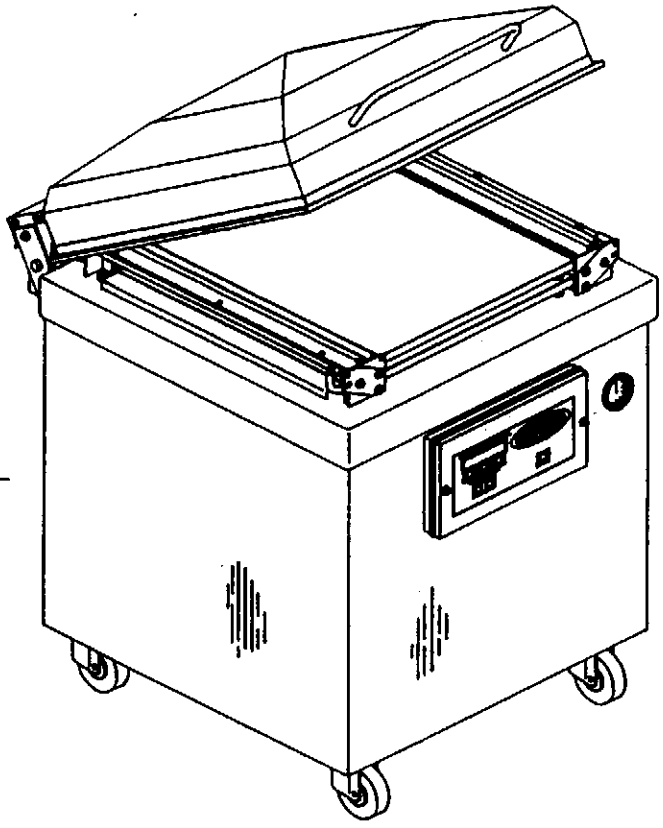
SIPROMAC



MODEL 550A

VACUUM PACKAGING MACHINE

MODEL 550A

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VACUUM PACKAGING MACHINES

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SIPROMAC INC.

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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 recommanded by the producer. Never exceed maximum quantity of oil indicated, when adding or changing oil.

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.

2. Con't

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 completly 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 mecanism pushes the sealing bar to the rubber support to seal the bag.

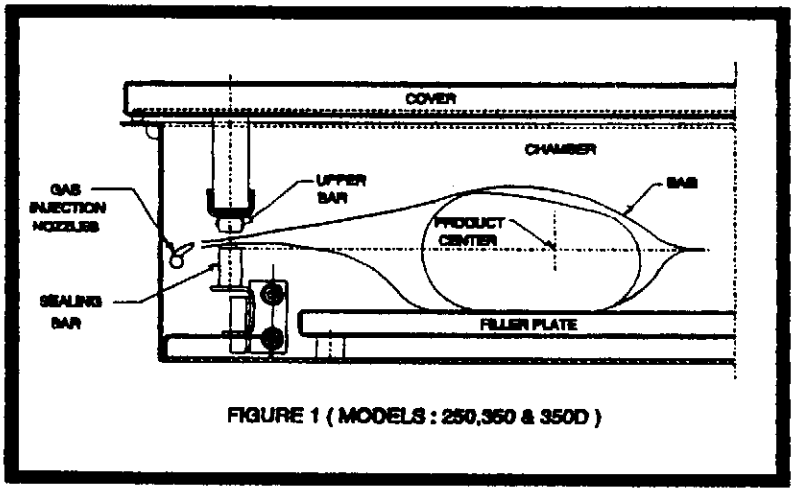


FIGURE 1 (MODELS : 250,350 & 350D)

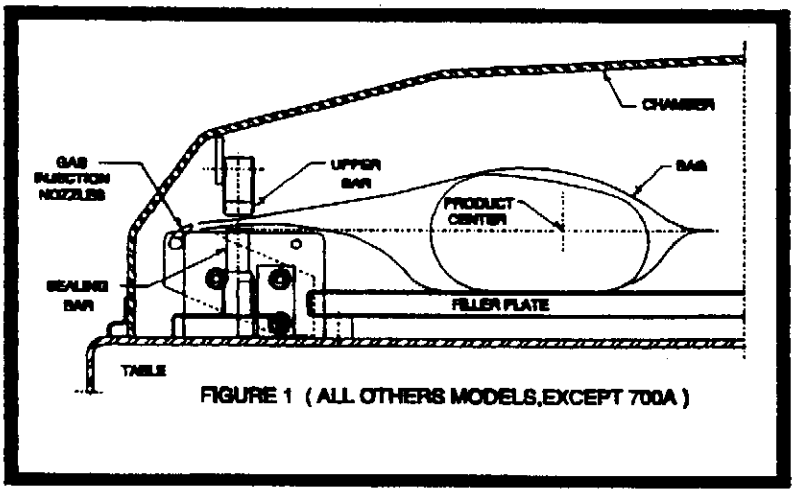


FIGURE 1 (ALL OTHERS MODELS,EXCEPT 700A)

3.1 Con't

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:

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 couterbalanced by inflating the bag with gas (nitrogen or carbon dioxide) before sealing after evacuation.

For gas flushing, the bags are placed on the sealing bars, the open end placed over the gas nozzles mounted alongside the sealing bar. After evacuation, the vacuum valve closes and the gas valve opens. Gas time can be set by "G" control.

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

3.2.2 Top and bottom sealing:
(bi-active sealing)

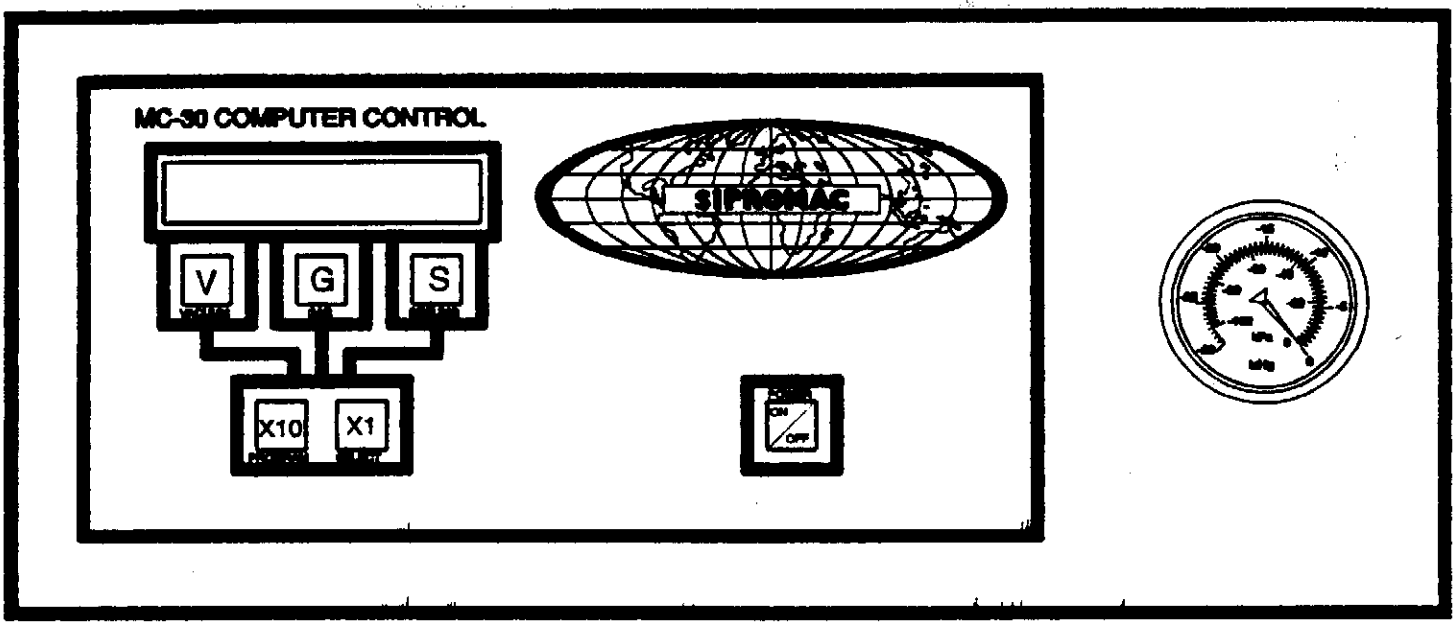
When sealing aluminium laminate bags (especially bags for e.g. coffee) it is imperative to have an upper and a lower sealing bar.

3.2.3 Electrical bag cut:

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

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

Control pannel:



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

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

How to program a complete cycle:

To enter the vacuum time (sec.):

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

To enter the gas time (sec.):

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

To enter the sealing time (sec. decimals):

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

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

BASIC PROGRAM TO MODIFY ACCORDING TO THE PRODUCTS

MACHINE	"V"	* "G"	"S"
VAC 250	18 sec.	As needed	1.2 sec.
VAC 350,350D	20 sec.	As needed	1.3 sec.
VAC 450T,450A	20 sec.	As needed	1.3 sec.
VAC 420A	22 sec.	As needed	1.3 sec.
VAC 550A	25 sec.	As needed	1.5 sec.
VAC 580A	25 sec.	As needed	1.5 sec.
VAC 600A	25 sec.	As needed	1.5 sec.
VAC 620A	25 sec.	As needed	1.5 sec.
VAC 650A	27 sec.	As needed	1.5 sec.
VAC 650A AUTOMATIC	27 sec.	As needed	1.5 sec
VAC 700A	27 sec.	As needed	1.5 sec.

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

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

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

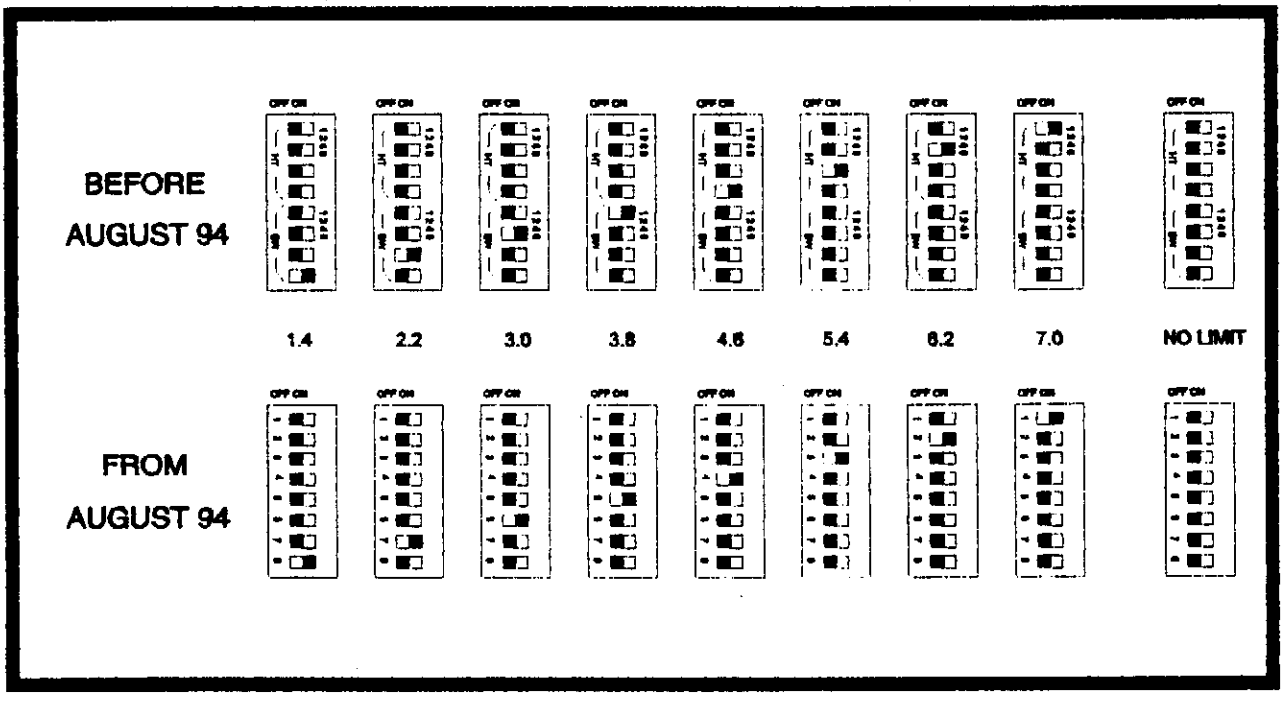
How to use the memories of the MC-30E p.c. board:

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

3.3 Con't

Sealing time security:

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



TIME LIMITS:

Time limit factory settings:

250	3.0
350,350D	3.8
420A	4.6
450T,450A	4.6
550A	4.6
580A	4.6
600A	4.6
620A	4.6
650A	4.6
650A AUTOMATIC	4.6
700A	4.6

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

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

3.4 Daily cleaning:

For hygenic cleanliness, it is imperative to clean chamber and spacers daily. Also clean the lid rubber to assure tight seat of the lid. Regular application of talkum powder will increase working life of the lid rubber.

Check oil in the pump weekly and add if neccessary. Only use oil types recommended by the producer (see pump brochure).

Check vacuum hose for damage regularly, will save a lot of avoidable trouble with machine breakdown.

4. TROUBLE SHOOTING:

4.1 Failure during a packaging cycle:

The lid is closed and cycle fails to start or stop immediatly after having started:
Micro switch is actuated too late, re-set the micro switch.
Fault in supply of electricity to the timing control (power on light does not go on):
Check input voltage at transformer (faulty contact in wires);
Check secondary voltage of transformer (approx. 24 Volt AC);
Check fuse;
If none of these apply, change the PC board.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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's.

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 leak with 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.

Verify 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 verifing machine.

Most frequent points of leakage: lid gasket, damaged vacuum hose and 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.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

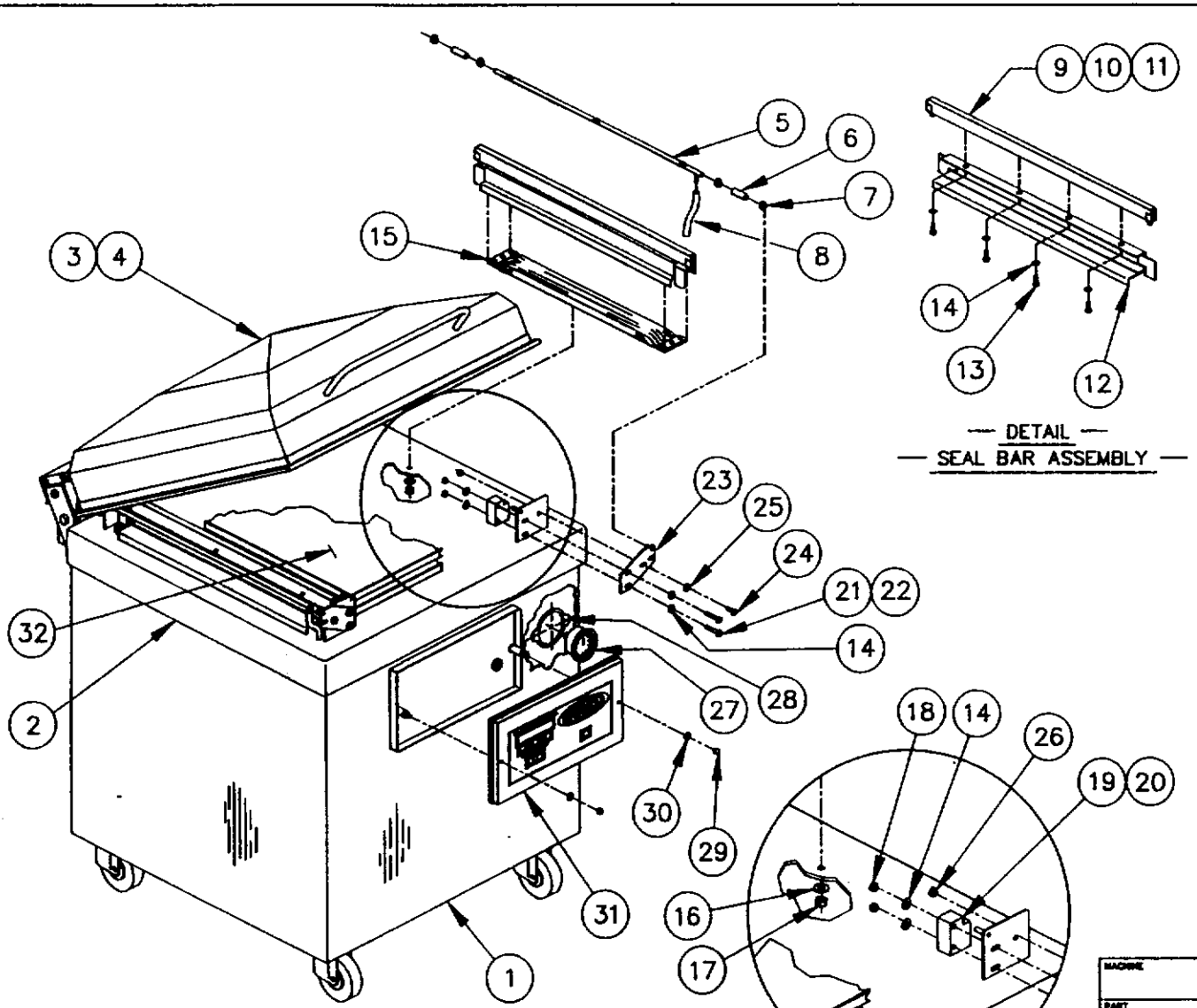
4.3.4 Seal does not stick:

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.

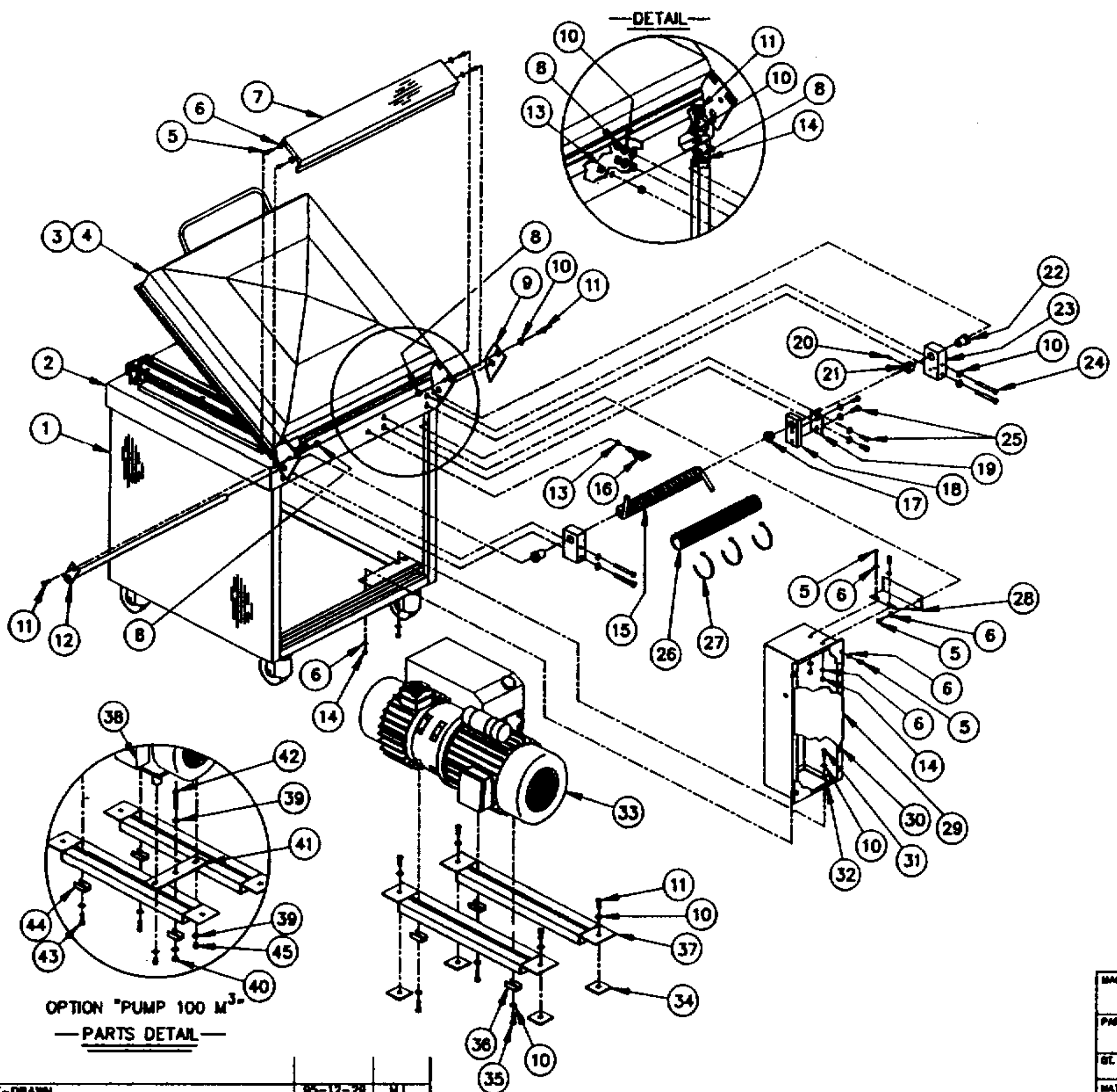


ITEM	PART #	DESCRIPTION	QT.
1	005-0460	BODY ASSEMBLY	1
2	005-0341	TABLE ASSEMBLY	1
3	005-0461	8" COVER ASSEMBLY	1
4	005-0462	12" COVER ASSEMBLY (OPTION)	1
5	009-0040	GAS INJECTION BAR (OPTION)	2
6	008-0295	GAS INJ. CONN. TUBE (OPTION)	4
7	105-0220	COLLARS (OPTION)	8
8	179-0008	TUBE (OPTION)	2
9	005-0152	SEAL BAR PRE-ASSEMBLY	2
10	005-0153	SEAL BAR P.-ASSY.(BAG CUT OPT.)	2
11	005-0370	SEAL BAR P.-ASSY.(TOP/BOT.OPT.)	2
12	005-0151	SEAL BAR SUPPORT ASSEMBLY	2
13	051-0180	BOLT 1/4"-20 x 1/2" S/S	8
14	051-0740	WASHER 1/4" FLAT S/S	8
15	005-0320	BELLOWS ASSEMBLY	2
16	051-0780	FLAT WASHER 3/8" S.S.	2
17	051-0620	HEX. NUT 3/8"-16 S.S.	2
18	051-0581	LOCK NUT 1/4"-20 S.S./NYLON	8
19	002-0326	LEFT/SEAL BAR GUIDE BLOCK	2
20	002-0327	RIGHT/SEAL BAR GUIDE BLOCK	2
21	051-0250	BOLT 1/4"-20 x 1 1/2" S/S	8
22	051-0255	BOLT 1/4"-20 x 1 3/4" S/S(OPT.)	8
23	005-0326	GAS INJ.BAR SUPP.ASS'Y (OPT.)	4
24	051-0190	BOLT 1/4"-20 x 3/4" S/S (OPT.)	4
25	051-0740	FLAT WASHER 1/4" S.S. (OPTION)	4
26	051-0580	NUT 1/4"-20 S/S (OPTION)	4
27	114-0260	VACUUM GAUGE	1
28	114-0290	VACUUM GAUGE FIXATION RING	1
29	051-0591	ACORN NUT 1/4"-20 S.S.	2
30	051-0740	FLAT WASHER 1/4" S.S.	2
31	005-0319	P.C. BOARD SUPPORT ASSEMBLY	1
32	005-0340	FILLER PLATE ASSEMBLY	2

LET.	MODIFICATION	DATE	INT.
A	RE-DRAWN	95-12-28	M.L.

MACHINE	550A	METRIC TOLERANCE	INCH TOLERANCE
PART	MACHINE ASSEMBLY FRONT VIEW		SIPROMAC
QTY. 1	SCALE NOT TO SCALE		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
MAT.	DRN. BY M.LAVIGNE APP.	DATE 95-12-28 DATE	NO. 005-0338

005-0338



ITEM	PART #	DESCRIPTION	QT.
1	005-0460	BODY ASSEMBLY	1
2	005-0341	TABLE ASSEMBLY	1
3	005-0461	8" COVER ASSEMBLY	1
4	005-0462	12" COVER ASSEMBLY (OPTION)	1
5	051-0180	HEX. BOLT 1/4"-20 x 1/2" S.S.	11
6	051-0740	FLAT WASHER 1/4" S.S.	17
7	004-0171	SPRING COVER ASSEMBLY	1
8	051-0620	HEX. NUT 3/8"-16 S.S.	12
9	001-1335	CHAMBER STOPPER	1
10	051-0780	FLAT WASHER 3/8" S.S.	30
11	051-0350	HEX. BOLT 3/8"-16 x 3/4" S.S.	10
12	004-0129	SHAFT ASSEMBLY	1
13	051-0630	HEX. NUT 1/2"-13 S.S.	2
14	051-0580	HEX. NUT 1/4"-20 S.S.	5
15	008-0322	SPRING	1
16	005-0346	SPRING TORQUE SUPPORT	1
17	075-0610	BUSHING	1
18	002-0391	CENTRAL REAR BLOCK	1
19	001-1540	CENTRAL REAR BLOCK SUPPORT	1
20	051-0178	SET SCREW 1/4"-20 x 5/16" S.S.	1
21	005-0348	COLLAR SWITCH	1
22	075-0630	BUSHING	2
23	002-0329	REAR BLOCK	2
24	051-0422	HEX. BOLT 3/8"-16 x 3 1/4" S.S.	4
25	051-0360	HEX. BOLT 3/8"-16 x 1" S.S.	4
26	038-0350	SPRING FITTING UP	1
27	057-0330	CABLE TIES	3
28	001-1364	UPPER ELECTRICAL BOX SUPPORT	1
29	001-1341	ELECTRICAL BOX COVER	1
30	179-0004	SELF ADHESIVE SPONGE NEOPRENE	1
31	051-0190	HEX. BOLT 1/4"-20 x 3/4" S.S.	2
32	005-0347	ELECTRICAL BOX PRE-ASSEMBLY	1
33	125--	PUMP 63 M³	1
34	005-0088	PUMP SUPPORT PLATE ASSEMBLY	4
35	052-4220	HEX. BOLT M8 x 30 ZINC	3
36	001-0199	SUPPORT	3
37	005-0342	PUMP SUPPORT ASSEMBLY	2
38	125--	PUMP 100 M³ (OPTION)	1
39	051-0780	FLAT WASHER 3/8" S.S. (OPTION)	6
40	051-0620	HEX. NUT 3/8"-16 S.S. (OPTION)	1
41	001-1318	PUMP FIXATION PLATE (OPTION)	1
42	051-0380	HEX.BOLT 3/8"-16x1 1/2" S.S. (OPT.)	1
43	052-4220	HEX. BOLT M8 x 30 ZINC (OPTION)	2
44	001-0199	SUPPORT (OPTION)	3
45	052-4200	HEX. BOLT M8 x 10 ZINC (OPTION)	2

LET.	MODIFICATION	DATE	INT.
A	RE-DRAWN	95-12-29	M.L.

MACHINE	550A
PART	MACHINE ASSEMBLY REAR VIEW
QT.	1
SCALE	NOT TO SCALE
DRAWN BY	M.LAVIGNE
DATE	95-12-29
NO.	005-0339

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

005-0339

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

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

4.5 Control board failure

PROBLEM	POSSIBLE CAUSE		
1. No display switch on	1.1	Programming error	Press on/off membrane
	1.2	No current coming to PC board	Check fuses Check voltage between pins #6 and #13 on "D" connector, the reading should be approx. 9 volts AC (if not it's due to transformer or wiring defect)
	1.3	On/off key defective membrane	Disconnect flat cable between PC board and switch and jump pins 1 and 2 or 7 and 8 using a screw driver
	1.4	Defective PC board	Replace PC board
2. Two digits continuously flashes on "V","G" or "S"	2.1	Programming error	Press corresponding "V", "G" or "S" key
	2.2	Defective membrane	Replace membrane
	2.3	Defective PC board	Replace PC board

4.5 Con't

3. All of the display continuously flashes	3.1 Cover switch remains closed	Check cover switch or continuity between pins #8 and #15 PC board connector (see dwg #006-0029)
	3.2 Defective	Replace PC board
4. Display is on but impossible to program any valves	4.1 Programming error	Press "V", "G" or "S" to be in programming mode. Only one at a time
	4.2 Defective PC board	Replace PC board
5. Impossible to program one timer ("V", "G" or "S") (the display is on) (see step 4 first)	5.1 Defective membrane	Replace membrane
	5.2 Defective PC board	Replace PC board
6. PC board doesn't keep data in memory	6.1 Battery not charged	Run the machine or leave it plugged in with switch off for a few hours to charge battery
	6.2 Defective battery	Replace battery or complete PC board (the battery is mounted on the PC board)
	6.3 Defective	Replace PC board Pc board

7. Cycle does'nt start	7.1 Poorly adjusted cover switch	Adjust
	7.2 Bad connection or defective limit switch	Verify
	7.3 Defective PC board	Replace PC board
	7.4 PC board is OK, outputs are defective (See dwg # 006-0029)	Check pump fuses, pump contactor coil,valves,etc..
8. Machine "recycling" or cycle "re-start" continuously	8.1 Poorly adjusted cover switch	Adjust
	8.2 Defective PC board	Replace
9. Double chamber: vacuum sealing or atmosphere is not done on one side only	9.1 Defective relay or connection	Replace the 4PDT (in electrical box). This relay switch fonctions from one side to the other (the PC board is good because there is one output which control's both sides)
	9.2 Defective contactor or valve	Test voltage on coil

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

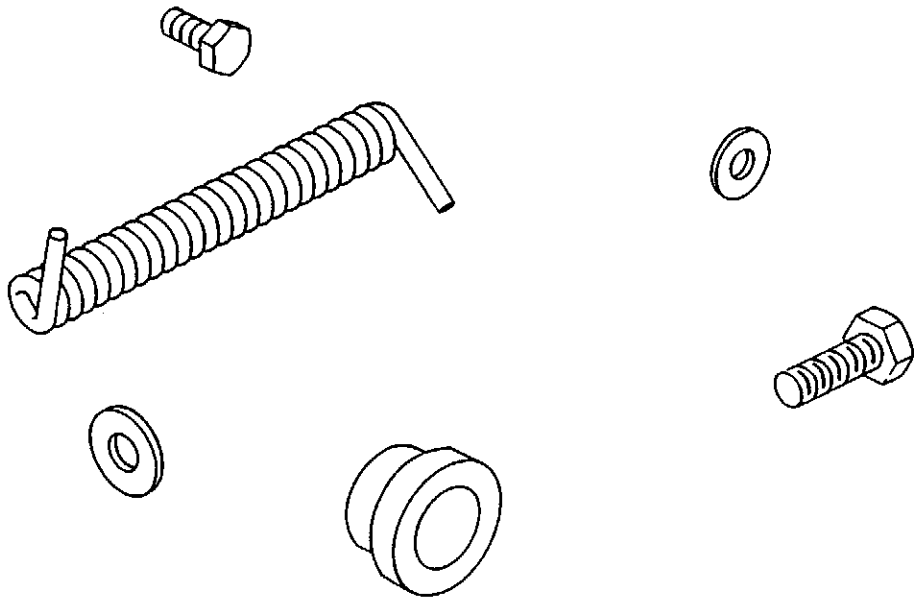
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

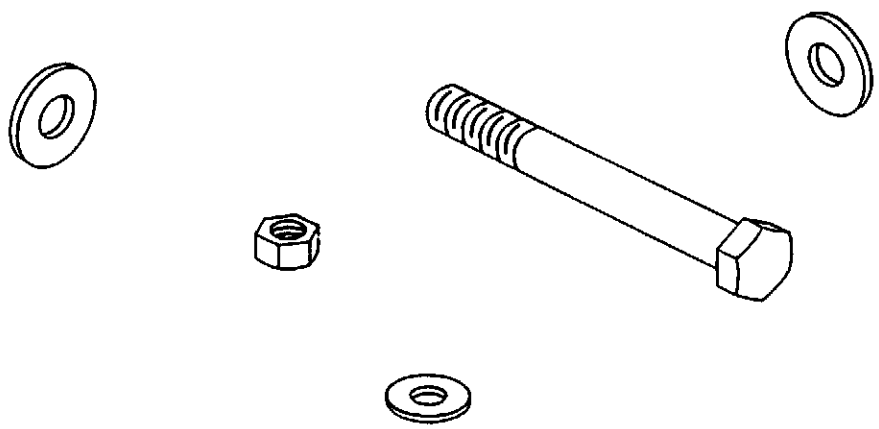
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

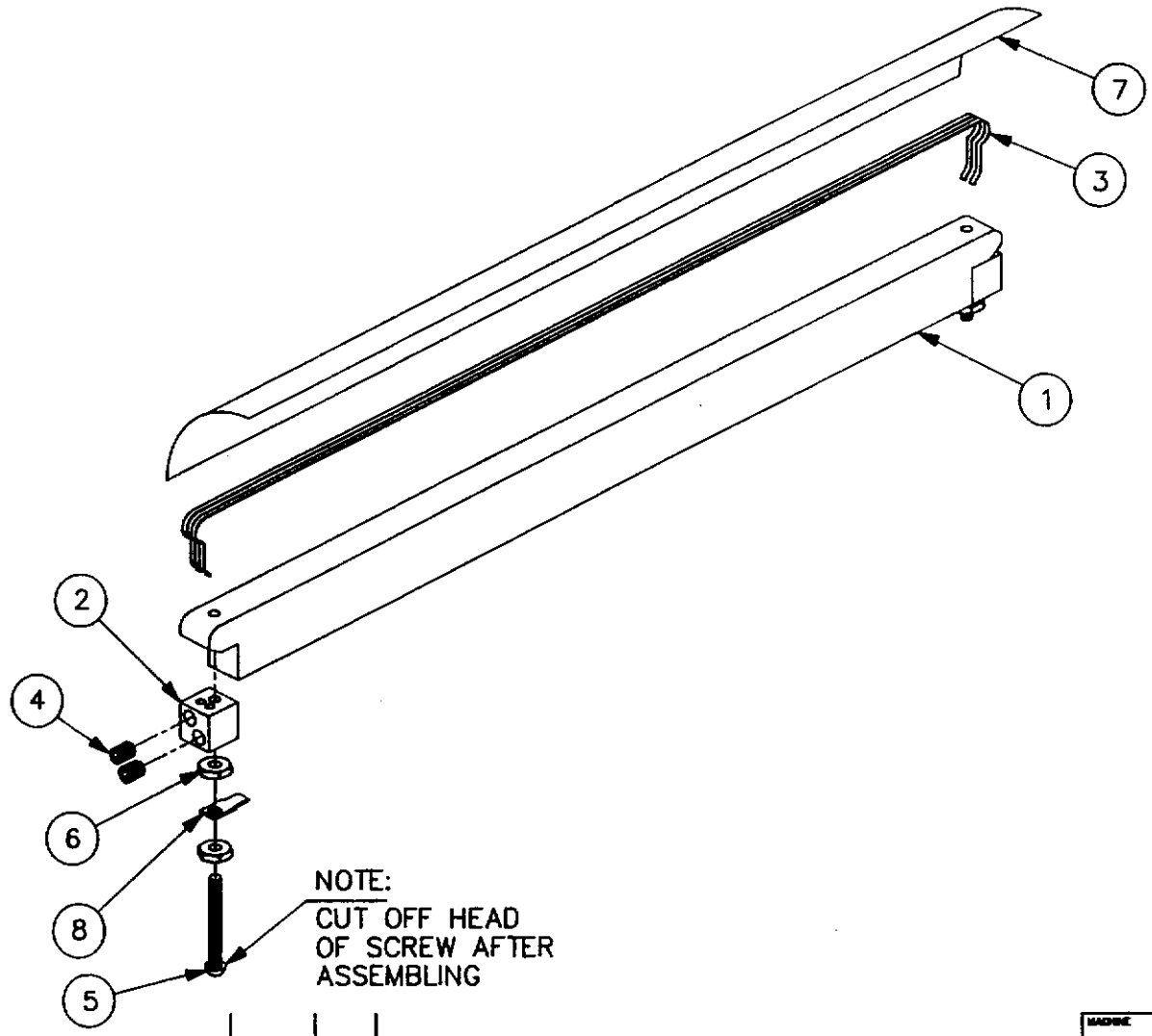
Check function of cycle with various settings of timers.



MECHANICAL DRAWING



ITEM	PART #	DESCRIPTION	QTY
1	002-0314	SEAL BAR (TABLE)	2/4
2	002-0031	CONNECTOR	4/8
3	039-0200	SEALING ELEMENT	4/8
4	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	8/16
5	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	4/8
6	051-0550	NUT #8-32 S/S	8/16
7	176-0200	TEFLON TAPE (5S) ADHESIVE	2/4
8	027-0400	CONNECTOR ADAPTOR	4/8



NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

MACHINE	QTY
600A	4
550A	2

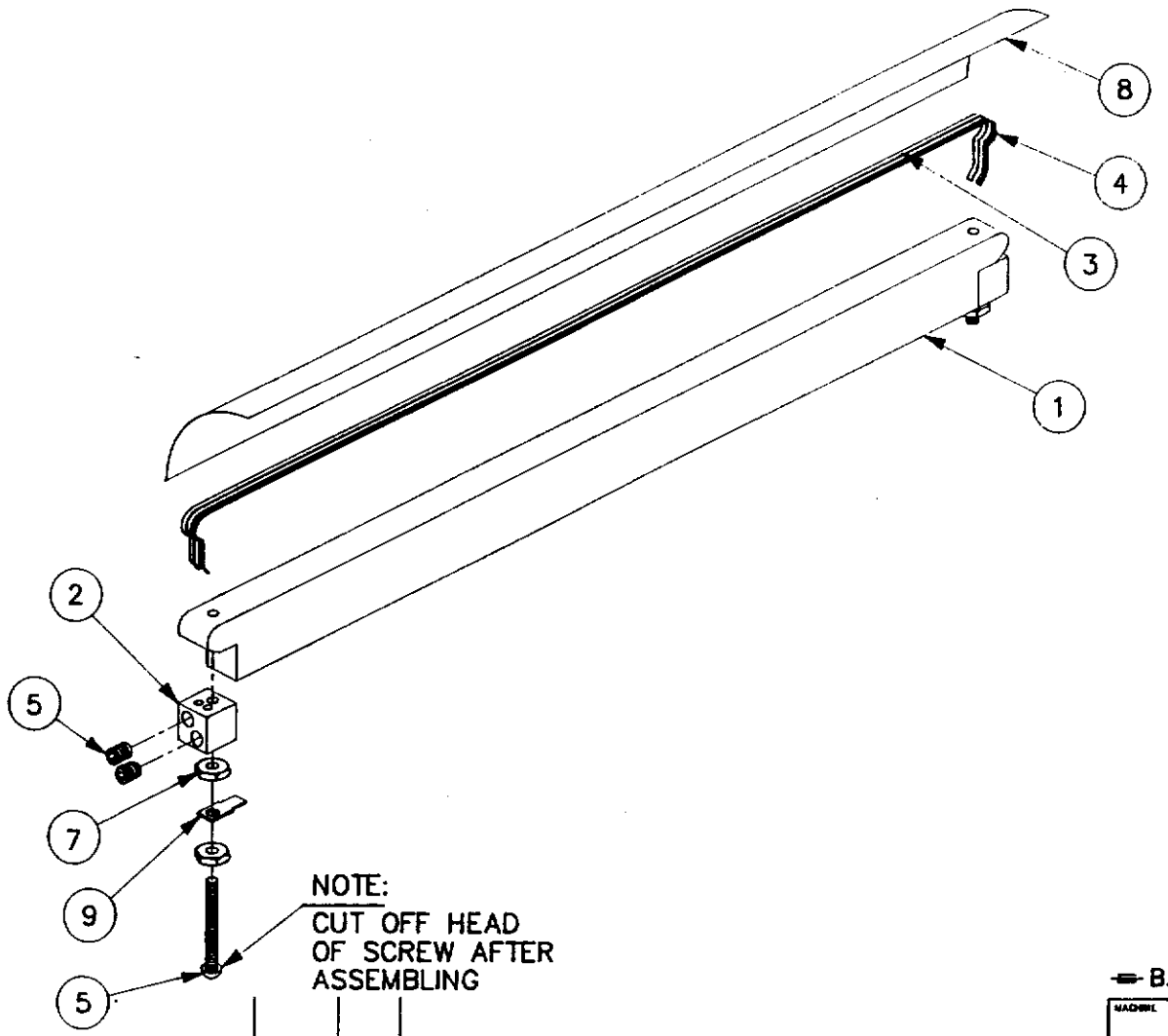
LET.	MODIFICATION	DATE	INT.
B	RE-DRAWN	95-12-29	M.L.

MACHINE: 550A & 600A
PART: SEAL BAR PRE-ASSEMBLY
QT. 2/4 | SCALE ——— | NOT TO SCALE
MAT: | DRWN BY M.LAVIGNE | DATE 95-12-29 | APP. | DATE
METRIC TOLERANCE: X ± .5 | .X ± .25 | .XX ± .025 | .XXX ± .0050 | ANGLE ± 1°
INCH TOLERANCE: .X ± .010" | .XX ± .005" | .XXX ± .0050"

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA
NO. 005-0152

005-0152

ITEM	PART #	DESCRIPTION	QT.
1	002-0314	SEAL BAR (TABLE)	2/4
2	002-0031	CONNECTOR	4/8
3	039-0230	CONVEX SEALING ELEMENT	2/4
4	039-0270	"T" PROFILE CUTTING ELEMENT	2/4
5	052-0305	SCREW 1/4"-20 x 5/16" SET HEX SKT OVAL PT	8/16
6	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	4/8
7	051-0550	NUT #8-32 S/S	8/16
8	176-0200	TEFLON TAPE 5S ADHESIVE x 2"1 x 650mm	2/4
9	027-0400	CONNECTOR ADAPTOR 1/4" x #10 STUD	4/8



NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

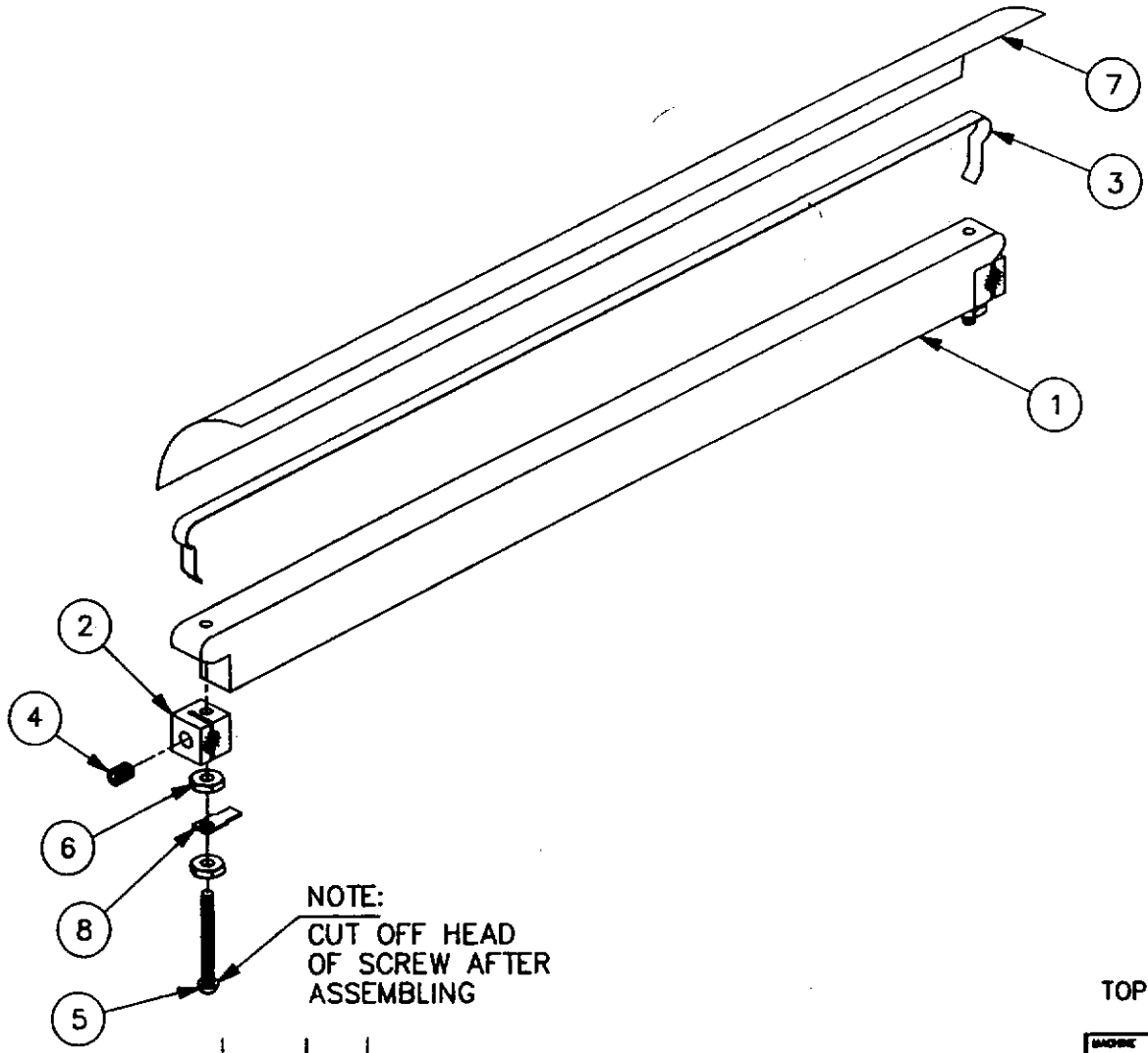
BAG CUT OPTION

LET.	MODIFICATION	DATE	INT.
C	REDRAWN	96-12-31	A.P.

MACHINE: 550A & 600A
PART: SEAL BAR PRE-ASSEMBLY
METRIC TOLERANCE: 0. ± .5 / .0 ± .05 / .00 ± .005 / .000 ± .0005 / ANGLE ± 1°
INCH TOLERANCE: .0 ± .005" / .00 ± .000" / .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:
CHG:
SCALE:
QT. 2/4
MAT:
DRN BY A.P.
APP.
DATE 96-12-31
DATE
NO. 005-0153

005-0153

ITEM	PART #	DESCRIPTION	QTY
1	002-0314	SEAL BAR (TABLE)	2/4
2	009-0029	CONNECTOR	4/8
3	036-0220	SEALING ELEMENT	2/4
4	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	4/8
5	052-0250	SCREW #8-32 x 1-1/2" RND SLOT BRASS	4/8
6	051-0550	NUT #8-32 S/S	8/16
7	176-0200	TEFLON TAPE (5S) ADHESIVE	2/4
8	027-0400	CONNECTOR ADAPTOR	4/8



NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

OPTION
TOP AND BOTTOM SEALING OR
BI-ACTIVE SEALING

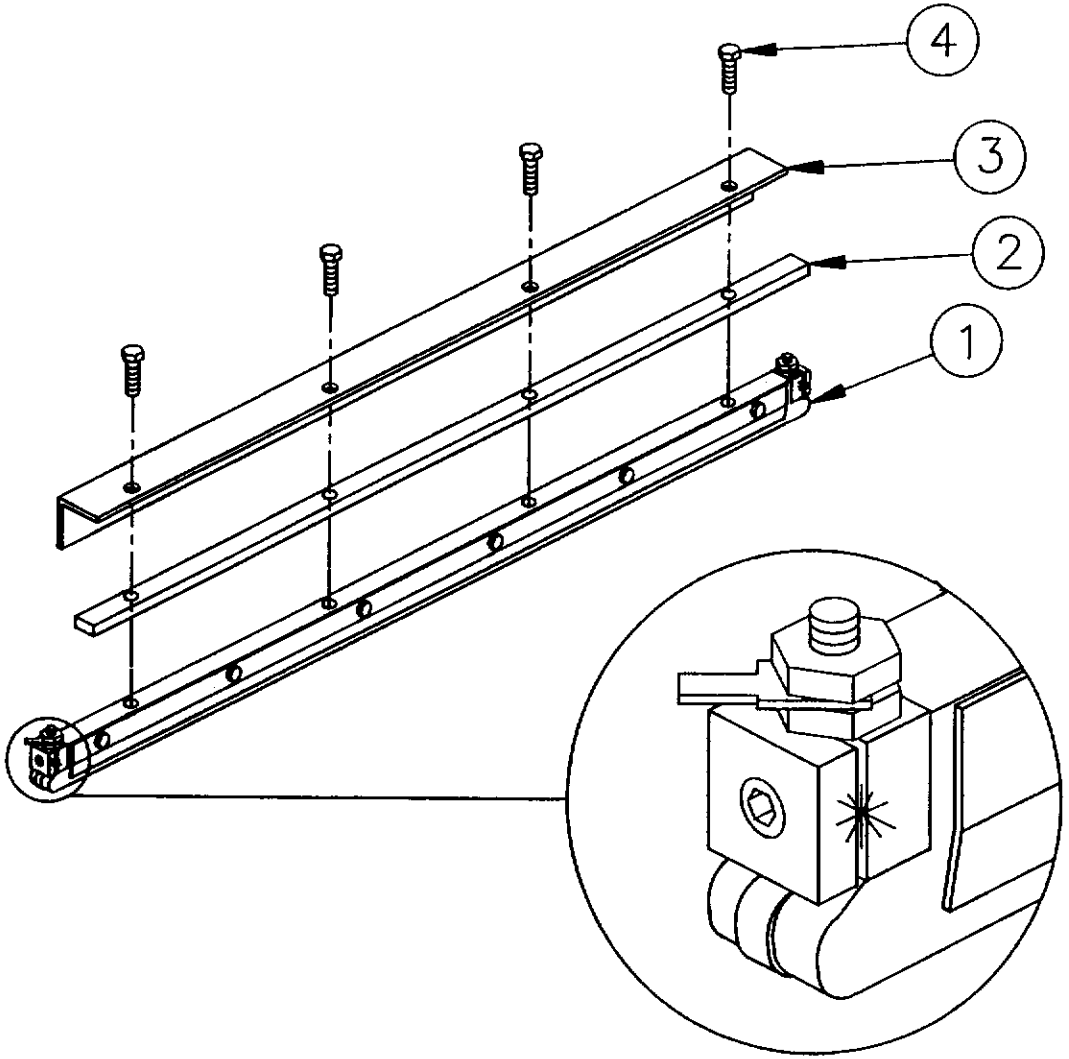
MACHINE	QTY
600A	4
550A	2

LET.	MODIFICATION	DATE	INT.
B	RE-DRAWN	95-12-29	M.L.

MACHINE: 550A & 600A
PART: SEAL BAR PRE-ASSEMBLY
QT. 2/4 SCALE —— NOT TO SCALE
MAT:
DES. M.LAVIGNE DATE 95-12-29
APP. DATE
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA
NO. 005-0370

005-0370

ITEM	PART #	DESCRIPTION	QT.
1	004-0262	UPPER SEAL BAR PRE-ASSY.	2
2	001-1388	UPPER SEAL BAR SPACER	2
3	001-1387	UPPER SEAL BAR SUPPORT	2
4	051-0190	BOLT 1/4"-20 x 3/4" S/S	8



= OPTION =

TOP & BOTTOM SEALING OR
BI-ACTIVE SEALING

LET.	MODIFICATION	DATE	INT.
B	RE-DRAWN	96-01-18	M.L.

MACHINE	550A	METRIC TOLERANCE	INCH TOLERANCE
PART	UPPER SEAL BAR ASSEMBLY		SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
QT. 2	SCALE ———	NOT TO SCALE	
MAT.	DES. M.LAMBRE APP.	DATE 96-01-18 DATE	NO. 005-0371

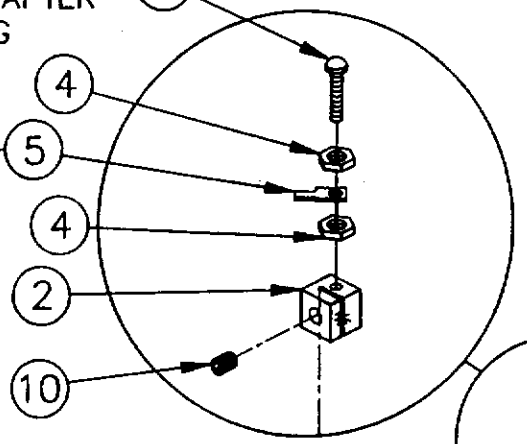
005-0371

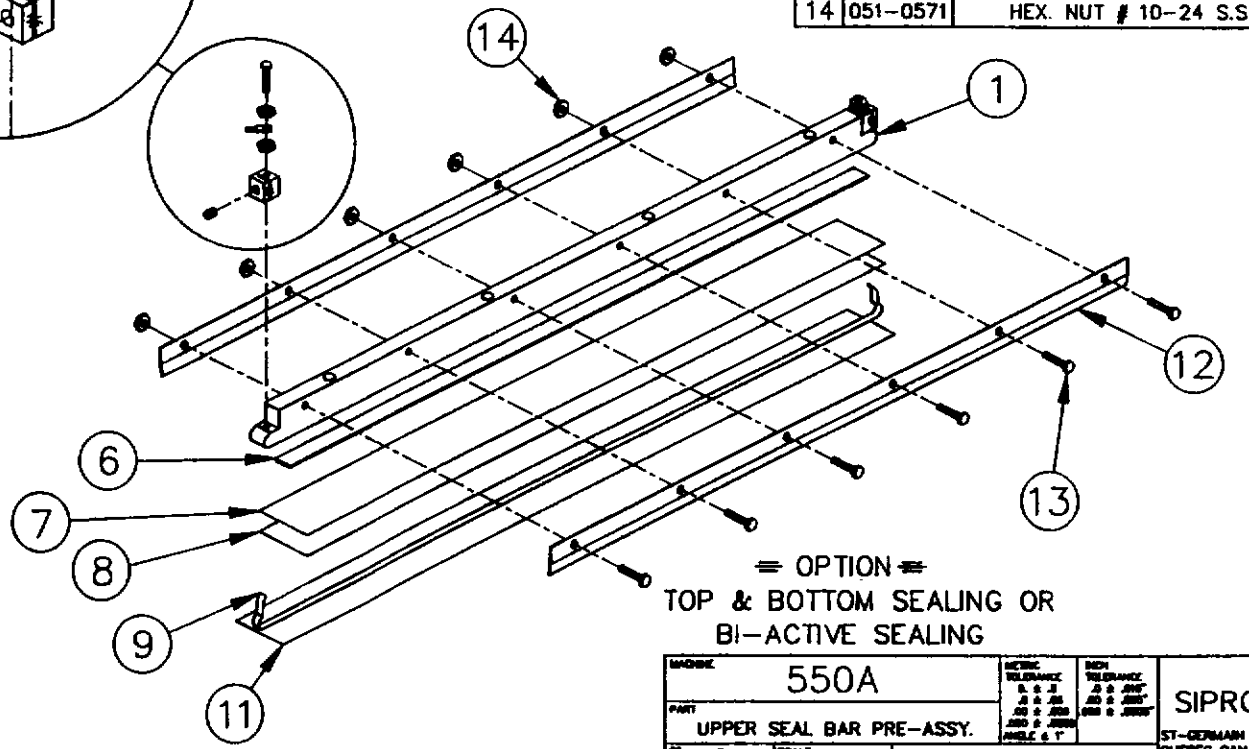
NOTE:

CUT OFF HEAD OF SCREW AFTER ASSEMBLING

NOTE:

INSTALL ITEM #5 AT ±45° TYP.





ITEM	PART #	DESCRIPTION	QT.
1	009-0033	UPPER SEAL BAR	2
2	009-0029	UPPER CONNECTOR	4
3	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	4
4	051-0550	HEX. NUT #8-32 S.S.	8
5	027-0400	CONNECTOR ADAPTOR	4
6	179-0003	UPPER SEAL BAR RUBBER	2
7	176-0200	TEFLON TAPE (5S) ADHESIVE	2
8	176-0220	TEFLON TAPE (10S) ADHESIVE	2
9	039-0220	SEALING ELEMENT	2
10	052-0395	SET SCREW 1/4"-20 x 5/16"(OVAL POINT)	4
11	176-0220	TEFLON TAPE (10S) ADHESIVE	2
12	001-1386	UPPER TEFLON HOLDER	4
13	051-0147	HEX. BOLT #10-24 x 1" S.S.	12
14	051-0571	HEX. NUT # 10-24 S.S.	12

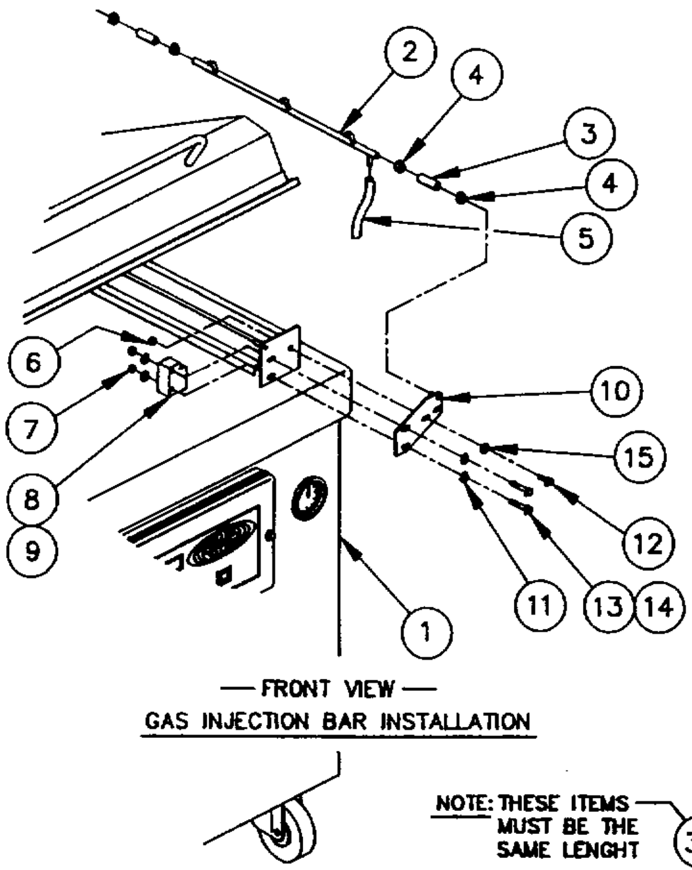
OPTION

TOP & BOTTOM SEALING OR BI-ACTIVE SEALING

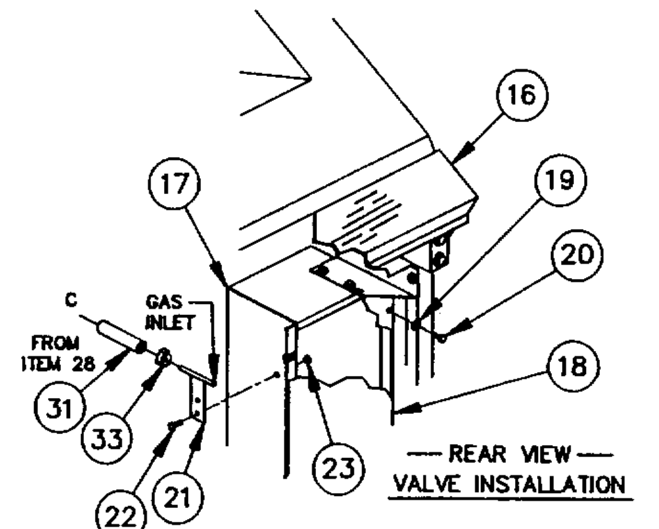
LET.	MODIFICATION	DATE	INT.
B	RE-DRAWN	96-01-18	M.L.

MACHINE	550A	METRIC TOLERANCE	INCH TOLERANCE
PART	UPPER SEAL BAR PRE-ASSY.		SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
QT. 2	SCALE ——	NOT TO SCALE	
MAT.	DWG. BY M.LAVIGNE	DATE 96-01-18	NO. 004-0262
	APP.	DATE	

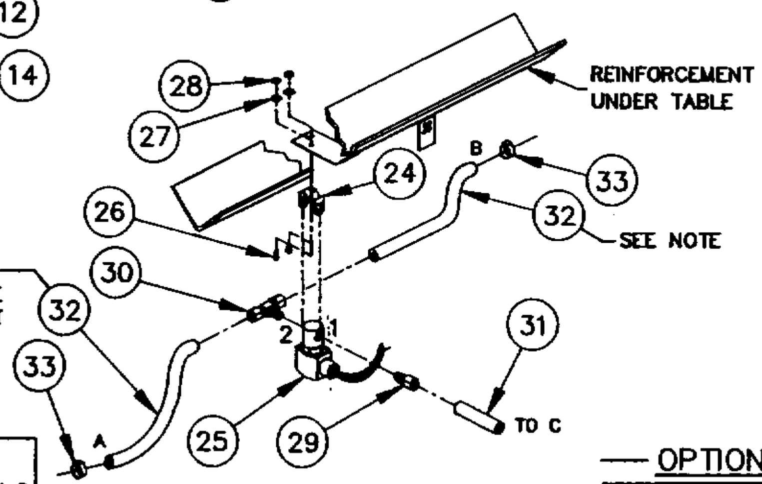
004-0262



— FRONT VIEW —
GAS INJECTION BAR INSTALLATION



— REAR VIEW —
VALVE INSTALLATION



— UNDER TABLE VIEW —
VALVE INSTALLATION

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

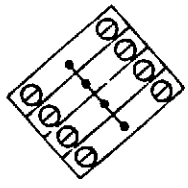
ITEM	PART #	DESCRIPTION	QT.
1	005-0338	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0318	GAS INJECTION BAR (OPTION)	2
3	008-0295	GAS INJ. CONN. TUBE (OPTION)	4
4	105-0220	COLLARS 1/2"ø	8
5	179-0030	GAS INJECT.TUBE (OPTION)	2
6	051-0580	HEX. NUT 1/4"-20 S.S.	4
7	051-0581	LOCK NUT 1/4"-20 S.S./NYLON	8
8	002-0326	LEFT/SEAL BAR GUIDE BLOCK	2
9	002-0327	RIGHT/SEAL BAR GUIDE BLOCK	2
10	005-0326	GAS INJ.BAR SUPP.ASS'Y (OPT.)	4
11	051-0740	FLAT WASHER 1/4" S.S.	16
12	051-0190	HEX. BOLT 1/4"-20 x 3/4" S.S.	4
13	051-0250	HEX. BOLT 1/4"-20 x 1 1/2" S.S.	8
14	051-0255	HEX.BOLT 1/4"-20x1 3/4"S.S(OPT.)	8
15	051-0740	FLAT WASHER 1/4" S.S (OPT.)	4
16	005-0339	MACHINE ASSEMBLY REAR VIEW	1
17	005-0347	ELECTRICAL BOX ASSEMBLY	1
18	001-1341	ELECTRICAL BOX COVER	1
19	051-0740	FLAT WASHER 1/4" S.S.	4
20	051-0180	HEX.BOLT 1/4"-20 x 1/2" S.S.	4
21	005-0323	GAS INLET ASSEMBLY	1
22	051-0180	HEX. BOLT 1/4"-20 x 3/4" S.S.	1
23	051-0580	HEX. NUT 1/4"-20 S.S.	1
24	106-0345	VALVE SUPPORT FOR 1/4" NPT	1
25	106-0010	SELENOID VALVE 2 WAY 1/4"NPT	1
26	051-0100	R.H.SCREW #8-32 x 3/8" S.S.	2
27	051-0720	FLAT WASHER #8 S.S.	2
28	051-0550	HEX.NUT #8-32 S.S.	2
29	101-0036	STRAIGHT 1/4"MNPT x 3/8"T.P.COMP.	1
30	101-0065	T 3/8"T.P.COMP.x1/4"MNPTx3/8"T.P.COMP.	1
31	104-0060	TUBE 3/8"ODx1/4"ID(POLY.) x mm LG.	1
32	104-0060	TUBE 3/8"ODx1/4"ID(POLY.) x mm LG.	2
33	105-0200	COLLARS 3/8"ø	3

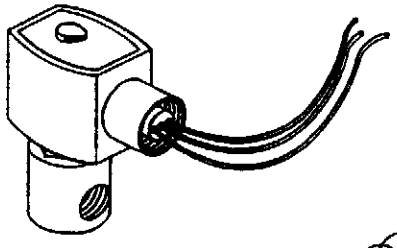
— OPTION GAS INJECTION —

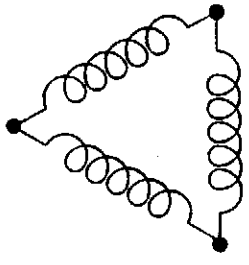
MACHINE: 550A	METRIC TOLERANCE	INCH TOLERANCE N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PART: GAS INJECTION KIT INSTALLATION			
ITEM:	DWG:	SCALE:	SH. 1
MAT:	DRN BY: M.LAVIGNE	DATE: 96-09-04	NO. 010-0013
	APP:	DATE:	

LET.	MODIFICATION	DATE	INT.
B	RE-DRAWN	96-09-04	M.L.

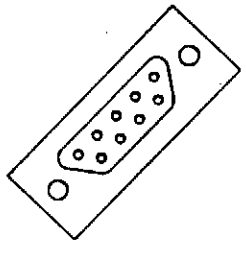
010-0013

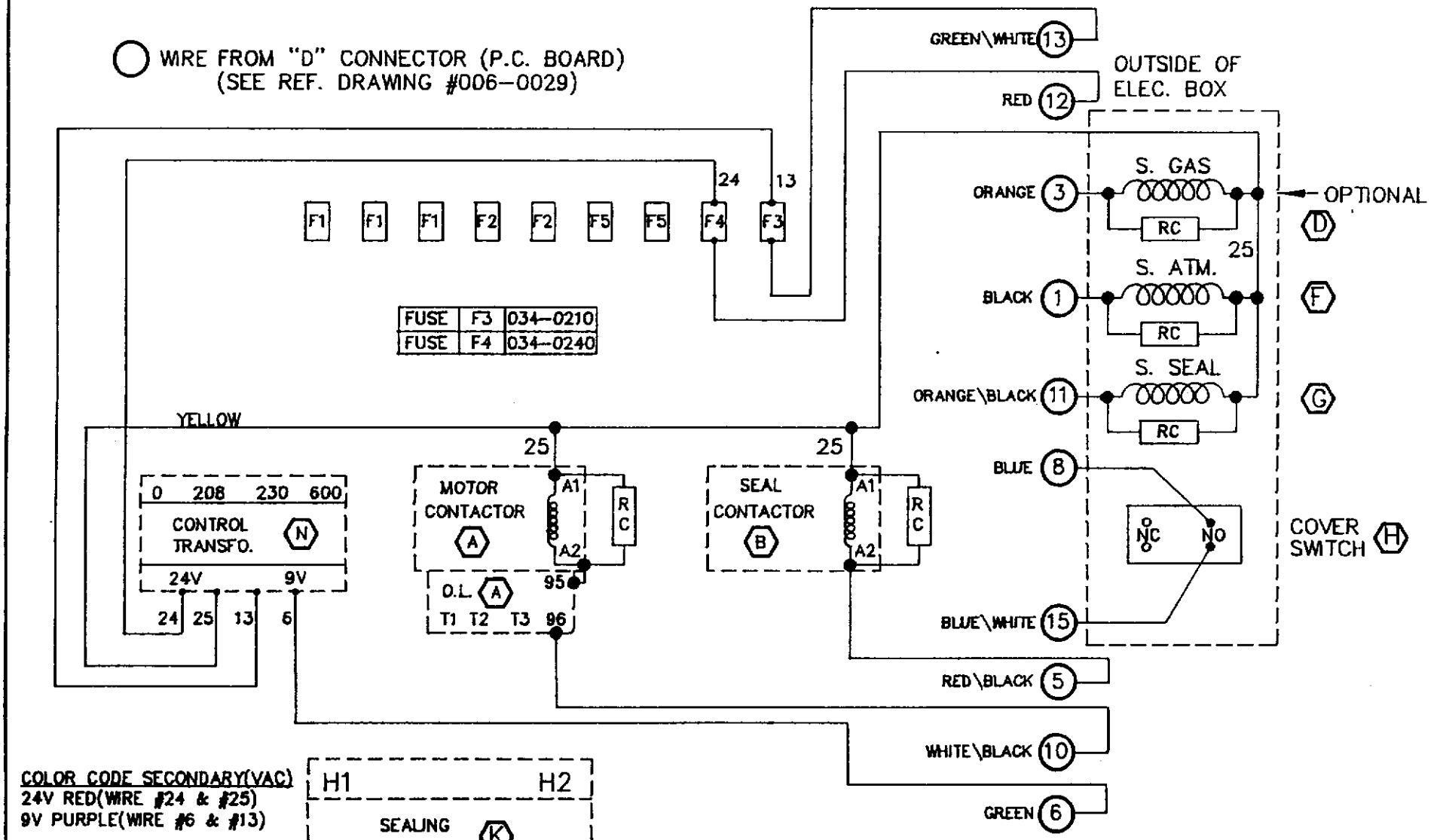






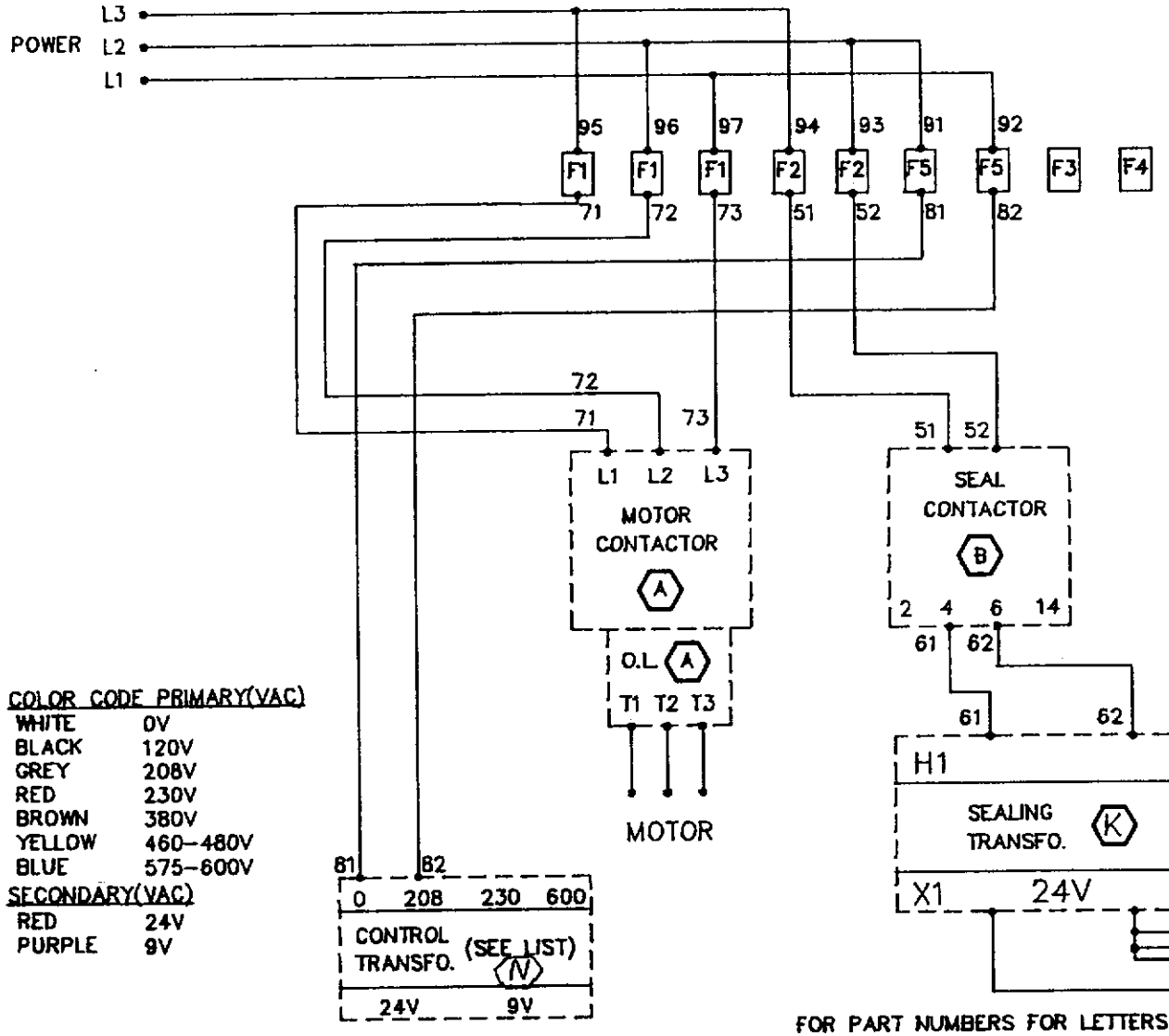
ELECTRICAL DRAWING





MACHINE	550A			SIPROMAC
PIECE	ELECT.-WIRING DIAGRAM- LOW VOLTAGE			ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
QT. ——	ECH. SCALE ——	NE PAS MESURER /N.T.S.		
MAT:	DESS. D.L.	DATE 97-03-10	NO. 006-0032	
	APP.	DATE		

LET.	MODIFICATION	DATE	INT.



PUMP		
MOTOR (HP)	VOLT +ph.	FUSE F1
3	230-1	034-0550
3	230-3	034-0530
3	575-3	034-0480
5	230-1	034-0570
5	230-3	034-0550
5	575-3	034-0510
7.5	220-3	034-0110
7.5	575-3	034-0540

OPTION	VOLTAGE	FUSE F2
TWIN SEAL & BAG CUT	220	034-0450
TWIN SEAL & BAG CUT	380	034-0430
TWIN SEAL & BAG CUT	575	034-0425
TOP & BOTTOM SEAL	220	034-0500
TOP & BOTTOM SEAL	380	034-0465
TOP & BOTTOM SEAL	575	034-0440

VOLTAGE	FUSE F5
220	034-0200
380	034-0410
575	034-0410

COLOR CODE PRIMARY(VAC)

WHITE	0V
BLACK	120V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY(VAC)

RED	24V
PURPLE	9V

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

LET.	MODIFICATION	DATE	INT.

MACHINE: 550A & 580A

PIECE: ELEC. WIRING DIAGRAM HIGH VOLTAGE 3ø

QT. ——— ECH. SCALE ———

NE PAS MESURER /N.T.S.

MAT:

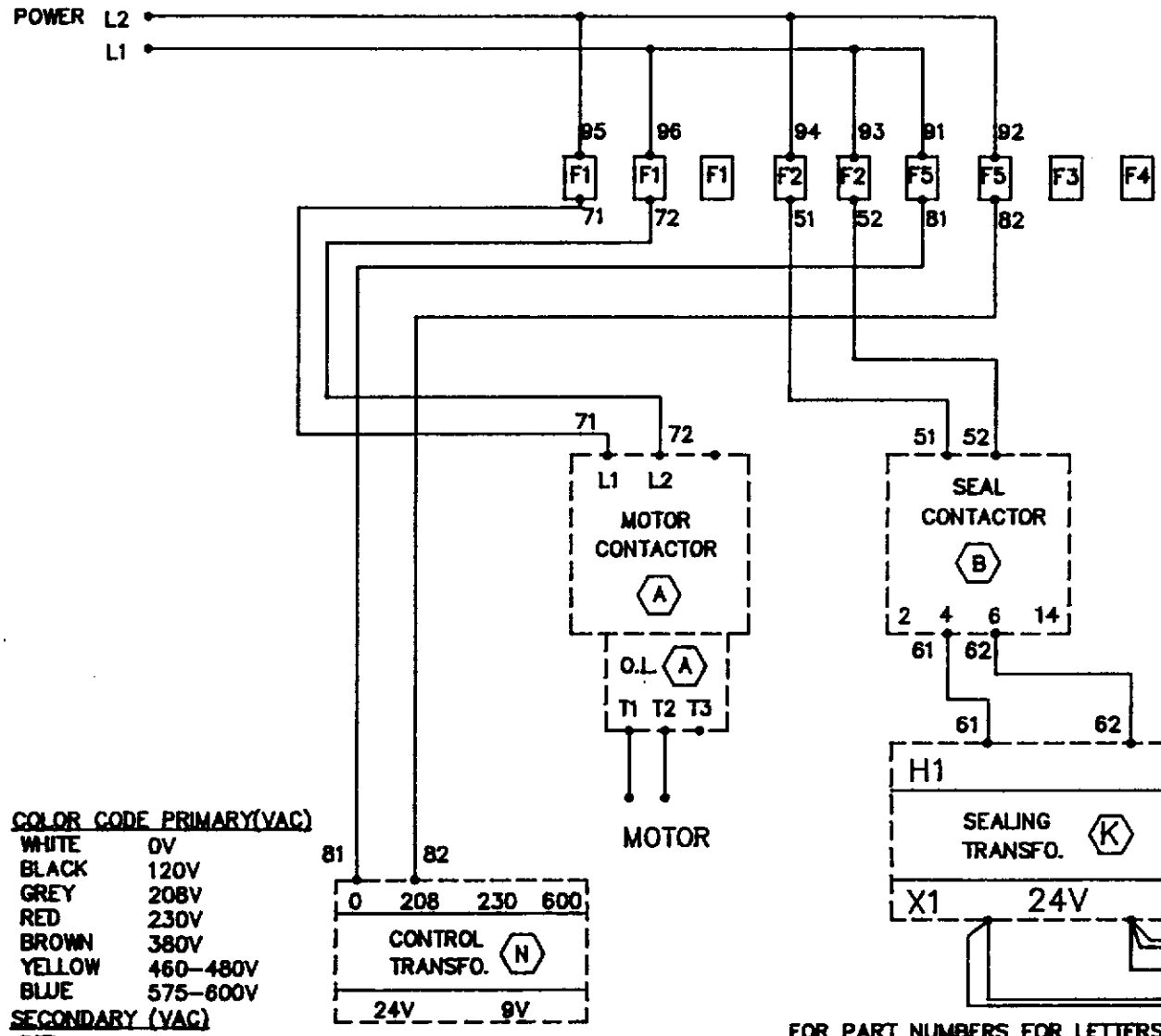
DESS. D. LETOURNEAU DATE 95-10-11

APP. DATE

NO. 006-0033

SIPROMAC
ST-GERMAIN DE GRANTHAM,
QUEBEC CANADA

006-0038



PUMP		
MOTOR (HP)	VOLT +ph	FUSE F1
3	230-1	034-0550
3	230-3	034-0530
3	380-3	034-0510
3	415-3	034-0510
3	575-3	034-0580
5	230-1	034-0570
5	230-3	034-0550
5	380-3	034-0560
5	415-3	034-0540
5	575-3	034-0510

OPTION	VOLTAGE	FUSE F2
TWIN SEAL & BAG CUT	220	034-0450
TWIN SEAL & BAG CUT	380	034-0430
TWIN SEAL & BAG CUT	600	034-0425
TOP & BOTTOM SEAL	220	034-0500
TOP & BOTTOM SEAL	380	034-0480
TOP & BOTTOM SEAL	600	034-0440

VOLTAGE	FUSE F5
220	034-0200
380	034-0410
600	034-0410

COLOR CODE PRIMARY(VAC)

WHITE	0V
BLACK	120V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY (VAC)

RED	24V
PURPLE	9V

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

LET.	MODIFICATION	DATE	INT.

MACHINE: 550A

PIECE: ELEC. WIRING DIAGRAM HIGH VOLTAGE 1Ø

QT. ——— ECH. SCALE ——— NE PAS MESURER /N.T.S.

MAT:

DESS. D. L. DATE 97-03-10

APP. DATE

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

NO. 006-0038

MODEL:250,350,420A,450A,550A,450T,600A,620A,650A & 700A

A : VOLT	PHASE	PUMP	CONTACTOR	OVERLOAD
110	1	3	025-0010	025-0140
110	1	6	025-0020	025-0170
110	1	16	025-0030	025-0180
110	1	21	025-0030	025-0190
220	1	21	025-0020	025-0190
220	1	40	025-0020	025-0190
220	3	40	025-0010	025-0170
380	3	40	025-0020	025-0150
575	3	40	025-0010	025-0140
220	1	63	025-0040	025-0190
220	3	63	025-0020	025-0180
575	3	63	025-0010	025-0150
220	1	100	025-0050	025-0200
220	3	100	025-0030	025-0190
460	3	100	025-0010	025-0170
575	3	100	025-0010	025-0160
220	1	160	025-0070	025-0222
220	3	160	025-0040	025-0210
575	3	160	025-0010	025-0180
220	3	250	025-0060	025-0220
460	3	250	025-0030	025-0190
575	3	250	025-0020	025-0190

B,C & O: SEALING CONTACTOR: # 025-0020

D: OPTIONAL GAZ SOLENOID VALVE: # 106-0010

E: VACUUM SOLENOID VALVE: # 106-0030---(420A)
106-0050---(600A & 620A)
106-0060---(650A)

F: ATMOSPHERE SOLENOID VALVE: # 106-0020 WITH PUMP: 21 M^3
106-0030 WITH PUMPS: 40 M^3, 60 M^3 & 100 M^3
106-0050 WITH PUMPS: 160 M^3 & 250M^3

G: BELLOWS SOLENOID VALVE: # 106-0070

H, I, J: COVER SWITCH: # 026-0610

K: SEALING TRANSFO.:
250 ONE SEAL BAR: # 029-0040
350 ONE SEAL BAR: # 029-0010
350 TWO SEAL BAR: # 029-0030
650 ALL MODEL : # 029-0170
420,450,550,600,620 TWIN SEAL & BAG CUT 220 VOLTS: # 029-0040
TWIN SEAL & BAG CUT 575 VOLTS: # 029-0050
TOP & BOTTOM SEALING 220 VOLTS: # 029-0080
TOP & BOTTOM SEALING 575 VOLTS: # 029-0095

L: RELAY & BASE: RELAY: # 025-MY424 & BASE: # 025-0600

M: OPTIONAL TOP SEALING CONTACTOR: # 025-0020

N: CONTROL TRANSFO.:MODEL 250 TO 650:029-0007,029-0008,029-0009, 029-0250

MODEL 700A:029-0010

DL/73

006-0029

ITEM	# PIECE	DESCRIPTION	QT.

WIRING OF 15 PIN "D" CONNECTOR-VACUUM PACKAGING MACHINE

COLOR CODE

(1) BLACK : OUTPUT TO ATMOSPHERE VALVE

JUMP SEE NOTE

(2) WHITE : OUTPUT TO SEALING CONTACTOR

(3) ORANGE : OUTPUT TO GAZ VALVE

PC BOARD RELAY

(4) RED/WHITE : CONTACT OF PC BOARD RELAY ACTIVATES WHEN MACHINE IS ON

(5) RED/BLACK : CONTACT OF PC BOARD RELAY ACTIVATES WHEN MACHINE IS ON

(6) GREEN : INPUT 9 VAC

(7) ---- : JUMPED WITH (6)

COVER SWITCH

(8) BLUE : TO COVER SWITCH

(9) ---- : NOT USED

(10) WHITE/BLACK : OUTPUT TO VACUUM VALVE OR CONT. MOTOR 350,450A OR 550A)

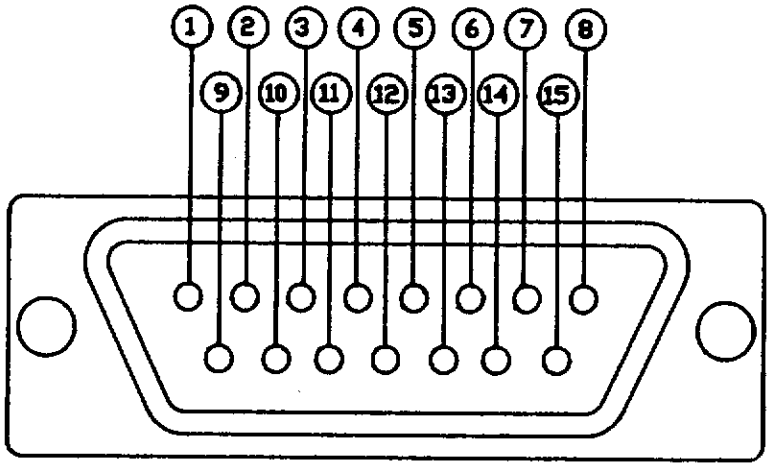
(11) ORANGE/BLACK : OUTPUT TO SEALING SELENOID VALVE (350,

(12) RED : INPUT 24 VAC

(13) GREEN/WHITE : INPUT 9 VAC

(14) ---- : JUMPED WITH (13)

(15) BLUE/WHITE : TO COVER SWITCH



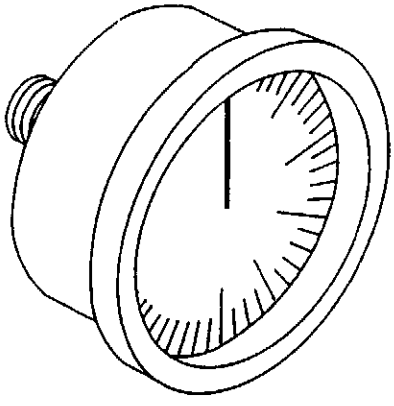
WIRE SIDE VIEW

NOTE: - JUMP (2)(4) FOR VACUUM : 250 350 450A 550A ONLY

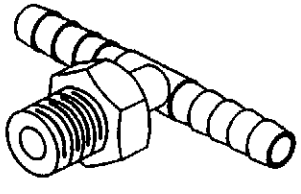
-THIS CONNECTOR PLUGS IN AT REAR OF P.C. BOARD

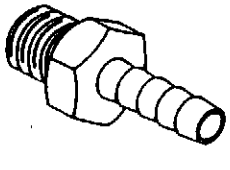
MACHINE	VACUUMS		SIPROMAC
PIECE	"D" CONNECTOR DETAIL		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
QT. ———	ECH. SCALE ———	NE PAS MESURER /N.T.S.	
MAT.	DESS. D.LETOURNEAU	DATE 96-11-07	NO. 006-0029
	APP.	DATE	

LET.	MODIFICATION	DATE	INT.
	REDESSINE	95-01-31	D.L.

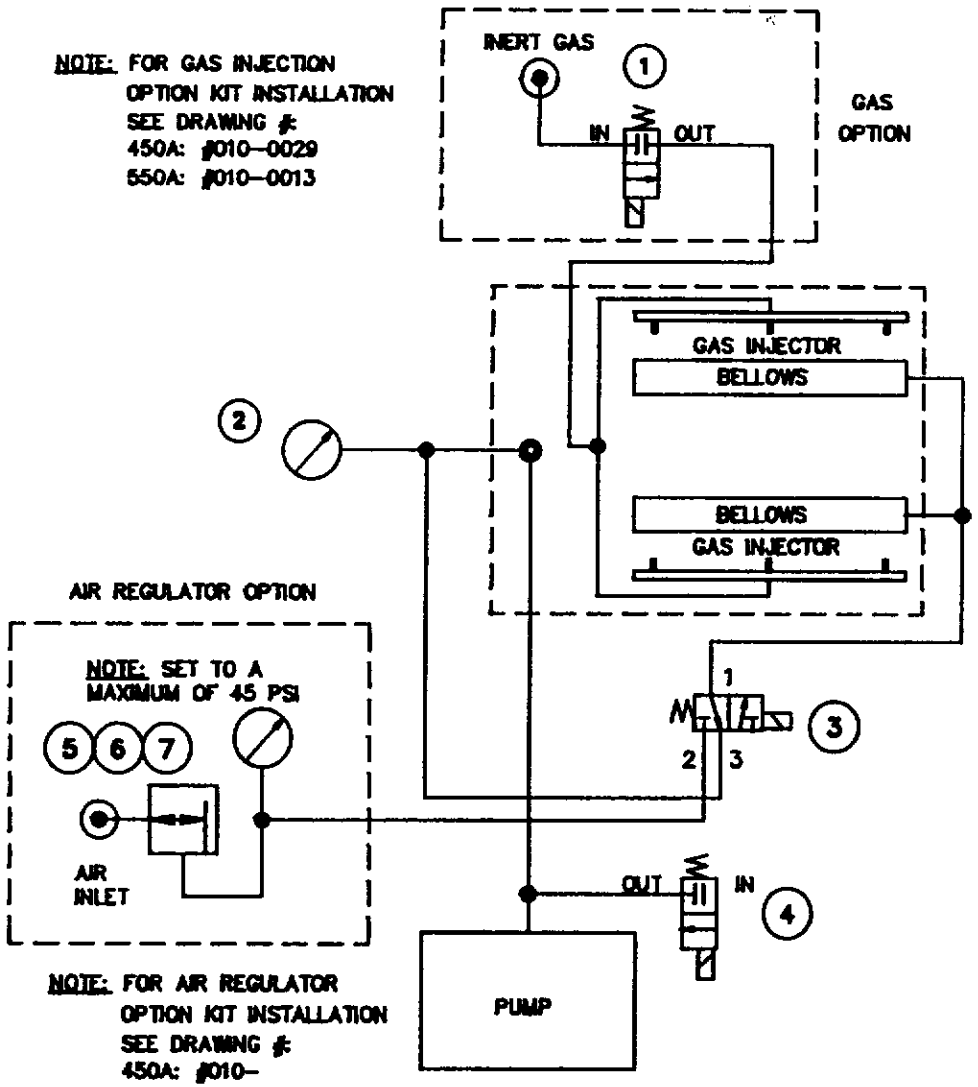


PNEUMATIC DRAWING





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



LET.	MODIFICATION	DATE	INT.
B	RE-DRAWN	97-03-12	M.L.

MACHINE: 450A & 550A

PART: PNEUMATIC DRAWING

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

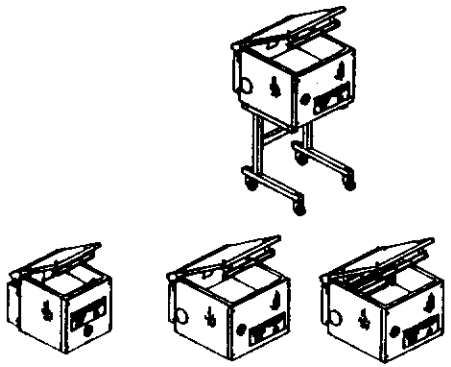
ITEM: ——— CNC: ——— SCALE ——— QT. 1

MAT: DWG BY M.LAVIGNE DATE 97-03-12

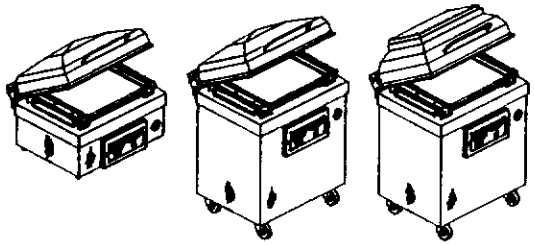
APP. DATE

NO. 007-0018

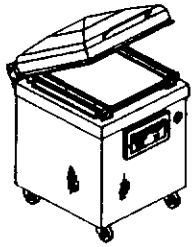
NOTES



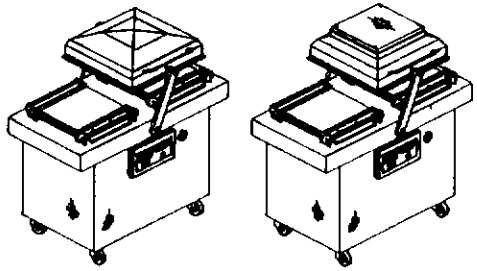
MODEL 250 MODEL 350 MODEL 350D



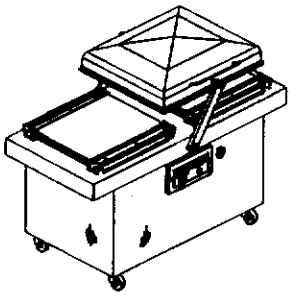
MODEL 450T MODEL 450A



MODEL 550A



MODEL 420A



MODEL 600A

SIPROMAC

Canada

SIPROMAC
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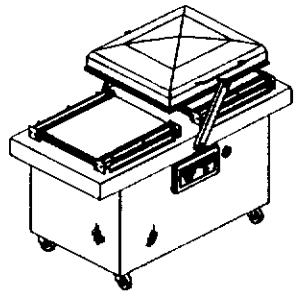
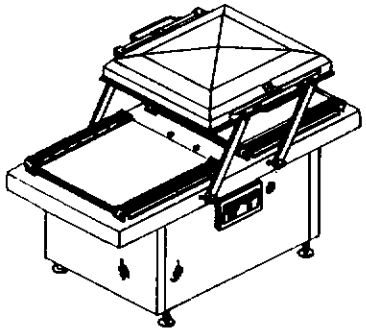
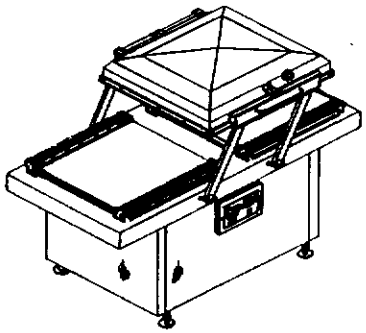
VACUUM PACKAGING MACHINES



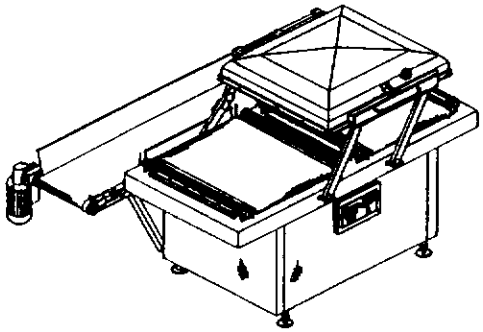
MODEL 620A

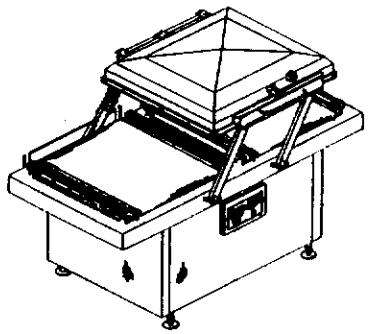


MODEL 650A



MODEL 650A AUTOMATIC





MODEL 700A

97-03-11/ML
(1997 EDITION)