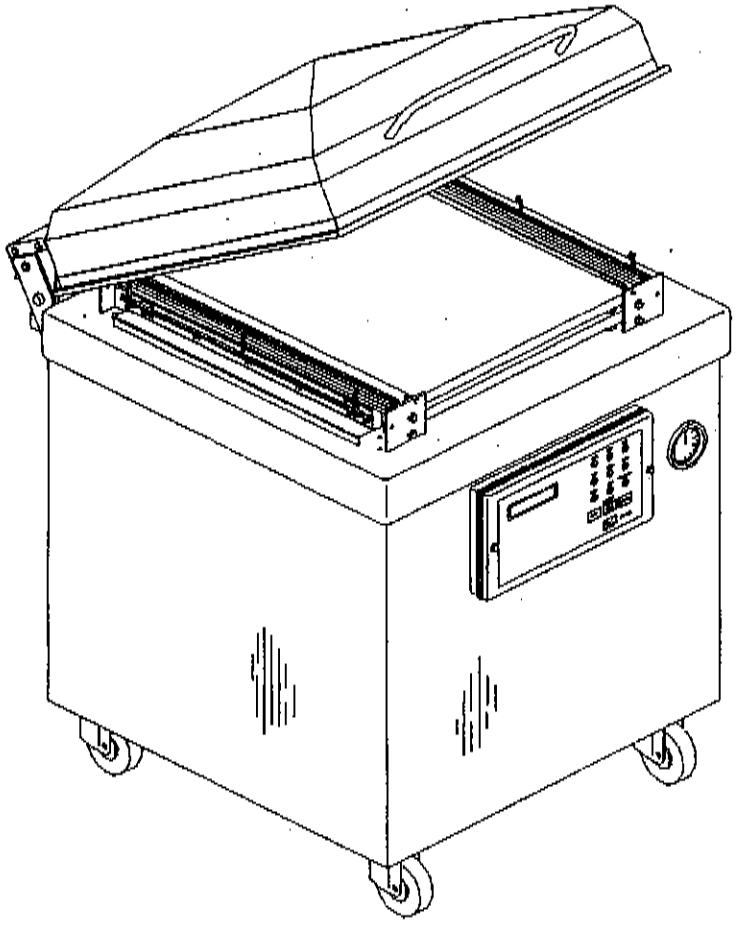
VACUUM PACKAGING MACHINE

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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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.

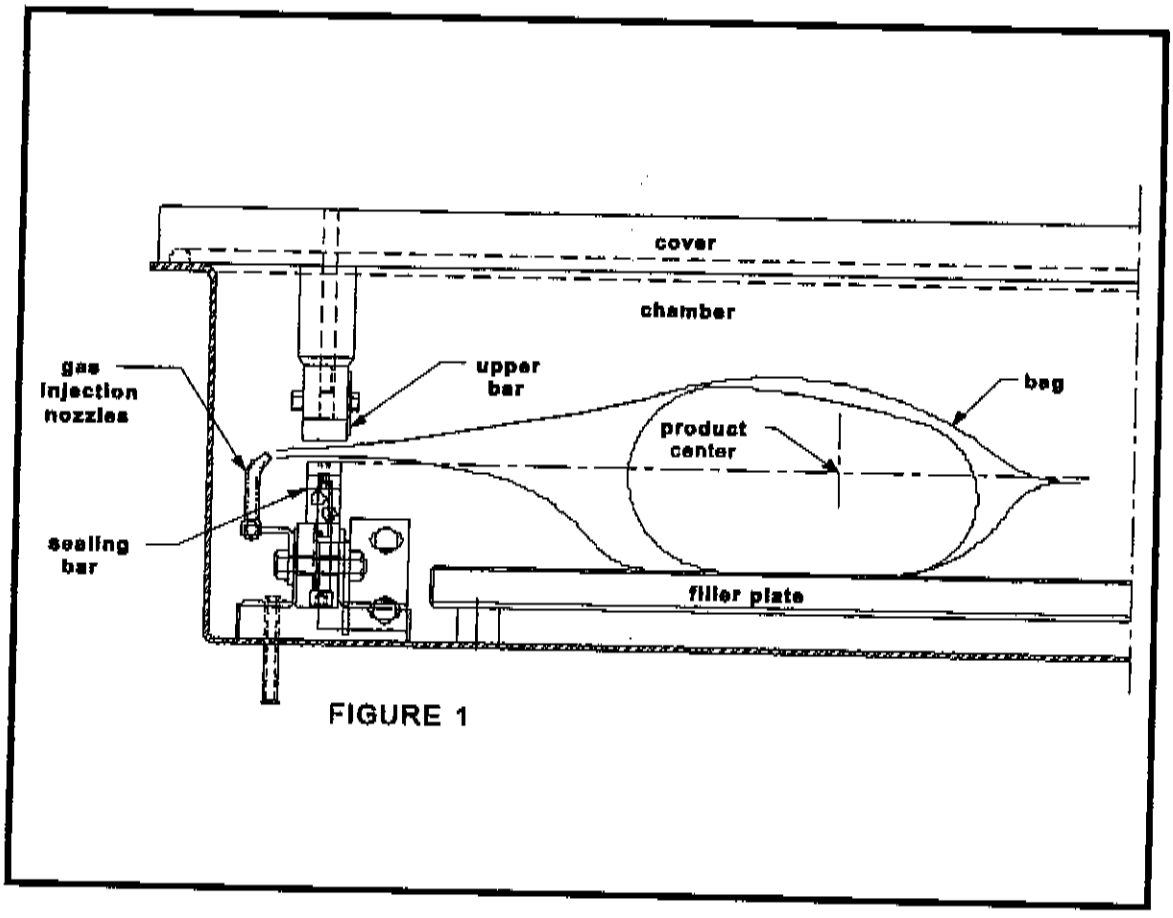


FIGURE 1

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 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	→	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:

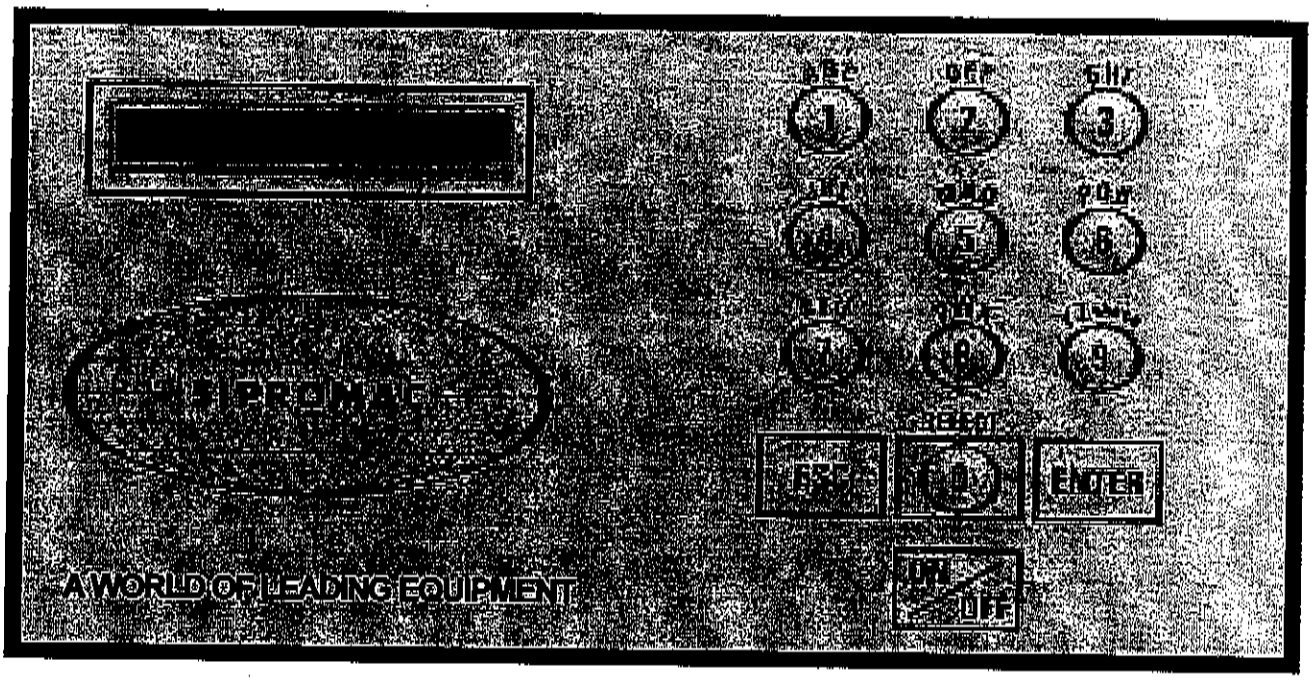
  "VACUUM: xx.x%" (10.0% - 99.5%)
  "VACUUM PLUS: xxs"(0s - 99s)
  "GAS FLUSH: xx.x%" (0.0% - 10% below the vacuum level) (units with gas option)
  "SEAL TIME: x.xxs" (0.00s - maximum unit allocated setting)
  "Pxx NAME" (12 characters)

- **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 hygenic 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 duringthe 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 verifing 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).

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 dammage 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.

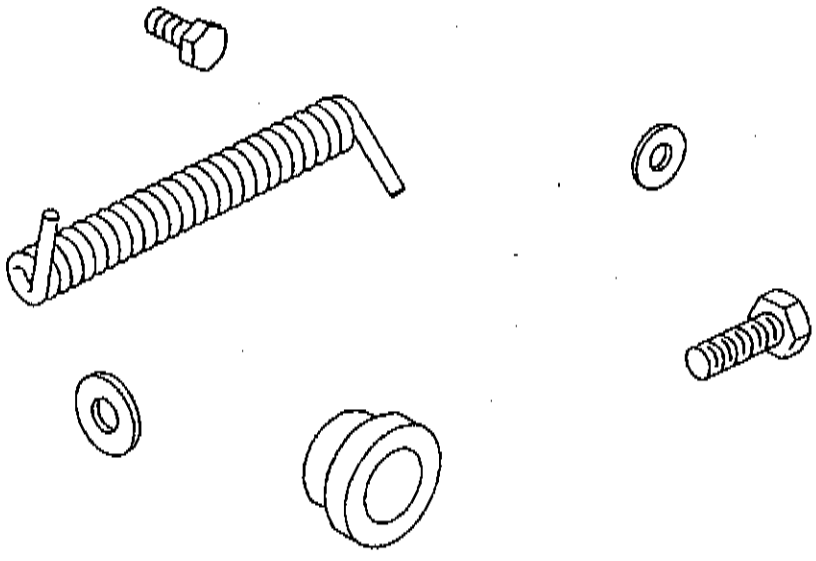
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

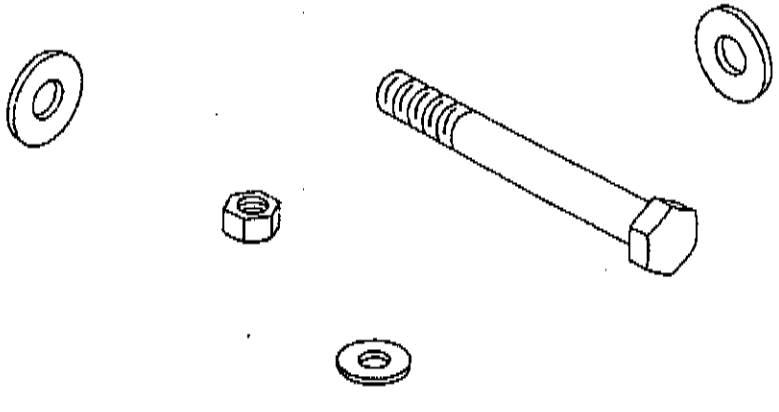
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.



MECHANICAL DRAWING



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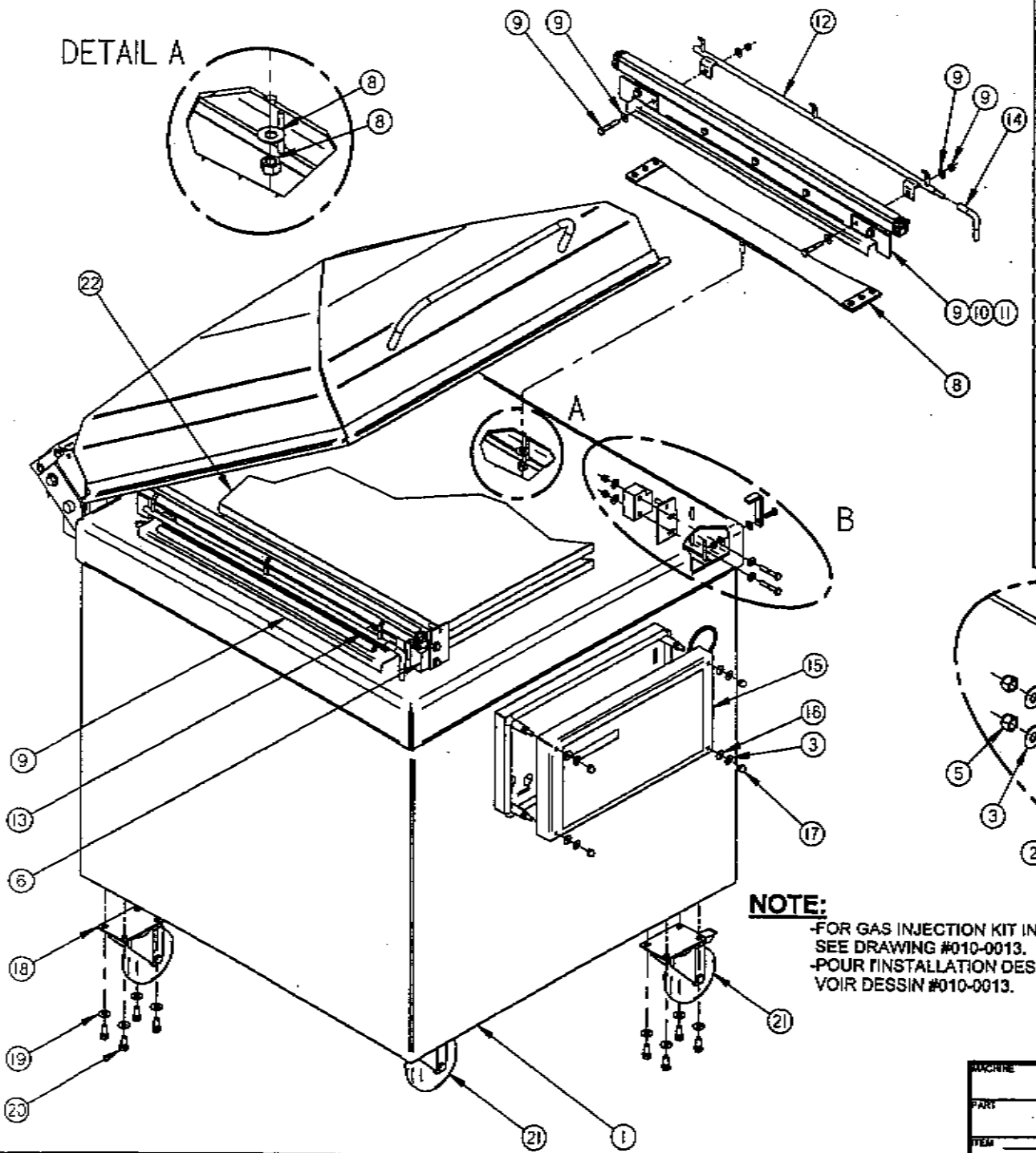
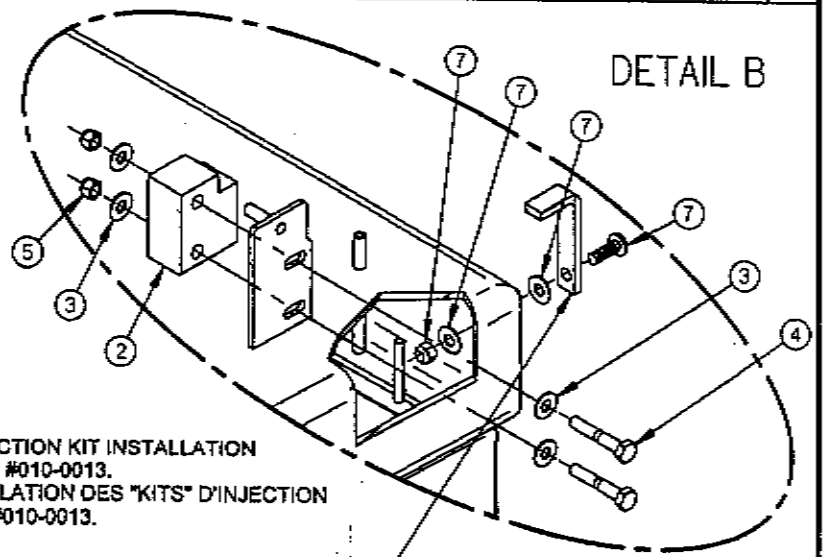




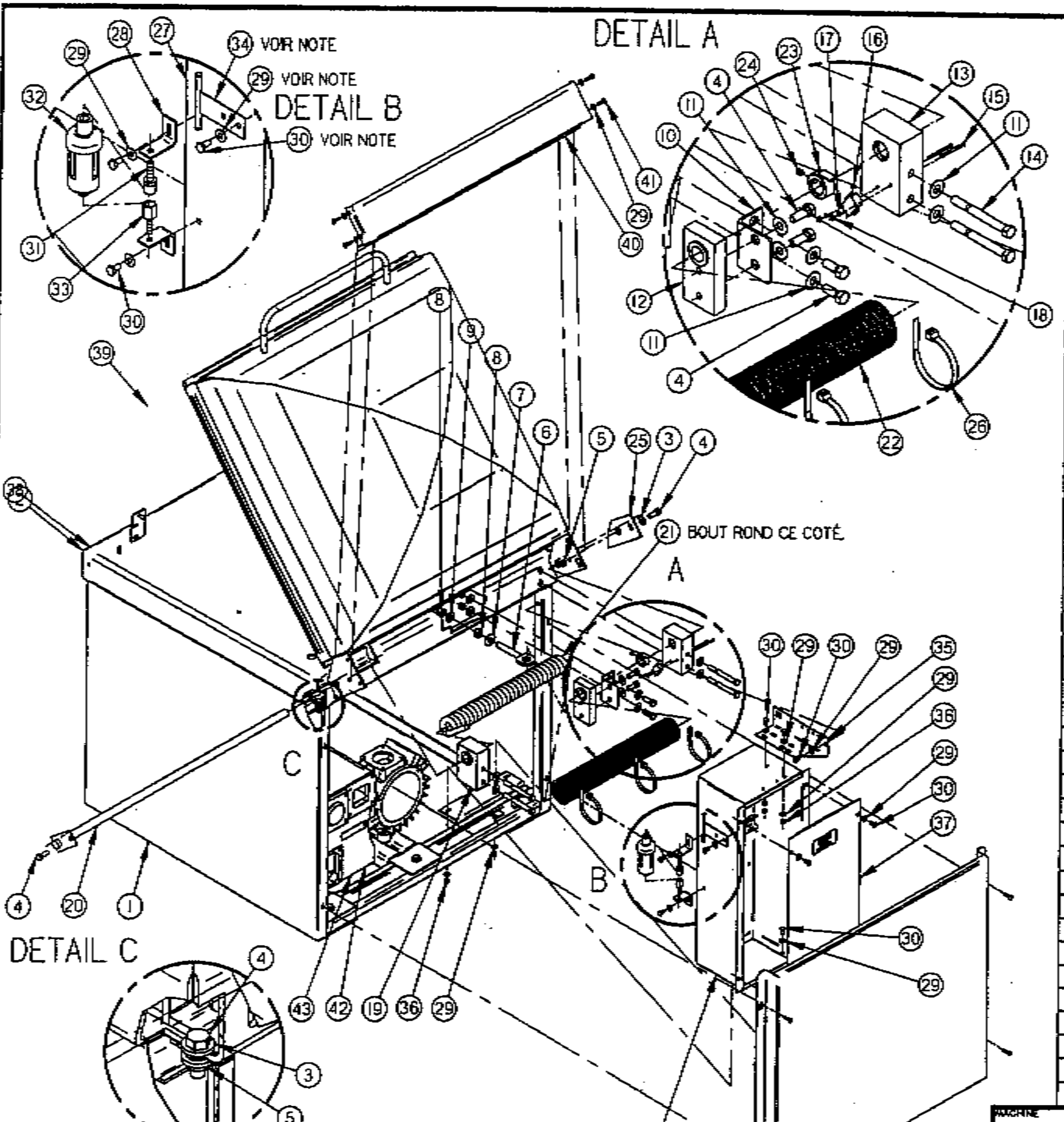
INSTALL TO MOVE FREELY (7) INSTALLER POUR UN MOUVEMENT LIBRE

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 ¼"-20nc. X 1½" 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-ASS'Y	1
8	005-0320	BELLOWS ASSEMBLY	2
9	005A0568	SEAL BAR ASS'Y W/SUPPORT	2
10	005A0570	SEAL BAR ASS'Y W/SUPPORT	2
11	005A0569	SEAL BAR ASS'Y 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 ASS'Y	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

LET.		DATE	INT.
E	REDESSINE	09-02-04	J.G.
	MODIFICATION	DATE	INT.

MACHINE: 550A	DEPT. DE USINAGE: LIMAGE ± 0.1, TOLERIE ± 0.5, SOUDAGE ± 0.5	FINITION	SIPROMAC, ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: MC-40 FRONT VIEW	N.T.S.		
ITEM	CNC	DEPT. M-I	QTY. 1
MAT.	DWG BY J.G.	DATE 09-01-26	NO. 005A0605
	APP. BY	QTY.	

005A0608



ITEM	PART #	DESCRIPTION	QT
1	005B0606	MC-40 STRUCTURE ASSEMBLY	1
2	005A0341	TABLE ASEMBLY	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-ASS'Y	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 ½" 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	051-0084	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-ASS'Y	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 ASS'Y	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-ASS'Y	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 ¼"mnpt. X 3/8"t.p. 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-ASS'Y	1
45	052-0420	SCREW 1/4"-20 N.C x 3/4" PAN SLOT BRASS	4

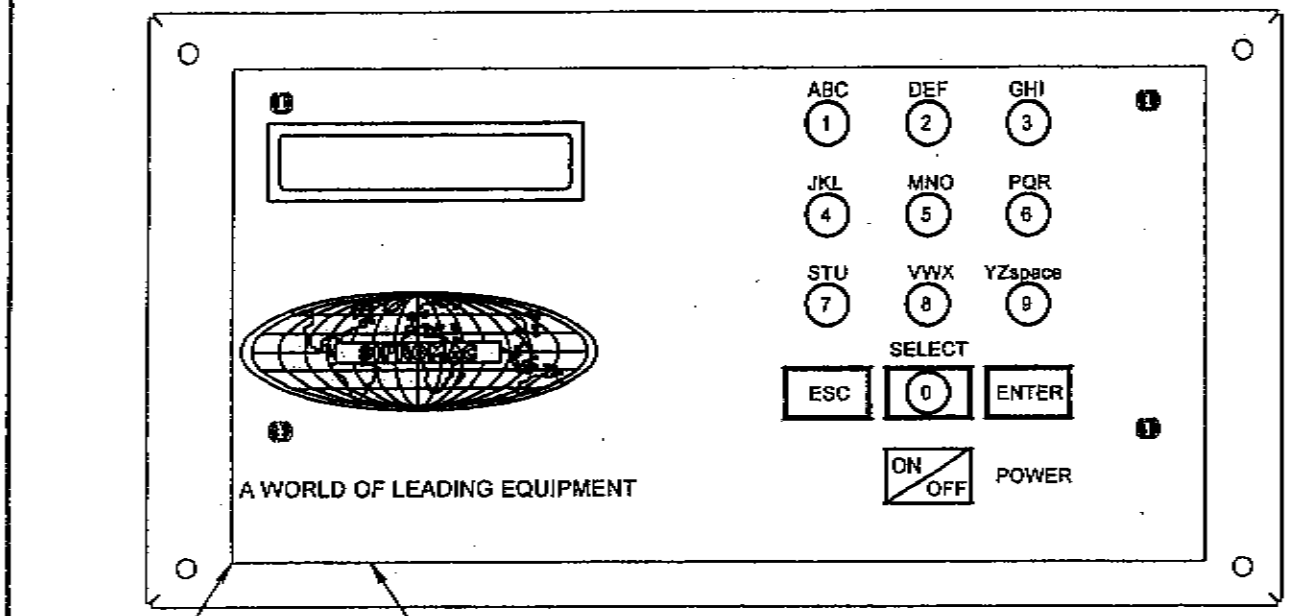
NOTE:
-INSTALLER POUR "GAS FLUSH" SEULEMENT.

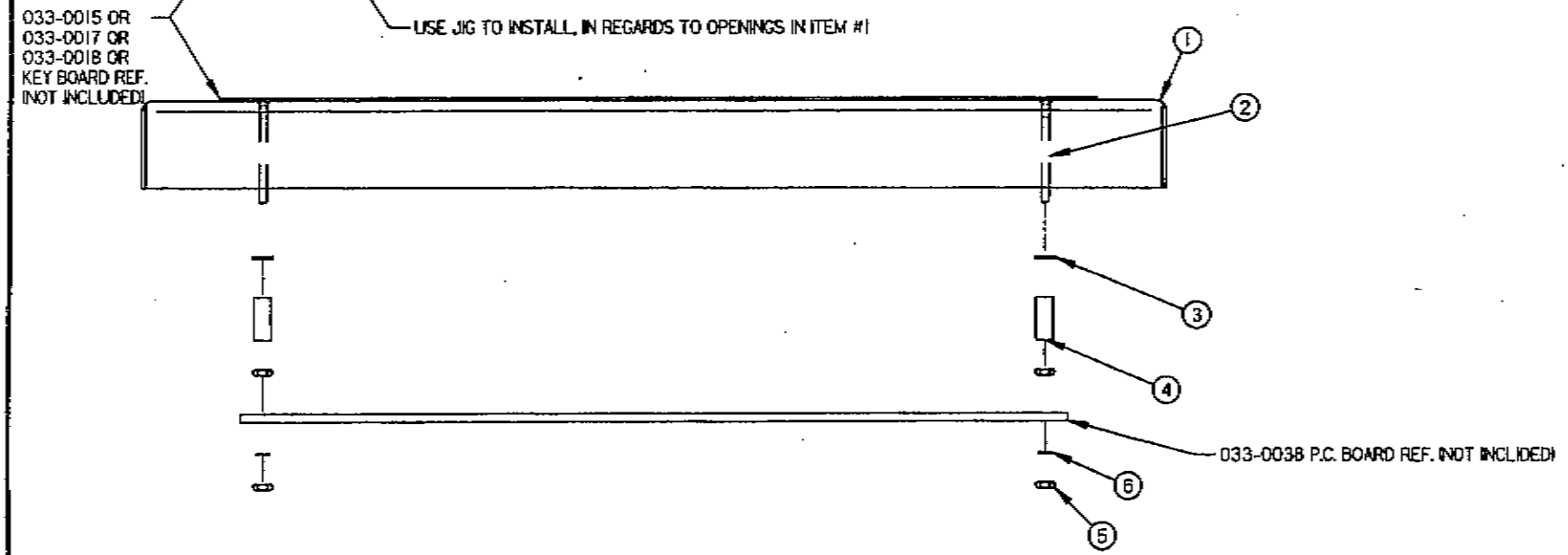
LET.	MODIFICATION	DATE	INT.
G	REMPLACER 004-0171 PAR 001-1334	10-06-08	J.G.
F	REDESSINE	09-02-04	J.G.

MACHINE: 550A	DEPT. TOLERANCES: USINAGE METRIC ±0.1 INCH ±0.004"; TOLERIE ±0.8 ±0.030"; SOUDAGE ±0.5 ±0.020"	N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: MC-40 REAR VIEW			
ITEM	CNC	DEPT. M-I	QTY. 1
MAT.	DWG BY J.G. / APP. BY	DATE 09-02-04 / DATE 10-06-11	NO. 005A0608

005A0583

ITEM	PART #	DESCRIPTION	QTY
1	004A0425	FRONT MC-40 SUPPORT PRE-ASS'Y	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





LET.	MODIFICATION	DATE	INT.
H	AJOUTER 500D	06-04-17	J.G.
G	REDRAWN	05-09-01	M.A.

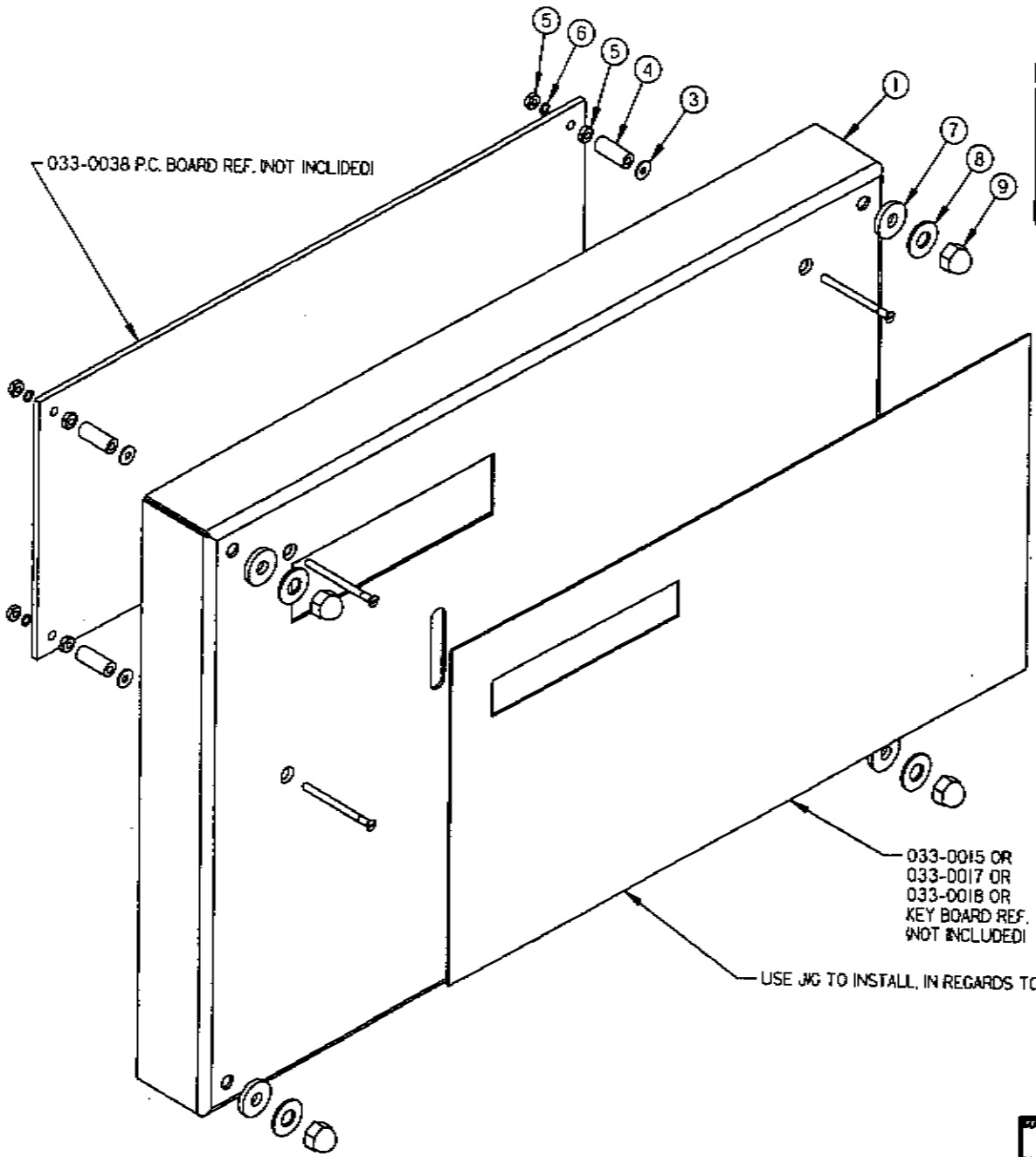
MACHINE	420A, 450A, 450T, 500A, 500D, 550A, 580A, 600A, 620A & 650A
PART	FRONT MC-40 SUPPORT ASS'Y
DEPT.	M(1)
QTY.	1
DWG BY	M.A.L.
DATE	05-09-01
APP. BY	
DATE	2006-04-25
NO.	005A0583

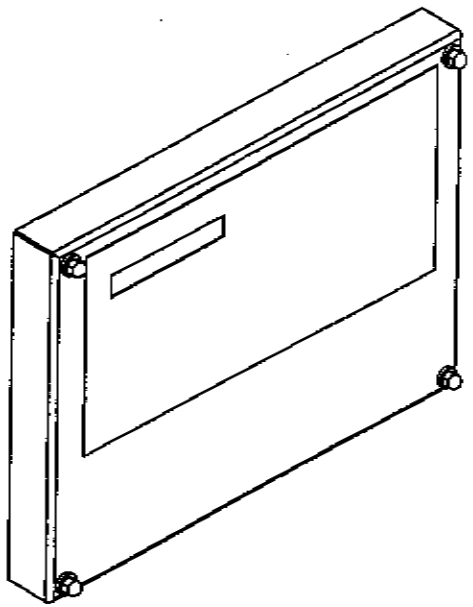
DEPT. TOL: DIMENSION ± 0.1, TOLERIE ± 0.5, SOUDAGE ± 0.5; MACH. ± 0.004" ± 0.002" ± 0.002"

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

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



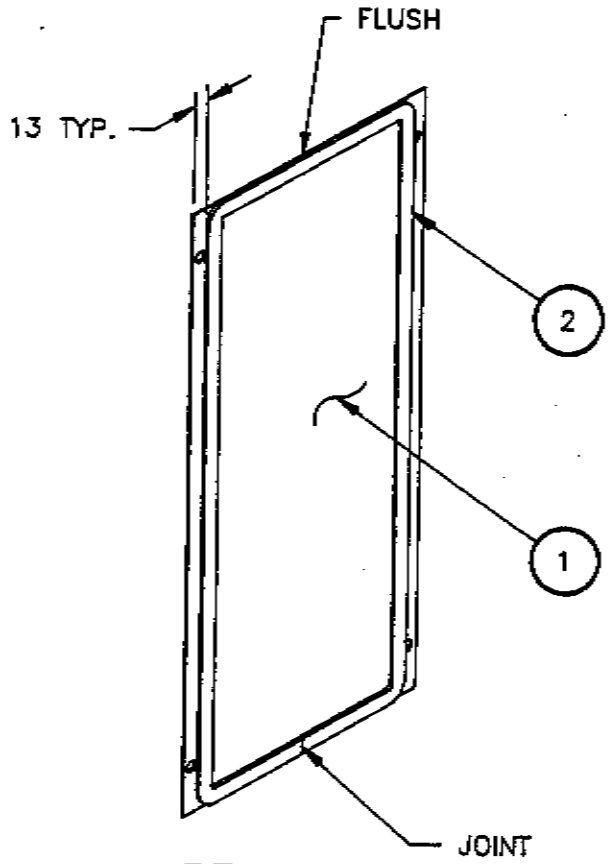


LET.	MODIFICATION	DATE	INT

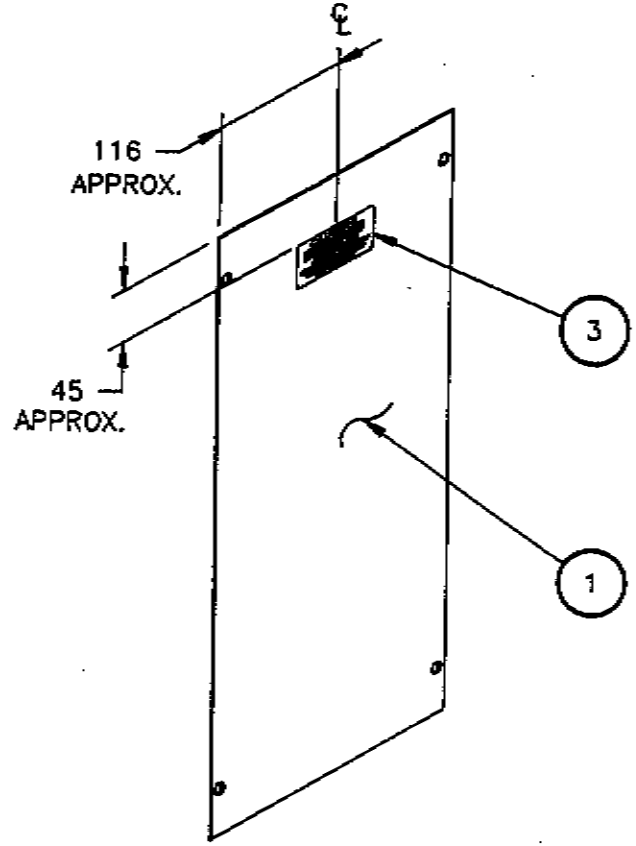
MACHINE	420A, 450A, 550A, 580A, 600A, 620A & 650A	DEPT. TOL. USINAGE / TOLERIE / SOUDAGE	DEC. ± 0.1 ± 0.5 ± 0.5 / FRACT. ± 1/64" ± 1/32" ± 1/16" / MET. ± 0.00R ± 0.000" ± 0.020"
PART	FRONT MC-40 SUPPORT ASS'Y(OPT. HEATER)	N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM	CHC	DEPT. M	QTY. 1
MAT.	DWG BY M.D.	DATE 10-02-03	NO. 005A0779

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-

LET.	MODIFICATION	DATE	INT.

MACHINE: 450A & 550A

PART: E-BOX COVER PRE-ASS'Y

ITEM:

MAT:

CNC:

DWG BY: A.P. DATE: 97-01-08

APP. DATE

METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°

INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"

N.T.S.

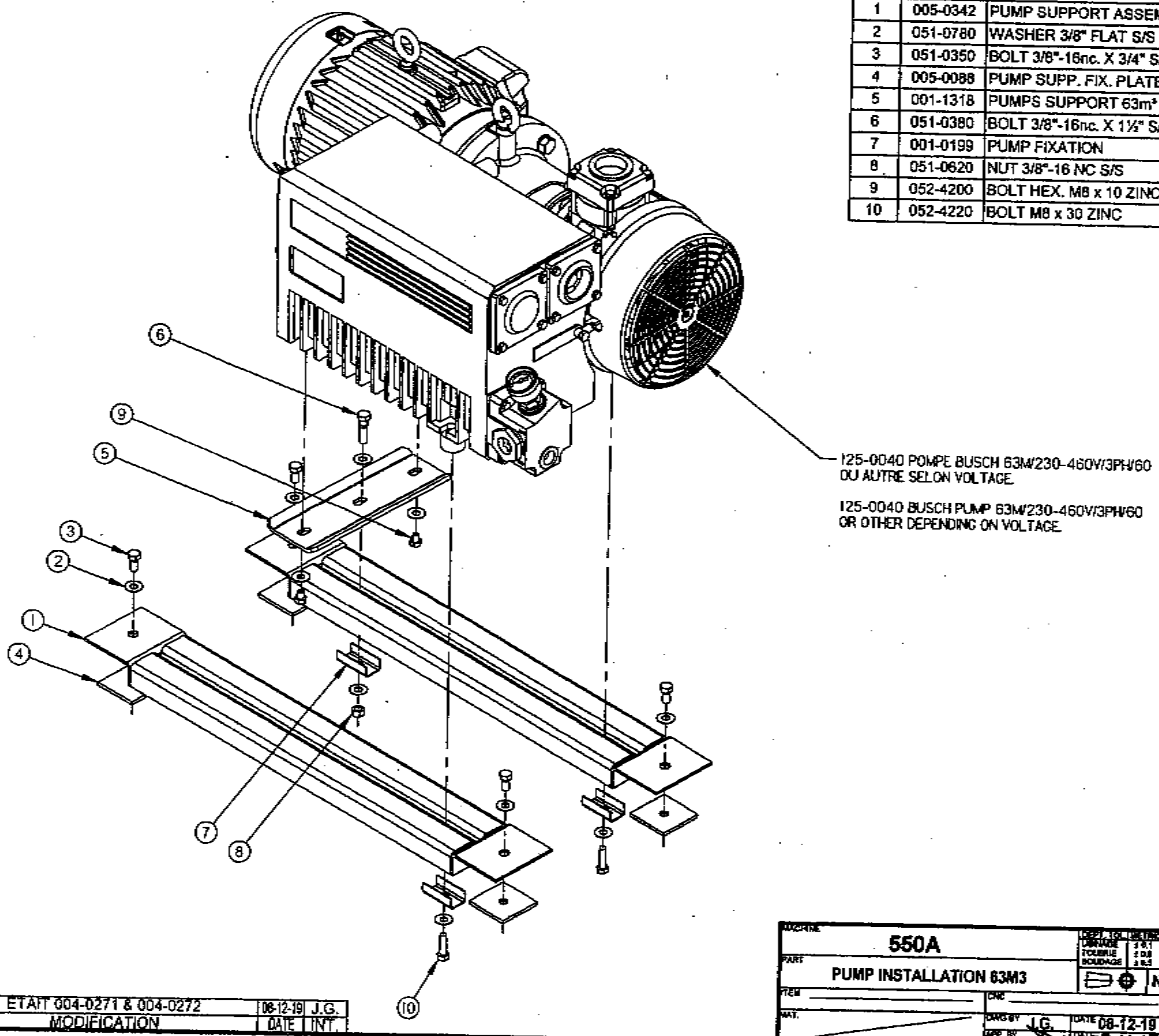
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

SCALE: QT. 1

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 ASS'Y	4
5	001-1318	PUMPS SUPPORT 63m³ & 100m³	1
6	051-0380	BOLT 3/8"-16nc. X 1½" 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

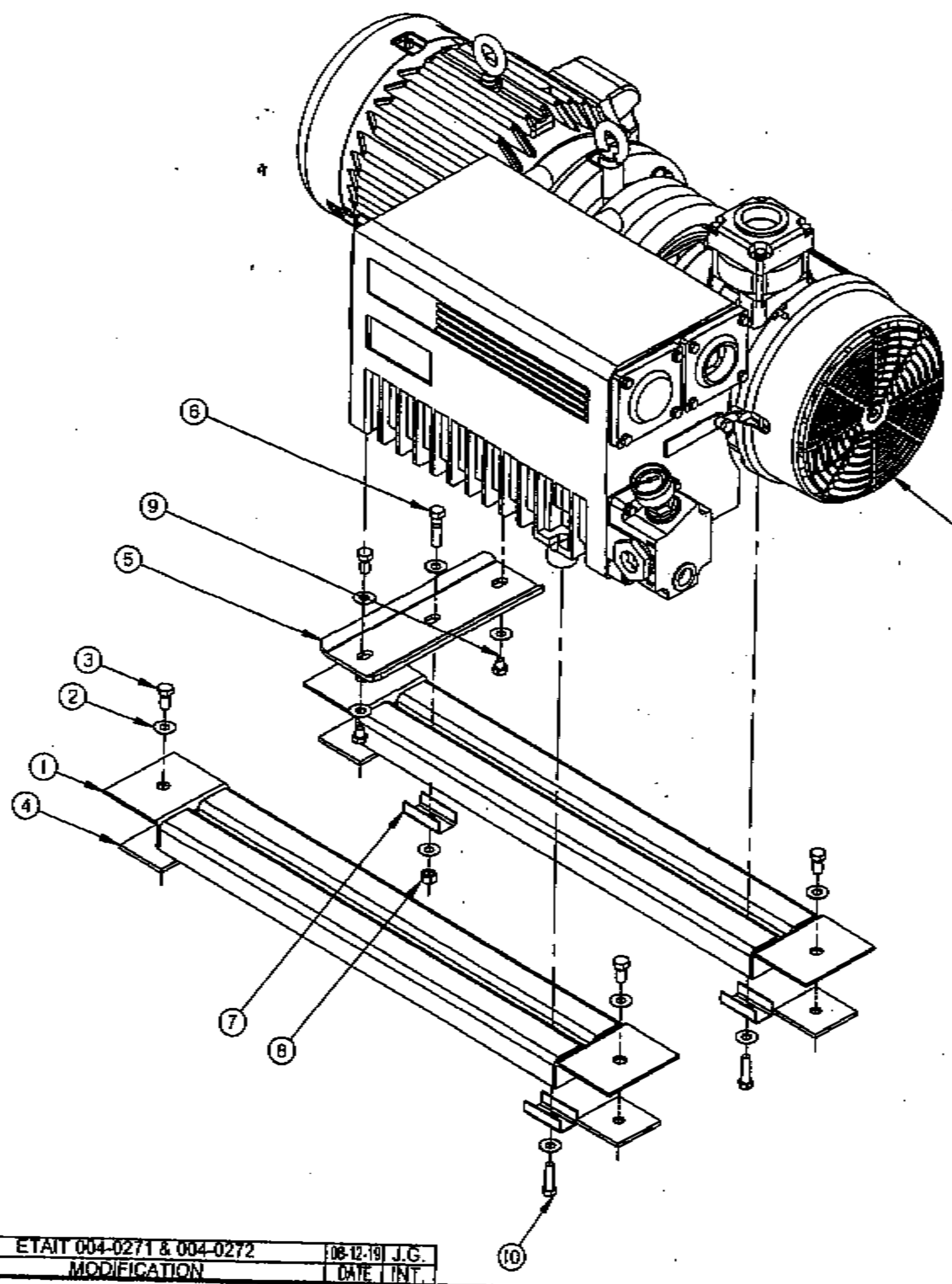


LET.	MODIFICATION	DATE	INT.
A	ETAIT 004-0271 & 004-0272	08-12-19	J.G.

MACHINE	550A	N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	PUMP INSTALLATION 63M3	DEPT. MJ	QTY. 1
DWG BY J.G.	DATE 08-12-19	NO. 010A0062	

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 ASS'Y	4
5	001-1318	PUMPS SUPPORT 63m³ & 100m³	1
6	051-0380	BOLT 3/8"-16nc. X 1½" 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

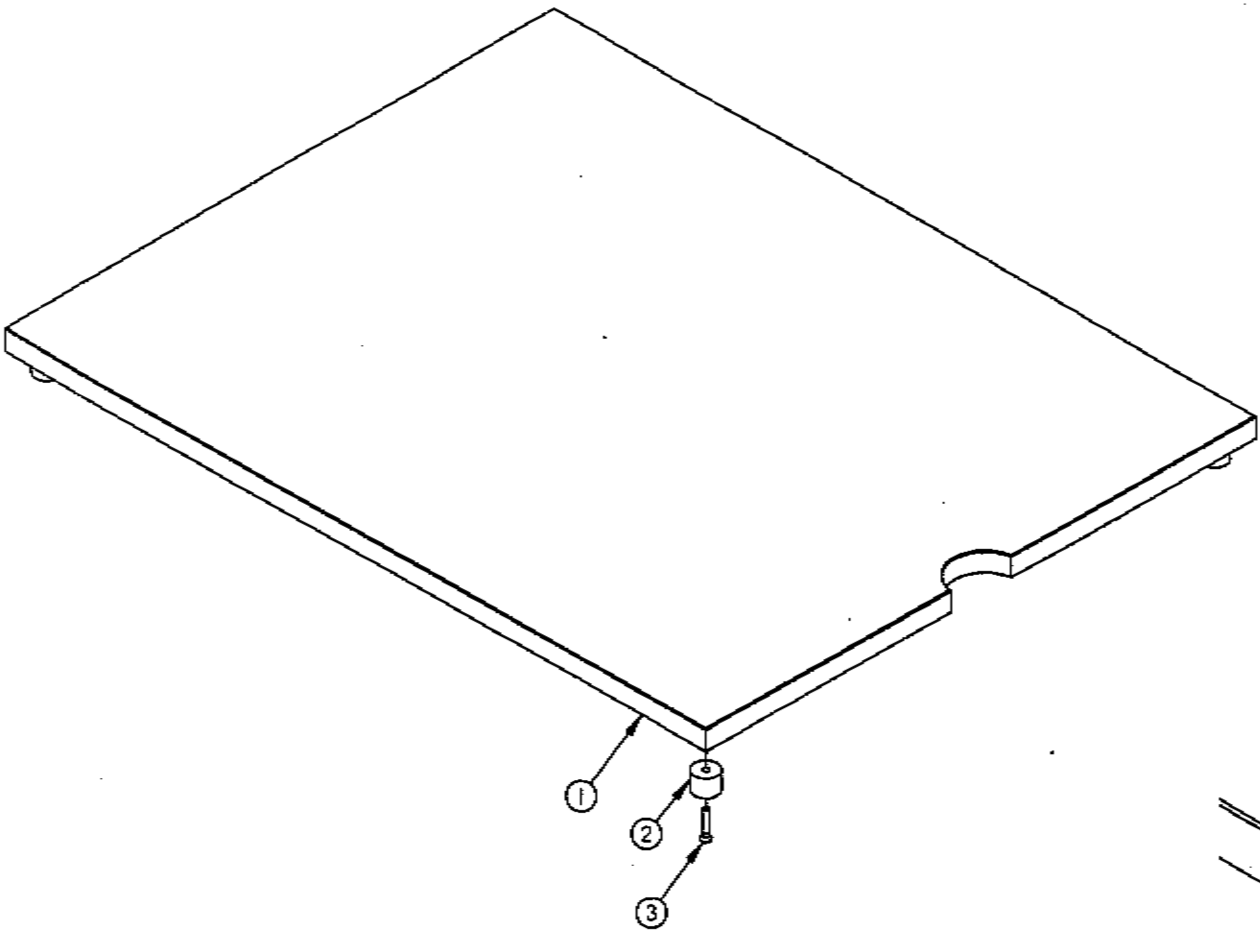


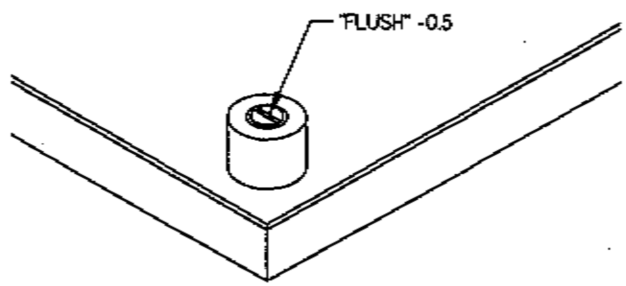
LET.	MODIFICATION	DATE	INT.
A	ETAIT 004-0271 & 004-0272	08-12-19	J.G.

MACHINE	550A
PART	PUMP INSTALLATION 100M3
	N.T.S.
	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
DEPT.	M-I
QTY.	1
DWG BY	J.G.
DATE	08-12-19
NO.	010A0063

005A0340

ITEM	PART #	DESCRIPTION	QT.
1	008A0323	FILLER PLATE	1
2	003-0080	FILLER PLATE FOOT	4
3	054-0004	METAL SCREW #10 x 1" FLAT SLOT S/S	4



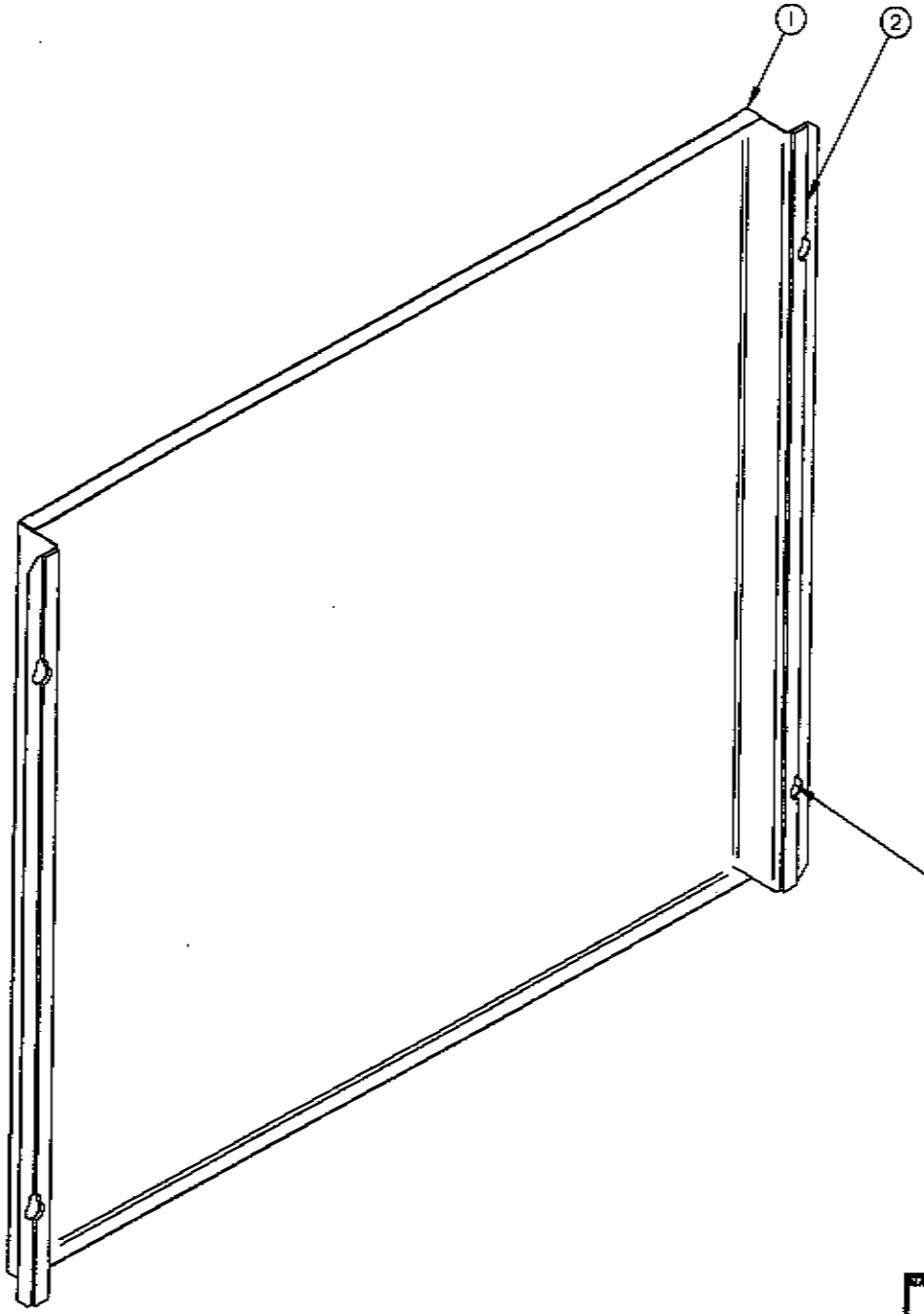


LET.	MODIFICATION	DATE	INT.
B	REDESSINE MODIF #A-0445	09-02-04	J.G.

MACHINE: 550A	DEPT. TOL: METRIC / INCH — USINAGE ±0.1 / ±0.004"; TOLERIE ±0.5 / ±0.020"; SOUDAGE ±0.5 / ±0.020"		SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: FILLER PLATE ASSEMBLY		N.T.S.	
ITEM	CNC	DEPT. M	QTY. 2
MAT.	DWG BY J.G.	DATE 09-02-04	NO. 005A0340
	APP. BY	DATE	

004A2834

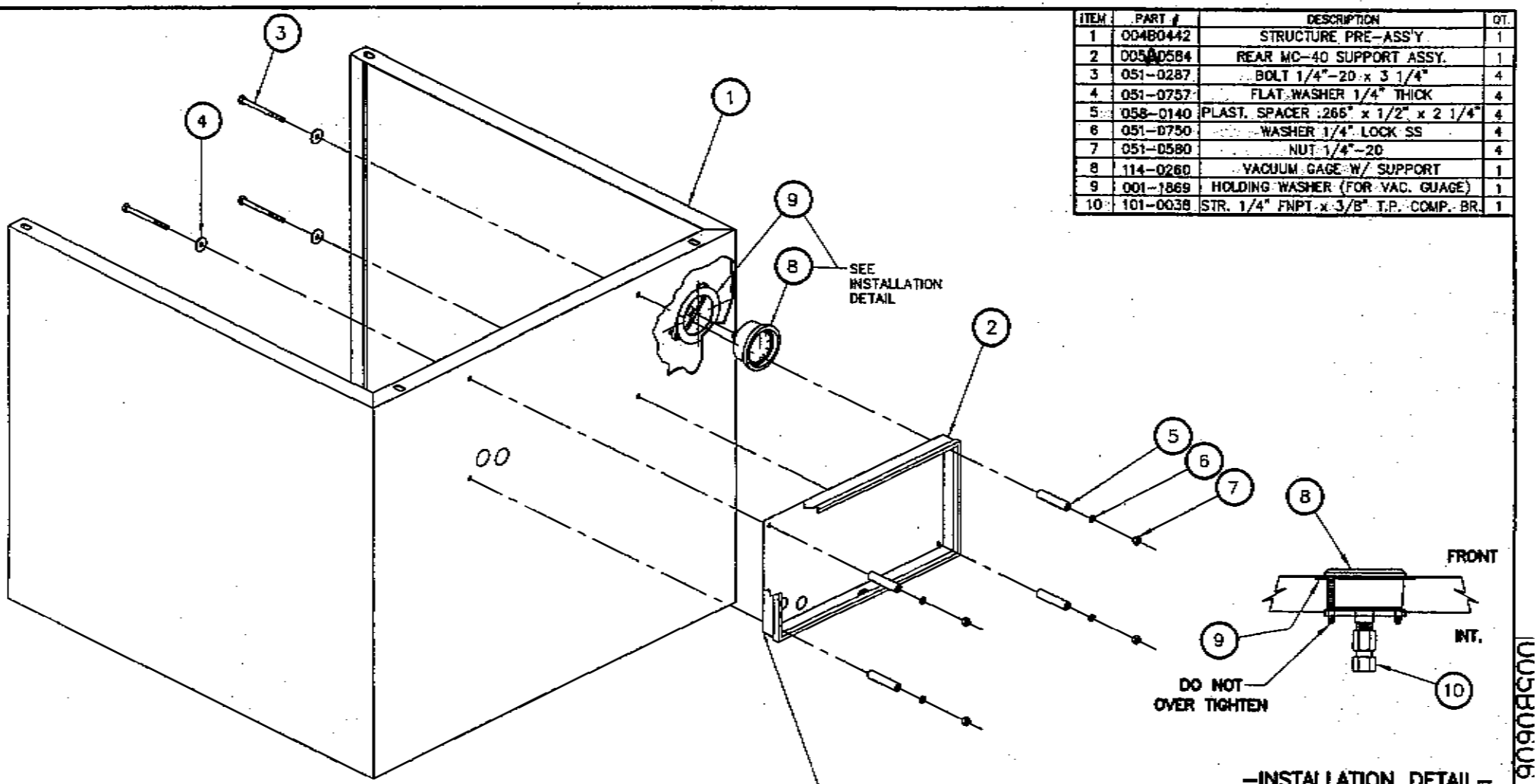
ITEM	PART #	DESCRIPTION	QT.
1	001A4934	REAR PANEL	1
2	179-0004	NITRILE PVC 1/8" x 1/2"	2



PASSER UNE LIME RONDE POUR DÉGAGER LES TROUS

MODIFICATION	DATE	INT.

MACHINE: 550A
PART: REAR PANEL PRE-ASS'Y
DEPT. TOLERANCE METRIC INCH: USINAGE ± 0.1 ± 0.004" | TOLERIE ± 0.5 ± 0.020" | SOUDAGE ± 0.5 ± 0.020"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM | DRC | DEPT. M | QTY. 1
MAT. | DRG BY J.G. | DATE 08-12-19 | APP. BY | DATE 08-12-19 | NO. 004A2834



ITEM	PART #	DESCRIPTION	QT.
1	004B0442	STRUCTURE, PRE-ASS'Y	1
2	005B0584	REAR MC-40 SUPPORT ASSY.	1
3	051-0287	BOLT 1/4"-20 x 3 1/4"	4
4	051-0757	FLAT WASHER 1/4" THICK	4
5	058-0140	PLAST. SPACER .265" x 1/2" x 2 1/4"	4
6	051-0750	WASHER 1/4" LOCK SS	4
7	051-0580	NUT 1/4"-20	4
8	114-0260	VACUUM GAGE W/ SUPPORT	1
9	001-1869	HOLDING WASHER (FOR VAC. GUAGE)	1
10	101-0038	STR. 1/4" FNPT x 3/8" T.P. COMP. BR.	1

-INSTALLATION DETAIL-

-UNE FOIS L'ITEM 2 INSTALLÉ, UTILISER DE L'ADHÉSIF MARIN 5200 #189-0210 POUR SCELLER LE HAUT, LES COTÉS ET LES COINS DU BAS (LE COTÉ DU DESSOUS N'EST PAS SCELLÉ)

-ONCE ITEM 2 IS INSTALLED, USE 189-0210 5200 MARINE ADHESIVE TO SEAL TOP, SIDES & BOTTOM CORNERS (UNDER SIDE NOT SEALED).

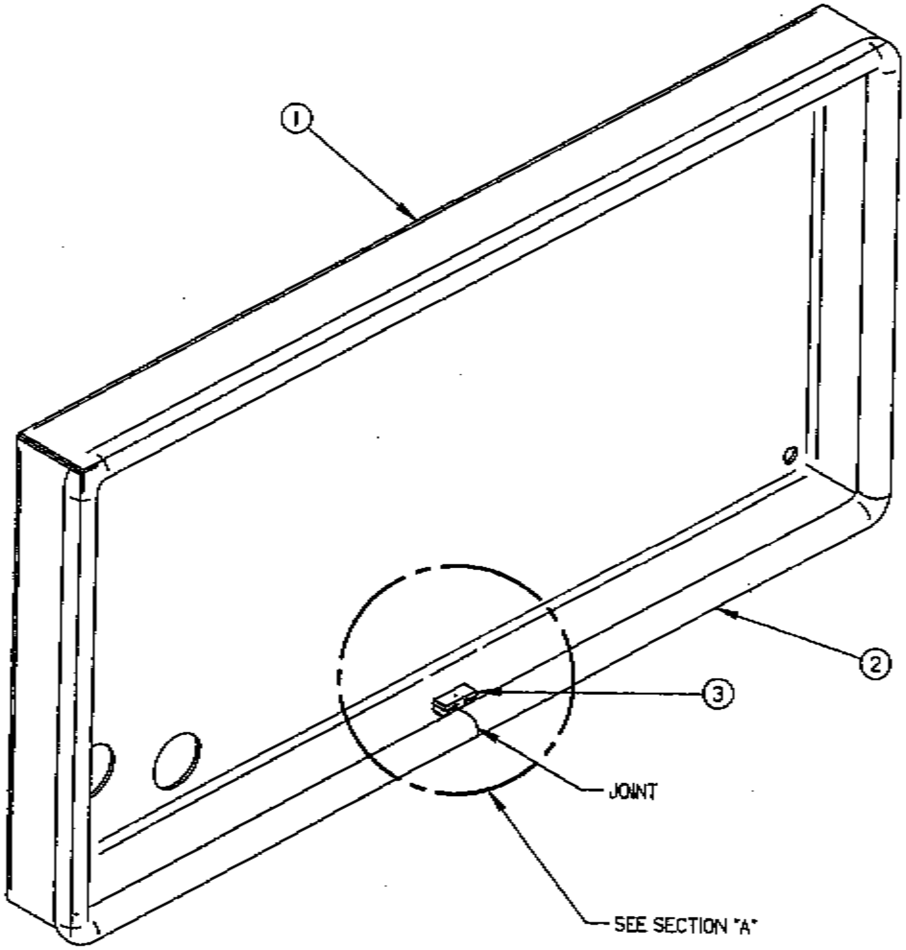
LET.	MODIFICATION	DATE	INT.
B	REDRAWN	05-09-07	M.A.L.

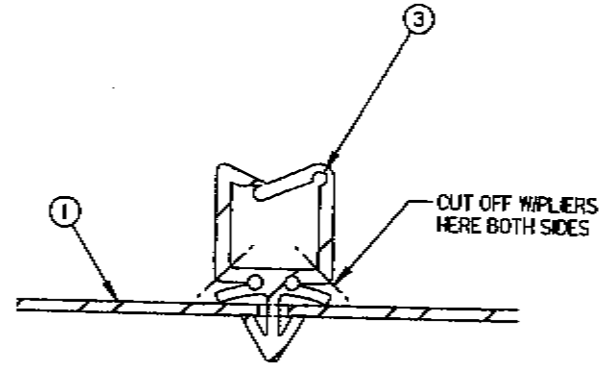
MACHINE: 550A	METRIC TOLERANCE: .5 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .005", .00 ± .005", .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: STRUCTURE ASS'Y	N.T.S.		
ITEM#: ----------	CHG: -----	DEPT: M	QT.: 1
MAT'L:	DWN: M.A.LEBLANC DATE: 05-09-07		NO. 005B0606
	APP. DATE: 05-11-05		

005B0606

005A0584

ITEM	PART #	DESCRIPTION	QT.
1	004A0426	REAR MC-40 SUPPORT PRE-ASS'Y	1
2	179-0019	U-CHANNEL BLACK EPDM FOAM (3.9)	1
3	057-0002	CABLE CLAMPS 9mm (11,2 X 9,3)	1





SECTION A

F	REDRAWN	050901	M.A.
LET.	MODIFICATION	DATE	INT.

MACHINE 420A, 450T, 450A, 550A, 570A, 580A, 600A, 620A & 650A

PART REAR MC-40 SUPPORT ASS'Y

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

DEPT. M QTY. 1

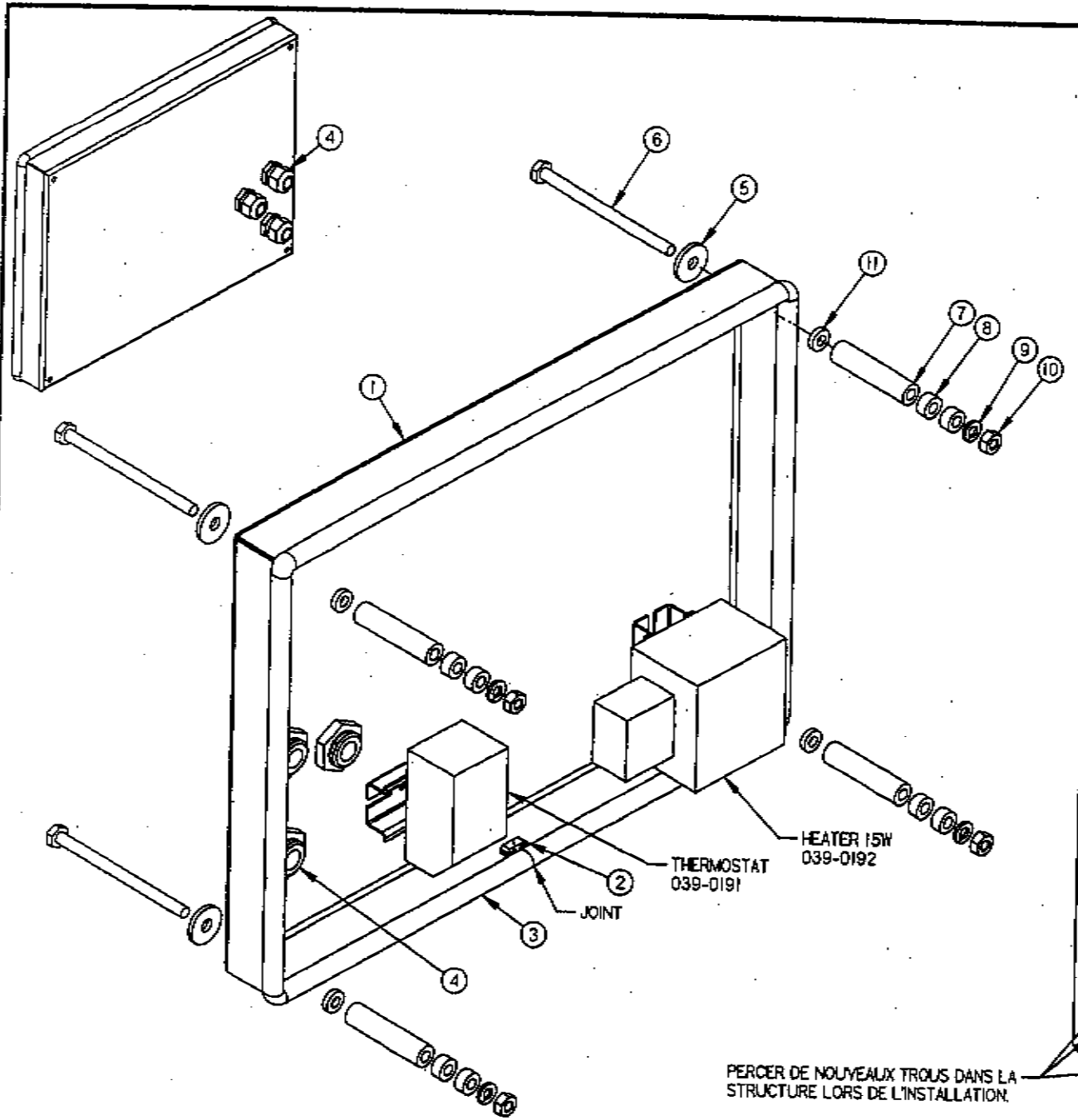
DWG BY M.A.L. DATE 05-09-01

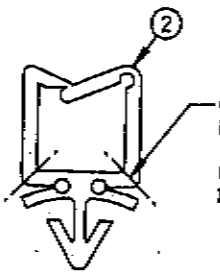
APP. BY DATE 06-10-24

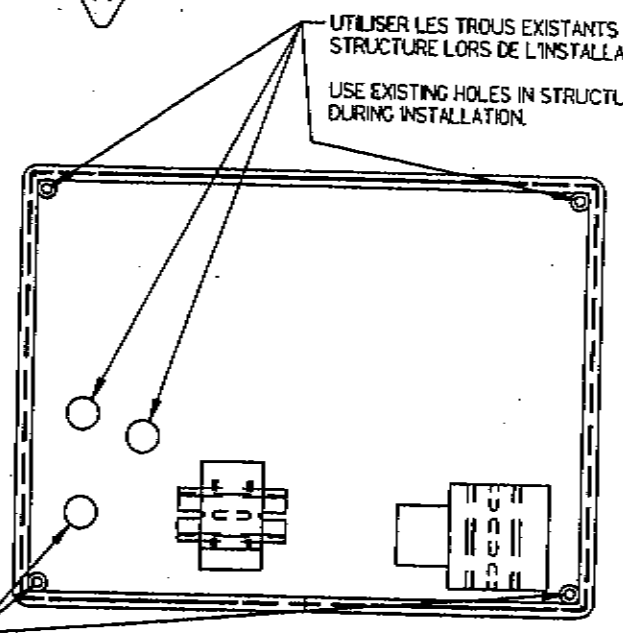
NO. 005A0584

005A0780

ITEM	PART #	DESCRIPTION	QT.
1	004A3167	REAR MC-40 SUPPORT PRE-ASS'Y	1
2	057-0002	CABLE CLAMPS 9mm (11,2 X 9,3)	1
3	179-0019	U-CHANNEL BLACK EPDM FOAM (4.5265)	1
4	036-0409	PRESSE-ETOUPE 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





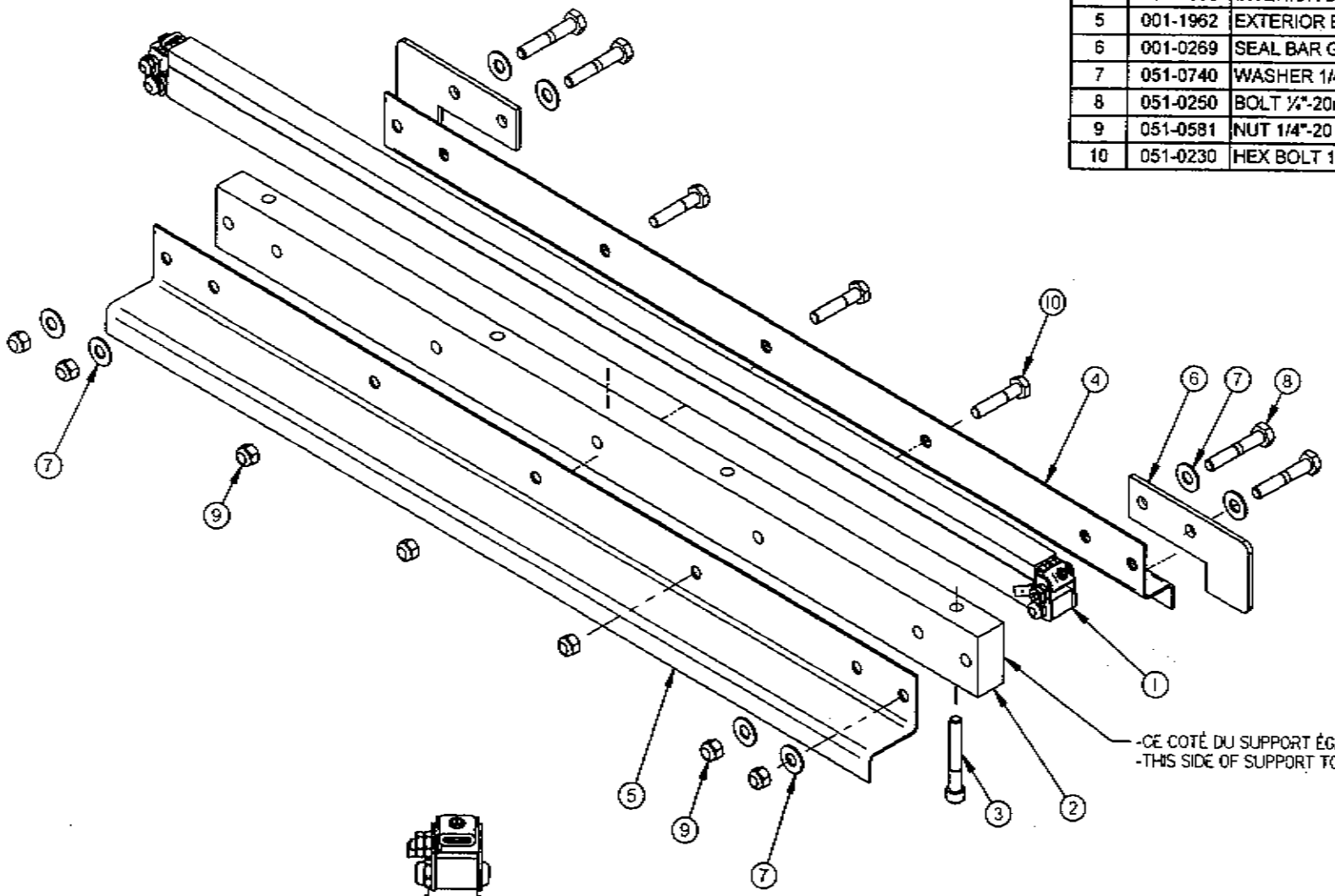


LET.	MODIFICATION	DATE	INT.
A	AJOUTER ITEM 058-0016 ET 058-0139 ETAIT 058-0140	10-09-01	J.G.

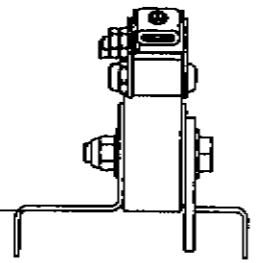
MACHINE	420A, 450A, 550A, 580A, 600A, 620A & 650A
PART	REAR MC-40 SUPPORT ASS'Y(OPT. HEATER)
ITEM	
MAT.	
DEPT.	M-(M)-H
QTY.	1
DRG BY	N.D.
DATE	10-02-03
NO.	005A0780

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

ITEM	PART #	DESCRIPTION	QT.
1	005A0152	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 BELLOWS COVER	1
5	001-1962	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	8
8	051-0250	BOLT ¼"-20nc. X 1½" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3



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



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

-END VIEW-

-TWIN SEAL OPTION -

600A	4
550A	2
MACHINE	QTY

MACHINE: **550A & 600A**
PART: **SEAL BAR ASS'Y W/SUPPORT**

DEPT. TOLÉRANCES	METRIC	INCH
USINAGE	± 0.1	± 0.005"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

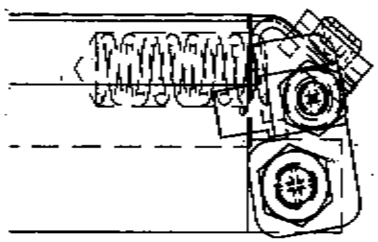
N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

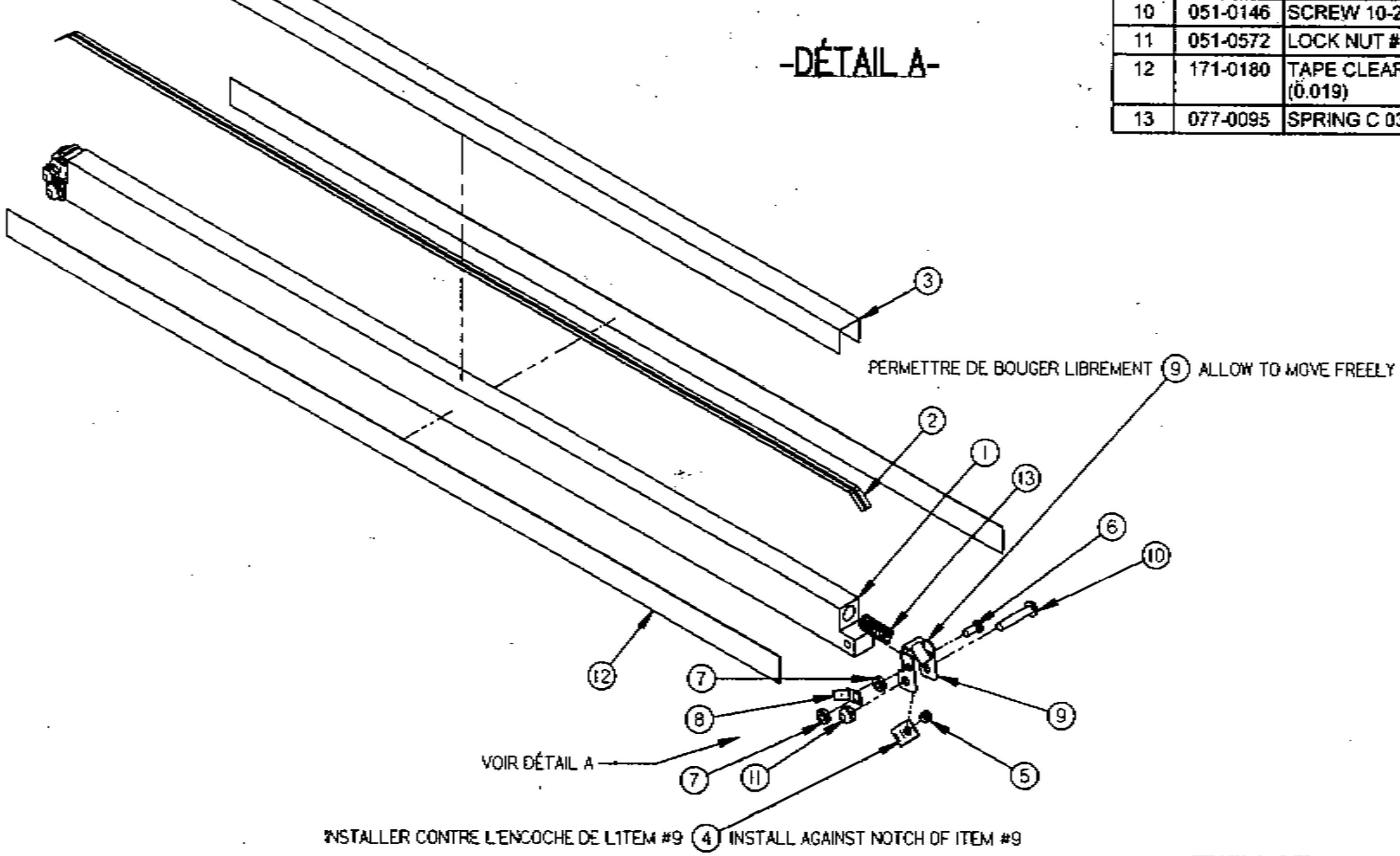
ITEM | CNC | DEPT. M-I-(M) | QTY LISTE
MAT. | DWG BY J.G. | DATE 11-08-30 | APP. BY | DATE | NO. 005A0568

LET.	MODIFICATION	DATE	INT.
E	ENLEVE 001A5692 ET 038-0230	12-06-19	S.B.
D	REDESSINE - AJOUTER 001A5692	11-08-30	J.G.

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-



-TWIN SEAL OPTION-

MACHINE	QTY
600A	4
550A	2

MACHINE: 550A & 600A

PART: SEAL BAR PRE-ASS'Y

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

DEPT.: M-(M)-I — QTY: LISTE

DWG BY: M.A.L. — DATE: 05-09-13

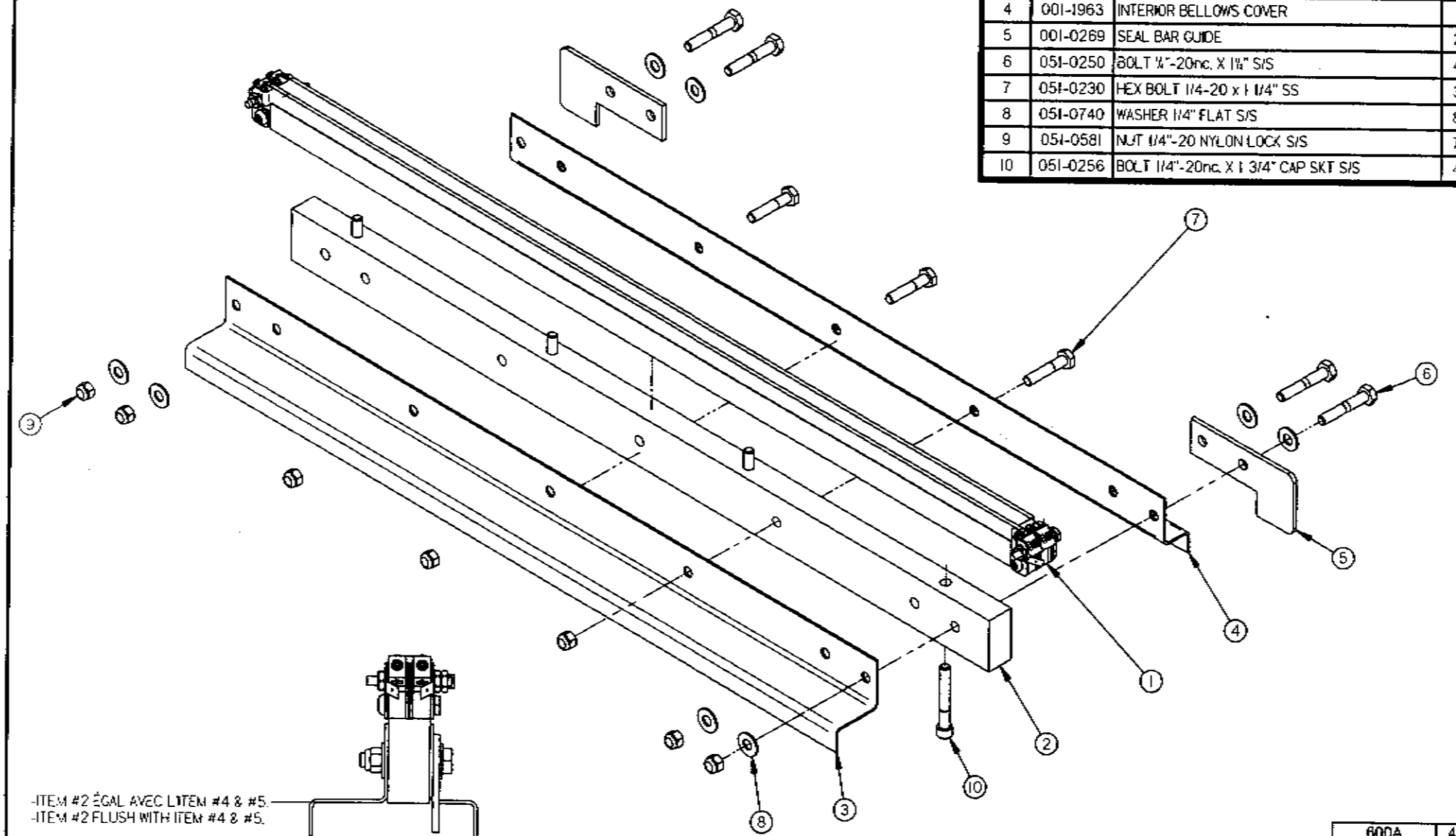
APP. BY: — DATE: 10-09-02

NO.: 005A0152

LET.	MODIFICATION	DATE	INT.
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.

005E0569

ITEM	PART #	DESCRIPTION	QT.
1	005E0153	SEAL BAR PRE-ASS'Y	1
2	002A4187	SEAL BAR SUPPORT (ECO)	1
3	001-1962	EXTERIOR BELLOWS COVER	1
4	001-1963	INTERIOR BELLOWS COVER	1
5	001-0269	SEAL BAR GUIDE	2
6	051-0250	BOLT ¼"-20nc. X 1¾" S/S	4
7	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3
8	051-0740	WASHER 1/4" FLAT S/S	8
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4



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

-END VIEW-

-BAG CUT OPTION-

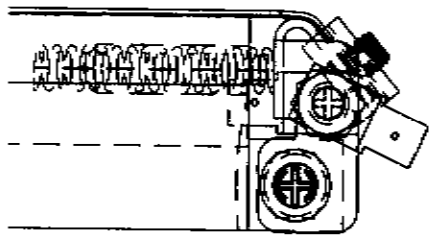
600A	4
550A	2
MACHINE	QTY

MACHINE: 550A & 600A
PART: SEAL BAR ASS'Y W/SUPPORT (ECO)
DEPT. TOL: USINAGE ± 0.5 ± 0.020"; TOLERIE ± 0.5 ± 0.020"; SOUDAGE ± 0.5 ± 0.020"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM | CNC | DEPT. M-I-(M) LISTE
MAT | DWG BY S.L. DATE 14-02-05 | APP. BY DATE | NO 005E0569

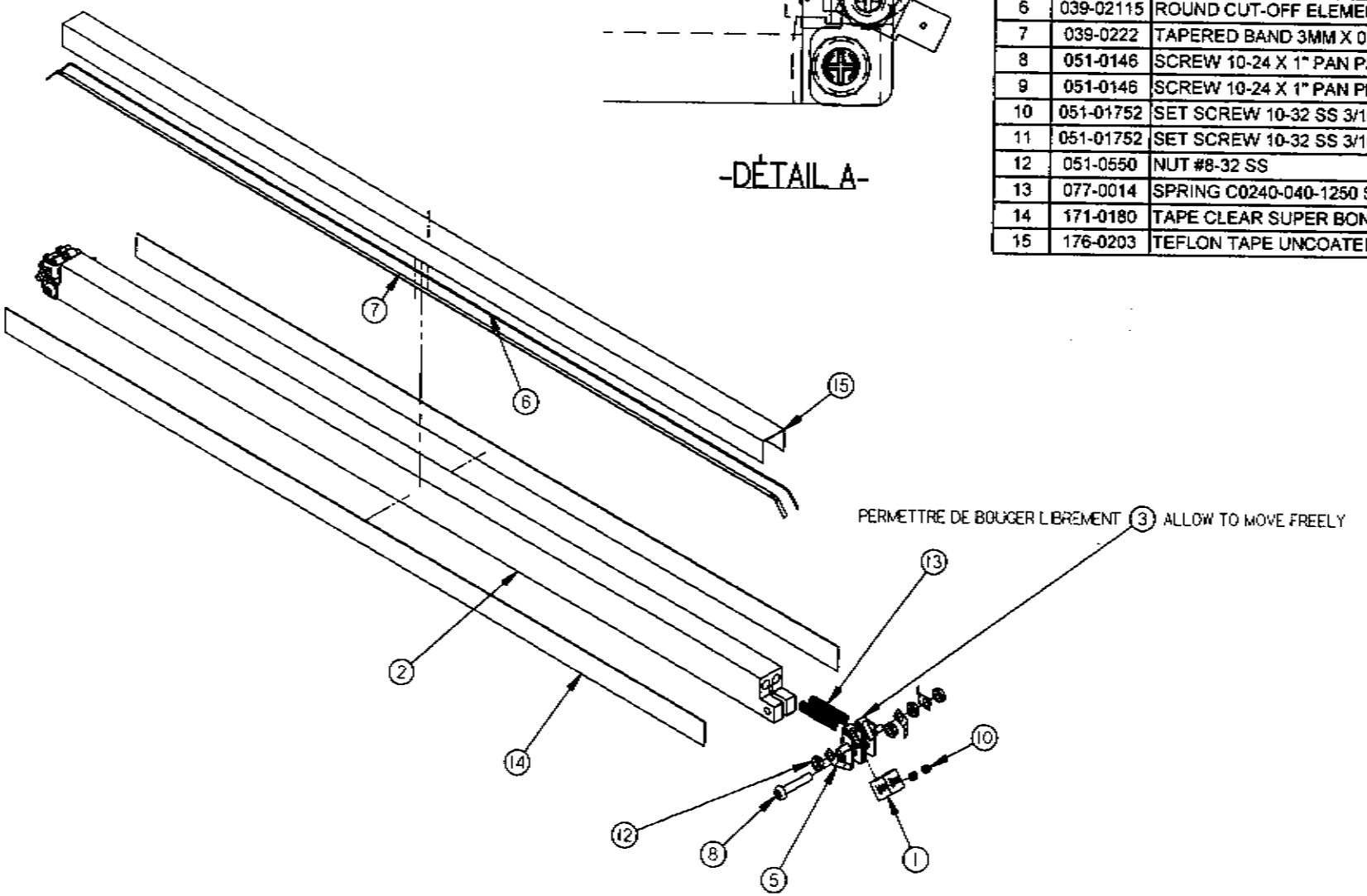
G	005D0153 WAS 005C0153	13-11-06	SBU
LET.	MODIFICATION	DATE	INT.

005E0153

ITEM	PART #	DESCRIPTION	QT.
1	002A4172	BANDING BUCKLE	4
2	002A4186	SEAL BAR	1
3	005A1443	ELEMENT BINDER RIGHT	2
4	005A1444	ELEMENT BINDER LEFT	2
5	027-0400	CONNECTOR ADAPTOR	6
6	039-02115	ROUND CUT-OFF ELEMENT 0.9MM	1
7	039-0222	TAPERED BAND 3MM X 0.3MM	1
8	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	1
9	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	1
10	051-01752	SET SCREW 10-32 SS 3/16"	2
11	051-01752	SET SCREW 10-32 SS 3/16"	2
12	051-0550	NUT #8-32 SS	8
13	077-0014	SPRING C0240-040-1250 SS COMP.	4
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2
15	176-0203	TEFLON TAPE UNCOATED ZONE 5MIL (0.78)	1



-DÉTAIL A-



-BAG CUT (ECO) -

MACHINE	QTY
600A	4
550A	2

MACHINE: 550A & 600A

PART: SEAL BAR PRE-ASS'Y

DEPT. TOLERANCE: METRIC / INCH
USINAGE ± 0.1 / ± 0.004
TOLÉRIE ± 0.5 / ± 0.020
SOUDAGE ± 0.5 / ± 0.020

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM QUÉBEC CANADA

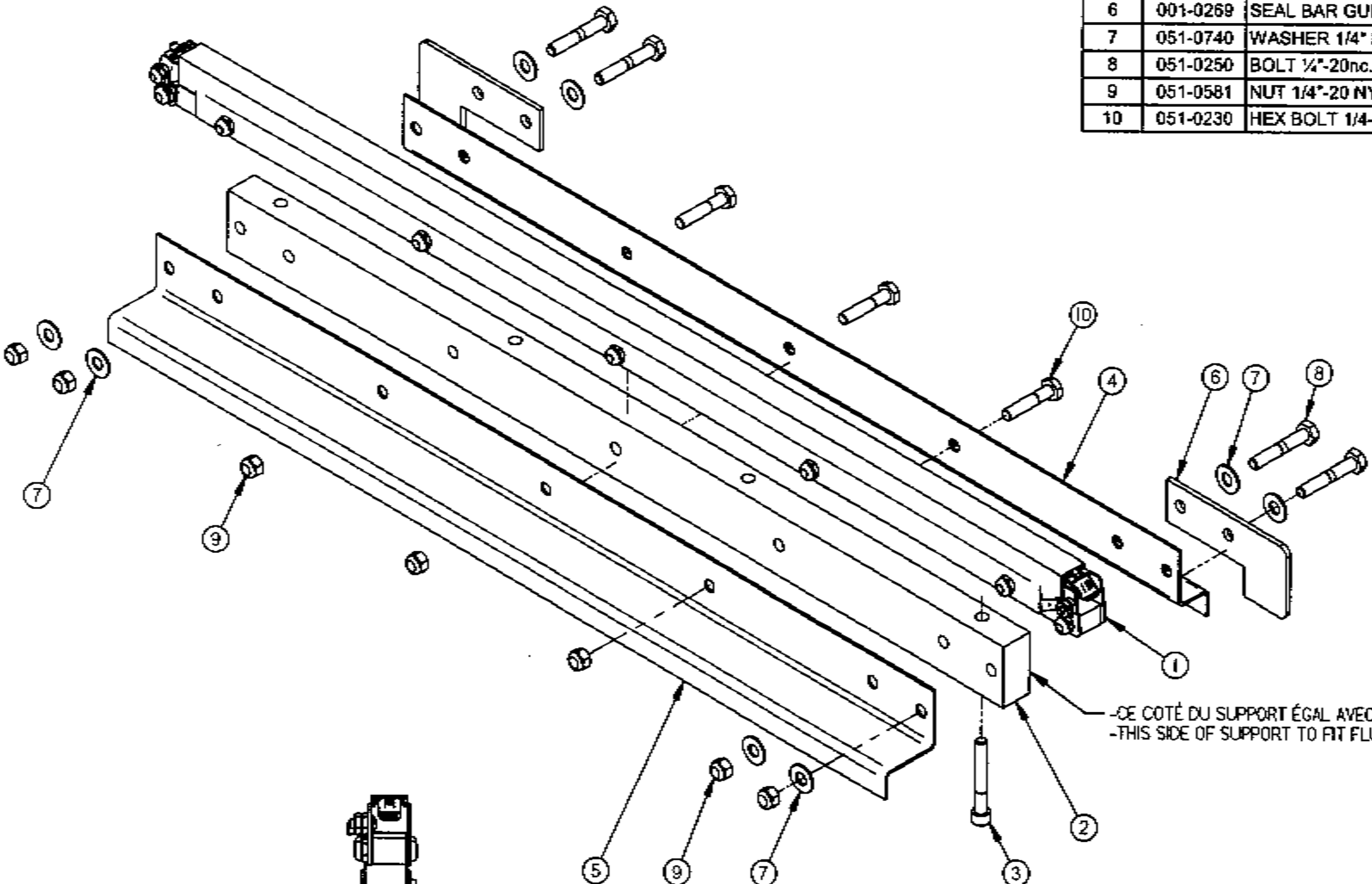
ITEM | CNC | DEPT. M-(M)-I | QTY LISTE

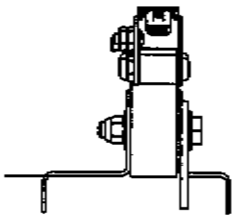
MAT | DWG BY S.L. | DATE 14-02-12 | APP BY | DATE | NO. 005E0153

LET.	MODIFICATION	DATE	INT.

005B0570

ITEM	PART #	DESCRIPTION	QT.
1	005B0370	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 BELLOWS COVER	1
5	001-1962	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	8
8	051-0250	BOLT ¼"-20nc. X 1½" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3





-END VIEW-

-TOP & BOTTOM SEALING OPTION-

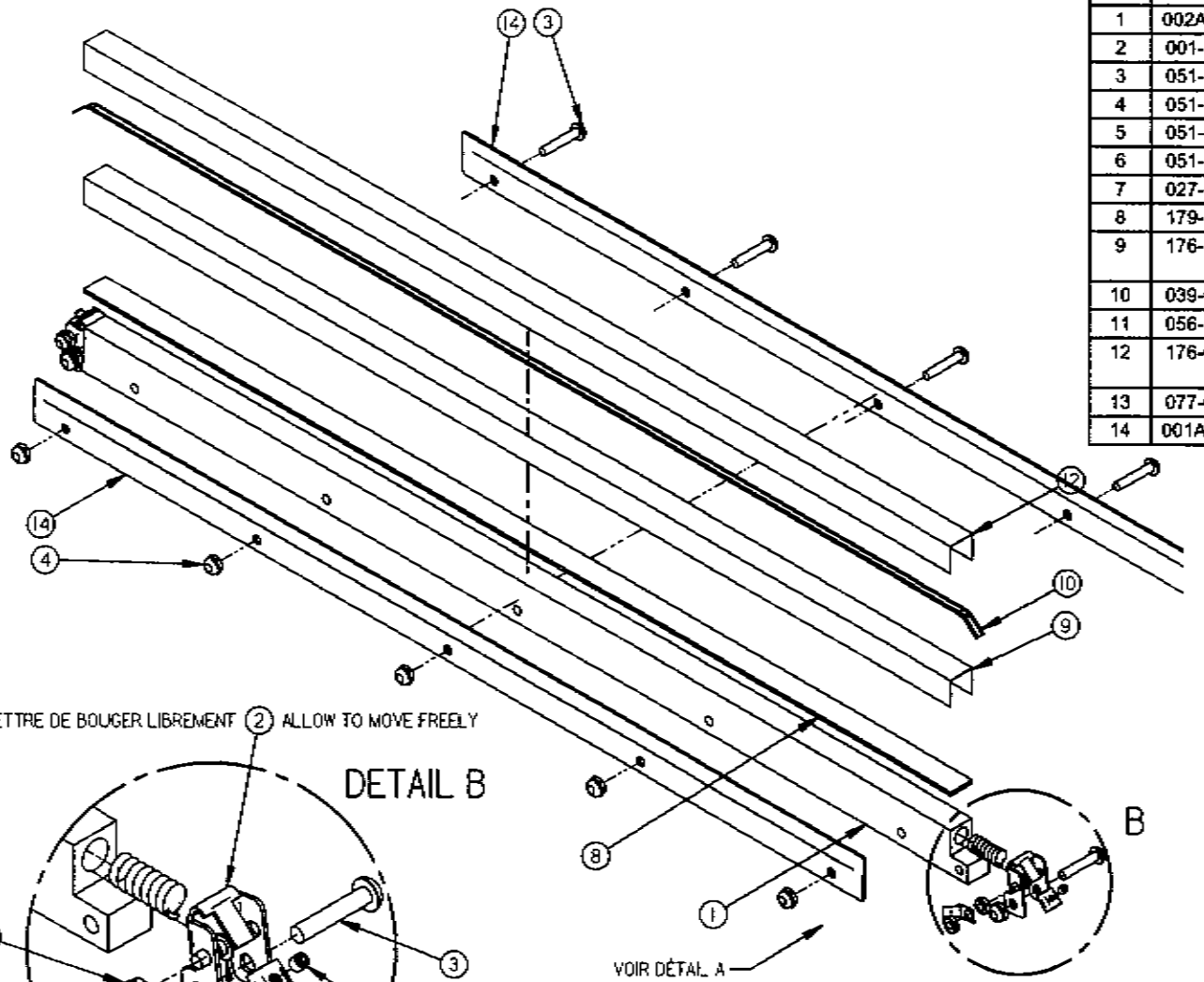
MACHINE	QTY
600A	4
550A	2

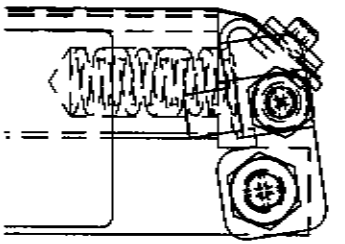
MACHINE: 550A & 600A			SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: SEAL BAR ASS'Y W/SUPPORT		N.T.S.	
ITEM	CNC		DEPT. M-I-(M) / QTY LIST
MAT.	DWG BY SBU / APP. BY	DATE 13-09-25	NO. 005B0570

LET.	MODIFICATION	DATE	INT.
E	005B0370 WAS 005A0370	13-09-25	SBU

005B0370

ITEM	PART #	DESCRIPTION	QT.
1	002A4146	SEAL BAR	1
2	001-2666	ELEMENT BINDER	2
3	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	7
4	051-0572	NUT #10-24 NYLON LOCK S/S	7
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	176-0203	TEFLON TAPE, 5MIL UNCOATED ZONE 641.5mm (0.064)	1
13	077-0095	SPRING C 0360-059-1250 S/S	2
14	001A6580	TEFLON HOLD DOWN PLATE	2

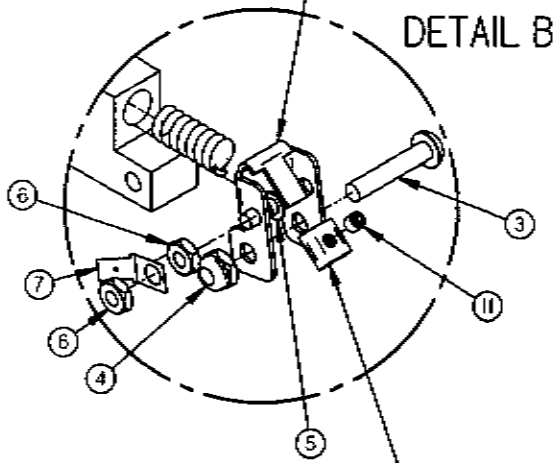




-DÉTAIL A-

PERMETTRE DE BOUGER LIBREMENT (2) ALLOW TO MOVE FREELY

DETAIL B



INSTALLER CONTRE L'ENCOCHE DE L'ITEM #2 (11) INSTALL AGAINST NOTCH OF ITEM #2

-TOP & BOTTOM SEALING OPTION-

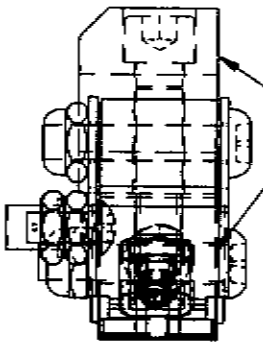
MACHINE	QTY
600A	4
550A	2

MACHINE: 550A & 600A	DIMENSIONS: UNLESS OTHERWISE SPECIFIED USINAGE ± 0.1 ± 0.004 TOLERIE ± 0.5 ± 0.020 SOUDAGE ± 0.5 ± 0.020	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART: SEAL BAR PRE-ASS'Y	N.T.S.		
ITEM	CRC	DEPT. M-(M)-I	QTY. LISTE
MAT.	DWG BY SBU DATE 13-09-25	APP. BY DATE	NO. 005B0370

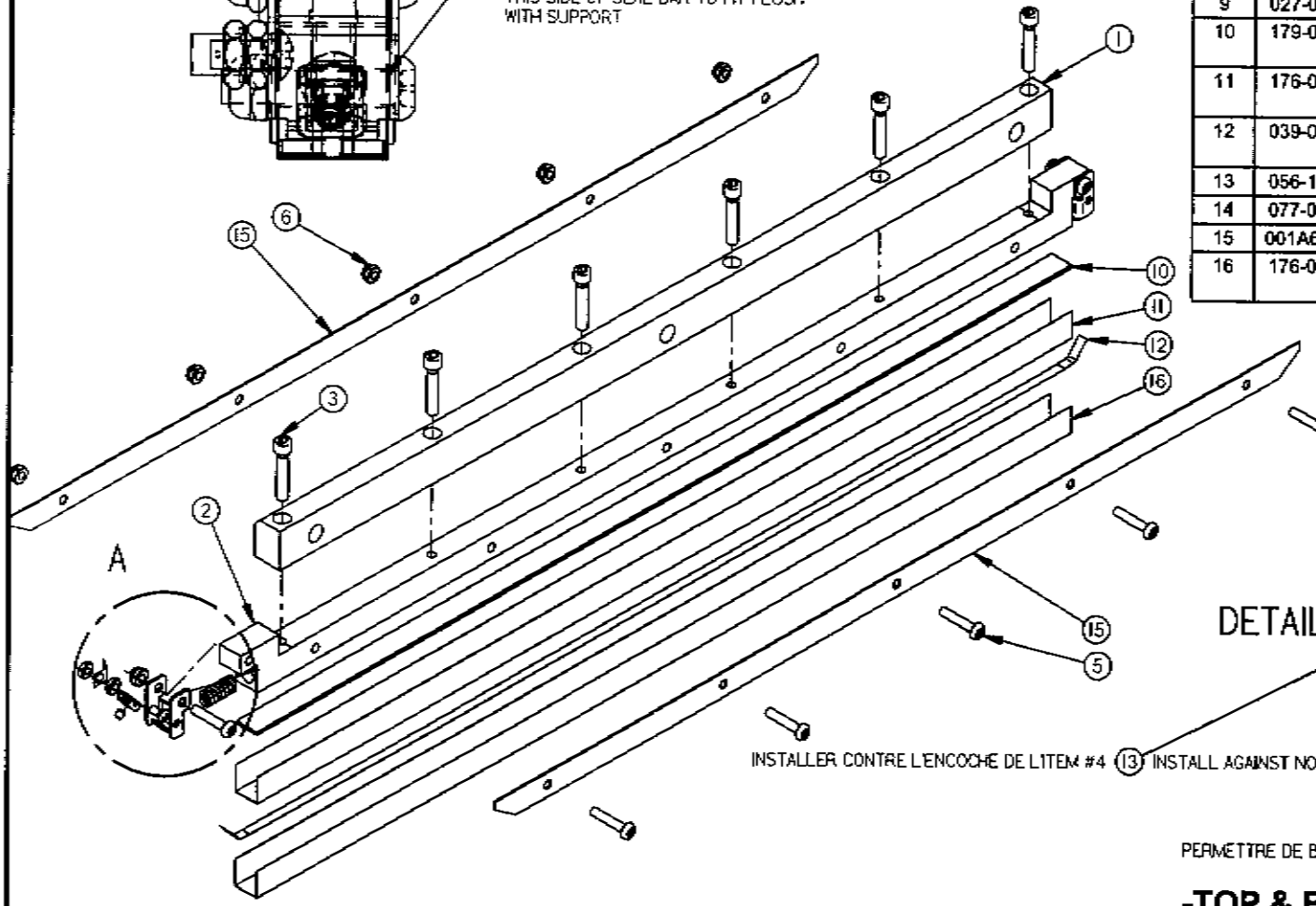
G	AJOUT TEFLON HOLDER	13-09-25	SBU
LET.	MODIFICATION	DATE	INT.

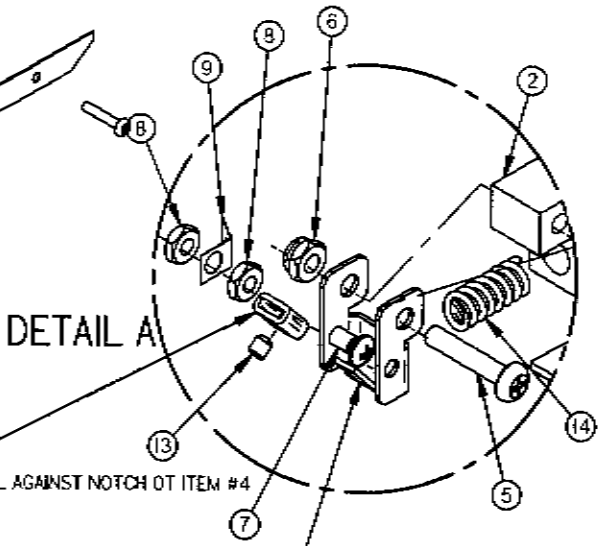
005C0371

ITEM	PART #	DESCRIPTION	QT.
1	002A0537	UPPER SEAL BAR SUPPORT	1
2	002B0538	UPPER SEAL BAR	1
3	051-0232	SCREW 1/4-20x 1-1/4"SKT CAP SS	6
4	001-2666	ELEMENT BINDER	2
5	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	7
6	051-0572	NUT #10-24 NYLON LOCK S/S	7
7	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
8	051-0550	NUT #8-32 SS	4
9	027-0400	CONNECTOR ADAPTOR	2
10	179-0003	SILICONE 2mm x 15mm ADHESIVE 617mm (0.62)	1
11	176-0220	TEFLON TAPE,PRESS.SENSITIVE 2" 617mm (0.07)	1
12	039-0220	BI-ACTIVE SEALING ELEMENT (6mm) 660mm (0.066)	1
13	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
14	077-0095	SPRING C 0360-059-1250 S/S	2
15	001A6584	UPPER TEFLON HOLDER	2
16	176-0203	TEFLON TAPE, UNCOATED ZONE 5 MIL 617mm (0.07)	1



CE COTÉ DE LA BARRE DOIT ÊTRE ÉGAL AU SUPPORT
THIS SIDE OF SEAL BAR TO FIT FLUSH WITH SUPPORT





PERMETTRE DE BOUGER LIBREMENT 4 ALLOW TO MOVE FREELY

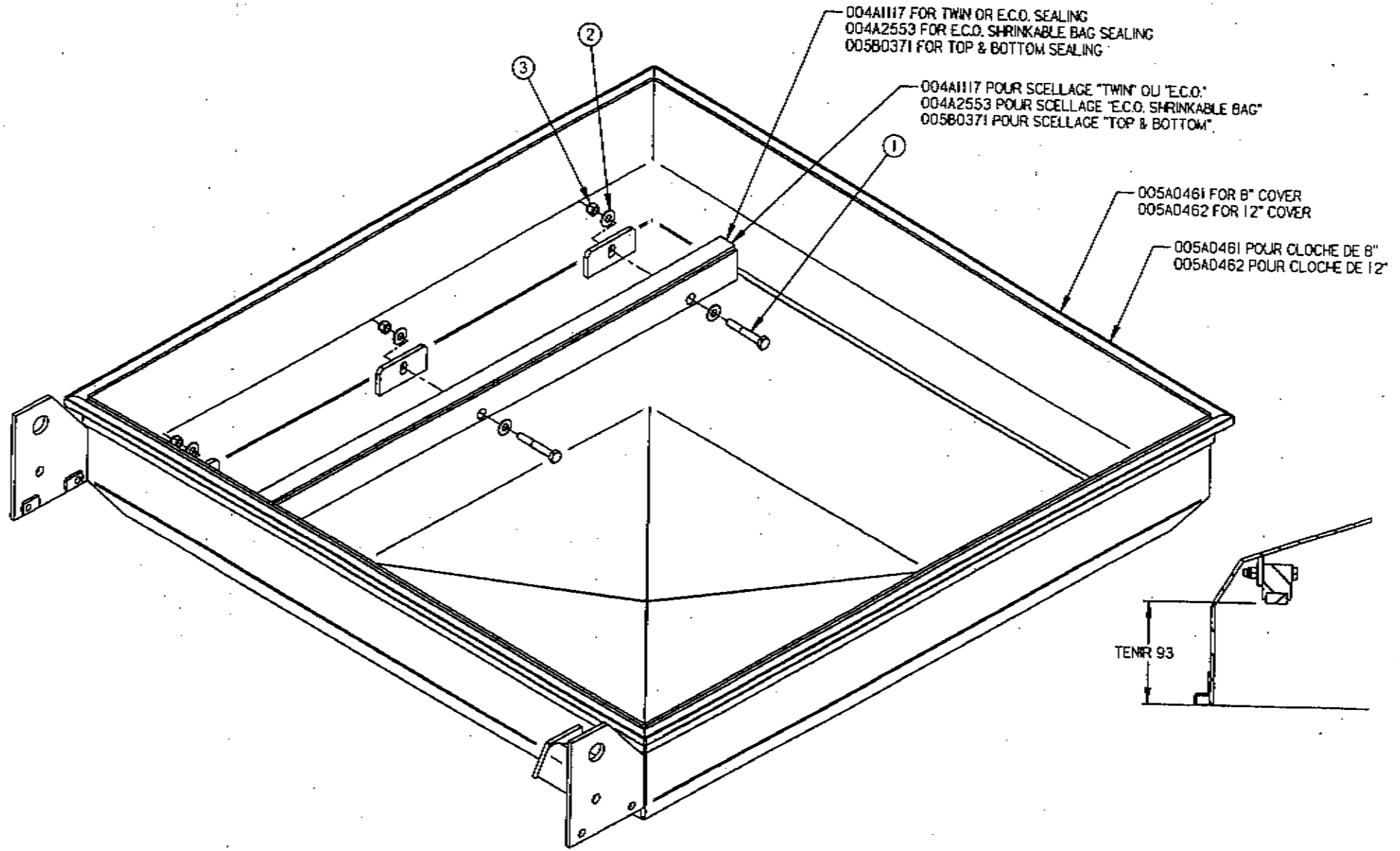
-TOP & BOTTOM SEALING OPTION-

LET.	MODIFICATION	DATE	INT.
G	AJOUT TEFLON HOLDER	13-09-26	SBU

MACHINE: 550A	DEPT TOL: USINAGE ± 0.1 / TOLERIE BOUDAGE ± 0.5	INCH: ± 0.004" / ± 0.020" / ± 0.020"	SIPROMAC ST-GERMAIN-DE GRANTHAM QUEBEC CANADA
PART: UPPER SEAL BAR ASS'Y W/SUPPORT		N.T.S.	
ITEM:	CNC:	DEPT: M-(M)-I	QTY: 2
MAT.:	DWG BY: SBU	DATE: 13-09-26	NO. 005C0371
	APP. BY:	DATE:	

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

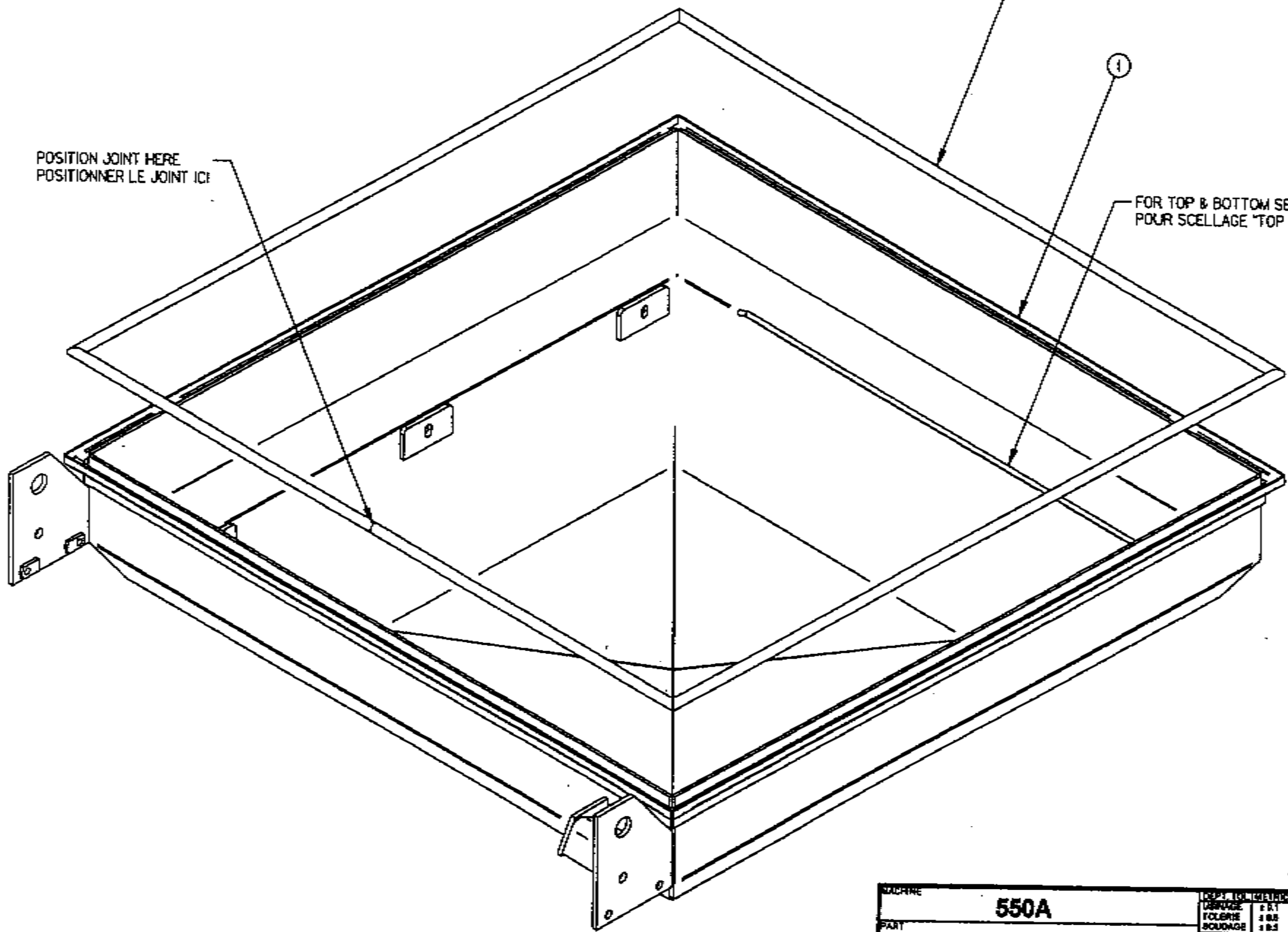


LET.	MODIFICATION	DATE	INT.
A	MODIF. #A-0444 ETAIT 005-0461 & 005-0462	09-01-06	J.G.

MACHINE: 550A
PART: UPPER SEAL BAR INSTALLATION
USINAGE / TOLERIE / SOUDAGE
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM
DWG
DEPT. M-I
QTY. 1
MAT.
DRWG BY J.G.
DATE 09-01-06
PG 010A0064

005A0461

ITEM	PART #	DESCRIPTION	QT.
1	004A0134	8" COVER PRE-ASSEMBLY	1
2	179-0020	NEOPRENE SPONGE 1/2" x 10.2'	1



LET.	MODIFICATION	DATE	INT.
B	REDESSINE MODIF. #A-0444 / VOIR AUSSI 010A0064	09-01-06	J.G.

MACHINE: 550A		N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: 8" COVER ASSEMBLY		DEPT.: M-I	QTY.: 1
DRAWN BY: J.G.	DATE: 09-01-06	NO.: 005A0461	
APP. BY:	DATE: 09-02-23		

005A0462

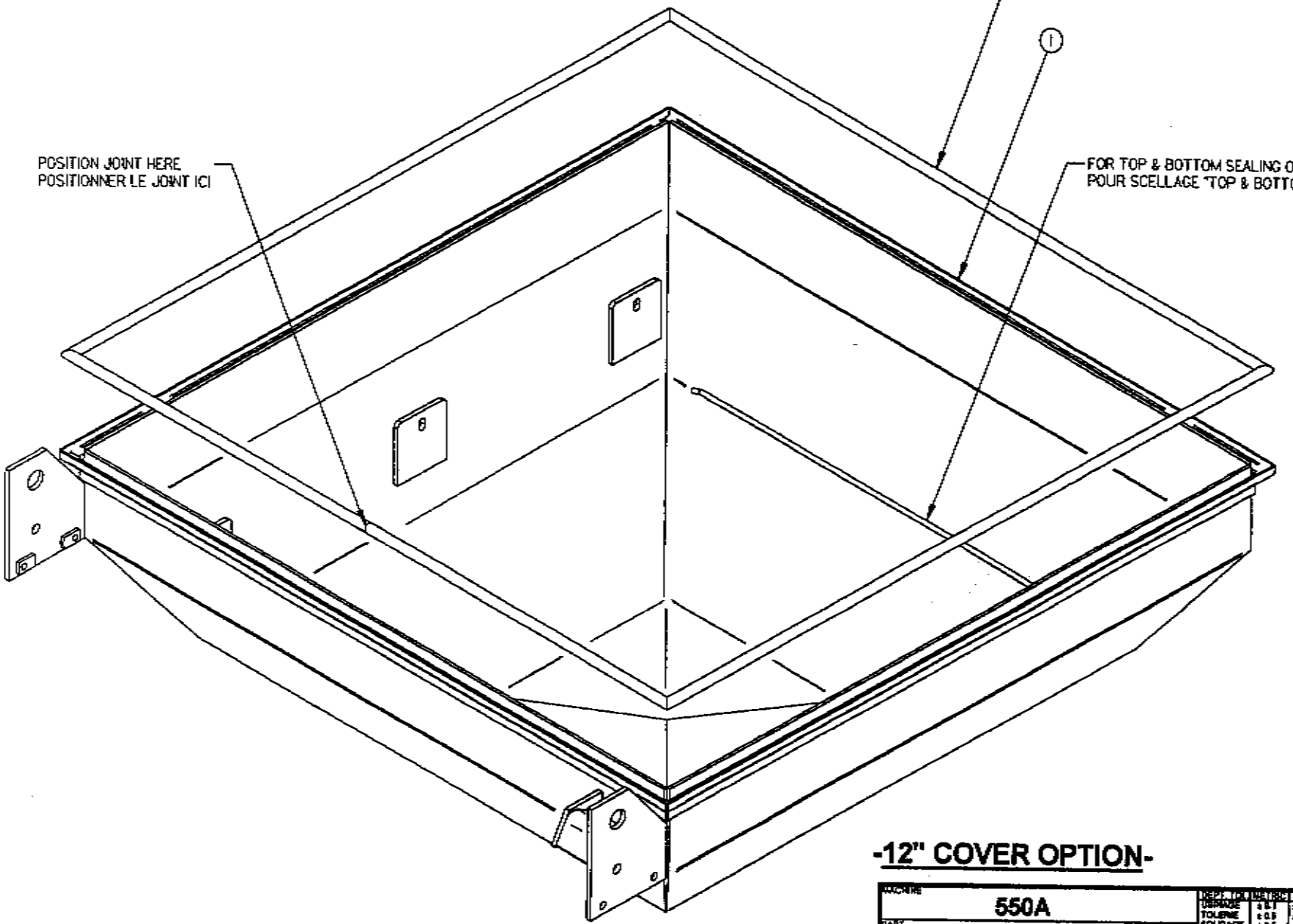
ITEM	PART #	DESCRIPTION	QT.
1	004A0135	12" COVER PRE-ASSEMBLY	1
2	179-0020	NEOPRENE SPONGE 1/2" x 10.2'	1

USE PERMATEX RUBBER ADHESIVE 169-0010 TO GLUE (2) UTILISER PERMATEX RUBBER ADHESIVE 169-0010 POUR COLLER

(1)

POSITION JOINT HERE
POSITIONNER LE JOINT ICI

FOR TOP & BOTTOM SEALING ONLY
POUR SCELLAGE "TOP & BOTTOM" SEULEMENT



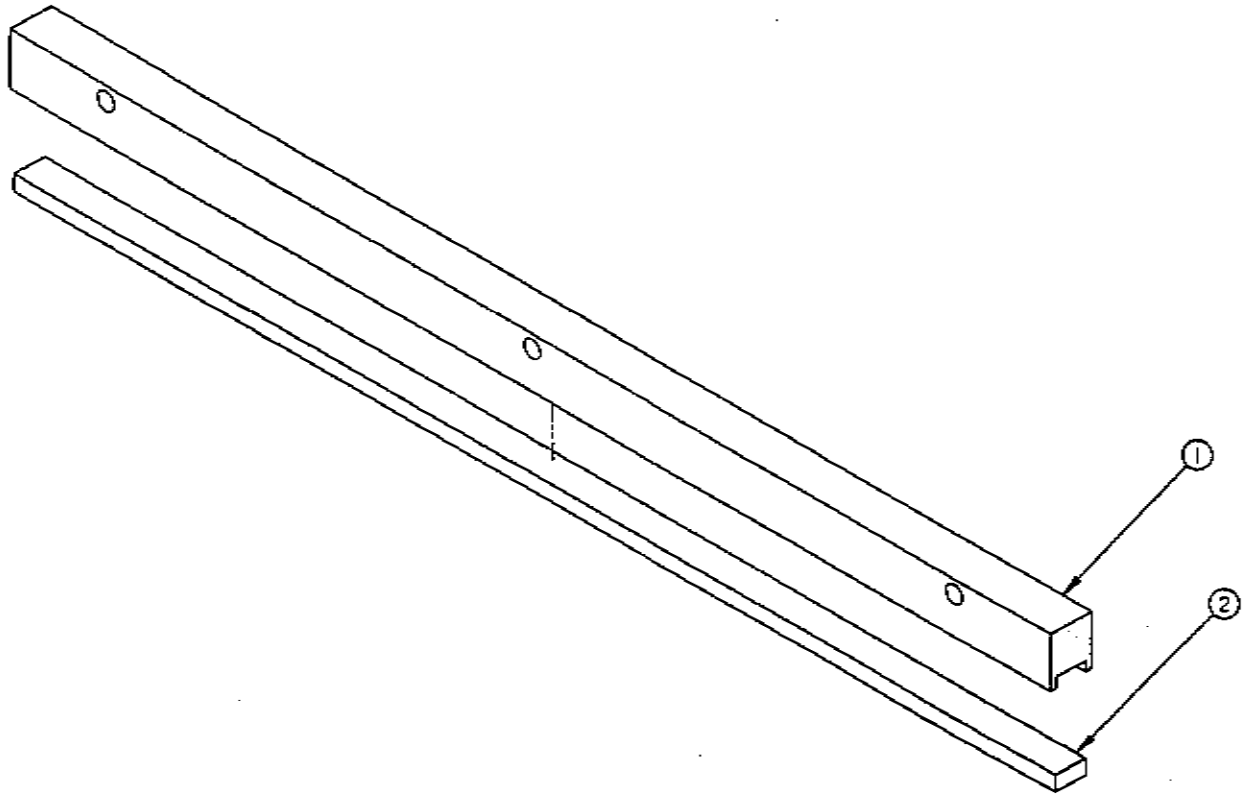
-12" COVER OPTION-

LET.	MODIFICATION	DATE	INT.
B	REDESSINE MODIF. #A-0444 / VOIR AUSSI 010A0064	09-01-06	J.G.

MACHINE: 550A	DEPT. TOL. USINAGE / TOLERIE / SOUDAGE	METRIC / INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: 12" COVER ASSEMBLY		N.T.S.	
ITEM	CRC	DEPT. M-I	QTY. 1
MAT.	DWG BY J.G. DATE 09-01-06	APP. BY DATE	NO. 005A0462

004A1117

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



-BAG CUT OPTION & TWIN-

LET.	MODIFICATION	DATE	INT.
B	MODIF. #A-0444 / AJOUTER TWIN ETAIT 004A0132	09-01-05	J.G.
A	REDESSINE VOIR AUSSI 004A2553 & 004A2554	08-04-30	J.G.

MACHINE: 550A

PART: UPPER SEAL BAR ASSEMBLY (E.C.O.) & (TWIN)

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

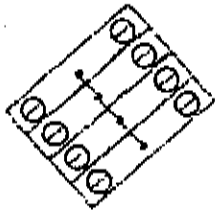
ITEM | QTY: 2

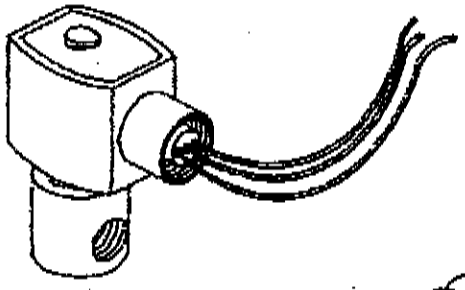
MAT. | DEPT: M-H

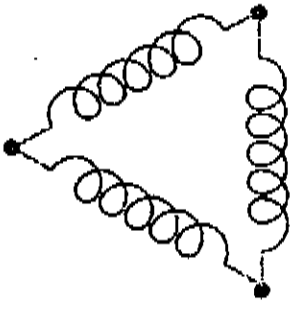
DWN BY: J.G. | DATE: 08-04-30

APP. BY: | DATE: 09-02-25

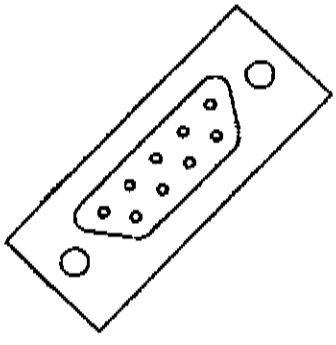
NO. 004A1117





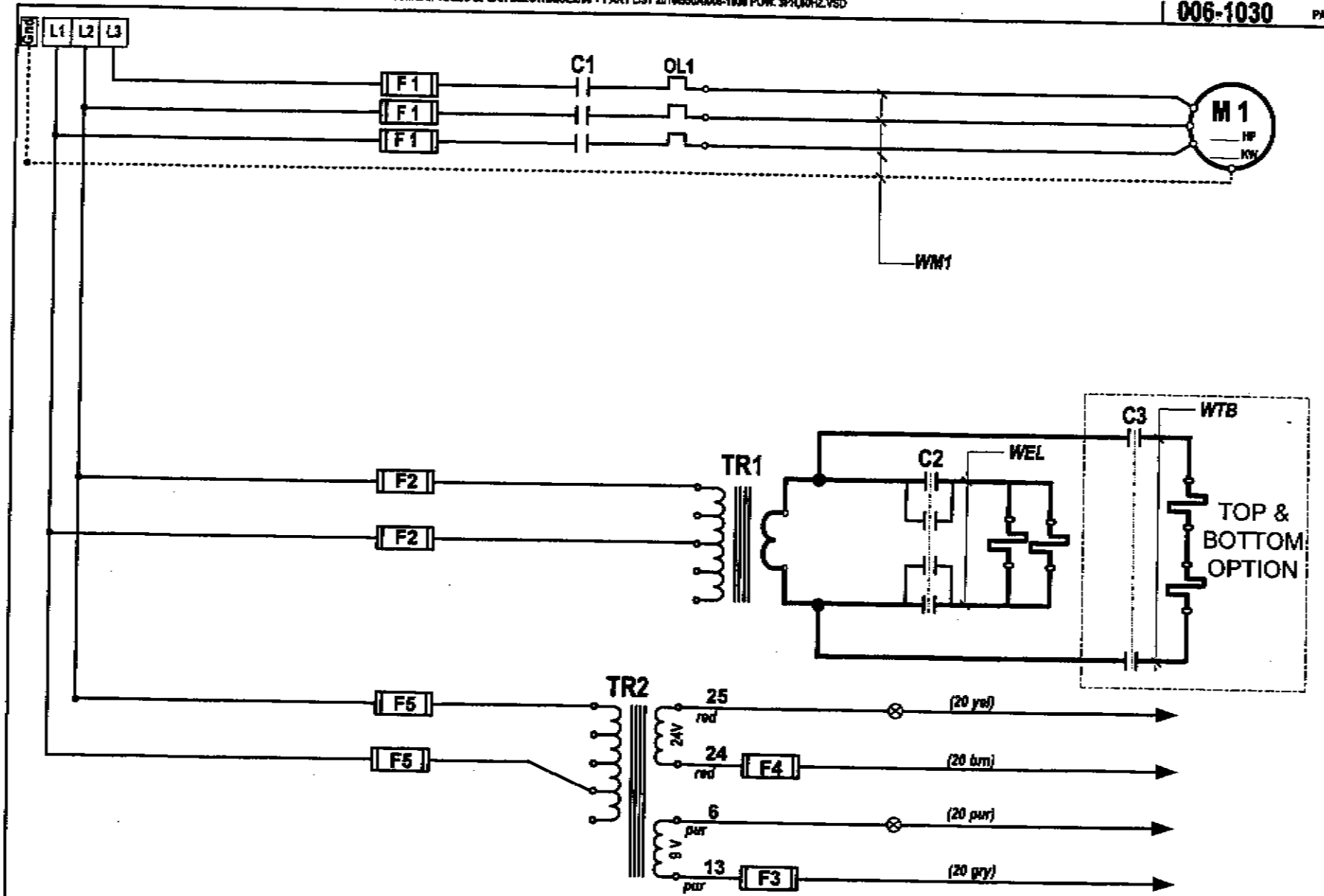


ELECTRICAL DRAWING

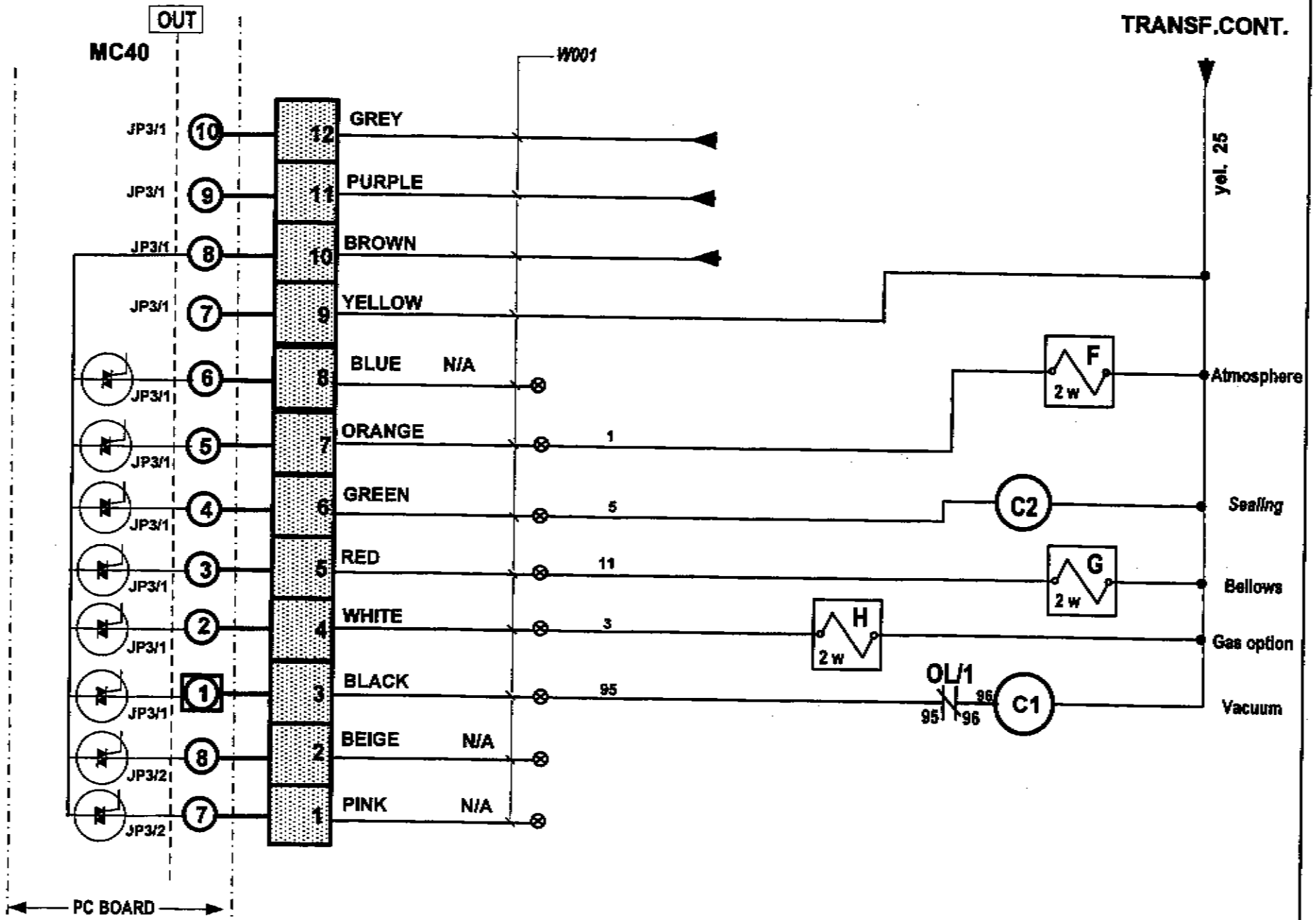


FULL FILENAME H:\DESSIN\DEPT\DESS-2\PLAN ÉLECTRIQUE\006 + PART LIST 2010\550A\006-1030 PONK 3PH,60HZ.VSD

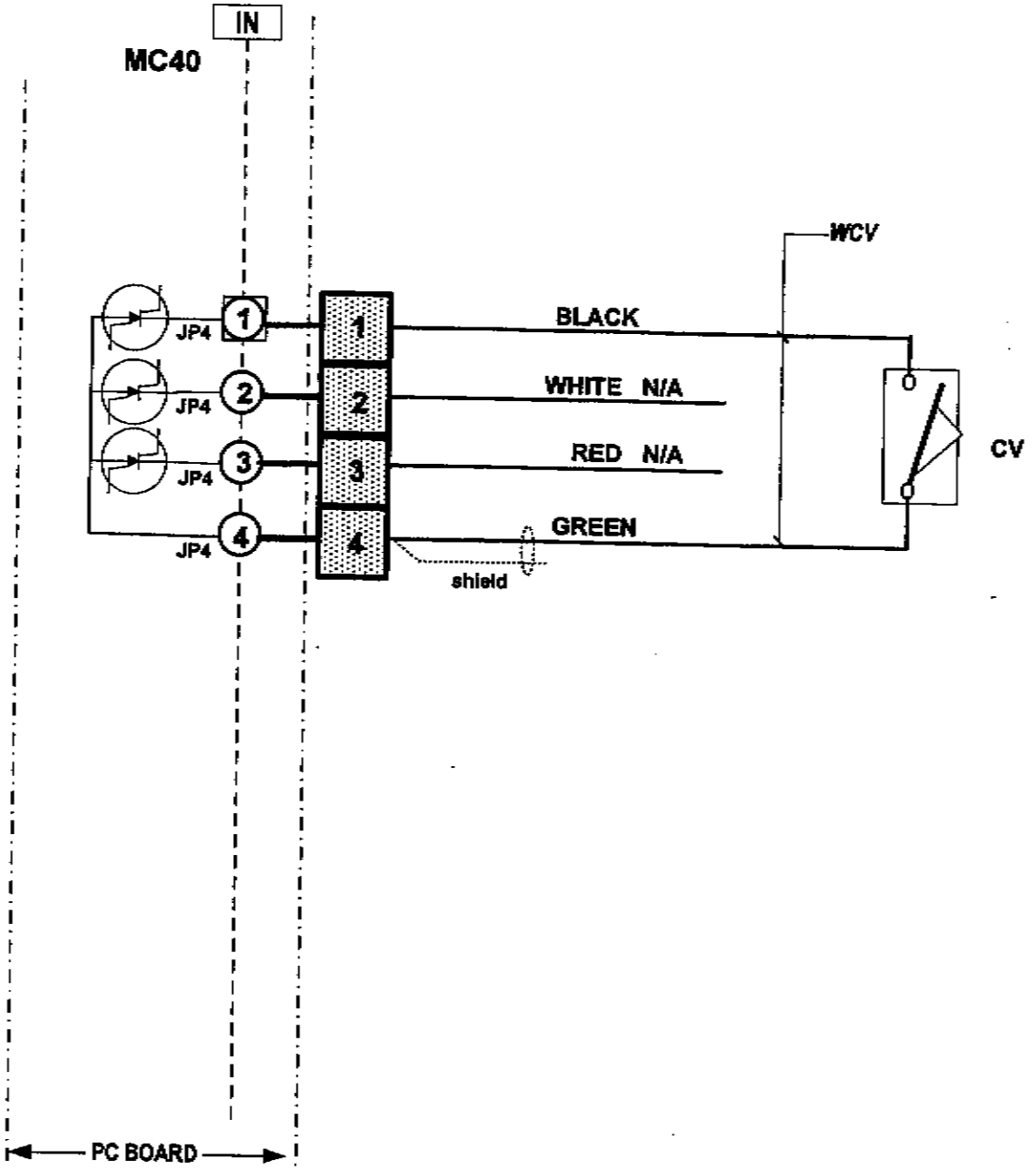
006-1030 PAGE 1 de 1



category: VACUUM PACK	model: 550A	volt: 3Ph 60Hz					SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system: MC-40		circuit: power	year: 10	month: 07	day: 08	block:	
usual functions:			concept: XX	draw: PP	app: DL	006-1030	PAGE 1 de 1
options:							



category: VACUUM PACK	model: 550A	ref.: ALL					SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system: MC-40		circuit: control	year: 10	month: 07	day: 08	block:	
manuf. functions:			concept: XX	draw: PP	app: DL	006-1037	PAGE 1 de 2
options:							

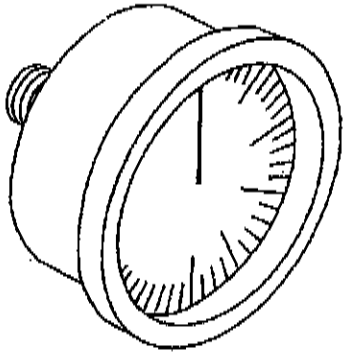


category: VACUUM PACK	model: 550A	volt: ALL			SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system: MC-40		circuit: control	year: 10	month: 07	day: 08	block:
seal:			concept: XX	draw: PP	app: DL	006-1037 PAGE 2 de 2
options:						

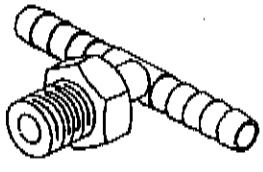
# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
028-0018	TERMINAL BLOCK M6/8 600V/50A,(8AWG)	SUPPLY	208V/3PH/60HZ	550A	L1-L2-L3		3
028-0020	GROUND TERMINAL BLOCK M6/8P	SUPPLY	208V/3PH/60HZ	550A	GND		1
028-0060	SEPARATOR M4/8	SUPPLY	208V/3PH/60HZ	550A	GND-L1-L2-L3		4
028-0105	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 3HP IN 208V/3PH-CSA,UL	VACUUM RA-0040	208V/3PH/60HZ	550A	C1	A1	1
026-0160	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 3HP 8.2A	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 3HP 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 13.8A	VACUUM RA-0100	208V/3PH/60HZ	550A	M1	A3	1
034-0700	FUSE HOLDER 30A/600V GOULD	SEALING	208V/3PH/60HZ	550A	F2		2
034-0460	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		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 6X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	208V/3PH/60HZ	550A	F5		2

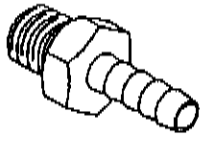
# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
029-0009	TRANSFO 65VA/208-230V/24-9V	CONTROL TRANSFO	208V/3PH/60HZ	550A	TR2		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	550A	F3+F4		2
034-0210	FUSE 6X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	550A	F3		1
034-0240	FUSE 6X20MM 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 3/4 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(G174)60HZ	BELLOWS	ALL	550A	G		1
026-0610	LIMIT SWITCH LONG ROLLER 3A 250V.	COVER POSITION	ALL	550A	CV		1
028-0018	TERMINAL BLOCK M6/8 600V/50A.(6AWG)	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 2.1 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 3HP 9.8A	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
025-0160	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 9.8A	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 5.6 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 6X20MM 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



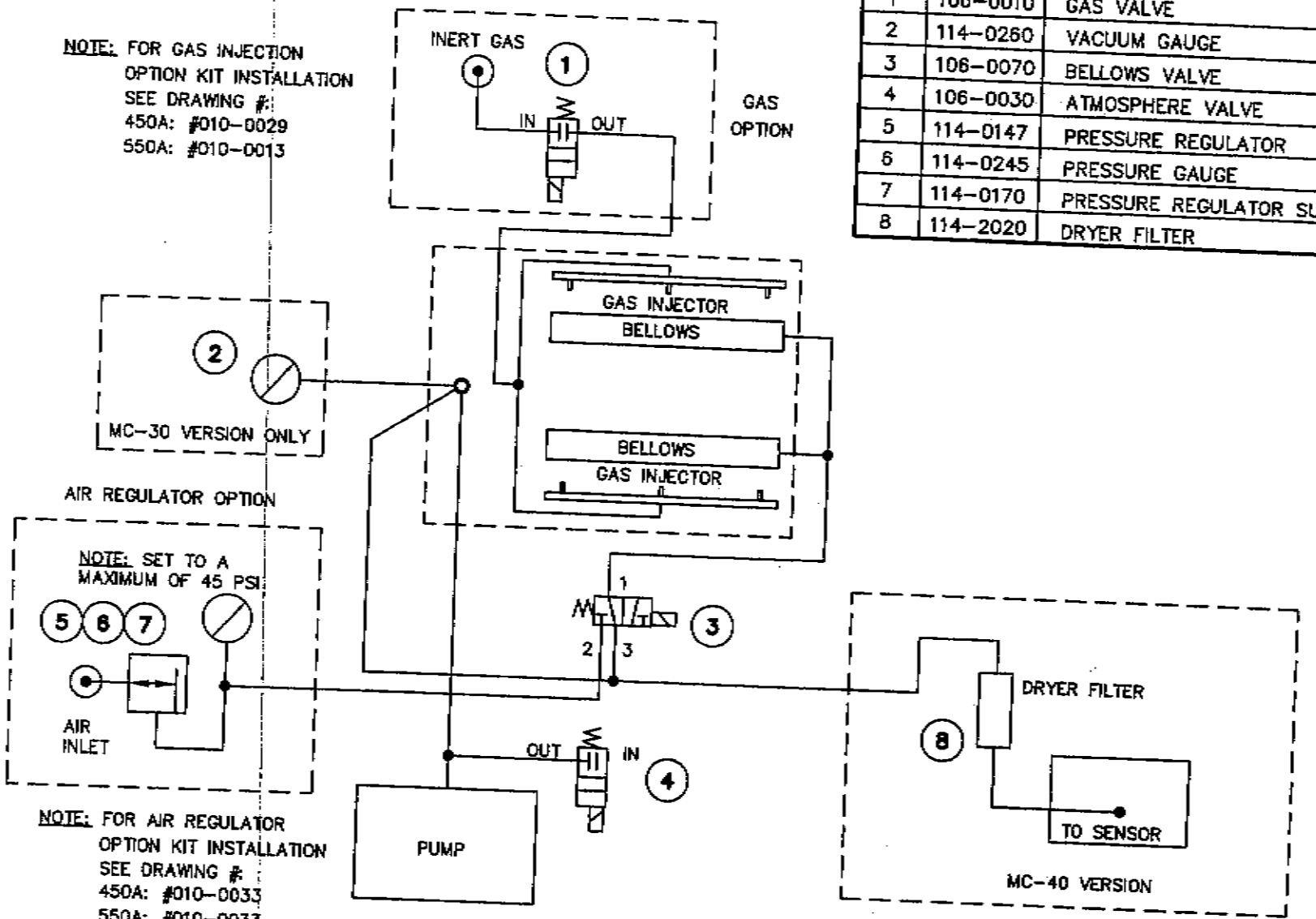
PNEUMATIC DRAWING





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



LET.	MODIFICATION	DATE	INT.
C	ADDED MC-40 AND DRYER	04-06-11	D.A.
B	RE-DRAWN	97-03-12	M.L.

MACHINE: 450A & 550A

PART: PNEUMATIC DRAWING

ITEM:

CNC:

MAT:

DWG BY: M.LAVIGNE

DATE: 97-03-12

APP.

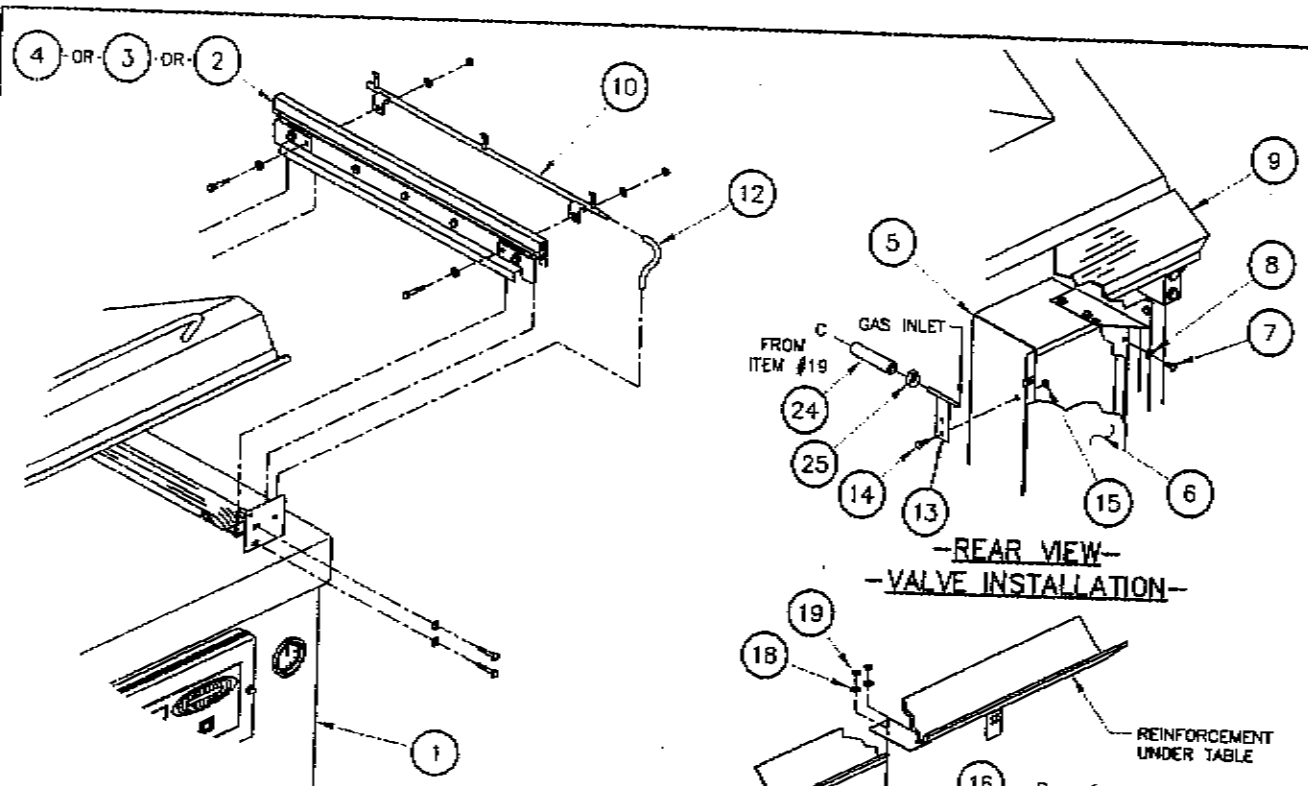
N.T.S.

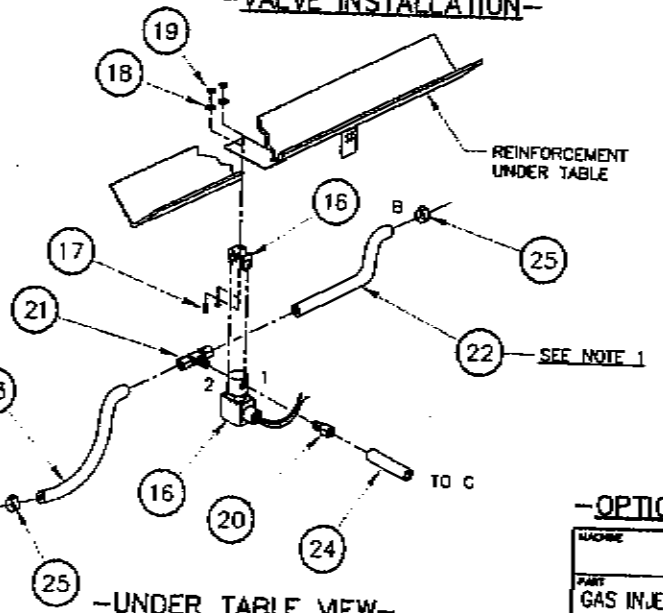
SCALE

QT. 1

NO.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA





ITEM	PART #	DESCRIPTION	QT.
1	005-0338	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0566	SEAL BAR ASS'Y W/ SUPPORT	2
3	005-0569	SEAL BAR ASS'Y W/ SUPPORT (BAG OUT 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"ø 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	101-0065	"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 1:
- THESE ITEMS MUST BE THE SAME LENGHT

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

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

-OPTION GAS INJECTION-

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

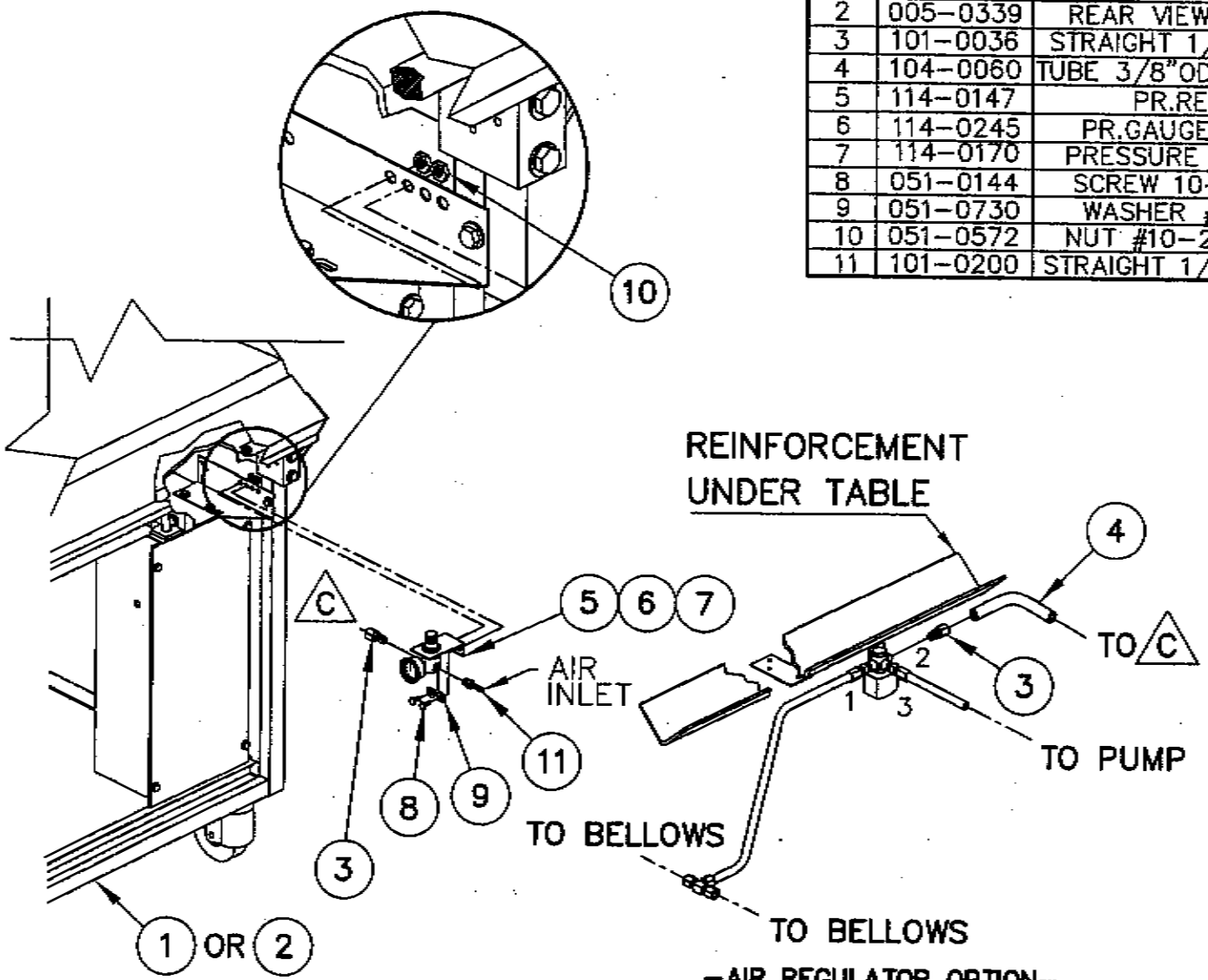
MACHINE	550A	METRIC TOLERANCE 0 ± .5 .0 ± .05 .00 ± .025 .000 ± .0005 ANGLE ± 1°	INCH TOLERANCE .0 ± .015" .00 ± .005" .000 ± .0005" N.T.S.
PART	GAS INJECTION KIT INSTALLATION		
TREA		DWG	M-P-I QT. 1
MAT		DES. A. PROMENCHER APP. L.T.	DATE 98-02-26 NO. 010-0013

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

010-0013

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"ODx1/4"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"MNPTx1/4"HOSE BARB	2



-AIR REGULATOR OPTION-

LET.	MODIFICATION	DATE	INT.
B	051-0144 WAS 051-0100, 051-0572 WAS 051-0560	05-05-05	M.A.L.
A	051-0100 WAS 051-0147, 051-0560 WAS 051-0572	05-03-23	M.A.L.

MACHINE: 450A & 550A

PART: AIR REGULATOR OPTION KIT INSTALLATION

ITEM:

MAT:

METRIC TOLERANCE	INCH TOLERANCE
0. ± .5	.0 ± .015"
.0 ± .05	.00 ± .005"
.00 ± .005	.000 ± .0005"
.000 ± .0005	
ANGLE ± 1°	N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

CNC:

DWG BY M.LAVIGNE DATE 97-10-07

APP. DATE 05-06-20

SCALE M-E QT. 1

NO. 010-0033

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 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. CONNECTION ÉLECTRIQUE:

Les connections 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 dur le moteur de la pompe.

3. OPÉRATION:

3.1 Principes de travail:

Un empaquetage 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 empaquetages, 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.

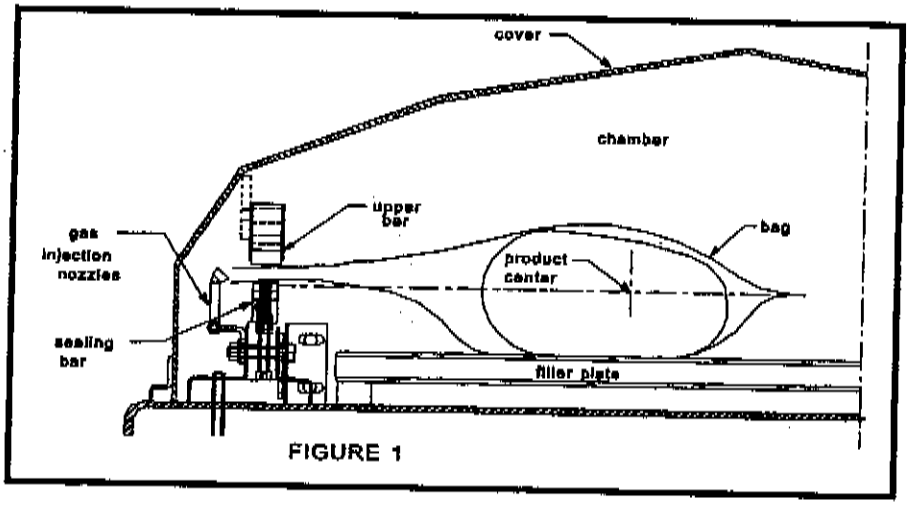


FIGURE 1

3.2 Empaquetage 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 empaquetés 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 adapteur 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'empaquetage 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 exécuter 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 function 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 utilisez 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).

Examples: 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 nécessité, 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:

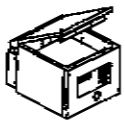
- niveau de vide de la chambre pendant la séquence,
- vide additionné du temps pendant le vide plus la séquence,
- niveau de vide de la chambre pendant la séquence d'injection de gaz,
- statut de temps de cachetage pendant la séquence de cachetage,
- niveau de vide de la chambre pendant La séquence d'atmosphère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

Pendant l'exécution du cycle, utilisé la clef "1" pour interrompre la séquence de vide et pour exécuter la séquence suivante, sois 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.

NOTES



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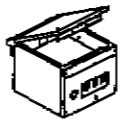

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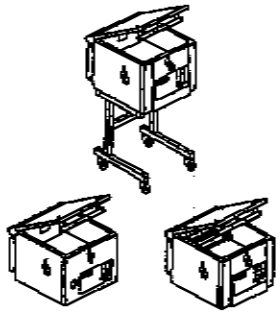

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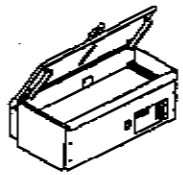

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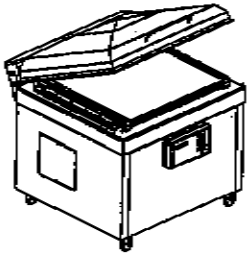

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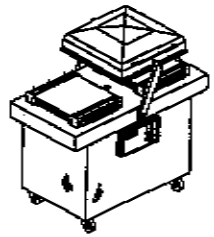
VACUUM PACKAGING MACHINES



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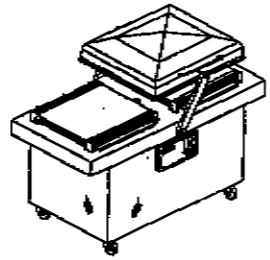

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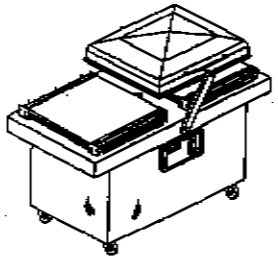

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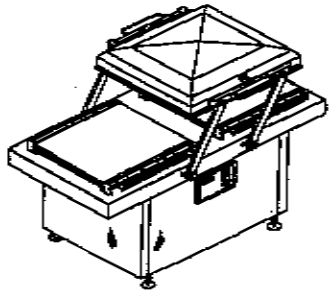

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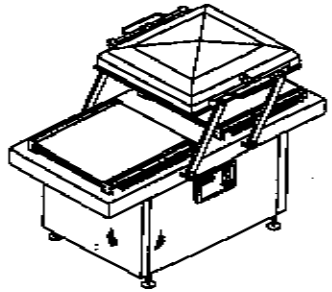

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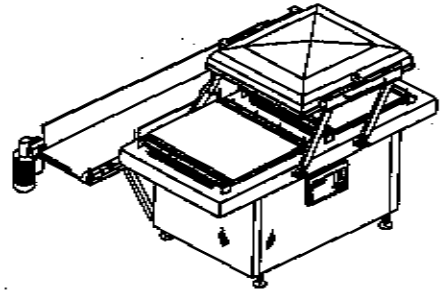

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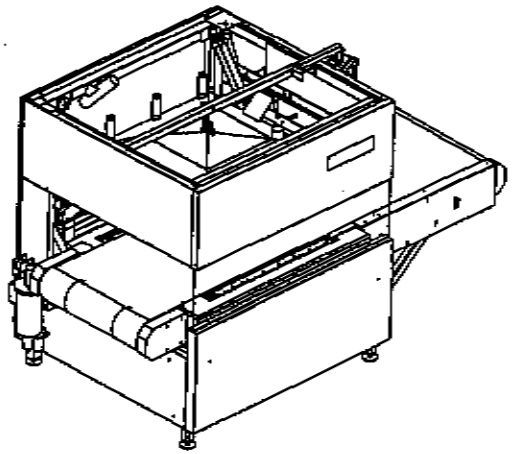

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