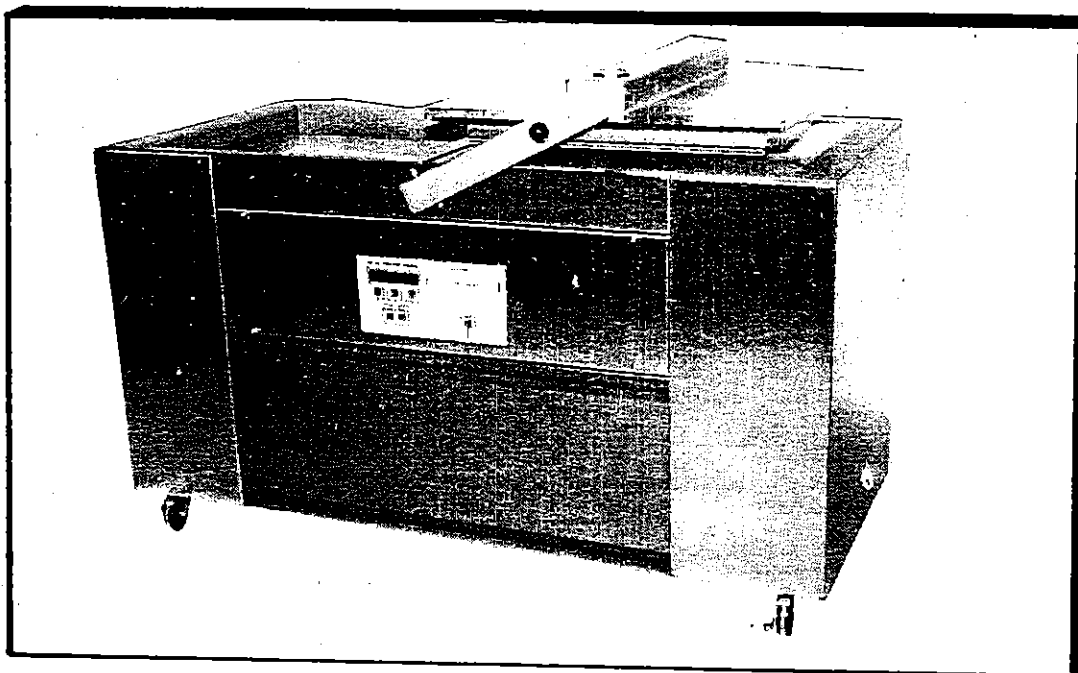


SIPROMAC

ANCIEN
MANUEL
EDITION
OCT. 1990

LA



MODELE 600



SIPROMAC INC.

VACUUM PACKAGING CHAMBER

MODEL 600

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SIPROMAC INC.

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

1. SETTING UP THE MACHINE:

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

Keep in mind that the machine must not be set up upon uneven ground. Especially with mobile models, the weight of the pump might then cause warping of the chamber. Then the lid will not fit closely upon the chamber and this gives a lot of avoidable troubles at operation.

Before starting to work, check at the oil view glass of the pump, whether 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.

Due to the oil viscosity, the machine is hard to start when temperatures are very low. Therefore the pump ought to be set up 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 have an electrical schematic in the electrical casing.

Con't 2. Electrical connection,

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.

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.

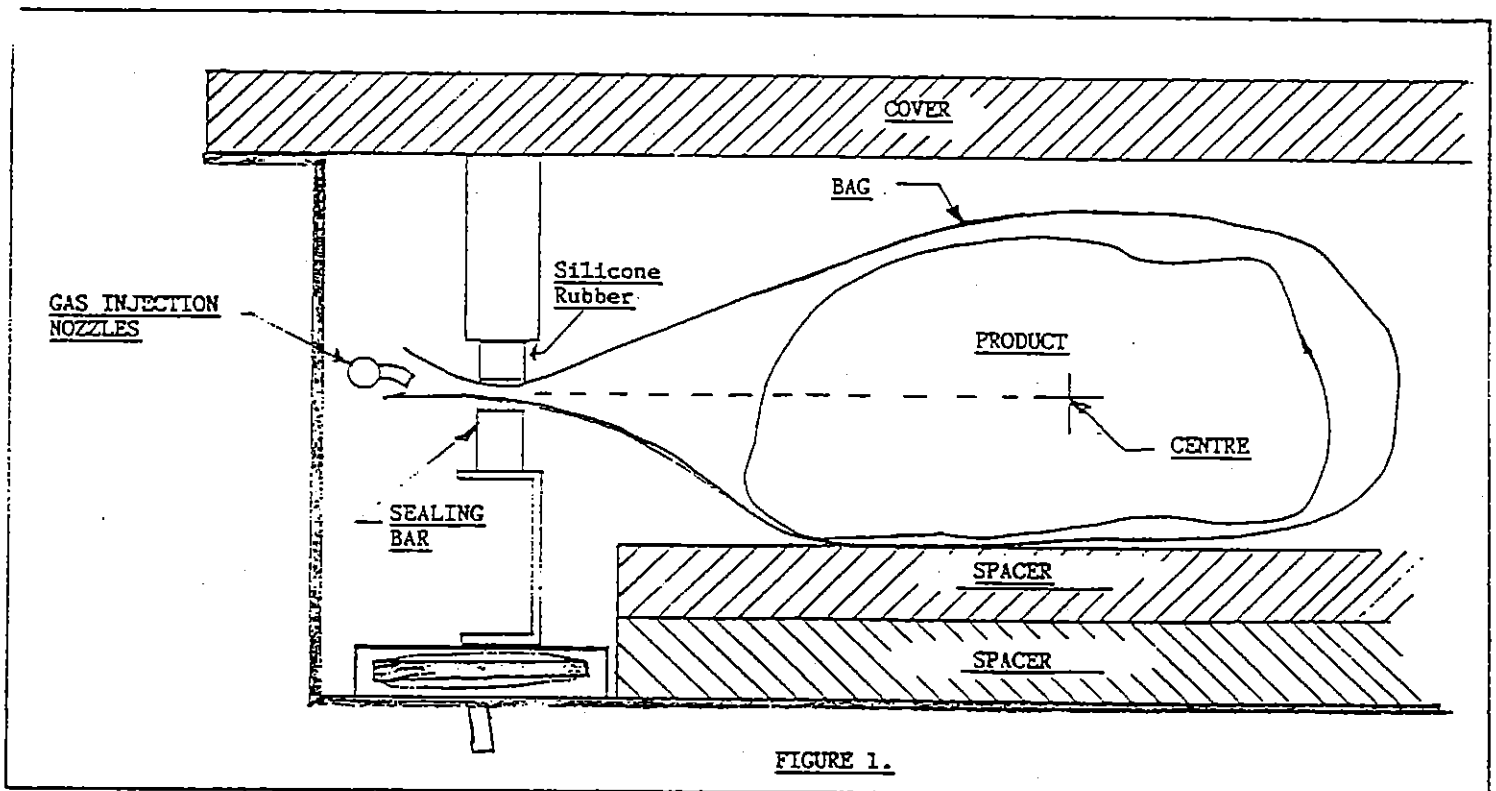


FIGURE 1.

Con't 3. Operation,

To obtain nice packings, the products and the bags have to be of proportional sizes. The bag's opening should never exceed 2" (50 cm) of the scelling bars. The scelling bar should always be at the center of the product. You may use different spacers.

To obtain a good seal, make sure that no residue of fat is left between the bag's inner sides where sealing is done. As for the injection of gas, place the bag's opening on the nozzles.

3.2 Special packaging:

3.2.1 Gas flushing;

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

For gas flushing, the bags are placed on the sealing bars, the open end pushed over the gas nozzles mounted alongside the sealing bar. After evacuation, the vacuum valve closes and the gas valve opens. Time of opening (corresponding to quantity of gas entering the bag) can be set on the "G" control.

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

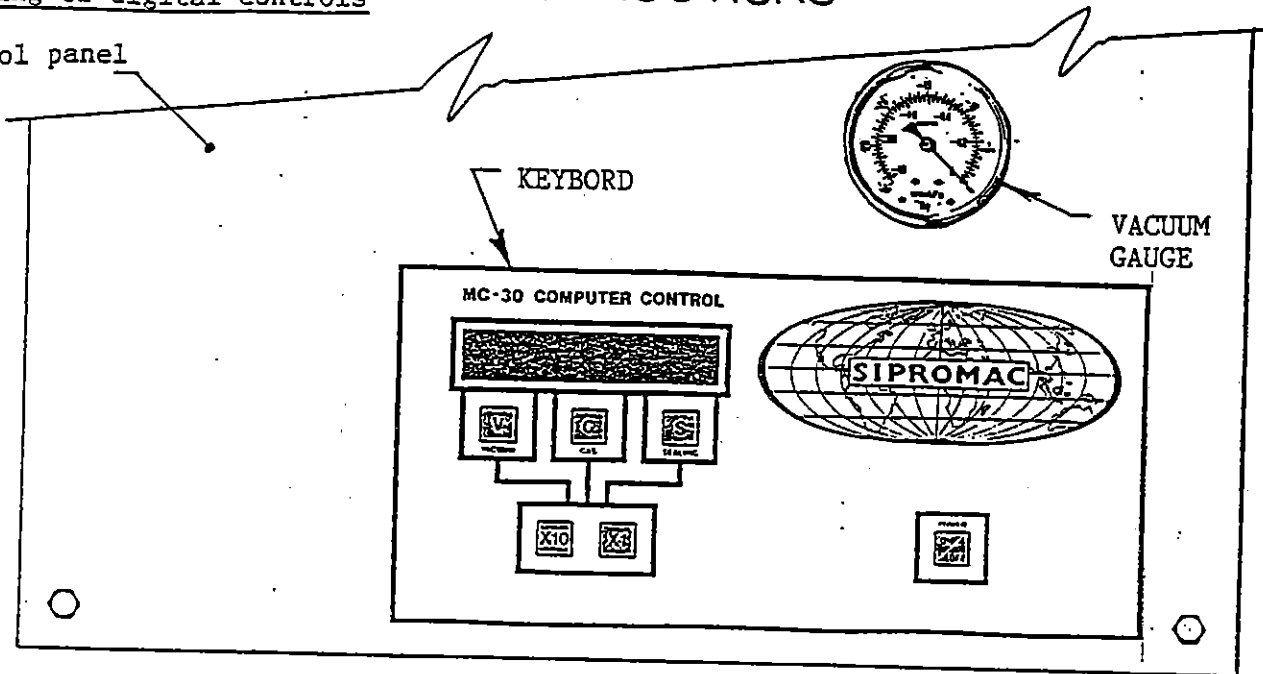
3.2.2 Up and down seal;

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

3.3 Setting of digital controls

INSTRUCTIONS

Control panel



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

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

To program the vacuum cycle:

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

To program the gas cycle:

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

To program the sealing cycle:

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

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

BASIC PROGRAM TO MODIFY ACCORDING TO THE PRODUCTS

| MACHINE | "V" | * "G" | "S" |
|-----------|---------|-----------|------------|
| VAC - 350 | 20 sec. | AS NEEDED | 1 - 3 sec. |
| VAC - 450 | 22 sec. | AS NEEDED | 1 - 5 sec. |
| VAC - 550 | 25 sec. | AS NEEDED | 1 - 5 sec. |
| VAC - 600 | 25 sec. | AS NEEDED | 1 - 5 sec. |
| VAC - 650 | 27 sec. | AS NEEDED | 1 - 7 sec. |

To modify your program, increase by "1" as desired by pressing on the "X1" key.

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

"V" --- indicated in seconds

"G" --- indicated in seconds

"S" --- indicated in seconds and 10th of a second.

Warning: Do not increase the sealing time too much to prevent deteriorating the tefflons.

.../5

CON'T 3.3 SETTING OF DIGITAL CONTROLS

NOTE:

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

3.4 Daily cleaning:

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

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

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

4 TROUBLE SHOOTING:

4.1 Failure during a packaging cycle:

The lid is closed and cycle fails to start or stops immediately after having started:

Micro switch is actuated too late, re-set the micro switch.

Fault in supply of electricity to the timing control (Power on light does not go on):

Check input voltage at transformer (Faulty contact in wires)

Check secondary voltage of transformer (Approx. 24 Volt AC)

Check fuse

If none of these applies; exchange electronic card.

WARNING

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

.../6

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 to any fault of the machine.

Pin-point leak for which there is no obvious explanation. Faulty bag material.

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

Rent of tear in bag by careless handling (Sharp edge on filling table, damage made by retailer or customer).

Leakage in lateral or bottom seal, complain at supplier's.

4.2.2 No leakage in the bag;

Bag is too large, therefore the residue air remains visible (There is residue air of 0.4% of 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 evacuation. To find the leakage quickly, check for leak with precision vacuumeter, going back step by step from the chamber to the pump.

At the chamber (measuring point at block valve) at maximum time of evacuation. If more than 6 torr, proceed to.

Directly at the pump, if more than 3 torr: Have pump serviced at pump supplier's workshop. If pressure at pump is all right:

Reconnect hoses to pump and measure again.

After the vacuum hose.

After the block valve.

With double chamber machine, after the air joint in lid.

.../7

Con't 4.2.3 Insufficient vacuum in chamber,

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

Warning: Keep in mind; absolute tightness of hoses and connections of measuring equipment.

Most frequent points of leakage: Lid gasket, damaged vacuum hose and loose hose clamps.

4.3 Faulty seal;

4.3.1 Insufficient seal;

Damaged teflon or silicone rubber.

Sealing pressure too low, membrane hose leaking or pressure bar jammed.

Leakers in seal (no homogenous sealline): heating wire mechanically damaged (knick by some blow, etc.) or silicone rubber uneven.

4.3.2 No seal;

Sealing wire burnt.

Faulty contact in sealing circuit

Sealing transformer burnt through.

Contactator does not work.

4.3.3 Permanent sealing current;

Contactator is jammed check sealing transformer for damage through overload.

.../8

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 valves:

Vacuum or air valve does not open.

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

If there is current, check change of vacuum and atmospheric pressure on hose from magnetic valve to block valve with the tip of your finger. If this is correct, the fault is in the block valve.

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

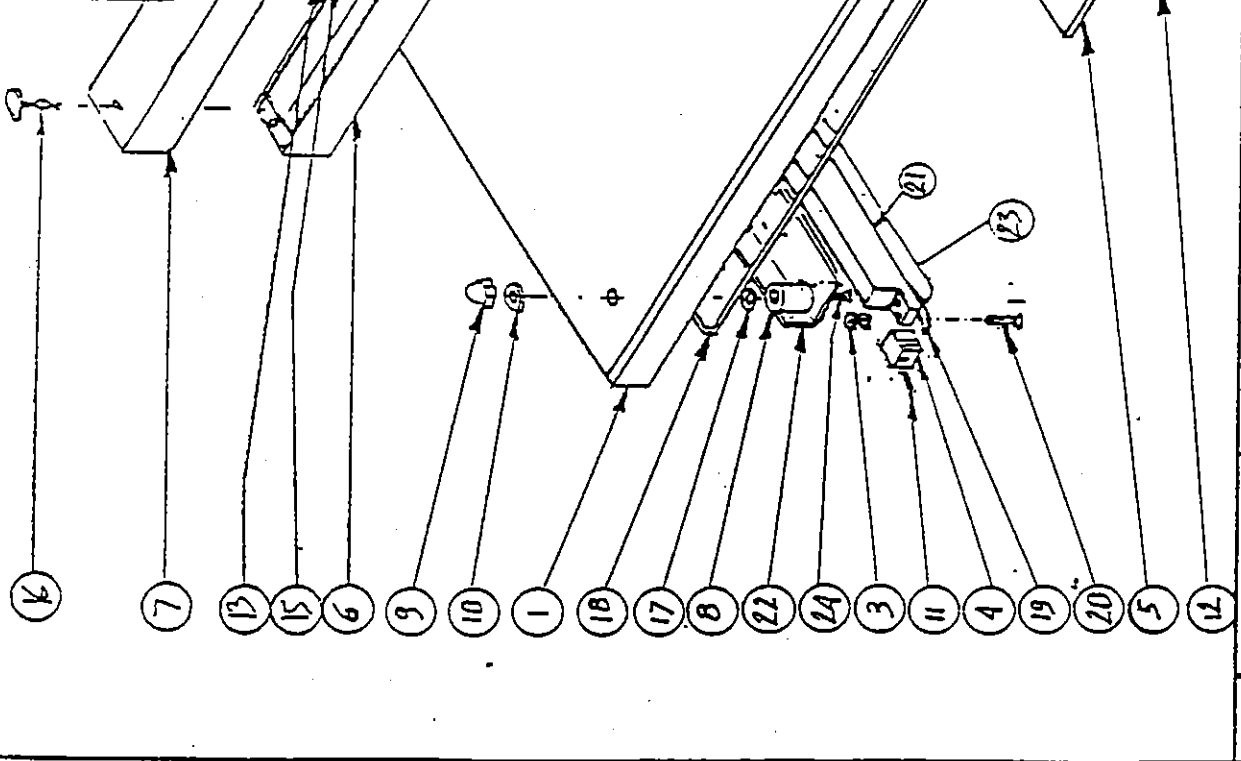
CONTROL BOARD FAILURE

| PROBLEM | POSSIBLE CAUSE | |
|---|------------------------------------|---|
| 1 No display | 1.1 Programmin error. | Press on/off switch on membrane switch |
| | 1.2 No current coming to PC board. | Check fuses Check voltage between pins # <u>6</u> and # <u>13</u> on "D" connector, the reading should be approx. 9 AC volts. (transformer or wiring defect) |
| | 1.3 On/off key defective | Disconnect flat cable between PC board and membrane switch and jump pins 1 and 2 or 7 and 8 using a screwdriver |
| | 1.4 Defective PC board | Replace PC board |
| 2 Two digits continously flashes on "V", "G" or "S" | 2.1 Programming error | Press corresponding "V", "G", or "S" key |
| | 2.2 Defective membrane switch | Replace membrane switch |
| | 2.3 Defective PC board | Replace PC board |
| 3 All of the display continously flashes | 3.1 Cover Switch remains closed | Check cover switch or continuity between pins # 8 and # 15 or PC board connector (see dwg #006-0029) |
| | 3.2 Defective PC board | Replace |

| | | |
|--|--|---|
| <p>8 Machine "recycling" or cycle "Re-start continuously.</p> | <p>8.1 Poorly adjusted cover switch</p> | <p>Adjust</p> |
| | <p>8.2 Defective PC board</p> | <p>Replace</p> |
| <p>9 Double chamber: Vacuum sealing or atmosphere is not done on one side only</p> | <p>9.1 Defective relay or connection</p> | <p>Replace the 4PDT (in electrical box) This relay switch functions from one side to the other. (the PC board is good because there is one output which control's both sides)</p> |
| | <p>9.2 Defective contactor or valve</p> | <p>Test voltage on coil</p> |

| | | | |
|----|-----------|--------------------------|---|
| 19 | Ø 1/015 | ELEMENT | 2 |
| 18 | | COVER GASKET | 1 |
| 17 | Ø 76- | O-RING 3/16" x 5/16" | 5 |
| 16 | Ø 56-0014 | HOLD DOWN CLIP | 2 |
| 15 | Ø 51-0760 | FLAT WASHER 5/16" | 4 |
| 14 | Ø 51-0150 | BOLT # 10-24 x 1 1/2" | 1 |
| 13 | Ø 51-0600 | NUT 5/16" - 18 | 4 |
| 12 | Ø 51-0310 | BOLT 5/16" - 18 x 1 1/2" | 4 |

| | | | |
|----|------------|-----------------------------|---|
| 20 | Ø 51-0140 | FLAT HEAD SCREW 8-32x1 1/2" | 4 |
| 21 | Ø 002-0073 | SEAL BAR | 2 |
| 22 | Ø 001-0434 | SEAL BAR SUPPORT | 2 |
| 23 | Ø 100-105 | SELF STICK TEFLON | 4 |
| 24 | Ø 51-0150 | FLAT HEAD SCREW 10-24 x 3" | 4 |



| | | | |
|--------------------------|------------|--------------------------|-----|
| 11 | Ø 51-0178 | SET SCREW 1/2-20 x 5/16" | 4 |
| 10 | Ø 51-0740 | FLAT WASHER 1/4" | 5 |
| 9 | Ø 51-0510 | ACORN NUT #10-24 | 5 |
| 8 | Ø 002-0077 | SEAL BAR SPACER | 4 |
| 7 | Ø 001-1187 | CROSS BEAM COVER | 1 |
| 6 | Ø 005-0287 | CROSS BEAM ASSEMBLY | 1 |
| ITEM # PIECE DESCRIPTION | | | QTE |

| | |
|-----------------------------|--|
| TOLERANCES | |
| ± .03 | |
| ± .05 | |
| ± .005 | |
| ± .0025 | |
| ± .001 | |
| NE PAS MESURER | |
| VACUUM 600 | |
| COVER ASSEMBLY | |
| BI ACTIVE SEAL BAR (OPTION) | |
| EQUIP. 1 | |
| MATERIAL | |
| PART | |
| QTE | |



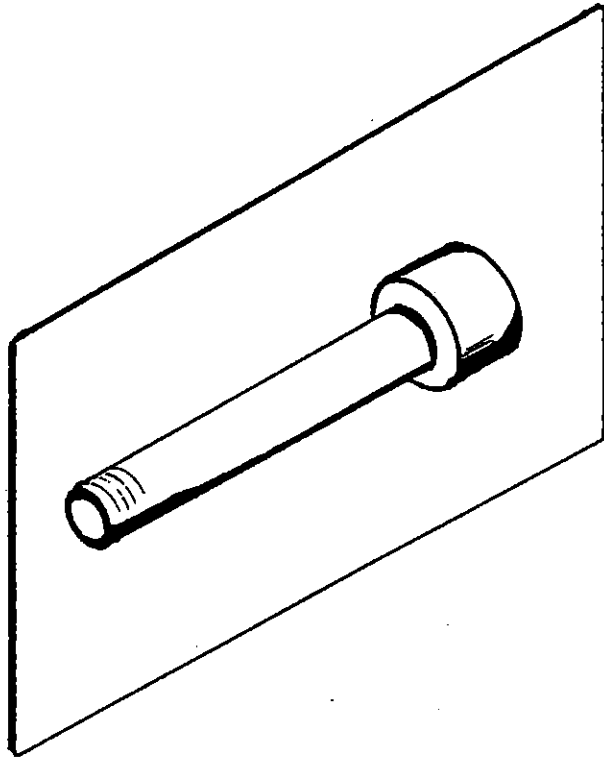
ORUJHONNO VILLE, QUEBEC, CANADA.

5. Regular Maintenance:

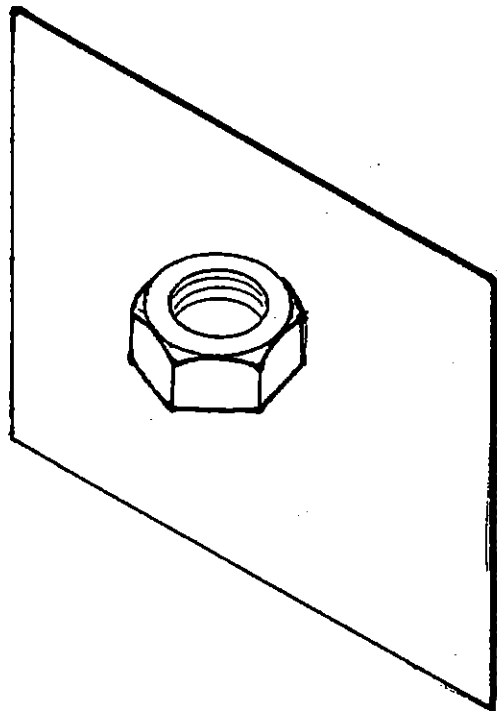
Routine controls to be made at regular intervals:

- 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.
- Clean upper chamber rim.
- Check switch-point of micro switch, adjust if necessary.
- Check evacuation hose for damage (Contraction of diameter abrasions).
- Check vacuum connections for tightness.
- Check oil in pump (oil level in view glass;
Add if necessary. Regular exchange of oil - necessity indicated by change of colour).
- Check vacuum in chamber with precision vacuumeter.
- Check function of cycle with various settings of timers.

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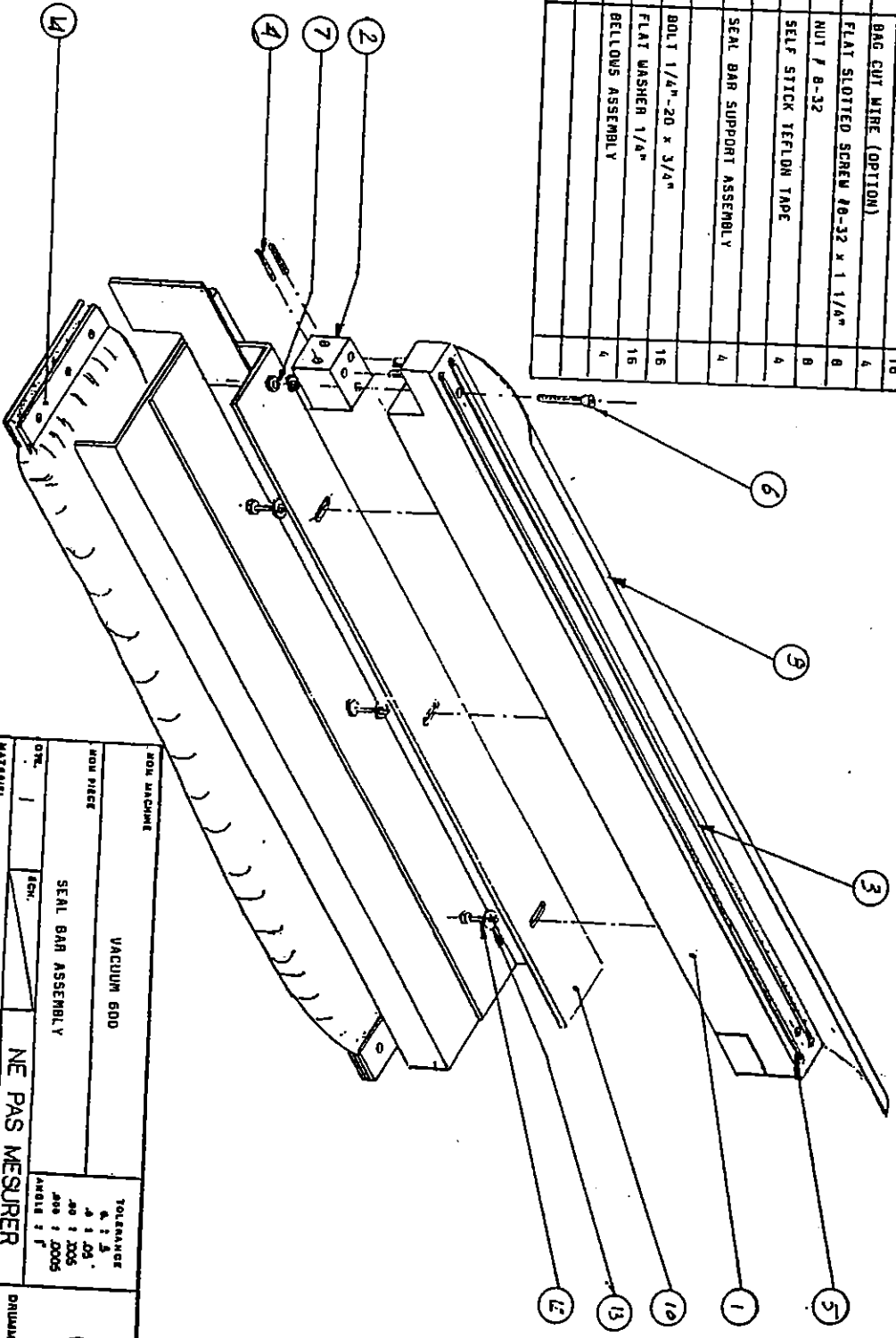


MECHANICAL DRAWING

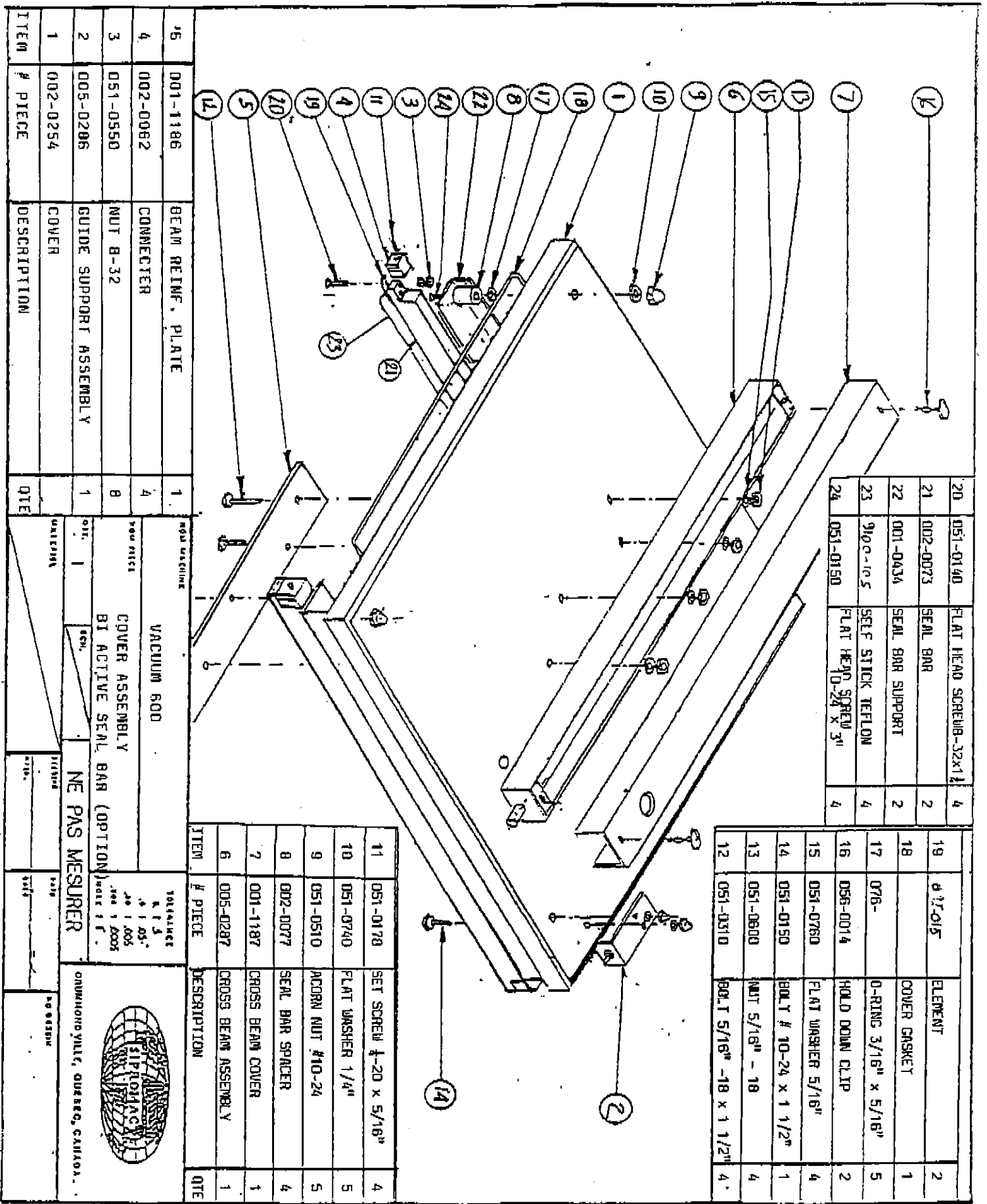


| | | |
|---|---|---|
| 4 Impossible to program any timer (all of the display is on) | 4.1 Programming error | Press "V", "G" or "S" to be in programming mode. Only 1 timer at a time. |
| | 4.2 Defective PC board | Replace PC board |
| 5 Impossible to program one timer (V,G, or S) (all of the display is on) (see step 4 first) | 5.1 Defective membrane switch | Replace membrane switch |
| | 5.2 Defective PC board | Replace PC board |
| 6 PC board doesn't keep data in memory | 6.1 Battery not charged | Run the machine or leave it plugged in with switch in off position for a few hours to charge battery. |
| | 6.2 Defective battery | Replace battery or complete PC board (the battery is mounted on the PC board) |
| | 6.3 Defective PC board | Replace PC board |
| 7 Cycle dosen't start | 7.1 Poorly adjusted cover Switch | Adjust |
| | 7.2 Bad connection or defective limit switch | Verify |
| | 7.3 Defective PC board | Replace PC board |
| | 7.4 PC board is OK, outputs are defective (dwg #006-0029) | Ckeck pump fuses, pump contactor coil, valves etc. |

| ITEM | QTY | DESCRIPTION |
|------|-----|-----------------------------------|
| 1 | 4 | SEAL BAR |
| 2 | 4 | BAG CUT SEAL BAR (OPTION) |
| 3 | 8 | CONNECTER |
| 3 | 8 | SEALING ELEMENT |
| 3 | 4 | SEALING ELEMENT (OPTION BAG CUT) |
| 4 | 16 | HEX SOCKET SET SCREW |
| 5 | 4 | BAG CUT WIRE (OPTION) |
| 6 | 8 | FLAT SLOTTED SCREW #8-32 x 1 1/4" |
| 7 | 8 | NUT # 8-32 |
| 8 | 4 | SELF STICK TEFLON TAPE |
| 9 | 4 | SEAL BAR SUPPORT ASSEMBLY |
| 10 | 4 | BOLT 1/4"-20 x 3/4" |
| 11 | 16 | FLAT WASHER 1/4" |
| 12 | 16 | BELLOWS ASSEMBLY |
| 13 | 16 | |
| 14 | 4 | |



| | | | |
|----------------|------|--|----------------|
| MOM MACHINE | | VACUUM 600 | |
| MOM PIECE | | SEAL BAR ASSEMBLY | |
| QTY: 1 | ECN: | DESIGNER: ALAIN | DATE: 90-07-24 |
| MATERIAL: | | DRIVER: DAVE | DATE: 90-08-10 |
| NE PAS MESURER | | TOLERANCE ± .5 ± .05 ± .005 ANGLE 2° | |
| SIPROMAC | | DRUMMOND VILLE, QUEBEC, CANADA. | |
| NO DESIGN | | 005-0270 | |



| | | | |
|----|----------|---------------------------|---|
| 20 | 051-0140 | FLAT HEAD SCREW-32x1 1/2" | 4 |
| 21 | 002-0073 | SEAL BAR | 2 |
| 22 | 001-0434 | SEAL BAR SUPPORT | 2 |
| 23 | 9100-105 | SELF STICK TEFLON | 4 |
| 24 | 051-0150 | FLAT HEAD SCREW 3" | 4 |

| | | | |
|----|------------|--------------------------|---|
| 19 | Ø 1/2-015" | ELEMENT | 2 |
| 18 | | COVER GASKET | 1 |
| 17 | Ø 7/8- | O-RING 3/16" x 5/16" | 5 |
| 16 | 056-0014 | HOLD DOWN CLIP | 2 |
| 15 | 051-0780 | FLAT WASHER 5/16" | 4 |
| 14 | 051-0150 | BOLT # 10-24 x 1 1/2" | 1 |
| 13 | 051-0800 | NUT 5/16" - 18 | 4 |
| 12 | 051-0310 | BOLT 5/16" - 18 x 1 1/2" | 4 |

| | | | |
|----|----------|------------------------|---|
| 11 | 051-0178 | SET SCREW 1/20 x 5/16" | 4 |
| 10 | 051-0740 | FLAT WASHER 1/4" | 5 |
| 9 | 051-0510 | ACORN NUT #10-24 | 5 |
| 8 | 002-0077 | SEAL BAR SPACER | 4 |
| 7 | 001-1187 | CROSS BEAM COVER | 1 |
| 6 | 005-0287 | CROSS BEAM ASSEMBLY | 1 |

| | | | |
|----|----------|------------------------|---|
| 15 | 001-1186 | BEAM REINF. PLATE | 1 |
| 4 | 002-0082 | CONNECTER | 4 |
| 3 | 051-0550 | NUT B-32 | 8 |
| 2 | 005-0206 | GUIDE SUPPORT ASSEMBLY | 1 |
| 1 | 002-0254 | COVER | |

| | | | |
|----|----------|------------------------|---|
| 15 | 001-1186 | BEAM REINF. PLATE | 1 |
| 4 | 002-0082 | CONNECTER | 4 |
| 3 | 051-0550 | NUT B-32 | 8 |
| 2 | 005-0206 | GUIDE SUPPORT ASSEMBLY | 1 |
| 1 | 002-0254 | COVER | |

VACUUM ROD

COVER ASSEMBLY

BI ACTIVE SEAL BAR (OPTION)

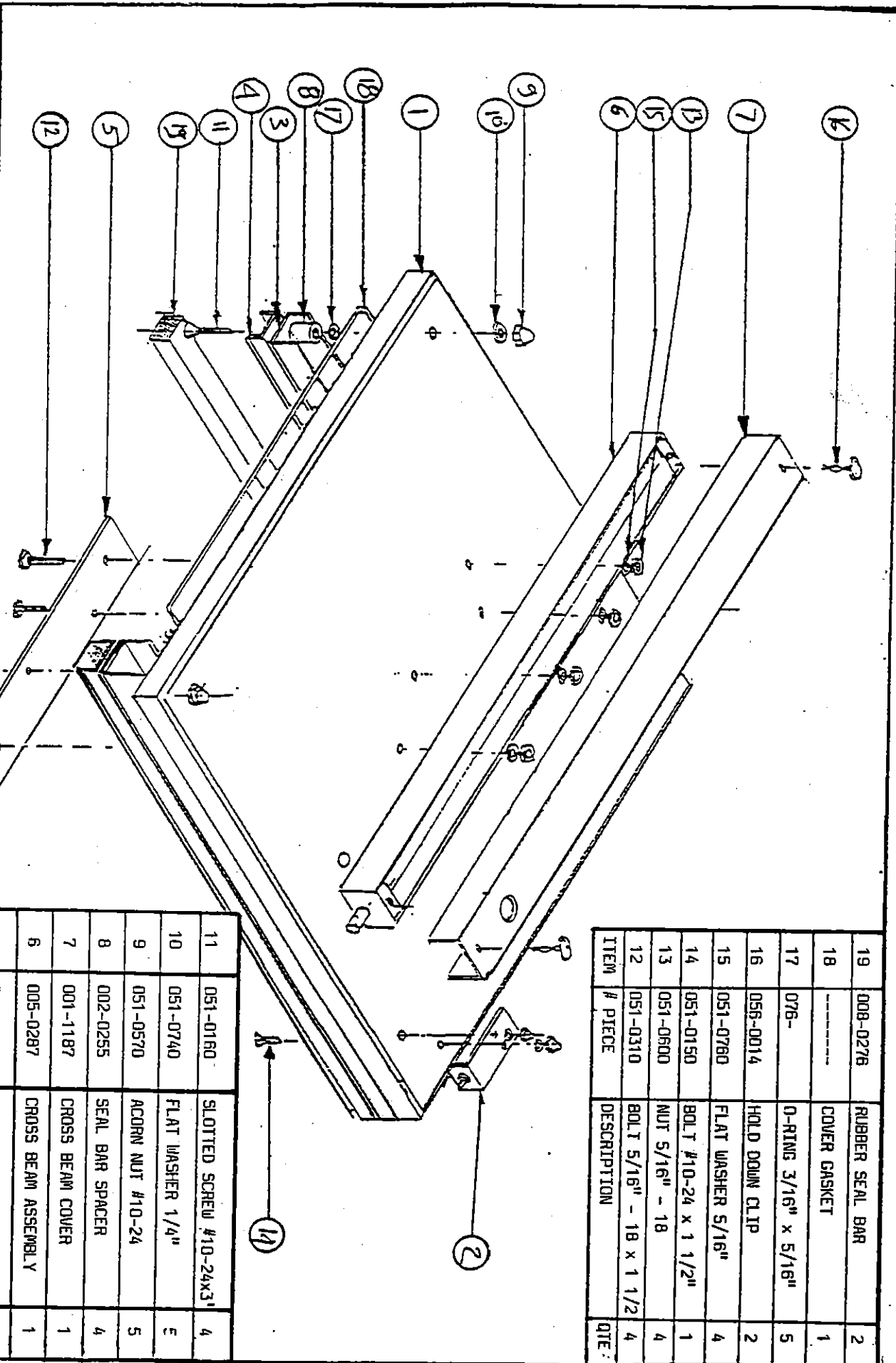
NE PAS MESURER

CONSTRUCTION YLLIT, QUEREQ, CALIXOR.

| ITEM | # | PIECE | DESCRIPTION | QTY |
|------|----------|-------|------------------------|-----|
| 5 | 001-1186 | 1 | BEAM REINFORC. PLATE | 1 |
| 4 | 001-0093 | 2 | RUBBER SEAL HOLDER | 2 |
| 3 | 001-1182 | 2 | SEAL BAR SUPPORT | 2 |
| 2 | 005-0286 | 1 | GUIDE SUPPORT ASSEMBLY | 1 |
| 1 | 002-0254 | 1 | COVER | 1 |

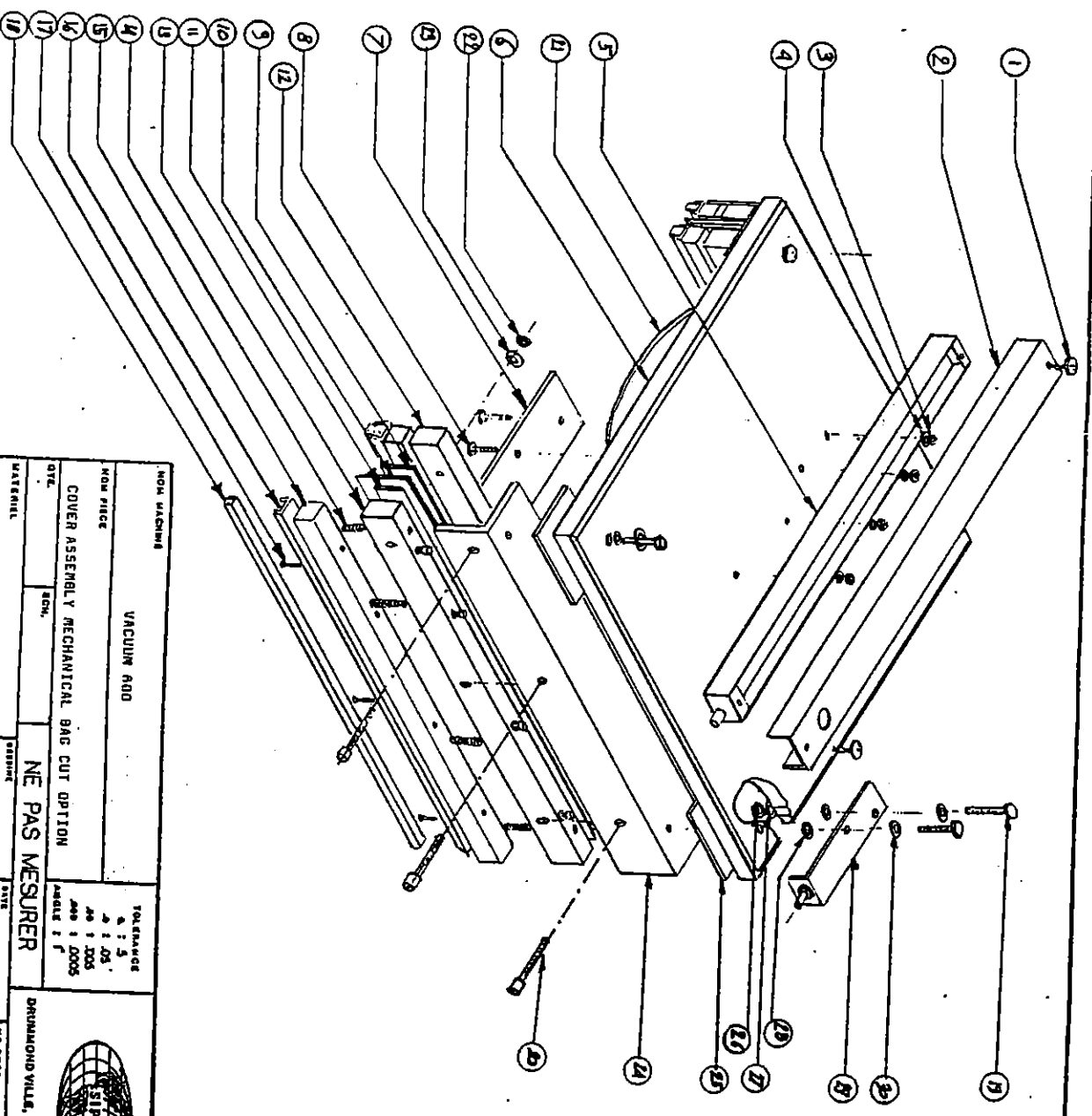
| ITEM | # | PIECE | DESCRIPTION | QTY |
|------|----------|-------|-------------------------|-----|
| 11 | 051-0160 | 4 | SLOTTED SCREW #10-24x3" | 4 |
| 10 | 051-0740 | 5 | FLAT WASHER 1/4" | 5 |
| 9 | 051-0570 | 5 | ACORN NUT #10-24 | 5 |
| 8 | 002-0255 | 4 | SEAL BAR SPACER | 4 |
| 7 | 001-1187 | 1 | CROSS BEAM COVER | 1 |
| 6 | 005-0287 | 1 | CROSS BEAM ASSEMBLY | 1 |

| ITEM | # | PIECE | DESCRIPTION | QTY |
|------|----------|-------|--------------------------|-----|
| 19 | 008-0276 | 2 | RUBBER SEAL BAR | 2 |
| 18 | ----- | 1 | COVER GASKET | 1 |
| 17 | 076- | 5 | O-RING 3/16" x 5/16" | 5 |
| 16 | 056-0014 | 2 | HOLD DOWN CLIP | 2 |
| 15 | 051-0780 | 4 | FLAT WASHER 5/16" | 4 |
| 14 | 051-0150 | 1 | BOLT #10-24 x 1 1/2" | 1 |
| 13 | 051-0600 | 4 | NUT 5/16" - 18 | 4 |
| 12 | 051-0310 | 4 | BOLT 5/16" - 18 x 1 1/2" | 4 |



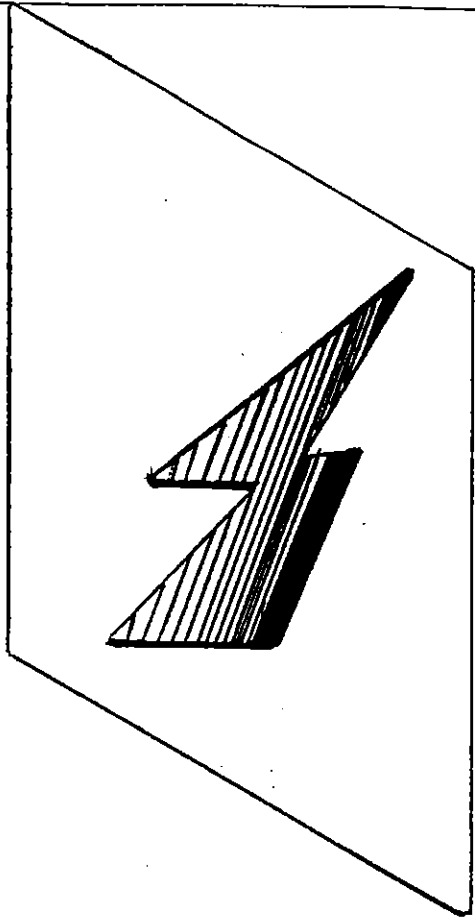
NE PAS MESURER
 ALAIN DAVE
 90-07-23
 90-08-10
 005-0272
 DUNDASVILLE, QUEBEC, CANADA.

| ITEM # | PIECE | DESCRIPTION | QTY | NOTE |
|--------|----------|--------------------------------------|-----|------|
| 1 | 056-0014 | NO. 10000 1125 | 2 | |
| 2 | 001-1187 | 2005 BEAM COVER | 1 | |
| 3 | 051-0900 | NUT 5/16" - 18 | 4 | |
| 4 | 051-0760 | FLAT WASHER 5/16" | 4 | |
| 5 | 005-0287 | CROSS BEAM ASSEMBLY | 1 | |
| 6 | 002-0254 | COVER | 1 | |
| 7 | 001-1186 | BEAM BEING. PLATE | 1 | |
| 8 | 051-0310 | BOLT 5/16" - 18 x 1 1/2" | 4 | |
| 9 | 001-1160 | BEAM SUPPORT | 2 | |
| 10 | 008-0267 | CUTTING BLADE | 2 | |
| 11 | 001-1161 | SPACER | 2 | |
| 12 | 002-0240 | SEAL BAR GUIDE REAR | 2 | |
| 13 | 002-0197 | SEAL BAR GUIDE FRONT | 2 | |
| 14 | 002-0198 | SEAL BAR SUPPORT | 2 | |
| 15 | 002-0199 | SEAL BAR SUPPORT | 2 | |
| 16 | 001-0093 | RUBBER SEAL HOLDER | 2 | |
| 17 | 051- | FLAT HEAD SCREW #10-24 x 3 1/8 | 6 | |
| 18 | 008-0278 | RUBBER SEAL BAR | 2 | |
| 19 | 051-0250 | BOLT 1/4" - 20 x 1 1/2" | 4 | |
| 20 | 051- | SOCKET HEAD CAP SCREW #1-20 x 1 1/4" | 6 | |
| 21 | 051- | COVER GASKET 3/8" Ø | 1 | |
| 22 | 051-0580 | NUT 1/4" - 20 | 6 | |
| 23 | 051-0740 | FLAT WASHER 1/4" | 6 | |
| 24 | 001-1189 | SPACER | 2 | |
| 25 | 001-1189 | SPACER | 2 | |
| 26 | 051-0580 | NUT 1/4" - 20 | 1 | |
| 27 | 051-0740 | WASHER 1/4" | 1 | |
| 28 | 008-0289 | 0-RING 3/16" x 5/16" | 5 | |
| 29 | 005-0289 | GUIDE SUPPORT ASSEMBLY | 1 | |
| 30 | 051-0740 | FLAT WASHER 1/4" | 5 | |

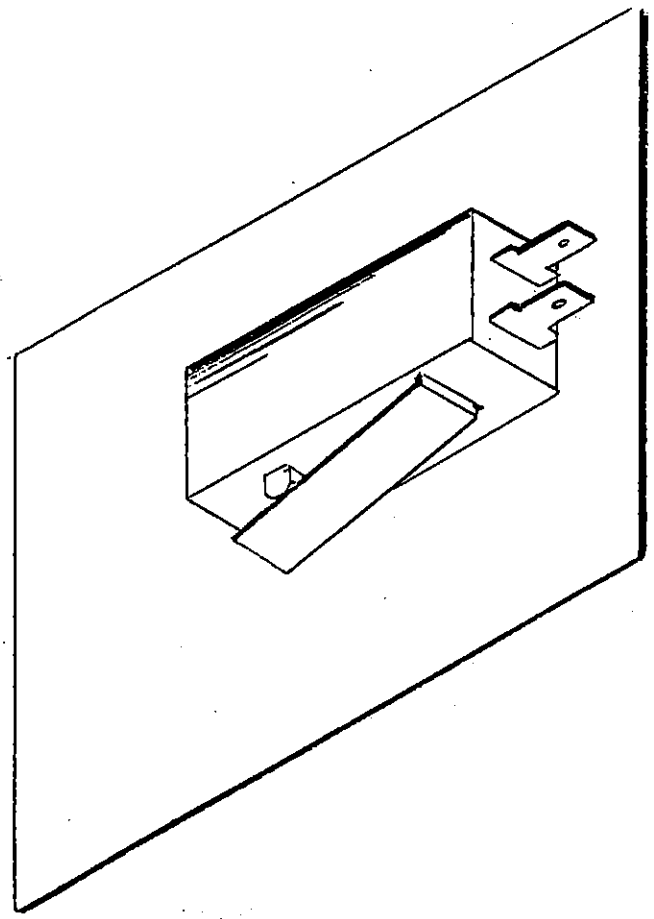



| | | | | | |
|--|--|----------------|--|--|--|
| NON MACHINA | | VACUUM ADO | | TOLERANCES ± .5 ± .05 ± .005 ANGLES 1° | |
| COVER ASSEMBLY MECHANICAL BAG CUT OPTION | | NE PAS MESURER | | DRUMMONDVILLE, QUEBEC, CANADA. | |
| MATERIAL | | ALAIN | | NO DESIGN | |
| DATE | | DATE | | DATE | |
| 056-0014 | | 00-08-28 | | 005-0273 | |



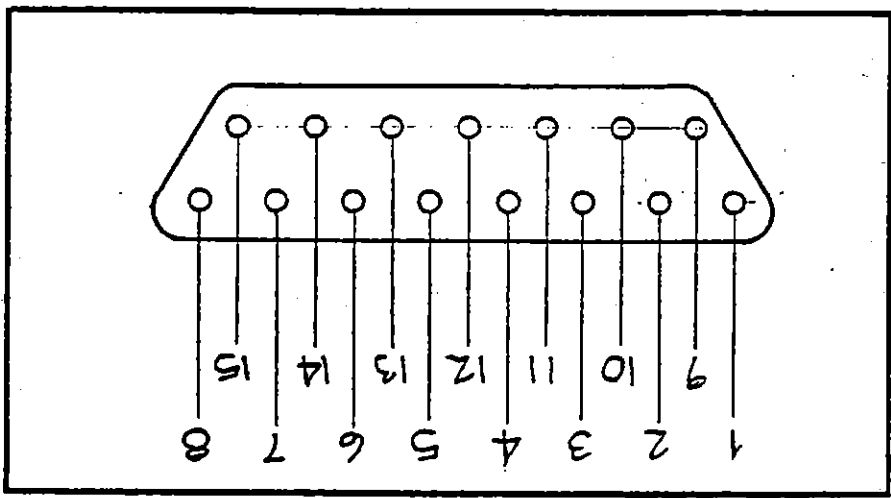


ELECTRICAL DRAWING

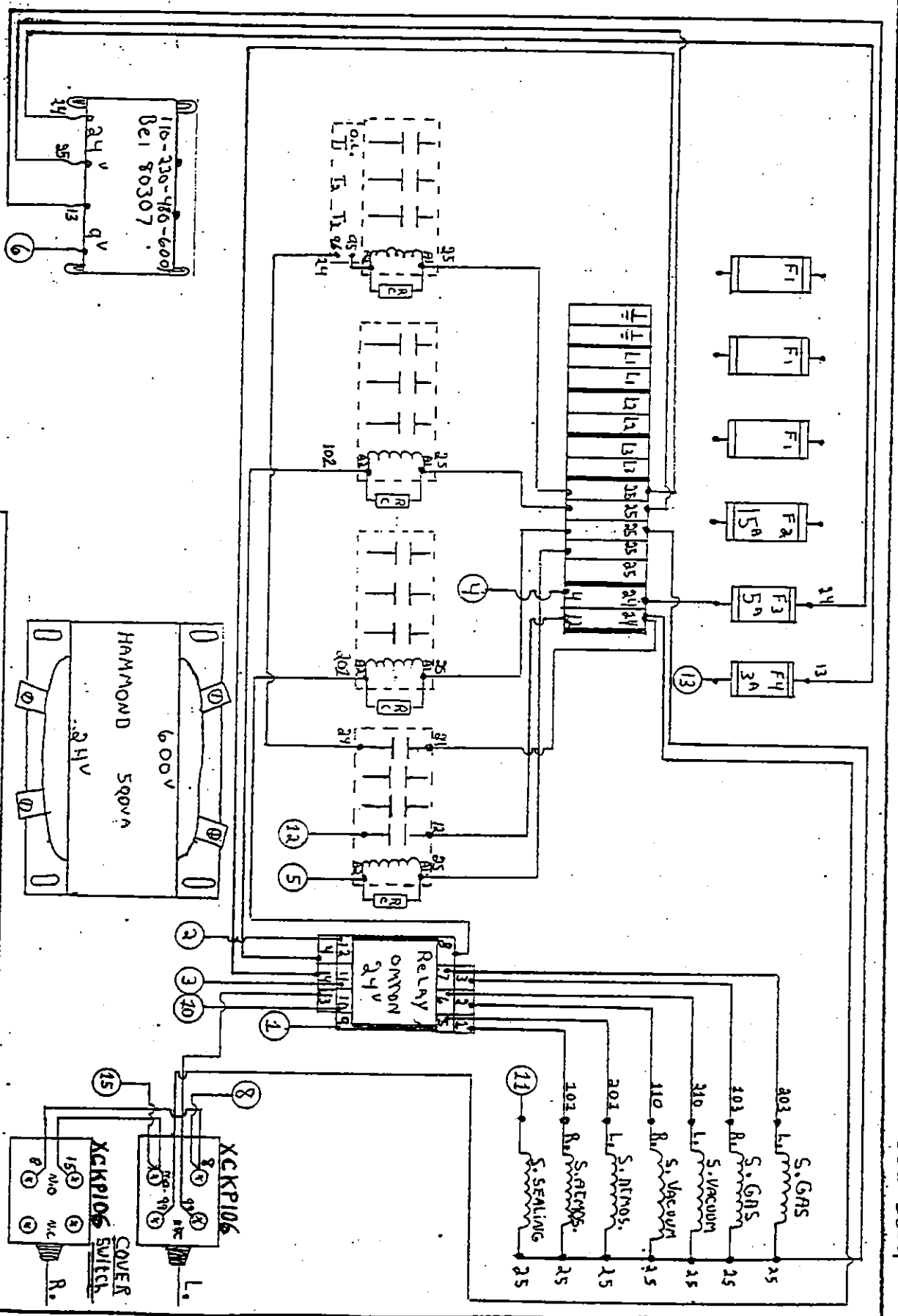


| | | | | |
|---|--|---|-----------------|-----------------------|
| NO DESSIN 006-0029 | | DATE 90-07-10 | APPR. DAVE A | MATERIEL |
| DRUMMOND VILLE, QUEBEC, CANADA. | | Op. | FILIERE | ECH. |
|  | | TOLERANCE 0 : .5 mm .0 : .01 mm .00 : .001 mm .000 : .0001 mm ANGLE : 0.30 | | NOM MACHINE VACUUM |
| | | NOM PIECE WIRING DIAGRAM 15 PINS | | |

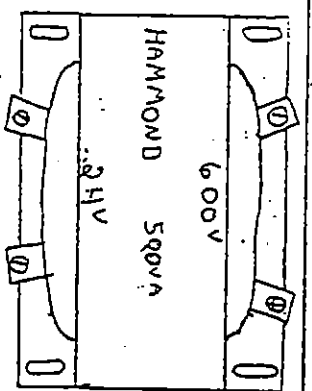
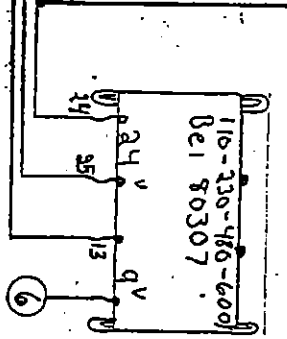
- COLOR CODE
- | | | |
|--------------|---|----------------|
| 1- BLACK : | OUTPUT TO ATMOSPHERE VALVE | |
| 2- WHITE : | OUTPUT TO SEALING CONTACTOR | |
| 3- GREEN : | OUTPUT TO GAZ VALVE | |
| 4- RED : | CONTACT OF PC BOARD RELAY | PC BOARD RELAY |
| 5- BLACK : | CONTACT OF PC BOARD RELAY ACTIVATE WHEN MACHINE IS ON | |
| 6- YELLOW : | INPUT: 9 VOLTS + | |
| 7- ----- : | JUMPED WITH # 6 | |
| 8- WHITE : | TO COVER SWITCH | COVER SWITCH |
| 10- RED : | OUTPUT TO VACUUM VALVE | |
| 9- ----- : | NOT USED | |
| 11- BLACK : | OUTPUT TO SEALING SELENOID VALVE | |
| 13- ORANGE : | INPUT: 9 VOLTS - | |
| 14- ----- : | JUMPED WITH # 13 | |
| 12- BLACK : | INPUT 24 VAC | |
| 15- BROWN : | TO COVER SWITCH | |



WIRING OF 15 PINS "D" CONNECTOR ON SIPROMAC VACUUM PACKAGING MACHINE



ALL CIRCLED NUMBER WIRES
GO TO P.C. BOARD



NON MACHINE
VACUUM 600 ET 420

NOUVEAU
ELECTRICAL WIRING Low Voltage.

NE PAS MESURER

ORIGINE
Y. M.

DATE
89-01-24

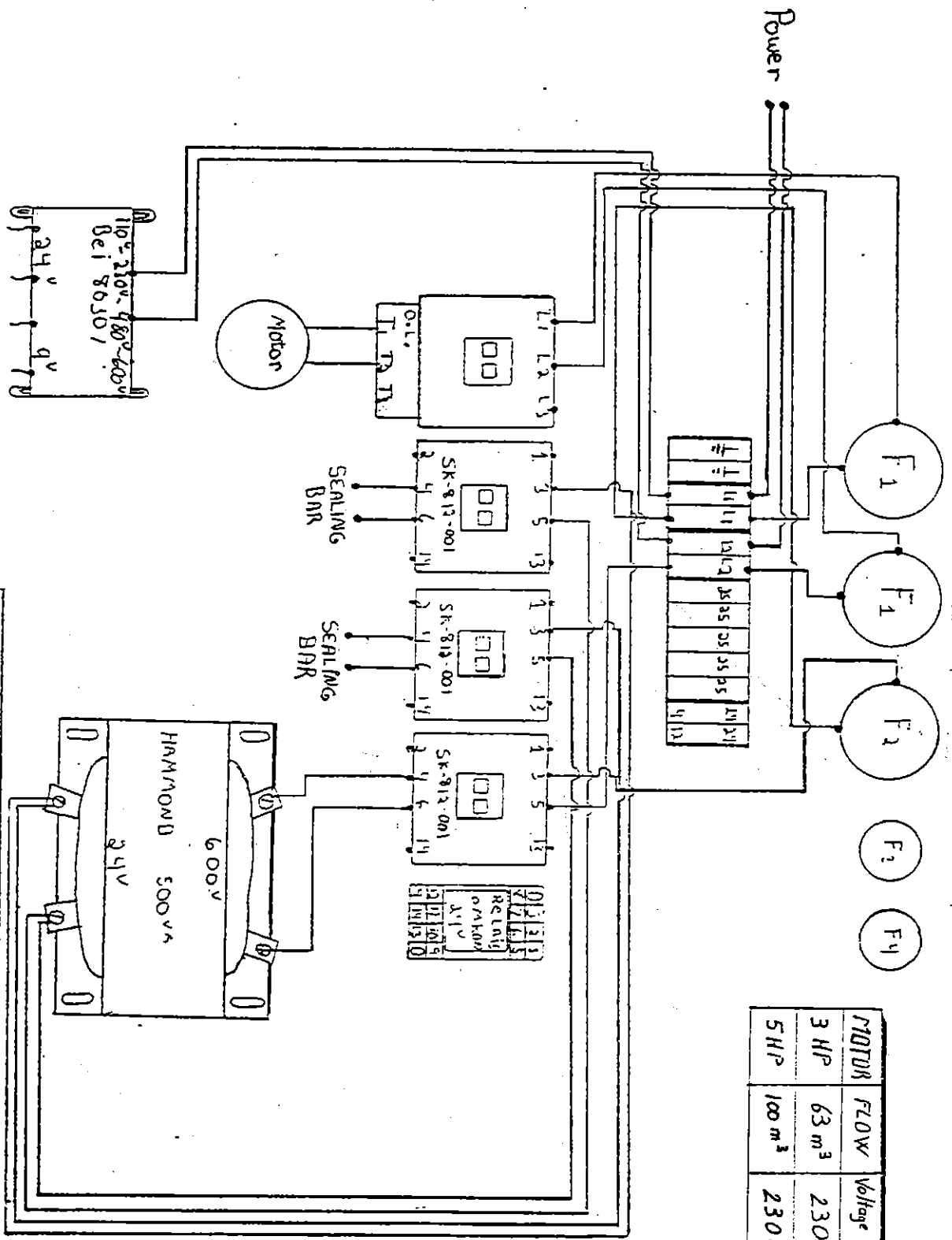
NO 83331H
006-0034

ORSHAMOND VILLE, QUEBEC, CANADA.

TOLEANCE
± 1 %
± 0.1 %
± 0.005
± 0.001
± 0.0005
ANNEE 1 F

SPINOMAC

XCKP106
COVER SWITCH
XCKP106
15V
8V

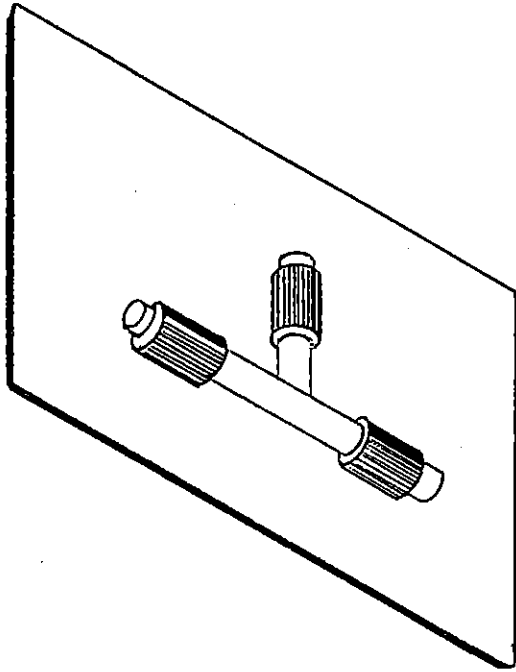


| MOTOR | FLOW | Voltage + Phase | PHUSE |
|-------|--------------------|-----------------|--------|
| 3 HP | 63 m ³ | 230-1 | MCL 30 |
| 5 HP | 100 m ³ | 230-1 | MEV-25 |

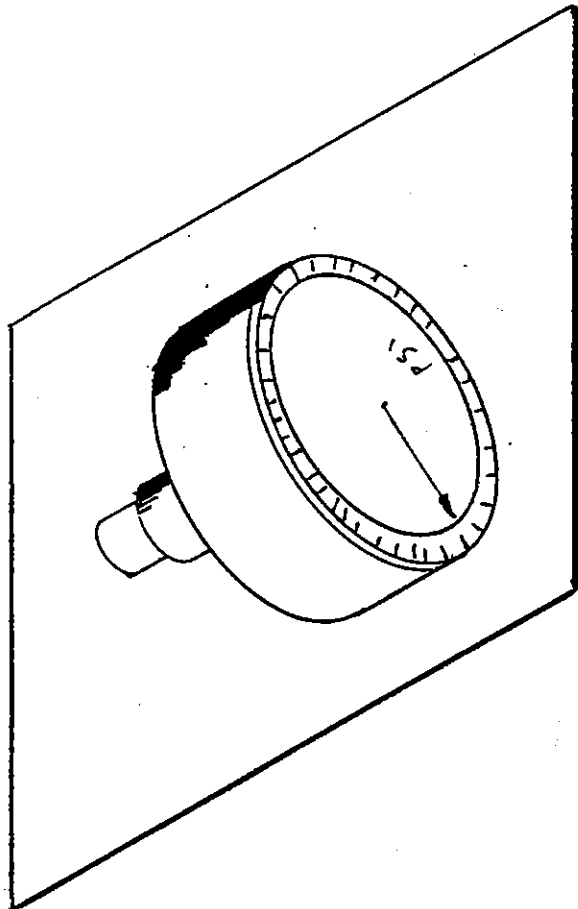
HOW MACHINE
VACUUM 600 ~ 1φ
 ELECTRICAL wiring High Voltage
 NE PAS MESURER
 DATE: 89-01-26
 NO. 00319
 006-0039

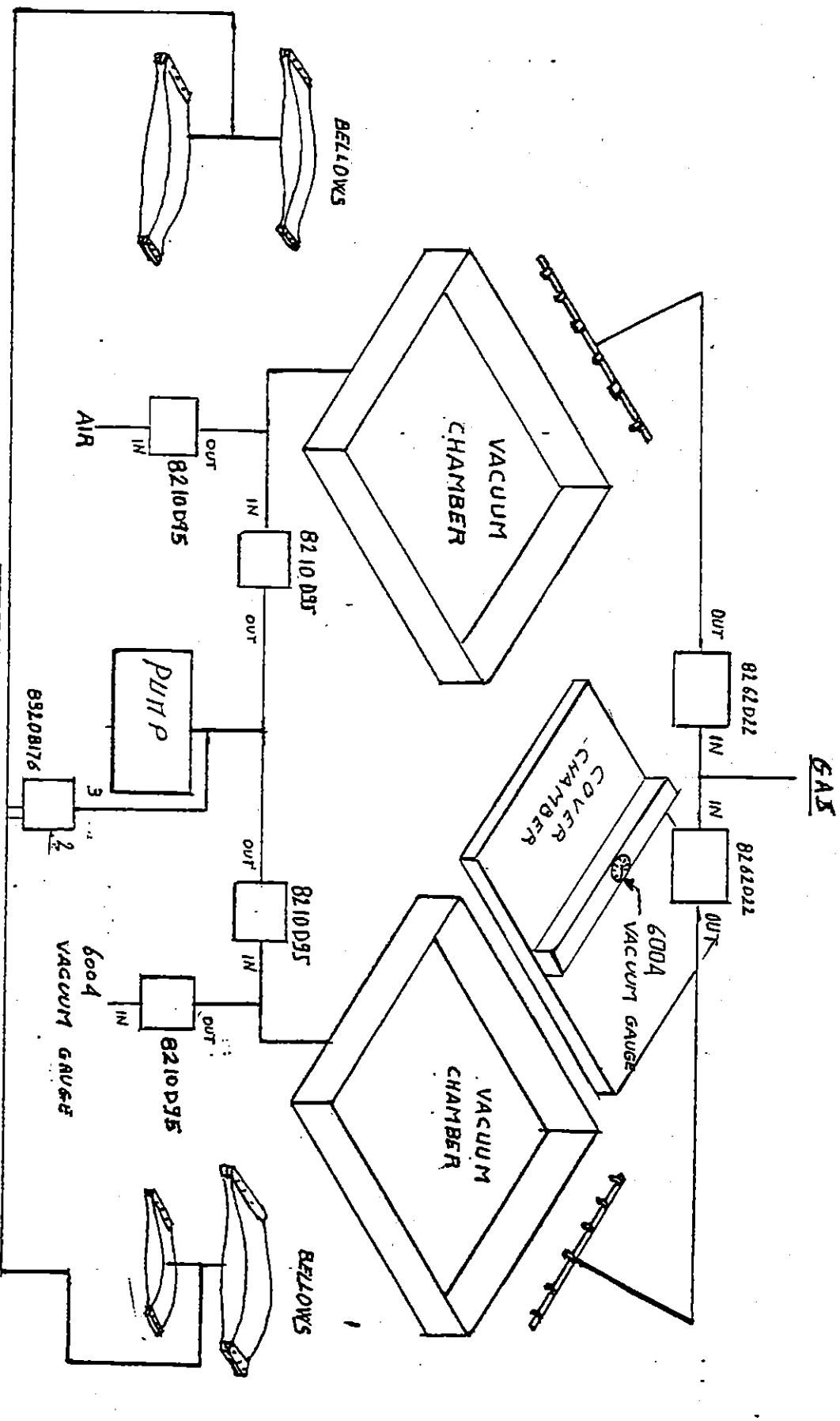
TOLERANCE
 A 1.5
 B 1.05
 C 1.005
 D 1.0005
 E 1.00005
 F 1.000005

GRANDHON VILLE, QUEBEC, CANADA.



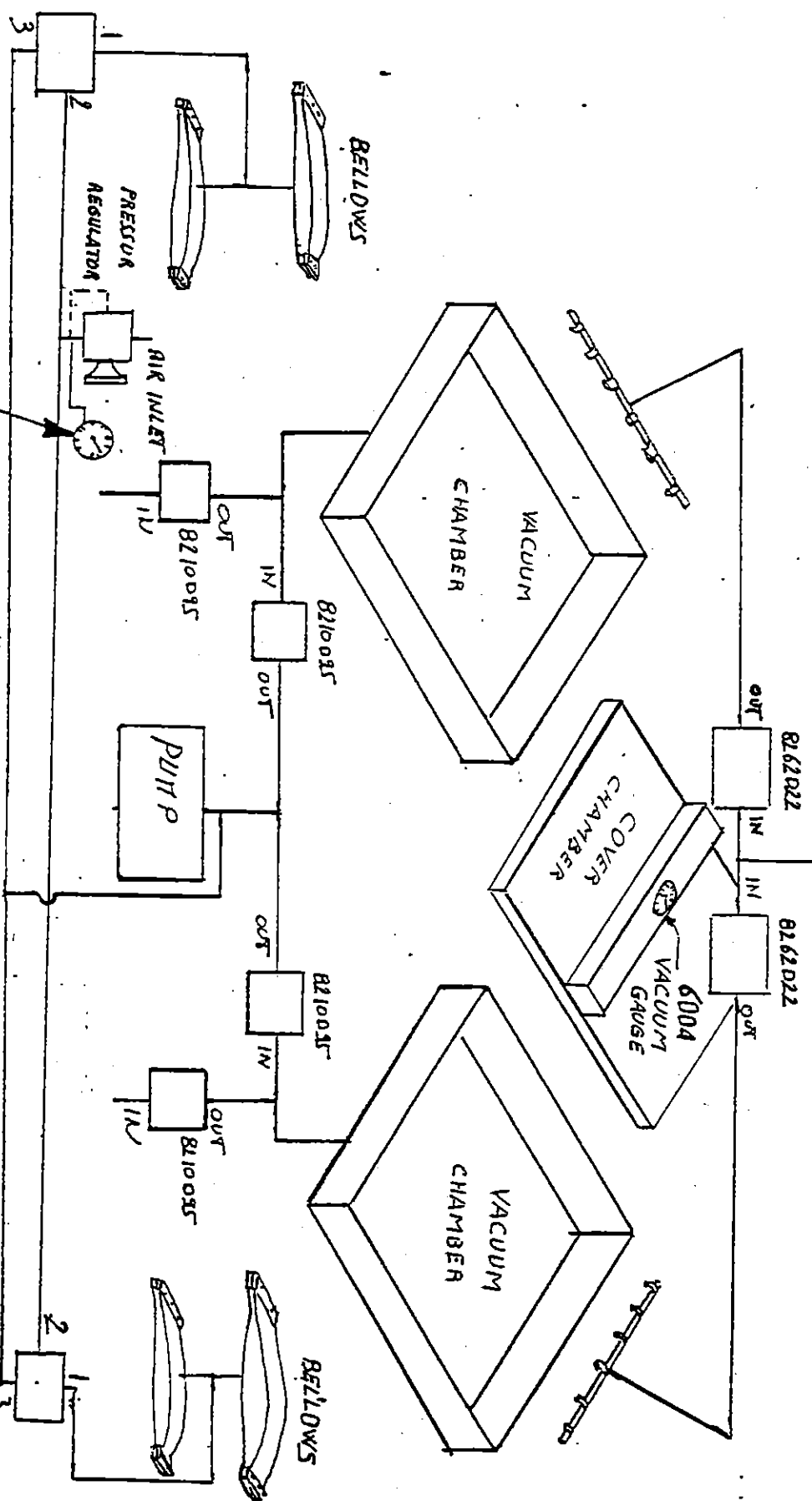
PNEUMATIC DRAWING





| | | | | |
|-------------------|------|--|--|--|
| NON MACHINE | | TOLERANCE | | |
| VACUUM 600 | | 1/5 0.1/0.5 .001/0.005 .0001/0.0005 ANGLE 1° | | |
| PNEUMATIC DRAWING | | | | |
| DIR. | ECN. | NE PAS MESURER | | DATE 90-08-23 |
| MATERIAL | | | | NO DESIGN 007-0019 |
| | | | | DUNSMUIR VILLE, QUEBEC, CANADA. ALAIN |

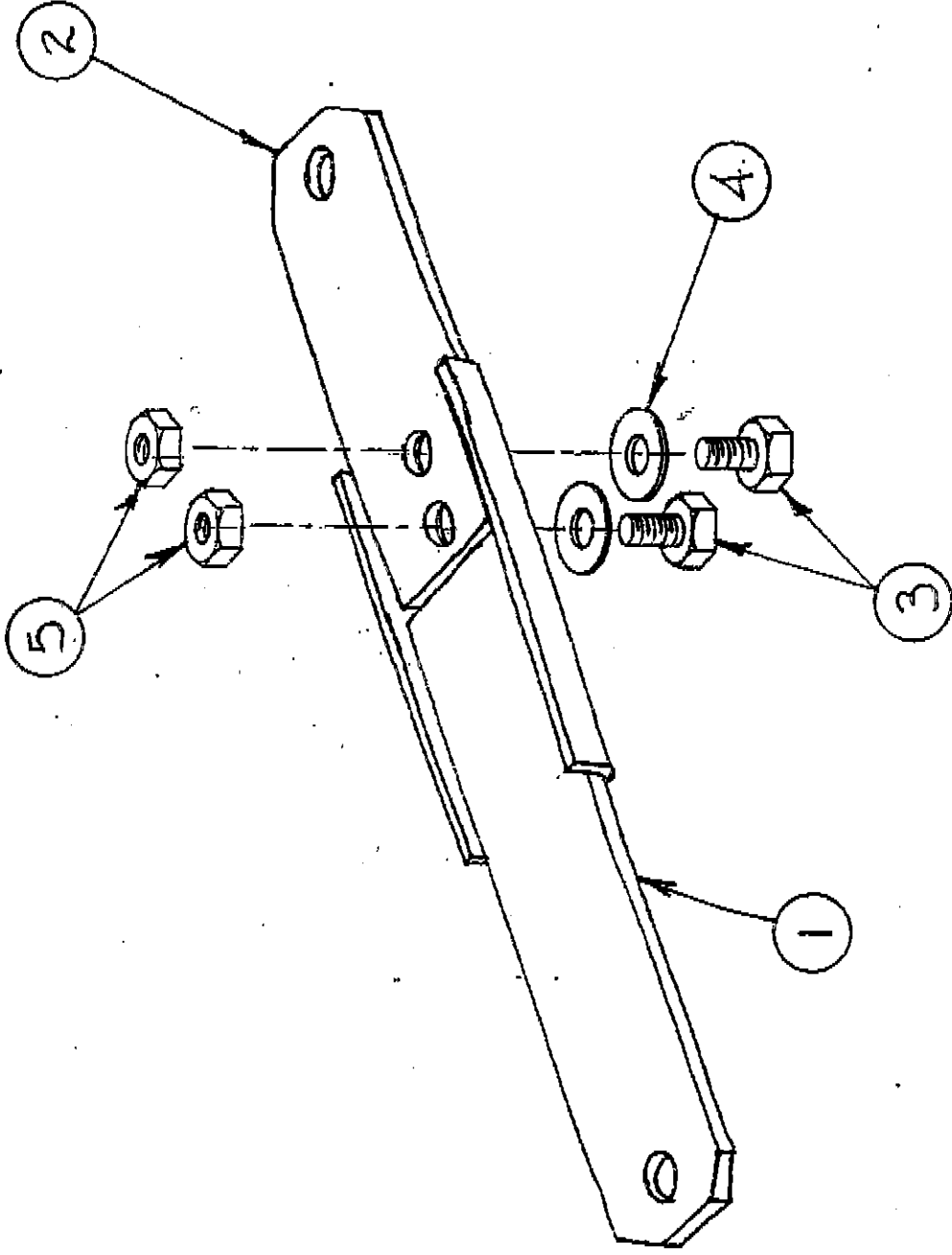
GAS



SET TO A MAXIMUM OF 30 PSI

| | | | | | |
|-------------|--|---------------------------|--|------------------------------|--|
| NON MACHINE | | VACUUM 600 | | TOLERANCE | |
| HOW MADE | | PNEUMATIC DRAWING | | 4 1 5 | |
| MATERIAL | | PRESSURE REGULATOR OPTION | | .001 .005 | |
| DATE | | NE PAS MESURER | | .000 1 .0005 | |
| DRAWN BY | | ALAIN | | DATE | |
| 90-08-23 | | 007 0020 | | DUNHAM WILK, QUEBEC, CANADA. | |

005-0290



| | | | |
|------|----------|-----------------------|-----|
| 5 | 051-0580 | ECROU 1/4"x20 | 2 |
| 4 | 051-0740 | RAIPELLE PLATE 1/4" | 2 |
| 3 | 051-0190 | BOULON 1/4"x20 x 3/4" | 2 |
| 2 | 001-1084 | BRAS DU GUIDE | 1 |
| 1 | 004-0084 | PRE-ASS. BRAS GUIDE | 1 |
| 1107 | #PIECE | DESCRIPTION | QTE |

NON DÉCHIRER

VACUUM 600

NOUVEAU

ASS. BRAS GUIDE

NE PAS MESURER

DATE: 15/08/08

REVISION: 15

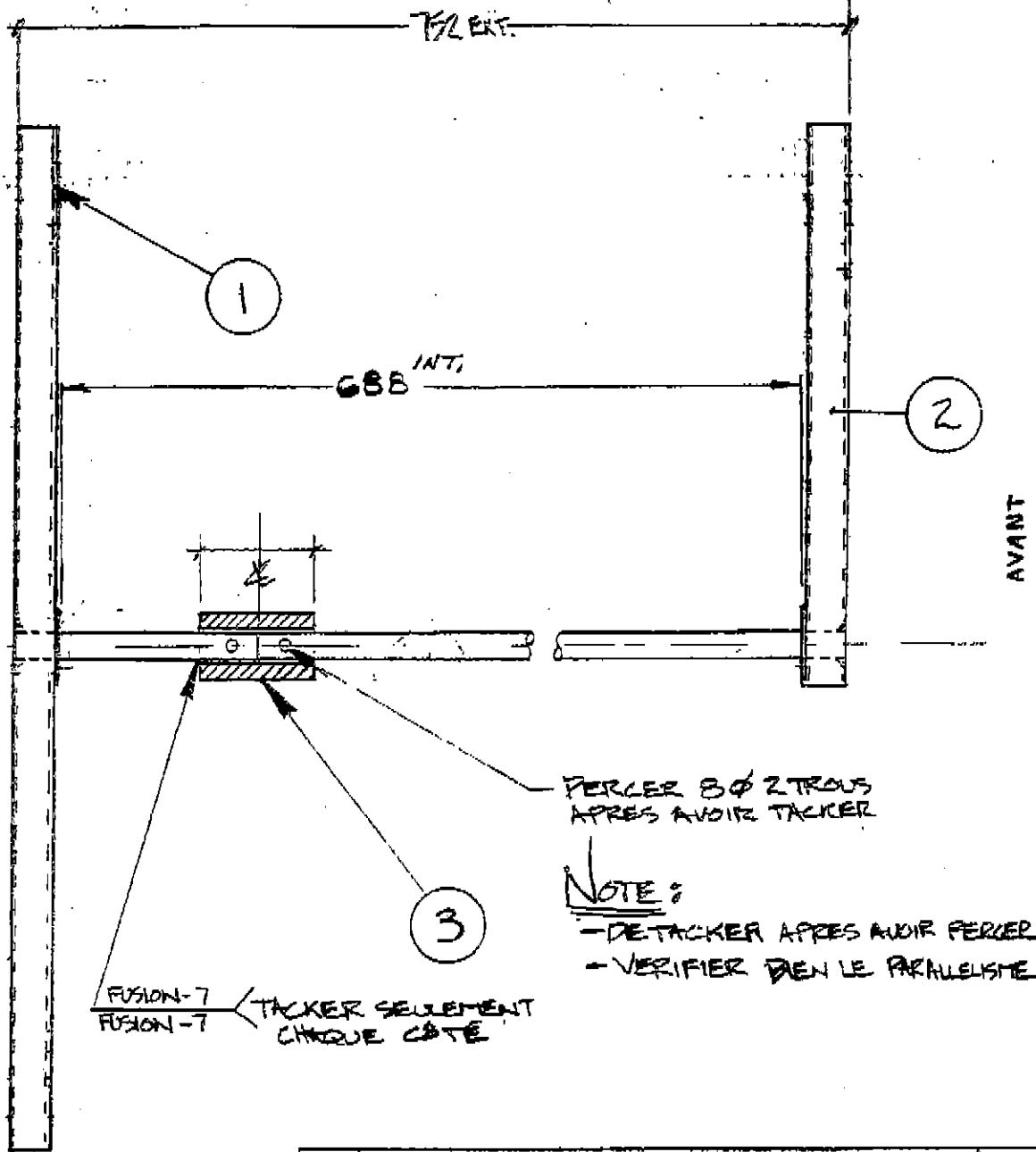
PROJ: PAVE A

TOLERANCE
 ± 0.15
 ± 0.05
 ± 0.003
 ± 0.000




DRUMMOND HILL, QUEBEC, CANADA.

005-0290



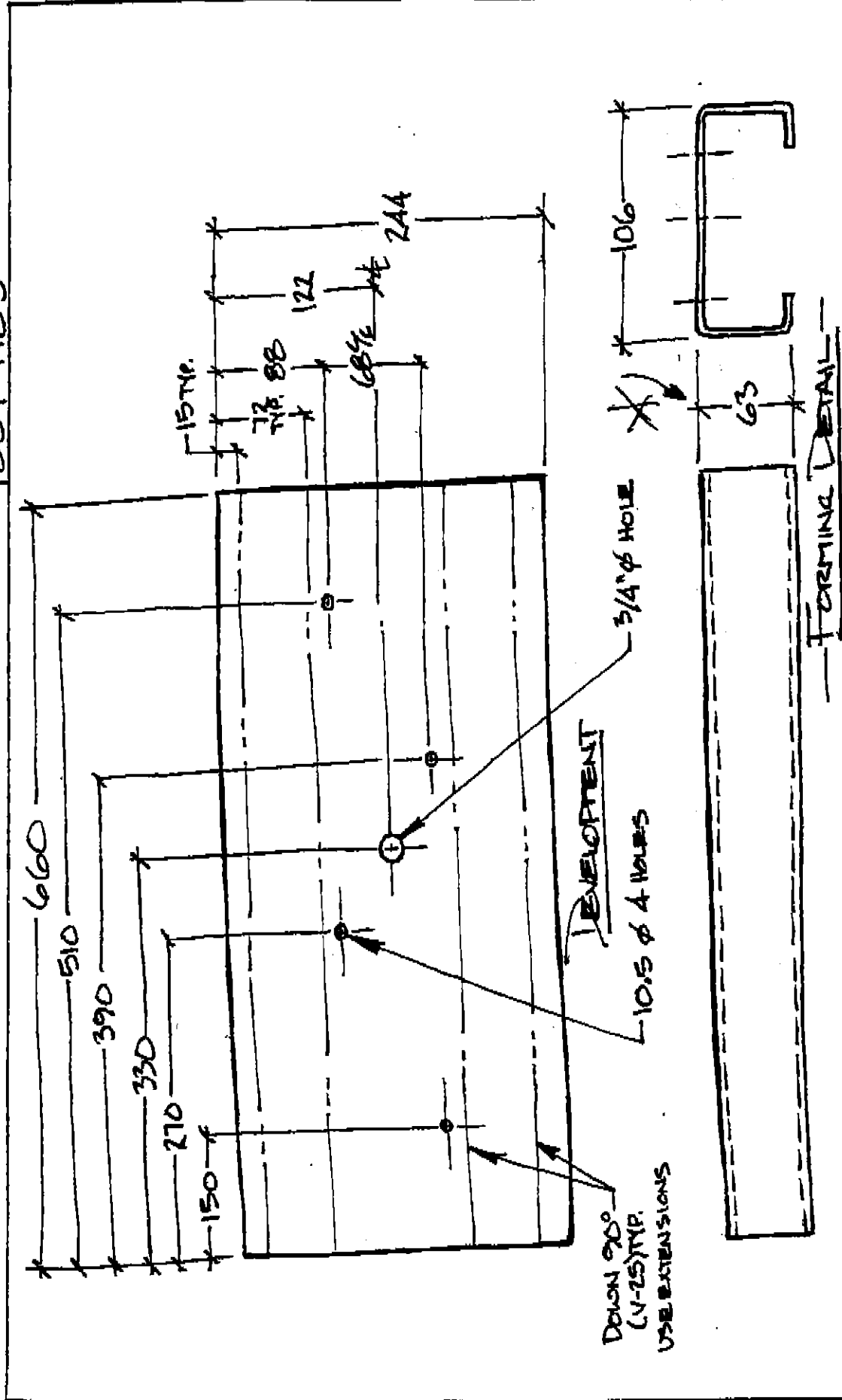
| 3 | 002-0297 | UNION DES BRAS | 1 |
|------|----------|-----------------------|-----|
| 2 | 004-0098 | ASSEMBLE BRAS AVANT | 1 |
| 1 | 004-0099 | ASSEMBLE BRAS ARRIERE | 1 |
| ITEM | #PIECE | DESCRIPTION | QTE |

| | | | | |
|---|------|---|-------------------------|--|
| NOM MACHINE VACUUM-600 | | TOLERANCE D : .5 mm D : .01 mm .00 : .001 mm .000 : .0001 mm ANGLE : 030 | |  DRUMMOND VILLE, QUEBEC, CANADA. |
| NOM PIECE PRE-ASSEMBLE DES BRAS | | | | |
| QTE. 1 | ECH. | FILIERE | OP. | NO DESSIN 004-0101 |
| MATERIEL | | DESSINE DAVE A | DATE 90-08-15 | |

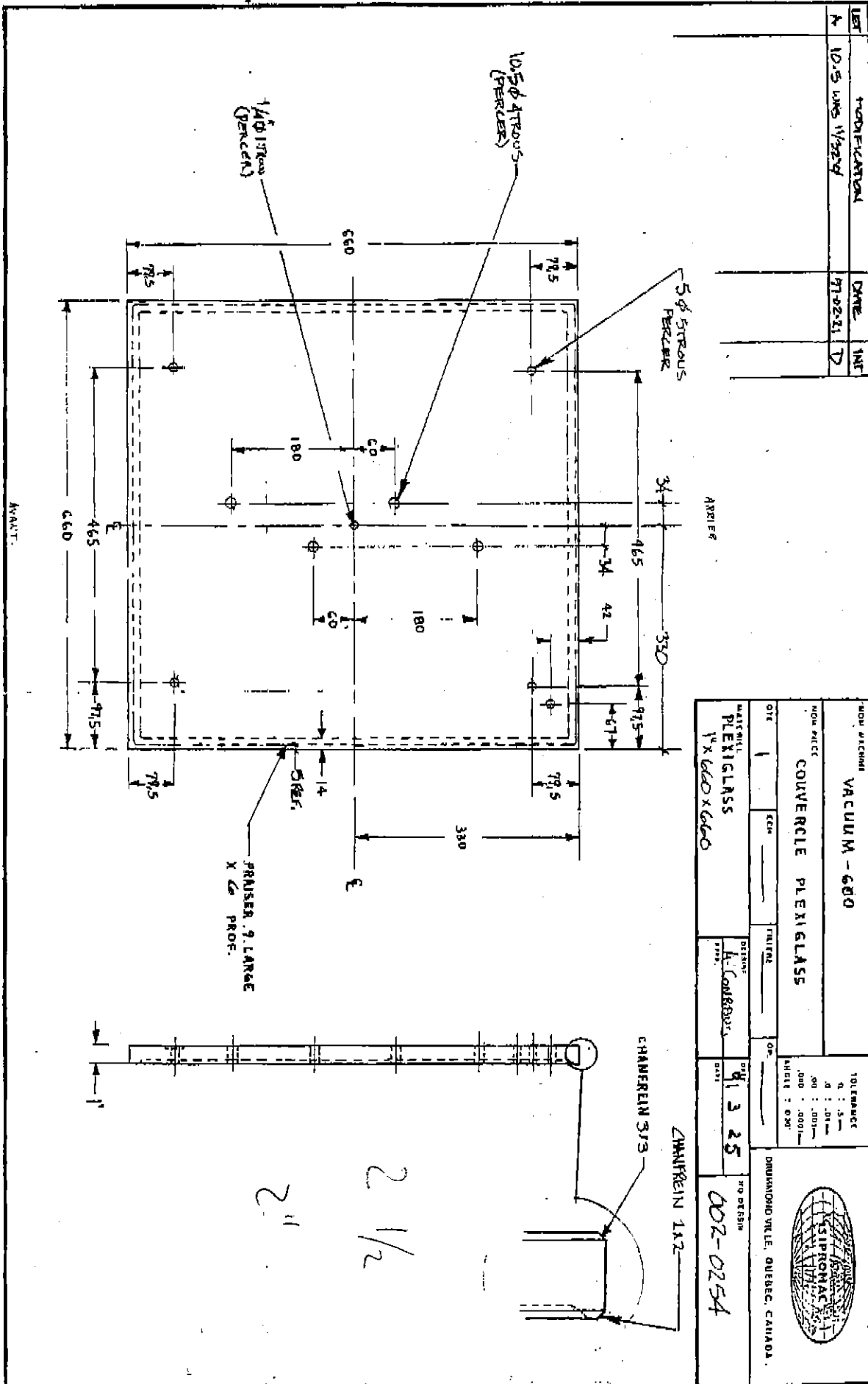
004-0101

1/11/2007 10:45 AM
1/11/2007 10:45 AM
1/11/2007 10:45 AM

001-1183



| | | | |
|---|--------------|--|--------------------------|
| LET. | MODIFICATION | DATE | INT. |
| | | | |
| MAGN. 1-600 PART COVER REINFORCEMENT | | DWS 01183 DATE 97-02-21 | N.T.S. SCALE 1 |
| DRAWN S/S 304-25 CHECKED S/S 600 & 23A | | DWS 01183 DATE 97-02-21 | NO. 001-1183 |
| SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA | | | |

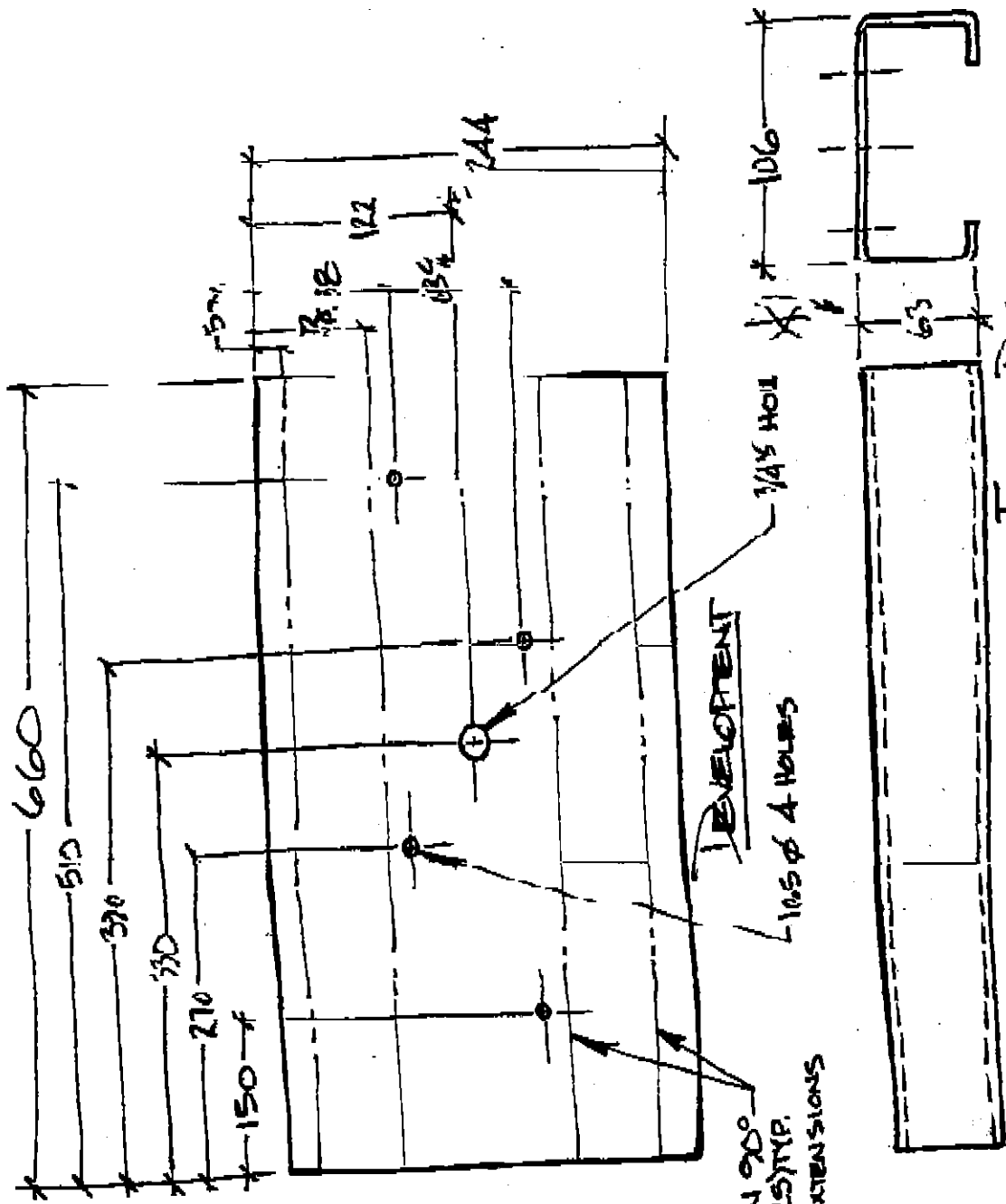


A MOBIL & REDRESSINE 91-12-30 ML VAC. 001-1264 of 1285

2 1/2
2 1/2

1/11/07 Rev 1 Clean All with Ear on Milling Flats Angle

001-1183



DOWN 90°
(V-25)TP.
USE EXTENSIONS

ENVELOPMENT

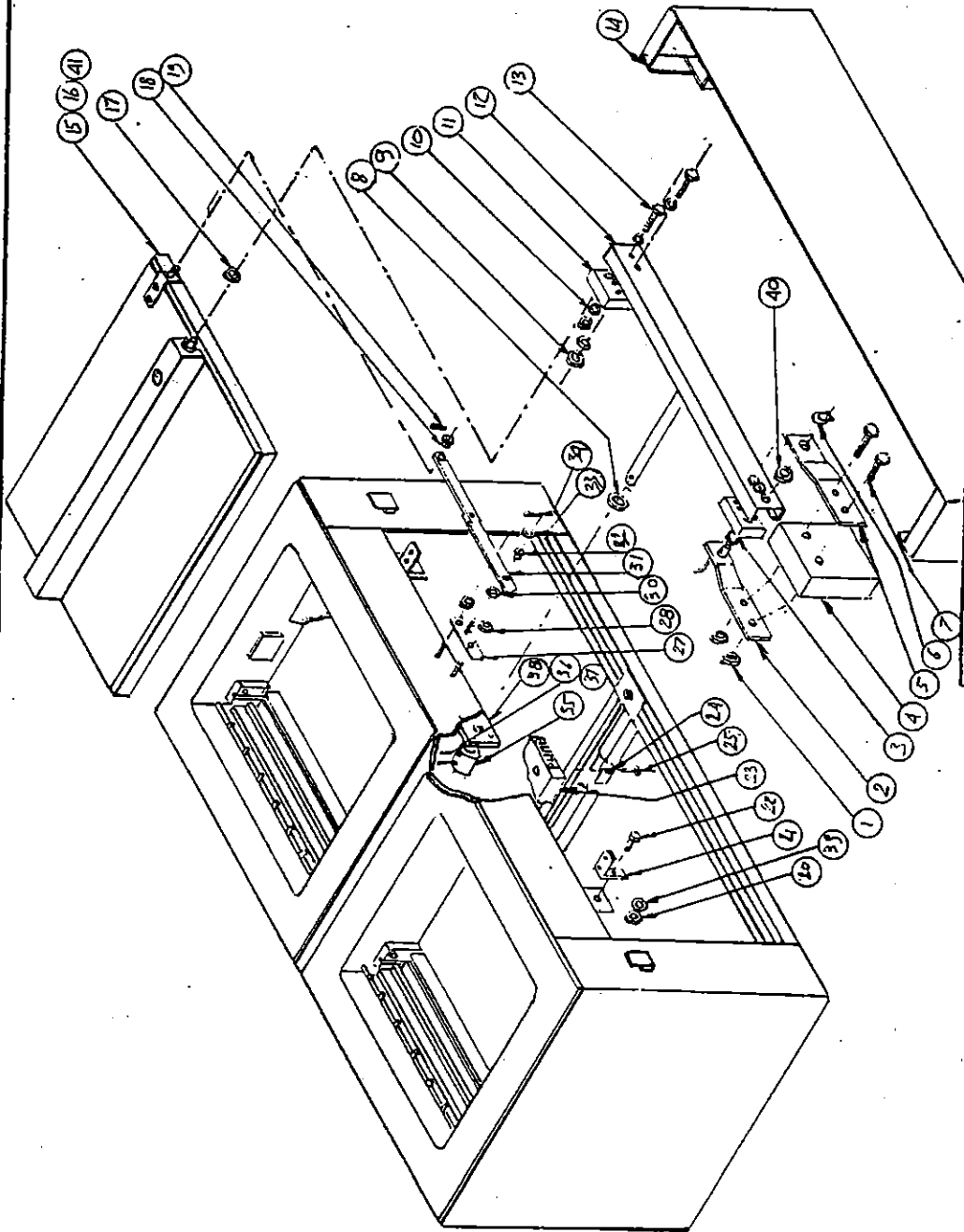
105 Ø 4 HOLES


1/4\"/>

63

FORMING DETAIL

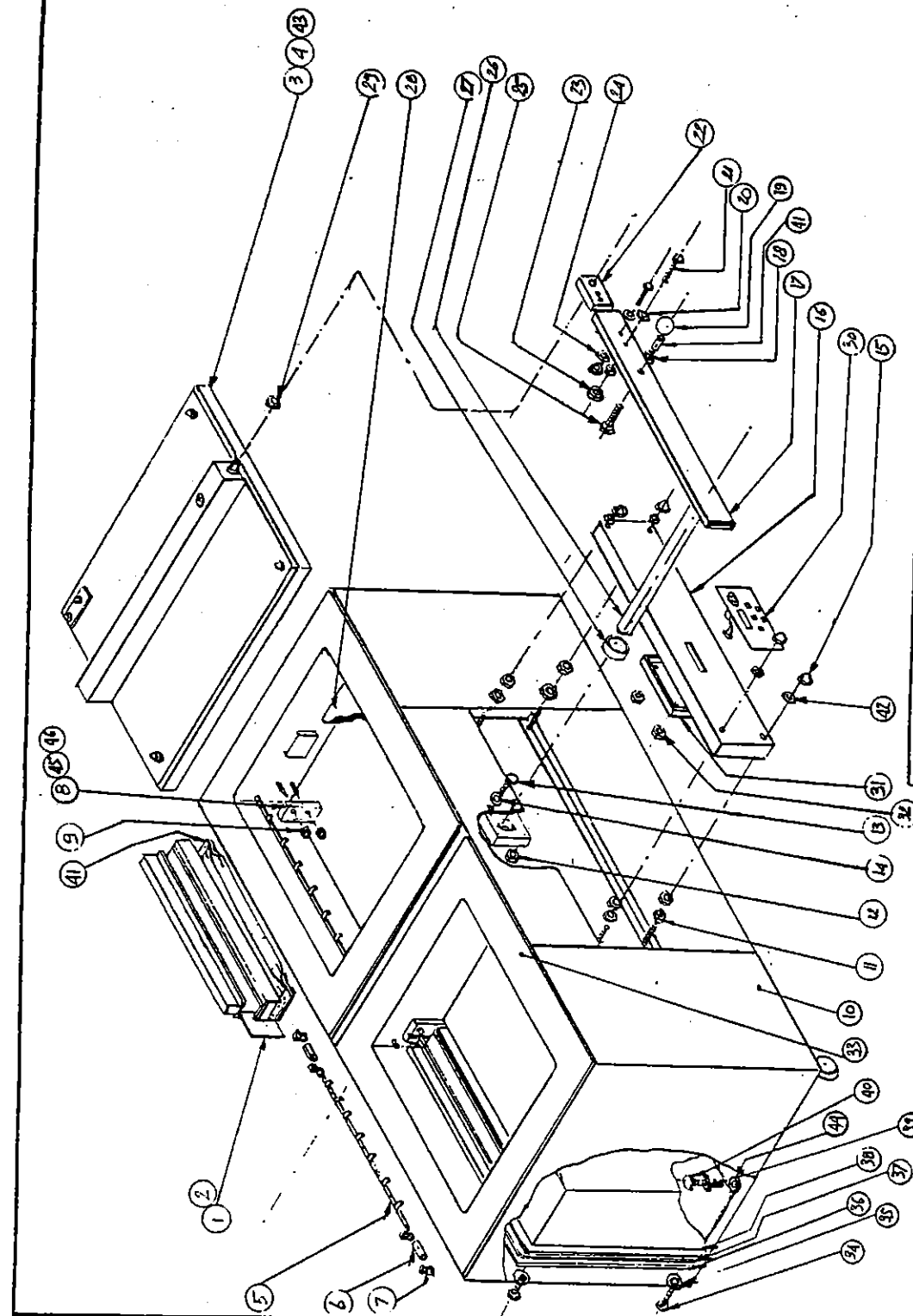
| | | | | | | | | |
|--------------|------------------|-----|--------|------------------------|--|---------------|--|--|
| UNIQUE | --- | 000 | | | | | | |
| PART | COVER REINFORCER | | | | | | | |
| FROM | 175-0510M1062 | REV | 011953 | | | | | |
| MTN | S/S 3042E | | | | | | | |
| | SI, 6600, 124 | | | | | | | |
| | | | | | | | | |
| LET. | | | | | | | | |
| MODIFICATION | | | | | | | | |
| DATE | | | | | | | | |
| INT. | | | | | | | | |
| SIPROMAC | | | | ST-TERRAIN DE GRANTHAM | | QUEBEC CANADA | | |
| N.T.S. | | | | SCALE | | 1 BL 1 | | |
| 001-1183 | | | | 001-1183 | | 001-1183 | | |




| | | | |
|--|------|---------------------------------|------|
|  | | DRUMMOND VILLE, QUEBEC, CANADA. | |
| TOLERANCE ± .005 ± .0025 ± .0015 ± .001 | | NO DESIGN | |
| VACUUM 600 | | NE PAS MESURER | |
| ASSEMBLY REAR VIEW | | 90-08-23 | |
| QTY. 1 | ECH. | VISITEUR ALAIN | DATE |
| MATERIEL | | 005-0275 | |

| ITEM # | PIECE | DESCRIPTION | QTY |
|--------|----------|------------------------------|-----|
| 41 | 005-0299 | BIACTIVE SEAL COVER (OPT) | 1 |
| 40 | 002-0288 | CONNECTER WEIGHT SPACER | 2 |
| 39 | 051-0740 | FLAT WASHER 1/4" | 2 |
| 38 | 002-0299 | CENTER ARM BUSHING | 2 |
| 37 | 056-0005 | SPRING PIN 5/16" x 2" | 2 |
| 36 | 056-0004 | SPRING PIN 3/16" x 2" | 2 |
| 35 | 002-0297 | SHAFT NYLON | 1 |
| 34 | 056-0012 | CUTTER PIN 1/8" x 1" | 1 |
| 33 | 051-0740 | FLAT WASHER 1/4" | 1 |
| 32 | FB-46-2 | BRONZE BUSHING 1-3/8" x 1/2" | 1 |
| 31 | 005-0280 | COVER GUIDE ARM ASSEMBLY | 1 |
| 30 | 051-0740 | FLAT WASHER 1/4" | 1 |
| 28 | 051-0581 | NYLON LOCKNUT 1/4"-20 | 2 |
| 27 | 005-0163 | GUIDE ARM PIVOT SHIFT | 1 |
| 25 | 052-4220 | BOLT M 8-20 | 3 |
| 24 | 001-0189 | PUMP SUPPORT | 3 |
| 23 | ----- | VACUUM PUMP 63" | 1 |
| 22 | 051-0180 | BOLT 1/4"-20 x 1/2" | 2 |
| 21 | 001-0710 | SWITCH SUPPORT | 2 |
| 20 | 051-0580 | NUT 1/4" - 20 | 1 |
| 19 | 056-0012 | CUTTER PIN 1/8" x 1" | 1 |
| 18 | FB-46-2 | BRONZE BUSHING 1-3/8" x 1/2" | 1 |
| 17 | 002-0074 | LOWER ARM SPACER | 1 |
| 16 | 005-0273 | REC. BAG OUT COVER ASSEM. | 1 |
| 15 | 005-0272 | STANDARD COVER ASS. | 1 |
| 14 | 005-0284 | REAR PANEL ASSEMBLY | 1 |
| 13 | 051-0250 | BOLT 1/4" - 20 x 1 1/2" | 2 |
| 12 | 004-0088 | REAR ARM ASSEMBLY | 1 |
| 11 | 002-0300 | ARM BUSHING | 1 |
| 10 | 051-0740 | FLAT WASHER 1/4" | 4 |
| 9 | 051-0581 | NUT 1/4" - 20 | 2 |
| 8 | 002-0301 | BODY ARM SPACER | 1 |
| 7 | 051-0410 | BOLT 3/8" - 16 x 2 3/4" | 2 |
| 6 | ----- | CIRCLIP | 1 |
| 5 | 001-1191 | COUNTER WEIGHT SUPPORT | 1 |
| 4 | 008-0277 | COUNTER WEIGHT | 1 |
| 3 | 002-0242 | BOTTOM ARM BUSHING | 1 |
| 2 | 005-0288 | COUNTER WEIGHT SUPPORT AS | 1 |
| 1 | 051-0620 | NUT 3/8" - 16 | 2 |
| ITEM # | PIECE | DESCRIPTION | QTY |

| ITEM # | PIECE | DESCRIPTION | QTE | ITEM # | PIECE | DESCRIPTION | QTE |
|--------|----------|------------------------|-----|--------|----------|------------------------------|-----|
| 40 | 051-0180 | BOLT 1/4"-20 x 1 1/2" | 3 | 46 | 002-0030 | RIGHT SEAL BAR GUIDE | 4 |
| 39 | 051-0740 | FLAT WASHER 1/4" | 6 | 45 | 002-0029 | LEFT SEAL BAR GUIDE | 4 |
| 38 | 005-0035 | ELECTRIC BOX ASSEMBLY | 1 | | | | |
| 37 | ----- | GASKET 3/8" | 1 | | | | |
| 36 | 001-0137 | COVER | 1 | | | | |
| 35 | 051-0740 | FLAT WASHER 1/4" | 4 | 44 | 051-0580 | SCREW 1/4"-20 | 3 |
| 34 | 051-0180 | BOLT 1/4"-20 x 1 1/2" | 4 | 43 | 005-0299 | COVER ASSEMBLY (ACTIVE SEAL) | 1 |
| 33 | 005-005 | CHAMBER ASSEMBLY | 1 | 42 | 051-0740 | FLAT WASHER 1/4" | 4 |
| 32 | 051-0580 | NUT 1/4"-20 | 4 | 41 | 008-119 | SPACER BLACK PLASTIC KNOB | 1 |
| 31 | 005-0291 | PC BOARD SUPPORT | 1 | | | | |
| 30 | ----- | SIPROMAC TOUCH PAD | 1 | | | | |
| 29 | 007-0074 | COVER SPACER | | | | | |
| 28 | 005-005 | SPACER ASSEMBLY | 1 | | | | |
| 27 | 002-0301 | COVER ARM SPACER | 1 | | | | |
| 25 | 051-0350 | BOLT 3/8" -16 x 3/4" | 1 | | | | |
| 24 | 051-0740 | FLAT WASHER 1/4" | 2 | | | | |
| 23 | 051-0581 | NYLON LOCKNUT 1/4"-20 | 2 | | | | |
| 22 | 002-0300 | ARM BUSHING | 1 | | | | |
| 21 | 051-0250 | BOLT 1/4"-20 x 1 1/2" | 2 | | | | |
| 20 | 051-0740 | FLAT WASHER 1/4" | 2 | | | | |
| 19 | 051-001 | BLACK PLASTIC KNOB | 1 | | | | |
| 18 | 051-0780 | FLAT WASHER 3/8" | 1 | | | | |
| 17 | 004-0088 | FRONT ARM ASSEMBLY | 1 | | | | |
| 16 | 005-0127 | CONTROL PANEL ASSEMBLY | 1 | | | | |
| 15 | 051-0581 | ACORN NUT 1/4"-20 | 4 | | | | |
| 14 | 051-0740 | FLAT WASHER 1/4" | 4 | | | | |
| 13 | 051-0250 | BOLT 1/4"-20 x 1 1/2" | 4 | | | | |
| 12 | 051-0581 | NYLON LOCKNUT 1/4"-20 | 4 | | | | |
| 11 | 051-0580 | NUT 1/4"-20 | 8 | | | | |
| 10 | 005 | BODY ASSEMBLY | 1 | | | | |
| 9 | 051-0581 | NYLON LOCKNUT 1/4"-20 | 16 | | | | |
| 8 | 002-0057 | SEAL BAR GUIDE | 8 | | | | |
| 7 | 8425 | TUBE CLAMPS | 16 | | | | |
| 6 | 008- | TUBE (GAS INJECTION) | 2 | | | | |
| 5 | 00C- | GAS INJECT. BAR | 4 | | | | |
| 4 | 005-0273 | REC. BAG CUT COVER AS | 1 | | | | |
| 3 | 005-0272 | COVER ASSEMBLY | 1 | | | | |
| 2 | 005-0271 | SEAL BAR ASSEMBLY | 4 | | | | |
| 1 | 005-0270 | SEAL BAR ASSEMBLY | 4 | | | | |





SIPROMAC
DRUMMOND VILLE, QUEBEC, CANADA.

| | | |
|--|--------|---|
| VACUUM 600 ASSEMBLY FRONT VIEW | | TOLERANCE ± .5 ± .05 ± .005 ± .0005 ANGLE : 1° |
| QTY 1 | ECH. 1 | NE PAS MESURER |
| MATERIEL | ALAIN | DATE 80-08-23 |
| NON MACHINE | | NO DESEM 005-0274 |

| ITEM # | PIECE | DESCRIPTION | QTE |
|--------|----------|------------------------------|-----|
| 46 | 002-0030 | RIGHT SEAL BAR GUIDE | 4 |
| 45 | 002-0029 | LEFT SEAL BAR GUIDE | 4 |
| 44 | 051-0580 | SCREW 1/4"-20 | 3 |
| 43 | 005-0299 | COVER ASSEMBLY (ACTIVE SEAL) | 1 |
| 42 | 051-0740 | FLAT WASHER 1/4" | 4 |
| 41 | 008-119 | SPACER BLACK PLASTIC KNOB | 1 |