

MODEL 550A
(MC-40)



VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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VACUUM PACKAGING MACHINE

MODEL 550A

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VACUUM PACKAGING MACHINES

1. SETTING UP THE MACHINE:

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

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

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

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

2. ELECTRICAL CONNECTION:

Electrical connections must be made by qualified personnel. This person must make sure that the electrical entries corresponds to the proper voltage and amperage of the machine.

All vacuum machines are supplied with an electrical schematic drawing.

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

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

3. OPERATION:

3.1 Working principles:

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

To obtain nice packages, the products and the bags have to be of proportional sizes. The bag's opening should never exceed 2" (50 cm) past the seal bar. 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.

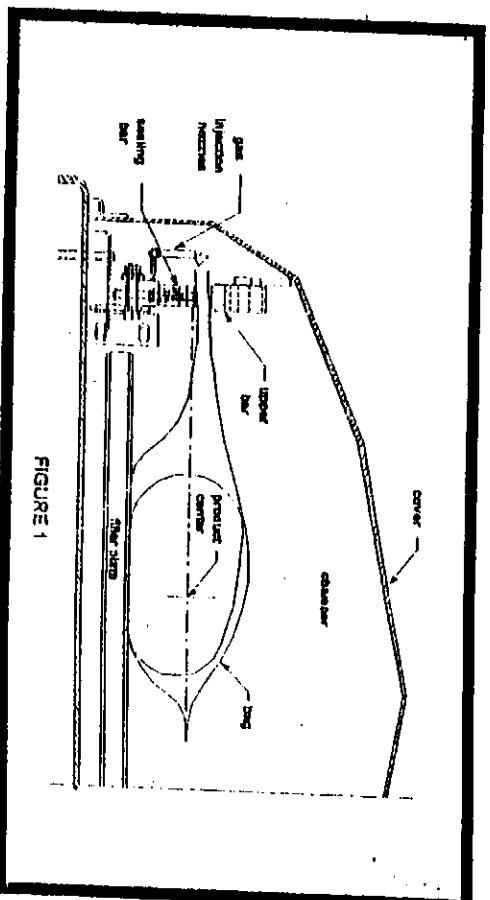


FIGURE 1

3.2 Special packaging:

3.2.1 Gas flushing (option):

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

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

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

3.2.2 Top and bottom sealing (optional):

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 (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 8 and the keyboard detail on page 9.

3.3.1 Basics:

Use key "POWER" to power ON / OFF the vacuum packaging machine. When the unit is energized, the identification of the last executed program is displayed on LCD screen.

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

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

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

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

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

3.3.2 Functions menu:

3.3.2.1 Create a program:

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

3.3.2.2 Delete a program:

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

3.3.2.3 Select operating mode:

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

3.3.3 Programs menu:

3.3.3.1 Program identification:

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

Example: EXAMPLE 1 →
(9 characters)

keys 2, 2, ENTER	→	E
keys 8, 8, 8, ENTER	→	X
keys 1, ENTER	→	A
keys 5, ENTER	→	M
keys 6, ENTER	→	P
keys 4, 4, 4, ENTER	→	L
keys 2, 2, ENTER	→	E
keys 9, 9, 9, ENTER	→	space
keys 1, 1, 1, 1, ENTER	→	↑

key ENTER to validate the characters string

3.3.3.2 Vacuum level setting:

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

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

3.3.3.3 Vacuum plus time setting:

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

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

3.3.3.4 Gas flush level setting:

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

3.3.3.5 Sealing time setting:

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

Examples:

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

3.3.4 Vacuum cycle execution:

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

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

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

3.3.5 System monitor

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

-MENUS STRUCTURE-

- Functions menu:
 - "F1 CREATE A PRGM"
 - "F2 DELETE A PRGM"
 - "F3 SELECT OPMODE" (automatic units only)

- Programs menu:
 - "Pxx NAME"

Program submenu:

"VACUUM: xx.x%"	(10.0% - 99.5%)
"VACUUM PLUS: xxs"	(0s - 99s)
(units with gas option) "GAS FLUSH: xx.x%"	(0.0% - 10% below the vacuum level)
"SEAL TIME: x.xxs"	(0.00s - maximum unit allocated setting)
"Pxx NAME"	(12 characters)

- Diagnostics menu (keys "ESC" & "POWER" for access):

"DIAGNOSTICS MENU" (access code required)

"D1 INPUTS TEST"

"D2 OUTPUTS TEST"

"D3 MODEL SELECT"

"D4 GAS OPTION"

"D5 SEALING TIME"

"D6 COOLING TIME"

"D7 LOADING TIME" (automatic units only)

"D8 UNLOADING TIME" (automatic units only)

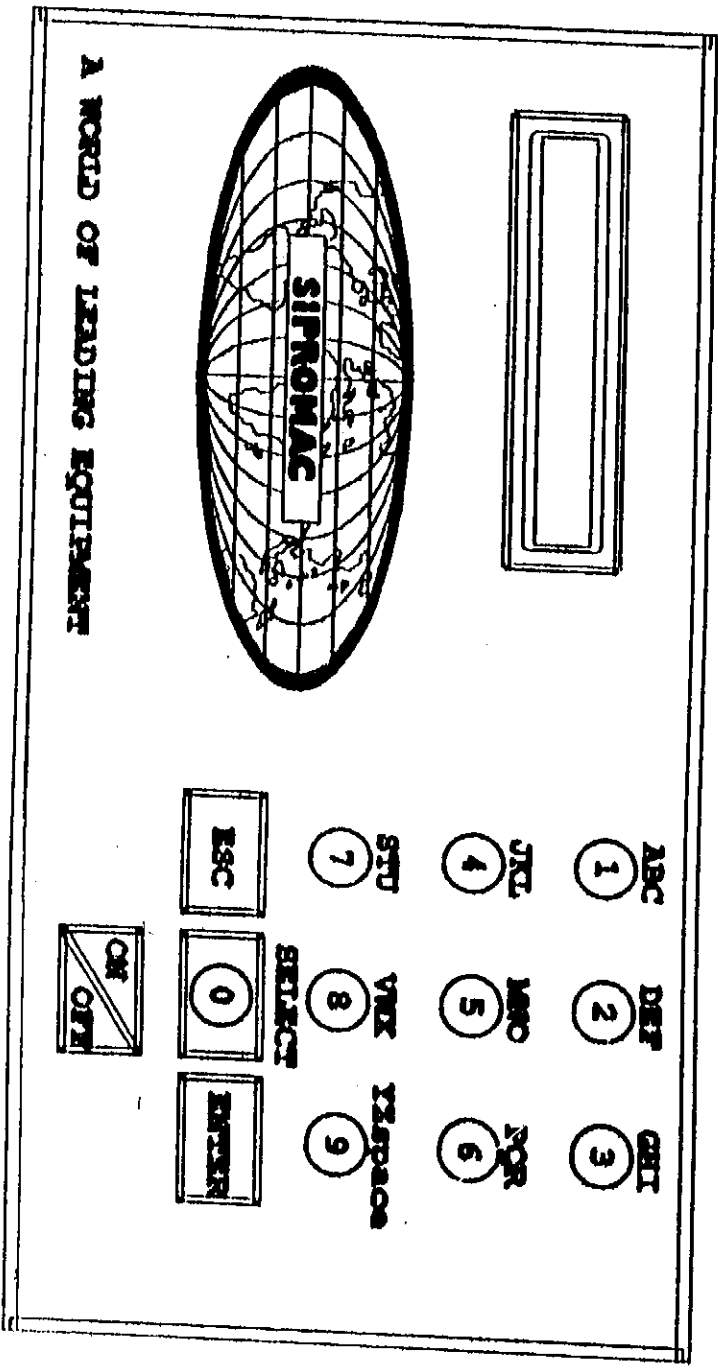
"SYSTEM MONITOR" (no access code required)

"SOFTWARE: R x.xx"

"WORK HRS: xxxxx"

"CYCLES xxxxxxx"

-KEYBOARD DETAILS-



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

3.4 Daily cleaning:

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

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "VACUUM ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

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

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

4.1.3 "ATMOSPHERE ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

The input signal of the down position switch has been lost during cycle execution.

- Check limit switch adjustment.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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

4.2.2 No leakage in the bag:

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

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

If troubles described under 4.2.1 and 4.2.2 do not apply, there is something wrong with the evacuation. To find the leakage quickly, check for leaks with a precision vacuummeter, going back step by step from the chamber to the pump.

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

Verify at vacuum hose connections and valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

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.

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 MCA0 Control board failure

NOTE: Refer to menu structure on page 8.

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

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

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

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

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

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

Check vacuum connections for tightness.

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

Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

INSTALLATION NOTICE FOR MODELS:

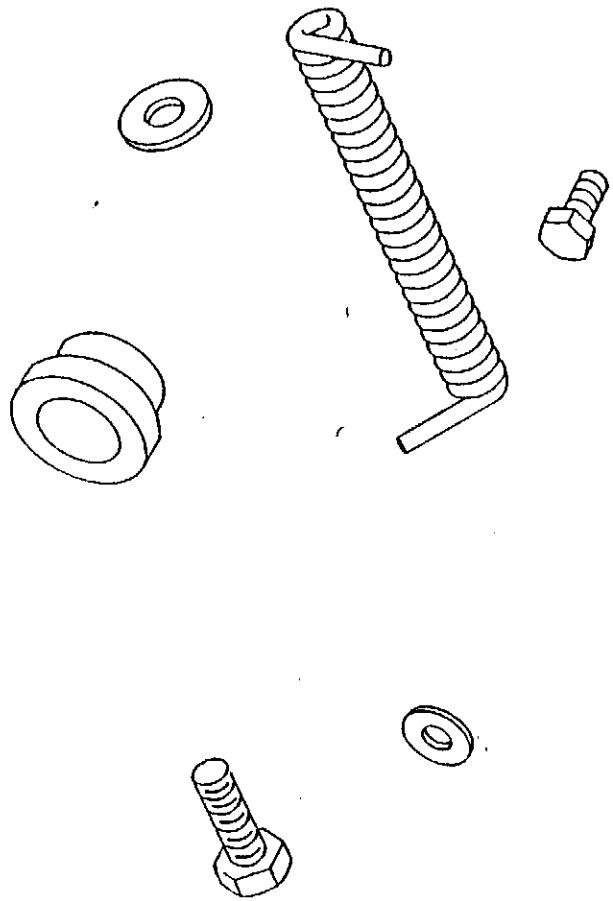
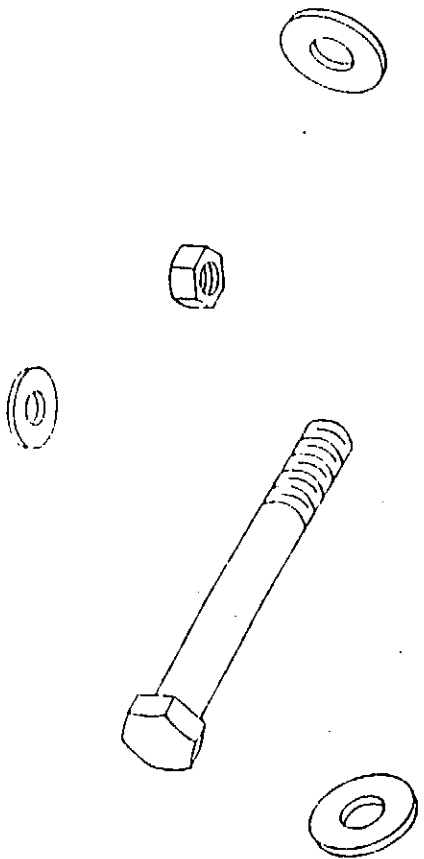
420A, 450T, 450A, 530A, 600A, 520A, 650A AND 700A

IN ORDER TO RESPECT NSF REGULATIONS:

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

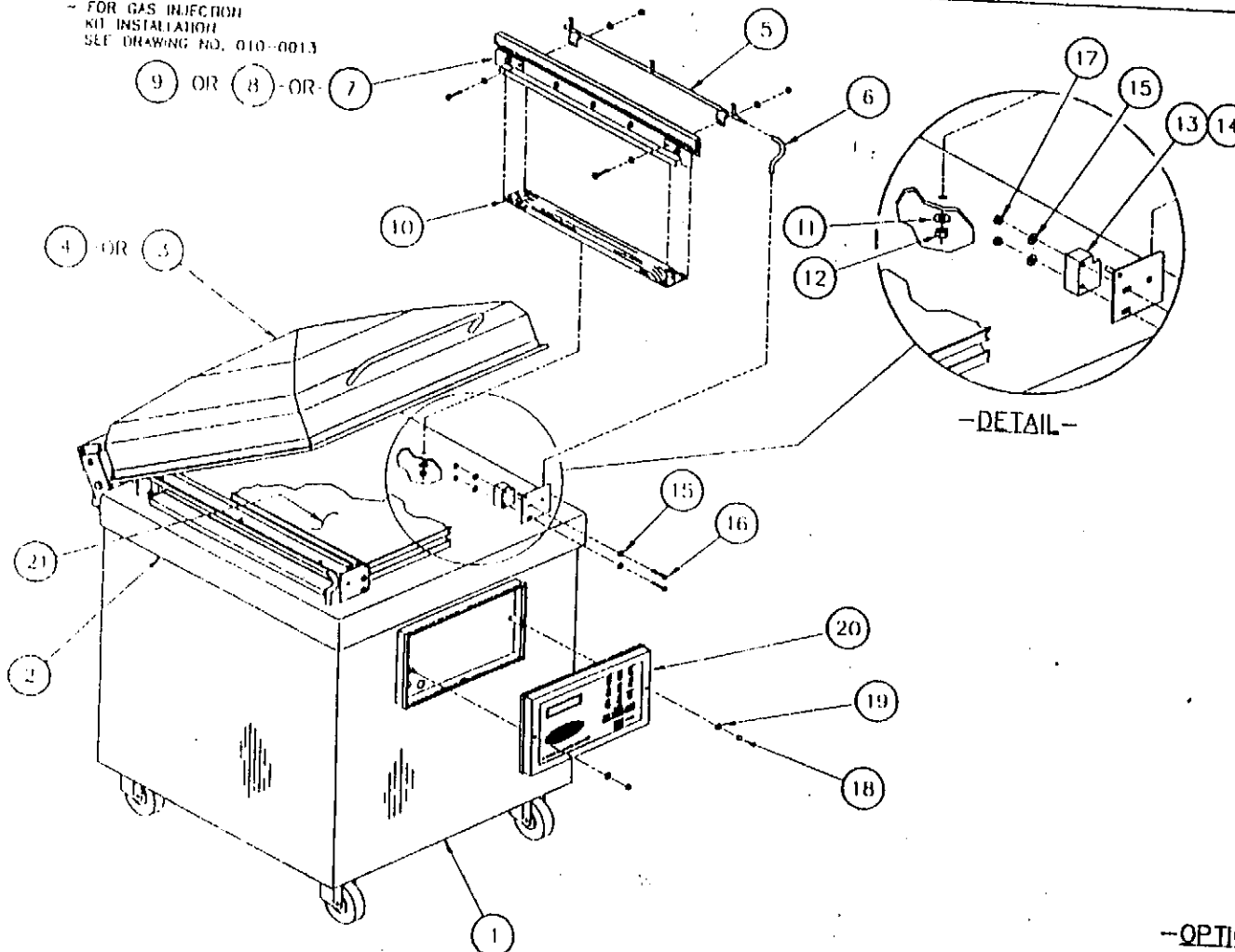


MECHANICAL DRAWING



NOTE:

FOR GAS INJECTION
KIT INSTALLATION
SEE DRAWING NO. 010-0013

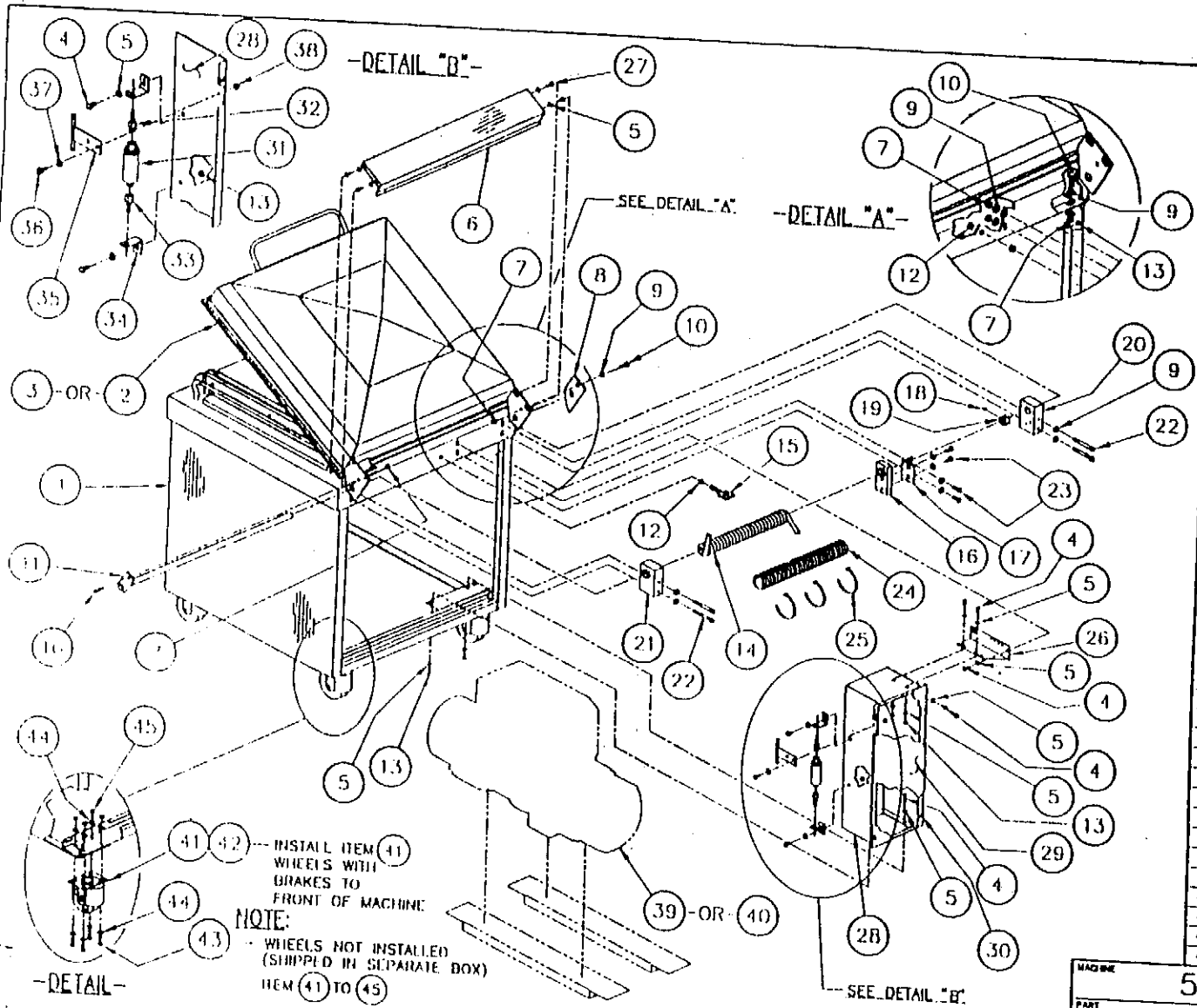


ITEM	PART #	DESCRIPTION	QTY.
1	005-0606	MC-40 STRUCTURE ASSEMBLY	1
2	005-0341	TABLE ASSEMBLY	1
3	005-0461	8" COVER ASSEMBLY	1
4	005-0482	12" COVER ASSEMBLY (OPTION)	1
5	005-0571	GAS INJECTION BAR ASS'Y (OPTION)	2
6	008-0464	GAS INJECTION CONN. TUBE (OPTION)	2
7	005-0568	SEAL BAR ASS'Y W/ SUPPORT	2
8	005-0569	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	2
9	005-0570	SEAL BAR ASS'Y W/ SUPPORT (TBS OPT.)	2
10	005-0320	BELLOWS ASSEMBLY	2
11	051-0780	FLAT WASHER 3/8" S/S	2
12	051-0620	HEX. NUT 3/8"-18 NC. S/S	2
13	002-0327	RIGHT SEAL BAR GUIDE BLOCK	2
14	002-0326	LEFT SEAL BAR GUIDE BLOCK	2
15	051-0740	FLAT WASHER 1/4" S/S	16
16	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	8
17	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	8
18	051-0591	ACORN NUT 1/4"-20 NC. S/S	2
19	052-2045	FLAT WASHER 1/4" COPPER	2
20	005-0583	P.C. BOARD SUPPORT ASSEMBLY	1
21	005-0340	FILLER PLATE ASSEMBLY	2

-OPTION MC-40-

MAKE 550A		METRIC TO FRANCE 0 1/8" = 3 1/4" = 6 3/8" = 9 1/2" = 12 5/8" = 15 3/4" = 18 1" = 25 1 1/4" = 31 1 1/2" = 38 1 3/4" = 44 2" = 50 2 1/4" = 62 2 1/2" = 63 2 3/4" = 69 3" = 76 3 1/4" = 86 3 1/2" = 89 3 3/4" = 95 4" = 101 4 1/4" = 111 4 1/2" = 113 4 3/4" = 119 5" = 127 5 1/4" = 137 5 1/2" = 139 5 3/4" = 145 6" = 152 6 1/4" = 162 6 1/2" = 165 6 3/4" = 171 7" = 178 7 1/4" = 188 7 1/2" = 191 7 3/4" = 197 8" = 203 8 1/4" = 213 8 1/2" = 215 8 3/4" = 221 9" = 228 9 1/4" = 238 9 1/2" = 241 9 3/4" = 247 10" = 254 10 1/4" = 264 10 1/2" = 266 10 3/4" = 272 11" = 281 11 1/4" = 291 11 1/2" = 294 11 3/4" = 300 12" = 305 12 1/4" = 315 12 1/2" = 318 12 3/4" = 324 13" = 330 13 1/4" = 340 13 1/2" = 343 13 3/4" = 349 14" = 354 14 1/4" = 364 14 1/2" = 367 14 3/4" = 373 15" = 381 15 1/4" = 391 15 1/2" = 394 15 3/4" = 400 16" = 406 16 1/4" = 416 16 1/2" = 419 16 3/4" = 425 17" = 432 17 1/4" = 442 17 1/2" = 445 17 3/4" = 451 18" = 457 18 1/4" = 467 18 1/2" = 470 18 3/4" = 476 19" = 483 19 1/4" = 493 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981 38 3/4" = 987 39" = 993 39 1/4" = 1003 39 1/2" = 1006 39 3/4" = 1012 40" = 1019 40 1/4" = 1029 40 1/2" = 1032 40 3/4" = 1038 41" = 1044 41 1/4" = 1054 41 1/2" = 1057 41 3/4" = 1063 42" = 1070 42 1/4" = 1080 42 1/2" = 1083 42 3/4" = 1089 43" = 1095 43 1/4" = 1105 43 1/2" = 1108 43 3/4" = 1114 44" = 1121 44 1/4" = 1131 44 1/2" = 1134 44 3/4" = 1140 45" = 1146 45 1/4" = 1156 45 1/2" = 1159 45 3/4" = 1165 46" = 1172 46 1/4" = 1182 46 1/2" = 1185 46 3/4" = 1191 47" = 1197 47 1/4" = 1207 47 1/2" = 1210 47 3/4" = 1216 48" = 1223 48 1/4" = 1233 48 1/2" = 1236 48 3/4" = 1242 49" = 1248 49 1/4" = 1258 49 1/2" = 1261 49 3/4" = 1267 50" = 1274 50 1/4" = 1284 50 1/2" = 1287 50 3/4" = 1293 51" = 1300 51 1/4" = 1310 51 1/2" = 1313 51 3/4" = 1319 52" = 1325 52 1/4" = 1335 52 1/2" = 1338 52 3/4" = 1344 53" = 1351 53 1/4" = 1361 53 1/2" = 1364 53 3/4" = 1370 54" = 1376 54 1/4" = 1386 54 1/2" = 1389 54 3/4" = 1395 55" = 1402 55 1/4" = 1412 55 1/2" = 1415 55 3/4" = 1421 56" = 1427 56 1/4" = 1437 56 1/2" = 1440 56 3/4" = 1446 57" = 1453 57 1/4" = 1463 57 1/2" = 1466 57 3/4" = 1472 58" = 1478 58 1/4" = 1488 58 1/2" = 1491 58 3/4" = 1497 59" = 1504 59 1/4" = 1514 59 1/2" = 1517 59 3/4" = 1523 60" = 1529 60 1/4" = 1539 60 1/2" = 1542 60 3/4" = 1548 61" = 1555 61 1/4" = 1565 61 1/2" = 1568 61 3/4" = 1574 62" = 1580 62 1/4" = 1590 62 1/2" = 1593 62 3/4" = 1599 63" = 1606 63 1/4" = 1616 63 1/2" = 1619 63 3/4" = 1625 64" = 1631 64 1/4" = 1641 64 1/2" = 1644 64 3/4" = 1650 65" = 1657 65 1/4" = 1667 65 1/2" = 1670 65 3/4" = 1676 66" = 1682 66 1/4" = 1692 66 1/2" = 1695 66 3/4" = 1701 67" = 1708 67 1/4" = 1718 67 1/2" = 1721 67 3/4" = 1727 68" = 1733 68 1/4" = 1743 68 1/2" = 1746 68 3/4" = 1752 69" = 1759 69 1/4" = 1769 69 1/2" = 1772 69 3/4" = 1778 70" = 1784 70 1/4" = 1794 70 1/2" = 1797 70 3/4" = 1803 71" = 1810 71 1/4" = 1820 71 1/2" = 1823 71 3/4" = 1829 72" = 1835 72 1/4" = 1845 72 1/2" = 1848 72 3/4" = 1854 73" = 1861 73 1/4" = 1871 73 1/2" = 1874 73 3/4" = 1880 74" = 1886 74 1/4" = 1896 74 1/2" = 1899 74 3/4" = 1905 75" = 1912 75 1/4" = 1922 75 1/2" = 1925 75 3/4" = 1931 76" = 1937 76 1/4" = 1947 76 1/2" = 1950 76 3/4" = 1956 77" = 1963 77 1/4" = 1973 77 1/2" = 1976 77 3/4" = 1982 78" = 1988 78 1/4" = 1998 78 1/2" = 2001 78 3/4" = 2007 79" = 2014 79 1/4" = 2024 79 1/2" = 2027 79 3/4" = 2033 80" = 2039 80 1/4" = 2049 80 1/2" = 2052 80 3/4" = 2058 81" = 2065 81 1/4" = 2075 81 1/2" = 2078 81 3/4" = 2084 82" = 2090 82 1/4" = 2100 82 1/2" = 2103 82 3/4" = 2109 83" = 2116 83 1/4" = 2126 83 1/2" = 2129 83 3/4" = 2135 84" = 2141 84 1/4" = 2151 84 1/2" = 2154 84 3/4" = 2160 85" = 2167 85 1/4" = 2177 85 1/2" = 2180 85 3/4" = 2186 86" = 2192 86 1/4" = 2202 86 1/2" = 2205 86 3/4" = 2211 87" = 2218 87 1/4" = 2228 87 1/2" = 2231 87 3/4" = 2237 88" = 2243 88 1/4" = 2253 88 1/2" = 2256 88 3/4" = 2262 89" = 2269 89 1/4" = 2279 89 1/2" = 2282 89 3/4" = 2288 90" = 2294 90 1/4" = 2304 90 1/2" = 2307 90 3/4" = 2313 91" = 2320 91 1/4" = 2330 91 1/2" = 2333 91 3/4" = 2339 92" = 2345 92 1/4" = 2355 92 1/2" = 2358 92 3/4" = 2364 93" = 2371 93 1/4" = 2381 93 1/2" = 2384 93 3/4" = 2390 94" = 2396 94 1/4" = 2406 94 1/2" = 2409 94 3/4" = 2415 95" = 2422 95 1/4" = 2432 95 1/2" = 2435 95 3/4" = 2441 96" = 2447 96 1/4" = 2457 96 1/2" = 2460 96 3/4" = 2466 97" = 2473 97 1/4" = 2483 97 1/2" = 2486 97 3/4" = 2492 98" = 2498 98 1/4" = 2508 98 1/2" = 2511 98 3/4" = 2517 99" = 2524 99 1/4" = 2534 99 1/2" = 2537 99 3/4" = 2543 100" = 2549 	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART 550A MC-40 FRONT VIEW	ITEM: _____ DATE: _____ APP: _____	SCALE: _____ QTY: 1 NO: 005-0605	

005-0605



ITEM	PART #	DESCRIPTION	QT.
1	005-0608	550A MC-40 FRONT VIEW	1
2	005-0461	B' COVER ASSEMBLY	1
3	005-0462	12" COVER ASSEMBLY (OPTION)	1
4	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	11
5	051-0740	FLAT WASHER 1/4" S/S	18
6	004-0171	SPRING COVER PRE-ASSEMBLY	1
7	051-0820	HEX. NUT 3/8"-18 NC. S/S	12
8	001-1335	COVER STOPPER	1
9	051-0783	FLAT WASHER 3/8" (THICK) S/S	23
10	051-0360	HEX. BOLT 3/8"-18 NC. X 1" S/S	10
11	004-0128	COVER AXIS PRE-ASSEMBLY	1
12	051-0830	HEX. NUT 1/2"-13 NC. S/S	2
13	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	7
14	008-0322	COVER SPRING	1
15	005-0316	SPRING TENSION SUPPORT PRE-ASSY	1
16	004-0276	CENTRAL COVER AXIS SUPPORT	1
17	001-1540	CENTRAL COVER AXIS SUPPORT FIXATION	1
18	051-0178	SET SCREW 1/4"-20 NC. X 5/16" S/S	1
19	005-0348	MICRO-SWITCH COLLAR	1
20	004-0274	LEFT COVER AXIS SUPPORT	1
21	004-0275	RIGHT COVER AXIS SUPPORT	1
22	051-0424	HEX. BOLT 3/8"-18 NC. X 3 1/2" S/S	4
23	051-0380	HEX. BOLT 3/8"-18 NC. X 1" S/S	4
24	038-0350	SLIT COORUG LOOM 2" ID X 370 MM	1
25	057-0330	CABLE TIES 14" LONG BLACK	3
26	001-1384	RIGHT/ELECTRICAL BOX UPPER SUPPORT	1
27	051-0192	BOLT 1/4"-20 NC. X 3/4" PAN PHIL. S/S	4
28	005-0347	ELECTRICAL BOX ASSEMBLY	1
29	004-0273	ELECTRICAL BOX COVER ASSEMBLY	1
30	058-0020	SPRING NUT 1/4"-20 NC. STEEL	1
31	114-2020	DRYER FILTER	1
32	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
33	101-0210	STRAIGHT 1/4" FNPT X 1/4" HOSE	1
34	001-2082	DRYER SUPPORT	2
35	005-0323	GAS INLET ASSEMBLY (OPTION)	1
36	051-0180	HEX BOLT 1/4"-20NC X 1/2" S/S (OPTION)	1
37	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
38	051-0581	HEX NUT 1/4"-20NC NYLON LOCK S/S (OPTION)	1
39	004-0271	"BUSCIF" PUMPS INSTALLATION	1
40	004-0272	"LEYBOLD" PUMPS INSTALLATION	1
41	130-4PHB	4" PL. CASTER SWIVEL W/ BRAKE	2
42	130-4PHK	4" PL. CASTER SWIVEL W/D BRAKE	2
43	052-0520	BOAT 5/16"-18 NC. X 3/4" ZINC	18
44	051-0780	FLAT WASHER 3/16" S/S	32
45	052-3110	HEX. NUT 5/16"-18 NC. ZINC	18

NOTE:
 - WHEELS NOT INSTALLED (SHIPPED IN SEPARATE BOX)
 ITEM (41) TO (45)

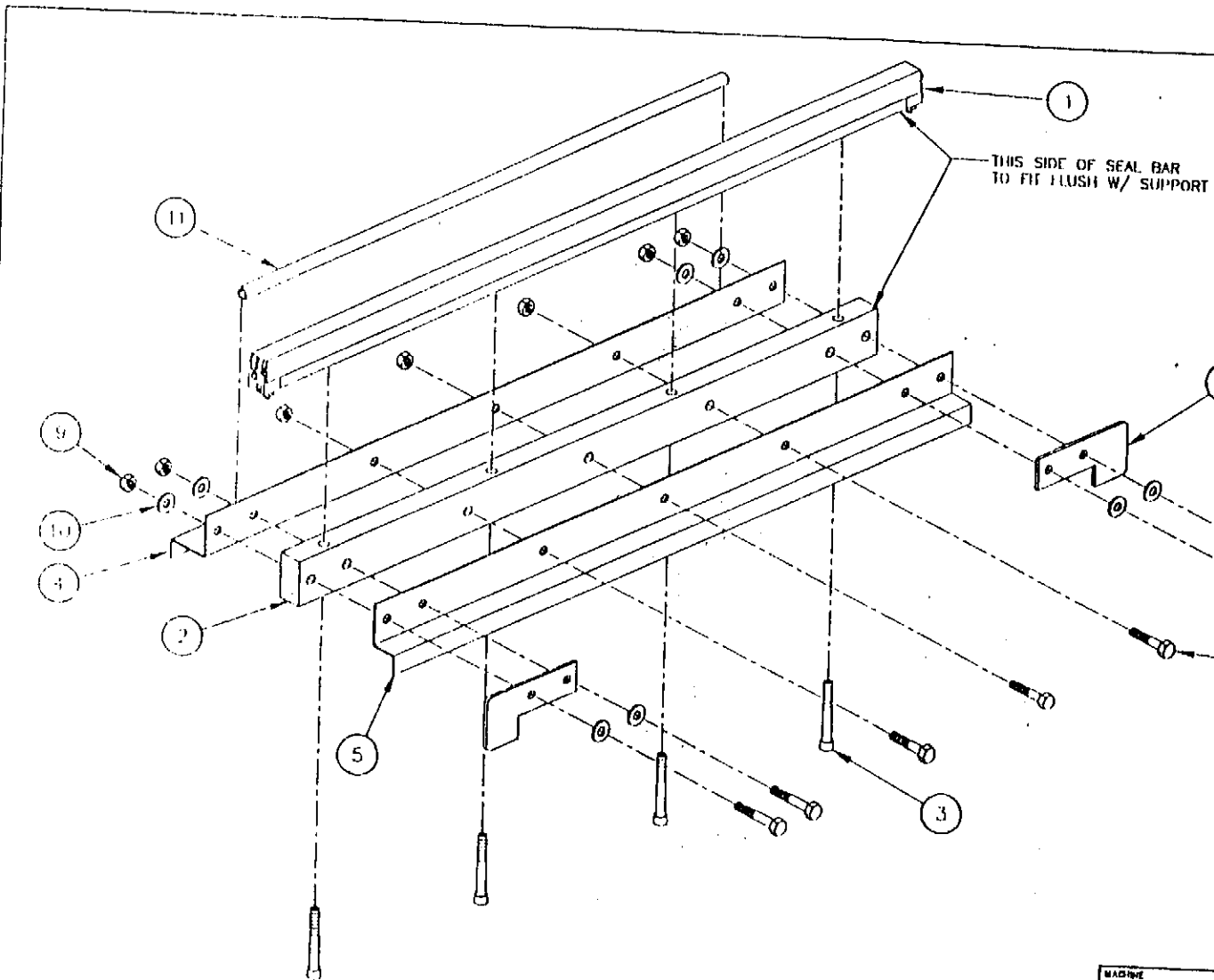
MACHINE: 550A
 PART: 550A MC-40 REAR VIEW
 ITEM: _____
 DATE: _____

METRIC TOLERANCE: 0.005
 INCH TOLERANCE: 0.0005
 N.T.S.

SCALE: _____
 QTY: 1
 005-0608

ST-GERMAIN DE GRANTHAM
 QUEBEC CANADA

005-0608



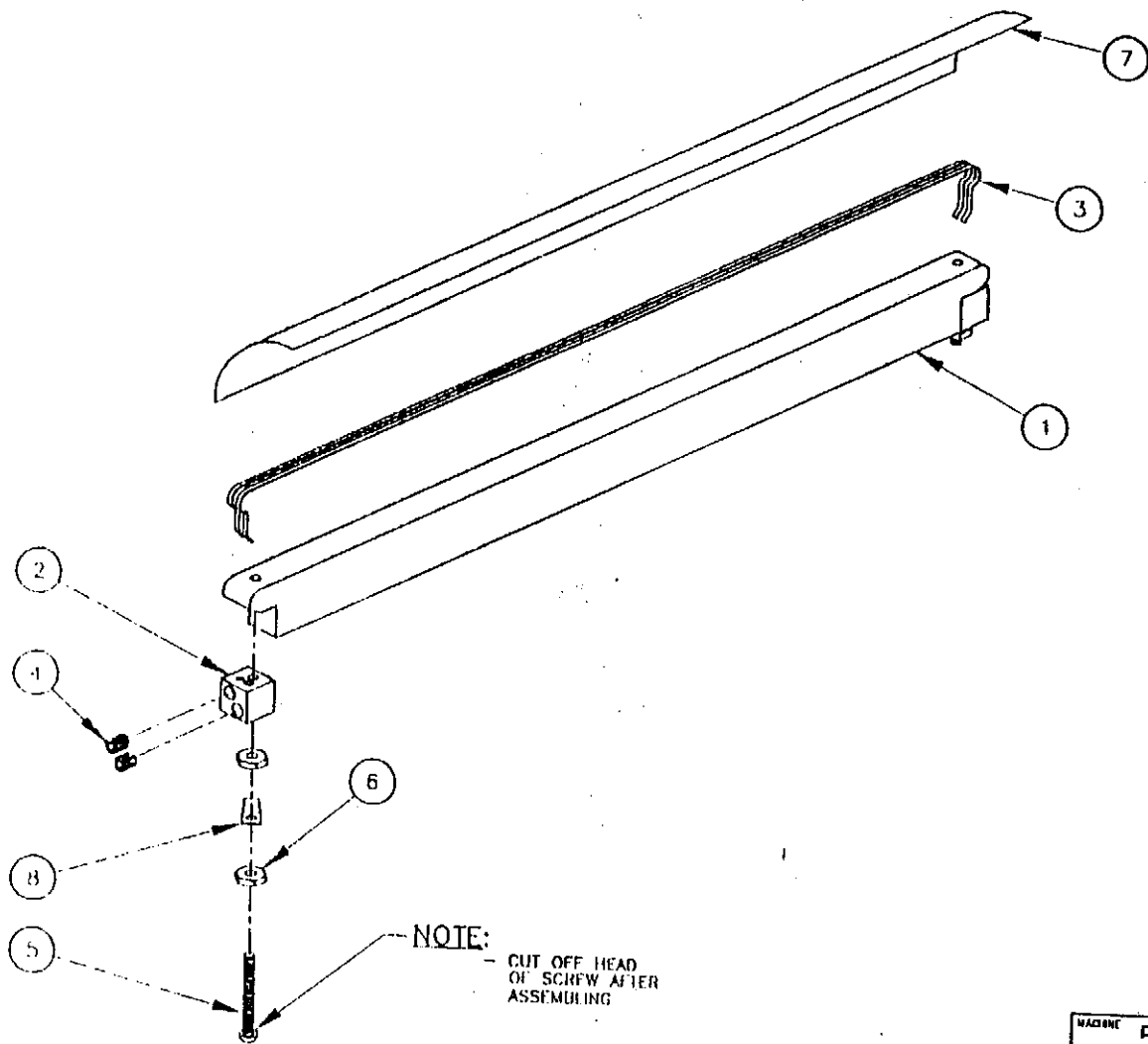
ITEM	PART #	DESCRIPTION	QTY.
1	005-0152	SEAL BAR PRE-ASSEMBLY	1
2	002-0514	SEAL BAR SUPPORT (TABLE)	1
3	051-0261	CAP HEX. SKT. BOLT 1/4"-20 NC X 2" S/S	4
4	001-1962	EXTERIOR BELLOWS COVER	1
5	001-1963	INTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	4
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	3
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	7
10	051-0740	FLAT WASHER 1/4" S/S	8
11	038-0230	WRING GUCT W/ ADHESIVE BACKING (0.15" X 0.5" X 176) PVC	1

NOTE:
QTY FOR ONE
SEAL BAR ONLY
SEE LIST

1005-0568

ESCA ADDED/ WAS 005-0151/ MODIF. NO. A: 0241	08-02-24	A.P.
REDRAWN/ WAS 005-0151/ MODIF. NO. A: 0279	07-10-24	A.P.
M. CHIRKACHEN	DATE	INIT.

MACHINE	550A & 600A	METRIC TOLERANCE	INCH TOLERANCE	600A	4
PART	SEAL BAR ASSEMBLY W/ SUPPORT	0.005 & 0.010	0.0005 & 0.0010	550A	2
ITEM:		0.002 & 0.003	0.0002 & 0.0003	MACHINE	QTY
MAN:		ANGLE & 1'	N.T.S.	SIPROMAC	
				ST-GERMAIN DE GRANTHAM	
				QUEBEC CANADA	
				SCALE	SEE LIST
				DATE 07-10-24	
				NO	005-0568



ITEM	PART #	DESCRIPTION	QTY
1	002-0314	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEMENT	2
4	052-0395	SCREW 1/8"-20 NC. X 5/16" SET HEX SKT OVAL PT	4
5	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
6	051-0550	NUT #8-32 S/S	4
7	178-0200	TEFLON TAPE 55 ADHESIVE X 2" X 650 MM	1
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2

NOTE:
- QTY FOR ONE SEAL BAR ONLY
SEE LIST

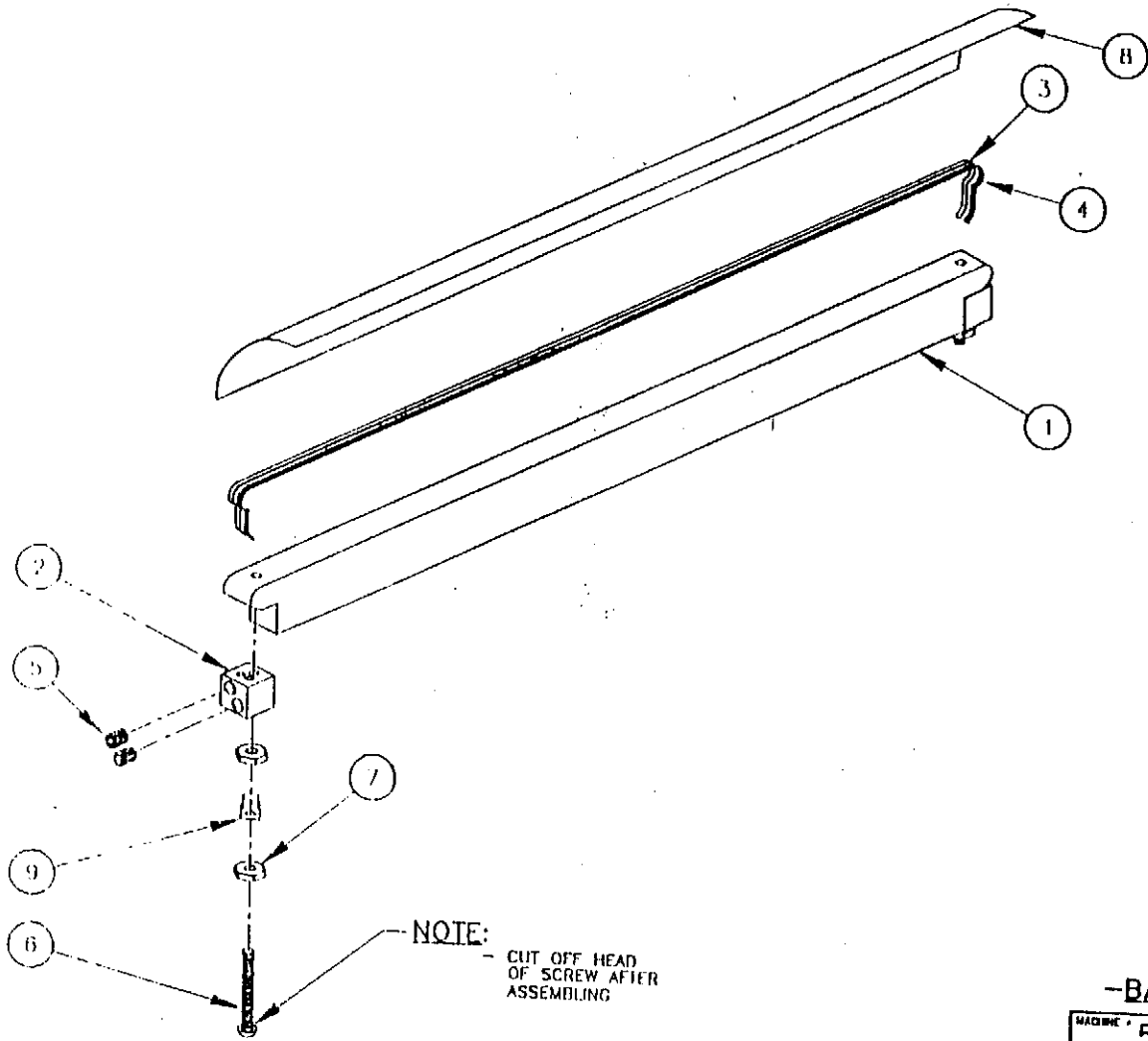
NOTE:
- CUT OFF HEAD OF SCREW AFTER ASSEMBLING

600A	4
550A	2
MACHINE	QTY

MACHINE	550A & 600A	METRIC TOLERANCE	ISO TOLERANCE	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	SEAL BAR PRE-ASSEMBLY	Metric: .0005, .001, .002, .005, .01, .02, .05, .1, .2, .5, 1, 2, 5, 10, 20, 50, 100	ISO: .0005, .001, .002, .005, .01, .02, .05, .1, .2, .5, 1, 2, 5, 10, 20, 50, 100	
ITEM:		UNIT:	N.T.S.	
DATE:		SCALE:		QTY: SEE LIST
		REV: 98-02-10		NO: 005-0152

REDRAWN
DATE: 98-02-10
A.P.
REV: 111

1005-0152



ITEM	PART #	DESCRIPTION	QTY.
1	002-0314	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	2
3	039-0230	CONVEX SEALING ELEMENT	1
4	039-0270	"T" PROFILE CUTTING ELEMENT	1
5	052-0395	SCREW 1/4" -20 HC. X 5/16" SET HEX SKT OVAL PT	4
6	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
7	051-0550	NUT #8-32 S/S	4
8	176-0200	TEFLON TAPE 55 ADHESIVE X 2" X 650 MM	1
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2

NOTE:
- QTY FOR ONE SEAL BAR ONLY
SEE LIST

NOTE:
- CUT OFF HEAD OF SCREW AFTER ASSEMBLING

-BAG CUT OPTION-

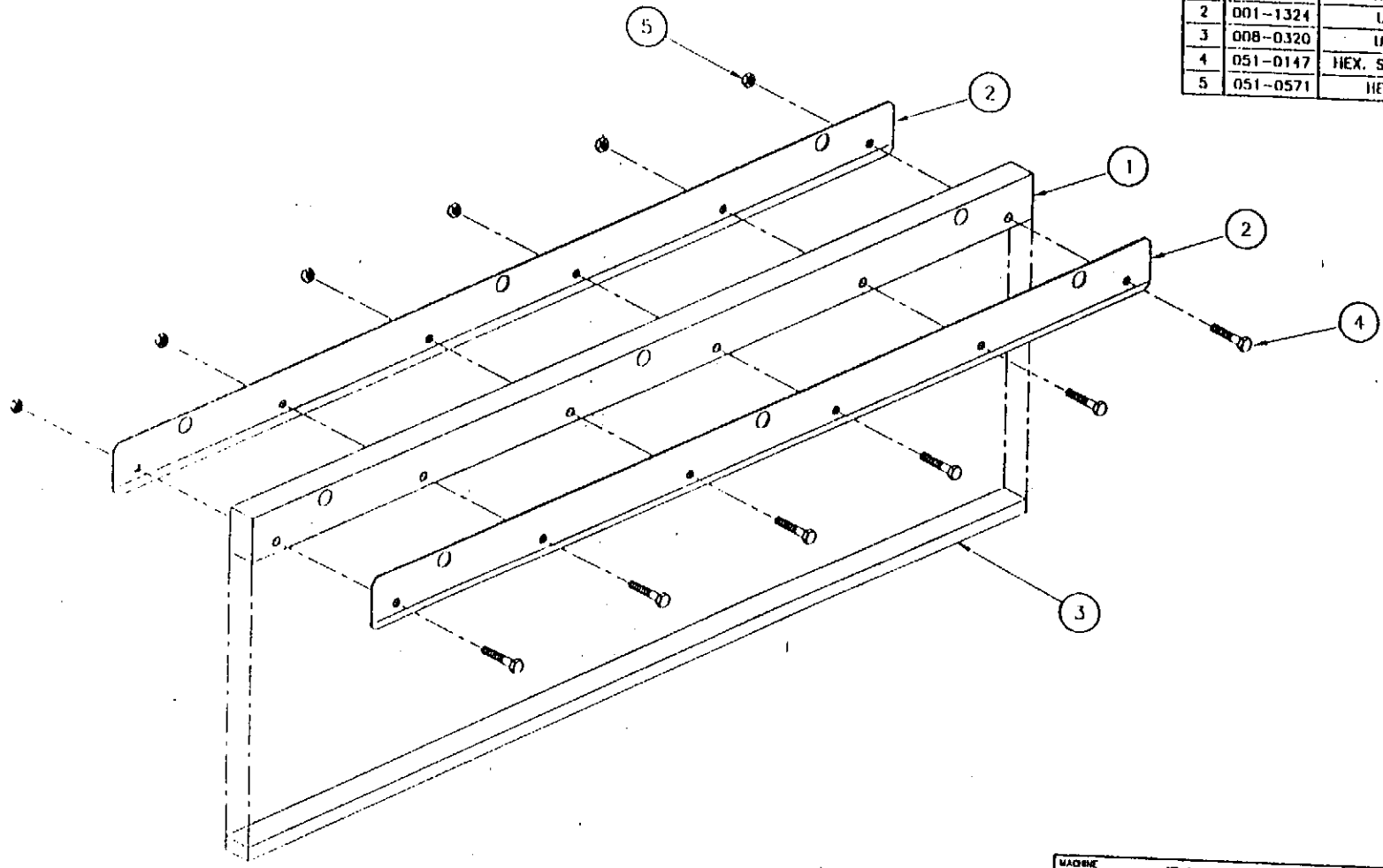
600A	4
550A	2
MACHINE	QTY

MACHINE	550A & 600A	METRIC TOLERANCE	ISO	ST-GERMAIN DE GRANBY
PART	SEAL BAR PRE-ASSEMBLY	INCH TOLERANCE	N.T.S.	QUEBEC CANADA
ITEM		DATE	98-02-10	SCALE
MAT		DATE	98-02-10	QTY
				SEE LIST
				005-0153

D	REDRAWN	98-02-10	A.P.
LL	MODIFICATION	DATE	INI

1005-0153

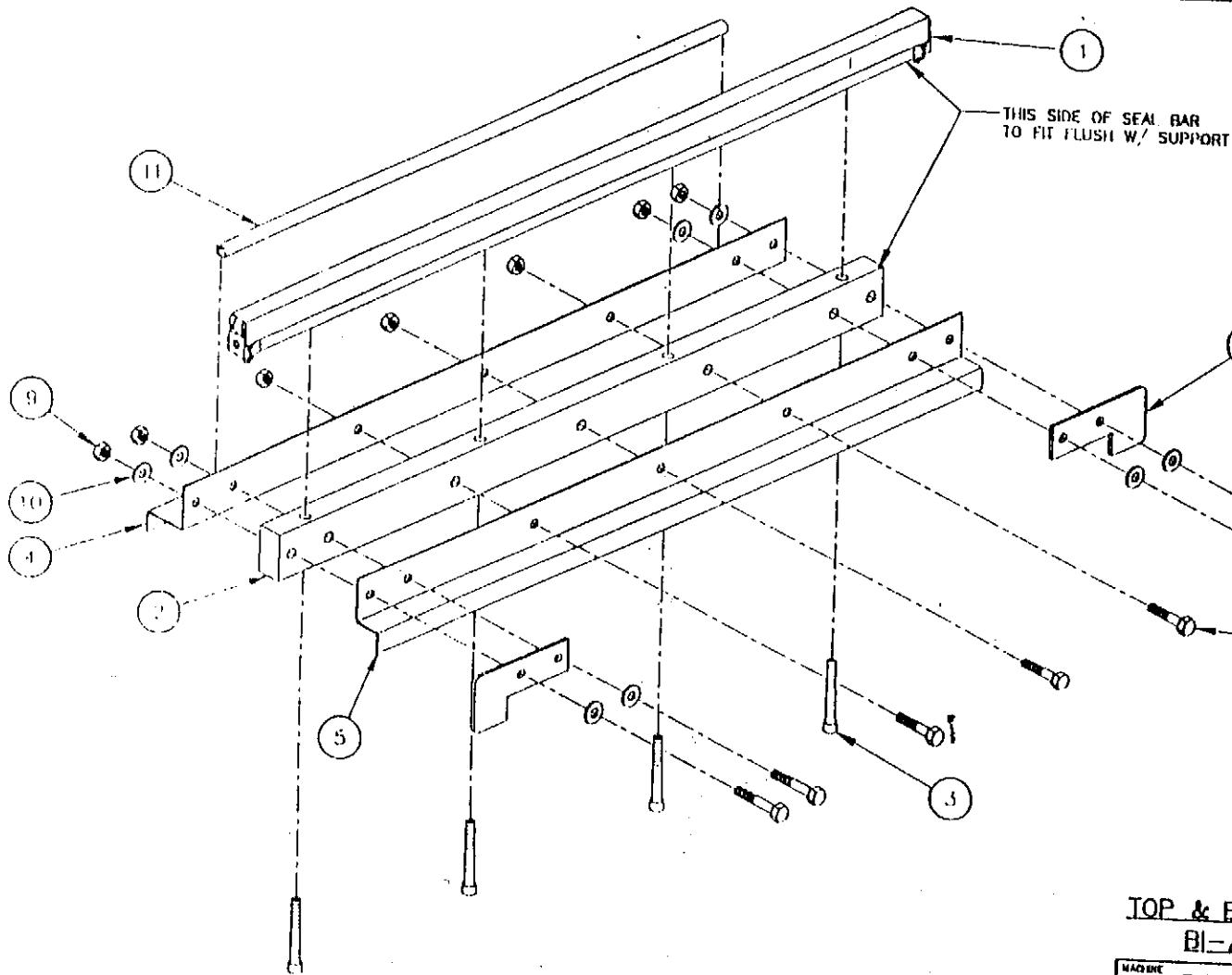
ITEM	PART #	DESCRIPTION	QT.
1	002-0404	UPPER SEAL BAR SUPPORT	2
2	001-1324	UPPER RUBBER SUPPORT	4
3	008-0320	UPPER SEAL BAR RUBBER	2
4	051-0147	HEX. SCREW #10-24 NC. X 1" S/S	12
5	051-0571	HEX. NUT #10-24 NC. S/S	12



REFORMA/ MODIF. NO. 1 0110
 MIX-ICABRY
 08-02-26
 DAN
 A.D.
 BIL.

MADE IN CANADA
550A
 PART UPPER SEAL BAR ASSEMBLY
 ITEM: _____
 MAT. _____
 METRIC TO INCHES
 1/8" = 3.175
 1/4" = 6.350
 3/8" = 9.525
 1/2" = 12.700
 5/8" = 15.875
 3/4" = 19.050
 INCH TO METRIC
 1" = 25.4
 2" = 50.8
 3" = 76.2
 4" = 101.6
 5" = 127.0
 6" = 152.4
 8" = 203.2
 10" = 254.0
 12" = 304.8
 N.T.S.
SIPROMAC
 ST-CERMAN DE GRAHNIAN
 QUEBEC CANADA
 SCALE _____
 QTY. 2
 DATE 08-02-26
 NO. 004-0132
 BY A. PROMMNER
 APP.

1004-0132



ITEM	PART #	DESCRIPTION	QTY.
1	005-0370	T&B SEAL BAR PRE-ASSEMBLY	1
2	002-0514	SEAL BAR SUPPORT (TABLE)	1
3	051-0261	CAP HEX. SKT. BOLT 1/4"-20 NC X 2" S/S	4
4	001-1962	EXTERIOR BELLOWS COVER	1
5	001-1963	INTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	4
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	3
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	7
10	051-0740	FLAT WASHER 1/4" S/S	8
11	03B-0230	WING DUCT W/ ADHESM. BACKING (0.35" X 0.5" X 176) PVC	1

NOTE:
QTY FOR ONE
SEAL BAR ONLY
SEE LIST

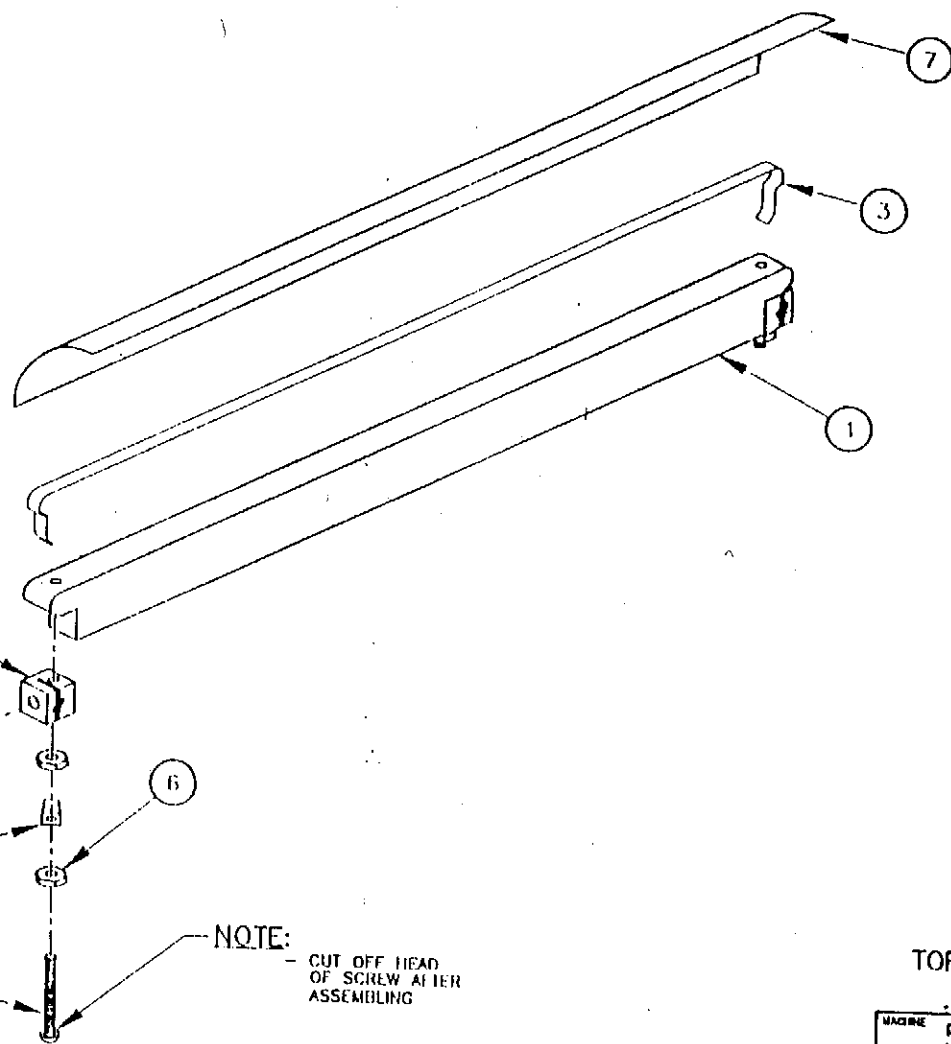
-OPTION-
TOP & BOTTOM SEALING OR
BI-ACTIVE SEALING

600A	4
550A	2
MACHINE	QTY

MACHINE	550A & 600A	METRIC TOLERANCE	± .15	SI-METRIC TOLERANCE	± .015	SCALE	SEE LIST
PART	SEAL BAR ASSEMBLY W/ SUPPORT	± .005	± .005	± .005	± .005	DATE	97-10-24
ITEM		± .005	± .005	± .005	± .005	NO.	005-0570
DATE		± .005	± .005	± .005	± .005	DATE	
APP.	ST. A. PROVINCER	DATE	97-10-24	NO.			

550A ADDED / MODIF. NO. A-0241
DATE 98-02-24 A.P.
MACHINE

1005-0570



ITEM	PART #	DESCRIPTION	QTY.
1	002-0314	SEAL BAR (TABLE)	1
2	009-0029	CONNECTOR	2
3	039-0220	SEALING ELEMENT	1
4	052-0395	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	2
5	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
6	051-0550	NUT #8-32 S/S	4
7	178-0200	TEFLON TAPE 55 ADHESIVE X 2" X 650 MM	1
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2

NOTE:
- QTY FOR ONE SEAL BAR ONLY
SEE LIST

NOTE:
- CUT OFF HEAD OF SCREW AFTER ASSEMBLING

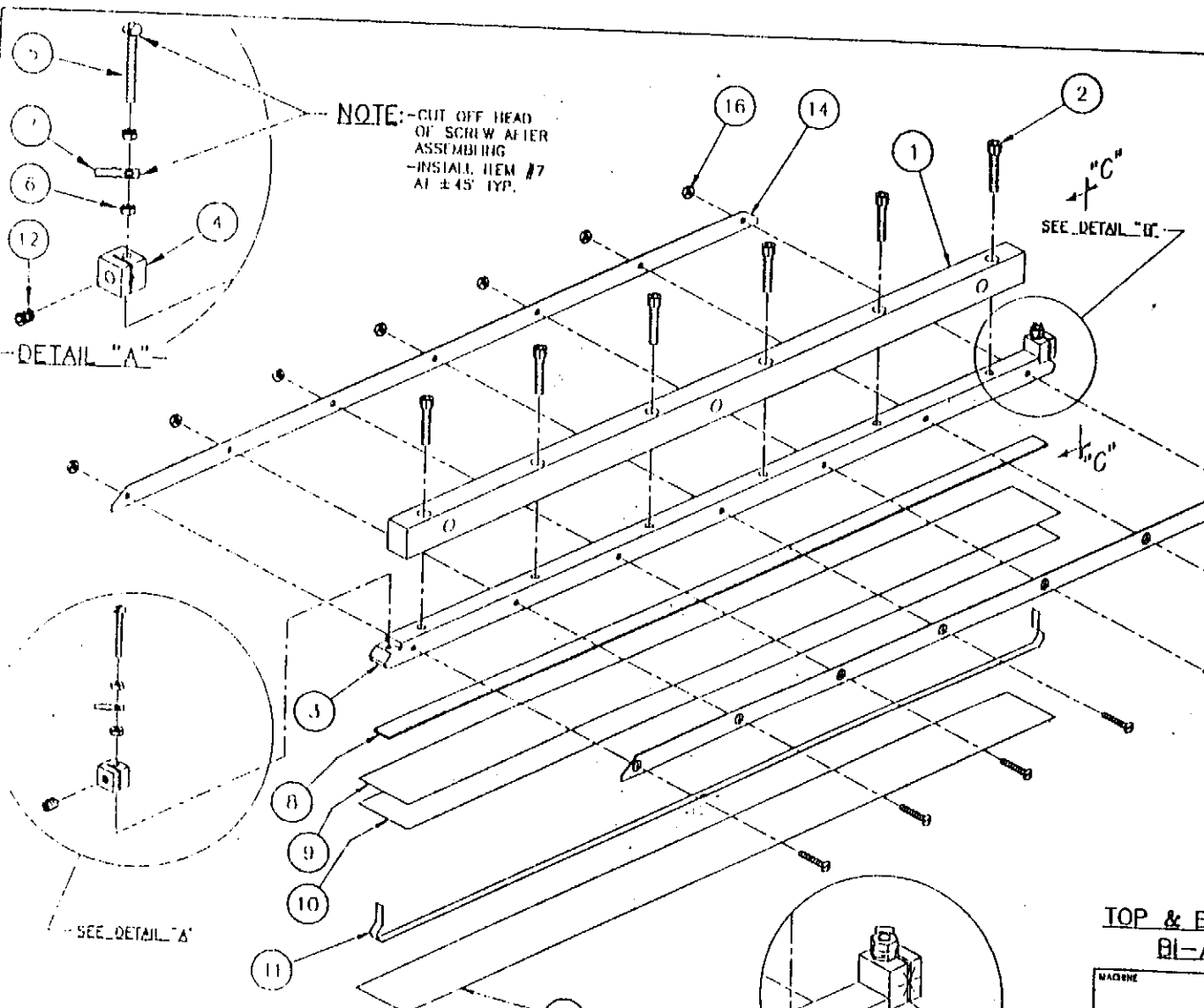
-OPTION-
TOP AND BOTTOM SEALING OR
BI-ACTIVE SEALING

800A	4
550A	2
MACHINE	QTY

MACHINE	550A & 600A	METRIC TOLERANCE	INCH TO FRANCE	ST-GERMAIN DE GRANBY
PART	SEAL BAR PRE-ASSEMBLY	0.0005	0.0005	QUEBEC CANADA
ITEM:		0.0005	0.0005	N.T.S.
DATE	08-02-10			
BY				
SCALE				QTY SEE LIST
				005-0370

REVISION	08-02-10	A.P.
DATE		REV.

1005-0370



NOTE: - CUT OFF HEAD OF SCREW AFTER ASSEMBLING
 - INSTALL ITEM #7 AT ±45° TYP.

ITEM	PART #	DESCRIPTION	QT.
1	002-0537	UPPER SEAL BAR SUPPORT	2
2	051-0232	SCREW 1/4"-20 NC. X 1 1/4" CAP HEX. SKT S/S	12
3	002-0538	UPPER SEAL BAR	2
4	009-0029	TOP & BOTTOM SEAL CONNECTOR WELDED	4
5	052-0250	SCREW #8-32 NC. X 1 1/2" RND SLOT BRASS	4
6	051-0550	HEX. NUT #8-32 NC. S/S	8
7	027-0400	CONNECTOR ADAPTOR	4
8	178-0003	UPPER SEAL BAR RUBBER	2
9	176-0200	TEFLON TAPE (55) ADHESIVE	2
10	176-0220	TEFLON TAPE (10S) ADHESIVE	2
11	039-0220	SEALING ELEMENT	2
12	052-0395	SET SCREW 1/4"-20 NC. X 5/16" (OVAL POINT)	4
13	176-0220	TEFLON TAPE (10S) ADHESIVE	2
14	001A1386	UPPER TEFLON HOLDER	4
15	051-0121	SCREW #8-32 NC. X 1" FLAT PHILL. S/S	14
16	051-0550	HEX. NUT #8-32 NC. S/S	14

THIS SIDE OF SEAL BAR TO FIT FLUSH W/ SUPPORT

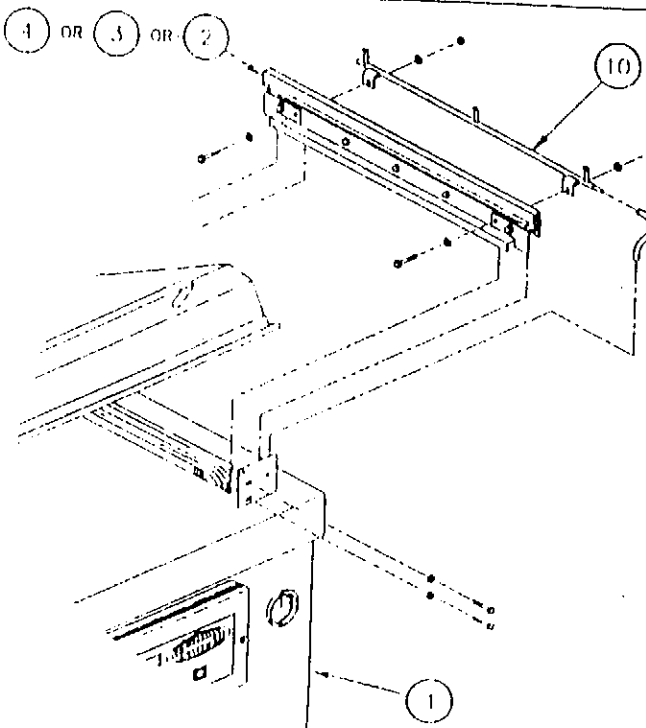
-VIEW "C-C"-
 (END VIEW ASSEMBLY)

-OPTION-
 TOP & BOTTOM SEALING OR
 BI-ACTIVE SEALING

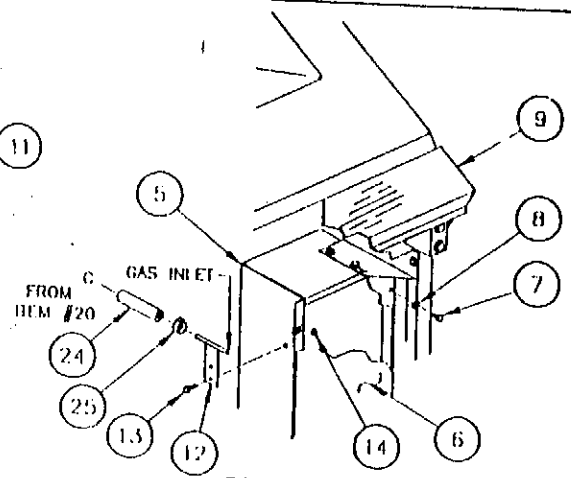
MACHINE		550A		METRIC TO INCHANCE 0 1/8 0 1/16 0 3/32 0 1/4 0 5/16 0 3/8 0 7/16 0 1/2 0 5/8 0 3/4 0 7/8 1	INCH TO METRIC 3/16 1/4 5/16 3/8 7/16 1/2 5/8 3/4 7/8 1	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		UPPER SEAL BAR ASS'Y W/ SUPPORT		N.T.S.		
ITEM:	CNC:	DATE:	08-04-07	SCALE:	QT. 2	
MAN:	DATE:	DATE:	08-04-07	NO.:	005A0371	

REV. RAN/ RAN ALSO (04-0163)
 MODIFIED BY
 98-04-07
 DATE
 A.P.
 BY

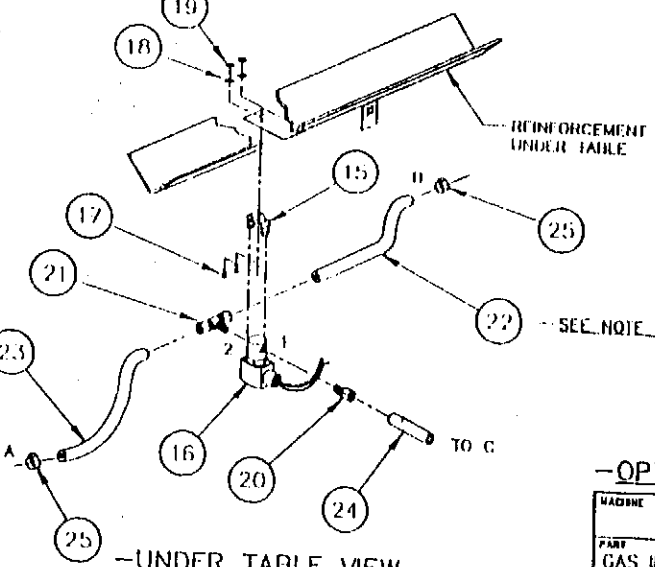
1005A0371



-GAS INJECTION BAR INSTALLATION-
-FRONT VIEW-



-REAR VIEW-
-VALVE INSTALLATION-



-UNDER TABLE VIEW-
-VALVE INSTALLATION-

NOTE 1:
THESE ITEMS
MUST BE THE
SAME LENGTH

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

ITEM	PART #	DESCRIPTION	QTY
1	005-0338	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0568	SEAL BAR ASSY W/ SUPPORT	2
3	005-0569	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPT.)	2
4	005-0570	SEAL BAR ASSY W/ SUPPORT (T & B OPT.)	2
5	005-0347	ELECTRICAL BOX ASSEMBLY	1
6	004-0273	ELECTRICAL BOX COVER PRE-ASSY	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4" S/S	4
9	005-0339	MACHINE ASSEMBLY REAR VIEW	1
10	005-0571	GAS INJECTION BAR ASSEMBLY (OPTION)	2
11	008-0464	GAS INJECTION CONN. TUBE (OPTION)	2
12	005-0323	GAS INLET ASSEMBLY	1
13	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
14	051-0580	HEX. NUT 1/4"-20 NC. S/S (OPTION)	1
15	106-0345	VALVE SUPPORT FOR 1/4" NPT	1
16	106-0010	SELENOIDE VALVE 2 WAY 1/4" NPT	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	101-0065	"F" 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 IG.	4
23	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm IG.	2
24	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm IG.	1
25	105-0200	COLLARS 3/8"	3

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

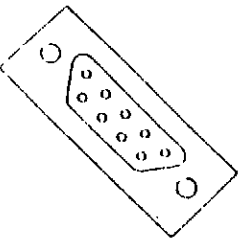
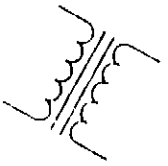
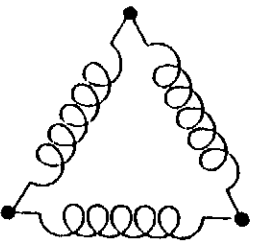
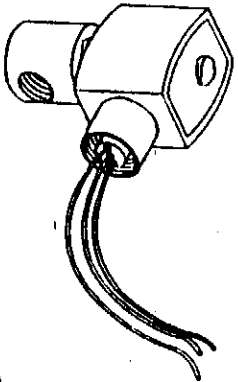
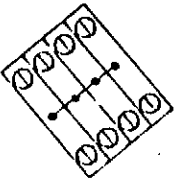
-OPTION GAS INJECTION-

MACHINE	550A	METRIC TOLERANCE	MM TO 0.05	MM TO 0.10	MM TO 0.15	MM TO 0.20	MM TO 0.25	MM TO 0.30	MM TO 0.35	MM TO 0.40	MM TO 0.45	MM TO 0.50	MM TO 0.55	MM TO 0.60	MM TO 0.65	MM TO 0.70	MM TO 0.75	MM TO 0.80	MM TO 0.85	MM TO 0.90	MM TO 0.95	MM TO 1.00	MM TO 1.05	MM TO 1.10	MM TO 1.15	MM TO 1.20	MM TO 1.25	MM TO 1.30	MM TO 1.35	MM TO 1.40	MM TO 1.45	MM TO 1.50	MM TO 1.55	MM TO 1.60	MM TO 1.65	MM TO 1.70	MM TO 1.75	MM TO 1.80	MM TO 1.85	MM TO 1.90	MM TO 1.95	MM TO 2.00
PART	GAS INJECTION KIT INSTALLATION	IND. REFERENCE	N.T.S.																																							
ITEM:		SCALE	1																																							
MAT:		DATE	08-02-26																																							
DRAWN BY: A. PROVINCER		DATE	08-02-26																																							
NO. 010-0013																																										

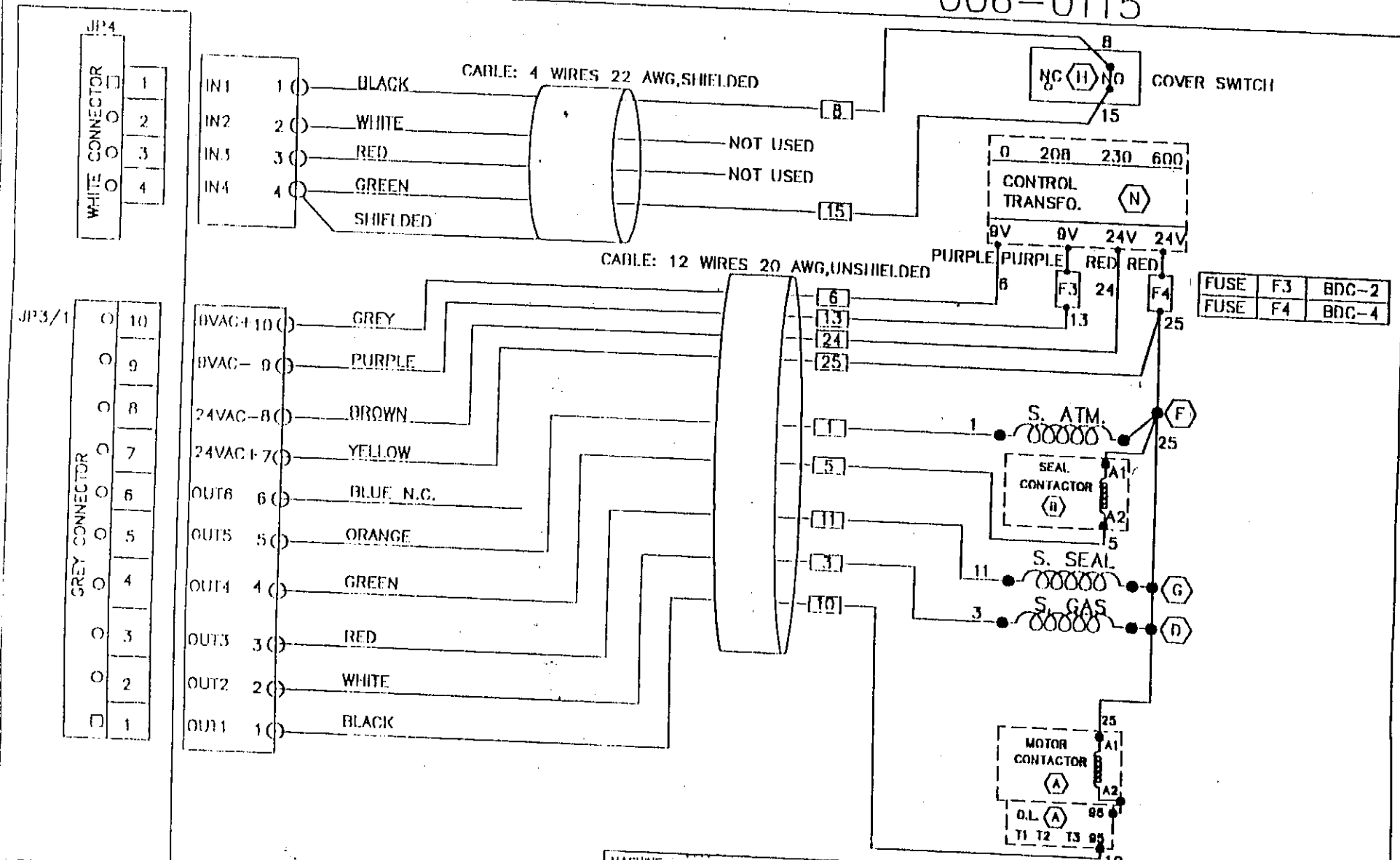
REDRAWN/ MOD. NO. A-0241
DATE: 08-02-26
A.P. INT.

1010-0013

ELECTRICAL DRAWING



006-0115

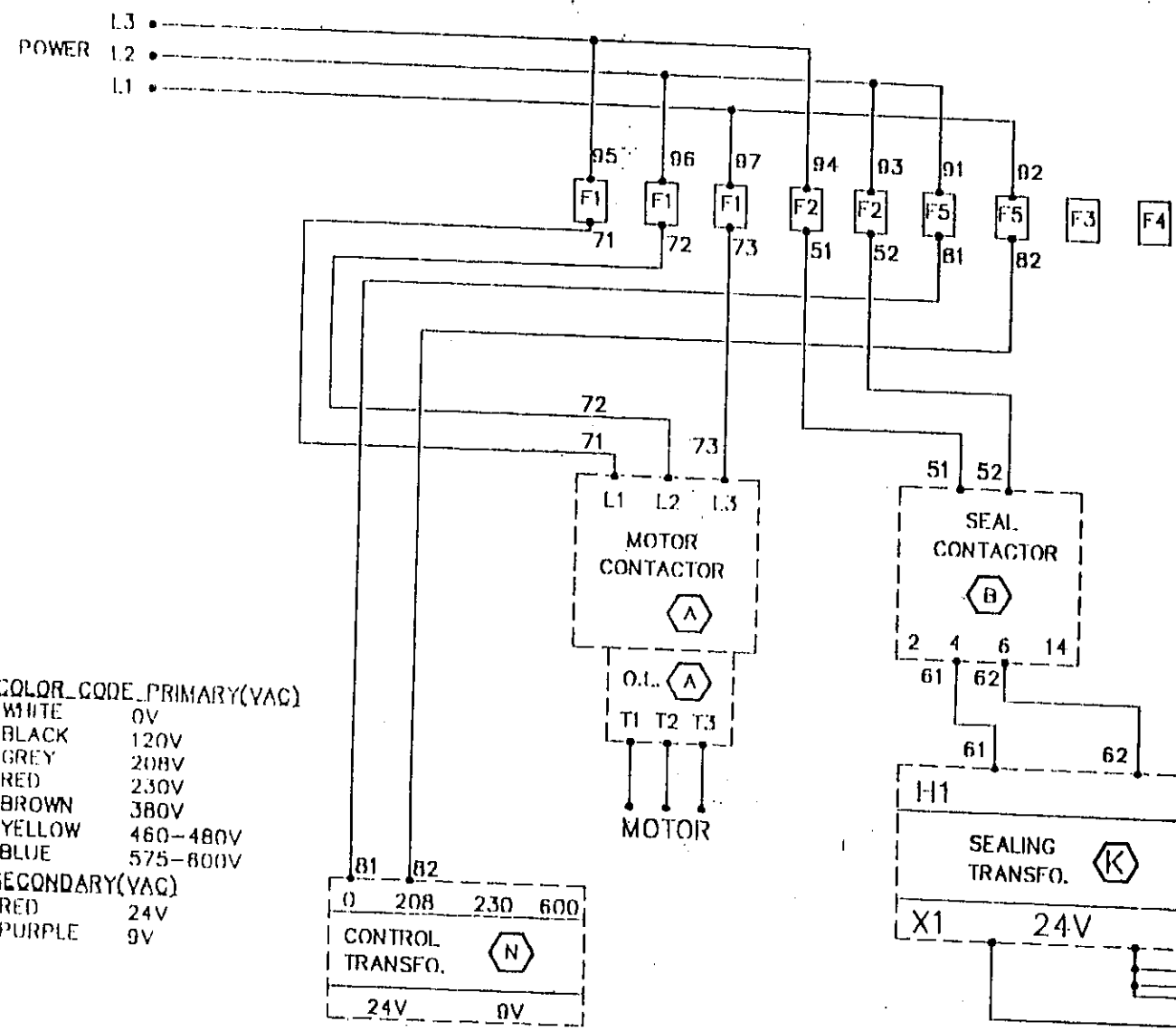


MC-40

MACHINE	VACUUM SINGLE CHAMBER	SIPROMAC
	LOW VOLTAGE WITH MC-40	ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
MAI:	DESS. D. LETOURNEAU	NO. 006-0115
MODIFICATION	DATE	DATE 15 MAY 88
	INT.	

22

1006-0116



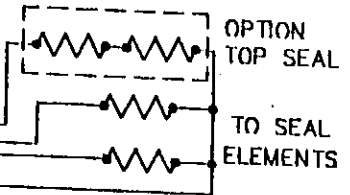
PUMP		
MOTOR (HP)	VOLT +ph.	FUSE F1
3	230-1	034-0550
3	230-3	034-0530
3	575-3	034-0480
5	230-1	034-0570
5	230-3	034-0550
5	575-3	034-0510
7.5	220-3	034-0110
7.5	575-3	034-0540

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 (K) SEE FOLLOWING LIST

MACHINE 550A, 570A & 580A		SIPROMAC	
PIECE ELEC. WIRING DIAGRAM HIGH VOLTAGE 3Ø		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	
QT.	ECH. SCALE	NE PAS MESURER /N.T.S.	
MAT.	DESS. D. LETOURNEAU	DATE 88-10-11	NO.
	APP.	DATE	
			006-0116

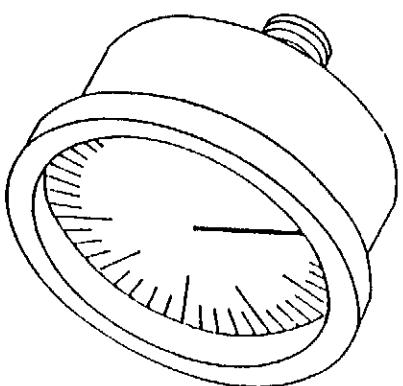
REF.	MODIFICATION	DATE	INT.
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ELECTRICAL DRAWINGS PARTS LIST

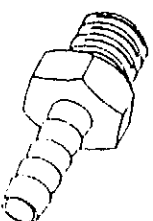
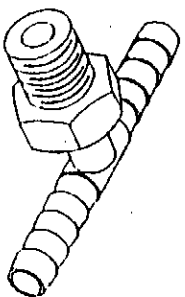
MODEL 550A

A: VOLT	PHASE	PUMP HP	CONTACTOR	OVERLOAD
220	1	3	025-0040	025-0190
220	3	3	025-0020	025-0180
575	3	3	025-0010	025-0150
220	1	4	025-0050	025-0200
220	3	4	025-0030	025-0190
460	3	4	025-0010	025-0170
575	3	4	025-0010	025-0160
B,C & O: SEALING CONTACTOR: 025-0020				
D: OPTIONAL GAZ SOLENOID VALVE: 106-0010				
E: VACUUM SOLENOID VALVE: 106-0030				
F: ATMOSPHERE SOLENOID VALVE: 106-0030 WITH PUMPS: 3HP & 4HP				
G: BELLOWS SOLENOID VALVE: 106-0070				
H, I, J: COVER SWITCH: 026-0610				
K: SEALING TRANSFO.: TWIN SEAL & BAG CUT: 029-0040, 029-0050				
L: RELAY & BASE: RELAY: 025-0600 BASE: 025-0610				
N: CONTROL TRANSFO.: 029-0007, 029-0008, 029-0009, 029-0250				

029 6010

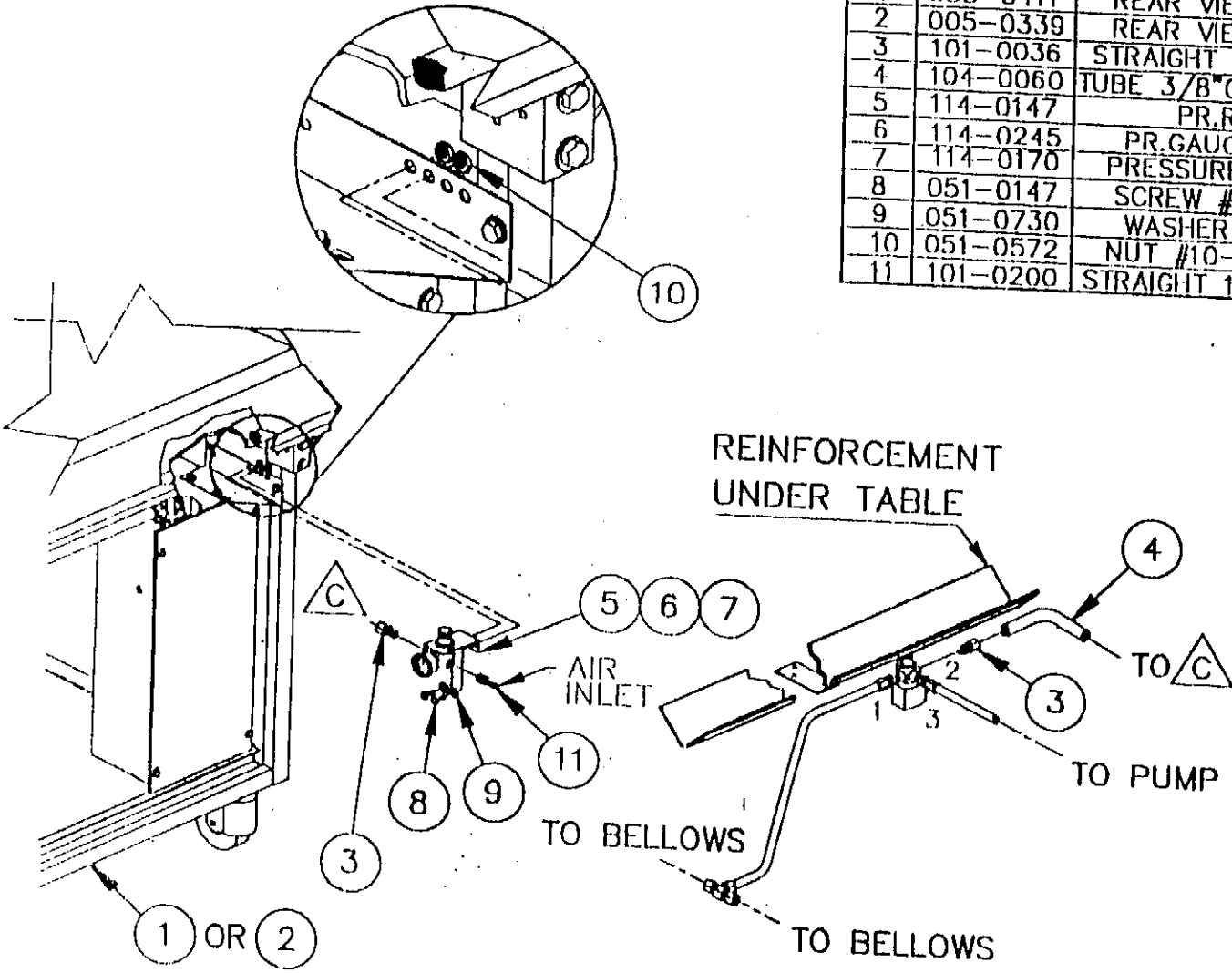


PNEUMATIC DRAWING



1010-0033

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	1
4	104-0060	TUBE 3/8" OD x 1/4" ID (POLY) x mm LG.	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	051-0147	SCREW #10-24 x 1" HEX. S/S	1
9	051-0730	WASHER #10 FLAT S/S	2
10	051-0572	NUT #10-24 NYLON LOCK S/S	2
11	101-0200	STRAIGHT 1/4" MNPT x 1/4" HOSE BARB	2



-AIR REGULATOR OPTION-

MACHINE	450A & 550A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	AIR REGULATOR OPTION KIT INSTALLATION		0. ± .5 .0 ± .05 .00 ± .008 .000 ± .0005 ANGLE ± 1'	.0 ± .015" .00 ± .008" .000 ± .0005" N.T.S.	
ITEM:	CNC:	DWG BY	M. LAVIGNE	DATE	07-10-07
MAT:	APP:	SCALE		QT.	1
MODIFICATION			DATE	INT.	NO. 010-0033

LET. _____ MODIFICATION _____ DATE _____ INT. _____



United States
Department of
Agriculture

Food Safety
and Inspection
Service

Washington, D.C.
20250

May 14, 1992

Sipromac, Inc.

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

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

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

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

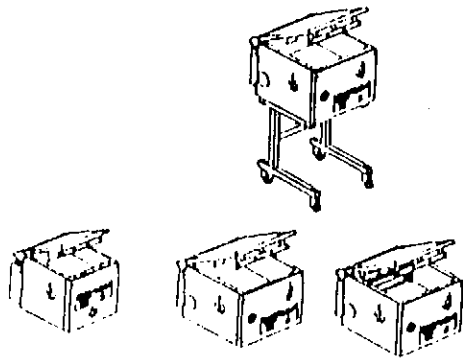
Sincerely,

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

PREP

NOTES

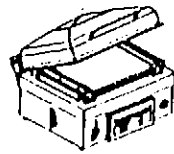
NOTES



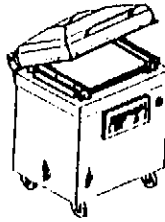
MODEL 250

MODEL 350

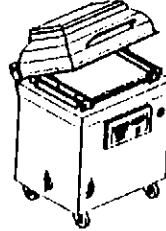
MODEL 350D



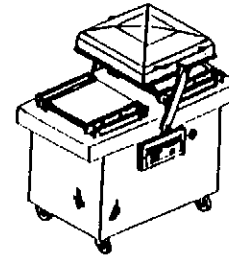
MODEL 450T



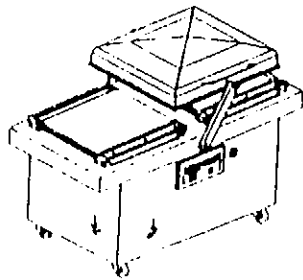
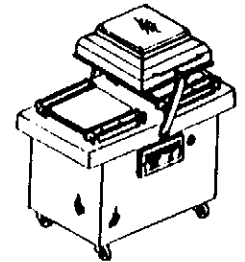
MODEL 450A



MODEL 550A



MODEL 420A

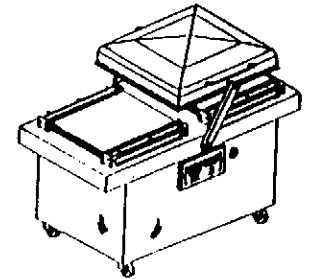


MODEL 600A

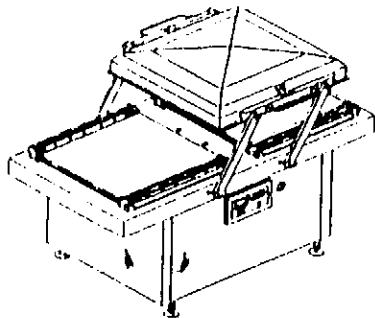


Canada
SIPROMAC
International Headquarters
St. Germain, Canada J0C1K0

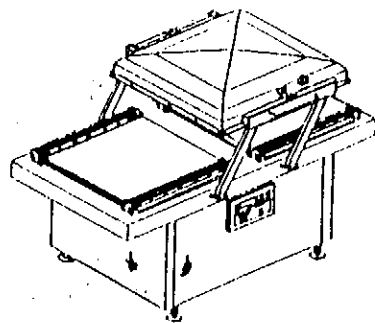
VACUUM PACKAGING MACHINES



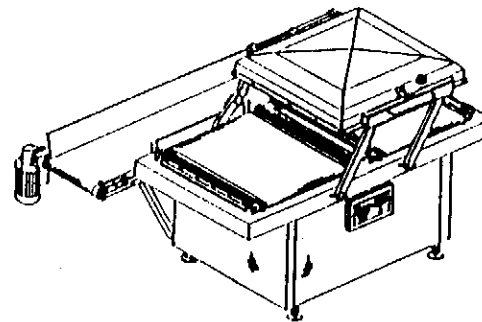
MODEL 620A



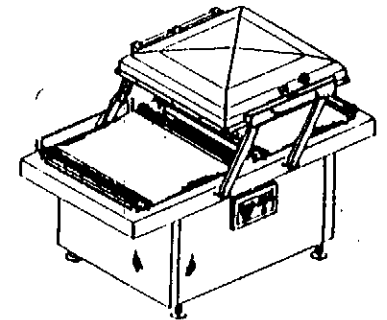
MODEL 650A



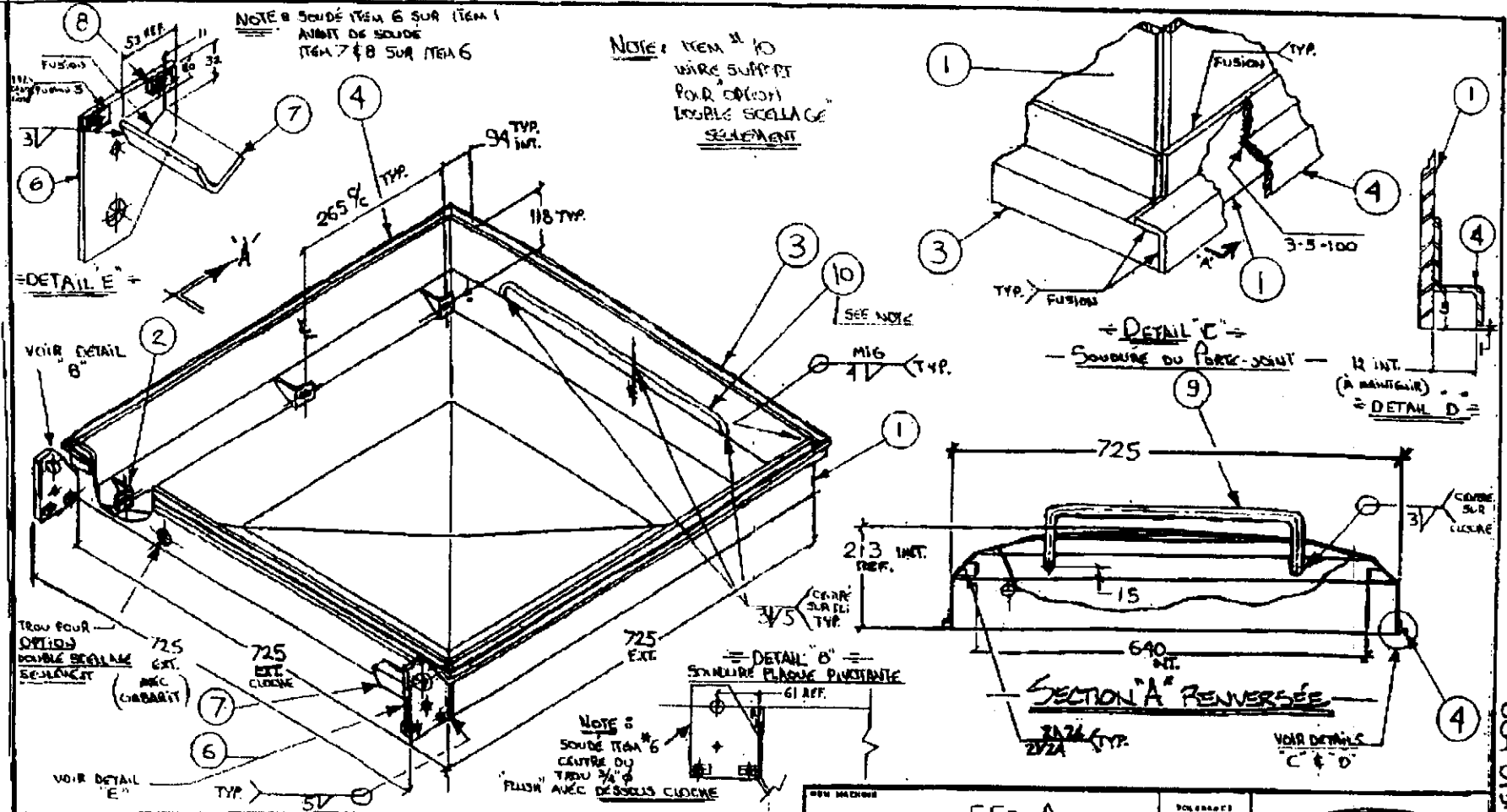
MODEL 650A AUTOMATIC



MODEL 700A



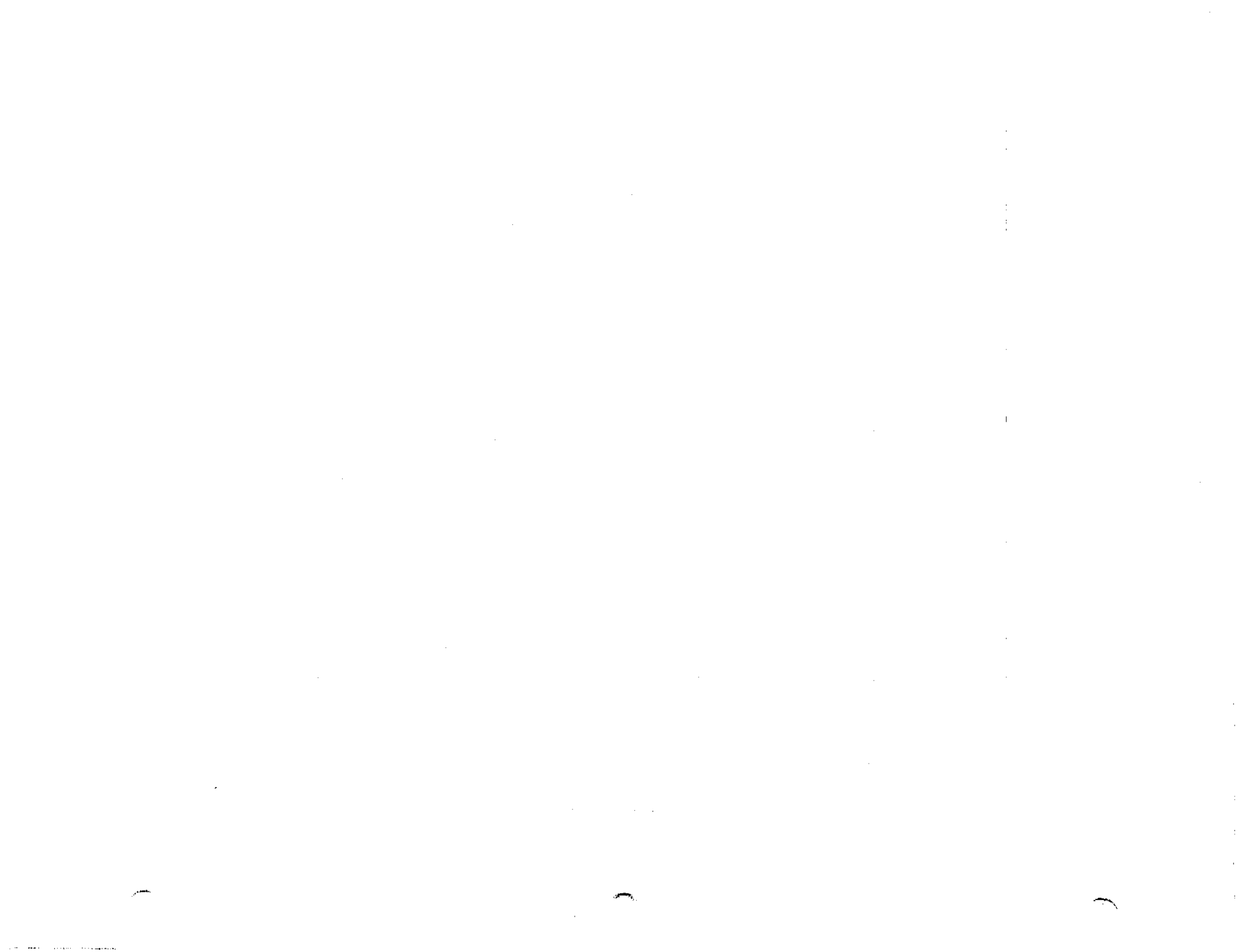
004-0134

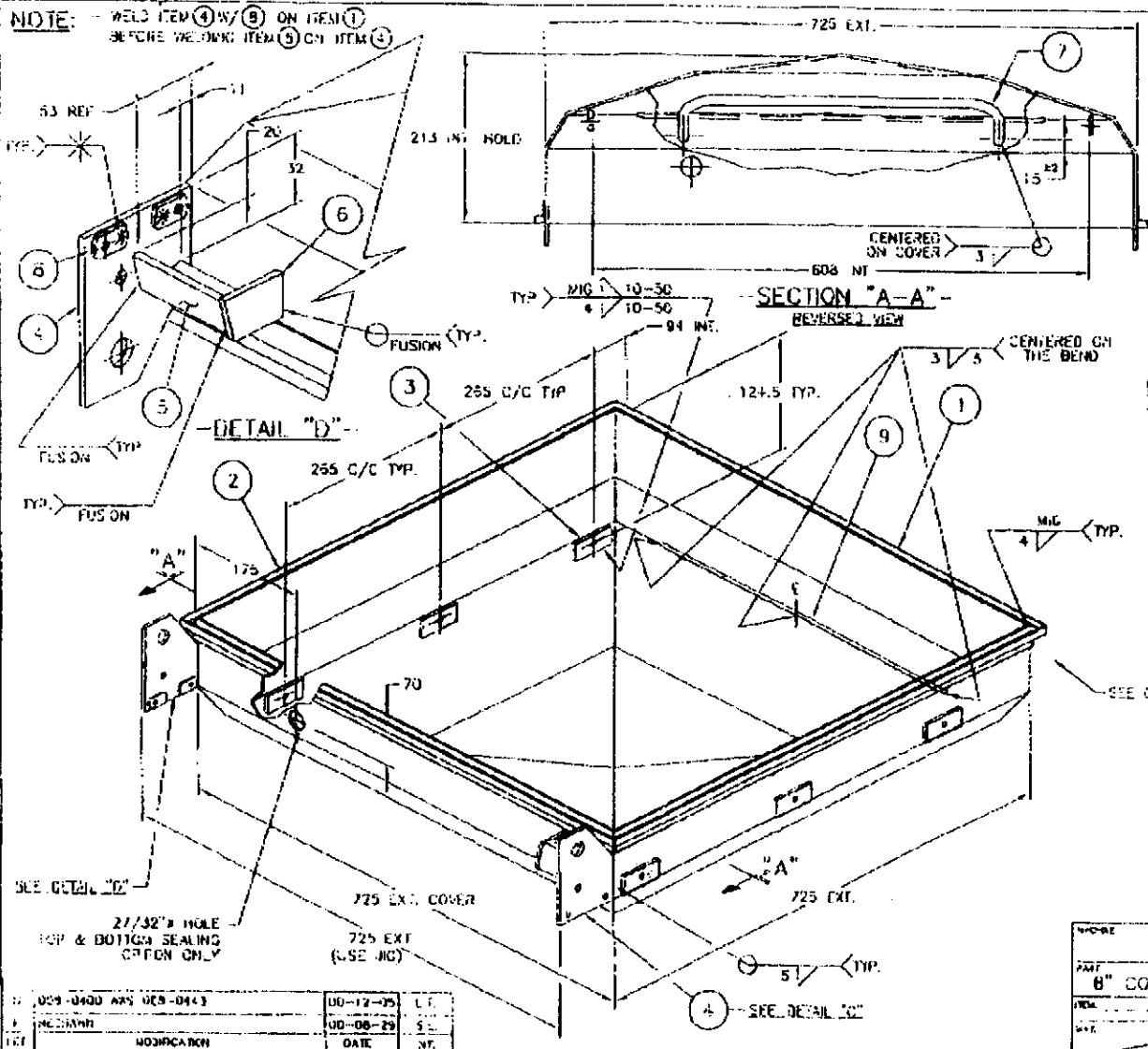


QTE	ITEM	PIECE	DESCRIPTION	QTE	ITEM	PIECE	DESCRIPTION
5				10	008-0943		WIRE SUPPORT (OPT.)
4	001-1328	2	PORTE-JOINT DROIT & GAUCHE	9	008-0941	1	POIGNÉE DE CLOCHE
3	001-1323	2	PORTE-JOINT ANNUL. GAUCHE	8	056-0012	4	ECROU Ø SOUDER 1/2-20 MAX.
2	001-1289	6	FUSION SUR PORTE-JOINT	7	001-1326	1	BUTÉE DU RESSORT
1	001-1326	4	CLOCHE B" CÔTÉS	6	001-1319	2	PLAQUE PIVOTANTE
1	8	PIECE	DESCRIPTION	QTE	ITEM	PIECE	DESCRIPTION

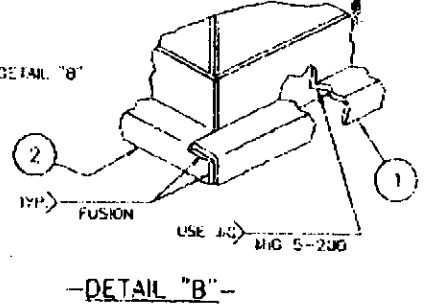
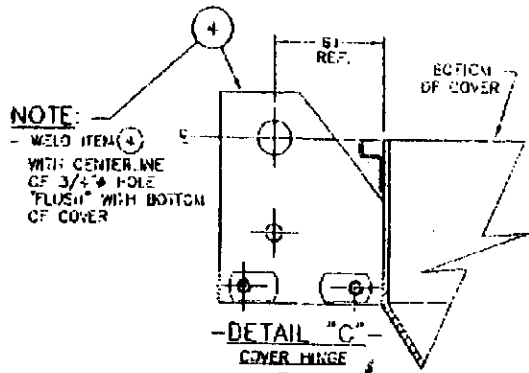
550-A		POLYMER 1 1.5 1.25 1.200 1.200		
PRE-ASSEMBLAGE CLOCHE 8"		NE PAS MESURER		
M. LAVIGNE		97-06-11		004-0134

004-0134





ITEM	PART #	DESCRIPTION	QTY
1	009-C073	8" COVER FRONT & REAR REWORKED	2
2	009-C050	8" COVER RIGHT & LEFT REWORKED	2
3	001-1647	UPPER RUBBER SUPPORT FIXATION 8" COVER	6
4	001-1319	COVER HINGE PLATE	2
5	001-1336	SPRING STOPPER	1
6	001-2039	SPRING STOPPER REINFORCEMENT	1
7	006-0341	COVER HANDLE	1
8	006-0212	WELD NUT 1/4"-20 NC. S/S	4
9	008-C400	WIRE SUPPORT (OPT T&G SEALING)	2



WORK NO	550A	REVISE	DATE	BY	CHK	DATE	BY
PART	8" COVER PRE-ASSEMBLY	QTY	2	DATE	DATE	DATE	DATE
REV		DATE		BY	DATE	BY	DATE
DATE		DATE		DATE	DATE	DATE	DATE

ST-GERMAIN DE GRANBY
QUEBEC CANADA

004-0134

004-0134

