



## OPERATING MANUAL Gfp 563TH-4



**Please read this manual carefully before operating!**  
Unpacking, assembly, and operating videos are available at  
[www.gfpartnersllc.com](http://www.gfpartnersllc.com)

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## 1. Introduction

Thank you for choosing the Gfp 563TH laminator. It has been designed and manufactured to provide years of continuous service. Please read this manual thoroughly before operating. Please inspect the box and the laminator for shipping damage. Damage should be brought to the attention of the delivering carrier immediately

We reserve the right to make changes to this publication and to the products described in it without notice. The details given in this manual are based on the most recent information available to us. They may be subject to change in the future. We retain the right to make changes to the construction or the design of our products without accepting any responsibility for modifying earlier versions

**WARNING!** Any unauthorized changes or modifications to this unit without our prior written approval will void the user's warranty and will transfer health and safety obligations to the end user.



**CAUTION!** Please pay attention to all passages with these symbols. This information is vital to preventing user injury and/or damage to the unit. Failure to follow this information could void the user's warranties and transfer all safety obligations to the user.

## 2. Important Safety Instructions



In this operating manual, you will find important safety messages regarding the product.

Read these instructions carefully, failure to comply with the following safety procedures could result in serious injury.


**WARNING** Do not attempt to service or repair the laminator. Only authorized maintenance and service technicians should make repairs.




**WARNING** Do not connect the laminator to an electrical supply or attempt to operate the laminator until you have completely read these instructions. Maintain these instructions in a convenient location for future reference.

**WARNING** To guard against injury, the following safety precautions must be observed in the installation and use of the laminator

## 3. Installation Safeguards



- Shipping damage should be brought to the immediate attention of the delivering carrier
- Avoid locating the laminator near sources of heat or cold. Avoid locating the laminator in the direct path of forced, heated or cooled air
- The receptacle must be located near the equipment and easily accessible.
-  Connect the attachment plug provided with the laminator to a suitably grounded outlet only. This machine must have reliable earth ground to ensure the safety of the machine during operations

- Contact an electrician should the attachment plug provided with the laminator not match the receptacles at your location
-  Ensure that the voltages of the power supply you are using match the rated working voltages before operations. Do not use incorrect power supply
-  Do not use damaged wires or sockets. If abnormal conditions occur, switch off the power supply first.
-  Only a licensed electrician should install wiring and outlet for the laminator
- Do not defeat or remove electrical and mechanical safety equipment such as interlocks, shields and guards

## 4. Regulatory Compliance Statements



### cTUVus Certification

This test mark, also referred to as the "cTUVus mark", serves as proof of compliance with US national standards from UL adopted by OSHA and the Canadian national standards of CSA adopted by the Standards Council of Canada (SCC). US Authorities having Jurisdiction (AHJs) and Provincial Regulators across Canada recognize the cTUVus mark as proof of product compliance to published national standards and code requirements. The cTUVus mark is officially recognized as an equivalent and direct replacement of the UL and CSA marks.



### Federal Communications Commission (FCC) Compliance Statement

This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

## CAN ICES-3(B)/NMB-3(B)


### Industry Canada Emission Compliance Statement

This Class B digital apparatus complies with Canadian, CAN ICES-3(B)/NMB-3(B), interference-causing equipment regulation.

Changes or modifications made to this device that are not expressly approved by Gfp, may void the user's authority granted by the FCC and/or by Industry Canada to operate the equipment.

## 5. General Safeguards



- Keep hands, long hair, loose clothing, and articles such as neckties away from rollers to avoid entanglement and entrapment. The rollers have pinch points that can trap body parts or clothing and cause serious injury
- Do not use the machines for purposes other than lamination and mounting, otherwise damages to the machine or accidents may occur
- Keep out of reach of children
- Keep flammable and wet objects away from the machine.
- Do not use flammable sprays or materials when cleaning the machine
- Do not leave the machine unattended during operations.
- Do not mount metal materials or other hard objects.
- Do not put burrs, sharp blades or rigid materials in between the two rubber rollers.
- Do not attempt to laminate items that exceed total recommended material thickness of the unit.
- Do not touch the rollers when they are hot or place foreign object inside the machine.
- Do not cut adhesive films directly on the surface of the rollers to avoid damaging the rubber coating.
- Shut down the machine after laminating to avoid misuse by others.
- Shut down the power before moving the machine
- Note the locations of castors while moving or operating this machine to avoid injuries to your feet.
-  Disconnect from the power supply before repair or maintenance.



- Disconnect from the power supply when the machine is not in use for a long time.
- When the machine lies idle for a long period of time, raise the top rubber roller to avoid flat spots on the rubber surface.
- Do not cover the surface of the machine until the machine has completely cooled.
- Perform only the routine maintenance procedures referred to in these instructions

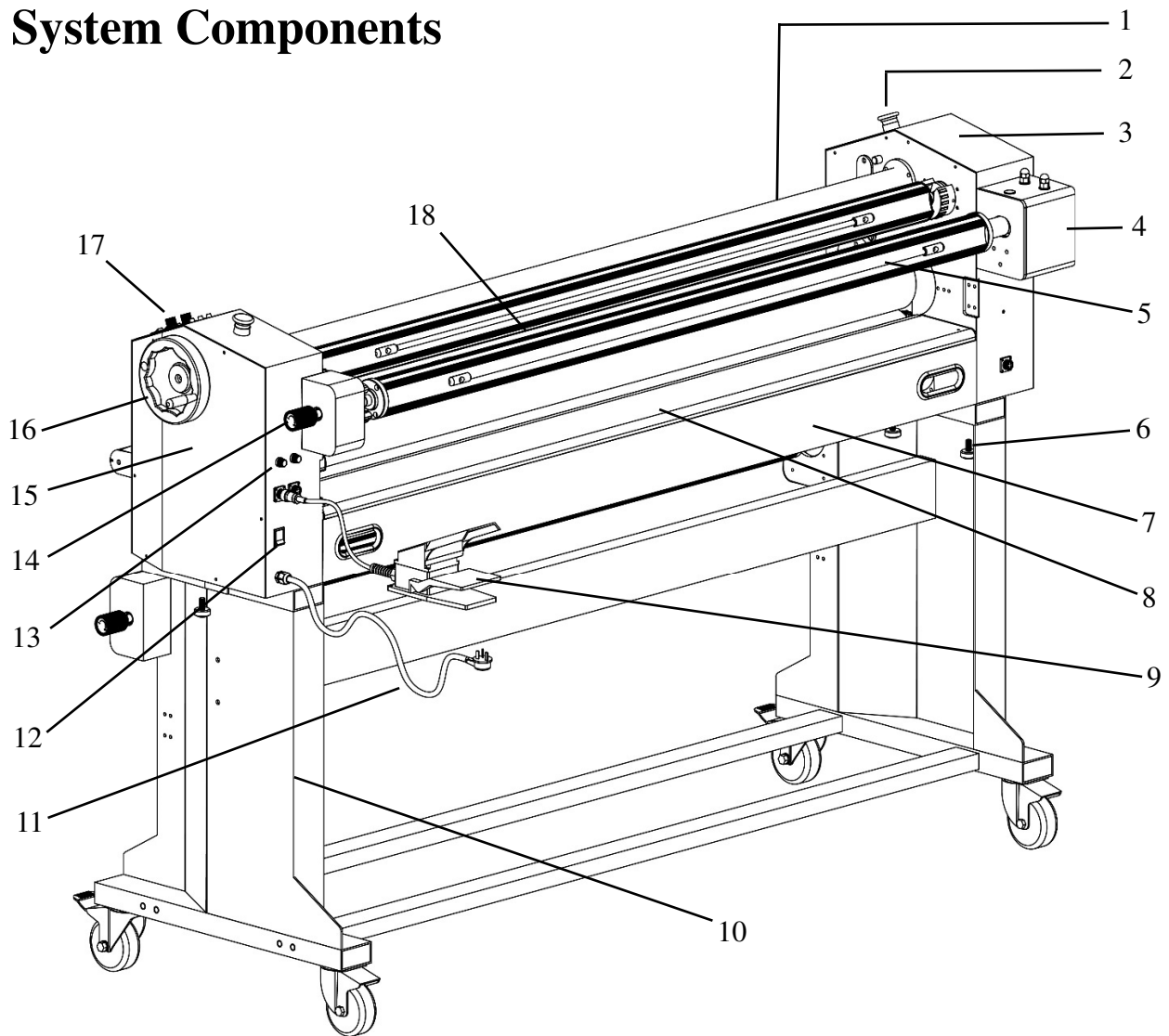
## 6. Operating Conditions

- Place machine on level surface
- Environment requirements :
- Ambient temperature: 50<sup>0</sup> F - 104<sup>0</sup> F
- Humidity : 30%—80% ; ideal humidity : 55%
- Due to the static on film rolls, you should try to keep the environment clean.
- Provide enough space around machine to ensure the safe and effective operation. The minimum area covered is 8 ft. x 10 ft.
- Do not directly cut the films on the surfaces of the rubber rollers to avoid damages to the rollers.
- Do not put burrs, sharp knives or extra thick and hard materials in between the rollers. Do not leave objects like tools, rulers, knives, etc. on the working panels or the side cabinets to avoid their being rolled into the machine accidentally and damaging the rollers.
- For repairs and replacements, please contact your local distributor. Unauthorized repairs and dismantling will affect future maintenances of the machines.
- The machine can laminate continuously objects less than ½” thick.
- For objects over ½” but less than 1” thick, use the foot pedal switch.
- Operator should be present while machine is in operation

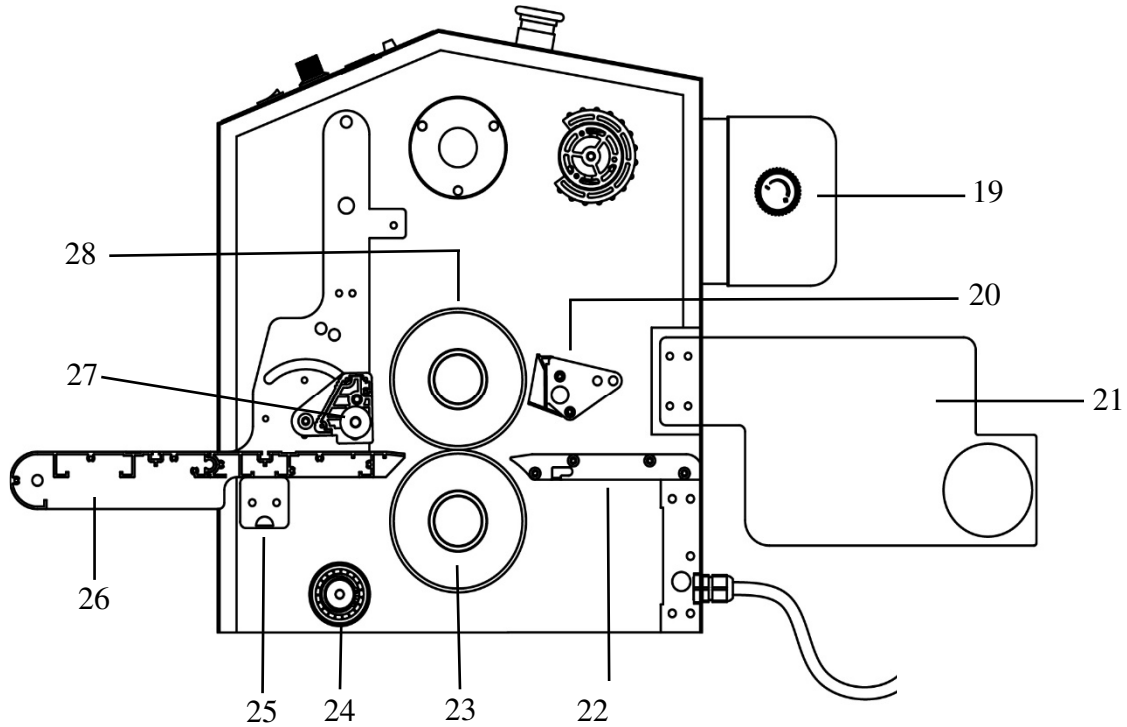


***Warning: Do not keep the machines in direct sunshine or near it.  
Do not keep the machine in dusty places or places with strong vibrations.***

## 7. System Components



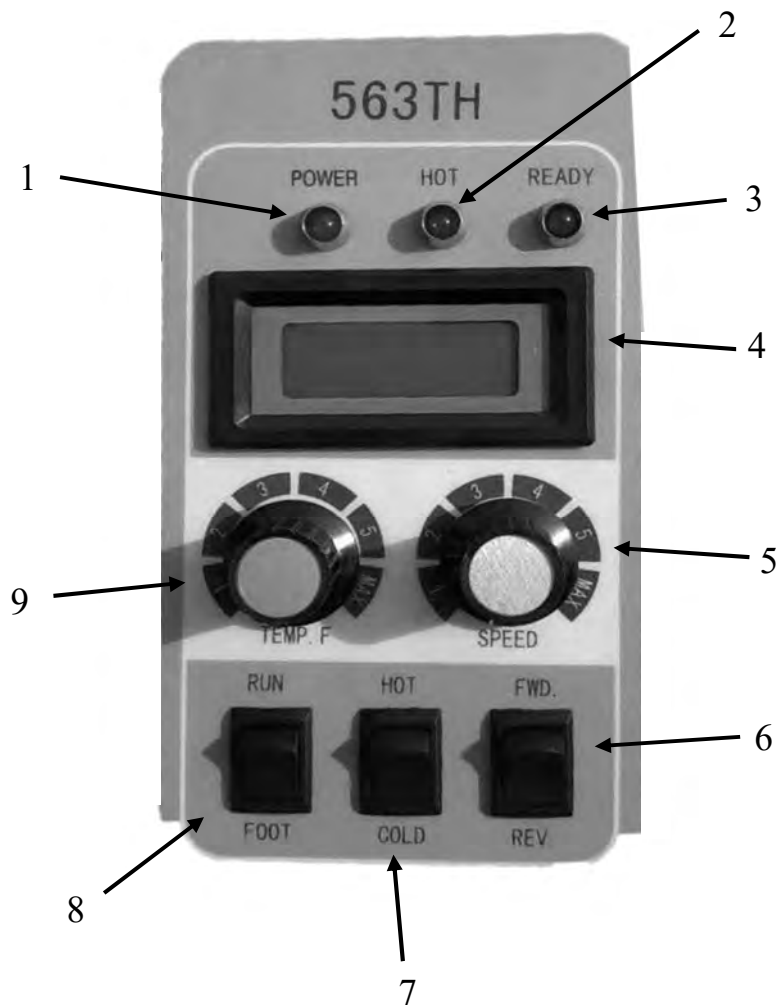
- |                             |                                       |
|-----------------------------|---------------------------------------|
| 1 Linkage Axle              | 10 Stand                              |
| 2 E-STOP                    | 11 Power Cord                         |
| 3 Left Cabinet              | 12 Main Power Switch                  |
| 4 Swing-out Shaft Cover     | 13 Fuses                              |
| 5 Upper Unwind Supply Shaft | 14 Supply Shaft Brake Adjustment Knob |
| 6 Stand Securing Bolts      | 15 Right Cabinet                      |
| 7 Rear Support Beam         | 16 Pressure/Gap Hand Wheel            |
| 8 Exit Table                | 17 Control Panel                      |
| 9 Foot Pedal                | 18 Upper Rewind w/Cardboard Tube      |



- 19 Supply Shaft Cradle and Brake Assembly
- 20 Temperature Sensor
- 21 Lower Rear Rewind
- 22 Exit table
- 23 Lower Nip Roller
- 24 Lower Idler and Support Bar
- 25 Support Cross Member
- 26 In-feed Table
- 27 Pressing Roller
- 28 Top Heat Roller



## 8. Control Panel



- |                               |                               |
|-------------------------------|-------------------------------|
| 1. Power indicator            | 6. Forward / Reverse Switch   |
| 2. Hot laminating indicator   | 7. Hot / Cold heater Switch   |
| 3. Ready light indicator      | 8. RUN / FOOT pedal operation |
| 4. Temperature display screen | 9. Temperature adjustment     |
| 5. Speed adjustment           |                               |

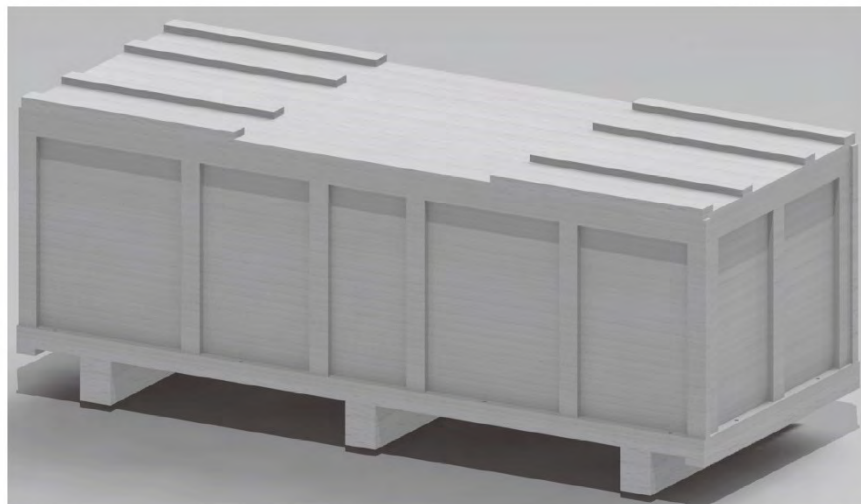
### Note:

1. The machine does not have continuous reverse. Reverse can only operate using the pedal switch
2. If the photo-electric eye stops the machine, move operation switch to FOOT then back to RUN for continuous operation.

## 9. Packing List

Remove all parts from shipping create and boxes. Inspect parts and the machine carefully. Any missing parts should be reported to the shipper upon receipt of shipment.

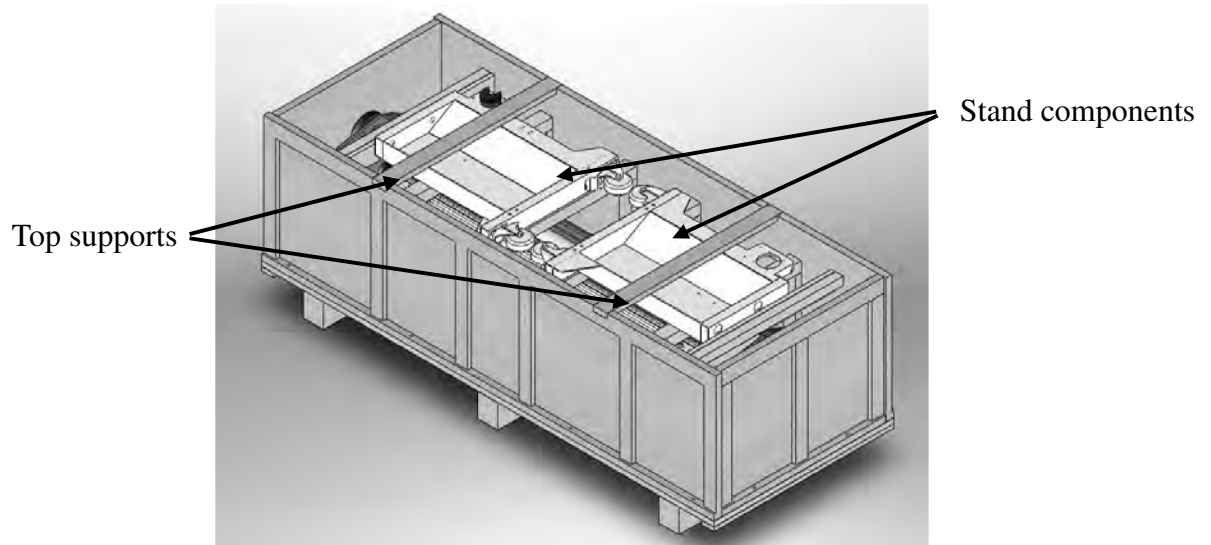
Main Machine Crate		Stand Box	
Part	Quantity	Part	Quantity
Main Machine	1	Fuse 2 Amp	2
Swing out shaft assembly	1	Cross beams	2
Rewind tube	1	Middle beam	1
Media support brackets	3	Left side stand	1
Alignment bracket	2	Right side stand	1
Anchor bolts (M8)	2	Alignment disk	2
Stand anchor bolts (M10)	4	Allen wrench 6mm	1
Flat washer	4	T-spanner 5mm T	1
Flat washer	2	Socket head cap screw (M8×100)	8
Spring spacer	4	Socket head cap screw (M8×20)	4
Spring spacer	2	Socket head cap screw (M6×16)	6
Nut	2	Cross recessed screw (M4×8)	3
Foot Pedal	1		
Socket head cap screw	4		
Operation manual	1		
Film cutter	1		
Allen wrench 2.5mm	1		
Allen wrench 4mm	1		
Storage box	2		
Cloth tray	1		



## 10. Installation

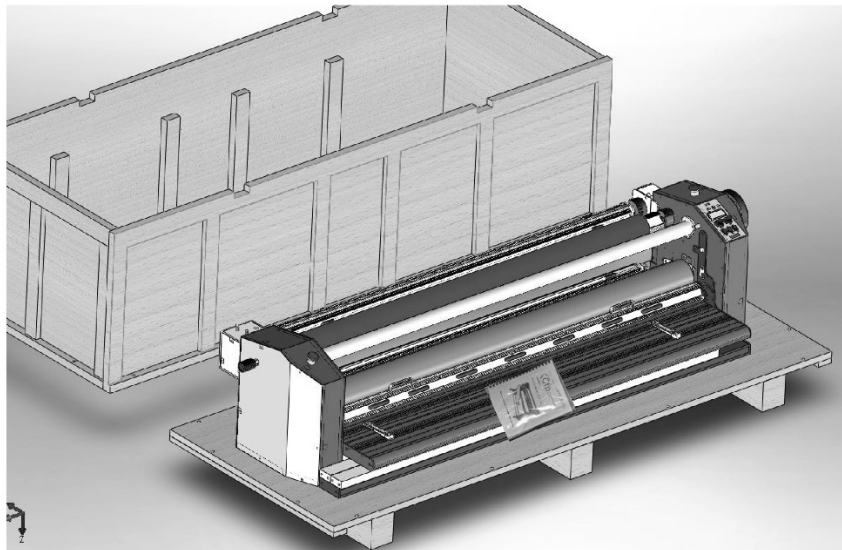
### 10A. Remove crate top and stand components

1. Remove screws around the top of the crate
2. Remove the top supports and stand components, set aside



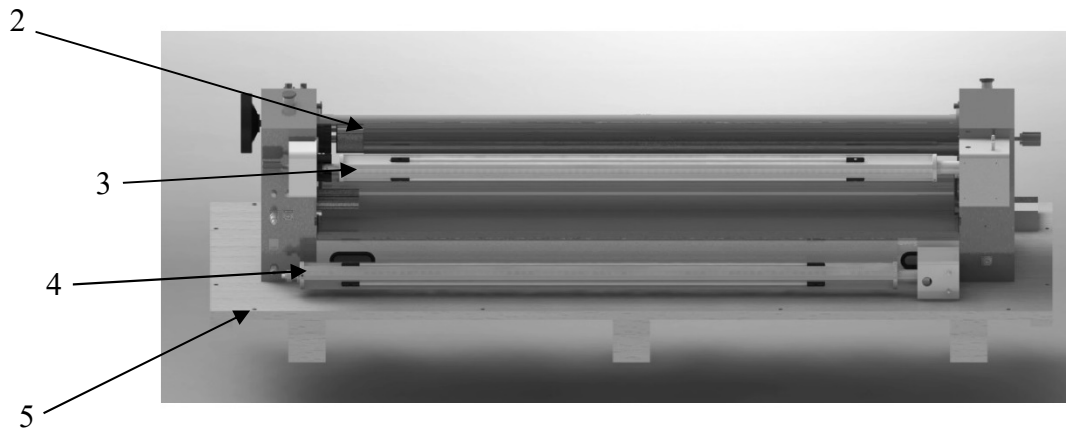
### 10B. Remove the crate and set aside

1. Remove all the screws including the corner protectors around the bottom of the crate
2. Lift up and over the machine and set the crate off to the side



### 10C. Remove the packing materials and accessories

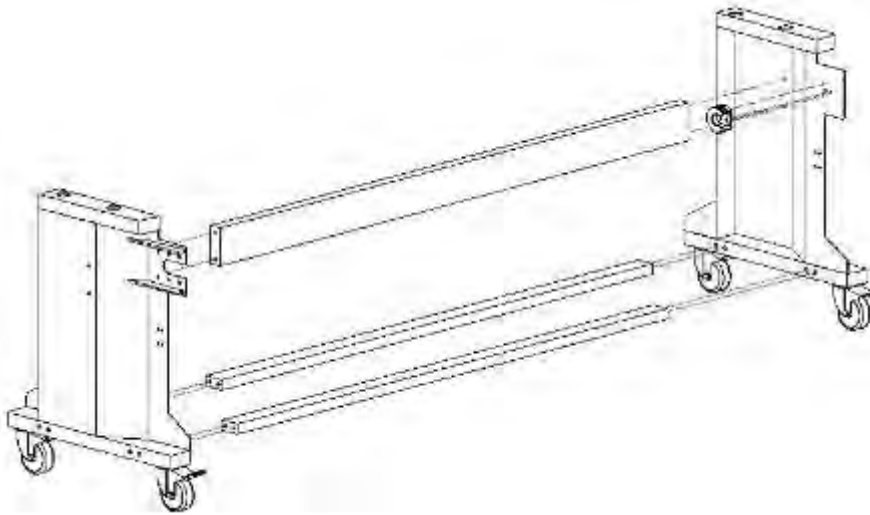
1. Remove plastic cover, accessory boxes, toolbox and Operator's Manual.
2. Raise the In-feed table and lock in place.
3. Remove rewind tube by rotating the shaft until the arrows are up, rotate the cradle locks and lift out.
4. Remove bottom supply shaft assembly from the crate skid.



1. Accessory box and manual
2. Top rewind mandrel
3. Top supply mandrel
4. Bottom supply shaft assembly
5. Shipping skid

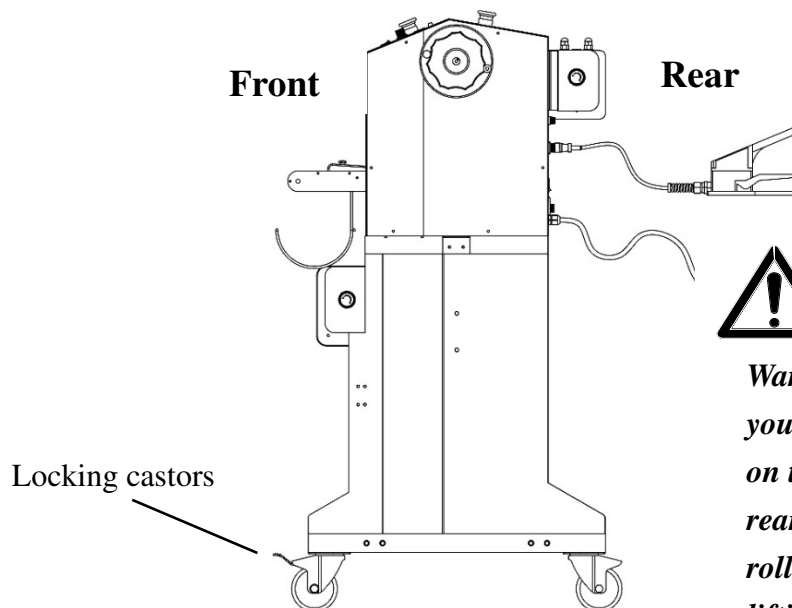
### 10D. Assemble machine stand

1. Remove stand components from the plastic shipping bags
2. Bolt cross members to stand side frame
3. Larger cross member goes in the center and takes the shorter bolts
4. Use a flat washer and lock washer – Flat washer contacts the stand.



### 10E. Set machine on stand

1. Lift the machine from shipping skid and onto machine the stand  
**Note:** Locking castors go to the **Front** of the machine



**Heavy! Handle with care!!**

**Warning:** when moving the machine, you should have your hands holding on the upper supporting beam and the rear supporting beam. Do not use roller gap adjustment hand-wheel for lifting!

## 10F. Align machine to stand

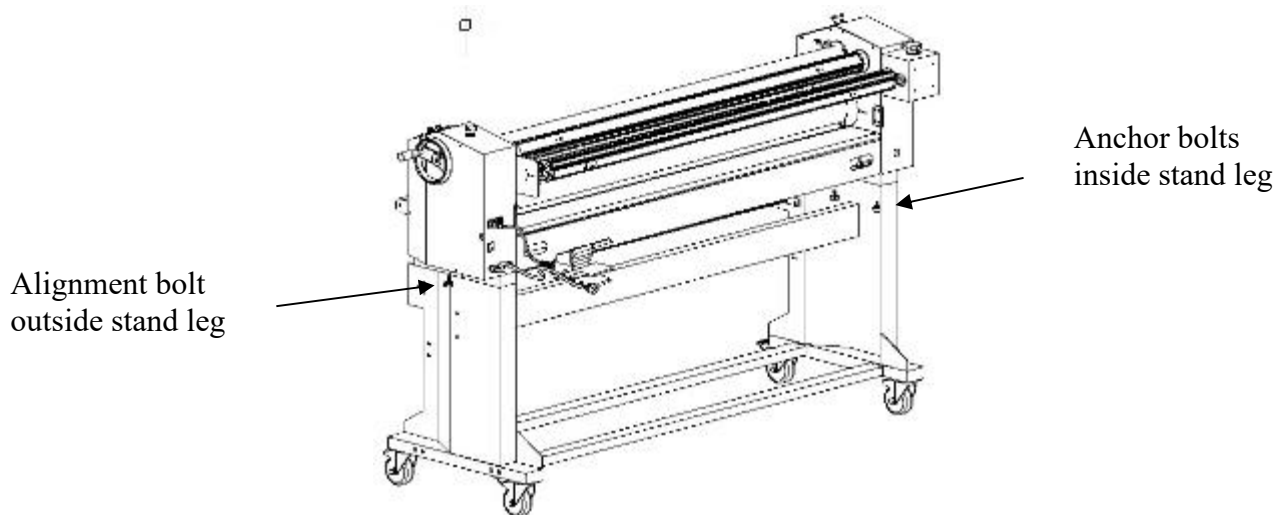
1. Screw one Alignment bolt through the alignment bracket into machine frame on the **outside** of each stand leg.

Note: You may need to slide machine to align holes in machine frame with machine stand



Alignment bolt

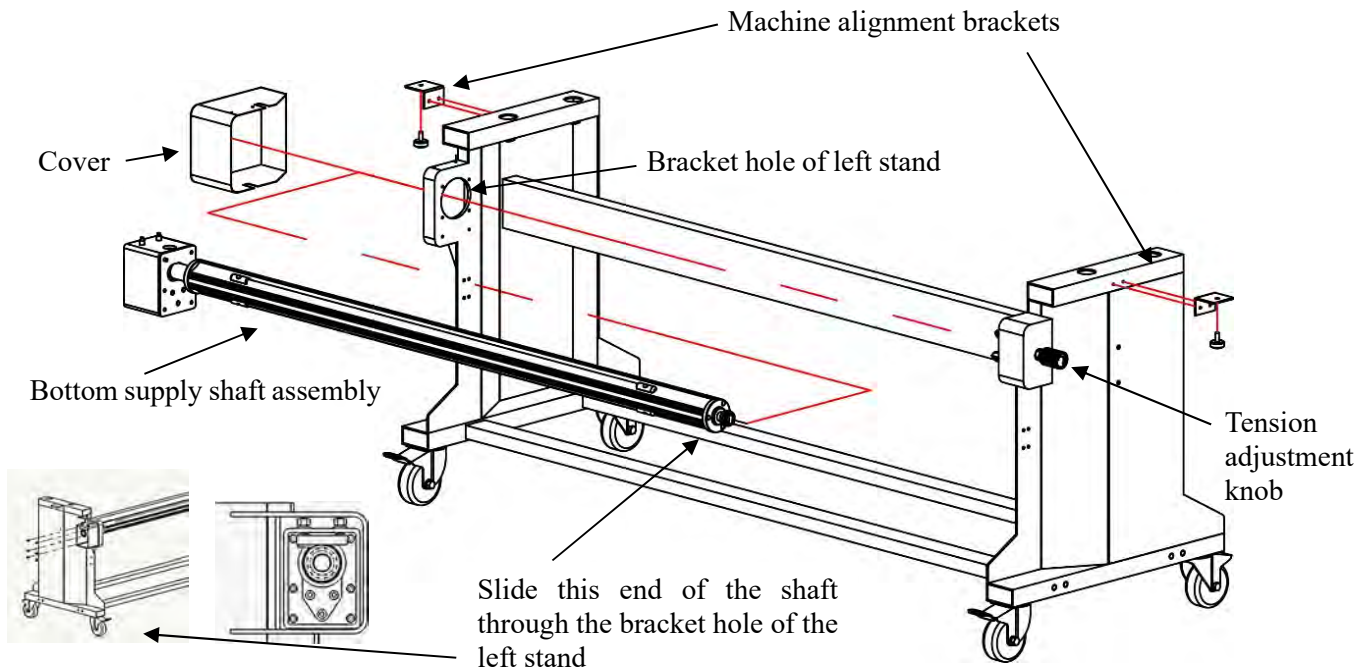
2. Screw two (2) Anchor bolts through the stand into the bottom of machine frame on the **inside** of each stand leg



**NOTE: Remove the shipping blocks and wire ties from the ends of the rollers before attempting to raise the top roller!**

### 10G. Attach lower supply shaft assembly

1. Bolt the bottom supply shaft assembly to the stand with 6 bolts by sliding the shaft through the hole on the left side of the left stand
2. Bolt the cover to supply shaft assembly
3. Bolt machine alignment brackets to the outside of machine stand



## 11. Additional Installation items

1. **Remove the shipping blocks and wire ties from the ends of the rollers before attempting to raise the top roller!**
2. Check drive chains for tightness
3. Check all drive set screws for tightness
4. Check all electrical connections and input power and test for proper operation

## 12. Loading Film

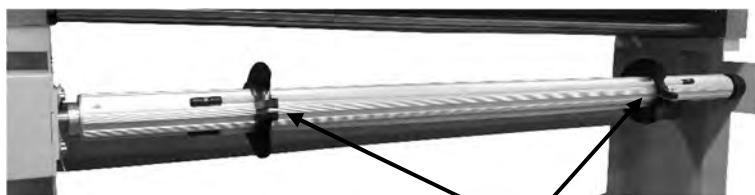
1. Rotate the locking outer sleeve in the direction of the arrow to the open position, aligned with the inner sleeve
2. Swing the supply shaft out to load position and slide the film roll onto the shaft  
Note: If using Liner-in film, the web should come off the bottom of the roll, for Liner-out film, the web should come off the top of the roll (see treading diagram in section #12)
3. Swing shaft back into position and rotate locking outer sleeve to the closed position
4. Align film roll with a number on the supply shaft, positioning the roll in the middle of the supply shaft



5. Adjust the brake tension by turning the adjusting knob on top of the supply roll assembly (see Brake tension adjustment section #15)



6. Repeat process with bottom supply shaft using Mounting adhesive or printed media roll
7. Position bottom supply roll using the same number position used on the top supply roll to align top and bottom rolls
  - i. *When using printed media, position one Media Alignment Disk on each side of the roll to keep edges lined up*
  - ii. *Media rolls can be very slippery and 'telescope' when loading on the supply shaft and running (see picture below)*



Media alignment disks

Bottom supply shaft with Media Alignment Disks

**NOTE:** Printed media can be very slippery and will 'telescope' when loading on the supply shaft. Use the alignment disks to keep the edges properly lined up.



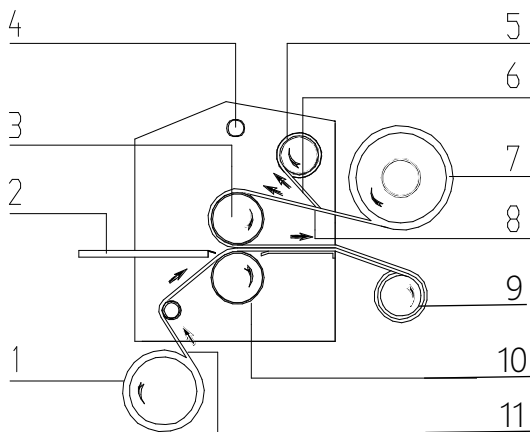
## 13. Threading Film

1. Pull the top film web under the rewind shaft, making sure there is proper resistance. The resistance can be adjusted with the adjusting knob on top of the supply shaft assembly
2. Turn the pressure-adjusting hand-wheel to lift the top rubber roller up.
3. Pass the film through the two rollers and lay on the rear working panel.
4. Pull the film flat then turn the pressure-adjusting hand-wheel to lower the upper rubber roller.
5. Separate the paper liner from the film web to allow enough liner to be taped to the paper rewind tube on the top rewind shaft

**NOTE: Slide film cutter between the paper liner and film to cut liner only. Be careful not to cut the top heat roller**

6. Use foot pedal to advance the film web until the adhesive is exposed on the front of the heat roller
7. Raise the feed tray assembly
8. Bring the mounting adhesive up to the nip area of the rollers or the media up and behind the idler bar then tack to the exposed film web adhesive
9. Lower the feed tray assembly
10. Use foot pedal to advance both webs until they clear the nip rollers

**Note: The film should be wrinkleless and tight to the surface of the heat roller. If wrinkles appear in the film web, adjust the brake tension knobs on both supply rolls**



1. Bottom supply roll
2. Front in-feed table
3. Top heat roller
4. Linkage shaft for roller pressure-adjustment
5. Liner rewind tube
6. Paper liner
7. PSA film roll
8. Film supply web
9. Optional lower rear rewind
10. Bottom nip roller
11. Bottom supply web

## 14. Operation

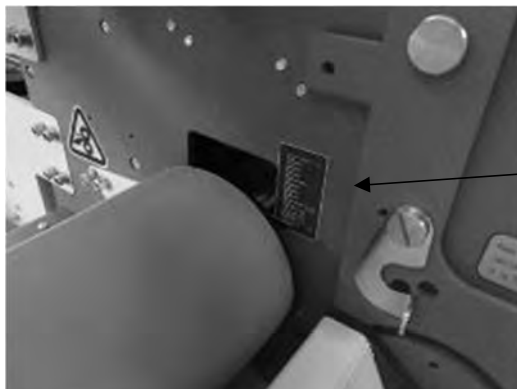
1. Plug power cord into a proper receptacle



- Connect the attachment plug provided with the laminator to a suitably grounded outlet only. This machine must have reliable earth wire to ensure the safety of the machine during operations
  - Contact an electrician should the attachment plug provided with the laminator not match the receptacles at your location
  - Ensure that the voltages of the power supply you are using match the rated working voltages before operations. Do not use incorrect power supply
  - Do not use damaged wires or sockets. If abnormal conditions occur, switch off the power supply first.
2. Turn power to “ON” with the rear power switch
  3. **Cold laminating:** When doing cold laminating, turn the switch to ‘Cold’
  4. **Hot Laminating:** Turn switch to “Hot” and set the needed temperature
  5. When the Green Ready indicator light is on the roller is up to temperature  
**NOTE: The temperature should meet the material to be laminated. If too high, the quality will be affected**
  6. The indicated temperature shows the surface temperature of the rollers. The temperature switch points to the set position. Actual temperature is shown on the LCD readout. The LCD does not work when the machine is in the “Cold” operating condition.

## 15. Nip Roller Pressure Adjustment

1. When the pressure-adjusting hand-wheel is turned clockwise, the top rubber roller comes down and the pressure will increase
2. With a counter-clock turn, the top rubber roller goes up and the pressure will decrease.
3. Bring the nip roller down to just touch the film, then increase 1/8 turn, (rotate the handle one number on the face of a clock).  
**Note: Too much nip pressure will wrinkle the output**
4. A roller gap opening scale is located inside the right-side frame which indicates the gap between the top and bottom nip rollers

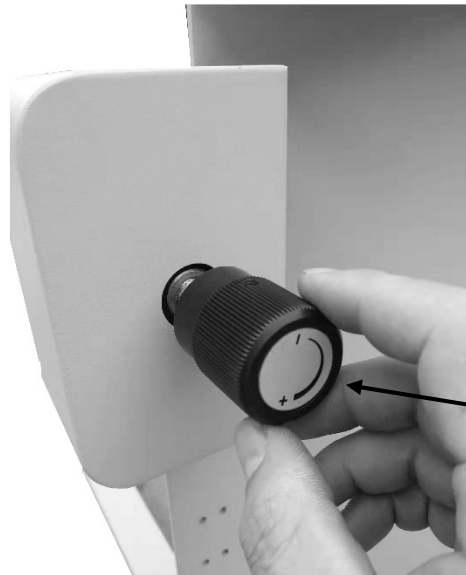


Roller gap scale

## 16. Brake Tension Adjustment

1. Adjust brake tension by turning the Tension adjustment knobs on top of each supply shaft assembly
2. Apply only enough brake tension to remove wrinkles from the vinyl web before it enters the nip rollers
3. Brake tension should not prevent roll from turning

**Note: Excessive brake tension will cause waves, wrinkles or curl in vinyl**



Rotate to the + to increase and to the - to decrease

## 17. Top Rewind Shaft Clutch adjustment

1. Adjust top liner rewind shaft clutch by turning the Clutch adjustment knob on the left side cabinet
2. Apply only enough clutch tension to keep the liner rewind shaft turning with the supply roll

**Note: Excessive clutch tension will cause rewind shaft to turn harder than the supply roll pulling the film onto the rewind shaft**



## 18. Inserting rewind shafts

1. Slide a cardboard core onto the rewind shaft
2. Set one end of the rewind shaft into the open side support bracket
3. Align the arrow and shaft tongue with the slot in the opposite side support bracket
4. Rotate both locking outer sleeves to the closed position on the support brackets



## 19. Feed tray safety latch

1. A Feed Tray Safety latch rotates freely with the feed tray
2. Ensure latch is in the locked position whenever the feed tray is rotated to the up position



Safety Latch



## 20. Removing Press Roller Assembly

1. Unscrew knurled thumb screw securing left side of Press Roller assembly
2. Lift off and remove Press Roller assembly



## 21. Rewind Assemblies

The unit comes with one standard lower rear rewind assembly. An additional optional rewind assembly can be added to the lower front for special applications that require two-sided PSA film to take up the release liner of the lower film supply.

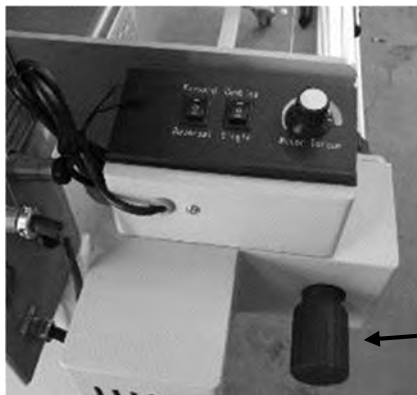
An additional rewind/slitter assembly can be installed on the lower rear rewind area if side slitting is required.

### Installing the Rewind device:

1. Remove 4 screws and inserts bolted inside each side frame
2. Bolt rewind motor assembly to control side frame and rewind bracket to opposite side frame where the inserts were located
3. Slide cardboard core onto the rewind tube and insert the rewind tube onto the support brackets
4. Plug rewind motor into power plug outlet at the rear of the side frame

### Operating rewind motor:

1. Select “Combine” and the rewind shaft will match the speed of the laminator
2. Select “Single” and the rewind shaft runs independent of laminator
3. Adjust the speed or power of the rewind shaft with the Motor Torque knob
  - a. As the diameter of the rear rewind roll gets larger and the roll gets heavier, the motor may need additional torque or power to maintain the same speed as the laminator
4. Select “Forward” for the rewind motor to turn clockwise
5. Select “Reverse” for the rewind motor to turn counterclockwise
6. Adjust the Shaft Clutch to keep the rewind shaft turning at the same speed as the machine output
  - a. As the diameter of the rear rewind roll gets larger and the roll gets heavier, the clutch may need to be tightened to keep the shaft clutch from slipping

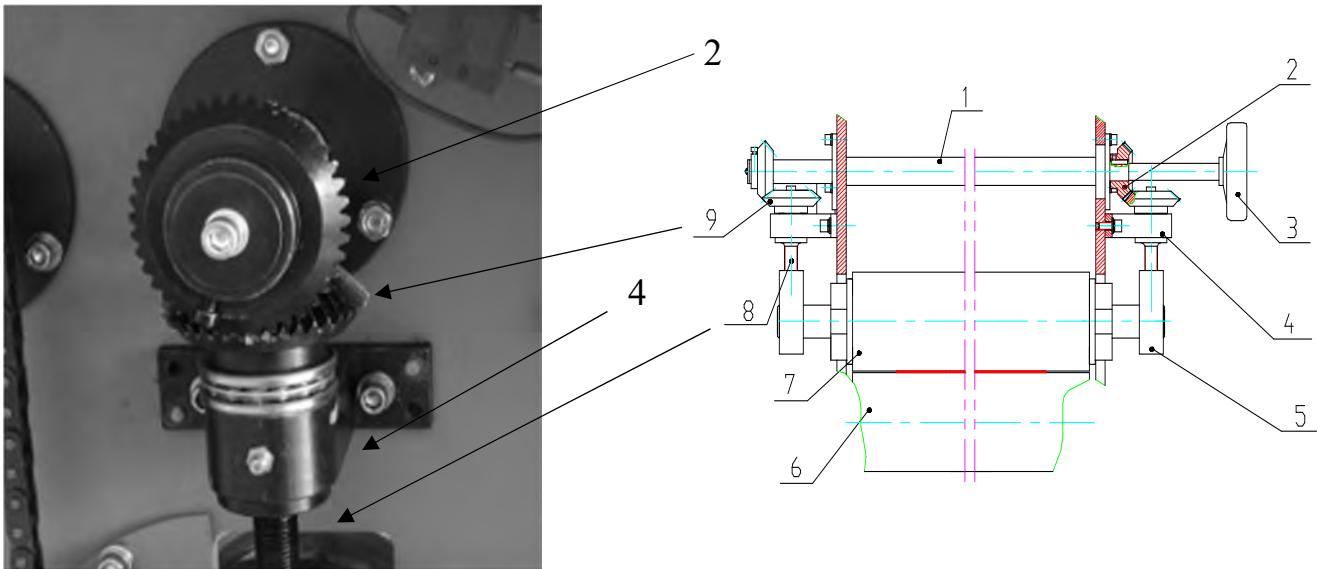


Clutch adjustment knob



## 22. Roller Gap Adjustment

1. Check for uneven roller gap
  - a. Place a sheet of paper between the rollers the full width of the laminator
  - b. Turn the pressure-adjusting hand-wheel to lower the upper rubber roller so the two rollers just touch
  - c. Check to see if the space between the rubber rollers is even across the width of the unit by inserting a sheet of paper between the rollers and sliding from side-to-side
2. If the space is not even, open the left and the right cabinet covers
  - a. Check if the left and right pressure-adjusting brackets (#4) are loose
    - If loose, tighten brackets and then replace cabinet covers
  - b. Check if the longitudinal taper gears (#9) on the two sides are loose
    - If they are loose, remove the screws of pressure-adjusting brackets, tilt the longitudinal taper gear, and tighten the screws on the top
    - Replace the pressure-adjusting brackets and cabinet covers
  - c. If space between the rollers is still not even
    - Remove the left transverse taper gear (#2), turn the longitudinal taper gear (#9) until the space of the two sides of rubber rollers becomes even.
    - Replace the transverse taper gear (#2), tighten the screws and replace the side covers



1. Linkage Axis 2. Transverse Taper Gear 3. Pressure-Adjusting Hand-wheel  
 4. Pressure-Adjusting Bracket 5. Pressure-Adjusting Blocks 6. Lower rubber Roller  
 7. Upper rubber Roller 8. Pressure-Adjusting Orientation Axis 9. Longitudinal Taper Gear

## 23. Troubleshooting

Problems	Causes	Solutions
Machine does not turn on	<ol style="list-style-type: none"> <li>1. No power supply</li> <li>2. Main power switch is OFF</li> <li>3. Circuit breaker has tripped</li> <li>4. Blown main power fuse</li> <li>5. Motor has failed</li> </ol>	<ol style="list-style-type: none"> <li>1. Plug in power cord</li> <li>2. Place power switch to ON</li> <li>3. Reset circuit breaker</li> <li>4. Replace fuse on rear panel</li> <li>5. Change the electric motor</li> </ol>
Rollers do not turn after “Run” button is pressed	<ol style="list-style-type: none"> <li>1. Emergency switch is engaged</li> <li>2. Excess roller nip pressure</li> </ol>	<ol style="list-style-type: none"> <li>1. Disengage emergency switch</li> <li>2. Reduce the nip pressure of the rubber rollers</li> </ol>
Heat roller not heating	<ol style="list-style-type: none"> <li>1. Heater not set</li> </ol>	<ol style="list-style-type: none"> <li>1. Switch heater on, adjust temperature setting knob</li> </ol>
Poor film adhesion or cloudy prints	<ol style="list-style-type: none"> <li>1. Nip roller pressure too low.</li> <li>2. Dust on the surface of the print</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase nip roller pressure</li> <li>2. Clean print surface before lamination</li> </ol>
Poor film adhesion on one side	<ol style="list-style-type: none"> <li>1. Nip roller pressure on the two sides is not even</li> </ol>	<ol style="list-style-type: none"> <li>1. See “Roller gap adjustment”</li> </ol>
Lamination output is curled	<ol style="list-style-type: none"> <li>1. Sheet is curled upward</li> <li>2. Sheet is curled downward</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce top roll tension</li> <li>2. Reduce bottom roll tension</li> </ol>
Film supply roll gets loose during operation	<ol style="list-style-type: none"> <li>1. Not enough brake tension on supply roll</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase brake tension on supply roll</li> </ol>
Backing paper gets loose when being rolled up	<ol style="list-style-type: none"> <li>1. Not enough brake tension on the backing paper rewind roller</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase brake tension on backing paper rewind roller</li> </ol>
Wrinkles in film both on top and bottom	<ol style="list-style-type: none"> <li>1. Too much nip roller pressure</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce nip pressure with hand wheel</li> </ol>

## 24. Specifications

Description	563TH
Laminating Width	63"
Roller Diameter	4.4"
Roller Gap	1.1"
Max Temperature	140° F
Film core size	3"
Laminating Speed	0-20 Ft/min
Pressure Adjustment	Hand wheel
Heat Method	Metal alloy tube
Power Supply	110 VAC 12 A
Power Consumption	1320 W
Net weight	491 lbs.
Output height	38"
Dimensions	87 x 26.5 x 52.5"
Shipping weight Machine	711 lbs.
Shipping dimensions machine	89 x 35.5 x 31.5"





## 25. Warranty

### EQUIPMENT WARRANTY

January 2014

Graphic Finishing Partners, LLC warrants each new Gfp Laminator is free from defects in material and workmanship for a period of one (1) year from the date of installation. A machine which proves defective in materials or workmanship within the warranty period will be repaired or, at Gfp's option, replaced without charge. This warranty is extended only to the original purchaser.

This warranty is the only warranty made by Gfp and cannot be modified or amended. Gfp's sole and exclusive liability and the customer's sole and exclusive remedy under this warranty shall be, at Gfp's option, to repair or replace any such defective part or product. These remedies are only available if Gfp's examination of the product discloses to Gfp's satisfaction that such defects actually exist and were not caused by misuse, neglect, attempt to repair, unauthorized alteration or modification, incorrect line voltage, fire, accident, flood or other hazard.

The warranty made herein is in lieu of all other warranties, expressed or implied, including any warranty or merchantability or fitness for a particular purpose. Gfp will not be liable for personal damage or personal injury (unless primarily caused by its negligence), loss of profit, or other incidental or consequential damages arising out of the use or inability to use this equipment.

This warranty specifically does not cover damage to laminating rollers caused by knives, razor blades, or any sharp objects or abrasives, or failure caused by adhesives, or damage caused by lifting, tilting and/or any attempt to position the machine other than rolling on the installed castors or feet on even surfaces, or improper use of the machine. Warranty repair or replacement by Gfp or its authorized reseller(s) does not extend the warranty beyond the initial period from the date of installation. Unauthorized customer alterations will void this warranty.