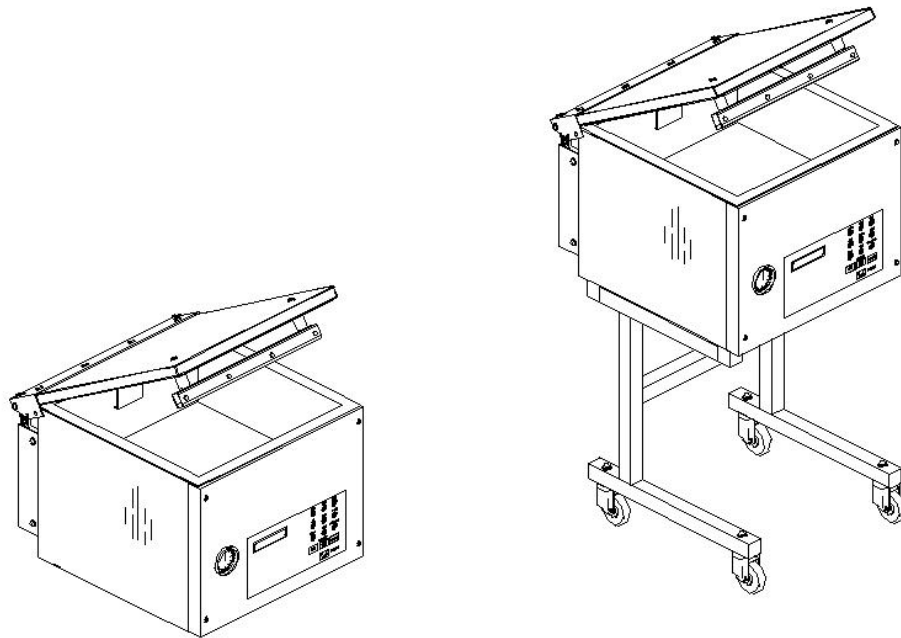


VACUUM PACKAGING MACHINE

MODELS 350 & 350D



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

IMPORTANT SAFETY INSTRUCTIONS

SAVE THESE INSTRUCTIONS



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

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

General Operation

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

- Never incline the machine more than 30 degrees, it may tip over and hurt someone seriously.
- Work only in daylight or good artificial light.
- Do not operate any appliance with a damaged cord or plug, or after the appliance malfunctions or is dropped or damaged in any manner. Return appliance to the nearest authorized service facility for examination, repair, or electrical or mechanical adjustment.

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

Service

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

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



Warning-Your responsibility:

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

INSTALLATION NOTICE FOR MODELS:

350, 350D

IN ORDER TO RESPECT NSF REGULATIONS:

The table, on which the machine has to be installed, should be of open frame type, to avoid dirt accumulation, and to allow easy cleaning under the machine.

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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.

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

Normal operating temperature for the 350/350D is 4°C to 32°C (39°F to 90°F). Vacuum pump is filled with synthetic oil that can be used in that range of temperature.

2. Electrical connection

Electrical connections must be made by qualified personnel. This person must make sure that the electrical entries correspond to the proper voltage and amperage of the machine. **GROUNDING INSTRUCTIONS:** This appliance must be grounded. In the event of malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This appliance is equipped with a cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

DANGER Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal. Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if in doubt as to whether the appliance is properly grounded. Do not modify the plug provided with the appliance if it will not fit the outlet; have a proper outlet installed by a qualified electrician.

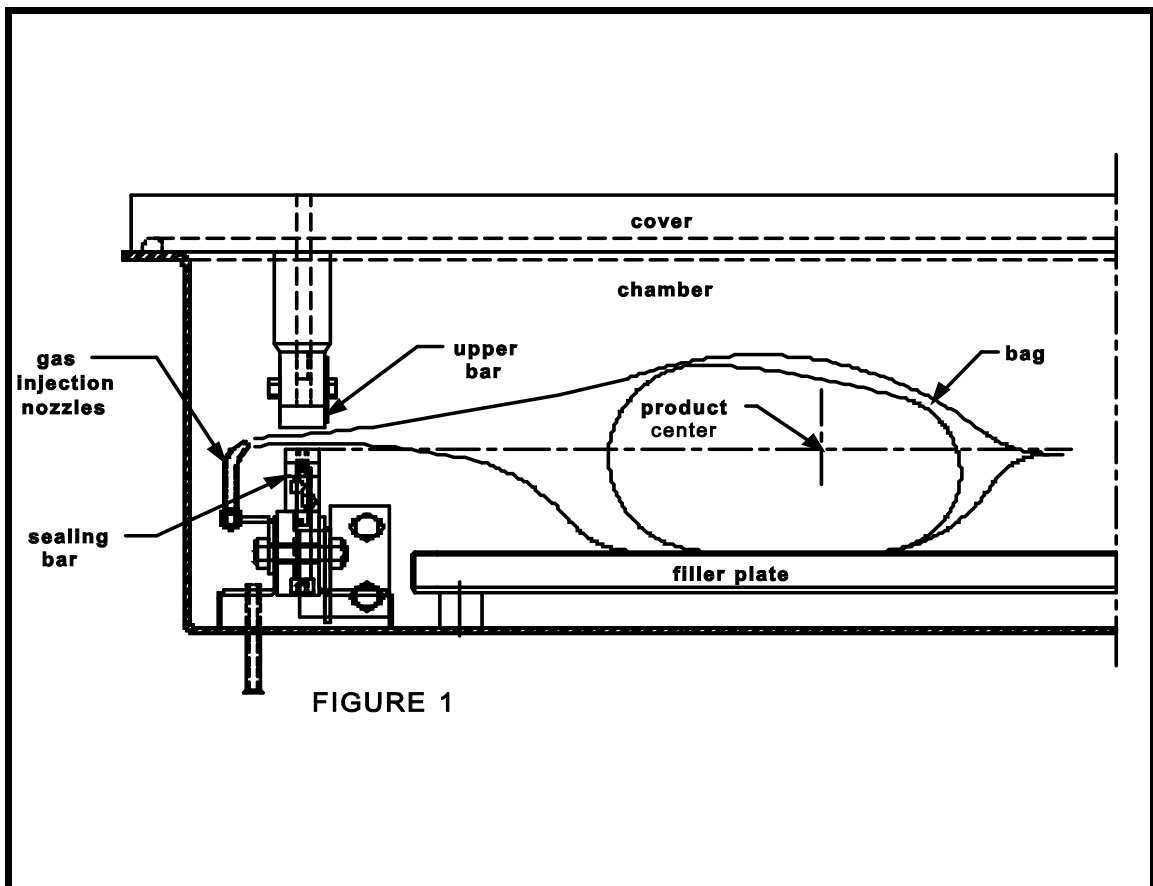
3. Operation

a. 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, gas flushing extended product shelf life and also act as a cushion for delicate product. 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 5 cm (2") past the seal bars. The product should be centered in height in relation to the seal bar by adjusting the spacers provided (see figure 1).

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



b. Gas flushing (option)

There is an atmospheric pressure of 1 kg/cm^2 (14 PSI) upon products when fully evacuated. Products which can be damaged by high pressure must be packaged with a partial vacuum, or the pressure must be counterbalance by inflating the bag with neutral gas.

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

The necessary gas tank and pressure regulator mounted on tank is not supplied, The pressure of the gas regulator should be set at approximately $1/3 \text{ kg/cm}^2$ (5 PSI). Each machine has an adaptor for gas connection when gas flush option is ordered.

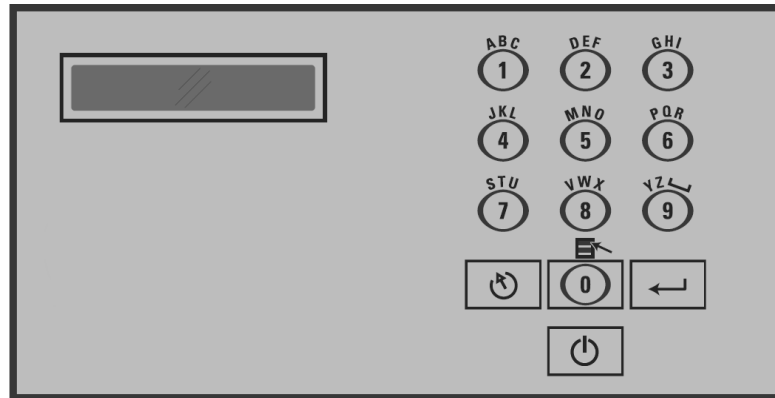
c. Electrical bag cut (option)

This option is used to obtain a package that the excess bagtail is cut off close to the seal.


d. Pressure regulator (option)


This option is used to obtain more sealing pressure between the sealing bar jaw. Suggested option for low vacuum level packaging or high level gas flushing. Also recommended for hard to seal laminated bags. Each machine has an adaptor for compressed air connection when pressure regulator option is ordered. Recommend pressure regulator adjustment is 1 kg/cm^2 (14 PSI), maximum setting 1.3 kg/cm^2 (20 PSI),



4. Control



a. Basic

Use power key  to power the vacuum packaging machine. When the unit is energized, the identification of the last executed program is displayed on LCD screen. To disconnect, use the power key to turn off the machine, then remove plug from outlet. Do not unplug by pulling on cord. To unplug, grasp the plug, not the cord. Unplug from outlet when not in use and before servicing or cleaning.

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 select key  to select a function and enter key  to accede and executed the selection.

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

In programs submenu, use enter key 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 esc key  to get back to the programs menu. Strike any key to clear the error messages which may be displayed on LCD screen. Menu Structure can be found in section 4.H.

Create a program:



When executing the "create a program" function, the program submenu is accessed, 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.


Delete a program:

When executing the "delete a program" function, the programs menu is accessed and the number of the first program in memory is blinking to point out the deletion

mode. Use select key  to select a program and enter key  to accede and confirm deletion of the selection. Use esc key  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.


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 enter key  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 esc key  to come backward and erase one or several characters.

For example, to use a 'E' characters, press number 2 two times and use the enter key  to confirm.



b. 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). In the middle of an acquisition, use enter key  to validate the vacuum level and key "ESC" to come backward and start over with a new acquisition. Set vacuum level to zero to bypass the pressure transducer and proceed only using the vacuum plus time.

A vacuum set point over 99.5% is not recommended. Hot products or very humid product may require a lower set point.



c. Vacuum plus 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 enter key  to validate the vacuum plus time and use esc key  to come backward and start over with a new acquisition.

d. 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. Maximum recommended gas flushing level is 80%, compressed air regulator option is recommended at this gas flushing level.


e. Sealing time setting

For a selected program set the sealing, 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). In a middle of an acquisition, use enter key  to validate the sealing time and use esc key  to come backward and start over with a new acquisition (the old sealing time is blinking).

f. Packaging cycle






Chose a program (see basic section) and place the bags on the sealing bar, close the cover to initiate a vacuum cycle. During cycle execution the operation status is sequentially displayed on LCD screen, except for the parameters established to zero, which are not displayed:

- Vacuum status % during vacuum sequence
- Vacuum plus time (seconds)
- Gas status % during gas flush sequence
- Sealing time status during sealing sequence (seconds)
- ATM message during venting sequence

During cycle execution, use key "1" to abort the vacuum sequence and execute the following sequence, which is gas flush or sealing, use enter key  to accede and modify the program; the parameters become valid only for the following vacuum cycles.

g. System monitor and diagnostic menu

To access the diagnostics menu, power up the vacuum packaging machine

 while keeping pushed in esc key . Use select key  to select the system monitor function and enter key  to access and visualize the monitored parameters. A password is required for some menus, contact your service center for support. Use select key  to change over from the software revision, the amount of working hours done and the amount of complete cycles performed since first initialization. See menu structure next.

h. Menus structure

- **Functions menu:**

"F1 CREATE A PRGM"

"F2 DELETE A PRGM"

- **Programs menu:**

"Pxx NAME"

Program submenu:

"VACUUM: xx.x%" (10.0% - 99.5%)

"VACUUM PLUS: xxs" (0s - 99s)

"GAS FLUSH: xx.x%" (0.0% - 10% below the vacuum level) (units with gas option)

"SEAL TIME: x.xxs" (0.00s - maximum unit allocated setting)

"Pxx NAME" (12 characters)

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

"DIAGNOSTICS MENU" (access code required)

"D1 INPUTS TEST" Show the input status

"D2 OUTPUTS TEST" Test the output of the card

"D3 MODEL SELECT" Select the model of the machine

"D4 GAS OPTION" Enable or disable the gaz option

"D5 SEALING TIME" Set the maximum sealing time

"D6 COOLING TIME" Set the cooling time

"D7 OFFSET CALIB" Show the current vacuum calibration

"D8 VACUUM SENSOR" Enable or disable vacuum sensor

"D9 ACCESS CODE" *Enable or disable the access code to modify the programs*

"D10 CODE CHANGE" *Modify the program access code*

"D11 PUB" *Enable or disable the screen saver message*

"D12 SELECT PUB" *Factory use*

"D13 VACUUM CALIB" *Automated calibration sequence*

"SYSTEM MONITOR" (no access code required)

"SOFTWARE: R x.xx" *Show the software version*

"WORK HRS: xxxxx" *Show the number of operating hours*

"CYCLES: xxxxxxx" *Show the total number of cycles*

S: XXX.X T: XXX.X *Show the set point and the current temperature for the heating option*

5. 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. The 350/350D is made to be clean by hand with a damp cloth, no water can be apply directly on the machine.

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



WARNING: All electrical work described in this brochure should be done by a QUALIFIED and AUTHORIZED technician.

6. Troubleshooting

a. Failure during packaging cycle

COVER DOWN ERROR” message is display on LCD. The input signal of the down position switch has been lost during cycle execution. Check limit switch adjustment.

b. Insufficient vacuum

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. Use bone-guard or thicker film for pin-hole leak caused by sharp edge of the product (bone, etc.). Tear in bag by careless handling can also be the source of the problem (sharp edge on filling table, damage made by retailer or customer).

If no leak in the bag can be found, make sure you use a bag of the appropriate size. Vacuum setting may also be too low. Check vacuum sensor with a remote vacuum sensor. Sealing bar can also be jammed or sealing valve is not working properly, see with service center. Vacuum pump may also need a check-up.

c. Faulty seal

Insufficient seal problem can be related to damaged Teflon or silicone rubber. Can also be from a low sealing pressure, a leaking bellow or the sealing bar are jammed. If there is no seal at all, the sealing wire may be or one of the electrical component is not working properly (wire, sealing transformer, contactor. If the sealing bar have a permanent current, check the contactor. In a case of non-sticking seal, check bag quality (insufficient layer of poly PE). Seal area have to be clean of contamination like juice and fat. In that case, use filling accessory.

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

d. Faulty valve

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. If the 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 (needs to be serviced).

e. Control board failure

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 Keynesian 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.

7. Maintenance

Routine controls must be made a qualified technician, contact your local service center.

Routine controls list:

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). Follow Busch maintenance schedule.

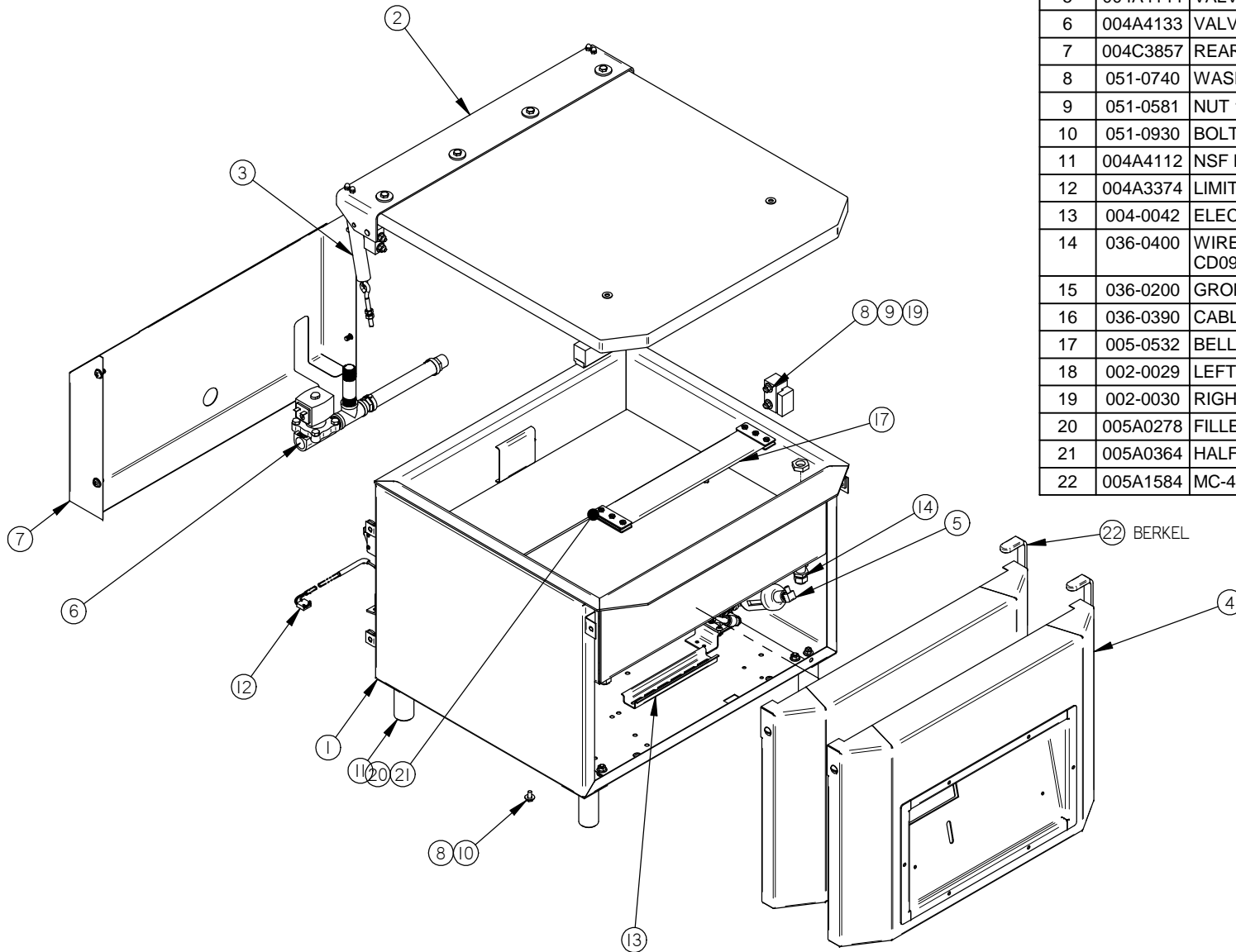
Check vacuum in chamber with precision vacuumeter.

Check desiccant filter for proper color, change if necessary.

Check function of cycle with various settings of timers. 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.

004A4142

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|---|-----|
| 1 | 004B0229 | VACUUM PRE-ASSEMBLY | 1 |
| 2 | 005B0266 | COVER ASSEMBLY | 1 |
| 3 | 004A1224 | SPRING PRE-ASSEMBLY | 2 |
| 4 | 005E0832 | MC-40 FRONT PANEL ASSEMBLY | 1 |
| 5 | 004A4144 | VALVE ASSEMBLY VACCUM SENSOR | 1 |
| 6 | 004A4133 | VALVE ASSEMBLY PUMP | 1 |
| 7 | 004C3857 | REAR PANNEL PRE-ASS'Y | 1 |
| 8 | 051-0740 | WASHER 1/4" FLAT S/S | 8 |
| 9 | 051-0581 | NUT 1/4"-20 NYLON LOCK S/S | 4 |
| 10 | 051-0930 | BOLT M6 x 10 S/S | 4 |
| 11 | 004A4112 | NSF FOOT | 4 |
| 12 | 004A3374 | LIMIT SWITCH ASS'Y | 1 |
| 13 | 004-0042 | ELEC. SUPPORT PRE-ASS'Y | 1 |
| 14 | 036-0400 | WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT | 2 |
| 15 | 036-0200 | GROMMET 5/8"IDx1 1/8"OD RUBBER | 1 |
| 16 | 036-0390 | CABLE CONNECT.3/8"-1/2"METAL | 1 |
| 17 | 005-0532 | BELLOWS ASSEMBLY | 1 |
| 18 | 002-0029 | LEFT SEAL BAR GUIDE BLOCK | 1 |
| 19 | 002-0030 | RIGHT SEAL BAR GUIDE BLOCK | 1 |
| 20 | 005A0278 | FILLER PLATE ASS'Y | 1 |
| 21 | 005A0364 | HALF FILLER PLATE ASS'Y | 2 |
| 22 | 005A1584 | MC-40 FRONT PANEL ASSEMBLY (BERKEL) | 1 |

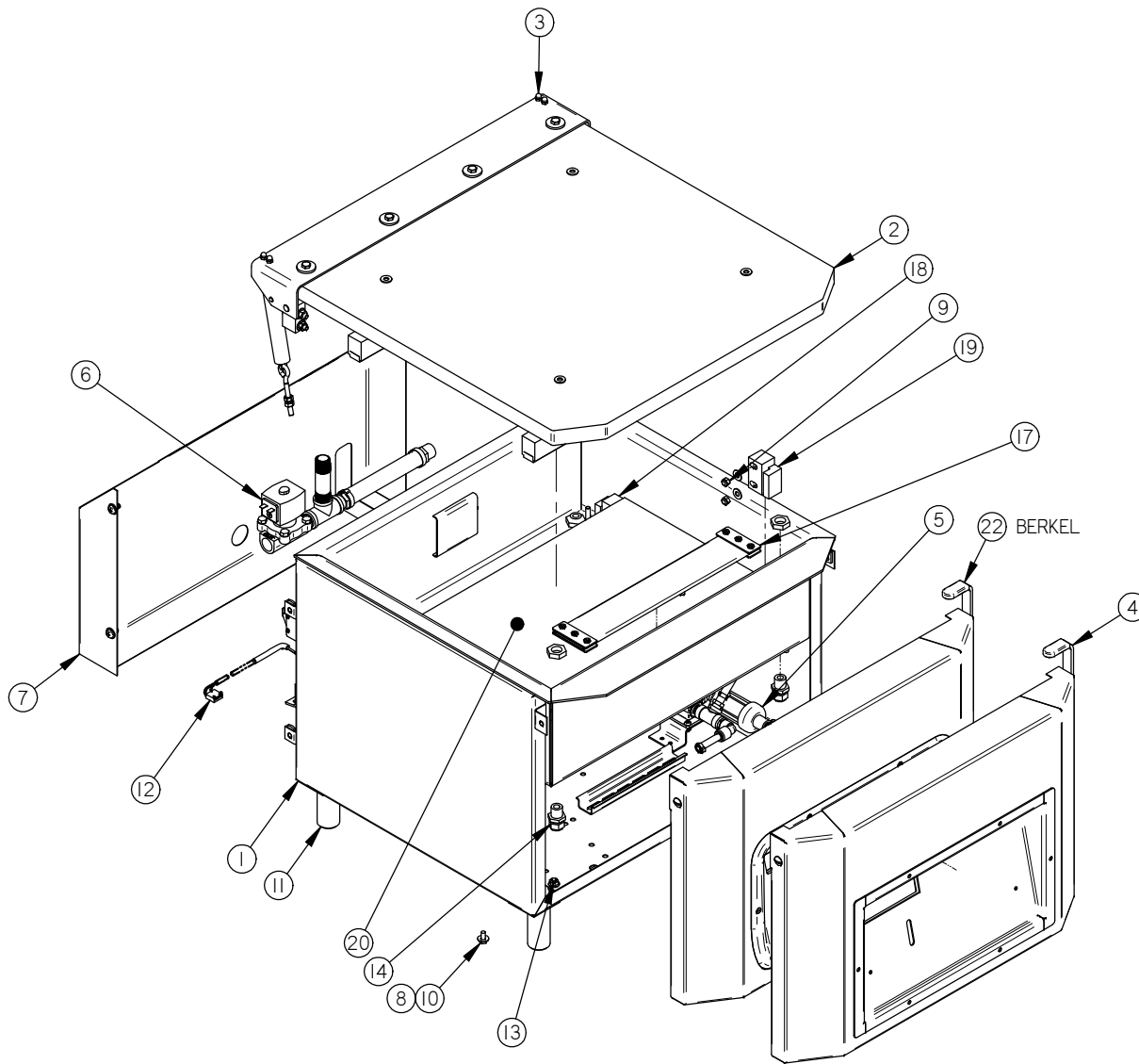


| | | | | | | |
|---------|-------------------------|----------------------|------------|--------|-----------------|---|
| MACHINE | 350 | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | MACHINE ASSEMBLY | | USINAGE | ± 0.1 | ± 0.004" | |
| | | | TOLERIE | ± 0.5 | ± 0.020" | |
| | | | SOUDEAGE | ± 0.5 | ± 0.020" | |
| ITEM | CNC | DEPT. | N.T.S. | | QTY. | 1 |
| MAT. | DWG BY S.L. | DATE 13-11-22 | | | 004A4142 | |
| | APP. BY | DATE | | | | |

| | | | |
|------|---------------------|----------|------|
| A | BERKEL OPTION ADDED | 15-02-24 | SBU |
| LET. | MODIFICATION | DATE | INT. |

004A4136

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|---|-----|
| 1 | 004B0230 | VACUUM PRE-ASSEMBLY | 1 |
| 2 | 005B0481 | COVER ASSEMBLY | 1 |
| 3 | 004A1224 | SPRING PRE-ASSEMBLY | 2 |
| 4 | 005E0832 | MC-40 FRONT PANEL ASSEMBLY | 1 |
| 5 | 004B4134 | VALVE ASSEMBLY VACCUM SENSOR | 1 |
| 6 | 004A4133 | VALVE ASSEMBLY PUMP | 1 |
| 7 | 004C3857 | REAR PANNEL PRE-ASS'Y | 1 |
| 8 | 051-0740 | WASHER 1/4" FLAT S/S | 12 |
| 9 | 051-0581 | NUT 1/4"-20 NYLON LOCK S/S | 8 |
| 10 | 051-0930 | BOLT M6 x 10 S/S | 4 |
| 11 | 004A4112 | NSF FOOT | 4 |
| 12 | 004A3374 | LIMIT SWITCH ASS'Y | 1 |
| 13 | 004-0042 | ELEC. SUPPORT PRE-ASS'Y | 1 |
| 14 | 036-0400 | WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT | 4 |
| 15 | 036-0200 | GROMMET 5/8"IDx1 1/8"OD RUBBER | 1 |
| 16 | 036-0390 | CABLE CONNECT.3/8"-1/2"METAL | 1 |
| 17 | 005-0532 | BELLOWS ASSEMBLY | 1 |
| 18 | 002-0029 | LEFT SEAL BAR GUIDE BLOCK | 2 |
| 19 | 002-0030 | RIGHT SEAL BAR GUIDE BLOCK | 2 |
| 20 | 005A0365 | FILLER PLATE ASS'Y | 2 |
| 21 | 036-0400 | WIRE CONNECTOR 3/8" NPT NUT | 2 |
| 22 | 005A1584 | MC-40 FRONT PANEL ASSEMBLY (BERKEL) | 1 |
| 23 | 001A0564 | VALVE SUPPORT | 1 |
| 24 | 051-0143 | SCREW 10-24 x 3/8" PAN PHIL S/S | 2 |
| 25 | 051-0571 | NUT #10-24 S/S | 2 |

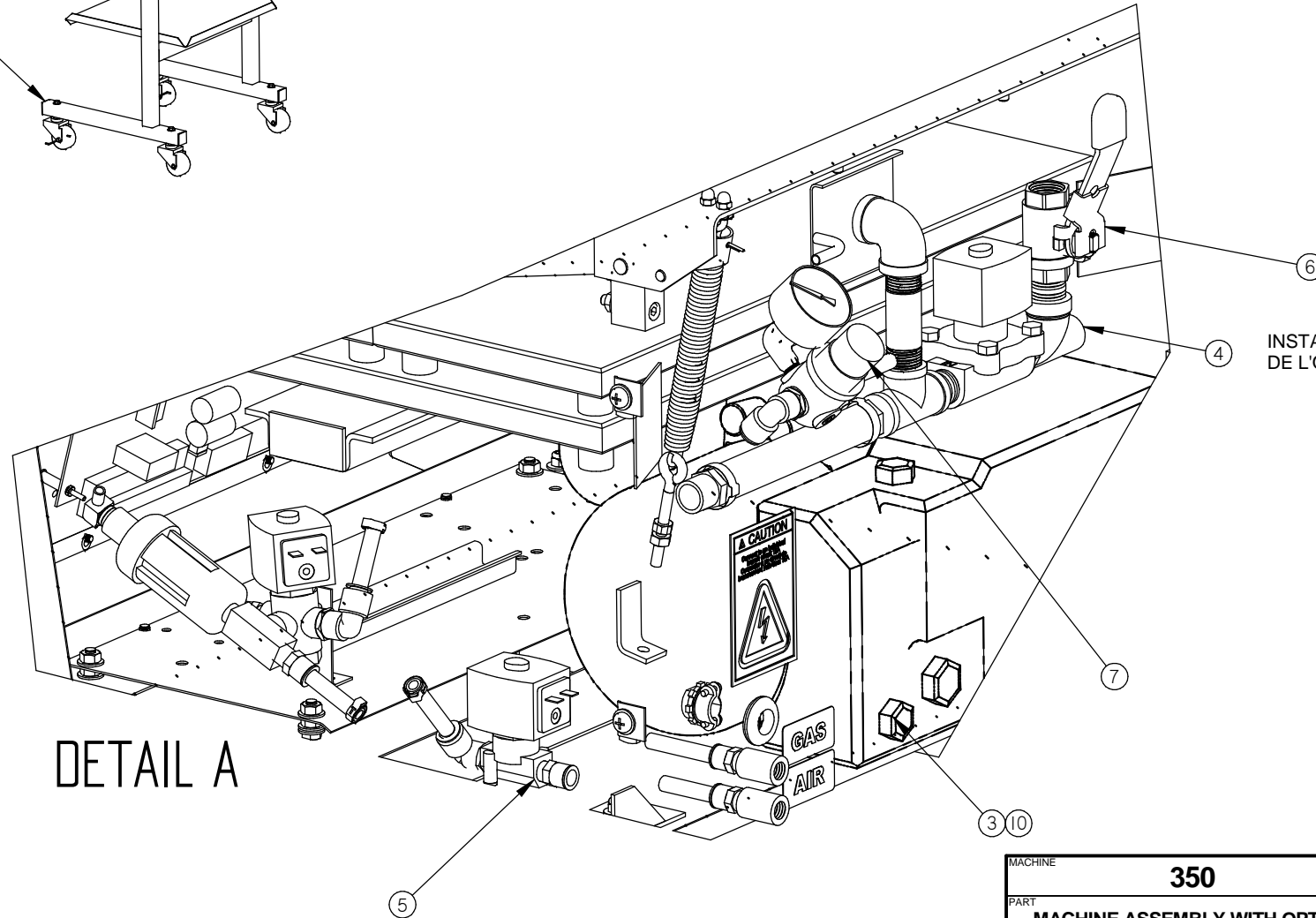
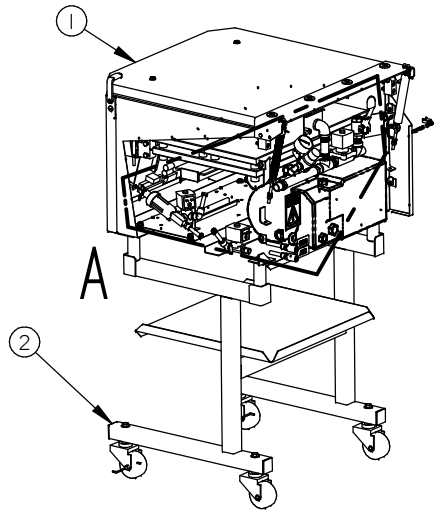


| | | | |
|------|---------------------|----------|------|
| A | BERKEL OPTION ADDED | 15-02-23 | SBU |
| LET. | MODIFICATION | DATE | INT. |

| | | | | | | | |
|---------|-------------------------|--|--|--------------------|----------------------|---------------------|---|
| MACHINE | 350D | | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | MACHINE ASSEMBLY | | | USINAGE | ± 0.1 | ± 0.004" | |
| ITEM | | | | TOLERIE | ± 0.5 | ± 0.020" | |
| MAT. | | | | SOUDEAGE | ± 0.5 | ± 0.020" | |
| | | | | N.T.S. | | | |
| | | | | CNC | | | DEPT. M QTY. 1 |
| | | | | DWG BY S.L. | DATE 13-11-22 | NO. 004A4136 | |
| | | | | APP. BY | DATE | | |

005C0610

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|-------------------------------------|-----|
| 1 | 004A4142 | MACHINE ASSEMBLY | 1 |
| 2 | 005B1031 | STAND ASSEMBLY 19" (OPTION) | 1 |
| 3 | 125-1021 | BUSCH KB-0020 220-240V/1PH/50-60HZ | 1 |
| 4 | 114-2009 | SILENCER 1/2 NPT TOPRING | 1 |
| 5 | 005A1424 | GAS OPTION | 1 |
| 6 | 005A1420 | SOFT AIR OPTION | 1 |
| 7 | 005A1421 | AIR OPTION | 1 |
| 8 | 005A1355 | SEAL BAR ASSEMBLY W/SUPP. TWIN SEAL | 1 |
| 9 | 005A1356 | SEAL BAR ASSEMBLY W/SUPP. BAG CUT | 1 |
| 10 | 125-1020 | BUSCH KB-0020 115V/1PH/60HZ | 1 |



INSTALLER SUR LA VALVE LORS DE L'OPTION SOFT AIR

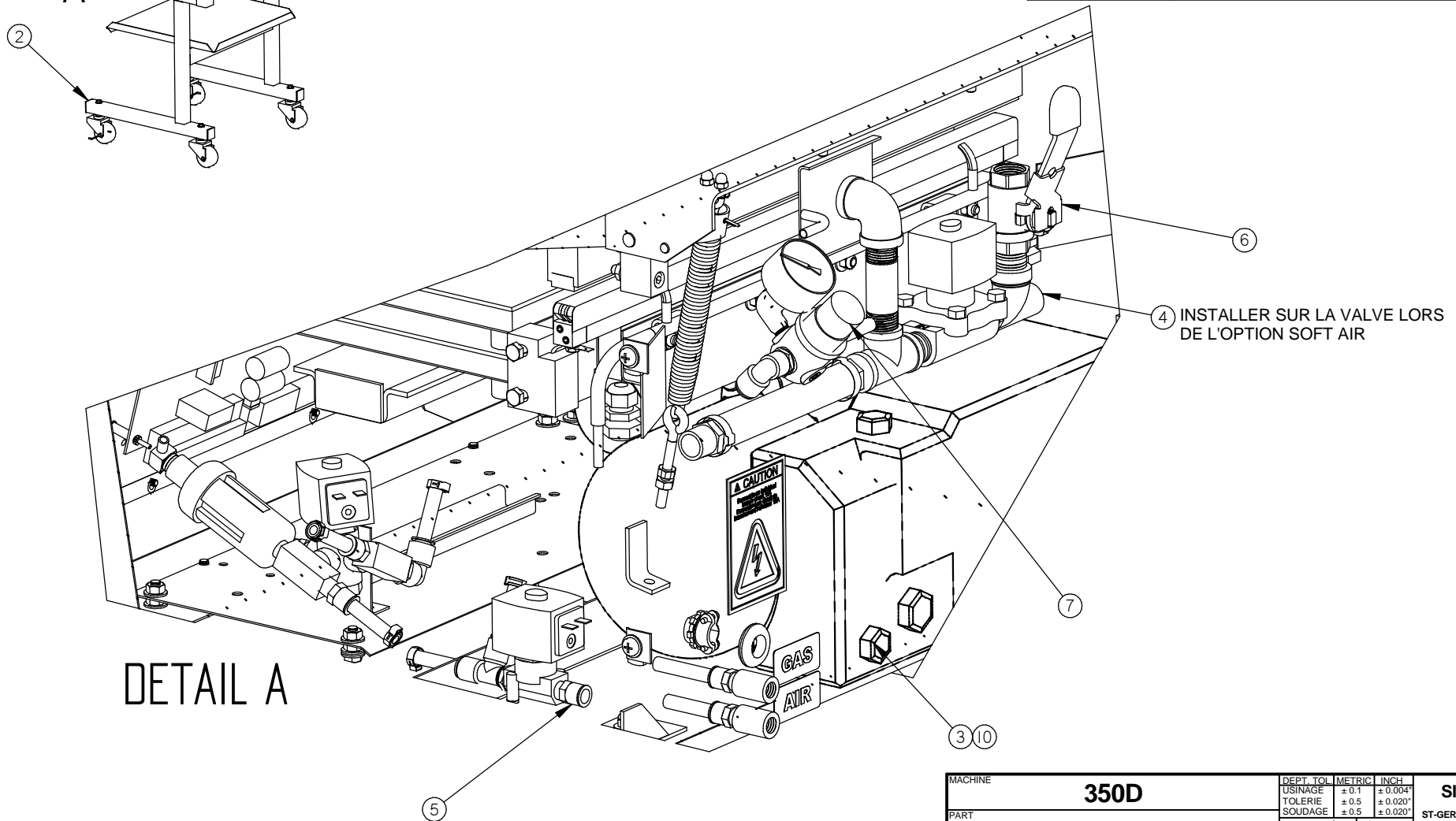
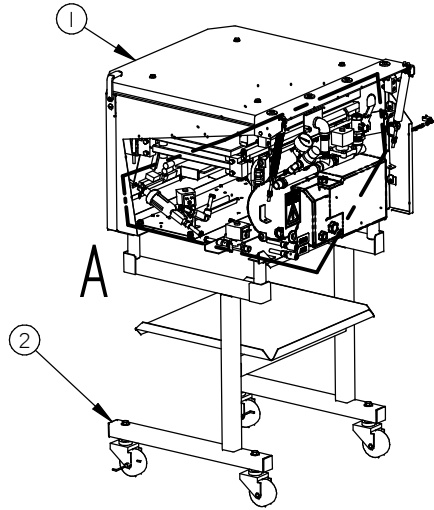
DETAIL A

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

| | | | | | | |
|---------|-------------------------------------|---------|----------|------------------------|------------------------|---|
| MACHINE | 350 | | | DEPT. TOL. METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | MACHINE ASSEMBLY WITH OPTION | | | USINAGE ± 0.1 ± 0.004" | TOLERIE ± 0.5 ± 0.020" | |
| ITEM | CNC | DATE | 13-11-22 | SOUDEGE ± 0.5 ± 0.020" | N.T.S. | |
| MAT. | DWG BY S.L. | APP. BY | DATE | DEPT. M-I | QTY. 1 | 005C0610 |

005B0611

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|------------------------------------|-----|
| 1 | 004A4136 | MACHINE ASSEMBLY | 1 |
| 2 | 005B1031 | STAND ASSEMBLY 19" (OPTION) | 1 |
| 3 | 125-1021 | BUSCH KB-0020 220-240V/1PH/50-60HZ | 1 |
| 4 | 114-2009 | SILENCER 1/2 NPT TOPRING | 1 |
| 5 | 005A1419 | GAS OPTION | 1 |
| 6 | 005A1420 | SOFT AIR OPTION | 1 |
| 7 | 005A1421 | AIR OPTION | 1 |
| 8 | 005A1422 | TWIN SEAL OPTION | 1 |
| 9 | 005A1423 | ECO SEAL BAR OPTION | 1 |
| 10 | 125-1020 | BUSCH KB-0020 115V/1PH/60HZ | 1 |

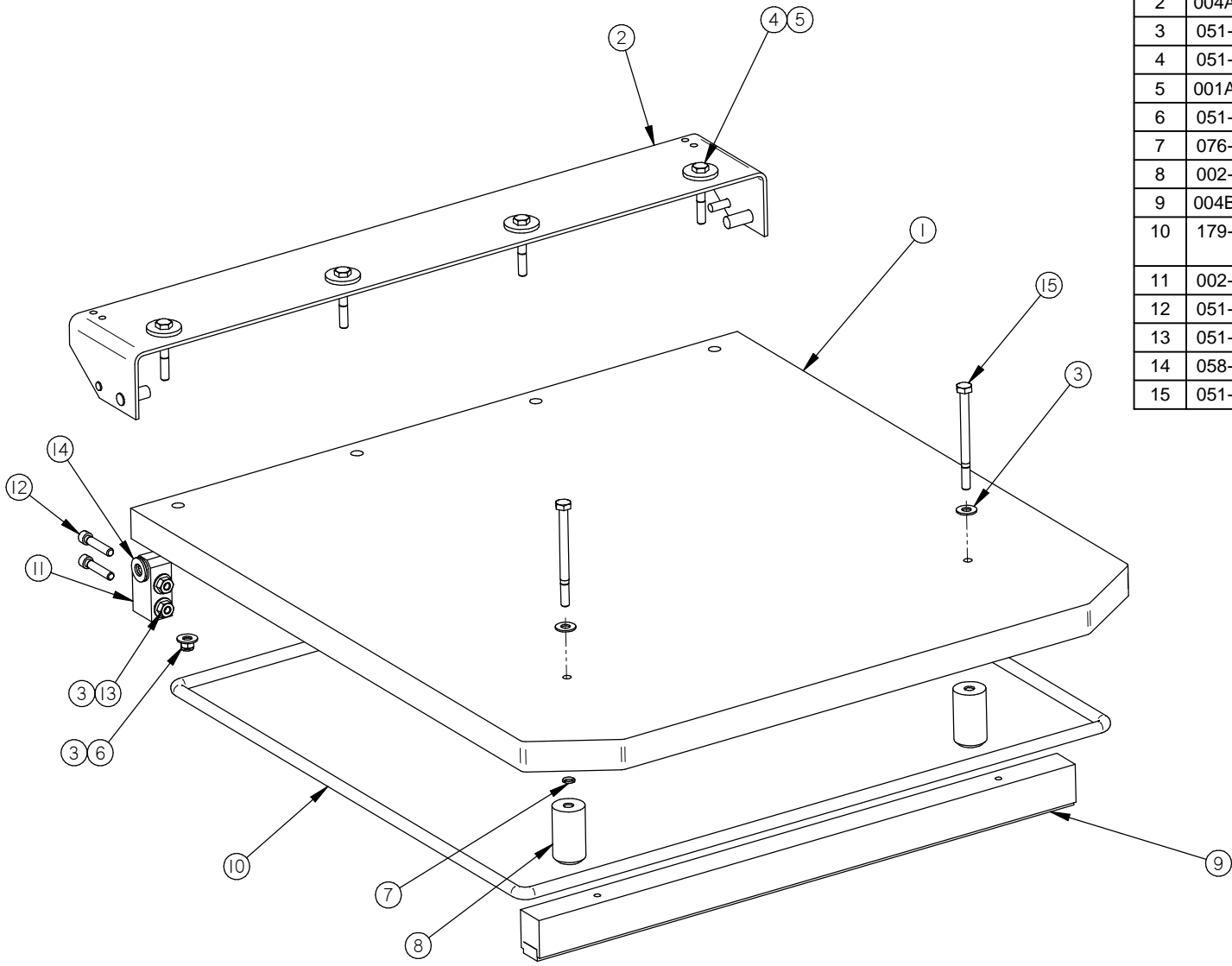


DETAIL A

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

| | | | | | | | |
|---------|--------------------|-------------------------------------|-----|-----------------|--------|----------|---|
| MACHINE | | 350D | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | | MACHINE ASSEMBLY WITH OPTION | | USINAGE | ± 0.1 | ± 0.004" | |
| | | | | TOLERIE | ± 0.5 | ± 0.020" | |
| | | | | SOUDEAGE | ± 0.5 | ± 0.020" | N.T.S. |
| ITEM | CNC | DEPT. | M-I | QTY. | 1 | | |
| MAT. | DWG BY S.L. | DATE 13-11-22 | NO. | 005B0611 | | | |
| | APP. BY | DATE | | | | | |

005B0266



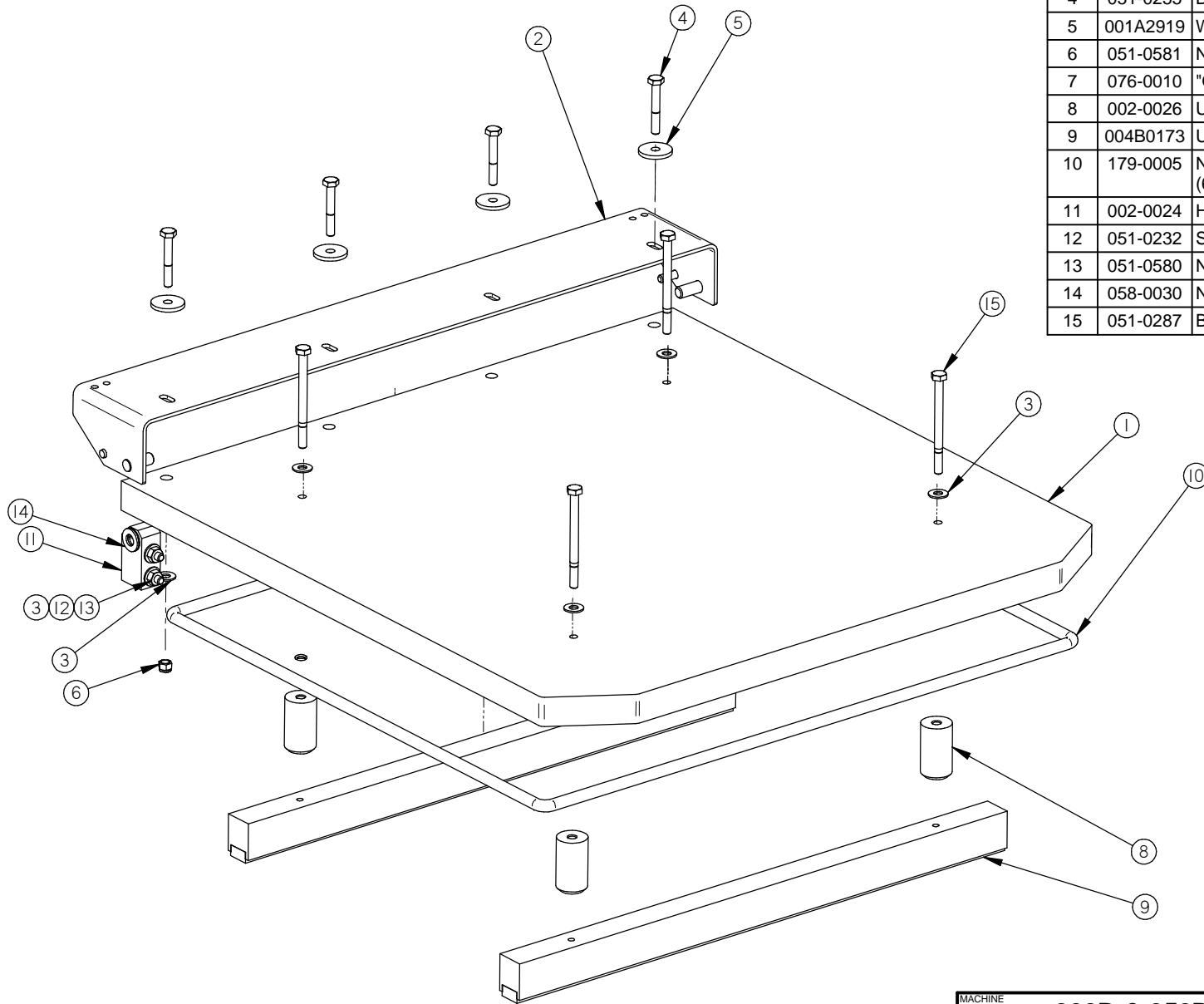
| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|---|-----|
| 1 | 002B0025 | PLEXI COVER | 1 |
| 2 | 004A0021 | COVER HINGE ASSEMBLY | 1 |
| 3 | 051-0740 | WASHER 1/4" FLAT S/S | 10 |
| 4 | 051-0255 | BOLT 1/4-20 x 1-3/4" HEX SS | 4 |
| 5 | 001A2919 | WASHER 0.381`ID X 1.062`OD X 3 | 4 |
| 6 | 051-0581 | NUT 1/4"-20 NYLON LOCK S/S | 4 |
| 7 | 076-0010 | "O" RING 1/4" x 3/8" x 1/16" | 2 |
| 8 | 002-0026 | UPPER SEAL BAR SPACER | 2 |
| 9 | 004B0173 | UPPER SEAL BAR PRE-ASS'Y | 1 |
| 10 | 179-0005 | NEOPRENE SPONGE 3/8" O.D. 2042mm (6.7') | 1 |
| 11 | 002-0024 | HINGE BLOCK | 2 |
| 12 | 051-0232 | SCREW 1/4-20x 1-1/4"SKT CAP SS | 4 |
| 13 | 051-0580 | NUT 1/4"-20 S/S | 4 |
| 14 | 058-0030 | NYLON SPACER 3/8IDx3/4ODx1/16 | 4 |
| 15 | 051-0287 | BOLT 1/4-20 x 3-1/4" S/S | 2 |

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

| | | | | | | |
|---------|-----------------------|------|------------|----------|----------|---|
| MACHINE | 300 & 350 | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | COVER ASSEMBLY | | USINAGE | ± 0.1 | ± 0.004" | |
| ITEM | CNC | | TOLERIE | ± 0.5 | ± 0.020" | |
| MAT. | APP. BY | S.L. | DATE | 13-11-26 | NO. | 005B0266 |
| | | | | | DEPT. | |
| | | | | | QTY. | 1 |

005B0481

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|---|-----|
| 1 | 002C0392 | PLEXI COVER | 1 |
| 2 | 004A0021 | COVER HINGE ASSEMBLY | 1 |
| 3 | 051-0740 | WASHER 1/4" FLAT S/S | 12 |
| 4 | 051-0255 | BOLT 1/4-20 x 1-3/4" HEX SS | 4 |
| 5 | 001A2919 | WASHER 0.381`ID X 1.062`OD X 3 | 4 |
| 6 | 051-0581 | NUT 1/4"-20 NYLON LOCK S/S | 4 |
| 7 | 076-0010 | "O" RING 1/4" x 3/8" x 1/16" | 4 |
| 8 | 002-0026 | UPPER SEAL BAR SPACER | 4 |
| 9 | 004B0173 | UPPER SEAL BAR PRE-ASS'Y | 2 |
| 10 | 179-0005 | NEOPRENE SPONGE 3/8" O.D. 2042mm (6.7') | 1 |
| 11 | 002-0024 | HINGE BLOCK | 2 |
| 12 | 051-0232 | SCREW 1/4-20x 1-1/4"SKT CAP SS | 4 |
| 13 | 051-0580 | NUT 1/4"-20 S/S | 4 |
| 14 | 058-0030 | NYLON SPACER 3/8IDx3/4ODx1/16 | 4 |
| 15 | 051-0287 | BOLT 1/4-20 x 3-1/4" S/S | 4 |

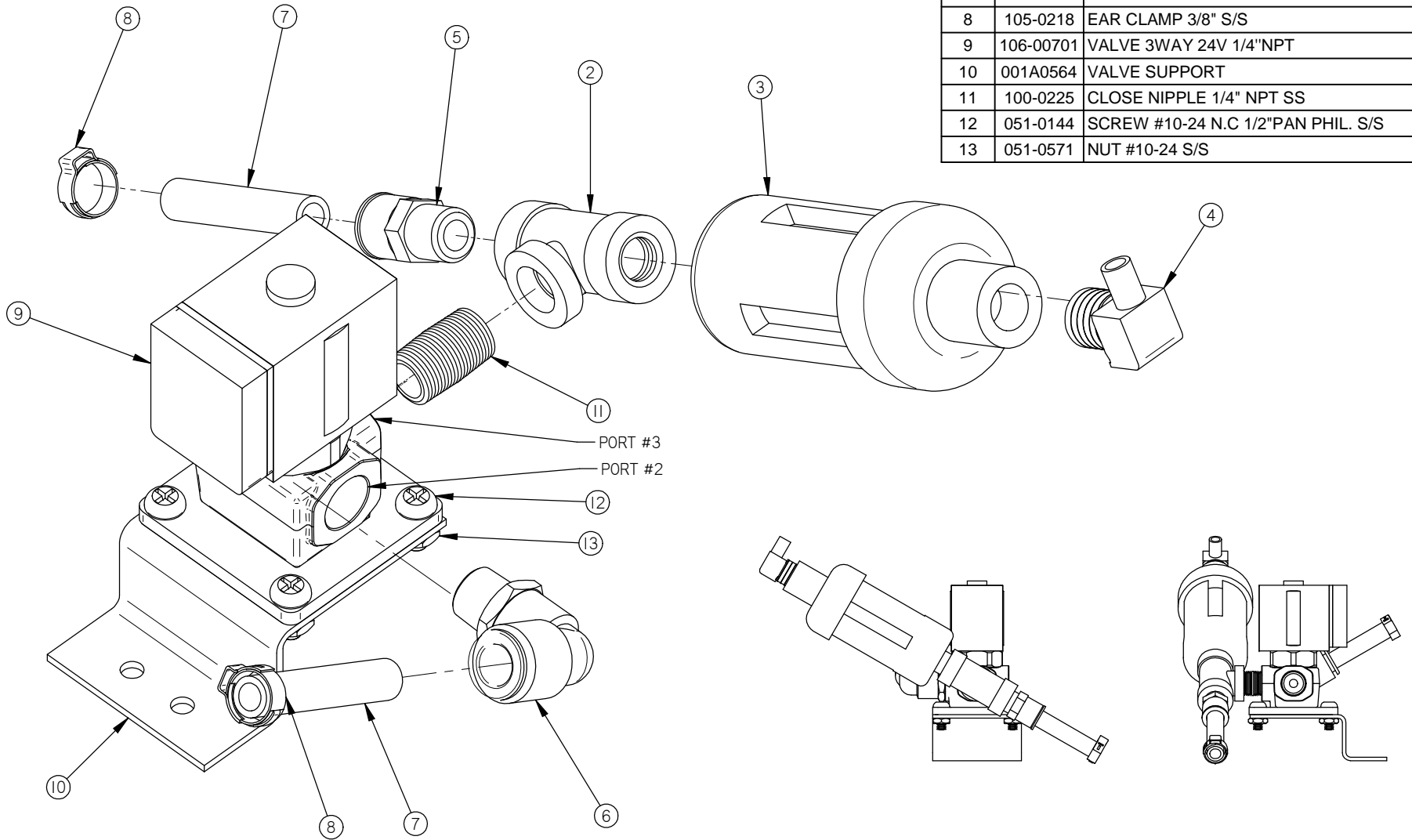


| | | | | | | |
|---------|------------------------|----------------------|--------------|--------|-----------------|---|
| MACHINE | 300D & 350D | | DEPT. TOL | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | COVER ASSEMBLY | | USINAGE | ± 0.1 | ± 0.004" | |
| | | | TOLERIE | ± 0.5 | ± 0.020" | |
| | | | SOUDEAGE | ± 0.5 | ± 0.020" | N.T.S. |
| ITEM | CNC | DEPT. | M-(M) | | QTY. | 1 |
| MAT. | DWG BY S.L. | DATE 14-02-06 | NO. | | 005B0481 | |
| | APP. BY | DATE | | | | |

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

004A4144

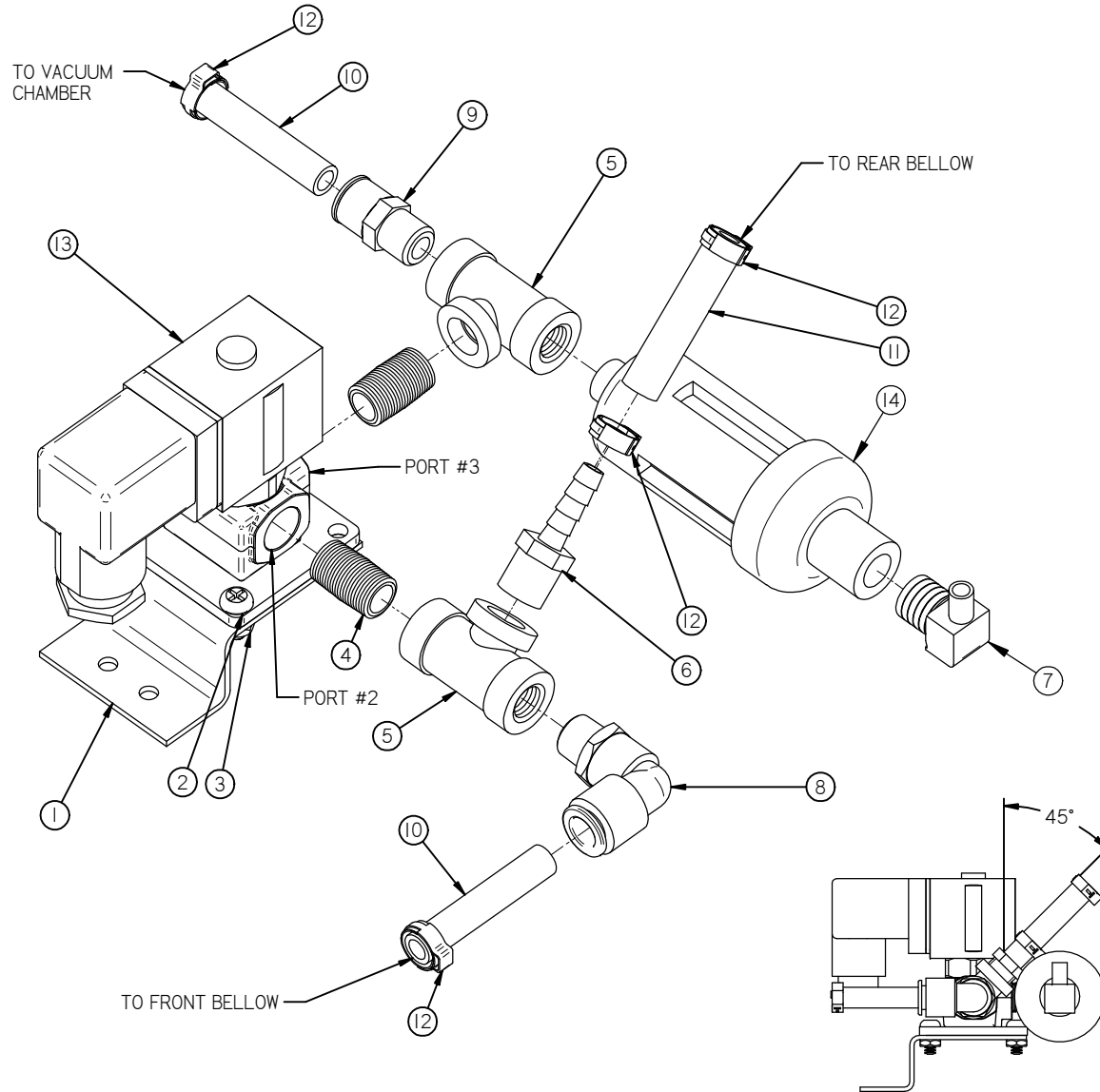
| ITEM | PART # | DESCRIPTION | QT. |
|------|-----------|---|-----|
| 2 | 100-0463 | TEE 1/4" NPT S/S | 1 |
| 3 | 114-2020 | FILTER / DRYER 1/4"mnpt. X 1/4"t.p. COMP. | 1 |
| 4 | 101-0170 | ELBOW 90° 1/4MNPTx1/4"HOSE | 1 |
| 5 | 102-0410 | MALE CONN.1/4"MNPTx3/8"T.QUICK | 1 |
| 6 | 102-0330 | ELBOW 1/4" NPT X 3/8" HOSE QUICK | 1 |
| 7 | 104-0060 | TUBE 3/8"OD x 1/4"ID POLYETHYL. | 2 |
| 8 | 105-0218 | EAR CLAMP 3/8" S/S | 2 |
| 9 | 106-00701 | VALVE 3WAY 24V 1/4"NPT | 1 |
| 10 | 001A0564 | VALVE SUPPORT | 1 |
| 11 | 100-0225 | CLOSE NIPPLE 1/4" NPT SS | 1 |
| 12 | 051-0144 | SCREW #10-24 N.C 1/2"PAN PHIL. S/S | 4 |
| 13 | 051-0571 | NUT #10-24 S/S | 4 |



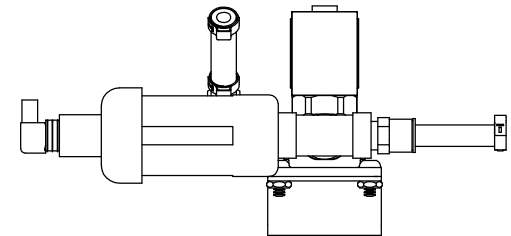
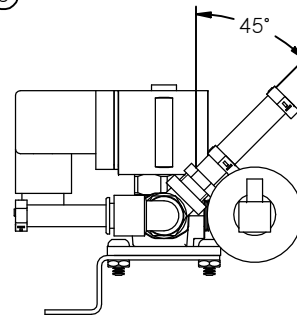
| | | | |
|------|------------------------|----------|------|
| A | 106-00701 WAS 106-0070 | 14-03-26 | SBU |
| LET. | MODIFICATION | DATE | INT. |

| | | | | | | |
|---------|-------------------------------------|-------|------------|----------|----------|---|
| MACHINE | 300/350 | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | VALVE ASSEMBLY VACCUM SENSOR | | USINAGE | ± 0.1 | ± 0.004" | |
| | | | TOLERIE | ± 0.5 | ± 0.020" | |
| | | | SOUDAGE | ± 0.5 | ± 0.020" | |
| ITEM | CNC | DEPT. | M | QTY. | 1 | |
| MAT. | DWG BY | S.L. | DATE | 13-11-14 | NO. | 004A4144 |
| | APP. BY | | DATE | | | |

004B4134



| ITEM | PART # | DESCRIPTION | QT. |
|------|-----------|---|-----|
| 1 | 001A0564 | VALVE SUPPORT | 1 |
| 2 | 051-0144 | SCREW #10-24 N.C 1/2" PAN PHIL. S/S | 2 |
| 3 | 051-0571 | NUT #10-24 S/S | 2 |
| 4 | 100-0225 | CLOSE NIPPLE 1/4" NPT SS | 2 |
| 5 | 100-0463 | TEE 1/4" NPT S/S | 2 |
| 6 | 100-1190 | STRAIGHT 1/4" MNPT x 1/4" HOSE BARB SS | 1 |
| 7 | 101-0170 | ELBOW 90° 1/4 MNPT x 1/4" HOSE | 1 |
| 8 | 102-0330 | ELBOW 1/4" NPT X 3/8" HOSE QUICK | 1 |
| 9 | 102-0410 | MALE CONN. 1/4" MNPT x 3/8" T. QUICK | 1 |
| 10 | 104-0060 | TUBE 3/8" OD x 1/4" ID POLYETHYL. | 2 |
| 11 | 104-0102 | HOSE 1/4" ID PVC BRAIDED | 1 |
| 12 | 105-0218 | EAR CLAMP 3/8" S/S | 4 |
| 13 | 106-00701 | VALVE 3WAY 24V 1/4" NPT | 1 |
| 14 | 114-2020 | FILTER / DRYER 1/4" mnpt. X 1/4" t.p. COMP. | 1 |



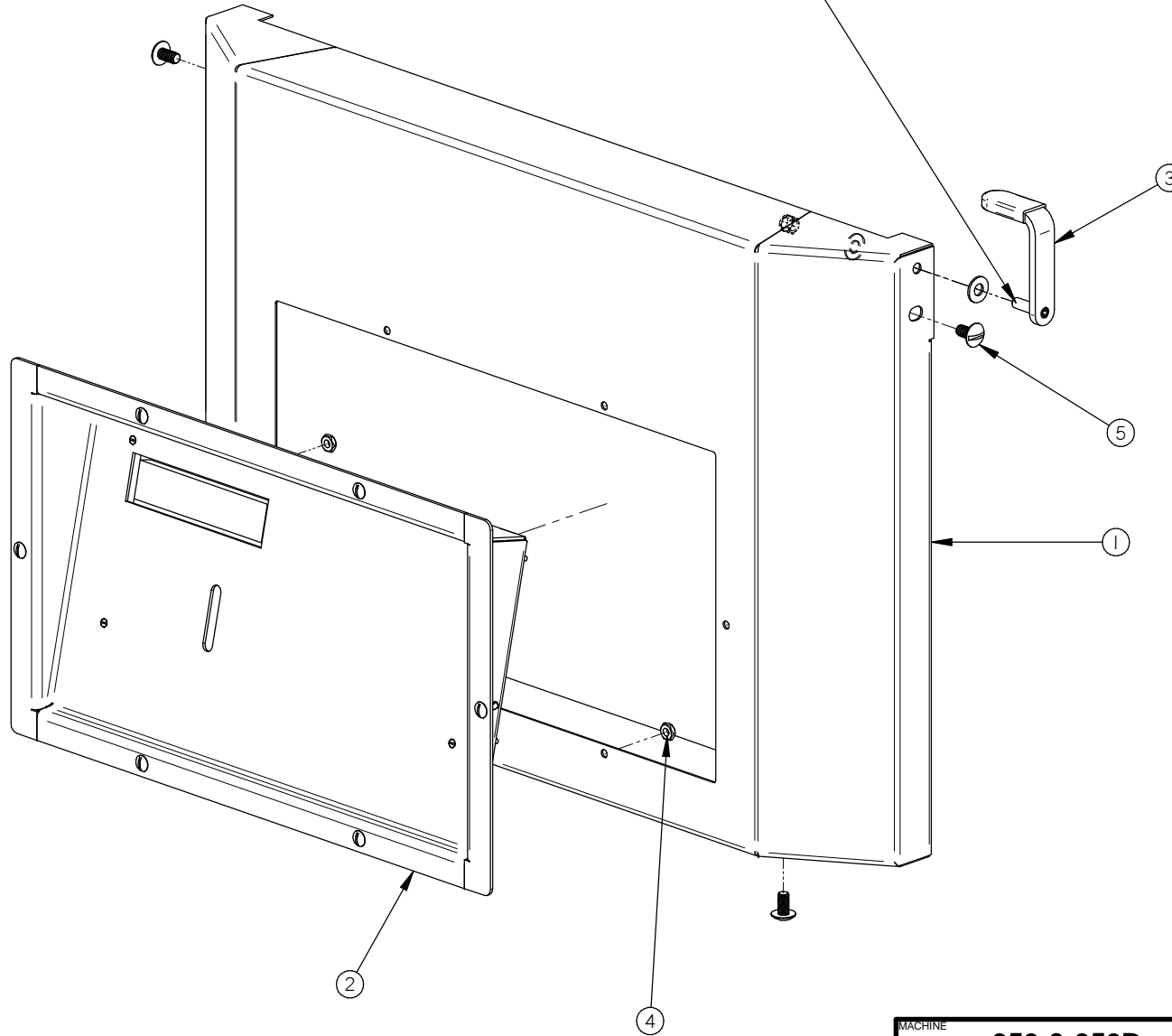
| | | | |
|------|----------------------------|----------|------|
| B | CHANGEMENT CONFIG | 14-06-02 | SBU |
| A | CHANGEMENT VALVE 106-00701 | 14-03-26 | S.T |
| LET. | MODIFICATION | DATE | INT. |

| | | | | | | | |
|---------|--|-------------------------------------|--|------------|--------|----------|---|
| MACHINE | | 300D/350D | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | | VALVE ASSEMBLY VACCUM SENSOR | | USINAGE | ± 0.1 | ± 0.004" | |
| ITEM | | CNC | | TOLERIE | ± 0.5 | ± 0.020" | |
| MAT. | | APP. BY | | S.L. | DATE | 13-11-14 | N.T.S. |
| | | | | | | | DEPT. M |
| | | | | | | | QTY. 1 |
| | | | | | | | 004B4134 |

005E0832

| ITEM | PART # | DESCRIPTION | QT. |
|------|-----------|----------------------------------|-----|
| 1 | 001E3123 | FRONT PANEL | 1 |
| 2 | 005C0583 | MC-40 CONTROL BOARD | 1 |
| 3 | 004B1651 | COVER HOLD DOWN ASS'Y | 1 |
| 4 | 051-0571 | NUT #10-24 S/S | 11 |
| 5 | 051-01865 | SCREW 1/4-20x 1/2" TRUSS SLOT SS | 4 |

INSTALLER POUR QUE LA BARRURE PUISSE BOUGER LIBREMENT SANS JEUX AXIAL.
 INSTALL SO THAT THE LOCK CAN TURN WITHOUT AXIAL PLAY.

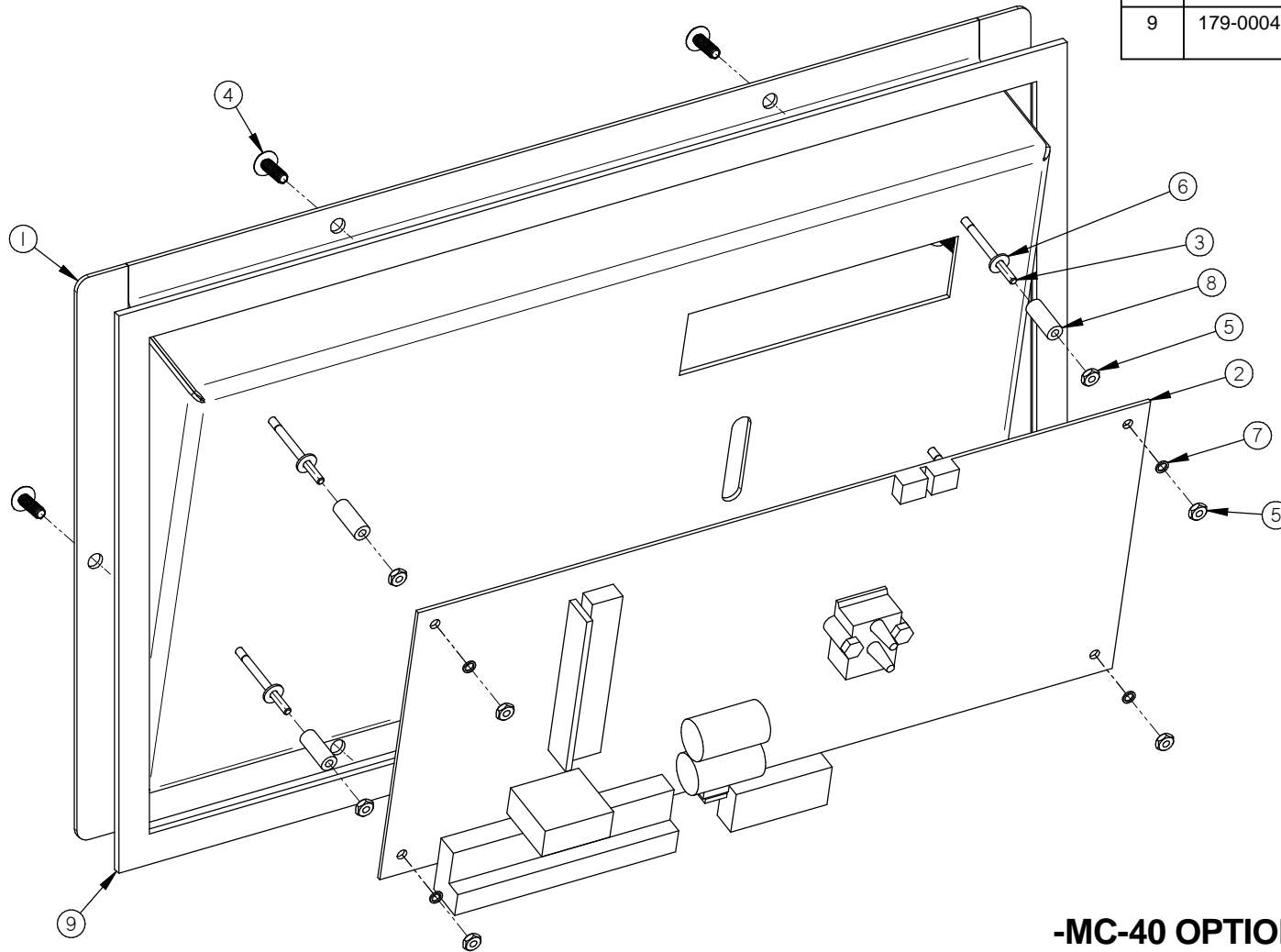


| | | | |
|------|--------------|------|------|
| LET. | MODIFICATION | DATE | INT. |
|------|--------------|------|------|

| | | | | | | |
|---------|--|-----------------------------------|--|------------------------|----------|---|
| MACHINE | | 350 & 350D | | DEPT. TOL. METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | | MC-40 FRONT PANEL ASSEMBLY | | USINAGE ± 0.1 ± 0.004" | N.T.S. | |
| ITEM | | CNC | | TOLERIE ± 0.5 ± 0.020" | | |
| MAT. | | APP. BY SBU | | SOUDAGE ± 0.5 ± 0.020" | | |
| | | DATE 15-02-23 | | DEPT. | M | QTY. 1 |
| | | DATE | | NO. 005E0832 | | |

005C0583

| ITEM | PART # | DESCRIPTION | QT. |
|------|-----------|---|-----|
| 1 | 001B6920 | CONTROL PANEL MC-40 | 1 |
| 2 | 033-0038 | MC-40 SENSOR VACUUM | 1 |
| 3 | 051-0092 | SCREW #4-40 x 1 1/4" FLAT SLT S/S | 4 |
| 4 | 051-01081 | SCREW 8-32 X 1/2" TRUSS SLOT SS | 6 |
| 5 | 051-0540 | NUT #4-40 HEX S/S | 8 |
| 6 | 051-0713 | WASHER #4 FLAT S/S | 4 |
| 7 | 051-0715 | WASHER #4 LOCK SS | 4 |
| 8 | 058-0120 | CPVC SPACER 0.120" x 1/4" x 5/8" | 4 |
| 9 | 179-0004 | NITRILE 1/2" X 1/8" AUTOCOLLANT X 1210mm long | 1 |



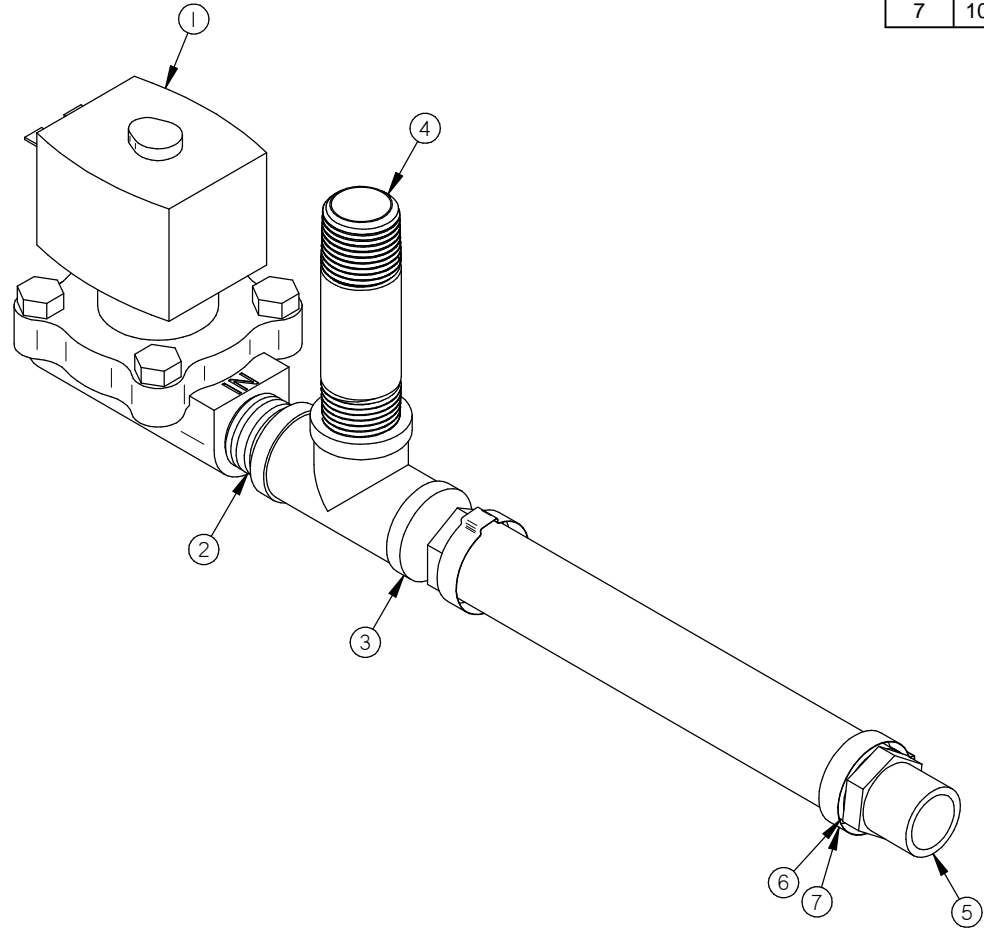
-MC-40 OPTION-

| | | | | | | | |
|---------|--|----------------------------|--|------------|----------|----------|---|
| MACHINE | | VACUUM | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | | MC-40 CONTROL BOARD | | USINAGE | ± 0.1 | ± 0.004" | |
| ITEM | | CNC | | TOLERIE | ± 0.5 | ± 0.020" | |
| MAT. | | 3D DWG BY SBU | | DATE | 15-02-23 | | NO. 005C0583 |
| LET. | | 2D DWG BY SBU | | DATE | 15-02-23 | | |
| | | | | DEPT. | M | | QTY. 1 |

| | | | |
|------|--------------|----------|------|
| A | SS INSERT | 15-02-23 | SBU |
| LET. | MODIFICATION | DATE | INT. |

004A4133

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|--|-----|
| 1 | 106-0020 | VALVE 2WAY 24V 1/2"NPT(G94) 60Hz | 1 |
| 2 | 100-0230 | CLOSE NIPPLE 1/2" npt, S/S | 1 |
| 3 | 100-0465 | TEE 1/2"npt. S/S | 1 |
| 4 | 100-0330 | NIPPLE 1/2" NPT X 3" SS | 1 |
| 5 | 101-0220 | STRAIGHT 1/2"MNPTx3/4" HOSE BARB BRASS | 2 |
| 6 | 104-0110 | HOSE 3/4" ID VACUUM TIGERFLEX | 1 |
| 7 | 105-0238 | EAR CLAMP 23.9-27.1 SS | 2 |

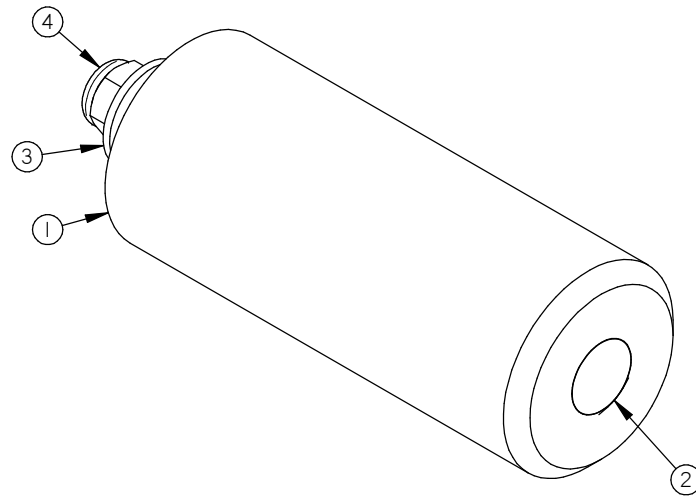


| | | | |
|------|--------------|------|------|
| LET. | MODIFICATION | DATE | INT. |
|------|--------------|------|------|

| | | | | | | | |
|---------|----------------------------|-------|------|------------|--------|-----------------|---|
| MACHINE | 350/350D | | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | VALVE ASSEMBLY PUMP | | | USINAGE | ± 0.1 | ± 0.004" | |
| | | | | TOLERIE | ± 0.5 | ± 0.020" | |
| | | | | SOUDEAGE | ± 0.5 | ± 0.020" | |
| ITEM | CNC | DEPT. | M | QTY. | 1 | N.T.S. | |
| MAT. | DWG BY | S.L. | DATE | 13-11-14 | NO. | 004A4133 | |
| | APP. BY | | DATE | | | | |

004A4112

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|----------------------------|-----|
| 1 | 002A3528 | NSF FOOT | 1 |
| 2 | 051-0288 | BOLT 1/4-20 x 3 1/2" S/S | 1 |
| 3 | 051-0740 | WASHER 1/4" FLAT S/S | 1 |
| 4 | 051-0581 | NUT 1/4"-20 NYLON LOCK S/S | 1 |

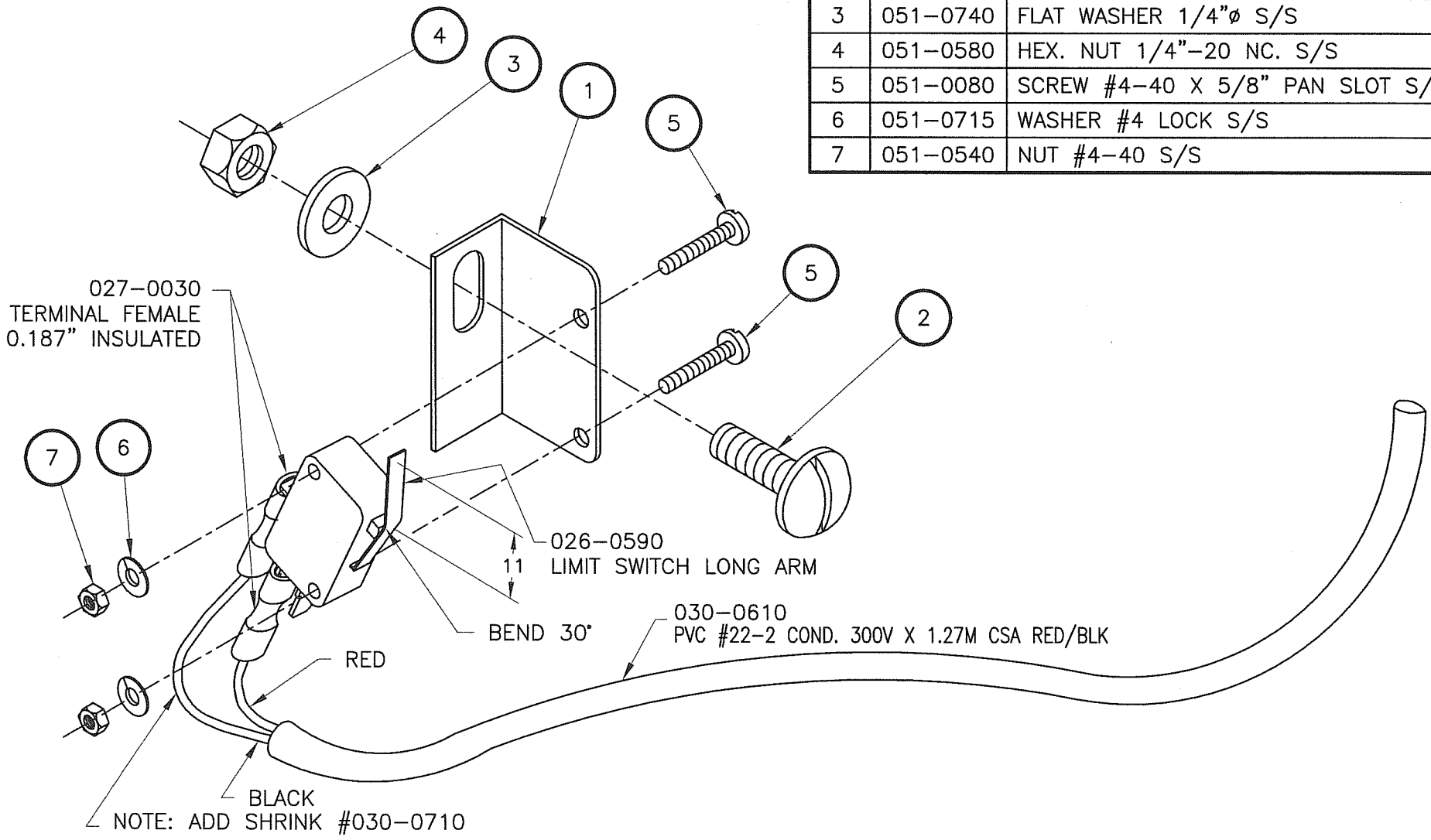


| | | | | | | | |
|---------|--|---------------------|--|------------|--------|----------|---|
| MACHINE | | VACUUM TABLE | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | | NSF FOOT | | USINAGE | ± 0.1 | ± 0.004" | |
| ITEM | | CNC | | TOLERIE | ± 0.5 | ± 0.020" | |
| MAT. | | APP. BY | | DATE | | NO. | 4 |
| LET. | | MODIFICATION | | DATE | | INT. | 004A4112 |

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

004A3374

| ITEM | PART # | DESCRIPTION | QT. |
|------|-----------|---|-----|
| 1 | 001-0944 | SUPPORT SWITCH | 1 |
| 2 | 051-01865 | SCREW 1/4"-20 NC. X 1/2" TRUSS SLOT S/S | 1 |
| 3 | 051-0740 | FLAT WASHER 1/4"φ S/S | 1 |
| 4 | 051-0580 | HEX. NUT 1/4"-20 NC. S/S | 1 |
| 5 | 051-0080 | SCREW #4-40 X 5/8" PAN SLOT S/S | 2 |
| 6 | 051-0715 | WASHER #4 LOCK S/S | 2 |
| 7 | 051-0540 | NUT #4-40 S/S | 2 |

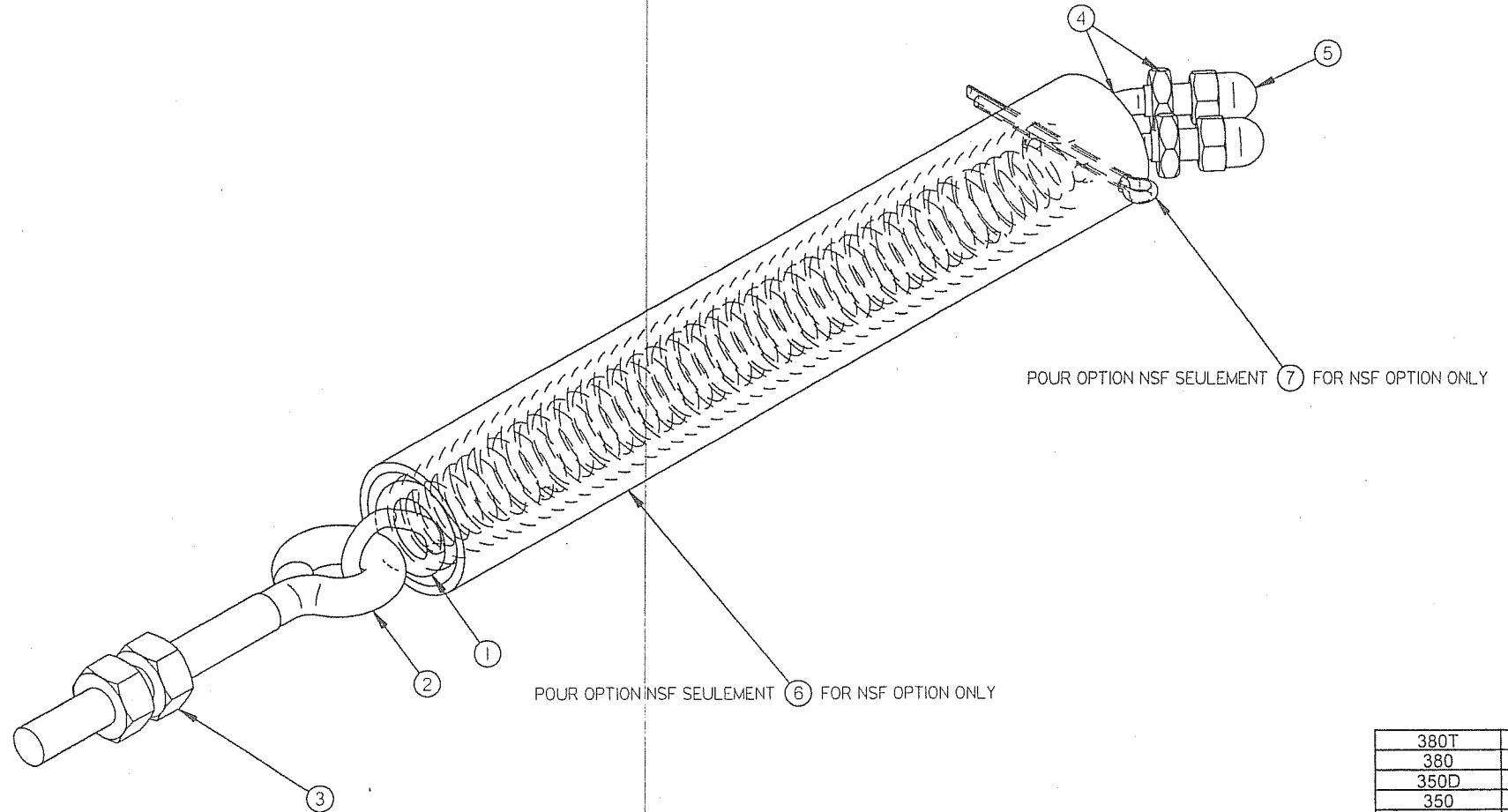


| | |
|---------|-----------------------|
| MACHINE | 300 & 300D |
| PART | LIMIT SWITCH ASSEMBLY |
| ITEM: | _____ |
| MAT: | _____ |
| A | REDRAWN WAS 004-0261 |
| LET. | MODIFICATION |
| | 10-11-16 |
| | D.A. |
| | DATE |
| | INT. |

| | | | | | |
|---------|-----------------------|---|--|--------------|---|
| MACHINE | 300 & 300D | METRIC TOLERANCE | INCH TOLERANCE | SIPROMAC | |
| PART | LIMIT SWITCH ASSEMBLY | 0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1° | .0 ± .015" .00 ± .005" .000 ± .0005" N.T.S. | | ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| ITEM: | _____ | CNC: | _____ | DEPT. M-I | QT. 1 |
| MAT: | _____ | DWG BY | D.A. | DATE | 10-11-16 |
| | | APP. | _____ | DATE | _____ |
| | | | | NO. 004A3374 | |

004A1224

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|--------------------------------|-----|
| 1 | 009A0152 | SPRING BLACK | 1 |
| 2 | 056-0150 | EYE BOLT 1/4"-20 x 3" ZINC | 1 |
| 3 | 051-0580 | NUT 1/4"-20 S/S | 2 |
| 4 | 056-2500 | U-BOLT CABLE CLAMP THRD #10-24 | 1 |
| 5 | 051-0570 | NUT #10-24 ACORN SS | 2 |
| 6 | 008A1603 | SPRING PROTECTION TUBE | 1 |
| 7 | 056-0118 | COTTER PIN 3/32" x 1" S/S | 1 |



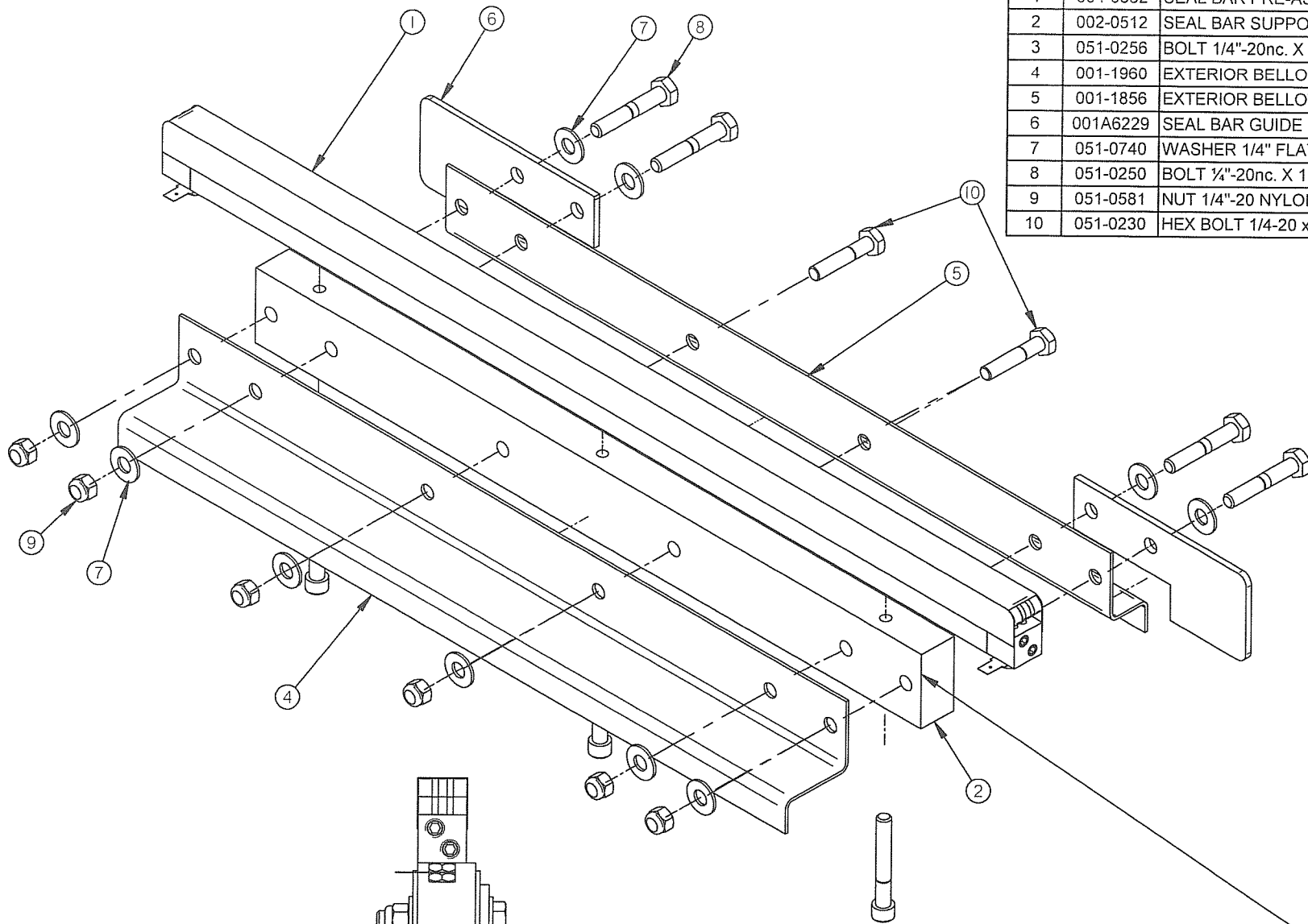
| | |
|---------|-----|
| 380T | 4 |
| 380 | 2 |
| 350D | 2 |
| 350 | 2 |
| 300 | 2 |
| MACHINE | QTY |

| | | | |
|------|--|----------|------|
| E | AJOUTER ITEM 008A1603 & 056-0118 (NSF) | 10-11-09 | J.G. |
| D | ADDED ITEM #3 051-0580 QTY : 2 | 05-05-05 | M.A. |
| C | ADDED 380T | 05-02-03 | M.A. |
| B | 009A0152 WAS 077-0002 | 04-12-07 | M.A. |
| A | AJOUTER 380 DANS CARTOUCHE | 03-09-04 | J.P. |
| LET. | MODIFICATION | DATE | INT. |

| | | | | | |
|---------|---------------------------|---------------|------------------------|--------|---|
| MACHINE | 300, 350, 350D 380 & 380T | | DEPT. TOL. METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | SPRING PRE-ASSEMBLY | | USINAGE ± 0.1 ± 0.004" | N.T.S. | |
| | | | TOLERIE ± 0.5 ± 0.020" | | |
| ITEM | CNC | DEPT. | M(M) | QTY | LISTE |
| MAY. | DWG BY J.T. | DATE 03-02-17 | NO. 004A1224 | | |
| | APP. BY | DATE 16-11-11 | | | |

1005A1355

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|--------------------------------------|-----|
| 1 | 004-0352 | SEAL BAR PRE-ASSEMBLY | 1 |
| 2 | 002-0512 | SEAL BAR SUPPORT | 1 |
| 3 | 051-0256 | BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S | 3 |
| 4 | 001-1960 | EXTERIOR BELLOWS COVER | 1 |
| 5 | 001-1856 | EXTERIOR BELLOWS COVER | 1 |
| 6 | 001A6229 | SEAL BAR GUIDE | 2 |
| 7 | 051-0740 | WASHER 1/4" FLAT S/S | 10 |
| 8 | 051-0250 | BOLT 1/4"-20nc. X 1 1/2" S/S | 4 |
| 9 | 051-0581 | NUT 1/4"-20 NYLON LOCK S/S | 6 |
| 10 | 051-0230 | HEX BOLT 1/4-20 x 1 1/4" SS | 2 |



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

-END VIEW-

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

| | |
|---------|-----|
| 350D | 2 |
| 350 | 1 |
| 300D | 2 |
| 300 | 1 |
| MACHINE | QTY |

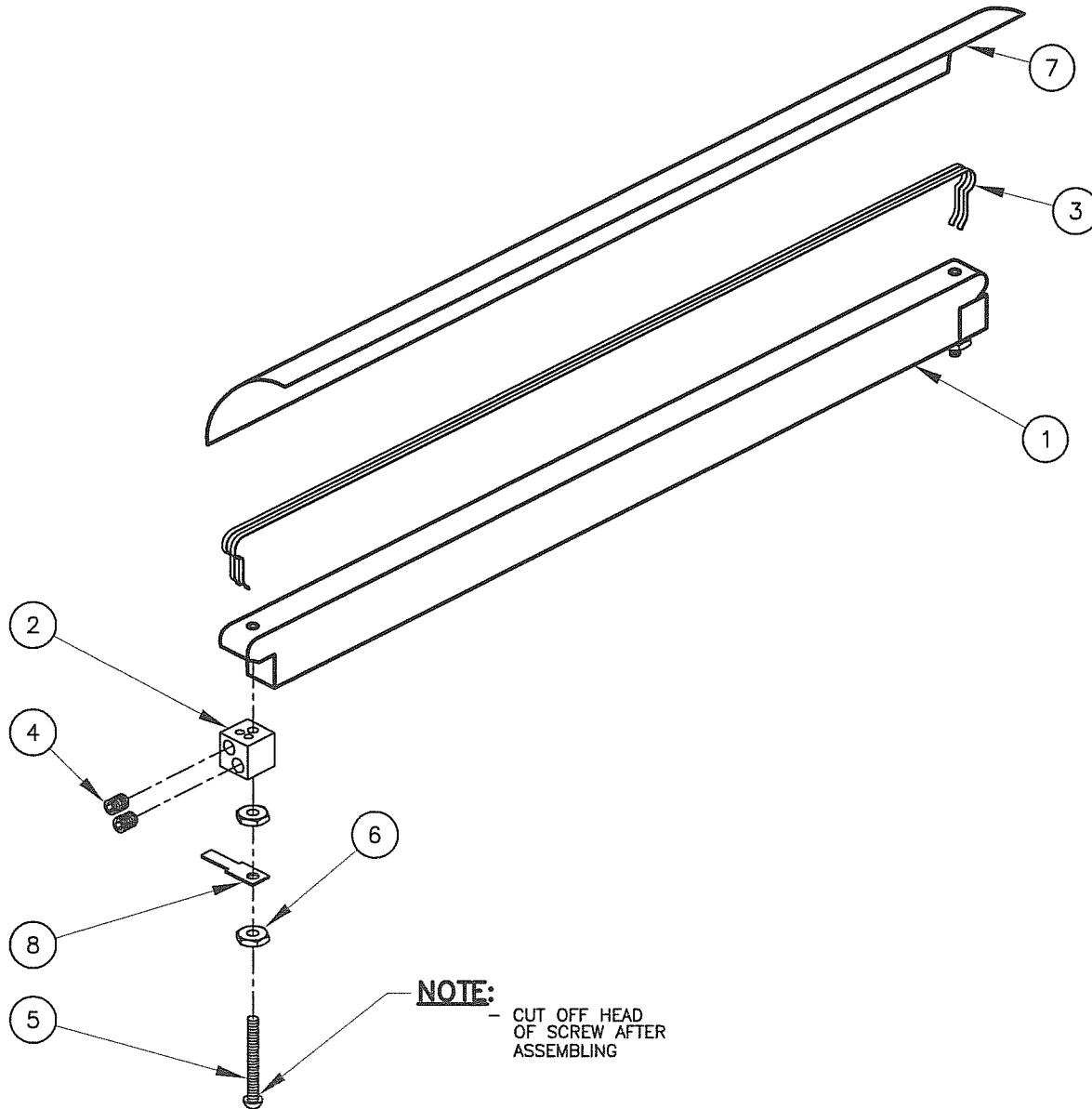
-TWIN SEAL OPTION-

| | | | | | |
|---------|-----------------------------|---------------|------------------------|------------------------|---|
| MACHINE | 300, 300D, 350 & 350D | | DEPT. TOL. METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | SEAL BAR ASSEMBLY W/SUPPORT | | USINAGE ± 0.1 ± 0.004" | TOLERIE ± 0.5 ± 0.020" | |
| ITEM | CNC | | SOUDEGE ± 0.5 ± 0.020" | | N.T.S. |
| MAT. | DWG BY J.G. | DATE 12-09-24 | APP. BY | | DEPT. M-I(M) QTY LIST |
| | | | | | NO. 005A1355 |

| | | | |
|------|--------------------------|----------|------|
| A | REDESSINE ÉTAIT 005B0046 | 12-09-24 | J.G. |
| LET. | MODIFICATION | DATE | INT. |

1004-0352

| ITEM | #PART | DESCRIPTION | QT. |
|------|----------|---|-------|
| 1 | 002-0481 | SEAL BAR (TABLE) | 1 |
| 2 | 002-0031 | CONNECTOR | 2 |
| 3 | 039-0200 | SEALING ELEM. STD TWIN (2x626mm EA.) | 4.31 |
| 4 | 052-0395 | SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT | 4 |
| 5 | 052-0250 | SCREW #8-32 X 1 1/2" RND SLOT BRASS | 2 |
| 6 | 051-0550 | NUT #8-32 S/S | 4 |
| 7 | 176-0200 | TEFLON TAPE 5S ADHESIVE X 2" X (496mm EA.) | 0.063 |
| 8 | 027-0400 | CONNECTOR ADAPTOR 1/4" X #10 STUD | 2 |



NOTE:
- CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

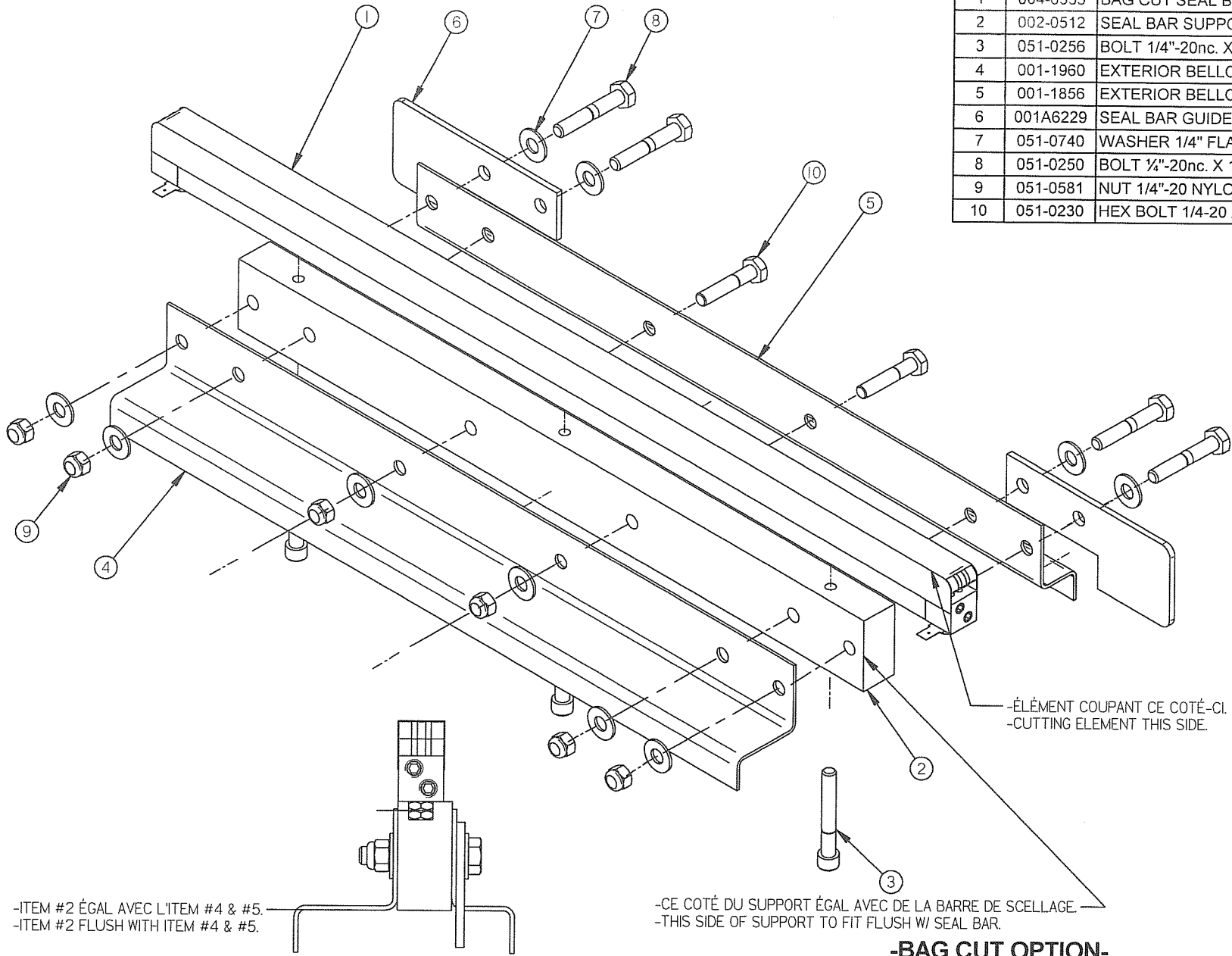
| | |
|---------|------|
| 450T | 2 |
| 450A | 2 |
| 400 | 2 |
| 350D | 2 |
| 350 | 1 |
| 300D | 2 |
| 300 | 1 |
| MACHINE | QTÉ. |

| | | | |
|------|--|----------|------|
| F | ADDED 300, 300D, 350 & 350D WAS 005-0267 | 12-09-24 | J.G. |
| E | ADDED 450T WAS 005-0377 | 08-05-26 | D.A. |
| D | MODIFICATION #A-0398 (CONNECTEUR) | 04-04-19 | J.G. |
| C | ADDED 400 | 99-05-06 | S.L. |
| B | REDRAWN | 98-02-10 | A.P. |
| LET. | MODIFICATION | DATE | INT. |

| | | | | | | | |
|---------|--|-----------------------|--|-----------|--|------------------------|--|
| MACHINE | | VOIR LISTE | | TOLERANCE | | ST-GERMAIN DE GRANTHAM | |
| PART | | SEAL BAR PRE-ASSEMBLY | | METRIC | | QUEBEC CANADA | |
| ITEM: | | CNC: | | USINAGE | | DEPT. M-1 | |
| MAT: | | DWG BY A. P. | | TOLERANCE | | QT. 2 | |
| | | DATE 98-02-10 | | SOUDAGE | | NO. 004-0352 | |
| | | DATE | | N.T.S. | | | |

005A1356

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|--------------------------------------|-----|
| 1 | 004-0355 | BAG CUT SEAL BAR PRE-ASSEMBLY | 1 |
| 2 | 002-0512 | SEAL BAR SUPPORT | 1 |
| 3 | 051-0256 | BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S | 3 |
| 4 | 001-1960 | EXTERIOR BELLOWS COVER | 1 |
| 5 | 001-1856 | EXTERIOR BELLOWS COVER | 1 |
| 6 | 001A6229 | SEAL BAR GUIDE | 2 |
| 7 | 051-0740 | WASHER 1/4" FLAT S/S | 10 |
| 8 | 051-0250 | BOLT 1/4"-20nc. X 1 1/2" S/S | 4 |
| 9 | 051-0581 | NUT 1/4"-20 NYLON LOCK S/S | 6 |
| 10 | 051-0230 | HEX BOLT 1/4-20 x 1 1/4" SS | 2 |



-ÉLÉMENT COUPANT CE CÔTÉ-CI.
-CUTTING ELEMENT THIS SIDE.

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

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

-END VIEW-

-BAG CUT OPTION-

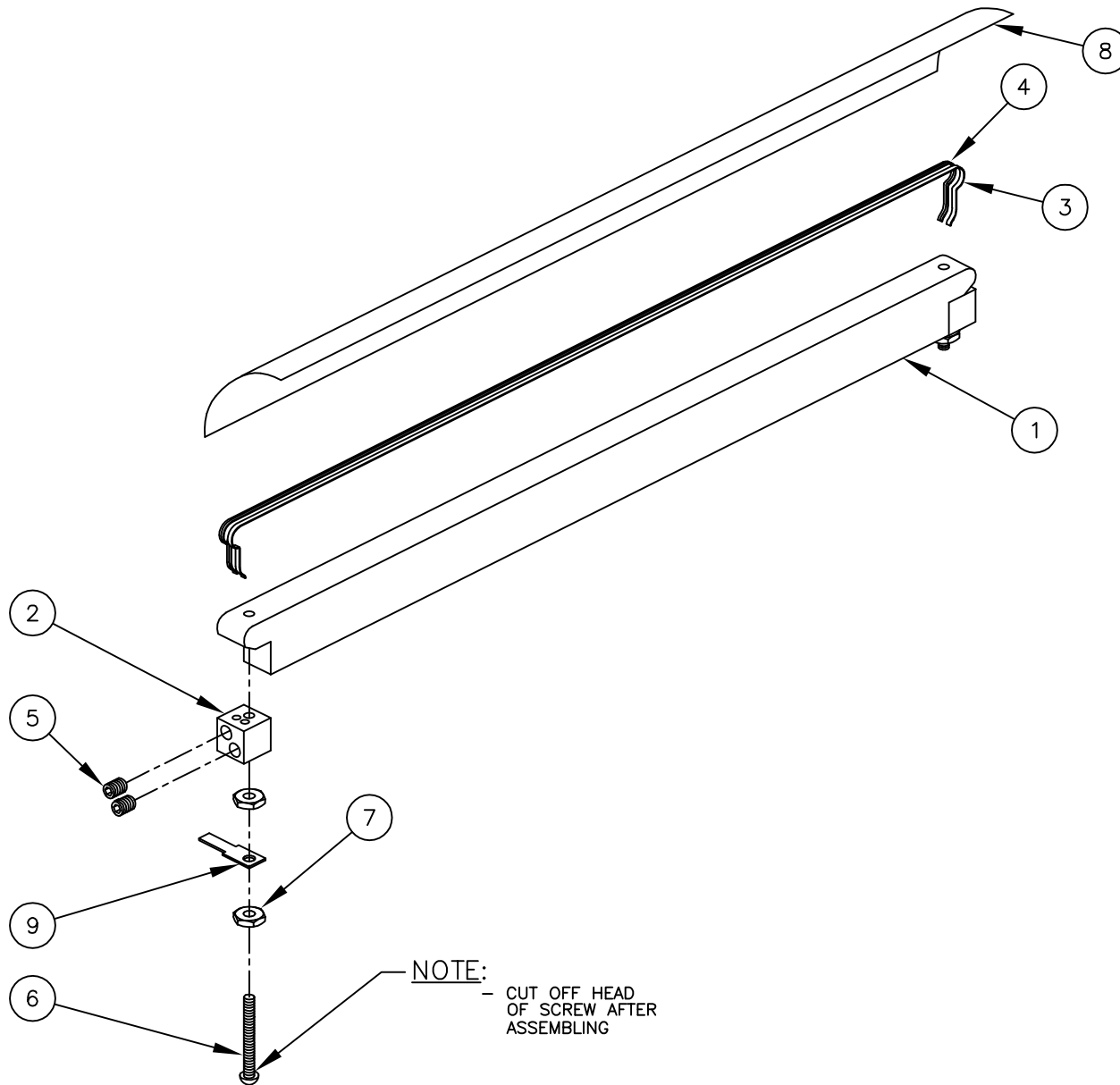
| | |
|---------|-----|
| 350D | 2 |
| 350 | 1 |
| 300D | 2 |
| 300 | 1 |
| MACHINE | QTY |

| | | | | |
|---|------|-----------------------|-----------------------|---|
| MACHINE 300, 300D, 350 & 350D | | DEPT. TOL. METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART SEAL BAR ASSEMBLY W/SUPPORT | | USINAGE ± 0.1 ± 0.004 | TOLERIE ± 0.5 ± 0.020 | |
| | | SOUDEGE ± 0.5 ± 0.020 | N.T.S. | |
| ITEM | CNC | DEPT. | M-I-(M) QTY LIST | |
| LET. | DATE | INT. | NO. 005A1356 | |

| | | | |
|------|--------------------------|----------|------|
| A | REDESSINE ETAIT 005B0558 | 12-09-24 | J.G. |
| LET. | MODIFICATION | DATE | INT. |

1004-0355

| ITEM | #PART | DESCRIPTION | QT. |
|------|----------|---|-------|
| 1 | 002-0481 | SEAL BAR | 1 |
| 2 | 002-0031 | CONNECTOR | 2 |
| 3 | 039-0230 | REFLEX BAND 2.5MM (626mm EA.) | 0.063 |
| 4 | 039-0270 | "T" PROFILE CUT. ELEM. (626mm EA.) | 0.063 |
| 5 | 052-0395 | SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT | 4 |
| 6 | 052-0250 | SCREW #8-32 X 1 1/2" RND SLOT BRASS | 2 |
| 7 | 051-0550 | NUT #8-32 S/S | 4 |
| 8 | 176-0200 | TEFLON TAPE 5S ADHESIVE X 2" X (496mm EA.) | 0.063 |
| 9 | 027-0400 | CONNECTOR ADAPTOR 1/4" X #10 STUD | 2 |



NOTE: - CUT OFF HEAD OF SCREW AFTER ASSEMBLING

-BAG CUT OPTION-

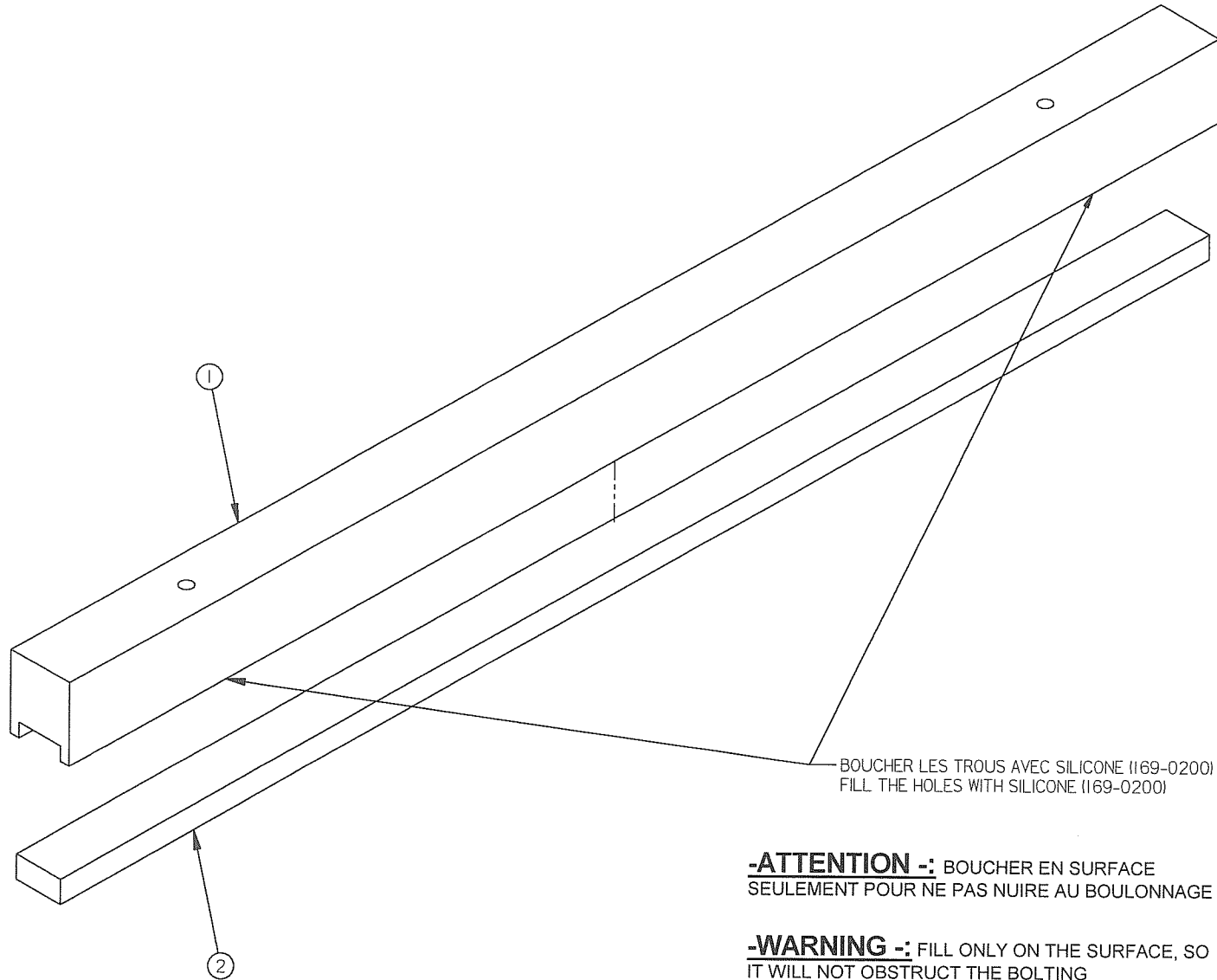
| | |
|---------|------|
| 450T | 2 |
| 450A | 2 |
| 400 | 2 |
| 350D | 2 |
| 350 | 1 |
| 300D | 2 |
| 300 | 1 |
| MACHINE | QTÉ. |

| | | | | | | |
|---------|-----------------------|---------|-----------|-------|----------|--|
| MACHINE | VOIR LISTE | | TOLERANCE | | | |
| PART | SEAL BAR PRE-ASSEMBLY | | USINAGE | ± 0.1 | ± 0.004" | SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA |
| | | | TOLERIE | ± 0.5 | ± 0.020" | |
| | | | SOUDAGE | ± 0.5 | ± 0.020" | |
| ITEM: | | CNC: | | | | |
| MAT: | | DWG BY: | A.P. | DATE | 98-02-10 | NO. 004-0355 |
| | | APP. | | DATE | | |

| | | | |
|------|--|----------|------|
| F | ADDED 300, 300D, 350 & 350D WAS 005-0267 | 12-09-24 | J.G. |
| E | ADDED 450T WAS 005-0383 | 08-05-26 | D.A. |
| D | MODIFICATION #A-0398 (CONNECTEUR) | 04-04-19 | J.G. |
| C | ADDED 400 | 99-05-06 | S.L. |
| B | REDRAWN | 98-02-10 | A.P. |
| LET. | MODIFICATION | DATE | INT. |

004B0173

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|------------------------|-----|
| 1 | 002B0377 | UPPER SEAL BAR SUPPORT | 1 |
| 2 | 008A0291 | UPPER SEAL BAR RUBBER | 1 |



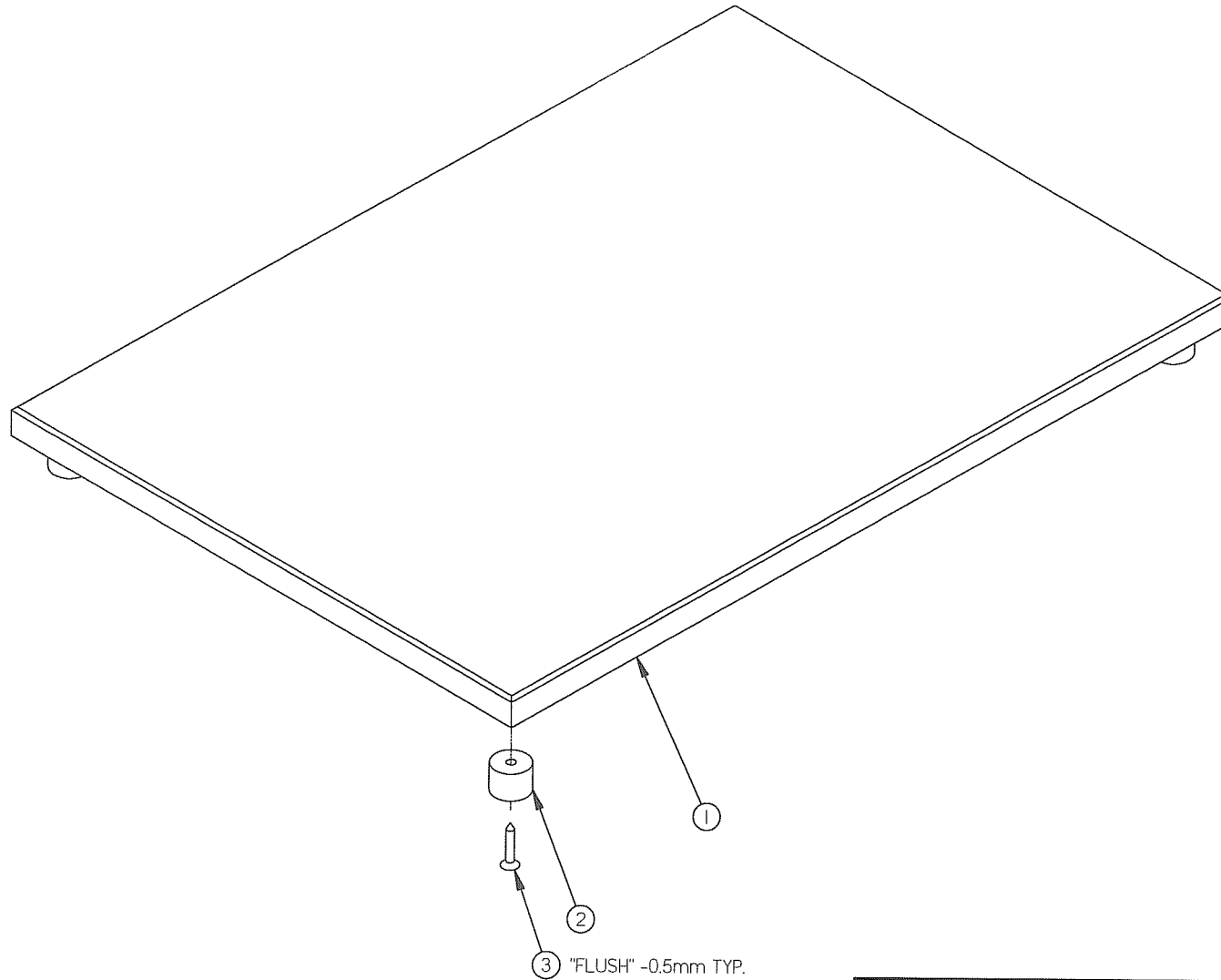
| | |
|---------|-----|
| 350D | 2 |
| 350 | 1 |
| 300D | 2 |
| 300 | 1 |
| MACHINE | QTY |

| | | | | |
|---|--|------------------------|------------------------|---|
| MACHINE 300, 300D, 350 & 350D | | DEPT. TOL. METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART UPPER SEAL BAR PRE-ASS'Y | | USINAGE ± 0.1 ± 0.004" | TOLERIE ± 0.5 ± 0.020" | |
| ITEM _____ | | SOUDEGE ± 0.5 ± 0.020" | | N.T.S. |
| MAT. _____ | | CNC _____ | DEPT. M-(M) | QTY LISTE |
| APP. BY _____ | | DWG BY J.G. | DATE 12-10-15 | NO 004B0173 |

| | | | |
|------|-------------------------|----------|------|
| F | REDESSINE MODIF. #A-462 | 12-10-15 | J.G. |
| LET. | MODIFICATION | DATE | INT. |

005A0278

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|---------------------------------|-----|
| 1 | 008A0270 | FILLER PLATE | 1 |
| 2 | 003-0080 | FILLER PLATE FOOT | 4 |
| 3 | 054-0019 | METAL SCREW #10x1"FLAT PHIL S/S | 4 |

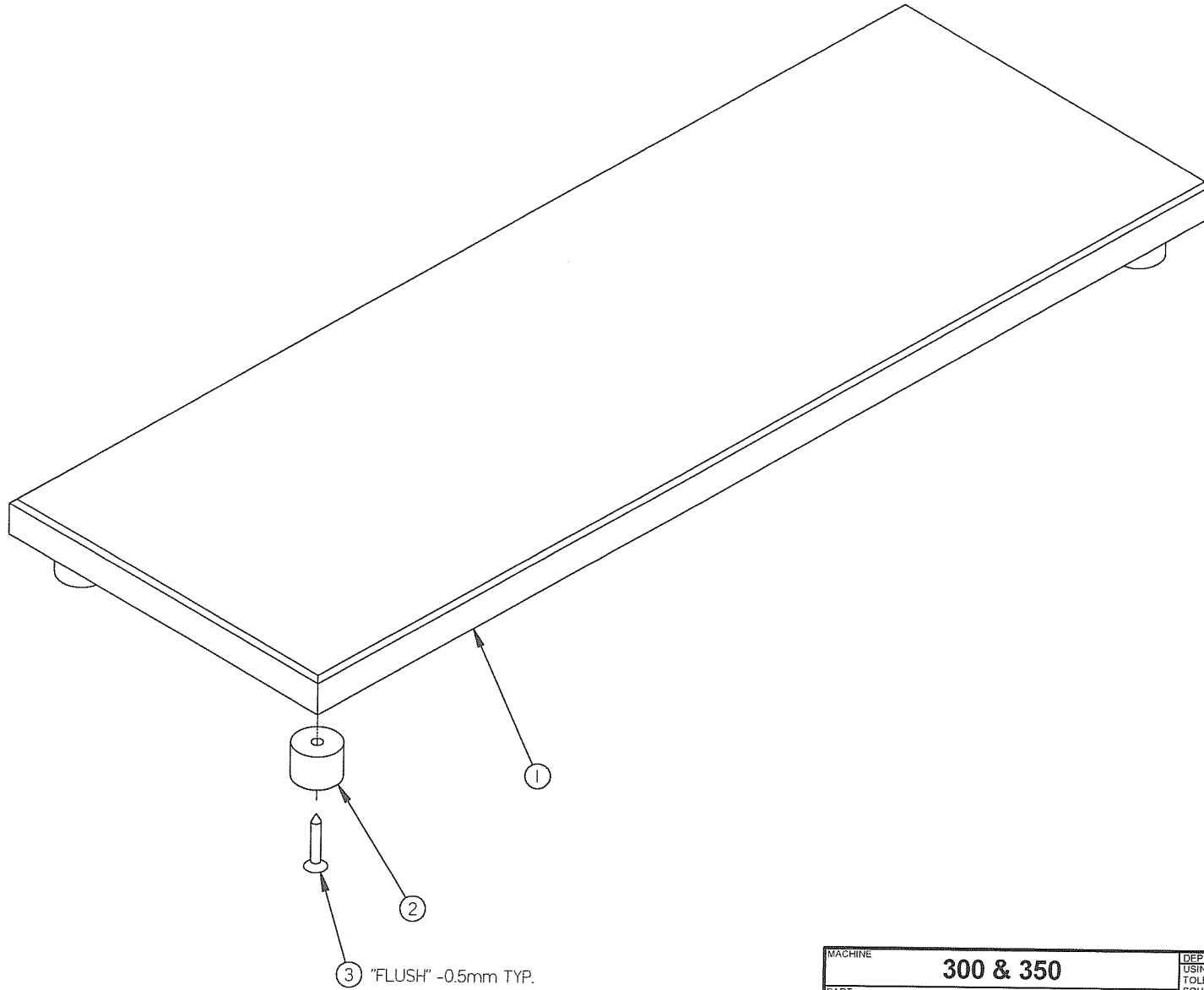


| | | | | | | |
|---------|----------------------|-------|------------|----------|----------|---|
| MACHINE | 300 & 350 | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | FILLER PLATE ASS'Y | | USINAGE | ± 0.1 | ± 0.004" | |
| | | | TOLERIE | ± 0.5 | ± 0.020" | |
| | | | SOUDAGE | ± 0.5 | ± 0.020" | N.T.S. |
| ITEM | CNC | DEPT. | M | QTY. | 1 | |
| MAT. | DWG BY | J.G. | DATE | 12-10-15 | NO. | 005A0278 |
| | APP. BY | | DATE | | | |

| | | | |
|------|------------------------|----------|------|
| C | REDESSINE MODIF. A-462 | 12-10-15 | J.G. |
| LET. | MODIFICATION | DATE | INT. |

005A0364

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|---------------------------------|-----|
| 1 | 008A0337 | HALF FILLER PLATE | 1 |
| 2 | 003-0080 | FILLER PLATE FOOT | 4 |
| 3 | 054-0019 | METAL SCREW #10x1"FLAT PHIL S/S | 4 |

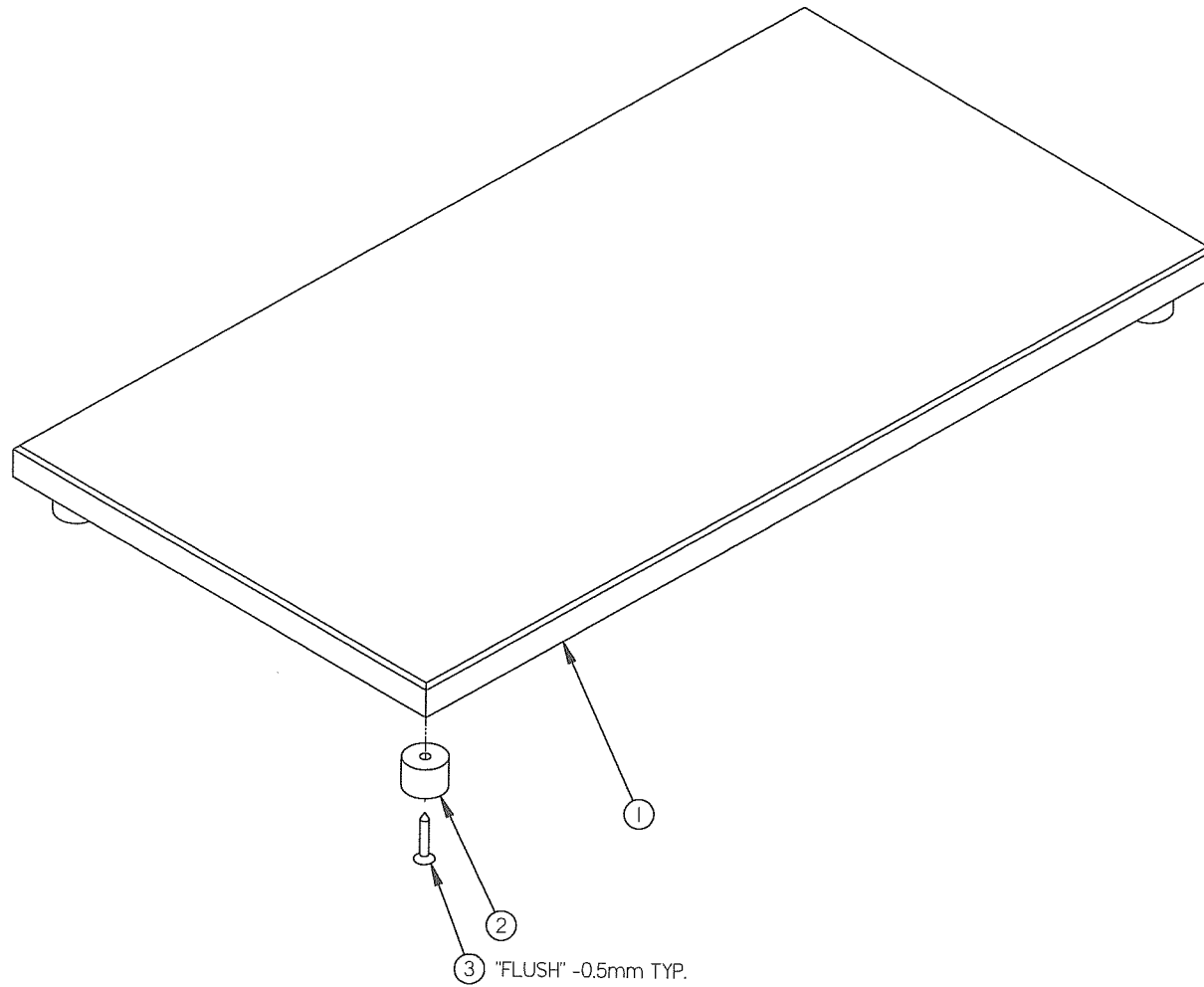


| | | | |
|------|------------------------|----------|------|
| C | REDESSINE MODIF. A-462 | 12-10-15 | J.G. |
| LET. | MODIFICATION | DATE | INT. |

| | | | | | | | |
|---------|--|-------------------------|--|------------|----------|----------|---|
| MACHINE | | 300 & 350 | | DEPT. TOL. | METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | | HALF FILLER PLATE ASS'Y | | USINAGE | ± 0.1 | ± 0.004" | |
| ITEM | | | | TOLERIE | ± 0.5 | ± 0.020" | |
| MAT. | | | | SOUDEAGE | ± 0.5 | ± 0.020" | N.T.S. |
| APP. BY | | J.G. | | DATE | 12-10-15 | | DEPT. M |
| DATE | | | | | | | QTY. 2 |
| | | | | | | | NO. 005A0364 |

005A0365

| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|---------------------------------|-----|
| 1 | 008A0338 | FILLER PLATE | 1 |
| 2 | 003-0080 | FILLER PLATE FOOT | 4 |
| 3 | 054-0019 | METAL SCREW #10x1"FLAT PHIL S/S | 4 |

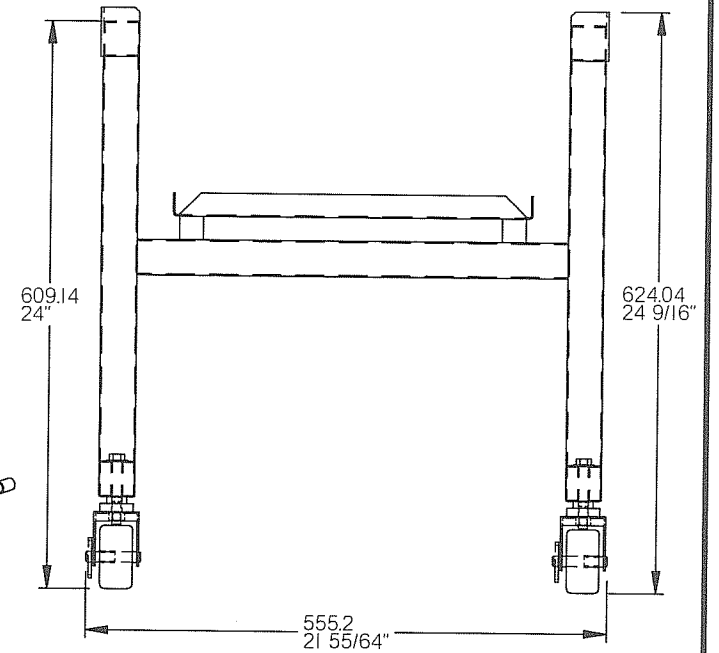
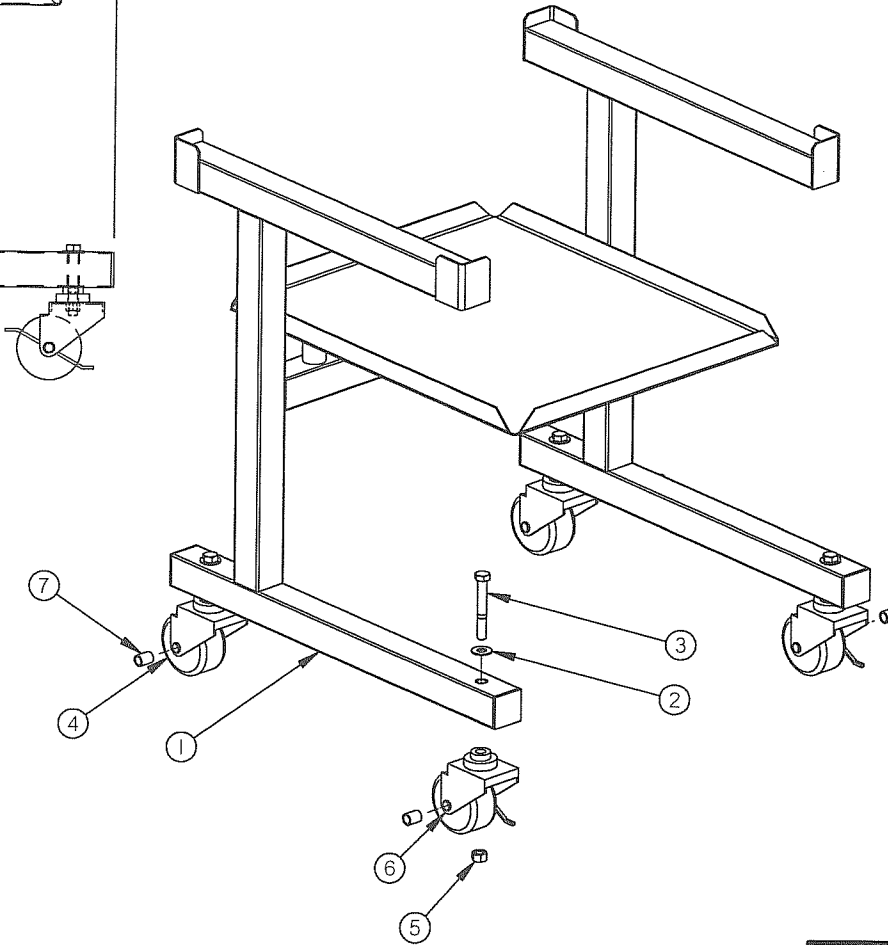
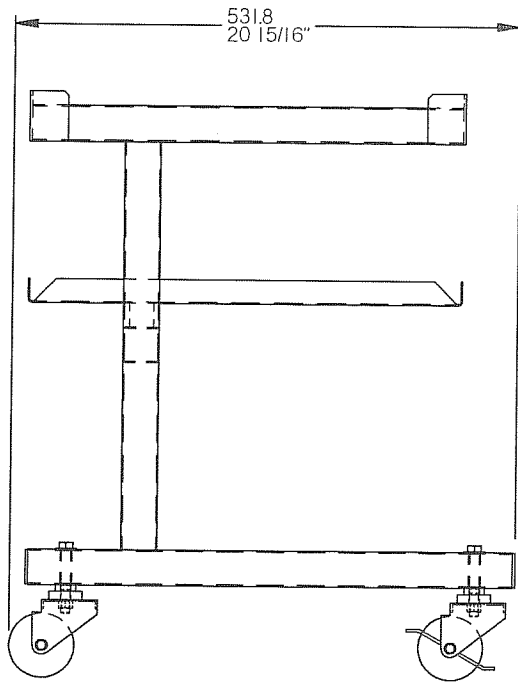


| | | | | | |
|---------|---------------------------|----------------------|------------------------|--------|---|
| MACHINE | 300D & 350D | | DEPT. TOL. METRIC | INCH | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART | FILLER PLATE ASS'Y | | USINAGE ± 0.1 ± 0.004" | N.T.S. | |
| | | | TOLERIE ± 0.5 ± 0.020" | | |
| ITEM | CNC | DEPT. | M | QTY. | 2 |
| MAT. | DWG BY J.G. | DATE 12-10-15 | NO. 005A0365 | | |
| | APP. BY | DATE | | | |

| | | | |
|------|------------------------|----------|------|
| C | REDESSINE MODIF. A-462 | 12-10-15 | J.G. |
| LET. | MODIFICATION | DATE | INT. |

1005B1031

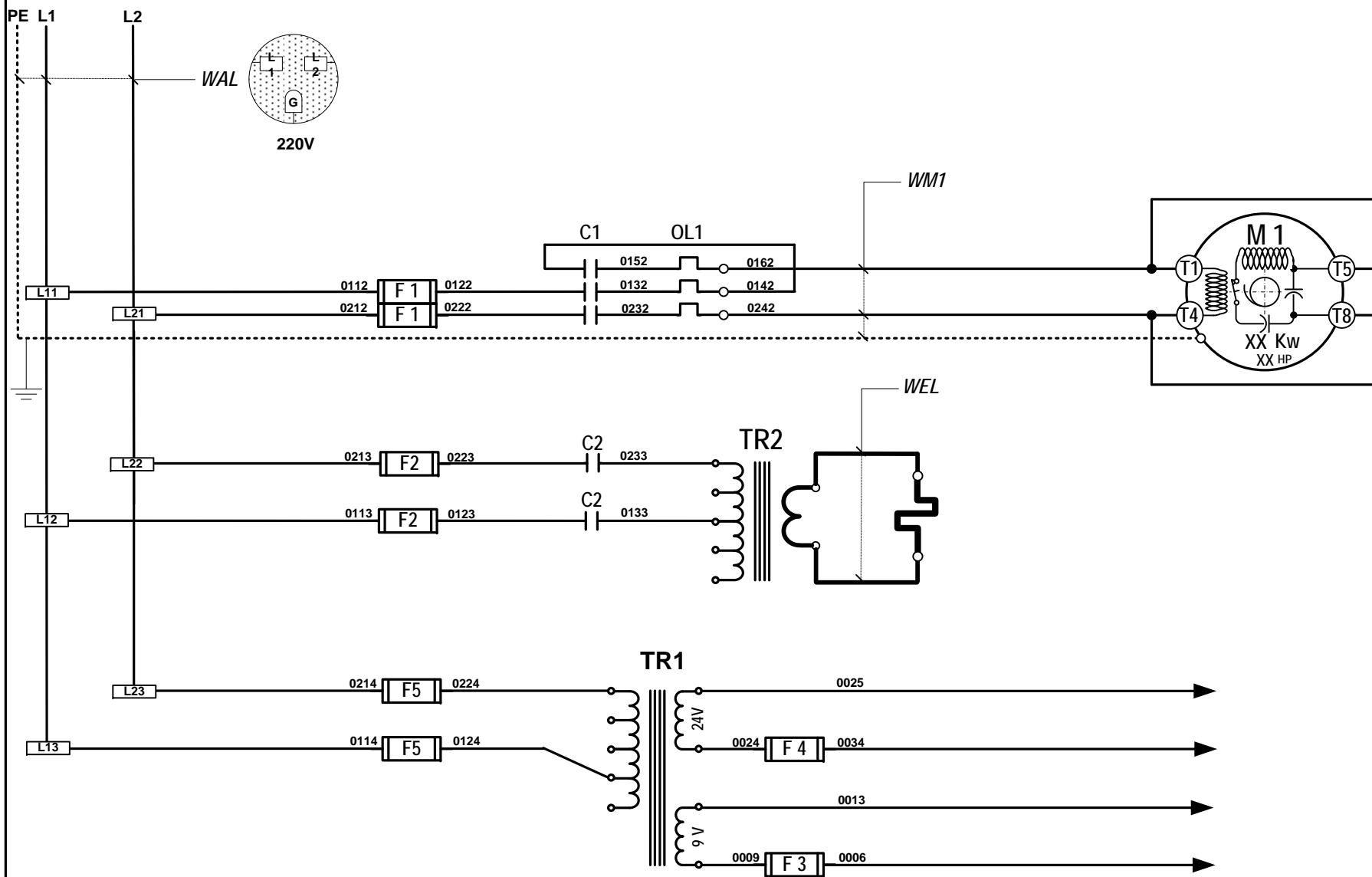
| ITEM | PART # | DESCRIPTION | QT. |
|------|----------|----------------------------------|-----|
| 1 | 005B1347 | STAND PRE-ASS'Y (SHELF) | 1 |
| 2 | 051-0780 | WASHER 3/8" FLAT S/S | 4 |
| 3 | 051-0410 | BOLT 3/8"-nc. X 2.75" S/S | 4 |
| 4 | 130-0190 | PL. CASTER SWIVEL W/OUT BRAKE | 2 |
| 5 | 051-0620 | NUT 3/8"-16 NC S/S | 4 |
| 6 | 130-0195 | PL. CASTER SWIVEL W/BRAKE | 2 |
| 7 | 075-0040 | BUSHING 3/8" x 1/2" x 5/8" PLAIN | 4 |




-STAND OPTION-

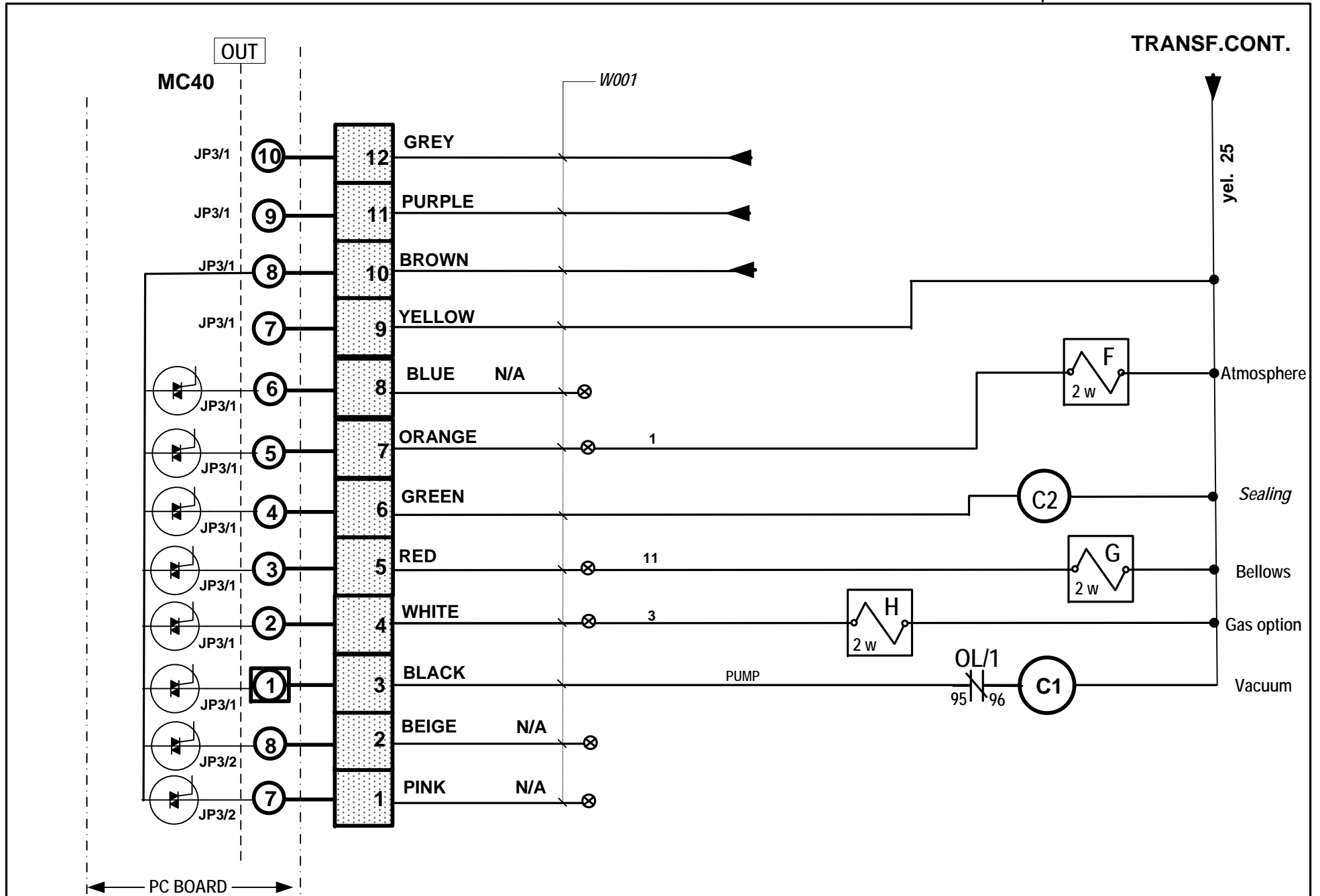
| | | | |
|---|--|---------------------------------------|---|
| MACHINE 300, 300D, 350 & 350D | DEPT. TOL. METRIC USINAGE ± 0.1 TOLERIE ± 0.5 SOUJAGE ± 0.5 | INCH ± 0.004 ± 0.020 ± 0.020 | SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA |
| PART STAND ASSEMBLY | N.T.S. | | |
| TEM _____ | CNC _____ | DEPT. M-(I) | QTY. 1 |
| MAT. _____ | DWG BY J.G. | DATE 12-10-15 | NO. 005B1031 |
| | APP. BY _____ | DATE _____ | |

| | | | |
|------|-------------------------|----------|------|
| E | REDESSINE MODIF. #A-462 | 12-10-15 | J.G. |
| LET. | MODIFICATION | DATE | INT. |

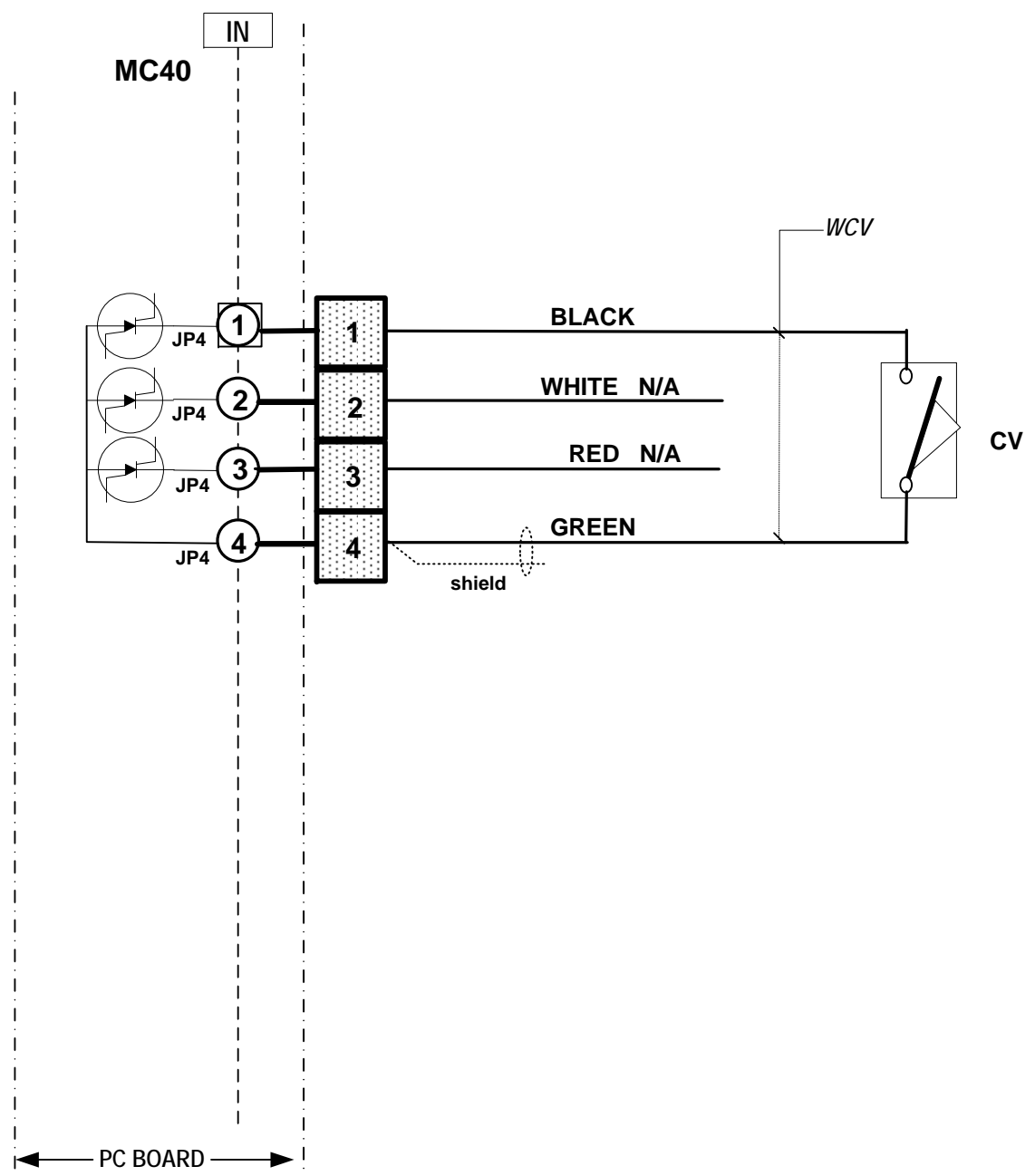


 All unmarked wires are caliber #14 AWG. (006-0200 page 1)

| | | | | | | | | |
|-----------------|-------------|-------|-----|---------------|---------------|-------|-----|--|
| category | VACUUM PACK | model | 350 | volt. | 220V 1Ph 60Hz | | | SIPROMAC St-Germain de Grantham QUEBEC, CANADA |
| system | MC-40 | | | circuit power | year | month | day | |
| usual functions | | | | | 05 | 04 | 25 | |
| options | | | | | concept | draw | app | |
| | | | | | PP | PP | DL | 006-0200 PAGE 1 de 1 |



| | | | | | | | | | | |
|-----------------|-------------|---------|---------|-------|-------|-----|-------|----------|--|-------------|
| category | VACUUM PACK | model | 350 | volt. | ALL | | | | SIPROMAC St-Germain de Grantham QUEBEC, CANADA | |
| system | MC-40 | circuit | control | year | month | day | block | | | |
| usual functions | | | | 10 | 07 | 08 | | concept | draw | app |
| options | | | | XX | PP | DL | | 006-0237 | | PAGE 1 de 2 |



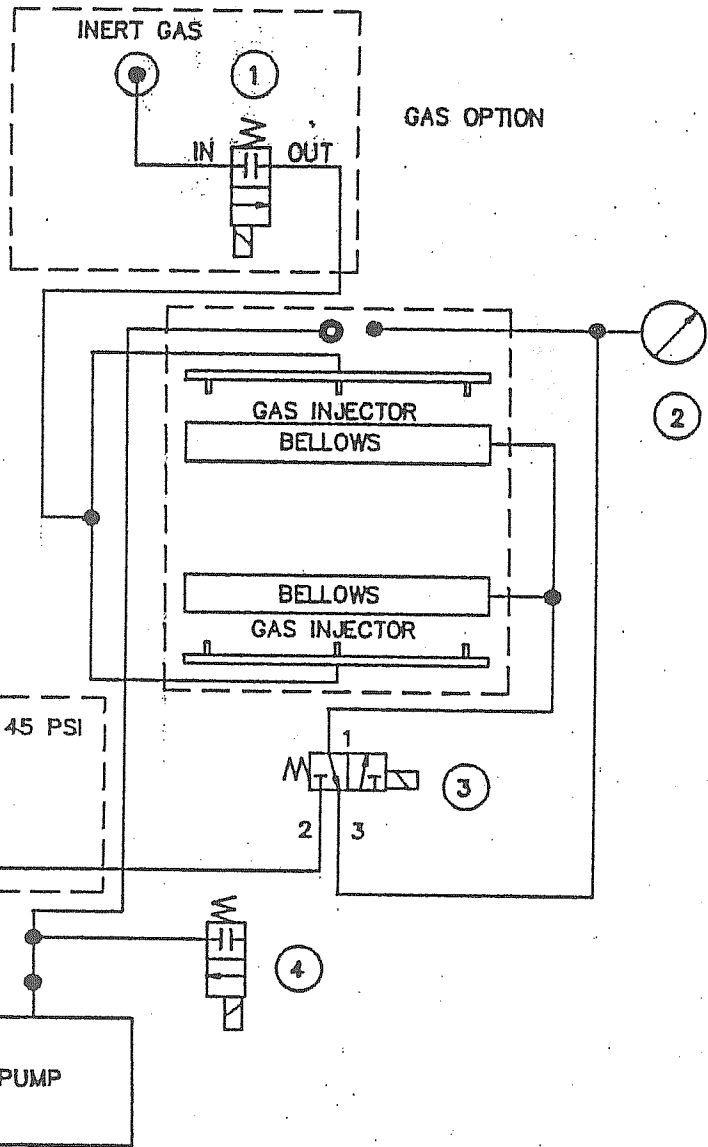
| | | | | | | | | |
|--------------------|-------------|---------|---------|---------|-------|-----|----------------------|--|
| category | VACUUM PACK | model | 350 | volt. | ALL | | | |
| system | MC-40 | circuit | control | year | month | day | block | SIPROMAC St-Germain de Grantham QUEBEC, CANADA |
| usual fonctions | | | | 10 | 07 | 08 | | |
| options | | | | concept | draw | app | 006-0237 PAGE 2 de 2 | |
| | | | | XX | PP | DL | | |

| # SIPO | PART DESCRIPTION | PART APPLICATION | MACHINE VOLTAGE | MACHINE | REF. | OPT. | QTY |
|-----------|--|---------------------|--------------------|---------|-----------|------|-------|
| 036-1500 | MALE PLUG 15 AMP./ 125 V. | SUPPLY | 120V/1PH/60HZ | 350 | GND-L1-N | | 1 |
| 030-0120 | CAB TIRE | SUPPLY | 120V/1PH/60HZ | 350 | GND-L1-N | | 3 M. |
| 028-0105 | GROUND BARRIER (6 HOLES) | SUPPLY | ALL | 350 | GND | | 1 |
| 034-0755 | FUSE HOLDER 30A 1 PÔLE | VACUUM KB-20 | 120V/1PH/60HZ | 350 | F1 | | 1 |
| 034-0530 | FUSE MIDGET 20A/250V TIME-DELAY | VACUUM KB-20 | 120V/1PH/60HZ | 350 | F1 | | 1 |
| 025-0030 | MOTOR CONTACTOR 1HP IN 120V-CSA,UL | VACUUM KB-20 | 120V/1PH/60HZ | 350 | C1 | | 1 |
| 025-0190 | THERMAL OVERLOAD 12 TO 18A-CSA,UL | VACUUM KB-20 | 120V/1PH/60HZ | 350 | O/L1 | | 1 |
| 030-0430 | TEW #14/41 BLACK | VACUUM KB-20 | 120V/1PH/60HZ | 350 | WM1 | | 1M. |
| 030-0440 | TEW #14/41 GREEN | VACUUM KB-20 | 120V/1PH/60HZ | 350 | WM1 | | 0.5M. |
| 125-1020 | VACUUM PUMP 110-120V/1PH/60HZ 0.75KW 13A | VACUUM KB-20 | 120V/1PH/60HZ | 350 | M1 | | 1 |
| 034-0755 | FUSE HOLDER 30A 1 PÔLE | SEALING | 120V/1PH/60HZ | 350 | F2 | | 1 |
| 034-0450 | FUSE MIDGET 7A/250V TIME-DELAY | SEALING | 120V/1PH/60HZ | 350 | F2 | | 1 |
| 025-0020 | CONTACTOR ITH=25A-CSA,UL | SEALING | 120V/1PH/60HZ | 350 | C2 | | 1 |
| 029-0014 | TRANSFO 250VA, 120V/24V 60HZ | SEALING | 120V/1PH/60HZ | 350 | TR2 | | 1 |
| 027-0220 | TERMINAL ROUND STUD #10 600v 75°C | SEALING | ALL | 350 | WEL | | 2 |
| 030-0410 | TEW #10/104 BLACK | SEALING | ALL | 350 | WEL | | 1.5M. |
| 027-0065 | TERMINAL FLAG FEMALE YELLOW .250" | SEALING | ALL | 350 | WEL | | 2 |
| 005A0046 | SEAL BAR ASSEMBLY W/SUPPORT | SEALING TWIN SEAL | ALL | 350 | | A1 | 1 |
| 005A0558 | SEAL BAR ASSEMBLY W/SUPPORT | SEALING BAG CUT | ALL | 350 | | A2 | 1 |
| 034-0740 | FUSE HOLDER M4/8SF | CONTROL TRANSFO | 120V/1PH/60HZ | 350 | F5 | | 1 |
| 034-0200 | FUSE 5X20MM 3/4A 250V T-DELAY | CONTROL TRANSFO | 120V/1PH/60HZ | 350 | F5 | | 1 |
| 029-0008 | TRANSFO 65VA/120V/24-9V | CONTROL TRANSFO | 120V/1PH/60HZ | 350 | TR1 | | 1 |
| 034-0740 | FUSE HOLDER M4/8SF | CONTROL 9VAC+24VAC | ALL | 350 | F3+F4 | | 2 |
| 034-0210 | FUSE 5X20MM 2A/250V TIME DELAY | CONTROL 9VAC | ALL | 350 | F3 | | 1 |
| 034-0240 | FUSE 5X20MM 4A/250V TIME DELAY | CONTROL 24VAC | ALL | 350 | F4 | | 1 |
| 030-0590 | 20AWG/12COND.PVC,UNSHIELD.300V | OUTPUT CONTROL | ALL | 350 | W001 | | 1M. |
| 036-0740 | 12 CONTACTS CONNECTOR | OUTPUT CONTROL | ALL | 350 | JP3/1-2 | | 1 |
| 030-0631 | 22AWG/4COND.PVC,SHIELDED,300V. | INPUT CONTROL | ALL | 350 | WCV | | 2M. |
| 036-0820 | 0.156" CENTERLINE CRIMP HOUSING | INPUT CONTROL | ALL | 350 | JP4 | | 1 |
| 036-0850 | 0.156" CENTERLINE CRIMP TERMINAL | INPUT CONTROL | ALL | 350 | JP4 | | 2 |
| 033-0038 | MICROPROCESSOR MC-40 SENSOR VACUUM | CONTROL WITH SENSOR | ALL | 350 | MC-40 | B1 | 1 |
| 033-00385 | MICROPROCESSOR MC-40 NO SENSOR VAC. | CONTROL W/O SENSOR | ALL | 350 | MC-40 | B2 | 1 |
| 033-0015 | MEMBRANE MC-40 SIPROMAC | CONTROL SIPROMAC | ALL | 350 | | C1 | 1 |
| 033-0018 | MEMBRANE MC-40 BERKEL | CONTROL BERKEL | ALL | 350 | | C2 | 1 |
| 106-0020 | VALVE 2WAY 24V 1/2 NPT(G94) 60HZ | ATMOSPHERE | ALL | 350 | F | | 1 |
| 106-0070 | VALVE 3WAY 24V 1/4 NPT(G176)60HZ | BELLOWS | ALL | 350 | G | | 1 |
| 106-0010 | VALVE 2WAY 24V 1/4 NPT(G22) 60HZ | OPTION GAS | ALL | 350 | H | D | 1 |
| 004-0261 | LIMIT SWITCH ASSY 15A 250V | COVER POSITION | ALL | 350 | CV | | 1 |
| 036-1512 | MALE PLUG 15 AMP./ 250 V. | SUPPLY | 220V/1PH/60HZ | 350 | GND-L1-L2 | | 1 |

| # SIPO | PART DESCRIPTION | PART APPLICATION | MACHINE VOLTAGE | MACHINE | REF. | OPT. | QTY |
|-----------|---|---------------------|--------------------|---------|-----------|------|-------|
| 030-0160 | CAB TIRE | SUPPLY | 220V/1PH/60HZ | 350 | GND-L1-L2 | | 3 M. |
| 028-0105 | GROUND BARRIER (6 HOLES) | SUPPLY | ALL | 350 | GND | | 1 |
| 034-0755 | FUSE HOLDER 30A 1 PÔLE | VACUUM KB-20 | 220V/1PH/60HZ | 350 | F1 | | 2 |
| 034-0500 | FUSE MIDGET 15A/250V TIME-DELAY | VACUUM KB-20 | 220V/1PH/60HZ | 350 | F1 | | 2 |
| 025-0010 | MOTOR CONTACTOR 1HP IN 220V MONO-CSA,UL | VACUUM KB-20 | 220V/1PH/60HZ | 350 | C1 | | 1 |
| 025-0160 | THERMAL OVERLOAD 5.5 TO 8A-CSA,UL | VACUUM KB-20 | 220V/1PH/60HZ | 350 | O/L1 | | 1 |
| 030-0430 | TEW #14/41 BLACK | VACUUM KB-20 | 220V/1PH/60HZ | 350 | WM1 | | 1M. |
| 030-0440 | TEW #14/41 GREEN | VACUUM KB-20 | 220V/1PH/60HZ | 350 | WM1 | | 0.5M. |
| 125-1021 | BUSCH KB-0020 220-240V/1PH/60HZ 0.75KW 6.5A | VACUUM KB-20 | 220V/1PH/60HZ | 350 | M1 | | 1 |
| 034-0755 | FUSE HOLDER 30A 1 PÔLE | SEALING | 220V/1PH/60HZ | 350 | F2 | | 2 |
| 034-0445 | FUSE MIDGET 5A/250V TIME-DELAY | SEALING | 220V/1PH/60HZ | 350 | F2 | | 2 |
| 025-0020 | CONTACTOR ITH=25A-CSA,UL | SEALING | 220V/1PH/60HZ | 350 | C2 | | 1 |
| 029-0018 | TRANSFO 250VA 220V/24V 50/60HZ | SEALING | 220V/1PH/60HZ | 350 | TR2 | | 1 |
| 027-0220 | TERMINAL ROUND STUD #10 600v 75°C | SEALING | ALL | 350 | WEL | | 2 |
| 030-0410 | TEW #10/104 BLACK | SEALING | ALL | 350 | WEL | | 1.5M. |
| 027-0065 | TERMINAL FLAG FEMALE YELLOW .250" | SEALING | ALL | 350 | WEL | | 2 |
| 005A0046 | SEAL BAR ASSEMBLY W/SUPPORT | SEALING TWIN SEAL | ALL | 350 | | A1 | 1 |
| 005A0558 | SEAL BAR ASSEMBLY W/SUPPORT | SEALING BAG CUT | ALL | 350 | | A2 | 1 |
| 034-0740 | FUSE HOLDER M4/8SF | CONTROL TRANSFO | 220V/1PH/60HZ | 350 | F5 | | 2 |
| 034-0200 | FUSE 5X20MM 3/4A 250V T-DELAY | CONTROL TRANSFO | 220V/1PH/60HZ | 350 | F5 | | 2 |
| 029-0007 | TRANSFO 65VA/220-230-460V/24-9 | CONTROL TRANSFO | 220V/1PH/60HZ | 350 | TR1 | | 1 |
| 034-0740 | FUSE HOLDER M4/8SF | CONTROL 9VAC+24VAC | ALL | 350 | F3+F4 | | 2 |
| 034-0210 | FUSE 5X20MM 2A/250V TIME DELAY | CONTROL 9VAC | ALL | 350 | F3 | | 1 |
| 034-0240 | FUSE 5X20MM 4A/250V TIME DELAY | CONTROL 24VAC | ALL | 350 | F4 | | 1 |
| 030-0590 | 20AWG/12COND.PVC,UNSHIELD.300V | OUTPUT CONTROL | ALL | 350 | W001 | | 1M. |
| 036-0740 | 12 CONTACTS CONNECTOR | OUTPUT CONTROL | ALL | 350 | JP3/1-2 | | 1 |
| 030-0631 | 22AWG/4COND.PVC,SHIELDED,300V. | INPUT CONTROL | ALL | 350 | WCV | | 2M. |
| 036-0820 | 0.156" CENTERLINE CRIMP HOUSING | INPUT CONTROL | ALL | 350 | JP4 | | 1 |
| 036-0850 | 0.156" CENTERLINE CRIMP TERMINAL | INPUT CONTROL | ALL | 350 | JP4 | | 2 |
| 033-0038 | MICROPROCESSOR MC-40 SENSOR VACUUM | CONTROL WITH SENSOR | ALL | 350 | MC-40 | B1 | 1 |
| 033-00385 | MICROPROCESSOR MC-40 NO SENSOR VAC. | CONTROL W/O SENSOR | ALL | 350 | MC-40 | B2 | 1 |
| 033-0015 | MEMBRANE MC-40 SIPROMAC | CONTROL SIPROMAC | ALL | 350 | | C1 | 1 |
| 033-0018 | MEMBRANE MC-40 BERKEL | CONTROL BERKEL | ALL | 350 | | C2 | 1 |
| 106-0020 | VALVE 2WAY 24V 1/2 NPT(G94) 60HZ | ATMOSPHERE | ALL | 350 | F | | 1 |
| 106-0070 | VALVE 3WAY 24V 1/4 NPT(G176)60HZ | BELLOWS | ALL | 350 | G | | 1 |
| 106-0010 | VALVE 2WAY 24V 1/4 NPT(G22) 60HZ | OPTION GAS | ALL | 350 | H | D | 1 |
| 004-0261 | LIMIT SWITCH ASSY 15A 250V | COVER POSITION | ALL | 350 | CV | | 1 |

007-0022

-NOTE:
 -FOR GAS INJECTION
 KIT INSTALLATION
 SEE DRAWING #:
 350: #010-0015
 350D: #010-0026



| ITEM | PART # | DESCRIPTION | QT. |
|----------|----------|----------------------------|-----|
| 1 | 106-0010 | GAS VALVE | 1* |
| 2 | 114-0260 | VACUUM GAUGE | 1 |
| 3 | 106-0070 | BELLOWS VALVE | 1 |
| 4 | 106-0020 | ATMOSPHERE VALVE | 1 |
| 5 | 114-0147 | PRESSURE REGULATOR | 1* |
| 6 | 114-0245 | PRESSURE GAUGE | 1* |
| 7 | 114-0170 | PRESSURE REGULATOR SUPPORT | 1* |
| * OPTION | | | |

-NOTE:
 -FOR AIR REGULATOR
 OPTION KIT INSTALLATION
 SEE DRAWING #:
 350 & 350D: 010-0030

| | | | | |
|---------|------------------|---------------|---|-------|
| MACHINE | 350 & 350D | | SIPROMAC | |
| PART | PNEUMATIC | | ST-GERMAIN DE GRANTHAM QUEBEC CANADA | |
| ITEM: | CNC: | SCALE | | QT. 1 |
| MAT: | DRG BY M.LAVIGNE | DATE 97-03-11 | NO. 007-0022 | |
| LET. | MODIFICATION | DATE | INT. | |

MANUEL D'UTILISATEUR

MICROPROCESSEUR MC-40

AVEC OU SANS DÉTECTEUR DE VIDE

EMBALLEUSE SOUS VIDE

TABLE DES MATIÈRES

I INSTRUCTIONS POUR LES OPÉRATIONS

II MÉCANIQUE

- A- Vue de face
- B- Vue de l'arrière
- C- Procédure d'ajustement du couvert
- D- Schéma de l'assemblage de l'axe central
- E- Barres de scellage
(Double scellage)
- F- Dessin des barres de scellage
(Option du coupe sac électrique)
- G- Dessins des barres d'assemblage
(Scellage du haut et du bas en option)
- H- Gas injection kit installation drawing
(gaz injection option)

III ELECTRIQUE

- A- Schéma électrique (Bas voltage)
- B- Schéma électrique (Haut voltage à une phase)
- C- Schéma électrique (Haut voltage à 3 phases)
- D- Schéma électrique (Haut voltage 1 phase 50 Hz)
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IV PNEUMATQUE

- A- Schéma Pneumatique

EMBALLEUSES SOUS VIDE INSTRUCTIONS D'OPÉRATIONS

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2. Connexion Électrique
3. Opération
 - 3.1 Principes de travail
 - 3.2 Emballage Spécial
 - 3.2.1 Injection de Gaz
 - 3.2.2 Scellage haut et bas
(bi-active sealing)
 - 3.2.3 Coupe sac électrique
 - 3.3 Ajustement des contrôles digital
 - 3.4 Nettoyage Quotidien
4. Trouble de lancement
 - 4.1 Échec durant le cycle d'emballage
 - 4.2 Vide insuffisant
 - 4.2.1 Fuites dans le sac
 - 4.2.2 Pas de fuite dans le sac
 - 4.2.3 Vide insuffisant dans la chambre
 - 4.3 Scellage Inadéquat
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 - 4.3.2 Pas de scellage
 - 4.3.3 Courant ininterrompu sur les barres de scellage
 - 4.3.4 Le scellage ne tient pas
 - 4.4 Problème avec les valves
 - 4.5 Problème du panneau de contrôle
5. Maintenance Régulière

SIPROMAC INC. EMBALLEUSES SOUS VIDE

1. MISE EN PLACE DE LA MACHINE:

Avant de choisir le site d'installation de votre machine, veuillez considérer que vous aurez besoin d'espace pour les produits emballés et non-emballés à part de l'espace occupé par la machine elle-même.

Bien vouloir vous rappelez que vous aurez besoin d'un sol bien au niveau pour votre installation. Spécialement avec les modèles mobiles, le poids de la pompe peut gauchir la machine et le couvercle ne fermera plus correctement.

Avant de commencer à travailler, vérifier l'huile de la pompe pour voir si elle est en quantité suffisante. Bien vouloir ne jamais utiliser une huile autre que celle recommandée par le fabricant. Ne pas excéder la quantité indiquée quand vous ajoutez ou faites le changement d'huile et faites votre vérification hebdomadairement.

En raison de la viscosité de l'huile, la machine sera plus difficile à démarrer à basses températures. Ainsi donc la pompe doit être placée dans un endroit où la température est d'au moins 50°F (+10°C). D'autre part, l'air doit circuler librement aux alentours de la pompe pour permettre le refroidissement dans les cas où la température des opérations atteindrait 160°F (70°C) ou la température maximale permise.

2. CONNEXION ÉLECTRIQUE:

Les connexions électriques doivent se faire par du personnel qualifié. La personne désignée doit s'assurer que les entrées électriques correspondent au voltage et à l'ampérage approprié de la machine.

Un schéma électrique accompagne chacune de nos machines.

Une étape importante dans le branchement de la machine est de s'assurer que le moteur de la pompe tourne dans une rotation appropriée.

Attention: Le moteur de la pompe ne devrait pas tourner plus de 3 ou 4 secondes dans une mauvaise rotation car il en résultera des dommages sérieux. La rotation est indiquée par une flèche sur le moteur de la pompe.

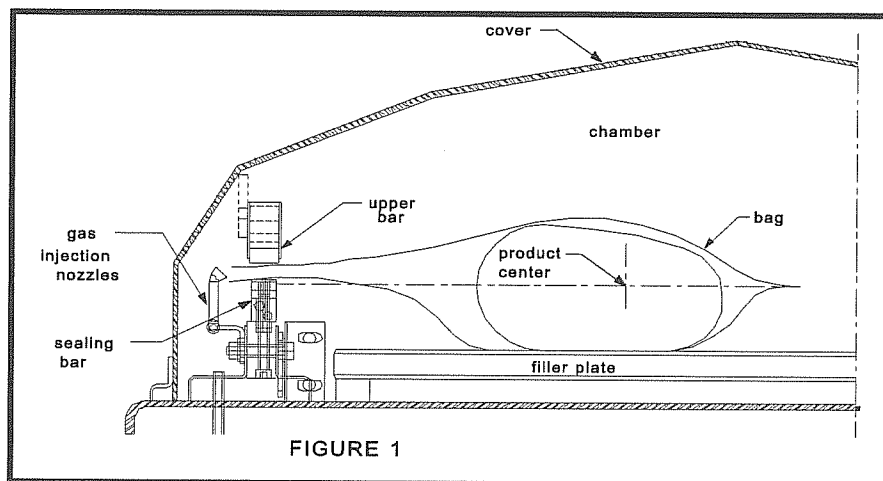
3. OPÉRATION:

3.1 Principes de travail:

Un emballage sous vide est un cycle composé de 3 étapes. Premièrement le vide est fait et l'air est complètement enlevé de la chambre et du sac contenant le produit. (Voir figure 1). Ensuite c'est possible d'injecter du gaz neutre par les conduits si le produit est très délicat. Finalement, un mécanisme pousse la barre de scellage sur le support de caoutchouc pour sceller le sac

Pour obtenir de beaux emballages, les produits et les sacs doivent être de taille proportionnelles. L'ouverture du sac ne devrait jamais excéder 2" (50cm) au delà des barres de scellage. Le produit doit être centré en hauteur par rapport aux barres de scellage en ajustant les écarteurs qui vous sont fournis.

Pour obtenir un bon scellage, assurez-vous qu'il n'y a pas de résidu de graisse qui reste entre les côtés intérieurs des sacs où le scellage doit être fait.



3.2 Emballage Spécial:

3.2.1 Injection de Gaz (option):

Il y a une pression atmosphérique de 14 lbs / pouce carré (= 1 kg / cm carré) sur les produits quand le vide demandé est atteint. Les produits qui peuvent être endommagés par une haute pression doivent être emballés avec un vide partiel et la pression doit être contrebalancée en injectant du gaz dans le sac (nitrogène ou dioxyde de carbone) avant le scellement et après avoir atteint le vide.

Pour l'injection de gaz, les sacs sont placés sur les barres de scellage, l'ouverture placée au dessus des conduits de gaz qui sont montés le long des barres de scellage. Après que le vide soit atteint, la valve du vide se ferme et la valve du gaz s'ouvre. Le pourcentage de gaz peut être ajusté par le menu du programme.

Le réservoir de gaz et la valve de pression qui est rattachée au réservoir ne sont pas fournis par Sipromac. La pression pour le régulateur de gaz devrait être ajustée approximativement à 5 lbs/pouce carré (1/3 Kg/cm carré). Chaque machine a un adaptateur pour la connexion de gaz quand l'option de l'injection de gaz est commandée.

3.2.2 Scellage Haut et Bas (optionnel):

Pour le scellage des sacs en aluminium comme pour le café il est impératif d'avoir une barre de scellage en haut et en bas.

3.2.3 Coupe sac électrique: (optionnel):

Cette option est utilisée pour obtenir un paquet dont l'excédent de film au niveau du scellage doit être coupée très près de la ligne de scellage. (cette option ne peut pas être utilisée avec le scellage Haut et Bas)

3.3 Les opérations de l'emballage sous vide:

Note: Reportez-vous aux menus structure de la page 8 et aux détails du panneau de contrôle sur la page 9

3.3.1 Bases:

Utilisez la touche "POWER" pour initier le bouton ON/OFF sur votre machine sous vide. Quand votre unité sera en fonction le dernier programme exécuté apparaîtra sur l'écran à cristaux liquides.

Utilisez la touche "ESC" pour passer du menu programme au menu fonctions et du menu des fonctions au menu des programmes.

Dans le menu des fonctions, utilisez la touche "SELECT" pour sélectionner une fonction et la touche "ENTER" pour exécuter la sélection.

Dans le menu des programmes, utilisez la touche "SELECT" pour sélectionner un programme et la touche "Enter" pour accéder ou modifier la sélection.

Dans les programmes du sous menu, utilisez la touche "ENTER" pour voir défiler les paramètres et lorsque ces derniers clignotent pour indiquer ils sont dans le mode d'acquisition. Quand la séquence de tous les paramètres se sont affichés, on revient automatiquement au début de la liste.

Dans les programmes du sous menu, utilisez la touche "ESC" pour revenir au menu des programmes. Pressez n'importe quelle touche pour effacer les messages d'erreur qui peuvent s'afficher sur l'écran à cristaux liquide.

3.3.2 Menu des fonctions:

3.3.2.1 Créer un programme:

Quand vous exécutez la fonction "create a program", le programme sous menu est atteint en commençant par l'identification. L'identification initiale "PxxNO NAME" est donné au programme et tous les paramètres sont établis à zéro; le numéro du programme est alloué automatiquement.

3.3.2.2 Supprimer un programme:

En exécutant la fonction de "delete a program", vous avez accès au menu des programmes et le numéro du premier programme en mémoire clignote pour indiquer le mode de suppression. Utilisez la touche "SELECT" pour sélectionner un programme et la touche "ENTER" pour avoir accès et confirmer la suppression de la sélection. Utilisez la touche "ESC" pour annuler une suppression et quitter la fonction. Quand vous quittez la fonction, le nombre des programmes actuels sur l'écran à cristaux liquides cesse de clignoter.

3.3.2.3 Choisir le mode d'opération:

Quand vous exécutez la fonction "Select Operating Mode", laquelle est disponible seulement pour les unités automatiques, la sélection en cours clignote pour vous indiquez le mode. Utilisez la touche "SELECT" pour parcourir les modes d'opération, lesquels sont automatiques, semi-automatiques et manuels.

Le mode d'opération sera validé et exécuté automatiquement. Utilisez la touche "ESC" ou "ENTER" pour quitter la fonction et retourner au menu des programmes.

3.3.3 Menu des Programmes:

3.3.3.1 Identification des Programmes:

Pour un programme sélectionné, choisissez l'identification en utilisant le panneau de contrôle numérique avec la chartre des caractères et pressez sur la touche numérique jusqu'à ce que le caractère soit sélectionné (4 x pour la valeur numérique). Utilisez la touche "ENTER" pour valider le caractère ainsi que la chaîne de caractères jusqu'à la fin (la nouvelle chaîne de caractères clignote). Vous pouvez utiliser la touche "ESC" pour revenir en arrière dans le cas où vous vous êtes trompé et que vous voulez effacer le caractère.

Exemple: EXAMPLE 1 → Touche 2, 2, ENTER → E
(9 caractères) Touche 8, 8, 8, ENTER → X
Touche 1, ENTER → A
Touche 5, ENTER → M
Touche 6, ENTER → P
Touche 4, 4, 4, ENTER → L
Touche 2, 2, ENTER → E
Touche 9, 9, 9, ENTER → espace
Touche 1, 1, 1, 1, ENTER → 1
Touche ENTER pour valider la chaîne de caractères

3.3.3.2 L'ajustement du niveau de Vide (capteur de vide désactivé):

Pour un programme sélectionné, ajustez le niveau de vide, en secondes; la validation est automatiquement exécutée après la deuxième entrée digitale (Le nouveau temps de vide clignote). En cours de traitement, utilisez la touche "ENTER" pour valider la valeur du niveau de vide et la touche "ESC" pour revenir en arrière et changer la valeur du niveau de vide (La valeur du niveau de vide la plus ancienne clignotera à ce moment).

Exemples: 1 sec. → Touches 0, 1 ou 1, ENTER
15 sec. → Touches 1, 5

3.3.3.3 L'ajustement du niveau de Vide (capteur de vide en activé):

Pour un programme sélectionné, ajustez le niveau de vide avec les valeurs; le point décimal est automatiquement inséré suivant la deuxième entrée digitale et la validation est automatiquement exécutée après la troisième entrée digitale (La nouvelle valeur du niveau du vide clignote). Le niveau de vide est arrondi à la demie la plus près de la valeur. En cours de traitement, utilisez la touche "ENTER" pour valider la valeur du niveau de vide et la touche "ESC" pour revenir en arrière et changer la valeur du niveau de vide (La valeur du niveau de vide la plus ancienne clignotera à ce moment). Ajustez le niveau du vide à zéro pour pouvoir contourner le capteur de vide et procédez en réglant seulement le " Temps de vide Plus" (Vacuum plus time).

Exemples: 90.0% → Touches 9, 0, 0 ou 9, 0, ENTER ou
Touches 9, 0, 1 ou 9, 0, 2 or 9, 0, 3 ou 9, 0, 4
97.5% → Touches 9, 7, 5 ou
Touches 9, 7, 6 ou 9, 0, 7 or 9, 0, 8 ou 9, 0, 9
0.0% → Touches 0, 0, 0 ou 0, ENTER

3.3.3.4 Ajustement du Temps de Vide "Plus" (capteur de vide activé):

Pour un programme sélectionné, réglez le "temps de vide plus" en secondes; la validation est automatiquement exécutée après la deuxième entrée digitale (La nouvelle valeur du "temps de vide plus" clignotera à ce moment). En cours de traitement, utilisez la touche "ENTER" pour valider la nouvelle valeur du "temps de vide plus" et la touche "ESC" pour revenir et recommencer avec de nouvelles valeurs (la valeur la plus ancienne du "temps de vacuum plus" clignotera).

Exemples: 1s → Touche 0, 1 or 1, ENTER
15s → Touche 1, 5

3.3.3.5 Ajustement de l'injection de gaz (capteur de vide désactivé):

Pour sélectionner un programme placer le niveau d'injection de gaz en suivant la même procédure que pour le niveau de vide. Gardez en mémoire que plus le temps d'injection de gaz est haut, moins la pression du sellage sera forte. Un certain niveau de vide doit être maintenu pour un bon fonctionnement.

3.3.3.6 Ajustement de l'injection de gaz (capteur de vide activé):

Pour sélectionner un programme placer le niveau d'injection de gaz en suivant la même procédure que pour le niveau de vide; L'ajustement pour le gaz le plus haut devrait être de 10% au-dessous du niveau de l'ajustement de vide.

3.3.3.7 Ajustement du cachetage:

Pour sélectionner un programme le temps de cachetage, en commençant par les secondes; le point décimale est automatiquement insérée après la première entrée de chiffre et la validation est automatiquement effectuée après la troisième entrée de chiffre (le nouveau temps de cachetage clignote). Le temps de cachetage est arrondi à la moitié la plus proche du cent. À un milieu l'entrée des données, utiliser la clé "ENTER" pour valider l'heure du cachetage et la clé " ESC " pour revenir en arrière et reprogrammer le temps cachetage avec de nouvelles données (le vieux temps de cachetage clignote).

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

3.3.4 Exécution de cycle de vide :

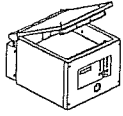
Pour les unités manuels ainsi que les unités automatiques faire la mise en marche manuelle, fermer le couvercle afin de lancer un cycle de vide. Pour l'unité automatique faire mise en marche semi-automatique ou automatique, utilisez le bouton "ARRÊT / DÉBUT" pour lancer ou interrompre un cycle de vide. Le programme sélectionné peut être lancé seulement dans le programme du menu, au moment où aucune modification n'est nécessaire, et l'accès des autres programmes et des fonctions ne sont pas requis. Pendant l'exécution du cycle le statut d'opération est séquentiellement affiché sur l'écran à cristaux liquides, excepté pour les paramètres établis à zéro, qui ne sont pas montrés:

- niveau de vide de la chambre pendant la séquence,
- vide additionné du temps pendant le vide plus la séquence,
- niveau de vide de la chambre pendant la séquence d'injection de gaz,
- statut de temps de cachetage pendant la séquence de cachetage,
- niveau de vide de la chambre pendant La séquence d'atmosphère .7

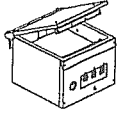
Pendant l'exécution du cycle, utilisé la clef "1" pour interrompre la séquence de vide et pour exécuter la séquence suivante, soit l'injection du gaz ou le cachetage, suivi de la clé "ENTER" afin d'accéder et modifier le programme; les paramètres deviennent valides seulement pour les cycles suivants de vide.

3.3.5 System monitor:

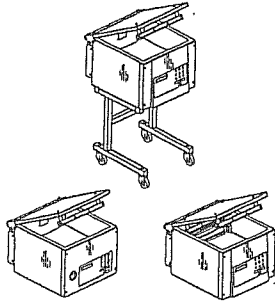
Pour accéder le menu des diagnostics, monter la puissance de la machine d'emballage sous vide tout en maintenant le bouton "ESC" enfoncé. Utilisez la clé "SELECT" pour choisir la fonction du système du moniteur et "ENTER" pour accéder et visualiser les paramètres surveillés. Employez la clé "SELECT" pour changer la révision de logiciel, la quantité d'heures de travail faites et de la quantité de cycles complets exécutés depuis la première initialisation.



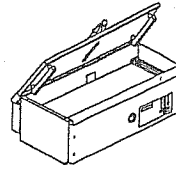
250



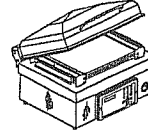
300



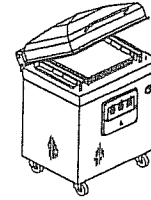
350/350D



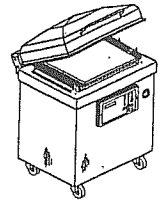
380A



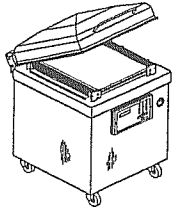
450T



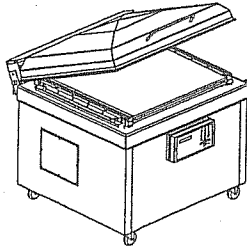
400A



450A

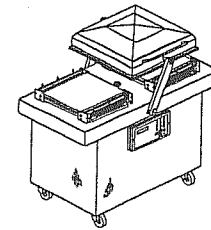


550A

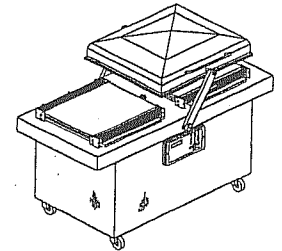


580A

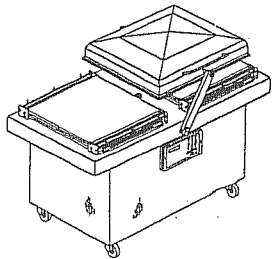
VACUUM PACKAGING MACHINES



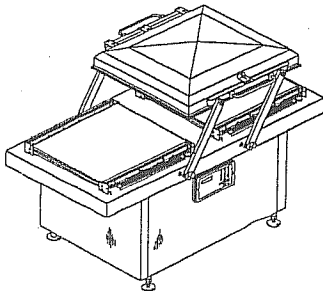
420A



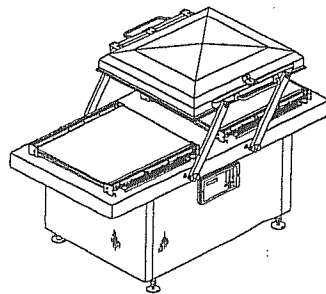
600A



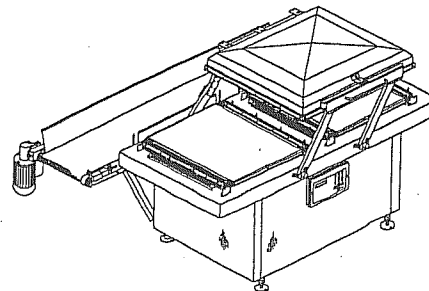
620A



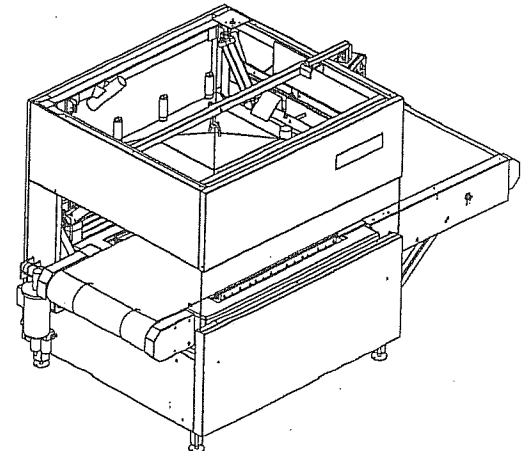
650A



680A



700A



750A