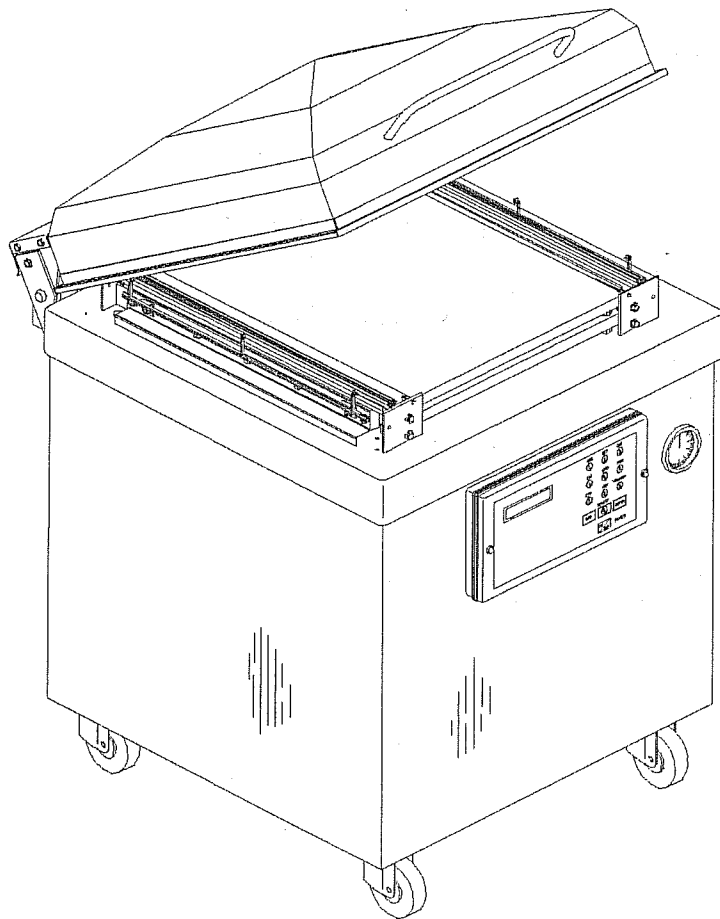


VACUUM PACKAGING MACHINE

MODEL 550A



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

IMPORTANT SAFETY INSTRUCTIONS

SAVE THESE INSTRUCTIONS



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

General Operation

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

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

Service

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

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



Warning-Your responsibility:

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

VACUUM PACKAGING MACHINE

MODEL 550A

(MC-40 SIPROMAC)

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- F- Seal bar assembly drawings (electrical bag cut option)
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VACUUM PACKAGING MACHINES-OPERATION INSTRUCTIONS

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2010-08-30

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.

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

2. ELECTRICAL CONNECTION:

Electrical connections must be made by qualified personnel. This person must make sure that the electrical entries corresponds to the proper voltage and amperage of the machine. **GROUNDING INSTRUCTIONS:** This appliance must be connected to a grounded, metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment-grounding terminal or lead on the appliance. A qualified electrician should be consulted if there is any doubt as to whether an outlet box is properly grounded.

All vacuum machines are supplied with an electrical schematic drawing.

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



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

3. OPERATION:

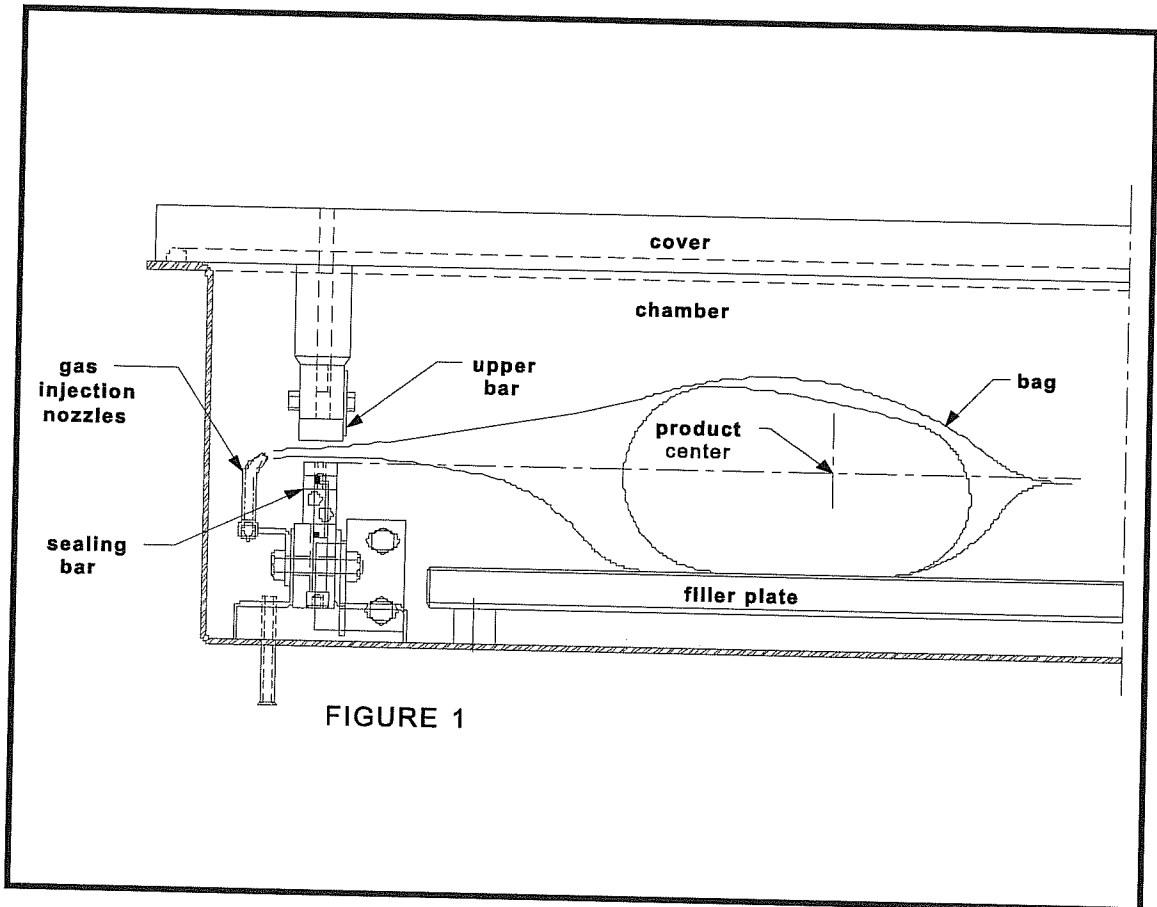
3.1 Working principles:

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

Finally, a mechanism pushes the sealing bar to the rubber support to seal the bag.

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

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



3.2 Special packaging:

3.2.1 Gas flushing (option):

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

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

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

3.2.2 Electrical bag cut (optional):

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

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 13 and the keyboard detail on page 14.

3.3.1 Basics:

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

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

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

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

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

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

3.3.2 Functions menu:

3.3.2.1 Create a program:

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

3.3.2.2 Delete a program:

When executing the "delete a program" function, the programs menu is accessed 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 access 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 ceases 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 time setting (sensor disabled):

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

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

3.3.3.3 Vacuum level setting (sensor enabled)

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

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

3.3.3.4 Vacuum plus time setting (sensor enabled)

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

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

3.3.3.5 Gas time setting (sensor disabled)

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

3.3.3.6 Gas flush level setting: (sensor enabled)

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

3.3.3.7 Sealing time setting:

For a selected program set the sealing, starting with the seconds; the decimal point is

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

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

3.3.4 Vacuum cycle execution:

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

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

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

3.3.5 System monitor:

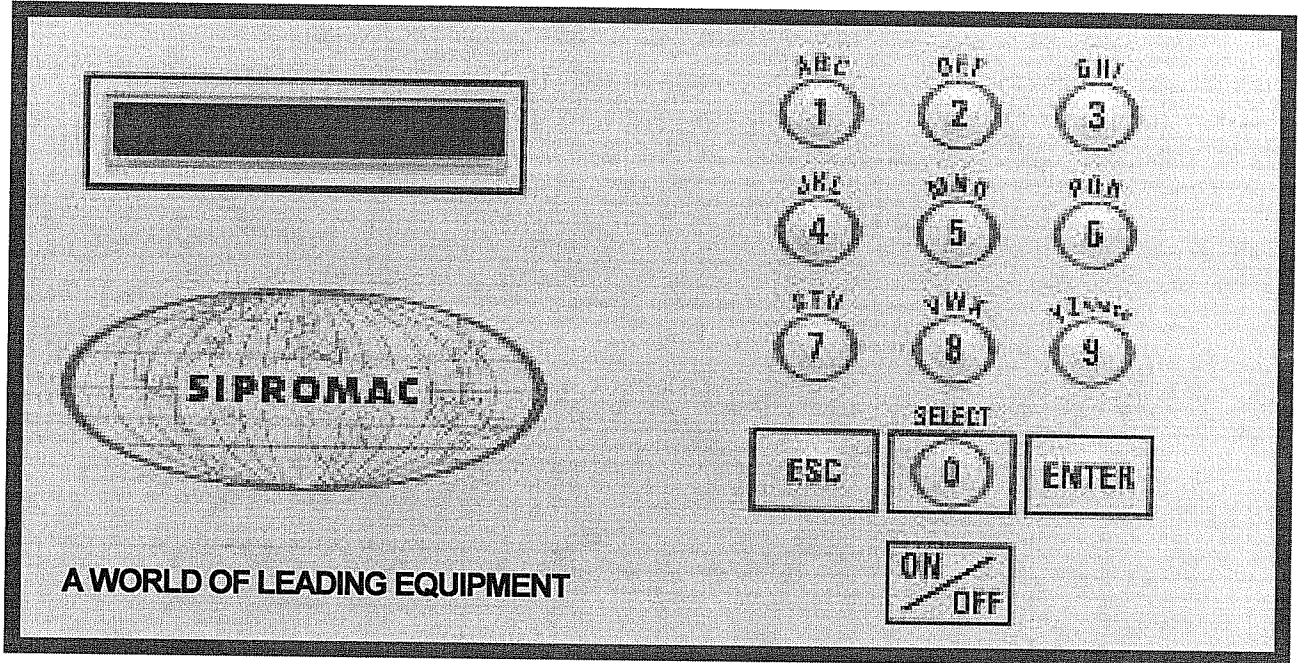
To accede the diagnostics menu, power up the vacuum packaging machine while keeping pushed in the "ESC"key. Use key "SELECT" to select the system monitor function and key "ENTER" to accede and visualize the monitored parameters. Use key "SELECT" to change over from the software revision, the amount of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

-MENUS STRUCTURE-

- **Functions menu:**
 - "F1 CREATE A PRGM"
 - "F2 DELETE A PRGM"
 - "F3 SELECT OPMODE" (automatic units only)
- **Programs menu:**
 - "Pxx NAME"
 - Program submenu:
 - "VACUUM: xx.x%" (10.0% - 99.5%)
 - "VACUUM PLUS: xxs"(0s - 99s)
 - "GAS FLUSH: xx.x%" (0.0% - 10% below the vacuum level) (units with gas option)
 - "SEAL TIME: x.xxs" (0.00s - maximum unit allocated setting)
 - "Pxx NAME" (12 characters)
- **Diagnostics menu** (keys "ESC" & "POWER" for access):
 - "DIAGNOSTICS MENU" (access code required)
 - "D1 INPUTS TEST"
 - "D2 OUTPUTS TEST"
 - "D3 MODEL SELECT"
 - "D4 GAS OPTION"
 - "D5 SEALING TIME"
 - "D6 COOLING TIME"
 - "D7 OFFSET CALIB."
 - "D8 VACUUM SENSOR"
 - "D9 SIPROMAC PUB"
 - "D10 LOADING TIME" (automatic units only)
 - "D11 UNLOADNG TIME" (automatic units only)
 - "SYSTEM MONITOR" (no access code required)
 - "SOFTWARE: R x.xx"
 - "WORK HRS: xxxxx"
 - "CYCLES: xxxxxxx"

-KEYBOARD DETAILS-

MC-40 CONTROLS





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.

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

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "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.

Vacuum level is too low:

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.

Caution: 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).

Caution: 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 13.

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 components: 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.

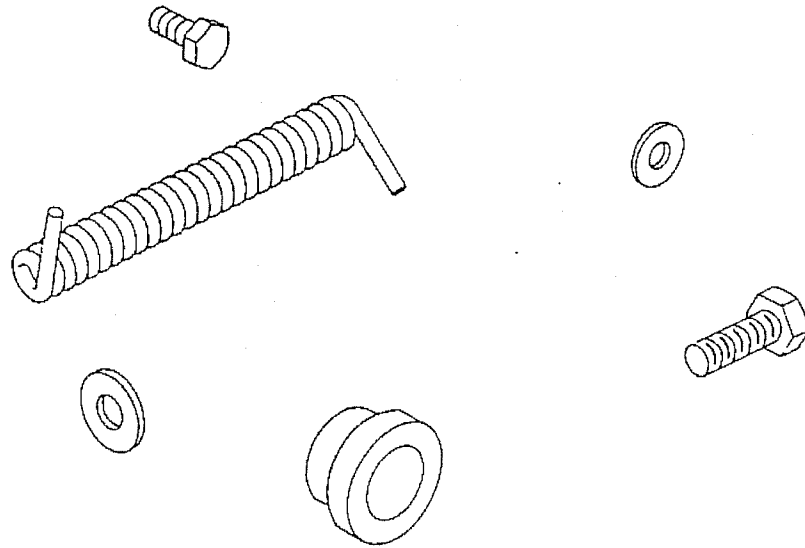
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

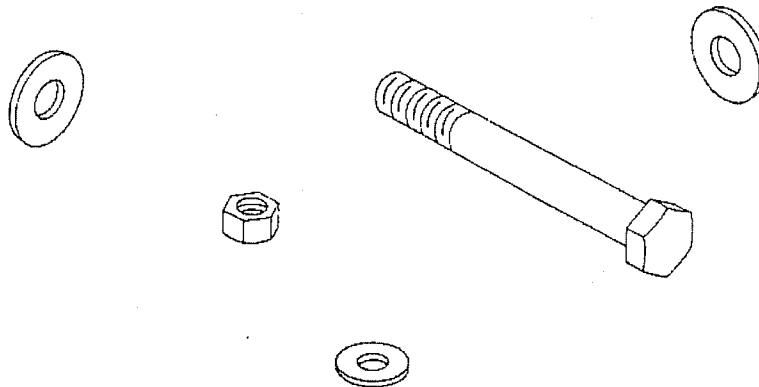
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

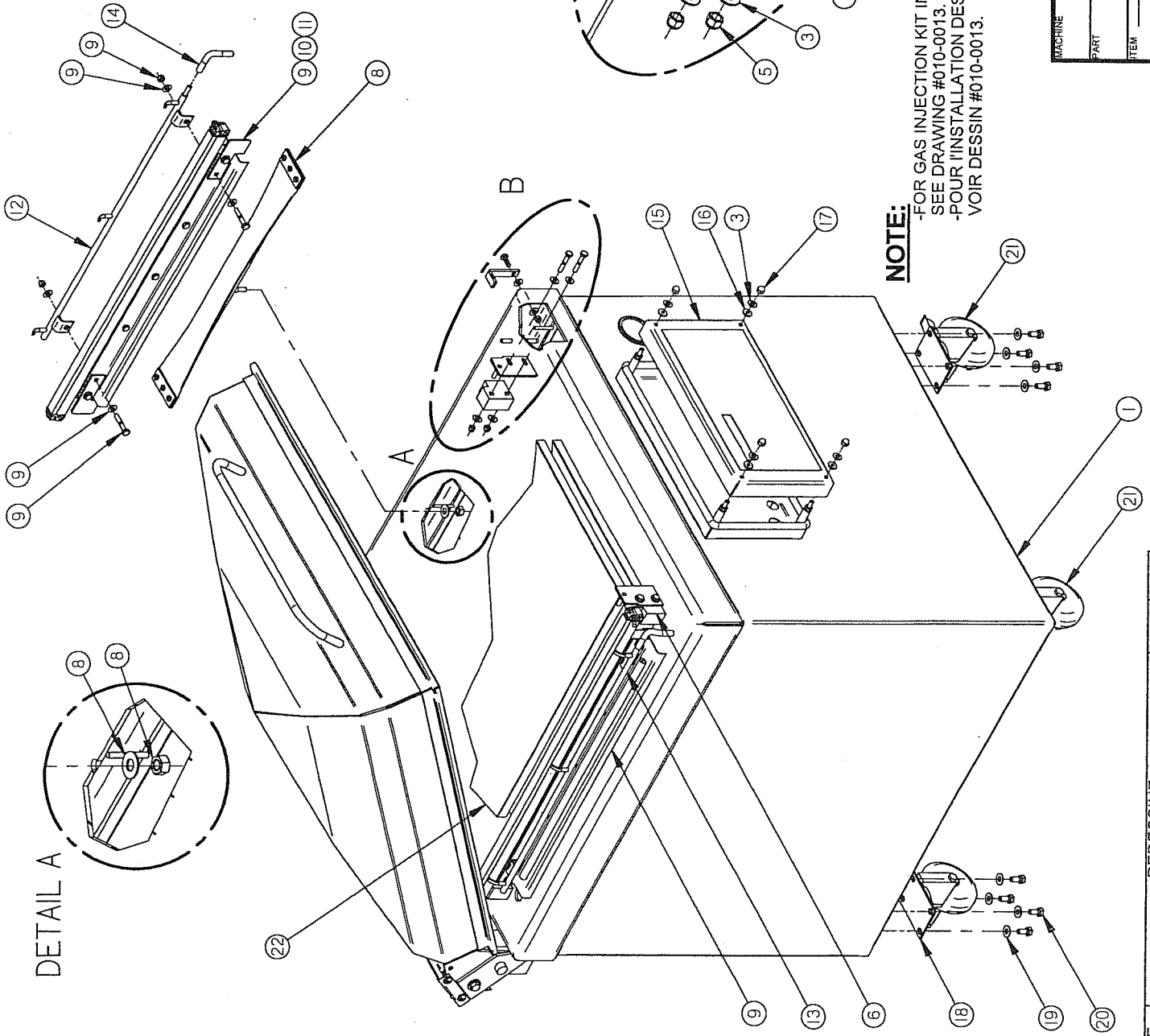


MECHANICAL DRAWING



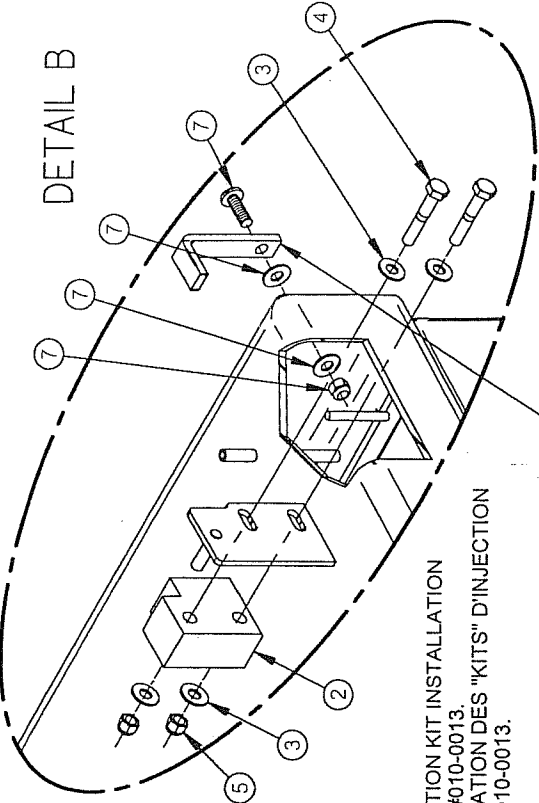
1005A0605

ITEM	PART #	DESCRIPTION	QT.
1	005A0608	MC-40 REAR VIEW	1
2	002-0326	LEFT SEAL BAR GUIDE BLOCK	2
3	051-0740	WASHER 1/4" FLAT S/S	20
4	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	8
5	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
6	002-0327	RIGHT SEAL BAR GUIDE BLOCK	2
7	004A1651	COVER HOLD DOWN PRE-ASSY	1
8	005-0320	BELLOWS ASSEMBLY	2
9	005A0568	SEAL BAR ASSY W/SUPPORT	2
10	005A0570	SEAL BAR ASSY W/SUPPORT	2
11	005A0569	SEAL BAR ASSY W/SUPPORT	2
12	005A0810	GAS 3 INJECTION BAR ASSEMBLY	1
13	005-0571	GAS 3 INJECTION BAR ASSEMBLY	1
14	008-0464	GAS INJECTION CONN. TUBE	2
15	005A0583	FRONT MC-40 SUPPORT ASSY	1
16	057-0089	1/4" x 5/8" O.D. EPDM RUB. SEAL. WASHER	4
17	051-0591	NUT 1/4"-20 ACORN S/S	4
18	130-4PHO	4" SWIVEL CASTER W/O BRAKES	2
19	051-0760	WASHER 5/16" FLAT S/S	16
20	052-0520	BOLT 5/16"-18nc. X 3/4" ZINC	16
21	130-4PHB	4" SWIVEL CASTER W/BRAKE	2
22	005A0340	FILLER PLATE ASSEMBLY	2



NOTE:
 -FOR GAS INJECTION KIT INSTALLATION
 -SEE DRAWING #010-0013.
 -POUR L'INSTALLATION DES "KITS" D'INJECTION
 VOIR DESSIN #010-0013.

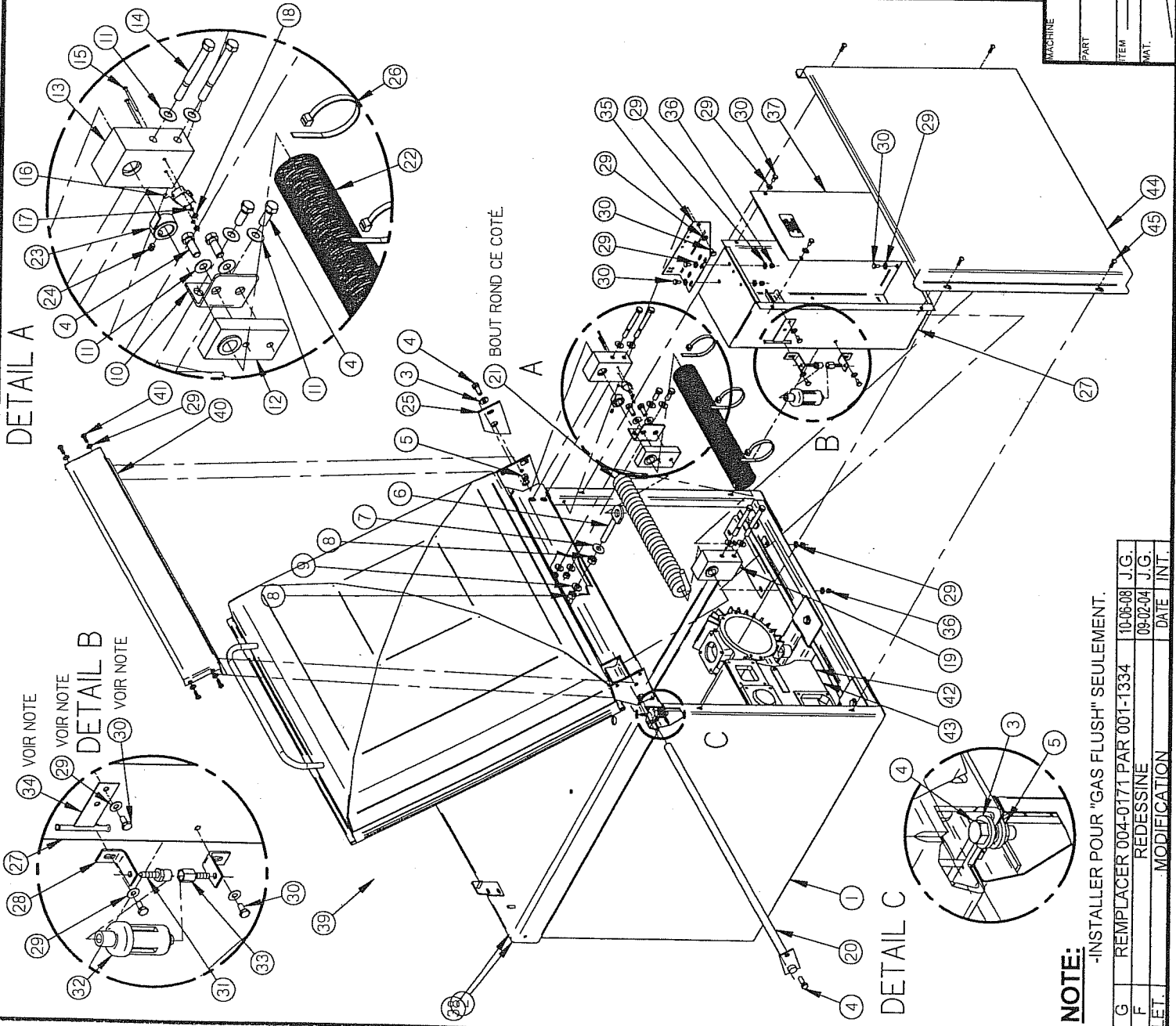
INSTALL TO MOVE FREELY (7) INSTALLER POUR UN MOUVEMENT LIBRE



MACHINE	550A	DEPT. TO: METRIC INCH	
PART	MC-40 FRONT VIEW	USINAGE ± 0.1 ± 0.004	SIPROMAC
ITEM		COUPE ± 0.5 ± 0.020	ST-GERMAIN DE GRANTHAM
MAT.		SOUDEGE ± 0.3 ± 0.020	QUEBEC CANADA
			N.T.S.
			DEPT. M-1
			QTY. 1
			DATE 09-01-26
			NO. 005A0605
			REV. 02-10
			DESIGNED BY J.G.
			APP. BY
			RECESSINE
			MODIFICATION
			DATE 09-02-04
			INT.

E
 LET. RECESSINE
 MODIFICATION
 DATE 09-02-04
 INT.

005A0608



ITEM	PART #	DESCRIPTION	QT
1	005B0606	MC-40 STRUCTURE ASSEMBLY	1
2	005A0341	TABLE ASSEMBLY	1
3	051-0783	WASHER 3/8" FLAT THICK S/S	15
4	051-0360	BOLT 3/8"-16nc. X 1" S/S	10
5	051-0620	NUT 3/8"-16 NC S/S	12
6	005-0346	SPRING TENSION SUPPORT PRE-ASSY	1
7	051-0790	WASHER 1/2" FLAT S/S	1
8	051-0630	NUT 1/2"-13 S/S	2
9	051-0792	WASHER 1/2" FLAT THICK S/S	1
10	001-1540	CENTRAL COVER AXIS SUPPORT FIXATION	1
11	051-0780	WASHER 3/8" FLAT S/S	8
12	004-0276	CENTRAL COVR AXIS SUPPORT	1
13	004-0274	LEFT COVER AXIS SUPPORT	1
14	051-0424	BOLT 3/8"-16 x 3-1/2" SS	4
15	051-0094	SCREW 4-40 X 1 1/2" FLAT SLOT SS	2
16	026-0610	LIMIT SWITCH LONG ROLLER	1
17	051-0715	WASHER #4 LOCK SS	2
18	051-0540	NUT #4-40 HEX S/S	2
19	004-0275	RIGHT COVER AXIS SUPPORT	1
20	004-0129	COVER AXIS PRE-ASSY	1
21	008-0322	COVER SPRING	1
22	038-0350	SLIT CORRUG. LOOM 2" ID x 370mm (1.27')	1
23	005-0348	MICRO SWITCH COLLAR ASSY	1
24	051-0178	SCREW 1/4"-20 x 5/16" SKT SET S/S	1
25	001-1335	COVER STOPPER	1
26	057-0330	CABLE TIES 14" LONG BLACK	3
27	005-0347	ELECTRICAL BOX PRE-ASSY	1
28	001-2062	DRYER SUPPORT	2
29	051-0740	WASHER 1/4" FLAT S/S	20
30	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	12
31	101-0200	STRAIGHT 1/4" MNPT x 1/4" HOSE BARB	1
32	114-2020	FILTER / DRYER 1/2"mppt. X 3/8"lp. COMP.	1
33	101-0210	STRAIGHT 1/4"FNPTx1/4"HOSE BARB	1
34	005-0323	INLET ASSEMBLY	1
35	001A2810	UPPER ELECTRICAL BOX SUPPORT	1
36	051-0581	NUT 1/4"-20 NYLON LOCK S/S	5
37	004-0273	ELECTRICAL BOX COVER ASSEMBLY	1
38	005A0461	8" COVER ASSEMBLY	1
39	005A0462	12" COVER ASSEMBLY	1
40	001-1334	SPRING COVER	1
41	051-0192	SCREW 1/4"-20NC X 3/4" PAN PHILL S/S	4
42	010A0062	PUMP INSTALLATION 63M3	1
43	010A0063	PUMP INSTALLATION 100M3	1
44	004A2834	REAR PANEL PRE-ASSY	1
45	052-0420	SCREW 1/4"-20 N.C x 3/4" PAN SLOT BRASS	4

550A
MC-40 REAR VIEW

DEPT. DIM. INCH
USINAGE ±0.1 ±0.004
TOLERANCE ±0.5 ±0.025
SOUDAGE ±0.5 ±0.025

N.T.S.

MACHINE PART ITEM MAT.

CNC DWG BY: J.G. DATE: 09-02-04
APP. BY: J.G. DATE: 10-06-08

DEPT. M-I QTY. 1

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

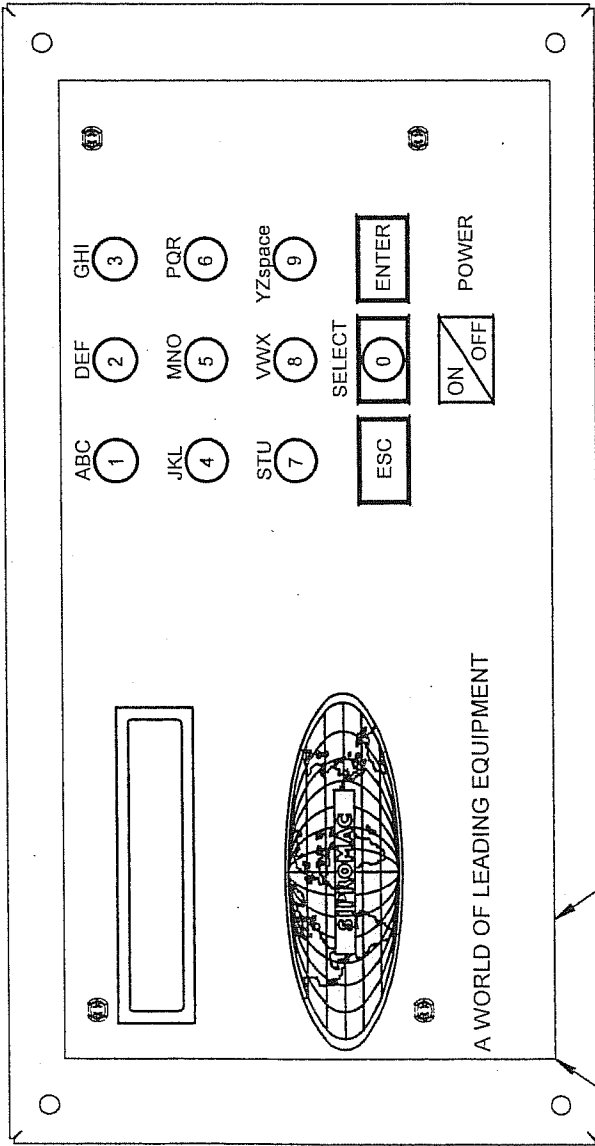
005A0608

NOTE:
-INSTALLER POUR "GAS FLUSH" SEULEMENT.
REPLACER 004-0171 PAR 001-1334

G	REDESSINE	10-06-08	J.G.
F	MODIFICATION	09-02-04	J.G.
LET.		DATE	INT.

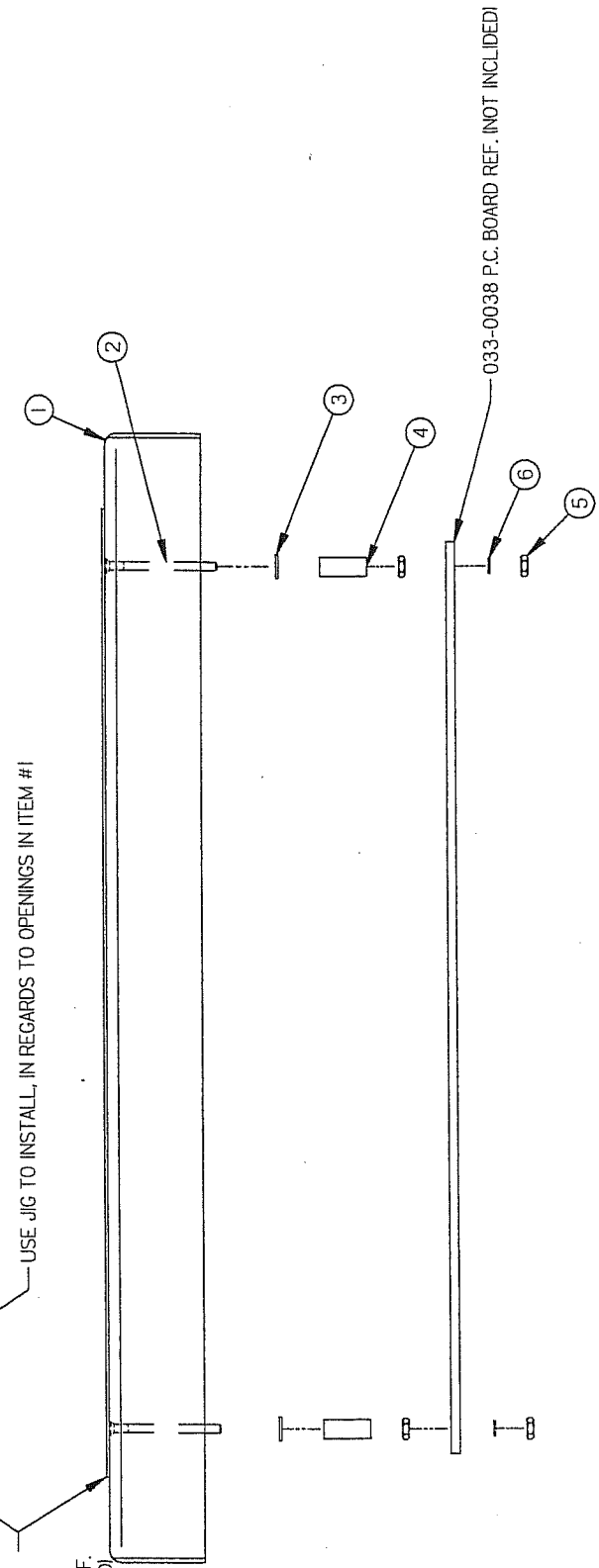
005A0583

ITEM	PART #	DESCRIPTION	QTY
1	004A0425	FRONT MC-40 SUPPORT PRE-ASSY	1
2	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	8
6	051-0715	WASHER #4 LOCK SS	4



033-0015 OR
033-0017 OR
033-0018 OR
KEY BOARD REF.
(NOT INCLUDED)

USE JIG TO INSTALL, IN REGARDS TO OPENINGS IN ITEM #1

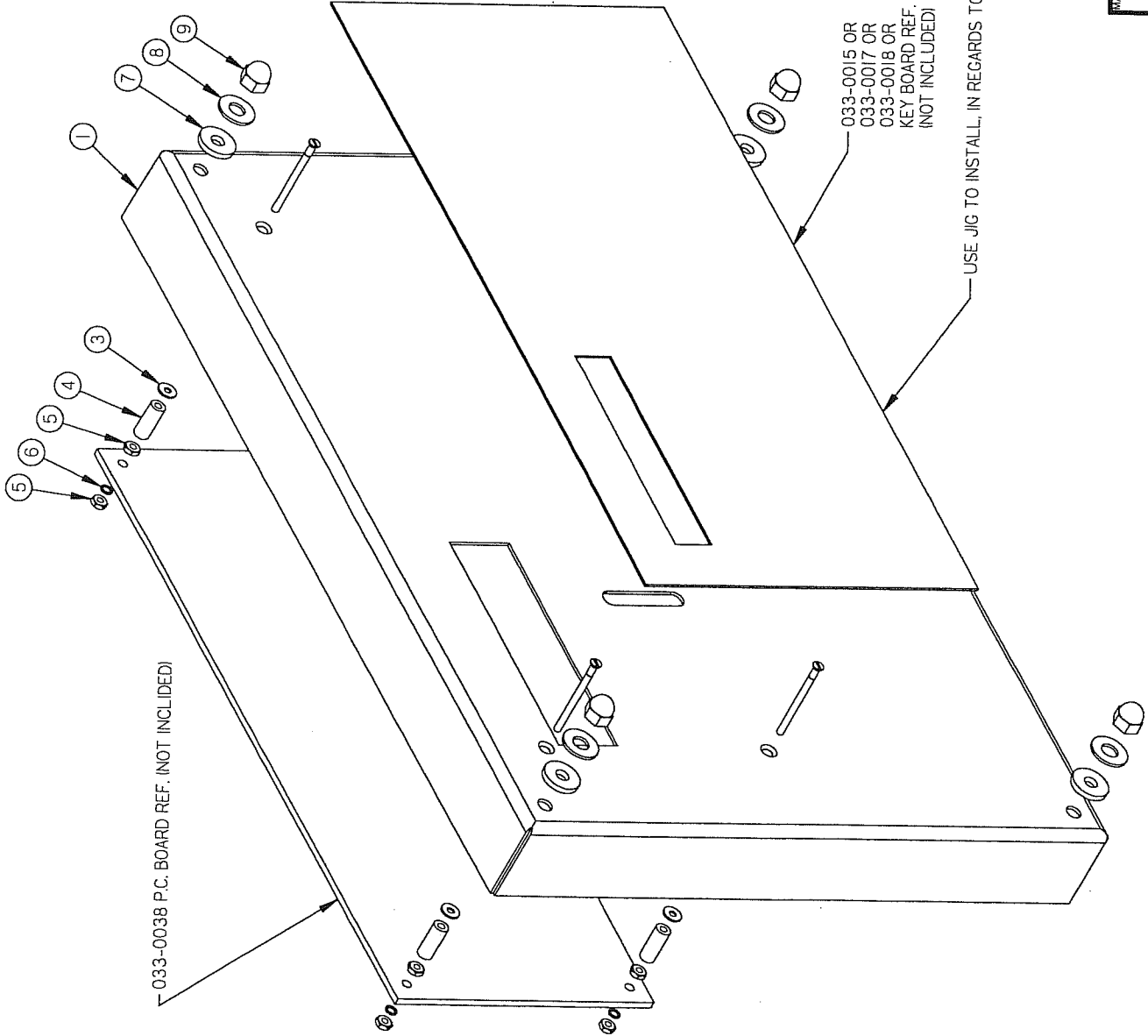


H	A-ROUTER 500D	08-04-17	J.G.
G	REDRAWN	05-09-01	M.A.
LET.	MODIFICATION	DATE	INT.

MACHINE	420A, 450A, 450T, 500A, 500D, 550A, 580A, 600A, 620A & 650A	DEPT.	SIPROMAC
PART	FRONT MC-40 SUPPORT ASS'Y	DATE	05-09-01
ITEM	FRONT MC-40 SUPPORT ASS'Y	APP. BY	M.A.L.
QTY.	1	DATE	05-09-01
NO.	005A0583	DATE	05-09-01
DEPT.	N.T.S.	DATE	05-09-01
DEPT.	N.T.S.	DATE	05-09-01
DEPT.	N.T.S.	DATE	05-09-01

005A0779

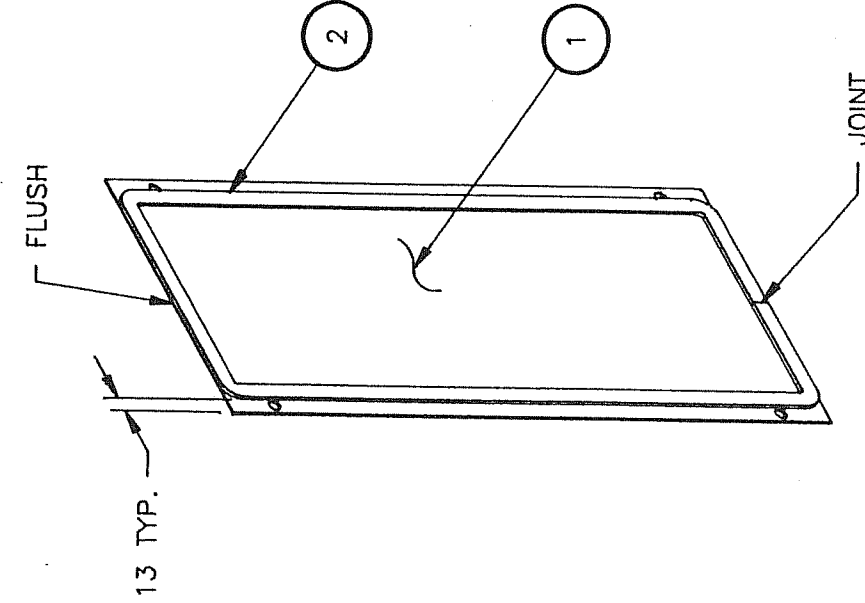
ITEM	PART #	DESCRIPTION	QT.
1	004A3166	FRONT MC-40 SUPPORT PRE-ASSY(OPT. HEATER)	1
2	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	8
6	051-0715	WASHER #4 LOCK SS	4
7	057-0089	1/4" x 5/8" O.D. EPDM RUB. SEAL. WASHER	4
8	051-0740	WASHER 1/4" FLAT S/S	4
9	051-0591	NUT 1/4"-20 ACORN S/S	4



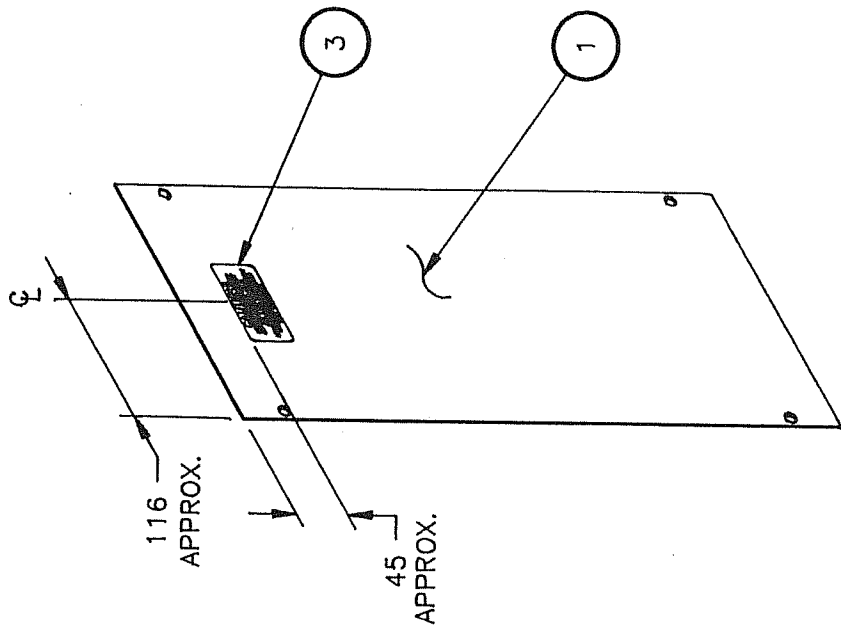
MACHINE	420A, 450A, 550A, 580A, 600A, 620A & 650A	DEPT.	M	QTY.	1
PART	FRONT MC-40 SUPPORT ASSY(OPT. HEATER)	DATE	10-02-03	NO.	005A0779
ITEM		DATE	10-02-05		
TOLERANCES: DIMENSIONS: ±0.001 TOU: ±0.5 TOLE: ±0.5 SOUDAGE: ±0.5		N.T.S.		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
DRAWN BY: M.D. APP. BY:		MODIFICATION:			
DATE:		DATE:			

004-0273

ITEM	PART #	DESCRIPTION	QT.
1	001-1341	ELECTRICAL BOX COVER	1
2	179-0004	NEOPRENE SPONGE 1/8" X 1/2" ADHESIVE	1
3	127-0100	"CAUTION" YELLOW STICKER	1



--REAR VIEW--

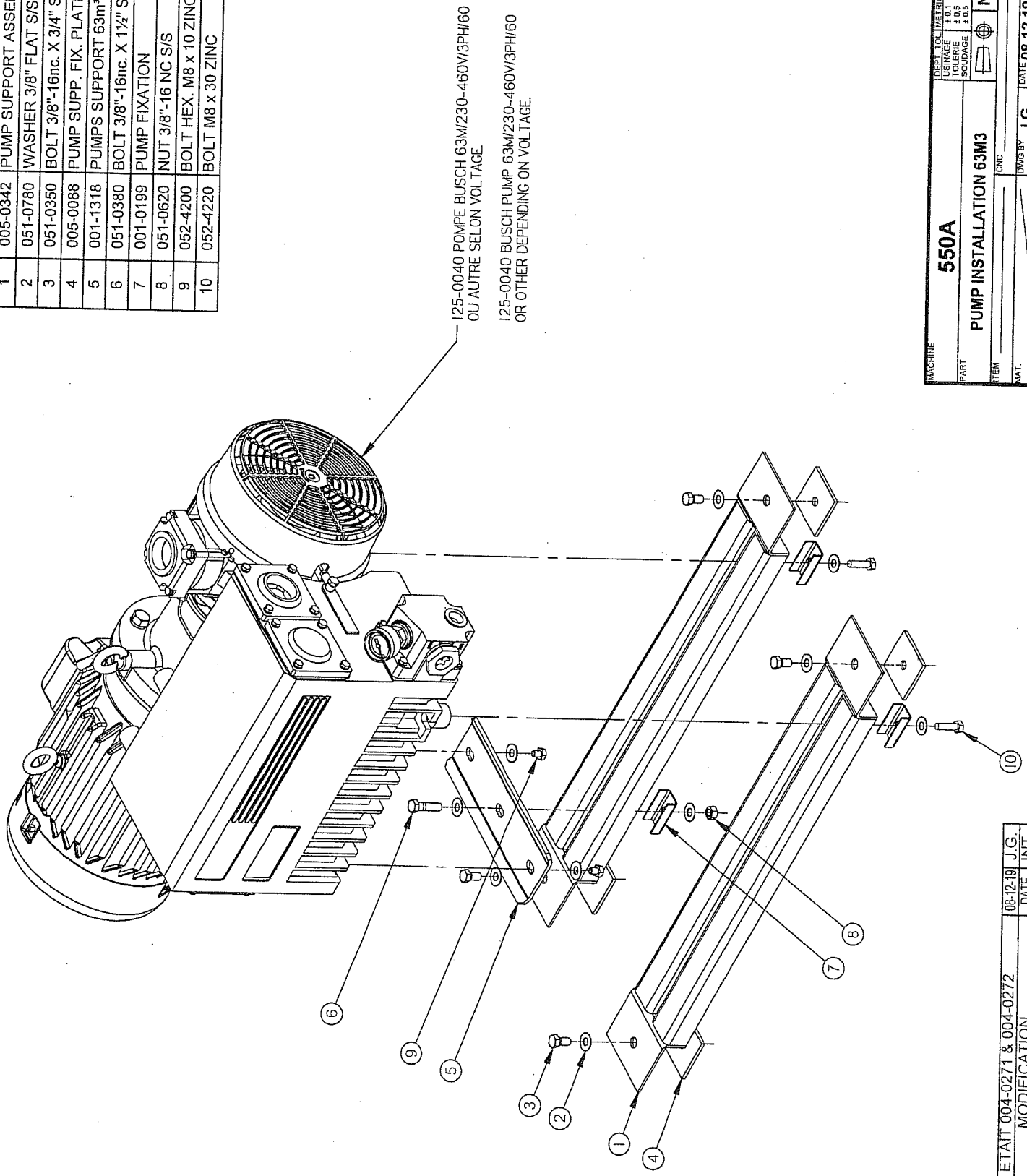


--FRONT VIEW--

MACHINE	450A & 550A	SIPROMAC	SCALE	1
PART	E-BOX COVER PRE-ASS'Y	ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	INCH TOLERANCE	0 ± .015"
ITEM:	CNC		METRIC TOLERANCE	0 ± .5 0 ± .05 0.00 ± .005 0.000 ± .0005 ANGLE ± 1'
MAT:	DWG A.P.	DATE 97-01-08	N.T.S.	
LET.	MODIFICATION	DATE	INT.	NO. 004-0273

010A0062

ITEM	PART #	DESCRIPTION	QT.
1	005-0342	PUMP SUPPORT ASSEMBLY	2
2	051-0780	WASHER 3/8" FLAT S/S	10
3	051-0350	BOLT 3/8"-16nc. X 3/4" S/S	4
4	005-0088	PUMP SUPP. FIX. PLATE ASSY	4
5	001-1318	PUMPS SUPPORT 63m ³ & 100m ³	1
6	051-0380	BOLT 3/8"-16nc. X 1 1/2" S/S	1
7	001-0199	PUMP FIXATION	3
8	051-0620	NUT 3/8"-16 NC S/S	1
9	052-4200	BOLT HEX. M8 x 10 ZINC	2
10	052-4220	BOLT M8 x 30 ZINC	2

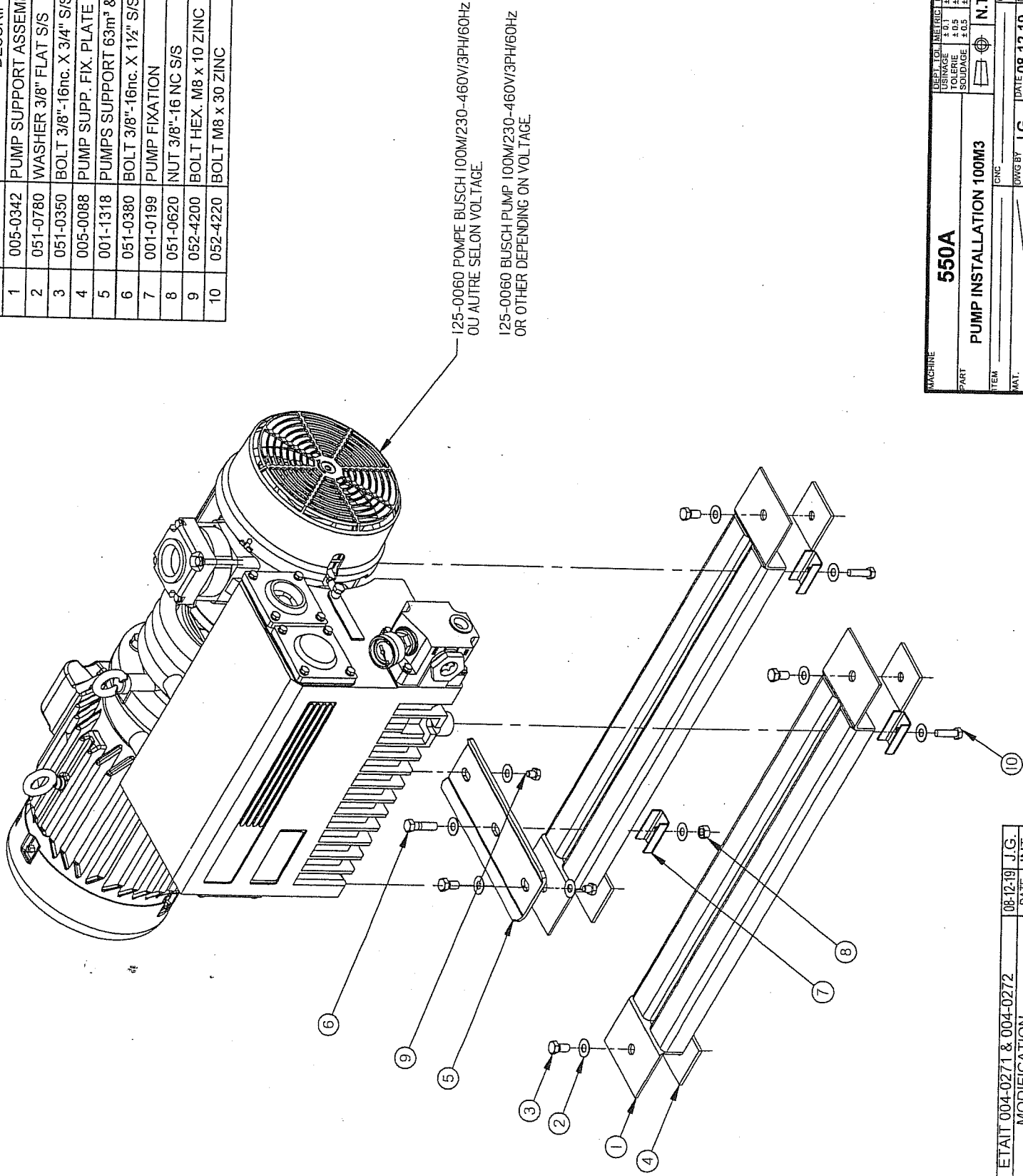


MACHINE		DEPT. VOL. METRIC INCH		SIPROMAC	
PART		USINAGE ±0.1 ±0.007	TOURNAGE ±0.05 ±0.007	ST-GERMAIN DE GRANTHAM	
ITEM		SOUDAGE ±0.3 ±0.020	INT.S.	QUEBEC CANADA	
MAT.		CNC		DEPT.	NO.
DRAWN BY J.G.		DATE 08-12-19	NO.	M-1	
APP. BY		DATE 08-12-19	NO.	010A0062	
PUMP INSTALLATION 63M3		N.T.S.		QTY. 1	
550A					

A	ETAIT 004-0271 & 004-0272	08-12-19	J.G.
LET.	MODIFICATION	DATE	INT.

010A0063

ITEM	PART #	DESCRIPTION	QT.
1	005-0342	PUMP SUPPORT ASSEMBLY	2
2	051-0780	WASHER 3/8" FLAT S/S	10
3	051-0350	BOLT 3/8"-16nc. X 3/4" S/S	4
4	005-0088	PUMP SUPP. FIX. PLATE ASSY	4
5	001-1318	PUMPS SUPPORT 63m ³ & 100m ³	1
6	051-0380	BOLT 3/8"-16nc. X 1 1/2" S/S	1
7	001-0199	PUMP FIXATION	3
8	051-0620	NUT 3/8"-16 NC S/S	1
9	052-4200	BOLT HEX. M8 x 10 ZINC	2
10	052-4220	BOLT M8 x 30 ZINC	2

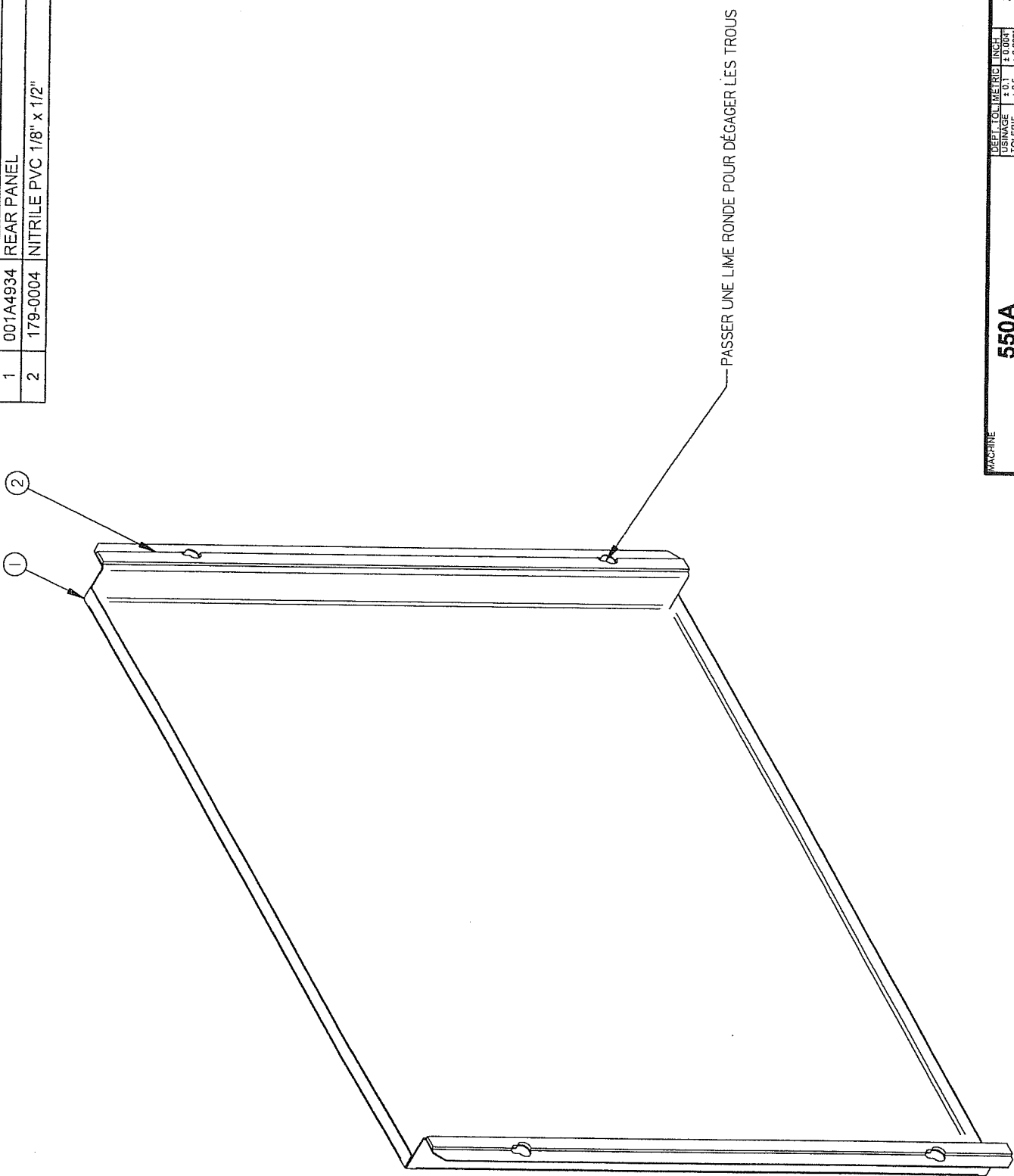


MACHINE	550A		DEPT. TO METRIC INCH	GBPT.	M-1	QTY.	1
PART	PUMP INSTALLATION 100M3		± 0.004	NO.	010A0063		
ITEM	CNC		± 0.01	DATE	08-12-19		
MAT.	DWG BY J.G.		TOLERANCE	DATE	08-12-19		
	APP. BY		SOUDAGE	DATE	08-12-19		
			± 0.5				
			± 0.025				
			N.T.S.				

A	ETAIT 004-0271 & 004-0272	08-12-19	J.G.
LET.	MODIFICATION	DATE	INT.

004A2834

ITEM	PART #	DESCRIPTION	QT.
1	001A4934	REAR PANEL	1
2	179-0004	NITRILE PVC 1/8" x 1/2"	2



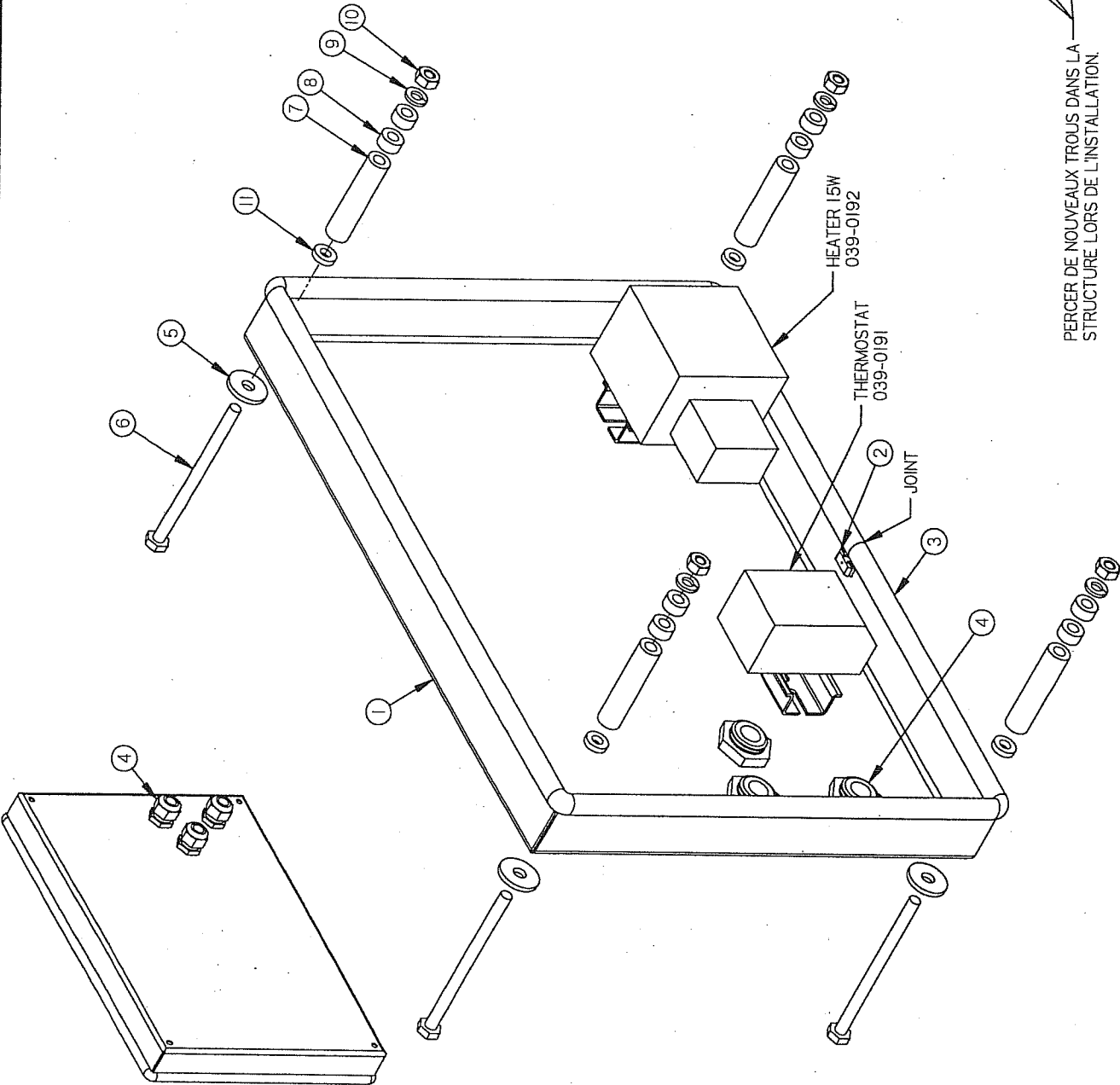
MACHINE	550A	DEPT. TOL. METRIC	INCH	SIPROMAC
PART	REAR PANEL PRE-ASSY	USINAGE	± 0.008	ST-GERMAIN DE GRANTHAM
ITEM		TOLERIE	± 0.5	QUEBEC CANADA
MAT.		SOUDEAGE	± 0.5	
		N.T.S.		
		DATE	08-12-19	NO
		DWG BY	J.G.	004A2834
		APP. BY	[Signature]	
		DEPT.	M	QTY.
				1

TFT | _____ | DATE | INT. | _____ |

MODIFICATION

005A0780

ITEM	PART #	DESCRIPTION	QT.
1	004A3167	REAR MC-40 SUPPORT PRE-ASSY	1
2	057-0002	CABLE CLAMPS 9mm (1,2 X 9,3)	1
3	179-0019	U-CHANNEL BLACK EPDM FOAM (4.5265)	1
4	036-0409	PRESSE-ETOIPE CD13	3
5	051-0757	WASHER 1/4" FLAT THICK S/S	4
6	051-02885	BOLT 1/4-20 x 3-3/4" HEX SS	4
7	058-0139	NYLON SPACER 1/4" ID X 1/2" OD X 2-1/8"	4
8	058-0025	NYLON SPACER 0.257" ID x 0.500" OD x 1/4"	8
9	051-0750	WASHER 1/4" LOCK S/S	4
10	051-0580	NUT 1/4"-20 S/S	4
11	058-0016	NYLON SPACER .252" ID X 1/2" OD X 1/8" THK	4



COUPER AVEC DES PINCES
ICI DES 2 CÔTES.

CUT OFF W/PLIERS
HERE BOTH SIDES.

UTILISER LES TROUS EXISTANTS DE LA
STRUCTURE LORS DE L'INSTALLATION.

USE EXISTING HOLES IN STRUCTURE
DURING INSTALLATION.

PERCER DE NOUVEAUX TROUS DANS LA
STRUCTURE LORS DE L'INSTALLATION.

DRILL NEW HOLES IN STRUCTURE
DURING INSTALLATION.

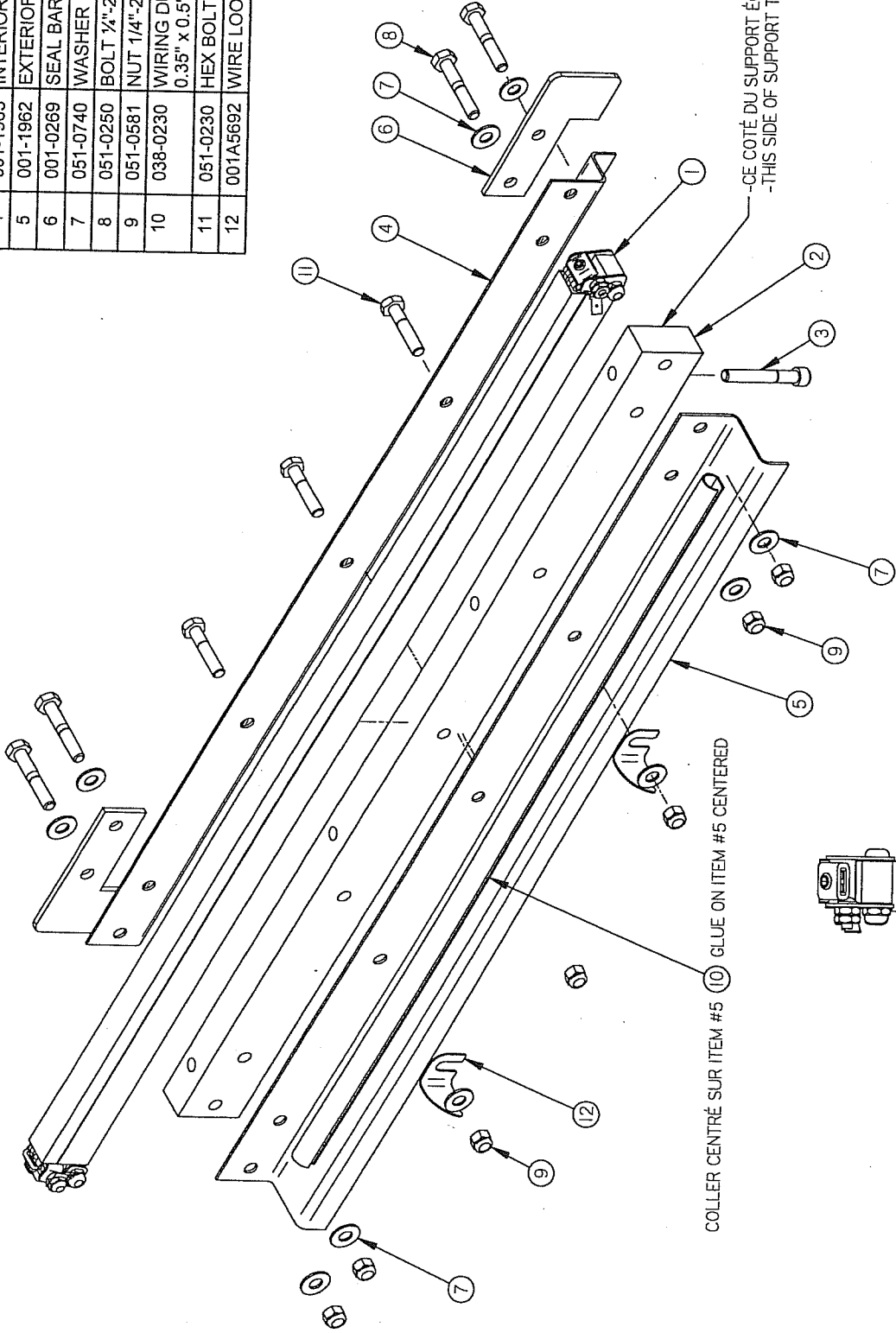
MACHINE	420A, 450A, 550A, 580A, 600A, 620A & 650A	DEPT. TOI METRIC INCH	
PART	REAR MC-40 SUPPORT ASSY(OPT. HEATER)	USINAGE	± 0.1 ± 0.004
ITEM		TOLERANCE	± 0.5 ± 0.020*
MAT.		SOUDAGE	± 0.3 ± 0.020
		N.T.S.	
		DEPT.	M-(M)-I
		QTY.	1

LET.	A	MODIFICATION	ADJOUTER ITEM 058-0016 ET 058-0139 ETAIT 058-0140	10-09-01	J.G.
DATE					INT.

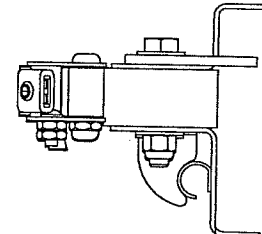
DATE	10-02-03	NO	005A0780
APP. BY	M.D.		

005A0568

ITEM	PART #	DESCRIPTION	QT.
1	005A0152	SEAL BAR PRE-ASSY	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOW COVER	1
5	001-1962	EXTERIOR BELLOW COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	10
8	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7))	1
11	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3
12	001A5692	WIRE LOOM SUPPORT #2	2



--CE COTÉ DU SUPPORT ÉGAL AVEC DE LA BARRE DE SCELLAGE.
 --THIS SIDE OF SUPPORT TO FIT FLUSH W/ SEAL BAR.



-END VIEW-

-ITEM #2 ÉGAL AVEC L'ITEM #4 & #5.
 -ITEM #2 FLUSH WITH ITEM #4 & #5.

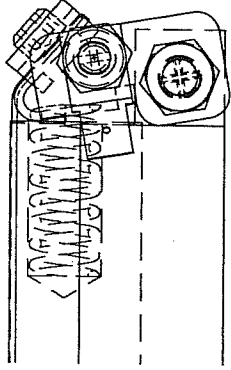
-TWIN SEAL OPTION -

MACHINE	550A & 600A	DEPT. / DIV. / METRIC / INCH	600A 4
PART	SEAL BAR ASSY W/SUPPORT	UNFINISH ± 0.004	550A 2
ITEM		TURNER ± 0.1	MACHINE QTY
MAT.		TOURNER ± 0.5	SIPROMAC
		SOLDAGE ± 0.007	ST-GERMAIN DE GRANTHAM
			QUEBEC CANADA
		DEPT. /	M-1-(M) LISTE
		DATE 11-08-30	NO. 005A0568
		APP. BY J.G.	

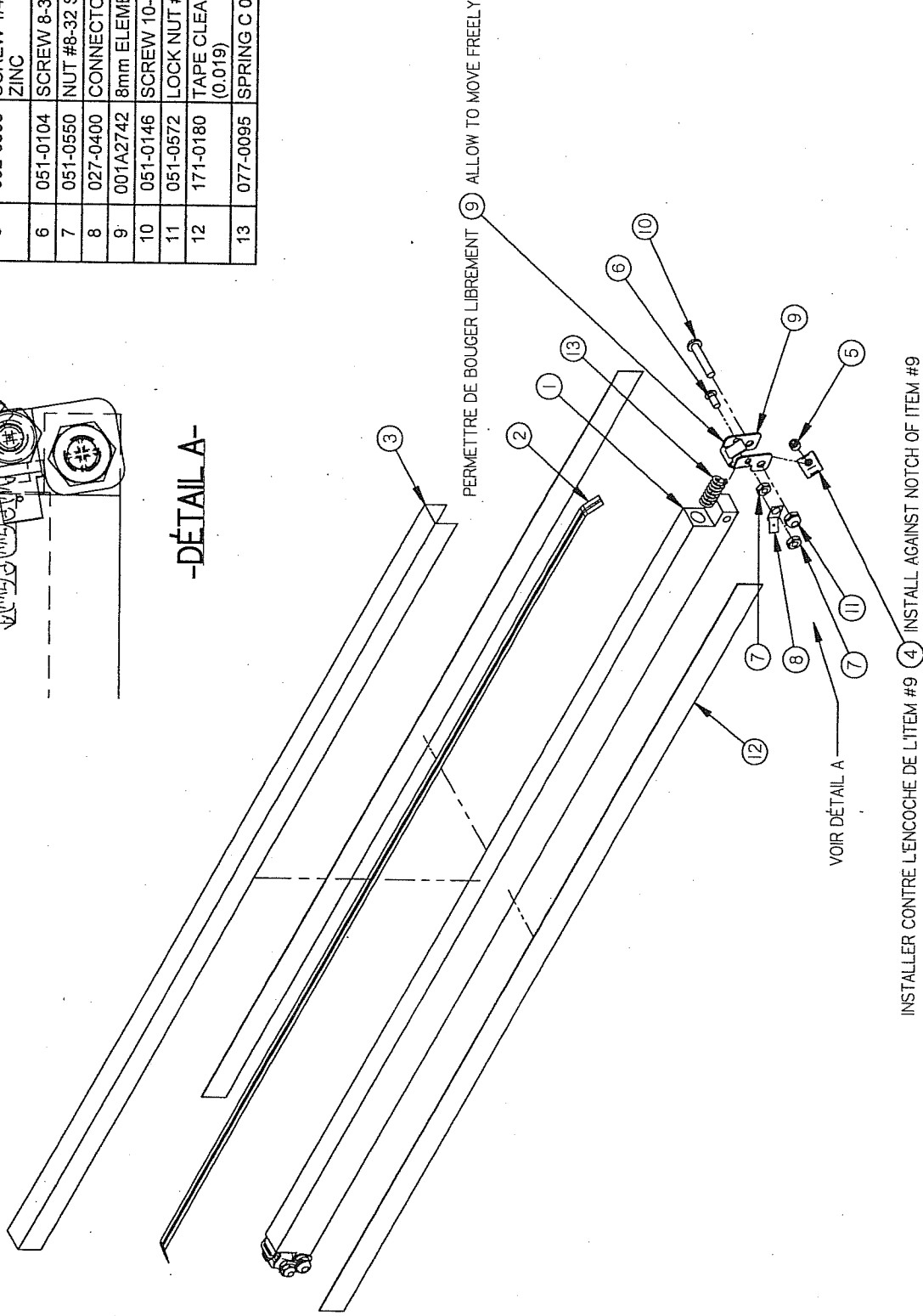
D	REDESSINE - AJOUTER 001A5692	11-08-30	J.G.
LET.	MODIFICATION	DATE	INT.

005A0152

ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	039-0268	DOUBLE SEAM BAND (8MM) (2.3)	1
3	176-0200	TEFLON TAPE, 5MIL (0.78)	1
4	056-1401	3/8"SET SCREW BANDING BUCKLE S/S	2
5	052-0393	SCREW 1/4-28x3/16"SKT SET OVAL POINT ZINC	2
6	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
7	051-0550	NUT #8-32 SS	4
8	027-0400	CONNECTOR ADAPTOR	2
9	001A2742	8mm ELEMENT BINDER	2
10	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
11	051-0572	LOCK NUT #10-24 S/S	2
12	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2
13	077-0095	SPRING C 0360-059-1250 S/S	2



-DÉTAIL A-



INSTALLER CONTRE L'ENCOCHE DE L'ITEM #9 (4) INSTALL AGAINST NOTCH OF ITEM #9

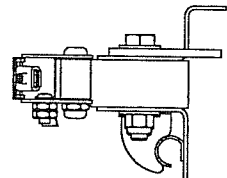
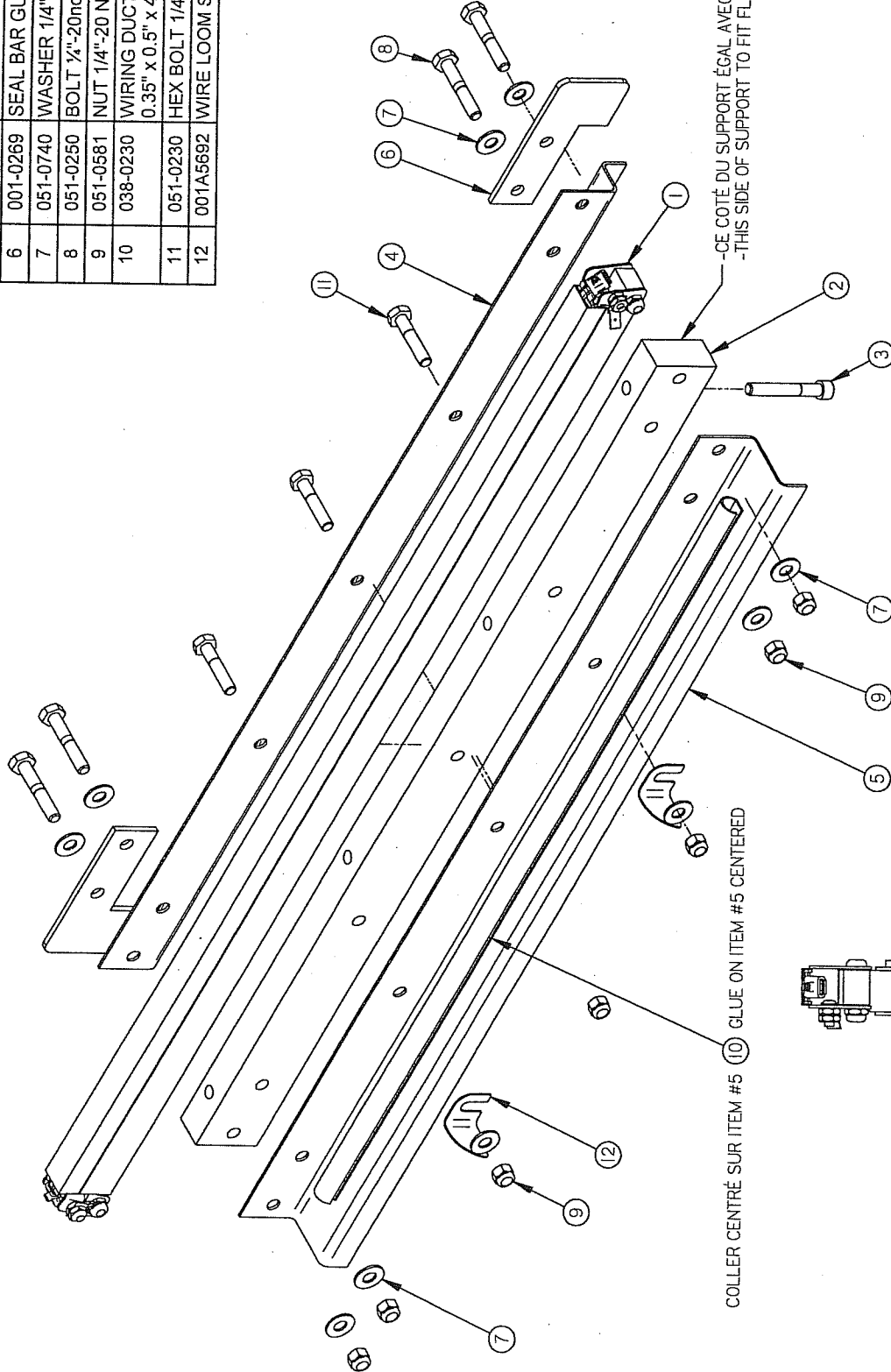
-TWIN SEAL OPTION-

MACHINE	600A	4
PART	550A	2
ITEM	MACHINE QTY	
MAT.	SIPROMAC ST GERMAN DE GRANTHAM QUEBEC CANADA	
DEPT. TO: METRIC INCH		
TOLERANCE		
FINISH	+ 0.1	+ 0.004"
THICKNESS	+ 0.1	+ 0.004"
WELDING	+ 0.5	+ 0.020"
N.T.S.		
DATE	05-09-13	NO.
APP. BY	M.A.L.	DATE
M-(M)-I QTY LISTE		
005A0152		

H	MODIF. A-453 AJOUTER 077-0095	10-06-01	J.G.
G	ADDED 052-0393	06-04-19	M.A.
F	051-0104 & 001B2742 ETAIT 051-0100 & 009A0187	06-03-06	J.G.
E	REDRAWN	05-09-13	M.A.
LET.	MODIFICATION	DATE	INT.

1005A0570

ITEM	PART #	DESCRIPTION	QT.
1	005A0370	SEAL BAR PRE-ASS'Y	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOW'S COVER	1
5	001-1962	EXTERIOR BELLOW'S COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	10
8	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7)	1
11	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3
12	001A5692	WIRE LOOM SUPPORT #2	2



-END VIEW-

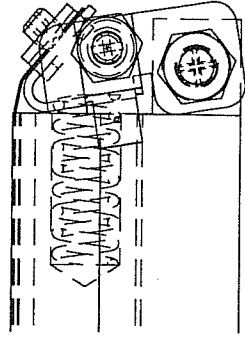
-TOP & BOTTOM SEALING OPTION-

MACHINE	550A & 600A	DEPT.	M-I-(M) LIST
PART	SEAL BAR ASS'Y W/SUPPORT	DATE	11-08-30
ITEM		APP. BY	J.G.
MAT.		DATE	11-08-30
MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED: FRACTIONS ± 0.0005" DECIMALS ± 0.005" HOLE DIA. ± 0.0025" SLOTTAGE ± 0.005"		N.T.S.	
ST-GERMAIN DE GRANBY/QUEBEC CANADA		600A 4 550A 2 MACHINE QTY	
SIPROMAC		NO 005A0570	

C	REDESSINE - AJOUTER 001A5692	11-08-30	J.G.
LET.	MODIFICATION	DATE	INT.

005A0370

ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	001-2666	ELEMENT BINDER	2
3	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
4	051-0572	LOCK NUT #10-24 S/S	2
5	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
6	051-0550	NUT #8-32 SS	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm 641.5mm (0.64)	1
9	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" 641.5mm (0.078)	1
10	039-0220	BI-ACTIVE SEALING ELEMENT (0.07)	1
11	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
12	176-0200	TEFLON TAPE, 5MIL (0.78)	1
13	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2
14	077-0095	SPRING C 0360-059-1250 S/S	2

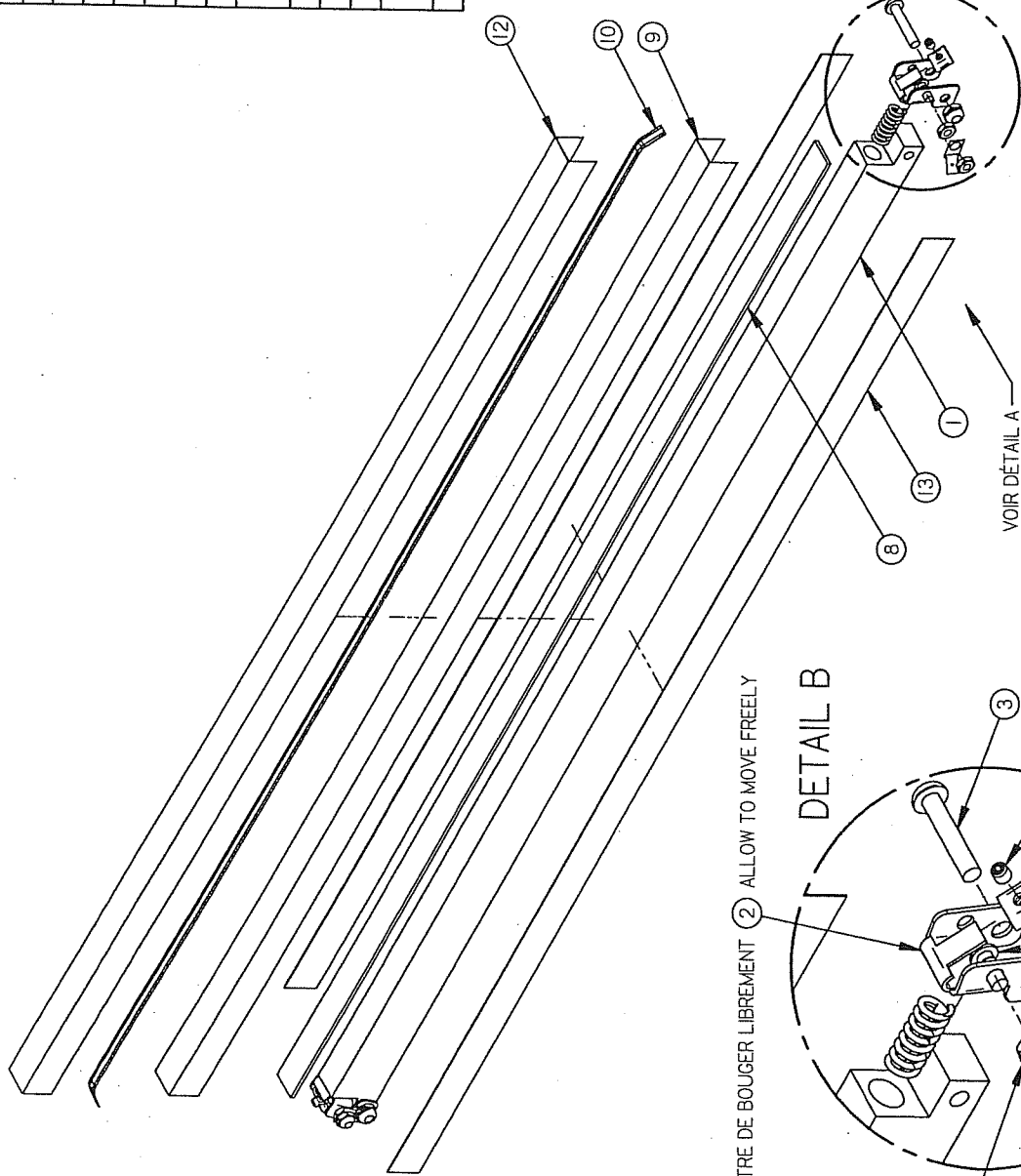


-DÉTAIL A-

-TOP & BOTTOM
SEALING OPTION-

600A	4
550A	2
MACHINE	QTY
SIPROMAC	
ST-GERMAIN DE GRANITUM QUEBEC CANADA	

MACHINE	550A & 600A
PART	SEAL BAR PRE-ASSY
ITEM	CNC
DATE	07-12-17
BY	M.A.L.
DEPT.	
NO	005A0370
LISTE	



PERMETTRE DE BOUGER LIBREMENT (2) ALLOW TO MOVE FREELY

DETAIL B

VOIR DÉTAIL A

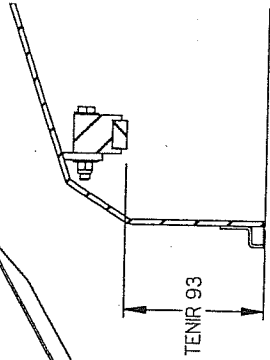
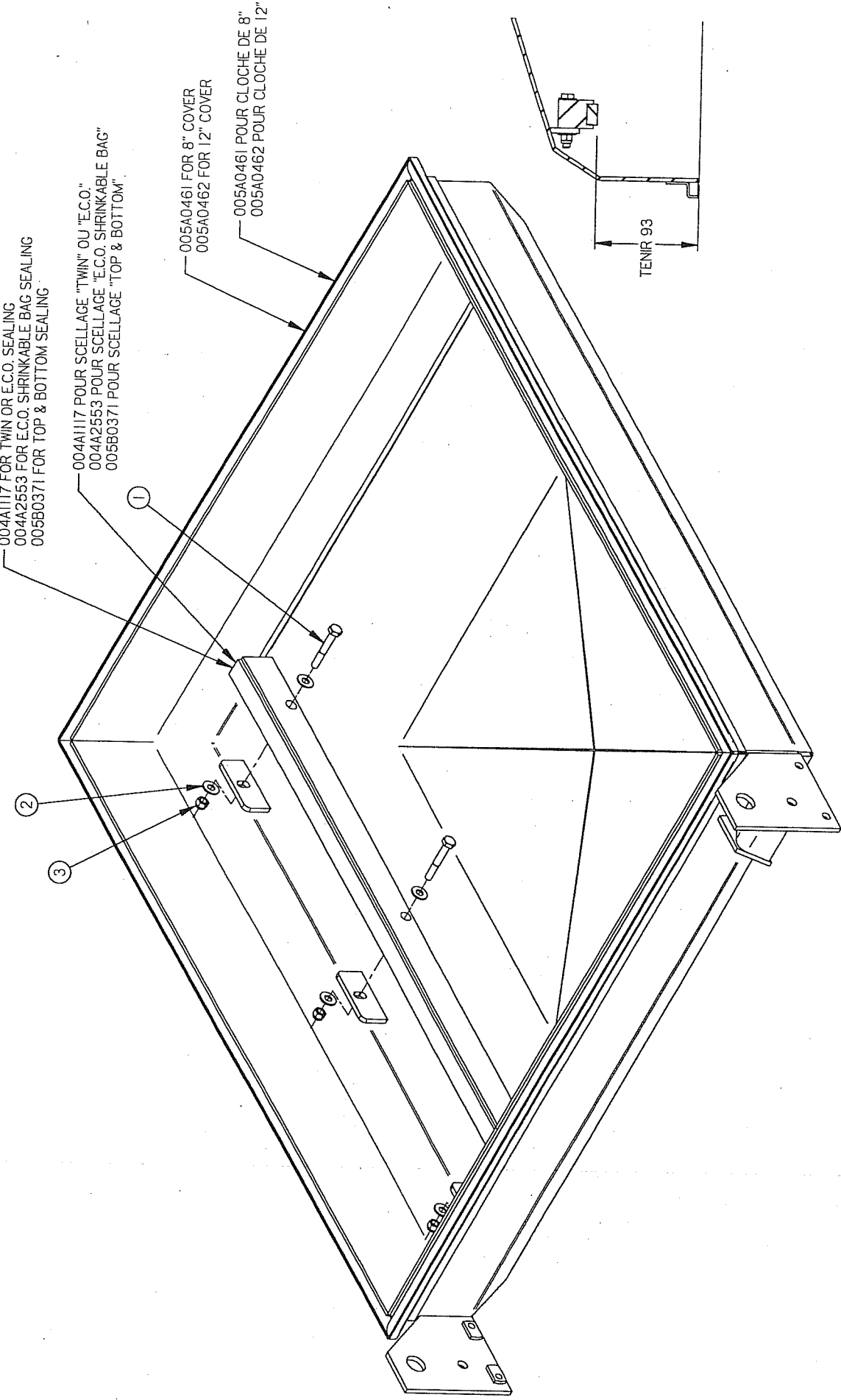
INSTALLER CONTRE L'ENCOCHE DE L'ITEM #2 (1) INSTALL AGAINST NOTCH OF ITEM #2

F	MODIF. A-463 AJOUTER 077-0095	10-06-01	J.G.
E	REDRAWN	07-12-17	M.A.
LET.	MODIFICATION	DATE	INT.

010A0064

ITEM	PART #	DESCRIPTION	QT.
1	051-0255	BOLT 1/4"-20 X 1-3/4" HEX SS	6
2	051-0740	WASHER 1/4" FLAT S/S	12
3	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6

004A1117 FOR TWIN OR E.C.O. SEALING
 004A2553 FOR E.C.O. SHRINKABLE BAG SEALING
 005B0371 FOR TOP & BOTTOM SEALING



MACHINE		DEPT. TOL. METRIC INCH		SIPROMAC	
PART		USINAGE ± 0.004	TOLERIE ± 0.002	ST-GERMAN DE GRANTHAM	
ITEM		SOUDEGE ± 0.5	± 0.020	QUEBEC CANADA	
DATE		N.T.S.		DEPT. M-I	
APP. BY		DATE 09-01-06		NO. 010A0064	
CNC		DAY 10-01-06		QTY. 1	
DWG BY J.G.		DATE 09-01-06		NO. 010A0064	
APP. BY		DATE 10-01-06		QTY. 1	

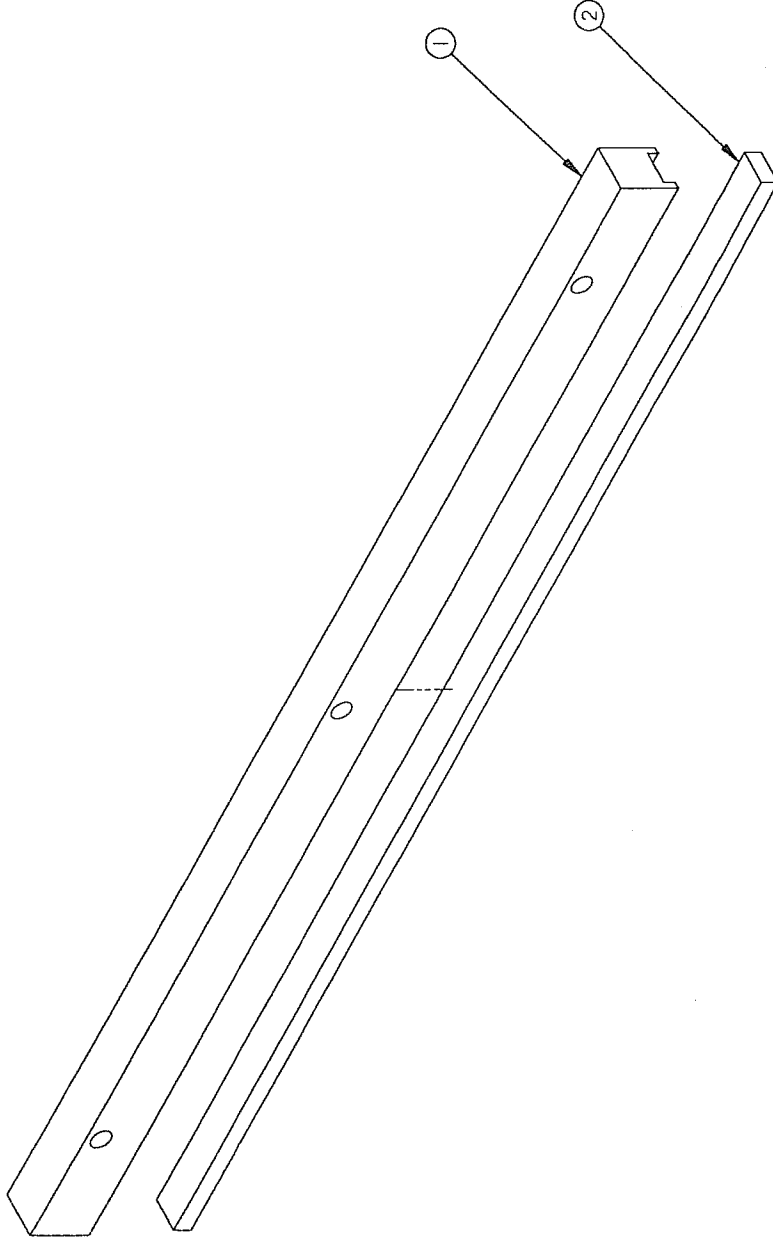
550A

UPPER SEAL BAR INSTALLATION

A	MODIF. #A-0444 ETAT 005-0461 & 005-0462	09-01-06	J.G.
LET.	MODIFICATION	DATE	INT.

1004A1117

ITEM	PART #	DESCRIPTION	QTY.
1	002A2063	UPPER SEAL BAR SUPPORT	1
2	008-0320	UPPER SEAL BAR RUBBER	1



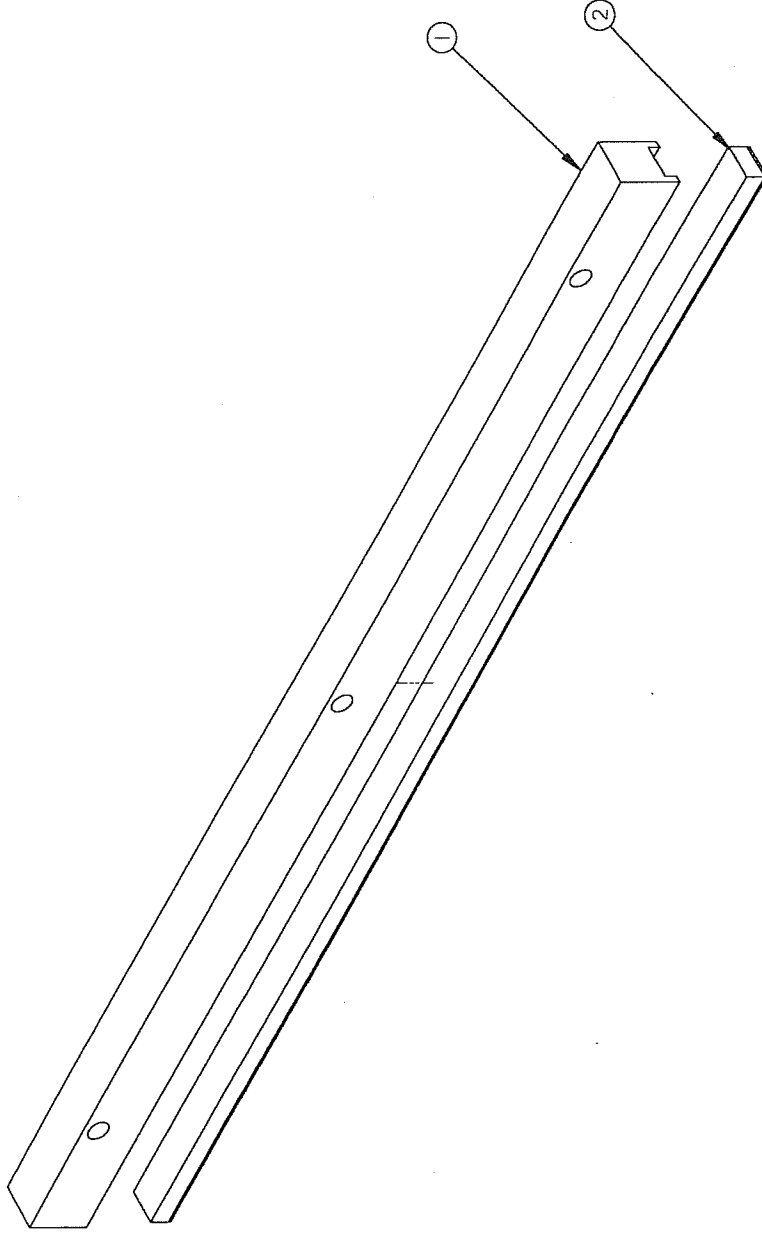
-BAG CUT OPTION & TWIN-

MACHINE	DEPT.	TOL.	METRIC	INCH	SIPROMAC
550A		USINAGE	± 0.1	± 0.004"	ST-GERMAN DE GRANTHAM
		TOLERIE	± 0.05	± 0.002"	QUEBEC CANADA
		SOUDAGE	± 0.3	± 0.020"	
UPPER SEAL BAR ASSEMBLY (E.C.O.) & (TWIN)					N.T.S.
ITEM	CNC	DEPT.	M-I	QTY.	2
DWG BY	J.G.	DATE	08-04-30	NO.	004A1117
APP. BY	J.S.	DA	07-02-23		

B	MODIF. #A-0444 / AJOUTER TWIN ETAIT 004A0132	09-01-06	J.G.
A	REDESSINE VOIR AUSSI 004A2553 & 004A2554	08-04-30	J.G.
LET.	MODIFICATION	DATE	INT.

004A2553

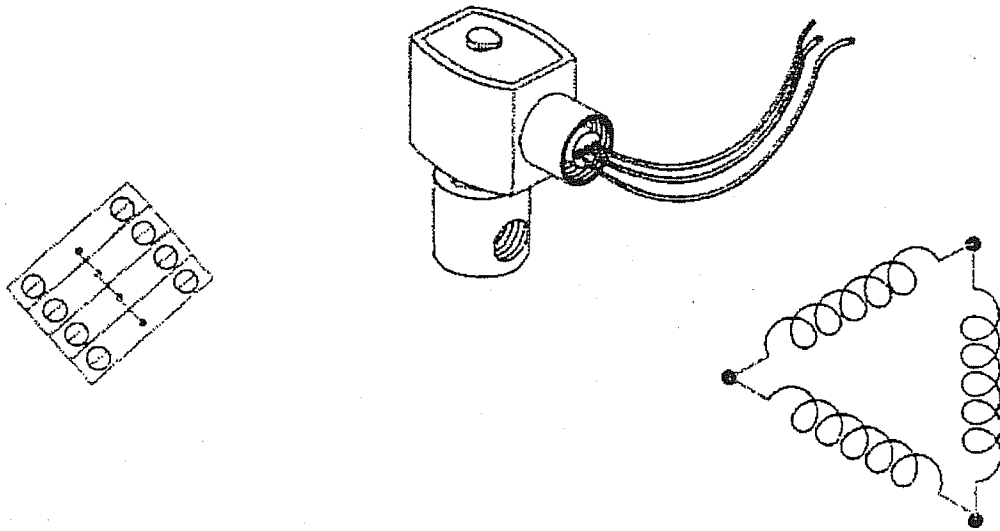
ITEM	PART #	DESCRIPTION	QT.
1	002A2063	UPPER SEAL BAR SUPPORT	1
2	004A2554	SHRINKABLE BAG TEFLON PRE-ASSY	1



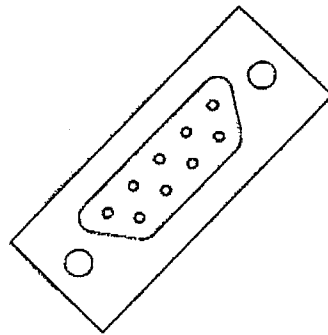
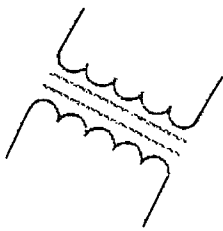
-SHRINKABLE BAG CUT OPTION-

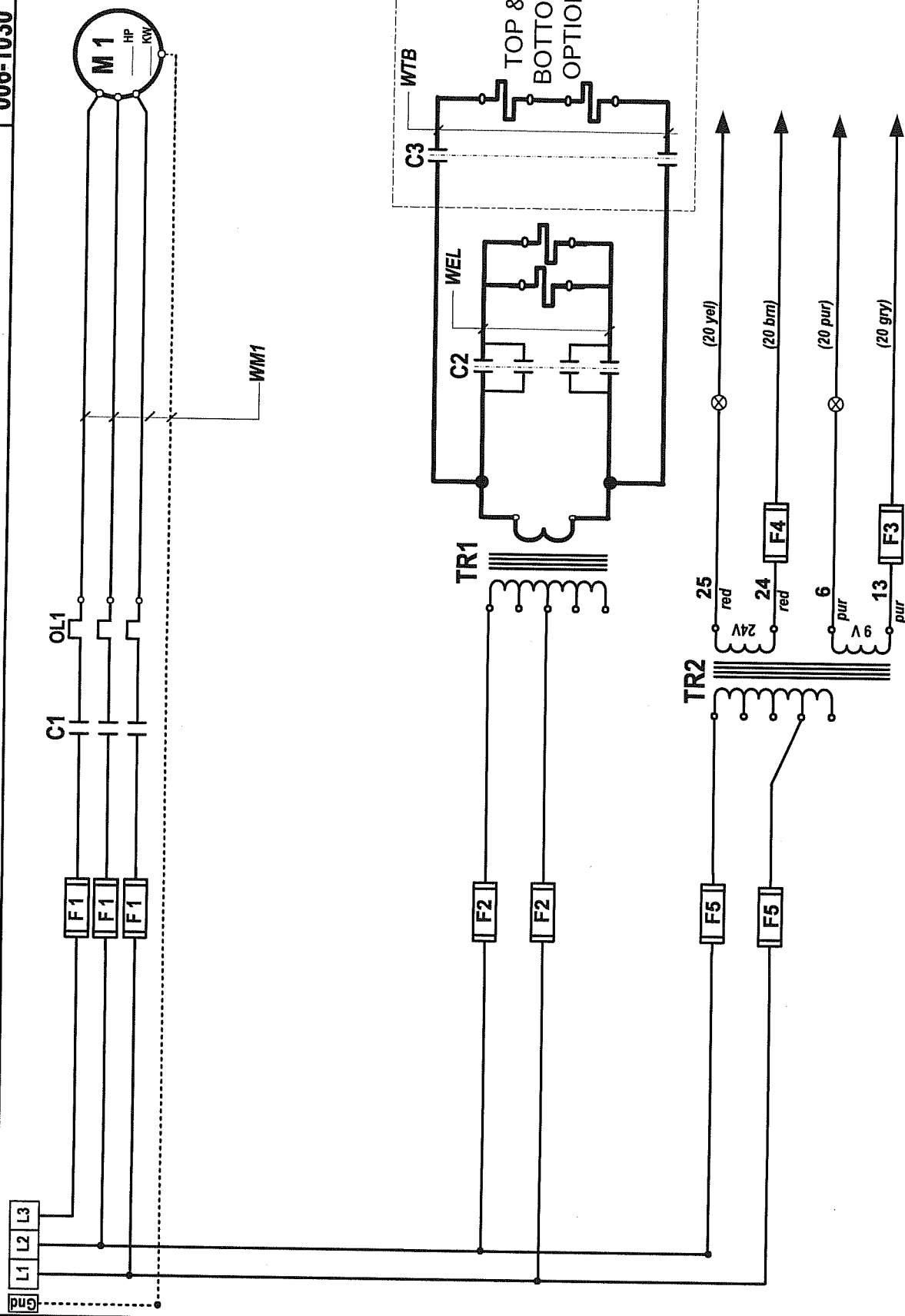
MACHINE	550A	DEPT.	M-I	QTY.	2
PART	UPPER SEAL BAR ASSY (SHRINKABLE)	DATE	08-04-30	NO.	004A2553
ITEM		DATE	07-22-23		
DRAWN BY: J.G. APP. BY: [Signature]		DEPT. M-I			
TOLERANCES: ±0.5 SOLDERAGE: ±0.025 FINISH: ±0.025		N.T.S.			
SIPROMAC ST-GERMAIN DE GRANBY/MTL QUEBEC CANADA					

A	ETAIT 004A1125	08-04-30	J.G.
LET.	MODIFICATION	DATE	INT.



ELECTRICAL DRAWING

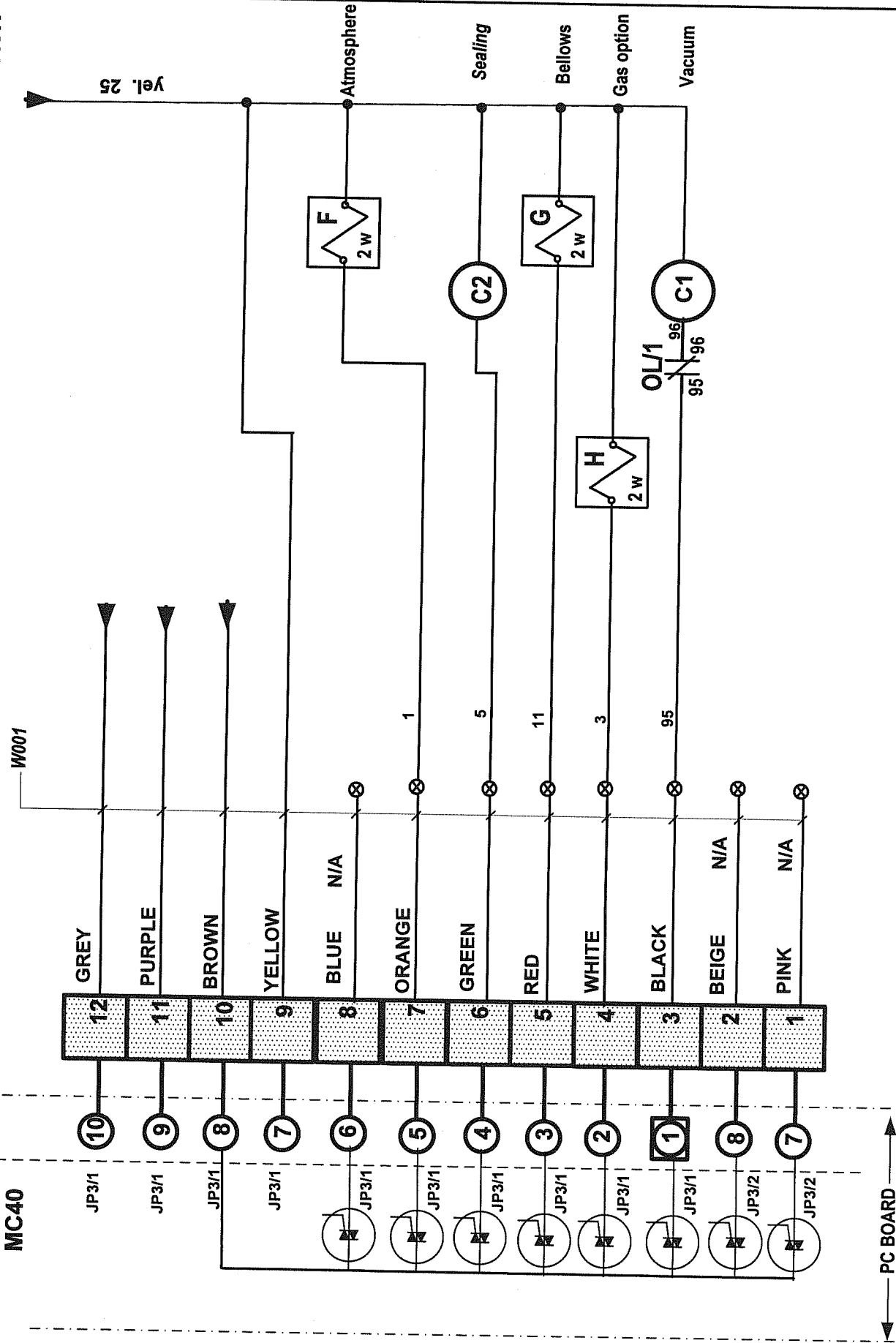




category	VACUUM PACK	model	550A	volL	3Ph 60Hz
system	MC-40			circuit	power
usual				year	month
functions				day	08
options				concept	draw
				app	DL
				XX	PP
					006-1030
					PAGE 1 de 1

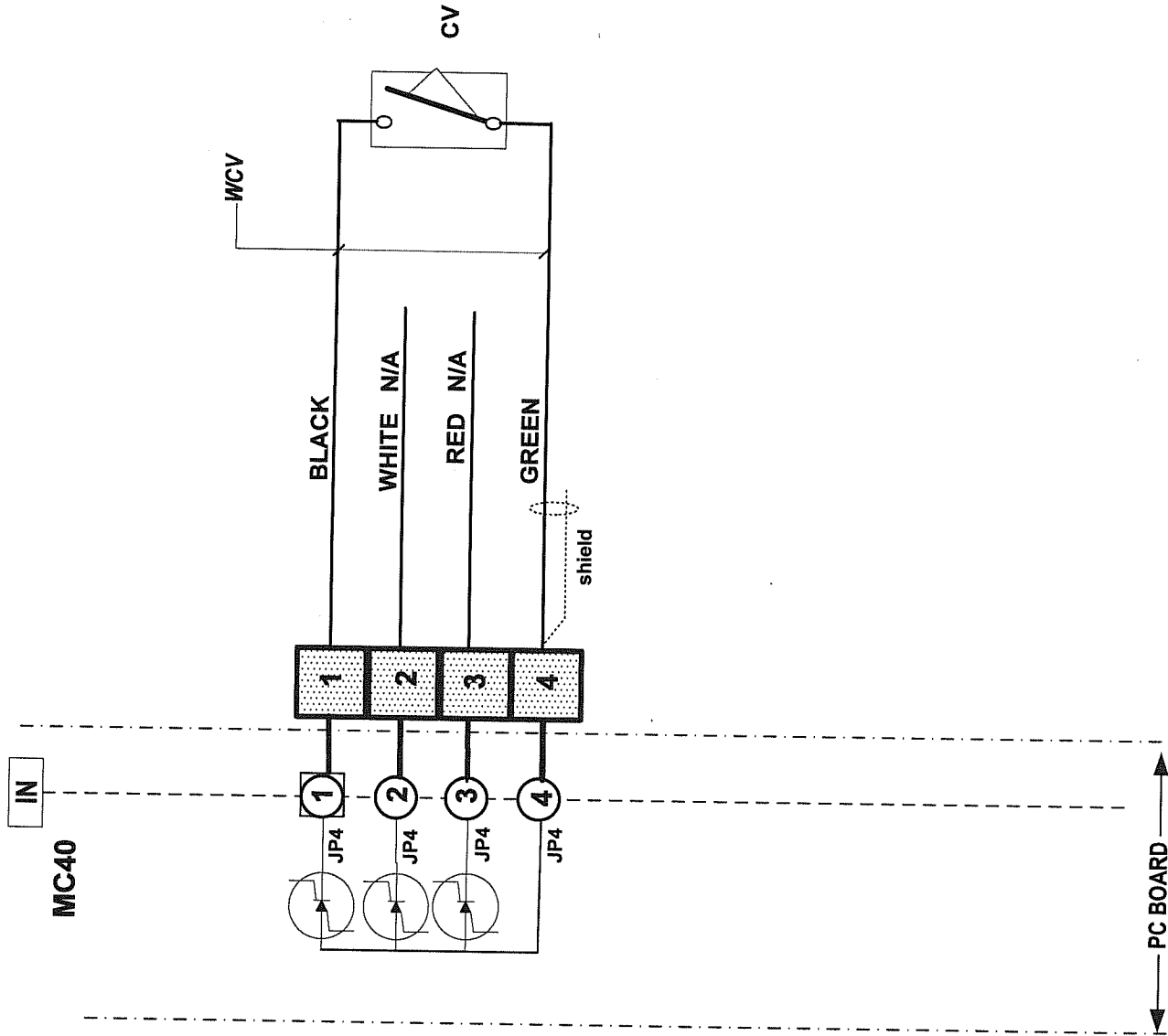
SIPROMAC
 St-Germain de Grantham
 QUEBEC, CANADA

TRANSF.CONT.



category	VACUUM PACK	model	550A	vol.	ALL
system	MC-40			circuit	control
usual functions				year	10 07 08
options				month	day
				block	block
				concept	draw
				app	DL
				PP	PP
				XX	XX
				006-1037	PAGE 1 de 2

SIPROMAC
 St-Germain de Grantham
 QUEBEC, CANADA

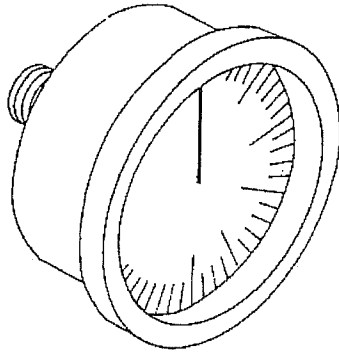


category	VACUUM PACK	model	550A	volt.	ALL
system	MC-40	circuit	control	year	month
usual functions		concept	XX	day	08
options		draw	PP	app	DL
				block	006-1037
				concept	10 07 08
				draw	XX
				app	DL
				DL	006-1037
				PAGE	2 de 2
				SIPROMAC	
				St-Germain de Grantham	
				QUEBEC, CANADA	

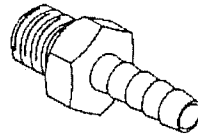
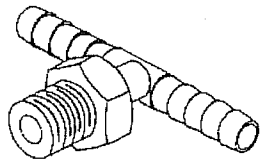
# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
028-0018	TERMINAL BLOCK M618 600V/50A.(8AWG)	SUPPLY	208V/3PH/60HZ	550A	L1-L2-L3		3
028-0020	GROUND TERMINAL BLOCK M618P	SUPPLY	208V/3PH/60HZ	550A	GND		1
028-0060	SEPARATOR M4/6	SUPPLY	208V/3PH/60HZ	550A	GND-L1-L2-L3		4
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	550A	GND		1
034-0700	FUSE HOLDER 30A/600V GOULD	VACUUM	208V/3PH/60HZ	550A	F1		3
034-0500	FUSE MIDGET 15A/250V TIME-DELAY	VACUUM RA-0040	208V/3PH/60HZ	550A	F1	A1	3
025-0030	MOTOR CONTACTOR 2HP IN 208V/3PH-CSA,UL	VACUUM RA-0040	208V/3PH/60HZ	550A	C1	A1	1
025-0160	THERMAL OVERLOAD 5.5 TO 8A-CSA,UL	VACUUM RA-0040	208V/3PH/60HZ	550A	O/L1	A1	1
030-0180	CAB TIRE	VACUUM RA-0040	208V/3PH/60HZ	550A	WM1	A1	2M.
125-0030	BUSCH RA-0040 230-460V/3PH/60HZ 2HP 6.2A	VACUUM RA-0040	208V/3PH/60HZ	550A	M1	A1	1
034-0530	FUSE MIDGET 20A/250V TIME-DELAY	VACUUM RA-0063	208V/3PH/60HZ	550A	F1	A2	3
025-0025	MOTOR CONTACTOR 3HP IN 208V/3PH-CSA,UL	VACUUM RA-0063	208V/3PH/60HZ	550A	C1	A2	1
025-0170	THERMAL OVERLOAD 7 TO 10A-CSA,UL	VACUUM RA-0063	208V/3PH/60HZ	550A	O/L1	A2	1
030-0180	CAB TIRE	VACUUM RA-0063	208V/3PH/60HZ	550A	WM1	A2	2M.
125-0040	BUSCH RA-0063 230-460V/3PH/60HZ 3HP 8.4A	VACUUM RA-0063	208V/3PH/60HZ	550A	M1	A2	1
034-0550	FUSE MIDGET 25A/250V TIME-DELAY	VACUUM RA-0100	208V/3PH/60HZ	550A	F1	A3	3
025-0030	MOTOR CONTACTOR 5HP IN 208V/3PH-CSA,UL	VACUUM RA-0100	208V/3PH/60HZ	550A	C1	A3	1
025-0190	THERMAL OVERLOAD 12 TO 18A-CSA,UL	VACUUM RA-0100	208V/3PH/60HZ	550A	O/L1	A3	1
030-0140	CAB TIRE	VACUUM RA-0100	208V/3PH/60HZ	550A	WM1	A3	2M.
125-0060	BUSCH RA-0100 230-460V/3PH/60HZ 5HP 13.6A	VACUUM RA-0100	208V/3PH/60HZ	550A	M1	A3	1
034-0700	FUSE HOLDER 30A/600V GOULD	SEALING	208V/3PH/60HZ	550A	F2		2
034-0450	FUSE MIDGET 7A/250V TIME-DELAY	SEALING TWIN SEAL	208V/3PH/60HZ	550A	F2	B1	2
029-0040	TRANSFO 500VA/208-240/24V 60HZ	SEALING TWIN SEAL	208V/3PH/60HZ	550A	TR1	B1	1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING	ALL	550A			2
025-0020	CONTACTOR ITH=25A-CSA,UL	SEALING	ALL	550A	C2		1
030-0410	TEW #10/104 BLACK	SEALING	ALL	550A	WEL		7M.
027-0210	TERMINAL FEMALE .250" INSULATED 600v 75°C	SEALING	ALL	550A	WEL		4
005A0568	SEAL BAR ASSY W/SUPPORT	SEALING TWIN SEAL	ALL	550A		B1	2
034-0470	FUSE MIDGET 10A/250V TIME-DELAY	SEALING BAG CUT	208V/3PH/60HZ	550A	F2	B2	2
029-0062	TRANSFO 750VA 208-240V/30V/60HZ	SEALING BAG CUT	208V/3PH/60HZ	550A	TR1	B2	1
005A0569	SEAL BAR ASSY W/SUPPORT	SEALING BAG CUT	ALL	550A		B2	2
034-0500	FUSE MIDGET 15A/250V TIME-DELAY	SEALING TOP & BOTTOM	208V/3PH/60HZ	550A	F2	B3	2
029-0079	TRANSFO 1000VA 208-240/24V 60H	SEALING TOP & BOTTOM	208V/3PH/60HZ	550A	TR1	B3	1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING TOP & BOTTOM	ALL	550A		B3	2
025-0020	CONTACTOR ITH=25A-CSA,UL	SEALING TOP & BOTTOM	ALL	550A	C3	B3	1
030-0120	CAB TIRE	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	3M.
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	4
005A0570	SEAL PRE ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	2
005B0371	UPPER SEAL BAR ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A		B3	2
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	208V/3PH/60HZ	550A	F5		2
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	208V/3PH/60HZ	550A	F5		2

#	SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
029-0009		TRANSFO 65VA/208-230V/24-9V	CONTROL TRANSFO	208V/3PH/60HZ	550A	TR2		1
034-0740		FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	550A	F3+F4		2
034-0210		FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	550A	F3		1
034-0240		FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	550A	F4		1
030-0690		20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	550A	W001		2.5M.
036-0740		12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	550A	JP3/1-2		1
030-0631		22AWG/ACOND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	550A	WCV		2.5M.
036-0820		0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	550A	JP4		1
036-0850		0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	550A	JP4		2
033-0038		MICROPROCESSOR MC-40 SENSOR VACUUM	CONTROL WITH SENSOR	ALL	550A	MC-40	C1	1
033-00385		MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL W/O SENSOR	ALL	550A	MC-40	C2	1
033-0015		MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	550A		D1	1
033-0018		MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	550A		D2	1
106-0010		VALVE 2WAY 24V 1/4 NPT(G22) 60HZ	OPTION GAS	ALL	550A	H	E	1
106-0030		VALVE 2WAY 24V 3/4 NPT(G95) 60HZ	ATMOSPHERE	ALL	550A	F		1
106-0070		VALVE 3WAY 24V 1/4 NPT(G176)60HZ	BELLOWS	ALL	550A	G		1
026-0610		LIMIT SWITCH LONG ROLLER 16A 250V	COVER POSITION	ALL	550A	CV		1
029-0018		TERMINAL BLOCK M6/8 600V/50A.(8AWG)	SUPPLY	460V/3PH/60HZ	550A	L1-L2-L3		3
028-0020		GROUND TERMINAL BLOCK M6/8P	SUPPLY	460V/3PH/60HZ	550A	GND		1
028-0060		SEPARATOR M4/6	SUPPLY	460V/3PH/60HZ	550A	GND-L1-L2-L3		4
028-0105		GROUND BARRIER (6 HOLES)	SUPPLY	ALL	550A	GND		1
034-0700		FUSE HOLDER 30A/600V GOULD	VACUUM	460V/3PH/60HZ	550A	F1		3
034-0480		FUSE MIDGET 10A/600V FAST ACTING	VACUUM RA-0040	460V/3PH/60HZ	550A	F1	A1	3
025-0010		MOTOR CONTACTOR 5HP IN 460V/3PH-CSA,UL	VACUUM RA-0040	460V/3PH/60HZ	550A	C1	A1	1
025-0140		THERMAL OVERLOAD 2.5 TO 4A-CSA,UL	VACUUM RA-0040	460V/3PH/60HZ	550A	O/L1	A1	1
030-0190		CAB TIRE	VACUUM RA-0040	460V/3PH/60HZ	550A	WM1	A1	2M.
125-0030		BUSCH RA-0040 230-460V/3PH/60HZ 2HP 2.6A	VACUUM RA-0040	460V/3PH/60HZ	550A	M1	A1	1
034-0510		FUSE MIDGET 15A/600V FAST ACTING	VACUUM RA-0063	460V/3PH/60HZ	550A	F1	A2	3
025-0025		MOTOR CONTACTOR 7.5HP IN 460V/3PH-CSA,UL	VACUUM RA-0063	460V/3PH/60HZ	550A	C1	A2	1
025-0150		THERMAL OVERLOAD 4 TO 6A-CSA,UL	VACUUM RA-0063	460V/3PH/60HZ	550A	O/L1	A2	1
030-0190		CAB TIRE	VACUUM RA-0063	460V/3PH/60HZ	550A	WM1	A2	2M.
125-0040		BUSCH RA-0063 230-460V/3PH/60HZ 3HP 3.9A	VACUUM RA-0063	460V/3PH/60HZ	550A	M1	A2	1
034-0540		FUSE MIDGET 20A/600V FAST ACTING	VACUUM RA-0100	460V/3PH/60HZ	550A	F1	A3	3
025-0010		MOTOR CONTACTOR 5HP IN 460V/3PH-CSA,UL	VACUUM RA-0100	460V/3PH/60HZ	550A	C1	A3	1
025-0160		THERMAL OVERLOAD 5.5 TO 8A-CSA,UL	VACUUM RA-0100	460V/3PH/60HZ	550A	O/L1	A3	1
030-0190		CAB TIRE	VACUUM RA-0100	460V/3PH/60HZ	550A	WM1	A3	2M.
125-0060		BUSCH RA-0100 230-460V/3PH/60HZ 5HP 6.3A	VACUUM RA-0100	460V/3PH/60HZ	550A	M1	A3	1
034-0700		FUSE HOLDER 30A/600V GOULD	SEALING	460V/3PH/60HZ	550A	F2		2
034-0450		FUSE MIDGET 7A/250V TIME-DELAY	SEALING TWIN SEAL	460V/3PH/60HZ	550A	F2	B1	2
029-0040		TRANSFO 500VA/208-240/24V 60HZ	SEALING TWIN SEAL	460V/3PH/60HZ	550A	TR1	B1	1

# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
027-0220	TERMINAL ROUND STUD #10 600V 75°C	SEALING	ALL	550A			2
025-0020	CONTACTOR ITH-25A-CSA,UL	SEALING	ALL	550A	C2		1
030-0410	TEW #10/104 BLACK	SEALING	ALL	550A	WEL		7M.
027-0210	TERMINAL FEMALE .250" INSULATED 600V 75°C	SEALING	ALL	550A	WEL		4
005A0568	SEAL BAR ASSY W/SUPPORT	SEALING TWIN SEAL	ALL	550A		B1	2
034-0470	FUSE MIDGET 10A/250V TIME-DELAY	SEALING BAG CUT	460V/3PH/60HZ	550A	F2	B2	2
029-0062	TRANSFO 750VA 208-240V/30V/60HZ	SEALING BAG CUT	460V/3PH/60HZ	550A	TR1	B2	1
005A0569	SEAL BAR ASSY W/SUPPORT	SEALING BAG CUT	ALL	550A		B2	2
034-0500	FUSE MIDGET 15A/250V TIME-DELAY	SEALING TOP & BOTTOM	460V/3PH/60HZ	550A	F2	B3	2
029-0079	TRANSFO 1000VA 208-240/24V 60H	SEALING TOP & BOTTOM	460V/3PH/60HZ	550A	TR1	B3	1
027-0220	TERMINAL ROUND STUD #10 600V 75°C	SEALING TOP & BOTTOM	ALL	550A		B3	2
025-0020	CONTACTOR ITH-25A-CSA,UL	SEALING TOP & BOTTOM	ALL	550A	C3	B3	1
030-0120	CAB TIRE	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	3M.
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	4
005A0570	SEAL PRE ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A		B3	2
005B0371	UPPER SEAL BAR ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A		B3	2
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	460V/3PH/60HZ	550A	F5		2
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	460V/3PH/60HZ	550A	F5		2
029-0009	TRANSFO 65VA/208-230V/24-9V	CONTROL TRANSFO	460V/3PH/60HZ	550A	TR2		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	550A	F3+F4		2
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	550A	F3		1
034-0240	FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	550A	F4		1
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	550A	W001		2.5M.
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	550A	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	550A	WCV		2.5M.
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	550A	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	550A	JP4		2
033-0038	MICROPROCESSOR MC-40 SENSOR VACUUM	CONTROL WITH SENSOR	ALL	550A	MC-40	C1	1
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL W/O SENSOR	ALL	550A	MC-40	C2	1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	550A		D1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	550A		D2	1
106-0010	VALVE 2WAY 24V 1/4 NPT(G22) 60HZ	OPTION GAS	ALL	550A	H	E	1
106-0030	VALVE 2WAY 24V 3/4 NPT(G95) 60HZ	ATMOSPHERE	ALL	550A	F		1
106-0070	VALVE 3WAY 24V 1/4 NPT(G176)60HZ	BELLOWS	ALL	550A	G		1
026-0610	LIMIT SWITCH LONG ROLLER 15A 250V	COVER POSITION	ALL	550A	CV		1

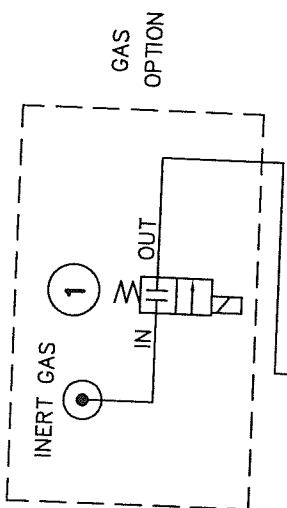


PNEUMATIC DRAWING

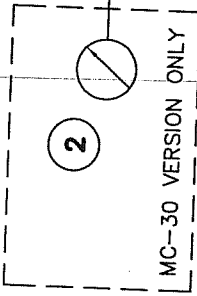
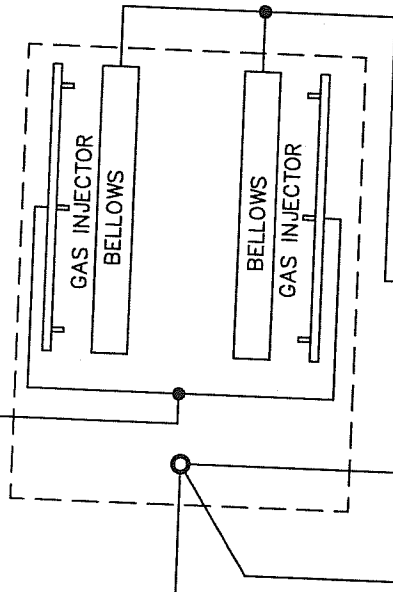


007-0018

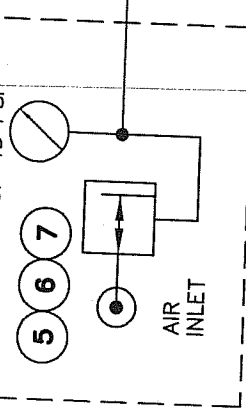
ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	1
2	114-0260	VACUUM GAUGE	1
3	106-0070	BELLOWS VALVE	1
4	106-0030	ATMOSPHERE VALVE	1
5	114-0147	PRESSURE REGULATOR	1
6	114-0245	PRESSURE GAUGE	1
7	114-0170	PRESSURE REGULATOR SUPPORT	1
8	114-2020	DRYER FILTER	1



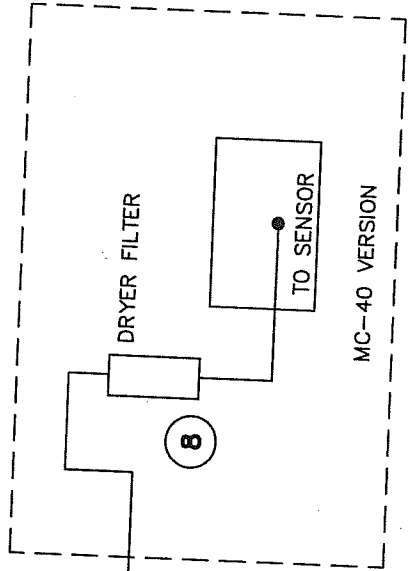
NOTE: FOR GAS INJECTION
OPTION KIT INSTALLATION
SEE DRAWING #:
450A: #010-0029
550A: #010-0013



NOTE: SET TO A
MAXIMUM OF 45 PSI

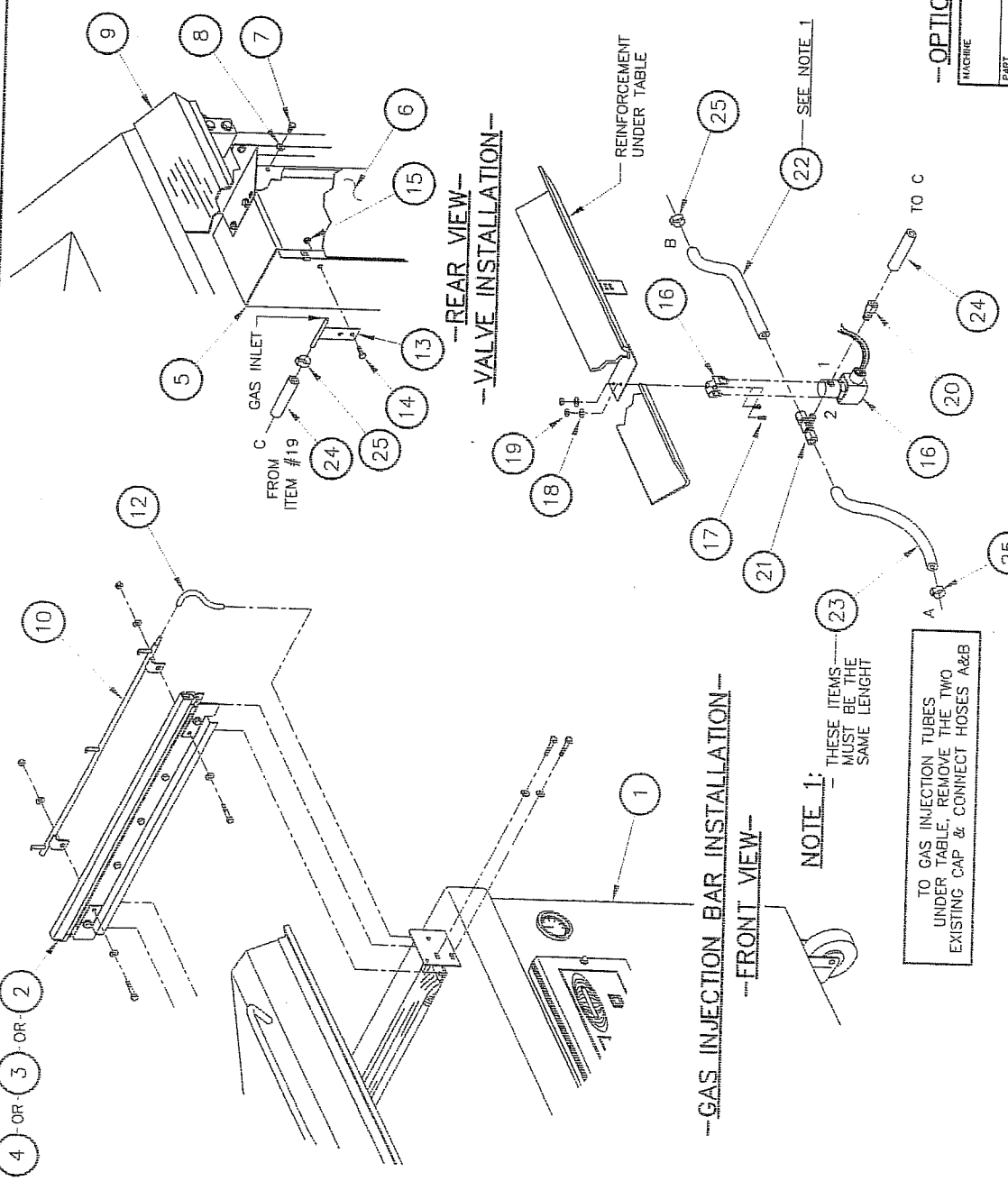


NOTE: FOR AIR REGULATOR
OPTION KIT INSTALLATION
SEE DRAWING #:
450A: #010-0033
550A: #010-0033



MACHINE 450A & 550A		PNEUMATIC DRAWING		SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	
PART		ITEM: N.T.S.		SCALE _____ QT. 1	
DATE		DATE		NO.	
D.A. 04-06-11		M.L. 97-03-12		DATE 97-03-12	
RE-DRAWN		MODIFICATION		APP. <i>MAE</i>	
C		ADDED MC-40 AND DRYER		CNC: _____	
B		RE-DRAWN		DWG BY M.LAVIGNE	
LET.				APP. <i>MAE</i>	
				DATE <i>04-06-11</i>	
				NO. 007-0018	

ITEM	PART #	DESCRIPTION	QTY.
1	005-0338	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0568	SEAL BAR ASS'Y W/ SUPPORT	2
3	005-0569	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	2
4	005-0570	SEAL BAR ASS'Y W/ SUPPORT (T & B OPT.)	2
5	005-0347	ELECTRICAL BOX ASSEMBLY	1
6	004-0273	ELECTRICAL BOX COVER PRE-ASS'Y	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	005-0339	MACHINE ASSEMBLY REAR VIEW	1
10	005A0810	GAS INJECTION BAR ASSEMBLY (OPTION)	1
11	005-0571	GAS INJECTION BAR ASSEMBLY (OPTION)	1
12	008-0464	GAS INJECTION CONN. TUBE (OPTION)	2
13	005-0323	GAS INLET ASSEMBLY	1
14	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
15	051-0580	HEX. NUT 1/4"-20 NC. S/S (OPTION)	1
16	106-0010	SELENOIDE VALVE 2 WAY 1/4" NPT W/ SUPP.	1
17	051-0100	SCREW #8-32 X 3/8" PAN PHILL. S/S	2
18	051-0720	FLAT WASHER #8 S/S	2
19	051-0550	HEX. NUT #8 S/S	2
20	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	1
21	101-0085	T 3/8" T.P.COMP. X 1/4" MNPT X 3/8" T.P.COMP.	1
22	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm LG.	4
23	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm LG.	2
24	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm LG.	1
25	105-0200	COLLARS 3/8" Ø	3



NOTE 2: PARTS 1 THRU 9 ARE EXISTING PARTS
PARTS 10 THRU 25 PARTS SUPPLIED W/ KIT

NOTE 1: THESE ITEMS MUST BE THE SAME LENGTH

TO GAS INJECTION TUBES UNDER TABLE, REMOVE THE TWO EXISTING CAP & CONNECT HOSES A&B

OPTION GAS INJECTION-

MACHINE: 550A
 PART: GAS INJECTION KIT INSTALLATION
 ITEM: _____
 MAT: _____

INCH TOLERANCE: .005
 METRIC TOLERANCE: .05
 ANGLES: N.T.S.

ST-GERMAIN DE GRANVILLE
 QUEBEC CANADA

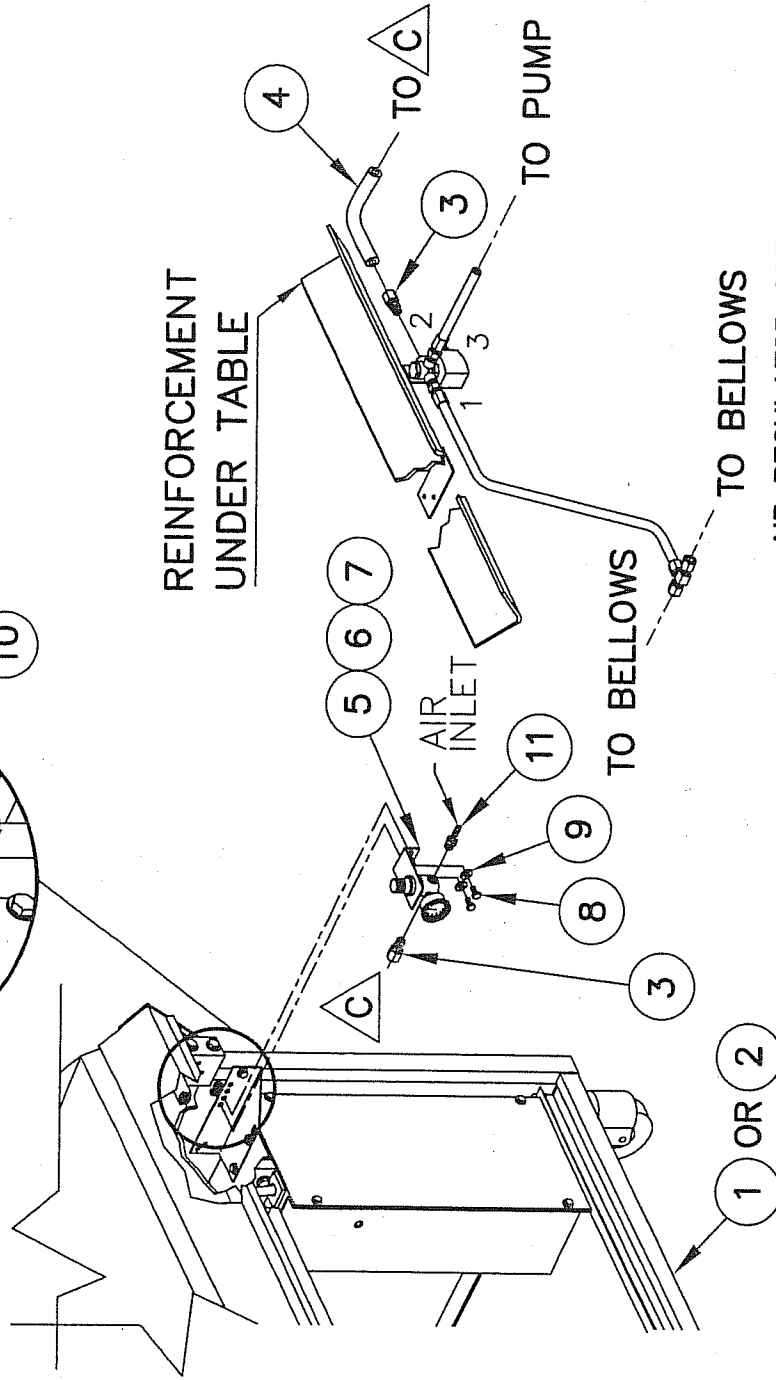
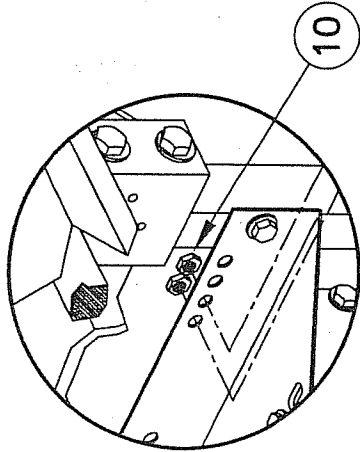
DATE: 98-02-26
 BY: A. PROVENCER
 APP: L.T.

NO. 010-0013

D	MODIFICATION #A-358	03-02-21	J.G.
C	REDRAWN/ MODIF. NO. A-0241	98-02-26	A.P.
LET.	MODIFICATION	DATE	INT.

010-0033

ITEM	PART #	DESCRIPTION	QT.
1	005-0411	REAR VIEW MACHINE ASSEMBLY	1
2	005-0339	REAR VIEW MACHINE ASSEMBLY	1
3	101-0036	STRAIGHT 1/4" MNPT x 3/8" T.P. COMP	2
4	104-0060	TUBE 3/8" OD x 1/4" ID (POLY) x mmLG.	2
5	114-0147	PR. REG. 0-60 PSI 1/4" NPT	1
6	114-0245	PR. GAUGE 0-60 PSI 1/8" NPT	1
7	114-0170	PRESSURE REGULATOR SUPPORT	1
8	051-0144	SCREW 10-24 x 1/2" PAN PHIL SS	2
9	051-0730	WASHER #10 FLAT S/S	2
10	051-0572	NUT #10-24 NYLON LOCK SS	2
11	101-0200	STRAIGHT 1/4" MNPT x 1/4" HOSE BARB	2



- AIR REGULATOR OPTION -

MACHINE	450A & 550A		SIPROMAC	
PART	AIR REGULATOR OPTION KIT INSTALLATION		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	CNC:		INCH TOLERANCE	SCALE: M-E QT, 1
MAT:	DWG M.LAVIGNE	DATE 97-10-07	.0 ± .015	
	APP. <i>D</i>	DATE 05-06-20	.0 ± .05	
			.00 ± .005	
			.000 ± .0005	
			ANGLE ± 1'	N.T.S.
B	051-0144 WAS 051-0100, 051-0572	05-05-05	M.A.L.	
A	051-0100 WAS 051-0147, 051-0560	05-03-23	M.A.L.	
LET.	MODIFICATION	DATE	INT.	

MANUEL D'UTILISATEUR

MICROPROCESSEUR MC-40 **AVEC OU SANS DÉTECTEUR DE VIDE**

EMBALLEUSE SOUS VIDE

TABLE DES MATIÈRES

I INSTRUCTIONS POUR LES OPÉRATIONS

II MÉCANIQUE

- A- Vue de face
- B- Vue de l'arrière
- C- Procédure d'ajustement du couvert
- D- Schéma de l'assemblage de l'axe central
- E- Barres de scellage
(Double scellage)
- F- Dessin des barres de scellage
(Option du coupe sac électrique)
- G- Dessins des barres d'assemblage
(Scellage du haut et du bas en option)
- H- Gas injection kit installation drawing
(gaz injection option)

III ELECTRIQUE

- A- Schéma électrique (Bas voltage)
- B- Schéma électrique (Haut voltage à une phase)
- C- Schéma électrique (Haut voltage à 3 phases)
- D- Schéma électrique (Haut voltage 1 phase 50 Hz)
- E- Schéma électrique (Haut voltage 3 phase 50 Hz)

IV PNEUMATQUE

- A- Schéma Pneumatique

EMBALLEUSES SOUS VIDE INSTRUCTIONS D'OPÉRATIONS

TABLE DES MATIÈRES

1. Mise en marche de la machine
2. Connexion Électrique
3. Opération
 - 3.1 Principes de travail
 - 3.2 Emballage Spécial
 - 3.2.1 Injection de Gaz
 - 3.2.2 Scellage haut et bas
(bi-active sealing)
 - 3.2.3 Coupe sac électrique
 - 3.3 Ajustement des contrôles digital
 - 3.4 Nettoyage Quotidien
4. Trouble de lancement
 - 4.1 Échec durant le cycle d'emballage
 - 4.2 Vide insuffisant
 - 4.2.1 Fuites dans le sac
 - 4.2.2 Pas de fuite dans le sac
 - 4.2.3 Vide insuffisant dans la chambre
 - 4.3 Scellage Inadéquat
 - 4.3.1 Scellage insuffisant
 - 4.3.2 Pas de scellage
 - 4.3.3 Courant ininterrompu sur les barres de scellage
 - 4.3.4 Le scellage ne tient pas
 - 4.4 Problème avec les valves
 - 4.5 Problème du panneau de contrôle
5. Maintenance Régulière

SIPROMAC INC. EMBALLEUSES SOUS VIDE

1. MISE EN PLACE DE LA MACHINE:

Avant de choisir le site d'installation de votre machine, veuillez considérer que vous aurez besoin d'espace pour les produits emballés et non-emballés à part de l'espace occupé par la machine elle-même.

Bien vouloir vous rappelez que vous aurez besoin d'un sol bien au niveau pour votre installation. Spécialement avec les modèles mobiles, le poids de la pompe peut gauchir la machine et le couvercle ne fermera plus correctement.

Avant de commencer à travailler, vérifier l'huile de la pompe pour voir si elle est en quantité suffisante. Bien vouloir ne jamais utiliser une huile autre que celle recommandée par le fabricant. Ne pas excéder la quantité indiquée quand vous ajoutez ou faites le changement d'huile et faites votre vérification hebdomadairement.

En raison de la viscosité de l'huile, la machine sera plus difficile à démarrer à basses températures. Ainsi donc la pompe doit être placée dans un endroit où la température est d'au moins 50°F (+10°C). D'autre part, l'air doit circuler librement aux alentours de la pompe pour permettre le refroidissement dans les cas où la température des opérations atteindrait 160°F (70°C) ou la température maximale permise.

2. CONNEXION ÉLECTRIQUE:

Les connexions électriques doivent se faire par du personnel qualifié. La personne désignée doit s'assurer que les entrées électriques correspondent au voltage et à l'ampérage approprié de la machine.

Un schéma électrique accompagne chacune de nos machines.

Une étape importante dans le branchement de la machine est de s'assurer que le moteur de la pompe tourne dans une rotation appropriée.

Attention: Le moteur de la pompe ne devrait pas tourner plus de 3 ou 4 secondes dans une mauvaise rotation car il en résultera des dommages sérieux. La rotation est indiquée par une flèche sur le moteur de la pompe.

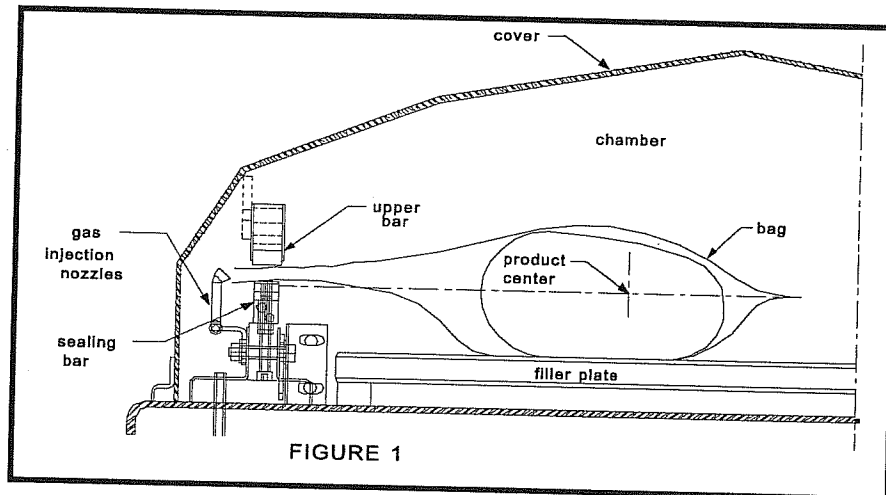
3. OPÉRATION:

3.1 Principes de travail:

Un emballage sous vide est un cycle composé de 3 étapes. Premièrement le vide est fait et l'air est complètement enlevé de la chambre et du sac contenant le produit. (Voir figure 1). Ensuite c'est possible d'injecter du gaz neutre par les conduits si le produit est très délicat. Finalement, un mécanisme pousse la barre de scellage sur le support de caoutchouc pour sceller le sac

Pour obtenir de beaux emballages, les produits et les sacs doivent être de taille proportionnelles. L'ouverture du sac ne devrait jamais excéder 2" (50cm) au delà des barres de scellage. Le produit doit être centré en hauteur par rapport aux barres de scellage en ajustant les écarteurs qui vous sont fournis.

Pour obtenir un bon scellage, assurez-vous qu'il n'y a pas de résidu de graisse qui reste entre les côtés intérieurs des sacs où le scellage doit être fait.



3.2 Emballage Spécial:

3.2.1 Injection de Gaz (option):

Il y a une pression atmosphérique de 14 lbs / pouce carré (= 1 kg / cm carré) sur les produits quand le vide demandé est atteint. Les produits qui peuvent être endommagés par une haute pression doivent être emballés avec un vide partiel et la pression doit être contrebalancée en injectant du gaz dans le sac (nitrogène ou dioxyde de carbone) avant le scellement et après avoir atteint le vide.

Pour l'injection de gaz, les sacs sont placés sur les barres de scellage, l'ouverture placée au dessus des conduits de gaz qui sont montés le long des barres de scellage. Après que le vide soit atteint, la valve du vide se ferme et la valve du gaz s'ouvre. Le pourcentage de gaz peut être ajusté par le menu du programme.

Le réservoir de gaz et la valve de pression qui est rattachée au réservoir ne sont pas fournis par Sipromac. La pression pour le régulateur de gaz devrait être ajustée approximativement à 5 lbs/pouce carré (1/3 Kg/cm carré). Chaque machine a un adaptateur pour la connexion de gaz quand l'option de l'injection de gaz est commandée.

3.2.2 Scellage Haut et Bas (optionnel):

Pour le scellage des sacs en aluminium comme pour le café il est impératif d'avoir une barre de scellage en haut et en bas.

3.2.3 Coupe sac électrique: (optionnel):

Cette option est utilisée pour obtenir un paquet dont l'excédent de film au niveau du scellage doit être coupée très près de la ligne de scellage. (cette option ne peut pas être utilisée avec le scellage Haut et Bas)

3.3 Les opérations de l'emballage sous vide:

Note: Reportez-vous aux menus structure de la page 8 et aux détails du panneau de contrôle sur la page 9

3.3.1 Bases:

Utilisez la touche "POWER" pour initier le bouton ON/OFF sur votre machine sous vide. Quand votre unité sera en fonction le dernier programme exécuté apparaîtra sur l'écran à cristaux liquides.

Utilisez la touche "ESC" pour passer du menu programme au menu fonctions et du menu des fonctions au menu des programmes.

Dans le menu des fonctions, utilisez la touche "SELECT" pour sélectionner une fonction et la touche "ENTER" pour exécuter la sélection.

Dans le menu des programmes, utilisez la touche "SELECT" pour sélectionner un programme et la touche "Enter" pour accéder ou modifier la sélection.

Dans les programmes du sous menu, utilisez la touche "ENTER" pour voir défiler les paramètres et lorsque ces derniers clignotent pour indiquer ils sont dans le mode d'acquisition. Quand la séquence de tous les paramètres se sont affichés, on revient automatiquement au début de la liste.

Dans les programmes du sous menu, utilisez la touche "ESC" pour revenir au menu des programmes. Pressez n'importe quelle touche pour effacer les messages d'erreur qui peuvent s'afficher sur l'écran à cristaux liquide.

3.3.2 Menu des fonctions:

3.3.2.1 Créer un programme:

Quand vous exécutez la fonction "create a program", le programme sous menu est atteint en commençant par l'identification. L'identification initiale "PxxNO NAME" est donné au programme et tous les paramètres sont établis à zéro; le numéro du programme est alloué automatiquement.

3.3.2.2 Supprimer un programme:

En exécutant la fonction de "delete a program", vous avez accès au menu des programmes et le numéro du premier programme en mémoire clignote pour indiquer le mode de suppression. Utilisez la touche "SELECT" pour sélectionner un programme et la touche "ENTER" pour avoir accès et confirmer la suppression de la sélection. Utilisez la touche "ESC" pour annuler une suppression et quitter la fonction. Quand vous quittez la fonction, le nombre des programmes actuels sur l'écran à cristaux liquides cesse de clignoter.

3.3.2.3 Choisir le mode d'opération:

Quand vous exécutez la fonction "Select Operating Mode", laquelle est disponible seulement pour les unités automatiques, la sélection en cours clignote pour vous indiquez le mode. Utilisez la touche "SELECT" pour parcourir les modes d'opération, lesquels sont automatiques, semi-automatiques et manuels.

Le mode d'opération sera validé et exécuté automatiquement. Utilisez la touche "ESC" ou "ENTER" pour quitter la fonction et retourner au menu des programmes.

3.3.3 Menu des Programmes:

3.3.3.1 Identification des Programmes:

Pour un programme sélectionné, choisissez l'identification en utilisant le panneau de contrôle numérique avec la chartre des caractères et pressez sur la touche numérique jusqu'à ce que le caractère soit sélectionné (4 x pour la valeur numérique). Utilisez la touche "ENTER" pour valider le caractère ainsi que la chaîne de caractères jusqu'à la fin (la nouvelle chaîne de caractères clignote). Vous pouvez utiliser la touche "ESC" pour revenir en arrière dans le cas où vous vous êtes trompé et que vous voulez effacer le caractère.

Example: EXAMPLE 1 → (9 caractères)

Touche 2, 2, ENTER	→ E
Touche 8, 8, 8, ENTER	→ X
Touche 1, ENTER	→ A
Touche 5, ENTER	→ M
Touche 6, ENTER	→ P
Touche 4, 4, 4, ENTER	→ L
Touche 2, 2, ENTER	→ E
Touche 9, 9, 9, ENTER	→ espace
Touche 1, 1, 1, 1, ENTER	→ 1

Touche ENTER pour valider la chaîne de caractères

3.3.3.2 L'ajustement du niveau de Vide (capteur de vide désactivé):

Pour un programme sélectionné, ajustez le niveau de vide, en secondes; la validation est automatiquement exécutée après la deuxième entrée digitale (Le nouveau temps de vide clignote). En cours de traitement, utilisez la touche "ENTER" pour valider la valeur du niveau de vide et la touche "ESC" pour revenir en arrière et changer la valeur du niveau de vide (La valeur du niveau de vide la plus ancienne clignotera à ce moment).

Exemples: 1 sec. → Touches 0, 1 ou 1, ENTER
15 sec. → Touches 1, 5

3.3.3.3 L'ajustement du niveau de Vide (capteur de vide en activé):

Pour un programme sélectionné, ajustez le niveau de vide avec les valeurs; le point décimal est automatiquement inséré suivant la deuxième entrée digitale et la validation est automatiquement exécutée après la troisième entrée digitale (La nouvelle valeur du niveau du vide clignote). Le niveau de vide est arrondi à la demie la plus près de la valeur. En cours de traitement, utilisez la touche "ENTER" pour valider la valeur du niveau de vide et la touche "ESC" pour revenir en arrière et changer la valeur du niveau de vide (La valeur du niveau de vide la plus ancienne clignotera à ce moment). Ajustez le niveau du vide à zéro pour pouvoir contourner le capteur de vide et procédez en réglant seulement le " Temps de vide Plus" (Vacuum plus time).

Exemples: 90.0% → Touches 9, 0, 0 ou 9, 0, ENTER ou
Touches 9, 0, 1 ou 9, 0, 2 or 9, 0, 3 ou 9, 0, 4
97.5% → Touches 9, 7, 5 ou
Touches 9, 7, 6 ou 9, 0, 7 or 9, 0, 8 ou 9, 0, 9
0.0% → Touches 0, 0, 0 ou 0, ENTER

3.3.3.4 Ajustement du Temps de Vide "Plus" (capteur de vide activé):

Pour un programme sélectionné, réglez le "temps de vide plus" en secondes; la validation est automatiquement exécutée après la deuxième entrée digitale (La nouvelle valeur du "temps de vide plus" clignotera à ce moment). En cours de traitement, utilisez la touche "ENTER" pour valider la nouvelle valeur du "temps de vide plus" et la touche "ESC" pour revenir et recommencer avec de nouvelles valeurs (la valeur la plus ancienne du "temps de vacuum plus" clignotera).

Exemples: 1s → Touche 0, 1 or 1, ENTER
15s → Touche 1, 5

3.3.3.5 Ajustement de l'injection de gaz (capteur de vide désactivé):

Pour sélectionner un programme placer le niveau d'injection de gaz en suivant la même procédure que pour le niveau de vide. Gardez en mémoire que plus le temps d'injection de gaz est haut, moins la pression du sellage sera forte. Un certain niveau de vide doit être maintenu pour un bon fonctionnement.

3.3.3.6 Ajustement de l'injection de gaz (capteur de vide activé):

Pour sélectionner un programme placer le niveau d'injection de gaz en suivant la même procédure que pour le niveau de vide; L'ajustement pour le gaz le plus haut devrait être de 10% au-dessous du niveau de l'ajustement de vide.

3.3.3.7 Ajustement du cachetage:

Pour sélectionner un programme le temps de cachetage, en commençant par les secondes; le point décimale est automatiquement insérée après la première entrée de chiffre et la validation est automatiquement effectuée après la troisième entrée de chiffre (le nouveau temps de cachetage clignote). Le temps de cachetage est arrondi à la moitié la plus proche du cent. À un milieu l'entrée des données, utiliser la clé "ENTER" pour valider l'heure du cachetage et la clé " ESC " pour revenir en arrière et reprogrammer le temps cachetage avec de nouvelles données (le vieux temps de cachetage clignote).

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

3.3.4 Exécution de cycle de vide :

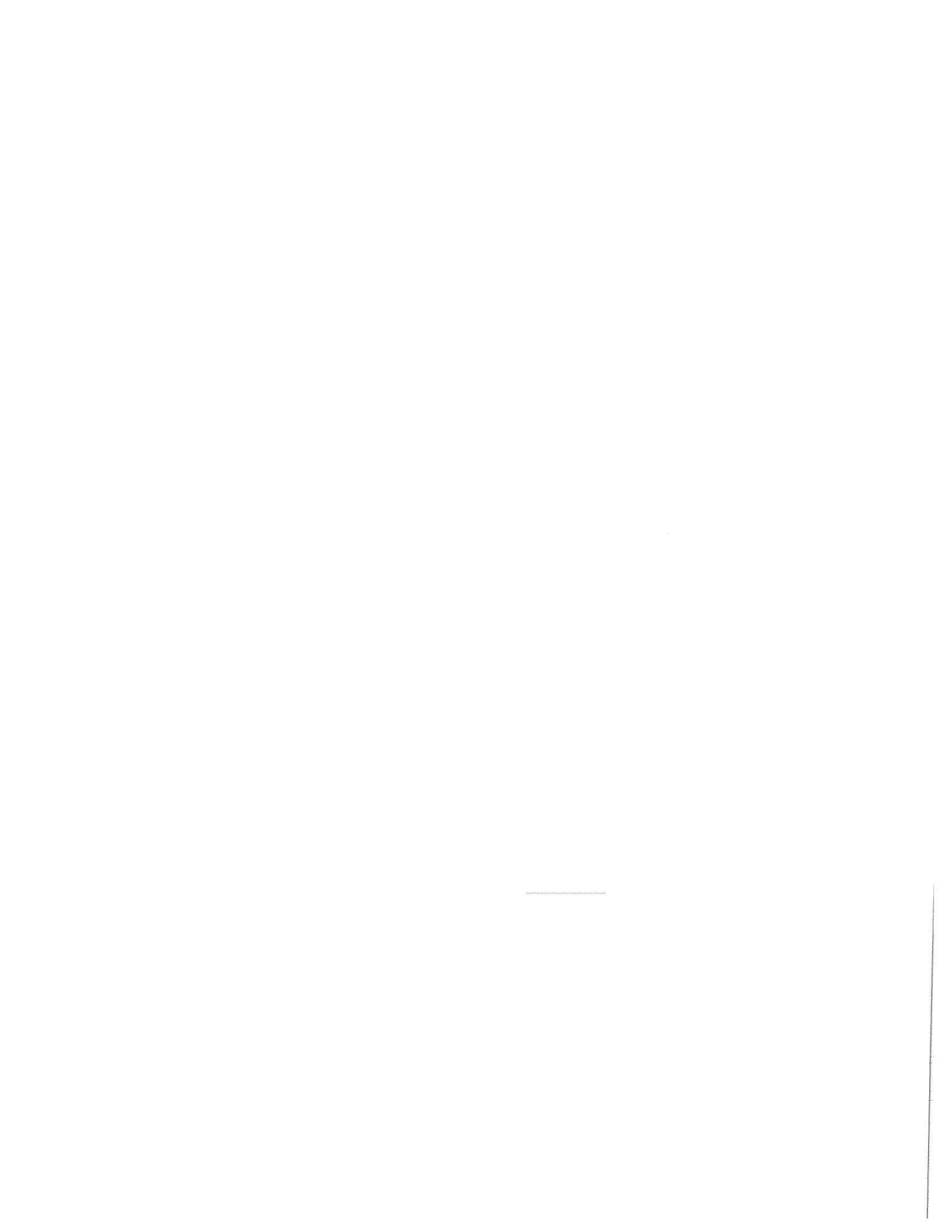
Pour les unités manuels ainsi que les unités automatiques faire la mise en marche manuelle, fermer le couvercle afin de lancer un cycle de vide. Pour l'unité automatique faire mise en marche semi-automatique ou automatique, utilisez le bouton "ARRÊT / DÉBUT" pour lancer ou interrompre un cycle de vide. Le programme sélectionné peut être lancé seulement dans le programme du menu, au moment où aucune modification n'est nécessaire, et l'accès des autres programmes et des fonctions ne sont pas requis. Pendant l'exécution du cycle le statut d'opération est séquentiellement affiché sur l'écran à cristaux liquides, excepté pour les paramètres établis à zéro, qui ne sont pas montrés:

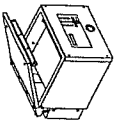
- niveau de vide de la chambre pendant la séquence,
- vide additionné du temps pendant le vide plus la séquence,
- niveau de vide de la chambre pendant la séquence d'injection de gaz,
- statut de temps de cachetage pendant la séquence de cachetage,
- niveau de vide de la chambre pendant La séquence d'atmosphère .7

Pendant l'exécution du cycle, utilisé la clef "1" pour interrompre la séquence de vide et pour exécuter la séquence suivante, soit l'injection du gaz ou le cachetage, suivi de la clé "ENTER" afin d'accéder et modifier le programme; les paramètres deviennent valides seulement pour les cycles suivants de vide.

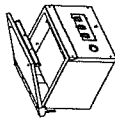
3.3.5 System monitor:

Pour accéder le menu des diagnostics, monter la puissance de la machine d'emballage sous vide tout en maintenant le bouton "ESC" enfoncé. Utilisez la clé "SELECT" pour choisir la fonction du système du moniteur et "ENTER" pour accéder et visualiser les paramètres surveillés. Employez la clé "SELECT" pour changer la révision de logiciel, la quantité d'heures de travail faites et de la quantité de cycles complets exécutés depuis la première initialisation.

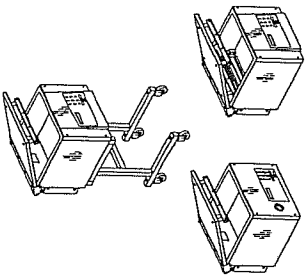




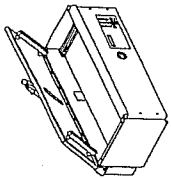
250



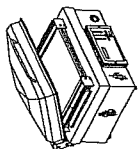
300



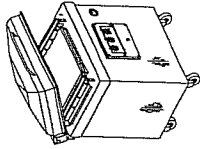
350/350D



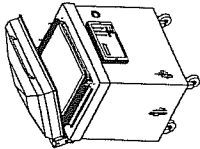
380A



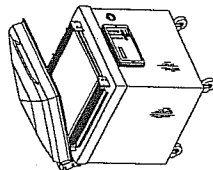
450T



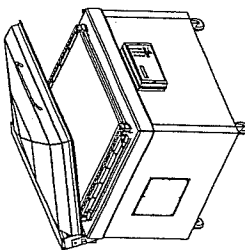
400A



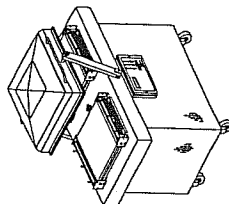
450A



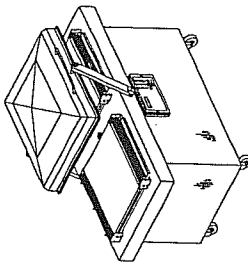
550A



580A

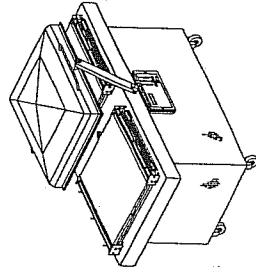


420A

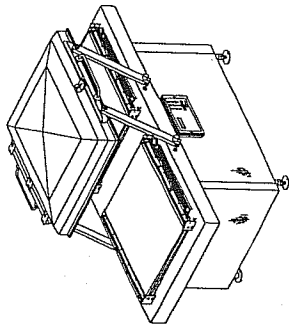


600A

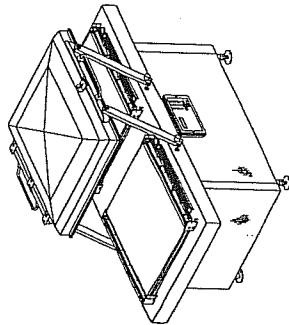
VACUUM PACKAGING MACHINES



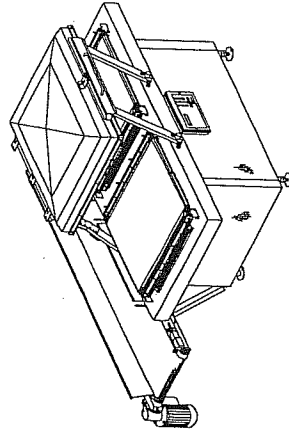
620A



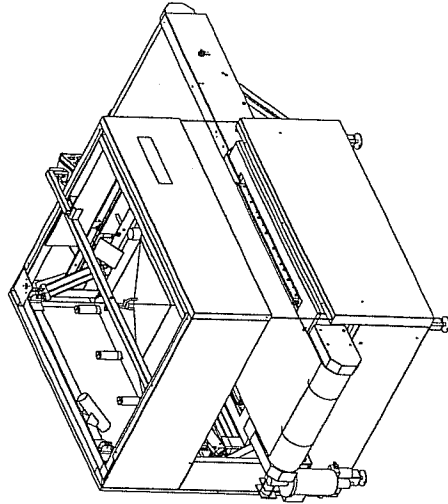
650A



680A



700A



750A