
INSTRUCTION MANUAL

HAND STACKER PA1025

Capacity 1000kg



Note: The Owner/Operator must read carefully and understand all the information presented here before operation.

IMPORTANT

Please read, understand and follow these safety rules and operating instructions before operating this machine. Only trained and authorized personnel should be permitted to operate this machine. Please replace Part No. 138 with hole prior to use. (See P9)

I. Safety Rules



Failure to obey these instructions and safety rules in this manual may result in death or serious injury.

1.1 Do Not Operate Unless:

- 1) You learn and practice the principles of safe machine operation contained in this operating manual.
 - Avoid hazardous situations.
 - Always perform a pre-operation inspection.
 - Always perform the function tests prior to use.
 - Inspect the workplace.
 - Only use the machine as a material lift.
- 2) You read, understand and obey:
 - Manufacturer's instructions and safety rules
 - Employee's safety rules and worksite regulations
 - Applicable governmental regulations

1.2 To Avoid Hazardous Situations:

- 1) Fall Hazards
 - Do not use as a personnel lifting platform or step.
 - Do not load unstable or loosely stacked loads.
- 2) Tip-over Hazards
 - Do not overload the machine. Check load diagram on the machine for different centered capacity machine.
 - Do not raise the load unless the machine is on a firm, level surface.
 - Do not move the machine with a raised load, except for minor positioning.
 - Do not operate the machine in strong or gusty winds.
 - Prior to use, check the work area for drop-offs, holes, bumps, debris, unstable surfaces or other possible hazardous conditions.
 - Do not subject the machine to horizontal force by raising or lowering a fixed or overhanging load.
- 3) Collision hazards
 - Do not lift if the load is not properly centered on the forks. Check load diagram on the machine for correct load center position.
 - Check the work area for overhead obstruction or other possible hazards.

Do not stand under or allow personnel under the machine when the load is raised.

Do not lower tile load unless the area below is clear of personnel and obstructions.

4) Bodily Injury Hazard

Always keep hands and fingers away from pulleys, the carriage and other potential pinch points.

5) Improper Use Hazard

Never leave a machine unattended with a load. Unauthorized personnel may attempt to operate the machine without proper instruction creating an unsafe situation.

6) Damaged Machine Hazards

Do not use a damaged or malfunctioning machine.

Do not use a machine with a worn, damaged or more than 3% elongation chain.

Be sure that all decals are in place and legible.

Maintain proper lubrication of chain and other movable parts.

7) Lifting Hazard

Use proper lifting techniques to load the machine.

2. Pre-operation Inspection

The operator should perform a visual inspection prior to each work shift to discover if anything is wrong with a machine.

2.1 Be sure that the instruction manual is complete, legible and available for reference.

2.2 Be sure that all decals are legible and in place.

2.3 Checking the following components or areas for damage and improperly installed, loose or missing parts:

- ~ Pump Unit and Related Components
- ~ Base Compo~ lol! S
- ~ Legs
- ~ Rollers
- ~ Frame
- ~ Chain and Pulleys
- ~ Casters
- ~ Forks
- ~ Brake System
- ~ Handle
- ~ Nuts, Bolts and Other Fasteners

2.4 Check entire machine for:

- ~ Dents or damage
- ~ Corrosion or oxidation
- ~ Cracks in welds or structural components

3. Function Tests

The operator must follow the step-by-step instructions to test all machine functions.

3.1 Test the Brake Operation

- 1) Press down on the foot pedal to lock the brake.
- 2) Push the machine. The machine should not move.
- 3) Pull up on the foot pedal to release the brake.
- 4) Push the machine. It should now move freely.

3.2 Test the Control Lever Functions

- 1) Set the control lever in the ASCENT position.
The carriage should rise to the top of the mast while pumping the handle.
The carriage should move smoothly, free of hesitation and binding.
- 2) Set the control lever in the NEUTRAL position.
The carriage should not rise or lower while pumping the handle.
- 3) Set the control lever in the LOWER position.
The carriage should lower into the mast. The carriage should move smoothly, free of hesitation and binding.

Note: A damaged or malfunctioning machine must never be used. If damage or malfunctions are discovered during pre-operation inspection or function tests, the machine must be tagged and removed from service. Repairs to the machine may only be made by a qualified service technician and according to the manufacturer's instructions. After repairs are completed, the operator must perform a pre-operation inspection and function test again before putting the machine into service.

4. Workplace inspection

To operate the machine safely, the operator should inspect the workplace prior to moving the machine to the workplace.

Be aware of and avoid the following hazardous situations:

- 1) Drop-offs or holes
- 2) Bumps and floor obstructions
- 3) Debris
- 4) Overhead obstructions and high voltage conductors
- 5) Hazardous locations
- 6) Inadequate surface support to withstand all load forces imposed by the machine
- 7) Wind and weather conditions
- 8) All other possible unsafe conditions

5. Operating Instructions

Using the machine for any purpose other than lifting material is unsafe.

5.1 Raising and Lowering Load

- 1) Please load centrally across the forks. Check the load diagram on the machine for correct load center position.
- 2) Raise the load by pumping the handle into the ASCENT position.
- 3) Lower the load by setting the control lever in the LOWER position.

5.2-Moving Machine with a Load

It is best to move the machine without load. Moving a raised load should be restricted to positioning for loading and unloading. If it is necessary to move the machine with a raised load, understand and obey the following safety rules:

- 1) Area is level and clear of obstructions.
- 2) Load is correctly centered on the forks.
- 3) Avoid sudden starts and stops.
- 4) Travel with load in the lowest possible position.
- 5) Do not tilt the machine back with a raised load by pulling the C-shape handle on the mast.

6) Keep personnel away from machine and load.

5.3 Moving Machine on Small Slopes

The machine shall not be used on gradients. If it is necessary to negotiate small slopes for the purposes of moving the truck between buildings etc., understand and obey the following safety rules:

1. The gradient shall be no more than 2%.
2. The machine shall be unloaded.
3. The forks shall be facing downgrade.

5.4 Actual Operating Capacity

The actual operating capacity of the machine is the responsibility of the user. It may depend on the operator, floor and machine conditions and frequency of the load handling cycle.

If the load exceeds the actual operating capacity, the operator must be assisted by one or more persons.

6. Maintenance

6.1 Periodic Maintenance

Periodic maintenance will prolong the lifetime of the machine.
See the table below for period of maintenance.

Item	Check	Period		
		1 month	6 months	12 months
Frame	Check the loading parts		•	
Wheels	Check wearing bearing and bearing housing	•		
Turning	Check whether it turns properly	•		
Hydraulic unit	Oil level Change oil Check safety		•	• •
Lifting chain	Check the extension rate and wear	•		
Brake	Check whether it functions properly	•		
Moveable parts	Check lubrication and tear	•		

6.2 Oil

1) Add oil

If the forks do not lift to maximum height, you should add oil. Restore the fluid level in the reservoir to 2mm below the oiling hole, this must be with the forks in the lowered position.

2) Change oil

Drain the oil in pump unit off. Then add oil as item 1).

3) Use the hydraulic type oil according to the temperature scale below.

Temperature	Oil
-20°C – 40°C	L-HM46 Hydraulic oil (equivalent to ISO VG46)

6.3 How To Expel Air Form The Pump Unit

Air may enter the unit when the seals are replaced. Lift the control lever to the LOWER position, and then move the handle up and down for dozens of times.

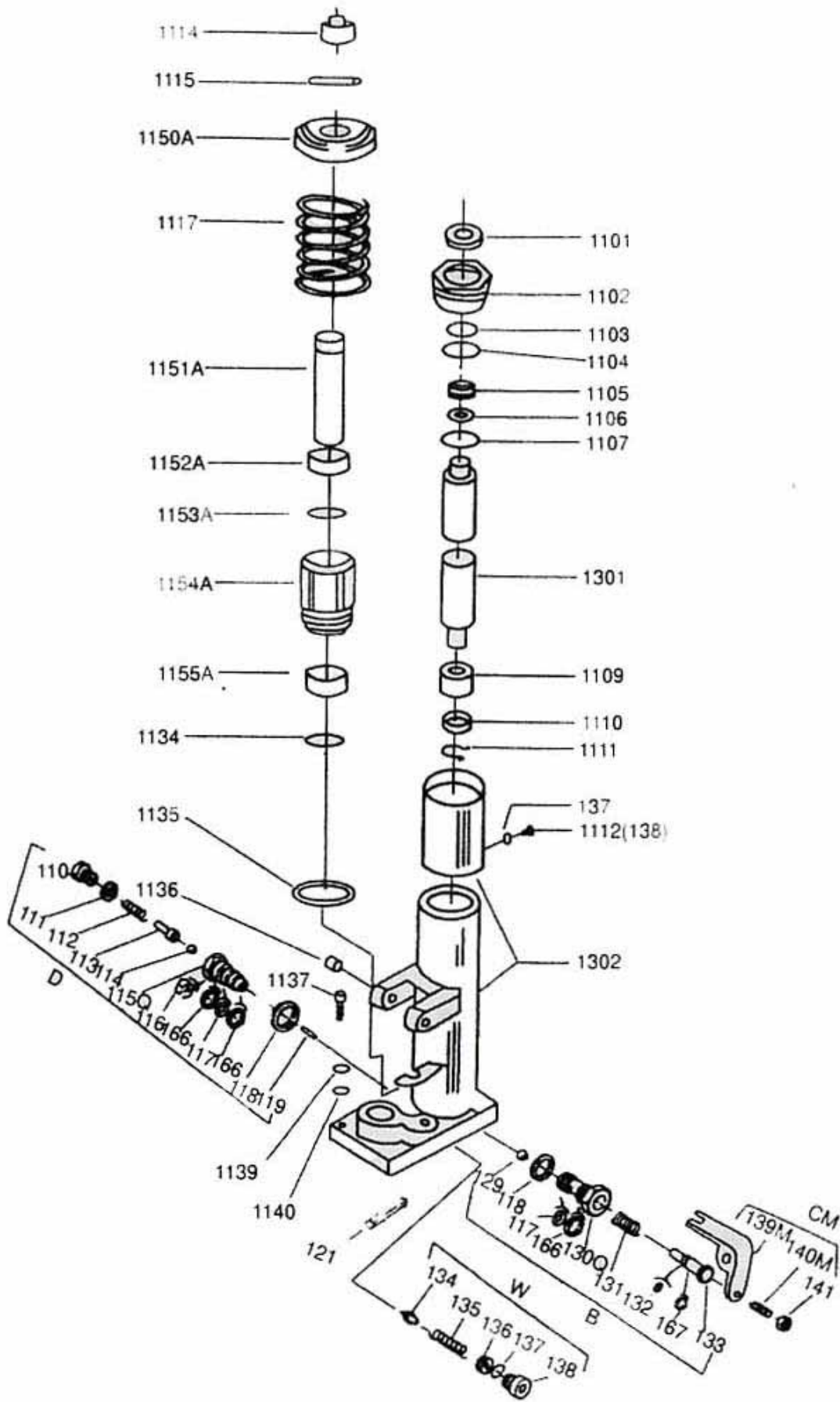
7. Troubles shooting

No.	Trouble	Cause	Action
1	The forks do not lift to maximum height.	Not enough hydraulic oil.	Add more oil.
2	The forks do not lift up.	Not enough hydraulic oil. The oil has impurities. Discharge valve is out of adjustment. Air in the hydraulic oil.	Add more oil. Change the oil. Adjust the setting screw(140M). Expel the air(see item 6.3).
3	The forks do not descend.	The rod(1301) is deformed resulting from seriously unbalanced load. A part has been broken or been deformed resulting from unbalanced load. The setting screw(140M) is not in the correct position.	Replace the rod (1301). Repair or replace component. Adjust the setting screw (140M).
4	Leaks	Seals worn out or damaged. Some parts may be cracked or worn out.	Replace seals with new ones. Check and replace with new ones.
5	The forks descend without being lowered.	Impurities in the oil cause the discharge valve(B) to fail to close. Air in the oil. Seals worn or damaged. Discharge valve(B) is out of adjustment.	Replace with filtered oil. Expel the air(see item 6.3). Replace with new ones. Adjust the setting screw(140M).

Note: Do not attempt to repair the hand hydraulic stacker unless you are trained and authorized to do so.

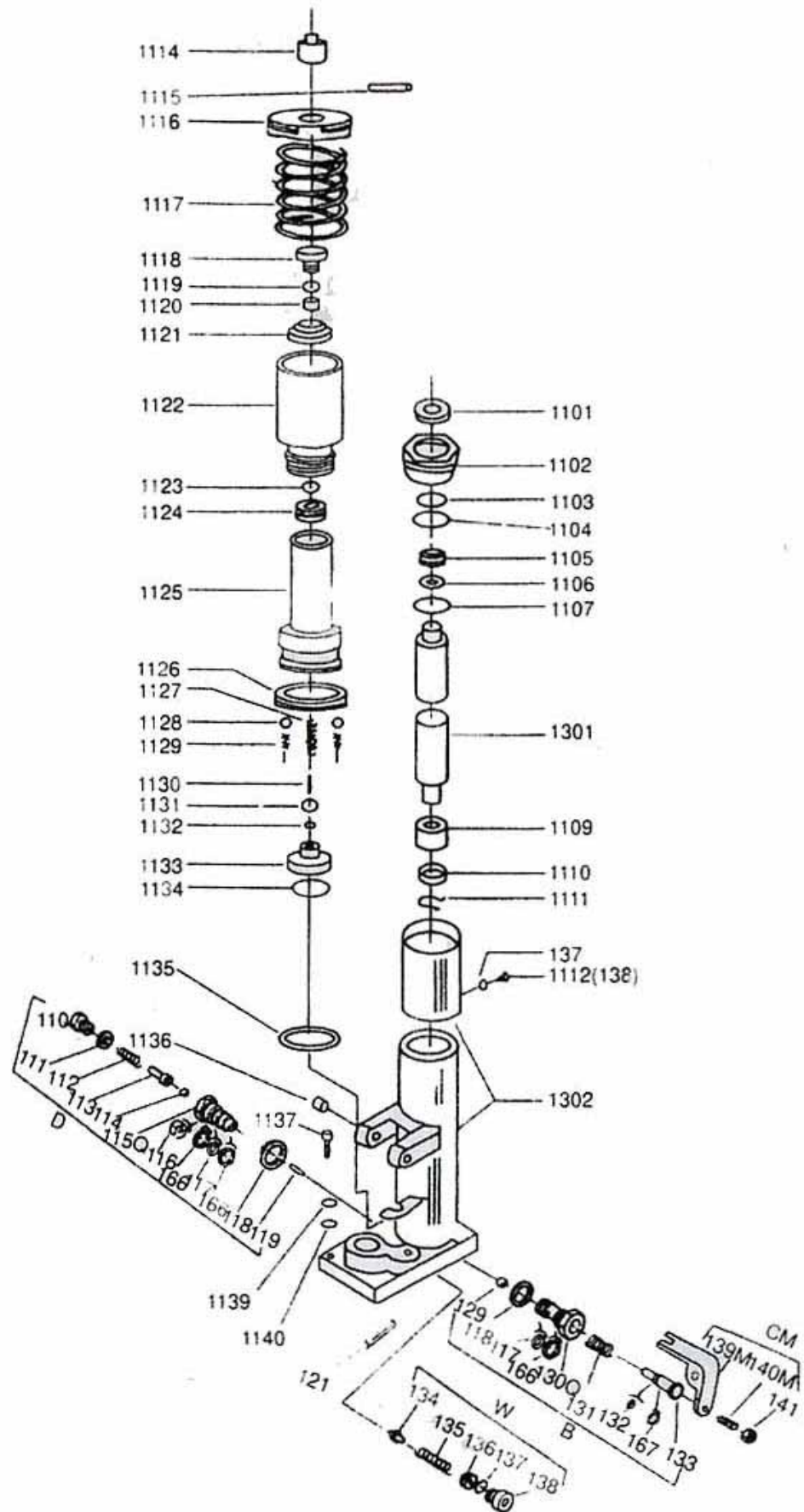
8.Specifications

Model	PA1025
Capacity	1000kg
Maximum fork height	2500mm
Minimum fork height	88mm
Fork width	160mm
Fork length	1150mm
Overall fork width	fixed: 540mm adjustable: 346~710mm
Load roller	φ 80 x 70mm
Steering wheel	φ 150 x 50mm
Overall length	1604mm
Overall width	760mm
Overall height	1774mm
Net weight	330kg



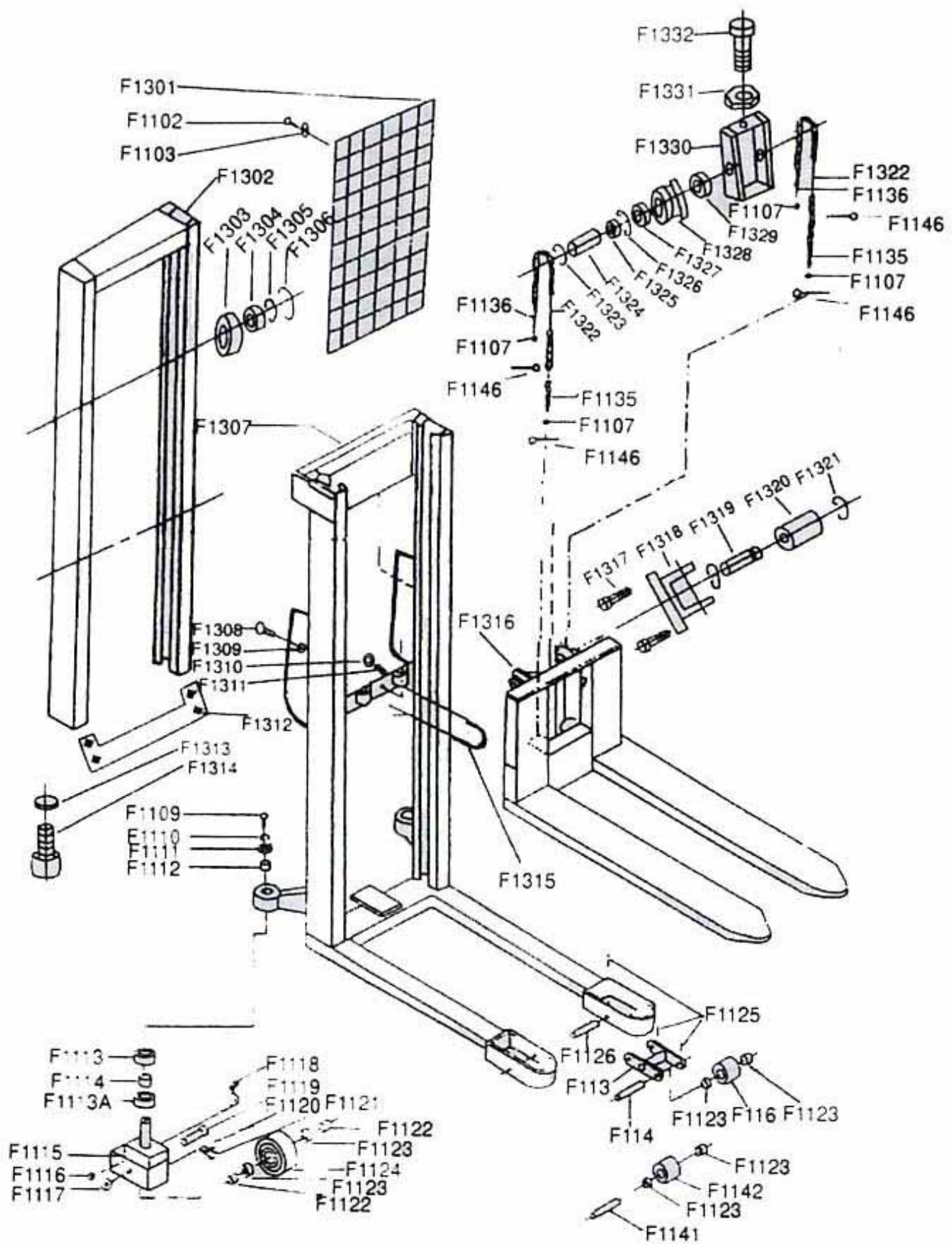
Parts List of Pump Unit (Standard)

Parts No.	Description	Q'ty	Parts No.	Description	Q'ty
1101	Dust proof ring	1	1155A	Seal ring	1
1102	Cylinder	1	110	Screw	1
1103	O-ring	1	111	Red copper washer	1
1104	O-ring	1	112	Spring	2
1105	Seal ring	1	113	Pressure rod	1
1106	Spacing washer	1	114	Steel ball	1
1107	O-ring	1	115Q	Pressure valve body	1
1301	Rod	1	116	Split ring	1
1109	Guide casing	1	166	Retainer	1
1110	Washer	1	117	O-ring	1
1111	Retaining ring	1	118	Red copper washer	2
1112	Screw	Each 1	119	Steel needle	1
1302	Welded bond	1	121	Spring pin	1
1114	Pressure bond	1	129	Steel ball	1
1115	Spring pin	1	130Q	Discharge valve body	1
1117	Spring	1	131	Spring	1
1134	O-ring	1	132	O-ring	1
1135	Red copper washer	1	167	Retainer	1
1136	Bushing	2	133	Discharge valve shaft	1
1137	Bolt	4	134	Valve taper core	1
1139	Spring washer	4	135	Spring	1
1140	Plain washer	4	136	Pressure regulating screw	1
1150A	Spring cover	1	137	O-ring	1
1151A	Pump plug	1	138	Screw	1
1152A	Dust proof ring	1	139M	Crank link	1
1153A	O-ring	1	140M	Setting screw	1
1154A	Pump body	1	141	Nut	1



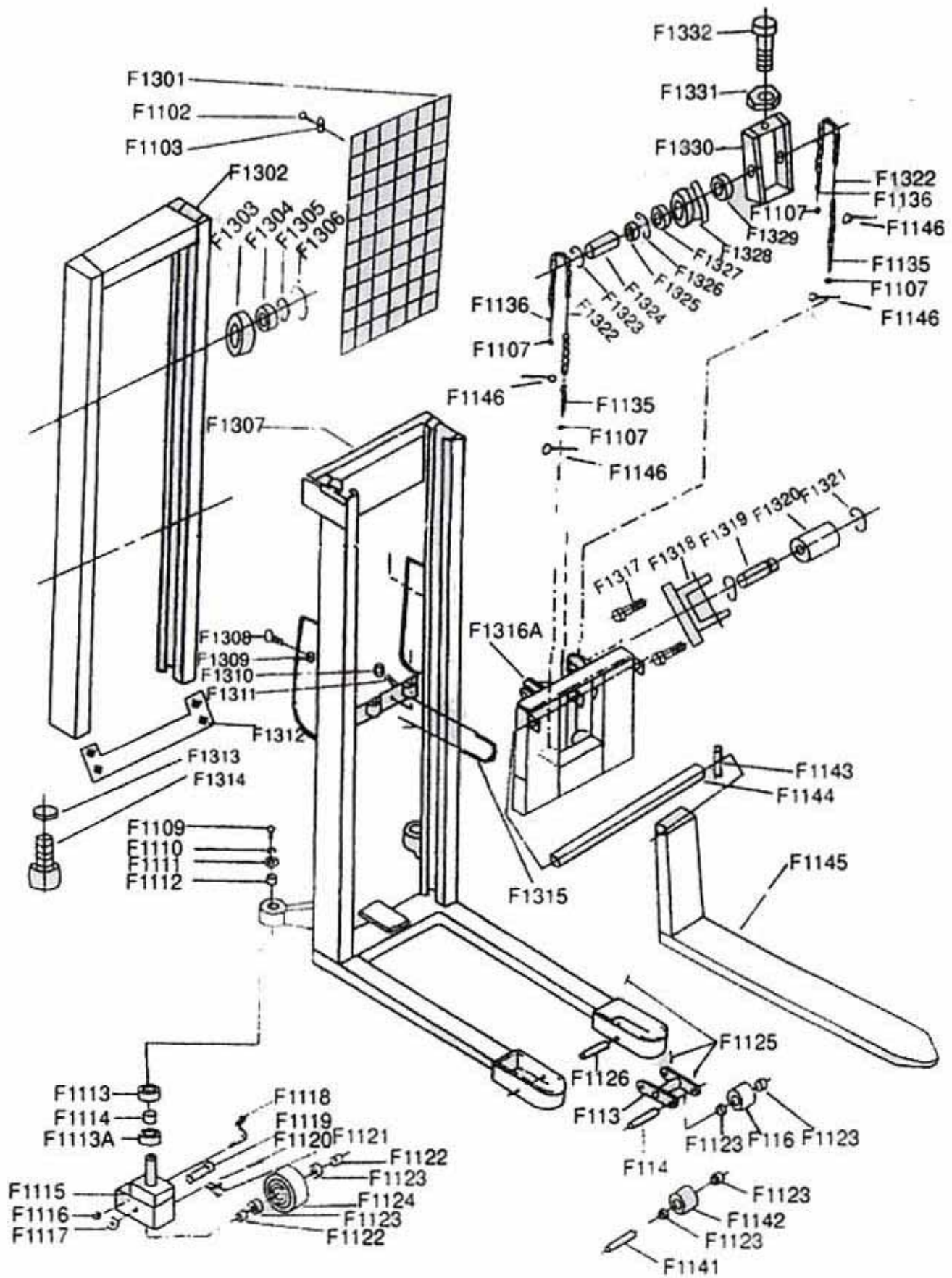
Parts List of Pump Unit (Quick Lift)

Parts No.	Description	Q'ty	Parts No.	Description	Q'ty
1101	Dust proof ring	1	1134	O-ring	1
1102	Cylinder	1	1135	Red copper washer	1
1103	O-ring	1	1136	Bushing	2
1104	O-ring	1	1137	Bolt	4
1105	Seal ring	1	1139	Plain washer	4
1106	Spacing washer	1	1140	Steel ball	4
1107	O-ring	1	110	Screw	1
1301	Rod	1	111	Red copper washer	1
1109	Guide casing	1	112	Spring	1
1110	Washer	1	113	Pressure rod	1
1111	Retaining ring	1	114	Steel ball	1
1112	Screw	Each	115Q	Pressure valve body	1
1302	Welded bond	1	116	Split ring	1
1114	Pressure bond	1	166	retainer	3
1115	Spring pin	1	117	O-ring	2
1116	Spring cover		118	Red copper washer	2
1117	Spring	1	119	Steel needle	1
1118	Screw		121	Spring pin	1
1119	O-ring		129	Steel ball	1
1120	Pressure regulating		130Q	Discharge valve body	1
1121	Dust proof ring		131	Spring	1
1122	Pump body		132	O-ring	1
1123	O-ring		167	retainer	1
1124	Seal ring		133	Discharge valve shaft	1
1125	Pump plug		134	Valve taper core	1
1126	Seal ring		135	Spring	1
1127	Spring		136	Pressure regulating screw	1
1128	Steel ball		137	O-ring	2
1129	Spring		138	screw	1
1130	Pressure rod		139M	Crank link	1
1131	Steel ball		140M	Setting screw	1
1132	O-ring		141	Nut	1
1133	Valve reseater				



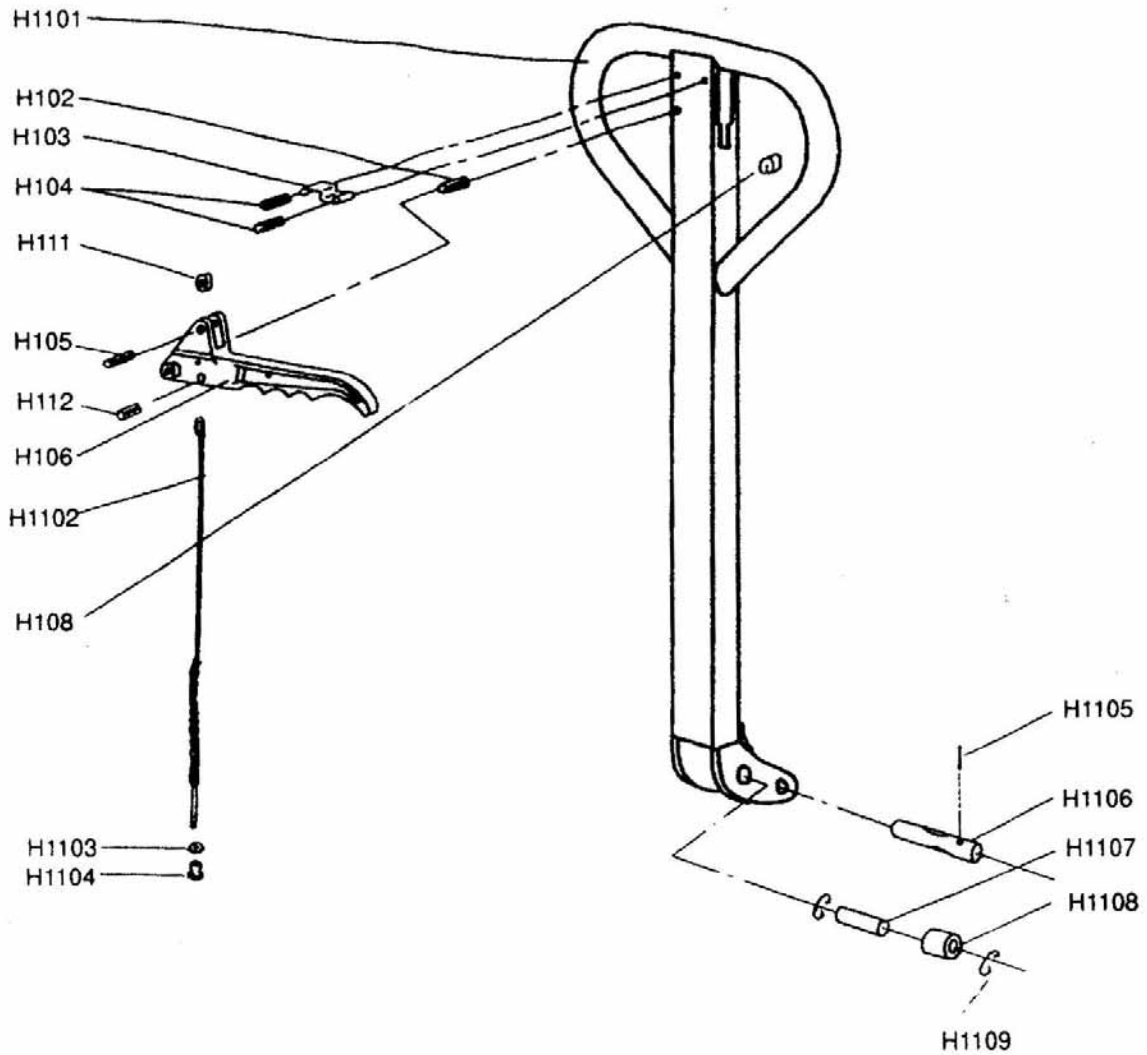
Parts List of Frame (Fixed)

Parts No.	Description	Q'ty	Parts No.	Description	Q'ty
F1301	Safety net	1	F1332	Bolt	1
F1302	Welded bond	8	F1102	Screw	6
F1303	Roller	2	F1103	Washer	6
F1304	Bearing	8	F1107	Nut	4
F1305	Retaining ring	1	F1109	Bolt	4
F1306	Retaining ring	1	F1110	Spring washer	2
F1307	Frame	4	F1111	Washer	2
F1308	Rubber cushion	2	F1112	Casing	2
F1309	Nut	2	F1113	Bearing	2
F1310	Nut	2	F1113A	Bearing	2
F1311	Spring	2	F1114	Casing	2
F1312	Link plate	1	F1115	Steering wheel	2
F1313	Spring washer	4	F1116	Self-locking nut	2
F1314	Bolt	4	F1117	Nut	2
F1315	Type U bolt	1	F1118	Foot pedal	2
F1316	Welded bond	1	F1119	Steering wheel axle	2
F1317	Bolt	16	F1120	Pin	2
F1318	Guide roller bracket	8	F1121	Spring leaf	2
F1319	Axle	8	F1122	Casing	4
F1320	Guide roller	8	F1123	Bearing	12
F1321	Retaining ring	16	F1124	Steering wheel	2
F1322	Chain	2	F1125	Spring pin	6
F1323	Retaining ring	2	F1126	Pivoted axle	2
F1324	Axle	1	F1135	Bolt	2
F1325	Dividing bush	2	F1136	Bolt	2
F1326	Retaining ring	2	F1141	Axle (single type)	2
F1327	Bearing	2	F1142	Load roller (single type)	2
F1328	Chain pulley	2	F1146	Split pin	4
F1329	Casing	1	F113	Adjustable bracket	2
F1330	Chain pulley bracket	1	F114	Axle (tandem type)	4
F1331	Nut	1	F116	Load roller (tandem type)	4



Parts List of Frame (Adjustable)

Parts No.	Description	Q'ty	Parts No.	Description	Q'ty
F1301	Safety net	1	F1103	Washer	6
F1302	Welded bond	8	F1107	Nut	4
F1303	Roller	2	F1109	Bolt	4
F1304	Bearing	8	F1110	Spring washer	2
F1305	Retaining ring	1	F1111	Washer	2
F1306	Retaining ring	1	F1112	Casing	2
F1307	Frame	4	F1113	Bearing	2
F1308	Rubber cushion	2	F1113A	Bearing	2
F1309	Nut	2	F1114	Casing	2
F1310	Nut	2	F1115	Steering wheel	2
F1311	Spring	2	F1116	Self-locking nut	2
F1312	Link plate	1	F1117	Nut	2
F1313	Spring washer	4	F1118	Foot pedal	2
F1314	Bolt	4	F1119	Steering wheel axle	2
F1315	Type U bolt	1	F1120	Pin	2
F1316A	Welded bond	1	F1121	Spring leaf	2
F1317	Bolt	16	F1122	Casing	4
F1318	Guide roller bracket	8	F1123	Bearing	12
F1319	Axle	8	F1124	Steering wheel	2
F1320	Guide roller	8	F1125	Spring pin	6
F1321	Retaining ring	16	F1126	Pivoted axle	2
F1322	Chain	2	F1135	Bolt	2
F1323	Retaining ring	2	F1136	Bolt	2
F1324	Axle	1	F1141	Axle (single type)	2
F1325	Dividing bush	2	F1142	Load roller (single)	2
F1326	Retaining ring	2	F1143	Spring pin	2
F1327	Bearing	2	F1144	Shaft	1
F1328	Chain pulley	2	F1145	Adjustable fork	2
F1329	Casing	1	F1146	Split pin	4
F1330	Chain pulley bracket	1	F113	Adjustable bracket	2
F1331	Nut	1	F114	Axle (tandem type)	4
F1332	Bolt	1	F116	Load roller (tandem type)	4
F1102	Screw	6			



Parts List of Handle

Parts No.	Description	Q'ty	Parts No.	Description	Q'ty
H1101	Handle	1	H102	Spring pin	1
H1102	Rod and chain	1	H103	Spring leaf	1
H1103	Nut	1	H104	Spring pin	2
H1104	Nut	1	H105	Spring pin	1
H1105	Spring ring	1	H106	Control level	1
H1106	Pin	1	H108	Rubber cushion	1
H1107	Axle	1	H111	Nylon roller	1
H1108	Steel roller	1	H112	Spring pin	1
H1109	Retaining ring	2			