



SC-420

**Single Chamber Vacuum Packaging
Machine**

Operation Manual

Version 6.9.1

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TABLE OF CONTENTS

1. SAFETY	1
1.1 SAFETY RECOMMENDATIONS	1
1.2 PERSONAL SAFETY	2
1.3 FOOD SAFETY	3
2. INSTALLATION	4
2.1 UNPACKING	4
2.2 MOVING THE MACHINE	4
2.3 MACHINE SPECIFICATIONS	5
2.4 ENVIRONMENT REQUIREMENTS	5
2.5 CHECK OIL LEVEL	6
2.6 POWER CONNECTION	6
2.7 VACUUM PUMP ROTATION	6
3. OPERATION	7
3.1 VACUUM SETTING GUIDELINES	7
3.2 BASIC OPERATING INSTRUCTIONS	7
3.3 OPTIONAL DEVICE	7
3.3.1 GAS FLUSHING UNIT	7
3.4 OPERATION OF THE PA-01 ANALOG CONTROL PANEL	8
3.5 OPERATION OF THE PD-01 DIGITAL CONTROL PANEL	9
4. MAINTENANCE	9
4.1 BASIC MAINTENANCE	9
4.1.1 DAILY VISUAL INSPECTION	9
4.1.2 DAILY CLEANING	10
4.2 VACUUM PUMP MAINTENANCE	10
4.3 SEAL BAR MAINTENANCE	10-11
4.4 MAINTENANCE INTERVAL CHART	12
5. TROUBLESHOOTING	13
5.1 PROBLEMS AND CORRECTIONS	13-14
6. DRAWINGS	15
6.1 PNEUMATIC DIAGRAM(F)	15
6.2 PNEUMATIC DIAGRAM(LR)	16
6.3 ELECTRICAL DIAGRAM	17
7. FABRICATION	18
7.1 BODY DIAGRAM	19-20
7.2 VACUUM CHAMBER DIAGRAMS	21
7.2.1 VACUUM CHAMBER DIAGRAM(F)	21-23
7.2.2 VACUUM CHAMBER DIAGRAM(LR)	24-26
7.3 SEALING BAR CONFIGUATIONS	27
7.3.1 SEAL BAR DIAGRAM(F)	27-28
7.3.2 SEAL BAR DIAGRAM(FC)	29-30
7.3.3 SEAL BAR DIAGRAM(LR)	31-32
7.3.4 SEAL BAR DIAGRAM(LRC)	33-34
7.4 LID DIAGRAMS	35
7.4.1 LID DIAGRAM(F)	35-36
7.4.2 LID DIAGRAM(LR)	37-38

Explanation of Abbreviations

- (F) Front Seal
- (LR) Left & Right Seal
- (FC) Front Seal with Hot Wire Cut-off
- (LRC) Left & Right Seal with Hot Wire Cut-off

General

This owner's manual contains information relating to your Promax/ Promarks machine. It will provide you with basic information concerning both operation and maintenance of your new machine. Please read it carefully as failure to do so may result in bodily injury and / or damage to the equipment.

Please fill in the information below. You will find the information on the bill of lading and on the machines identification tag. You will need this information when ordering replacement parts or making technical inquiries.

Model # _____

Serial # _____

Ship Date: _____

Owner: _____

Location: _____

1. SAFETY

1.1 SAFETY RECOMENDATIONS

Unsafe practices or unauthorized modifications of machine could result in accidents or property damage.

For safe installation, operation, handling and maintenance, please strictly follow the simple safety rules stated below and take precautions. Failure to follow these safety rules and take necessary precautions can result in serious injury or death as well as cause damage to the equipment.

- 1) Never operate or service your Promax / Promarks machine until you have read this manual completely and understand it fully.
- 2) All adjustments and repairs must be carried out only by qualified technicians or maintenance personnel.
- 3) No service work should be attempted until the machine's power has been turned off. All proper lock out / tag out procedures should be followed.
- 4) Do not put tools, parts or other foreign objects on or into the machine.
- 5) Always keep the machine clean, lubricated and in good working condition.
- 6) To provide protection against the risk of electrical shock the power connection must be properly grounded at all times.
- 7) The machine should always be operated on a flat stable surface.
- 8) A certified electrician should be employed to install the permanent electrical connections for your new machine.

1.2 PERSONAL SAFETY

Please read and understand this operation manual before using this equipment. Failure to follow the operating instructions may result in personal injury or damage to the machine.

The following procedures and guidelines must be observed to avoid problems that can result in property damage, personal injury or death. If you have any questions regarding this information please contact Promax /Promarks, Inc. Service Department at (909) 481-3338.

Hazardous Voltage: DANGER

Electrical power must be disconnected and locked out before servicing or cleaning of the machine. Do not remove any panels before power has been disconnected and locked out due to the risk of electric shock hazard.

Explosion Hazard: DANGER

When utilizing the gas flush feature (optional) do not use any gas mixture with greater than 22% oxygen content.

Blade Hazard: WARNING

If your machine is equipped with either a Perforating Knife System (optional) or a Precut Knife System (optional) then do not remove or install blades without wearing protective gloves. These blades are SHARP, use care when handling.

Signal words used in classifying potential hazards are defined as follows:

DANGER: Indicates an imminently hazardous situation, which if not avoided, may result in death or serious injury.

WARNING: Indicates a potentially hazardous situation, which if not avoided, could result in serious injury.

CAUTION: Indicates a potentially hazardous situation, which, if not avoided, may result in minor to moderate injury. Caution also indicates actions that may cause property damage.

1.3 FOOD SAFETY

While many Promax / Promarks machines are used in applications involving vacuum packaging and vacuum cooking, there are inherent risks associated with these techniques that can result in serious illness or death to the consumer of the food product. Therefore if you are using your machine for food applications, you must consult a qualified food technician or specialist in vacuum / modified atmosphere (M.A.P.) to review the safety of your application.

GAS FLUSH

If your machine is equipped with gas flush (optional) and your application involves the use of gas flush to extend the shelf life of your product you must consult a qualified food technician or specialist to review your application and develop a suitable gas mixture for your package. Further you must perform quality control and gas analysis on your final M.A.P. package.

CLEANING

Every environment and application is different; therefore Promax / Promarks cannot provide cleaning procedure instructions that will guarantee microbiological sanitation. Therefore Promax / Promarks recommends that the purchaser of these machines consult with a sanitation expert to review your procedures for cleaning the machine while operating in your environment and with your specific product to develop a robust cleaning schedule and methodology, followed by bacterial testing to ensure satisfactory cleaning is achieved.

2.INSTALLATION

2.1 UNPACKING

- Carefully remove the cardboard outer shell by cutting the retaining straps then removing the top and then the side panels.
- Inspect the machine carefully for any hidden shipping damage. Notify the shipping company right away if any damage is observed.
- Remove the machine from the wooden skid. This can be done by two people on the smaller table top machines. However an approved fork lift will be required for the larger SC and DC models. **Important note:** Refer to the Moving the Machine Section below.
- Wipe down the outside of the machine.

2.2 MOVING THE MACHINE

Promax chamber style vacuum packaging machines are available in three basic designs, TC (Table Top), SC (Free Standing Single Chamber) and DC (Double Chamber). Recommendations for the movement of all three types are listed below.

TC Machines: Some of the smallest TC units may be lifted off of their wooden skid and moved manually. However Promax recommends that moving even the smallest of their TC units should not be attempted by one person. The larger TC units should be lifted with the aid of a fork lift or other approved lifting aid. Prior to lifting with a forklift the forks should be adjusted to a width that provides the machine with stable support. The proper lifting point for TC machines is to place the forks so they come in contact with the units rubber feet located on the bottom of the machine.

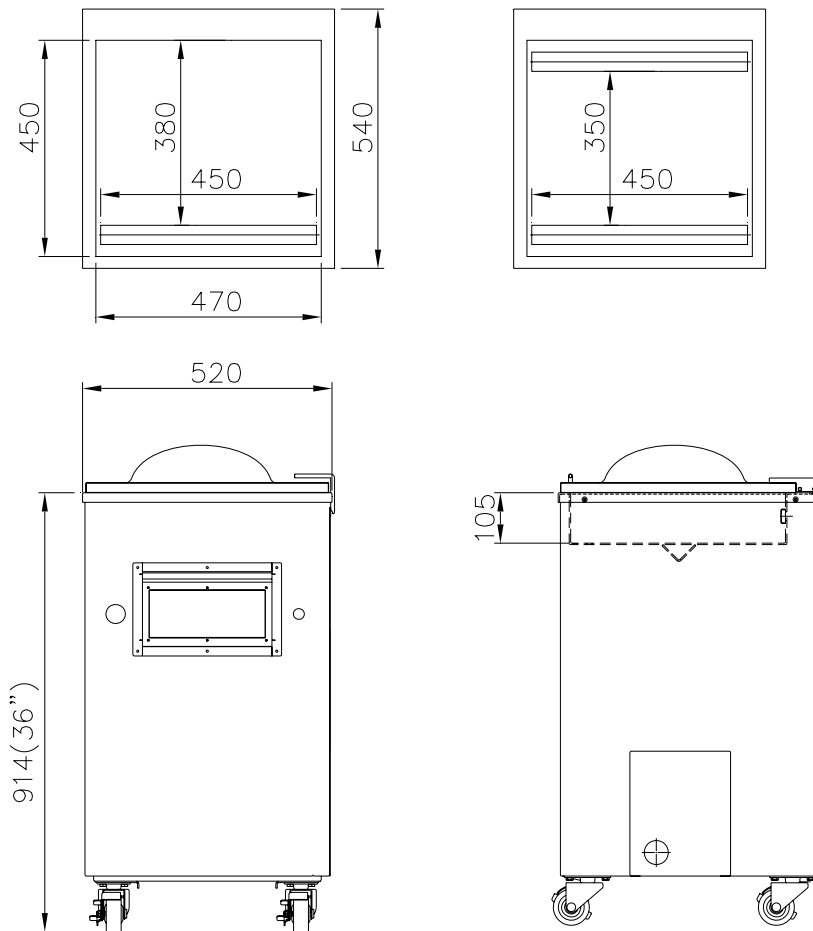
SC Machines: All SC units should be lifted from their wooden skid and moved to the location where they will be used with an approved fork lift. Be sure to take note of the points listed below.

DC Machines: All DC units should be lifted from their wooden skid and moved to the location where they will be used with an approved fork lift. Be sure to take note of the points listed below.

*** Make sure the fork lift forks are properly adjusted for width and use fork extensions if needed.**

*** Make sure to ascertain the center of gravity and use identified lifting points.**

2.3 SC-420 SPECIFICATION



2.4 ENVIRONMENT REQUIREMENTS

The machine will be difficult to start if the air temperature is very low. This is caused by the increase in the vacuum pump's oil viscosity due to the low temperature. To prevent this, please set up machine according to the installation checklist described as below:

- Temperature: around 5 ~ 40°C
- Working elevation: between 0 ~ 1000 meters
- Relative humidity: 30 ~ 95% RH
- During operating, heat is generated by the vacuum pump and vacuum process, so a machine temperature of around 70 ~ 80°C is normal. The machine must have free air access for cooling.
- A minimum distance from walls, other machines, etc. should be maintained, at least 20 cm for each side of machine for providing adequate ventilation.

2.5 CHECK OIL LEVEL

Check the oil level only when the machine is not in operation and all vacuum built up in the chamber has been vented. Be aware that the oil may be very hot and avoid all contact.

Checking the Oil Level

- * Check the oil level on a daily basis
- * When checking the oil level use the sight gauge shown in **figure 1 below**. The level should be between the arrows indicating Minimum and Maximum. If the level is below the minimum arrow add oil until the maximum arrow is reached.

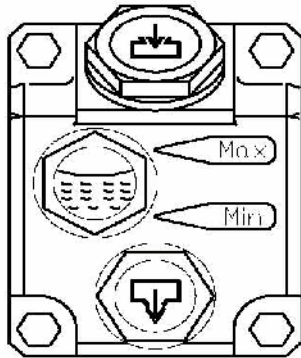


Figure 1

2.6 POWER CONNECTION

When preparing to install the machine's main power connection please refer to the electrical information on the serial number plate located on the machine's back panel. A certified electrician should be employed to complete this connection.

2.7 VACUUM PUMP ROTATION

If your machine operates on 3 phase power it is important to check the rotation of the vacuum pump. The pump should turn in the direction indicated in **Figure 2** below. If the pump turns in the wrong direction it will make a sound that is obviously wrong. Turn off the power immediately and change the position of two of the power wires and retest.

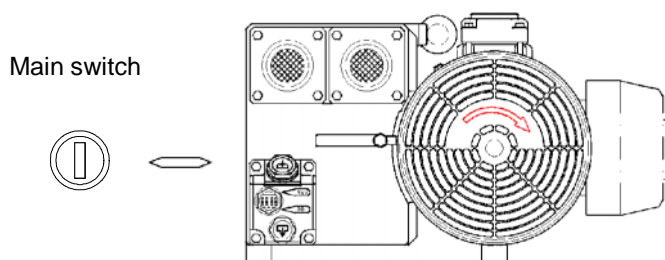


Figure 2

3. OPERATION

3.1 VACUUM SETTING GUIDLINES

Products	Vacuum time/Sec.	Storage life when stored at 2 ~ 6 °C/day
Fresh meat	30	10
Pork	30	10
Beef	30	30
Meat with liquid	15 ~ 30	14
Pasta	3 ~ 9	21
Sliced sausage	15	10
Cold cuts	9	10 ~ 21

3.2 BASIC OPERATING INSTRUCTIONS

Turn on the main switch and the LED display shows the operation menu, at this time, machine is ready to operate.

Place the product to be packaged in a vacuum pouch. Place the bag in chamber with the open end of bag across the sealing bar. (With a package that doesn't completely fill the chamber, place provided flat plates in the chamber to shorten vacuum time.)

Close the lid to start the cycle, the lid will open automatically when cycle is completed.

Take out the sealed product from vacuum chamber. You are ready to start the next cycle.

After all packaging is completed, please let the vacuum pump run for about 15 minutes, then turn off the main switch to shut down the machine.

3.3 OPTIONAL DEVICE

3.3.1 GAS FLUSHING UNIT

If your machine is equipped with an optional gas flush system please note the following points.

Make sure you have connected a regulated gas source to the gas inlet fitting

Do not set your regulator for a pressure of greater than 40psi

Place the open end of your package in front of the gas inlet nozzles

Do not tuck the bag under the gas nozzles

3.4 Operation of the Model PA-01 Analog Control Panel

On the model PA-01 analog control panel you will see four (4) dials from left to right they are vacuum, gas, seal and cool (Refer to Fig. 3 below). **When setting these dials to accomplish your intended cycle please keep in mind that the reference numbers around each dial are only to be used as a reference as they do not equate to seconds.**

Proceed with setting these dials as indicated below. The settings indicated will be for a trial cycle and various settings of each dial may be needed to achieve the results you require.



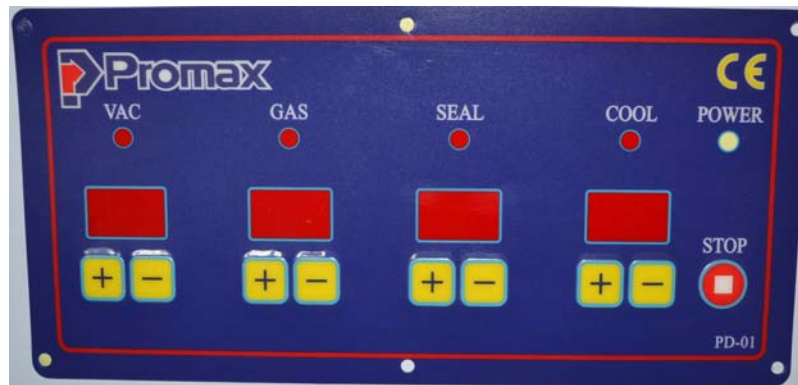
Set Each of the Dials as Follow.

- 1. Vacuum:** Turn the dial to # 5
- 2. Gas:** (optional feature) If your machine is equipped with the gas flush option and you wish to gas flush the package you are currently working with turn this dial to # 2.
If your machine does not have the gas flush option or you do not wish to gas flush then turn the dial to # 0.
- 3. Seal:** Turn the dial **no higher than # 3** for your first trial then increase or decrease as needed for your pouch.
- 4. Cool:** Turn to a **minimum of # 3**

3.5 Operation of the Optional PD-01 Digital Control

Using the touch up/down touch pads (Refer to Fig. 4 below) set the time for the vacuum, gas , and seal and cool as indicated below. The times indicated in the digital display are in seconds.

Important note: the settings indicated below represent a starting point only and you will need to perform adequate testing to determine the exact settings needed for your product.



1. Vacuum: Set a time of 15 seconds

2. Gas Flush (optional): If your machine is equipped with a gas flush system set a time of 5 seconds. If your machine does not have a gas flush system or you will not use gas flush for the current application then it is very important to set a time of 0.0 seconds.

3. Seal: Set a time of 1.5 seconds.

4. Cool: Set a time of 3.0 seconds.

4. MAINTENANCE

4.1 Basic Maintenance

The following maintenance procedures should be followed no matter what model Promax machine you own.

4.1.1 Daily Visual Inspection

Your machine should have the following items inspected daily. If this inspection is performed daily prior to the start of your days production you will find that your machine will always perform consistently, last longer and suffer less down time.

A. Teflon Covers

1. Clean if they have any foreign mater adhering to them
2. Look for any burned spots, cuts or tears. Replace if needed.

B. Vacuum Pump Oil

1. Check the oil level. Fill if below Minimum on the sight gauge. Refer to Page 7.
2. Replace the oil after 500 hours of operating time.

C. Vacuum Chamber Lid Gasket

1. Check for general wear
2. Check for damage
3. Replace as needed.

D. Pressure Bar Rubber: On TC and some SC machines this is the rubber part found in the lid of your machine that meets with the seal bar when the machine is in operation. In other SC machines and in all DC machines this is the rubber part that is located on the chamber's base that meets with the seal bar when the machine is in operation.

1. Check for excessive wear.
2. Check for burnt spots, cuts and tears.
3. Replace as needed.

E. Vacuum Pump Motor Sound

1. Listen for the smooth, normal sound of your vacuum pump.
2. If any abnormal sounds are detected **TURN OFF YOUR MACHINE RIGHT AWAY** and perform a trouble shooting procedure..

4.1.2 Daily Cleaning

Important Note: The following daily cleaning points are meant to help keep your machine in proper working order. They are in no way intended to provide the required level of sanitation needed for the packaging of food products. As noted earlier in this manual your company should consult with an expert in the sanitation field to design a robust sanitation routine when packaging food products.

1. Clean the seal bar's Teflon tape very carefully using a rag and a mild organic solvent. **DO NOT** directly wash down this area of the machine.
2. Clean the rubber pad in the seal pressure bar. Once again use a rag and a mild organic solvent. **DO NOT** directly wash down this area of the machine.
3. Wipe down the stainless steel housing using an approved stainless steel cleaner.
4. On machines with clear chamber lids or viewing windows clean them using a mild glass cleaner.
5. If your machine is an SC Series or a DC Series unit open the housing access door and visually check for oil or debris around the vacuum pump area. If you see anything that needs to be cleaned **DO NOT start cleaning until the machine is properly locked out and tagged out.**

4.2 Vacuum Pump Maintenance

For detailed information concerning maintenance and repair of your machine's vacuum pump please refer to the manufactures operating manual that was packaged with your new machine.

4.3 Seal Bar Maintenance

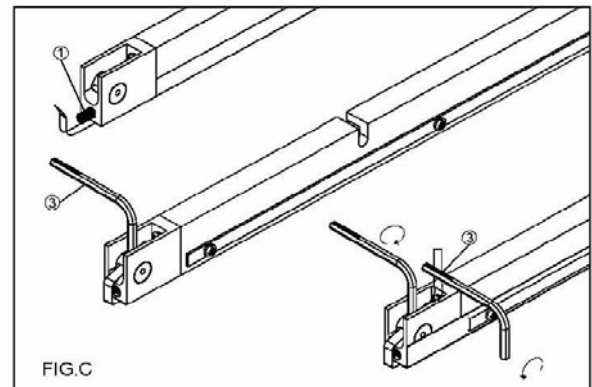
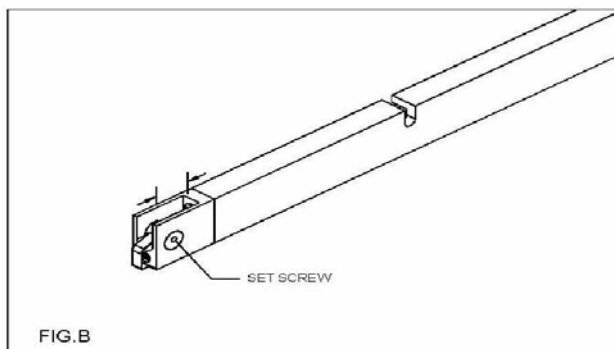
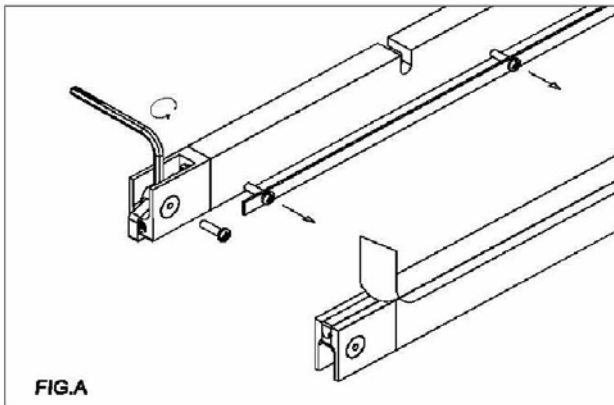
A. Replacing the Teflon Cover

1. Remove the seal bars from your machine.
 - a. Seal bars are located in the chamber on all TC Series machines and some smaller SC Series machines.

- b. Seal bars are located in the lid on larger SC Series machines and all DC Series machines.
2. Remove the screws that hold the Teflon holding strap in place. Refer to **Figure A on the next page.**
 3. Remove the old Teflon cover.
 4. Inspect the seal element.
 - a. Clean it off with lacquer thinner if needed.
 - b. Replace if broken or burnt badly. **Refer to the instructions under B below for replacement**
 5. Install the new Teflon cover and reinstall the seal bars.

B. Replacing the Seal Element

1. Using a hex wrench loosen the screws holding the seal element and remove it
2. Install the new seal element. **Refer to Figures B & C on the next page.**
 - a. Place the new element across the surface of the seal bar leave an excess of about 3/4" at each end.
 - b. Make sure you put the tension spring back in place..



4.4 MAINTENANCE INTERVALS AND CHECK ITEMS

Maintenance Intervals/ Check items	Daily	Bimonthly	Quarterly	Yearly	Biyearly	3 ~ 5 years	Note
Keep the vacuum lid open after finished working and let vacuum pump running about 15 minutes.	X						
Check the oil level	X						
Check the sound of motor	X						
Oil come out from exhaust cover or not	X						
Bottom sealing bar working normally or not	X						
Clean the exhaust filter		X					
Change vacuum oil		X					
Replace exhaust filter				X			
Replace Teflon tape				X			As request
Replace sealing Silicone rubber				X			As request
Replace lid gasket rubber				X			As request
Replace pressure bag					X		As request
Replace vanes						X	

Above-mentioned maintenance intervals are scheduled basically for 8 working hours per day.

Recommended oil :

A. Grav. API	30.5
Pour Pt.	-15°C
Flash Pt.	225°C
Viscosity	32.05 CST@40°C
Color	Light Yellow
V.I.	100

5. TROUBLESHOOTING

5.1 Problems and Corrections

Problem and Corrections - Review installation procedure section to ensure the installation is correct. If correct, the troubleshooting chart below lists possible problems, causes, corrections, and reference guide.

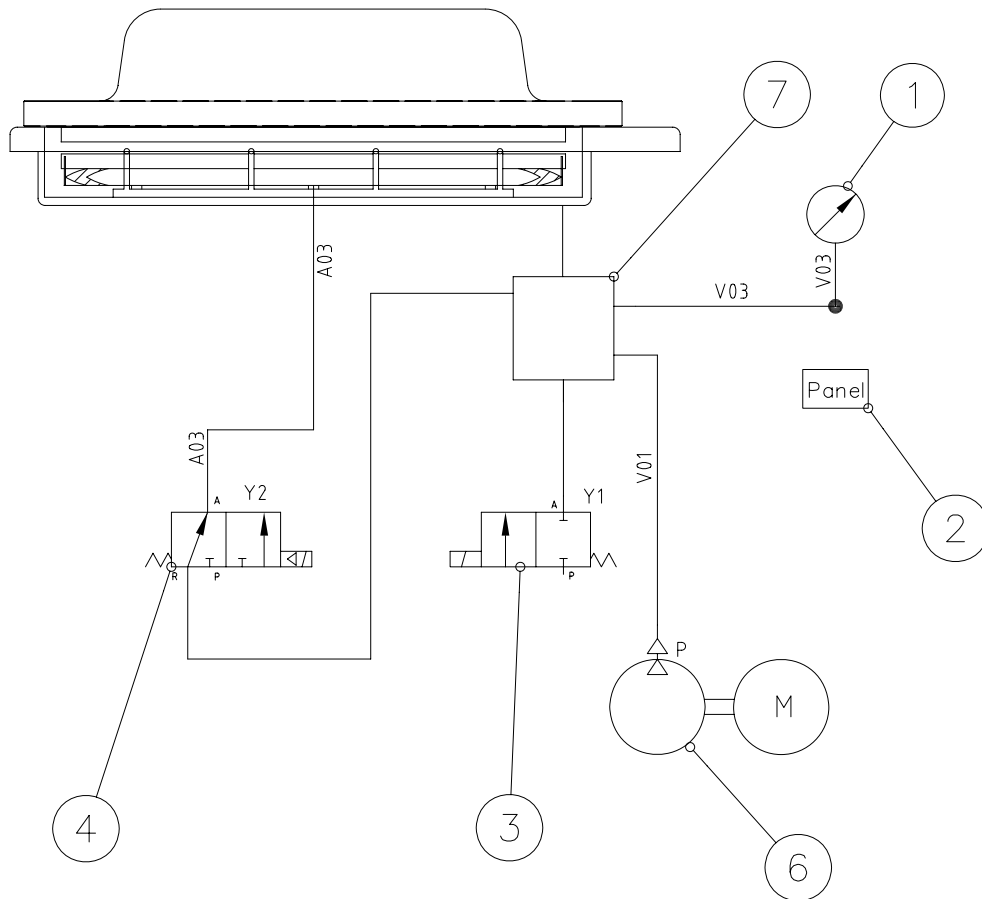
Problem	Cause	Correction
Control panel is under normal function, but vacuum pump does not start.	The KM1, QM1, MCB1, MCB2 protectors are disconnected.	Check each part and turn on the switch, reconnect, if necessary.
Vacuum pump does not run.	The power supply is not corresponding with the power demand indicated on the back of machine.	Reconnect to correct power source.
Insufficient vacuum in chamber.	Low oil level in vacuum pump. Vacuum pump is rotating in wrong direction. Lid silicone rubber damaged.	Fill oil, if necessary. Stop machine immediately. Then alter the power connection and reconnect to correct ones. Replace.
Insufficient vacuum in bag. Note : Mostly insufficient vacuum in bag is due to leakage of bag, but not the fault of machine.	Bag is leaking. Sharp corners on wrapped product puncture the bag. Bag is too large.	Replace the bag. Replace the bag and use a thicker one. Replace with a smaller one.
Vacuum bag is easily pulled apart by hand.	Sealing time (temperature) is too short (low).	Adjust sealing time (temperature) to be longer (higher).
Sealing area has some burnt marks or bubbles appeared.	Sealing area stuffed with oil or meat juice or dirt. Sealing time (temperature) is too long (high).	Clean and remove them. Adjust sealing time (temperature) to be shorter (lower).
Lid does not open.	Vacuum valve is damaged.	Replace it.

Problem	Cause	Correction
<p>No or improper sealing. NOTE : Please do not adjust sealing longer than regular time, or it will reduce the life of Teflon tape and silicone rubber.</p>	<p>Insufficient pressure. Sealing transformer is damaged. Teflon tape or silicone rubber is damaged. Sealing time and cooling time are too short. Sealing pressure is too low. Heating element is loose. Heating element is broken.</p>	<p>Replace it. Tighten it. Pressure bar is damaged, replace it. Replace it. Replace it. Adjust to proper time. Replace the pressure bag.</p>
<p>Lid does not close.</p>	<p>Vacuum valve is damaged. Limit switch is disconnected or damaged.</p>	<p>Replace it. Reconnect or replace it.</p>

6 DRAWINGS

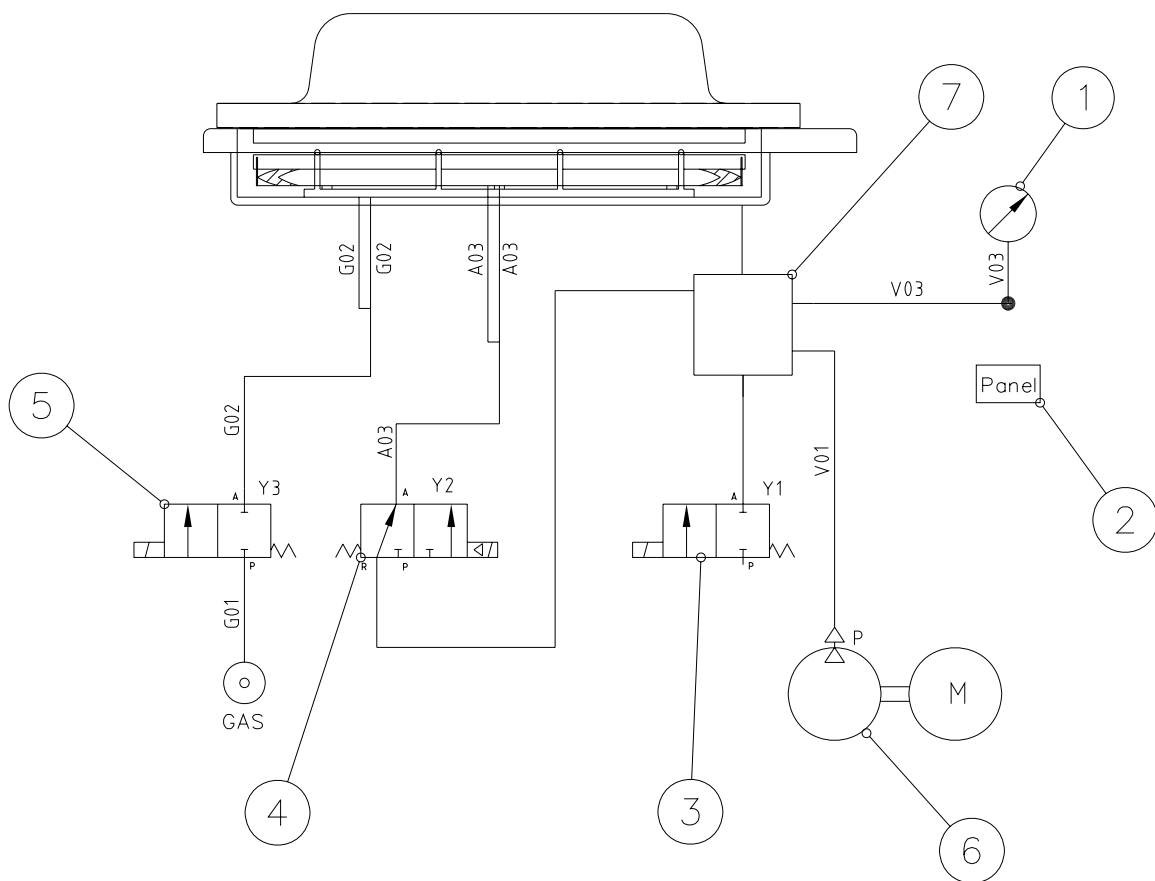
6.1 PNEUMATIC DIAGRAM (F)

NO	DESCR	QTY	NOTE
1	Vacuum gauge	1	
2	Control panel	1	
3	Ventilation valve	1	
4	Sealing valve	1	
5	Vacuum pump	1	
6	Distributing connector	1	

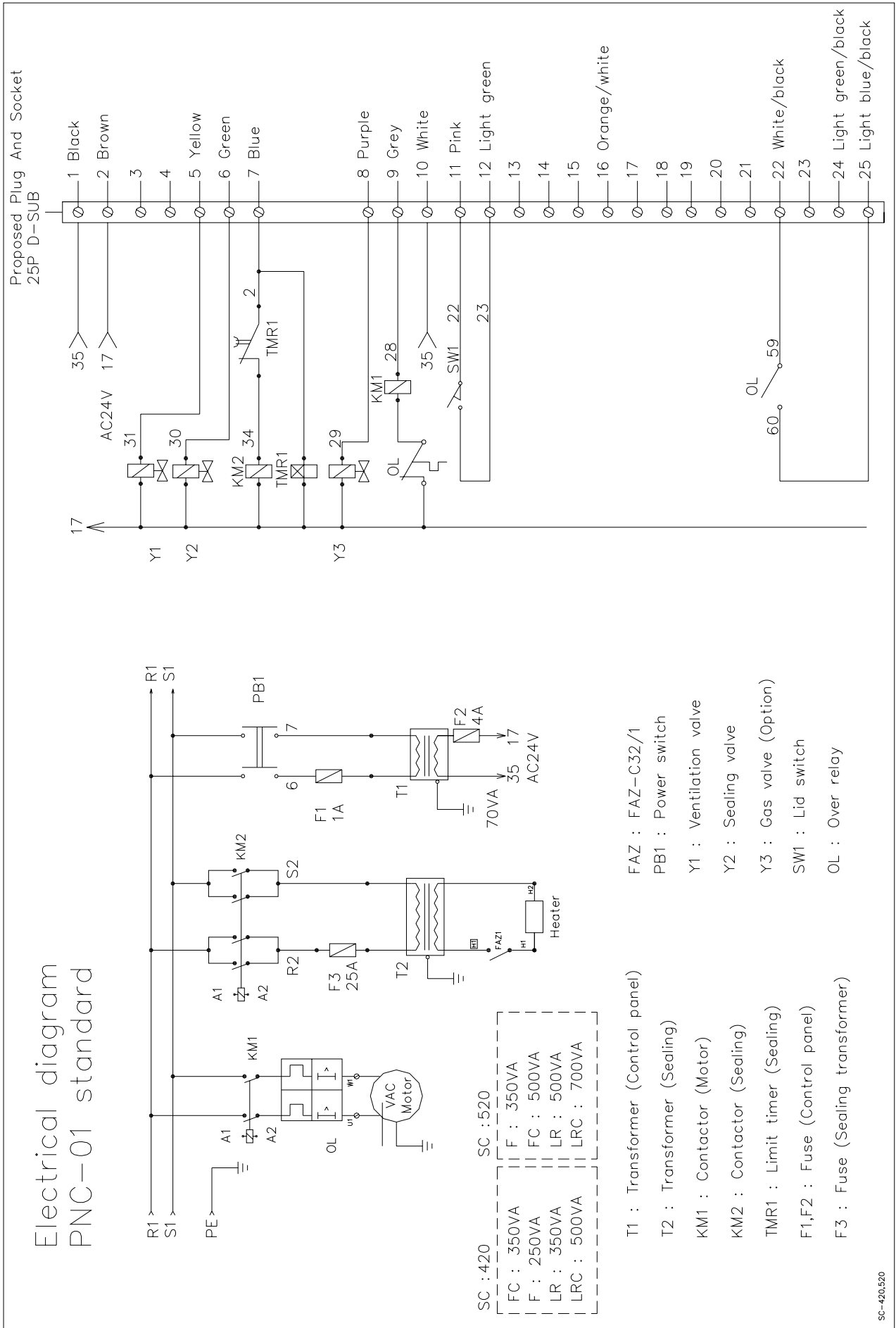


6.2 PNEUMATIC DIAGRAM (LR)

NO	DESCR	QTY	NOTE
1	Vacuum gauge	1	
2	Control panel	1	
3	Ventilation valve	1	
4	Sealing valve	1	
5	Gas valve	1	
6	Vacuum pump	1	
7	Distributing connector	1	

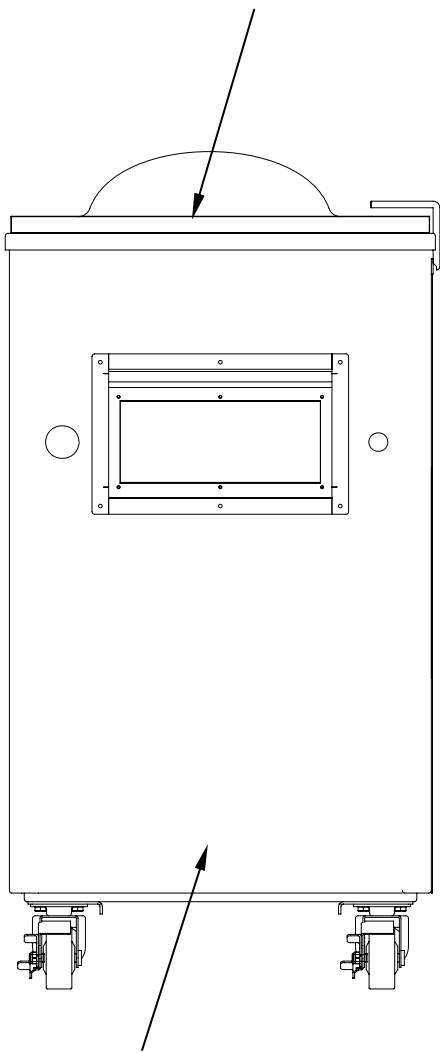


6.3 ELECTRICAL DIAGRAM



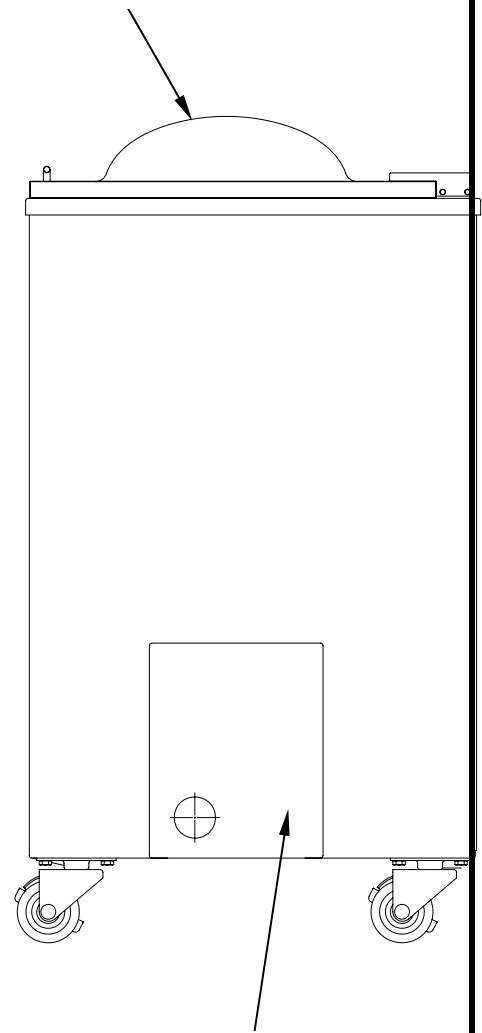
7. FABRICATION

7.2 VACUUM CHAMBER
7.3 SEALING BAR



7.1 BODY

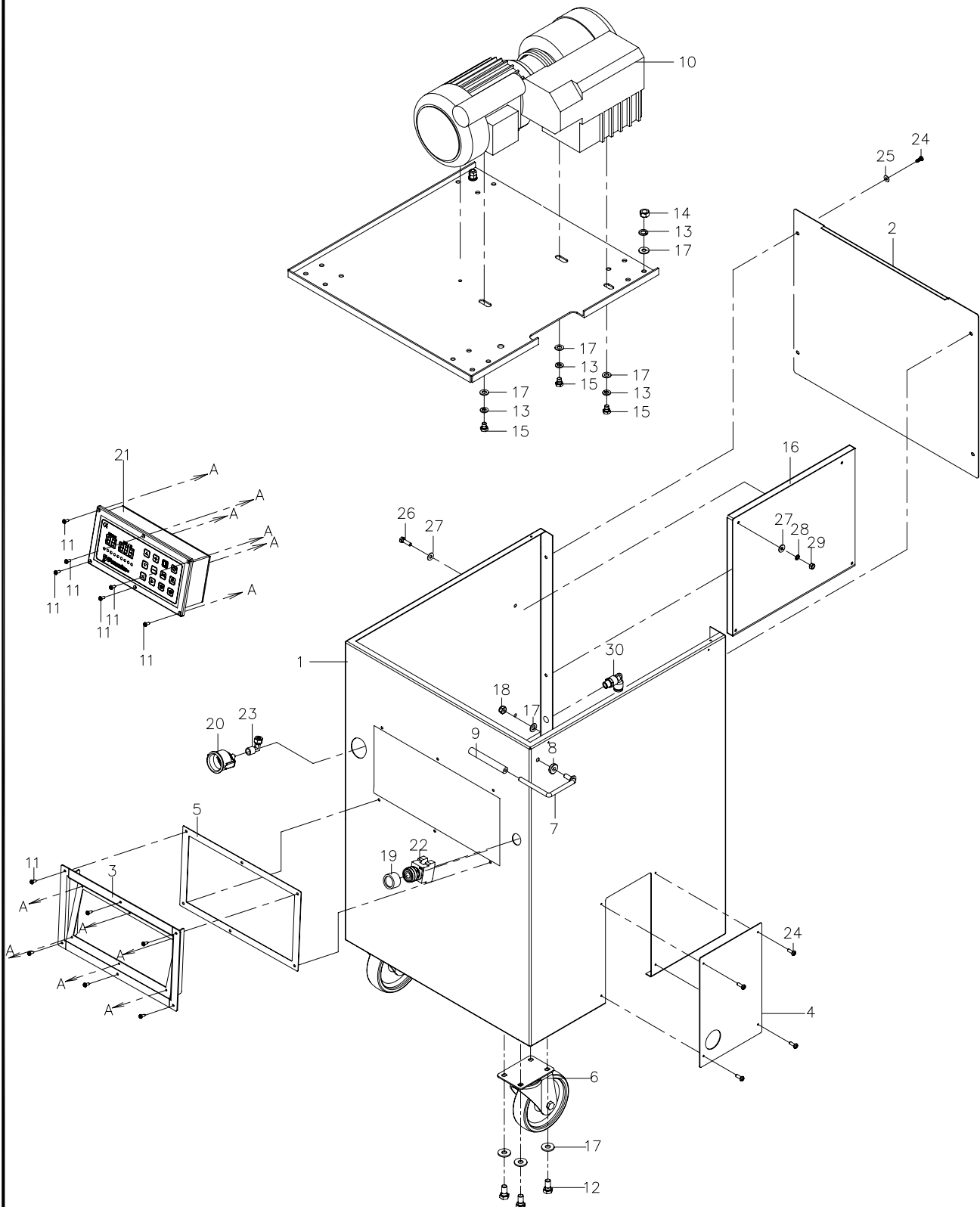
7.4 LID DIAGRAM



7.5 ELECTRICAL BOX

7.1 BODY

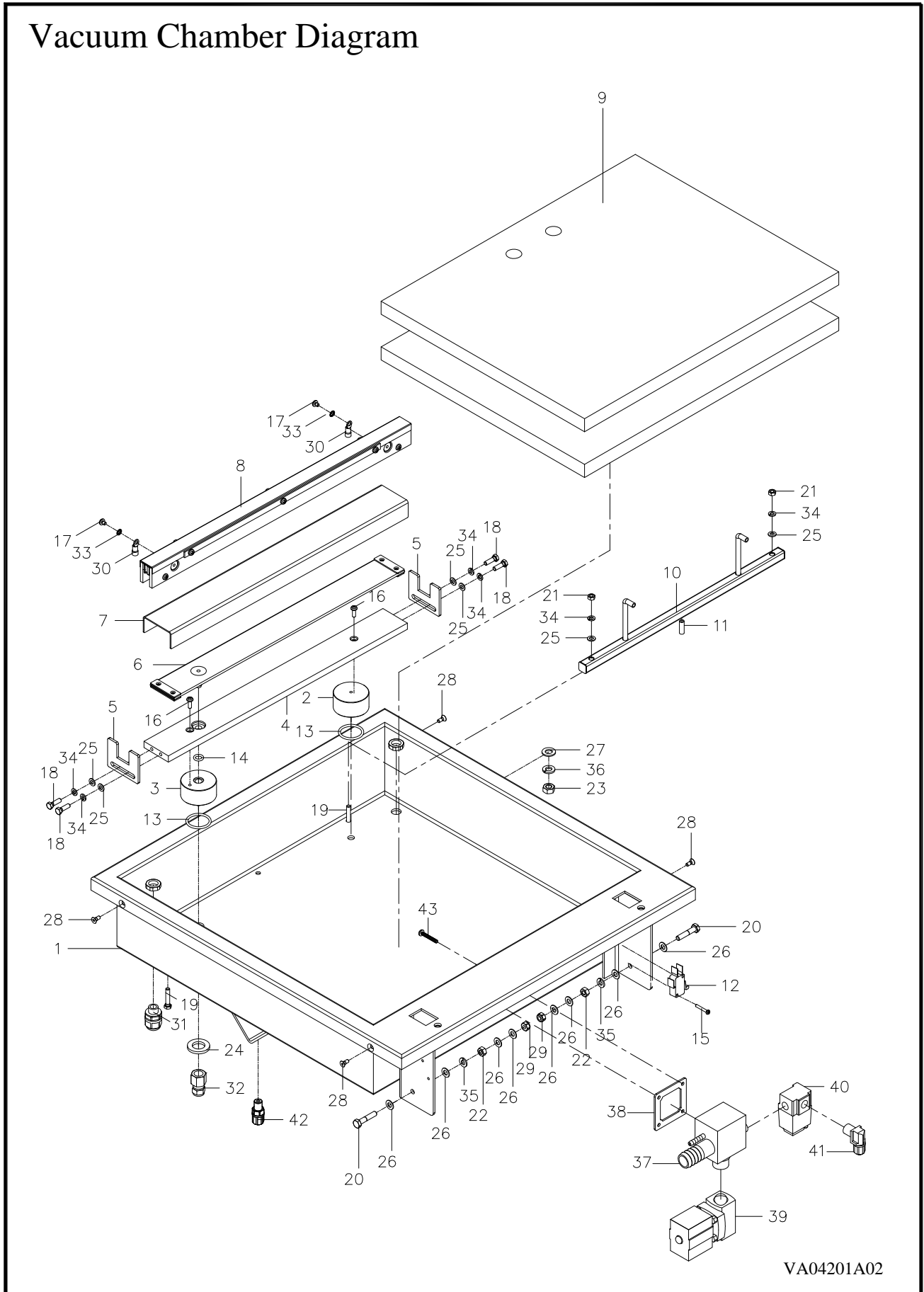
Body Diagram



SC42101A01

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	SC42101000	Frame	1	
2	SC42102000	Back door	1	
3	SC42103000	Panel fixed plate	1	
4	SC42104000	Side plate	2	
5	SC42105000	Washer	1	
6	271211812	Casters	4	
7	VA04130001	Bolt	1	
8	VA04131000	Washer $\phi 20 \times 5L$	1	
9	VA04132000	CAP $\phi 13 \times \phi 6 \times 95L$	1	
10	TA0001112070	Vacuum pump	1	
11	2703307	Round head screw M4 x 10	6	
12	2700408	Hex head screw M8 x 20	16	
13	2705301	Split lock washer M8	19	
14	27072032	Nut M8	16	
15	2700415	Hex hd screw M8 x 16	3	
16	SC42104000	Mounting plate	1	
17	2705152	Washer M8	36	
18	2707103A	Nylock nut M8	1	
19	28704940	Button guard	1	
20	29135564	Vacuum gauge 2" x 760mm	1	
21	2874043	Control panel	1	
22	2870048	Round-Flat head button YW1B-A1E20G	1	
23	29090426	Copper PU adapter A-026-1 1/8PT x 5/16N 90°	1	
24	2703302	Hex head screw M5x15	4	
25	2705150	Flat washer M5	4	
26	27004011	Hex head screw M6x20	4	
27	2705151	Flat washer M6	8	
28	2705302	Split lock washer M6	4	
29	2705204	Nut M6	4	
30	29093382	Fitting JPL 10-02	1	

7.2.1 VACUUM CHAMBER DIAGRAM-F

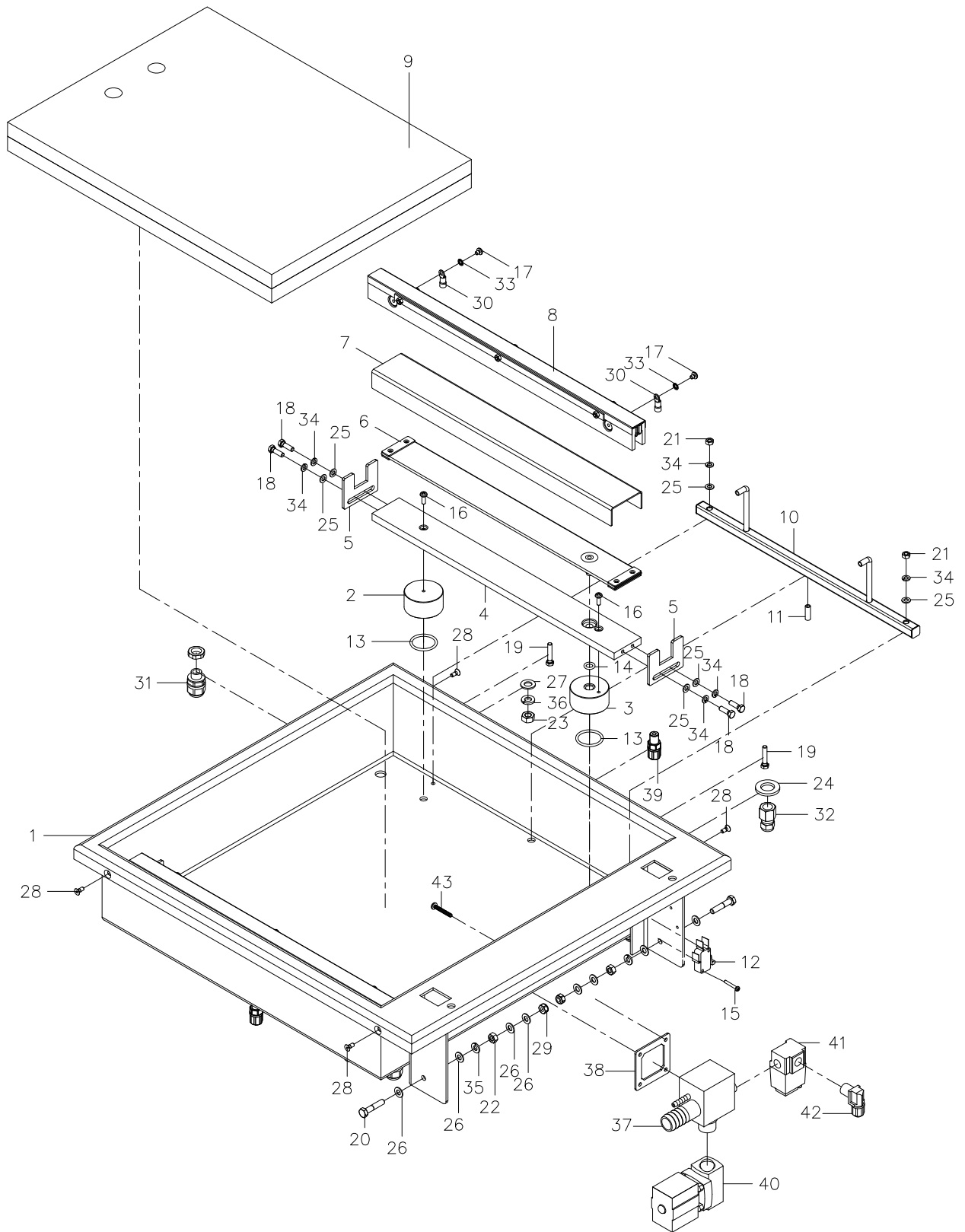


VA04201A02

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	VA04201006	Vacuum chamber	1	
2	VA04210001	Hex busing block holder	1	
3	VA04211001	Hex busing block holder	1	
4	VA04212000	Sealing bar plate	1	
5	VA04213001	Sealing bar holder	2	
6	VA04214A00	Pressure bag	1	
7	VA04219001	Pressure bag holder	1	
8	VA04220A00	Sealing bar - bottom (F-C)	1	
	VA04270A00	Sealing bar - bottom (F)		
9	VA04230000	Flat plate	2	
10	VA04412000	Gas nozzle tube 430x325x20	1	
11	VA04241000	Gas inner bushing $\varphi 6 \times 1 \times 18$	1	
12	2841110	Limit switch	1	
13	2740168	O-ring	2	
14	2740169	O-ring	1	
15	2703323	Round head screw M3 x 20	2	
16	2703308	Round head screw M4 x 12	2	
17	2703304	Round head screw M4 x 6	2	
18	2700414	Hex head screw M5 x 12	4	
19	27004131	Hex head screw M5 x 25	2	
20	2700462	Hex head screw M6 x 30	2	
21	2707208	Hex nut M5	2	
22	2707204	Hex nutM6	2	
23	2707203	Hex nut M8	1	
24	2705155	Washer M14	1	
25	2705150	Washer M5	6	
26	2705151	Washer M6	8	
27	2705152	Washer M8	1	
28	2702090	Flat philip screw M4x10	4	
29	2707110	Hex nut M6	2	
30	2840075	Terminal K.S. RVS3-5	2	
31	2861019	MG Fitting MG-12A-05G(50PCS)	2	
32	2909074	Nylon fitting A-022	1	
33	2705601	Split lock washer M4	2	
34	2705303	Split lock washer M5	6	
35	2705302	Split lock washer M6	2	

7.2.2 VACUUM CHAMBER DIAGRAM-LR

Vacuum Chamber Diagram

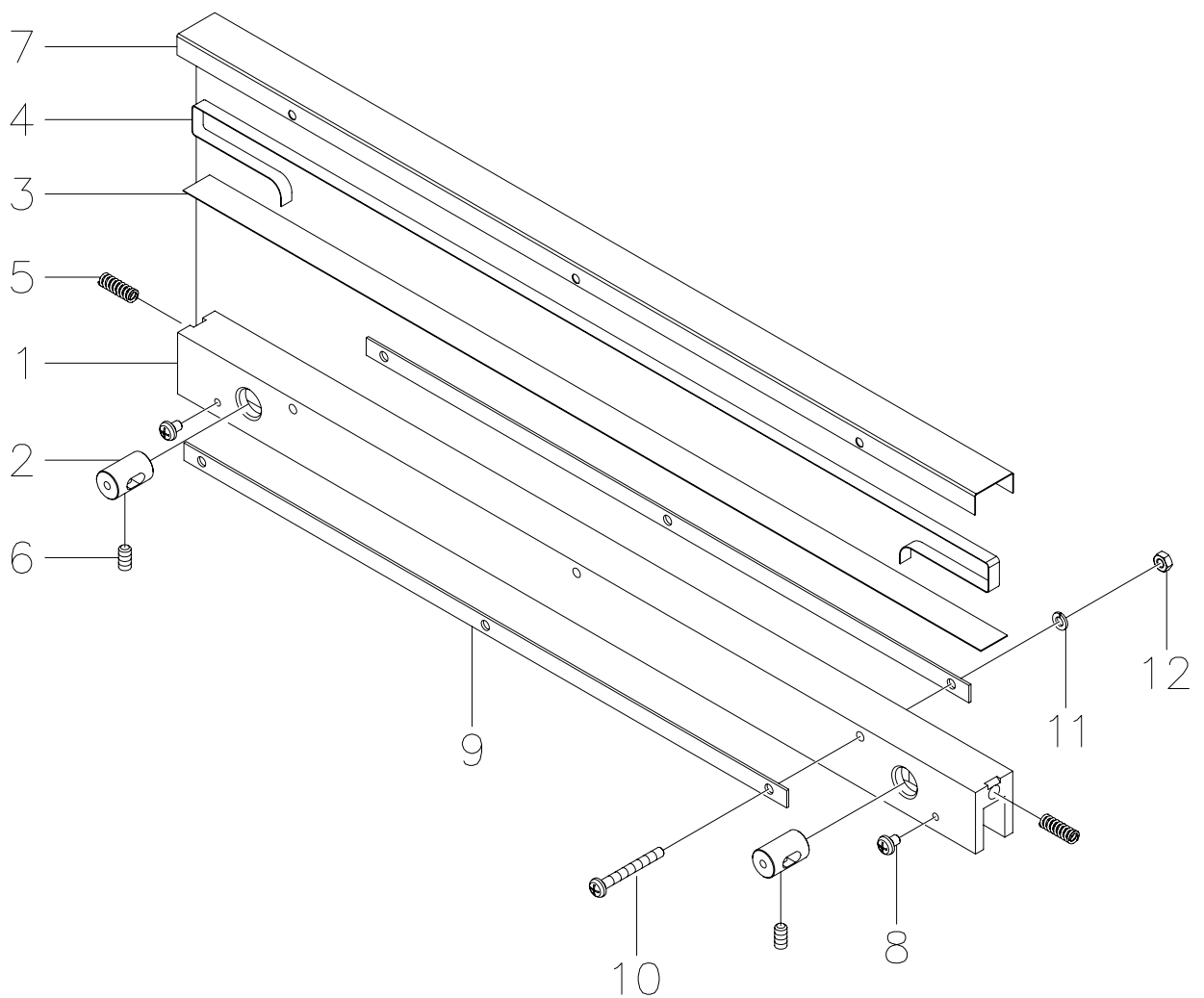


VA05201A03

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	VA05201005	Vacuum chamber	1	
2	VA04210001	Hex busing block holder	2	
3	VA04211001	Hex busing block holder	2	
4	VA05212000	Sealing bar plate	2	
5	VA04213001	Sealing bar holder	4	
6	VA05214A00	Pressure bag	2	
7	VA05219001	Pressure bag holder	2	
8	VA05220A00	Sealing bar - bottom (LR-C)	2	
	VA05270A00	Sealing bar - bottom (LR)		
9	VA05230000	Flat plate	2	
10	VA04412000	Gas nozzle tube	2	
11	VA04241000	Gas inner bushing	2	
12	2841110	Limit switch	1	
13	2740168	O-ring	2	
14	2740169	O-ring	2	
15	2703323	Round head screw M3x20	2	
16	2703308	Round head screw M4x12	4	
17	2703304	Round head screw M4x6	4	
18	2700413	Hex head screw M5x16	8	
19	27004131	Hex head screw M5x25	4	
20	2700462	Hex head screw M6x30	2	
21	2707208	Hex nut M5	4	
22	2707204	Hex nutM6	2	
23	2707203	Hex nut M8	2	
24	2705155	Washer M14	2	
25	2705150	Washer M5	12	
26	2705151	Washer M6	8	
27	2705152	Washer M8	2	
28	2702090	Flat philip screw M4x10	4	
29	2707110	Hex nut M6	2	
30	2840075	Terminal K.S. RVS3-5	4	
31	2861019	MG Fitting MG-12A-05G(50PCS)	4	
32	2909074	Nylon fitting A-022	2	
33	2705601	Split lock washer M4	4	
34	2705303	Split lock washer M5	12	
35	2705302	Split lock washer M6	2	

7.3.1 SEALING BAR-STANDARD DIAGRAM-F

Sealing Bar-Standard Diagram

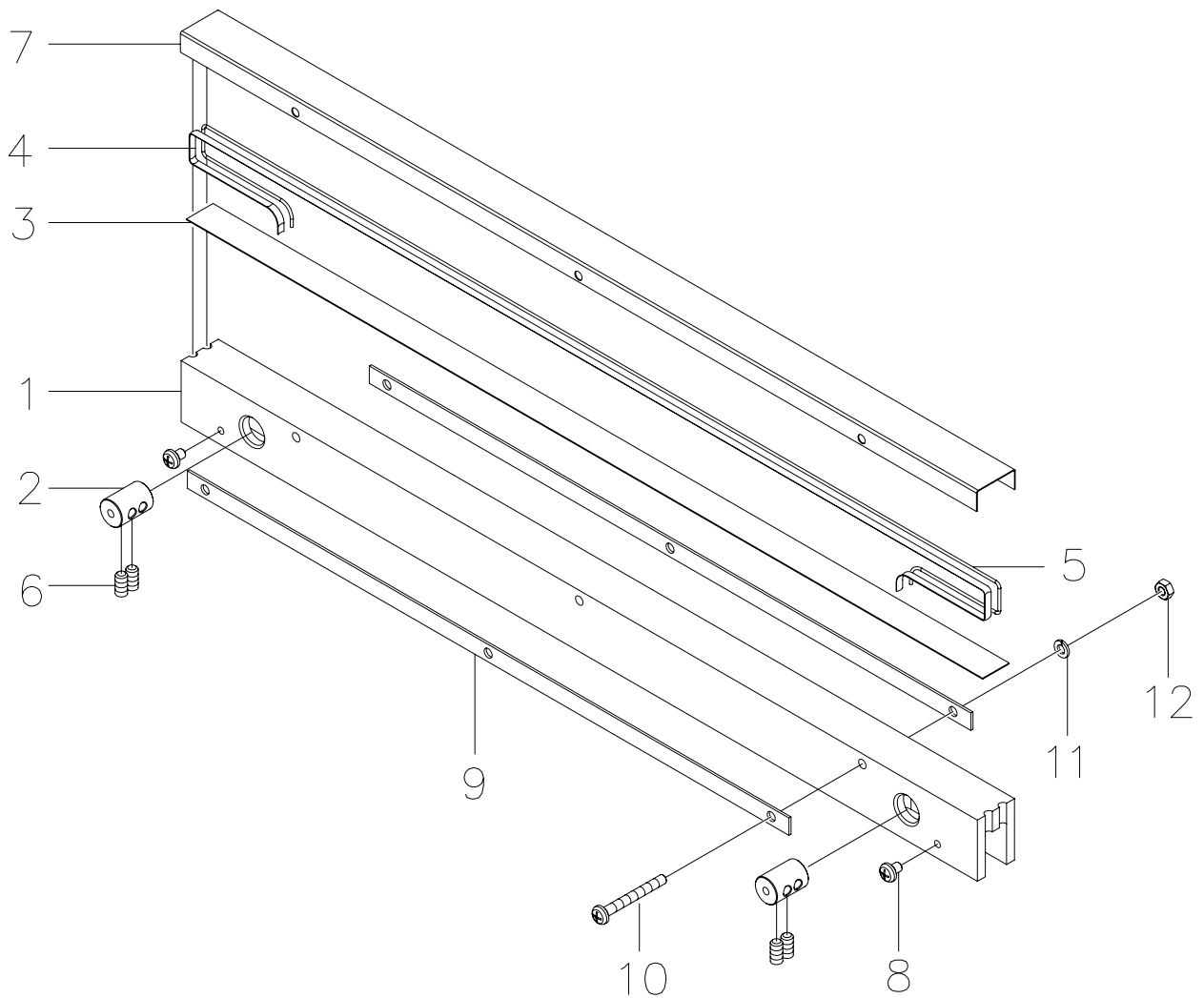


VA04270A00

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	VA04270000	Sealing bar	1	
2	VA04271000	Sealing element holder	2	
3	3200958	Teflon tape, 16mm	1	
4	2825060003	Sealing element, 6mm	1	
5	VA04277000	Spring	2	
6	2704617	Socket set screw M4 x 10	2	
7	3200955	Teflon tape 450 x 45 x 0.45	1	
8	2703304	Round head screw M4 x 6	2	
9	VA04226000	Teflon tape clamp	2	
10	2703310	Round head screw M4 x 30	3	
11	2705306	Split lock washer M4	3	
12	27072042	Hex nut M4	3	

7.3.2 SEALING BAR-STANDARD DIAGRAM-FC

Sealing Bar-Standard Diagram

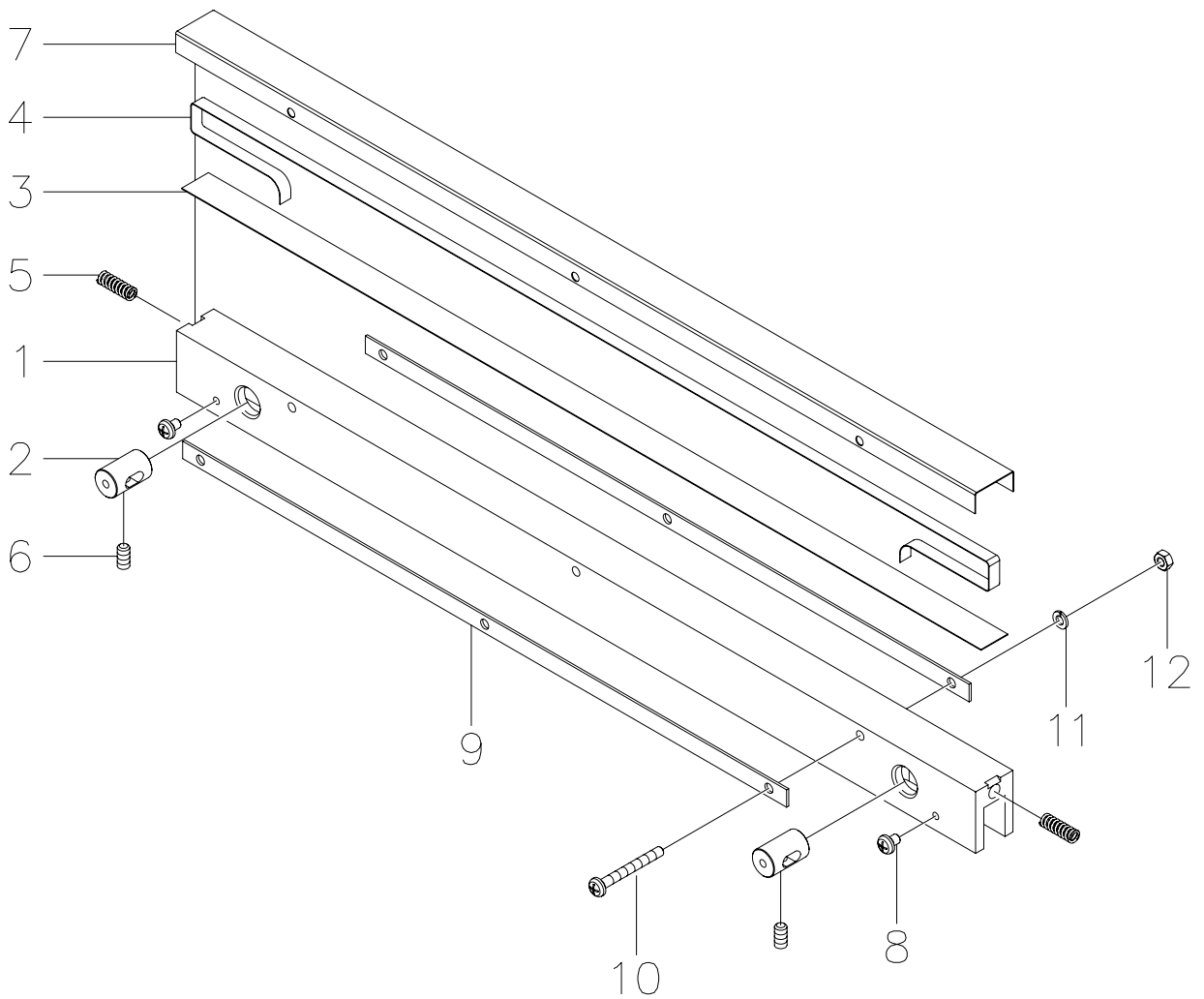


VA04220A00

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	VA04220000	Sealing bar	1	
2	VA04221000	Sealing element holder	2	
3	3200958	Teflon tape, 16mm	1	
4	2824050265	Sealing element for seal	1	
5	2827130012	Sealing element for cut	2	
6	2704617	Socket set screw M4 x 10	4	
7	3200955	Teflon tape 450 x 45 x 0.45	1	
8	2703304	Round head screw M4 x 6	2	
9	VA04226000	Teflon tape clamp	2	
10	2703310	Round head screw M4 x 30	3	
11	2705306	Split lock washer M4	3	
12	27072042	Hex nut M4	3	

7.3.3 SEALING BAR-STANDARD DIAGRAM-LR

Sealing Bar-Standard Diagram

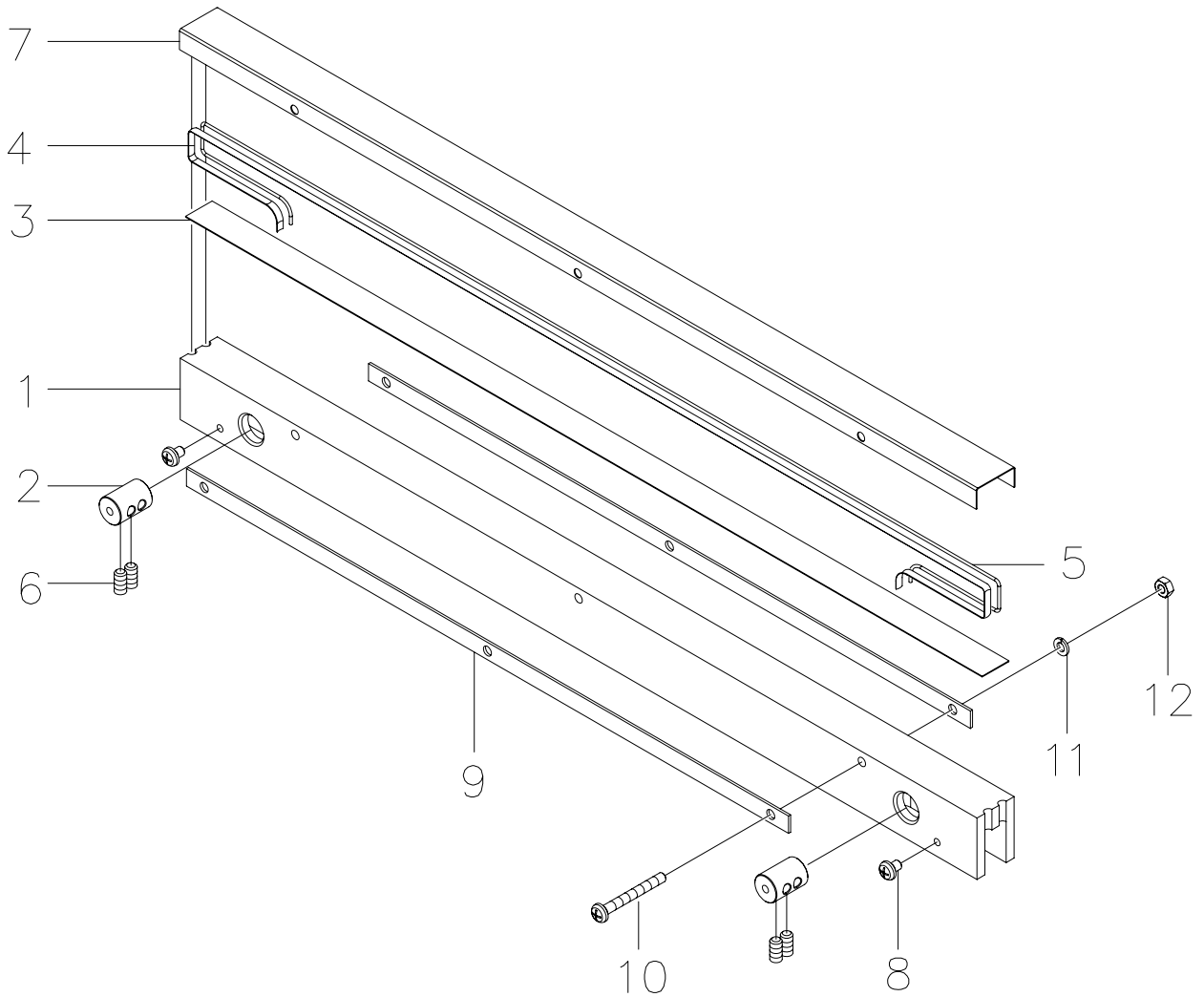


VA05270A00

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	VA05270000	Sealing bar	1	
2	VA04271000	Sealing element holder	2	
3	3200958	Teflon tape , 16mm	1	
4	2827010064	Sealing element, 6mm	1	
5	VA04277000	Spring	1	
6	2704617	Socket set screw M4 x 10	1	
7	VA05225000	Teflon tape 430 x 45 x 0.45	1	
8	2703304	Round head screw M4 x 6	2	
9	VA04226000	Teflon tape plate	2	
10	2703310	Round head screw M4 x 30	3	
11	2705306	Split lock washer M4	3	
12	27072042	Hex nut M4	3	

7.3.4 SEALING BAR-STANDARD DIAGRAM-LRC

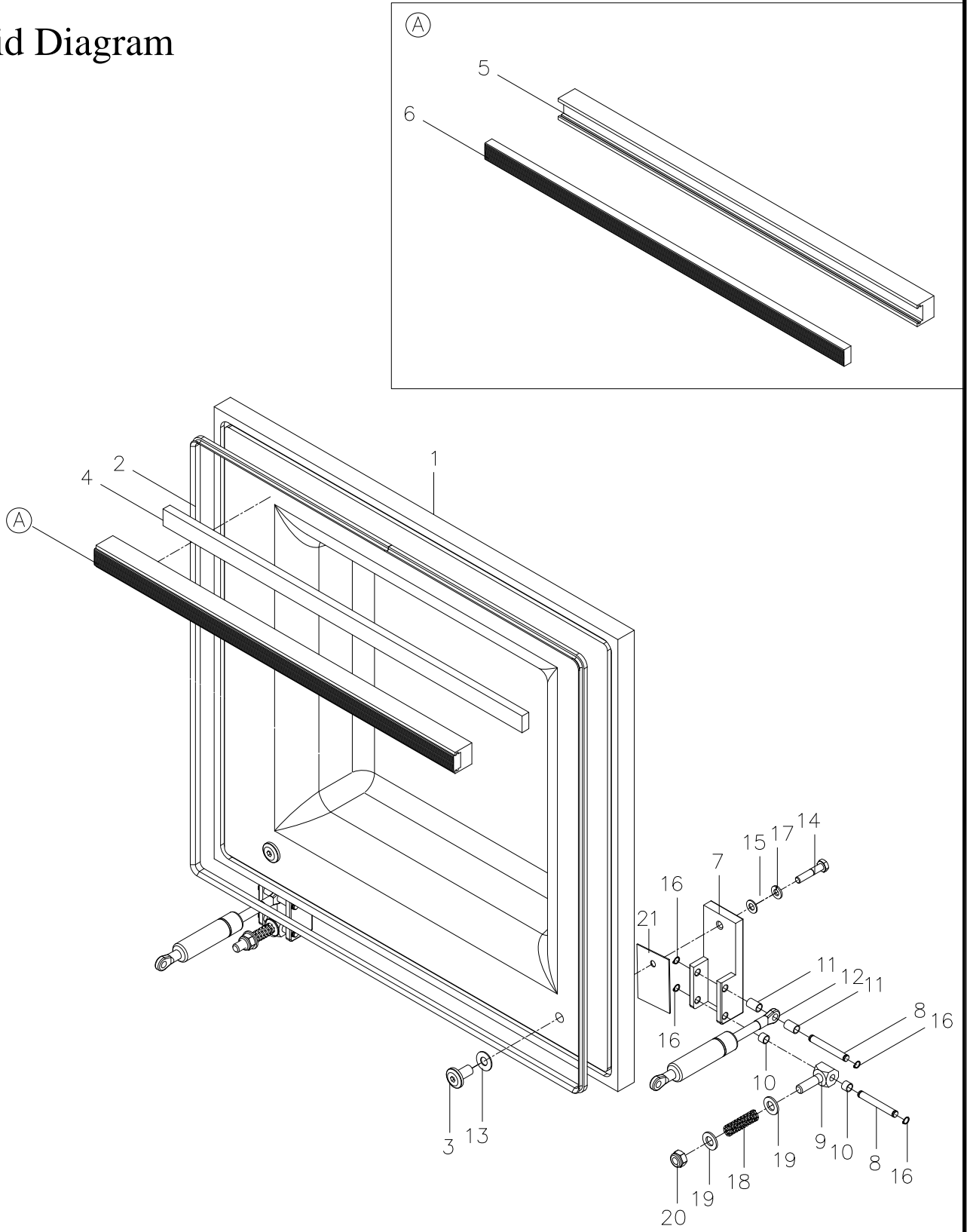
Sealing Bar-Standard Diagram



VA05220A00

7.4.1 LID DIAGRAM-F

Lid Diagram

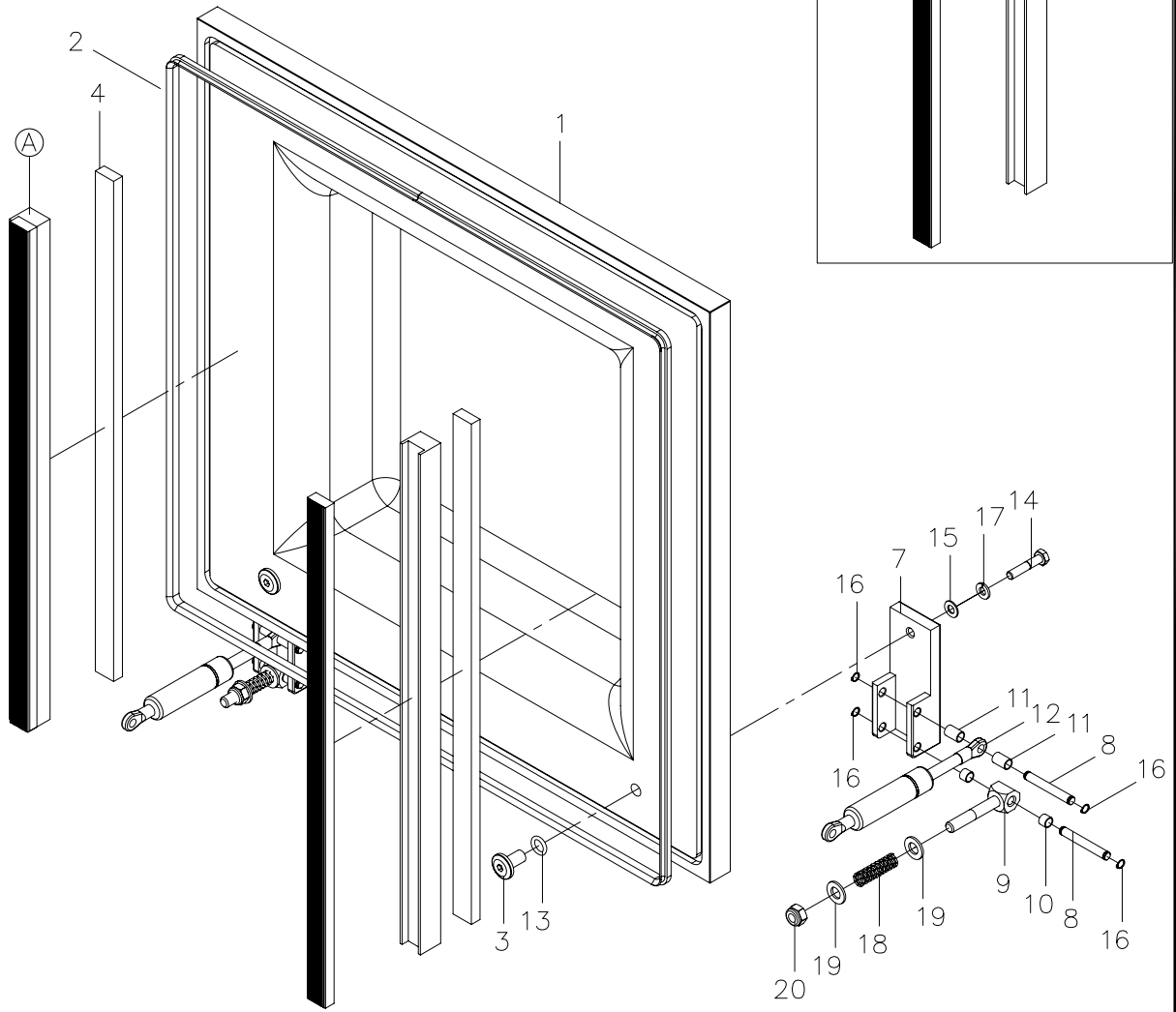


VA04301A03

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	VA04301005	Vacuum lid	1	
2	3114459	Lid gasket	1	
3	VA04303000	Binding post screw	2	
4	3200410	Tape	1	
5	VA04311002	Sealing bar - top	1	
6	3114463	Sealing silicone	1	
7	VA04320000	Lid Holder	2	
8	VA04321001	Hinge Pin	4	
9	VA04322002	Bolt(E) 5/8" x 5/8" x 62L	2	
10	VA04323001	Washer(E) $\phi 8$ x 6L	4	
11	VA04324001	Washer(E) $\phi 8$ x 12L	4	
12	VA04330002	Gas spring	2	
13	TC28325000	Washer	2	
14	2700462	Hex hd screw M6 x 30	2	
15	2705151	Washer M6	2	
16	27060141	Ring S6	8	
17	2705302	Split lock washer M6	2	
18	VA04325000	Pressure spring $\phi 10$ x $\phi 1.2$ x 36L	2	
19	2705152	Washer M8	4	
20	2707103A	Nylock nut M8	2	
21	VA04326000	Washer	2	
A	VA04311A02	Cushion bar assembly	2	

7.4.2 LID DIAGRAM-LR

Lid Diagram

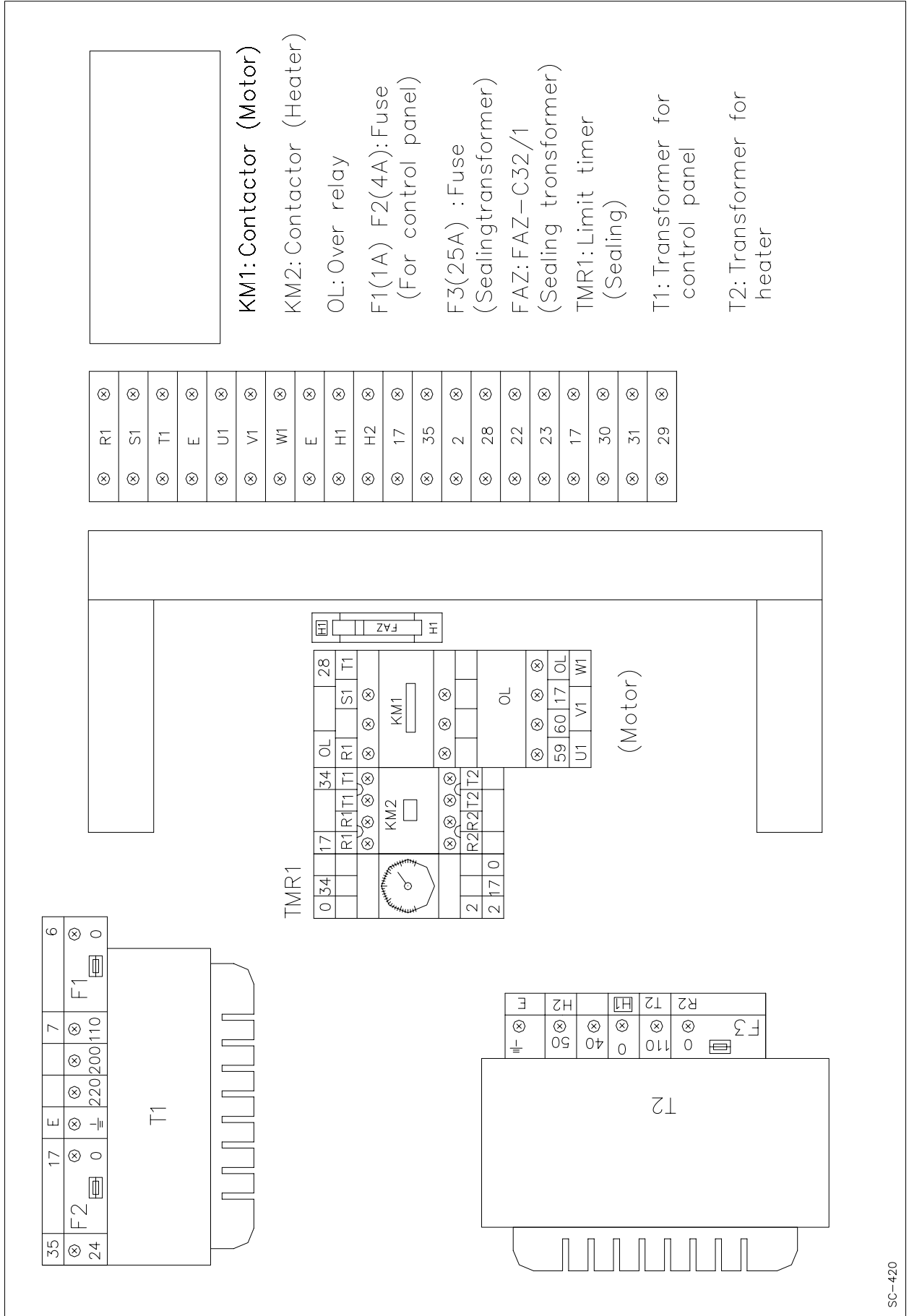


VA05301A03

NO.	PART NO.	DESCRIPTION	Q'TY	NOTE
1	VA04301005	Vacuum lid	1	
2	3114459	Lid gasket	1	
3	VA04303000	Binding post screw φ19 x 21L	2	
4	3200410	Tape 20W x 8M x 6.4t	2	
5	VA05311002	Cushion bar	2	
6	3114463	Sealing silicone 18 x 9 x 430L	2	
7	VA04320000	Lid Holder 28 x 40 x 102	2	
8	VA04321001	Hinge Pin φ6 x 45L	4	
9	VA04322002	Bolt(E) 5/8" x 5/8" x 62L	2	
10	VA04323001	Washer(E) φ8 x 6L	4	
11	VA04324001	Washer(E) φ8 x 12L	4	
12	VA04330002	Gas spring	2	
13	2740174	O-ring P10A	2	
14	2700462	Hex hd screw M6 x 30	2	
15	2705151	Washer M6	2	
16	27060141	Ring S6	8	
17	2705302	Split lock washer M6	2	
18	VA04325000	Pressure spring	2	
19	2705152	Washer M8	4	
20	2707103A	Nylock nut M8	2	
A	VA05311A02	Cushion bar assembly	2	

7.5 ELECTRICAL BOX

STANDARD



ITEM	PART NO.	DESCRIPTION	SPECIFICATION	Q'TY	NOTE
KM1	2810739	Contactora	3A1a CN-11-B5 (AC24V)	1	
KM2	2810758	Contactora	CU-18/4P-4A (AC24V)	1	
OL	2811514	Overload Relay	RHN-10K(12.5~18A)	1	
F1	2890048	Fuse	20mm 1A	1	
F2	2811659	Fuse	20mm 4A	1	
F3	2890069	Fuse	20mm 25A	1	
R1	2833328	Time Relay	ANLY AMY-2 6S AC24V	1	
	2833329	Socket Relay	PYF08A-E MY2	1	
	2850636	Hook	PYC-A1	2	
T1	2896037	Transformer	TBSW-1I-70VA CE 0F-110-200-220V/0F-24V	1	
T2	28960941	Transformer	500VA 0F-110V/ 0-45V	1	
	28960943		500VA 0F-220V/ 0-45V	1	Option
T.B	2843212	Terminal Block	PUT-10 (17~29)	10	
	2843209	Terminal Block	PTU-30 (R1~H2)	10	
	2843210	Plate, Terminal Block	PTU-30L2	1	
	2843207	Brake, Terminal Block	SBN-20	2	
POWER	2896515	Power Supply	MT S-50-24	1	Option
T.B	2843212	Terminal Block	PUT-10 (17~29)	2	Option
FAZ	2801734	Breaker	FAZ-C32/1	1	