

MODEL 620A

VACUUM PACKAGING MACHINE

MODEL 620A

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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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SIPROMAC INC.

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

1. SETTING UP THE MACHINE:

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

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

Before starting to work, check the oil view glass on the pump, if there is a sufficient quantity of oil in the pump. Never use oil other than recommended by the producer. Never exceed maximum quantity of oil indicated, when adding or changing oil.

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

2. Con't

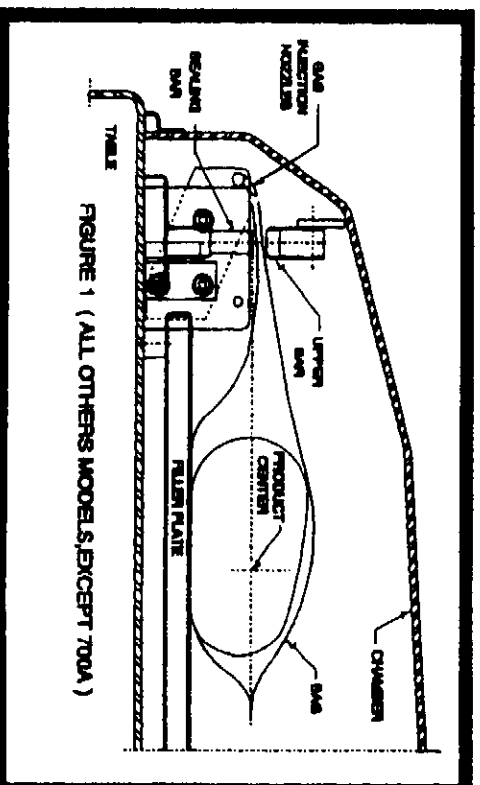
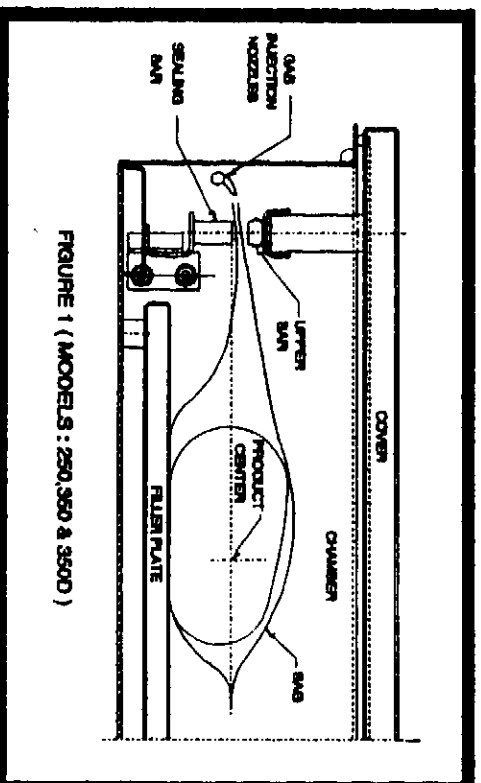
An important step in connecting the machine is to make sure that the pump turns in its correct rotation.

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

3. OPERATION:

3.1 Working principles:

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



3.1 Con't

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

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

3.2 Special packaging:

3.2.1 Gas flushing:

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

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

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

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

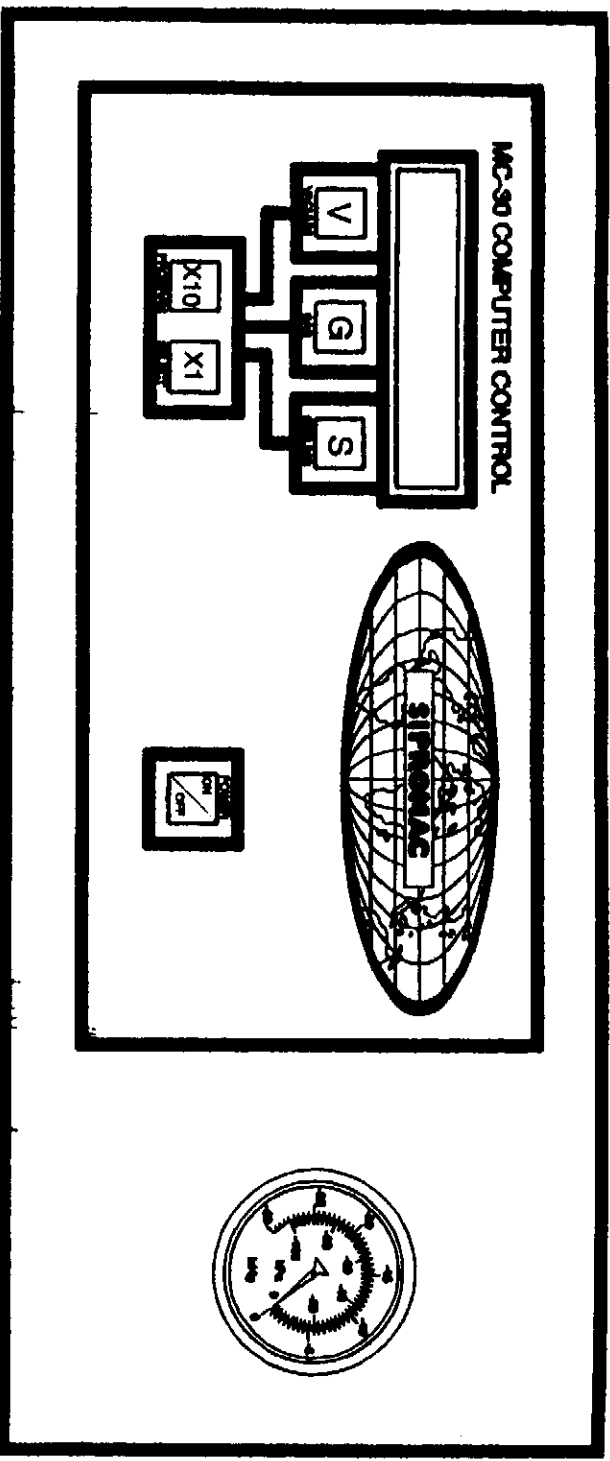
When sealing aluminium laminate bags (especially bags for e.g. coffee) it is imperative to have an upper and a lower sealing bar.

3.2.3 Electrical bag cut:

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

3.3 Setting of digital controls for MC-30E P.C. board:

Control pannel:



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

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

How to program a complete cycle:

To enter the vacuum time (sec.):

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

To enter the gas time (sec.):

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

To enter the sealing time (sec. decimals):

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

The micro-processor will memorize the last program you entered. The system functions with a 5 volt Cadmium Nickel battery which lasts approximately 3 years and recharges automatically if your machine remains plugged in. You may notice, during the first few days of use, that your micro-processor does not keep you program in memory, it is normal due to the fact that your battery is not yet fully charged.

BASIC PROGRAM TO MODIFY ACCORDING TO THE PRODUCTS

MACHINE	"V"	* "G"	"S"
VAC 250	18 sec.	As needed	1.2 sec.
VAC 350,350D	20 sec.	As needed	1.3 sec.
VAC 450T,450A	20 sec.	As needed	1.3 sec.
VAC 420A	22 sec.	As needed	1.3 sec.
VAC 550A	25 sec.	As needed	1.5 sec.
VAC 580A	25 sec.	As needed	1.5 sec.
VAC 600A	25 sec.	As needed	1.5 sec.
VAC 620A	25 sec.	As needed	1.5 sec.
VAC 650A	27 sec.	As needed	1.5 sec.
VAC 650A AUTOMATIC	27 sec.	As needed	1.5 sec
VAC 700A	27 sec.	As needed	1.5 sec.

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

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








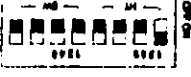


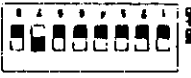



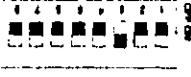

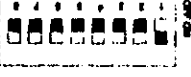

Warning: Do not increase the sealing time too much to prevent damaging the teflon.

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

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

Sealing time security:

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

BEFORE AUGUST 94									
FROM AUGUST 94									

TIME LIMITS:

Time limit factory settings:

250	3.0
350, 350D	3.8
420A	4.6
450T, 450A	4.6
550A	4.6
580A	4.6
600A	4.6
620A	4.6
650A	4.6
650A AUTOMATIC	4.6
700A	4.6

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

3.4 Daily cleaning:

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

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

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

4. TROUBLE SHOOTING:

4.1 Failure during a packaging cycle:

The lid is closed and cycle fails to start or stop immediately after having started:

Micro switch is actuated too late, re-set the micro switch.

Fault in supply of electricity to the timing control (power on light does not go on):

Check input voltage at transformer (Faulty contact in wires);

Check secondary voltage of transformer (approx. 24 Volt AC);

Check fuse;

If none of these apply, change the PC board.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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

4.2.2 No leakage in the bag:

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

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

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

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

Verify at vacuum hose connections.

Verify valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

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

4.5 Control board failure

PROBLEM	POSSIBLE CAUSE
---------	----------------

1. No display
switch on

1.1 Programming
error

Press on/off
membrane

1.2 No current
coming to PC
board

Check fuses
Check voltage between
pins #6 and #13 on "D"
connector, the reading
should be approx.
9 volts AC (if not
it's due to trans-
former or wiring
defect)

1.3 On/off key
defective
membrane

Disconnect flat cable
between PC board and
switch and jump pins 1
and 2 or 7 and 8
using a screw
driver
Replace PC board

1.4 Defective
PC board

2. Two digits
continuously
flashes on
"Y", "G" or
"S"

2.1 Programming
error

Press corresponding
"Y", "G" or "S" key

2.2 Defective
membrane

Replace membrane

2.3 Defective
PC board

Replace PC board

4.5 Con't

3. All of the display continuously flashes

3.1 Cover switch remains closed

Check cover switch or continuity between pins #8 and #15 PC board connector (see dwg #006-0029)

3.2 Defective

Replace PC board

4. Display is on but impossible to program any valves

4.1 Programming error

Press "V", "G" or "S" to be in programming mode. Only one at a time

4.2 Defective PC board

Replace PC board

5. Impossible to program one timer ("V", "G" or "S") (the display is on) (see step 4 first)

5.1 Defective membrane

Replace membrane

5.2 Defective PC board

Replace PC board

6. PC board doesn't keep data in memory

6.1 Battery not charged

Run the machine or leave it plugged in with switch off for a few hours to charge battery

6.2 Defective battery

Replace battery or complete PC board (the battery is mounted on the PC board)

6.3 Defective

Replace PC board
PC board

4.5 Con't

7. Cycle does'nt start

7.1 Poorly adjusted cover switch

Adjust

7.2 Bad connection or defective limit switch

Verify

7.3 Defective PC board

Replace PC board

7.4 PC board is OK, outputs are defective (See dwg # 006-0029)

Check pump fuses, pump contactor coil, valves, etc..

8. Machine "recycling" or cycle "re-start" continuously

8.1 Poorly adjusted cover switch

Adjust

8.2 Defective PC board

Replace

9. Double chamber: vacuum sealing or atmosphere is not done on one side only

9.1 Defective relay or connection

Replace the APDT (in electrical box). This relay switch functions from one side to the other (the PC board is good because there is one output which control's both sides)

9.2 Defective contactor or valve

Test voltage on coil

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).

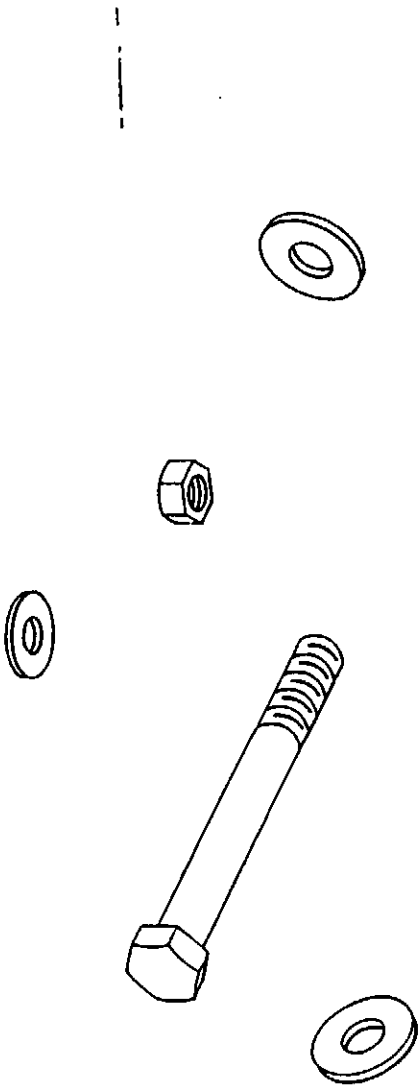
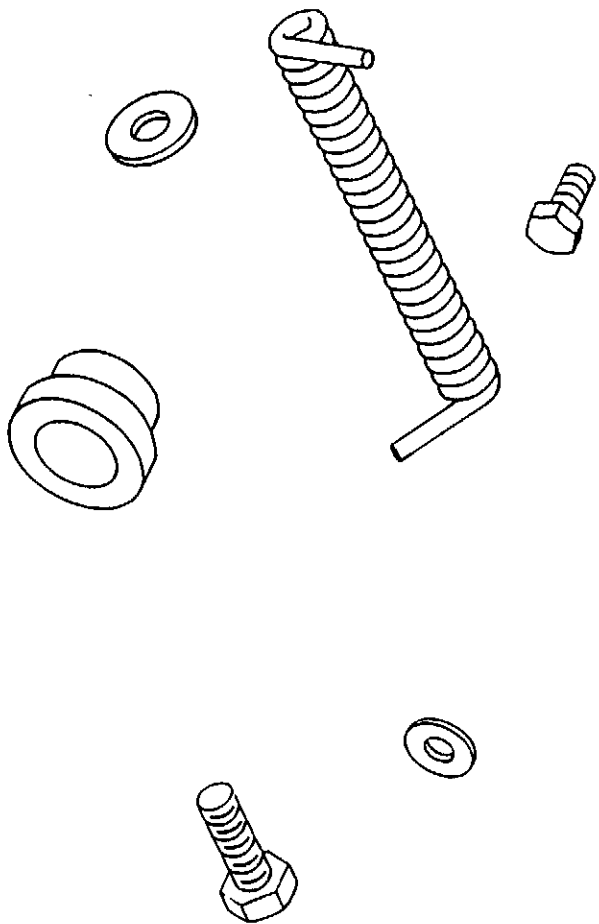
Check vacuum connections for tightness.

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

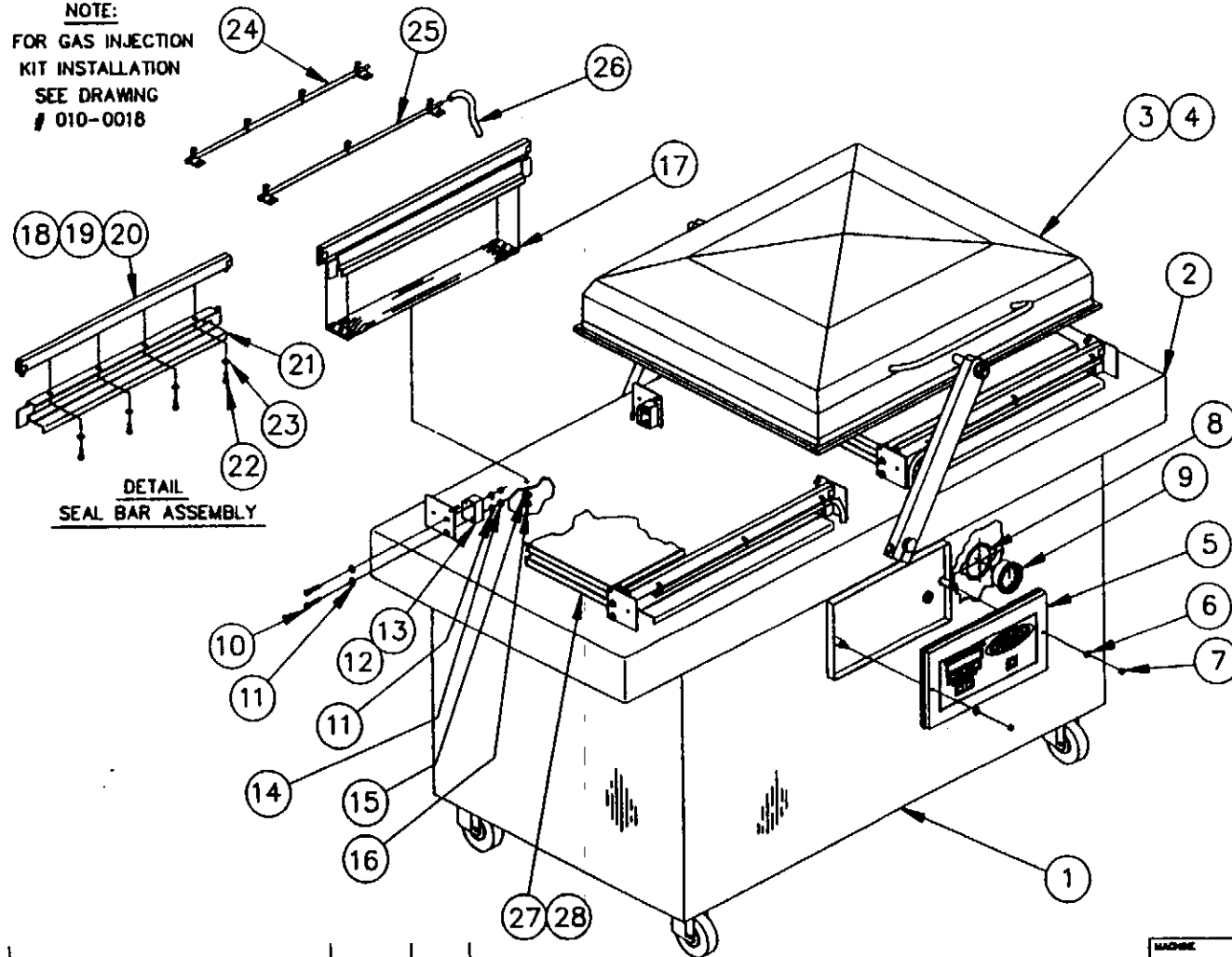
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

MECHANICAL DRAWING



NOTE:
FOR GAS INJECTION
KIT INSTALLATION
SEE DRAWING
010-0018



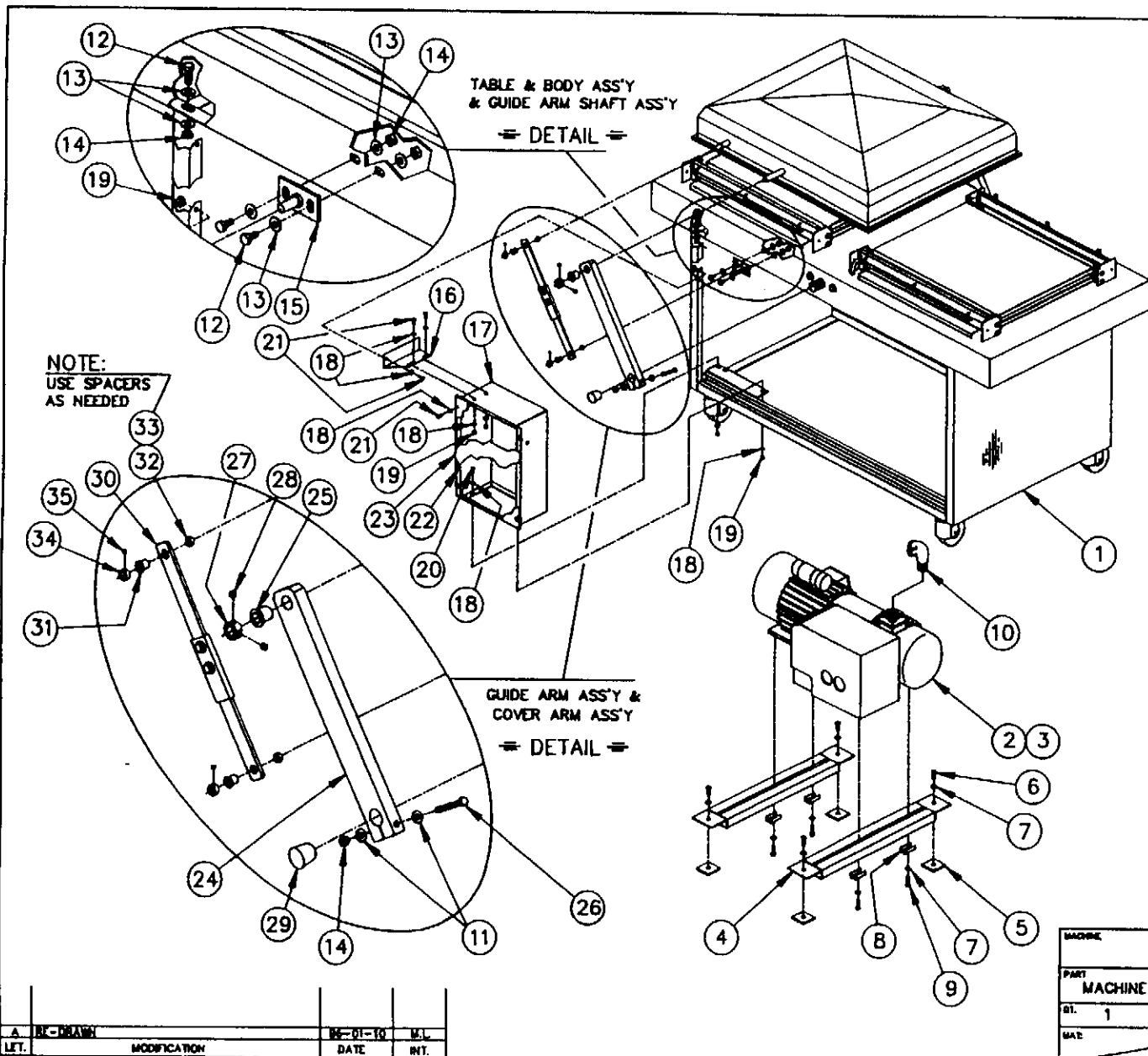
ITEM	PART #	DESCRIPTION	QT.
1	005-0457	BODY ASSEMBLY	1
2	005-0414	TABLE ASSEMBLY	1
3	005-0463	8" COVER ASSEMBLY	1
4	005-0464	12" COVER ASSY.(OPTION)	1
5	005-0319	P.C.BOARD SUPPORT ASS'Y	1
6	051-0740	FLAT WASHER 1/4" S.S.	2
7	051-0591	ACORN NUT 1/4"-20 S.S.	2
8	114-0290	VACUUM GAGE FIXATION RING	1
9	114-0260	VACUUM GAGE	1
10	051-0250	HEX.BOLT 1/4"-20 x 1 1/2" S.S.	16
11	051-0740	FLAT WASHER 1/4" S.S.	32
12	002-0326	LEFT/SEAL BAR GUIDE BLOCK	4
13	002-0327	RIGHT/SEAL BAR GUIDE BLOCK	4
14	051-0581	LOCK-NUT 1/4"-20 S.S./NYLON	16
15	051-0780	FLAT WASHER 3/8" S.S.	4
16	051-0620	HEX.NUT 3/8"-16 S.S.	4
17	005-0320	BELLOWS ASSEMBLY	4
18	005-0418	SEAL BAR ASSEMBLY	4
19	005-0419	BAG CUT SEAL BAR ASS'Y(OPT.)	4
20	005-0420	TOP & BOTTOM BAR ASS'Y(OPT.)	4
21	005-0376	SEAL BAR SUPPORT ASSEMBLY	4
22	051-0740	WASHER 1/4" FLAT S/S	12
23	051-0180	BOLT 1/4"-20 x 1/2" S/S	12
24	009-0046	GAS 3 INJECTION BAR (OPTION)	4
25	009-0047	GAS 4 INJECTION BAR (OPTION)	4
26	179-0030	TUBE (OPTION)	4
27	005-0422	FILLER PLATE ASSEMBLY	2
28	005-0427	HALF FILLER PLATE ASSEMBLY	4

→ 005-0417

A	RE-DRAWN	85-12-28	M.L.
LET.	MODIFICATION	DATE	INT.

MACHINE 620A		METRIC TOLERANCE H & J K & M N & P R & S T & V W & X Y & Z	INCH TOLERANCE A & B C & D E & F G & H I & J K & L M & N O & P	SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PART MACHINE ASSEMBLY FRONT VIEW		SCALE NOT TO SCALE		
QTY. 1	SCALE	DATE 85-12-28		NO. 005-0415
MAT.	APP.	DATE		

005-0415



ITEM	PART #	DESCRIPTION	QT.
1	005-0415	MACHINE ASSEMBLY FRONT VIEW	1
2	125-	PUMP 160 M ³	1
3	125-	PUMP 250 M ³ (OPTION)	1
4	005-0104	PUMP SUPPORT ASSEMBLY	2
5	005-0088	PUMP SUPPORT PLATE ASSEMBLY	4
6	051-0350	HEX. BOLT 3/8"-16 x 3/4" S.S.	4
7	051-0780	FLAT WASHER 3/8" S.S.	8
8	001-0199	SUPPORT	4
9	052-4240	HEX. BOLT M10 x 30 ZINC	4
10	005-0388	BELLOWS CONNECTOR ELBOW ASS'Y	1
11	051-0783	FLAT WASHER (THICK) 3/8" S.S.	4
12	051-0350	HEX. BOLT 3/8"-16 x 3/4" S.S.	8
13	051-0780	FLAT WASHER 3/8" S.S.	16
14	051-0620	HEX. NUT 3/8"-16 S.S.	10
15	005-0317	GUIDE ARM SHAFT ASSEMBLY	1
16	001-1364	LEFT/ELECTRICAL BOX UPPER SUPPORT	1
17	005-0374	ELECTRICAL BOX ASSEMBLY	1
18	051-0740	FLAT WASHER 1/4" S.S.	13
19	051-0580	HEX. NUT 1/4"-20 S.S.	5
20	051-0190	HEX. BOLT 1/4"-20 x 3/4" S.S.	2
21	051-0180	HEX. BOLT 1/4"-20 x 1/2" S.S.	7
22	179-0004	SELF ADHESIVE SPONGE NEOPRENE	1
23	001-1415	ELECTRICAL BOX COVER	1
24	002-0316	COVER ARM	2
25	075-0620	BUSHING	2
26	051-0420	HEX. BOLT 3/8"-16 x 3" S.S.	2
27	002-0390	SET SCREW COLLAR	2
28	051-0178	SET SCREW 1/4"-20 x 5/16" S.S.	4
29	057-0013	CENTRAL SHAFT END CAP	2
30	005-0321	GUIDE ARM ASSEMBLY	1
31	075-0440	BUSHING	2
32	058-0050	SPACERS	2
33	058-0060	SPACERS	2
34		SET SCREW COLLAR	2
35	051-0178	SET SCREW 1/4"-20 x 5/16" S.S.	2

MACHINE		620A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC
PART		MACHINE ASSEMBLY REAR VIEW		± .005	± .005	
DL		1	SCALE	NOT TO SCALE		ST-GERMAIN DE GRANTHAM QUEBEC CANADA
MATERIAL		M.LAWRENCE	DATE	06-01-10	005-0416	

A	RE-DRAWING	06-01-10	M.L.
LET.	MODIFICATION	DATE	INT.

MODEL 620A

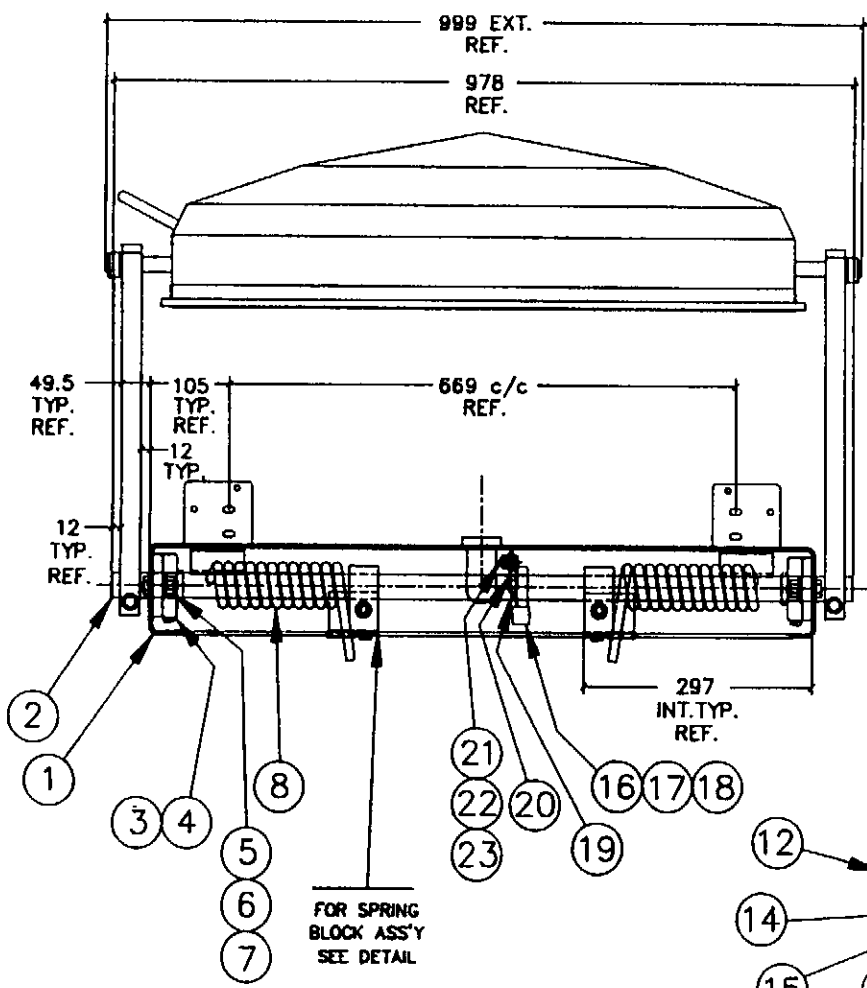
COVER ADJUSTMENT PROCEDURE

Reference Drawing: # 005-0416
004-0223

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

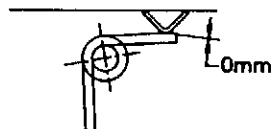
1. Floor should be flat (within 1/8" approx.).
- 2.1 Mark position of original adjustment of guide arm length and its lower shaft position (See drawing # 005-0416; items:#30 & #15).
- 2.2 Loosen the two bolts on the guide arm (See drawing # 005-0416; items #30).
- 2.3 Now move the cover each side and 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 # 005-0416; items #26 , #14 & #11).
- 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 # 004-0223; item #12) until cover is sealing properly each side (less than 1/16").
- 3.0 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.

20

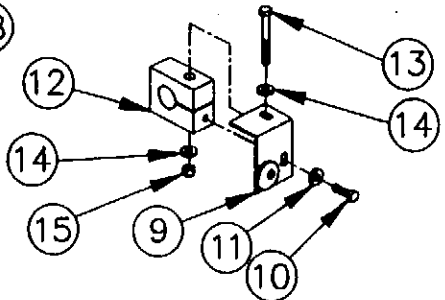
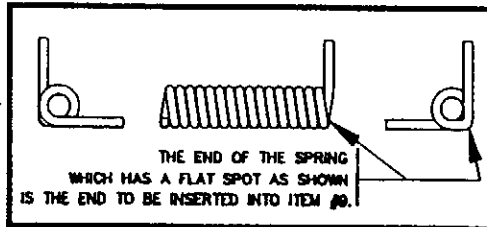


SPRING ADJUSTMENT PRODEURE

- 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 0mm (0°) AS SHOWN BELOW.

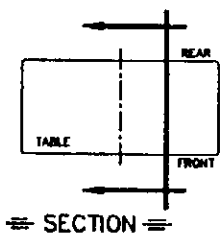


- E- RETIGHTEN BOLTS ON SPRING SUPPORT PLATE ASSY. (ITEMS #10,#13 & #15).



SPRING BLOCK ASS'Y
≡ DETAIL ≡

ITEM	PART #	DESCRIPTION	QT.
1	005-0414	TABLE ASSEMBLY	1
2	002-0399	CENTRAL SHAFT	1
3	075-1650	2 BOLTS FLANGED BEARING	2
4	081-0100	GREASE FITTING 90° 1/4"-28 S.S.	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	051-0790	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	002-0319	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

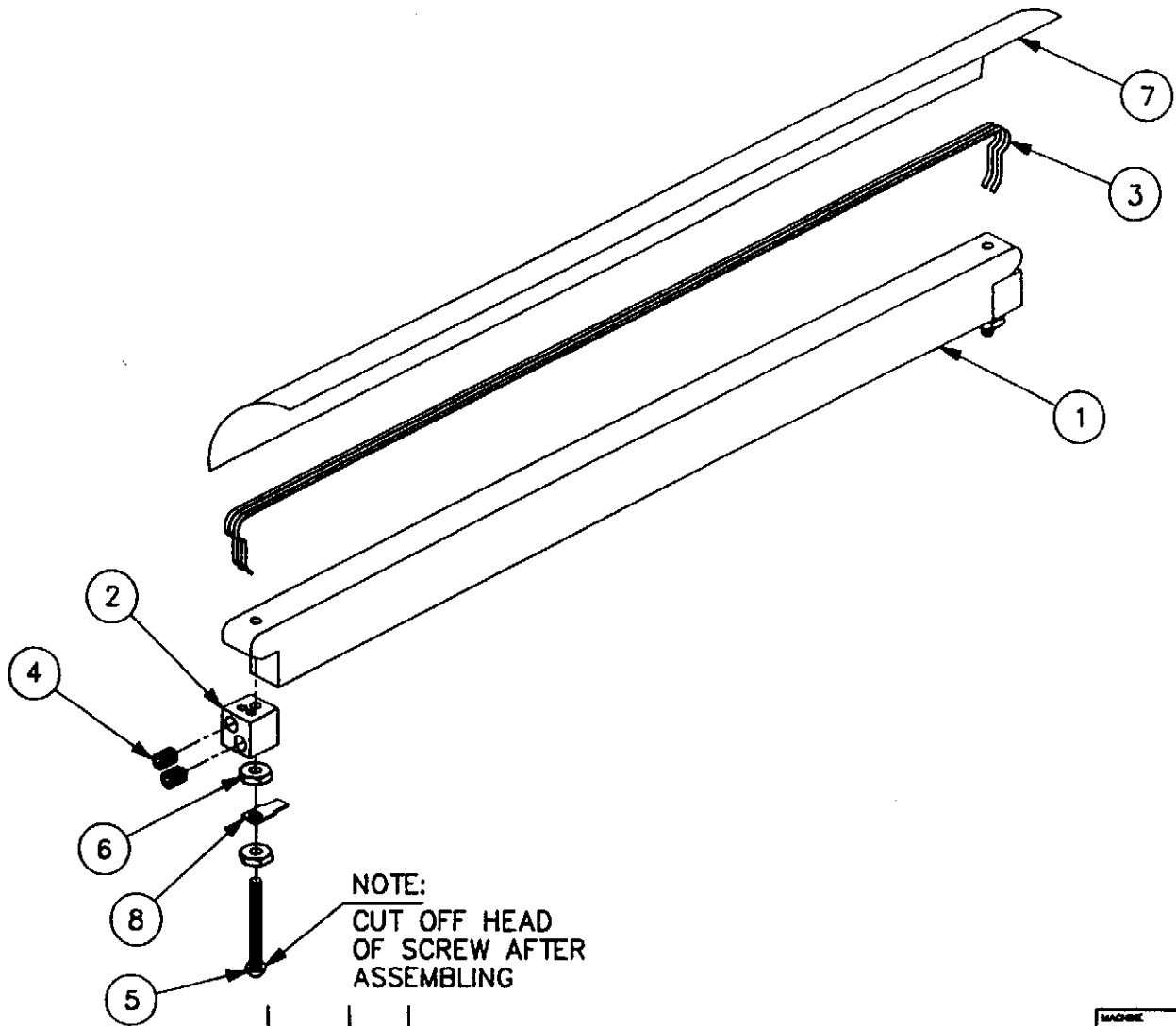


≡ SECTION ≡

A	RE-DRAWN	85-12-29	M.L.
LET.	MODIFICATION	DATE	INT.

MACHINE	620A	METRIC TOLERANCES 0.4 3 .00 4 .000 0.00 5 .000 ANGLE 0.1°	IMP. TOLERANCES 0.005 0.0025 0.0015 ANGLE 0.1°	SIPROMAC 51-GERRAIN DE GRANTHAM, QUEBEC CANADA	
PART	CENTRAL SHAFT ASSEMBLY	NOT TO SCALE			
QTY	1	SCALE		DATE	85-12-29
DATE		APP.		DATE	
				004-0223	

1004-0223



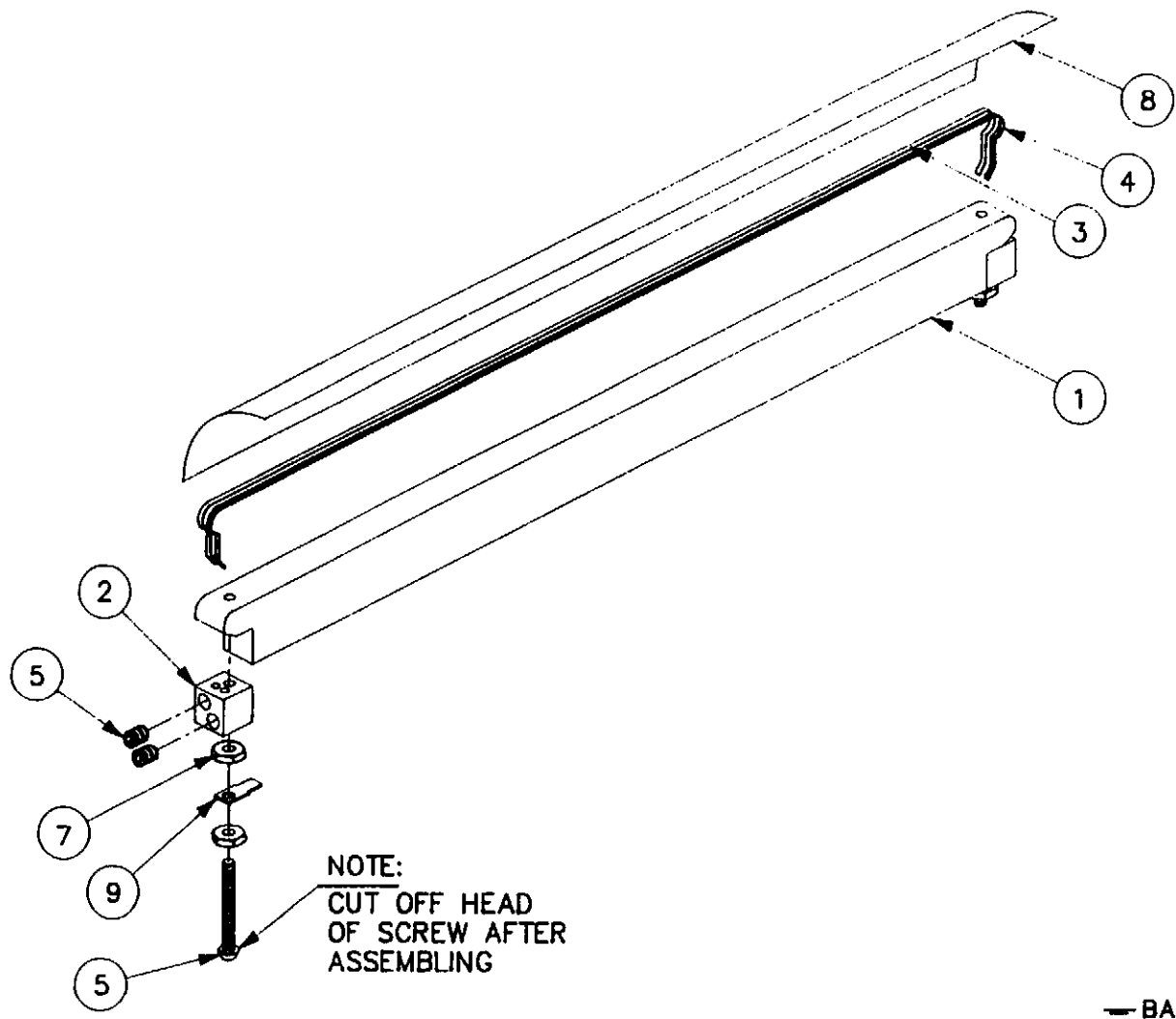
ITEM	PART #	DESCRIPTION	QTY
1	002-0400	SEAL BAR (TABLE)	4
2	002-0031	CONNECTOR	8
3	039-0200	SEALING ELEMENT	8
4	052-0385	SET SCREW 1/4" - 20 x 5/16" (OVAL POINT)	16
5	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	8
6	051-0550	NUT #8-32 S/S	16
7	176-0200	TEFLON TAPE (5S) ADHESIVE	4
8	027-0400	CONNECTOR ADAPTOR	8

NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

LET.	MODIFICATION	DATE	INT.
8	RE-DRAWN	80-12-29	M.L.

MACHINE		620A		METRIC TOLERANCE		ENGLISH TOLERANCE		SIPROMAC	
PART		SEAL BAR PRE-ASSEMBLY		± .001		± .001		ST-GERMAIN DE GRANTHAM	
QTY.		4		± .002		± .002		QUEBEC CANADA	
SCALE		NOT TO SCALE		± .005		± .005		005-0418	
DATE		80-12-29		± .010		± .010			
APP.				± .020		± .020			

66



ITEM	PART #	DESCRIPTION	QT.
1	002-0400	SEAL BAR (TABLE)	4
2	002-0031	CONNECTOR	8
3	039-0230	CONVEX SEALING ELEMENT	4
4	039-0270	"T" PROFILE CUTTING ELEMENT	4
5	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	16
6	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	8
7	051-0550	NUT #8-32 5/5	16
8	176-0200	TEFLON TAPE (5S) ADHESIVE	4
9	027-0400	CONNECTOR ADAPTOR	8

NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

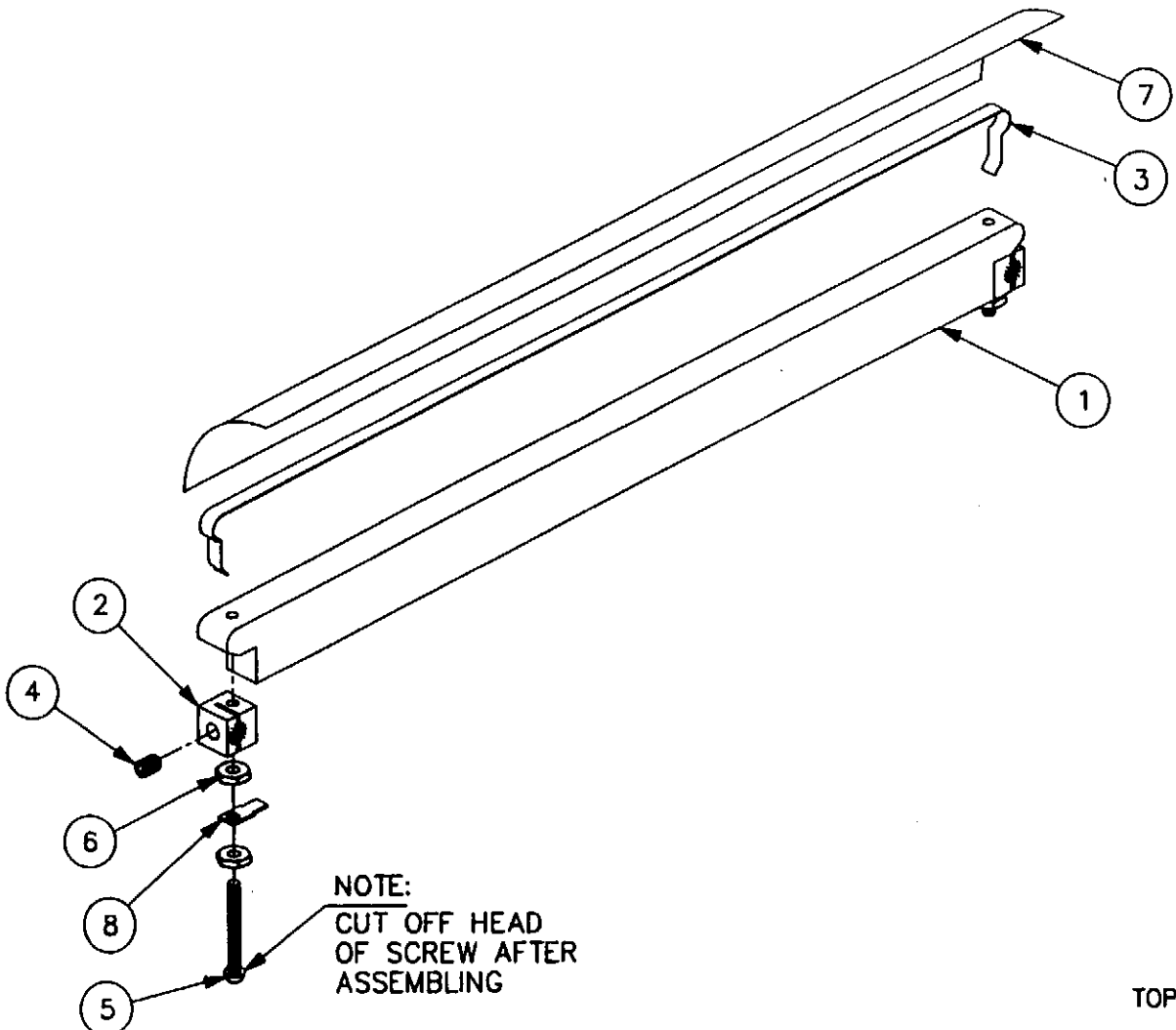
— BAG CUT OPTION —

C	REDRAWN	96-12-31	A.P.
LET.	MODIFICATION	DATE	INT

MACHINE 620A		METRIC TOLERANCE FRACTIONS ± .005 ± .0005 ANGLE ± 1°	INCH TOLERANCE FRACTIONS ± .015 ± .005 N.T.S.	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART SEAL BAR PRE-ASSEMBLY		SIPROMAC		
ITEM:	QTY:	SCALE:	QT. 4	
MAT:	BY: A.P.	DATE: 96-12-31	NO. 005-0419	

005-0419

23



ITEM	PART #	DESCRIPTION	QTY
1	002-0400	SEAL BAR (TABLE)	4
2	009-0029	CONNECTOR	8
3	039-0220	SEALING ELEMENT	4
4	052-0385	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	8
5	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	8
6	051-0550	NUT #8-32 S/S	16
7	176-0200	TEFLON TAPE (55) ADHESIVE	4
8	027-0400	CONNECTOR ADAPTOR	8

NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

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

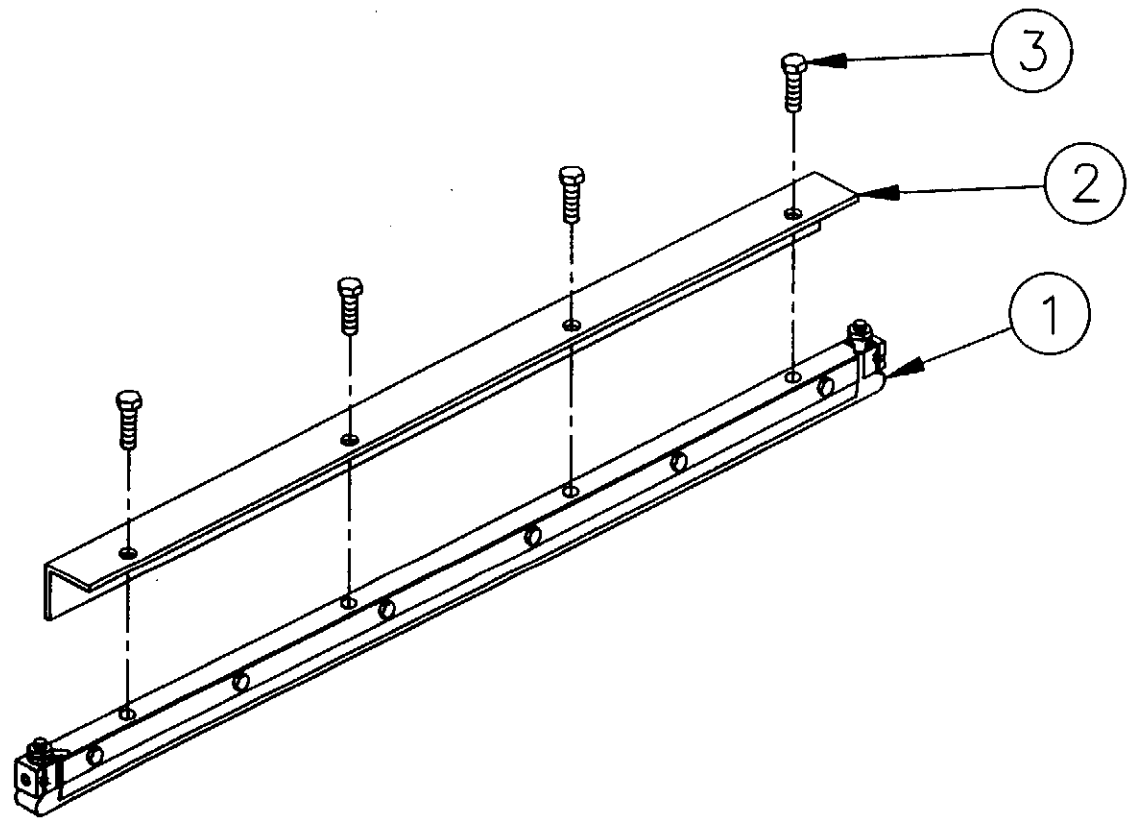
REV	RE-DRAWN	95-12-29	M.L.
LET.	MODIFICATION	DATE	INT.

MAGRE 620A		METRIC TOLERANCE 0.4 ± 0.3 0.8 ± 0.6 1.6 ± 1.2 3.2 ± 2.5 6.3 ± 5.0 12.5 ± 10.0 25.0 ± 20.0 50.0 ± 40.0 100 ± 80.0 200 ± 160.0 400 ± 320.0 800 ± 640.0	NON-METRIC TOLERANCE 0.005 ± 0.004 0.010 ± 0.008 0.020 ± 0.015 0.040 ± 0.030 0.080 ± 0.060 0.150 ± 0.120 0.300 ± 0.240 0.600 ± 0.480 1.200 ± 0.960 2.400 ± 1.920 4.800 ± 3.840 9.600 ± 7.680	SIPROMAC ST-GERMAIN DE GRANBY QUEBEC CANADA
PART	SEAL BAR PRE-ASSEMBLY			
QTY	4	SCALE	NOT TO SCALE	
MAT.	STAINLESS STEEL	DATE	95-12-29	
		DATE		
			005-0420	

1005-0420

24

ITEM	PART #	DESCRIPTION	QTY.
1	004-0259	UPPER SEAL BAR ASSY.(T.& B.OPT.)	2
2	001-1595	UPPER SEAL BAR SUPPORT	2
3	051-0180	HEX. BOLT 1/4"-20 x 1/2" S.S.	8



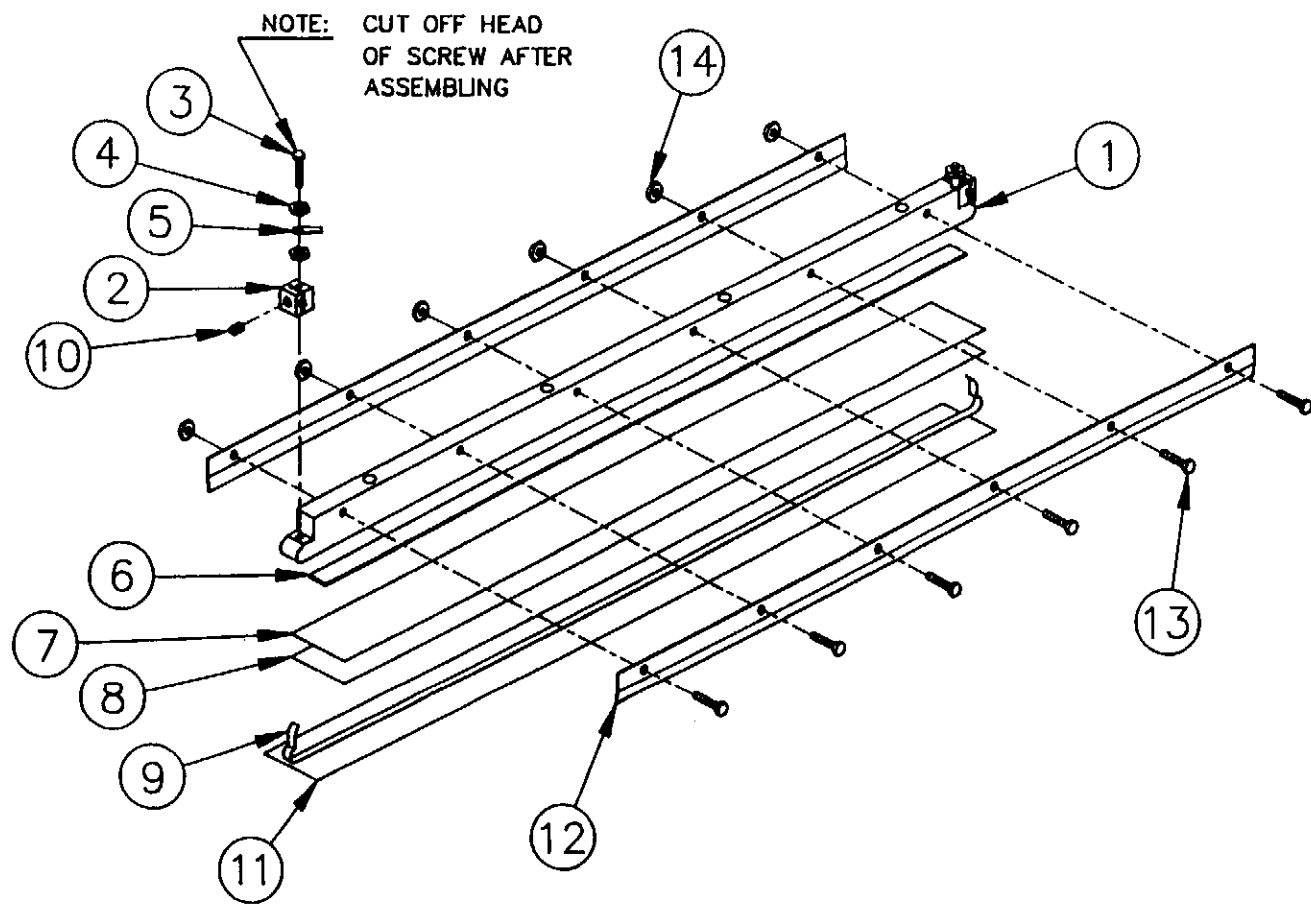
≡ OPTION ≡
 TOP & BOTTOM SEALING OR
 BI-ACTIVE SEALING

LET.	RE-DRAWN	DATE	INT.
		05-12-29	M.L.

MACHINE	620A	METRIC TOLERANCE	NON TOLERANCE	SIPROMAC
PART	UPPER SEAL BAR ASSY.	0.05 0.10 0.20 0.30 0.50 0.75 1.00 1.50 2.00 3.00 4.00 5.00 7.00 10.00	0.0015 0.0030 0.0045 0.0075 0.0100 0.0150 0.0200 0.0300 0.0400 0.0600 0.0800 0.1200 0.1600 0.2500 0.3500	
QTY.	2	SCALE	NOT TO SCALE	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
DATE		DATE	05-12-29	NO.
				005-0421

005-0421

ITEM	PART #	DESCRIPTION	QT.
1	002-0401	UPPER SEAL BAR	2
2	009-0029	UPPER CONNECTOR	4
3	052-0250	SCREW #8-32 x 1 1/2" RND SLOT	4
4	051-0550	HEX. NUT #8-32 S.S.	8
5	027-0400	CONNECTOR ADAPTOR	4
6	179-0003	UPPER SEAL BAR RUBBER	2
7	176-0200	TEFLON TAPE (5S) ADHESIVE	2
8	176-0220	TEFLON TAPE (10S) ADHESIVE	2
9	039-0220	SEALING ELEMENT	2
10	052-0395	SET SCREW 1/4"-20 x 5/16"(OVAL POINT)	4
11	176-0220	TEFLON TAPE (10S) ADHESIVE	2
12	001-1594	UPPER TEFLON HOLDER	4
13	051-0147	HEX. BOLT #10-24 x 1" S.S.	12
14	051-0571	HEX. NUT # 10-24 S.S.	12



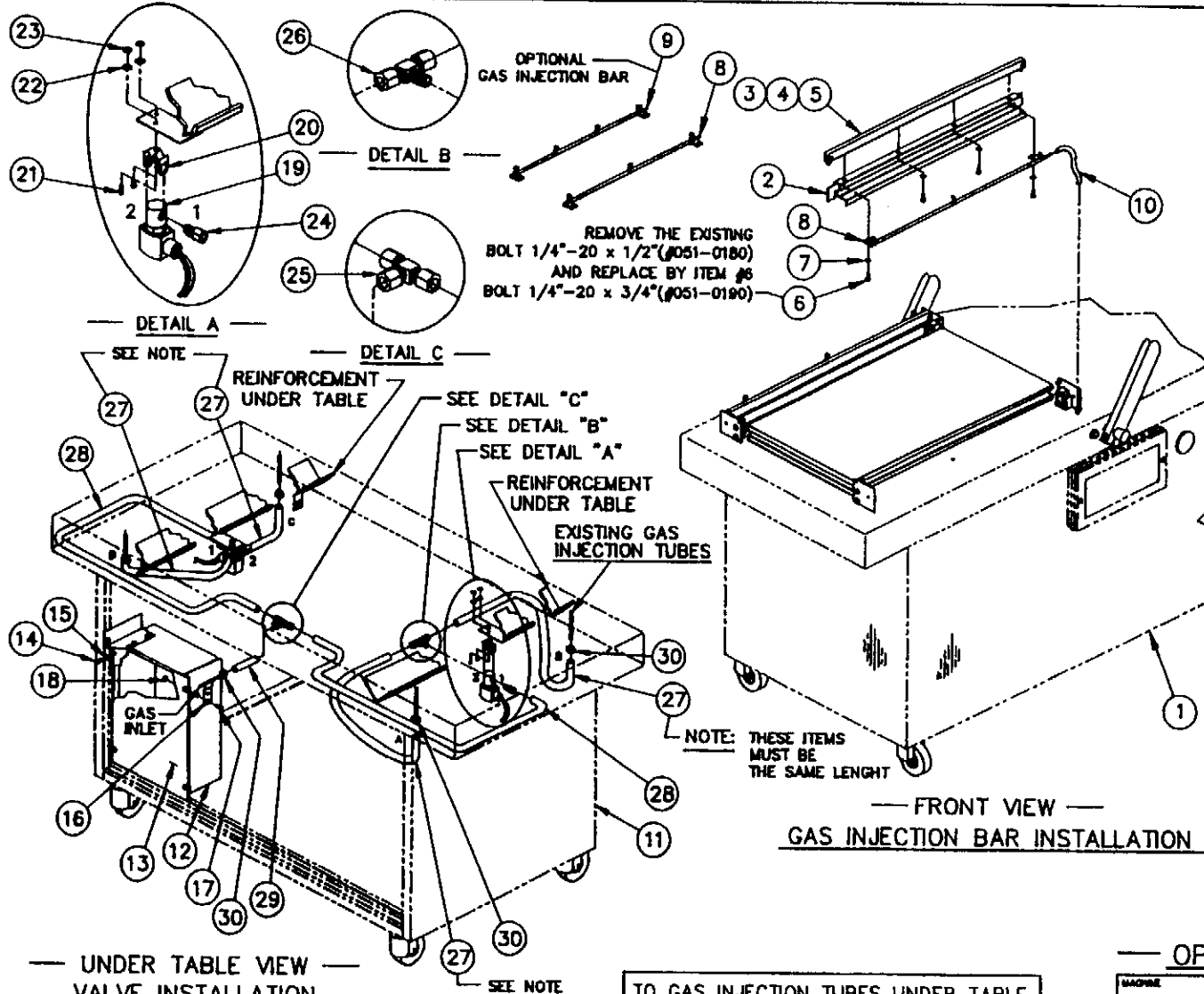
OPTION
 TOP & BOTTOM SEALING OR
 BI-ACTIVE SEALING

MAGNR 620A		METRIC TOLERANCE 0.005 0.0025 0.0015 0.0010 0.0005	SIEM TOLERANCE 0.015 0.010 0.0075 0.0050 0.0025	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART UPPER SEAL BAR PRE-ASSY.		NOT TO SCALE		
QTY 2	SCALE	DATE 88-12-28		004-0259
LET.	MODIFICATION	DATE	INT.	

8	REC-DRAWN	88-12-28	M.L.
LET.	MODIFICATION	DATE	INT.

25

1004-0259



ITEM	PART #	DESCRIPTION	QTY.
1	005-0415	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0378	SEAL BAR SUPPORT ASSEMBLY	4
3		SEAL BAR PRE-ASSEMBLY	4
4		BAG CUT SEAL BAR PRE-ASSY(OPT.)	4
5		TOP/BOTTOM S.BAR PRE-ASSY(OPT.)	4
6	051-0190	HEX. BOLT 1/4"-20 x 3/4" S.S.	16
7	051-0740	FLAT WASHER 1/4" S.S.	16
8	005-0423	GAS 3 INJECTION BAR (OPTION)	4
9	005-0424	GAS 4 INJECTION BAR (OPTION)	4
10	178-0030	GAS INJECTION TUBE (OPTION)	4
11	005-0416	MACHINE ASSEMBLY REAR VIEW	1
12	005-0374	ELECTRICAL BOX ASSEMBLY	1
13	001-1415	ELECTRICAL BOX COVER	1
14	051-0180	HEX. BOLT 1/4"-20 x 1/2" S.S.	4
15	051-0740	FLAT WASHER 1/4" S.S.	4
16	005-0323	GAS INLET ASSEMBLY	1
17	051-0180	HEX.BOLT 1/4"-20 x 1/2" S.S.(OPT.)	1
18	051-0580	HEX.NUT 1/4"-20 S.S. (OPTION)	1
19	106-0010	SOLENOID VALVE 2 WAY 1/4" NPT	2
20	106-0345	VALVE SUPPORT FOR 1/4" NPT	2
21	051-0100	SCREW #8-32 x 3/8" PAN PHIL S/S	4
22	051-0720	FLAT WASHER #8 S.S.	4
23	051-0550	HEX NUT #8-32 S.S.	4
24	101-0036	STRAIGHT 1/4"MNPT x 3/8" T.P.COMP.	2
25	101-0062	T 3/8" T.P.COMP.	1
26	101-0065	T 3/8" T.P.COMP.x1/4" MNPTx3/8" T.P.COMP.	2
27	104-0080	TUBE 3/8"ODx1/4"D(POLY.) x mm LG.	4
28	104-0080	TUBE 3/8"ODx1/4"D(POLY.) x mm LG.	2
29	104-0060	TUBE 3/8"ODx1/4"D(POLY.) x mm LG.	1
30	105-0200	COLLARS 3/8"	5

FRONT VIEW
GAS INJECTION BAR INSTALLATION

UNDER TABLE VIEW
VALVE INSTALLATION

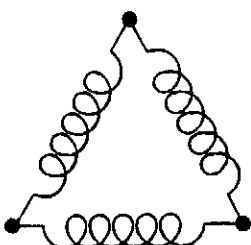
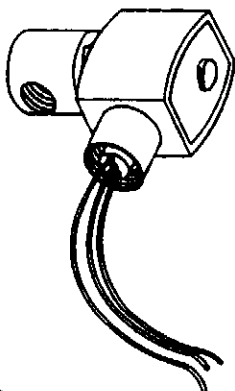
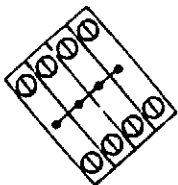
TO GAS INJECTION TUBES UNDER TABLE,
REMOVE THE FOUR EXISTING CAPS
& CONNECT HOSES A,B,C & D

OPTION GAS INJECTION

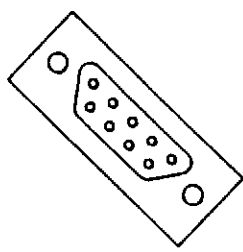
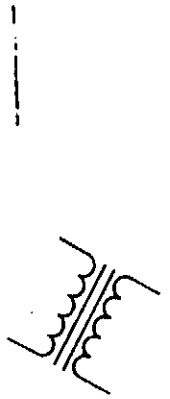
MACHINE	620A	NETW. TOLERANCE ± .005 ± .010 ± .015 ± .020 ± .030 ± .040 ± .050 ± .060 ± .070 ± .080 ± .090 ± .100	NETI. TOLERANCE ± .005 ± .010 ± .015 ± .020 ± .030 ± .040 ± .050 ± .060 ± .070 ± .080 ± .090 ± .100	SIPROMAC
PART	GAS INJECTION KIT INSTALLATION	N.T.S.		ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM	1	QTY.	SCALE	ET.
DATE		ILLUSTRATION DATE	88-01-10	NO.
		DATE		010-0018

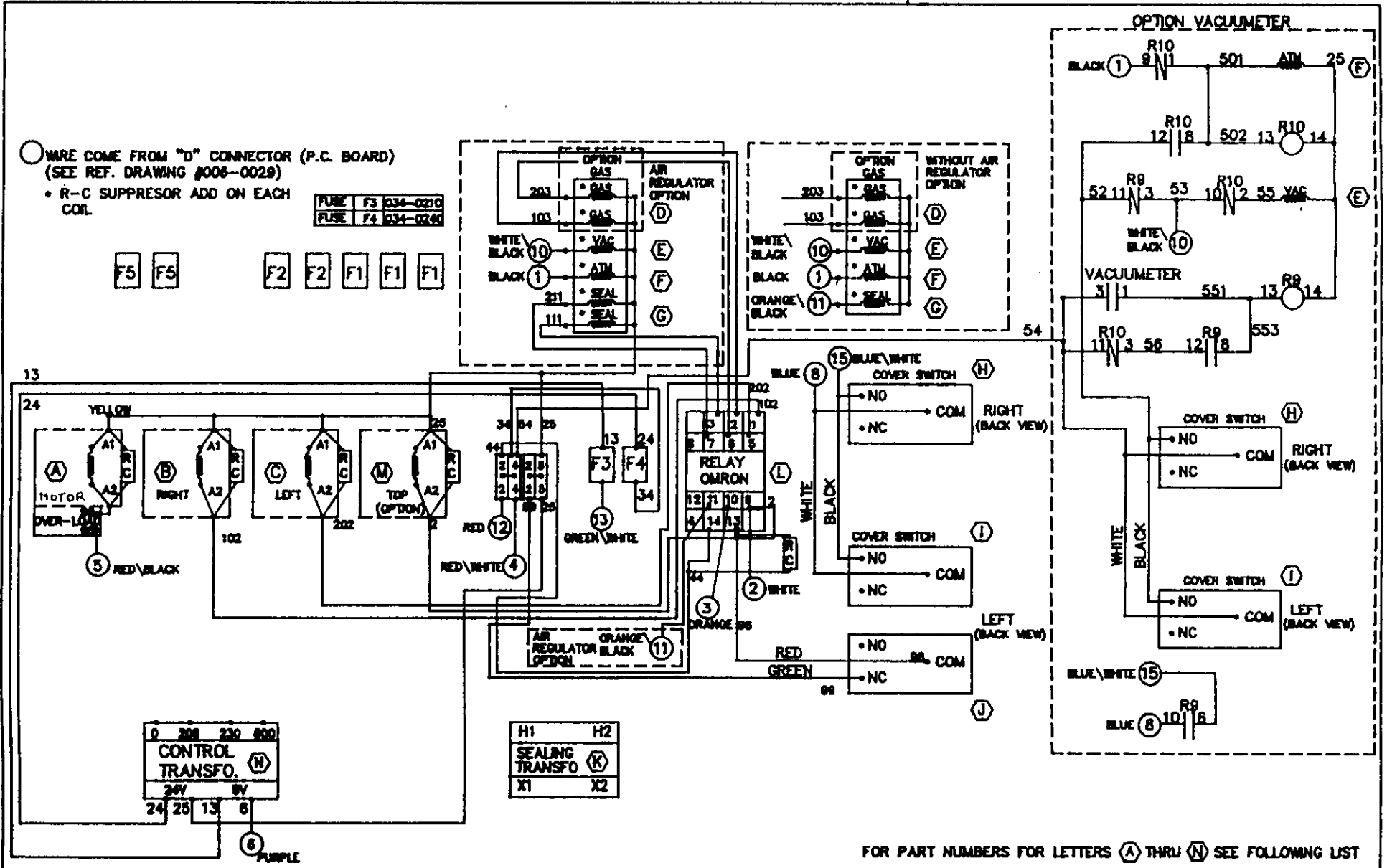
REV.	DESCRIPTION	DATE	BY

1010-0018



ELECTRICAL DRAWING





COLOR CODE SECONDARY (VAC)
24V RED WIRE (#24 & #25)
0V PURPLE WIRE (#6 & #13)

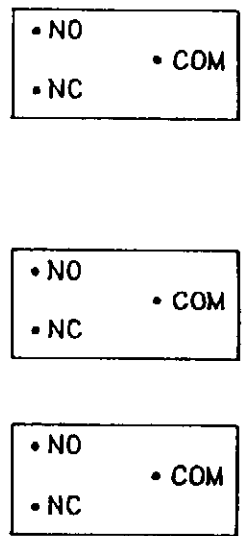
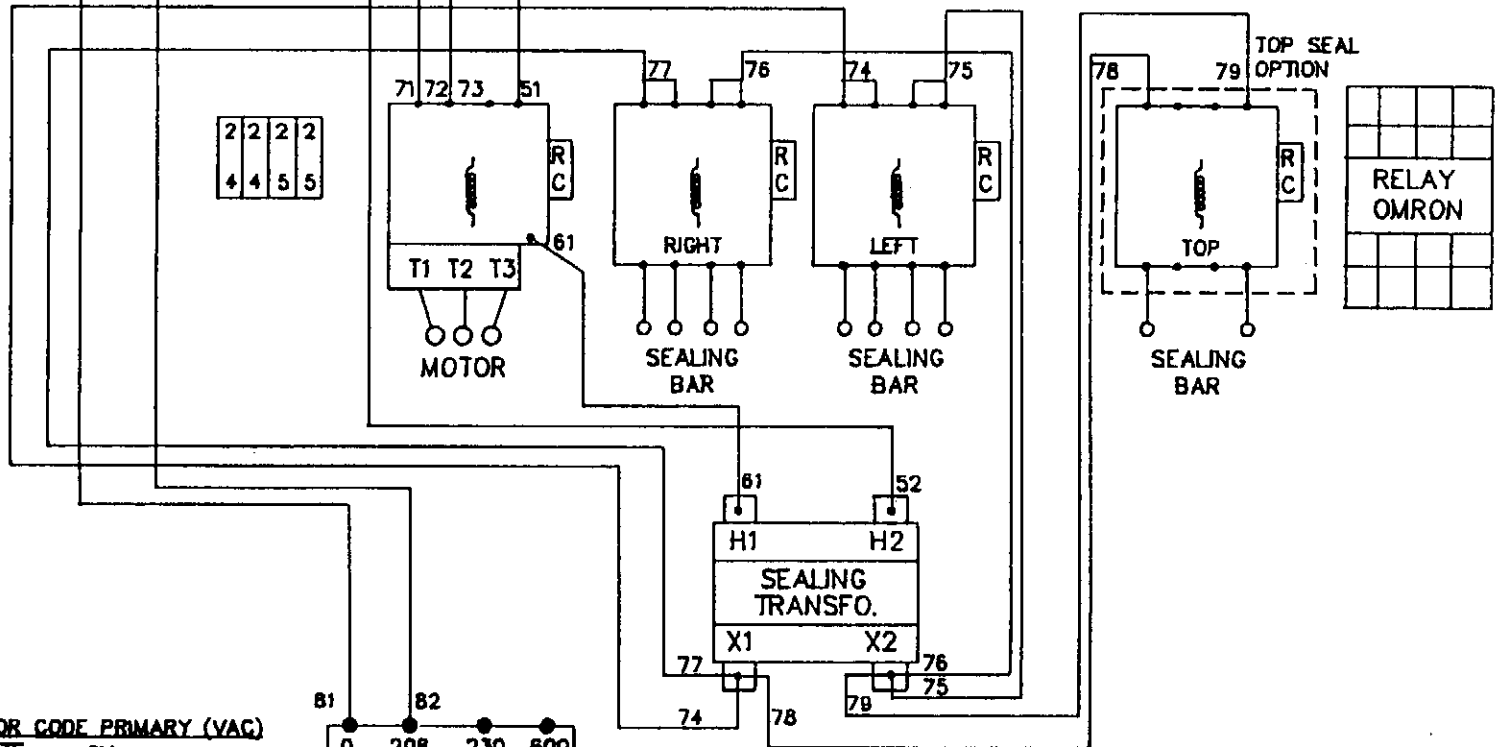
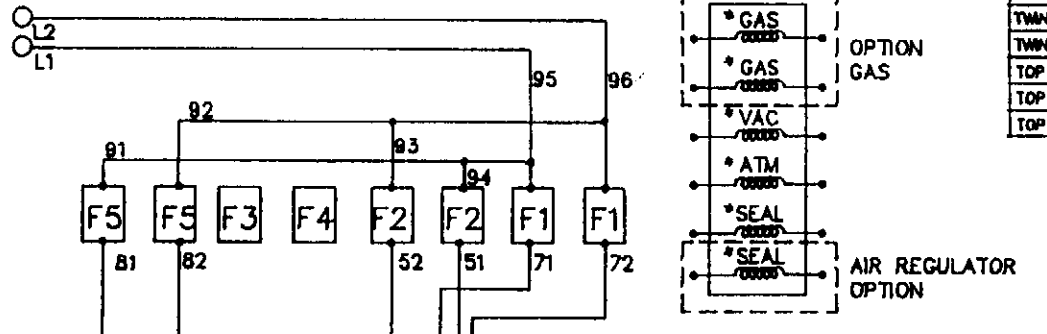
MACHINE	420A, 600A & 620A		
PIECE	ELECT. WIRING LOW-VOLTAGE		
QT.	ECH. SCALE	NE PAS MESURER / N.T.S.	
MAT.	DESS. D.L.	DATE 97-03-10	NO. 006-0067
LET.	MODIFICATION	DATE	INT.

ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

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* RC SUPPRESSOR ADD ON EACH COIL

OPTION	VOLTAGE	FUSE F2	FUSE F5	PUMP		
				MOTOR (HP)	VOLT +ph	FUSE F1
TWIN SEAL & BAG CUT	220	034-0450	034-0200	3	230-1	034-0560
TWIN SEAL & BAG CUT	380	034-0430	034-0410	3	230-3	034-0530
TWIN SEAL & BAG CUT	800	034-0425	034-0410	3	575-3	034-0480
TOP & BOTTOM SEAL	220	034-0500	034-0200	5	230-1	034-0570
TOP & BOTTOM SEAL	380	034-0485	034-0410	5	230-3	034-0550
TOP & BOTTOM SEAL	800	034-0440	034-0410	5	575-3	034-0510

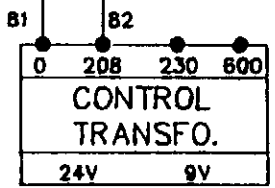


COLOR CODE PRIMARY (VAC)

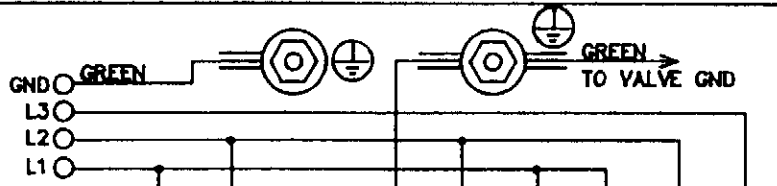
WHITE	0V
BLACK	190V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY (VAC)

RED	24V
PURPLE	9V



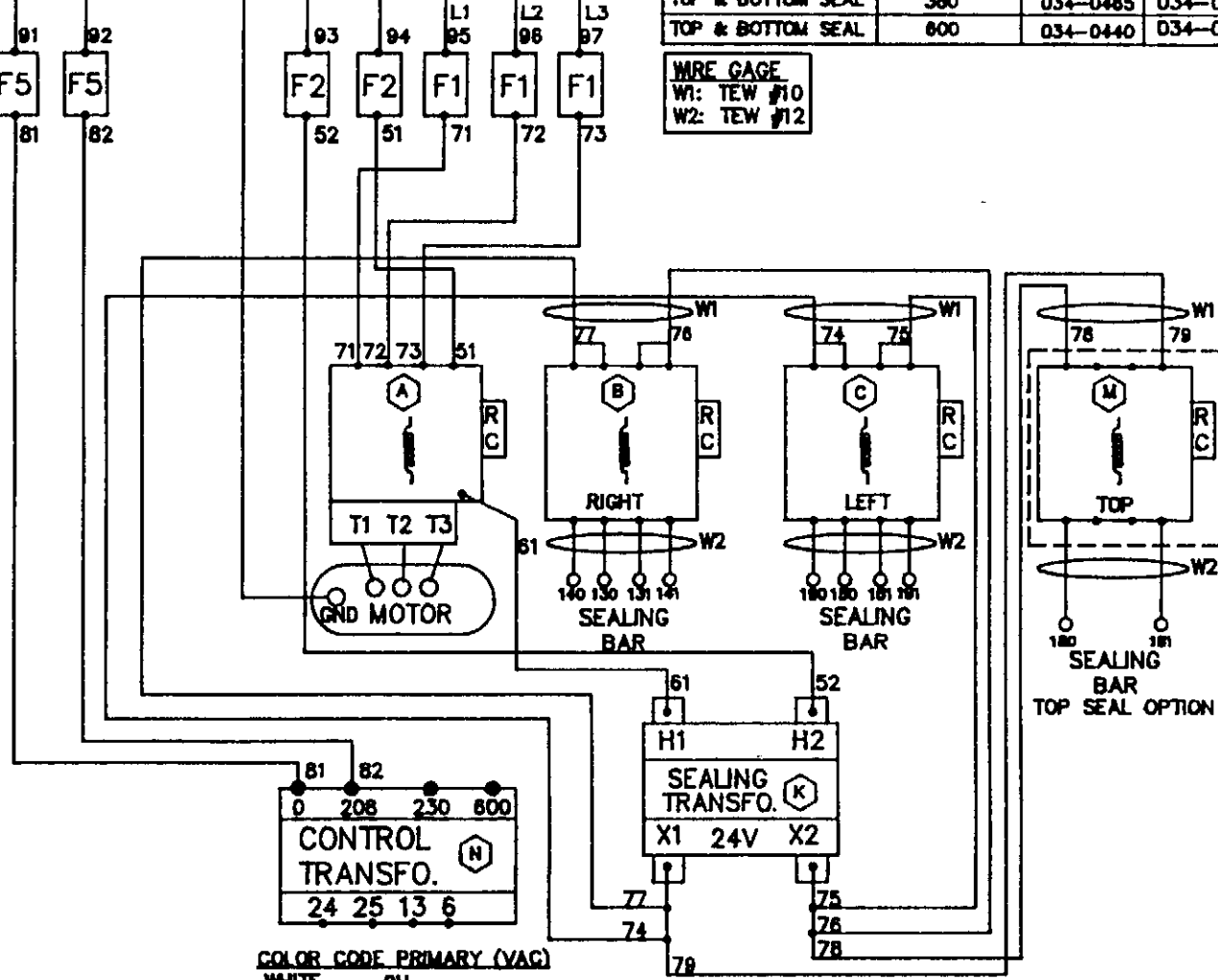
MACHINE		420A, 600A & 620A		SIPROMAC	
PIECE		ELECT. WIRING HIGH VOLTAGE 1		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	
QT.	ECH. SCALE	NE PAS MESURER /N.T.S.		NO. 006-0068	
MA1:	DESS. D. LETOURNEAU	DATE 87-03-10	APP. DATE		



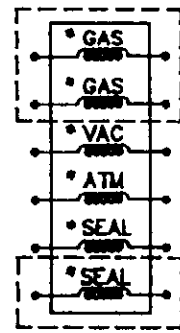
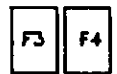
OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0450	034-0200
TWIN SEAL	380	034-0430	034-0410
TWIN SEAL	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0485	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

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

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



2	2	2	2
4	4	5	5



*RC SUPPRESSOR ADD ON EACH COIL

COLOR CODE PRIMARY (VAC)

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

SECONDARY (VAC)

RED	24V
PURPLE	9V

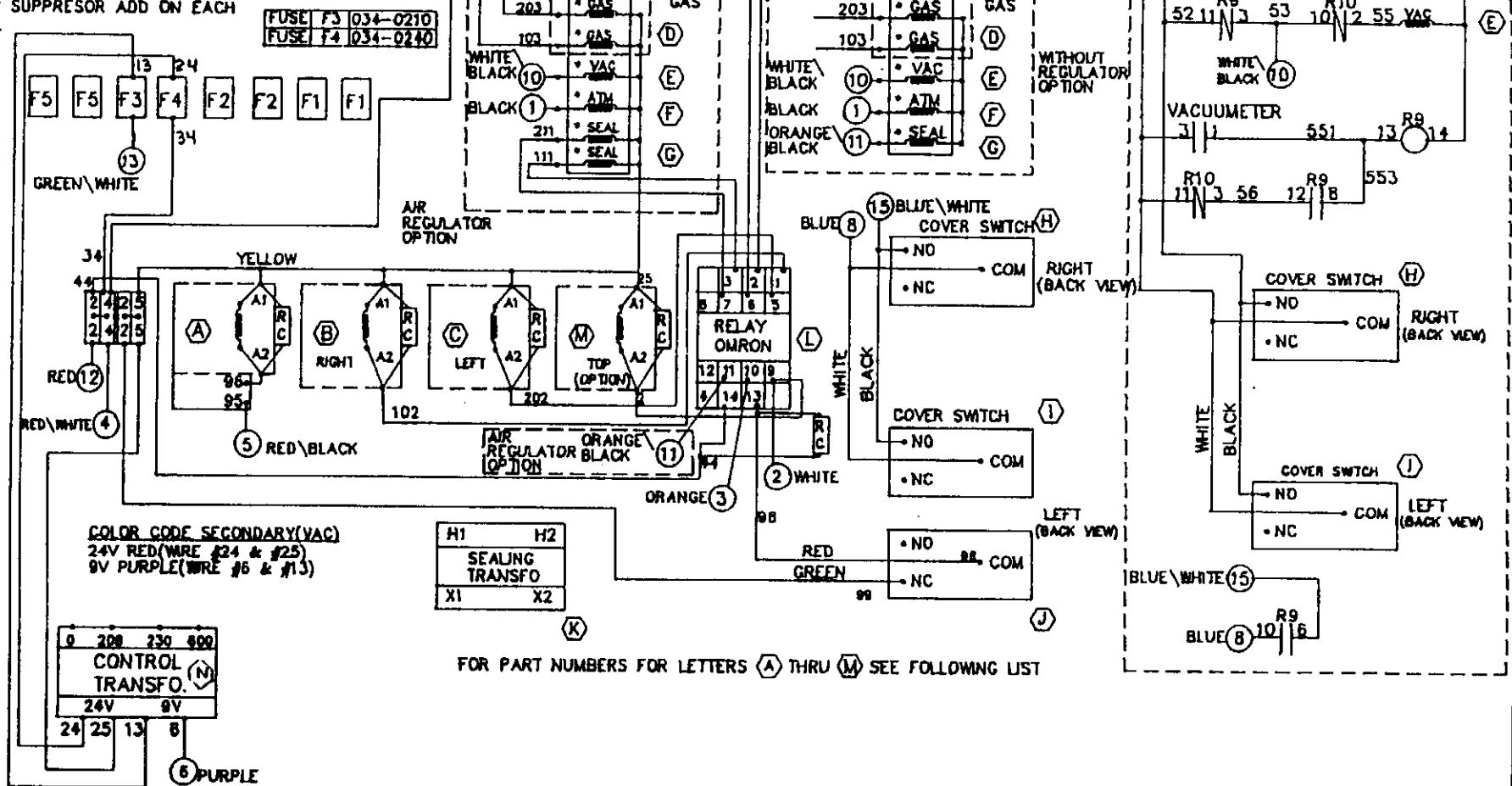
MACHINE	420A, 600A & 620A			
PIECE	ELECT. WIRING HIGH VOLTAGE 3Ø			
QT.	_____	ECH. SCALE	_____	
MAR.	_____	DESS. D. LETOURNEAU	DATE 87-03-10	NO. 006-0069
		APP.	DATE	

SIPROMAC
ST-GERMAN DE GRANTHAM,
QUEBEC CANADA

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○ WIRE COME FROM "D" CONNECTOR (P.C. BOARD)
(SEE REF. DRAWING #006-0029)

• R-C SUPPRESSOR ADD ON EACH
COL



COLOR CODE SECONDARY(VAC)
24V RED(WIRE #24 & #25)
9V PURPLE(WIRE #6 & #13)

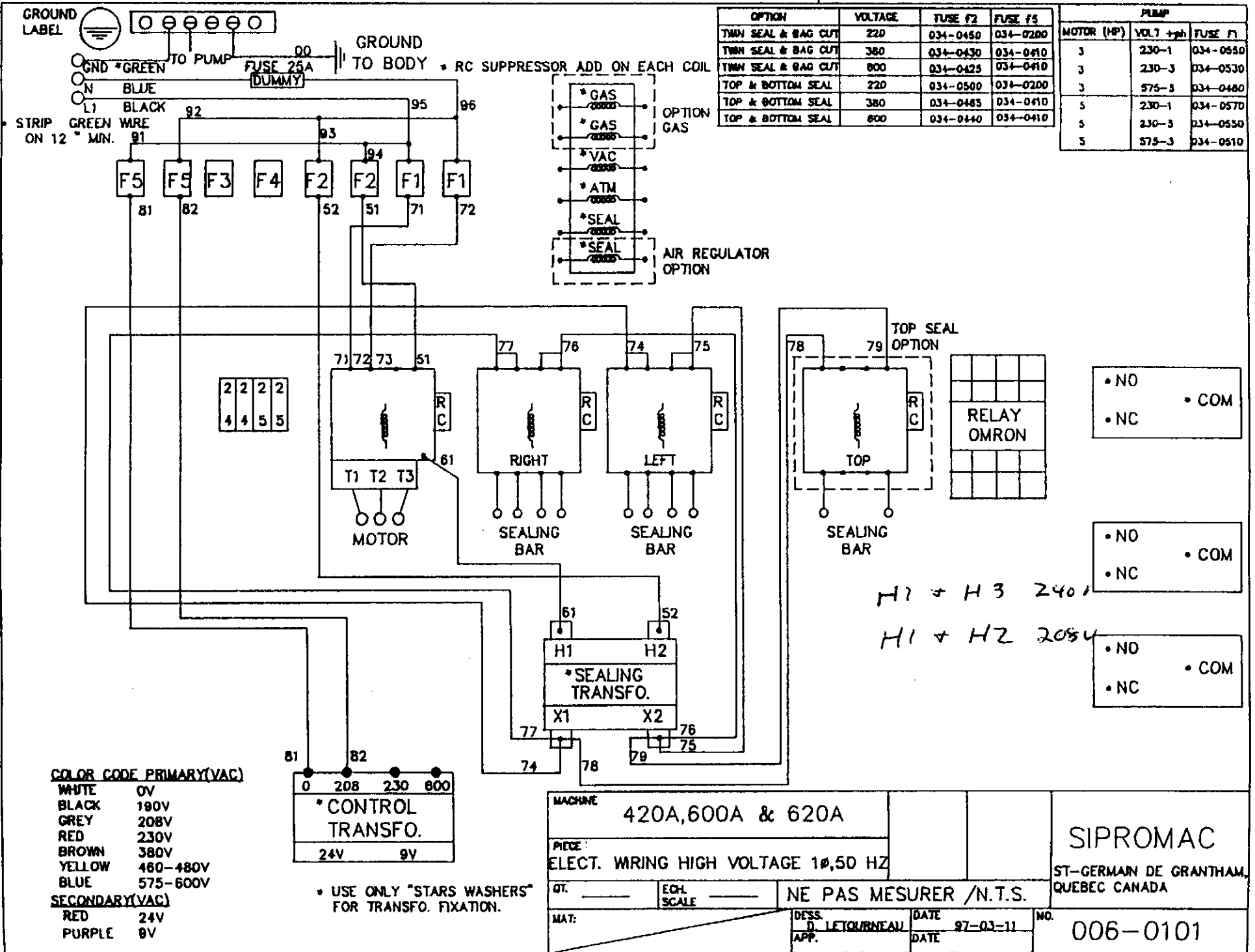
H1	H2
X1	X2

0	200	230	900
CONTROL TRANSFO. (N)			
24V		9V	
24	25	13	8

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

MACHINE		420A,600A & 620A			
PIECE		ELECT. WIRING LOW-VOLTAGE (50 HZ)		SIPROMAC	
QT.		ECH. SCALE		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	
MAT:		NE PAS MESURER /N.T.S.		NO. 006-0100	
DESS. D.L.		DATE 97-03-11		APP. DATE	

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

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

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COLOR CODE PRIMARY(VAC)

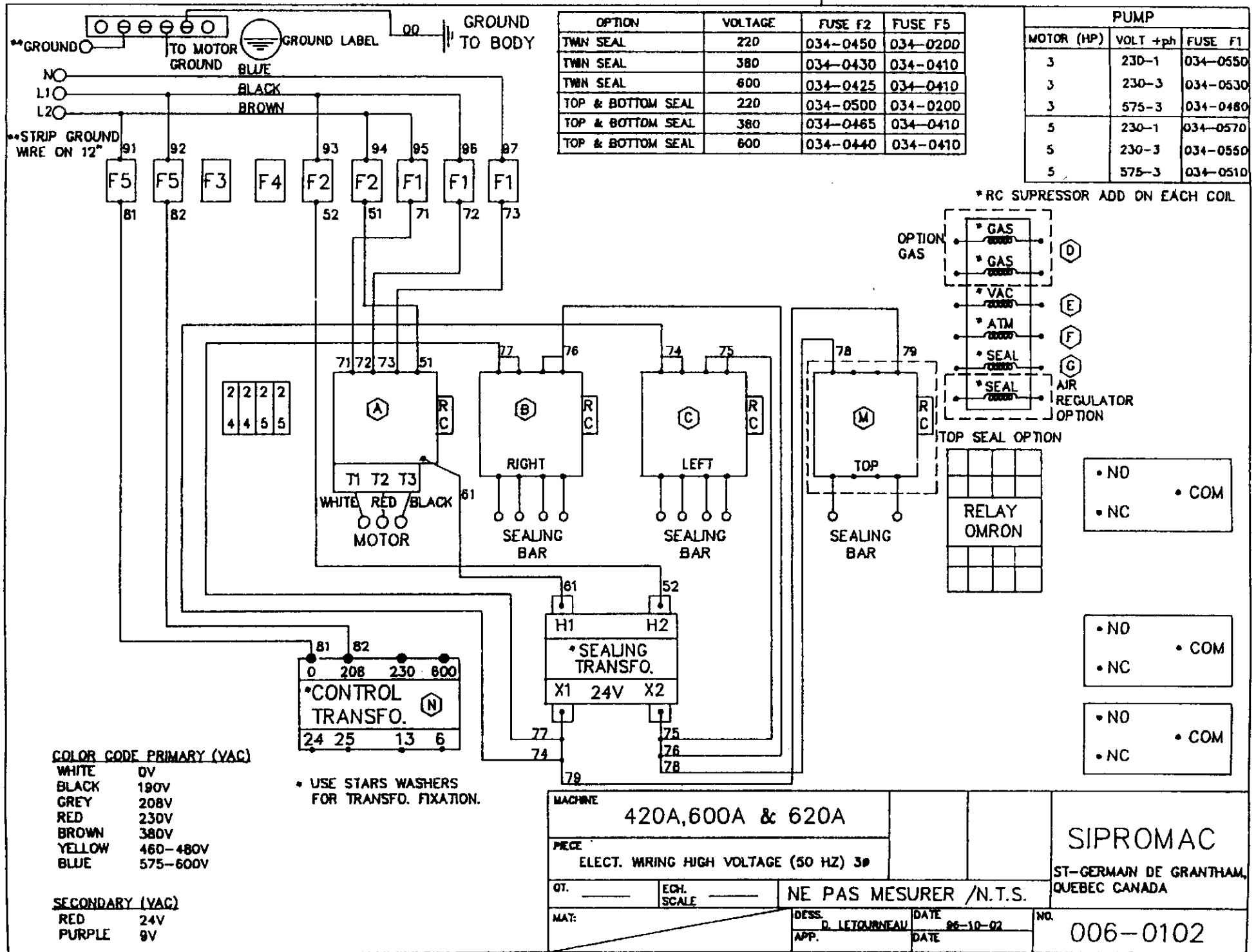
WHITE	0V
BLACK	190V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY(VAC)

RED	24V
PURPLE	9V

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

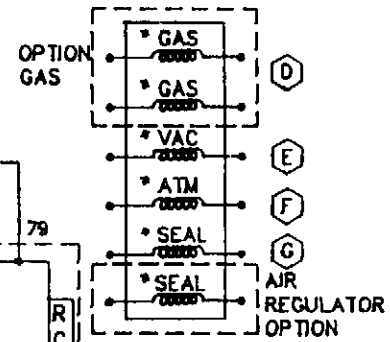
MACHINE		420A, 600A & 620A		SIPROMAC	
PIECE		ELECT. WRING HIGH VOLTAGE 1ø, 50 HZ		ST-GERMAN DE GRANTHAM, QUEBEC CANADA	
QT.	ECH. SCALE	NE PAS MESURER /N.T.S.		NO.	006-0101
MAT:	DESS. D. LETOURNEAU	DATE	97-03-11	DATE	



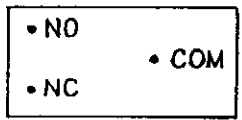
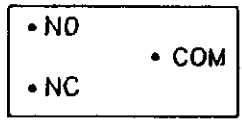
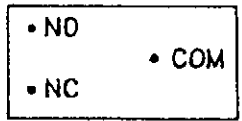
OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0450	034-0200
TWIN SEAL	380	034-0430	034-0410
TWIN SEAL	600	034-0425	034-0410
TOP & BOTTOM SEAL	220	034-0500	034-0200
TOP & BOTTOM SEAL	380	034-0465	034-0410
TOP & BOTTOM SEAL	600	034-0440	034-0410

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

* RC SUPPRESSOR ADD ON EACH COIL



TOP SEAL OPTION



53

COLOR CODE PRIMARY (VAC)

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

SECONDARY (VAC)

RED	24V
PURPLE	9V

* USE STARS WASHERS FOR TRANSFO. FIXATION.

MACHINE	420A, 600A & 620A			
PIECE	ELECT. WIRING HIGH VOLTAGE (50 HZ) 3P			
QT.		ECH. SCALE	NE PAS MESURER /N.T.S.	
MAT:		DESS. D. LETOURNEAU	DATE 86-10-02	NO.
		APP.	DATE	006-0102

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

MODEL:250,350,420A,450A,550A,450T,600A,620A,650A & 700A

A:	VOLT	PHASE	PUMP	CONTACTOR	OVERLOAD
	110	1	3	025-0010	025-0140
	110	1	6	025-0020	025-0170
	110	1	16	025-0030	025-0180
	110	1	21	025-0030	025-0190
	220	1	21	025-0020	025-0190
	220	1	40	025-0020	025-0190
	220	3	40	025-0010	025-0170
	380	3	40	025-0020	025-0150
	575	3	40	025-0010	025-0140
	220	1	63	025-0040	025-0190
	220	3	63	025-0020	025-0180
	575	3	63	025-0010	025-0150
	220	1	100	025-0050	025-0200
	220	3	100	025-0030	025-0190
	460	3	100	025-0010	025-0170
	575	3	100	025-0010	025-0160
	220	1	160	025-0070	025-0222
	220	3	160	025-0040	025-0210
	575	3	160	025-0010	025-0180
	220	3	250	025-0060	025-0220
	460	3	250	025-0030	025-0190
	575	3	250	025-0020	025-0190

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

D: OPTIONAL GAZ SOLENOID VALVE: # 106-0010

E: VACUUM SOLENOID VALVE: # 106-0030---(420A)
 # 106-0050---(600A & 620A)
 # 106-0060---(650A)

F: ATMOSPHERE SOLENOID VALVE: # 106-0020 WITH PUMP:
 21 M³
 # 106-0030 WITH PUMPS:
 40 M³, 60 M³ & 100 M³
 # 106-0050 WITH PUMPS:
 160 M³ & 250M³

G: BELLOW SOLENOID VALVE: # 106-0070
 H, I, J: COVER SWITCH: # 026-0610
 K: SEALING TRANSFO.:

250 ONE SEAL BAR: # 029-0040
 350 ONE SEAL BAR: # 029-0010
 350 TWO SEAL BAR: # 029-0030
 650 ALL MODEL : # 029-0170
 420, 450, 550, 600, 620 TWIN SEAL & BAG CUT 220 VOLTS: # 029-0040
 TWIN SEAL & BAG CUT 575 VOLTS: # 029-0050
 TOP & BOTTOM SEALING 220 VOLTS: # 029-0080
 TOP & BOTTOM SEALING 575 VOLTS: # 029-0095
 L: RELAY & BASE: RELAY: # 025-MY424 & BASE: # 025-0600
 M: OPTIONAL TOP SEALING CONTACTOR: # 025-0020
 N: CONTROL TRANSFO.:MODEL 250 TO 650:029-0007, 029-0008, 029-0009,
 029-0250

MODEL 700A:029-0010

ITEM	#	PIECE	DESCRIPTION	QT.
------	---	-------	-------------	-----

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

COLOR CODE

① BLACK : OUTPUT TO ATMOSPHERE VALVE

② WHITE : OUTPUT TO SEALING CONTACTOR

③ ORANGE : OUTPUT TO GAZ VALVE

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

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

⑥ GREEN : INPUT 9 VAC

⑦ ----- : JUMPED WITH ⑥

⑧ BLUE : TO COVER SWITCH

⑨ ----- : NOT USED

⑩ WHITE/BLACK : OUTPUT TO VACUUM VALVE OR CONT.
MOTOR 350,450A OR 550A
(250,

⑪ ORANGE/BLACK : OUTPUT TO SEALING SELENOID VALVE

⑫ RED : INPUT 24 VAC

⑬ GREEN/WHITE : INPUT 9 VAC

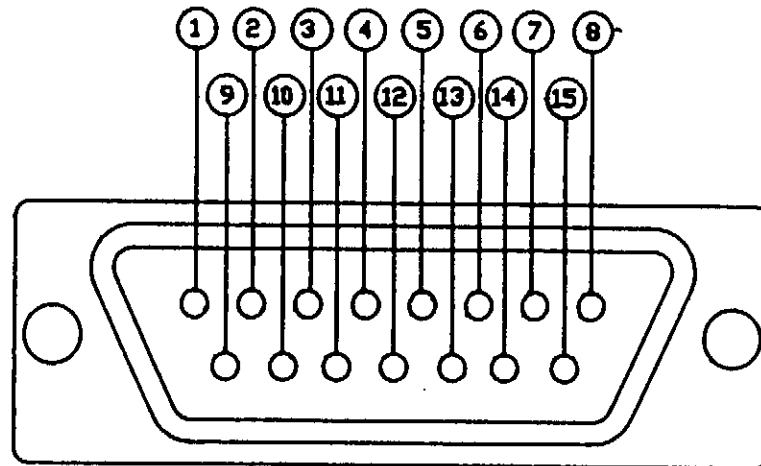
⑭ ----- : JUMPED WITH ⑬

⑮ BLUE/WHITE : TO COVER SWITCH

JUMP
SEE NOTE

PC BOARD
RELAY

COVER
SWITCH



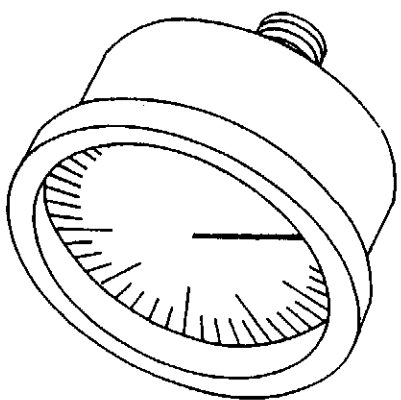
WIRE SIDE VIEW

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

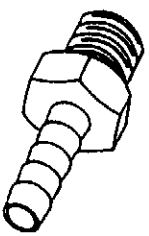
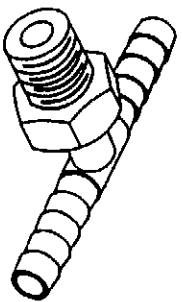
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24

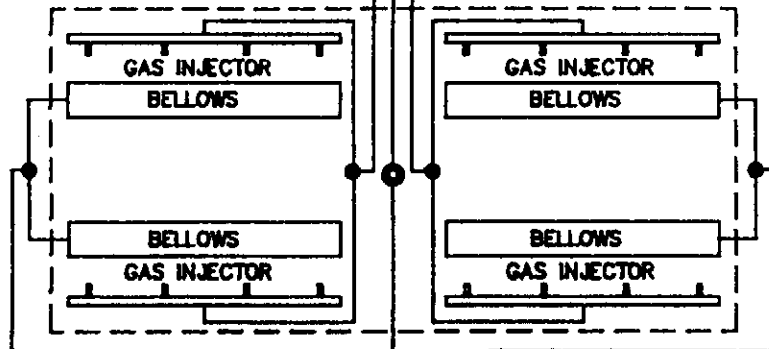
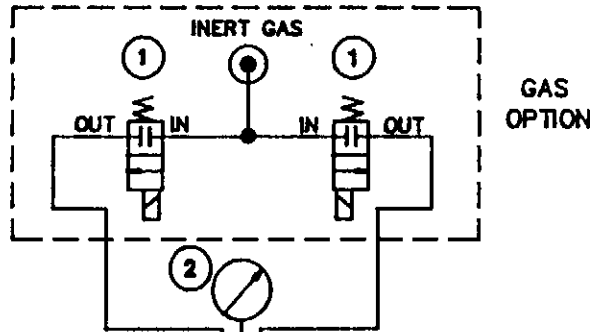
MACHINE		VACUUMS		SIPROMAC	
PIECE		"D" CONNECTOR DETAIL		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	
QTY	_____	ECH. SCALE	_____	NE PAS MESURER /N.T.S.	
DATE	95-01-31	D.L.		DATE 96-11-07	NO. 006-0029
LET.	REDESSINE	MODIFICATION	DATE	INT.	



PNEUMATIC DRAWING

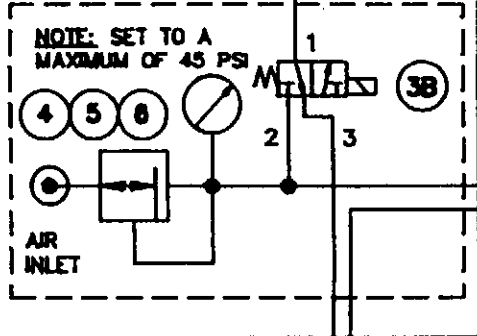


-NOTE:
 -FOR GAS INJECTION
 KIT INSTALLATION
 SEE DRAWINGS #:
 420A: #010-0016
 600A: #010-0017
 620A: #010-0018
 650A: #010-0020



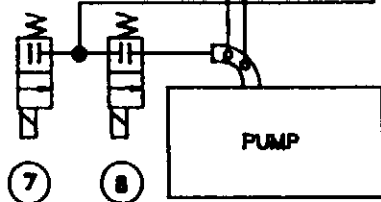
AIR REGULATOR OPTION

**NOTE: SET TO A
 MAXIMUM OF 45 PSI**

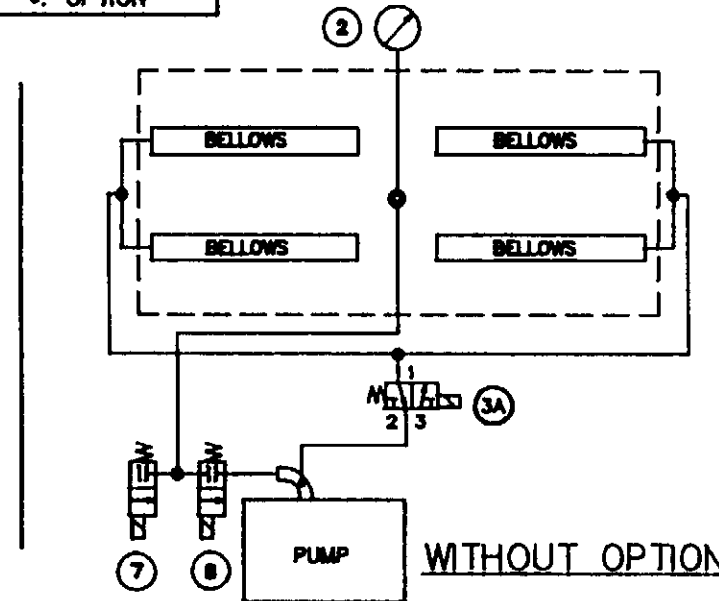


-NOTE:
 -FOR AIR REGULATOR
 OPTION KIT INSTALLATION
 SEE DRAWINGS # 010-0019
 & 650A: #010-0027
 (FOR EXISTING MACHINES)

WITH OPTIONS



ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	2*
2	114-0280	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, 063M ³ AND 100 M ³	
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A: 160 M ³ AND 250 M ³	
8	106-0030	VACUUM VALVE FOR 420A	1
	106-0050	VACUUM VALVE FOR 600A & 620A	
	106-0060	VACUUM VALVE FOR 650A & 700A	
* : OPTION			

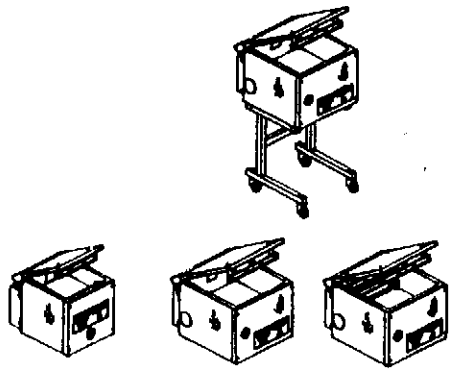


WITHOUT OPTION

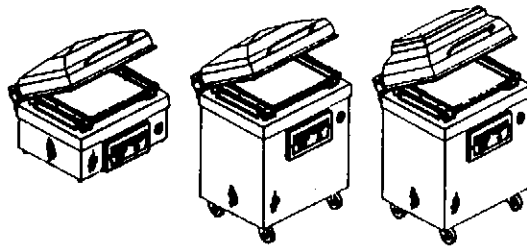
MACHINE 420A,600A,620A & 650A		SIPROMAC	
PART PNEUMATIC		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM: _____		N.T.S.	
CNC: _____		SCALE: _____	QT. 1
MAT: _____		CNC M.LAVIGNE	NO. 007-0019
DATE 97-03-11		DATE	

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

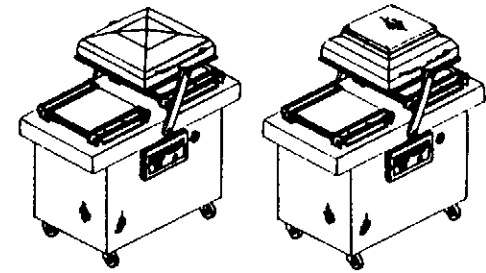
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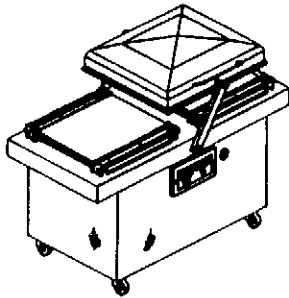
MODEL 250 MODEL 350 MODEL 350D



MODEL 450T MODEL 450A MODEL 550A



MODEL 420A

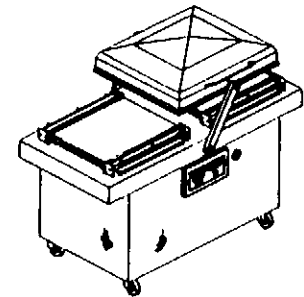


MODEL 600A



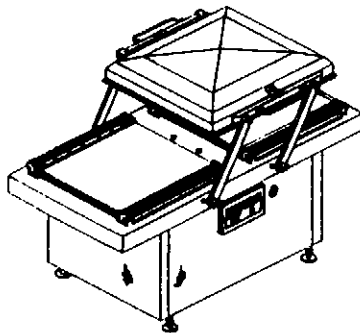
Canada

SIPROMAC
International Headquarters
240 Industrial Blvd.
St. Germain, Canada J0C1K0
819-395-5151
FAX: 819-395-5343

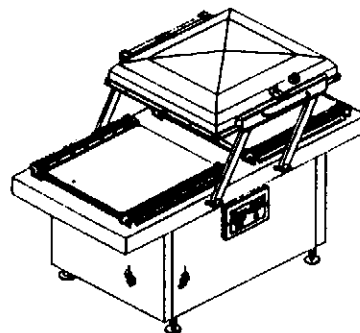


MODEL 620A

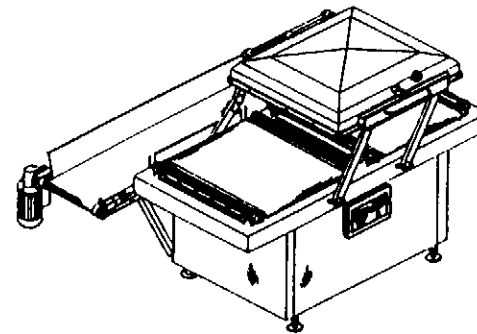
VACUUM PACKAGING MACHINES



MODEL 650A



MODEL 650A AUTOMATIC



MODEL 700A

