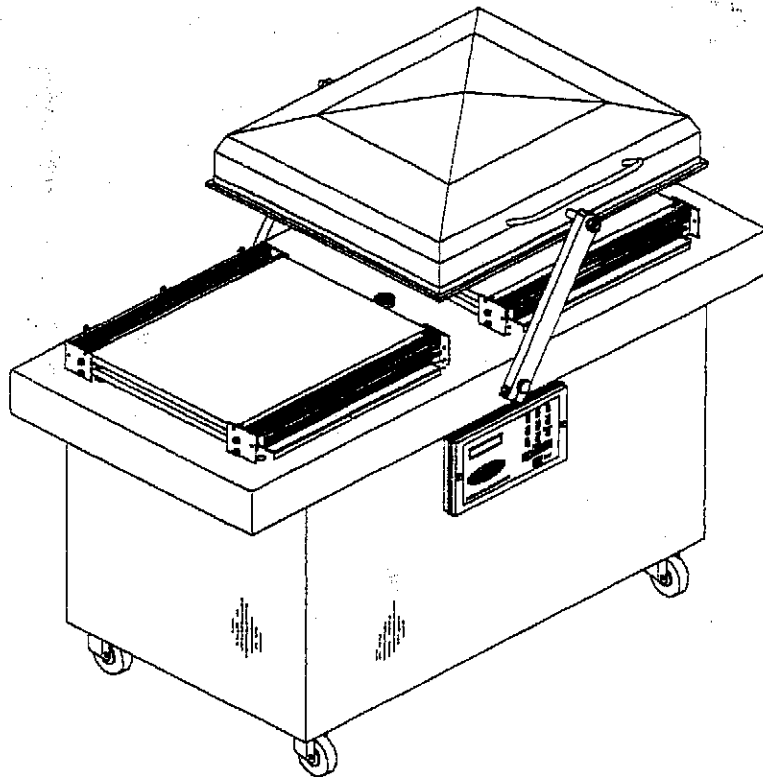


**MODEL
600A**

mc-40

2007



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!

ervice

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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I OPERATION INSTRUCTIONS

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- C- Cover adjustment procedure
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(twin seal)
- F- Seal bar assembly drawings
(electrical bag cut option)
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III ELECTRICAL

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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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 - 3.4 Daily cleaning
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 - 4.2 Insufficient vacuum
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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 recommended by the producer. Never exceed maximum quantity of oil indicated, when adding or changing oil. Verify weekly.

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

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

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

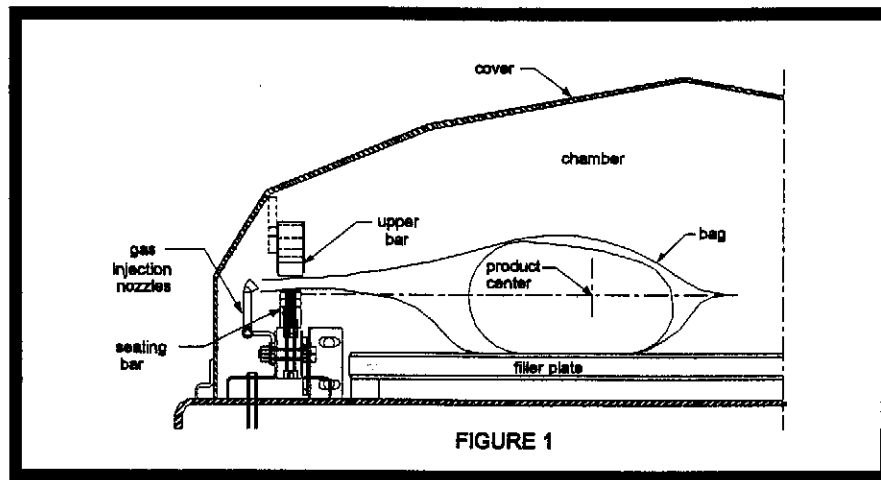
3. OPERATION:

3.1 Working principles:

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

To obtain nice packages, the products and the bags have to be of proportional sizes. The bag's opening should never exceed 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.



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

For gas flushing, the bags are placed on the sealing bars, the open end placed over the gas nozzles mounted alongside the sealing bar. After evacuation, the vacuum valve closes and the gas valve opens. Gas level (%) can be set 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 approximately 1/3 kg/sq. cm(5 lbs/sq. inch.). Each machine has an adaptor for gas connection when gas flush option is ordered.

3.2.2 Top and bottom sealing (optional):

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

3.2.3 Electrical bag cut (optional):

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

3.3 Vacuum packaging operation:

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

3.3.1 Basics:

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

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

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

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

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

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

3.3.2 Functions menu:

3.3.2.1 Create a program:

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

3.3.2.2 Delete a program:

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

3.3.2.3 Select operating mode:

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

3.3.3 Programs menu:

3.3.3.1 Program identification:

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

Example: EXAMPLE 1 → keys 2, 2, ENTER → E
(9 characters) 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 sequentially displayed on LCD screen, except for the parameters established to zero, which are not displayed:

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

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: xxxs"	(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)

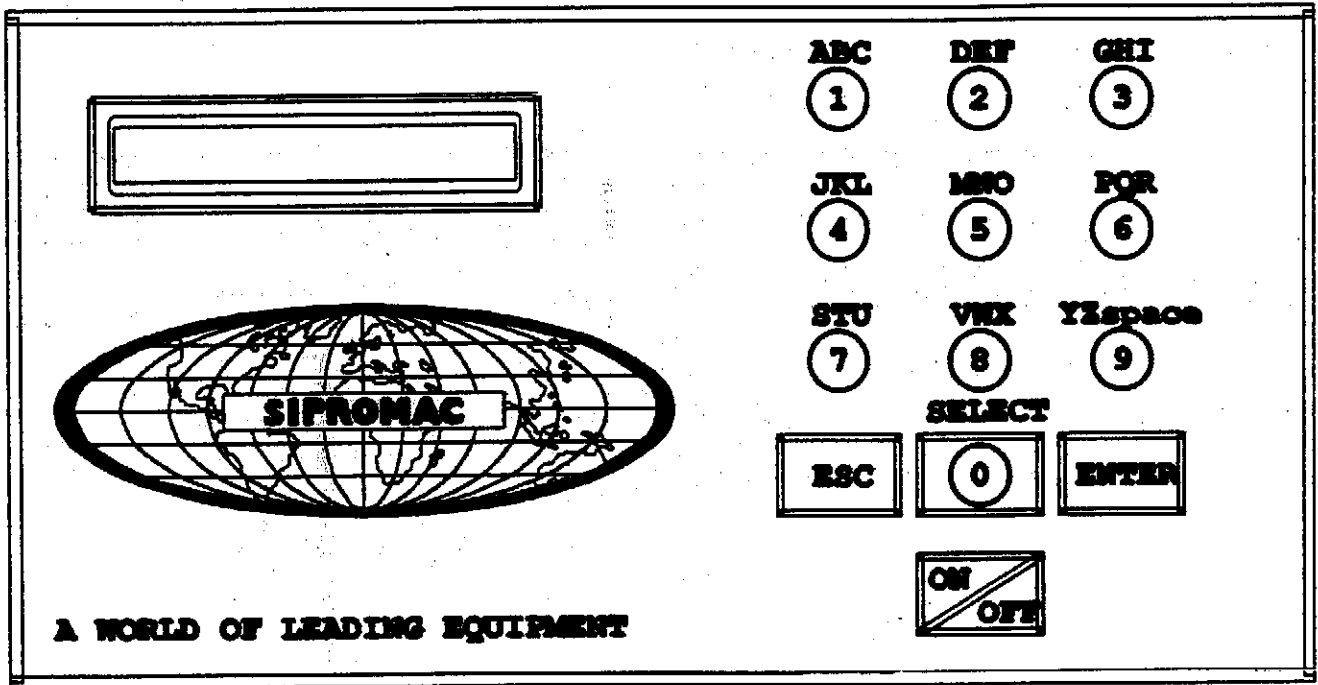
"SYSTEM MONITOR" (no access code required)

"SOFTWARE: R x.xx"

"WORK HRS: xxxxx"

"CYCLES: xxxxxxxx"

-KEYBOARD DETAILS-



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

3.4 Daily cleaning:

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

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "VACUUM ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

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

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

4.1.3 "ATMOSPHERE ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

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

- Check limit switch adjustment.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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

4.2.2 No leakage in the bag:

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

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

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

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

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.

4.4 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 damage to the main component: vacuum pump, valves..., electrical contactors, thermal overload, fuses holder or transformer.

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

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

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

Check vacuum connections for tightness.

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

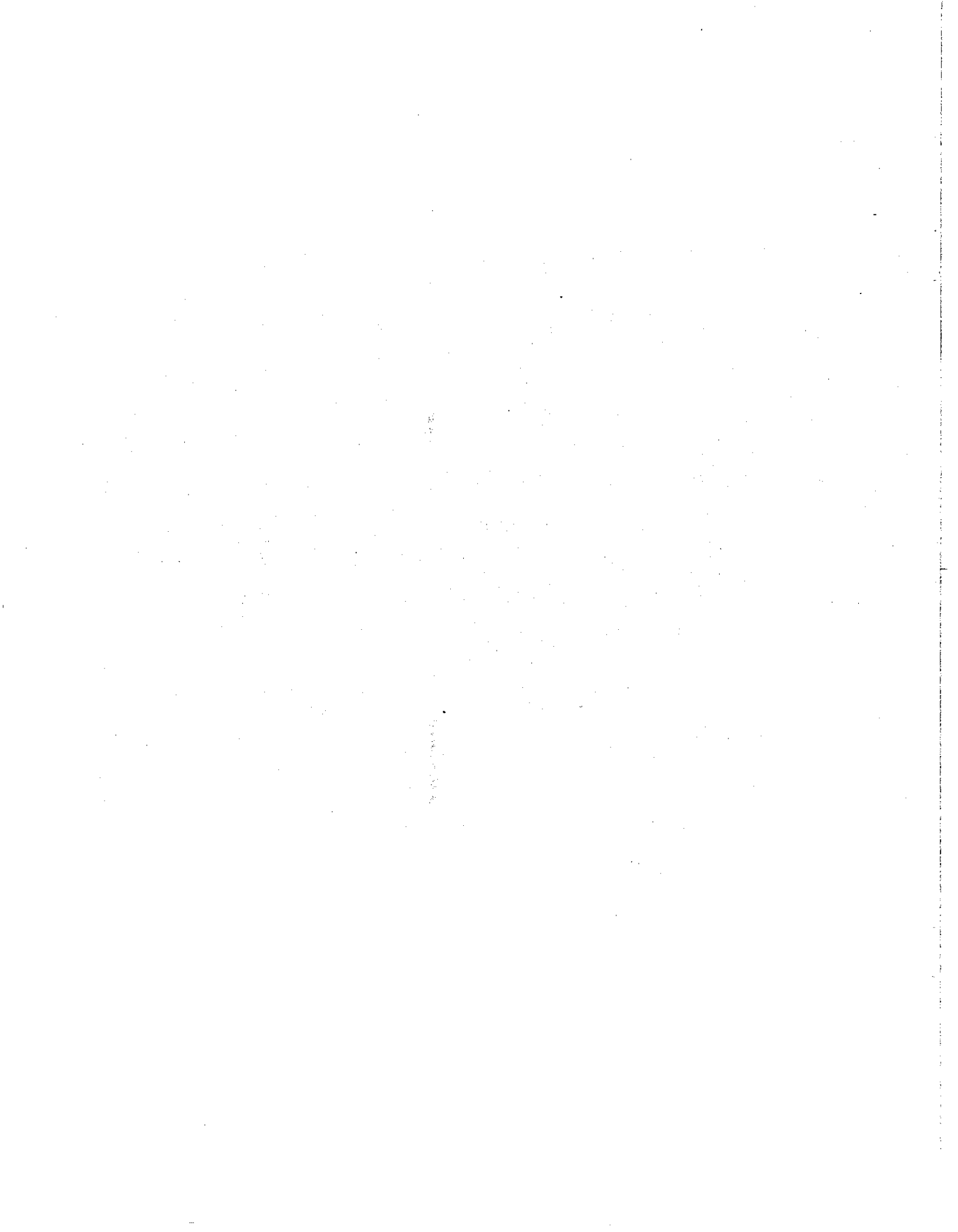
Check vacuum in chamber with precision vacuummeter.

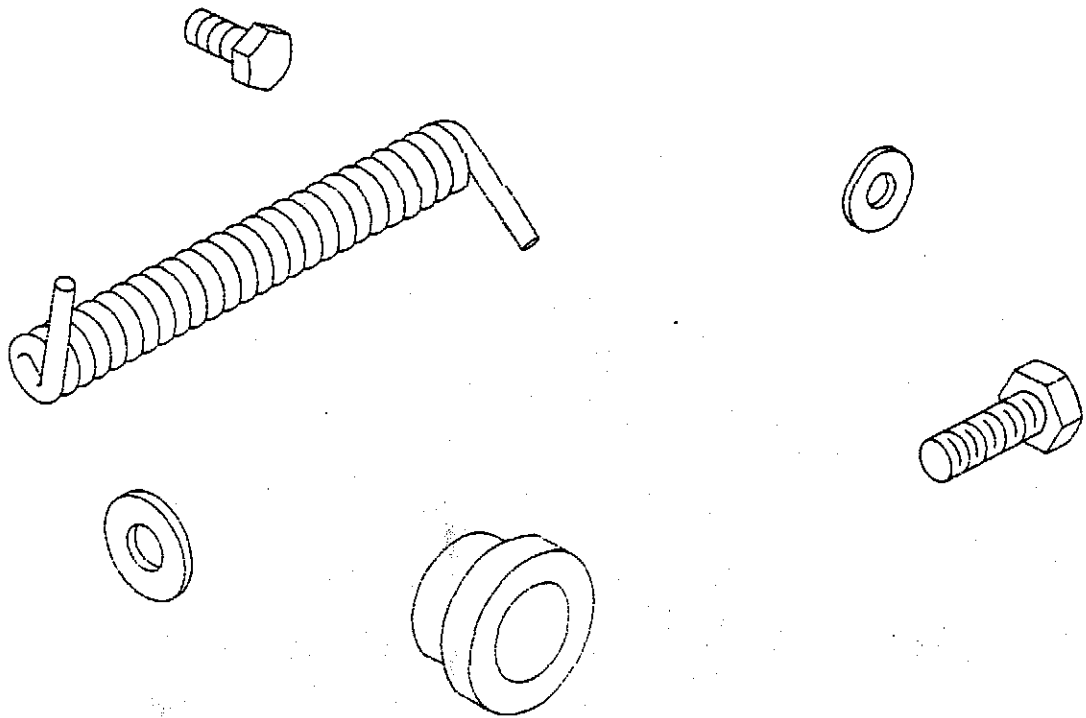
Check function of cycle with various settings of timers.

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

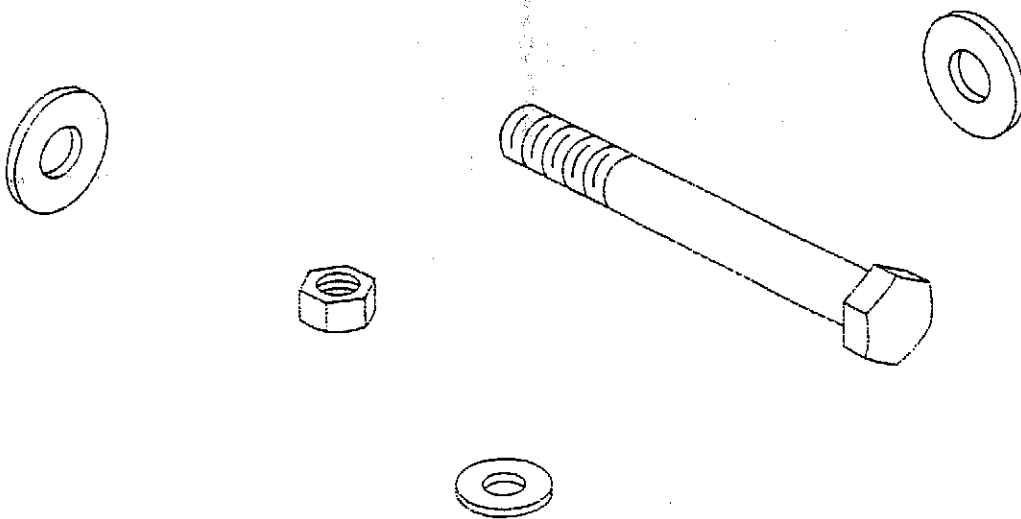
IN ORDER TO RESPECT NSF REGULATIONS:

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



ITEM	PART #	DESCRIPTION	QTY.
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	4
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	005A0589	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	057-0088	1/4" x 5/8" O.D. EPDM RUB. SEAL WASHER	4

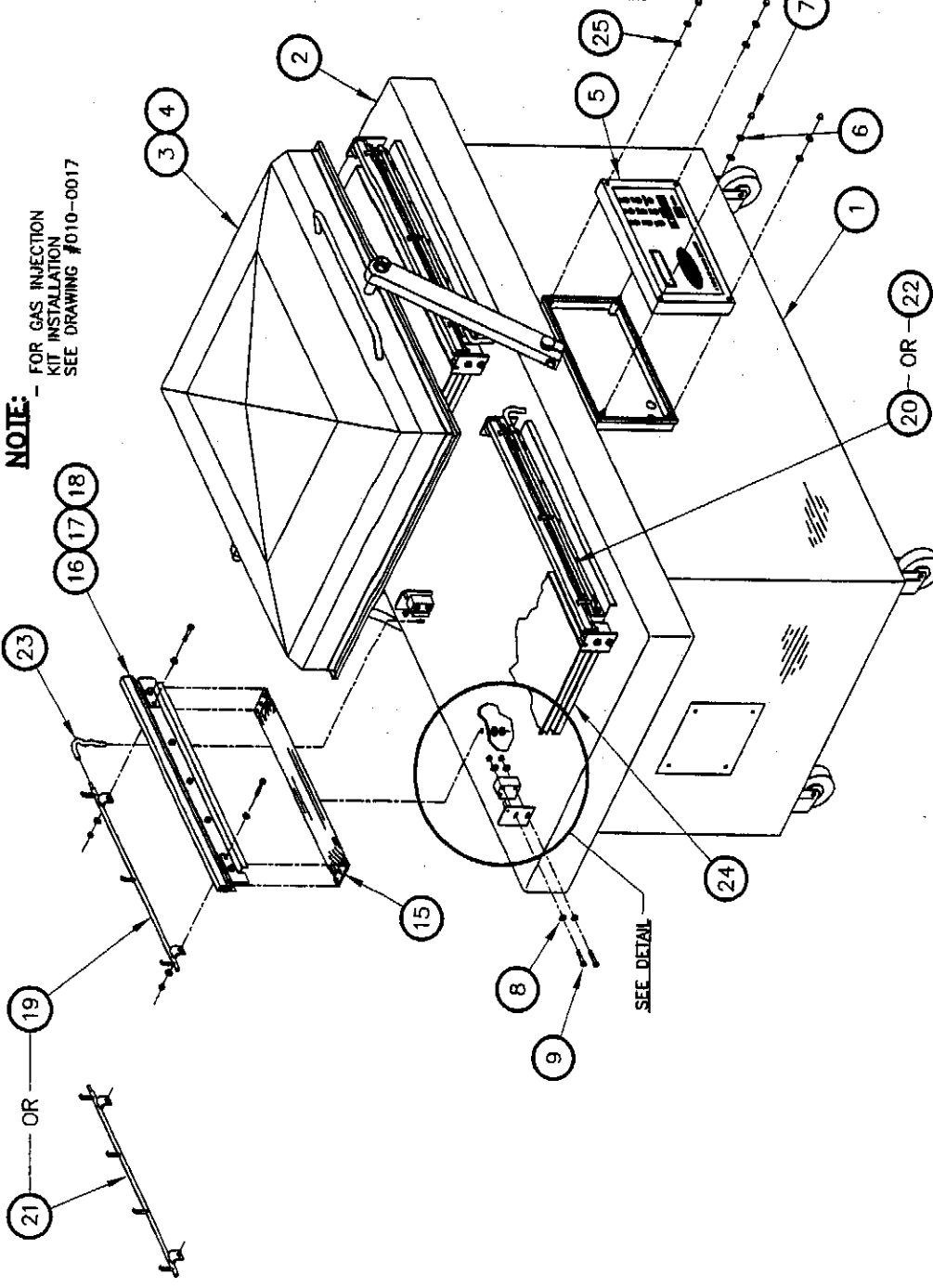
600A

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

MACHINE: 600A
PART: MACHINE ASSEMBLY FRONT VIEW
ITEM: 1
MATERIAL: M-1

DATE: 05-09-07
BY: J. REDAWN
MODIFICATION: []
DATE: []
BY: []

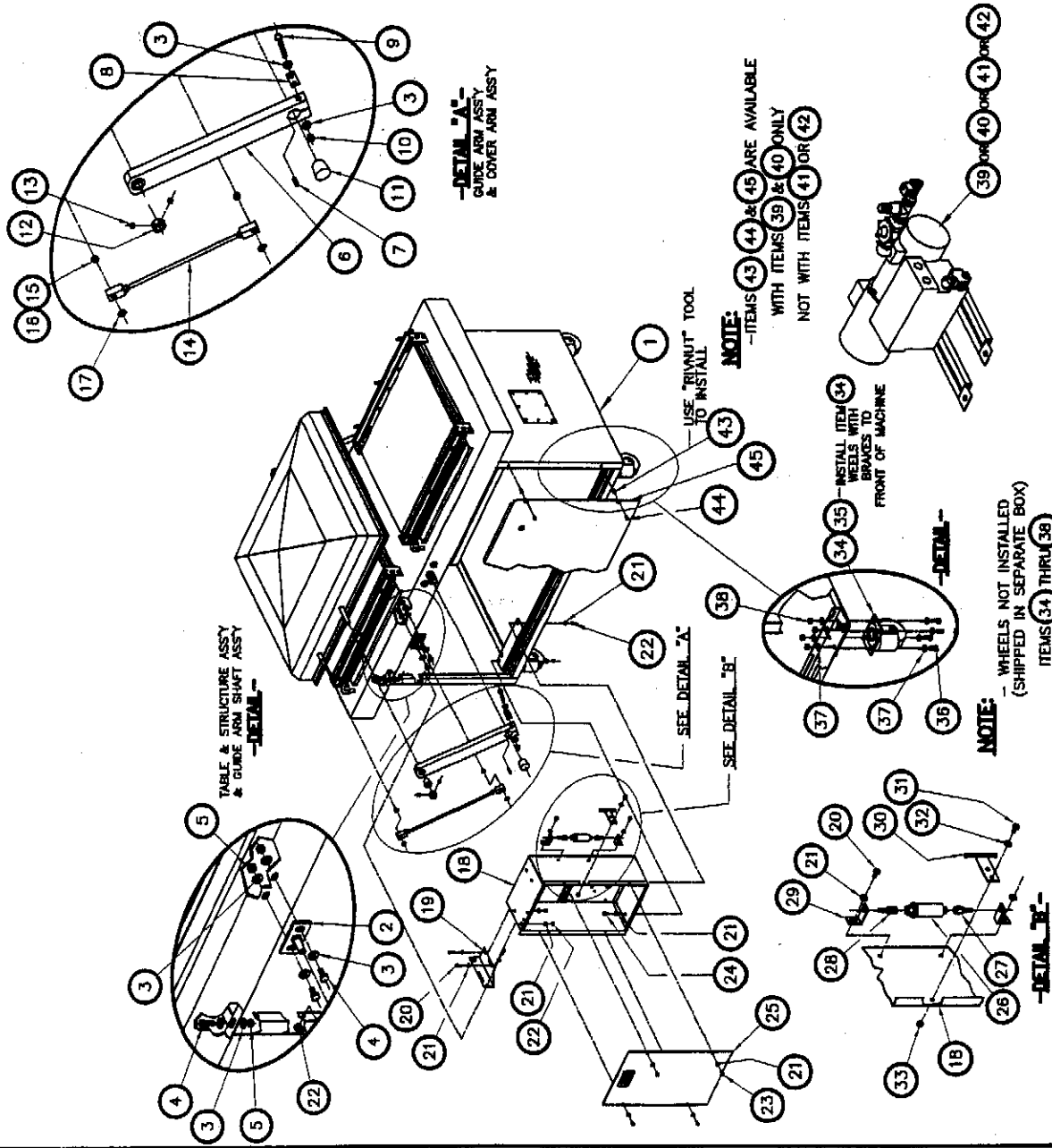
005A0324



-DETAIL-

1005-0325

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 ASSY	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"-18 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-ASSY	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" MINPT 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-ASSY (OPTION)	1



600A

MACHINE ASSEMBLY REAR VIEW

DATE 00-12-14

005-0325

SIPROMAC

ST-GERMAIN DE GRANTHAM

QUEBEC CANADA

M-1 01

MODIFIED VIEW	ITEM #1	M.A.L.
H	04-12-15	M.A.L.
M	04-01-14	J.G.
L	03-12-09	J.C.
K	02-11-05	Y.C.
J	00-05-12	S.L.
I	00-02-14	S.L.
H	00-02-14	S.L.
G	00-02-14	S.L.
F	00-02-14	S.L.
E	00-02-14	S.L.
D	00-02-14	S.L.
C	00-02-14	S.L.
B	00-02-14	S.L.
A	00-02-14	S.L.
0	00-02-14	S.L.
1	00-02-14	S.L.
2	00-02-14	S.L.
3	00-02-14	S.L.
4	00-02-14	S.L.
5	00-02-14	S.L.
6	00-02-14	S.L.
7	00-02-14	S.L.
8	00-02-14	S.L.
9	00-02-14	S.L.
10	00-02-14	S.L.
11	00-02-14	S.L.
12	00-02-14	S.L.
13	00-02-14	S.L.
14	00-02-14	S.L.
15	00-02-14	S.L.
16	00-02-14	S.L.
17	00-02-14	S.L.
18	00-02-14	S.L.
19	00-02-14	S.L.
20	00-02-14	S.L.
21	00-02-14	S.L.
22	00-02-14	S.L.
23	00-02-14	S.L.
24	00-02-14	S.L.
25	00-02-14	S.L.
26	00-02-14	S.L.
27	00-02-14	S.L.
28	00-02-14	S.L.
29	00-02-14	S.L.
30	00-02-14	S.L.
31	00-02-14	S.L.
32	00-02-14	S.L.
33	00-02-14	S.L.
34	00-02-14	S.L.
35	00-02-14	S.L.
36	00-02-14	S.L.
37	00-02-14	S.L.
38	00-02-14	S.L.
39	00-02-14	S.L.
40	00-02-14	S.L.
41	00-02-14	S.L.
42	00-02-14	S.L.
43	00-02-14	S.L.
44	00-02-14	S.L.
45	00-02-14	S.L.

MODEL 600A

COVER ADJUSTMENT PROCEDURE

Reference Drawing:# 005-0325
004A0122

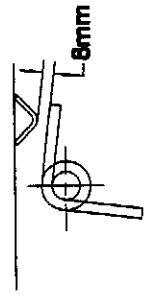
PROBLEM: MACHINE TABLE AND COVER SEEMS TO BE STRAIGHT, LID GASKET IS GOOD BUT COVER DOES NOT SIT PROPERLY ON BOTH SIDES OF TABLE.

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.

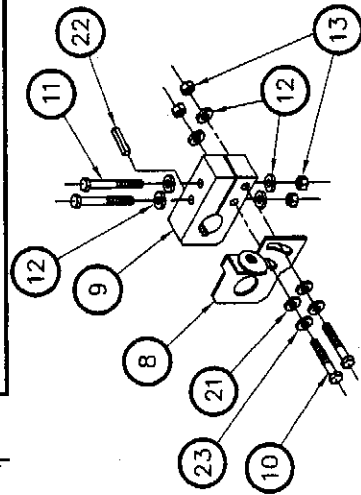
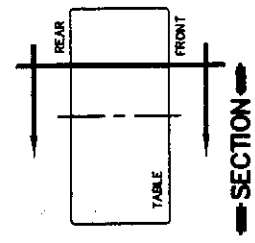
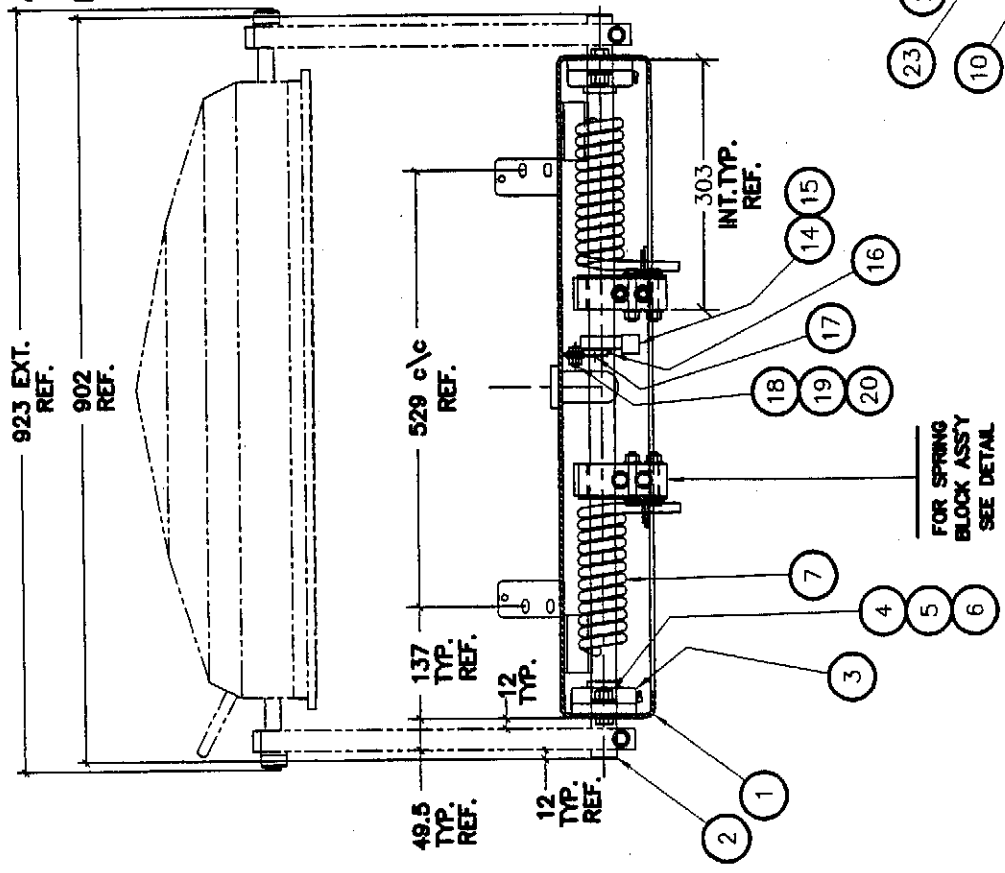
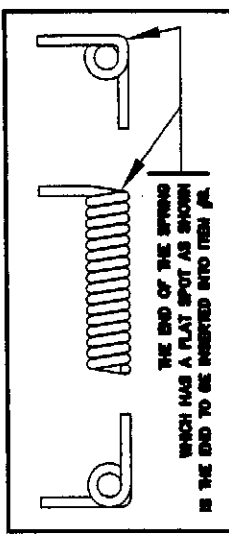
ITEM	PART #	DESCRIPTION	QT.
1	005-0150	TABLE ASSEMBLY	1
2	002A0318	CENTRAL SHAFT	1
3	075-1650	FLANGED BEARING W/ GREASE FITTING 90°	2
4	051-0441	HEX.BOLT 1/2"-13 x 1 1/2" S.S.	4
5	051-0630	HEX.NUT 1/2"-13 S.S.	4
6	051-0790	FLAT WASHER 1/2" S.S.	4
7	008-0315	CENTRAL SHAFT SPRING	2
8	004A0117	SUPPORT PLATE 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

SPRING ADJUSTMENT PRODEURE

- A- PLACE COVER UP(ARM VERTICAL) TO FREE TENSION OF SPRINGS.
- B- LOOSEN BOLTS ITEMS #10 ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASSY 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).



600A

CENTRAL SHAFT ASSEMBLY

SYMPHONIE

ST-VAIN I

DATE 99-11-17

ITEM

DATE 01-12-18

NO. 004A0122

ST-CERAMIC DE GRANITHAM

QUEBEC CANADA

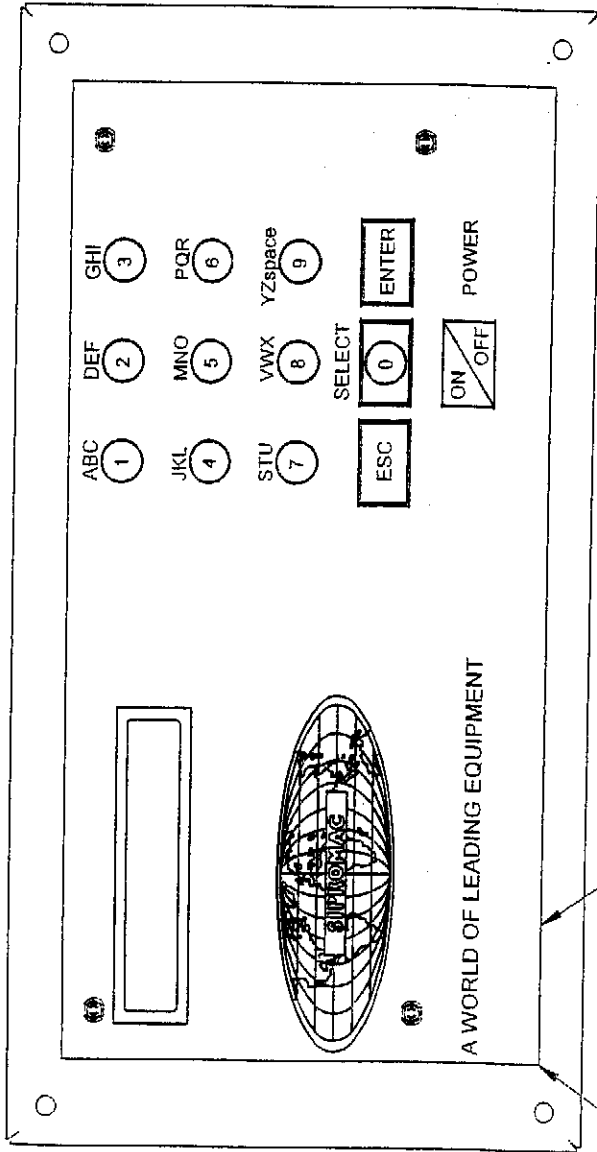
1-1-01

1

REV.	DESCRIPTION	DATE	BY	CHK.
1	REVISED VIEW ITEM #1	01-12-18	M.A.L.	
2	051-0783 ETAL D57-02060	09-11-20	S.L.	
3	REDRAWN/ MODIFIED SPRING BLOC	99-11-17	S.L.	

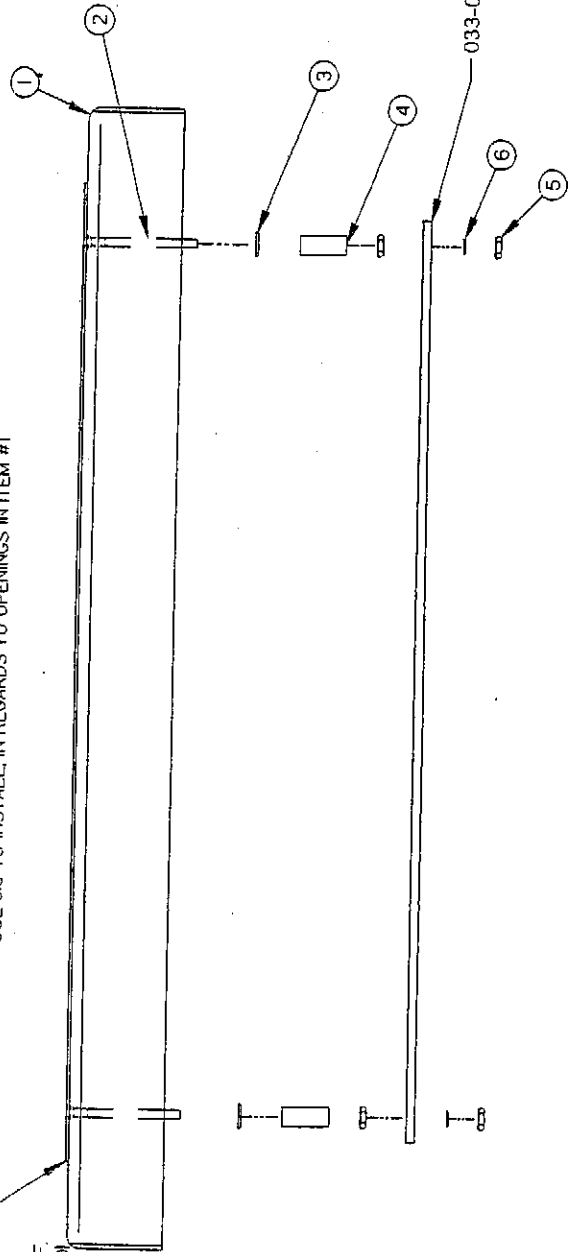
1005A0583

ITEM	PART #	DESCRIPTION	QT.
1	004A0425	FRONT MC-40 SUPPORT PRE-ASSY	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

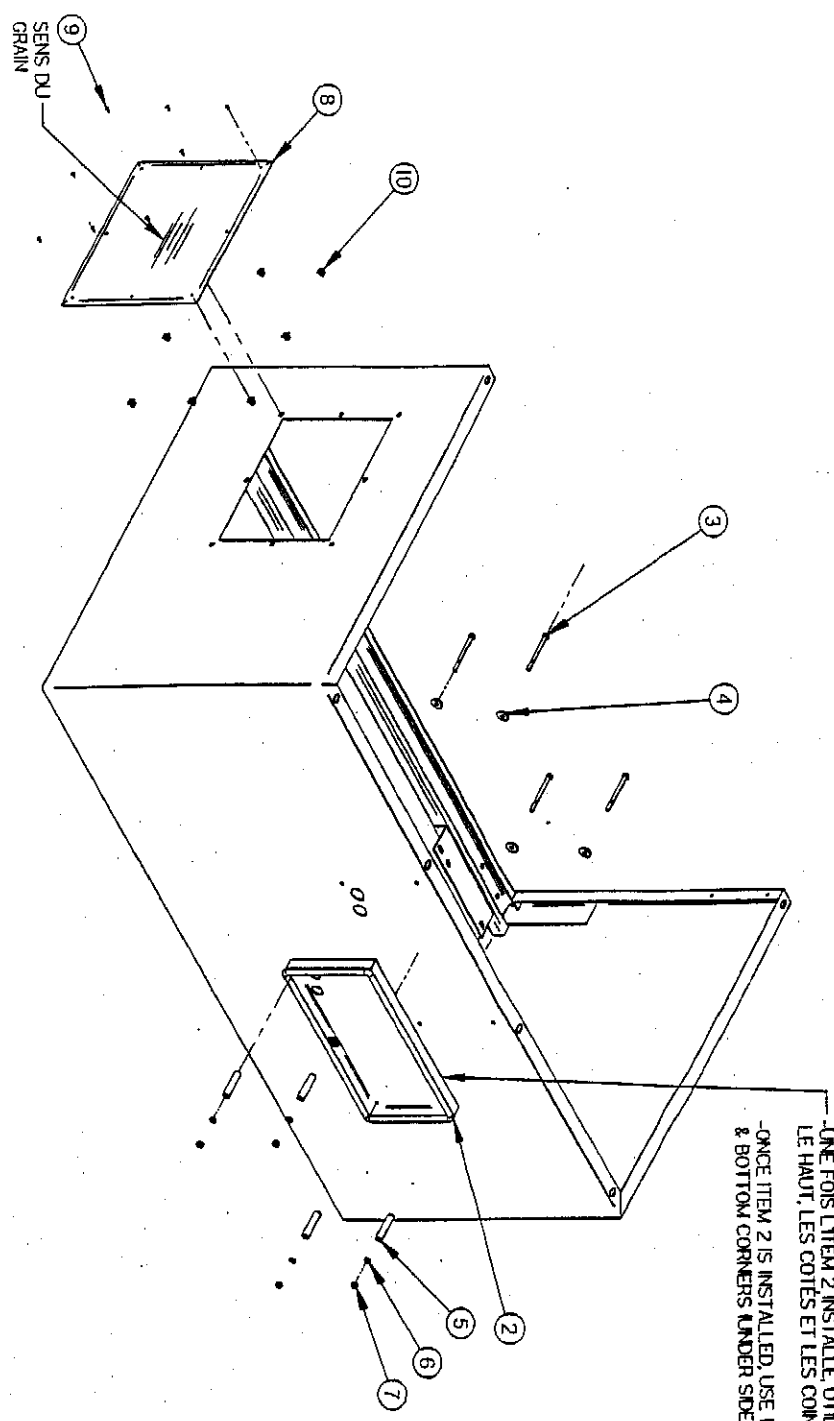


MACHINE 420A, 450A, 480T, 500A, 550A, 580A, 600A, 620A & 650A	DESIGN 1.000 2.00 3.00 4.00	REVISION 1.000 2.00 3.00 4.00	DATE 05-09-01	BY M.A.L.	DATE 05-16-74	NO. 005A0583	QTY. 1
PART FRONT MC-40 SUPPORT ASSY				N.T.S.		SIPROMAC ST-GERMAIN DE DEQUETIEN QUEBEC CANADA	
ITEM	CHK	DATE	BY	DATE	BY	NO.	QTY.

REDRAWN	050901	M.A.
MODIFICATION		DATE INT.

1005A0457

ITEM	PART #	DESCRIPTION	QTY.
1	004B0114	STRUCTURE PRE-ASSEMBLY	1
2	005A0584	REAR MC-40 SUPPORT ASSY	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 7/8"-20nc. S/S	4
8	001A3230	STRUCTURE COVER	1
9	054-0180	METAL SCREW #8 x 3/8" PAN SLOT S/S	8
10	057-5010	NYLON SCREW #10 RECEPTACLE INSERT	8

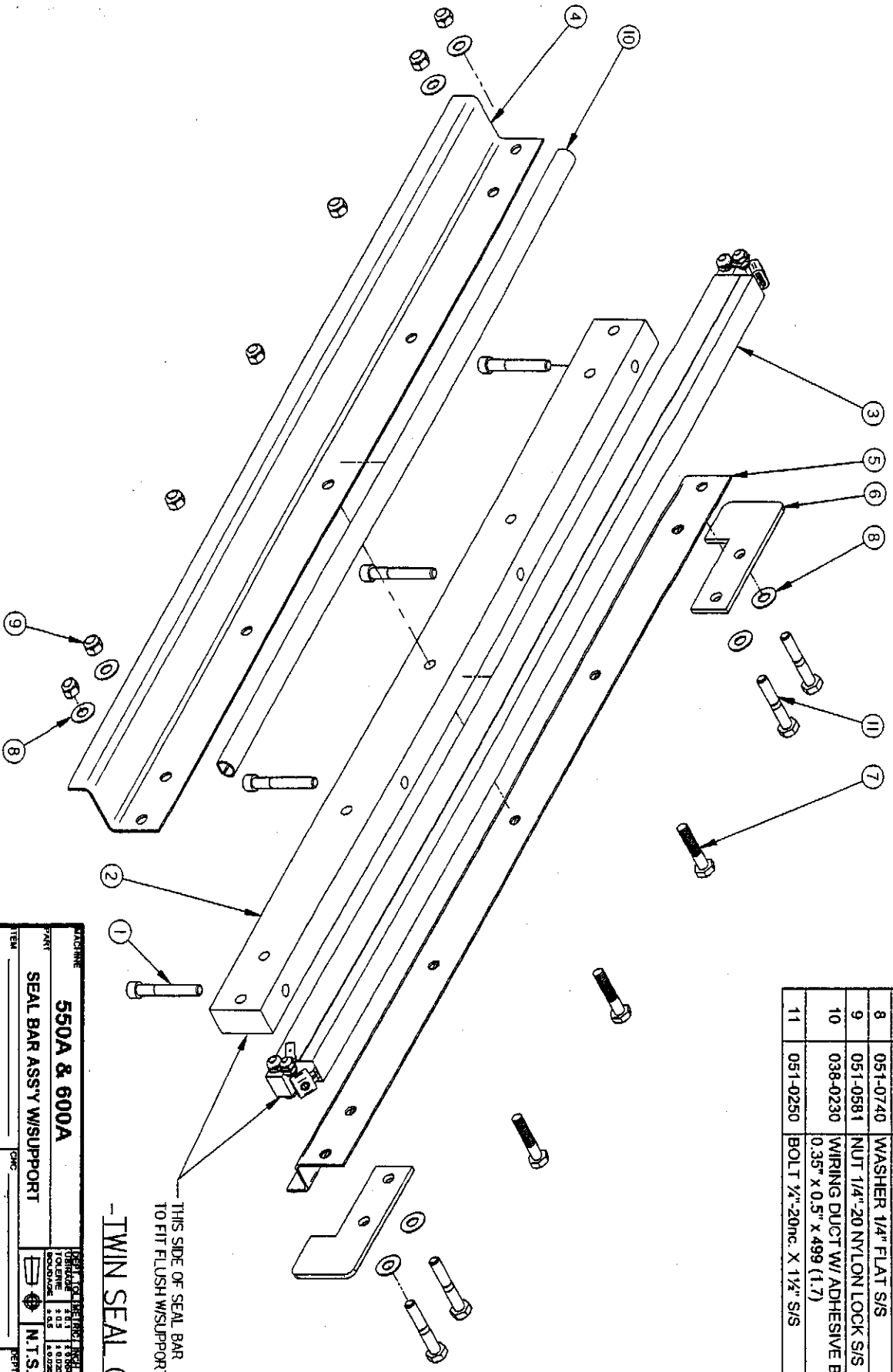


— L'UNE FOIS L'ITEM 2 INSTALLÉ, UTILISER DE L'ADHÉSIF MARIN 5200 #169-0210 POUR SCÉLER LE HAUT, LES CÔTES ET LES CORNS DU BAS (LE CÔTÉ DU DESSOUS N'EST PAS SCÉLÉ) & BOTTOM CORNERS (UNDER SIDE NOT SEALED).

C LET.	REDRAWN MODIFICATION	050907 M.A. DATE INT.	600A & 620A STRUCTURE ASSY	005A0457
ITEM PART QTY.	1 1 1	004B0114 005A0584 051-0287	STRUCTURE PRE-ASSEMBLY REAR MC-40 SUPPORT ASSY BOLT 1/4-20 x 3-1/4" S/S	1 1 4
4 4 4	051-0757 058-0140 051-0750	WASHER 1/4" FLAT THICK S/S PLASTIC SPACER 0.266" x 1/2" x 2 1/4" WASHER 1/4" LOCK S/S	4 4 4	4 4 4
4 1 8	051-0580 001A3230 054-0180	NUT 7/8"-20nc. S/S STRUCTURE COVER METAL SCREW #8 x 3/8" PAN SLOT S/S	4 1 8	4 1 8
8	057-5010	NYLON SCREW #10 RECEPTACLE INSERT	8	8

1005A0568

ITEM	PART #	DESCRIPTION	QTY.
1	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT SIS	4
2	002-0514	SEAL BAR SUPPORT	1
3	005A0152	SEAL BAR PRE-ASSY	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 SIS	8
9	051-0581	NUT 1/4"-20 NYLON LOCK SIS	7
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 499 (1.7)	1
11	051-0250	BOLT 3/4"-20nc. X 1 1/2" SIS	4



THIS SIDE OF SEAL BAR
TO FIT FLUSH W/SUPPORT

-TWIN SEAL OPTION-

550A & 600A
SEAL BAR ASSY W/SUPPORT

DATE: 05-09-13
BY: [Signature]

005A0568

REVISIONS:
REV. 1: 05-09-13
REV. 2: 05-09-13

DESIGNED BY: [Signature]
CHECKED BY: [Signature]
DRAWN BY: [Signature]
DATE: 05-09-13

SYMBOLS:
N.T.S.

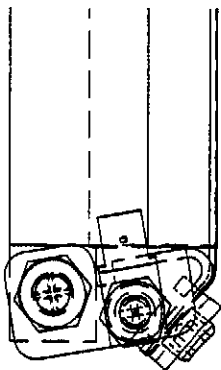
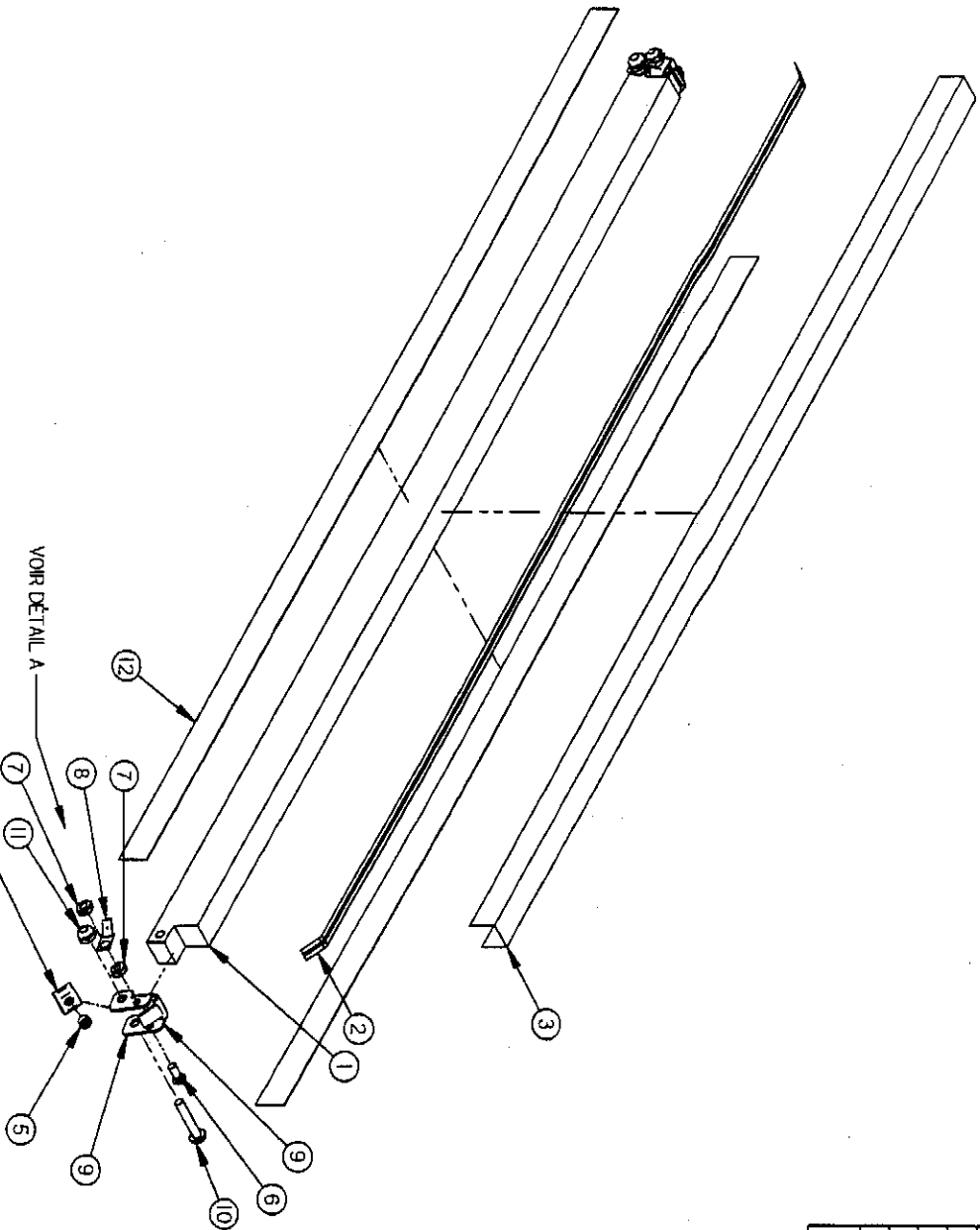
STANDARD: SIPROMAC
CLASSIFICATION: M-1

QTY: 1
LISTE

REDRAWN: 05-09-13 M.A.
MODIFICATION: DATE INT.

1005A0152

ITEM	PART #	DESCRIPTION	QTY.
1	002A0314	SEAL BAR	1
2	039-0268	DOUBLE SEAM BAND (8MM) (2.3)	1
3	176-0200	TEFLON TAPE, 5MIL (0.79)	1
4	056-1401	3/8" SET SCREW/BANDING BUCKLE S/S	2
5	051-0393	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

VOIR DÉTAIL A

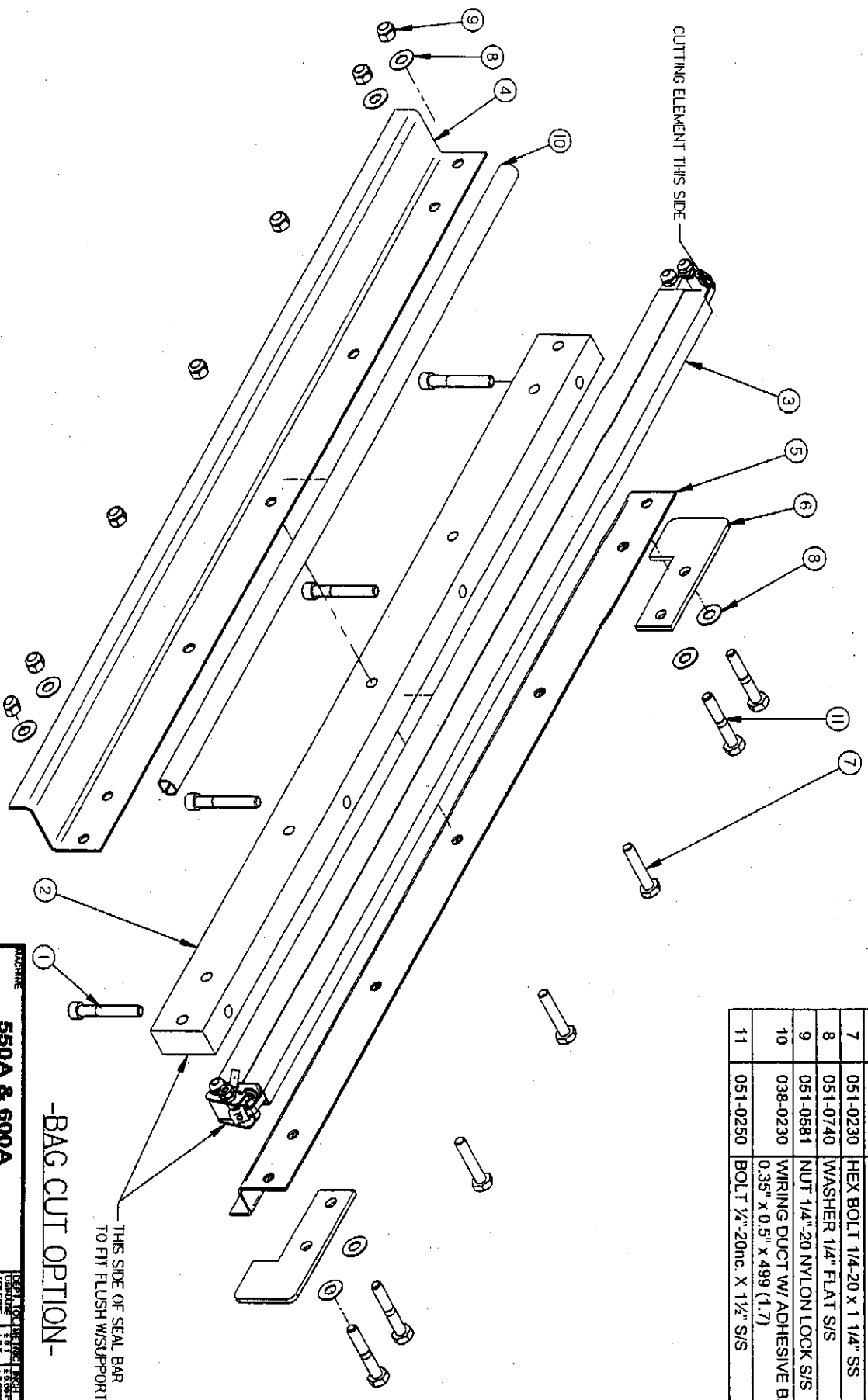
-TWIN SEAL OPTION-

C	ADDED 052-0393	06-04-19	M.A.
F	051-0104 & 001B2742 ETANT 051-0100 & 009A0187	06-03-06	J.G.
E	REDRAWN	05-08-13	M.A.
LET.	MODIFICATION	DATE	INT.

550A & 600A SEAL BAR PRE-ASS'Y		PART NO. 1005A0152 QTY. 2 UNIT. EACH
DRAWN BY: MAL DATE: 05-09-13 APPR. BY: [Signature]	DEPT.: M-1 PLANT: [Blank]	MACHINE: [Blank] QTY: [Blank]
005A0152		SIPPROMAC 550A 600A

1005B0569

ITEM	PART #	DESCRIPTION	QTY.
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-ASSY	1
4	001-1962	EXTERIOR BELLOW'S COVER	1
5	001-1963	EXTERIOR BELLOW'S 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 1/2"-20nc. X 1 1/2" S/S	4



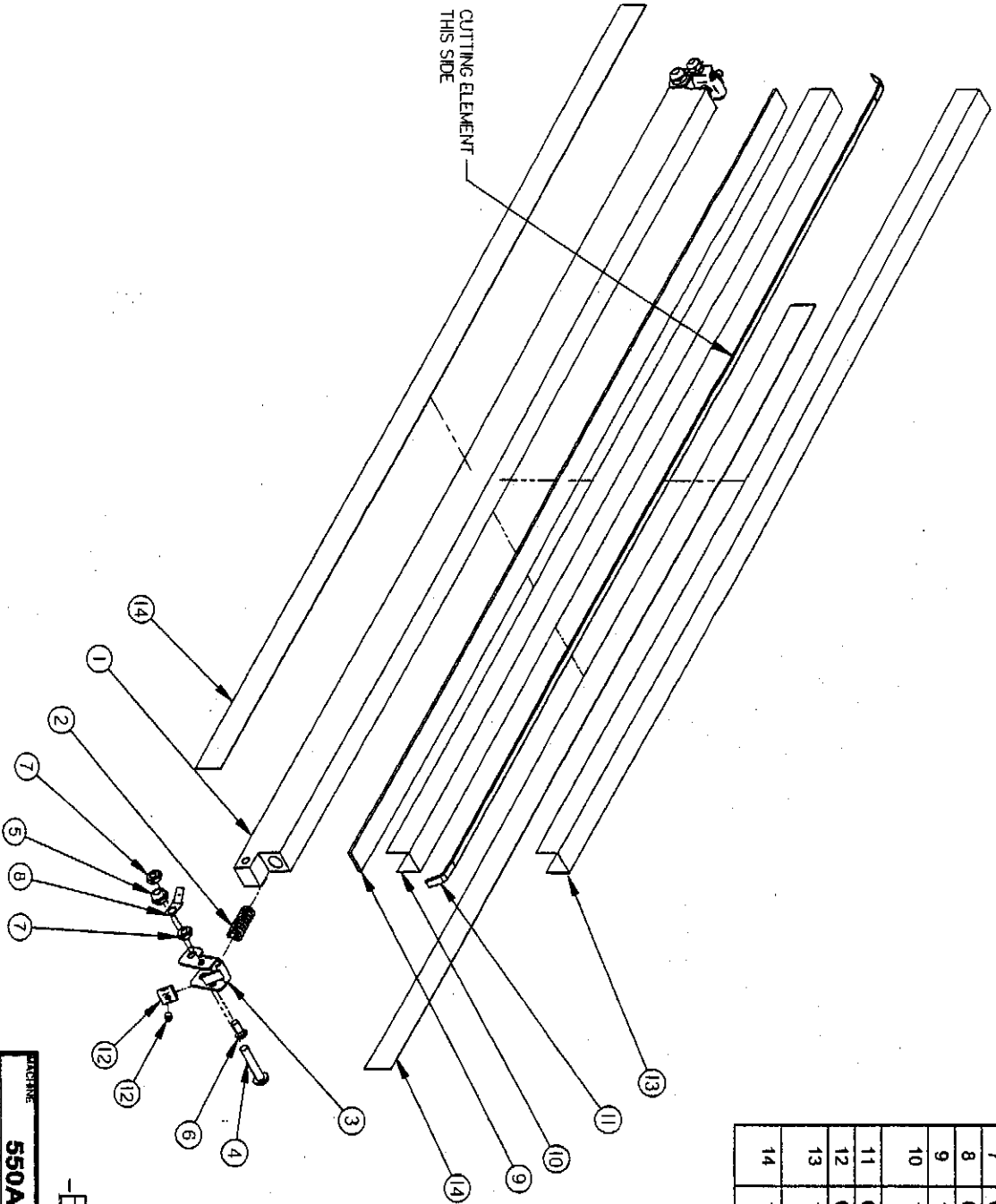
-BAG CUT OPTION-
THIS SIDE OF SEAL BAR
TO FIT FLUSH W/SUPPORT

MACHINE		550A & 600A	
PART		SEAL BAR ASSY W/SUPPORT	
ITEM	QTY	DATE	BY
M-1	4	06-05-29	MAL
MACHINE		SIPROMAC	
MACHINE QTY		2	
MACHINE		550A	
MACHINE		600A	
MACHINE		M-1	
MACHINE		LISTE	
MACHINE		005B0569	

REF	REDRAWN	DATE	06-05-29	INIT	M.A.
MODIFICATION					

1005B0153

ITEM	PART #	DESCRIPTION	QTY.
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 (0.019)	TAPE CLEAR SUPER BOND 3/4" 641.5mm	2



-BAG CUT OPTION-

600A	4
550A	2
MACHINE	QTY
SIPROMAC	
ST-DESIGNER DE GRANITUM	
QUÉBEC CANADA	

MACHINE: **550A & 600A**

PART: **SEAL BAR PRE-ASSY**

QTY: **N.T.S.**

DATE: **06-05-29**

BY: **M.A.L.**

NO: **005B0153**

LISTE

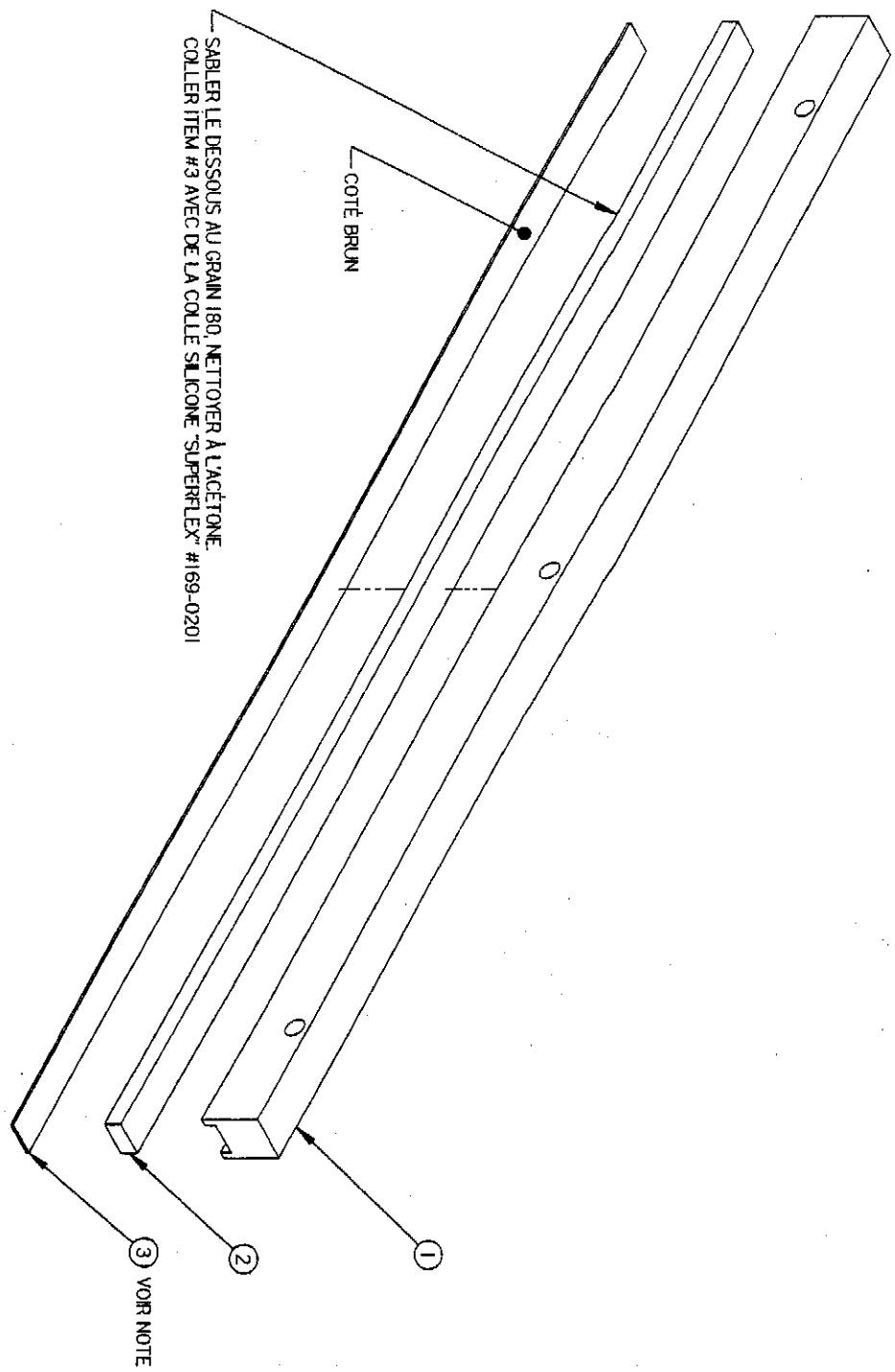
REDRAWN: **M.A.**

DATE: **06-05-29**

MODIFICATION: **INT.**

1004A1326

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

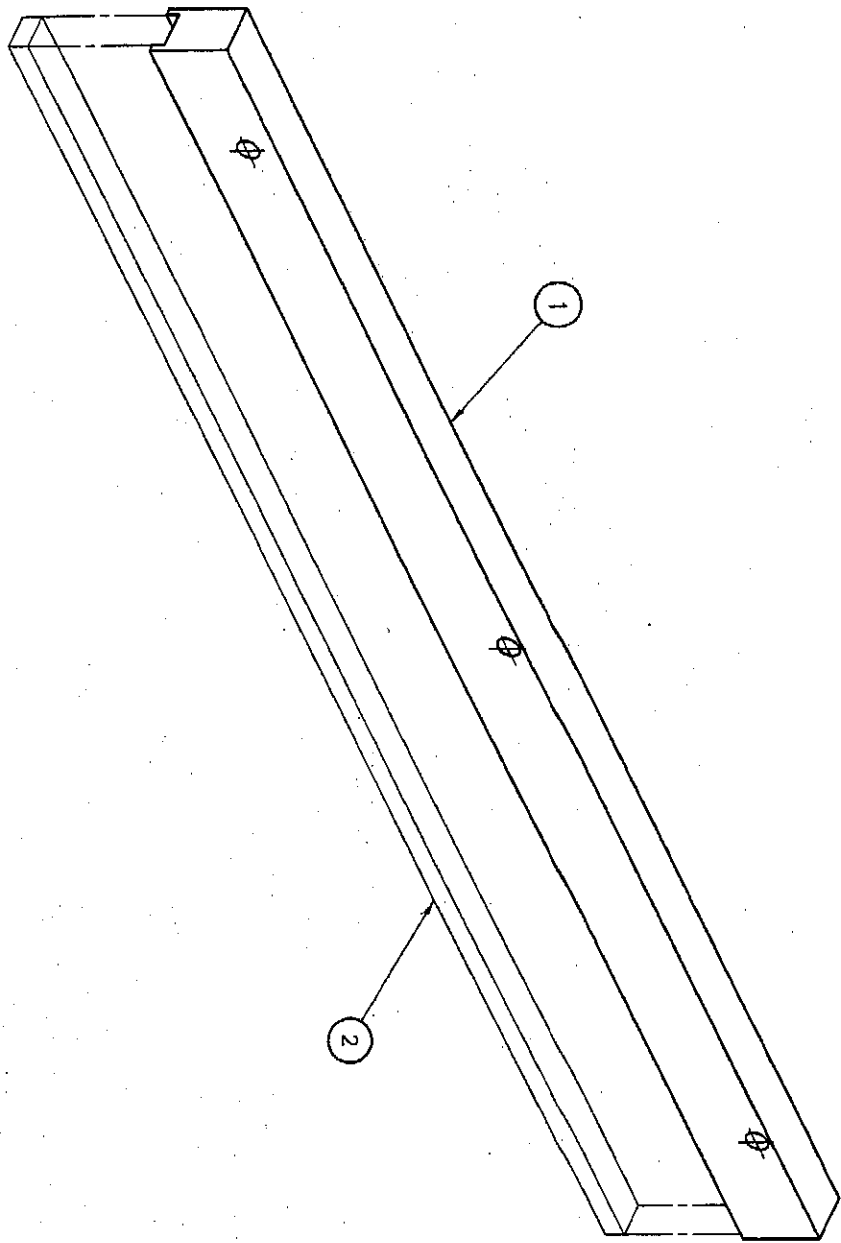


NOTE:
 -INSTALLER ITEM #3 SEULEMENT SI L'OPTION "SHRINKABLE BAG" EST COMMANDE.

-BAG CUT OPTION-

MACHINE		600A	
UPPER SEAL BAR ASSEMBLY (E.C.O.)			
DATE	BY	DATE	BY
	JG	06-03-07	
ITEM	REV	REV	REV
M.I.		D.V. 2	
SIPROMAC		SIPROMAC	
DREBEC CANADA		DREBEC CANADA	

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

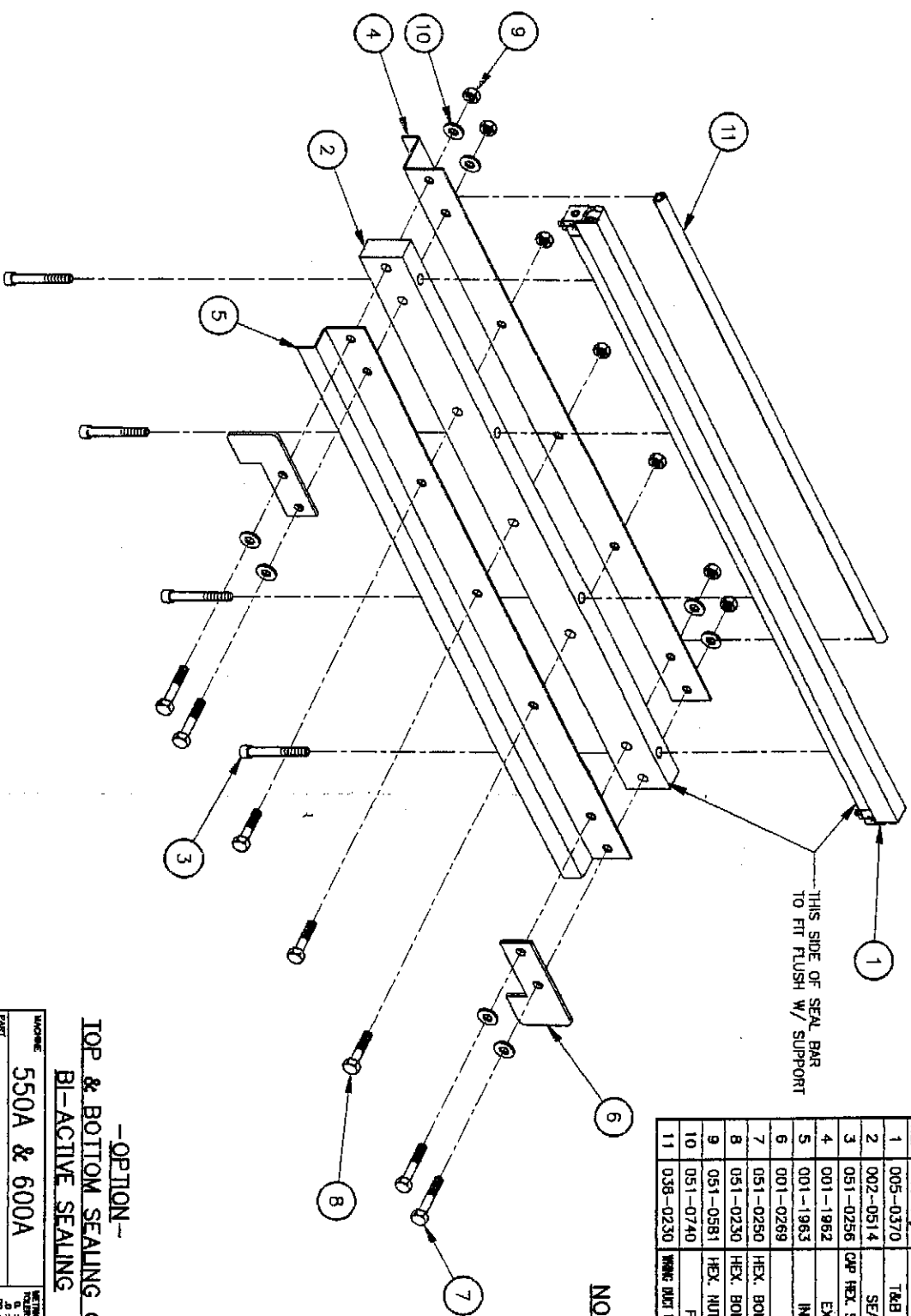


9	REDRAWN	SL
LET	MODIFICATION	DATE
		99-07-15
		NIT.

PART NAME		600A	
PART		UPPER SEAL BAR ASSEMBLY	
DATE	BY	DATE	BY
		99-07-15	
SCALE		2	
MATERIAL		SIPROMAC	
DRAWN BY		ST-GERMAIN DE GRANVILLE	
CHECKED BY		DUBRECH CARRIER	
APPROVED BY		N.T.S.	
PART NO.		005A0573	

1005A0573

A S50A ADDED/ MOORE, NO. A-0241
 LET. KOORPACTIEM
 98-02-24
 DATE
 A.P.
 MT.



ITEM	PART #	DESCRIPTION	QTY
1	005-0370	T&B SEAL BAR PRE-ASSEMBLY	1
2	002-0514	SEAL BAR SUPPORT (TABLE)	1
3	051-0256	CPW HEX. SRT. BOLT 1/4"-20 NC X 1 3/4" S/S	4
4	001-1962	EXTERIOR BELLOW'S COVER	1
5	001-1963	INTERIOR BELLOW'S COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	4
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	3
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	7
10	051-0740	FLAT WASHER 1/4" S/S	8
11	038-0230	WING NUT W/ ADHESIVE BRIDGE (0.25 X 0.5 X 0.75) PVC	1

NOTE:
 QTY FOR ONE
 SEAL BAR ONLY
 SEE LIST

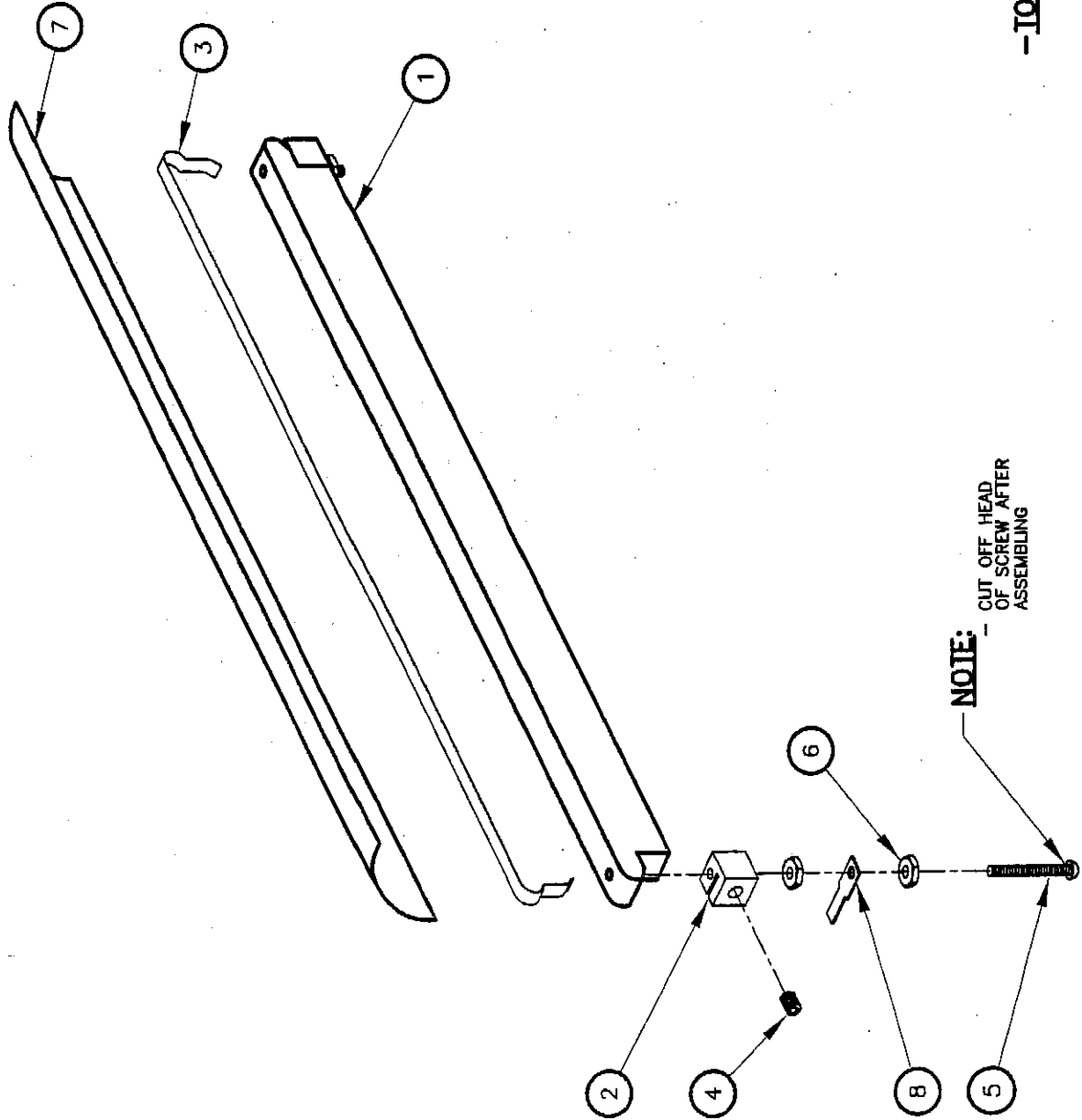
-OPTION-
 TOP & BOTTOM SEALING OR
 BI-ACTIVE SEALING

MACHINE: 550A & 600A
 PART: SEAL BAR ASSEMBLY W/ SUPPORT
 TITLE: SEAL BAR ASSEMBLY W/ SUPPORT
 DATE: 97-10-24
 NO: 005-0570
 ST-GERMAIN DE GRANVILLE
 QUEBEC CANADA

1005-0570

005-0370

ITEM	#PART	DESCRIPTION	QTY.
1	002-0314	SEAL BAR (TABLE)	1
2	009-0029	CONNECTOR	2
3	039-0220	BI-ACTIVE SEALING ELEM. (780MM EA.)	0.078
4	052-0395	SCREW 1/4" - 20 NC. X 5/16" SET HEX SKT OVAL PT	2
5	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
6	051-0550	NUT #8-32 S/S	4
7	176-0200	TEFLON TAPE 5S ADHESIVE X 2" X (650mm EA.)	0.083
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2



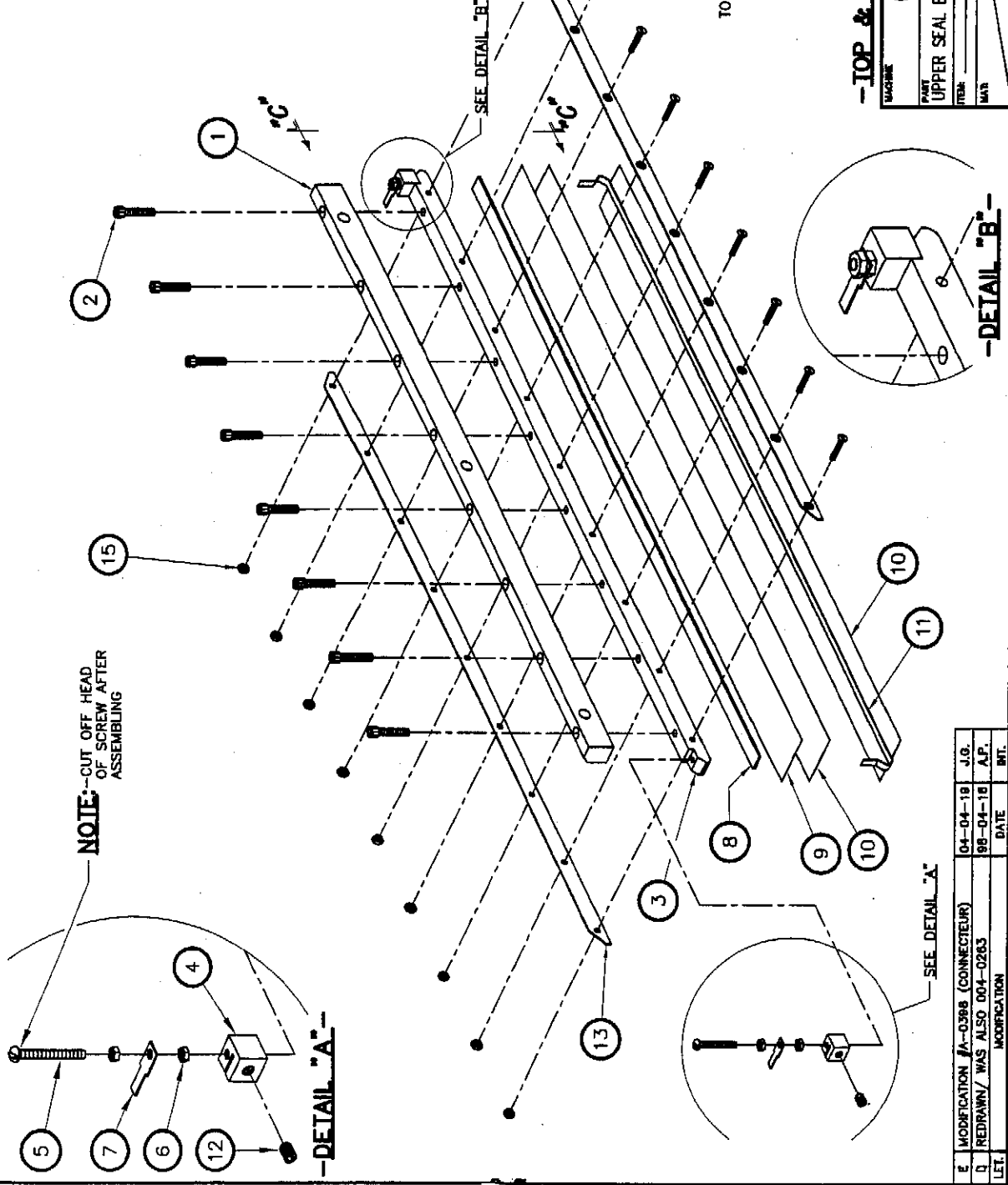
NOTE: - CUT OFF HEAD OF SCREW AFTER ASSEMBLING

-TOP AND BOTTOM SEALING OPTION-

MACHINE	550A & 600A	TEL. NO.	550A	QTY.	4
PART	SEAL BAR PRE-ASSEMBLY	DATE	98-02-10	MACHINE	2
ITEM		DATE	98-02-10		
MATERIAL		DATE	98-02-10		
ST-GERMAIN DE GRANTHAM QUEBEC CANADA		M-1		QTY. SEE LIST	
N.T.S.		M-1		005-0370	

D	MODIFICATION	A-0398 (CONNECTEUR)	04-04-18	J.G.
C	REDRAWN		98-02-10	A.P.
LET.	MODIFICATION		DATE	INT.

ITEM	PART #	DESCRIPTION	QTY.
1	002-0534	UPPER SEAL BAR SUPPORT	1
2	051-0220	SCREW 1/4"-20 NC. X 1" CAP HEX. SKT S/S	8
3	002-0349	UPPER SEAL BAR	1
4	009-0029	TOP & BOTTOM SEAL CONNECTOR WELDED	2
5	052-0250	SCREW #8-32 NC. X 1 1/2" RND SLOT BRASS	2
6	051-0550	HEX. NUT #8-32 NC. S/S	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm ADHESIVE (706mm EA.)	0.74
9	176-0200	TEFLON TAPE (5S) ADHESIVE (716mm EA.)	0.09
10	176-0220	TEFLON TAPE (10S) ADHESIVE (2x716mm EA.)	0.18
11	039-0220	BI-ACTIVE SEALING ELEM. (B466mm EA.)	0.06
12	052-0395	SET SCREW 1/4"-20 NC. X 5/16" (OVAL POINT)	2
13	001-1410	UPPER TEFLON HOLDER	2
14	051-0121	SCREW #8-32 NC. X 1" FLAT PHILL. S/S	9
15	051-0550	HEX. NUT #8-32 NC. S/S	9



-TOP & BOTTOM SEALING OPTION-

MACHINE: 600A

PART: UPPER SEAL BAR ASSY W/ SUPPORT

ITEM: _____

DATE: 98-05-26

SCALE: _____

QTY.: 2

BY: A. PROVENCHER

DATE: 24-03-97

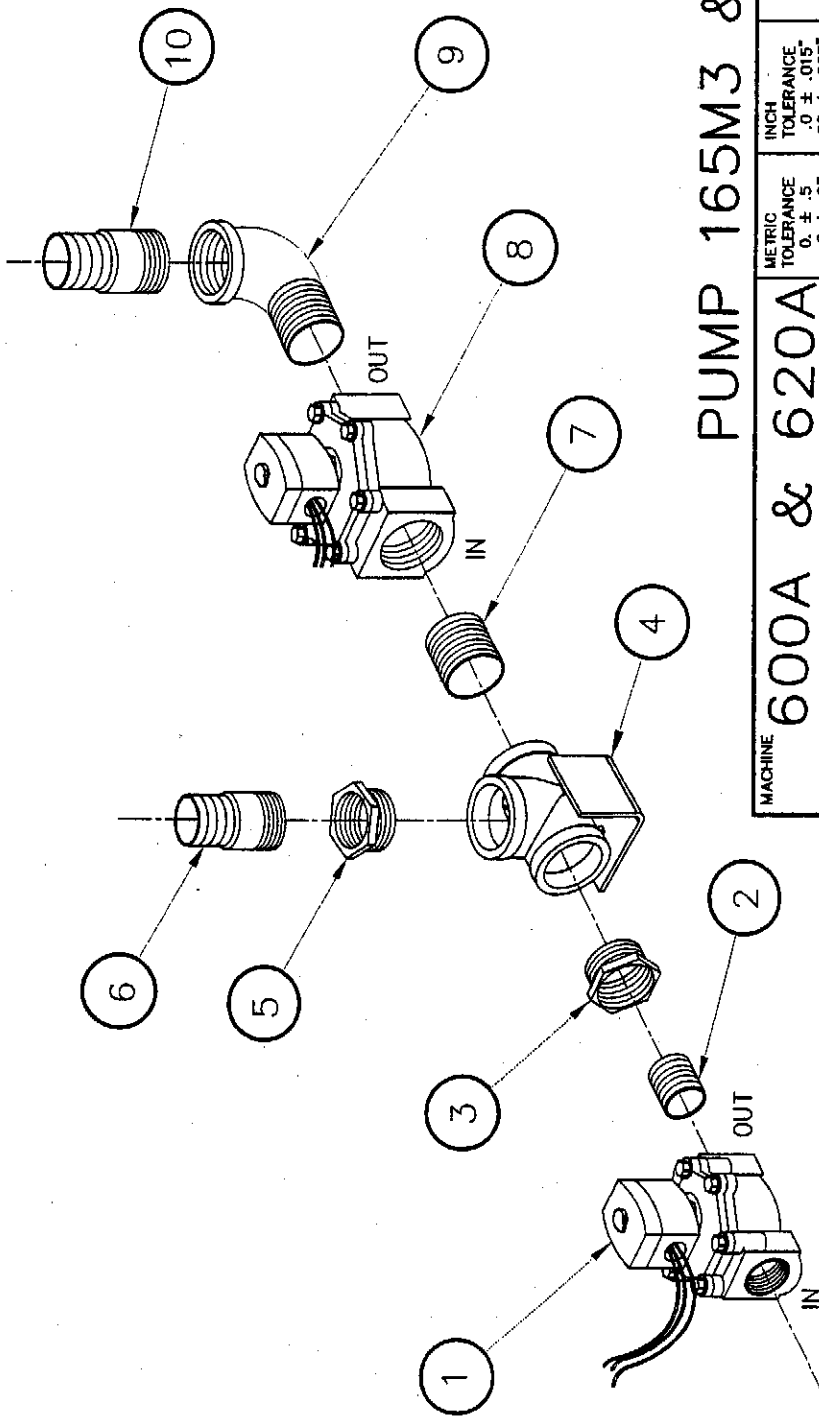
005-0386

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

E	MODIFICATION #A-0386 (CONNECTEUR)	04-04-18	J.O.
Q	REDRAWN/ WAS ALSO 004-0263	98-04-18	A.P.
LET.	MODIFICATION	DATE	INT.

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 x 1-1/4" 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

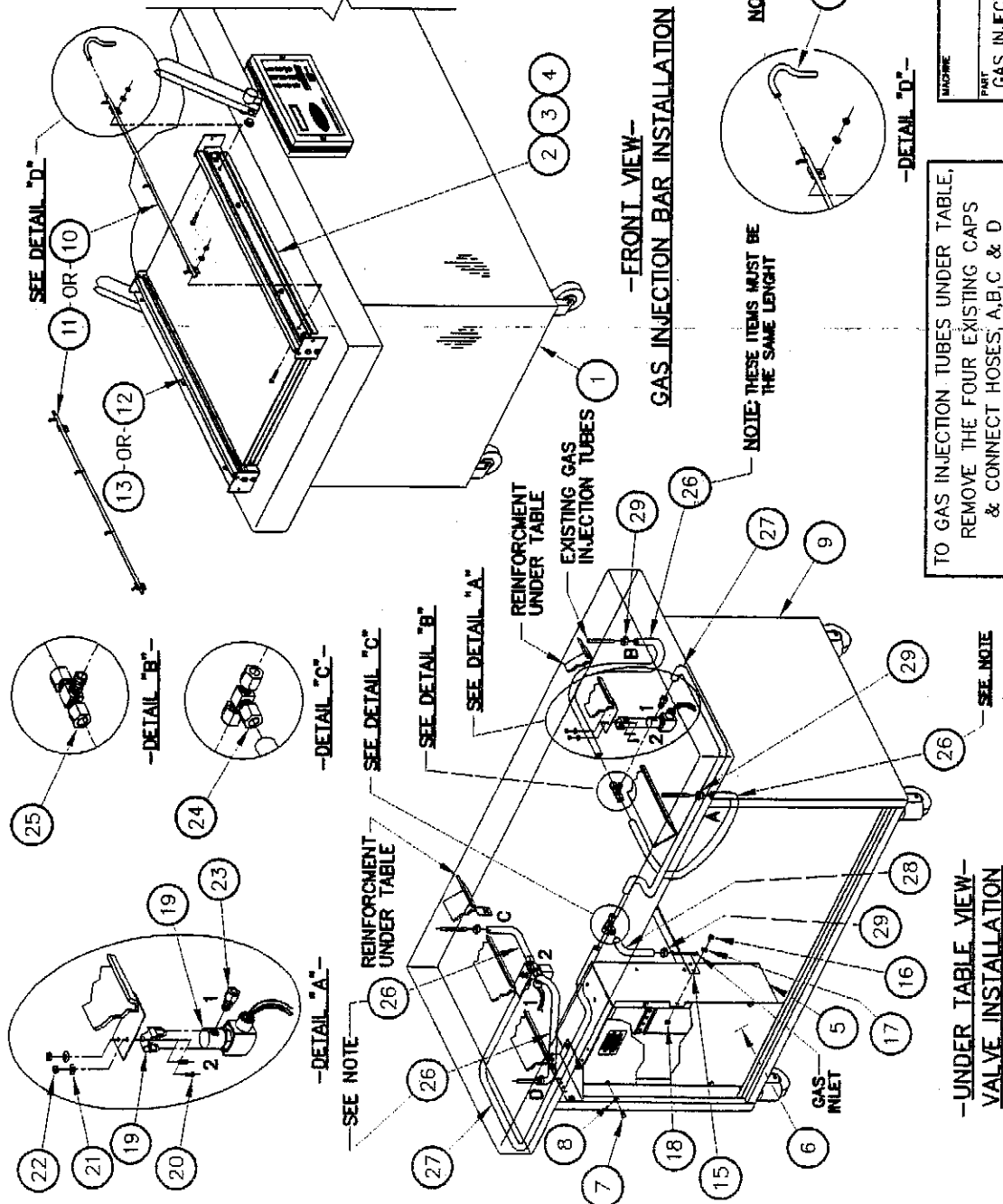


PUMP 165M3 & 255M3

MACHINE 600A & 620A	METRIC TOLERANCE 0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1°	INCH TOLERANCE .0 ± .015 .00 ± .005 .000 ± .0005	SIPROMAC
PART VACUUM/ATMOSPHERE VALVE ASSY.	N.T.S.		ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM: _____	CNC: _____	M	QT. 1
MAT: _____	DWG BY DAVE A	DATE 01-01-29	NO. 004-0863
DATE _____	APP. _____	DATE 05-11-23	

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

ITEM	PART #	DESCRIPTION	QTY.
1	005-0336	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0568	SEAL BAR ASSY W/ SUPPORT	4
3	005-0569	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPT.)	4
4	005-0570	SEAL BAR ASSY W/ SUPPORT (I & B OPT.)	4
5	005-0374	ELECTRICAL BOX ASSEMBLY	1
6	004-0279	ELECTRICAL BOX COVER PRE-ASSY	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4" S/S	4
9	005-0337	MACHINE ASSEMBLY REAR VIEW	1
10	005-0571	GAS 3 INJECTION BAR ASSEMBLY (OPTION)	2
11	005A0446	FRONT GAS 4 INJECTION BAR ASSY (OPT.)	2
12	005A0810	GAS 3 INJECTION BAR ASSEMBLY (OPTION)	2
13	005A0811	REAR GAS 4 INJECTION BAR ASSY (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	108-0010	SELENIUM 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	051-0950	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"	5



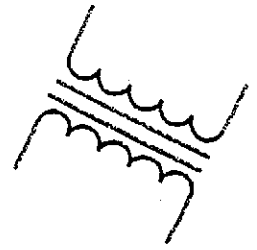
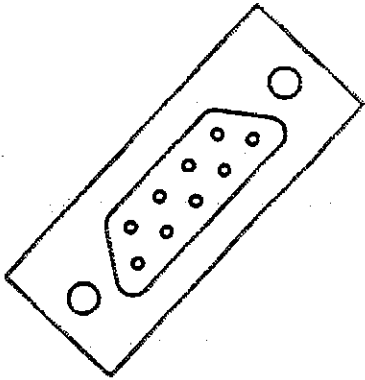
NOTE: PARTS 1 THRU 9 ARE EXISTING PARTS
PARTS 10 THRU 29 ARE PARTS SUPPLIED W/ KIT

-OPTION GAS INJECTION-

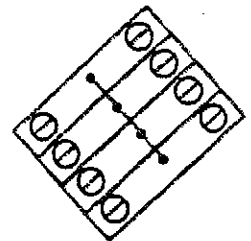
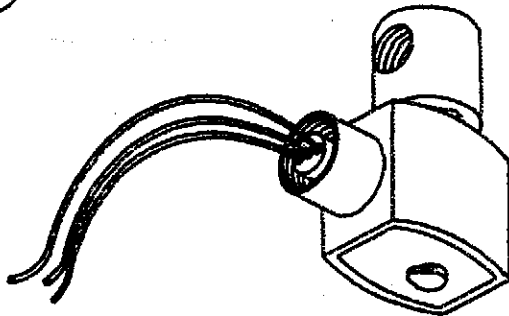
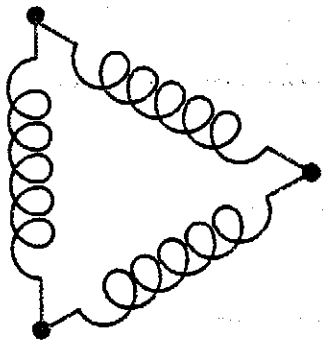
TO GAS INJECTION TUBES UNDER TABLE,
REMOVE THE FOUR EXISTING CAPS
& CONNECT HOSES, A, B, C & D

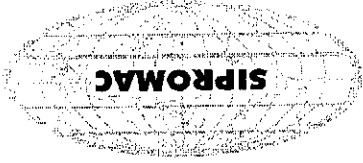
MACHINE: 600A
PART: GAS INJECTION KIT INSTALLATION
YEAR: 1988
DATE: 08-06-09
MARCOTTE
DATE: 08-06-09
M-P-I
010-0017

E. MODIFICATION #A-358	03-02-21	J.C.
D. REDRAWN/ MC-40 WAS MC-30	08-05-09	L.M.
LET. MODIFICATION	DATE	INT.



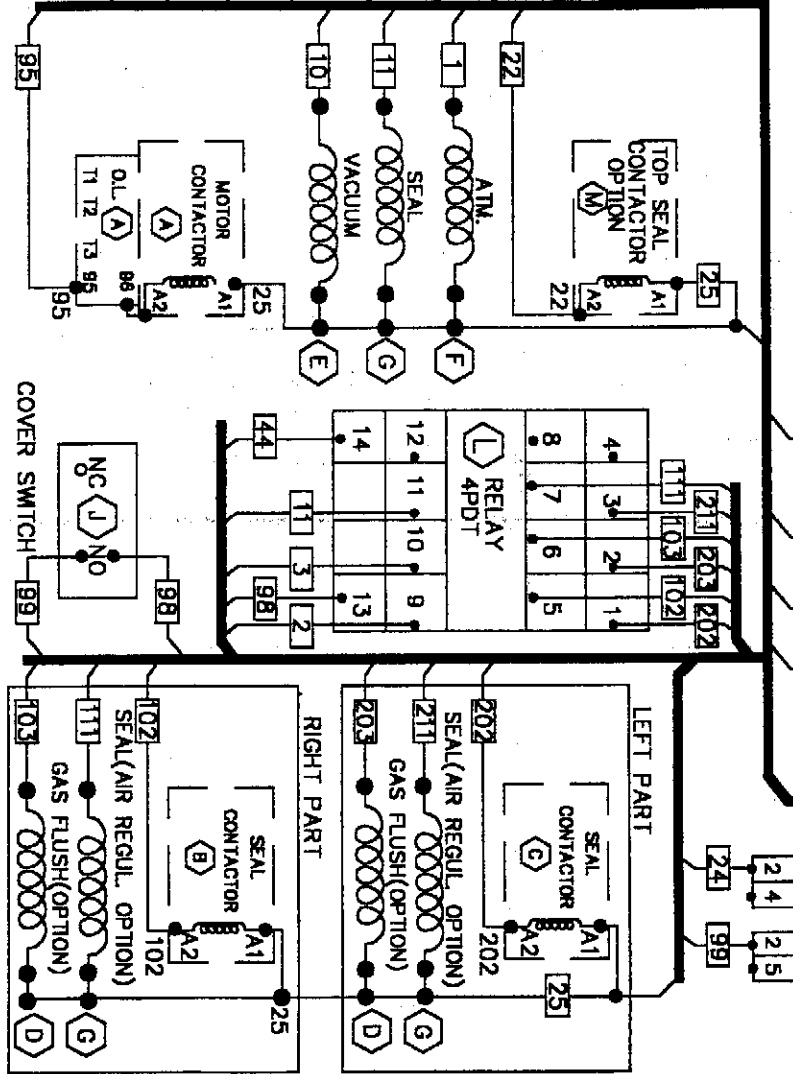
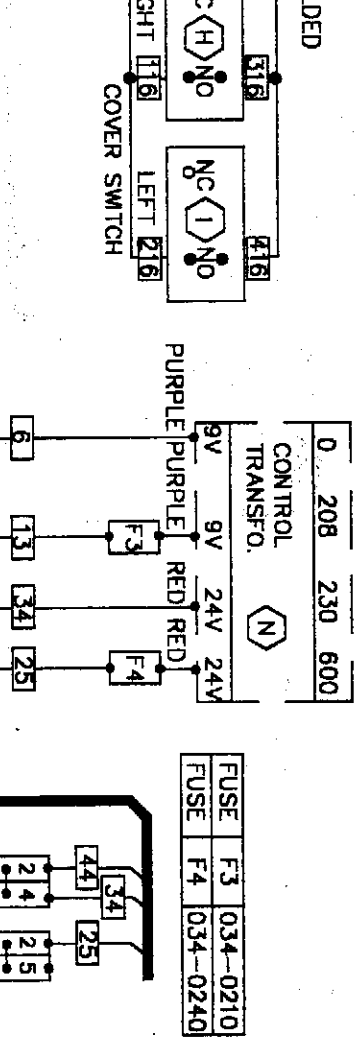
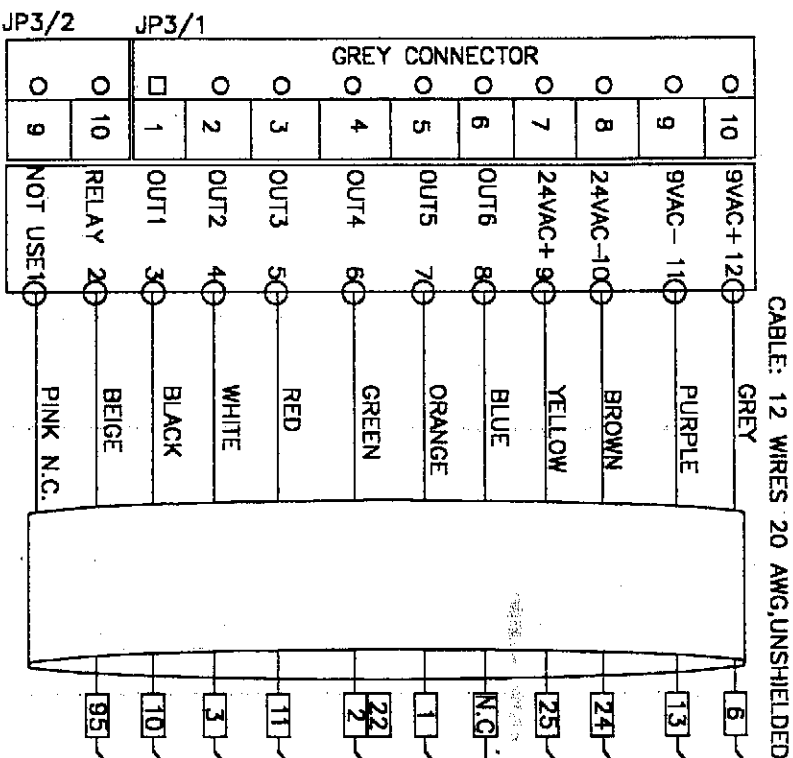
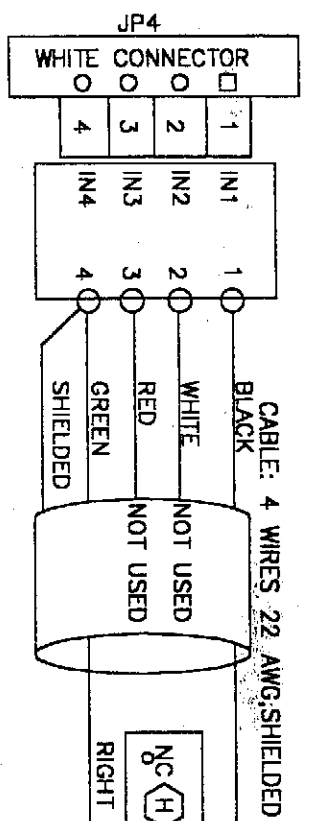
ELECTRICAL DRAWING





A series of horizontal lines for writing notes, consisting of approximately 20 parallel lines extending across the width of the page.

NOTES



MC-40

FOR PART NUMBERS FOR LETTERS A THRU N SEE FOLLOWING LIST

MACHINE

VACUUM DOUBLE CHAMBER

SIPROMAC

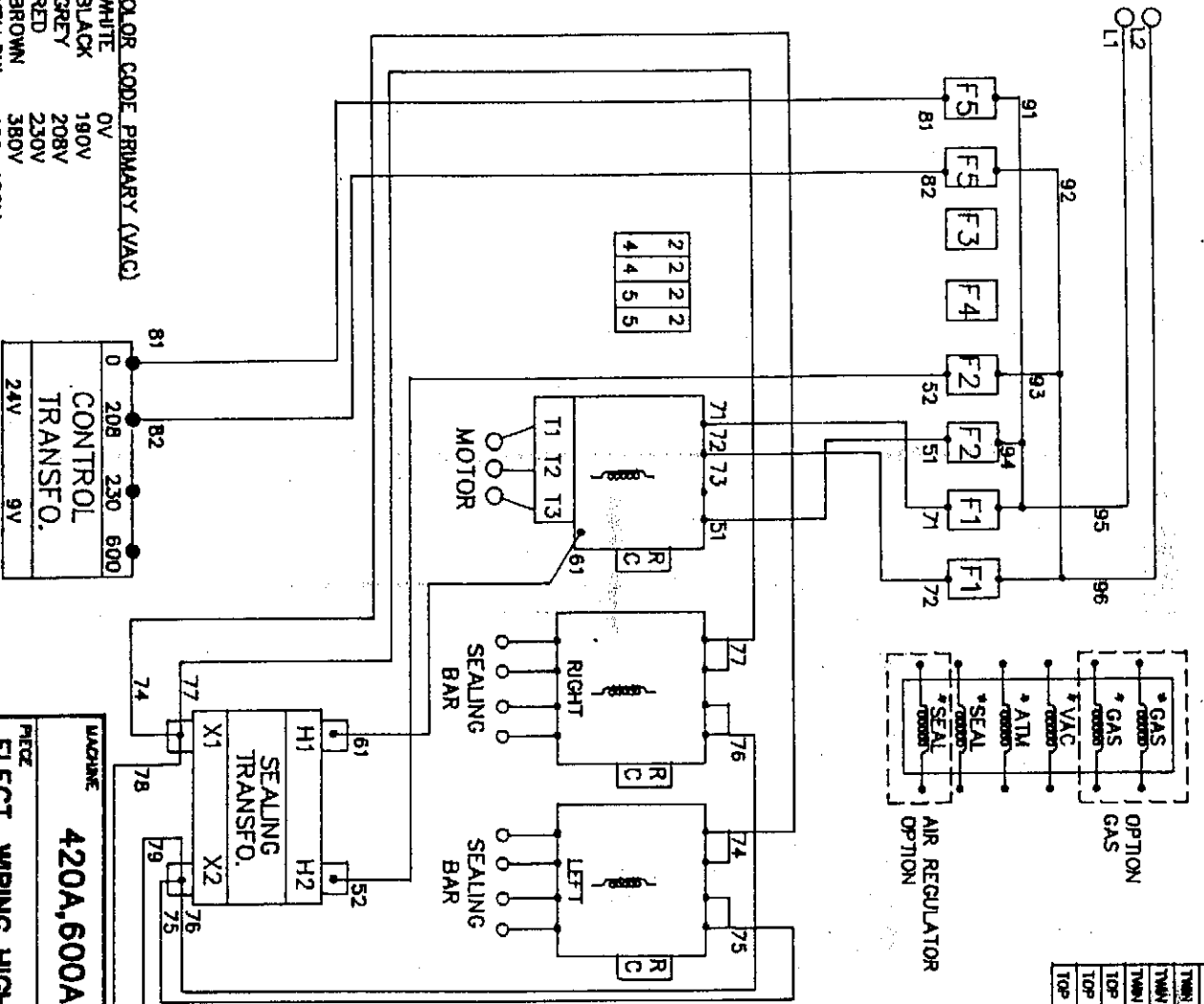
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

LOW VOLTAGE WITH MC-40

DATE 15 MAY 1988

016-0118

* RC SUPPRESSOR ADD ON EACH COIL



OPTION	VOLTAGE	FUSE F2	FUSE F5
TRM SEAL & BAG CUT	220	034-0450	034-0200
TRM SEAL & BAG CUT	380	034-0430	034-0410
TRM 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

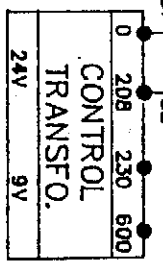
MOTOR (HP)	VOLT (V)	FUSE F1
3	230-1	034-0560
3	230-3	034-0530
3	375-3	034-0480
5	230-1	034-0570
5	230-3	034-0550
5	375-3	034-0510

• NO • COM
• NC

• NO • COM
• NC

• NO • COM
• NC

- 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



420A, 600A & 620A

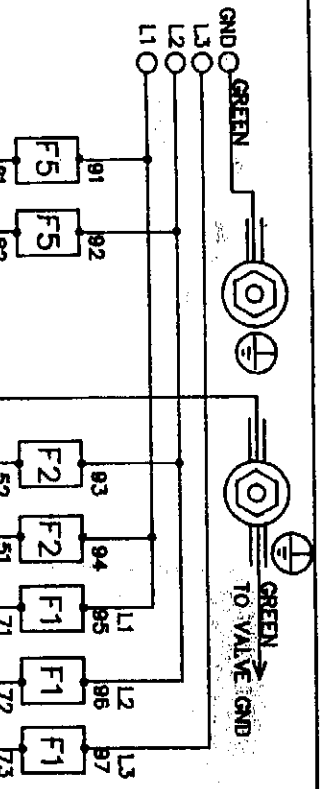
ELECT. WIRING HIGH VOLTAGE 1P

NE PAS MESURER / N.T.S.

SIPROMAC

ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

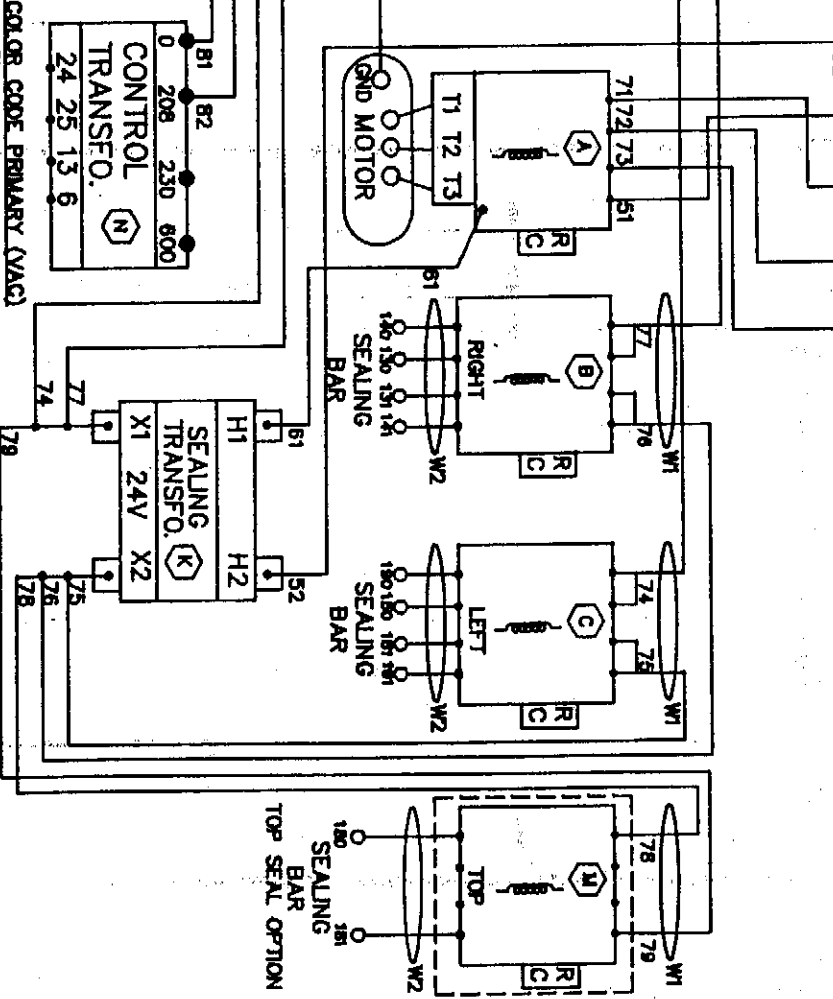
006-0068



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

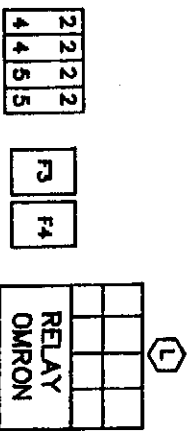
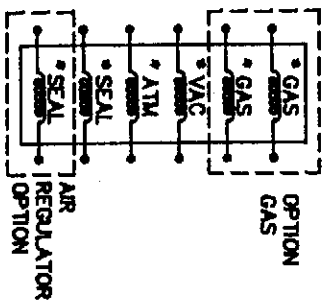
PUMP			
MOTOR (HP)	VOLT (ph)	FUSE F1	FUSE F2
3	230-1	034-0550	
3	230-3	034-0530	
3	575-3	034-0480	
5	230-1	034-0570	
5	230-3	034-0550	
5	575-3	034-0510	



COLOR CODE PRIMARY (VAC)

WHITE	0V
BLACK	180V
GREY	208V
RED	230V
BROWN	380V
YELLOW	480-480V
BLUE	575-600V
RED	24V
PURPLE	9V

*RC SUPPRESSOR ADD ON EACH COIL

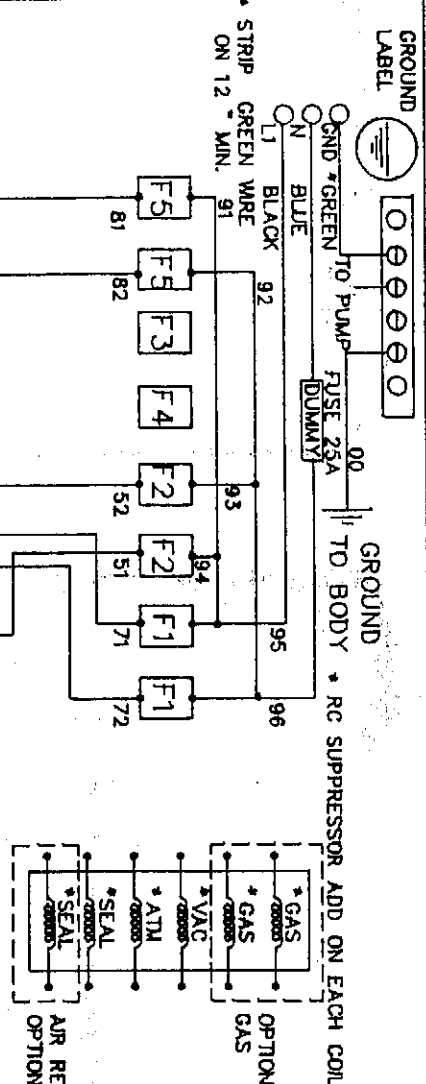


WAGNER 420A, 600A & 620A
 ELECT. WIRING HIGH VOLTAGE 3Ø

PRECISE ELECT. WIRING HIGH VOLTAGE 3Ø

DATE 87-03-10
 INCL 006-0069

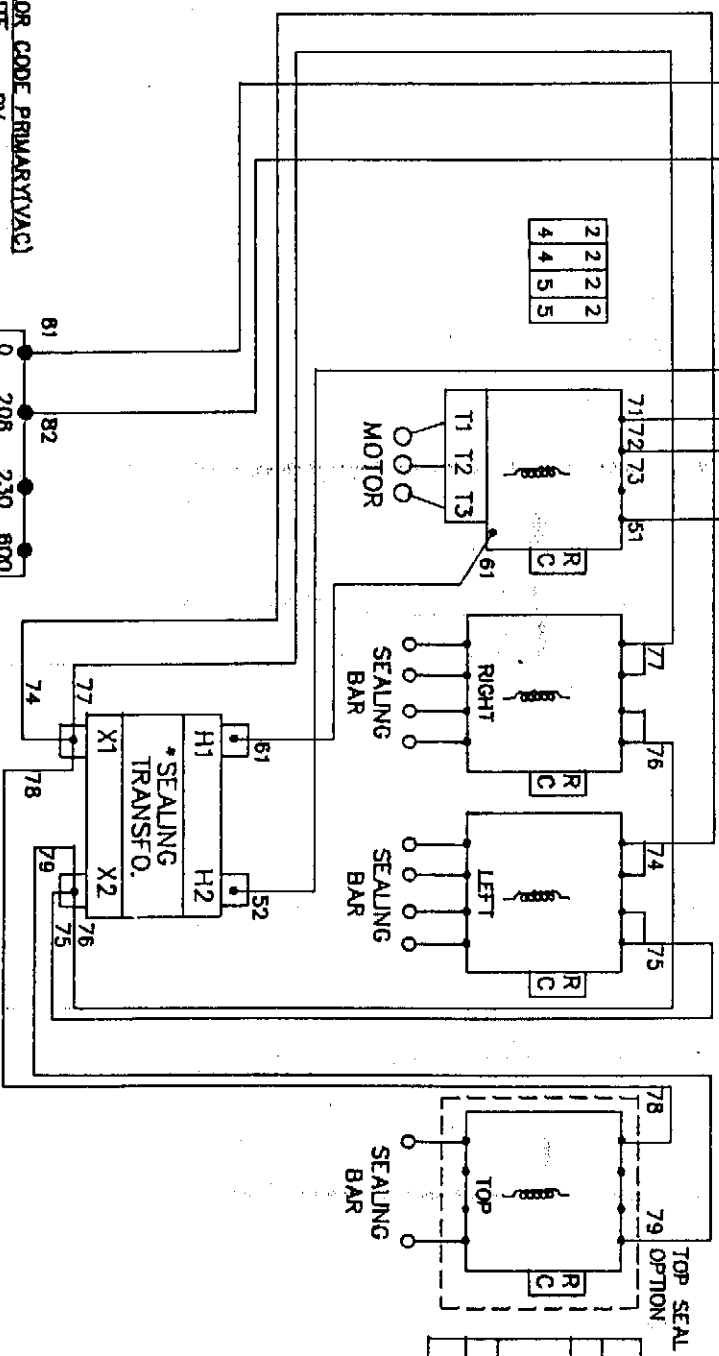
SIPROMAC
 ST-GERMAIN DE GRANTHAM
 QUEBEC CANADA



OPTION	VOLTAGE	FUSE F2	FUSE F5
TOP SEAL & BAG CUT	220	031-0460	031-0200
TRIM SEAL & BAG CUT	380	031-0430	031-0410
TRIM SEAL & BAG CUT	800	031-0425	031-0410
TOP & BOTTOM SEAL	220	031-0500	031-0200
TOP & BOTTOM SEAL	380	031-0485	031-0410
TOP & BOTTOM SEAL	600	031-0440	031-0410

MOTOR (HP)	VOLTS +PH	FUSE F1
3	230-1	031-0550
3	230-3	031-0530
3	575-5	031-0460
5	230-1	031-0570
5	230-5	031-0550
5	575-3	031-0510

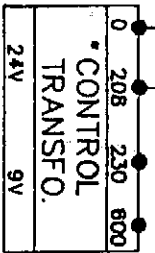
2	2	2	2
4	4	5	5



- NO • COM
- NC
- NO • COM
- NC
- NO • COM
- NC

COLOR CODE PRIMARY(VAC)

WHITE	DV
BLACK	190V
GREY	208V
RED	230V
BROWN	380V
YELLOW	480-480V
BLUE	575-600V
RED	24V
PURPLE	9V



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

MACHINE: 420A, 600A & 620A

PIECE: ELECT. WIRING HIGH VOLTAGE 10,50 HZ

NE PAS MESURER / N.T.S.

DATE: 97-03-11

NO. 006-0101

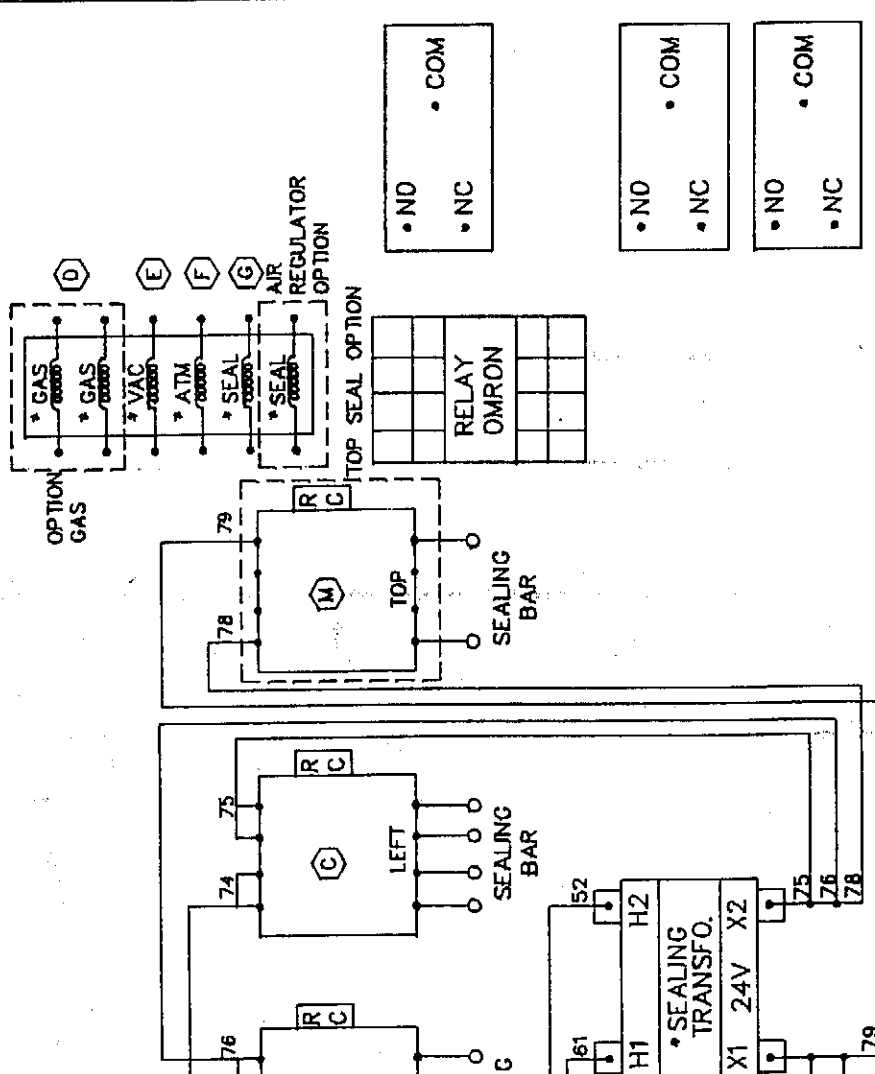
SIPROMAC

ST-GERMAIN DE GRANTHAM QUEBEC CANADA

PUMP	
MOTOR (HP)	VOLT -Ph
3	230-1
3	230-3
3	575-3
5	230-1
5	230-3
5	575-3

* RC SUPPRESSOR ADD ON EACH COIL

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



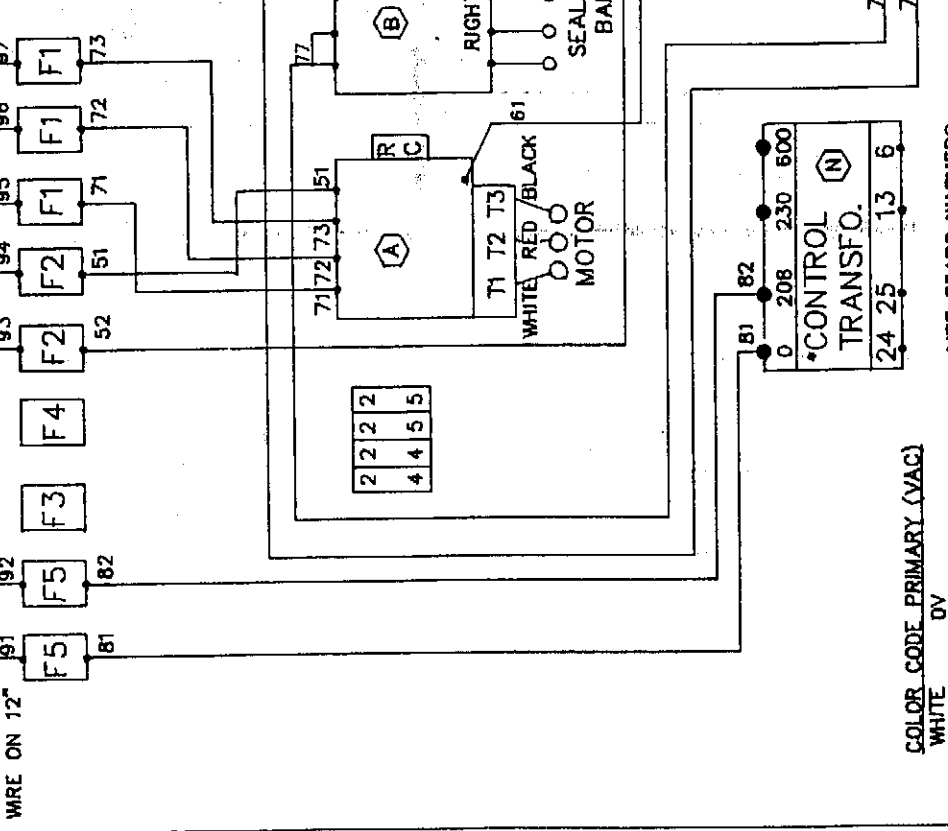
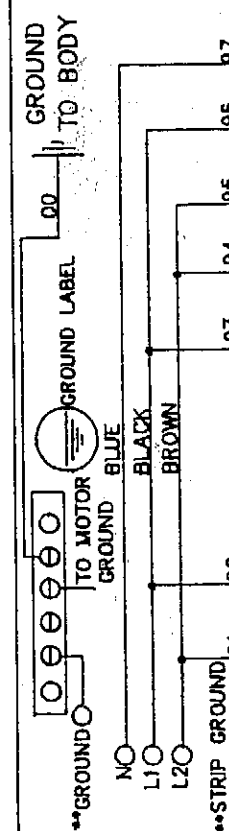
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• NC
• COM

• NO
• NC
• COM

• NO
• NC
• COM

SIPROMAC
ST-GERMAIN DE GRANTHAM,
QUEBEC CANADA

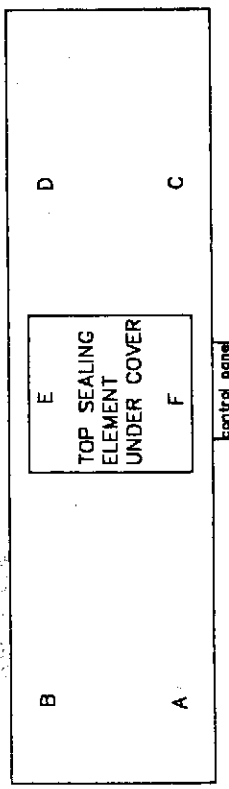
MACHINE	420A, 600A & 620A
PIECE	ELECT. WIRING HIGH VOLTAGE (50 HZ) 3P
DT.	NE PAS MESURER / N.T.S.
MAT.	DATE 88-10-02
APP.	DATE
NO.	006-0102



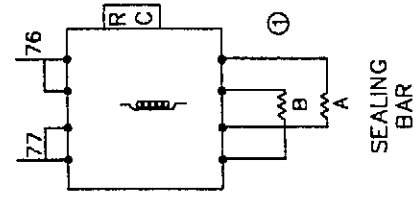
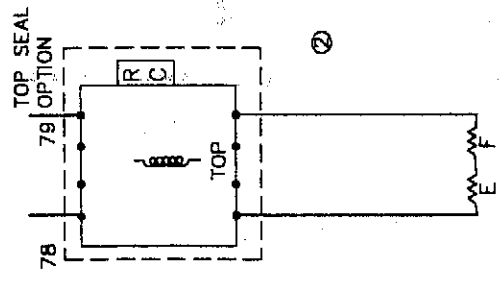
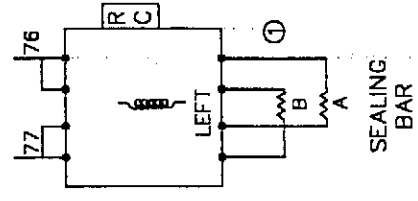
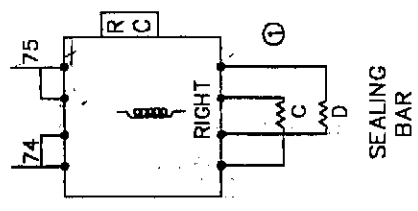
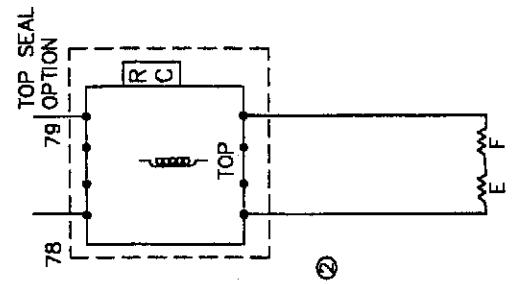
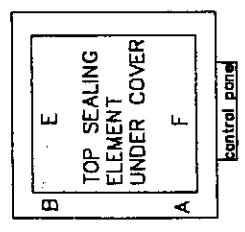
* USE STARS WASHERS FOR TRANSFO. FIXATION.

- 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

DOUBLE CHAMBER



SINGLE CHAMBER



① WIRE TEW 12 AWG SIPROMAC # 030-0420

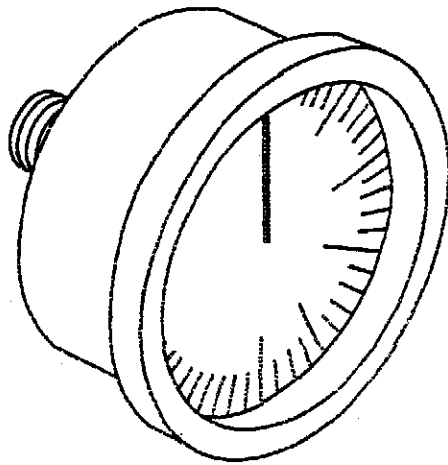
② WIRE CABTIRE 12/3 SJ SIPROMAC # 030-0120
CONNECTOR CD-13 SIPROMAC # 036-0409

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

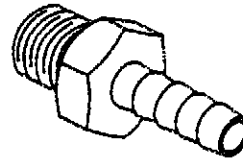
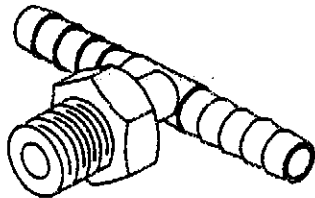
ELECTRICAL DRAWINGS PARTS LIST

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

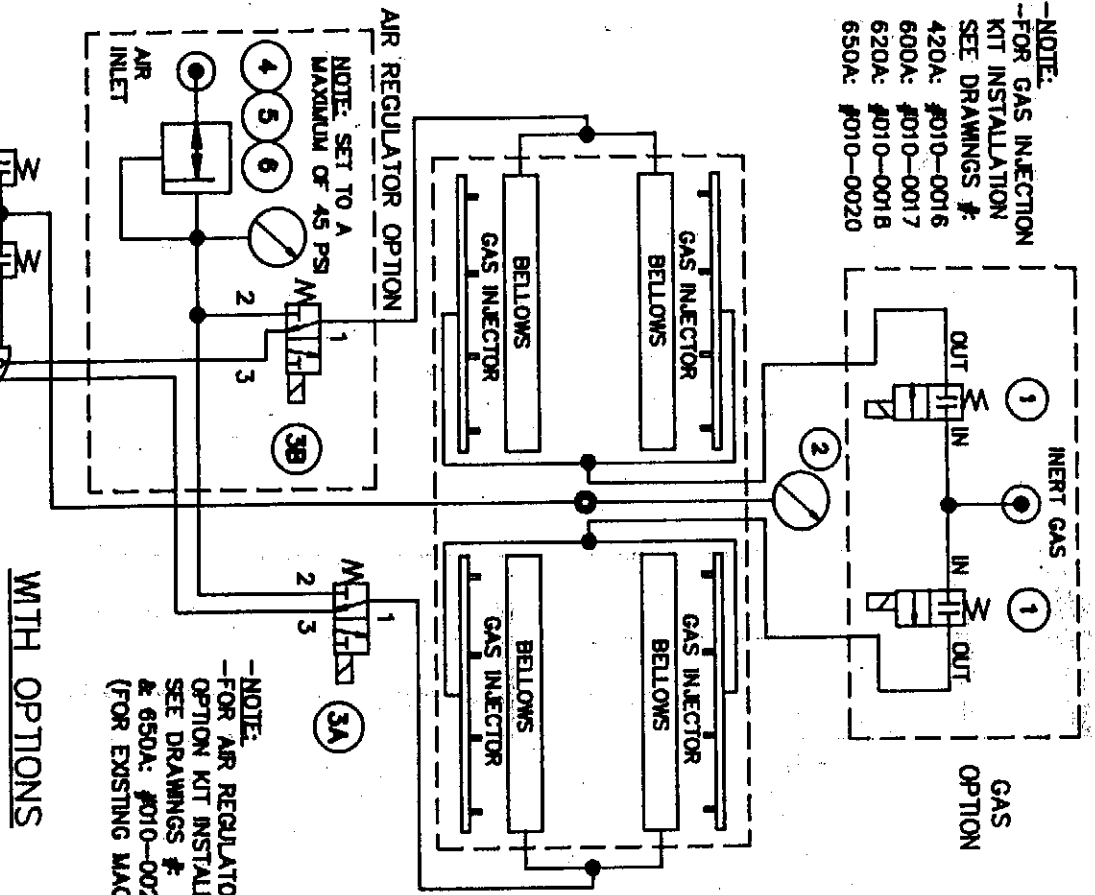


PNEUMATIC DRAWING



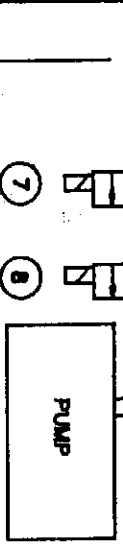
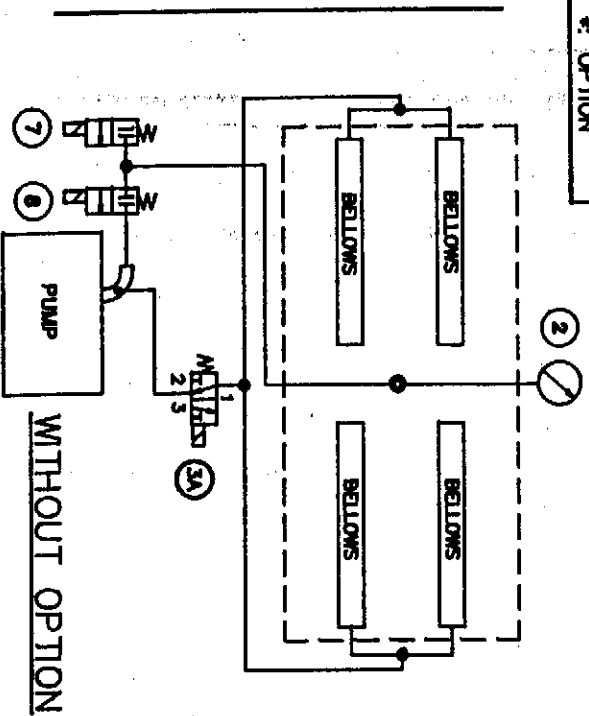
1007-0019

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



-NOTE:
-FOR AIR REGULATOR
OPTION KIT INSTALLATION
SEE DRAWINGS # 010-0018
& 650A: #010-0027
(FOR EXISTING MACHINES)

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	2*
2	114-0260	VACUUM GAUGE	1
3A	106-0070	BELLONS VALVE	1
3B	106-0070	BELLONS 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, 063W ² AND 100W ²	
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A: 160W ² AND 250W ²	
	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	



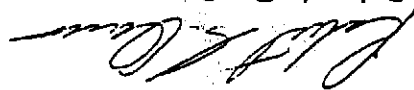
MACHINE
420A, 600A, 620A & 650A
PNEUMATIC
N.T.S.
ST-GERMAN DE GRANTRHAM
QUEBEC CANADA

LET.	A	RE-DRAWN	DATE	97-03-11	ML	NT.
MODIFICATION			DATE	97-03-11	ML	NT.
DATE	97-03-11	ML	NT.	DATE	97-03-11	ML
BY	M. LAVIGNE	DATE	97-03-11	NO.	007-0019	
SCALE	1	GT.	1			

42

REC-50

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



Sincerely,

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

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

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

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

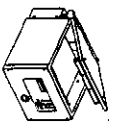
SIpromac, Inc.

May 14, 1992

United States Department of Agriculture
Food Safety and Inspection Service
Washington, D.C. 20250



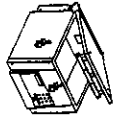




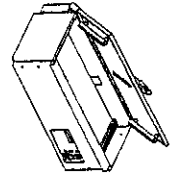
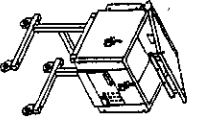
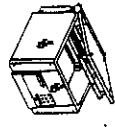
250



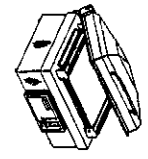
300



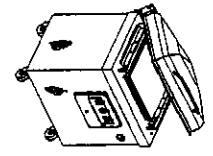
350/350D



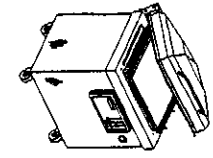
380A



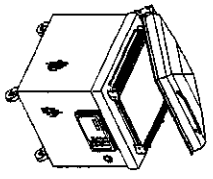
450T



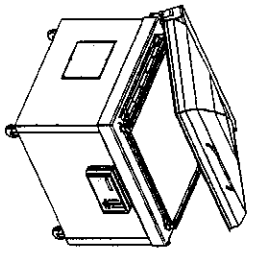
400A



450A



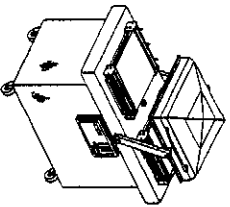
550A



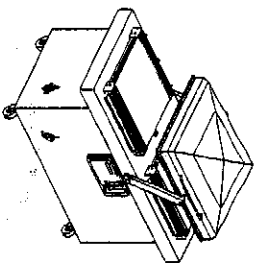
580A



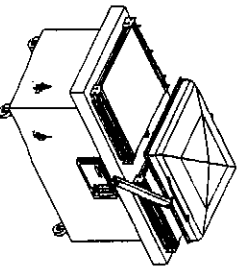
VACUUM PACKAGING MACHINES



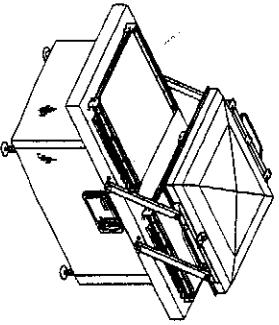
420A



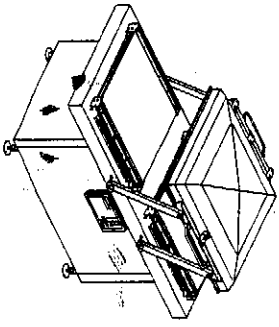
600A



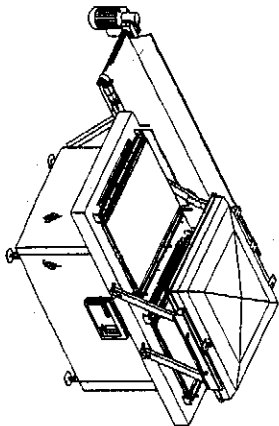
620A



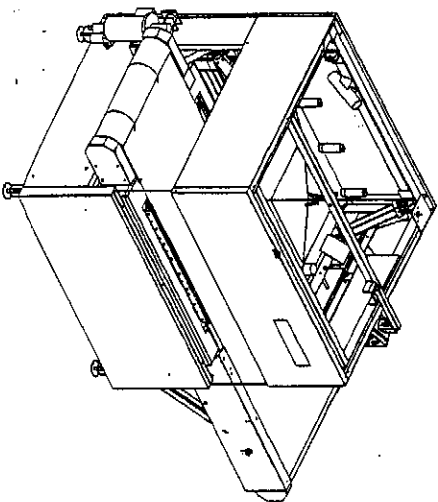
650A



680A



700A



750A