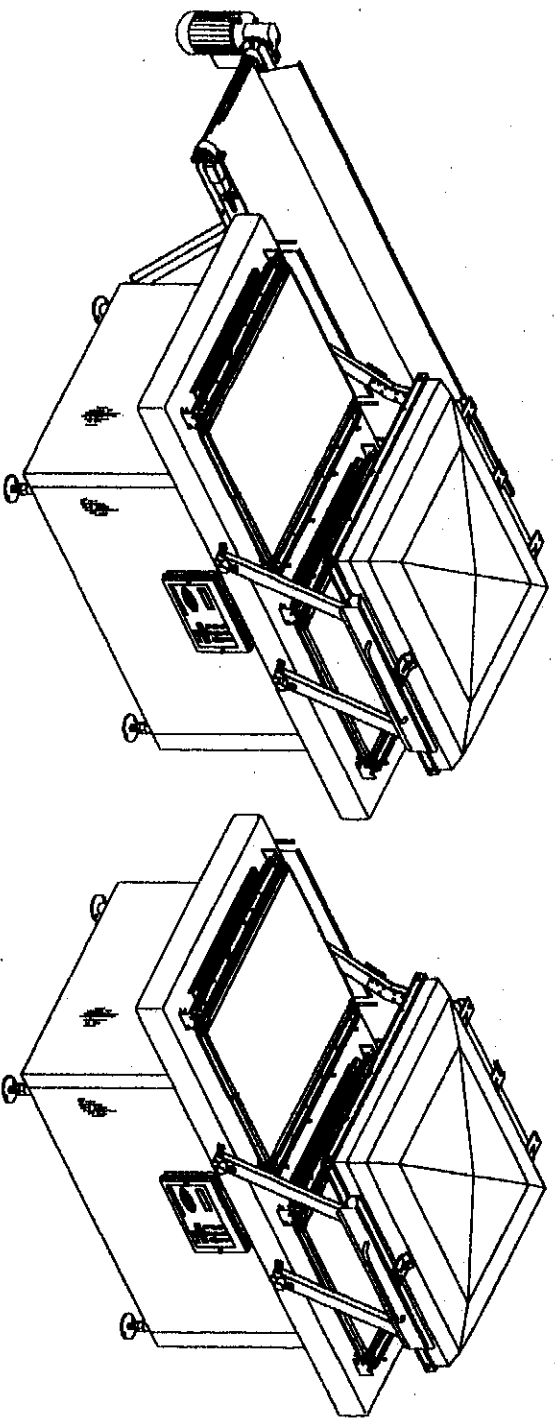
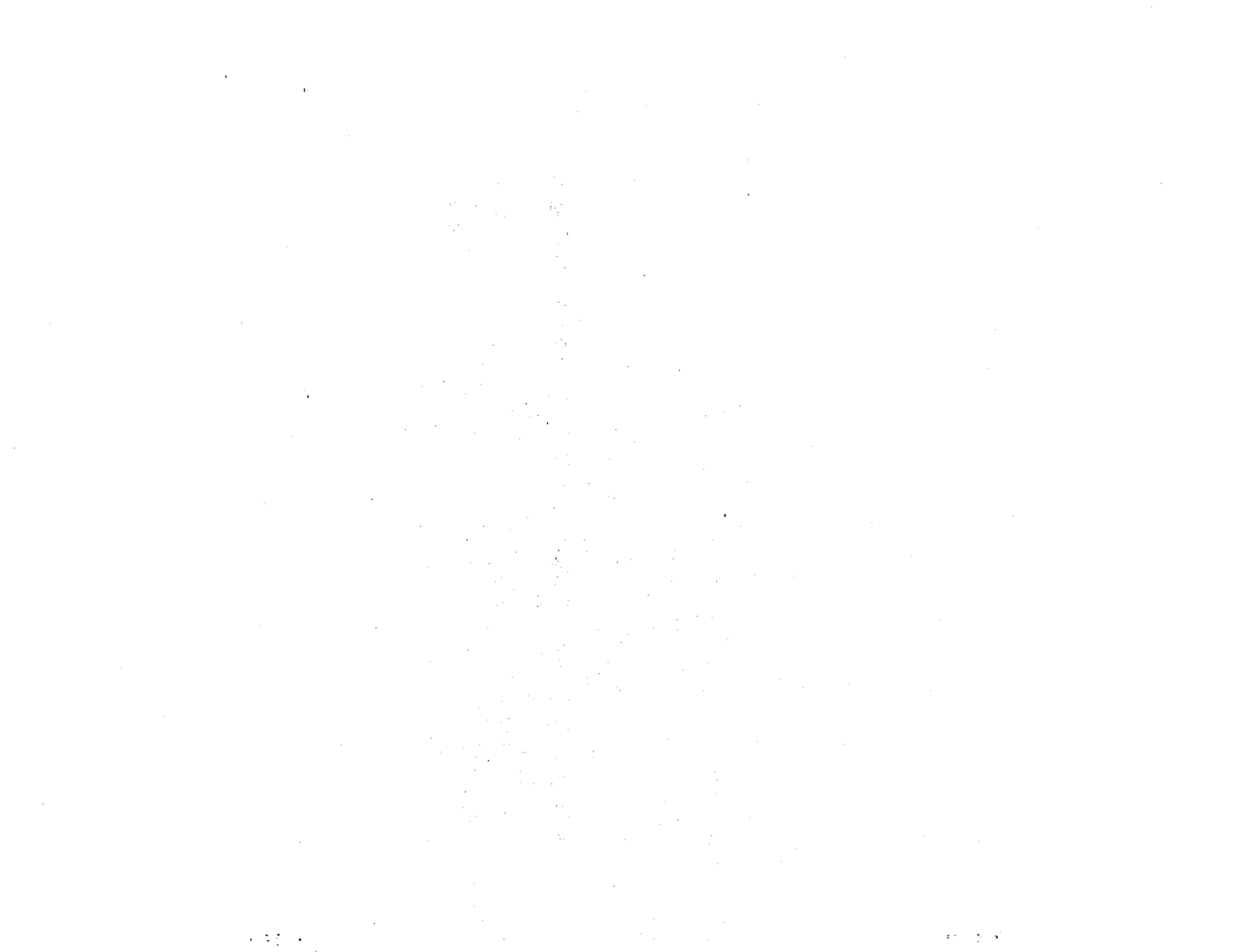




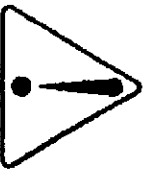
**MODEL  
700A**



**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.

# AUTOMATIC VACUUM PACKAGING MACHINE

## MODEL 700A

### GENERAL TABLE OF CONTENTS

#### I OPERATION INSTRUCTIONS

- A- Operating guide & conveyor notice

#### II MECHANICAL

- A- Front view general assembly drawing
- B- Rear view general assembly drawing
- C- Rear conveyor installation drawing  
(rear conveyor option)
- D- Central shaft assembly drawing
- E- Seal bar assembly drawings  
(Twin seal)
- F- Seal bar assembly drawings  
(Elec.cut-off option)
- G- Seal bar assembly drawings  
(Top & bottom option)
- H- Upper seal bar assembly drawings
- I- Gas injection kit installation drawing

#### III ELECTRICAL

- A- Power diagram
- B- control diagram
- C- Plc input
- D- Electrical part list

#### IV PNEUMATIC

- A- Pneumatic drawing

# VACUUM PACKAGING MACHINES

## OPERATION INSTRUCTIONS

### TABLE OF CONTENTS

1. Setting up the machine
2. Electrical connection
3. Operation
  - 3.1 Working principles
  - 3.2 Special packaging
    - 3.2.1 Gas flushing
    - 3.2.2 Top and bottom sealing (bi-active sealing)
  - 3.3 Setting of digital controls
  - 3.4 Daily cleaning
4. Trouble shooting
  - 4.1 Failure during a packaging cycle
  - 4.2 Insufficient vacuum
    - 4.2.1 Leakage in the bag
    - 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
    - 4.3.3 Permanent sealing current
    - 4.3.4 Seal does not stick
  - 4.4 Fault in the valves
  - 4.5 Control board failure
5. Regular maintenance

# 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 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 bar. The product should be centered in height in relation to the seal bar by adjusting the spacers provided.

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

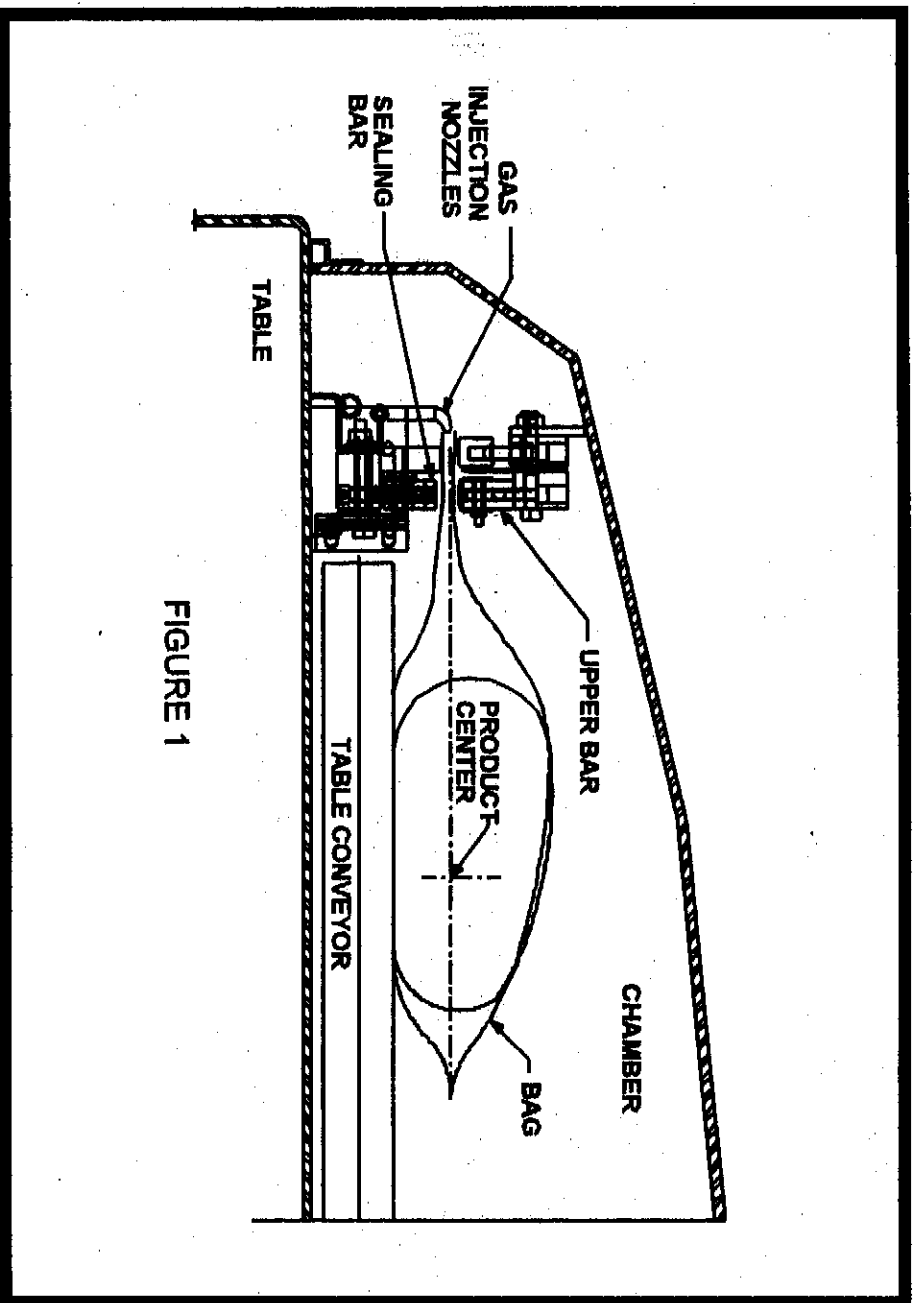


FIGURE 1

### 3.2 Special packaging:

#### 3.2.1 Gas flushing (option):

There is an atmospheric pressure of 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 in the program menu.



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.

### 3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 9 and the keyboard detail on page10.

#### 3.3.1 Basics:

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

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

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

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

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

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

#### 3.3.2 Functions:

##### 3.3.2.1 Create a program:

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

### 3.3.2.2 Delete a program:

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

### 3.3.2.3 Select operating mode:

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

## 3.3.3 Programs menu:

### 3.3.3.1 Program identification:

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

Example: EXAMPLE 1 → 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 truncated to the nearest half value. In the middle of an acquisition, use key "ENTER" to validate the vacuum level and key "ESC" to come backward and start over with a new acquisition (the old vacuum level is blinking). Set vacuum level to zero to bypass the pressure transducer and proceed only using the vacuum plus time.

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

### 3.3.3.3 Vacuum plus time setting:

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

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

### 3.3.3.4 Gas flush level setting:

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

### 3.3.3.5 Sealing time setting:

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

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

### 3.3.4 Vacuum cycle execution:

For the manual units and the automatic units set on manual, close the cover to initiate a vacuum cycle. For the automatic units set on semi-automatic or on automatic, use push button "STOP / START" to initiate or interrupt a vacuum cycle. A selected program can be initiated only in the programs menu, when no modifications are in progress, and the access to the other programs and functions is denied. During cycle execution the operation status is sequentially displayed on LCD screen, except for the parameters established to zero, which are not displayed:

- chamber vacuum level during vacuum sequence,
- vacuum plus time status during vacuum plus sequence,
- chamber vacuum level during gas flush sequence,
- sealing time status during sealing sequence,
- chamber vacuum level during atmosphere sequence. 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)

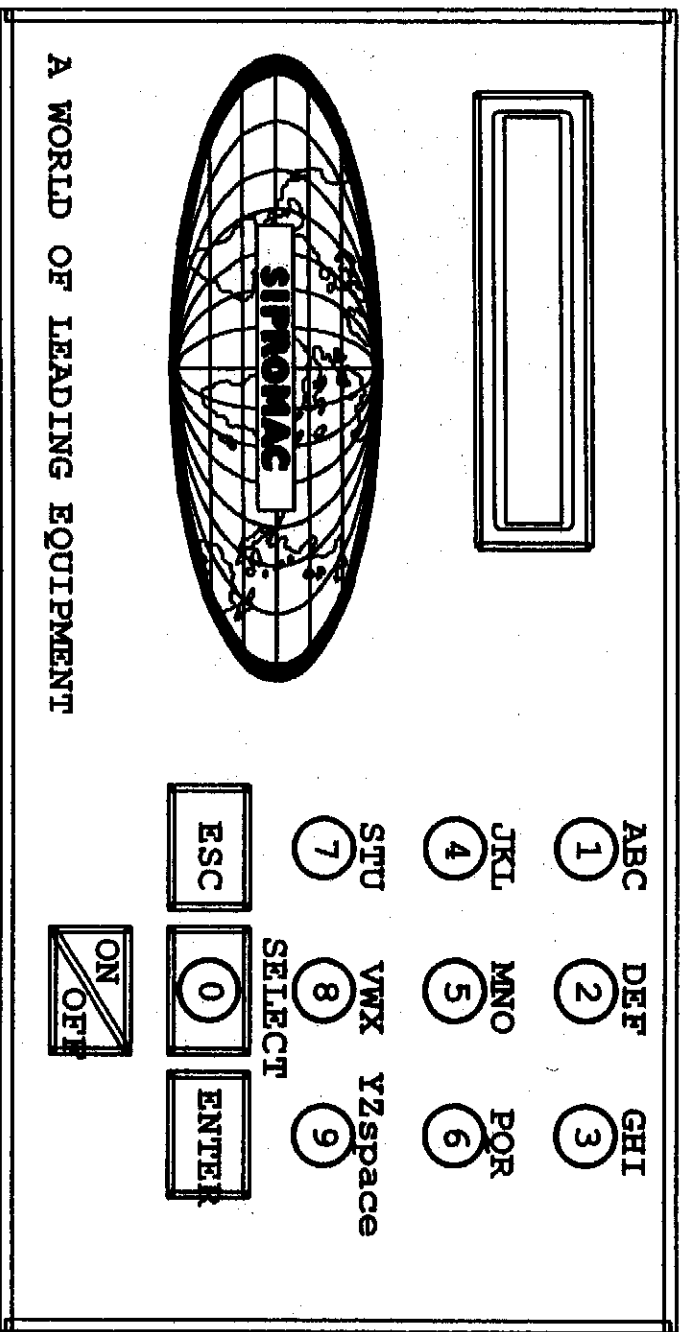
- Programs menu:
  - "Pxx NAME"

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: R 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 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.

4.1.5 "COVER RISE ERROR" message is displayed on LCD (automatic units):

The input signal of the middle position switch is not picked up during cover positioning.

- Check limit switch adjustment.

#### 4.1.6 "COVER FALL ERROR" message is displayed on LCD (automatic units):

The input signal of the left position switch or the right position switch is not picked up during cover positioning.

- Check left or right proximity 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.

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 menustructure in Figure 3.3.1

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:

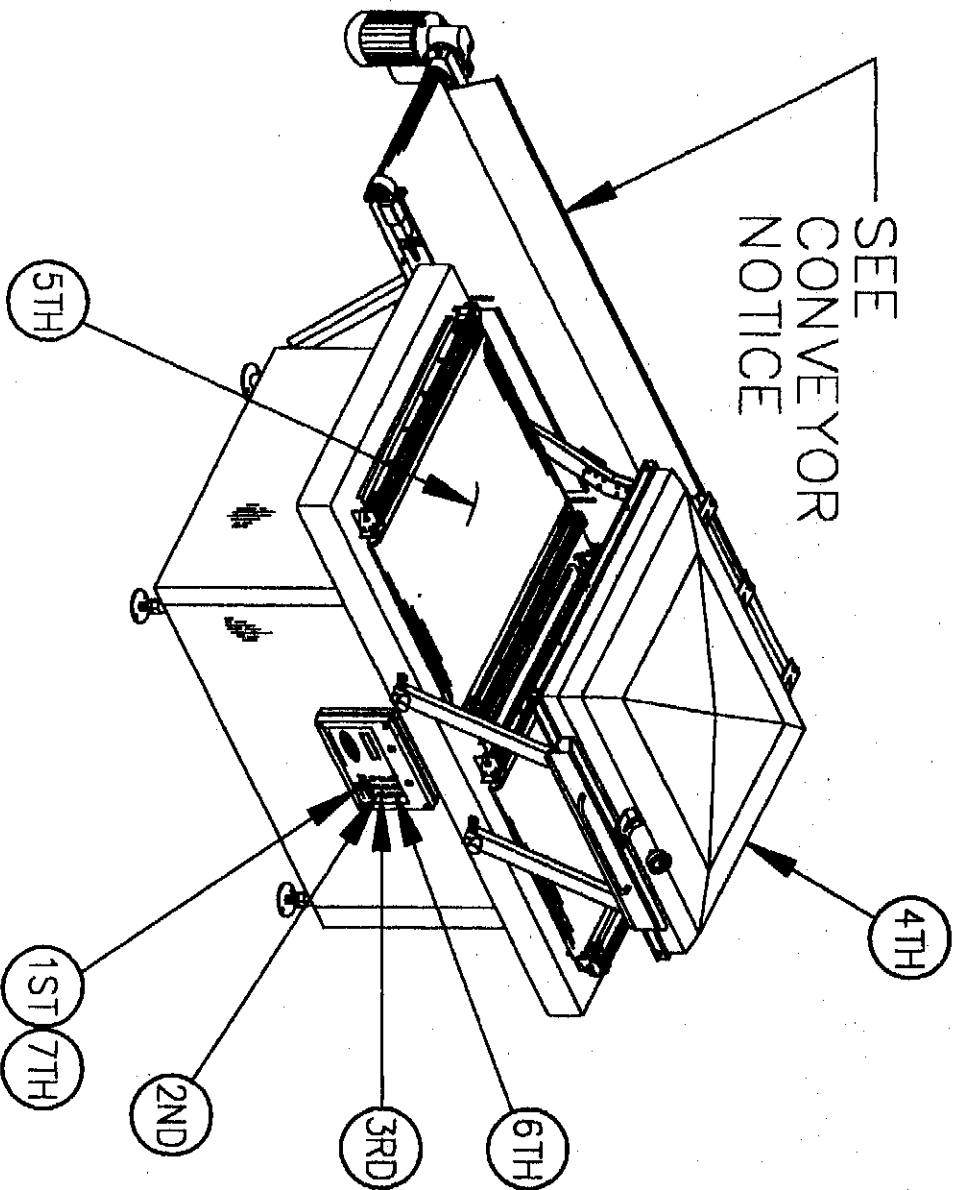
420A, 450T, 450A, 550A, 600A, 620A, 650A AND 700A

IN ORDER TO RESPECT NSF REGULATIONS:

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

# **MODEL 700A**

(SHOWN WITH REAR CONVEYOR)



# 700A OPERATING GUIDE

- 1 st Push **POWER ON**.
- 2 nd Adjust vacuum level, gas level and seal time, if or as needed (refer to sec. 3.3).
- 3 rd Select manual, semi-automatic or automatic mode.
- 4 th Place the chamber half way down on one side (left or right).  
**IMPORTANT:Never push start when the chamber is in the middle.**
- 5 th Place products on the opposite side.
- 6 th To change vacuum level, gas level or seal time, push stop button before attempting to change.
- 7 th When the machine is stopped during a vacuum cycle, the ON/OFF button must be pressed, then the start button to be able to re-start the machine.

## CONVEYOR NOTICE (700A ONLY)

The rear conveyor is designed to unload either towards the right or left, simply unbolt the conveyor place towards side desired and bolt in appropriate slots, place product guide fastened with pillow block on the exit end of the conveyor, set motor rotation to turn the opposite way.

**SEE DRAWING #010-0023**

**ATTN -RE-ADJUST & REALIGN CONVEYOR BELT AFTER INSTALLING CONVEYOR ON THE MACHINE**

**MACHINE SHOULD BE STRAIGHT & LEVEL**

## HOW TO ADJUST SPEED OF COVER

- 1 st Machine should be level(adjustable feet)
- 2 nd Put machine in automatic mode,vacuum time 99.5%.  
Ajust cylinder pressure regulator at 80 PSI.
- 3 rd Bring cover close to the table,start machine and adjust the exhaust flow control on the lifting solenoid valve (See drawing #007-0039) to the desired speed.
- 4 rd Adjust the exhaust flow control on the chamber lowering solenoid valve(turning screw clockwise will reduce the speed).

## MACHINE STOPPED WITH CHAMBER UNDER VACUUM:

### HOW TO RE-START THE MACHINE:

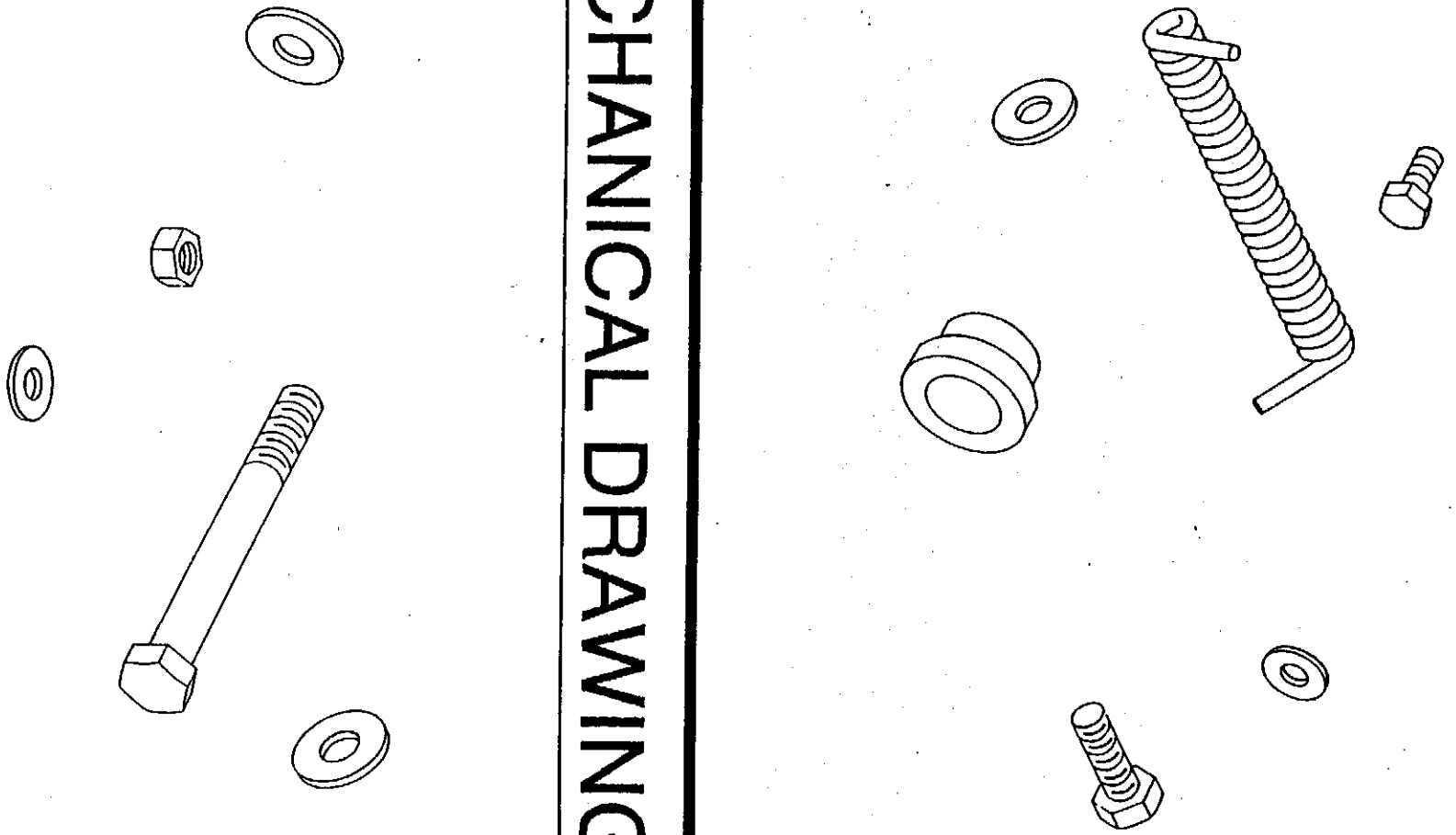
- 1 st Press on/off switch on the membrane to stop the machine.
- 2 nd Press on/off again to re-start the machine(vacuum valve will open and machine will continue its cycle).
- 3 rd Press start to have the automatic movement of cover.

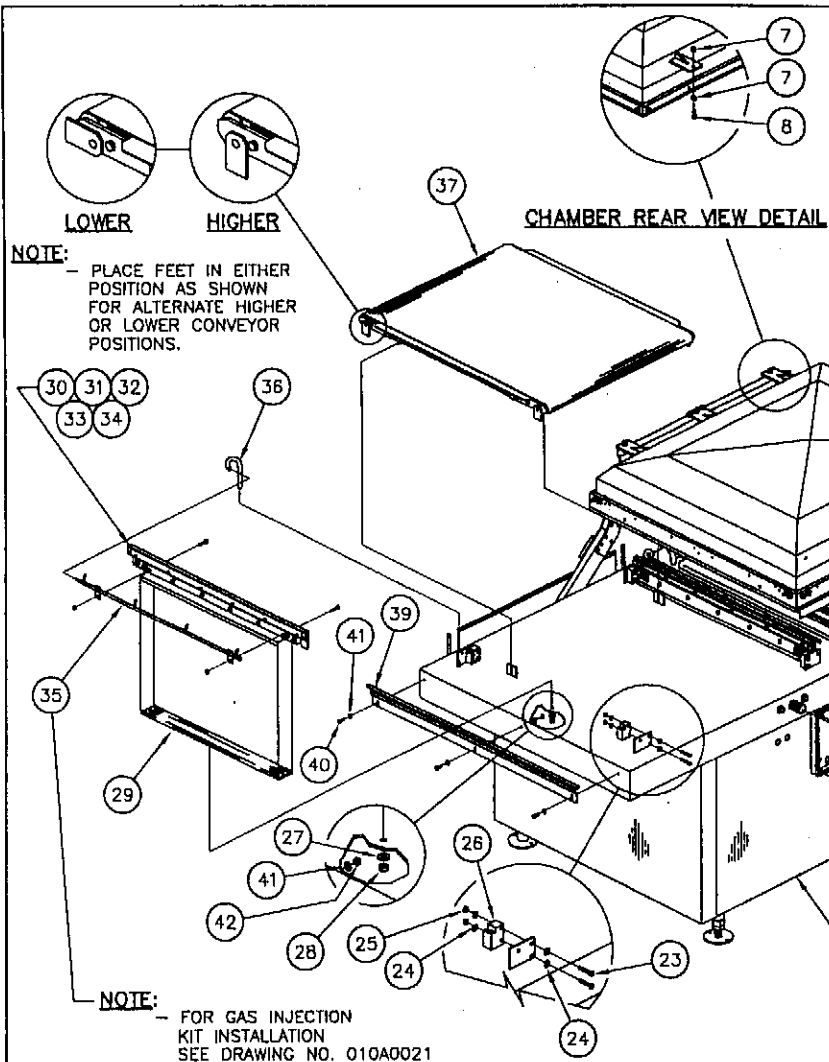
### MAINTENANCE

- **VERY IMPORTANT:** Always be sure that the air oiler contains a sufficient quantity of oil (food grade).
- Grease all bearings and springs regularly.
- Adjust conveyor when necessary.
- **IMPORTANT:** Tighten belts moderately.
- See pump manual for pump maintenance.



# MECHANICAL DRAWING





38	056-0167	KEY 1/4" SQ x 1" W/ ROUNDED END	4
39	004-0401	TABLE END SECURITY PRE-ASS'Y	2
40	051-0190	BOLT 1/4"-20 x 3/4" HEX. S/S	6
41	051-0740	WASHER 1/4" FLAT S/S	12
42	051-0580	NUT 1/4"-20 S/S	6
43	003-0107	SECURITY BUMPER HOLDER 500	4
44	051-0097	SCREW 6-32 x 3/8" TYPE F PAN PHIL S/S	12
45	004A0447	JUNCTION BOX PRE-ASS'Y.	1
46	003A0126	JUNCTION BOX (LEFT)	1
47	051-0192	SCREW 1/4"-20 x 3/4" PAN PHIL S/S	8

ITEM	PART #	DESCRIPTION	QT.
1	005-0472	STRUCTURE ASSEMBLY	1
2	005-0397	CENTRAL SHAFT ASSEMBLY	1
3	005-0473	8" COVER ASSEMBLY	1
4	005-0474	12" COVER ASSEMBLY (OPTION)	1
5	005-0482	8" COVER ASS'Y (MBC OR MBCTBS) (OPTION)	1
6	005-0483	12" COVER ASS'Y (MBC OR MBCTBS) (OPTION)	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	2
11	004-0213	COVER HANDLE ASSEMBLY	1
12	005-0359	ARM SUPPORT ASSEMBLY	2
13	008-0368	SPACER	2
14	004A0381	COVER ARM ASSEMBLY	2
15	105-0430	COLLARS W/ 5/16"-18 NC. SET SCREW	2
16	051-0422	HEX. BOLT 3/8"-18 NC. X 3 1/4" S/S	2
17	051-0783	FLAT WASHER (THICK) 3/8" S/S	4
18	051-0822	HEX. NUT 3/8"-16 NC. NYLON LOCK S/S	2
19	057-0013	SHAFT END CAP	2
20	005-0392	FRONT P.C. BOARD SUPPORT ASSEMBLY	1
21	052-2045	FLAT WASHER 1/4" COPPER	4
22	051-0591	ACORN NUT 1/4"-20 NC. S/S	4
23	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	18
24	051-0740	FLAT WASHER 1/4" S/S	32
25	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	16
26	009-0042	SEAL BAR GUIDE BLOCKS	8
27	051-0780	FLAT WASHER 3/8" S/S	4
28	051-0820	HEX. NUT 3/8"-18 NC. S/S	4
29	005-0391	BELLOWS ASSEMBLY	4
30	005A0357	SEAL BAR ASS'Y W/ SUPPORT	4
31	005A0358	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	4
32	005A0369	SEAL BAR ASS'Y (TBS OPT.)	4
33	005A0386	SEAL BAR ASS'Y (MBC OPT.)	4
34	005A0368	SEAL BAR ASS'Y (MBCTBS OPT.)	4
35	005A0350	GAS INJECTION BAR ASSEMBLY (OPT.)	4
36	008-0464	GAS INJECTION CONN. TUBE (OPT.)	4
37	005-0403	TABLE CONVEYOR ASSEMBLY	2

20

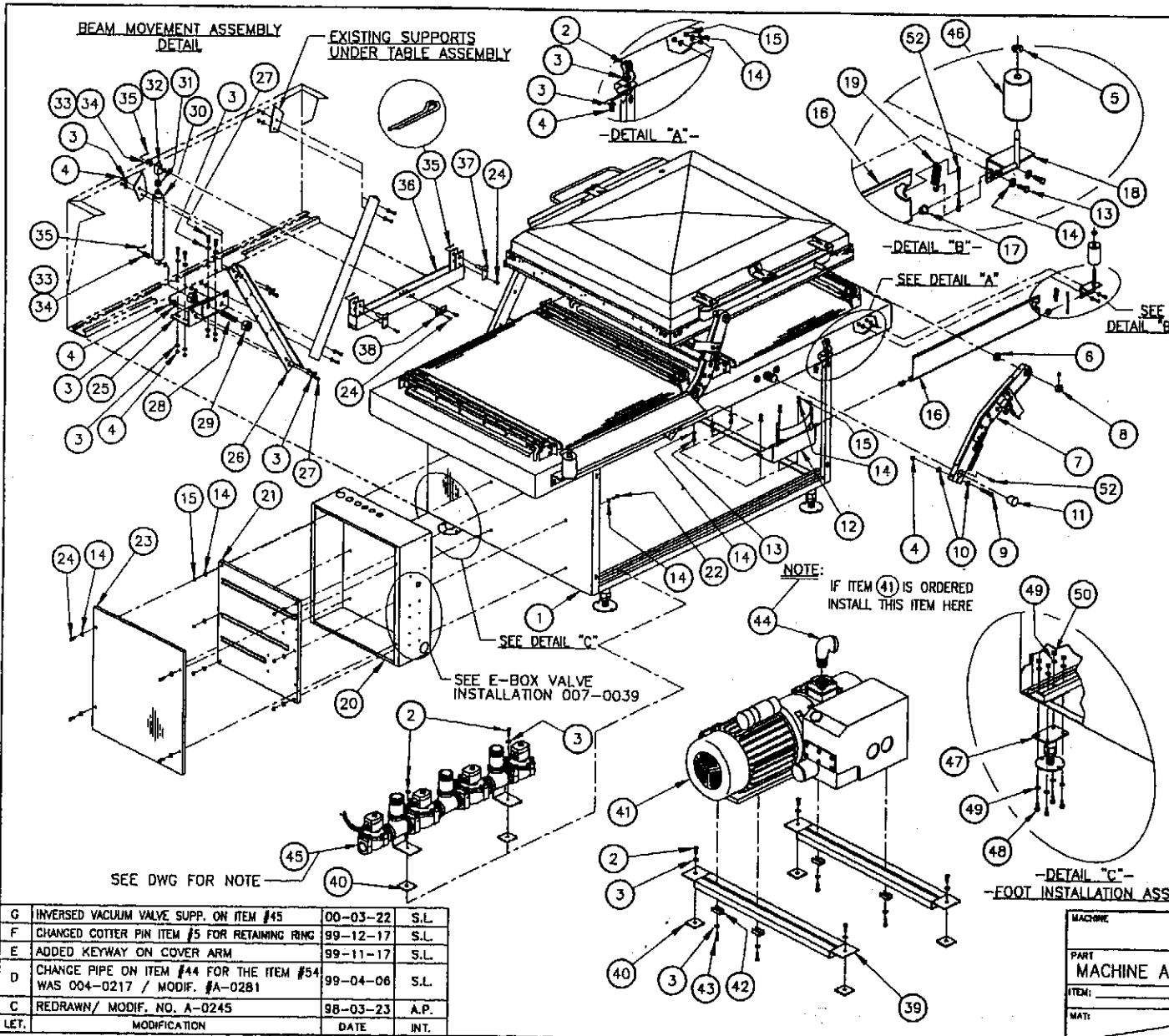
005-0395

E	MODIFIED VIEW FRONT ARMS W/ J-BOXES	00-11-14	S.L.
D	ADDED KEYWAY ON COVER ARM	99-11-17	S.L.
C	ITEM #22 051-0591 & #21 051-0740 QTY WAS 2/ MODIF. No. A-0252	98-04-02	A.P.
B	REDRAWN/ MODIF. No. A-0245	98-03-18	A.P.
LET.	MODIFICATION	DATE	INT.

**NOTE:**  
- FOR REAR CONVEYOR OPTION SEE DRAWING NO. 010-0023

MACHINE	700A	METRIC TOLERANCE 0 ± .5 .5 ± .06 .005 ± .0008 ANGLE ± 1°	INCH TOLERANCE .0 ± .015 .05 ± .005 .002 ± .0005 N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	MACHINE ASSEMBLY FRONT VIEW	CNC		BRAND M-1
ITEM:		DATE	98-03-18	QT. 1
MAT:		DATE		005-0395





ITEM	PART #	DESCRIPTION	QT.
1	005-0395	MACHINE ASSEMBLY FRONT VIEW	1
2	051-0350	HEX. BOLT 3/8"-18 NC. X 3/4" S/S	8
3	051-0780	FLT. WASHER 3/8" S/S	48
4	051-0820	HEX. NUT 3/8"-18 NC. S/S	20
5	058-0315	EXT. RETAINING RING. 3/8" S/S	2
6	008-0388	SPACER	2
7	005-0405	REAR COVER ARM ASSEMBLY	2
8	105-0430	COLLAR 3/4" X 1 1/4" X 9/16" W/ SCREW S/S	2
9	051-0420	HEX. BOLT 3/8"-18 NC. 3" S/S	2
10	051-0783	FLAT WASHER 3/8" (THICK) S/S	4
11	057-0013	SHAFT END CAP	2
12	004-0180	DISCHARGE MIDDLE SUPPORT ASSY	1
13	051-0190	HEX. BOLT 1/4"-20 NC. X 3/4" S/S	7
14	051-0740	FLAT WASHER 1/4" S/S	30
15	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	13
16	004-0182	DISCHARGE ASSEMBLY	2
17	002-0372	BUSHING	4
18	004-0181	DISCHARGE END SUPPORT ASSY	2
19	077-0090	SPRING	2
20	005-0401	ELECTRICAL BOX ASSEMBLY	1
21	004-0218	FALSE BOTTOM ELECTRICAL BOX	1
22	051-0210	HEX. BOLT 1/4"-20 NC. X 1" S/S	8
23	004-0250	ELECTRICAL BOX COVER ASSY	1
24	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	8
25	004-0208	CYLINDER SUPPORT ASSEMBLY	1
26	001-1533	CYLINDER SUPPORT REINFORCEMENT	2
27	051-0380	HEX. BOLT 3/8"-18 NC. X 1" S/S	12
28	002-0388	CYLINDER AXIS	1
29	051-0875	HEX. NUT 3/4"-10 NC. S/S	2
30	114-0105	CYLINDER	1
31	051-0845	HALF NUT 1/2"-20 NF. S/S	1
32	002-0387	CYLINDER EXTENSION	1
33	058-0060	SPACER	2
34	058-0050	SPACER	8
35	058-0120	COTTER PIN 1/8" X 1"	4
36	004-0191	BEAM MOVEMENT ASSEMBLY	1
37	004-0192	ARM AXIS MOVEMENT ASSY	2
38	004-0193	UPPER CYLINDER AXIS ASSEMBLY	1
39	005-0354	PUMP SUPPORT ASSEMBLY	2
40	005-0088	PUMP SUPPORT	8
41	125-0080	PUMP 250 M (OPTION)	1
42	001-0199	SUPPORT	4
43	052-4240	HEX. BOLT M10 X 30 S/S	4
44	103-0095	ELBOW STREET 2" NPT ZINC	1
45	004-0505	VACUUM/ ATMOSPHERE VALVE ASSY	1
46	002-0412	PRODUCT ROLLER	2
47	005-0393	LEGS ASSEMBLY	4
48	051-0300	HEX. BOLT 5/16"-18 NC. X 3/4" S/S	16
49	051-0780	FLAT WASHER 5/16" S/S	32
50	051-0600	HEX. NUT 5/16"-18 NC. S/S	16
51	058-0187	KEY 1/4" SQ X 1" W/ ROUNDED END	4
52	004-0448	DISCHARGE PLATE LANYARD	2

NOTE: - FOR REAR CONVEYOR INSTALLATION SEE DRAWING NO: 010-0023

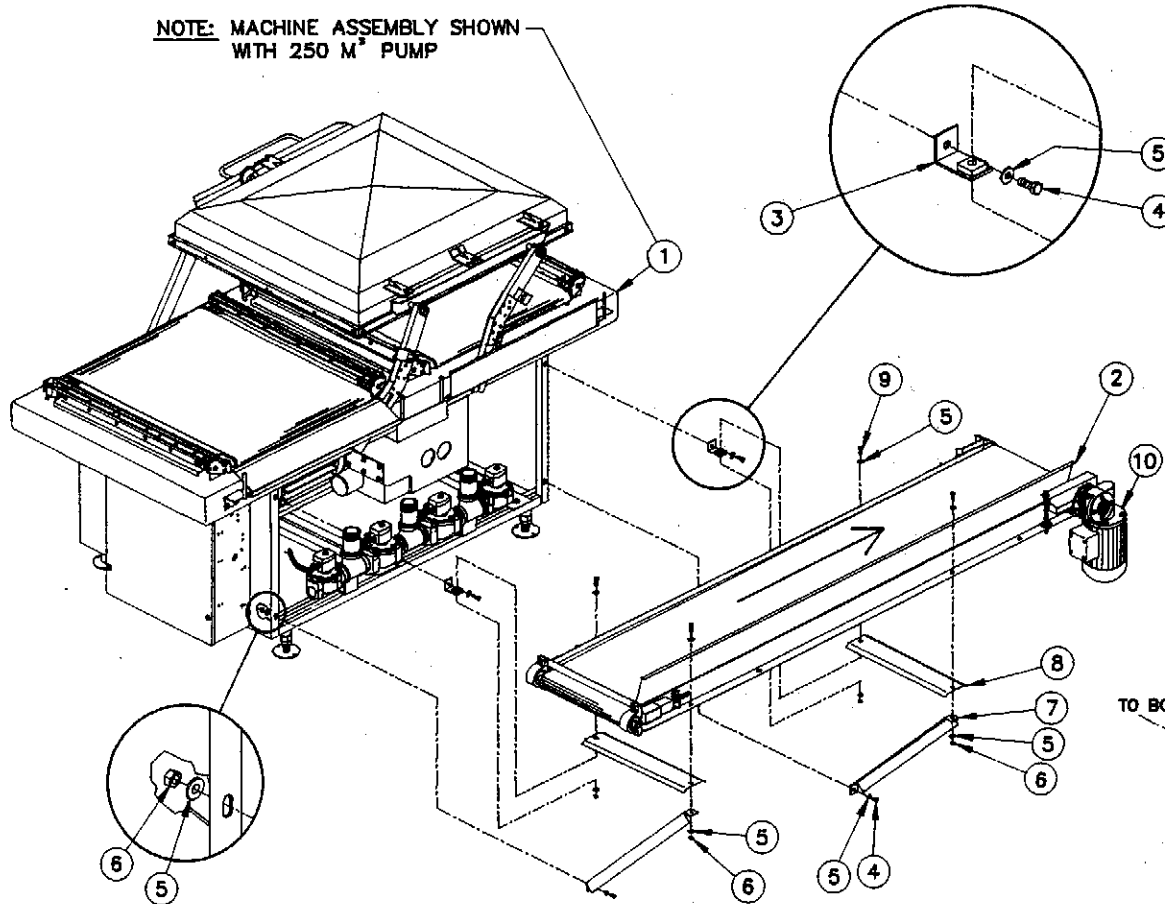
G	INVERSED VACUUM VALVE SUPP. ON ITEM #45	00-03-22	S.L.
F	CHANGED COTTER PIN ITEM #5 FOR RETAINING RING	99-12-17	S.L.
E	ADDED KEYWAY ON COVER ARM	99-11-17	S.L.
D	CHANGE PIPE ON ITEM #44 FOR THE ITEM #54 WAS 004-0217 / MODIF. #A-0281	99-04-06	S.L.
C	REDRAWN/ MODIF. NO. A-0245	98-03-23	A.P.
LET.	MODIFICATION	DATE	INT.

MACHINE	700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC
PART	MACHINE ASSEMBLY REAR VIEW		0 ± .005	.00 ± .015	
ITEM:	CNC:	SCALE	0 ± .005	.0002 ± .0005	ST-GERMAIN DE GRANTHAM
MAT:	APP. BY A. PROVENCHER	DATE 98-03-23	ANGLE ± 1°	N.T.S.	QUEBEC CANADA
		DATE			NO. 005-0396

1005-0396

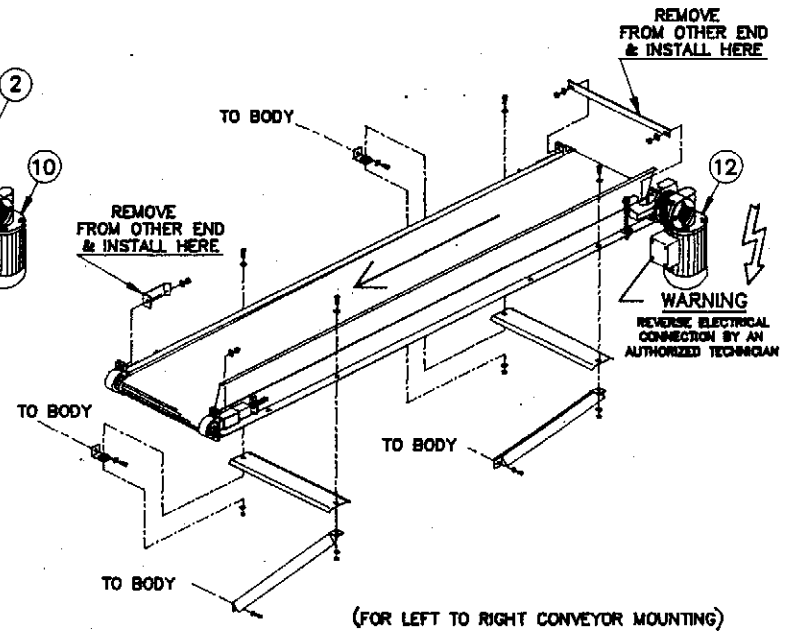
NOTE: MACHINE ASSEMBLY SHOWN WITH 250 M<sup>2</sup> PUMP

ITEM	PART #	DESCRIPTION	QT.
1	005-0396	MACHINE ASSEMBLY REAR VIEW	1
2	005-0398	REAR CONVEYOR ASS'Y (OPTION)	1
3	004-0370	REAR CONVEYOR SUPPORT PRE-ASS'Y	2
4	051-0360	HEX. BOLT 3/8"-16 x 1" S.S.	4
5	051-0780	FLAT WASHER 3/8" S.S.	16
6	051-0620	HEX. NUT 3/8"-16 S.S.	8
7	001-1473	REAR CONVEYOR SUPPORT	2
8	001-1486	CONVEYOR STRAP SUPPORT	2
9	051-0380	HEX. BOLT 3/8"-16 x 1 1/2" S.S.	4
10	005-0480	MOTOR/GEARBOX ASSEMBLY	1



⇒ DETAIL ⇒

(RIGHT TO LEFT CONVEYOR MOUNTING SHOWN)



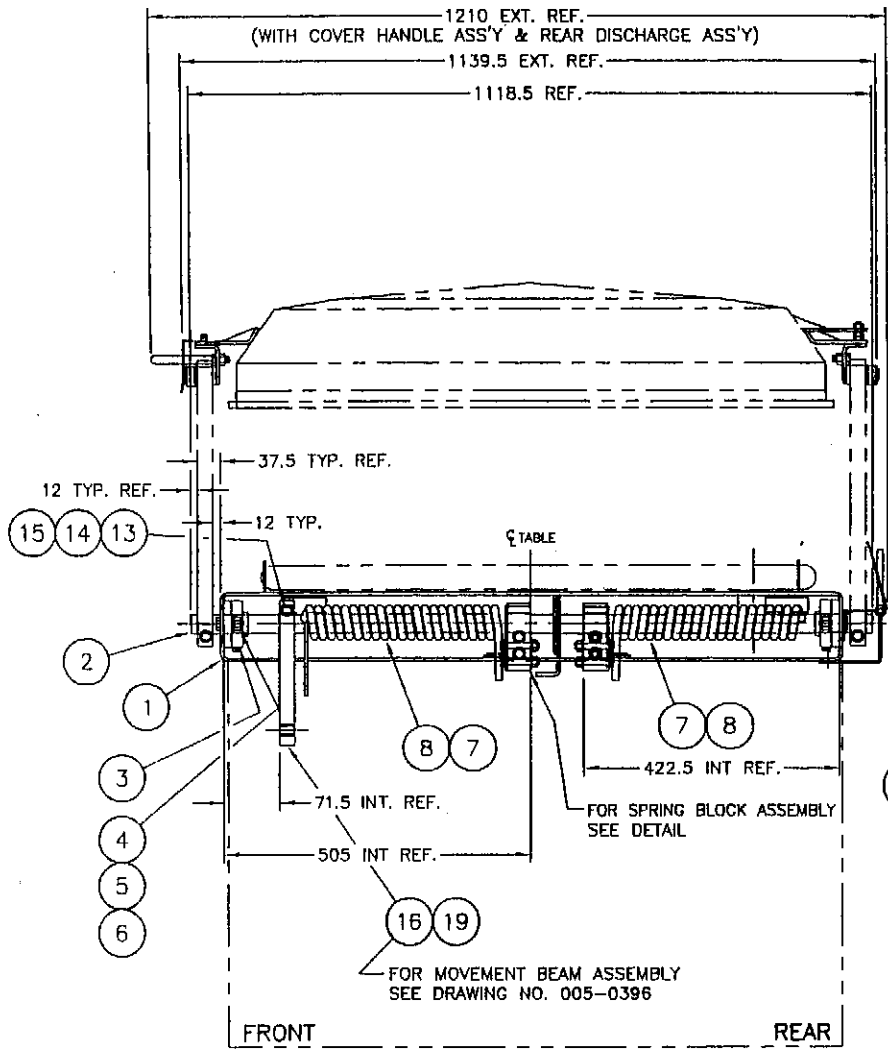
(FOR LEFT TO RIGHT CONVEYOR MOUNTING)

-REAR CONVEYOR OPTION-

MACHINE	700A		METRIC TOLERANCE 0 ± .5 .0 ± .05 .000 ± .0005	INCH TOLERANCE 0 ± .015 .00 ± .0005 N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PART	REAR CONVEYOR INSTALLATION				
ITEM:	CWC:	SCALE: 1:1	DATE: 97-02-07	QT.:	1
MAT:	APP.:	DATE:	DATE:	1010-0023	

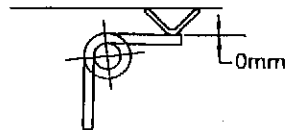
E	REDRAWN/ REMOVE ITEM NO.7 & 8/ITEM NO.3 HAS 001-1473	97-02-07	A.P.
LET.	MODIFICATION	DATE	INT.

29

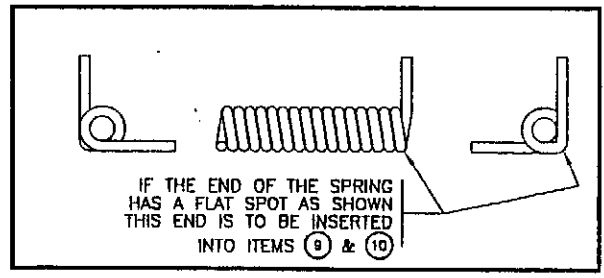
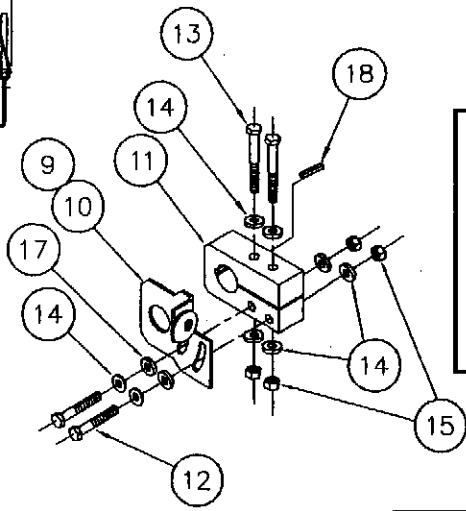


**-SPRING ADJUSTMENT PROCEDURE-**

- A- PLACE COVER UP(ARM VERTICAL) TO FREE TENSION OF SPRINGS.
- B- LOOSEN BOLTS ITEMS (12) ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y (ITEMS (9) & (10)).
- C- TURN SPRING/BLOCK ASSEMBLY TO OBTAIN 0mm (0°) AS SHOWN BELOW.



- D- RETIGHTEN BOLTS ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASSY.(ITEMS (11)).



**-SPRING BLOCK ASSEMBLY-  
--DETAIL--**

ITEM	PART #	DESCRIPTION	QT.
1	005-0394	TABLE ASSEMBLY	1
2	009A0054	CENTRAL SHAFT	2
3	075-1650	FLANGED BEARING W/ GREASE FITTING 90°	4
4	051-0441	HEX. BOLT 1/2"-13 NC. 1 1/2" S/S	8
5	051-0630	HEX. NUT 1/2"-13 NC. 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/ SUPPORT PLATE ASSEMBLY	2
10	004A0170	RIGHT/ SUPPORT PLATE ASSEMBLY	2
11	002A0319	SPRING BLOCK	4
12	052-0775	HEX. BOLT 3/8"-24 NC. X 2 1/2" ZINC	6
13	052-0777	HEX. BOLT 3/8"-24 NC. X 3" ZINC	10
14	052-2060	FLAT WASHER 3/8" ZINC	36
15	052-3128	HEX. NUT 3/8"-24 NC. ZINC	18
16	004-0382	AUTO MOVEMENT ARM ASS'Y	1
17	052-2071	CONTACT WASHER 3/8" STEEL	8
18	056-0188	KEY 1/4" SQ x 1 1/2" W/ ROUNDED END	4
19	056-0187	KEY 1/4" SQ x 1" W/ ROUNDED END	2

C	REDRAWN / WITH NEW SPRING BLOC	99-11-16	S.L.
LET.	MODIFICATION	DATE	INT.

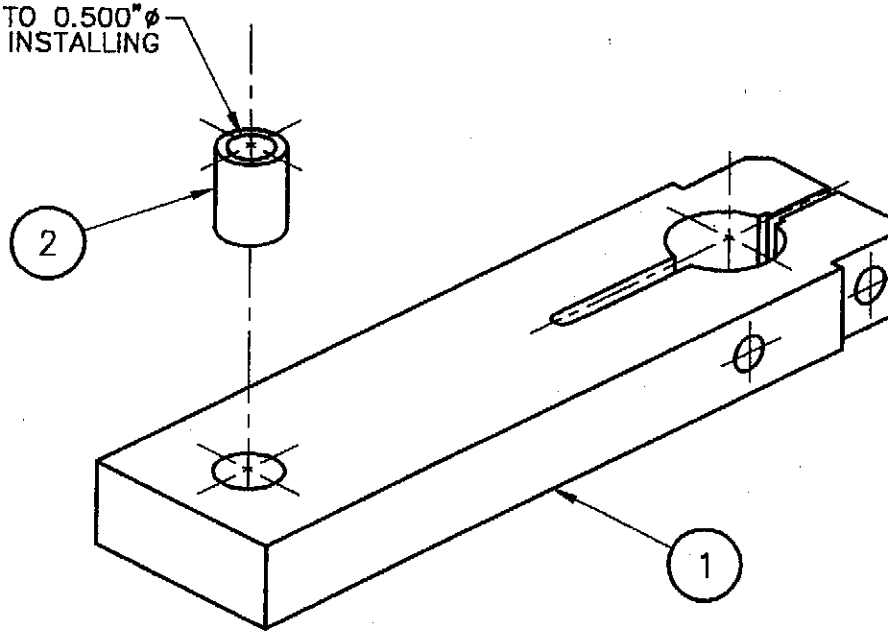
MACH-NE	700A	METRIC TOLERANCE 0 ± .03 .00 ± .005 1.00 ± .005 ANGLE ± 1°	INCH TOLERANCE 0 ± .015" .00 ± .005" 1.000 ± .0005" N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	CENTRAL SHAFT ASSEMBLY	SCALE	DT.	1
ITEM:		DATE	99-11-16	NO.
APP.	SYLVAIN L.	DATE		005A0397

U05A0397

004A0382

ITEM	PART #	DESCRIPTION	QT.
1	002A0360	AUTO. MOVEMENT ARM	1
2	075-0120	BUSHING PLAIN 1/2" x 3/4" x 1" BR	1

REAM TO 0.500"  $\phi$   
AFTER INSTALLING



24

MACHINE		680A & 700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC	
PART		AUTO. MOVEMENT ARM ASS'Y		0. $\pm$ .5	.0 $\pm$ .015"	ST-GERMAIN DE GRANTHAM	
ITEM:		CNC:		.0 $\pm$ .05	.00 $\pm$ .005"	QUEBEC CANADA	
MAT:		APP.		.00 $\pm$ .005	.000 $\pm$ .0005"	SCALE _____	
LET.		MODIFICATION		ANGLE $\pm$ 1'	N.T.S.	QT. 2	
DATE		INT.		DATE 99-12-21		NO. 004A0382	

A REDRAWN

99-12-21

S.L.

LET.

MODIFICATION

DATE

INT.

MAT:

DWG BY SYLVAIN L.

DATE 99-12-21

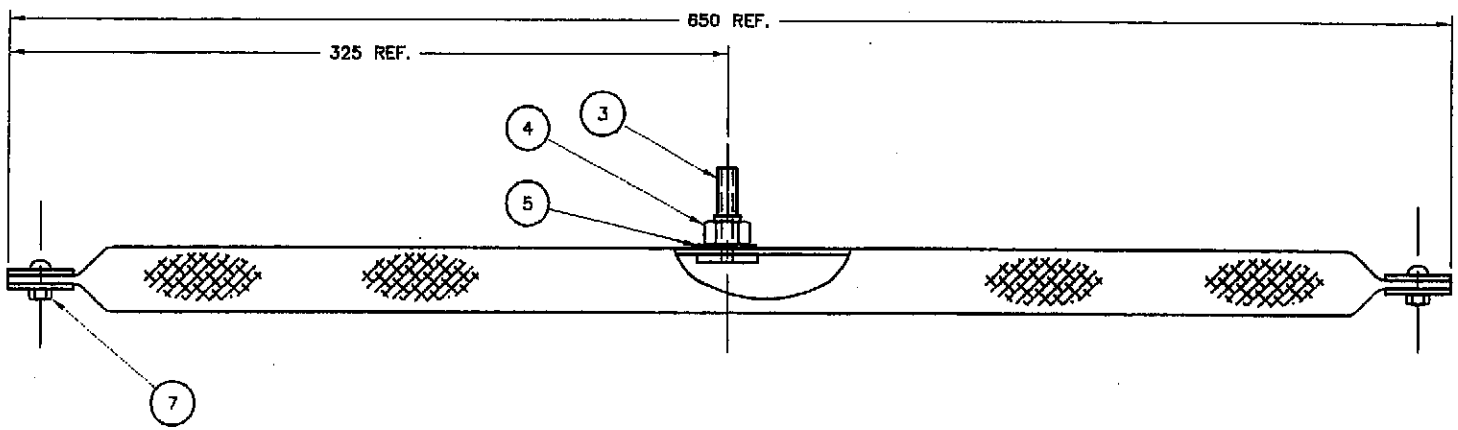
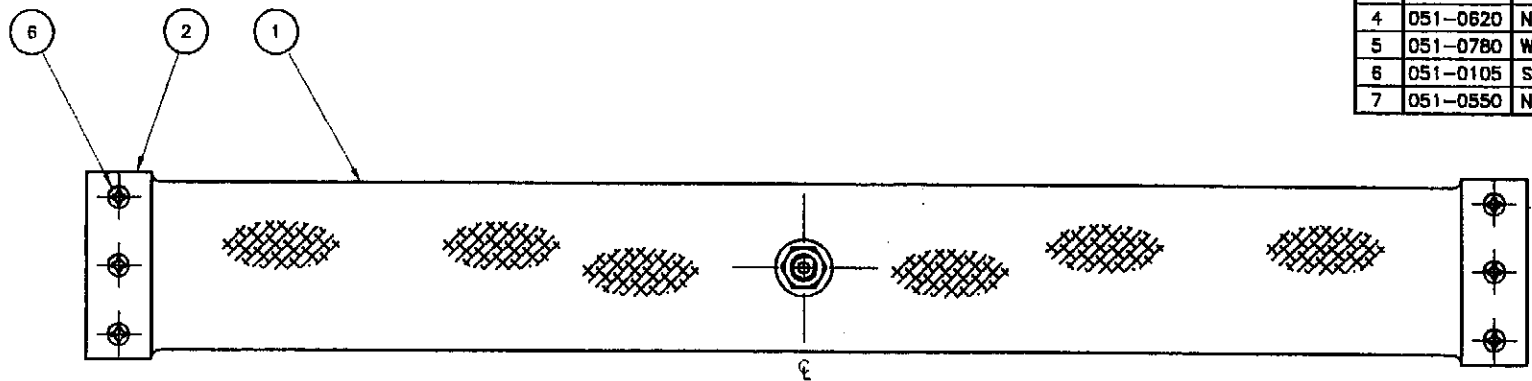
NO.

APP.

DATE

004A0382

ITEM	PART #	DESCRIPTION	QT.
1	008-0372	BELLOWS	1
2	001-0899	BELLOWS CLAMPS	4
3	003-0022	BELLOWS CONNECTOR	1
4	051-0620	NUT 3/8"-16 NC S/S	1
5	051-0780	WASHER 3/8" # FLAT S/S	1
6	051-0105	SCREW #8-32 NC X 7/16" PAN PHIL S/S	6
7	051-0550	NUT #8-32 NC S/S	6



25

1005 - 0391

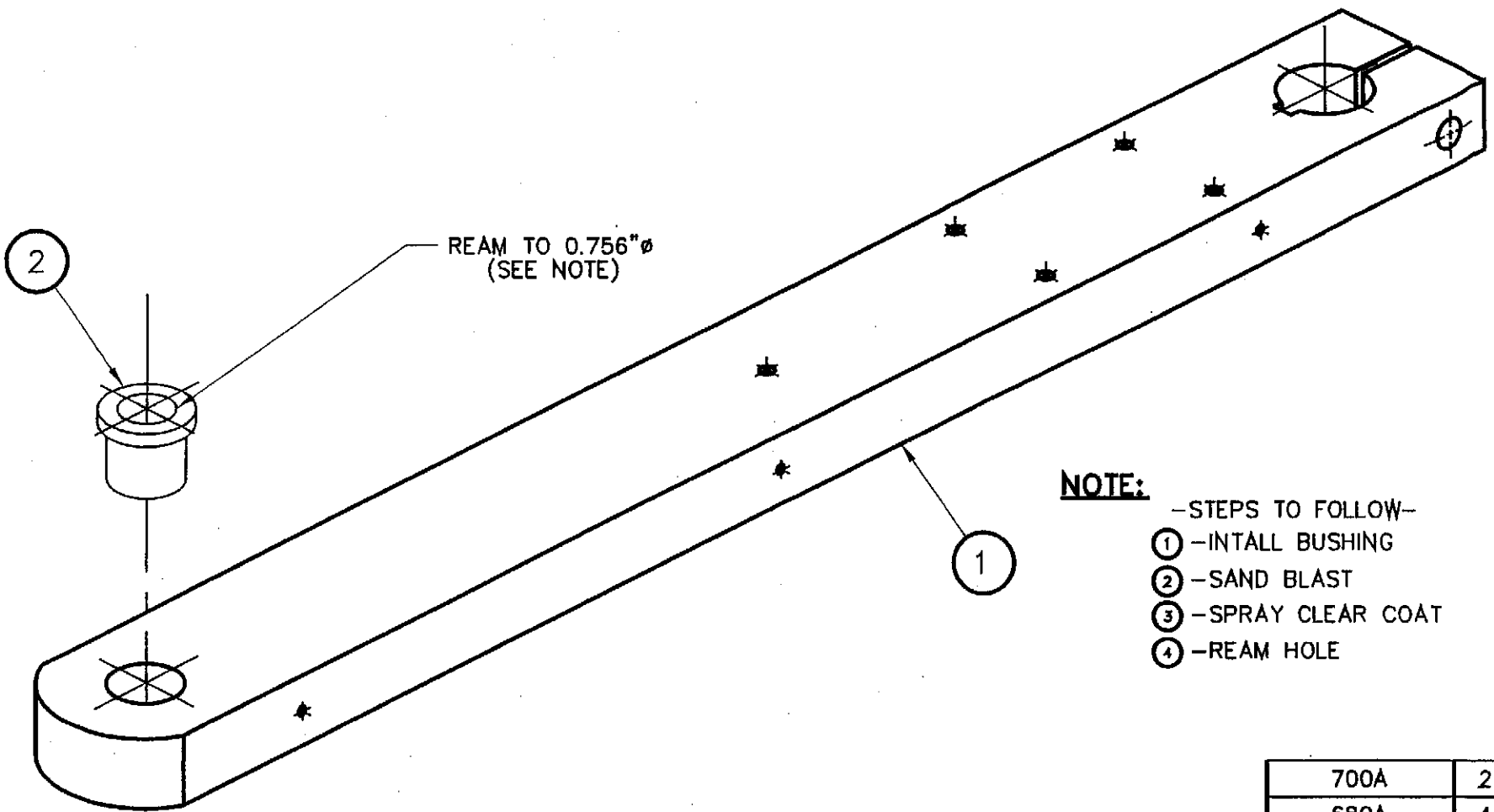
REV.	MODIFICATION	DATE	INT.
E	A & R 880A SEE 005-0651	00-02-11	S.L.
D	ITEM #8 051-0105 WAS 051-0108	98-04-06	A.P.
C	ADDED 880A WAS 005-0435	97-04-22	A.P.
B	REDRAWN	87-01-14	A.P.

MACH#	700A	METRIC TOLERANCE D. # .5 0 ± .05 .000 ± .0005 ANGLE ± 1°	NON TOLERANCE D. # .015 .00 ± .005 .000 ± .0005 H.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	BELLOWS ASSEMBLY	SCALE		QT. 4
ITEM:	CHK:	DATE 97-01-14	IND. 005-0391	
MAT:	BY A. PROCHER	DATE	APP. LT	

004-0381

OBSCURED

ITEM	PART #	DESCRIPTION	QT.
1	002-0361	COVER ARM	1
2	075-0620	BUSHING FLANGED 3/4" x 1" x 1" BRONZE	1



- NOTE:**
- STEPS TO FOLLOW-
  - ① -INSTALL BUSHING
  - ② -SAND BLAST
  - ③ -SPRAY CLEAR COAT
  - ④ -REAM HOLE

26

700A	2
680A	4
MACHINE	QTY

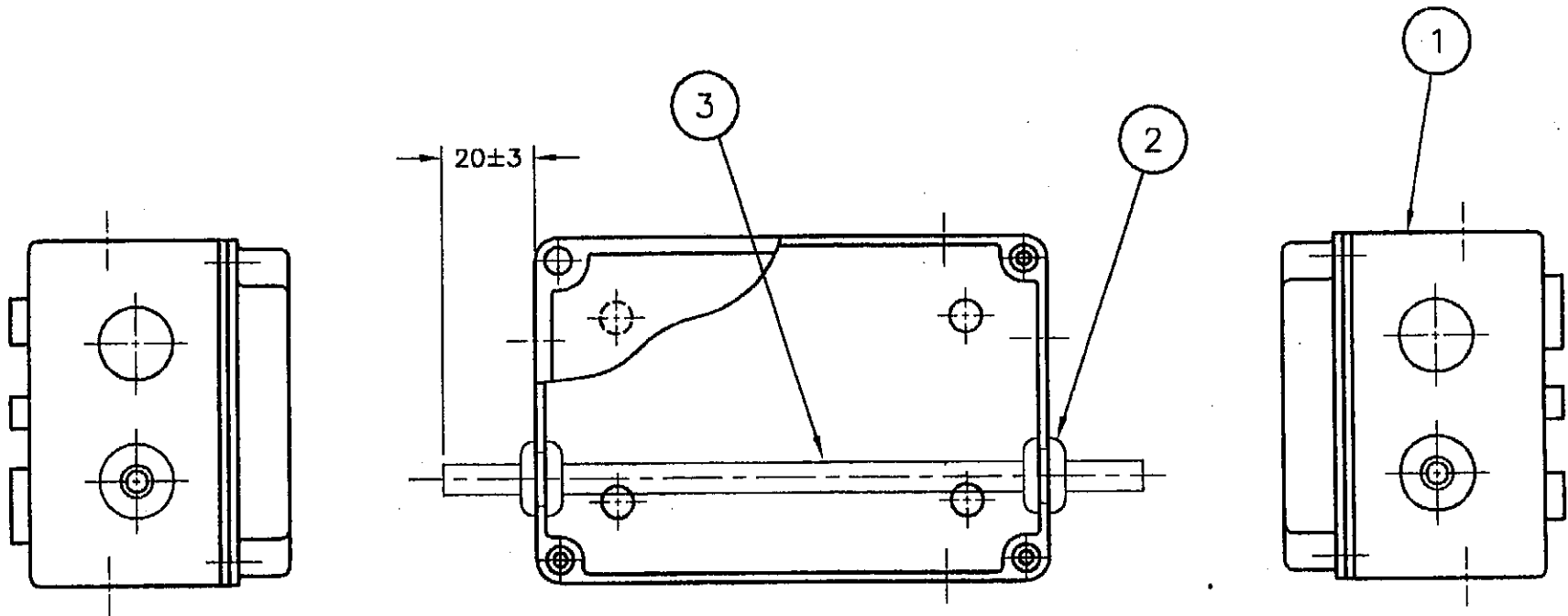
MACHINE	680A & 700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	COVER ARM ASS'Y		0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1'	.0 ± .015" .00 ± .005" .000 ± .0005" N.T.S.	

LET.	MODIFICATION	DATE	INT.
C	MODIFIED VIEW ITEM #1 (ADDED 2 HOLES)	00-11-09	S.L.
B	ADDED KEYWAY	99-11-17	S.L.
A	REDRAWN CAD	99-01-11	S.L.

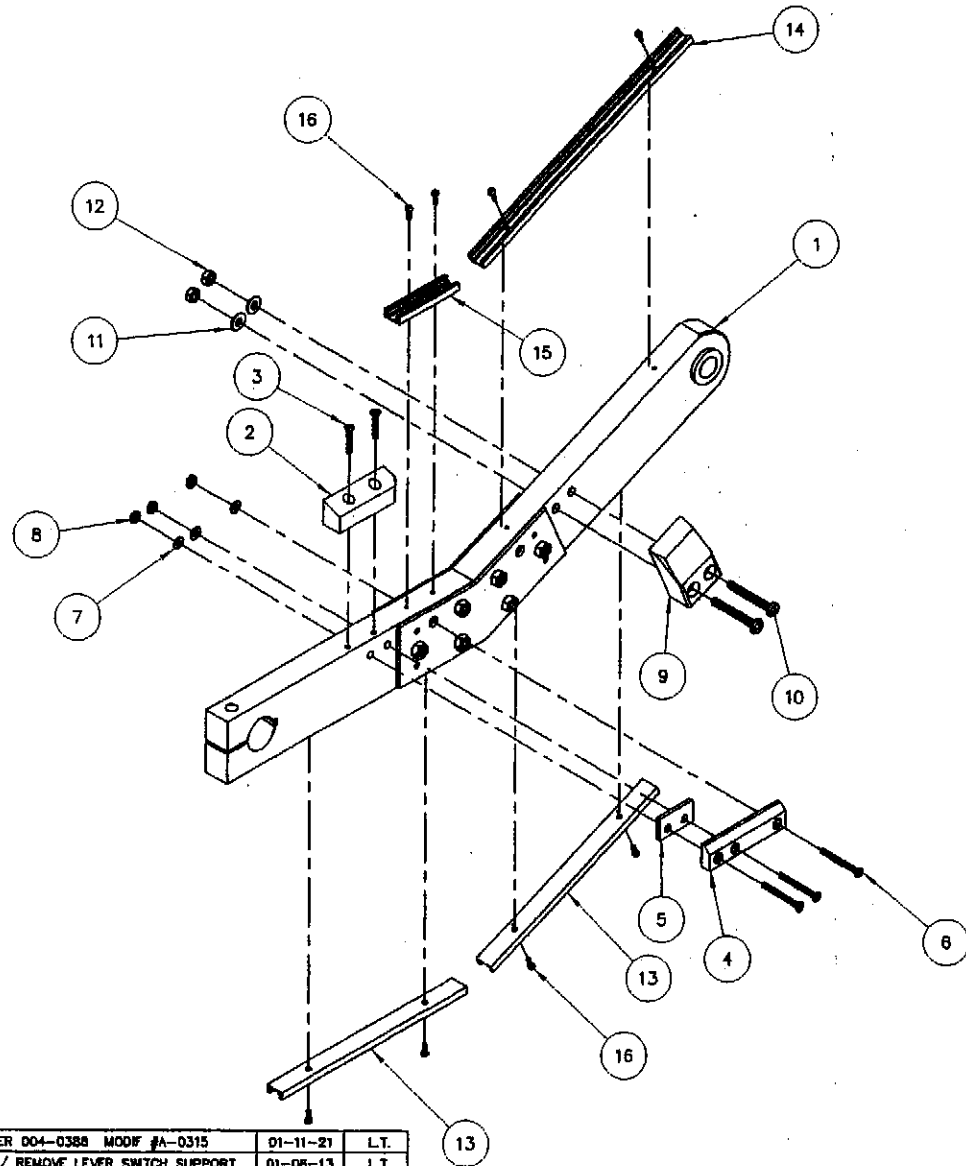
ITEM:	CNC:	DATE	99-01-11	NO.	004-0381
MAT:	DWG BY S. LAROUCHE	DATE	99-01-11	APP.	LT
		DATE		U-J SEE LIST	

004A0447

ITEM	PART #	DESCRIPTION	QT.
1	003A0127	JUNCTION BOX (RIGHT)	1
2	036-0182	GROMMET 17/64 " ID X 5/8" OD	2
3	008A0486	VACUUM HOSE JUNCTION	1



MACHINE 680A & 700A		METRIC TOLERANCE 0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1'	INCH TOLERANCE .0 ± .015" .00 ± .005" .000 ± .0005" N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART JUNCTION BOX PRE-ASS'Y		ITEM: _____	CNC: _____	SCALE: M QT. 1
A REDRAWN	00-11-10 S.L.	MAT: _____	DWG BY SYLVAIN L. DATE 00-11-10	NO. 004A0447
LET. MODIFICATION	DATE INT.		APP.	



ITEM	PART #	DESCRIPTION	QT.
1	004A0175	REAR COVER ARM PRE-ASS'Y	1
2	002-0373	FIRST DISCHARGE STOPPER	1
3	051-0148	SCREW #10-24 NC. x 1" FLAT SLOT S/S	2
4	002-0374	2nd DISCHARGER STOPPER	1
5	001-1498	2 ND DISCHARGE STOPPER SPACER	1
6	051-0158	SCREW #10-24 NC.x1 3/4" FLAT PHIL S/S	3
7	051-0730	WASHER #10 FLAT S/S	3
8	051-0571	NUT #10-24 S/S	3
9	002-0375	THIRD DISCHARGE STOPPER	1
10	051-0284	SCREW 1/4"-20 NC.x2" PAN PHIL S/S	2
11	051-0740	FLAT WASHER 1/4" S/S	2
12	051-0580	NUT 1/4"-20 S/S	2
13	003-0109	SECURITY BUMPER HOLDER 215	2
14	003-0108	SECURITY BUMPER HOLDER 270	1
15	003-0110	SECURITY BUMPER HOLDER 70	1
16	051-0087	SCREW 6-32x 3/8"TYPE F PAN PHIL S/S	8

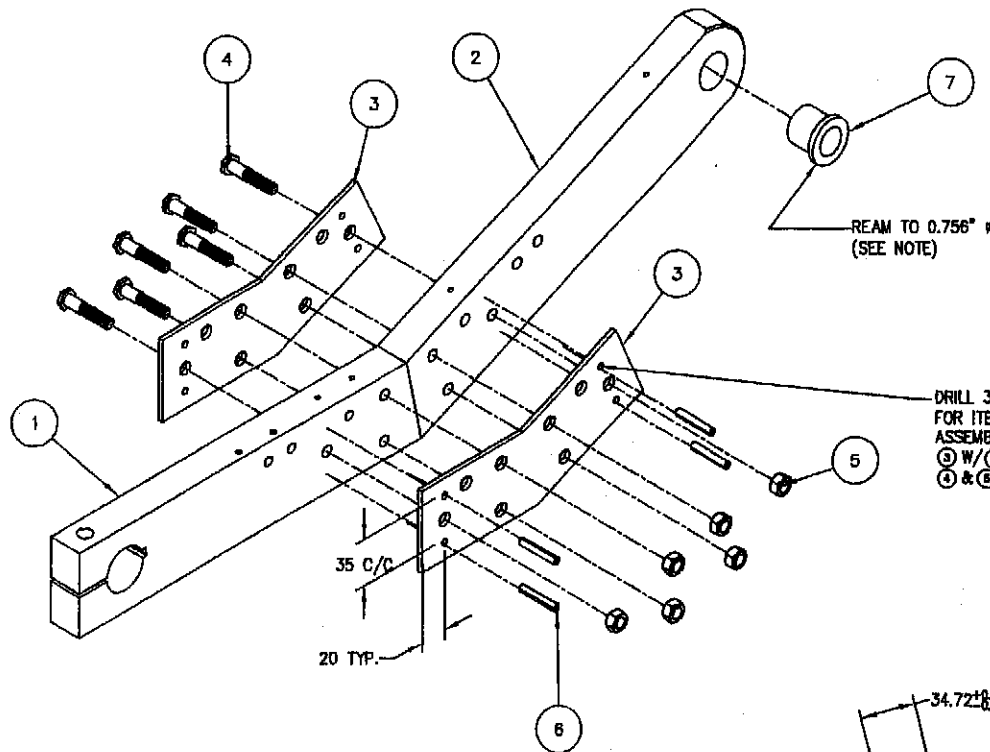
**NOTE:**  
 -RIGHT SHOWN  
 -LEFT OPPOSITE

C	ENLEVER 004-0388 MODIF #A-0315	01-11-21	L.T.
F	REDRAWN / REMOVE LEVER SWITCH SUPPORT	01-08-13	L.T.
LET.	MODIFICATION	DATE	INT.

MACHINE	700A	PRECISION	INCH	SIPROMAC
PART	REAR COVER ARM ASS'Y.	TOLERANCE	± 0.001	ST-GERMAIN DE GRANTHAM
ITEM:		TOLERANCE	± 0.001	QUEBEC CANADA
MAT:		TOLERANCE	± 0.001	N.T.S.
DATE	01-08-13	DATE	01-08-13	QTY 2/1 EA
DATE		DATE		005A0405

1005A0405

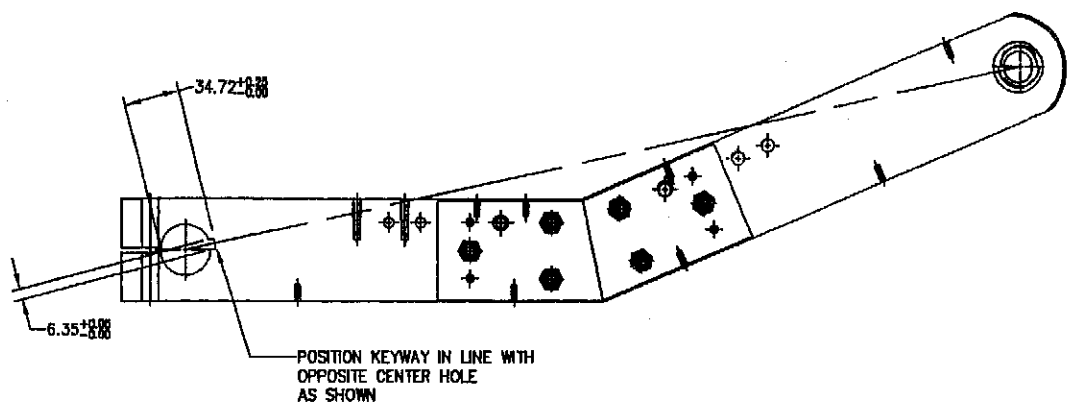




ITEM	PART #	DESCRIPTION	QT
1	002-0382	REAR COVER ARM (1 st PART)	1
2	002-0363	REAR COVER ARM (2nd PART)	1
3	001-0282	COVER ARM UNION	2
4	003-0082	BOLT COVER ARM #1 & #2	6
5	051-0800	HEX. NUT 5/16"-18 NC S/S	6
6	056-0042	SPRING PIN 3/16" x 1 1/4" S/S	4
7	075-0820	BUSHING FLANGED 3/4" x 1" x 1" BR.	1

**NOTE:**  
RIGHT SHOWN  
LEFT OPPOSITE

- STEPS TO FOLLOW**
- 1-ASSEMBLE AS SHOWN WITHOUT BUSHING
  - 2-BROACH KEYWAY AS SHOWN
  - 3-INSTALL BUSHING
  - 4-SAND BLAST
  - 5-SPRAY CLEAR COAT
  - 6-REAM HOLE

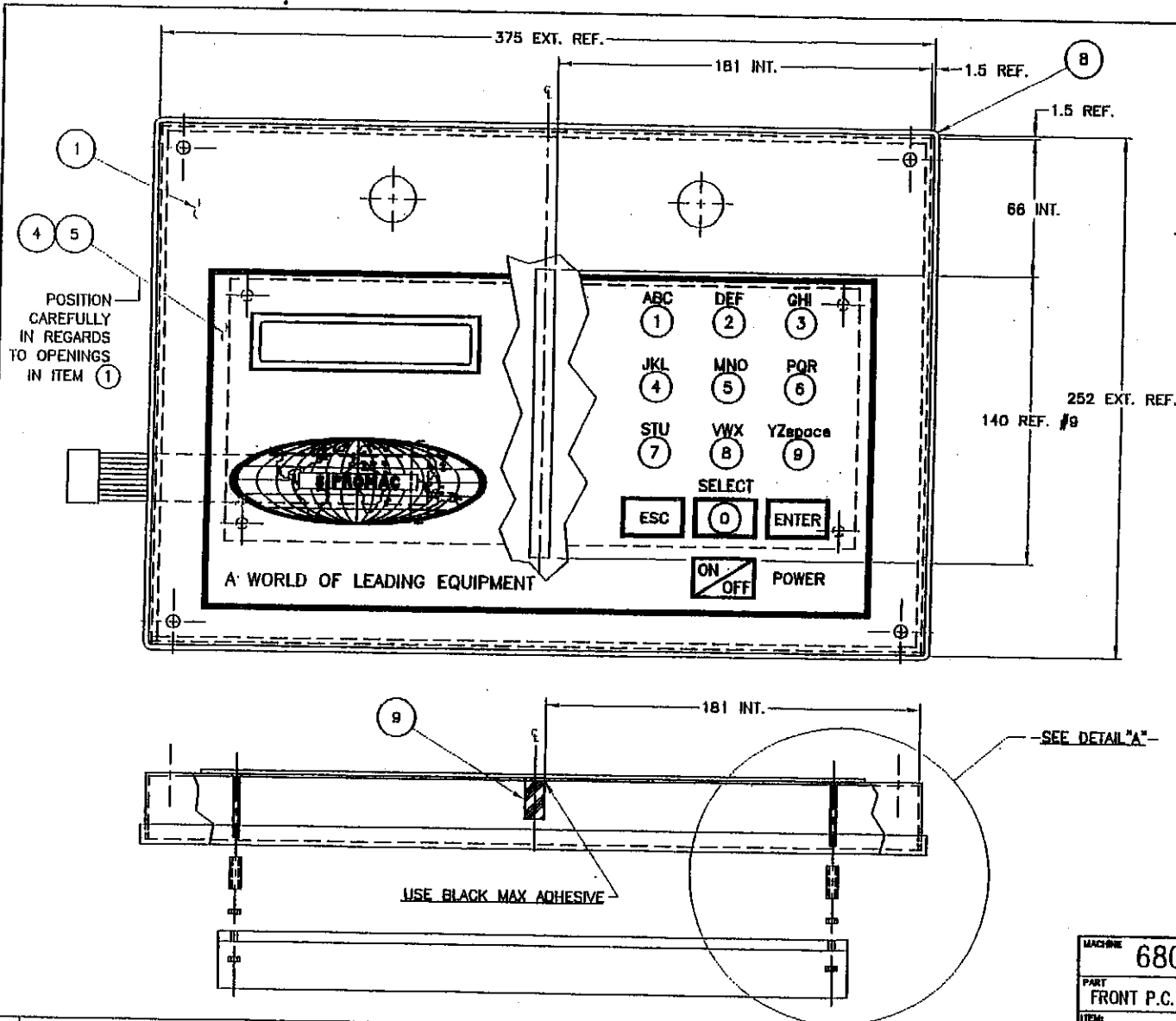


H	REDAWN/REMOVE 2 HOLES IN ITEM 2	01-06-19	L.T.
LET.	MODIFICATION	DATE	INT.

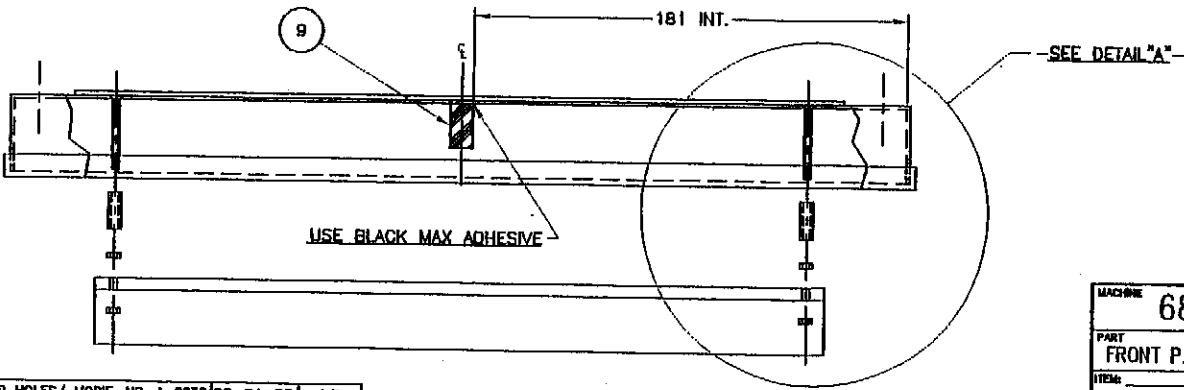
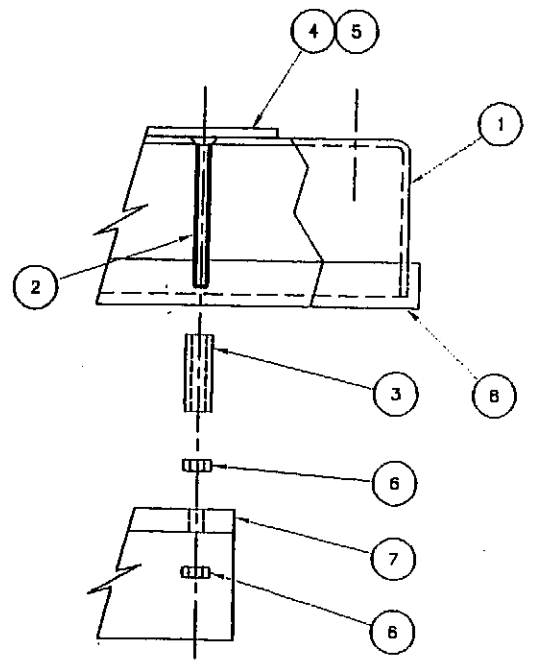
MACHINE	700A	TOLERANCE	FINISH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	REAR COVER ARM PRE-ASS'Y	UNRAZE TOLERANCE ± 0.5 ± 0.020"	ROCK ± 0.5 ± 0.040"	
ITEM		QRC		M-U
MAT		APP.	L.T.	01-06-19
			DATE	01-06-19
				004A0175

004A0175

30



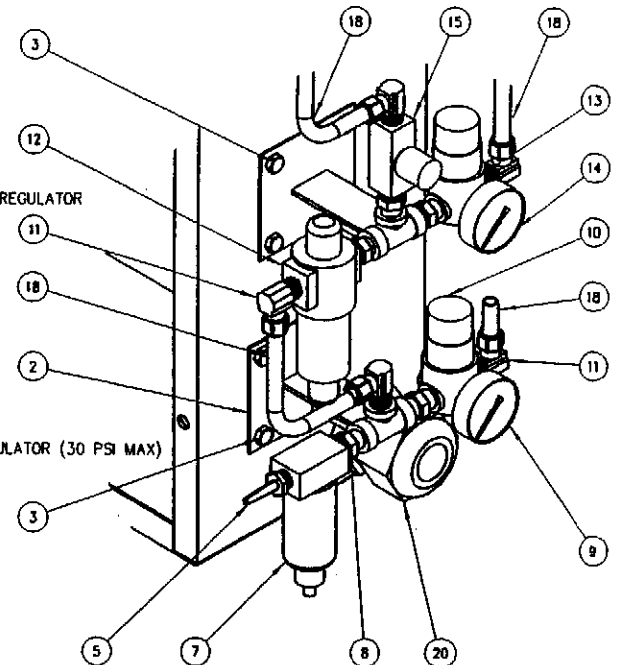
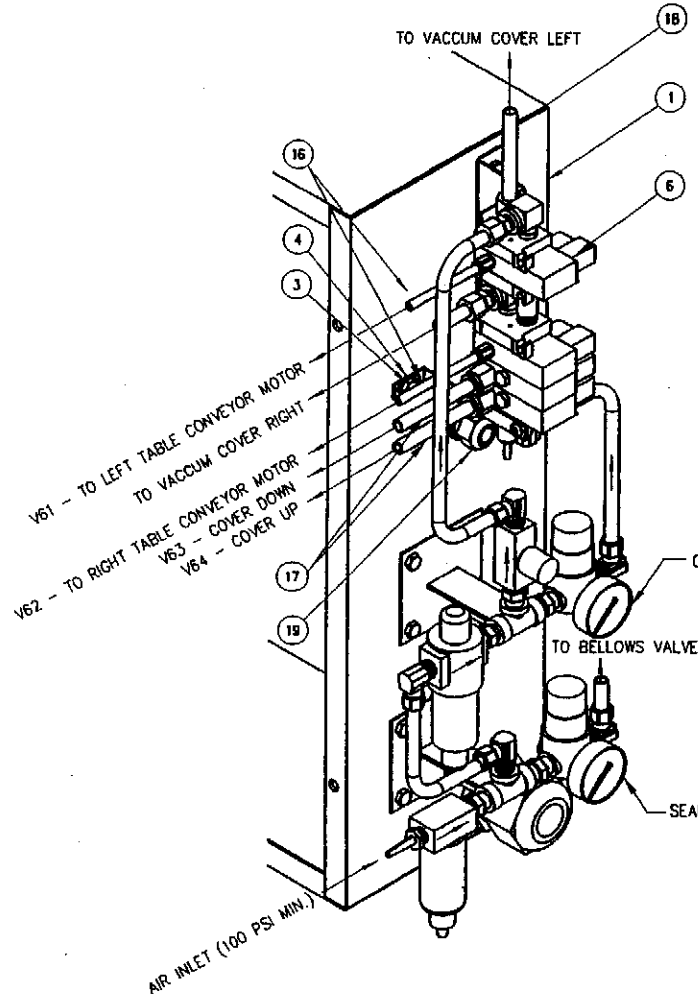
ITEM	PART #	DESCRIPTION	QT.
1	004A037B	FRONT P.C. BOARD SUPPORT PRE-ASS'Y	1
2	051-0092	SCREW 4-40 X 1 1/4" FLAT SLOT S/S	4
3	058-0120	CPVC SPACER 0.120" X 1/4" X 5/8"	4
4	033-0015	MC-40 KEYBOARD "SIPROMAC"	1
5	033-	MC-40 KEYBOARD "OPTION"	1
6	051-0540	NUT #4-40 S/S	8
7	033-3000	MC-40 DIGITAL P.C. BOARD	1
8	179-0014	RUBBER 1/4" X 3/8" X 1/16" "U SHAPED"	4.3
9	179-0008	SILICONE RUBBER 3/8" X 3/4" X 1/40	0.48



MACHINE 680A & 700A		METRIC TOLERANCE L + .1 S ± .05 H ± .005 F ± .005 R ± .005 X ± .005 Y ± .005 Z ± .005	DRAWING TOLERANCE S ± .015 H ± .005 F ± .005 R ± .005 X ± .005 Y ± .005 Z ± .005	SCALE 1
PART FRONT P.C. BOARD SUPPORT ASS'Y		N.T.S.		ST. 1
ITEM	DATE	BY	DATE	NO.
	98-04-02	A. PROVENCER	98-04-02	005A0392
LET.	MODIFICATION	DATE	INT.	

1005A0392

ITEM	PART#	DESCRIPTION	QT.
1	005-0401	E-BOX PRE-ASS'Y	1
2	005-0524	PNEUMATIC SUPPORT ASS'Y	2
3	051-0190	BOLT 1/4-20 x 3/4" HEX S/S	11
4	051-0740	FLAT WASHER 1/4" S/S	1
5	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE BARB BR.	1
6	004A0985	PRE-ASS'Y VALVE INSTALLATION	1
7	114-0430	AIR FILTER 1/4" NPT	1
8	101-0315	HEXAGONALE NIPPLE 1/4" NPT BR.	5
9	114-0245	PRESSURE GAUGE-60psi. 1/8" npt.	1
10	114-0147	PRESSURE REGULATOR 0-60 PSI 1/8" NPT	1
11	101-0058	ELBOW 90° 1/4" mnpt. X 3/8" T.P. COMP.	5
12	114-0200	LUBRICATOR 1/4" NPT	1
13	114-0150	PRESSURE REGULATOR 0-125PSI 1/4" NPT	1
14	114-0250	PRESSURE GAUGE 0-160psi. 1/4" npt.	1
15	107-0300	IN-LINE FLOW CONTROL 1/4" NPT	1
16	104-0004	POLYURETHANE TUBING 1/4" OD RED	
17	104-0077	POLYURETHANE 3/8" OD SMC BLUE	
18	104-0060	POLYETHENE TUBING 3/8" OD LPDE	
19	036-0409	PRESSE-ÉTOUPE CD13NABKS + "O" RING	1
20	036-0440	PRESSE-ÉTOUPE CD36AA-BK + "O" RING	1



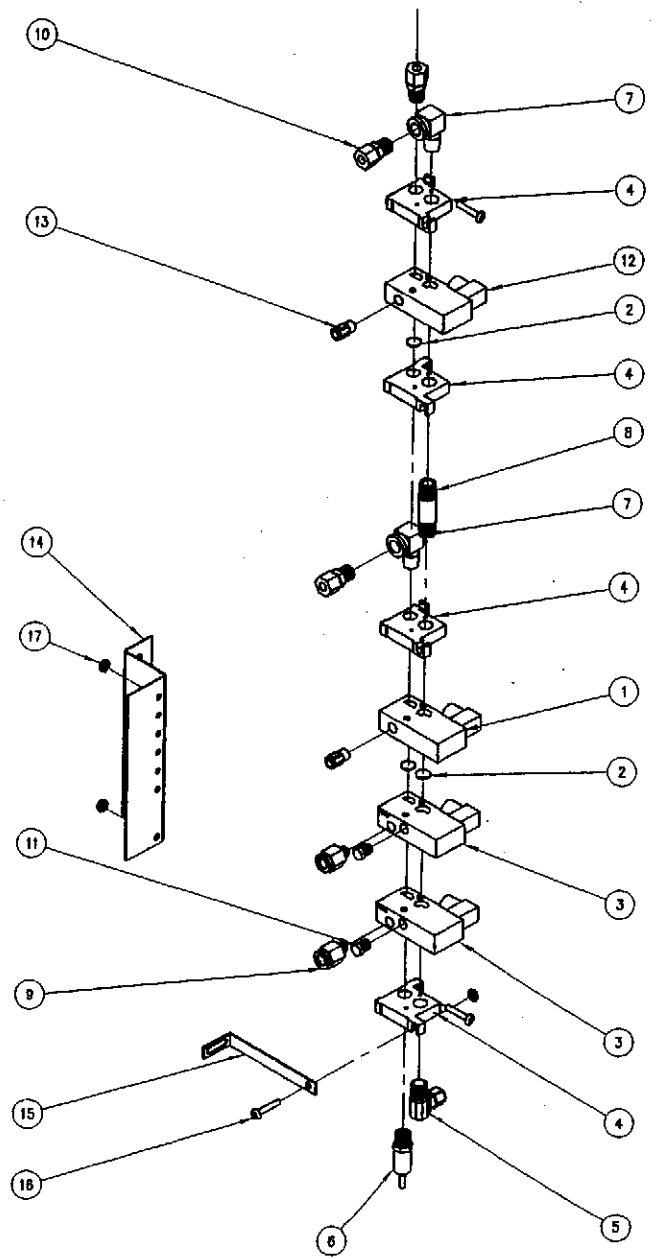
31

A	REDESSNER MDT	01-12-03	Y.C
LET.	MODIFICATION	DATE	INT.

MACHINE	700A			TOLERANCE	FRACTION	DECIMAL	PERCENT	SIPROMAC	
PART	E-BOX VALVE INSTALLATION			FRACTION	± 0.1	± 0.001	± 0.001	ST-DERMAIN DE GRANTHAM	
ITEM:	CNC:			RESIDUAL	± 0.5	± 0.001	± 0.001	QUEBEC CANADA	
MAT:	APP.	YAN C.	DATE	01-12-03		NO.	007-0039		
		LT	DATE						

1004A0985

ITEM	PART#	DESCRIPTION	QT.
1	114-0800	VALVE 3 WAYS 24VAC 1/8"NPT	2
2	114-0870	2 PORT ISOLATOR KIT	2
3	114-0820	VALVE 4 WAYS 24VAC 1/8"NPT W/FLOW CONT.	2
4	114-0860	2 ENDS PLATES KIT 1/4"npt.	2
5	101-0058	ELBOW 90° 1/4"mnpt. X 3/8" T.P. COMP.	1
6	114-1055	MUFLER 1/4"npt. ADJ.	1
7	101-0660	ELBOW STREET 90° 1/4" NPT BR.	2
8	101-0325	NIPPLE 1/4"npt. X 2" BR.	1
9	102-0380	MALE CONN. 1/8"MNPT X 3/8" T.QUICK	2
10	101-0036	STRAIGHT 1/4"MNPT. X 3/8" T.P. COMP.	3
11	101-1020	HEX. PLUG 1/8"NPT BR.	2
12	114-0850	MINI DIM PLUG HS 2	4
13	102-0370	MALE CONN. 1/8"MNPT X 1/4 T QUICK	2
14	001-1840	VALVE MTG. BRACKET	1
15	001-1839	AIR VALVE SUPPORT	1
16	051-0146	SCREW 10-24 x 1" PAN PHIL S/S	3
17	051-0571	NUT #10-24 S/S	3



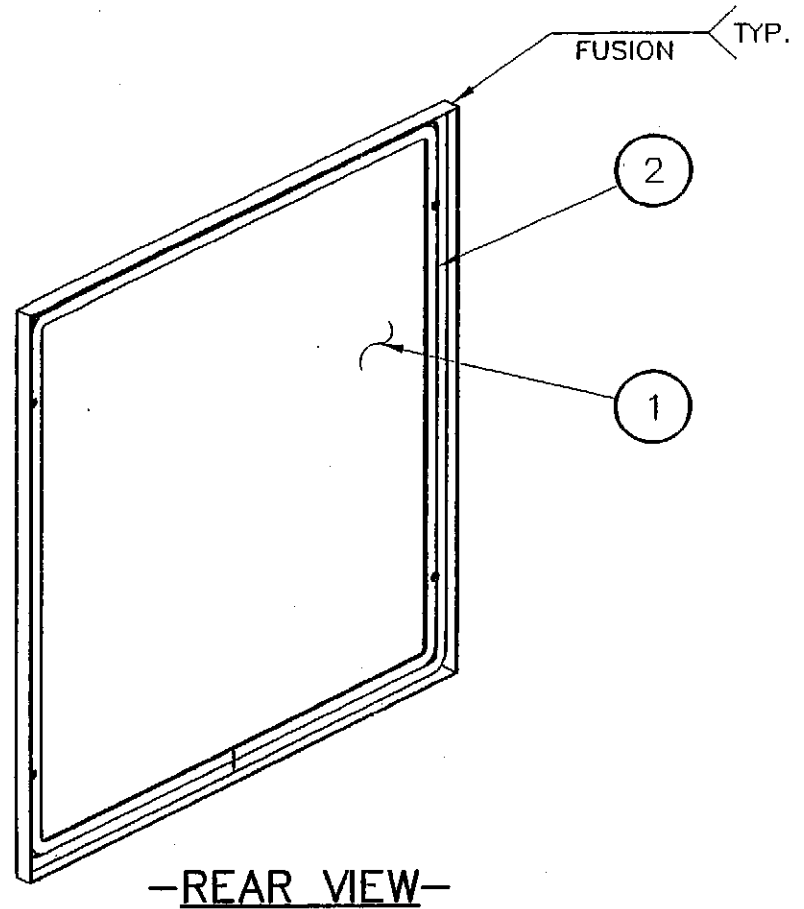
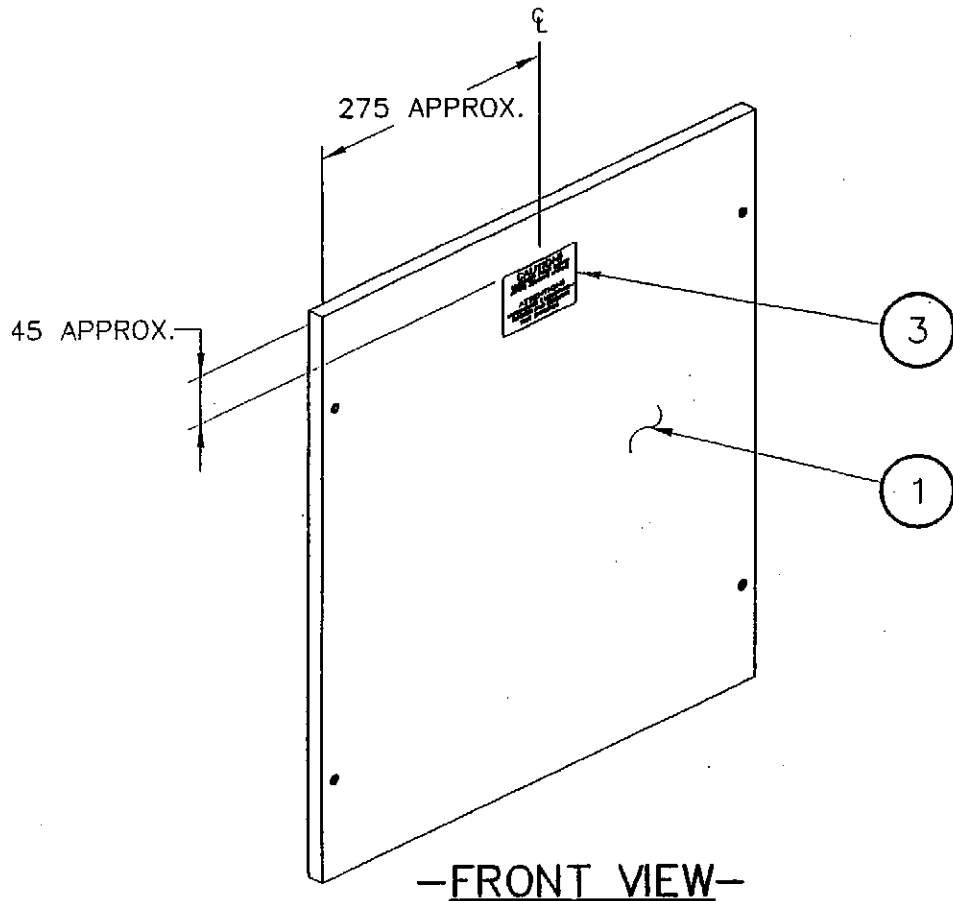
32

LET.	MODIFICATION	DATE	INT.

MACHINE <b>700A</b>		TOLERANCE FINISH		<b>SIPROMAC</b>	
PART <b>PRE ASS'Y VALVE INSTALLATION</b>		FINISH ± 0.1 ± 0.05 ± 0.02	FINISH ± 0.05 ± 0.02 ± 0.02	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM: _____		CNC: _____		M    QT. 1	
MAT: _____		APP. <b>YAN C.</b>	DATE <b>01-11-29</b>	NO. <b>004A0985</b>	

004-0250

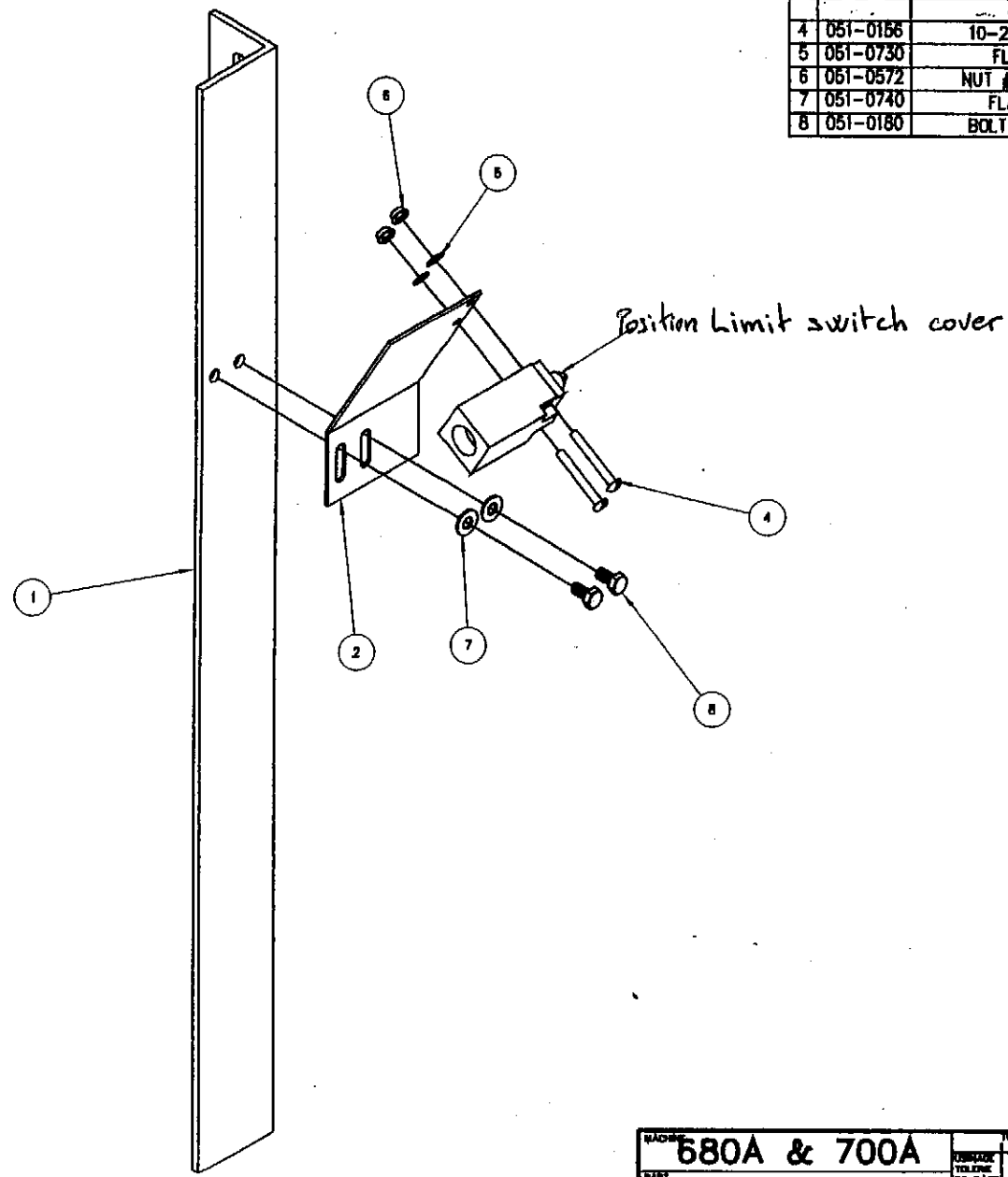
ITEM	PART #	DESCRIPTION	QT.
1	001-1545	ELECTRICAL BOX COVER	1
2	179-0004	NEOPRENE SPONGE 1/8" X 1/2" ADHESIVE	15.2
3	127-0100	"CAUTION" YELLOW STICKER	1



MACHINE <b>680A &amp; 700A</b>		METRIC TOLERANCE 0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1'	INCH TOLERANCE .0 ± .015" .00 ± .005" .000 ± .0005" N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART <b>E-BOX COVER PRE-ASS'Y</b>		ITEM: _____	CNC: _____	SCALE _____ QT. <b>1</b>
LET.	MODIFICATION	DATE	INT.	DWG BY <b>A. PROVENCHER</b> DATE <b>98-03-23</b> NO. <b>004-0250</b>
		MAT: _____	APP. <b>LT</b>	DATE _____

004-0947

ITEM	PART#	DESCRIPTION	QTY.
1	004-0948	CYLINDER SUPP. REINF. PRE-ASS'Y	1
2	001-2612	SWITCH SUPPORT	1
			1
4	051-0166	10-24x1-1/2" PAN SLOT S/S	2
5	051-0730	FLAT WASHER #10 S/S	2
6	051-0572	NUT #10-24 NYLON LOCK S/S	2
7	051-0740	FLAT WASHER 1/4" S/S	2
8	051-0180	BOLT 1/4-20 x 1/2" HEX.SS	2

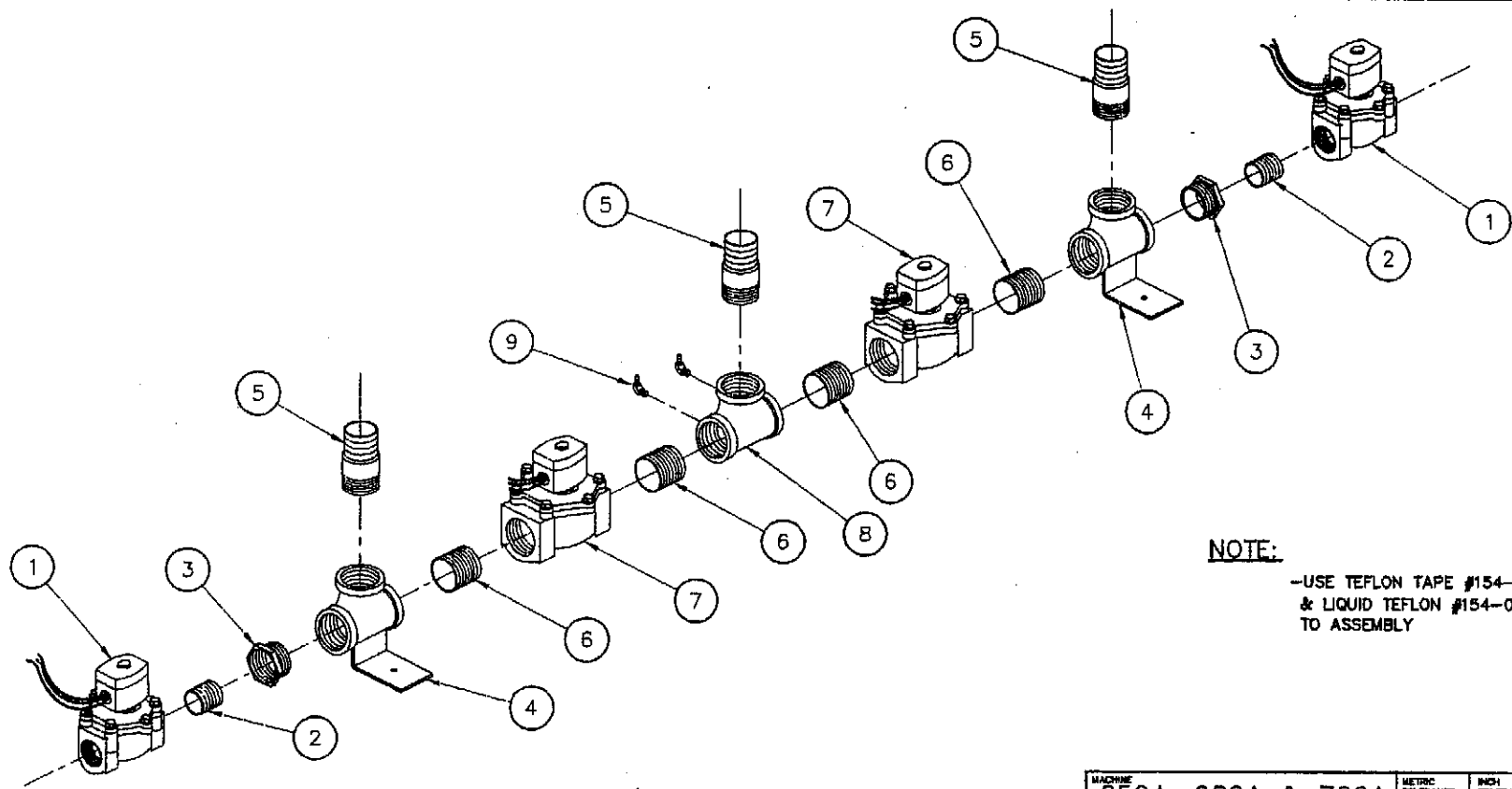


34

<b>680A &amp; 700A</b>		TOLERANCE FRAISE ± .01 ± 0.005 TOLINE ± .01 ± 0.005 SONDAGE ± .01 ± 0.005	<b>SIPROMAC</b> ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART <b>CYLINDER SUPP. REINF. ASS'Y</b>		N.T.S.	M 102/1 CH.
DATE 01-08-27	L.T.	DATE	NO. <b>004-0947</b>

LET.	MODIFICATION	DATE	INT.

ITEM	PART #	DESCRIPTION	QT.
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-ASS'Y	2
5	103-0780	STRAIGHT 2" NPT x 2" HOSE ZINC	3
6	103-0280	CLOSE NIPPLE 2" NPT ZINC	4
7	106-0080	VALVE 2WAY / 24V / 60Hz / 2" NPT	2
8	003-0079	BELLOWS CONNECTOR TEE	1
9	101-0191	ELBOW 1/8" MNPT x 1/4" HOSE	2



**NOTE:**

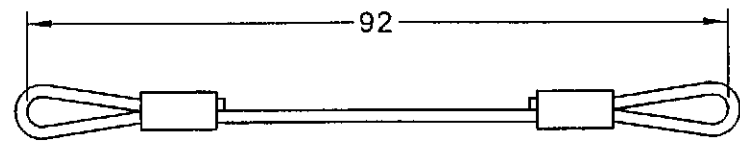
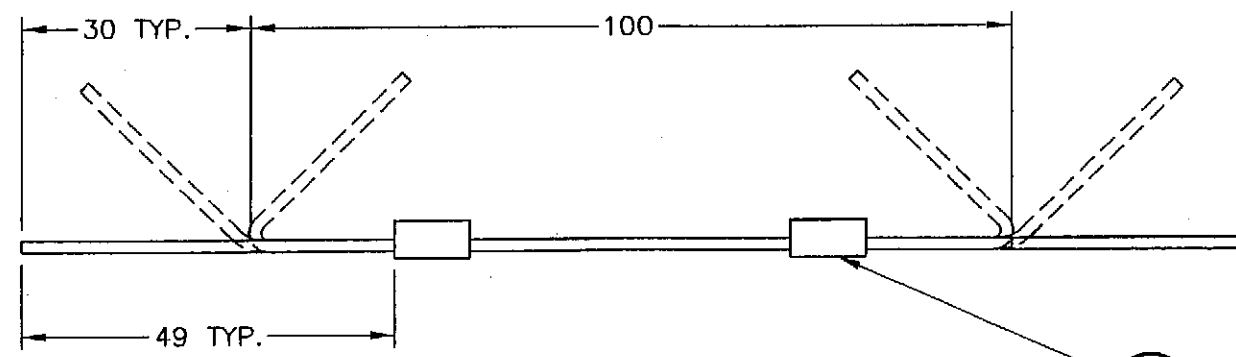
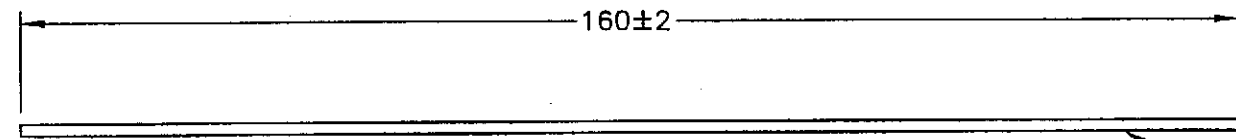
--USE TEFLON TAPE #154-0060  
& LIQUID TEFLON #154-0030  
TO ASSEMBLY

C	INVERSED SIDE ITEM #4	00-03-22	S.L.
B	ADDED 650A	00-03-22	S.L.
A	REDRAWN / ITEM #9 101-0191 WAS 101-0190	00-01-08	S.L.
LET.	MODIFICATION	DATE	INT.

MACHINE	650A, 680A & 700A	METRIC TOLERANCE 0.5 ± .05 0.0 ± .005 .000 ± .0005 ANGLE ± 1°	INCH TOLERANCE .03 ± .015 .000 ± .0005 N.T.S.	SIPROMAC ST-GERMAN DE GRANTHAM QUEBEC CANADA
PART	VACUUM / ATMOSPHERE VALVE ASS'Y	SCALE _____ DT. 1		
ITEM:	CNC:	DATE 00-01-08	NO. 004-0505	
MAT:	APP. S. LAROUCHE	DATE		

004-0448

ITEM	PART #	DESCRIPTION	QT.
1	056-0190	S/S BARE WIRE ROPE 1/16"φ	0.55
2	056-0192	S/S OVAL SLEEVES	2



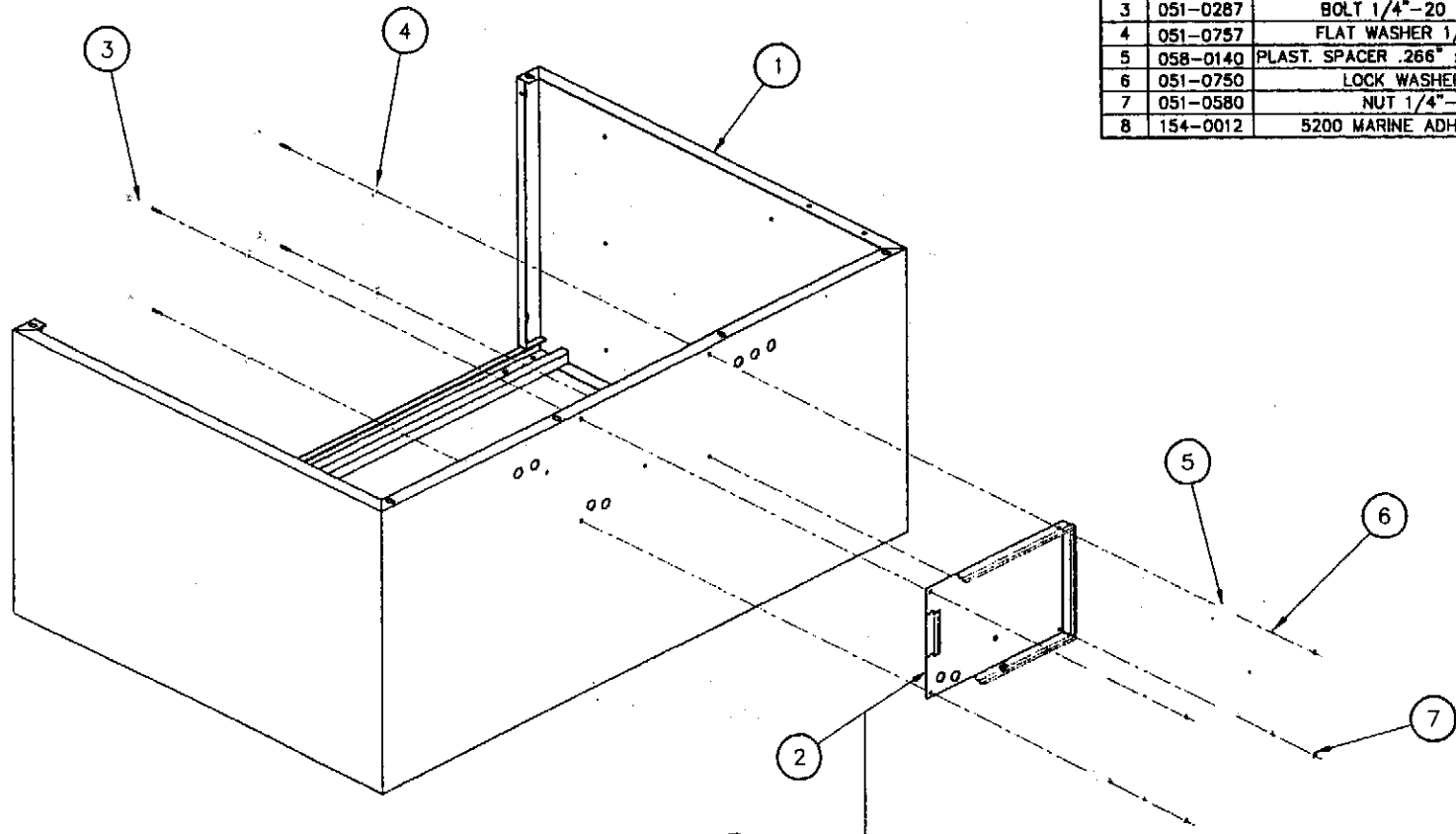
**NOTE:**

- INSERT SLEEVES BEFORE BENDING WIRE
- SLEEVES TO BE WELL CRIMPED

MACHINE	700A	METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	DISCHARGE PLATE LANYARD	0. ± .5 .0 ± .05 .00 ± .005 ANGLE ± 1'	.0 ± .015" .00 ± .005" N.T.S.	
ITEM:	CNC:	SCALE		QT. 2
MAT:	DWG. BY L.MARCOTTE	DATE 98-06-15	NO. 004-0448	
LET.	MODIFICATION	DATE	INT.	



37



USE (8) TO SEAL AGAINST STRUCTURE ONCE INSTALLED

ITEM	PART #	DESCRIPTION	QT.
1	004-0178	STRUCTURE PRE-ASS'Y	1
2	005-0582	REAR MC-40 SUPPORT ASSY.	1
3	051-0287	BOLT 1/4"-20 x 3 1/4"	4
4	051-0757	FLAT WASHER 1/4" THICK	4
5	058-0140	PLAST. SPACER .266" x 1/2" x 2 1/4"	4
6	051-0750	LOCK WASHER 1/4"	4
7	051-0580	NUT 1/4"-20	4
8	154-0012	5200 MARINE ADHESIVE SEAL	.06

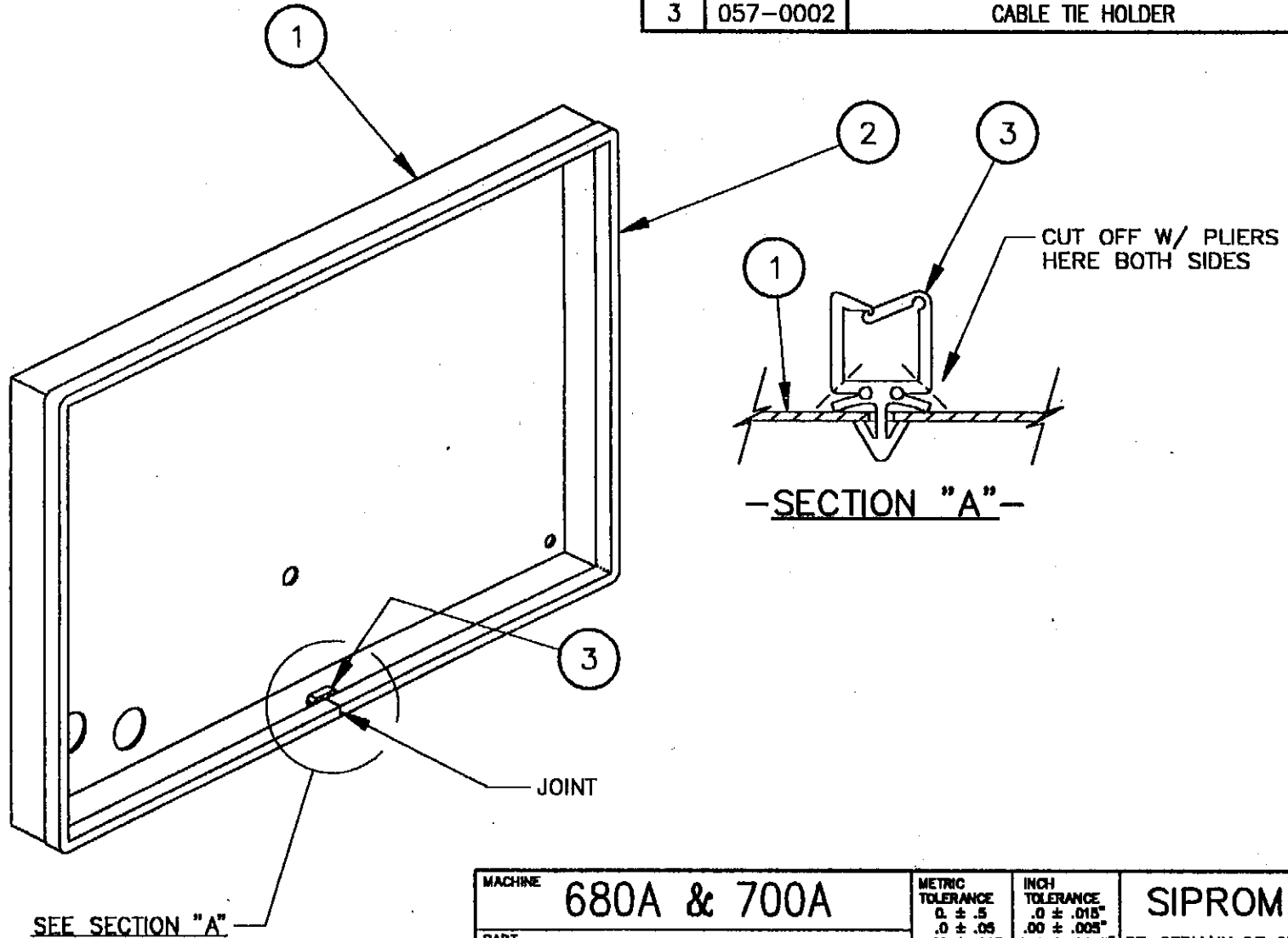
1005-0472

LET.	MODIFICATION	DATE	INT.

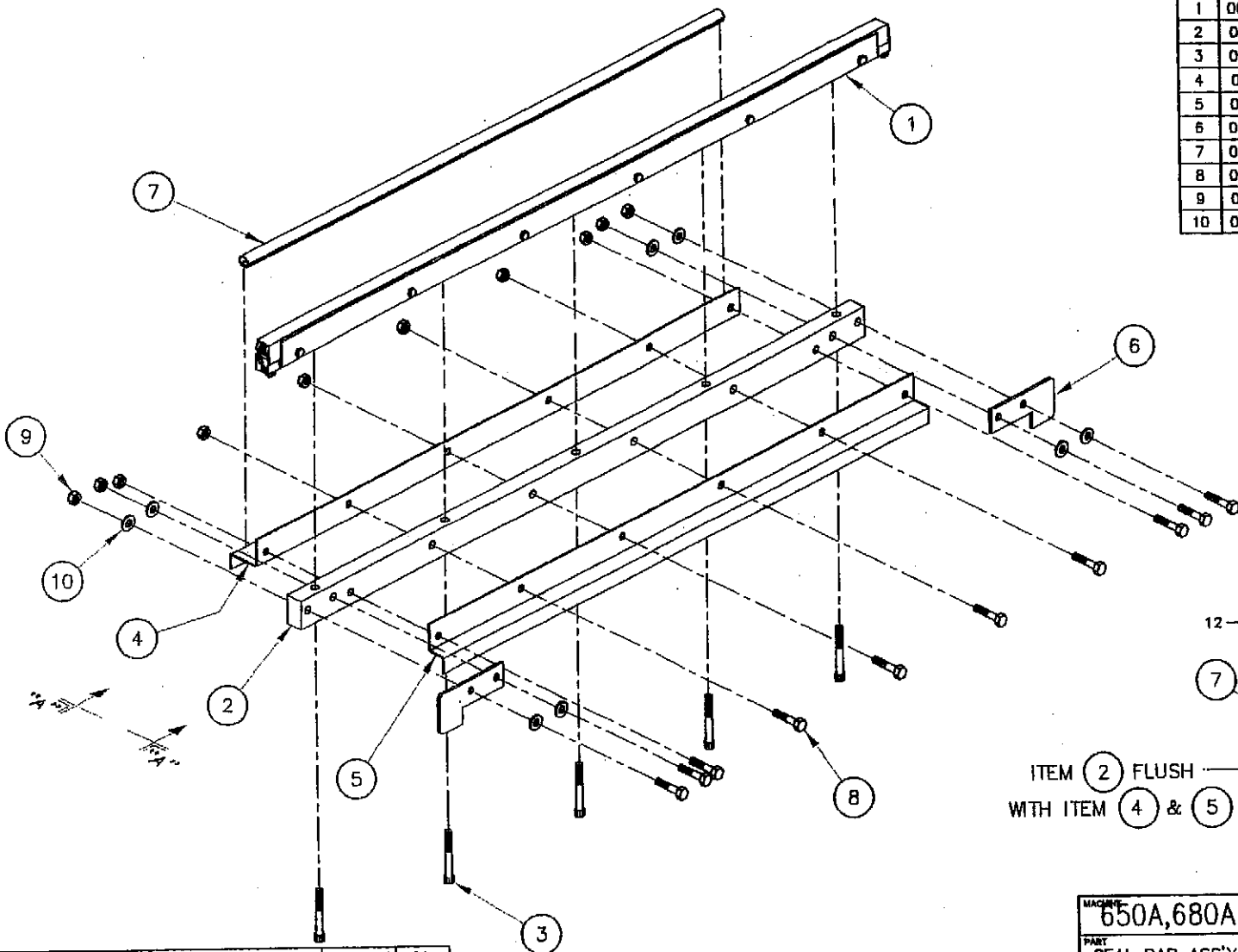
MACHINE	700A		METRIC TOLERANCE 0 & .5 .0 & .05 .00 & .005 .000 & .0000	INCH TOLERANCE 0 & .015" .00 & .0005" .000 & .00005"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	STRUCTURE ASS'Y		N. T. S.		
ITEM	QNC	SCALE	QTY	1	
MAT	APP. S	DATE 98-11-13	NO	005-0472	

005-0582

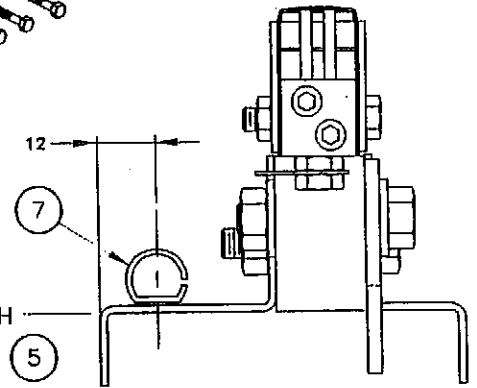
ITEM	PART #	DESCRIPTION	QT.
1	004A0177	REAR P.C. BOARD SUPPORT PRE-ASS'Y	1
2	179-0014	RUBBER 1/4" X 3/8" X 1/16" ("U" SHAPED)	1
3	057-0002	CABLE TIE HOLDER	1



MACHINE	680A & 700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	REAR P.C. BOARD SUPPORT ASS'Y		0 ± .5 .0 ± .05 .00 ± .005 ANGLE ± 1'	.0 ± .015" .00 ± .005" .000 ± .0005" N.T.S.	
ITEM:	CNC:	SCALE	QT. 1		
MAT:	DWG BY A. PROVENCHER	DATE 98-04-02	NO. 005-0582		
LET.	MODIFICATION	DATE	INT.		



ITEM	PART #	DESCRIPTION	QT.
1	004-0254	SEAL BAR PRE-ASS'Y (TWIN SEAL)	1
2	002A0357	SEAL BAR SUPPORT	1
3	051-0251	CAP HEX. SKT BOLT 1/4"-20 NC. X 1 1/2" S/S	5
4	001A1901	EXTERIOR BELLOWS COVER	1
5	001A1900	INTERIOR BELLOWS COVER	1
6	001-0268	SEAL BAR GUIDE	2
7	038-0230	WRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 800)	1
8	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	10
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	10
10	051-0740	FLAT WASHER 1/4" S/S	8



ITEM 2 FLUSH WITH ITEM 4 & 5

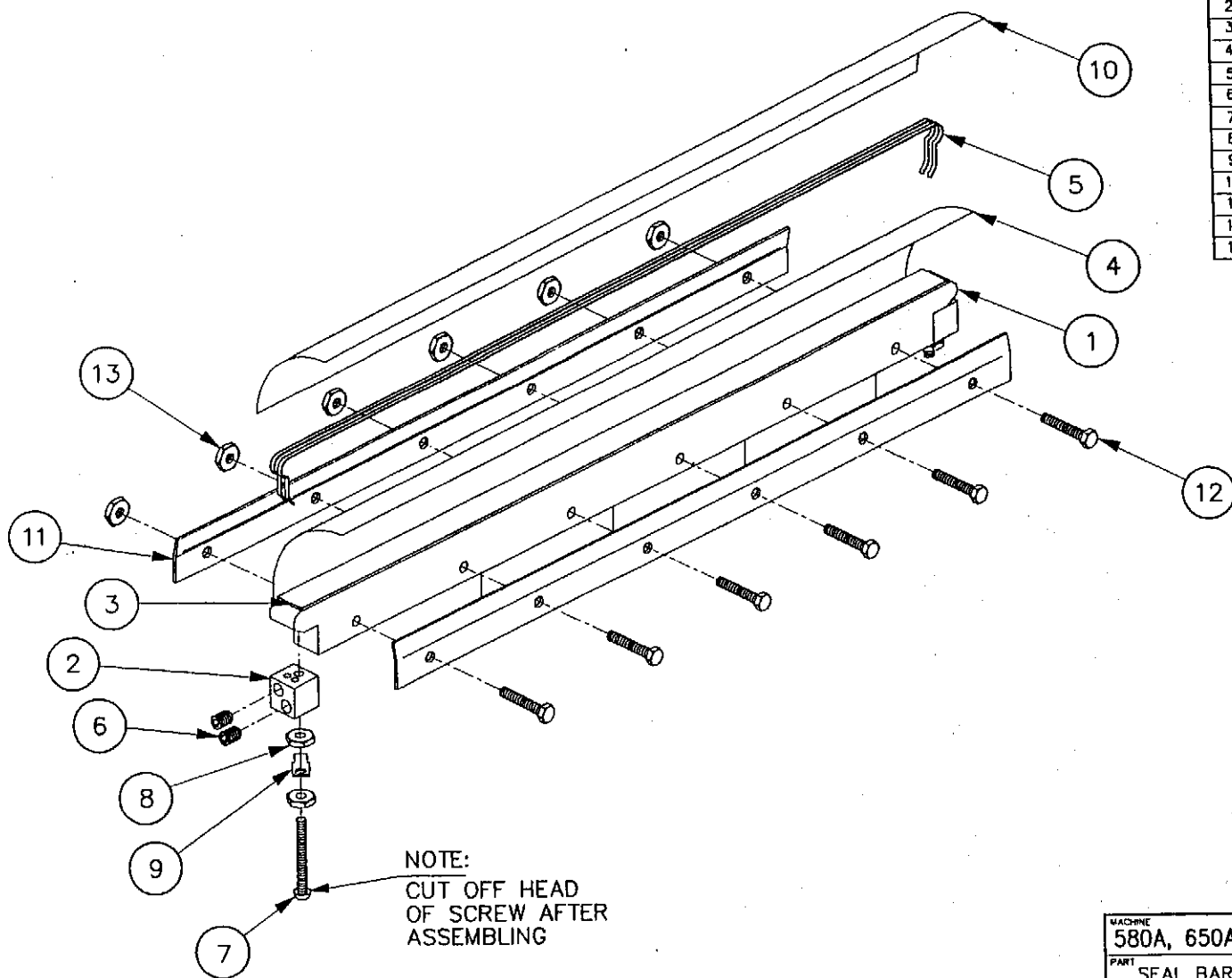
-VIEW "A-A"-

LET.	MODIFICATION	DATE	INT.
D	ADDED 650A WAS 005A0357	00-02-01	S.L.
C	40 BOLTS #051-0230 WAS 24 REMOVE BOLTS #051-0250/MODIF. #A-0263	88-05-14	L.M.
B	REDRAWN/ MODIF. ND. A-0245	88-03-08	A.P.

MACHINE <b>650A, 680A &amp; 700A</b>		METRIC TOLERANCE D ± .05 F ± .06 H ± .008 K ± .008 M ± .008 N ± .008 P ± .008 R ± .008 S ± .008 T ± .008 V ± .008 W ± .008 X ± .008 Y ± .008 Z ± .008	SI-METRIC TOLERANCE D ± .015 F ± .020 H ± .0025 K ± .0025 M ± .0025 N ± .0025 P ± .0025 R ± .0025 S ± .0025 T ± .0025 V ± .0025 W ± .0025 X ± .0025 Y ± .0025 Z ± .0025	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART <b>SEAL BAR ASS'Y W/ SUPPORT</b>		N.T.S.		SCALE _____ QT. <b>4</b>
ITEM _____	CRG: _____	DATE <b>88-03-08</b>	NO. <b>005A0547</b>	
MAT: _____	BY: <b>LT</b>	DATE _____		

005A0547

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 (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



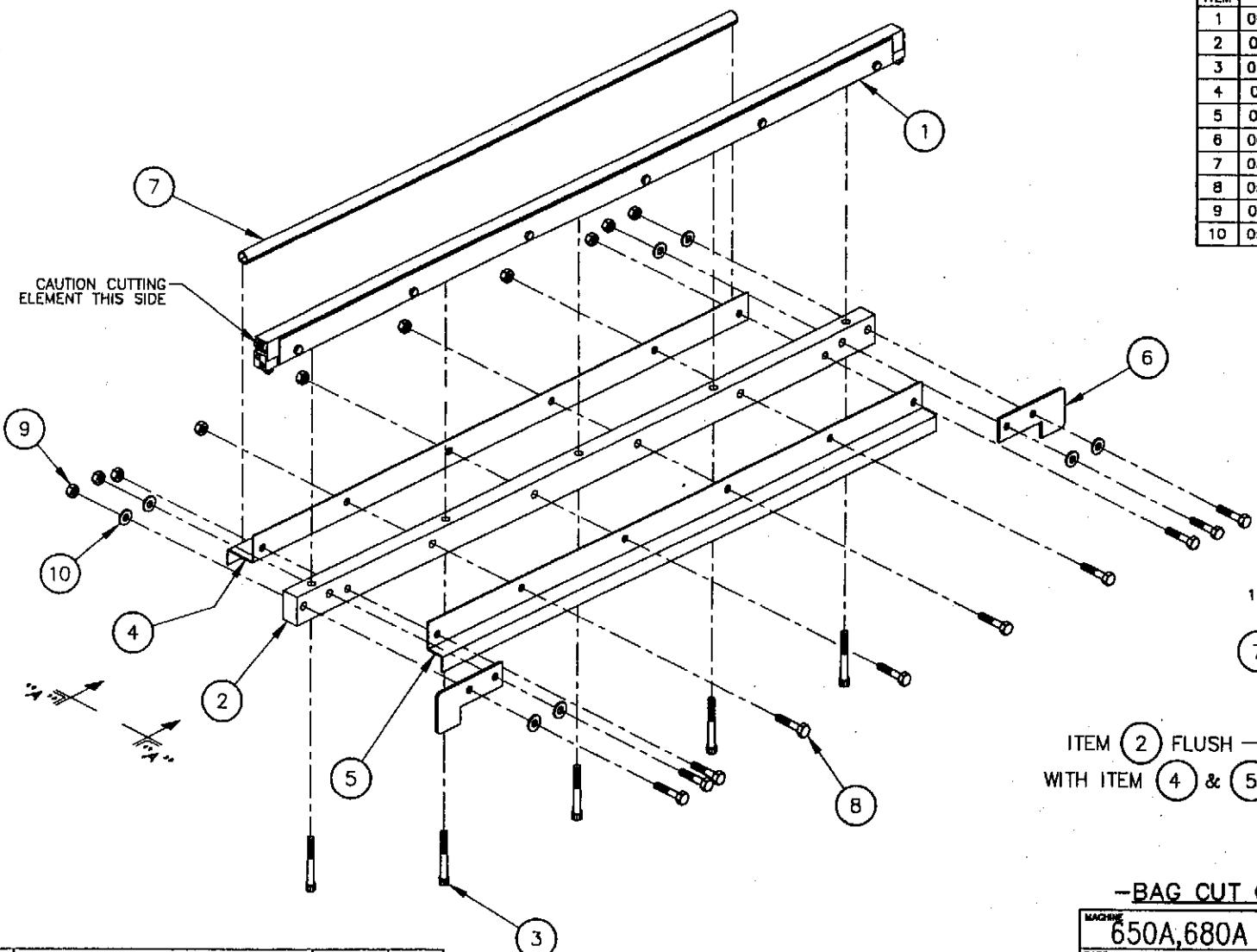
NOTE:  
CUT OFF HEAD  
OF SCREW AFTER  
ASSEMBLING

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

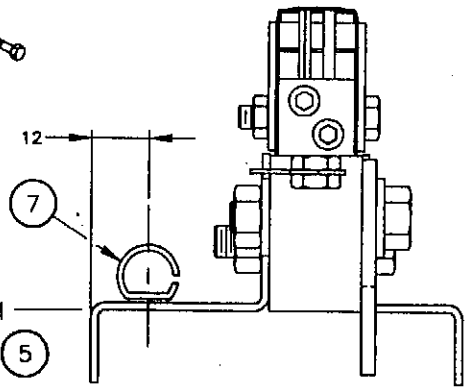
MACHINE 580A, 650A, 680A & 700A		METRIC TOLERANCE 0. ± .5 .0 ± .05 .00 ± .003 .000 ± .0005 ANGLE ± 1°	INCH TOLERANCE 0. ± .015" .00 ± .005" .000 ± .0005"	N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART SEAL BAR PRE-ASSEMBLY					SCALE: M	QTY: SEE LIST
ITEM:	CNC:	DATE: 95-12-29	NO: 004-0254			
WAT:	BY: M. LAVIGNE	DATE:	REF:			

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.
LET.	MODIFICATION	DATE	INT.

1004-0254



ITEM	PART #	DESCRIPTION	QT.
1	004-0255	SEAL BAR PRE-ASS'Y (BAG CUT OPTION)	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	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



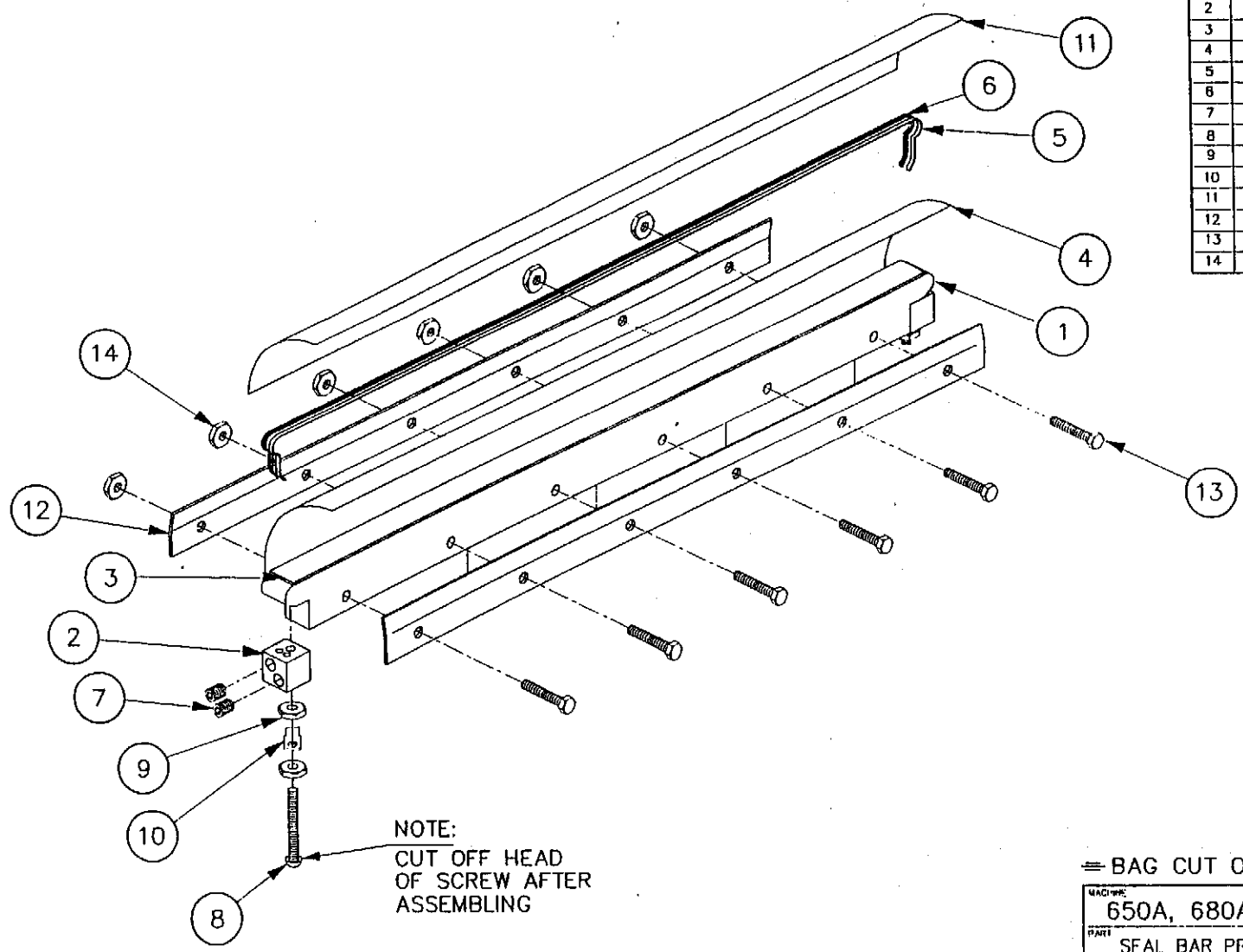
-VIEW "A-A"-

-BAG CUT OPTION-

LET.	MODIFICATION	DATE	INT.
D	ADDED 850A WAS 005A0358	00-02-01	S.L.
C	40 BOLTS #051-0230 WAS 24 REMOVE BOLTS #051-0250/MODIF. #A-0263	98-05-14	L.M.
B	REDRAWN/ MODIF. NO. A-0245	98-03-11	A.P.

MACHINE <b>650A, 680A &amp; 700A</b>		METRIC TOLERANCE 0 ± .5 .5 ± .05 .000 ± .0005 ANGLE ± 1°	INCH TOLERANCE 0 ± .015 .01 ± .0025 0.000 ± .0005 N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART <b>SEAL BAR ASS'Y W/ SUPPORT</b>		SCALE	QT.	4	
ITEM:	CNC:	DATE	98-03-11	NO. <b>005A0548</b>	
MAT:	BY A. PROVENCER	DATE			

42



NOTE:  
CUT OFF HEAD  
OF SCREW AFTER  
ASSEMBLING

ITEM	PAR. #	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 (5S) 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

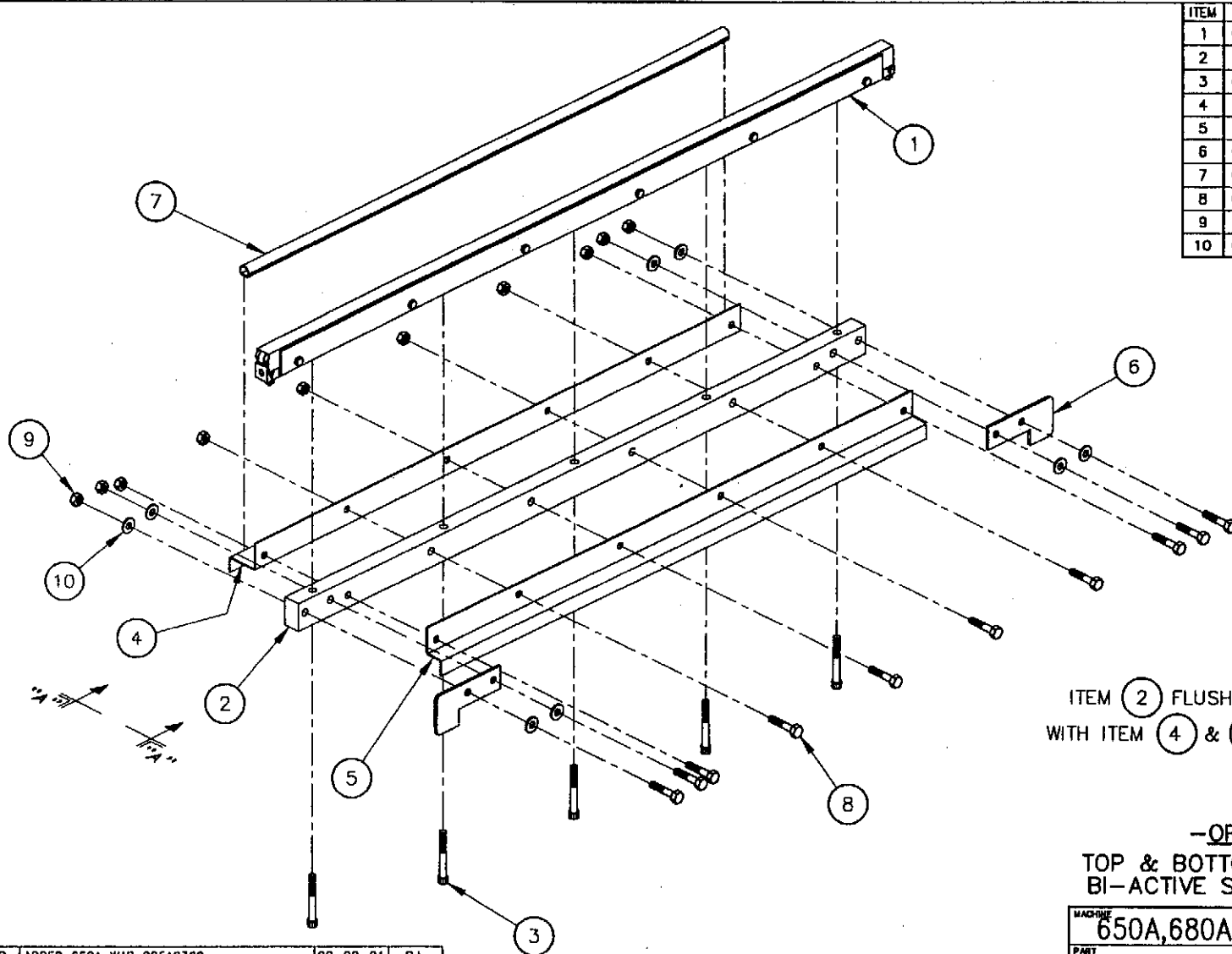
== BAG CUT OPTION ==

MACI/MP: <b>650A, 680A &amp; 700A</b>	METRIC TOLERANCE 0.1 0.5 0.1 0.5 0.01 0.005 0.001 0.0005 ANGLE ± 1°	INCH TOLERANCE 0 ± 0.015 0.01 ± 0.005 0.001 ± 0.0005 N.T.S.	<b>SIPROMAC</b> ST-CERMAIN DE GRANTHAM QUEBEC CANADA
PART <b>SEAL BAR PRE-ASSEMBLY</b>		N.T.S.	
ITEM: _____ DATE: _____	ENG: _____ A. PROVENCIER	DATE: 96-12-31	QTY: 4 <b>004-0255</b>

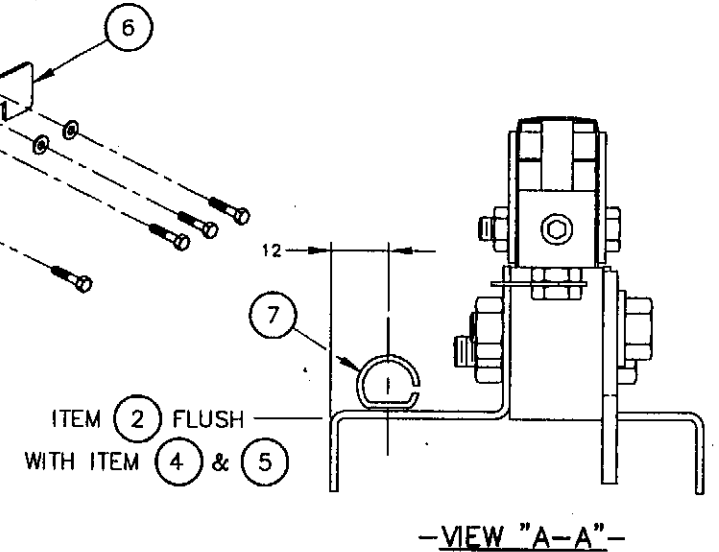
A	REDRAWN	96-12-31	A.P.
LET.	MODIFICATION	DATE	INT.

CUT: 0200

43



ITEM	PART #	DESCRIPTION	QT.
1	004-0256	SEAL BAR PRE-ASS'Y (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 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

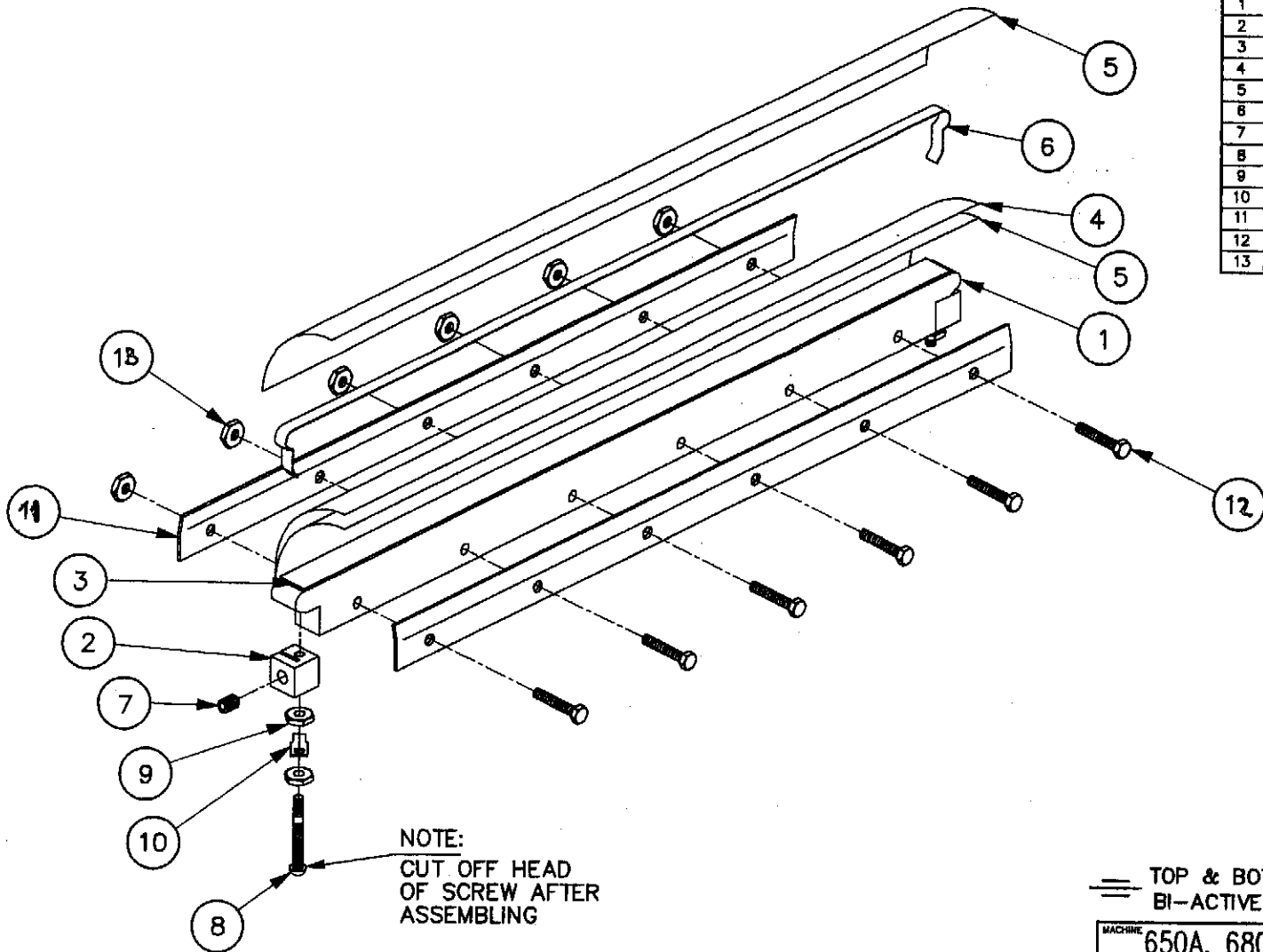


-OPTION-  
TOP & BOTTOM SEALING OR  
BI-ACTIVE SEALING OPTION

D	ADDED 650A WAS 005A0389	00-02-01	S.L.
C	40 BOLTS #051-0230 WAS 24 REMOVE BOLTS #051-0250/MODIF. #A-0263	98-05-14	L.M.
B	REDRAWN / MODIF. NO. A-0245	98-03-11	A.P.
LET.	MODIFICATION	DATE	INT.

MACHINE	650A, 680A & 700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	SEAL BAR ASS'Y W/ SUPPORT		0.5 ± .05 .00 ± .0008 ANGLE ± 1°	.015 ± .015 .002 ± .002 N.T.S.	
ITEM:	CNC:	SCALE	QT.	4	
WAR:	APP. BY A. PROVENCER	DATE	98-03-11	005A0549	

005A0549



NOTE:  
CUT OFF HEAD  
OF SCREW AFTER  
ASSEMBLING

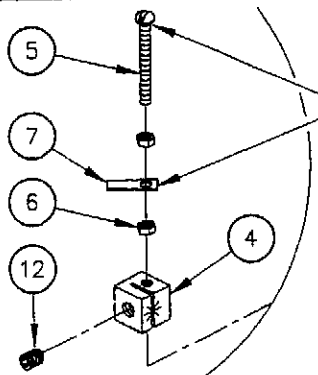
ITEM	PART #	DESCRIPTION	QT.
1	002-0332	SEAL BAR (TABLE)	1
2	009-0029	CONNECTOR	2
3	179-0003	SILICONE 2mm x 15mm ADHESIVE (852mm EA.)	0.890
4	176-0220	TEFLON TAPE (10S) ADHESIVE (882mm EA.)	0.109
5	176-0200	TEFLON TAPE (5S) ADHESIVE (2 x 882mm)	0.218
8	039-0220	BI-ACTIVE SEALING ELEM. (992mm EA.)	0.104
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	001-0286	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	METRIC TOLERANCE D ± .5 D ± .06 D ± .008 D ± .0005 ANGLE ± 1°	INCH TOLERANCE D ± .015 D ± .005 D ± .0005 D ± .0005 N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	SEAL BAR ASSEMBLY			
ITEM:		CNC:	DATE	NO.
MAT:		BY M. LAVIGNE	95-12-29	4
				004-0256

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

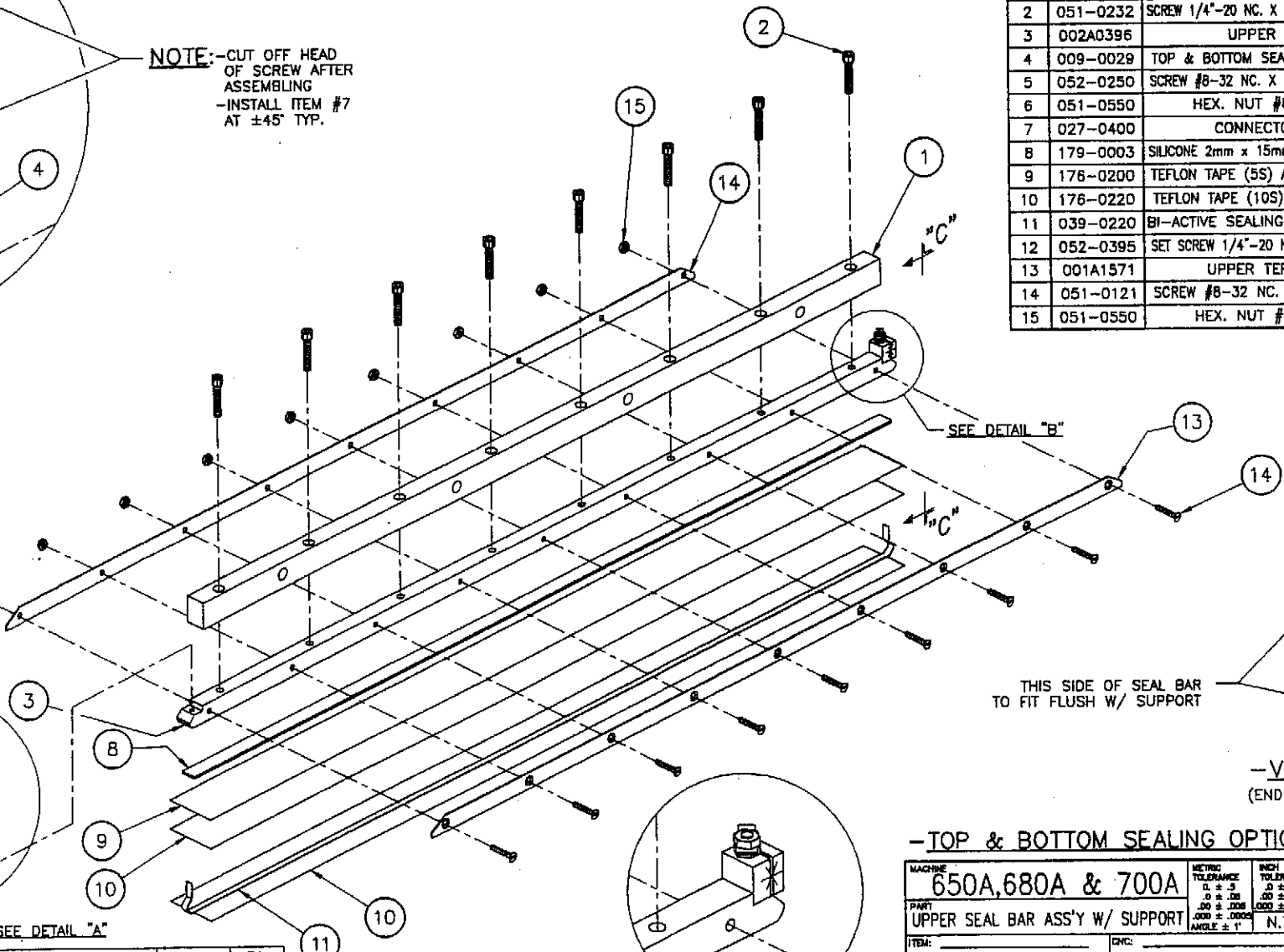




**NOTE:** - CUT OFF HEAD OF SCREW AFTER ASSEMBLING  
 - INSTALL ITEM #7 AT  $\pm 45^\circ$  TYP.

-DETAIL "A"-

ITEM	PART #	DESCRIPTION	QT.
1	002A037B	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 PHLL. S/S	9
15	051-0550	HEX. NUT #8-32 NC. S/S	9



SEE DETAIL "B"

THIS SIDE OF SEAL BAR TO FIT FLUSH W/ SUPPORT

-VIEW "C-C"-  
 (END VIEW ASSEMBLY)

-TOP & BOTTOM SEALING OPTION-

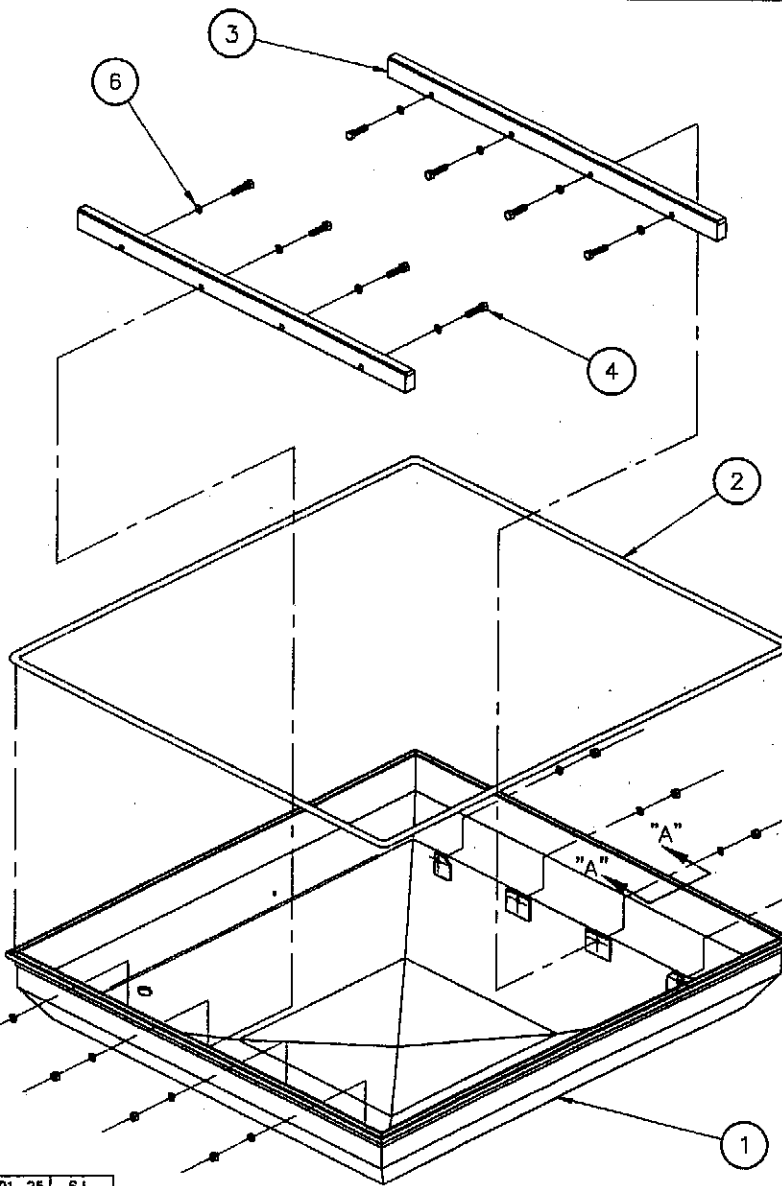
E	ADDED 650A WAS 005A0404	00-02-01	S.L.
D	REDRAWN/ WAS ALSO 004-025B	98-04-20	A.P.
LET.	MODIFICATION	DATE	INT.

MACHINE	650A, 680A & 700A	METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC
PART	UPPER SEAL BAR ASSY W/ SUPPORT	DL $\pm .5$	D $\pm .015$	ST-GERMAIN DE GRANTHAM
		.00 $\pm .008$	.000 $\pm .0005$	QUEBEC CANADA
		.000 $\pm .0005$	N.T.S.	
ITEM:		ENC:		SCALE: M
MAT:		DATE	98-04-20	QT. 2
		DATE		NO. 005A0437

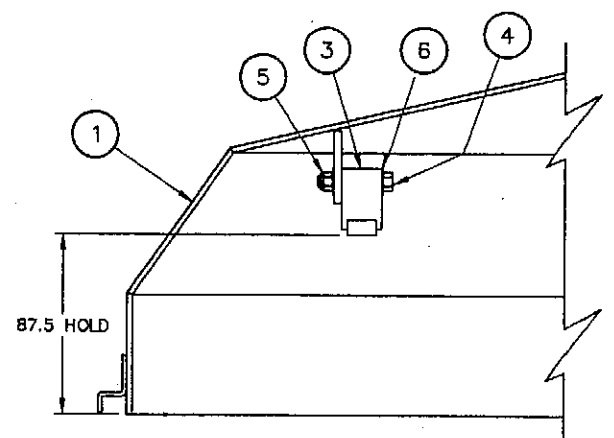
-DETAIL "B"-

45

005A0437



ITEM	PART #	DESCRIPTION	QT.
1	004-0245	8" COVER EXTERIOR PRE-ASSEMBLY	1
2	179-0020	NEOPRENE SPONGE 1/2"	14.0
3	004B0207	UPPER SEAL BAR ASSEMBLY	2
4	051-0250	BOLT 1/4"-20 x 1 1/2" S/S	8
5	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
6	051-0740	WASHER 1/4" FLAT S/S	16



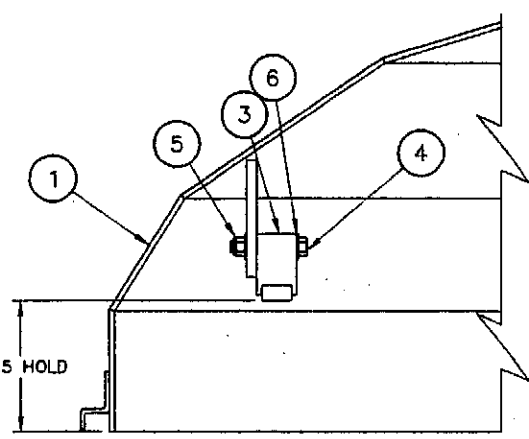
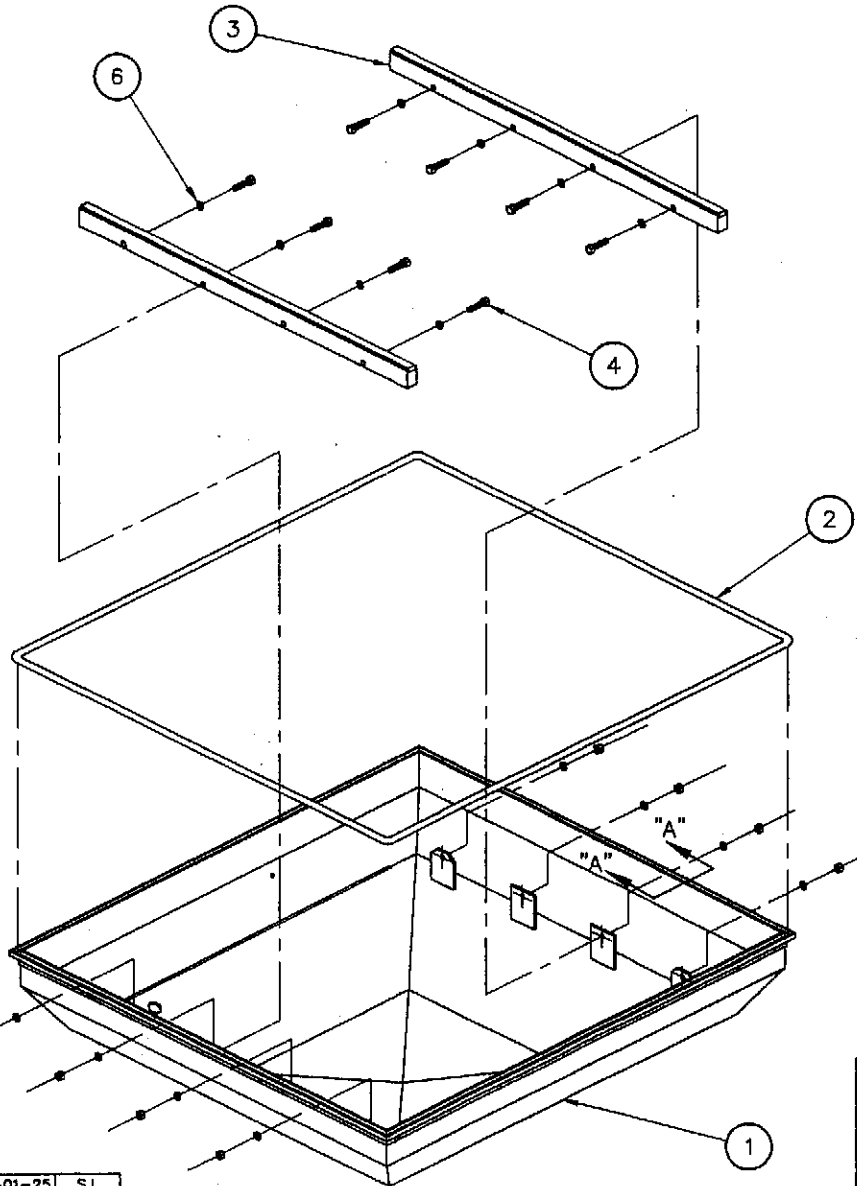
-SECTION A-A-

LET.	MODIFICATION	DATE	INT.
A	MODIFIED VIEW ITEM #3 (UPPER SEAL BAR)	00-01-25	S.L.

MACHINE	700A	METRIC TOLERANCE 0 ± .3 .0 ± .05 .000 ± .0005 ANGLE ± 1°	INCH TOLERANCE 0 ± .015 .00 ± .0005 N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	8" COVER ASSEMBLY	CNC		SCALE
ITEM:		DATE	99-04-22	QT. 1
MAT:	S. LAROUCHE	DATE		NO. 005-0473

1005-04/3

ITEM	PART #	DESCRIPTION	QT.
1	004-0248	12" COVER EXTERIOR PRE-ASSEMBLY	1
2	179-0020	NEOPRENE SPONGE 1/2"	14.0
3	004B0207	UPPER SEAL BAR ASSEMBLY	2
4	051-0250	BOLT 1/4"-20 x 1 1/2" S/S	8
5	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
6	051-0740	WASHER 1/4" FLAT S/S	16



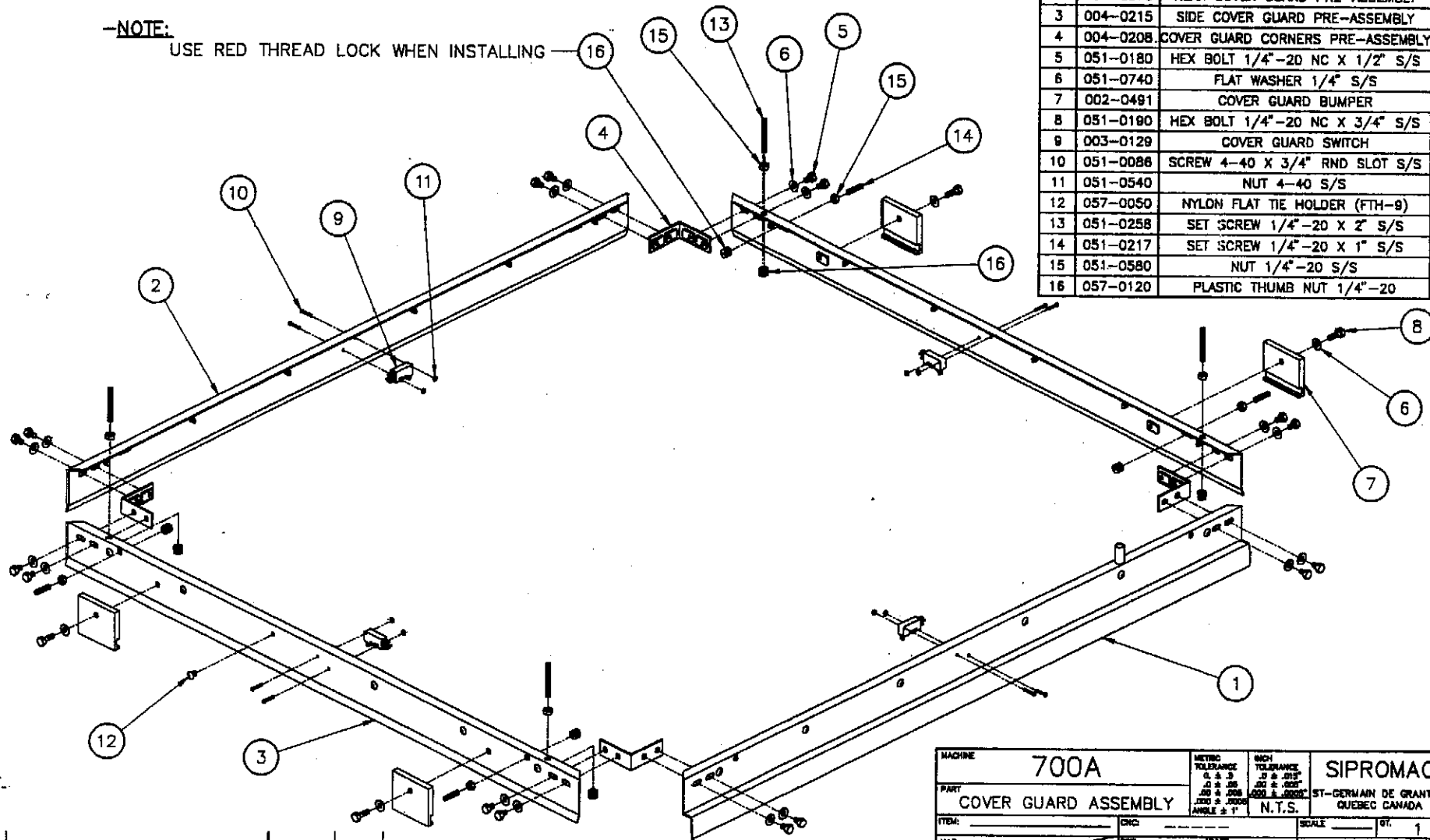
-SECTION A-A-

A	MODIFIED VIEW ITEM #3 (UPPER SEAL BAR)	00-01-25	S.L.
LET.	MODIFICATION	DATE	INT.

MACHINE	700A	METRIC TOLERANCE 1 ± .3 .0 ± .05 .00 ± .008 .000 ± .0008 ANGLE ± 1°	INCH TOLERANCE .0 ± .005 .00 ± .0005 .000 ± .00005 N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	12" COVER ASSEMBLY (OPTION)	DATE	99-04-22	NO.
ITEM:	CNC:	SCALE	ST.	1
MAT:	APP. S. LAROUCHE	DATE	99-04-22	NO.
				005-0474

**-NOTE:**  
USE RED THREAD LOCK WHEN INSTALLING

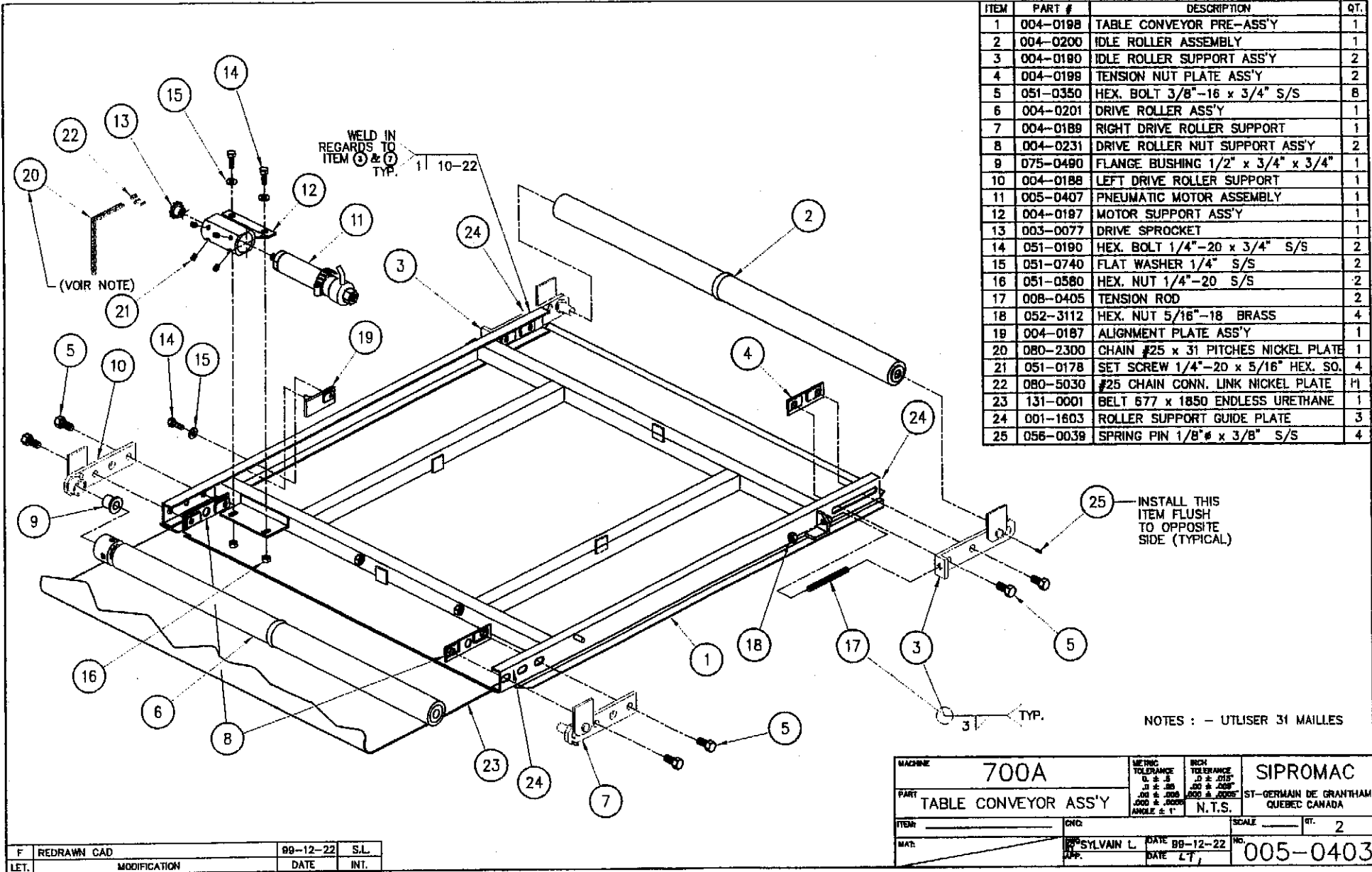
ITEM	PART #	DESCRIPTION	QT.
1	004-0214	COVER GUARD PRE-ASSEMBLY	1
2	004-0378	REAR COVER GUARD PRE-ASSEMBLY	1
3	004-0215	SIDE COVER GUARD PRE-ASSEMBLY	2
4	004-0208	COVER GUARD CORNERS PRE-ASSEMBLY	4
5	051-0180	HEX BOLT 1/4"-20 NC X 1/2" S/S	16
6	051-0740	FLAT WASHER 1/4" S/S	20
7	002-0491	COVER GUARD BUMPER	4
8	051-0190	HEX BOLT 1/4"-20 NC X 3/4" S/S	4
9	003-0129	COVER GUARD SWITCH	4
10	051-0088	SCREW 4-40 X 3/4" RND SLOT S/S	8
11	051-0540	NUT 4-40 S/S	8
12	057-0050	NYLON FLAT TIE HOLDER (FTH-9)	24
13	051-0258	SET SCREW 1/4"-20 X 2" S/S	4
14	051-0217	SET SCREW 1/4"-20 X 1" S/S	4
15	051-0580	NUT 1/4"-20 S/S	8
16	057-0120	PLASTIC THUMB NUT 1/4"-20	8



1005-0614

LET.	MODIFICATION	DATE	INT.
------	--------------	------	------

MACHINE <b>700A</b>		METRIC TOLERANCE G & S F & J6 J60 & J66 J600 & J606 ANGLE ± 1°	INCH TOLERANCE J & J12 J6 & J62 J60 & J66 N.T.S.	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART <b>COVER GUARD ASSEMBLY</b>		SCALE		QT. <b>1</b>
ITEM:	CRG:	DATE <b>88-06-18</b>	NO. <b>005-0614</b>	
MAT:	APP. <b>D</b>	DATE	DATE	



ITEM	PART #	DESCRIPTION	QT.
1	004-0198	TABLE CONVEYOR PRE-ASS'Y	1
2	004-0200	IDLE ROLLER ASSEMBLY	1
3	004-0190	IDLE ROLLER SUPPORT ASS'Y	2
4	004-0198	TENSION NUT PLATE ASS'Y	2
5	051-0350	HEX. BOLT 3/8"-16 x 3/4" S/S	8
6	004-0201	DRIVE ROLLER ASS'Y	1
7	004-0189	RIGHT DRIVE ROLLER SUPPORT	1
8	004-0231	DRIVE ROLLER NUT SUPPORT ASS'Y	2
9	075-0490	FLANGE BUSHING 1/2" x 3/4" x 3/4"	1
10	004-0188	LEFT DRIVE ROLLER SUPPORT	1
11	005-0407	PNEUMATIC MOTOR ASSEMBLY	1
12	004-0187	MOTOR SUPPORT ASS'Y	1
13	003-0077	DRIVE SPROCKET	1
14	051-0190	HEX. BOLT 1/4"-20 x 3/4" S/S	2
15	051-0740	FLAT WASHER 1/4" S/S	2
16	051-0580	HEX. NUT 1/4"-20 S/S	2
17	008-0405	TENSION ROD	2
18	052-3112	HEX. NUT 5/16"-18 BRASS	4
19	004-0187	ALIGNMENT PLATE ASS'Y	1
20	080-2300	CHAIN #25 x 31 PITCHES NICKEL PLATE	1
21	051-0178	SET SCREW 1/4"-20 x 5/16" HEX. SO.	4
22	080-5030	#25 CHAIN CONN. LINK NICKEL PLATE	11
23	131-0001	BELT 677 x 1850 ENDLESS URETHANE	1
24	001-1603	ROLLER SUPPORT GUIDE PLATE	3
25	056-0039	SPRING PIN 1/8" x 3/8" S/S	4

1005-0403

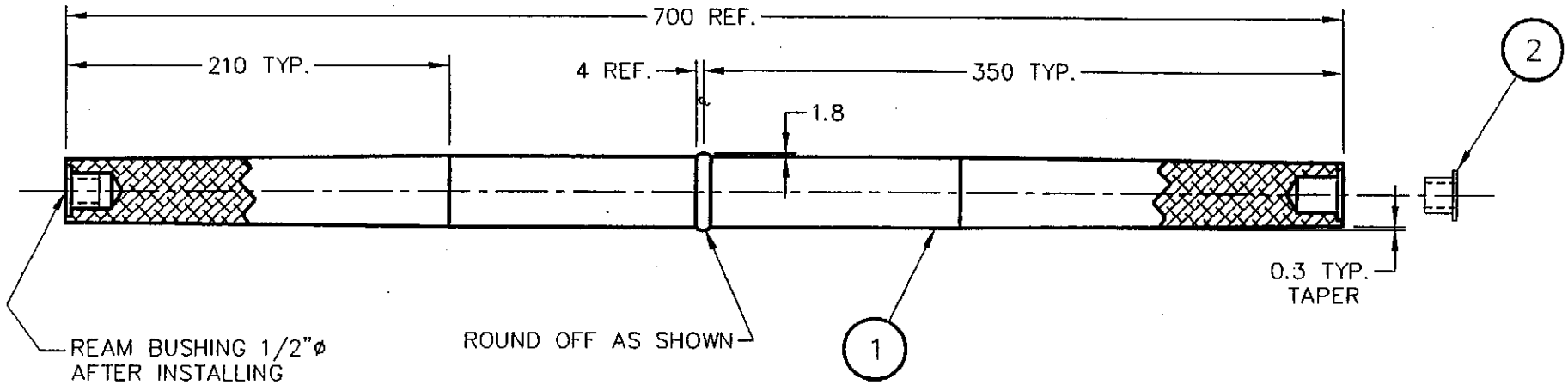
F	REDRAWN CAD	09-12-22	S.L.
LET.	MODIFICATION	DATE	INT.

MACHINE		700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC	
PART		TABLE CONVEYOR ASS'Y		0.1 ± .03	0.005 ± .015	ST-GERMAIN DE GRANTHAM	
ITEM:				0.01 ± .008	0.000 ± .0005	QUEBEC CANADA	
MAT:				0.000 ± .0005	0.000 ± .0005	N.T.S.	
				ANGLE ± 1°		SCALE	
						ST. 2	
						NO. 005-0403	
						DATE 09-12-22	
						DATE 17	

004-0200

ITEM	PART #	DESCRIPTION	QT.
1	004-0384	IDLE ROLLER PRE-ASS'Y	1
2	075-0490	BUSHING FLANGE 1/2" x 3/4" x 3/4" BR	2

50



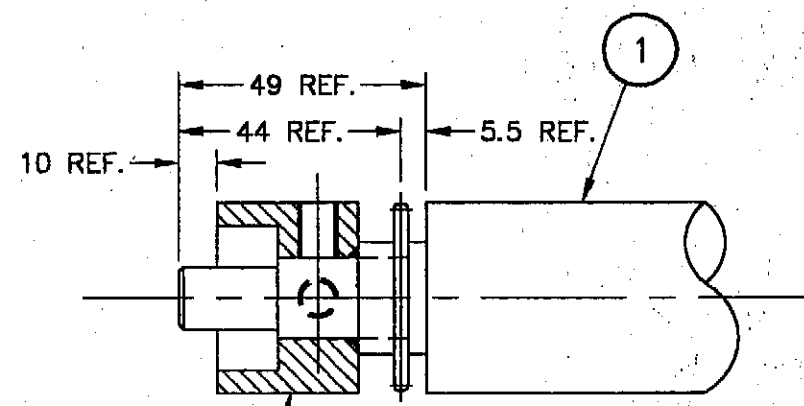
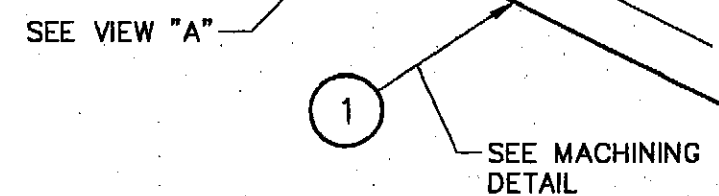
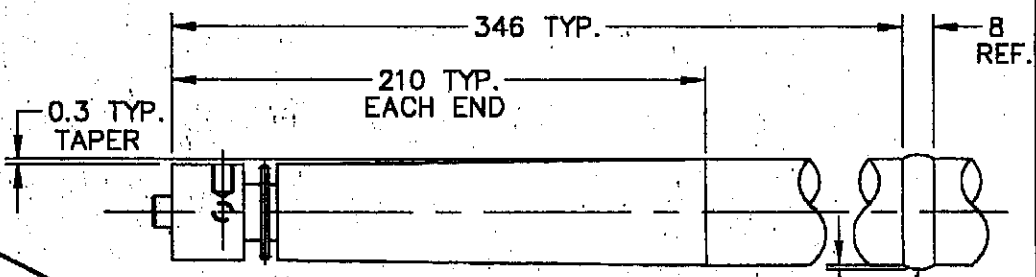
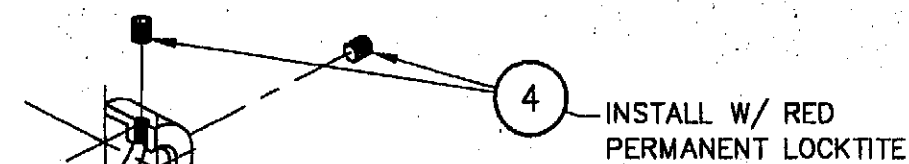
**NOTE:**

-MACHINE ROLLER  
AFTER INSTALLING  
BUSHING

MACHINE	700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	IDLE ROLLER ASS'Y		0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1'	0 ± .015" .00 ± .005" .000 ± .0005" N.T.S.	
ITEM:	CNC:	02200/1	SCALE	QT.	2
MAT:	DWC BY	SYLVAIN L.	DATE	99-12-06	NO.
LET.	MODIFICATION	DATE	INT.		004-0200

004-0201

ITEM	PART #	DESCRIPTION	QT.
1	004-0385	DRIVE ROLLER PRE-ASS'Y	1
2	075-0490	BUSHING 1/2" x 3/4" x 3/4" BRONZE	1
3	002-0383	DRIVE ROLLER PART-2	1
4	051-0290	SET SCREW 5/16"-18 x 5/16" S/S	2



VIEW "A"

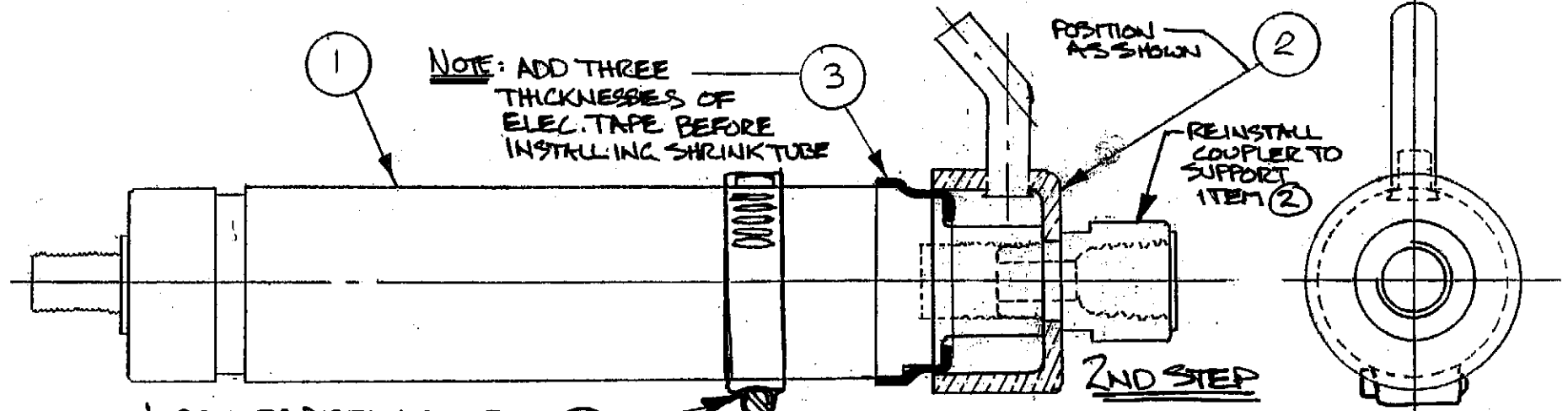
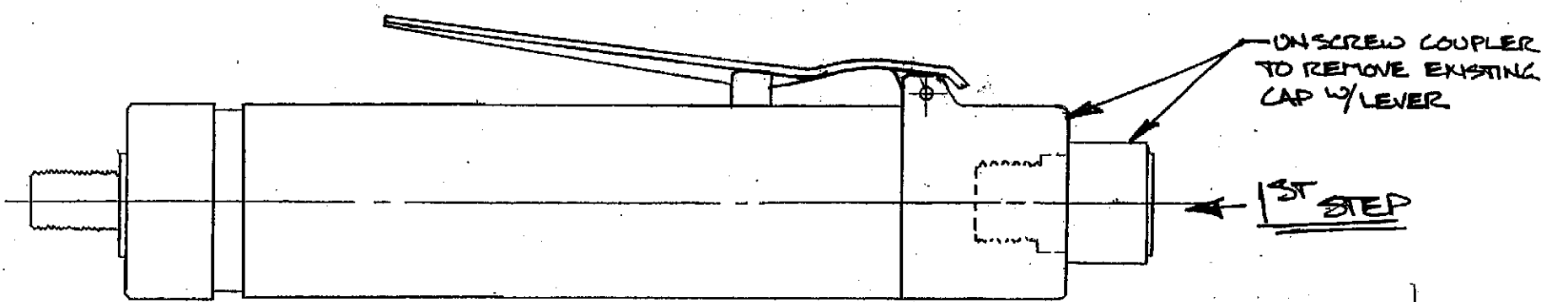
**NOTE:**  
 -MACHINE AFTER ASSEMBLING  
 REAM BUSHING 1/2" Ø AFTER INSTALLING

MACHINE	700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	DRIVE ROLLER ASS'Y		0. ± .5 .0 ± .06 .00 ± .006 .000 ± .0005 ANGLE ± 1'	.0 ± .015" .00 ± .005" 1.000 ± .0005" N.T.S.	
ITEM:	CNC:	SCALE	QT.	2	
E	REDRAWN CAD	99-12-08	S.L.	DWG BY SYLVAIN L.	DATE 99-12-08
LET.	MODIFICATION	DATE	INT.	APP.	DATE

004-0201

005-0407

ITEM	# PIECE	DESCRIPTION	QT.
1	114-0910	PNEU DRILL ASSY	1
2	004-0210	OIL EVALUATION CAP PRE-ASSY.	1
3	030-0720	SHRINK 1 1/2" BLACK	1
4	105-0110	SCREW CLAMP 1 1/16" TO 2" ALL S/S	1



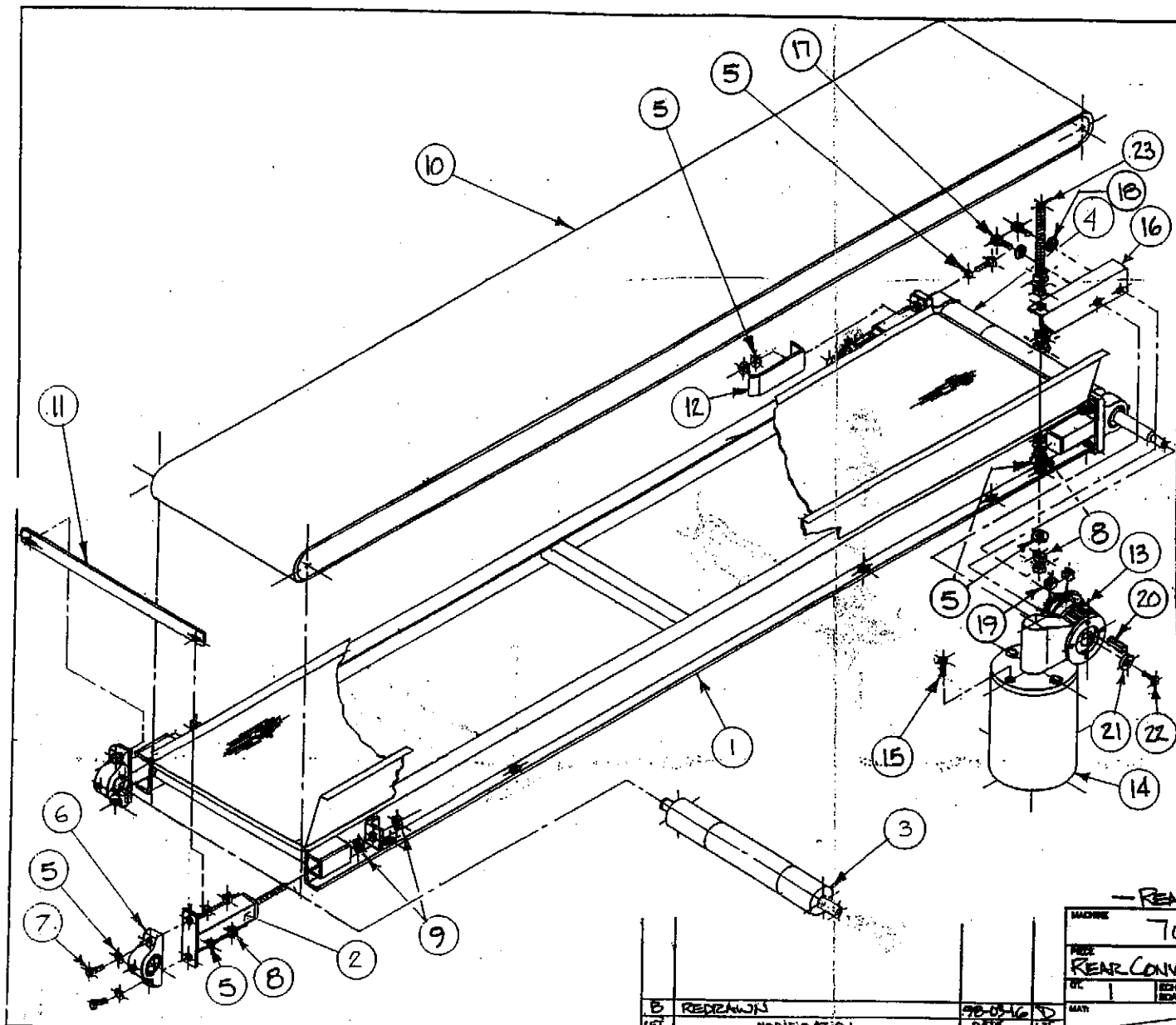
IMPORTANT: POSITION COLLAR AS SHOWN OVER SWITCH BUTTON & TIGHTEN MODERATELY

MACHINE	700A	METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PIECE	PNEUMATIC MOTOR ASSEMBLY	0 ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1'	0 ± .015 .00 ± .005 .000 ± .0005	
QT.	2	ECH. SCALE	N.T.S.	

A	FRENCH → ENGLISH	93-05-17	D	MAT.	DESS.	DATE	NO.
LET.	MODIFICATION	DATE	INT.		APP. DAVE	DATE	005-0407

52





ITEM	PART NO.	DESCRIPTION	QTY.
1	004-0196	REAR CONVEYOR PRE-ASBY.	1
2	004-0195	TENSION BLOCK PRE-ASBY.	3
3	004-0202	IDLE ROLLER ASBY.	1
4	004-0203	DRIVE ROLLER ASBY.	1
5	051-0183	FLAT WASHER 3/8" THICK 5/8	18
6	075-1521	PULLOW BLOCK 3/4" LOCKING COLLAR	4
7	051-0380	HEX BOLT 3/8"-16x1 1/2 5/8	8
8	051-0620	HEX NUT 3/8"-16 5/8	16
9	052-3151	HEX NUT 1/2"-15 BRASS	6
10	131-0009	BOLT ZIPP PK ENDLESS 16" x .087	1
11	081-1480	PRODUCT STOPPER BAR	1
12	001-1487	PRODUCT GUIDE	1
13	057-6000	GEAR BOX RATIO 20:1 M.V.F. 44F	1
14	057-0012	MOTOR 1/2 H.P. 50C FRAME	1
15	051-0350	HEX BOLT 3/8"-16x 3/4 5/8	4
16	001-1471	GEAR BOX ARM	1
17	051-0500	HEX BOLT 5/16"-18x 3/4 5/8	2
18	051-0160	FLAT WASHER 3/16 5/8	4
19	051-0600	HEX NUT 5/16"-18 5/8	2
20	008-0482	GEAR BOX/SHAFT KEY	1
21	001-1472	GEAR BOX RETAINER	1
22	051-0190	HEX BOLT 1/4"-20x 3/4 5/8	1
23	008-0373	GEAR BOX STABILIZER	1

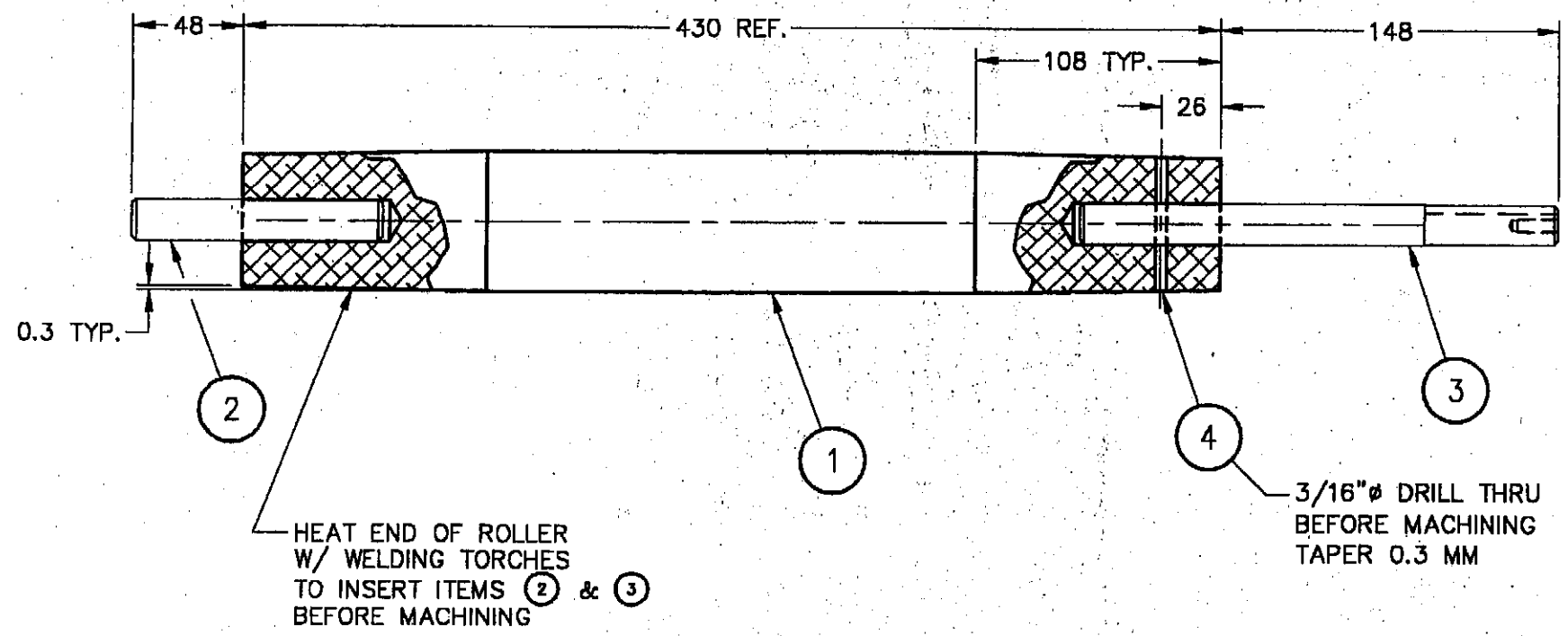
- REAR CONVEYOR OPTION -

MACHINE	700A	METRIC TOLERANCES	ASSEMBLY	SIPROMAC ST-BERNAIN DE GRANTHAM QUEBEC CANADA
PART	REAR CONVEYOR ASSEMBLY	ASSEMBLY	N.T.S.	
QTY.		UNIT		005-0398
BY	B. REDDAWON	DATE	98-05-16	
REV.	MODIFICATION	DATE		

005-0398

004-0203

ITEM	PART #	DESCRIPTION	QT.
1	002-0365	ROLLER	1
2	002-0366	IDLE ROLLER AXIS (REAR CONV.)	1
3	002-0367	DRIVE ROLLER AXIS (REAR CONV.)	1
4	056-0046	SPRING PIN 3/16" NOM x 2" S/S	1



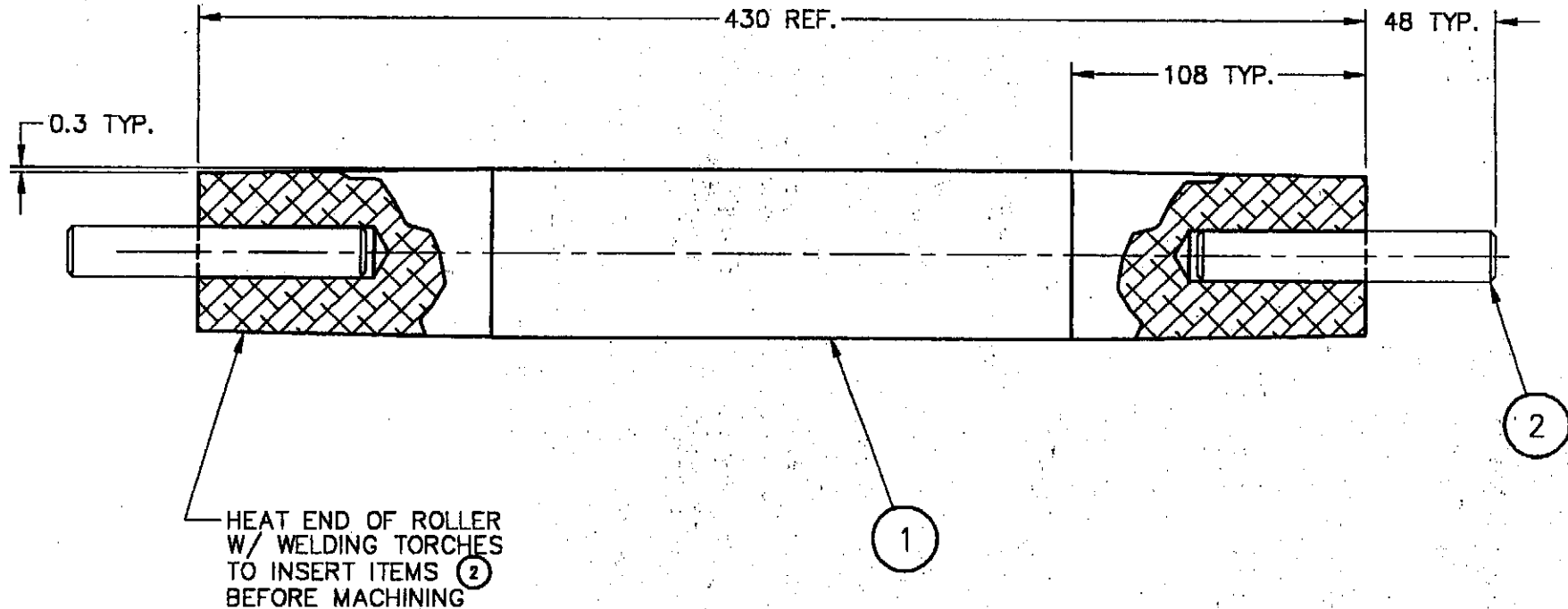
-REAR CONVEYOR OPTION-

MACHINE	700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	DRIVE ROLLER ASS'Y		0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1°	.0 ± .015° .00 ± .005° 0.00 ± .0005° N.T.S.	
ITEM:	CNC:	SCALE	QT.	1	
LET.	MODIFICATION	DATE	INT.	DWG BY: SYLVAIN L. APP. <i>D</i>	NO. 004-0203
C	REDRAWN CAD	99-12-14	S.L.	DATE 99-12-14	DATE

54

004-0202

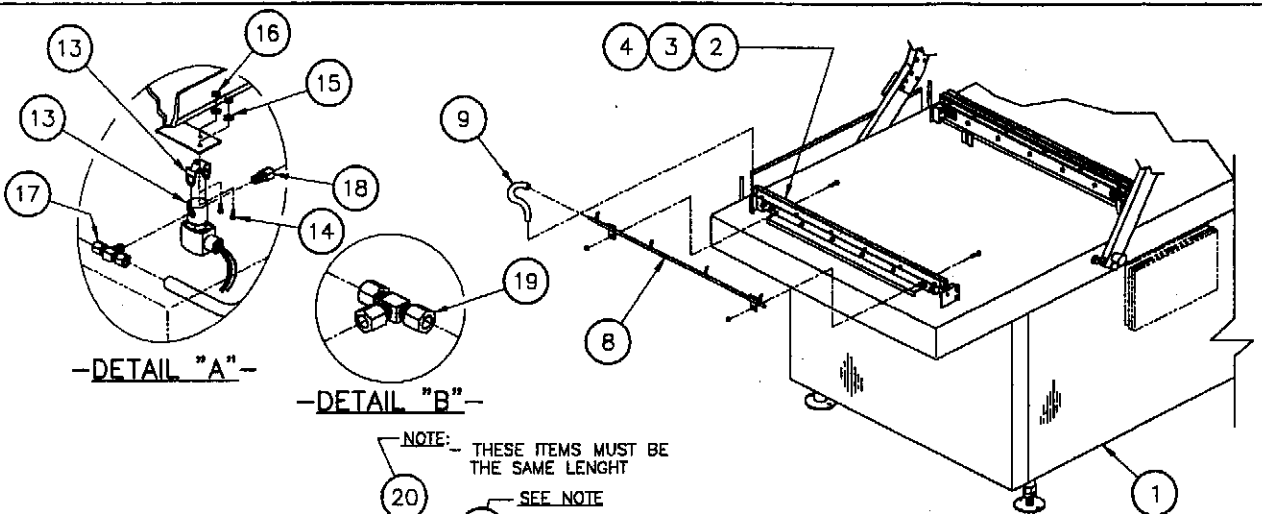
ITEM	PART #	DESCRIPTION	QT.
1	002-0365	ROLLER	1
2	002-0366	IDLE ROLLER AXIS (REAR CONV.)	2



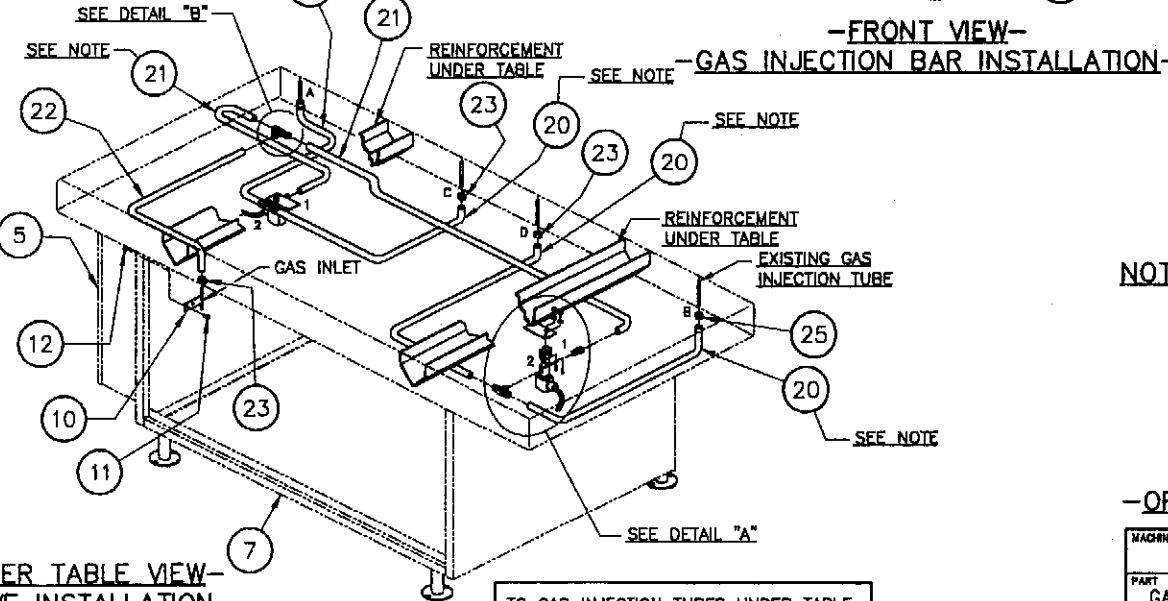
-REAR CONVEYOR OPTION-

MACHINE	700A		METRIC TOLERANCE	INCH TOLERANCE	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	IDLE ROLLER ASS'Y		0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1°	.0 ± .015° .00 ± .005° .000 ± .0005° N.T.S.	
ITEM:	_____	CNC:	_____	SCALE	DT. 1
MAT:	_____	DWG BY	SYLVAIN L.	DATE	99-12-14
LET.	MODIFICATION	DATE	INT.	APP.	NO. 004-0202

55



ITEM	PART #	DESCRIPTION	QT.
1	005-0395	MACHINE ASSEMBLY FRONT VIEW	1
2	005A0547	SEAL BAR ASS'Y W/ SUPPORT	4
3	005A0548	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	4
4	005A0549	SEAL BAR ASS'Y W/ SUPPORT (T&B OPT.)	4
5	005-0479	ELECTRICAL BOX ASSEMBLY	1
6	004-0250	ELECTRICAL BOX COVER PRE-ASS'Y	1
7	005-0396	MACHINE ASSEMBLY REAR VIEW	1
8	005A0350	GAS INJECTION BAR ASSEMBLY (OPTION)	4
9	008-0464	GAS INJECTION CONN. TUBE (OPTION)	4
10	005-0323	GAS INLET ASSEMBLY	1
11	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
12	051-0580	HEX. NUT 1/4"-20 NC. S/S (OPTION)	1
13	108-0010	SELENOIDE VALVE 2 WAY 1/4" NPT W/ SUPP.	2
14	051-0100	SCREW #8-32 X 3/8" PAN PHILL S/S	4
15	051-0720	FLAT WASHER #8 S/S	4
16	051-0550	HEX. NUT #8 S/S	4
17	101-0065	"T" 3/8" T.P.COMP. X 1/4" MNPT X 3/8" T.P.COMP.	2
18	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	2
19	101-0062	"T" 3/8" T.P.COMP.	1
20	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	4
21	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	2
22	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	1
23	105-0200	COLLARS 3/8" #	5



**NOTE:**

PARTS 1 THRU 7 ARE EXISTING PARTS

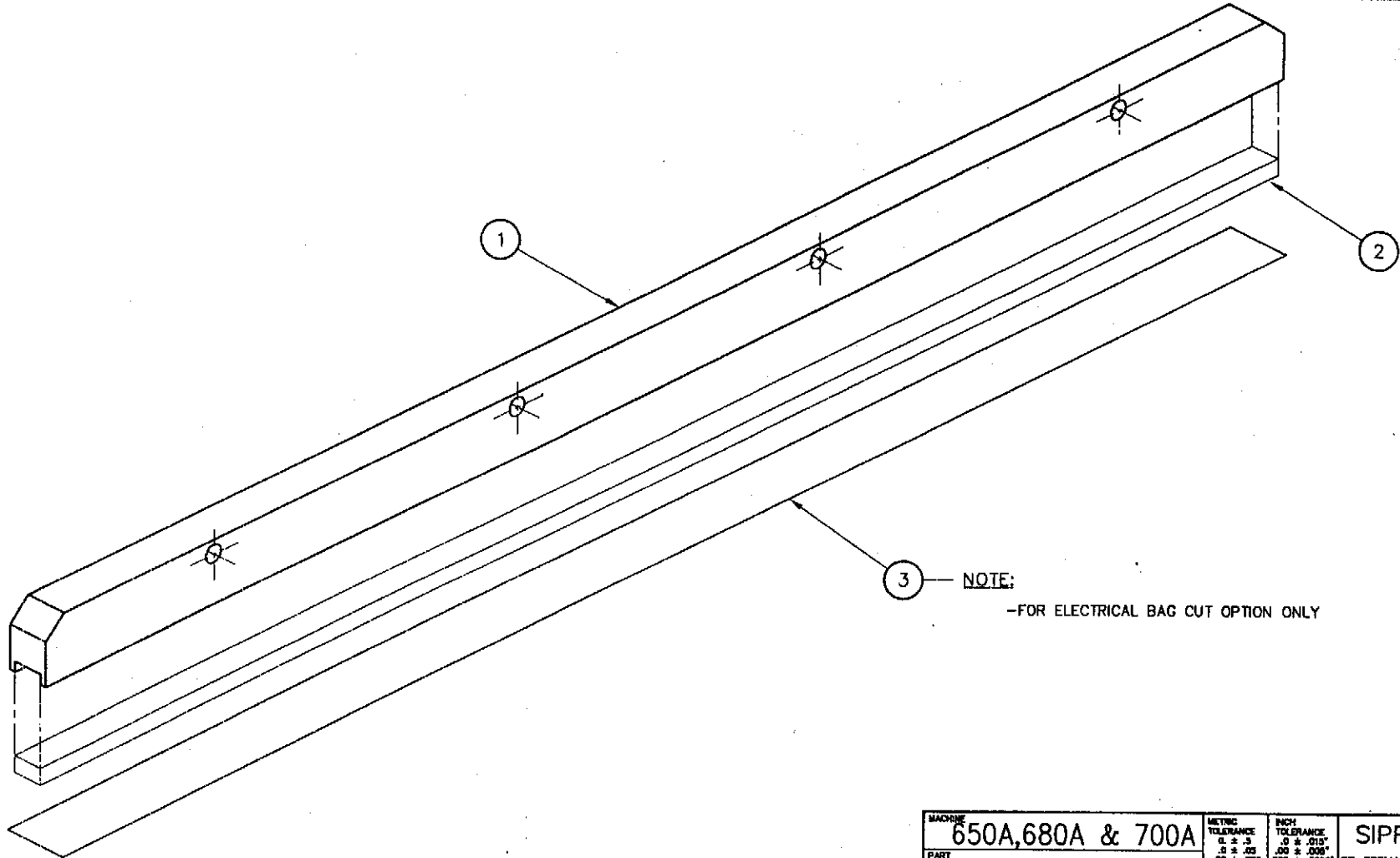
PARTS 8 THRU 23 ARE PARTS SUPPLIED W/ KIT

**-OPTION GAS INJECTION-**

MACHINE <b>700A</b>		METRIC TOLERANCE 0 ± .005 .00 ± .005 1.00 ± .005 1.00 ± .005 ANGLE ± 1°	INCH TOLERANCE 0 ± .015" .00 ± .005" 1.00 ± .005" 1.00 ± .005" N.T.S.	SCALE	DT. 1
PART <b>GAS INJECTION KIT INSTALLATION</b>					
ITEM:	CNC:	DATE 98-03-24		NO. 010-0021	
MAT:	APP. A. PROVENCHER	DATE	DATE		

C	REDRAWN/ MODIF. NO. A-0245	98-03-24	A.P.
LET.	MODIFICATION	DATE	INT.

ITEM	PART #	DESCRIPTION	QT.
1	002B0364	UPPER SEAL BAR SUPPORT	2
2	008-0374	UPPER SEAL BAR RUBBER	2
3	176-0200	TEFLON TAPE (5S) ADHESIVE (2" x 938MM)	0.12



3 NOTE:  
-FOR ELECTRICAL BAG CUT OPTION ONLY

57

1004B0207

G	ADDED 650A WAS 004B0139	00-02-01	S.L.
F	REDRAWN WAS 004A0207	99-08-20	S.L.
LET.	MODIFICATION	DATE	INT.

MACHINE 650A, 680A & 700A		METRIC TOLERANCE 0.2 ± 0.3 0.1 ± 0.2 0.05 ± 0.08 0.00 ± 0.005 ANGLE ± 1°	INCH TOLERANCE 0 ± .015" 0.00 ± .008" 0.00 ± .0005" N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART UPPER SEAL BAR ASSEMBLY				
ITEM:	QNC:	SCALE:		QT. 2
MAT:	APP. S. LAROUCHE	DATE 99-08-20	NG. 004B0207	



# ELECTRICAL DRAWINGS PARTS LIST

MODEL: 700A

A: VOLT	PHASE	PUMP HP	CONTACTOR	OVERLOAD
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: 106-0050 WITH PUMPS: 7.5 HP & 10 HP

G: BELLOW SOLENOID VALVE: 106-0070

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

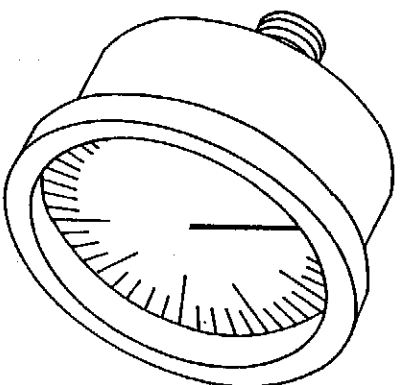
K: SEALING TRANSFO.: 029-0172, 029-0174

L: RELAY & BASE:

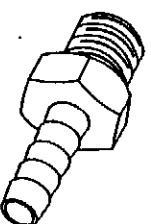
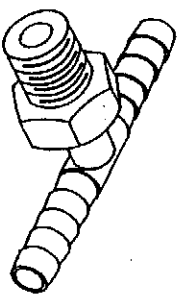
RELAY: 025-0600  
BASE: 025-0610

M:OPTIONAL TOP SEALING CONTACTOR: 025-0020

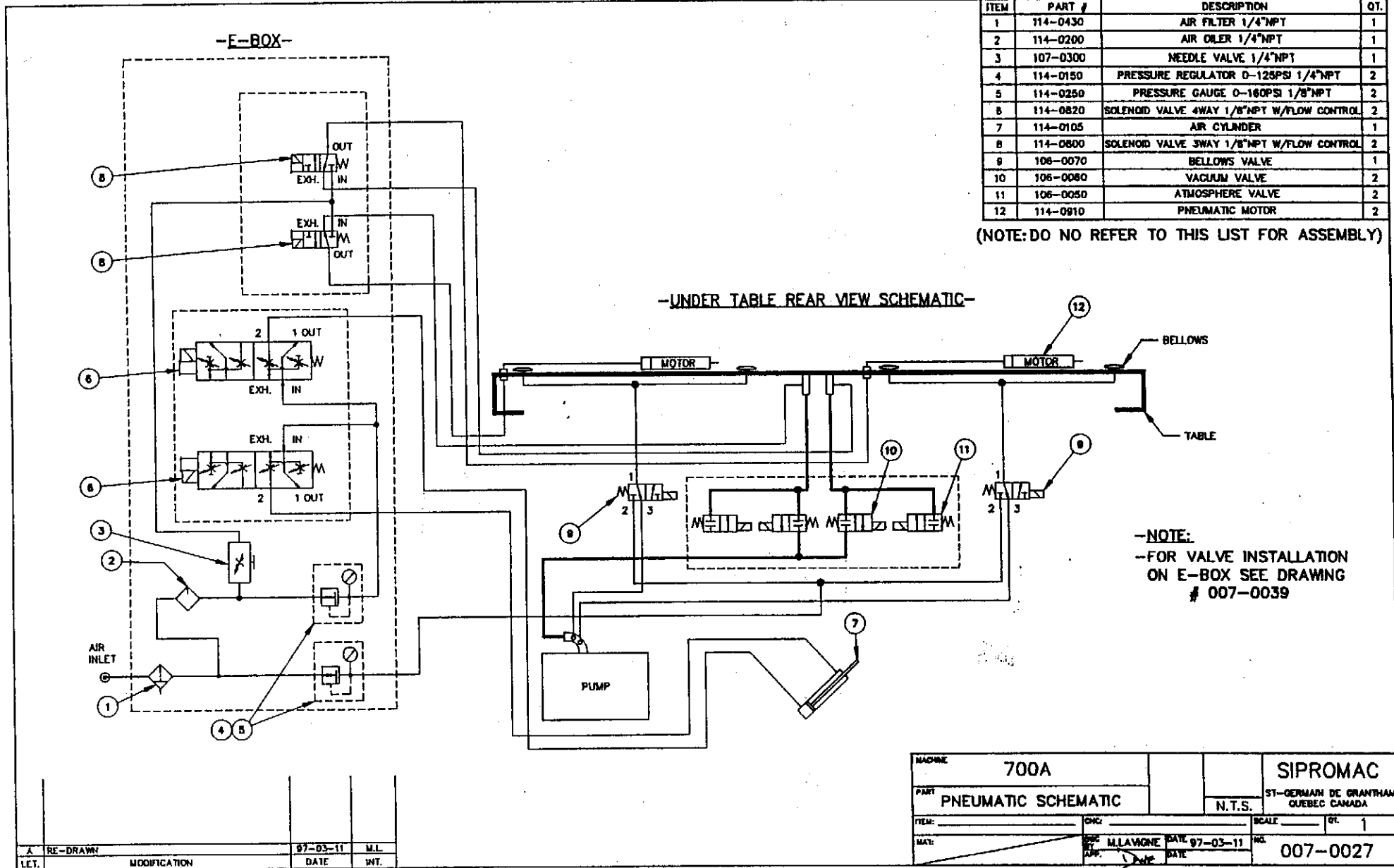
N:CONTROL TRANSFO.: 029-0010



# PNEUMATIC DRAWING





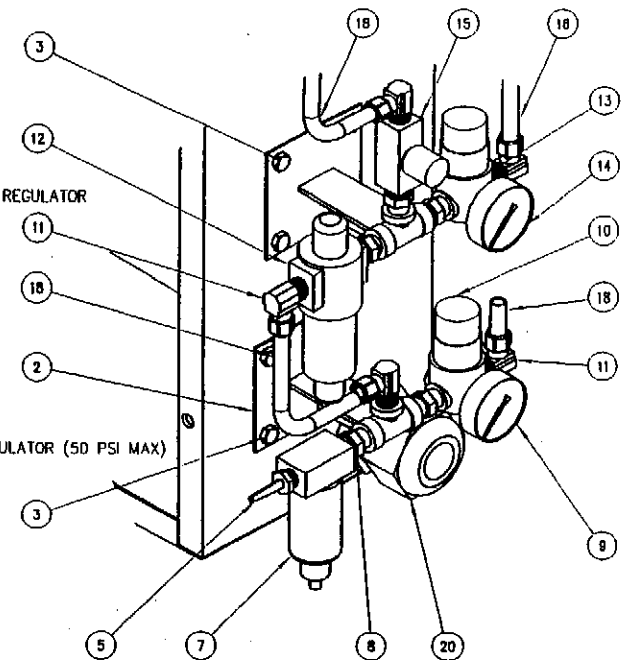
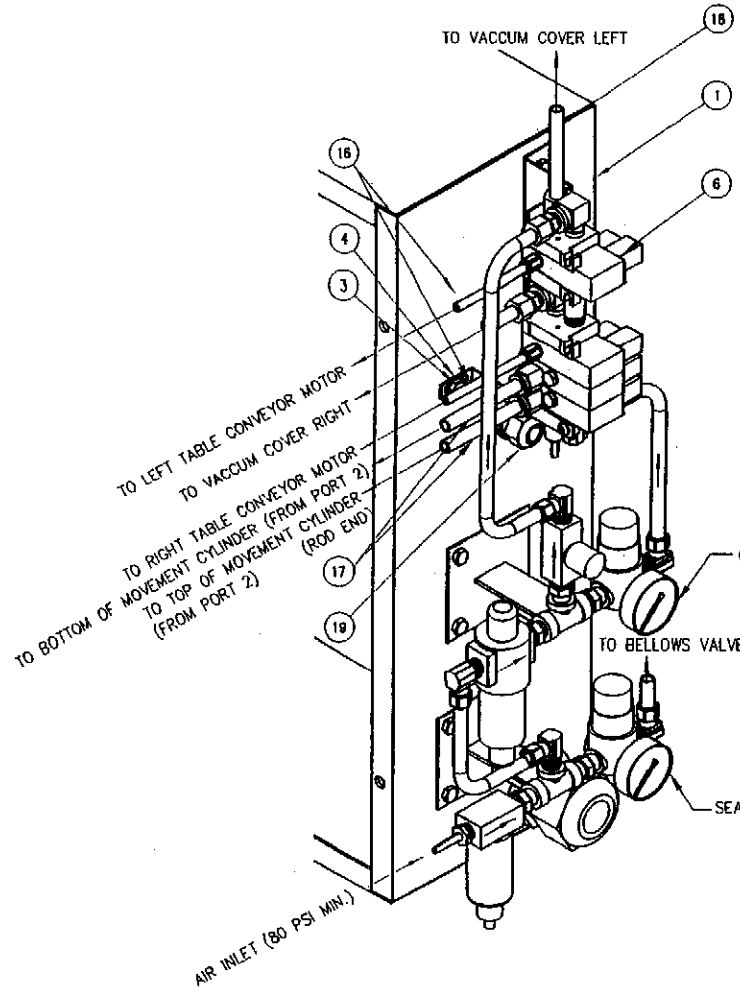


REV.	DESCRIPTION	DATE	BY
A	RE-DRAWN	97-03-11	M.L.
LET.	MODIFICATION	DATE	INT.

MACHINE	700A	SIPROMAC	
PART	PNEUMATIC SCHEMATIC	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	CNC:	SCALE	QT. 1
MAT:	APP. M. LAVIGNE	DATE 97-03-11	NO. 007-0027

007-0039

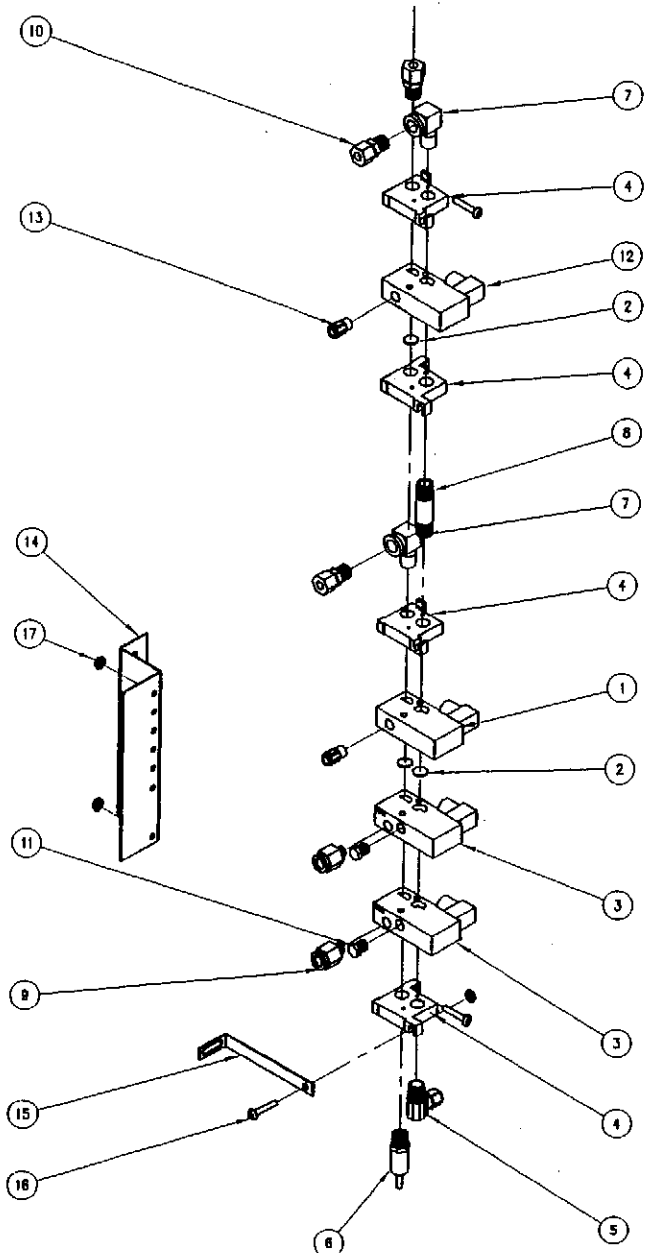
ITEM	PART#	DESCRIPTION	QT.
1	005-0401	E-BOX PRE-ASS'Y	1
2	005-0524	PNEUMATIC SUPPORT ASS'Y	2
3	051-0190	BOLT 1/4-20 x 3/4" HEX S/S	11
4	051-0740	FLAT WASHER 1/4" S/S	1
5	101-0200	STRAIGHT 1/4"MNPT X 1/4" HOSE BARB BR.	1
6	004A0985	PRE-ASS'Y VALVE INSTALLATION	1
7	114-0430	AIR FILTER 1/4" NPT	1
8	101-0315	HEXAGONALE NIPPLE 1/4" NPT BR.	5
9	114-0245	PRESSURE GAUGE-60psi. 1/8"npt.	1
10	114-0147	PRESSURE REGULATOR 0-60 PSI 1/8"NPT	1
11	101-0058	ELBOW 90° 1/4"mnpt. X 3/8" T.P. COMP.	5
12	114-0200	LUBRICATOR 1/4"NPT	1
13	114-0150	PRESSURE REGULATOR 0-125PSI 1/4"NPT	1
14	114-0250	PRESSURE GAUGE 0-160psi. 1/8"npt.	1
15	107-0300	IN-LINE FLOW CONTROL 1/4"NPT	1
16	104-0004	POLYURETHANE TUBING 1/4" OD RED	---
17	104-0077	POLYURETHANE 3/8" OD SMC BLUE	---
18	104-0060	POLYURETHANE TUBING 3/8" OD LPDE	---
19	036-0409	PRESSE-ÉTOUPE CD13NABKS + "O" RING	1
20	036-0440	PRESSE-ÉTOUPE CD36AA-BK + "O" RING	1



A	REDESSINER MOT	01-12-03	Y.C.
LET.	MODIFICATION	DATE	INT.

MACHINE	700A		TOLERANCE	INCH		SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	E-BOX VALVE INSTALLATION		USINAGE	± 0.1	± 0.004	
ITEM:	CNC:		TOLERANCE	± 0.5	± 0.020	
MAT:	DWC YAN C.		FINISHING	± 0.5	± 0.020	N.T.S.
		DATE 01-12-03				M
		DATE				1
						007-0039

1004A0985



ITEM	PART#	DESCRIPTION	QT.
1	114-0800	VALVE 3 WAYS 24VAC 1/8"NPT	2
2	114-0870	2 PORT ISOLATOR KIT	2
3	114-0820	VALVE 4 WAYS 24VAC 1/8"NPT W/FLOW CONT.	2
4	114-0860	2 ENDS PLATES KIT 1/4"npt.	2
5	101-0058	ELBOW 90° 1/4"mnpt. X 3/8" T.P. COMP.	1
6	114-1055	MUFFLER 1/4"npt. ADJ.	1
7	101-0660	ELBOW STREET 90° 1/4" NPT BR.	2
8	101-0325	NIPPLE 1/4"npt. X 2" BR.	1
9	102-0380	MALE CONN. 1/8"MNPT X 3/8" T. QUICK	2
10	101-0036	STRAIGHT 1/4"MNPT. X 3/8" T.P. COMP.	3
11	101-1020	HEX. PLUG 1/8"NPT BR.	2
12	114-0850	MINI DIM PLUG HS 2	4
13	102-0370	MALE CONN. 1/8"MNPT X 1/4" T QUICK	2
14	001-1840	VALVE MTG. BRACKET	1
15	001-1839	AIR VALVE SUPPORT	1
16	051-0146	SCREW 10-24 x 1" PAN PHIL S/S	3
17	051-0571	NUT #10-24 S/S	3

LET.	MODIFICATION	DATE	INT.

MACHINE		700A		TOLERANCE		MICH		SIPROMAC	
PART		PRE ASS'Y VALVE INSTALLATION		USURAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM		
ITEM:		CNC:		TOLERANCE	± 0.5	± 0.020"	QUEBEC CANADA		
MAT:		APP. <i>LT</i>		DATE	01-11-20	± 0.004"	N.T.S.		
				DATE			M		QT. 1
						004A0985			

**NOTES**

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

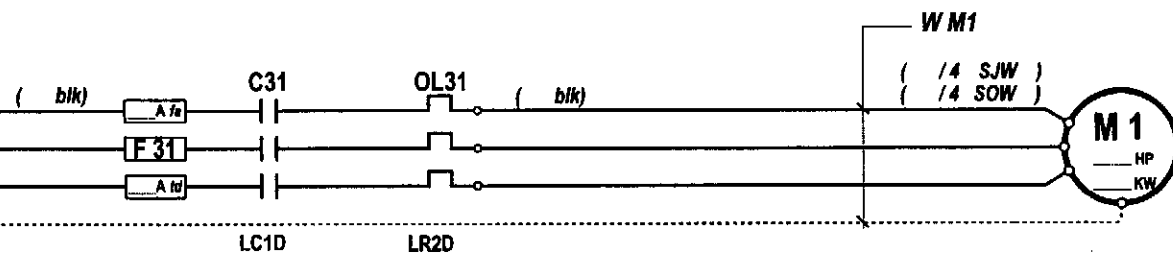
---

# NOTES

Tested with: \_\_\_\_\_ V 3 Ph \_\_\_\_\_ Hz

Gnd  
 L1  
 L2  
 L3

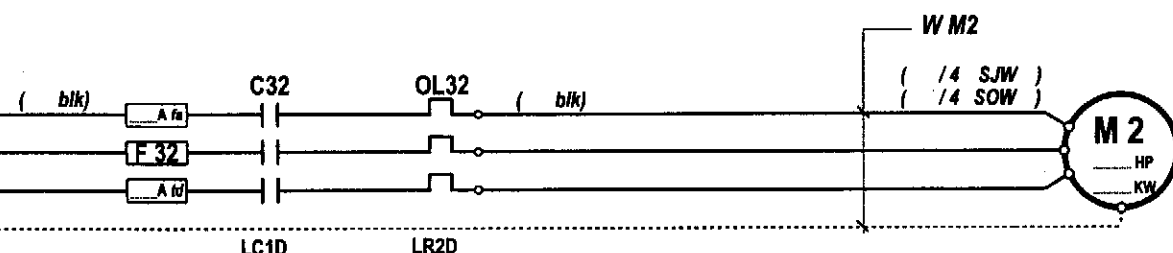
name  
 plate  
 \_\_\_\_\_  
 measured  
 \_\_\_\_\_



**VACUUM PUMP**

**Pump**  
 Model : \_\_\_\_\_  
 Sn : \_\_\_\_\_  
**Motor**  
 Model : \_\_\_\_\_  
 Sn : \_\_\_\_\_  
 Vac : \_\_\_\_\_  
 Vacuum : \_\_\_\_\_ *mb*

LC1D  
 \_\_\_\_\_  
 LR2D  
 \_\_\_\_\_  
 Setting  
 \_\_\_\_\_  
 A



**REAR CONVEYOR**

**Motor**  
 Model : \_\_\_\_\_  
 Sn : \_\_\_\_\_  
**Gearbox**  
 Model : \_\_\_\_\_  
 Sn : \_\_\_\_\_  
 Ratio : \_\_\_\_\_

LC1D  
 \_\_\_\_\_  
 LR2D  
 \_\_\_\_\_  
 Setting  
 \_\_\_\_\_  
 A

Total: \_\_\_\_\_ A  
 KW : \_\_\_\_\_

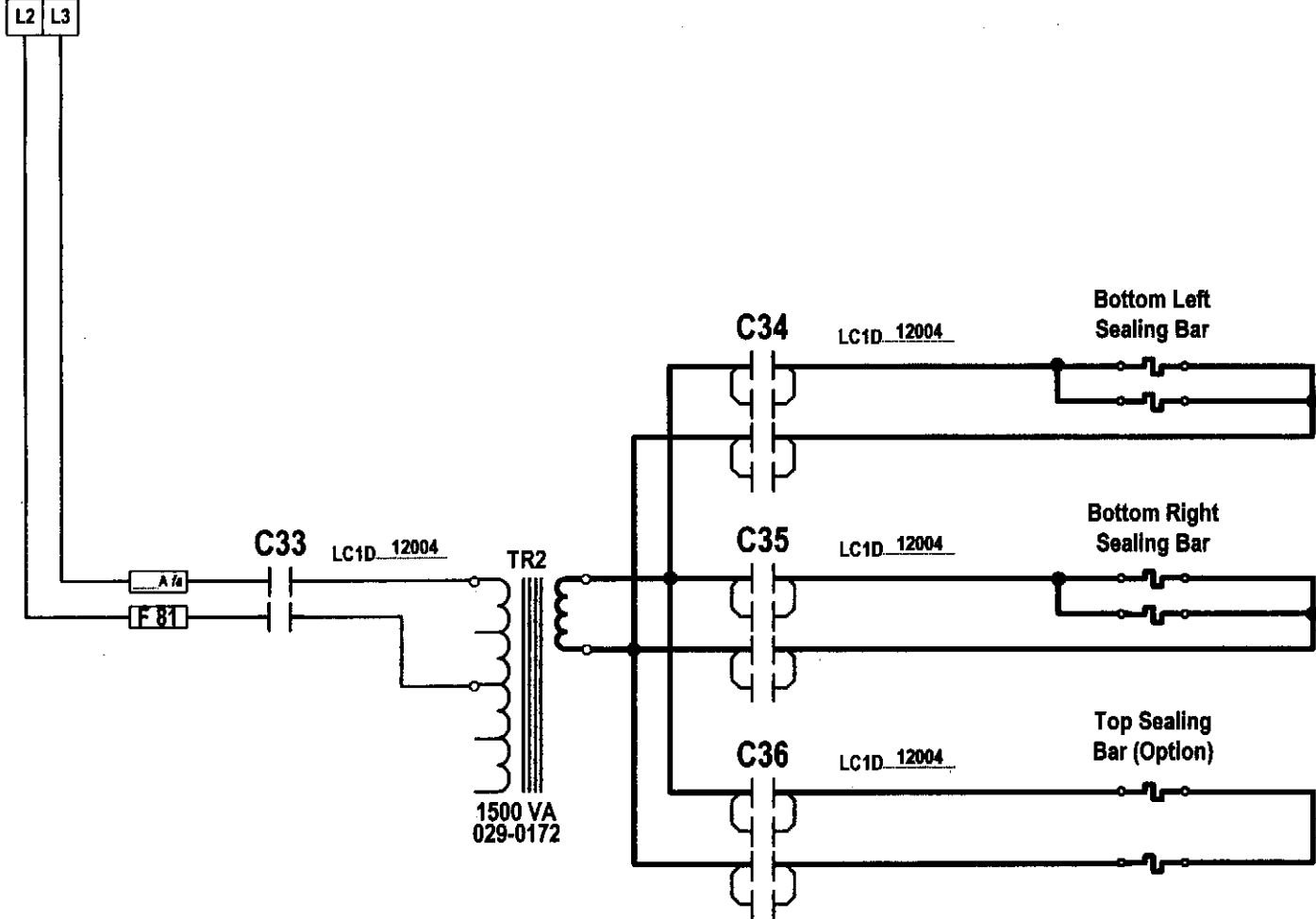
category	<b>VACUUM PACK</b>	model	<b>700A &amp; 680A</b>	volt.	<b>ALL</b>				<b>SIPROMAC</b> St-Germain de Grantham QUEBEC, CANADA
system	<b>PUMP AND CONVEYOR</b>			circuit	<b>Power</b>	year	month	day	
usual fonctions				concept	GM	Y.C	XX	<b>006A0495</b> PAGE 1 de 10	
options									

Tested with: \_\_\_\_\_ V Ph \_\_\_\_\_ Hz

L2 L3

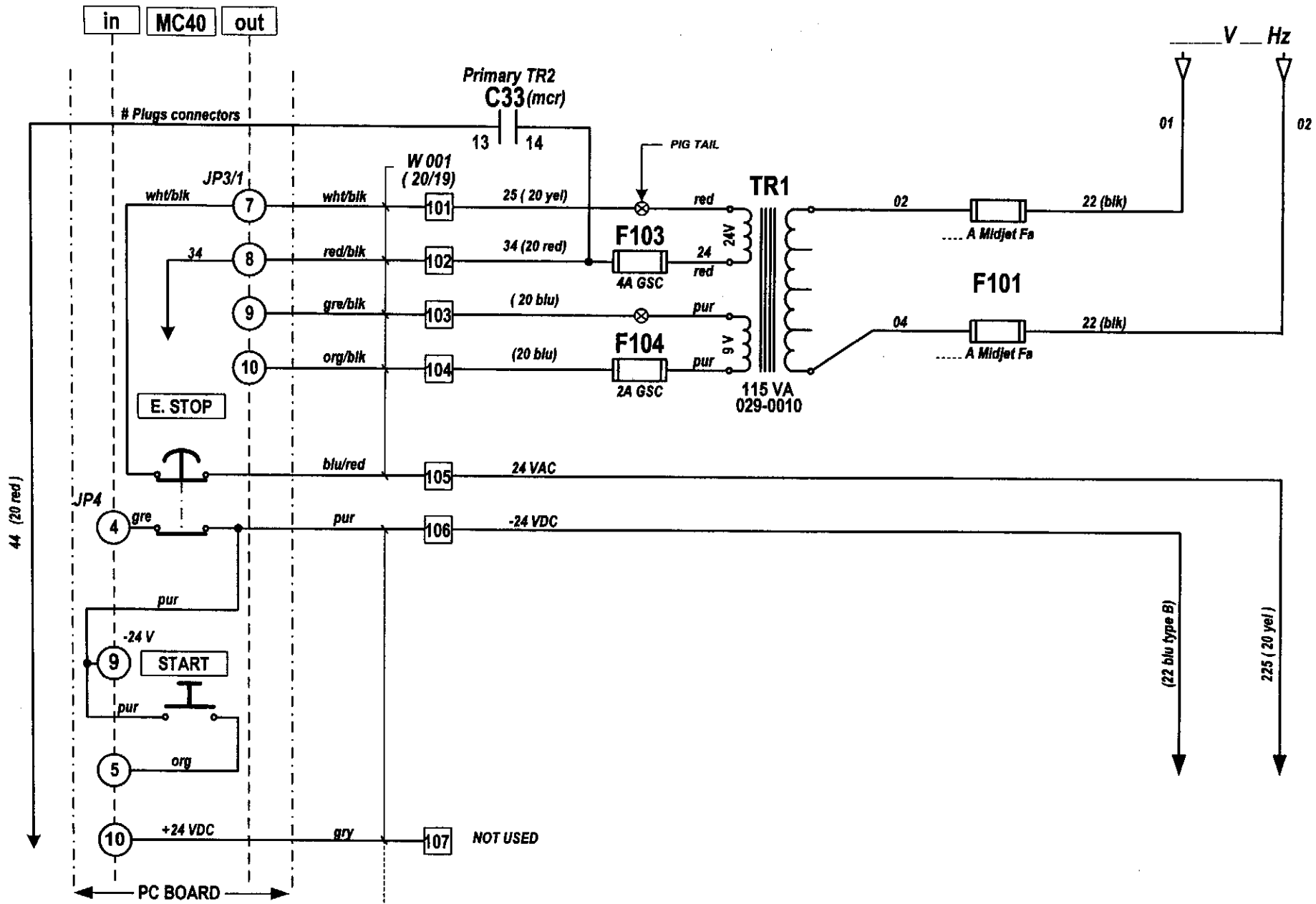
name  
plate

measured



Total: \_\_\_\_\_ A  
Kw: \_\_\_\_\_

category	VACUUM PACK	model	700A & 680A	volt	ALL				SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system	SEALING			circuit	Power	year	month	day	
usual fonctions	Bottom Sealing					02	07	02	
options	Top Sealing					concept	draw	app	
						GM	Y.C	XX	006A0495 PAGE 2 de 10



44 (20 red)

(22 blu type B)

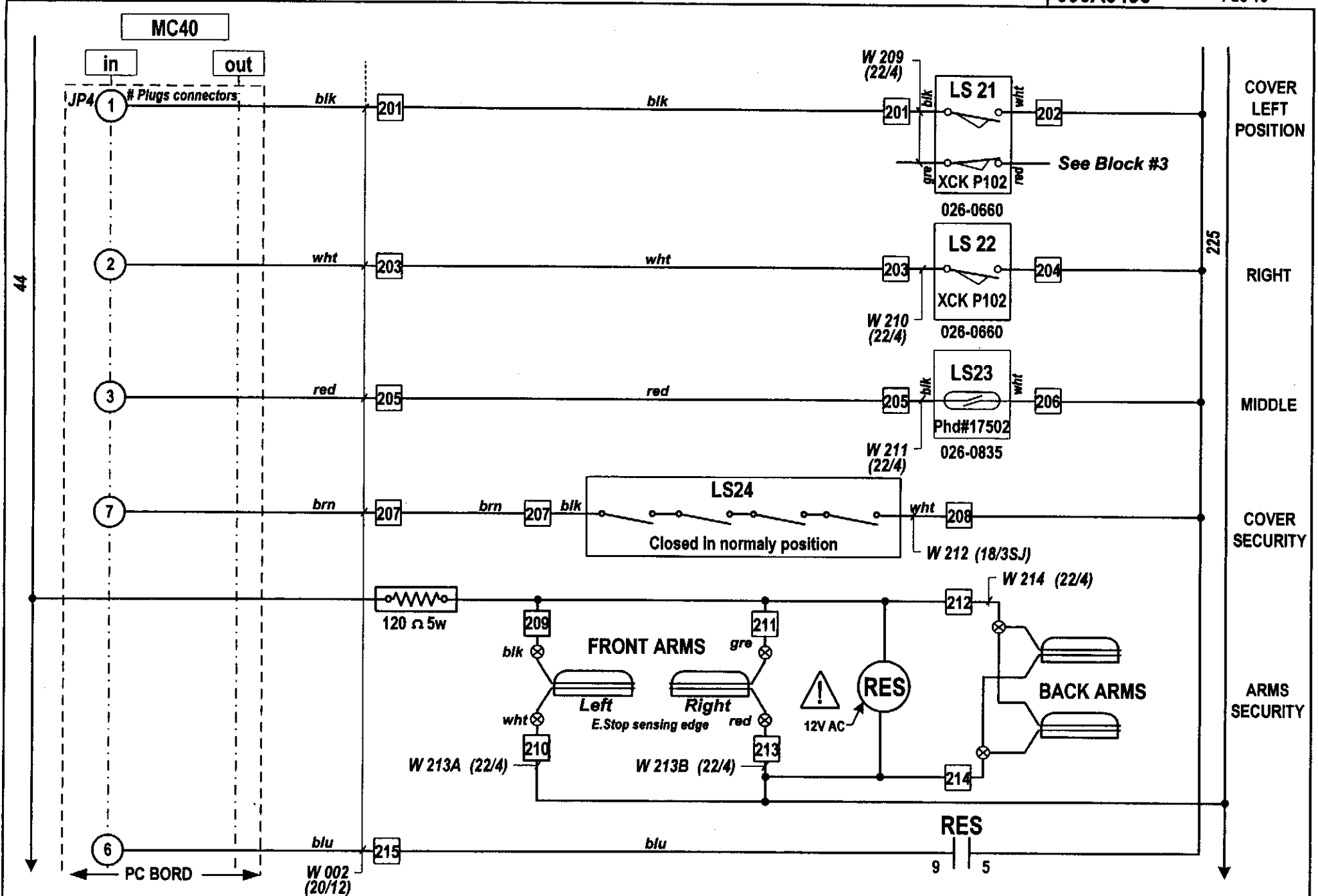
225 (20 yel)



RC filters must be connect on each coil AC (not show on diagram)

category	VACUUM PACK		model	700A & 680A		volt.	24V 60Hz		SIPROMAC St-Germain de Grantham QUEBEC, CANADA				
system	CONTROL SUPPLIES					circuit	control						
usual functions						year	02	month	08	day	06	block	1
options						concept	GM	draw	Y.C	app	XX	006A0495 PAGE 3 de 10	

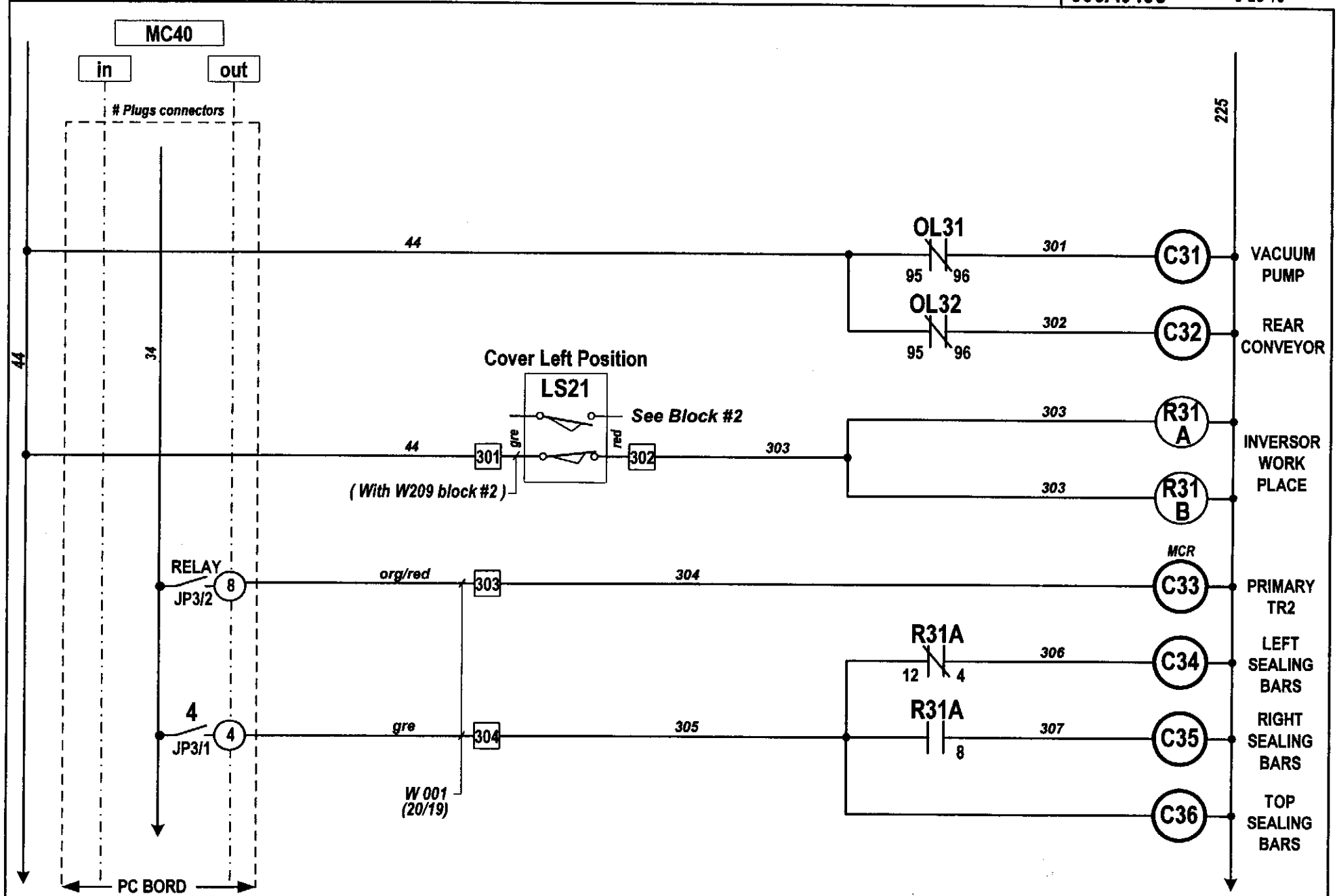




- The left or right sides are base on operator position facing the control panel  
 - RC filters must be connect on each coil AC (not show on diagram)



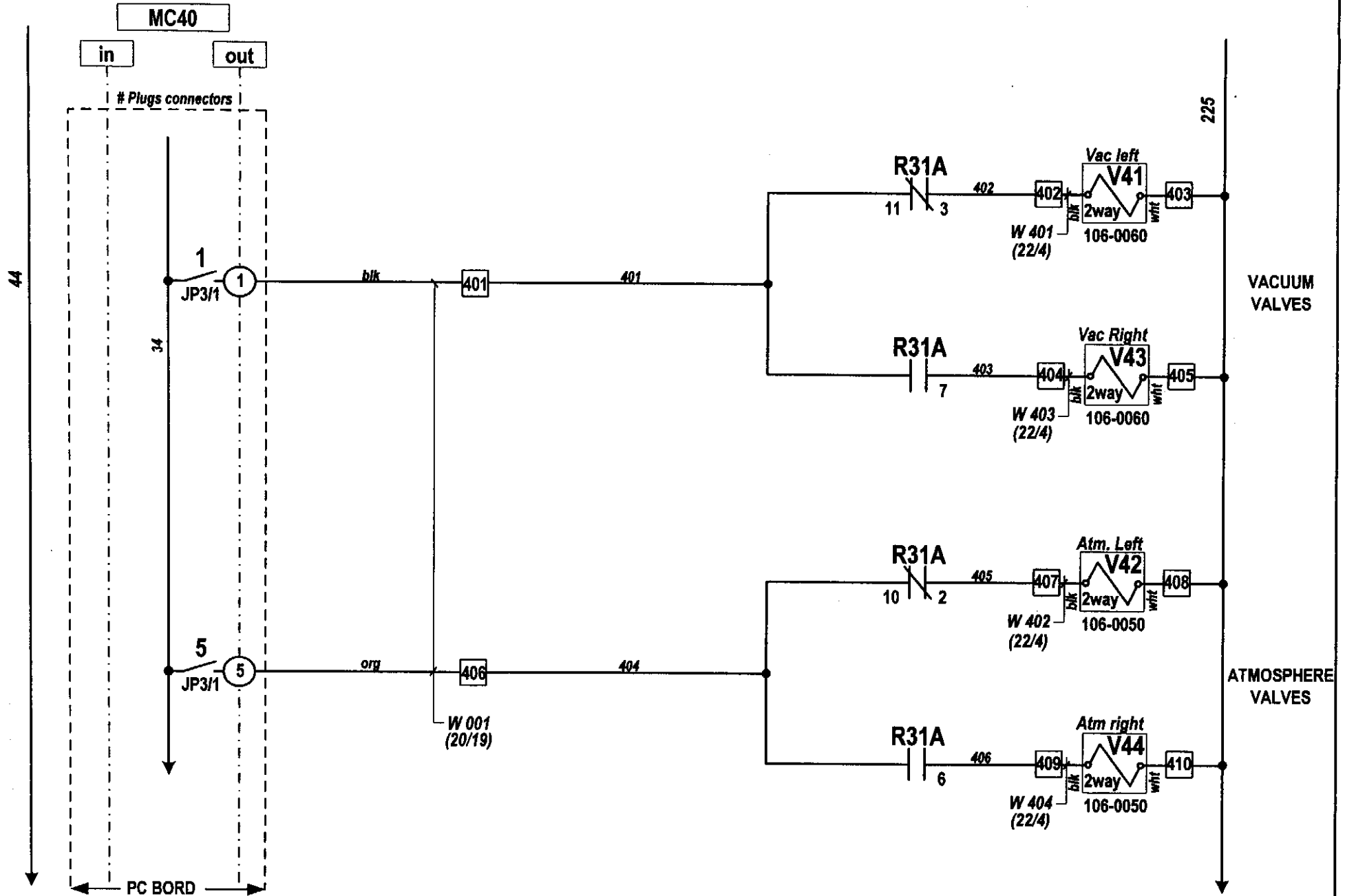
category	<b>VACUUM PACK</b>	model	<b>700A &amp; 680A</b>	volt.	<b>24V 60Hz</b>				<b>SIPROMAC</b> St-Germain de Grantham QUEBEC, CANADA
system	<b>SECURITY</b>			circuit	<b>Control</b>			year month day block	
usual functions options							year month day block <b>02 07 10 2</b>	<b>006A0495</b> PAGE 4 de 10	
				concept	draw	app	concept draw app <b>GM Y.C XX</b>		



- The left or right sides are base on operator position facing the control panel  
 - RC filters must be connect on each coil AC (not show on diagram)



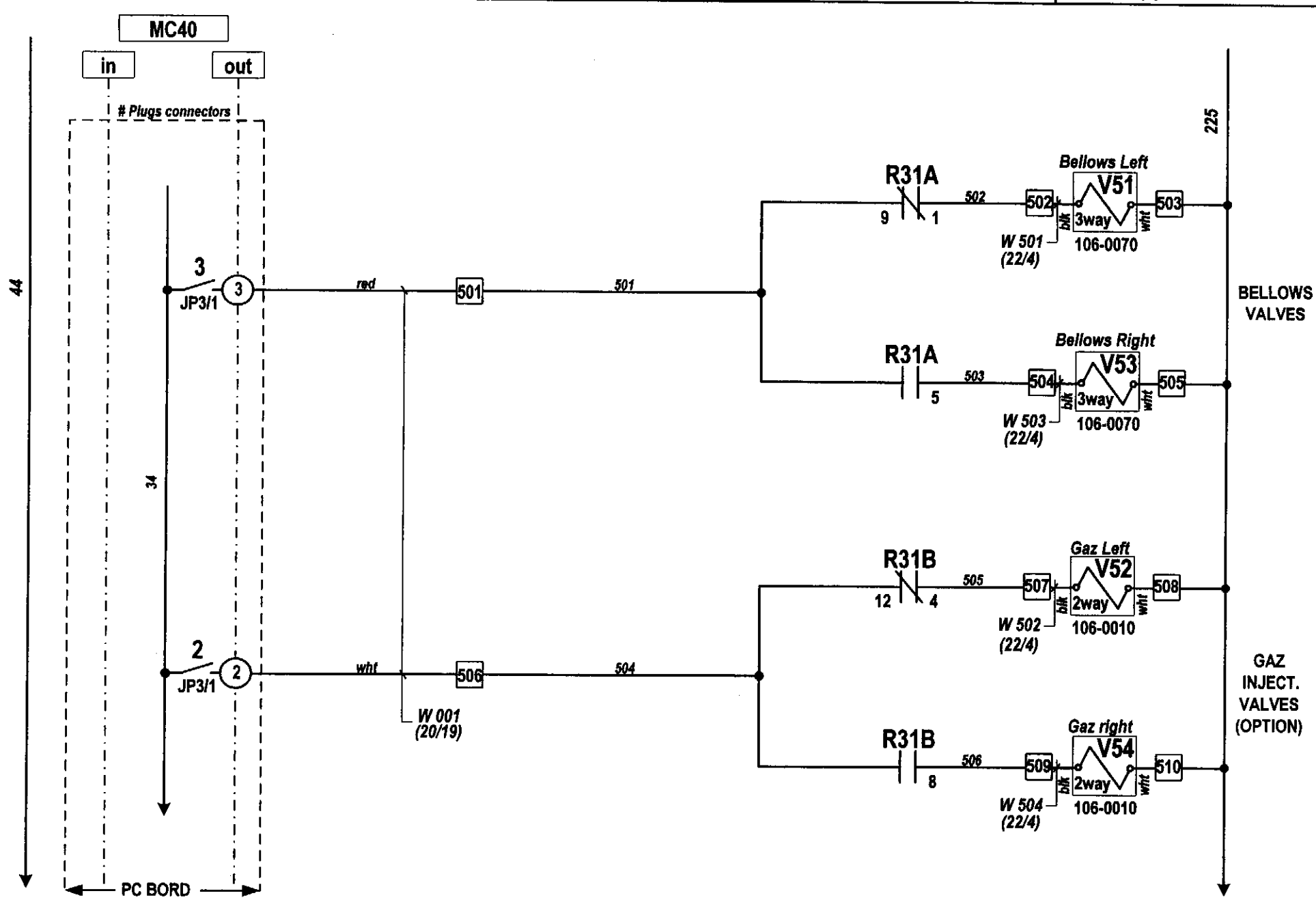
category	VACUUM PACK	model	700A & 680A	volt.	24V 60Hz				SIPROMAC St-Germain de Grantham QUEBEC, CANADA
system	POWER COMMAND			circuit	Control	year	month	day	
usual fonctions options						02	07	11	3
						concept	draw	app	006A0495 PAGE 5 de 10
						GM	Y.C	XX	



- The left or right sides are base on operator position facing the control panel  
 - RC filters must be connect on each coil AC (not show on diagram)



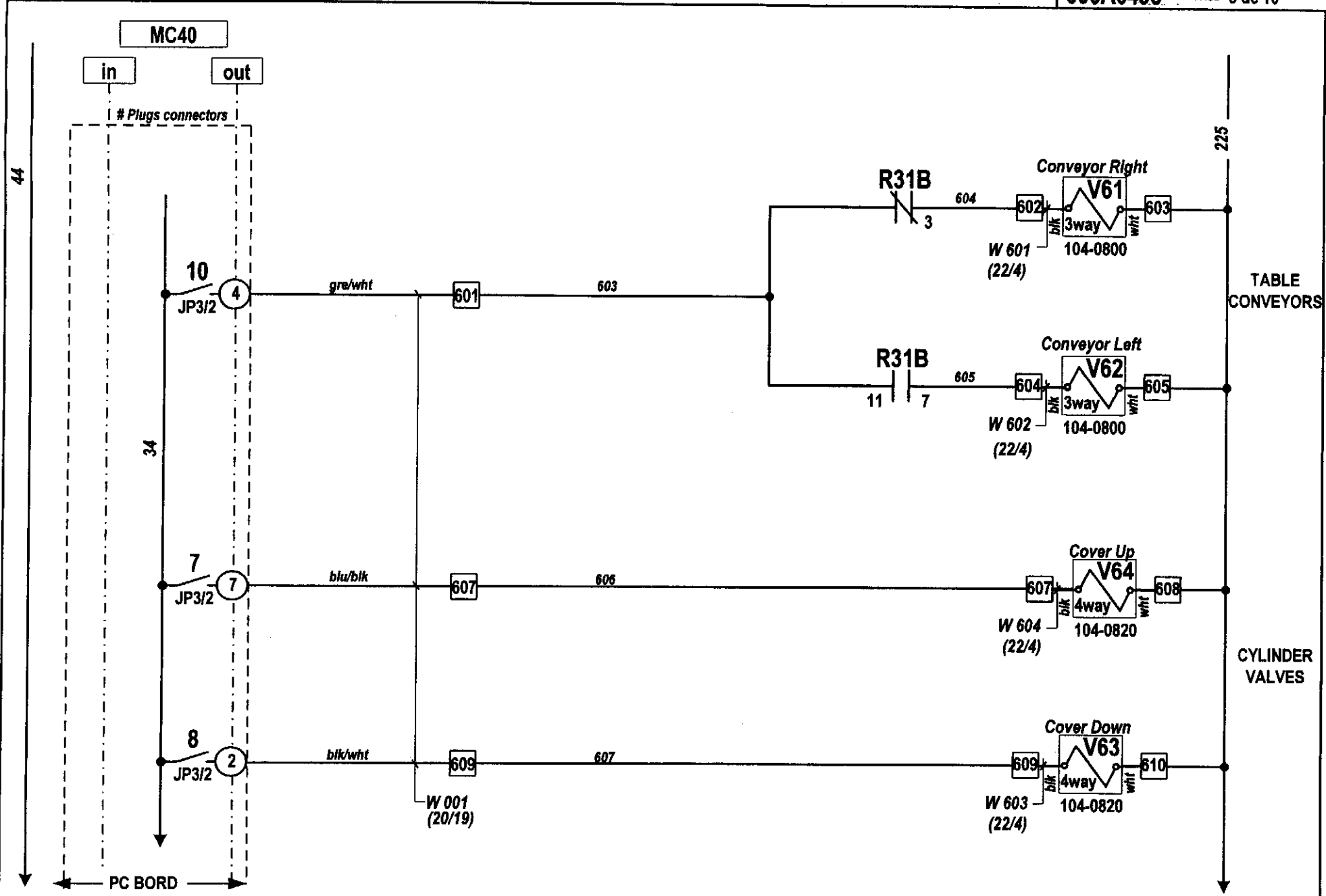
category	VACUUM PACK	model	700A & 680A	volt.	24V 60Hz			
system	VACUUM AND ATMOSPHERE			circuit	Control	year	month	day
usual fonctions						02	07	11
options								4
						concept	draw	app
						GM	Y.C	XX
						006A0495 PAGE 6 de 10		
						SIPROMAC St-Germain de Grantham QUEBEC, CANADA		



- The left or right sides are base on operator position facing the control panel  
 - RC filters must be connect on each coil AC (not show on diagram)



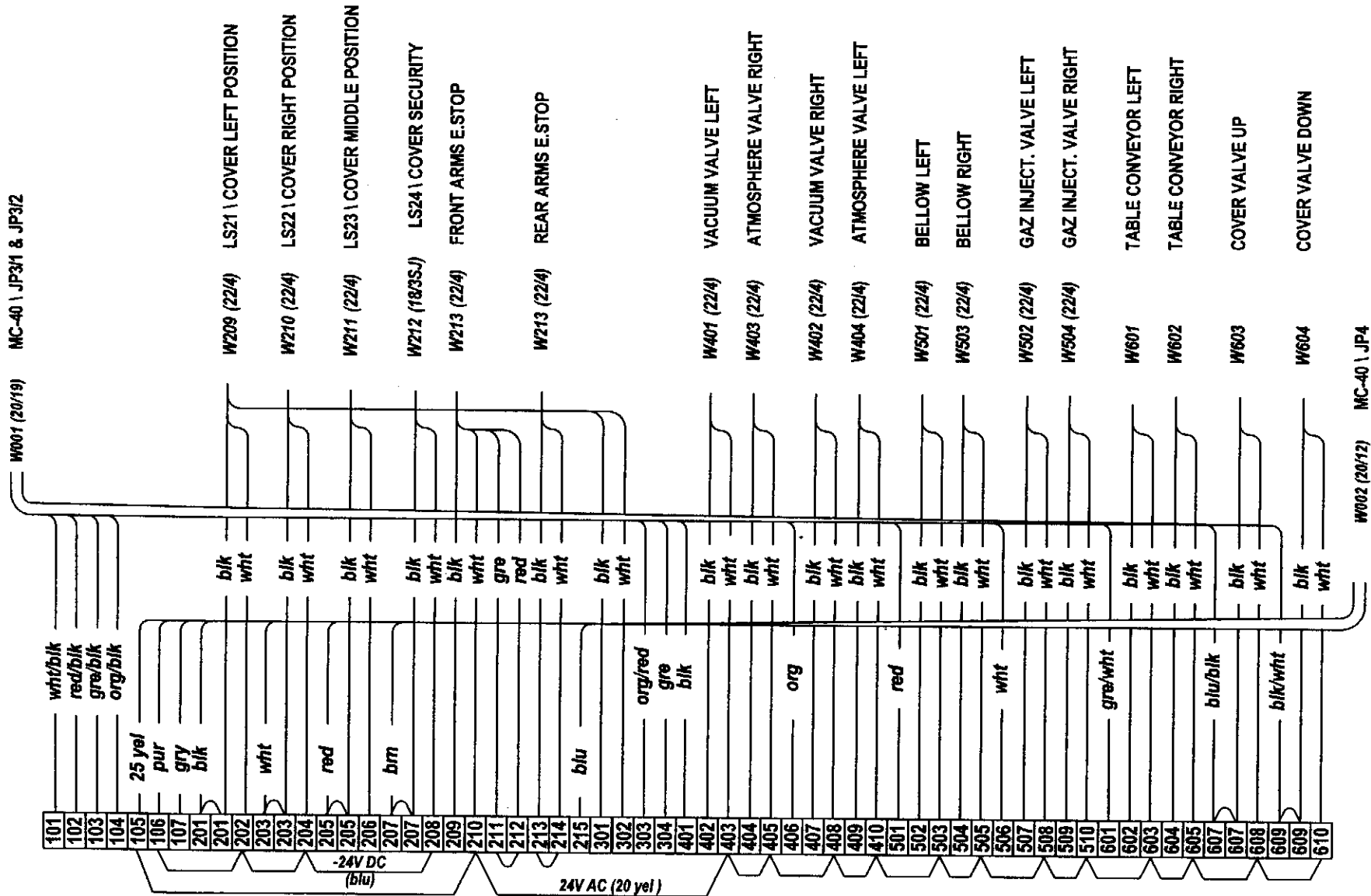
category	VACUUM PACK	model	700A & 680A	vol.	24V 60Hz			
system	BELLOWS			circuit	Control			
usual fonctions				year	month	day	block	SIPROMAC St-Germain de Grantham QUEBEC, CANADA
options	Gaz injection			02	07	11	5	
	concept	draw	app	006A0495				PAGE 7 de 10
	GM	Y.C	XX					



- The left or right sides are base on operator position facing the control panel  
 - RC filters must be connect on each coil AC (not show on diagram)



category	VACUUM PACK	model	700A & 680A	volt.	24V 60Hz
system	COVER MOUVEMENT			circuit	Control
usual functions				year	02 08 12
options				month	08
				day	12
				block	6
				concept	GM
				draw	Y.C
				app	XX
				006A0495 PAGE 8 de 10	
<b>SIPROMAC</b> St-Germain de Grantham QUEBEC, CANADA					



MC-40 \ JP3/1 & JP3/2

W001 (20/19)

W209 (22/4) LS21 \ COVER LEFT POSITION

W210 (22/4) LS22 \ COVER RIGHT POSITION

W211 (22/4) LS23 \ COVER MIDDLE POSITION

W212 (18/3S-J) LS24 \ COVER SECURITY

W213 (22/4) FRONT ARMS E.STOP

W213 (22/4) REAR ARMS E.STOP

W401 (22/4) VACUUM VALVE LEFT

W403 (22/4) ATMOSPHERE VALVE RIGHT

W402 (22/4) VACUUM VALVE RIGHT

W404 (22/4) ATMOSPHERE VALVE LEFT

W501 (22/4) BELLOW LEFT

W503 (22/4) BELLOW RIGHT

W502 (22/4) GAZ INJECT. VALVE LEFT

W504 (22/4) GAZ INJECT. VALVE RIGHT

W601 TABLE CONVEYOR LEFT

W602 TABLE CONVEYOR RIGHT

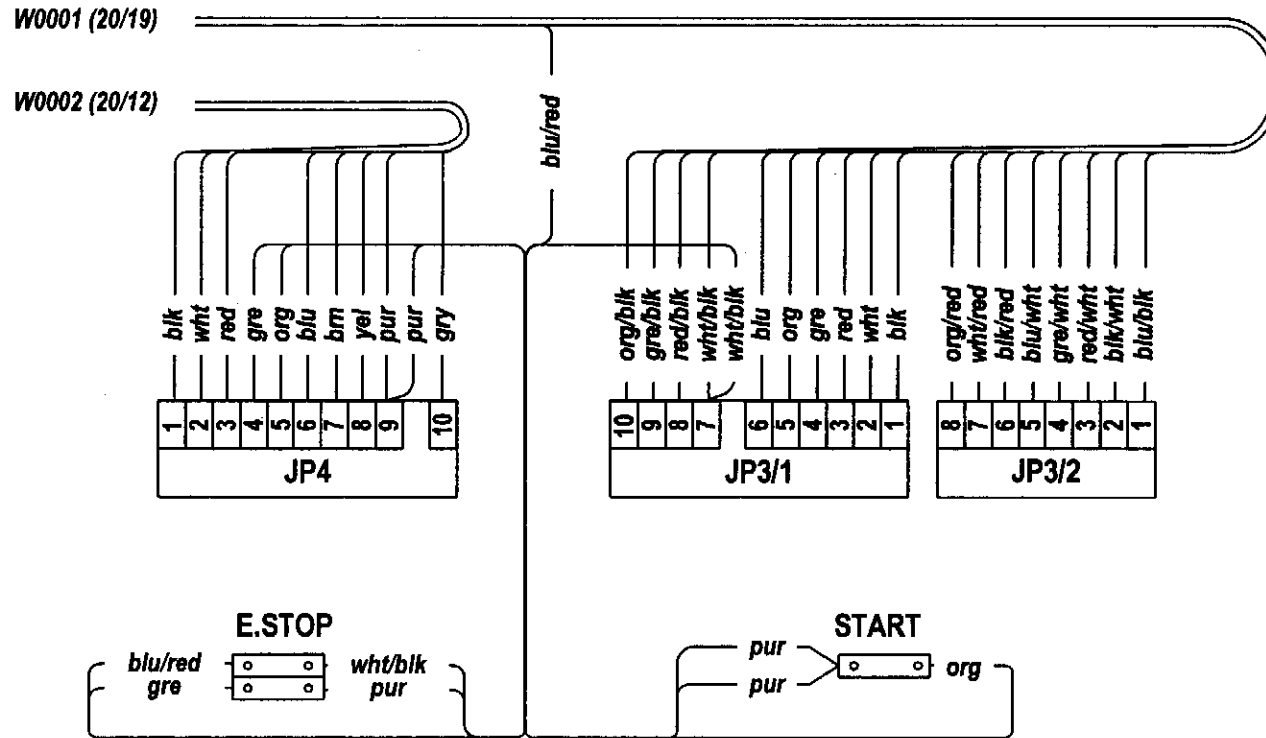
W603 COVER VALVE UP

W604 COVER VALVE DOWN

W002 (20/12) MC-40 \ JP4

- The left or right sides are base on operator position facing the control panel

category	<b>VACUUM PACK</b>		model	<b>700A &amp; 680A</b>		vol.					
system	<b>PLAN DE CABLAGE BORNIER</b>					circuit	<b>control</b>				
usual fonctions options			year	02	month	08	day	06	block		
			concept	GM	draw	Y.C	app	XX	<b>006A0495</b> PAGE 9 de 10		
									<b>SIPROMAC</b> St-Germain de Grantham QUEBEC, CANADA		



category	VACUUM PACK	model	700A & 680A	volt.	
system	PLAN DE CABLAGE P.C. BOARD			circuit	control
usual functions		year	02	month	08
options		day	06	block	
	concept	draw	app	006A0495	
	GM	Y.C	XX	PAGE 10 de 10	
<b>SIPROMAC</b> St-Germain de Grantham QUEBEC, CANADA					

