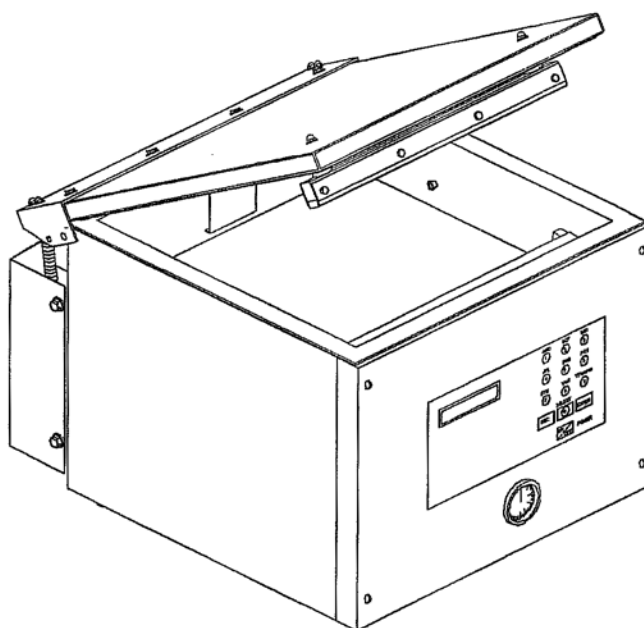




VACUUM PACKAGING MACHINE

MODEL 250

(Model with New Vacuum Sensor)



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 jewellery 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. 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 250

(MC-40)

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VACUUM PACKAGING MACHINES-OPERATION INSTRUCTIONS

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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.

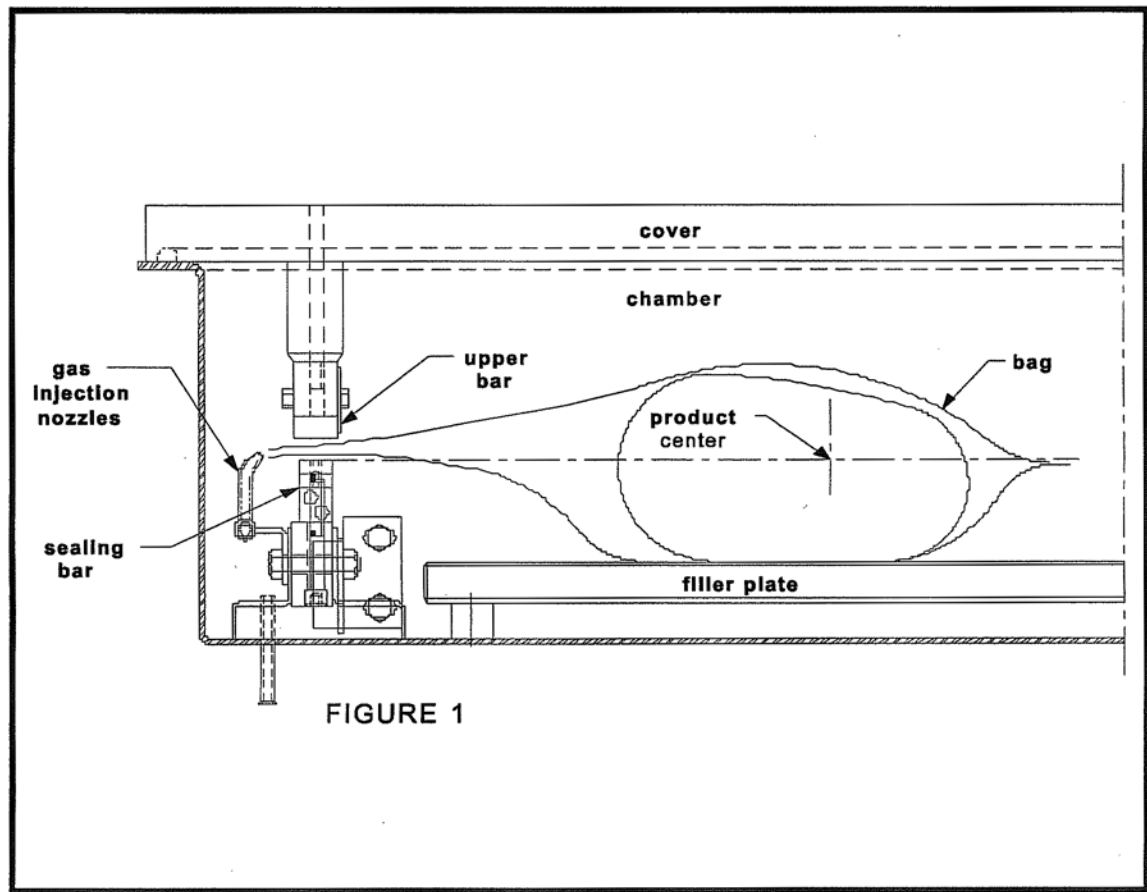
3.OPERATION:

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 14 and the keyboard detail on page 15.

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 (9 characters)	→	keys 2, 2, ENTER	→	E
		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:

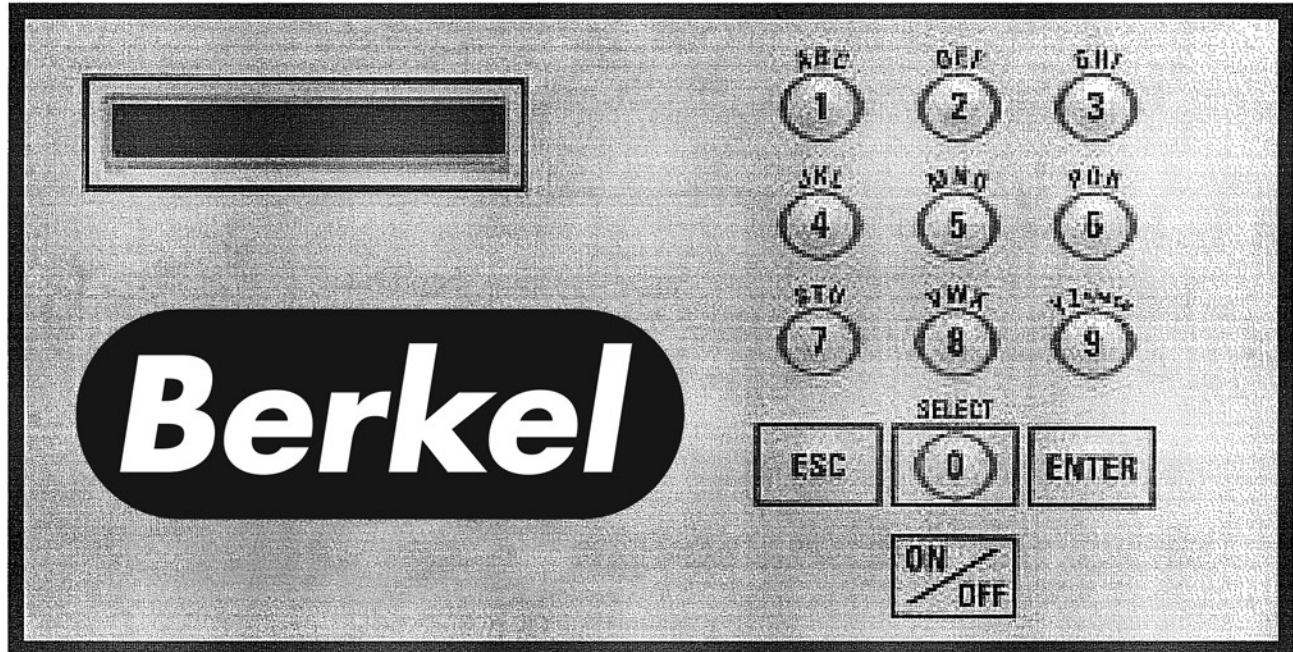
- "VACUUM: xx.xs" (10 – 199s)
 - "GAS FLUSH: xx.xs" (0 – 99s) (units with gas option)
 - "SEAL TIME: x.xxs" (0.00s - maximum unit allocated setting)
 - "Pxx NAME" (12 characters)

- **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: xxxxxxx"

-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.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

4.5 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.

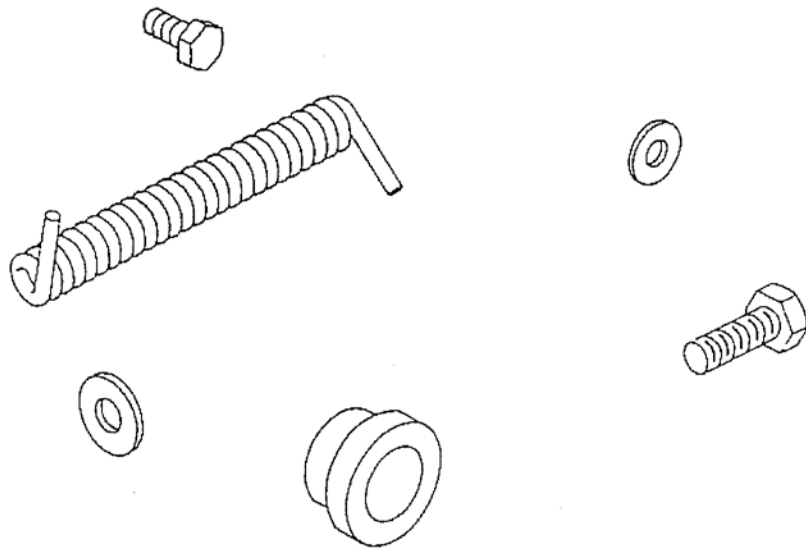
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

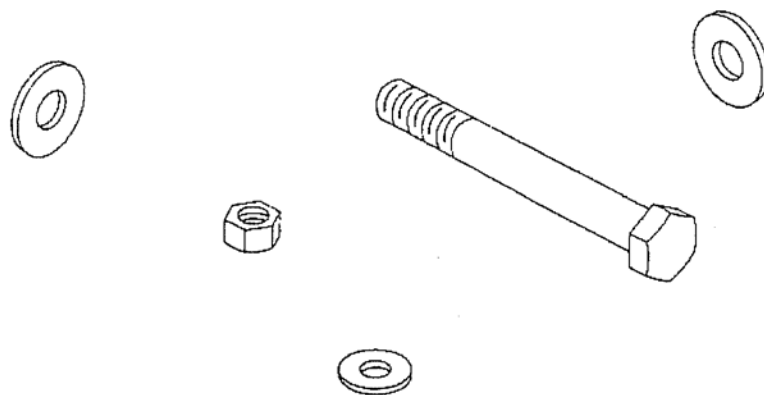
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

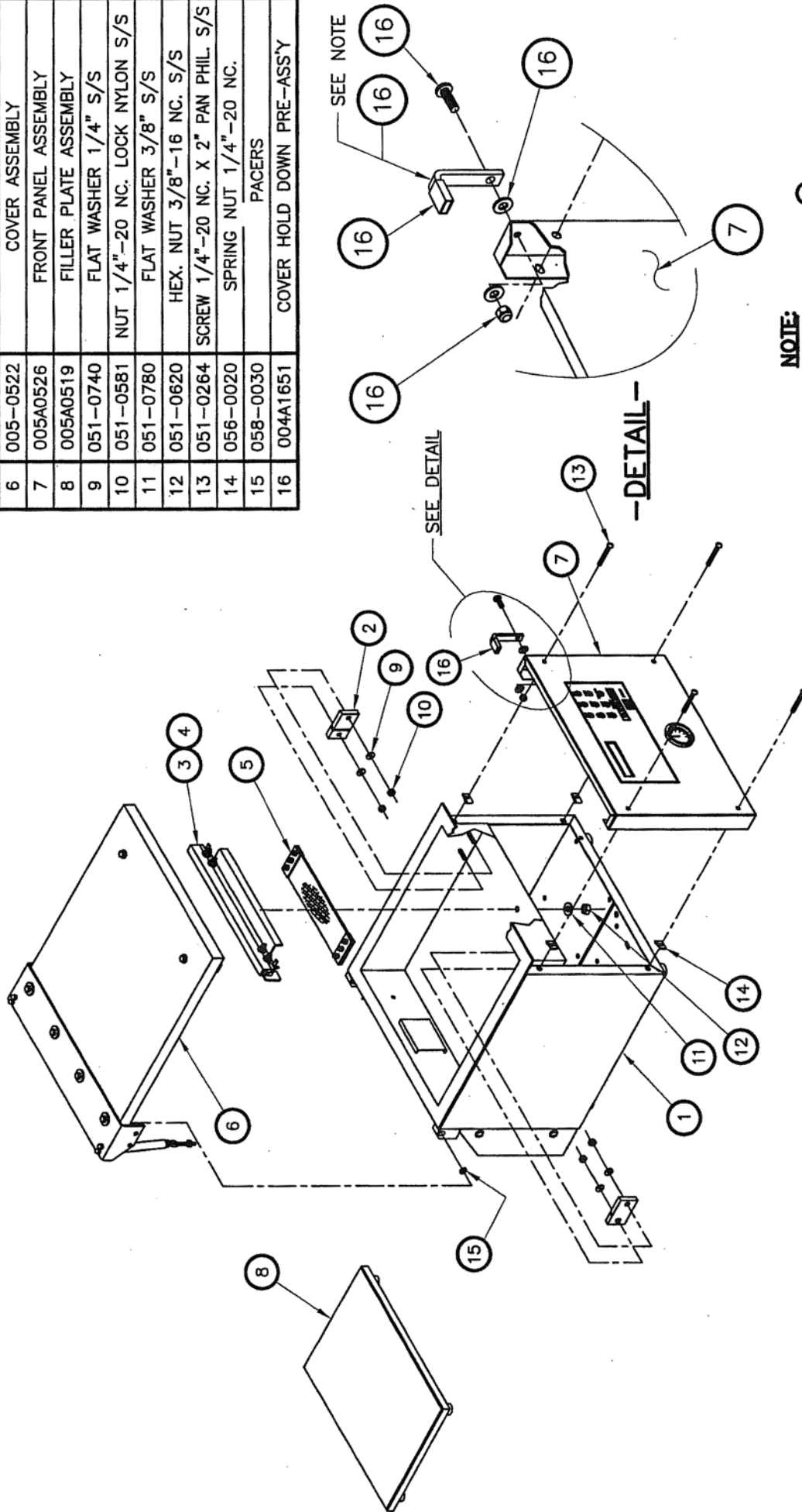


MECHANICAL DRAWING



|005A0523

ITEM	#PART	DESCRIPTION	QTY.
1	004-0406	VACUUM 250 PRE-ASS'Y	1
2	002A2282	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	005A0519	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	PACERS	2
16	004A1651	COVER HOLD DOWN PRE-ASS'Y	1



NOTE:

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

NOTE:

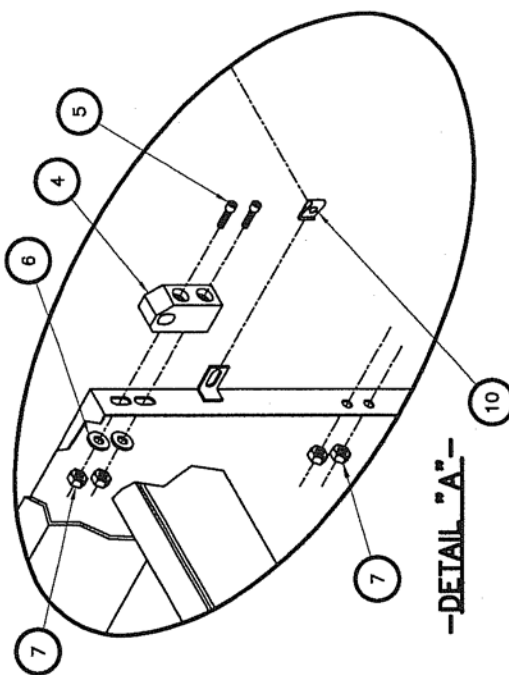
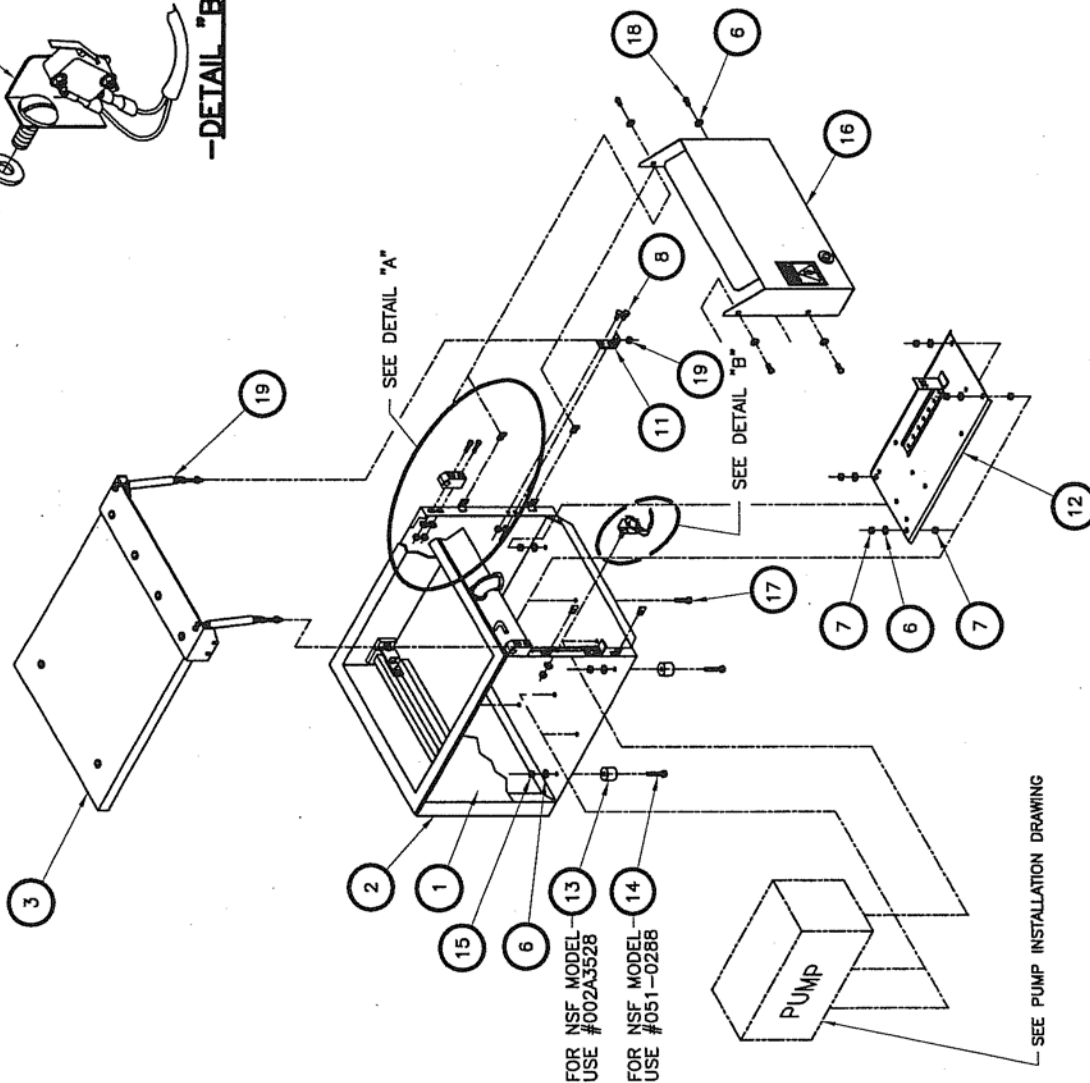
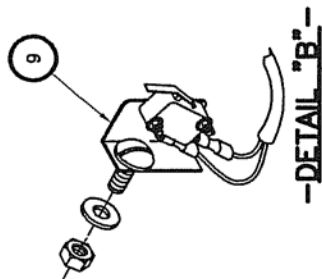
USE THIS DRAWING ALONG
WITH DRAWING #005A0527
TO ASSEMBLE THE MACHINE
NO PARTICULAR ORDER SHOWN.

MACHINE	250		TELEPRINTS		SIPROMAC	
PART	MACHINE ASSEMBLY FRONT VIEW		USHAZE	± 0.1	INCH	± 0.0004
			SOUHAZE	± 0.3		± 0.0007
			N.T.S.			
ITEM:	QTY		M-I			
MAT:	DATE		NO			
	DATE		005A0523			

H	REDRAWN		10-11-12	D.A.
LET.		MODIFICATION	DATE	INT.

005A0527

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 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	REAR 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:

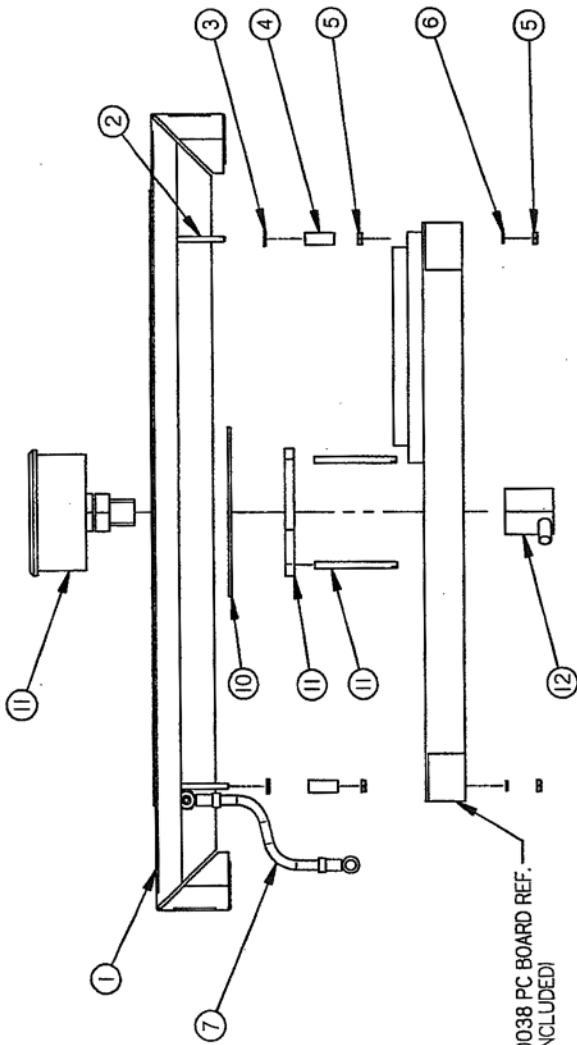
USE THIS DRAWING ALONG WITH DRAWING #005A0523 TO ASSEMBLE THE MACHINE NO PARTICULAR ORDER SHOWN.

MACHINE		250		SIPROMAC	
PART		MACHINE ASSEMBLY REAR VIEW		ST-GERMAIN DE GRANHAM QUEBEC CANADA	
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MAT:	APP:	DATE:	10-11-10	QTY:	1
				005A0527	

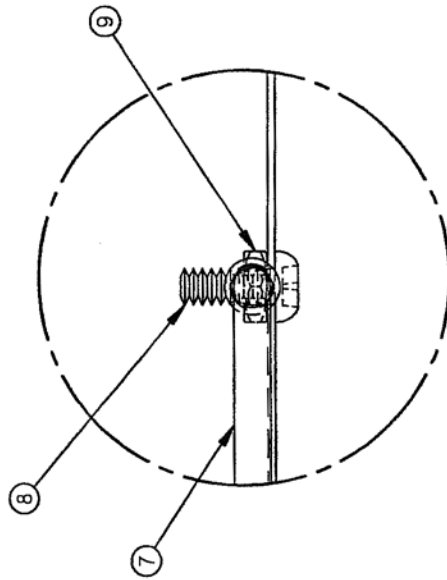
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1005A0526

ITEM	PART #	DESCRIPTION	QT.
1	001A1824	FRONT PANEL	1
2	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	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" SURE BARB	1



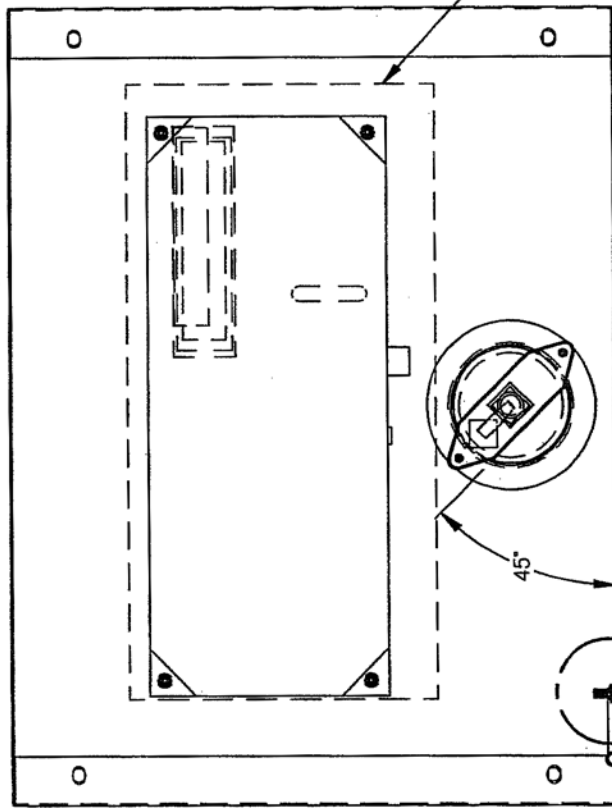
033-0038 PC BOARD REF.
(NOT INCLUDED)



DETAIL A

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

POSITION CAREFULLY IN REGARDS
TO OPENING IN ITEM #1



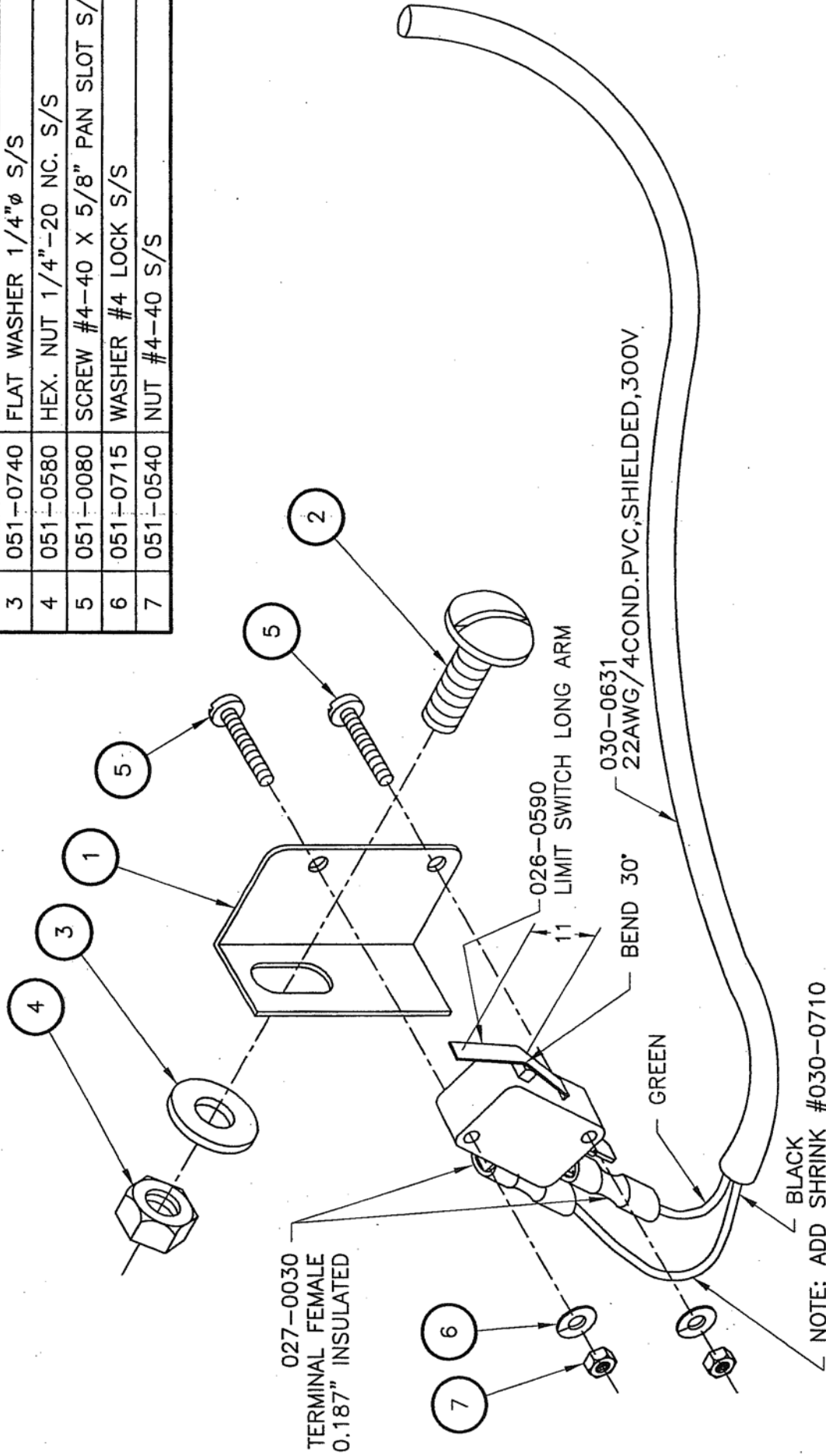
A

MACHINE		DEPT. TOL. METRIC INCH		SIPROMAC	
250		USINAGE ± 0.1 ± 0.004		ST-GERMAIN DE GRANTHAM	
PART		CHISEL ± 0.05 ± 0.007		QUEBEC CANADA	
ITEM		BOULANGE ± 0.5 ± 0.027		N.T.S.	
FRONT PANEL ASSEMBLY		DATE 04-10-13		DEPT. M-(M)-1	
APP. BY J.G.		DATE 04-10-13		NO. 005A0526	
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.
LET.	MODIFICATION	DATE	INT.

004-0261

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



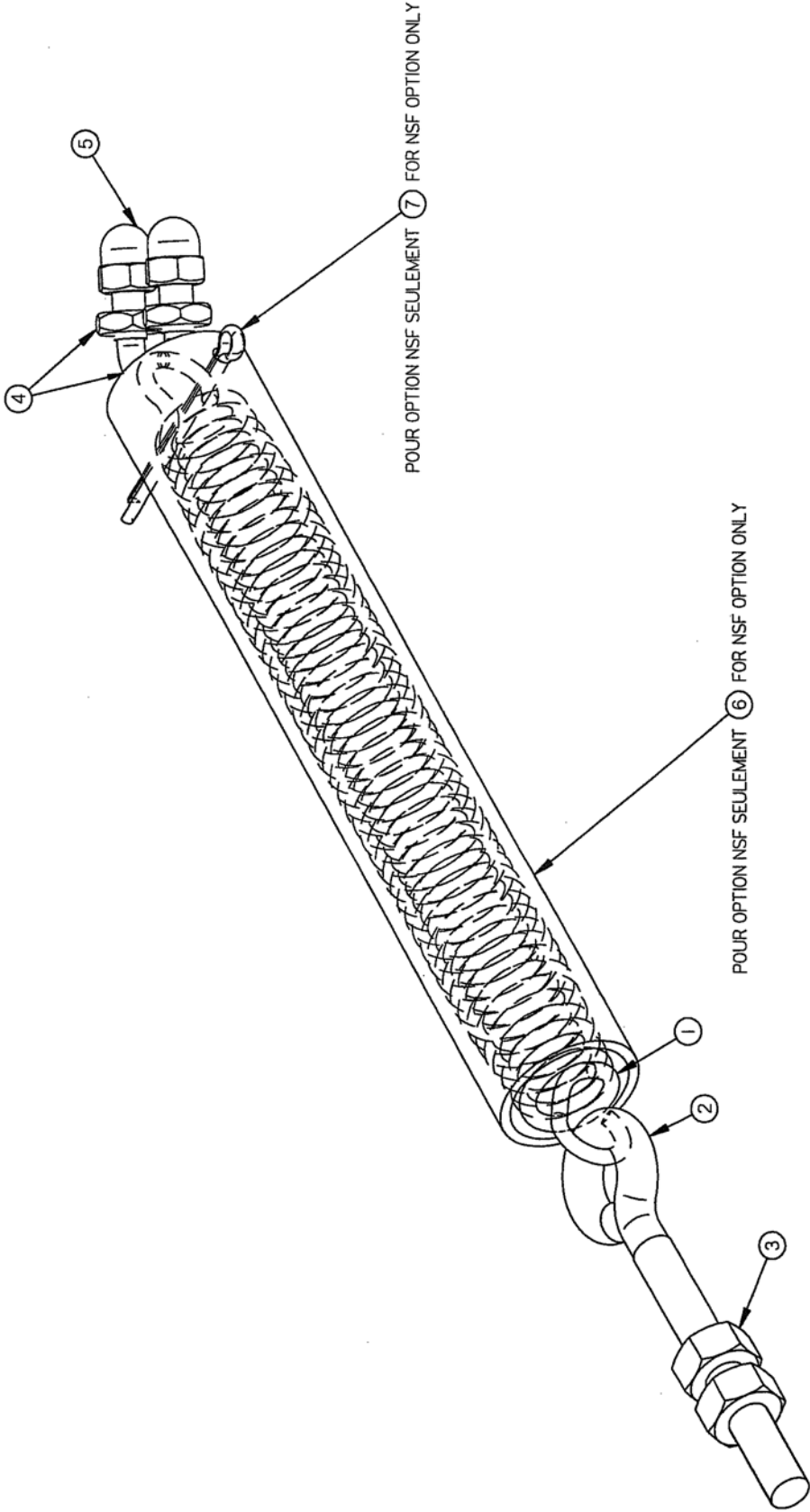
LET.	MODIFICATION		DATE	INT.
A	REDRAWN	97-11-11	M.L.	
B	ADDED 300	98-05-22	D.A.	
C	AJOUTER 380	03-02-12	Y.C.	
D	AJOUTER 380T	06-01-26	M.A.L.	
E	AJOUTER 300D	06-05-24	M.A.L.	
F	#2 051-01865 TRUSS SLOT WAS 051-0180 HEX	10-11-10	D.A.	
G	A&R 300 & 300D SEE 004A3374 / 030-0631 WAS 030-0610	10-11-16	D.A.	

MACHINE		250, 350, 380 & 380T		SIPROMAC	
PART		LIMIT SWITCH ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	_____	CNC:	_____	DEPT.	M-I OT. 1
MAT:	_____	DWG BY	M.LAVIGNE	DATE	97-11-11
		APP.	_____	DATE	_____
				NO.	004-0261

METRIC TOLERANCE	INCH TOLERANCE
0. $\pm$.5	.0 $\pm$.015"
.0 $\pm$.05	.00 $\pm$.005"
.00 $\pm$.005	.000 $\pm$.0005"
.000 $\pm$.0005	N.T.S.
ANGLE $\pm$ 1°	

004A1225

ITEM	PART #	DESCRIPTION	QT.
1	009A0151	SPRING GRAY	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

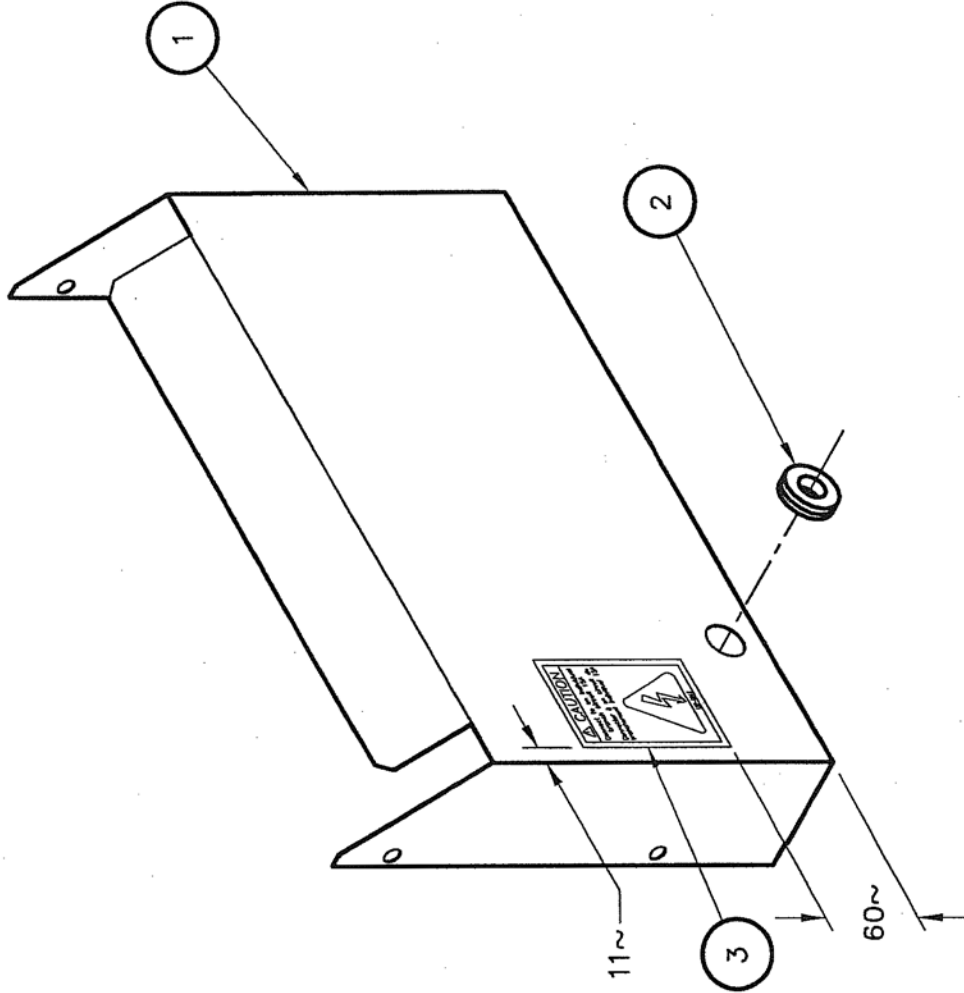


MACHINE		250 & 380		DEPT. 101 METRIC INCH		SIPROMAC	
PART		SPRING PRE-ASSEMBLY		TOLERANCE		ST-GERMAIN DE GRANHAM	
ITEM		CNC		TOLERANCE		QUEBEC CANADA	
MAT.		DATE 03-02-17		TOLERANCE		M-(M) QTY. 2	
APP. BY		DATE 03-02-17		TOLERANCE		004A1225	
		DATE 03-02-17		TOLERANCE			

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	05-02-17	M.A.
B	009A0151 WAS 004A1225	04-12-07	M.A.
A	MODIFIER QUANTITE DANS 380 (4>2)	03-09-04	J.P.
LET.	MODIFICATION	DATE	INT.

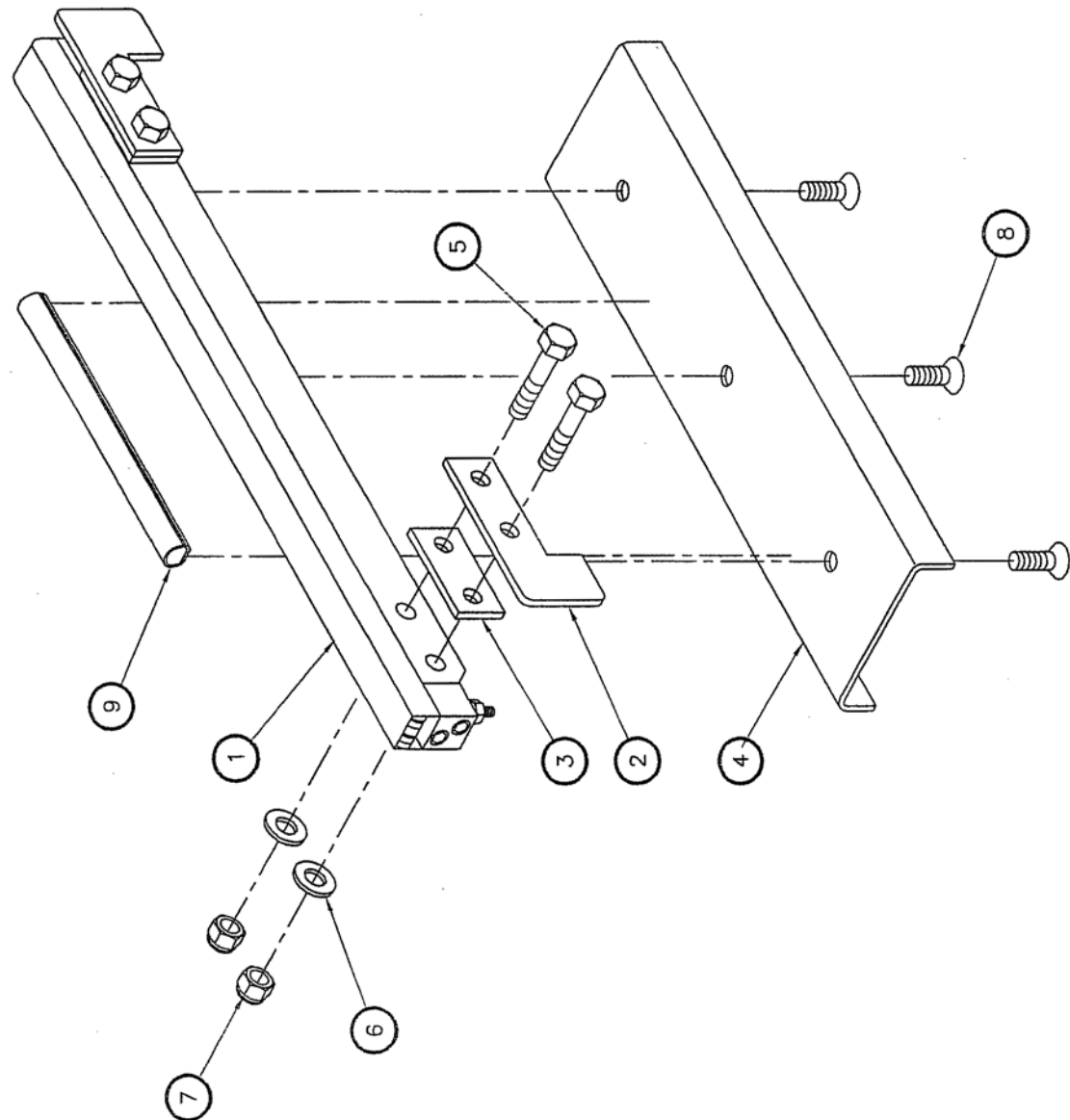
004-0363

ITEM	PART #	DESCRIPTION	QT.
1	001-1836	REAR PANNEL	1
2	036-0200	GROMMET	1
3	127-0115	STICKER ELEC. CONN. 15A 2-1/2" X 3-3/4"	1



MACHINE		250		SIPROMAC	
PART		REAR PANNEL PRE-ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:		CNC:		DEPT. M-I QT. 1	
DATE 10-11-02		DATE 10-11-02		NO.	
D.A.		D.A.		004-0363	
MODIFICATION		DATE		INT.	
A REDRAWN		DATE		INT.	
LET.		DATE		INT.	

ITEM	PART #	DESCRIPTION	QTY.
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	PIPING DUCT W/ ADH. BACK. (0.36" X 0.5" X 170) 0.5856	1

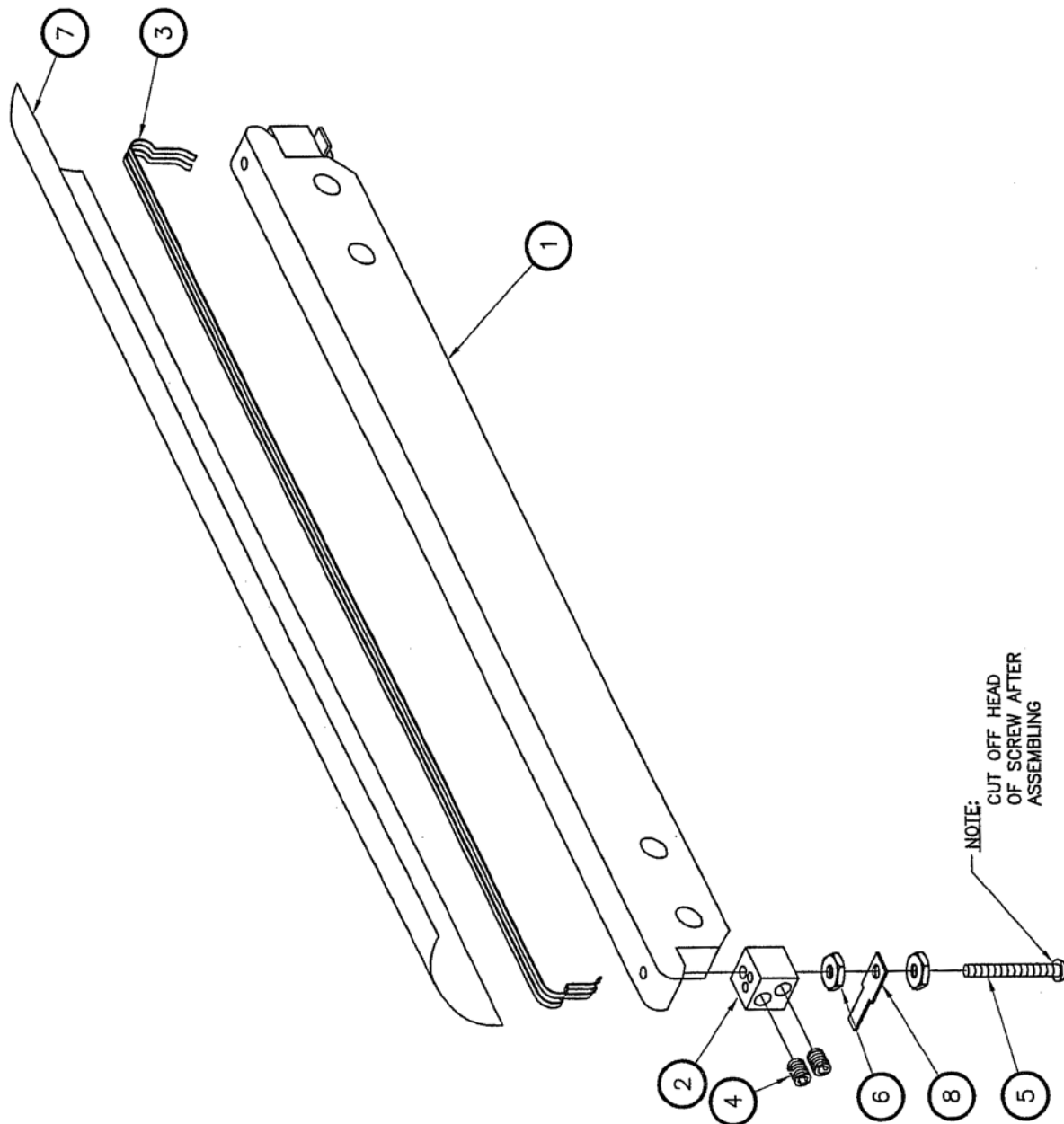


MACHINE	250	SYNOPSIS	DATE 05-09-27	NO.	1
PART	SEAL BAR ASSEMBLY	DATE	05-11-87	005A0497	
ITEM:		DATE	05-11-87	005A0497	
MAT:		DATE	05-11-87	005A0497	
APP:		DATE	05-11-87	005A0497	
SCALE		SCALE			
BY: M. A. LEBLANC		DATE	05-09-27	NO.	1
APP.		DATE	05-11-87	005A0497	

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

004-0334

ITEM	#PART	DESCRIPTION	QT.
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

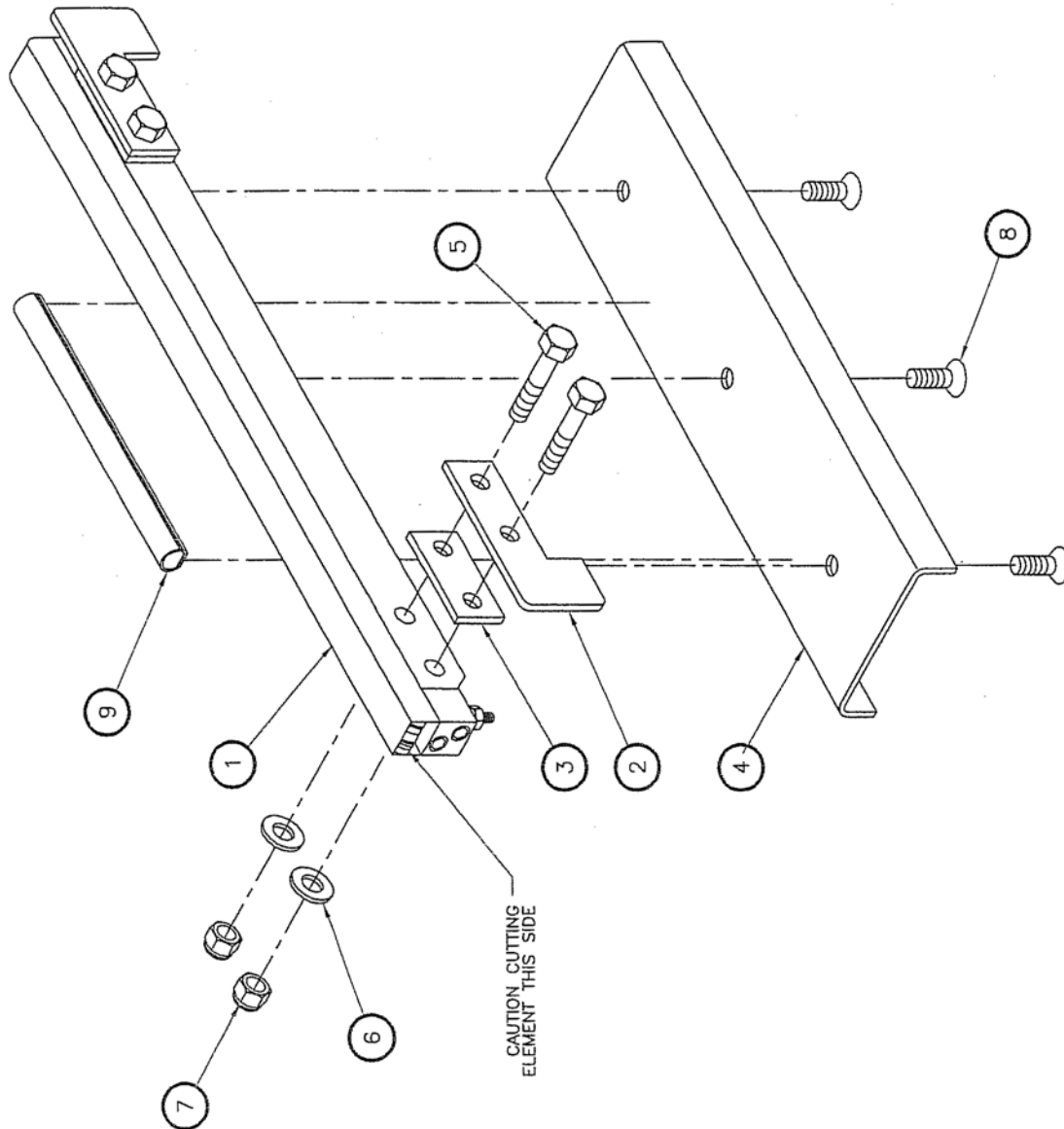


NOTE: CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

MACHINE	250	TELESCOPE METRO ± 0.1 ± 0.0004"		INCH ± 0.1 ± 0.0004"		SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	SEAL BAR PRE-ASSEMBLY	TOLERANCE ± 0.1 ± 0.0004"		TOLERANCE ± 0.1 ± 0.0004"		
ITEM	SEAL BAR PRE-ASSEMBLY	N.T.S.		M-I		1
MAT	SUPA PROVENCHER DATE 98-04-06 APP.	SUPA PROVENCHER DATE 98-04-06 APP.		SUPA PROVENCHER DATE 98-04-06 APP.		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) 0.59558	1

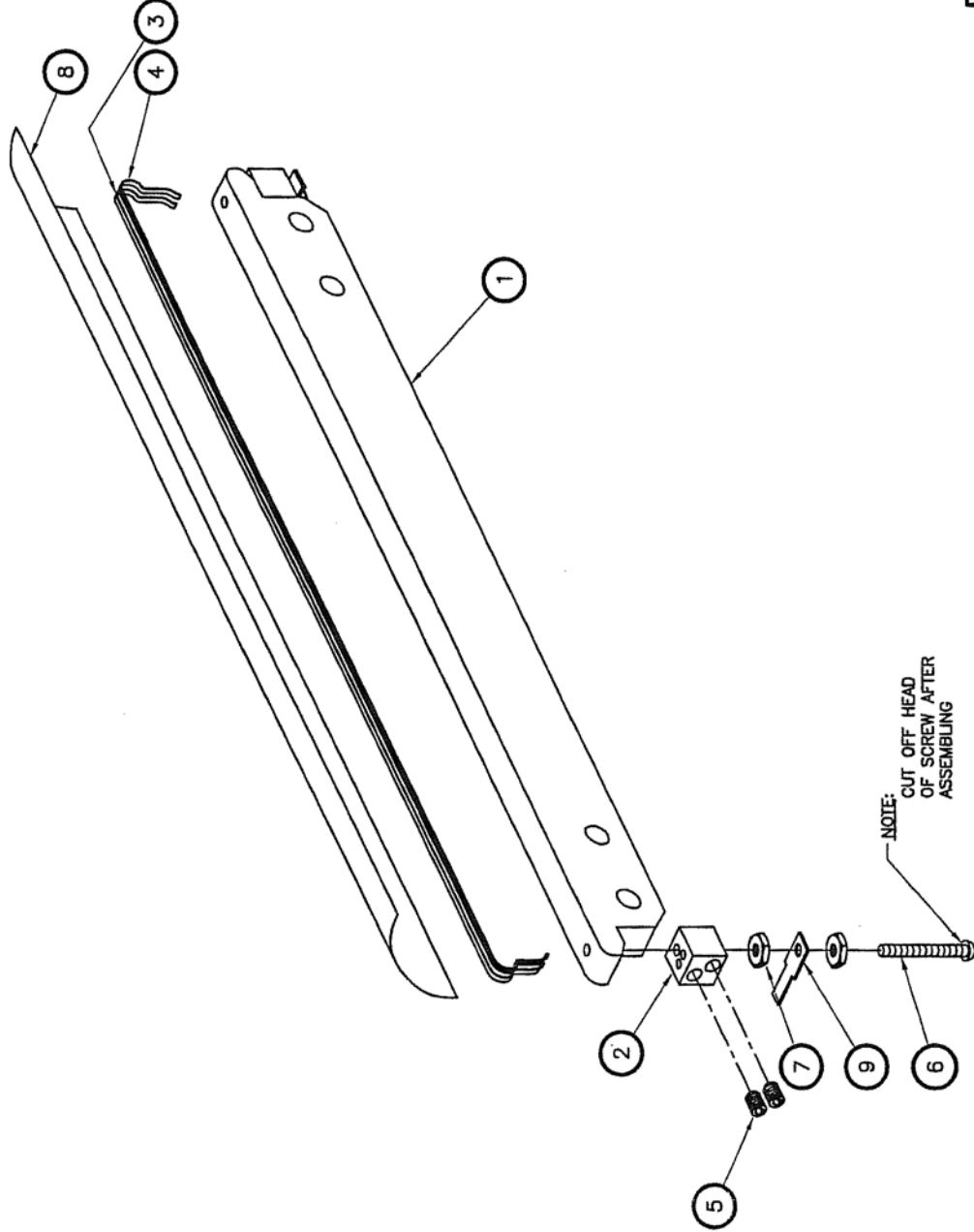


MACHINE		250		SIPROMAC		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART		SEAL BAR ASSEMBLY		N.T.S.		QT. 1	
ITEM:		QNC:		SCALE		ID.	
MAT:		GPM, A, LEBLANC		DATE 05-09-27		005A0520	
		APP:		DATE 05-11-28			

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

004-0335

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	"T" 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



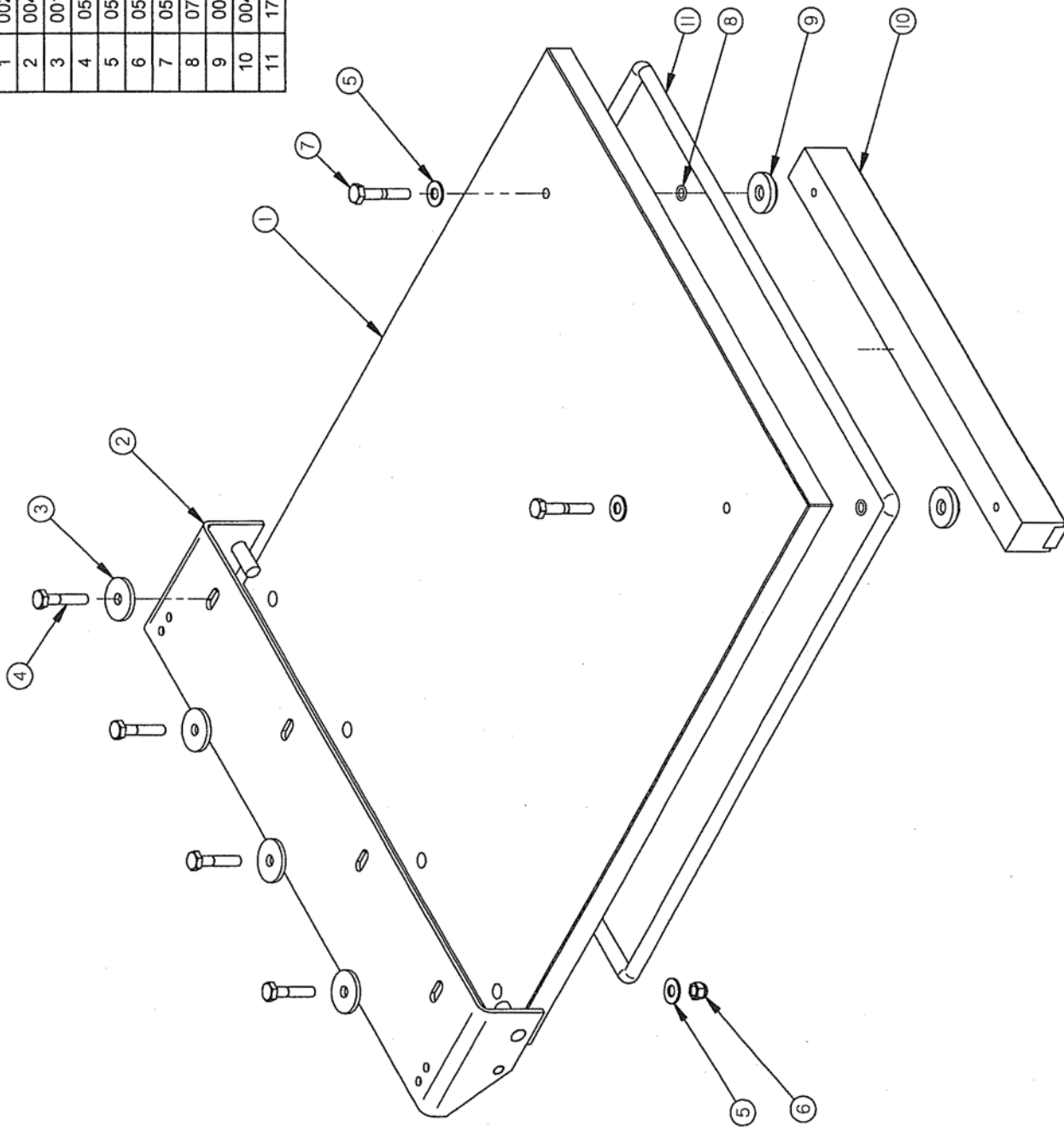
-BAG CUT OPTION-

MACHINE		250		SIPROMAC	
PART		SEAL BAR PRE-ASSEMBLY		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	QNC:	DATE	88-04-08	NO.	004-0335
MAT:	APP.	DATE	04-07-04	INT.	

B	MODIFICATION	1A-0398 (CONNECTEUR)	04-04-19	J.G.
A	REDRAWN/	REMOVED 2 HOLES ON THE SEAL BAR	98-04-08	A.P.
LET.	MODIFICATION		DATE	INT.

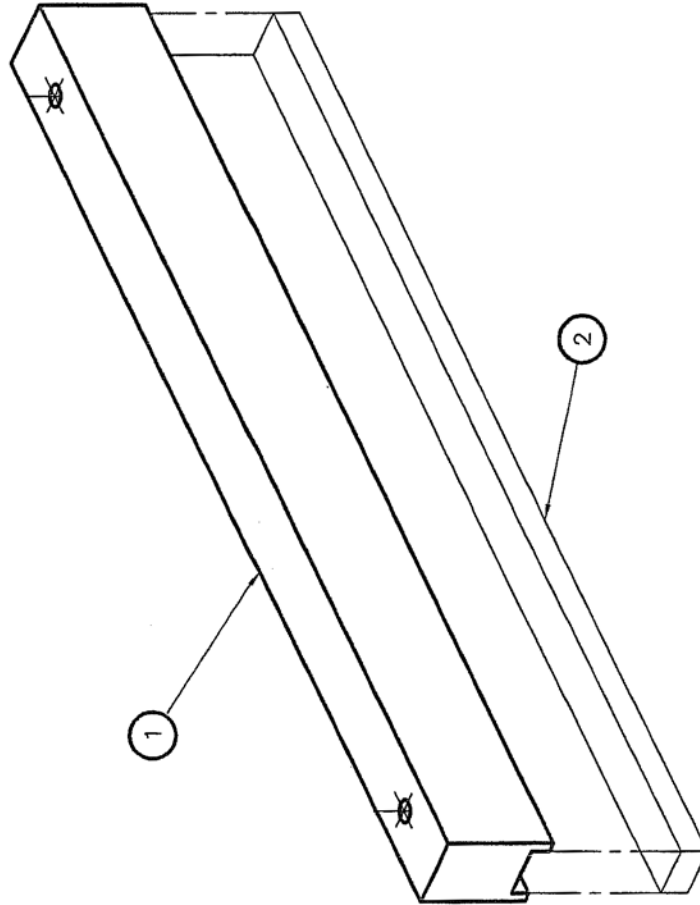
005B0522

ITEM	PART #	DESCRIPTION	QT.
1	002A0438	PLEXI COVER	1
2	004A0309	COVER HINGE ASS'Y	1
3	001A2919	WASHER 0.381" ID X 1.062" OD X 3	4
4	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	4
5	051-0740	WASHER 1/4" FLAT S/S	6
6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
7	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	2
8	076-0010	"O" RING 1/4" x 3/8" x 1/16"	2
9	002-0437	UPPER SEAL BAR SPACER	2
10	004A0308	UPPER SEAL BAR PRE-ASS'Y	1
11	179-0005	NEOPRENE SPONGE 3/8" O.D. 5.47	1



MACHINE	250	DEPT. TO: METRIC	INCH	SIPROMAC
PART	COVER ASSEMBLY	TO: 0.01	TO: 0.001	ST-GERMAIN DE GRANTHAM
ITEM	CNC	TO: 0.01	TO: 0.001	QUEBEC CANADA
MAT.	J.G.	TO: 0.01	TO: 0.001	
DATE	10-11-12	TO: 0.01	TO: 0.001	
APP. BY		TO: 0.01	TO: 0.001	
MODIFICATION		TO: 0.01	TO: 0.001	
REDESSINE (BOLT / WASHER CHANGED)	10-11-12	TO: 0.01	TO: 0.001	
LET.		TO: 0.01	TO: 0.001	
DATE	10-11-12	TO: 0.01	TO: 0.001	
INT.		TO: 0.01	TO: 0.001	
QTY.	1	TO: 0.01	TO: 0.001	
005B0522		TO: 0.01	TO: 0.001	

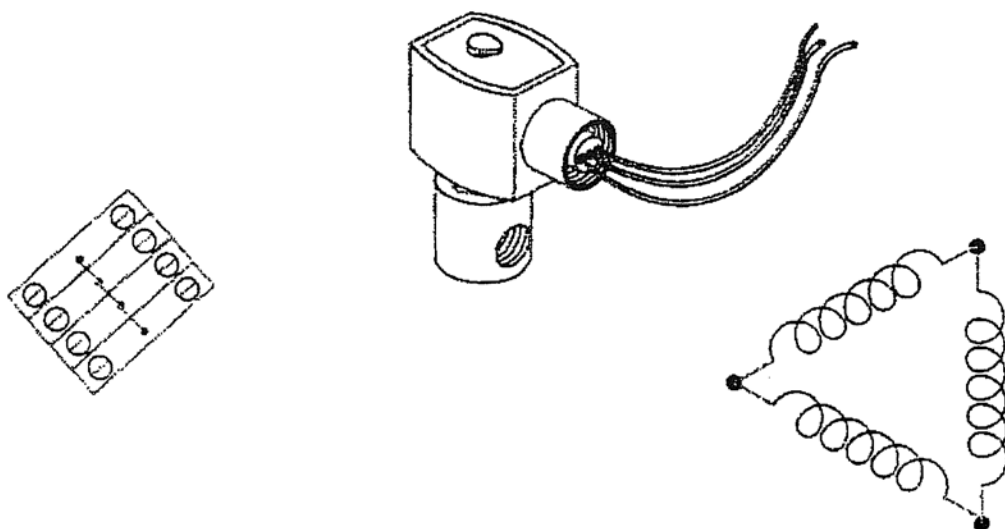
ITEM	PART #	DESCRIPTION	QT.
1	002A0436	UPPER SEAL BAR SUPPORT	1
2	008--0435	UPPER SEAL BAR RUBBER	1



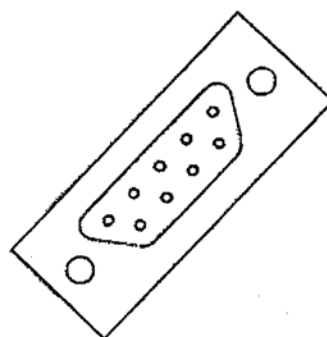
380T	2
380	2
250	1

[illegible]

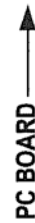
C	ADJUTER 380T		08-01-26	M.A.L.
B	ADJUTER 380		03-02-13	Y.C.
A	REDRAWN		99-08-02	S.L.
LET.		MODIFICATION	DATE	INT.



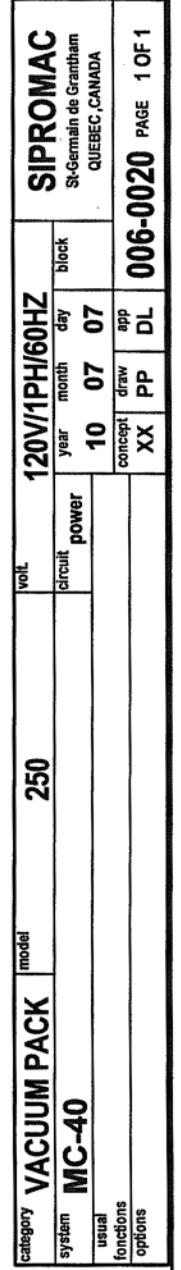
ELECTRICAL DRAWING



OUT

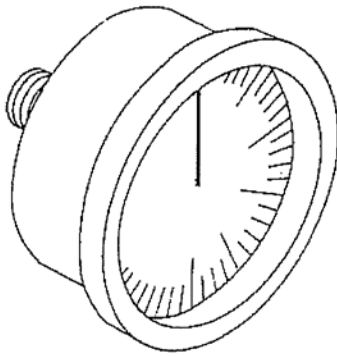


category	VACUUM PACK	model	250	vol				ALL				SIPROMAC			
system	MC-40			circuit	control		year	month	day	block	St-Germain de Grantham QUEBEC, CANADA				
usual															
functions															
options															
				concept	draw	app	DL	006-0037				PAGE 1 de 2			

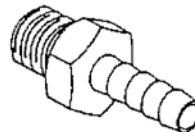
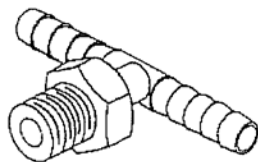


# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
036-1500	MALE PLUG 15 AMP./ 125 V.	SUPPLY	120V/1PH/60HZ	250	GND-L1-N		1
030-0160	CAB TIRE	SUPPLY	120V/1PH/60HZ	250	GND-L1-N		3 M.
028-0008	TERMINAL BLOCK M4/6 600V/25A.(22-10 AWG)	SUPPLY	120V/1PH/60HZ	250	N		1
028-0060	SEPARATOR M4/6	SUPPLY	120V/1PH/60HZ	250	N		1
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	250	GND		1
034-0755	FUSE HOLDER 30A 1 PÔLE	VACUUM PB-0004	120V/1PH/60HZ	250	F1		1
034-0445	FUSE MIDGET 5A/250V TIME-DELAY	VACUUM PB-0004	120V/1PH/60HZ	250	F1		1
025-0010	MOTOR CONTACTOR 1/3HP IN 120V-CSA,UL	VACUUM PB-0004	120V/1PH/60HZ	250	C1		1
025-0130	THERMAL OVERLOAD 1.6 TO 2.5A-CSA,UL	VACUUM PB-0004	120V/1PH/60HZ	250	O/L1		1
125-0004	VACUUM PUMP 115V/1PH/60HZ 0.1KW 2.1A	VACUUM PB-0004	120V/1PH/60HZ	250	M1		1
034-0755	FUSE HOLDER 30A 1 PÔLE	SEALING	120V/1PH/60HZ	250	F2		1
034-0445	FUSE MIDGET 5A/250V TIME-DELAY	SEALING	120V/1PH/60HZ	250	F2		1
025-0010	MOTOR CONTACTOR 1TH=25A-CSA,UL	SEALING	120V/1PH/60HZ	250	C2		1
029-0400	TRANSFO 200VA, 120V/24V 60HZ	SEALING	120V/1PH/60HZ	250	TR1		1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING	ALL	250	WEL		2
030-0410	TEW #10/104 BLACK	SEALING	ALL	250	WEL		1.5M.
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING	ALL	250	WEL		2
005A0497	SEAL BAR ASSEMBLY	SEALING TWIN SEAL	ALL	250		A1	1
005A0520	SEAL BAR ASSEMBLY	SEALING BAG CUT	ALL	250		A2	1
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	120V/1PH/60HZ	250	F5		1
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	120V/1PH/60HZ	250	F5		1
029-0008	TRANSFO 65VA/120V/24-9V	CONTROL TRANSFO	120V/1PH/60HZ	250	TR2		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	250	F3+F4		2
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	250	F3		1
034-0240	FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	250	F4		1
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	250	W001		1M.
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	250	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	250	WCV		2M.
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	250	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	250	JP4		2
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL	ALL	250	MC-40		1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	250		B1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	250		B2	1
106-0020	VALVE 2WAY 24V 1/2 NPT(G94) 60HZ	ATMOSPHERE	ALL	250	F		1
106-0070	VALVE 3WAY 24V 1/4 NPT(G176)60HZ	BELLOWS	ALL	250	G		1
026-0590	LIMIT SWITCH LONG ARM 15A 250V	COVER POSITION	ALL	250	CV		1
036-1512	MALE PLUG 15 AMP./ 250 V.	SUPPLY	220V/1PH/60HZ	250	GND-L1-L2		1
030-0160	CAB TIRE	SUPPLY	220V/1PH/60HZ	250	GND-L1-L2		3 M.
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	250	GND		1
034-0755	FUSE HOLDER 30A 1 PÔLE	VACUUM PB-0004	220V/1PH/60HZ	250	F1		2

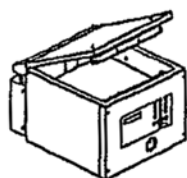
# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
034-0427	FUSE MIDGET 3A/250V TIME-DELAY	VACUUM PB-0004	220V/1PH/60HZ	250	F1		2
025-0010	MOTOR CONTACTOR 1HP IN 220V MONO-CSA,UL	VACUUM PB-0004	220V/1PH/60HZ	250	C1		1
025-0120	THERMAL OVERLOAD 1 TO 1.8A-CSA,UL	VACUUM PB-0004	220V/1PH/60HZ	250	O/L1		1
125-0005	BUSCH PB-0004 220V/1PH/50-60 0.1KW 1.1A	VACUUM PB-0004	220V/1PH/60HZ	250	M1		1
034-0755	FUSE HOLDER 30A 1 PÔLE	SEALING	220V/1PH/60HZ	250	F2		2
034-0445	FUSE MIDGET 5A/250V TIME-DELAY	SEALING	220V/1PH/60HZ	250	F2		2
025-0010	MOTOR CONTACTOR ITH=25A-CSA,UL	SEALING	220V/1PH/60HZ	250	C2		1
029-0018	TRANSFO 250VA 220V/24V 50/60HZ	SEALING	220V/1PH/60HZ	250	TR1		1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING	ALL	250	WEL		2
030-0410	TEW #10/104 BLACK	SEALING	ALL	250	WEL		1.5M.
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING	ALL	250	WEL		2
005A0497	SEAL BAR ASSEMBLY	SEALING TWIN SEAL	ALL	250		A1	1
005A0520	SEAL BAR ASSEMBLY	SEALING BAG CUT	ALL	250		A2	1
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	220V/1PH/60HZ	250	F5		2
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	220V/1PH/60HZ	250	F5		2
029-0007	TRANSFO 65VA/220-230-460V/24-9	CONTROL TRANSFO	220V/1PH/60HZ	250	TR2		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	250	F3+F4		2
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	250	F3		1
034-0240	FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	250	F4		1
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	250	W001		1M.
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	250	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	250	WCV		2M.
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	250	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	250	JP4		2
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL	ALL	250	MC-40		1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	250		B1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	250		B2	1
106-0020	VALVE 2WAY 24V 1/2 NPT(G94) 60HZ	ATMOSPHERE	ALL	250	F		1
106-0070	VALVE 3WAY 24V 1/4 NPT(G176)60HZ	BELLOWS	ALL	250	G		1
026-0590	LIMIT SWITCH LONG ARM 15A 250V	COVER POSITION	ALL	250	CV		1



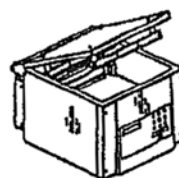
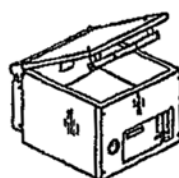
PNEUMATIC DRAWING



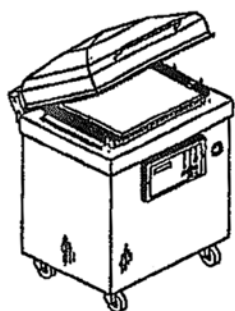
VACUUM PACKAGING MACHINES



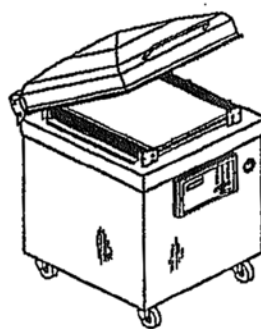
250



350/350D



450A



550A