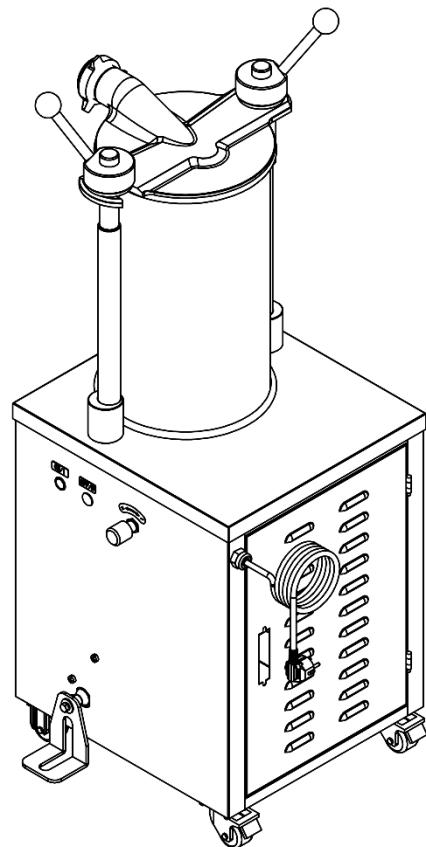


ggm gastro

HYDRAULIC STUFFER USER MANUAL

Model Number: WFFC25



SAVE THESE INSTRUCTIONS!

General Information

- We are not responsible for any harm or injury caused due to any person's improper or negligent use of this equipment. The product shall only be operated by someone over the age of 18, of sound mind, and not under the influence of any drugs or alcohol, who has been trained in the correct operation of this machine, and is wearing authorized, proper safety clothing. Any modification to the machine voids any warranty, and may cause harm to individuals using the machine or in the vicinity of the machine while in operation.
- CHECK PACKAGE UPON ARRIVAL.
- Upon receipt the shipment please inspect for external damage. If no damage is evident on the external packaging, open carton to ensure all ordered items are within the box, and there is no concealed damage to the machine.
- Before operating any equipment, always read and familiarize yourself with all operation and safety instructions.
- We would like to thank you for purchasing this machine. It's of the utmost importance to save these instructions for future reference. Also save the original box and packaging for shipping the equipment if servicing or returning of the machine is required.

Safety and Warranty

DEFINITION OF WARNINGS AND SIGNAL WORDS

SAFETY WARNINGS AND SIGNAL WORDS USED IN THIS MANUAL

The safety instructions serve as indications and precautionary measures that must be taken into account or adopted to avoid a dangerous situation.

- This is the safety alert symbol. It is used to alert you to personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

Warnings can be classified according to the severity of the hazardous situation. The classification is based on an assumption of probability of being exposed to a dangerous situation and what could happen in such a case.

There are four kinds of warnings:

- DANGER** Indicates a hazardous situation which, if not avoided, will result in death or serious injury.
- WARNING** Indicates a hazardous situation which, if not avoided, could result in death or serious injury.
- WARNING** Indicates a hazardous situation which, if not avoided, may result in minor or moderate injury.
- NOTICE** Is used to address practices not related to personal injury.

IMPORTANT INFORMATION:

- i** NOTE: provides additional information to clarify or simplify a procedure.

SAFETY WARNINGS ATTACHED TO THE MACHINES

The safety symbols warn of special hazards and are placed in the relevant places on the machine. Check warning symbols daily:

- Are all security symbols present?
- Are all safety symbols recognizable and readable?

Ensure that the safety plates / adhesives are firmly attached to the machine, are easily readable and are not erased during the cleaning process. Disconnect the machine and secure the main switch against reconnection if a warning symbol is missing or no longer recognizable. Do not reconnect the machine until they are in place and all safety symbols are recognizable. If they become damaged or lost, contact your authorized dealer.

INTENDED USE OF THE MACHINE

In general, the hydraulic piston fillers/stuffers are used to prepare sausages made of minced meat. Other applications include dough or paste of any type that can flow through a nozzle/horn of Ø10mm. Never use hard masses or pastes that do not flow and could cause dangerous overpressure. The temperature of the dough to be stuffed should be higher than 2°C (35°F). Do not process frozen or semi-frozen doughs. Working environment conditions: temperature +5 to + 40°C (+40 to + 100°F), relative humidity: 20 to 90%. The maximum operating pressure must not exceed 120 bar.

Any other use would conflict with the machine's characteristics, the manufacturer is not liable for any damages that may occur as a result of improper use.

MODIFICATIONS

DISCLAIMER OF LIABILITY

It is not allowed to modify the machine without the prior express authorization of the manufacturer, neither in its design nor in its security systems. The manufacturer will not be liable for damages caused by arbitrary changes. When a user makes essential modifications to the machine, he assumes the manufacturer status. In such a case, he shall be obliged to take all the measures incumbent on it legally as a manufacturer. The original manufacturer is therefore released from its responsibility.

GENUINE PARTS

The machine is only allowed to be used with original accessories and spare parts. The manufacturer will not be liable for damages caused by using tools, accessories or spare parts from other manufacturers.

IMPORTANT WARNINGS

Since the WARNINGS, CAUTIONS and INSTRUCTIONS in this manual cannot address all possible conditions and situations that may arise, the operator **MUST ALWAYS** exercise common sense and due caution when using this machine!

- DO NOT DISCARD THIS MANUAL; KEEP IT FOR FUTURE REFERENCE BY ALL USERS AND MAINTENANCE PERSONNEL. PLEASE THOROUGHLY READ AND FULLY UNDERSTAND ALL THE INSTRUCTIONS BEFORE SERVICING OR USING THE MACHINE.
- THIS MACHINE HAS MOVING PARTS AND USES VOLTAGES THAT ARE POTENTIALLY HAZARDOUS. FAILURE TO FOLLOW THE INSTRUCTIONS CONTAINED IN THIS MANUAL COULD RESULT IN SEVERE, POSSIBLY LIFE-THREATENING, PERSONAL INJURY.
- THIS MACHINE HAS BEEN DESIGNED EXCLUSIVELY FOR MEAT PROCESSING. USE OF THIS MACHINE FOR ANYTHING OTHER THAN MEAT PROCESSING DOES NOT CONFORM TO ITS INTENDED FUNCTION, IS STRICTLY PROHIBITED AND SHALL VOID WARRANTY. THE MANUFACTURER ASSUMES NO RESPONSIBILITY FOR ANY DAMAGE OR INJURY RESULTING FROM IMPROPER USE OF THIS MACHINE.
- DO NOT ALTER OR MODIFY THE MACHINE'S ORIGINAL DESIGN IN ANY WAY; DOING SO WILL VOID WARRANTY AND MAY RESULT IN PERSONAL INJURY OR DAMAGE TO THE MACHINE.
- This machine **MUST** be installed **ONLY** by a qualified electrician in accordance with the instructions in this manual and in compliance with all applicable national, regional and local electrical, safety and hygiene standards and codes. Compliance with said standards and codes is the sole responsibility of the owner and installer.
- DO NOT open the machine or tamper with its internal parts; none of the internal components requires adjustment or maintenance by the user.
- DO NOT tamper with the machine's mechanical or electrical safeguards.
- Use **ONLY** genuine the manufacturer's parts or accessories and have them installed only by a qualified technician. Use of unapproved parts and accessories voids warranty and may result in personal injury or damage to the machine.
- NEVER attempt to repair the machine on your own. Should the machine require service, contact the authorized dealer from whom you purchased the machine.

- Modifications to the machine that raise noise emission levels above 85 dB(A) may result in hearing damage. **ALWAYS** wear appropriate hearing protection.

ELECTRICAL HAZARDS

- **DO NOT TAMPER WITH THE MACHINE'S ELECTRIC SYSTEM. THIS MACHINE MUST BE INSTALLED ONLY BY A QUALIFIED ELECTRICIAN AND IN COMPLIANCE WITH APPLICABLE NATIONAL, REGIONAL AND LOCAL ELECTRICAL CODES.**
- **ALWAYS USE CAUTION WHEN WORKING ON THE MACHINE'S ELECTRICAL SYSTEM SINCE THERE IS A RISK OF ELECTRIC SHOCK DUE TO:**
 - DIRECT OR INDIRECT CONTACT WITH ELECTRIC CURRENT.
 - IMPROPERLY INSTALLED DEFECTIVE OR DAMAGED ELECTRICAL PARTS.
- **BEFORE** operating the machine, make sure that all phases are connected properly and that the machine is properly grounded and/or connected to a circuit leakage breaker and thermal switch. Failure to do so could result in electric shock!
- **DO NOT** tamper with the machine's electrical wiring or components after installation.
- **ALWAYS** disconnect the machine from the electrical outlet before proceeding with cleaning, maintenance, or repairs.
- To avoid damaging the power cord and possible injury, keep it away from areas where it may be stepped on or tripped over. **DO NOT** pull on the power cord to disconnect the plug from the electrical outlet; always pull on the plug.

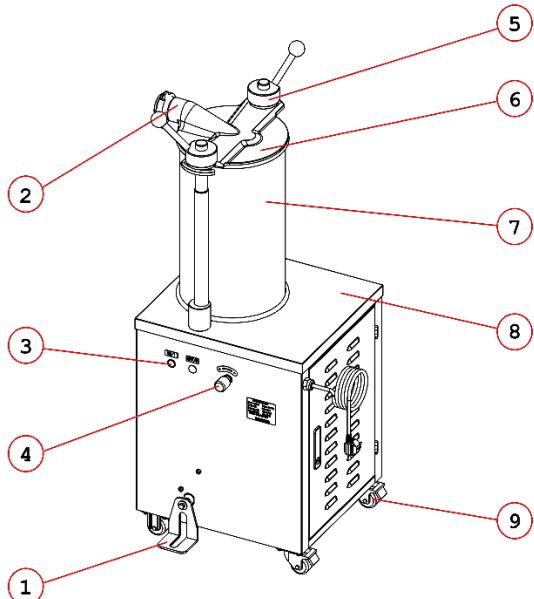
DISPOSAL

Risk of damage to people and environmental hazards. The machine is composed of different materials. Observe local regulations on waste disposal. Instruct an authorized waste disposal company to dispose of waste correctly.

- **WARNING:**
- The packaging components are classified as normal solid urban waste and can therefore be disposed of without difficulty.
- In any case, for suitable recycling, we suggest disposing of the products separately (differentiated waste) according to the current norms.
- **DO NOT DISCARD ANY PACKAGING MATERIALS IN THE ENVIRONMENT!**

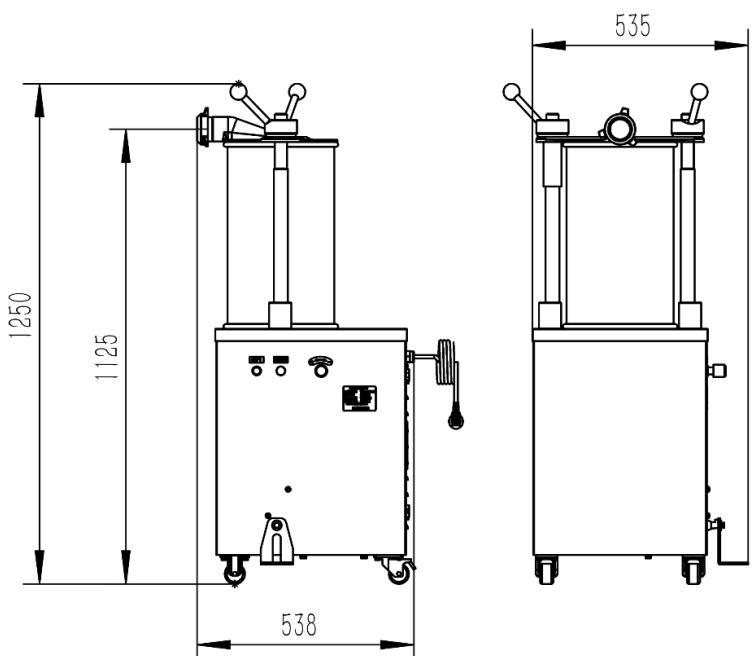
Technical Specifications

KEY PARTS



1. Foot pedal
2. Discharge port
3. Button switch
4. Discharge speed adjustment knob
5. Upper cover locking nut
6. Upper cover
7. Material cylinder
8. Rack
9. Casters

Model Number	WFFC25
Motor Power	1HP/0.75kw
Rated current	5A
Rated voltage/frequency	230V/50Hz
Capacity	20L
Working temperature	5°C-40°C / 40°F-100°F
Working humidity	20%-90%
Net weight	110 Kg
Overall dimensions	530 x 535 x 1,250 mm



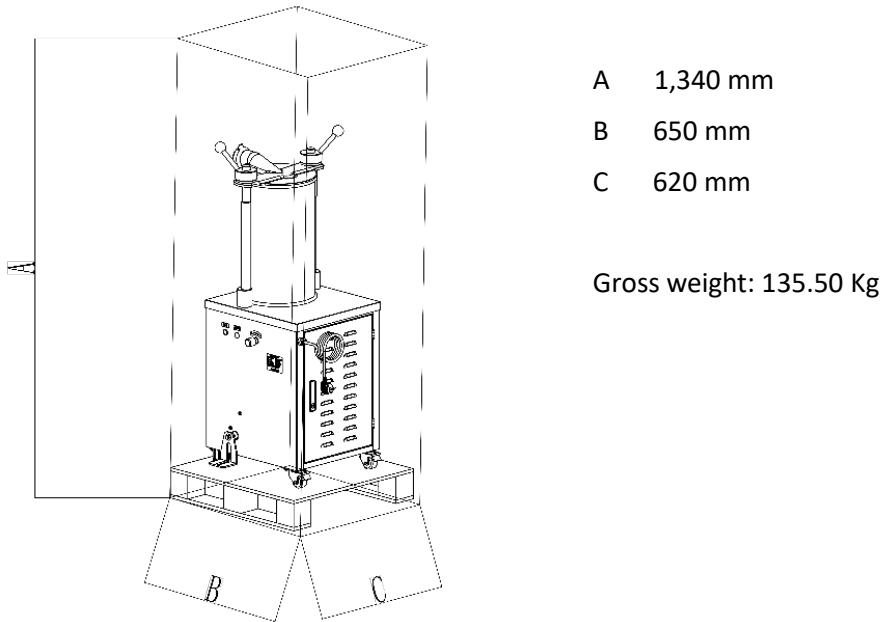
Handling and installation

Note: The machine has been tested before leaving the factory to ensure good operation and correct adjustment.

Handling and loading/unloading

Before sending it to the shipper, the machine is carefully inspected.

For particularly heavy goods, we usually use plastic strapping to pack them and place them on pallets.



- **Attention: After receiving the machine, please check the packaging for any damage.**

Installation

Attention: The place where the machine is installed should be flat and stable.

If the machine is installed on the floor, make sure there is enough space around the machine. Not only is it convenient to operate the machine, but it is also easy to clean.

Handling of packaging materials

Packaging materials, such as cardboard, plastic, and wood, are generally considered solid waste and can be disposed of at will. Plastics are polluting materials, and if burned, they will produce toxic gases. Therefore, they cannot be incinerated or decomposed, and should be disposed of in accordance with effective local regulations. If the machine is transported to a country with special regulations, packaging materials should be disposed of according to these regulations.

Handling machines

Attention: Use tools or equipment with sufficient load capacity to handle goods. Example: Forklift.

Ensure the stability and position of the goods during transportation, and pay special attention when passing through uneven, slippery, and sloping surfaces. Keep the machine as low as possible to ensure its visibility and stability.

Power Connection

The randomly provided cable comes with a standard three holes plug. Rated current 16A.

Attention: Ensure that the provided power supply matches the voltage on the machine nameplate. Electrical connections can only be carried out by professionals and authorized personnel.

When connecting the main power supply, it must be reliably grounded.

Single phase 230V-50Hz machine

The machine is equipped with a power cord with a cross-sectional area of 2.5 square meters and a length of approximately 3 meters. Equipped with standard plugs. The rated current of the power cord is 16A.

Operation

NOTICE

- BEFORE STARTING WORK, PLEASE READ AND UNDERSTAND THIS ENTIRE MANUAL AND SAFETY.
- DO NOT use the machine without having been instructed by an advanced user.
- Practice using the machine in vacuum before contacting mass.
- This machine is not designed to run in continuous operation uninterrupted at high pressures, but intermittent operation stops dissipating the heat generated varies depending on the consistency of the product.

WARNING

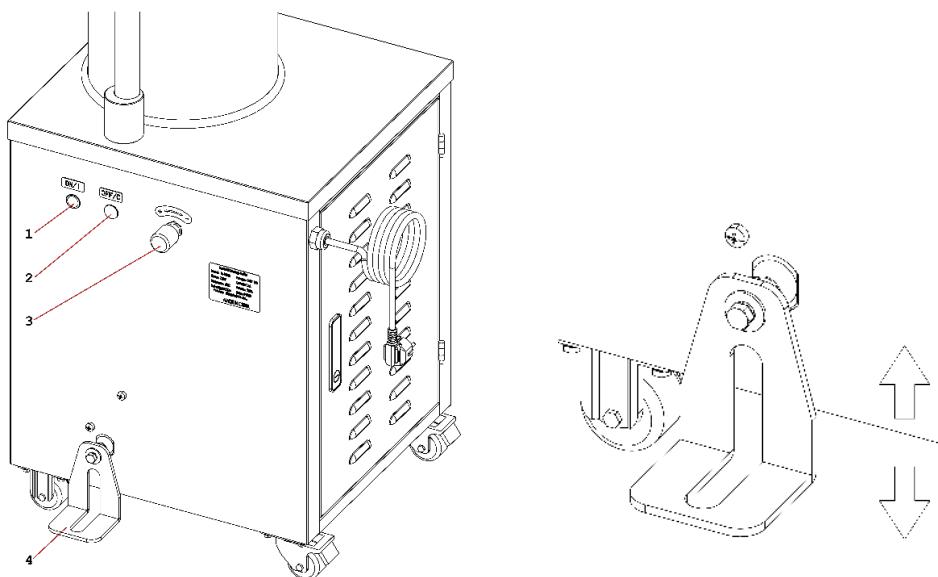
- ⚠ If the phases are not well connected, power up the pump will operate in reverse, the engine make noise but will not move the piston. In this case stop immediately and disconnect the machine from the mains.
- ⚠ Have a qualified electrician permute two of the three phases in the plug.
- ⚠ Observe all hygiene measures in food processing, using the necessary protection material (washing, gloves, hat, apron, etc.)

Machine operation panel

- #1 is the start switch of the machine with a green indicator light. When this switch is pressed, the green indicator light will light up, and the machine power will be connected for enema operation.
- #2 is the stop switch of the machine. After pressing this switch, the machine control power will be cut off, and the machine cannot be operated at this time. If this switch is pressed while operating the machine, the machine will immediately stop moving.
- #3 is the discharge speed adjustment knob. Clockwise rotation reduces the speed of meat production. Rotate counterclockwise to increase the speed of meat production.
- #4 is a foot switch. Control the piston inside the barrel to rise or fall.
- Step down on the foot pedal, and the material cylinder piston moves upwards, at which point meat is produced.
- Lift the foot pedal upwards, and the material cylinder piston moves downwards until it automatically stops at the

bottom.

- When the foot is in a horizontal position, it does not move.



NOTICE

- Before using the machine, corresponding inspections must be carried out to ensure that the machine is in a safe and correct state.
- When the foot switch is pressed down, it must always be kept in the pressed state. If the foot switch is released, it will automatically return to the horizontal position and meat production will stop.
- When the foot switch is pulled upwards, it is in a self-locking state and there is no need to keep pulling the foot pedal. When the piston moves downwards to the lowest position, the indicator light of the start button goes out, and the machine automatically stops working. The next time you start the machine, you must first press the start button. The foot switch will only activate when the green indicator light is on. Otherwise, the motor will not run.
- The speed adjustment knob 3 only works during the upward pushing of the piston, not including the downward process.

ATTENTION:

- Check that the power cord and the power requirements on the machine nameplate are consistent, and that the grounding is good.
- The motor is powered by a single-phase power supply, and the rotation direction of the motor is directly adjusted by the manufacturer without the need for further adjustment.
- Check the pedal. The pedal should remain level before starting the machine.
- The various components of the machine are installed and fixed normally.
- Cover locking nut. Before starting the machine, ensure that the locking nut of the cover is tightened.

Foot pedal function inspection

- Turn on the machine and press the start button 1. The green indicator light on the start button will light up. Press the foot switch 4 downwards, and the piston inside the barrel moves upwards. Stop pressing the foot pedal and the piston will immediately stop.
- Pull the foot switch upwards and the piston inside the barrel moves downwards. Until the piston moves to the

lowest position, the start button indicator light goes out, and the machine automatically stops.

- During the downward movement of the piston, if the foot switch is turned to the horizontal position, the cylinder piston will also stop. At this time, the start button indicator light does not turn off.

Machine startup

After connecting the power, press the start button 1, and the start button indicator light will light up. At this time, the control circuit power is connected, and the foot pedal can be operated to control the piston to rise or fall.

Machine stop

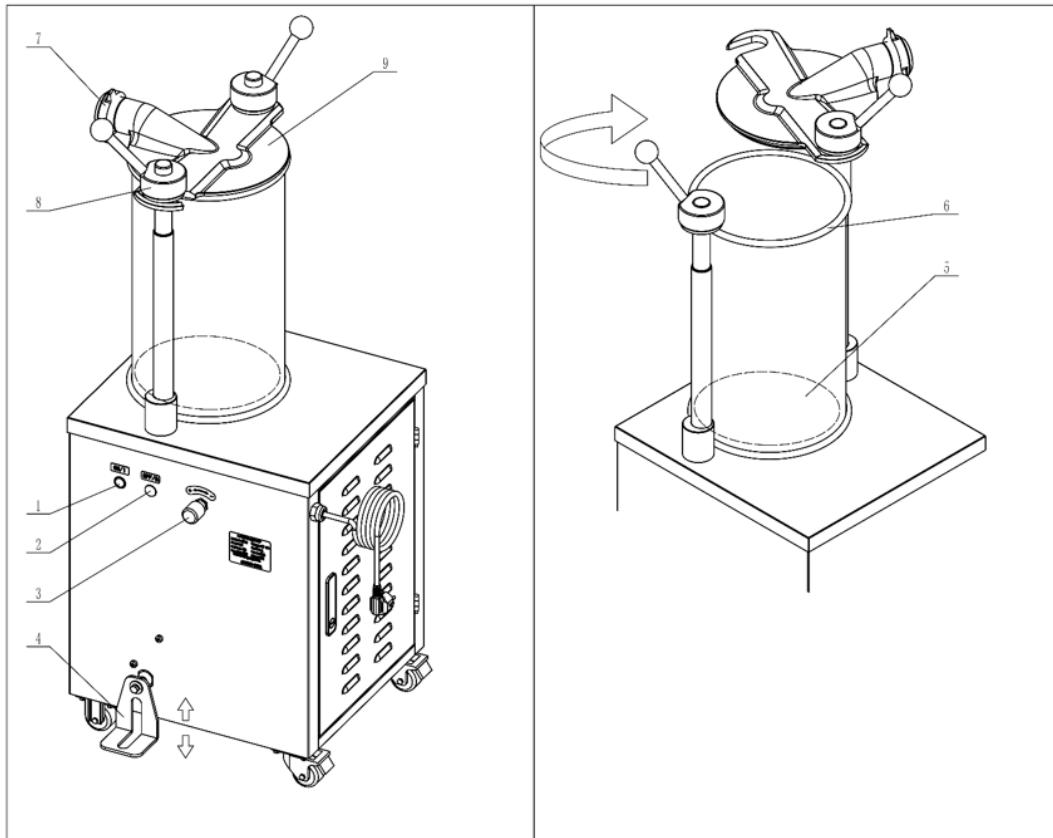
- Press the stop button on the lower panel, the indicator light on the start switch will turn off, and the machine will stop running.
- When the piston is not at the lowest point, lift the foot pedal upwards, and the piston will automatically descend until it reaches the lowest point. The start button light will turn off and the machine will stop.

How to use the machine

WARNING

- Only authorized employees are allowed to use this machine.
- Before starting, the operator must ensure that all safety devices are correctly installed and working properly. Otherwise, shut down the machine and contact maintenance personnel.
- In the presence of technical personnel, some operations can be carried out on the empty machine to obtain some technical points for safe operation of the machine.

- When the machine power cord is reliably connected, press the start button 1 shown in below picture, and the indicator light of the start button will light up.
- Pull pedal 4 upwards to ensure that push piston 5 is at the lowest point.
- Rotate a few times to loosen the compression nut 8, lift the cover 9, and rotate the cover to one side in the direction shown in below picture.
- Put the meat filling to be processed into barrel 6.
- Turn the cover back to its original position and tighten it with locking nut 8. Ensure that the sealing gasket is in the correct position.
- Use fixing nut 7 to secure the enema catheter at the outlet and tighten it.
- Pull pedal 4 downwards, piston 5 rises, and start enema.
- The speed of enema can be adjusted by turning the adjustment knob 3. Clockwise rotation reduces the pushing speed of piston 5, while counterclockwise rotation increases the pushing speed of piston 5.
- When barrel 6 is empty, pull foot switch 4 upwards and piston 5 moves downwards until it reaches the bottom and stops.



USEFUL TIPS

1. The minimum operating temperature for the filler is 5°C. Therefore never store the machine in cold rooms, freezers, etc.
2. This machine is not designed to operate in continuous uninterrupted service, but to work on an intermittent regime with stops to dissipate the heat generated which varies depending on product consistency.
3. Given the pressure transmitted to pump hydraulic oil, it is normal that the temperature can raise above 60°C and the machine body is hot after a prolonged operating period.
4. For a better presentation of the sausage filling process, smoother and less effort and heating of the machine the following is recommend:
 - Select nozzle/horn with the largest diameter and shortest length possible.
 - Meat mass should be minced/chopped as fine as possible and as warm as possible.
5. During operation of the machine with dough, you cannot open the lid until lowering the piston a bit, since the compressed meat mass would prevent it.
6. Approach the filler to the worktable as much as possible to avoid meat falling to the ground or on the operator.
7. Try to work at a reasonable speed and pressure, thus avoiding constant starts and stops the hydraulic unit.

CLEANING INSTRUCTIONS

NOTICE

- If using detergents, disinfectants or oils maintenance, observe the special instructions of the manufacturers.
- NEVER use water pressure jet to clean or rinse any part of the machine.
- NO use abrasive products, especially those erasable plates or safety adhesives.
- NO open or close the lid without the red seal, because doing so will scratch the cover and flange.
- To prevent mechanical hazards during cleaning operations and removing the piston, always open the lid completely before making up the piston.

DANGER

Electrical Hazard!

- The machine MUST remain disconnected from the power supply throughout the entire cleaning procedure.
- NEVER wet or dampen the machine's electrical components (switches, cables, etc.)

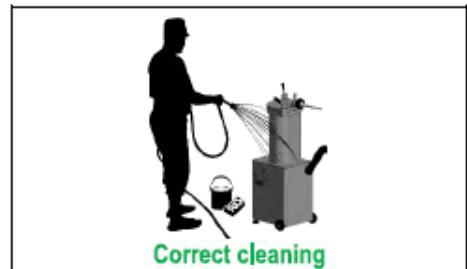
⚠ To proceed with the manual cleaning using suitable protection (latex gloves, plastic apron, etc.) is required.

⚠ ALWAYS necessary intensive rinsing machine after application of detergents or disinfectants to prevent contamination of the mass.

Cleaning the filler is essential not only for health reasons but also for efficient operation. NEGLIGENCE IN CLEANING MAY VOID THE WARRANTY. Stuffer should be cleaned after and, where appropriate, before each use.

EXTERIOR CLEANING

- To clean the exterior of the machine use hot water and a mild detergent.
- After each day the bottom of the lid (mass outlet hole), the nozzle/horn holder nut and the nozzles/horns must be thoroughly cleaned, inside with a tubular round brush.
- Use plenty of hot water to clarify the axis of rotation of the lid in order to remove residual salt and spices that might crystallize and swell after a few hours / days of inactivity and prevent the lid is opened and closed easily.
- The top of the piston silicone gasket should also be cleaned daily by following these steps:
 - Fully open the lid and remove the lid gasket.
 - Press the knee lever until the piston reaches the top of its travel. A portion of the piston silicone gasket will hover at the top of the tank.
 - Clean with a soft brush and / or damp cloth.



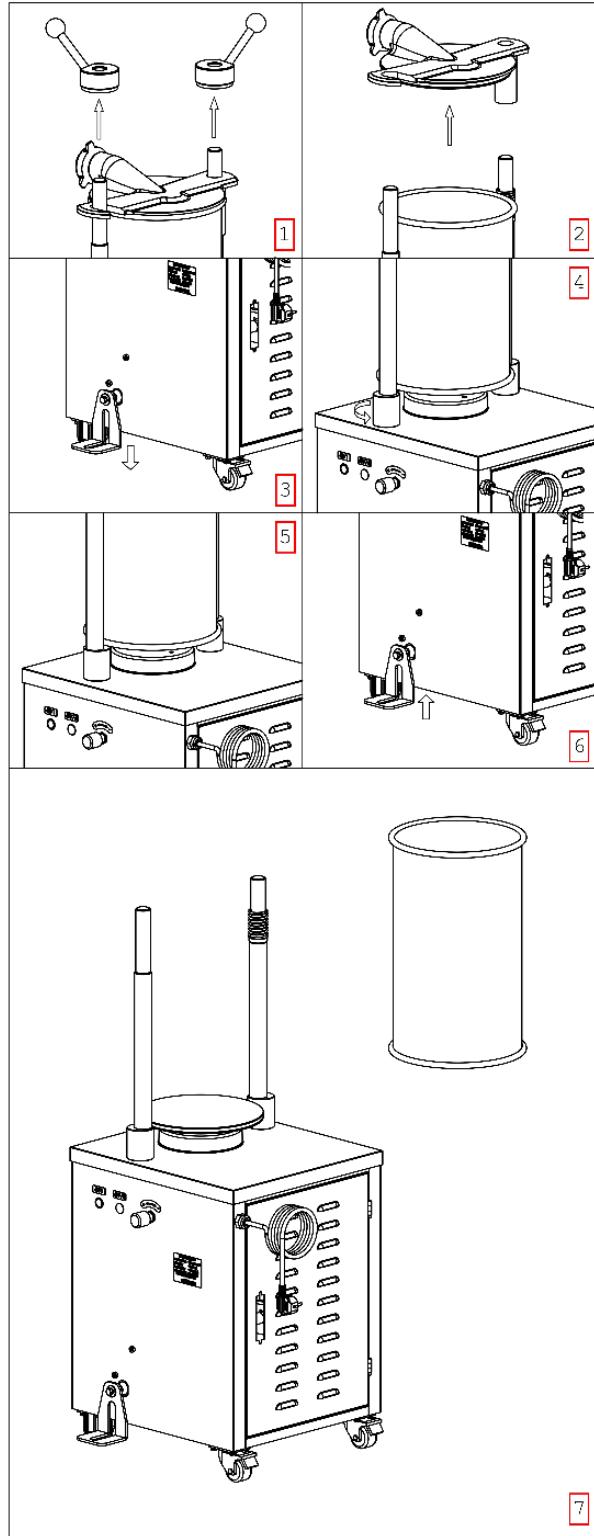
CAUTION:

- The lid and piston of the filler are heavy as they are made of solid stainless steel. Be careful when removing them.
- Due to their heavy weight, it is recommended to remove the lid and piston of the F50s between two people.

INTERIOR CLEANING

It is recommended to periodically clean the inside of piston and tank. The frequency depends on the product (dough consistency), working pressure, etc. We recommend starting with a daily inspection, lengthening intervals depending on their needs.

- Fully open the lid and remove the Upper cover.
- Press the Foot pedal until the piston reaches the top of the cylindrical blocks.
- Rotate the cylinder blocks 180 degrees.
- Lift up the Foot pedal so that the piston goes down till the tank was been taken off.
- Clean the cylinder, plug and the external parts of the machine with water and non-toxic detergent then dry all the parts.
- Clean the piston and silicone gasket.
- To prevent noise on the rise or lowering of the piston, lubricate the piston silicone gasket before inserting it into the reservoir, with edible fat or other authorized USDA food.
- Bring the plug to the lower limit by lifting the pedal (to block it from turning);
- Unfasten the plug without the help of wrenches and proceed to accurately cleaning it.
- Reassemble the disassembled parts by carrying out the disassembly steps in reverse. Taking care that the small seal is installed correctly.
- Lubricate the piston screw and thread before placing it. This will make disassembly easier.
- When the machine is not in use, keep the piston at the bottom of the tank. Being immersed in the hydraulic oil will prolong the life of the rod and seals.



GENERAL CLEANING RECOMMENDATIONS

Steps	Products	Tools	Observations
Superficial cleaning & residue removal.		Spatula.	Promptly after use.
Extensive cleaning.	Mild detergent.	Brush, bucket.	Allow the product to work approximately 15 minutes.
Rinsing.	Warm water.	Sponge, bucket.	The water should be 40 to 50°C (100 to 120°F).
Inspection.			Visually examine all critical components, especially those subject to stress and wear.
Disinfecting.	Disinfectants; NEVER use bleach.	Sponge, cleaning cloth.	Disinfect after completing all other cleaning operations.
Rinsing.	Potable water.	Sponge, bucket.	ALWAYS rinse the machine thoroughly after using detergents and disinfectants.
Drying.		Cleaning cloth.	Be sure to completely dry all cleaned components.
Conservation.	Lubricating oil.	Cleaning cloth.	Only external machine parts.

RECOMMENDED CLEANING INTERVALS

Interval	Area to be cleaned	Product	Tools	Observations
Daily.	Daily Lid, lid gasket, tank and piston screw.	Mild detergent, warm water.	Sponge, cleaning cloth.	Mild detergent, warm water Sponge, cleaning cloth Remove contamination from the piston center screw using, if necessary, a brush to prevent the accumulation of waste.
Weekly.	Piston, piston seals and piston screw gasket	Mild detergent, warm water.	Sponge, cleaning cloth.	To remove the piston follow the instructions detailed above.
Every two weeks.	Machine body, bottom of the machine.	Mild detergent, warm water.	Sponge, cleaning cloth.	

NOTE: The above cleaning intervals are suggested for companies with just one work shift. The machine should be cleaned more frequently if it is used for multiple shifts each day.

STAINLESS STEEL CARE

NOTICE

Never use aggressive cleaners with stainless steel such as bleach or similar chlorine derivatives products. If you have used it, never leave acting, rinse immediately with plenty of water and dry thoroughly.

It is uncommon, but possible, that small traces of rust or oxidation points may be observed on the machine. This may be due to:

- Welding impurities.
- Food fragments adhering to the surface.
- Pits resulting from use of aggressive cleaners such as bleach or similar chlorine derivatives products.

- Moisture that remains after cleaning with water. ALWAYS wipe dry all components that have been cleaned. To remove these rust spots simply use a liquid stripper with a cloth, or clean with Scotch Brite.

Maintenance

⚠ WARNING

- ALWAYS unplug the machine before proceeding with maintenance and inspection.
- ALWAYS follow the safety instructions in this manual during maintenance and inspection operations.

Breakdowns resulting from infrequent or improper maintenance can lead to expensive repairs, lost productivity due to down time and could void our warranty; therefore, regular and adequate maintenance is indispensable. The safety and life of the machine depend on many factors, including proper maintenance. Although it is difficult to give specific advice regarding inspection, maintenance or parts replacement schedules since these depend on many variables related to the machine's use, we can make some recommendations. The user, however, is solely responsible for formulating and following an inspection and maintenance schedules that reflect the machine's actual use. Our local distributor will be delighted to provide you with further information.

MAINTENANCE AND INSPECTION INTERVALS

Inspection interval	Critical component	Maintenance information
Daily.	Lid gasket.	Check it and replace it if necessary.
	Piston silicone seal.	Check it and replace it if necessary.
Monthly.	Knee lever.	Performance review and grease if necessary.
	Lid opening.	Performance review and grease if necessary.
Annually.	Hydraulic oil.	Check the level and fill the reservoir if necessary.
Every 2,500 to 5,000 hours.	Hydraulic oil.	Change the hydraulic oil.

NOTICE

The above maintenance and inspection intervals are suggested for a machine under normal use. The filler should be inspected and maintained more frequently if it is used heavily.

MAINTENANCE AND INSPECTION TIPS

⚠ WARNING

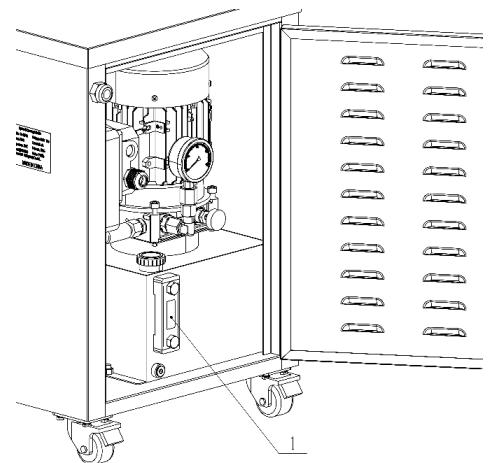
Electrical Hazard!

- If the electric cord becomes damaged, immediately have a qualified electrician replace it with a cord of identical specifications. Contact your dealer's service department to obtain the replacement cord.
- Lid gasket:
 - Replace in case of leakage of meat dough, in case of wear or breakage.
 - To reduce friction between the gasket and the bottom of the lid, lubricate both with animal or authorized oil.
 - It is manufactured of non-toxic material suitable for food use.

- Piston seal:
- Replace if leakage or breakage.
- To avoid noise when raising or lowering the piston, lubricate before inserting the piston into the tank with edible fat or other food authorized USDA
- Hydraulic: To avoid premature wear of the rod of the hydraulic reservoir, keep the piston at the bottom of the tank when finished using the machine. This way the rod will remain submerged in hydraulic oil.
- Lid closing: The lid can be closed more or less tightening the lid locking nuts, depending on the degree of sealing to be obtained. If you normally work with dry meat masses you can tighten the nuts with less force; for liquid masses you may close the lid more tightly and thus avoid the possibility of leakage.
- Spare parts: If you need a spare, contact your dealer who sold the unit, indicating all identification details (model, serial number, year of manufacture, power, voltage, frequency, etc.) you'll find on the nameplate of the machine.

HYDRAULIC OIL

- Hydraulic oil level:
 - Check the oil level on the marks of the tank. Unscrew and remove the screws that hold the panel to the machine base, then withdraw it.
 - On the tank, check that the oil level is between the MAX and MIN marks.
 - Fill the tank to the maximum level (not over), since the greater amount of cooling oil will improve dissipation of heat from the hydraulic unit, increasing its useful life.
 - The lack of oil for operation can be noticed if the piston rises "leapfrog" to allow air to enter the circuit.
- Oil temperature: Given the pressure transmitted to pump hydraulic oil, it is normal that the temperature can rise up to 60° C and the machine body becomes hot after prolonged operating period. This machine is not designed to run in continuous, uninterrupted operation at high pressures, but to work in an intermittent regime with stops to dissipate generated heat.
- Replacing the hydraulic oil:
 - It is recommended to remove used oil with a suction pump oil.
 - Unscrew and remove the screws that hold the panel to the machine base, then withdraw it.
 - Remove the depressurized oil cap (red) and enter the suction pipe of the pump through the same hole. Ensure that the tubing reaches the bottom of the tank to suck any impurities. Empty the tank by pumping the oil in a suitable container. Please recycle used oil.
 - Using a funnel or filling gun, enter the amount of hydraulic oil indicated in the table, through the filling hole. Do not fill the tank completely, as a certain volume of air is required for expansion of the warm oil.
 - Move the piston up and down two or three times in order to purge and remove air pockets circuit. The lack of enough oil for operation can be seen that the piston rises "leapfrog" to allow air to enter the circuit.
 - If an oil suction pump is not available, the oil reservoir can be disassembled by releasing the oil reservoir tubes and screws. Remove the tank and pour the oil through the filling hole into a suitable container.



Using ISO high-pressure hydraulic oil (200 bar), the viscosity and quality level of ISO VG 46 are equivalent to ISO 6743-4:2015 DIN 51524-2 or HM: 2006-04 HLP.

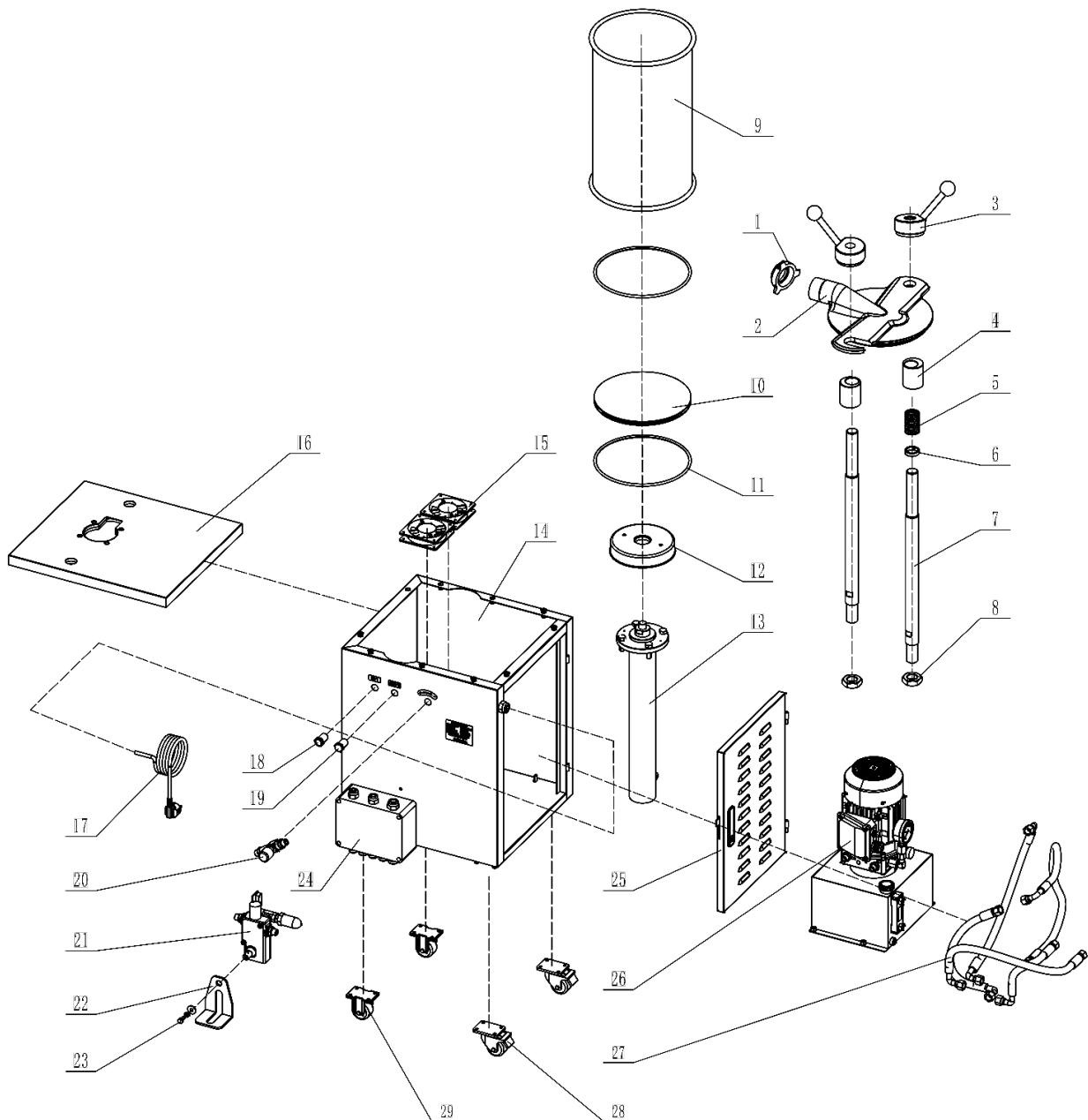
Troubleshooting

⚠ WARNING

- ALWAYS power off and unplug the machine from the electrical outlet before proceeding with cleaning, maintenance, or repairs.
- If you are unable to resolve the difficulty, DO NOT CONTINUE TO USE THE MACHINE and contact the dealer for service.

Problems	Possible Causes	Solutions
The machine is not working.	The machine is switched off.	Connect the machine.
	The machine is connected to a lower voltage.	Change the voltage of the machine to the right.
	Without tension in one or more stages.	Check fuses, plugs and switches.
	The internal micro switch on / off the knee lever is defective or not properly adjusted.	Contact an electrician to replace or readjusted.
The sound of the motor rotation is heard, but the piston does not go up or down when pushing the knee lever.	The pressure valve is at the minimum.	Increase pressure by turning knob clockwise.
	The motor turns in the opposite direction to the correct.	Permute two of the three phases in the plug.
The piston moves up and down but the machine seems to lack strength.	The air passage hole located at the base of the tank is clogged.	Clean it.
	The piston and the piston seal are dirty.	Clean them.
	The mains voltage is not compatible with the selected for the engine.	Contact an electrician to change the voltage of the machine.
	The three-phase motor (if applicable) is only running two phases.	Contact an electrician to check electric grid.
	There is little hydraulic oil.	Fill the oil reservoir up to "MAX"
	There is an oil leak in the fittings or pipes.	Call your local dealer.
	The chambers of the hydraulic cylinder are communicated.	Call your local dealer.

Part List



Part #	Description	Quantity
1	Stuffing tube locking nut	1
2	Upper cover of cylinder	1
3	Upper cover locking nut	2
4	Dismantling eccentric block of cylinder	2
5	Spring	1
6	Spring stop plate	1
7	Pillar	2
8	Pillar locking nut	2
9	Cylinder	1
10	Piston	1
11	Sealing ring	2
12	Cylinder sealing cover	1
13	Oil cylinder	1
14	Housing	1
15	Cooling fan	2
16	Upper housing cover plate	1
17	Power cord	1
18	Start button	1
19	Stop button	1
20	One-way throttle valve	1
21	Directional valve	1
22	Foot Pedal	1
23	Foot pedal fixing screw	1
24	Electrical control box	1
25	Housing door	1
26	Hydraulic station	1
27	Hydraulic oil pipe	1
28	Universal wheel with brake	2
29	Fixed casters	2



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