



OWNER'S MANUAL

VACCUM MACHINE 380T

IMPORTANT SAFETY INSTRUCTIONS

SAVE THESE INSTRUCTIONS



This symbol points out important safety instructions which, if not followed, could endanger the personal safety and/or property of yourself and others. Read and follow all instructions in this manual before attempting to operate your machine. Failure to comply with these instructions may result in personal injury.

General Operation

- Read, understand, and follow all instructions in the manual and on the machine before starting. Keep this manual in a safe place for further and regular reference and for ordering replacement parts.
- Only allow responsible individuals familiar with the instructions to operate the machine. Be sure to know controls and how to stop the machine quickly.
- Never put your hands near moving parts.
- Only allow qualified individuals for the maintenance of your machine.
- Remove all obstacles, which may interfere with the machine functions.
- Clear the work area such as electrical wires, buckets, knives etc.
- Be sure that everyone else is clear of your work area before operating the machine.
- Do not sit nor stand on the machine.
- Always turn off the machine after your work is done. Never leave a running machine unattended.
- Always disconnect and wait till the machine has cooled before attempting any maintenance.
- Do not wear loose fitting clothes or jewelry as they may get caught in moving parts of the machine.
- Always wear security shoes, to prevent injury caused by moving the machine or objects falling from the machine.
- Never exceed the time limit to seal, which is recommended by the manufacturer. This is to avoid any damage that may be caused to the sealing bars and to eliminate the risk of fire in the machine. Thus avoiding corporal burns.
- Never touch the sealing bars after they have been used, this will avoid corporal burns. Wait a few minutes to let the machine cool down before touching.
- Always make sure that the sealing bars are well installed in their "Guide Blocks" before starting a cycle.
- Never incline the machine more than 30 degrees, it may tip over and hurt someone seriously.
- Work only in daylight or good artificial light.

Do not operate the machine while under the influence of alcohol or drugs!

Service

- Use proper containers when draining the oil. Do not use food or beverage containers that may mislead someone into drinking from them. Properly dispose of the containers, or store in a safe place immediately following the draining of the oil.
- Prior to disposal, determine the proper method to dispose of waste from your local office of Environmental Protection Agency. Recycling centers are established to properly dispose of materials in an environmentally safe fashion.

Do not pour oil or other fluids into the ground, down a drain or into a body of water.



Warning-Your responsibility:

This machine should only be operated by personal who can read, understand and respect warnings and instructions regarding this machine in the owners manual. Save these instructions for future reference.



WARNING: All electrical work described in this brochure should be done by a QUALIFIED and AUTHORIZED technician.

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VACUUM PACKAGING MACHINES

1. SETTING UP THE MACHINE:

Before choosing the site for the machine, please consider that you will also need room for packaged and non-packaged products apart from the space needed for the machine itself.

Keep in mind that the machine must not be set up upon uneven ground. Especially with mobile models, the weight of the pump might then cause warping of the machine. Then the lid will not fit correctly.

Before starting to work, check the oil view glass on the pump, if there is a sufficient quantity of oil in the pump. Never use oil other than recommended by the producer. Never exceed maximum quantity of oil indicated, when adding or changing oil. Verify weekly.

Normal ambient temperature for the vacuum pump is between 10 to 70°C. For temperature below 10°C; it is recommended to use synthetic oil. Please consult factory and pump manufacturer manual for more information or when ambient temperature are outside normal limits

2. ELECTRICAL CONNECTION:

Electrical connections must be made by qualified personnel. This person must make sure that the electrical entries corresponds to the proper voltage and amperage of the machine. **GROUNDING INSTRUCTIONS:** This appliance must be grounded. In the event of malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This appliance is equipped with a cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

DANGER Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal. Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if in doubt as to whether the appliance is properly grounded. Do not modify the plug provided with the appliance if it will not fit the outlet; have a proper outlet installed by a qualified electrician.

All vacuum machines are supplied with an electrical schematic drawing.

An important step in connecting the machine is to make sure that the pump turns in its correct rotation.



The pump should not rotate more than 3 to 4 seconds in the wrong rotation or it may cause serious damage. The proper rotation is indicated by an arrow on the pump motor.

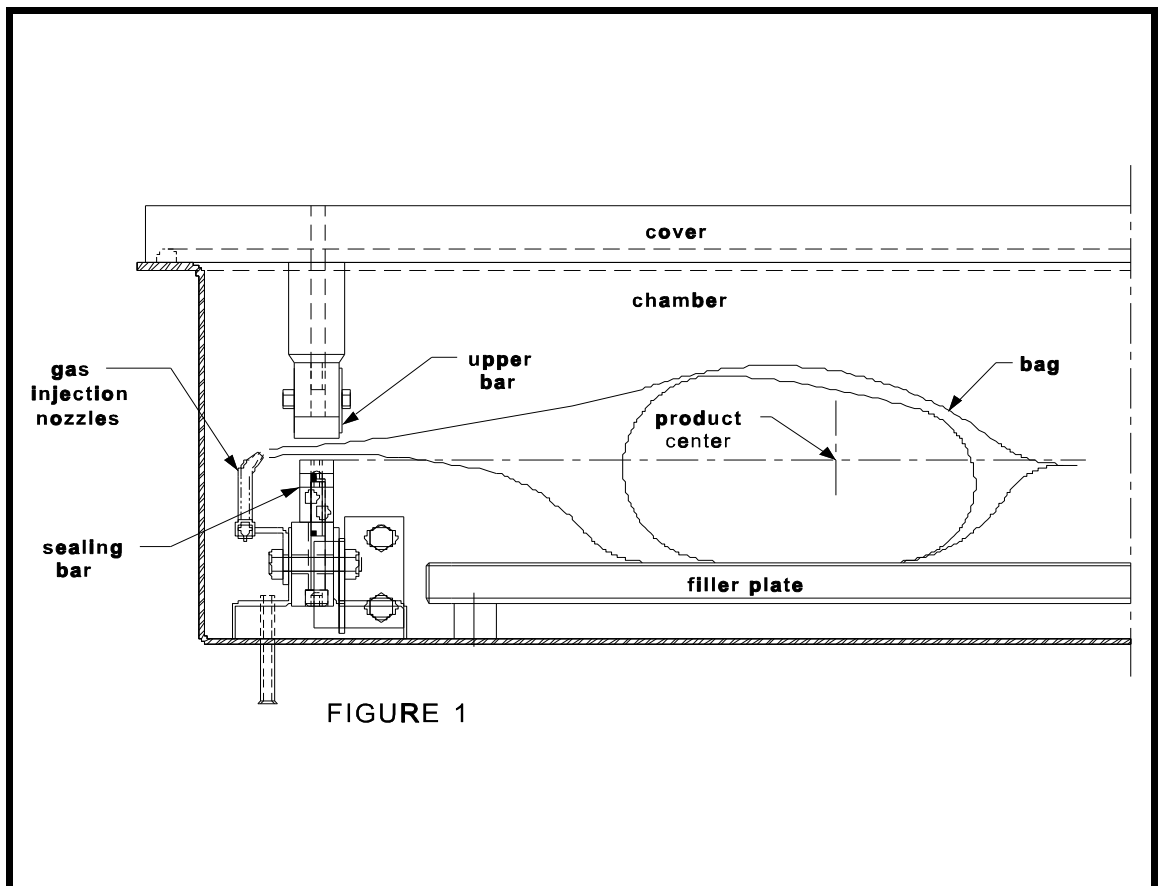
3.OPERATION:

3.1 Working principles:

A vacuum packaging cycle is made of 3 stages. First the vacuum is made, the air is completely taken out of the chamber and from bag containing the product. (See figure 1). Then it is possible to inject neutral gas from the nozzles, if the product is delicate. Finally, a mechanism pushes the sealing bar to the rubber support to seal the bag.

To obtain nice packages, the products and the bags have to be of proportional sizes. The bag's opening should never exceed 50 cm(2") past the seal bars. The product should be centered in height in relation to the seal bar by adjusting the spacers provided.

To obtain a good seal, make sure that no residue of fat is left between the bag's inner sides where sealing is done.



3.2 Special packaging:

3.2.1 Gas flushing (option):

There is an atmospheric pressure of 1 kg/ sq. cm (14 lbs/sq. inch) upon products when fully evacuated. Products which can be damaged by high pressure must be packaged with a partial vacuum, or the pressure must be counterbalance by inflating the bag with gas (nitrogen or carbon dioxide) before sealing after evacuation.

For gas flushing, the bags are placed on the sealing bars, the open end placed over the gas nozzles mounted alongside the sealing bar. After evacuation, the vacuum valve closes and the gas valve opens. Gas time (sec.) can be set in the program menu.

The necessary gas tank and pressure valve mounted on tank is not supplied, The pressure of the gas regulator should be set at approximately 1/3 kg/sq. cm (5 lbs/sq.inch.). Each machine has an adaptor for gas connection when gas flush option is ordered.

3.2.2 Electrical bag cut (optional):

This option is used to obtain a package that the excess bagtail is cut off close to the seal (cannot be used with top and bottom sealing).

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 14 and the keyboard detail on page 15.

3.3.1 Basics:

Use key "POWER" to power ON / OFF the vacuum packaging machine. When the unit is energized, the identification of the last executed program is displayed on LCD screen. To disconnect, use the "POWER" key to turn off the machine , then remove plug from outlet. Do not unplug by pulling on cord. To unplug, grasp the plug, not the cord. Unplug from outlet when not in use and before servicing or cleaning.

Use the "ESC" key to change over from the programs menu to the functions menu and from the functions menu to the programs menu.

In functions menu, use key "SELECT" to select a function and key "ENTER" to accede and executed the selection.

In programs menu, use key "SELECT" to select a program and key "ENTER" to accede and modify the selection.

In programs submenu, use key "ENTER" to pass over the parameters and point to the following one; the parameters are blinking to point out the acquisition mode. A return to programs menu is performed automatically following the last parameter

acquisition.

In program submenu, use key "ESC" to get back to the programs menu. Strike any key to clear the error messages which may be displayed on LCD screen.

3.3.2 Functions menu:

3.3.2.1 Create a program:

When executing the "create a program" function, the program submenu is acceded, starting with the identification. The initial identification "Pxx NO NAME" is given to the program and all parameters are established to zero; the program number is allocated automatically.

3.3.2.2 Delete a program:

When executing the "delete a program" function, the programs menu is acceded and the number of the first program in memory is blinking to point out the deletion mode. Use key "SELECT" to select a program and key "ENTER" to accede and confirm deletion of the selection. Use key "ESC" to unconfirm a deletion and to leave the function. When leaving the function, the number of the actual program on LCD screen cease to blink.

3.3.2.3 Select operating mode:

When executing the "select operating mode" function, which is available only for the automatic units, the actual selection is blinking to point out the acquisition mode. Use key "SELECT" to get through the operating modes, which are automatic, semi-automatic and manual; the validation of the selected operating mode is performed automatically. Use key "ESC" or "ENTER" to leave the function and get back to the program menu.

3.3.3 Programs menu:

3.3.3.1 Program identification:

For a selected program, set the identification, using the numeric keyboard characters chart; press numeric key until the desired character is selected (4 times for the numeric value). Use key "ENTER" to validate the character and to validate the characters string at the end(the new characters string is blinking). In a middle of an acquisition, use key "ESC" to come backward and erase one or several characters.

Example: EXAMPLE 1 (9 characters)	→	keys 2, 2, ENTER	→	E
		keys 8, 8, 8, ENTER	→	X
		keys 1, ENTER	→	A
		keys 5, ENTER	→	M
		keys 6, ENTER	→	P
		keys 4, 4, 4, ENTER	→	L

keys 2, 2, ENTER → E
keys 9, 9, 9, ENTER → space
keys 1, 1, 1, 1, ENTER → 1
key ENTER to validate the characters string

3.3.3.2 Vacuum time setting (sensor disabled):

For a selected program set the vacuum time, in seconds; the validation is automatically performed following the second digit entry (the new vacuum time is blinking). In a middle of an acquisition, use key "ENTER" to validate the vacuum time and key "ESC" to come backward and start over with a new acquisition (the old vacuum time is blinking).

Examples: 1s → keys 0, 1 or 1, ENTER
15s → keys 1, 5

3.3.3.3 Vacuum level setting (sensor enabled)

For a selected program set the vacuum level, starting with the values; the decimal point is automatically inserted following the second digit entry and the validation is automatically performed following the third digit entry (the new vacuum level is blinking). The vacuum level is rounded off to the nearest half value. In the middle of an acquisition, use key "ENTER" to validate the vacuum level and key "ESC" to come backward and start over with a new acquisition (the old vacuum level is blinking). Set vacuum level to zero to bypass the pressure transducer and proceed only using the vacuum plus time.

Examples: 90.0% → keys 9, 0, 0 or 9, 0, ENTER or
keys 9, 0, 1 or 9, 0, 2 or 9, 0, 3 or 9, 0, 4
97.5% → keys 9, 7, 5 or
keys 9, 7, 6 or 9, 0, 7 or 9, 0, 8 or 9, 0, 9
0.0% → keys 0, 0, 0 or 0, ENTER

3.3.3.4 Vacuum plus time setting (sensor enabled)

For a selected program set the vacuum plus time, in seconds; the validation is automatically performed following the second digit entry (the new vacuum plus time is blinking). In a middle of an acquisition, use key "ENTER" to validate the vacuum plus time and key "ESC" to come backward and start over with a new acquisition (the old vacuum plus time is blinking).

Examples: 1s → keys 0, 1 or 1, ENTER
15s → keys 1, 5

3.3.3.5 Gas time setting (sensor disabled)

For a selected program set the gas time setting following the same procedure as for the vacuum time. Keep in mind that increasing gas time decrease sealing pressure. Some vacuum must be kept inside to assure proper functioning.

3.3.3.6 Gas flush level setting: (sensor enabled)

For a selected program set the gas flush level following the same procedure as for the vacuum level; the maximum gas flush level setting is 10% below the vacuum setting.

3.3.3.7 Sealing time setting:

For a selected program set the sealing, starting with the seconds; the decimal point is automatically inserted following the first digit entry and the validation is automatically performed following the third digit entry (the new sealing time is blinking). The sealing time is truncated to the nearest half hundredth. In a middle of an acquisition, use key "ENTER" to validate the sealing time and key "ESC" to come backward and start over with a new acquisition (the old sealing time is blinking).

Examples: 4.50s → keys 4, 5, 0 or 4, 5, ENTER or
keys 4, 5, 1 or 4, 5, 2 or 4, 5, 3 or 4, 5, 4
2.35s → keys 2, 3, 5 or
keys 2, 3, 6 or 2, 3, 7 or 2, 3, 8 or 2, 3, 9
0.00s → keys 0, 0, 0 or 0, ENTER

3.3.4 Vacuum cycle execution:

For the manual units and the automatic units set on manual, close the cover to initiate a vacuum cycle. For the automatic units set on semi-automatic or on automatic, use push button "STOP / START" to initiate or interrupt a vacuum cycle. A selected program can be initiated only in the programs menu, when no modifications are in progress, and the access to the other programs and functions is denied. During cycle execution the operation status is sequentially displayed on LCD screen, except for the parameters established to zero, which are not displayed:

- Vacuum time or vacuum % status during vacuum sequence,
- Gas time or gas % status during gas flush sequence,
- Sealing time status during sealing sequence,
- ATM message during atmosphere sequence.

During cycle execution, use key "1" to abort the vacuum sequence and execute the following sequence, which is gas flush or sealing, and key "ENTER" to accede and modify the program; the parameters become valid only for the following vacuum cycles.

3.3.5 System monitor:

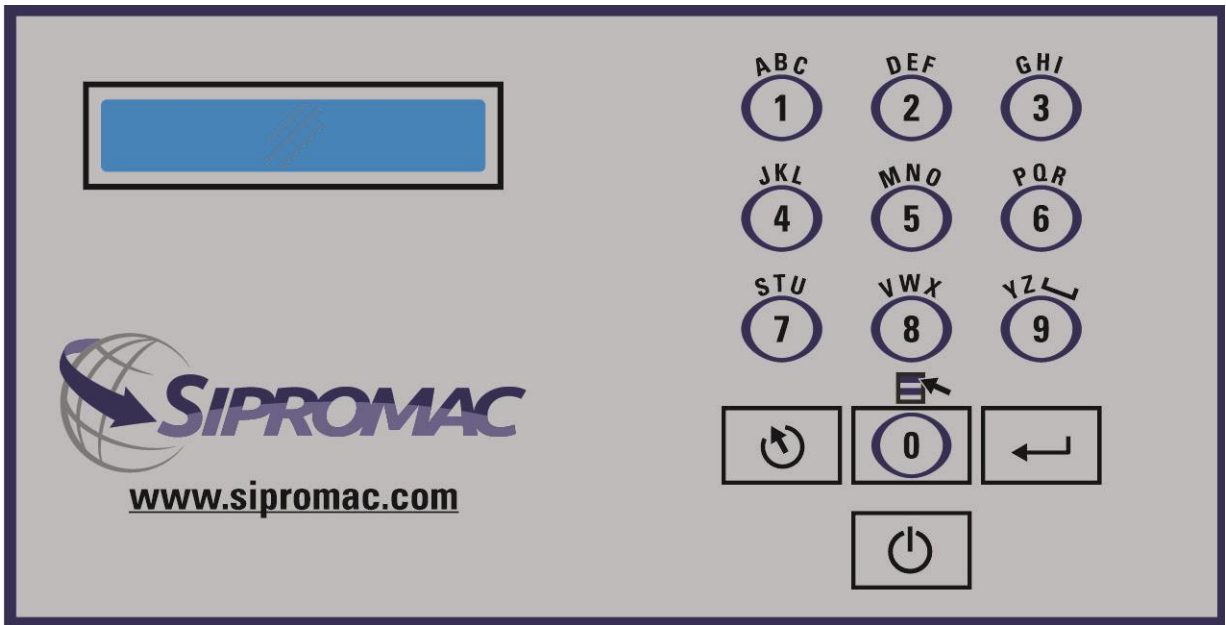
To accede the diagnostics menu, power up the vacuum packaging machine while keeping pushed in the "ESC"key. Use key "SELECT" to select the system monitor function and key "ENTER" to accede and visualize the monitored parameters. Use key "SELECT" to change over from the software revision, the amount of working hours done and the amount of complete cycles performed since first initialization.

-MENUS STRUCTURE-

- **Functions menu:**
 - "F1 CREATE A PRGM"
 - "F2 DELETE A PRGM"
 - "F3 SELECT OPMODE" (automatic units only)
- **Programs menu:**
 - "Pxx NAME"
 - Program submenu:
 - "VACUUM: xx.xs" (10 – 199s)
 - "GAS FLUSH: xx.xs" (0 – 99s) (units with gas option)
 - "SEAL TIME: x.xxs" (0.00s - maximum unit allocated setting)
 - "Pxx NAME" (12 characters)
- **Diagnostics menu** (keys "ESC" & "POWER" for access):
 - "DIAGNOSTICS MENU" (access code required)
 - "D1 INPUTS TEST"
 - "D2 OUTPUTS TEST"
 - "D3 MODEL SELECT"
 - "D4 GAS OPTION"
 - "D5 SEALING TIME"
 - "D6 COOLING TIME"
 - "D7 OFFSET CALIB."
 - "D8 VACUUM SENSOR"
 - "D9 SIPROMAC PUB"
 - "D10 LOADING TIME" (automatic units only)
 - "D11 UNLOADNG TIME" (automatic units only)
 - "SYSTEM MONITOR" (no access code required)
 - "SOFTWARE: R x.xx"
 - "WORK HRS: xxxxx"
 - "CYCLES: xxxxxxxx"

-KEYBOARD DETAILS-

MC-40 CONTROLS



3.4 Daily cleaning:

For hygienic cleanliness, it is imperative to clean chamber and spacers daily. Also clean the lid rubber to assure tight seat of the lid.

Cleaning instructions for gas injection nozzles: Periodically on a regular basis the gas injection nozzles must be removed with the connection tube and soaked in a food grade soap and water solution, then dried and re-installed.

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "COVER DOWN ERROR" message is displayed on LCD(manual units):

The input signal of the down position switch has been lost during cycle execution.
- Check limit switch adjustment.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

Most frequently, insufficient vacuum in bags is due to leakage in bag and not due to any fault of the machine.

Pin-hole leak for which there is no obvious explanation is due to faulty bag material.

Pin-hole leak caused by sharp edge of the product (bone, etc.).Use bone-guard or thicker film.

Tear in bag by careless handling (sharp edge on filling table, damage made by retailer or customer).

Leakage in lateral or bottom seal, complain to supplier of bags or film.

4.2.2 No leakage in the bag:

Bag is too large, therefore the surplus of air remains visible (there is surplus of air in 0.4% of the bag volume in each bag). Use bags of suitable size.

Vacuum time is too short:

Pressure bar is jammed and closes opening of bag during evacuation.

4.2.3 Insufficient vacuum in chamber:

If troubles described under 4.2.1 and 4.2.2 do not apply, there is something

wrong with the evacuation. To find the leakage quickly, check for leaks with a precision vacuumeter, going back step by step from the chamber to the pump.

At the chamber (measuring point at base of valve) at maximum time of evacuation. If more than 6 torr, proceed directly to the pump, if more than 3 torr: have pump service by pump supplier. If pressure at pump is good, reconnect hoses to pump and measure again.

Verify at vacuum hose connections and valve connections.

When proceeding this way, starting from pump, loss of pressure per step must not exceed 0.5 to 1 torr.

Warning: Verify connections of measuring equipment before verifying machine.

Most frequent points of leakage: lid gasket, damaged vacuum hose or loose hose clamps.

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

Sealing pressure too low, bellows leaking or pressure bar jammed.

Leakers in seal: heating wire mechanically damaged (knicked) or silicone rubber uneven.

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactors do not work.

4.3.3 Permanent sealing current:

Contactors are jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

Seal area extremely contaminated by fat or meat juice. Use filling aid.

Sealing temperature is too low (when using very thick films).

Warning: Do not increase sealing time more than really necessary; higher temperature will reduce working life of teflon and silicone rubber.

4.4 Fault in the valve:

Vacuum or air valve does not open.

Check whether there is voltage on the magnetic valves during their period of operation. If there is no voltage a wire is broken or the PC board is damaged.

Lid does not open at the end of the cycle; air enters, but there is still 20 - 40% vacuum in chamber. Vacuum valve does not close.

4.5 MC40 Control board failure

NOTE: Refer to menu structure on page 14.

This board software is allowing access to a "Diagnostics Menu". Only qualified service technicians are authorized to access this menu by entering a security password.

By acceding either the "D1 input test" feature or the "D2 output test" feature, a trained technician will be able to quickly know the origin of the problem: pump, sealing system, pneumatic problem, security switches problem, etc...

Keep in mind that in most cases trouble is due to a leakage, loose electrical Keynesian or evident damage to the main component: vacuum pump, valves..., electrical contactors, thermal overload, fuses holder or transformer.

For assistance do not hesitate to contact your local service technicians.

5. REGULAR MAINTENANCE:

Routine controls to be made at regular intervals:

Check Teflon tape for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

Check switch-point of micro switch, adjust if necessary.

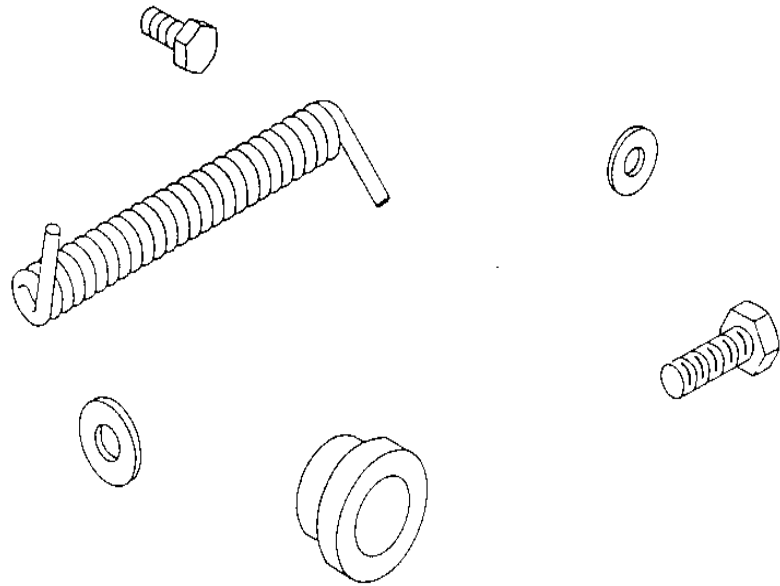
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

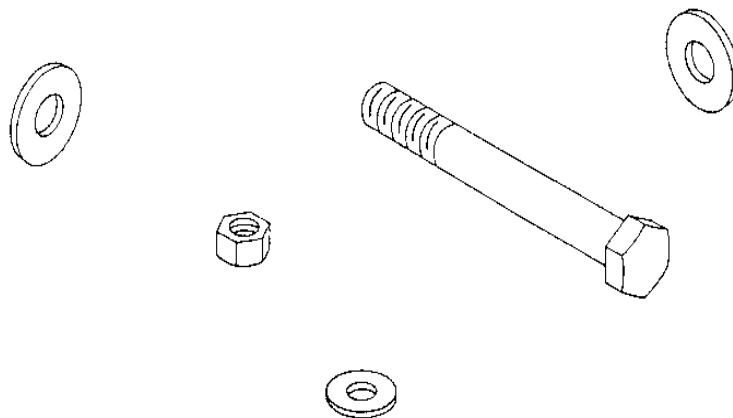
Check oil in pump (oil level in view glass; add if necessary. Regular oil change - necessity indicated by color change).

Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

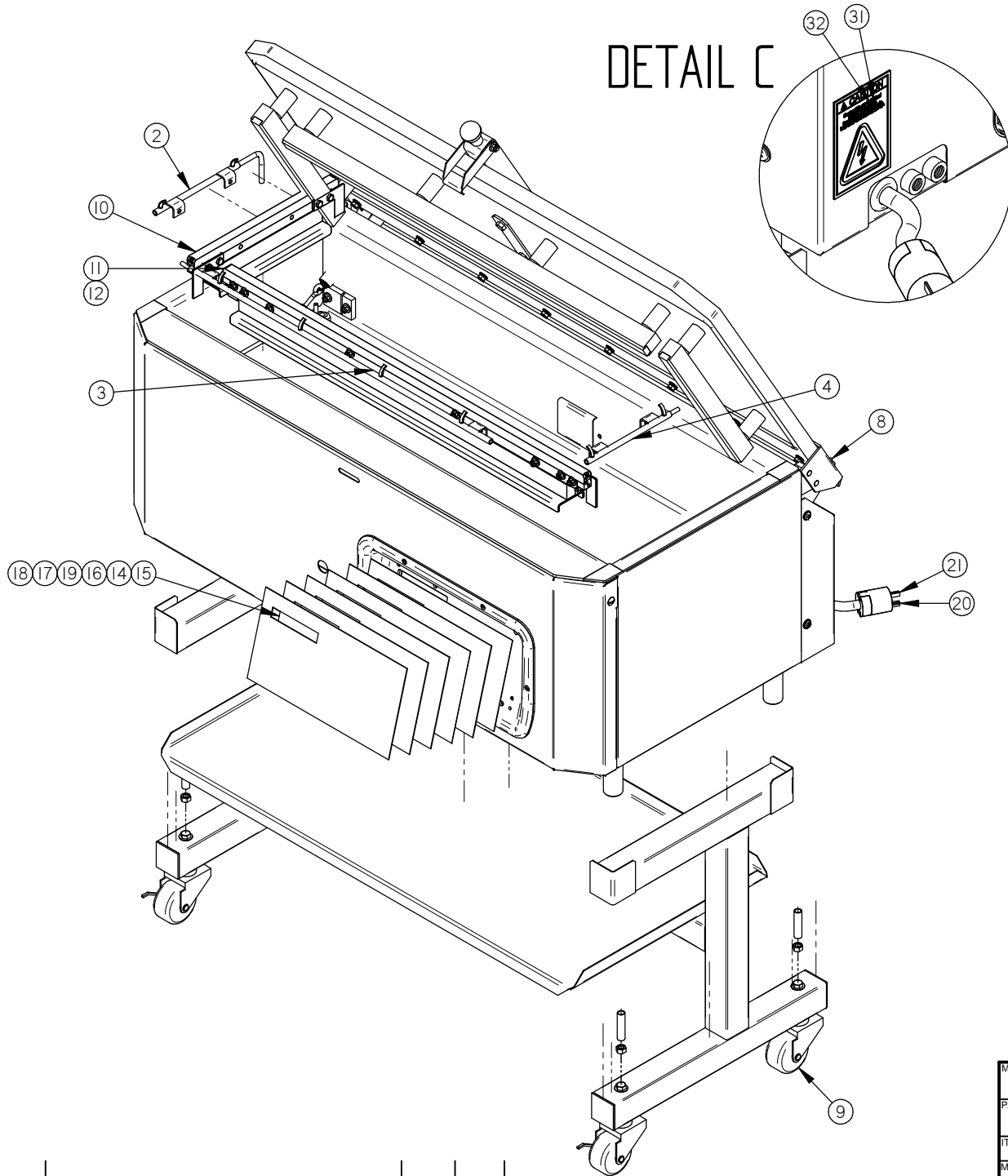


MECHANICAL DRAWING



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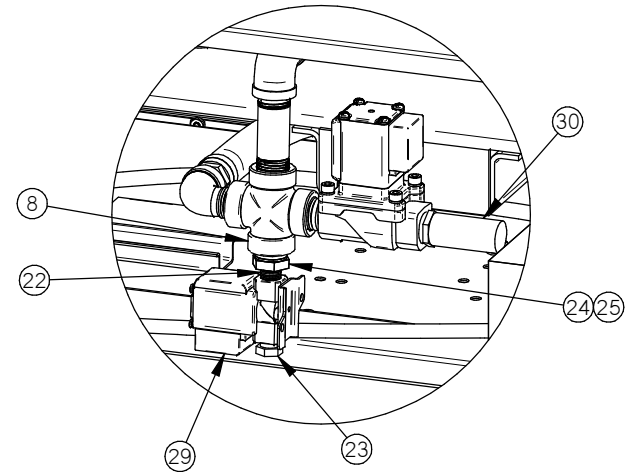
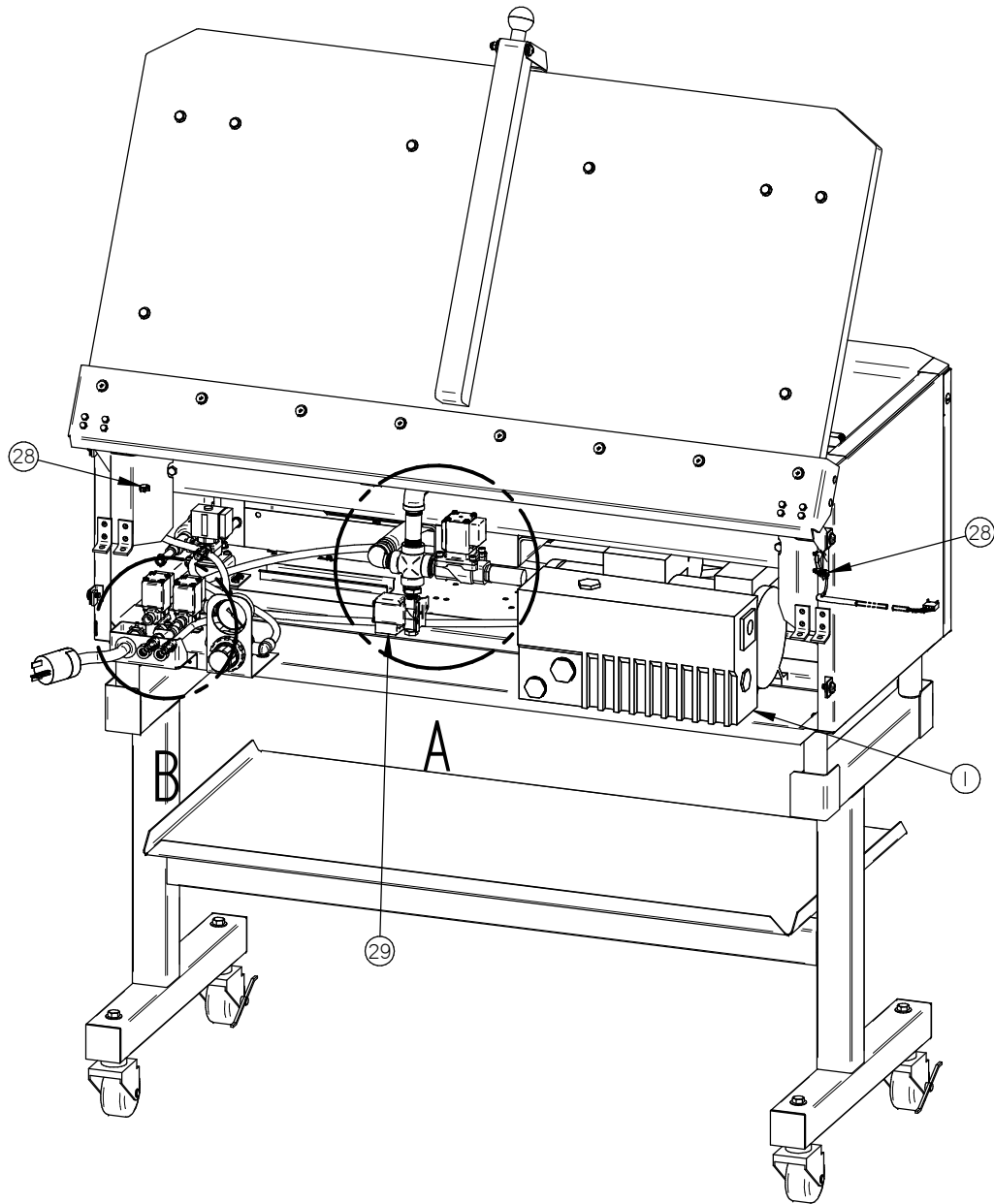
DETAIL C



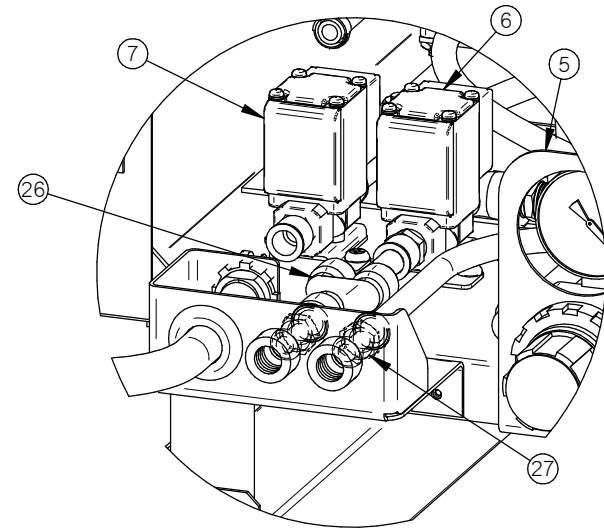
ITEM	PART #	DESCRIPTION	QT.
1	004-0346	"BUSCH" PUMP INSTALATION	1
2	005A0960	LEFT GAS INJECTION BAR ASS'Y	1
3	005A0961	FRONT GAS INJECTION BAR ASSEMBLY	1
4	005A0962	RIGHT GAS INJECTION BAR ASS'Y	1
5	005A1496	AIR REGULATOR VALVE ASSY	1
6	005A1497	GAS VALVE ASSY	1
7	005A1529	GAS VALVE ASSY	1
8	005B0941	BASE MACHINE ASSEMBLY	1
9	005B0972	STAND ASSEMBLY	1
10	005C0803	SEAL BAR ASSEMBLY	2
11	005C0882	LONG SEAL BAR ASSEMBLY	1
12	005C0882	LONG SEAL BAR ASSEMBLY	1
13	005C0967	SEAL BAR ASSEMBLY B.C.O.	2
14	033-0013	MC-40 KEYBOARD "CPI/GUARDIAN"	1
15	033-0014	MC-40 KEYBOARD "FOODPAK"	1
16	033-0015	MC-40 KEYBOARD "SIPROMAC"	1
17	033-0016	MC-40 KEYBOARD "HOLLYMATIC"	1
18	033-0018	MC-40 KEYBOARD "BERKEL"	1
19	033-0019	MC-40 KEYBOARD "BSA"	1
20	036-1510	MALE PLUG 20 AMP. / 125 V.	1
21	036-1512	MALE PLUG 15 AMP. / 250 V.	1
22	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
23	100-0500	RED. BUSH. 1/4" NPT x 1/8" NPT SS	1
24	100-0510	RED.BUSH.1/2"NPT x 1/4"NPT S/S	1
25	100-0832	HEX. PLUG 1/2" NPT S/S	1
26	102-0362	Y BRANCH 3/8" MNPT X 3/8" T. QUICK	1
27	102-0410	MALE CONN.1/4"MNPTx3/8"T.QUICK	3
28	105-0218	EAR CLAMP 3/8" S/S	2
29	106-0010	VALVE 2WAY N.C. 24VAC 1/4" NPT(SMC)	1
30	114-2050	EXHAUST MUFFLER 1/2 NPT S/S	1
31	127-0115	STICKER ELEC. CONN. 15A 2-1/2" X 3-3/4"	1
32	127-0120	STICKER ELEC. CONN. 20A 2-1/2" X 3-3/4"	1

LET.	MODIFICATION	DATE	INT.
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MACHINE		380T		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		MACHINE ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		3D DWG BY SBU		DATE	14-06-12	NO.	M-I
		2D DWG BY AG		DATE	24-09-14	NO.	
							005B0942



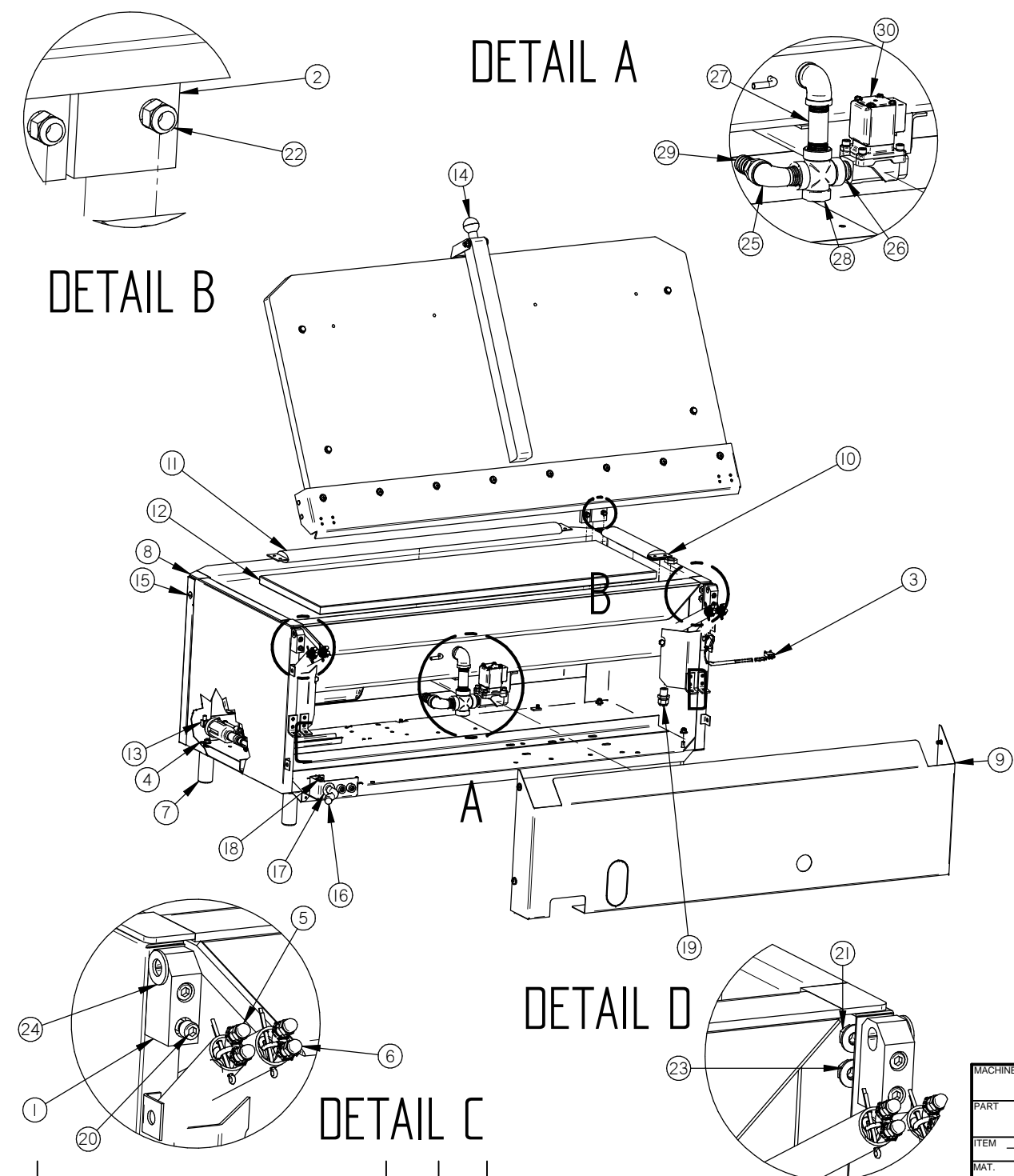
DETAIL A



DETAIL B

MACHINE		380T		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		MACHINE ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		3D DWG BY SBU		DATE	14-06-12	NO.	005B0942
		2D DWG BY		DATE		DEPT.	M-I QTY. 1

005B0941

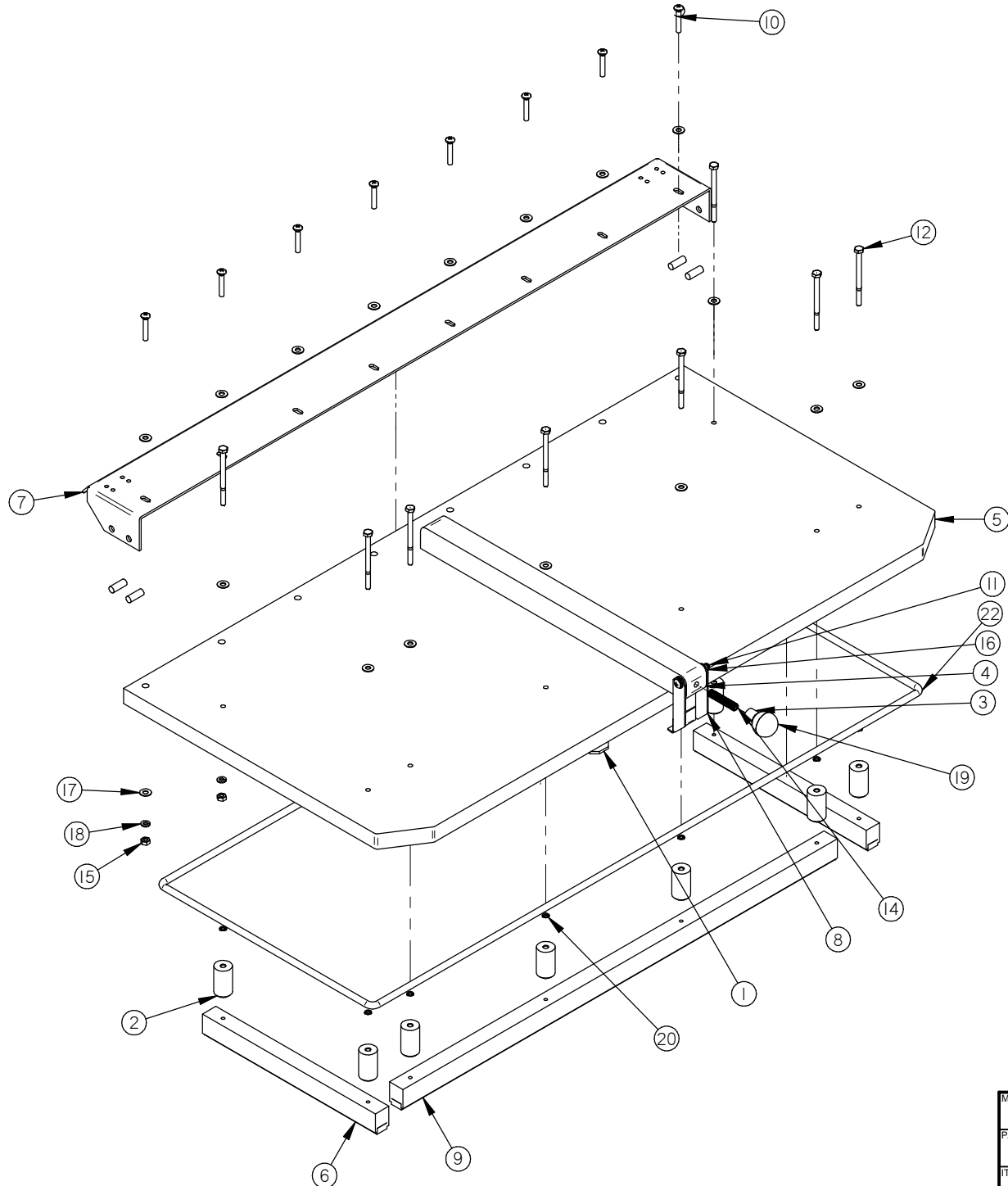


ITEM	PART #	DESCRIPTION	QT.
1	002-0024	HINGE BLOCK	2
2	002-0435	SEAL BAR GUIDE BLOCK	6
3	004-0261	LIMIT SWITCH ASS'Y	1
4	004A0042	ELEC. SUPPORT PRE-ASS'Y	1
5	004A1224	SPRING PRE-ASSEMBLY	2
6	004A1225	SPRING PRE-ASSEMBLY	2
7	004A4112	NSF FOOT	3
8	004B0595	VACUUM 380T PRE-ASSEMBLY	1
9	004C1223	REAR PANEL PRE-ASS'Y	1
10	005-0518	BELLOWS ASS'Y	2
11	005A0889	BELLOWS ASSEMBLY	1
12	005A0925	FILLER PLATE ASSEMBLY	2
13	005A1495	BELLOWS VALVE ASSY	1
14	005B0943	COVER ASSEMBLY	1
15	005C0944	FRONT PANEL ASSEMBLY	1
16	030-0120	CAB TIRE #12/3 SJOW	1
17	036-0200	GROMMET 5/8"IDx1 1/8"OD RUBBER	1
18	036-0390	CABLE CONNECT. 3/8"-1/2"METAL	1
19	036-0400	WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT	6
20	051-0232	SCREW 1/4-20x 1-1/4"SKT CAP SS	4
21	051-0580	NUT 1/4"-20 S/S	4
22	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
23	051-0740	WASHER 1/4" FLAT S/S	12
24	058-0030	NYLON SPACER 3/8IDx3/4ODx1/16	2
25	100-0075	STREET ELBOW 1/2" NPT SS	1
26	100-0230	CLOSE NIPPLE 1/2" npt, S/S	1
27	100-0330	NIPPLE 1/2" NPT X 3" SS	1
28	100-0493	CROSS 1/2" NPT SS	1
29	100-1205	STRAIGHT 1/2"MNPTx3/4" HOSE BARB S/S	1
30	106-00201	VALVE 2WAY 24V 1/2" NPT	1

LET.	MODIFICATION	DATE	INT.
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MACHINE	380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	BASE MACHINE ASSEMBLY		USINAGE ± 0.1 ± 0.004	TOLERIE ± 0.5 ± 0.020	
			SOUDEAGE ± 0.5 ± 0.020	N.T.S.	
ITEM	CNC	DEPT.	M	QTY.	1
MAT.	3D DWG BY SBU	DATE 14-06-02	NO.	005B0941	
	2D DWG BY AG	DATE 24-09-14			

005B0943



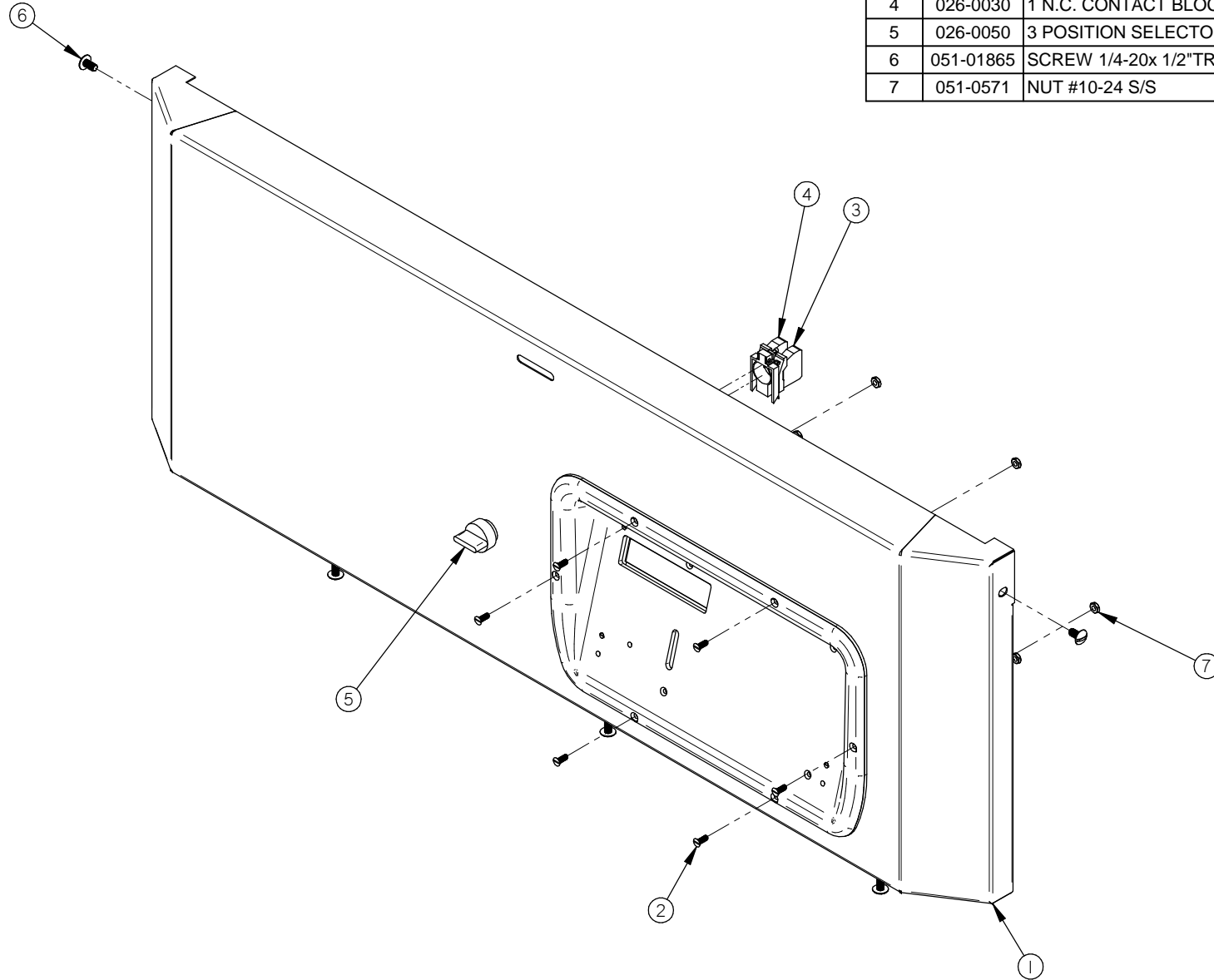
ITEM	PART #	DESCRIPTION	QT.
1	001A3074	COVER REINFORCEMENT	1
2	002-0026	UPPER SEAL BAR SPACER	8
3	002A1295	BALL SPACER	1
4	002B1347	COVER REINFORCEMENT	1
5	002B1786	PLEXI COVER	1
6	004A0308	UPPER SEAL BAR PRE-ASS'Y	2
7	004A1215	COVER HINGE ASSEMBLY	1
8	004A1244	COVER HOLD DOWN ASS'Y	1
9	004A1559	LONG UPPER SEAL BAR PRE-ASS'Y	1
10	051-0249	SCREW 1/4-20x 1-1/2" PAN PHIL SS	8
11	051-0272	SCREW 1/4"-20 x 2 1/4" PAN PHIL S/S	1
12	051-0288	BOLT 1/4-20 x 3 1/2" S/S	8
13	051-0390	BOLT HEX. 3/8"-16nc. X 2" S/S	3
14	051-0393	SCREW 3/8"-16 x 2" SET HEX SKT SS	1
15	051-0580	NUT 1/4"-20 S/S	8
16	051-0581	NUT 1/4"-20 NYLON LOCK S/S	1
17	051-0740	WASHER 1/4" FLAT S/S	28
18	051-0750	WASHER 1/4" LOCK S/S	8
19	057-0001	BALL 1-3/8" x 3/8"-16 PLASTIC	1
20	076-0010	"O" RING 1/4" x 3/8" x 1/16"	8
21	076-0040	O RING 3/8" x 1/2" x 1/16"	3
22	179-0005	NEOPRENE SPONGE 3/8" O.D. (9'-6")	1

LET.	MODIFICATION	DATE	INT.
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MACHINE	380T	DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA			
PART	COVER ASSEMBLY	USINAGE	± 0.1	± 0.004"				
		TOLERIE	± 0.5	± 0.020"				
		SOUDEAGE	± 0.5	± 0.020"				
ITEM	CNC	N.T.S.			DEPT.	M-I	QTY.	1
MAT.	3D DWG BY SBU	DATE	14-08-06	NO.	005B0943			
	2D DWG BY AG	DATE	23-09-14					

005C0944

ITEM	PART #	DESCRIPTION	QT.
1	001C2670	FRONT PANEL	1
2	005B0583	MC-40 CONTROL BOARD	1
3	026-0025	1 N.C. CONTACT WITH BASE	1
4	026-0030	1 N.C. CONTACT BLOCK	1
5	026-0050	3 POSITION SELECTOR	1
6	051-01865	SCREW 1/4-20x 1/2" TRUSS SLOT SS	5
7	051-0571	NUT #10-24 S/S	6

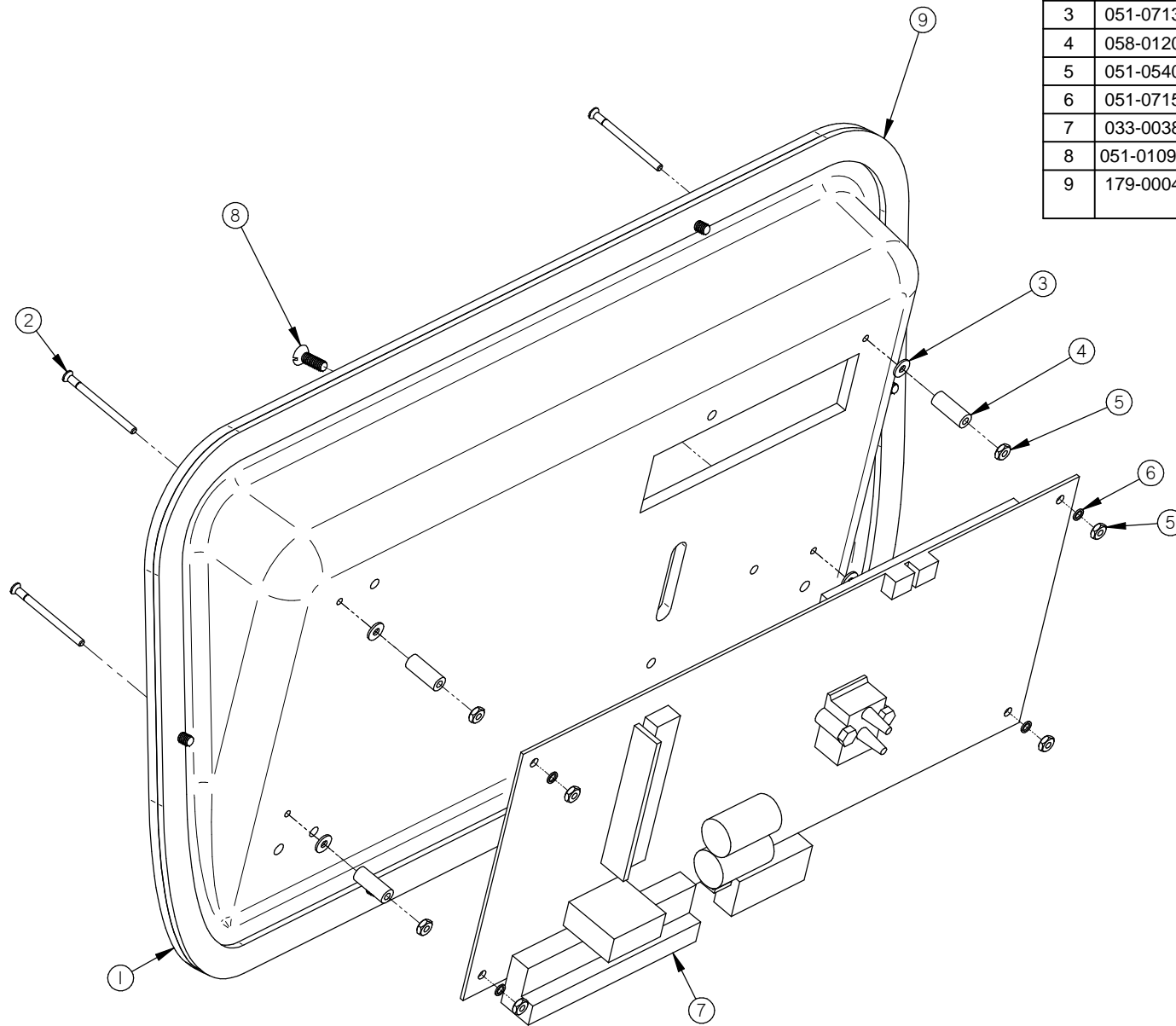


MACHINE		380T		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		FRONT PANEL ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		3D DWG BY SBU		DATE 14-06-12		NO.	005C0944
		2D DWG BY AG		DATE 23-09-14		DEPT.	
						QTY.	1

LET.	MODIFICATION	DATE	INT.
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005B0583

ITEM	PART #	DESCRIPTION	QT.
1	003A0403	CONTROL INSERT	1
2	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	8
6	051-0715	WASHER #4 LOCK SS	4
7	033-0038	MC-40 SENSOR VACUUM	1
8	051-01095	SCREW 8-32 x 1/2 FLAT SLOT SS	6
9	179-0004	NITRILE 1/2" X 1/8" AUTOCOLLANT X 1220mm long	1

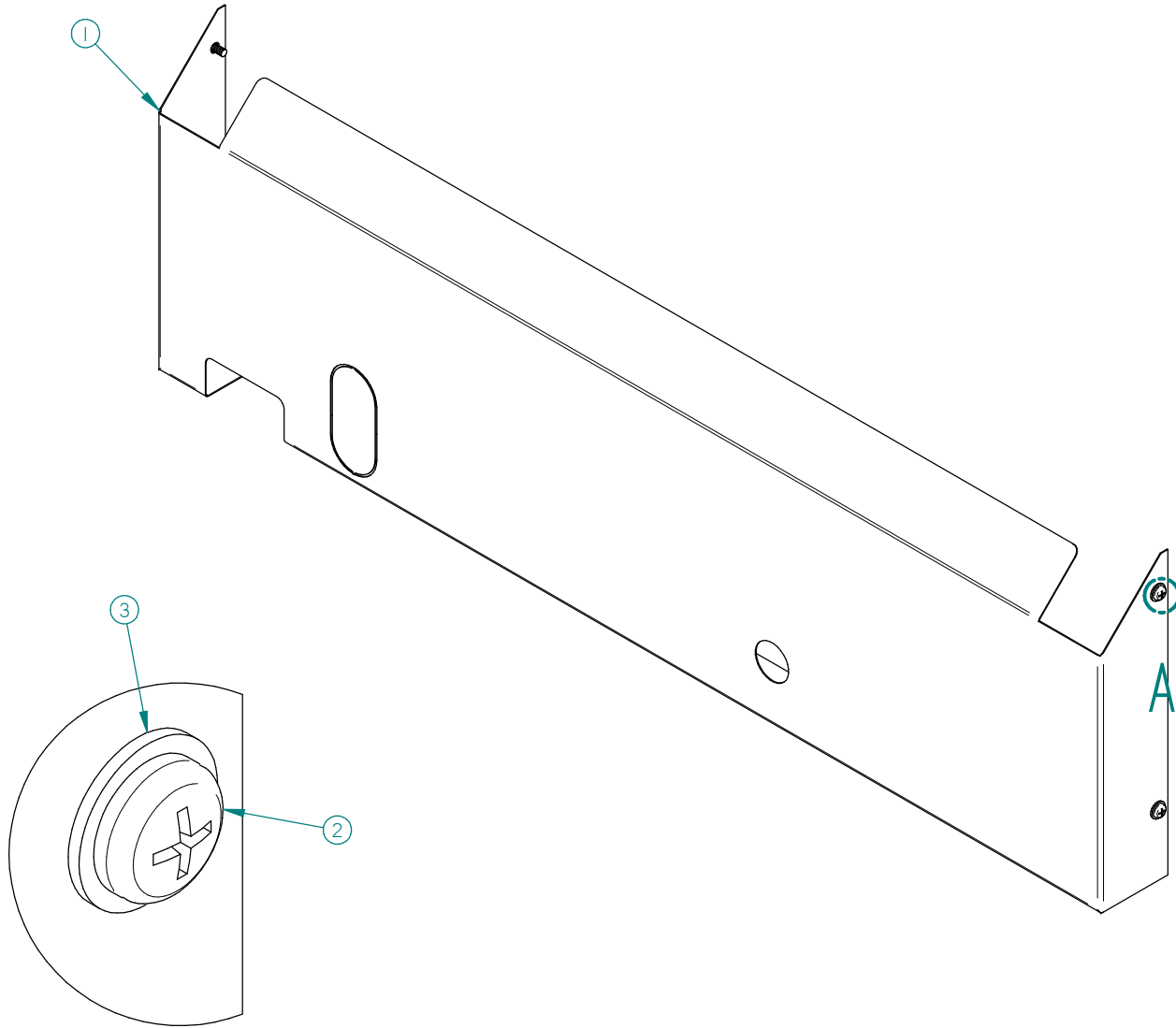


MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		MC-40 CONTROL BOARD		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
				SOUDEAGE	± 0.5	± 0.020"	N.T.S.
ITEM		CNC		DEPT.	M		QTY. 1
MAT.		DWG BY	SBU	DATE	13-11-21		NO. 005B0583
		APP. BY		DATE			

LET.	MODIFICATION	DATE	INT.
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004C1223

ITEM	PART #	DESCRIPTION	QT.
1	001C3063	REAR PANEL	1
2	051-0185	SCREW 1/4-20x 1/2" PAN PHIL S/S	4
3	051-0740	WASHER 1/4" FLAT S/S	4

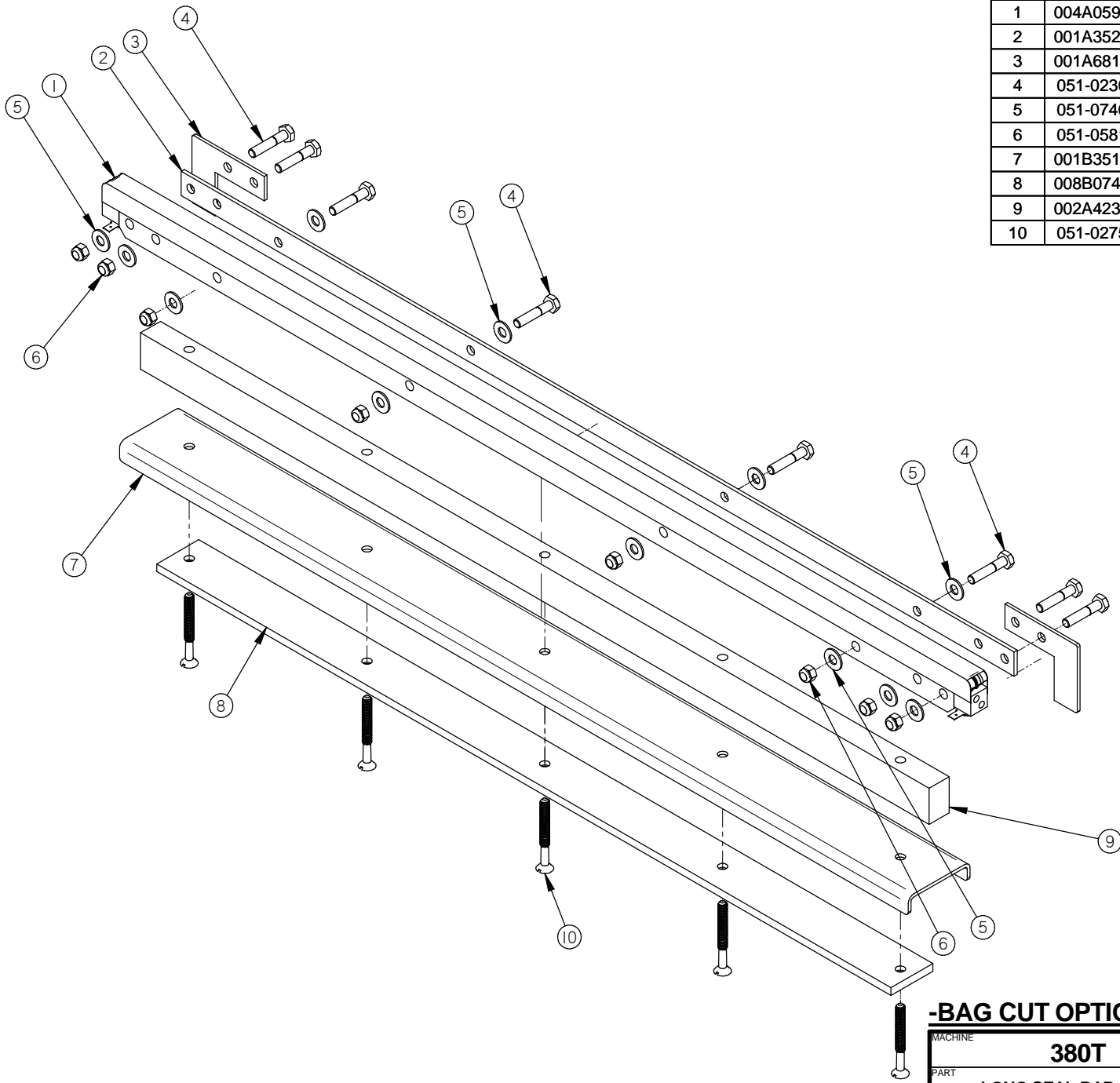


DETAIL A

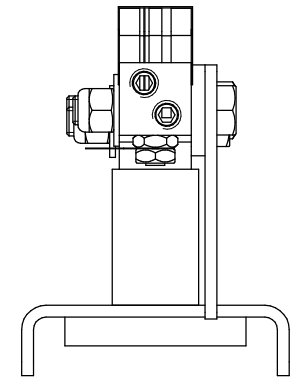
LET.	MODIFICATION	DATE	INT.
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MACHINE	380, 380T		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	REAR PANEL PRE-ASS'Y		USINAGE	± 0.1	± 0.004"	
			TOLERIE	± 0.5	± 0.020"	
			SOUDEAGE	± 0.5	± 0.020"	
ITEM	CNC	DEPT.	N.T.S.		QTY.	1
MAT.	DWG BY	APP. BY	DATE	NO.	004C1223	
	SBU (AG)		14-06-03			

005C0968



ITEM	PART #	DESCRIPTION	QT.
1	004A0599	LONG SEAL BAR PRE- ASS'Y	1
2	001A3521	LONG SEAL BAR REINFORCEMENT	1
3	001A6812	SEAL BAR GUIDE	2
4	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	8
5	051-0740	WASHER 1/4" FLAT S/S	12
6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
7	001B3519	LONG SEAL BAR SUPPORT	1
8	008B0749	LONG BELLOW SPACER	1
9	002A4235	SEAL BAR SUPPORT (LONG)	1
10	051-0275	SCREW 1/4-20 X 2-1/4" FLAT SLOT S/S	5



-END VIEW-

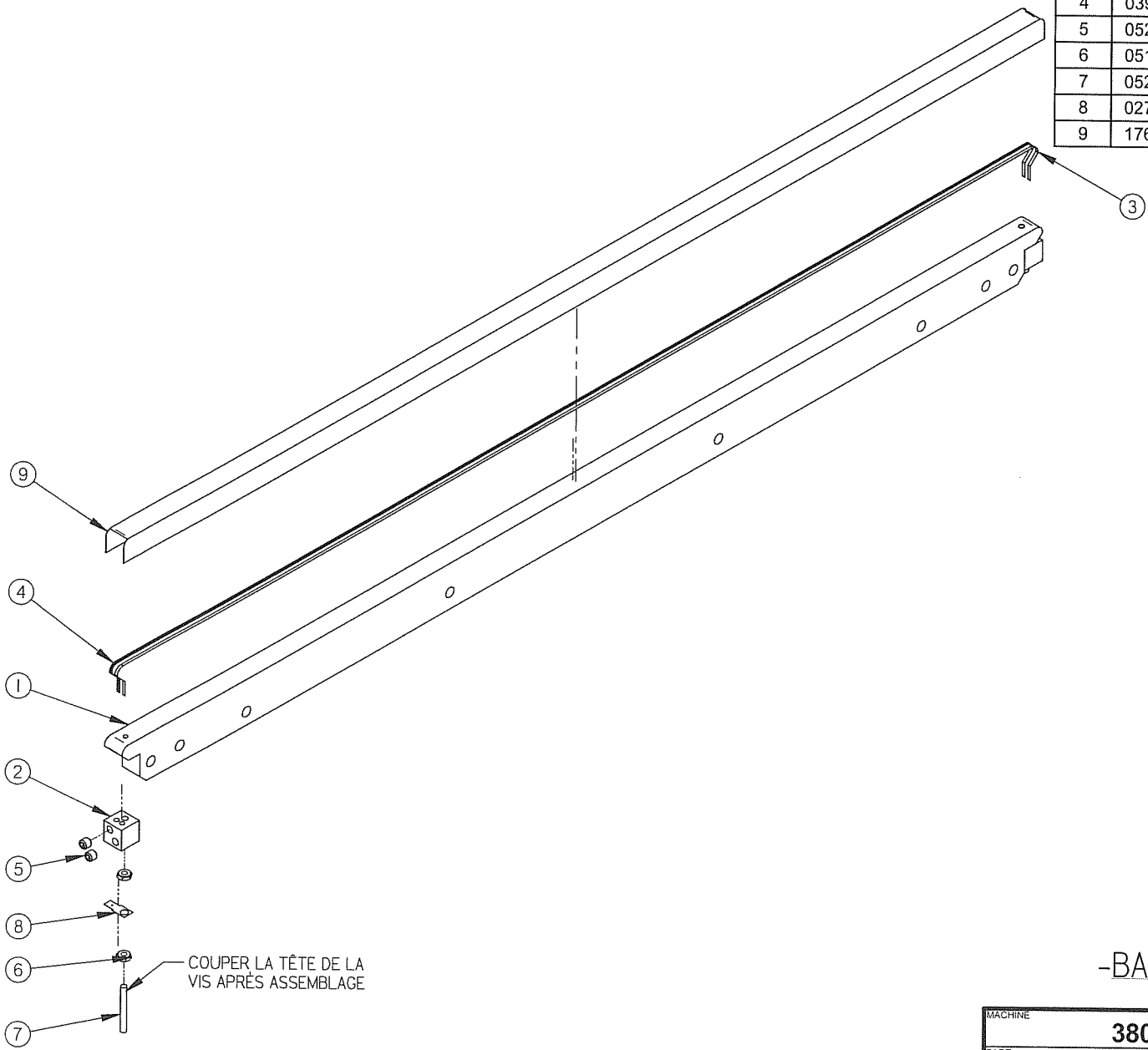
-BAG CUT OPTION-

MACHINE	380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	LONG SEAL BAR ASSEMBLY		USINAGE ± 0.1 ± 0.004"	N.T.S.	
ITEM	CNC	DATE	TOLERIE ± 0.5 ± 0.020"		
MAT.	APP. BY	DATE	NO.	DEPT.	QTY.
	SBU	14-08-06	005C0968	M	1

LET.	MODIFICATION	DATE	INT.
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004A0599

ITEM	PART #	DESCRIPTION	QT.
1	002A1787	LONG SEAL BAR	1
2	002A1275	CONNECTOR	2
3	039-0230	REFLEX BANC 2.5mm (958mm) (0.10)	1
4	039-0270	"T" PROFILE CUT. ELEM. (958mm) (0.10)	1
5	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	4
6	051-0550	NUT #8-32 SS	4
7	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
8	027-0400	CONNECTOR ADAPTOR	2
9	176-0202	TEFLON TAPE .005"x1-1/2" ADHESIVE (.1056)	1

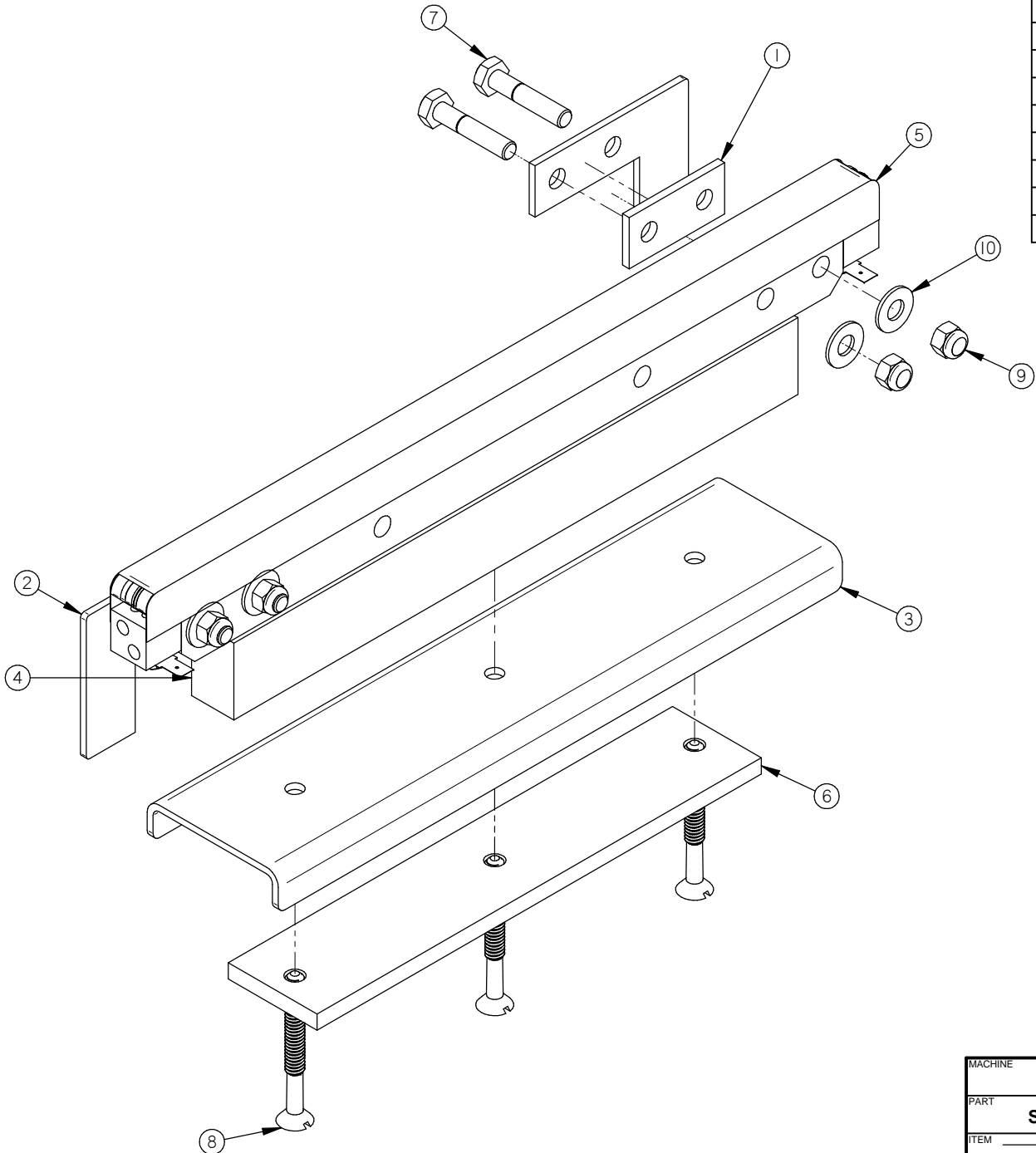


-BAG CUT OPTION-

LET.	MODIFICATION	DATE	INT.
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MACHINE	380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	LONG SEAL BAR PRE- ASSY		USINAGE ± 0.1	± 0.004"	
			TOLERIE ± 0.5	± 0.020"	
ITEM		CNC	SOUDEAGE ± 0.5	± 0.020"	N.T.S.
MAT.		DWG BY M.A.L.	DATE 05-06-22	DEPT.	M-I
		APP. BY D	DATE 05-06-22	NO.	004A0599
				QTY.	1

005C0967



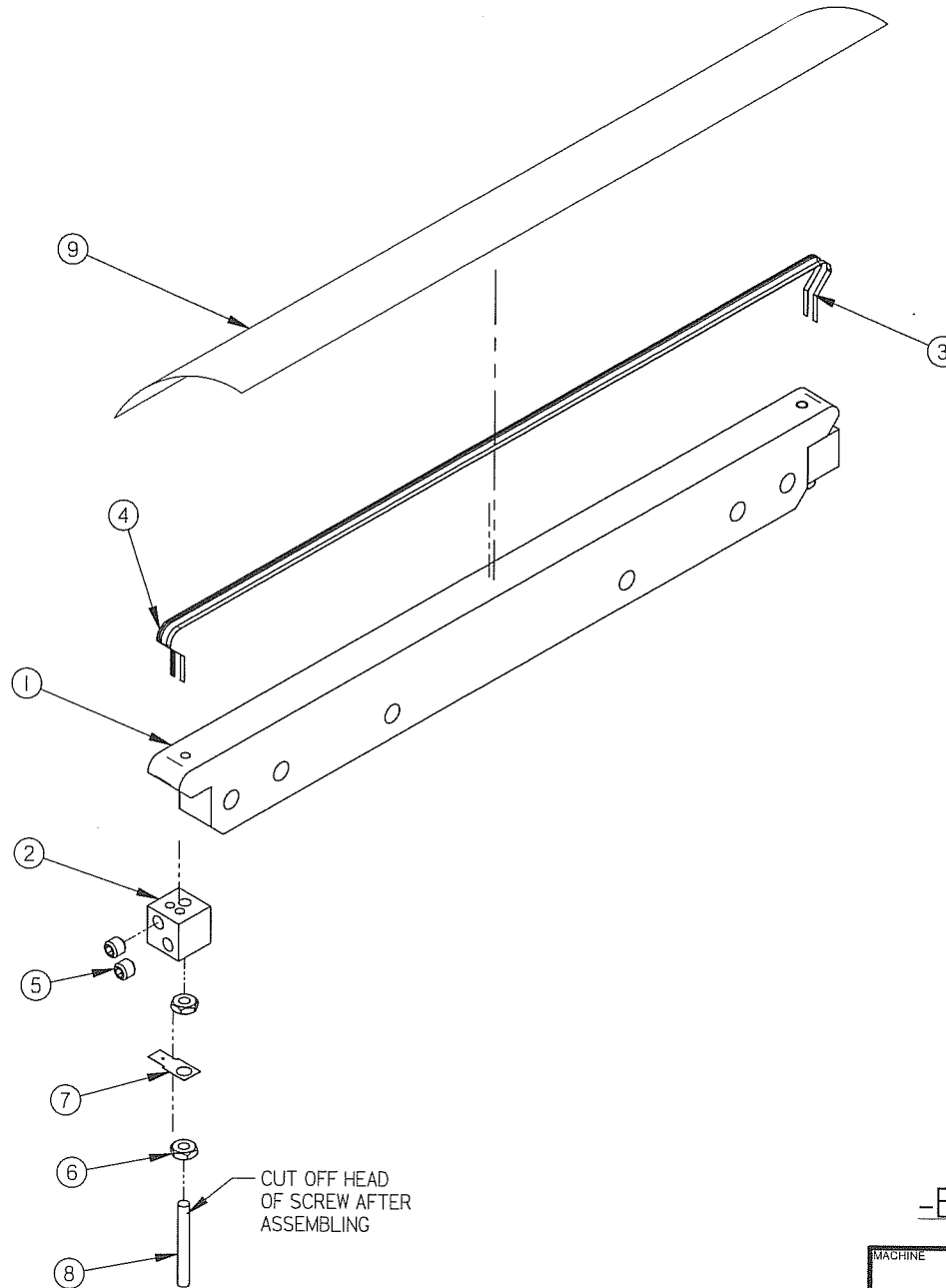
ITEM	PART #	DESCRIPTION	QT.
1	001-1829	SEAL BAR GUIDE SPACER	2
2	001A6812	SEAL BAR GUIDE	2
3	001B1737	SEAL BAR SUPPORT	1
4	002A4231	SEAL BAR SUPPORT (SHORT)	1
5	004A1333	SEAL BAR PRE- ASSY	1
6	008B0677	ESPACEUR DE SOUFFLET	1
7	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	4
8	051-0275	SCREW 1/4-20 X 2-1/4" FLAT SLOT S/S	3
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
10	051-0740	WASHER 1/4" FLAT S/S	4

LET.	MODIFICATION	DATE	INT.
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MACHINE		380T		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		SEAL BAR ASSEMBLY B.C.O.		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		3D DWG BY CF		DATE	12-04-19		N.T.S.
		2D DWG BY AG		DATE	23-09-14		
				DEPT.	M-1(M)		QTY. 2
							005C0967

004A1333

ITEM	PART #	DESCRIPTION	QT.
1	002A0433	SEAL BAR	1
2	002A1275	CONNECTOR	2
3	039-0230	REFLEX BANC 2.5mm (460mm) (0.48)	1
4	039-0270	"T" PROFILE CUT. ELEM. (460mm) (0.48)	1
5	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	4
6	051-0550	NUT #8-32 SS	4
7	027-0400	CONNECTOR ADAPTOR	2
8	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
9	176-0202	TEFLON TAPE .005"x1-1/2" ADHESIVE (330mm) (.042)	1



-BAG CUT OPTION-

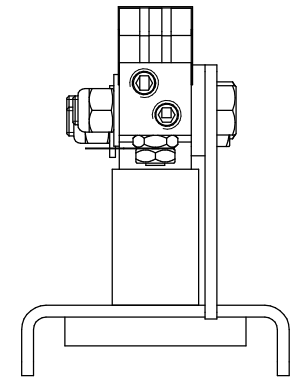
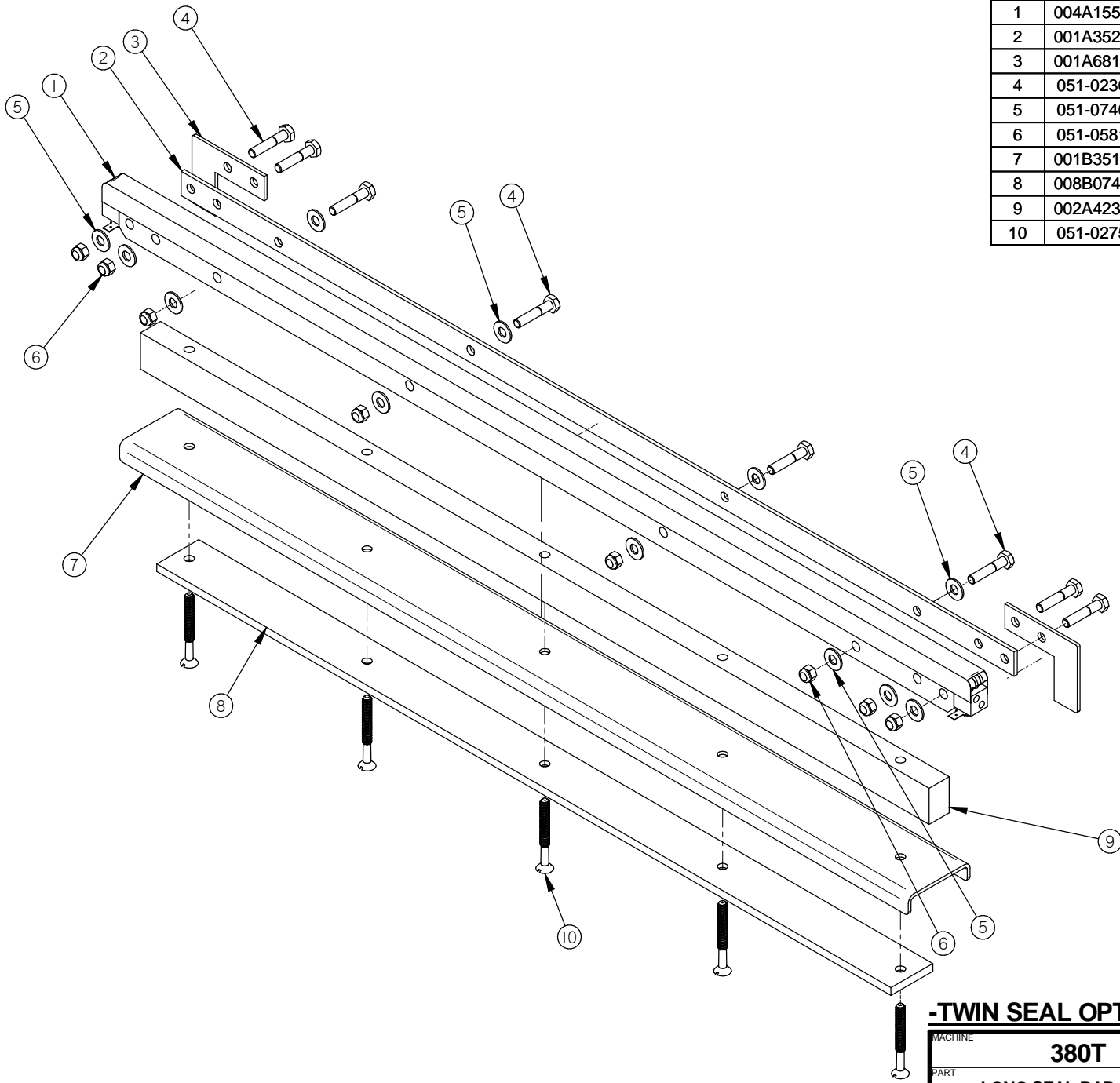
380T	2
380	2
MACHINE	QTY

MACHINE	380 & 380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	SEAL BAR PRE- ASS'Y		USINAGE ± 0.1	± 0.004"	
			TOLERIE ± 0.5	± 0.020"	
			SOUDAGE ± 0.5	± 0.020"	N.T.S.
ITEM	CNC	DEPT.	M	QTY	LISTE
MAT.	DWG BY M.A.L.	DATE 05-06-22	NO.	004A1333	
	APP. BY	DATE			

LET.	MODIFICATION	DATE	INT.
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005C0882

ITEM	PART #	DESCRIPTION	QT.
1	004A1558	LONG SEAL BAR PRE- ASS'Y	1
2	001A3521	LONG SEAL BAR REINFORCEMENT	1
3	001A6812	SEAL BAR GUIDE	2
4	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	8
5	051-0740	WASHER 1/4" FLAT S/S	12
6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
7	001B3519	LONG SEAL BAR SUPPORT	1
8	008B0749	LONG BELLOW SPACER	1
9	002A4235	SEAL BAR SUPPORT (LONG)	1
10	051-0275	SCREW 1/4-20 X 2-1/4" FLAT SLOT S/S	5



-END VIEW-

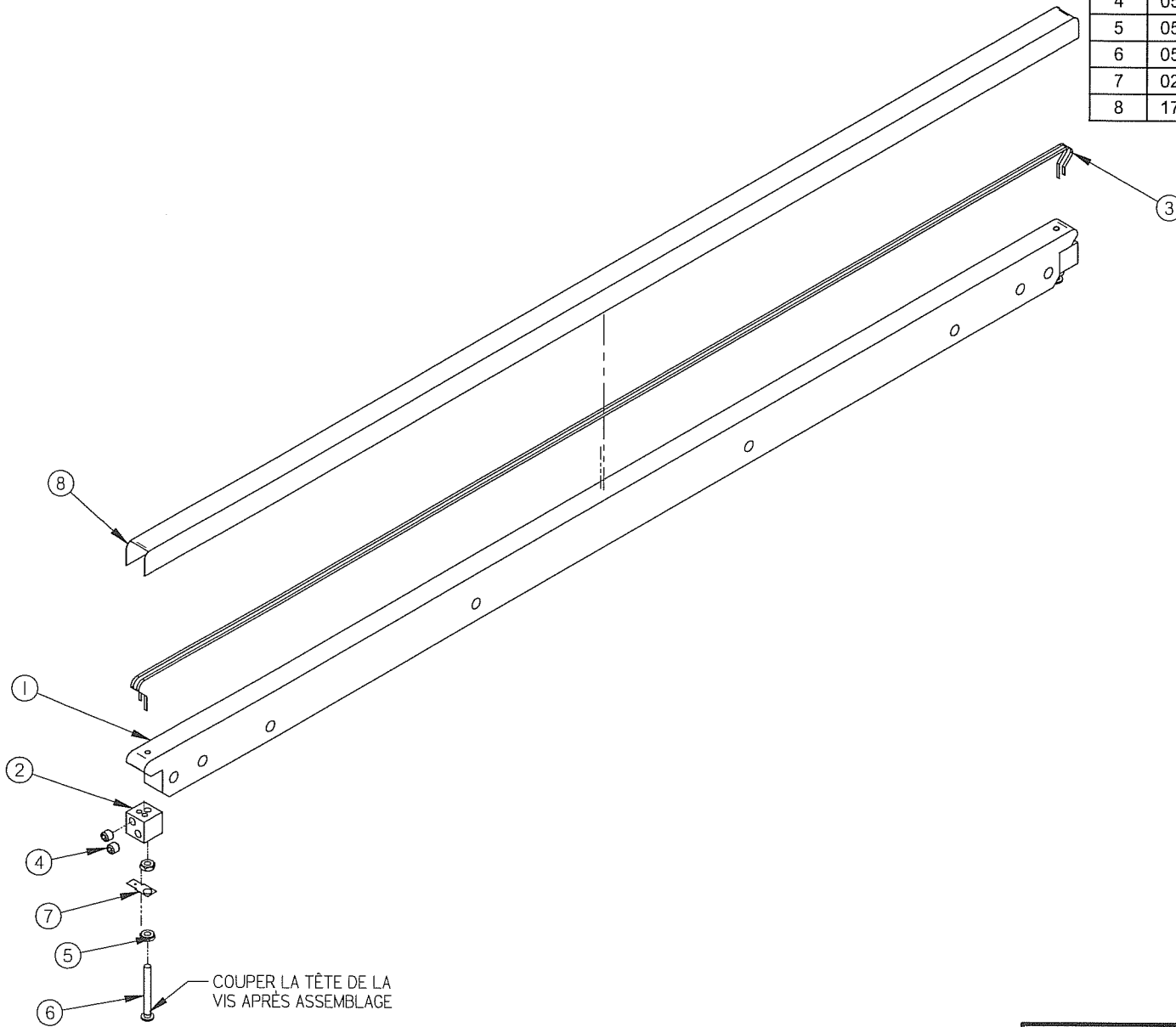
-TWIN SEAL OPTION-

LET.	MODIFICATION	DATE	INT.
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MACHINE	380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	LONG SEAL BAR ASSEMBLY		USINAGE ± 0.1	± 0.004"	
			TOLERIE ± 0.5	± 0.020"	
ITEM	CNC		SOUDAGE ± 0.5	± 0.020"	N.T.S.
MAT.	DWG BY SBU	DATE 14-08-06	APP. BY	DATE	DEPT. M QTY. 1
					005C0882

004A1558

ITEM	PART #	DESCRIPTION	QT.
1	002A1787	LONG SEAL BAR	1
2	002A1275	CONNECTOR	2
3	039-0200	SEALING ELEM. STD TWIN (2 x 3') (3.15)	2
4	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	4
5	051-0550	NUT #8-32 SS	4
6	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
7	027-0400	CONNECTOR ADAPTOR	2
8	176-0202	TEFLON TAPE .005"x1-1/2" ADHESIVE (.1056)	1



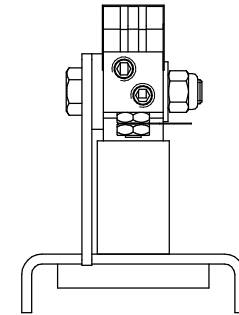
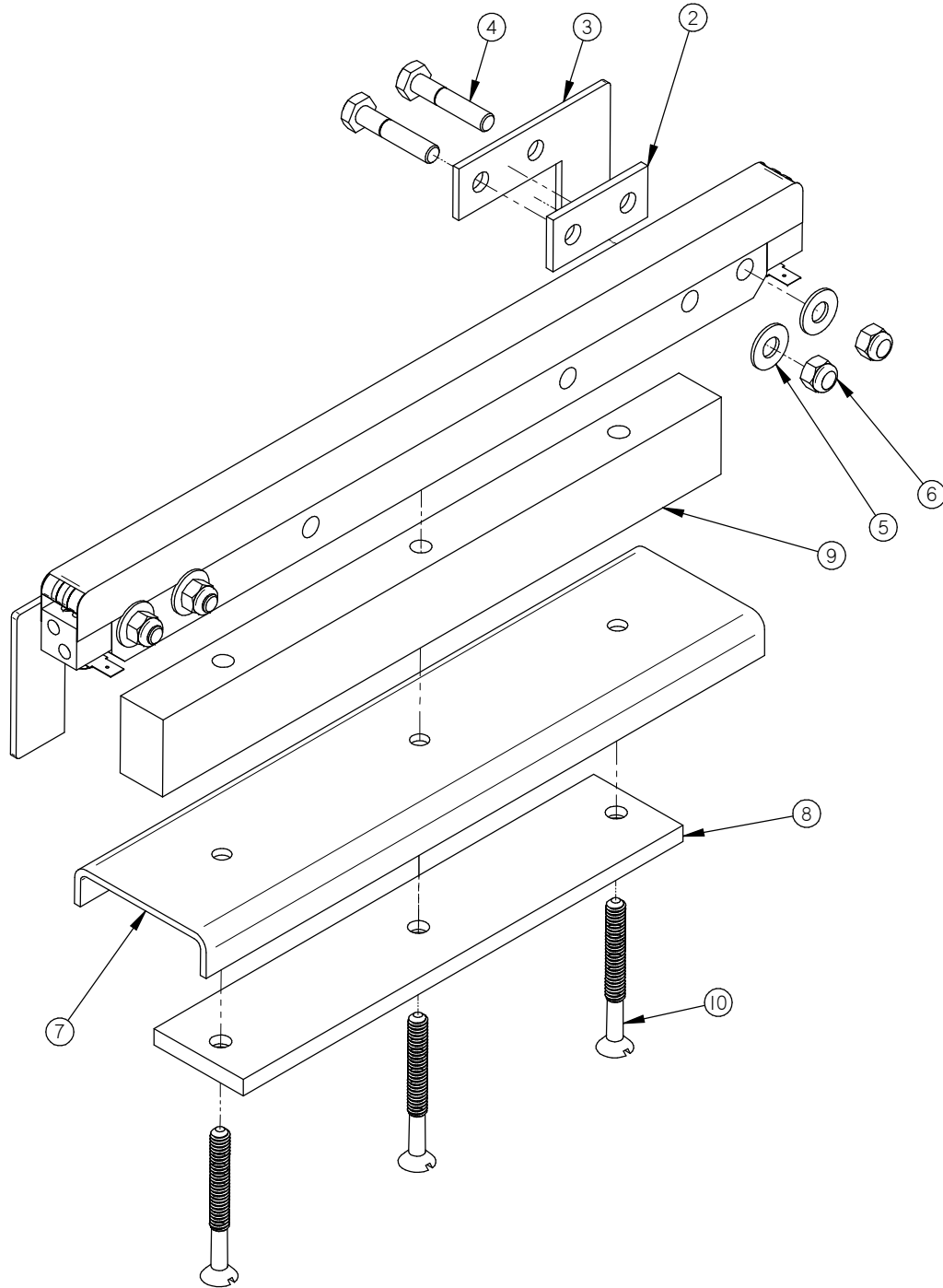
COUPER LA TÊTE DE LA VIS APRÈS ASSEMBLAGE

MACHINE		380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		LONG SEAL BAR PRE- ASS'Y		USINAGE ± 0.1 ± 0.004"	TOLERIE ± 0.5 ± 0.020"	
				SOUDAGE ± 0.5 ± 0.020"	N.T.S.	
ITEM	CNC	DEPT.	M-I	QTY.	1	
MAT.	DWG BY B.C.	DATE 04-05-06	NO.	004A1558		
	APP. BY	DATE 05-06-29				

A	MODIFIED VIEW ITEM #1	05-05-20	M.A.
LET.	MODIFICATION	DATE	INT.

005C0803

ITEM	PART #	DESCRIPTION	QT.
1	004A1218	SEAL BAR PRE- ASS'Y	1
2	001-1829	SEAL BAR GUIDE SPACER	2
3	001A6812	SEAL BAR GUIDE	2
4	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	4
5	051-0740	WASHER 1/4" FLAT S/S	4
6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
7	001B1737	SEAL BAR SUPPORT	1
8	008B0677	ESPACEUR DE SOUFFLET	1
9	002A4231	SEAL BAR SUPPORT (SHORT)	1
10	051-0275	SCREW 1/4-20 X 2-1/4" FLAT SLOT S/S	3



-END VIEW-

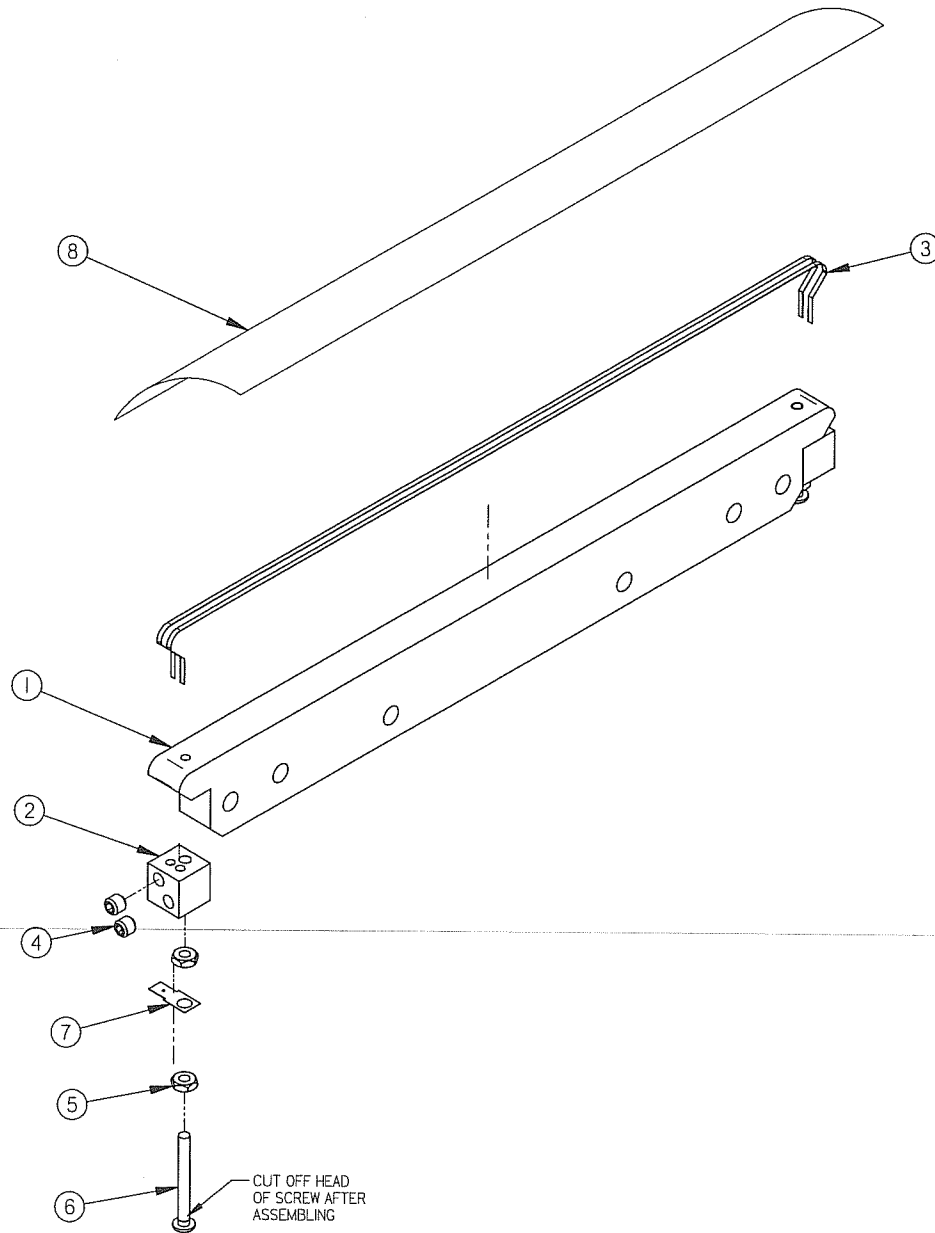
-TWIN SEAL OPTION-

MACHINE		380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		SEAL BAR ASSEMBLY		USINAGE ± 0.1	± 0.004"	
ITEM		CNC		TOLERIE ± 0.5	± 0.020"	
MAT.		APP. BY		SBU	DATE	14-08-06
DATE		DATE		NO.		2
MODIFICATION		DATE		INT.		005C0803

LET.	MODIFICATION	DATE	INT.
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004A1218

ITEM	PART #	DESCRIPTION	QT.
1	002A0433	SEAL BAR	1
2	002A1275	CONNECTOR	2
3	039-0200	SEALING ELEM. STD TWIN (2x460mm) (3.02)	2
4	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	4
5	051-0550	NUT #8-32 SS	4
6	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
7	027-0400	CONNECTOR ADAPTOR	2
8	176-0202	TEFLON TAPE .005"x1-1/2" ADHESIVE (330mm) (.042)	1



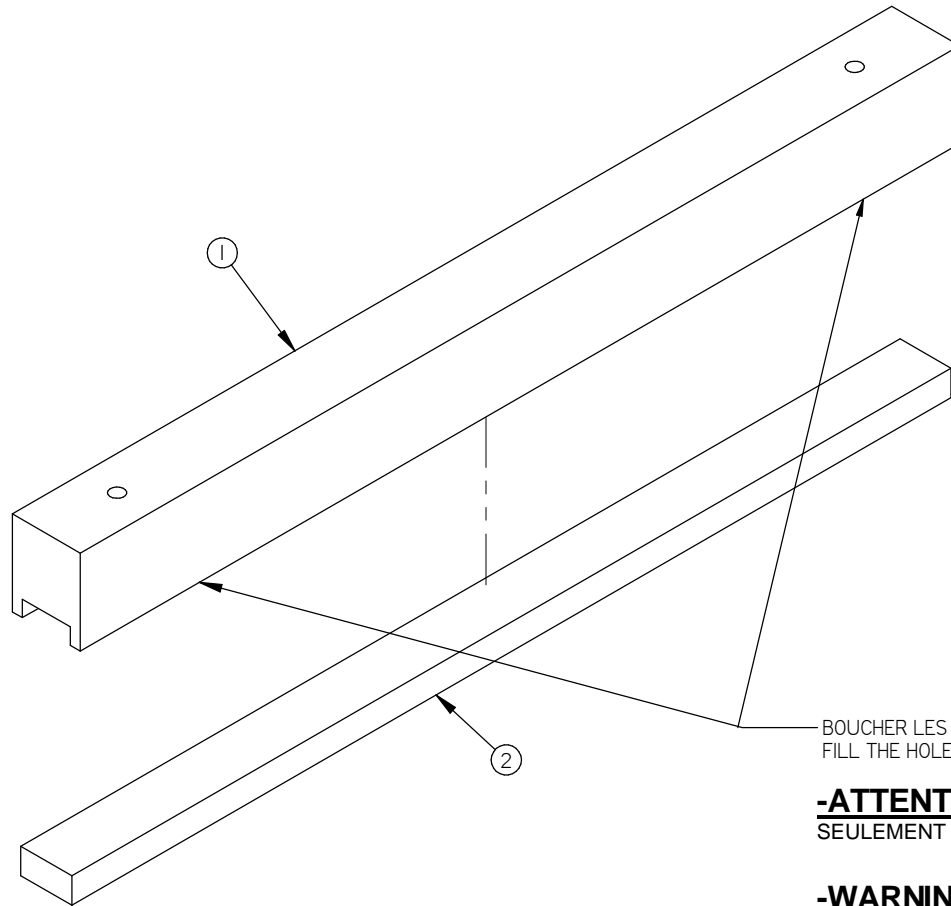
380T	2
380	2
MACHINE	QTY

MACHINE		380 & 380T		DEPT. TOL	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		SEAL BAR PRE- ASS'Y		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
ITEM		CNC		SOUDEGE	± 0.5	± 0.020"	MACHINE QTY
MAT.		DWG BY Y.C.		N.T.S.			
		DATE 03-02-18		DATE 05-06-22		NO. 004A1218	

B	MODIFIED VIEW ITEM #1, ADDED 380T	05-05-24	M.A.
A	MODIFICATION #A-0398 (CONNECTEUR)	04-04-19	J.G.
LET.	MODIFICATION	DATE	INT.

004A0308

ITEM	PART #	DESCRIPTION	QT.
1	002A0436	UPPER SEAL BAR SUPPORT	1
2	008-0435	UPPER SEAL BAR RUBBER	1



BOUCHER LES TROUS AVEC SILICONE (I69-0200)
 FILL THE HOLES WITH SILICONE (I69-0200)

-ATTENTION -: BOUCHER EN SURFACE
 SEULEMENT POUR NE PAS NUIRE AU BOULONNAGE

-WARNING -: FILL ONLY ON THE SURFACE, SO
 IT WILL NOT OBSTRUCT THE BOLTING

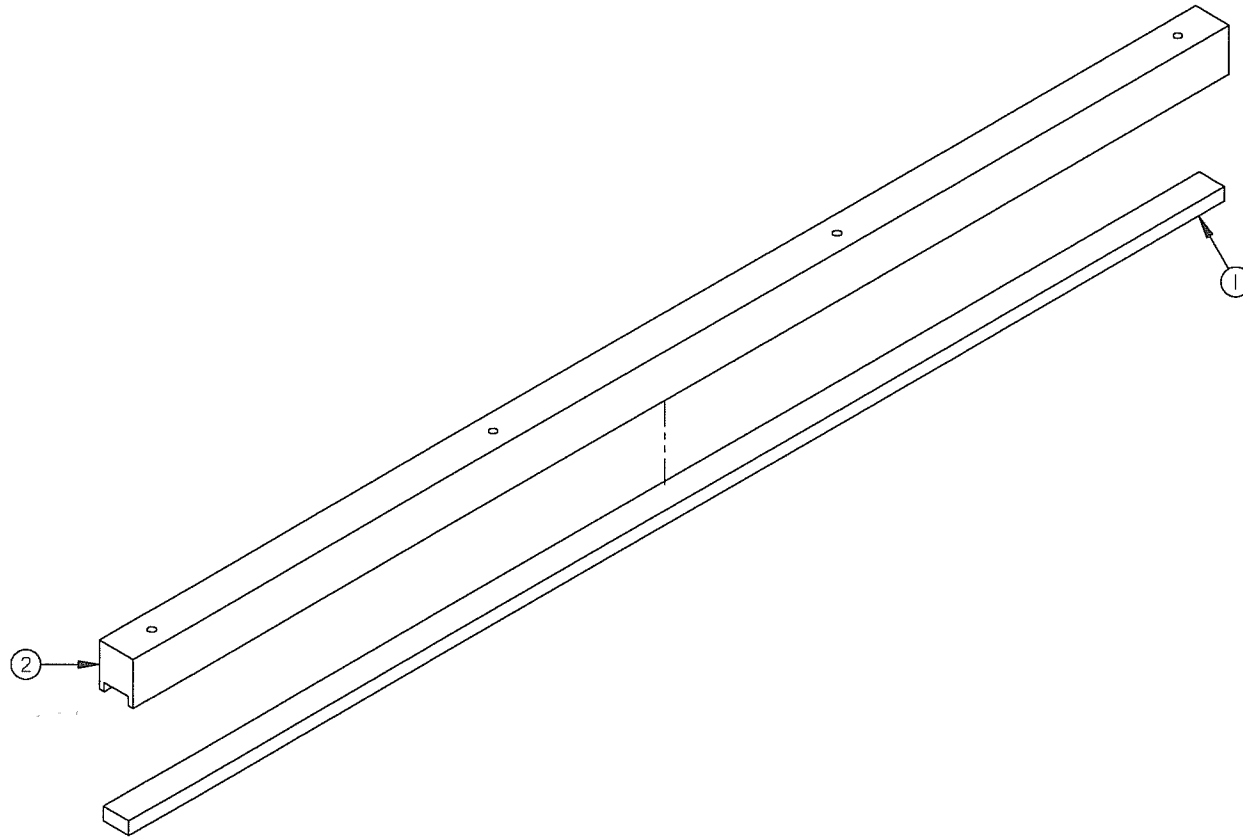
380T	2
380	2
250	1
MACHINE	QTY

MACHINE	250 , 380 & 380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	UPPER SEAL BAR PRE-ASS'Y		USINAGE ± 0.1	± 0.004"	
ITEM	CNC	DEPT.	TOLERIE ± 0.5	± 0.020"	
MAT.	DWG BY CF		DATE 12-03-26	NO.	004A0308
LET.	APP. BY		DATE	M LIST	

D	REDESSINER SE	12-04-02	CF
LET.	MODIFICATION	DATE	INT.

004A1559

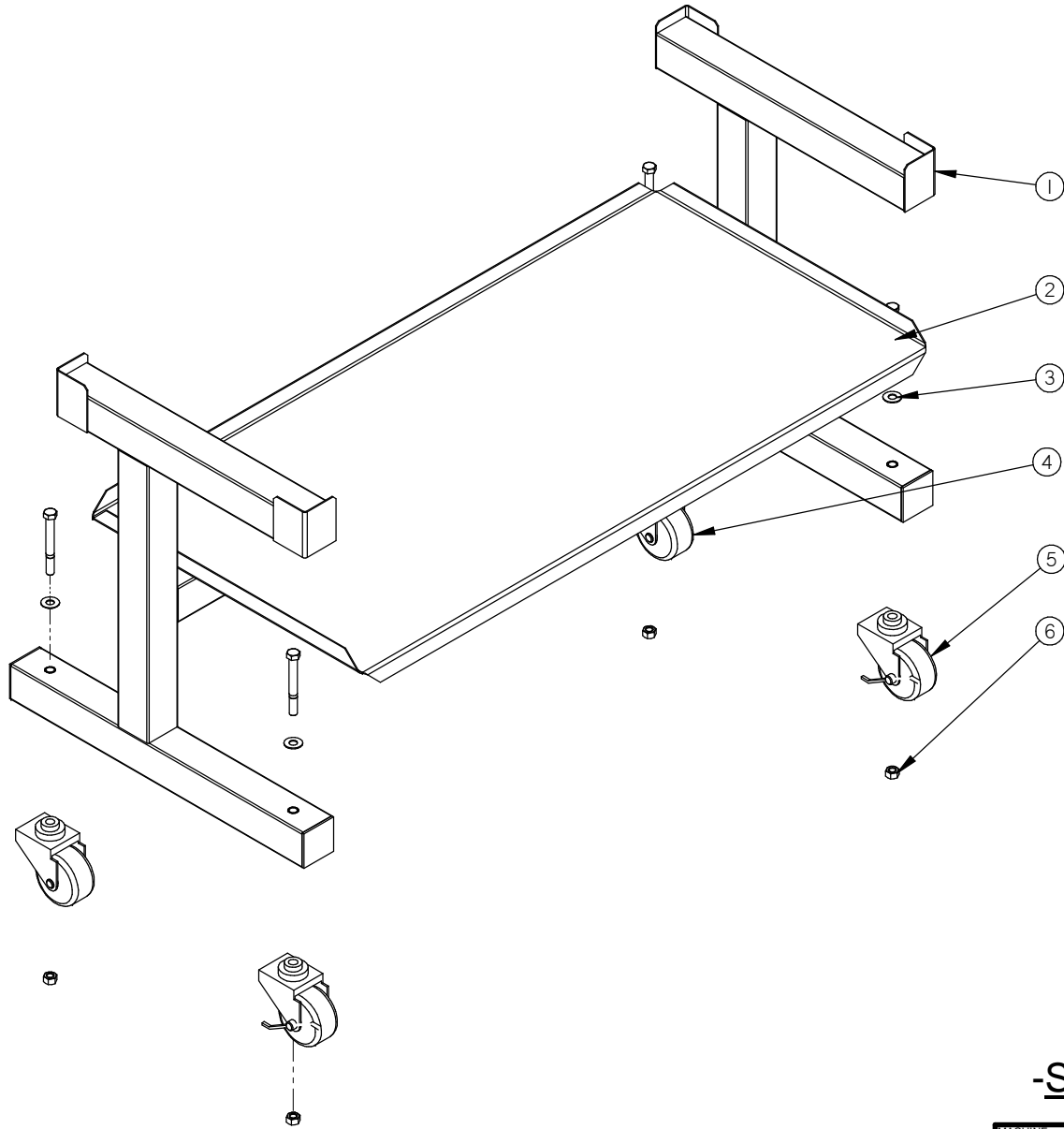
ITEM	PART #	DESCRIPTION	QT.
1	008A0750	UPPER SEAL BAR RUBBER	1
2	002A1788	LONG UPPER SEAL BAR	1



MACHINE	380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	LONG UPPER SEAL BAR PRE-ASS'Y		USINAGE ± 0.1 ± 0.004"		
ITEM	CNC	DATE	TOLERIE ± 0.5 ± 0.020"	N.T.S.	
MAT.	APP. BY	DATE	SOUDAGE ± 0.5 ± 0.020"		
LET.	MODIFICATION	DATE	INT.	DEPT.	QT.
				M	1
					004A1559

005B0972

ITEM	PART #	DESCRIPTION	QT.
1	004B3994	STAND SHELF PRE-ASSY	1
2	051-0422	BOLT 3/8"-16nc. X 3/4" S/S	4
3	051-0780	WASHER 3/8" FLAT S/S	4
4	130-0190	PL. CASTER SWIVEL W/OUT BRAKE	2
5	130-0195	PL. CASTER SWIVEL W/BRAKE	2
6	051-0620	NUT 3/8"-16 NC S/S	4



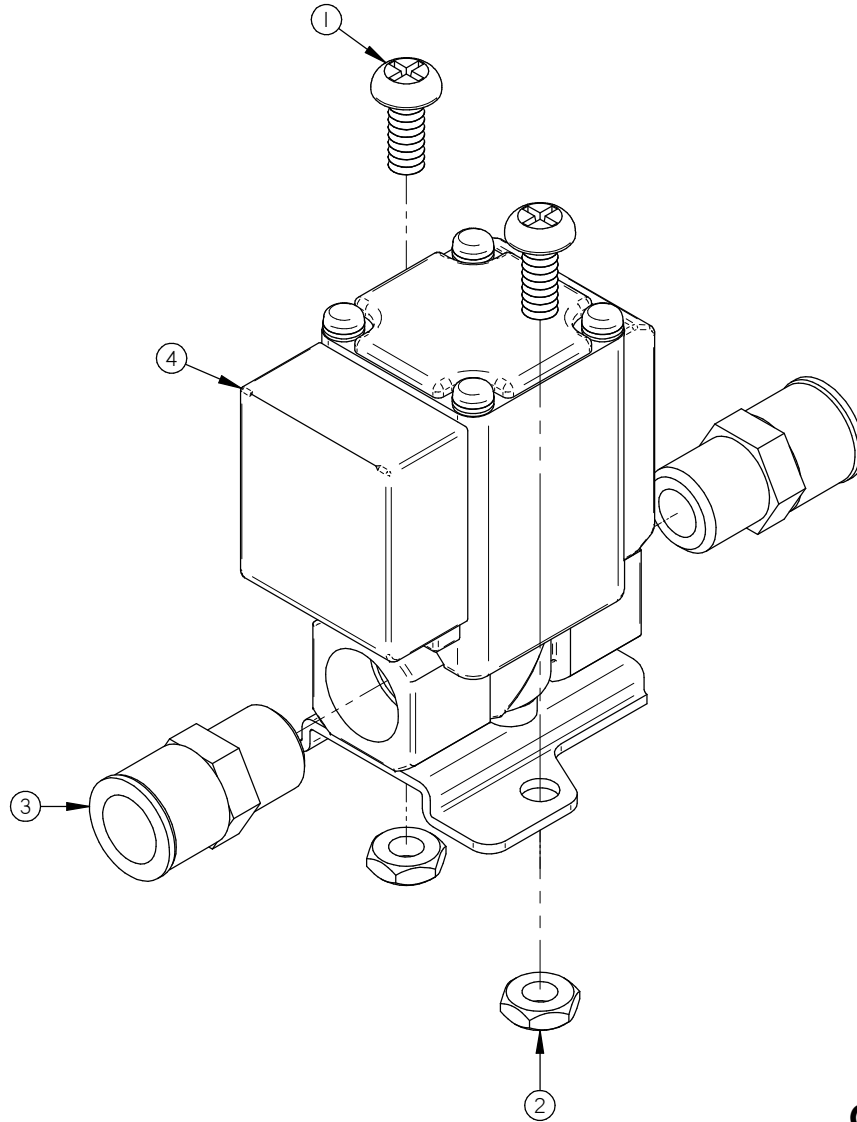
-STAND OPTION-

LET.	MODIFICATION	DATE	INT.
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MACHINE	380 & 380T	DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	STAND ASSEMBLY	USINAGE ± 0.1 ± 0.004"	TOLERIE ± 0.5 ± 0.020"	
		SOUDEAGE ± 0.5 ± 0.020"	N.T.S.	
ITEM	CNC	DEPT.	M	QTY. 1
MAT.	DWG BY AG	DATE 14-08-04	NO. 005B0972	
	APP. BY	DATE		

005A1529

ITEM	PART #	DESCRIPTION	QT.
1	051-0144	SCREW #10-24 N.C 1/2" PAN PHIL. S/S	2
2	051-0571	NUT #10-24 S/S	2
3	102-0410	MALE CONN. 1/4" MNPT x 3/8" T. QUICK	2
4	106-0010	VALVE 2WAY N.C. 24VAC 1/4" NPT (SMC)	1



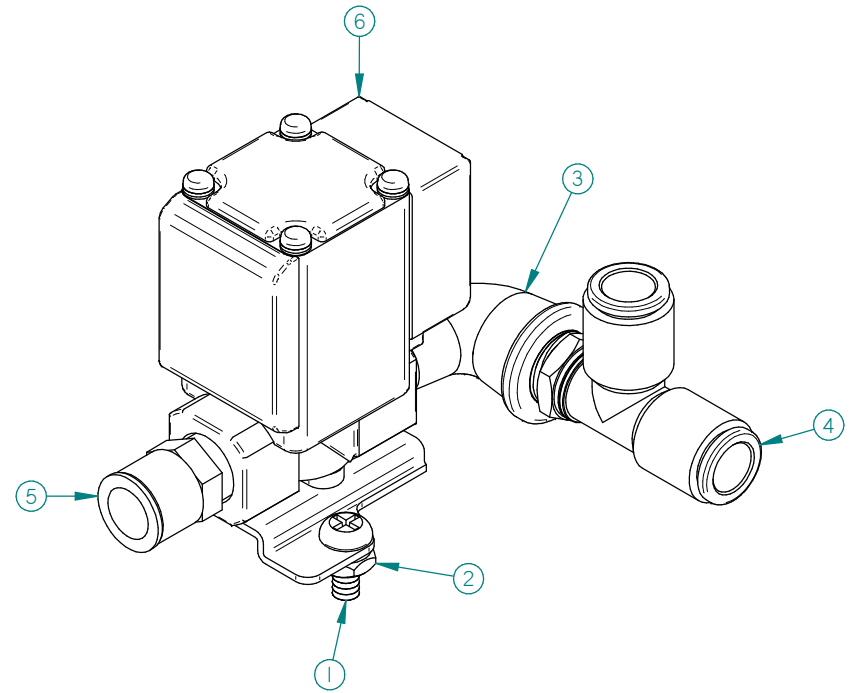
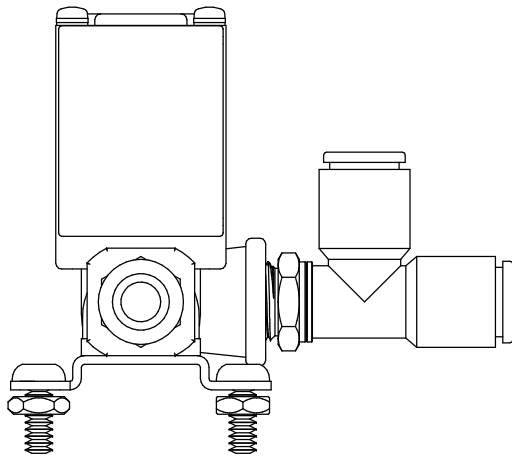
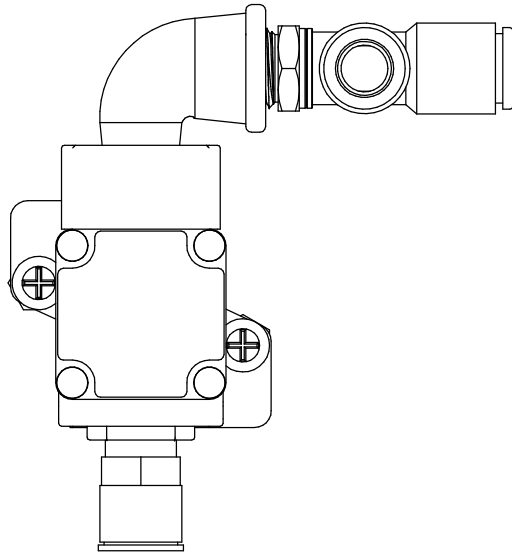
GAS OPTION

MACHINE		VACCUM		DEPT. TOL.	METRIC	INCH	SIPROMAC				
PART		GAS VALVE ASSY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM				
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA				
MAT.		3D DWG BY AG		SOUDEGE	± 0.5	± 0.020"	NO. 005A1529				
LET.		MODIFICATION		DATE		INT.		DEPT.	M	QTY.	1
				DATE		DATE					
				23-09-14		23-09-14					
				AG		AG					

LET.	MODIFICATION	DATE	INT.
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005A1497

ITEM	PART #	DESCRIPTION	QT.
1	051-0144	SCREW #10-24 N.C 1/2" PAN PHIL. S/S	2
2	051-0571	NUT #10-24 S/S	2
3	100-0065	STREET ELBOW 1/4" NPT SS	1
4	102-0345	BRANCH TEE 1/4" MNPT X 3/8" T.QUICK	1
5	102-0410	MALE CONN. 1/4" MNPTx3/8" T.QUICK	1
6	106-0010	VALVE 2WAY N.C. 24VAC 1/4" NPT(SMC)	1

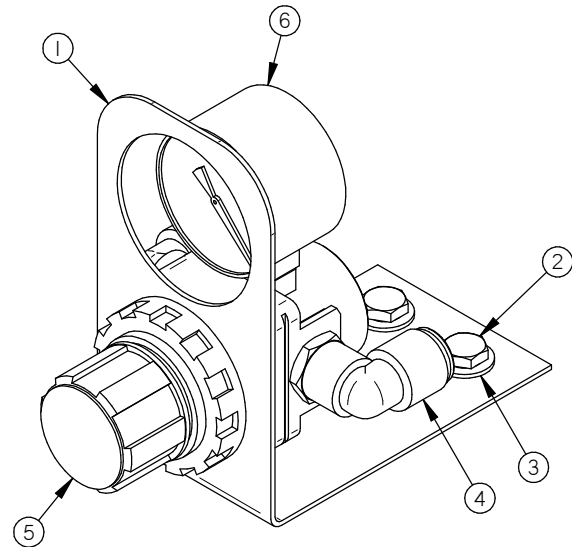
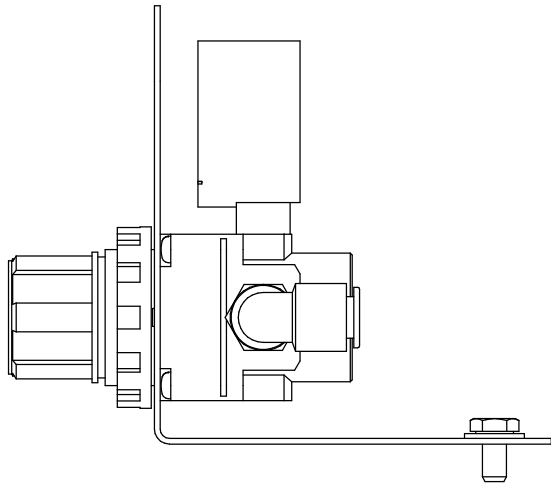
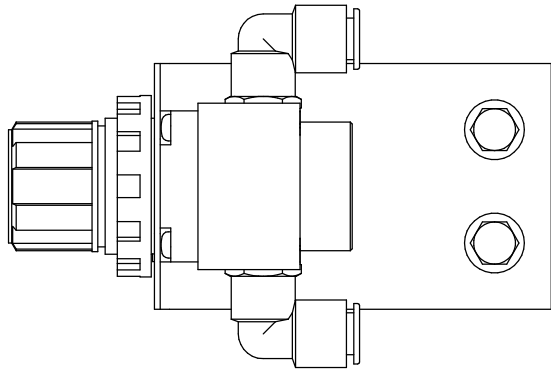


LET.	MODIFICATION	DATE	INT.
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MACHINE		VACCUM		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		GAS VALVE ASSY		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
				SOUDEAGE	± 0.5	± 0.020"	N.T.S.
ITEM		CNC		DEPT.	M		QTY. 1
MAT.		DWG BY	SBU (A.G)	DATE	14-06-10		NO. 005A1497
		APP. BY		DATE			

005A1496

ITEM	PART #	DESCRIPTION	QT.
1	001A6811	AIR REGULATOR SUPPORT	1
2	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	2
3	051-0740	WASHER 1/4" FLAT S/S	2
4	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	2
5	114-01501	PRESSURE REGUL.0-100 PSI 1/4" NPT W/ NUT	1
6	114-0236	PRESSURE GAUGE 30 PSI 1/8" NPT BOTTOM	1



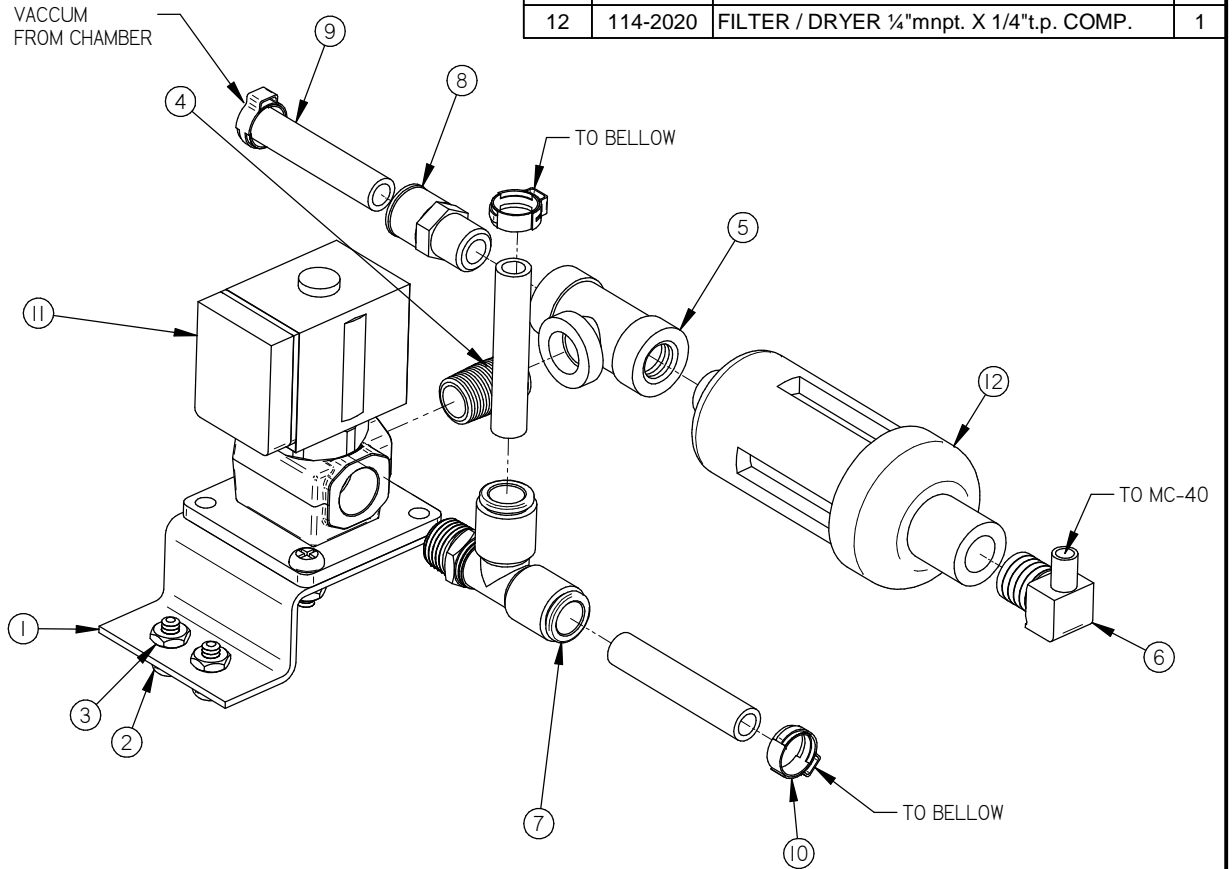
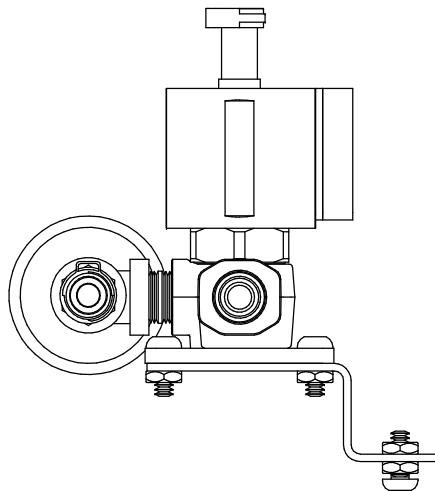
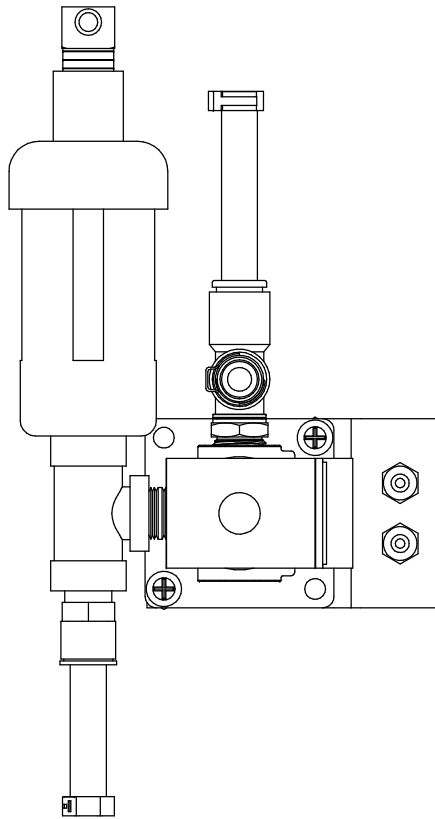
-AIR REGULATOR OPTION -

MACHINE		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
TABLE TOP VACUUM		USINAGE	± 0.1	± 0.004"	
PART		TOLERIE	± 0.5	± 0.020"	
AIR REGULATOR VALVE ASSY		SOUDEAGE	± 0.5	± 0.020"	N.T.S.
ITEM	CNC	DEPT.	M	QTY.	1
MAT.	DWG BY SBU (A.G)	DATE	14-06-09	NO.	005A1496
	APP. BY	DATE			

LET.	MODIFICATION	DATE	INT.
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005A1495

ITEM	PART #	DESCRIPTION	QT.
1	001A0564	VALVE SUPPORT	1
2	051-0144	SCREW #10-24 N.C 1/2" PAN PHIL. S/S	4
3	051-0571	NUT #10-24 S/S	6
4	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
5	100-0463	TEE 1/4" NPT S/S	1
6	101-0170	ELBOW 90° 1/4 MNPT x 1/4" HOSE	1
7	102-0345	BRANCH TEE 1/4" MNPT X 3/8" T.QUICK	1
8	102-0410	MALE CONN. 1/4" MNPT x 3/8" T.QUICK	1
9	104-0060	TUBE 3/8" OD x 1/4" ID POLYETHYL.	3
10	105-0218	EAR CLAMP 3/8" S/S	3
11	106-00701	VALVE 3WAY 24V 1/4" NPT	1
12	114-2020	FILTER / DRYER 1/4" mnpt. X 1/4" t.p. COMP.	1

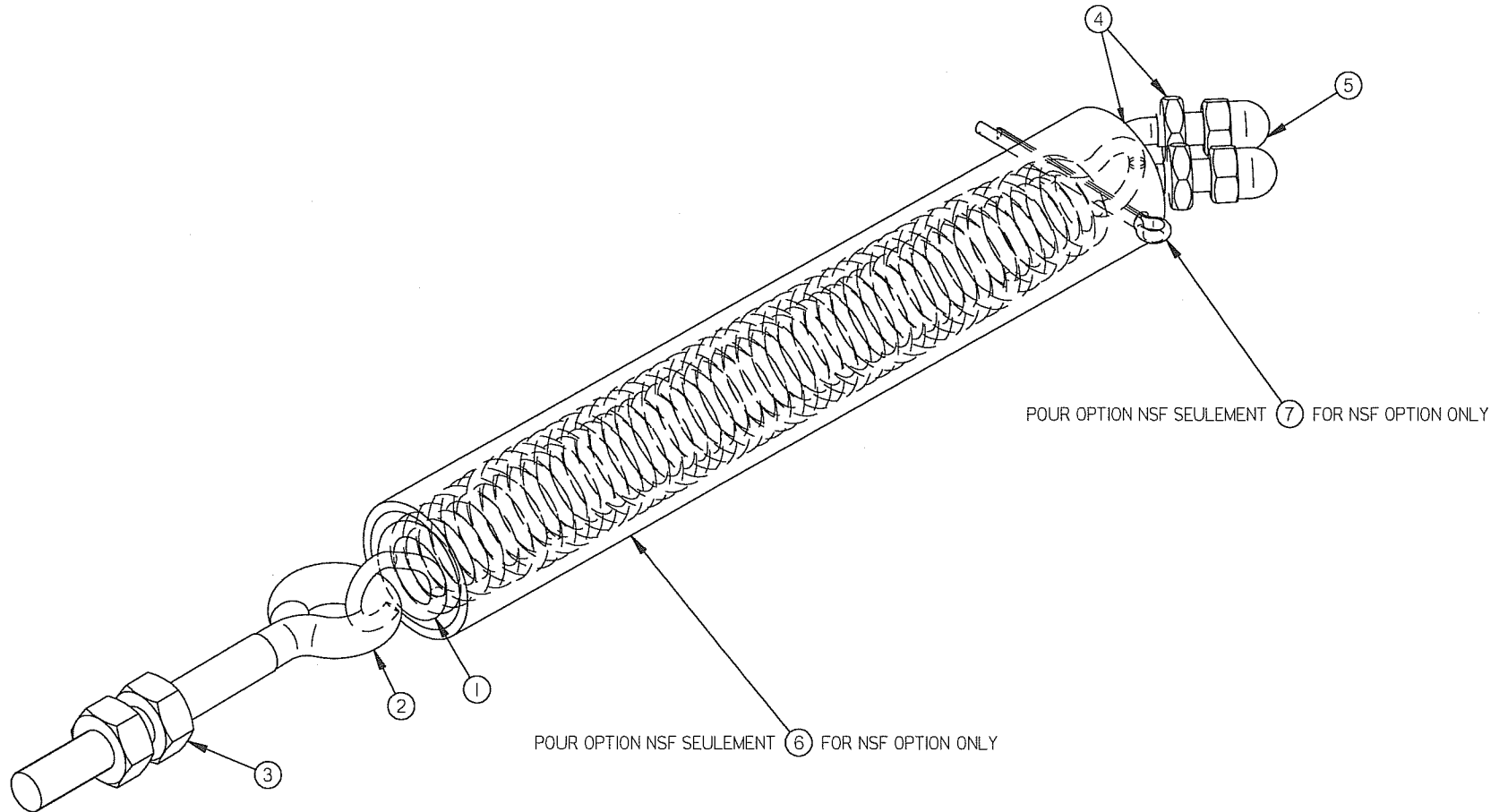


LET.	MODIFICATION	DATE	INT.
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MACHINE		380 & 380T		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		BELLOWS VALVE ASSY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SBU (A.G)	DATE	13-11-14	N.T.S.
							DEPT. M
							NO. 005A1495
							QTY. 1

004A1225

ITEM	PART #	DESCRIPTION	QT.
1	009A0151	SPRING GRAY	1
2	056-0150	EYE BOLT 1/4"-20 x 3" ZINC	1
3	051-0580	NUT 1/4"-20 S/S	2
4	056-2500	U-BOLT CABLE CLAMP THRD #10-24	1
5	051-0570	NUT #10-24 ACORN SS	2
6	008A1603	SPRING PROTECTION TUBE	1
7	056-0118	COTTER PIN 3/32" x 1" S/S	1



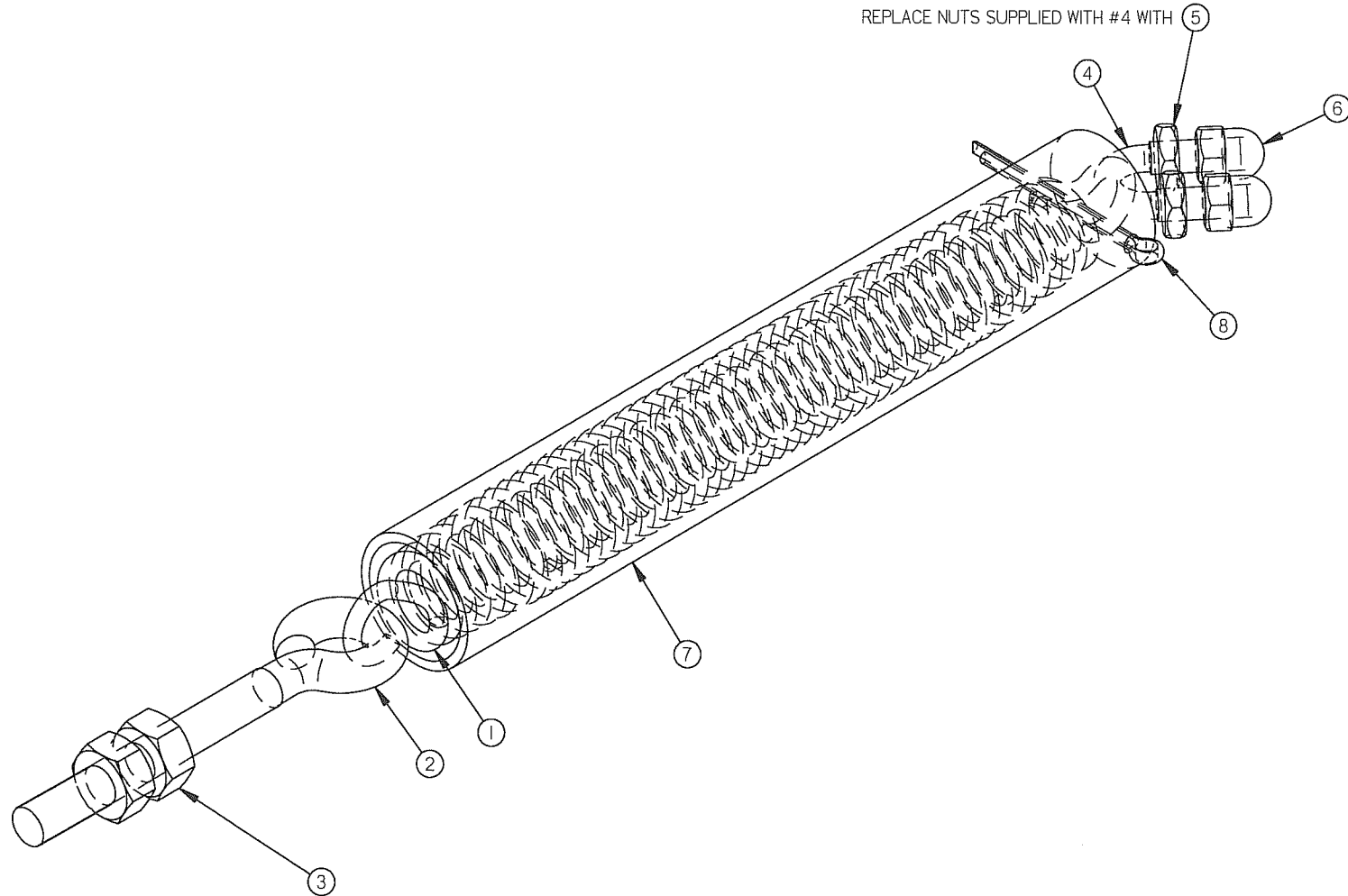
E	AJOUTER ITEM 008A1603 & 056-0118 (NSF)	10-11-09	J.G.
D	ADDED ITEM #3 051-0580 QTY : 2	05-05-05	M.A.
C	ADDED 380T	05-02-17	M.A.
B	009A0151 WAS 004A1225	04-12-07	M.A.
A	MODIFIER QUANTITE DANS 380 (4>2)	03-09-04	J.P.
LET.	MODIFICATION	DATE	INT.

MACHINE	250 & 380		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	SPRING PRE-ASSEMBLY		USINAGE ± 0.1	± 0.004"	
			TOLERIE ± 0.5	± 0.020"	
			SOUDAGE ± 0.5	± 0.020"	N.T.S.
ITEM	CNC	DATE	03-02-17	DEPT.	M-(M) QTY. 2
MAT.	DWG BY L.T.	DATE	03-02-17	NO.	004A1225
	APP BY	DATE	02-11-11		

004A1224

ITEM	PART #	DESCRIPTION	QT.
1	009A0152	SPRING BLACK	1
2	056-0150	EYE BOLT 1/4"-20 x 3" ZINC	1
3	051-0580	NUT 1/4"-20 S/S	2
4	056-2500	U-BOLT CABLE CLAMP THRD #10-24	1
5	051-0571	NUT #10-24 S/S	2
6	051-0570	NUT #10-24 ACORN SS	2
7	008A1603	SPRING PROTECTION TUBE	1
8	056-0118	COTTER PIN 3/32" x 1" S/S	1

REPLACE NUTS SUPPLIED WITH #4 WITH 5



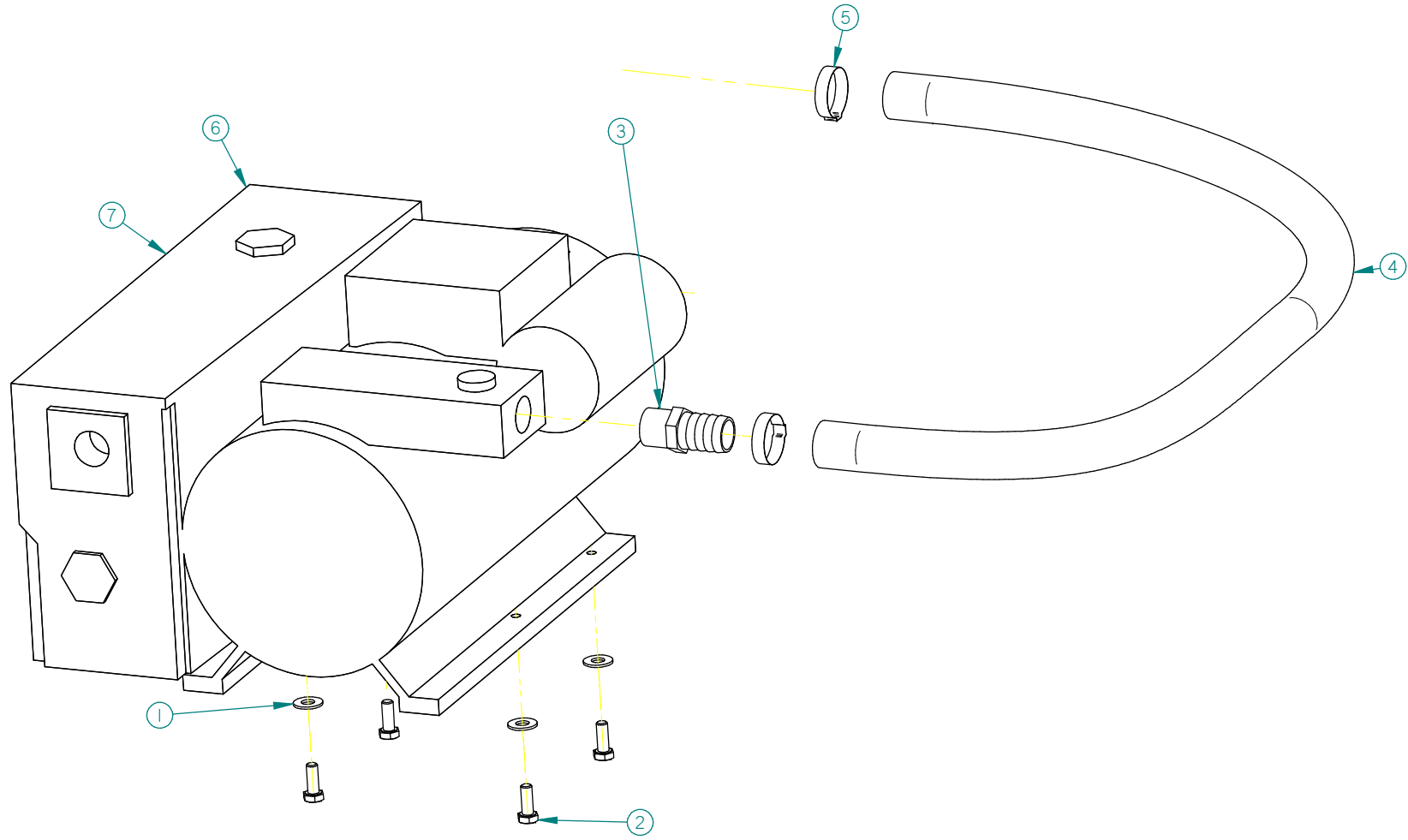
380T	4
380	2
350D	2
350	2
300D	2
300	2
MACHINE	QTY

F	REPLACE NUT SUPPLIED W/ #4 BY 051-0571	12-04-04	CF
E	AJOUTER ITEM 008A1603 & 056-0118 (NSF)	10-11-09	J.G.
D	ADDED ITEM #3 051-0580 QTY : 2	05-05-05	M.A.
C	ADDED 380T	05-02-03	M.A.
B	009A0152 WAS 077-0002	04-12-07	M.A.
A	AJOUTER 380 DANS CARTOUCHE	03-09-04	J.P.
LET.	MODIFICATION	DATE	INT.

MACHINE	DEPT	TOL	METRIC	INCH	NO
300,300D, 350, 350D 380 & 380T		USINAGE ± 0.1	± 0.004"		
		TOLERIE ± 0.5	± 0.020"		
		SOUDAGE ± 0.5	± 0.020"		
PART	N.T.S.				
SPRING PRE-ASSEMBLY					
ITEM	CNC	DEPT.	M-(M)	QTY	LISTE
MAT.	DWG BY LT.	DATE 03-02-17			
	APP. BY	DATE 12-04-18			
					004A1224

004-0346

ITEM	PART #	DESCRIPTION	QT.
1	051-0740	WASHER 1/4" FLAT S/S	4
2	051-0950	BOLT M6 x 16 S/S	4
3	100-1205	STRAIGHT 1/2"MNPTx3/4" HOSE BARB S/S	1
4	104-0106	HOSE	1
5	105-0238	EAR CLAMP 23.9-27.1 SS	2
6	125-1020	BUSCH KB-0020 115V/1PH/60HZ	1
7	125-1021	BUSCH KB-0020 220-240V/1PH/50-60HZ	1

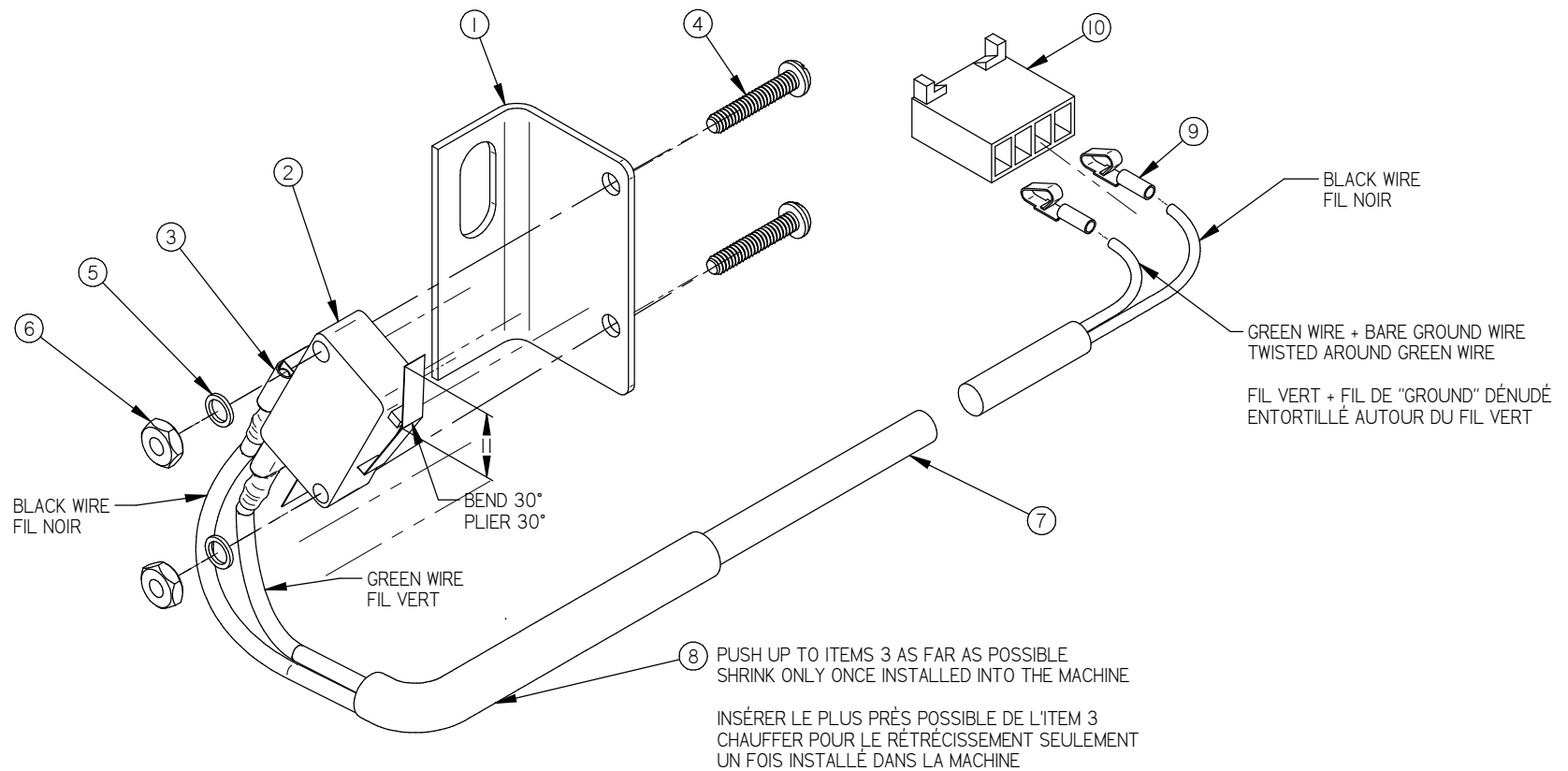


B	HOSE ADDED	14-06-10	A.G.
A	ADDED 380T	06-01-26	M.A.
LET.	MODIFICATION	DATE	INT.

MACHINE 350, 350D, 380 & 380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART "BUSCH" PUMP INSTALATION		USINAGE ± 0.1 ± 0.004"	TOLERIE ± 0.5 ± 0.020"	
		SOUDEAGE ± 0.5 ± 0.020"	N.T.S.	
ITEM	CNC	DEPT.	M	QTY. 1
MAT.	DWG BY: E.T. (A.G)	DATE: 02-03-11	NO. 004-0346	
	APP. BY	DATE		

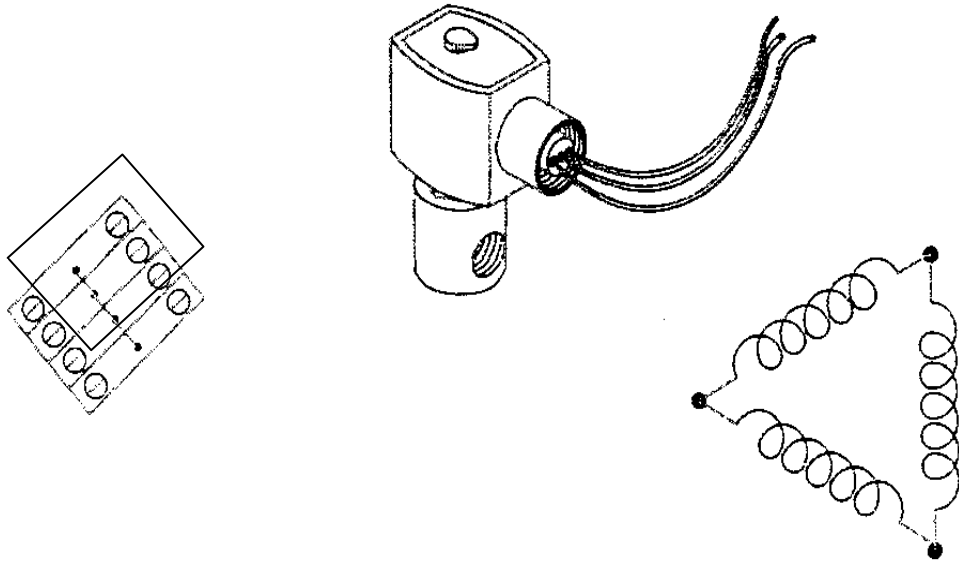
004-0261

ITEM	PART #	DESCRIPTION	QT.
1	001-0944	SWITCH SUPPORT	1
2	026-0590	LIMIT SWITCH LONG ARM	1
3	027-0030	TERMINAL FEMALE 0.187" INSULATE	2
4	051-0080	SCREW 4-40 x 5/8" RND SLOT SS	2
5	051-0715	WASHER #4 LOCK SS	2
6	051-0540	NUT #4-40 HEX S/S	2
7	030-0631	22AWG/4COND.PVC,SHIELDED,300V. (1.7M)	1
8	030-0711	SHRINK 3/8" BLACK 6" (0.52')	1
9	036-0850.	0.156" CENTERLINE CRIMP TERMINAL	2
10	036-0820	0.156" CENTERLINE CRIMP HOUSING	1



MACHINE 250, 350, 350D, 380, 380T		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART LIMIT SWITCH ASS'Y		USINAGE ± 0.1	± 0.004"	
		TOLERIE ± 0.5	± 0.020"	
		SOUDAGE ± 0.5	± 0.020"	
ITEM	CNC	DEPT.	M	QTY. 1
MAT.	DWG BY CF	DATE 12-03-26	NO. 004-0261	
	APP. BY	DATE		

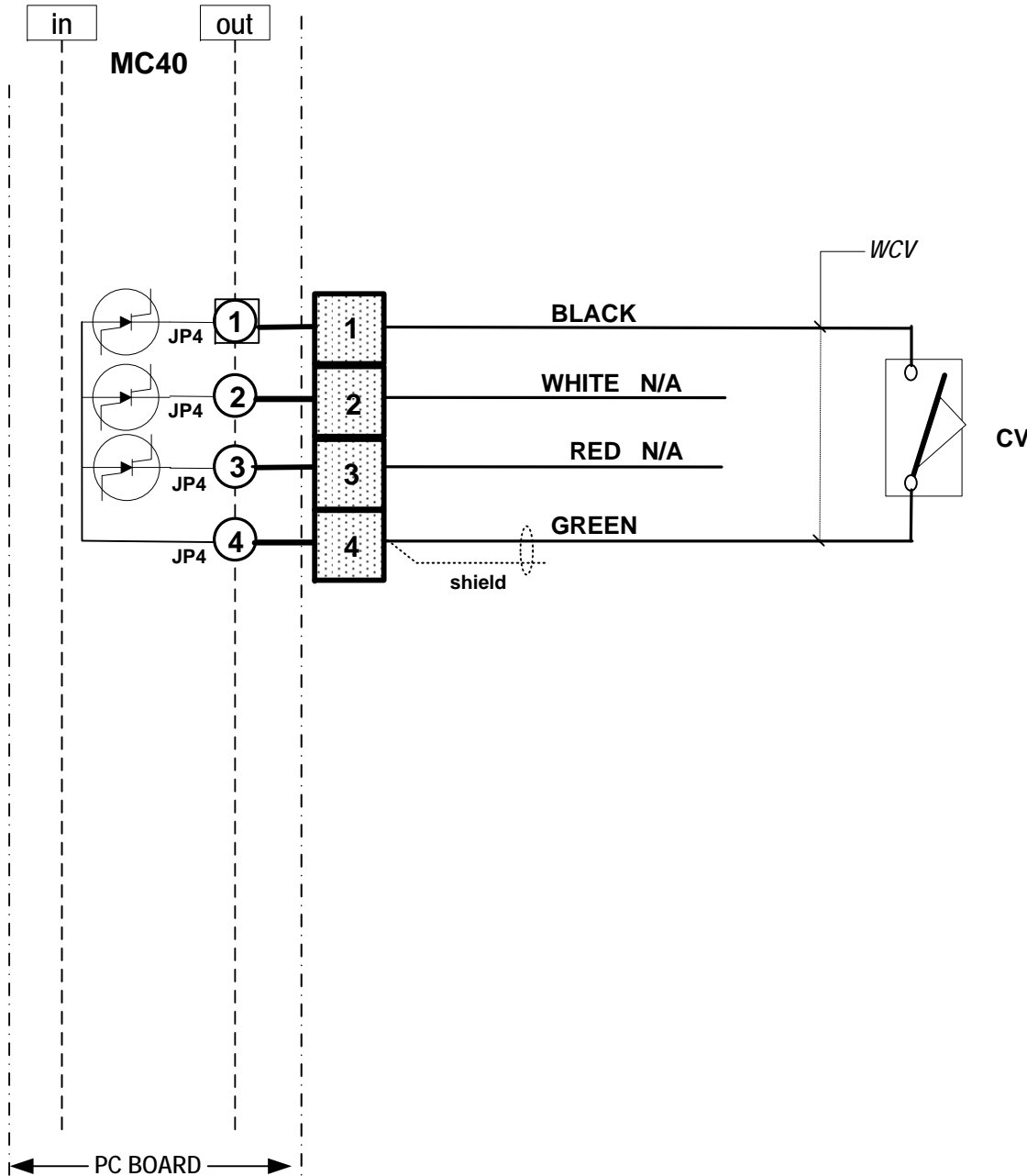
H	REDRAWN SE & LISTED ELECT. PART	12-03-26	CF
LET.	MODIFICATION	DATE	INT.



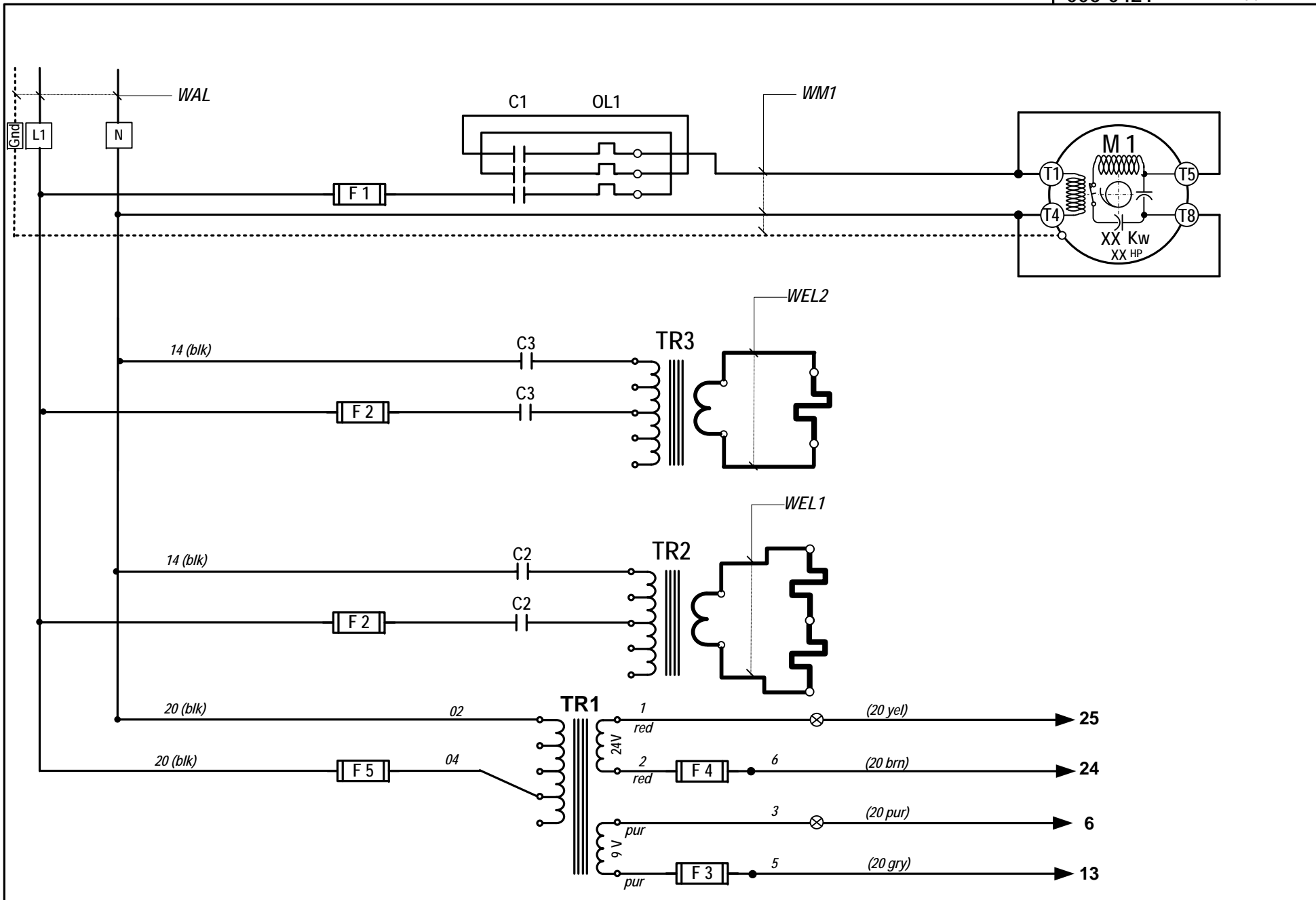
ELECTRICAL DRAWING



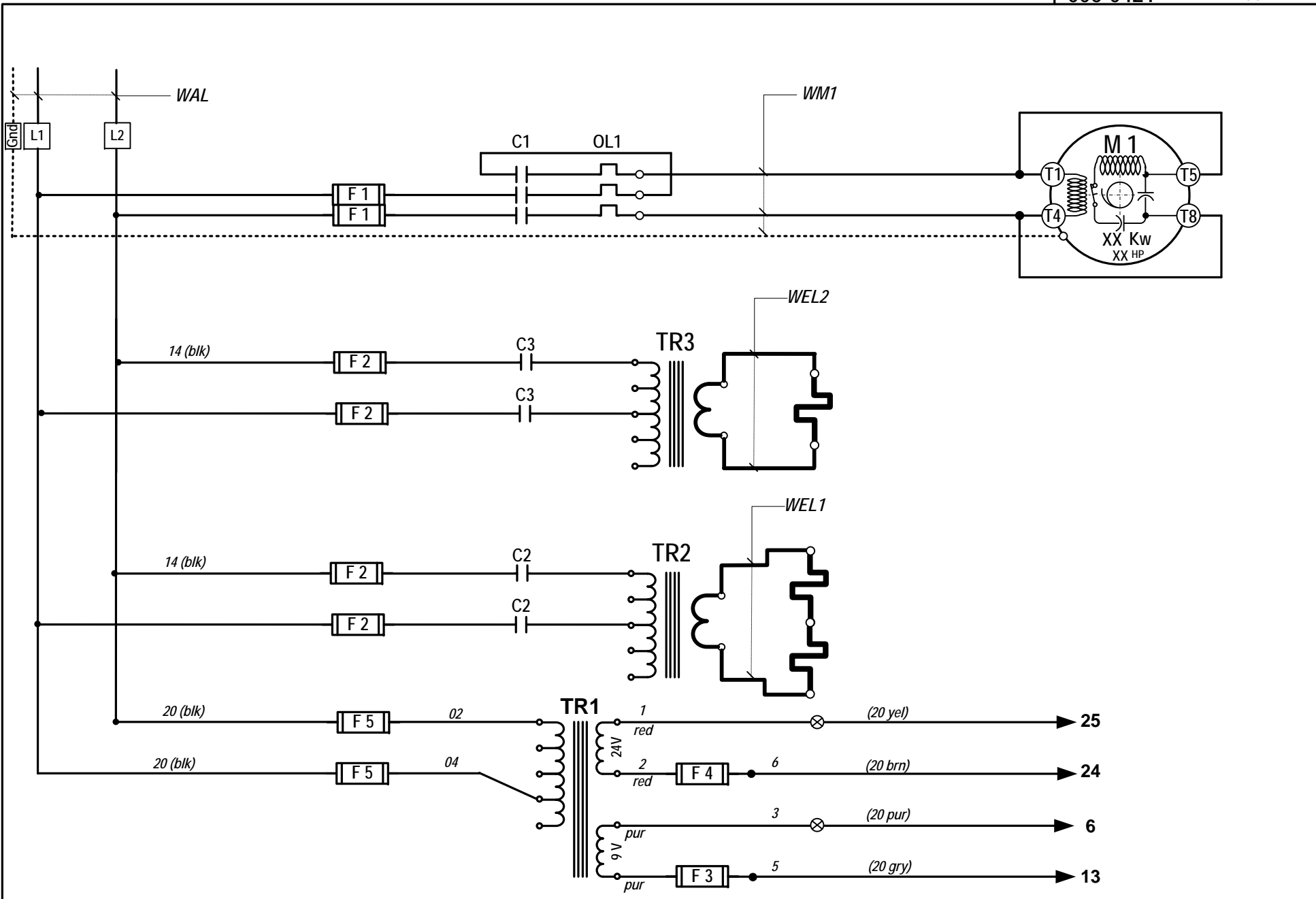
TRANSF.CONT.



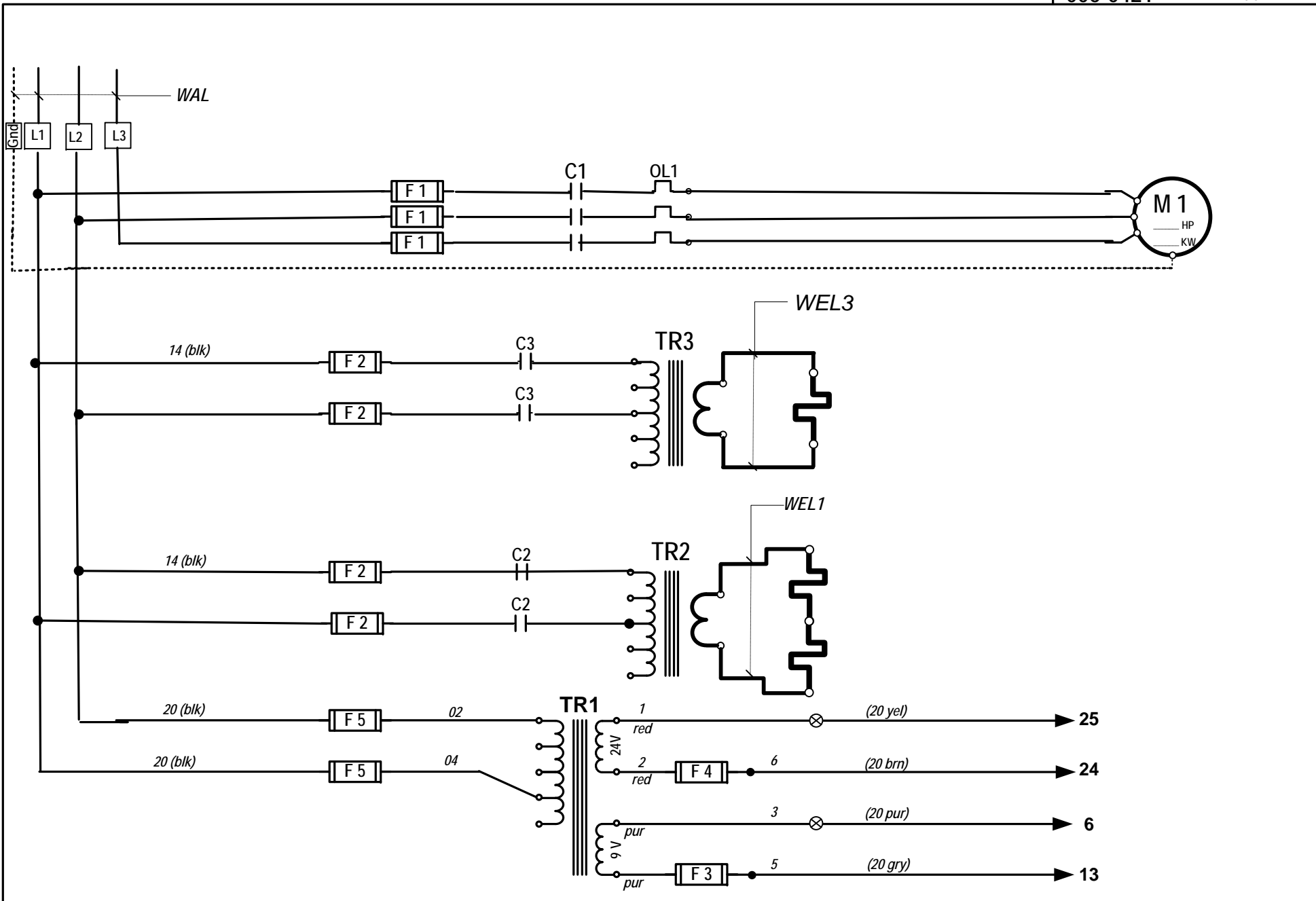
category	VACUUM PACK	model	380-T	volt.	ALL				SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system	Control MC-40			circuit	control	year	month	day	
usual fonctions	MC-40					05	04	14	
options					concept	draw	app	006-0438 PAGE 2 de 2	
					PP	PP	DL		



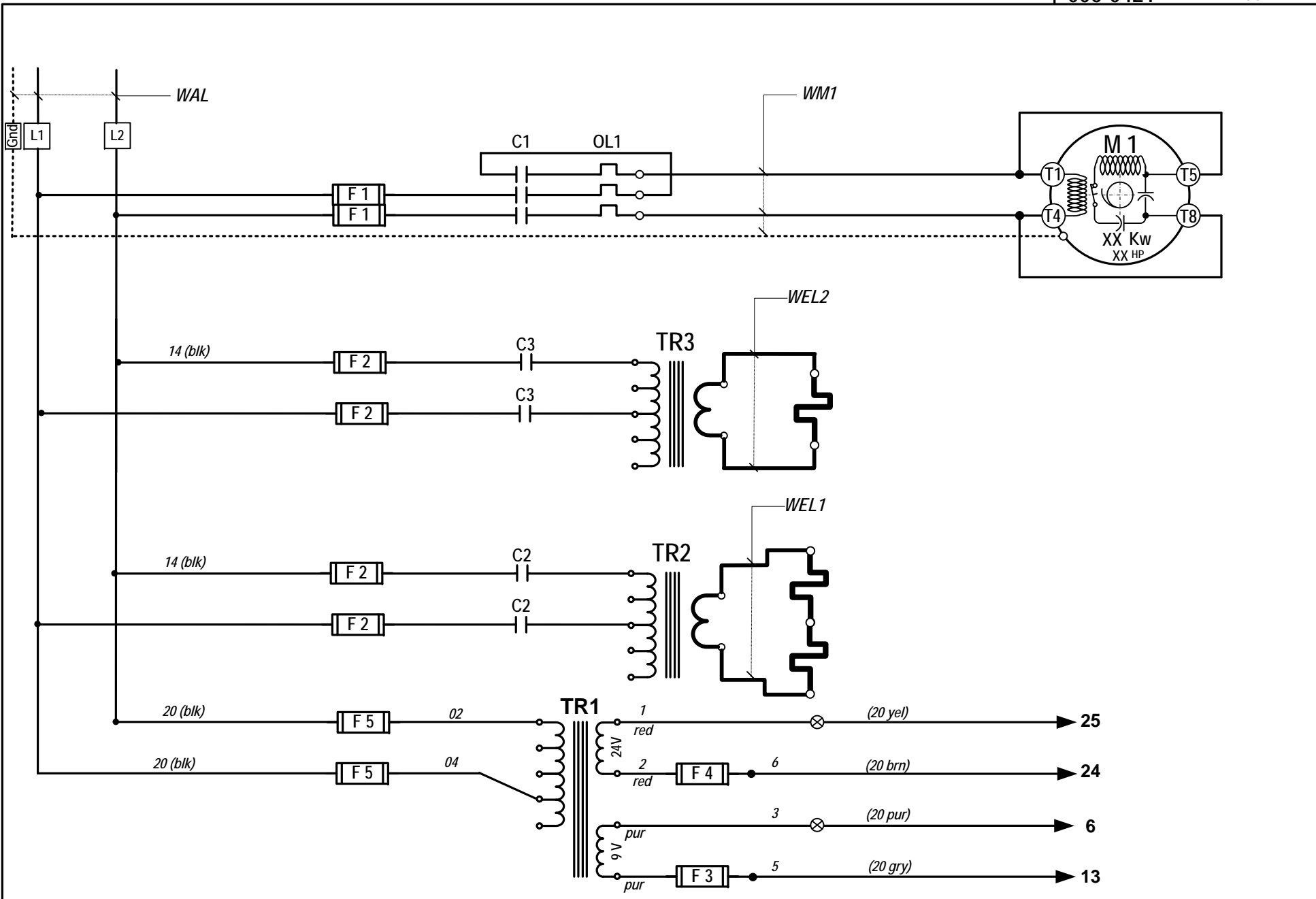
category	VACUUM PACK	model	380-T	volt.	115-120 V 1 Ph 60 Hz				SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system	MC-40			circuit power	year	month	day	block	
usual fonctions					05	07	07		006-0421 PAGE 1 de 2
options					concept	draw	app		
					PP	PP	DL		



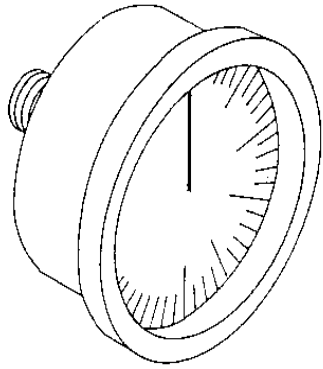
category	VACUUM PACK	model	380-T	volt.	208-230 V 1 Ph 60 Hz				SIPROMAC	
system	MC-40			circuit power	year	month	day	block	St-Germain de Grantham QUEBEC, CANADA	
usual functions					05	07	07			
options					concept	draw	app	006-0421 PAGE 2 de 2		
					PP	PP	DL			



category	VACUUM PACK	model	380-T	volt.	208 v 3 ph 60 hz				SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system	MC-40			circuit power	year	month	day	block	
usual fonctions					11	04	26		006-0421 PAGE 1 de 2
options					concept	draw	app	DL	



category	VACUUM PACK	model	380-T	volt.	208-230 V 1 Ph 60 Hz				SIPROMAC	
system	MC-40			circuit power	year	month	day	block	St-Germain de Grantham QUEBEC, CANADA	
usual functions					05	07	07			
options					concept	draw	app	006-0421 PAGE 2 de 2		
					PP	PP	DL			



PNEUMATIC DRAWING

