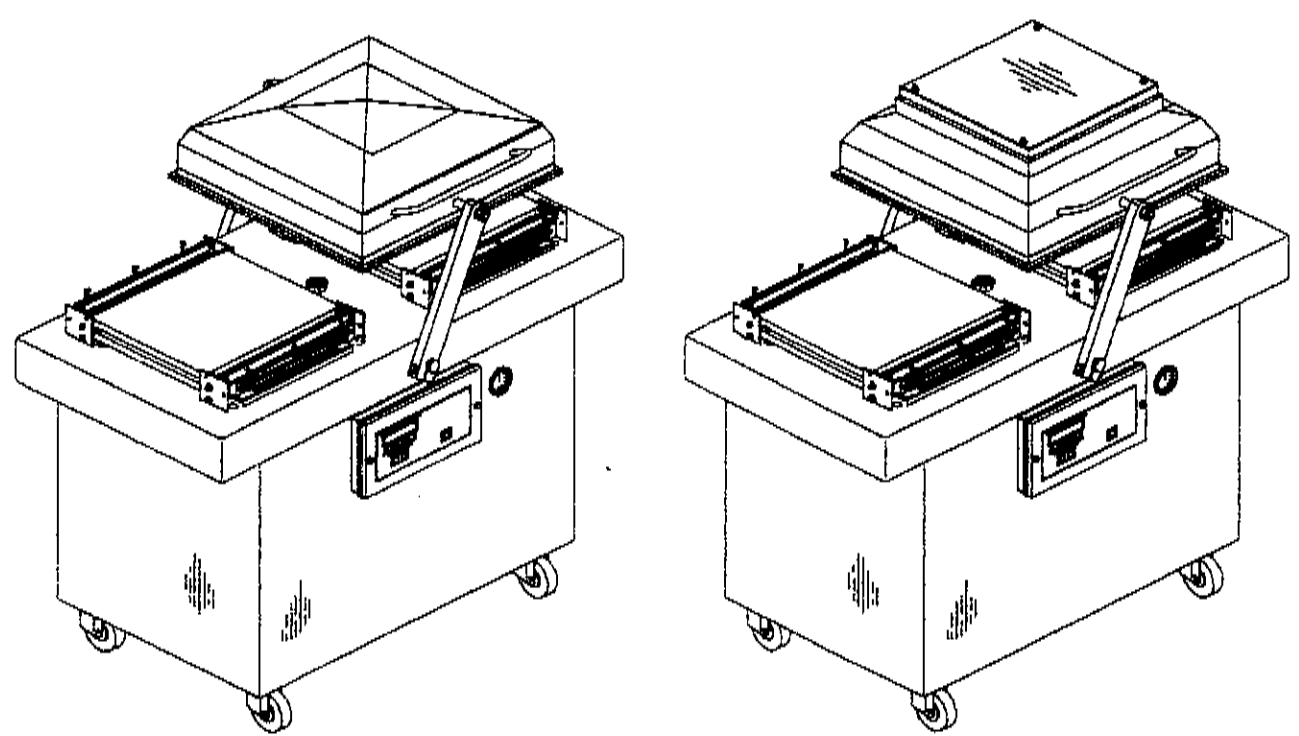
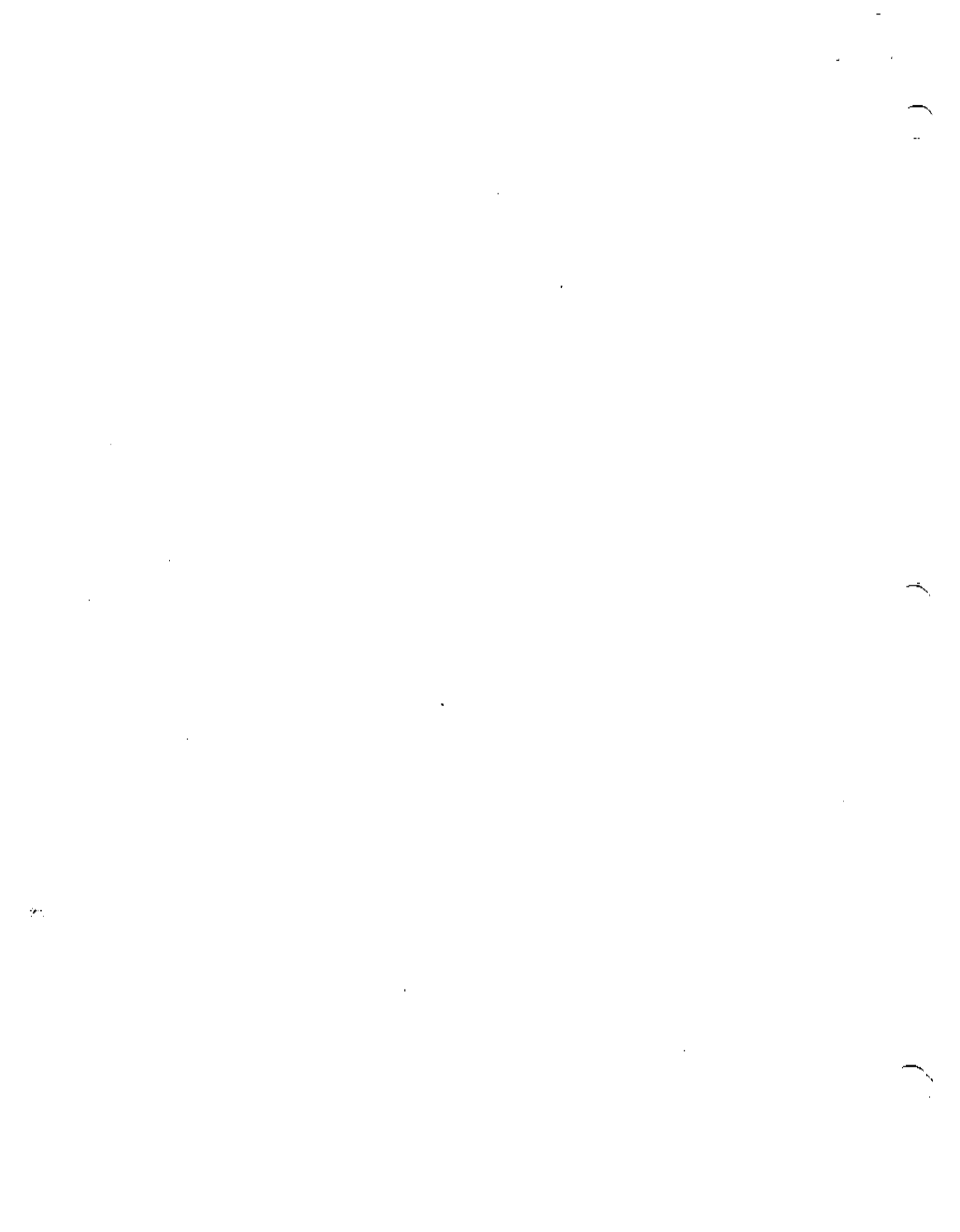


MODEL 420A



OWNERS MANUAL (MANUEL D'UTILISATION) (MANUAL DE UTILIZACIÓN)



Safe Operation Practices



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 vacuum 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 instruction regarding this machine in the owners manual.

VACUUM PACKAGING MACHINE

MODEL 420A

GENERAL TABLE OF CONTENTS

I OPERATION INSTRUCTIONS

II MECHANICAL

- A- Front view general assembly drawing
- B- Rear view general assembly drawing
- C- Cover adjustment procedure
- D- Central shaft assembly drawing
- E- Seal bar assembly drawings
(twin seal)
- F- Seal bar assembly drawings
(electrical bag cut option)
- G- Upper seal bar assembly drawing
- H- Gas injection kit installation drawing
(gas injection option)

III ELECTRICAL

- A- Electrical drawing low voltage
- B- Electrical drawing high voltage 1 phase
- C- Electrical drawing high voltage 3 phase
- D- Electrical drawing high voltage 1 phase 50 Hz
- E- Electrical drawing high voltage 3 phase 50 Hz
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IV PNEUMATIC

- A- Pneumatic drawing

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

TABLE OF CONTENTS

1. Setting up the machine
2. Electrical connection
3. Operation
 - 3.1 Working principles
 - 3.2 Special packaging
 - 3.2.1 Gas flushing
 - 3.2.2 Electrical bag cut
 - 3.3 Setting of digital controls
 - 3.4 Daily cleaning
4. Trouble shooting
 - 4.1 Failure during a packaging cycle
 - 4.2 Insufficient vacuum
 - 4.2.1 Leakage in the bag
 - 4.2.2 No leakage in the bag
 - 4.2.3 Insufficient vacuum in the chamber
 - 4.3 Faulty seal
 - 4.3.1 Insufficient seal
 - 4.3.2 No seal
 - 4.3.3 Permanent sealing current
 - 4.3.4 Seal does not stick
 - 4.4 Fault in the valves
 - 4.5 Control board failure
5. Regular maintenance

SIPROMAC INC.

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.

Due to the oil viscosity, the machine is hard to start when temperatures are very low. Therefore the pump should be put in a room with an air temperature of at least 50°F (+10°C). On the other hand, there must be free access of air to the pump to allow for cooling so that operation temperature of 160°F (70°C) is not exceeded.

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.

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.

Warning: 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.

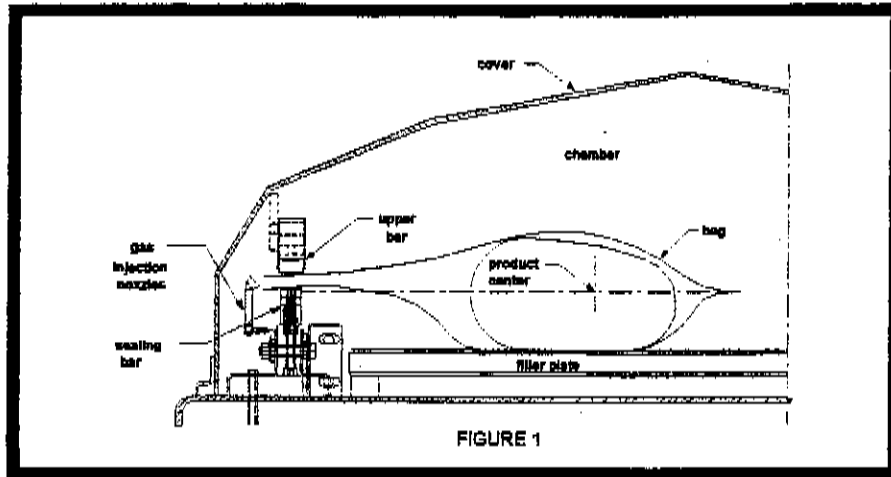
3. OPERATION:

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 2" (50 cm) 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 14 lbs/sq. inch (= 1 kg/ sq. cm) 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 counterbalanced 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 can be set by "G" control.

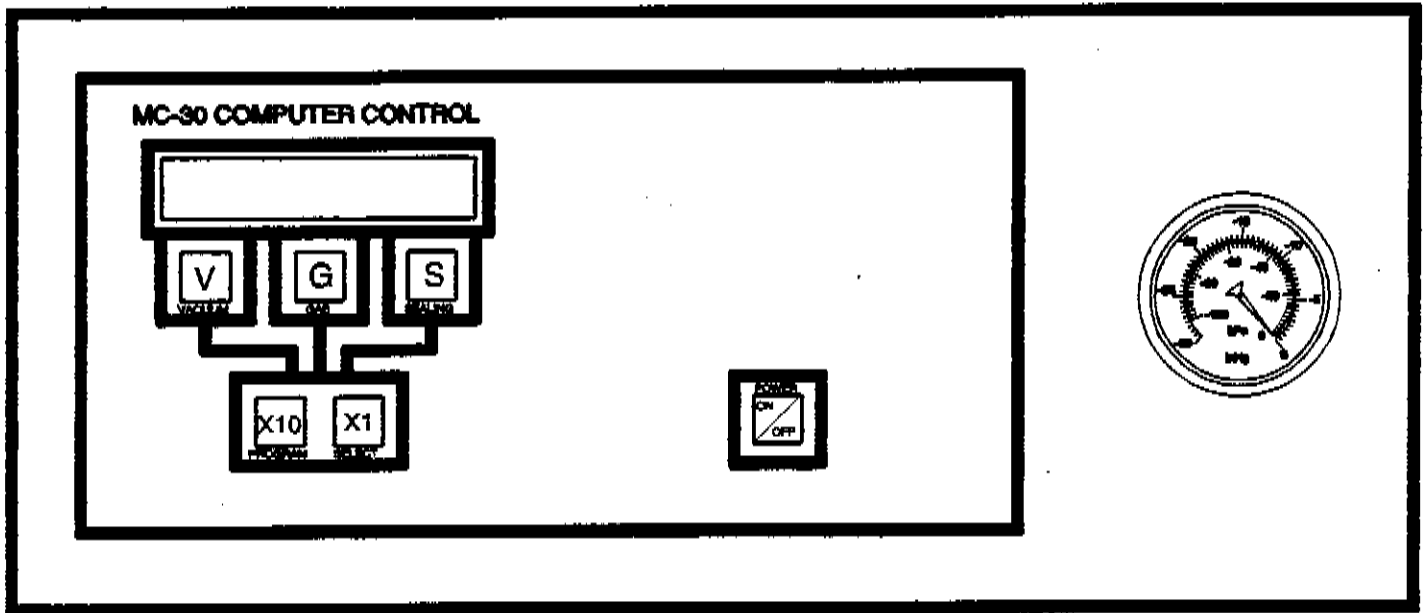
The necessary gas tank and pressure valve mounted on tank is not supplied by Sipromac. The pressure of the gas regulator should be set at approximately 5 lbs/sq. inch. (1/3 kg/sq. cm). Each machine has an adaptor for gas connection when gas flush option is ordered.

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 Setting of digital controls for MC-30E p.c. board:

Control pannel:



To turn on: Press the "Power On" key.

To turn off: Press the "Power Off" key.

How to program a complete cycle:

To enter the vacuum time (sec.):

1. Press the "V" key. The display will flash.
2. Set your desired timing by pressing on "X10" and/or "X1".
3. Press one more time on the "V" key. The display stays on.

To enter the gas time (sec.):

1. Press the "G" key. The display will flash.
2. Set your desired timing by pressing on "X10" and/or "X1".
3. Press one more time on the "G" key. The display stays on.

To enter the sealing time (sec. decimals):

1. Press the "S" key. The display will flash.
2. Set your desired timing by pressing on "X10" and/or "X1".
3. Press one more time on the "S" key. The display stays on.

3.3 Con't

The micro-processor will memorize the last program you entered. The system functions with a 5 volt Cadium Nickel battery which lasts approximately 3 years and recharges automatically if your machine remains plugged in. You may notice, during the first few days of use, that your micro-processor does not keep you program in memory, it is normal due to the fact that your battery is not yet fully charged.

BASIC PROGRAM TO MODIFY ACCORDING TO THE PRODUCTS

MACHINE	"V"	* "G"	"S"
VAC 250	18 sec.	N/A	1.2 sec.
VAC 350,350D	20 sec.	As needed	1.3 sec.
VAC 450T,450A	20 sec.	As needed	1.3 sec.
VAC 420A	22 sec.	As needed	1.3 sec.
VAC 550A	25 sec.	As needed	1.5 sec.

To modify your program, increase as desired by pressing the "X1" key.

* If you do not use the gas option, you have to program "00".

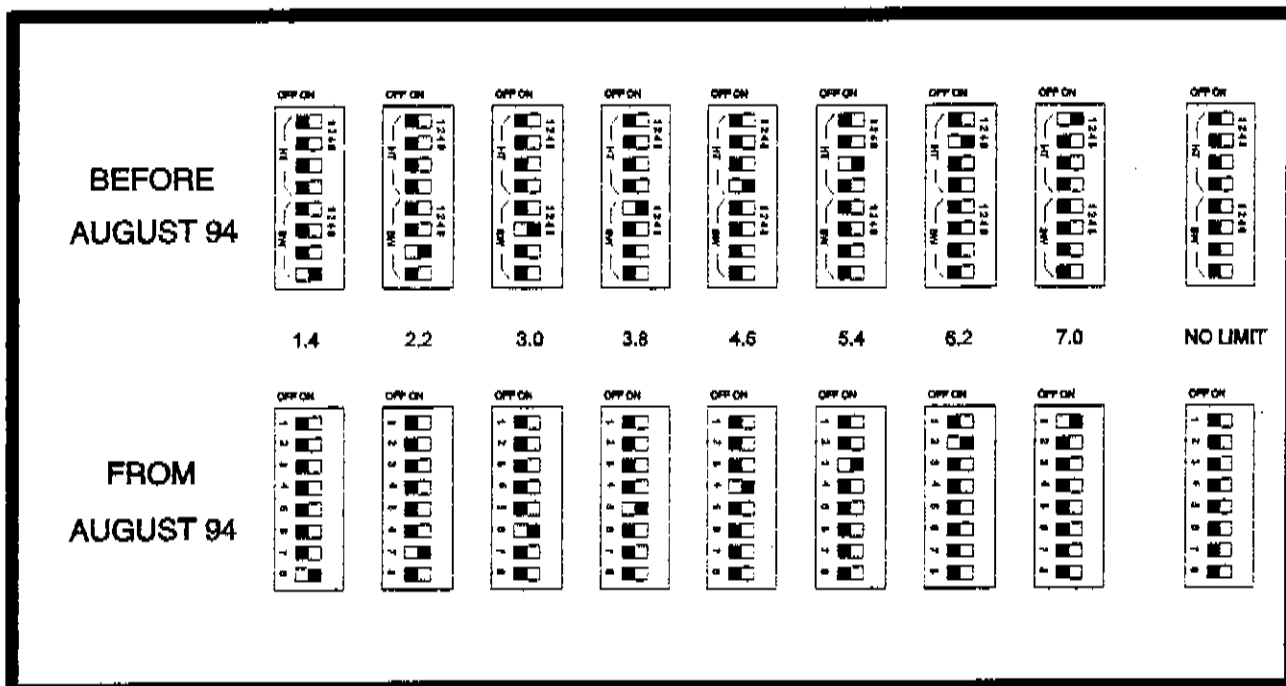
Warning: Do not increase the sealing time too much to prevent damaging the teflon.

How to use the memories of the MC-30E P.C. board:

The MC-30E p.c. board has a memory to store up to 9 different programs. To display program number, press the "X10" key. The program number will appear in the center of the display. To select the program number, press the "X1" key, then press the "X10" key to return to operating mode.

Sealing time security:

The MC-30E p.c. board also has a time limit on the sealing. This is an additional security which does not go thru the micro-processor and has a separate circuit. This is in case the computer malfunctions or the operator sets a sealing time too high. When the sealing time reaches the limit value, the machine will turn off automatically.



TIME LIMITS:
Time limit factory settings:

250	3.0
350,350D	3.8
420A	4.6
450T	4.6
450A	4.6
550A	4.6

NOTE: Pressing the "V" key during the vacuum cycle will stop the vacuum cycle and go to the next step (gas or sealing). This is especially useful to package liquids.

WARNING: ALL ELECTRICAL WORK DESCRIBED IN THIS BROCHURE SHOULD BE DONE BY A QUALIFIED AND AUTHORIZED TECHNICIAN.

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.

4. TROUBLE SHOOTING:

4.1 Failure during a packaging cycle:

The lid is closed and cycle fails to start or stop immediately after having started:

Micro switch is actuated too late, re-set the micro switch.

Fault in supply of electricity to the timing control (power on light does not go on):

Check input voltage at transformer (faulty contact in wires);

Check secondary voltage of transformer (approx. 24 Volt AC);

Check fuse;

If none of these apply, change the PC board.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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.

Evacuation time is too short:

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

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).

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 vacuummeter, 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.

4.2.3 Insufficient vacuum in chamber (cont.):

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 does not work.

4.3.3 Permanent sealing current:

Contactors is 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 Control board failure

PROBLEM	POSSIBLE CAUSE	
1. No display	1.1 Programming error	Press on/off switch on membrane
	1.2 No current coming to PC board	Check fuses check voltage between pins #6 and # 13 on "D" connector, the reading should be approx. 9 volts AC (if not it's due to trans-former or wiring defect)
	1.3 On/off key defective	Disconnect flat cable between PC board and switch and jump pins 1 and 2 or 7 and 8 using a screw driver
	1.4 Defective PC board	Replace PC board
2. Two digits continuously flashes on "V", "G" or "S"	2.1 Programming error	Press corresponding "V", "G" or "S" key
	2.2 Defective membrane	Replace membrane
	2.3 Defective PC board	Replace PC board
3. All of the display continuously flashes	3.1 Cover switch remains closed	Check cover switch or continuity between pins #8 and #15 PC board connector see (dwg #006-0029).
	3.2 Defective	Replace PC board
4. Display is on but impossible to program valves	4.1 Programming error	Press "V", "G" or "S" to be in programming mode. Only one at any a time
	4.2 Defective PC board	Replace PC board

4.5 cont.

Impossible to program one timer ("V", "G" or "S") (the display is on) (see step 4 first)	5.1 Defective membrane	Replace membrane
	5.2 Defective PC board	Replace PC board
6. PC board doesn't keep data in memory	6.1 Battery not charged	Run the machine or leave it plugged in with switch off for a few hours to charge battery
	6.2 Defective battery	Replace battery or complete PC board (the battery is mounted on the PC board)
	6.3 Defective PC board	Replace PC board
7. Cycle doesn't start	7.1 Poorly adjusted cover	Adjust switch
	7.2 Bad connection or defective limit switch	Verify
	7.3 Defective PC board	Replace PC board
	7.4 PC board is OK, outputs are defective (see dwg #006-0029)	Check pump fuses, pump contactors coil, valves, etc...
8. Machine "recycling" or cycle "re-start" continuously	8.1 Poorly adjusted cover	Adjust
	8.2 Defective PC board	Replace PC board
9. Double chamber: vacuum sealing or atmosphere is not done on one side only.	9.1 Defective relay or connection	Replace the 4PDT (in elec. box). This relay switch functions from one side to the other. (the PC board is good because there is one output which controls both sides)
	9.2 Defective contactor or valve	Test voltage on coil.

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon 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 change of oil - necessity indicated by change of color).

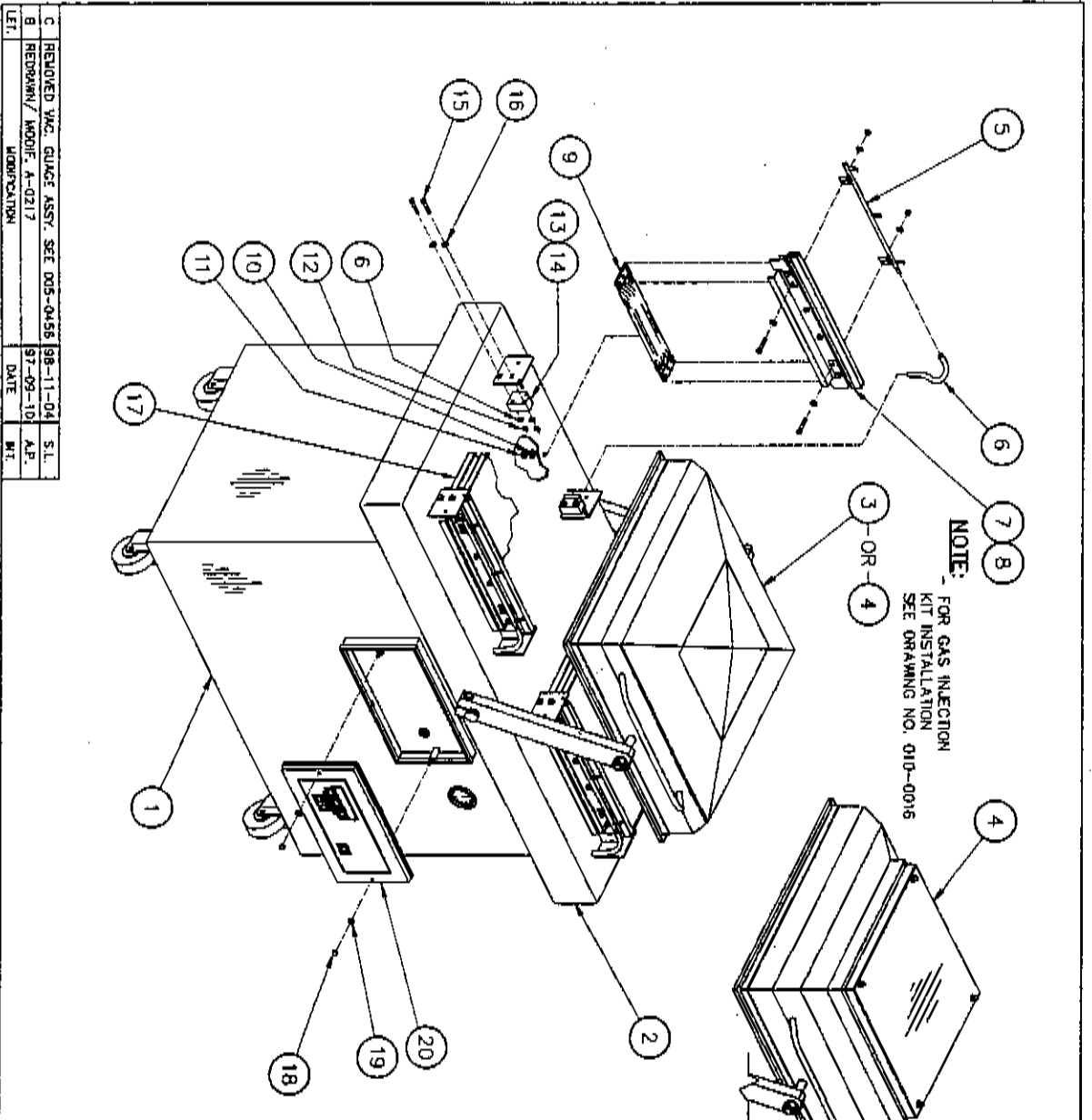
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

INSTALLATION NOTICE FOR MODELS:
420A, 450T, 450A, 550A, 600A, 620A, 650A AND 700A

IN ORDER TO RESPECT NSF REGULATIONS:

NOTE: A PLASTIC CAP IS INSTALLED ON THE TABLE TOP VACUUM INLET USED FOR
LEANING PURPOSES ONLY AND IS TO BE REMOVED PRIOR TO OPERATING THE
MACHINE.



NOTE:
FOR GAS INJECTION
KIT INSTALLATION
SEE DRAWING NO. 010-0016

ITEM	PART #	DESCRIPTION	QTY.
1	005-0456	STRUCTURE ASSEMBLY	1
2	005-0327	TABLE ASSEMBLY	1
3	005-0455	B' COVER ASSEMBLY	1
4	005-0476	B' COVER ASSEMBLY (PLEXI OPTION)	1
5	00560042	GAS INJECTION BAR ASSEMBLY (OPTION)	4
6	005-0464	GAS INJECTION CONTROL TUBE (OPTION)	4
7	005-0046	SEAL BAR ASSEMBLY W/ SUPPORT	4
8	005-0568	SEAL BAR ASSEMBLY W/ SUPPORT (BAG OUT OPTION)	4
9	005-0331	BELLOWS ASSEMBLY	4
10	051-0760	FLAT WASHER 3/8" S/S	4
11	051-0620	HEX NUT 3/8"-16 NC.	4
12	051-0581	HEX NUT 1/4"-20 NC. MUDLOK LOCK S/S	4
13	002-0327	RIGHT SEAL BAR GUIDE BLOCK	4
14	002-0326	LEFT SEAL BAR GUIDE BLOCK	4
15	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	18
16	051-0740	FLAT WASHER 1/4" S/S	32
17	005-0333	FILLER PLATE ASSEMBLY	4
18	051-0591	ACORN NUT 1/4"-20 NC. S/S	2
19	052-2045	FLAT WASHER 1/4" COPPER	2
20	005-0319	P.C. BOARD SUPPORT ASSEMBLY	1

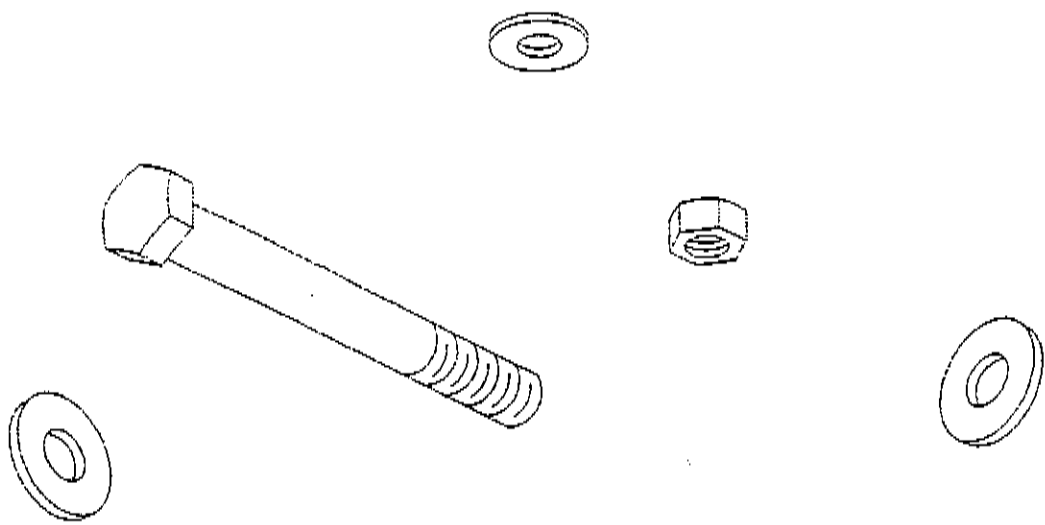
420A

MACHINE ASSEMBLY FRONT VIEW

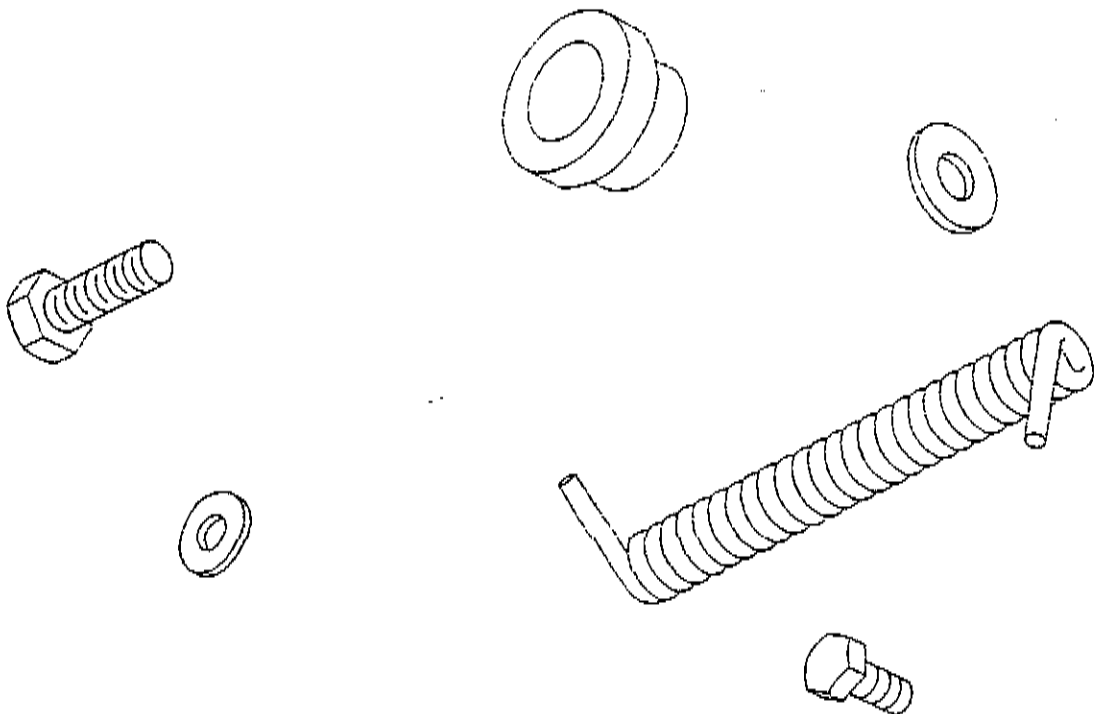
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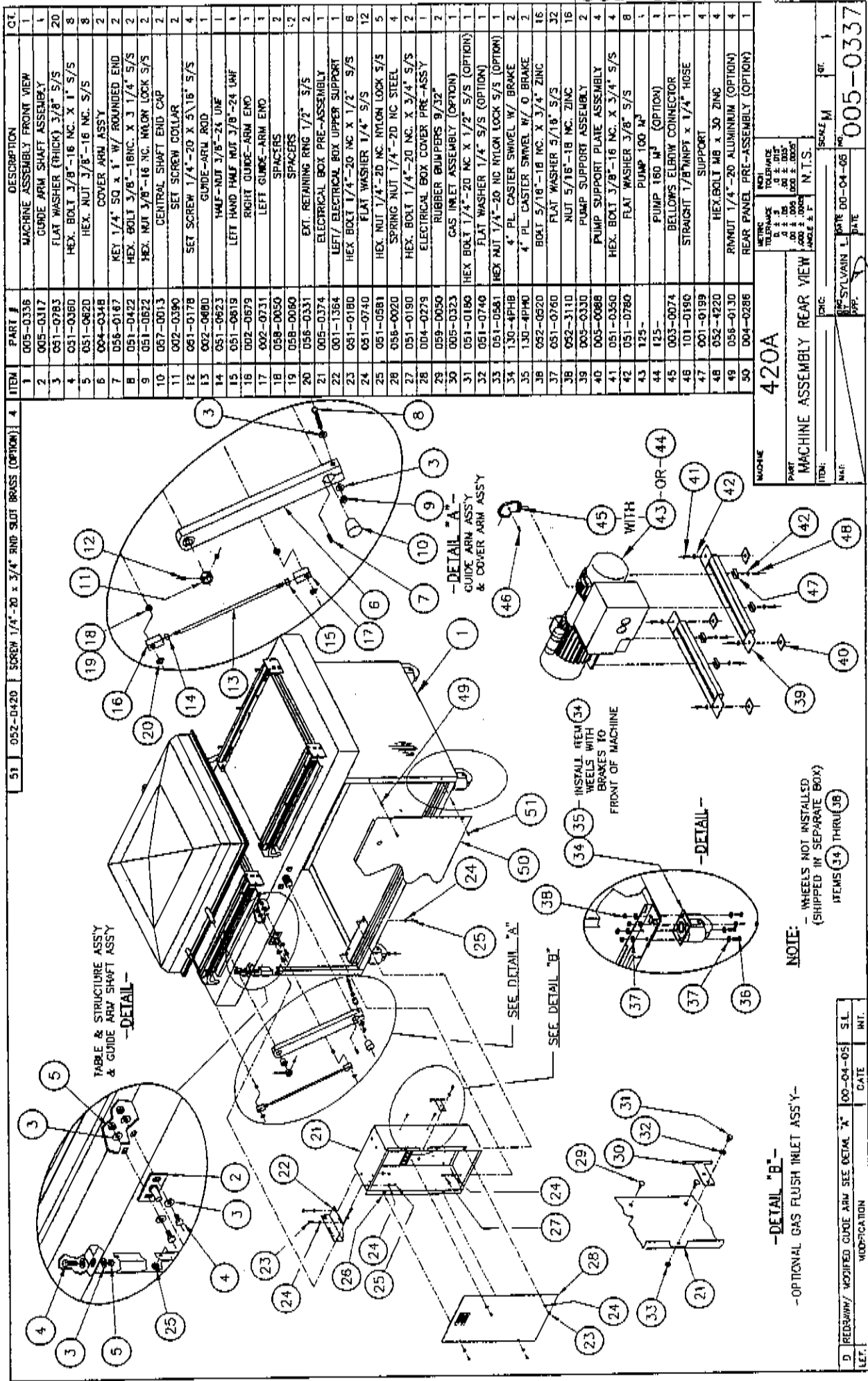
005-0336

1005-0336



MECHANICAL DRAWING





ITEM	PART #	DESCRIPTION	QTY
1	005-0336	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0317	GUIDE ARM SHAFT ASSEMBLY	1
3	051-0283	FLAT WASHER (THICK) 3/8" S/S	20
4	051-0380	HEX BOLT 3/8"-16 NC. X 1" S/S	8
5	051-0820	HEX. NUT 3/8"-16 NC. S/S	8
6	004-0348	COVER ARM ASSY	2
7	056-0167	KEY 1/4" SQ X 1" W/ ROUNDED END	2
8	051-0182	HEX. BOLT 3/8"-16 NC. X 3/4" S/S	2
9	051-0623	HEX. NUT 3/8"-16 NC. NICKEL LOCK S/S	2
10	057-0013	CENTRAL SHAFT END CAP	2
11	002-0390	SET SCREW 1/4"-20 X 5/16" S/S	4
12	061-0178	GUIDE-ARM ROD	1
13	002-0480	HAIF-NUT 3/8"-24 UNF	1
14	051-0623	LEFT HAND HALF NUT 3/8"-24 UNF	1
15	051-0819	RIGHT GUIDE-ARM END	1
16	002-0679	LEFT GUIDE-ARM END	1
17	002-0731	SPACERS	2
18	058-0050	EXT. RETAINING RING 1/2" S/S	2
19	056-0331	ELECTRICAL BOX PRE-ASSEMBLY	1
20	005-0374	LEFT/ ELECTRICAL BOX UPPER SUPPORT	1
21	001-1364	HEX BOLT 1/4"-20 NC X 1/2" S/S	6
22	051-0190	FLAT WASHER 1/4" S/S	12
23	051-0740	HEX NUT 1/4"-20 NC NYLON LOCK S/S	5
24	051-0581	HEX BOLT 1/4"-20 NC. X 3/4" S/S	2
25	056-0020	SPRING NUT 1/4"-20 NC STEEL	4
26	051-0190	ELECTRICAL BOX COVER PRE-ASSY	2
27	004-0279	RUBBER GROMMETS 9/32"	2
28	005-0050	GAS INLET ASSEMBLY (OPTION)	1
29	051-0190	HEX BOLT 1/4"-20 NC X 1/2" S/S (OPTION)	1
30	005-0323	FLAT WASHER 1/4" S/S (OPTION)	1
31	051-0740	HEX NUT 1/4"-20 NC NYLON LOCK S/S (OPTION)	1
32	051-0581	HEX BOLT 1/4"-20 NC. X 3/4" S/S (OPTION)	1
33	051-0581	4" PL. CASTER SWIVEL W/ O. BRAKE	2
34	130-4PHB	BOKT 5/16"-16 NC. X 3/4" ZINC	16
35	130-4PHB	FLAT WASHER 5/16" S/S	32
36	052-0620	NUT 5/16"-18 NC. ZINC	16
37	051-0760	PUMP SUPPORT ASSEMBLY	2
38	052-3110	PUMP SUPPORT PLATE ASSEMBLY	4
39	003-0330	HEX. BOLT 3/8"-16 NC. X 3/4" S/S	4
40	005-0088	FLAT WASHER 3/8" S/S	8
41	051-0350	PUMP 100 M ³	1
42	051-0760	PUMP 160 M ³ (OPTION)	1
43	125-	BELLOWS ELBOW CONNECTOR	1
44	125-	STRAIGHT 1/2" BHNPT X 1/4" HOSE	1
45	003-0074	SUPPORT	4
46	101-0190	HEX BOLT M6 X 30 ZINC	4
47	001-0199	RIVNUT 1/4"-20 ALUMINUM (OPTION)	4
48	052-4220	REAR PANEL PRE-ASSEMBLY (OPTION)	1
49	058-0130		
50	004-0286		

MACHINE 420A

PART MACHINE ASSEMBLY REAR VIEW

ITEM: 420A

DATE: 00-04-05

SCALE: M

005-0337

REV.	DESCRIPTION	DATE	INT.
D	REDRAWN/ MODIFIED GUIDE ARM SEE DETAIL "A"	00-04-05	S.L.

MODEL 420A

COVER ADJUSTMENT PROCEDURE

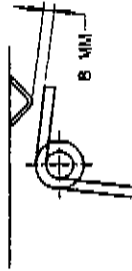
Reference Drawing:# 005-0337
004A0124

PROBLEM: MACHINE TABLE AND COVER SEEMS TO BE STRAIGHT, LID GASKET IS GOOD BUT COVER DOES NOT SIT PROPERLY ON BOTH SIDES OF TABLE.

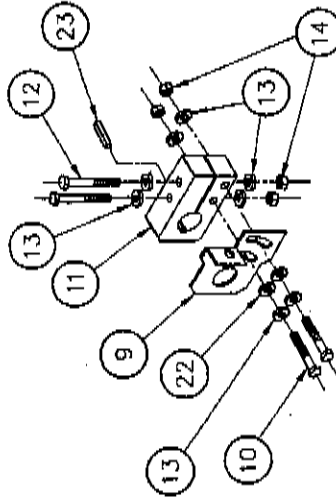
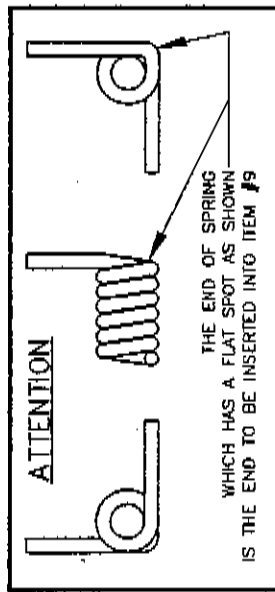
1. Floor should be flat (within 1/8" approx.).
 - 2.1 Mark position of original adjustment of lower shaft position & measure guide arm length. (See drawing # 005-0337; items: #13 & #2).
 - 2.2 Loosen the two nuts on the guide arm (See drawing # 005-0337; item #14).
 - 2.3 Now move the cover each side and check how cover sits on the table. Distance between table and lid gasket should be under 1/16" approx. If so, go to step 3.0 for guide arm adjustment. Otherwise go to step 2.4 for central arm adjustment.
 - 2.4 Put chamber in upright position and check with a square angle to see if arms are parallel. If not, loosen bolt at the end of one arm and adjust until square (See drawing # 005-0337; items #6, #8 & #9).
 - 2.5 When closing cover (guide arm still loose), if cover is not sitting properly on either the front or rear of the table, you have to change the height of a central bearing (See drawing # 004-0124; item #4) until cover is sitting properly each side (less than 1/16").
3. Adjustment of guide arm: two things have to be adjusted, the length and the lower axis position. Each of these should be adjusted separately. Fix the lower axis in a central position, then adjust guide arm length when chamber is at the left and at the right. Adjustment can be done a couple of times until everything is ok.

SPRING ADJUSTMENT PROCEDURE

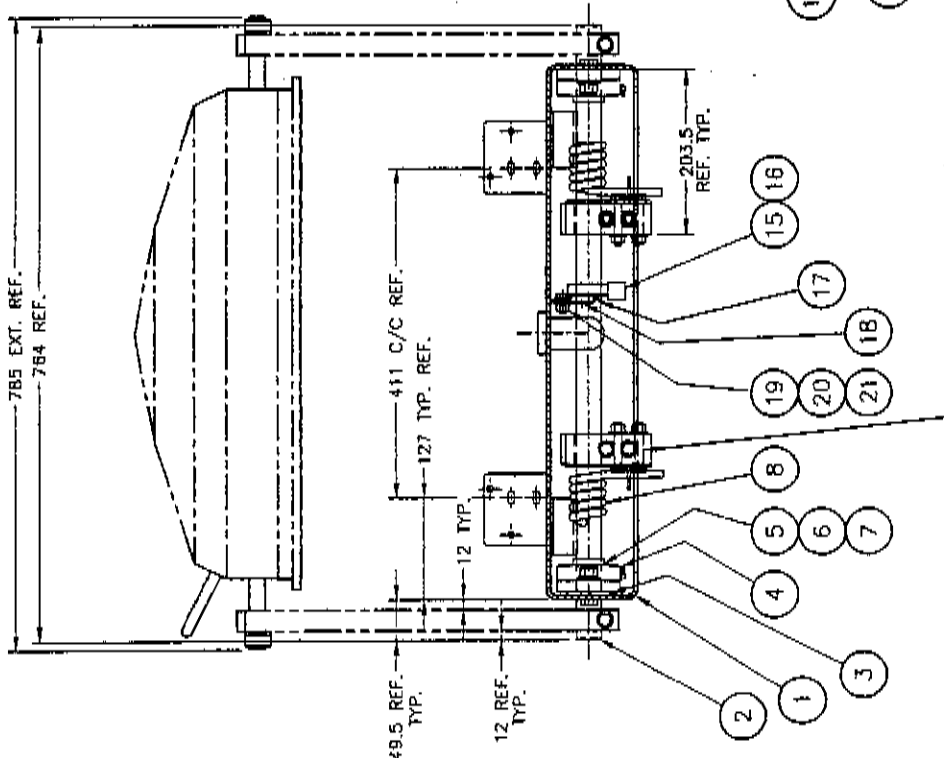
- A- PLACE COVER UP (ARM VERTICAL) TO FREE TENSION OF SPRINGS.
- B- LOOSEN BOLTS ITEMS #10 ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASSY (ITEM #9).
- C- TURN SPRING/BLOCK ASSEMBLY TO OBTAIN A SPACE APPROX. 8MM (5/16") AS SHOWN BELOW.



E- RETIGHTEN BOLTS ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASSY. (ITEMS #10).

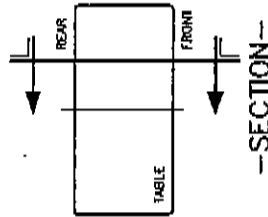


**SPRING BLOCK ASS'Y
-DETAIL-**



FOR SPRING BLOCK ASSY SEE DETAIL

ITEM	PART #	DESCRIPTION	QT.
1	005-0327	TABLE ASSEMBLY	1
2	002A0324	CENTRAL SHAFT	1
3	001-1542	PILLOW BLOCK SPACER	2
4	075-1650	FLANGED BEARING W/ GREASE FITTING 90T	2
5	051-0441	HEX. BOLT 1/2"-13 NC X 1 1/2" S/S	4
6	051-0630	HEX. NUT 1/2"-13 NC S/S	4
7	051-0790	FLAT WASHER 1/2" S/S	4
8	001A1316	CENTRAL SHAFT SPRING	2
9	001A1316	SPRING SUPPORT PLATE	2
10	052-0775	HEX. BOLT 3/8"-24 NC. X 2 1/2" ZINC	4
11	002A0319	SPRING BLOCK	2
12	052-0777	HEX. BOLT 3/8"-24 NC. X 3" ZINC	4
13	052-2060	FLAT WASHER 3/8" ZINC	16
14	052-312B	HEX. NUT 3/8"-24 NC. ZINC	8
15	005-0154	MICRO-SWITCH COLLAR	1
16	051-0334	SET SCREW 3/8"-16 NC. X 3/8" S/S	2
17	025-0610	MICRO-SWITCH	2
18	001-1294	MICRO-SWITCH FIXATION PLATE	2
19	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	2
20	051-0740	FLAT WASHER 1/4" S/S	4
21	051-0580	HEX. NUT 1/4" S/S	2
22	052-2071	CONTACT WASHER 3/8" STEEL	4
23	056-0168	KEY 1/4" SQ X 1 1/2" W/ ROUNDED END	2

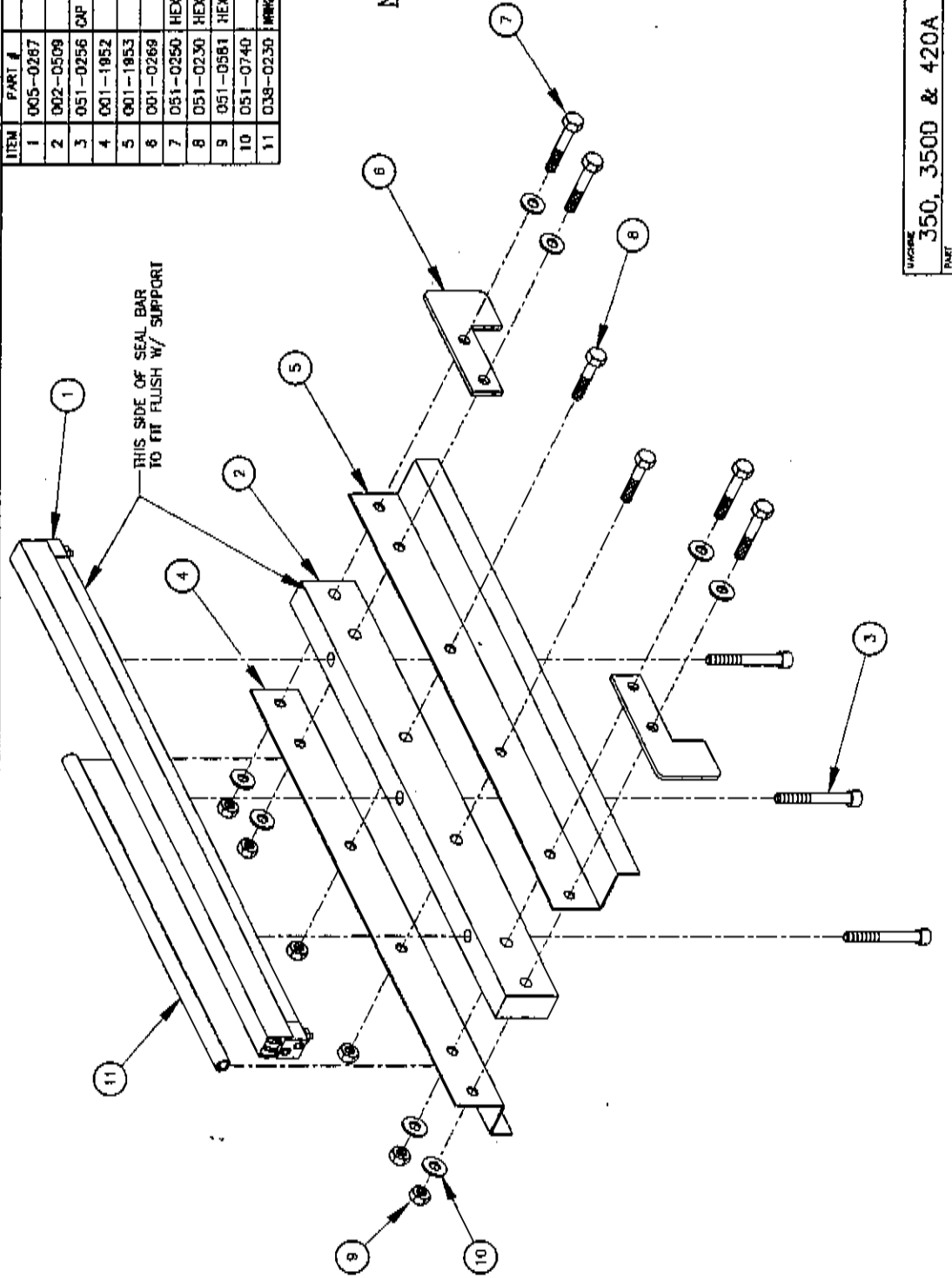


MACHINE: 420A
 PART: CENTRAL SHAFT ASSEMBLY
 DATE: 99-11-18
 SCALE: 1:1
 N.T.S.

REV: 00
 DATE: 99-11-18
 S.L. 004A0124
 MODIFICATION: 004A0124

ITEM	PART #	DESCRIPTION	QTY
1	005-0267	SEAL BAR PRE-ASSEMBLY	1
2	002-0509	SEAL BAR SUPPORT (TABLE)	1
3	051-0256	CAP HEX. SKT. BOLT 1/4" - 20 NC X 1 3/4" S/S	3
4	001-1952	EXTERIOR BELLOWS COVER	1
5	001-1953	INTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0250	HEX. BOLT 1/4" - 20 NC. X 1 1/2" S/S	4
8	051-0230	HEX. BOLT 1/4" - 20 NC. X 1 1/4" S/S	2
9	051-0581	HEX. NUT 1/4" - 20 NC. NYLON LOCK S/S	6
10	051-0740	FLAT WASHER 1/4" S/S	B
11	038-0230	MARK DUST W/ ADHESIVE BACKING (0.35" X 0.5" X 20") PVC	1

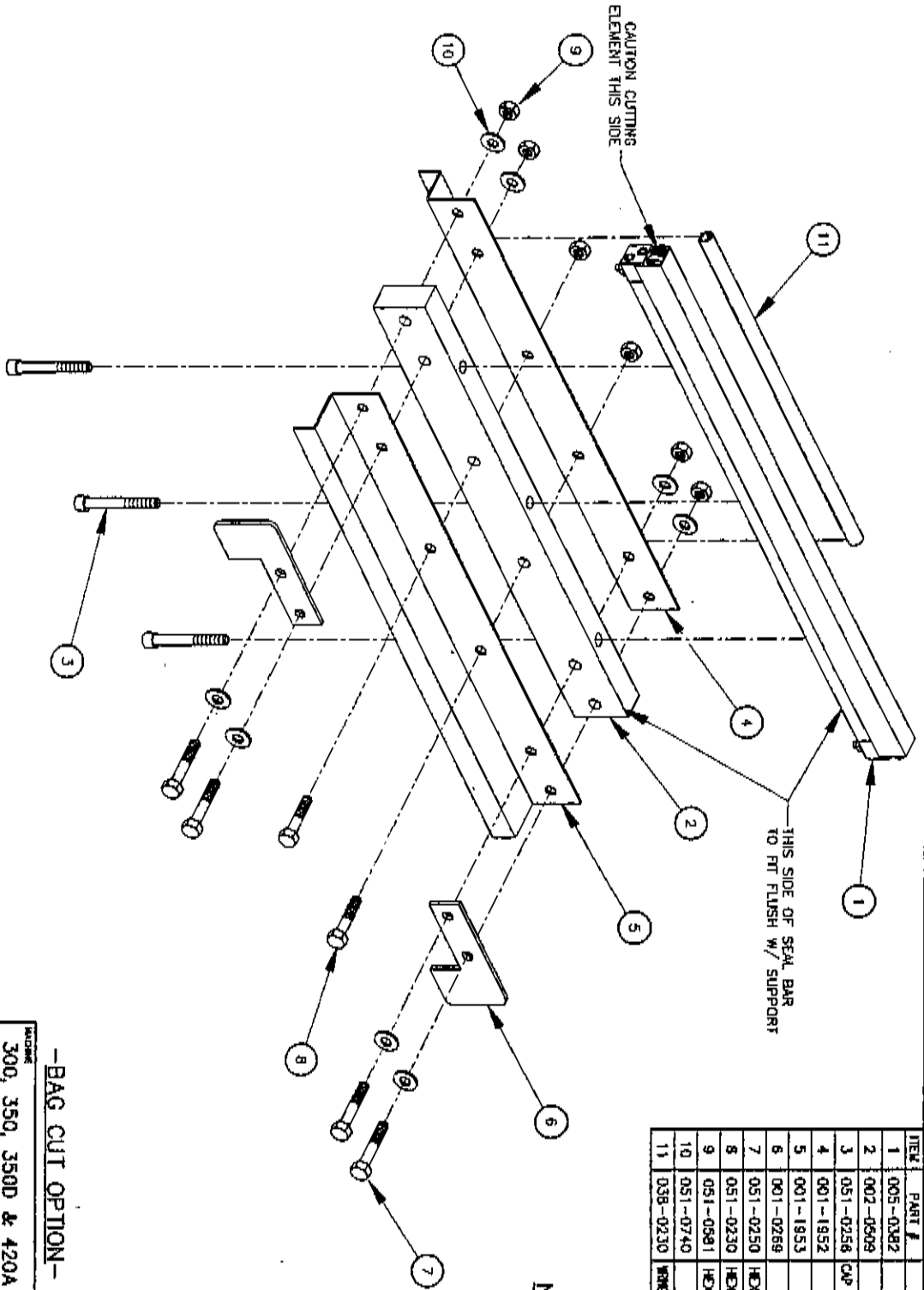
NOTE: QTY FOR ONE SEAL BAR ONLY SEE LIST



420A	4
350D	2
350	1
MACHINE	QTY

WORKING	DATE	SCALE	R ¹ SEE LIST
350, 350D & 420A	97-08-29	N.T.S.	005-0046
PART	DATE	SCALE	R ¹ SEE LIST
SEAL BAR ASSEMBLY W/ SUPPORT	97-08-29	N.T.S.	005-0046
REV:	DATE	SCALE	R ¹ SEE LIST
WAR:	DATE	SCALE	R ¹ SEE LIST

LET.	MODIFICATION	DATE	INT.
E	420A ADDED/ WAS 005-0329/ MODIF. A-0217	97-09-06	A.P.
D	FLORNER BOLT HOLES	97-09-09	A.P.
C	REDRAWN/ MODIF. A-0216	97-08-29	A.P.



ITEM #	PART #	DESCRIPTION	QTY.
1	005-0382	SEAL BAR PRE-ASSEMBLY	1
2	002-0509	SEAL BAR SUPPORT (TABLE)	1
3	051-0256	CAP HEX SMT. BOLT 1/4" - 20 NC. X 1 3/4" S/S	3
4	001-1952	EXTERIOR BELLOWS COVER	1
5	001-1953	INTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0250	HEX. BOLT 1/4" - 20 NC. X 1 1/2" S/S	4
8	051-0230	HEX. BOLT 1/4" - 20 NC. X 1 1/4" S/S	2
9	051-0591	HEX. NUT 1/4" - 20 NC. NYLON LOCK S/S	6
10	051-0740	FLAT WASHER 1/4" S/S	8
11	038-0230	WING NUT W/ ADHESIVE BACKING (LAST 1 05 X 1 00) NC	1

NOTE:
QTY FOR ONE
SEAL BAR ONLY
SEE LIST

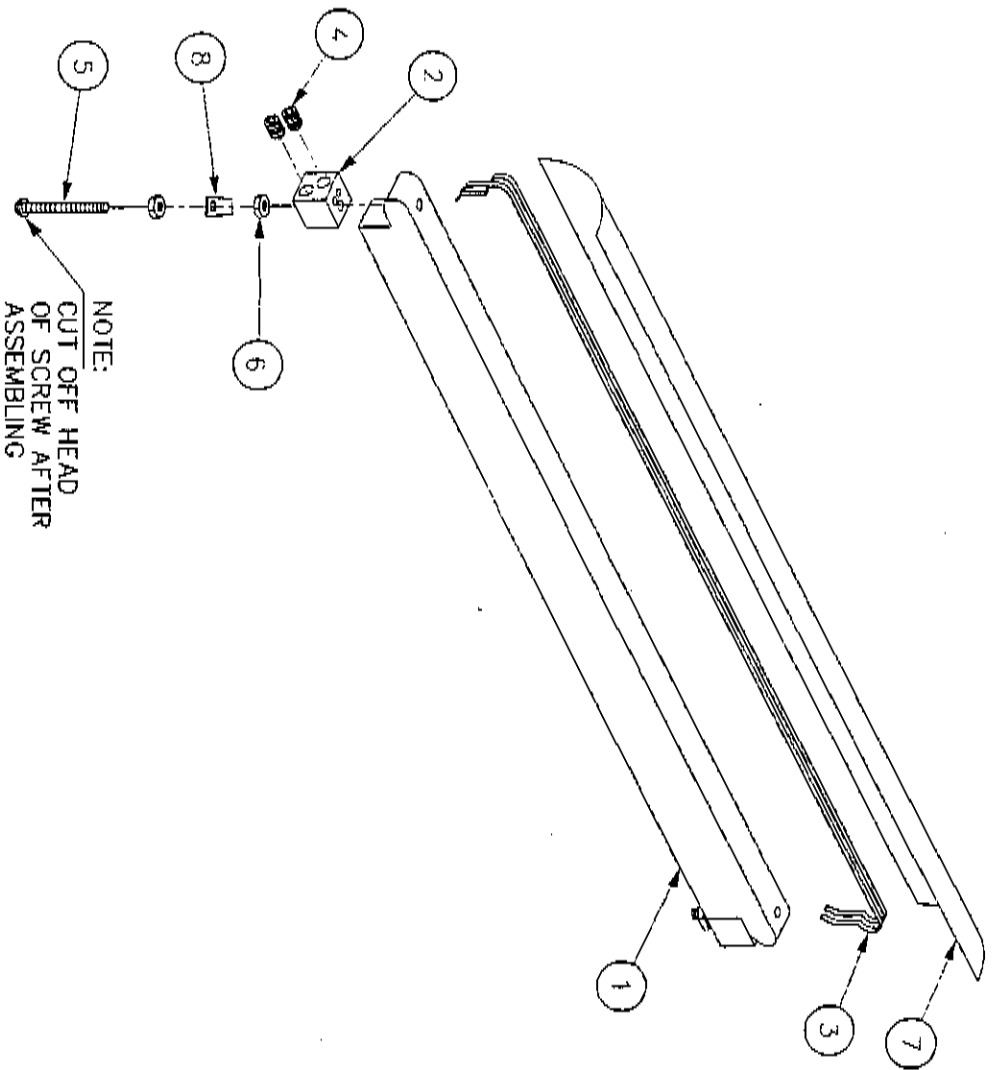
- BAG CUT OPTION -

ITEM #	PART #	DESCRIPTION	QTY.
1	005-0558	SEAL BAR ASSEMBLY W/ SUPPORT	1
2	420A	420A	4
3	350D	350D	2
4	350	350	1
5	300	300	1
6		MACHINE	QTY

REV	DESCRIPTION	DATE	BY
C	ADDED 300	98-08-03	L.M.
B	420A ADDED/ MODIF. A-Q217	97-09-08	A.P.
A	LOWERED BOLT HEADS	97-09-08	A.P.
1E1	MODIFICATION		

005-0558

C REORAWN/ MODIF. A-0216
 LET: H20R3CA30N
 97-09-03 GATE A.P.
 RTI.



NOTE:
 CUT OFF HEAD
 OF SCREW AFTER
 ASSEMBLING

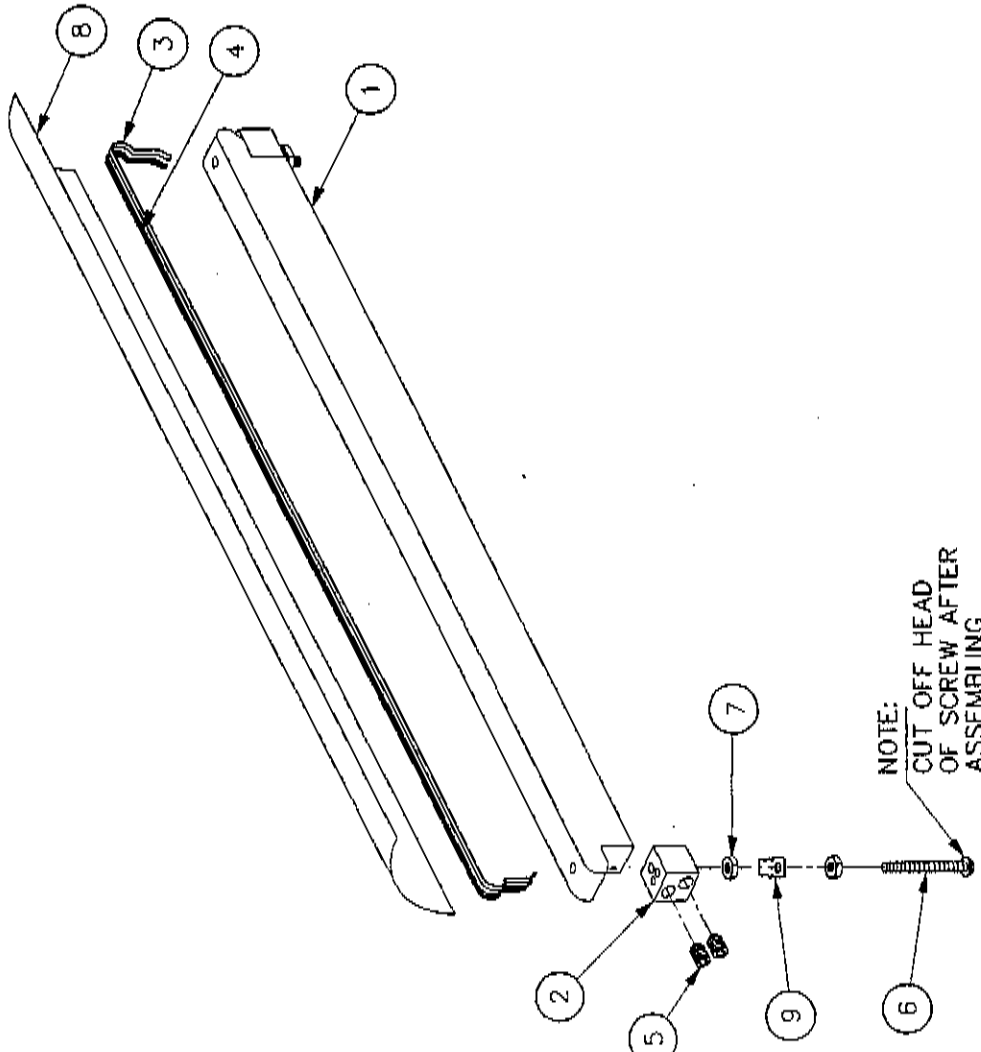
ITEM	PART #	DESCRIPTION	QTY
1	002-0015	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEW. STD 1WH (2x566 mm EA.)	1012
4	052-0395	SET SCREW 1/4" X 5/16" (OVAL POINT)	4
5	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
6	051-0550	NUT #8-32 S/S	4
7	176-0200	TEFLON TAPE (SS) ADHESIVE (436mm EA.)	1055
8	027-0400	CONNECTOR ADAPTOR	2

VENDOR: 350, 350D & 420A
 PART: SEAL BAR PRE-ASSEMBLY
 DATE: 97-09-03
 SCALE: SEE LIST
 NO: 005-0267

QTY	MACHINE
4	420A
2	350D
1	350

1005-0267

ITEM	PART #	DESCRIPTION	QTY.
1	002-0015	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0230	REFLEX BAND 2.5 MM (566mm EA.)	0.057
4	039-0270	"T" PROFILE CUT. ELEM. (566mm EA.)	0.057
5	052-0395	SET SCREW 1/4" - 20 X 5/16" (OVAL POINT)	4
6	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
7	051-0550	NUT #8-32 5/S	4
8	176-0200	TEFLON TAPE (SS) ADHESIVE (4.36mm EA.)	0.055
9	027-0400	CONNECTOR ADAPTOR	2



NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

MACHINE	QTY
420A	4
3500	2
350	1
300	1
MACHINE	

-BAG CUT OPTION-

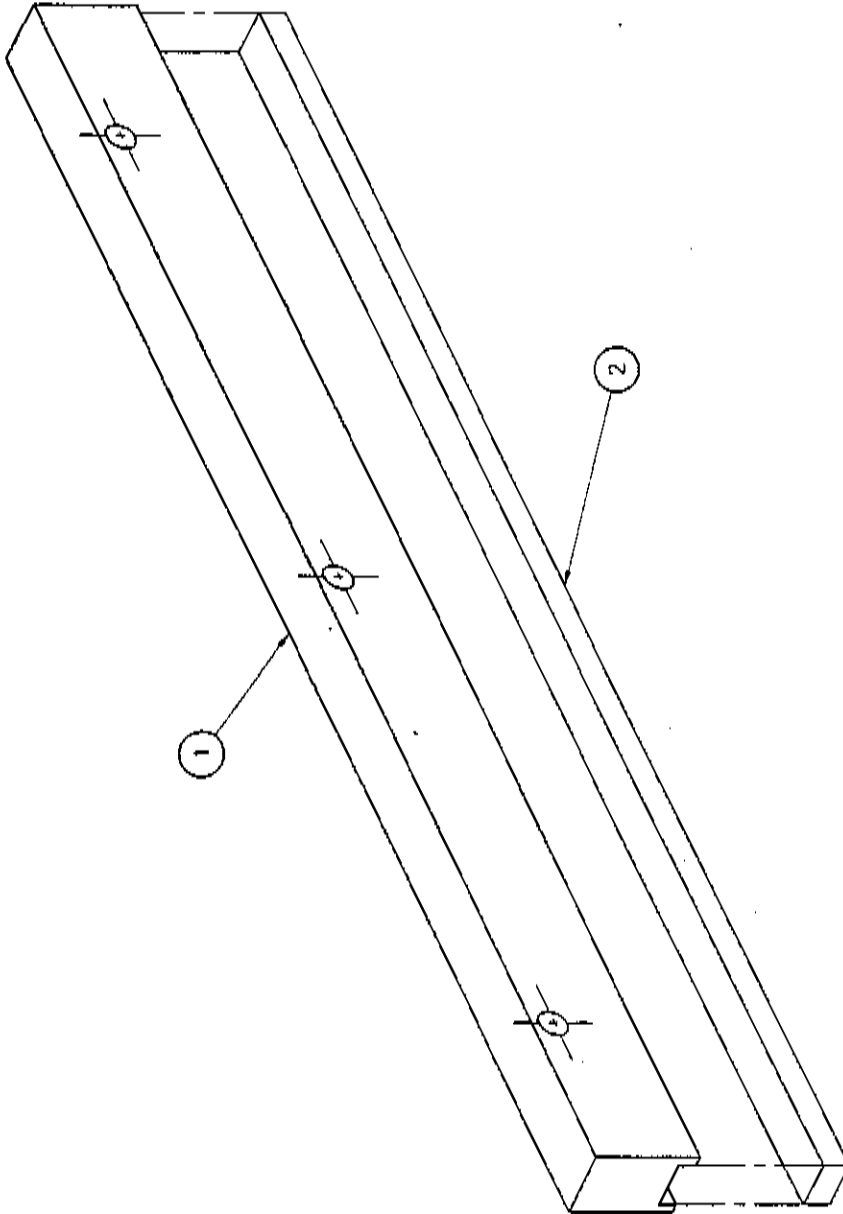
MACHINE	300, 350, 3500 & 420A	SCALE IN.	
PART	SEAL BAR PRE-ASSEMBLY	DATE	97-08-03
ITEM		DATE	
DATE		DATE	
BY		DATE	
APP.		DATE	

E	ADDED 300	98-05-03	L.M.
D	REDRAWN/ MODIF. A-0216	97-09-03	A.P.
REV.	MODIFICATION	DATE	INT.

SEE LIST
005-0382

1004A0126

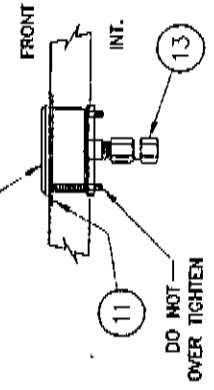
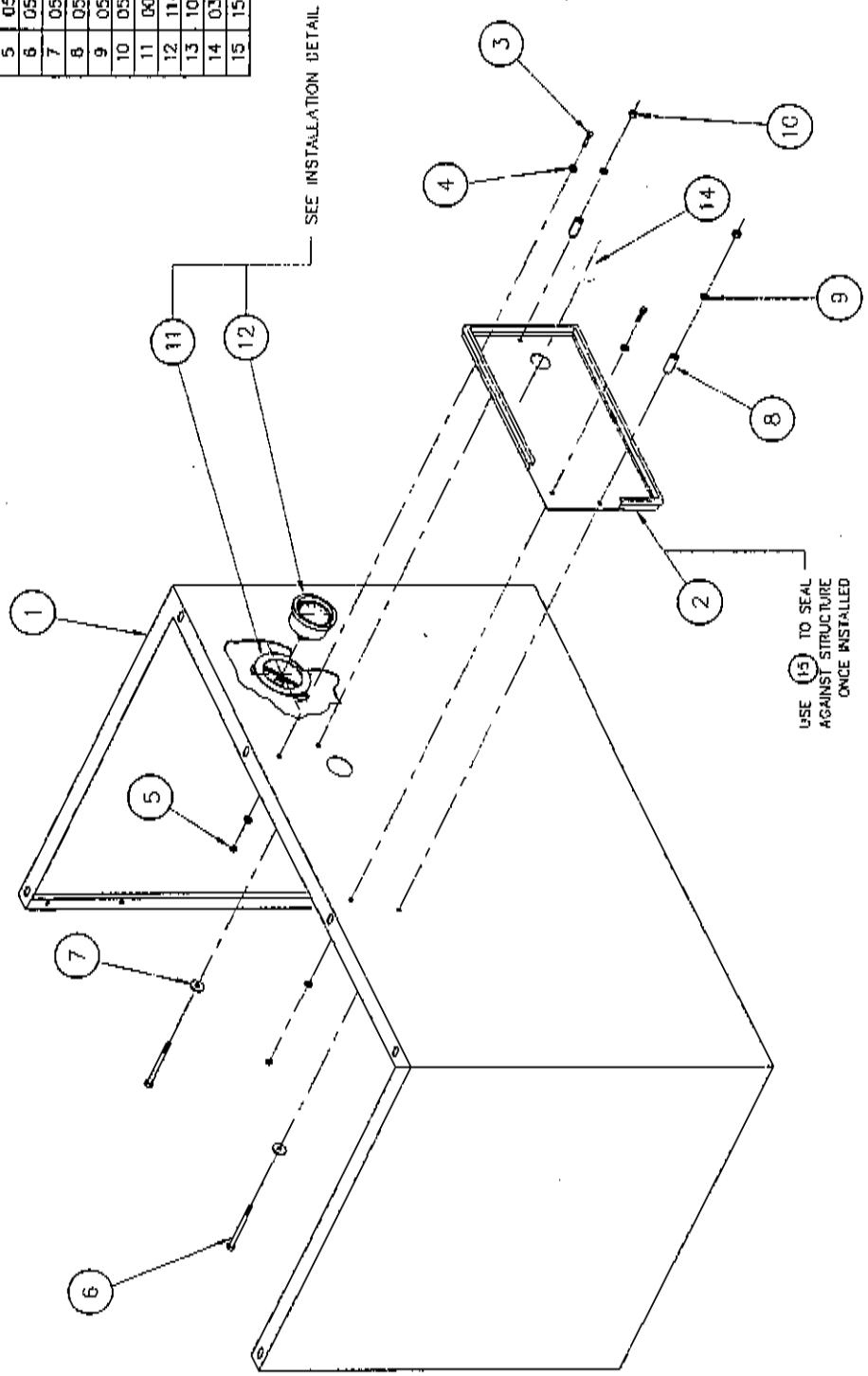
ITEM	PART #	DESCRIPTION	QTY.
1	002A0406	UPPER SEAL BAR SUPPORT	1
2	008-0316	UPPER SEAL BAR RUBBER	1



WZDRK	420A	REV. TOLERANCE	DATE 98-08-02	SCALE	PL 2
PART	UPPER SEAL BAR PRE-ASSY	DATE 98-08-02	NO.	004A0126	
ITEM		DATE 98-08-02	NO.		
DATE		DATE	NO.		

B	RECRWNY	98-08-02	S.L.
1.ET.	MODIFICATION	DATE	INT.

ITEM	PART #	DESCRIPTION	QTY.
1	004-0123	STRUCTURE PIRE-ASSY	1
2	005-0585	REAR MC-30 SUPPORT ASSY.	1
3	051-0160	BOLT 1/4" - 20 x 1/2"	2
4	051-0740	FLAT WASHER 1/4"	4
5	051-0581	NUT 1/4" - 20 NYLON LOCK	2
6	051-0270	BOLT 1/4" - 20 x 2 1/4"	2
7	051-0757	FLAT WASHER 1/4" THICK	2
8	058-0100	NYLON SPACER .5mm x 15mm x 30mm	2
9	051-0750	LOCK WASHER 1/4"	2
10	051-0580	NUT 1/4" - 20	2
11	001-1869	HOLDING WASHER (FOR VAC. GAUGE)	1
12	114-0260	VACUUM GAUGE W/ SUPPORT	1
13	101-0038	STR. 1/4" FNPT x 3/8" L.P. COMP. BR.	1
14	038-0213	GROMMET 1/4" ID x 1 1/2" O.D. RUBBER	1
15	154-0012	5200 MARINE ADHESIVE SEAL	.06



-INSTALLATION DETAIL-

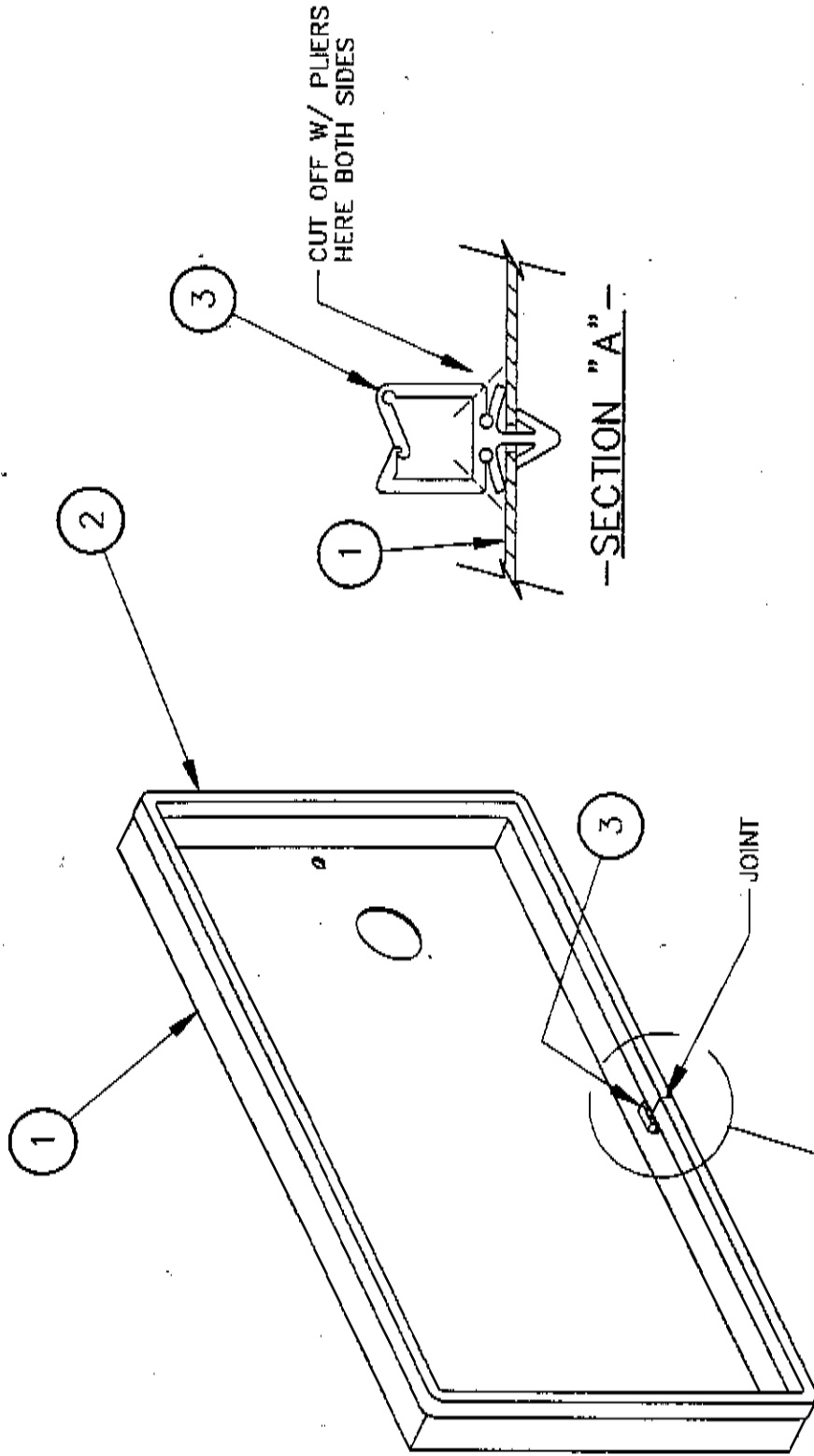
USE (15) TO SEAL AGAINST STRUCTURE ONCE INSTALLED

MACHINE: **420A**
 PART: **MC-30 STRUCTURE ASSY**
 ITEM: **MC-30 STRUCTURE ASSY**
 DATE: **98-11-04**
 DRAWN BY: **[Signature]**
 CHECKED BY: **[Signature]**
 APPROVED BY: **[Signature]**
 MATERIAL: **ALUMINUM**
 FINISH: **N.T.S.**
 QUANTITY: **1**
 UNIT: **QTY.**
 PART NO.: **1005-0456**

LET.	MODIFICATION	DATE	INT.

005-0585

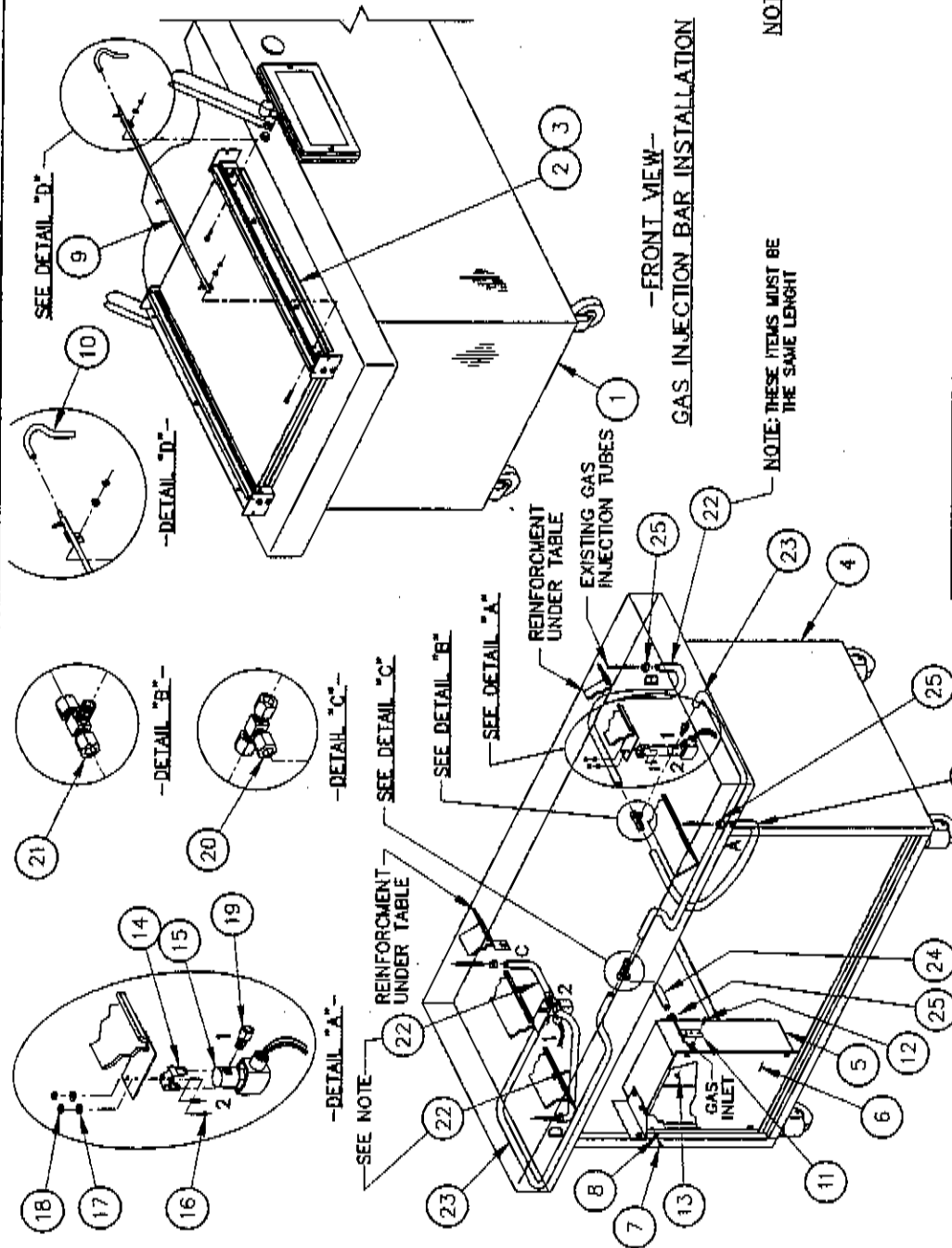
ITEM	PART #	DESCRIPTION	QTY.
1	004-0115	REAR P.C. BOARD SUPPORT PRE-ASS'Y	1
2	179-0014	RUBBER 1/4" X 3/8" X 1/16" (U SHAPED)	1
3	057-0002	CABLE TIE HOLDER	1



SEE SECTION "A"

MACHINE	420A, 450T, 450A, 550A & 580A	METRIC TOLERANCE	0. ± .5 0.00 ± .005 0.00 ± .005 0.00 ± .0006 ANGLE ± 1°	INCH TOLERANCE	.0 ± .015 .00 ± .005 .000 ± .0005 N.T.S.	SCALE	1
PART	REAR P.C. BOARD SUPPORT ASS'Y	DATE	98-05-15	DATE	98-05-05	NO.	005-0585
ITEM:	004-0584	DATE	98-05-15	DATE			
MAT:	MODIFICATION	DATE		DATE			
BY:	A. PROVENCHER	DATE		DATE			
APP:		DATE		DATE			

ITEM	PART #	DESCRIPTION	QT.
1	005-0336	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0046	SEAL BAR ASSY W/ SUPPORT	4
3	005-0558	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPT.)	4
4	005-0337	MACHINE ASSEMBLY REAR VIEW	1
5	005-0035	ELECTRICAL BOX ASSEMBLY	1
6	004-0281	ELECTRICAL BOX COVER PRE-ASSY	1
7	051-0180	HEX. BOLT 1/4" - 20 NC. X 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4" S/S	4
9	005-0042	GAS INJECTION BAR ASSEMBLY (OPTION)	4
10	008-0464	GAS INJECTION CONN. TUBE (OPTION)	4
11	005-0323	GAS INLET ASSEMBLY	1
12	051-0190	HEX. BOLT 1/4" - 20 NC. X 1/2" S/S (OPTION)	1
13	051-0580	HEX. NUT 1/4" - 20 NC. S/S (OPTION)	1
14		VALVE SUPP. SUPPLIED W/ (9)	2
15	106-0010	SELENOIDE VALVE 2 WAY 1/4" NPT	2
16	051-0100	SCREW #8-32 X 3/8" PAN PHILL. S/S	4
17	051-0720	FLAT WASHER #8 S/S	4
18	051-0550	HEX. NUT #8 S/S	4
19	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	2
20	101-0062	"T" 3/8" T.P.COMP.	1
21	101-0065	"T" 3/8" T.P.COMP. X 1/4" MNPT X 3/8" T.P.COMP.	2
22	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) min LG.	4
23	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) min LG.	2
24	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) min LG.	1
25	105-0200	COLLARS 3/8"	5



NOTE: - PARTS 1 THRU 8 ARE EXISTING PARTS
 - PARTS 9 THRU 25 ARE PARTS SUPPLIED W/ KIT

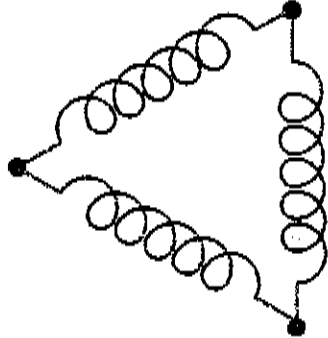
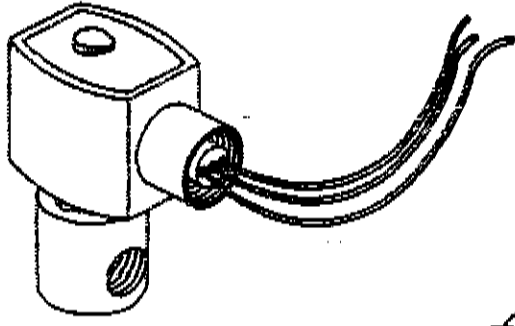
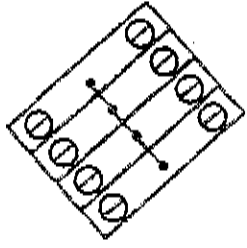
-OPTION GAS INJECTION-

MACHINE		420A	
PART		GAS INJECTION KIT INSTALLATION	
REV. NO.	DATE	REV. NO.	DATE
1	08-11-57	1	08-11-57
BY: A. PROVEDER		DATE: B7-08-11	
SCALE		1	
DRAWN		010-0016	

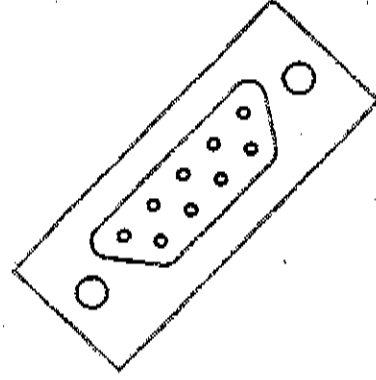
TO GAS INJECTION TUBES UNDER TABLE, REMOVE THE FOUR EXISTING CAPS & CONNECT HOSES A, B, C & D

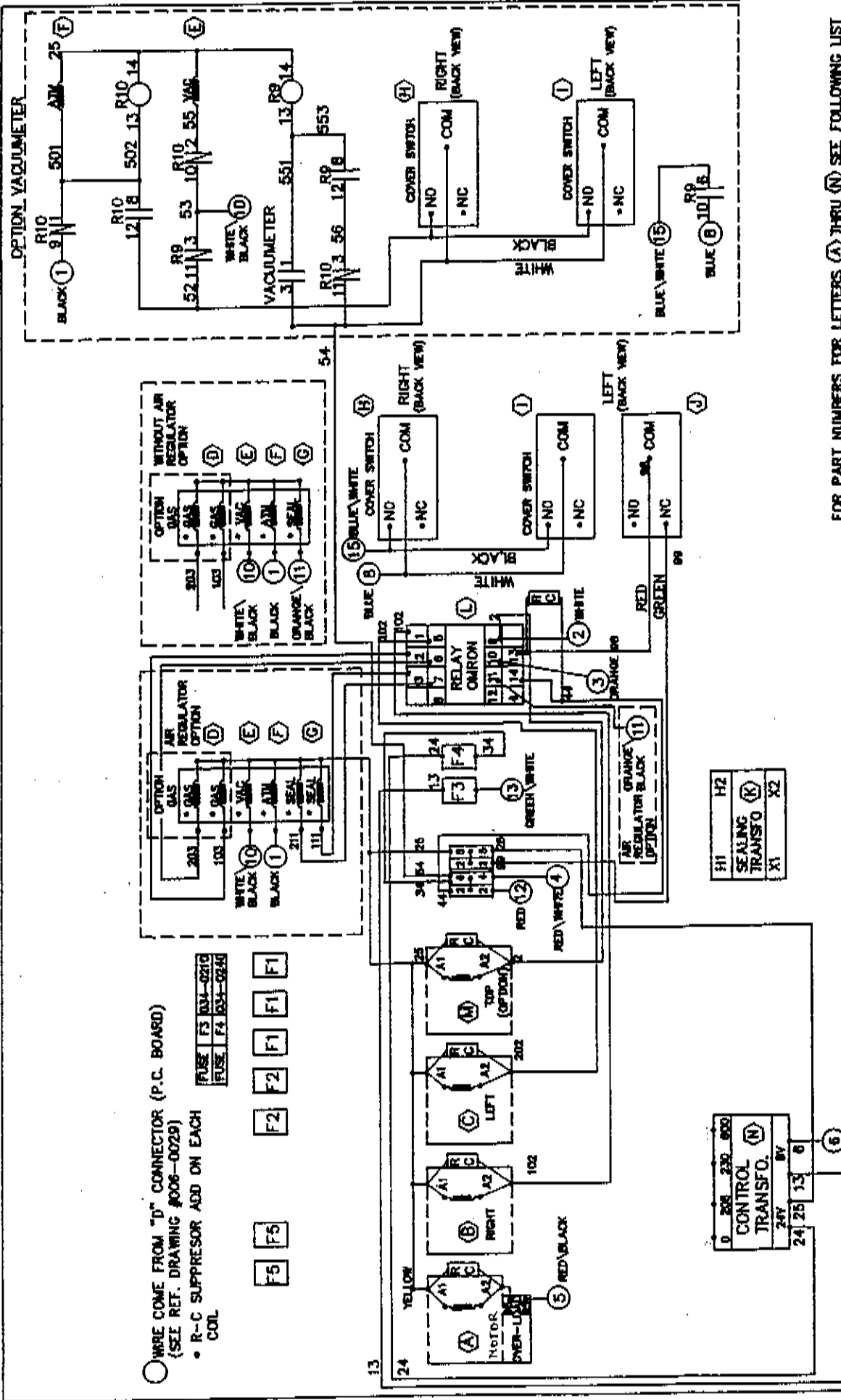
UNDER TABLE VIEW - VALVE INSTALLATION

LET.	C. REDRAWN/ MODIF. A-0217	DATE	87-08-11	A.P.
	MODIFICATION			INT.



ELECTRICAL DRAWING





FOR PART NUMBERS FOR LETTERS (A) THRU (N) SEE FOLLOWING LIST

MACHINE		420A, 600A & 620A	
TYPE		ELECT. WIRING LOW-VOLTAGE	
DT.	EDS.	SCALE	NE PAS MESURER / N.T.S.
MAT.	DATE	97-03-10	NO.
	APP.		
LET.	MODIFICATION	DATE	INT.
			006-0067

H1	H2
SEALING TRANSFO (K)	
X1	X2

0	206	230	600
CONTROL TRANSFO. (N)			
24V	24V	0V	
24	25	13	6

COLOR CODE SECONDARY(VAC)
 24V RED(WIRE #24 & #25)
 0V PURPLE(WIRE #6 & #13)

WIRE COME FROM "D" CONNECTOR (P.C. BOARD)
 (SEE REF. DRAWING #006-0029)
 • R-C SUPPRESSOR ADD ON EACH COIL

FUSE F3	03A-021G
FUSE F4	03A-021G

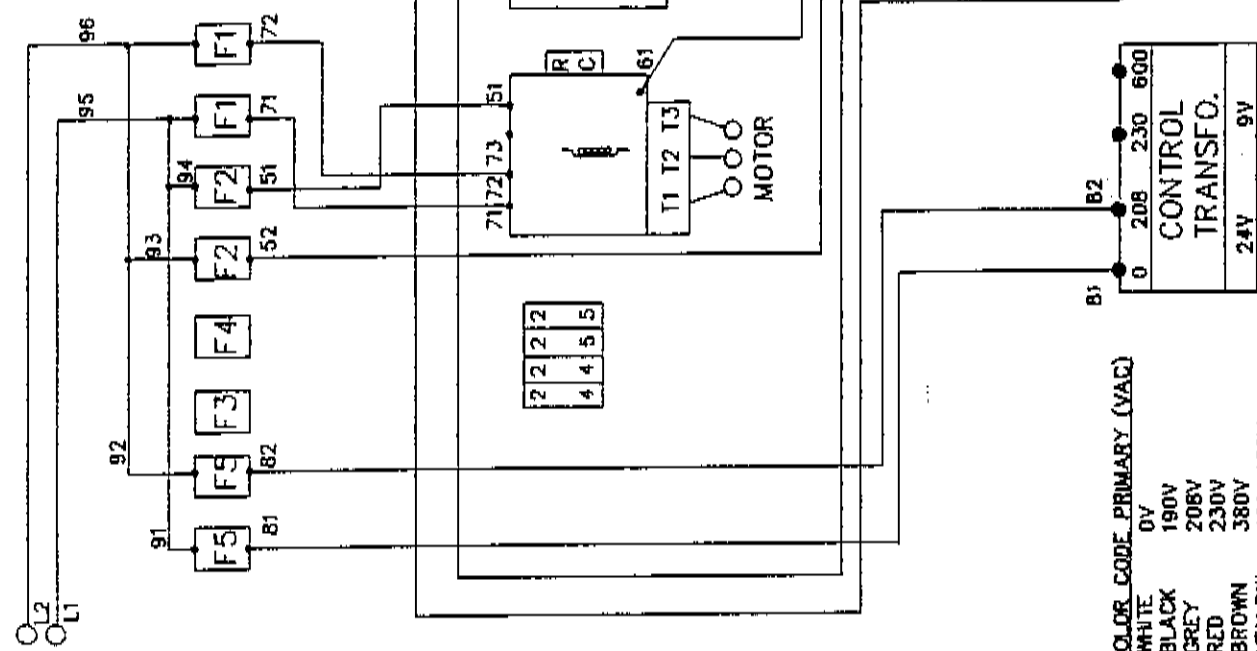
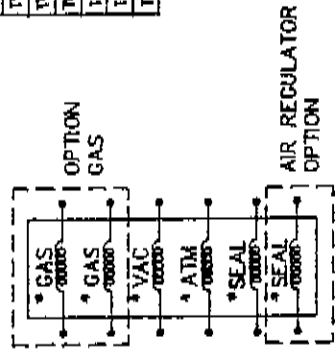
- F5
- F2
- F1
- F1
- F1

006-0068

* RC SUPPRESSOR ADD ON EACH COIL

PUMP		MOTOR (HP)	VOLT	FUSE F1
TWIN SEAL & BAG CUT	FUSE F2			
3	034-0450	3	230-1	034-0550
3	034-0430	3	230-3	034-0530
3	034-0425	3	575-3	034-0480
5	034-0500	5	230-1	034-0570
5	034-0485	5	230-3	034-0550
5	034-0440	5	575-3	034-0510

OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL & BAG CUT	230	034-0450	034-0200
TWIN SEAL & BAG CUT	380	034-0430	034-0410
TWIN SEAL & BAG CUT	600	034-0425	034-0410
TOP & BOTTOM SEAL	230	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0485	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410



COLOR CODE PRIMARY (VAC)

0V	WHITE
190V	BLACK
208V	GREY
230V	RED
380V	BROWN
460-480V	YELLOW
575-600V	BLUE

SECONDARY (VAC)

24V	RED
9V	PURPLE

MACHINE
420A, 600A & 620A

PIECE
ELECT. WIRING HIGH VOLTAGE 1

01. _____
DATE 97-03-10
APP. _____
NE PAS MESURER / N.T.S.

DESIGNER
U. LETOURNEAU
DATE 97-03-10
APP. _____

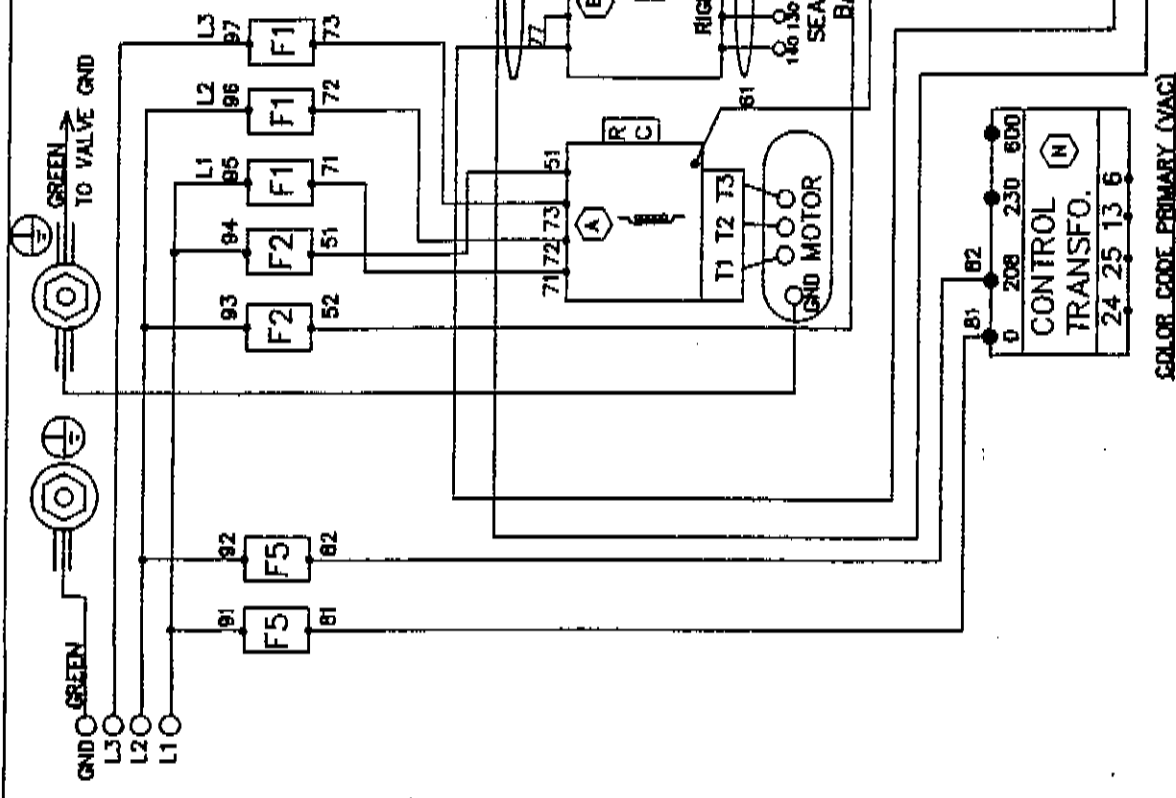
NO. 006-0068

1006-0069

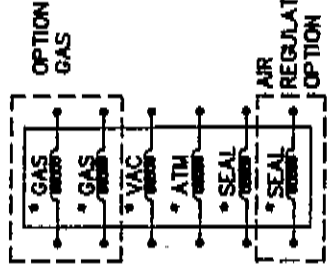
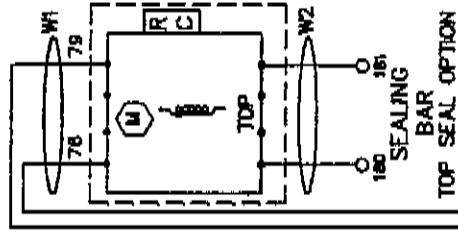
MOTOR (HP)	VOLT 4PH	FUSE F1
3	230-1	034-0560
3	230-3	034-0530
3	575-3	034-0480
5	230-1	034-0570
5	230-3	034-0500
5	575-3	034-0610

OPTION	VOLTAGE	FUSE F2	FUSE F3
TWIN SEAL	220	034-0460	034-0200
TWIN SEAL	380	034-0430	034-0410
TWIN SEAL	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0485	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

WIRE GAUGE
W1: TEW #10
W2: TEW #12



COLOR CODE PRIMARY (VAC)
 0 208 230 600
 CONTROL TRANSFO. (N)
 24 25 13 6
 0 208 230 600
 SEALING TRANSFO. (K)
 X1 24V X2
 H1 H2
 52
 61
 77 74
 75 76 78



2	2	2
4	4	5

F3

F4

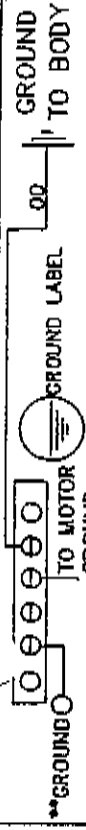
L
RELAY
OMRON

MACHINE 420A, 600A & 620A

ELECT. WIRING HIGH VOLTAGE 3φ

DATE	87-03-10
DATE	
NO.	006-0069

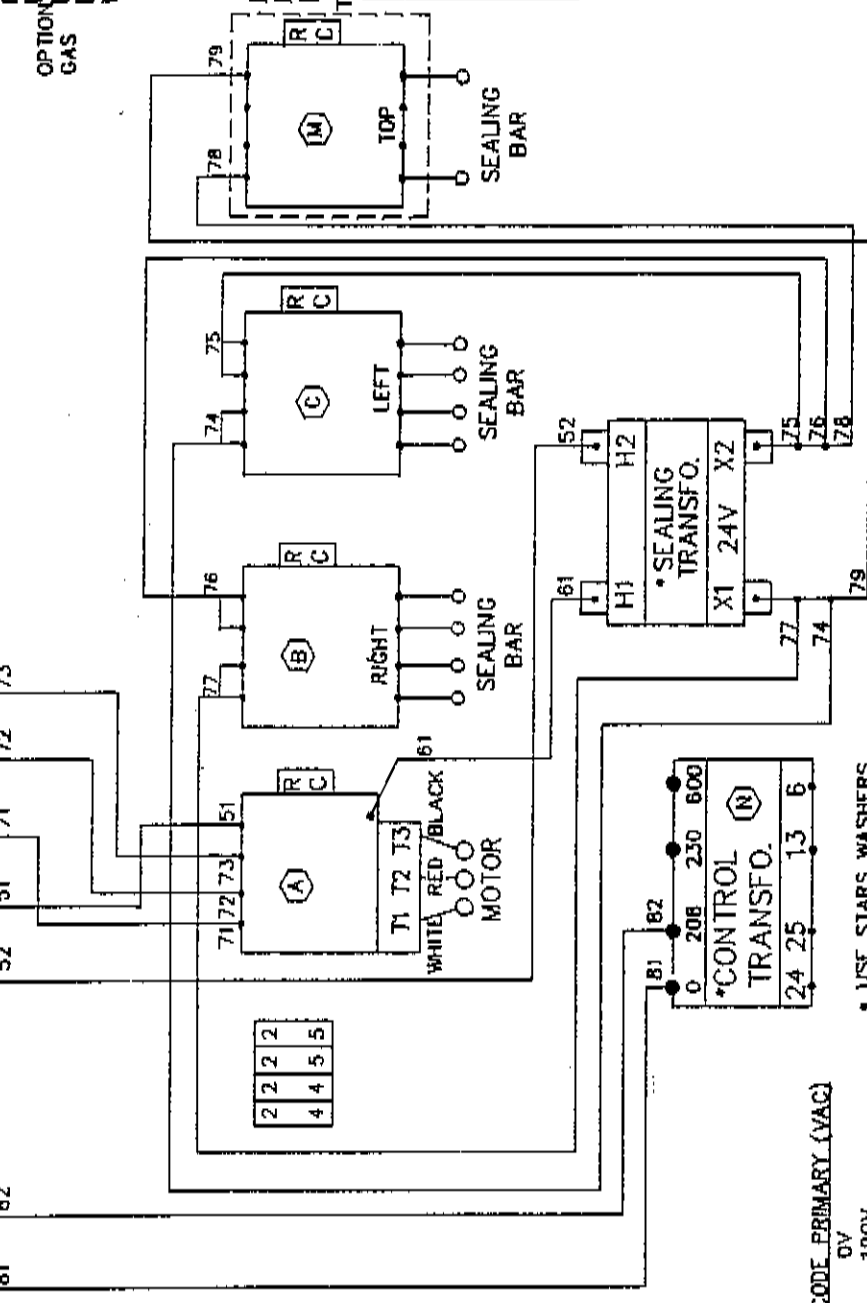
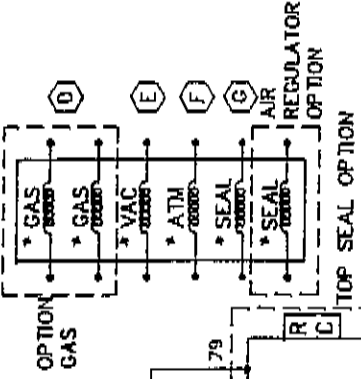
1006-0102



OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0450	034-0200
TWIN SEAL	360	034-0430	034-0410
TWIN SEAL	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	360	034-0465	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

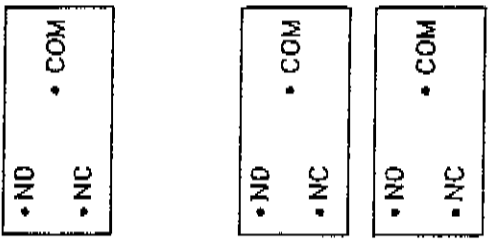
MOTOR (HP)	VOLT +ph	FUSE F1
3	230-1	034-0550
3	230-3	034-0530
3	575-3	034-0480
5	230-1	034-0570
5	230-3	034-0550
5	575-3	034-0610

* RC SUPPRESSOR ADD ON EACH COIL



- COLOR CODE PRIMARY (VAC)
- WHITE 0V
 - BLACK 190V
 - GREY 208V
 - RED 230V
 - BROWN 380V
 - YELLOW 460-480V
 - BLUE 575-600V
- SECONDARY (VAC)
- RED 24V
 - PURPLE 5V

* USE STARS WASHERS FOR TRANSFO. FIXATION.



420A, 600A & 620A

ELECT. WIRING HIGH VOLTAGE (50 HZ) 3ø

NE PAS MESURER / N.T.S.

DATE 06-10-02

006-0102

006-0029

ITEM #	PIECE	DESCRIPTION	QT.
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WIRING OF 15 PIN "D" CONNECTOR-VACUUM PACKAGING MACHINE

COLOR CODE

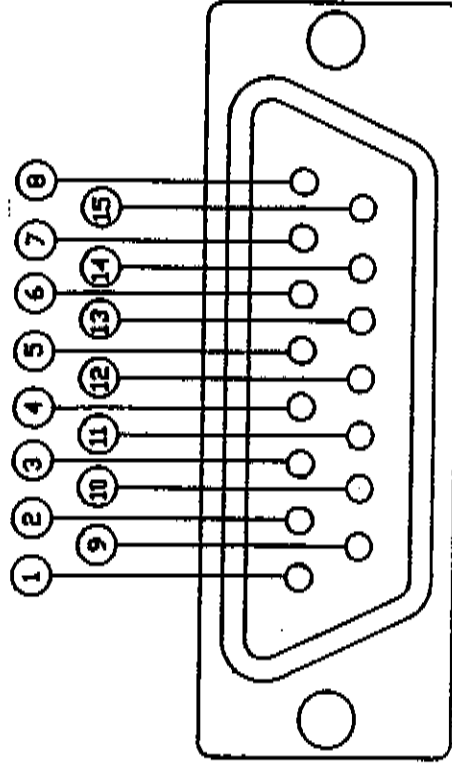
- ① BLACK : OUTPUT TO ATMOSPHERE VALVE
- ② WHITE : OUTPUT TO SEALING CONTACTOR
- ③ ORANGE : OUTPUT TO GAZ VALVE
- ④ RED/WHITE : CONTACT OF PC BOARD RELAY
ACTIVATES WHEN MACHINE IS ON
- ⑤ RED/BLACK : CONTACT OF PC BOARD RELAY
ACTIVATES WHEN MACHINE IS ON
- ⑥ GREEN : INPUT 9 VAC
- ⑦ ----- : JUMPED WITH ⑥
- ⑧ BLUE : TO COVER SWITCH
- ⑨ ----- : NOT USED
- ⑩ WHITE/BLACK : OUTPUT TO VACUUM VALVE OR CONT.
MOTOR 350,450A OR 550A)
- ⑪ ORANGE/BLACK : OUTPUT TO SEALING SELENOID VALVE
(250)
- ⑫ RED : INPUT 24 VAC
- ⑬ GREEN/WHITE : INPUT 9 VAC
- ⑭ ----- : JUMPED WITH ⑬
- ⑮ BLUE/WHITE : TO COVER SWITCH

JUMP

SEE NOTE

PC BOARD
RELAY

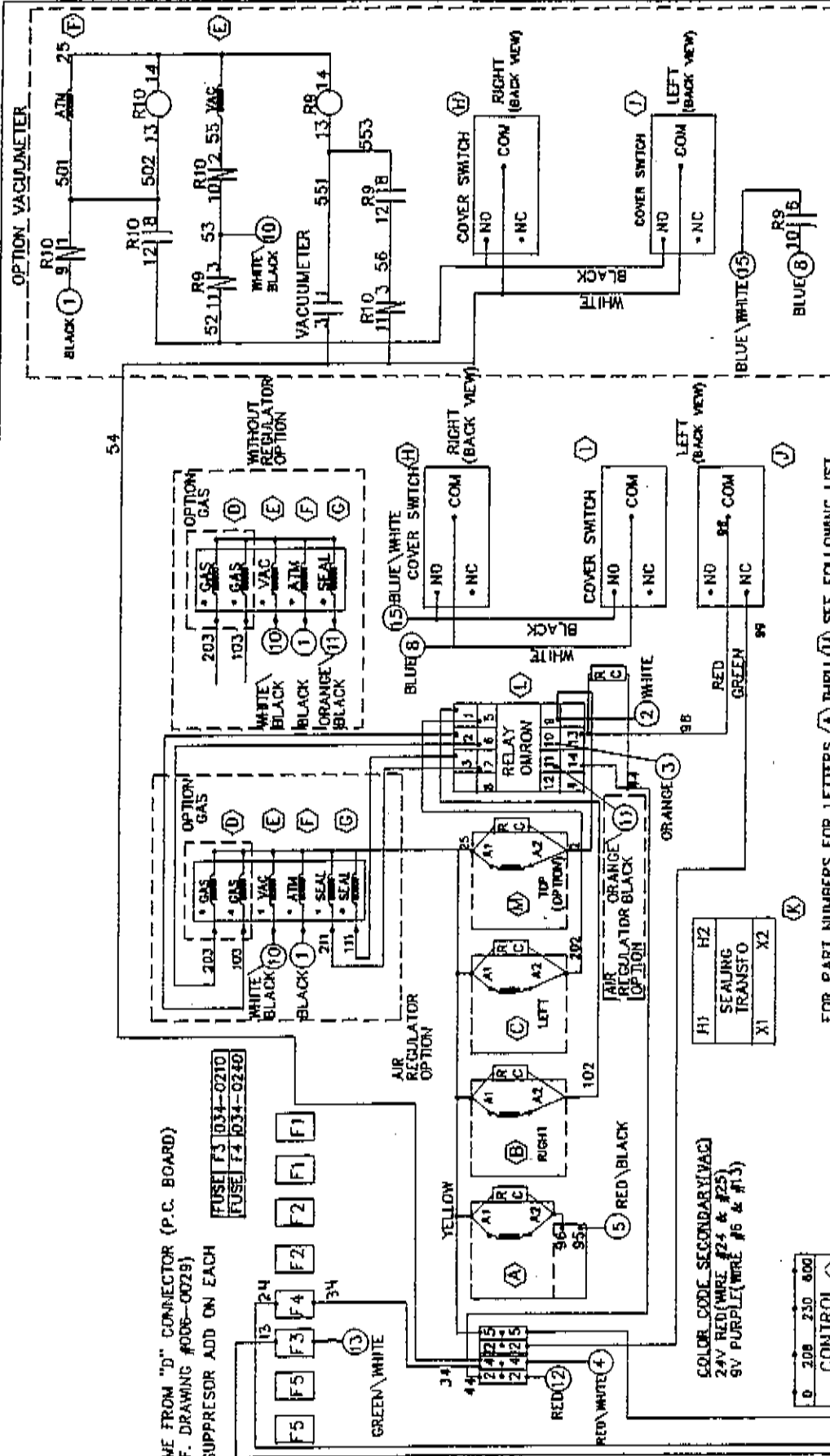
COVER
SWITCH



WIRE SIDE VIEW

NOTE: - JUMP ②④ FOR VACUUM : 250 350 450A 550A ONLY
-THIS CONNECTOR PLUGS IN AT REAR OF P.C. BOARD

MACHINE		VACUUMS	
PIECE "D" CONNECTOR DETAIL			
QT.	LOG. SCALE	NE PAS MESURER /N.T.S.	
DATE	DATE	DATE	DATE
95-01-31	95-11-07	95-11-07	95-11-07
D.I.	INT.		
RECESSIVE	MODIFICATION		
LET.			
			006-0029



WIRE COME FROM "D" CONNECTOR (P.C. BOARD)
 (SEE REF. DRAWING #006-0029)
 R-C SUPPRESSOR ADD ON EACH COIL

FUSE F3 034-0210
 FUSE F4 034-0240

COLOR CODE SECONDARY(VAC)
 24V RED(WIRE #24 & #25)
 9V PURPLE(WIRE #6 & #13)

CONTROL TRANSFO. (M)
 24V 9V
 24 25 13 6

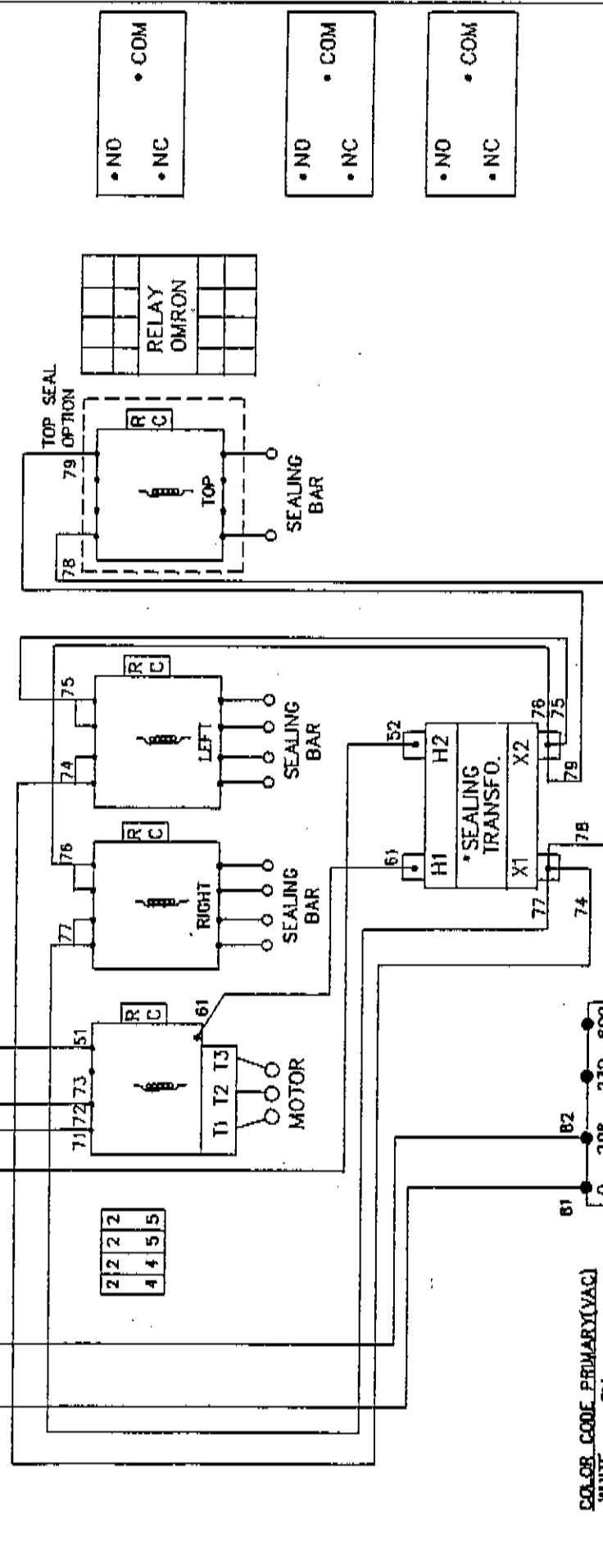
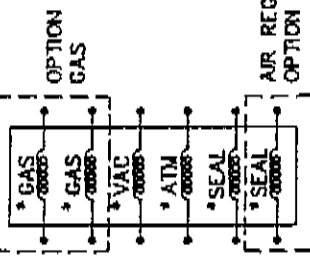
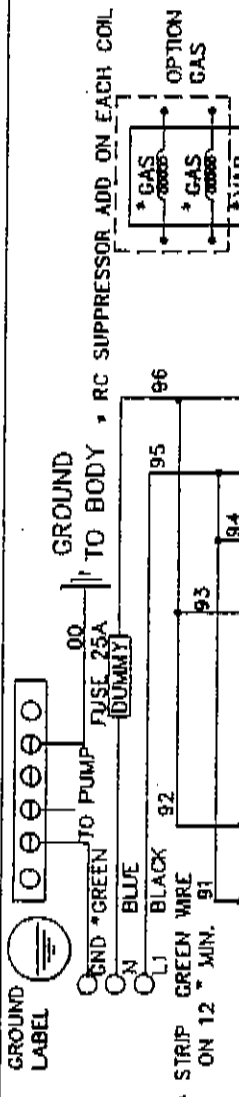
FOR PART NUMBERS FOR LETTERS (A) THRU (M) SEE FOLLOWING LIST

H1 SEALING TRANSFO. X1
 H2 TRANSFO. X2

MACHINE	420A, 600A & 620A	
PIECE	ELECT. WIRING LOW-VOLTAGE (50 HZ)	
QT.	EDH SCALE	NE PAS MESURER / N.T.S.
MAT.	DESS. D.L.	DATE 97-03-11
	APP.	DATE
LET.	MODIFICATION	NO. 006-0100

006-0101

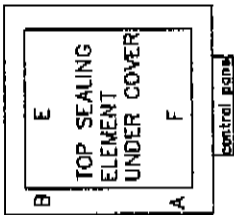
OPTION	VOLTAGE	FUSE F1	FUSE F3	MOTOR (HP)	PUMP
TWIN SEAL & BAG CUT	220	034-0480	034-0200	3	230-1
TWIN SEAL & BAG CUT	360	034-0430	034-0410	3	230-3
TWIN SEAL & BAG CUT	600	034-0425	034-0410	3	575-3
TOP & BOTTOM SEAL	220	034-0500	034-0200	5	230-1
TOP & BOTTOM SEAL	360	034-0485	034-0410	5	230-5
TOP & BOTTOM SEAL	600	034-0440	034-0410	5	575-3



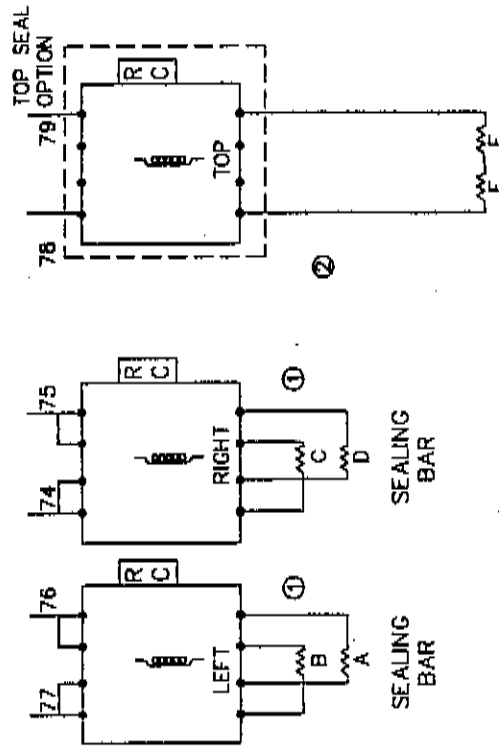
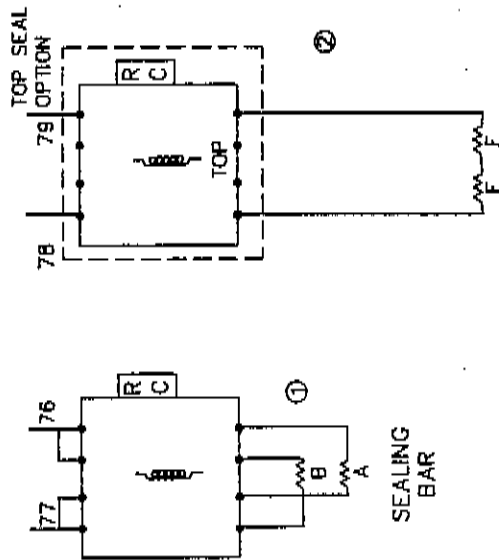
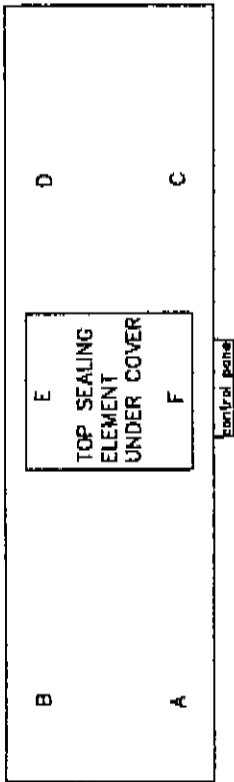
MACHINE		420A, 600A & 620A	
PIECE		ELECT. WIRING HIGH VOLTAGE 10.50 HZ	
DT.	ECH. SCALE	NE PAS MESURER / N.T.S.	
DATE	DATE	DATE	DATE
NO.	NO.	NO.	NO.
006-0101	006-0101	006-0101	006-0101

- COLOR CODE PRIMARY(VAC)
- WHITE 0V
 - BLACK 190V
 - GREY 208V
 - RED 230V
 - BROWN 380V
 - YELLOW 460-480V
 - BLUE 575-600V
- SECONDARY(VAC)
- RED 24V
 - PURPLE 0V
- * USE ONLY "STARS WASHERS" FOR TRANSFO. FIXATION.

SINGLE CHAMBER



DOUBLE CHAMBER



SEALING BAR

SEALING BAR

① WIRE TEW 12 AWG SIPROMAC # 030-0420

② WIRE CABTIRE 12/3 SJ SIPROMAC # 030-0120
CONNECTOR CD-13 SIPROMAC # 036-0409

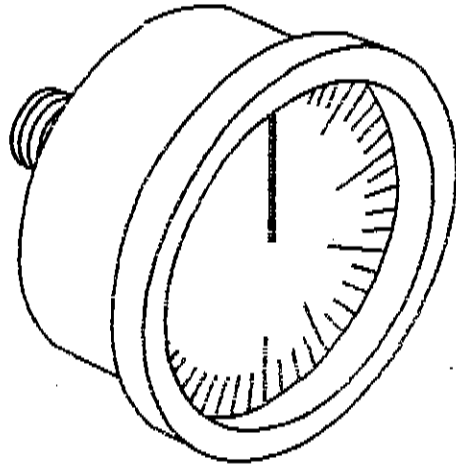
MACHINE		ALL MODEL	
PIECE		WIRING FOR SEALING BAR	
QT.	ECH.	NE PAS MESURER / N.T.S.	
	SCALE.	DATE	NO.
MAT:	APP.	12 DEC 2000	006-0131
		ERIC J. T.P.	

ELECTRICAL DRAWINGS PARTS LIST

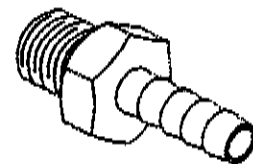
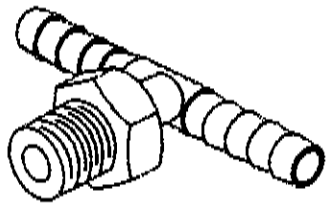
MODEL 420A

A: VOLT	PHASE	PUMP HP	CONTACTOR	OVERLOAD
220	1	2	025-0020	025-0190
220	3	2	025-0010	025-0170
380	3	2	025-0020	025-0150
575	3	2	025-0010	025-0140
220	1	3	025-0040	025-0190
220	3	3	025-0020	025-0180
575	3	3	025-0010	025-0150
220	1	4	025-0050	025-0200
220	3	4	025-0030	025-0190
460	3	4	025-0010	025-0170
575	3	4	025-0010	025-0160

B, C & O: SEALING CONTACTOR:	025-0020
D: OPTIONAL GAZ SOLENOID VALVE:	106-0010
E: VACUUM SOLENOID VALVE:	106-0030
F: ATMOSPHERE SOLENOID VALVE:	106-0030 WITH PUMPS: 2 HP, 3HP & 4HP
G: BELLOWS SOLENOID VALVE:	106-0070
H, I, J: COVER SWITCH:	026-0610
K: SEALING TRANSFO.:	
TWIN SEAL & BAG CUT:	029-0040, 029-0050
L: RELAY & BASE:	
RELAY:	025-0600
BASE:	025-0610
M: OPTIONAL TOP SEALING CONTACTOR:	025-0020
N: CONTROL TRANSFO.:	029-0007, 029-0008, 029-0009, 029-0250



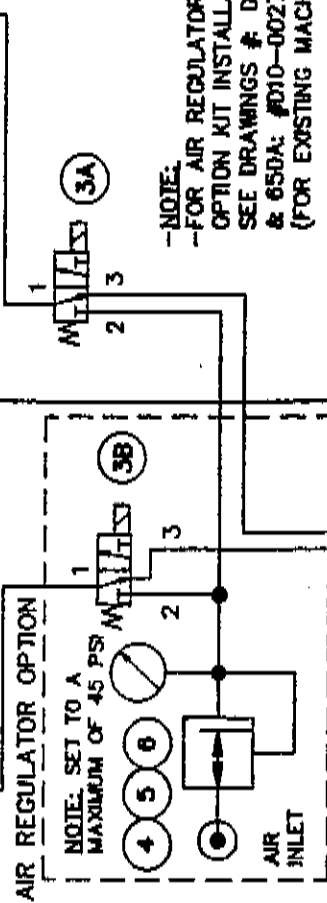
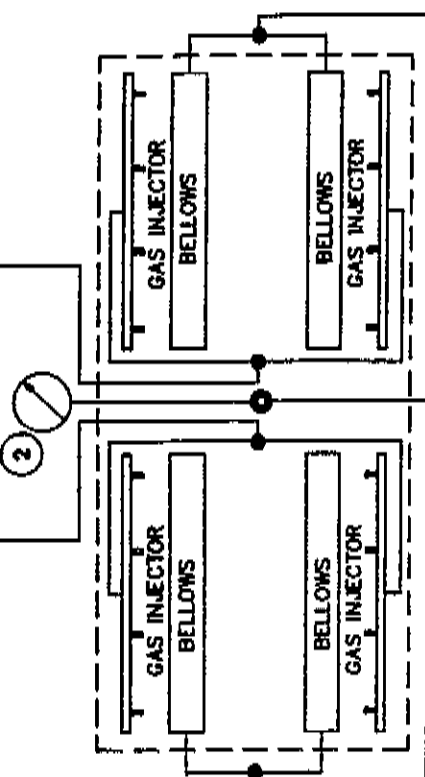
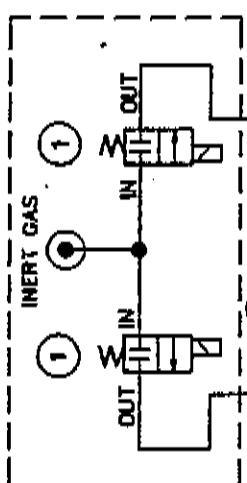
PNEUMATIC DRAWING



007-0019

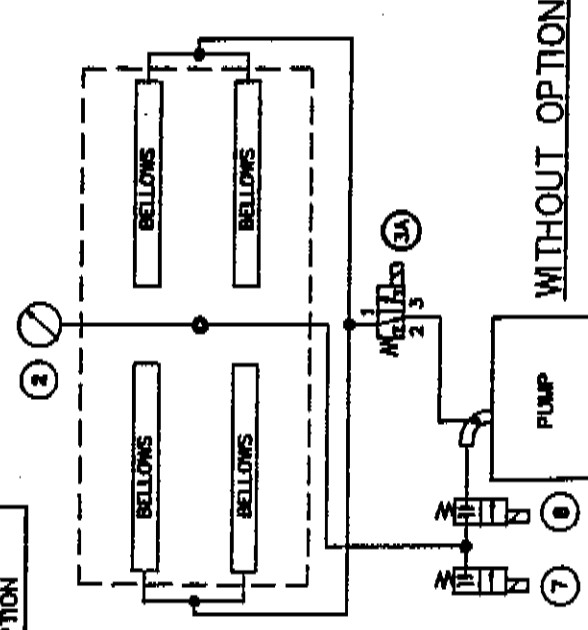
ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	2*
2	114-0280	VACUUM GAUGE	1
3A	106-0070	BELLOWS VALVE	1
3B	106-0070	BELLOWS VALVE	1*
4	114-0147	PRESSURE REGULATOR	1*
5	114-0245	PRESSURE GAUGE	1*
6	114-0170	PRESSURE REGULATOR SUPPORT	1*
7	106-0030	ATMOSPHERE VALVE FOR 420A	1
	106-0030	ATMOSPHERE VALVE FOR 600A, 663M ³ AND 100 M ³	
	106-0050	ATMOSPHERE VALVE FOR 800A & 820A 160M ³ AND 250 M ³	
8	106-0050	ATMOSPHERE VALVE FOR 650A & 700A	1
	106-0030	VACUUM VALVE FOR 420A	
	106-0050	VACUUM VALVE FOR 600A & 620A	
* OPTION			

GAS INJECTION KIT INSTALLATION
SEE DRAWINGS #:
420A: #D10-0016
600A: #D10-0017
620A: #D10-0018
650A: #D10-0020



NOTE: SET TO A MAXIMUM OF 45 PSI

WITH OPTIONS



WITHOUT OPTION

MACHINE 420A, 600A, 620A & 650A		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART PNEUMATIC		N.T.S.	
ITEM	QTY	SCALE	QT.
97-03-11	1		1
RE-DRAWN	DATE	BY	DATE
LET.	MODIFICATION	DATE	DATE
M. LAVIGNE		M. LAVIGNE	
DATE 97-03-11		DATE 97-03-11	
007-0019		007-0019	

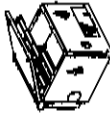
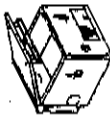
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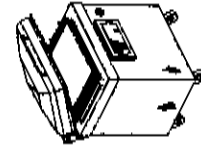
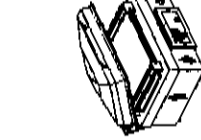
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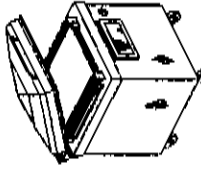
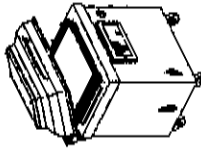
350/350D



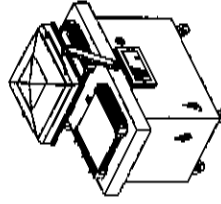
450T



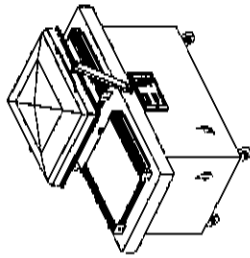
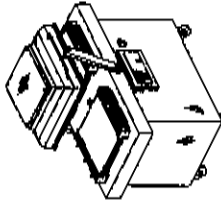
450A



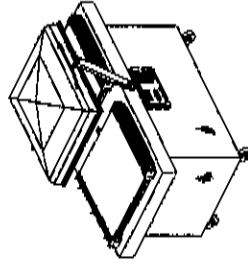
550A



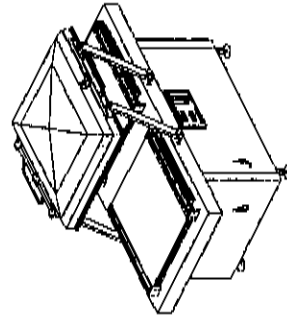
420A



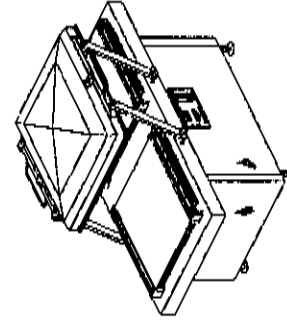
600A



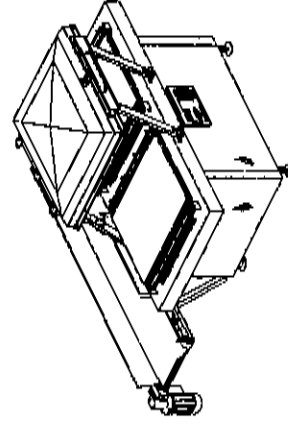
620A



650A



650A AUTOMATIC



700A

VACUUM PACKAGING MACHINES