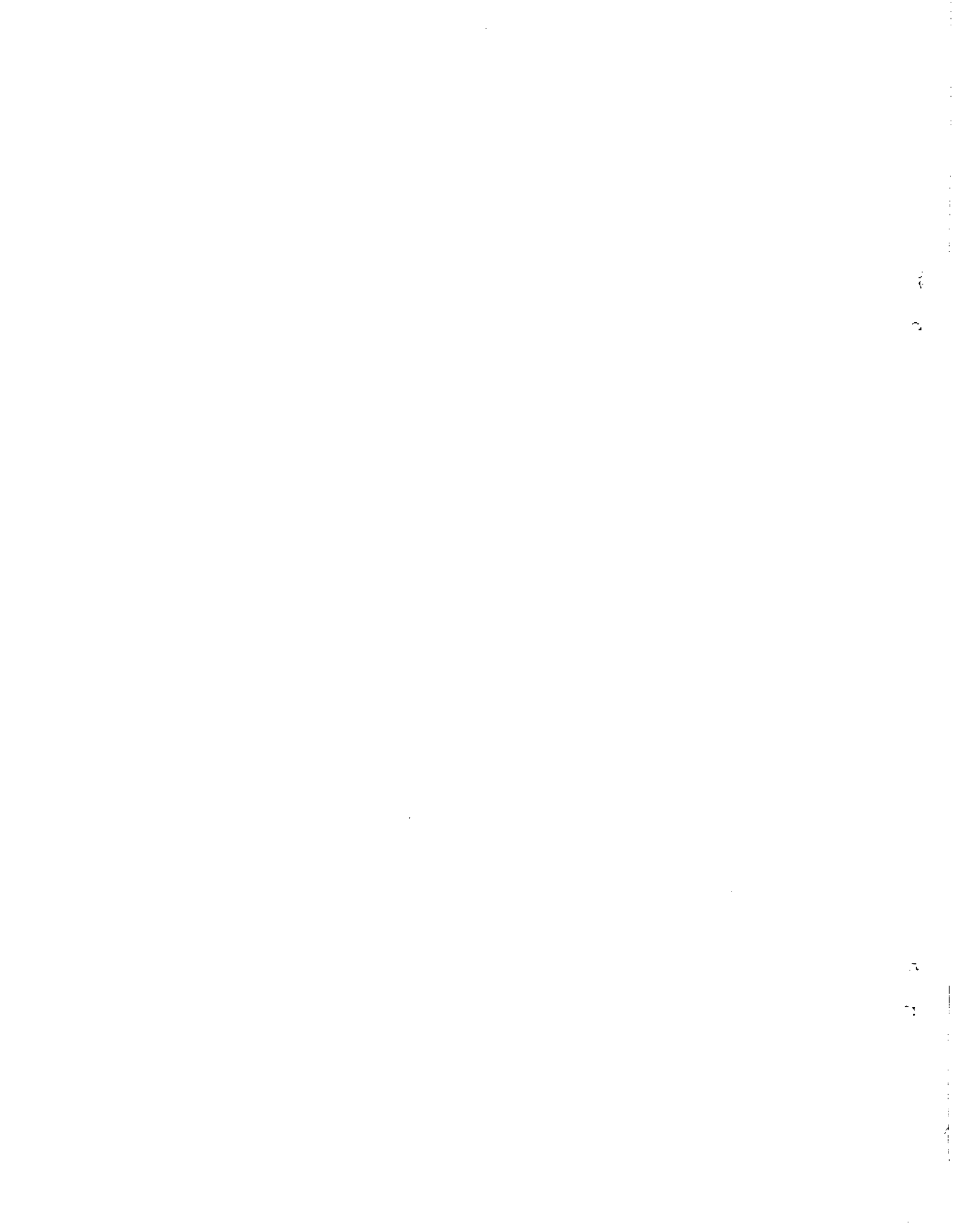




OWNER'S MANUAL

**VACCUM MACHINE
600A**



IMPORTANT SAFETY INSTRUCTIONS SAVE THESE INSTRUCTIONS



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 machine.

Failure to comply with these instructions may result in personal injury.

General Operation

- Read, understand, and follow all instructions in the manual and on the machine before starting. Keep this manual in a safe place for further and regular reference and for ordering replacement parts.
- Only allow responsible individuals familiar with the instructions to operate the machine. Be sure to know controls and how to stop the machine quickly.
- Never put your hands near moving parts.
- Only allow qualified individuals for the maintenance of your machine.
- Remove all obstacles, which may interfere with the machine functions.
- Clear the work area such as electrical wires, buckets, knives etc.
- Be sure that everyone else is clear of your work area before operating the machine.
- Do not sit nor stand on the machine.
- Always turn off the machine after your work is done. Never leave a running machine unattended.
- Always disconnect and wait till the machine has cooled before attempting any maintenance.
- Do not wear loose fitting clothes or jewelry as they may get caught in moving parts of the machine.
- Always wear security shoes, to prevent injury caused by moving the machine or objects falling from the machine.
- Never exceed the time limit to seal, which is recommended by the manufacturer. This is to avoid any damage that may be caused to the sealing bars and to eliminate the risk of fire in the machine. Thus avoiding corporal burns.
- Never touch the sealing bars after they have been used, this will avoid corporal burns. Wait a few minutes to let the machine cool down before touching.
- Always make sure that the sealing bars are well installed in their "Guide Blocks" before starting a cycle.
- Never incline the machine more than 30 degrees, it may tip over and hurt someone seriously.
- Work only in daylight or good artificial light.

Do not operate the machine while under the influence of alcohol or drugs!

Service

- Use proper containers when draining the oil. Do not use food or beverage containers that may mislead someone into drinking from them. Properly dispose of the containers, or store in a safe place immediately following the draining of the oil.
- Prior to disposal, determine the proper method to dispose of waste from your local office of Environmental Protection Agency. Recycling centers are established to properly dispose of materials in an environmentally safe fashion.

Do not pour oil or other fluids into the ground, down a drain or into a body of water.



Warning-Your responsibility:

This machine should only be operated by personal who can read, understand and respect warnings and instructions regarding this machine in the owners manual. Save these instructions for future reference.

VACUUM PACKAGING MACHINE

MODEL 600A

(MC-40 SIPROMAC)

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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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2010-08-30

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.

Normal ambient temperature for the vacuum pump is between 10 to 70°C. For temperature below 10°C; it is recommended to use synthetic oil. Please consult factory and pump manufacturer manual for more information or when ambient temperature are outside normal limits

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. **GROUNDING INSTRUCTIONS:** This appliance must be connected to a grounded, metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment-grounding terminal or lead on the appliance. A qualified electrician should be consulted if there is any doubt as to whether an outlet box is properly grounded.

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.



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.

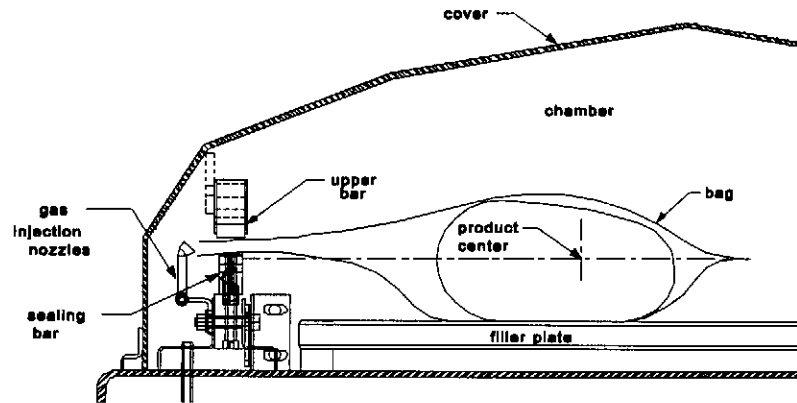


FIGURE 1

3.2 Special packaging:

3.2.1 Gas flushing (option):

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

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

The necessary gas tank and pressure valve mounted on tank is not supplied, 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.

3.2.2 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:

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 14 and the keyboard detail on page 15.

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:

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 → (9 characters)

keys 2, 2, ENTER	→ E
keys 8, 8, 8, ENTER	→ X
keys 1, ENTER	→ A
keys 5, ENTER	→ M
keys 6, ENTER	→ P
keys 4, 4, 4, ENTER	→ L
keys 2, 2, ENTER	→ E
keys 9, 9, 9, ENTER	→ space
keys 1, 1, 1, 1, ENTER	→ 1

key ENTER to validate the characters string

3.3.3.2 Vacuum level setting:

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

Examples: 90.0% → keys 9, 0, 0 or 9, 0, ENTER or
keys 9, 0, 1 or 9, 0, 2 or 9, 0, 3 or 9, 0, 4
97.5% → keys 9, 7, 5 or
keys 9, 7, 6 or 9, 0, 7 or 9, 0, 8 or 9, 0, 9
0.0% → keys 0, 0, 0 or 0, ENTER

3.3.3.3 Vacuum plus time setting:

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

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

3.3.3.4 Gas flush level setting:

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

3.3.3.5 Sealing time setting:

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

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

3.3.4 Vacuum cycle execution:

For the manual units and the automatic units set on manual, close the cover to initiate a vacuum cycle. For the automatic units set on semi-automatic or on automatic, use push button "STOP / START" to initiate or interrupt a vacuum cycle. A selected program can be initiated only in the programs menu, when no modifications are in progress, and the access to the other programs and functions is denied. During cycle execution the operation status is 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:

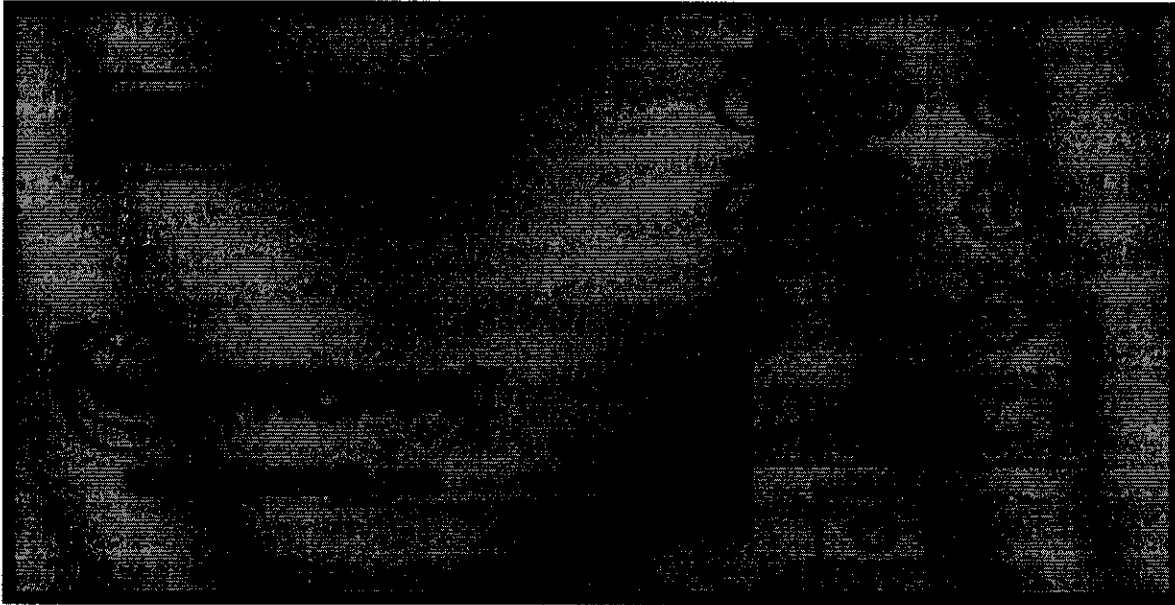
To accede the diagnostics menu, power up the vacuum packaging machine while keeping pushed in the "ESC"key. Use key "SELECT" to select the system monitor function and key "ENTER" to accede and visualize the monitored parameters. Use key "SELECT" to change over from the software revision, the amount of 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: xxs"(0s - 99s)
 - "GAS FLUSH: xx.x%" (0.0% - 10% below the vacuum level) (units with gas option)
 - "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 OFFSET CALIB."
 - "D8 VACUUM SENSOR"
 - "D9 SIPROMAC PUB"
 - "D10 LOADING TIME" (automatic units only)
 - "D11 UNLOADNG TIME" (automatic units only)
 - "SYSTEM MONITOR" (no access code required)
 - "SOFTWARE: R x.xx"
 - "WORK HRS: xxxxx"
 - "CYCLES: xxxxxxx"

-KEYBOARD DETAILS-

MC-40 CONTROLS





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.

Cleaning instructions for gas injection nozzles: Periodically on a regular basis the gas injection nozzles must be removed with the connection tube and soaked in a food grade soap and water solution, then dried and re-installed.

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.

Vacuum level is too low:

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.

Caution: 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).

Caution: 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 13.

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

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

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

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

Check vacuum connections for tightness.

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

Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

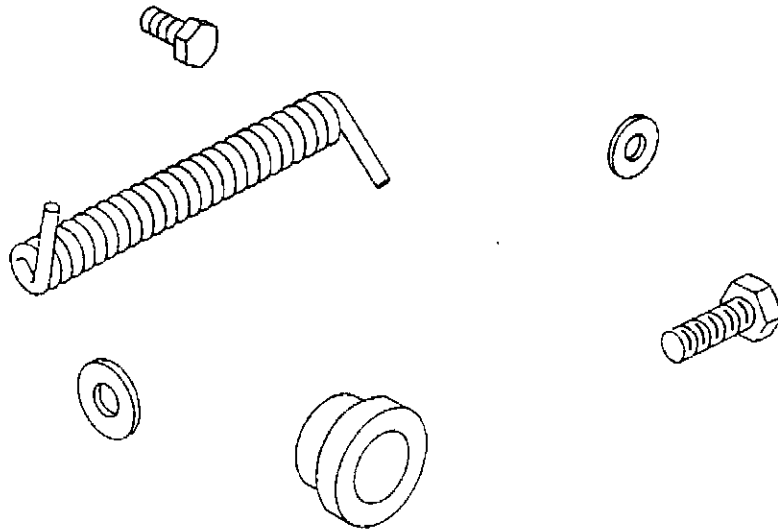
MODEL 600A

COVER ADJUSTMENT PROCEDURE

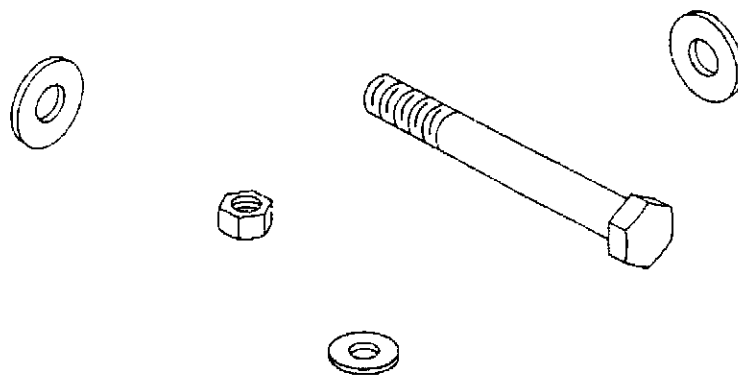
Reference Drawing:# 005C0324
004C0122

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.).
 - 2.2 Loosen the two bolts of the guide arm axis (See drawing #004C0122; items #23).
 - 2.3 Now move the cover on each side and check how cover sits on the table. Distance between table and lid gasket should be less than 1/16" approx. If so, go to step 3.0 for guide arm adjustment. Otherwise go to step 2.4 for central arm adjustment.
 - 2.5 When closing cover (guide arm axis still loose), if cover is not sitting properly on either the front or rear of the table, you have to change the height of the flange bearings (See drawing # 004C0122; item #12) until cover is seating properly on each side. Normally shaft is centered in the table holes and the height is adjusted in a way that cover will slightly touch the back side of the table first.
3. Adjustment of guide arm: Both length of the guide arm and position on the guide arm axis have to be adjusted. Each of these should be adjusted separately. Fix the lower axis in a central position (centered in the holes) then adjust guide arm length until cover sit correctly on the right side. Move cover to the left side and check if cover sits correctly, if not move lower axis position and change length of the guide arm. Move the cover back to its original position to confirm, normally multiples tryout is required. Make sure there is no stress is transferred to the guide arm when machine is operating, stress induced arm will cause premature component fail.



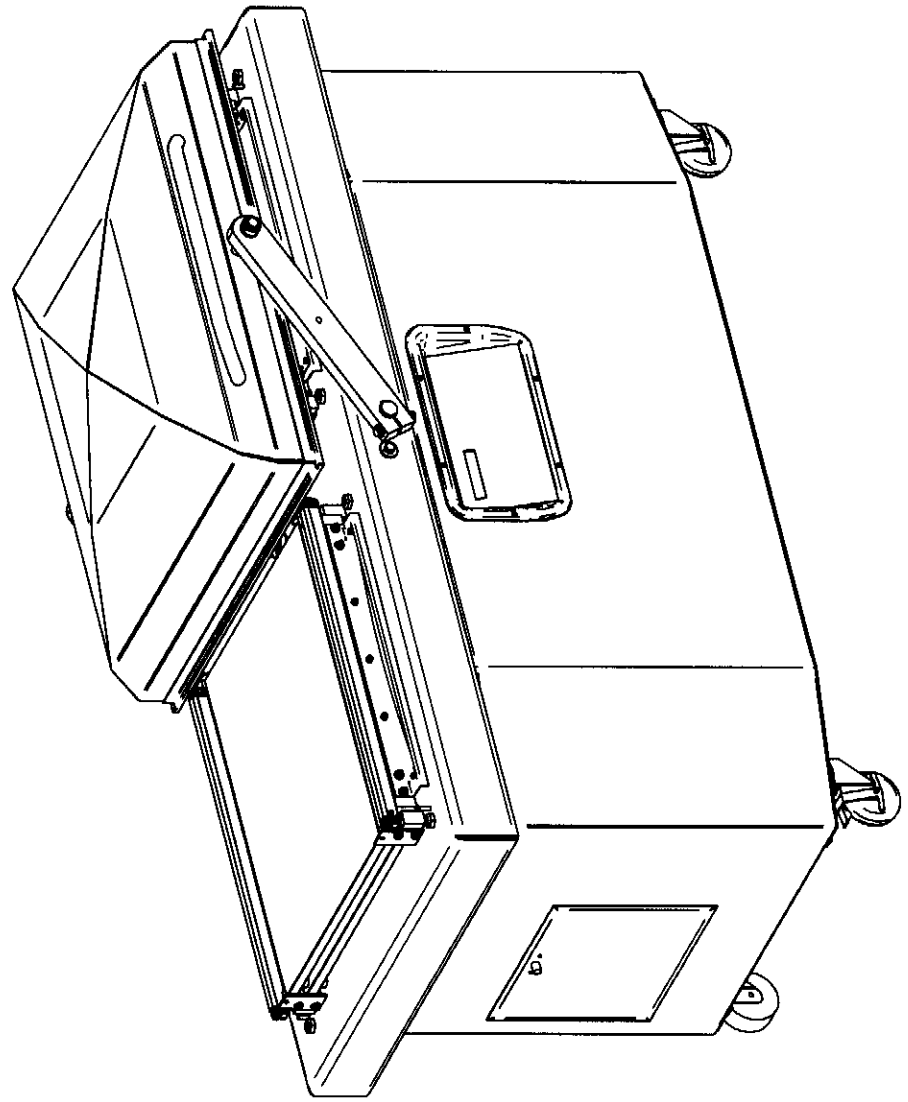
MECHANICAL DRAWING



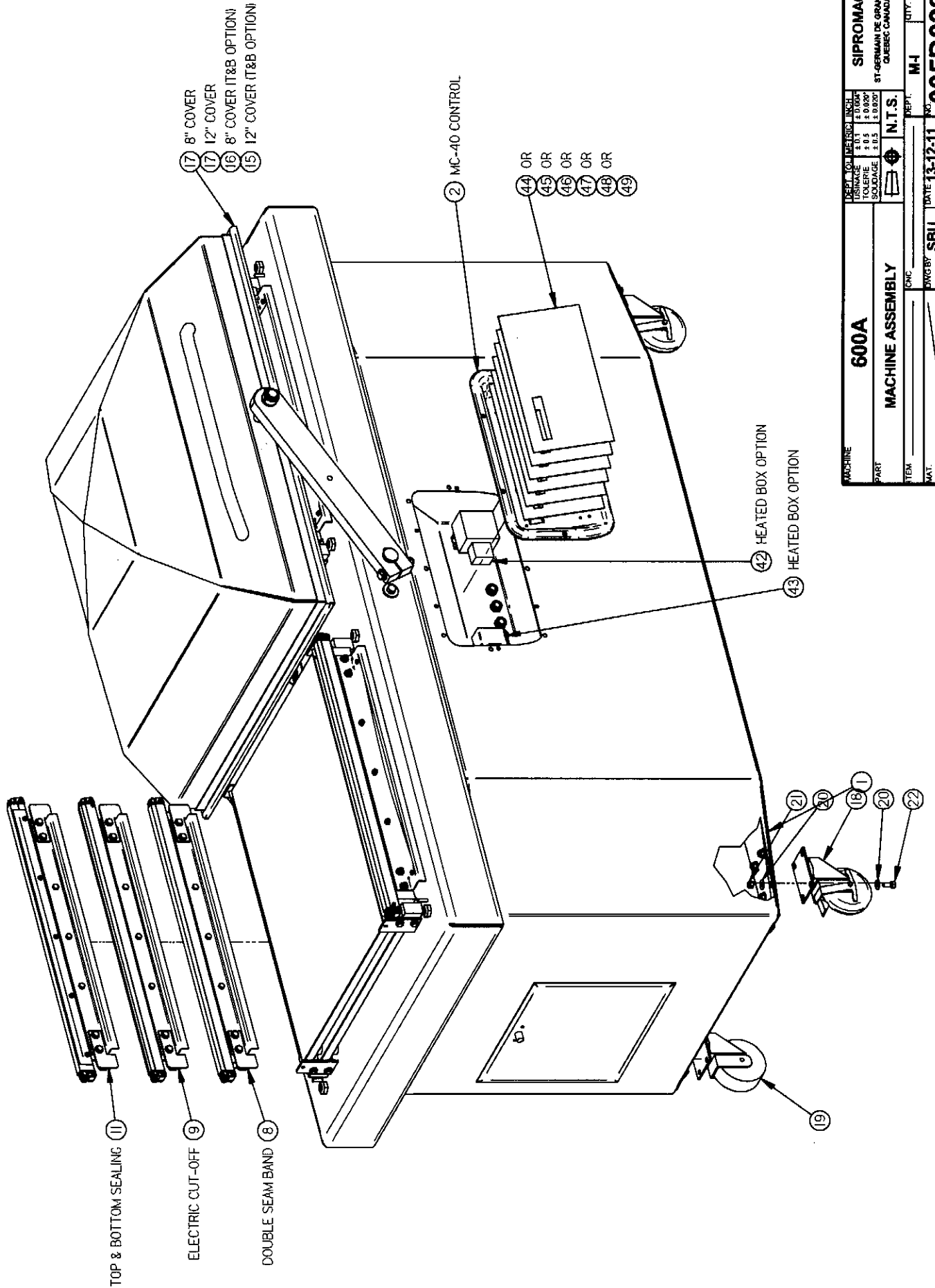
1005D0324

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ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
45	033-0014	MC-40 KEYBOARD "FOODPAK"	1	37	004A4108	VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR + MUFFLER)	1	1	004A4146	BASE MACHINE ASSEMBLY	1
46	033-0016	MC-40 KEYBOARD "HOLLYMATIC"	1	38	004A4109	VACUUM/ATMOSPHERE VALVE (OPT MUFFLER)	1	2	005B0583	MC-40 CONTROL BOARD	1
47	033-0018	MC-40 KEYBOARD "BERKEL"	1	39	004A4110	VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR)	1	2	004A1326	UPPER SEAL BAR ASSEMBLY (TWIN)	2
48	033-0019	MC-40 KEYBOARD "BSA"	1	40	004A4111	VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR+MUFFLER)	1	12	051-0740	WASHER 1/4" FLAT S/S	12
49	033-0021	MC-40 KEYBOARD "SUPPLY ONE"	1	41	004A4104	BELLOWS VALVE ASSY	1	6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6
				42	039-0192	HEATER 100W HAMMOND	1	6	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	6
				43	039-0191	THERMOSTAT HAMMOND	1	1	036-0280	PLUG GRÖMMET 1-1/16" X 1/2" X 13/16" HOLE	1
				44	033-0015	MC-40 KEYBOARD "SIPROMAC"	1	4	005A0568	SEAL BAR ASSY W/SUPPORT	4
								4	005D00569	SEAL BAR ASSY W/SUPPORT (ECO)	4
								2	004A4132	UPPER SEAL BAR ASSEMBLY (E.C.O.)	2
								4	005B0570	SEAL BAR ASSY W/SUPPORT (T&B)	4
								2	005B0386	UPPER SEAL BAR ASSY W/SUPPORT	2
								1	036-0409	PRESSE-ETOIPE CD13	1
								1	009B0136	8" TOP & BOTTOM COVER REWORKED	1
								1	009B0137	12" TOP & BOTTOM COVER REWORKED	1
								1	005A0453	8" COVER ASSEMBLY	1
								1	005A0454	12" COVER ASSEMBLY	1
								2	130-4PHB	4" SWIVEL CASTER W/BRAKE	2
								2	130-4PHO	4" SWIVEL CASTER W/O BRAKES	2
								32	051-0760	WASHER 5/16" FLAT S/S	32
								16	051-0601	NUT 5/16"-18 NYLON LOCK S/S	16
								16	051-0300	BOLT 5/16"-18 x 3/4" S/S	16
								2	005A0446	RIGHT GAS 4 INJECTION BAR ASSEMBLY	2
								2	005A0811	LEFT GAS 4 INJECTION BAR ASSEMBLY	2
								2	005A0810	LEFT GAS 3 INJECTION BAR ASSEMBLY	2
								2	005-0571	RIGHT GAS 3 INJECTION BAR ASSEMBLY	2
								2	004A4113	GAS VALVE ASSEMBLY (OPTION)	2
								4	104-0064	SILICONE TUBING 3/8" OD x 3/16" ID x 80mm	4
								1	004B1471	PUMP "BUSCH" 255 M ³	1
								1	004B1468	PUMP "BUSCH" 100 M ³ ASSEMBLY	1
								1	004B1469	PUMP "BUSCH" 165 M ³ ASSEMBLY	1
								1	004A4141	PUMP "BUSCH" 305 M ³	1
								1	004A4103	AIR REGULATOR VALVE ASSY	1
								1	004A4105	BELLOWS VALVE ASSY (OPT AIR REG)	1
								1	004A4106	VACUUM/ATMOSPHERE VALVE (OPT MUFFLER)	1
								1	004A4107	VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR)	1

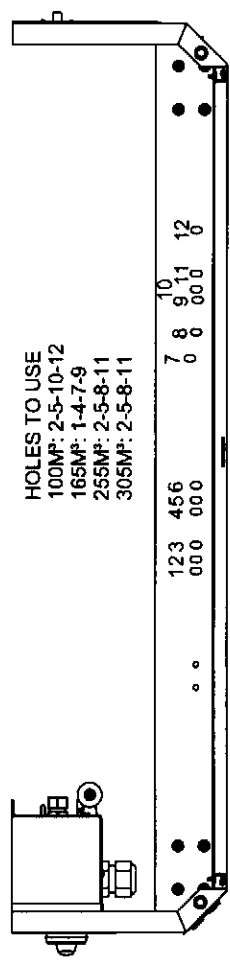
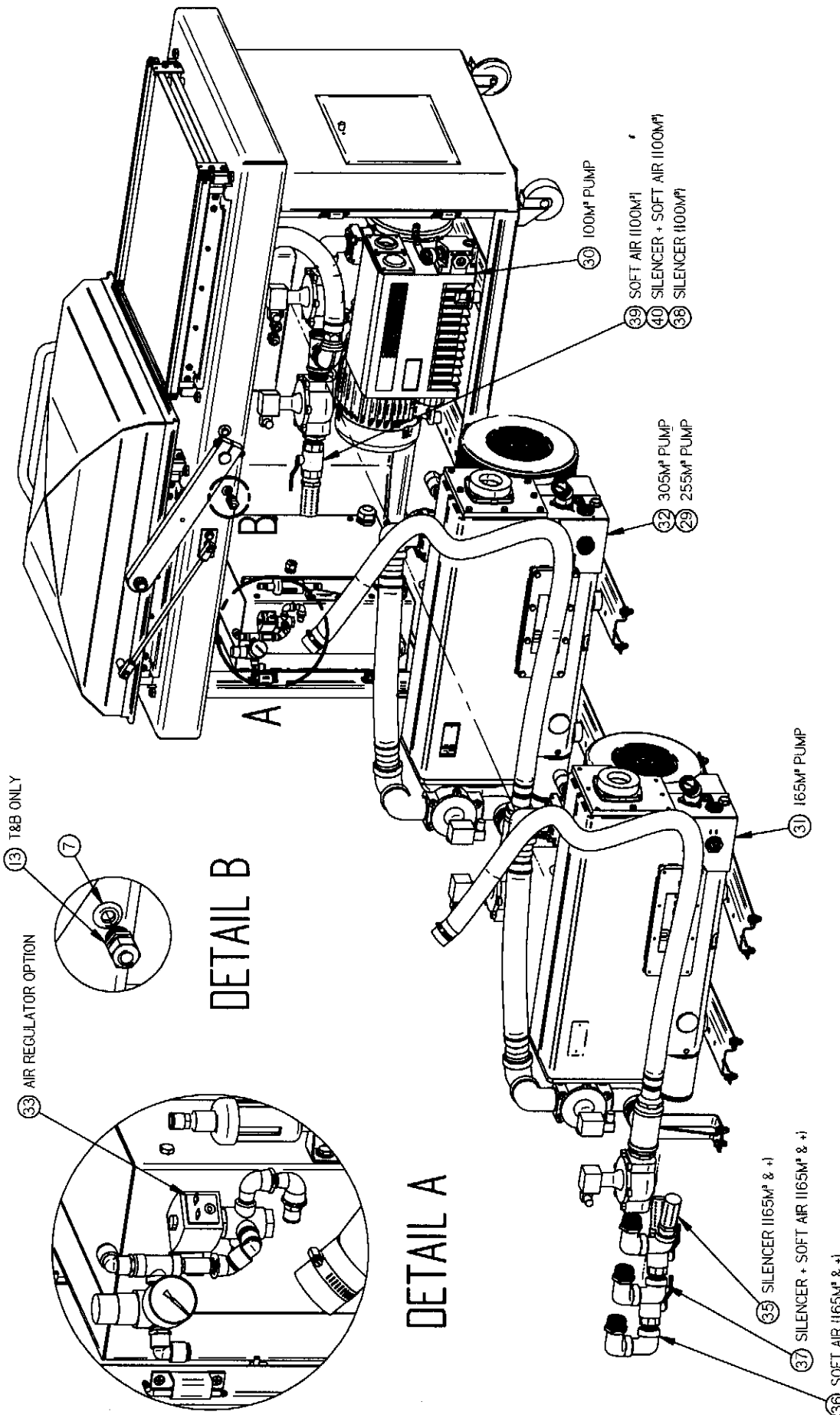


MACHINE		600A		SIPROMAC	
PART		MACHINE ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM	QTY	REP.	QTY	REP.	QTY
DATE	13-12-11	DATE	13-12-11	DATE	13-12-11
APP. BY	SBU	APP. BY	SBU	APP. BY	SBU
MODIFICATION		MODIFICATION		MODIFICATION	
DATE		DATE		DATE	
INT.		INT.		INT.	
1005D0324		1005D0324		1005D0324	



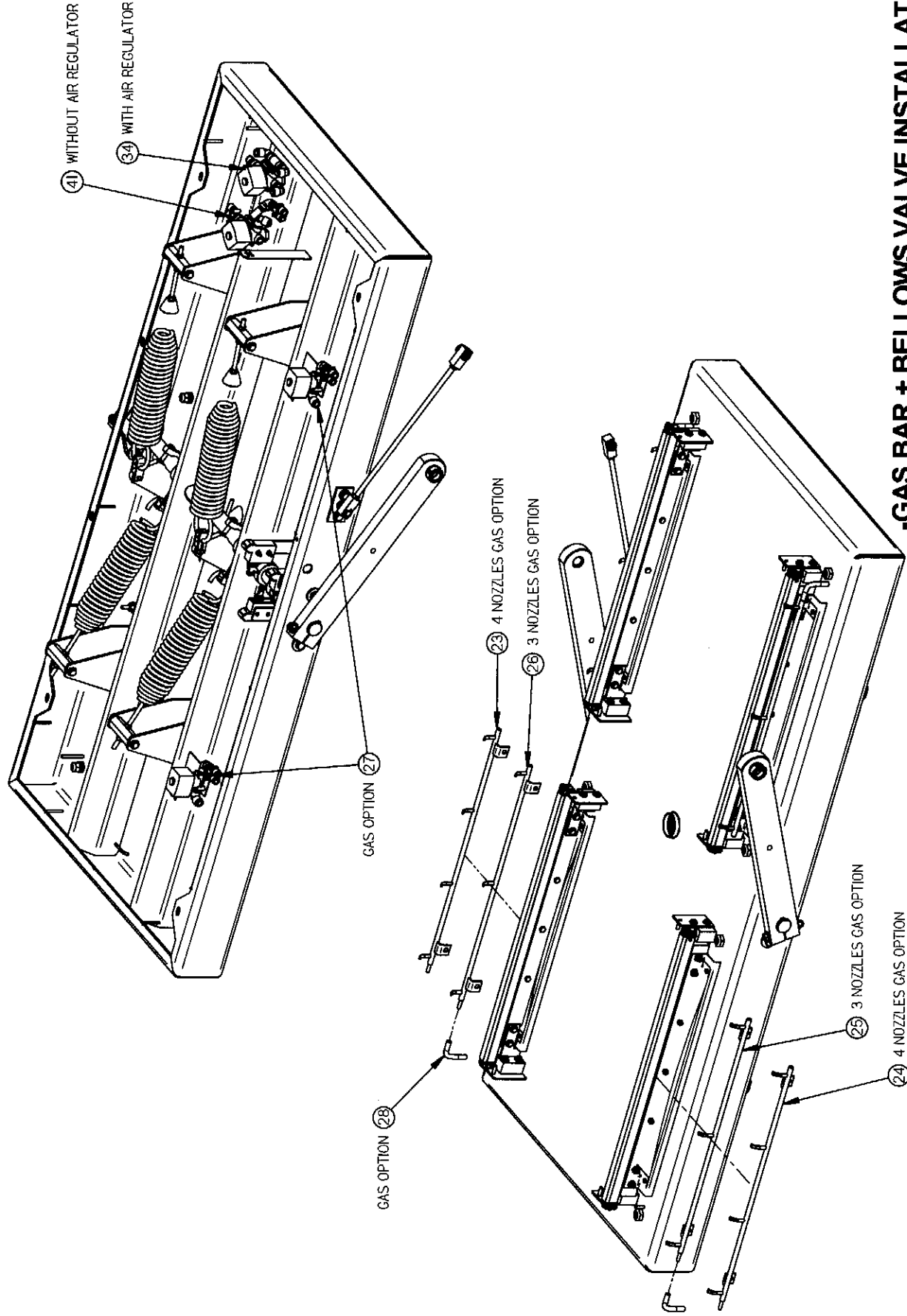
MACHINE	600A	DEPT. OF METRIC INCH	± 0.1	± 0.004
PART	MACHINE ASSEMBLY	USINANCE	± 0.1	± 0.004
ITEM	CNC	CYLINDRICAL	± 0.1	± 0.004
MAT.	SBU	SQUARE	± 0.1	± 0.004
DATE	13-12-11	DATE	13-12-11	DATE
REP.	M-J	REP.	N.T.S.	REP.
QTY.	1	QTY.	1	QTY.

005D0324



-PUMP + AIR REGULATOR INSTALLATION-

MACHINE	600A	DEPT. 100 METRIC INCH	STIPROMAC
PART	MACHINE ASSEMBLY	USINAGE ± 0.1 ± 0.004	ST-GERMAIN DE GRANBY
ITEM		TOLERANCE ± 0.5 ± 0.020	QUEBEC CANADA
MAT.		SOUDAGE ± 0.5 ± 0.020	
		N.T.S.	
		DEPT.	M-1
		DATE 13-12-11	NO. 005D0324
		APP. BY: SBU	



-GAS BAR + BELLOWS VALVE INSTALLATION-

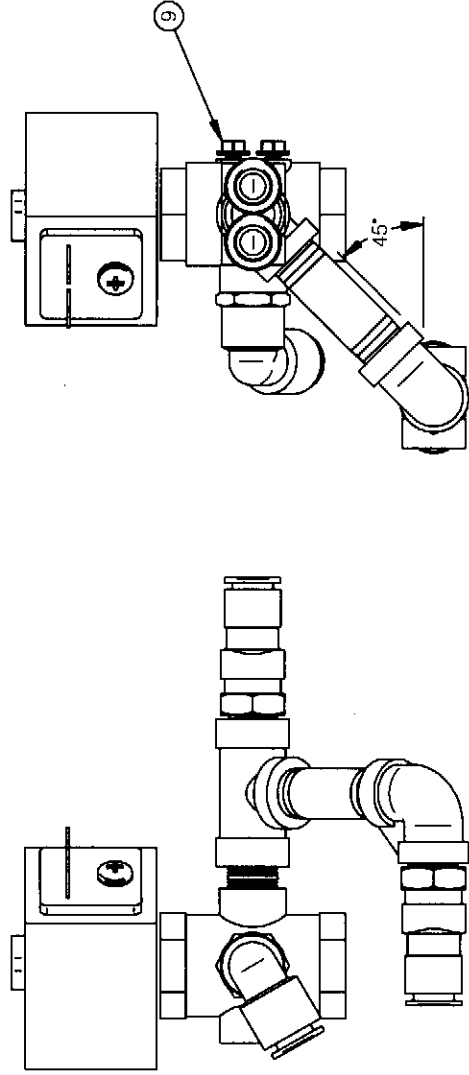
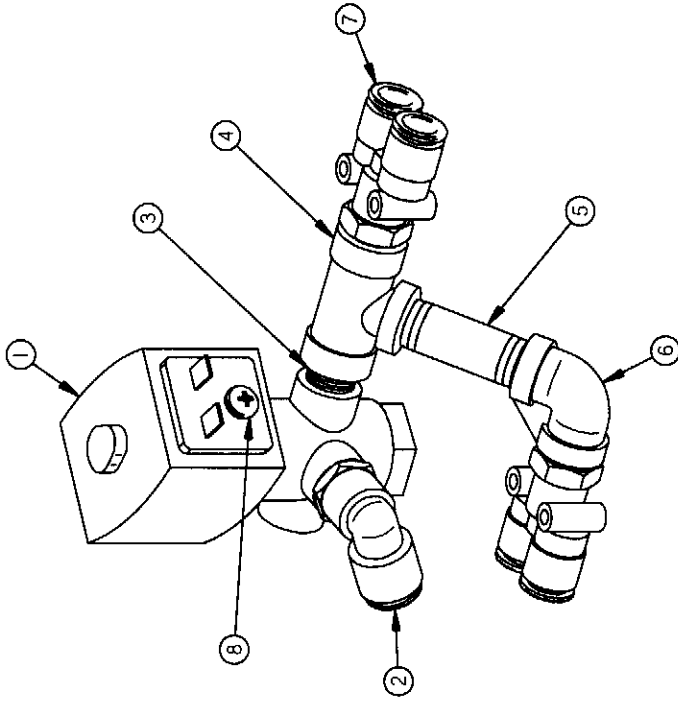
MACHINE		SIPROMAC		ST-GERMAIN DE GRANITHAM QUEBEC CANADA	
PART		MACHINE ASSEMBLY		ITEM	
DRAWN BY		CHK		DEPT.	
APP. BY		SBU		M-1	
DATE		13-12-11		NO.	
				QTY.	
				1	
				005D0324	

USINAGE	± 0.05	± 0.05	± 0.05
TOLERANCE	± 0.5	± 0.5	± 0.5
SOUDEUSE	± 0.5	± 0.5	± 0.5

N.T.S.

004A4104

ITEM	PART #	DESCRIPTION	QT.
1	106-0070	VALVE 3WAY 24V 1/4"NPT(G176)60Hz	1
2	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	1
3	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
4	100-0463	TEE 1/4" NPT S/S	1
5	100-0290	NIPPLE 1/4" NPT x 2" S/S	1
6	100-0015	ELBOW 90° x 1/4"NPT SS	1
7	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	2
8	051-01753	SCREW 10-32 X 3/8" PAN PHIL SS	1
9	051-01065	SELF TAPPING SCREW 8-32 X 3/8" HEX SS	2

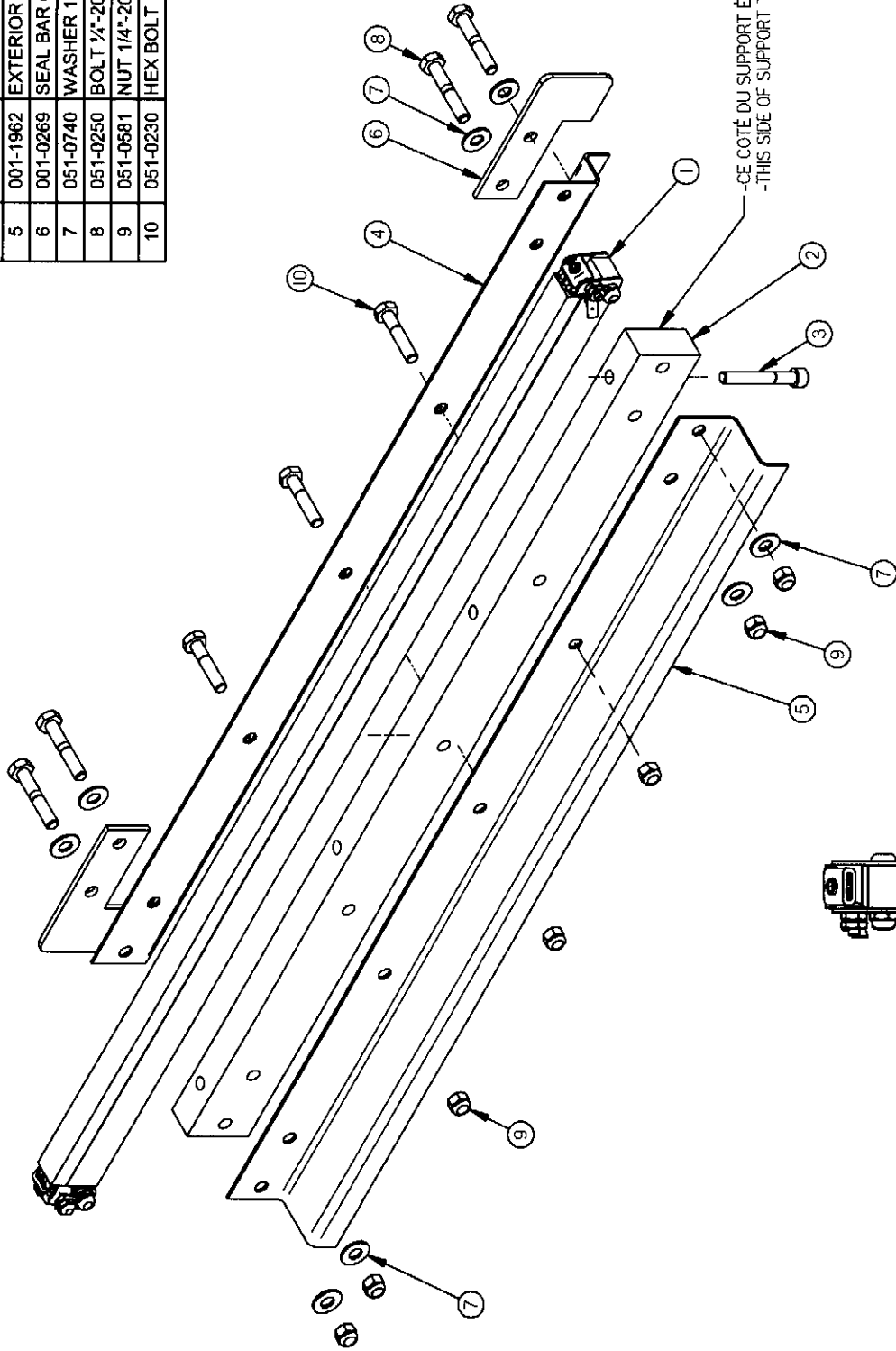


MACHINE		SIPROMAC		STY.:	M	QTY:	1
PART		BELLAWS VALVE ASSY		DATE:	13-09-17	NO.:	004A4104
ITEM		CNC		DEPT.			
MAT.		SBU		DATE			
		APP. BY:		DATE			
		N.T.S.		DEPT.			
		TOLERANCE		±0.020"			
		STAVAGE		±0.003"			
		SOUDEAGE		±0.5			

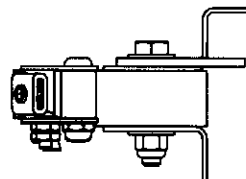
LET. _____ DATE INT. _____
 MODIFICATION _____

1005A0568

ITEM	PART #	DESCRIPTION	QT.
1	005A0152	SEAL BAR PRE-ASSY	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOW'S COVER	1
5	001-1962	EXTERIOR BELLOW'S COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	8
8	051-0250	BOLT 1/2"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3



--CE CÔTÉ DU SUPPORT ÉGAL AVEC DE LA BARRÉ DE SCELLAGE.
 --THIS SIDE OF SUPPORT TO FIT FLUSH W/ SEAL BAR.



-END VIEW-

-ITEM #2 ÉGAL AVEC L'ITEM #4 & #5.
 -ITEM #2 FLUSH WITH ITEM #4 & #5.

-TWIN SEAL OPTION -

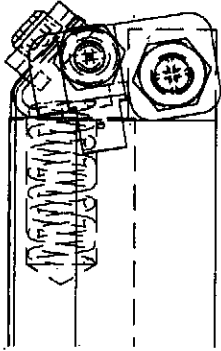
MACHINE	600A	4
	550A	2
MACHINE	QTY	
SIPROMAC		
ST-GERMAIN DE GRANVILLE		
QUEBEC CANADA		
REVISION	DATE	BY
1	11-08-30	J.G.
2	11-08-30	J.G.
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E	ENLEVE 001A5692 ET 038-0230	12-06-19	S.B.
D	REDESSINE - AJOUTER 001A5692	11-08-30	J.G.
LET.	MODIFICATION		

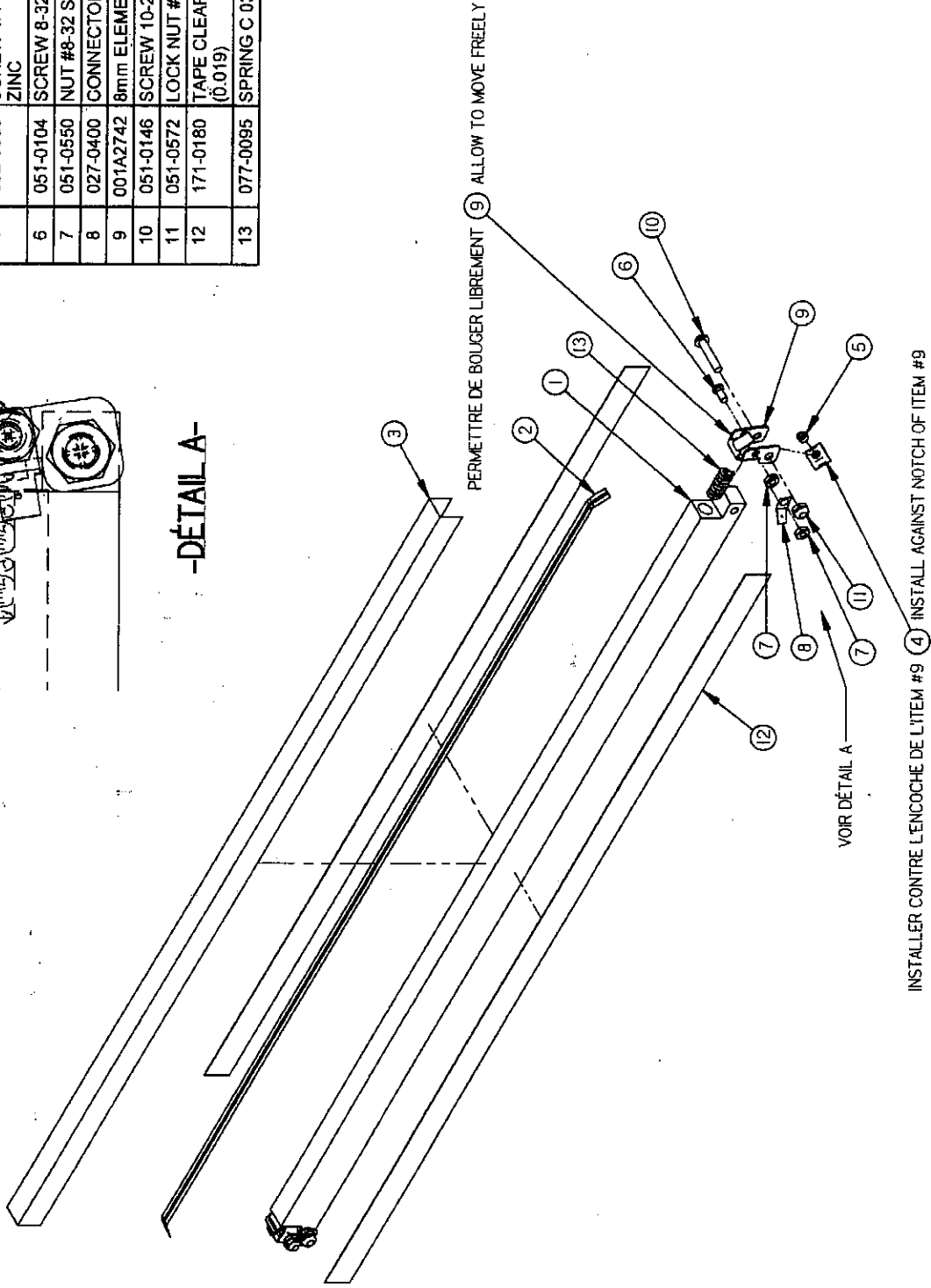
M-J-(M) LISTE
005A0568

005A0152

ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	039-0268	DOUBLE SEAM BAND (8MM) (2.3)	1
3	176-0200	TEFLON TAPE, 5MIL (0.78)	1
4	056-1401	3/8" SET SCREW BANDING BUCKLE S/S	2
5	052-0393	SCREW 1/4-28x3/16" SKT SET OVAL POINT ZINC	2
6	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
7	051-0550	NUT #8-32 SS.	4
8	027-0400	CONNECTOR ADAPTOR	2
9	001A2742	8mm ELEMENT BINDER	2
10	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
11	051-0572	LOCK NUT #10-24 S/S	2
12	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2
13	077-0095	SPRING C 0360-059-1250 S/S	2



-DÉTAIL A-



INSTALLER CONTRE L'ENCOCHE DE L'ITEM #9 (4) INSTALL AGAINST NOTCH OF ITEM #9

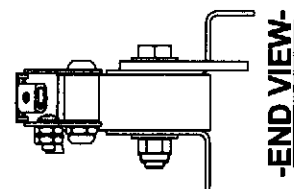
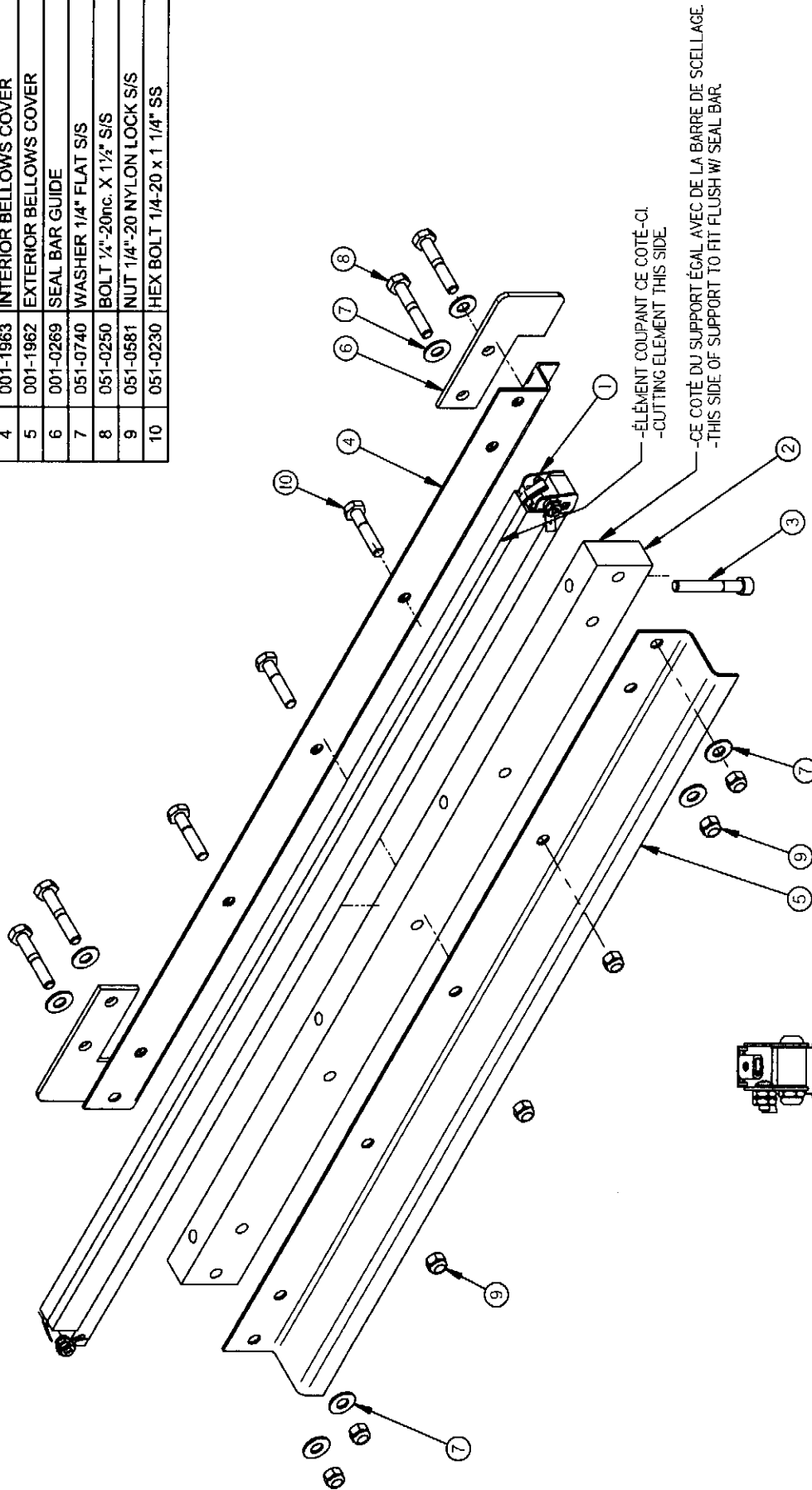
-TWIN SEAL OPTION-

MACHINE	550A & 600A	DEPT	03
PART	SEAL BAR PRE-ASSY	USINAGE	± 0.1 ± 0.04
ITEM		TOLERANCE	± 0.5 ± 0.007
REV.		SOLDAGE	± 0.5 ± 0.007
			N.T.S.
DATE	05-08-13	NO	
APP BY		REV	10-09-02
		DEPT	
		M (M) J	LISTE
			005A0152

H	MODIF. A-453 AJOUTER 077-0095	10-06-01	J.G.
G	ADDED 052-0393	08-04-19	M.A.
F	051-0104 & 001B2742 ETAIT 051-0100 & 009A0187	06-03-06	J.G.
E	REDRAWN	05-09-13	M.A.
LET.	MODIFICATION	DATE	INT.

1005D0569

ITEM	PART #	DESCRIPTION	QT.
1	005D0153	SEAL BAR PRE-ASS'Y	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOW'S COVER	1
5	001-1962	EXTERIOR BELLOW'S COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	8
8	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3



-ITEM #2 ÉGAL AVEC L'ITEM #4 & #5.
 -ITEM #2 FLUSH WITH ITEM #4 & #5.

-BAG CUT OPTION-

MACHINE	550A & 600A
PART	SEAL BAR ASSY W/SUPPORT
ITEM	
DATE	13-11-06
BY	SBU
CHKD	
REPT	M-1(M) LISTE
NO	005D0569

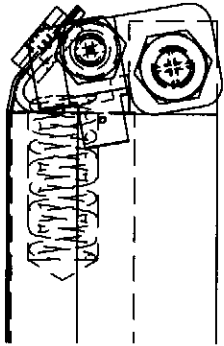
600A	4
550A	2
MACHINE	QTY

SIPROMAC
 ST-GERMAIN DE GRANTHAM
 QUÉBEC CANADA

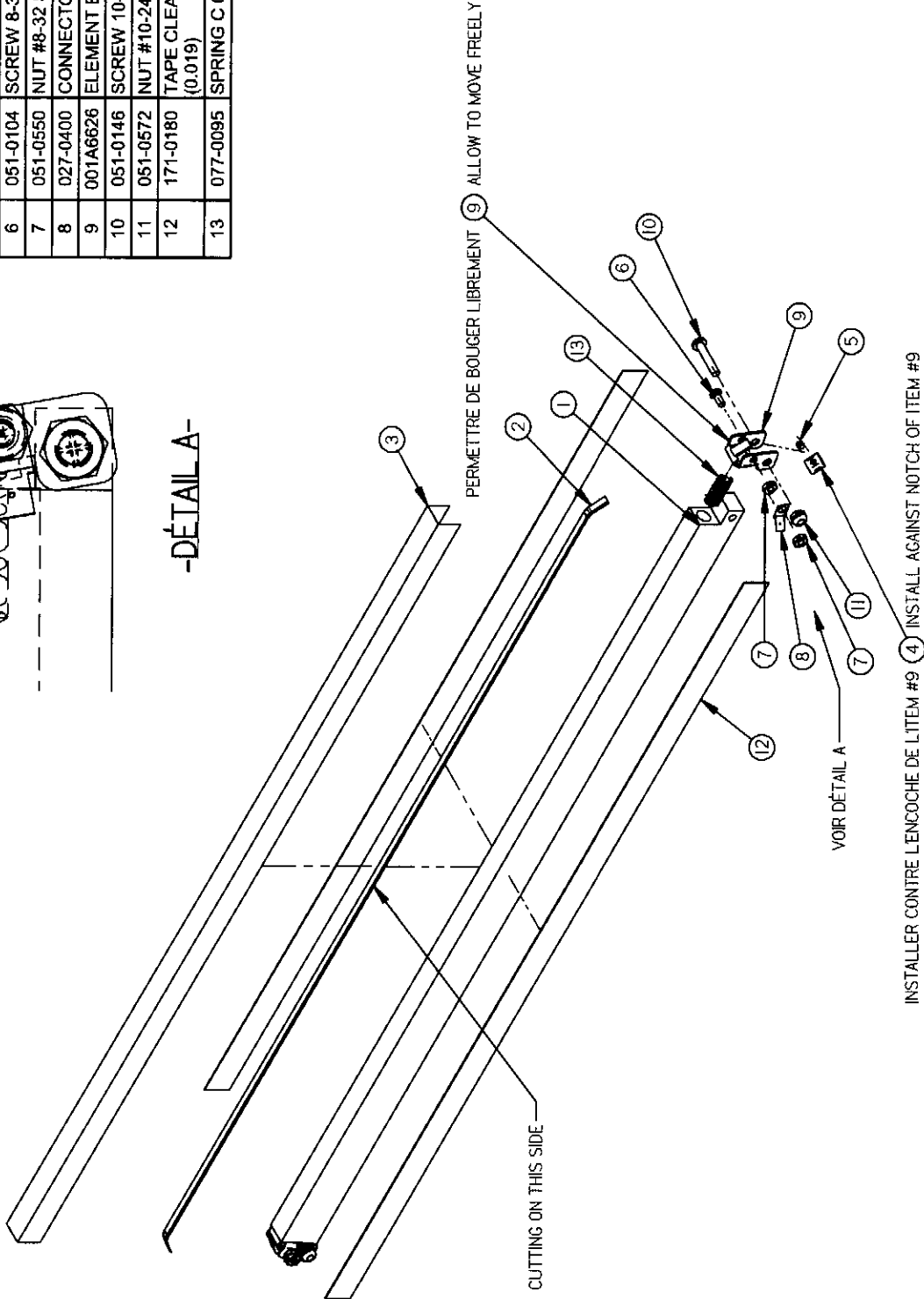
G.	005D0153 WAS 005C0153	13-11-06	SBU
LET.	MODIFICATION	DATE	INT.

1005D0153

ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	039-0269	SEAL CUT ELEMENT (0.0688)	1
3	176-0200	TEFLON TAPE, 5MIL (0.78)	1
4	056-1400	1/4" SET SCREW BANDING BUCKLE S/S	2
5	056-1400	1/4" SET SCREW BANDING BUCKLE 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	001A6626	ELEMENT BINDER 6.5MM	2
10	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
11	051-0572	NUT #10-24 NYLON LOCK S/S	2
12	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2
13	077-0095	SPRING C 0360-059-1250 S/S	2



-DÉTAIL A-



-BAG CUT (ECO)-

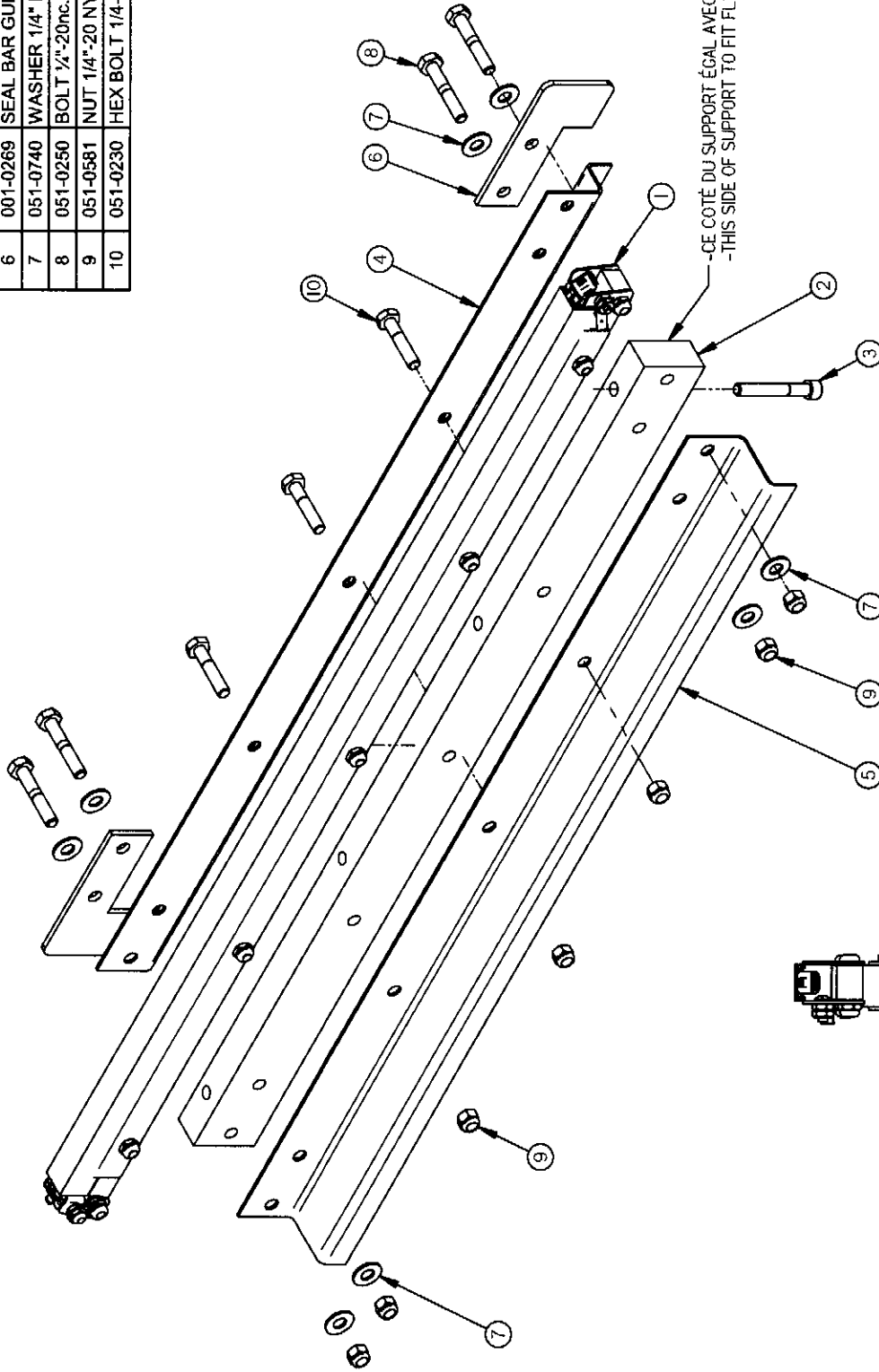
MACHINE	550A & 600A	NEW DESIGN	13-11-06	DATE	13-11-06
PART	SEAL BAR PRE-ASSY	DESIGNED BY	SBU	DATE	13-11-06
ITEM		APP. BY			
MAT.					
DEPT.					
NO.					
LISTE					
M-(M)-H					
005D0153					

K	NEW DESIGN	13-11-06	SBU
LET.	MODIFICATION	DATE	INT.

600A	4
550A	2
MACHINE	QTY
SIPROMAC	
ST-GERMAIN DE GRANBY	
QUEBEC CANADA	

1005B0570

ITEM	PART #	DESCRIPTION	QT.
1	005B0370	SEAL BAR PRE-ASSY	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOWS COVER	1
5	001-1962	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	8
8	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	7
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3



-ITEM #2 ÉGAL AVEC L'ITEM #4 & #5.
 -ITEM #2 FLUSH WITH ITEM #4 & #5.

-END VIEW-

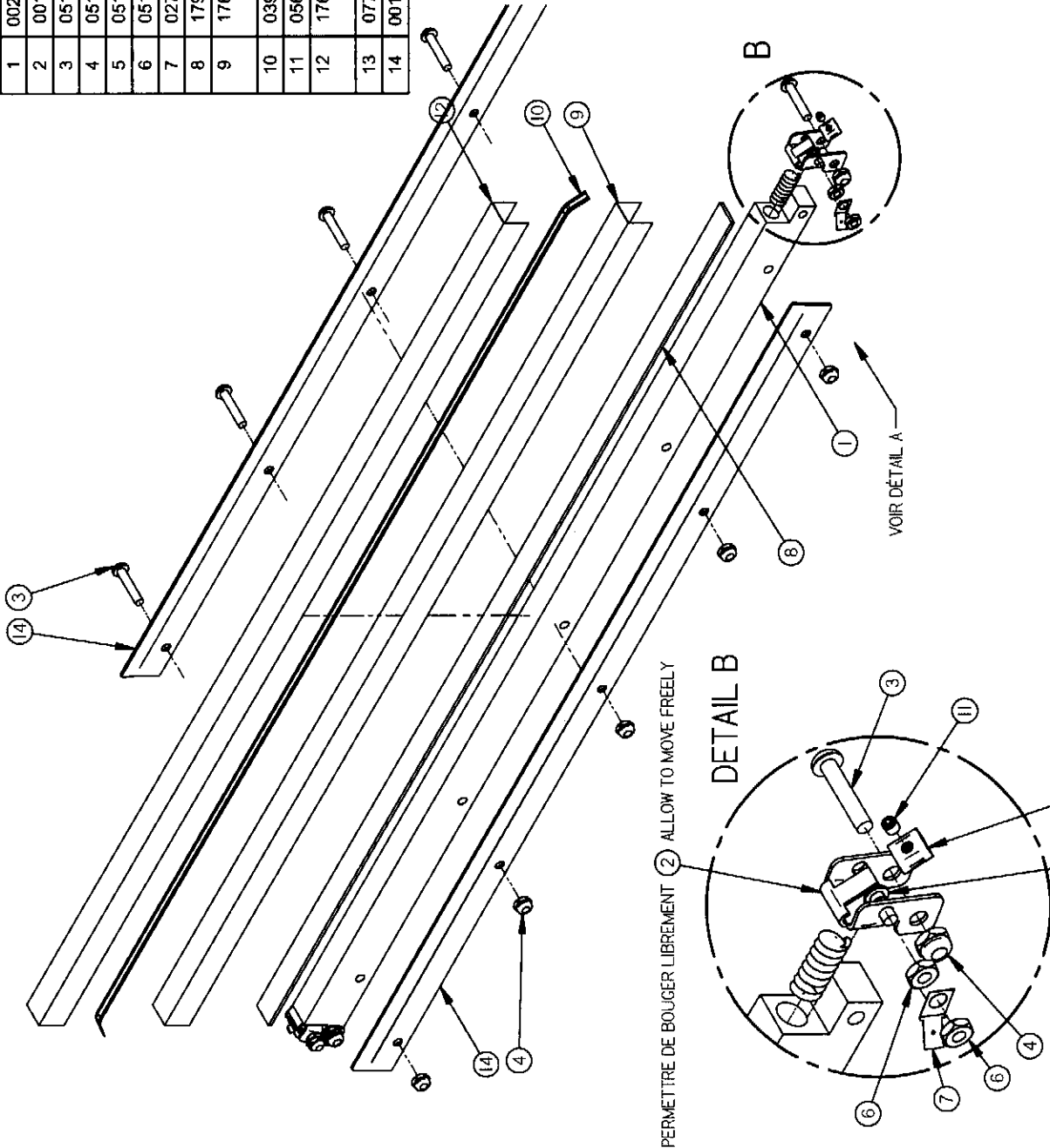
-TOP & BOTTOM SEALING OPTION-

MACHINE	550A & 600A	DEPT. TO INVENTORY IN CH.	600A	4
PART	SEAL BAR ASSY W/SUPPORT	USAGE	550A	2
ITEM		CLASSE	MACHINE QTY	
DAT.		SCISSURE	SIPROMAC	
			ST-GERMAIN DE GRANTHAM	
			QUEBEC CANADA	
			M-I-(M) QTY LIST	
			NO. 005B0570	
			DATE 13-09-25	
			DATE	
			SBU	
			DATE INT.	

E. 005B0370 WAS 005A0370 13-09-25 SBU
 LET. MODIFICATION DATE INT.

005B0370

ITEM	PART #	DESCRIPTION	QTY.
1	002A4146	SEAL BAR	1
2	001-2666	ELEMENT BINDER	2
3	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	7
4	051-0572	NUT #10-24 NYLON LOCK S/S	7
5	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
6	051-0550	NUT #8-32 SS	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm 641.5mm (0.64)	1
9	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" 641.5mm (0.078)	1
10	039-0220	BI-ACTIVE SEALING ELEMENT (0.07)	1
11	056-1400	1/4" SET SCREW BANDING BUCKLE S/S	2
12	176-0203	TEFLON TAPE, 5MIL UNCOATED ZONE 641.5mm (0.064)	1
13	077-0095	SPRING C 0360-059-1250 S/S	2
14	001A6580	TEFLON HOLD DOWN PLATE	2

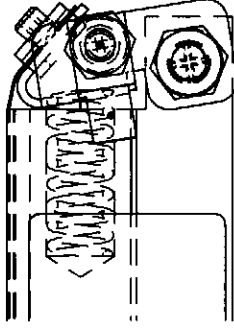


PERMETTRE DE BOUJER LIBREMENT ② ALLOW TO MOVE FREELY

DETAIL B

VOIR DÉTAIL A

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



-DÉTAIL A-

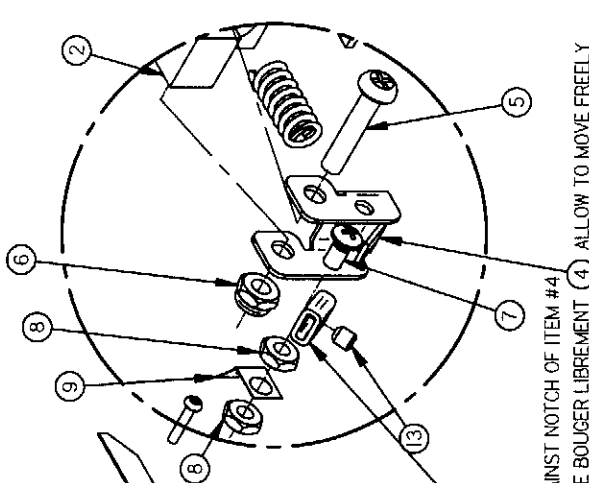
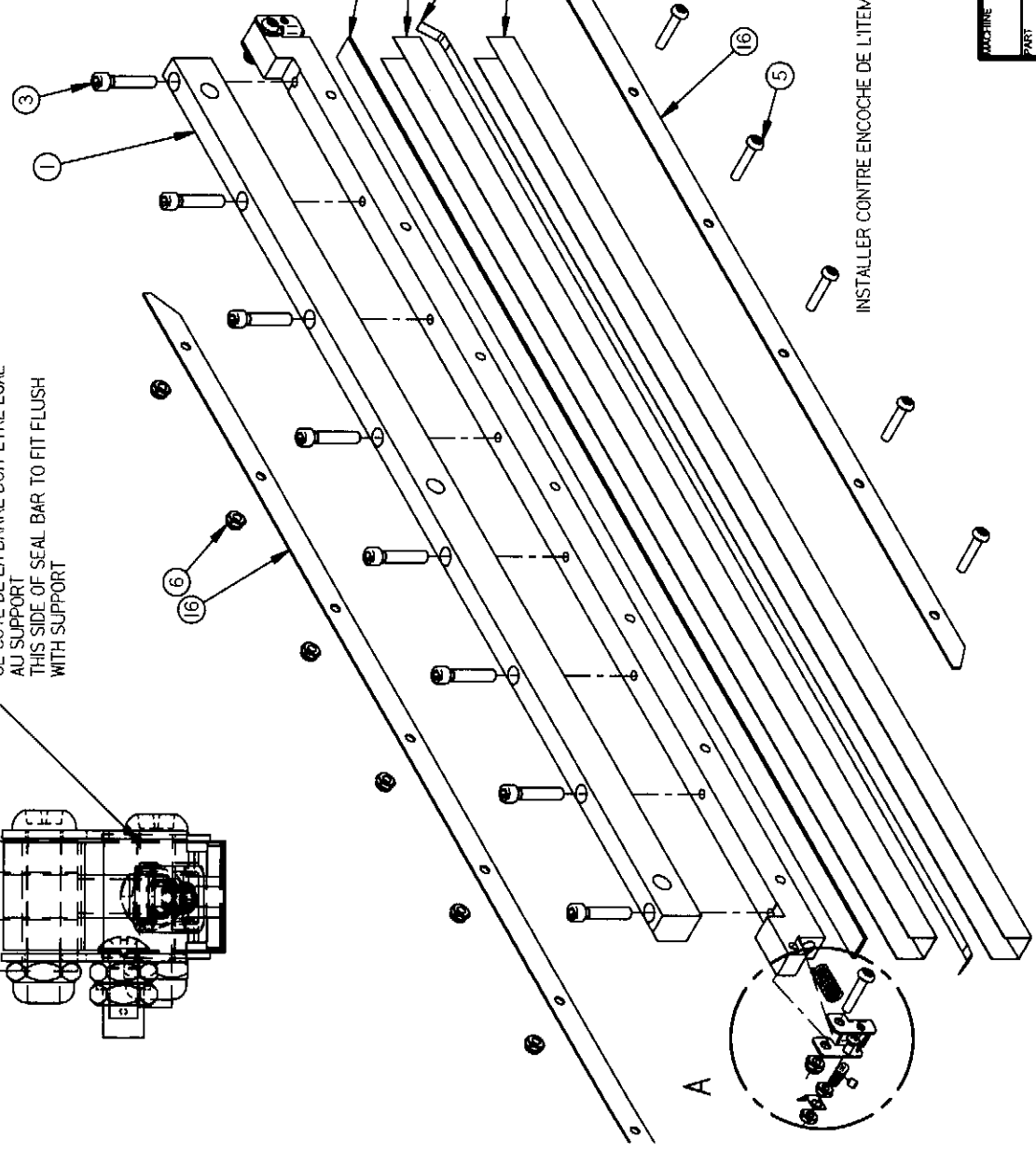
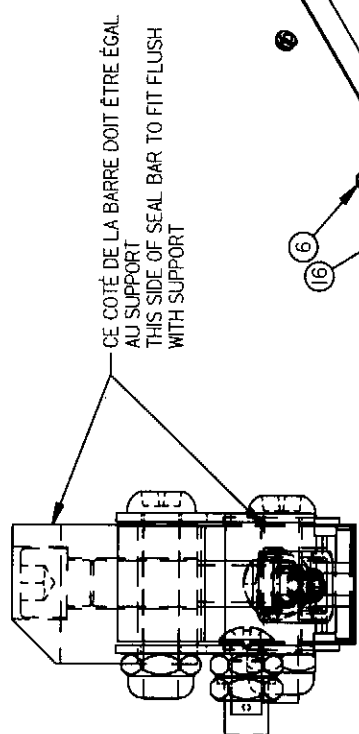
-TOP & BOTTOM
SEALING OPTION-

MACHINE	550A & 600A	REF. TO METRIC SCSH	4.01	3.0000	1.00
PART	SEAL BAR PRE-ASSY	USINAGE	2.01	3.0000	1.00
ITEM		BOULAGE	1.00	1.0000	1.00
MAT.					
REP.					
DATE	13-09-25				
APP. BY	SBU				
NO.					
REP.					
MACHINE QTY	600A	4			
	550A	2			
	MACHINE QTY				
	SIPROMAC				
	ST-GERMAIN DE GRANBY				
	QUEBEC CANADA				
	M-(M)-I LISTE				
	005B0370				

G	AJOUT TEFLOH HOLDER	13-09-25	SBU
LET.	MODIFICATION	DATE	INT.

1005B0386

ITEM	PART #	DESCRIPTION	QT.
1	002A0534	UPPER SEAL BAR SUPPORT	1
2	002B0349	UPPER SEAL BAR	1
3	051-0232	SCREW 1/4-20x 1-1/4"SKT CAP SS	8
4	001-2666	ELEMENT BINDER	2
5	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	9
6	051-0572	NUT #10-24 NYLON LOCK S/S	9
7	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
8	051-0650	NUT #8-32 SS	4
9	027-0400	CONNECTOR ADAPTOR	2
10	179-0003	SILICONE 2mm x 15mm ADHESIVE 683mm (0.68)	1
11	176-0220	TEFLON TAPE,PRESS.SENSITIVE 2" 683mm (0.08)	1
12	039-0220	BI-ACTIVE SEALING ELEMENT (6mm) 726mm (0.07)	1
13	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
14	077-0095	SPRING C 0360-059-1250 S/S	2
15	176-0203	TEFLON TAPE, 5MIL UNCOATED ZONE 683mm (0.08)	1
16	001A6581	UPPER TEFLON HOLDER	2



INSTALLER CONTRE ENCOCHE DE L'ITEM #4 (13) INSTALL AGAINST NOTCH OF ITEM #4
PERMETTRE DE BOUGER LIBREMENT (4) ALLOW TO MOVE FREELY

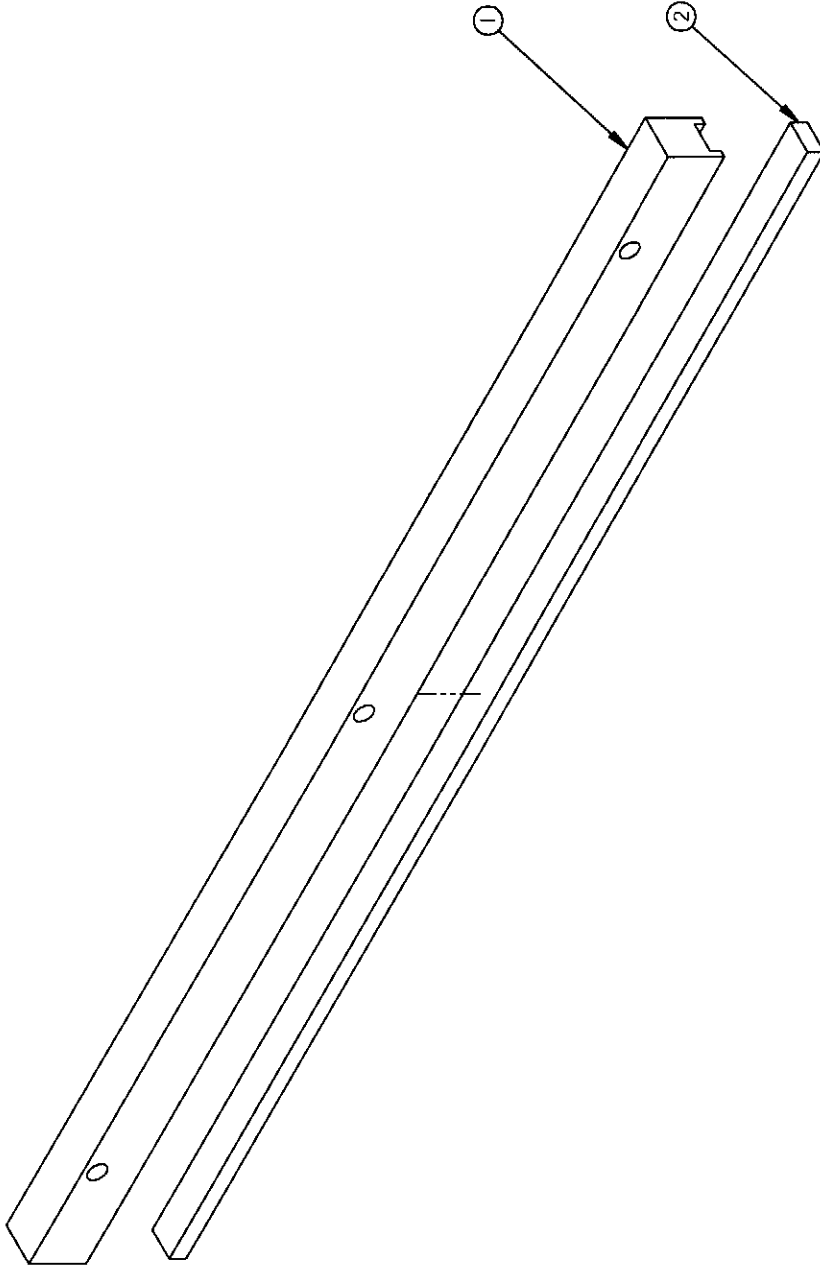
-TOP & BOTTOM SEALING OPTION-

MACHINE		600A	
PART		UPPER SEAL BAR ASSY W/SUPPORT	
ITEM		N.T.S.	
DATE		13-09-25	
DRAWN BY		SBU	
CHECKED BY		M-(M)-1	
DATE		13-09-25	
NO.		005B0386	

H	13-09-25	SBU
LET.	MODIFICATION	DATE INT.

004A1326

ITEM	PART #	DESCRIPTION	QT.
1	002A2061	UPPER SEAL BAR SUPPORT	1
2	008-0311	UPPER SEAL BAR RUBBER	1



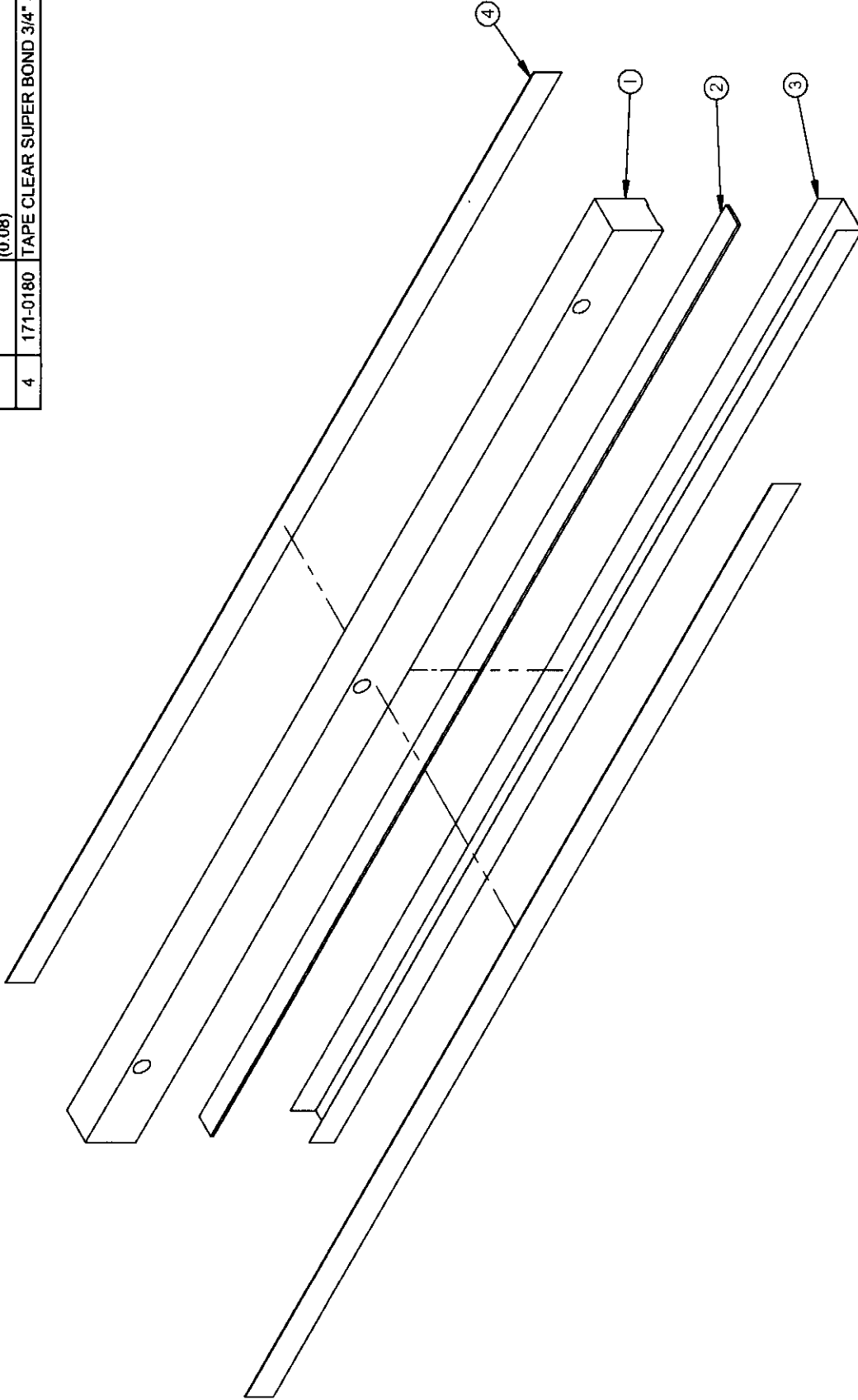
-TWIN SEAL-

MACHINE		DEPT. TO: M.S. (R) S.H.		SIPROMAC	
PART		USURGE	1 0 1	ST-GERMAIN DE GRANITUM	
ITEM		DATE	1 0 1	QUEBEC CANADA	
MAT.		QUANTITE	1 0 1	REPT. M-1	
600A		DATE	08-04-30	QTY 2	
UPPER SEAL BAR ASSEMBLY (E.C.O.) & (TWIN)		DATE	08-04-30	NO. 004A1326	
DRAWN BY: J.G.		DATE	08-04-30	M-1	
APP. BY:		DATE	08-04-30	QTY 2	

C	ENLEVE BAG CUT	13-11-06	SBU
B	MODIF #A-0444 / AJOUTER TWIN ET AJ 005A0573	10-10-01	J.G.
A	REDESSINE VOIR AUSSI 004A2557 & 004A2558	08-04-30	J.G.
LET.	MODIFICATION	DATE	INT.

1004A4132

ITEM	PART #	DESCRIPTION	QTY.
1	002A4160	UPPER SEAL BAR SUPPORT (ECO)	1
2	179-00035	SILICONE 2mm x 15mm ADHESIVE 60 DURO (770mm)	1
3	176-0200 (0.08)	TEFLON TAPE,PRESS.SENSITIVE 2" 720mm	1
4	171-0180	TAPE CLEAR SUPER BOND 3/4" (0.024)	2



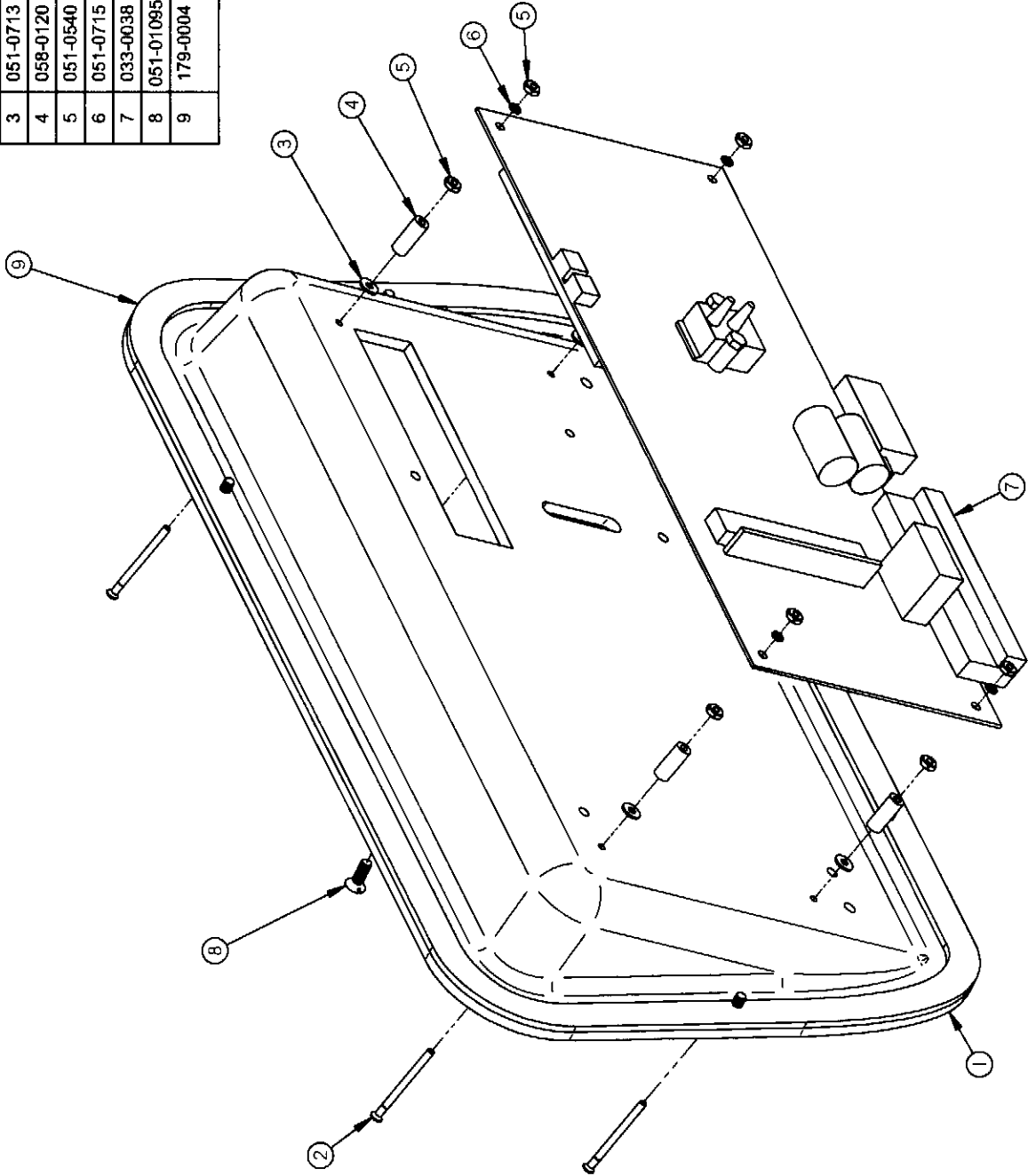
-BAG CUT-

MACHINE		DEPTH OF METRIC INCH		SIPROMAC	
PART		USINAGE	± 0.1	± 0.004	ST-GERMAIN DE GRANBY
ITEM		TOLERANCE	± 0.1	± 0.004	QUEBEC CANADA
DATE		DATE	13-11-06	DATE	NO.
BY		BY	SBU	BY	004A4132
APP. BY		APP. BY		APP. BY	
CNC		N.T.S.		DEPT.	M-J
QTY.		2			

LET. _____ DATE INT. _____

005B0583

ITEM	PART #	DESCRIPTION	QT.
1	003A0403	CONTROL INSERT	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
7	033-0038	MC-40 SENSOR VACUUM	1
8	051-01095	SCREW 8-32 x 1/2 FLAT SLOT SS	6
9	179-0004	NITRILE 1/2" X 1/8" AUTOCOILLANT X 1220mm long	1



MACHINE	VACUUM	DEPT. 100	INCH	SIPROMAC
PART	MC-40 CONTROL BOARD	USINAGE ± 0.1	± 0.004	ST-GERMAIN DE GRANTHAM
ITEM	CNC	LA PERE ± 0.5	± 0.020	QUEBEC CANADA
MAT.		SOUDEUSE 1.50	± 0.020	
DATE	13-11-21	N.T.S.		REP: M
APP. BY	SBU	NO.		QTY: 1
		005B0583		

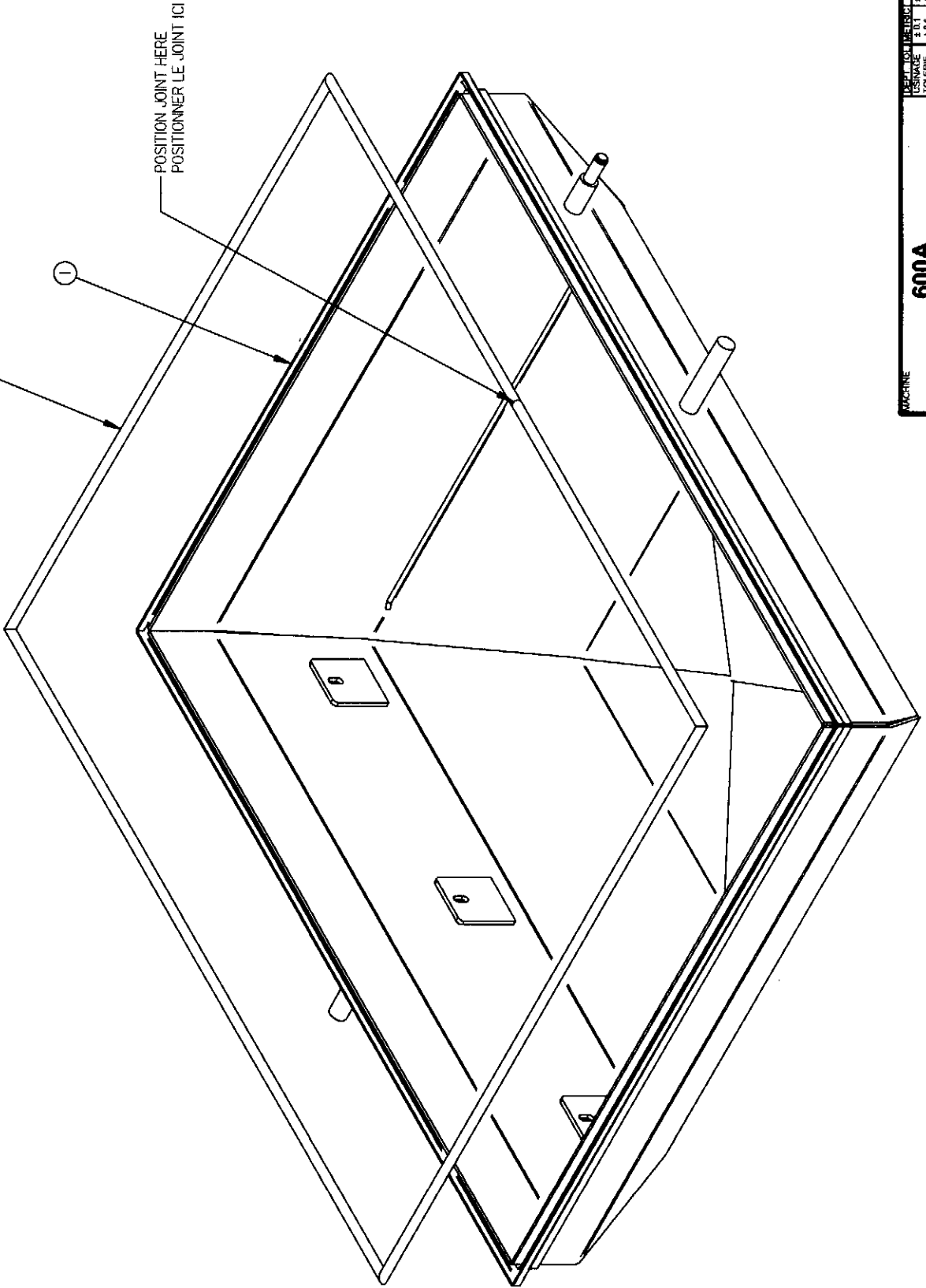
LET. _____ DATE INT. _____

MODIFICATION

1005A0454

ITEM	PART #	DESCRIPTION	QT.
1	004A0237	12" COVER PRE-ASSY	1
2	179-0020	NEOPRENE SPONGE 1/2" x 14.5'	1

USE PERMATEX RUBBER ADHESIVE 169-0010 TO GLUE ② UTILISER PERMATEX RUBBER ADHESIVE 169-0010 POUR COLLER



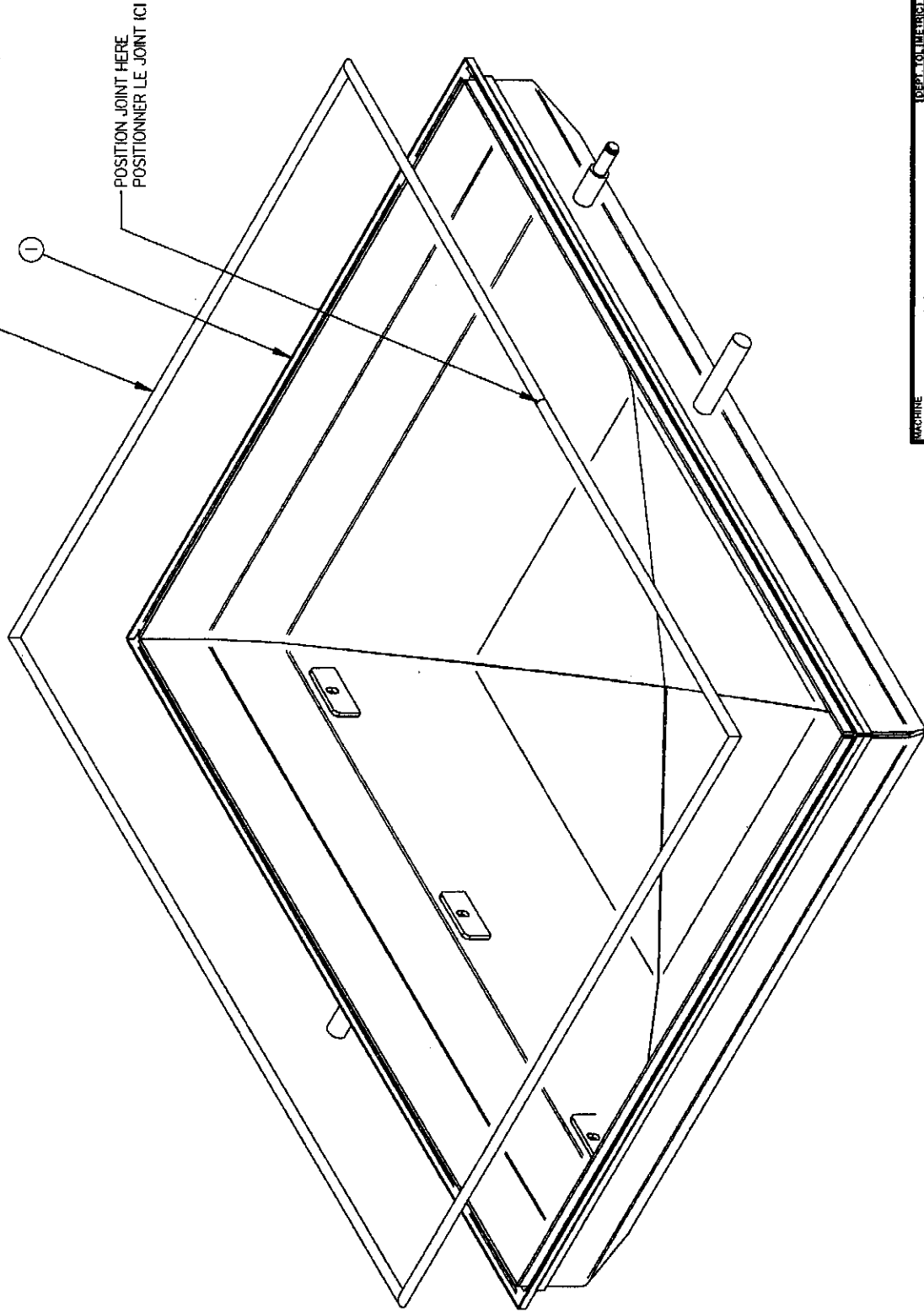
MACHINE	600A	DEPT. (O) (METRIC) (INCH)	± 0.1	± 0.004
PART	12" COVER ASSEMBLY	TOLERANCE	± 0.5	± 0.020
ITEM		SOLDING	± 0.5	± 0.020
MAT.				
		N.T.S.		
		DEPT.	M-(M)-1	QTY. 1
		DATE	10-10-01	
		BY	J.G.	
		APP. BY		
				NO. 005A0454

B	MODIF. #A-0444 / VOIR AUSSI 010A0085	10-10-01	J.G.
LET.	MODIFICATION	DATE	INT.

1005A0453

ITEM	PART #	DESCRIPTION	QT.
1	004A0236	8" COVER PRE-ASSY	1
2	179-0020	NEOPRENE SPONGE 1/2" x 14.5'	1

USE PERMATEX RUBBER ADHESIVE 169-0010 TO GLUE ② UTILISER PERMATEX RUBBER ADHESIVE 169-0010 POUR COLLER

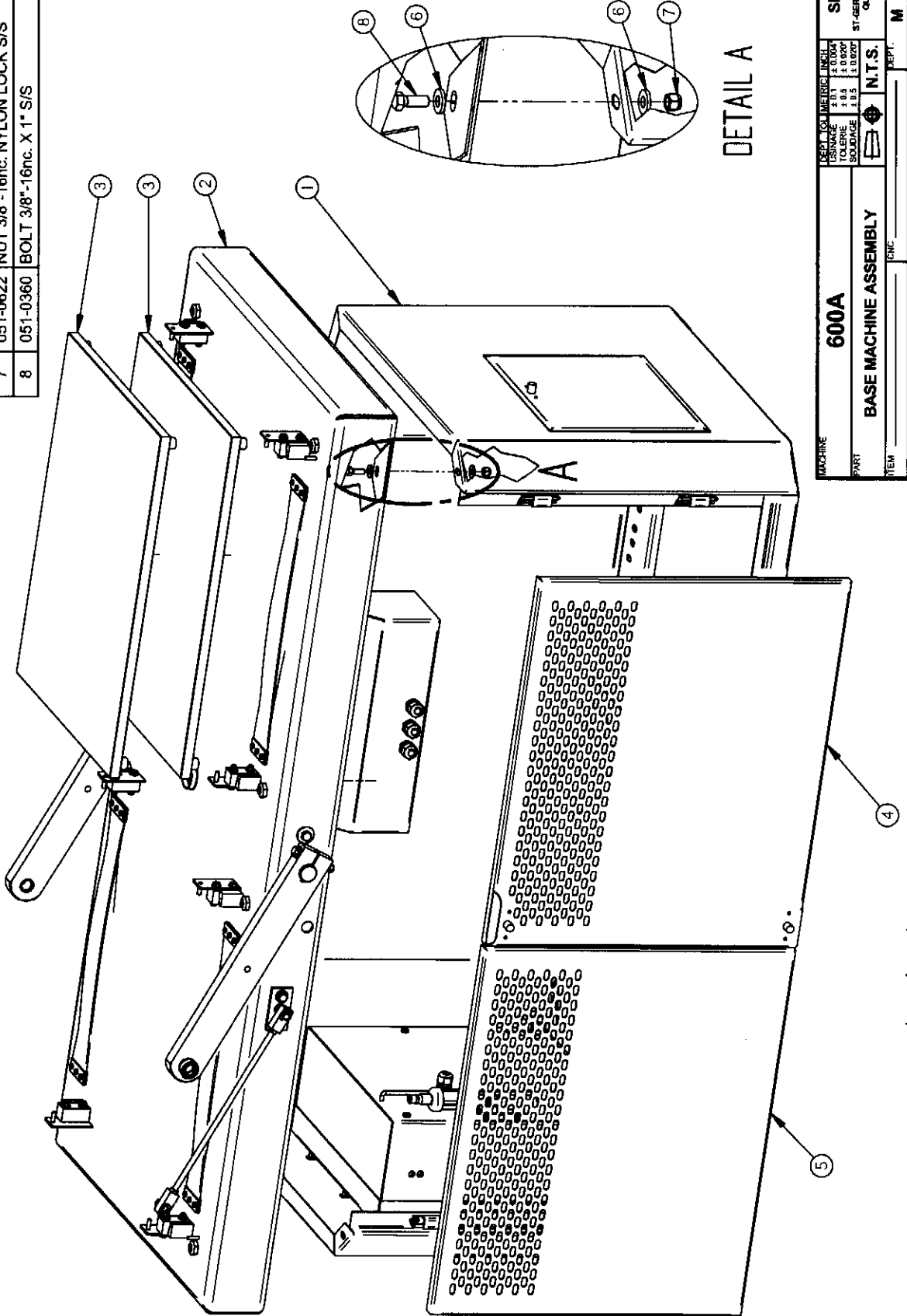


MACHINE		DEPT. TO DRAWING		SIPROMAC	
PART		USINAGE ± 0.1	± 0.05	ST-GERMAIN DE GRANITAN	
ITEM		TOLERANCE ± 0.5	± 0.5	QUEBEC CANADA	
MAT		SOUDEUSE ± 0.5		M-(M)-I	
CNC		N.T.S.		DEPT.	
DWG BY J.G.		DATE 10-10-01		NO	
APP. BY		DATE 10-10-01		005A0453	
600A		8" COVER ASSEMBLY		1	

B	REDESSINE MODIF. #A-0444 / VOIR AUSSI 010A0085	10-10-01	J.G.
L.E.T.	MODIFICATION	DATE	INT.

004A4146

ITEM	PART #	DESCRIPTION	QT.
1	005C0457	STRUCTURE ASSY	1
2	004A4145	TABLE W/ARM ASSY	1
3	005-0322	FILLER PLATE ASSEMBLY	4
4	004A4097	RIGHT REAR ACCESS DOOR ASSY	1
5	004A4095	LEFT REAR ACCESS DOOR PRE-ASSY	1
6	051-0783	WASHER 3/8" FLAT THICK S/S	12
7	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	6
8	051-0360	BOLT 3/8"-16nc. X 1" S/S	6



DETAIL A

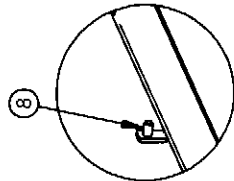
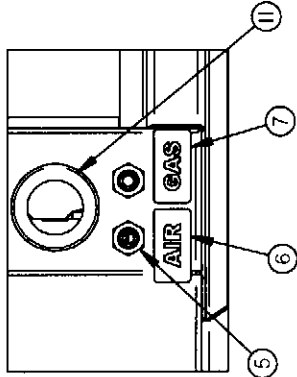
MACHINE	6000A	DEPT. 100 AMERICAL INCH	± 0.1	± 0.004
PART	BASE MACHINE ASSEMBLY	TOLERANCE	± 0.5	± 0.020
ITEM		SOLDAGE	± 0.5	± 0.020
MAT.		N.T.S.		
DATE	13-11-26	DATE		
APP. BY	SBU	DATE		
APP. BY		DATE		
REPT.	M	REPT.		
QUANTITY	1	QUANTITY		
SIPROMAC			ST-GERMAIN DE GRANITHAM	
			QUEBEC CANADA	
			004A4146	

LET.	MODIFICATION	DATE	INT.
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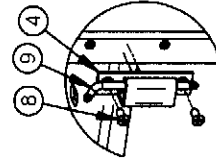
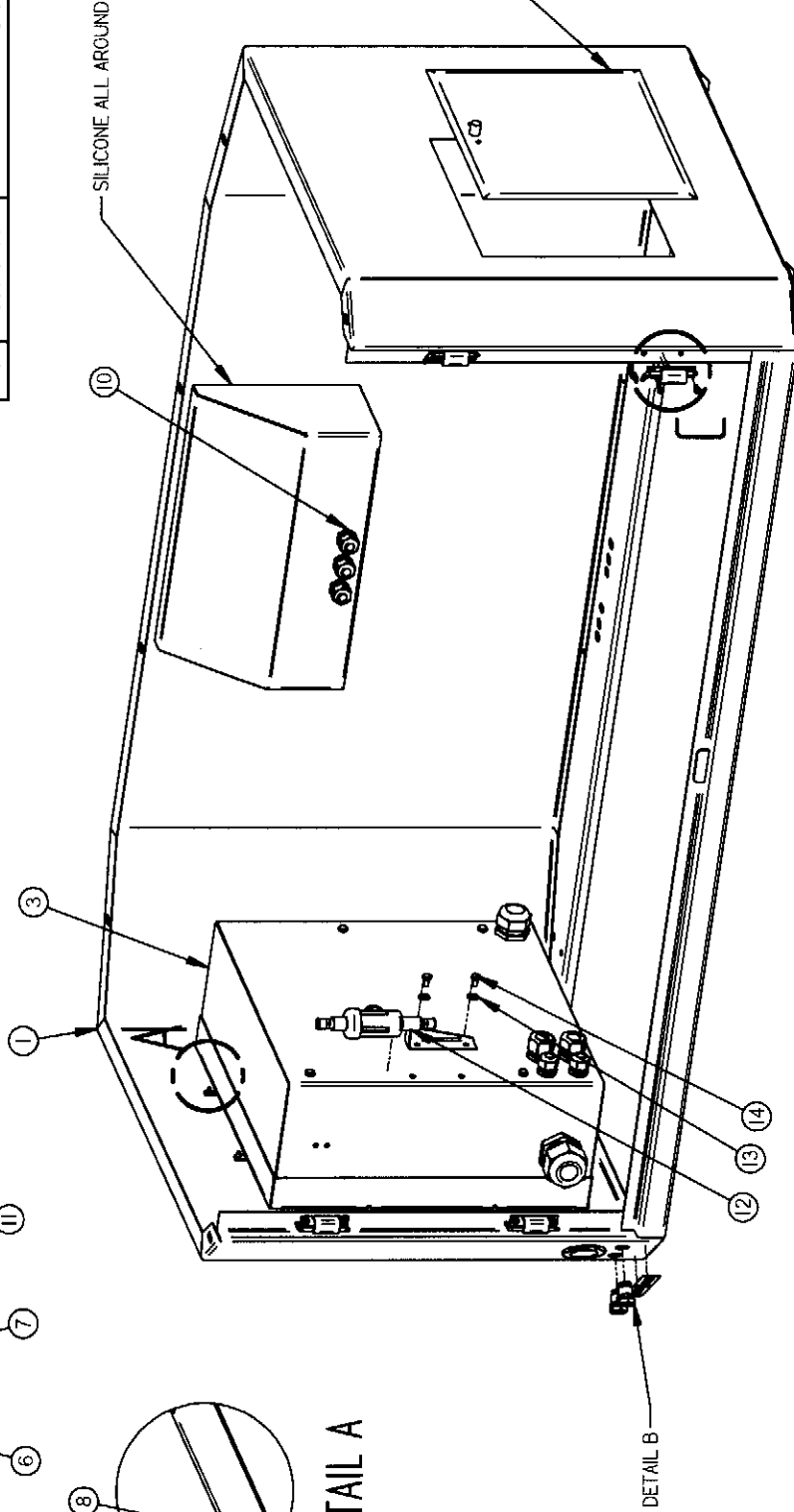
005C0457

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
11	036-0265	GROMMET 1-1/2" ID X 2-3/8" OD RUBBER	1	1	004D0114	STRUCTURE PRE-ASSEMBLY	1
12	004A4138	VACUUM SENSOR FILTER	1	2	004A4090	ACCESS DOOR ASSEMBLY	1
13	051-0740	WASHER 1/4" FLAT S/S	2	3	004A4098	ELECTRIC BOX ASSY	1
14	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	2	4	056-3010-1	WELD PLATE	4
				5	102-0551	BULKHEAD 1/4"NPT X 3/8 TUBE QUICK	2
				6	127-0040	STICKER "AIR" BLUE/WHITE 1" X 2"	1
				7	127-0041	STICKER "GAS" YELLOW/BLACK 1" X 2"	1
				8	051-01385	SCREW 10-24 x 1/2"FLAT-UND. PHIL S/S	16
				9	056-3010-3	PIN	4
				10	036-0409	PRESSE-ETOUPPE CD13	3

DETAIL B



DETAIL A



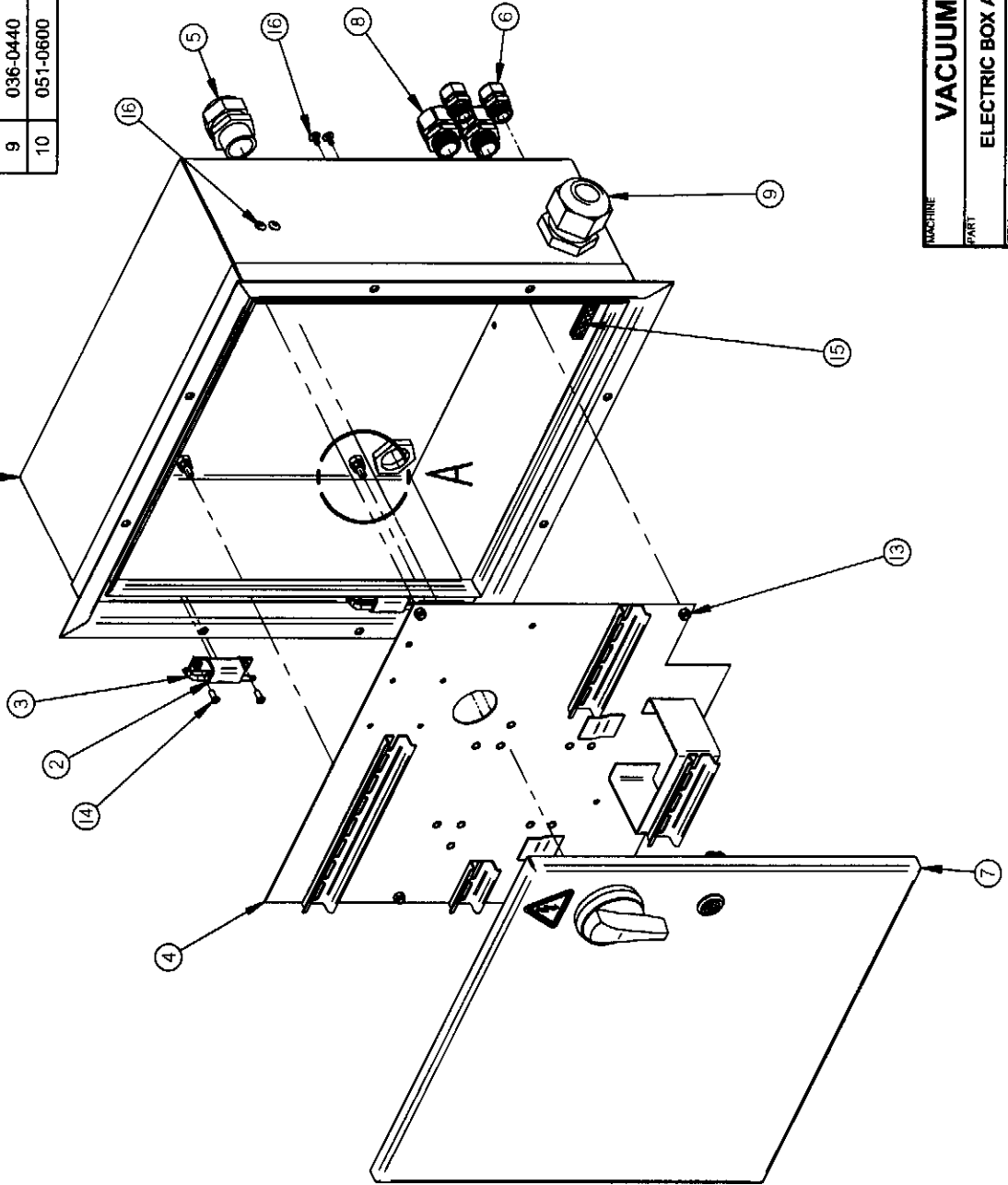
DETAIL C

MACHINE	600A & 620A	DEPT. NO.	SIPROMAC
PART	STRUCTURE ASSY	DATE	13-09-23
ITEM		BY	SBU
MAT.		DATE	
		DEPT.	M-(M)-1
		NO.	005C0457
		QTY.	1

LET. _____ MODIFICATION _____ DATE INT. _____

004A4098

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
11	051-0580	NUT 1/4"-20 S/S	4	1	004A4099	E-BOX PRE-ASSY	1
12	051-0210	BOLT 1/4"-20nc. X 1" S/S	4	2	056-3010-1	WELD PLATE	2
13	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4	3	056-3010-3	PIN	2
14	051-01385	SCREW 10-24 x 1/2"FLAT-UND. PHIL S/S	4	4	004A4102	E-BOX FALSE BOTTOM	1
15	028-0105	GROUND BARRIER (6 HOLES)	1	5	036-0430	PRESSE-ÉTOUPE CD29	1
16	051-0128	SCREW 10-24 x 3/8" TRUSS PHIL S/S	4	6	036-0409	PRESSE-ÉTOUPE CD13	3
				7	004A4100	E-BOX DOOR ASSEMBLY	1
				8	036-0420	PRESSE-ÉTOUPE CD21	2
				9	036-0440	PRESSE-ÉTOUPE CD36	1
				10	051-0600	NUT 5/16" -18 S/S	4

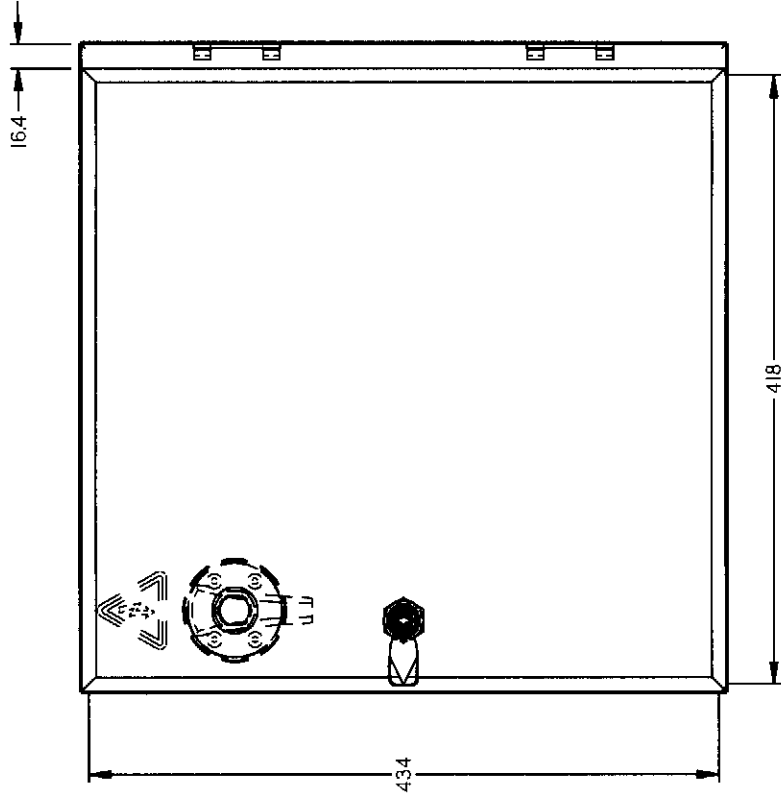
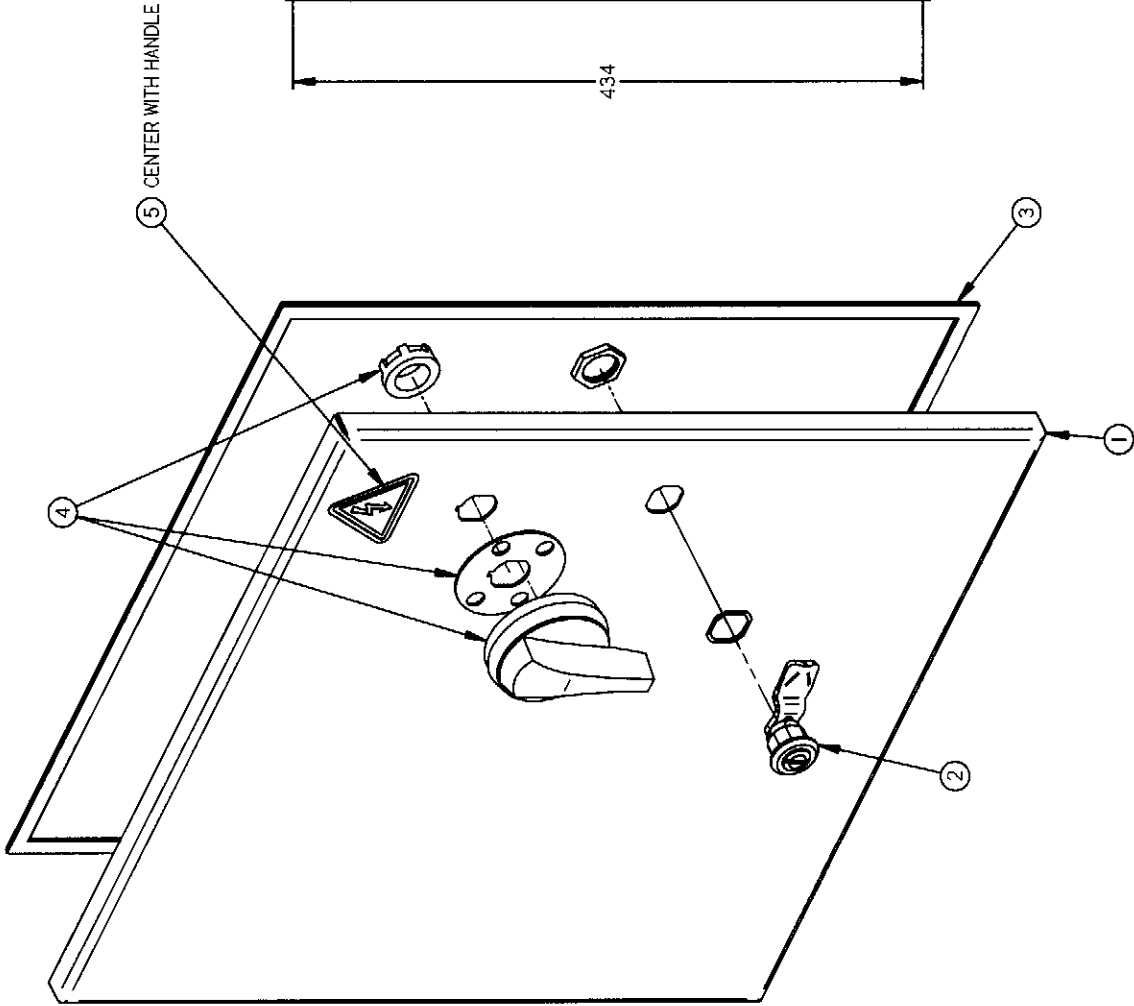


DETAIL A

MACHINE		DEPT. TOLERANCE INCH		SIPROMAC	
PART		FINISH	± 0.004	ST-GERMAIN DE GRANBY	
ITEM		TOLERANCE	± 0.5	QUEBEC CANADA	
MATERIAL		SOUDAGE	± 0.5	N.T.S.	
VACUUM		N.T.S.		DEPT. M	
ELECTRIC BOX ASSY		DATE 13-09-23		NO. 004A4098	
DRAWN BY SBU		DATE		APP. BY	
MODIFICATION		DATE		INT.	

004A4100

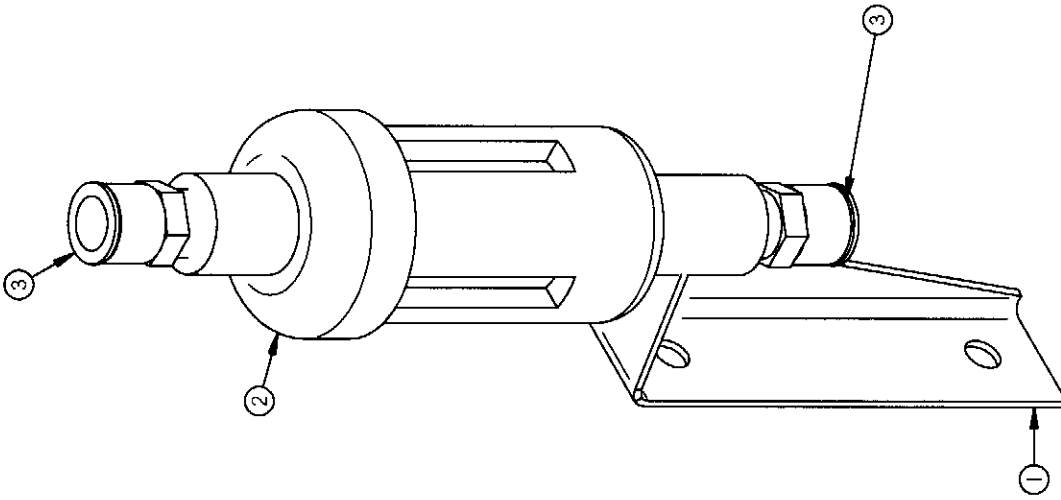
ITEM	PART #	DESCRIPTION	QT.
1	004A4101	E-BOX DOOR PRE-ASSY	1
2	056-2612	CAM LOCK QUARTER TURN SS304	1
3	179-0026	D-SHAPED RUBBER SEAL 1683mm LONG	1
4	026-3160	HANDLE RED/YELLOW NEMA 4X, COMPACT, PADLOCKABLE	1
5	127-0100	STICKER ELEC-HAZARD ISO 2-1/2" TRIANGLE	1



MACHINE		VACUUM		SIPROMAC	
PART		E-BOX DOOR ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM		ENC		DEPT. M	
DATE		DATE 13-09-17		QTY. 1	
APP. BY		SBU		NO. 004A4100	
MODIFICATION		DATE		INT.	

004A4138

ITEM	PART #	DESCRIPTION	QT.
1	004A4138	VACUUM SENSOR FILTER SUPPORT	1
2	114-2020	FILTER / DRYER 1/2"mnpt. X 1/4"t.p. COMP.	1
3	102-0410	MALE CONN. 1/4"MNPTx3/8" T. QUICK	2

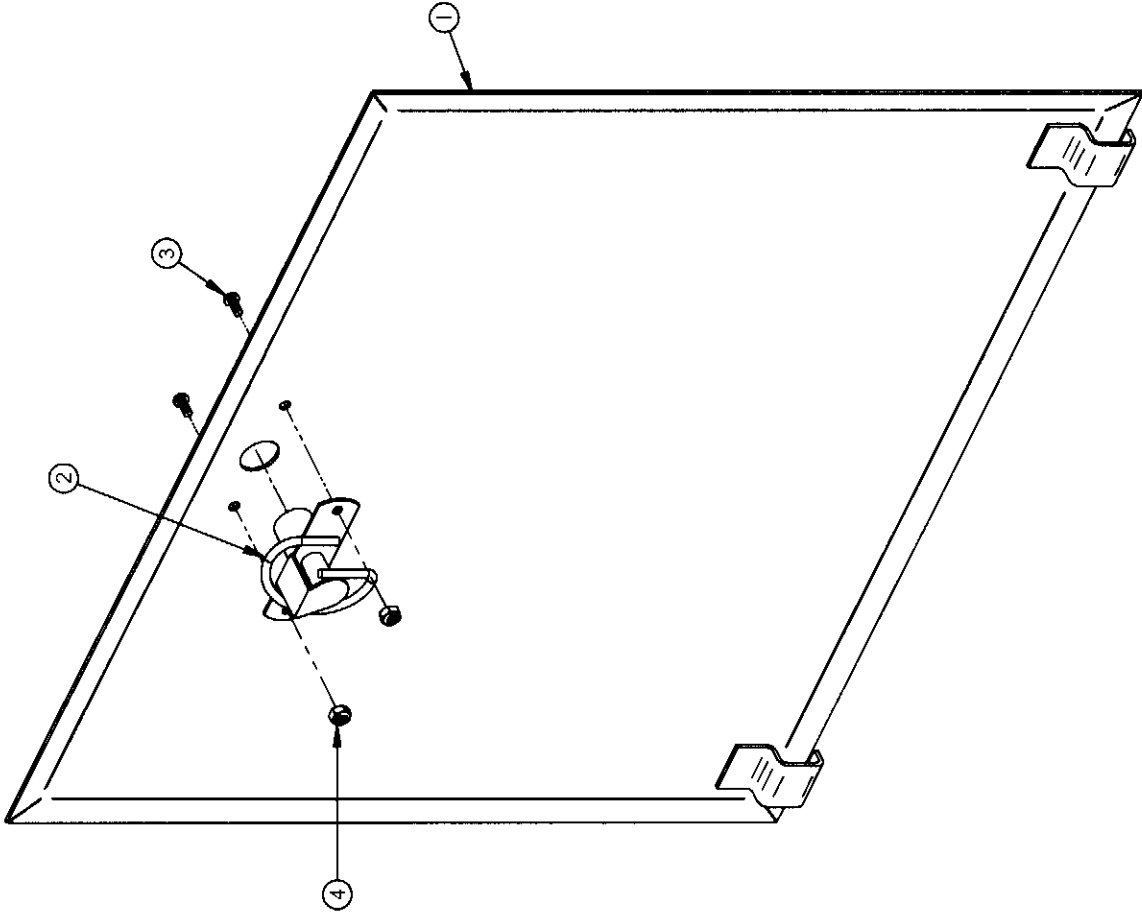


MACHINE		DEPT. COL. METRIC INCH		SIPROMAC	
PART		USINAGE	3.01 ± 0.004	ST-GERMAIN DE GRANBY QUEBEC CANADA	
ITEM		TOLERANCE	1.05 ± 0.004	N.T.S.	
MAT.		SOLDAGE	1.05 ± 0.004	DEPT. M	
DATE		DATE 13-11-19		NO. 004A4138	
DRAWN BY		DATE		DEPT. M	
CNC		DATE		NO. 004A4138	
DRAWN BY		DATE		DEPT. M	
CNC		DATE		NO. 004A4138	
DRAWN BY		DATE		DEPT. M	
CNC		DATE		NO. 004A4138	

LET.	MODIFICATION	DATE	INT.
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004A4090

ITEM	PART #	DESCRIPTION	QT.
1	004A4089	ACCESS PANEL PRE-ASSY	1
2	056-2600	SPRING PAWL LATCHE SS KNOB	1
3	051-0071	SCREW 4-40 x 1/4" RND SLOT S/S	2
4	051-0541	NUT # 4-40 NYLON LOCK SS	2

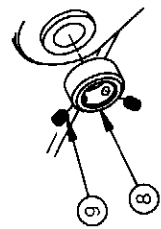


MACHINE		VACUUM		SIPROMAC	
PART		ACCESS DOOR ASSEMBLY		ST-GERMAIN DE GRANBY/AM QUEBEC CANADA	
ITEM		DATE 13-09-11		DEPT. M	
MAT.		DRAWN BY SIBU		QTY. 1	
		APP. BY		NO. 004A4090	

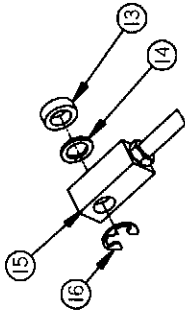
LET. _____ DATE INT. _____
 MODIFICATION

004A4145

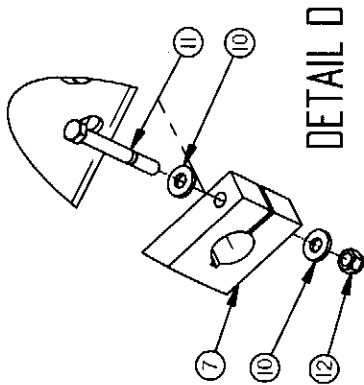
ITEM	PART #	DESCRIPTION	QT.
1	004D0122	TABLE ASSEMBLY	1
2	002-0327	RIGHT SEAL BAR GUIDE BLOCK	4
3	002-0326	LEFT SEAL BAR GUIDE BLOCK	4
4	051-0740	WASHER 1/4" FLAT S/S	32
5	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	16
6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	16
7	004-0280	COVER ARM ASSY	2
8	002-0390	COVER ARM COLLAR	2
9	051-0178	SCREW 1/4"-20 x 5/16" SKT SET S/S	4
10	051-0783	WASHER 3/8" FLAT THICK S/S	4
11	051-0422	BOLT 3/8"-16nc. X 3 1/2" S/S	2
12	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	2
13	058-0060	NYLON SPACER 1/2IDx3/4ODx1/4"	2
14	058-0050	NYLON SPACER 1/2IDx3/4ODx1/16"	2
15	004A1394	GUIDE ARM PRE-ASSY	1
16	056-0331	EXT. RETAINING RING 1/2" S/S	2
17	005-0320	BELLOWS ASSEMBLY	4
18	056-01675	KEY 1/4" SQ. x 1 1/4" ROUNDED END S/S	2



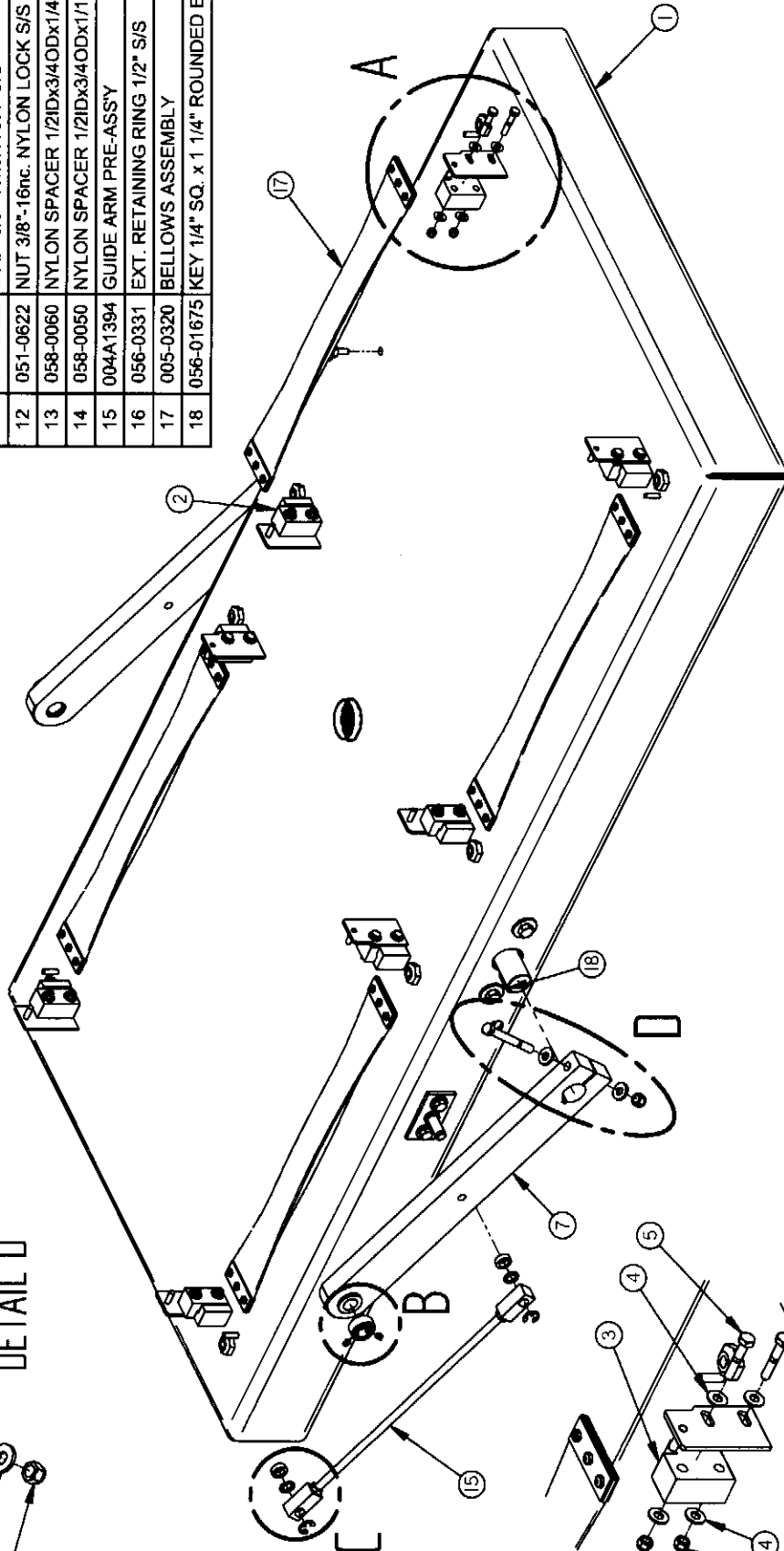
DETAIL B



DETAIL C



DETAIL D



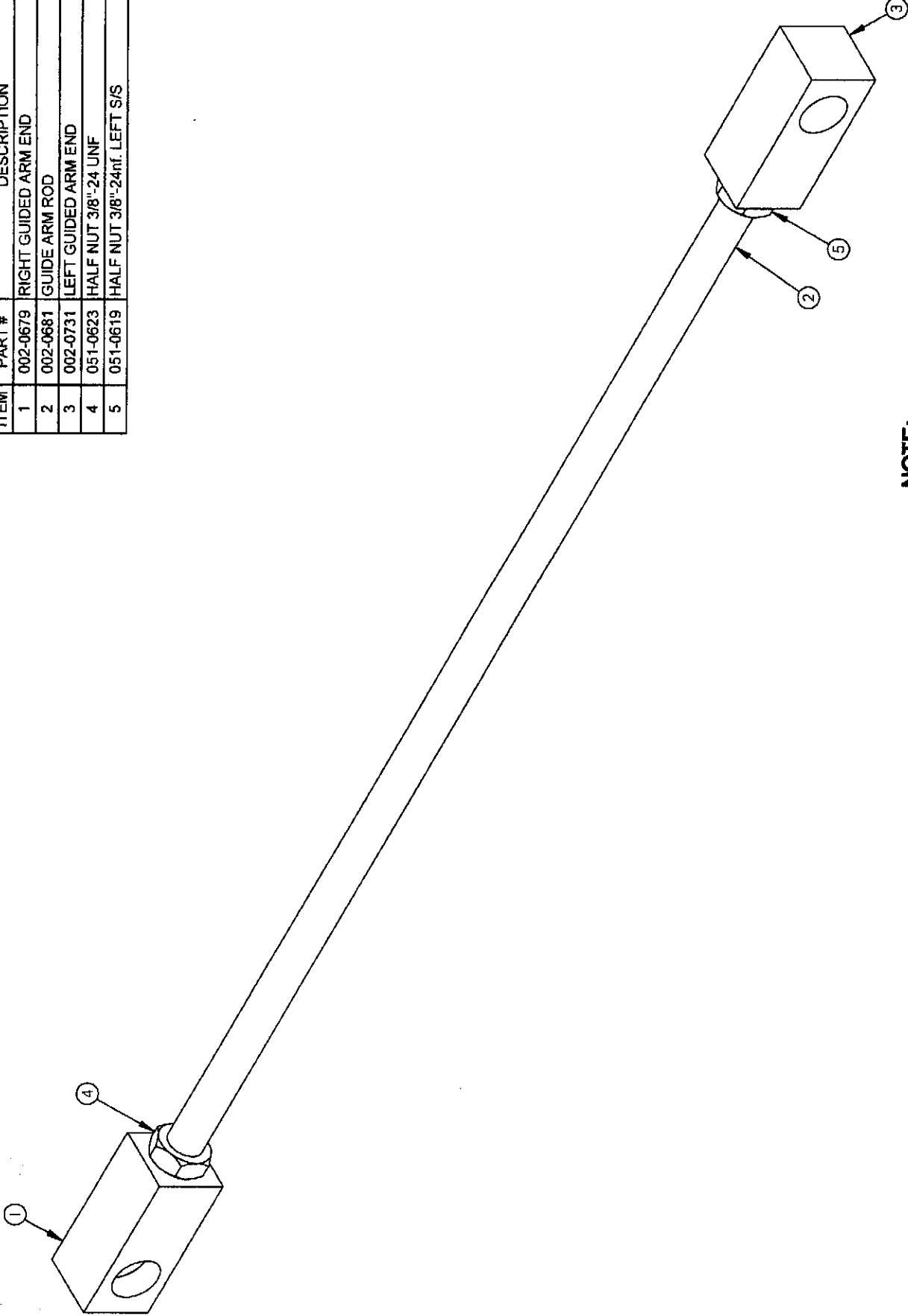
MACHINE	600A	DEPT. FOR ELECTRIC MACH.	SIPROMAC
PART	TABLE W/ARM ASSY	FINISHANCE ±0.1	ST-GERMAIN DE GRANITHAM
ITEM		TOLERANCE ±0.5	QUEBEC, CANADA
DRAWN BY	SBU	SCOURAGE ±0.5	
DATE	13-11-28	N.T.S.	
APP. BY		REP.	
		QTY.	1
			004A4145

DETAIL A

LET.	MODIFICATION	DATE	INT.
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004A1394

ITEM	PART #	DESCRIPTION	QT.
1	002-0679	RIGHT GUIDED ARM END	1
2	002-0681	GUIDE ARM ROD	1
3	002-0731	LEFT GUIDED ARM END	1
4	051-0623	HALF NUT 3/8"-24 UNF	1
5	051-0619	HALF NUT 3/8"-24mt. LEFT S/S	1



NOTE:
 -PASSER AU JET DE SABLE APRES AVOIR ASSEMBÉ LES 5 ITEMS.

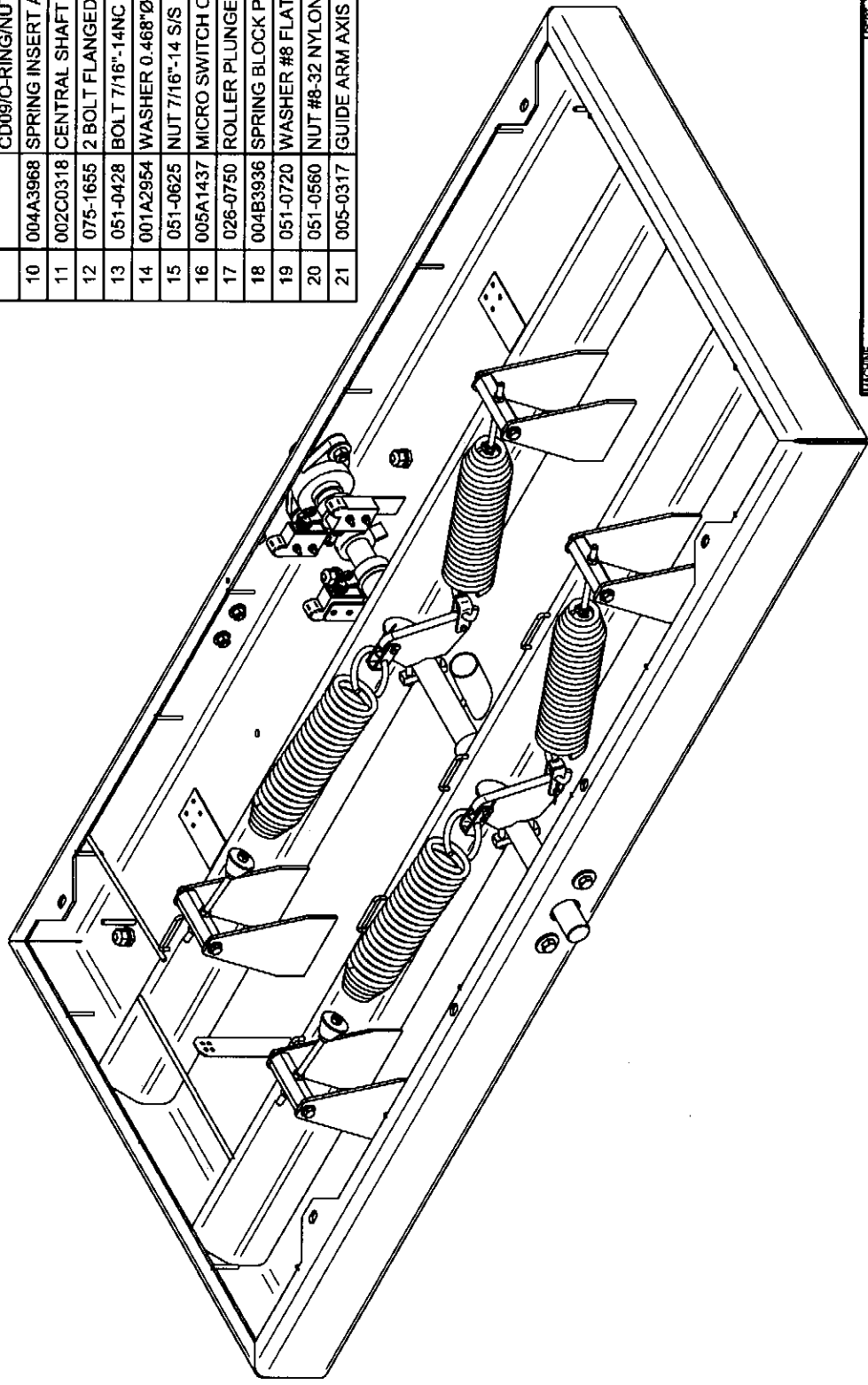
MACHINE		DEPT. D'OUTILS	DATE	QTY.
PART		USINAGE	03-12-09	1
ITEM		FINISSE	J.C.	
MAT		SOLDAJE	28-05-08	
CNC		N.T.S.		
DOWS BY				
TRF. BY				
SIPROMAC				
ST-GERMAIN DE GRANVILLE				
QUEBEC CANADA				
U-J-(M)				
004A1394				

A	AJOUTER JET DE SABLE	08-02-15	J.G.
LET.	MODIFICATION	DATE	INT.

004D0122

1/2

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
22	051-0783	WASHER 3/8" FLAT THICK S/S	4	1	005D0150	TABLE PRE-ASSEMBLY	1
23	051-0360	BOLT 3/8"-16nc. X 1" S/S	2	2	008A1953	SPRING	4
24	051-0620	NUT 3/8"-16 NC S/S	2	3	002A3941	SPRING ADJ. PIVOT	4
25	001A6466	BEARING SPACER	2	4	051-0600	NUT 5/16" -18 S/S	8
				5	002A4002	SPRING ADJ. PIVOT SPACER	8
				6	051-0760	WASHER 5/16" FLAT S/S	8
				7	051-0300	BOLT 5/16"-18 x 3/4" S/S	8
				8	004A3937	SHACKLE ASSY	4
				9	036-0400	WIRE CONNECT. 3/8" NPT	8
						CD09/O-RING/NUT	
				10	004A3968	SPRING INSERT ASSEMBLY	4
				11	002C0318	CENTRAL SHAFT	1
				12	075-1655	2 BOLT FLANGED BEARING 1-1/4" PLASTIC	2
				13	051-0428	BOLT 7/16"-14NC x 1-1/2" SS	4
				14	001A2954	WASHER 0.468"Ø ID x 1.250"OD x 3.5	8
				15	051-0625	NUT 7/16"-14 S/S	4
				16	005A1437	MICRO SWITCH COLLAR ASSY	3
				17	026-0750	ROLLER PLUNGER SWITCH SPDT	3
				18	004B3936	SPRING BLOCK PRE-ASSY	2
				19	051-0720	WASHER #8 FLAT S/S	6
				20	051-0560	NUT #8-32 NYLON LOCK S/S	6
				21	005-0317	GUIDE ARM AXIS ASSY	1



MACHINE: 600A
 PART: TABLE ASSEMBLY
 ITEM: _____
 MAT: _____

REPT. M-(M) QTY. 1

DATE 13-12-02

BY SBU
 APP BY _____

NO. 004D0122

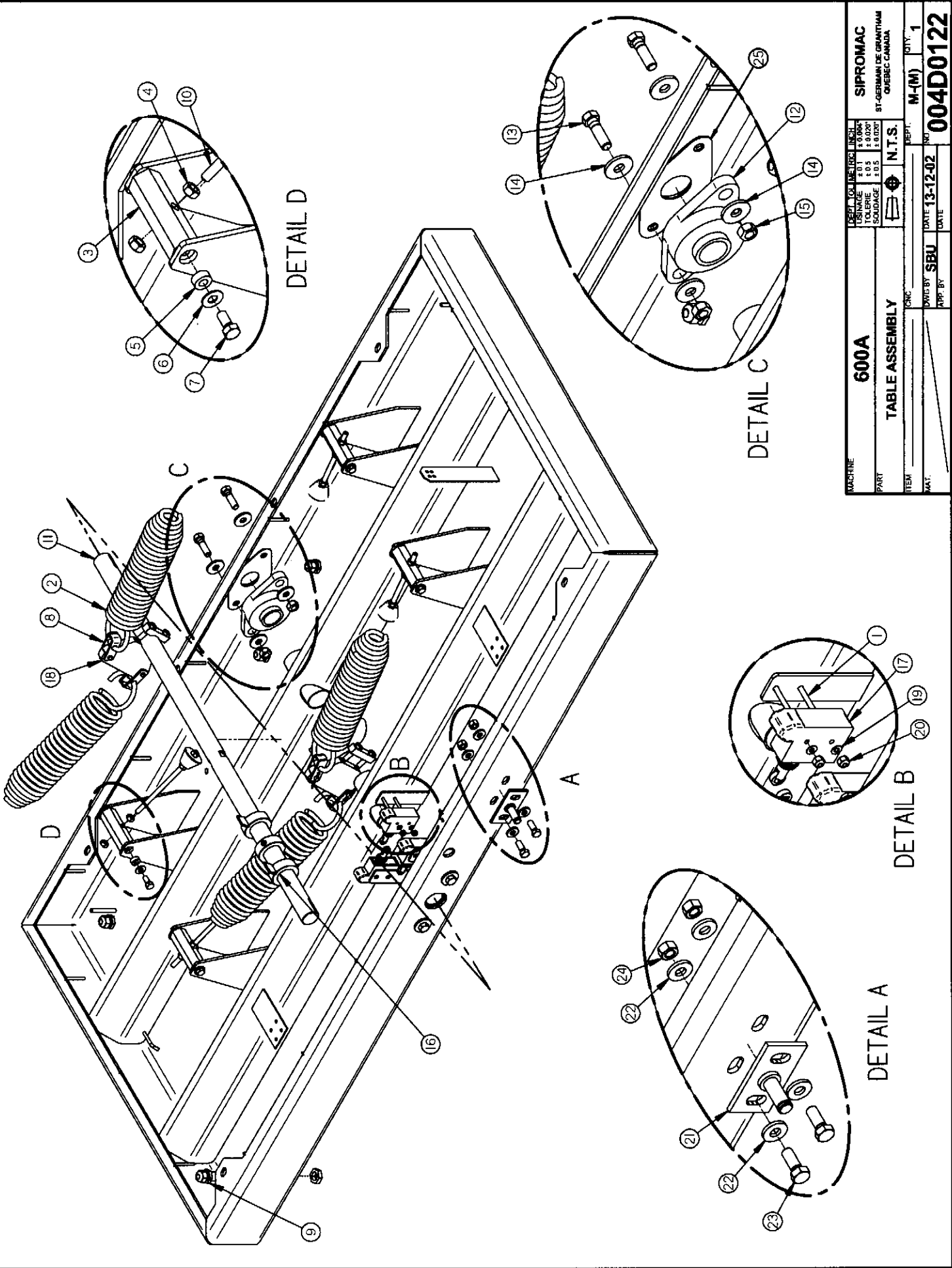
ST-GERMAIN DE GRANTHAM
 QUEBEC CANADA

SIPROMAC
 N.T.S.

USE: METRIC INCH
 USINAGE ± 0.1 ± 0.004
 TOLERIE ± 0.5 ± 0.020
 SOLDAJGE ± 0.5 ± 0.020

H. 005D0150 WAS 005C0150
 LET. MODIFICATION

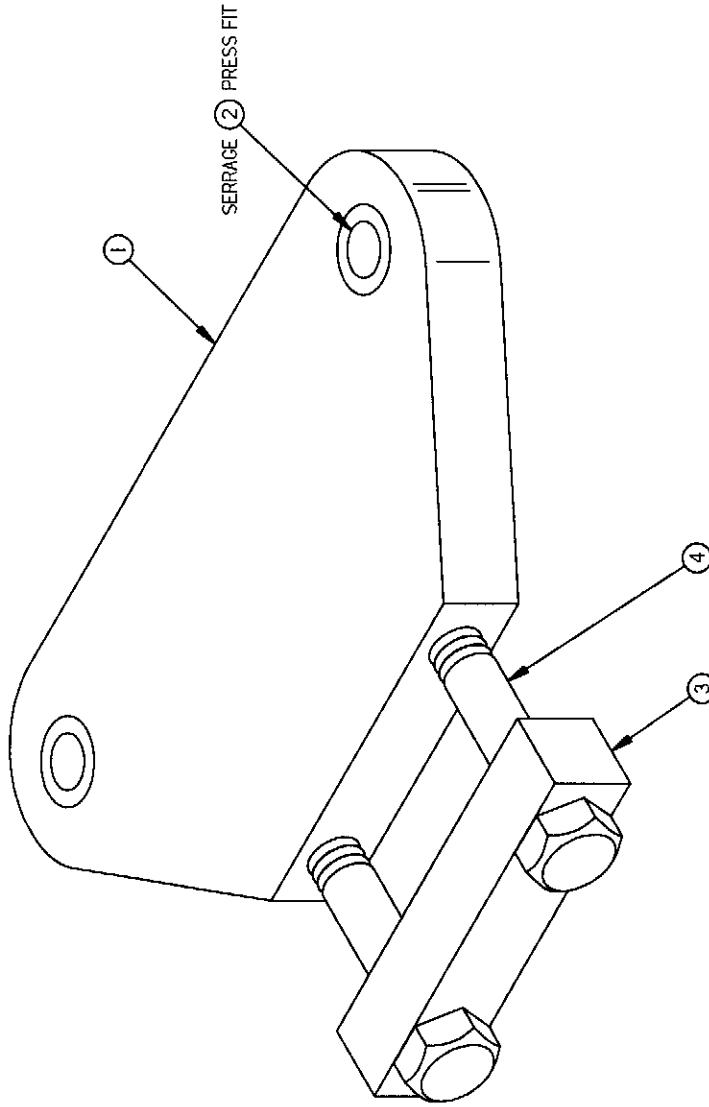
13-12-02 SBU
 DATE INT.



MACHINE	600A	UNIT	INCH	SCALE	1:1	DATE	13-12-02	NO.	1
PART	TABLE ASSEMBLY	UNIT	INCH	SCALE	1:1	DATE	13-12-02	NO.	1
ITEM		UNIT	INCH	SCALE	1:1	DATE	13-12-02	NO.	1
MAT.		UNIT	INCH	SCALE	1:1	DATE	13-12-02	NO.	1
DRAWN BY: SIBU		DATE: 13-12-02		NO.:		DATE:		M-(M) QTY: 1	
APP. BY:				N.T.S.				004D0122	
				STIPROMAC		ST-GERMAIN DE GRANTHAM		QUEBEC CANADA	

004B3936

ITEM	PART #	DESCRIPTION	QT.
1	002B4058	SPRING BLOCK	1
2	075-0015	BUSHING PL. 5/16" x 1/2" x 1/2"	2
3	002B3939	UPPER SPRING BLOCK	1
4	051-0312	S/S BOLT 5/16" - 18NC. 2 1/4"	2



620A	2
600A	2
MACHINE	QTY

DEPT. FOR METRIC UNITS
 USINAGE ± 0.1 ± 0.004
 TOLERIE ± 0.1 ± 0.004
 SOUDAGE ± 0.5 ± 0.020

VACCCUM
 SPRING BLOCK PRE-ASSY

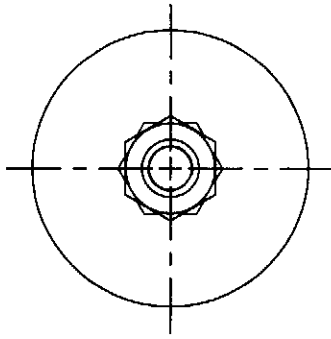
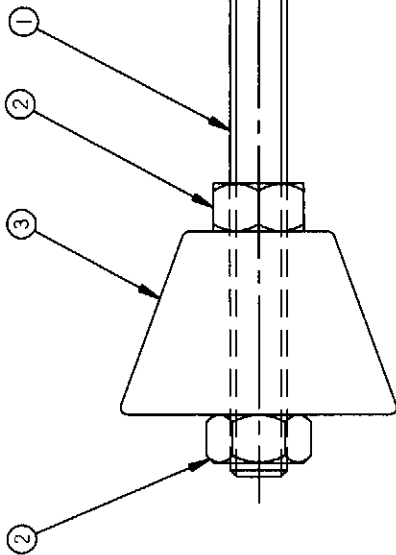
ITEM: _____ DEPT.: _____
 MAT.: _____ DATE: 13-01-15
 ING BY: J.G. APP BY: _____

U-(M) LISTE
004B3936

B	AJOUTER 620A	13-01-23	J.G.
A	REDESSINE	13-01-15	J.G.
LET.	MODIFICATION	DATE	INT.

004A3968

ITEM	PART #	DESCRIPTION	QTY.
1	002A3989	SPRING ADJUSTMENT ROD	1
2	051-0600	NUT 5/16" -18 S/S	2
3	002B3940	SPRING INSERT	1



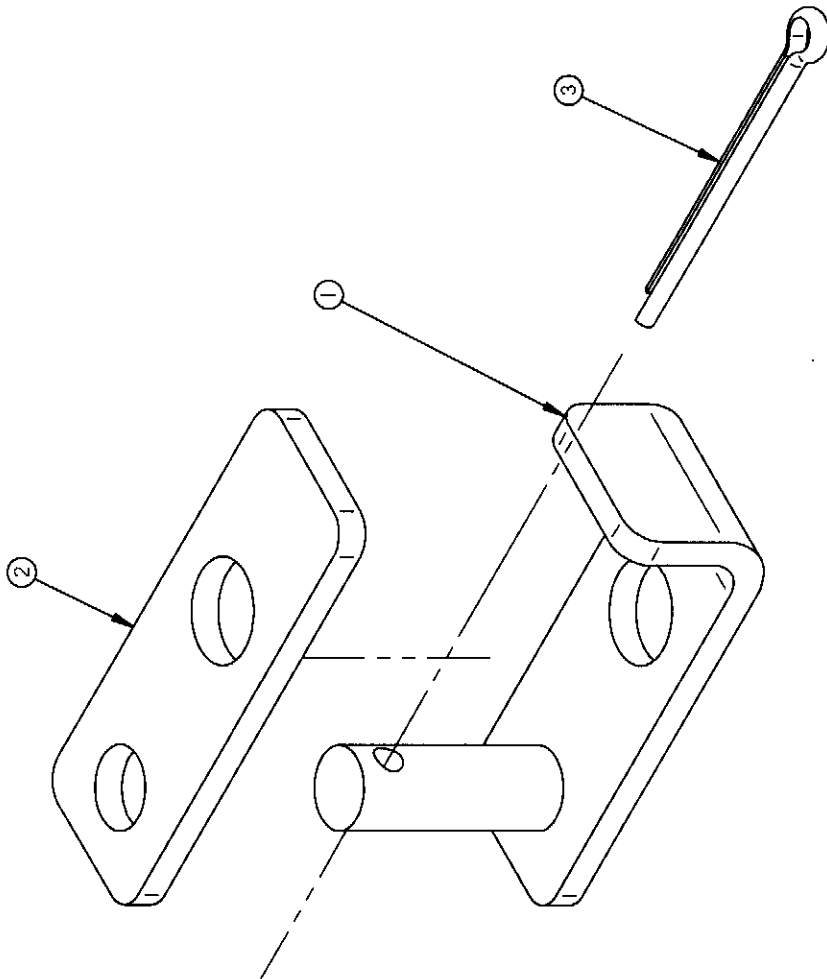
A	13-01-23	J.G.
LET.	MODIFICATION	DATE INT.

MACHINE	600A & 620A	UNIT TO INCHES	1/8
PART	SPRING INSERT ASSEMBLY	TOLERANCE	± 0.005
ITEM	CNC	SURFACE	± 0.0025
		SOLDAGE	± 0.0025
			N.T.S.
			REPT.
			NO.
		DATE 13-01-15	DATE
		DWG BY J.G.	
		APP BY	

620A	4
600A	4
MACHINE	QTY.
SIPROMAC	
ST-GERMAIN DE GRANBY/AM	
QUEBEC CANADA	
M-(M)	QTY.
004A3968	

004A3937

ITEM	PART #	DESCRIPTION	QT.
1	004A3935	SHACKLE PRE-ASSY	1
2	001A6269	SHACKLE PLATE	1
3	056-0118	COTTER PIN 3/32" x 1" S/S	1



MACHINE	600A	4
PART	MACHINE QTY	
ITEM	SIPROMAC	
MAT.	ST-GERMAIN DE GRANITAN QUEBEC CANADA	
DEPT.	M-(M)	
DATE	12-11-06	LISTE
NO.	004A3937	
DATE		
APP. BY		
DATE		
DEPT.		
DATE		
APP. BY		
DATE		

VACUUM

SHACKLE ASSY

CNC

DWG BY: J.G.

DATE

DATE

NO.

LISTE

004A3937

DATE

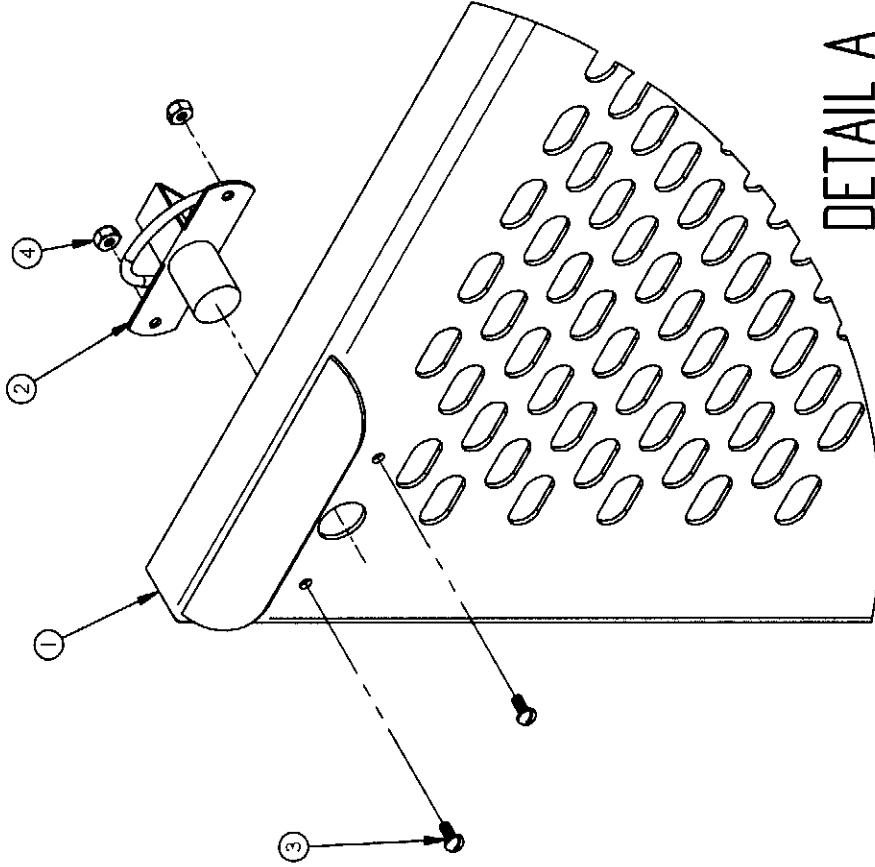
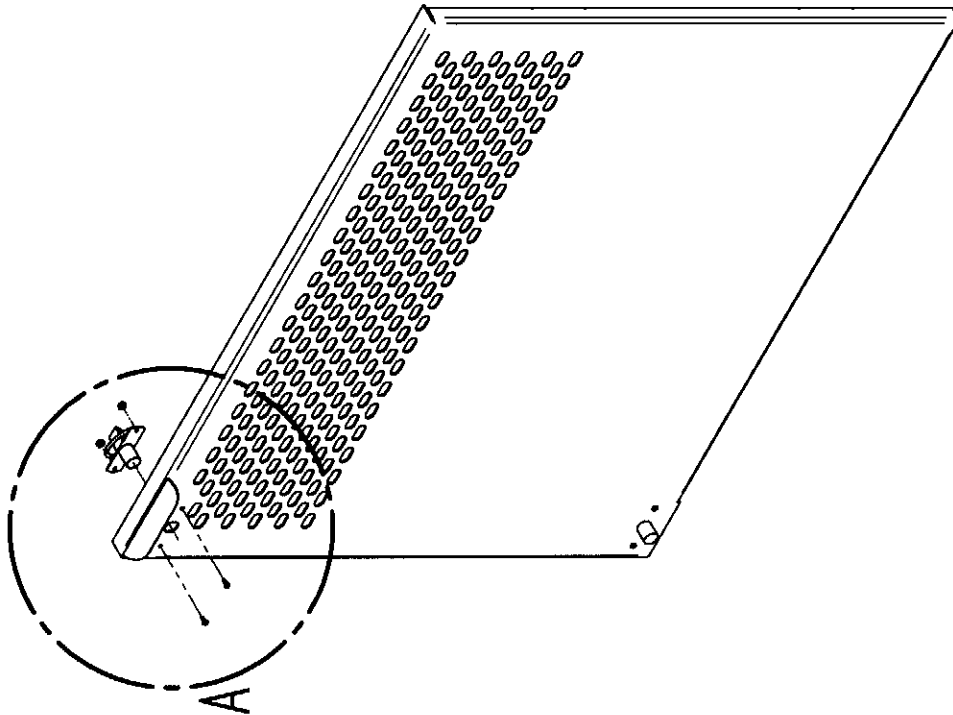
INT.

MODIFICATION

LET.

004A4097

ITEM	PART #	DESCRIPTION	QT.
1	004A4096	RIGHT REAR ACCESS DOOR PRE-ASSY	1
2	056-2600	SPRING PAWL LATCHE SS KNOB	2
3	051-0071	SCREW 4-40 x 1/4" RND SLOT S/S	4
4	051-0541	NUT # 4-40 NYLON LOCK SS	4

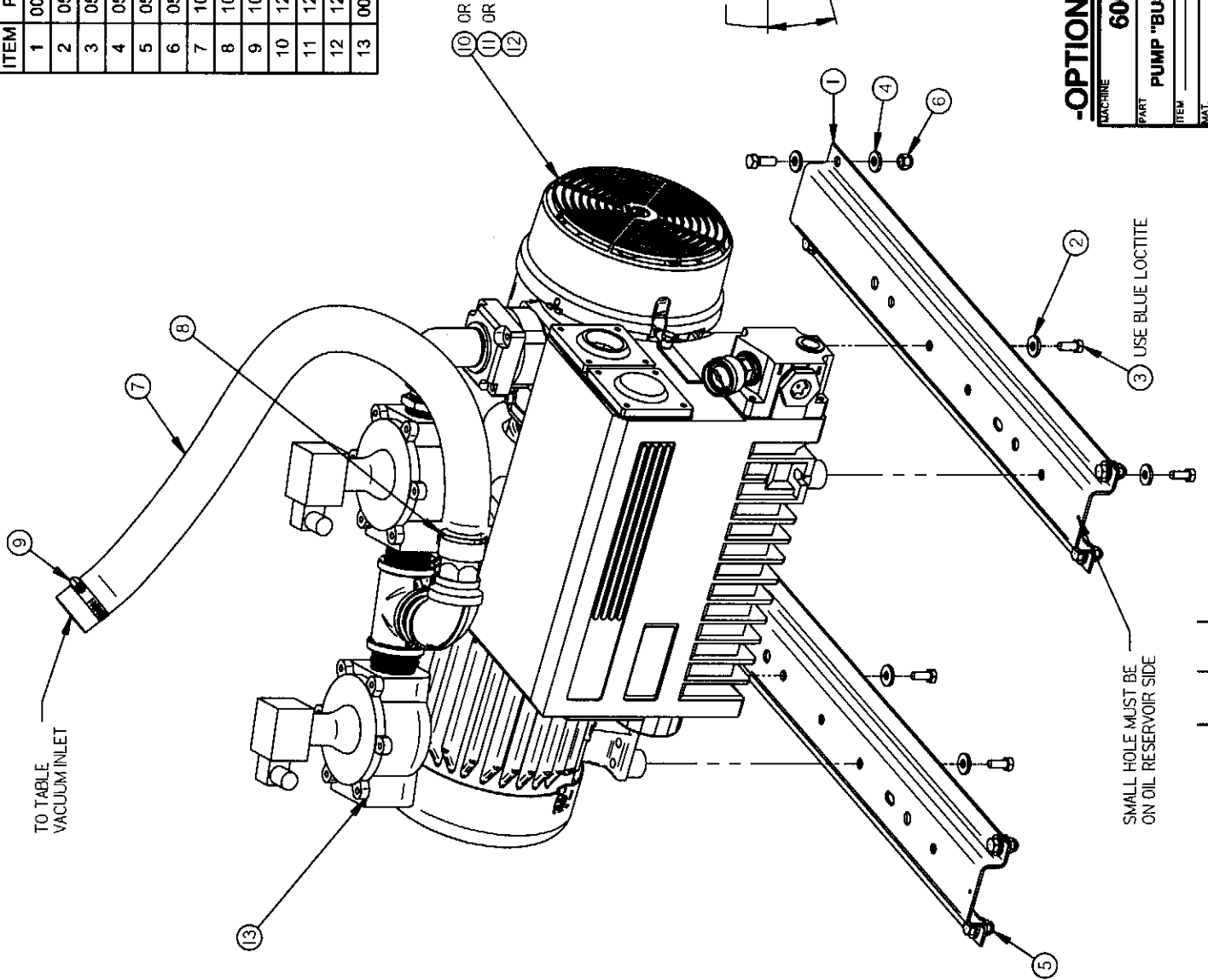


MACHINE	600A & 620A		DEPT TO METRIC INCHES 1/16" = 1.588mm 1/8" = 3.175mm 1/4" = 6.350mm 3/8" = 9.525mm 1/2" = 12.700mm 5/8" = 15.875mm 3/4" = 19.050mm 7/8" = 21.625mm 1" = 25.400mm	SIPROMAC ST-GERMAIN DE GRANBY QUEBEC CANADA
PART	RIGHT REAR ACCESS DOOR ASSY		UNIT	N.T.S.
ITEM	ENC	DATE 13-09-16	DEPT.	M
DWG BY	SIBU	NO.	QTY.	1
PWP BY		DATE	004A4097	

LET.	MODIFICATION	DATE	INT.
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004B1468

ITEM	PART #	DESCRIPTION	QT.
1	001A6563	PUMP SUPPORT	2
2	051-0762	WASHER 5/16" THICK FLAT S/S	4
3	051-0980	BOLT M8 x 20 S/S	4
4	051-0783	WASHER 3/8" FLAT THICK S/S	16
5	051-0360	BOLT 3/8"-16nc. X 1" S/S	8
6	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	8
7	104-0125	HOSE 1-1/2" ID VACUUM POLYWIRE (810mm)	1
8	105-0250	EAR CLAMP 1-1/2" S/S	1
9	105-0110	SCREW CLAMPS 1-1/16" TO 2" ALL S/S	1
10	125-0060	BUSCH RA-0100 230-460V/3PH/60HZ	1
11	125-0062	BUSCH RA-0100 575V/3PH/60HZ	1
12	125-0064	BUSCH RA-0100 220V/1PH/60HZ	1
13	004B1404	VACUUM / ATMOSPHERE VALVE ASSY.	1



-OPTION - 100M³ PUMP

MACHINE	600A & 620A
PART	PUMP "BUSCH" 100 M ³ ASSEMBLY
ITEM	
MAT.	

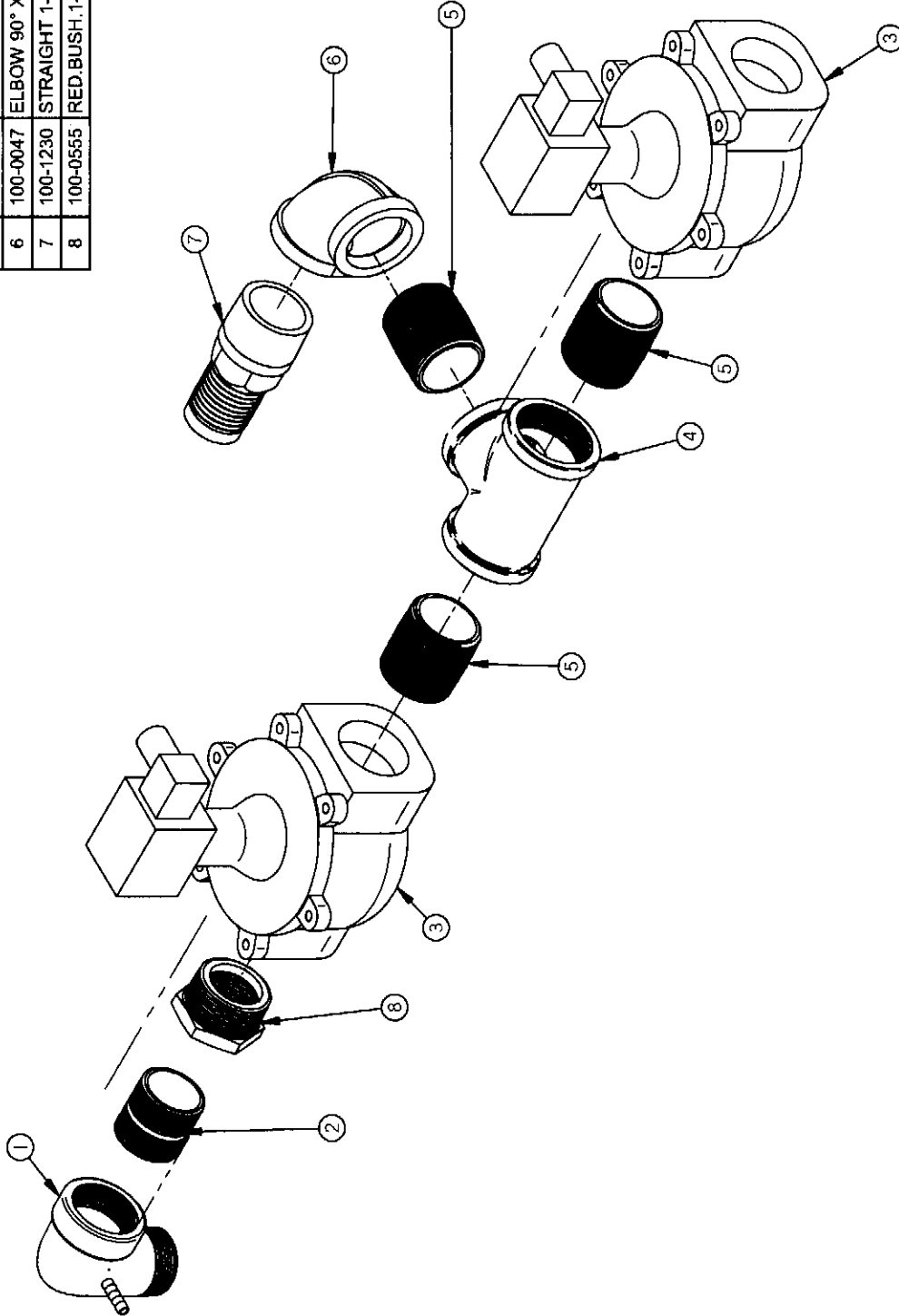
DEPT. FOR	LABOR	INCH	1/16	±0.004
USINAGE	±0.1	±0.004		
TOLERANCE	±0.5	±0.020		
SOUDAGE	±0.5	±0.020		
N.T.S.				
SIPROMAC ST-JERMAIN DE GRANTHAM QUEBEC CANADA				

DATE	13-09-19
BY	SBU
APP BY	
DEPT.	M-H
QTY.	1

LET.		MODIFICATION		DATE	INT.
004B1468					

004B1404

ITEM	PART #	DESCRIPTION	QT.
1	004A081	BELLOWS ELBOW CONNECTOR ASSY	1
2	100-0245	CLOSE NIPPLE 1-1/2"npt. S/S	1
3	106-0050	VALVE 2WAY 24V 1-1/2"NPT(B60)60HZ	2
4	100-0485	TEE 1-1/2" NPT S/S	1
5	100-0440	NIPPLE 1-1/2" NPT X 2" SS	3
6	100-0047	ELBOW 90° X 1-1/2" NPT S/S	1
7	100-1230	STRAIGHT 1-1/2"MNPT x1-1/2" HOSE BARB	1
8	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1



-OPTION - 40M³, 63M³ & 100M³ PUMP

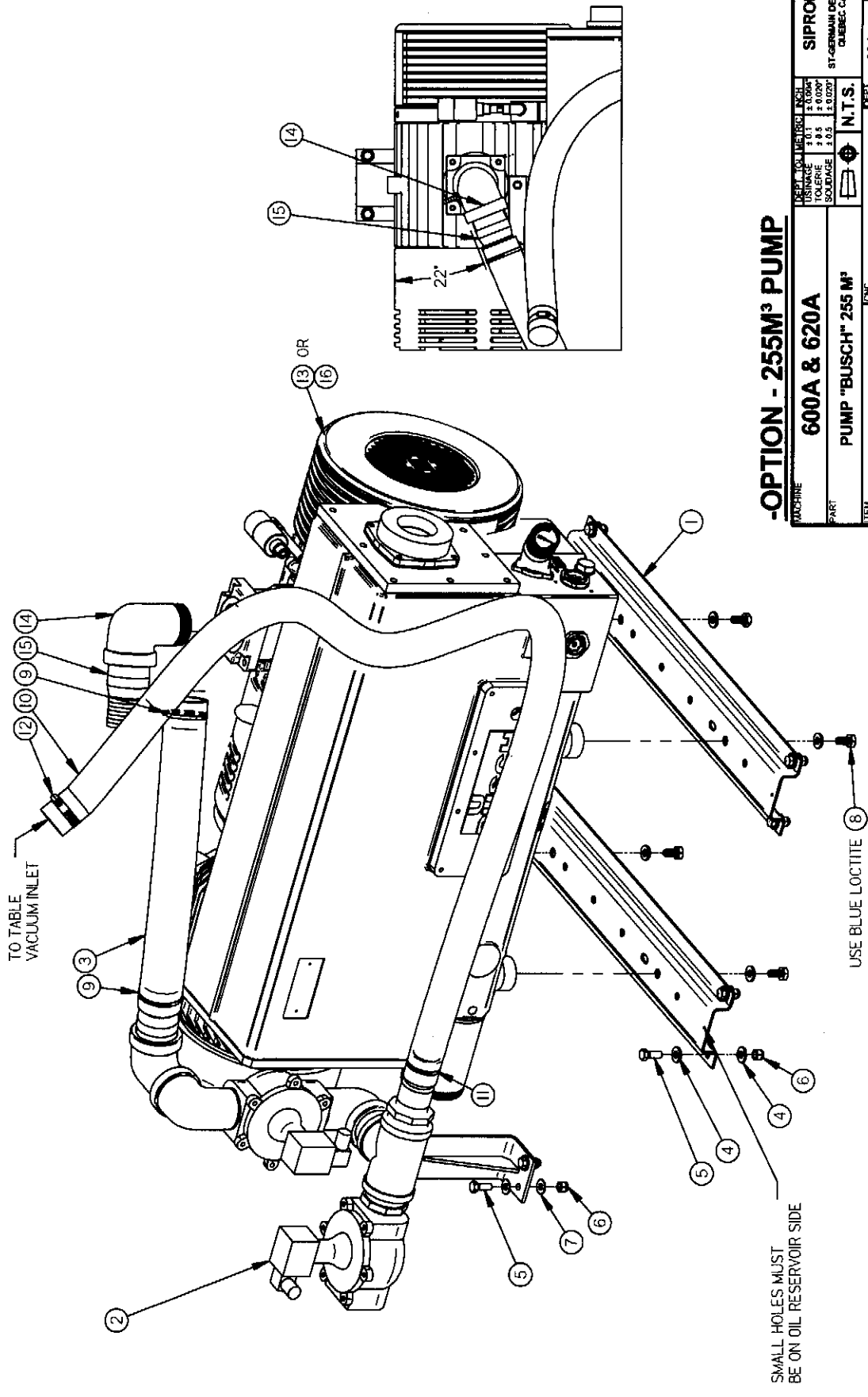
MACHINE	DEPT. 101	INCH	STIPROMAC
PART	NUMBER	TOLERANCE	ST-GERMAIN DE GRANBY/QUEBEC CANADA
ITEM	CNC	DATE	13-09-19
MAT	DWG BY	DATE	
	REP.	NO.	004B1404
	QTY.		1

LET. _____ DATE INT. _____

MODIFICATION

004B1471

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
9	105-0258	EAR CLAMP 2" S/S	2	1	001A6563	PUMP SUPPORT	2
10	104-0125	HOSE 1-1/2" ID VACUUM POLYWIRE (1720mm)	1	2	004A0863	VACUUM/ATMOSPHERE VALVE ASSY	1
11	105-0250	EAR CLAMP 1-1/2" S/S	1	3	104-0150	HOSE 2" ID VACUUM POLYWIRE (554mm)	1
12	105-0110	SCREW CLAMPS 1-1/16" TO 2" ALL S/S	1	4	051-0783	WASHER 3/8" FLAT THICK S/S	20
13	125-0080	BUSCH RA-0255 230-460V/3PH/60HZ	1	5	051-0360	BOLT 3/8"-16nc. X 1" S/S	10
14	004A4082	BELLOWS ELBOW CONNECTOR ASSY	1	6	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	10
15	100-1250	STRAIGHT 2"MNPT X 2" HOSE BARB SS	1	7	051-0780	WASHER 3/8" FLAT S/S	4
16	125-0085	BUSCH RA-0255 575V/3PH/60HZ	1	8	051-09931	BOLT M10 X 20MM HEX SS	4



SMALL HOLES MUST BE ON OIL RESERVOIR SIDE

USE BLUE LOCTITE 6

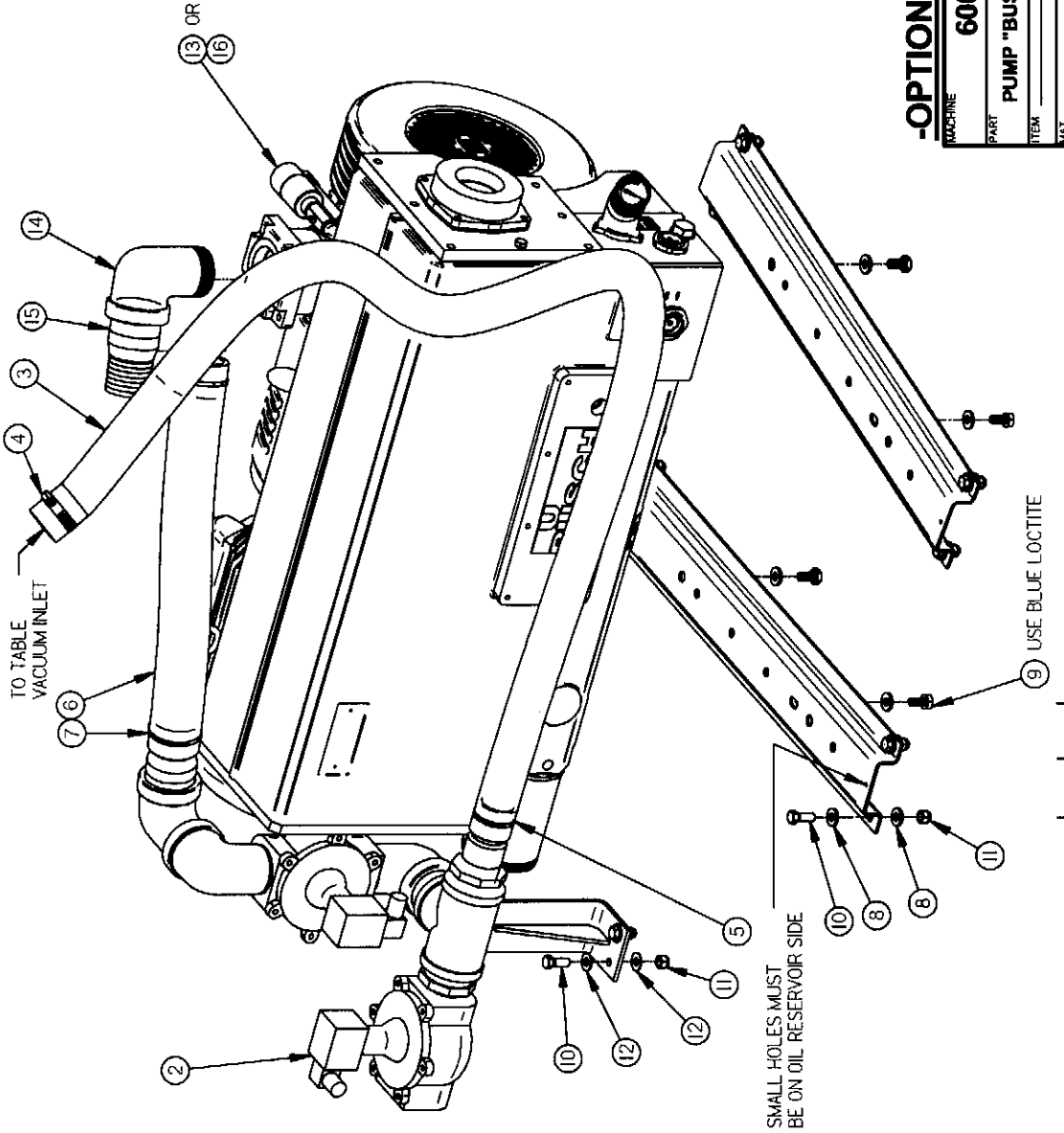
-OPTION - 255M³ PUMP

MACHINE		DEPT. 100 LITHURGICAL		SIPROMAC	
PART		600A & 620A		ST-GERMAIN DE GRANITHAM	
ITEM		PUMP "BUSCH" 255 M ³		QUEBEC CANADA	
MATERIAL		N.T.S.		REP. M-H	
DATE		13-09-18		NO. 004B1471	
DRAWN BY		SBU		QTY. 1	
CHECKED BY					

LET.	MODIFICATION	DATE	INT.
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004B1469

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
9	051-09931	BOLT M10 X 20MM HEX SS	4	1	001A6563	PUMP SUPPORT	2
10	051-0360	BOLT 3/8"-16nc. X 1" S/S	10	2	004A0863	VACUUM/ATMOSPHERE VALVE ASSY	1
11	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	10	3	104-0125	HOSE 1-1/2" ID VACUUM POLYWIRE (1720mm)	1
12	051-0780	WASHER 3/8" FLAT S/S	4	4	105-0110	SCREW CLAMPS 1-1/16" TO 2" ALL S/S	1
13	125-0070	BUSCH RA-0165 230-460V/3PH/60HZ	1	5	105-0250	EAR CLAMP 1-1/2" S/S	1
14	004A4082	BELLOW'S ELBOW CONNECTOR ASSY	1	6	104-0150	HOSE 2" ID VACUUM POLYWIRE (570mm)	1
15	100-1250	STRAIGHT 2"MNPT X 2" HOSE BARB SS	1	7	105-0258	EAR CLAMP 2" S/S	2
16	125-0075	BUSCH RA-0165 575V/3PH/60HZ	1	8	051-0783	WASHER 3/8" FLAT THICK S/S	20

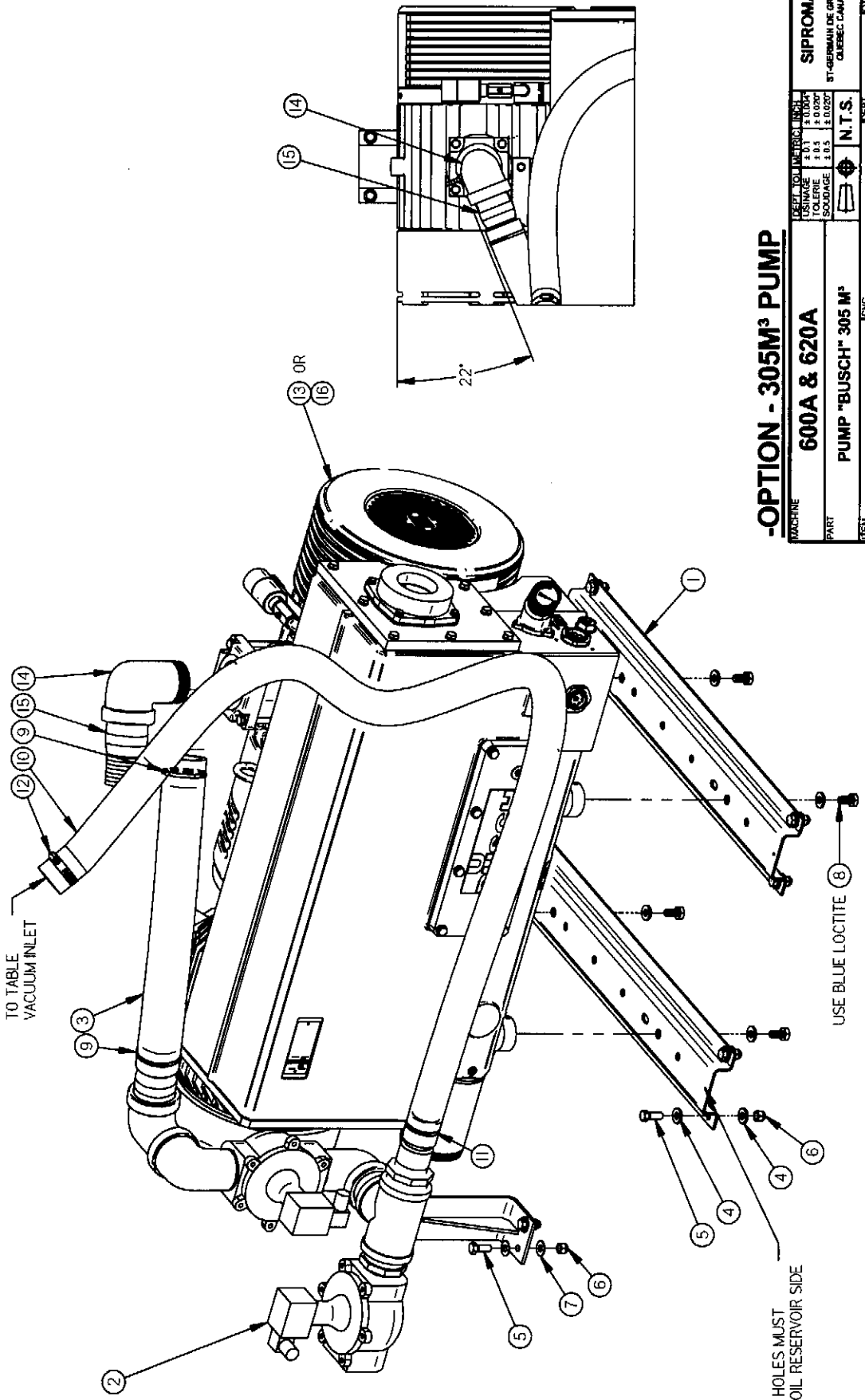


-OPTION - 165M³ PUMP

TOOLING	USE TOOLS METRIC INCH	STIPROMAC	ST-GERMAIN DE GRANBY/QUEBEC CANADA
DRYING	10 S	600A & 620A	
APP. BY	SBU	PUMP "BUSCH" 165 M ³ ASSEMBLY	
DATE	13-09-18		
DEPT.	M-1		
CITY			
NO.			004B1469

004A4141

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
9	105-0258	EAR CLAMP 2" S/S	2	1	001A6563	PUMP SUPPORT	2
10	104-0125	HOSE 1-1/2" ID VACUUM POLYWIRE (1720mm)	1	2	004A0863	VACUUM ATMOSPHERE VALVE ASSY	1
11	105-0250	EAR CLAMP 1-1/2" S/S	1	3	104-0150	HOSE 2" ID VACUUM POLYWIRE (554mm)	1
12	105-0110	SCREW CLAMPS 1-1/16" TO 2" ALL S/S	1	4	051-0783	WASHER 3/8" FLAT THICK S/S	20
13	125-0087	BUSCH RA-0305 230-460V/3PH/60HZ	1	5	051-0360	BOLT 3/8"-16nc. X 1" S/S	10
14	004A4082	BELLOWS ELBOW CONNECTOR ASSY	1	6	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	10
15	100-1250	STRAIGHT 2" MNPT X 2" HOSE BARB SS	1	7	051-0780	WASHER 3/8" FLAT S/S	4
16	125-0088	BUSCH RA-0305 575V/3PH/60HZ	1	8	051-09931	BOLT M10 X 20MM HEX SS	4



SMALL HOLES MUST BE ON OIL RESERVOIR SIDE

-OPTION - 305M³ PUMP

MACHINE	600A & 620A	DESIGN TO METRIC DIMS	±0.1	±0.001	SIPROMAC
PART	PUMP "BUSCH" 305 M³	USINAGE	+0.1	+0.001	ST-GERMAIN DE GRANBY
ITEM		TOLERANCE	+0.3	+0.001	QUEBEC CANADA
MAT.		SOUDEUSE	±0.5	±0.001	
					N.T.S.
DATE	13-11-21	APP. BY	SBU	NO.	004A4141
				DEPT.	M-1
				QTY.	1

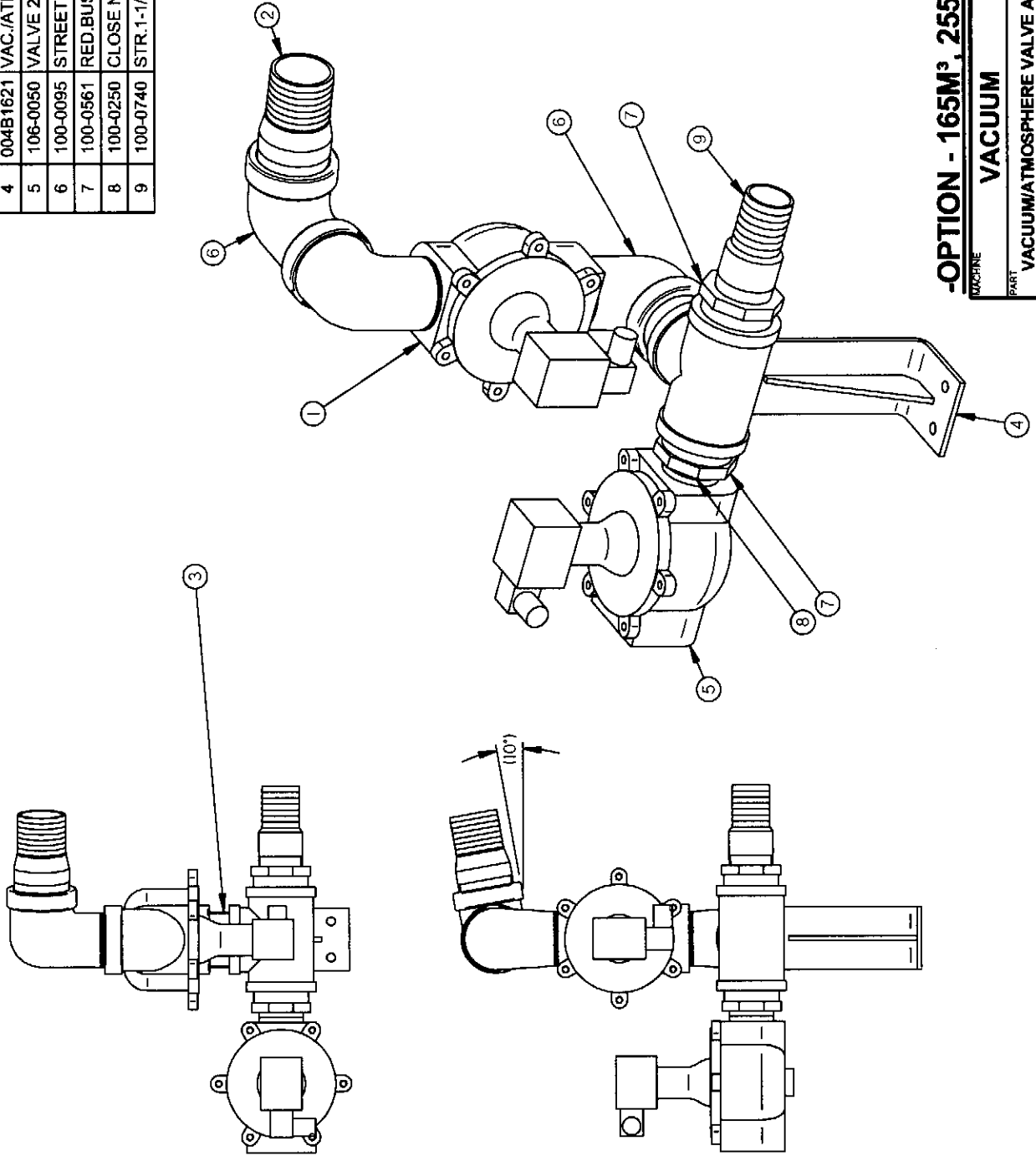
LET. _____ DATE _____ INT. _____

MODIFICATION

USE BLUE LOCTITE (8)

004A0863

ITEM	PART #	DESCRIPTION	QT.
1	106-0050	VALVE 2WAY 24V 1-1/4"NPT(B60)60HZ	1
2	100-1250	STRAIGHT 2"MNPT X 2" HOSE BARB SS	1
3	100-0250	CLOSE NIPPLE 2" NPT SS	1
4	004B1621	VAC./ATM. VALVE SUPP. PRE-ASSY	1
5	106-0050	VALVE 2WAY 24V 1-1/2"NPT(B60)60HZ	1
6	100-0095	STREET ELBOW 90° X 2" NPT SS	3
7	100-0561	RED.BUSH. 2"NPTX1-1/2"NPT SS	2
8	100-0250	CLOSE NIPPLE 1-1/2"NPT S/S	1
9	100-0740	STR.1-1/2"MNPTX1-1/2"HOSE SS	1



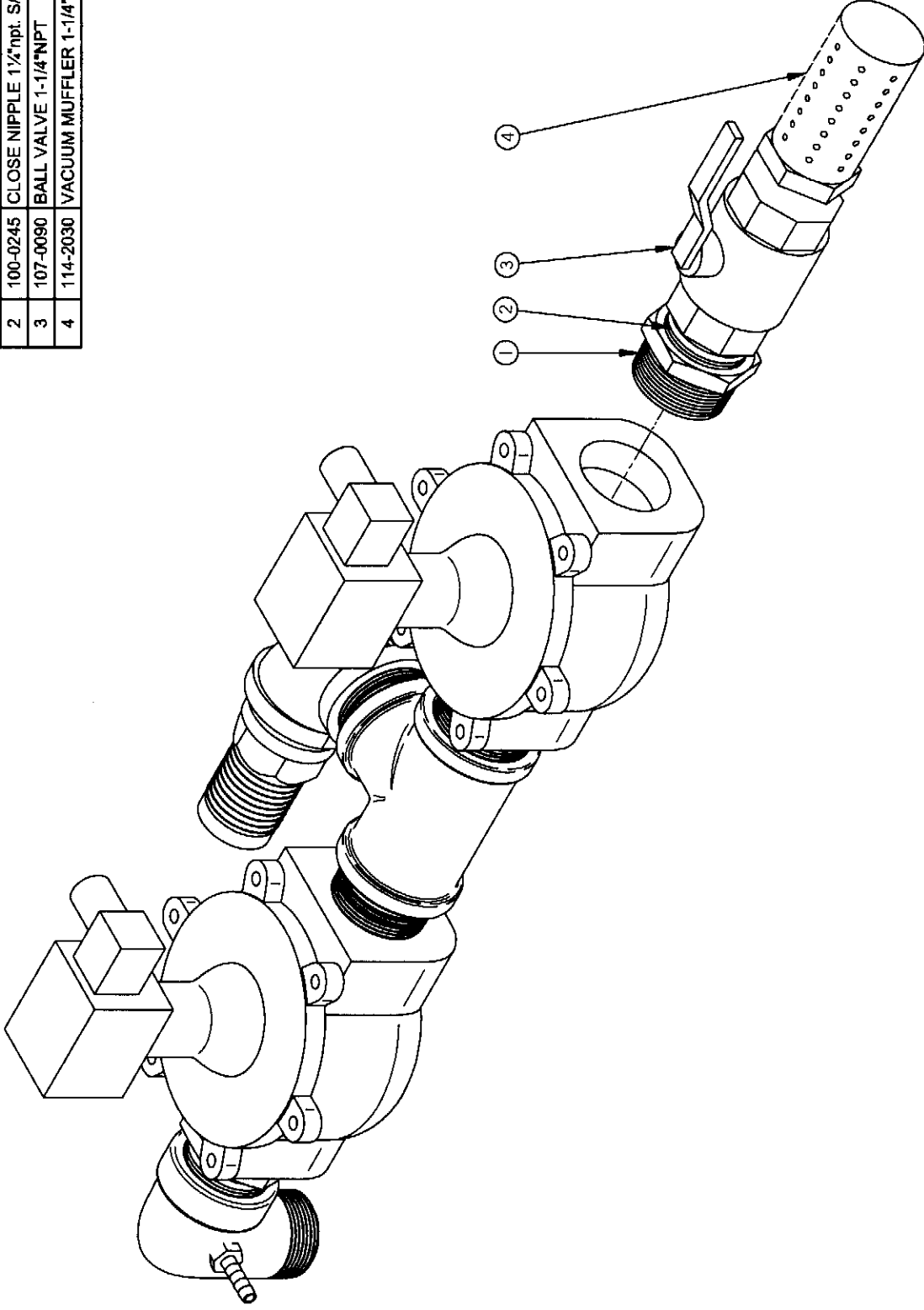
-OPTION - 165M³, 255M³ & 305M³ PUMP

DRAWING NO. 13-09-18 DATE 13-09-18 DATE 13-09-18		DEPT. M QTY. 1	
VACUUM VACUUM/ATMOSPHERE VALVE ASSY		N.T.S.	
SIPROMAC ST-GERMAIN DE GRANBY/QUEBEC CANADA		004A0863	
ITEM MAT.	ENG. BY SBU DATE 13-09-18	DEPT. M QTY. 1	004A0863

LET. _____ DATE INT. _____
 MODIFICATION _____

004A4111

ITEM	PART #	DESCRIPTION	QT.
1	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
2	100-0245	CLOSE NIPPLE 1/2"npt. S/S	1
3	107-0090	BALL VALVE 1-1/4"NPT	1
4	114-2030	VACUUM MUFFLER 1-1/4"NPT	1



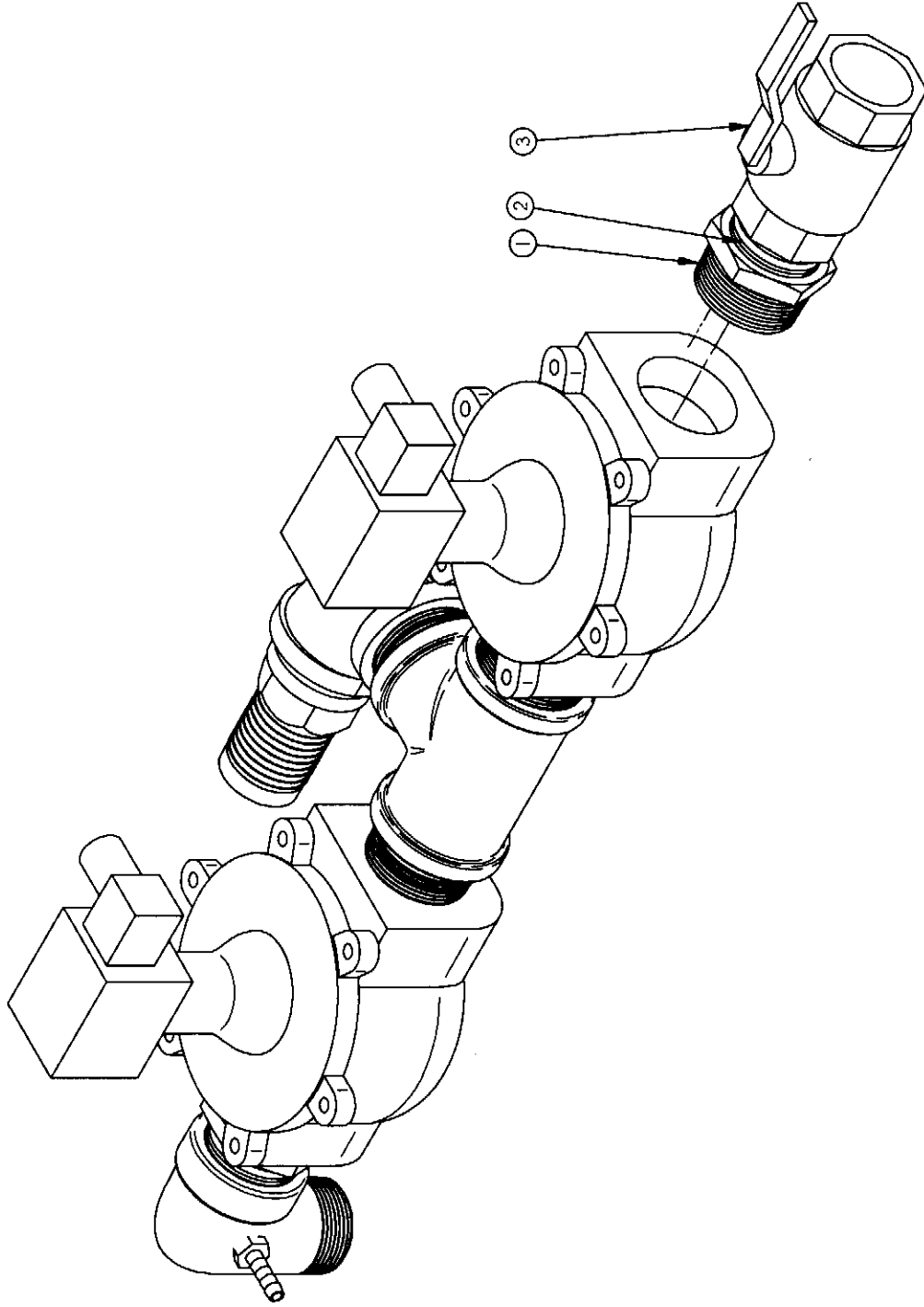
-OPTION - SOFT AIR + MUFFLER 40M³ @ 100M³

MACHINE		DEPT. TOOL METRIC LINES	
VACUUM		DESIGNANCE	3 0.1 ± 0.004
PART		TOLERANCE	1 0.5 ± 0.020*
VACUUM ATMOSPHERE VALVE (OPT SOFT AIR+MUFFLER)		SOUDAGE	1 2.5 ± 0.020*
ITEM		N.T.S.	
DATE		DATE	DEPT.
13-09-19		13-09-19	M
DRAWN BY SBU		APP BY	QTY. 1
MODIFICATION		004A4111	

LET.	DATE	INT.

004A4110

ITEM	PART #	DESCRIPTION	QT.
1	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
2	100-0245	CLOSE NIPPLE 1/4"npt. S/S	1
3	107-0090	BALL VALVE 1-1/4"NPT	1



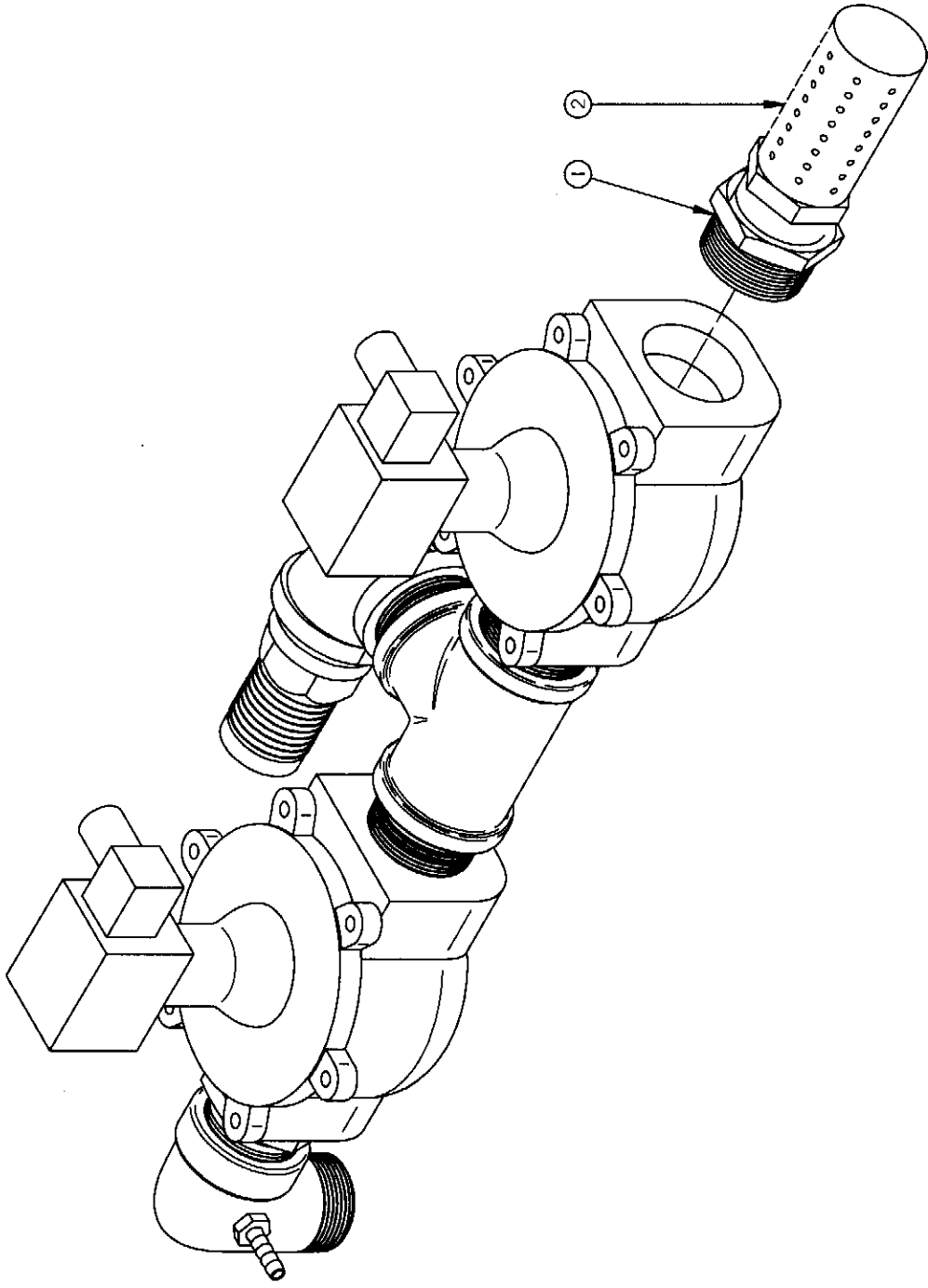
-OPTION - SOFT AIR 40M³ @ 100M³

MACHINE		DEPT. TO USE (SEE INCH)		SIPROMAC	
PART		DRYING	± 0.01	ST-GERMAIN DE GRANBY/VAL	
VACUUM ATMOSPHERE VALVE (OPT SOFT AIR)		FINISH	± 0.005	QUEBEC CANADA	
ITEM		SOLDAGE	± 0.02	N.T.S.	
MAT.		N.T.S.		DEPT.	M
DWG BY: SBU		DATE: 13-09-19	NO.	QTY: 1	
APP BY:		DATE:	004A4110		

LET. _____ DATE INT. _____
 MODIFICATION _____

004A4109

ITEM	PART #	DESCRIPTION	QT.
1	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
2	114-2030	VACUUM MUFFLER 1-1/4"NPT	1



-OPTION - MUFFLER 40M³ @ 100M³

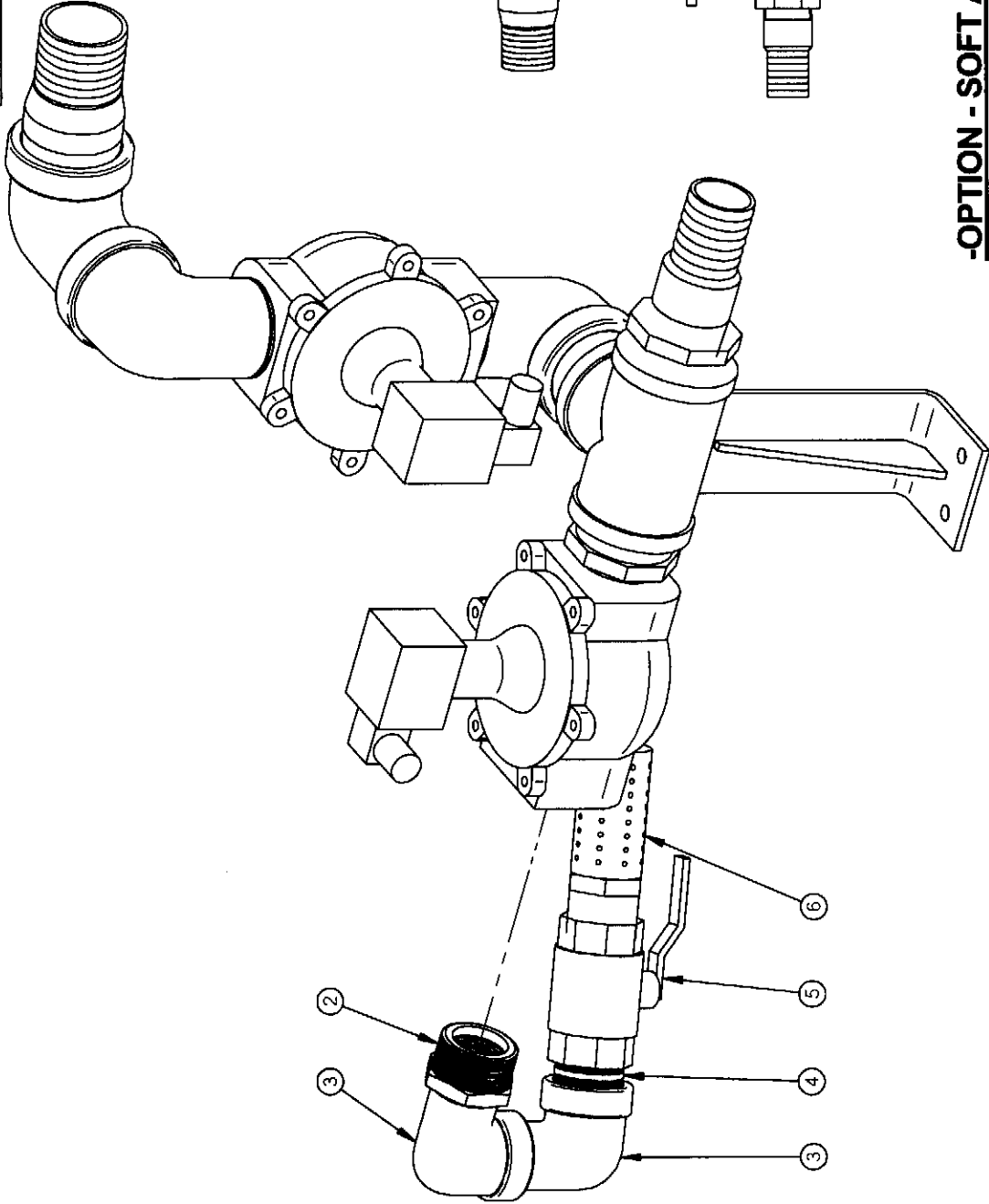
MACHINE	VACUUM	DESIGN (DIMENSIONS) INCH	SIPROMAC
PART	VACUUM/ATMOSPHERE VALVE (OPT MUFFLER)	FINISH	ST-GERMAIN DE GRANBY/AM
ITEM		TOLERANCE	QUEBEC CANADA
MAT.		SOUDAGE	
			N.T.S.
			REP.
			QTY.
			NO
			DATE
			DATE
			APP. BY
			NO
			DATE
			NO
			DATE

LET. _____ DATE INT. _____
 MODIFICATION _____

004A4109

004A4108

ITEM	PART #	DESCRIPTION	QT.
2	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
3	100-0090	STREET ELBOW 90° X 1-1/4" NPT SS	2
4	100-0245	CLOSE NIPPLE 1/4"npt. S/S	1
5	107-0090	BALL VALVE 1-1/4"NPT	1
6	114-2030	VACUUM MUFFLER 1-1/4"NPT	1



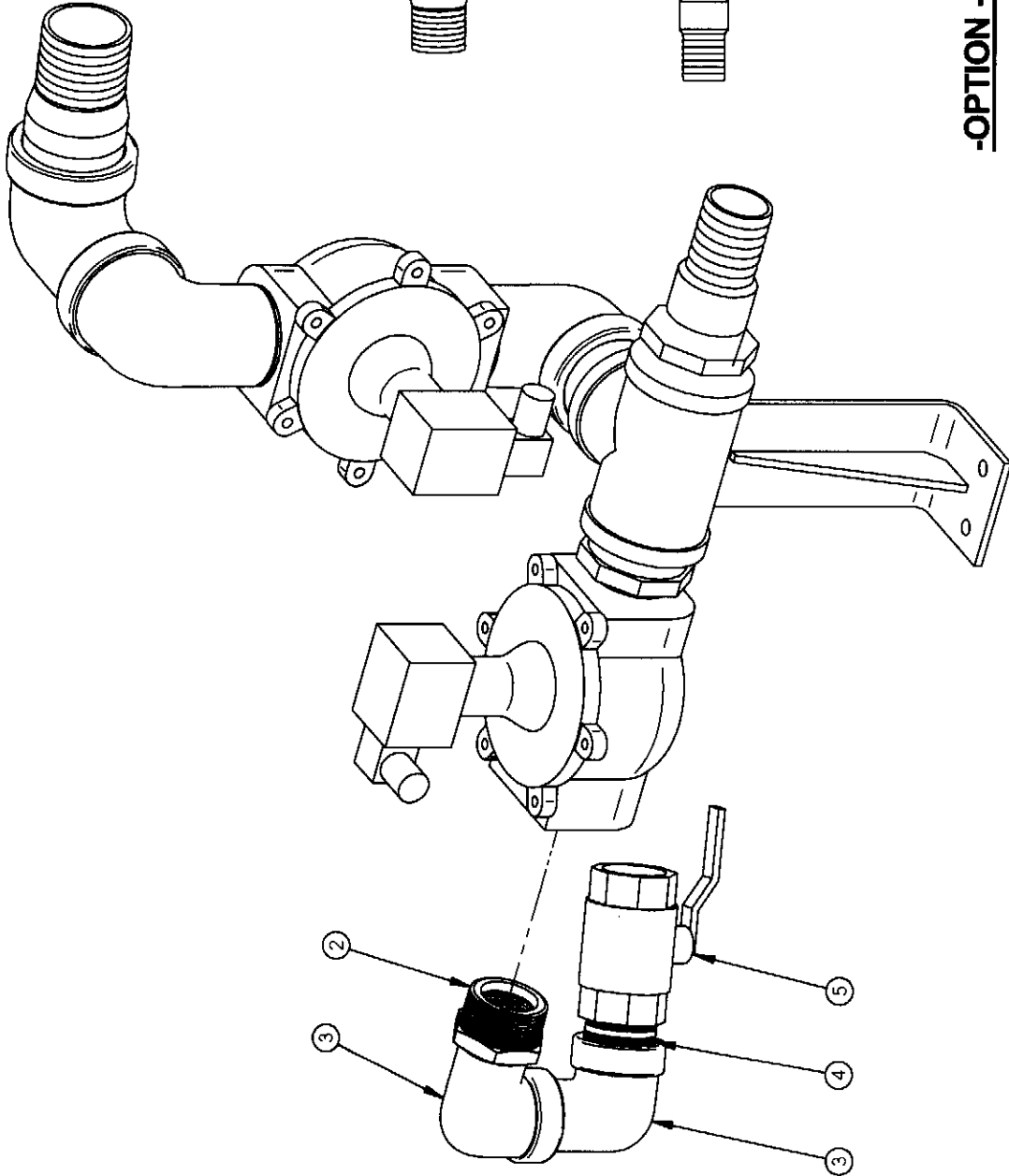
-OPTION - SOFT AIR + MUFFLER 165M³ @ 305M³

MACHINE	600A & 620A	DEPT. 101	101
PART	VACUUM ATMOSPHERE VALVE (OPT SOFT AIR + MUFFLER)	DESIGN	101
ITEM		CONTRACT	101
MAT.		DATE	13-09-18
		APP. BY	SBU
		DATE	
		REP.	M
		QTY.	1
		NO.	004A4108

LET.	MODIFICATION	DATE	INT.
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004A4107

ITEM	PART #	DESCRIPTION	QT.
2	100-0555	RED BUSH 1-1/2" x 1-1/4" NPT S/S	1
3	100-0090	STREET ELBOW 90° X 1-1/4" NPT SS	2
4	100-0245	CLOSE NIPPLE 1/2"npt. S/S	1
5	107-0090	BALL VALVE 1-1/4"NPT	1



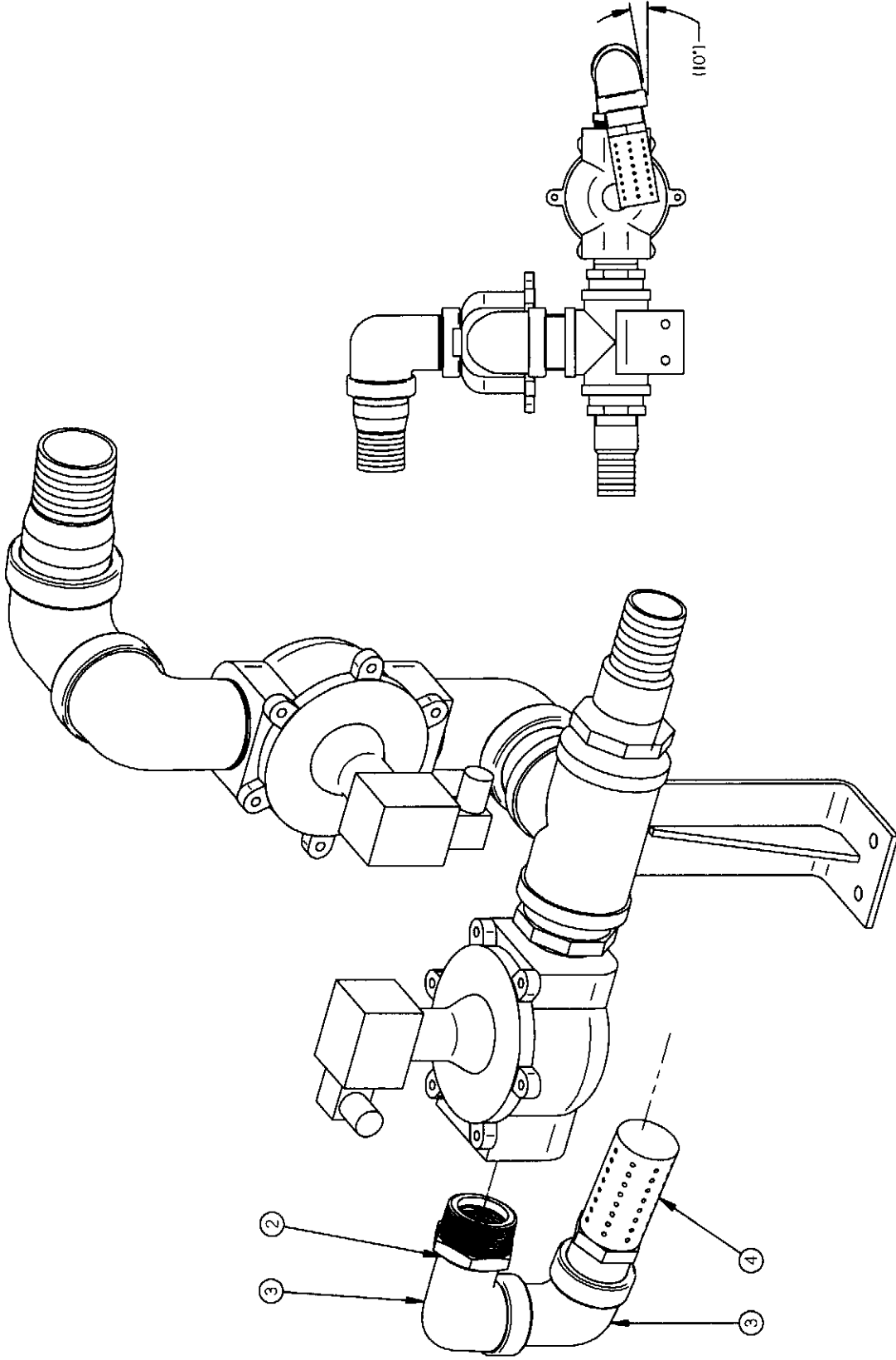
-OPTION - SOFT AIR 165M³ @ 305M³

MACHINE	600A & 620A	DEPT. 100 METRIC UNITS	SIPROMAC
PART	VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR)	USINAGE ± 0.1 ± 0.004	ST-GERMAIN DE GRANBY
ITEM		TOLERANCE ± 0.5 ± 0.007	QUEBEC CANADA
DATE	13-09-18	SOUDAGE 1/2 ± 0.02	
APP. BY	SBU		
DATE			
REP.	M		
QTY.	1		
NO.			004A4107

LET.	MODIFICATION	DATE	INT.
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004A4106

ITEM	PART #	DESCRIPTION	QT.
2	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
3	100-0090	STREET ELBOW 90° X 1-1/4" NPT SS	2
4	114-2030	VACUUM MUFFLER 1-1/4"NPT	1



-OPTION - MUFFLER 165M³ @ 305M³

MACHINE	600A & 620A	DEPT. TO WHICH ORDERED	SIPROMAC
CAST	VACUUM/ATMOSPHERE VALVE (OPT MUFFLER)	QUANTITY	1
ITEM		DATE	13-09-18
		BY	SIBU
		DATE	
		NO.	004A4106
		DEPT.	M
		QTY.	1

ST-GERMAIN DE GRANBY/QUÉBEC CANADA

100% TOLERANCE
± 0.1
± 0.020"

100% SOLIDAGE
± 0.1
± 0.020"

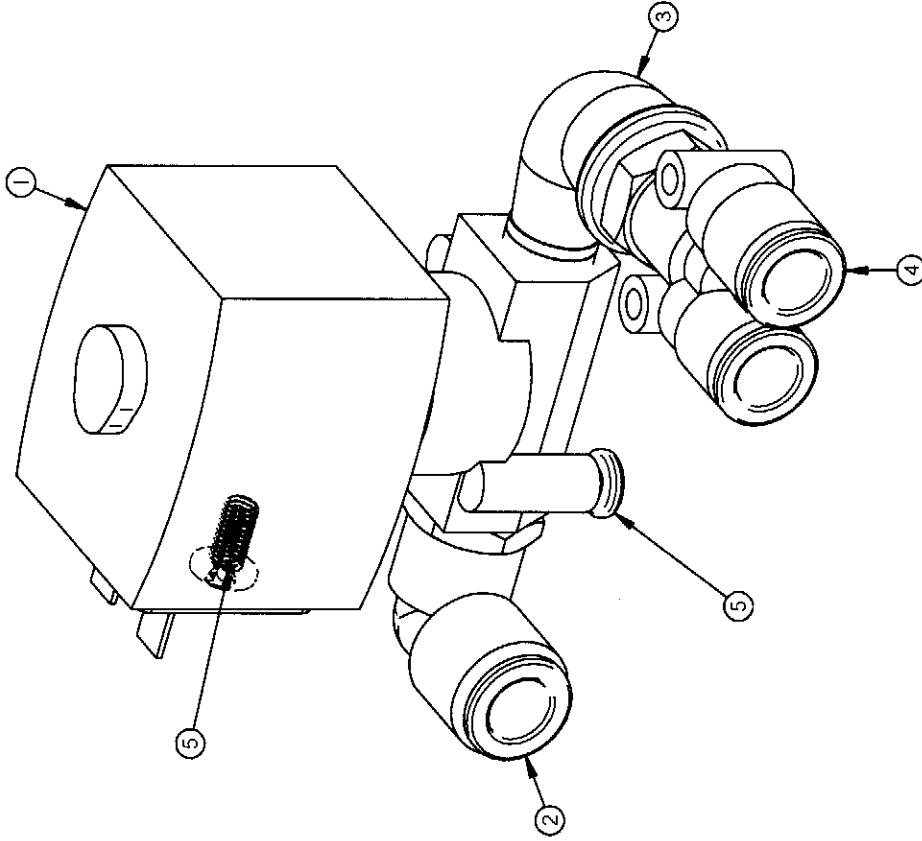
N.T.S.

LET. _____ DATE INT. _____

MODIFICATION _____

004A4113

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	VALVE 2WAY 24V 1/4"NPT(G22) 60Hz	1
2	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	1
3	100-0065	STREET ELBOW 1/4" NPT SS	1
4	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	1
5	051-01753	SCREW 10-32 X 3/8" PAN PHIL SS	3



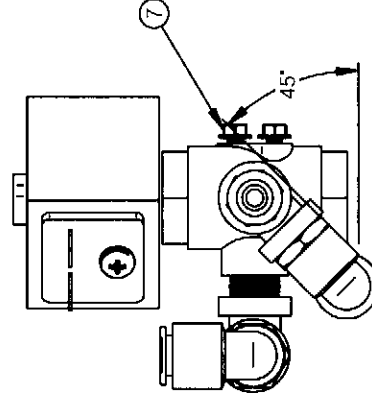
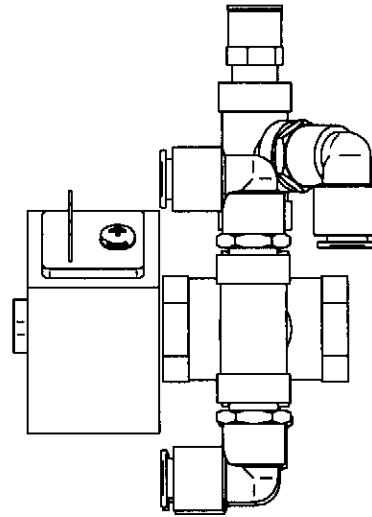
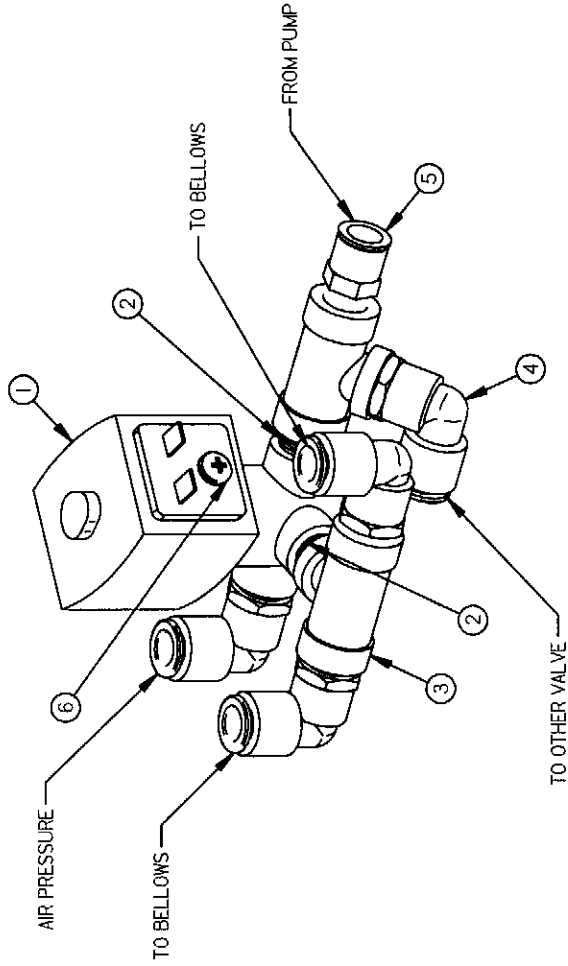
-OPTION - GAS

MACHINE		DEPT. 100 METRIC INCH	
PART		US INCH	± 0.004
VACUUM		TOLENRE	± 0.002
GAS VALVE ASSEMBLY (OPTION)		SOLDAGE	± 0.002
ITEM		N.T.S.	
DATE		DEPT.	QTY.
13-09-23		M	2
BY: SBU		NO	
DATE		004A4113	

LET. _____ MODIFICATION _____ DATE INT. _____

004A4105

ITEM	PART #	DESCRIPTION	QT.
1	106-0070	VALVE 3WAY 24V 1/4"NPT(G176)60HZ	1
2	100-0225	CLOSE NIPPLE 1/4" NPT SS	2
3	100-0463	TEE 1/4" NPT S/S	2
4	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	4
5	102-0410	MALE CONN. 1/4" MNPT X 3/8" T. QUICK	1
6	051-01753	SCREW 10-32 X 3/8" PAN PHIL SS	1
7	051-01065	SELF TAPPING SCREW 8-32 X 3/8" HEX SS	2



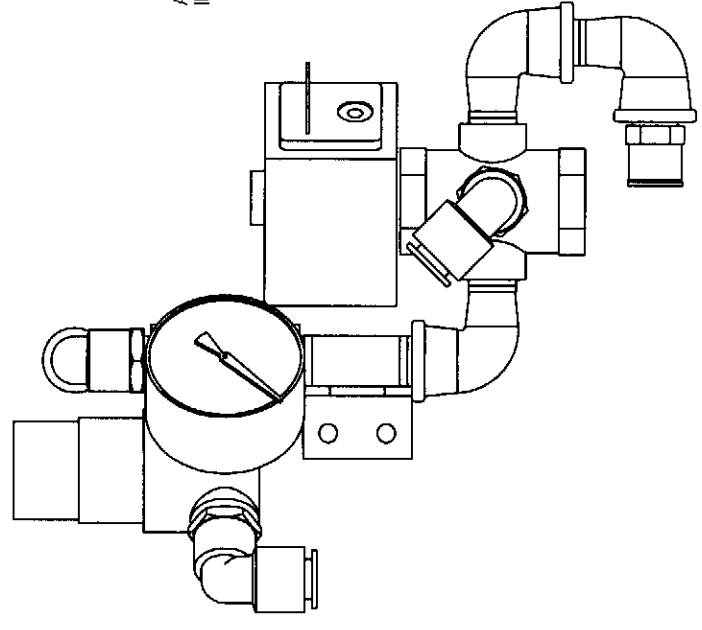
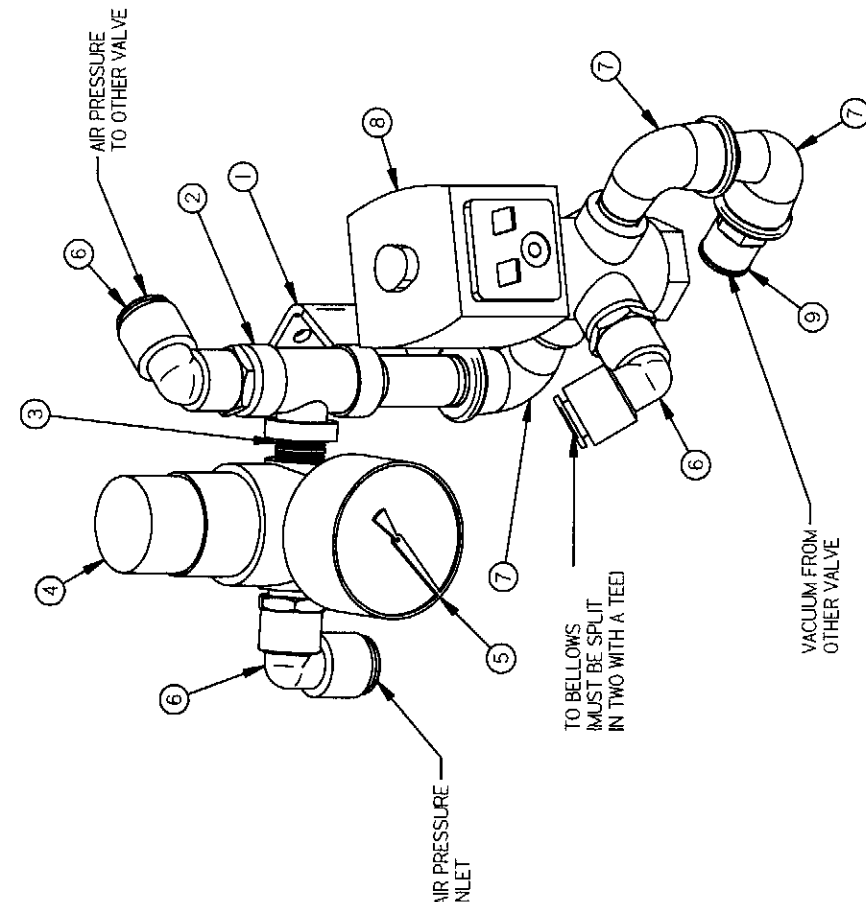
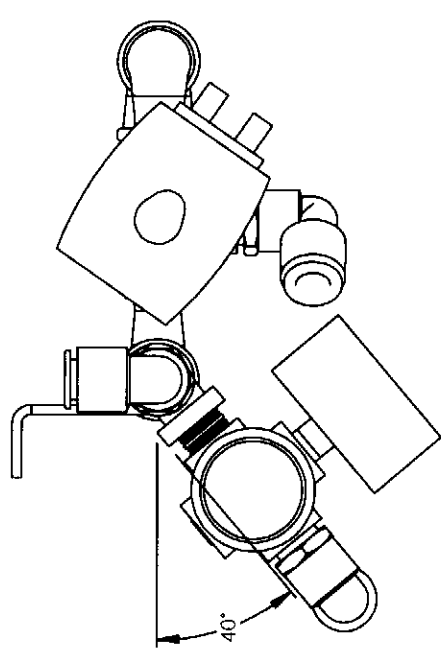
-OPTION - AIR REGULATOR

MACHINE	VACUUM		DEPT. NO.	106	INSTRUC. NO.	106
PART	BELLOWS VALVE ASSY (OPT AIR REG)		USAGE	2 01	2 000P	2 000P
ITEM	GNC		SOLD/AGE	1 01	1 010T	1 010T
MAT.	SBU		DATE	13-09-17	DATE	13-09-17
DRAWN BY			DATE			NO.
APP BY			DATE			NO.
GNC			N.T.S.			DEPT.
M			M			QTY
004A4105			004A4105			1

LET. _____ MODIFICATION _____ DATE INT. _____

004A4103

ITEM	PART #	DESCRIPTION	QT.
1	004A4140	AIR REGULATOR SUPPORT	1
2	100-0463	TEE 1/4" NPT S/S	1
3	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
4	114-0147	PRESSURE REGUL. 0-60 PSI 1/4" NPT	1
5	114-0245	PRESSURE GAUGE 60 PSI 1/8" NPT	1
6	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	3
7	100-0065	STREET ELBOW 1/4" NPT SS	3
8	106-0070	VALVE 3WAY 24V 1/4"NPT(G176)60Hz	1
9	102-0410	MALE CONN. 1/4"MNPTx3/8" T. QUICK	1

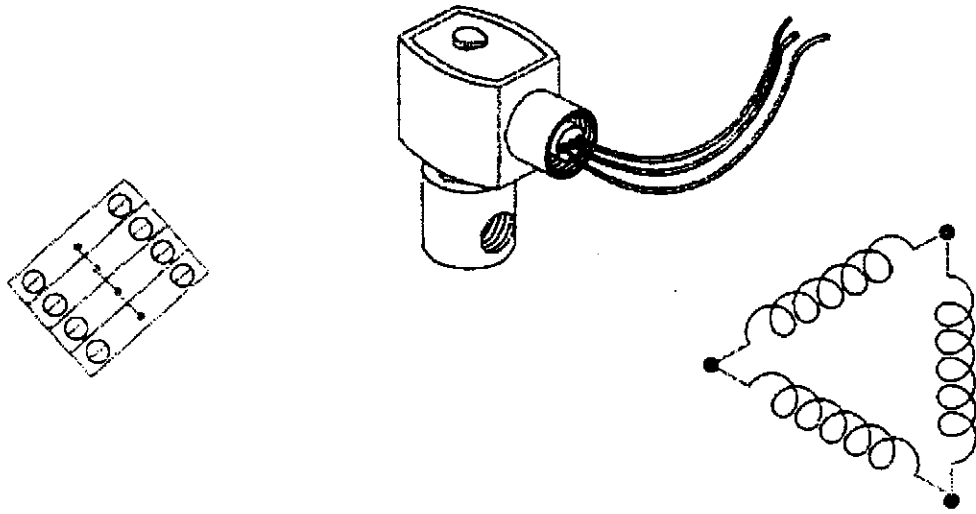


-OPTION - AIR REGULATOR

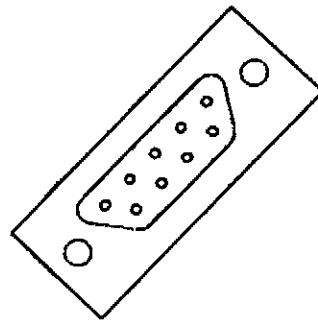
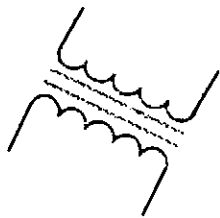
MACHINE	600A & 620A	DEPT. TO: METRIC INCH	SIPROMAC
PART	AIR REGULATOR VALVE ASSY	FINISH: ± 0.01	ST-GERMAIN DE GRANITUM
ITEM		TOLERANCE: ± 0.5	QUEBEC CANADA
MAT.		SOUDAGE: ± 0.020"	
		Ø: N.T.S.	
		DEPT.:	QTY. 1
		DATE: 13-09-19	
		APP. BY: SBU	
			004A4103

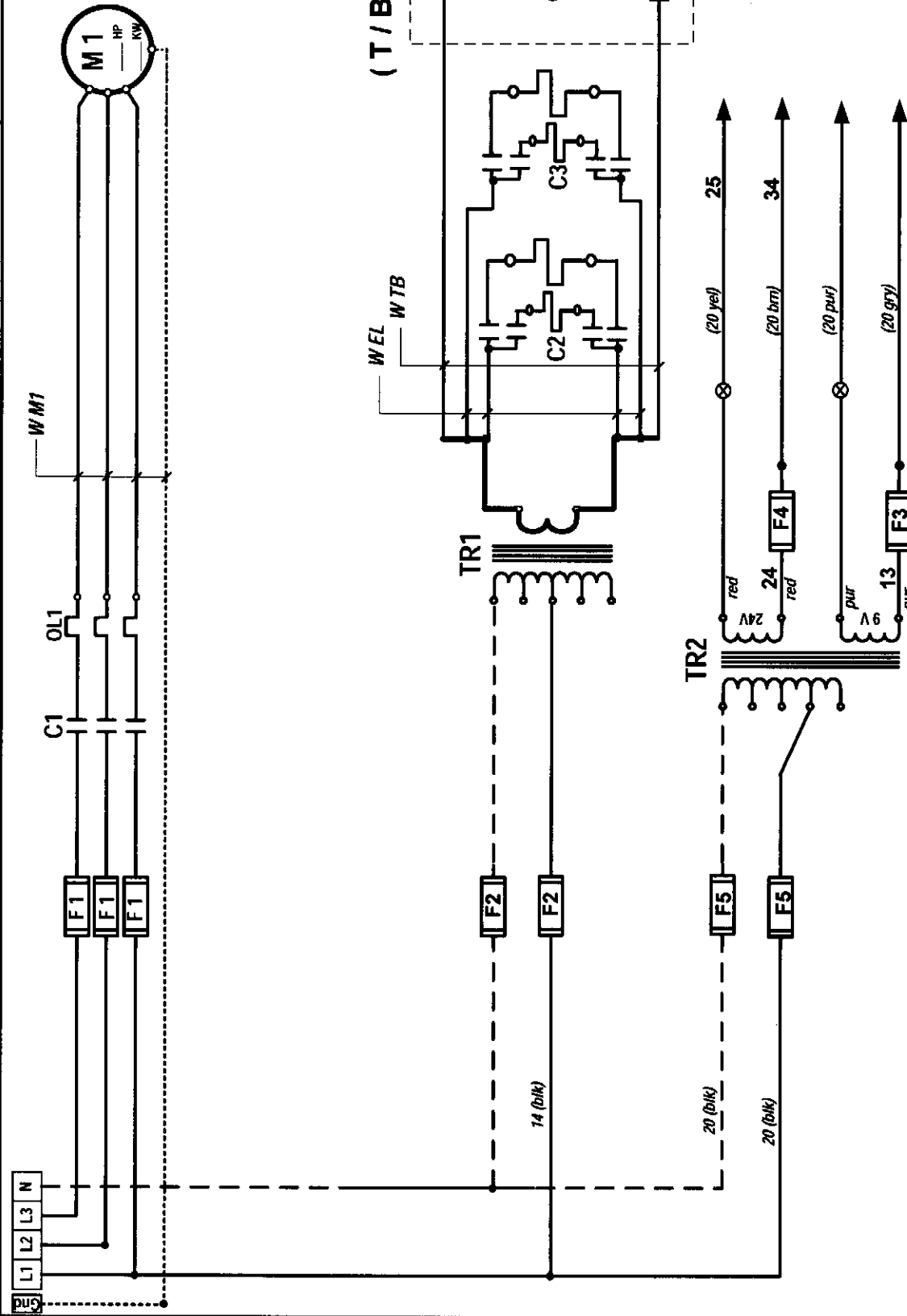
LET. _____ DATE INT. _____

MODIFICATION



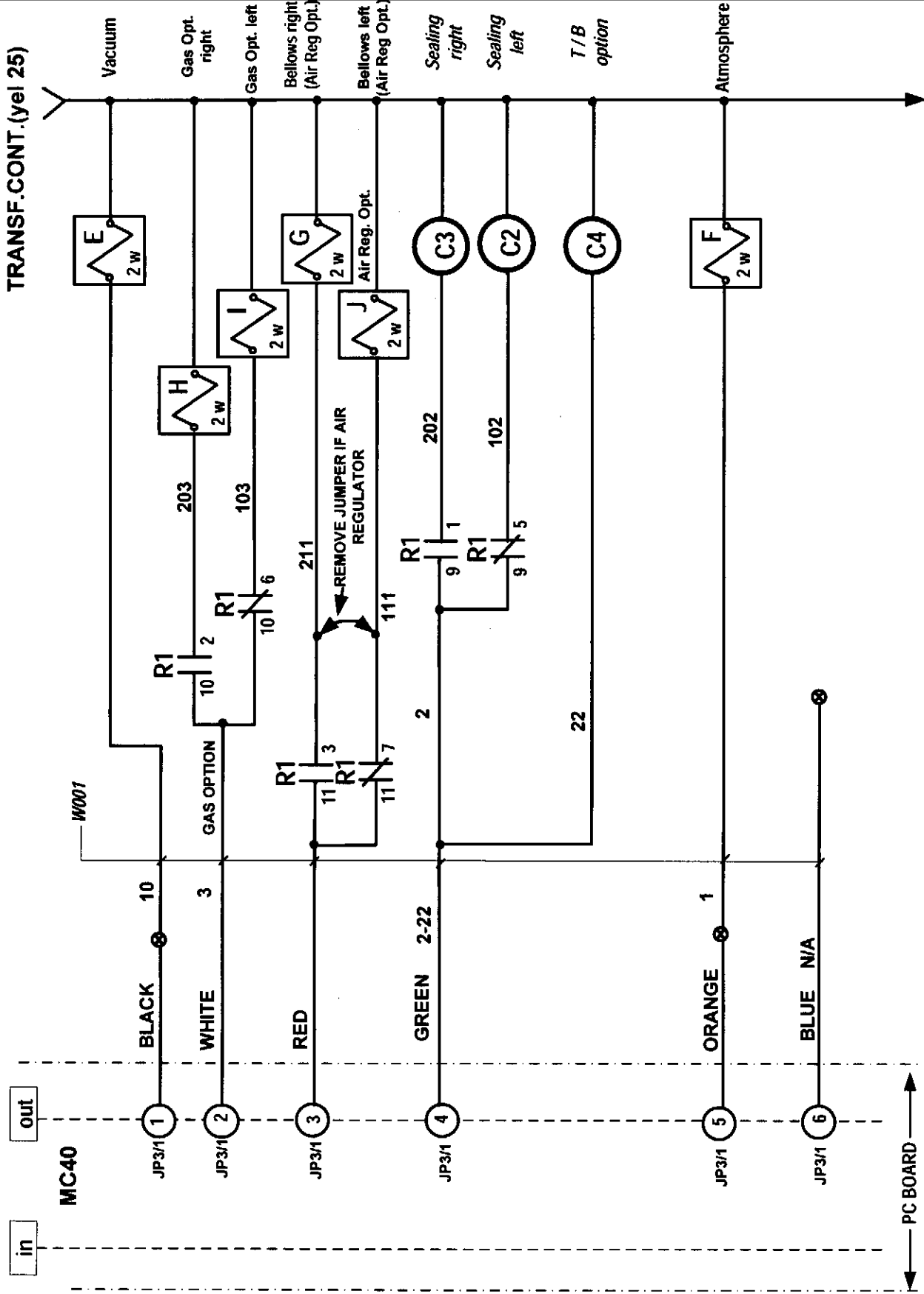
ELECTRICAL DRAWING





category	VACUUM PACK	model	600A	volt	3Ph 60Hz
system				circuit	
year	05	month	01	day	18
concept	PP	draw	PP	app	DL
usual functions					
options					
				006-1330	PAGE 1 de 1

SIPROMAC
St-Germain de Granby
QUEBEC, CANADA



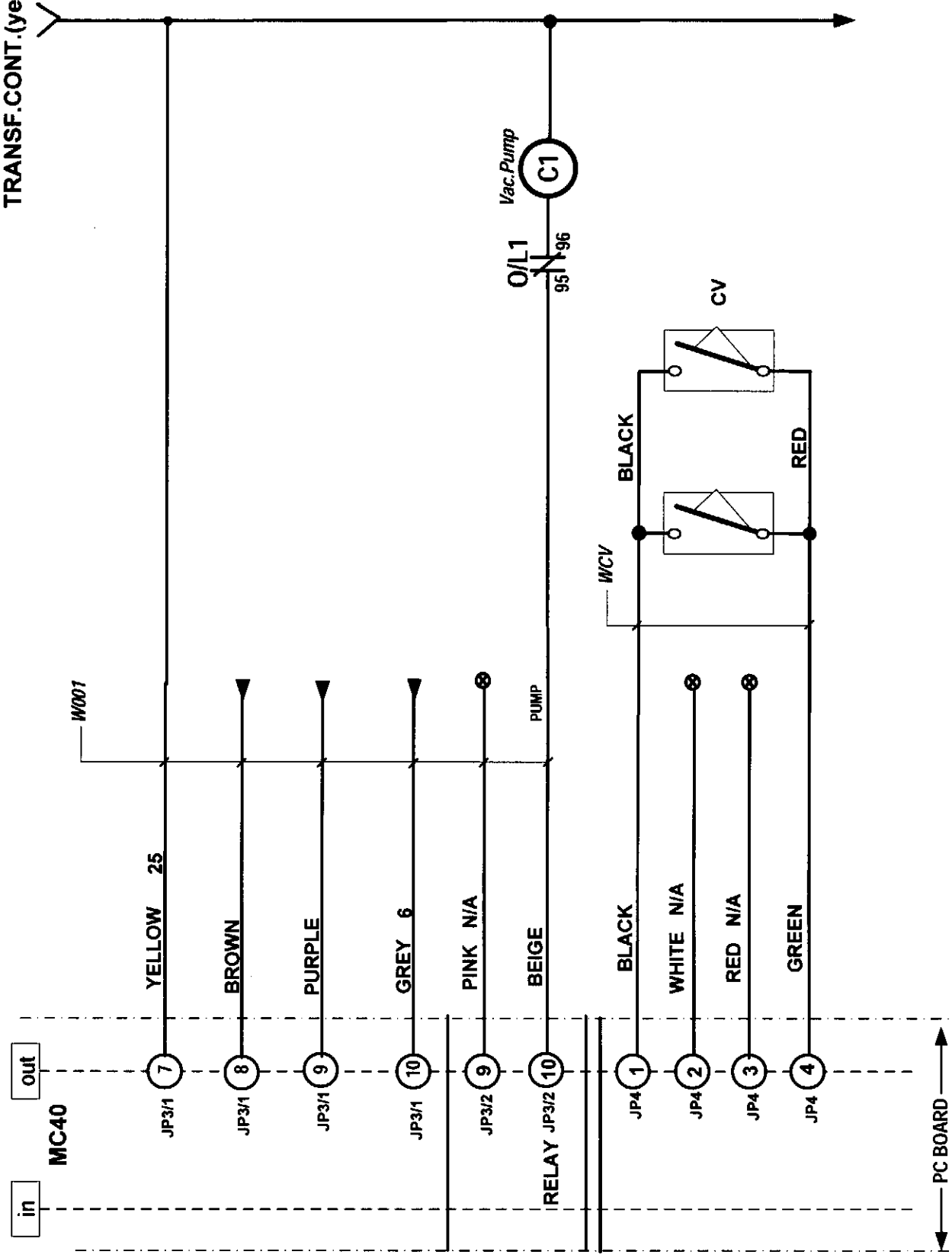
!

RC filters must be connected on each AC coil (not shown on diagram)

category	VACUUM PACK	model	620A	vol.	24V 50HZ
system	fruit				
usual functions	year	month	day	app	DL
options	04	12	08	PP	PP
	concept	draw	draw	DL	DL
				006A0481	PAGE 3 DE 5

SIPROMAC
 St-Germain de Grantham
 QUEBEC, CANADA

TRANSF.CONT.(yel 25)

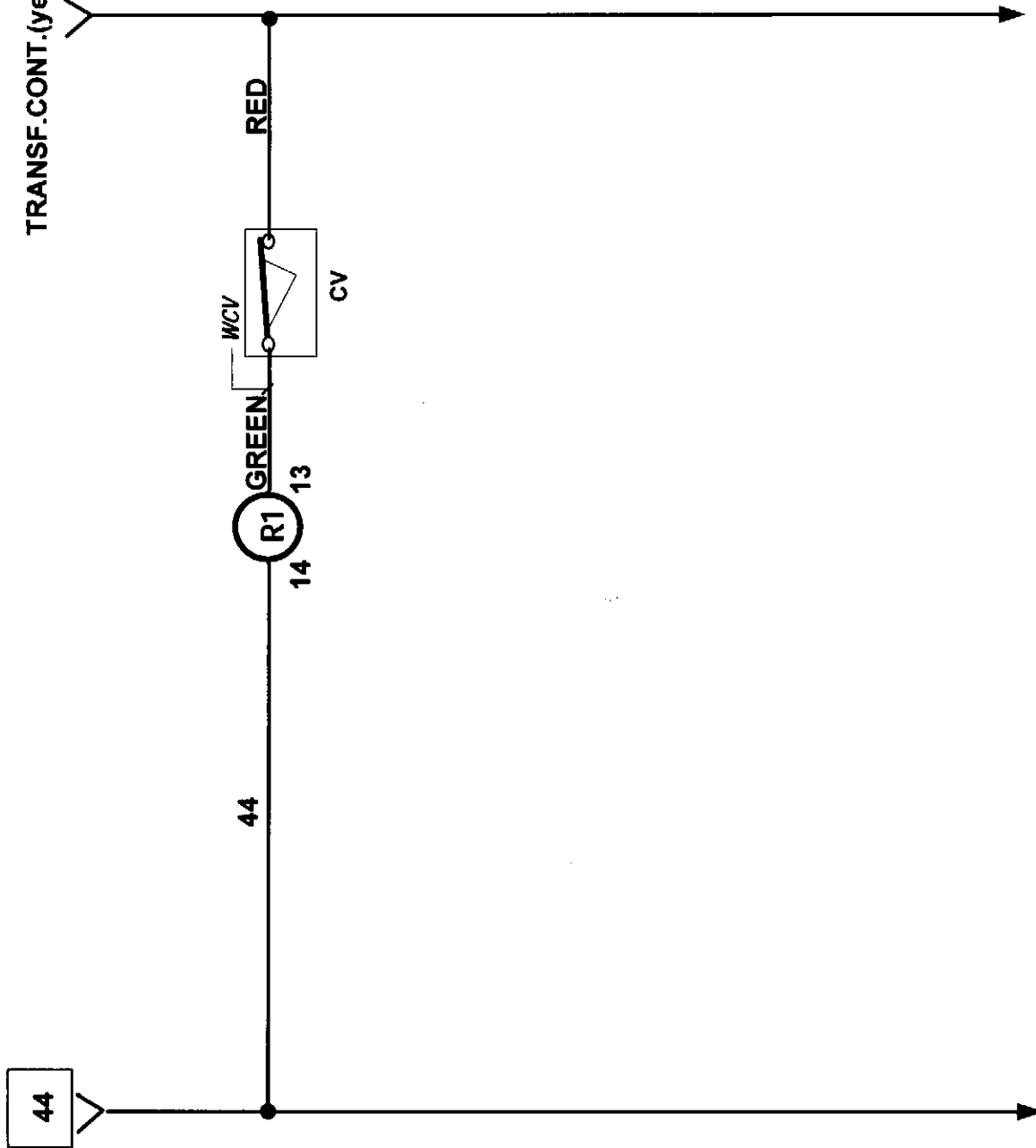


Category		VACUUM PACK		model	620A	vol.	24V 50Hz	
system				concept		year	month	day
usual functions				draw		04	12	08
options				app		PP	PP	DL
				DL		006A0481		PAGE 4 de 5

RC filters must be connected on each AC coil (not shown on diagram)



TRANSF.CONT.(yel 25)



!
 RC filters must be connected on
 each AC coil (not shown on diagram)

category	VACUUM PACK	model	620A	volt.	24V 50HZ
system				circuit	
usual				year	04
functions				month	12
options				day	08
				block	
				concept	PP
				draw	PP
				app	DL
				DL	
				006A0481	PAGE 5 de 5
				SIPROMAC	St-Germain de Grantham QUEBEC, CANADA

#	SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
028-0022		TERMINAL BLOCK M10/10	SUPPLY	208V/3PH/60HZ	600A	L1-L2-L3		3
028-0025		GROUND TERMINAL BLOCK M16/12P	SUPPLY	208V/3PH/60HZ	600A	GND		1
028-0060		SEPARATOR M4/6	SUPPLY	208V/3PH/60HZ	600A	L1-L2-L3		3
028-0080		BAM END STOP (BUTEE D'ARRET)	SUPPLY	ALL	600A			1
028-0105		GROUND BARRIER (6 HOLES)	SUPPLY	ALL	600A	GND		1

034-0700		FUSE HOLDER 30A/600V GOULD	SEALING	208V/3PH/60HZ	600A	F2		2
034-0450		FUSE MIDGET 7A/250V TIME-DELAY	SEALING TWIN SEAL	208V/3PH/60HZ	600A	F2	B1	2
029-0040		TRANSFO 600VA/208-240/24V 60HZ	SEALING TWIN SEAL	208V/3PH/60HZ	600A	TR1	B1	1
027-0220		TERMINAL ROUND STUD #10 600V 75°C	SEALING	ALL	600A			4
025-0020		CONTACTOR ITH-25A-CSA,UL	SEALING	ALL	600A	C2+C3		2
030-0410		TEW #10/104 BLACK	SEALING	ALL	600A	WEL		12M.
027-0210		TERMINAL FEMALE .250" INSULATED 600V 75°C	SEALING	ALL	600A	WEL		8
005A0568		SEAL BAR ASSY W/SUPPORT	SEALING TWIN SEAL	ALL	600A		B1	4
034-0470		FUSE MIDGET 10A/250V TIME-DELAY	SEALING BAG CUT	208V/3PH/60HZ	600A	F1	B2	2
029-0062		TRANSFO 750VA 208-240V/30V/60HZ	SEALING BAG CUT	208V/3PH/60HZ	600A	TR1	B2	1
005B0569		SEAL BAR ASSY W/SUPPORT	SEALING BAG CUT	ALL	600A		B2	4
034-0500		FUSE MIDGET 15A/250V TIME-DELAY	SEALING TOP & BOTTOM	208V/3PH/60HZ	600A	F1	B3	2
029-0079		TRANSFO 1000VA 208-240/24V 60H	SEALING TOP & BOTTOM	208V/3PH/60HZ	600A	TR1	B3	1
027-0220		TERMINAL ROUND STUD #10 600V 75°C	SEALING TOP & BOTTOM	ALL	600A		B3	2
025-0020		CONTACTOR ITH-25A-CSA,UL	SEALING TOP & BOTTOM	ALL	600A	C4	B3	1
030-0120		CAB TIRE	SEALING TOP & BOTTOM	ALL	600A	WTB	B3	3M.
027-0065		TERMINAL FLAG FEMALE YELLOW .250"	SEALING TOP & BOTTOM	ALL	600A	WTB	B3	4
005A0570		SEAL BAR ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	600A		B3	4
005A0386		UPPER SEAL BAR ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	600A		B3	2

# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	600A	W001		2.5M.
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	600A	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	600A	WCV1+WCV3		2.5M.
030-0610	PVC #22-2COND.300V CSA RED/BLK	INPUT CONTROL	ALL	600A	WCV2		0.5M.
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	600A	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	600A	JP4		2
033-0038	MICROPROCESSOR MC-40 SENSOR VACUUM	CONTROL WITH SENSOR	ALL	600A	MC-40	C1	1
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL W/O SENSOR	ALL	600A	MC-40	C2	1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	600A		D1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	600A		D2	1

