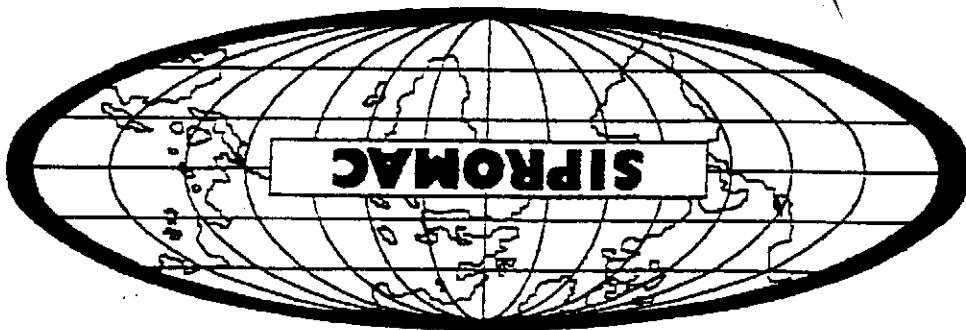
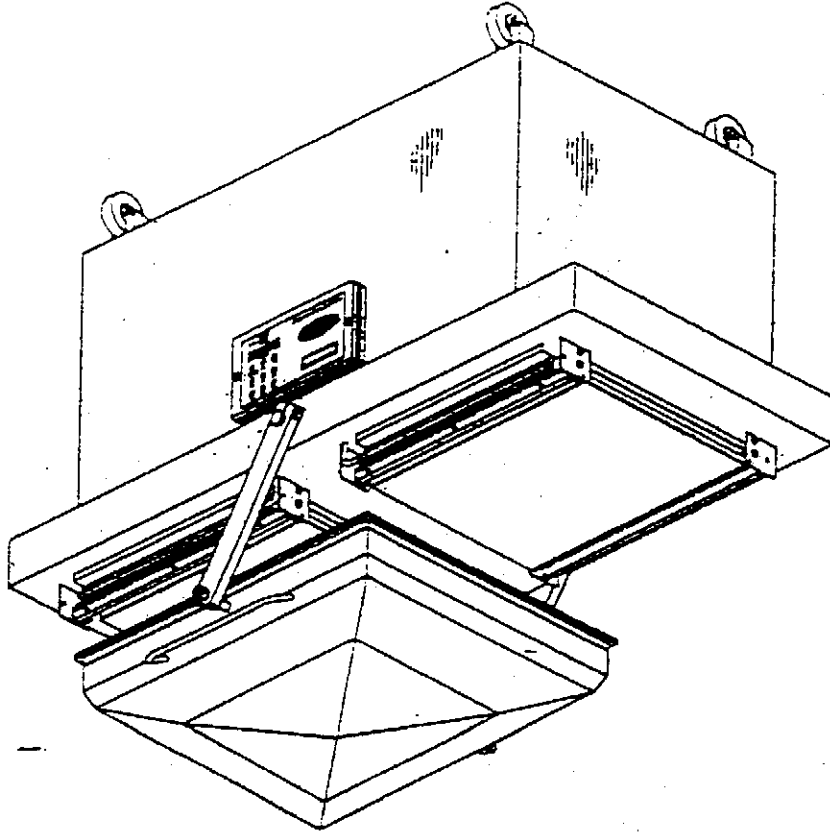


CA/56

MODEL 600A

M.C.40



VACUUM PACKAGING MACHINE

MODEL 600A

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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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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.

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).

3.2.3 Electrical bag cut (optional)

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

3.2.2 Top and bottom sealing (optional)

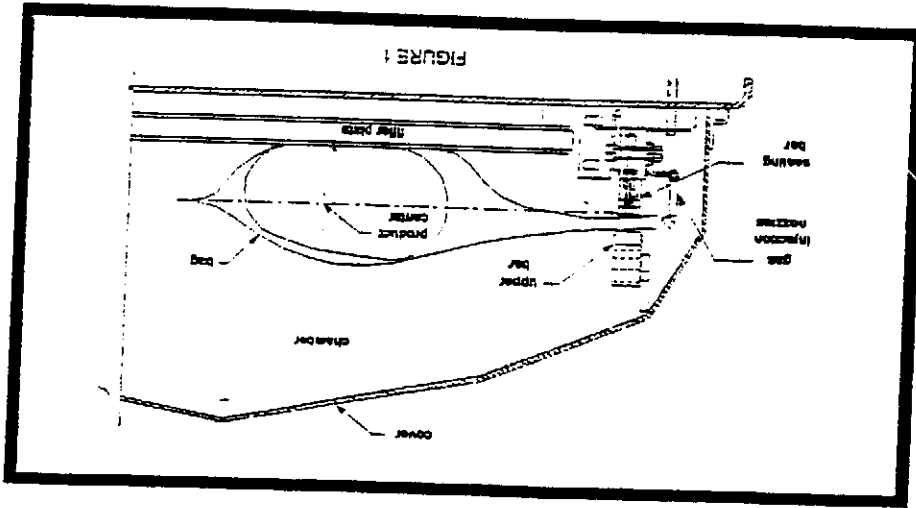
The necessary gas tank and pressure valve mounted on tank is not supplied by Sipromac. The pressure of the gas regulator should be set at approximately 5 lbs/sq. inch. (1/3 kg/sq. cm). Each machine has an adaptor for gas connection when gas flush option is ordered.

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 by program.

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.

3.2.1 Gas flushing (option)

3.2 Special packaging



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.

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

Example: EXAMPLE 1 (9 characters)

→ keys 2, 2, ENTER
 → keys 8, 8, 8, ENTER
 → X
 → A
 → M
 → P
 → L
 → E
 → space
 → keys 1, 1, 1, 1, 1, ENTER
 → 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:
 → keys 0, 1 or 1, ENTER
 → 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%"
- "VACUUM PLUS: xxs"
- (units with gas option) "GAS FLUSH: xx.x%"
- "SEAL TIME: x.xxs"
- "Pxx NAME"

- (10.0% - 99.5%)
- (0s - 99s)
- (0.0% - 10% below the vacuum level)
- (0.00s - maximum unit allocated setting)
- (12 characters)

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

"DIAGNOSTICS MENU" (access code required) "WCHQ"

"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 UNLOADING TIME"

(automatic units only)

"SYSTEM MONITOR"

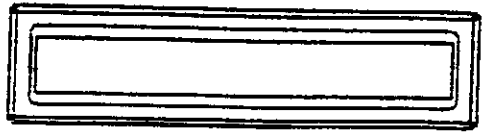
(no access code required)

"SOFTWARE: R.x.xx"

"WORK HRS: xxxxx"

"CYCLES: xxxxxxxx"

A WORLD OF LEADING EQUIPMENT



SELECT



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 vacuummeter, 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 venting machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

Seal area extremely contaminated by fat or meat juice. Use filling aid.

Sealing temperature is too low (when using very thick films).

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

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

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 accessing 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 connectors, 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 spots in uneven position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

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

Check vacuum connections for tightness.

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

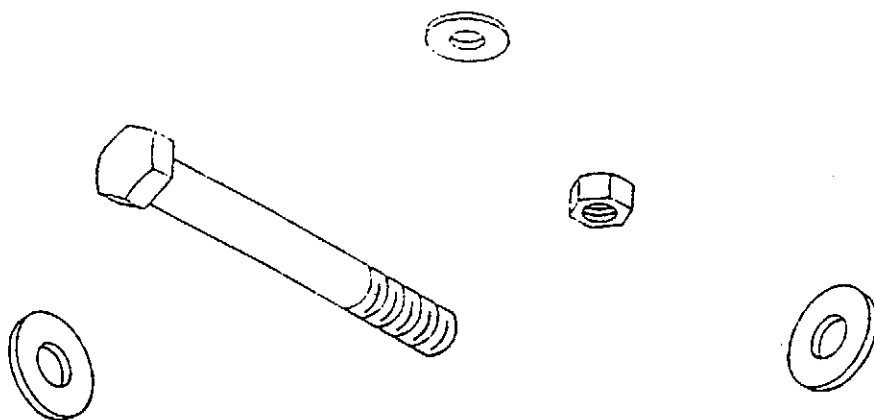
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

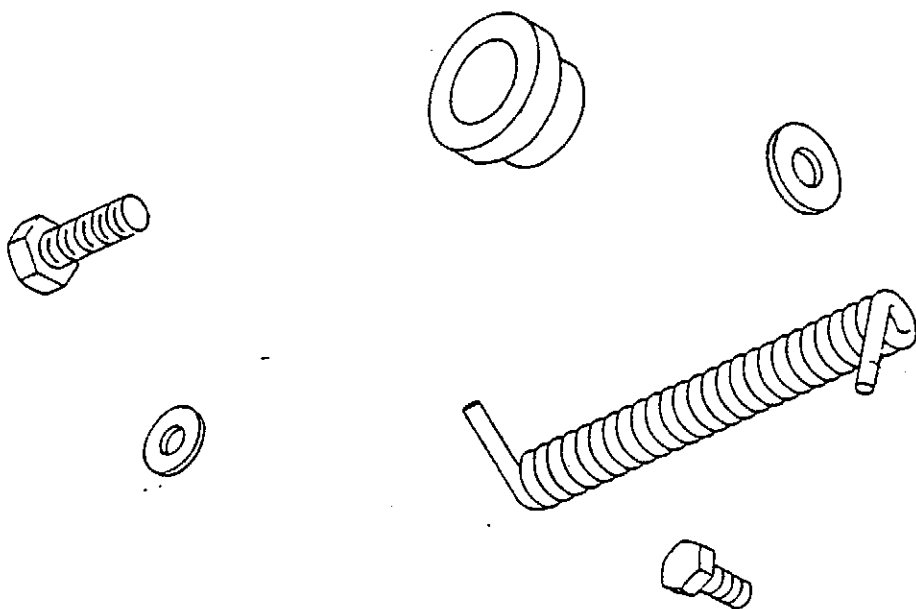
INSTALLATION NOTICE FOR MODELS:
420A, 450T, 450A, 550A, 600A, 620A, 650A AND 700A

IN ORDER TO RESPECT NSF REGULATIONS:

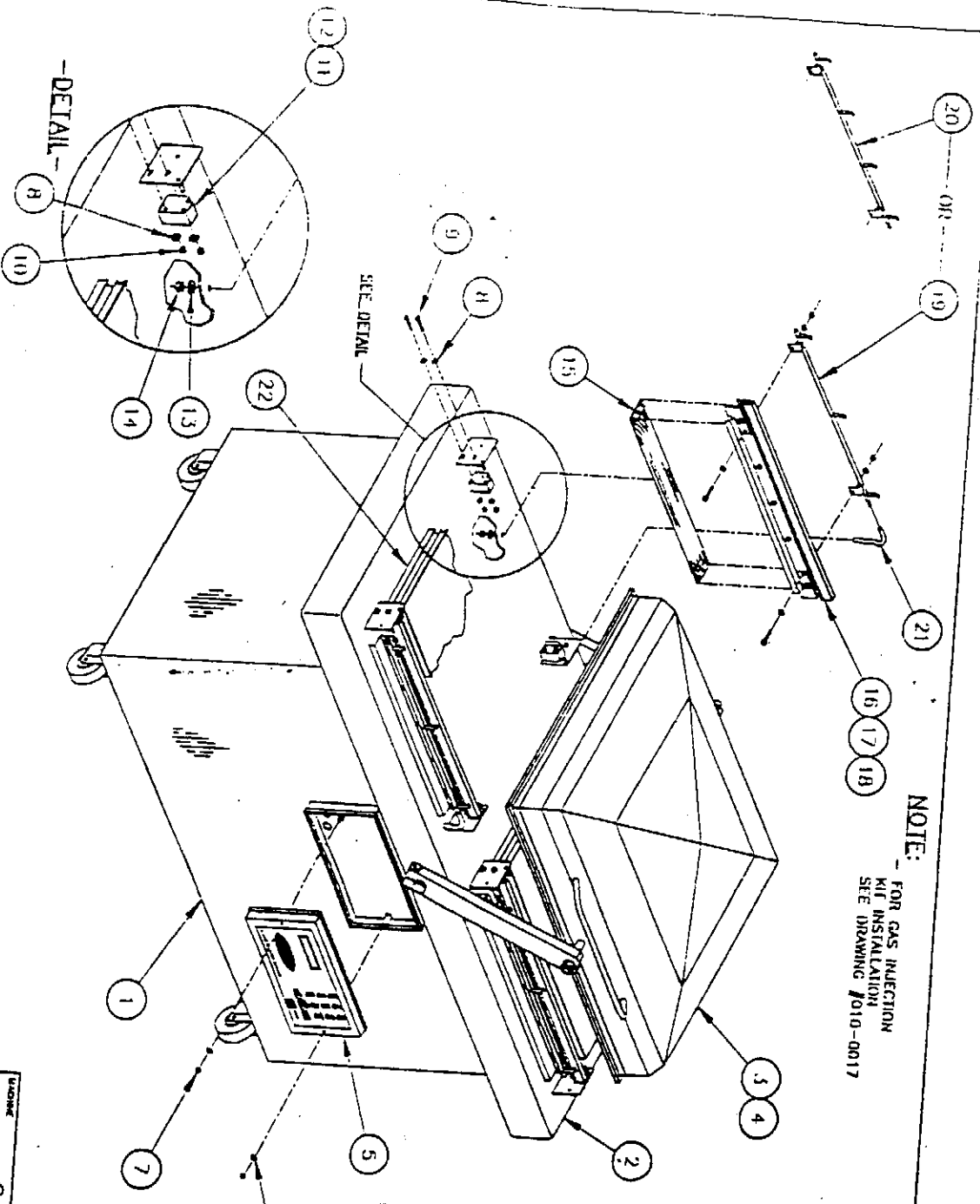
NOTE: A PLASTIC CAP IS INSTALLED ON THE TABLE TOP VACUUM INLET USED FOR CLEANING PURPOSES ONLY AND IS TO BE REMOVED PRIOR TO OPERATING THE MACHINE



MECHANICAL DRAWING



5. REORDRAN/ UC: 40 WAS UC: 30
 98-05-19 DATE
 L.M. M.I.



ITEM	PART #	DESCRIPTION	QTY
1	005-0363	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	005-0583	P.C. BOARD SUPPORT ASSY	1
6	052-2045	FLAT WASHER 1/4" COPPER	1
7	051-0591	ACORN NUT 1/4"-20 NC. S/S	2
8	051-0740	FLAT WASHER 1/4" S/S	2
9	051-0280	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	32
10	051-0581	HEX. NUT 1/4"-20 NC. N/ON 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	005-0568	1 SEAL BAR ASSY W/ SUPPORT	4
17	005-0569	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPT.)	4
18	005-0570	SEAL BAR ASSY W/ SUPPORT (TOP & BOT OPT.)	4
19	005-0318	GAS 3 INJECTION BAR ASSY (OPT.)	4
20	005-0446	GAS 4 INJECTION BAR ASSY (OPT.)	4
21	008-0464	GAS INJECTION CONNECTION TUBE	4
22	005-0322	FILTER PLATE ASSEMBLY	4

600A

MACHINE ASSEMBLY FRONT VIEW

SIPROMAC

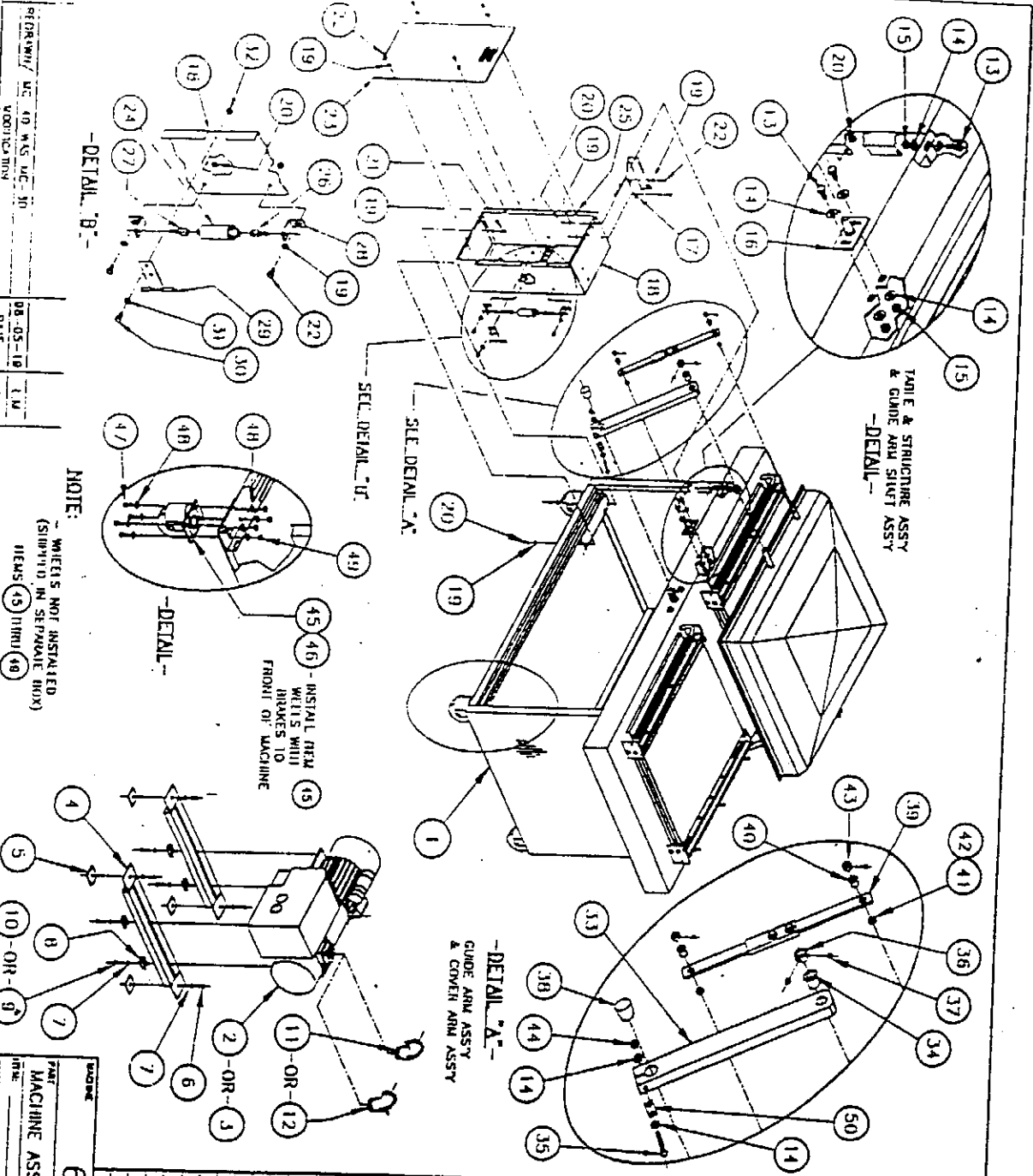
1ST-ETABLISSEMENT DE GRANBY

QUEBEC CANADA

DATE 98-05-19

005-0324

1005-0324



ITEM	PART #	DESCRIPTION	QTY
1	005-0334	MACHINE ASSEMBLY FRONT VIEW	1
2	125	PUMP 100 W	1
3	005-0104	PUMP 160 W (OPTION)	1
4	005-0088	PUMP SUPPORT ASSEMBLY	1
5	051-0350	PUMP SUPPORT PLATE ASSEMBLY	2
6	051-0350	HEX BOLT 3/8" - 18 NC. X 3/4" S/S	4
7	051-0780	FLAT WASHER 3/8" S/S	4
8	001-0198	SHIPPON	4
9	053-4320	HEX BOLT 1/2" X 30 ZINC	4
10	052-4310	HEX BOLT 1/2" X 30 ZINC (OPT. (R002))	4
11	005-0388	BELOW'S ELBOW CONNECTION ASSY	1
12	005-0387	BELOW'S ELBOW CONNECTION ASSY (OPT.)	1
13	051-0380	HEX BOLT 3/8" - 18 NC. X 1" S/S	4
14	051-0283	FLAT WASHER (THICK) 3/8" S/S	4
15	051-0820	HEX NUT 3/8" - 18 NC. S/S	4
16	005-0317	GUIDE ARM SLUVT ASSEMBLY	4
17	001-1384	LEDT/ ELECTRICAL BOX UPPER SUPPORT	1
18	005-0374	ELECTRICAL BOX ASSEMBLY	1
19	051-0710	FLAT WASHER 1/2" S/S	13
20	051-0581	HEX NUT 1/2" - 20 NC. INCH LOCK S/S	13
21	051-0180	HEX BOLT 1/2" - 20 NC. X 3/4" S/S	3
22	051-0180	HEX BOLT 1/2" - 20 NC. X 1/2" S/S	2
23	004-0178	ELECTRICAL BOX COVER PNE-ASSY	7
24	114-2020	DRYER FILTER	1
25	058-0020	SPRING NUT 1/2" - 20 NC. STEEL	1
26	101-0200	STRAIGHT 1/2" NUT X 1/4" HOSE	4
27	101-0210	STRAIGHT 1/2" NUT X 1/4" HOSE	1
28	001-2012	DRYER SUPPORT	1
29	005-0313	GAS INLET ASSEMBLY (OPTION)	2
30	051-0180	HEX BOLT 1/2" - 20 NC. X 1/2" S/S (OPTION)	1
31	051-0210	FLAT WASHER 1/2" S/S (OPTION)	1
32	051-0281	HEX NUT 1/2" - 20 NC. INCH LOCK S/S (OPTION)	1
33	002-0318	COVER ARM	1
34	075-0420	C/S Z O	2
35	051-0432	HEX BOLT 3/8" - 18 NC. X 3 1/4" S/S	2
36	005-0180	SET SCREW COLLAR	2
37	051-0178	SET SCREW COLLAR	2
38	057-0013	CENTRAL SLUVT END CAP	2
39	005-0351	GUIDE ARM ASSEMBLY	2
40	075-0410	BUSHING	1
41	058-0050	SPACERS	2
42	058-0060	SPACERS	2
43	105-0420	SCREW COLLAR WITH S/S SET SCREW	2
44	051-0812	HEX NUT 3/8" - 18 NC. INCH LOCK S/S	2
45	130-4PH12	1/2" PL. CASTER SWIVEL W/ BRAKE	2
46	130-4PH10	1/2" PL. CASTER SWIVEL W/ O BRAKE	2
47	052-0520	BOLT 5/16" - 18 NC. X 3/4" ZINC	18
48	051-0780	FLAT WASHER 3/8" S/S	18
49	052-3110	NUT 5/16" - 18 NC. ZINC	18
50	001-1878	LOWER WARE SUPPORT (TOP & BOT OPT.)	1

600A
MACHINE ASSEMBLY REAR VIEW
DATE: 08-05-18
DRAWN BY: MARGOTIE
REV: 1

005-0325
SIPROMAC
31-CENTRAL DE GRAMMONT
CHATELAIN CANADA

MODEL 600A

COVER ADJUSTMENT PROCEDURE

Reference Drawing: # 005-0325
004-0122

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 guide arm length and its lower shaft position (See drawing # 005-0325; items: #39 & #16).

2.2 Loosen the two bolts on the guide arm (See drawing # 005-0325; items #39).

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 #35, #14 & #44).

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 pillow block (See drawing # 004-0122; item #3) until cover is sealing properly each side (less than 1/16").

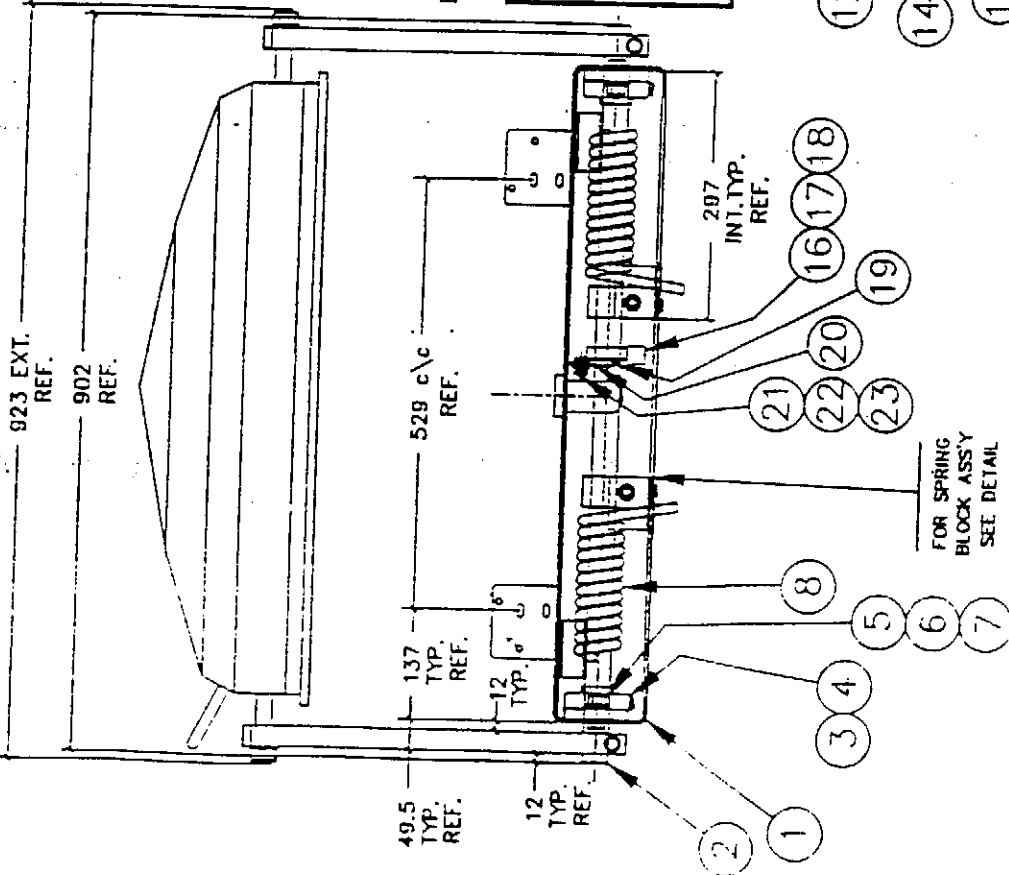
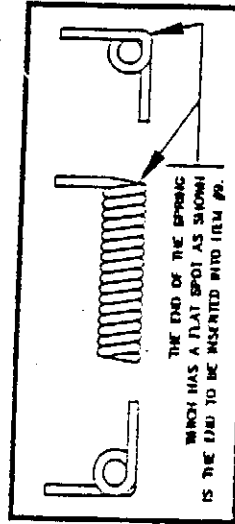
3. Adjustment of guide arm: two things have to be adjusted, the length and the lower axis position. Each of these should be adjusted separately. Fix the lower axis in a central position, then adjust guide arm length by marking its position. When chamber is at the left and at the right, tighten at the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

SPRING ADJUSTMENT PROCEDURE

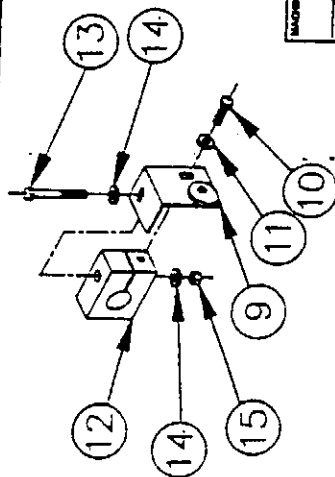
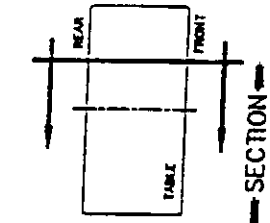
- A- PLACE COVER UP(ARM VERTICAL) TO FREE TENSION OF SPRINGS.
- B- LOOSEN BOLTS (ITEMS #10, #13 & #15) ON THE SPRING SUPPORT PLATE ASS'Y (ITEM #9).
- C- INSERT A SCREWDRIVER IN SLOT OF ITEM #12 AND PRY OPEN UNTIL BLOCK IS FREE ON CENTRAL SHAFT.
- D- TURN SPRING/BLOCK ASSEMBLY TO OBTAIN A SPACE APPROX. 8mm (5/16") AS SHOWN BELOW.



- E- RETIGHTEN BOLTS ON SPRING SUPPORT PLATE ASSY. (ITEMS #10, #13 & #15).



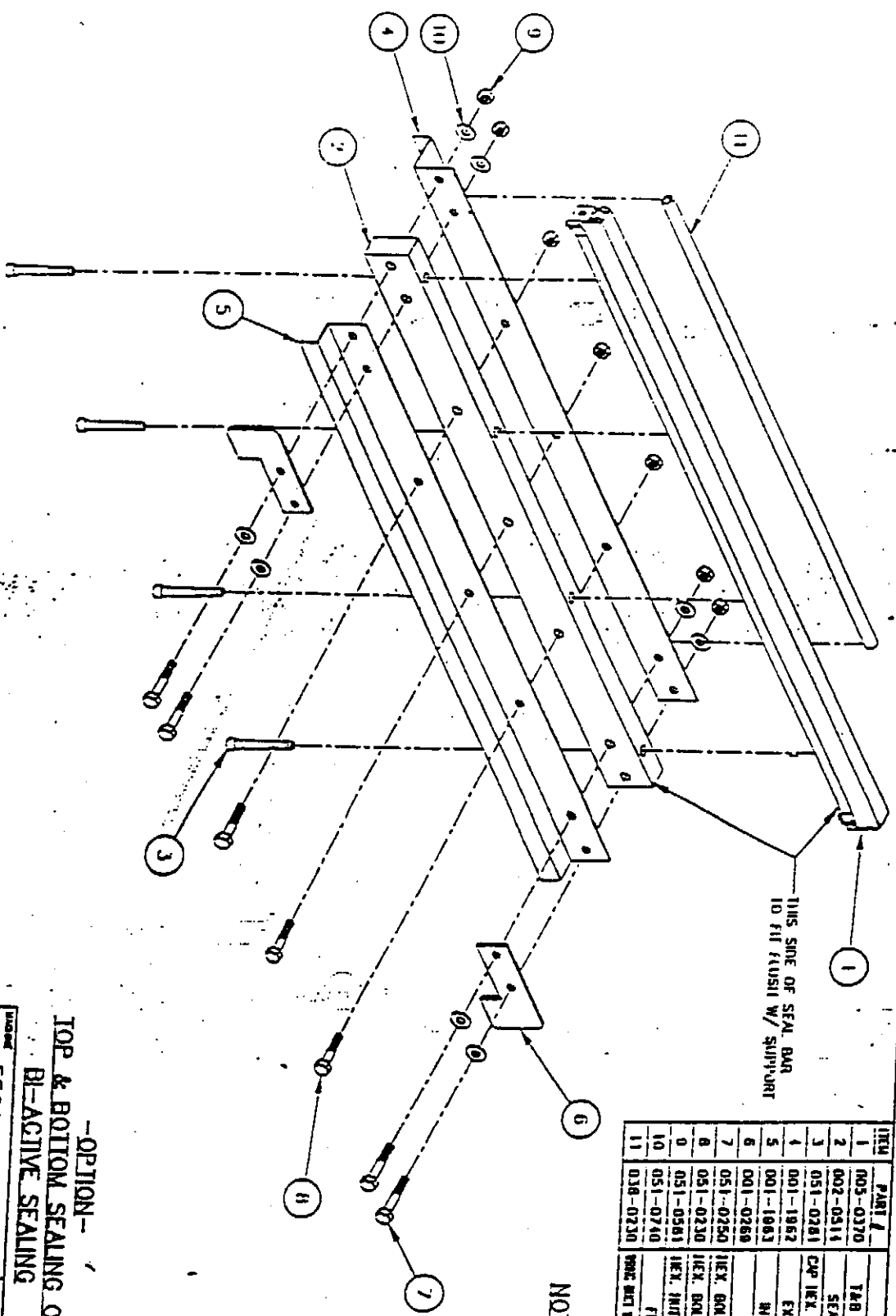
FOR SPRING BLOCK ASS'Y SEE DETAIL



ITEM	PART #	DESCRIPTION	QTY
1	005-0150	TABLE ASSEMBLY	1
2	002-0318	CENTRAL SHAFT	1
3	075-1650	2 BOLTS FLANGED BEARING	2
4	081-0100	GREASE FITTING 1/4"-28 x 90"	2
5	051-0441	HEX.BOLT 1/2"-13 x 1 1/2" S.S.	4
6	051-0630	HEX.NUT 1/2"-13 S.S.	4
7	051-0780	FLAT WASHER 1/2" S.S.	4
8	008-0315	CENTRAL SHAFT SPRING	2
9	004-0117	SUPPORT PLATE ASSEMBLY	2
10	051-0300	HEX.BOLT 5/16"-18 x 3/4" S.S.	2
11	051-0762	WASHER 5/16" THICK FLAT S/S	2
12	002-0318	SPRING BLOCK	2
13	051-0420	HEX.BOLT 3/8"-16 x 3" S.S.	2
14	051-0783	FLAT WASHER (THICK) 3/8" S.S.	4
15	051-0620	HEX.NUT 3/8"-16 S.S.	2
16	005-0154	MICRO-SWITCH COLLAR	1
17	051-0510	SET SCREW 3/8"-16 x 3/8" S.S.	1
18	051-0520	SET SCREW 5/16"-18 x 3/8" S.S.	1
19	026-0610	MICRO-SWITCH	2
20	001-1294	MICRO-SWITCH FIXATION PLATE	2
21	051-0180	HEX.BOLT 1/4"-20 x 1/2" S.S.	2
22	051-0740	FLAT WASHER 1/4" S.S.	4
23	051-0580	HEX.NUT 1/4"-20 S.S.	2

DRAWING NO. 600A PART CENTRAL SHAFT ASSEMBLY QTY 1 SCALE 1:1 NOT TO SCALE		DATE 05-11-59 BY [Signature] CHECKED [Signature]
600A CENTRAL SHAFT ASSEMBLY SCALE 1:1 NOT TO SCALE		DATE 05-11-59 BY [Signature] CHECKED [Signature]
SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA		004-0122

3504 ADDENDUM/ MODIF. NO. A-0211
 88-02-21
 DATE



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

ITEM	PART #	DESCRIPTION	QTY
1	005-0370	T&B SEAL BAR PRE-ASSEMBLY	1
2	002-0511	SEAL BAR SUPPORT (TABLE)	1
3	051-0781	CUP HEX. SRT. DNLT 1/4" - 20 NC X 1 1/4" S/S	4
4	001-1962	EXTERIOR BELLOWS COVER	1
5	001-1083	INTERIOR BELLOWS COVER	1
6	001-0266	SEAL BAR GUIDE	2
7	051-0250	HEX. DNLT 1/4" - 20 NC. X 1 1/4" S/S	4
8	051-0230	HEX. DNLT 1/4" - 20 NC. X 1 1/4" S/S	4
9	051-0581	HEX. DNLT 1/4" - 20 NC. INTRON LOCK S/S	3
10	051-0740	FLAT WASHER 1/4" S/S	7
11	036-0230	PHOS. MET. / ANTI-RUNE WASH 1 1/2 X 1 (10) PK	8

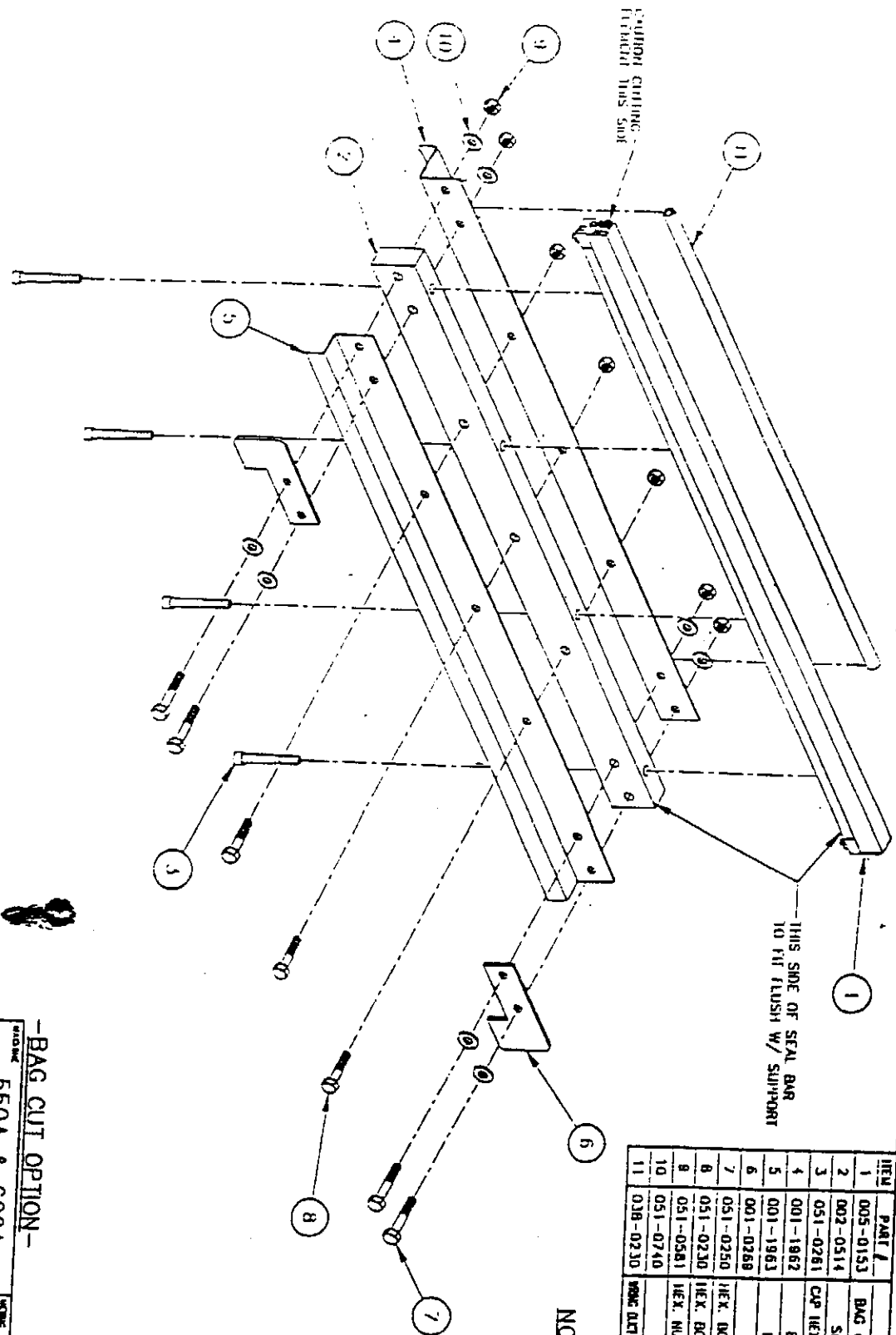
NOTE:
 QTY FOR ONE
 SEAL BAR ONLY
 SEE LIST

ITEM	DESCRIPTION	QTY
1	550A & 600A	4
2	550A	2
3	SIPROMAG	1

SEAL BAR ASSEMBLY W/ SUPPORT
 005-0570

1005-10570

MODEL 550A / MOD. NO. A 0741
 DATE 02-74
 PART NO. 005-0569



ITEM	PART #	DESCRIPTION	QTY
1	005-0153	BAG CUT SEAL BAR PRE-ASSEMBLY	1
2	002-0514	SEAL BAR SUPPORT (TABLE)	1
3	051-0261	CAP HEX. SRT. BOLT 1/4" - 20 NC X 7/8"	4
4	001-1962	EXTERIOR BELLOW'S COVER	1
5	001-1963	INTERIOR BELLOW'S COVER	1
6	001-0268	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. ANCHOR LOCK S/S	7
10	051-0740	FLAT WASHER 1/4" S/S	7
11	036-0230	HEX. BOLT 1/4" - 20 NC. (L.S. 1.45 T (M) PC	1

NOTE:
 QTY FOR ONE
 SEAL BAR ONLY
 SEE LIST

-BAG CUT OPTION-

550A & 600A

SEAL BAR ASSEMBLY W/ SUPPORT

MODEL	QTY
550A	4
600A	2

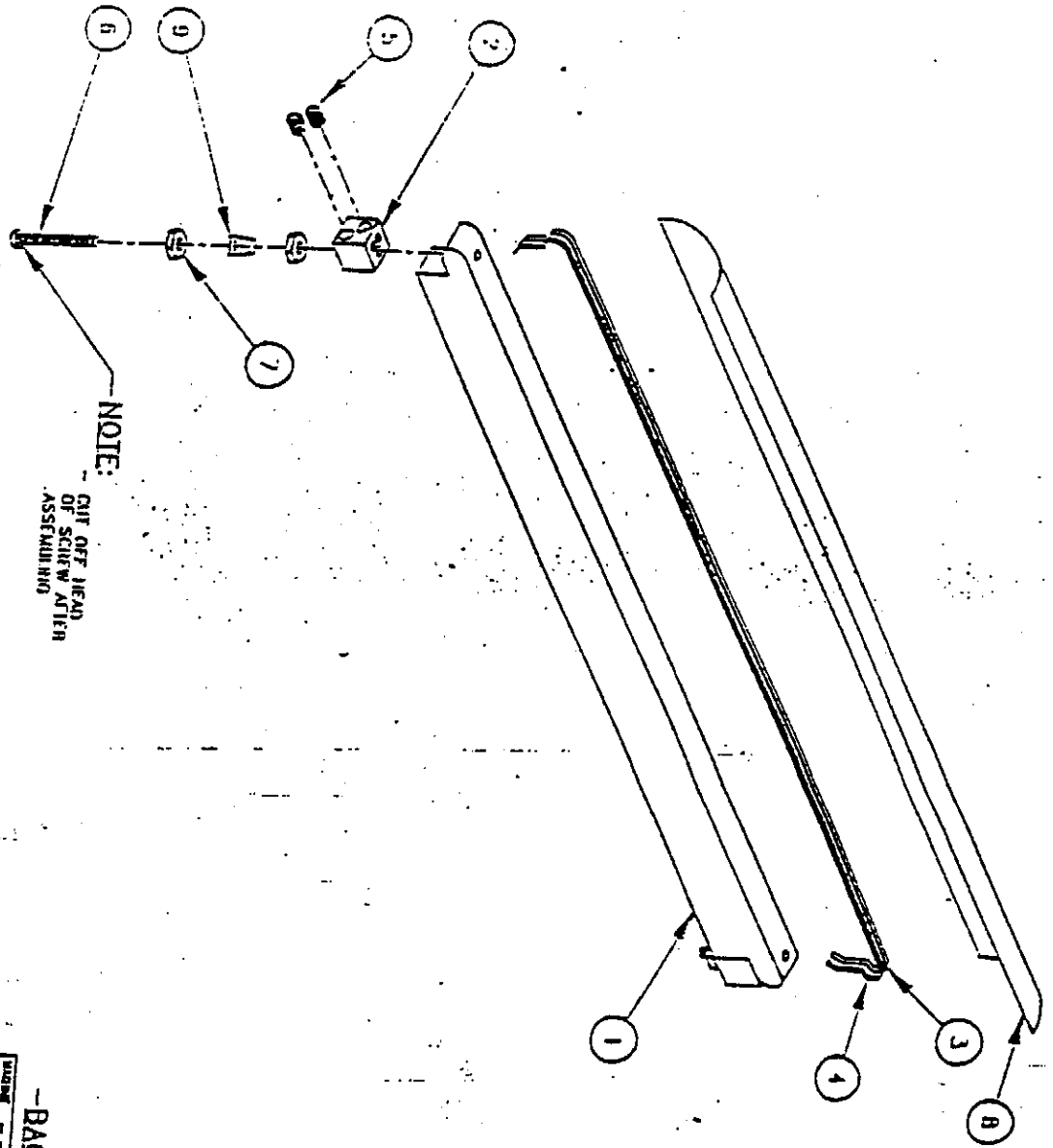
SIPROMAC

31 - CHINAM DE CAMBODIA
 OUTREC CANADA

005-0569

1005-0569

REVISION
 DATE 06-02-10
 BY
 CHK



NOTE:
 CUT OFF HEAD
 OF SCREW AFTER
 ASSEMBLING

ITEM	PART #	DESCRIPTION
1	002-0314	SEAL BAG (PAIR E)
2	002-0031	CONNECTION
3	030-0230	COMPLEX SEALING ELEMENT
4	030-0270	*T PROFILE CUTTING ELEMENT
5	052-0285	SCREW 1/4" - 20 X 3/16" SET HEX SHI DRG M
6	052-0250	SCREW 1/8" - 18 X 1/2" RND SLOT BRASS
7	051-0550	NUT 1/8" - 32 5/8
8	126-0200	LETTON TAPE 55 ADHESIVE X 7" X 850 YD
9	027-0100	CORRECTION ADAPTION 1/4" X 710 STD

NOTE:
 QTY FOR ONE
 SEAL BAG ONLY
 SEE LIST

-BAG CUT OPTION-

550A & 600A

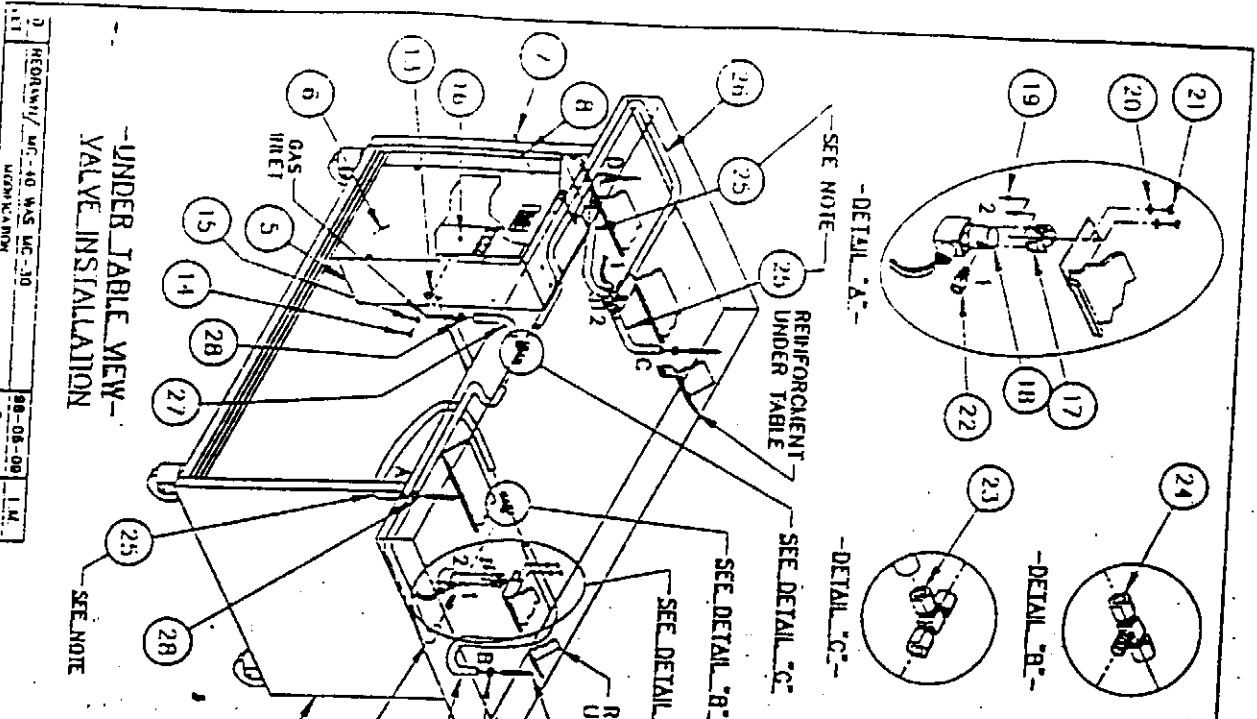
SEAL BAG PRE-ASSEMBLY

DATE 06-02-10
 BY
 CHK

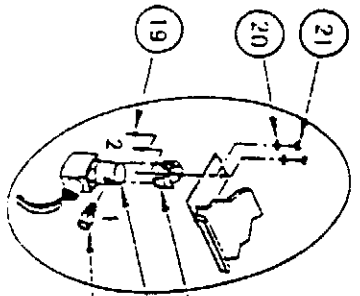
ITEM	QTY
600A	4
550A	2

SIPROMAC
 MACHINE 1
 QTY

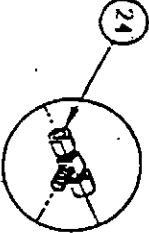
005-0153
 SEE LIST



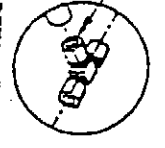
-UNDER TABLE VIEW-
VALVE INSTALLATION



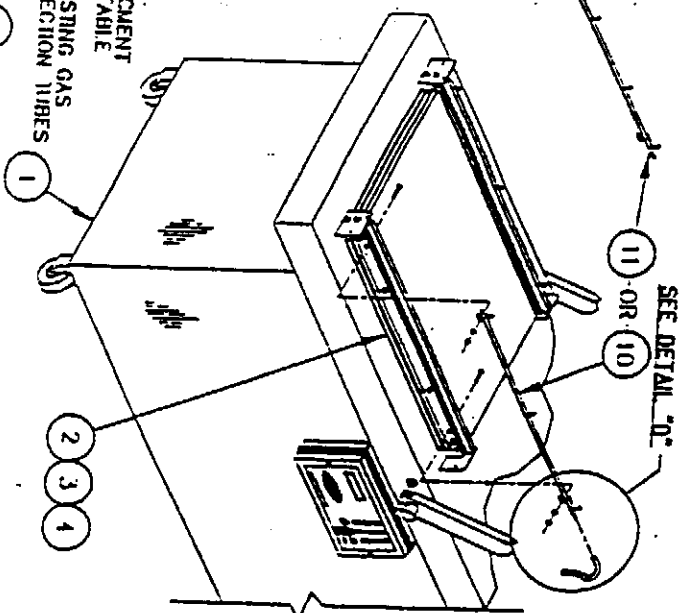
-DETAIL 'A'-



-DETAIL 'B'-

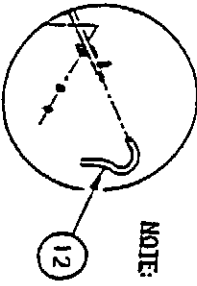


-DETAIL 'C'-



-FRONT VIEW-
GAS INJECTION BAR INSTALLATION

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



-DETAIL 'D'-

NOTE: THESE ITEMS MUST BE
THE SAME LENGTH

NOTE: PARTS 1 THRU 8 ARE EXISTING PARTS
PARTS 10 THRU 28 ARE PARTS SUPPLIED W/ KIT

ITEM	PART #	DESCRIPTION	QTY
1	005-0336	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0568	SEAL BAR ASSY W/ SUPPORT	1
3	005-0588	SEAL BAR ASSY W/ SUPPORT (R&L OPT)	1
4	005-0570	SEAL BAR ASSY W/ SUPPORT (R & B OPT)	1
5	005-0374	ELECTRICAL BOX ASSEMBLY	1
6	004-0278	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 INJECTION BAR ASSEMBLY (OPTION)	1
11	005A0448	GAS INJECTION CONN. TUBE (OPTION)	1
12	008-0184	GAS INJECTION CONN. TUBE (OPTION)	1
13	005-0323	GAS INLET ASSEMBLY (OPTION)	1
14	051-0180	HEX. BOLT 1/4" - 20 NC. X 1/2" S/S (OPTION)	1
15	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
16	051-0581	HEX. NUT 1/4" - 20 NC. MIDD LOCK S/S (OPTION)	1
17	108-0315	VALVE SUPPORT FOR 1/4" NPT	1
18	108-0010	SELENOIDE VALVE 2 WAY 1/4" NPT	2
19	051-0100	SCREW #8-32 X 3/8" PAN PHIL. S/S	4
20	051-0220	FLAT WASHER #8 S/S	4
21	051-0550	HEX. NUT #8 S/S	4
22	101-0036	STRAIGHT 1/4" TUBIT X 3/8" TP COUP.	1
23	101-0082	"T" 3/8" TP COUP.	1
24	101-0085	T 3/8" TP COUP. X 1/4" TUBIT X 3/8" TP COUP.	2
25	104-0080	TUBE 3/8" O.D. X 1/4" I.D. (PROV) 100 mm LG.	4
26	104-0080	TUBE 3/8" O.D. X 1/4" I.D. (PROV) 100 mm LG.	2
27	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (PROV) 800 mm LG.	1
28	105-0200	CONTAINS 3/8" S	5

-OPTION GAS INJECTION-

600A
SIPROMAC
GAS INJECTION KIT INSTALLATION

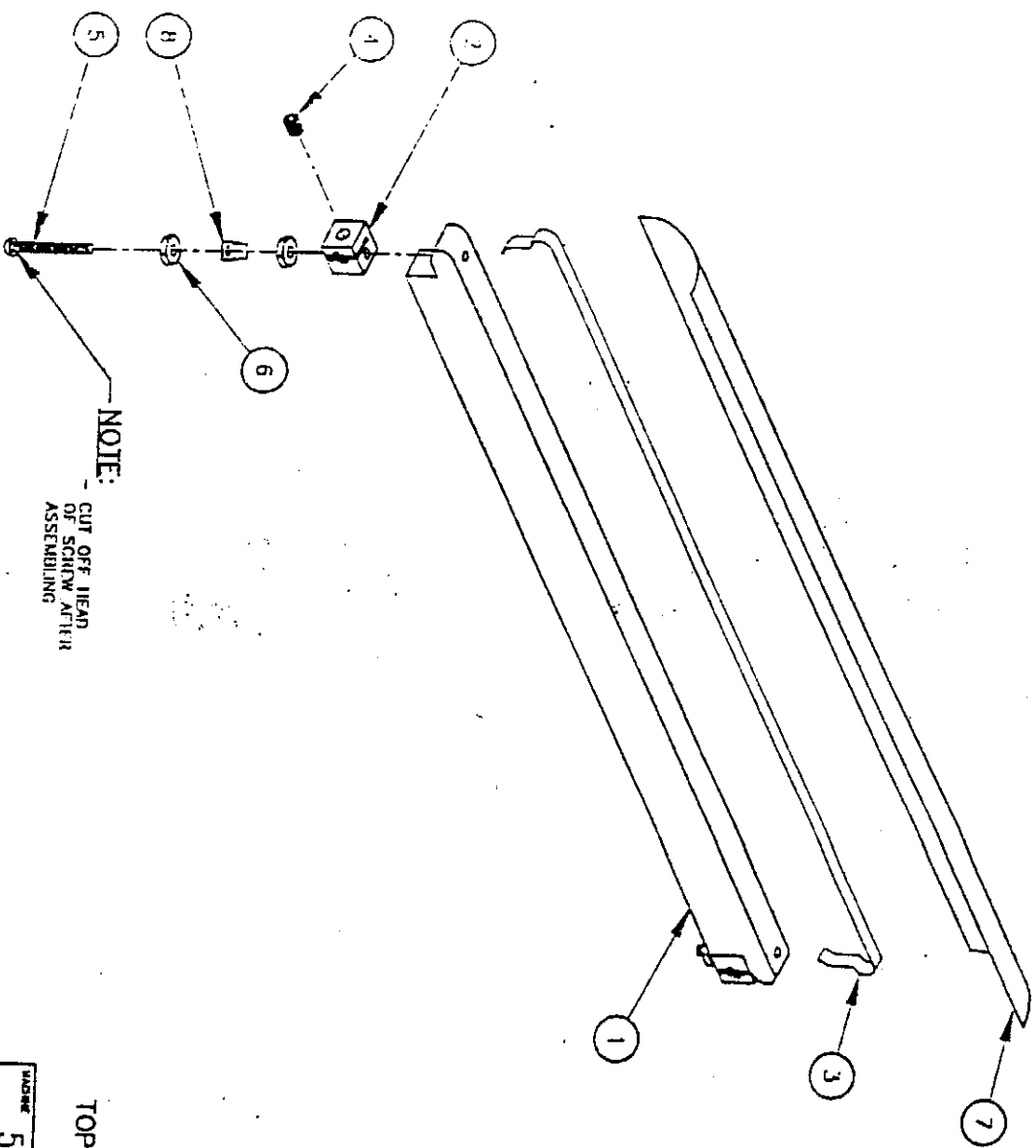
DATE: 88-04-08
PART: 1

010-0017

REVISION/ MFG. NO. WAS LIC. NO.
MCKAY/KAYM

88-08-09 1 M.
DATE M.I.

REVISIONS
 DATE 08-07-10
 AP
 INI



NOTE:
 CUT OFF HEAD
 OF SCREW AFTER
 ASSEMBLING

ITEM	PART #	DESCRIPTION	QTY
1	002-0314	SEAL BAR (TABLE)	1
2	009-0028	CONNECTOR	1
3	030-0220	SEALING ELEMENT	2
4	052-0395	SCREW 1/4" - 20 NC. X 5/16" ST HEX SH ORL 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	HEFTON TAPE SS ADHESIVE X 2" X 650 MM	1
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2

NOTE:
 QTY FOR ONE
 SEAL BAR ONLY
 SEE LIST

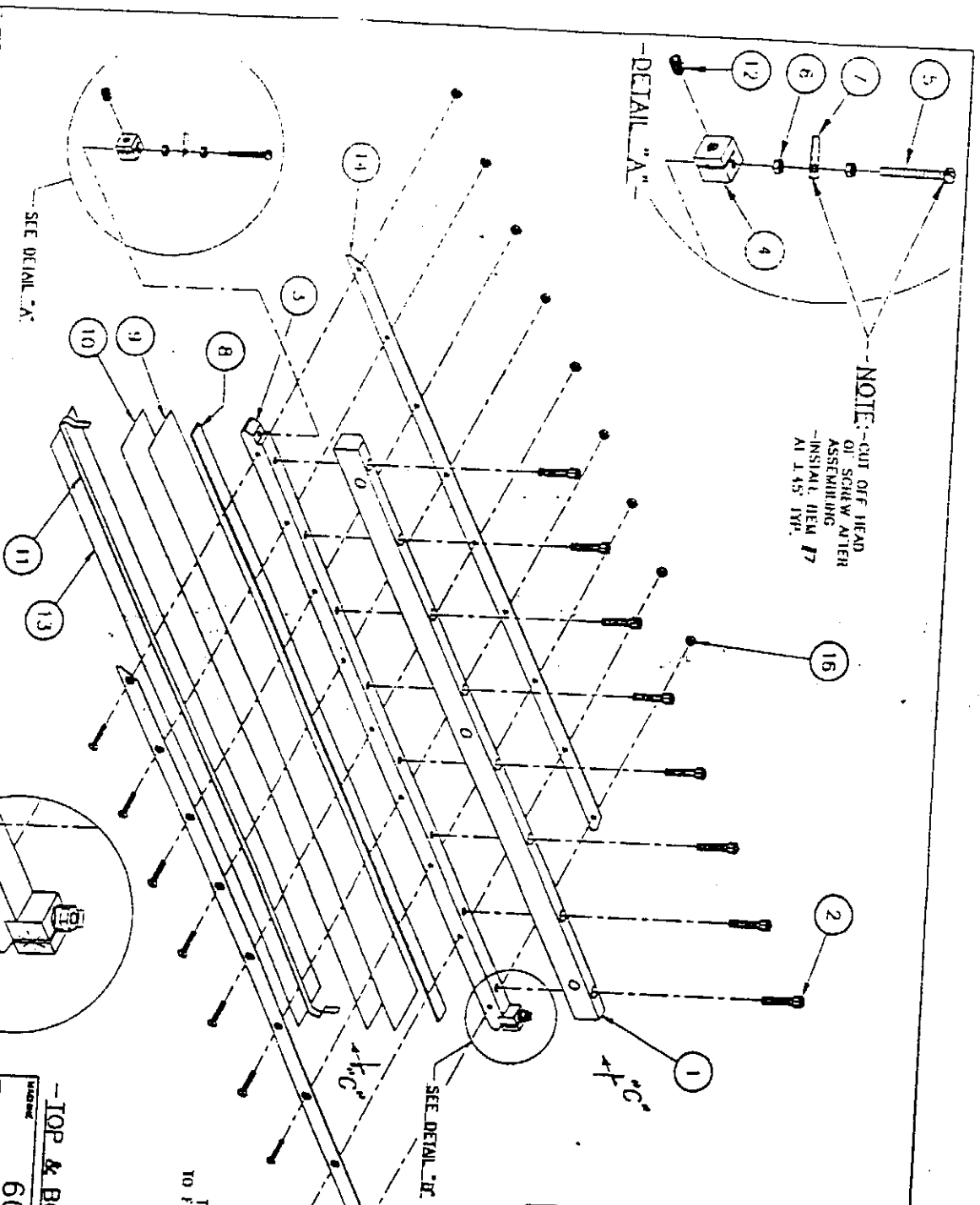
-OPTION-
 TOP AND BOTTOM SEALING OR
 BI-ACTIVE SEALING

550A & 600A

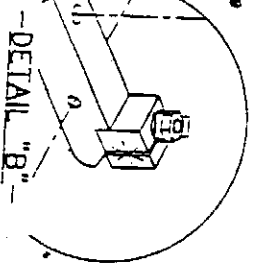
ITEM	DESCRIPTION	QTY
1	SEAL BAR PRE-ASSEMBLY	4
2	SIPROMAC	2

ST-GERMAIN DE GRANBY
 QUEBEC CANADA
 005-0370

01 01 1989
 98-01-18
 DATE
 111
 111

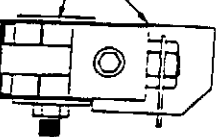


NOTE:-- CUT OFF HEAD OF SCREW AFTER INSTALLING ITEM 17 AT 45° ANG.



TOP & BOTTOM SEALING OPTION

NEW "C-C" (END VIEW ASSEMBLY)



THIS SIDE OF SEAL BAR TO FIT FLUSH W/ SUPPORT

ITEM	PART #	DESCRIPTION	QTY
1	002-0534	UPPER SEAL BAR SUPPORT	2
2	051-0232	SCREW 1/4" - 20 NC. X 1 1/4" CAP HEX SHD 5/5	18
3	002-0318	UPPER SEAL BAR	2
4	009-0028	TOP & BOTTOM SEAL CONNECTOR WELDED	4
5	052-0250	SCREW #8-32 NC. X 1 1/2" AND SLOT BRASS	4
6	051-0550	HEX NUT #8-32 NC. 5/5	4
7	027-0400	CONNECTOR ADAPTOR	8
8	178-0003	UPPER SEAL BAR RUBBER	4
9	176-0200	TEFLON TAPE (55) ADHESIVE	2
10	176-0220	TEFLON TAPE (105) ADHESIVE	2
11	039-0220	SEALING ELEMENT	2
12	052-0385	SET SCREW 1/4" - 20 NC. X 5/16" (OVAL POINT)	4
13	176-0220	TEFLON TAPE (105) ADHESIVE	4
14	001-1410	UPPER TEFLON HOLDER	2
15	051-0121	SCREW #8-32 NC. X 1" FLAT PHIL. 5/5	4
16	051-0550	HEX. NUT #8-32 NC. 5/5	18

600A

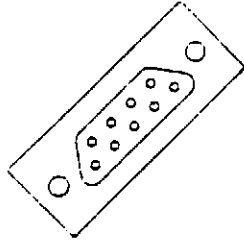
UPPER SEAL BAR ASSY W/ SUPPORT

DATE: 98-05-26

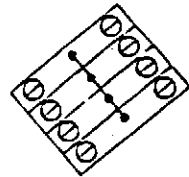
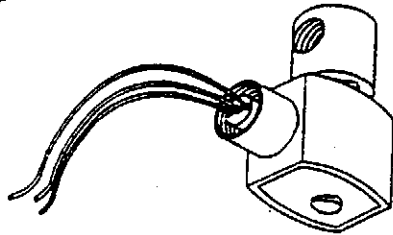
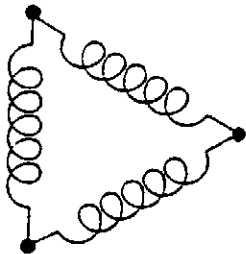
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005-0386

1005-0386

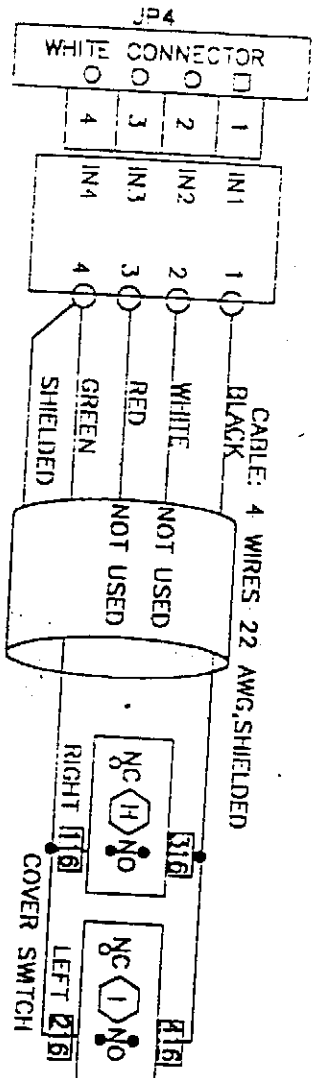


ELECTRICAL DRAWING



ATT: MIKE

2 amp



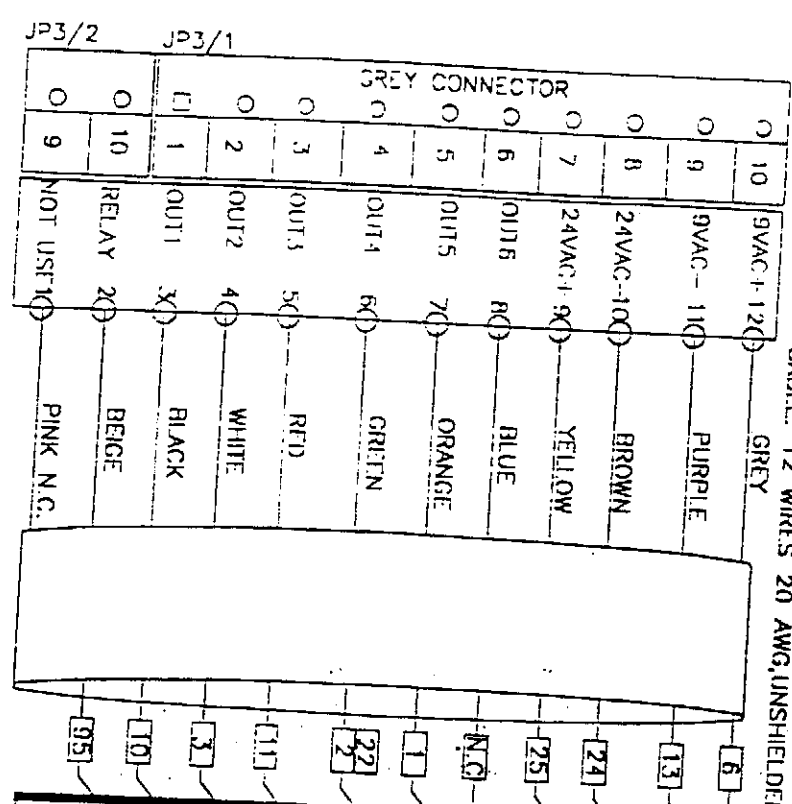
CONTROL TRANSFO.

0	208	230	600
9V	9V	24V	24V

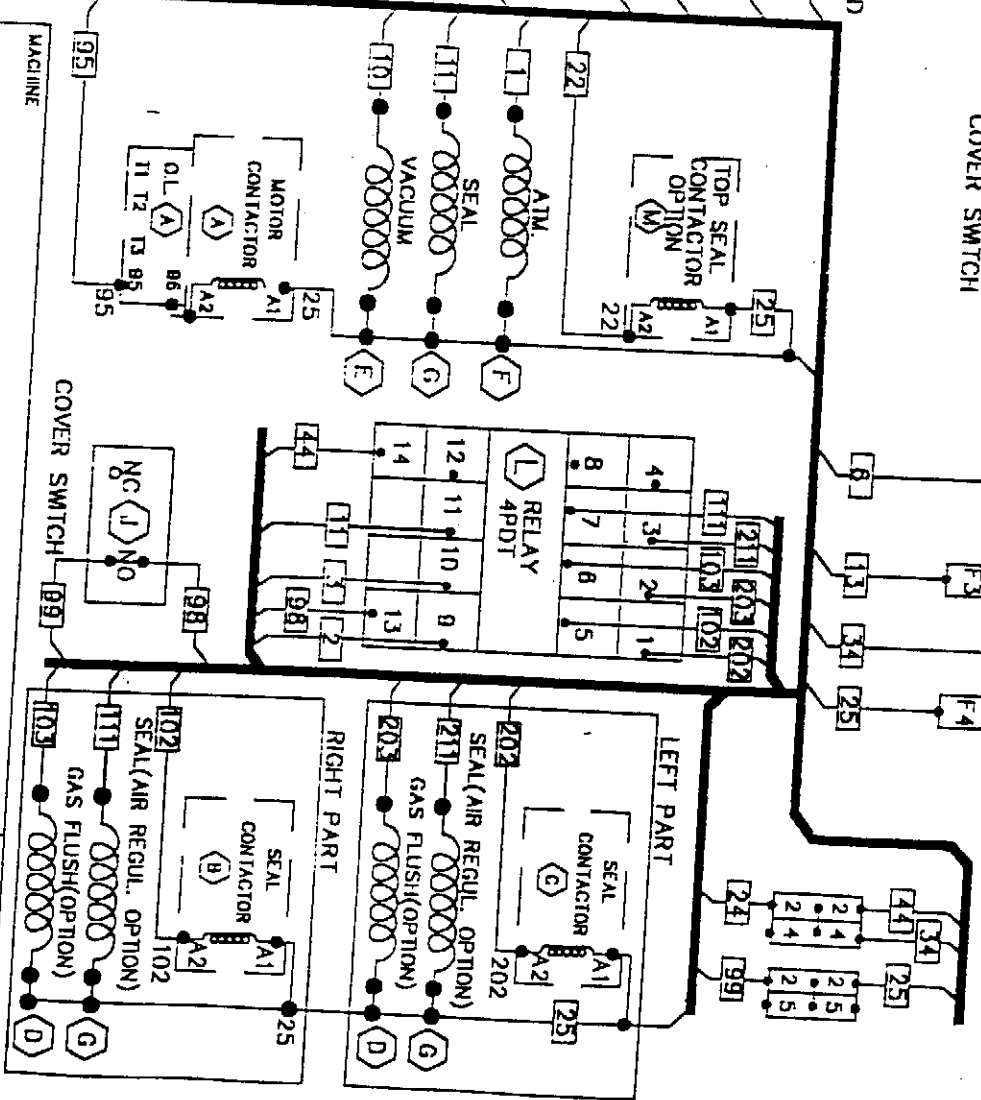
PURPLE PURPLE RED RED

FUSE F3	0.34-0.210	2A
FUSE F4	0.34-0.240	2A

CABLE: 12 WIRES 20 AWG, UNSHIELDED



MC-40



MACHINE
VACUUM DOUBLE CHAMBER

SIPROMAC

LOW VOLTAGE WITH MC-40

ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

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

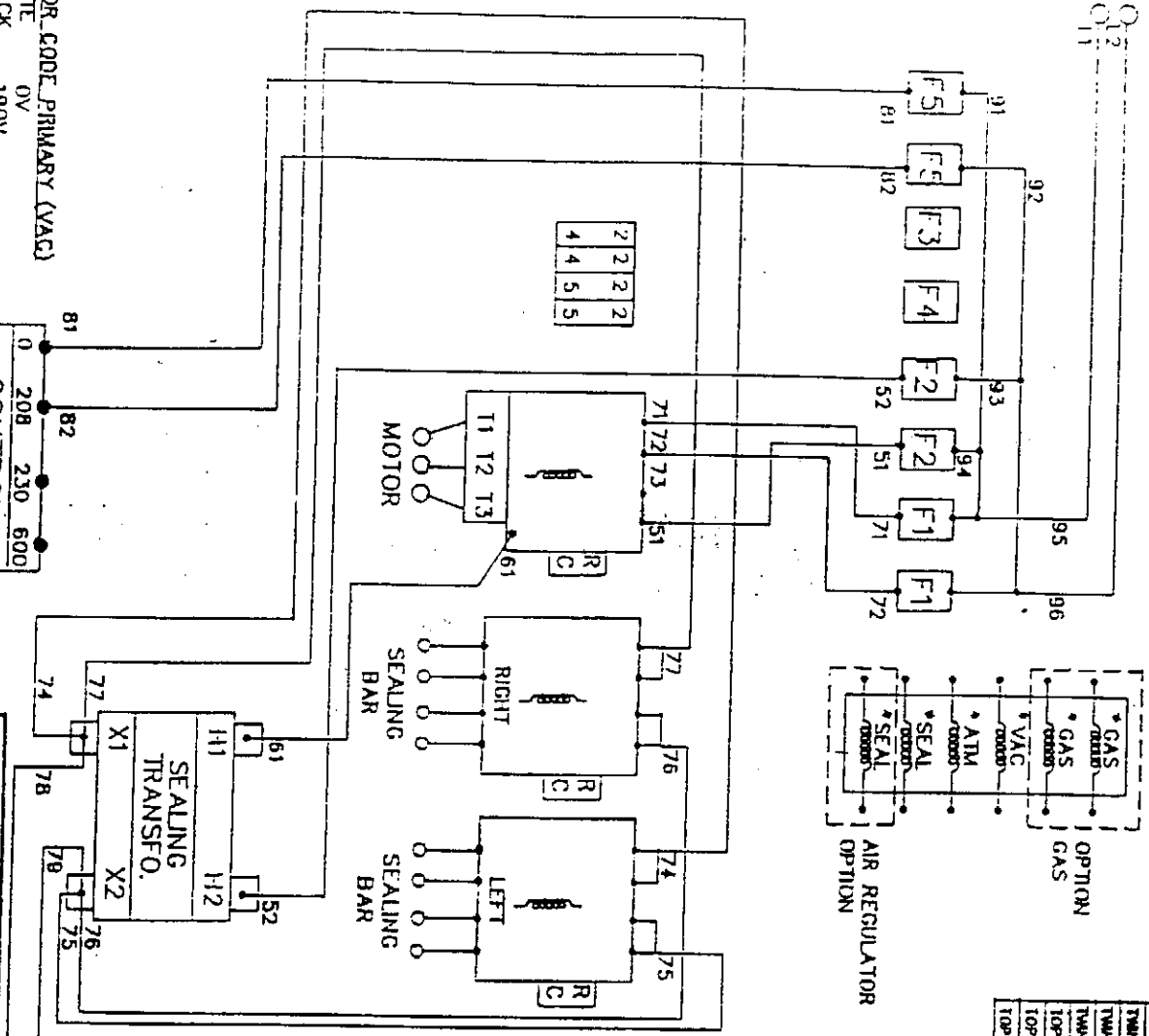
DATE: 5 MAY 1998

APPR. DATE

NO. 016 0110

1006-0068

* RC SUPPRESSOR ADD ON EACH COIL



OPTION	VOLTAGE	FUSE F2	FUSE F3
TOP SEAL & BAG CUT	220	031-0450	031-0700
TWIN SEAL & BAG CUT	380	031-0430	031-0410
TWIN SEAL & BAG CUT	800	031-0425	031-0410
TOP & BOTTOM SEAL	220	031-0300	031-0700
TOP & BOTTOM SEAL	380	031-0425	031-0410
TOP & BOTTOM SEAL	800	031-0440	031-0410

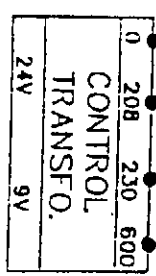
MOTOR (HP)	VOLT 1ph	FUSE F1
3	230-1	031-0550
3	230-3	031-0530
3	575-3	031-0440
5	230-1	031-0570
5	230-3	031-0550
5	575-3	031-0410

• 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



UNACIINE
420A, 600A & 620A

PIECE ELECT. WIRING HIGH VOLTAGE 10

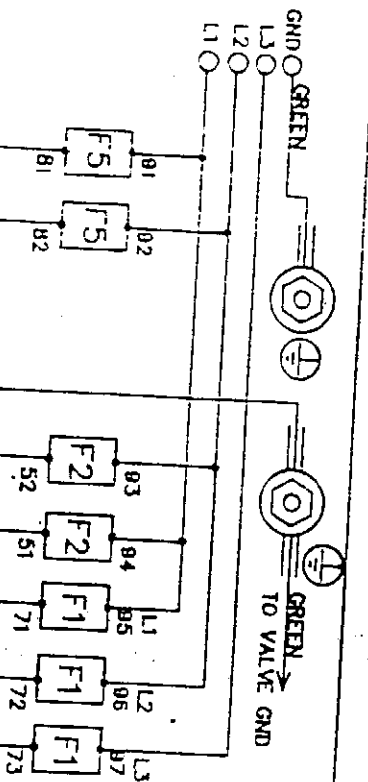
NE PAS MESURER / N.T.S.

DATE 97-03-10

SIPROMAC
ST-GERMAIN DE GRANTMAM
QUEBEC CANADA

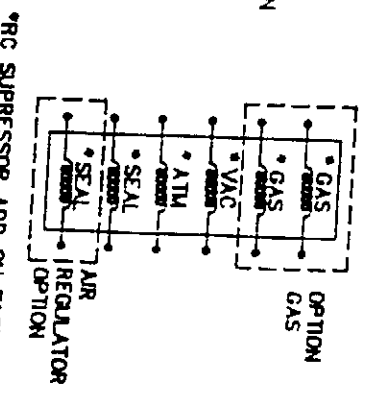
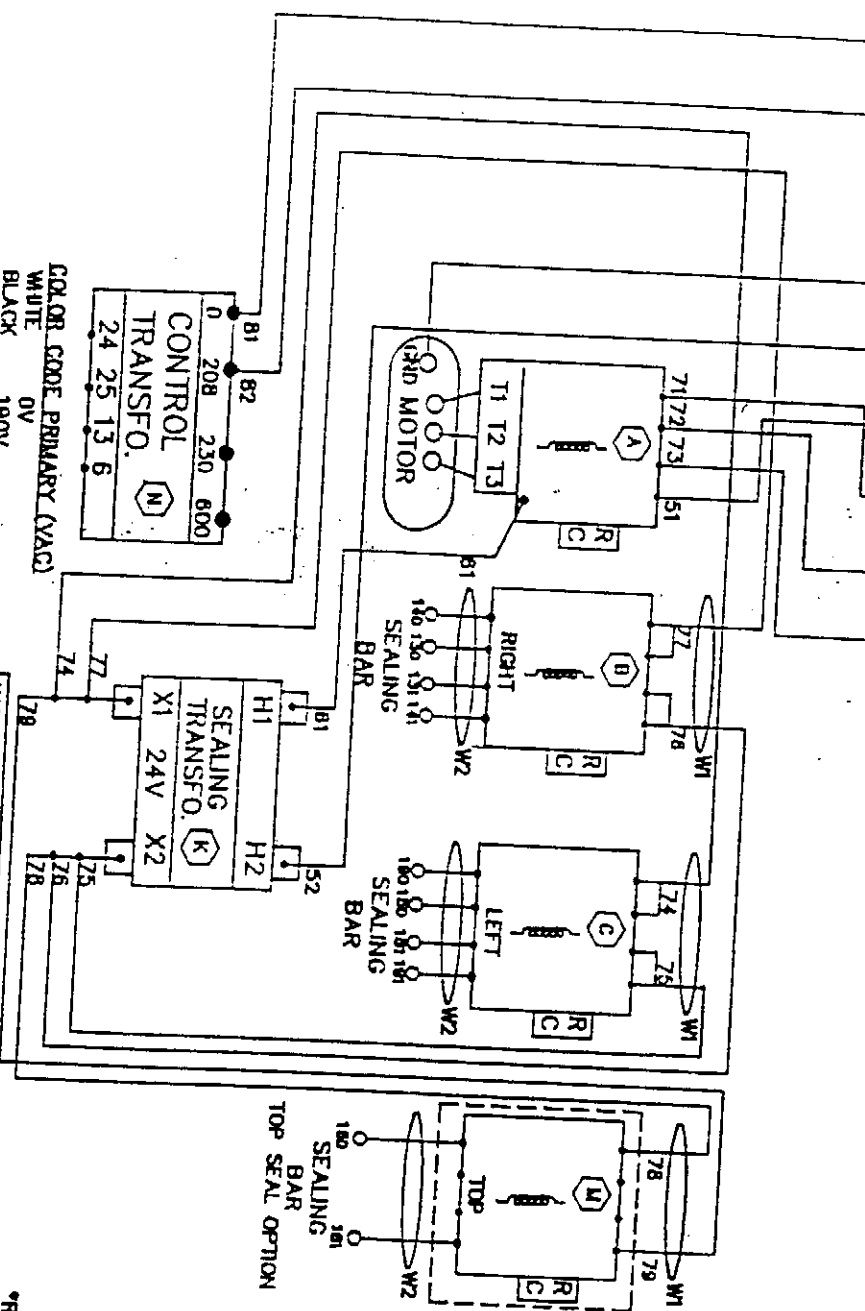
006-0068

1006-0069



OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0450	034-0700
TWIN SEAL	360	034-0430	034-0410
TWIN SEAL	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	360	034-0485	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

MOTOR (HP)	VOLT 4PH	PUMP	FUSE F1
3	230-1	230-1	034-0500
3	230-3	230-3	034-0530
3	575-3	575-3	034-0480
5	230-1	230-1	034-0570
5	230-3	230-3	034-0530
5	575-3	575-3	034-0510



COLOR CODE PRIMARY (VAC)

WHITE	0V
BLACK	180V
GREY	208V
RED	230V
BROWN	230V
YELLOW	380V
BLUE	480-480V
RED	575-800V
PURPLE	24V
PURPLE	8V

420A, 600A & 620A

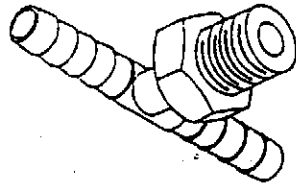
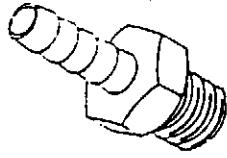
ELECT. WIRING HIGH VOLTAGE 3Ø

PRICE _____ EQUL SCALE _____

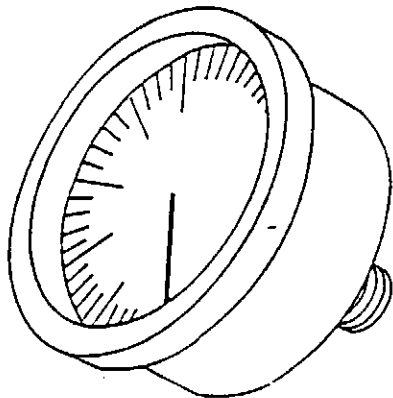
DATE 92-03-10

NO. 006-0069

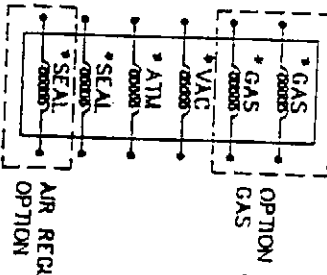
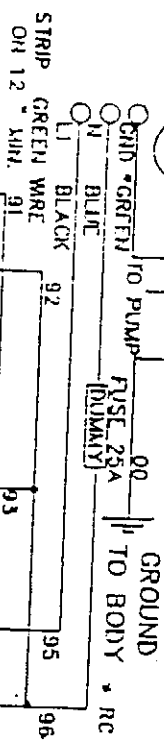
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA



PNEUMATIC DRAWING

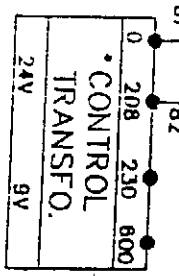
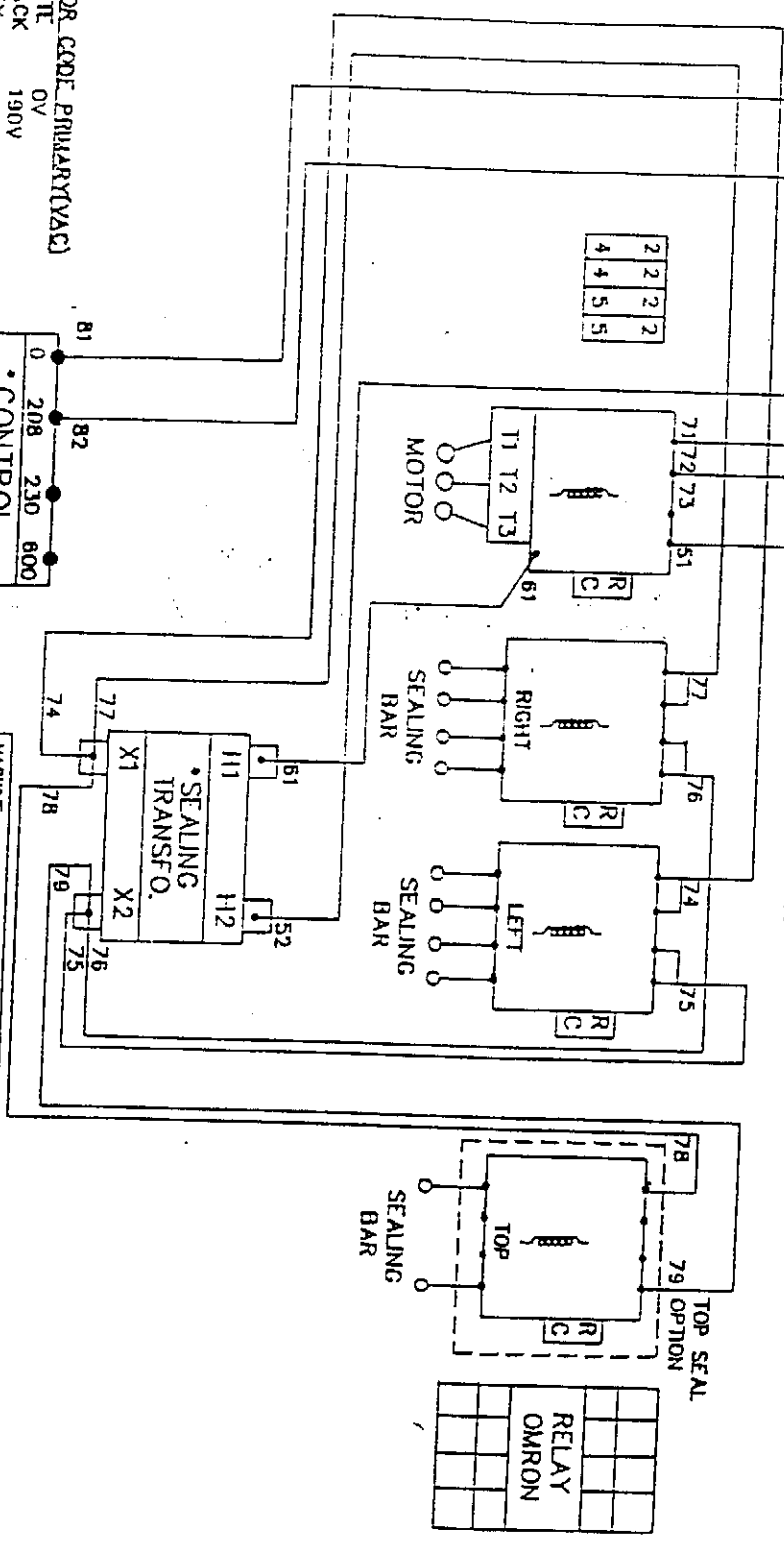


GROUND



OPTION	VOLTAGE	FUSE F2	FUSE F3
TOP SEAL & BAG CUT	220	031-0150	031-0200
TWIN SEAL & BAG CUT	380	031-0430	031-0410
TWIN SEAL & BAG CUT	600	031-0425	031-0410
TOP & BOTTOM SEAL	220	031-0300	031-0200
TOP & BOTTOM SEAL	380	031-0465	031-0410
TOP & BOTTOM SEAL	600	031-0440	031-0410

MOTOR (hp)	VOL 1 (ph)	FUSE F1
3	230-1	031-0530
3	230-3	031-0830
3	575-3	031-0480
5	230-1	031-0570
5	230-5	031-0850
5	575-3	031-0510



- COLOR CODE PRIMARY(VAC)
- WHITE 0V
 - BLACK 190V
 - GREY 200V
 - RED 230V
 - BROWN 380V
 - YELLOW 460-480V
 - BLUE 575-600V
- SECONDARY(VAC)
- RED 24V
 - PURPLE 9V

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

420A, 600A & 620A

ELECT. WIRING HIGH VOLTAGE 10,50 HZ

NE PAS MESURER N.T.S.

SIPROMAC

ST-GERMAIN DE GRANTHAU, QUEBEC CANADA

DATE 97-03-11

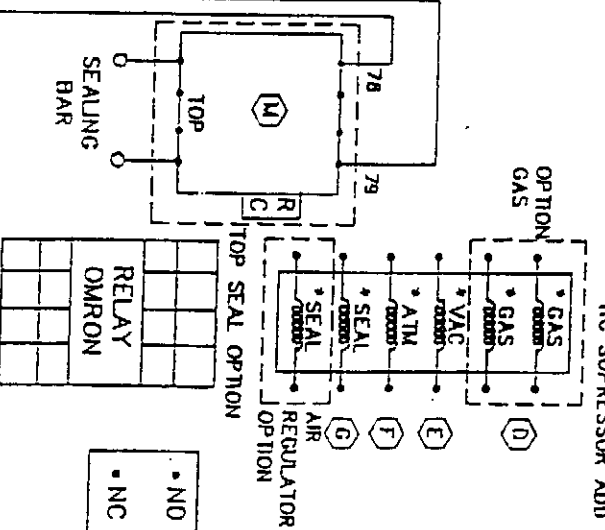
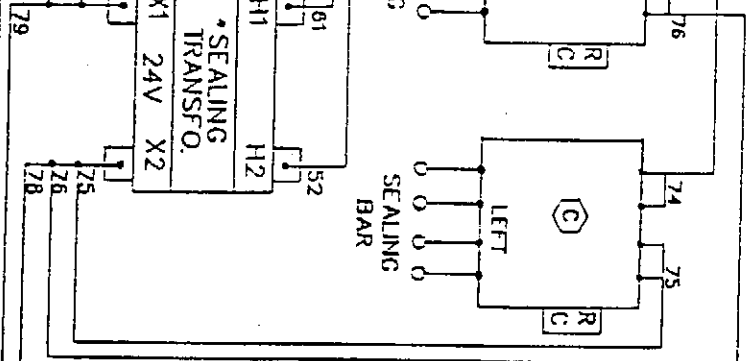
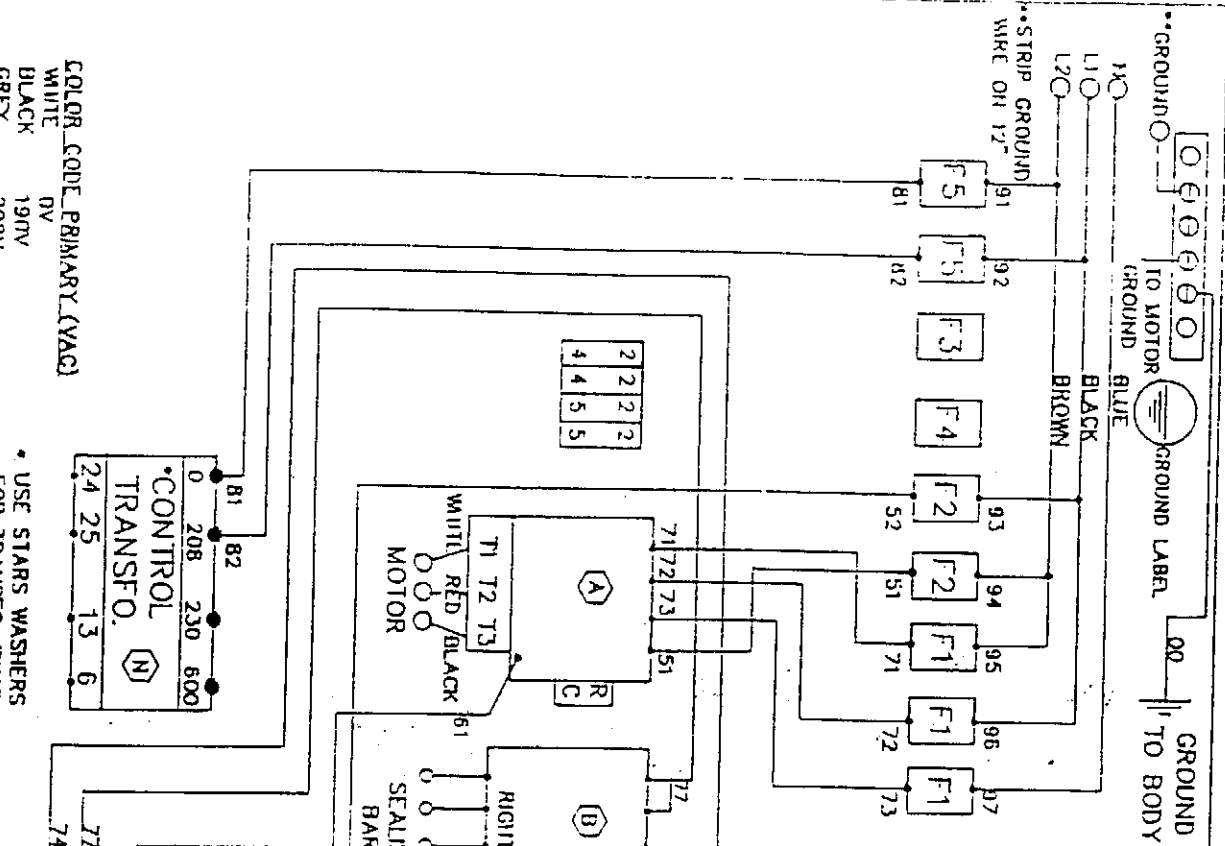
006-0101

1006-0101

1006-0102

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

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



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

- COLOR CODE PRIMARY (VAC)
- WHITE 0V
 - BLACK 190V
 - GREY 208V
 - RED 230V
 - BROWN 380V
 - YELLOW 460-480V
 - BLUE 575-600V

* USE STARS WASHERS FOR TRANSFO. FIXATION.

420A, 600A & 620A

ELECT. WIRING HIGH VOLTAGE (50 HZ) 3P

NE PAS MESURER / N.T.S.

SIPROMAC

ST-GERMAIN DE GRANTHAU, QUEBEC CANADA

006-0102

ELECTRICAL DRAWINGS PARTS LIST

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

B,C & O: SEALING CONTACTOR:

D: OPTIONAL GAZ SOLENOID VALVE:

E: VACUUM SOLENOID VALVE:

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:

026-0610

K: SEALING TRANSFO:

TWIN SEAL & BAG CUT:
TOP & BOTTOM SEALING:

029-0040, 029-0050
029-0080

L: RELAY & BASE:

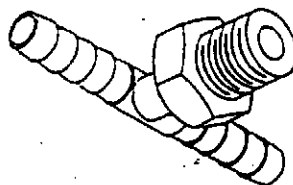
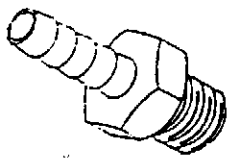
025-0600
025-0610

RELAY:
BASE:

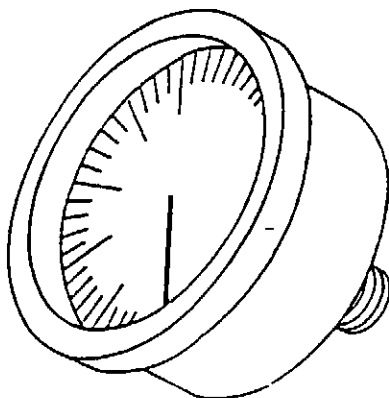
M: OPTIONAL TOP SEALING CONTACTOR: 025-0020

N: CONTROL TRANSFO:

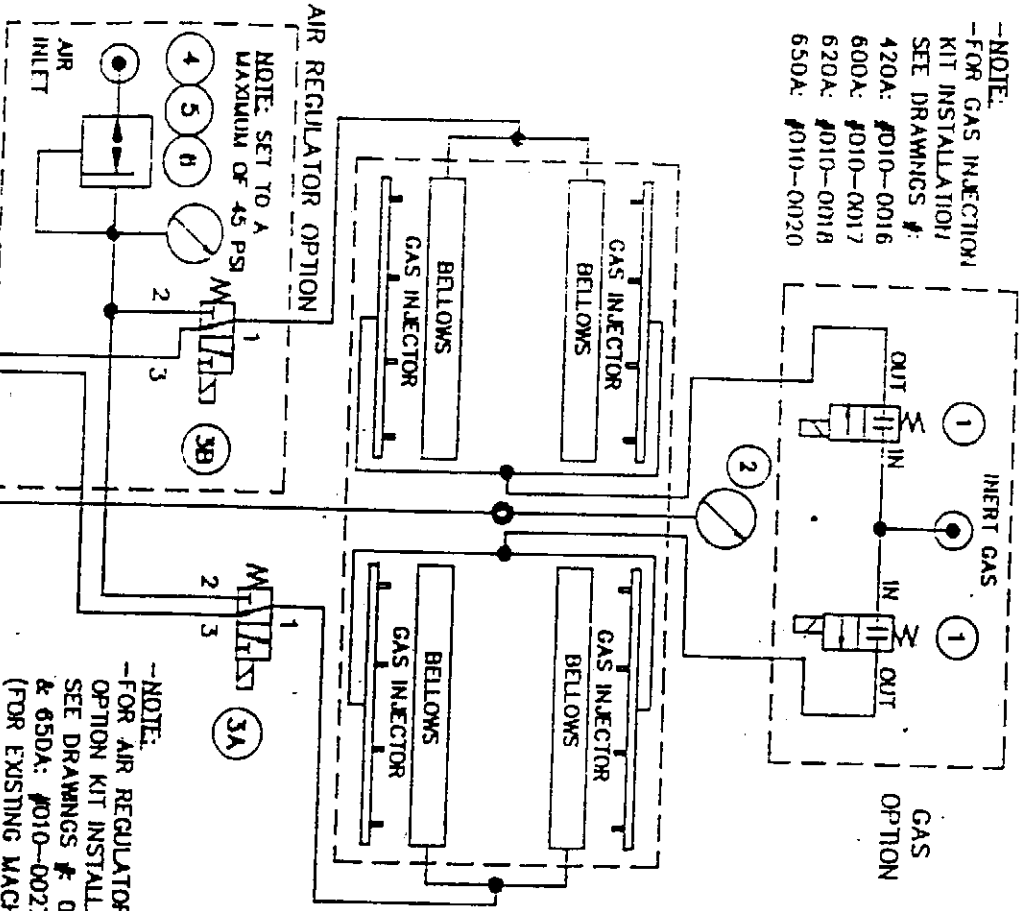
029-0007, 029-0008, 029-0009, 029-0250



PNEUMATIC DRAWING



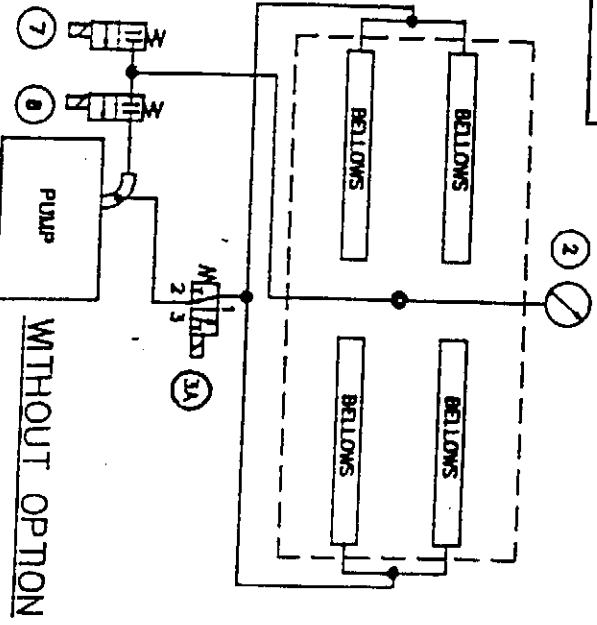
-NOTE:
-FOR GAS INJECTION
KIT INSTALLATION
SEE DRAWINGS #:
420A: #010-0016
600A: #010-0017
620A: #010-0018
650A: #010-0020



-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	114-0280	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	1
	106-0030	ATMOSPHERE VALVE FOR 600A, 620A AND 100 M ³	1
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A: 160 M ³ AND 250 M ³	1
8	106-0050	VACUUM VALVE FOR 600A & 620A	1
	106-0030	VACUUM VALVE FOR 420A	1
	106-0060	VACUUM VALVE FOR 650A & 700A	1

*: OPTION



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

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

TITLE: _____ DATE: 97-03-11 SCALE: 1

DATE: 97-03-11 DATE: 97-03-11

DATE: 97-03-11 DATE: 97-03-11

DATE: 97-03-11 DATE: 97-03-11

DATE: 97-03-11 DATE: 97-03-11

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DATE: 97-03-11 DATE: 97-03-11

007-0019