



**ATTENTION:**

If any components of this unit are broken,  
or if the unit does not operate properly,  
please contact LEM Products at

**877-536-7763**

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THE LEADER IN GAME PROCESSING



# 5 LB. SAUSAGE STUFFER

**USE & MAINTENANCE**

1606 & 1606SS



**1 YEAR  
WARRANTY**

## ⚠ CAUTION ⚠

Before using the stuffer for the first time please make sure to read carefully and thoroughly through these operating instructions and the safety advice. Familiarize yourself completely with the functions of this product.

## ⚠ GENERAL WARNINGS AND SAFETY INFORMATION ⚠

1. Always ensure that the product is properly assembled and safely set up before use. Read assembly instructions in manual.
2. Any time you complete stuffing or raise the Piston out of the Cylinder, release the Handle slowly. Pressure or gravity could cause the Handle to spin back causing injury.
3. Check for damaged parts before using the product. Check that all parts are operating properly and perform the intended functions. Check for binding of moving parts, mounting and any other conditions that may apply.
4. The product is designed exclusively for domestic use and not for commercial purposes.
5. Do not force. Use correct sausage stuffer for your application. The correct sausage stuffer will do the job better and safer at the rate for which it was designed.
6. Keep your work area clean and well lit. Cluttered work benches and dark work areas may cause accidents or injury.
7. Handle carefully! Keep fingers and loose objects away from moving parts.
8. Tie back loose hair and clothing. Remove neckties, rings, watches, bracelets and all other jewelry before operating the unit.
9. Use the product with the supplied accessories only. **WARNING:** The use of attachments not recommended or sold by the manufacturer may cause injury, damage to personal property, and may void your warranty.
10. **WARNING:** Do not use while under the influence of alcohol or drugs (prescription or nonprescription) as these may impair user's ability to properly assemble or safely operate the product.
11. Thoroughly hand-wash all removable parts in warm soapy water prior to use. Do not soak. **NOT DISHWASHER SAFE** (discoloration may occur).
12. Use product on a level, stable surface to prevent tipping. Secure product with clamps on surface prior to use. Never move the product while unit is in use.
13. **CAUTION:** This product is not recommended for use near or by children or persons with certain disabilities without proper supervision. Set up and store the product out of reach of children. When not in use, store device in a secure dry place out of reach of children.
14. The manufacturer declines any responsibility in the case of improper use of this product. Improper use of this product voids the warranty.
15. **DO NOT** leave the product unattended.
16. **CAUTION:** This product is not recommended for use near or by children or persons with certain disabilities. Set up and store the product out of reach of children. When not in use, store product in a secure and dry place out of reach of children.
17. Avoid contacting moving parts. Wait until all parts have come to a complete stop and before removing any parts of the unit.
18. **WARNING:** The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions or situations that could occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

## 19. SAVE THESE INSTRUCTIONS

### IMPORTANT WARRANTY INFORMATION PLEASE READ FILL OUT AND RETURN ENCLOSED WARRANTY CARD

THIS WARRANTY COVERS:  
LEM 1606 & 1606SS 5 lb. Sausage Stuffer  
THE WARRANTY IS EXTENDED TO THE ORIGINAL PURCHASER ONLY.

**WARRANTY DURATION:** This product is warranted to the original purchaser for a period of one (1) year from the original purchase date. **EACH UNIT COMES WITH A WARRANTY CARD, WHICH MUST BE FILLED OUT COMPLETELY AND RETURNED IMMEDIATELY, WITH A COPY OF THE PURCHASING RECEIPT. FAILURE TO RETURN YOUR WARRANTY CARD WILL LIMIT WARRANTY TO 90 DAYS WITH PROOF OF PURCHASE.**

**WARRANTY COVERAGE:** This product is warranted against defective materials or workmanship. The warranty is void if the product has been damaged by accident, misuse, neglect, modification or improper service or repairs by unauthorized personnel. It is also void if damaged in shipment or by other causes not arising out of defects in the materials or workmanship. This warranty does not extend to any units which have been in violation of written instructions furnished. This warranty covers only the product and its specific parts, not food or other products processed in it.

**WARRANTY DISCLAIMERS:** This warranty is in lieu of all warranties expressed or implied, and no representative or person is authorized to assume any other liability in connection with the sale of our products. There shall be no claims for defects or failure of performance under any theory of sort, contract or commercial law including, but not limited to negligence, gross negligence, strict liability or breach of contract. The manufacturer declines all responsibility for damage to persons, things or animals arising from the failure to comply with the norms contained in this manual. The manufacturer reserves the right to make modifications at anytime to the models while maintaining the main characteristics described herein. The manufacturer also declines all responsibility for any errors in compiling this manual.

**WARRANTY PERFORMANCE:** During the above one year warranty period, a product with a defect will either be repaired or replaced after the product has been inspected by an LEM Service Technician. **LEM RESERVES THE RIGHT TO REFUSE WARRANTY PERFORMANCE OR PRODUCT EVALUATION UNLESS THE ORIGINAL SALES RECEIPT OR THE WARRANTY CARD IS ON FILE.** The repaired product will be in warranty for the balance of the one year warranty period. No charge will be made for such repair or replacement.

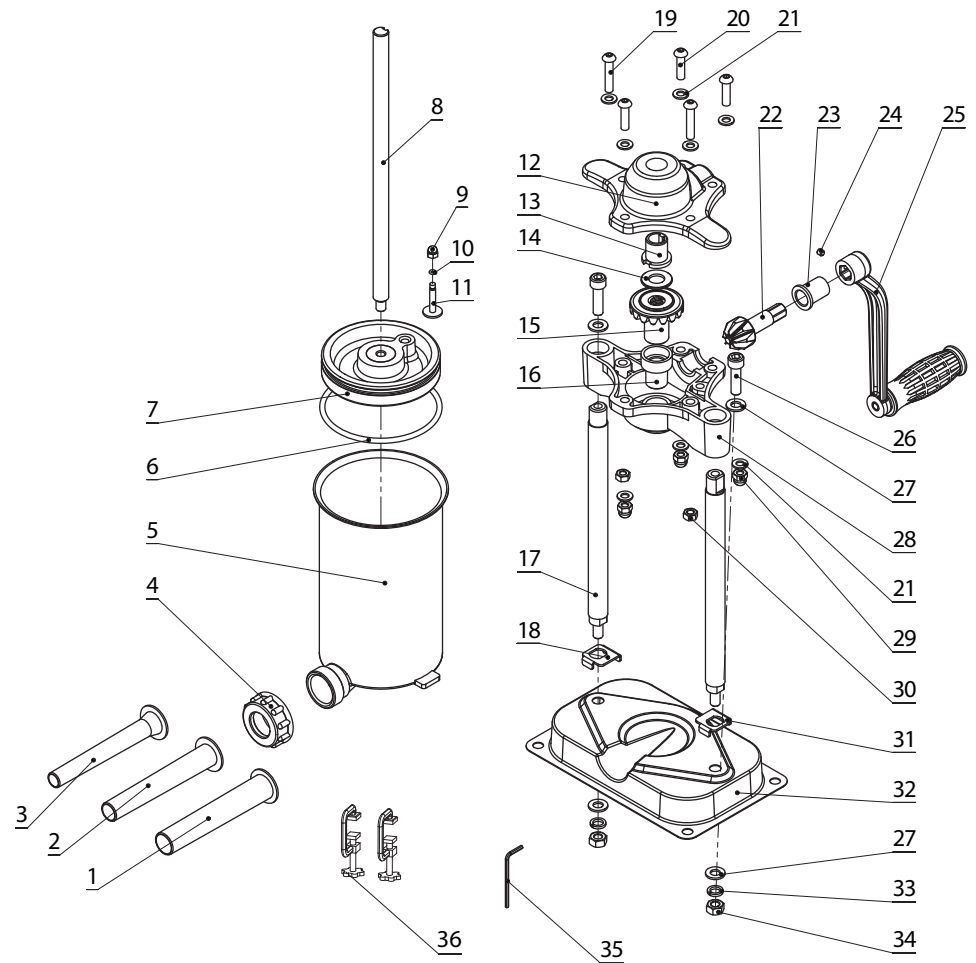
**IMPORTANT NOTICE:** If any parts are missing or defective, please contact our Customer Service Department for assistance at 877-536-7763. (M-F 8:30am to 4:30pm EST) **DO NOT RETURN TO THE STORE WHERE THE PRODUCT WAS PURCHASED.**

#### LEM PRODUCTS MERCHANDISE RETURN POLICY WARRANTY SERVICE:

To obtain service under terms of this warranty, please contact us at 877-536-7763 to obtain authorization prior to returning the merchandise. No merchandise will be accepted without prior authorization. Please return the product pre-paid in the original packaging if possible, enclose a copy of your receipt, (Keep a copy of your proof-of purchase for your records.) and include a written explanation of the issue. Ship to LEM Products, 4440 Muhlhauser Rd., Suite 300, West Chester, OH 45011-9767. LEM Products is not responsible for damage incurred in shipping, make certain to pack product properly. Return shipping charges are the responsibility of the purchaser. Packages returned to LEM should be insured for the value of the product to cover any damages that may occur during shipping.

Revised June 22, 2016

PART#	DESCRIPTION	QTY.PCS.
1	Stuffing Tube (Large) 1"	1
2	Stuffing Tube (Medium) 7/8"	1
3	Stuffing Tube (Small) 11/16"	1
4	Retaining Ring	1
5	Cylinder	1
6	Piston Gasket	1
7	Piston	1
8	Threaded Rod	1
9	Acorn Nut (M6)	1
10	O-ring for Air-Release Valve	1
11	Air Release Valve	1
12	Upper Cover	1
13	Metal Fixing Bushing	1
14	Washer for Vertical Gear	1
15	Vertical Metal Gear	1
16	Plastic Positioning Bushing	1
17	Vertical Shaft	2
18	Left Stop	1
19	Long Hexagon Socket Button Head Screw (M8*40)	2
20	Hexagon Socket Button Head Screw (M8*30)	3
21	Plain Washer (φ8)	8
22	Horizontal Metal Gear	1
23	Horizontal Gear Bushing	1
24	Hexagon Socket Set Screw with Flat Point (M6*6)	1
25	Handle Set	1
26	Hexagon Socket Head Cap Screw (M10*35)	2
27	Base Washer (φ10)	4
28	Lower Cover	1
29	Acorn Nut (M8)	3
30	Hexagon Nut (M8)	2
31	Right Stop	1
32	Base	1
33	Spring Washer (φ10)	2
34	Base Hexagon Nut (M10)	2
35	L-Hexagon Wrench	1
36	Clamps	2



\* Parts 1,2,3 Sold as a set  
 Parts 9,10,11 Sold as a set

## ! CAUTION !

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Read assembly instructions in manual.

This product is not recommended for use near or by children or persons with certain disabilities without proper supervision. Set up and store the product out of reach of children.  
When not in use, store product in a secure and dry place out of reach of children.

## CLEANING, ASSEMBLY AND PROPER USE

1. Remove the cylinder for cleaning.
2. Remove piston by unscrewing clockwise.
3. Remove air release valve by unscrewing the acorn nut.
4. Remove gasket from piston with a rounded tip of a spoon or similar dull tool.
5. To assist in removing excess meat from the Stuffing Tube tightly twist a corner of a paper towel, insert the twisted end into the stuffing tube and push meat out. A small wooden dowel or other straight, dull object is also helpful for this task.
6. Wash all removable parts in hot soapy water and dry thoroughly.
7. Wipe down the frame, base and gear case of the stuffer with a warm damp cloth.
8. Reassemble and spray with food grade Silicon Spray. (Available at LEM Products.)

## TROUBLESHOOTING

### Stuffer is hard to crank:

- Sausage mixture has become too stiff. Add water to mix.
- Add lubricant (mineral oil or vegetable oil) to the Piston Gasket and the interior of the Cylinder.

### Meat is passing by the Piston:

- Gasket is not installed.
- Gasket needs to be lubricated.

### Casings are bursting when filling:

- Casings are old and brittle.
- Casings were not soaked long enough.
- Casings were soaked too long.
- Casings should not have been soaked.
- Casings were filled too tightly.
- Stuffing Tube has a burr and is puncturing the casing.
- Stuffing tube is too large for casings.

## ! WARNING !

**HANDLE CAREFULLY!**  
**KEEP FINGERS AND LOOSE OBJECTS AWAY FROM MOVING PARTS!**

## MAKING SAUSAGE

**Before using the stuffer, always apply a food-grade lubricant to the inside of the cylinder and gasket to decrease friction.**

1. Collect ingredients: ground meat, ground pork or pork fat, your choice of sausage seasonings, cure (if used) and casings. (LEM carries a wide variety of casings, sausage seasonings, cure and other sausage enhancers.)
2. LEM suggests using an 80/20 ratio of lean meat to pork or pork fat. This ratio will make for a juicy sausage.
3. Combine meat with pork, seasonings (and cure if used), and 1 oz. of water per pound of meat being mixed. Water will not weaken the flavor but allows the meat to flow more freely through the stuffer and tube.
4. After meat is mixed, immediately begin the stuffing process. Meat mixed with the seasoning will quickly "set up" and become difficult to work with, which will cause undue stress on the stuffer gears.
5. Attach the handle to the gear. Tighten set screw with included allen wrench.
6. Free the cylinder by turning/cranking the handle counter-clockwise until the piston is free of the cylinder. Slide the cylinder out of the frame.
7. Place seasoned meat in the cylinder. Pack the meat tightly to minimize air pockets.
8. Slide the cylinder back into the frame.
9. Remove the retaining ring. Select the proper sized stuffing tube and insert it into the retaining ring. Screw the ring tightly to the cylinder.
10. Turn the handle clockwise so the piston moves down into the cylinder and the meat is extruded just to the end of the stuffing tube.
11. Slide the casing onto the proper size stuffing tube. (When using collagen casings it may be necessary to unfurl the casings and feed them on, just like natural casings.)
12. Fill casings until firm. If twisting into links is desired, you can do so as you fill or after the entire casing is filled. If the latter is desired do not over fill casing or it may burst upon twisting.
13. After extruding all the meat from the cylinder, turn the handle counter-clockwise so the piston backs out of the cylinder.

When salt is mixed with the meat along with other spices and ingredients, it causes the meat to stiffen, or "set-up" very much like cement. This process only requires 20-30 minutes to take effect. It then becomes very difficult to push the meat mixture through the stuffer. With a geared sausage stuffer, a stiffened meat mixture causes wear on the gears. We strongly recommend that the meat mixture be packed into the sausage stuffer right after it is mixed. Then, quickly fill the casings while the meat is pliable. **Applying food grade grease to the gears will make the gears work more smoothly and turning the handle much easier.**

LEM Products recommends that you use 1 oz. of water for each pound of meat used. If you are using soy protein concentrate, you can use 2 oz. of water per pound of meat.

Clean the stuffer using a mild detergent and warm water. Rinse and hand dry all parts. With normal use and maintenance, this stuffer will give you years of enjoyment. After washing the unit, spray it with a food grade Silicone Spray. This will prevent oxidation and will keep your stuffer like new. This silicone coating can be washed off easily with hot soapy water before the next use. Silicone Spray is available from LEM Products.