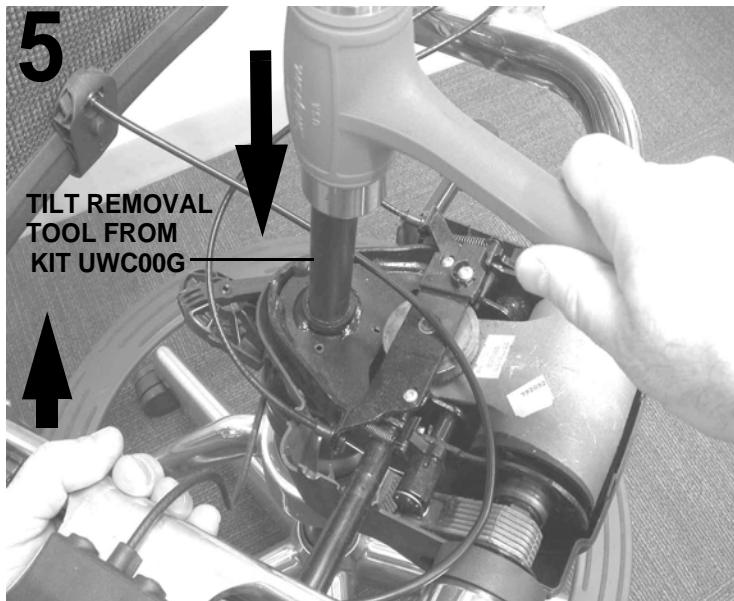


**3.b.1** At right side of tilt covers, insert finger(s) behind lower cover, as shown, and disengage third and last spring tab



**4.1** Using #2 Phillips screwdriver, remove and save (2) screws securing pneumatic cylinder actuator to top of tilt.

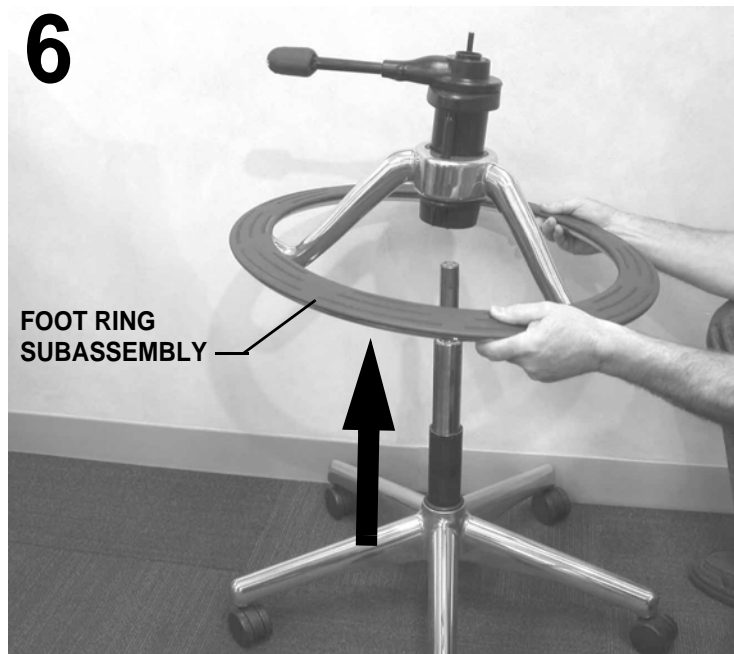
**4.2** Remove actuator from top of tilt and let it hang free.



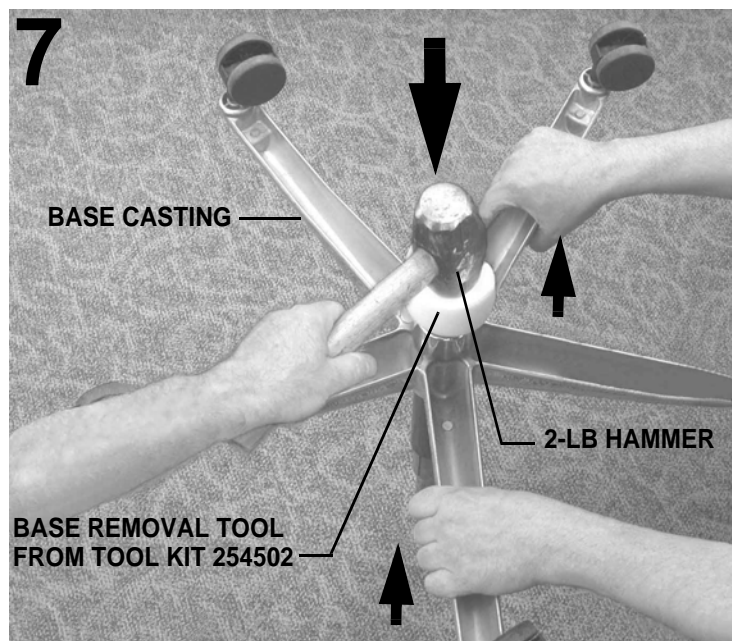
5.1 Place tilt removal tool from kit, onto top of pneumatic cylinder with hole in end of tool towards cylinder.

5.2 Support stool slightly off floor by swing arm(s) and strike removal tool sharply with a 2-lb hammer until tilt is unseated from end of pneumatic cylinder.

5.3 Set upper portion of chair aside on padded surface.



6.1 Remove foot ring subassembly from pneumatic cylinder and set it aside.



8.1 With assistance, support base assembly off floor. Place base removal tool from service tool kit 254502 over pneumatic cylinder canister as shown. Strike base removal tool with 2-lb hammer to remove pneumatic cylinder from base casting.

#### WARNING

Pneumatic cylinder contents are under extreme pressure. DO NOT puncture or incinerate cylinder. Dispose of old cylinders in a safe and proper manner. Follow all replacement instructions for cylinder service. Failure to comply can result in product damage or personal injury.

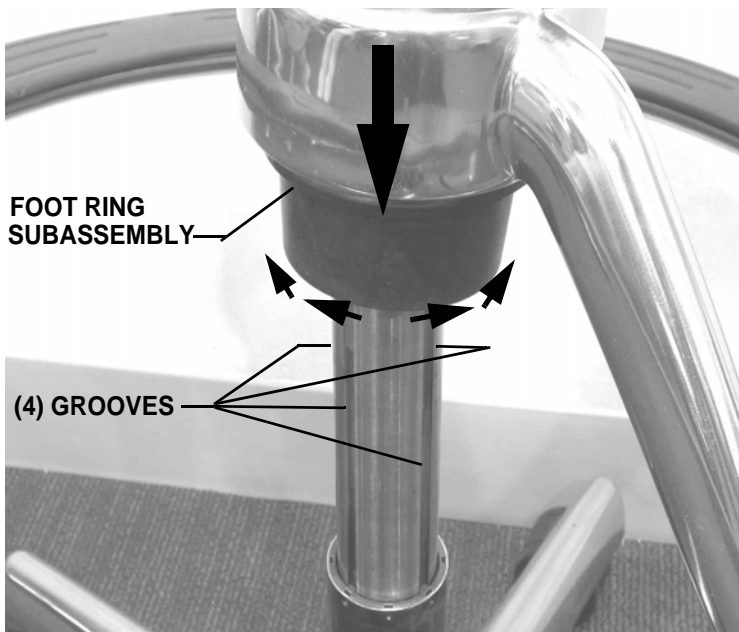
8.2 Dispose of pneumatic cylinder properly.

## Reassembly Notes:

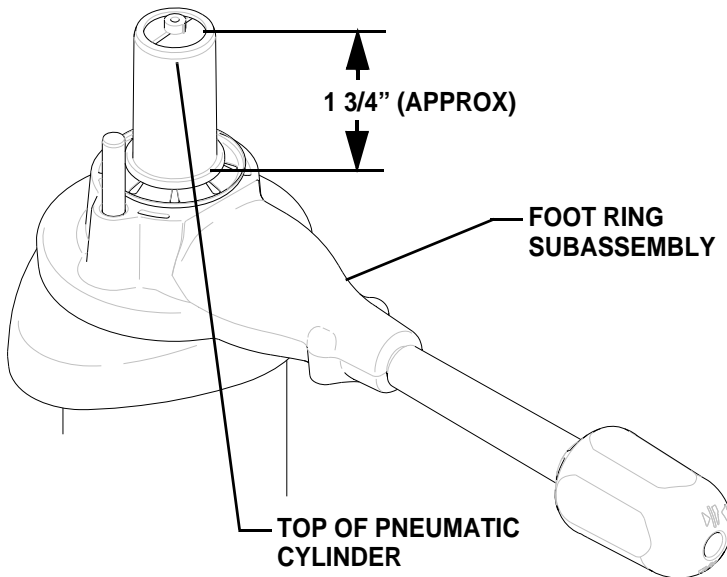
Place base assembly in upright position and install replacement pneumatic cylinder into base assembly.

**NOTE:** reseating of pneumatic cylinder to base and tilt assemblies is achieved by sitting in chair after reassembly of chair is complete. DO NOT strike pneumatic cylinder to reseat it to base or tilt.

Reverse disassembly steps, referring to figures and sequence as necessary, and as noted below.



When reinstalling foot ring subassembly, rotate sub-assembly to engage (4) internal guides into (4) grooves in pneumatic cylinder.

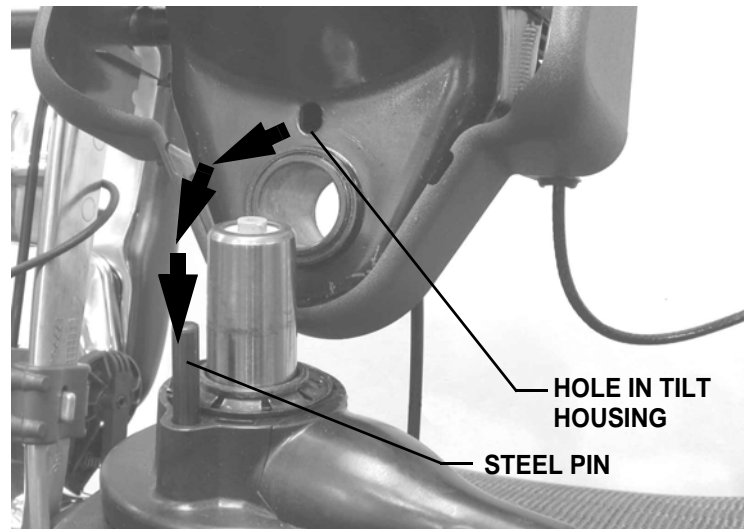


After replacing foot ring subassembly, check to ensure subassembly is fully seated on pneumatic cylinder. Refer to demension noted in figure above to confirm that foot ring subassembly is properly reinstalled.

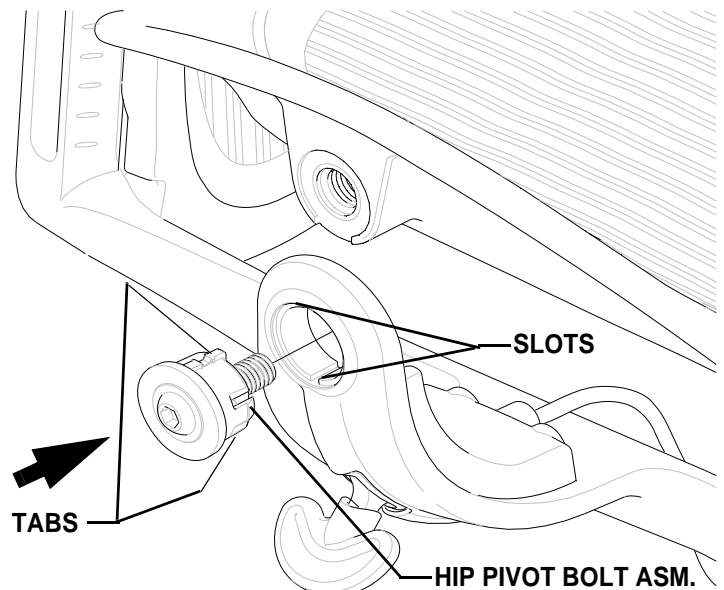
**NOTE:** Make sure noted fasteners are torqued to values specified. Failure to comply can cause unsafe usage of product.

## Fastener Torque Values:

FASTENER DESC.	TORQUE
HIP PIVOT BOLT ASSEMBLY	180 -200 IN-LBS
SEAT LINK SHOULDER BOLT	120 -150 IN-LBS



When reinstalling upper portion of stool to foot ring sub-assembly, hole in bottom of tilt housing must engage steel pin on gearbox assembly.



When reinstalling dislodged hip pivot bolt assembly make sure (2) small tabs on outside of assembly engage (2) small slots in swing arm. Retightening of bolt will draw hip pivot assembly back into swing arm.



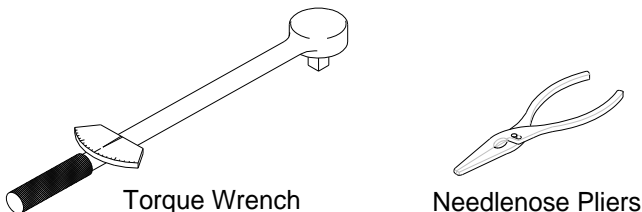
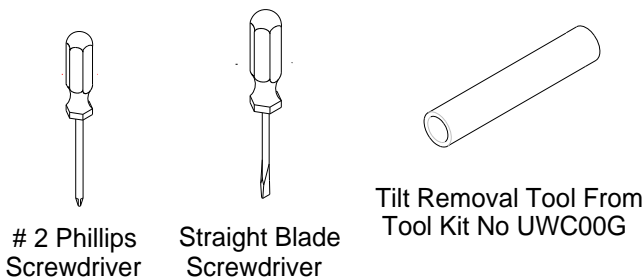
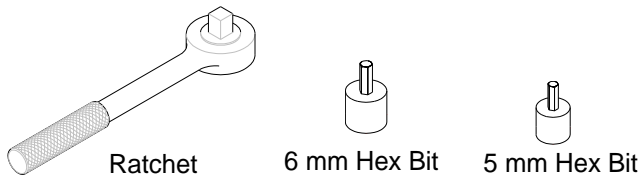
# Aeron® Stool Tilt Replacement

## PARTS INCLUDED:

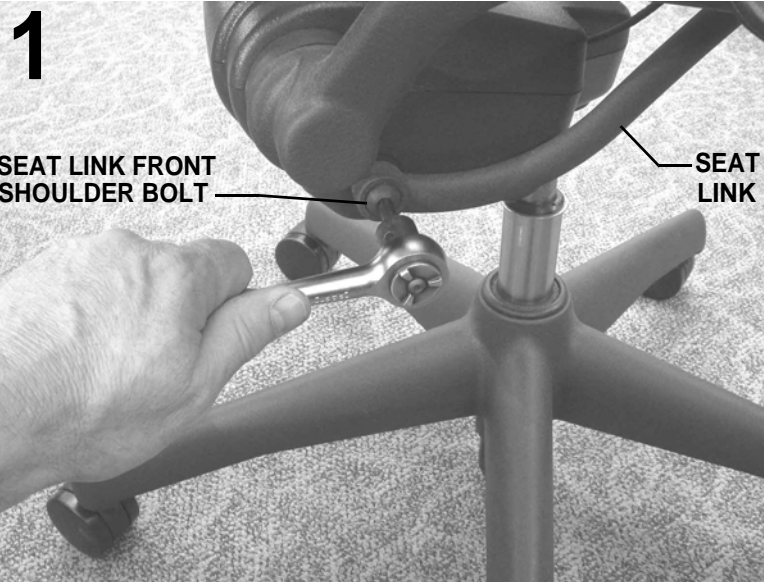


**NOTE:** Additional tilt control components may be included to accommodate occasional upgrades to tilt assembly. Use any included control components as needed.

## TOOLS REQUIRED:

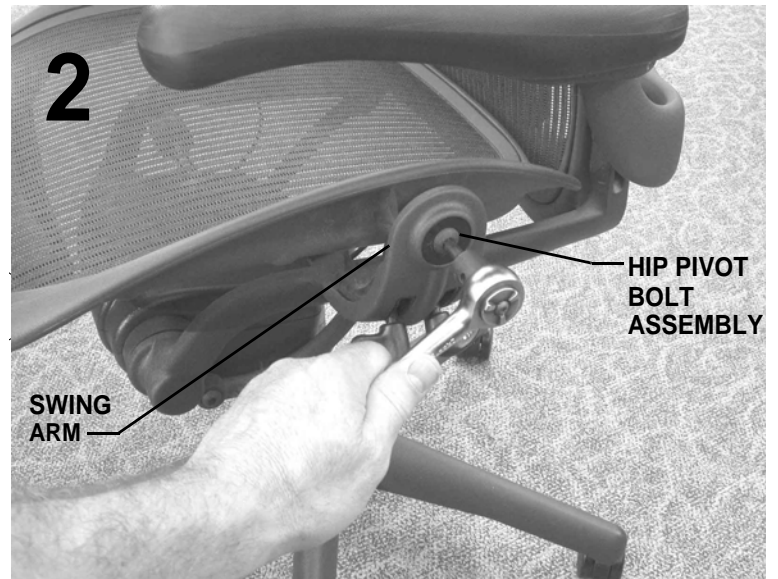


**NOTE:** To help minimize risk of damaging pneumatic cylinder internal components, set chair height to it's lowest setting before begining service procedure.



1.1 Using ratchet and 6 mm hex bit, remove and save seat link front shoulder bolt, securing seat link to tilt housing.

1.2 Repeat step 1.1 for opposite seat link.

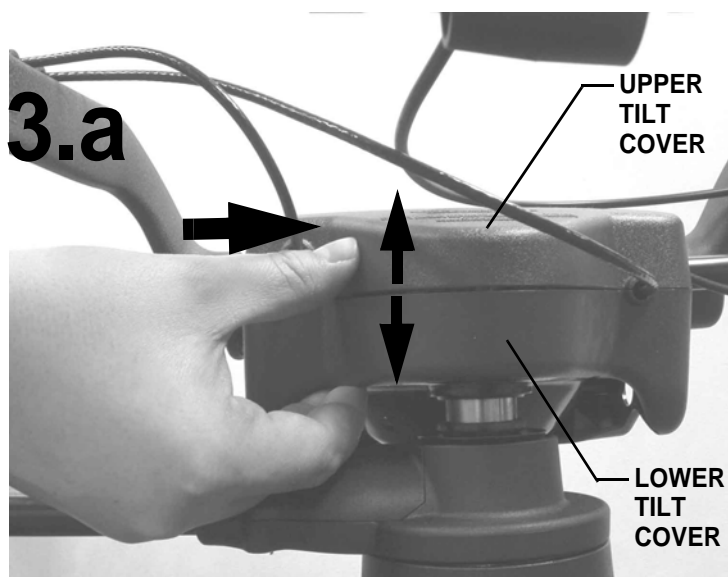


2.1 Using 6 mm hex bit, unthread hip pivot bolt assembly from seat frame. Unthreading of first hip pivot bolt will force hip pivot bolt assembly to dislodge from swing arm. Set hip pivot bolt assembly aside.

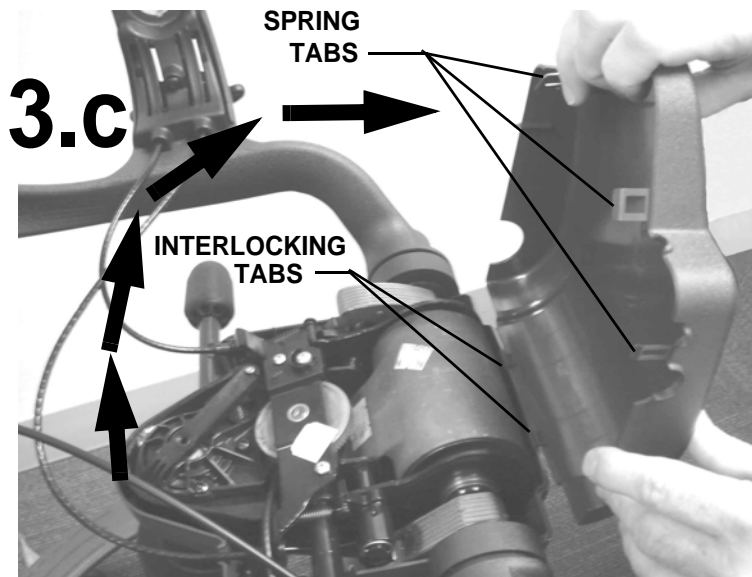
2.2 Unthread opposite hip pivot bolt assembly while supporting free side of seat frame.

2.3 Remove seat assembly with links and set it aside.



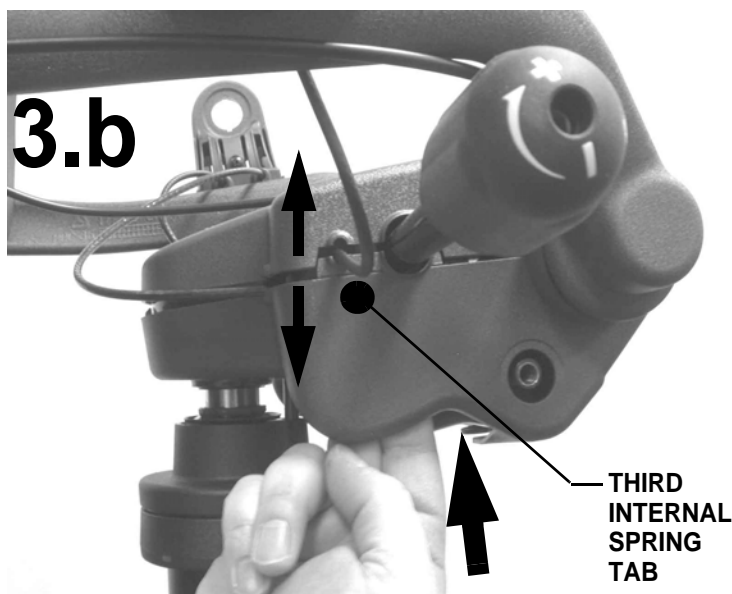


**3.a.1** On left side of tilt covers, press in on upper tilt cover with thumb, while holding lower cover with fingers, as shown. This will shift upper cover and dislodge 2 of 3 internal spring tabs securing covers together. As upper cover shifts and tabs disengage, push upper cover up with thumb, to begin separation of covers.

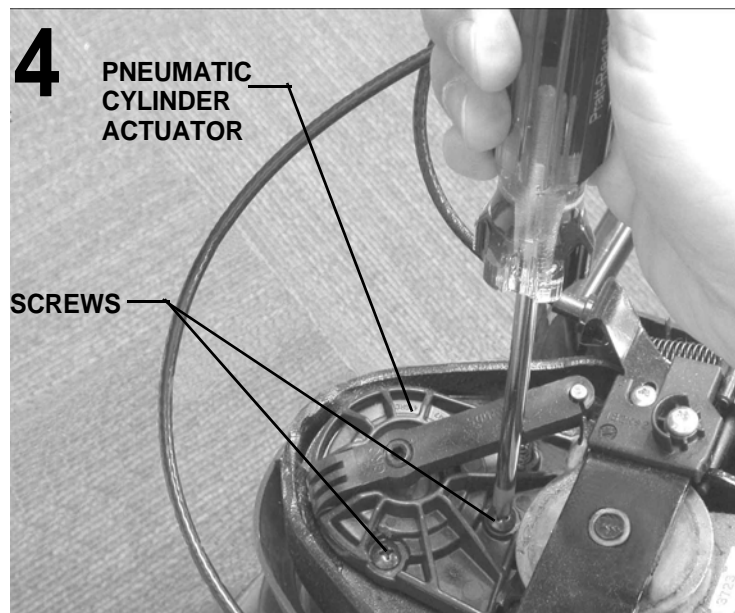


**3.c.1** With all internal spring tabs disengaged, rotate upper tilt cover forward to disengage (2) interlocking tabs at front of covers.

**3.c.2** Remove upper cover and set it aside.

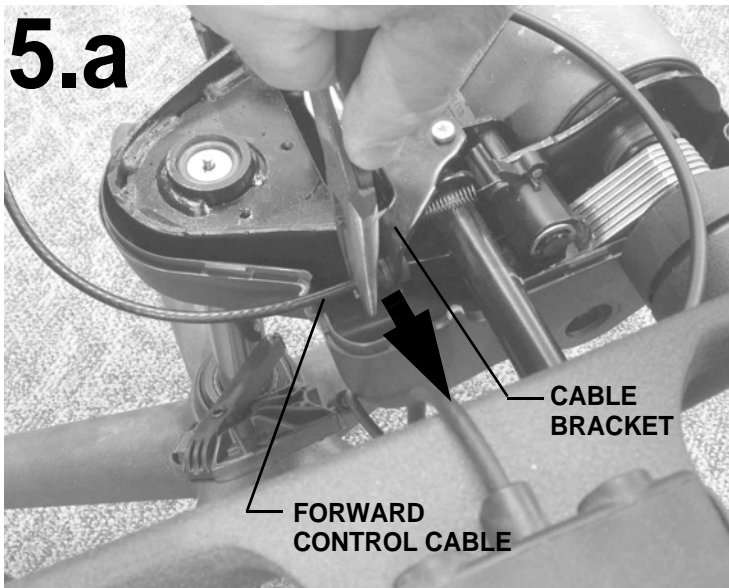


**3.b.1** At right side of tilt covers, insert finger(s) behind lower cover, as shown, and disengage third and last spring tab



**4.1** Using #2 Phillips screwdriver, remove and save (2) screws securing pneumatic cylinder actuator to top of tilt.

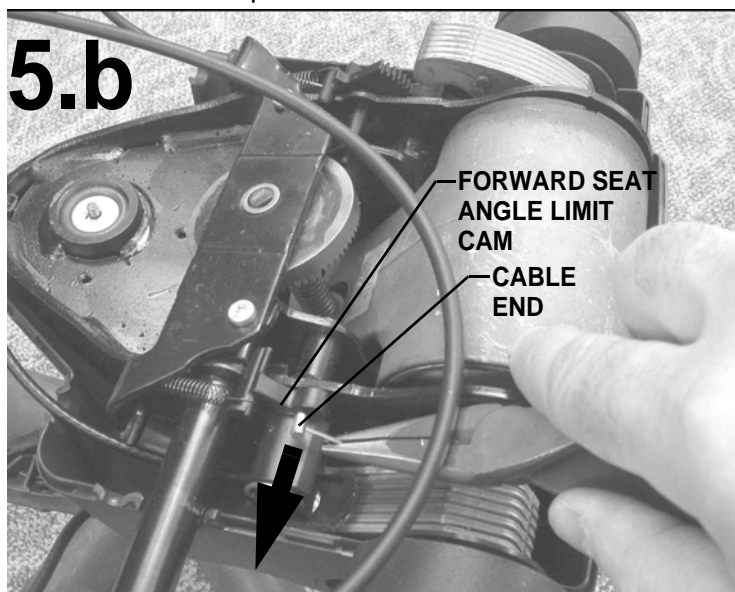
**4.2** Remove actuator from top of tilt and let it hang free.



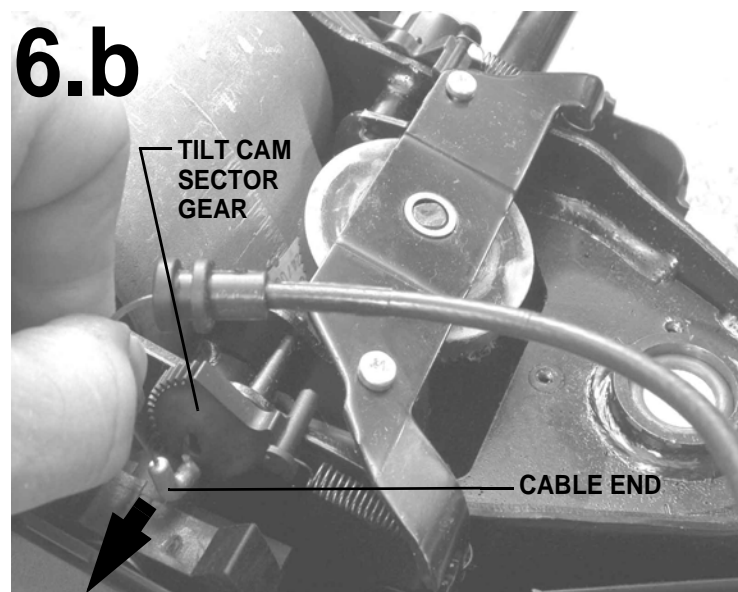
5.a.1 Remove forward seat angle control cable by first disconnecting cable from cable bracket, using needle nose pliers.



6.a.1 Remove tilt limit control cable by first removing cable from cable bracket with needle nose pliers.

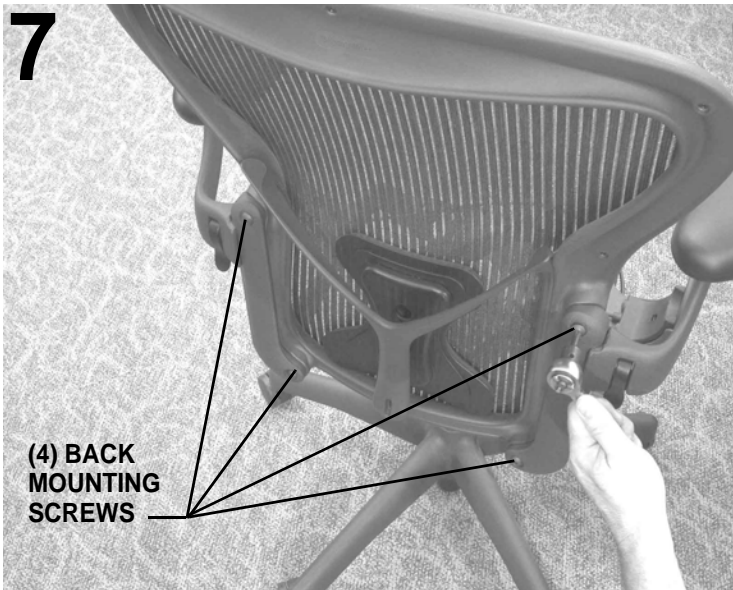


5.b.1 Disconnect forward seat angle control cable from forward seat angle limit cam by sliding cable end out of cam with needle nose pliers, as shown. Allow cable to hang free.



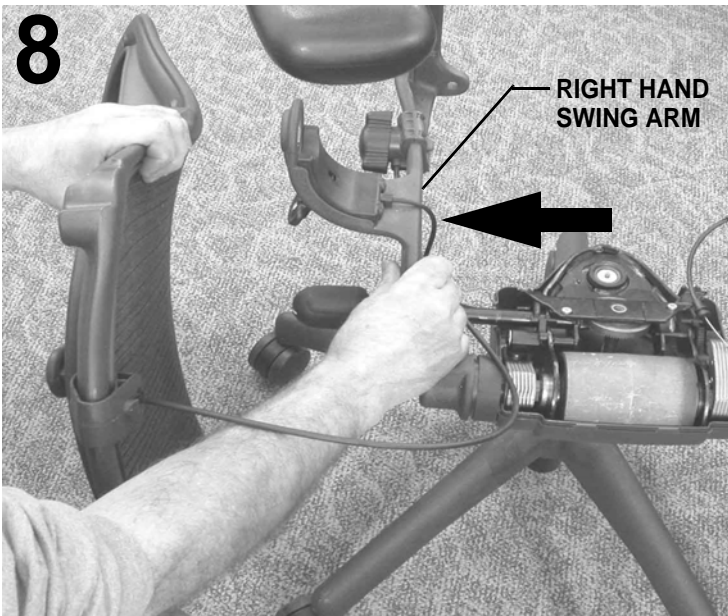
6.b.1 Remove tilt limit control cable end from tilt cam sector gear by rotating cable end forward 90 degrees to release cable end from keyhole slot in sector gear. allow cable to hang free.



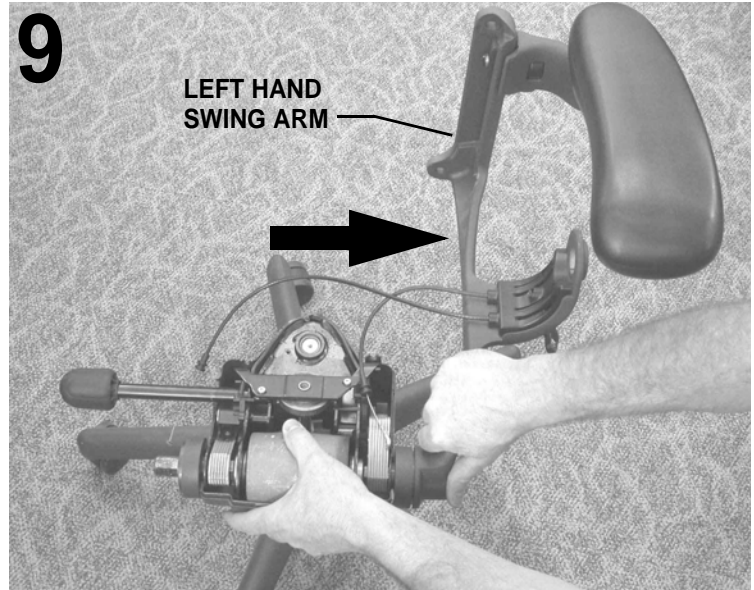


7.1 Using 5 mm hex bit, remove and save (4) back mounting screws, securing chair back to swing arms.

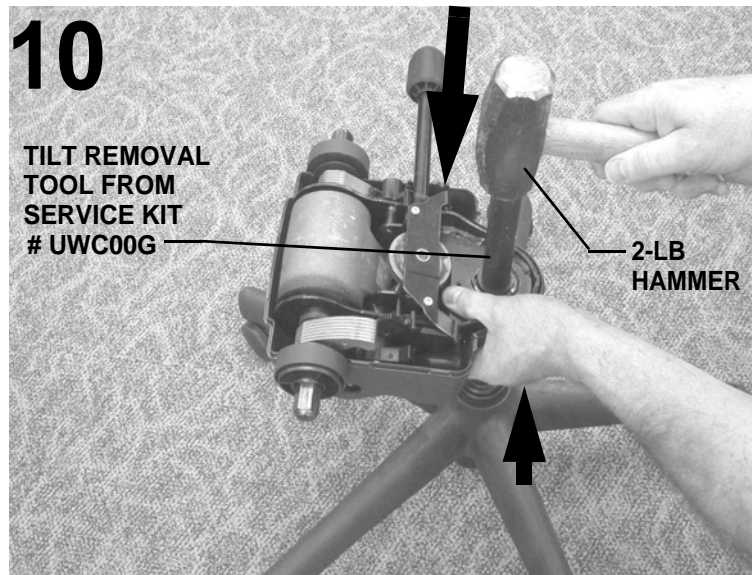
**NOTE:** If back is equipped with posture fit lumbar, as shown, lumbar control cable connects to right swing arm and chair back. Keep back in close proximity to right swing arm during entire procedure to avoid damaging lumbar control cable.



8.1 By hand, slide right hand swing arm off tilt assembly hex shaft. Set swing arm and any attached posture fit type chair back aside.



9.1 By hand, slide left hand swing arm off tilt assembly and set swing arm aside.

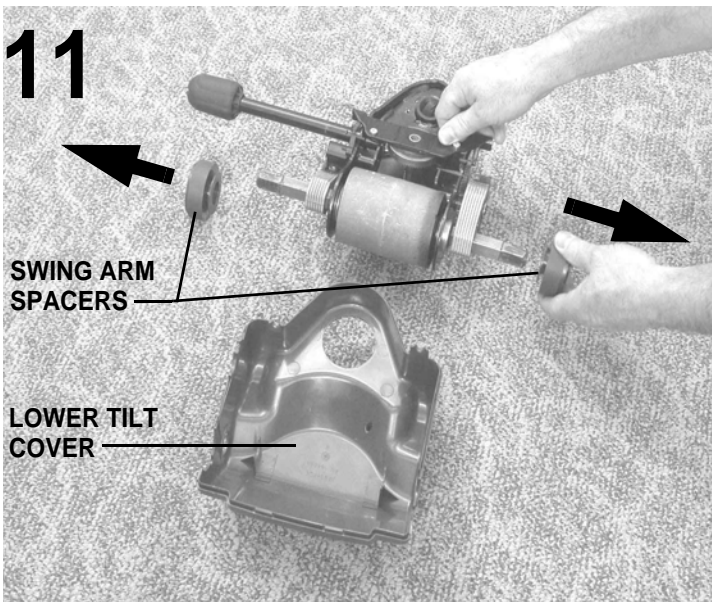


10.1 Place tilt removal tool from kit, onto top of pneumatic cylinder with hole in end of tool towards cylinder.

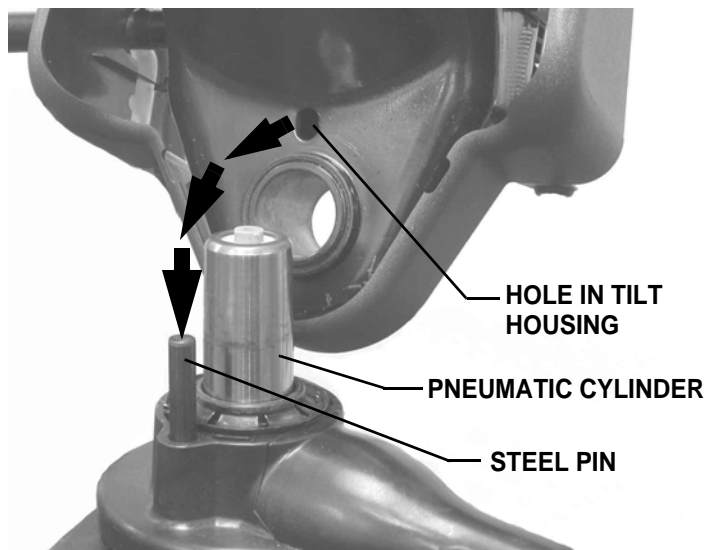
**CAUTION:** Maintain grasp on tilt assembly as it is freed from pneumatic cylinder to prevent it from falling and causing product damage. Some help removing tilt is recommended.

10.2 Support chair base and tilt assembly slightly off floor and strike removal tool sharply with a 2-lb hammer until tilt is unseated from end of pneumatic cylinder.





**NOTE:** On Aeron stools only, make sure steel pin on base assembly engages hole in tilt housing when installing replacement tilt assembly.



Install replacement tilt assembly to pneumatic cylinder.

**NOTE:** reseating of tilt assembly to pneumatic cylinder is achieved by sitting in chair after reassembly is completed.

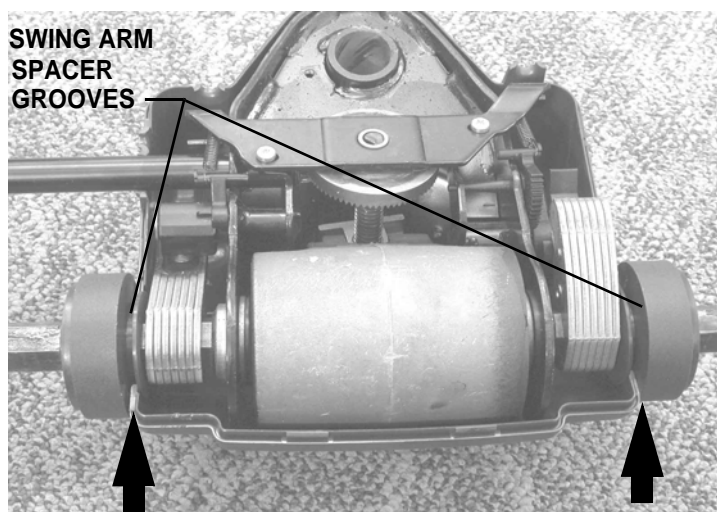
11.1 Slide lower tilt cover free of swing arm spacers and tilt assembly and set it aside.

11.2 Remove swing arm spacers from hex shafts and set them aside.

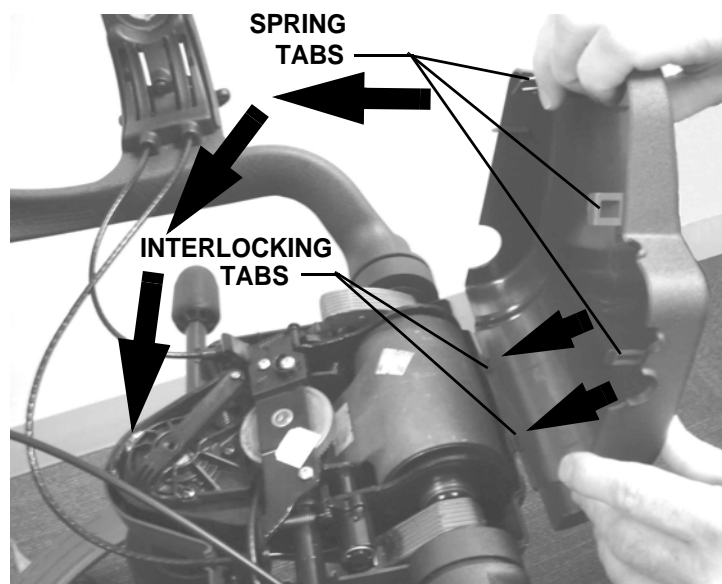
11.3 Dispose of old tilt assembly properly.

## Reassembly Notes:

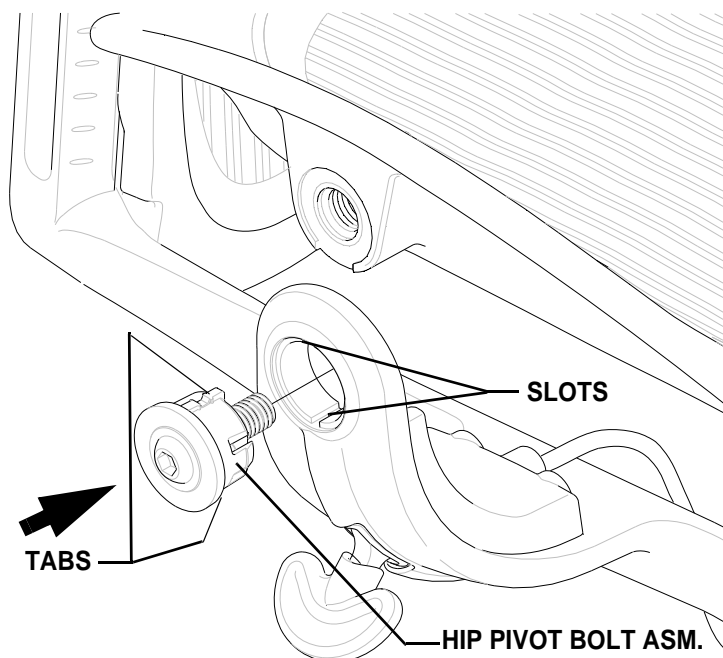
Reverse disassembly steps, referring to figures and sequence as necessary, and as noted below.



Reinstall swing arm spacers, groove first. Make sure tilt cover sides engage grooves in spacers with an audible snap.



Check to ensure all control cables are properly routed through lower tilt cover. Insert interlocking tabs on upper cover into slots on lower cover, then rotate upper cover over onto lower cover and press covers together to engage spring tabs.



When reinstalling dislodged hip pivot bolt assembly make sure (2) small tabs on outside of assembly engage (2) small slots in swing arm. Retightening of bolt will draw hip pivot assembly back into swing arm

**NOTE:** make sure noted fasteners are torqued to values specified. Failure to comply can cause unsafe usage of product.

## Fastener Torque Values:

FASTENER DESC.	TORQUE
HIP PIVOT BOLT ASSEMBLY	180 -200 IN-LBS
SEAT LINK SHOULDER BOLT	120 -150 IN-LBS
BACK ATTACHMENT SCREW	70 -100 IN-LBS