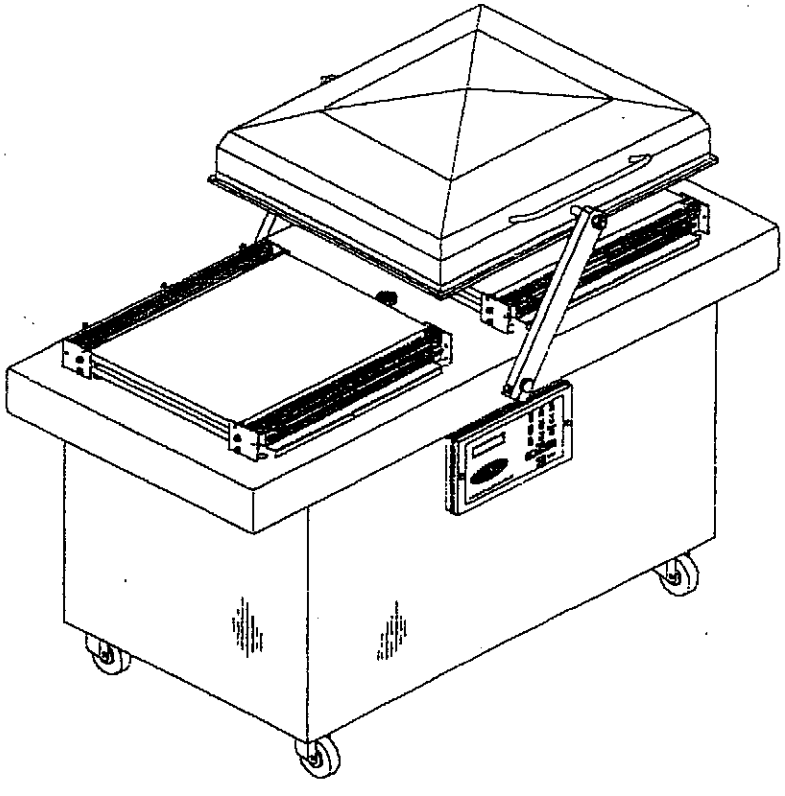
SIPROMAC

MODEL
600A

2011



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

Safe Operation Practices

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 vacuum 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 instruction regarding this machine in the owners manual.

VACUUM PACKAGING MACHINE

MODEL 600A

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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

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

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

3. OPERATION:

3.1 Working principles:

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

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.

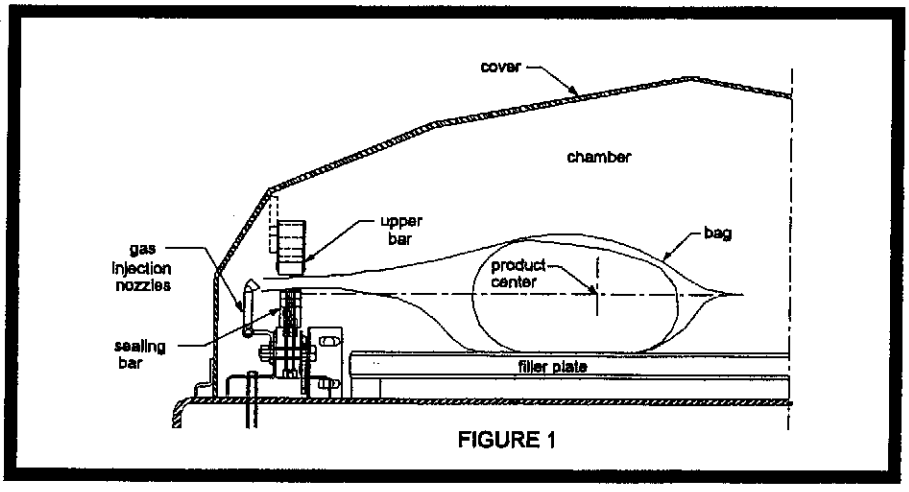


FIGURE 1

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

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

The necessary gas tank and pressure valve mounted on tank is not supplied by Sipromac. The pressure of the gas regulator should be set at approximatly 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 Top and bottom sealing (optional):

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

3.2.3 Electrical bag cut (optional):

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

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 8 and the keyboard detail on page 9.

3.3.1 Basics:

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

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

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

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

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

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

3.3.2 Functions menu:

3.3.2.1 Create a program:

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

3.3.2.2 Delete a program:

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

3.3.2.3 Select operating mode:

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

3.3.3 Programs menu:

3.3.3.1 Program identification:

For a selected program, set the identification, using the numeric keyboard characters chart; press numeric key untill 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 level setting:

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

Examples:
90.0% → keys 9, 0, 0 or 9, 0, ENTER or
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

3.3.3.3 Vacuum plus time setting:

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

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

3.3.3.4 Gas flush level setting:

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

3.3.3.5 Sealing time setting:

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

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

3.3.4 Vacuum cycle execution:

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

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

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

3.3.5 System monitor:

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

-MENUS STRUCTURE-

- Functions menu:

  "F1 CREATE A PRGM"
  "F2 DELETE A PRGM"
  "F3 SELECT OPMODE" (automatic units only)

- Programs menu:

  "Pxx NAME"

  Program submenu:

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

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

  "DIAGNOSTICS MENU" (access code required)

  "D1 INPUTS TEST"

  "D2 OUTPUTS TEST"

  "D3 MODEL SELECT"

  "D4 GAS OPTION"

  "D5 SEALING TIME"

  "D6 COOLING TIME"

  "D7 LOADING TIME" (automatic units only)

  "D8 UNLOADNG TIME" (automatic units only)

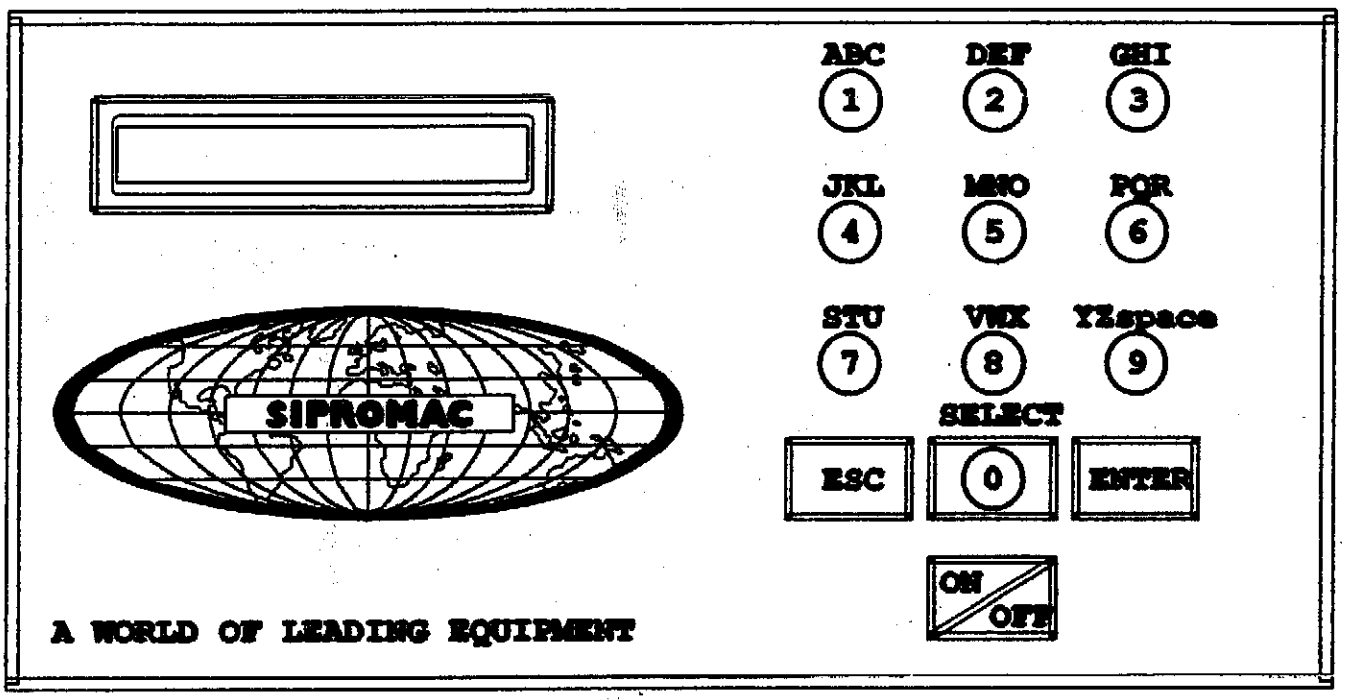
  "SYSTEM MONITOR" (no access code required)

  "SOFTWARE: R x.xx"

  "WORK HRS: xxxxx"

  "CYCLES: xxxxxxx"

-KEYBOARD DETAILS-



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

3.4 Daily cleaning:

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

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "VACUUM ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

No pressure variation is picked up by the PCB transducer 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.

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

If troubles described under 4.2.1 and 4.2.2 do not apply, there is something wrong with the evacuation.To find the leakage quickly, check for leaks with a precision 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.

Warning: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).

Warning: Do not increase sealing time more than really necessary; higher temperature will reduce working life of teflon and silicone rubber.

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

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

4.5 MC40 Control board failure

NOTE:Refer to menu structure on page 8.

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

By 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 component:vacuum pump, valves..., electrical contactors, thermal overload, fuses holder or transformer.

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

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

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

Check vacuum connections for tightness.

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

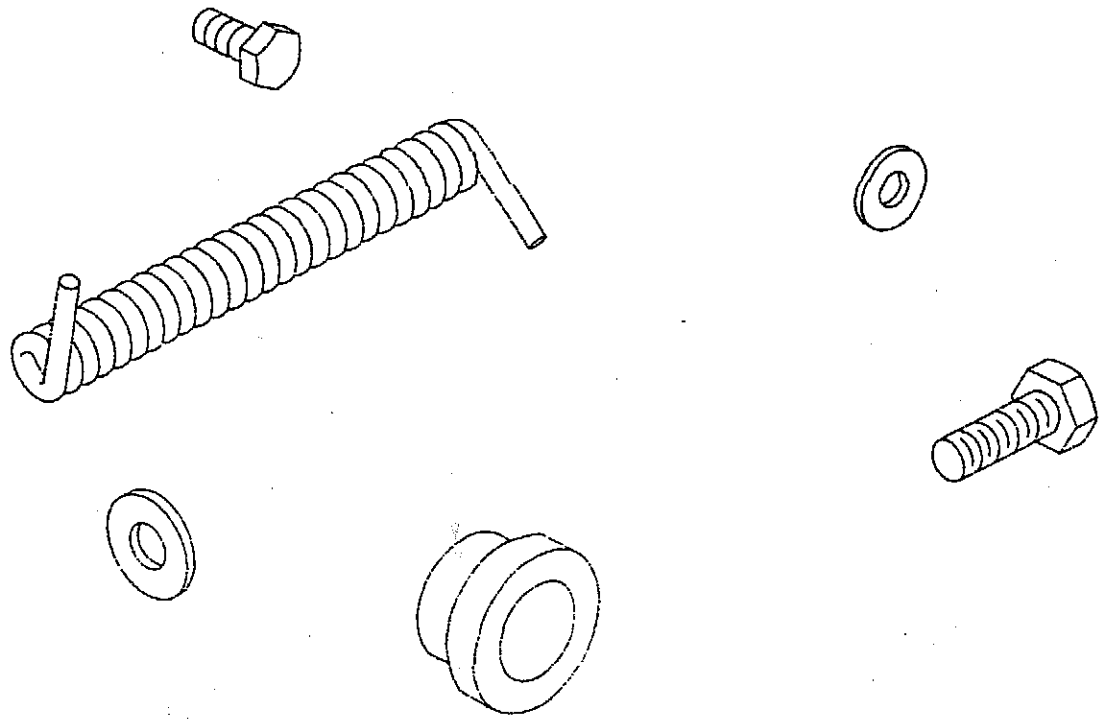
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

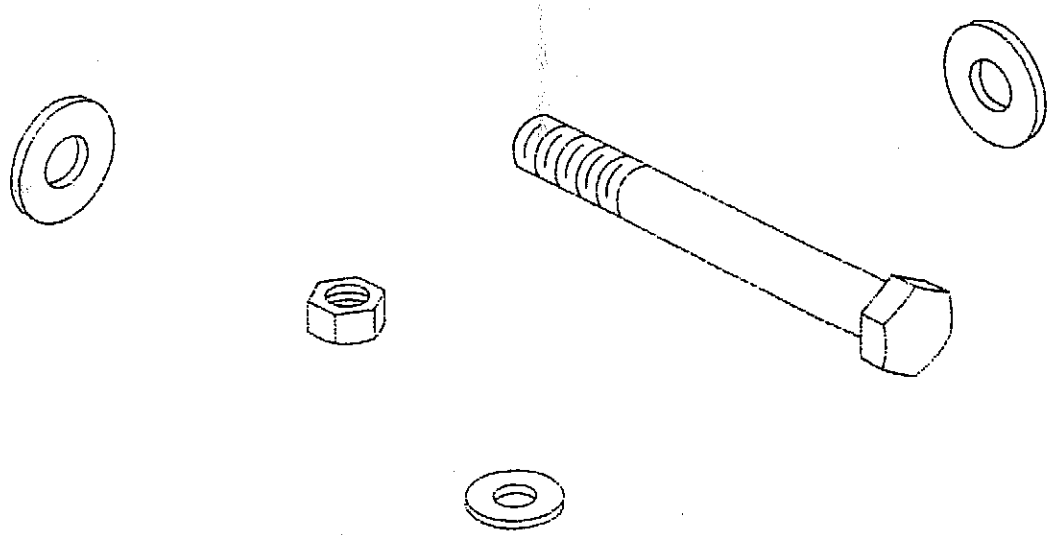
INSTALLATION NOTICE FOR MODELS:
420A,450T,450A,550A,600A,620A, 650A AND 700A

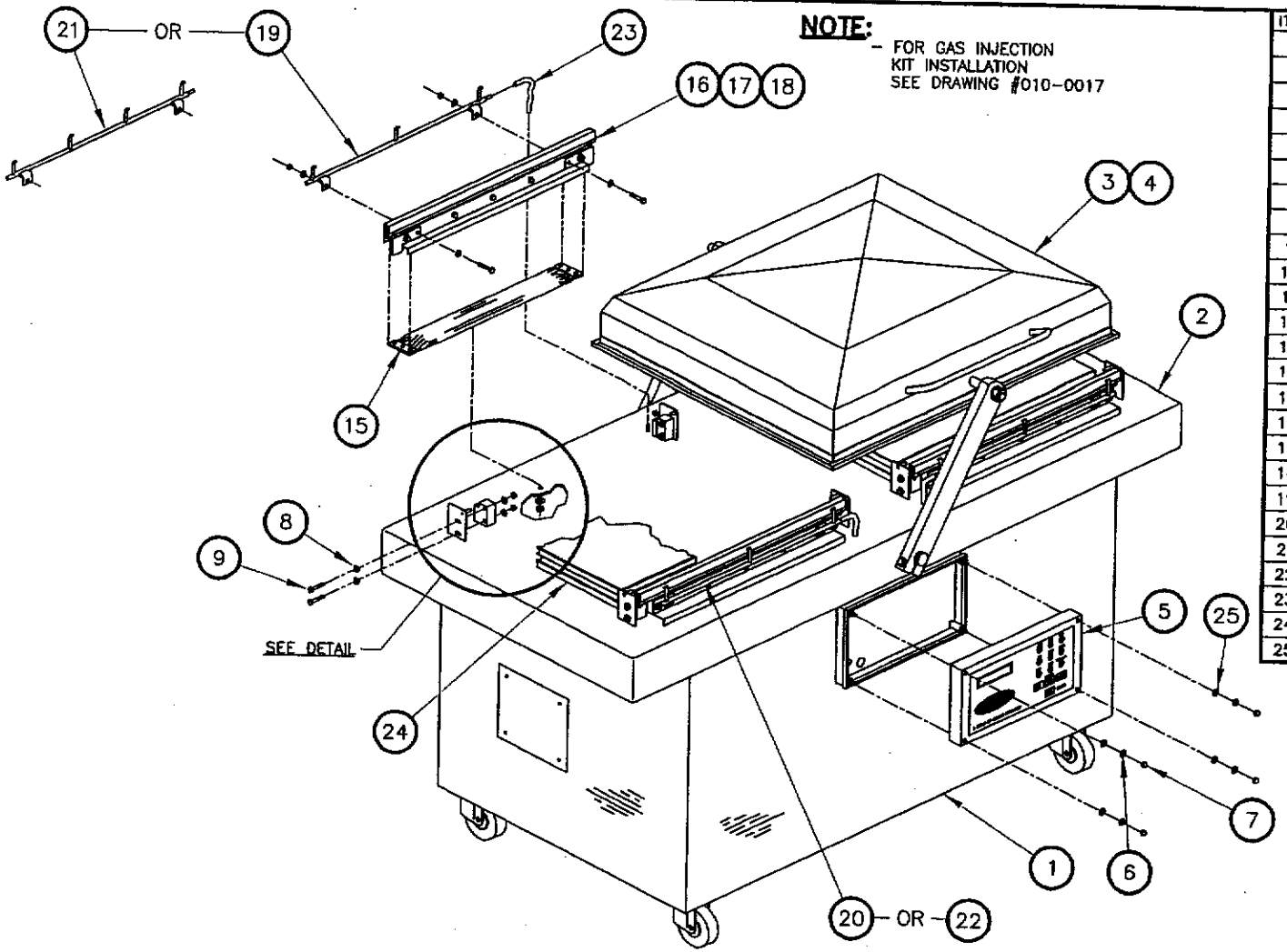
IN ORDER TO RESPECT NSF REGULATIONS:

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



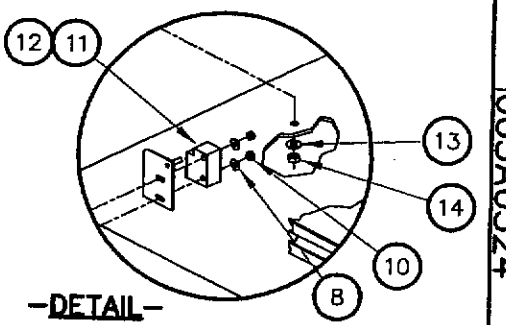
MECHANICAL DRAWING





NOTE: - FOR GAS INJECTION KIT INSTALLATION SEE DRAWING #010-0017

ITEM	PART #	DESCRIPTION	QT.
1	005A0457	STRUCTURE ASSEMBLY	1
2	005-0150	TABLE ASSEMBLY	1
3	005-0453	8" COVER ASSEMBLY	1
4	005-0454	12" COVER ASSEMBLY (OPT.)	1
5	005A0583	P.C. BOARD SUPPORT ASS'Y	1
6	051-0740	FLAT WASHER 1/4" S/S	4
7	051-0591	ACORN NUT 1/4"-20 NC. S/S	4
8	051-0740	FLAT WASHER 1/4" S/S	32
9	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	16
10	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	16
11	002-0326	LEFT/ SEAL BAR GUIDE BLOCK	4
12	002-0327	RIGHT/ SEAL BAR GUIDE BLOCK	4
13	051-0780	FLAT WASHER 3/8" S/S	4
14	051-0620	HEX. NUT 3/8"-16 NC. S/S	4
15	005-0320	BELLOWS ASSEMBLY	4
16	005A0568	SEAL BAR ASS'Y W/ SUPPORT	4
17	005A0569	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	4
18	005A0570	SEAL BAR ASS'Y W/ SUPPORT (TOP & BOT OPT.)	4
19	005A0810	GAS 3 INJECTION BAR ASS'Y (OPT.)	2
20	005-0571	GAS 3 INJECTION BAR ASS'Y (OPT.)	2
21	005A0811	REAR GAS 4 INJECTION BAR ASS'Y (OPT.)	2
22	005A0446	FRONT GAS 4 INJECTION BAR ASS'Y (OPT.)	2
23	008-0464	GAS INJECTION CONNECTION TUBE	4
24	005-0322	FILLER PLATE ASSEMBLY	4
25	057-0089	1/4" x 5/8"O.D. EPDM RUB. SEAL. WASHER	4



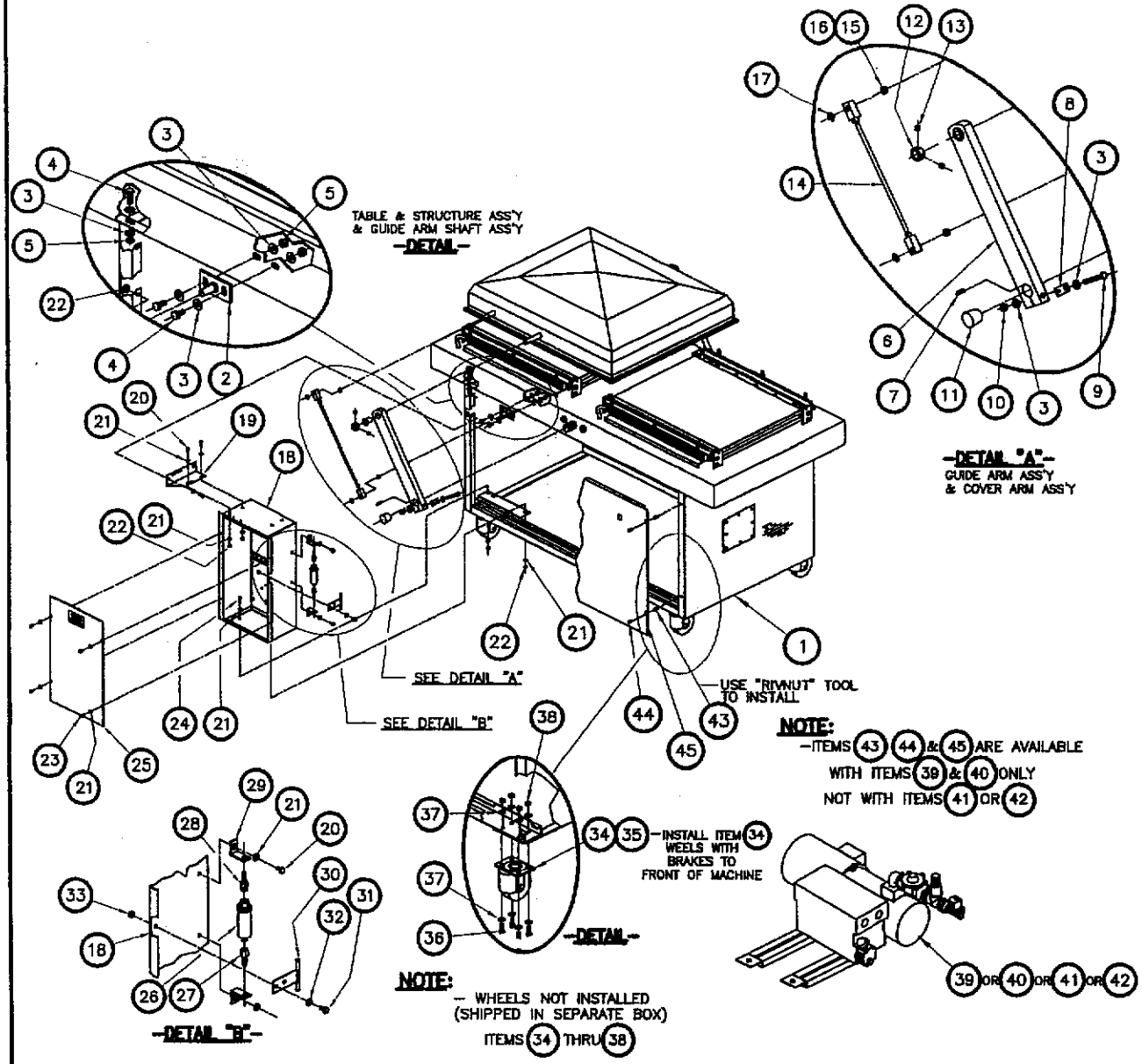
-DETAIL-

005A0324

J	REDRAWN	05-09-07	M.A.L.
ET.	MODIFICATION	DATE	INT.

MACHINE: 600A	METRIC TOLERANCE: 0. ± .8, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC, ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PART: MACHINE ASSEMBLY FRONT VIEW	N.T.S.		
ITEM:	CNC:		M-I / QT. 1
MAT:	DWG BY: M.A. LEBLANC / APP.	DATE: 05-09-07 / DATE: 24-02-09	NO. 005A0324

005-0325



ITEM	#PART	DESCRIPTION	QT.
1	005-0324	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0317	GUIDE ARM SHAFT ASSEMBLY	1
3	051-0783	FLAT WASHER (THICK) 3/8" S/S	20
4	051-0360	HEX. BOLT 3/8"-16 NC. X 1" S/S	8
5	051-0620	HEX. NUT 3/8"-16 NC. S/S	8
6	004-0280	COVER ARM ASS'Y	2
7	056-0167	KEY 1/4" SQ x 1" W/ ROUNDED END	2
8	001-1876	LOWER WIRE SUPPORT (TOP & BOT OPT.)	1
9	051-0422	HEX. BOLT 3/8"-16NC. X 3 1/4" S/S	2
10	051-0622	HEX. NUT 3/8"-16 NC. NYLON LOCK S/S	2
11	057-0013	CENTRAL SHAFT END CAP	2
12	002-0390	SET SCREW COLLAR	2
13	051-0178	SET SCREW 1/4"-20 X 5\16" S/S	4
14	004A1394	GUIDE ARM PRE-ASSEMBLY	1
15	058-0050	SPACERS	2
16	058-0060	SPACERS	2
17	056-0331	EXT. RETAINING RING 1/2" S/S	2
18	005-0374	ELECTRICAL BOX PRE-ASSEMBLY	1
19	001-1364	LEFT/ ELECTRICAL BOX UPPER SUPPORT	1
20	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	3
21	051-0740	FLAT WASHER 1/4" S/S	13
22	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	3
23	052-0402	HEX. BOLT 1/4"-20 X 1/2" BRASS	4
24	051-0190	HEX. BOLT 1/4"-20 NC. X 3/4" S/S	2
25	004-0279	ELECTRICAL BOX COVER PRE-ASS'Y	1
26	114-2020	DRYER FILTER	1
27	101-0210	STRAIGHT 1/4" FNPT X 1/4" HOSE	1
28	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
29	001-2062	DRYER SUPPORT	2
30	005-0323	GAS INLET ASSEMBLY (OPTION)	1
31	051-0180	HEX BOLT 1/4"-20 NC X 1/2" S/S (OPTION)	1
32	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
33	051-0581	HEX NUT 1/4"-20 NC NYLON LOCK S/S (OPTION)	1
34	130-4PHB	4" PL. CASTER SWIVEL W/ BRAKE	2
35	130-4PHO	4" PL. CASTER SWIVEL W/ O BRAKE	2
36	052-0520	BOLT 5/16"-18 NC. X 3/4" ZINC	16
37	051-0760	FLAT WASHER 5/16" S/S	32
38	052-3110	NUT 5/16"-18 NC. ZINC	16
39	004A1470	"BUSCH" 63M3 & PLUMBING	1
40	004A1468	"BUSCH" 100M3 & PLUMBING	1
41	004A1469	"BUSCH" 165M3 & PLUMBING	1
42	004A1471	"BUSCH" 255M3 & PLUMBING	1
43	056-0130	RIVNUT 1/4"-20 ALUMINIUM (OPTION)	4
44	052-0420	SCREW 1/4"-20 x 3/4" RND SLOT BRASS (OPTION)	4
45	004-0726	REAR PANNEL PRE-ASS'Y (OPTION)	1

LET.	MODIFICATION	DATE	INT.
N	MODIFIED VIEW ITEM #1	04-12-15	M.A.L.
M	MODIF. #A-0382 NOUVELLE POMPE BUSH	04-01-14	J.G.
L	004A1394 ÉTAIT EN PIÈCES SÉPARÉES	03-12-09	J.C.
K	MODIF. #A-0337 E-BOX NOIR ÉTAIT ACIER WELD NUT ÉTAIT SPRING NUT	02-11-05	Y.C
J	ADDED REAR PANNEL WITH HARDWARE	00-05-12	S.L.
H	REDRAWN/ MODIFIED GUIDE ARM SEE DETAIL "A"	00-02-14	S.L.

MACHINE	600A	TOLERANCE METRIC / INCH	SIPROMAC
PART	MACHINE ASSEMBLY REAR VIEW	USINAGE ± 0.1 / ± 0.004"	ST-GERMAIN DE GRANTHAM
		TOLERIE ± 0.5 / ± 0.020"	QUEBEC CANADA
		SOUDAGE ± 0.5 / ± 0.020"	
	N.T.S.		
ITEM:	CNC:	M-1	QT. 1
MAT:	DWG BY S.L. DATE 00-12-14	APP. DATE 05/01/03	NO. 005-0325

MODEL 600A

COVER ADJUSTMENT PROCEDURE

Reference Drawing:# 005-0325
004A0122

PROBLEM: MACHINE TABLE AND COVER SEEMS TO BE STRAIGHT, LID GASKET IS GOOD BUT COVER DOES NOT SIT PROPERLY ON BOTH SIDES OF TABLE.

1. Floor should be flat (within 1/8" approx.).

2.1 Mark position of original adjustment of lower shaft position & measure guide arm length. (See drawing # 005-0325; items: #14 & #2).

2.2 Loosen the two nuts on the guide arm (See drawing # 005-0325; items #15).

2.3 Now move the cover each side and check how cover sits on the table. Distance between table and lid gasket should be under 1/16" approx. If so, go to step 3.0 for guide arm adjustment. Otherwise go to step 2.4 for central arm adjustment.

2.4 Put chamber in upright position and check with a square angle to see if arms are parallel. If not, loosen bolt at the end of one arm and adjust until square (See drawing # 005-0325; items #6, #9 & #10).

2.5 When closing cover (guide arm still loose), if cover is not sitting properly on either the front or rear of the table, you have to change the height of a central bearing (See drawing # 004-0122; item #3) until cover is sits properly each side (less than 1/16"). Keep in mind that the rear of the cover should touch the table before the front.

3. Adjustment of guide arm: two things have to be adjusted, the length and the lower axis position. Each of these should be adjusted separately. Fix the lower axis in a central position, then adjust guide arm length by marking its position. When chamber is at the left and at the right, Adjustment can be done a couple of times until everything is ok.

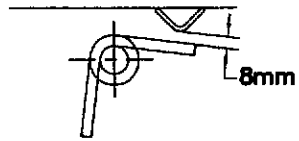
DA/011

SPRING ADJUSTMENT PRODEDURE

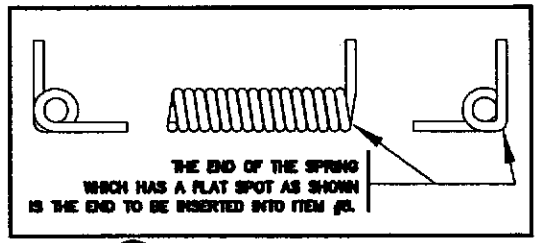
A– PLACE COVER UP(ARM VERTICAL) TO FREE TENSION OF SPRINGS.

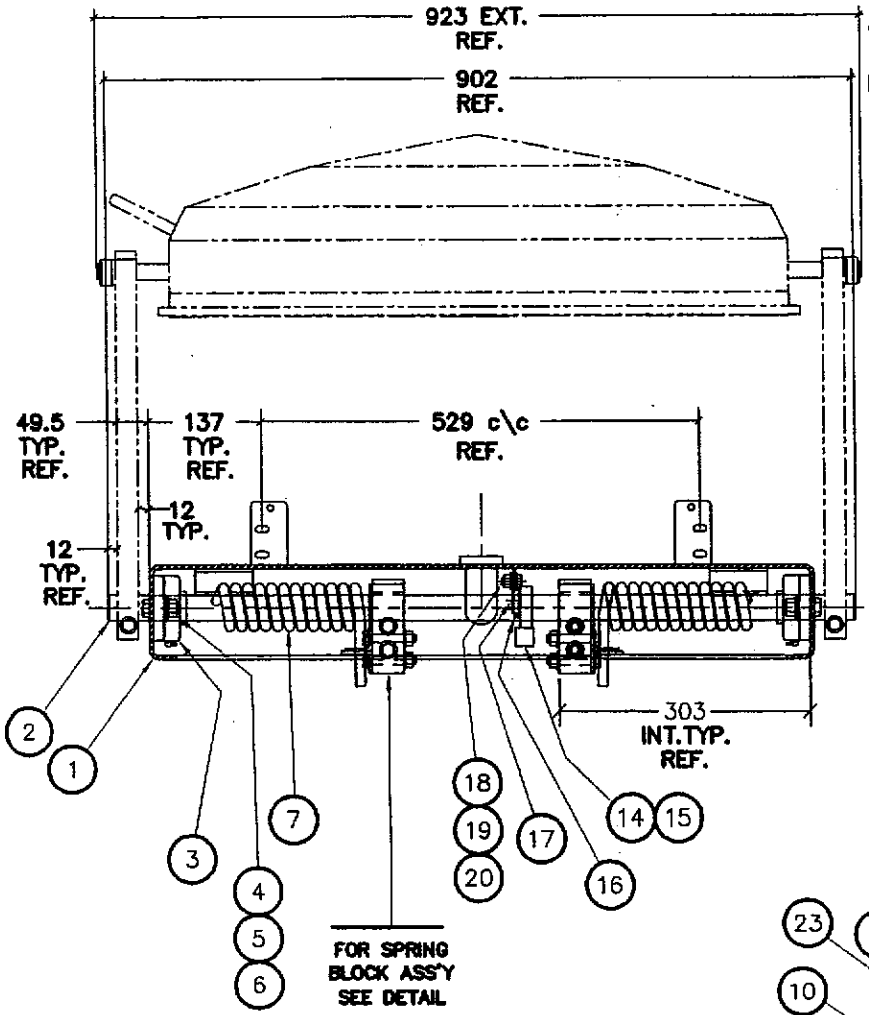
B– LOOSEN BOLTS ITEMS #10 ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y ITEM #8.

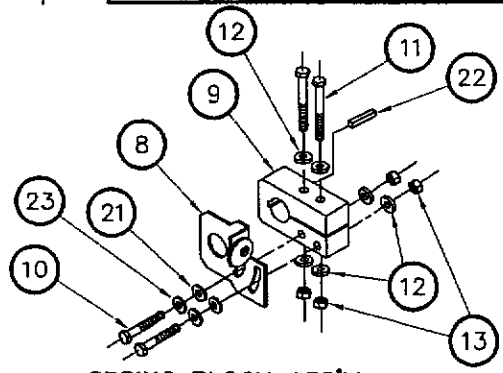
C– TURN SPRING/BLOCK ASSEMBLY TO OBTAIN A SPACE APPROX. 8mm (5/16") AS SHOWN BELOW.



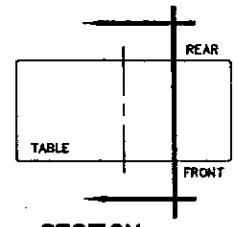
E– RETIGHTEN BOLTS ON SPRING SUPPORT PLATE ASSY. (ITEMS #10).







SPRING BLOCK ASS'Y
DETAIL



SECTION

ITEM	PART #	DESCRIPTION	QT.
1	005–0150	TABLE ASSEMBLY	1
2	002A0318	CENTRAL SHAFT	1
3	075–1650	FLANGED BEARING W/ GREASE FITTING 90°	2
4	051–0441	HEX.BOLT 1/2"–13 x 1 1/2" S.S.	4
5	051–0630	HEX.NUT 1/2"–13 S.S.	4
6	051–0790	FLAT WASHER 1/2" S.S.	4
7	008–0315	CENTRAL SHAFT SPRING	2
8	004A0117	SUPPORT PLATE ASSEMBLY	2
9	002A0319	SPRING BLOCK	2
10	052–0775	HEX.BOLT 3/8"–24 NC x 2 1/2" ZINC	4
11	052–0777	HEX.BOLT 3/8"–24 x 3" ZINC	4
12	052–2060	FLAT WASHER 3/8" ZINC	12
13	052–3128	HEX.NUT 3/8"–24 ZINC	8
14	005–0154	MICRO–SWITCH COLLAR	1
15	051–0334	SET SCREW 3/8"–16 x 3/8" S.S.	2
16	026–0610	MICRO–SWITCH	2
17	001–1294	MICRO–SWITCH FIXATION PLATE	2
18	051–0180	HEX.BOLT 1/4"–20 x 1/2" S.S.	2
19	051–0740	FLAT WASHER 1/4" S.S.	4
20	051–0580	HEX.NUT 1/4"–20 S.S.	2
21	052–2071	CONTACT WASHER 3/8" STEEL	4
22	056–0168	KEY 1/4" SQ x 1 1/2" W/ ROUNDED END	2
23	051–0783	WASHER 3/8" FLAT THICK SS	4

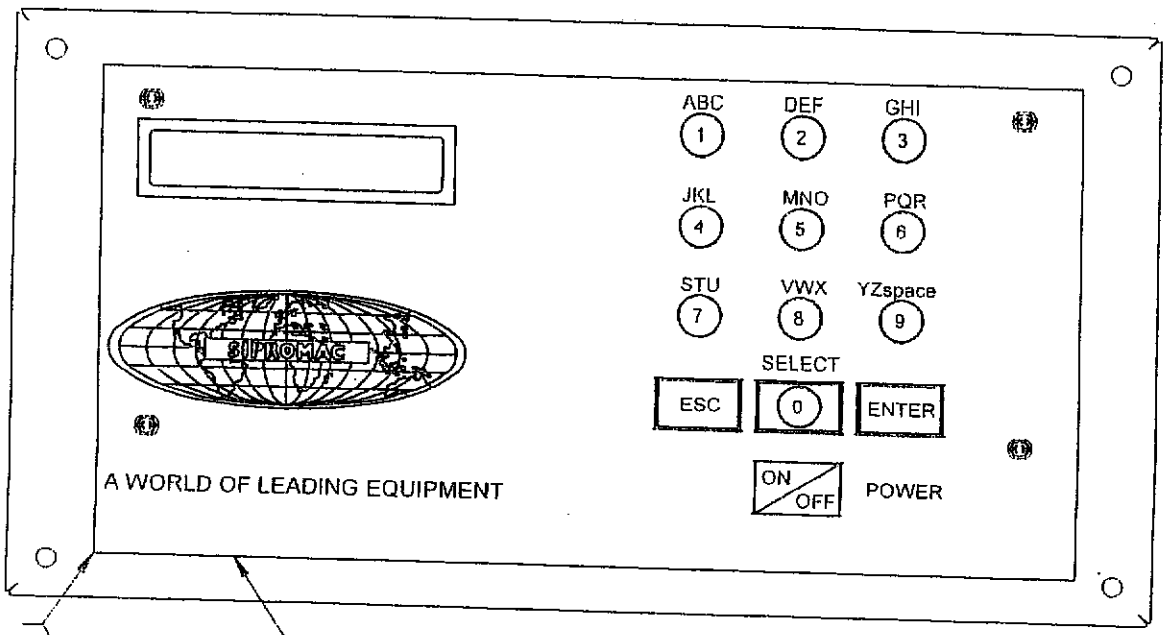
LET.	MODIFICATION	DATE	INT.
D	MODIFIED VIEW ITEM #1	04–12–15	M.A.L
C	051–0783 ETAIT 052–02060	03–11–20	L.T.
B	REDRAWN/ MODIFIED SPRING BLOC	99–11–17	S.L.

MACHINE: 600A	METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC
PART: CENTRAL SHAFT ASSEMBLY	N.T.S.		ST–GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:	CNC:		QT. 1
MAT:	DWG BY SYLVAIN L. DATE 99–11–17		NO. 004A0122
	APP. DATE 04-12-16		

004A0122

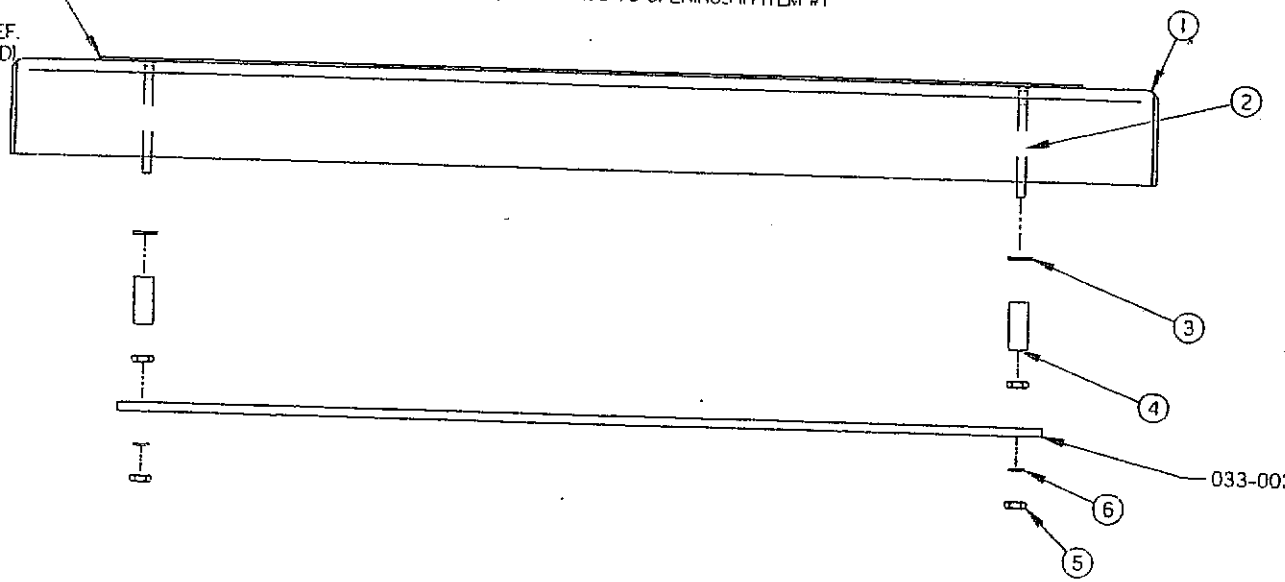
005A0583

ITEM	PART #	DESCRIPTION	QT.
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



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

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



033-0038 P.C. BOARD REF. (NOT INCLUDED)

LET.		DATE	INT.
G	REDRAWN	05-09-01	M.A.
	MODIFICATION	DATE	INT.

MACHINE: 420A, 450A, 450T, 500A, 550A, 600A, 580A, 620A & 650A

PART: FRONT MC-40 SUPPORT ASS'Y

ITEM:

MAT.:

CNC:

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

APP. BY: DATE: 05-10-24

DEPT. TOL: USINAGE / TOLERIE / SOUDAGE — METRIC: ± 0.1, ± 0.5, ± 0.5 — INCH: ± 0.004", ± 0.020", ± 0.020"

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

DEPT. M QTY. 1

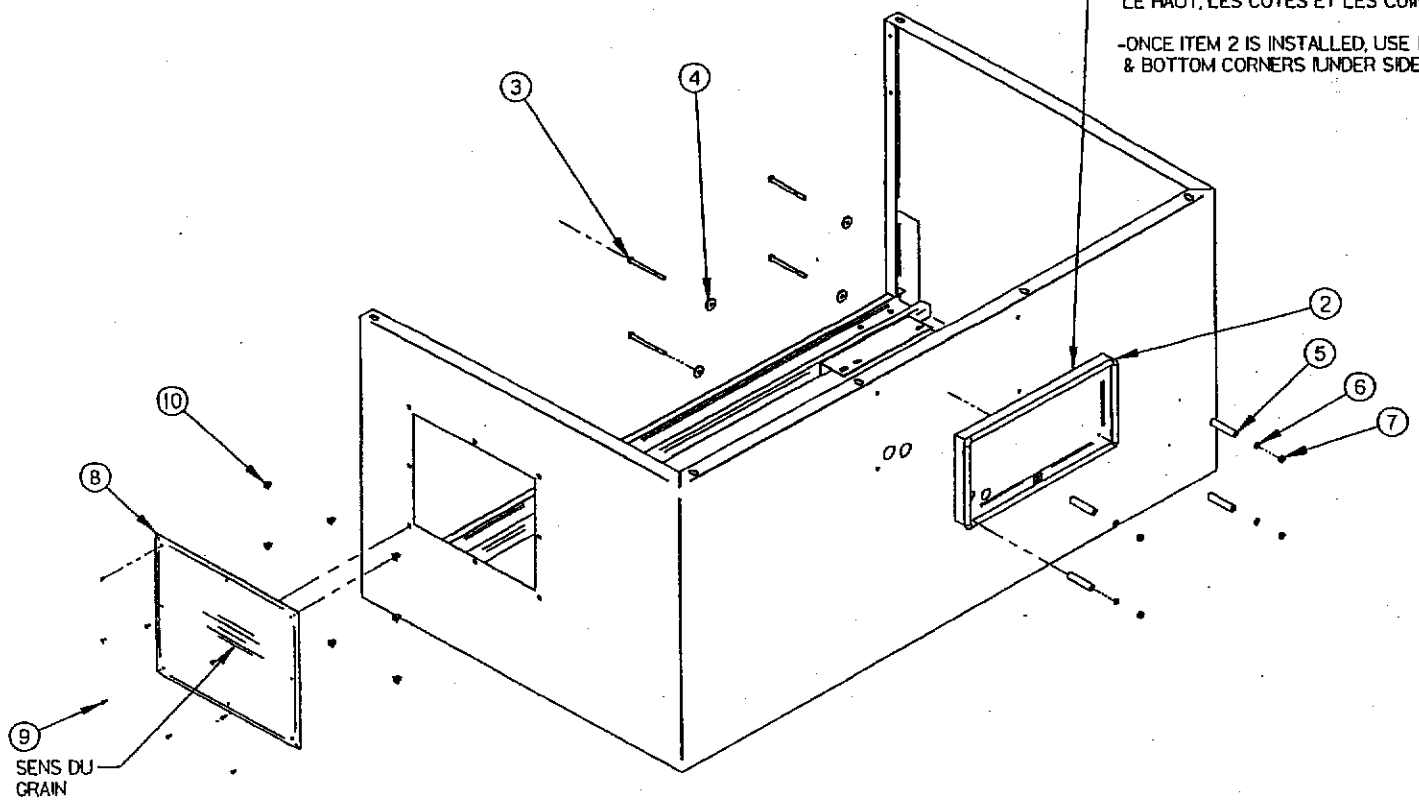
FIG. 005A0583

005A0457

ITEM	PART #	DESCRIPTION	QT.
1	004B0114	STRUCTURE PRE-ASSEMBLY	1
2	005A0584	REAR MC-40 SUPPORT ASS'Y	1
3	051-0287	BOLT 1/4-20 x 3-1/4" S/S	4
4	051-0757	WASHER 1/4" FLAT THICK S/S	4
5	058-0140	PLASTIC SPACER 0.266" x 1/2" x 2 1/4"	4
6	051-0750	WASHER 1/4" LOCK S/S	4
7	051-0580	NUT ¼"-20nc. S/S	4
8	001A3230	STRUCTURE COVER	1
9	054-0180	METAL SCREW #6 x 3/8" PAN SLOT S/S	8
10	057-5010	NYLON SCREW #10 RECEPTACLE INSERT	8

-UNE FOIS L'ITEM 2 INSTALLÉ, UTILISER DE L'ADHÉSIF MARIN 5200 #169-0210 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 169-0210 5200 MARINE ADHESIVE TO SEAL TOP, SIDES & BOTTOM CORNERS (UNDER SIDE NOT SEALED).

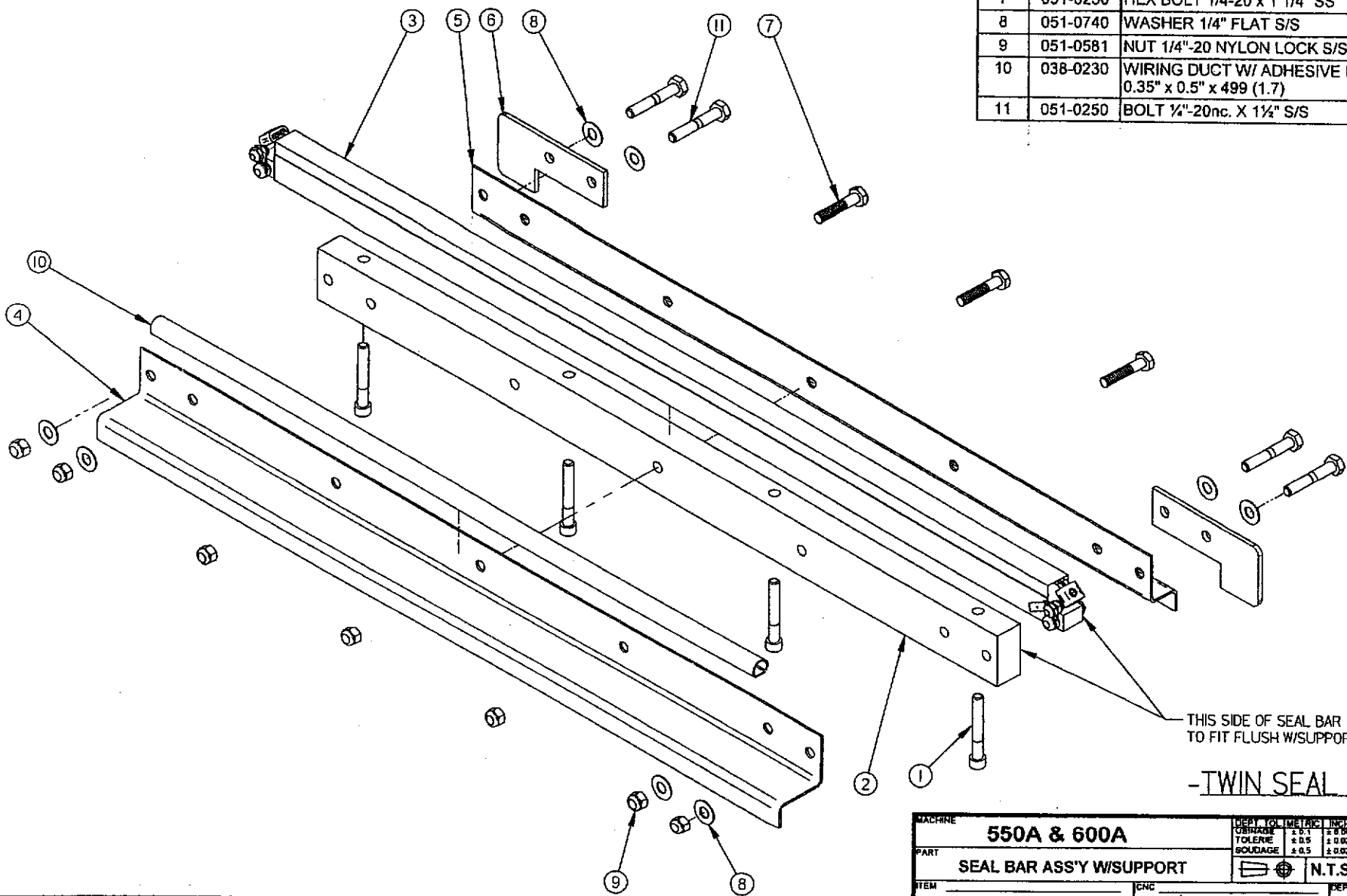


LET.	MODIFICATION	DATE	INT.
C	REDRAWN	05-09-07	M.A.

MACHINE	600A & 620A	DEPT. TOL. / TOLÉRANCE / TOLERIE / SOUDAGE	METRIC: ± 0.1, ± 0.5, ± 0.5 / INCH: ± 0.005", ± 0.020", ± 0.020"
PART	STRUCTURE ASS'Y	N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM	CNC	DEPT. M	QTY. 1
MAT.	DWG BY M.A.L. / APP. BY	DATE 05-09-07 / DATE 05-11-07	NO. 005A0457

005A0568

ITEM	PART #	DESCRIPTION	QT.
1	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
2	002-0514	SEAL BAR SUPPORT	1
3	005A0152	SEAL BAR PRE-ASS'Y	1
4	001-1962	EXTERIOR BELLOWS COVER	1
5	001-1963	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
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	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7)	1
11	051-0250	BOLT ¼"-20nc. X 1½" S/S	4



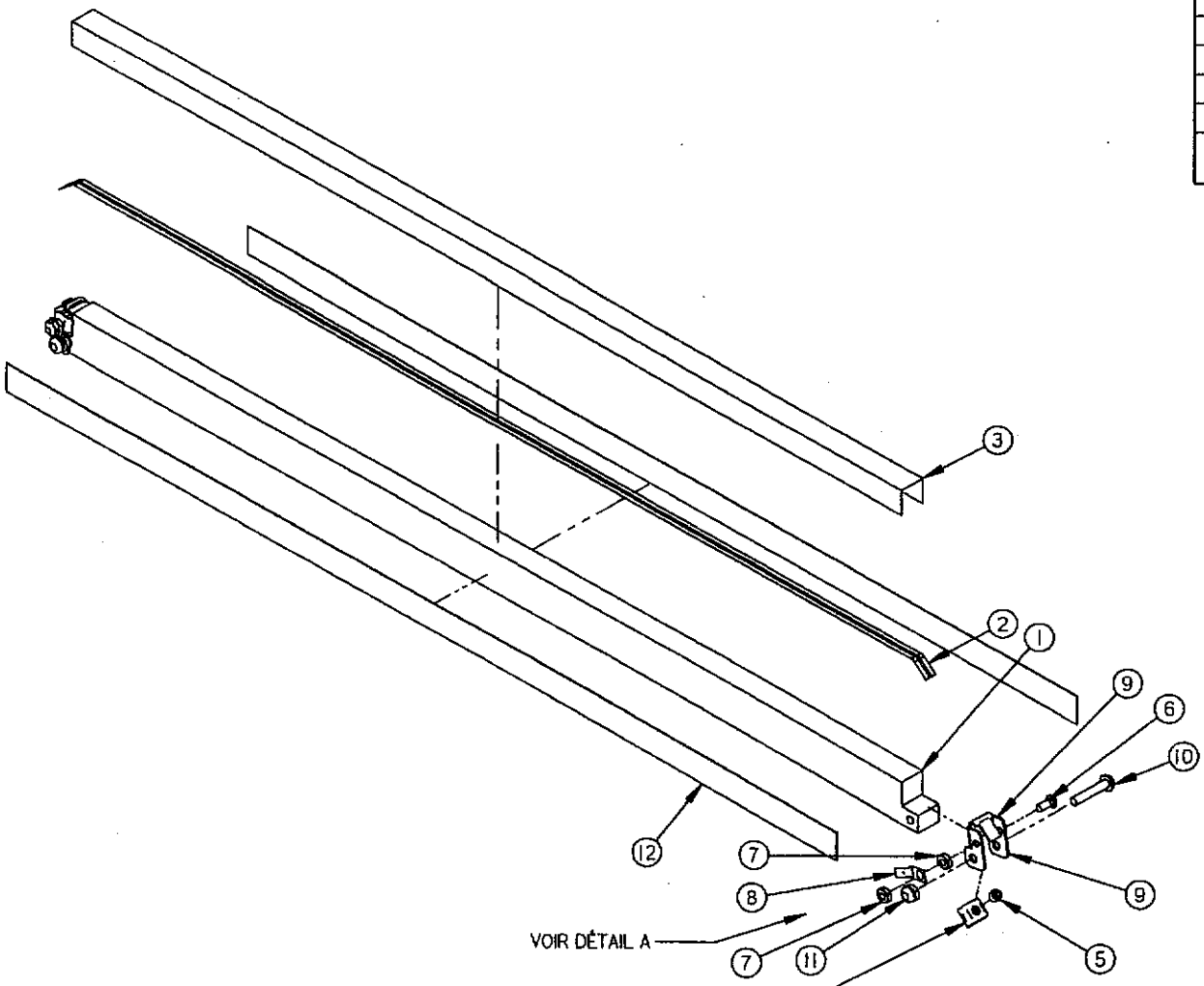
-TWIN SEAL OPTION-

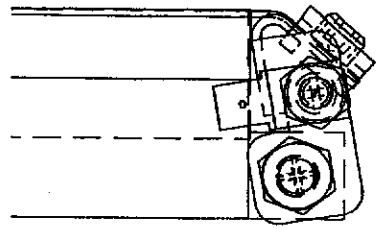
LET.	MODIFICATION	DATE	INT.
C	REDRAWN	05-09-13	M.A.

MACHINE: 550A & 600A
PART: SEAL BAR ASS'Y W/SUPPORT
ITEM
MAT.
DEPT. TOL. | METRIC | INCH
USINAGE | ± 0.1 | ± 0.004"
TOLERIE | ± 0.5 | ± 0.020"
SOUDAGE | ± 0.5 | ± 0.020"
N.T.S.
CNC
DWG BY: M.A.L. DATE: 05-09-13
APP. BY: DATE: 05-09-13
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUÉBEC CANADA
DEPT. M-I
QTY LISTE
NO. 005A0568

005A0152

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





-DÉTAIL A-

INSTALLER CONTRE L'ENCOCHE DE L'ITEM #8 (4) INSTALL AGAINST NOTCH OF ITEM #8

-TWIN SEAL OPTION-

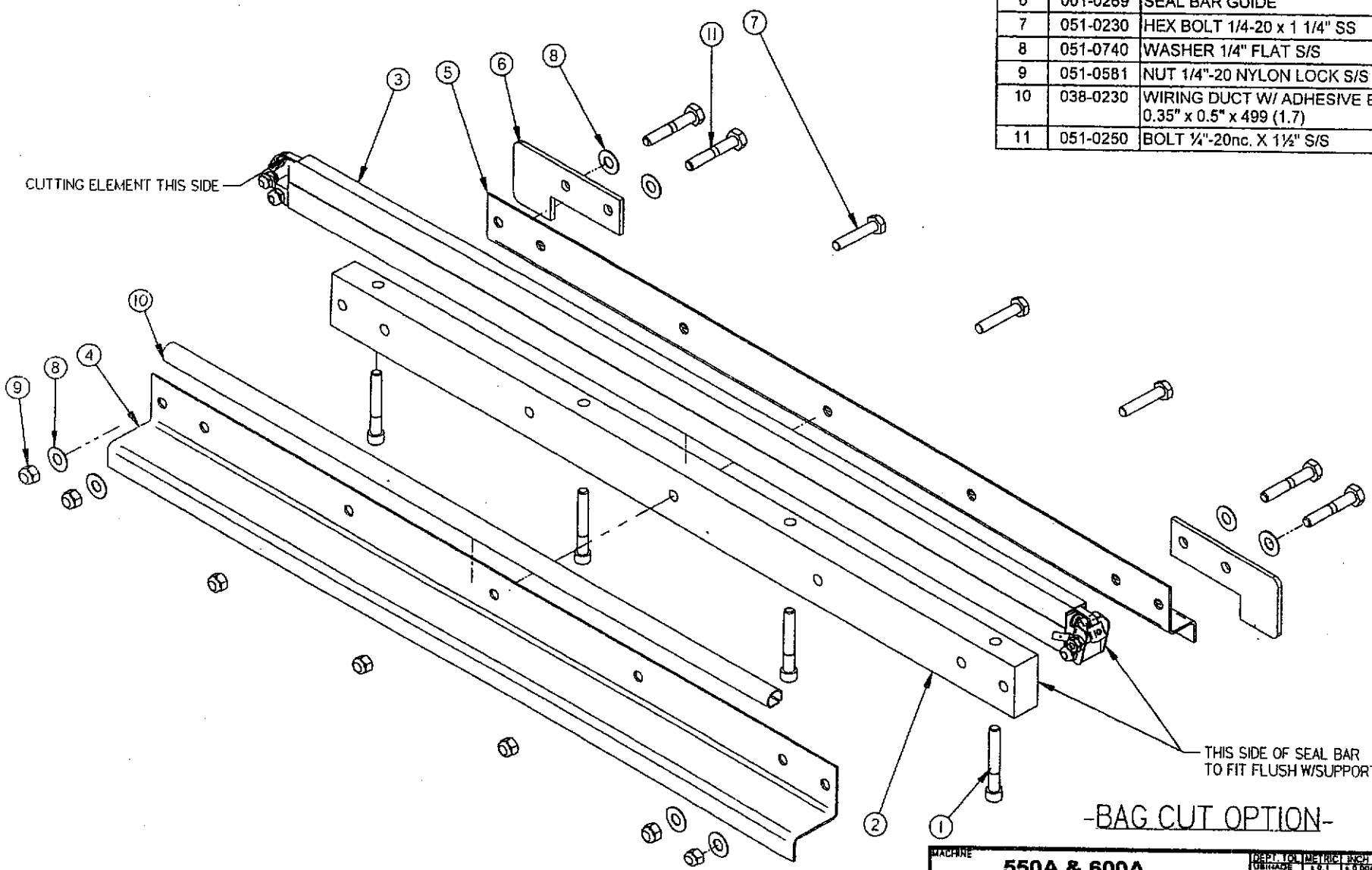
600A	4
550A	2
MACHINE	QTY

MACHINE: 550A & 600A
PART: SEAL BAR PRE-ASS'Y
ITEM
MAT.
CHC
DWG BY: M.A.L. DATE: 05-09-13
APP. BY: DATE: 06-04-19
DEPT. TOL: USINAGE ± 0.5 ± 0.020" | TOLERIE ± 0.5 ± 0.020" | SOUDAGE ± 0.5 ± 0.020"
METRIC / INCH
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
DEPT. M-1
QTY LISTE
NO. 005A0152

LET.	MODIFICATION	DATE	INT.
C	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.

005B0569

ITEM	PART #	DESCRIPTION	QT.
1	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
2	002-0514	SEAL BAR SUPPORT	1
3	005B0153	SEAL BAR PRE-ASS'Y	1
4	001-1962	EXTERIOR BELLOWS COVER	1
5	001-1963	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
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	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7)	1
11	051-0250	BOLT ¼"-20nc. X 1½" S/S	4



-BAG CUT OPTION-

MACHINE	QTY
600A	4
550A	2

C	REDRAWN	06-05-29	M.A.
LET.	MODIFICATION	DATE	INT.

MACHINE: 550A & 600A
PART: SEAL BAR ASS'Y W/SUPPORT
ITEM
MAT.
CNC
DWG BY M.A.L. DATE 06-05-29
APP. BY DATE

DEPT. TOL	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

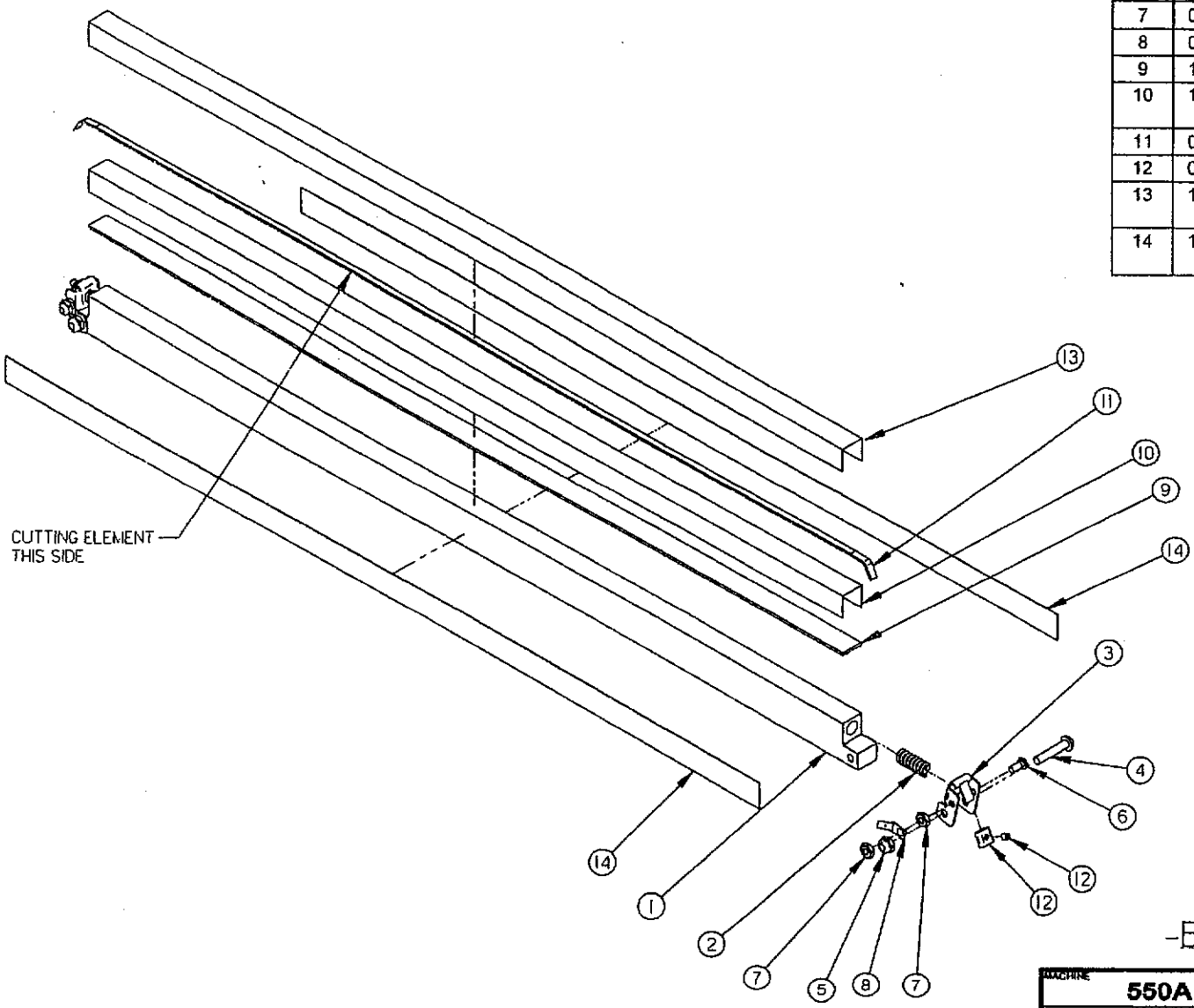
N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA

DEPT. M-I
NOMENCLATURE
NO. 005B0569

005B0153

ITEM	PART #	DESCRIPTION	QT.
1	009A0191	ECO SEAL BAR	1
2	077-0095	SPRING C 0360-059-1250 S/S	2
3	001-2666	ELEMENT BINDER	3
4	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
5	051-0572	LOCK NUT #10-24 S/S	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	179-0003	SILICONE 2mm x 15mm 641.5mm (0.64)	1
10	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" 641.5mm (0.078)	1
11	039-0269	SEAL CUT ELEMENT (0.0688)	1
12	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
13	176-0203	TEFLON TAPE, 5MIL UNCOATED ZONE 641.5mm (0.064)	1
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2



-BAG CUT OPTION-

600A	4
550A	2
MACHINE	QTY

MACHINE	550A & 600A	DEPT. TOLERANCE	METRIC / INCH
PART	SEAL BAR PRE-ASS'Y	TOLERIE / SOUDAGE	± 0.5 / ± 0.020"
ITEM		CHC	N.T.S.
MAT.		DWG BY M.A.L. DATE 06-05-29	APP. BY DATE 06-05-30

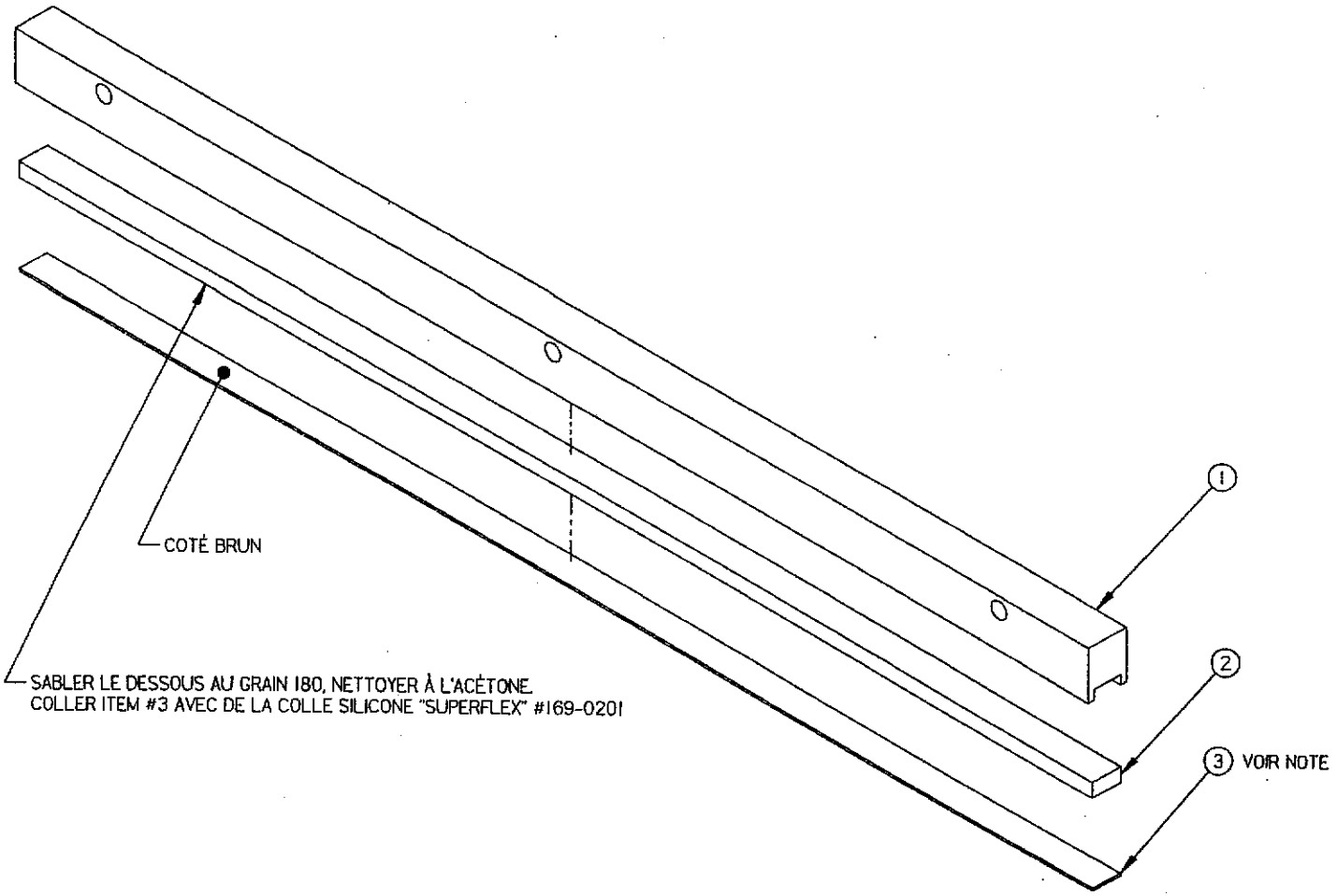
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

DEPT. M-I | QTY LISTE | DWG NO. 005B0153

LET.	MODIFICATION	DATE	INT.
G	REDRAWN	06-05-29	M.A.

004A1326

ITEM	PART #	DESCRIPTION	QT.
1	002A2061	UPPER SEAL BAR SUPPORT (E.C.O.)	1
2	008-0311	UPPER SEAL BAR RUBBER	1
3	008A0832	TEFLON CUTTING STRIP	1



NOTE:

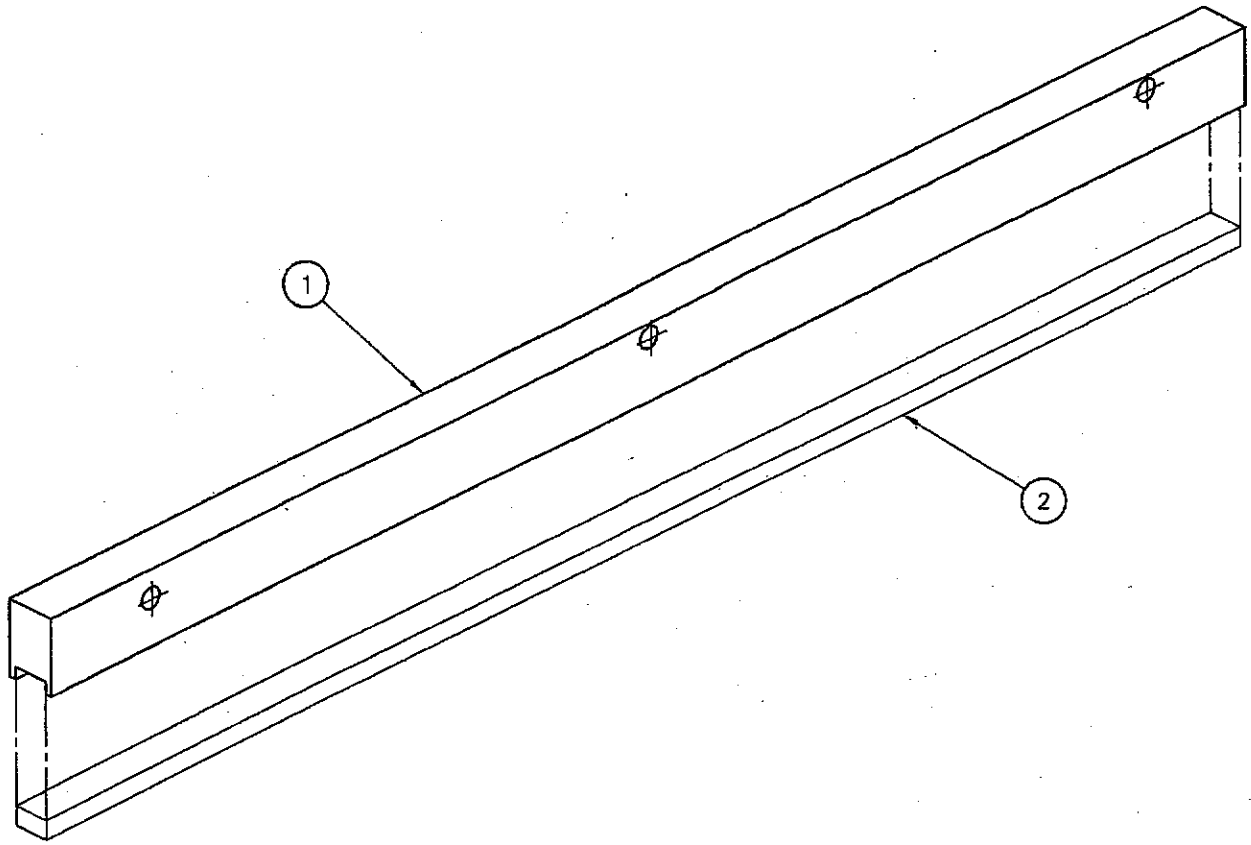
-INSTALLER ITEM #3 SEULEMENT SI L'OPTION "SHRINKABLE BAG" EST COMMANDÉ.

-BAG CUT OPTION-

LET.	MODIFICATION	DATE	INT.

MACHINE: 600A
PART: UPPER SEAL BAR ASSEMBLY (E.C.O.)
DEPT. TOL: USINAGE ± 0.1 / TOLERIE ± 0.5 / SOUDAGE ± 0.5
METRIC
INCH: ± 0.004" / ± 0.020" / ± 0.020"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM
CNC
DEPT. M-I
QTY. 2
MAT.
DWG BY J.G.
APP. BY
DATE 06-03-07
DATE ~~06-04-04~~
NO. 004A1326

ITEM	PART #	DESCRIPTION	QT.
1	002A0403	UPPER SEAL BAR SUPPORT	1
2	008-0311	UPPER SEAL BAR RUBBER	1



LET.	MODIFICATION	DATE	INT.
B	REDRAWN	99-07-15	S.L.

MACHINE: 600A

PART: UPPER SEAL BAR ASSEMBLY

ITEM:

MAT:

METRIC TOLERANCE: 0 ± .5 / .X ± .05 / .XX ± .005 / .XXX ± .0005 / ANGLE ± 1°

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

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

CNTD:

SCALE: ____ QT. 2

DWG BY: S.L. DATE: 99-07-15

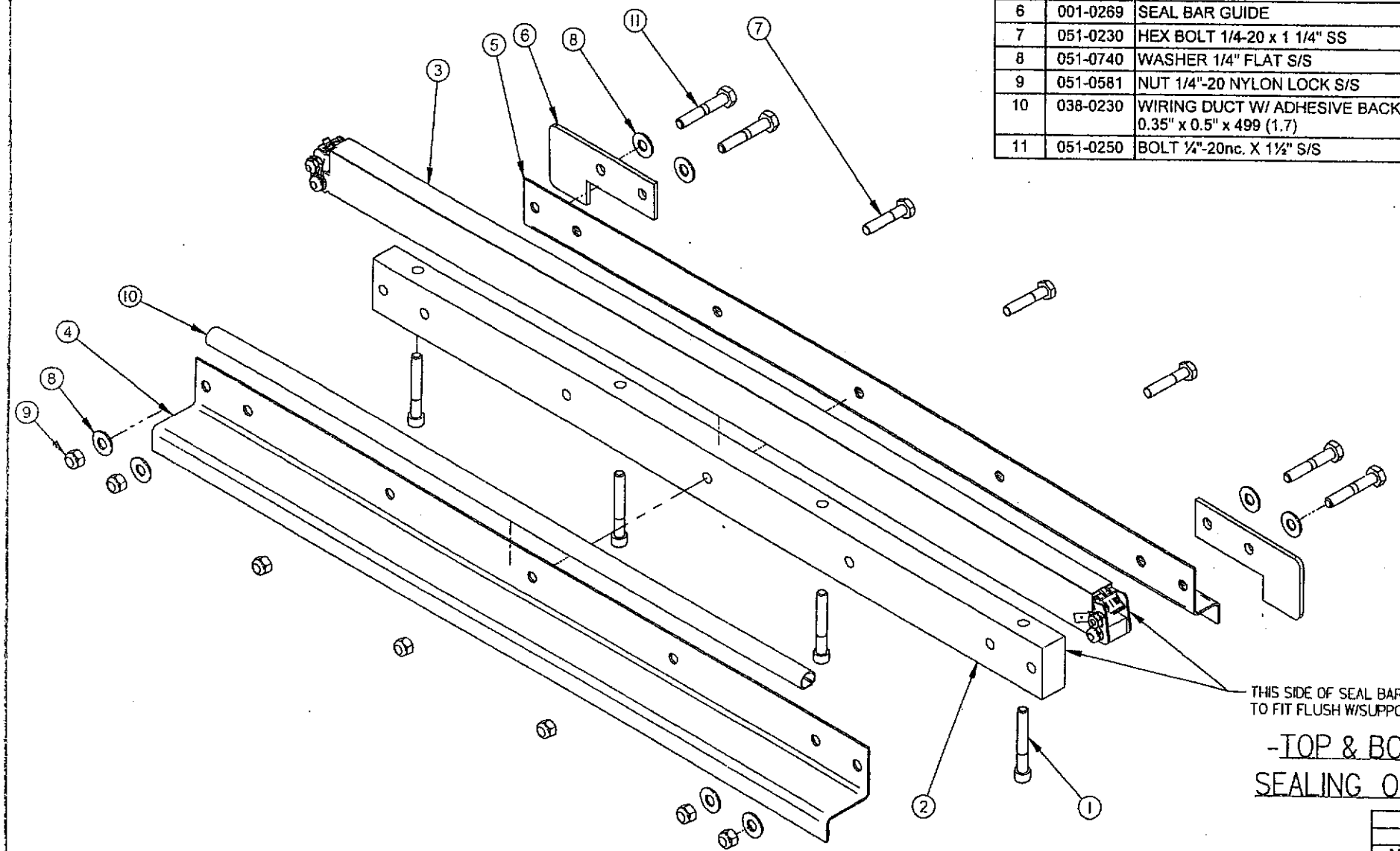
APP. DATE:

NO. 005A0573

005A0573

005A0570

ITEM	PART #	DESCRIPTION	QT.
1	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
2	002-0514	SEAL BAR SUPPORT	1
3	005A0370	SEAL BAR PRE-ASS'Y	1
4	001-1962	EXTERIOR BELLOWS COVER	1
5	001-1963	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
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	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7)	1
11	051-0250	BOLT ¼"-20nc. X 1½" S/S	4



-TOP & BOTTOM SEALING OPTION-

600A	4
550A	2
MACHINE	QTY

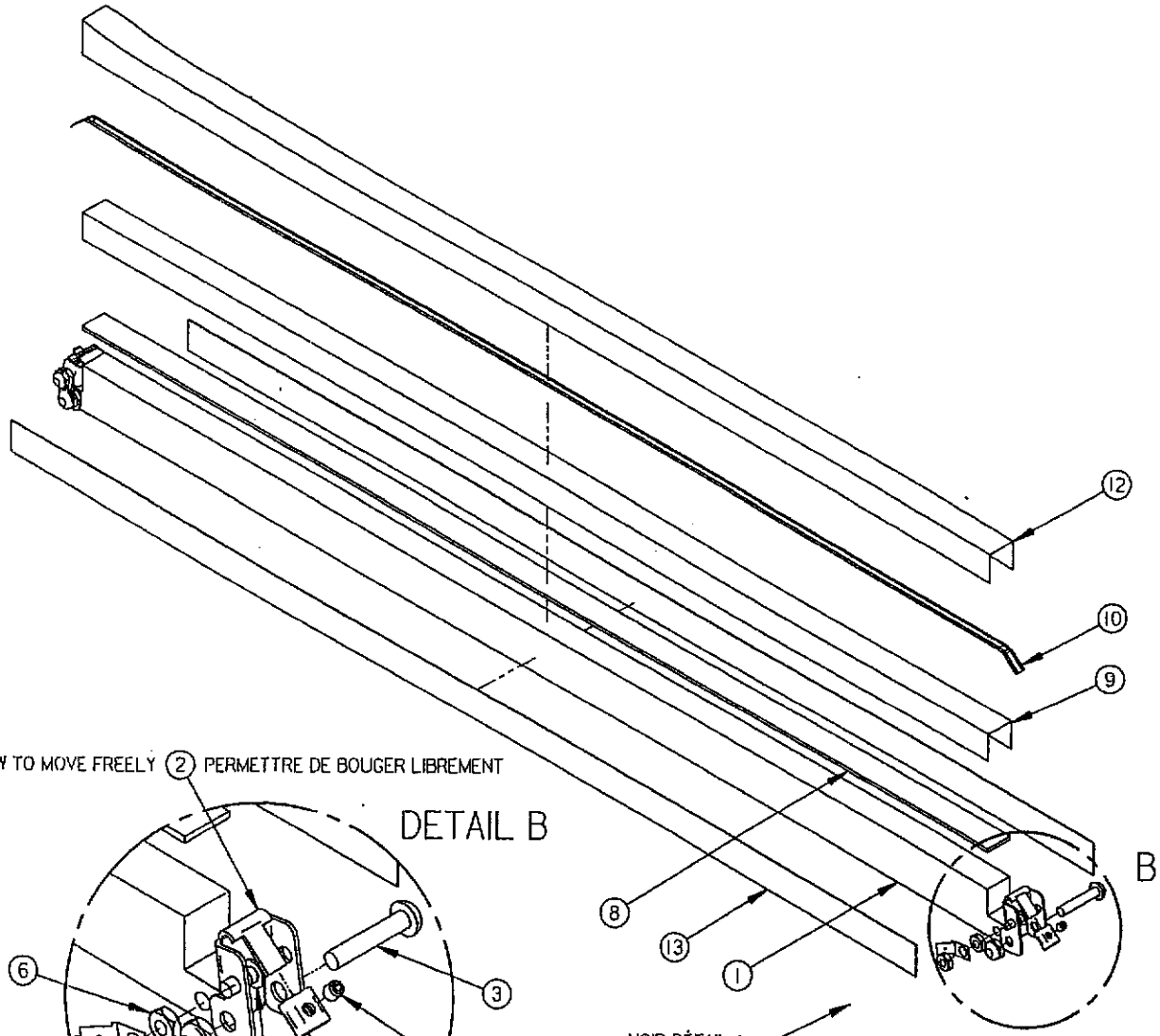
MACHINE: 550A & 600A
PART: SEAL BAR ASS'Y W/SUPPORT
DEPT. TOL: USINAGE ± 0.1 / ± 0.004" — TOLERIE ± 0.5 / ± 0.020" — SOUDAGE ± 0.5 / ± 0.020"
METRIC / INCH
N.T.S.
ITEM
CNC
MAT.
DEPT. M-I
QTY LISTE
DWG BY M.A.L. DATE 07-12-17
APP. BY DATE 08-11-06
REV. 005A0570

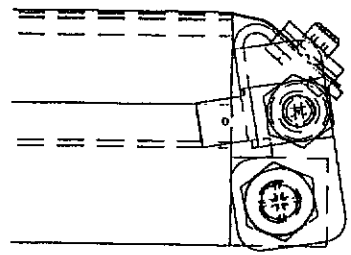
SIPROMAC
ST-GERMAIN DE GRANTHAN
QUEBEC, CANADA

B	REDRAWN	07-12-17	M.A.
LET.	MODIFICATION	DATE	INT.

005A0370

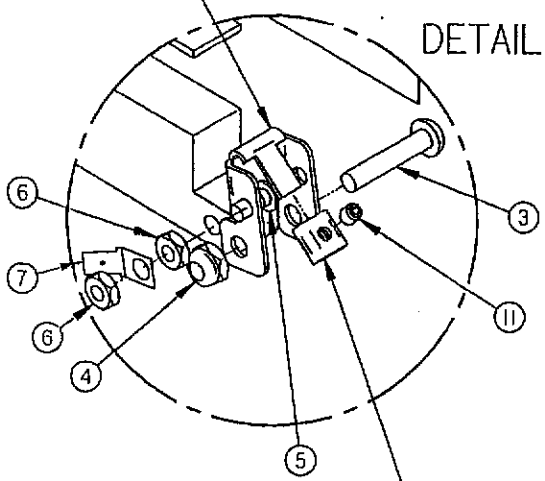
ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	001-2666	ELEMENT BINDER	2
3	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
4	051-0572	LOCK NUT #10-24 S/S	2
5	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
6	051-0550	NUT #8-32 SS	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm 641.5mm (0.64)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





-DÉTAIL A-

ALLOW TO MOVE FREELY (2) PERMETTRE DE BOUGER LIBREMENT



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

-TOP & BOTTOM SEALING OPTION-

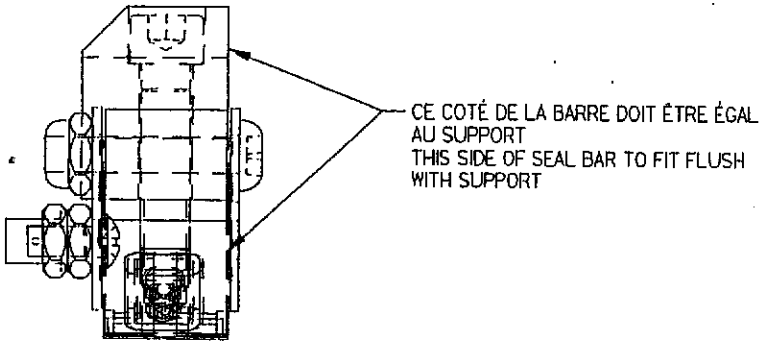
MACHINE	QTY
600A	4
550A	2

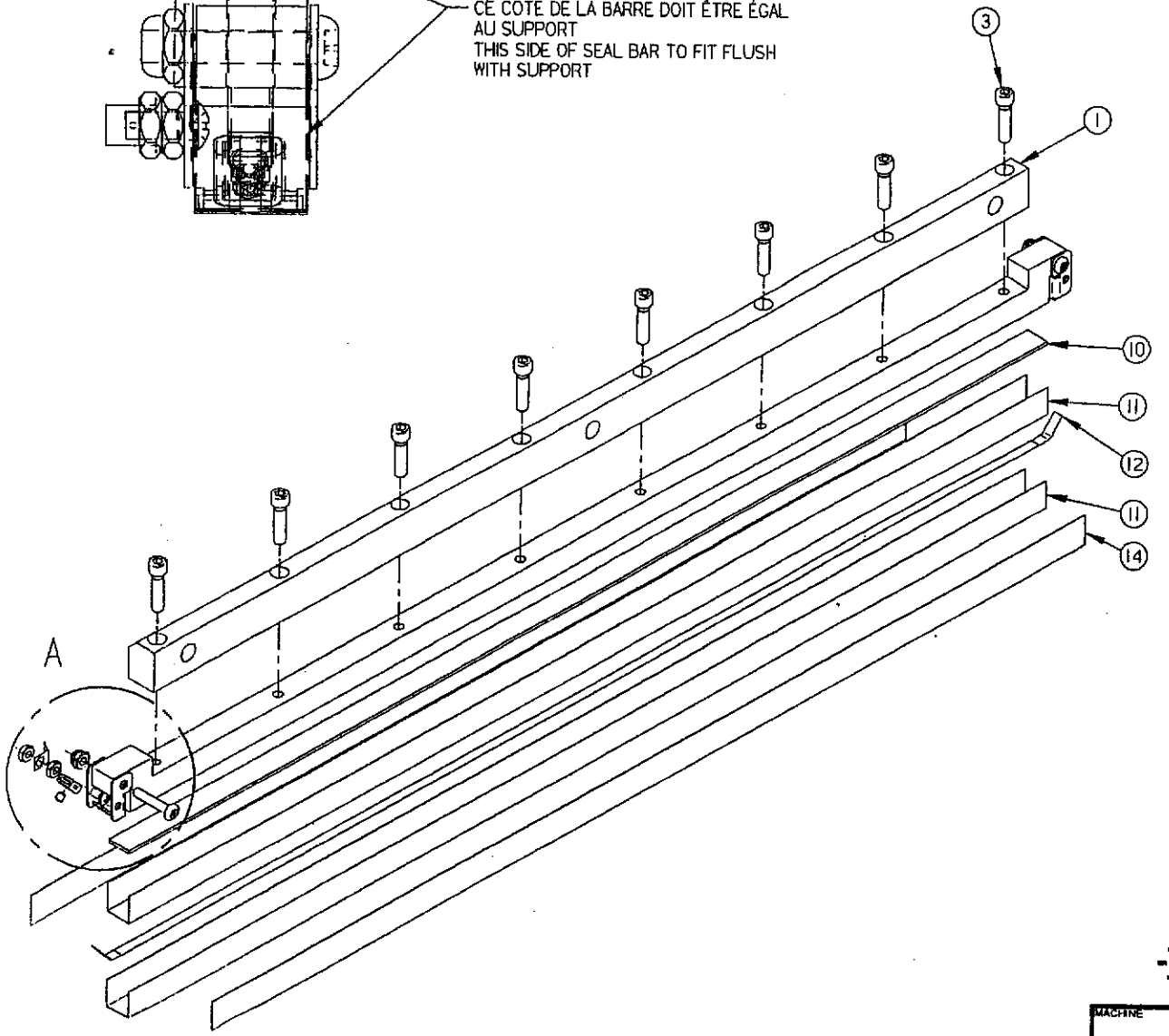
MACHINE: 550A & 600A	DEPT. TOL. USINAGE ± 0.1 TOLERIE ± 0.5 SOUDAGE ± 0.5	METRIC ± 0.254 ± 0.020" ± 0.020"	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART: SEAL BAR PRE-ASS'Y		N.T.S.			
ITEM	CNC		DEPT. M-I	QTY LISTE	
MAT.	DWG BY M.A.L.	DATE 07-12-17	NO. 005A0370		

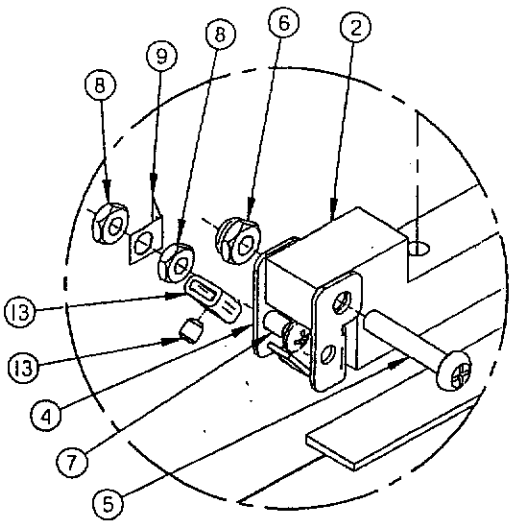
LET.		DATE	INT
E	REDRAWN	07-12-17	M.A.
	MODIFICATION		

005A0386

ITEM	PART #	DESCRIPTION	QT.
1	002A0534	UPPER SEAL BAR SUPPORT	1
2	002A0349	UPPER SEAL BAR	1
3	051-0220	SCREW ¼"-20nc x 1" SKT. CAP S/S	8
4	001-2666	ELEMENT BINDER	2
5	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
6	051-0572	LOCK NUT #10-24 S/S	2
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 683mm (0.68)	1
11	176-0220	TEFLON TAPE,PRESS.SENSITIVE 2" 683mm (0.08)	2
12	039-0220	BI-ACTIVE SEALING ELEMENT (6mm) 726mm (0.07)	1
13	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 650mm (0.020)	2







DETAIL A

-TOP & BOTTOM SEALING OPTION-

F	REDESSINE	07-12-17	J.G.
LET.	MODIFICATION	DATE	INT.

MACHINE: 600A
PART: UPPER SEAL BAR ASS'Y W/SUPPORT
ITEM
MAT.

DEPT. TOL.	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

N.T.S.

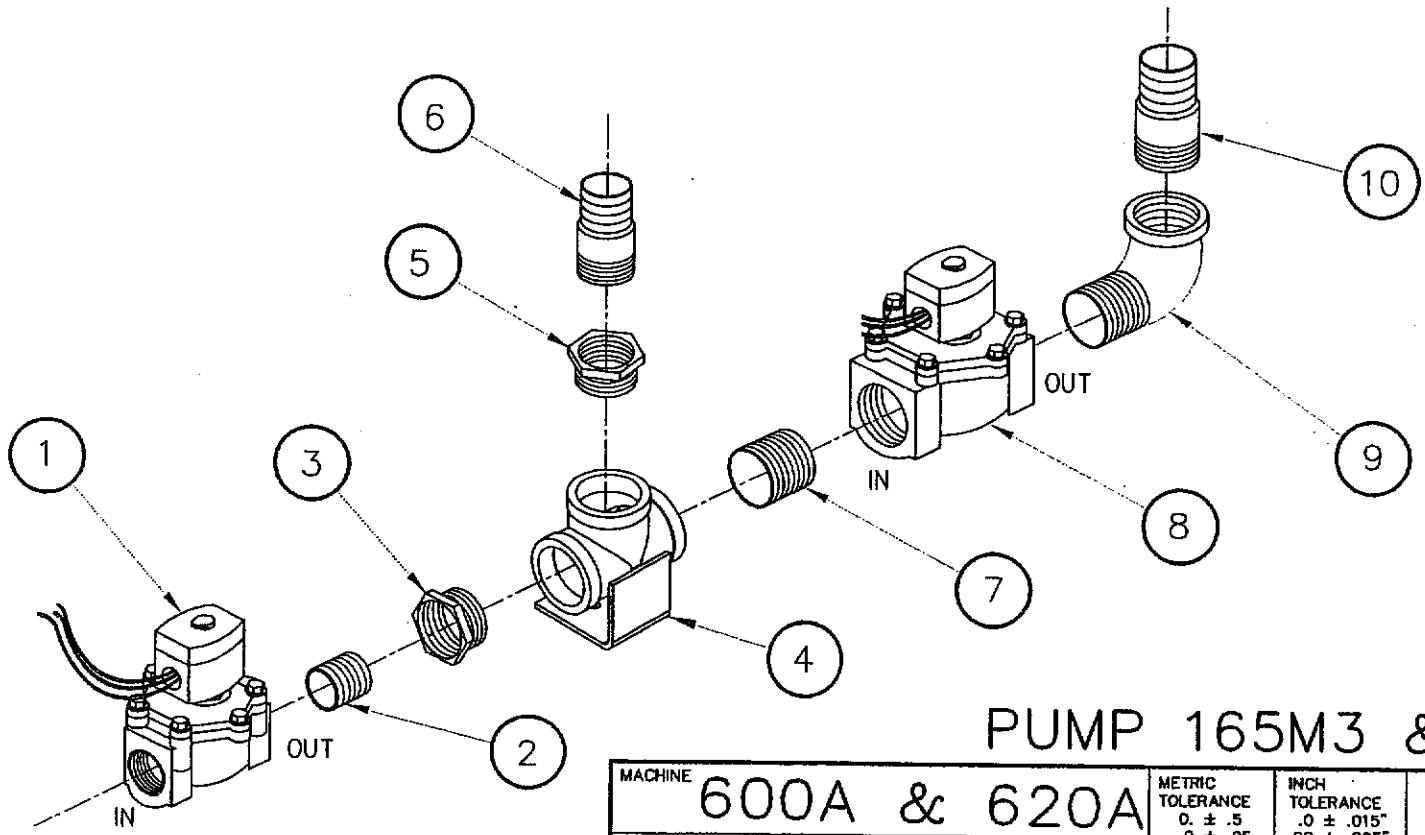
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

CNC
DWG BY J.G. DATE 07-12-17
APP. BY DATE

DEPT. M-I QTY. 2
NO. 005A0386

004-0863

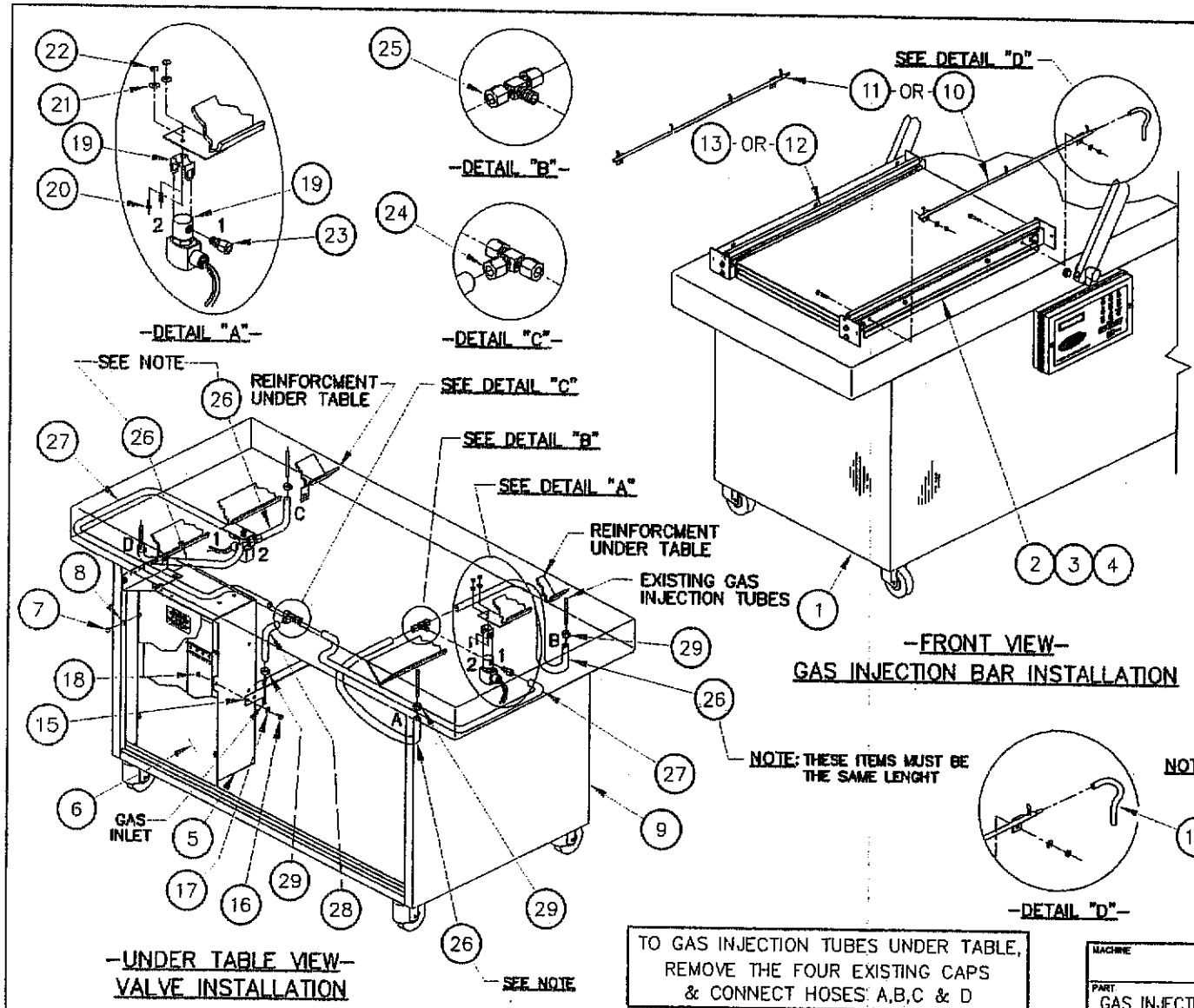
ITEM	#PART	DESCRIPTION	QT.
1	106-0050	VALVE 2WAY /24V /60Hz / 1-1/4" NPT	1
2	103-0247	CLOSE NIPPLE 1-1/4" NPT ZINC	1
3	103-0587	RED.BUSHING 2" NPT x1-1/4"NPT ZINC	1
4	004A1621	VAC./ATM. VALVE SUPP. PRE-ASSY	1
5	103-0592	RED.BUSHING 2"NPT x 1-1/2" NPT ZINC	1
6	103-0740	STRIGHT 1-1/2"NPT x 1-1/2"HOSE ZINC	1
7	103-0260	CLOSE NIPPLE 2"NPT ZINC	1
8	106-0060	VALVE 2WAY /24V /60Hz / 2" NPT	1
9	103-0095	ELBOW STREET 2"NPT ZINC	1
10	103-0760	STRIGHT 2"NPT x 2"HOSE ZINC	1



PUMP 165M3 & 255M3

MACHINE: 600A & 620A	METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC, ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: VACUUM/ATMOSPHERE VALVE ASSY.		N.T.S.	
ITEM:	CNC:		M / QT. 1
MAT:	DWG BY DAVE A / DATE 01-01-29		NO. 004-0863
	APP. / DATE 05-08-23		

LET.	MODIFICATION	DATE	INT.
A	004A1621 WAS 004-0183, 165M3 WAS160M3, 255M3 x 250M3	05-08-11	M.A.L.



ITEM	PART #	DESCRIPTION	QT.
1	005-0336	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0568	SEAL BAR ASS'Y W/ SUPPORT	4
3	005-0569	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	4
4	005-0570	SEAL BAR ASS'Y W/ SUPPORT (T & B OPT.)	4
5	005-0374	ELECTRICAL BOX ASSEMBLY	1
6	004-0279	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	005-0337	MACHINE ASSEMBLY REAR VIEW	1
10	005-0571	GAS 3 INJECTION BAR ASSEMBLY (OPTION)	2
11	005A0446	FRONT GAS 4 INJECTION BAR ASS'Y (OPT.)	2
12	005A0810	GAS 3 INJECTION BAR ASSEMBLY (OPTION)	2
13	005A0811	REAR GAS 4 INJECTION BAR ASS'Y (OPT.)	2
14	008-0464	GAS INJECTION CONN. TUBE (OPTION)	4
15	005-0323	GAS INLET ASSEMBLY (OPTION)	1
16	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
17	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
18	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S (OPTION)	1
19	106-0010	SELENOIDE VALVE 2 WAY 1/4" NPT W/ SUPP.	2
20	051-0100	SCREW #8-32 X 3/8" PAN PHILL. S/S	4
21	051-0720	FLAT WASHER #8 S/S	4
22	051-0550	HEX. NUT #8 S/S	4
23	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	2
24	101-0062	"T" 3/8" T.P.COMP.	1
25	101-0065	"T" 3/8" T.P.COMP. X 1 /4" MNPT X 3/8" T.P.COMP.	2
26	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) 1100 mm LG.	4
27	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) 1400 mm LG.	2
28	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) 900 mm LG.	1
29	105-0200	COLLARS 3/8"ø	5

NOTE: PARTS (1) THRU (9) ARE EXISTING PARTS

PARTS (10) THRU (29) ARE PARTS SUPPLIED W/ KIT

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

LET.	MODIFICATION	DATE	INT.
E	MODIFICATION #A-358	03-02-21	J.G.
D	REDRAWN/ MC-40 WAS MC-30	98-06-09	L.M.

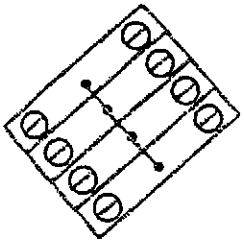
-OPTION GAS INJECTION-

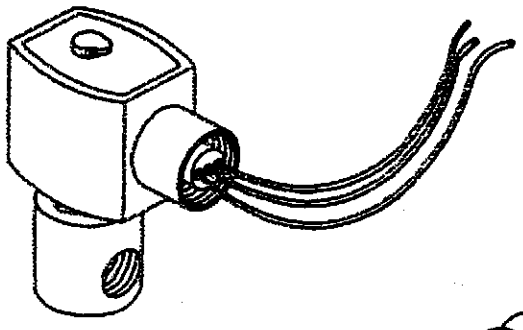
MACHINE: 600A	METRIC TOLERANCE 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	IMPERIAL TOLERANCE .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: GAS INJECTION KIT INSTALLATION	N.T.S.		
ITEM:	CHK:		M-P-I QT. 1
MAT:	DWG BY L.MARCOTTE DATE 98-06-09		NO. 010-0017
	APP. LT DATE		

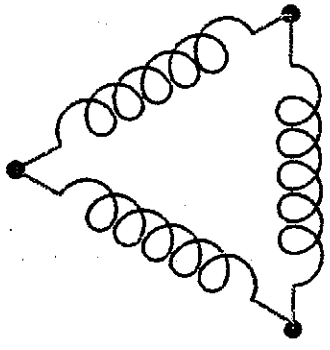
010-0017

NOTES

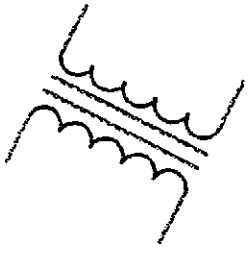
SIPROMAC

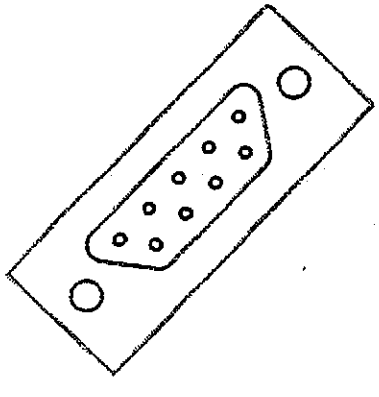


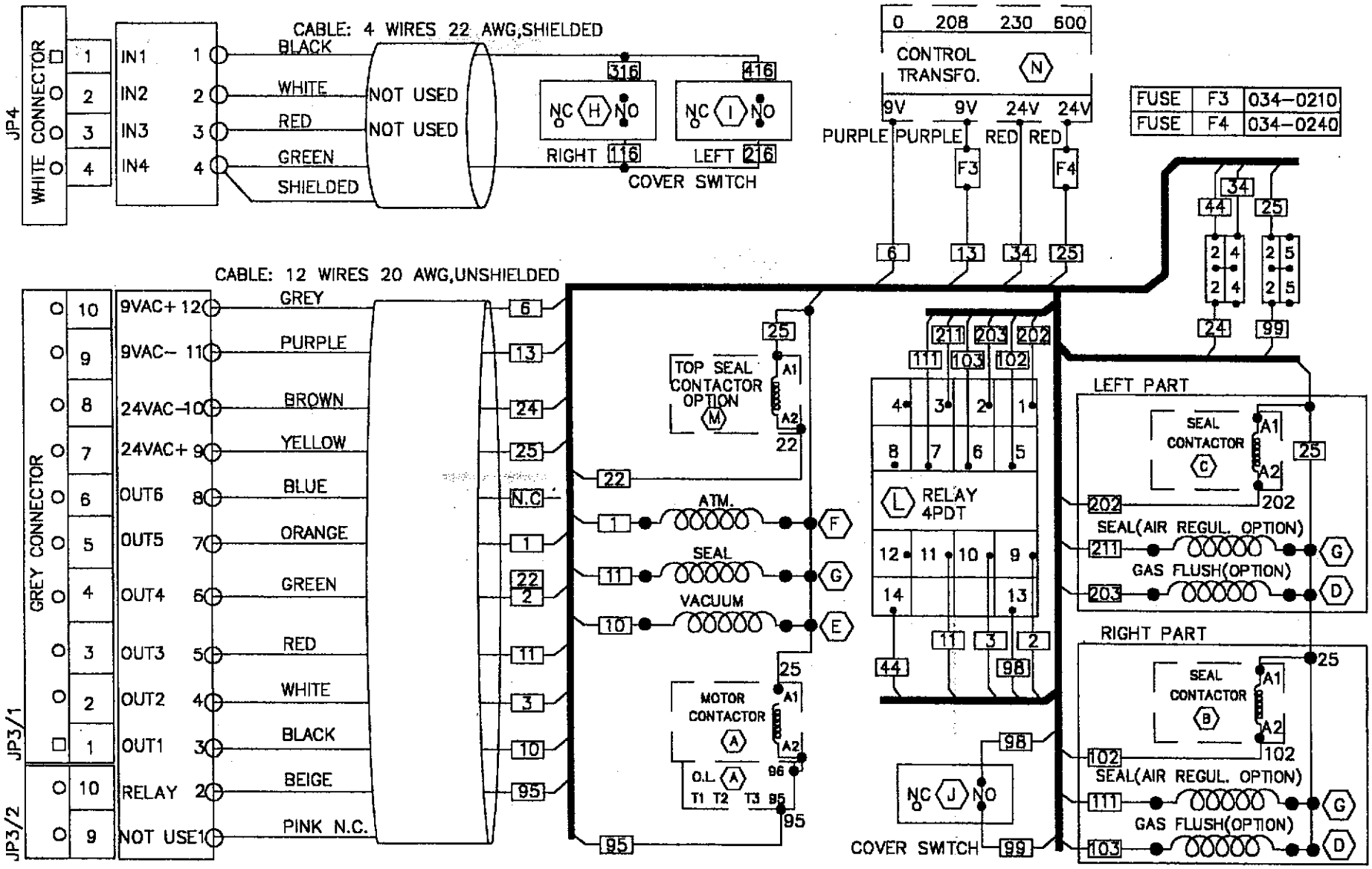




ELECTRICAL DRAWING







MC-40

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

MACHINE

VACUUM DOUBLE CHAMBER

LOW VOLTAGE WITH MC-40

SIPROMAC

ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

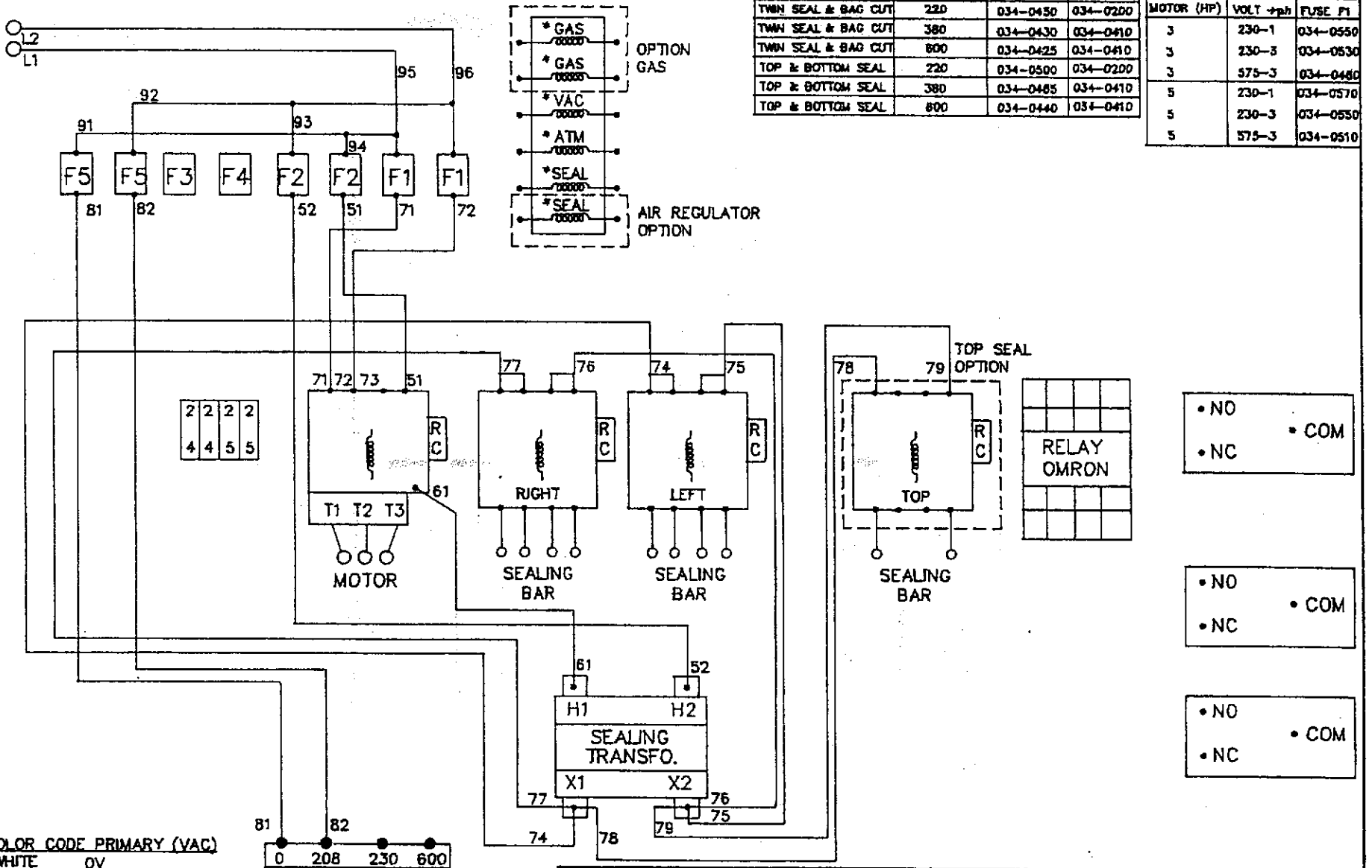
MAT:	DESS. D.L.	DATE 5 MAY 1998	NO. 016-0118
	APP.	DATE	

006-0068

* RC SUPPRESSOR ADD ON EACH COIL

OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL & BAG CUT	220	034-0450	034-0200
TWIN SEAL & BAG CUT	380	034-0430	034-0410
TWIN SEAL & BAG CUT	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0485	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

PUMP		
MOTOR (HP)	VOLT +ph	FUSE F1
3	230-1	034-0550
3	230-3	034-0530
3	575-3	034-0460
5	230-1	034-0570
5	230-3	034-0550
5	575-3	034-0510



COLOR CODE PRIMARY (VAC)

WHITE	0V
BLACK	190V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY (VAC)

RED	24V
PURPLE	9V

MACHINE: 420A,600A & 620A

PIECE: ELECT. WIRING HIGH VOLTAGE 1ø

QT. ——— ECH. SCALE ———

NE PAS MESURER /N.T.S.

MAT:

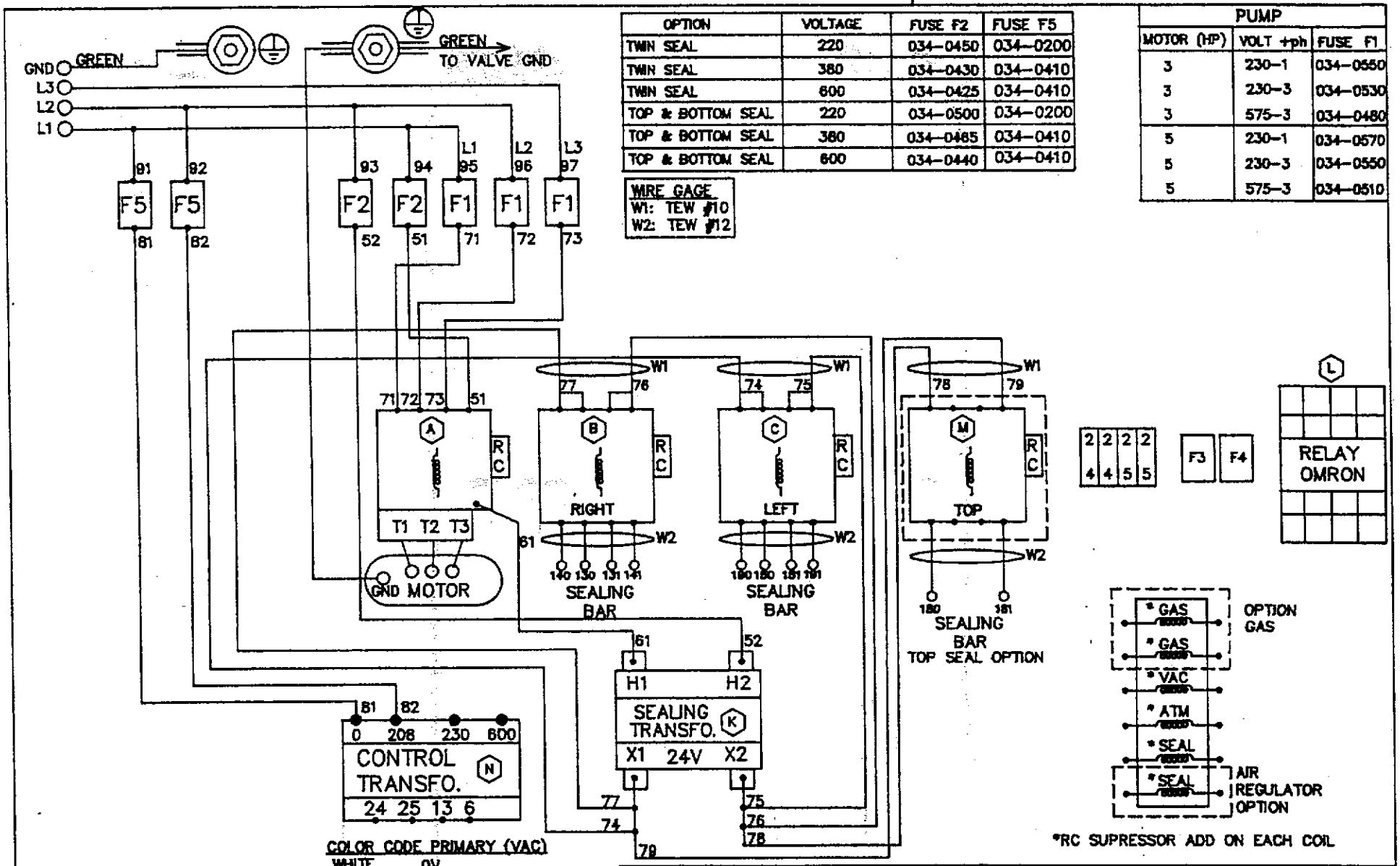
DESS. D. LETOURNEAU DATE 97-03-10

APP. DATE

NO. 006-0068

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

006-0069



OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0450	034-0200
TWIN SEAL	380	034-0430	034-0410
TWIN SEAL	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0485	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

WIRE GAGE
W1: TEW #10
W2: TEW #12

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

COLOR CODE PRIMARY (VAC)

WHITE	0V
BLACK	190V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY (VAC)

RED	24V
PURPLE	9V

MACHINE: 420A,600A & 620A

PIECE: ELECT. WIRING HIGH VOLTAGE 3Ø

QT. ——— ECH. SCALE ———

MAT.

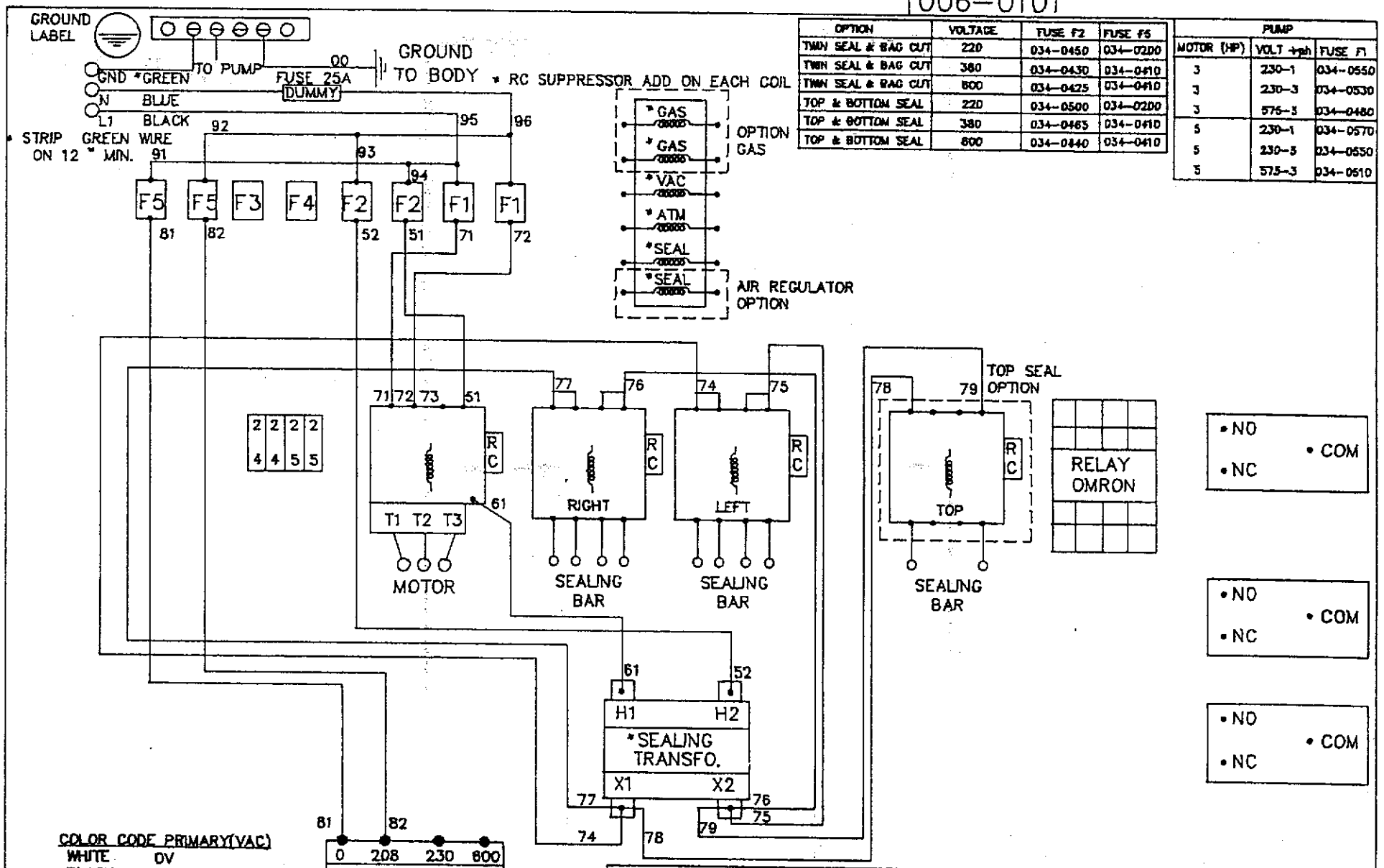
DESS. D. LETOURNEAU DATE 97-03-10

APP. DATE

SIPROMAC
ST-GERMAIN DE GRANTHAM,
QUEBEC CANADA

NO. 006-0069

006-0101



OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL & BAG CUT	220	034-0450	034-0200
TWIN SEAL & BAG CUT	380	034-0430	034-0410
TWIN SEAL & BAG CUT	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0465	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

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

COLOR CODE PRIMARY(VAC)

WHITE	0V
BLACK	190V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY(VAC)

RED	24V
PURPLE	9V

* USE ONLY "STARS WASHERS" FOR TRANSFO. FIXATION.

MACHINE: 420A,600A & 620A

PIECE: ELECT. WIRING HIGH VOLTAGE 1ø,50 HZ

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

MAT:

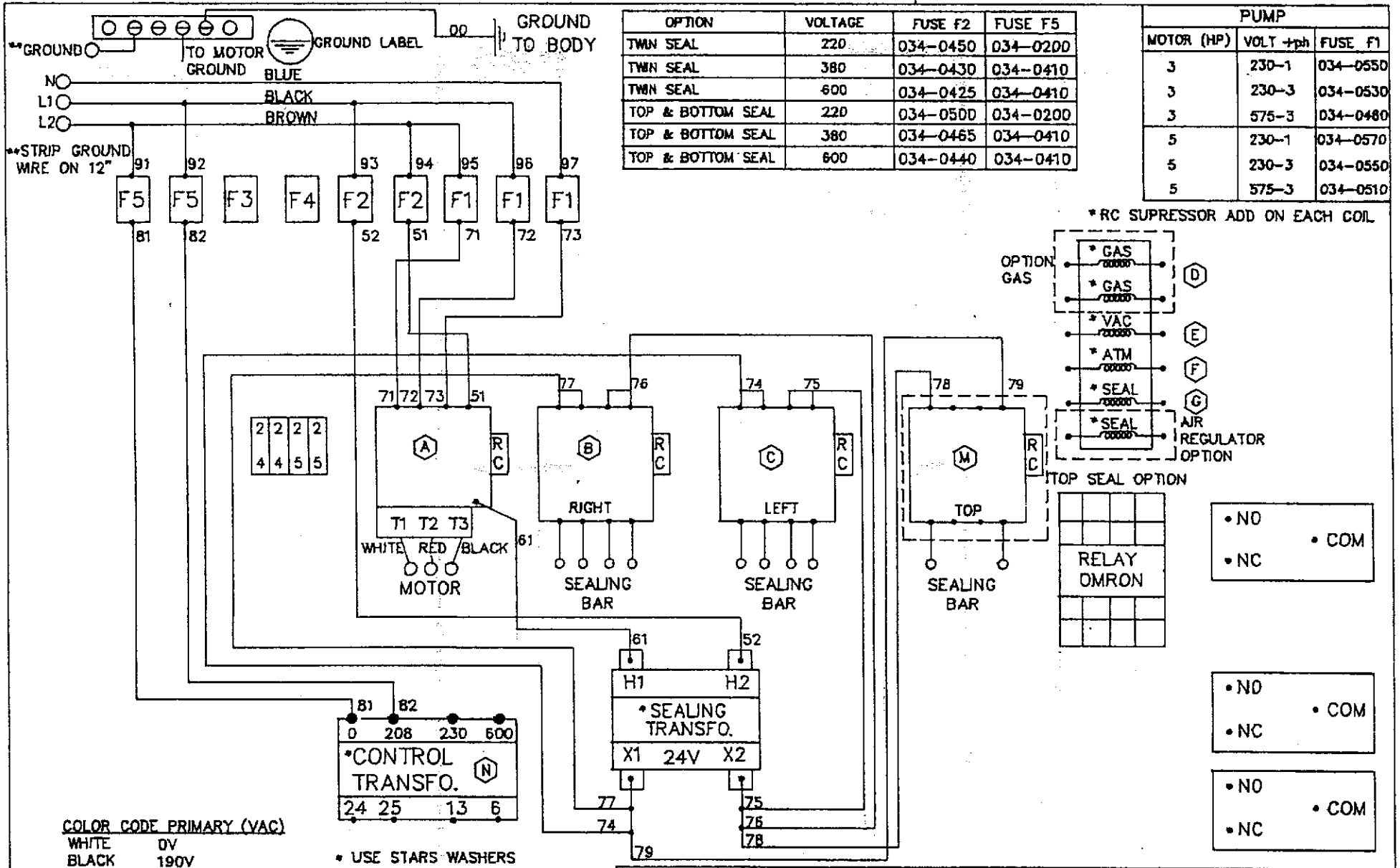
DESS. D. LETOURNEAU DATE 97-03-11

APP. DATE

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

NO. 006-0101

1006-0102



OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0450	034-0200
TWIN SEAL	380	034-0430	034-0410
TWIN SEAL	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0465	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

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

*RC SUPRESSOR ADD ON EACH COIL

COLOR CODE PRIMARY (VAC)

WHITE	0V
BLACK	190V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY (VAC)

RED	24V
PURPLE	9V

* USE STARS WASHERS FOR TRANSFO. FIXATION.

MACHINE: 420A,600A & 620A

PIECE: ELECT. WIRING HIGH VOLTAGE (50 HZ) 3φ

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

MAT:

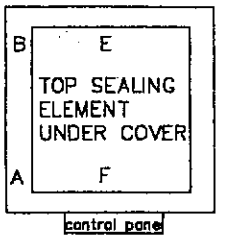
DESS. D. LETOURNEAU DATE 96-10-02

APP. DATE

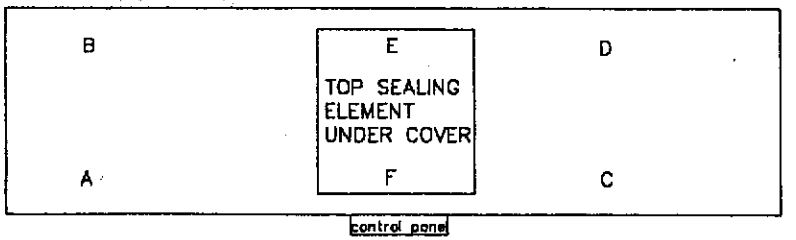
SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

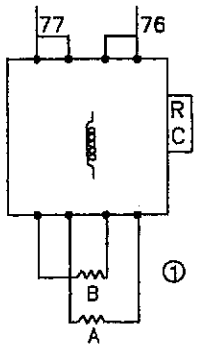
NO. 006-0102

SINGLE CHAMBER

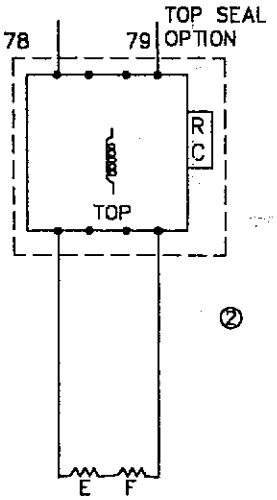


DOUBLE CHAMBER

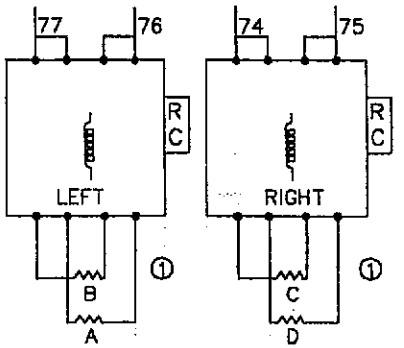




SEALING BAR

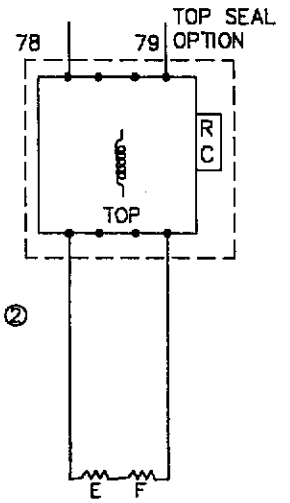


SEALING BAR



SEALING BAR

SEALING BAR



SEALING BAR

① WIRE TEW 12 AWG SIPROMAC # 030–0420

② WIRE CABTIRE 12/3 SJ SIPROMAC # 030–0120
CONNECTOR CD–13 SIPROMAC # 036–0409

MACHINE: ALL MODEL			SIPROMAC
PIECE: WIRING FOR SEALING BAR			ST–GERMAIN DE GRANTHAM, QUEBEC CANADA
QT. ———	ECH. SCALE ———	NE PAS MESURER /N.T.S.	
MAT:	DESS. ERIC J. T.P.	DATE 12 DEC 2000	NO. 006–0131
	APP.	DATE	

ELECTRICAL DRAWINGS PARTS LIST

A : VOLT	PHASE	PUMP HP	CONTACTOR	OVERLOAD
220	1	3	025-0040	025-0190
220	3	3	025-0020	025-0180
575	3	3	025-0010	025-0150
220	1	4	025-0050	025-0200
220	3	4	025-0030	025-0190
460	3	4	025-0010	025-0170
575	3	4	025-0010	025-0160
220	1	7.5	025-0070	025-0222
220	3	7.5	025-0040	025-0210
575	3	7.5	025-0010	025-0180

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

D: OPTIONAL GAZ SOLENOID VALVE: 106-0010

E: VACUUM SOLENOID VALVE: 106-0050

F: ATMOSPHERE SOLENOID VALVE: 106-0030 WITH PUMPS: 3HP & 4HP
106-0050 WITH PUMP: 7.5 HP

G: BELLOWS SOLENOID VALVE: 106-0070

H, I, J: COVER SWITCH: 026-0590

K: SEALING TRANSFO.:

TWIN SEAL & BAG CUT: 029-0040, 029-0050
TOP & BOTTOM SEALING: 029-0080

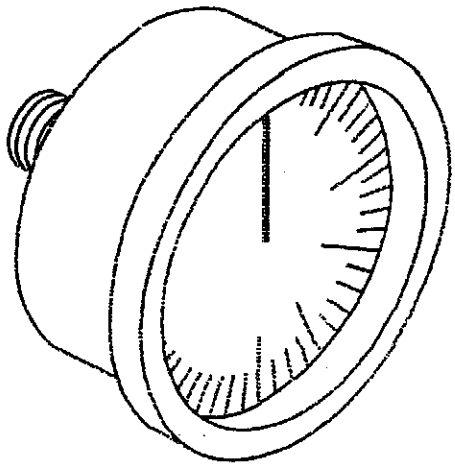
L: RELAY & BASE:

RELAY: 025-0600
BASE: 025-0610

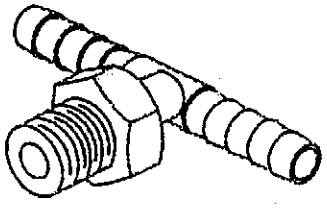
M: OPTIONAL TOP SEALING CONTACTOR: 025-0020

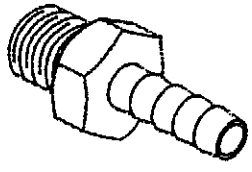
N: CONTROL TRANSFO.: 029-0007, 029-0008, 029-0009, 029-0250

DAJG/86



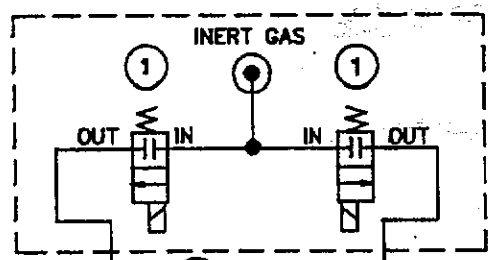
PNEUMATIC DRAWING



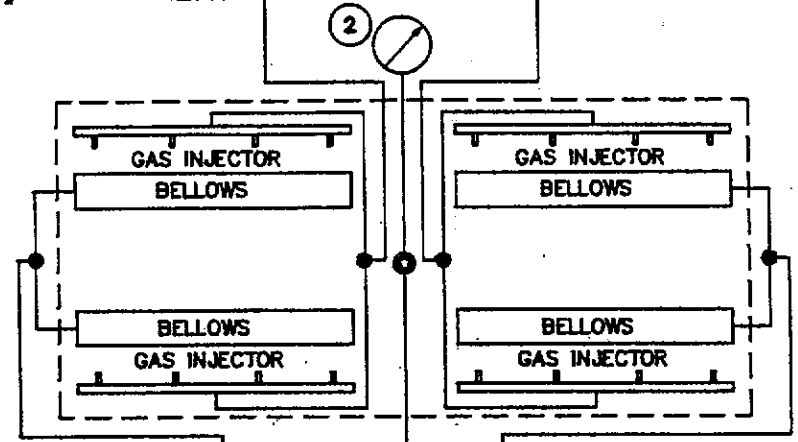


007-0019

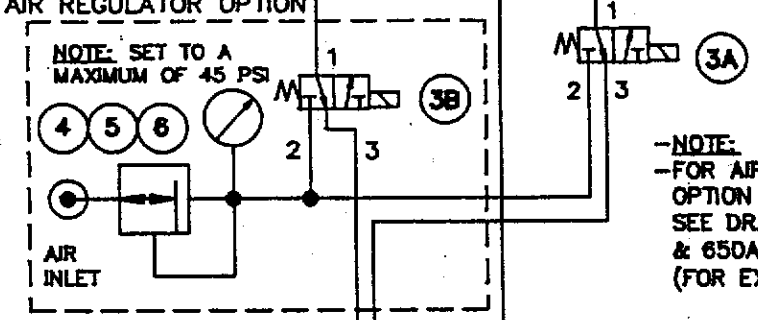
-NOTE:
-FOR GAS INJECTION KIT INSTALLATION SEE DRAWINGS #:
420A: #010-0016
600A: #010-0017
620A: #010-0018
650A: #010-0020

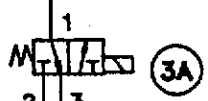


GAS OPTION

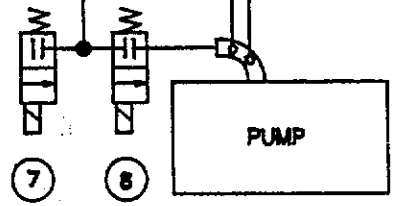


AIR REGULATOR OPTION



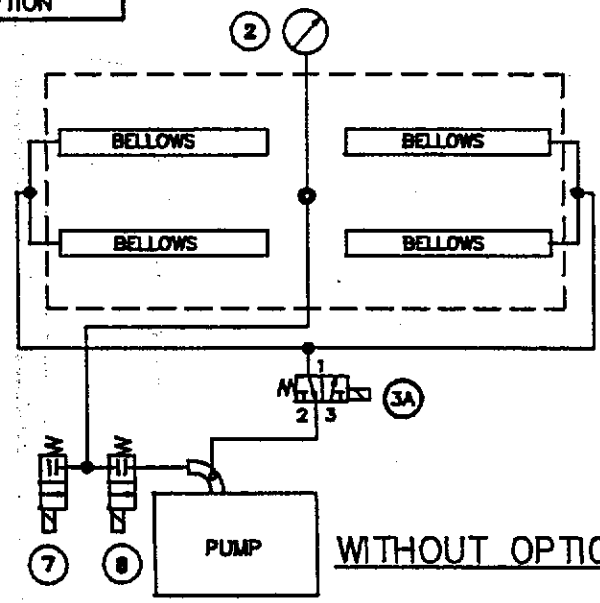


-NOTE:
-FOR AIR REGULATOR OPTION KIT INSTALLATION SEE DRAWINGS #: 010-0019 & 650A: #010-0027 (FOR EXISTING MACHINES)



WITH OPTIONS

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	2*
2	114-0260	VACUUM GAUGE	1
3A	106-0070	BELLOWS VALVE	1
3B	106-0070	BELLOWS VALVE	1*
4	114-0147	PRESSURE REGULATOR	1*
5	114-0245	PRESSURE GAUGE	1*
6	114-0170	PRESSURE REGULATOR SUPPORT	1*
7	106-0030	ATMOSPHERE VALVE FOR 420A	1
	106-0030	ATMOSPHERE VALVE FOR 600A, 063M^3 AND 100 M^3	
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A: 160 M^3 AND 250 M^3	
	106-0050	ATMOSPHERE VALVE FOR 650A & 700A	
8	106-0030	VACUUM VALVE FOR 420A	1
	106-0050	VACUUM VALVE FOR 600A & 620A	
	106-0060	VACUUM VALVE FOR 650A & 700A	
*: OPTION			



WITHOUT OPTION

LET.	MODIFICATION	DATE	INT.
A	RE-DRAWN	97-03-11	M.L.

MACHINE: 420A,600A,620A & 650A
PART: PNEUMATIC
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
ITEM: CNC: SCALE: QT. 1
MAT: DRG BY M.LAVIGNE DATE 97-03-11
APP. DATE
NO. 007-0019

United States Department of Agriculture

Food Safety and Inspection Service

Washington, D.C. 20250

May 14, 1992

Sipromac, Inc.

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

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

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

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

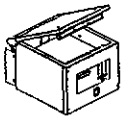
Sincerely,

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

NOTES

SIPROMAC

NOTES



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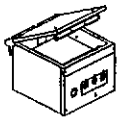

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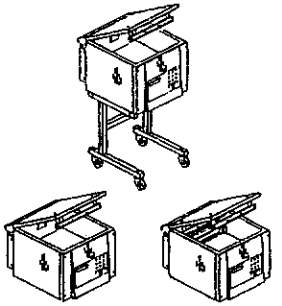

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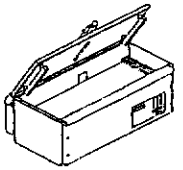

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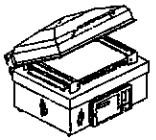

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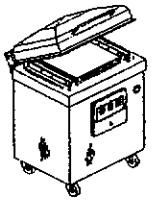

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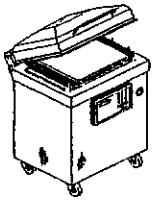

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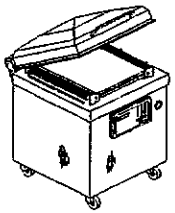

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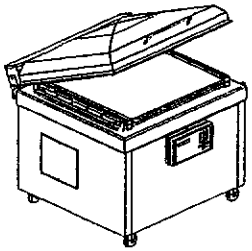
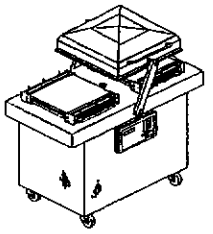


580A

SIPROMAC

VACUUM PACKAGING MACHINES



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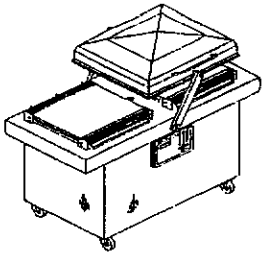

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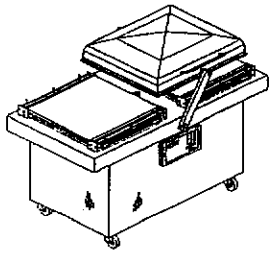

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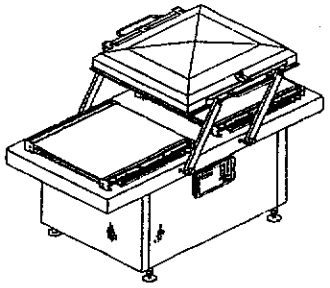

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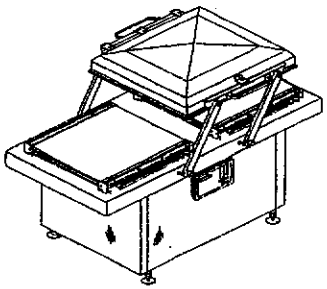

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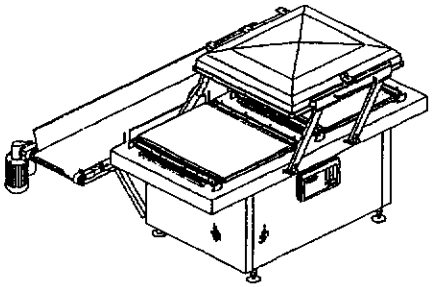

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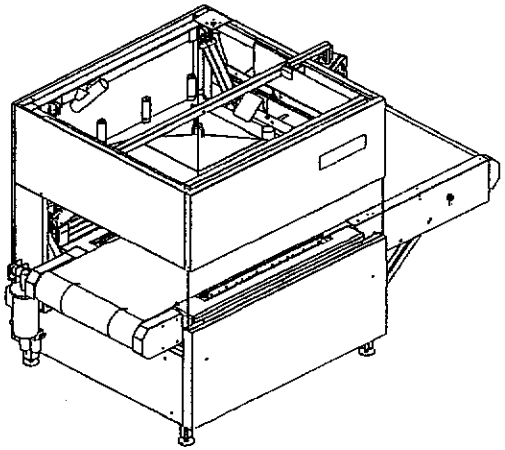


750A


SIPROMAC

MANUEL D'UTILISATEUR

MICROPROCESSUR MC-40
AVEC DÉTECTEUR DE VIDE

EMBALLEUSE SOUS VIDE

TABLE DES MATIÈRES

EMBALLEUSES SOUS VIDE
INSTRUCTIONS D'OPÉRATIONS

TABLE DES MATIÈRES

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.

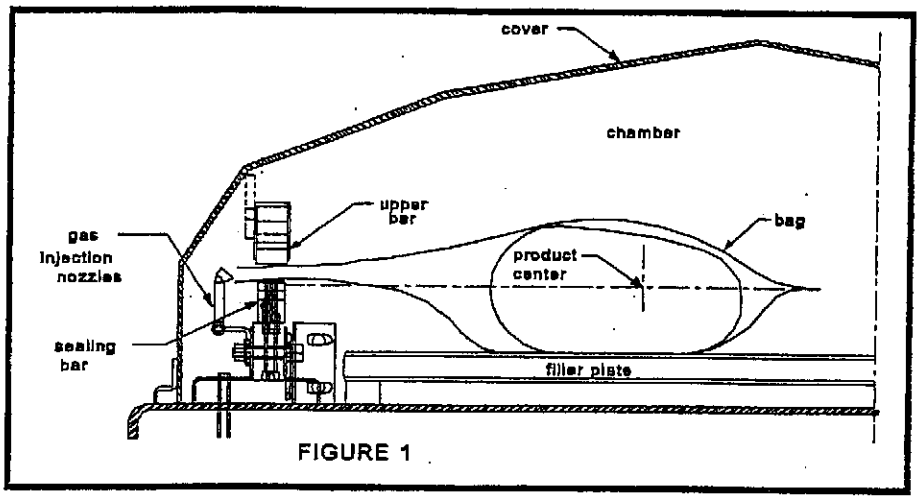


FIGURE 1

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:

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

3.3.3.3 Ajustement du Temps de Vide "Plus":

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

3.3.3.4 Ajustement de l'injection de gaz

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.

3.3.3.5 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.

-MENUS STRUCTURE-

- Functions menu:

  "F1 CREATE A PRGM"
  "F2 DELETE A PRGM"
  "F3 SELECT OPMODE" (automatic units only)

- Programs menu:

  "Pxx NAME"

  Program submenu:

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

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

  "DIAGNOSTICS MENU" (access code required)

  "D1 INPUTS TEST"

  "D2 OUTPUTS TEST"

  "D3 MODEL SELECT"

  "D4 GAS OPTION"

  "D5 SEALING TIME"

  "D6 COOLING TIME"

  "D7 LOADING TIME" (automatic units only)

  "D8 UNLOADNG TIME" (automatic units only)

  "SYSTEM MONITOR" (no access code required)

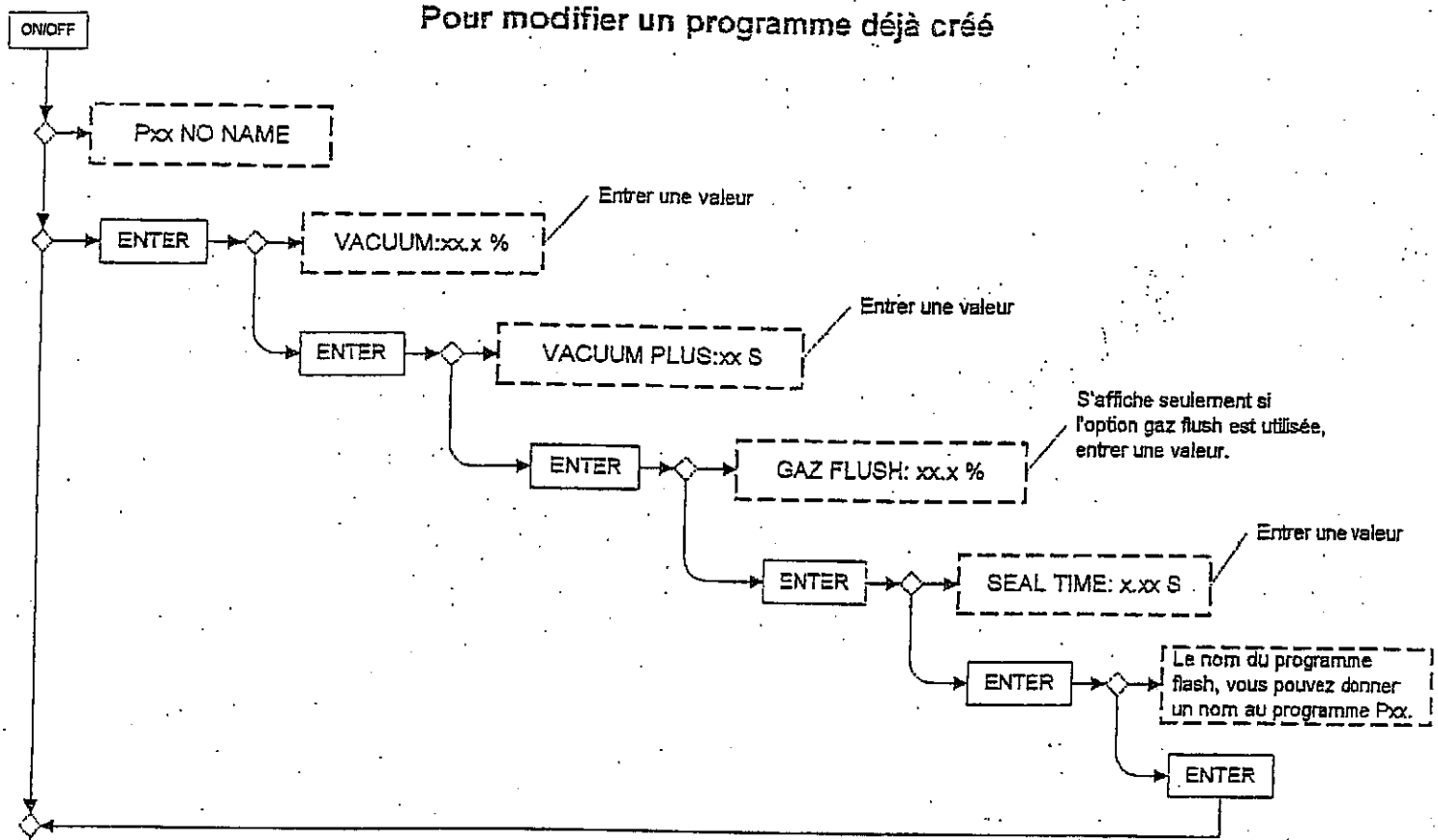
  "SOFTWARE: R x.xx"

  "WORK HRS: xxxxx"

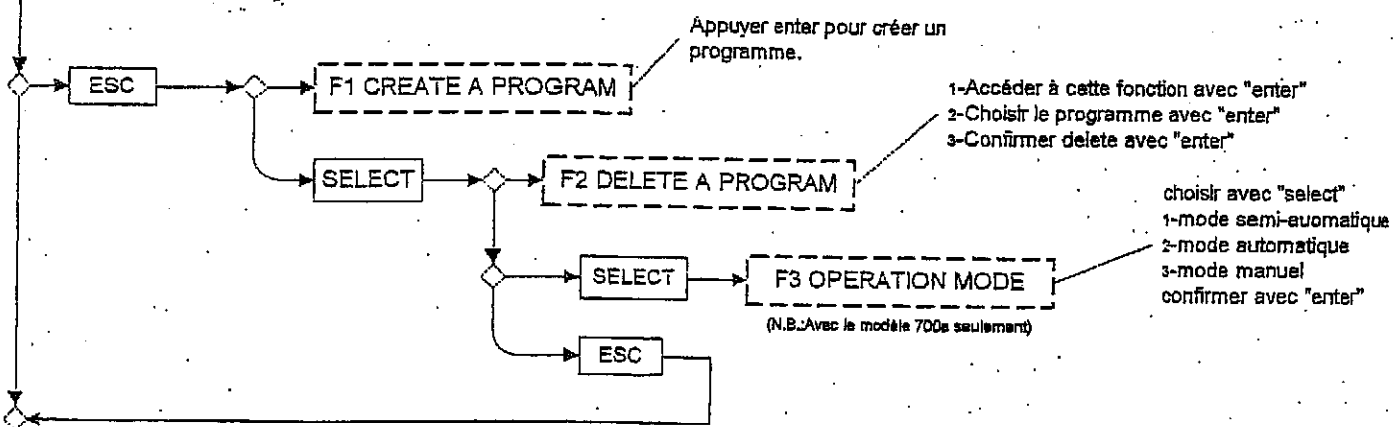
  "CYCLES: xxxxxxx"

PROGRAMMATION MC-40

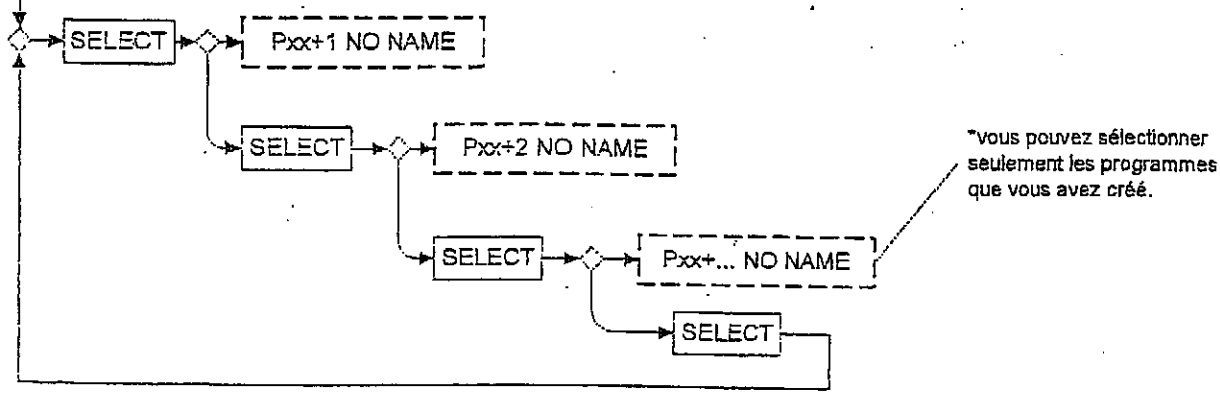
Pour modifier un programme déjà créé



Pour créer un programme

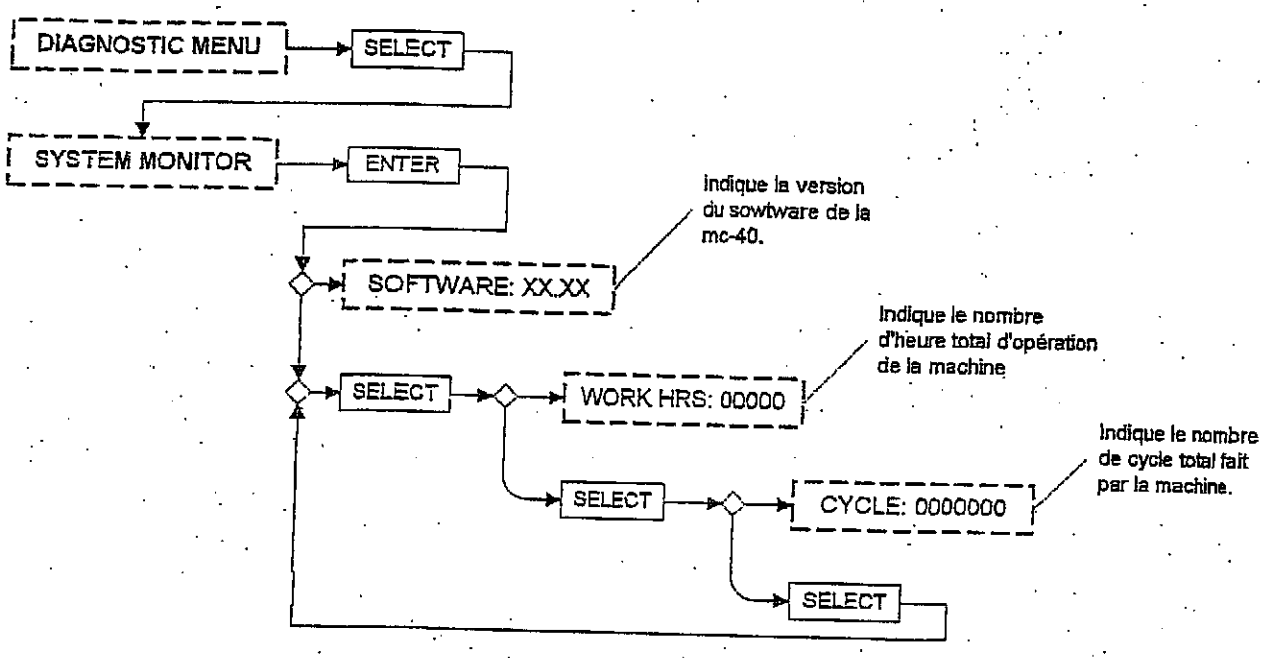


Pour sélectionner un programme créé



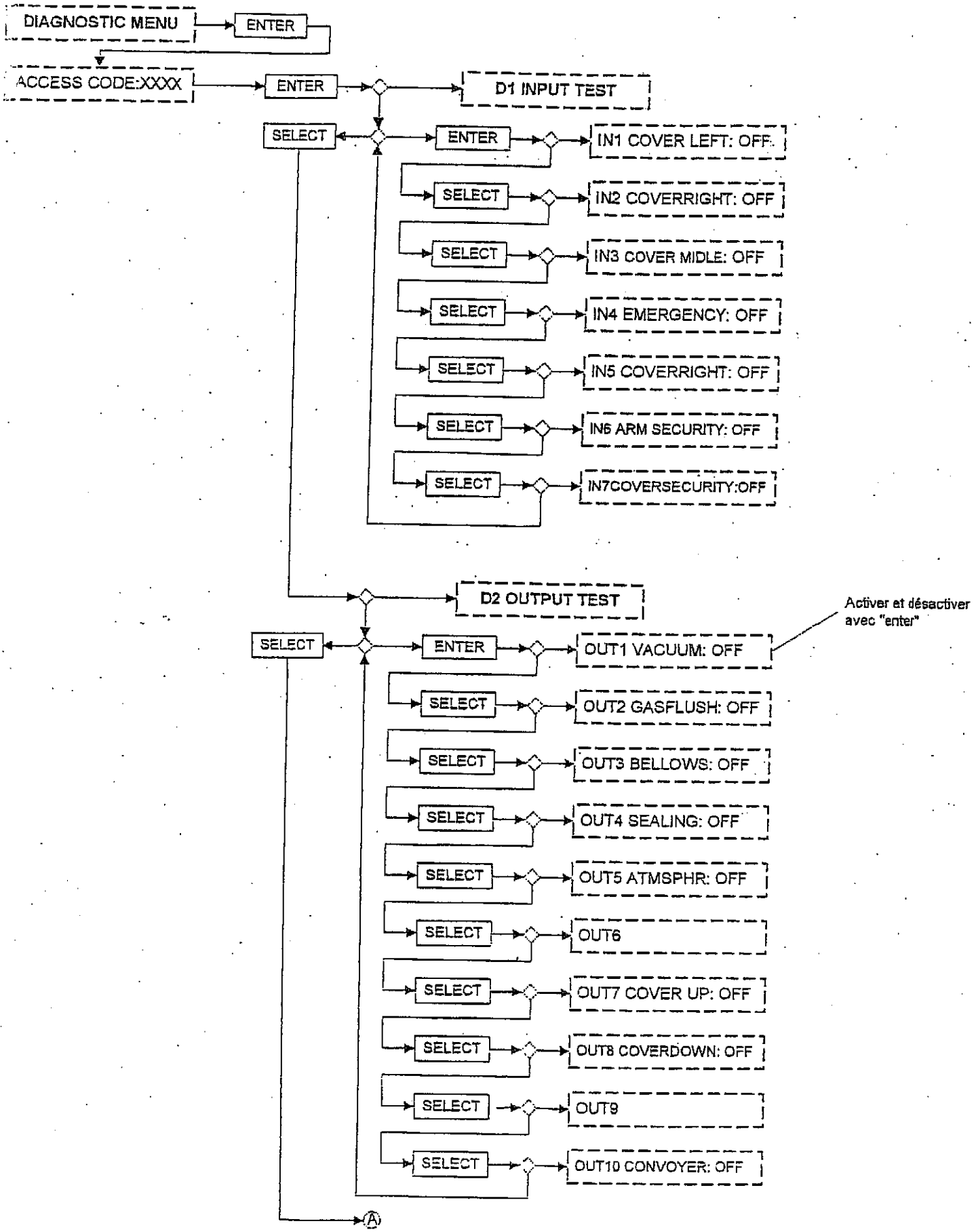
SYSTEM MONITOR

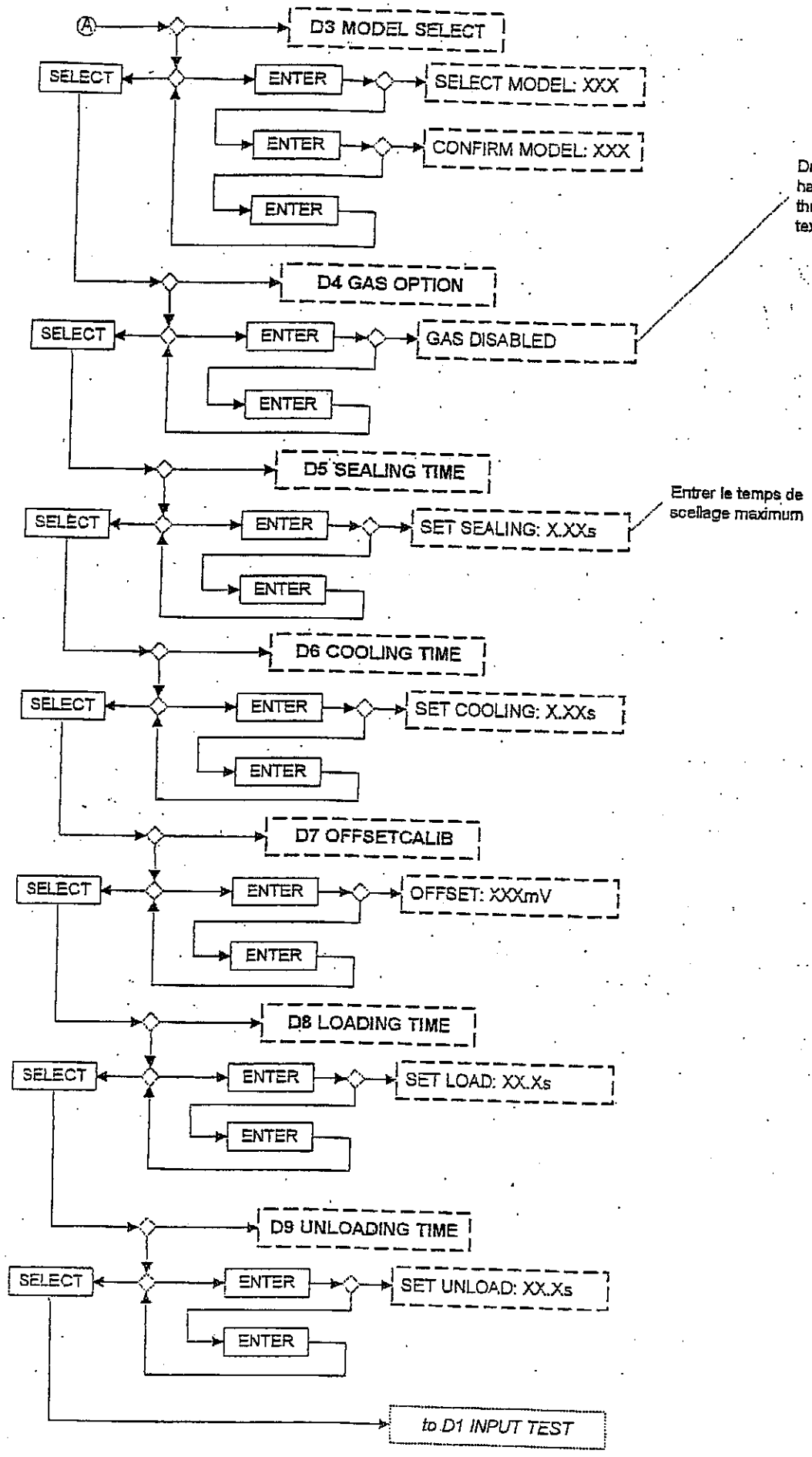
Pour acceder au menu "system monitor", mettre la machine à off, tenir la touche "esc", appuyer et relacher la touche "on/off" et finalement relacher la touche "esc". L'affichage indique DIAGNOSTIC MENU, appuyer sur select pour accéder au SYSTEM MONITOR.



DIAGNOSTIC MENU

Pour acceder au "DIAGNOSTIC MENU", mettre la machine à off, tenir la touche "esc", appuyer et relacher la touche "on/off" et finalement relacher la touche "esc". L'affichage indique DIAGNOSTIC MENU, appuyer sur enter pour y accéder.




A
D3 MODEL SELECT
SELECT
ENTER
SELECT MODEL: XXX
ENTER
CONFIRM MODEL: XXX
ENTER
D4 GAS OPTION
SELECT
ENTER
GAS DISABLED
ENTER
D5 SEALING TIME
SELECT
ENTER
SET SEALING: X.XXs
ENTER
D6 COOLING TIME
SELECT
ENTER
SET COOLING: X.XXs
ENTER
D7 OFFSETCALIB
SELECT
ENTER
OFFSET: XXXmV
ENTER
D8 LOADING TIME
SELECT
ENTER
SET LOAD: XX.Xs
ENTER
D9 UNLOADING TIME
SELECT
ENTER
SET UNLOAD: XX.Xs
ENTER
to D1 INPUT TEST
Drag the side handles to change the width of the text block.
Entrer le temps de scellage maximum