20 lb & 30 lb Motorized Stuffer Gearbox Replacement Procedure

Tools Required

- 3/32" Allen wrench
- 3/16" Allen wrench

Removal Procedure

1. Remove the motor.
2. Remove the white plastic piston from the plunger rod.
3. Lay the stuffer on its side and pull the plunger rod through the bottom hole in the frame.
4. Stand the stuffer upright.
5. Remove the gearbox housing panels by taking out the Allen-head screws on both sides using a 3/32" Allen wrench.
6. Pull the lower gearbox housing panel down and around the frame bolts to remove it.
7. Disconnect the magnet sensor from the frame:
    - Locate the plastic spring clips holding the wire connector in place.
    - Pinch the clips and pull the connector backward to remove it.
8. Remove the cast-iron gearbox assembly:
    - Remove the four Allen-head mounting bolts (two on each side of the frame) using a 3/16" Allen wrench.
    - Support the gearbox while removing the final bolts to prevent it from falling.

Installation Procedure

1. Position the new gearbox in the frame.
2. Install the four mounting bolts, but **do not fully tighten them**. Leave them loose for alignment. This step is critical.
3. Reconnect the magnet sensor wire connector to the frame.

WARNING: Failure to reconnect the magnet sensor can result in serious damage to the stuffer during motorized operation.

4. Reinstall the upper and lower gearbox housing panels.
5. Secure the panels with the eight small Allen-head screws.
6. Reinstall the main plunger rod by feeding it upward through the base opening and into the gearbox.
    - The gear teeth will only allow installation in the correct orientation.
7. Thread the white plastic piston back onto the plunger rod.
8. Install the meat cylinder and secure it by locking the cylinder brackets onto the frame mounting bolts.
9. Crank the piston all the way to the bottom of the cylinder as though stuffing sausage.
10. Once the piston reaches the bottom of the cylinder, tighten the four gearbox mounting bolts that were left loose during installation.

Final Assembly

1. Verify all hardware is secure.
2. Test the unit by hand-cranking the stuffer.
3. Reinstall the motor if desired.

IMPORTANT: Do not forget to reconnect the motor wire connector to the frame before operating the unit.

Alignment Note

The four gearbox mounting bolts must remain loose until the piston has been cranked completely to the bottom of the cylinder. This allows the gearbox to self-align before final tightening and helps prevent binding or premature wear.