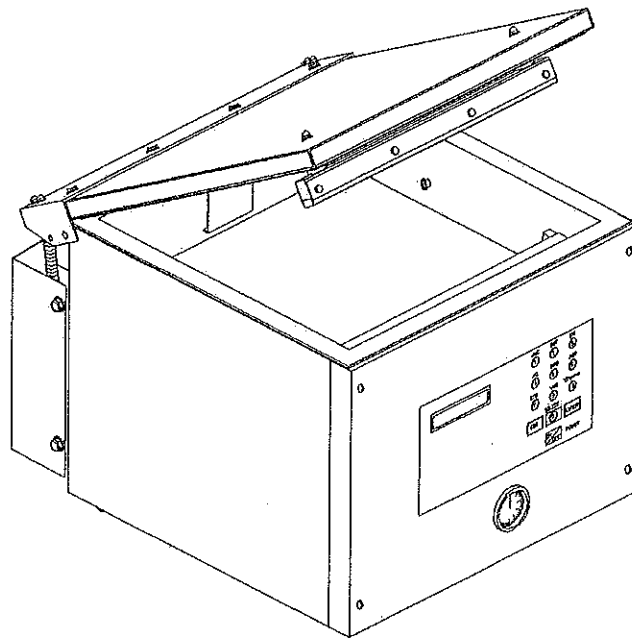


VACUUM PACKAGING MACHINE

MODEL 250



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

Safe Operation Practices



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

General Operation

- Read, understand, and follow all instructions in the manual and on the machine before starting. Keep this manual in a safe place for further and regular reference and for ordering replacement parts.
- Only allow responsible individuals familiar with the instructions to operate the machine. Be sure to know controls and how to stop the machine quickly.
- Never put your hands near moving parts.
- Only allow qualified individuals for the maintenance of your machine.
- Remove all obstacles, which may interfere with the machine functions.
- Clear the work area such as electrical wires, buckets, knives etc.
- Be sure that everyone else is clear of your work area before operating the machine.
- Do not sit nor stand on the machine.
- Always turn off the machine after your work is done. Never leave a running machine unattended.
- Always disconnect and wait till the machine has cooled before attempting any maintenance.
- Do not wear loose fitting clothes or jewelry as they may get caught in moving parts of the machine.
- Always wear security shoes, to prevent injury caused by moving the machine or objects falling from the machine.
- Never exceed the time limit to seal, which is recommended by the manufacturer. This is to avoid any damage that may be caused to the sealing bars and to eliminate the risk of fire in the machine. Thus avoiding corporal burns.
- Never touch the sealing bars after they have been used, this will avoid corporal burns. Wait a few minutes to let the machine cool down before touching.
- Always make sure that the sealing bars are well installed in their "Guide Blocks" before starting a cycle.
- Never incline the machine more than 30 degrees, it may tip over and hurt someone seriously.
- Work only in daylight or good artificial light.

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

Service

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

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



Warning-Your responsibility:

This machine should only be operated by personal who can read, understand and respect warnings and instructions regarding this machine in the owners manual.

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 250

(MC-40)

GENERAL TABLE OF CONTENTS

I	OPERATION INSTRUCTIONS
II	MECHANICAL
	A- 250: front view assembly drawing.
	B- 250: rear view assembly drawing
	C- 250: front panel assembly
	D- Seal bar assembly drawings (twin seal)
	E- Seal bar assembly drawings (electrical bag cut option)
	F- 250: cover assembly drawing
	G- 250: upper seal bar assembly drawing
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VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

TABLE OF CONTENTS

1. Setting up the machine
2. Electrical connection
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 - 3.4 Daily cleaning
4. Trouble shooting
 - 4.1 Failure during a packaging cycle
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 - 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

VACUUM PACKAGING MACHINES

1. SETTING UP THE MACHINE:

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

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

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

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

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



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.

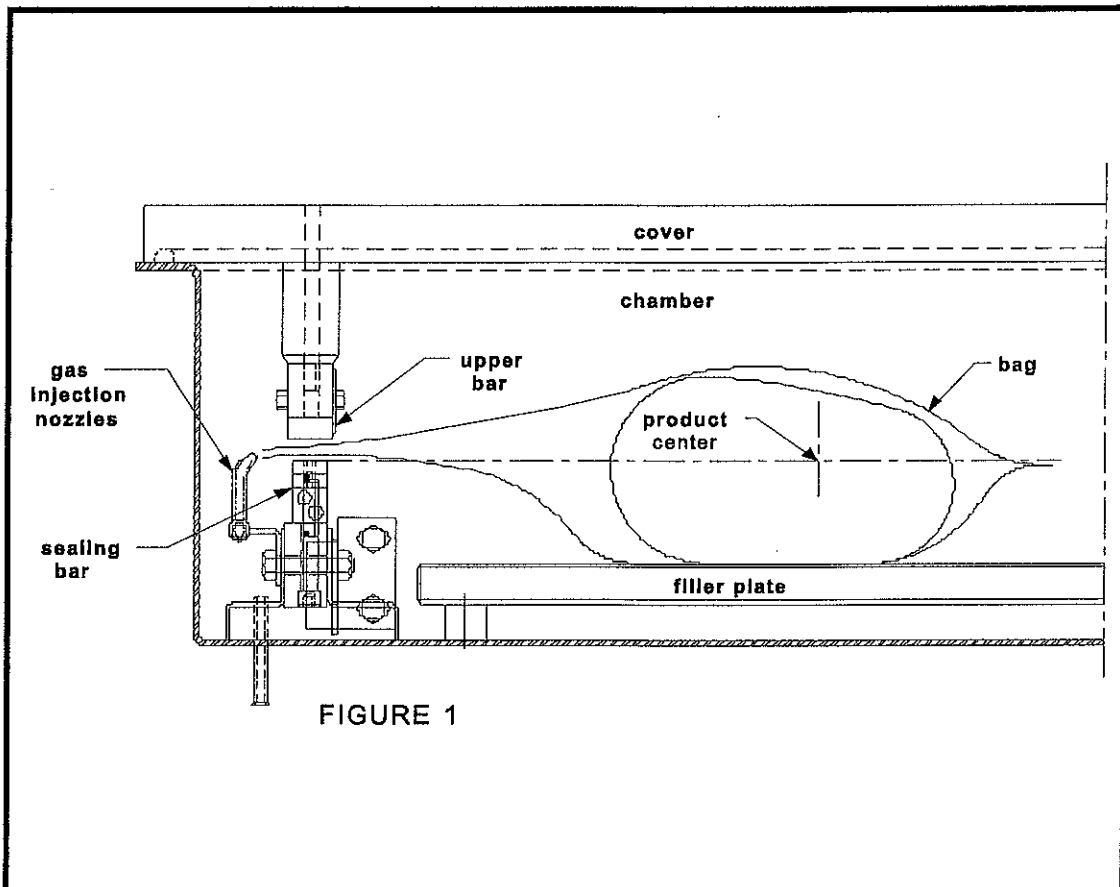
3. OPERATION:

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 10 and the keyboard detail on page 11.

3.3.1 Basics:

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

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

In functions menu, use key "SELECT" to select a function and key "ENTER" to accedeand 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:

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 Gas time setting:

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.

3.3.3.4 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 status during vacuum sequence,
- gas time status during gas flush sequence,
- sealing time status during sealing sequence,
- ATM message level 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.xs" (10 – 199s)

"GAS FLUSH: xx.xs" (0 – 99s) (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)

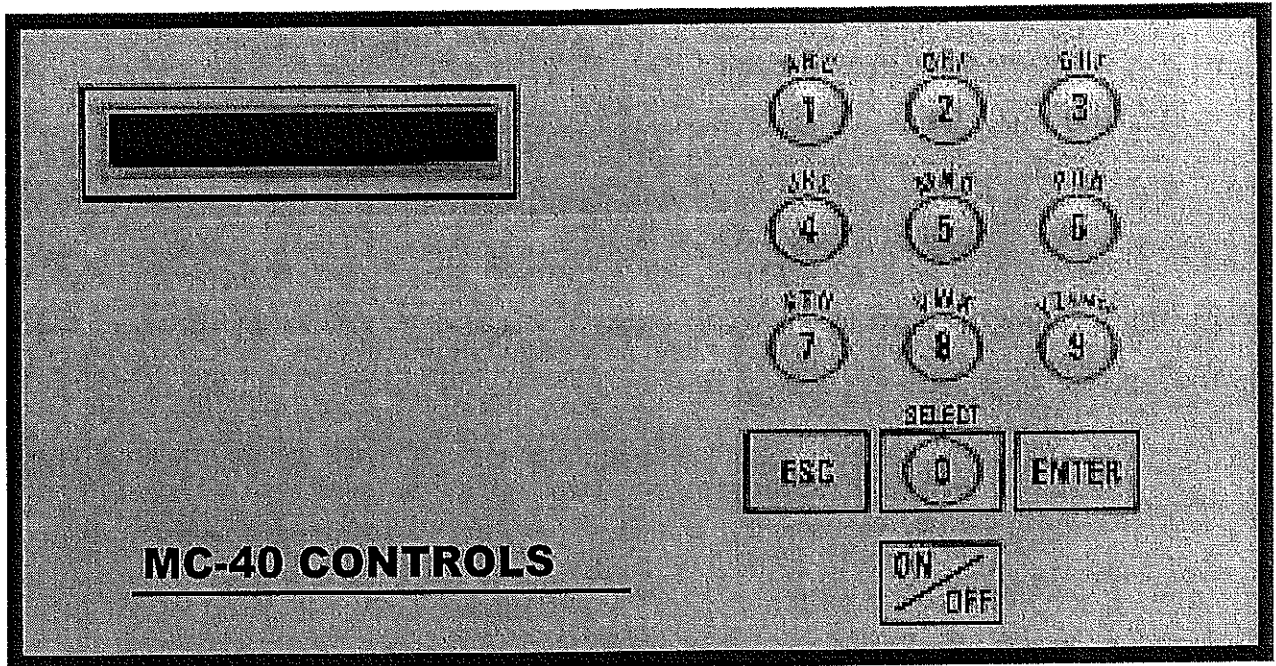
"SOFTWARE: R x.xx"

"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.

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 vacuummeter, 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 9.

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.

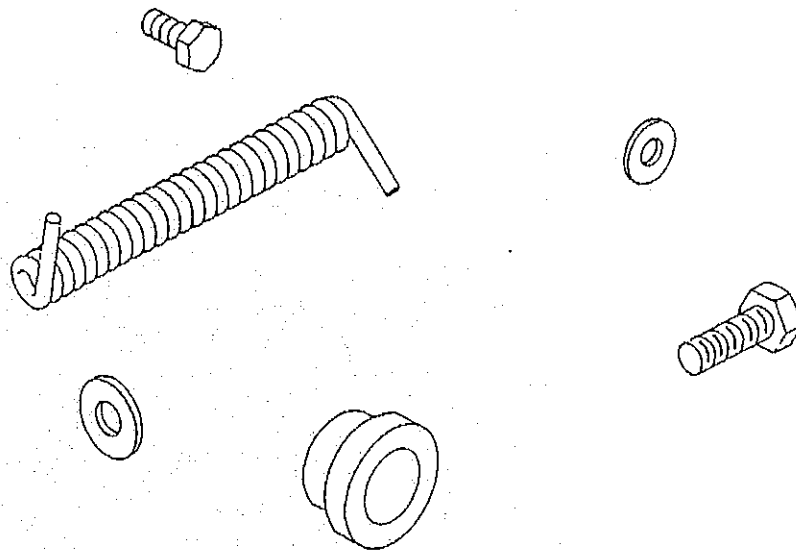
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

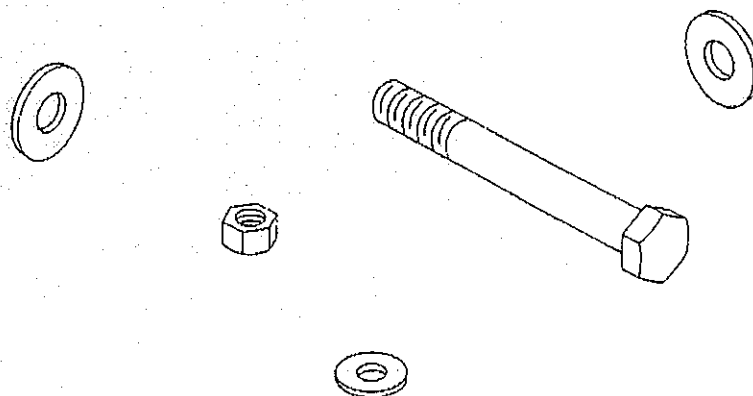
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

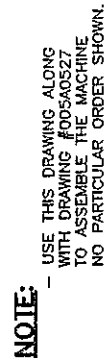
Check function of cycle with various settings of timers.



MECHANICAL DRAWING



ITEM	#PART	DESCRIPTION	QTY.
1	004-0406	VACUUM 250 PRE-ASS'Y	1
2	002-0435	SEAL BAR GUIDE BLOCK	2
3	005A0497	SEAL BAR ASSEMBLY	1
4	005A0520	BAG CUT SEAL BAR ASSEMBLY	1
5	005A1000	BELLOWS ASSEMBLY	1
6	005-0522	COVER ASSEMBLY	1
7	005A0526	FRONT PANEL ASSEMBLY	1
8	005-0519	FILLER PLATE ASSEMBLY	1
9	051-0740	FLAT WASHER 1/4" S/S	4
10	051-0581	NUT 1/4"-20 NC. LOCK NYLON S/S	4
11	051-0780	FLAT WASHER 3/8" S/S	1
12	051-0620	HEX. NUT 3/8"-16 NC. S/S	1
13	051-0264	SCREW 1/4"-20 NC. X 2" PAN PHIL. S/S	4
14	056-0020	SPRING NUT 1/4"-20 NC.	4
15	058-0030	SPACERS	2
16	004A1651	COVER HOLD DOWN PRE-ASS'Y	1

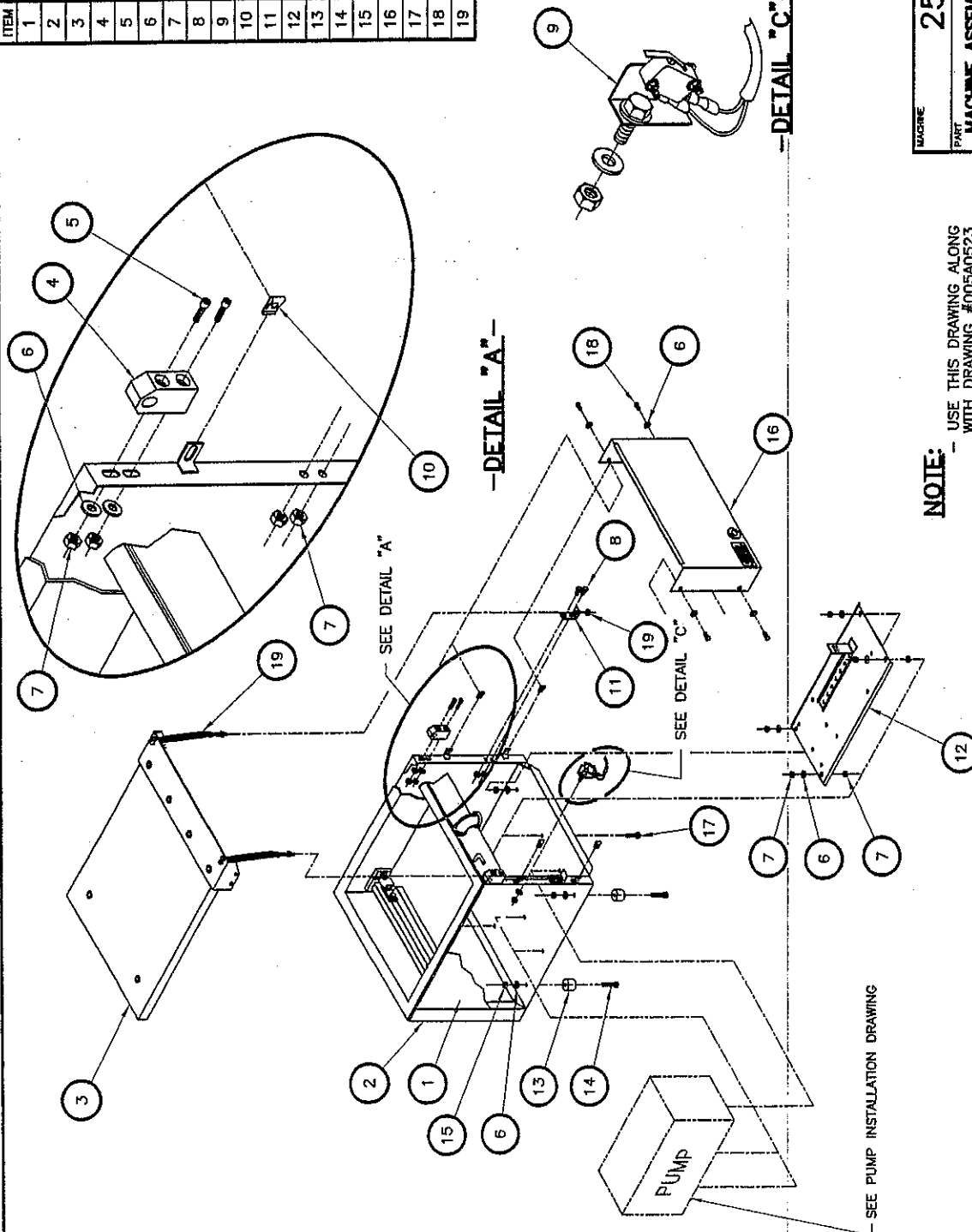


- INSTALL ITEM 16 SO THAT IT CAN MOVE FREELY BUT WITHOUT TOO MUCH LOOSENESS

MACHINE	250	U.S. METRIC U.S. 1 1/2 1 1/2 1 1/2 METRIC 38 38 38		SIPROMAC
PART	ST-GERMAIN DE GRANTHAM			
MACHINE ASSEMBLY FRONT VIEW			N.T.S. QUEBEC CANADA	
DATE:	DATE	DATE	DATE	DATE
BY	J.G.	J.G.	J.G.	J.G.
APP.	APP.	APP.	APP.	APP.
NO	005A0523	005A0523	005A0523	005A0523

F	0050497 WS 005-0497, 0050520 WS 005-0520, 0051000 WS 005-0510	05-09-27	M.A.L.
E	REDESINÉ MODIF. #A-0408 (MC-40)	04-10-13	J.G.
ET	MODIFICATION	DATE	INT

ITEM	PART #	DESCRIPTION	QT.
1	004-0406	VACUUM 250 PRE-ASS'Y	1
2	005A0526	FRONT PANNEL ASSEMBLY	1
3	005B0522	COVER ASSEMBLY	1
4	002-0024	HINGE BLOCK	2
5	051-0232	SCREW 1/4"-20x 1-1/4"SKT CAP SS	4
6	051-0740	FLAT WASHER 1/4" S/S	16
7	051-0580	HEX. NUT 1/4" -20 NC S/S	16
8	051-0180	HEX. BOLT 1/4"-20 NC X 1/2" S/S	4
9	004-0261	LIMIT SWITCH ASSEMBLY	1
10	056-0020	SPRING NUT 1/4"	4
11	001-1337	REAR SPRING SUPPORT	2
12	004-0333	ELECTRICAL SUPPORT PRE-ASS'Y	1
13	002-0022	PLASTIC FOOT	4
14	051-0250	HEX. BOLT 1/4"-20 NC X 1 1/2" S/S	4
15	051-0581	HEX. NUT 1/4"-20 NC NYLON LOCK S/S	4
16	004-0363	FRONT PANNEL PRE-ASSEMBLY	1
17	051-0190	HEX. BOLT 1/4"-20 NC X 3/4" S/S	4
18	051-0185	SCREW 1/4"-20 NC. X 1/2" PAN PHIL S/S	4
19	004A1225	SPRING PRE-ASSEMBLY	2



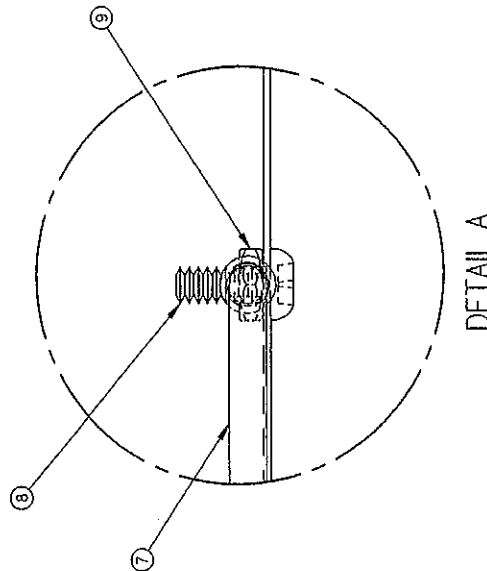
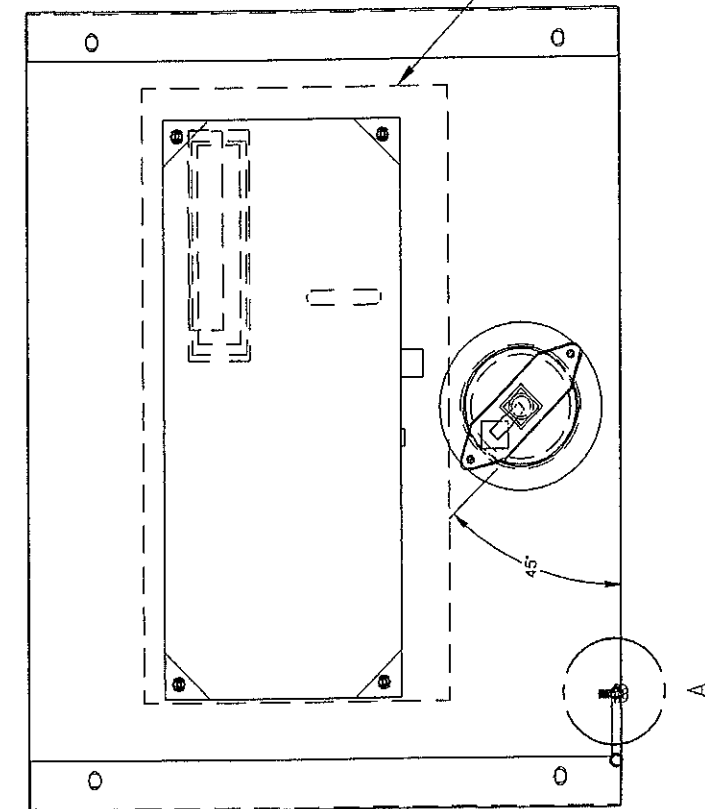
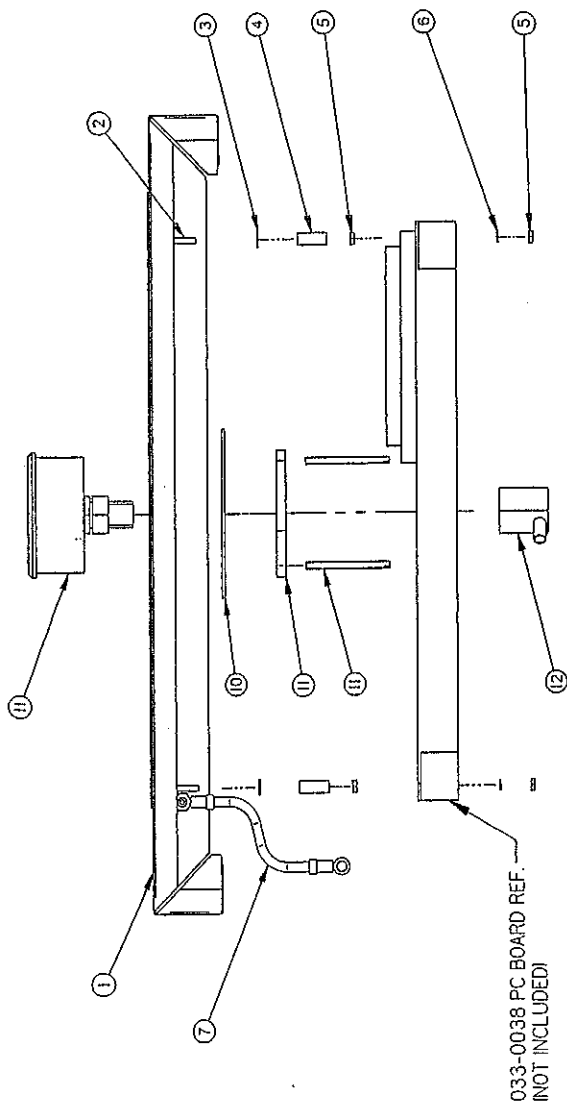
NOTE: USE THIS DRAWING ALONG WITH DRAWING #005A0523 TO ASSEMBLE THE MACHINE. NO PARTICULAR ORDER SHOWN.

MACHINE		250	SIPROMAC	
PART		ST-GERMAIN DE GRANTHAM QUEBEC CANADA		
MACHINE ASSEMBLY REAR VIEW		N.T.S.		
ITEM		SCALE _____		
DATE		DATE 04-10-13		
DRAWING APP.		DATE 04-10-13		
ITEM		SCALE _____		
DATE		DATE 04-10-13		
DRAWING APP.		DATE 04-10-13		

1FT.	MODIFICATION	DATE	INT.
F	REMOVED 056-0150 & REMOVED 4 X ITEM #7 ADDED TO NEW 19	05-05-04	M.A.L.
E	FE 051-0232 WS 051-0251, #7 051-0580 WS #15 051-0581	04-11-22	M.A.L.
D	REDESSINE MODIF. #A-0408 (MC-40)	04-10-13	J.G.


005A0526

ITEM	PART #	DESCRIPTION	QT.
1	001A1824	FRONT PANEL	1
2	051-0089	SCREW 4-40 x 1" FLAT SLOT SS	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	8
6	051-0715	WASHER #4 LOCK SS	4
7		GROUND WIRE	1
8	051-0144	SCREW #10-24 N.C 1/2" PAN PHIL. S/S	1
9	051-0571	NUT #10-24 S/S	1
10	001-1869	VACUUM GAGE FIXATION RING	1
11	114-0260	VACUUM GAGE W/ SUPPORT	1
12	101-0160	ELBOW 90° 1/4" FNPT x 1/4" HOSE	1



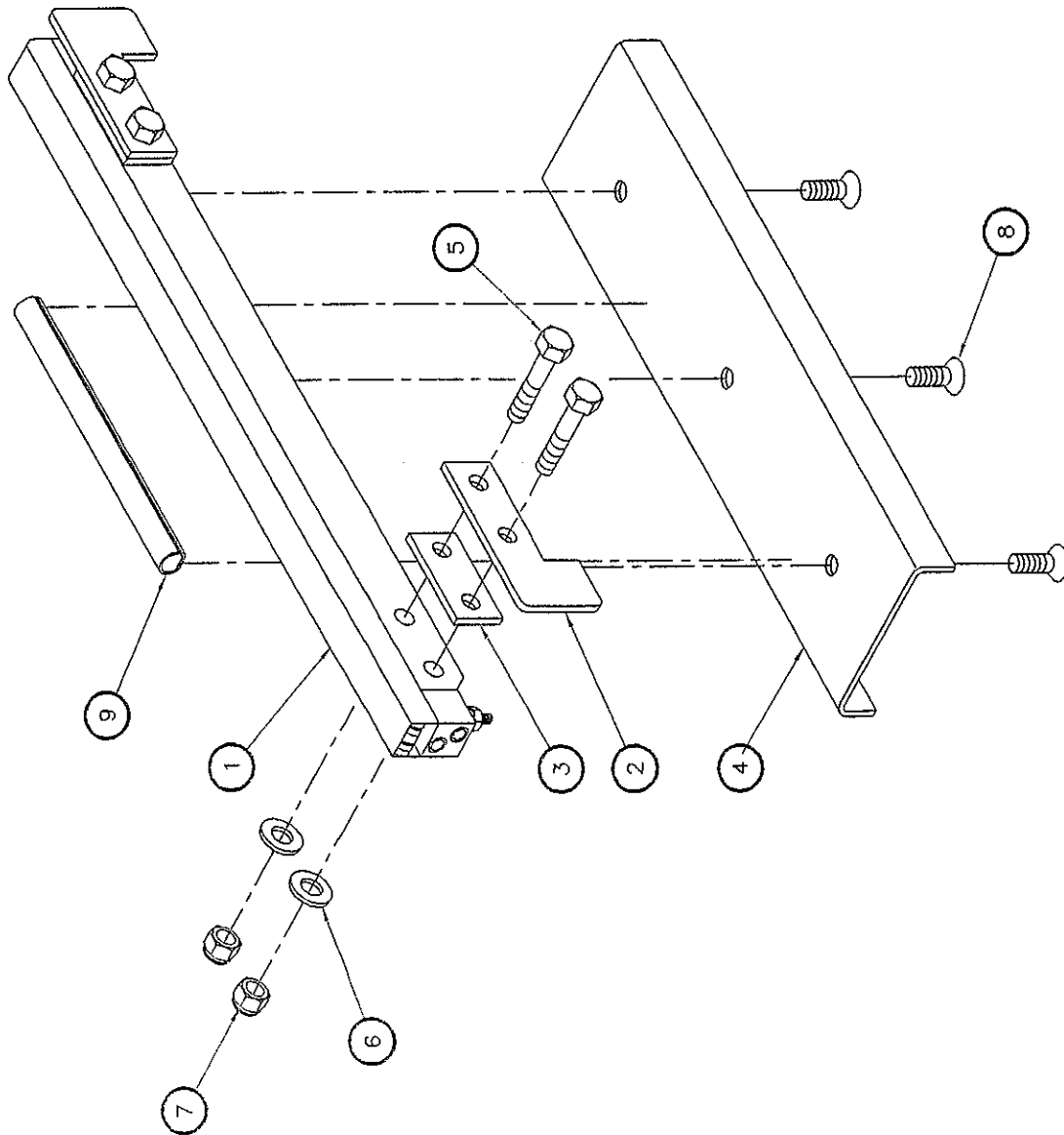
033-0015 OR 033-0017
OR 033-0018 KEYBOARD REF.
NOT INCLUDED

POSITION CAREFULLY IN REGARDS
TO OPENING IN ITEM #1

MACHINE	250	FRONT PANEL ASSEMBLY		DEPT. _____ CITY _____ STATE _____ ZIP _____ COUNTRY _____	
PART		DWG BY _____ APP. BY _____	DATE 04-10-13 DWG NO. 05-01-05	M _____ 1 _____ 005A0526	
		DRESS BY _____ US INCHES _____ TOLERANCE _____ SOUDAGE ±0.5 ±0.020		N.T.S. 	
				SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	

LET	MODIFICATION	DATE	INT
E	001A1824 WAS 004A0362 MODIF #A-0415	04-11-11	M.A.
D	REDESSINE S.E. MODIF. #A-0408 (MC-40)	04-10-13	J.G.

ITEM	PART #	DESCRIPTION	QT.
1	004-0334	SEAL BAR PRE-ASSEMBLY	1
2	001-1738	SEAL BAR GUIDE	2
3	001-1829	SEAL BAR GUIDE SPACER	2
4	001A2757	SEAL BAR SUPPORT	1
5	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	4
6	051-0740	FLAT WASHER 1/4" S/S	4
7	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
8	051-0195	FLAT HEAD SCREW 1/4"-20 NC. X 3/4" S/S	3
9	038-0230	WIRING DUCT W/ ADHL BACK (0.36" X 0.5" X 170) 05855	1

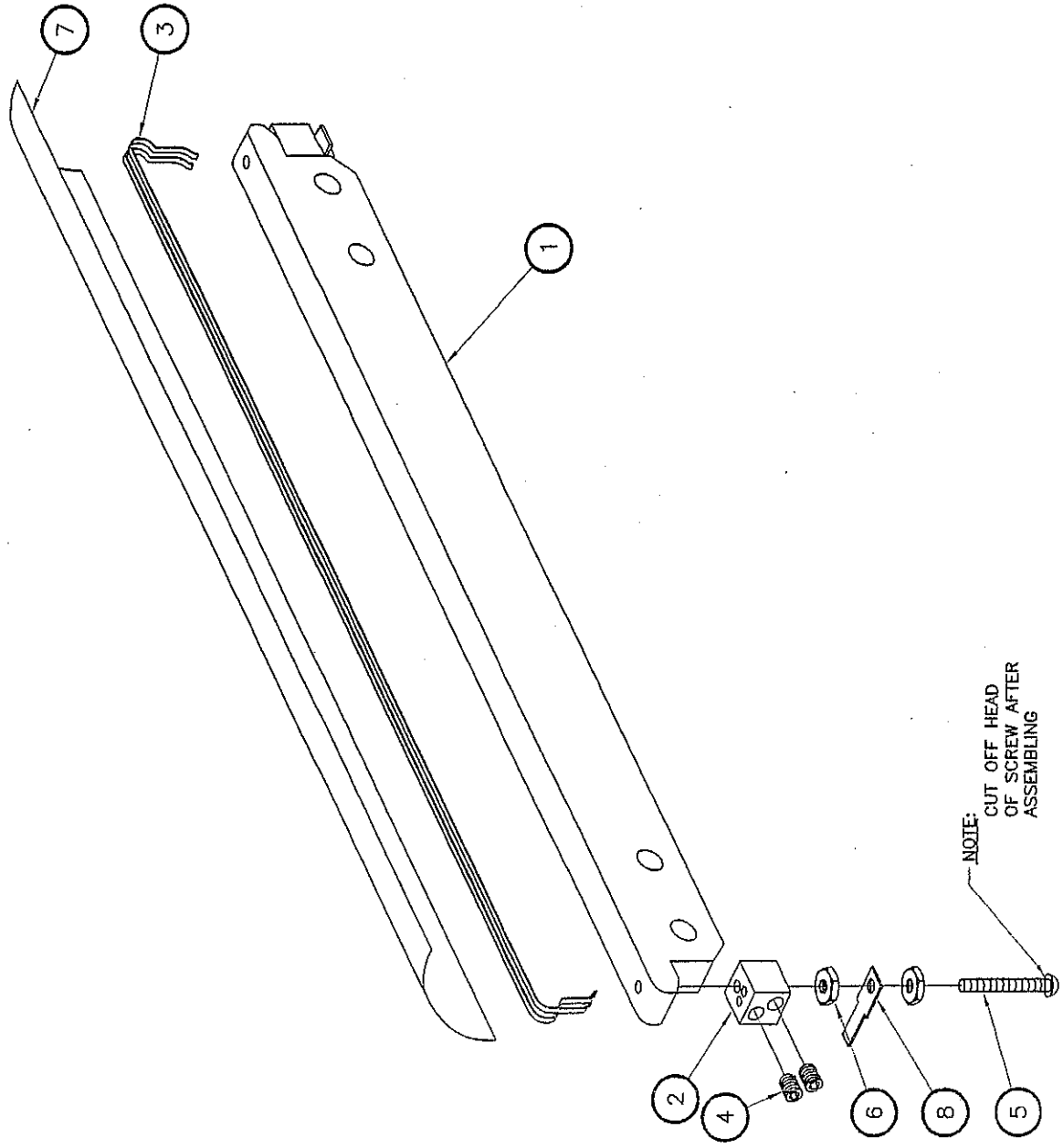


250		SIPROMAC	
SEAL BAR ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
METRIC TOLERANCE 0.001 ± 0.001 0.002 ± 0.002 0.005 ± 0.005 0.010 ± 0.010 0.020 ± 0.020 0.050 ± 0.050 0.100 ± 0.100 0.200 ± 0.200 0.500 ± 0.500 1.000 ± 1.000 2.000 ± 2.000 5.000 ± 5.000 10.000 ± 10.000 20.000 ± 20.000 50.000 ± 50.000 100.000 ± 100.000 200.000 ± 200.000 500.000 ± 500.000 1000.000 ± 1000.000 N.T.S.		N.T.S.	
DATE 05-09-27		SCALE 1	
M.A.L.		005A0497	

LET.	REDRAWN / MODIFIED ITEM #4	DATE	M.A.L.	INT.
C		05-09-27		

1004-0334

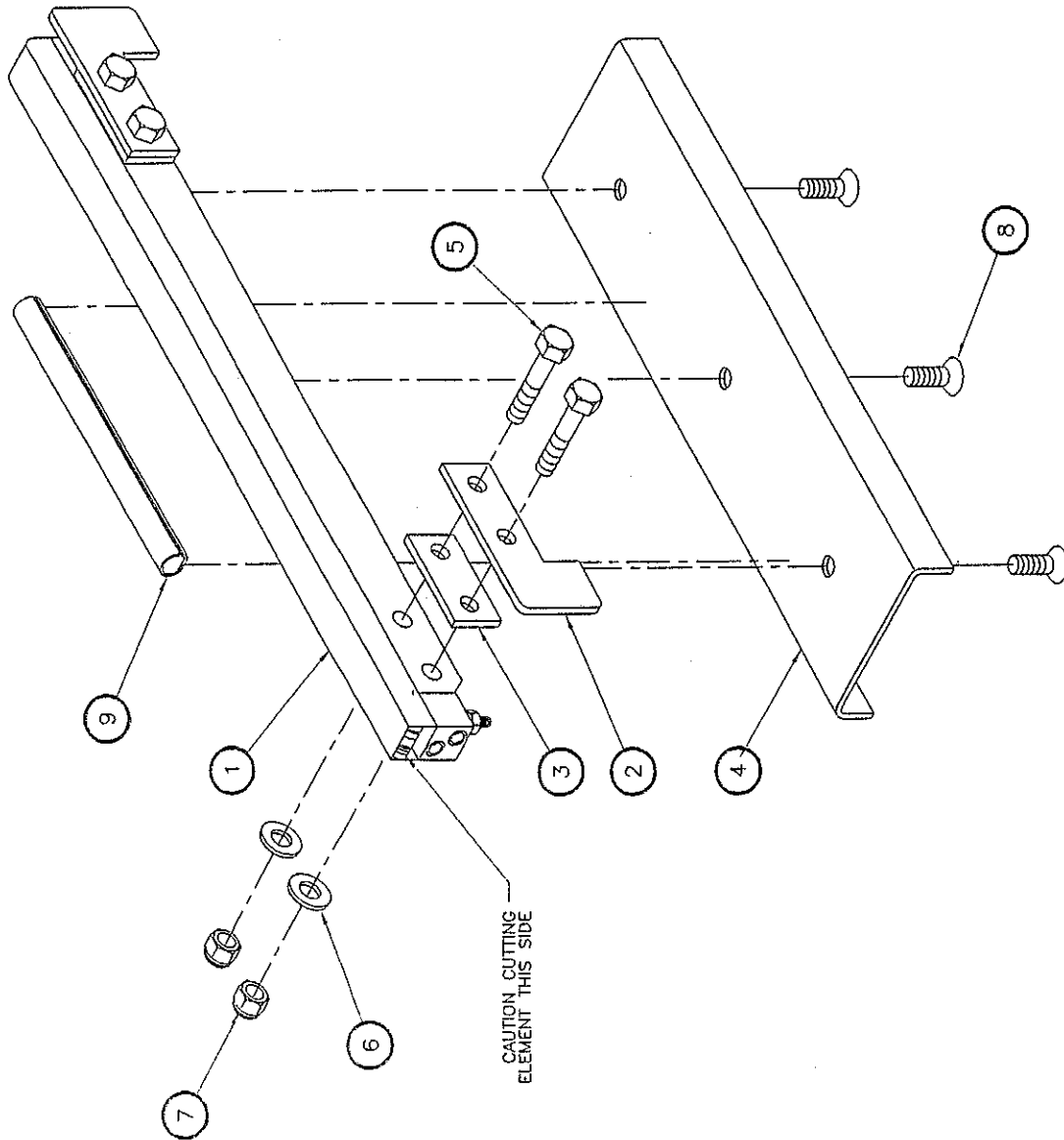
ITEM	#PART	DESCRIPTION	QTY.
1	002A0433	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEM. STD TWIN (2x460mm EA.)	3.02
4	052-0395	SET SCREW 1/4"-20 NC. X 5/16" (OVAL POINT)	4
5	052-0250	SET SCREW #8-32 NC. X 1 1/2" ROUND SLOT BRASS S/S	2
6	051-0550	HEX. NUT #8-32 NC. S/S	4
7	176-0202	TEFLON TAPE .005"x1-1/2" ADHES. (330mm EA.)	0.042
8	027-0400	CONNECTOR ADAPTOR	2



MACHINE	250	REVISIONS	DATE	QTY.
PART	SEAL BAR PRE-ASSEMBLY	DATE	DATE	DATE
ITEM		DATE	DATE	DATE
DATE		DATE	DATE	DATE
SIPROMAC		ST-GERMAIN DE GRANTHAM QUEBEC CANADA		
004-0334		004-0334		

B	MODIFICATION #A-0398 (CONNECTEUR)	04-04-19	J.G.
A	REDRAWN/ REMOVED 2 HOLES ON THE SEAL BAR	98-04-06	A.P.
LET.	MODIFICATION	DATE	INT.

ITEM	PART #	DESCRIPTION	QT.
1	004-0335	SEAL BAR PRE-ASSEMBLY	1
2	001-1738	SEAL BAR GUIDE	2
3	001-1829	SEAL BAR GUIDE SPACER	2
4	001A2757	SEAL BAR SUPPORT	1
5	051-0230	HEX. BOLT 1/4"-20 NC. X 1 1/4" S/S	4
6	051-0740	FLAT WASHER 1/4" S/S	4
7	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
8	051-0195	FLAT HEAD SCREW 1/4"-20 NC. X 3/4" S/S	3
9	038-0230	WIRING DUCT W/ ADH. BACK (0.36" X 0.5" X 170) 05858	1



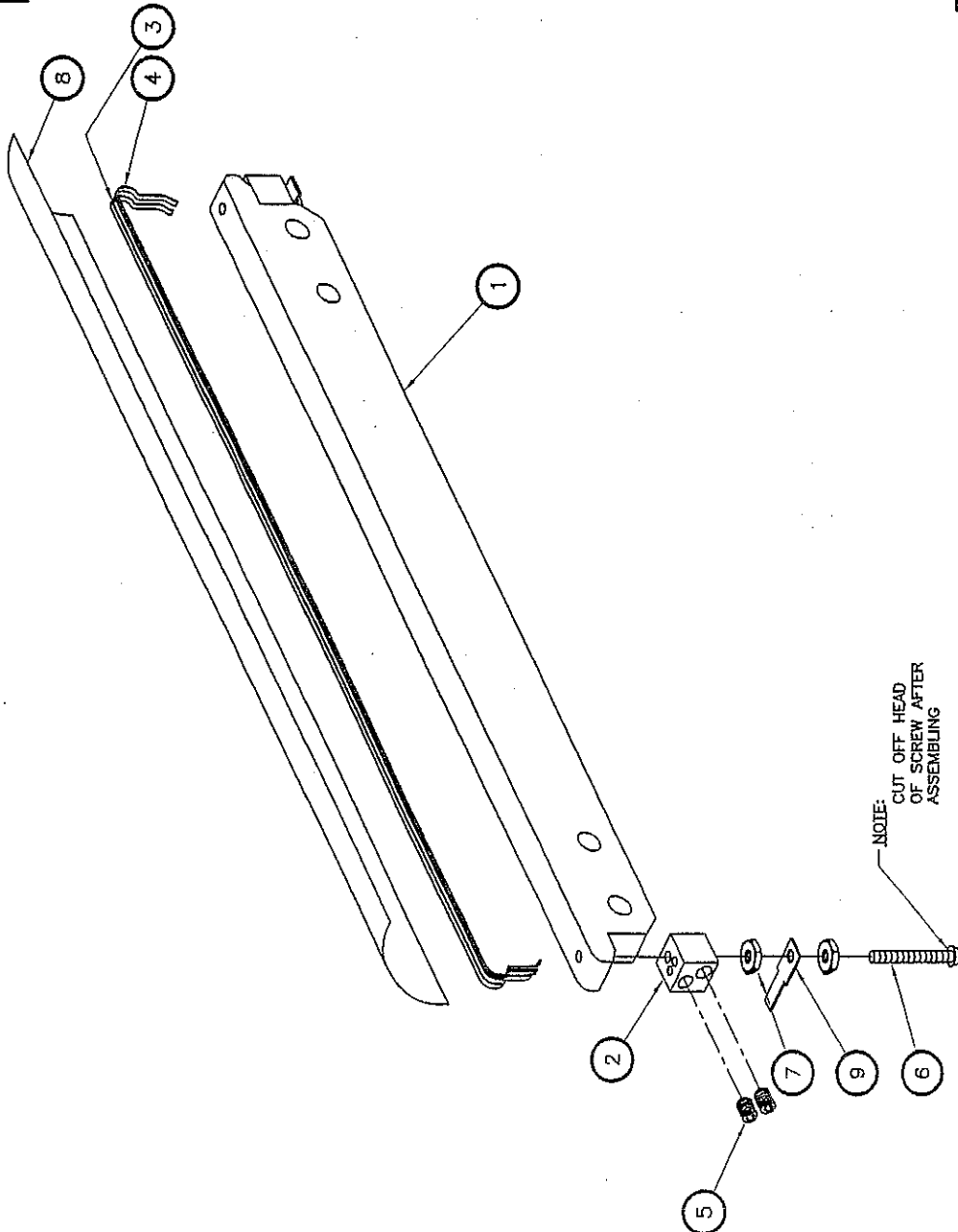
~~-BAG CUT OPTION-~~

MACHINE	250	METRE		INCH	SIPROMAC
PART	SEAL BAR ASSEMBLY	0 ± .5 0 ± .05 0 ± .005 0 ± .0005	0 ± .015 0 ± .005 0 ± .0005 0 ± .00005	N.T.S.	
ITEM#		ANGLE ± 1°		SCALE	01. 1
MAT#		BY M. A. LEBLANC		DATE 05-09-27	NO.
		APP.		05-1-28	005A0520

C	REDRAWN/ MODIFIED ITEM #4	05-09-27	M.A.L
LET.	MODIFICATION	DATE	INT.

1004-0335

ITEM	#PART	DESCRIPTION	QT.
1	002A0433	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0230	REFLEX BAND 2.5MM (460mm EA.)	0.046
4	039-0270	1" PROFILE CUT. ELEM. (460mm EA.)	0.046
5	052-0395	SET SCREW 1/4"-20 NC. X 5/16" (OVAL POINT)	4
6	052-0250	SET SCREW #8-32 NC. X 1 1/2" ROUND SLOT BRASS S/S	2
7	051-0550	HEX. NUT #8-32 NC. S/S	4
8	176-0202	TEFLON TAPE .005"x1-1/2" ADHES. (330mm EA.)	0.042
9	027-0400	CONNECTOR ADAPTOR	2



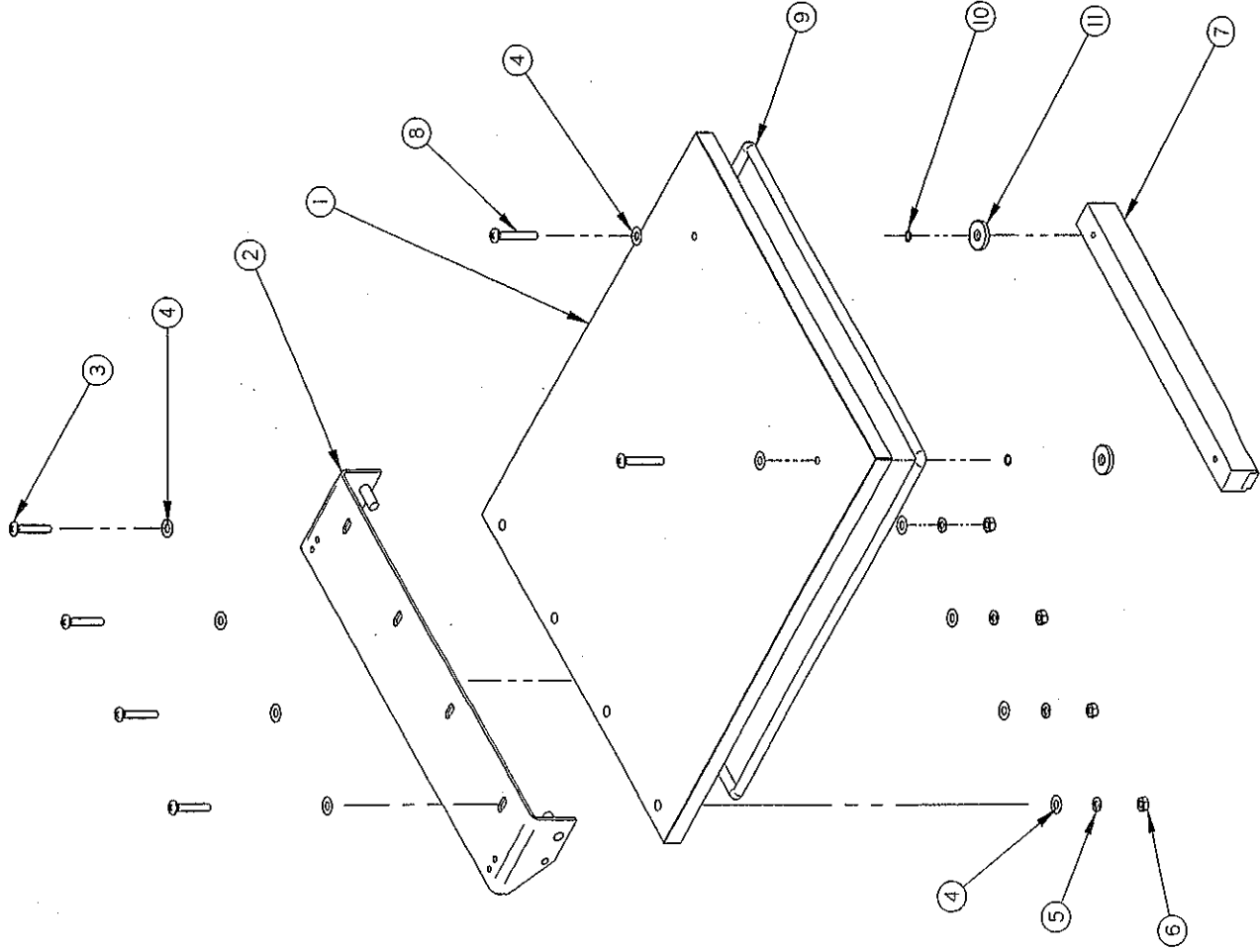
-BAG CUT OPTION-

MACHINE		250		SIPROMAC	
PART		SEAL BAR PRE-ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM	QTY	DATE	98-04-06	NO	1
DATE	98-04-06	DATE	98-04-06	NO	1
TOLERANCES		FRACTION		DECIMAL	
USINAGE	± 0.1	± 0.005	± 0.005	± 0.005	± 0.005
TOLERANCE	± 0.1	± 0.005	± 0.005	± 0.005	± 0.005
SCULPTURE	± 0.1	± 0.005	± 0.005	± 0.005	± 0.005
N.T.S.		N.T.S.		N.T.S.	
CNC		CNC		CNC	
AP		AP		AP	
DATE		DATE		DATE	
98-04-06		98-04-06		98-04-06	
004-0335		004-0335		004-0335	

B	MODIFICATION #A-0398 (CONNECTEUR)	04-04-19	J.G.
A	REDRAWN/ REMOVED 2 HOLES ON THE SEAL BAR	98-04-06	A.P.
LET.	MODIFICATION	DATE	INT.

1005B0522

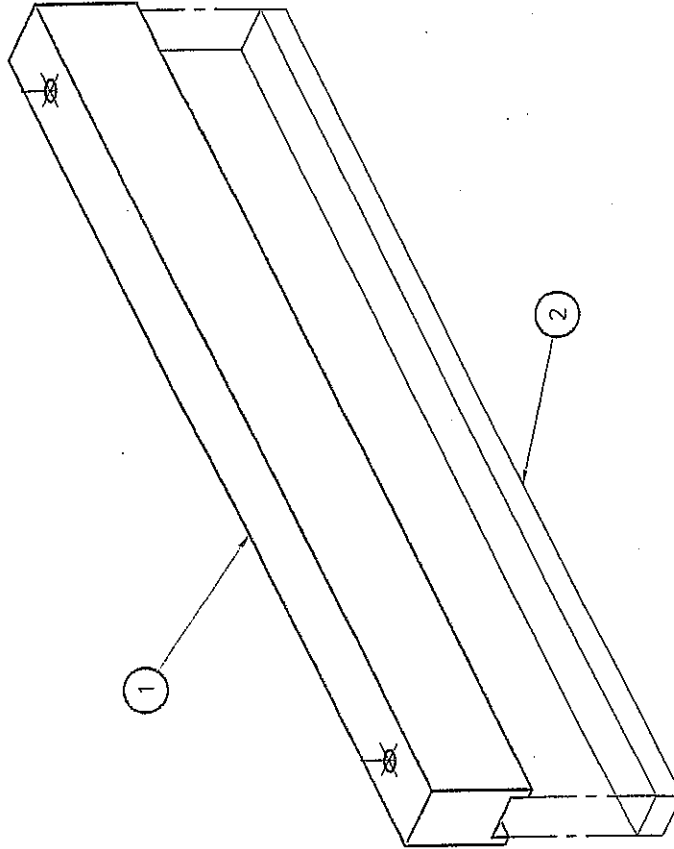
ITEM	PART #	DESCRIPTION	QT.
1	002A0438	PLEXI COVER	1
2	004A0309	COVER HINGE ASS'Y	1
3	051-0249	SCREW 1/4-20x 1-1/2" PAN PHIL SS	4
4	051-0740	WASHER 1/4" FLAT S/S	10
5	051-0750	WASHER 1/4" LOCK S/S	4
6	051-0580	NUT 1/4"-20nc. S/S	4
7	004A0308	UPPER SEAL BAR PRE-ASS'Y	1
8	051-0257	SCREW 1/4-20 x 1 3/4" PAN PHIL S/S	2
9	179-0005	NEOPRENE SPONGE 3/8" O.D.(5.47)	1
10	076-0010	"O" RING 1/4" x 3/8" x 1/16"	2
11	002-0437	UPPER SEAL BAR SPACER	2



MACHINE		250		SIPROMAC	
PART		COVER ASSEMBLY		ST-GERMAIN DE GRANBY QUEBEC CANADA	
ITEM		CNC		N.T.S.	
DATE		05-05-09		NO	
APP. BY		D		DATE 05-07-04	
M.A.L.		M-I		QTY. 1	
005B0522		005B0522		005B0522	

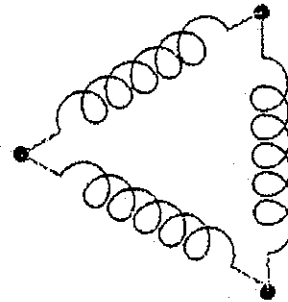
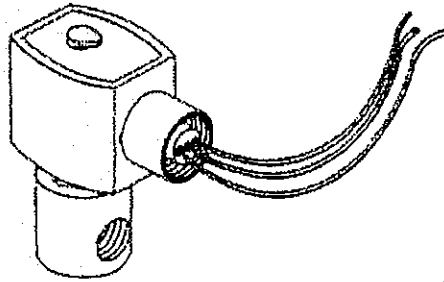
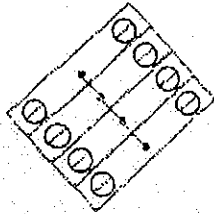
D	REDRAWN	05-05-09	M.A.
LET.	MODIFICATION	DATE	INT.

ITEM	PART #	DESCRIPTION	QT.
1	002A0436	UPPER SEAL BAR SUPPORT	1
2	008-0435	UPPER SEAL BAR RUBBER	1

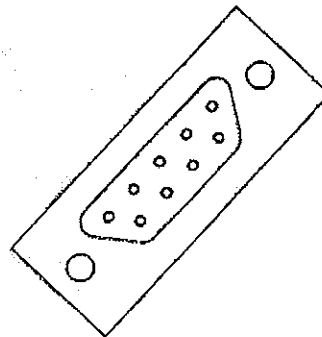
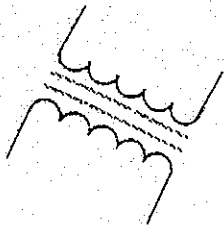


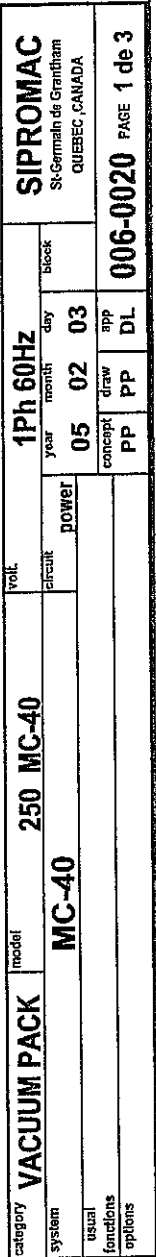
MACHINE	250, 380		METRIC TOLERANCE 1/16" ± .005 1/32" ± .003 1/64" ± .001		INCH TOLERANCE .015" ± .005 .010" ± .003 .005" ± .001		HIGH TOLERANCE .005" ± .001 .003" ± .001 .001" ± .001		SIPROMAC ST.-GERMAIN DE GRANTHAU QUEBEC CANADA		380 250	2 1
PART	UPPER SEAL BAR PRE-ASSY											
ITEM	135C 135C 135C											
DATE	98-08-02		SCALE		97		LISTE		004A0308			
NAME	S. LAROCHE		DATE		98-08-02		NO					
	L.T.											

LET.	MODIFICATION	DATE	INT.
B	AJOUTER 380	03-02-13	Y.C.
A	REDRAWN	99-08-02	S.L.

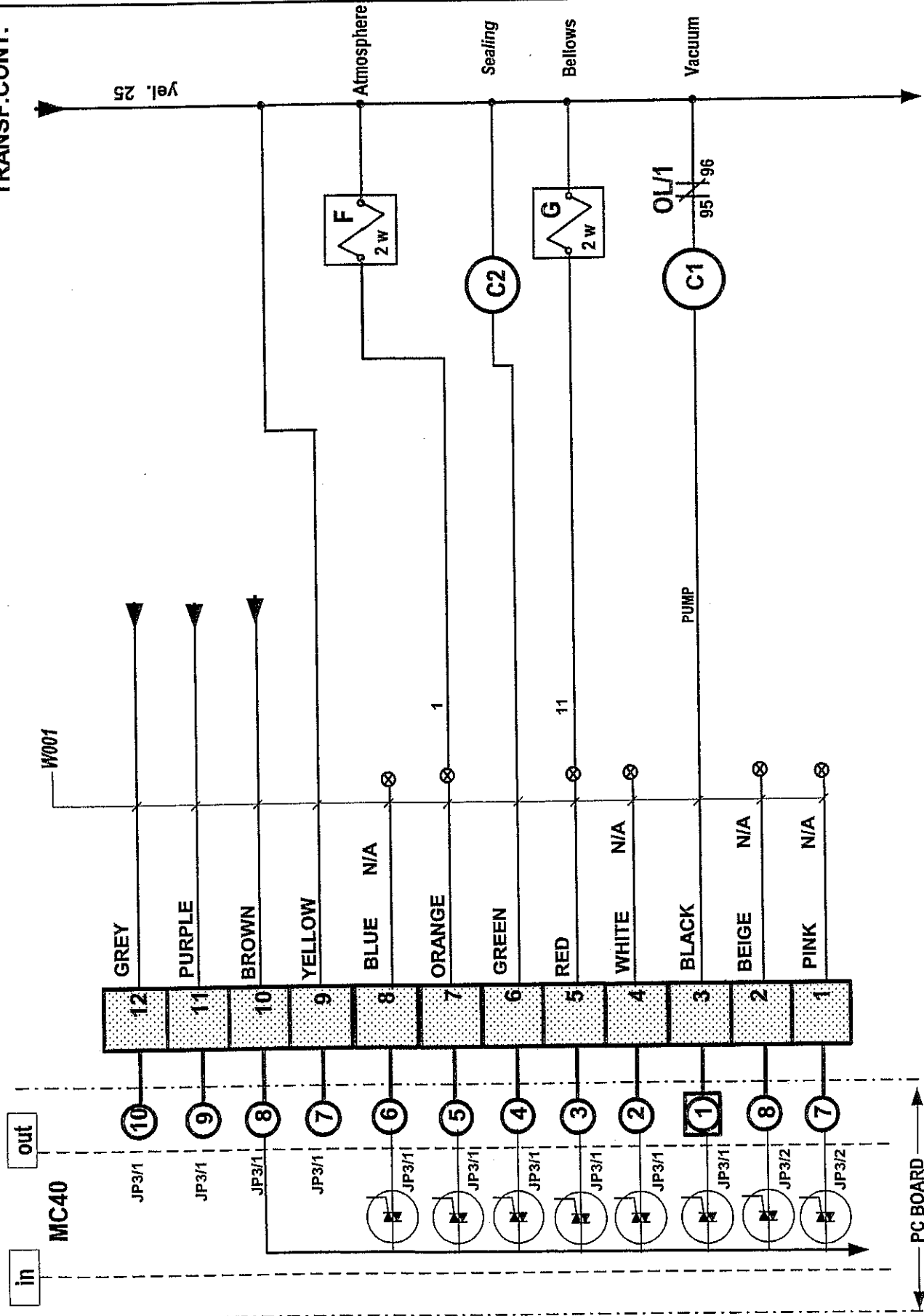


ELECTRICAL DRAWING



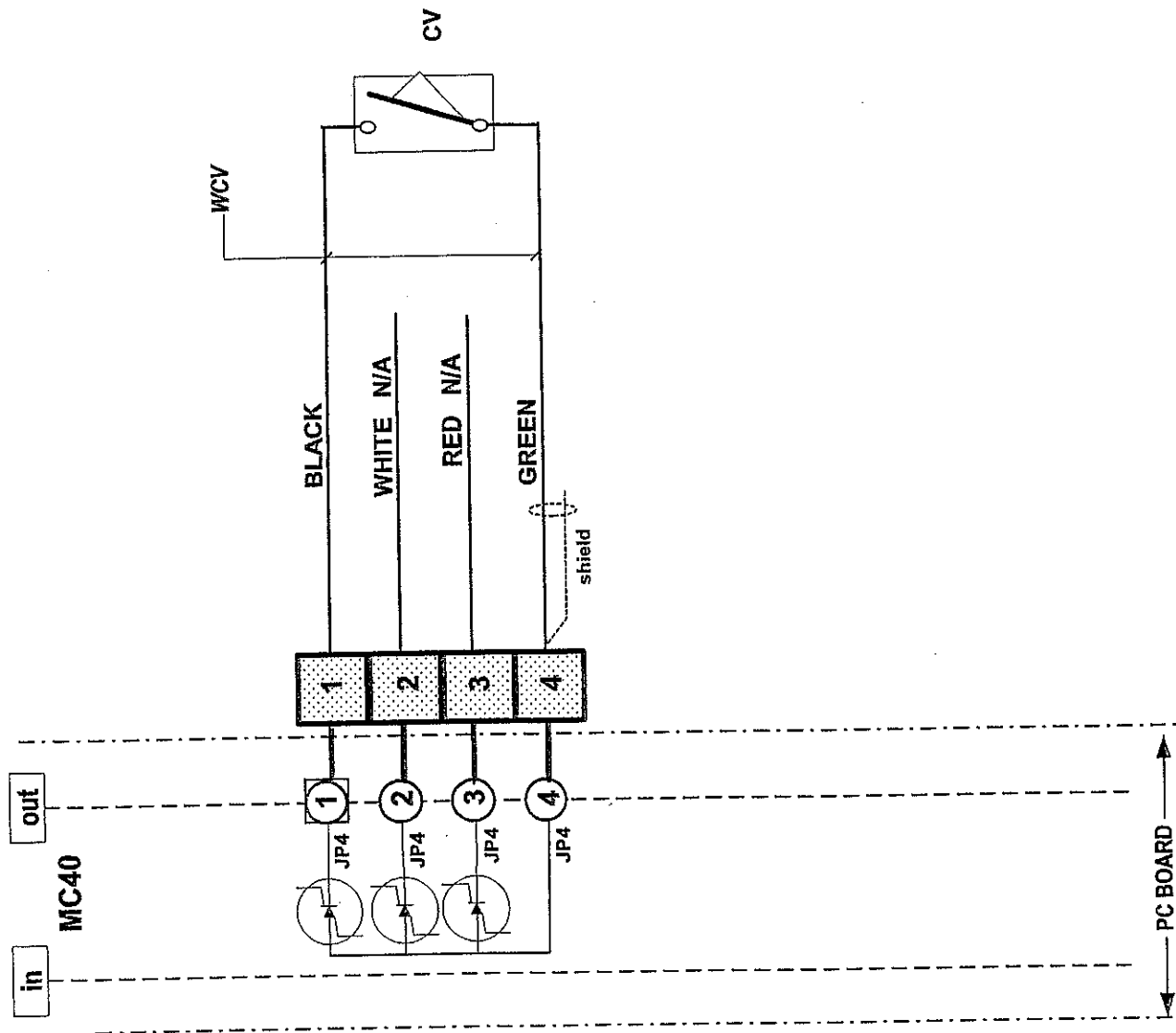


TRANSF.CONT.

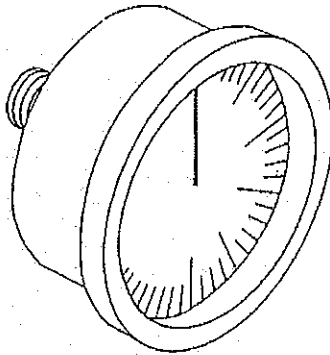


VACUUM PACK		model	250 MC-40	vol	24V 60Hz	SIPROMAC			
category	system	control	control	circuit	block	St-Germain de Grantham			
year	month	day	year	month	day	05	02	03	006-0020
concept	draw	app	concept	draw	app	PP	PP	DL	PAGE 2 de 3
usual	functions	options	MC-40						

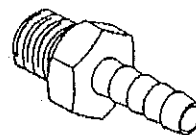
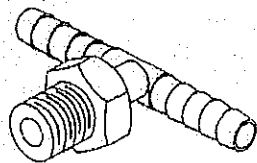
TRANSF.CONT.



category	model	250 MC-40		volts		24V 60Hz				SIPROMAC		
system	Control		circuit		control		year	month	day	block	St-Germain de Grantham QUEBEC CANADA	
usual	MC-40						05	02	03			
functions							concept	draw	app	DL		
options							PP	PP	PP	DL		
										006-0020		PAGE 3 de 3

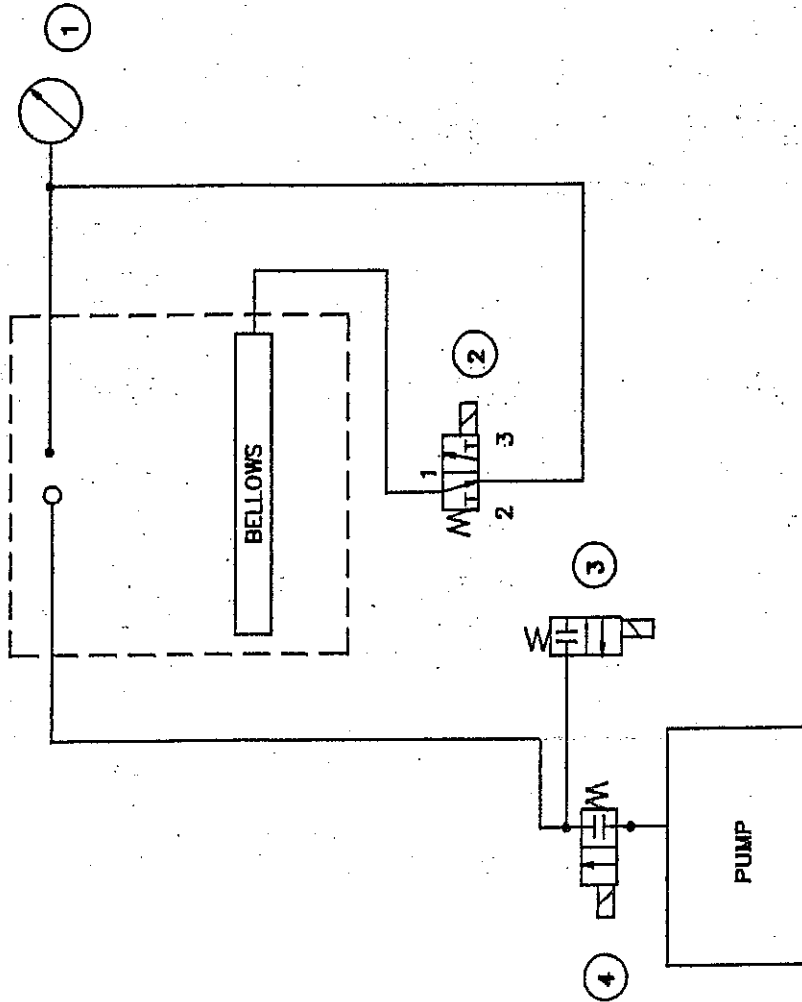


PNEUMATIC DRAWING



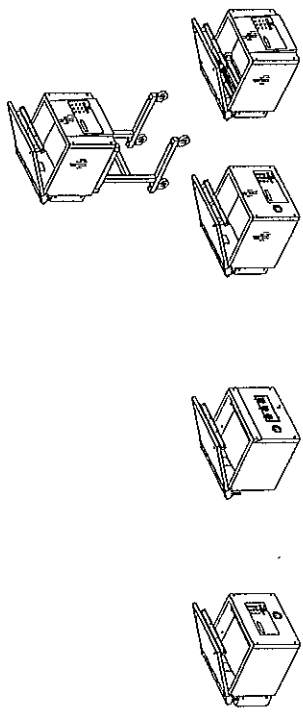
007-0035

ITEM	PART #	DESCRIPTION	QT.
1	114-0280	VACUUM GAUGE	1
2	106-0070	BELLOWS VALVE	1
3	106-0020	ATMOSPHERE VALVE	1
4	106-0020	VACUUM VALVE	1



MACHINE		250		SIPROMAC	
PART		PNEUMATIC DRAWING		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM	QNC	N.T.S.	SCALE	QT.	1
MAT	DATE	DATE	DATE	DATE	DATE
BY		DATE 96-11-06		NO.	
APP.		DATE		007-0035	
LET.	MODIFICATION		DATE	INT.	

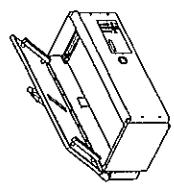
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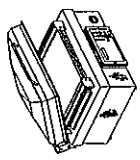
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300

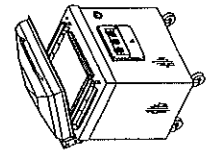
350/350D



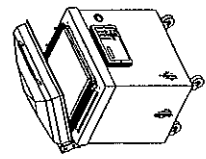
380A



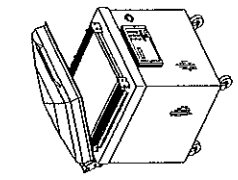
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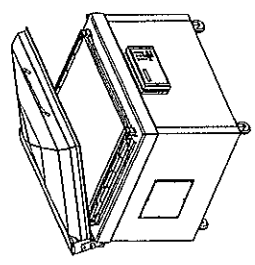
400A



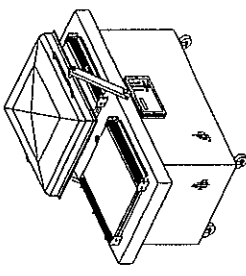
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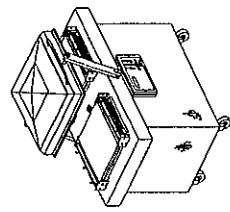
550A



580A

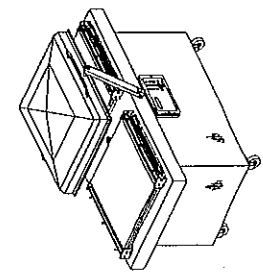


600A

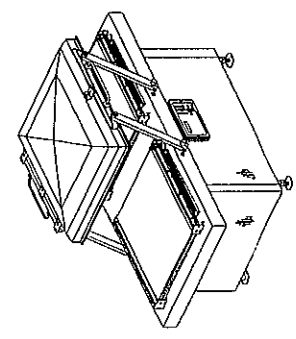


420A

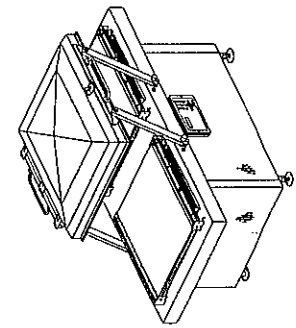
VACUUM PACKAGING MACHINES



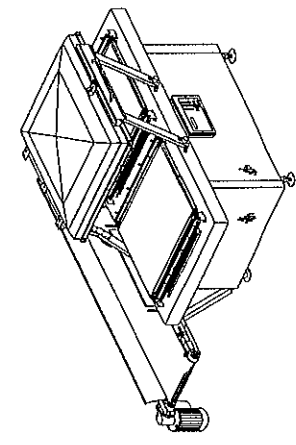
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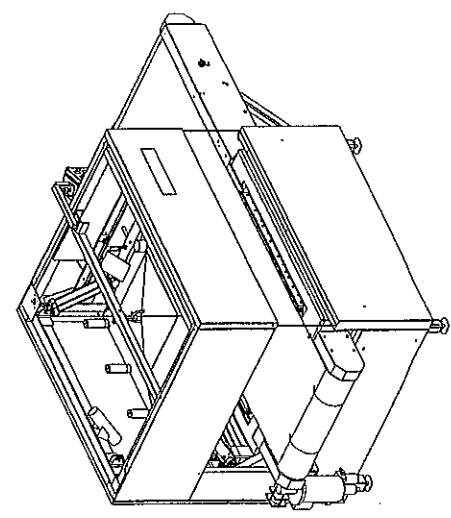
650A



680A



700A



750A