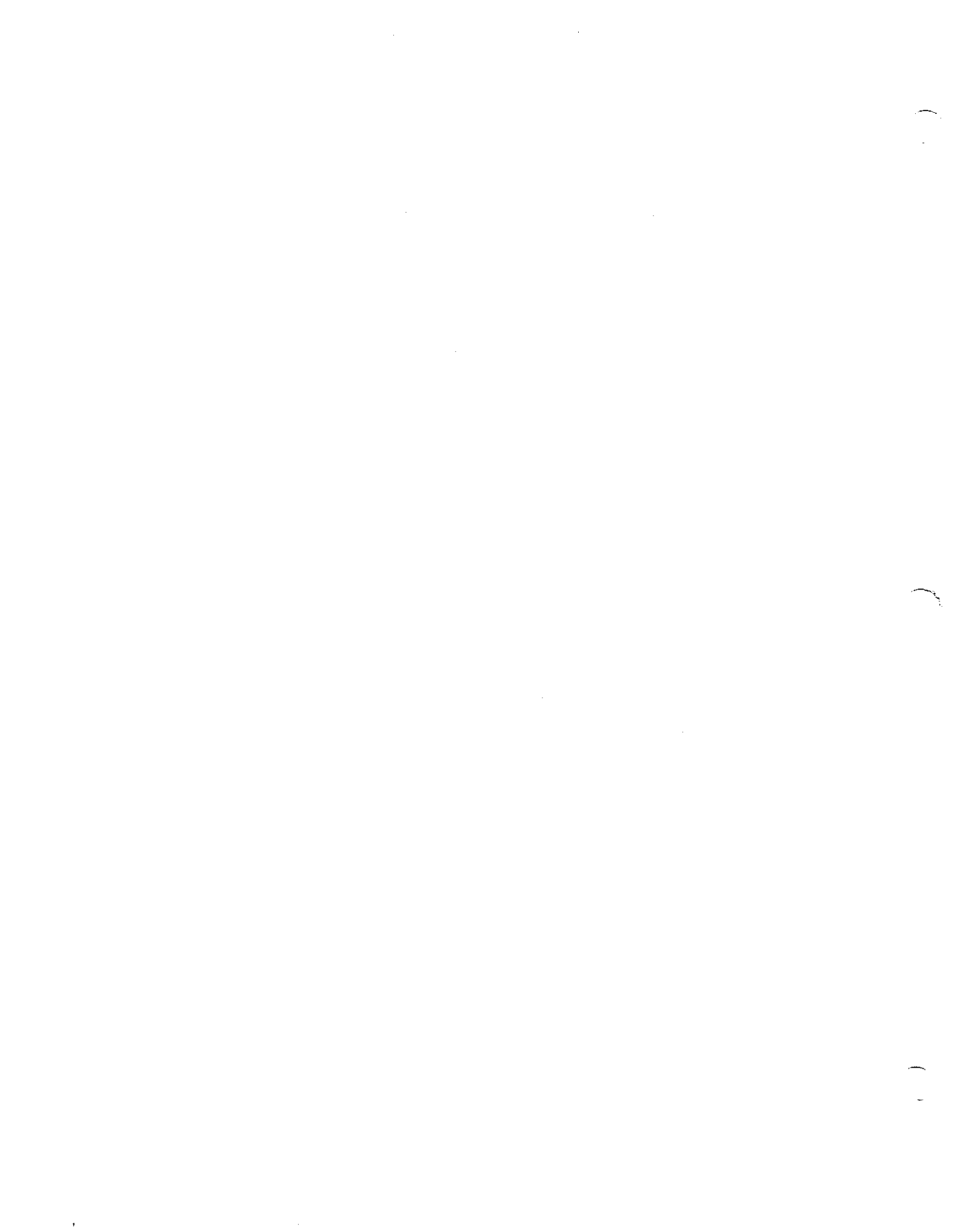


MC-30
MODEL 600A



VACUUM PACKAGING MACHINES OPERATION INSTRUCTIONS

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SIPROMAC INC.

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

1. SETTING UP THE MACHINE:

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

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

Before starting to work, check the oil view glass on the pump, if there is a sufficient quantity of oil in the pump. Never use oil other than 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 should be put in a room with an air temperature of at least 50°F (+10°C). On the other hand, there must be free access of air to the pump to allow for cooling so that operation temperature of 160°F (70°C) is not exceeded.

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.



2. Con't

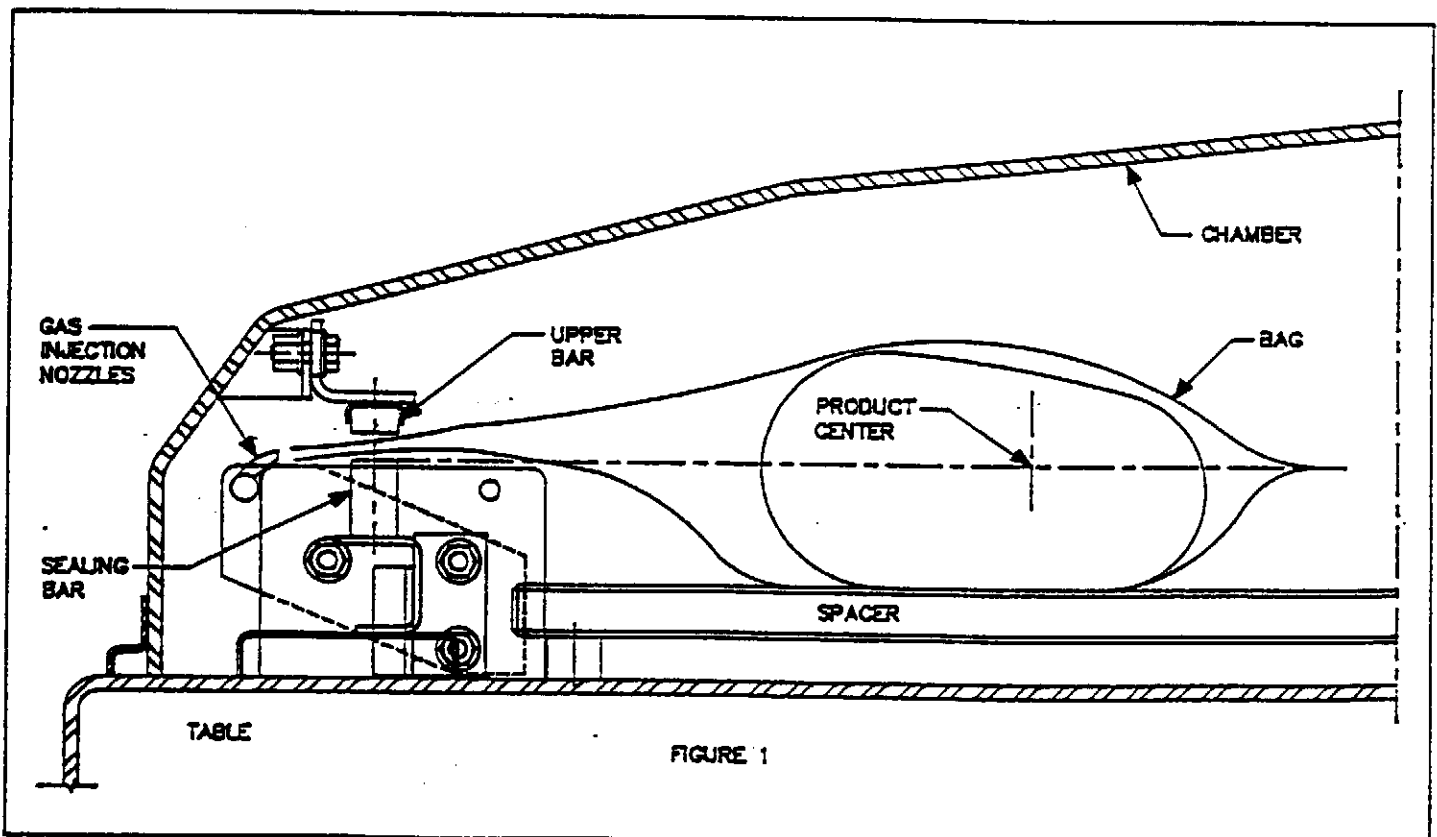
An important step in connecting the machine is to make sure that the pump turns in its correct rotation.

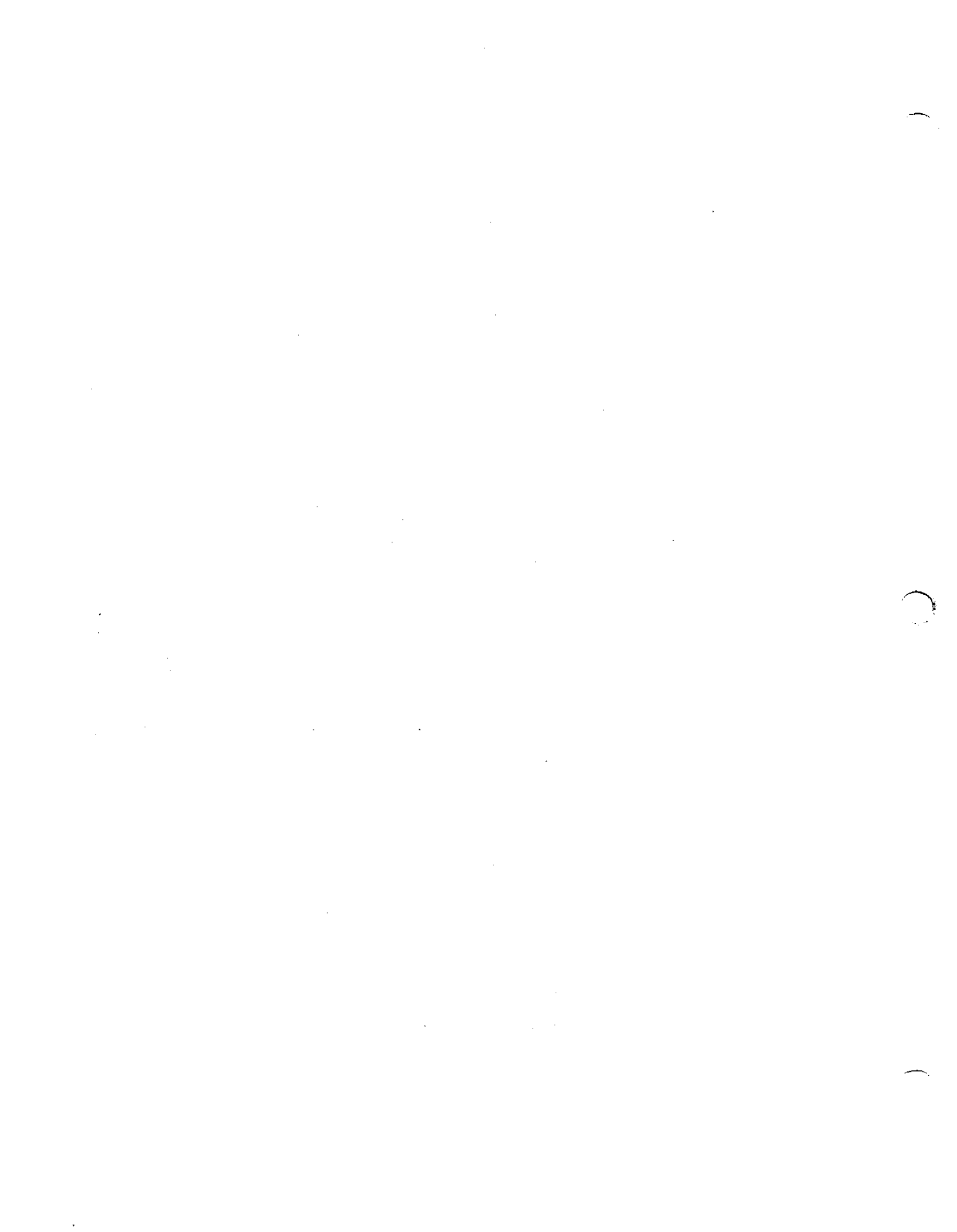
Warning: The pump should not rotate more than 3 to 4 seconds in the wrong rotation or it may cause serious damage. The proper rotation is indicated by an arrow on the pump motor.

3. OPERATION:

3.1 Working principles:

A vacuum packaging cycle is made of 3 stages. First the vacuum is made, the air is 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.





3.1 Con't

To obtain nice packages, the products and the bags have to be of proportional sizes. The bag's opening should never exceed 2" (50 cm) past the seal bars. The product should be centered in height in relation to the seal bar by adjusting the spacers provided.

To obtain a good seal, make sure that no residue of fat is left between the bag's inner sides where sealing is done.

3.2 Special packaging:

3.2.1 Gas flushing:

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

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

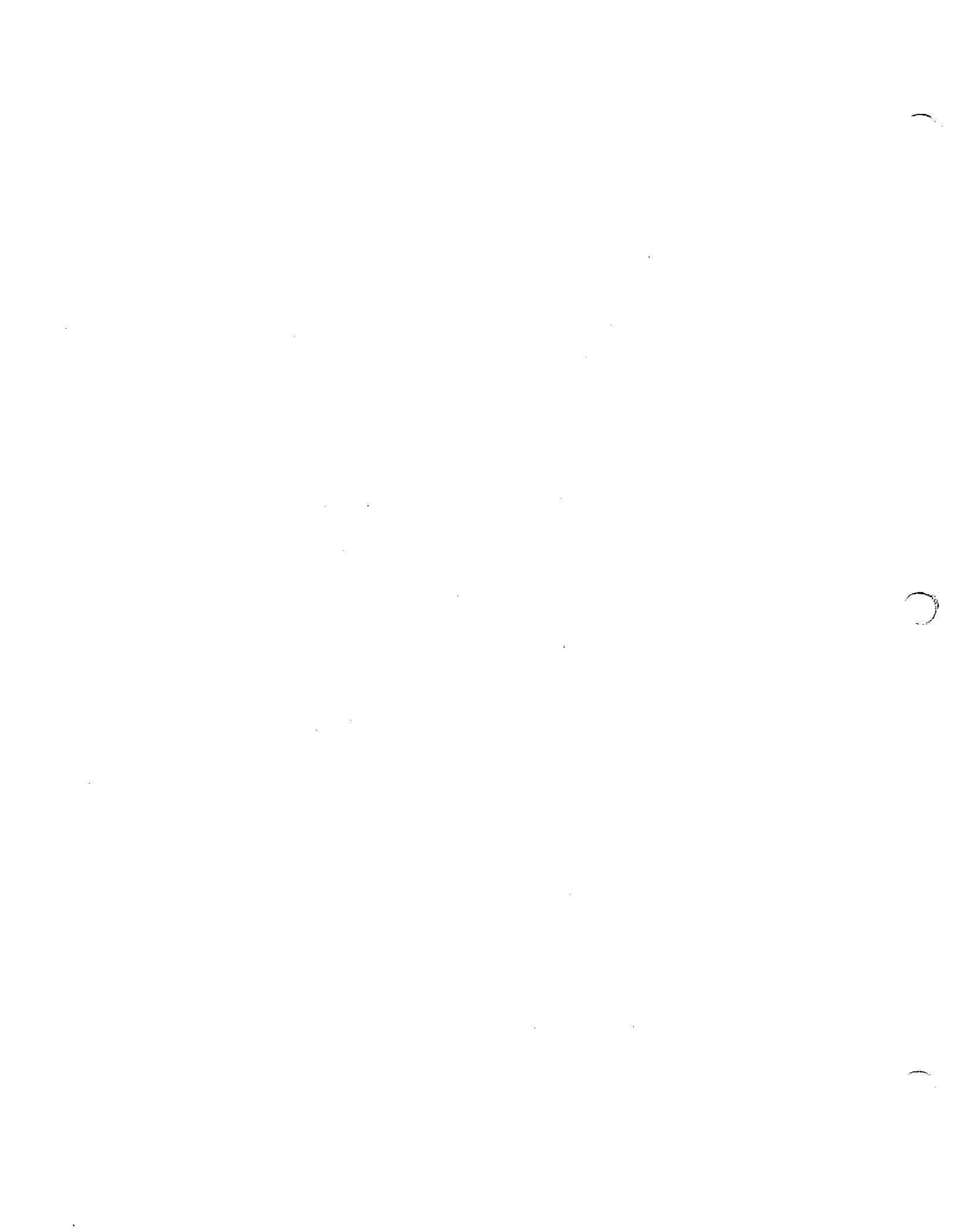
The necessary gas tank and pressure valve mounted on tank not supplied by Sipromac. The pressure of the gas regulator should be set at approximately 5 lbs/sq. inch. (1/3 kg/sq. cm). Each machine has an adaptor for gas connection.

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

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

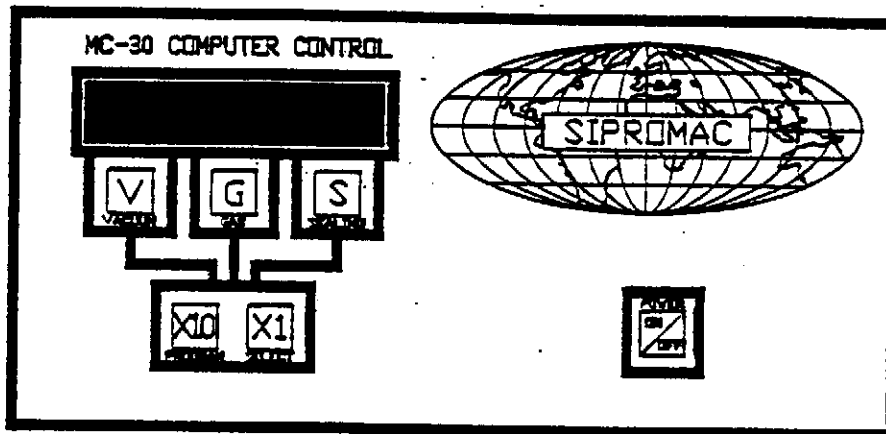
3.2.3 Electrical bag cut:

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



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

Control pannel:



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

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

How to program a complete cycle:

To enter the vacuum time (sec.):

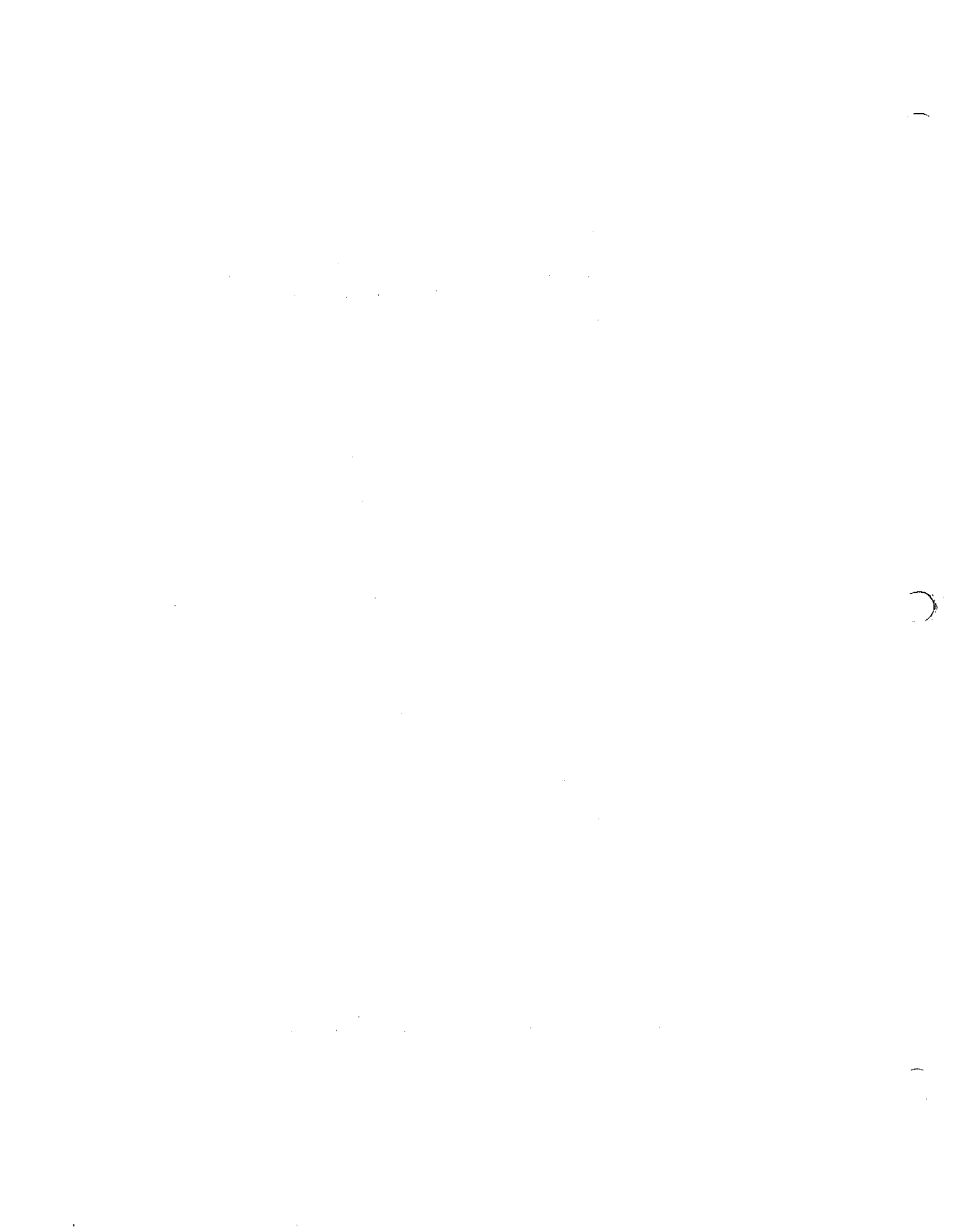
1. Press the "V" key. The display will flash.
2. Set your desired timing by pressing on "X10" and/or "X1".
3. Press one more time on the "V" key. The display stays on.

To enter the gas time (sec.):

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

To enter the sealing time (sec. decimals):

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



3.3 Con't

The micro-processor will memorize the last program you entered. The system functions with a 5 volt 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 normal due to the fact that your battery is not yet fully charged.

BASIC PROGRAM TO MODIFY ACCORDING TO THE PRODUCTS

MACHINE	"v"	* "G"	"S"
VAC 350	20 sec.	As needed	1.3 sec.
VAC 450A	20 sec.	As needed	1.3 sec.
VAC 420A	22 sec.	As needed	1.3 sec.
VAC 550A	25 sec.	As needed	1.5 sec.
VAC 600A	25 sec.	As needed	1.5 sec.
VAC 620A	25 sec.	As needed	1.5 sec.
VAC 650A	27 sec.	As needed	1.5 sec.
VAC 680A	27 sec.	As needed	1.5 sec.
VAC 700A	27 sec.	As needed	1.5 sec.

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

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

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

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

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

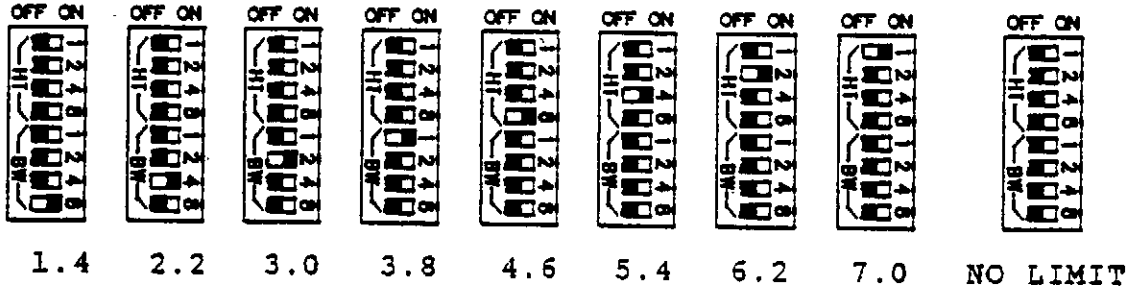


3.3 Con't

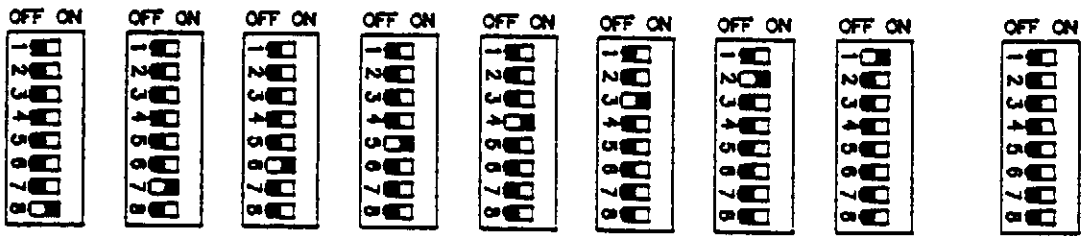
Sealing time security:

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

BEFORE
AUGUST 94



FROM
AUGUST 94



TIME LIMIT

Time limit factory settings:

350	3.8
420A	3.8
450A	4.6
550A	4.6
600A	4.6
620A	4.6
650A	4.6
680A	4.6
700A	4.6

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



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

3.4 Daily cleaning:

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

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

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

4. TROUBLE SHOOTING:

4.1 Failure during a packaging cycle:

The lid is closed and cycle fails to start or stop 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 apply, change the PC board.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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



4.3 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.

Contactors does not work.

4.3.3 Permanent sealing current:

Contactors 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.



4.2.2 No leakage in the bag:

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

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

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

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

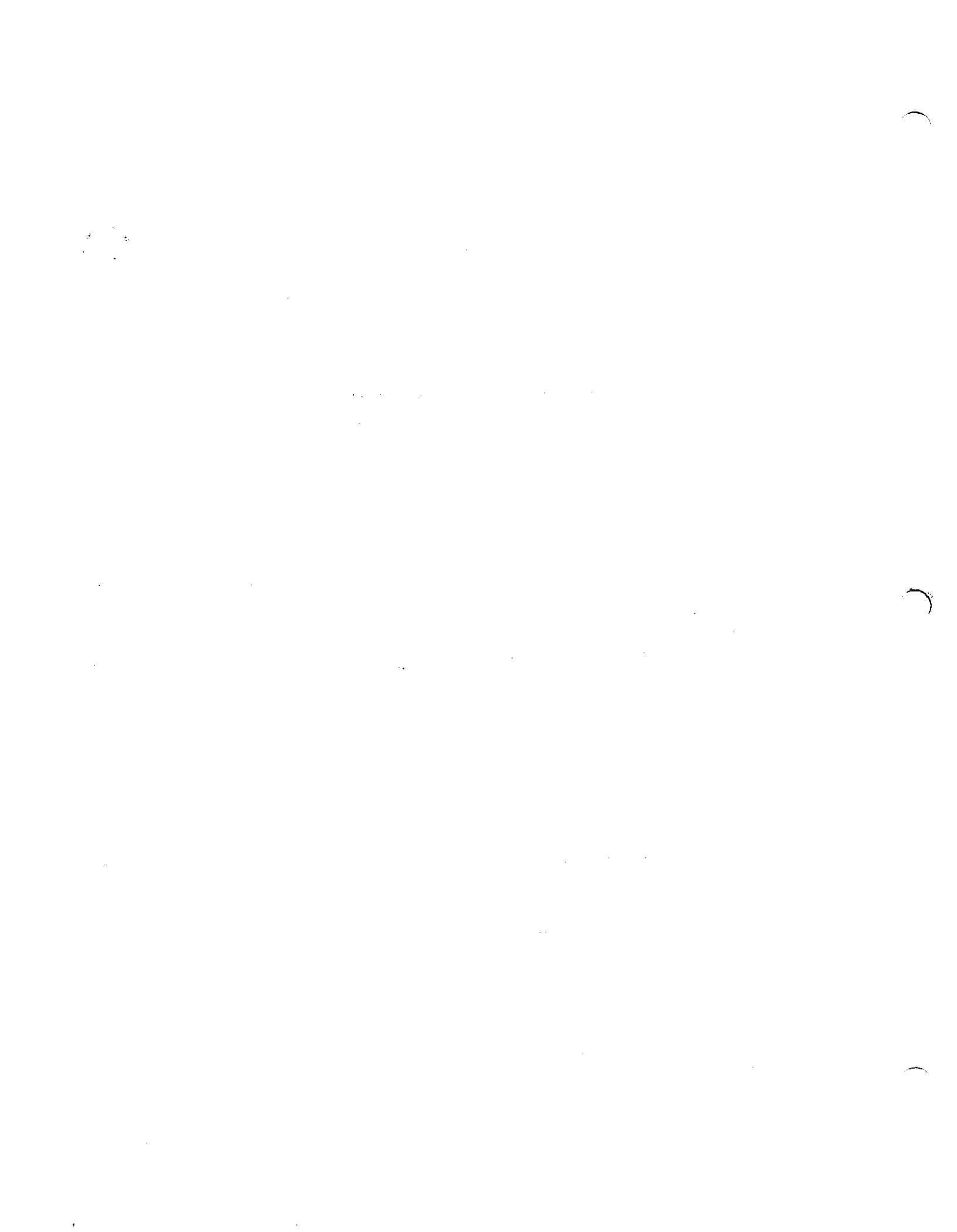
Verify at vacuum hose connections.

Verify valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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



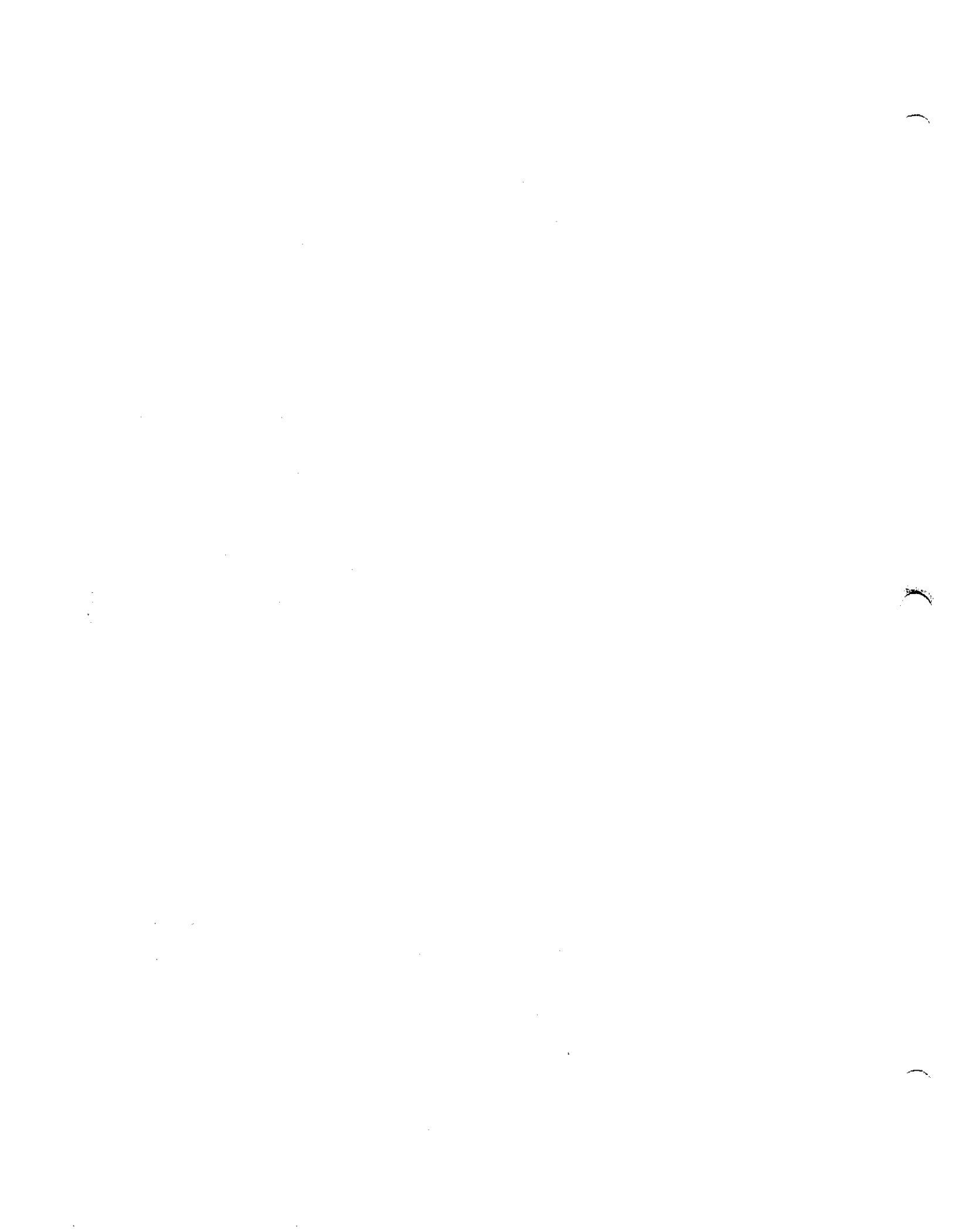
4.5 Con't

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



4.5 Con't

<p>7. Cycle does'nt start</p>	<p>7.1 Poorly adjusted cover switch</p> <p>7.2 Bad connection or defective limit switch</p> <p>7.3 Defective PC board</p> <p>7.4 PC board is OK, outputs are defective (dwg #006-0029)</p>	<p>Adjust</p> <p>Verify</p> <p>Replace PC board</p> <p>Check pump fuses, pump contactor coil, valves, etc.</p>
<p>8. Machine "recycling" or cycle "re-start" continuously</p>	<p>8.1 Poorly adjusted cover switch</p> <p>8.2 Defective PC board</p>	<p>Adjust</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>9.2 Defective contactor or valve</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>Test voltage on coil</p>



4.4 Fault in the valve:

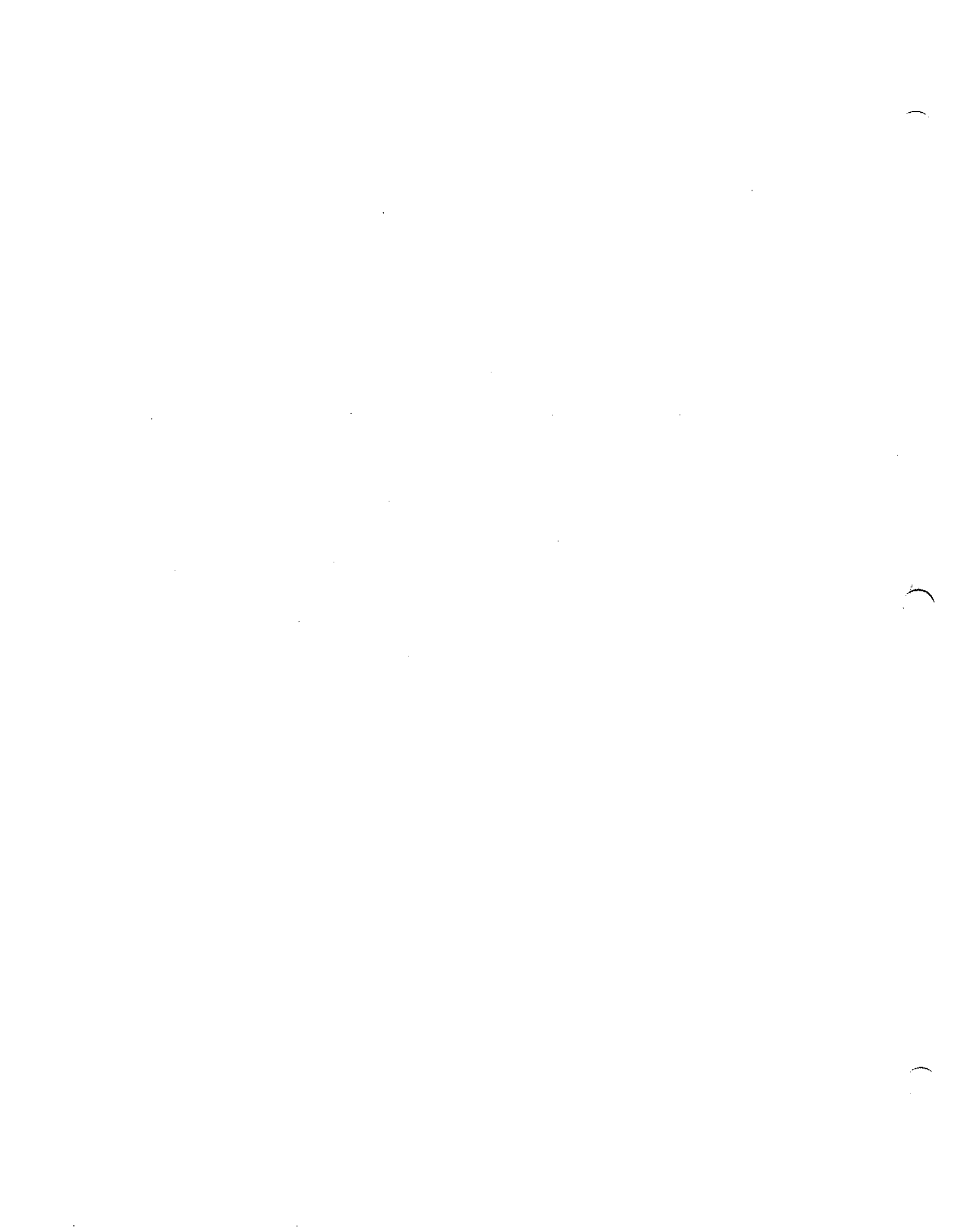
Vacuum or air valve does not open.

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

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

4.5 Control board failure

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



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.

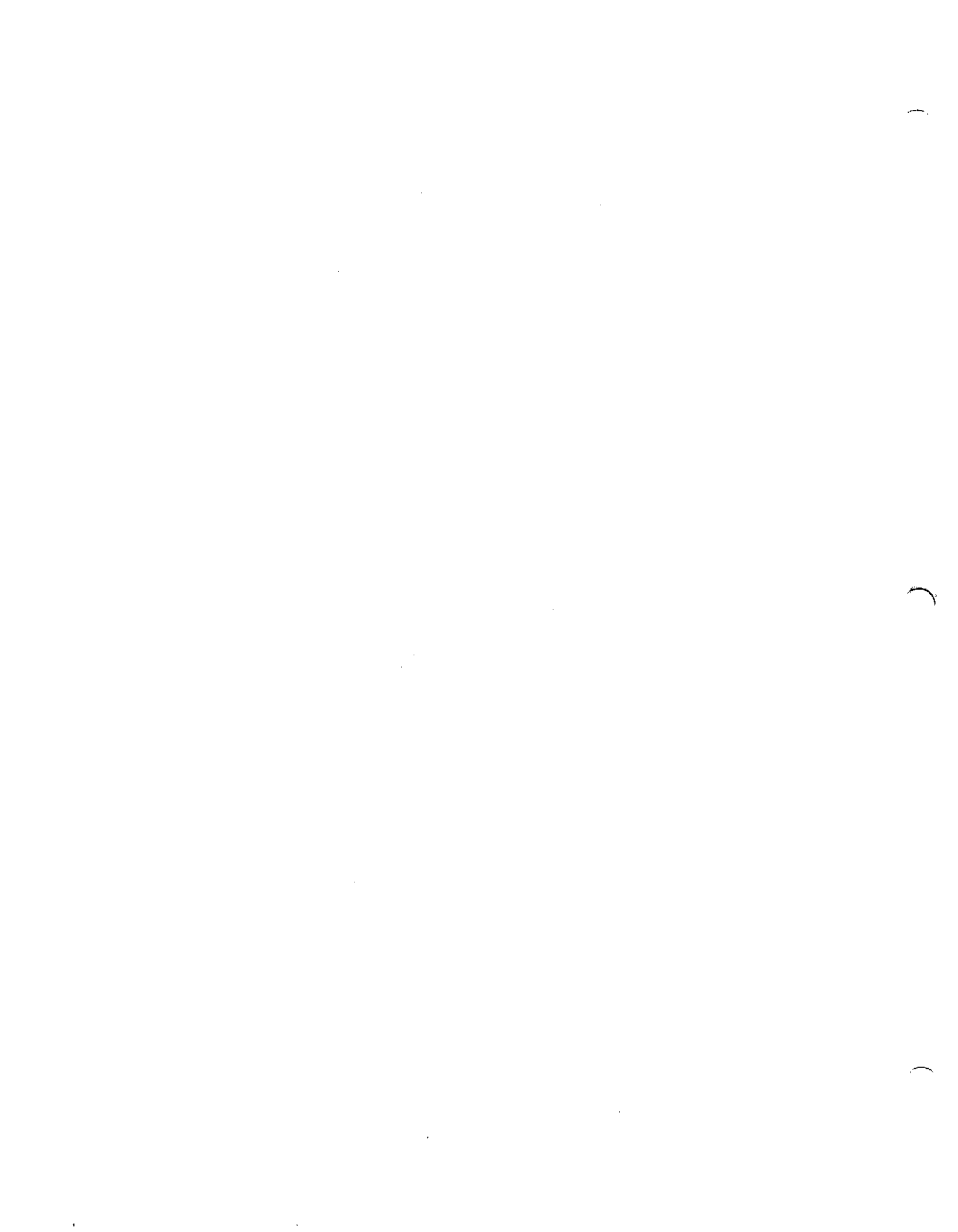
Check evacuation hose for damage (contraction of diameter, or abrasions).

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.



VACUUM PACKAGING MACHINE

MODEL 600A

GENERAL TABLE OF CONTENTS

I OPERATION INSTRUCTIONS

II MECHANICAL DRAWINGS

- A- Front view general assembly drawing
- B- Rear view general assembly drawing
- C- Seal bar assembly drawing
(twin seal)
- D- Seal bar assembly drawing
(electrical bag cut option)
- E- Seal bar assembly drawing
(top and bottom sealing or
bi-active seal bar option)
- F- Central shaft assembly drawing
- G- Gas injection kit installation drawing
(option gas injection)

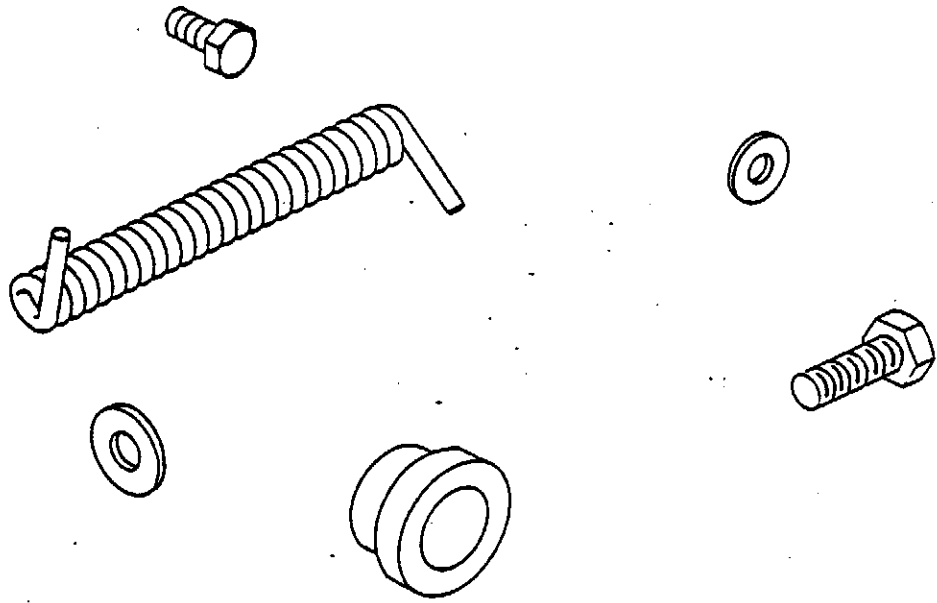
III ELECTRICAL DRAWINGS

- A- Wiring diagram 15 pins
- B- Electrical drawing low voltage
- C- Electrical drawing high voltage (600A-1 phase)
- D- Electrical drawing high voltage (600A-3 phase)

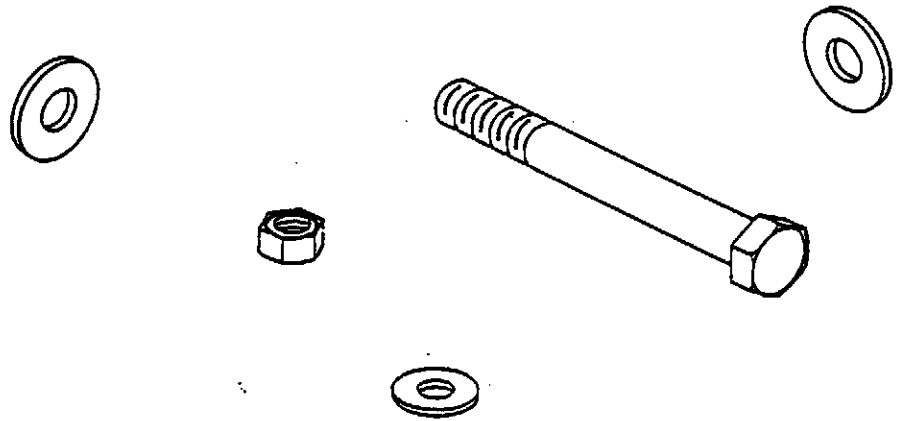
IV PNEUMATIC DRAWING

- A- Pneumatic drawing

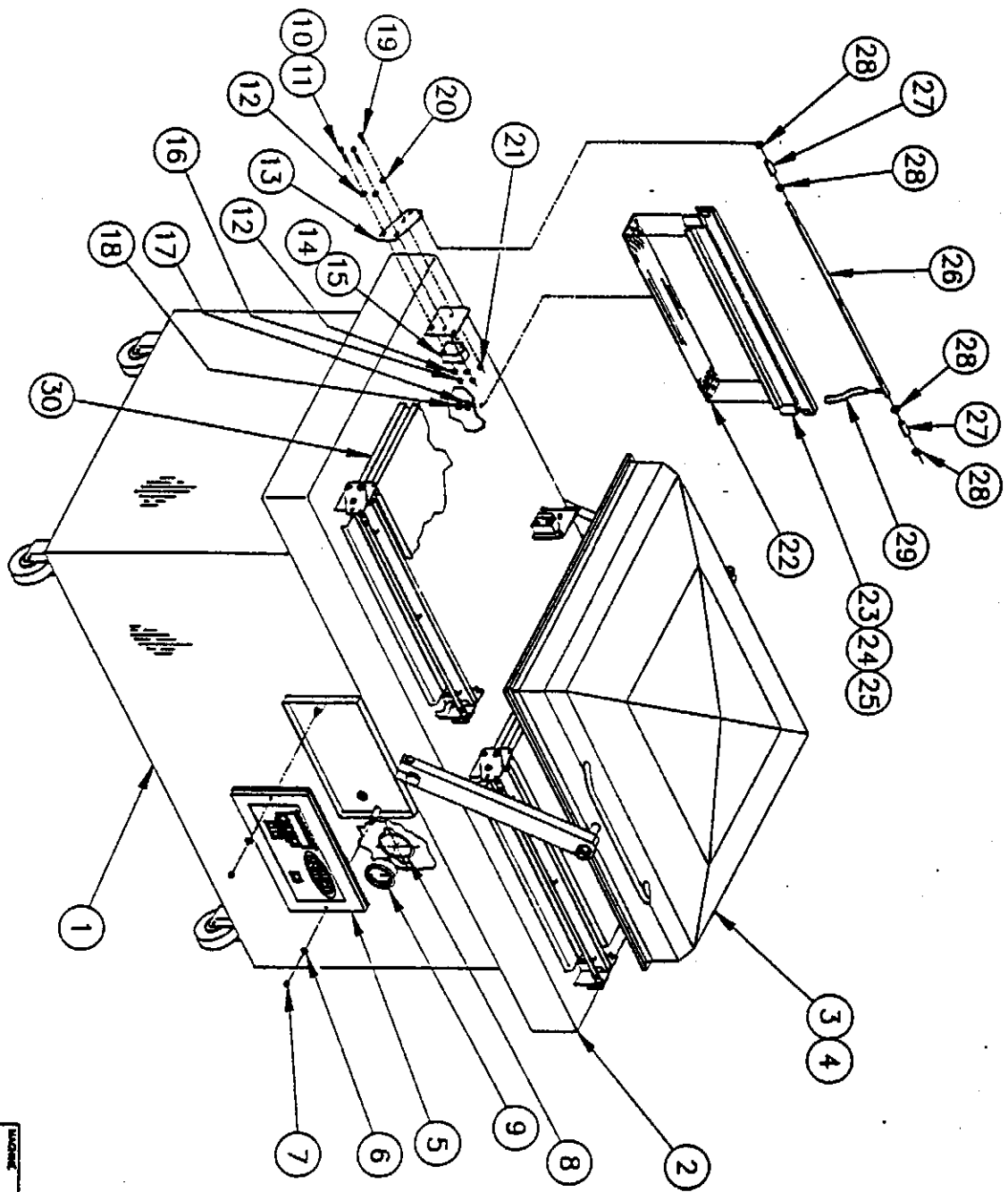




MECHANICAL DRAWING







ITEM	QTY	DESCRIPTION	QTY
1	005--	BODY ASSEMBLY	1
2	005-0150	TABLE ASSEMBLY	1
3	005--	8" CHAMBER ASSEMBLY	1
4	005--	12" CHAMBER ASS'Y (OPTION)	1
5	005-0319	P.C. BOARD SUPPORT ASS'Y	1
6	051-0740	FLAT WASHER 1/4" S.S.	2
7	051-0591	ACORN NUT 1/4"-20 S.S.	2
8	114-W4140	VACUUM GAGE FIXATION RING	1
9	114-VG4004	VACUUM GAGE	1
10	051-0250	HEX BOLT 1/4"-20 x 1 1/2" S.S.	16
11	051-0255	HEX BOLT 1/4"-20x1 3/4" S.S. (OPT.)	16
12	051-0740	FLAT WASHER 1/4" S.S.	32
13	005-0326	GAS INJ BAR SUPP ASS'Y (OPT.)	8
14	002-0326	LEFT SEAL BAR GUIDE BLOCK	4
15	002-0327	RIGHT SEAL BAR GUIDE BLOCK	4
16	051-0581	LOCK-NUT 1/4"-20 S.S./HT/COI	16
17	051-0780	FLAT WASHER 3/8" S.S.	4
18	051-0620	HEX NUT 3/8"-16 S.S.	4
19	051-0190	HEX BOLT 1/4"-20x 3/4" S.S. (OPT.)	8
20	051-0740	FLAT WASHER 1/4" S.S. (OPT.)	8
21	051-0580	HEX NUT 1/4"-20 S.S. (OPT.)	8
22	005-0320	BELLOWS ASSEMBLY	4
23	005-0152	SEAL BAR ASSEMBLY	4
24	005-0153	BAG CUT SEAL BAR ASS'Y (OPT.)	4
25	005-0370	TOP & BOTTOM BAR ASS'Y (OPT.)	4
26	009-0040	GAS INJECTION BAR (OPTION)	4
27	008-0295	GAS INJ. COIN. TUBE (OPTION)	8
28	105-C-133	COLLARS (OPTION)	16
29	179-0388	TUBE (OPTION)	4
30	005-0322	FILLER PLATE ASSEMBLY	4

MACHINE 600A

PRICE MACHINE ASSEMBLY FRONT VIEW

QTY 1

DATE 05-07-70

BY J

REV. 1

DESIGNER NE PAS MESURER N.T.S.

DATE 05-07-70

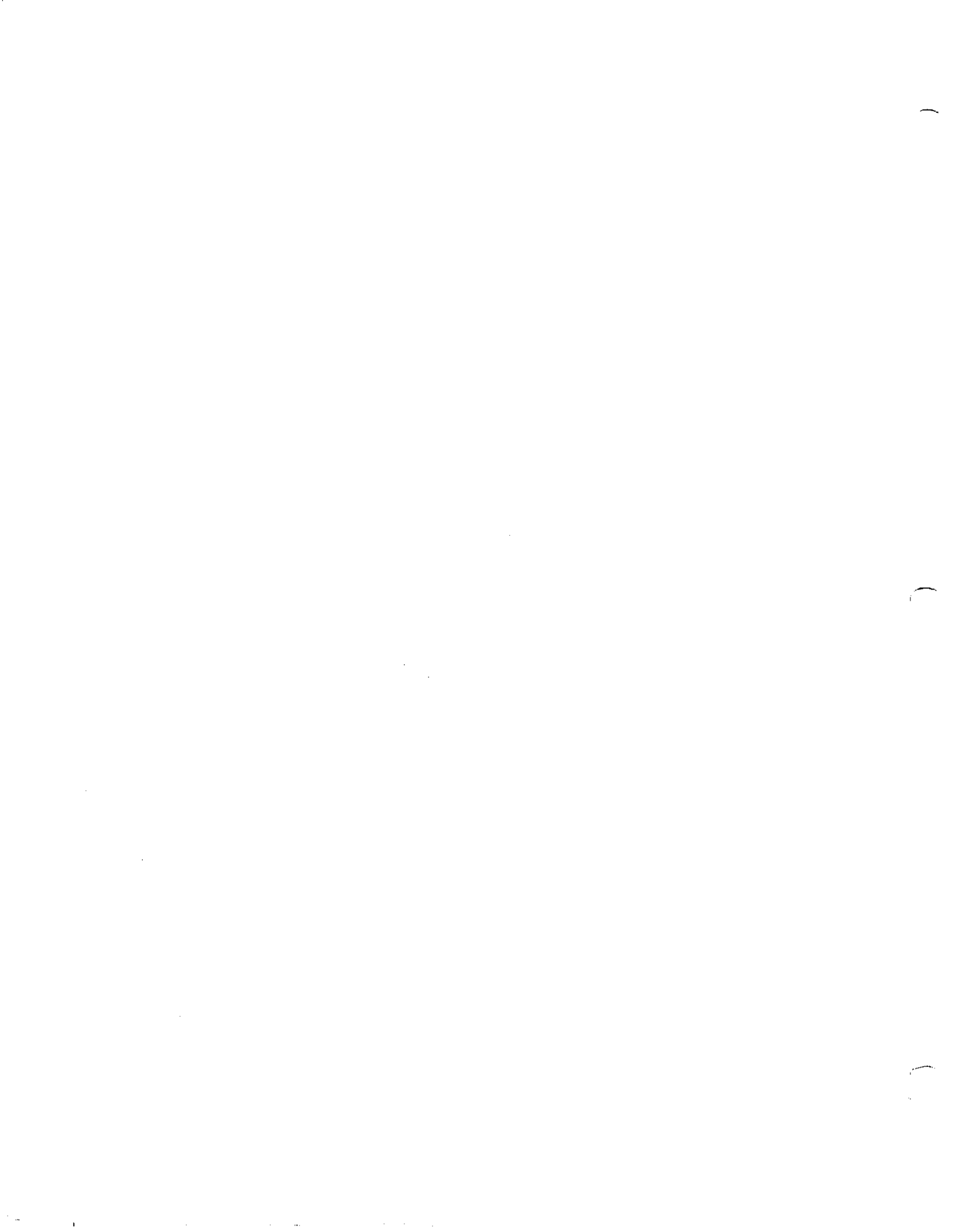
ST-CERAMIC DE CANADA

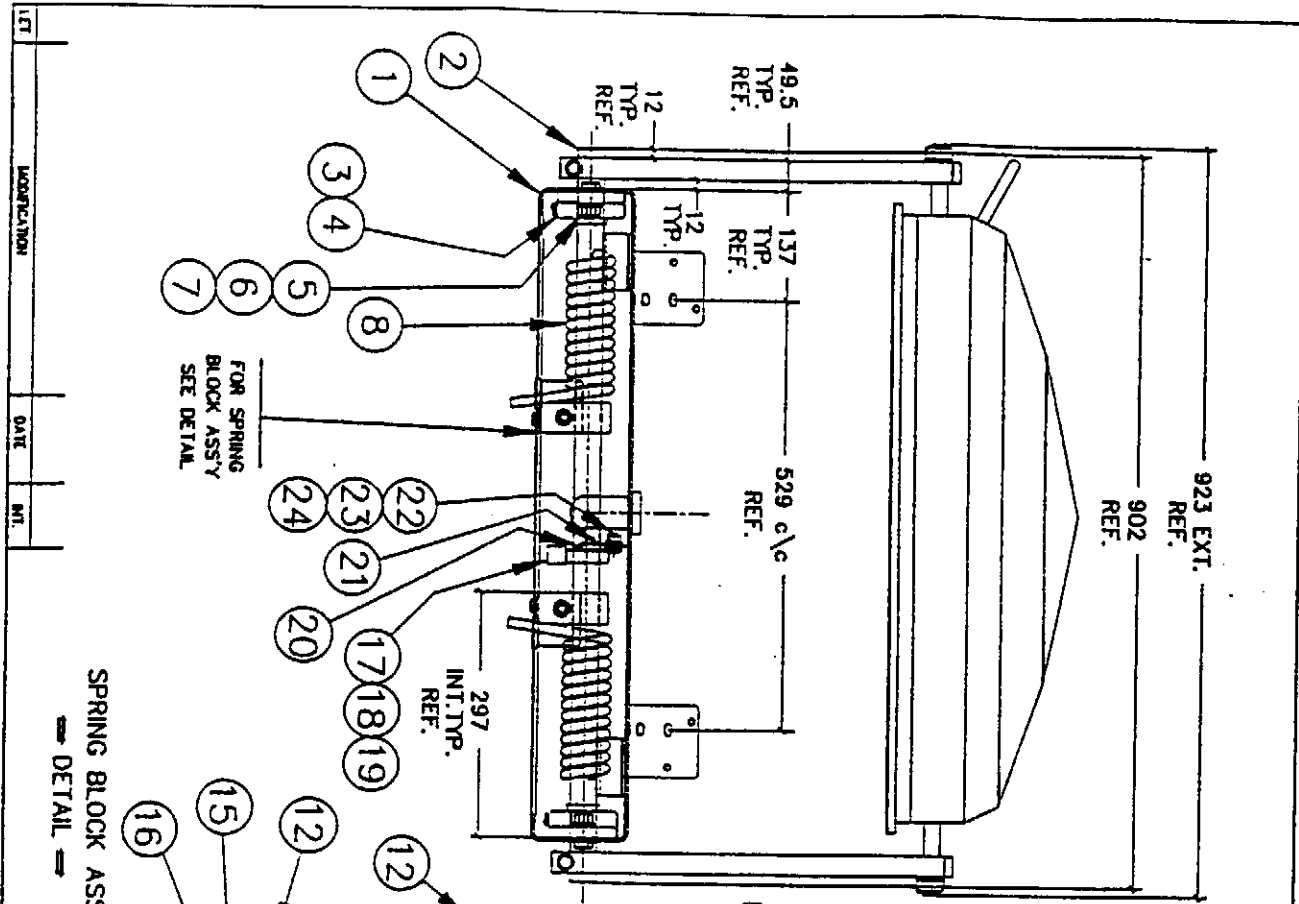
QUEBEC CANADA

SIPROMAC

005-0324

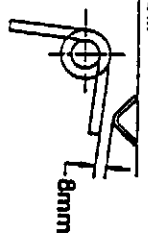
1005-0324





SPRING ADJUSTMENT PRODEDURE

- A-- PLACE COVER UP(ARU VERTICAL) TO FREE TENSION OF SPRINGS.
- B-- LOOSEN BOLTS (ITEMS #10, #13 & #16) ON THE SPRING SUPPORT PLATE ASSY (ITEM #9).
- C-- INSERT A SCREWDRIVER IN SLOT OF ITEM #12 AND PAY OPEN UNTIL BLOCK IS FREE ON CENTRAL SHAFT.(SEE NOTE)
- D-- TURN SPRING/BLOCK ASSEMBLY TO OBTAIN A SPACE APPROX. 8mm (5/16") AS SHOWN BELOW.

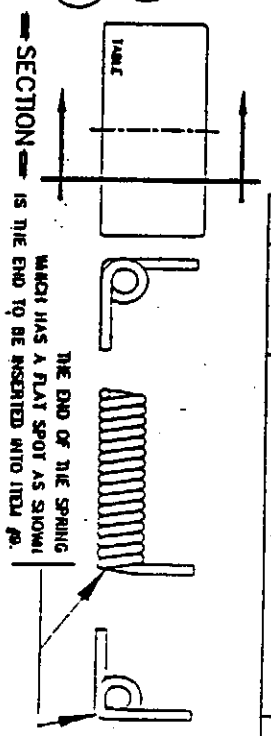
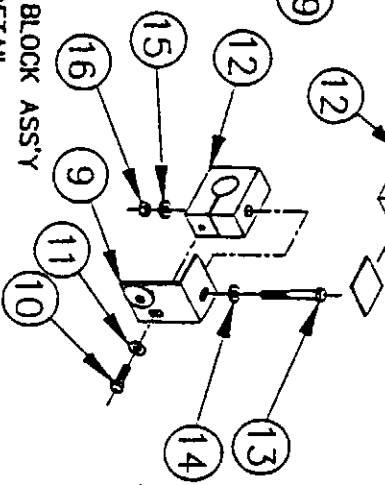


- E-- RETIGHTEN BOLTS ON SPRING SUPPORT PLATE ASSY (ITEMS #10, #13 & #16)

NOTE: IF NECESSARY ONLY SEE C BEFORE ATTEMPTING.

TO LOOSEN BLOCK (ITEM #12) ON SHAFT, REMOVE ITEMS #10, #13 & #16, INSERT A PLATE (APPROX. 2.5mm THICK.) INTO THE SLOT & USE A 1/2"-13 BOLT THREAD INTO BLOCK & TIGHTEN AGAINST PLATE TO OPEN BLOCK.

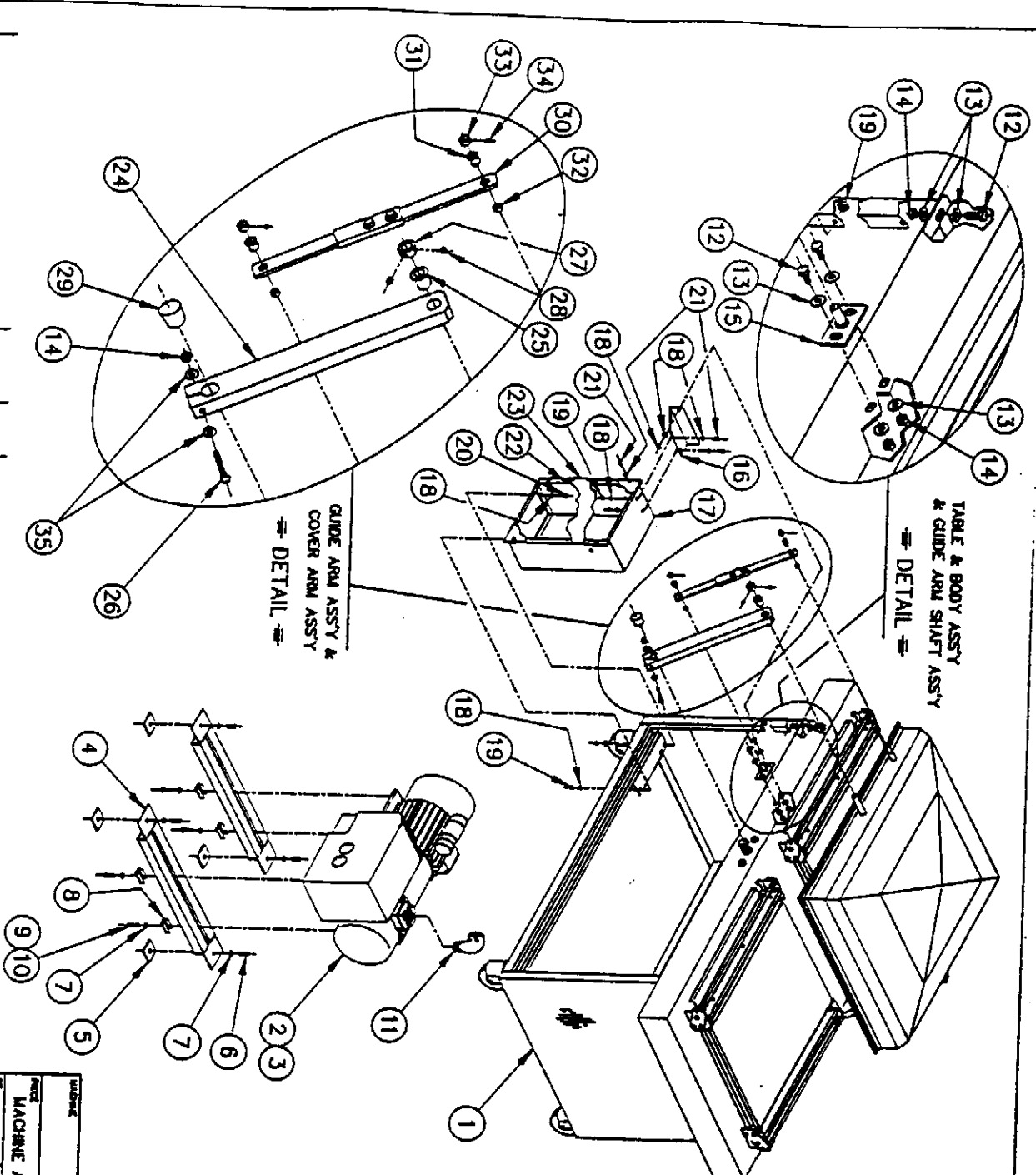
SPRING BLOCK ASSY DETAIL



ITEM	QTY	DESCRIPTION	QTY
1	1	TABLE ASSEMBLY	1
2	1	CENTRAL SHAFT	1
3	2	PILLOW BLOCK	2
4	2	GREASE FITTING 90° 1/4" x 1/2" S.S.	2
5	4	HEX BOLT 1/2"-13 x 1 1/2" S.S.	4
6	4	HEX NUT 1/2"-13 S.S.	4
7	4	FLAT WASHER 1/2" S.S.	4
8	2	CENTRAL SHAFT SPRING	2
9	2	SUPPORT PLATE ASSEMBLY	2
10	2	HEX BOLT 5/16"-18 x 3/4" S.S.	2
11	2	FLAT WASHER 5/16" S.S.	2
12	2	SPRING BLOCK	2
13	2	HEX BOLT 3/8"-16 x 3" S.S.	2
14	2	FLAT WASHER 3/8" S.S.	2
15	2	FLAT WASHER (THICK) 3/8" S.S.	2
16	2	HEX NUT 3/8"-16 S.S.	2
17	1	MICRO-SWITCH COLLAR	1
18	1	SET SCREW 3/8"-16 x 3/8" S.S.	1
19	1	SET SCREW 5/16"-18 x 3/8" S.S.	1
20	2	MICRO-SWITCH	2
21	2	MICRO-SWITCH FIXATION PLATE	2
22	2	HEX BOLT 1/4"-20 x 1/2" S.S.	2
23	1	FLAT WASHER 1/4" S.S.	1
24	2	HEX NUT 1/4"-20 S.S.	2

600A
CENTRAL SHAFT ASSEMBLY
SIPROMAC
1004-0122



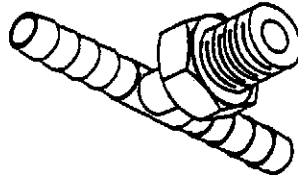
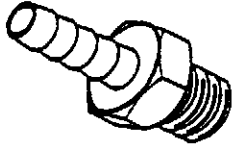


QTY	ITEM #	DESCRIPTION
1	005-0324	MACHINE ASSEMBLY FRONT VIEW
1	125-880100	PUMP 100 U3
1	125-880100	PUMP 160 U3 (OPTION)
1	005-0104	PUMP SUPPORT ASSEMBLY
2	005-0088	PUMP SUPPORT PLATE ASSEMBLY
4	051-0350	HEX. BOLT 3/8"-16 x 3/4" S.S.
4	051-0780	FLAT WASHER 3/8" S.S.
9	001-0199	SUPPORT
1	052-4220	HEX. BOLT 1/4" x 30 ZINC
1	052-4240	HEX. BOLT M10 x 30 ZINC (OPT 160U3)
1	005-0388	BELLOWS CONNECTOR ELBOW ASSY
1	051-0350	HEX. BOLT 3/8"-16 x 3/4" S.S.
8	051-0780	FLAT WASHER 3/8" S.S.
16	051-0820	HEX. NUT 3/8"-16 S.S.
10	005-0317	GUIDE ARM SHAFT ASSEMBLY
1	001-1384	EFT/ELECTRICAL BOX UPPER SUPPORT
1	005-0035	ELECTRICAL BOX ASSEMBLY
13	051-0740	FLAT WASHER 1/4" S.S.
13	051-0580	HEX. NUT 1/4"-20 S.S.
5	051-0190	HEX. BOLT 1/4"-20 x 3/4" S.S.
2	051-0180	HEX. BOLT 1/4"-20 x 1/2" S.S.
7	178-0004	SELF ADHESIVE SPONGE NEOPRENE
1	001-0137	ELECTRICAL BOX COVER
2	002-0316	COVER ARM
2	051-0420	BUSHING
2	002-0380	HEX. BOLT 3/8"-16 x 3" S.S.
2	051-0178	SET SCREW COLLAR
2	9-1.25	SET SCREW 1/4"-20 x 5/16" S.S.
2	005-0321	CENTRAL SHAFT END CAP
1		GUIDE ARM ASSEMBLY
2		BUSHING
2		SPACERS
2		SET SCREW COLLAR
2	051-0178	SET SCREW 1/4"-20 x 5/16" S.S.
2	051-0783	FLAT WASHER 3/8" (THICK) S.S.

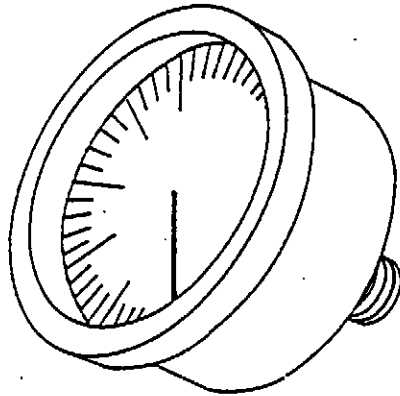
MODEL NO. 600A		DATE	WIT.
MACHINE ASSEMBLY REAR VIEW		DATE	WIT.
NE PAS MESURER / N.T.S.		DATE	WIT.
SI-CANADA DE CHARLEVOIX		DATE	WIT.
QUÉBEC CANADA		DATE	WIT.
005-0325		DATE	WIT.

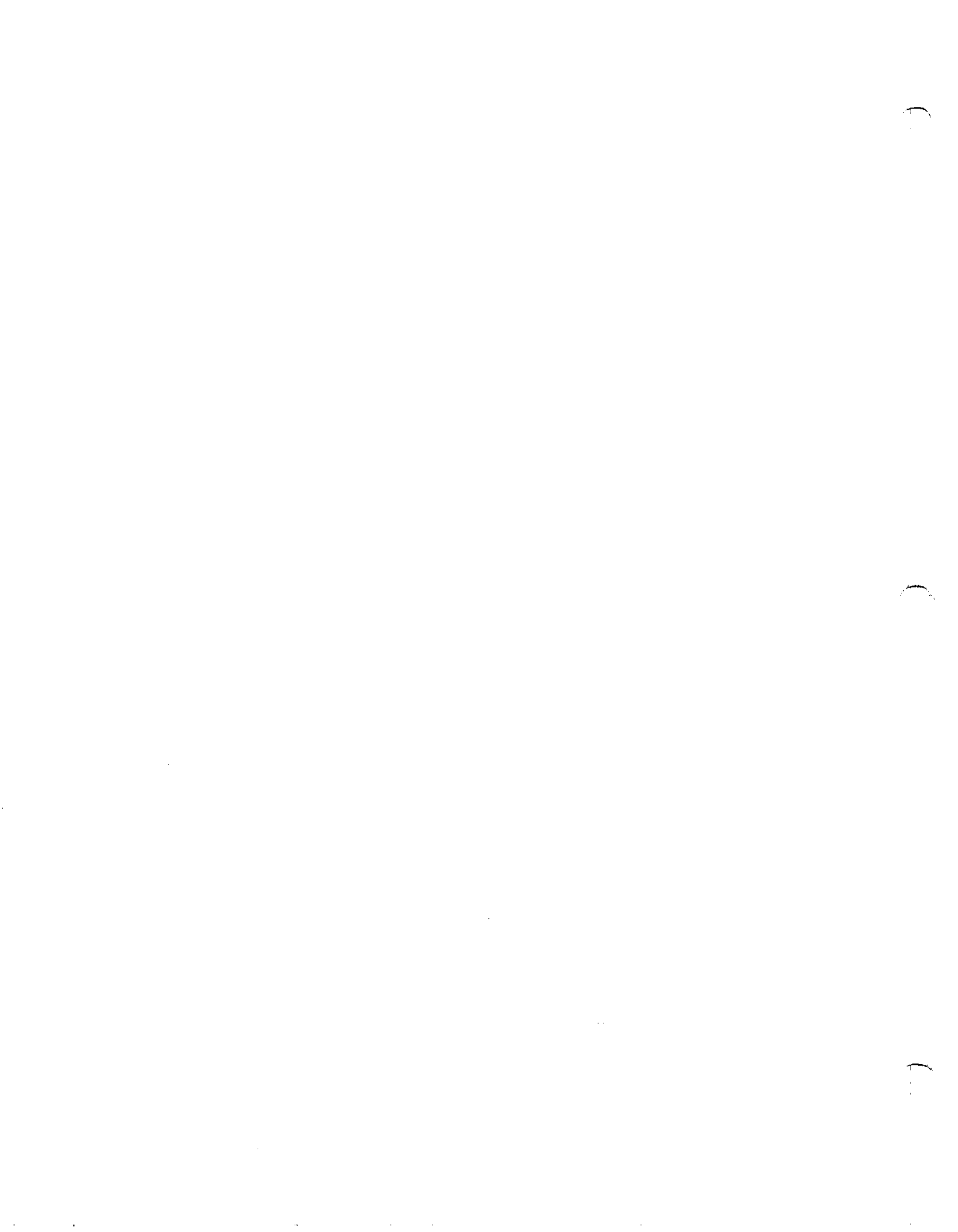
1005104225





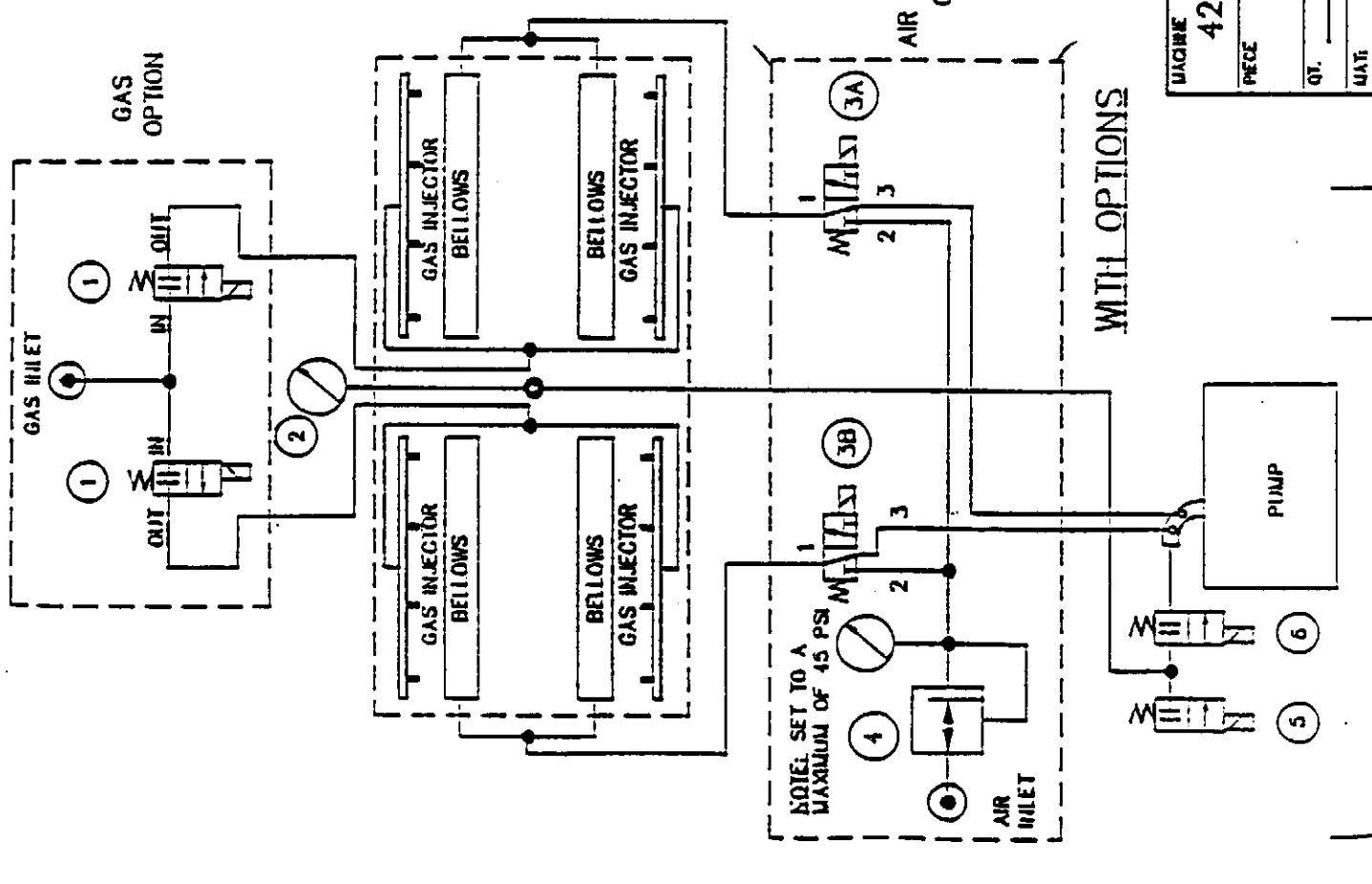
PNEUMATIC DRAWING





ITEM	# PIECE	DESCRIPTION	QT.
1	106-8262G22	GAS VALVE	2
2		VACUUMETER	1
3A	106-8320G176	BELLOWS VALVE	1
3B	106-8320G176	BELLOWS VALVE	1
4		PRESSURE REGULATOR	1
5	106-8210G95	ATMOSPHERE VALVE FOR 420A	1
	106-8210G95	ATMOSPHERE VALVE FOR 600A, 620A, 640A, 660A & 700A	
	106-8215B60	ATMOSPHERE VALVE FOR 800A & 820A; 160 μ ³ AND 250 μ ³	
	106-8215B60	ATMOSPHERE VALVE FOR 650A & 700A	
	106-8210G95	VACUUM VALVE FOR 420A	
6	106-8215B60	VACUUM VALVE FOR 600A & 620A	1
	106-8215B60	VACUUM VALVE FOR 650A & 700A	
	106-8215B80	OPTION	

*: OPTION



MACHINE
420A, 600A, 620A & 650A
 PNEUMATIC

METRIC TOLERANCE	± .05	FRACTIONAL TOLERANCE	± .015
± .05	± .005	± .005	± .005
± .005	± .005	± .005	± .005
± .0005	± .0005	± .0005	± .0005
ANGLE ± 1°			

QT. _____

DATE 94-03-03

NE PAS MESURER / N.T.S.

DATE 97-03-04

APP. / M

ST-GERMAIN DE GRANBRIAN
 QUEBEC CANADA

007-0019

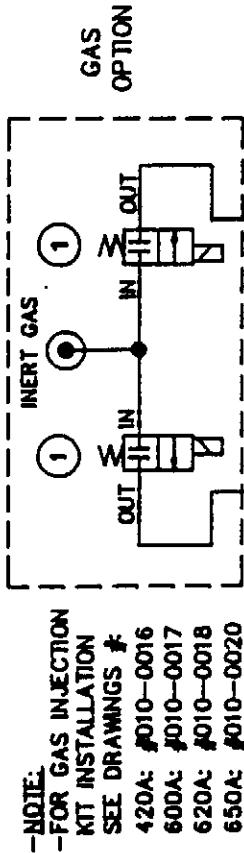
MODIFICATION

DATE

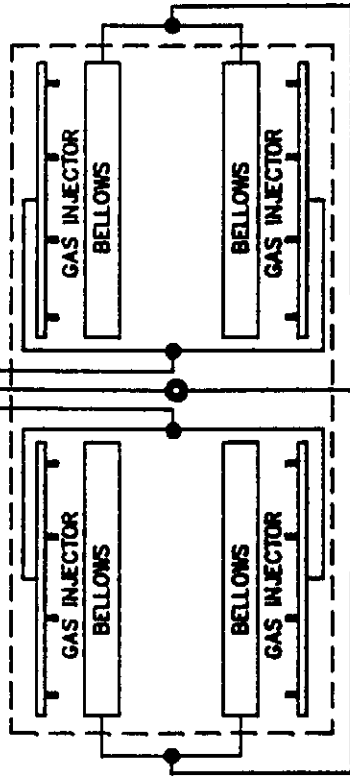
INIT.



007-0019



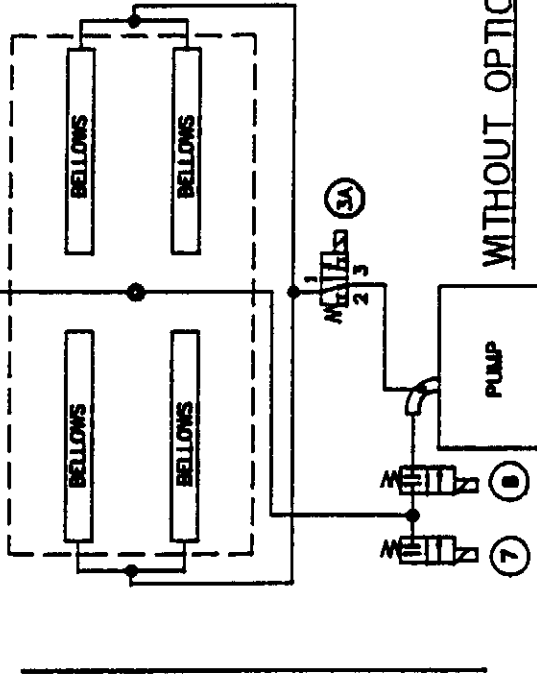
-NOTE-
 -FOR GAS INJECTION KIT INSTALLATION SEE DRAWINGS #:
 420A: #010-0016
 600A: #010-0017
 620A: #010-0018
 650A: #010-0020



NOTE: SET TO A MAXIMUM OF 45 PS

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

AIR REGULATOR OPTION



ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	2*
2	114-0280	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	
	106-0030	ATMOSPHERE VALVE FOR 600A, 603M ³ AND 100 M ³	1
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A; 160 M ³ AND 280 M ³	
	106-0050	ATMOSPHERE VALVE FOR 650A & 700A	
	106-0030	VACUUM VALVE FOR 420A	
	106-0050	VACUUM VALVE FOR 600A & 620A	
	106-0060	VACUUM VALVE FOR 650A & 700A	1

*: OPTION

MACHINE 420A, 600A, 620A & 650A

PART PNEUMATIC

ST-GERMAIN DE GRANTHAM QUEBEC CANADA

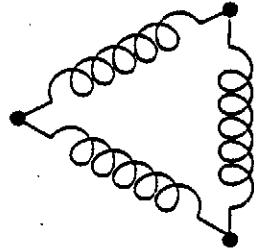
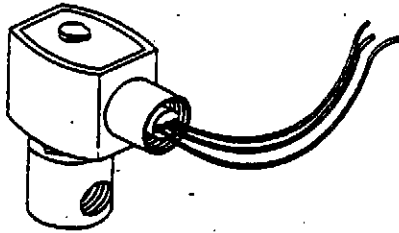
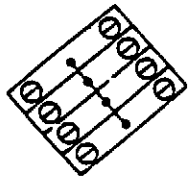
ITEM _____ **SCALE** _____ **QT.** 1

APP. _____ **DATE** 97-03-11 **NO.** 007-0019

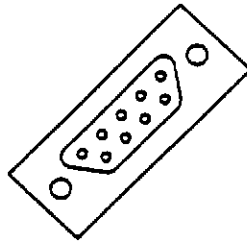
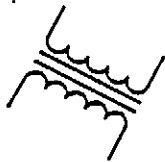
M.L. M.LAVIGNE **DATE** 97-03-11

LET. _____ **MODIFICATION** _____





ELECTRICAL DRAWING





ITEM / PIECE

1006-0029

DESCRIPTION

QT.

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

COLOR CODE

- ① BLACK : OUTPUT TO ATMOSPHERE VALVE
- ② WHITE : OUTPUT TO SEALING CONTACTOR
- ③ GREEN : OUTPUT TO GAS VALVE
- ④ RED : CONTACT OF PC BOARD RELAY

JUMP
SEE NOTE

- ⑤ BLACK : CONTACT OF PC BOARD RELAY
ACTIVATES WHEN MACHINE IS ON
- ⑥ YELLOW : INPUT +9 VOLTS
- ⑦ ----- : JUMPED WITH ⑥

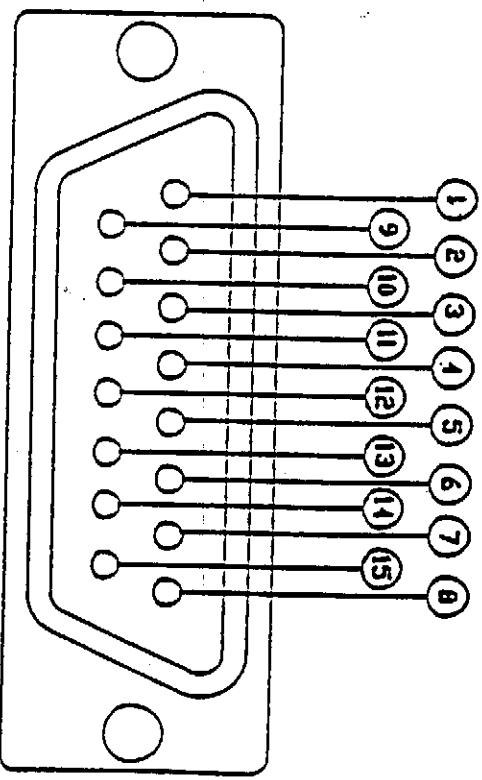
PC BOARD
RELAY

COVER
SWITCH

- ⑧ WHITE : TO COVER SWITCH
- ⑩ RED : OUTPUT TO VACUUM VALVE
OR CONTACTOR MOTOR (350,450A OR 550A)
- 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



NOTE: -- JUMP ② ④ FOR VACUUM : 350 450A 550A ONLY
 -- THIS CONNECTOR PLUGS IN AT REAR OF P.C. BOARD

LET	MODIFICATION	DATE	HT.
-----	--------------	------	-----

MACHINE		VACUUMS	
"D" CONNECTOR DETAIL			
PIECE	QTY	SCALE	UNIT
NE PAS MESURER / N.T.S.		DESIGNER	
DATE 94-03-03		DATE 94-03-04	
SIPROMAC		ST-GERMAIN DE GRANTHIAU	
006-0		006-0	



ITEM # PIECE

1006-0029

DESCRIPTION

QT.

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

MC-30

COLOR CODE

① BLACK : OUTPUT TO ATMOSPHERE VALVE

② WHITE : OUTPUT TO SEALING CONTACTOR

③ ORANGE : OUTPUT TO GAZ VALVE

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

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

⑥ GREEN : INPUT 9 VAC

⑦ ----- : JUMPED WITH ⑥

⑧ BLUE : TO COVER SWITCH

⑨ ----- : NOT USED

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

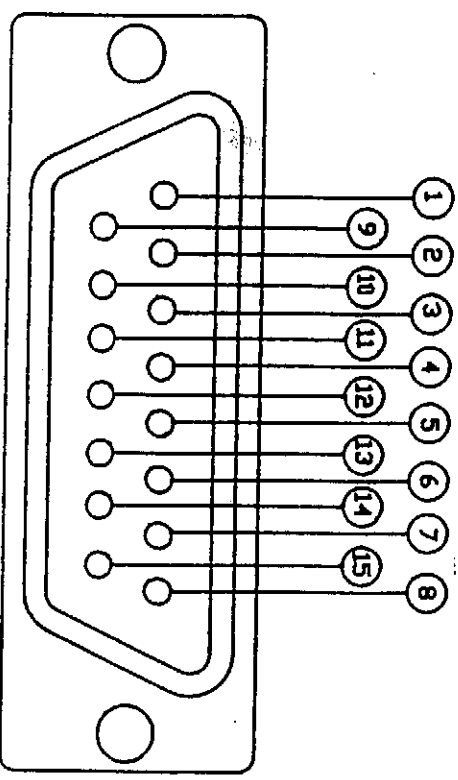
⑪ ORANGE/BLACK : OUTPUT TO SEALING SELENOID VALVE

⑫ RED : INPUT 24 VAC

⑬ GREEN/WHITE : INPUT 9 VAC

⑭ ----- : JUMPED WITH ⑬

⑮ BLUE/WHITE : TO COVER SWITCH



WIRE SIDE VIEW

NOTE: - JUMP ② ④ FOR VACUUM : 250 350 450A 550A ONLY
 - THIS CONNECTOR PLUGS IN AT REAR OF P.C. BOARD

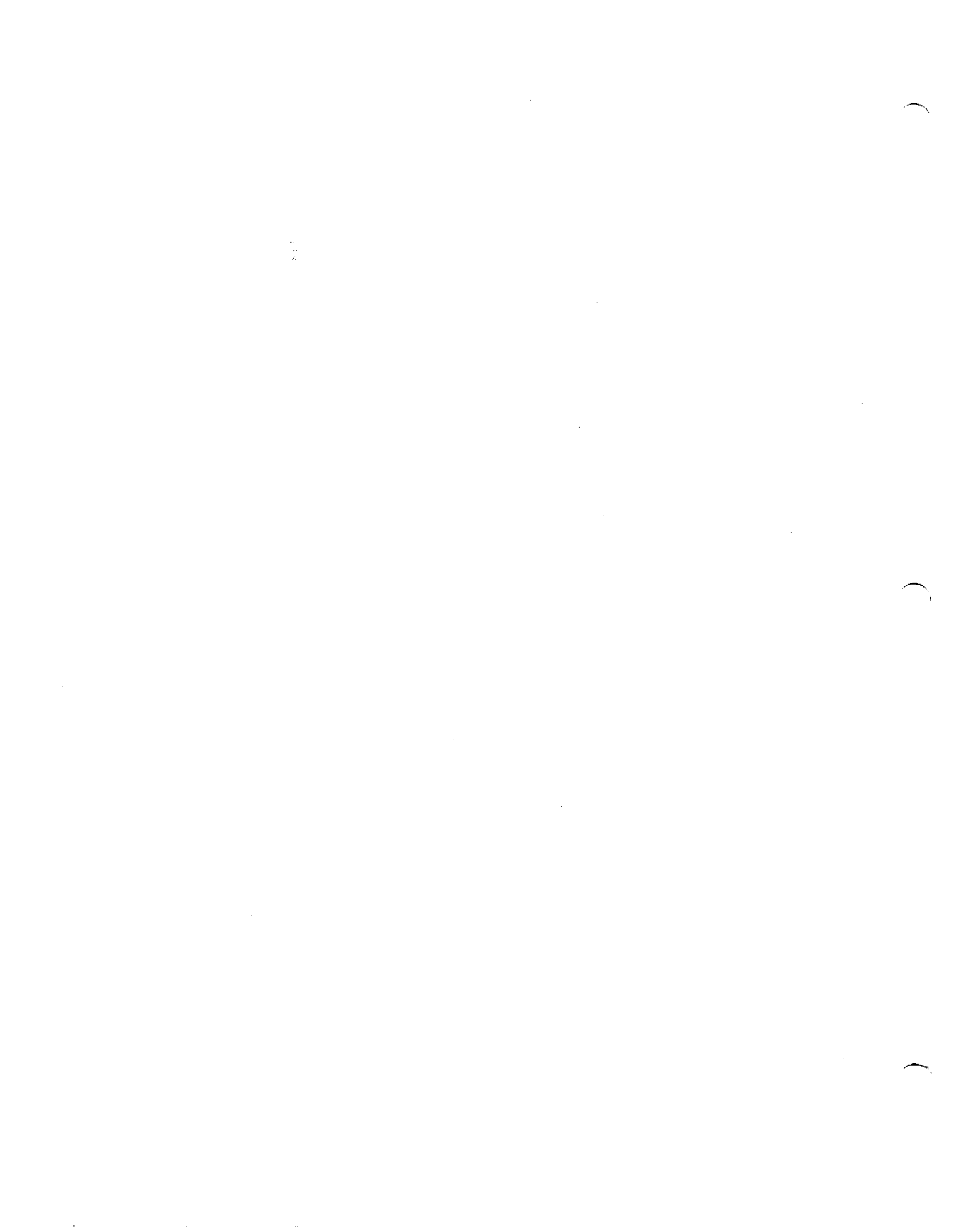
JUMP SEE NOTE

PC BOARD RELAY

COVER SWITCH

LET.	REDESSINE	MODIFICATION	DATE	DL	INT.
			05-01-31		

MACHINE		VACUUMS	
PREP	"D" CONNECTOR DETAIL	DATE	BY
EQ	NE PAS MESURER / N.T.S.	DATE	BY
DATE	06-11-07	DATE	
006-0029			



01/34

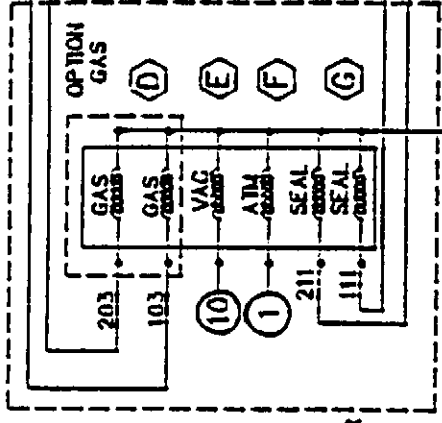
006-0067

ALL CIRCLED NUMBER WIRES
COME FROM "D" CONNECTOR (P.C. BOARD)
(SEE REF. DRAWING #006-0029)

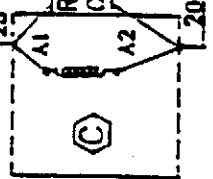
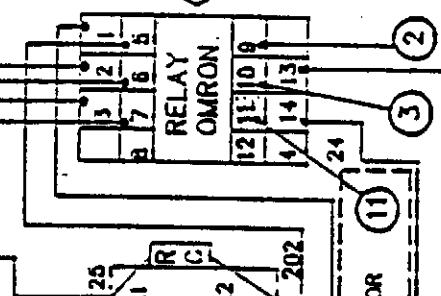
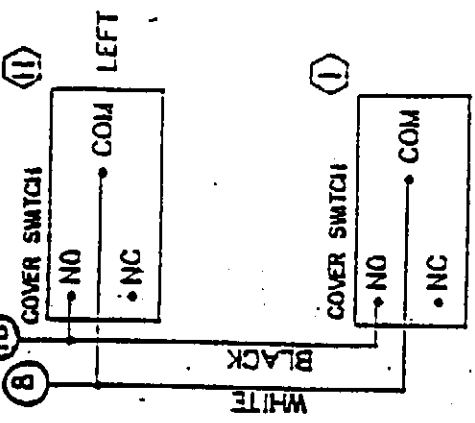
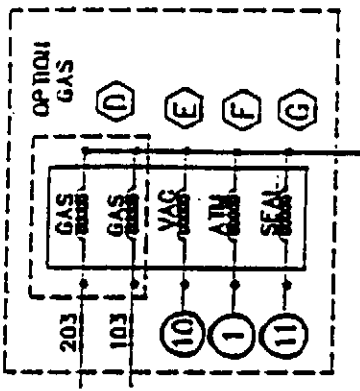
FUSE F3	GMA-3
FUSE F4	GMA-5



AIR
REGULATOR
OPTION



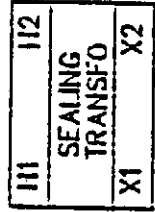
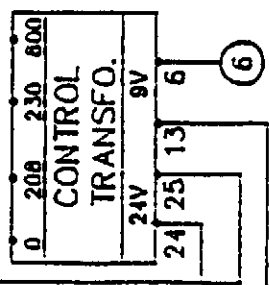
WITHOUT
REGULATOR
OPTION



COLOR CODE SECONDARY(VAC)
24V RED(WIRE #24 & #25)
9V GREEN(WIRE #8 & #9)

SECONDARY CONTROL
TRANSFO. LIST

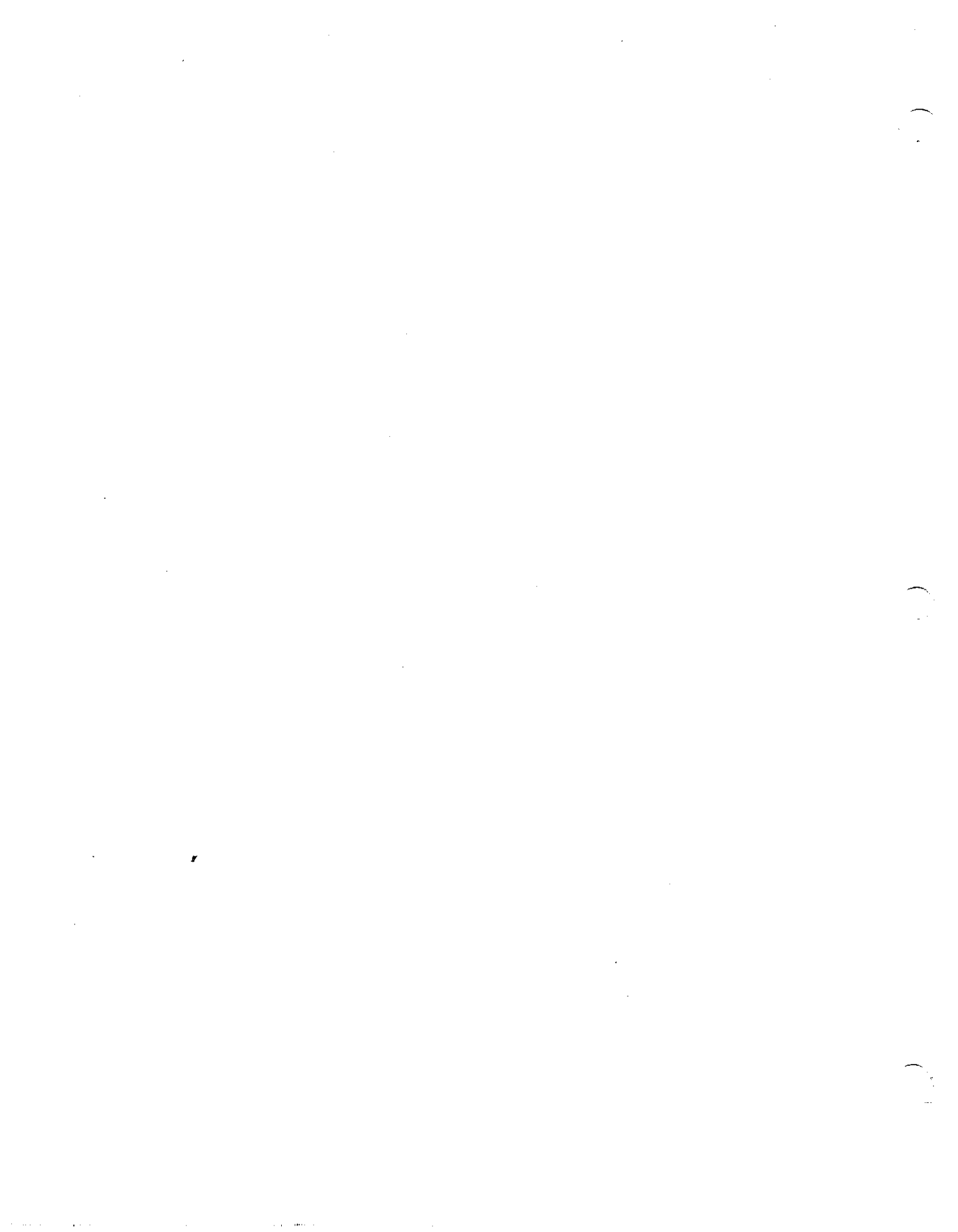
- 029-80307C
- 029-A1105
- 029-91134
- 029-A1105A
- 029-C1154



FOR PART NUMBERS FOR LETTERS A THRU L SEE FOLLOWING LIST

<p>MAQUINE 420A, 600A & 620A</p>		<p>PIECI TOLERANCE TO DIMANCE 0 ± .015 0.00 ± .045 0.00 ± .0005</p>	<p>DATE 94-03-03</p>
<p>PIECE ELECT. WIRING LOW-VOLTAGE</p>		<p>PIECI TOLERANCE TO DIMANCE 0 ± .015 0.00 ± .045 0.00 ± .0005</p>	<p>DATE 94-03-04</p>
<p>OT. _____</p>	<p>EQIL SCALE _____</p>	<p>NE PAS MESURER / N.T.S.</p>	<p>DATE 94-03-04</p>
<p>MAJ: _____</p>	<p>DESS. M.LAVAGNE</p>	<p>ST-GERMAIN DE GRANBRIAN QUEBEC CANADA</p>	<p>006-0067</p>

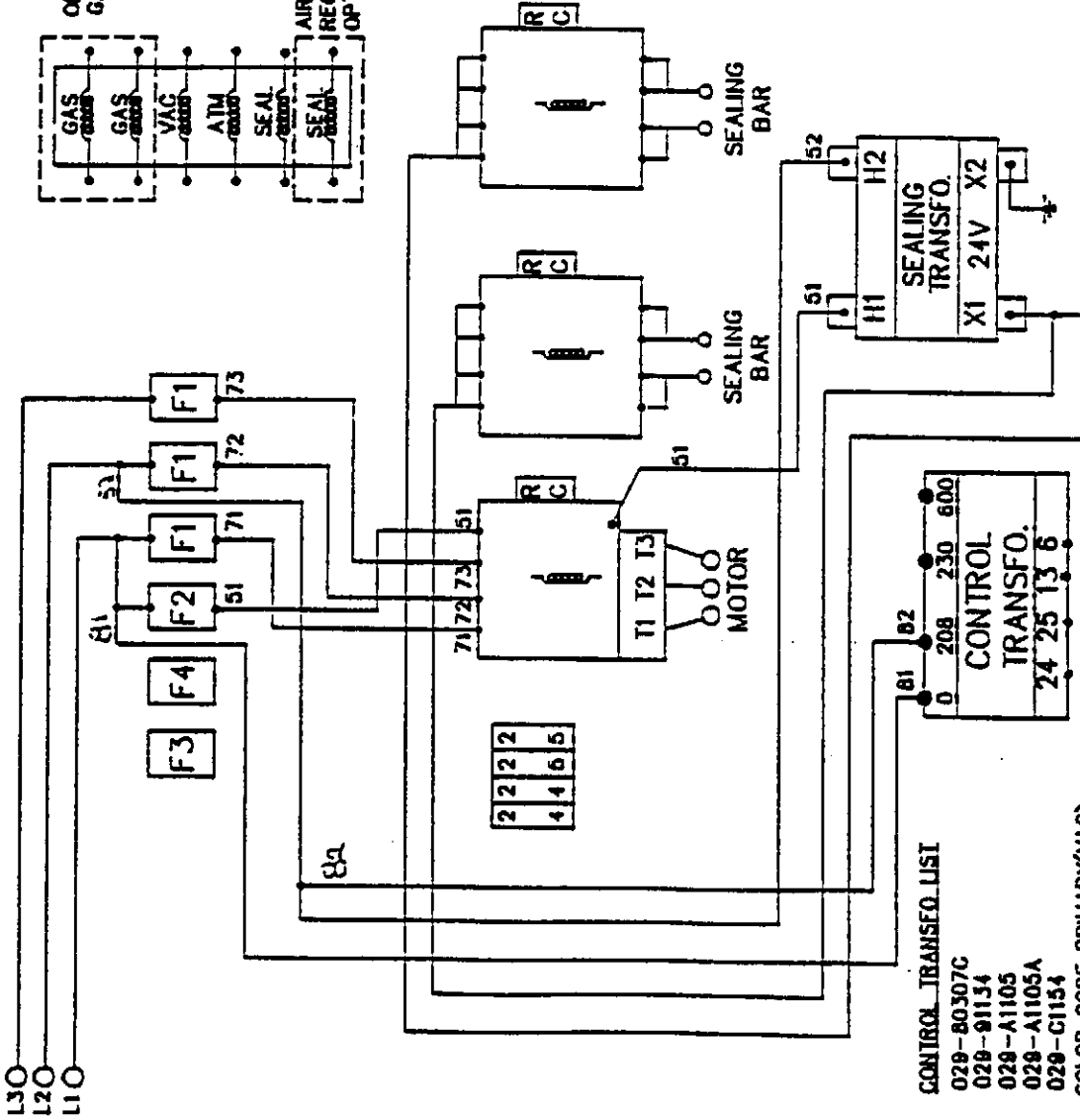
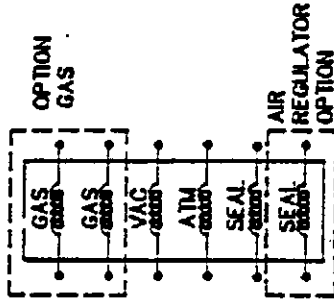
DET.	MODIFICATION	DATE	INT.



PUMP

MOTOR (HP)	VOLT tph	FUSE F1
3	230-1	MEN-25
3	230-3	MEN-20
3	575-3	MCL-10
5	230-1	MEN-30
5	230-3	MEN-25
5	675-3	MCL-15

OPTION	VOLTAGE	FUSE F2
TWIN SEAL	220	MEN-25
TWIN SEAL	380	KTK-25
TWIN SEAL	600	KTK-20
BAG CUT	220	MEN-25
BAG CUT	380	KTK-25
BAG CUT	600	KTK-20
TOP & BOTTOM SEAL	220	MEN-30
TOP & BOTTOM SEAL	380	KTK-30



RELAY	OMRON
-------	-------

• NO
• COM
• NC

• NO
• COM
• NC

• NO
• COM
• NC

CONTROL TRANSFO. LIST

- 029-80307C
- 029-81134
- 029-A1105
- 029-A1105A
- 029-C1154

COLOR CODE PRIMARY(YAG)

- WHITE 0V
 - BLACK 150V
 - GREY 208V
 - RED 230V
 - BROWN 380V
 - YELLOW 460-480V
 - BLUE 575-600V
- SECONDARY(YAG)
- RED 24V
 - GREEN 8V

0	220	380	460
CONTROL TRANSFO.			
24	25	13	6

H1	H2
SEALING TRANSFO.	
X1	X2
24V X2	

420A, 600A & 620A

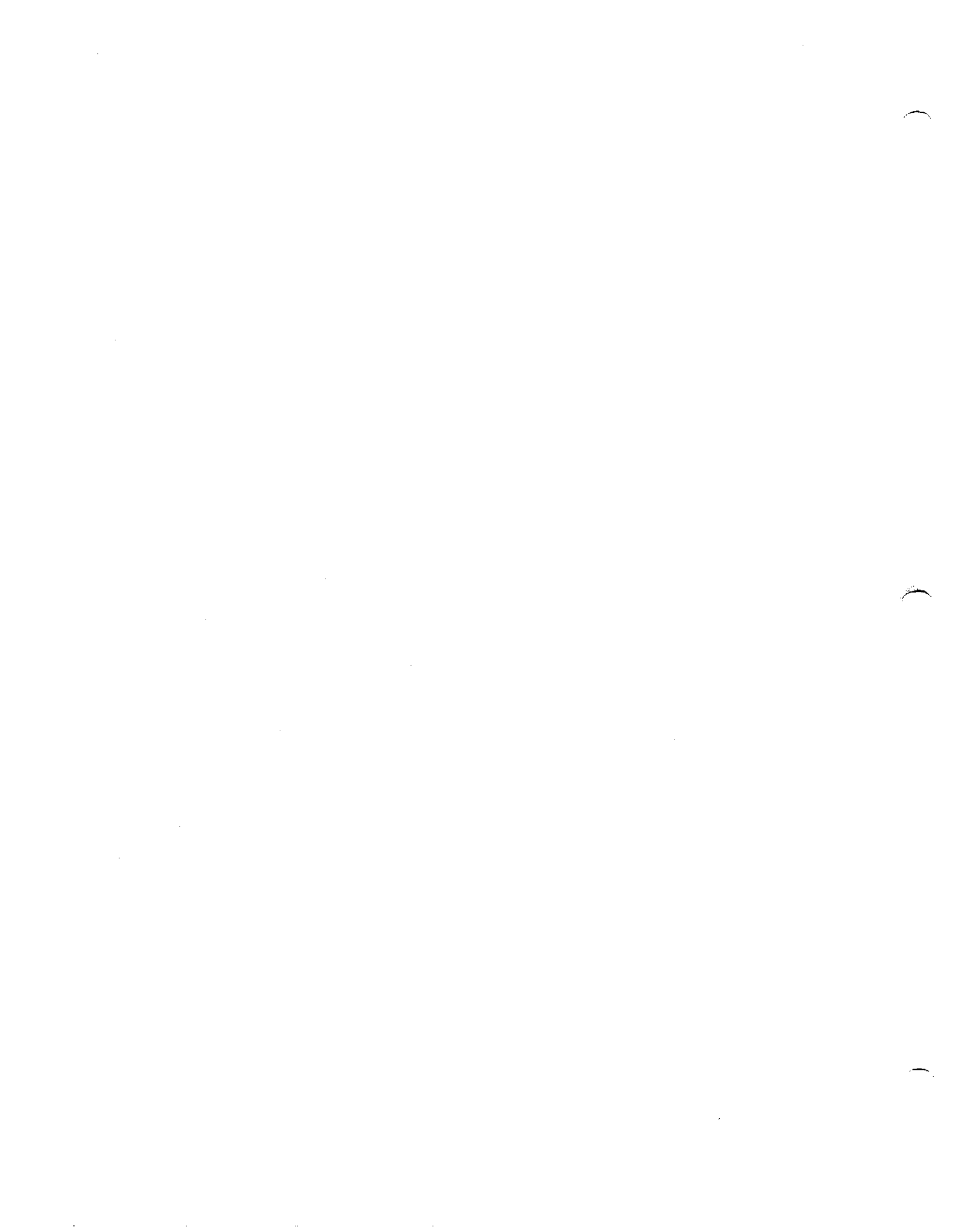
ELECT. WIRING HIGH VOLTAGE 3Ø

METRIC	TOL. GRANGE
0.1	0.016"
0.05	0.005"
0.025	0.0025"
0.0125	0.00125"
ANGLE ± 1°	

SIPROMAC
SF-GERMAIN DE GRANTULIUM
QUEBEC CANADA

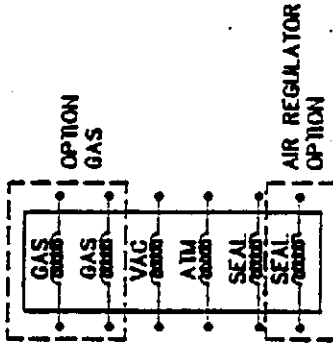
NE PAS MESURER / N.T.S.

DATE: 94-03-03
DATE: 91-03-04

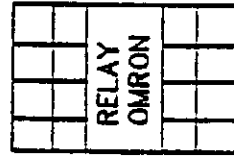


MOTOR (HP)	VOLT (PH)	FUSE F1
3	230-1	MEH-25
3	230-3	MEH-20
3	875-3	MOJ-10
5	230-1	MDH-30
6	230-3	MEH-25
6	875-3	MOJ-15

OPTION	VOLTAGE	FUSE F2
THIN SEAL	230	MEH-25
THIN SEAL	380	KTK-25
THIN SEAL	600	KTK-30
BAG CUT	230	MEH-25
BAG CUT	380	KTK-25
BAG CUT	600	KTK-30
TOP & BOTTOM SEAL	230	MEH-30
TOP & BOTTOM SEAL	380	KTK-30



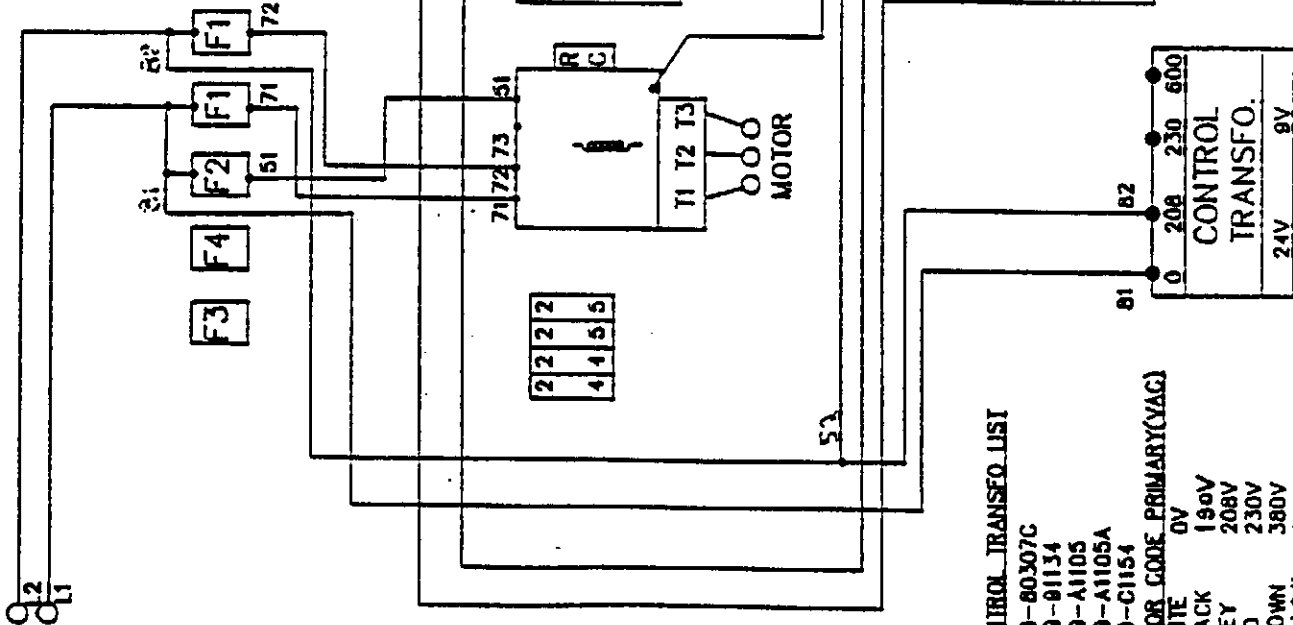
AIR REGULATOR
OPTION



• NO
• NC
• COM

• NO
• NC
• COM

• NO
• NC
• COM



CONTROL TRANSFO LIST

- 028-80307C
- 028-91134
- 028-A1105
- 028-A1105A
- 028-C1154

COLOR CODE PRIMARY(VAC)

- WHITE 0V
 - BLACK 190V
 - GREY 208V
 - RED 230V
 - BROWN 380V
 - YELLOW 460-480V
 - BLUE 575-600V
- SECONDARY(VAC)
- RED 24V
 - GREEN 9V

MACHINE 420A, 600A & 620A

PIECE ELECT. WIRING HIGH VOLTAGE 1#

QTY. _____ FOL. _____ SCALE _____

MAT: _____ NE PAS MESURER / N.T.S.

APP. *im* DATE 94-03-03

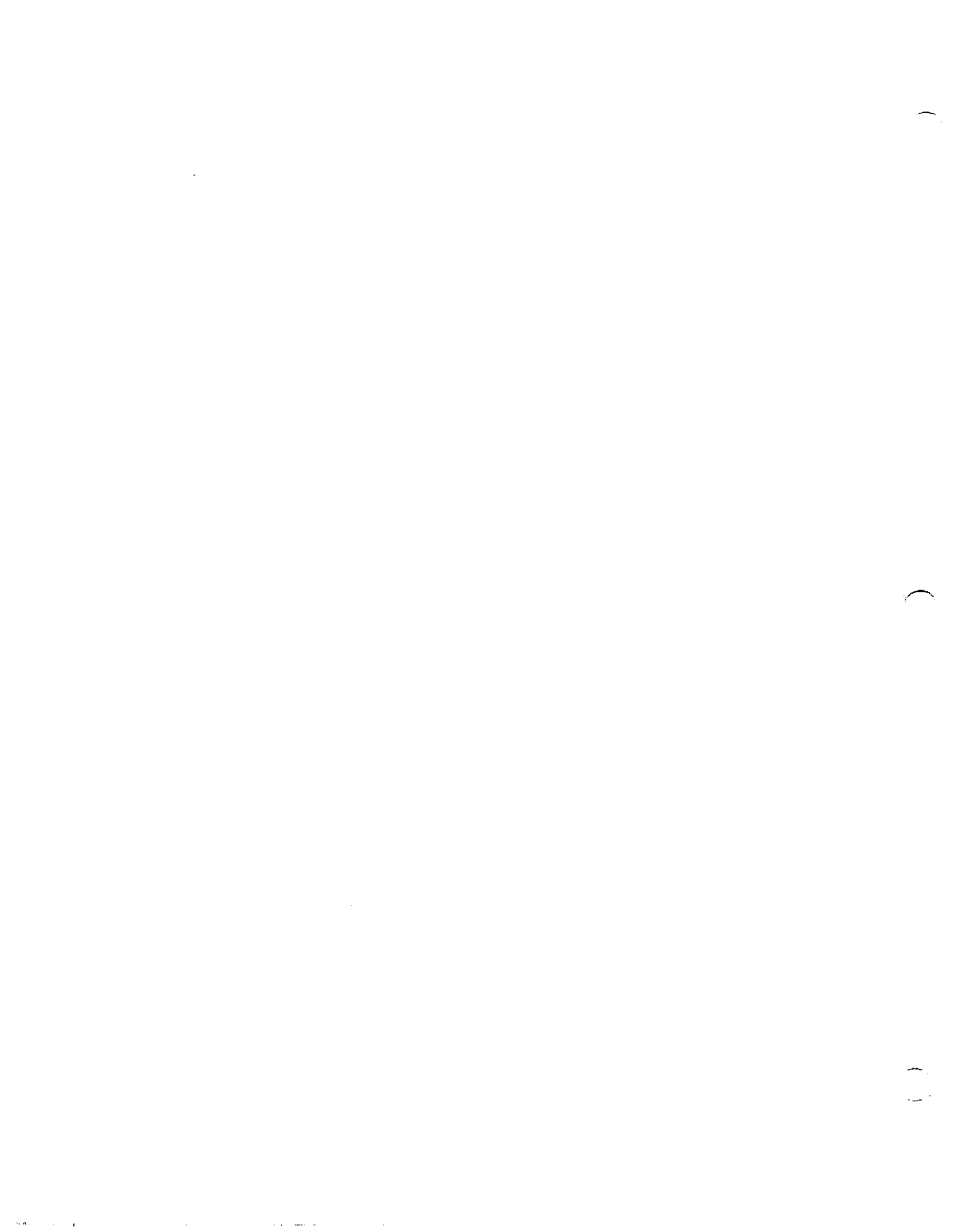
DATE 93-03-04

METRIC TOLERANCE	INCH TOLERANCE
0 ± .5	.0 ± .015"
0.00 ± .005	.00 ± .005"
.000 ± .0005	.000 ± .0005"
ANGLE ± 1'	

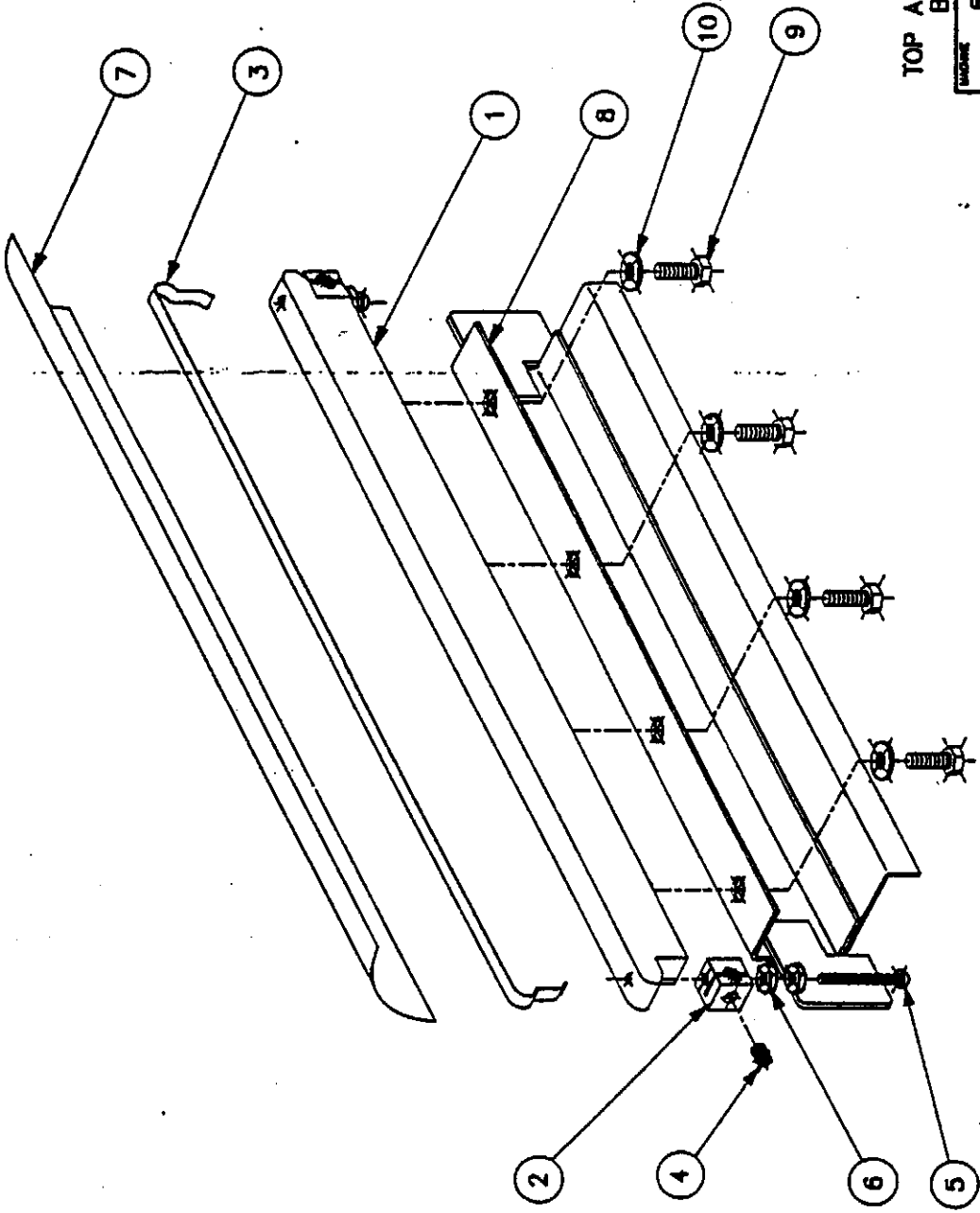
SIPROMAC

ST-GERMAIN DE GRANVILLE
QUEBEC CANADA

006-0068



ITEM	#	PIECE	DESCRIPTION	QTY
1	002-0314	SEAL BAR (TABLE)	2/1	
2	009-0028	CONNECTOR	4/8	
3	038-2500000	SEALING ELEMENT	2/1	
4	009-0178	HEX SOCKET SET SCREW 1/4" - 20 x 5/16 S.S.	4/8	
5	001-0142	ROUND HEAD BOLT #8-32 x 1 1/2" S.S.	4/8	
6	001-0650	HEX NUT #8-32 STAINLESS STEEL	2/1	
7	178-9100-35	SELF STICK REFLECTOR TAPE	2/1	
8	005-0181	SEAL BAR SUPPORT ASSEMBLY	2/1	
9	001-0180	HEX BOLT 1/4" - 20 x 3/4" S.S.	2/10	
10	001-0740	FLAT WASHER 1/4" STAINLESS STEEL	2/10	



OPTION →
 TOP AND BOTTOM SEALING OR
 BI-ACTIVE SEALING

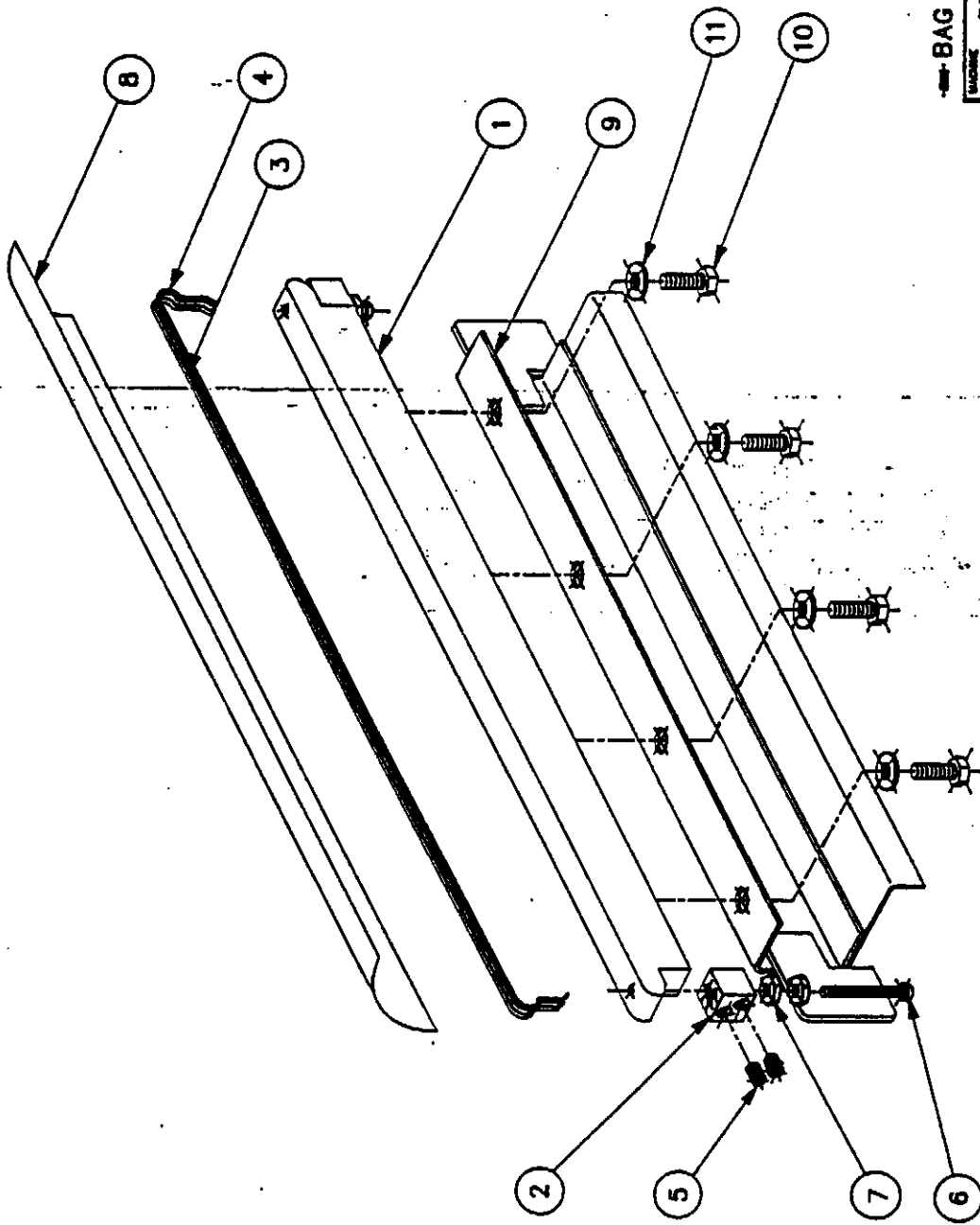
600A	4
550A	2
MACHINE	QTY

MACHINE: 550A & 600A
 SEAL BAR ASSEMBLY
 SIZE: 2/4
 DATE: 83-04-23
 DRAWN BY: [Signature]
 CHECKED BY: [Signature]
 APPROVED BY: [Signature]
 PARTS LIST: 83-04-23
 DATE: 83-04-23
 NAME: NE PAS MESURER / N.T.S.
 SIPROMAC
 ST-GERMAIN DE GRANTHAM
 QUEBEC CANADA
 005-0370

LET. _____
 MODIFICATION _____
 DATE _____
 INT. _____



ITEM	# PIECE	DESCRIPTION	QTY
1	002-0314	SEAL BAR (TABLE)	2/4
2	002-0031	CONNECTION	4/8
3	039-2602	SEALING ELEMENT	2/4
4	039728	CUTTING ELEMENT	2/4
5	051-0178	HEX SOCKET SET SCREW 1/4" - 20 x 3/8 S.S.	8/16
6	051-0142	ROUND HEAD SCREW #8-32 x 1 1/2" S.S.	4/8
7	051-0550	HEX NUT #8-32 STAINLESS STEEL	8/16
8	178-9100-55	SELF STICK REFLON TAPE	2/4
9	008-0181	SEAL BAR SUPPORT ASSEMBLY	2/4
10	051-0160	HEX BOLT 1/4" - 20 x 3/4" S.S.	8/16
11	051-0740	FLAT WASHER 1/4" STAINLESS STEEL	8/16



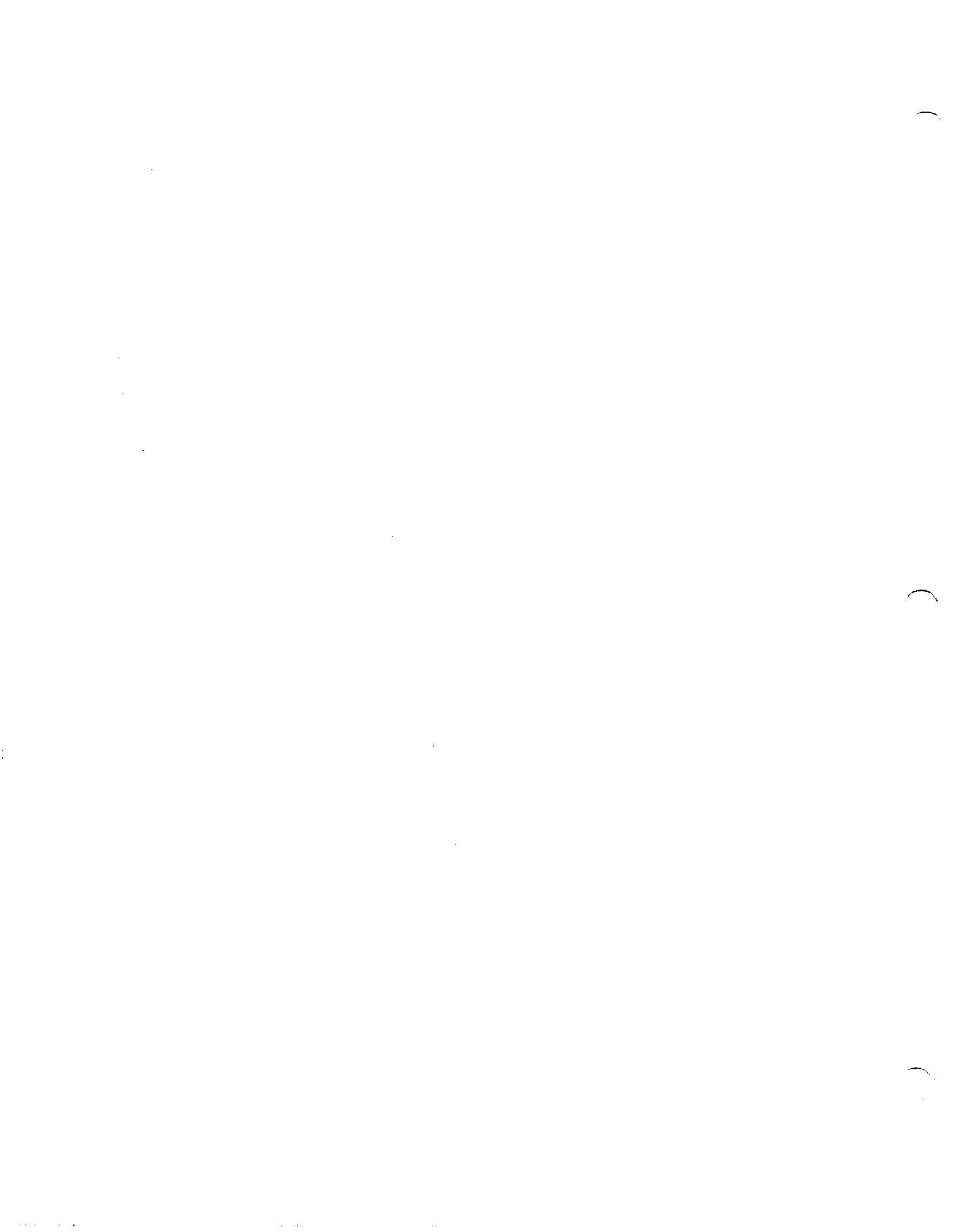
BAG CUT OPTION

600A	1
550A	2
MACHINE	QTY

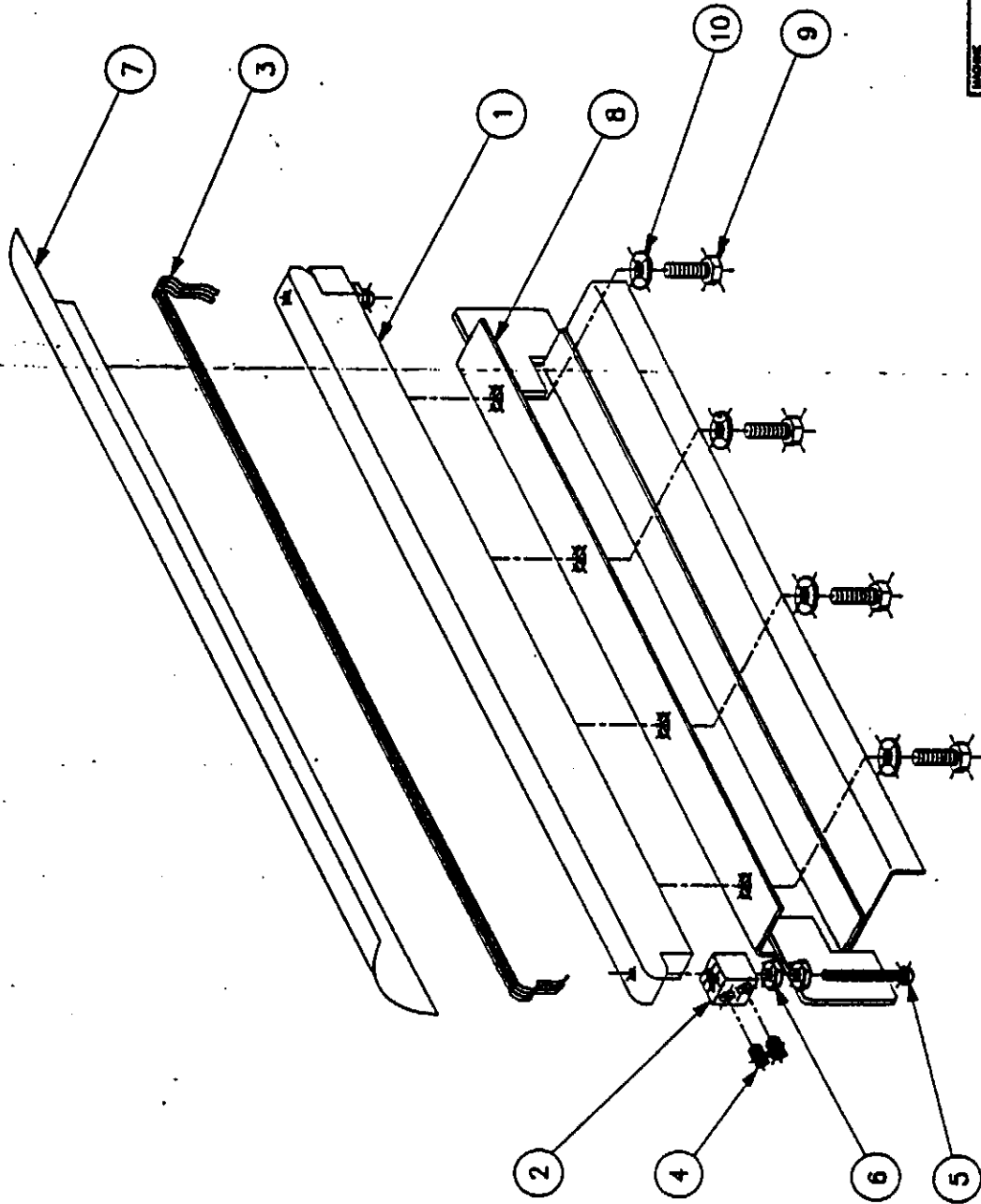
550A & 600A
 BAG CUT SEAL BAR ASS'Y
 2/4
 NE PAS MESURER / N.T.S.
 93-04-23
 005-0153

SIPROMAC
 ST-GERMAIN DE GRANBIAN
 ALBERG CANADA

LET.	MODIFICATION	DATE	INT.
------	--------------	------	------



ITEM #	QTY	DESCRIPTION	QTY
1	002-0314	SEAL BAR (TABLE)	2/1
2	002-003N	CONNECTOR	4/8
3	039-080018	SEALING ELEMENT	4/8
4	081-0178	HEX SOCKET SET SCREW 1/4" - 20 x 8/16 S.S.	8/16
5	081-0142	ROUND HEAD SCREW #8 - 32 x 1 1/2" S.S.	4/8
6	081-0850	HEX NUT #8 - 32 STAINLESS STEEL	8/16
7	178-8100-52	SELF STICK REPTON TAPE	2/1
8	005-0181	SEAL BAR SUPPORT ASSEMBLY	2/1
9	081-0180	HEX BOLT 1/4" - 20 x 3/4" S.S.	8/16
10	081-0710	FLAT WASHER 1/4" STAINLESS STEEL	8/16



600A	4
550A	2
MACHINE	QTY

MACHINE		550A & 600A	
PART		SEAL BAR ASSEMBLY (table model)	
REV.	DATE	REV.	DATE
2/4	1924K	1	NE PAS MESURER / N.T.S.
DRAWN		ILLUMONE	
DATE		03-04-23	
APP.		[Signature]	
MATERIALS		ST-GERMAIN DE GRANVILLE QUEBEC CANADA	
MATERIALS		SIPROMAC	
MATERIALS		005-0152	

LET.	MODIFICATION	DATE	INT.

