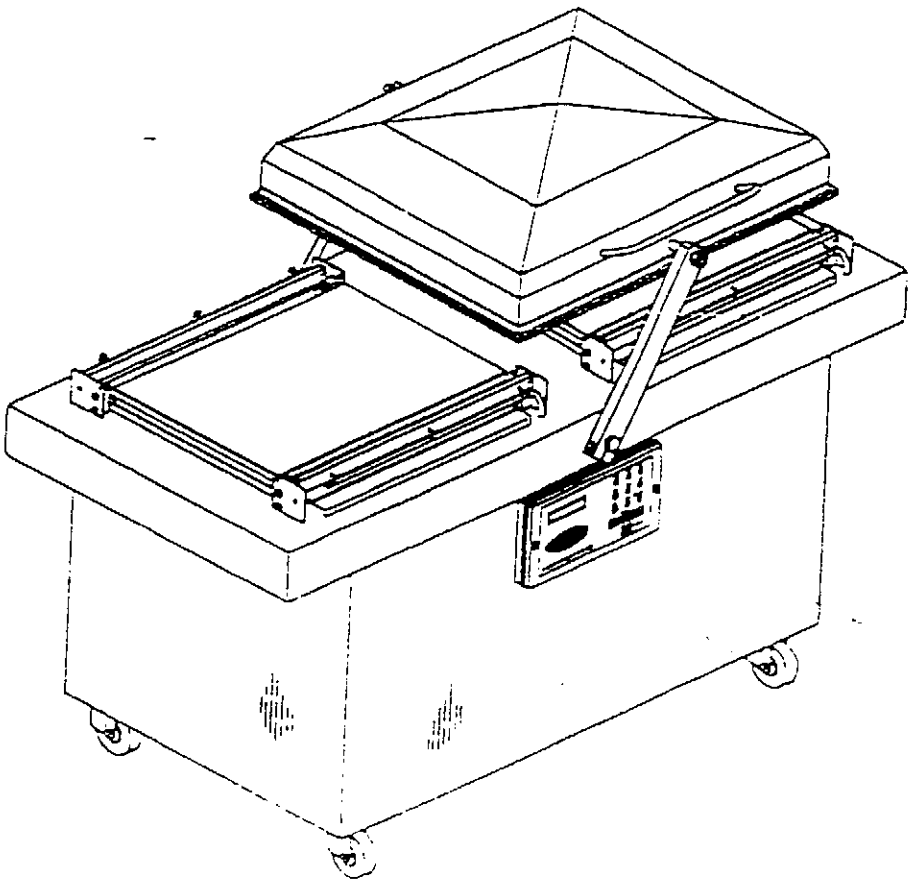
SIPROMAC



MODEL 620A

MC-46

VACUUM PACKAGING MACHINE

MODEL 620A

GENERAL TABLE OF CONTENTS

DAJG/88

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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SIPROMAC INC.

VACUUM PACKAGING MACHINES

1. SETTING UP THE MACHINE:

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

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

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

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

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

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

3. OPERATION:

3.1 Working principles:

A vacuum packaging cycle is made of 3 stages. First the vacuum is made, the air is completly 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 mecanism 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 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 side where sealing is done.

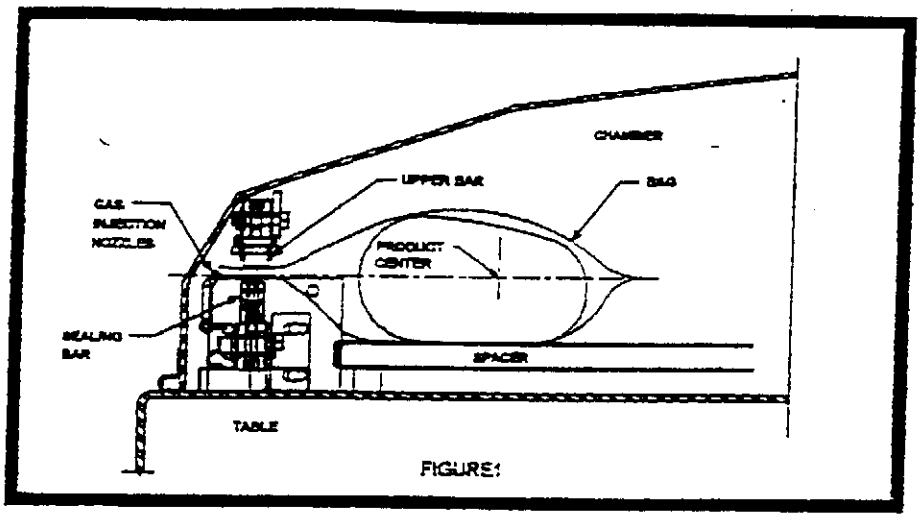


FIGURE:

3.2 Special packaging:

3.2.1 Gas flushing (option):

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

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

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

3.2.2 Top and bottom sealing (optional):

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

3.2.3 Electrical bag cut (optional):

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

3.3 Vacuum packaging operation:

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

3.3.1 Basics:

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

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

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

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

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

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

3.3.2 Functions menu:

3.3.2.1 Create a program:

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

3.3.2.2 Delete a program:

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

3.3.2.3 Select operating mode:

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

3.3.3 Programs menu:

3.3.3.1 Program identification:

For a selected program, set the identification, using the numeric keyboard characters chart; press numeric key untill 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 sequencally 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.7

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)
(units with gas option)	"GAS FLUSH: xx.x%"	(0.0% - 10% below the vacuum level)
	"SEAL TIME: x.xxs"	(0.00s - maximum unit allocated setting)
	"Pxx NAME"	(12 characters)

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

  "DIAGNOSTICS MENU" (access code required)

  "D1 INPUTS TEST"

  "D2 OUTPUTS TEST"

  "D3 MODEL SELECT"

  "D4 GAS OPTION"

  "D5 SEALING TIME"

  "D6 COOLING TIME"

  "D7 LOADING TIME" (automatic units only)

  "D8 UNLOADNG TIME" (automatic units only)

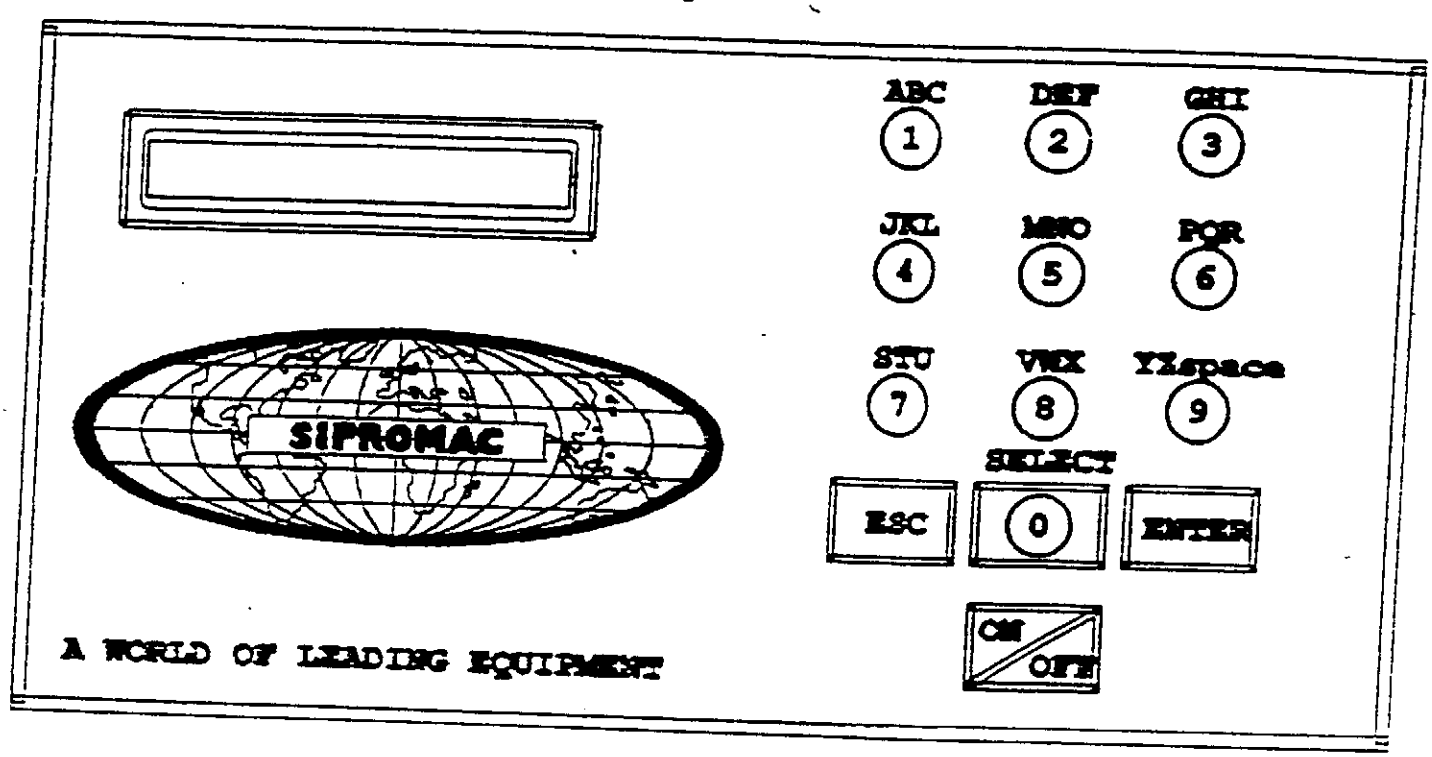
  "SYSTEM MONITOR" (no access code required)

  "SOFTWARE P.x.xx"

  "WORK HRS xxxxx"

  "CYCLES xxxxxxx"

-KEYBOARD DETAILS-



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

3.4 Daily cleaning:

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

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "VACUUM ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

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

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

4.1.3 "ATMOSPHERE ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

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

- Check limit switch adjustment.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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

4.2.2 No leakage in the bag:

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

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

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

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

Verify at vacuum hose connections and valve connections.

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

Warning: Verify connections of measuring equipment before verifing machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

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

4 5 MC40 Control board failure

NOTE: Refer to menu structure on page 8.

This board software is allowing access to a "Diagnostics Menu". Only qualified service technicians are authorized to access this menu by entering a security password.

By acceding either the "D1 input test" feature or the "D2 output test" feature, a trained technician will be able to quickly know the origin of the problem: pump, sealing system, pneumatic problem, security switches problem, etc...

Keep in mind that in most cases trouble is due to a leakage, loose electrical connection or evident dammage to the main component: vacuum pump, valves..., electrical contactors, thermal overload, fuses holder or transformer.

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

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

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

Check vacuum connections for tightness.

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

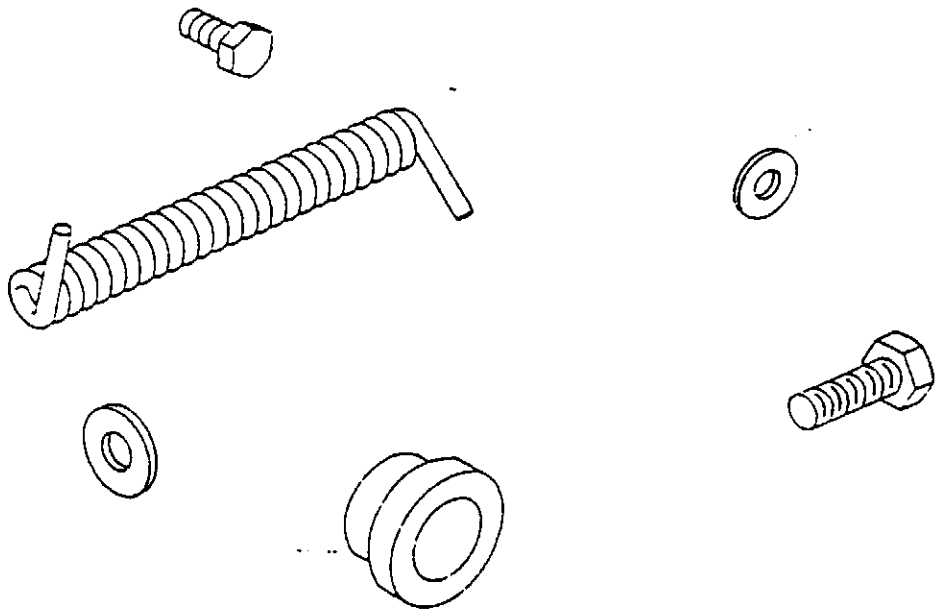
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

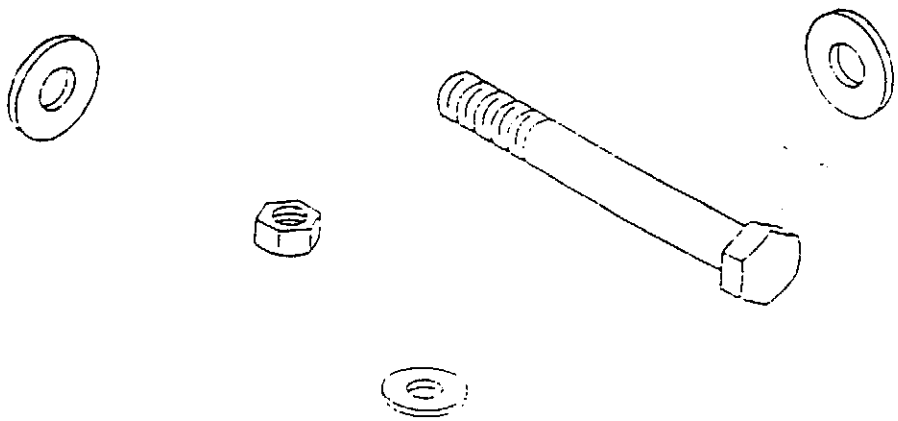
INSTALLATION NOTICE FOR MODELS: 420A,450T,450A,550A,600A,620A, 650A AND 700A

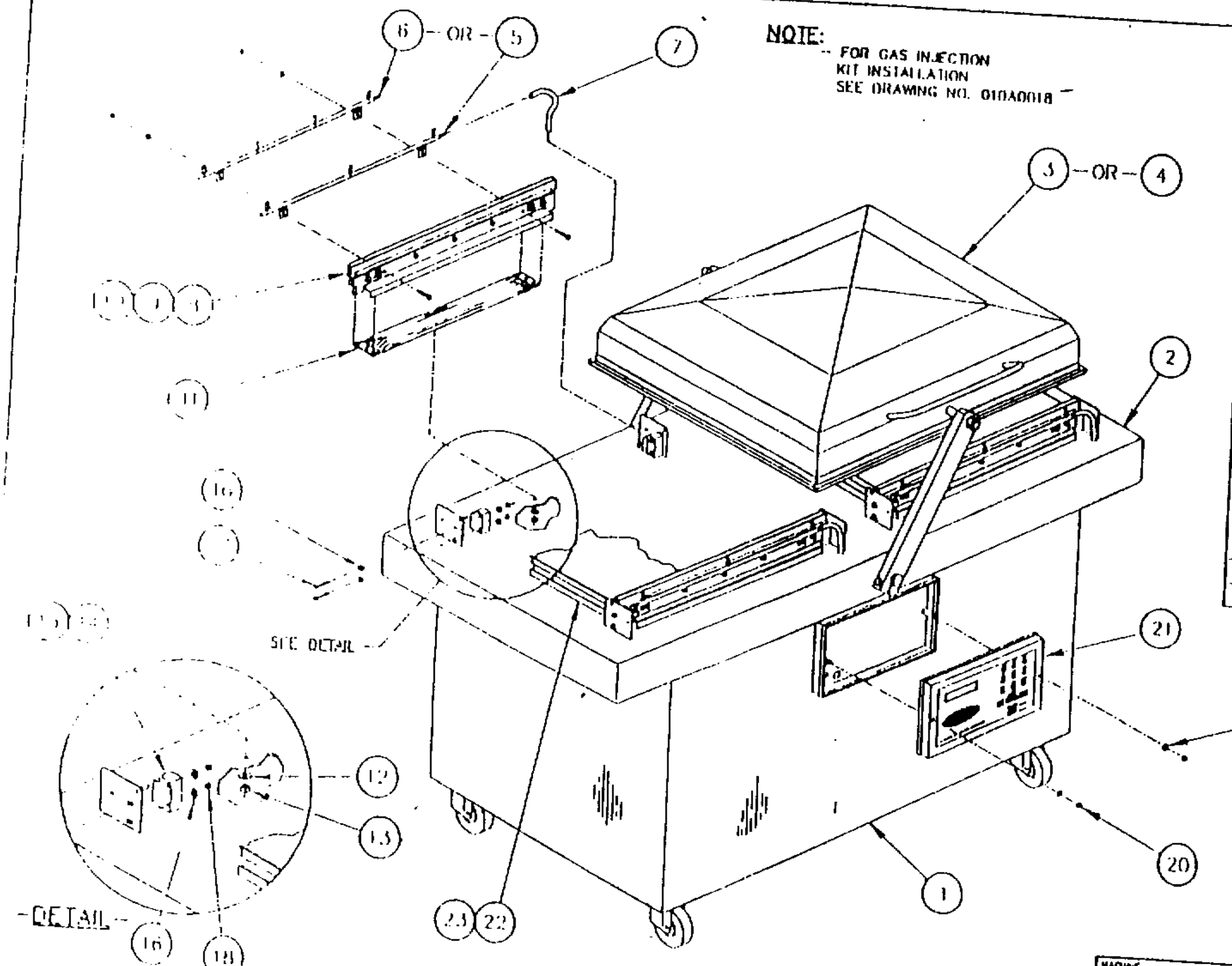
IN ORDER TO RESPECT NSF REGULATIONS:

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



MECHANICAL DRAWING





ITEM	PART #	DESCRIPTION	QT
1	005-0457	STRUCTURE ASSEMBLY	1
2	005-0414	TABLE ASSEMBLY	1
3	005-0463	8" COVER ASSEMBLY	1
4	005-0464	12" COVER ASSEMBLY (OPTION)	1
5	005A0423	GAS 3 INJECTION BAR ASS'Y (OPTION)	1
6	005A0424	GAS 4 INJECTION BAR ASS'Y (OPTION)	4
7	008-0484	GAS INJECTION CONN. TUBE (OPTION)	4
8	005-0560	SEAL BAR ASS'Y W/ SUPPORT	4
9	005-0561	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPTION)	4
10	005-0562	SEAL BAR ASS'Y W/ SUPPORT (TBS OPTION)	4
11	005-0320	BELLOWS ASSEMBLY	4
12	051-0780	FLAT WASHER 3/8"ø S/S	4
13	051-0620	HEX. NUT 3/8"-16 NC.	4
14	002-0327	RIGHT SEAL BAR GUIDE BLOCK	4
15	002-0328	LEFT SEAL BAR GUIDE BLOCK	4
16	051-0740	FLAT WASHER 1/4"ø S/S	4
17	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	32
18	051-0581	NUT 1/4"-20 NC. NYLON LOCK S/S	16
19	052-2045	FLAT WASHER 1/4" COPPER	16
20	051-0591	ACORN NUT 1/4"-20 NC. S/S	2
21	005-0583	P.C. BOARD SUPPORT ASSEMBLY	2
22	005-0422	FILLER PLATE ASSEMBLY	1
23	005-0427	HALF FILLER PLATE ASSEMBLY	2

REDRAWN: DC-10 WAS DC-30		98-05-19	L.M.
		DATE	INIT.

MACHINE	620A			SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	MACHINE ASSEMBLY FRONT VIEW	METRIC TOLERANCE	INCH TOLERANCE N.T.S.	
ITEM:		CHG.		SCALE — OF 1
MAT:		DR. L.MARCOTTE	DATE 98-05-19	NO. 005-0415

1005-0415

MODEL 600A

COVER ADJUSTMENT PROCEDURE

Reference Drawing: # 005-0325
005-0324
004-0122

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

1. Floor should be flat (within 1/8" approx.).

2.1 Mark position of original adjustment of guide arm length and its lower shaft position (# 005-0317). See drawing # 005-0325.

2.2 Loosen the two bolts on the guide arm (# 005-0321).

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 bolts # 20,# 21 & # 22 (items of drawing # 005-0325) at the end of one arm and adjust until square.

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 (# 002-0317; see item 3 of drawing # 004-0122) 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.

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: #37 & #14).

2.2 Loosen the two bolts on the guide arm (See drawing # 005-0416; items #37).

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 #33, #12 & #42).

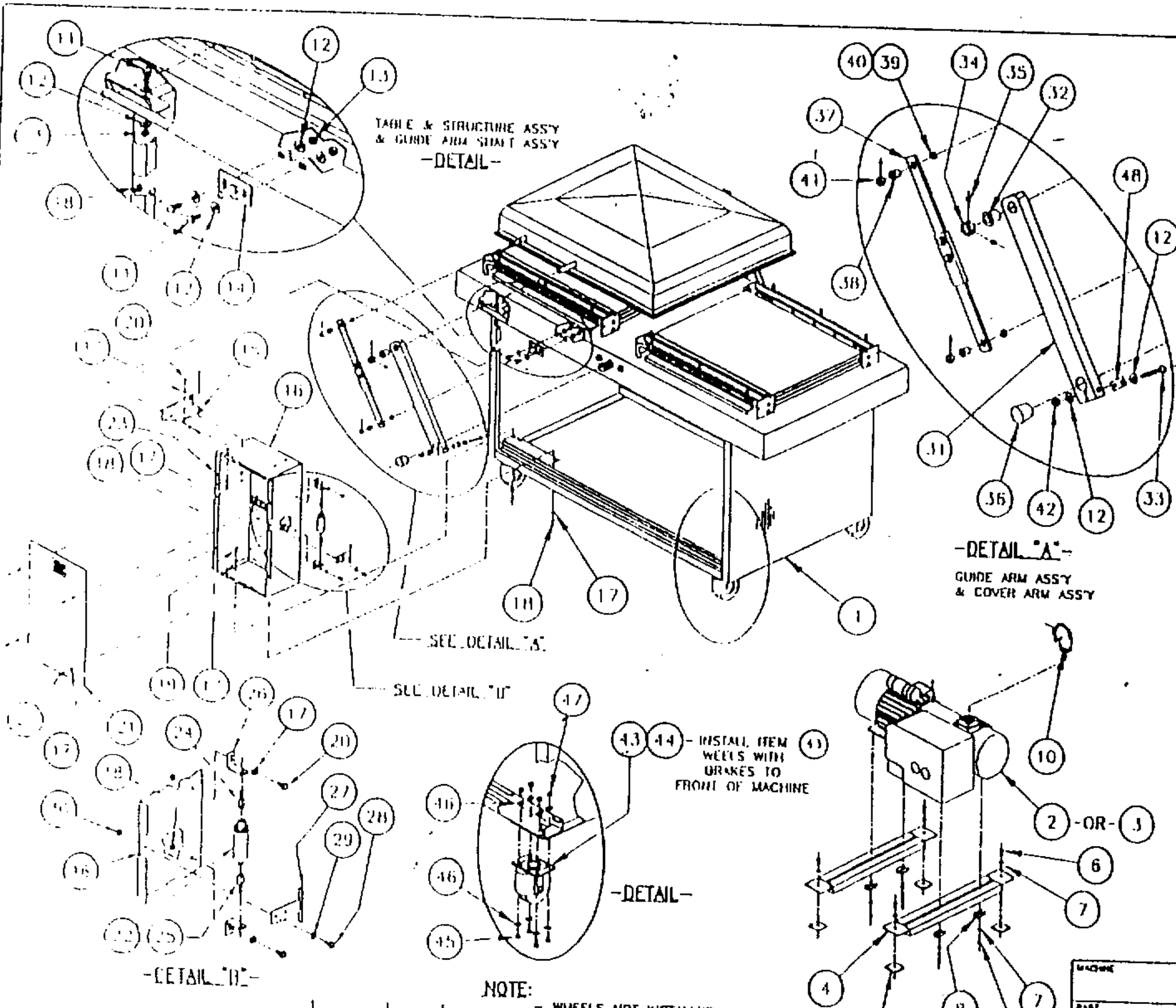
2.5 When closing cover (guide arm still loose), if cover is not sitting properly on either the front or rear of the table, you have to change the height of a central pillow block (See drawing # 004-0223; item #3) until cover is sealing properly each side (less than 1/16").

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

TOUCH MAIN ARMS

ATTACHMENT 2

DAJ36



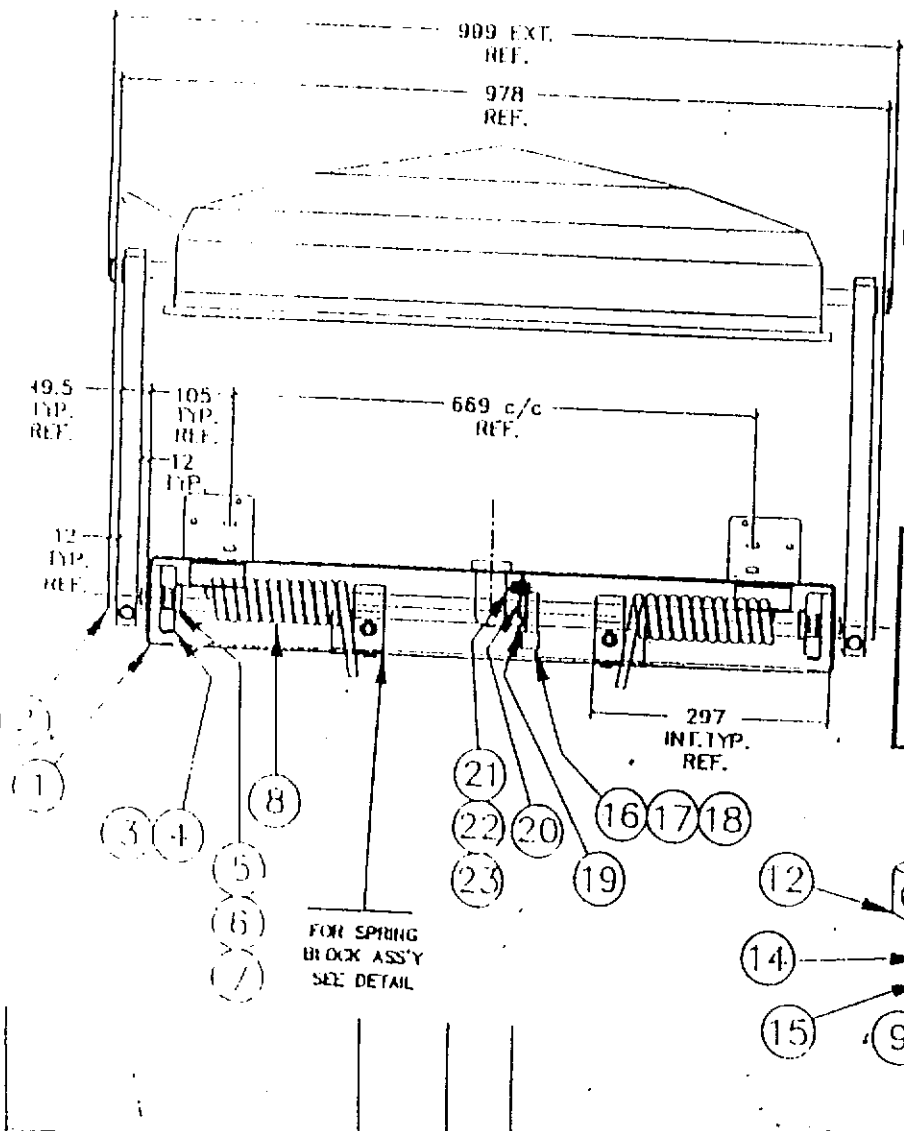
NOTE:
- WHEELS NOT INSTALLED (SHIPPED IN SEPARATE BOX) ITEMS 43 THRU 47

ITEM	PART #	DESCRIPTION	QT
1	005-0415	MACHINE ASSEMBLY FRONT VIEW	1
2	125-	PUMP 160 M³	1
3	125-	PUMP 250 M³ (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 NC. 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	005-0387	BELLOWS ELBOW CONNECTOR ASS'Y	1
11	051-0380	HEX. BOLT 3/8"-16 NC. X 1" S/S	8
12	051-0783	FLAT WASHER (THICK) 3/8" S/S	20
13	051-0620	HEX. NUT 3/8"-16 NC. S/S	8
14	005-0317	GUIDE ARM SHAFT ASSEMBLY	1
15	001-1364	LEFT/ ELECTRICAL BOX UPPER SUPPORT	1
16	005-0374	ELECTRICAL BOX ASSEMBLY	1
17	051-0740	FLAT WASHER 1/4" S.S.	13
18	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	5
19	051-0190	HEX. BOLT 1/4"-20 NC. X 3/4" S/S	2
20	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	7
21	001-0279	ELECTRICAL BOX COVER PRE-ASS'Y	1
22	114-2020	DRYER FILTER	1
23	058-0020	SPRING NUT 1/4"-20 NC STEEL	4
24	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
25	101-0210	STRAIGHT 1/4" FNPT X 1/4" HOSE	1
26	001-2062	DRYER SUPPORT	2
27	005-0323	GAS INLET ASSEMBLY (OPTION)	1
28	051-0180	HEX BOLT 1/4"-20 NC X 1/2" S/S (OPTION)	1
29	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
30	051-0581	HEX NUT 1/4"-20 NC NYLON LOCK S/S (OPTION)	1
31	002-0318	COVER ARM	2
32	075-0820	BUSHING	2
33	051-0422	HEX. BOLT 3/8"-16NC. X 3 1/4" S/S	2
34	002-0390	SET SCREW COLLAR	2
35	051-0178	SET SCREW 1/4"-20 X 5\16" S/S	4
36	057-0013	CENTRAL SHAFT END CAP	2
37	005-0321	GUIDE ARM ASSEMBLY	1
38	075-0440	BUSHING	2
39	058-0050	SPACERS	2
40	058-0060	SPACERS	2
41	105-0420	SCREW COLLAR WITH S/S SET SCREW	2
42	051-0622	HEX. NUT 3/8"-16 NC. NYLON LOCK S/S	2
43	130-4PHB	4" PL. CASTER SWIVEL W/ BRAKE	2
44	130-4PHO	4" PL. CASTER SWIVEL W/ O BRAKE	2
45	052-0520	BOLT 5/16"-18 NC. X 3/4" ZINC	16
46	051-0780	FLAT WASHER 5/16" S/S	32
47	052-3110	NUT 5/16"-18 NC. ZINC	16
48	001-1878	LOWER WIRE SUPPORT (TOP & BOT OPT.)	1

MACHINE: 620A		SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: MACHINE ASSEMBLY REAR VIEW	N.T.S.	
DR. L. MARCOTTE	DATE 98-05-19	SCALE — SH 1
		NO. 005-0416

REDRAWN NO 40 AND NO 39 MODIFICATION — 98-05-19 — L.M. — DATE — INIT.

1005-0416



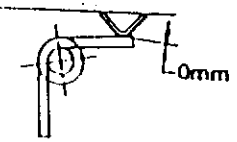
SPRING ADJUSTMENT PRODEDURE

A– PLACE COVER UP(ARM VERTICAL) TO FREE TENSION OF SPRINGS.

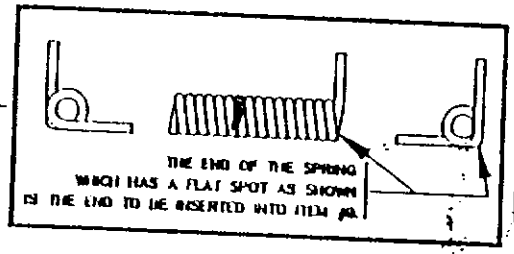
B– LOOSEN BOLTS (ITEMS #10, #13 & #15) ON THE SPRING SUPPORT PLATE ASS'Y (ITEM #9).

C– INSERT A SCREWDRIVER IN SLOT OF ITEM #12 AND PRY OPEN UNTIL BLOCK IS FREE ON CENTRAL SHAFT.

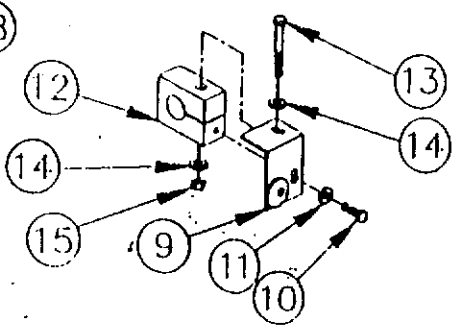
D– TURN SPRING/BLOCK ASSEMBLY TO OBTAIN 0mm (0") AS SHOWN BELOW.



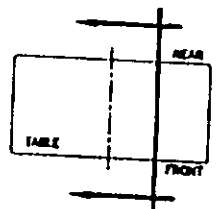
E– RETIGHTEN BOLTS ON SPRING SUPPORT PLATE ASSY. (ITEMS #10, #13 & #15).



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	028-0610	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



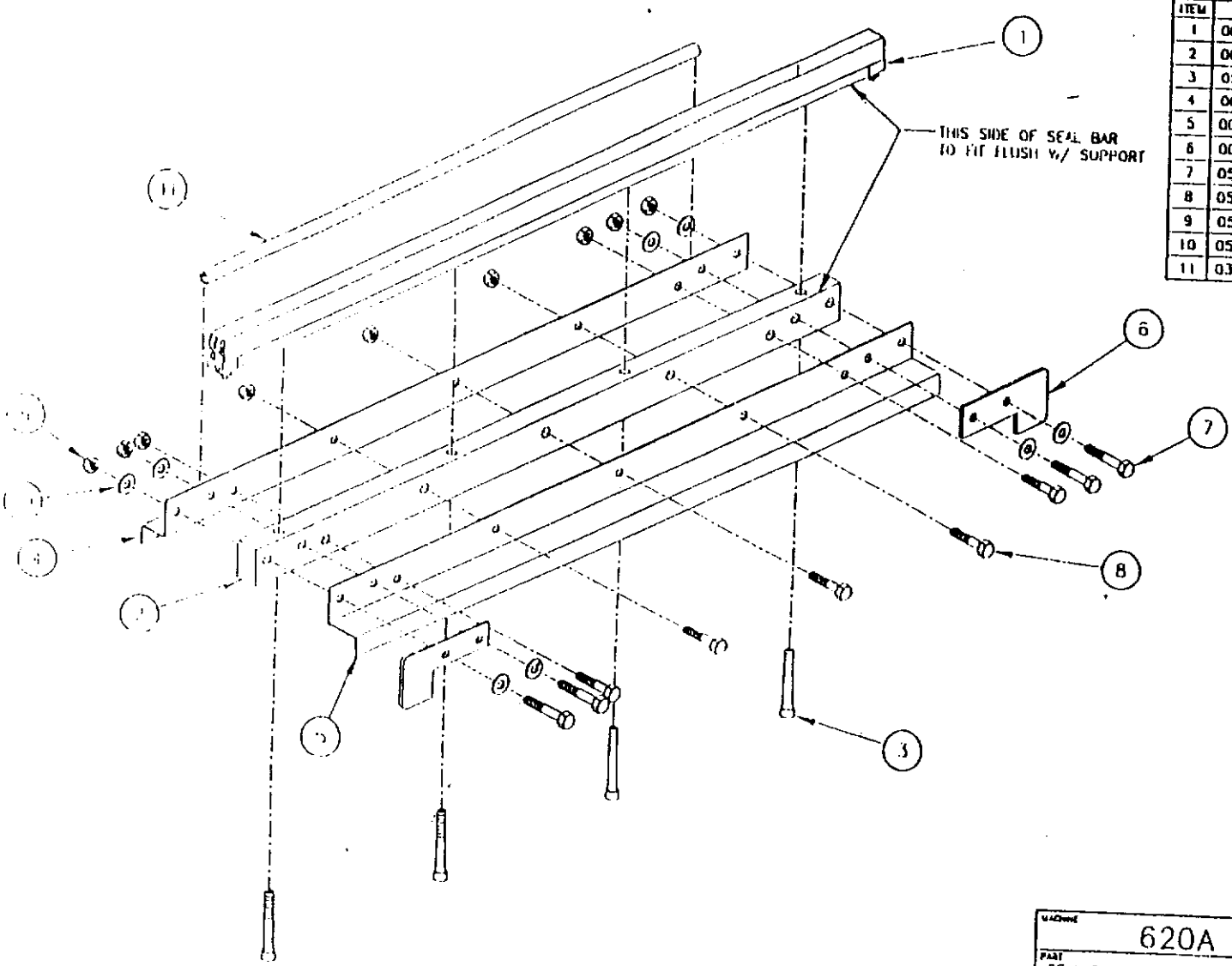
SPRING BLOCK ASS'Y
= DETAIL =



= SECTION =

MACHINE: 620A	METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC
PART: CENTRAL SHAFT ASSEMBLY			ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
QT.: 1	SCALE: NOT TO SCALE		
MAT'D	DRAWN: M.LAVIGNE	DATE: 95-12-20	004-0223
	APP.	DATE	

004-0223

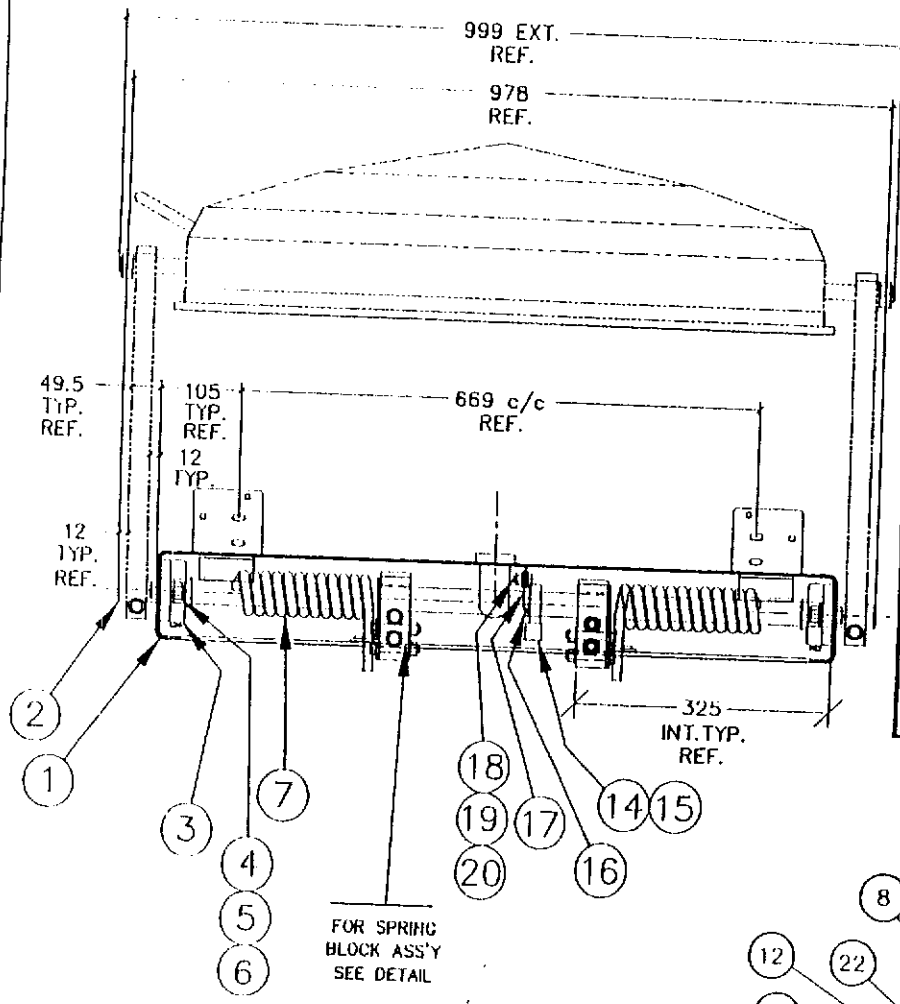


ITEM	PART #	DESCRIPTION	QT
1	005-0418	SEAL BAR PRE-ASSEMBLY	1
2	002-0510	SEAL BAR SUPPORT (TABLE)	1
3	051-0261	CAP HEX. SKT. BOLT 1/4"-20 NC X 2" S/S	16
4	001-1591	EXTERIOR BELLOWS COVER	1
5	001-1958	INTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	8
7	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	16
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	14
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	30
10	051-0740	FLAT WASHER 1/4" S/S	32
11	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 413) PVC	1

97-09-18	AP			
DATE				

MACHINE: 620A	METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC	
PART: SEAL BAR ASSEMBLY W/ SUPPORT		N.T.S.	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	CHG:		SCALE:	QT: 4
MAT:	DES: A. PROVENCHER	DATE: 97-09-18		
	APP:	DATE: 98-03-05	NO. 005-0560	

005-0560

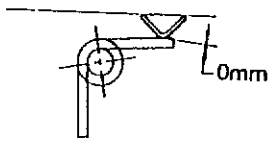


SPRING ADJUSTMENT PROCEDURE

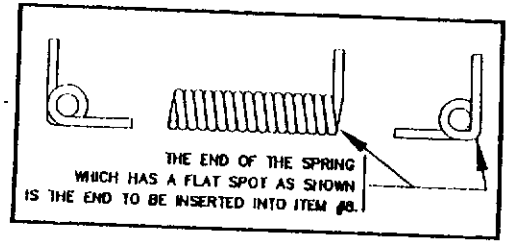
A– PLACE COVER UP(ARM VERTICAL) TO FREE TENSION OF SPRINGS.

B– LOOSEN BOLTS (ITEMS #10) ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y (ITEM #8).

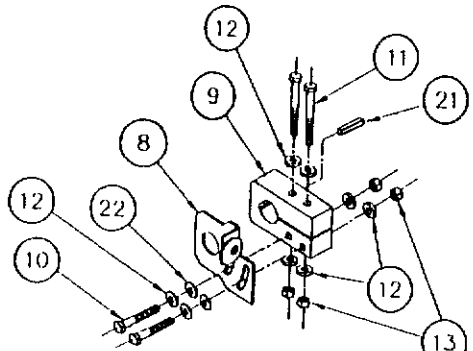
C– TURN SPRING/BLOCK ASSEMBLY TO OBTAIN 0mm (0") AS SHOWN BELOW.



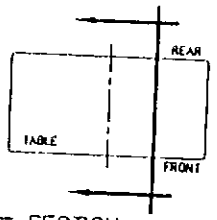
E– RETIGHTEN BOLTS ON SPRING SUPPORT PLATE ASSY. (ITEMS #10).



ITEM	PART #	DESCRIPTION	QT
1	005-0414	TABLE ASSEMBLY	1
2	002A0399	CENTRAL SHAFT	1
3	075-1650	FLANGED BEARING w/ GREASE FITTING 90°	2
4	051-0441	HEX.BOLT 1/2"-13 x 1 1/2" S.S.	4
5	051-0630	HEX.NUT 1/2"-13 S.S.	4
6	051-0790	FLAT WASHER 1/2" S.S.	4
7	008-0315	CENTRAL SHAFT SPRING	2
8	004A0117	SUPPORT PLATE ASSEMBLY	2
9	002A0319	SPRING BLOCK	2
10	052-0775	HEX.BOLT 3/8"-24 x 2 1/2" ZINC	4
11	052-0777	HEX.BOLT 3/8"-24 x 3" ZINC	4
12	052-2060	FLAT WASHER 3/8" ZINC	16
13	052-3128	HEX.NUT 3/8"-24 NC ZINC	8
14	005-0154	MICRO-SWITCH COLLAR	1
15	051-0334	SET SCREW 3/8"-16 x 3/8" S.S.	2
16	026-0610	MICRO SWITCH	2
17	001-1294	MICRO SWITCH FIXATION PLATE	1
18	051-0180	HEX.BOLT 1/4" 20 x 1/2" S.S.	2
19	051-0740	FLAT WASHER 1/4" S.S.	4
20	051-0580	HEX.NUT 1/4"-20 S.S.	2
21	056-0168	KEY 1/4" SQ x 1 1/2" W/ ROUNDED END	2
22	052-2071	CONTACT WASHER 3/8" STEEL	4



SPRING BLOCK ASS'Y
DETAIL



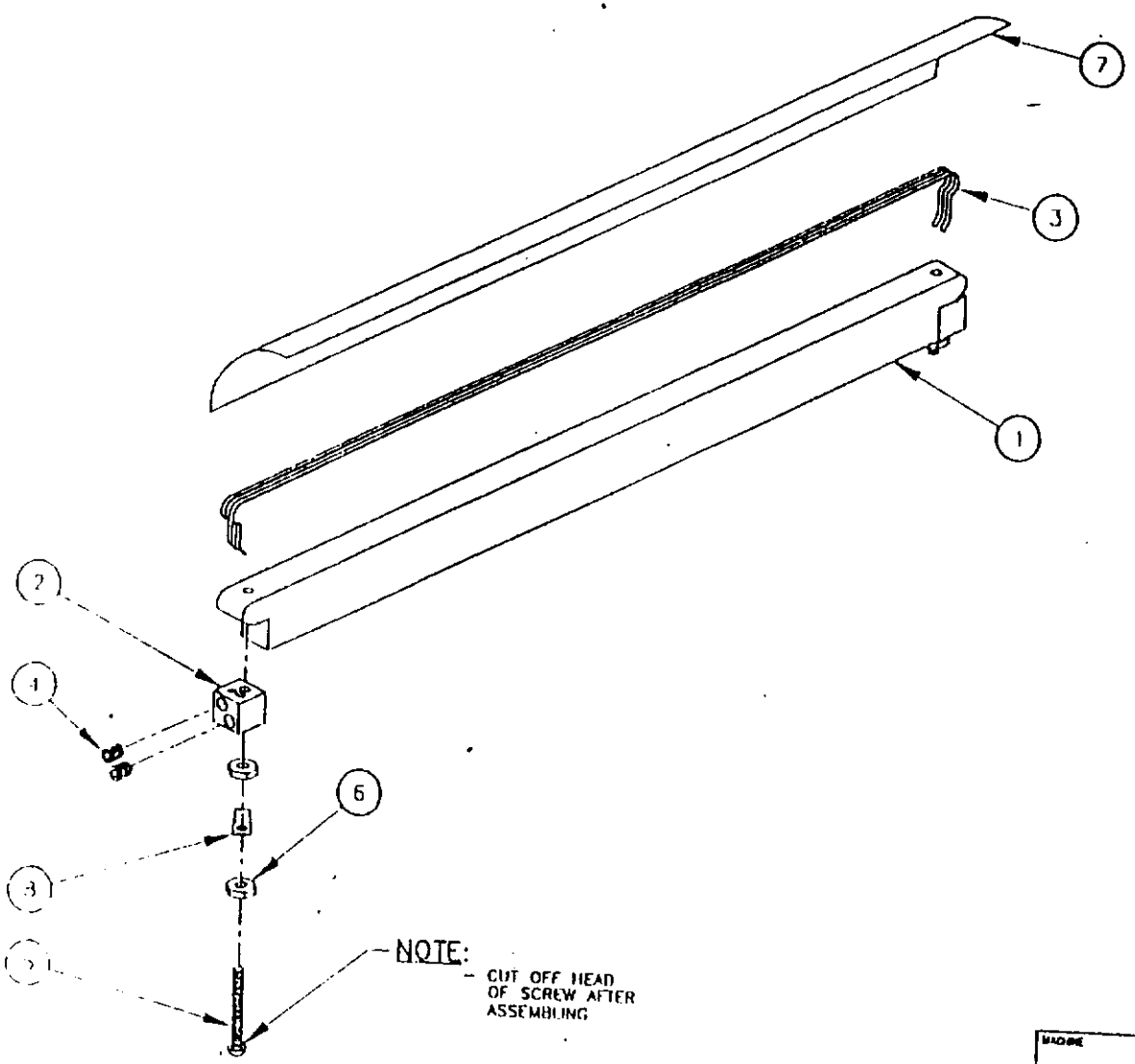
SECTION

REV.	MODIFICATION	DATE	INT.
B	REDRAWN / NEW SPRING BLOC	99-11-17	S.L.

MACHINE: 620A
PART: CENTRAL SHAFT ASSEMBLY
ITEM:
MAT:
METRIC TOLERANCE: 0 ± .5 / .0 ± .03 / .00 ± .005 / .000 ± .0005 / ANGLE ± 1°
INCH TOLERANCE: 0 ± .02" / .00 ± .005" / .000 ± .0003"
N.T.S.
CHG:
DWG SYLVAIN L. DATE 99-11-17
APP. DATE
SCALE
QT. 1
NO 004A0223

SIPROMAC
ST-GERMAIN DE GRANTHAM QUÉBEC CANADA

004A0223



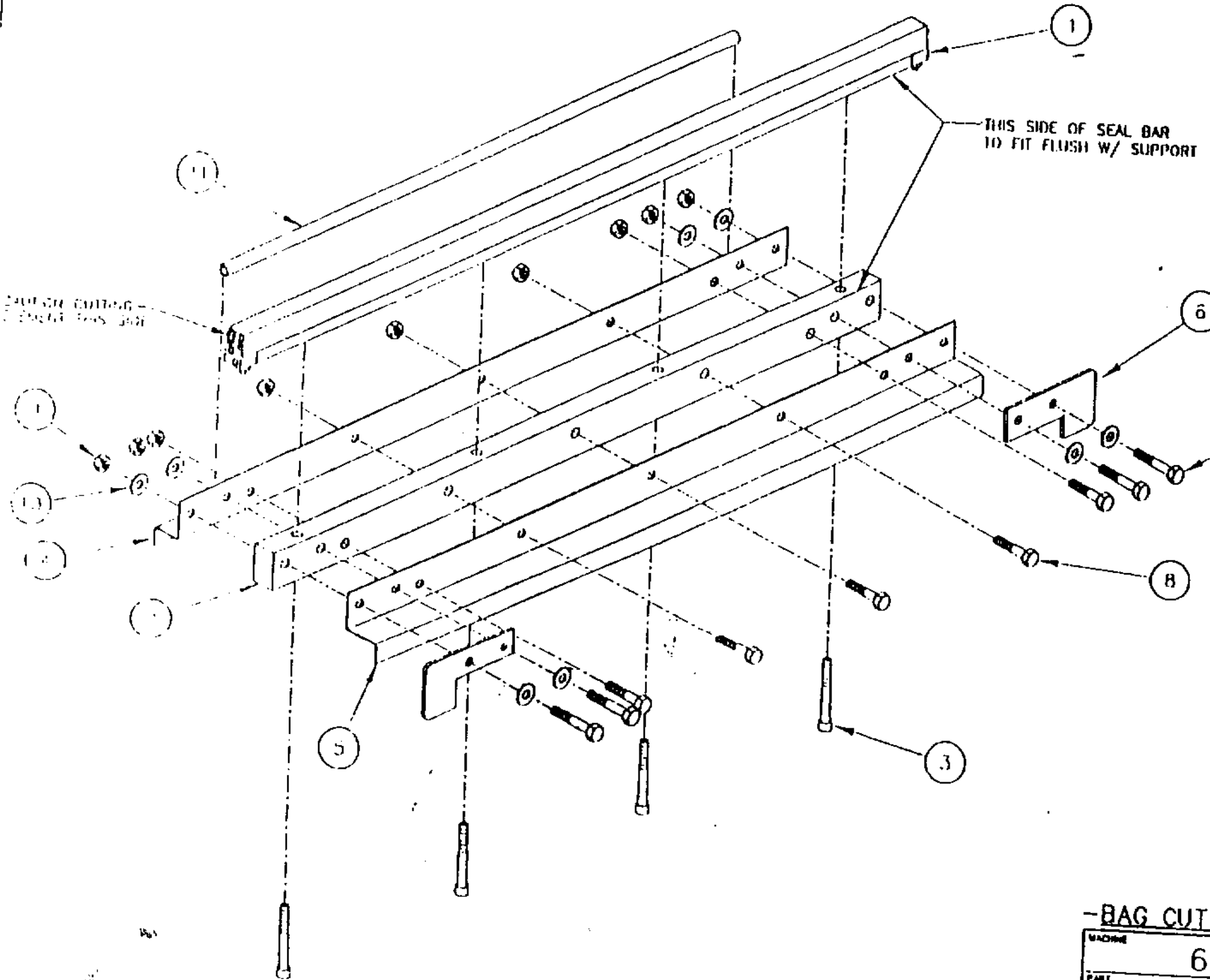
ITEM	PART #	DESCRIPTION	QT.
1	002-0400	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	8
3	030-0200	SEALING ELEMENT	8
4	052-0395	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	16
5	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	8
6	051-0550	NUT #8-32 S/S	16
7	176-0200	TEFLON TAPE SS ADHESIVE X 2" X 650 MM	1
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	8

	98-02-10	AP
	0418	INT

MACHINE: 620A
PART: SEAL BAR PRE-ASSEMBLY
ITEM:
MAT'L:
METRIC TOLERANCE: .X ± .5 / .XX ± .05 / .XXX ± .025 / ANGLE ± 1°
INCH TOLERANCE: .0 ± .02" / .00 ± .01" / .000 ± .005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUÉBEC CANADA
CHG:
DRWN: A. PROVENCHER
DATE: 98-02-10
SCALE:
QT. 4
NO. 005-0418

005-0418

ITEM	PART #	DESCRIPTION	QT
1	005-0419	SEAL BAR PRE-ASSEMBLY	4
2	002-0510	SEAL BAR SUPPORT (TABLE)	4
3	051-0261	CAP HEX. SKT. BOLT 1/4"-20 NC x 2" S/S	16
4	001-1591	EXTERIOR BELLOWS COVER	4
5	001-1958	INTERIOR BELLOWS COVER	4
6	001-0269	SEAL BAR GUIDE	8
7	051-0250	HEX. BOLT 1/4"-20 NC. x 1 1/2" S/S	16
8	051-0230	HEX. BOLT 1/4"-20 NC. x 1 1/4" S/S	14
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	30
10	051-0740	FLAT WASHER 1/4" S/S	32
11	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 41.3) PVC	4



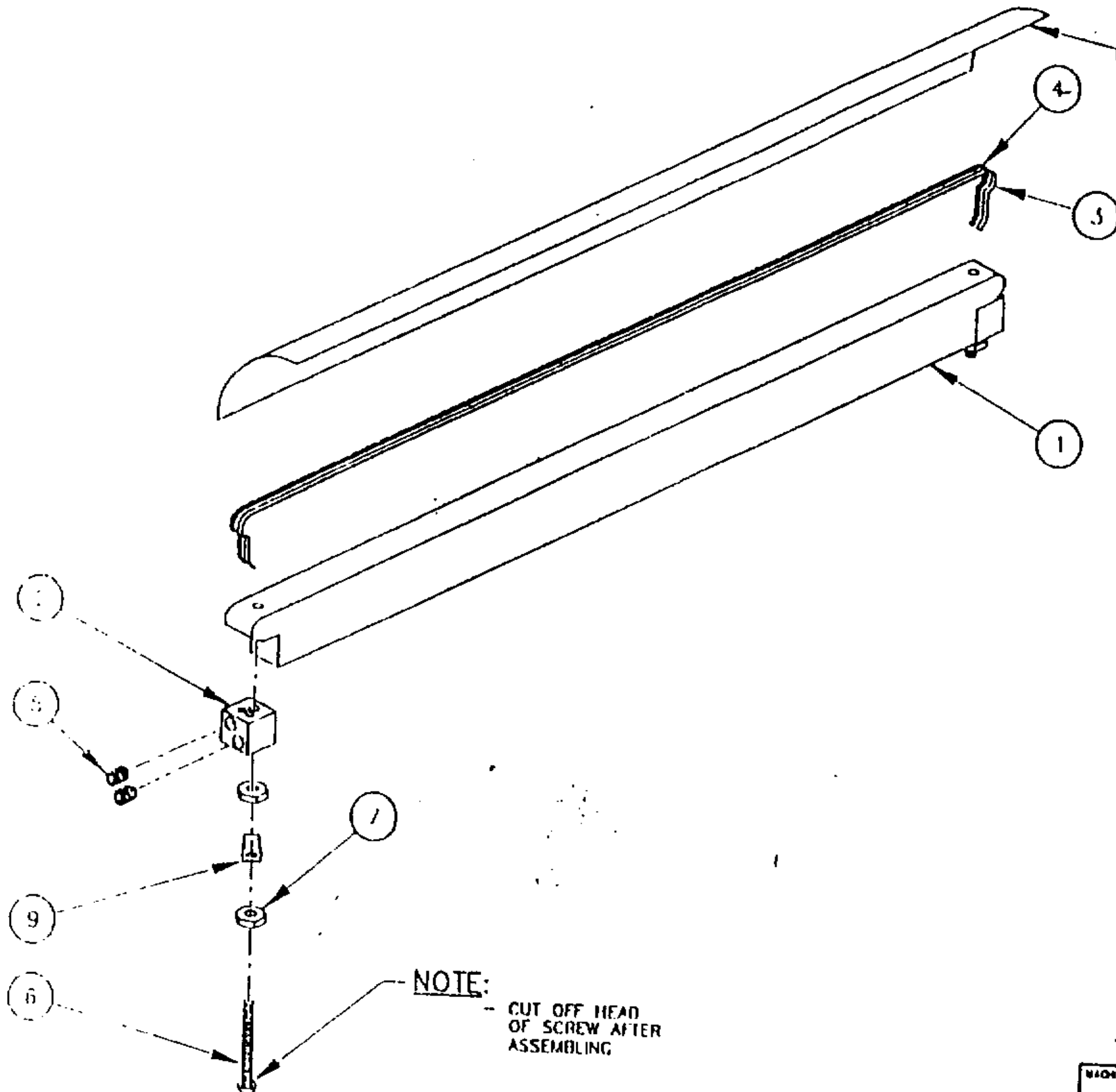
-BAG CUT OPTION-

MACHINE: 620A		SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: SEAL BAR ASSEMBLY W/ SUPPORT	N.T.S.	QT. 4
DES.: A. PROVENCHER	DATE 97-09-18	NO. 005-0561

1005-0561

1005-0419

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	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	16
6	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	8
7	051-0550	NUT #8-32 S/S	16
8	176-0200	TEFLON TAPE 5S ADHESIVE X 2" X 850 MM	4
9	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	8

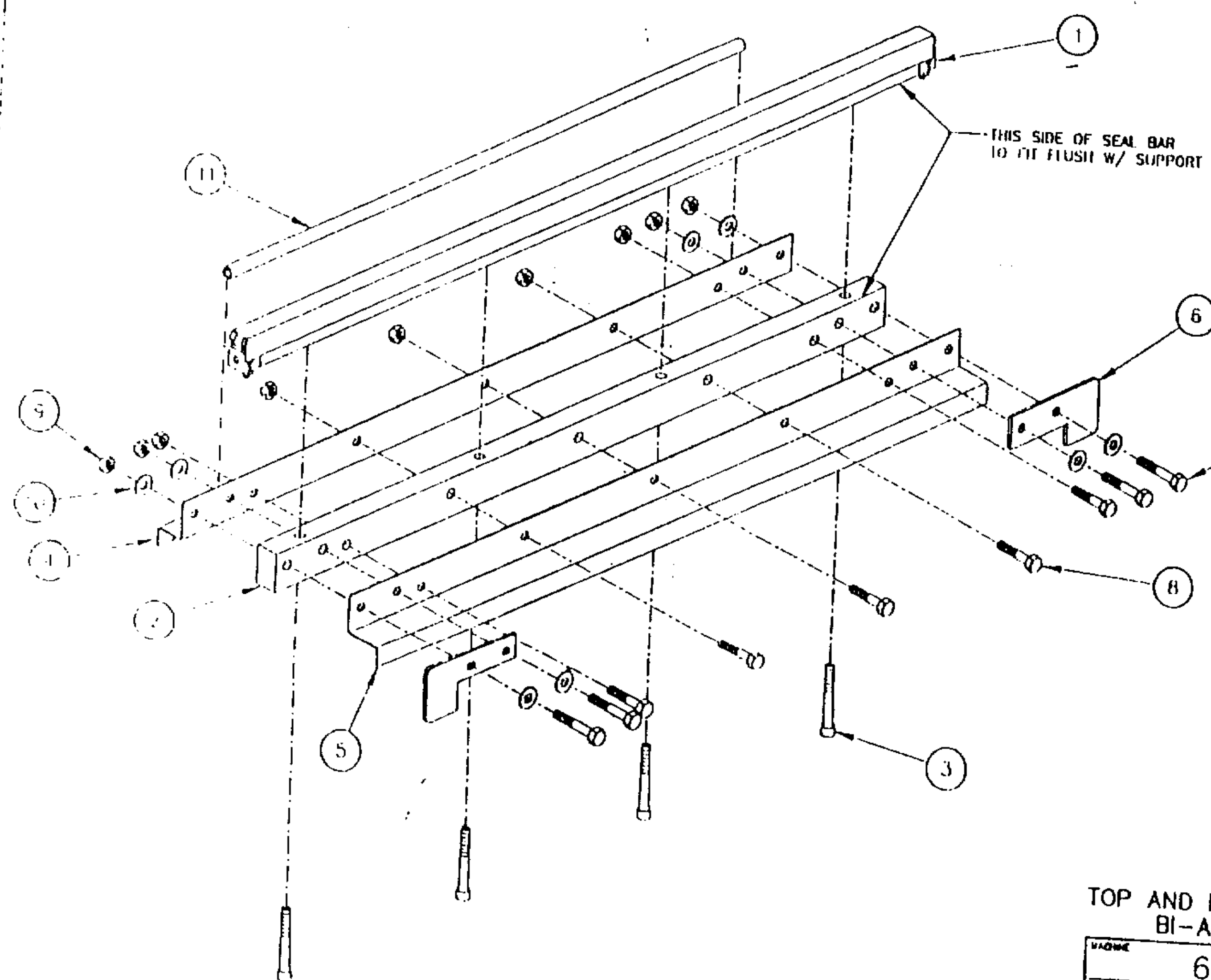


NOTE:
- CUT OFF HEAD OF SCREW AFTER ASSEMBLING

-BAG CUT OPTION-

MACHINE: 620A	METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: SEAL BAR PRE-ASSEMBLY		N.T.S.	
ITEM:	CHK:	SCALE:	SH. 4
MAT:	DWG: J.A. PROVENCHER	DATE: 98-02-10	NO. 005-0419

REDRAWN — 98-02-10 — A.P.
DESCRIPTION — DATE — REV



ITEM	PART #	DESCRIPTION	QT.
1	005-0420	SEAL BAR PRE-ASSEMBLY	4
2	002-0510	SEAL BAR SUPPORT (TABLE)	4
3	051-0261	CAP HEX. SKT. BOLT 1/4"-20 NC X 2" S/S	16
4	001-1591	EXTERIOR BELLOWS COVER	4
5	001-1958	INTERIOR BELLOWS COVER	4
6	001-0269	SEAL BAR GUIDE	8
7	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	16
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	14
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	30
10	051-0740	FLAT WASHER 1/4" S/S	32
11	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.15" X 0.5" X 1.13) PVC	4'

1005-0562

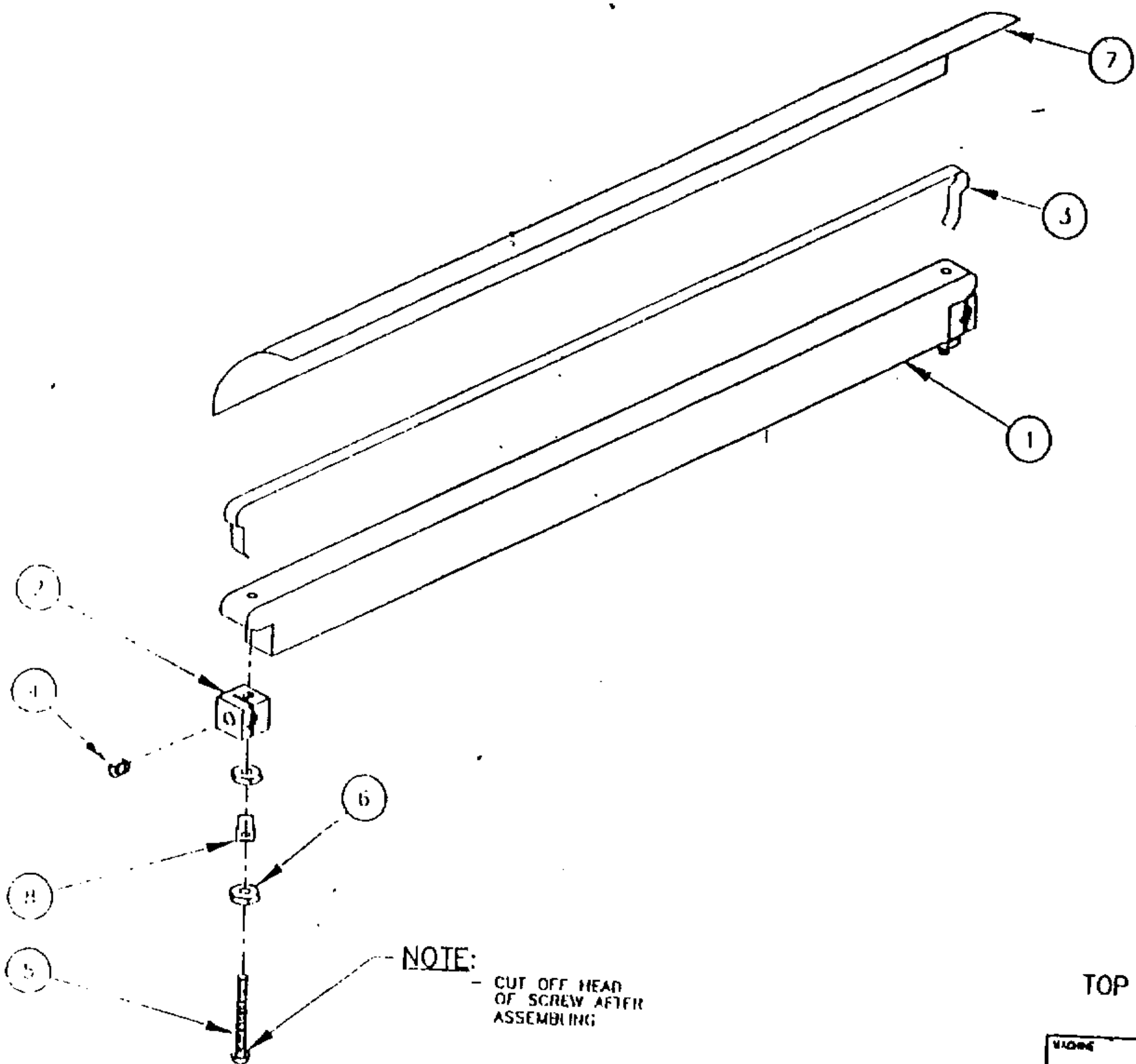
-OPTION-

TOP AND BOTTOM SEALING OR
BI-ACTIVE SEALING

MACHINE: 620A	METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC
PART: SEAL BAR ASSEMBLY W/ SUPPORT		N.T.S.	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:	CHG.		SCALE: OF 4
MAT:	DWG BY: L. PROVENCHER	DATE: 97-09-18	NO. 005-0562

1005-0420

ITEM	PART #	DESCRIPTION	QT
1	002-0400	SEAL BAR (TABLE)	4
2	009-0029	CONNECTOR	8
3	039-0220	SEALING ELEMENT	4
4	052-0395	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	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 SS ADHESIVE X 2" X 650 MM	4
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	8

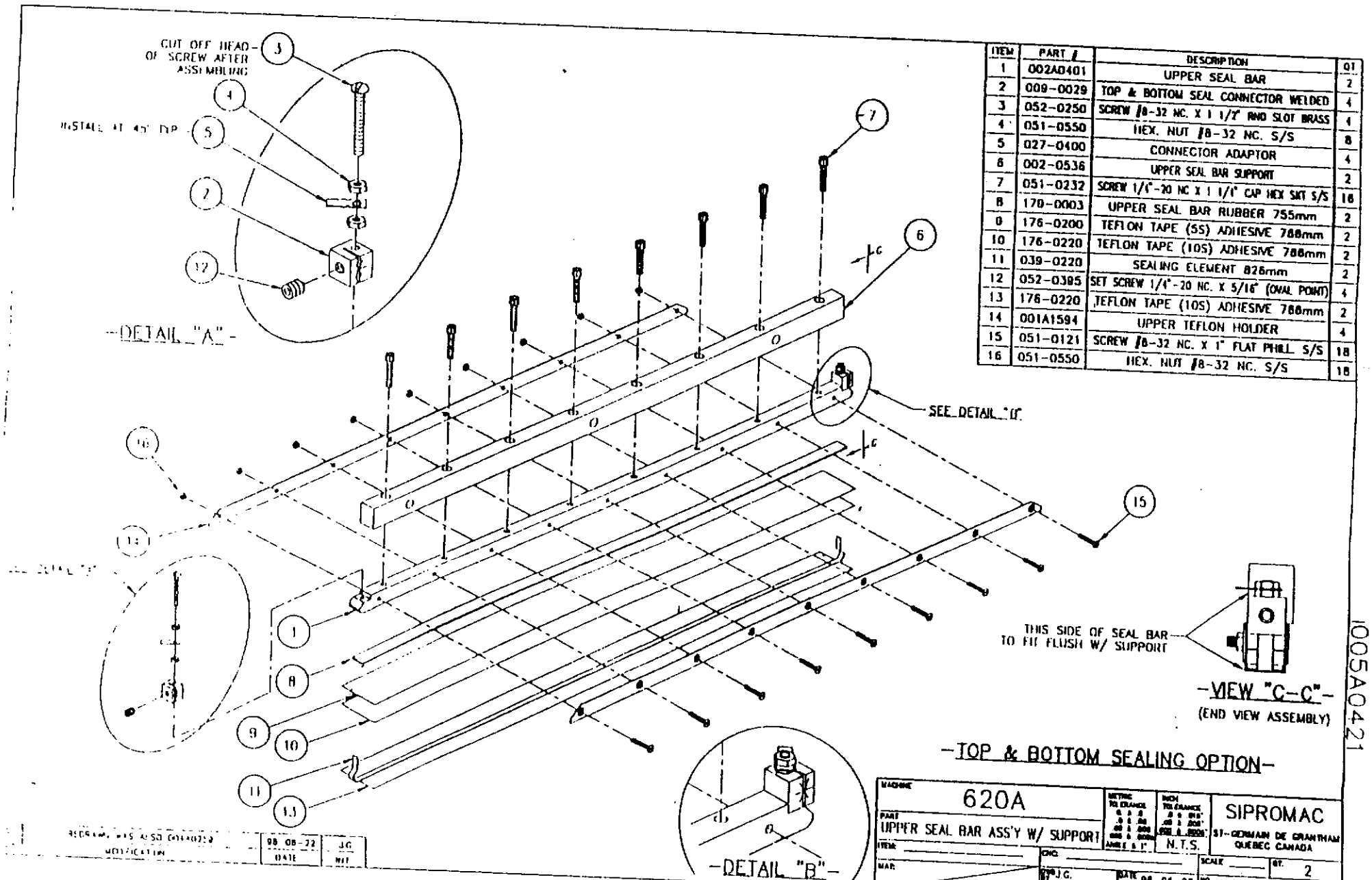


-OPTION-

TOP AND BOTTOM SEALING OR BI-ACTIVE SEALING

MACHINE: 620A			SIPROMAC
PART: SEAL BAR PRE-ASSEMBLY		N.T.S.	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
DWG BY: A. PROVENCHER	DATE: 98-02-10	SCALE	SH. 4
			NO. 005-0420

MODIFICATION	98-02-10 DATE	A.P.



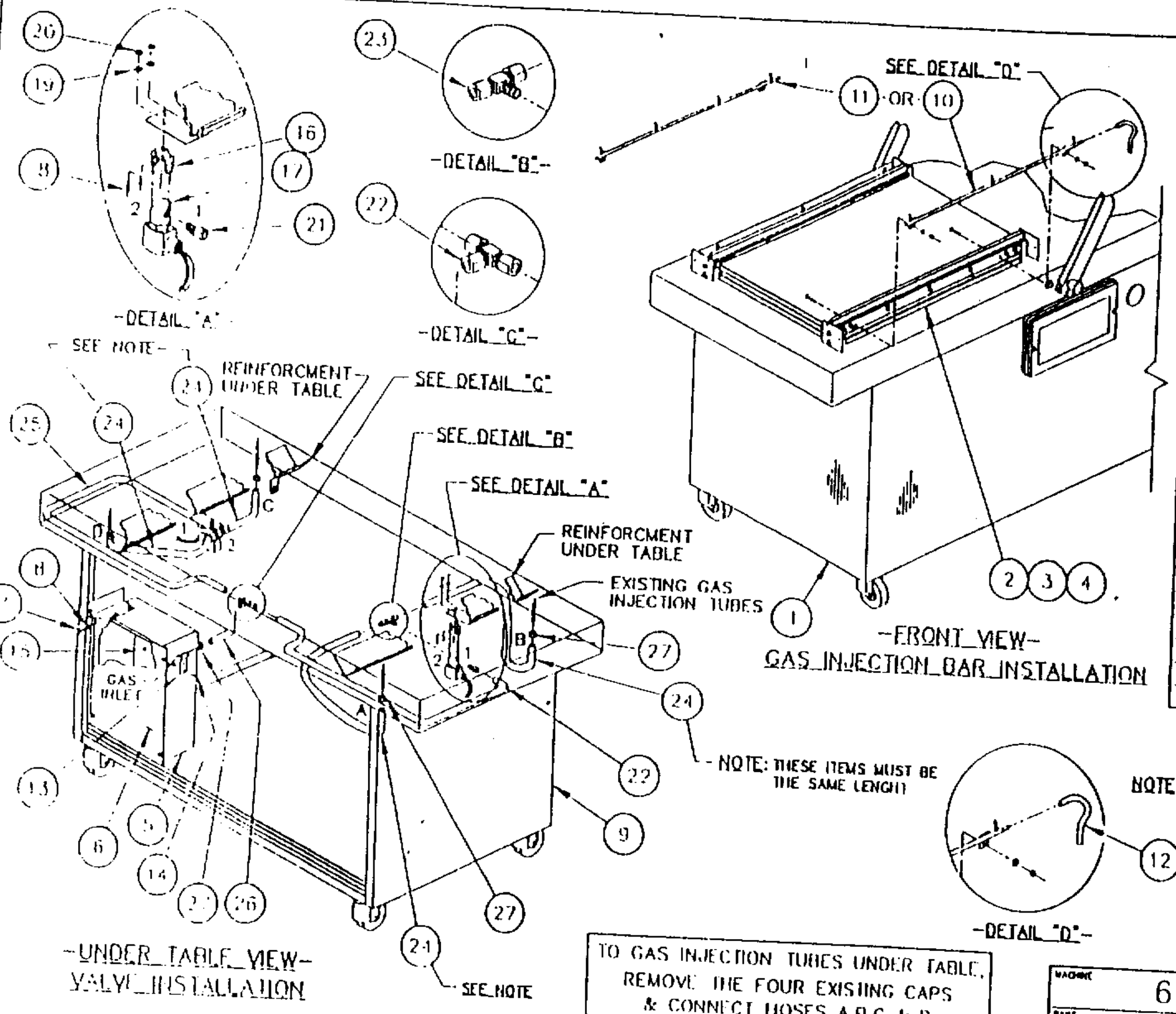
ITEM	PART #	DESCRIPTION	QT
1	002A0401	UPPER SEAL BAR	2
2	009-0029	TOP & BOTTOM SEAL CONNECTOR WELDED	4
3	052-0250	SCREW #8-32 NC. X 1 1/2" RND SLOT BRASS	4
4	051-0550	HEX. NUT #8-32 NC. S/S	8
5	027-0400	CONNECTOR ADAPTOR	4
6	002-0536	UPPER SEAL BAR SUPPORT	2
7	051-0232	SCREW 1/4"-20 NC X 1 1/4" CAP HEX SKT S/S	16
8	170-0003	UPPER SEAL BAR RUBBER 755mm	2
9	176-0200	TEFLON TAPE (5S) ADHESIVE 788mm	2
10	176-0220	TEFLON TAPE (10S) ADHESIVE 788mm	2
11	039-0220	SEALING ELEMENT 828mm	2
12	052-0385	SET SCREW 1/4"-20 NC. X 5/16" (OVAL POINT)	4
13	176-0220	TEFLON TAPE (10S) ADHESIVE 788mm	2
14	001A1594	UPPER TEFLON HOLDER	4
15	051-0121	SCREW #8-32 NC. X 1" FLAT PHIL. S/S	18
16	051-0550	HEX. NUT #8-32 NC. S/S	18

MACHINE: 620A	SETTING TOLERANCE: N.T.S.	SIPROMAC, ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PART: UPPER SEAL BAR ASS'Y W/ SUPPORT		
ITEM:	CHG:	SCALE: — QT. 2
MAT:	DWN: J.G. DATE: 98-08-22	NO. 005A0421
	APP:	

MODIFICATION	98-08-22 DATE	J.G. INIT.

005A0421

010-0018



ITEM	PART #	DESCRIPTION	QT.
1	005-0415	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0560	SEAL BAR ASS'Y W/ SUPPORT	4
3	005-0561	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	4
4	005-0562	SEAL BAR ASS'Y W/ SUPPORT (T & B OPT.)	4
5	005-0174	ELECTRICAL BOX ASSEMBLY	1
6	004-0279	ELECTRICAL BOX COVER PRE-ASS'Y	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4"ø S/S	4
9	005-0416	MACHINE ASSEMBLY REAR VIEW	1
10	005A0423	GAS 3 INJECTION BAR ASSEMBLY (OPTION)	4
11	005A0424	GAS 4 INJECTION BAR ASSEMBLY (OPTION)	4
12	008-0464	GAS INJECTION CONN. TUBE (OPTION)	4
13	005-0323	GAS INLET ASSEMBLY	1
14	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
15	051-0580	HEX. NUT 1/4"-20 NC. S/S (OPTION)	1
16	106-0345	VALVE SUPP. SUPPLIED W/ (17)	2
17	————	SELENOIDE VALVE 2 WAY 1/4" NPT	2
18	051-0100	SCREW #8-32 X 3/8" PAN PHILL. S/S	4
19	051-0720	FLAT WASHER #8 S/S	4
20	051-0550	HEX. NUT #8 S/S	4
21	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	2
22	101-0062	"T" 3/8" T.P.COMP.	1
23	101-0065	"T" 3/8" T.P.COMP. X 1/4" MNPT X 3/8" T.P.COMP	2
24	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) mm. LG.	4
25	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) mm. LG.	2
26	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) mm. LG.	1
27	105-0200	COLLARS 3/8"ø	5

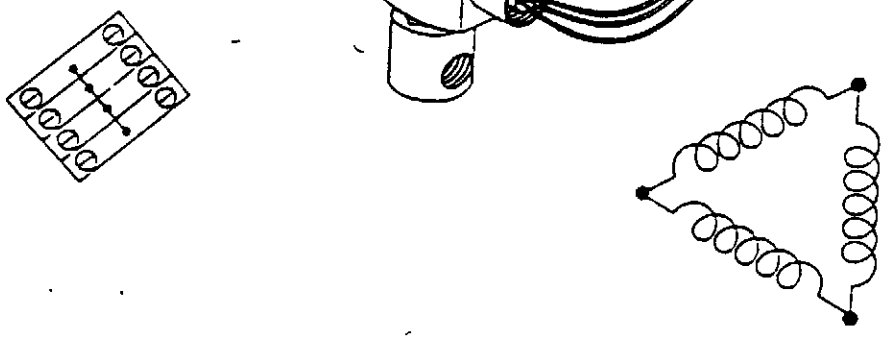
NOTE: PARTS (1) THRU (9) ARE EXISTING PARTS
PARTS (10) THRU (27) ARE PARTS SUPPLIED W/ KIT

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

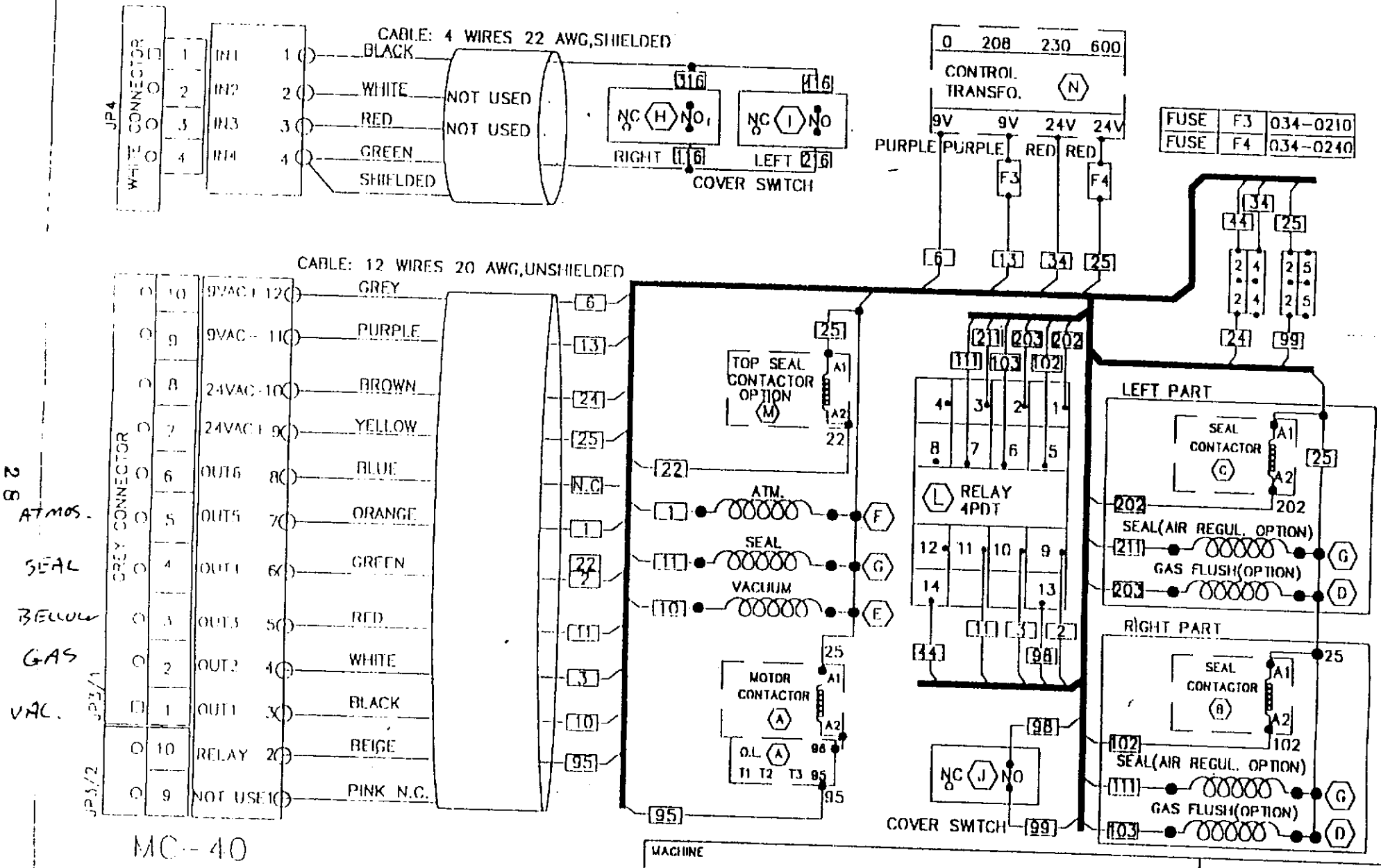
-OPTION GAS INJECTION-

MACHINE: 620A
PART: GAS INJECTION KIT INSTALLATION
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
N.T.S.
SH. 1
DWG. BY: A. PROVENCHER DATE 97-08-19
NO. 010-0018

REVISION: ... 97-10-30 A.P. DATE



ELECTRICAL DRAWING



ATMOS.

SEAL

BELLOW

GAS

VAC.

MC-40

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

MACHINE

VACUUM DOUBLE CHAMBER

LOW VOLTAGE WITH MC-40

MAT:

DESS. D.L.

APP.

DATE 5 MAY 1998

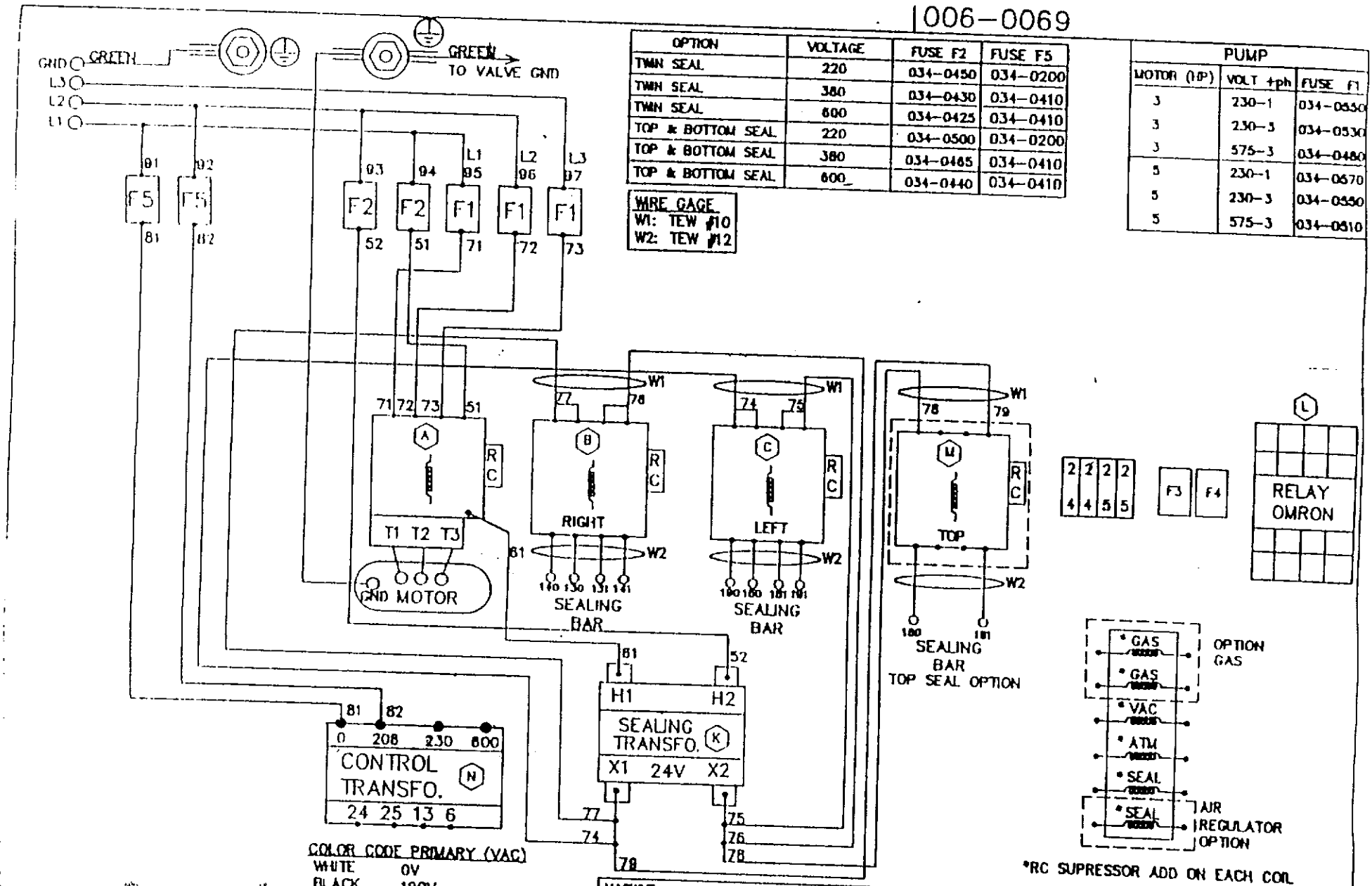
DATE

NO. 016 0118

SIPROMAC

ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

006-0069



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

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

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

COLOR CODE PRIMARY (VAC)

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

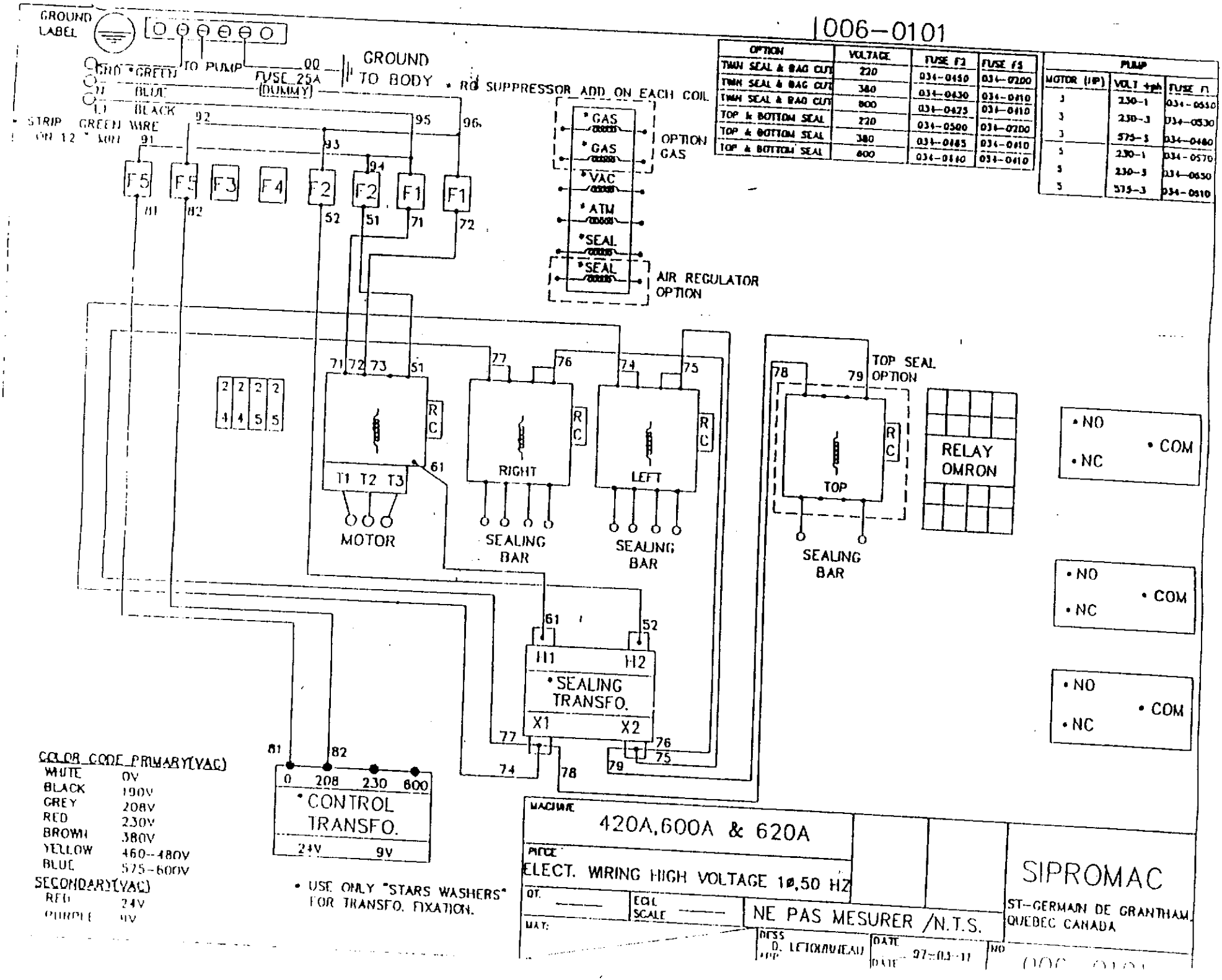
SECONDARY (VAC)

RED	24V
PURPLE	0V

MACHINE: 420A,600A & 620A
PIECE: ELECT. WIRING HIGH VOLTAGE 3ø
QTY. ____ SCALE ____
MAT.
DESS. D. LETOURNEAU
APP.
DATE 97-03-10
NO. 006-0069

SIPROMAC
ST-GERMAIN DE GRANTHAM,
QUEBEC CANADA

1006-0101



OPTION	VOLTAGE	FUSE F3	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 1ph	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	034-0650
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

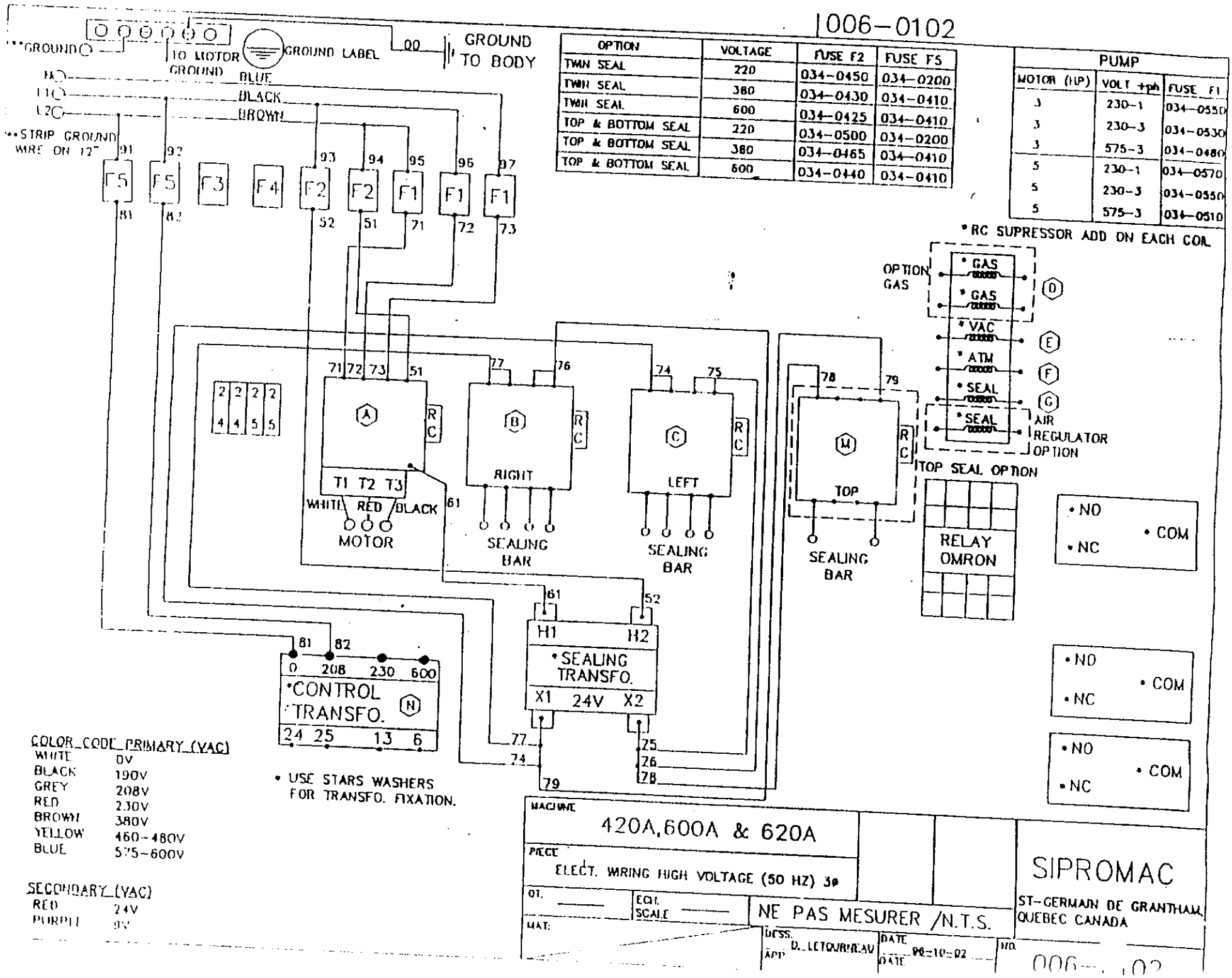
SECONDARY(VAC)

RED	24V
PURPLE	0V

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

MACHINE: 420A,600A & 620A		SIPROMAC
PIECE: ELECT. WIRING HIGH VOLTAGE 1Ø,50 HZ		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
QT. —— SCALE —— NE PAS MESURER /N.T.S.		
MAT:	DESS D. LETOURNEAU DATE 97-03-11	NO 1006-0101

006-0102



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

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

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	0V

MACHINE: 420A,600A & 620A

PIECE: ELECT. WIRING HIGH VOLTAGE (50 HZ) 3ø

QT. | ECH. SCALE: NE PAS MESURER /N.T.S.

MAT:

DESS. D. LETOURNEAU | DATE 98-10-02

APP. | DATE

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

NO. 006-0102

ELECTRICAL DRAWINGS PARTS LIST

A : VOLT	PHASE	PUMP HP	CONTACTOR	OVERLOAD
220	1	3	025-0040	025-0190
220	3	3	025-0020	025-0180
575	3	3	025-0010	025-0150
220	1	4	025-0050	025-0200
220	3	4	025-0030	025-0190
460	3	4	025-0010	025-0170
575	3	4	025-0010	025-0160
220	1	7.5	025-0070	025-0222
220	3	7.5	025-0040	025-0210
575	3	7.5	025-0010	025-0180
220	3	10	025-0060	025-0220
460	3	10	025-0030	025-0190
575	3	10	025-0020	025-0190

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

D: OPTIONAL GAZ SOLENOID VALVE: 106-0010

E: VACUUM SOLENOID VALVE: 106-0050

F: ATMOSPHERE SOLENOID VALVE: 106-0030 WITH PUMPS: 3HP & 4HP
106-0050 WITH PUMPS: 7.5 HP& 10 HP

G: BELLOWS SOLENOID VALVE: 106-0070

H, I, J: COVER SWITCH: 026-0610

K: SEALING TRANSFO

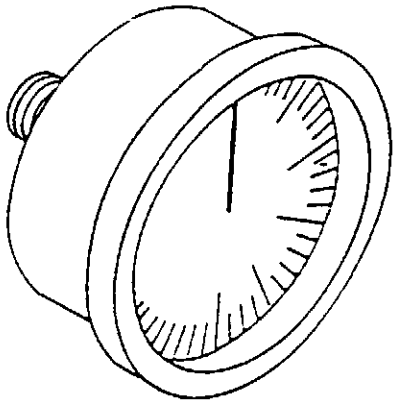
TWIN SEAL & B- CUT: 029-0040, 029-0050
TOP & BOTTOM EALING: 029-0080

L: RELAY & BASE:

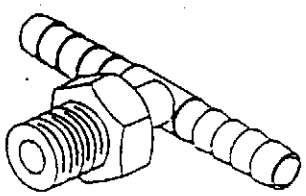
RELAY: 025-0600
BASE: 025-0610

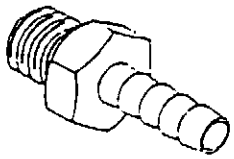
M: OPTIONAL TOP SEALING CONTACTOR 025-0020

N: CONTROL TRANSFO: 029-0007, 029-0008, 029-0009, 029-0250



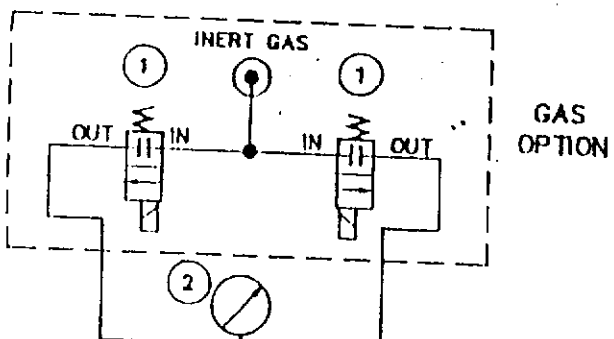
PNEUMATIC DRAWING

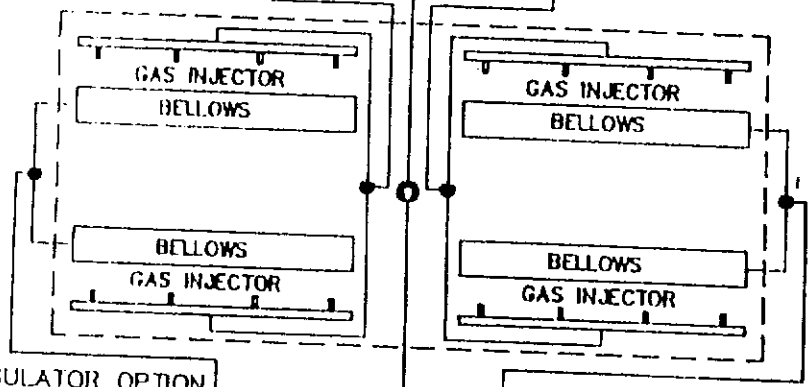


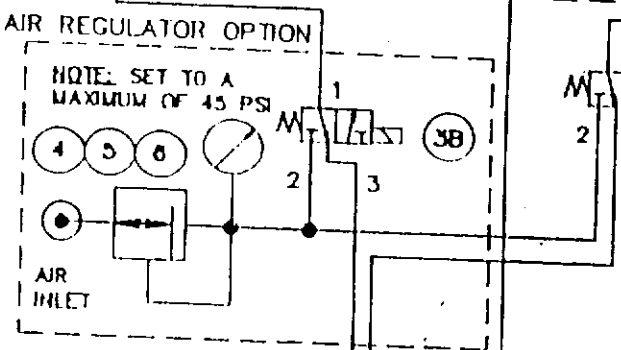


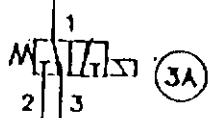
007-0019

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

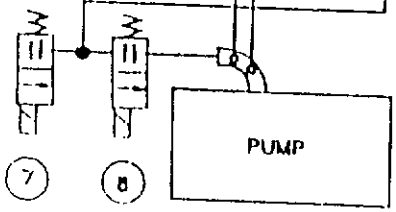






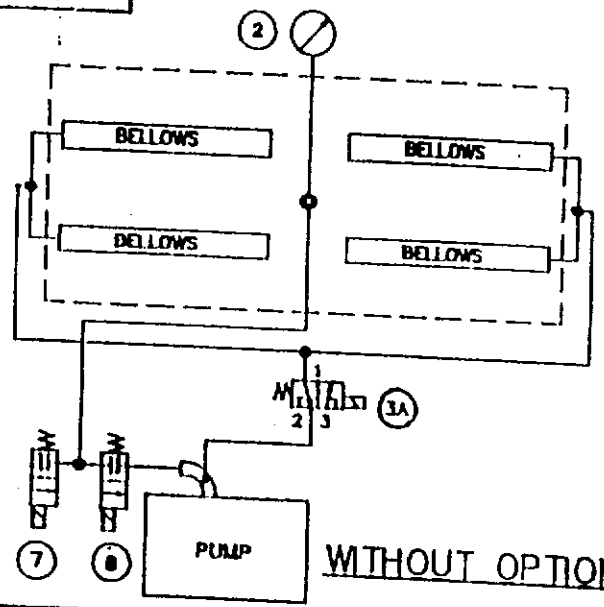


-NOTE:
-FOR AIR REGULATOR OPTION KIT INSTALLATION SEE DRAWINGS #: 010-0019 & 650A: #010-0027 (FOR EXISTING MACHINES)



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	144-0147	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, 063M³ AND 100 M³	
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A: 160 M³ AND 250 M³	
	106-0050	ATMOSPHERE VALVE FOR 650A & 700A	
8	106-0030	VACUUM VALVE FOR 420A	1
	106-0050	VACUUM VALVE FOR 600A & 620A	
	106-0060	VACUUM VALVE FOR 650A & 700A	
*: OPTION			



WITHOUT OPTION

A	RE-DRAWN	07-03-11	M.L.
LET.	MODIFICATION	DATE	INT.

MACHINE: 420A,600A,620A & 650A
PART: PNEUMATIC
ITEM:
MAT:
CNC:
DWG BY: M.LAVIGNE
APP.
DATE: 07-03-11
DATE
N.T.S.
SCALE
QT. 1
NO. 007-1019

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

United States Department of Agriculture

Food Safety and Inspection Service

Washington, D.C. 20250

March 16, 1994

Sipromac Inc.

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

Vacuum Packaging Machine, Model 620A

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

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

Sincerely,

Ronald M. Partyka

Ronald M. Partyka
Industrial Specialist
Equipment Branch
Facilities, Equipment and Sanitation Division
Science and Technology