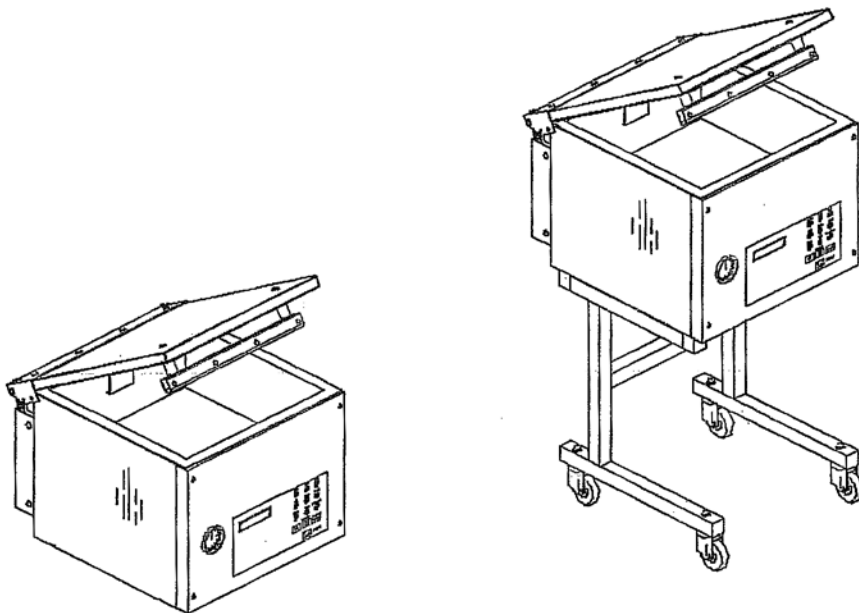




VACUUM PACKAGING MACHINE

MODELS 350 & 350D

(Models with New Vacuum Sensor and 19" Seal Bars)



OWNERS MANUAL

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 owners manual. Save these instructions for future reference.

INSTALLATION NOTICE FOR MODELS:

250, 300, 350, 350D, 380 & 450T

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.

VACUUM PACKAGING MACHINE

MODEL 350, 350D

(MC-40)

GENERAL TABLE OF CONTENTS

I	OPERATION INSTRUCTIONS
II	MECHANICAL
	A- 350: front view assembly drawing.
	B- 350: rear view assembly drawing
	C- 350D: front view assembly drawing
	D- 350D: rear view assembly drawing
	E- 350 & 350D: front panel assembly
	F- Seal bar assembly drawings (twin seal)
	G- Seal bar assembly drawings (electrical bag cut option)
	H- 350: cover assembly drawing
	I- 350D: cover assembly drawing
	J- 350 & 350D: upper seal bar assembly drawing
	K- 350: gas injection kit installation drawing
	L- 350D: gas injection kit installation drawing
III	ELECTRICAL
	A- Electrical drawings
IV	PNEUMATIC
	A- Pneumatic drawing

VACUUM PACKAGING MACHINES-OPERATION INSTRUCTIONS

TABLE OF CONTENTS

1. Setting up the machine
2. Electrical connection
3. Operation
 - 3.1 Working principles
 - 3.2 Special packaging
 - 3.2.1 Gas flushing
 - 3.2.2 Electrical bag cut (optional)
 - 3.3 Vacuum packaging operation
 - 3.3.1 Basics
 - 3.3.2 Functions menu
 - 3.3.2.1 Create a program
 - 3.3.2.2 Delete a program
 - 3.3.2.3 Select operating mode
 - 3.3.3 Programs menu
 - 3.3.3.1 Program identification
 - 3.3.3.2 Vacuum time setting (sensor disabled)
 - 3.3.3.3 Vacuum level setting (sensor enabled)
 - 3.3.3.4 Vacuum plus time setting (sensor enabled)
 - 3.3.3.5 Gas time setting (sensor disabled)
 - 3.3.3.6 Gas flush level setting (sensor enabled)
 - 3.3.3.7 Sealing time setting
 - 3.3.4 Vacuum cycle execution
 - 3.3.5 System monitor
 - 3.4 Daily cleaning
4. Trouble shooting
 - 4.1 Failure during a packaging cycle
 - 4.2 Insufficient vacuum
 - 4.2.1 Leakage in the bag
 - 4.2.2 No leakage in the bag
 - 4.2.3 Insufficient vacuum in the chamber
 - 4.3 Faulty seal
 - 4.3.1 Insufficient seal
 - 4.3.2 No seal
 - 4.3.3 Permanent sealing current
 - 4.3.4 Seal does not stick
 - 4.4 Fault in the valves
 - 4.5 Control board failure.
5. Regular maintenance

2010-08-30

VACUUM PACKAGING MACHINES

1. SETTING UP THE MACHINE:

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

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

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

Normal ambient temperature for the vacuum pump is between 10 to 70°C. For temperature below 10°C; it is recommended to use synthetic oil. Please consult factory and pump manufacturer manual for more information or when ambient temperature are outside normal limits.

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.

All vacuum machines are supplied with an electrical schematic drawing. An important step in connecting the machine is to make sure that the pump turns in its correct rotation.



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

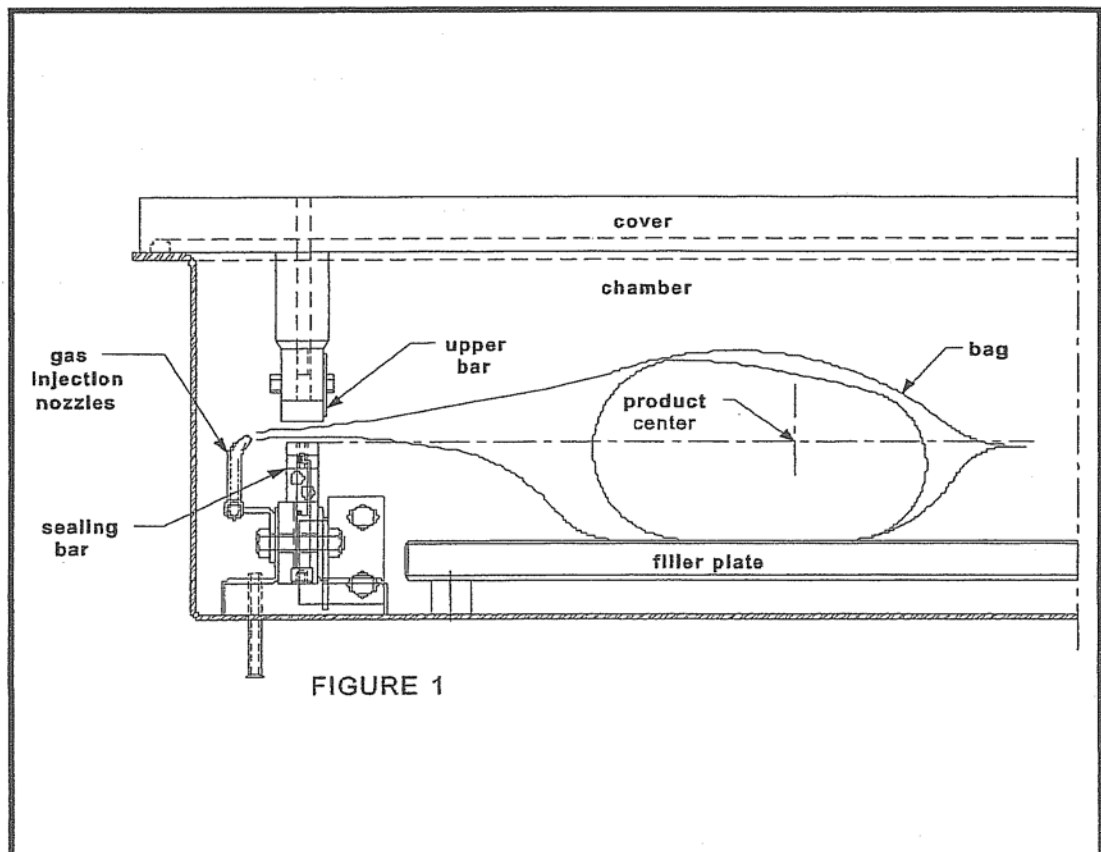
3.OPERATION:

3.1 Working principles:

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

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

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



3.2 Special packaging:

3.2.1 Gas flushing (option):

There is an atmospheric pressure of 1 kg/ sq. cm (14 lbs/sq. inch) 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 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 (sec.) can be set in the program menu.

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

3.2.2 Electrical bag cut (optional):

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

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 13 and the keyboard detail on page 14.

3.3.1 Basics:

Use key "POWER" to power ON / OFF the vacuum packaging machine. When the unit is energized, the identification of the last executed program is displayed on LCD screen. 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 key "SELECT" to select a function and key "ENTER" to accede and executed the selection.

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

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

In program submenu, use key "ESC" to get back to the programs menu. Strike any key

to clear the error messages which may be displayed on LCD screen.

3.3.2 Functions menu:

3.3.2.1 Create a program:

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

3.3.2.2 Delete a program:

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

3.3.2.3 Select operating mode:

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

3.3.3 Programs menu:

3.3.3.1 Program identification:

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

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

3.3.3.2 Vacuum time setting (sensor disabled):

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

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

3.3.3.3 Vacuum level setting (sensor enabled)

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

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

3.3.3.4 Vacuum plus time setting (sensor enabled)

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

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

3.3.3.5 Gas time setting (sensor disabled)

For a selected program set the gas time setting following the same procedure as for the vacuum time. Keep in mind that increasing gas time decrease sealing pressure. Some vacuum must be kept inside to assure proper functioning.

3.3.3.6 Gas flush level setting: (sensor enabled)

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

3.3.3.7 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). The sealing time is truncated to the nearest half hundredth. In a middle of an acquisition, use key "ENTER" to validate the sealing time and key "ESC" to come backward and start over with a new acquisition (the old sealing time is blinking).

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

3.3.4 Vacuum cycle execution:

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

- Vacuum time or vacuum % status during vacuum sequence,
- Gas time or gas % status during gas flush sequence,
- Sealing time status during sealing sequence,
- ATM message during atmosphere sequence.

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

3.3.5 System monitor:

To accede the diagnostics menu, power up the vacuum packaging machine while keeping pushed in the "ESC"key. Use key "SELECT" to select the system monitor function and key "ENTER" to accede and visualize the monitored parameters. Use key "SELECT" to change over from the software revision, the amount of working hours done and the amount of complete cycles performed since first initialization.

-MENUS STRUCTURE-

- **Functions menu:**
 - "F1 CREATE A PRGM"
 - "F2 DELETE A PRGM"
 - "F3 SELECT OPMODE" (automatic units only)
- **Programs menu:**
 - "Pxx NAME"
 - Program submenu:
 - "VACUUM: xx.x%" (10.0% - 99.5%)
 - "VACUUM PLUS: xxs" (0s - 99s)
 - "VACUUM: xx.xs" (10 – 199s) (sensor disabled in D8 menu)
 - "GAS FLUSH: xx.xs" (0 – 99s) (units with gas option) (sensor disabled in D8)
 - "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"
 - "D2 OUTPUTS TEST"
 - "D3 MODEL SELECT"
 - "D4 GAS OPTION"
 - "D5 SEALING TIME"
 - "D6 COOLING TIME"
 - "D7 OFFSET CALIB"
 - "D8 VACUUM SENSOR"
 - "D9 SIPROMAC PUB"
 - "D10 LOADING TIME" (automatic units only)
 - "D11 UNLOADNG TIME" (automatic units only)
 - "SYSTEM MONITOR" (no access code required)
 - "SOFTWARE: R x.xx"
 - "WORK HRS: xxxxx"
 - "CYCLES: xxxxxxxx"

-KEYBOARD DETAILS-

MC-40 CONTROLS





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

3.4 Daily cleaning

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

Cleaning instructions for gas injection nozzles: 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.

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

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

The input signal of the down position switch has been lost during cycle execution.
- Check limit switch adjustment.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

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

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

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

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

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

4.2.2 No leakage in the bag:

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

Vacuum time is too short:

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

4.2.3 Insufficient vacuum in chamber:

If troubles described under 4.2.1 and 4.2.2 do not apply, there is something wrong with the evacuation. To find the leakage quickly, check for leaks with a precision

vacuumeter, going back step by step from the chamber to the pump.

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

Verify at vacuum hose connections and valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactors does not work.

4.3.3 Permanent sealing current:

Contactors is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

Check whether there is voltage on the magnetic valves during their period of operation. If there is no voltage a wire is broken or the PC board is damaged.
Lid does not open at the end of the cycle; air enters, but there is still 20 - 40% vacuum in chamber. Vacuum valve does not close.

4.5 MC40 Control board failure

NOTE: Refer to menu structure on page 13.

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.

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.

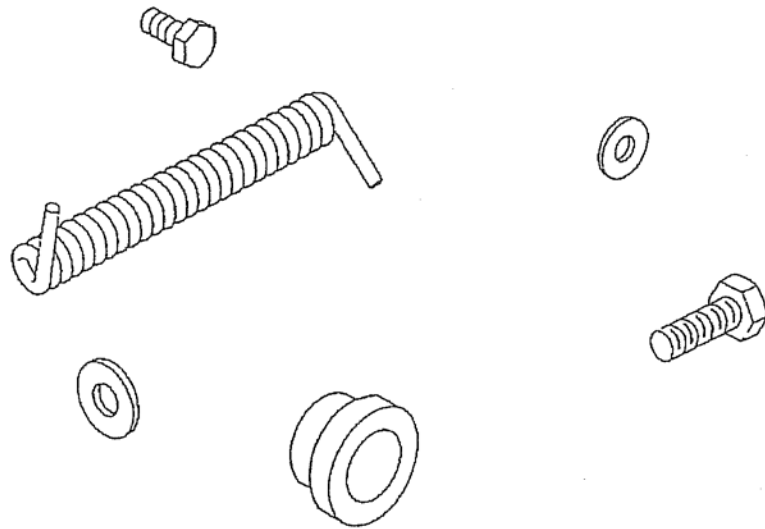
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

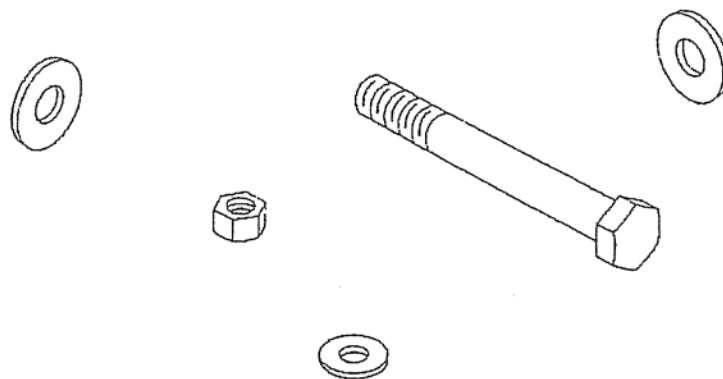
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

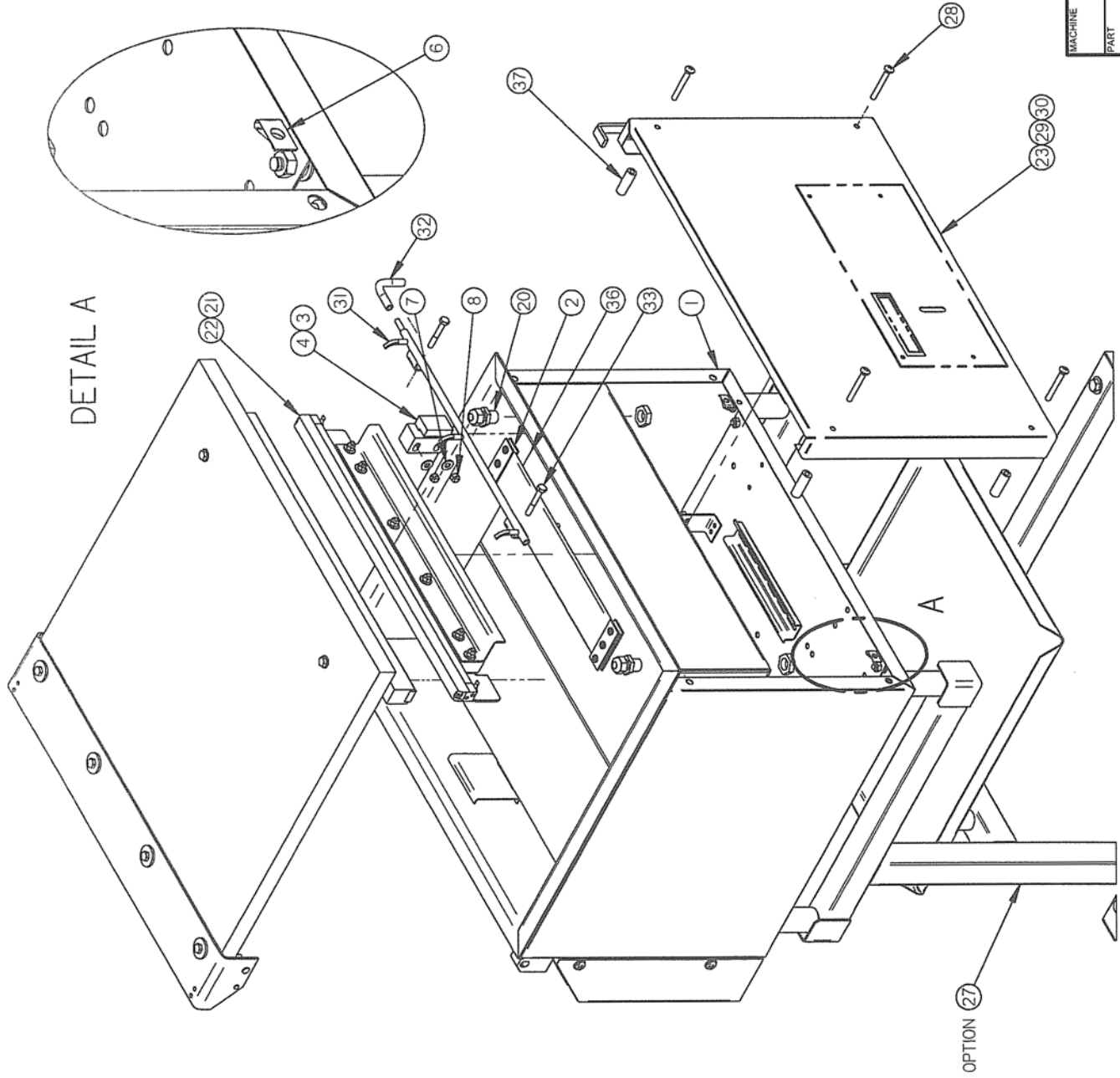
Check function of cycle with various settings of timers.



MECHANICAL DRAWING

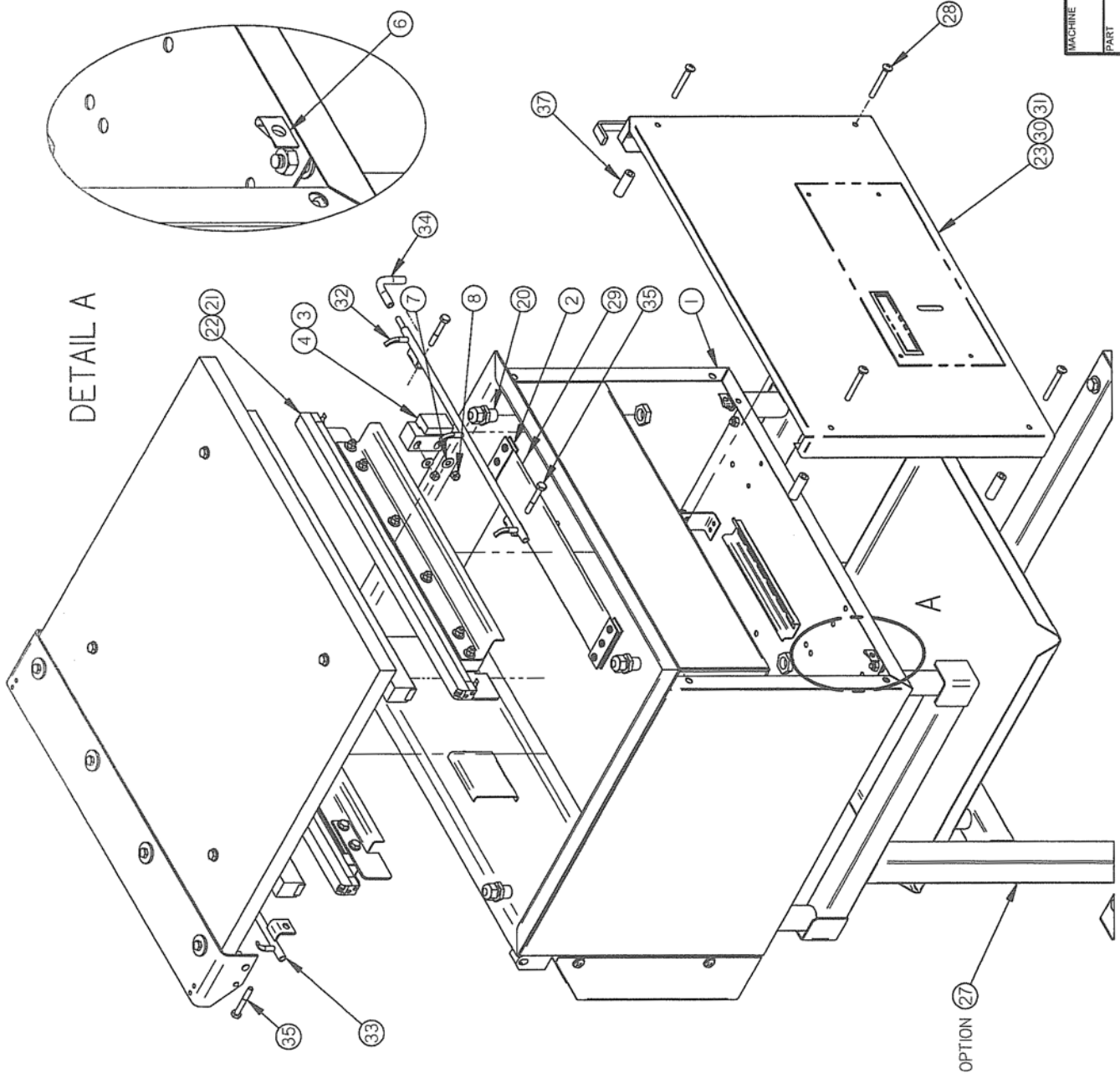


ITEM	PART #	DESCRIPTION	QT.
1	004A0229	VACUUM PRE-ASSEMBLY	1
2	005-0532	BELLOWS ASSEMBLY	1
3	002-0029	LEFT SEAL BAR GUIDE BLOCK	1
4	002-0030	RIGHT SEAL BAR GUIDE BLOCK	1
5	005A0266	COVER ASSMBLY	1
6	056-0020	SPRING NUT 1/4"-20 STEEL	8
7	051-0740	WASHER 1/4" FLAT S/S	28
8	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
9	004A1224	SPRING PRE-ASSEMBLY	2
10	002A3528	NSF FOOT	4
11	051-0288	BOLT 1/4-20 x 3 1/2" S/S	4
12	002-0024	HINGE BLOCK	2
13	051-0232	SCREW 1/4-20x 1-1/4"SKT CAP SS	4
14	051-0580	NUT 1/4"-20 S/S	16
15	004A3374	LIMIT SWITCH ASSY	1
16	001-1337	REAR SPRING SUPPORT	2
17	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	4
18	004-0042	ELEC. SUPPORT PRE-ASSY	1
19	058-0030	NYLON SPACER 3/8IDx3/4ODx1/16	4
20	036-0400	WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT	2
21	005A1356	SEAL BAR ASSEMBLY W/SUPP. BAG CUT	1
22	005A1355	SEAL BAR ASSEMBLY W/SUPP. TWIN SEAL	1
23	005C0832	FRONT PANEL ASSY W/VAC SEN (SI)	1
24	004A0361	REAR PANNEL PRE-ASSY	1
25	051-0185	SCREW 1/4-20x 1/2" PAN PHIL S/S	4
26	051-0930	BOLT M6 x 10 S/S	4
27	005B1031	STAND ASSEMBLY (OPTION)	1
28	051-0264	SCREW 1/4-20x 2" PAN PHIL SS	4
29	005B1341	FRONT PANEL ASSY W/VAC SEN (BK)	1
30	005B1339	FRONT PANEL ASSY W/VAC SEN (BSA)	1
31	005A0533	LEFT GAS INJECTION BAR ASSEMBLY	1
32	104-0064	SURGERY TUBE 3/8"OD x 3/16"ID x 90	2
33	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	2
34	004B3857	REAR PANNEL PRE-ASSY	1
35	005A0278	FILLER PLATE ASSY	1
36	005A0364	HALF FILLER PLATE ASSY	2
37	003A0370	PANEL SPACER	4
38	051-0190	BOLT 1/4-20 x 3/4" HEX S/S	4



MACHINE	350	DEPT. TOL. METRIC INCH	±0.1	±0.004"
PART	MACHINE ASSEMBLY	USINAGE	±0.5	±0.002"
ITEM	CNC	SOUDAGE	±0.5	±0.020"
MAT.		N.T.S.		
DATE	12-11-27	DEPT.	M-1	QTY. 1
APP. BY	J.G.	NO.	005A0610	

REDESSINE MODIF. A-462 ETAIT AUSSI 005-0612 12-1-26 J.G.
 DATE INT.
 MODIFICATION



ITEM	PART #	DESCRIPTION	QT.
1	004A0230	VACUUM PRE-ASSEMBLY	1
2	005-0532	BELLOWS ASSEMBLY	1
3	002-0029	LEFT SEAL BAR GUIDE BLOCK	2
4	002-0030	RIGHT SEAL BAR GUIDE BLOCK	2
5	005A0481	COVER ASSEMBLY	1
6	056-0020	SPRING NUT 1/4"-20 STEEL	8
7	051-0740	WASHER 1/4" FLAT S/S	32
8	051-0581	NUT 1/4"-20 NYLON LOCK S/S	12
9	004A1224	SPRING PRE-ASSEMBLY	2
10	002A3528	NSF FOOT	4
11	051-0288	BOLT 1/4-20 x 3 1/2" S/S	4
12	002-0024	HINGE BLOCK	2
13	051-0232	SCREW 1/4-20x 1-1/4"SKT CAP SS	4
14	051-0580	NUT 1/4"-20 S/S	16
15	004A3374	LIMIT SWITCH ASSY	1
16	001-1337	REAR SPRING SUPPORT	2
17	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	4
18	004-0042	ELEC. SUPPORT PRE-ASS'Y	1
19	058-0030	NYLON SPACER 3/8IDx3/4ODx1/16	4
20	036-0400	WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT	4
21	005A1356	SEAL BAR ASSEMBLY W/SUPP. BAG CUT	2
22	005A1355	SEAL BAR ASSEMBLY W/SUPP. TWIN SEAL	2
23	005C0832	FRONT PANEL ASSY W/VAC SEN (SI)	1
24	004A0361	REAR PANNEL PRE-ASS'Y	1
25	051-0185	SCREW 1/4-20x 1/2" PAN PHIL S/S	4
26	051-0930	BOLT M6 x 10 S/S	4
27	005B1031	STAND ASSEMBLY (OPTION)	1
28	051-0264	SCREW 1/4-20x 2" PAN PHIL SS	4
29	005A0365	FILLER PLATE ASSY	2
30	005B1341	FRONT PANEL ASSY W/VAC SEN (BK)	1
31	005B1339	FRONT PANEL ASSY W/VAC SEN (BSA)	1
32	005A0533	LEFT GAS INJECTION BAR ASSEMBLY	1
33	005A0808	RIGHT GAS INJECTION BAR ASSEMBLY	1
34	104-0064	SURGERY TUBE 3/8"OD x 3/16"ID x 90	2
35	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	4
36	004B3857	REAR PANNEL PRE-ASS'Y	1
37	003A0370	PANEL SPACER	4
38	051-0190	BOLT 1/4-20 x 3/4" HEX S/S	4

350D
MACHINE ASSEMBLY

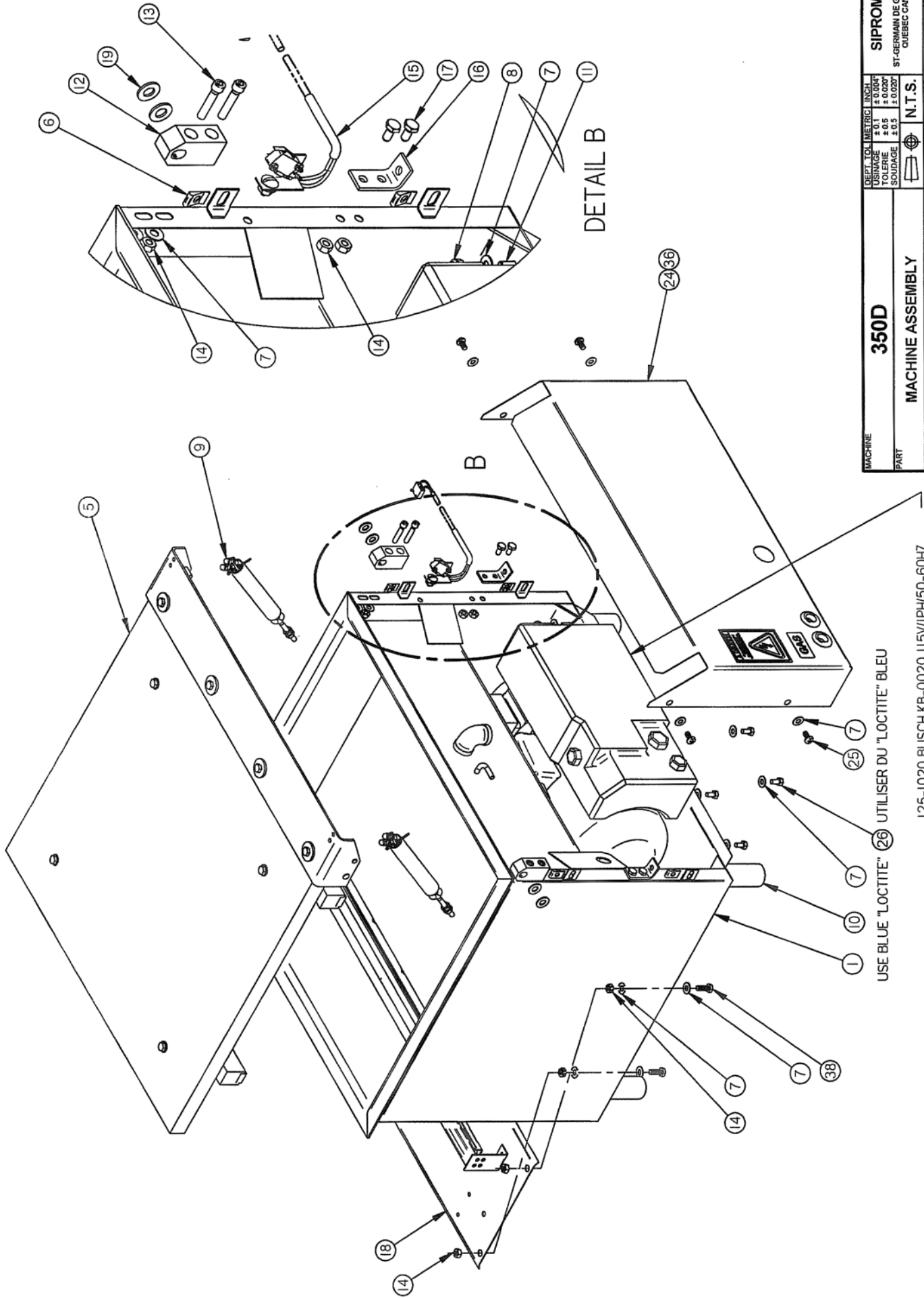
DEPT. TOL. METRIC INCH
USINAGE ±0.1 ±0.004
TOLERANCE ±0.5 ±0.0027
SOUDAGE ±0.5 ±0.0027

STIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

ITEM: _____ DEPT.: M-1 QTY.: 1
MAT.: _____ DATE: 12-11-27
APP. BY: J.G. DATE: _____

RECESSINE MODIF. A-462 ETAIT AUSSI 005-0613 12-11-26 J.G.
LET. _____ DATE INT. _____
MODIFICATION

005A0611

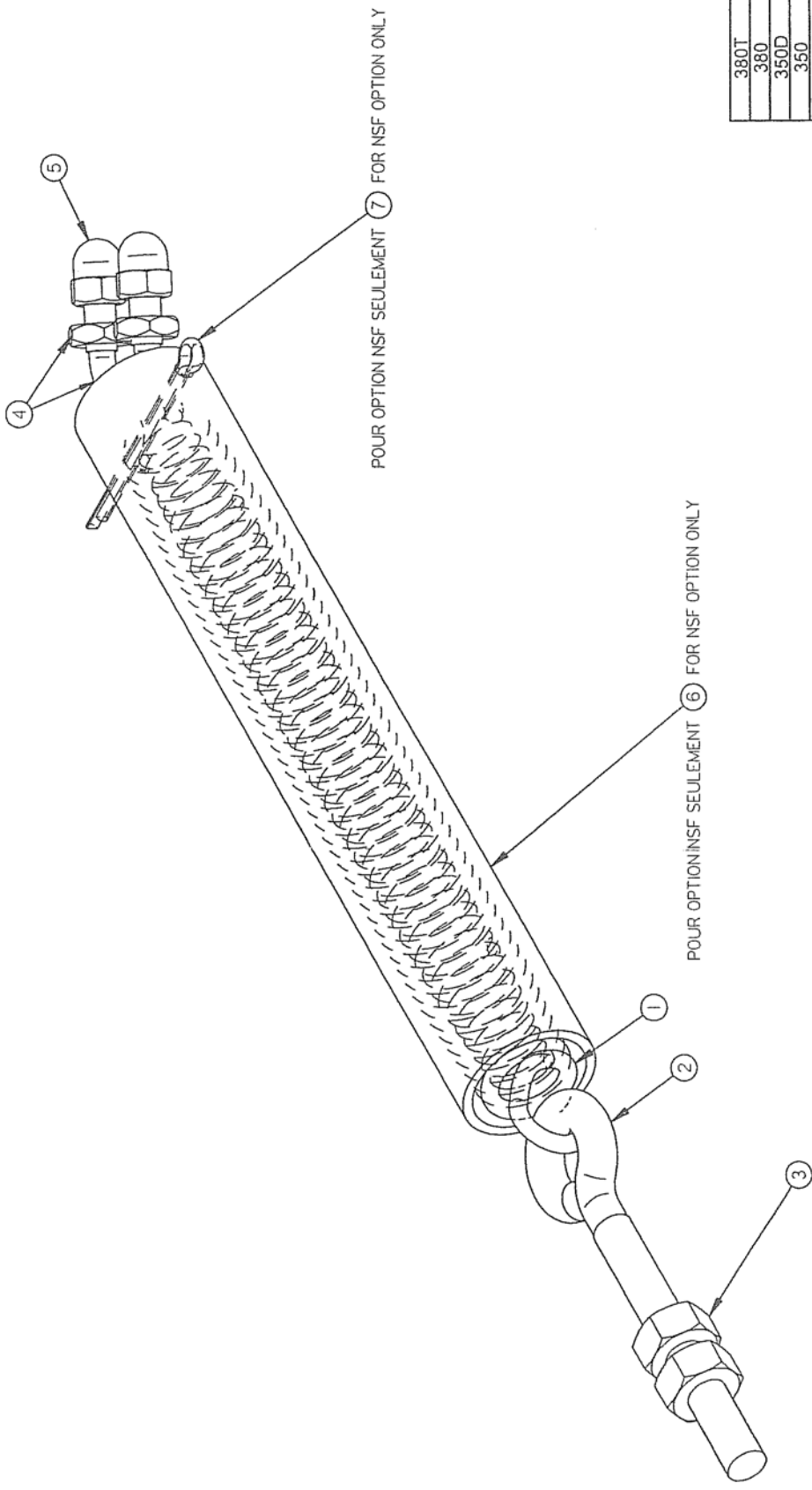


MACHINE	350D		DEPT. TOL. METRIC INCH		SIPROMAC	
PART	MACHINE ASSEMBLY		USINAGE ± 0.1	± 0.004	ST-GERMAIN DE GRANTHAM	
ITEM	CNC		TOLENE ± 0.5	± 0.020	QUEBEC CANADA	
MAT.	DWG BY J.G.		SOUDAGE ± 0.5	± 0.020		
	APP. BY	DATE 12-11-27			DEPT. M-H	QTY. 1
						005A0611

USE BLUE "LOCTITE" (26) UTILISER DU "LOCTITE" BLEU
 125-1020 BUSCH KB-0020 115V/1PH/50-60HZ
 125-1021 BUSCH KB-0020 220-240V/1PH/50-60HZ

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



POUR OPTION NSF SEULEMENT (7) FOR NSF OPTION ONLY

POUR OPTION NSF SEULEMENT (6) FOR NSF OPTION ONLY

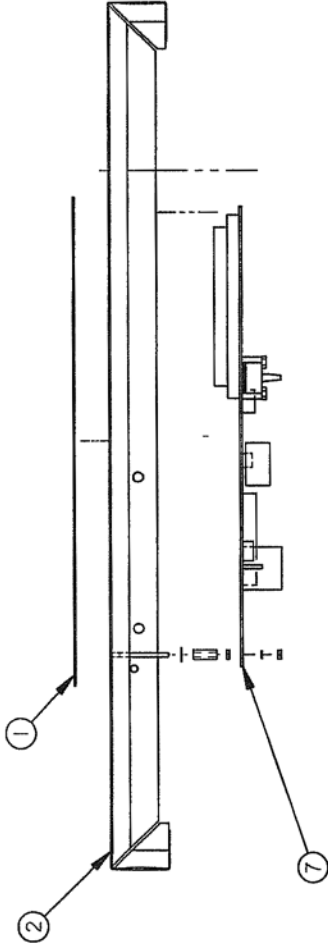
MACHINE	QTY
380T	4
380	2
350D	2
350	2
300	2
MACHINE	QTY

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

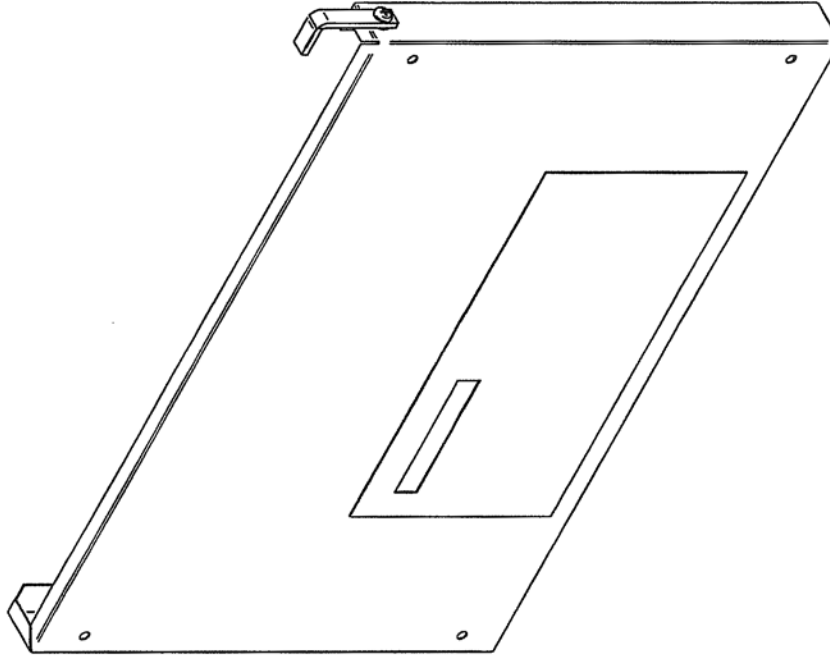
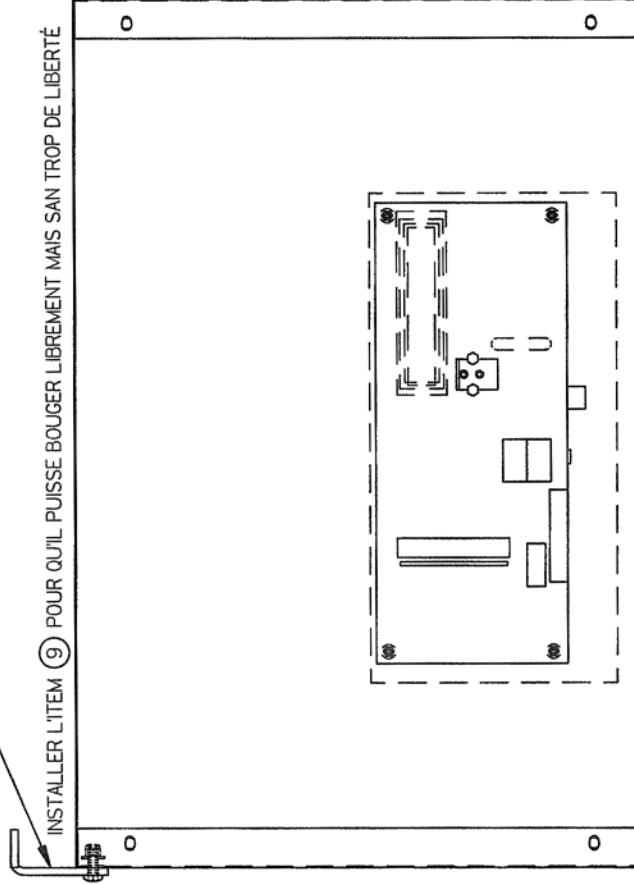
LET.	MODIFICATION	DATE	INT.
E	AJOUTER ITEM 008A1603 & 056-0118 (NSF)	10-11-09	J.G.
D	ADDED ITEM #3 051-0580 QTY : 2	05-05-05	M.A.
C	ADDED 380T	05-02-03	M.A.
B	009A0152 WAS 077-0002	04-12-07	M.A.
A	AJOUTER 380 DANS CARTOUCHE	03-09-04	J.P.

1005C0832

ITEM	PART #	DESCRIPTION	QT.
1	033-0015	MC-40 KEYBOARD "SIPROMAC"	1
2	001C3123	FRONT FLAT PANEL	1
3	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
4	051-0720	WASHER #8 FLAT S/S	4
5	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
6	051-0540	NUT #4-40 HEX S/S	8
7	033-0038	MC-40 SENSOR VACUUM	1
8	051-0715	WASHER #4 LOCK SS	4
9	004A1651	COVER HOLD DOWN PRE-ASSY	1



INSTALL ITEM ⑨ SO THAT IT CAN MOVE FREELY BUT WITHOUT TOO MUCH LOOSENESS



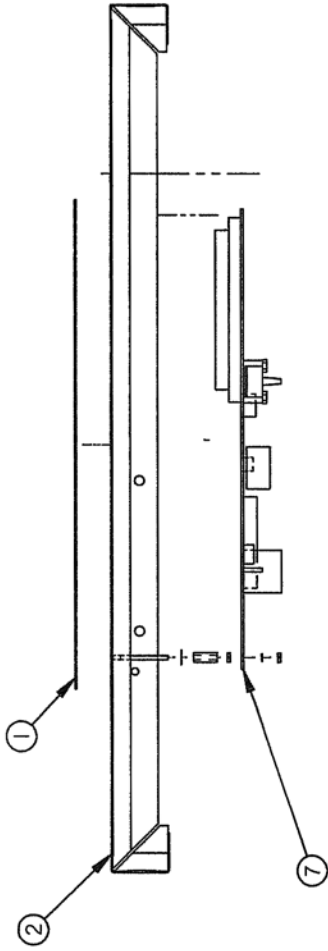
**-VACUUM SENSOR OPTION-
-SIPROMAC OPTION -**

MACHINE		DEPT. LOC. METRIC INCH		SIPROMAC	
PART		USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		TOLERANCE ± 0.5	± 0.002"	QUEBEC CANADA	
MAT.		SOUDAGE ± 0.5	± 0.027"	DEPT. M-11	
FRONT PANEL ASSY WVAC SEN (SI)		N.T.S.		NO. 1	
CNC		DATE 12-10-15		005C0832	
DWG BY J.G.		DATE		APP. BY	
MODIFICATION		DATE		INT.	

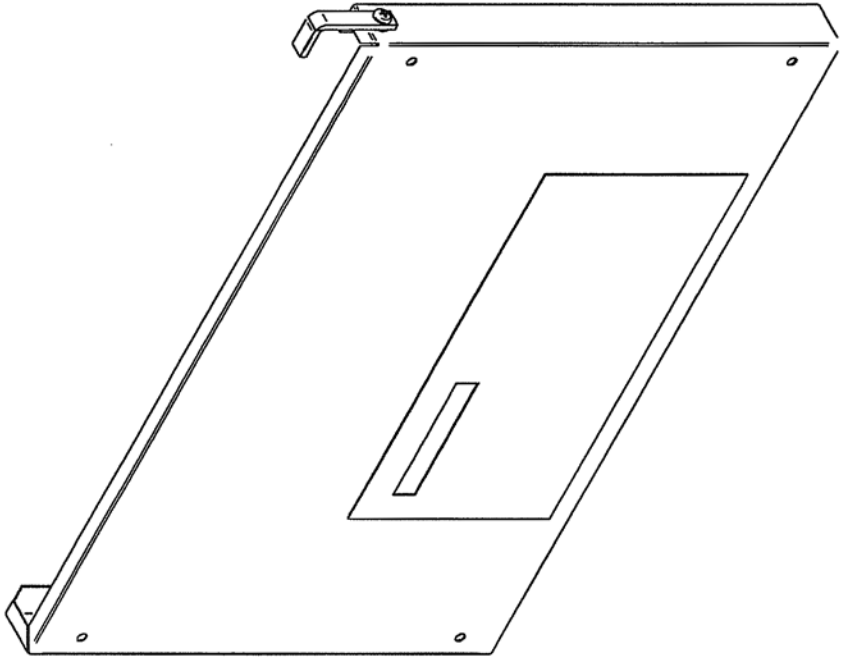
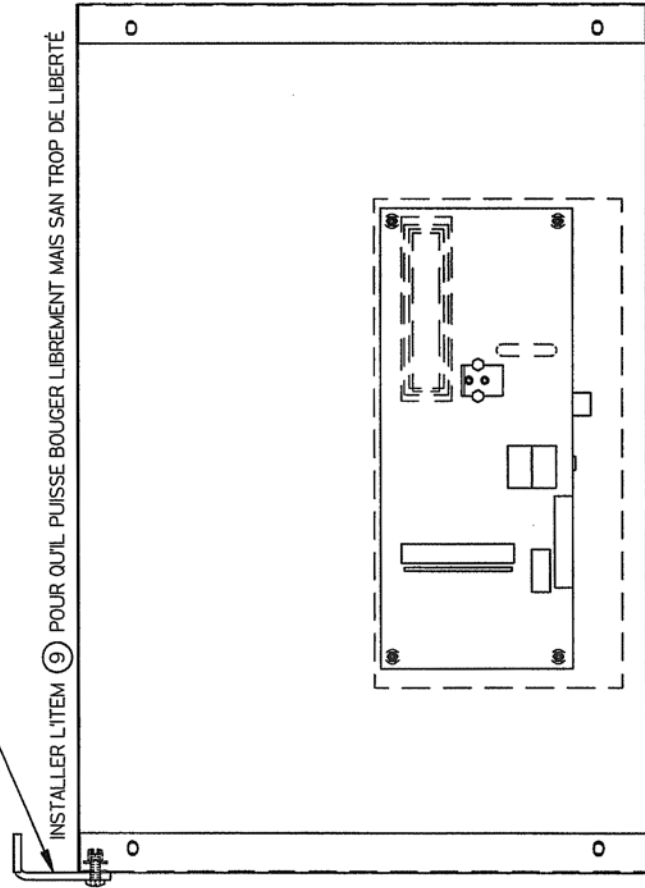
A REDESSINE MODIF. #A-462 12-10-15 J.G.
LET. MODIFICATION DATE INT.

1005B1341

ITEM	PART #	DESCRIPTION	QT.
1	033-0018	MC-40 KEYBOARD "BERKEL"	1
2	001C3123	FRONT FLAT PANEL	1
3	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
4	051-0720	WASHER #8 FLAT S/S	4
5	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
6	051-0540	NUT #4-40 HEX S/S	8
7	033-0038	MC-40 SENSOR VACUUM	1
8	051-0715	WASHER #4 LOCK SS	4
9	004A1651	COVER HOLD DOWN PRE-ASSY	1



INSTALL ITEM ⑨ SO THAT IT CAN MOVE FREELY BUT WITHOUT TOO MUCH LOOSENESS



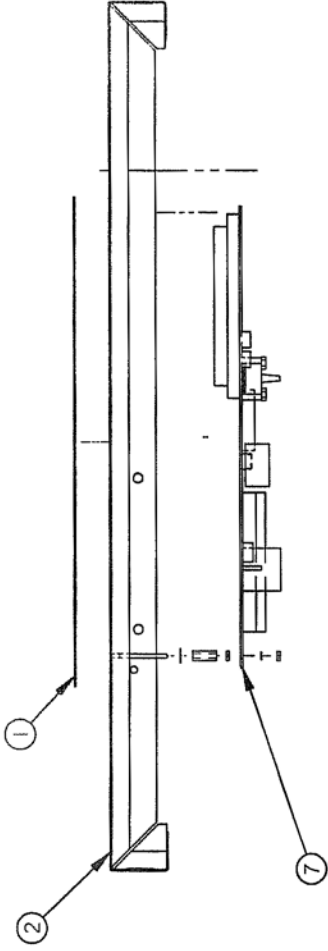
**-VACUUM SENSOR OPTION-
-BERKEL OPTION -**

MACHINE	350 & 350D	DEPT. TOU	METRIC	INCH	USINAGE	± 0.1	± 0.004	SIPPROMAC
PART	FRONT PANEL ASSY WVAC SEN (BK)	TOLERANCE	± 0.5	± 0.020"	SOLDAGE	± 0.3	± 0.050"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM	CNC	DATE	12-10-15	N.T.S.	DEPT.	M-(M)-1	QTY.	1
APP. BY	J.G.	DATE	12-10-15	NO.	1005B1341			

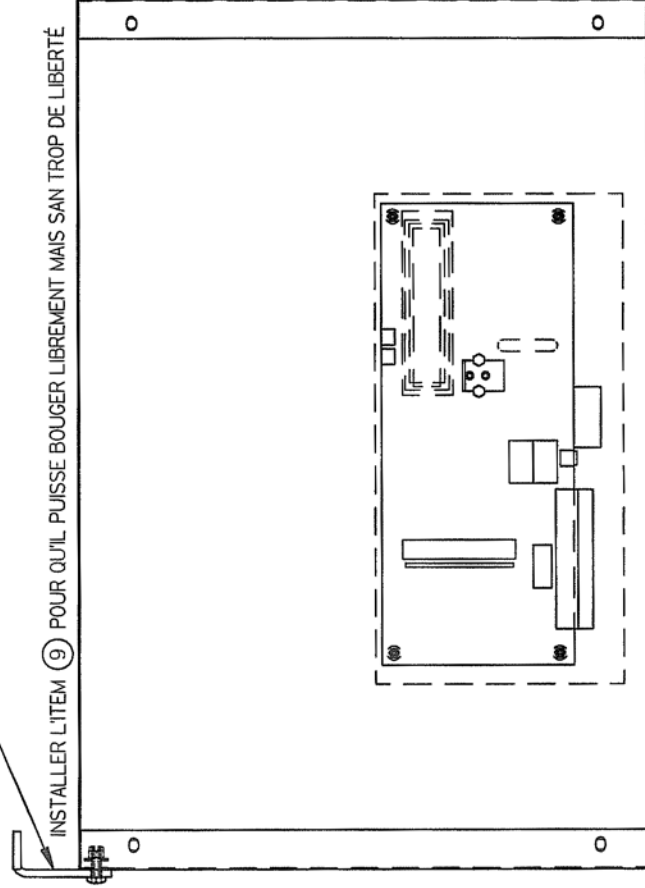
A	REDESSINE MODIF. #A-462	12-10-15	J.G.
LET.	MODIFICATION	DATE	INT.

005B1339

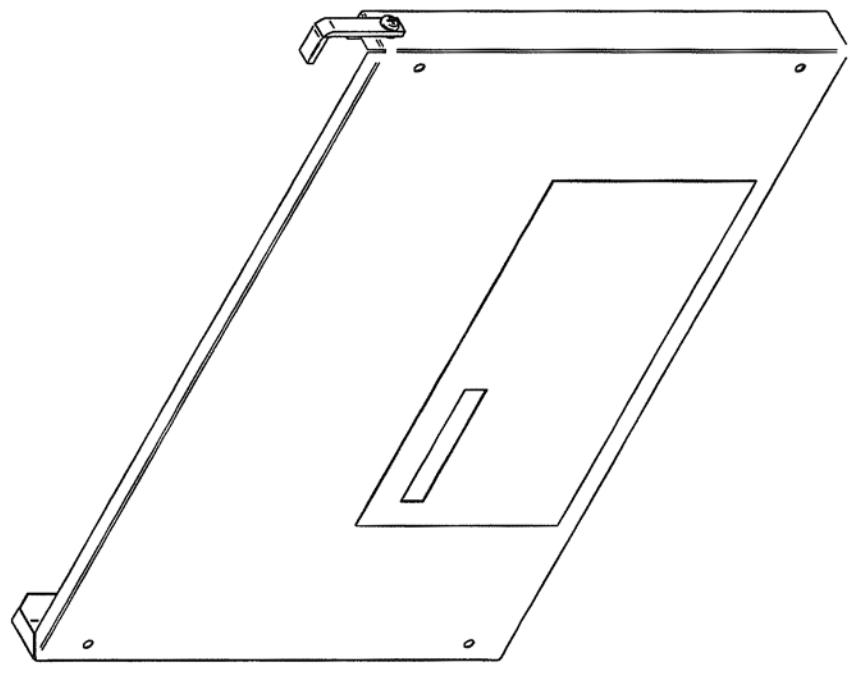
ITEM	PART #	DESCRIPTION	QT.
1	033-0019	MC-40 KEYBOARD "BSA"	1
2	001C3123	FRONT FLAT PANEL	1
3	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
4	051-0720	WASHER #8 FLAT S/S	4
5	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
6	051-0540	NUT #4-40 HEX S/S	8
7	033-0038	MC-40 SENSOR VACUUM	1
8	051-0715	WASHER #4 LOCK SS	4
9	004A1651	COVER HOLD DOWN PRE-ASS'Y	1



INSTALL ITEM ⑨ SO THAT IT CAN MOVE FREELY BUT WITHOUT TOO MUCH LOOSENESS



INSTALLER L'ITEM ⑨ POUR QU'IL PUISSE BOUGER LIBREMENT MAIS SANS TROP DE LIBERTÉ



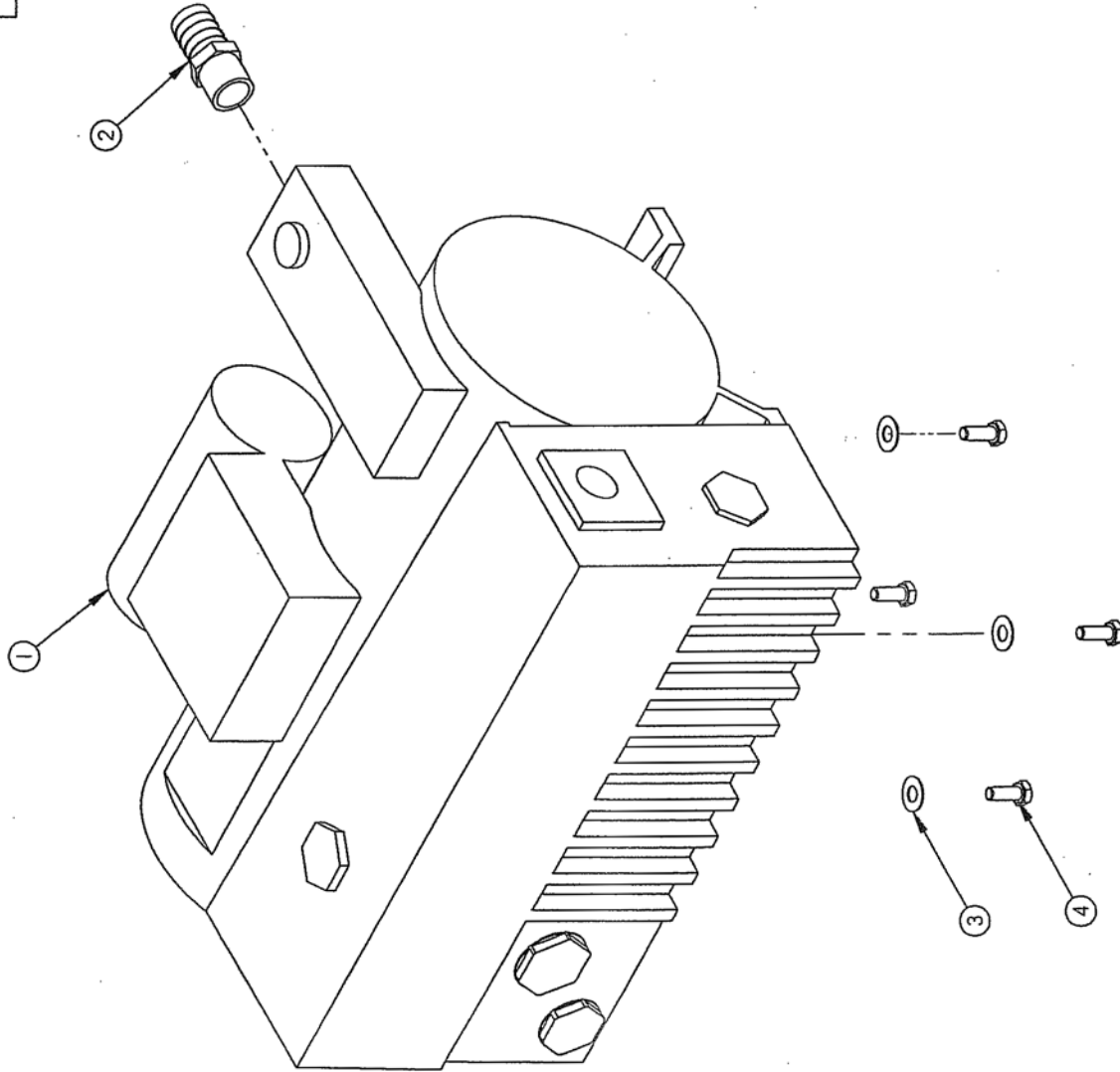
**-VACUUM SENSOR OPTION-
-BSA OPTION -**

MACHINE		DEPT. TOL. METRIC INCH		SIPROMAC	
350 & 350D		USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
PART		TOLERIE ± 0.5	± 0.020"	QUEBEC CANADA	
FRONT PANEL ASS'Y W/VAC SEN (BSA)		SOUDAGE ± 0.5	± 0.020"	N.T.S.	
ITEM		CNC		DEPT. M-(M)-1	
MAT.		DWG BY J.G.		NO. 12-10-15	
		APP. BY		DATE	
				QTY. 1	
				005B1339	

A	REDESSINE MODIF #A-462 ETAIT SANS VAC. SENSOR	12-10-15	J.G.
LET.	MODIFICATION	DATE	INT.

1004-0346

ITEM	PART #	DESCRIPTION	QT.
1	125-1020	BUSH PUMP KB-20 /115V/1PH/60HZ	1
2	101-0220	STRAIGHT 1/2"MNPTx3/4" HOSE BARB BRASS	1
3	051-0740	WASHER 1/4" FLAT S/S	4
4	051-0950	BOLT M6 x 16 SS	4

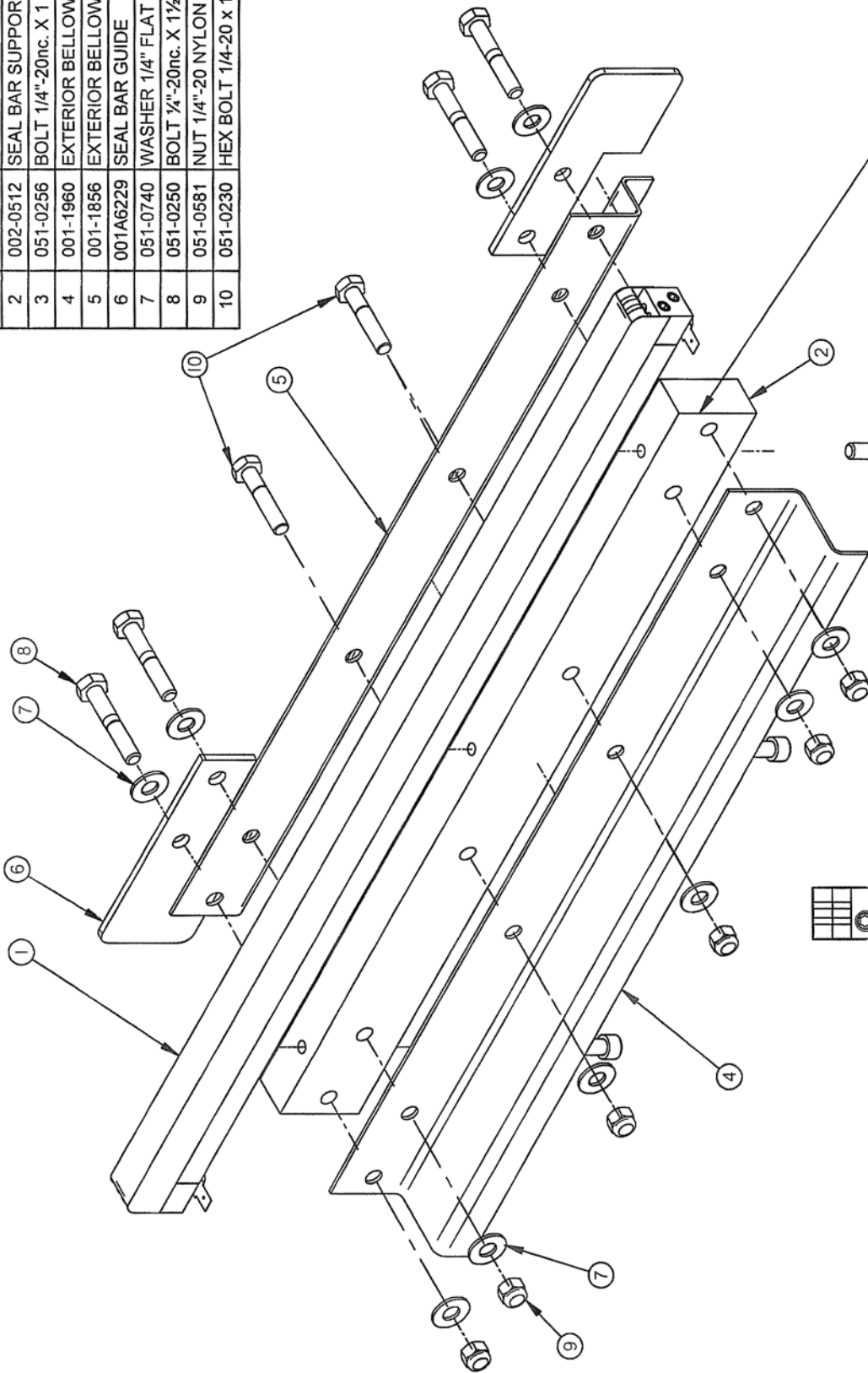


MACHINE	DEPT. TOL. METRIC	INCH	SIPROMAC
350, 350D, 380 & 380T	USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM
PART	TOLERIE ± 0.5	± 0.020"	QUEBEC CANADA
"BUSCH" PUMP INSTALATION	SOUDAGE ± 0.5	± 0.020"	
ITEM	CNC	DEPT.	M
QTY.			1
DATE	DATE	NO.	004-0346
02-03-11	02-03-11	004-0346	
DESIGNED BY	APP. BY		

A	ADDED 380T	06-01-28	M.A.
LET.	MODIFICATION	DATE	INT.

005A1355

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



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

-TWIN SEAL OPTION-

350D	2
350	1
300D	2
300	1
MACHINE	QTY

SIPROMAC
 ST-GERMAIN DE GRANTHAM
 QUEBEC CANADA

M-I-(M) LIST
 NO. 005A1355

DEPT.	TOL. METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"
N.T.S.		

MACHINE
300, 300D, 350 & 350D
 PART
SEAL BAR ASSEMBLY W/SUPPORT

ITEM
 CNC
 DWG BY J.G.
 DATE 12-09-24
 APP. BY
 MAY.

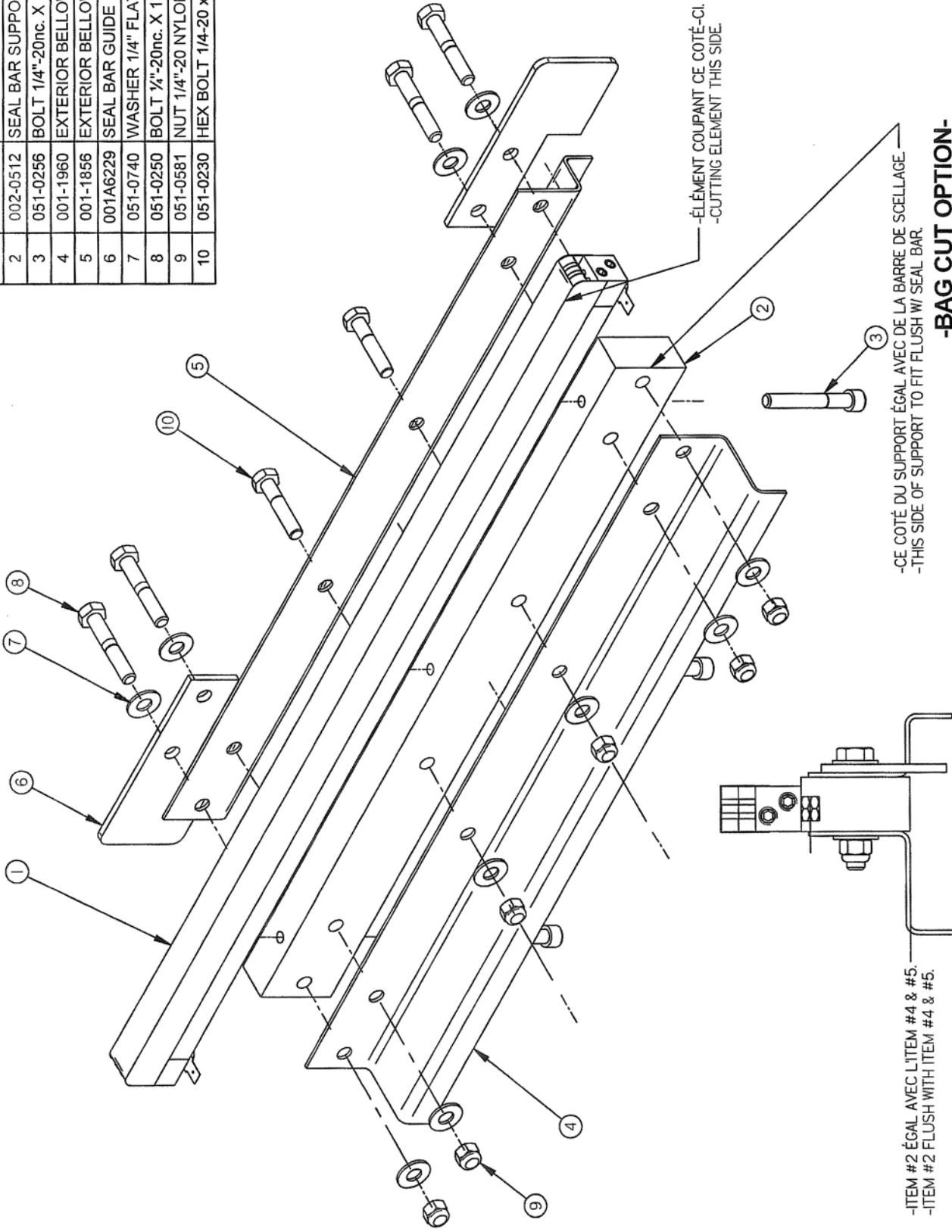
RECESSINE ETAIT 005B0046
 DATE 12-09-24 J.G.
 INT.
 MODIFICATION

-END VIEW-

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

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 BELLOW COVER	1
5	001-1856	EXTERIOR BELLOW COVER	1
6	001A6229	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	10
8	051-0250	BOLT 3/4"-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.

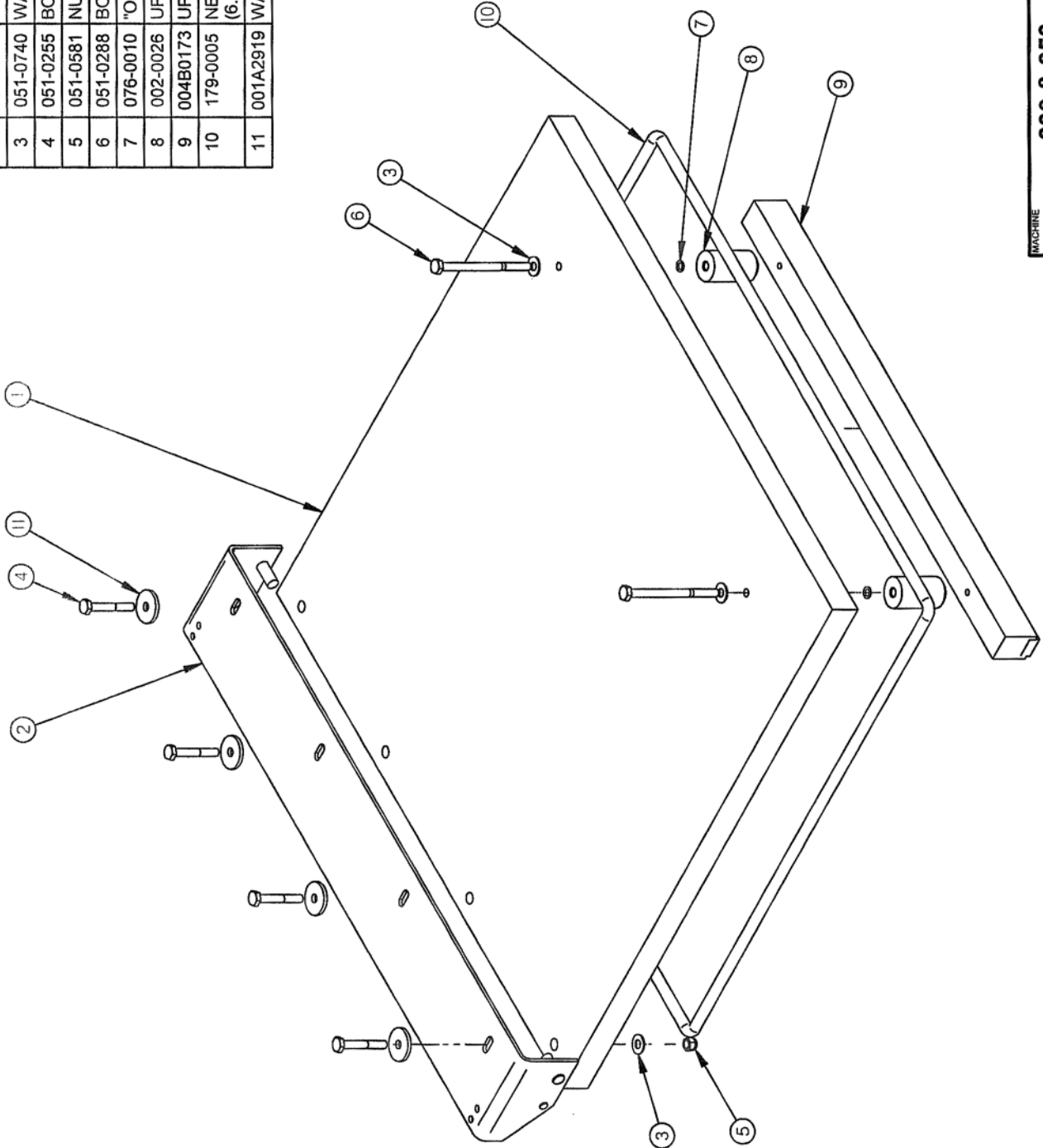
-END VIEW-

-BAG CUT OPTION-

MACHINE		DEPT. Q. METRIC INCH	
300, 300D, 350 & 350D		USINAGE	± 0.1 ± 0.004
SEAL BAR ASSEMBLY W/SUPPORT		TOLERANCE	± 0.5 ± 0.007
PART		SOUDAGE	± 0.5 ± 0.020
ITEM		N.T.S.	
CNC		DEPT.	
DWG BY J.G.		DATE 12-09-24	
APP BY		DATE	
M-F-(M)		QTY LIST	
REDESSINE ETAIT 005B0558		NO 005A1356	
MODIFICATION		ST-GERMAIN DE GRANTHAM	
A		QUEBEC CANADA	
LET.		MACHINE QTY	
		350D 2	
		350 1	
		300D 2	
		300 1	
		MACHINE QTY	

005A0266

ITEM	PART #	DESCRIPTION	QT.
1	002A0025	PLEXI COVER	1
2	004A0021	COVER HINGE ASSEMBLY	1
3	051-0740	WASHER 1/4" FLAT S/S	6
4	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	4
5	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
6	051-0288	BOLT 1/4-20 x 3 1/2" S/S	2
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	001A2919	WASHER 0.381" ID X 1.062" OD X 3	4

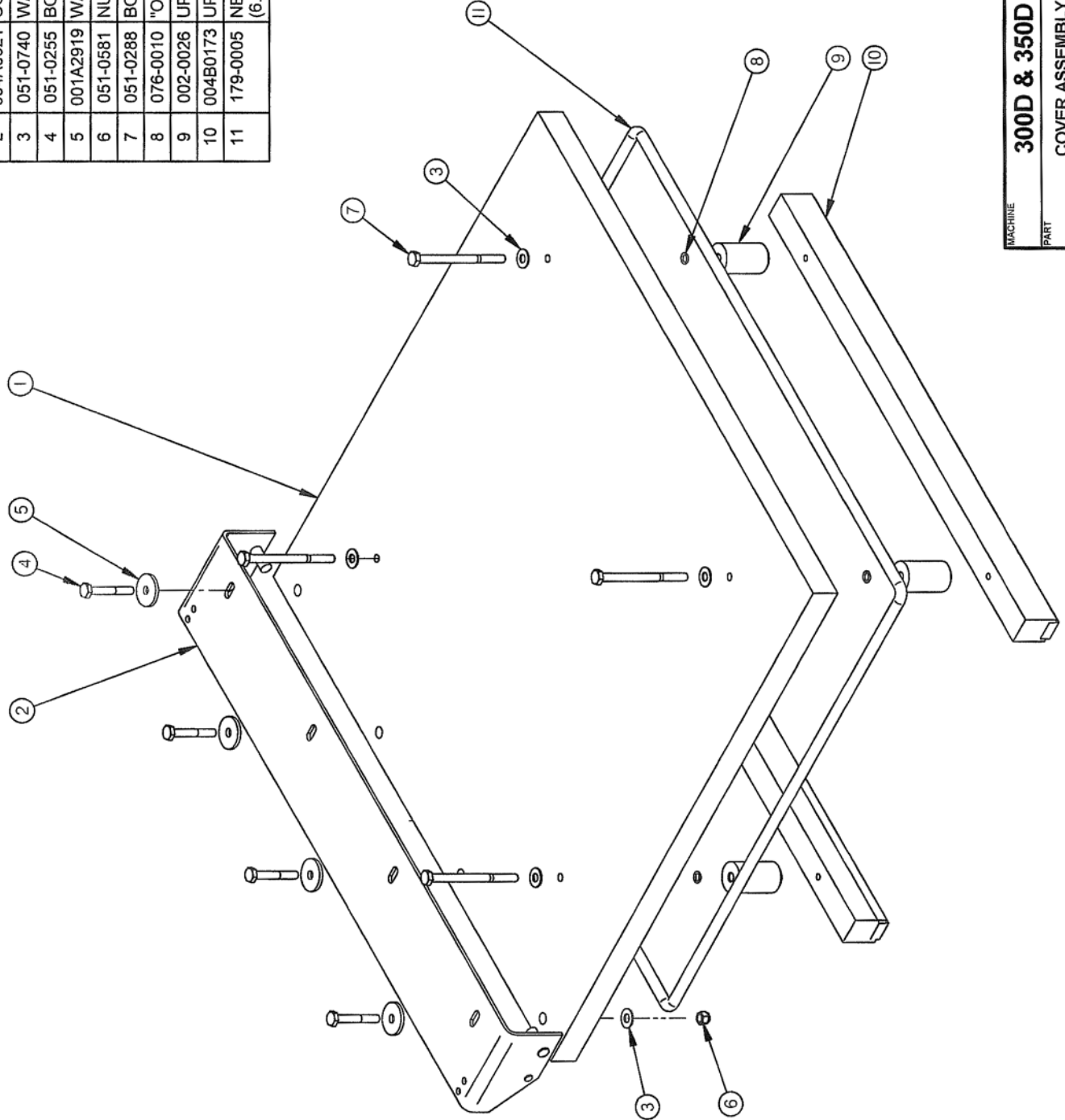


MACHINE	300 & 350	DEPT. TOL. METRIC INCH	USINAGE ± 0.1 ± 0.004"
PART	COVER ASSEMBLY	TOLERIE ± 0.5 ± 0.020"	SOUDEGE ± 0.5 ± 0.020"
ITEM	CNC	N.T.S.	
MAT.	DWG BY J.G.	DATE 12-10-15	DEPT. M-(M) QTY. 1
	APP. BY		NO. 005A0266

LET. _____ DATE INT. _____ MODIFICATION _____

005A0481

ITEM	PART #	DESCRIPTION	QT.
1	002A0392	PLEXI COVER	1
2	004A0021	COVER HINGE ASSEMBLY	1
3	051-0740	WASHER 1/4" FLAT S/S	8
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	051-0288	BOLT 1/4-20 x 3 1/2" S/S	4
8	076-0010	"O" RING 1/4" x 3/8" x 1/16"	4
9	002-0026	UPPER SEAL BAR SPACER	4
10	004B0173	UPPER SEAL BAR PRE-ASS'Y	2
11	179-0005	NEOPRENE SPONGE 3/8" O.D. 2042mm (6.7')	1



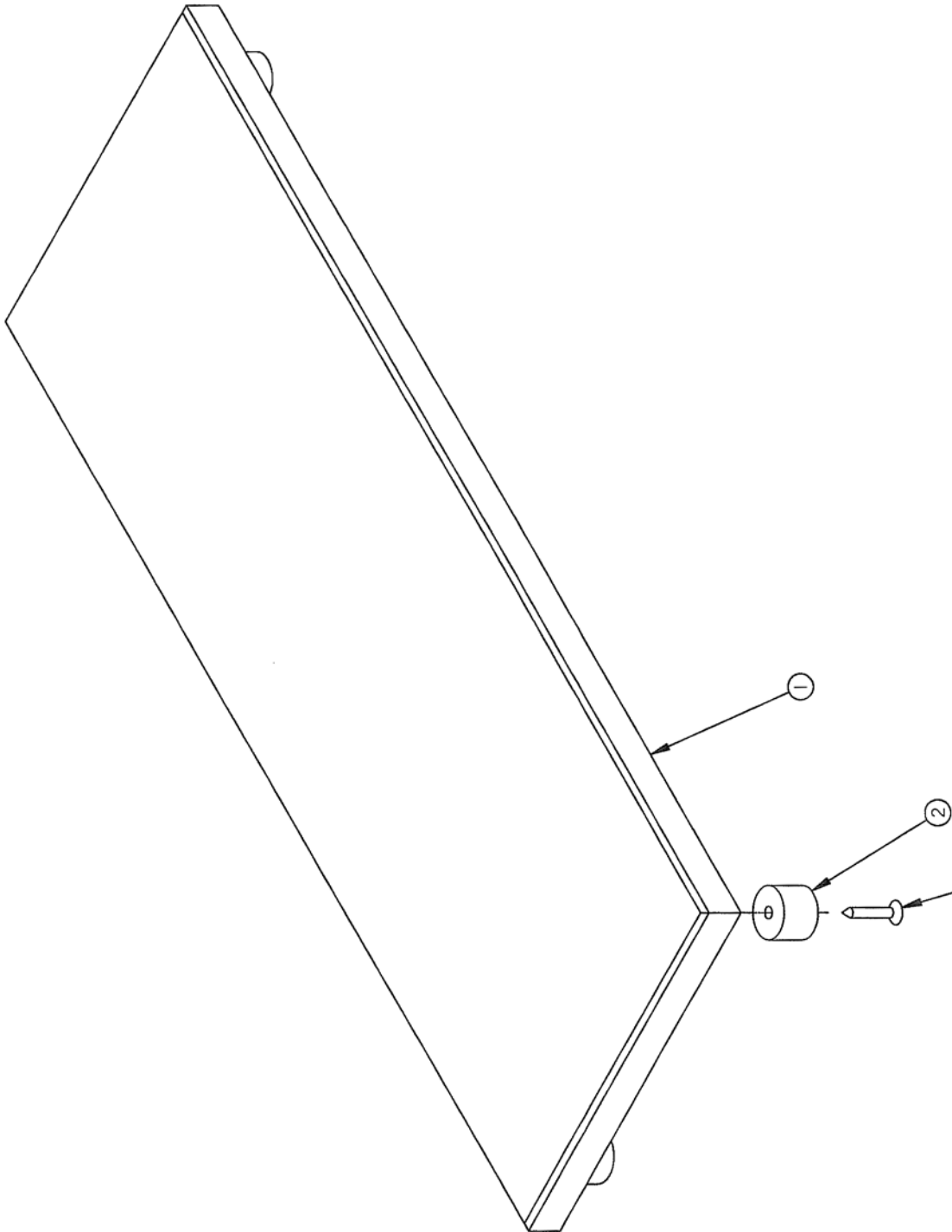
MACHINE	300D & 350D		DEPT. TOL. METRIC INCH	SIPROMAC
PART	COVER ASSEMBLY		USINAGE ± 0.1 ± 0.004	ST-GERMAIN DE GRANTHAM
ITEM	CNC	DATE 12-10-15	TOLERIE ± 0.5 ± 0.007	QUEBEC CANADA
MAT.	DWG BY J.G.	DATE	SOUDAGE ± 0.5 ± 0.027	
	APP. BY		N.T.S.	
			DEPT.	M-(M)
			NO	005A0481
			QTY.	1

LET. _____ DATE INT. _____

MODIFICATION

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

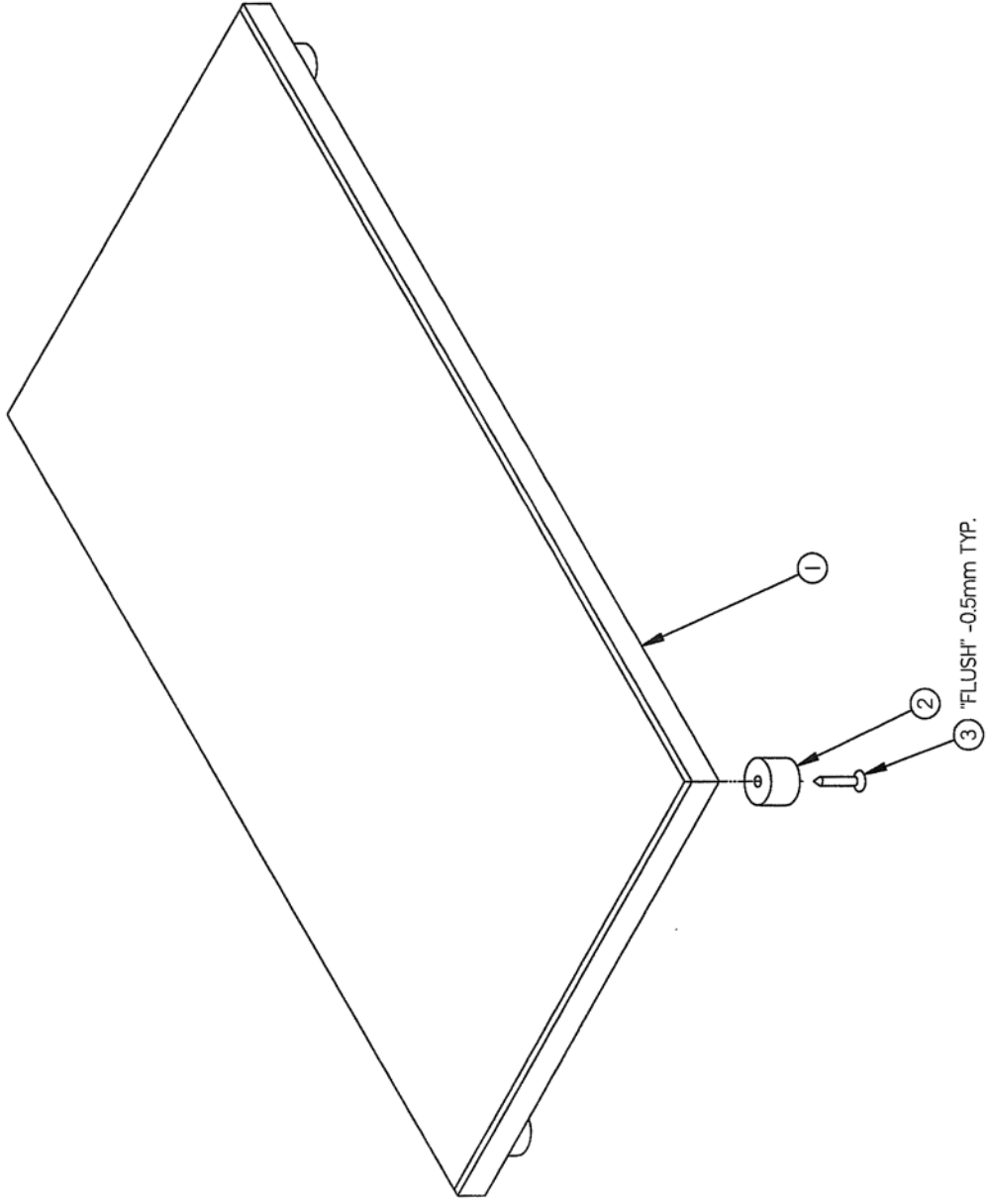


MACHINE	300 & 350	DEPT. TOL. METRIC	INCH	SIPROMAC
PART	HALF FILLER PLATE ASS'Y	USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANITHAM
ITEM		COUPE ± 0.3	± 0.002"	QUEBEC CANADA
MAT.		SOUDAGE ± 0.3	± 0.002"	
		N.T.S.		DEPT. M
		DATE	12-10-15	NO
		APP. BY	J.G.	005A0364
		DATE		QTY. 2

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

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

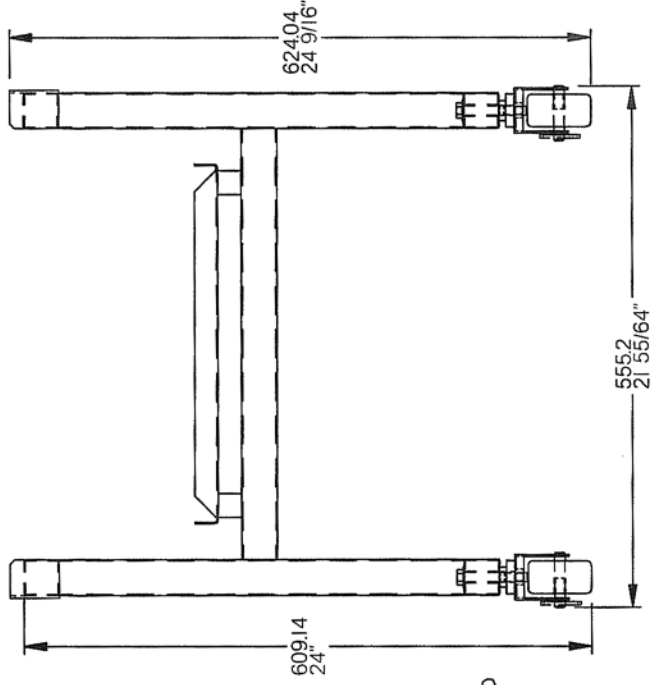
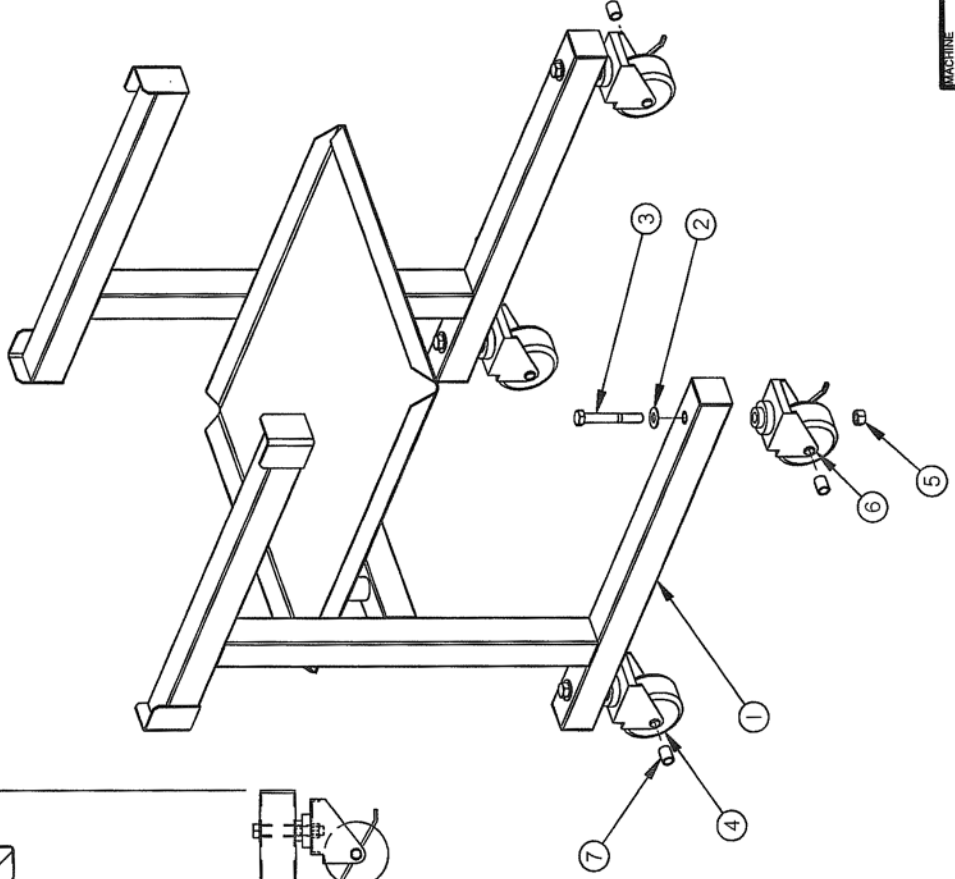
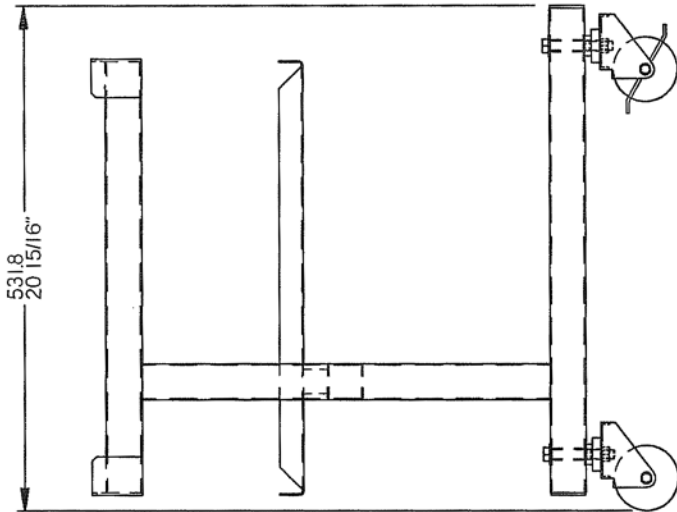


MACHINE	300D & 350D	DEPT. TOI	METRIC	INCH	SIPROMAC
PART	FILLER PLATE ASS'Y	USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM
ITEM		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA
DATE		SOLDAGE	± 0.5	± 0.020"	
DWG BY	J.G.	N.T.S.		DEPT.	M
APP. BY		DATE	12-10-15	NO	005A0365
RECESSINE MODIF.	A-462	DATE		QTY.	2
MODIFICATION					

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

1005B1031

ITEM	PART #	DESCRIPTION	QT.
1	005B1347	STAND PRE-ASSY (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

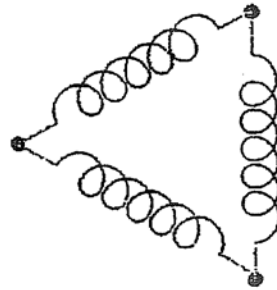
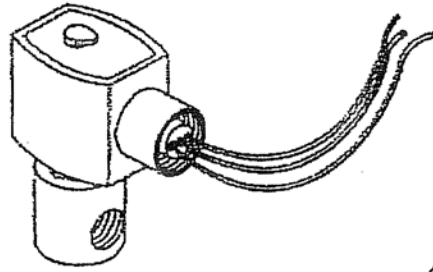
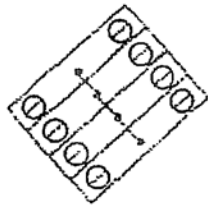


555.2
21 55/64"

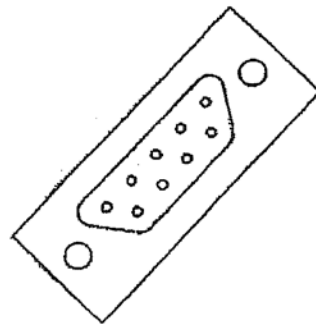
-STAND OPTION-

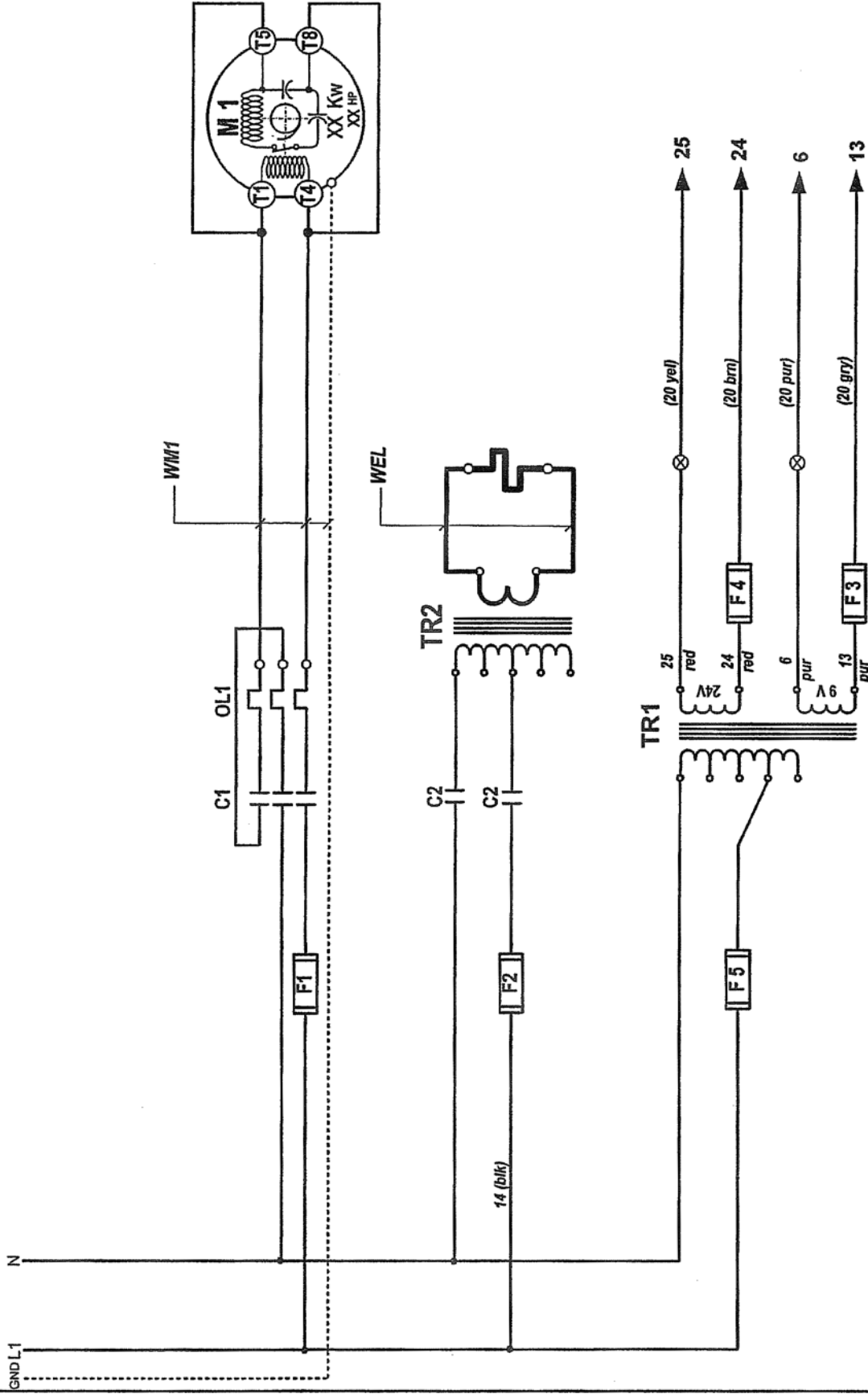
MACHINE 300, 300D, 350 & 350D		DEPT. / TOL. / USINAGE ± 0.1 / ± 0.004	INCH	SIPROMAC
PART		TOLERANCE / SOUDAGE ± 0.5 / ± 0.5	METRIC	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM		N.T.S.		DEPT.
MAT.		CNC	DATE	M-1)
APP. BY		J.G.	12-10-15	NO
DATE				1
MODIFICATION		REDESSINE MODIF. #A-462		005B1031

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

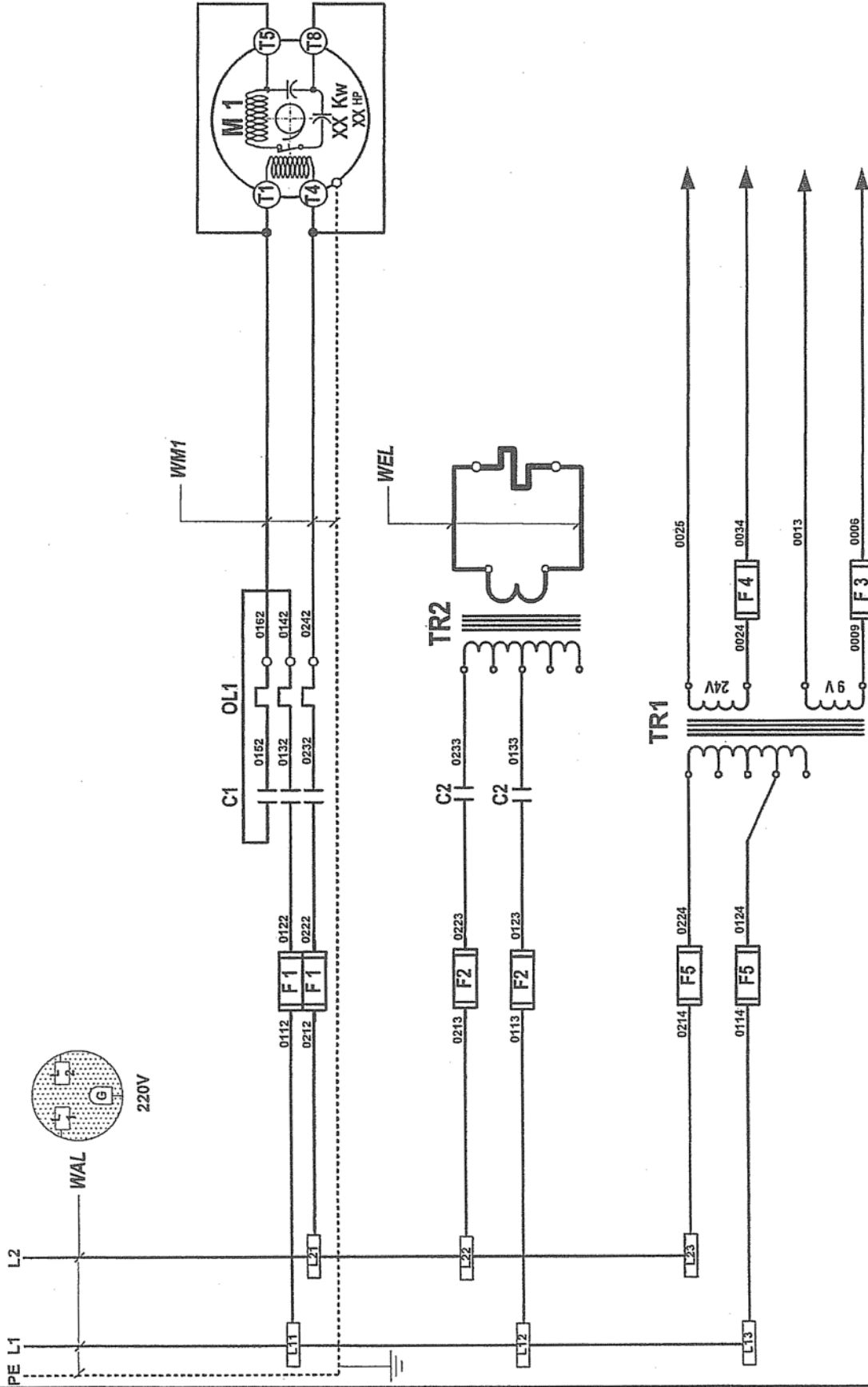


ELECTRICAL DRAWING





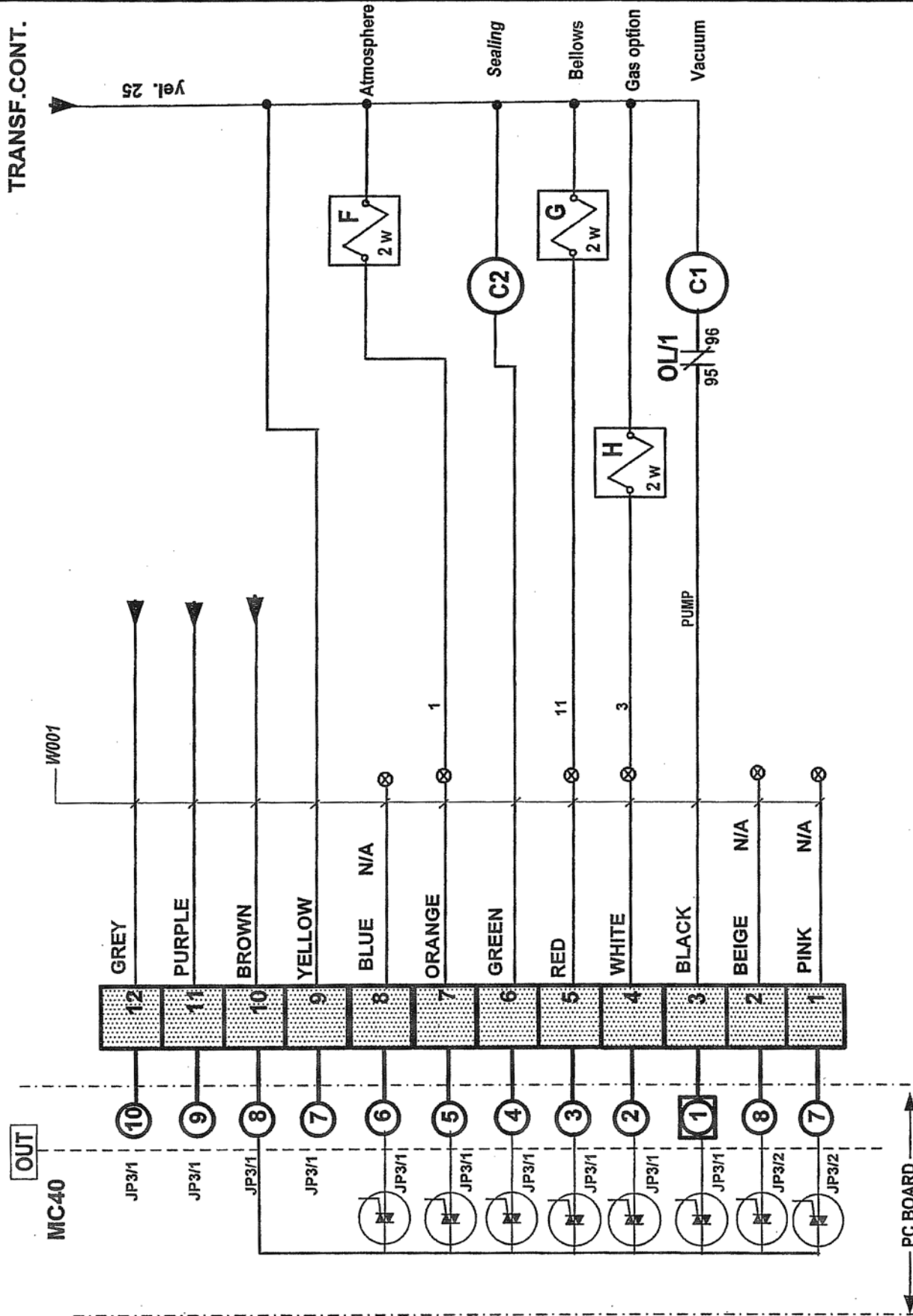
category	VACUUM PACK	model	350	vol.	120V/1PH/60HZ
system	MC-40			circuit	power
usual				year	month
fonctions				10	07
options				08	
				concept	draw
				XX	PP
				DL	
				006-0220	PAGE 1 de 1
				SIPROMAC	
				St-Germain de Grantham	
				QUEBEC, CANADA	



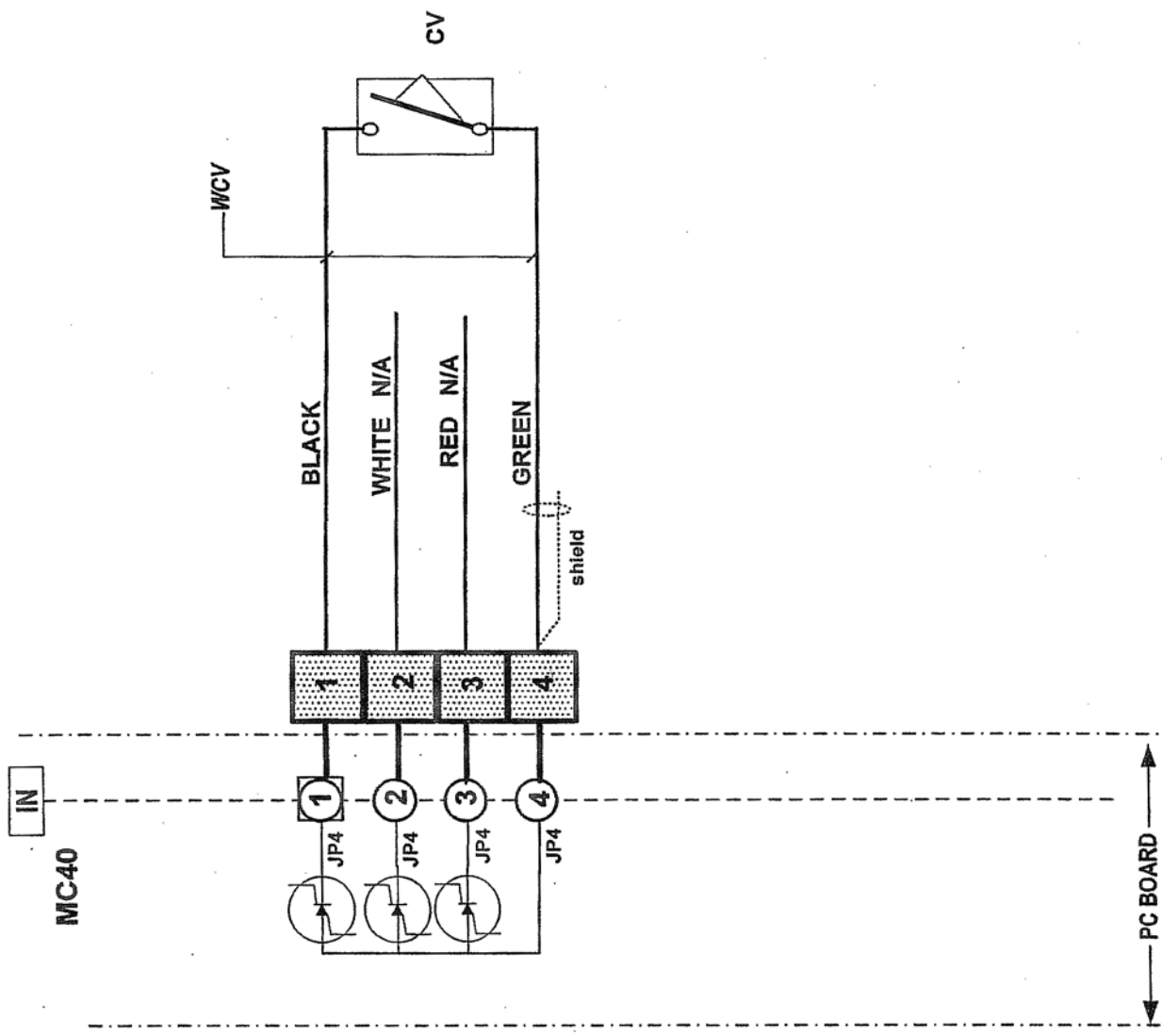
! All unmarked wires are caliber #14 AWG. (006-0200 page 1)

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

TRANSF.CONT.



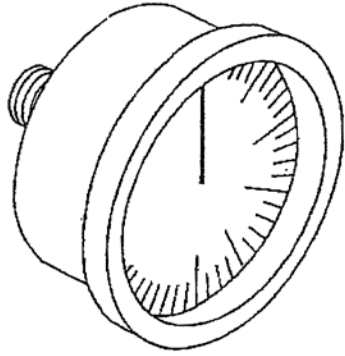
category	VACUUM PACK	model	350	volt.	ALL
system	MC-40	circuit	control	year	10
usual		month	07	day	08
fonctions		concept	XX	draw	PP
options		app		DL	
				block	08
				006-0237	PAGE 1 de 2
				SIPROMAC	
				St-Germain de Grantham	
				QUEBEC, CANADA	



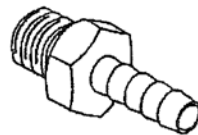
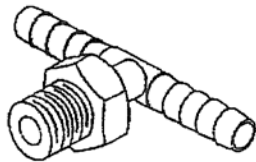
category	VACUUM PACK	model	350	vol.	ALL
system	MC-40	circuit	control	year	10 07 08
usual		draw	PP	month	07
fonctions		app	DL	day	08
options		concept	XX	block	
				draw	006-0237
				DL	PAGE 2 de 2
					SIPROMAC
					St-Germain de Grantham
					QUEBEC, CANADA

# SIPRO	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 POLE	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 1/2 TO 15A-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 POLE	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 1TH=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
030-0160	CAB TIRE	SUPPLY	220V/1PH/60HZ	350	GND-L1-L2		3 M.

# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	350	GND		1
034-0755	FUSE HOLDER 30A 1 POLE	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 5.6 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 POLE	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 1TH=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 16A 250V	COVER POSITION	ALL	350	CV		1

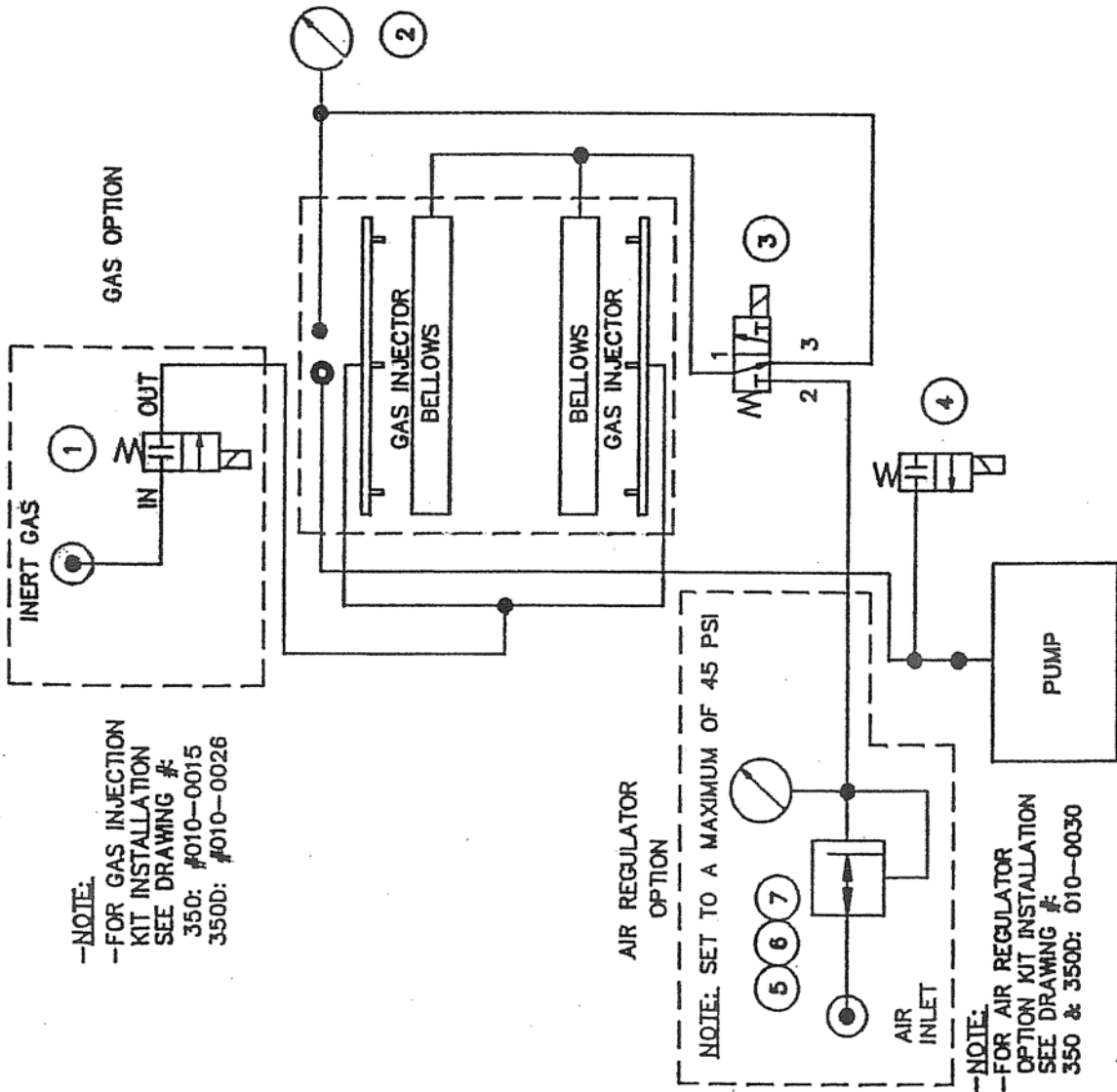


PNEUMATIC DRAWING



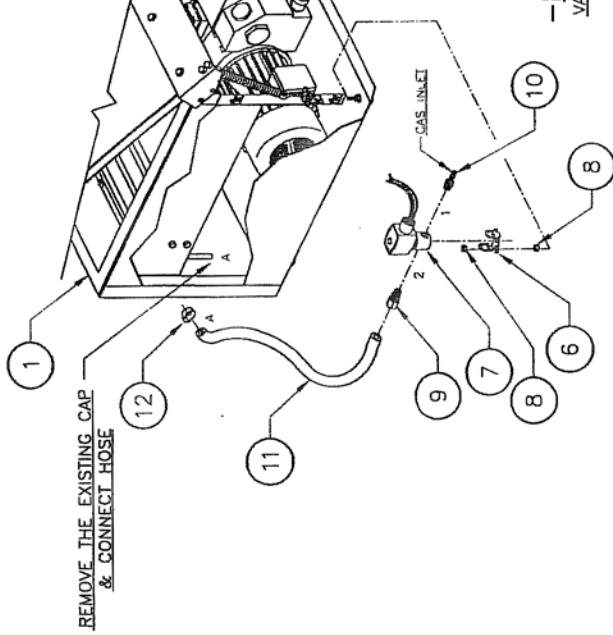
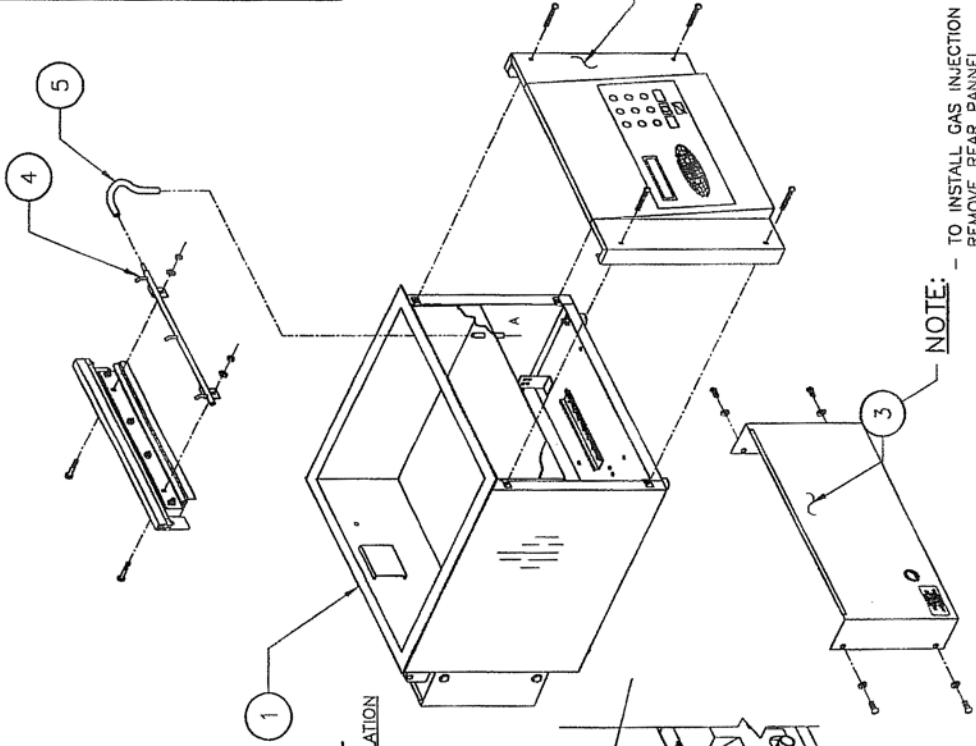
007-0022

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			



MACHINE		350 & 350D		SIPROMAC	
PART		PNEUMATIC		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM	CHG	DATE	SCALE	QT.	
		97-03-11		1	
MAT	APP.	DATE	NO.		
		DATE	007-0022		
A	RE-DRAWN	MODIFICATION			
LET.					

ITEM	PART #	DESCRIPTION	QT.
1	004-0229	VACUUM 350 PRE-ASSEMBLY	1
2	005-0609	MC-40 FRONT PANNEL ASSEMBLY	1
3	004-0446	REAR PANNEL PRE-ASSEMBLY	1
4	005B00042	GAS INJECTION BAR	1
5	008-0464	GAS INJECTION CONNECTION TUBE	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 NC. 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" O.D. X 1/4" I.D. (POLY) X 610 MM	1
12	105-0200	COLLARS 3/8"Ø	1



MACHINE: 350

PART: GAS INJECTION KIT INSTALLATION

ITEM: _____ DATE: _____

MAT: _____ DATE: _____

INC: _____ DATE: _____

APP: _____ DATE: _____

ST-A. PROVINCHEUR

ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

SIEMENS M-1 QT. 1

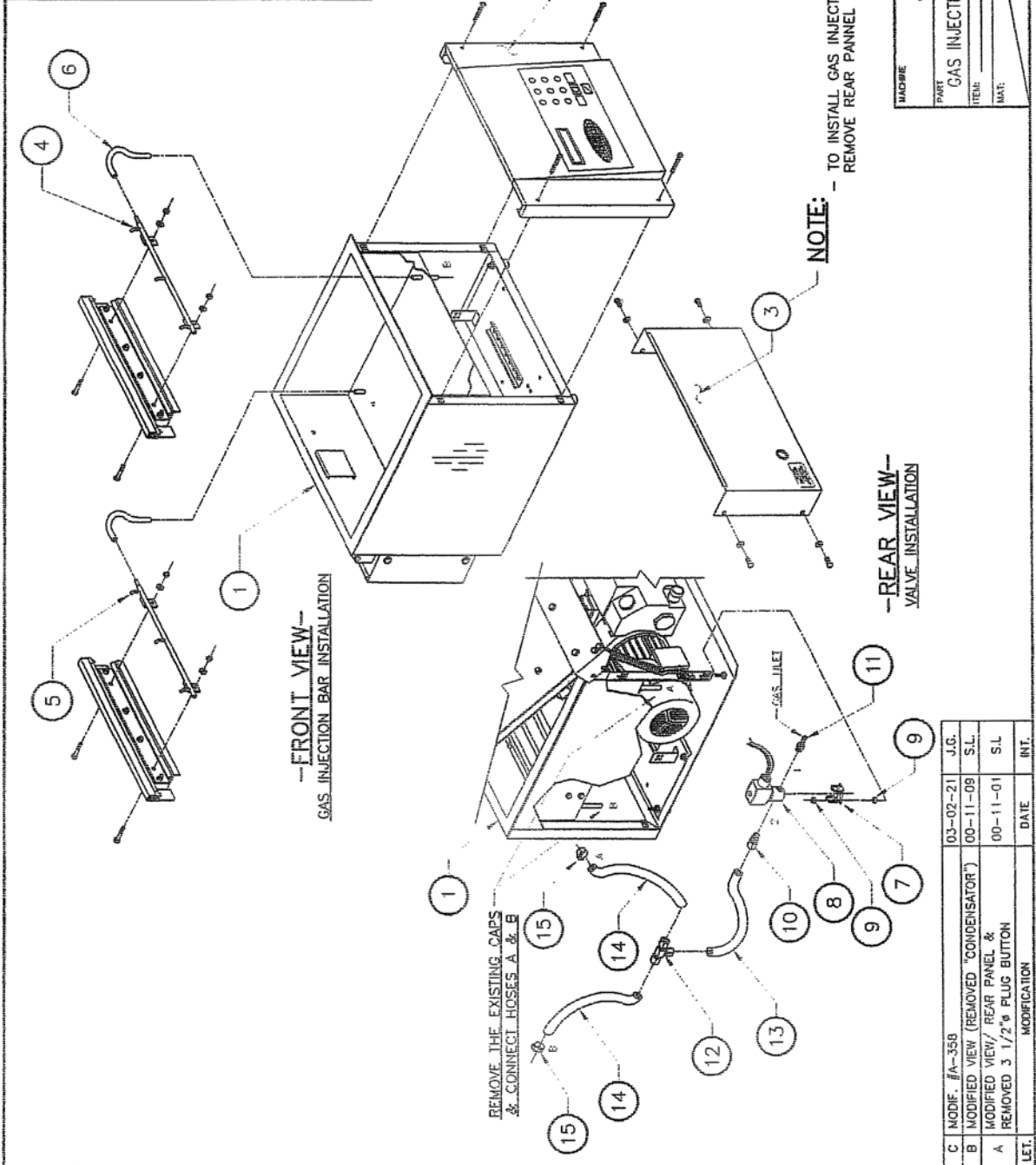
NO. 010-0034

DATE: 98-06-05

DATE: _____

LET.	MODIFICATION	DATE	INT.
B	MODIFIED VIEW (REMOVED "CONDENSATOR")	00-11-09	S.L.
A	MODIFIED VIEW/ REAR PANNEL & REMOVED 3 1/2"Ø PLUG BUTTON	00-11-01	S.L.

ITEM	PART #	DESCRIPTION	QTY
1	004-0230	VACUUM 350D PRE-ASSEMBLY	1
2	005-0450	FRONT PANNEL ASSEMBLY	1
3	004-0361	REAR PANNEL PRE-ASSEMBLY	1
4	00590042	FRONT GAS INJECTION BAR	1
5	005A0807	REAR GAS INJECTION BAR	1
6	008-0464	GAS INJECTION CONNECTION TUBE	2
7	106-0345	VALVE SUPPORT FOR 1/4" NPT	1
8	106-0010	SOLENOID VALVE 2 WAY 1/4" NPT	1
9	051-0580	HEX. NUT 1/4"-20 NC. S/S	2
10	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	1
11	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
12	101-0062	T 3/8" T.P.COMP.	1
13	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) X 230 MM	1
14	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) X 270 MM	2
15	105-0200	COLLARS 3/8"	2

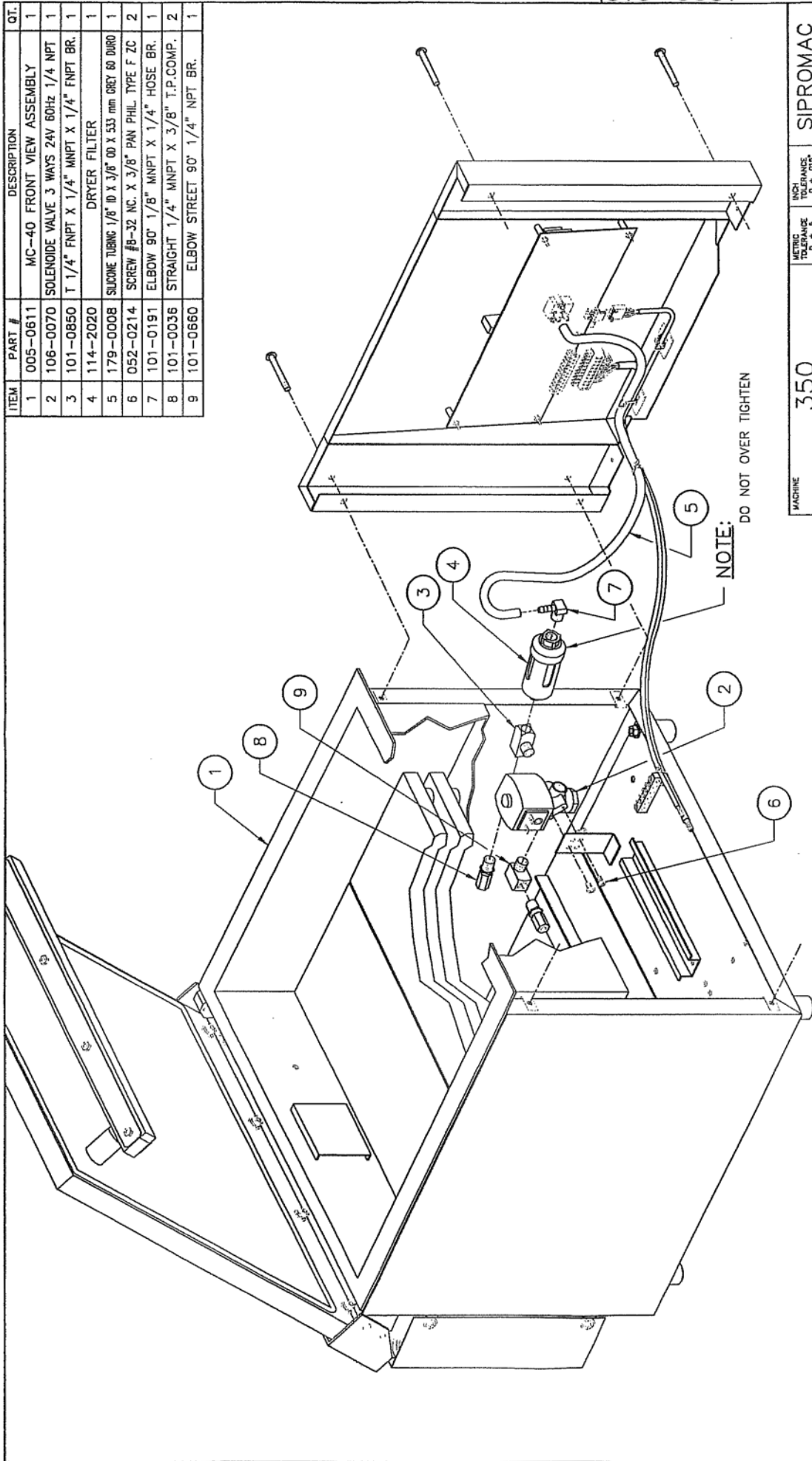


-MC-40 OPTION-
-OPTION GAS INJECTION-

MODEL 350D
PART GAS INJECTION KIT INSTALLATION
ITEM _____
MAT _____
DATE 98-06-05
PROVINCE _____
REP. FTJ
SPRINGER M-H
QTY 1
010-0035

MOD.	#	DATE	J.G.
C	MODIFIED VIEW (REMOVED 'CONDENSATOR')	00-11-09	S.L.
B	MODIFIED VIEW / REAR PANNEL & REMOVED 3 1/2" PLUG BUTTON	00-11-01	S.L.
A	MODIFICATION		

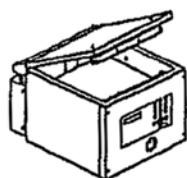
ITEM	PART #	DESCRIPTION	QT.
1	005-0611	MC-40 FRONT VIEW ASSEMBLY	1
2	106-0070	SOLENOID VALVE 3 WAYS 24V 60Hz 1/4 NPT	1
3	101-0850	T 1/4" FNPT X 1/4" MNPT X 1/4" FNPT BR.	1
4	114-2020	DRYER FILTER	1
5	179-0008	SILICONE TUBING 1/8" ID X 3/8" OD X 533 mm GREY 60 DURO	1
6	052-0214	SCREW #8-32 NC. X 3/8" PAN PHIL. TYPE F ZC	2
7	101-0191	ELBOW 90° 1/8" MNPT X 1/4" HOSE BR.	1
8	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	2
9	101-0860	ELBOW STREET 90° 1/4" NPT BR.	1



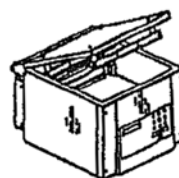
MACHINE: 350
 PART: DRYER FILTER INSTALLATION
 INCH TOLERANCE: .0005 ±, .001 ±, .002 ±, .003 ±, .004 ±, .005 ±, .006 ±, .007 ±, .008 ±, .009 ±, .010 ±
 METRIC TOLERANCE: .0005 ±, .001 ±, .002 ±, .003 ±, .004 ±, .005 ±, .006 ±, .007 ±, .008 ±, .009 ±, .010 ±
 ANGLE: ± 1° N.T.S.
 DATE: 98-06-19
 BY: [Signature]
 APP: [Signature]
 S.I.P.R.O.M.A.C. ST-GERMAIN DE GRANTHAM QUEBEC CANADA
 FORM M-1 QT. 1
 NO. 010-0037

LET.	MODIFICATION	DATE	S.L.	INT.
A	MODIFIED VIEW/ REAR PANEL REMOVED 3 1/2" PLUG BUTTON	00-11-01		

VACUUM PACKAGING MACHINES



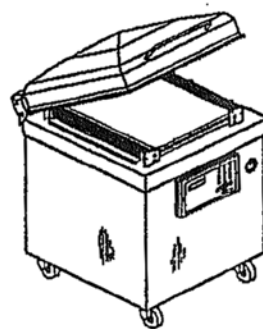
250



350/350D



450A



550A