

PORTION CUTTING MACHINE FOR FRESH SAUSAGES

Mod. L-80



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1. INDUSTRIAS GASER

Since its foundation in 1969, INDUSTRIAS GASER has specialised in manufacturing a range of stainless-steel machinery for the meat industry.

Since 1985 we have constantly developed technology for GASER-brand hamburger-forming machines, developing a distinctive system based on a SIMPLER, MORE EFFECTIVE AND MORE ECONOMICAL TECHNIQUE.

In the 1990s, INDUSTRIAS GASER expanded into markets in various countries around the world, and not just in the hamburger sector.

We are aware that our work would be of no value without the trust of our existing clients and partners or the interest shown by those who wish to join them.

We thank them all.



INDUSTRIAS GASER

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For more information about the company and its products: www.gaser.com

2. EC DECLARATION OF CONFORMITY

We declare under our responsibility that the following machine:

Brand: GASER

Model: L-80

Serial no.

Year of construction:

is in conformity with the following regulations

UNE-EN ISO 12100:2012

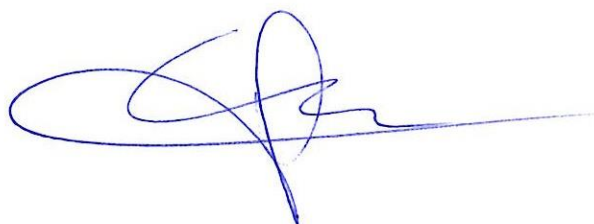
UNE-EN ISO 14120:2016

UNE-EN ISO 14121-1:2008

UNE-EN ISO 13849-1:2008/AC:2009

It is forbidden to make any change or modification to the machine without the prior written permission of our technical department. Use of the machine in these conditions could cause accidents, in which case INDUSTRIAS GASER S.L. accepts no liability for the improper use of the machine.

Salt,



CARLOS GARGANTA SERRAMITJA

TECHNICAL DIRECTOR INDUSTRIAS GASER S.L.

3. HYGIENE CERTIFICATE

We declare the machine:

Brand: GASER

Model: L-80

Serial no.

Year of construction:

is in conformity with the following regulations

Regulation (EC) 1935/2004, materials and articles in contact with food, repealing Directives 80/590/EEC and 89/109/EEC.

This means that all of the types of steel and plastic from which the machine is constructed and which are in contact with the meat comply with the hygiene rules and regulations in force.

* Plastic material: polyethylene terephthalate (PETP), white, density 1.37g/cm³,

Manufactured in accordance with DIN 50014.

* Stainless steel: AISI 304, manufactured in accordance with European regulations EN-10088,

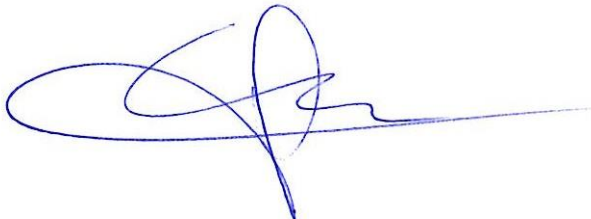
Chemical composition: C≤0.07% Si≤0.75% Mn≤2% Cr=18-19% Ni=8-10%

AISI 316, manufactured in accordance with European regulations EN-10088,

Chemical composition: C≤0.03% Si≤1% Mn≤2% Cr=18.5-16.5% Ni=13-10%

Mo=2.5-2%

Salt,



CARLOS GARGANTA SERRAMITJA

TECHNICAL DIRECTOR INDUSTRIAS GASER S.L.

4. INTRODUCTION

Before using or handling the machine, you must read this manual carefully. The instructions in this document are, whenever possible, accompanied by illustrations to help with understanding of how to start, use and clean the machine.

This manual is subject to amendment.

4.1 Safety

Making any change or modification to the machine without the prior written permission of our technical department is forbidden. Use of the machine in these conditions could cause accidents, in the event of which INDUSTRIAS GASER S.L. will accept no liability for improper use of the machine.

The machine has been designed for use with food products and must be used in the way described in this manual. Any use other than the specified one will involve risk for the user and for the machine. INDUSTRIAS GASER S.L. accepts no liability either for damage to the machine or personal injury or injury to third parties that this use might cause.

4.2 Hygiene

All of the materials used in the manufacture of the machine and which come into contact with food comply with Regulation 1935/2004. Consequently, the machine has the CE mark.

It is not recommended to use detergents containing chlorine, any of its derivatives or any other product that could damage the construction materials of the machine.

5. TECHNICAL SPECIFICATIONS

1. Twists and cuts fresh sausage
2. Produces 100 to 400 pieces/minute
3. Suitable for natural or artificial casing
4. Length of pieces with the standard L-80: 100, 120, 140, 160, 180 mm
5. Length of pieces with the special L-80: 160, 180, 200, 220, 240, 260, 280 mm
6. Sausage diameter from 10 to 35 mm.
7. Manual operation (5 pieces/rotation)
8. Tabletop machine
9. Made from stainless steel and non-toxic plastics (suitable for the meat industry)
10. Easy to maintain and clean
11. Measurements of the machine with packaging 570 × 510 × 240 mm
12. Weight of the machine 10 kg.

6. RECEIPT AND START-UP

6.1 Receipt

When you receive the machine, you must first check that it is in perfect conditions, without any damage, dents or knocks.

If there is any problem, we advise you to notify the distributor or INDUSTRIAS GASER S.L. directly.

6.2 Start-up

1. This machine basically comprises the following parts: the chassis, the blades, the eccentrics and the crank
2. It is important that when you start to portion the product, the machine is completely clean to ensure its correct functioning.
3. Depending on the length of the product to be prepared, the corresponding pair of eccentrics will be used (Pos. 2 overview).
- 3.1. To change the eccentrics, loosen the 5 blade assemblies (page 16) using the knurled nuts (Pos. 14 overview) and move them to the edge of the rotating plate (Pos. 1 overview) using the slots. Remove the eccentric fixing knob (Pos. 7 overview) and replace the eccentrics.

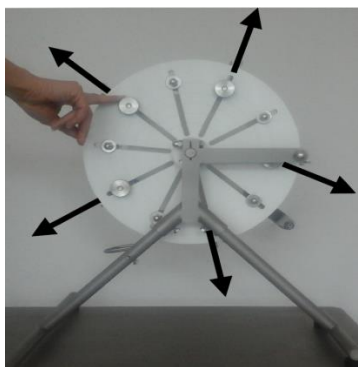


Photo 1. Loosen the nuts and slide the blades out of the way.



Photo 2. Remove the knob.



Photo 3. Remove the eccentrics.

- 3.2. To fit the eccentrics, tighten the eccentric fixing knob again. Take special care when putting the blades back in place as the blades must be positioned according to the grooves on the back face of the rotating plate. Each of these grooves corresponds to a 20 mm increase in the length of the product. Note that when adjusting the blades, they must **close completely** when passing over the widest point of the eccentric (Photos 6.1 and 6.2)

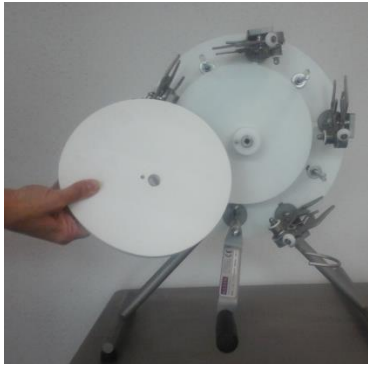


Photo 4. Fit the eccentrics.



Photo 5. Fit the knob.

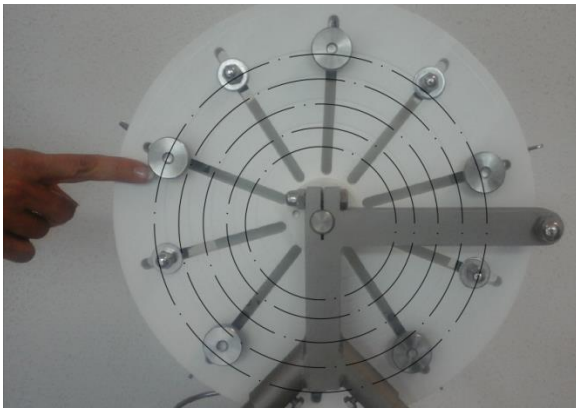


Photo 6.1. Adjust blades 1



Photo 6.2. Widest point on the eccentric (indicated by horizontal mark)

- 3.3. Once you have adjusted the blades, you must also adjust the position of the sausage support bars (Pos. 16 overview) so that a thread will pass tangential to them, as shown in Photo 7.

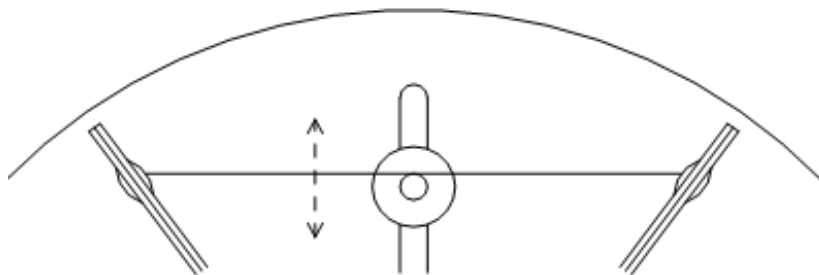


Photo 7. Adjust the sausage support bars

4. To start portioning, place the sausage so that a small amount is held by the clamps (Pos. 1, Photo 8). You can then start portioning. The sausage will be guided helped by the sausage guide bar (Pos 3. Overview).

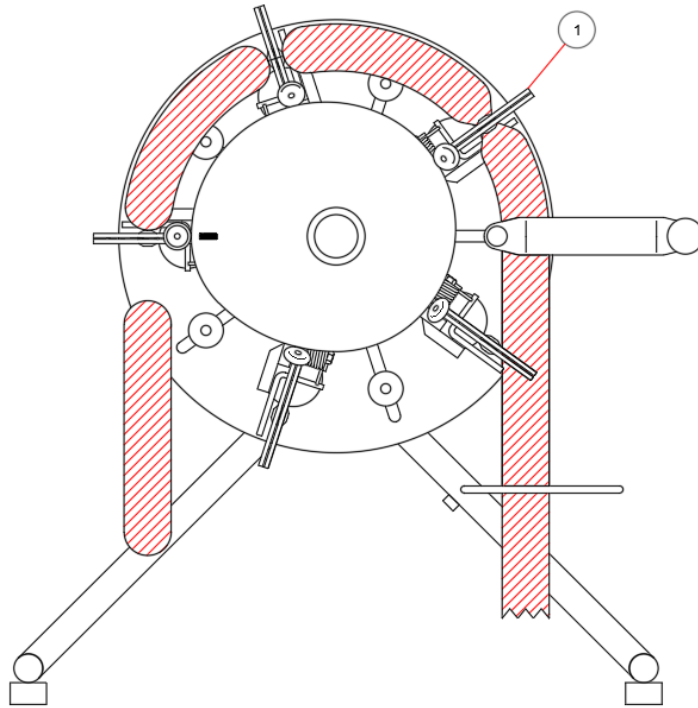


Photo 8. Positioning sausage

7. CLEANING

The machine can be cleaned without disassembly. To do this, water at low or medium pressure can be used with any neutral soap at a temperature of under 40 degrees centigrade.

For deep cleaning, we recommend disassembling the moving parts of the machine and then cleaning them.

It is important to dry the blades fully every time they are cleaned as if not, they might oxidise.

8. MAINTENANCE

1. Lubricate the central spindle (Pos. 15 overview) regularly with oil suitable for food-grade use.
2. Regularly check the condition of the blades. Ensure that they are sharp and are not bent. Also check that the rollers (Pos. 4 clamp assembly) turn correctly.
3. Check the condition of the surface of the eccentrics.
4. Regularly check the condition of the blade springs (Pos. 8 and 9 clamp assembly) to ensure they open and close correctly.
5. Regularly check the condition of the crank bearing (Pos. 3 crank assembly) and the central support (Pos. 10 overview).

9. TROUBLESHOOTING

A list is provided below of the problems that might occur with the machine, their potential causes and how to solve them.

Problem	Cause	Solution
The blades do not cut	Springs (Pos. 8 and 9 clamp assembly) worn out or in poor condition	Replace affected springs
	Clamps in clamp assembly bent	Straighten the blade if possible If this is not possible, it must be replaced
	A blade has come loose	Replace the affected blade assembly
	Blunt blade	Sharpen the blade (a special diamond file is required)
Crank hard to turn	The spindle (Pos. 15 overview) is not well lubricated	Lubricate with oil suitable for food-grade use
	The surface of the eccentrics is not smooth.	Replace the eccentric
	The rollers do not turn	1. If they are still round, lubricate with oil suitable for food use 2. If they are not still round, replace the effected rollers and lubricate with oil suitable for food-grade use
	Interior crank bearing (Pos. 4 overview) in poor condition	Replace bearing

10. GENERAL DISASSEMBLY

10.1 Overview

Number	Description	Reference	Units
1	STANDARD ROTATING PLATE	80030200	1
	SPECIAL ROTATING PLATE	80030200-EE	1
2	ECCENTRIC	PLEASE CONSULT	2
3	STANDARD SAUSAGE GUIDE BAR	80010400	1
	SPECIAL SAUSAGE GUIDE BAR	80010400-E	1
4	LONG BASE	80010200	1
5	SHORT BASE	80010300	1
6	RUBBER BASE	SI0226B250820N	4
7	ECCENTRIC FIXING KNOB	33000200	1
8	ECCENTRIC FIXING WASHER	80030500	1
9	ECCENTRIC FIXING RING	80030600	1
10	BEARING Ø8mm AISI-304	SI0109B08	1
11	ROTATING PLATE SUPPORT	80010500	1
12	STANDARD MAIN SUPPORT CHASSIS	80010100	1
	SPECIAL MAIN SUPPORT CHASSIS	80010100-EE	1
13	ROTATING PLATE SUPPORT	80030300	1
14	KNURLED NUT SUPPORT. CENTRAL PLATE	00100200	5
15	MAIN SPINDLE	80030100	1
16	SAUSAGE SUPPORT BAR	80030700	4
17	ECCENTRIC SEPARATOR	80030400	1
18	BRAND STICKER L-80	PA0230L80	1
19	CE STICKER	PA0230L80CE	1

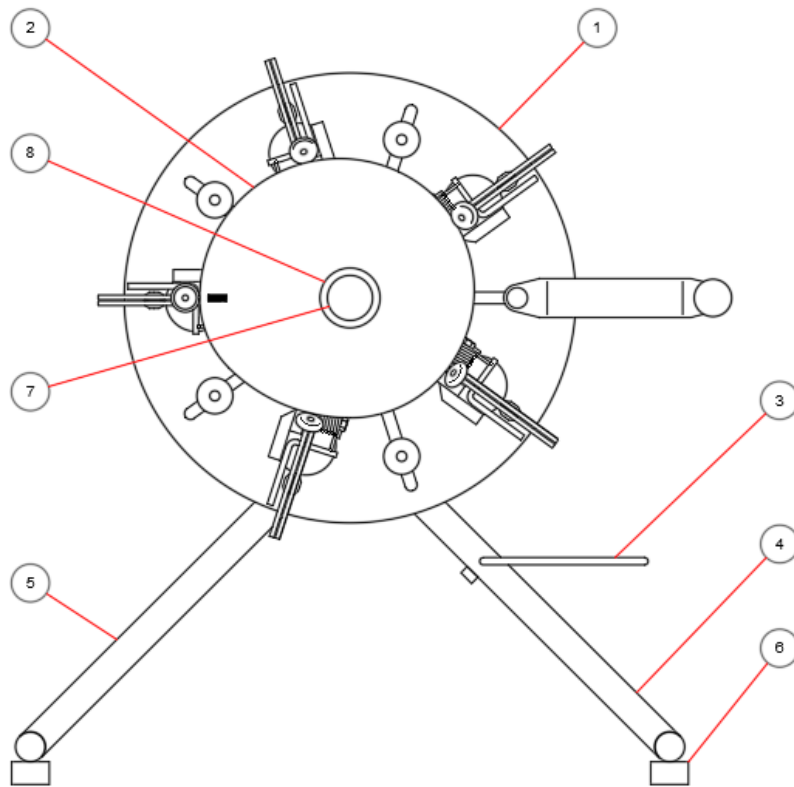


Diagram 1, Standard overview 1

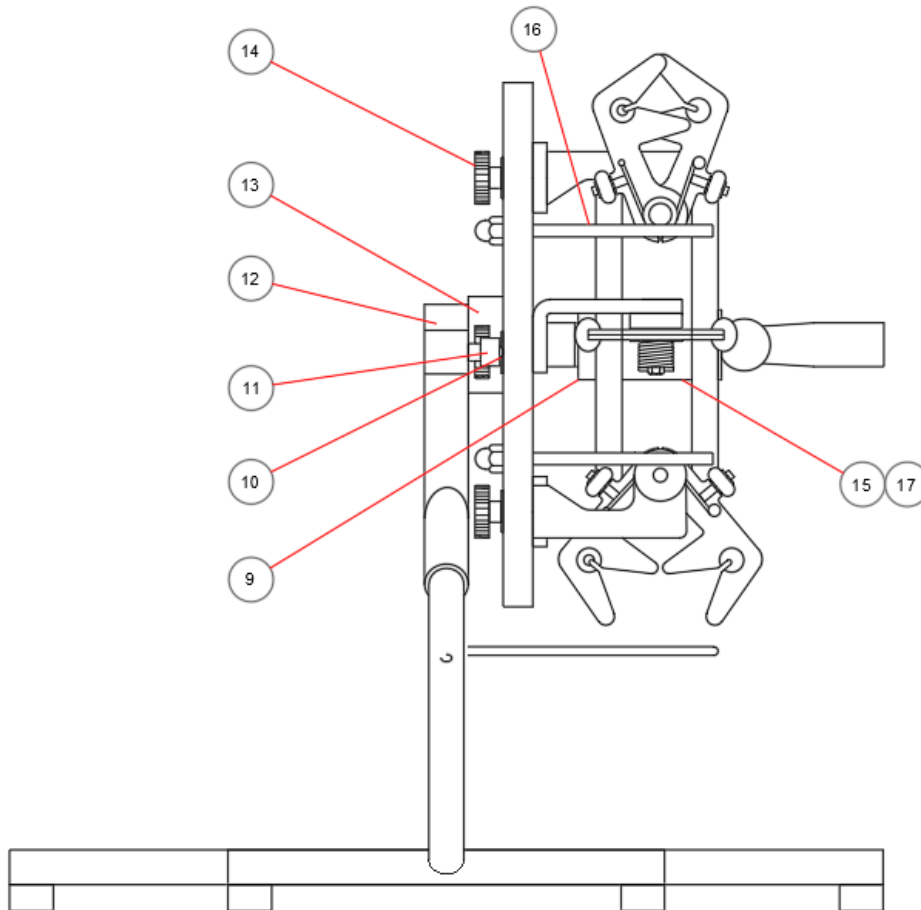


Diagram 2, Standard overview 2

10.2 Clamp assembly

Ref.88510000

Number	Description	Reference	Units
1	OUTER CUTTING CLAMP	80020100	1
2	INNER CUTTING CLAMP	80020200	1
3	CLAMP SUPPORT	80023300	1
4	ROLLER	80020700	2
5	CUTTING CLAMP AXLE SLEEVE	80020800	1
6	CLAMP SPREADER WASHER	80020900	2
7	CLAMP SPINDLE SLEEVE INNER WASHER	80021000	1
8	COMPRESSING CLAMP INNER SPRING	SI011415121.64	1
9	COMPRESSING CLAMP OUTER SPRING	SI0114T1.8	1
10	INNER CLAMP SLEEVE	SI0409A081108	1
11	DIN933 HEX SCREW M8x40 IN AISI-304	FE0108M080400933	1

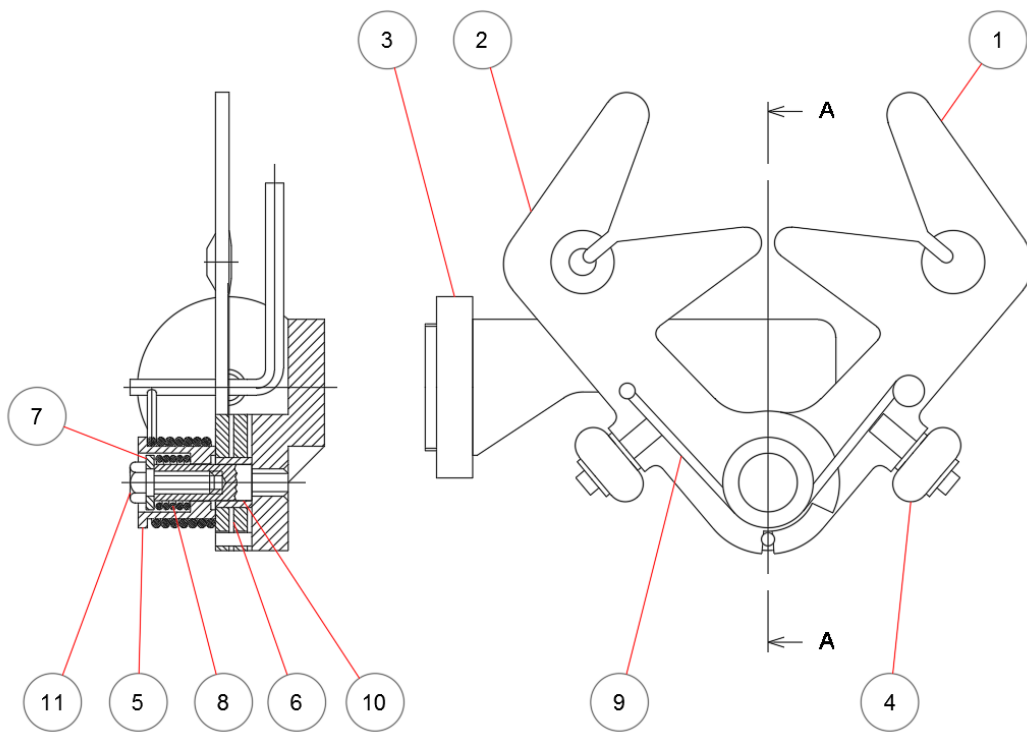


Diagram 3, Clamp assembly

10.3 Crank assembly

Standard model ref. 88540000

Special model ref. 88540000-EE

Position	Description	Reference	Units
1	CRANK AXLE	80040100	1
2	STANDARD CRANK ARM SPECIAL CRANK ARM	80040200 80040200-E	1 1
3	BEARING Ø4 AISI-304	SI0109B04	1
4	CRANK HANDLE	SI0612I601080M10	1

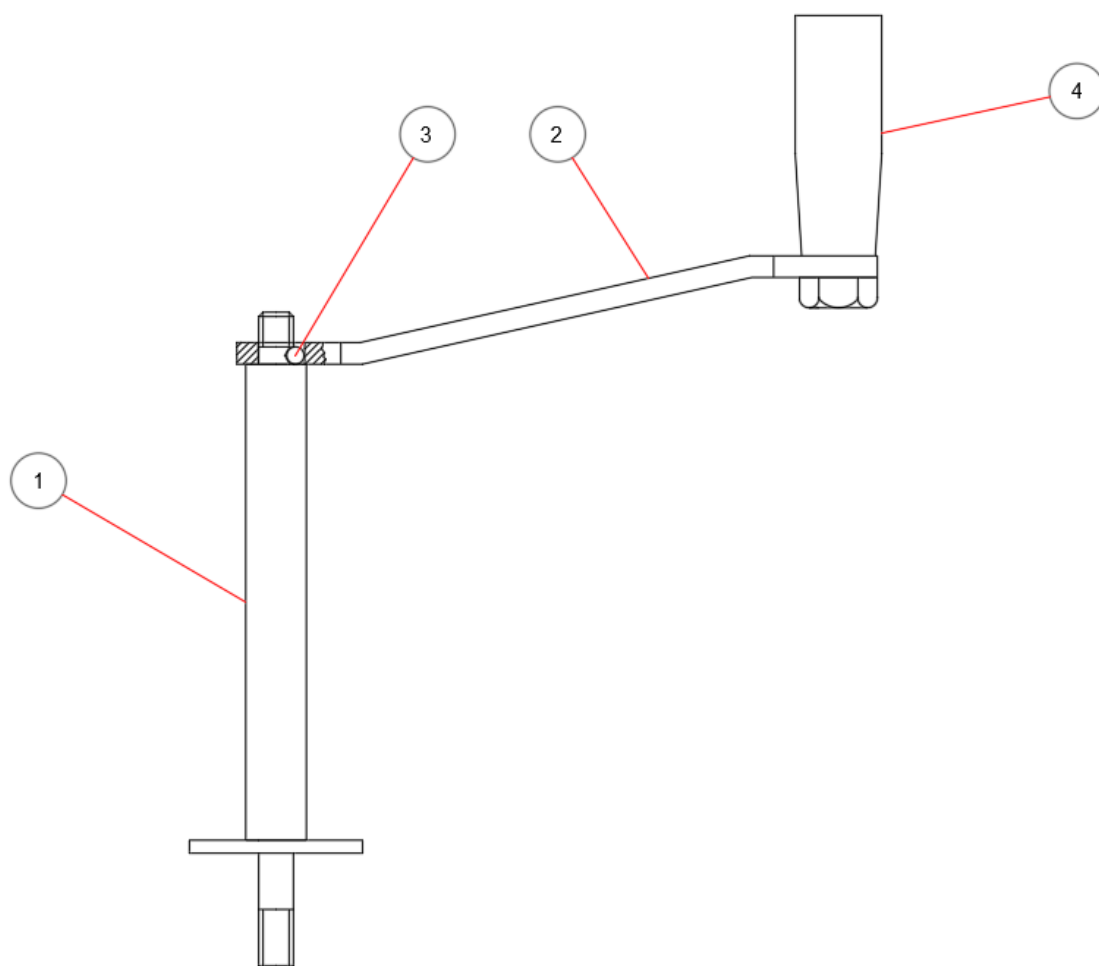


Diagram 4. Crank assembly

