




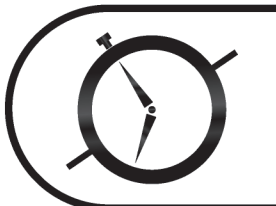







## SEALING + COOLING CYCLE TIMES

| VacSeries Model  | Pouch/Bag Type  | Sealing Cycle Time            | Cooling Cycle Time |
|--|-----------------|-------------------------------|--------------------|
| <b>Vac100</b><br>           | 3 mil VacPouch  | 1.8 seconds                   | 3.0 seconds        |
|  | 4 mil VacPouch  | 2.0 seconds                   | 3.0 seconds        |
|  | 5 mil VacPouch  | 2.2 seconds                   | 3.0 seconds        |
|  | Retort Pouch    | 2.8 seconds (with retort bar) | 6.0 seconds        |
|  | 7 mil Mylar Bag | 2.4 seconds (with retort bar) | 5.0 seconds        |
| <b>Vac110</b><br>          | 3 mil VacPouch  | 1.5 seconds                   | 3.0 seconds        |
|  | 4 mil VacPouch  | 1.7 seconds                   | 3.0 seconds        |
|  | 5 mil VacPouch  | 1.9 seconds                   | 3.0 seconds        |
|  | Retort Pouch    | 2.2 seconds (with retort bar) | 5.0 seconds        |
|  | 7 mil Mylar Bag | 2.0 seconds (with retort bar) | 5.0 seconds        |
| <b>Vac310 (1 BAR)</b><br> | 3 mil VacPouch  | 1.8 seconds                   | 3.0 seconds        |
|  | 4 mil VacPouch  | 2.0 seconds                   | 3.0 seconds        |
|  | 5 mil VacPouch  | 2.2 seconds                   | 3.0 seconds        |
|  | Retort Pouch    | 2.4 seconds                   | 6.0 seconds        |
|  | 7 mil Mylar Bag | 2.2 seconds                   | 5.0 seconds        |
| <b>Vac310 (2 BAR)</b><br> | 3 mil VacPouch  | 2.2 seconds                   | 3.0 seconds        |
|  | 4 mil VacPouch  | 2.4 seconds                   | 3.0 seconds        |
|  | 5 mil VacPouch  | 2.6 seconds                   | 3.0 seconds        |
|  | Retort Pouch    | NOT APPLICABLE                | NOT APPLICABLE     |
|  | 7 mil Mylar Bag | NOT APPLICABLE                | NOT APPLICABLE     |
| <b>Vac410</b><br>         | 3 mil VacPouch  | 2.2 seconds                   | 3.0 seconds        |
|  | 4 mil VacPouch  | 2.4 seconds                   | 3.0 seconds        |
|  | 5 mil VacPouch  | 2.6 seconds                   | 3.0 seconds        |
|  | Retort Pouch    | NOT APPLICABLE                | NOT APPLICABLE     |
|  | 7 mil Mylar Bag | 2.4 seconds                   | 5.0 seconds        |



**DISCLAIMER:** These recommended times are based on a properly maintained machine with appropriate voltage supply. Contamination in the seal area will directly effect seal integrity. Only use OEM replacement parts when maintaining your machine.

## VACUUM CYCLE TIMES

| VacSeries Model  | Food Type  | Vacuum Cycle Time  |
|--|--|--------------------|
| <b>Vac100</b><br>           | <b>SOUPS</b> ( <i>chilled</i> )                    | <b>25 seconds</b>  |
|  | <b>VEGGIES + FRUITS</b> ( <i>freeze tempered</i> ) | <b>35 seconds</b>  |
|  | <b>FRESH SAUSAGE</b> ( <i>freeze tempered</i> )    | <b>35 seconds</b>  |
|  | <b>GRAINS</b>                                      | <b>20 seconds</b>  |
|  | <b>BEEF + POULTRY</b>                              | <b>50 seconds</b>  |
| <b>Vac110</b><br>          | <b>SOUPS</b> ( <i>chilled</i> )                    | <b>15 seconds</b>  |
|  | <b>VEGGIES + FRUITS</b> ( <i>freeze tempered</i> ) | <b>25 seconds</b>  |
|  | <b>FRESH SAUSAGE</b> ( <i>freeze tempered</i> )    | <b>25 seconds</b>  |
|  | <b>GRAINS</b>                                      | <b>15 seconds</b>  |
|  | <b>BEEF + POULTRY</b>                              | <b>35 seconds</b>  |
| <b>Vac310 (1 BAR)</b><br> | <b>SOUPS</b> ( <i>chilled</i> )                    | <b>15 seconds</b>  |
|  | <b>VEGGIES + FRUITS</b> ( <i>freeze tempered</i> ) | <b>25 seconds</b>  |
|  | <b>FRESH SAUSAGE</b> ( <i>freeze tempered</i> )    | <b>25 seconds</b>  |
|  | <b>GRAINS</b>                                      | <b>15 seconds</b>  |
|  | <b>BEEF + POULTRY</b>                              | <b>30 seconds</b>  |
| <b>Vac310 (2 BAR)</b><br> | <b>SOUPS</b> ( <i>chilled</i> )                    | <b>15 seconds</b>  |
|  | <b>VEGGIES + FRUITS</b> ( <i>freeze tempered</i> ) | <b>25 seconds</b>  |
|  | <b>FRESH SAUSAGE</b> ( <i>freeze tempered</i> )    | <b>25 seconds</b>  |
|  | <b>GRAINS</b>                                      | <b>15 seconds</b>  |
|  | <b>BEEF + POULTRY</b>                              | <b>30 seconds</b>  |
| <b>Vac410</b><br>         | <b>SOUPS</b> ( <i>chilled</i> )                    | <b>10 seconds</b>  |
|  | <b>VEGGIES + FRUITS</b> ( <i>freeze tempered</i> ) | <b>15 seconds</b>  |
|  | <b>FRESH SAUSAGE</b> ( <i>freeze tempered</i> )    | <b>15 seconds</b>  |
|  | <b>GRAINS</b>                                      | <b>10 seconds</b>  |
|  | <b>BEEF + POULTRY</b>                              | <b>25 seconds</b>  |
| <b>All VacSeries Chamber Vacuum Sealers</b>  | <b>SEAL-ONLY CYCLE (NO VACUUM):</b>                | <b>5-6 seconds</b> |



Generally speaking, pulling full vacuum on anything is the best practice in order to achieve longer shelf life. Obviously this general practice **DOES NOT** apply to all applications such as certain food types, delicate products, liquids, sharp edged contents, etc.