

MODELS

350

350D



VACUUM PACKAGING MACHINE

MODELS 350,350D

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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

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SIPROMAC INC.

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

1. SETTING UP THE MACHINE:

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

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

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

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

2. Con't

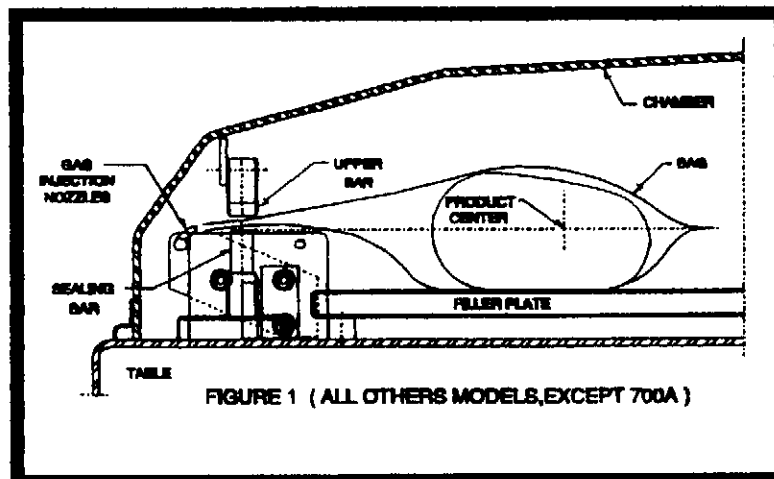
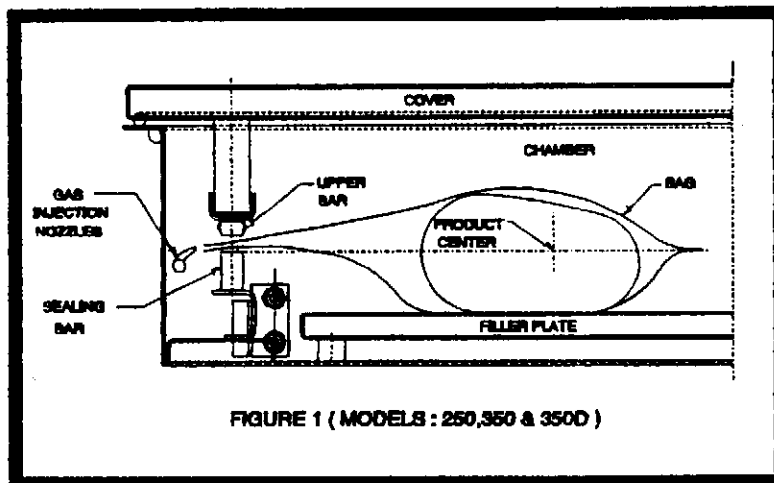
An important step in connecting the machine is to make sure that the pump turns in its correct rotation.

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

3. OPERATION:

3.1 Working principles:

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



3.1 Con't

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

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

3.2 Special packaging:

3.2.1 Gas flushing:

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

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

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

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

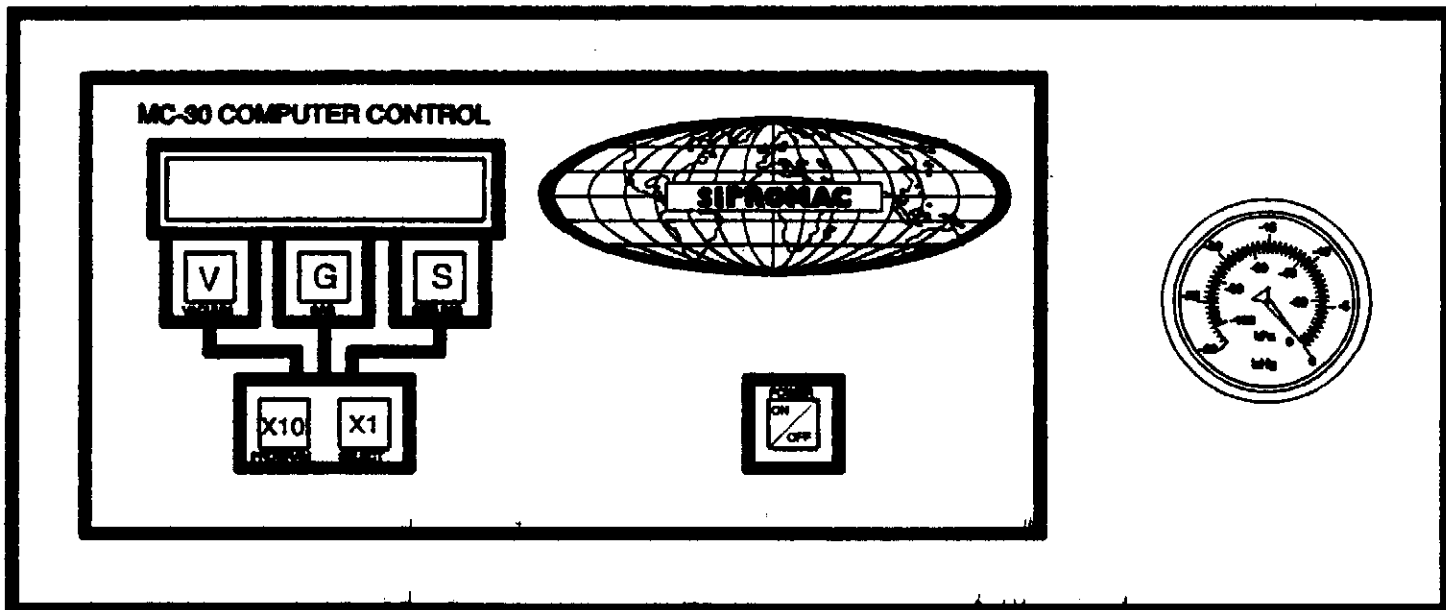
When sealing aluminium laminate bags (especially bags for e.g. coffee) it is imperative to have an upper and a lower sealing bar.

3.2.3 Electrical bag cut:

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

3.3 Setting of digital controls for MC-30E p.c. board:

Control pannel:



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

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

How to program a complete cycle:

To enter the vacuum time (sec.):

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

To enter the gas time (sec.):

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

To enter the sealing time (sec. decimals):

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

3.3 Con't

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

BASIC PROGRAM TO MODIFY ACCORDING TO THE PRODUCTS

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

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

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

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

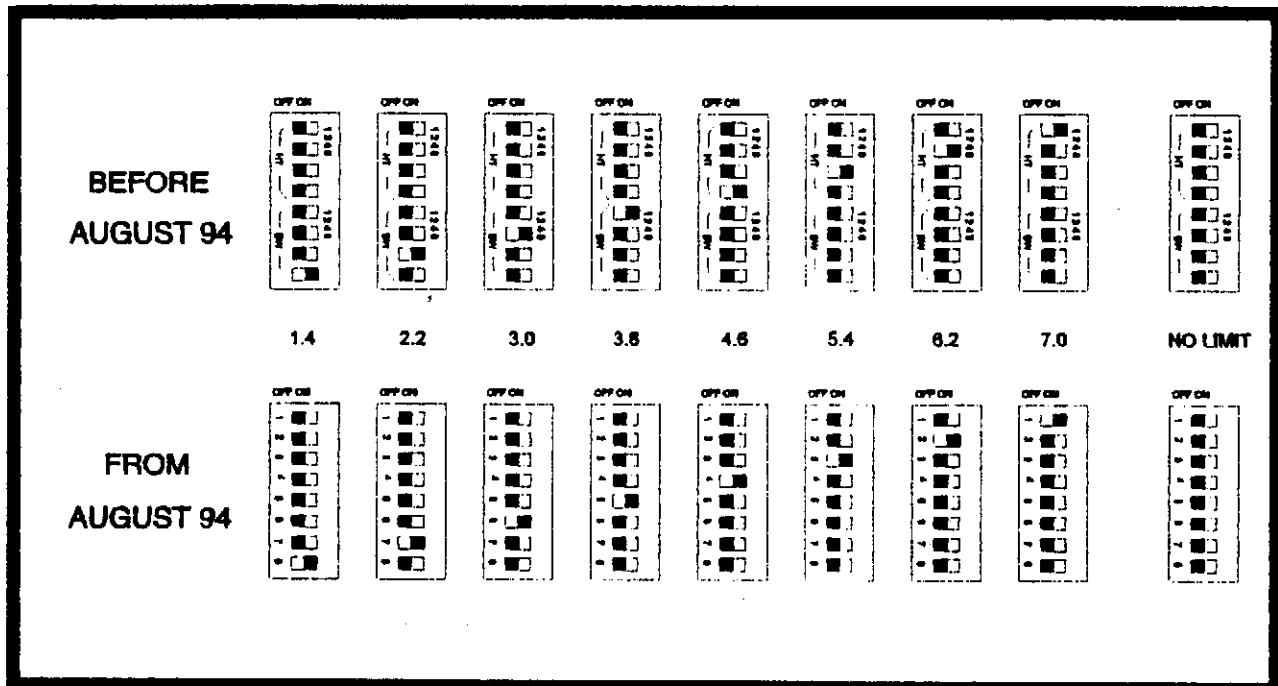
How to use the memories of the MC-30E p.c. board:

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

3.3 Con't

Sealing time security:

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



TIME LIMITS:

Time limit factory settings:

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

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

3.4 Daily cleaning:

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

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

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

4. TROUBLE SHOOTING:

4.1 Failure during a packaging cycle:

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

Micro switch is actuated too late, re-set the micro switch.
Fault in supply of electricity to the timing control (power on light does not go on):

Check input voltage at transformer (faulty contact in wires);
Check secondary voltage of transformer (approx. 24 Volt AC);
Check fuse;

If none of these apply, change the PC board.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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

4.2.2 No leakage in the bag:

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

Evacuation time is too short:

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

4.2.3 Insufficient vacuum in chamber:

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

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

Verify at vacuum hose connections.

Verify valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

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

4.5 Control board failure

PROBLEM	POSSIBLE CAUSE
1. No display switch on	1.1 Programming error Press on/off membrane
	1.2 No current coming to PC board Check fuses Check voltage between pins #6 and #13 on "D" connector, the reading should be approx. 9 volts AC (if not it's due to transformer or wiring defect)
	1.3 On/off key defective membrane Disconnect flat cable between PC board and switch and jump pins 1 and 2 or 7 and 8 using a screw driver
	1.4 Defective PC board Replace PC board
2. Two digits continuously flashes on "V", "G" or "S"	2.1 Programming error Press corresponding "V", "G" or "S" key
	2.2 Defective membrane Replace membrane
	2.3 Defective PC board Replace PC board

4.5 Con't

3. All of the display continuously flashes	3.1 Cover switch remains closed	Check cover switch or continuity between pins #8 and #15 PC board connector (see dwg #006-0029)
	3.2 Defective	Replace PC board
4. Display is on but impossible to program any valves	4.1 Programming error	Press "V", "G" or "S" to be in programming mode. Only one at a time
	4.2 Defective PC board	Replace PC board
5. Impossible to program one timer ("V", "G" or "S") (the display is on) (see step 4 first)	5.1 Defective membrane	Replace membrane
	5.2 Defective PC board	Replace PC board
6. PC board doesn't keep data in memory	6.1 Battery not charged	Run the machine or leave it plugged in with switch off for a few hours to charge battery
	6.2 Defective battery	Replace battery or complete PC board (the battery is mounted on the PC board)
	6.3 Defective	Replace PC board Pc board

4.5 Con't

7. Cycle does'nt start	7.1 Poorly adjusted cover switch	Adjust
	7.2 Bad connection or defective limit switch	Verify
	7.3 Defective PC board	Replace PC board
	7.4 PC board is OK, outputs are defective (See dwg # 006-0029)	Check pump fuses, pump contactor coil, valves, etc..
8. Machine "recycling" or cycle "re-start" continuously	8.1 Poorly adjusted cover switch	Adjust
	8.2 Defective PC board	Replace
9. Double chamber: vacuum sealing or atmosphere is not done on one side only	9.1 Defective relay or connection	Replace the 4PDT (in electrical box). This relay switch fonctions from one side to the other (the PC board is good because there is one output which control's both sides)
	9.2 Defective contactor or valve	Test voltage on coil

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

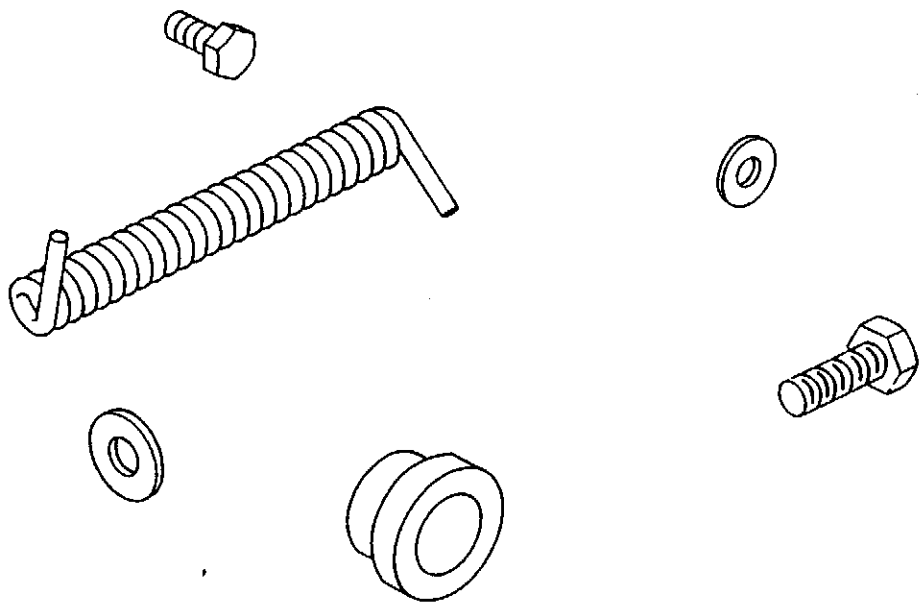
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

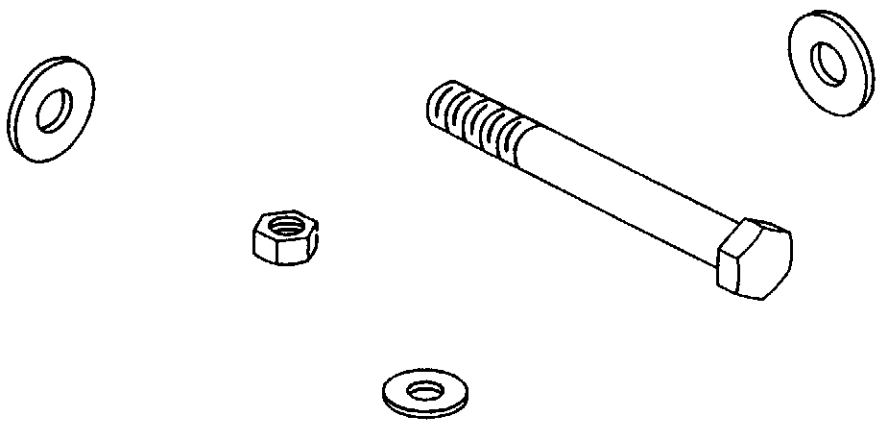
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

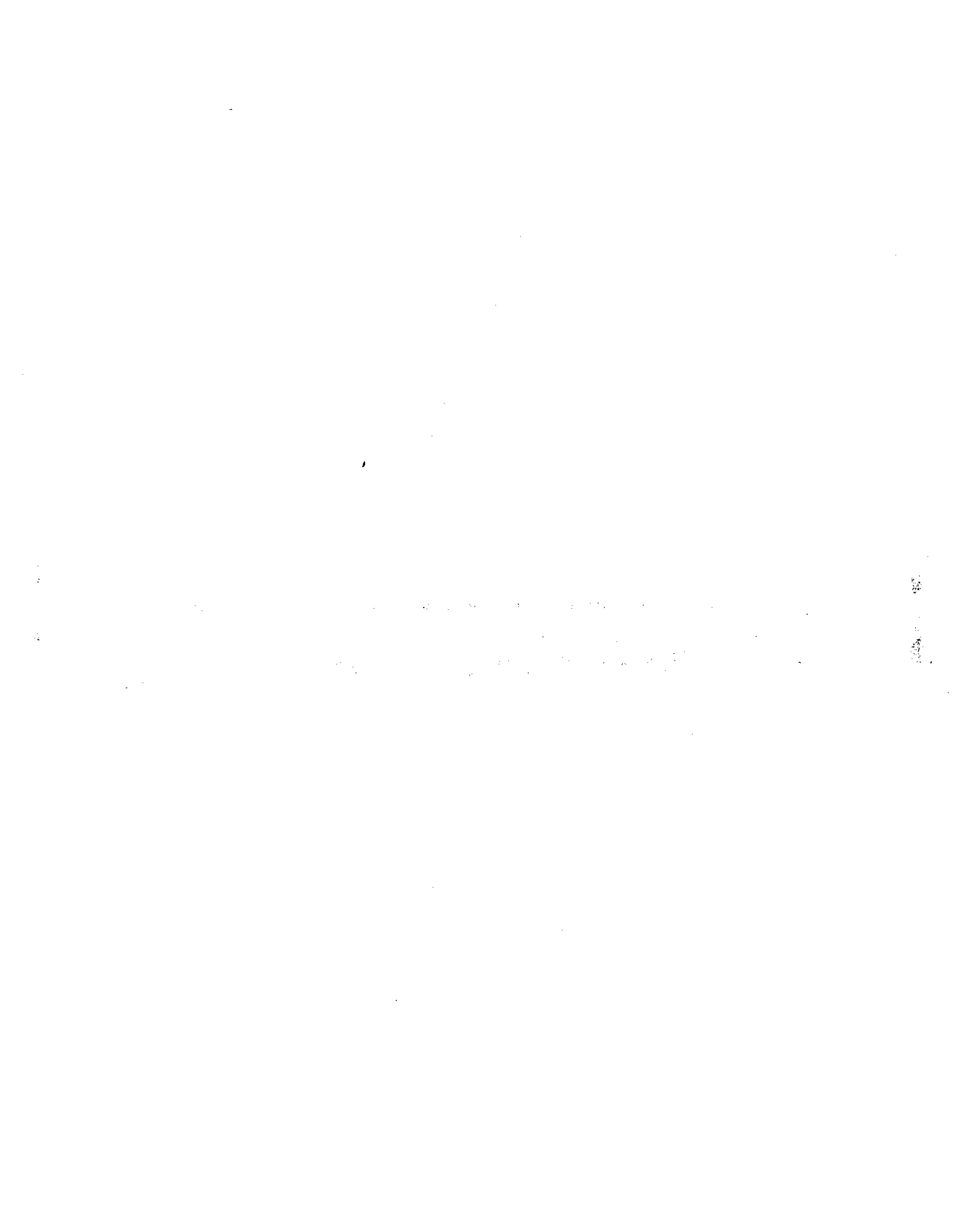
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

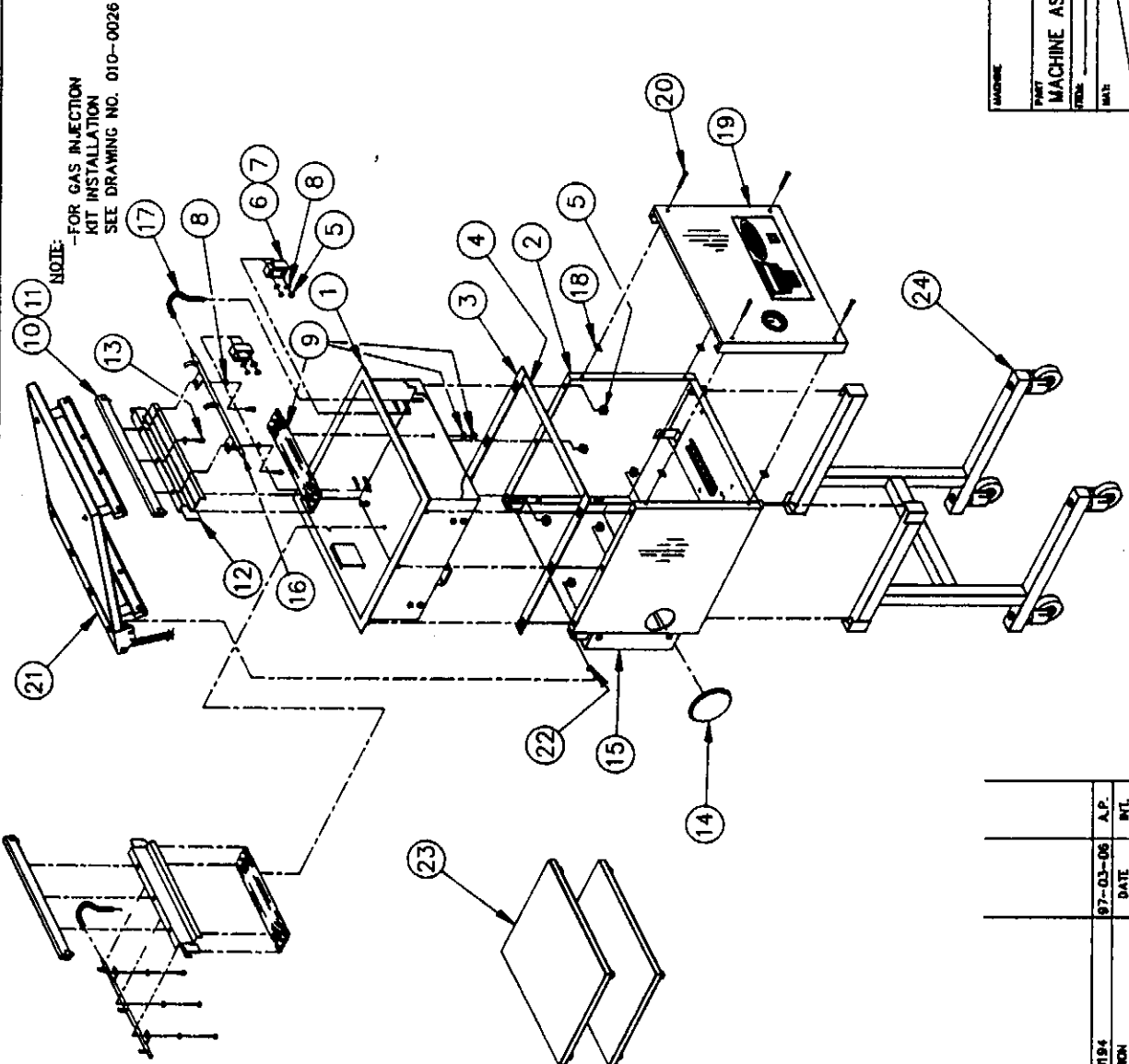


MECHANICAL DRAWING





ITEM	PART #	DESCRIPTION	QT.
1	005-0413	CHAMBER ASSEMBLY	1
2	005-0265	STRUCTURE ASSEMBLY	1
3	008-0458	SIDE CHAMBER GASKET	2
4	008-0461	FRONT CHAMBER GASKET	1
5	051-0581	LOCK NUT 1/4"-20 NC. S/S	14
6	002-0029	LEFT SEAL BAR GUIDE BLOCK	2
7	002-0030	RIGHT SEAL BAR GUIDE BLOCK	2
8	051-0740	FLAT WASHER 1/4" S/S	14
9	005-0045	BELLOWS ASSEMBLY	2
10	005-0267	SEAL BAR ASSEMBLY	2
11	005-0382	BAG CUT SEAL BAR ASSY (OPT.)	2
12	005-0046	SEAL BAR SUPPORT ASSEMBLY	2
13	051-0180	BOLT 1/4"-20 NC. X 1/2" S/S	6
14	057-0650	PLASTIC PLUG BUTTON 3 1/2" Ø	1
15	004-0361	REAR PANNEL PRE-ASSEMBLY	1
16	005-0042	GAS INJECTION BAR ASSY (OPTION)	2
17	008-0464	GAS INJ. CONN. TUBE (OPTION)	2
18	056-0020	SPRING NUT 1/4"-20 NC.	4
19	005-0450	FRONT PANNEL ASSEMBLY	1
20	051-0262	R.H.S. SCREW 1/4"-20 NC. X 2" S/S	4
21	005-0481	COVER ASSEMBLY (D.B. OPT.)	1
22	058-0030	SPACERS	2
23	005-0365	FILLER PLATE ASSEMBLY	1
24	004-0361	STAND ASSEMBLY (OPTION)	1

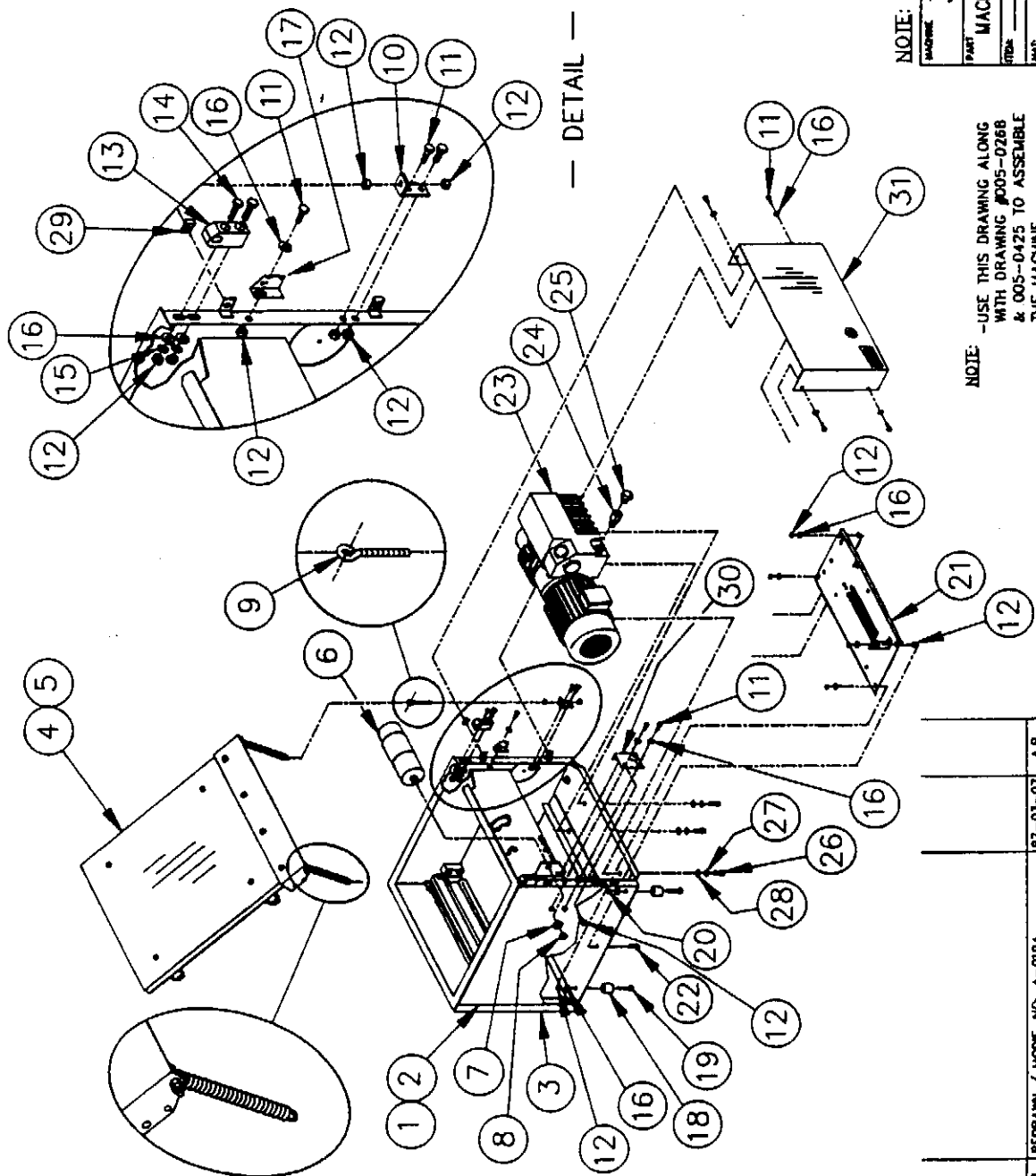


NOTE: - USE THIS DRAWING ALONG WITH DRAWING #005-0426 TO ASSEMBLE THE MACHINE. NO PARTICULAR ORDER SHOWN.

3500		SIPROMAC	
MACHINE		ST-GERMAIN DE GRANVILLE QUEBEC CANADA	
PART MACHINE ASSEMBLY FRONT VIEW		N.T.S.	
DATE: 97-03-06	SCALE: 1:1	005-0425	
BY: A. PROSSER	CHK: [Signature]	005-0425	

B	REDRAWN / MODIF. A-0194	97-03-06	A.P.
UFL	MODIFICATION	DATE	BY

ITEM	PART #	DESCRIPTION	QT.
1	004-0229	VACUUM 350 PRE-ASSY	1
2	004-0230	VACUUM 350D PRE-ASSY	1
3	005-0450	FRONT PANEL ASSY	1
4	005-0266	COVER ASSEMBLY	1
5	005-0481	COVER ASSEMBLY(D.B.OPT.)	1
6		CONDENSATOR	1
7		FLAT WASHER 1/2" ALUM.	1
8	051-0630	HEX. NUT 1/2"-13 S.S.	1
9	056-0015	EYEBOLT 1/4"-20 x 3" S.S.	2
10	001-1337	SPRING SUPPORT	2
11	051-0180	HEX. BOLT 1/4"-20 x 1/2" S.S.	12
12	051-0580	HEX. NUT 1/4"-20 S.S.	24
13	002-0024	LOWER HINGE	2
14	051-0230	BOLT 1/4"-20 x 1 1/4" S/S	4
15	051-0750	LOCK WASHER 1/4" S.S.	4
16	051-0740	FLAT WASHER 1/4" S.S.	20
17	001-0944	SWITCH SUPPORT	1
18	002-0022	FEET	4
19	051-0250	BOLT 1/4"-20 x 1 1/2" S/S	4
20	051-0581	NUT 1/4"-20 NYLON LOCK S/S	2
21	004-0042	ELECTRICAL SUPPORT PRE-ASSY	1
22	051-0190	BOLT 1/4"-20 x 3/4" S/S	2
23	125-	PUMP 21 M ³	1
24	103-0840	DRAIN EXTENSION	1
25		DRAIN EXTENSION CAP	1
26	052-4208	BOLT M8 x 12	3
27	051-0770	LOCK WASHER 5/16" S.S.	3
28	051-0760	FLAT WASHER 5/16" S.S.	3
29	056-0002	SPRING NUT 1/4"-20	4
30	001-0100	ELECTRIC WIRE SUPPORT	1
31	004-0361	REAR PANEL PRE-ASSEMBLY	1



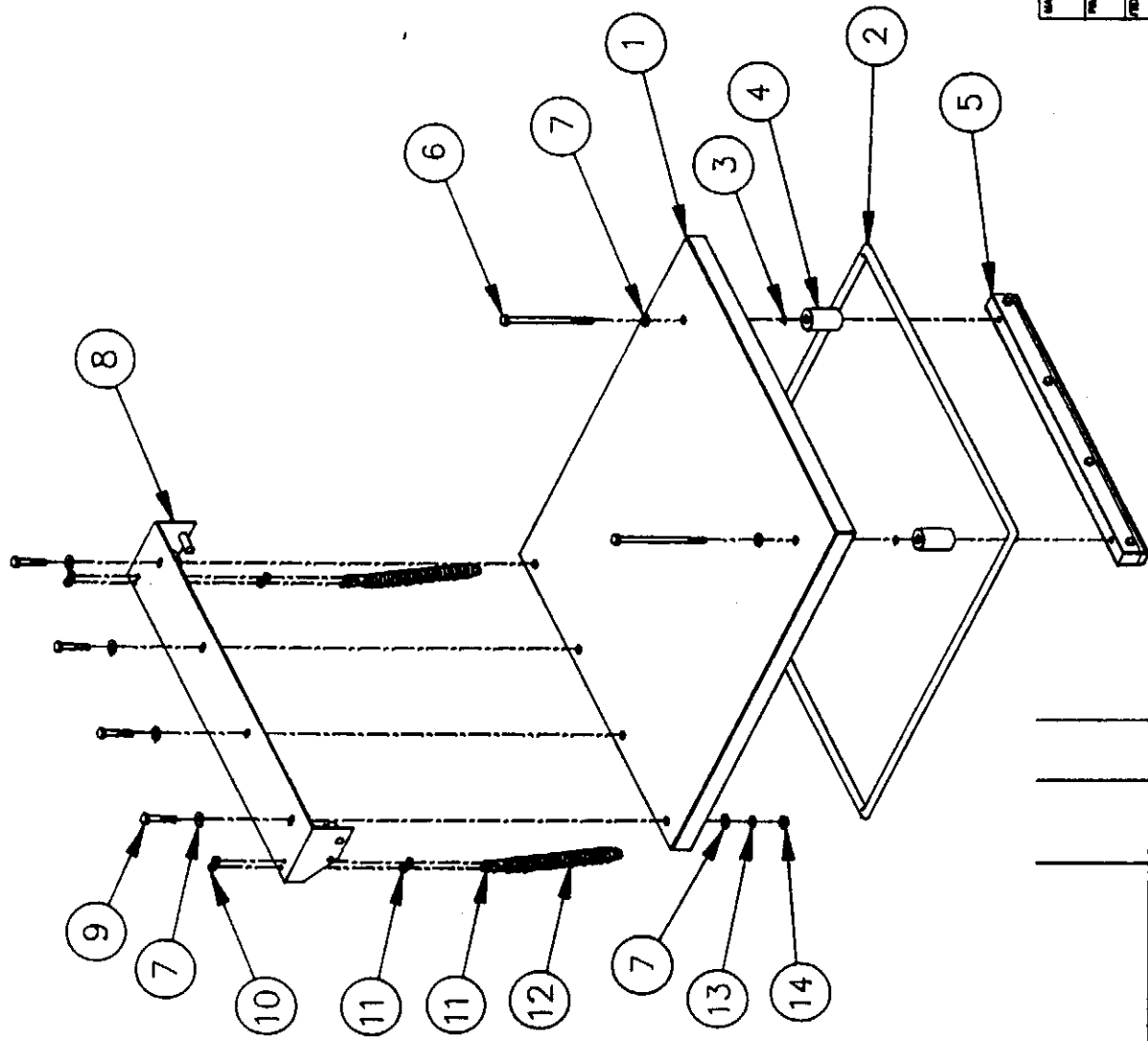
NOTE: 350D SHOWN

MACHINE: 350 & 350D		SIPROMAC	
PART: MACHINE ASSEMBLY REAR VIEW		ST-GERMAIN DE GRANVILLE QUEBEC CANADA	
DATE: 97-03-07	SCALE: 1	REV: 1	
BY: A. PROSSER	DATE: 97-03-07		
NO. 005-0426			

NOTE: -USE THIS DRAWING ALONG WITH DRAWING #005-0266 & 005-0425 TO ASSEMBLE THE MACHINE. NO PARTICULAR ORDER SHOWN.

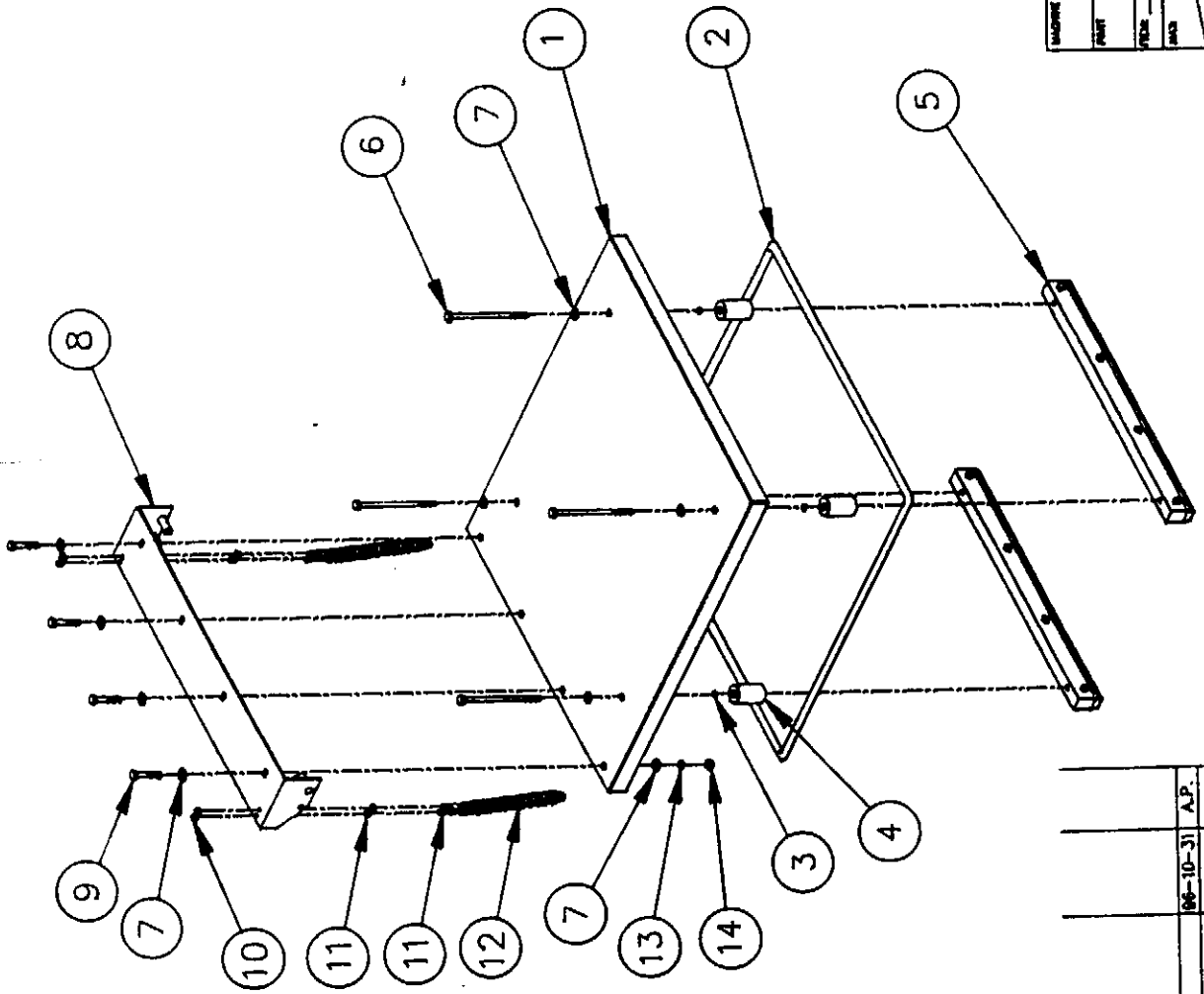
LET.	B	REDRAWN / MODIF. NO. A-0194	DATE: 97-03-07	A.P.
		MODIFICATION		MT.

ITEM	PART #	DESCRIPTION	QT.
1	002-0025	COVER	1
2	179-0005	COVER GASKET	1
3	076-0010	"D" RING	2
4	002-0026	UPPER SEAL BAR SPACER	2
5	004-0173	UPPER SEAL BAR ASSY	1
6	051-0284	HEX. BOLT 1/4"-20 NC X 3" S/S	2
7	051-0740	FLAT WASHER 1/4" S/S	10
8	004-0021	COVER HINGE ASSY	1
9	051-0250	HEX. BOLT 1/4"-20 NC X 1 1/2" S/S	4
10	051-0570	ACORN NUT 10-24 NC S/S	4
11	056-2500	U-BOLT 10-24 NC W/NUTS	2
12	077-0002	SPRING	2
13	051-0750	LOCK WASHER 1/4" S/S	4
14	051-0580	HEX. NUT 1/4"-20 NC S/S	4



350		SIPROMAC	
COVER ASSEMBLY		ST-GERMAIN DE GRANBY QUEBEC CANADA	
DATE	REV.	SCALE	PL. 1
06-10-31	A.P.	005-0266	
B REDRAWN/MODIFIED ITEM 8		005-0266	
LET.			

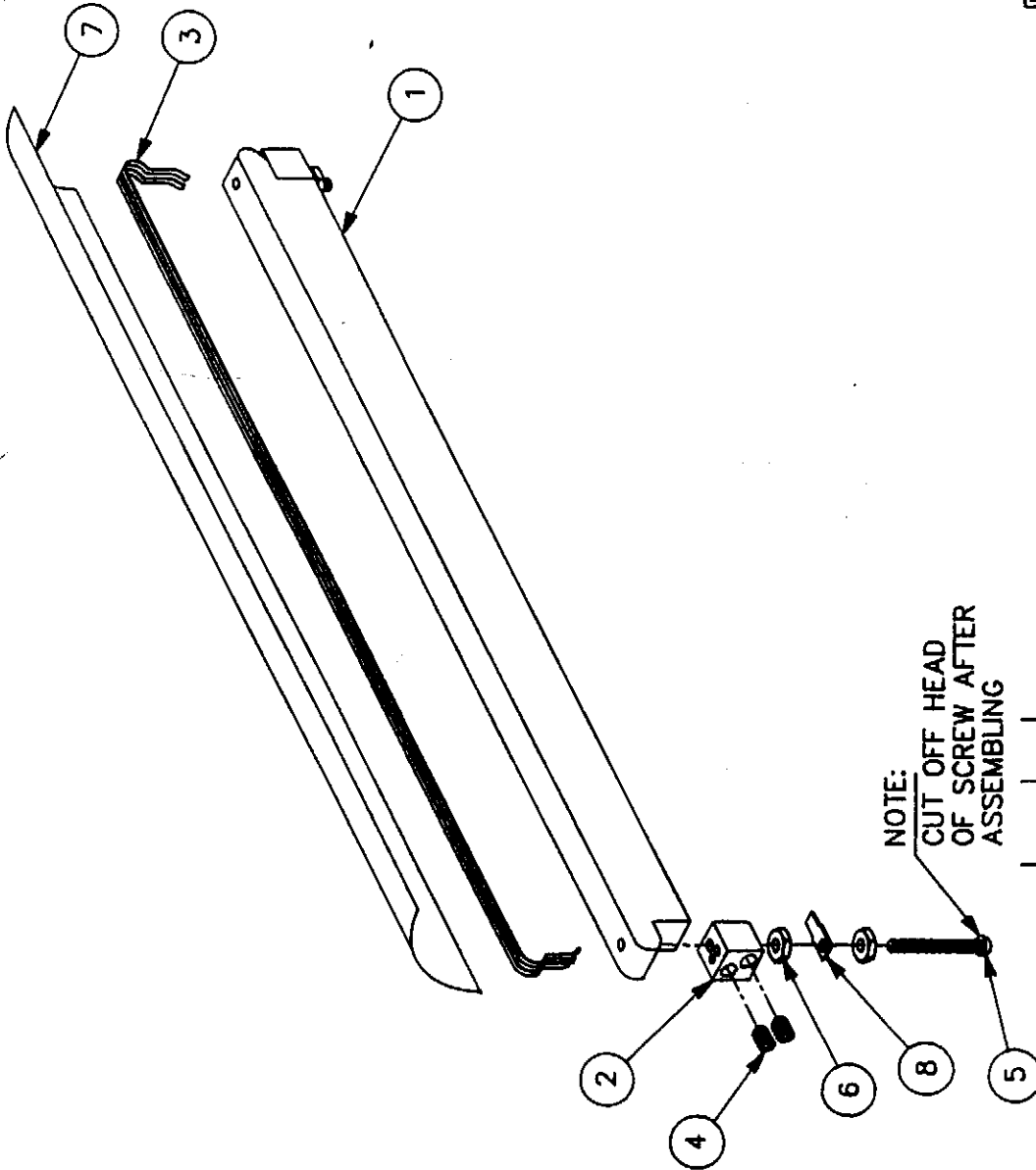
ITEM	PART #	DESCRIPTION	QTY.
1	002-0392	COVER	1
2	179-0005	COVER GASKET	1
3	076-0010	Ø" RING	4
4	002-0026	UPPER SEAL BAR SPACER	4
5	004-0173	UPPER SEAL BAR ASSY	2
6	051-0284	HEX. BOLT 1/4" - 20 NC X 3" S/S	4
7	051-0740	FLAT WASHER 1/4" S/S	12
8	004-0021	COVER HINGE ASSY	1
9	051-0250	HEX. BOLT 1/4" - 20 NC X 1 1/2" S/S	4
10	051-0570	ACORN NUT 10-24 NC S/S	4
11	056-2500	U-BOLT 10-24 NC W/NUTS	2
12	077-0002	SPRING	2
13	051-0750	LOCK WASHER 1/4" S/S	4
14	051-0580	HEX. NUT 1/4" - 20 NC S/S	4



350D		SIPROMAC	
COVER ASSEMBLY		ST-GERMAIN DE GRANBY QUEBEC CANADA	
DATE	BY	DATE	BY
96-10-31	A.P.	96-10-31	A.P.
005-0481		005-0481	

8	REDRAWN/MODIFIED ITEM 6	DATE	BY
	MODIFICATION	96-10-31	A.P.

ITEM	PART #	DESCRIPTION	QTY.
1	002-0015	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEMENT	2
4	052-0385	SET SCREW 1/4" - 20 X 5/16" (OVAL POINT)	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 (SS) ADHESIVE	1
8	027-0400	CONNECTOR ADAPTOR	2



NOTE:
CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

420A	4
350D	2
350	1
MACHINE	QTY

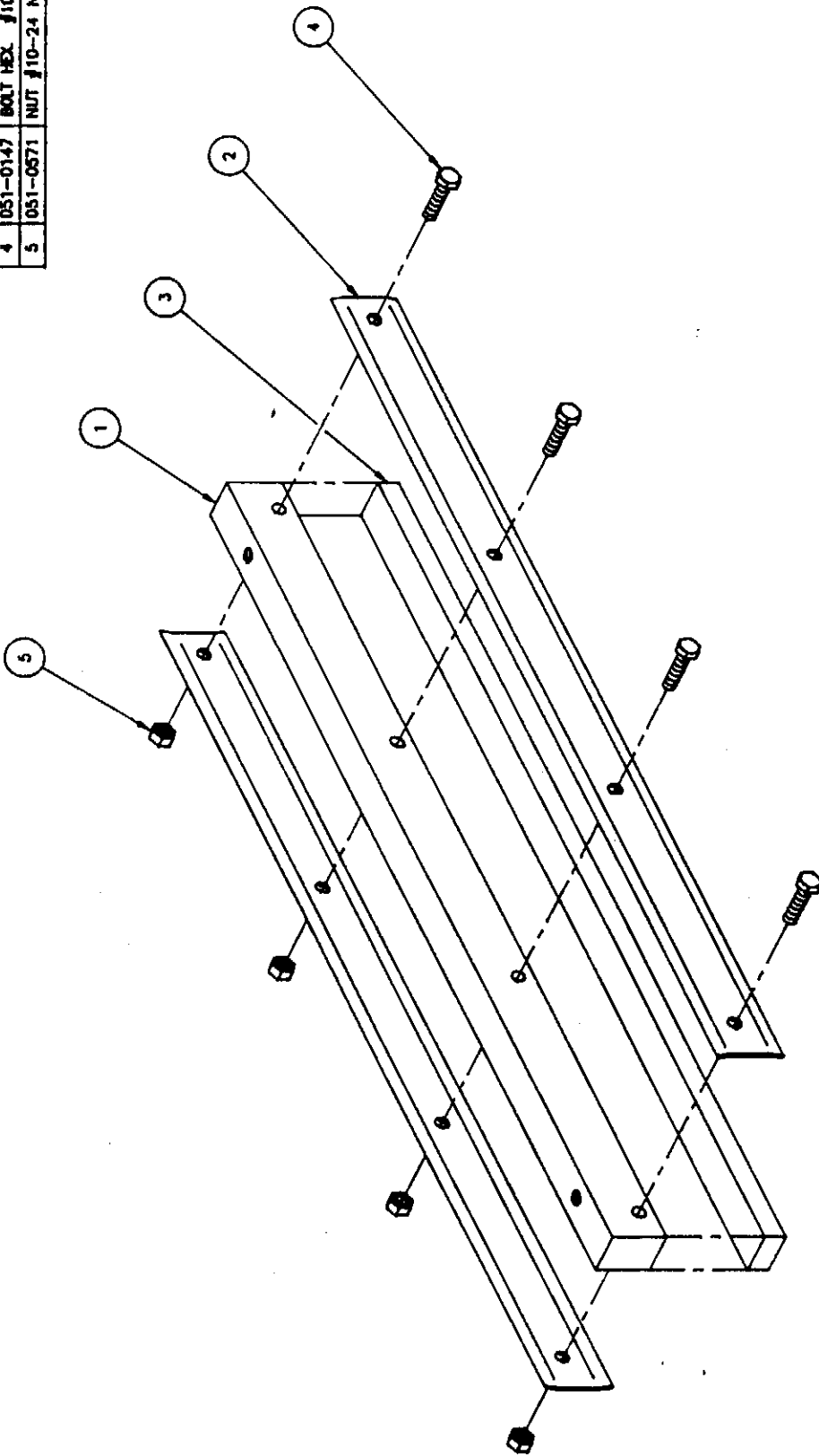
MACHINE		350, 350D & 420A	
PART		SEAL BAR PRE-ASSEMBLY	
DATE	REV.	DATE	REV.
96-08-11	A.P.	85-12-28	M.L.
MODIFICATION		DATE	
A REDRAWN		DATE	
B 420A ADDED / was 005-2334		DATE	
CET		DATE	

MACHINE		SIPROMAC	
PART		ST-GERMAN DE GRANBY QUEBEC CANADA	
DATE	REV.	DATE	REV.
96-05-12-28			
MODIFICATION		DATE	
A P.A.P.		DATE	
B		DATE	
CET		DATE	

005-0267

ITEM	PART #	DESCRIPTION	QTY
1	002-0377	UPPER SEAL BAR	1
2	001-0086	UPPER SEAL SUPPORT	2
3	008-0291	UPPER SEAL BAR RUBBER	1
4	051-0147	BOLT HEX. #10-24 NC X 1" S/S	4
5	051-0571	NUT #10-24 NC S/S	4

QUANTITY FOR ONE
BAR ONLY.
SEE LIST FOR QTY

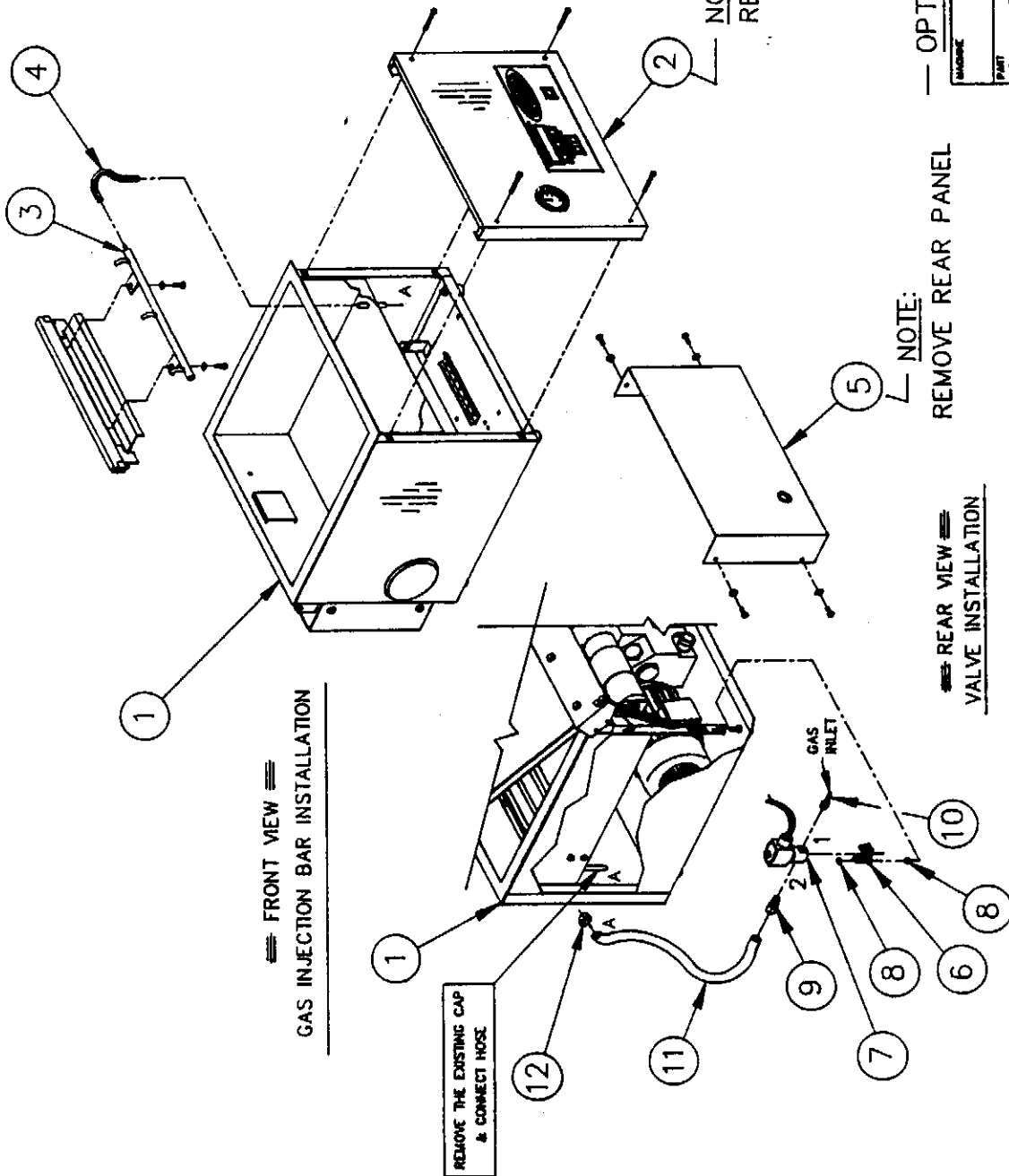


QTY	DESCRIPTION
2	3500
1	350
	MACHINE

350 & 350D UPPER SEAL BAR PRE-ASSY		N.T.S. DATE 06-11-14	SEE LIST 004-0173
SIPROMAC 31-GEMMAN DE GRANBY QUEBEC CANADA	DATE 06-11-14 BY A.P.	DATE 06-11-14 BY A.P.	SEE LIST 004-0173

RETURN/ADDED 3500 MODIFICATION	DATE 06-11-14 BY A.P.	DATE 06-11-14 BY A.P.
-----------------------------------	--------------------------	--------------------------

ITEM	PART #	DESCRIPTION	QTY
1	004-0229	VACUUM 350 PRE-ASS'Y	1
2	005-0450	FRONT PANEL ASS'Y	1
3	005-0042	GAS INJECTION BAR	1
4	008-0464	GAS INJECTION CONN. TUBE	1
5	004-0361	REAR PANEL ASS'Y	1
6	106-0345	VALVE SUPPORT FOR 1/4" NPT	1
7	106-0010	SELENOID VALVE 2 WAY 1/4"NPT	1
8	051-0580	HEX. NUT 1/4"-20 S.S.	2
9	101-0036	STRAIGHT 1/4"MNPT x 3/8" T.P. COMP.	1
10	101-0200	STRAIGHT 1/4"MNPT x 1/4" HOSE	1
11	104-0060	TUBE 3/8"ODx1/4"ID(POL.Y.) x 610mm LG.	1
12	105-0200	COLLARS 3/8"Ø	1



FRONT VIEW
GAS INJECTION BAR INSTALLATION

REAR VIEW
VALVE INSTALLATION

NOTE: TO INSTALL GAS INJECTION TUBE,
REMOVE FRONT PANEL, ITEM #2

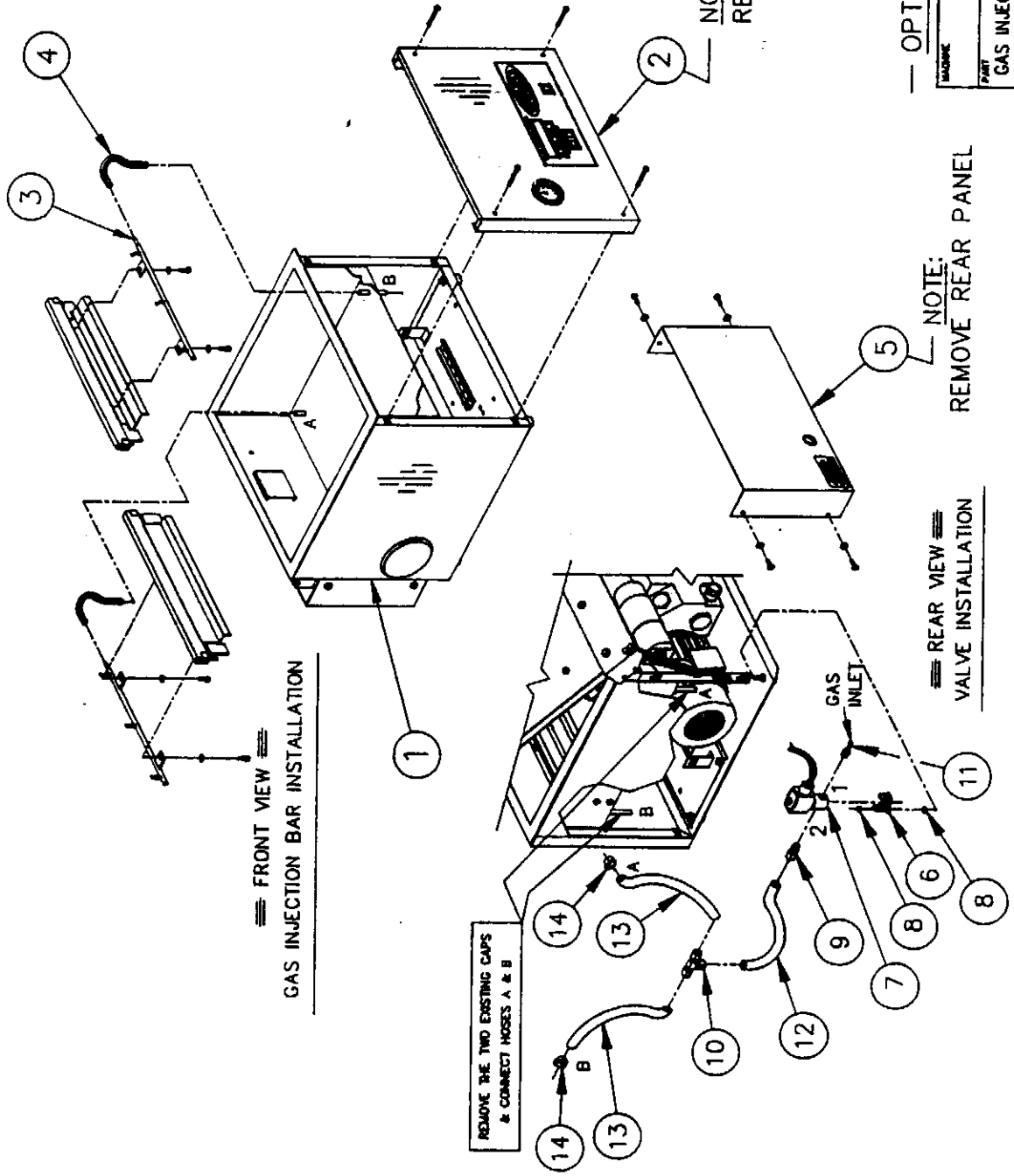
OPTION GAS INJECTION

NOTE:
REMOVE REAR PANEL

MARKING	350	DATE	97-03-07
PART #	GAS INJECTION KIT INSTALLATION	REV.	1
MANUFACTURER	SIPROMAC	ST-GERMAIN DE GRANTHAM	QUEBEC CANADA
DATE	97-03-07	DATE	97-03-07
BY		BY	

8	REDAIN / MOD. NO. A-0184	97-03-07	A.P.
LET.	MODIFICATION	DATE	INT.

ITEM	PART #	DESCRIPTION	QTY.
1	004-0230	VACUUM 3500 PRE-ASS'Y.	1
2	005-0450	FRONT PANEL ASS'Y	1
3	005-0042	GAS INJECTION BAR	2
4	008-0464	GAS INJECTION CONN. TUBE	2
5	004-0361	REAR PANEL ASS'Y	1
6	106-0345	SELENOID VALVE SUPPORT	1
7	106-0010	SELENOID VALVE 2 WAY 1/4"NPT	1
8	051-0580	HEX. NUT 1/4"-20 S.S.	2
9	101-0036	STRAIGHT 1/4"MNPT x 3/8"TP.COMP.	1
10	101-0062	T 3/8" T.P.COMP.	1
11	101-0200	STRAIGHT 1/4"MNPT x 1/4" HOSE	1
12	104-0060	TUBE 3/8"ODx1/4"ID(POLY.) x 230mm LG.	1
13	104-0060	TUBE 3/8"ODx1/4"ID(POLY.) x 270mm LG.	2
14	105-0200	COLLARS 3/8" Ø	2

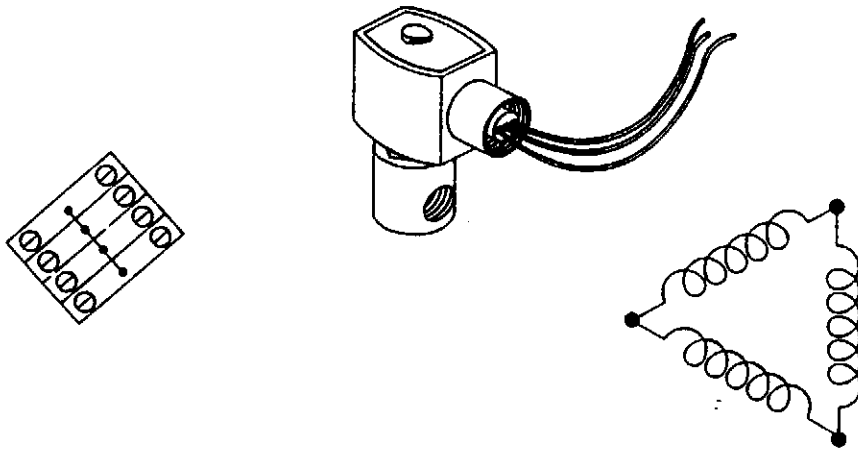


NOTE: TO INSTALL GAS INJECTION TUBE,
REMOVE FRONT PANEL, ITEM #2

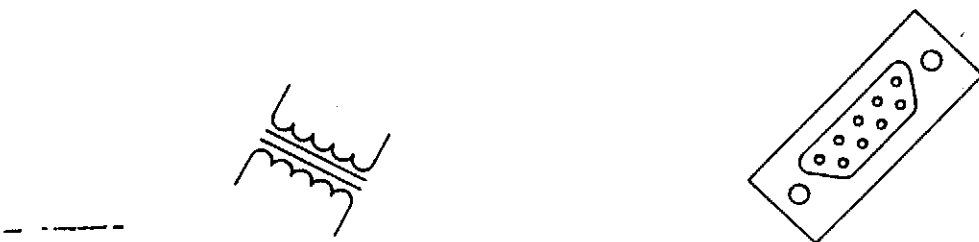
OPTION GAS INJECTION

MAKE	3500	NO. IN CHARGE	
PART	GAS INJECTION KIT INSTALLATION	NO. OF SETS	
FRONT		NO. OF SETS	
BACK		NO. OF SETS	
DATE: 97-03-07		SCALE: 1	
BY: A. PROBERT		SIPROMAC	
		11-CENTRIUM DE GRANITUM	
		11-QUEBEC CANADA	
		010-0026	

LET.	B	REPAIR / MOD. NO. A-0184	DATE: 87-03-07	A.P.
		MODIFICATION		MT.

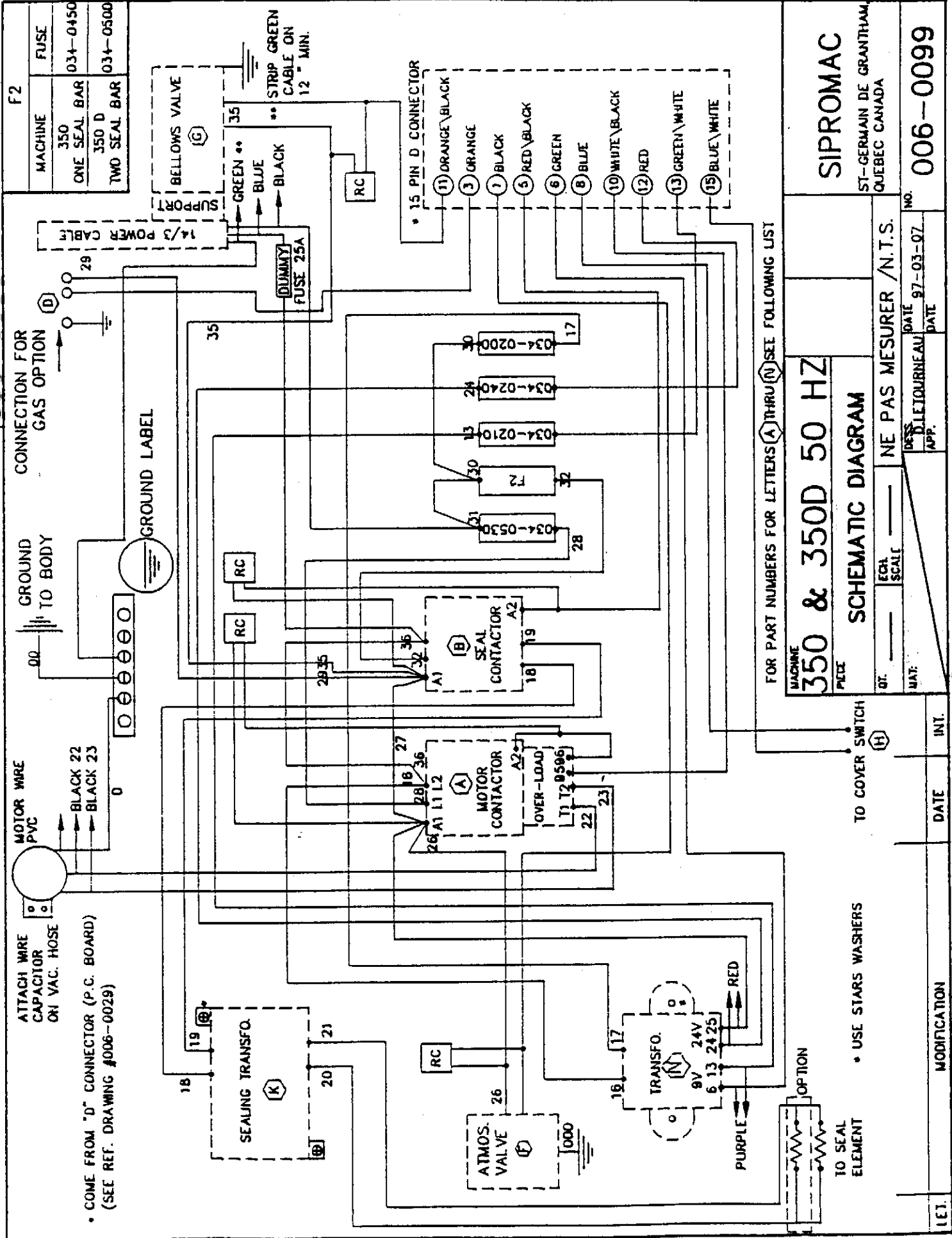


ELECTRICAL DRAWING





1006-0099



SIPROMAC

ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

006-0099

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

MACHINE
350 & 350D 50 HZ
PIECE

SCHEMATIC DIAGRAM

NE PAS MESURER / N.T.S.

DATE 97-03-07
APP. [Signature]

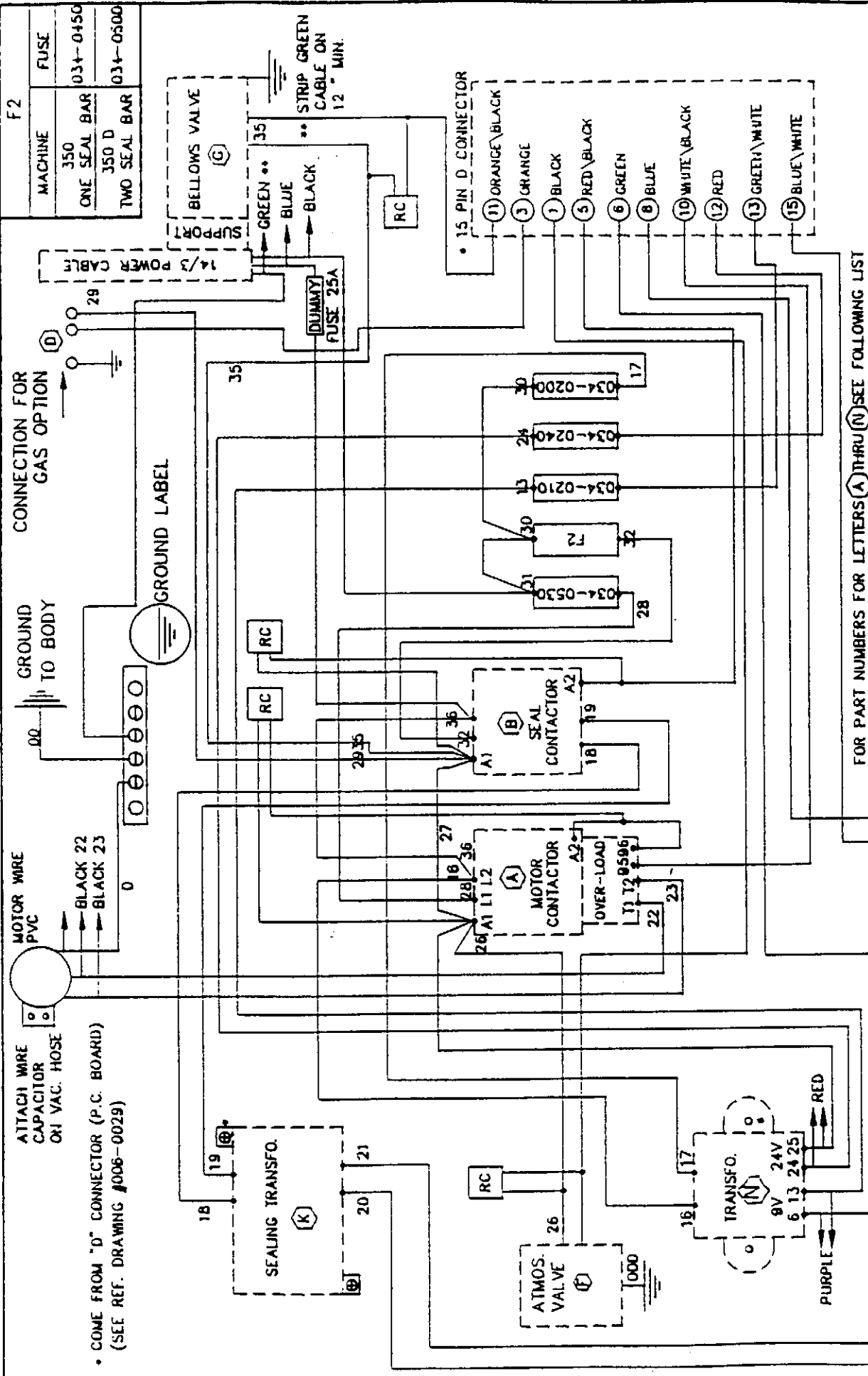
INT.

DATE

MODIFICATION

LET.

1006-0099



F2	
MACHINE	FUSE
350	033-0450
ONE SEAL BAR	350 D
TWO SEAL BAR	033-0500

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

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

350 & 350D 50 HZ
SCHEMATIC DIAGRAM

PIECE: _____

GT: _____ ECH. SCALE: _____

MAT: _____ DATE: 97-03-07

NE PAS MESURER / N.T.S.

DATE: _____ INT. _____

MODIFICATION: _____

1006-0099

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

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

- B, C & O: SEALING CONTACTOR: # 025-0020
- D: OPTIONAL GAZ SOLENOID VALVE: # 106-0010
- E: VACUUM SOLENOID VALVE: # 106-0030---(420A)
106-0050---(600A & 620A)
106-0060---(650A)
- F: ATMOSPHERE SOLENOID VALVE: # 106-0020 WITH PUMP:
21 M³
106-0030 WITH PUMPS:
40 M³, 60 M³ & 100 M³
106-0050 WITH PUMPS:
160 M³ & 250M³
- G: BELLOWS SOLENOID VALVE: # 106-0070
- H, I, J: COVER SWITCH: # 026-0610
- K: SEALING TRANSFO.:
250 ONE SEAL BAR: # 029-0040
350 ONE SEAL BAR: # 029-0010
350 TWO SEAL BAR: # 029-0030
650 ALL MODEL : # 029-0170
- 420, 450, 550, 600, 620 TWIN SEAL & BAG CUT 220 VOLTS: # 029-0040
TWIN SEAL & BAG CUT 575 VOLTS: # 029-0050
TOP & BOTTOM SEALING 220 VOLTS: # 029-0080
TOP & BOTTOM SEALING 575 VOLTS: # 029-0095
- L: RELAY & BASE: RELAY: # 025-MY424 & BASE: # 025-0600
- M: OPTIONAL TOP SEALING CONTACTOR: # 025-0020
- N: CONTROL TRANSFO.:MODEL 250 TO 650:029-0007,029-0008,029-0009,
029-0250

MODEL 700A:029-0010

1006-0029

ITEM / PIECE

DESCRIPTION

QT.

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

COLOR CODE

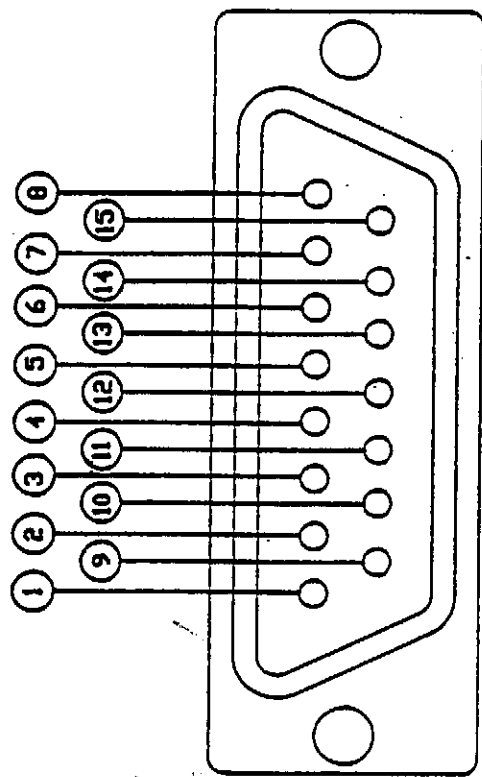
- ① BLACK : OUTPUT TO ATMOSPHERE VALVE
- ② WHITE : OUTPUT TO SEALING CONTACTOR
- ③ GREEN : OUTPUT TO GAS VALVE
- ④ RED : CONTACT OF PC BOARD RELAY
- ⑤ BLACK : CONTACT OF PC BOARD RELAY
ACTIVATES WHEN MACHINE IS ON
- ⑥ YELLOW : INPUT +9 VOLTS
- ⑦ ----- : JUMPED WITH ⑥
- ⑧ WHITE : TO COVER SWITCH
- ⑩ RED : OUTPUT TO VACUUM VALVE
OR CONTACTOR MOTOR (350,450A OR 550A)
- ⑨ ----- : NOT USED
- ⑪ BLACK : OUTPUT TO SEALING SELENOID VALVE
- ⑬ ORANGE : INPUT -9 VOLTS
- ⑭ ----- : JUMPED WITH ⑬
- ⑫ BLACK : INPUT 24 VAC
- ⑮ BROWN : TO COVER SWITCH

JUMP
SEE NOTE

PC BOARD
RELAY

COVER
SWITCH

JUMP 2 + 4
5 GOES TO SEAL CONTACTOR



NOTE: - JUMP ②④ FOR VACUUM : 350 450A 550A ONLY
- THIS CONNECTOR PLUGS IN AT REAR OF P.C. BOARD

MACHINE		VACUUMS		METRIC TOLERANCE		ENGLISH TOLERANCE		SIPROMAC	
PIECE		"D" CONNECTOR DETAIL		0. ± .015		.0 ± .015		ST-GERMAIN DE GRANTHIAU	
QT.		ECH. SCALE		.00 ± .005		.000 ± .0005		QUEBEC CANADA	
MAT.		NE PAS MESURER / N.T.S.		ANGLE ± 1°		G			
		DATE 94-03-03		DATE 94-03-04					
		APP. / /						006-0029	

LET. MODIFICATION DATE INT.

006-0029

ITEM # PIECE

DESCRIPTION

QT.

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

COLOR CODE

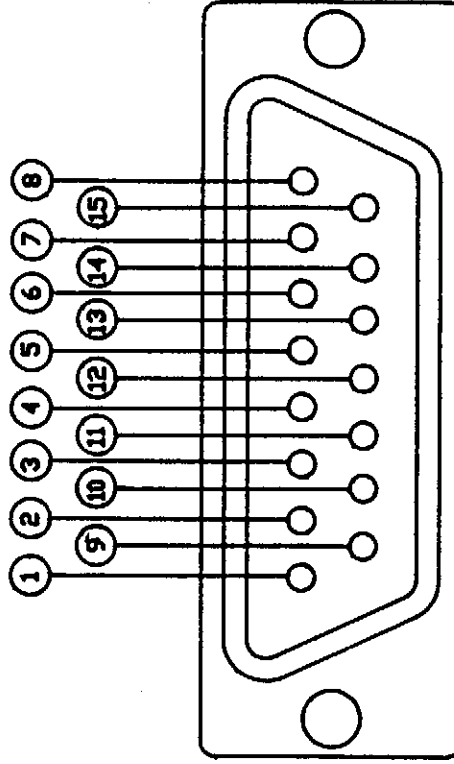
- ① BLACK : OUTPUT TO ATMOSPHERE VALVE
- ② WHITE : OUTPUT TO SEALING CONTACTOR
- ③ ORANGE : OUTPUT TO GAZ VALVE
- ④ RED/WHITE : CONTACT OF PC BOARD RELAY ACTIVATES WHEN MACHINE IS ON
- ⑤ RED/BLACK : CONTACT OF PC BOARD RELAY ACTIVATES WHEN MACHINE IS ON
- ⑥ GREEN : INPUT 9 VAC
- ⑦ ----- : JUMPED WITH ⑥
- ⑧ BLUE : TO COVER SWITCH
- ⑨ ----- : NOT USED
- ⑩ WHITE/BLACK : OUTPUT TO VACUUM VALVE OR CONT. MOTOR 350,450A OR 550A) (250)
- ⑪ ORANGE/BLACK : OUTPUT TO SEALING SELENOID VALVE
- ⑫ RED : INPUT 24 VAC
- ⑬ GREEN/WHITE : INPUT 9 VAC
- ⑭ ----- : JUMPED WITH ⑬
- ⑮ BLUE/WHITE : TO COVER SWITCH

JUMP

SEE NOTE

PC BOARD RELAY

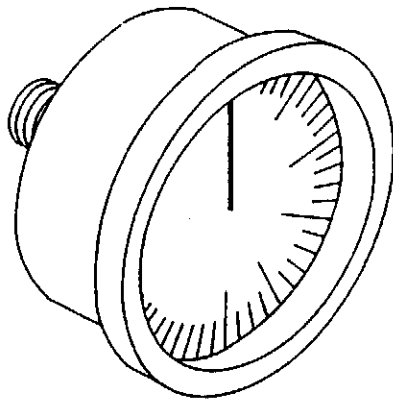
COVER SWITCH



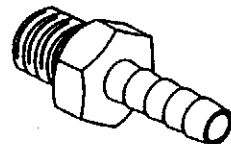
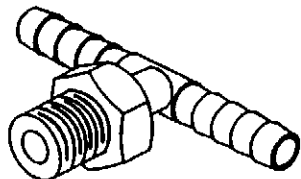
WIRE SIDE VIEW

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

MACHINE		VACUUMS		SIPROMAC	
PIECE "D" CONNECTOR DETAIL		TECH SCALE		ST-GERMAN DE GRANTHAM QUEBEC CANADA	
REF.	NE PAS MESURER /N.T.S.	DATE	96-11-07	NO.	006-0029
REVISION	MODIFICATION	DATE	95-01-31	D.L.	INT.
LET.					

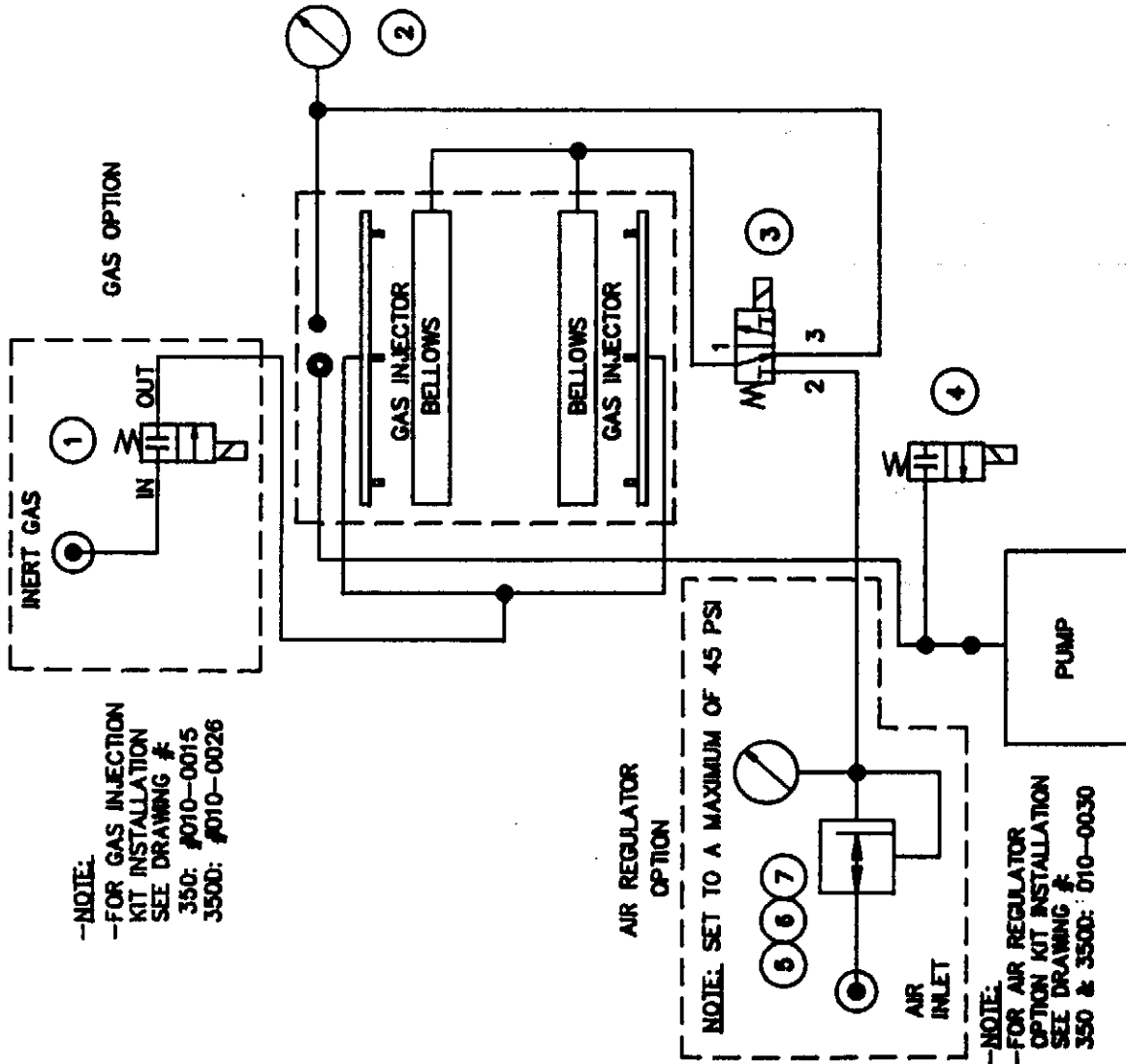


PNEUMATIC DRAWING



007-0022

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	1*
2	114-0280	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 GAS INJECTION
 KIT INSTALLATION
 SEE DRAWING #
 350: #010-0015
 350D: #010-0026

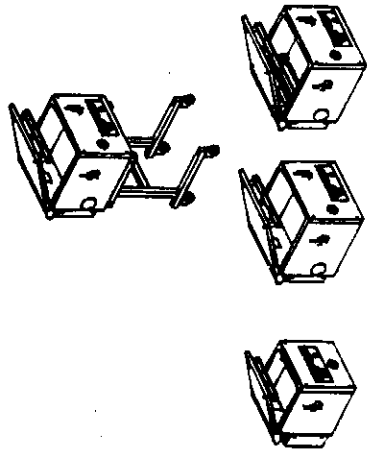
AIR REGULATOR
 OPTION

NOTE: SET TO A MAXIMUM OF 45 PSI

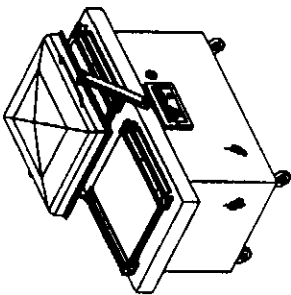
NOTE:
 -FOR AIR REGULATOR
 OPTION KIT INSTALLATION
 SEE DRAWING #
 350 & 350D: 010-0030

MACHINE		350 & 350D		SIPROMAC	
PART		PNEUMATIC		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM	CNC	N.T.S.	SCALE	QT.	1
DATE	DATE	DATE	DATE	DATE	DATE
APP.	M.LAVIGNE	DATE	97-03-11	NO.	007-0022
RE-DRAWN	MODIFICATION	DATE	97-03-11	M.L.	INT.
LET.					

NOTES



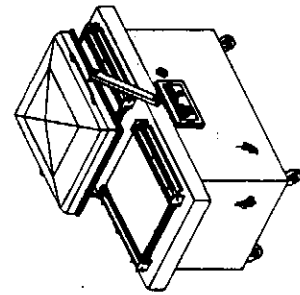
MODEL 250 MODEL 350 MODEL 350D MODEL 450T MODEL 450A MODEL 550A MODEL 420A



MODEL 600A

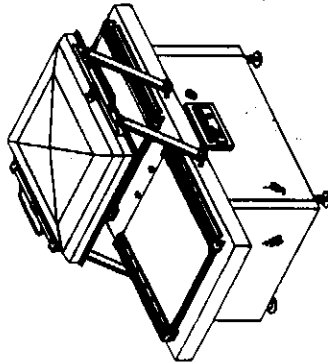


Canada
SIPROMAC
 International Headquarters
 240 Industrial Blvd.
 St. Germain, Canada J0C1K0
 819-395-5151
 FAX: 819-395-5343

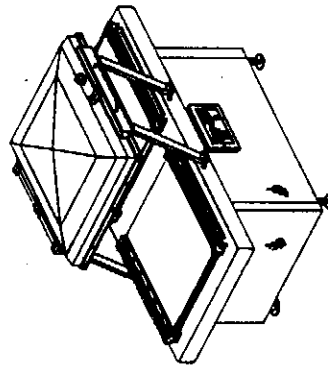


MODEL 620A

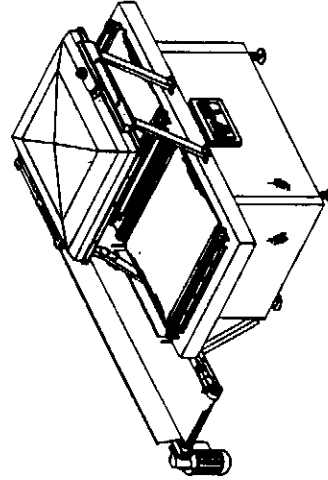
VACUUM PACKAGING MACHINES



MODEL 650A



MODEL 650A AUTOMATIC



MODEL 700A

