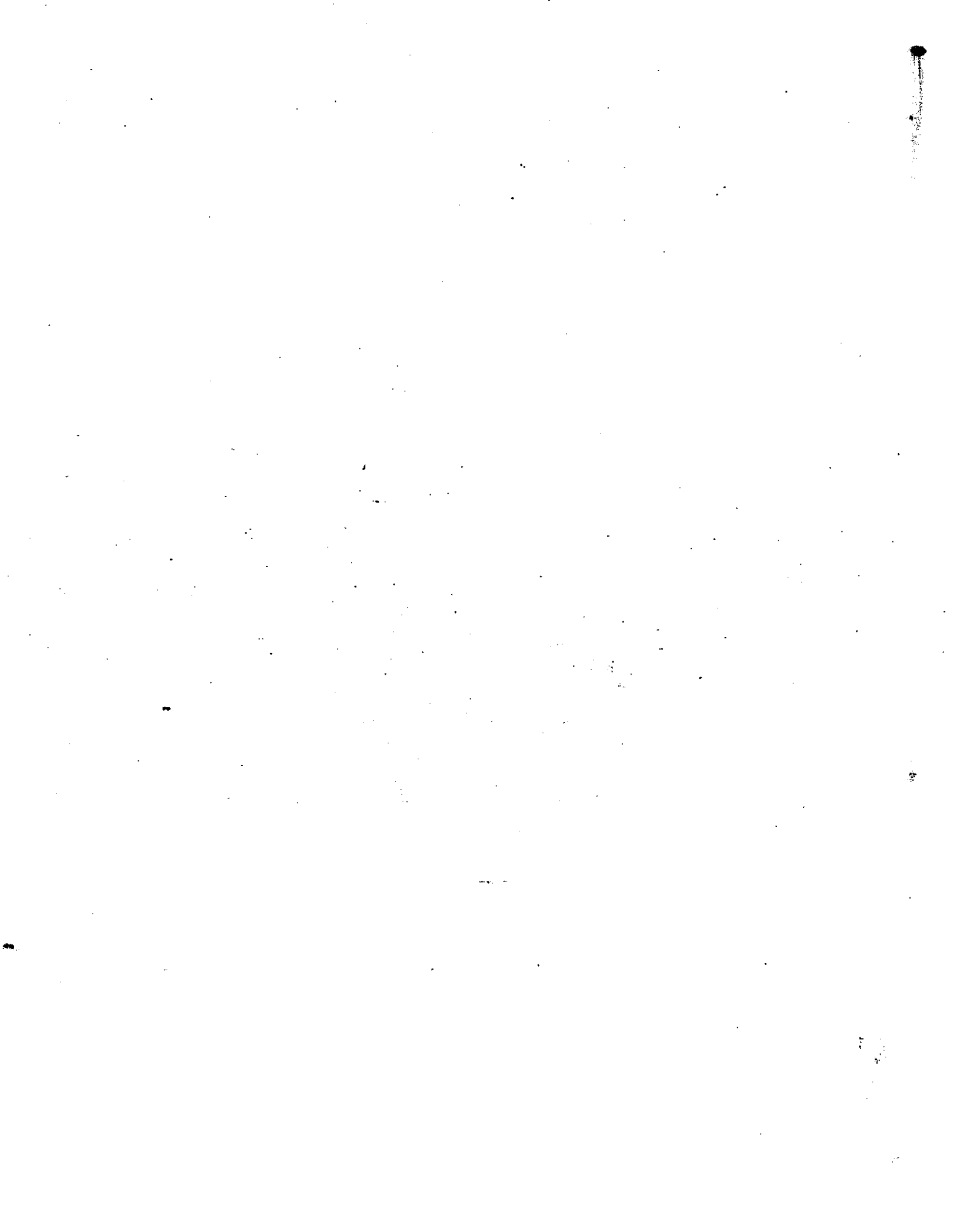


MODEL 420A
(MC-40)



VACUUM PACKAGING MACHINE

MODEL 420A

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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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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.

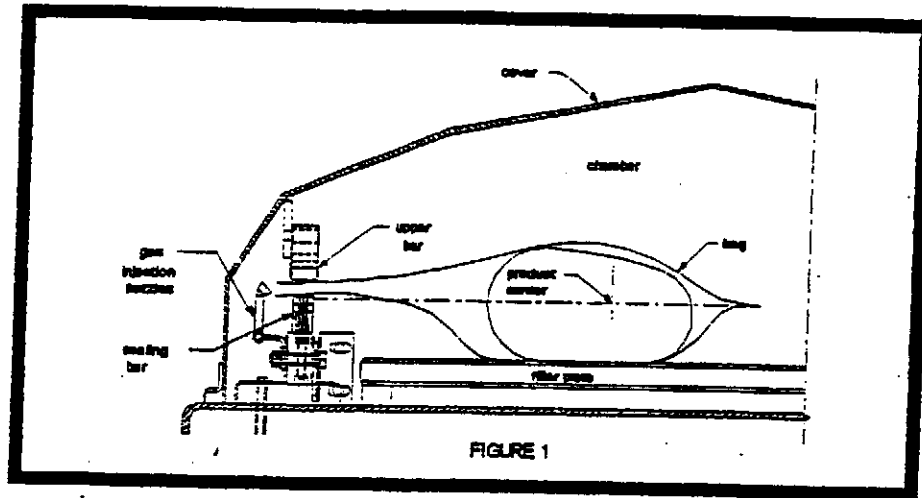
3. OPERATION:

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 level (%) can be set in the program menu.

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.

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 8 and the keyboard detail on page 9.

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.

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 → keys 2, 2, ENTER → E
(9 characters) → 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 level setting:

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

3.3.3.3 Vacuum plus time setting:

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

3.3.3.4 Gas flush level setting:

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.

3.3.3.5 Sealing time setting:

For a selected program set the sealing time, 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:

- chamber vacuum level during vacuum sequence,
- vacuum plus time status during vacuum plus sequence,
- chamber vacuum level during gas flush sequence,
- sealing time status during sealing sequence,
- chamber vacuum level during atmosphere sequence.7

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.x%"	(10.0% - 99.5%)
	"VACUUM PLUS: xxs"	(0s - 99s)
(units with gas option)	"GAS FLUSH: xx.x%"	(0.0% - 10% below the vacuum level)
	"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 LOADING TIME" (automatic units only)

"D8 UNLOADNG TIME" (automatic units only)

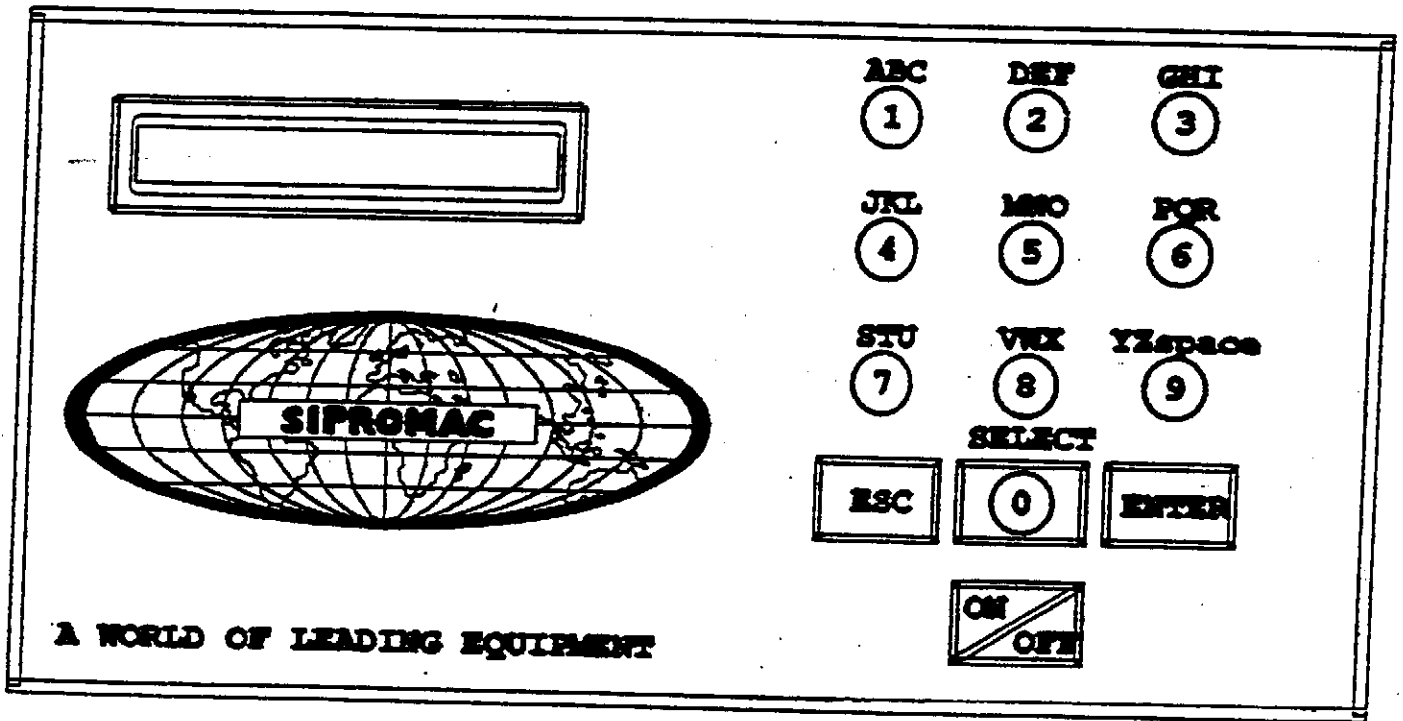
"SYSTEM MONITOR" (no access code required)

"SOFTWARE: R x.xx"

"WORK HRS: xxxxx"

"CYCLES: xxxxxxxx"

-KEYBOARD DETAILS-



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 packaging cycle:

4.1.1 "VACUUM ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the vacuum sequence within a preset period of time.

- Check vacuum lines for potential leaks or kinks.

4.1.2 "GAS FLUSH ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the gas flush sequence within a preset period of time.

- Check gas flush and vacuum lines for potential leaks or kinks.

4.1.3 "ATMOSPHERE ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the atmosphere sequence within a preset period of time.

- Check vacuum lines for potential leaks or kinks.

4.1.4 "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.

Evacuation 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 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 MC40 Control board failure

NOTE: Refer to menu structure on page 8.

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 connection 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:

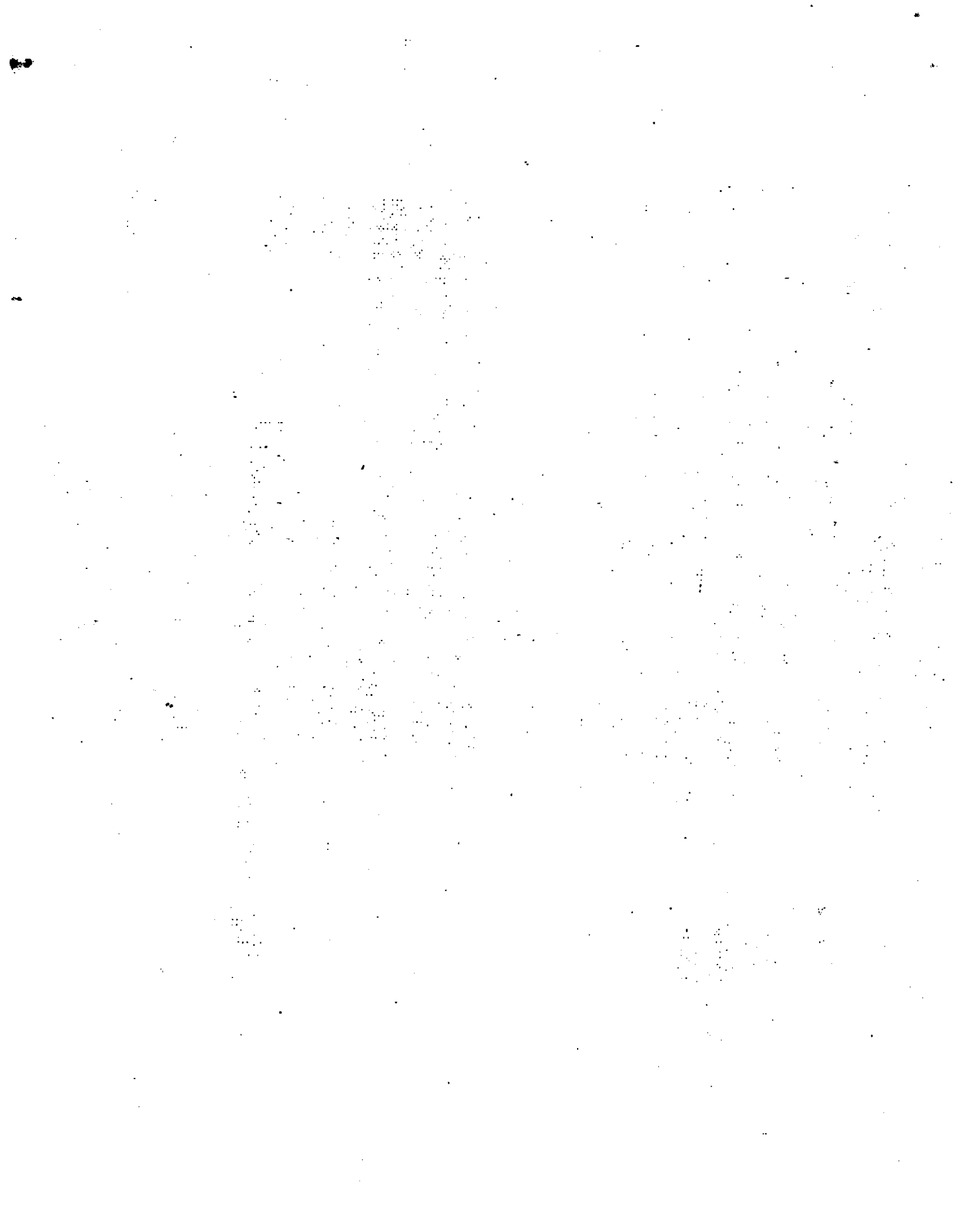
Routine controls to be made at regular intervals:

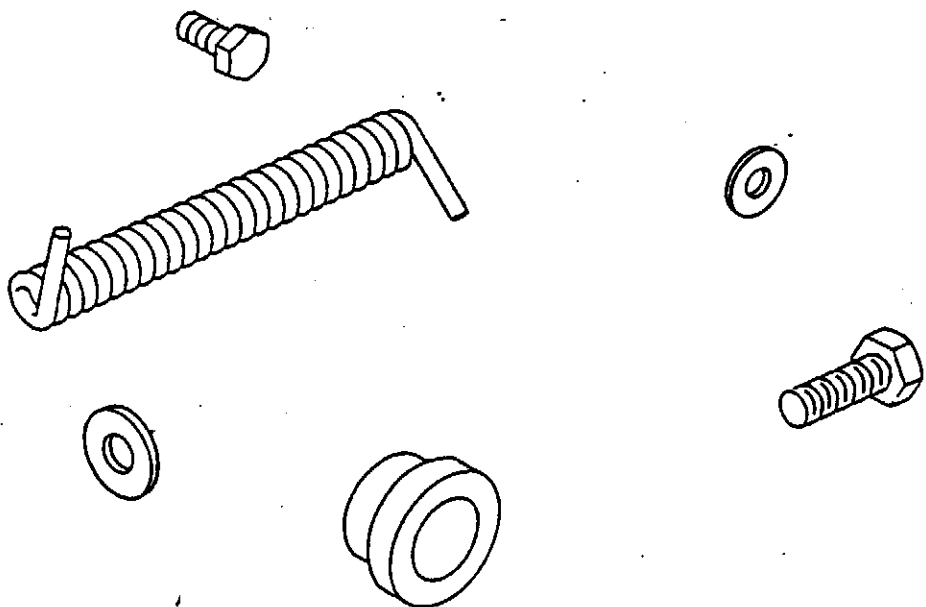
- Check teflon for wear.
- Check silicone rubber for burnt spots and smooth even position.
- Check pressure bar for jamming.
- Check lid sealing for damage and hardened spots.
- Check switch-point of micro switch, adjust if necessary.
- Check evacuation hose for damage (contraction of diameter, or abrasions).
- 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 vacuummeter.
- Check function of cycle with various settings of timers.

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

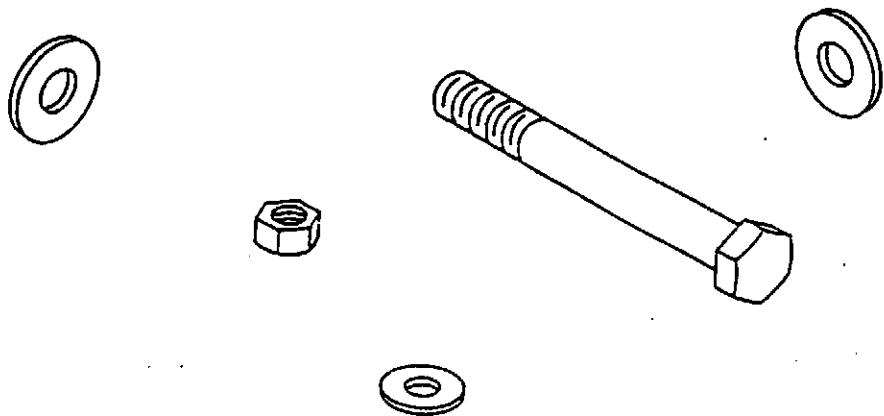
IN ORDER TO RESPECT NSF REGULATIONS:

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.

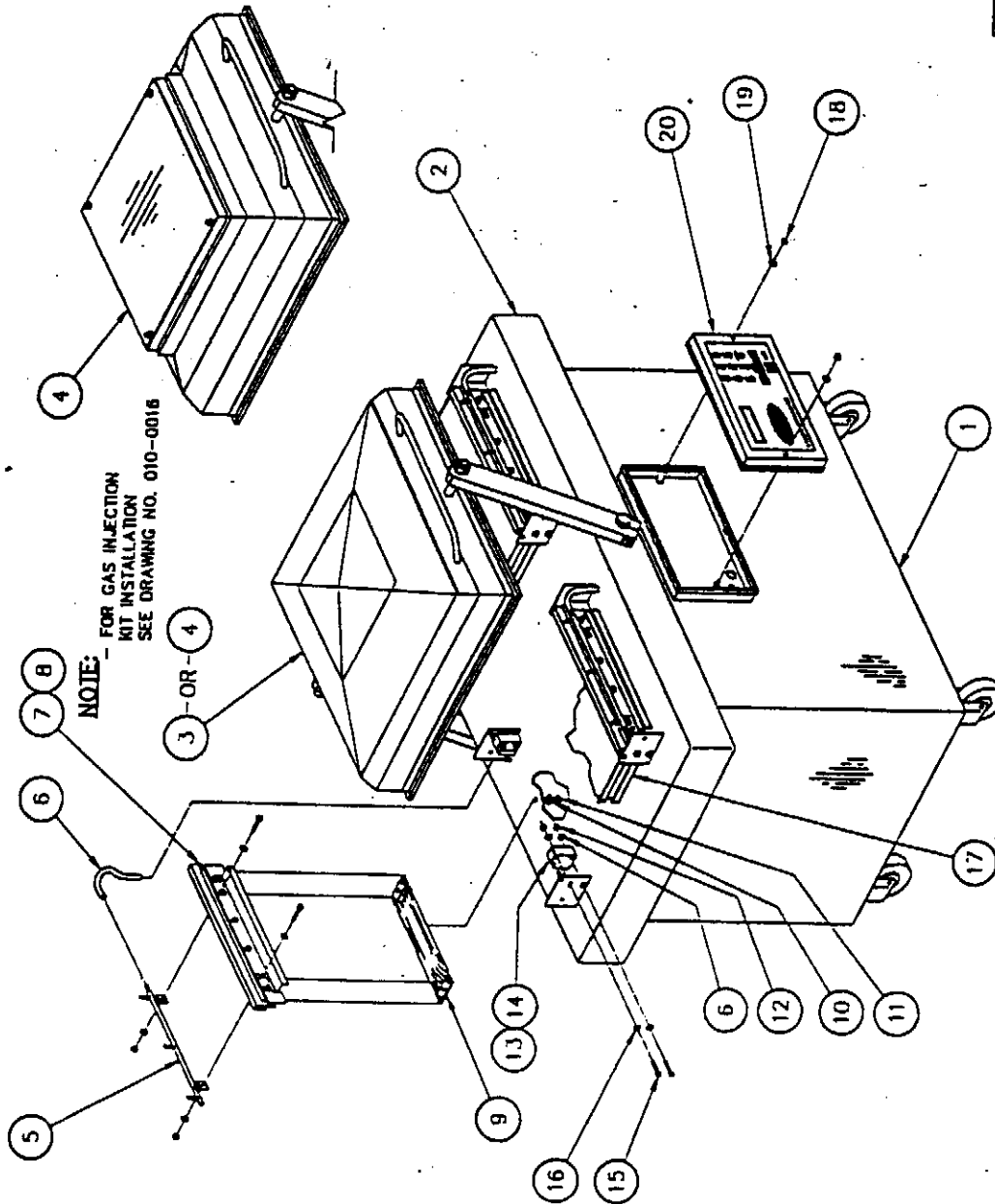




MECHANICAL DRAWING

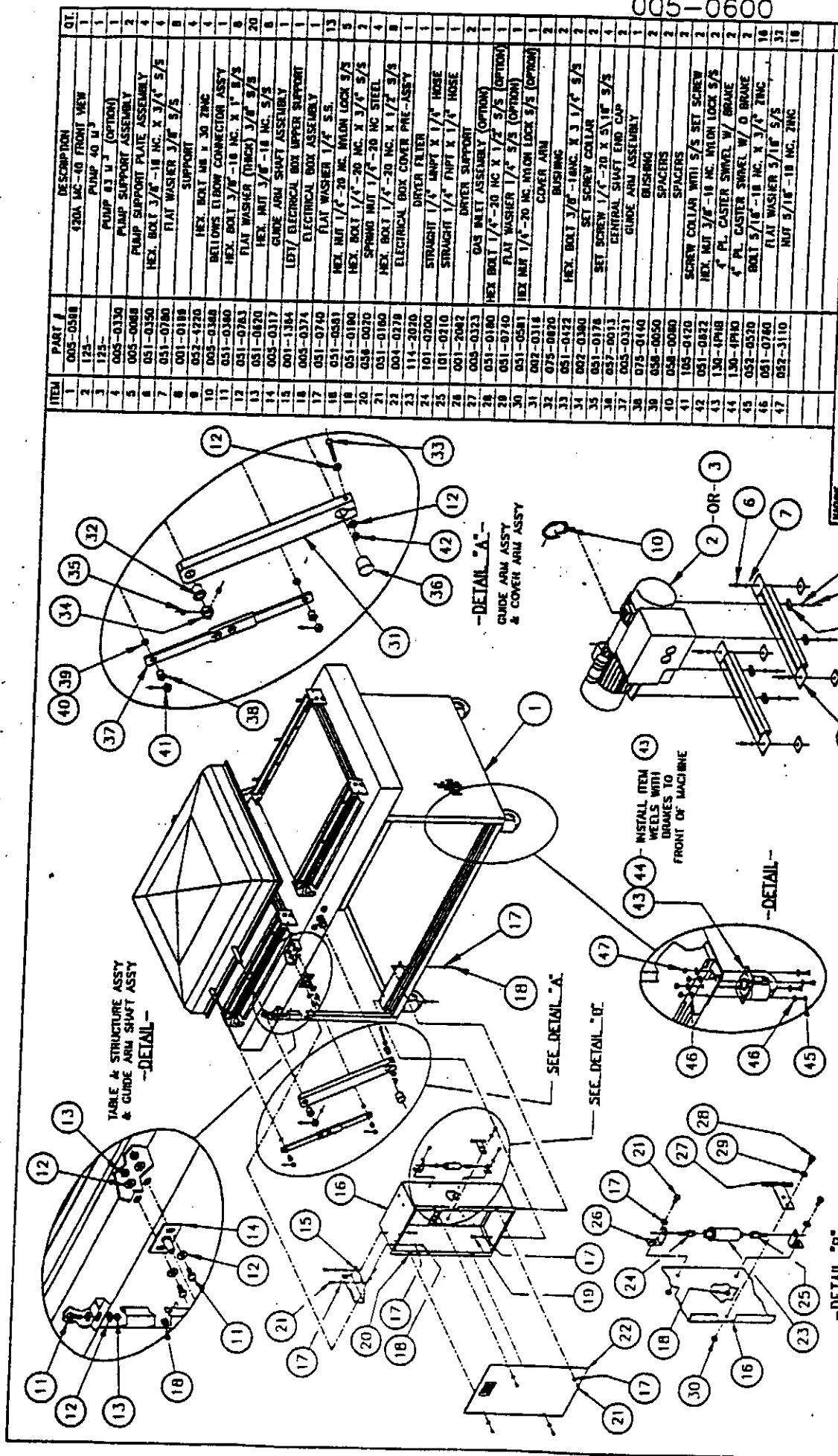


ITEM	PART #	DESCRIPTION	QT.
1	005-0589	MC-40 STRUCTURE ASSEMBLY	1
2	005-0327	TABLE ASSEMBLY	1
3	005-0455	6" COVER ASSEMBLY	1
4	005-0476	6" COVER ASSEMBLY (PLEXI OPTION)	1
5	005B0042	GAS INJECTION BAR ASSEMBLY (OPTION)	1
6	008-0484	GAS INJECTION CONN. TUBE (OPTION)	4
7	005-0048	SEAL BAR ASSY W/ SUPPORT	4
8	005-0558	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPTION)	4
9	005-0331	BELLOWS ASSEMBLY	4
10	051-0780	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. NYLON LOCK S/S	16
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	16
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	005-0583	P.C. BOARD SUPPORT ASSEMBLY	1



-OPTION MC-40-

DRAWING NO. 420A		SCALE 1	
PART NO. 420A MC-40 FRONT VIEW		DATE 88-05-28	
DESIGNED BY		DRAWN BY	
CHECKED BY		DATE	
APPROVED BY		SCALE	
SIPROMAC		005-0598	
ST-GERMAIN DE GRANTHAM		QUEBEC CANADA	
N.T.S.		DATE	



ITEM	PART #	DESCRIPTION	QT.
1	005-0388	420A MC-40 FRONT VIEW	1
2	125-	PUMP 40 H ₃	1
3	125-	PUMP 43 U ₃ (OPTION)	1
4	005-0330	PUMP SUPPORT ASSEMBLY	2
5	005-0088	PUMP SUPPORT PLATE ASSEMBLY	1
6	051-0350	HEX. BOLT 3/8" - 18 NC. X 3/4" S/S	4
7	051-0740	FLAT WASHER 3/8" S/S	8
8	001-0189	SUPPORT	1
9	052-4720	HEX. BOLT 1/2" X 30 ZINC	4
10	005-0368	BELLOWS ELBOW CONNECTION ASSY	4
11	051-0360	HEX. BOLT 3/8" - 18 NC. X 1" S/S	8
12	051-0743	FLAT WASHER (THICK) 3/8" S/S	20
13	051-0620	HEX. NUT 3/8" - 18 NC. S/S	8
14	003-0317	GUIDE ARM SHAFT ASSEMBLY	1
15	001-1344	LEFT ELECTRICAL BOX UPPER SUPPORT	1
16	003-0374	ELECTRICAL BOX ASSEMBLY	1
17	051-0740	FLAT WASHER 1/4" S.S.	13
18	051-0541	HEX. NUT 1/4" - 20 NC. NYLON LOCK S/S	5
19	051-0190	HEX. BOLT 1/4" - 20 NC. X 3/4" S/S	5
20	036-0070	SPRING NUT 1/4" - 20 NC STEEL	4
21	051-0160	HEX. BOLT 1/4" - 20 NC. X 1/2" S/S	8
22	004-0278	ELECTRICAL BOX COVER PRE-ASSY	1
23	114-2020	DRYER FILTER	1
24	101-0700	STRAIGHT 1/4" NPT X 1/4" HOSE	1
25	101-0210	STRAIGHT 1/4" NPT X 1/4" HOSE	1
26	001-2042	DRYER SUPPORT	2
27	005-0323	GAS MALT ASSEMBLY (OPTION)	1
28	051-0180	HEX. BOLT 1/4" - 20 NC X 1/2" S/S (OPTION)	1
29	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
30	051-0581	HEX. NUT 1/4" - 20 NC. NYLON LOCK S/S (OPTION)	1
31	002-0318	COVER ARM	2
32	075-0020	BUSHING	2
33	051-0422	HEX. BOLT 3/8" - 18 NC. X 3/4" S/S	2
34	002-0360	SET SCREW COLLAR	2
35	051-0176	SET SCREW 1/4" - 20 X 5/16" S/S	4
36	052-0013	CENTRAL SHAFT END CAP	2
37	005-0321	GUIDE ARM ASSEMBLY	1
38	075-0160	BUSHING	2
39	058-0050	SPACERS	2
40	058-0080	SPACERS	2
41	105-0120	SCREW COLLAR WITH 5/5 SET SCREW	2
42	051-0872	HEX. NUT 3/8" - 18 NC. NYLON LOCK S/S	2
43	130-4748	4" PL. CASTER SWIVEL W/ BRAKE	2
44	130-4749	4" PL. CASTER SWIVEL W/ O BRAKE	2
45	052-0570	BOLT 5/16" - 18 NC. X 3/4" ZINC	18
46	051-0740	FLAT WASHER 5/16" S/S	32
47	052-3110	NUT 5/16" - 18 NC. ZINC	18

420A

420A MC-40 REAR VIEW

SIPROMAC
 81-GERMAN DE GRANITUM
 QUEBEC CANADA

SCALE: 1" = 1"

DATE: _____

BY: _____

005-0600

MODEL 420A

COVER ADJUSTMENT PROCEDURE

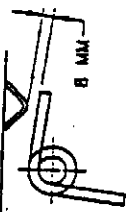
Reference Drawing:# 005-0600
004-0124

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

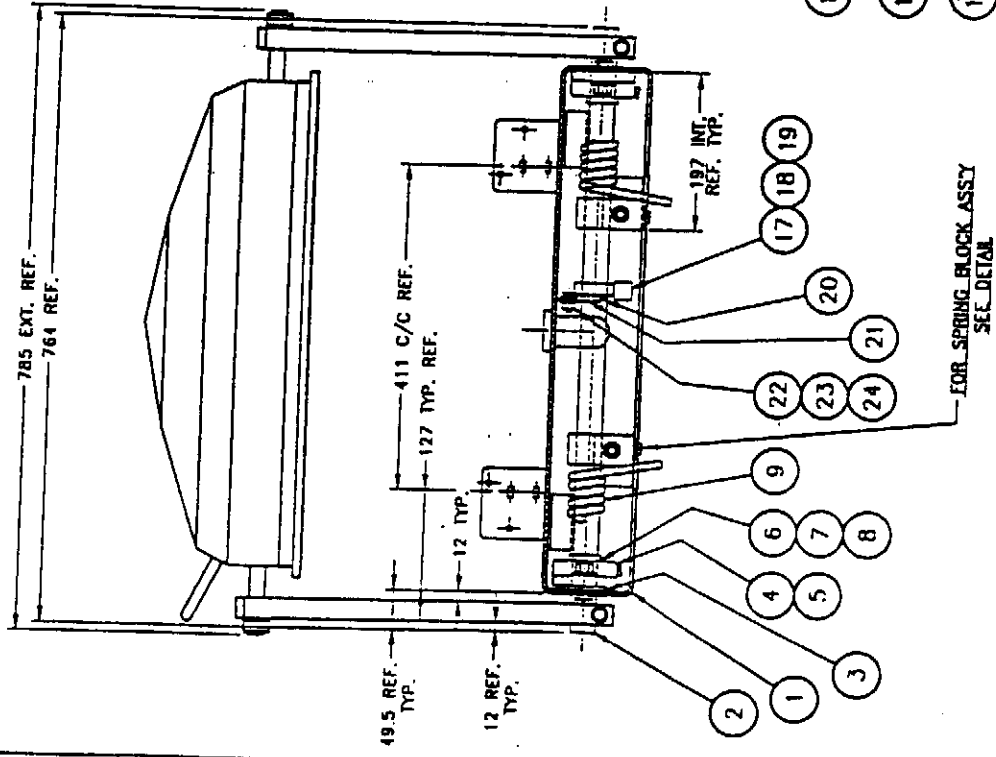
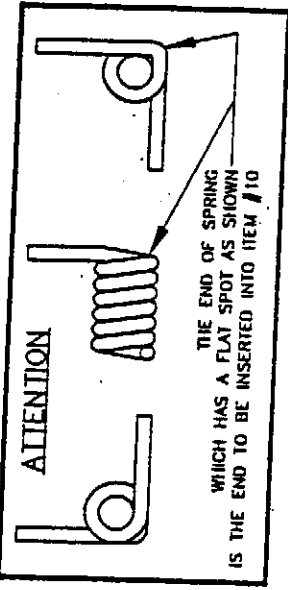
1. Floor should be flat (within 1/8" approx.).
 - 2.1 Mark position of original adjustment of guide arm length and its lower shaft position (See drawing # 005-0600; items: #37 & #14).
 - 2.2 Loosen the two bolts on the guide arm (See drawing # 005-0600; items #37).
 - 2.3 Now move the cover each side 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 # 005-0600; items #33, #12 & #42).
 - 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 pillow block (See drawing # 004-0124; item #4) until cover is sealing 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 by marking its position. When chamber is at the left and at the right, tighten at the center of your marks. Adjustment can be done a couple of times until everything is ok.

SPRING ADJUSTMENT PROCEDURE

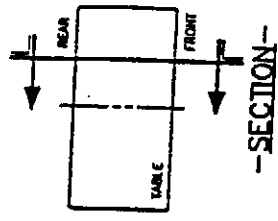
- A- PLACE COVER UP (ARM VERTICAL) TO FREE TENSION OF SPRINGS.
- B- LOOSEN BOLTS (ITEMS #11, #14 & #16) ON THE SPRING SUPPORT PLATE ASSY (ITEM #10). INSERT A SCREWDRIVER IN SLOT OF ITEM #13 ON CENTRAL SHAFT.
- C- TURN SPRING/BLOCK ASSEMBLY TO OBTAIN A SPACE APPROX. 8MM (5/16") AS SHOWN BELOW.



- D- RETIGHTEN BOLTS ON SPRING SUPPORT PLATE ASSY. (ITEMS #11, #14 & #16).



FOR SPRING BLOCK ASSY SEE DETAIL



ITEM	PART #	DESCRIPTION	QT.
1	005-0327	TABLE ASSEMBLY	1
2	008-0918	CENTRAL SHAFT	1
3	001-1542	PILLOW BLOCK SPACER	2
4	075-1650	2 BOLTS FLANGE BEARING	2
5	081-0100	GREASE FITTING 1/4" - 28 X 80"	2
6	051-0441	HEX. BOLT 1/2" - 13 NC X 1 1/2" S/S	4
7	051-0630	HEX. NUT 1/2" - 13 NC S/S	4
8	051-0780	FLAT WASHER 1/2" S/S	4
9	008-0319	CENTRAL SHAFT SPRING	2
10	004-0117	SUPPORT PLATE ASSEMBLY	2
11	051-0300	HEX. BOLT 5/16" - 18 NC. X 3/4" S/S	2
12	051-0762	FLAT WASHER 5/16" (THICK) S/S	2
13	002-0319	SPRING BLOCK	2
14	051-0420	HEX. BOLT 3/8" - 16 NC. X 3" S/S	2
15	051-0783	FLAT WASHER 3/8" (THICK) S/S	4
16	051-0620	HEX. NUT 3/8" - 16 NC. S/S	2
17	005-0154	MICRO-SWITCH COLLAR	1
18	051-0510	SET SCREW 3/8" - 16 NC. X 3/8" S/S	1
19	051-0520	SET SCREW 5/16" - 18 NC. X 3/8" S/S	1
20	026-0610	MICRO-SWITCH	2
21	001-1294	MICRO-SWITCH FIXATION PLATE	2
22	051-0180	HEX. BOLT 1/4" - 20 NC. X 1/2" S/S	2
23	051-0740	FLAT WASHER 1/4" S/S	4
24	051-0580	HEX. NUT 1/4" S/S	2

420A
CENTRAL SHAFT ASSEMBLY

DATE: 95-12-29
BY: M. LAMOREL

SCALE: 1:1

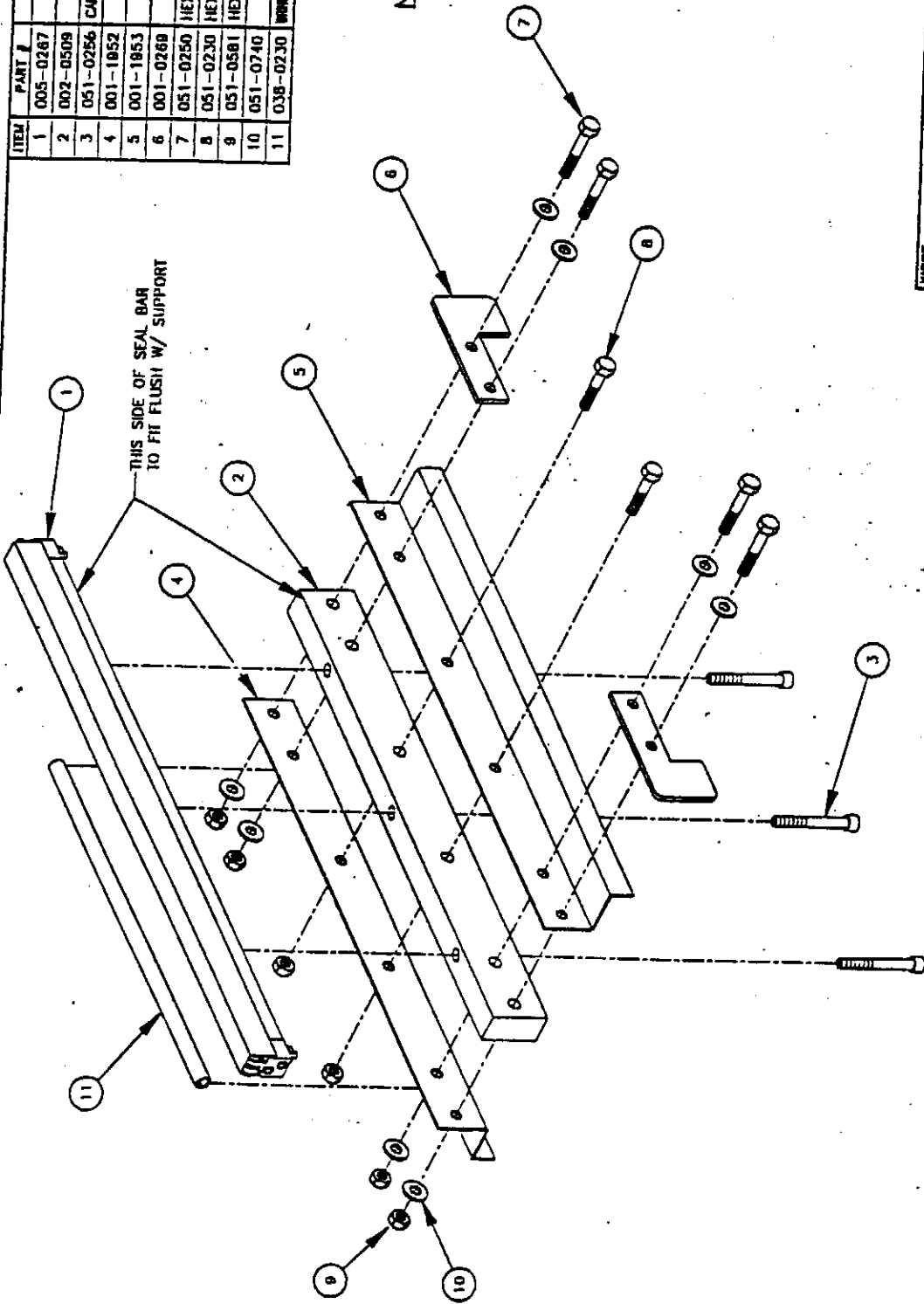
004-0124

SPRING BLOCK ASSY
-DETAIL-

MODIFICATION: M.L.
DATE: 95-12-29
REV: 1

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 1/4" S/S	3
4	001-1852	EXTERIOR BELLOWS COVER	1
5	001-1853	INTERIOR BELLOWS COVER	1
6	001-0268	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	8
10	051-0740	FLAT WASHER 1/4" S/S	8
11	038-0230	BRG. DCT W/ WIRE W/ MESHING (0.35 I.D.S X 3/16) PNC	1

NOTE: QTY FOR ONE SEAL BAR ONLY SEE LIST



MACHINE	QTY
420A	4
3500	2
350	1

350, 350D & 420A
SEAL BAR ASSEMBLY W/ SUPPORT

DATE: 97-08-28
BY: [Signature]

DATE: 97-08-28
BY: [Signature]

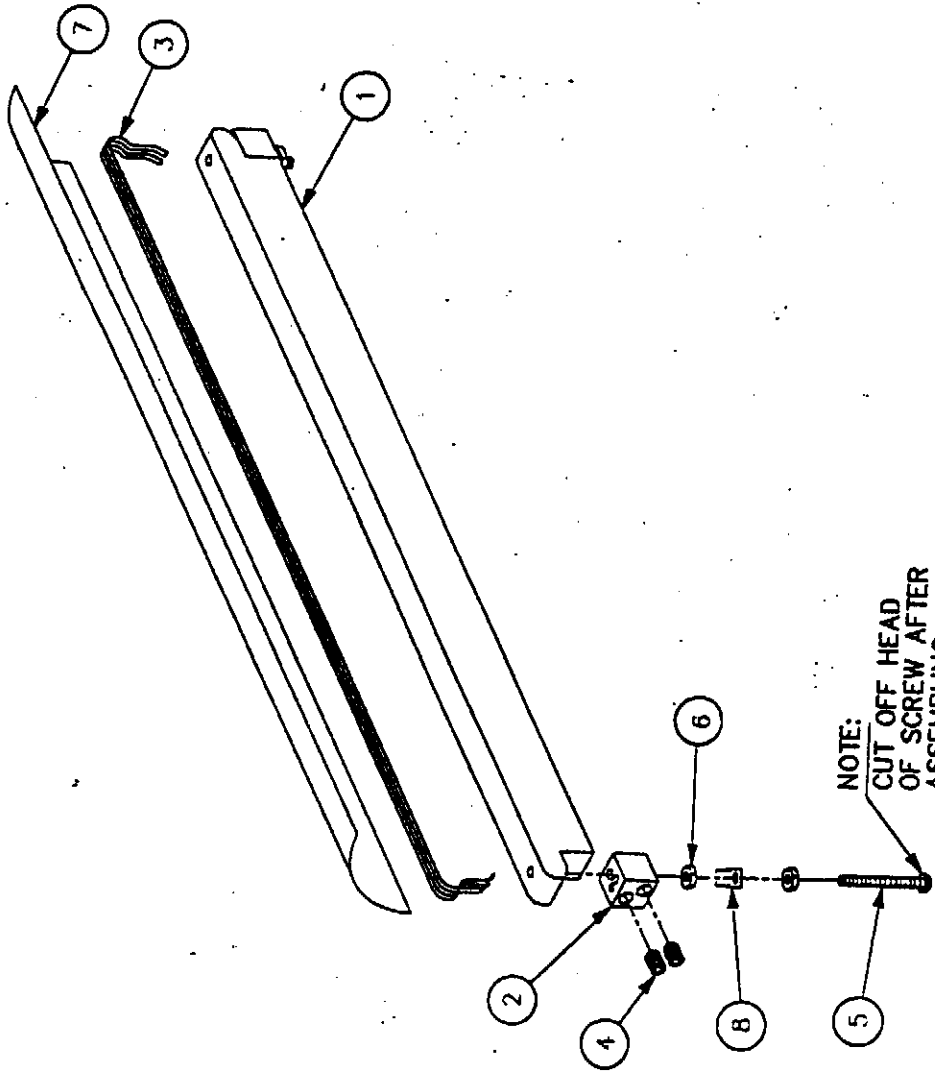
DATE: 97-08-28
BY: [Signature]

DATE: 97-08-28
BY: [Signature]

REV.	DESCRIPTION	DATE	BY
A	420A ADDED/ WAS 003-0329/ MODIF. A-0217	97-08-08	A.P.
B	LOWERED BOLT HOLES	97-08-08	A.P.
C	REDRAWN/ MODIF. A-0218	97-08-28	A.P.
LET.	MODIFICATION		WT.

ITEM	PART #	DESCRIPTION	QTY.
1	002-0015	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEMENT	2
4	052-0395	SET SCREW 1/4" - 20 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 (55) ADHESIVE	1
8	027-0400	CONNECTOR ADAPTOR	2

QTY SHOWN IS FOR ONE BAR SEE LIST FOR QTY.



NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

MACHINE	QTY
420A	4
350D	2
350	1

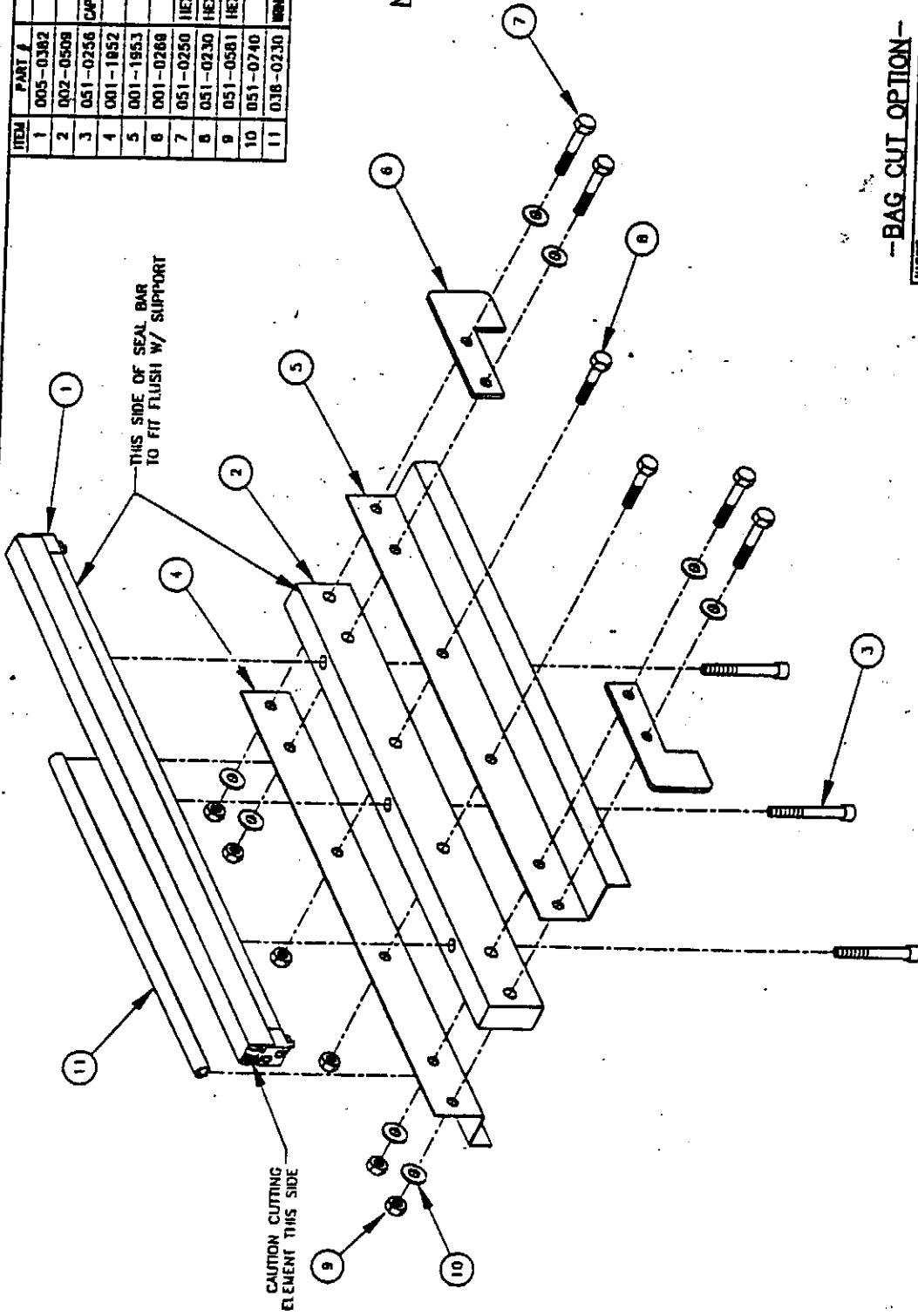
350, 350D & 420A
 SEAL BAR PRE-ASSEMBLY
 SIPROMAC
 ST-CEREMAN DE GRABRIAN
 QUEBEC CANADA

DATE: 97-09-03
 BY: A. PROVENCHER
 PART: 1005-0267

C REDRAWN/ MODIF. A-0216
 DATE: 97-09-03
 A.P. INT.
 MODIFICATION

ITEM	PART #	DESCRIPTION	QTY
1	005-0362	SEAL BAR PRE-ASSEMBLY	1
2	002-0508	SEAL BAR SUPPORT (TABLE)	1
3	051-0256	CAP HEX. SKT. BOLT 1/4" - 20 NC. X 1 3/4" S/S	3
4	001-1852	EXTERIOR BELLOW'S COVER	1
5	001-1853	INTERIOR BELLOW'S COVER	1
6	001-0268	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	6
11	038-0230	WING BOLT W/ ANTI-SK BACKING (3/8" X 0.5" X 20) PNC	1

NOTE: QTY FOR ONE SEAL BAR ONLY
SEE LIST



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

SIPROMAC
ST-GEMERON DE GRANBAUD
QUEBEC CANADA

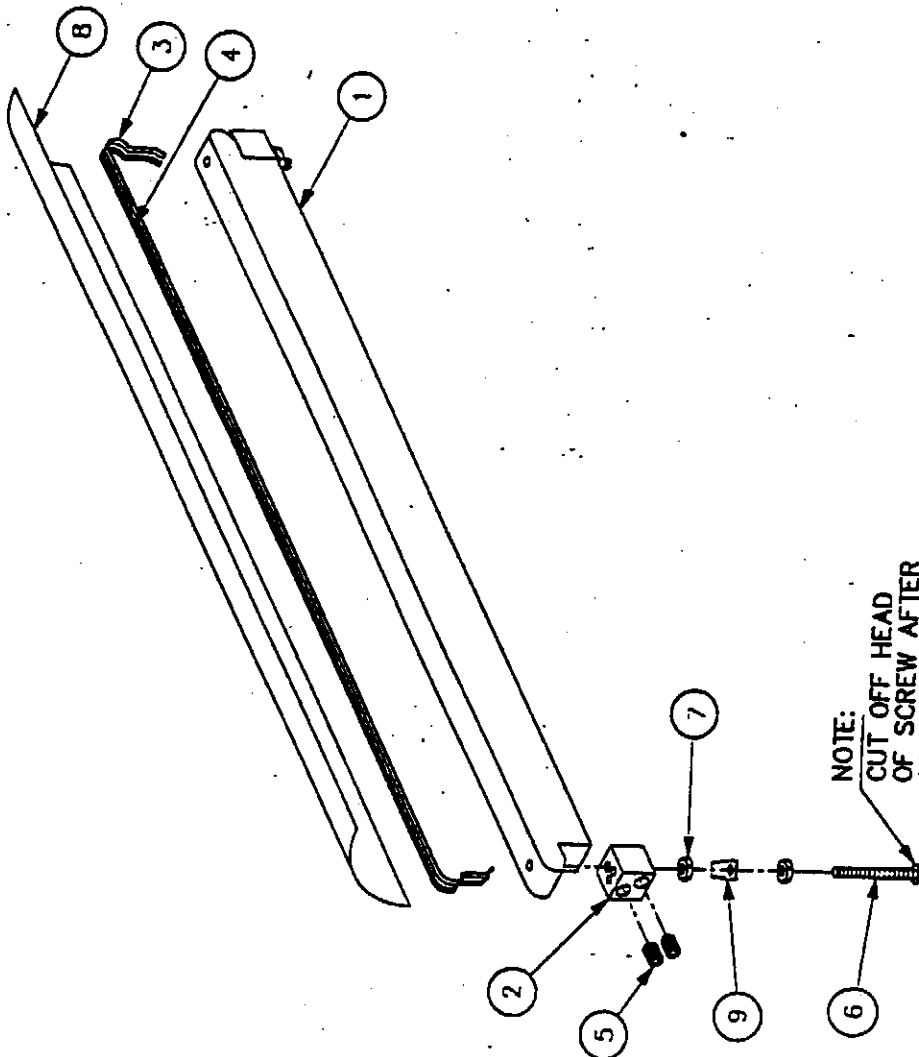
-BAG CUT OPTION-

DATE	REV. 97-08-20
BY	SCALE
APP. 1	SEE LIST
APP. 2	1005-0558

C	ADDED 300	08-08-03	L.M.
B	420A ADDED/ MOORE, A-0217	97-09-08	A.P.
A	LOWERED BOLT HOLES	97-09-08	A.P.
LET.	MODIFICATION	DATE	BY

ITEM	PART #	DESCRIPTION	QTY.
1	002-0015	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0230	CONVEX SEALING ELEMENT	1
4	039-0270	"T" PROFILE CUTTING ELEMENT	1
5	052-0385	SET SCREW 1/4" 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 S/S	4
8	178-0200	TEFLON TAPE (55) ADHESIVE	1
9	027-0100	CONNECTOR ADAPTOR	2

QTY SHOWN IS FOR ONE BAR SEE LIST FOR QTY.



NOTE:
CUT OFF HEAD OF SCREW AFTER ASSEMBLING

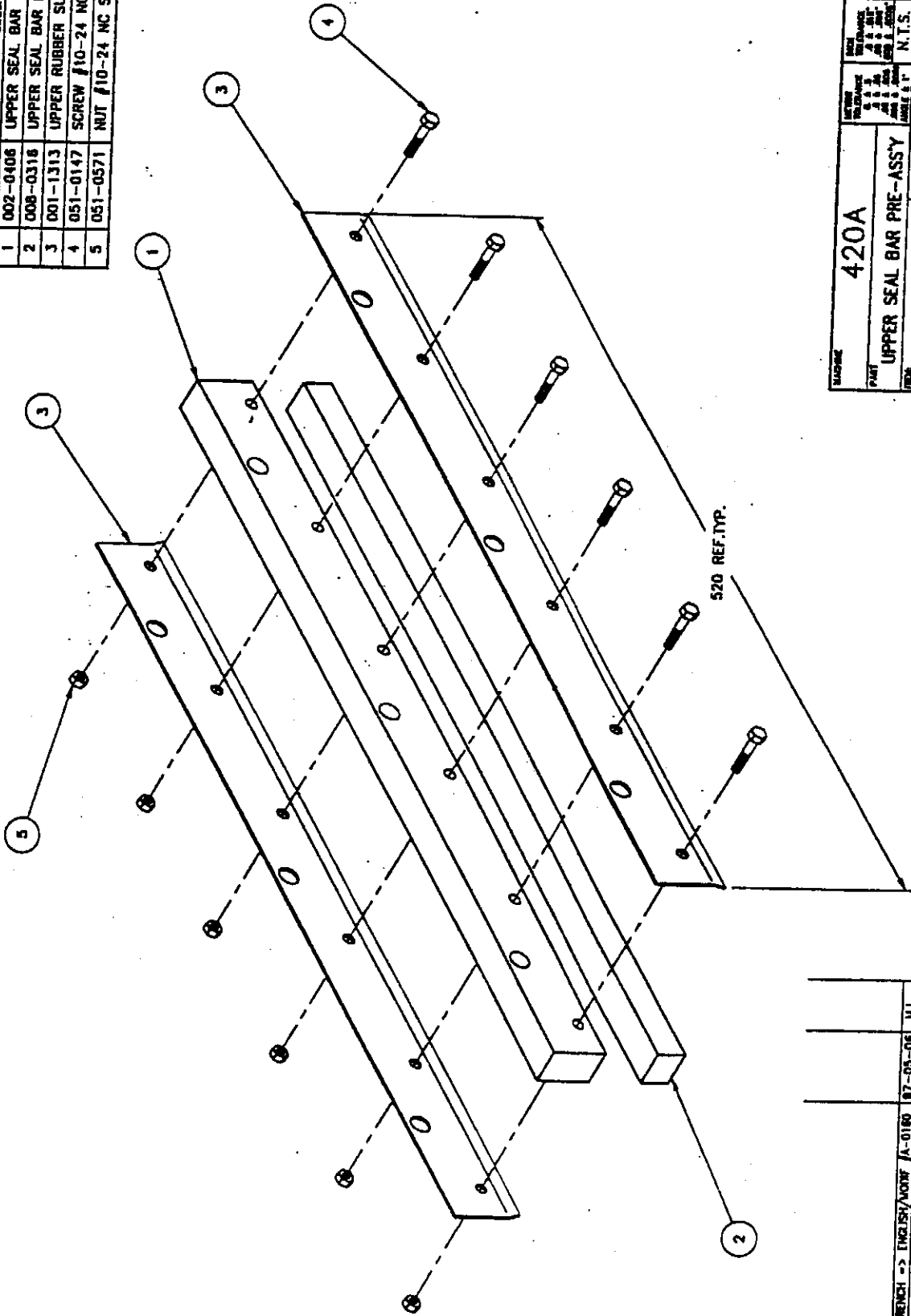
MACHINE	QTY
420A	1
3500	2
350	1
300	1

-BAG CUT OPTION-

MACHINE 300, 350, 3500 & 420A PART SEAL BAR PRE-ASSEMBLY		N.I.S. N.I.S.	
DATE	DATE	DATE	DATE
88-08-03	87-08-03	87-08-03	87-08-03
LM	A.P.	WT.	
SEE LIST 005-0382		SEE LIST 005-0382	

E	MODEL 300	88-08-03	LM
B	REDRAWN/WORK. A-0118	87-08-03	A.P.
LET.	MANUFACTURER	DATE	WT.

ITEM	PART #	DESCRIPTION	QTY
1	002-0406	UPPER SEAL BAR SUPPORT	2
2	008-0318	UPPER SEAL BAR RUBBER	2
3	001-1313	UPPER RUBBER SUPPORT	4
4	051-0147	SCREW #10-24 NC x 1" HEX. S/S	12
5	051-0571	NUT #10-24 NC S/S	12

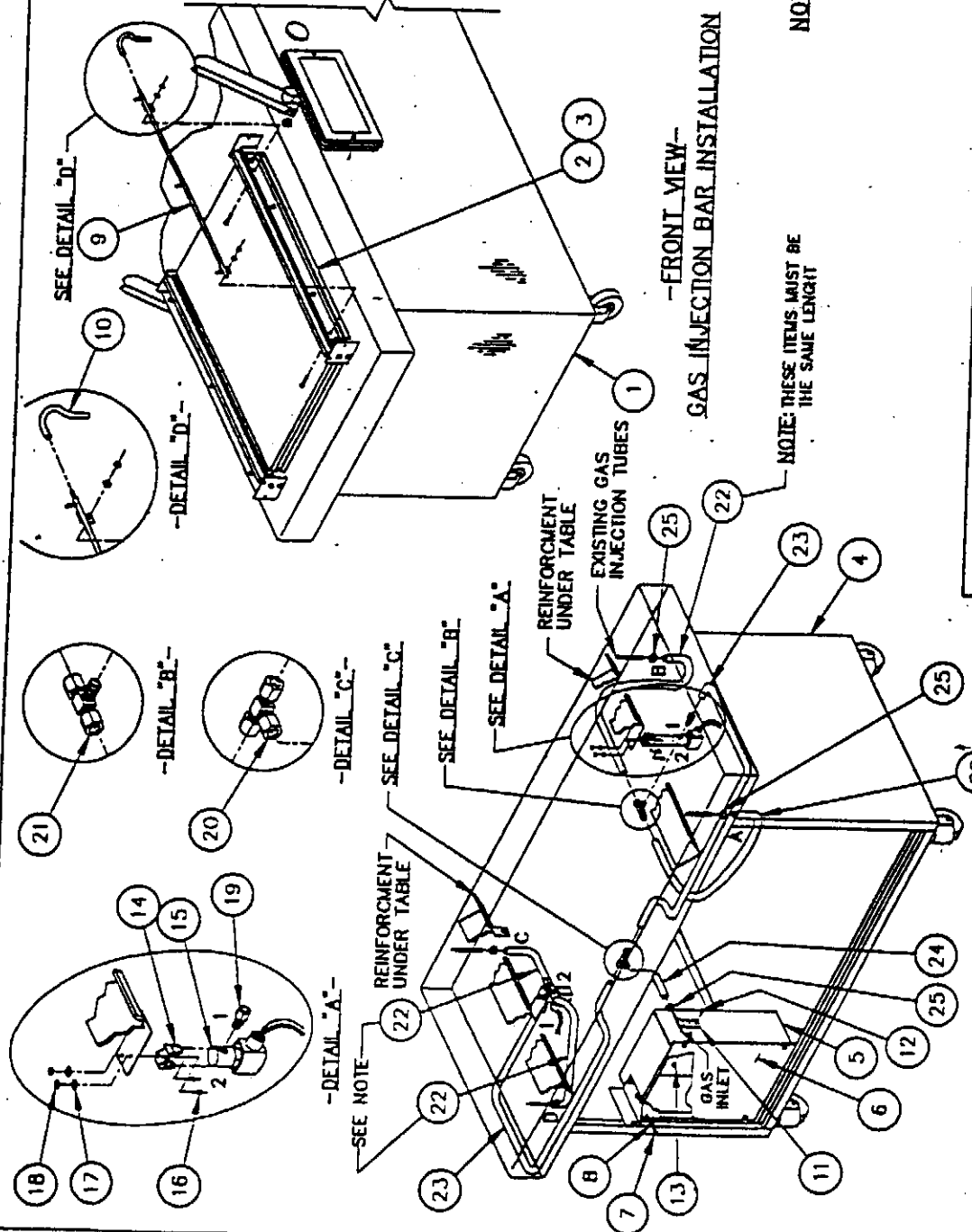


420A		SIPROMAC	
UPPER SEAL BAR PRE-ASSY		ST-GERMAIN DE GRANVILLE QUEBEC CANADA	
SCALE	1:1	DATE	97-05-08
REV	2	BY	

REVISION/FRENCH -> ENGLISH/MODIF A-0180	DATE	M.I.	INT.

004-0126

ITEM	PART #	DESCRIPTION	QTY.
1	005-0336	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0046	SEAL BAR ASSY W/ SUPPORT	4
3	005-0598	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	051-0180	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	108-0010	SELENIDE VALVE 2 WAY 1/4" NPT	2
16	051-0100	SCREW #8-32 X 3/8" PAN PHIL. S/S	4
17	051-0720	FLAT WASHER #8 S/S	4
18	051-0550	HEX. NUT #8 S/S	4
19		STRAIGHT 1/4" MNPT X 3/8" T.P. COMP.	2
20	101-0082	"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.)	4
23	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.)	4
24	104-0080	TUBE 3/8" O.D. X 1/4" I.D. (POLY.)	2
25	105-0200	COLLARS 3/8"	5



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

NOTE: THESE ITEMS MUST BE THE SAME LENGTH

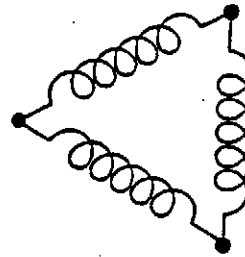
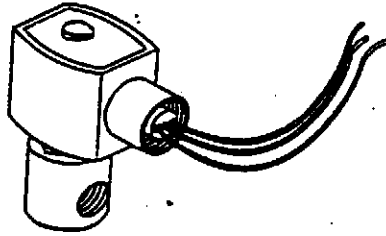
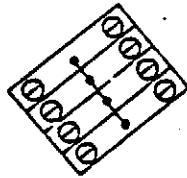
TO GAS INJECTION TUBES UNDER TABLE, REMOVE THE FOUR EXISTING CAPS & CONNECT HOSES A, B, C & D

-UNDER TABLE VIEW- VALVE INSTALLATION

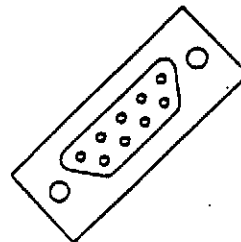
-OPTION GAS INJECTION-

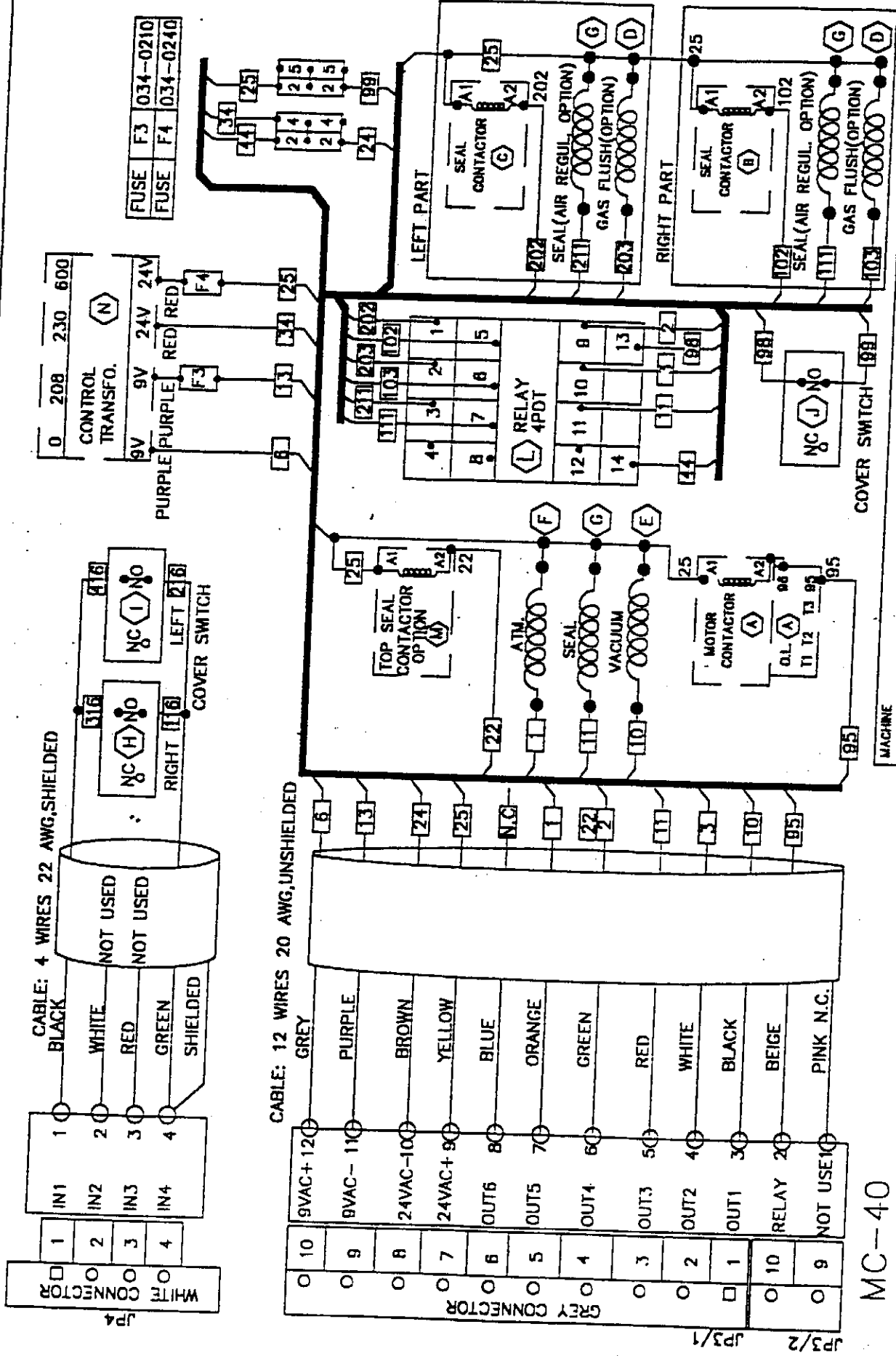
NAME: 420A
 PART: SIPROMAC
 GAS INJECTION KIT INSTALLATION
 DATE: 97-09-11
 A.P. INT.
 1010-0016





ELECTRICAL DRAWING





VACUUM DOUBLE CHAMBER

LOW VOLTAGE WITH MC-40

MACHINE

SIPROMAC

ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

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

DATE: 5 MAY 1988

APP. DATE: 5 MAY 1988

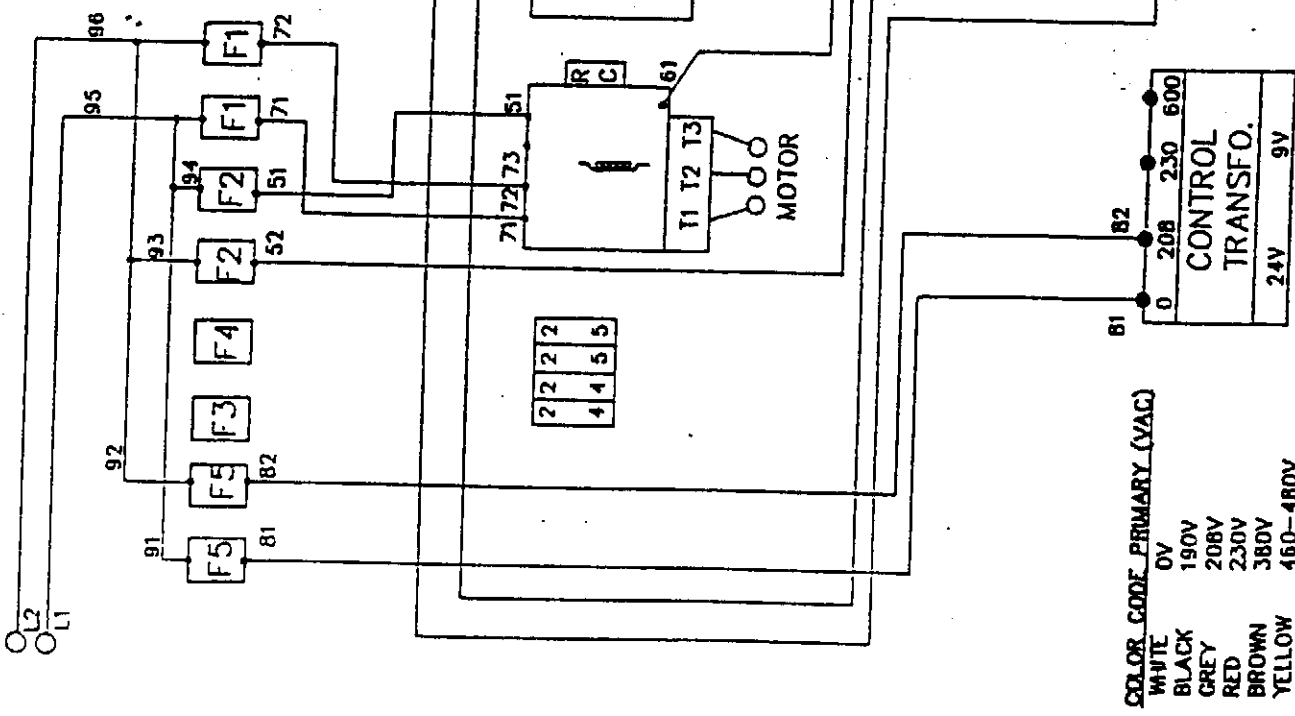
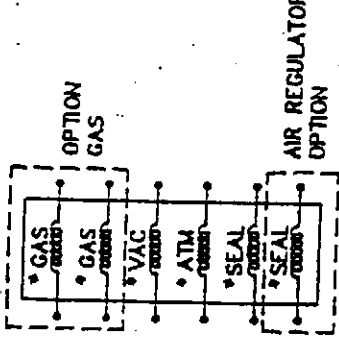
NO. 016-0118

MC-40

1006-0068

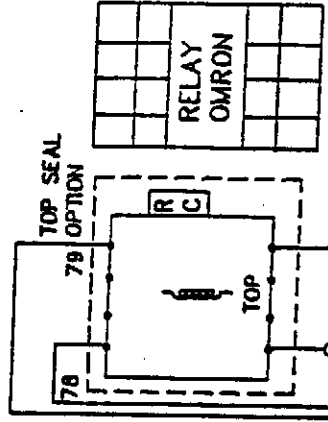
* RC SUPPRESSOR ADD ON EACH COIL

OPTION	VOLTAGE	FUSE F2	FUSE F5	MOTOR (HP)	PLMP	FUSE F1
TWIN SEAL & BAG CUT	220	031-0480	031-0200	3	230-1	031-0530
TWIN SEAL & BAG CUT	300	031-0430	031-0410	3	230-3	031-053X
TWIN SEAL & BAG CUT	900	031-0425	031-0410	3	375-3	031-0481
TOP & BOTTOM SEAL	220	031-0500	031-0200	5	230-1	031-0570
TOP & BOTTOM SEAL	300	031-0485	031-0410	5	230-3	031-0590
TOP & BOTTOM SEAL	600	031-0440	031-0410	5	375-3	031-0410



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 9V

2 2 2 2
 4 4 5 5



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MACHINE 420A, 600A & 620A

PREZ ELECT. WIRING HIGH VOLTAGE 10

Q1. _____ FCH. SCALE _____ NE PAS MESURER / N.T.S.
 MAT. _____

DESS. L. LETCHEREAU DATE 07-03-10
 APP. _____

SIPROMAC
 ST-GERMAIN DE GRANTHAM
 QUEBEC CANADA

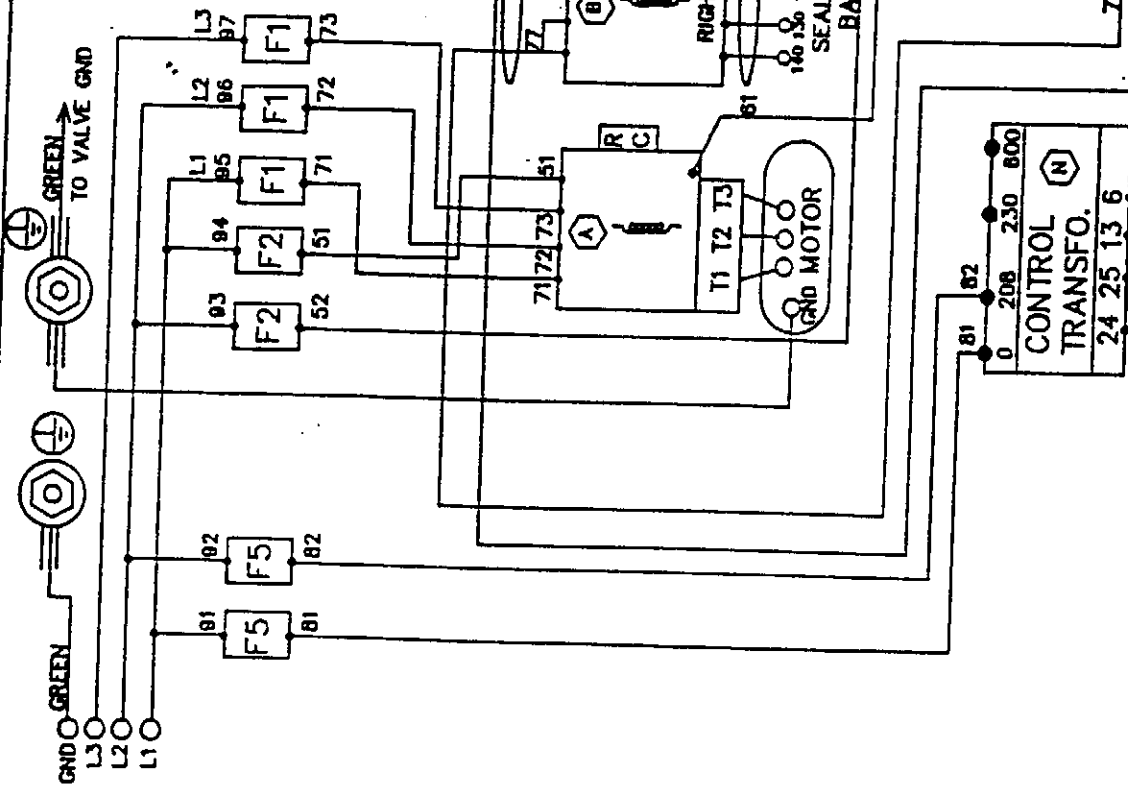
006-0068

1006-0069

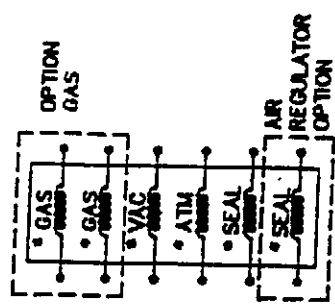
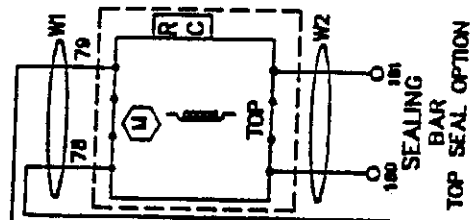
PUMP	
MOTOR (HP)	VOLT +/-PH
3	230-1
3	230-3
3	575-3
5	230-1
5	230-3
5	575-3

OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0480	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



- CONTROL TRANSFO. (N)**
 0 208 230 600
 24 25 13 6
- SEALING TRANSFO. (K)**
 H1 H2
 X1 24V X2
 77 74 75 78
- COLOR CODE PRIMARY (VAC)**
 WHITE 0V
 BLACK 180V
 GREY 208V
 RED 230V
 BROWN 380V
 YELLOW 480-480V
 BLUE 575-600V
- SECONDARY (VAC)**
 RED 24V
 PURPLE 9V



*RC SUPPRESSOR ADD ON EACH COIL

MACHINE: 420A, 600A & 620A

PRICE: ELECT. WIRING HIGH VOLTAGE 30

GT. _____ ECU SCALE _____

MAR. _____

SIPROMAC
 ST-GERMAN DE GRANTHAM
 QUEBEC CANADA

DATE: 87-03-10

NO. 006-0069

1006-0101



GROUND TO PUMP
 FUSE 25A (DUMMY)
 00 TO BODY

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RC SUPPRESSOR ADD ON EACH COIL
 * GAS
 * GAS
 * VAC
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 * SEAL
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AIR REGULATOR
 OPTION

TOP SEAL
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OPTION	VOLTAGE	FUSE F1	FUSE F5
TWIN SEAL & BAG CUT	270	031-0450	031-0700
TWIN SEAL & BAG CUT	360	031-0430	031-0710
TWIN SEAL & BAG CUT	800	031-0425	031-0710
TOP & BOTTOM SEAL	270	031-0500	031-0700
TOP & BOTTOM SEAL	360	031-0485	031-0710
TOP & BOTTOM SEAL	800	031-0440	031-0710

MOTOR (HP)	VOLTS	FUSE F1
3	230-1	031-0450
3	230-3	031-0425
3	875-3	031-0500
5	230-1	031-0485
5	230-3	031-0440
5	875-3	031-0710

MOTOR (HP)	VOLTS	FUSE F1	FUSE F5
3	230-1	031-0450	031-0700
3	230-3	031-0425	031-0710
3	875-3	031-0500	031-0700
5	230-1	031-0485	031-0710
5	230-3	031-0440	031-0710
5	875-3	031-0710	031-0710

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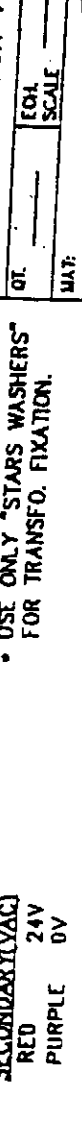
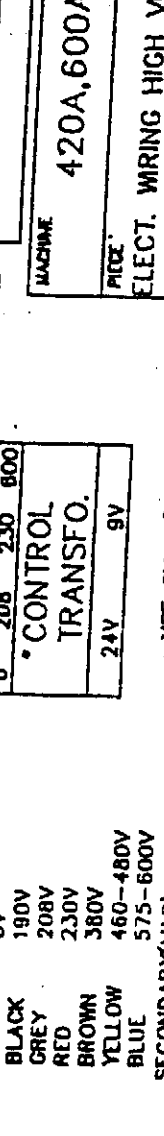
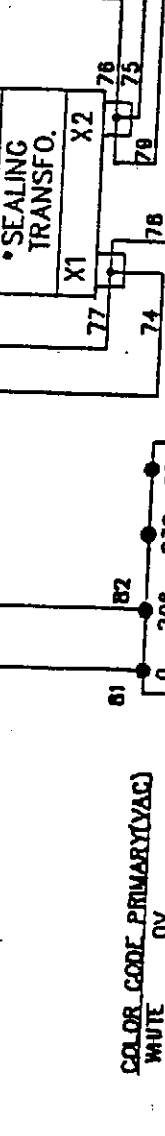
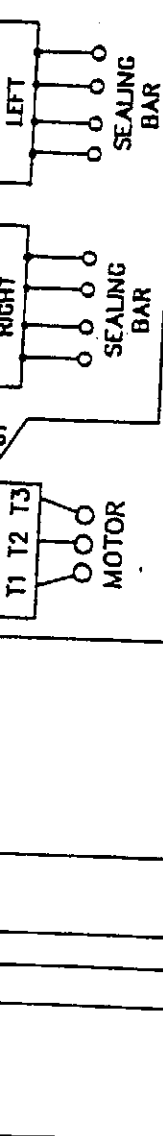
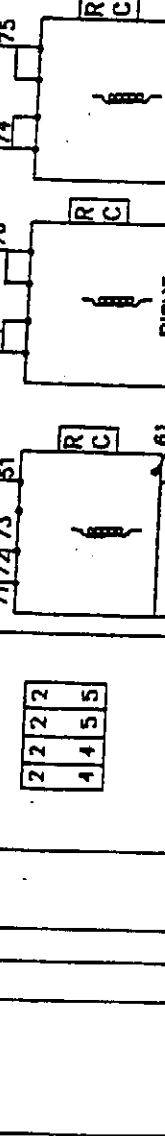
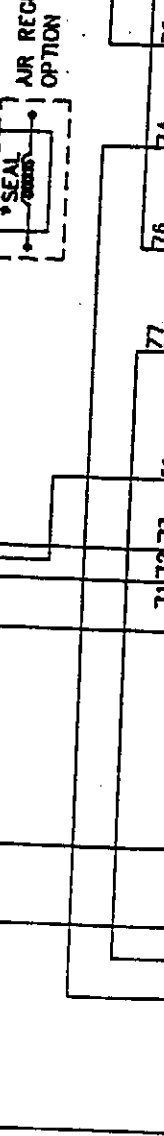
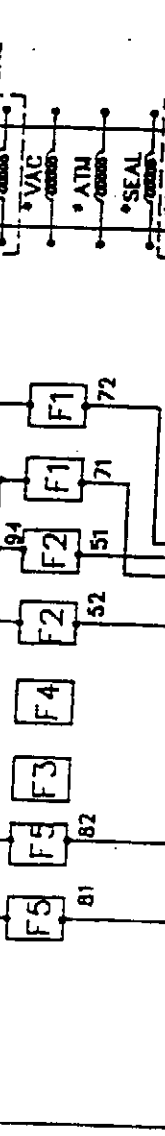
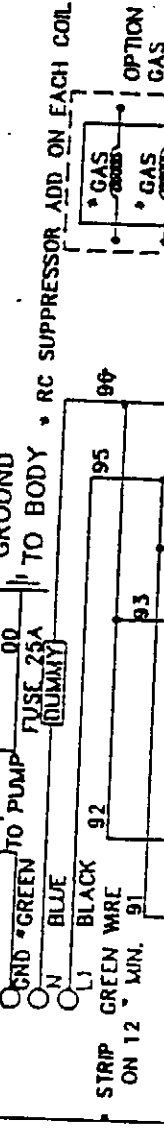
* NO
 * NC
 * COM

* NO
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* NO
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* NO
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* NO
 * NC
 * COM



- 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.

MACHINE
420A, 600A & 620A
 ELECT. WIRING HIGH VOLTAGE 10,50 HZ
 DATE: _____
 WAT: _____
 NE PAS MESURER / N.T.S.
 DATE: 97-03-11

SIPROMAC

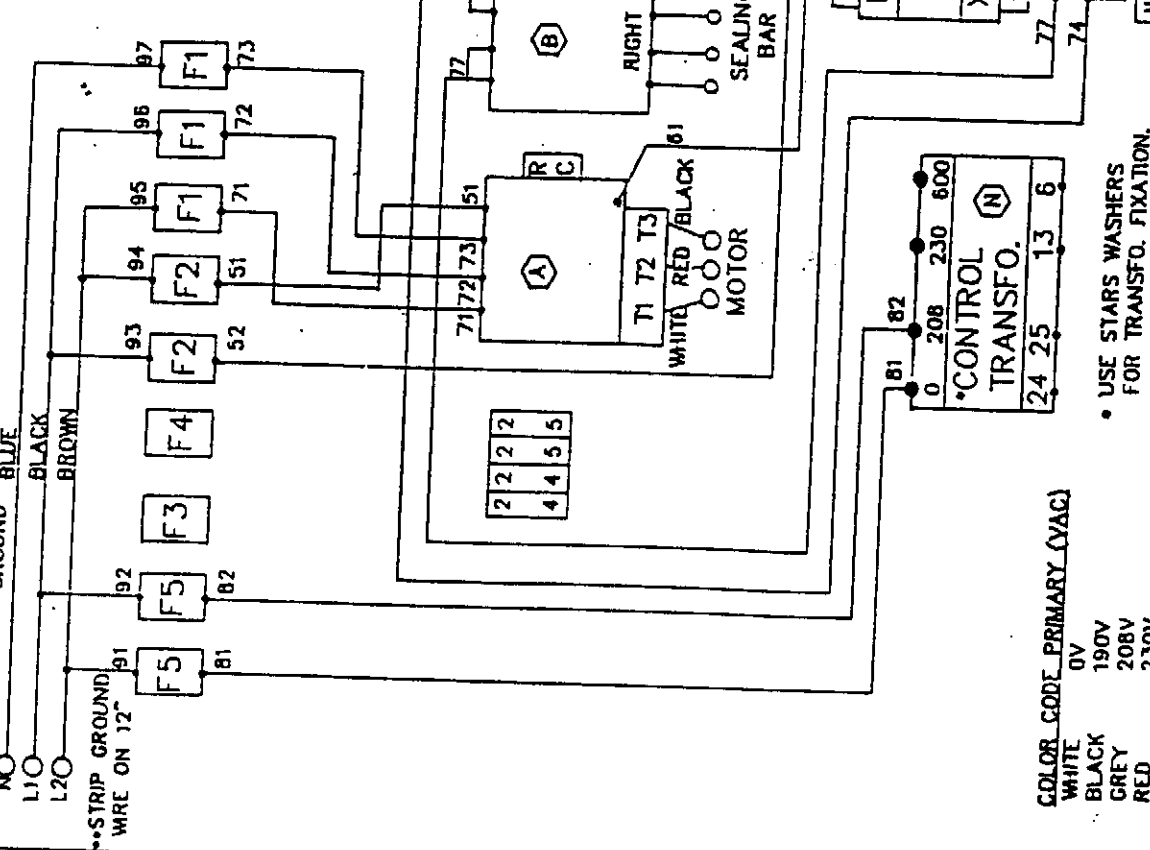
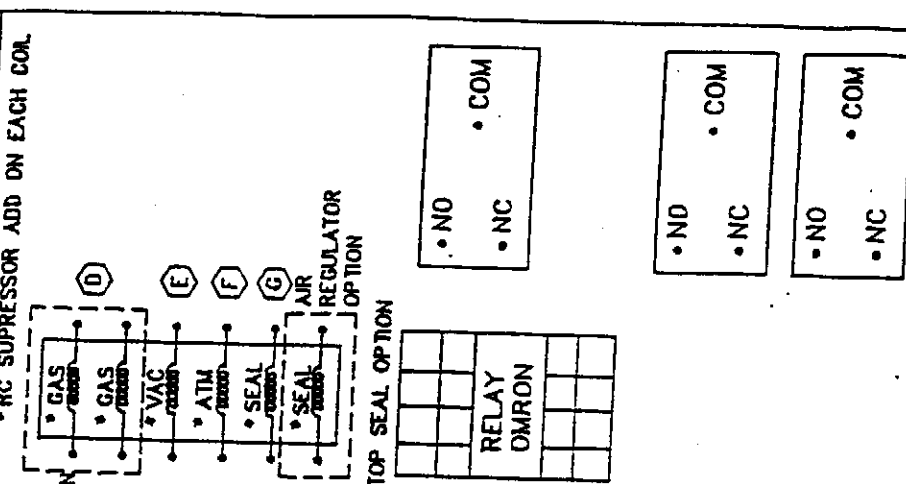
ST-GERMAN DE GRANTHAM
 QUEBEC CANADA

006-0101

1006-0102

OPTION	VOLTAGE	FUSE F2	FUSE F5	MOTOR (HP)	PUMP
TWIN SEAL	220	034-0450	034-0200	3	VOLT - rpm
TWIN SEAL	380	034-0430	034-0410	3	230-1
TWIN SEAL	600	034-0425	034-0410	3	230-3
TOP & BOTTOM SEAL	220	034-0500	034-0200	5	575-3
TOP & BOTTOM SEAL	380	034-0465	034-0410	5	230-1
TOP & BOTTOM SEAL	600	034-0440	034-0410	5	230-3
					575-3

OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0450	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	034-0465	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410



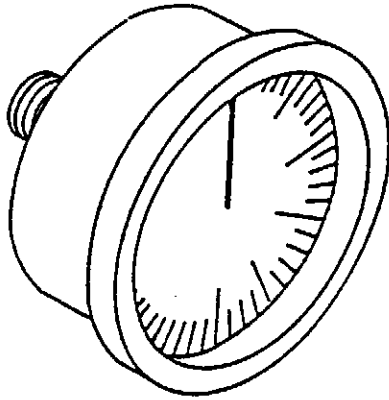
ELECTRICAL DRAWINGS PARTS LIST

A: VOLT PHASE PUMP HP CONTACTOR OVERLOAD

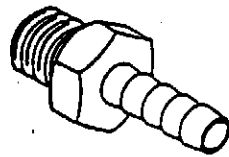
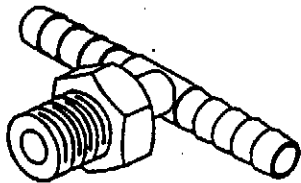
220	1	2	025-0020	025-0190
220	3	2	025-0010	025-0170
380	3	2	025-0020	025-0150
575	3	2	025-0010	025-0140
220	1	3	025-0040	025-0190
220	3	3	025-0020	025-0180
575	3	3	025-0010	025-0150
220	1	4	025-0050	025-0200
220	3	4	025-0030	025-0190
460	3	4	025-0010	025-0170
575	3	4	025-0010	025-0160

- 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: 2HP, 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
- N: CONTROL TRANSFO.: 029-0007, 029-0008, 029-0009, 029-0250



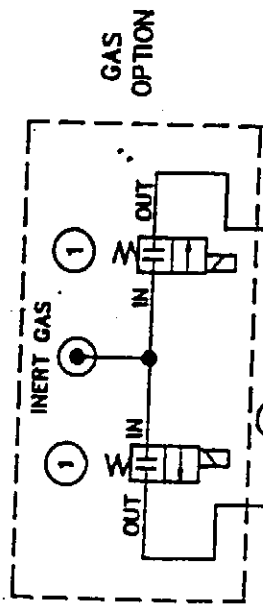


PNEUMATIC DRAWING

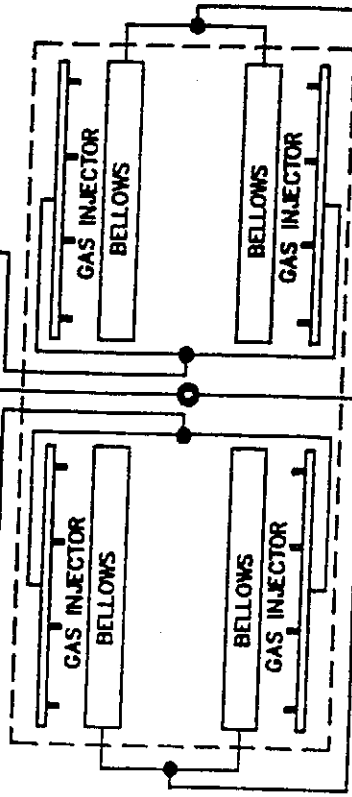


007-0019

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, 083M ³ AND 100 M ³	
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A; 160 M ³ AND 250 M ³	
8	106-0050	ATMOSPHERE VALVE FOR 650A & 700A	
	106-0030	VACUUM VALVE FOR 420A	
	106-0050	VACUUM VALVE FOR 600A & 620A	
	106-0060	VACUUM VALVE FOR 650A & 700A	1
* OPTION			

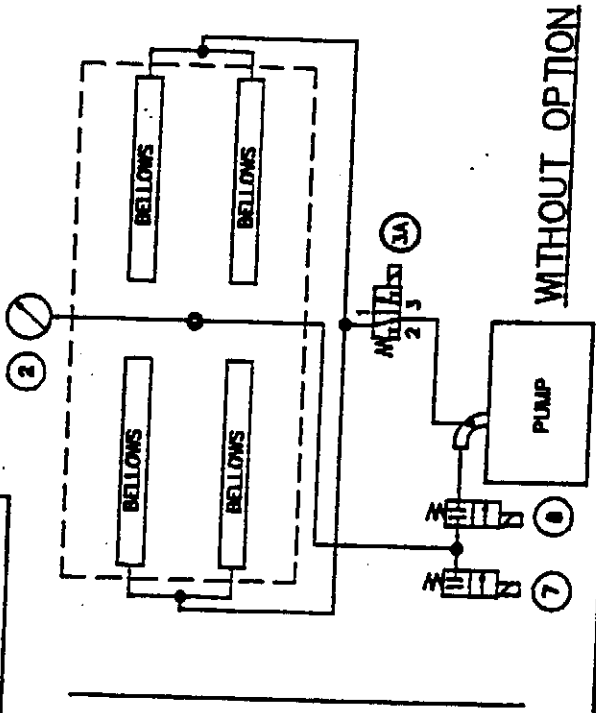


-NOTE:
 --FOR GAS INJECTION
 KIT INSTALLATION
 SEE DRAWINGS #
 420A: #010-0016
 600A: #010-0017
 620A: #010-0018
 650A: #010-0020



NOTE: SET TO A
 MAXIMUM OF 45 PSI

-NOTE:
 --FOR AIR REGULATOR
 OPTION KIT INSTALLATION
 SEE DRAWINGS # 010-0019
 & 650A: #010-0027
 (FOR EXISTING MACHINES)



WITH OPTIONS

WITHOUT OPTION

MACHINE 420A, 600A, 620A & 650A		PART		N.T.S.		SCALE		QT.	
PNEUMATIC		SIPROMAC		ST-GERMAN DE GRANTHAM QUEBEC CANADA		DATE 87-03-11		DATE	
DRAWN BY M. LAVIGNE		DATE 87-03-11		DATE		DATE		DATE	
MODIFICATION		DATE		DATE		DATE		DATE	
LET.		DATE		DATE		DATE		DATE	

007-0019



May 14, 1992

Sipromac, Inc.

The following equipment is acceptable for use in federally inspected meat and poultry plants:

EQUIPMENT: Vacuum Packaging Machine, Models: Sipromac 650A, Sipromac 600A, Sipromac 550A, and Sipromac 420A

This acceptance is with the understanding that all future equipment designated by a similar model number will be of the same design and material as those for which this letter is written. Once this equipment is published in our "Accepted Meat and Poultry Equipment" booklet, this letter becomes invalid and can no longer be used as an authorization for installation of equipment in plants.

This acceptance does not imply compliance with Department of Labor Occupational Safety and Health Standards, nor should it be considered as an approval of processing methods. Any departure from established procedures must be cleared with the Slaughter Inspection Standards and Procedures Division or the Processed Products Inspection Division.

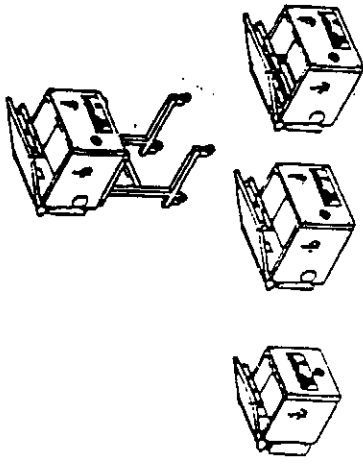
Sincerely,

Robert E. Owens
Industrial Specialist
Equipment Branch
Facilities, Equipment and Sanitation Division
Science and Technology

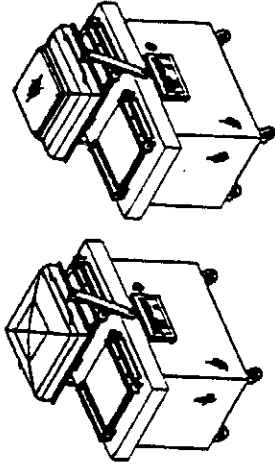
DECU

NOTES

NOTES



MODEL 250 MODEL 350 MODEL 350D MODEL 450T



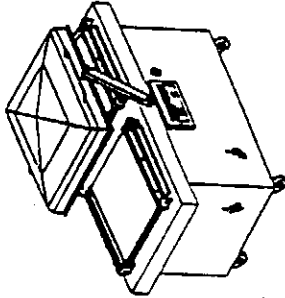
MODEL 550A

MODEL 420A

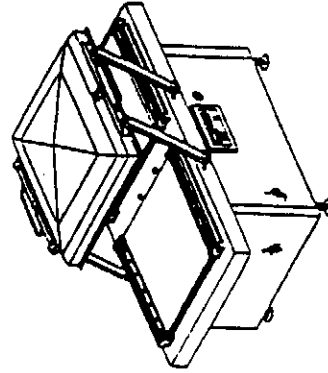


Canada
SIPROMAC
 International Headquarters
 St. Germain, Canada J0C1K0

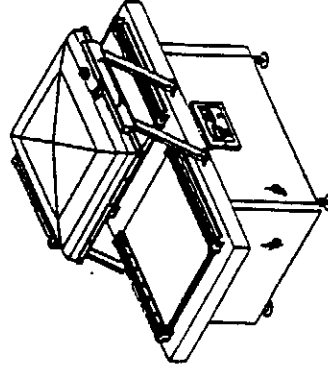
VACUUM PACKAGING MACHINES



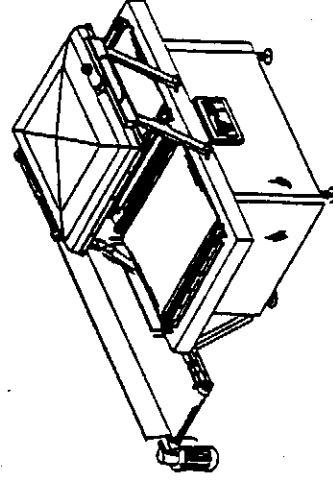
MODEL 600A



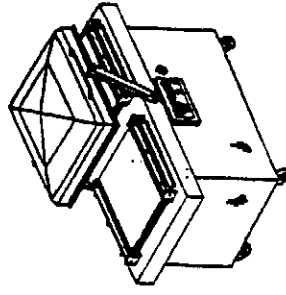
MODEL 650A



MODEL 650A AUTOMATIC



MODEL 700A



MODEL 820A

