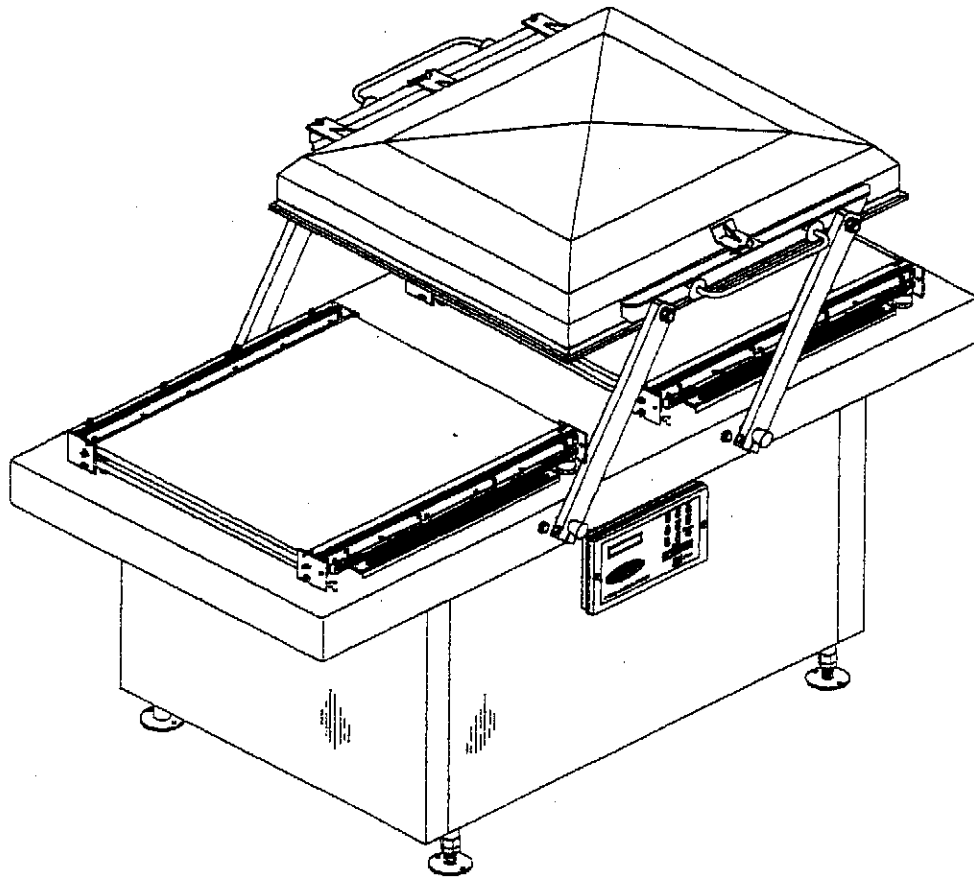


**MODEL
650A**



OWNERS MANUAL
(MANUEL D'UTILISATION)
(MANUAL DE UTILIZACIÓN)

Safe Operation Practices



This symbol points out important safety instructions which, if not followed, could endanger the personal safety and/or property of yourself and others. Read and follow all instructions in this manual before attempting to operate your vacuum machine. Failure to comply with these instructions may result in personal injury.

General Operation

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

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

Service

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

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

Warning-Your responsibility:

This machine should only be operated by personal who can read, understand and respect warnings and instruction regarding this machine in the owners manual.

VACUUM PACKAGING MACHINE

MODEL 650A

GENERAL TABLE OF CONTENTS

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II MECHANICAL

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- B- Rear view general assembly drawing
- C- Cover adjustment procedure
- D- Central shaft assembly drawing
- E- Seal bar assembly drawings
(twin seal)
- F- Seal bar assembly drawings
(electrical bag cut option)
- G- Seal bar assembly drawings
(top and bottom sealing option)
- H- Gas injection kit installation drawing
(gas injection option)

III ELECTRICAL

- A- Electrical drawing low voltage
- B- Electrical drawing high voltage 1 phase
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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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(bi-active sealing)
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 - 3.3 Setting of digital controls
 - 3.4 Daily cleaning
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 - 4.1 Failure during a packaging cycle
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 - 4.2.2 No leakage in the bag
 - 4.2.3 Insufficient vacuum in the chamber
 - 4.3 Faulty seal
 - 4.3.1 Insufficient seal
 - 4.3.2 No seal
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SIPROMAC INC.

VACUUM PACKAGING MACHINES

1. SETTING UP THE MACHINE:

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

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

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

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

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

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

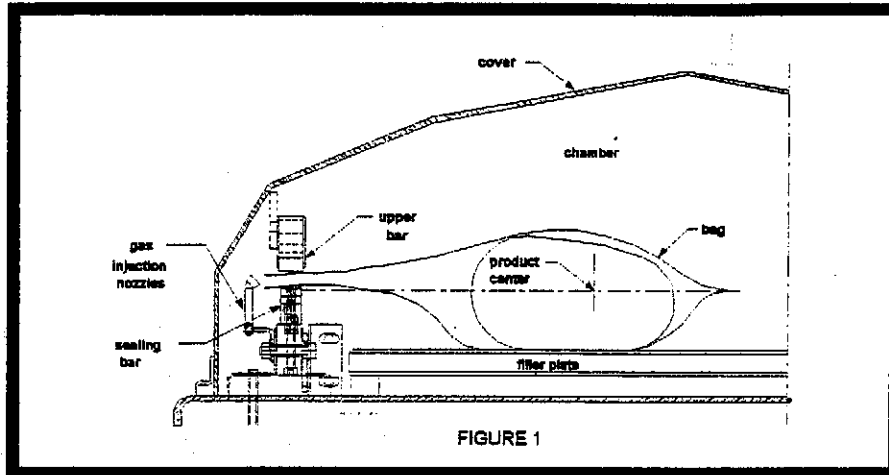
3. OPERATION:

3.1 Working principles:

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

To obtain nice packages, the products and the bags have to be of proportional sizes. The bag's opening should never exceed 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 (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 counterbalanced by inflating the bag with gas (nitrogen or carbon dioxide) before sealing after evacuation.

For gas flushing, the bags are placed on the sealing bars, the open end placed over the gas nozzles mounted alongside the sealing bar. After evacuation, the vacuum valve closes and the gas valve opens. Gas level can be set 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 approximately 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 until the desired character is selected (4 times for the numeric value). Use key "ENTER" to validate the character and to validate the characters string at the end (the new characters string is blinking). In a middle of an acquisition, use key "ESC" to come backward and erase one or several characters.

Example: EXAMPLE 1 → keys 2, 2, ENTER → E
(9 characters) keys 8, 8, 8, ENTER → X
keys 1, ENTER → A
keys 5, ENTER → M
keys 6, ENTER → P
keys 4, 4, 4, ENTER → L
keys 2, 2, ENTER → E
keys 9, 9, 9, ENTER → space
keys 1, 1, 1, 1, ENTER → 1
key ENTER to validate the characters string

3.3.3.2 Vacuum level setting:

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

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

3.3.3.3 Vacuum plus time setting:

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

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

-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)

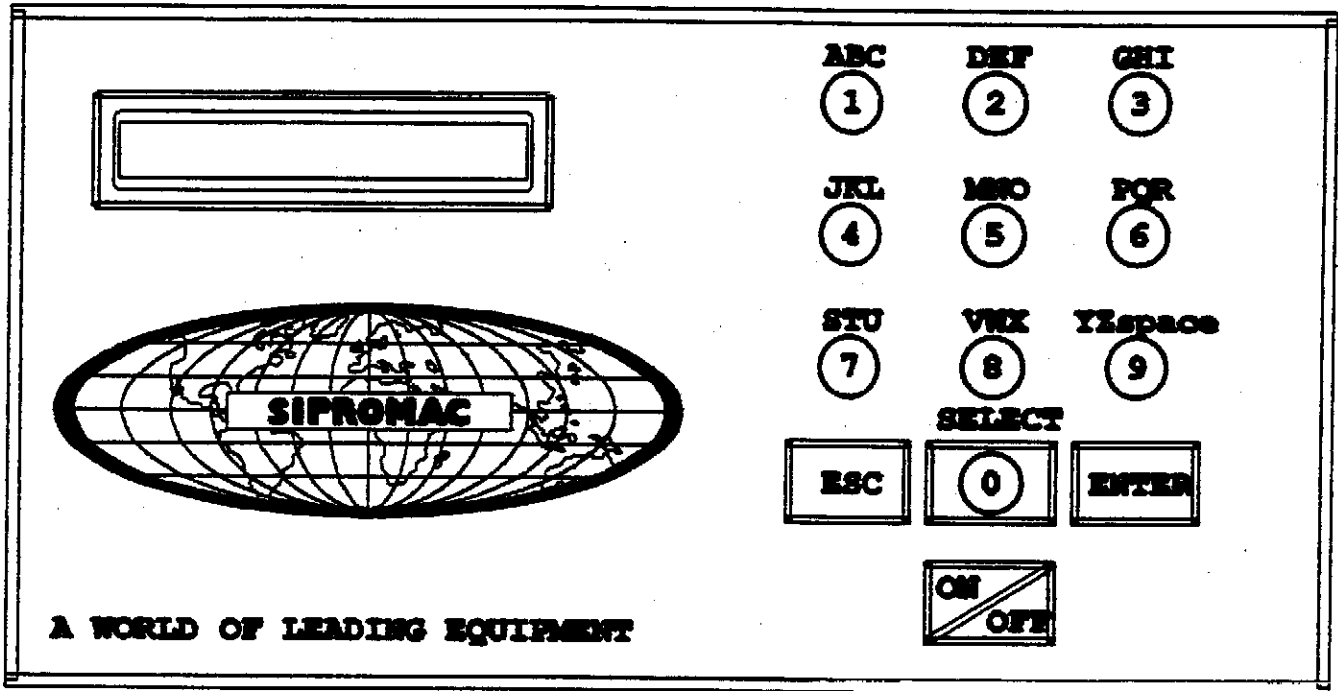
"SYSTEM MONITOR" (no access code required)

"SOFTWARE: R x.xx"

"WORK HRS: xxxxxx"

"CYCLES: xxxxxxxx"

-KEYBOARD DETAILS-



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

3.4 Daily cleaning:

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

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "VACUUM ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

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

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

4.1.3 "ATMOSPHERE ERROR" message is displayed on LCD:

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

- Check vacuum lines for potential leaks or kinks.

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

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

- Check limit switch adjustment.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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

4.2.2 No leakage in the bag:

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

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

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

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

Verify at vacuum hose connections and valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactors does not work.

4.3.3 Permanent sealing current:

Contactors is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

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

4.5 MC40 Control board failure

NOTE: Refer to menu structure on page 8.

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

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

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

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

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

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

Check vacuum connections for tightness.

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

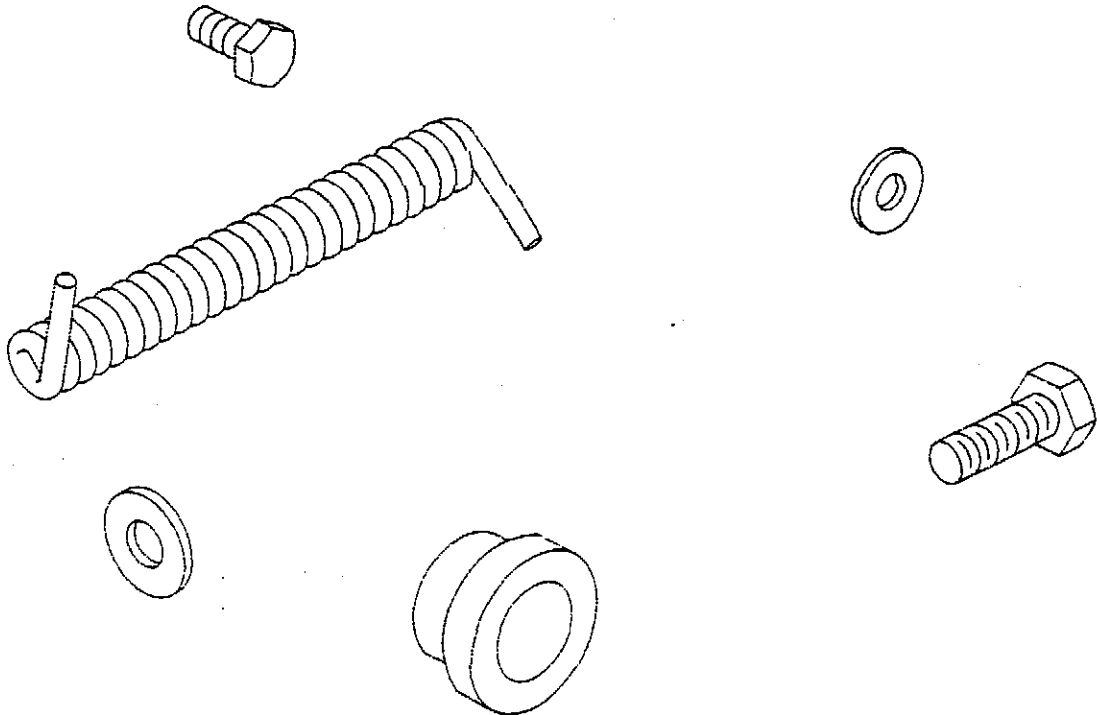
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

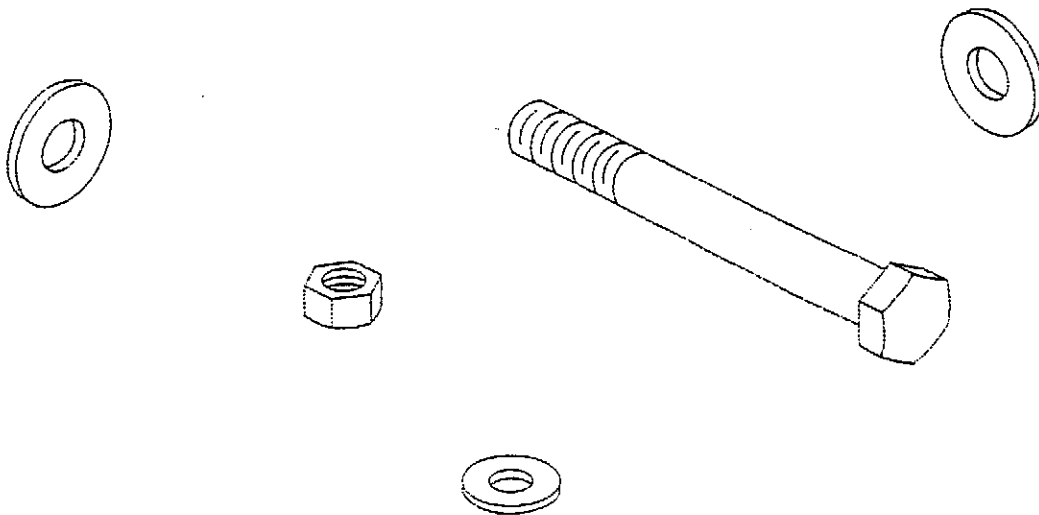
INSTALLATION NOTICE FOR MODELS: 420A, 450T, 450A, 550A, 600A, 620A, 650A AND 700A

IN ORDER TO RESPECT NSF REGULATIONS:

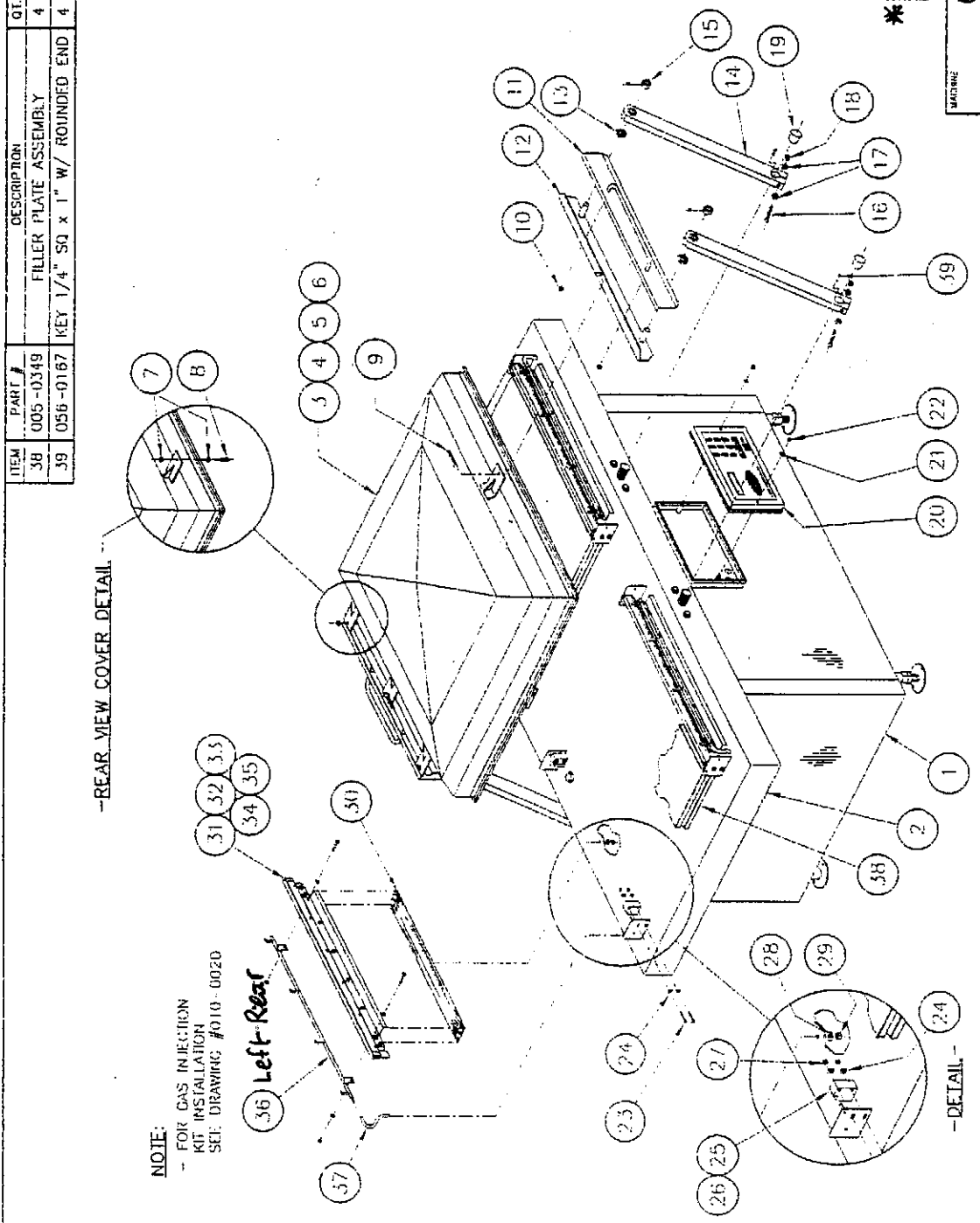
NOTE: A PLASTIC CAP IS INSTALLED ON THE TABLE TOP VACUUM INLET USED FOR LEANING PURPOSES ONLY AND IS TO BE REMOVED PRIOR TO OPERATING THE MACHINE.



MECHANICAL DRAWING



ITEM	PART #	DESCRIPTION	QTY
38	005-0349	FILLER PLATE ASSEMBLY	4
39	056-0167	KEY 1/4" SQ x 1" W/ ROUNDED END	4
1	005-0465	BODY ASSEMBLY	1
2	004B0137	CENTRAL SHAFT ASSEMBLY	1
3	005-0469	8" COVER ASSEMBLY (OPT.)	1
4	005-0470	12" COVER ASSEMBLY	1
5	005-0477	8" COVER ASSY (M.B.C. OR M.B.C.I.B.S) (OPT.)	1
6	005-0478	12" COVER ASSY (M.B.C. OR M.B.C.I.B.S) (OPT.)	1
7	051-0600	HEX. NUT 5/16" - 18 NC. S/S	4
8	051-0305	HEX. BOLT 5/16" - 18 NC. X 1" S/S	2
9	056-0125	HITCH PIN CLIP	2
10	051-0630	HEX. NUT 1/2" - 13 NC. S/S	4
11	004-0213	COVER HANDLE ASSEMBLY	2
12	005-0359	ARM SUPPORT	2
13	008-0368	SPACER	4
14	004A0383	COVER ARM ASSEMBLY	4
15	105-0430	COLLARS W/ 5/16" - 18 NC. SELF SCREW	4
16	051-0422	HEX. BOLT 3/8" - 16 NC. X 3 1/4" S/S	4
17	051-0783	FLAT WASHER (THICK) 3/8" S/S	8
18	051-0622	HEX. NUT 3/8" - 16 NC. NYLON LOCK S/S	4
19	057-0013	SHAFT END CAP	4
20	005-0563	P.C. BOARD SUPPORT ASSEMBLY	1
21	052-2045	FLAT WASHER 1/4" COPPER	2
22	051-0591	ACORN NUT 1/4" - 20 NC. S/S	2
23	051-0250	HEX. BOLT 1/4" - 20 NC. X 1 1/2" S/S	16
24	051-0740	FLAT WASHER 1/4" S/S	32
25	002-0326	LEFT/ SEAL BAR GUIDE BLOCK	4
26	002-0327	RIGHT/ SEAL BAR GUIDE BLOCK	4
27	051-0581	HEX. NUT 1/4" - 20 NC. NYLON LOCK S/S	16
28	051-0780	FLAT WASHER 3/8" S/S	4
29	051-0620	HEX. NUT 3/8" - 16 NC. S/S	4
30	005-0391	BELLOWS ASSEMBLY	4
31	005A0547	SEAL BAR ASSY W/ SUPPORT	4
32	005A0548	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPT.)	4
33	005A0549	SEAL BAR ASSY W/ SUPPORT (TOP & BOTTOM OPT.)	4
34	005A0550	SEAL BAR ASSY W/ SUPPORT (M.B.C.) (OPT.)	4
35	005A0551	SEAL BAR ASSY W/ SUPPORT (M.B.C.I.B.S) (OPT.)	4
36	005A0350	GAS INJECTION BAR ASSEMBLY	4
37	008-0464	GAS INJECTION CONNECTION TUBE	4



NOTE:
 - FOR GAS INJECTION
 KIT INSTALLATION
 SEE DRAWING #010-0020

* When ordering bar injection
 for replacement specify
 location on the table

650A

MACHINE: MACHINI ASSEMBLY FRONT VIEW

SCALE: 1"

DATE: 00-02-09

NO: 005A0352

SYLVAIN L. DATE: 00-02-09

APP: [Signature]

Q.T. 1

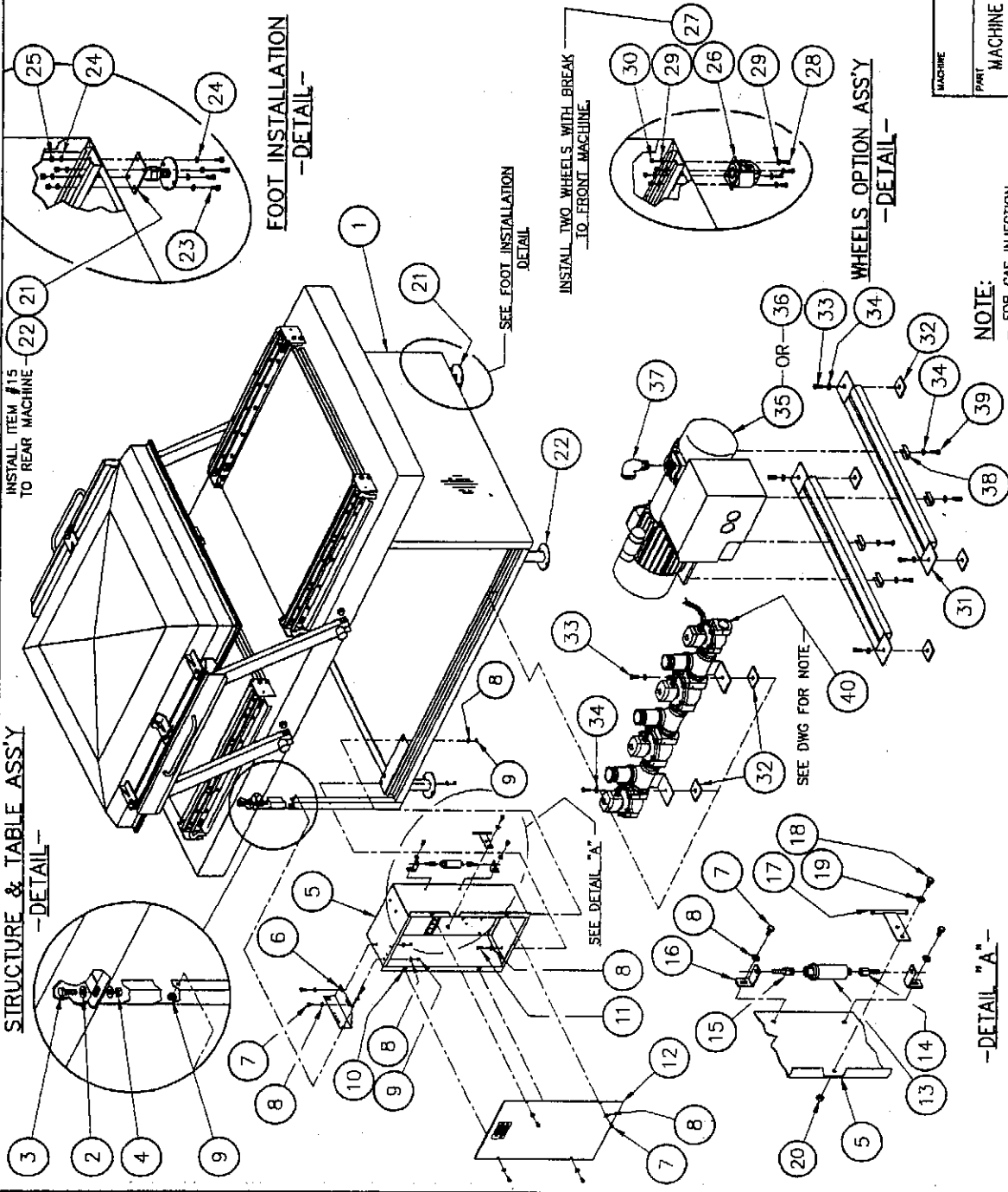
SIPROMAC

117 - GERMAN DE GRUYTHAM
 QUEBEC CANADA

DATE	00-02-09
SCALE	1"
NO.	005A0352

005A0353

ITEM	PART #	DESCRIPTION	QTY.
1	005A0352	MACHINE ASSEMBLY FRONT VIEW	1
2	051-0783	FLAT WASHER 3/8" (THICK) S/S	12
3	051-0360	HEX. BOLT 3/8"-16 NC. X 1" S/S	6
4	051-0820	HEX. NUT 3/8"-16 NC.	6
5	005-0374	ELECTRICAL BOX ASSEMBLY	1
6	001-1364	LEFT/ ELECTRICAL BOX UPPER SUPPORT	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	8
8	051-0740	FLAT WASHER 1/4" S/S	12
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	3
10	056-0020	SPRING NUT 1/4"-20 NC STEEL	4
11	051-0190	HEX. BOLT 1/4"-20 NC. X 3/4" S/S	2
12	004-0464	ELECTRICAL BOX COVER ASSY	1
13	114-2020	DRYER FILTER	1
14	101-0210	STRAIGHT 1/4" FNPT X 1/4" HOSE	1
15	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
16	001-2062	DRYER SUPPORT	2
17	005-0323	GAS INLET ASSEMBLY (OPTION)	1
18	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
19	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
20	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S (OPTION)	1
21	005-0361	FRONT LEGS ASSEMBLY	2
22	005-0362	REAR LEGS ASSEMBLY	2
23	051-0300	HEX. BOLT 5/16"-18 NC. X 3/4" S/S	16
24	051-0760	FLAT WASHER 5/16" S/S	32
25	051-0600	HEX. NUT 5/16"-18 NC. S/S	16
26	130-5HPB	WHEEL W/ O BRAKES (OPT.)	2
27	130-5PHD	WHEEL W/ O BRAKES (OPT.)	2
28	052-0520	HEX. BOLT 5/16"-18 NC. X 3/4" ZINC (OPT.)	16
29	052-2150	FLAT WASHER 5/16" ZINC (OPT.)	32
30	052-3110	HEX. NUT 5/16"-18 NC. ZINC (OPT.)	16
31	005-0354	PUMP SUPPORT ASSEMBLY	2
32	005-0088	PUMP SUPPORT PLATE ASSY	6
33	051-0350	HEX. BOLT 3/8"-16 NC. X 3/4" S/S	6
34	051-0780	FLAT WASHER 3/8" S/S	10
35	125-	PUMP 160 M ³	1
36	125-	PUMP 250 M ³ (OPTION)	1
37	103-0085	ELBOW STREET 2" NPT ZINC	1
38	001-0199	SUPPORT	4
39	052-4240	HEX. BOLT M10 X 30 ZINC	4
40	004-0505	VACUUM / ATMOSPHERE VALVE ASSY	1



MACHINE: 650A

PART: MACHINE ASSEMBLY REAR VIEW

ITEM: 005A0353

DATE: 00-03-22

SCALE: 1/1

SYLVAIN L. DATE: 00-03-22

ST-GERMAIN DE GRANTHAM QUEBEC CANADA

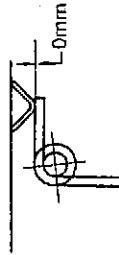
SIPROMAC

LET.	REDRAWN	MODIFICATION	DATE	S/L	INT.
			00-03-22		

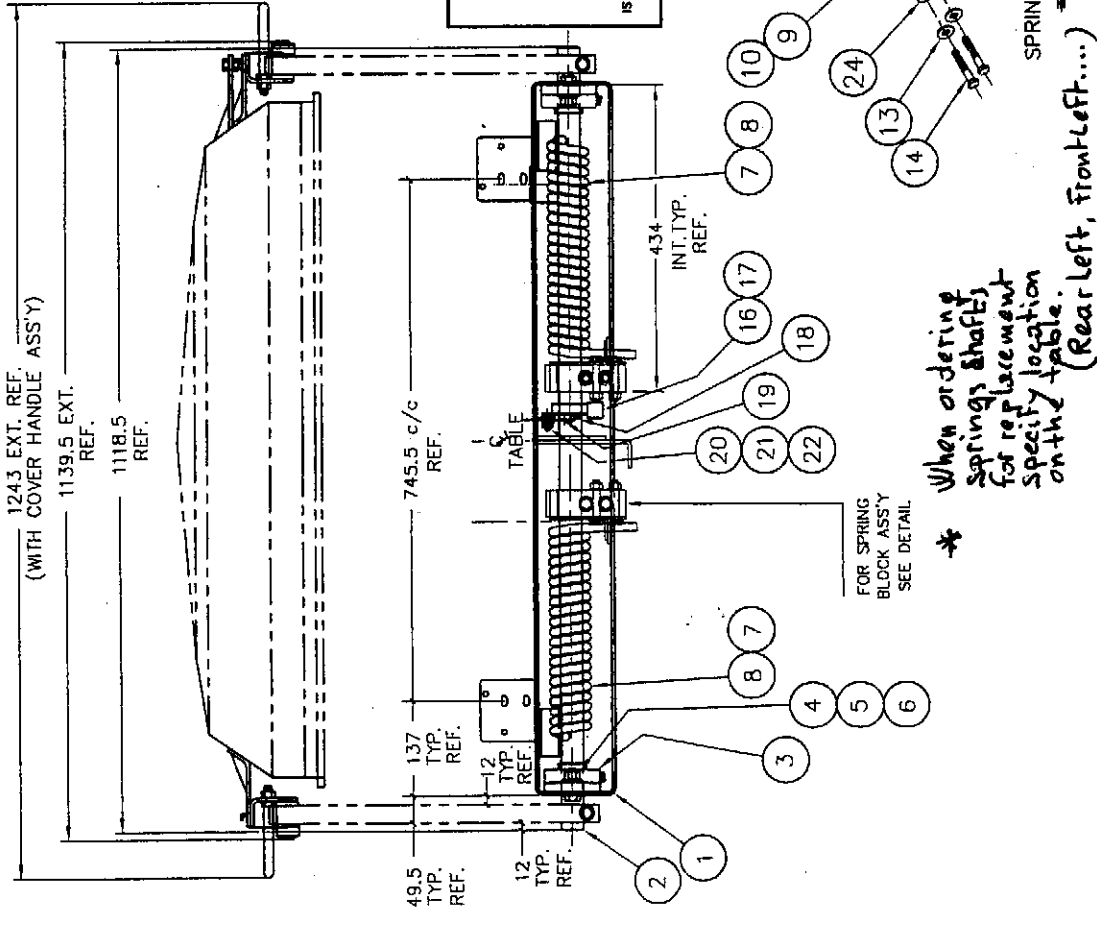
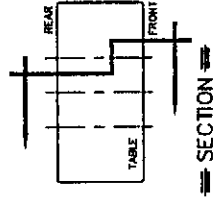
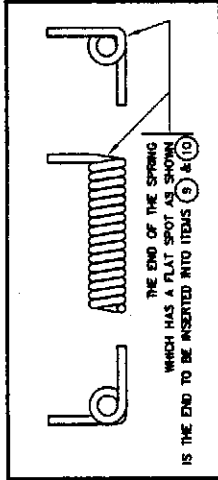
ITEM	PART #	DESCRIPTION	QTY
1	005A0355	TABLE ASSEMBLY	1
2	009A0056	CENTRAL SHAFT	2
3	075-1650	FLANGED BEARING W/ GREASE FITTING 90°	4
4	051-0441	HEX.BOLT 1/2"-13 x 1 1/2" S.S.	8
5	051-0630	HEX.NUT 1/2"-13 S.S.	8
6	051-0790	FLAT WASHER 1/2" S.S.	8
7	008-0589	LEFT COVER SPRING	2
8	008-0590	RIGHT COVER SPRING	2
9	004A0222	LEFT SPRING SUPPORT ASS'Y	2
10	004A0170	RIGHT SPRING SUPPORT ASS'Y	2
11	002A0319	SPRING BLOCK	4
12	052-0777	HEX.BOLT 3/8"-24 x 3" ZINC	8
13	052-2060	FLAT WASHER 3/8" ZINC	36
14	052-0775	HEX.BOLT 3/8"-24 x 2 1/2" ZINC	8
15	052-3128	HEX.NUT 3/8"-24 ZINC	16
16	005-0154	MICRO-SWITCH COLLAR	1
17	051-0334	SET SCREW 3/8"-16 x 3/8" S.S.	2
18	026-0610	MICRO-SWITCH	2
19	001-1294	MICRO-SWITCH FIXATION PLATE	2
20	051-0180	HEX.BOLT 1/4"-20 x 1 1/2" S.S.	2
21	051-0740	FLAT WASHER 1/4" S.S.	4
22	051-0580	HEX.NUT 1/4"-20 S.S.	2
23	056-0168	KEY 1/4" S0 x 1 1/2" W/ ROUNDED END	4
24	052-2071	CONTACT WASHER 3/8" STEEL	8

SPRING ADJUSTMENT PROCEDURE

- A-- PLACE COVER UP(ARM VERTICAL) TO FREE TENSION OF SPRINGS.
- B-- LOOSEN BOLTS ITEMS (14) ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y (ITEMS 9 & 11).
- C-- TURN SPRING/BLOCK ASSEMBLY TO OBTAIN 0mm (0") AS SHOWN BELOW.
- D-- RETIGHTEN BOLTS ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y.(ITEMS 12).

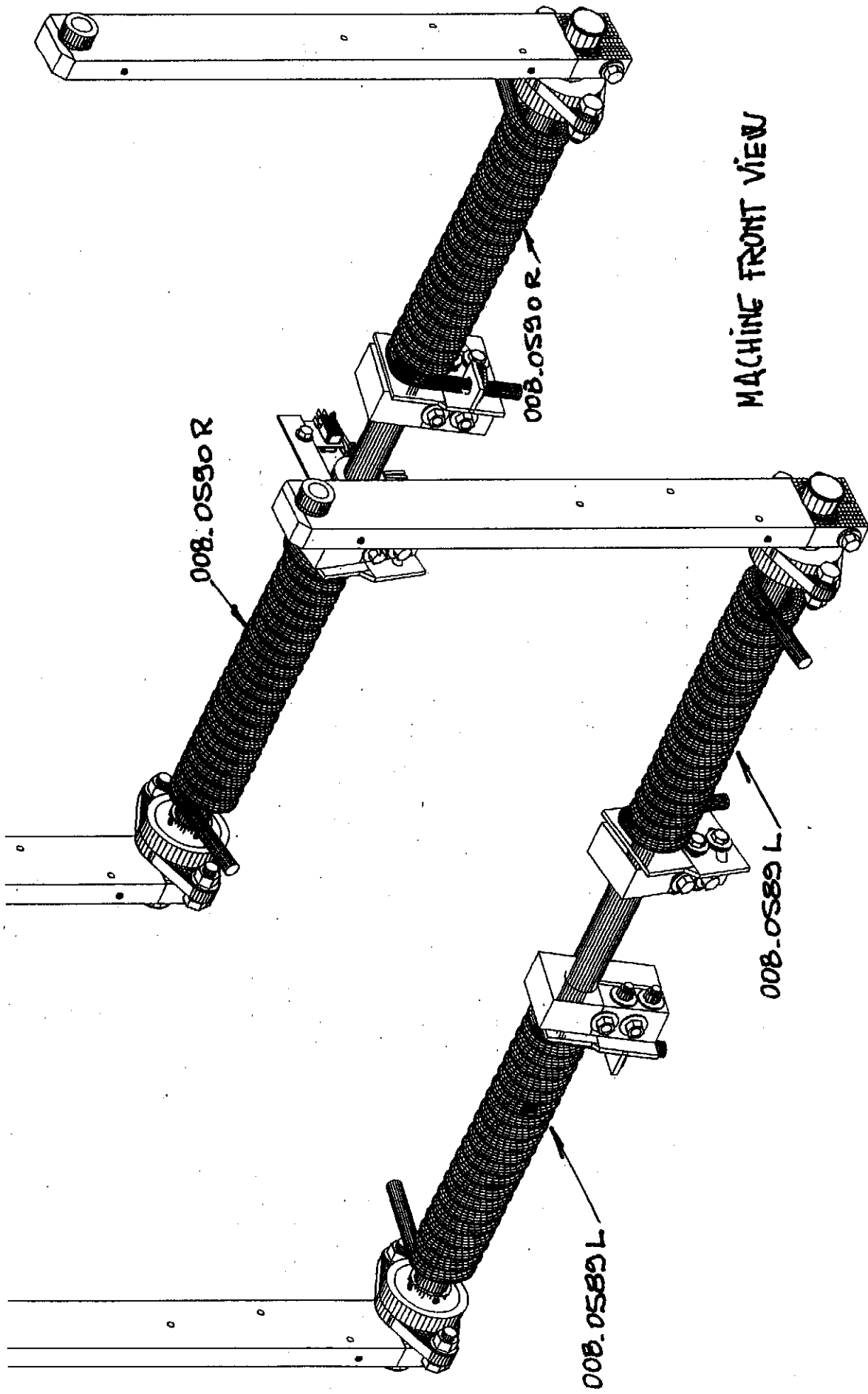


D-- RETIGHTEN BOLTS ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y.(ITEMS 12).



MACHINE	650A	INCH READING	0.005	DATE	00-02-09
PART	CENTRAL SHAFT ASSEMBLY	METRIC READING	0.025	SCALE	1
ITEM		ANGLE S.Y.	N.T.S.	NO.	004B0137
MAT.		DATE			

LET.	REDRAWN	MODIFICATION	DATE	S.L.	INT.
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MACHINE FRONT VIEW

650-680-700 A

CENTRAL SHAFT ASSEMBLY

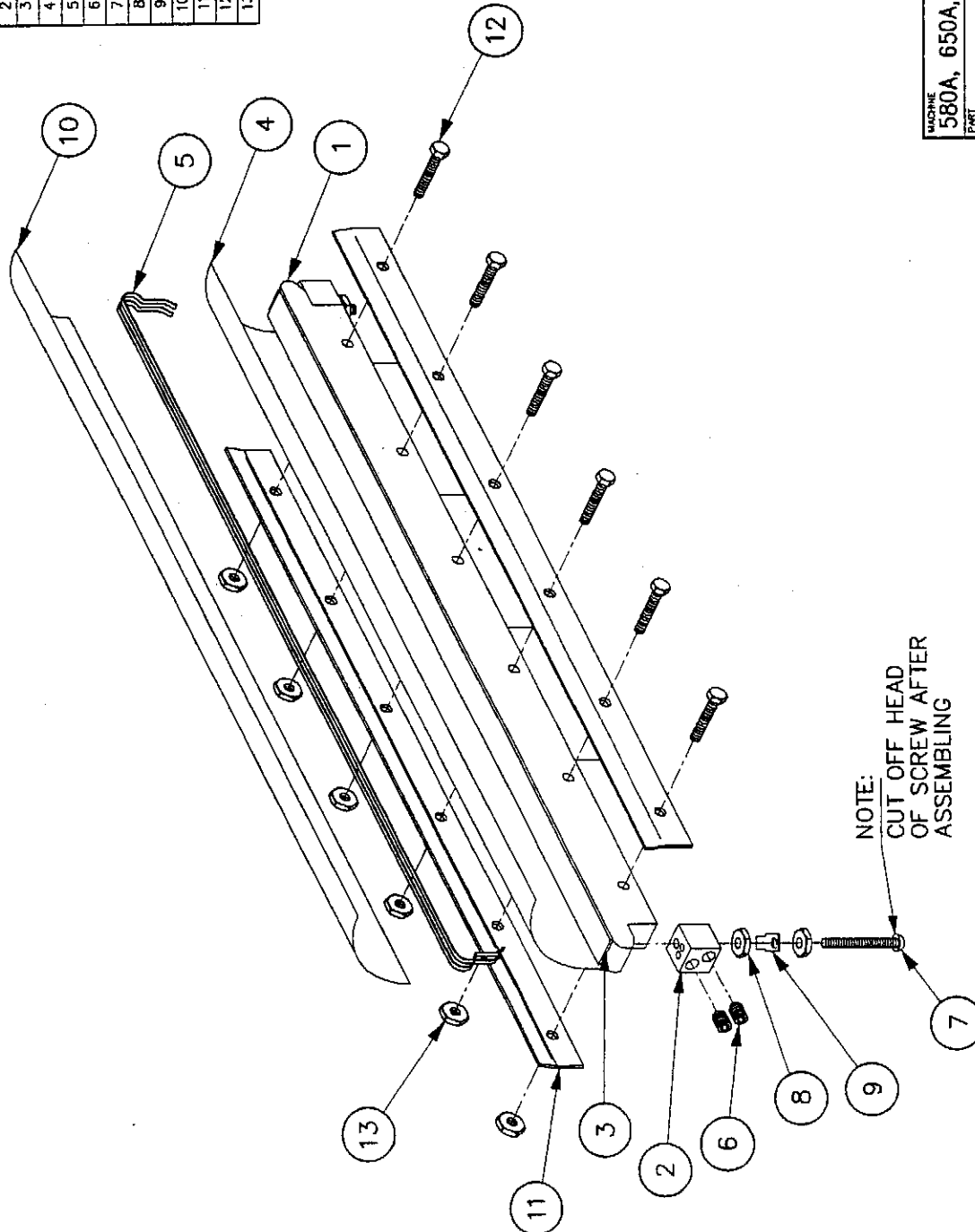
008.0590 R

008.0590 R

008.0589 L

008.0589 L

ITEM	PART #	DESCRIPTION	QTY.
1	002-0332	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	2
3	179-0003	SILICONE 2mm x 15mm ADHESIVE (862mm EA.)	0.890
4	178-0220	TEFLON TAPE (10S) ADHESIVE (862mm EA.)	0.109
5	039-0230	REFLEX BAND 2.5MM (2 x 992mm EA.)	0.208
6	052-0395	SET SCREW 1/4" - 20 x 5/16" (OVAL POINT)	4
7	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
8	051-0550	NUT #8-32 S/S	4
9	027-0400	CONNECTOR ADAPTOR	2
10	176-0200	TEFLON TAPE (5S) ADHESIVE (862mm EA.)	0.109
11	001-0266	TEFLON HOLD DOWN PLATE	2
12	051-0147	SCREW #10-24 x 1" HEX. S/S	6
13	051-0571	HEX. NUT #10-24 S.S.	6



NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

MACHINE	QTY
700A	4
680A	4
650A	4
580A	2
MACHINE	

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

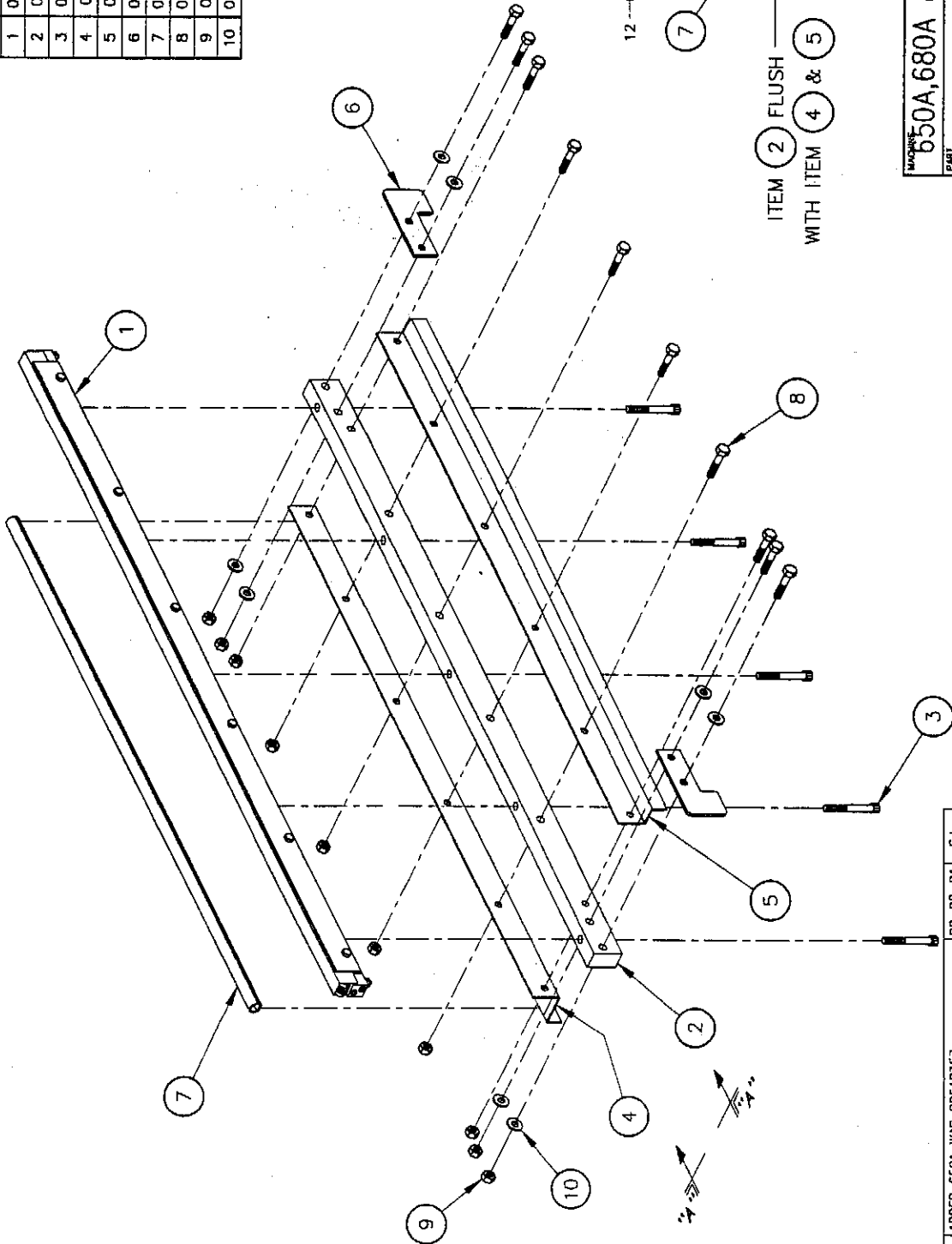
INCH TOLERANCE:
0.005 ± 0.005
0.010 ± 0.010
0.015 ± 0.015
0.020 ± 0.020
0.030 ± 0.030
0.050 ± 0.050
0.100 ± 0.100
N.T.S.

DATE: 95-12-29
APPROVED: [Signature]
PART: SEAL BAR PRE-ASSEMBLY

ITEM: _____
MAT: _____
QTY: _____
SEE LIST: 004-0254

LET.	MODIFICATION	DATE	A.P.	INT.
B	ITEM NO. 5 WAS 039-0200/ MODIF. A-0202	97-05-08	A.P.	
A	ADDED 580A/ADDED LIST	97-04-02	A.P.	

ITEM	PART #	DESCRIPTION	QT.
1	004-0254	SEAL BAR PRE-ASSY (TWIN SEAL)	4
2	002A0357	SEAL BAR SUPPORT	4
3	051-0251	CAP HEX. SKT BOLT 1/4"-20 NC. X 1 1/2" S/S	20
4	001A1901	EXTERIOR BELLOW COVER	4
5	001A1900	INTERIOR BELLOW COVER	4
6	001-0269	SEAL BAR GUIDE	8
7	036-0230	WRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 600)	4
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	40
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	40
10	051-0740	FLAT WASHER 1/4" S/S	32

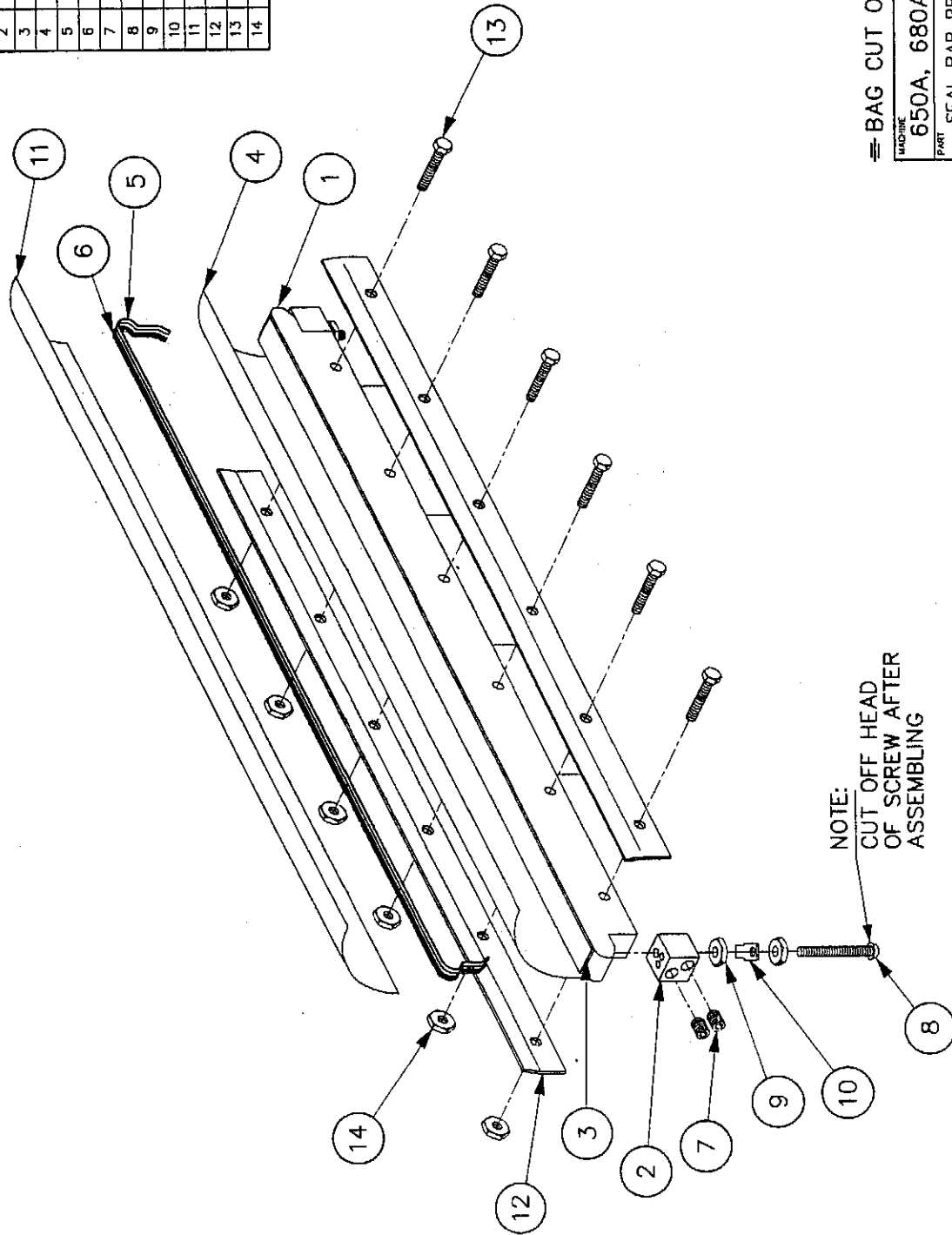


VIEW "A-A"

METRIC TOLERANCE DIM ± .015 DIA ± .003 ANG ± .0005 N.T.S.		INCH TOLERANCE DIM ± .015 DIA ± .003 ANG ± .0005 N.T.S.	
MACHINE: 650A, 680A & 700A PART: SEAL BAR ASSY W/ SUPPORT		SIPROMAC ST-CERMAIN DE GRANTHAM QUEBEC CANADA	
DATE: 98-03-09	BY: A. PROVENCEN	SCALE: 1:1	QT: 4
MODIFICATION D: ADDED 650A WAS 005A0357 C: 40 BOLTS #051-0230 WAS 24 REMOVE BOLTS #051-0250/MODIF. #A-0263 B: REDRAWN/ MODIF. NO. A-0245		005A0547	

LET.	MODIFICATION	DATE	INT.
D	ADDED 650A WAS 005A0357	00-02-01	S.L.
C	40 BOLTS #051-0230 WAS 24	98-05-14	L.M.
B	REMOVED BOLTS #051-0250/MODIF. #A-0263	98-03-09	A.P.

ITEM	PART #	DESCRIPTION	QTY.
1	002-0332	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	2
3	179-0003	SILICONE 2mm x 15mm ADHESIVE (852mm EA.)	0.890
4	176-0220	TEFLON TAPE (10S) ADHESIVE (862mm EA.)	0.109
5	039-0230	REFLEX BAND 2.5MM (992MM EA.)	0.104
6	039-0270	"T" PROFILE CUT. ELEM. (992MM EA.)	0.104
7	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	4
8	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
9	051-0550	NUT #8-32 S/S	4
10	027-0400	CONNECTOR ADAPTOR	2
11	176-0200	TEFLON TAPE (SS) ADHESIVE (862 mm EA.)	0.109
12	001-0266	TEFLON HOLD DOWN PLATE	2
13	051-0147	SCREW #10-24 x 1" HEX. S/S	6
14	051-0571	HEX. NUT #10-24 S.S.	6



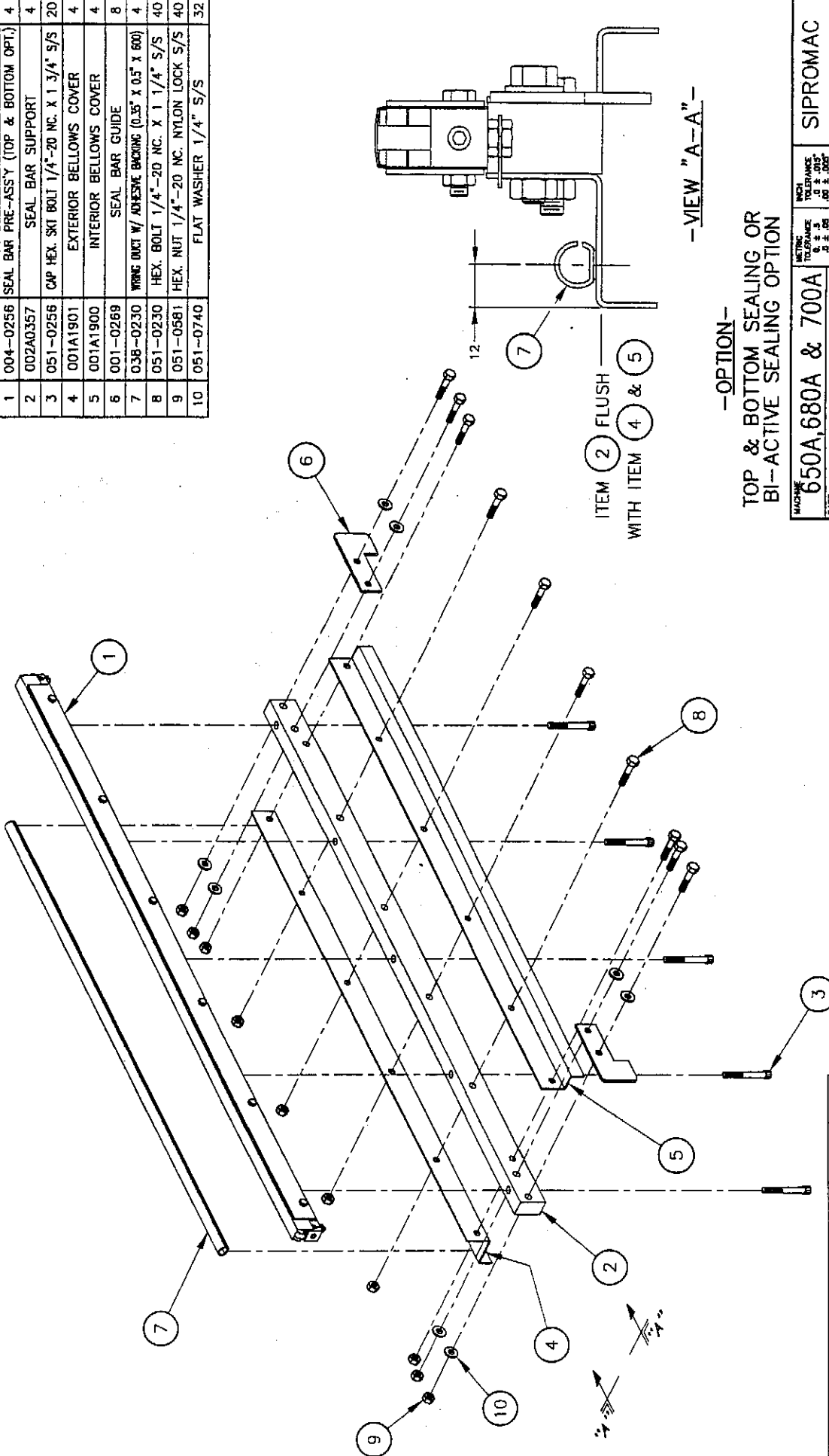
NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

≡ BAG CUT OPTION ≡

MACHINE 650A, 680A & 700A		SIPROMAC	
PART SEAL BAR PRE-ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	CNC:	BRNEM:	LOT: 4
DATE: 96-12-31	DATE: 96-12-31	DATE: 96-12-31	DATE: 96-12-31
BY: A. PROMENGER	DATE:	DATE:	DATE:
NO. 004-0255			

A	REDRAWN	MODIFICATION	DATE	INT.
LET				

ITEM	PART #	DESCRIPTION	QT.
1	004-0256	SEAL BAR PRE-ASSY (TOP & BOTTOM OPT.)	4
2	002A0357	SEAL BAR SUPPORT	4
3	051-0256	CAP HEX. SKT BOLT 1/4"-20 NC. X 1 3/4" S/S	20
4	001A1901	EXTERIOR BELLOWS COVER	4
5	001A1900	INTERIOR BELLOWS COVER	4
6	001-0269	SEAL BAR GUIDE	8
7	038-0230	WING NUT W/ ADHESIVE BACKING (0.35" X 0.5" X 600)	4
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	40
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	40
10	051-0740	FLAT WASHER 1/4" S/S	32



ITEM 2 FLUSH WITH ITEM 4 & 5

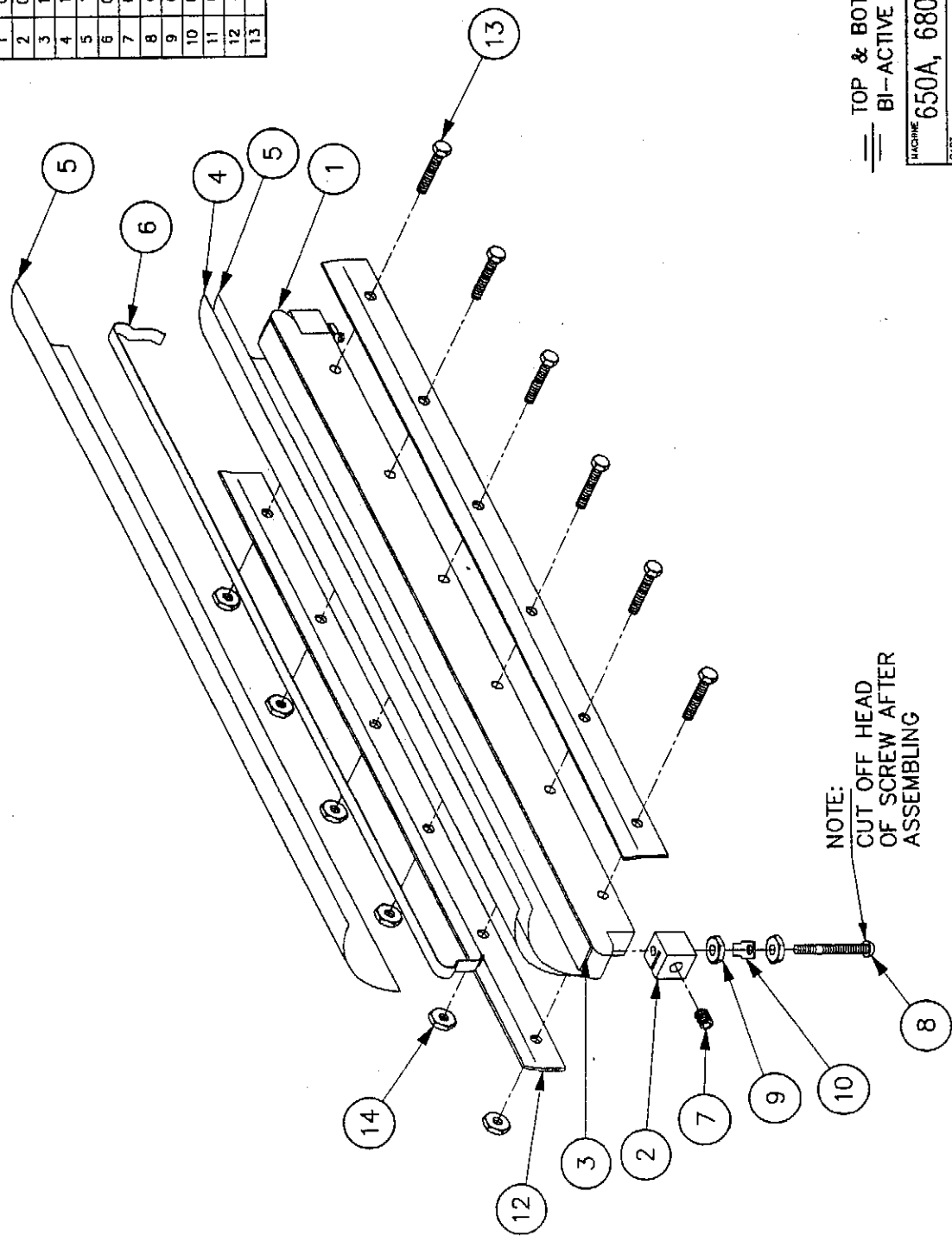
-VIEW "A-A"-

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

MACHINE	650A, 680A & 700A	SCALE	1" = 4"
PART	SEAL BAR ASSY W/ SUPPORT	DATE	98-03-11
ITEM		DATE	
MAINT		DATE	
INC: BY: A. PROMECHER		NO. 4	
MFG: ST-GERMAN DE GRANITHAM QUEBEC CANADA		005A0549	

REV.	DESCRIPTION	DATE	INT.
D	ADDED 650A WAS D05A0369	00-02-01	S.L.
C	40 BOLTS #051-0230 WAS 24	98-05-14	L.M.
	REMOVE BOLTS #051-0250/MODIF. #A-0263		
B	REDRAWN / MODIF. NO. A-0245	98-03-11	A.P.
LET.	MODIFICATION		

ITEM	PART #	DESCRIPTION	QT.
1	002-0332	SEAL BAR (TABLE)	1
2	009-0029	CONNECTOR	2
3	179-0003	SILICONE 2mm x 15mm ADHESIVE (852mm EA.)	0.890
4	176-0220	TEFLON TAPE (105) ADHESIVE (862mm EA.)	0.109
5	176-0200	TEFLON TAPE (55) ADHESIVE (2 x 862mm)	0.218
6	039-0220	BI-ACTIVE SEALING ELEM. (992mm EA.)	0.104
7	052-0395	SET SCREW 1/4" - 20 x 5/16" (OVAL POINT)	2
8	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
9	051-0550	NUT #8-32 S/S	4
10	027-0400	CONNECTOR ADAPTOR	2
11	001-0266	TEFLON HOLD DOWN PLATE	2
12	051-0147	HEX. BOLT #10-24 x 1" S.S.	6
13	051-0571	HEX. NUT #10-24 S.S.	6



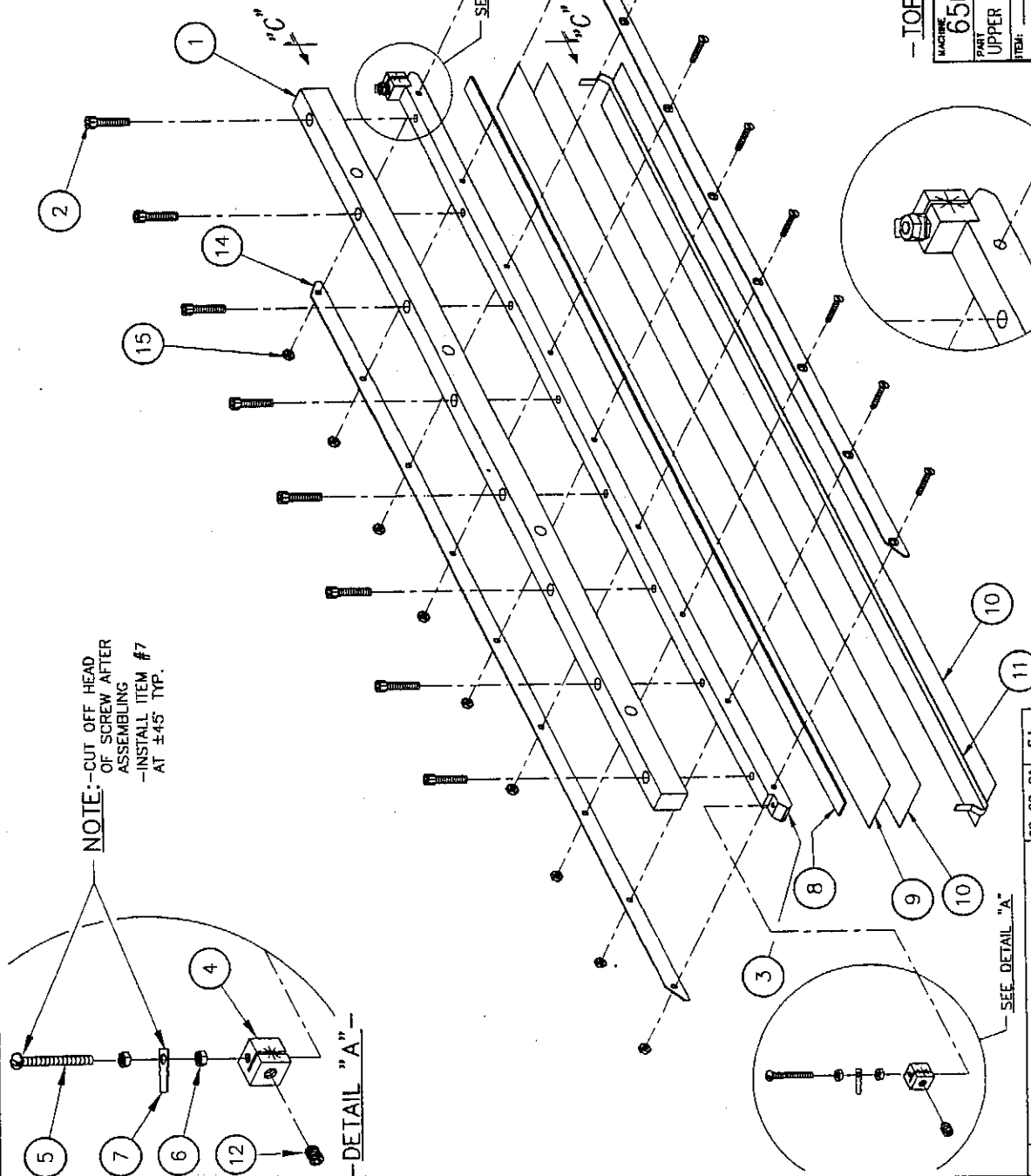
TOP & BOTTOM SEALING OR
BI-ACTIVE SEALING OPTION

MACHINE	650A, 680A & 700A	INCH TOLERANCE	0 ± .015 0.000 ± .0005 0.000 ± .0005	DATE	95-12-29	REV.	4
PART	SEAL BAR ASSEMBLY	METRIC TOLERANCE	0 ± .3 0.005 ± .0005 0.000 ± .0005	DATE		DATE	95-12-29
ITEM:		ANGLE ± 1°		DATE		DATE	
BY:	M. LAVIGNE			DATE		DATE	
APP:				DATE		DATE	
SIPROMAC		ST-GERMAIN DE GRANTHAM QUEBEC CANADA		004-0256			

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

NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

ITEM	PART #	DESCRIPTION	QT.
1	002A0378	UPPER SEAL BAR SUPPORT	1
2	051-0232	SCREW 1/4"-20 NC. X 1 1/4" CAP HEX. SKT S/S	8
3	002A0396	UPPER SEAL BAR	1
4	009-0029	TOP & BOTTOM SEAL CONNECTOR WELDED	2
5	052-0250	SCREW #8-32 NC. X 1 1/2" RND SLOT BRASS	2
6	051-0550	HEX. NUT #8-32 NC. S/S	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm ADHESIVE (852mm EA.)	0.890
9	176-0200	TEFLON TAPE (5S) ADHESIVE (862mm EA.)	0.109
10	176-0220	TEFLON TAPE (10S) ADHESIVE (2x862mm)	0.218
11	039-0220	BI-ACTIVE SEALING ELEM. (992mm EA.)	0.104
12	052-0395	SET SCREW 1/4"-20 NC. X 5/16" (OVAL POINT)	2
13	001A1571	UPPER TEFLON HOLDER	2
14	051-0121	SCREW #8-32 NC. X 1" FLAT PHILL. S/S	9
15	051-0550	HEX. NUT #8-32 NC. S/S	9



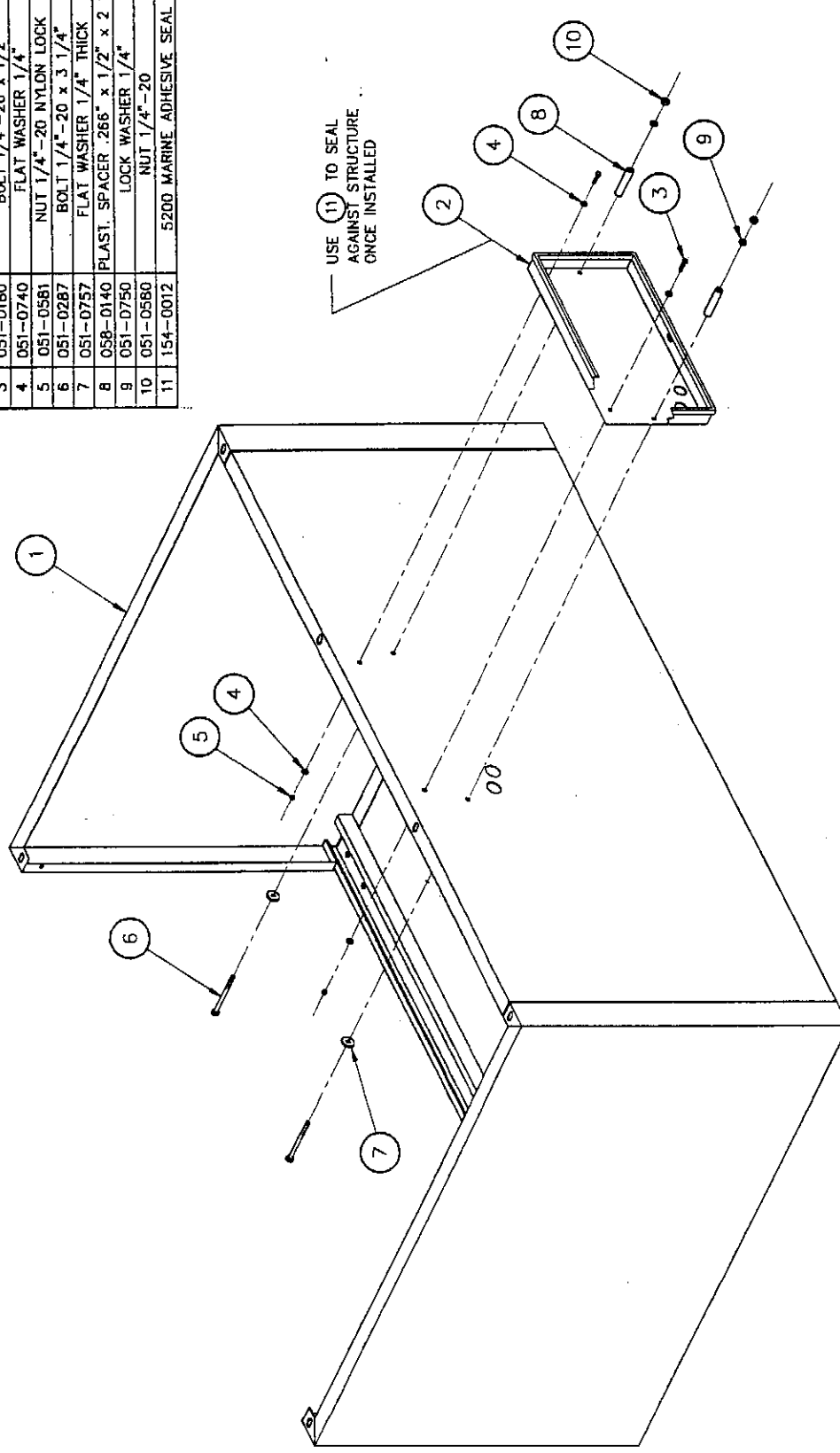
-TOP & BOTTOM SEALING OPTION-

PART # 650A,680A & 700A UPPER SEAL BAR ASSY W/ SUPPORT		METRIC TOLERANCE DIM. ± .015" DIA. ± .005" ANG. ± .005" SURF. ± .005" HOLE ± .005" N.T.S.	SIPROMAC ST-GERMAIN DE GRANBHAM QUEBEC CANADA
DATE: 00-02-01 BY: 005A0404 MODIFICATION	DATE: 98-04-20 BY: 004-D258	DATE: 98-04-20 BY: 004-D258	DATE: 98-04-20 BY: 004-D258
ITEM: _____ MAT: _____		SCALE: M	QTY: 2
PART # 005A0437		005A0437	

E	ADDED 650A WAS 005A0404	00-02-01	S.L.
D	REDRAWN/ WAS ALSO 004-D258	98-04-20	A.P.
LET.	MODIFICATION	DATE	INT.

005-0465

ITEM	PART #	DESCRIPTION	QTY.
1	004-0138	STRUCTURE PRE-ASSY	1
2	005-0584	REAR MC-40 SUPPORT ASSY.	1
3	051-0180	BOLT 1/4" - 20 x 1/2"	2
4	051-0740	FLAT WASHER 1/4"	4
5	051-0581	NUT 1/4" - 20 NYLON LOCK	2
6	051-0287	BOLT 1/4" - 20 x 3 1/4"	2
7	051-0757	FLAT WASHER 1/4" THICK	2
8	058-0140	PLAST. SPACER .266" x 1/2" x 2 1/4"	2
9	051-0750	LOCK WASHER 1/4"	2
10	051-0560	NUT 1/4" - 20	2
11	154-0012	5200 MARINE ADHESIVE SEAL	.06



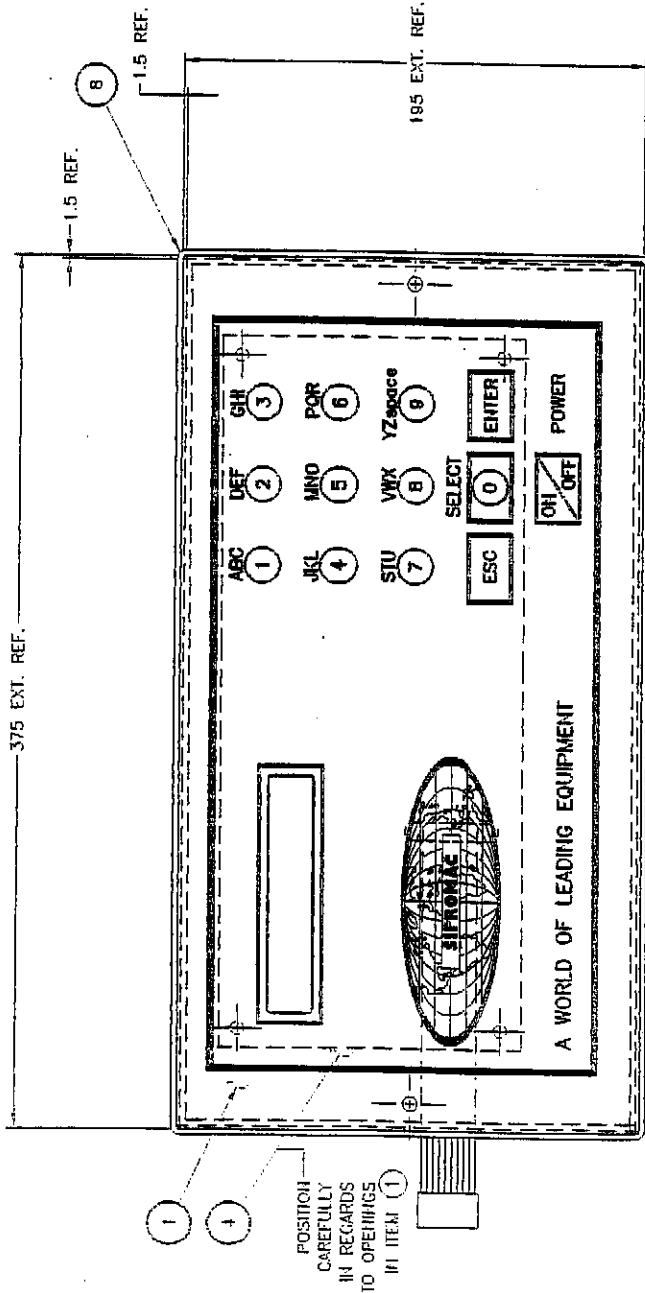
650A		SIPROMAC	
STRUCTURE ASSY		ST-GERMAIN DE BRANTHAM QUEBEC CANADA	
ITEM	DATE	SCALE	QTY.
DATE	DATE	SCALE	QTY.
DATE	DATE	SCALE	QTY.
DATE	DATE	SCALE	QTY.

LET.	DATE	INT.

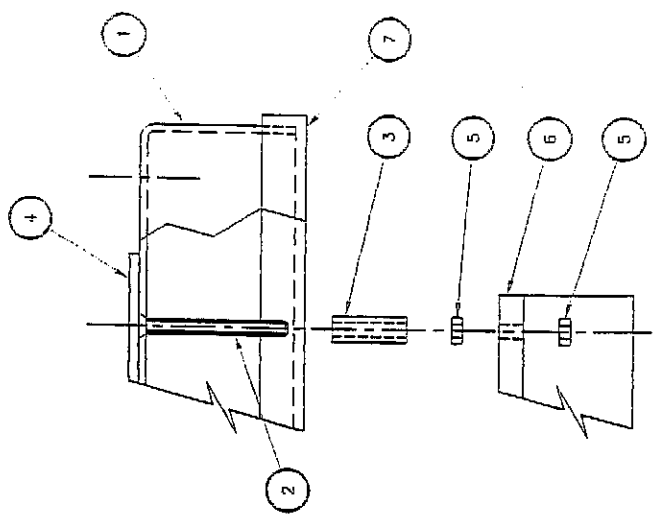
MODIFICATION

005-0465

ITEM	PART #	DESCRIPTION	QTY.
1	904-0425	FRONT MC-40 SUPPORT PRE-ASS'Y	1
2	051-0092	SCREW 4-40 X 1 1/4" FLAT SLOT S/S	4
3	058-0120	CPVC SPACER 0.120" X 1/4" X 5/8"	4
4	033-0015	MC-40 KEYBOARD "SIPROMAC"	1
5	051-0540	NUT #4-40 S/S	8
6	033-3003	MC-40 DIGITAL P.C. BOARD	1
7	179-0014	RUBBER 1/4" X 3/8" X 1/16" "U SHAPED"	37



POSITION CAREFULLY IN REGARDS TO OPENINGS IN ITEM 1



---DETAIL "A"---

NOTE:

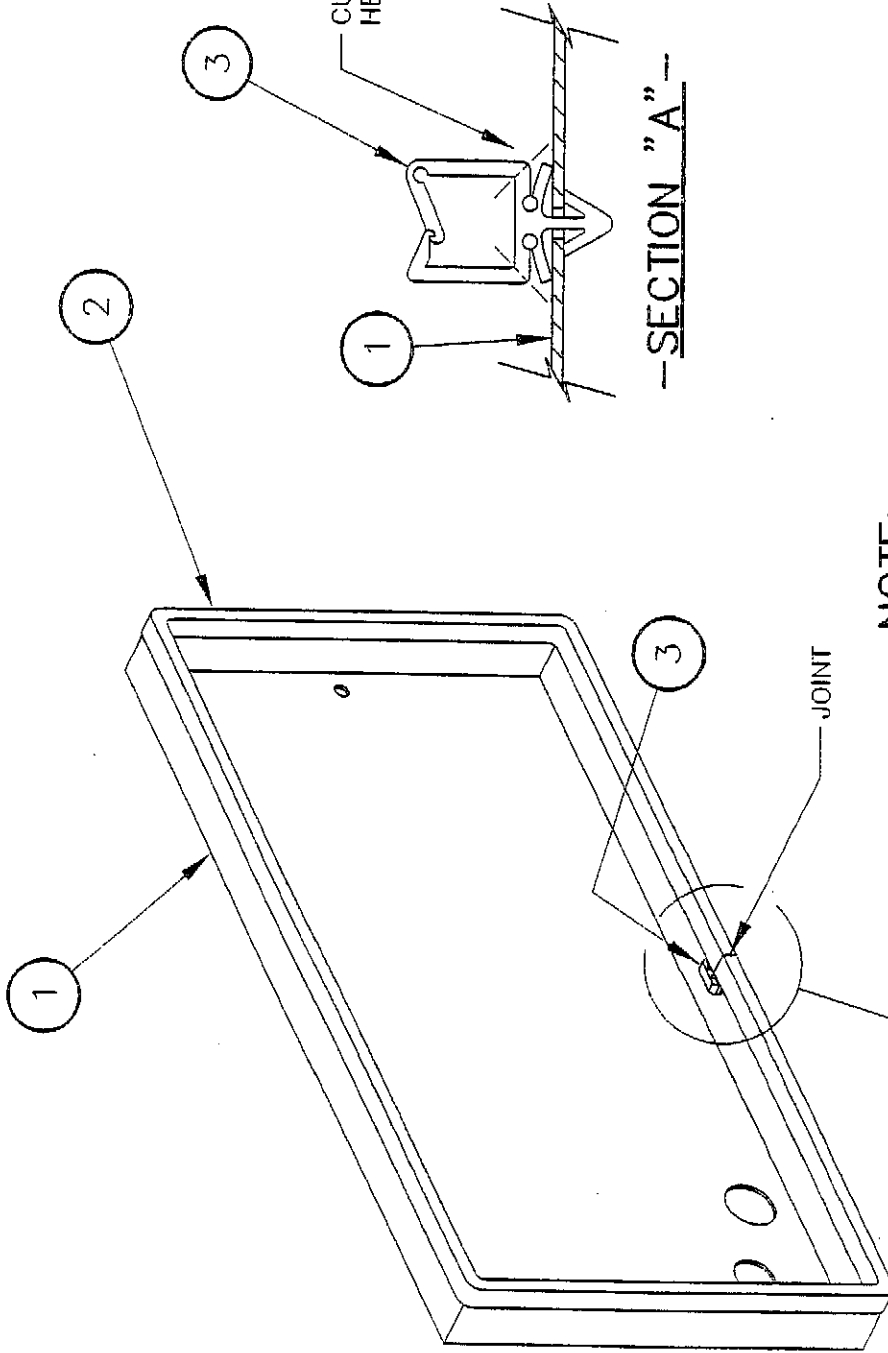
- OPTIONAL FOR 420A, 450T, 450A, 450I, 450A & 550A

MACHINE	420A, 450T, 450A, 550A, 600A, 620A & 650A
PART	FRONT MC-40 SUPPORT ASS'Y
ITEM	1
DATE	08-01-28
SCALE	1/1" = 1"
REV. A	DATE 08-01-28
REV. B	DATE
REV. C	DATE
REV. D	DATE
REV. E	DATE
REV. F	DATE
REV. G	DATE
REV. H	DATE
REV. I	DATE
REV. J	DATE
REV. K	DATE
REV. L	DATE
REV. M	DATE
REV. N	DATE
REV. O	DATE
REV. P	DATE
REV. Q	DATE
REV. R	DATE
REV. S	DATE
REV. T	DATE
REV. U	DATE
REV. V	DATE
REV. W	DATE
REV. X	DATE
REV. Y	DATE
REV. Z	DATE

REV.	DESCRIPTION	DATE	BY
D	REMOVED ITEM #9 (179-0006)	00-09-07	S.L.
C	ADDED 420A, 450T, 450A & 550A	98-05-25	L.M.
B	ADDED 600A & 620A / WAS 005-0319	98-05-15	L.M.
A	WAS 005-0319 / MODIF. NO. A-0258	98-04-28	A.P.

005-0584

ITEM	PART #	DESCRIPTION	QT.
1	004-0426	REAR MC-40 SUPPORT PRE-ASS'Y	1
2	179-0014	RUBBER 1/4" X 3/8" X 1/16" ("U" SHAPED)	3.9
3	057-0002	CABLE TIE HOLDER	1

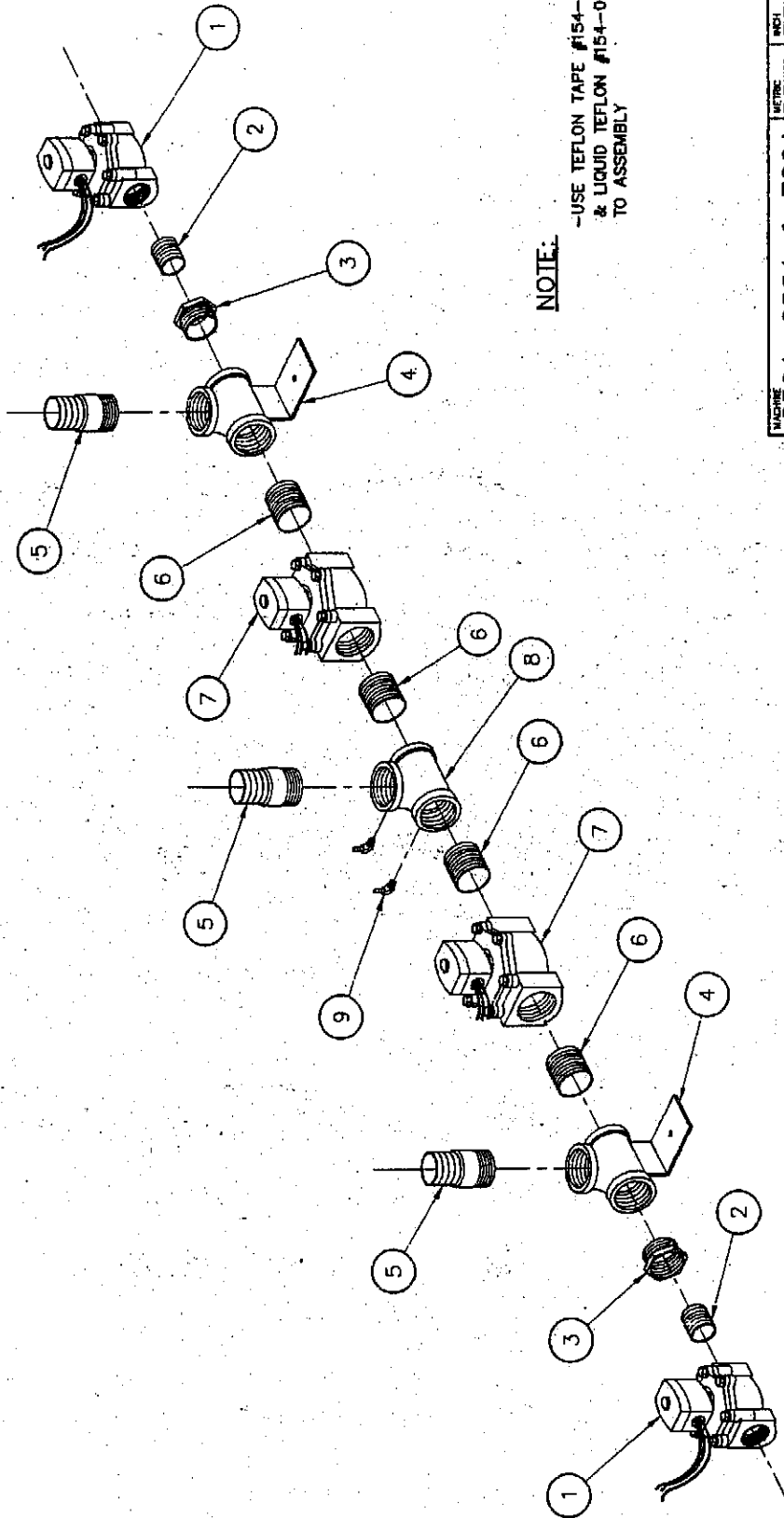


NOTE:

- OPTIONAL FOR 420A, 450T, 450T, 450A & 550A

MACHINE	420A, 450T, 450A 550A, 600A, 620A & 650A	METRIC TOLERANCE	0. ± .5 .00 ± .005 .000 ± .0005	INCH TOLERANCE	0 ± .015 .00 ± .005 .000 ± .0005	SCALE	1
PART	REAR MC-40 SUPPORT ASS'Y	ANGLE ± 1'	N.T.S.				
ITEM:	CNC:						
DWG. BY	A. PROVENCHER	DATE	98-05-05	NO.	005-0584		
APP.	LT	DATE					
B	ADDED 420A, 450T, 450A & 550A	DATE	98-05-25	L.M.			
A	ADDED 600A & 620A / WAS 005-0585	DATE	98-05-15	L.M.			
LET.	MODIFICATION						

ITEM	PART #	DESCRIPTION	QTY.
1	106-0050	VALVE 2WAY / 24V / 60Hz / 1 1/4" NPT	2
2	103-0247	CLOSE NIPPLE 1 1/4" NPT ZINC	2
3	103-0587	RED. BUSHING 2" NPT x 1 1/4" NPT ZINC	2
4	004-0183	VACUUM VALVE SUPPORT PRE-ASSY	2
5	103-0780	STRAIGHT 2" NPT x 2" HOSE ZINC	3
6	103-0280	CLOSE NIPPLE 2" NPT ZINC	4
7	106-0060	VALVE 2WAY / 24V / 60Hz / 2" NPT	2
8	003-0079	BELLOWS CONNECTOR TEE	1
9	101-0191	ELBOW 1/8" NPT x 1/4" HOSE	2



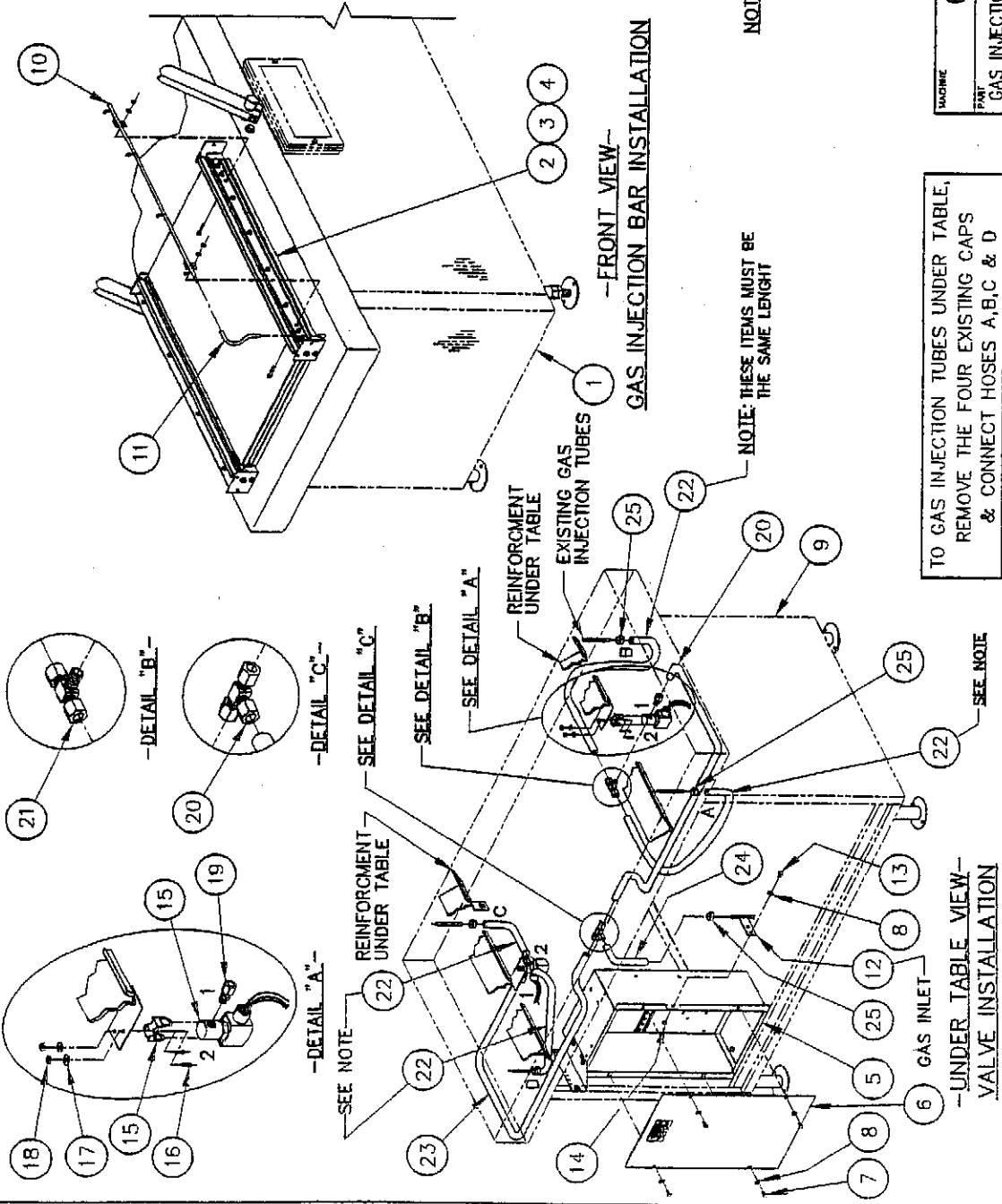
NOTE:

-USE TEFLON TAPE #154-0080
& LIQUID TEFLON #154-0030
TO ASSEMBLY

NAME 650A, 680A & 700A		SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	
PART VACUUM / ATMOSPHERE VALVE ASSY		SCALE 1	QTY. 1
ITEM	DATE DD-01-06	DATE DD-01-06	NO. 004-0505
APP. S. LAROUCHE	DATE DD-01-06	DATE DD-01-06	NO. 004-0505

LET.	MODIFICATION	DATE	INT.
C	INVERSED SIZE ITEM #1	00-03-22	S.L.
B	ADDED 650A	00-03-22	S.L.
A	REDRAWN / ITEM #2, 101-0191 WAS 101-0190	00-01-06	S.L.

ITEM	PART #	DESCRIPTION	QTY
1	005-0352	MACHINE ASSEMBLY FRONT VIEW	1
2	005A0357	SEAL BAR ASSY W/ SUPPORT	4
3	005A0358	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPT.)	4
4	005A0358	SEAL BAR ASSY W/ SUPPORT (T&B OPT.)	4
5	005-0374	ELECTRICAL BOX ASSEMBLY	1
6	004-0278	ELECTRICAL BOX COVER PRE-ASSY	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4" S/S	5
9	005-0353	MACHINE ASSEMBLY REAR VIEW	1
10	005A0350	GAS INJECTION BAR ASSEMBLY (OPTION)	4
11	008-0464	GAS INJECTION CONN. TUBE (OPTION)	4
12	005-0323	GAS INLET ASSEMBLY	1
13	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
14	051-0380	HEX. NUT 1/4"-20 NC. S/S (OPTION)	1
15	106-0010	SELENOIDE VALVE 2 WAY 1/4" NPT W/ SUPP.	2
16	051-0100	SCREW #8-32 X 3/8" PAN PHILL. S/S	4
17	051-0720	FLAT WASHER #8 S/S	4
18	051-0550	HEX. NUT #8 S/S	4
19	101-0036	STRAIGHT 1/4" MNPT X 3/8" I.P. COMP.	2
20	101-0062	"T" 3/8" I.P. COMP.	1
21	101-0065	"T" 3/8" I.P. COMP. X 1/4" MNPT X 3/8" I.P. COMP.	2
22	104-0080	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	4
23	104-0080	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	2
24	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	1
25	105-0200	COLLARS 3/8" φ	5



NOTE: PARTS 1 THRU 9 ARE EXISTING PARTS
PARTS 10 THRU 25 ARE PARTS SUPPLIED W/ KIT

-OPTION GAS INJECTION-

MACHINE: **650A**

PART: **GAS INJECTION KIT INSTALLATION**

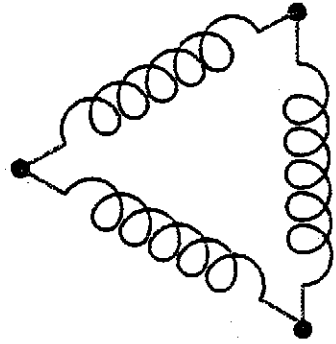
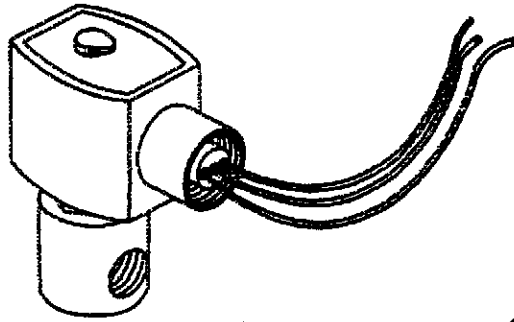
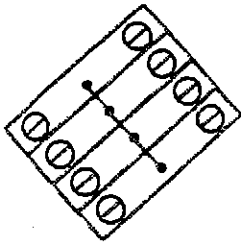
ITEM: _____ DATE: 98-02-19

REV. A. PREPARED BY: _____ DATE: _____

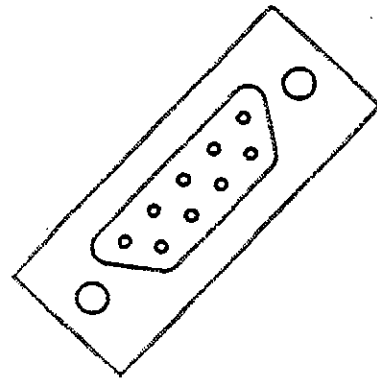
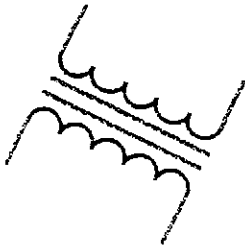
SCALE: _____ DR. 1

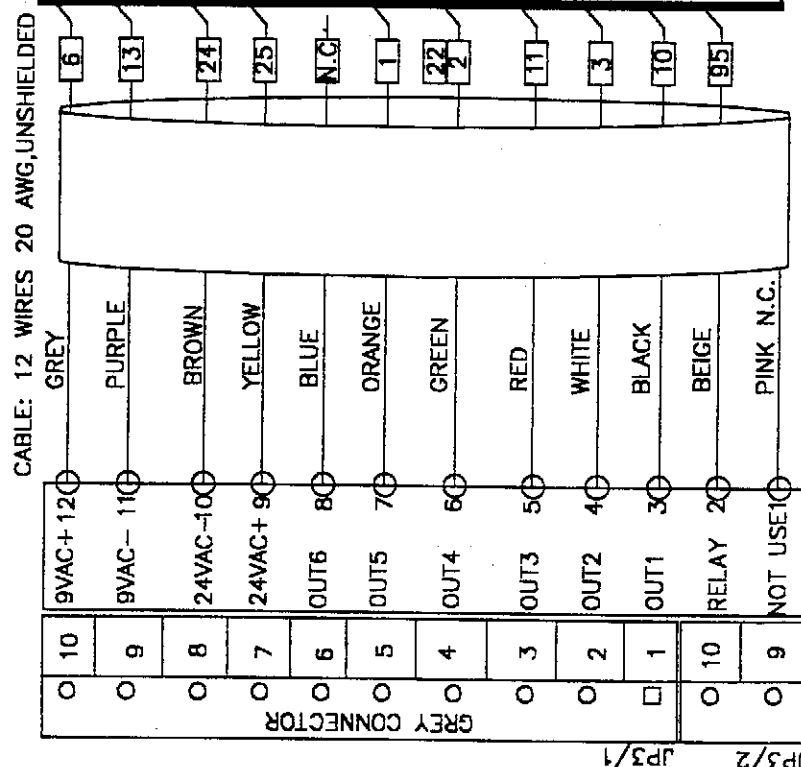
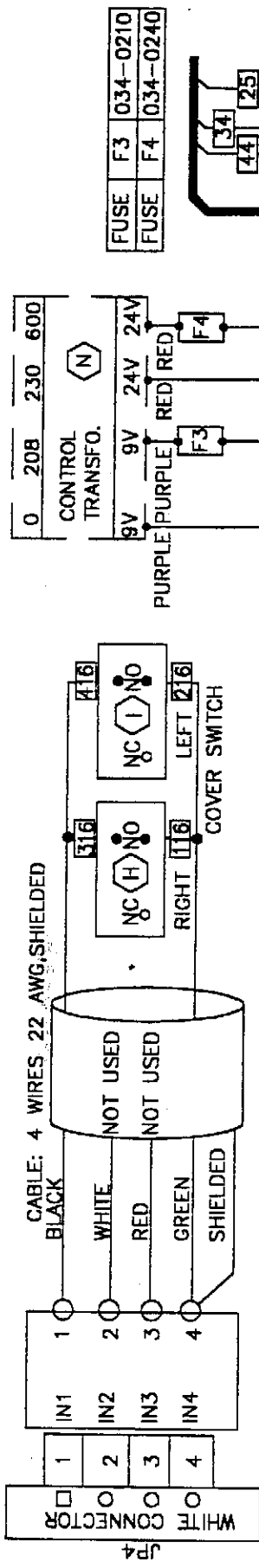
010-0020

C. REDRAWN/ MODIF. A-023R 98-02-19 A.P.
LET. DATE INT.

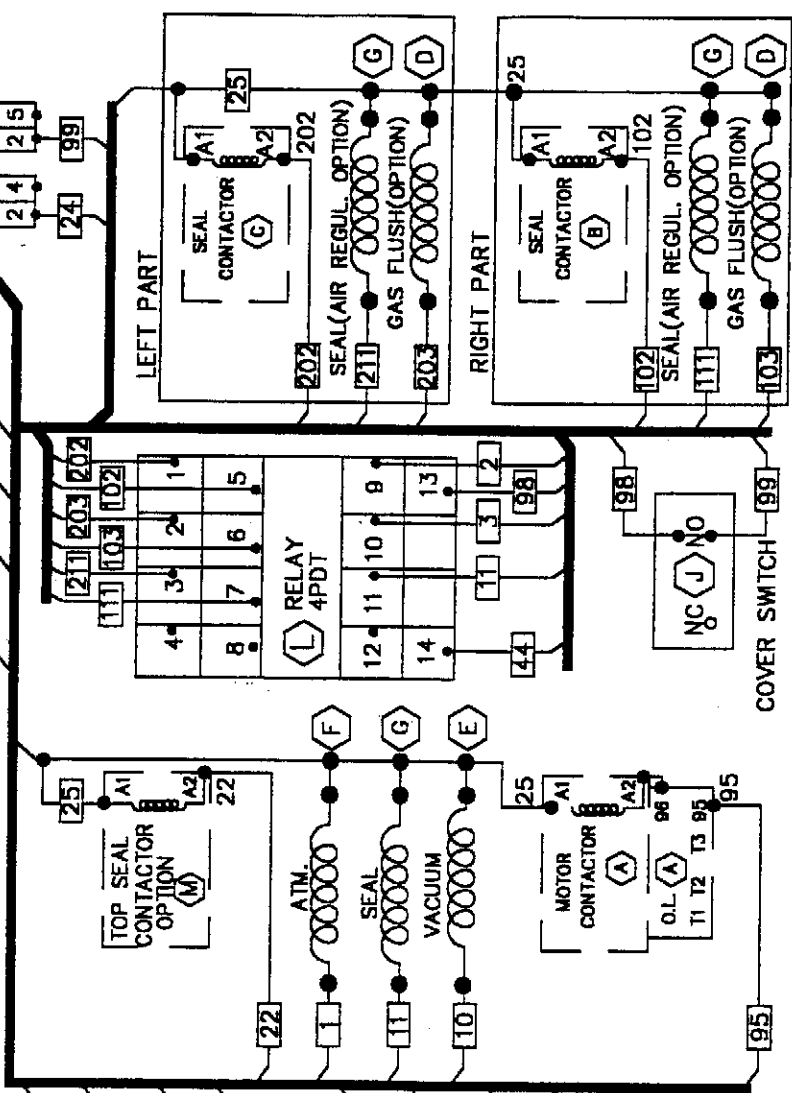


ELECTRICAL DRAWING





MC-40



MACHINE

VACUUM DOUBLE CHAMBER

SIPROMAC

ST-GERMAIN DE GRANTHAM,
QUEBEC CANADA

LOW VOLTAGE WITH MC-40

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

DATE 15 MAY 1998

NO.

DESS. D.L.

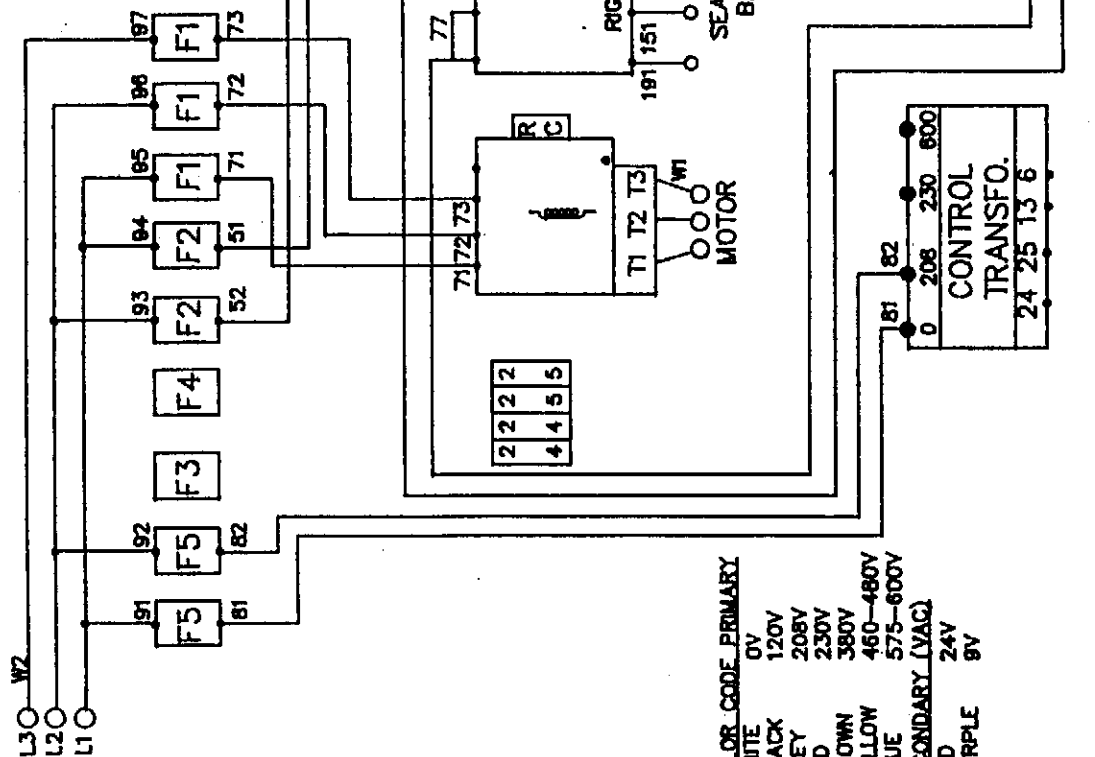
APP.

016-0118

1006-0037

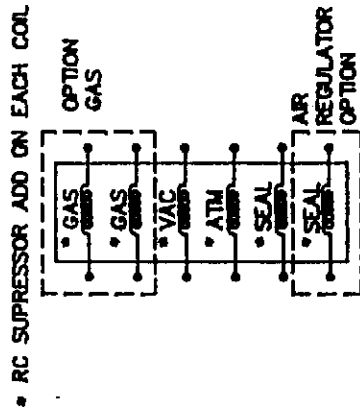
MOTOR	VOLT-PL	FUSE F1
7.5	230-3	034-0110
7.5	380-3	034-0100
10	230-3	034-0110
10	380-3	034-0100
10	575-3	034-0580

OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0530	034-0200
TWIN SEAL	380	034-0510	034-0410
TWIN SEAL	600	034-0465	034-0410
BAG CUT	220	034-0530	034-0200
BAG CUT	380	034-0510	034-0410
BAG CUT	600	034-0465	034-0410
TOP & BOTTOM SEAL	220	034-0530	034-0200
TOP & BOTTOM SEAL	380	034-0510	034-0410



COLOR CODE PRIMARY
 0V WHITE
 120V BLACK
 208V GREY
 230V RED
 380V BROWN
 460-480V YELLOW
 575-600V BLUE

SECONDARY (VAC)
 24V RED
 8V PURPLE



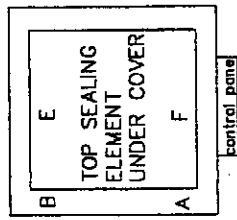
WIRE LOCATION	W1	W2	W1	W2
VOLTAGE	220	575	220	575
PUMP	10			
SEAL OPTION	10/4S0	6/4S0	12/4S0	2/4S0
WIRE DIA.	10/4S0	6/4S0	12/4S0	2/4S0

MAGNIE		VACUUM 650A	
PRICE	ELECT. WIRING HIGH VOLTAGE 3Ø		
BT	ECH. SCALE	NE PAS MESURER /N.T.S.	
DATE	DATE	DATE	DATE
NO.	97-03-12	NO.	006-0037

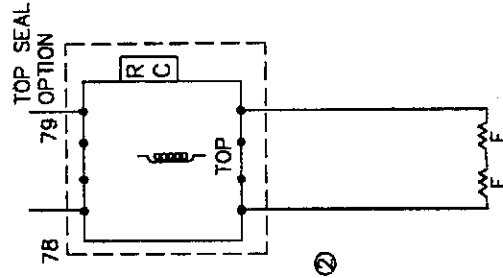
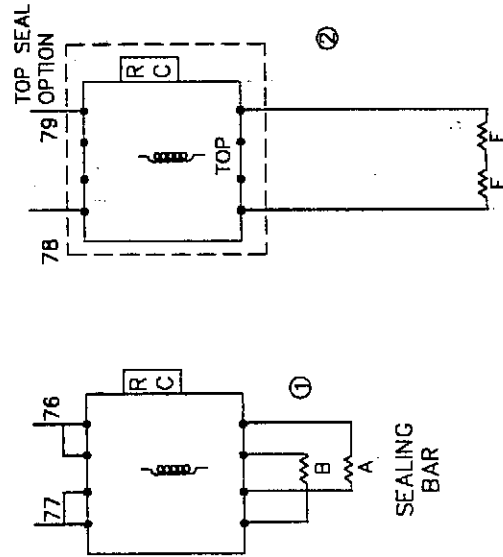
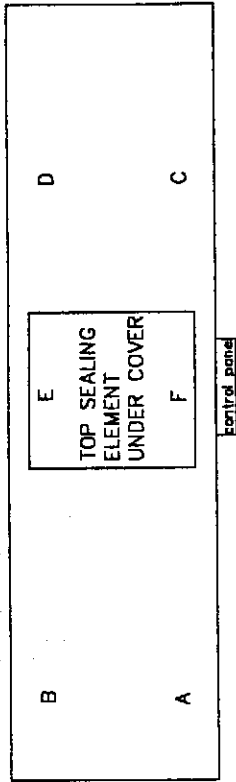
SIPROMAC

ST-GERMAIN DE GRANTHAM
 QUEBEC CANADA

SINGLE CHAMBER



DOUBLE CHAMBER



① WIRE TEW 12 AWG SIPROMAC # 030-0420

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

MACHINE

ALL MODEL

PIECE

WIRING FOR SEALING BAR

QT.

ECH. SCALE

NE PAS MESURER /N.T.S.

MAT:

DESS. APP. ERIC J. I.P.

DATE 12 DEC. 2000

NO.

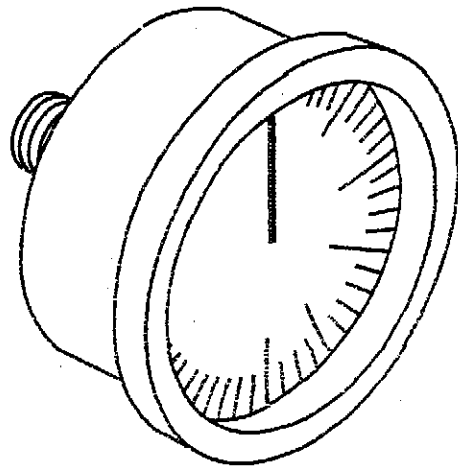
006-0131

SIPROMAC

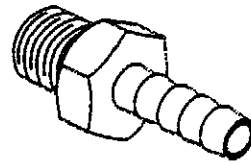
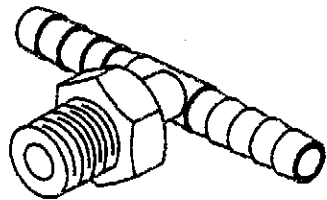
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

ELECTRICAL DRAWINGS PARTS LIST

A : VOLT	PHASE	PUMP HP	CONTACTOR	OVERLOAD
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:			106-0060	
F: ATMOSPHERE SOLENOID VALVE:			106-0030	
			106-0050 WITH PUMP: 7.5 HP	
G: BELLOWS SOLENOID VALVE:			106-0070	
H, I, J: COVER SWITCH:			026-0610	
K: SEALING TRANSFO.:			029-0172,029-0174	
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	



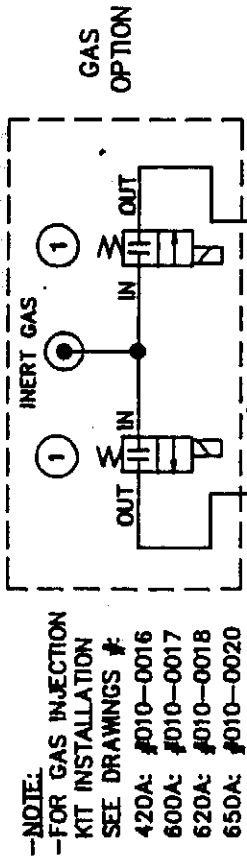
PNEUMATIC DRAWING



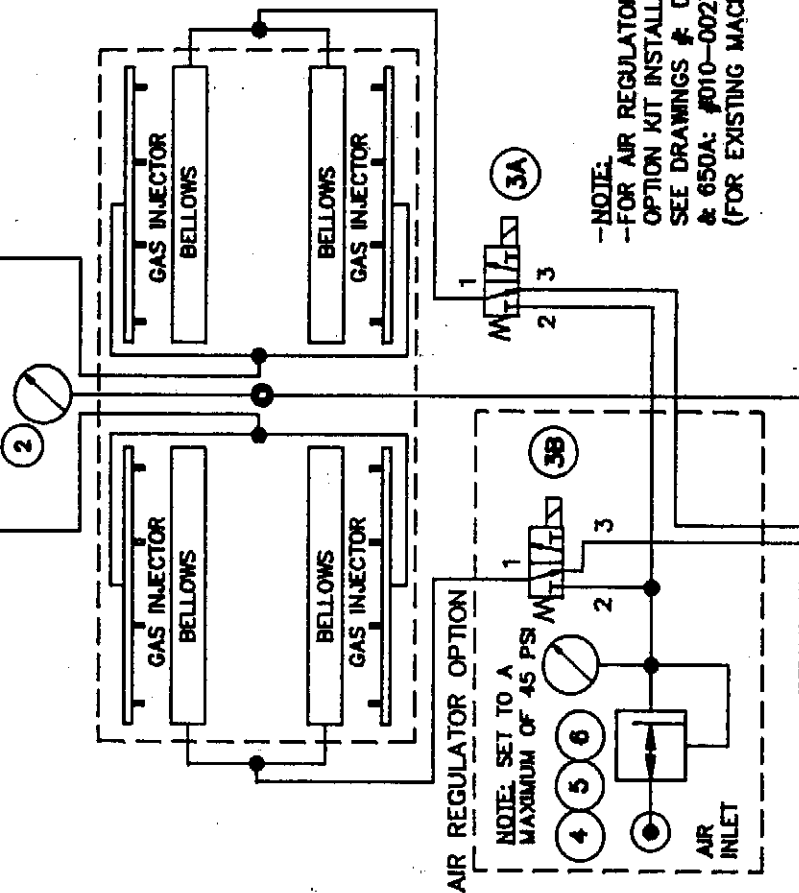
007-0019

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 620A & 620A: 160 M ³ AND 250 M ³	
8	106-0050	ATMOSPHERE VALVE FOR 850A & 700A	1
	106-0030	VACUUM VALVE FOR 420A	
	106-0050	VACUUM VALVE FOR 600A & 620A	
	106-0060	VACUUM VALVE FOR 850A & 700A	

*: OPTION

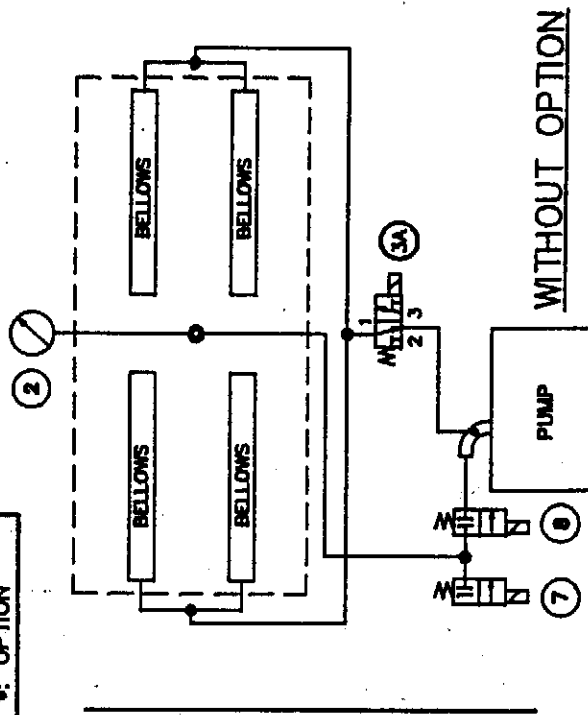


NOTE:
-FOR GAS INJECTION
KIT INSTALLATION
SEE DRAWINGS #:
420A: #010-0016
600A: #010-0017
620A: #010-0018
650A: #010-0020



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)



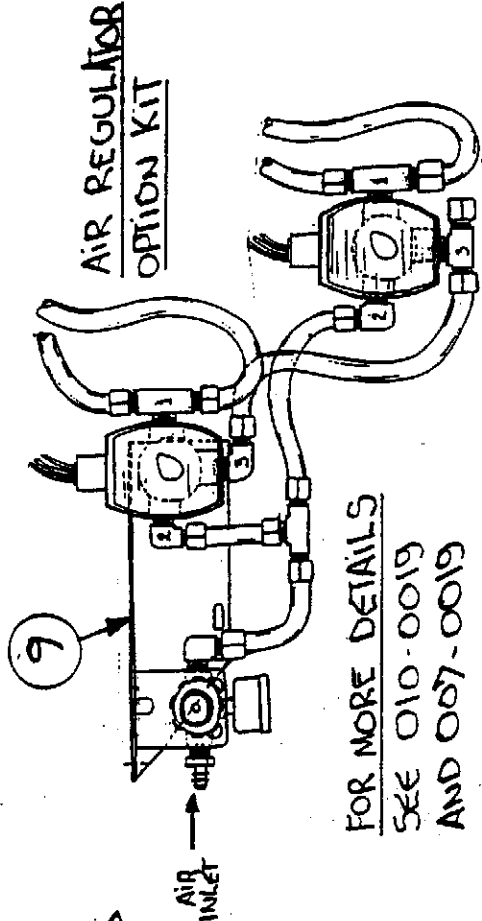
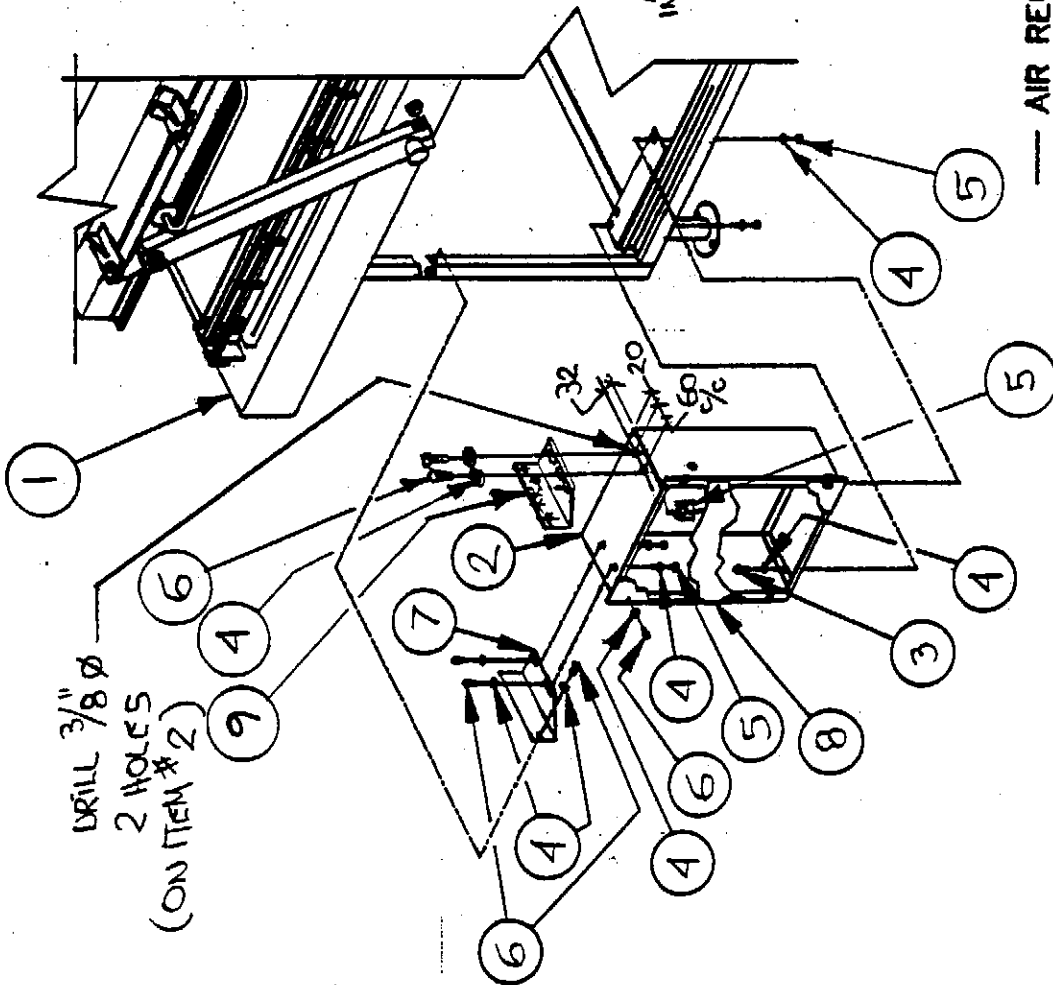
WITH OPTIONS

WITHOUT OPTION

MACHINE	420A, 600A, 620A & 650A	SIPROMAC
PART	PNEUMATIC	ST-GERMAN DE GRANTHAM QUEBEC CANADA
ITEM	CNC	N.T.S.
MAT	DATE 97-03-11	SCALE
APP	DATE 97-03-11	DT.
RE-DRAWN	MODIFICATION	007-0019
LET.		

1010-0027

ITEM	PART-N	DESCRIPTION	QT.
1	006-0353	MACHINE ASSEMBLY REAR VIEW	1
2	005-037A	ELECTRICAL BOX ASSEMBLY	1
3	051-0190	BOLT 1/4"-20 x 3/4" 9/5	2
4	051-0740	WASHER 1/4" FLAT 5/5	15
5	051-0580	NUT 1/4"-20 5/9	6
6	051-0180	BOLT 1/4"-20 x 1/2" 9/5	9
7	001-1364	LEFT/ELEC. BOX UPPER SUPPORT	1
8	004-0279	E-BOX COVER ASSEMBLY	1
9	009-004A	VALVE/REGULATOR SUPPORT	1

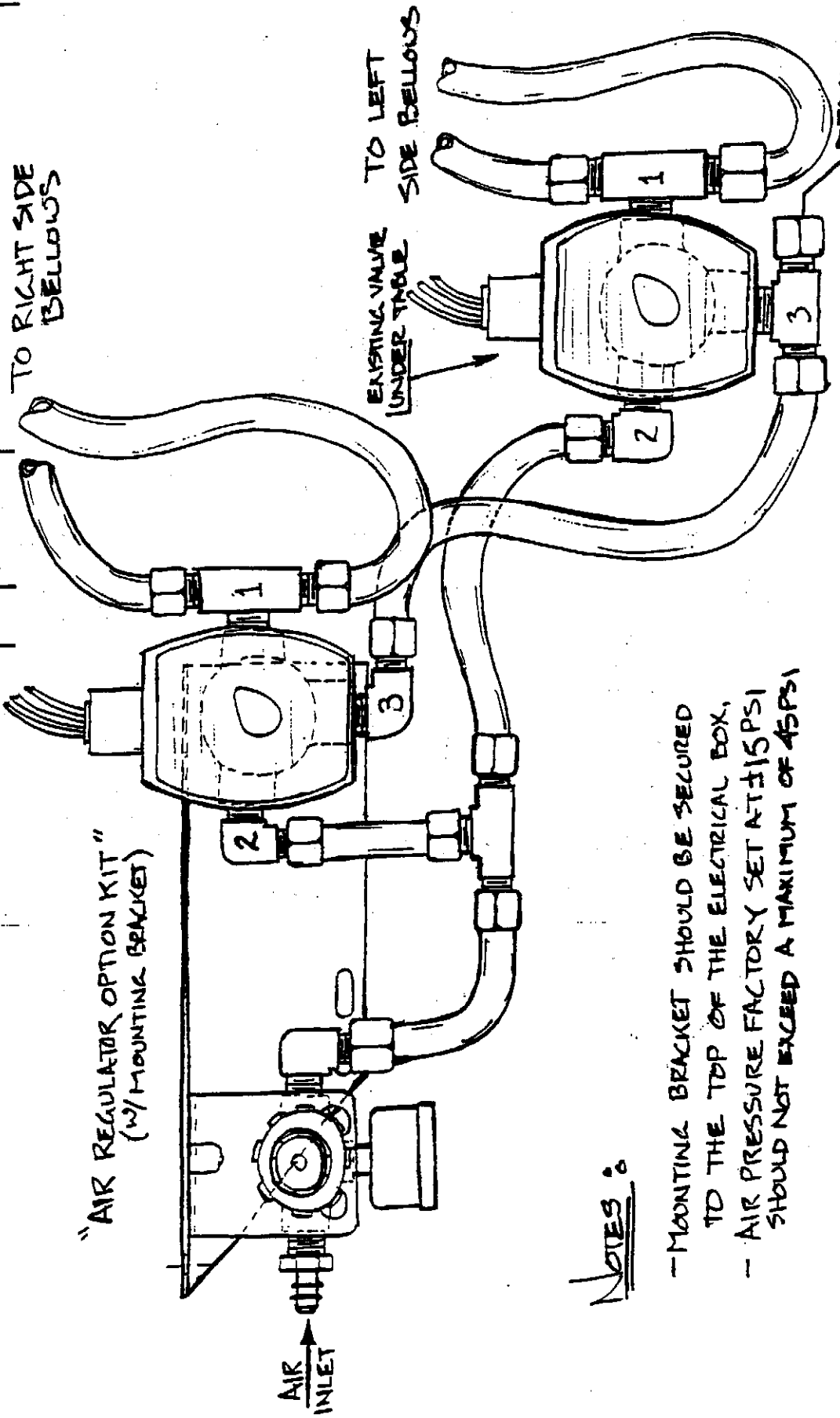


— AIR REGULATOR OPTION — (FOR EXISTING MACHINES)

MACHINE	650A	METRIC TOLERANCE	± .015 ± .010 ± .008 ± .006 ± .005 ± .004 ± .003 ± .002 ± .001	INCH TOLERANCE	± .015 ± .010 ± .008 ± .006 ± .005 ± .004 ± .003 ± .002 ± .001	ST-GERMAN DE GRANTHAM QUEBEC CANADA
PART	AIR REGULATOR OPTION KIT INSTALLATION	N.T.S.		SCALE		SIPROMAC
ITEM		DATE	97-02-21	DATE	97-02-21	NO. 010-0027
LET.	A REDRAN-3	MODIFICATION		DATE		

010-0019

ITEM	PIECE	DESCRIPTION	QTY.
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"AIR REGULATOR OPTION KIT"
(w/ MOUNTING BRACKET)

TO RIGHT SIDE BELLOWS

EXISTING VALVE UNDER INSOLE

TO LEFT SIDE BELLOWS

TO CONNECTION ON BELLOWS OF PUMP (SEE DWG. 007-0019)

NOTES:

- MOUNTING BRACKET SHOULD BE SECURED TO THE TOP OF THE ELECTRICAL BOX,
- AIR PRESSURE FACTORY SET AT 15 PSI SHOULD NOT EXCEED A MAXIMUM OF 45 PSI

MACHINE 420 A600A, 620A & 650A		METRIC TOLERANCE 0 ± .05 .00 ± .005 ANGLE ± 1		INCH TOLERANCE .0 ± .015 .00 ± .005 0.000 ± .0005	
PIECE AIR REGULATOR OPTION KIT INSTALLATION		N.T.S.		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
QTY.	1	DATE	97-02-21	NO.	
DATE		DATE		010-0019	
APP.	DAVE A	DATE			
MODIFICATION		DATE			
INT.		DATE			
LET.		DATE			



United States
Department of
Agriculture

Food Safety
and Inspection
Service

Washington, D.C.
20250

May 14, 1992

Sipromac, Inc.

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

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

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,

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

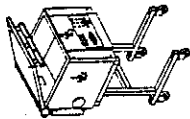
DECU

NOTES

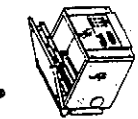
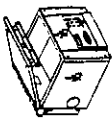
NOTES



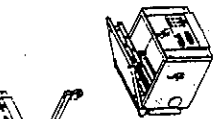
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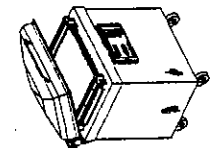
350/350D



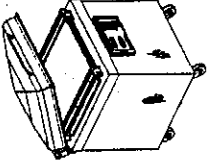
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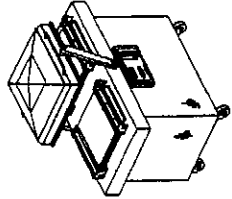
450A



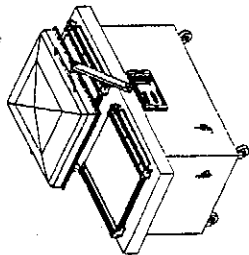
550A



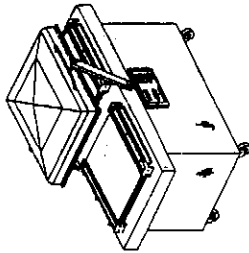
420A



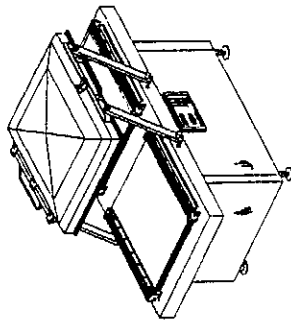
600A



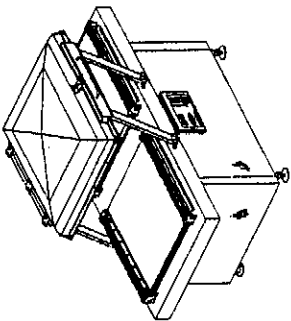
620A



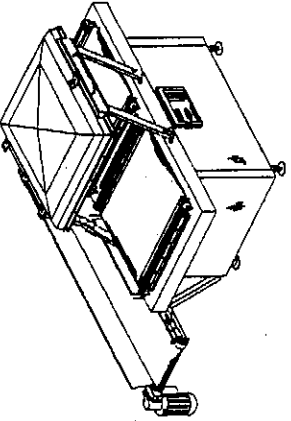
650A



650A AUTOMATIC



700A



VACUUM PACKAGING MACHINES