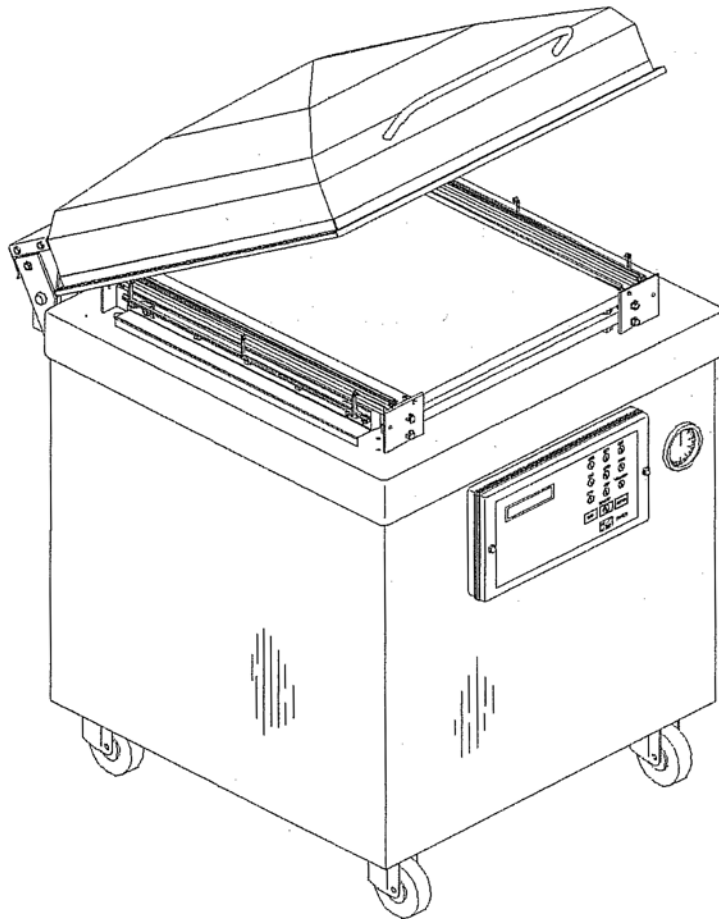




VACUUM PACKAGING MACHINE

MODEL 550A

(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 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. Save these instructions for future reference.

VACUUM PACKAGING MACHINE

MODEL 550A

(MC-40 SIPROMAC)

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VACUUM PACKAGING MACHINES-OPERATION INSTRUCTIONS

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2010-08-30

SIPROMAC INC.

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 corresponds to the proper voltage and amperage of the machine. **GROUNDING INSTRUCTIONS:** This appliance must be connected to a grounded, metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment-grounding terminal or lead on the appliance. A qualified electrician should be consulted if there is any doubt as to whether an outlet box is properly grounded.

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:

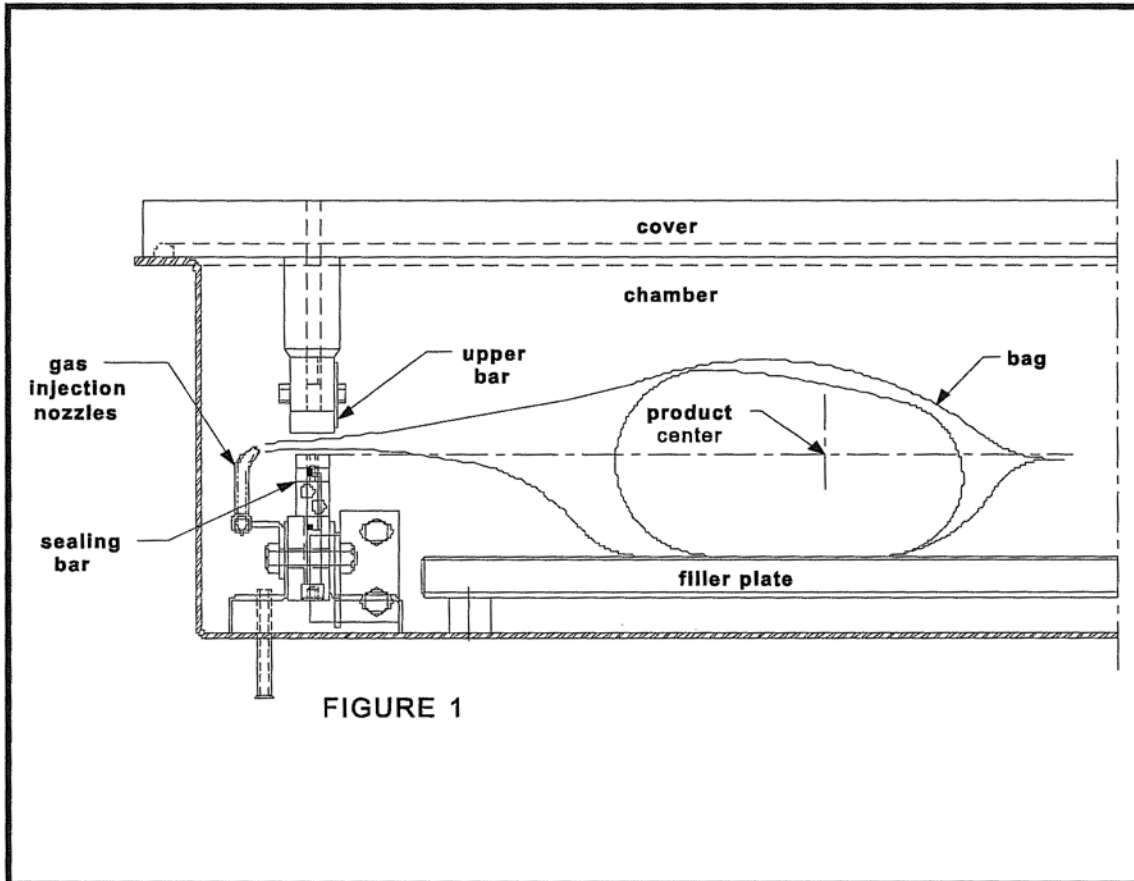
3.1 Working principles:

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:

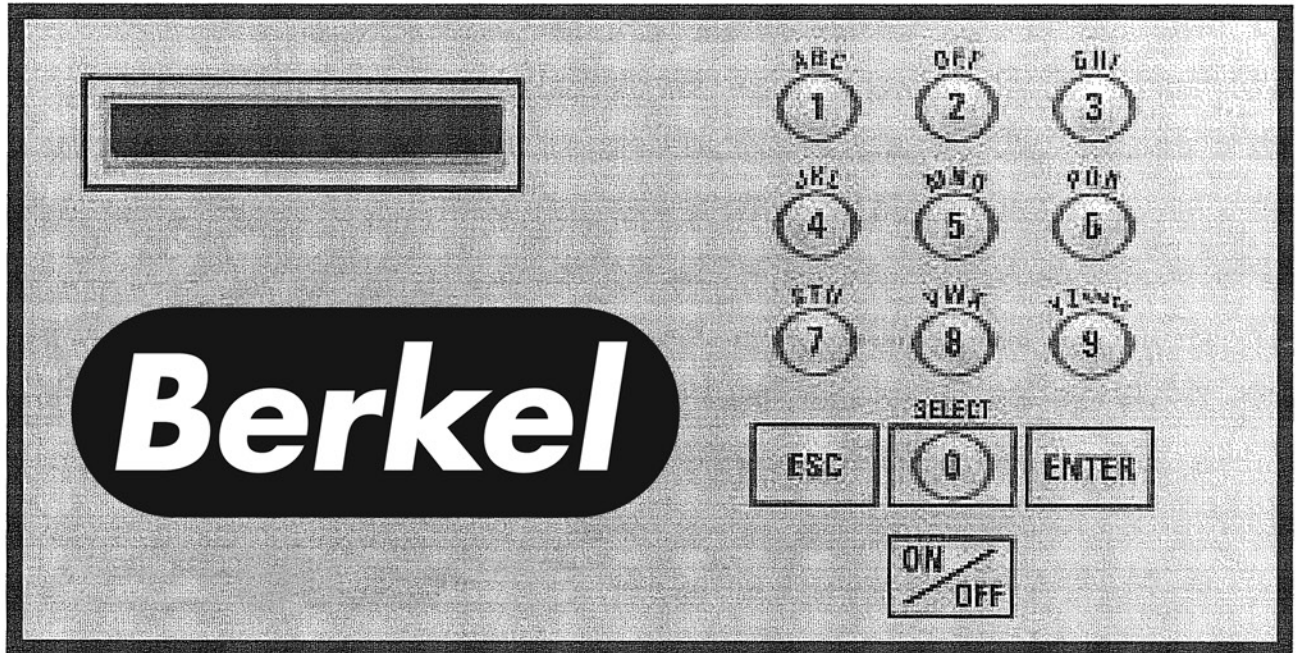
To accede the diagnostics menu, power up the vacuum packaging machine while keeping pushed in the "ESC"key. Use key "SELECT" to select the system monitor function and key "ENTER" to accede and visualize the monitored parameters. Use key "SELECT" to change over from the software revision, the amount of 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)
 - "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 "VACUUM ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the vacuum sequence within a preset period of time.

- Check vacuum lines for potential leaks or kinks.

4.1.2 "GAS FLUSH ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the gas flush sequence within a preset period of time.

- Check gas flush and vacuum lines for potential leaks or kinks.

4.1.3 "ATMOSPHERE ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the atmosphere sequence within a preset period of time.

- Check vacuum lines for potential leaks or kinks.

4.1.4 "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 level is too low:

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.

Caution: 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).

Caution: 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 connection or evident damage to the main components: 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.

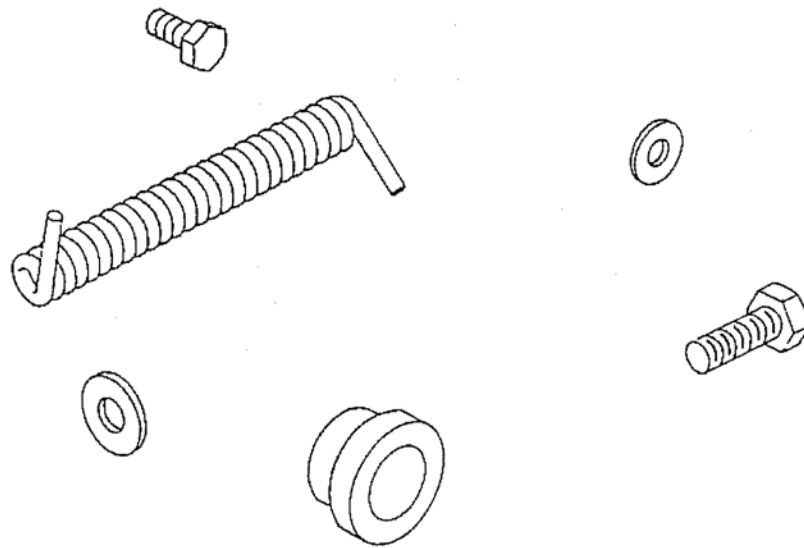
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

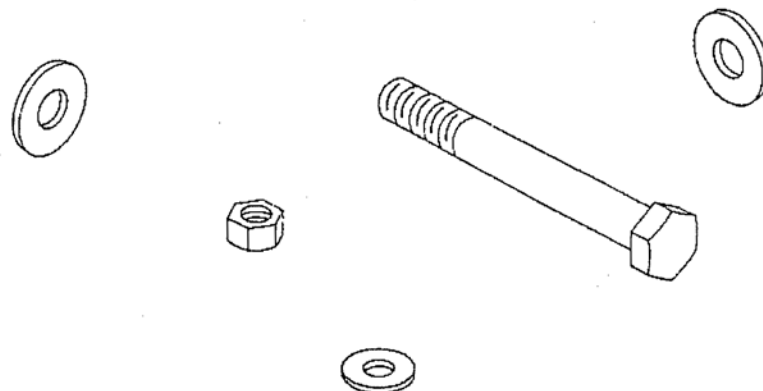
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.



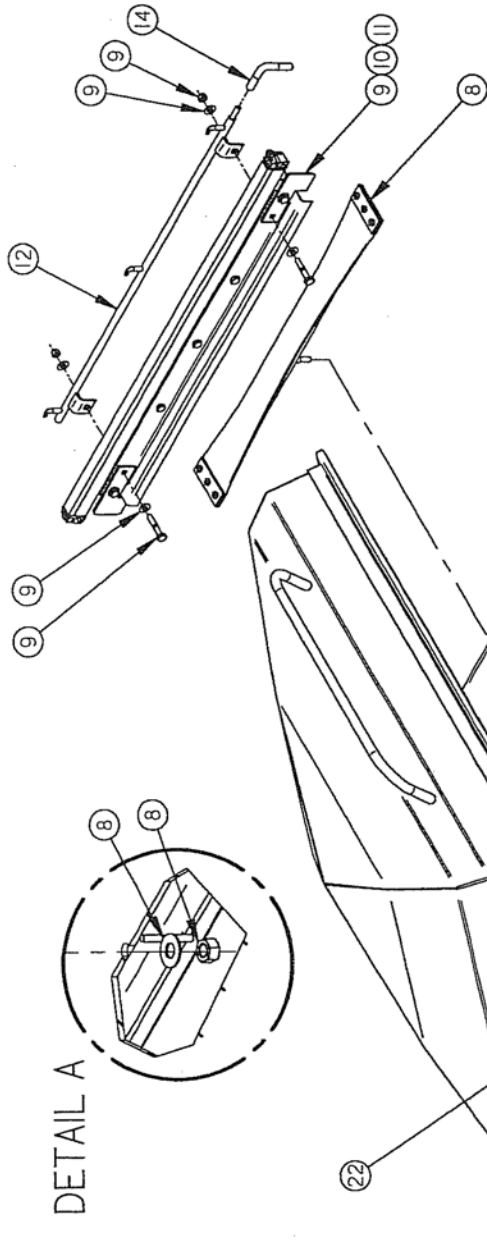
MECHANICAL DRAWING



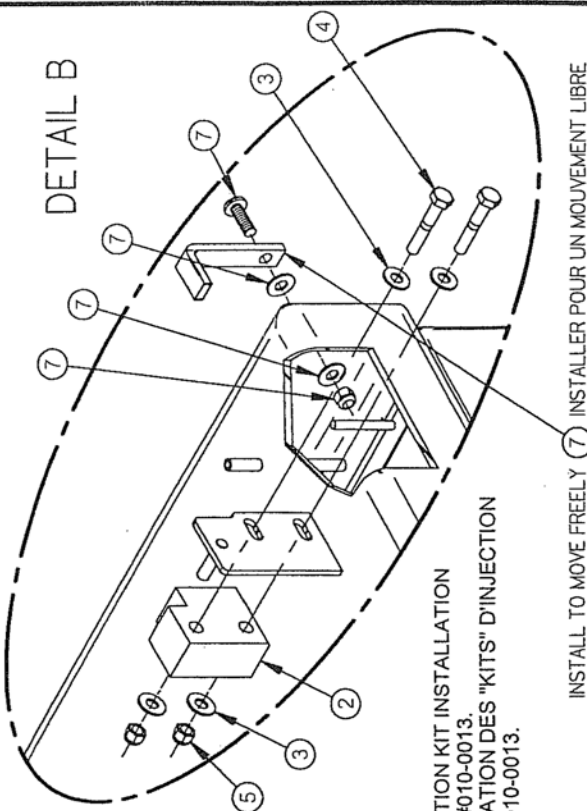
005A0605

ITEM	PART #	DESCRIPTION	QT.
1	005A0608	MC-40 REAR VIEW	1
2	002-0326	LEFT SEAL BAR GUIDE BLOCK	2
3	051-0740	WASHER 1/4" FLAT S/S	20
4	051-0250	BOLT 1/2"-20nc. X 1 1/2" S/S	8
5	051-0581	NUT 1/4"-20 NYLON LOCK S/S	8
6	002-0327	RIGHT SEAL BAR GUIDE BLOCK	2
7	004A1651	COVER HOLD DOWN PRE-ASSY	1
8	005-0320	BELLOWS ASSEMBLY	2
9	005A0568	SEAL BAR ASSY W/SUPPORT	2
10	005A0570	SEAL BAR ASSY W/SUPPORT	2
11	005A0569	SEAL BAR ASSY W/SUPPORT	2
12	005A0810	GAS 3 INJECTION BAR ASSEMBLY	1
13	005-0571	GAS 3 INJECTION BAR ASSEMBLY	1
14	008-0464	GAS INJECTION CONN. TUBE	2
15	005A0583	FRONT MC-40 SUPPORT ASSY	1
16	057-0089	1/4" x 5/8" O.D. EPDM RUB. SEAL, WASHER	4
17	051-0591	NUT 1/4"-20 ACORN S/S	4
18	130-4PHO	4" SWIVEL CASTER W/O BRAKES	2
19	051-0760	WASHER 5/16" FLAT S/S	16
20	052-0520	BOLT 5/16"-18nc. X 3/4" ZINC	16
21	130-4PHB	4" SWIVEL CASTER W/BRAKE	2
22	005A0340	FILLER PLATE ASSEMBLY	2

DETAIL A



DETAIL B



NOTE:

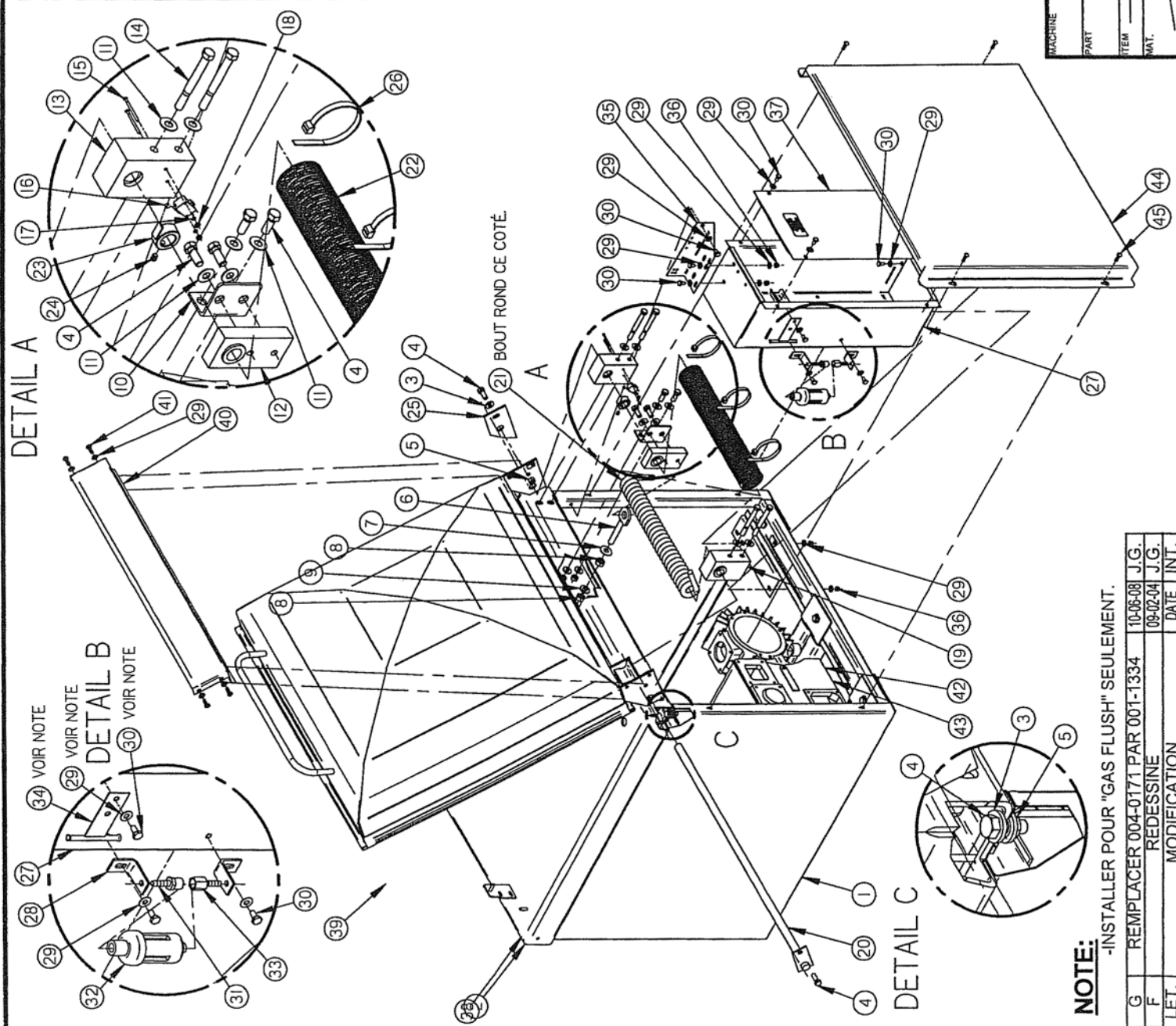
-FOR GAS INJECTION KIT INSTALLATION
SEE DRAWING #010-0013.
-POUR L'INSTALLATION DES "KITS" D'INJECTION
VOIR DESSIN #010-0013.

INSTALL TO MOVE FREELY 7 INSTALLER POUR UN MOUVEMENT LIBRE

MACHINE		550A		DEPT. TO: METRIC INCH		USINAGE		± 0.1		± 0.004		TOLERANCE		± 0.1		± 0.004		SOLDEAGE		S.S.		N.T.S.		DEPT.		M-1		QTY.		1	
PART		MC-40 FRONT VIEW		CNC		DATE		09-01-26		NO		005A0605		ST-GERMAIN DE GRANTHAM		QUEBEC CANADA		SIPROMAC													
ITEM				CNC		DATE		09-01-26		NO		005A0605		ST-GERMAIN DE GRANTHAM		QUEBEC CANADA		SIPROMAC													
MAT.				CNC		DATE		09-01-26		NO		005A0605		ST-GERMAIN DE GRANTHAM		QUEBEC CANADA		SIPROMAC													

E		REDESSINE		09-02-04		J.G.	
LET.		MODIFICATION		DATE		INT.	

005A0608



ITEM	PART #	DESCRIPTION	QT
1	005B0606	MC-40 STRUCTURE ASSEMBLY	1
2	005A0341	TABLE ASSEMBLY	1
3	051-0783	WASHER 3/8" FLAT THICK S/S	15
4	051-0360	BOLT 3/8"-16nc. X 1" S/S	10
5	051-0620	NUT 3/8"-16 NC S/S	12
6	005-0346	SPRING TENSION SUPPORT PRE-ASSY	1
7	051-0790	WASHER 1/2" FLAT S/S	1
8	051-0630	NUT 1/2"-13 S/S	2
9	051-0792	WASHER 1/2" FLAT THICK S/S	1
10	001-1540	CENTRAL COVER AXIS SUPPORT FIXATION	1
11	051-0780	WASHER 3/8" FLAT S/S	8
12	004-0276	CENTRAL COVR AXIS SUPPORT	1
13	004-0274	LEFT COVER AXIS SUPPORT	1
14	051-0424	BOLT 3/8"-16 x 3-1/2" SS	4
15	051-0094	SCREW 4-40 X 1 1/2" FLAT SLOT SS	2
16	028-0610	LIMIT SWITCH LONG ROLLER	1
17	051-0715	WASHER #4 LOCK SS	2
18	051-0540	NUT #4-40 HEX S/S	2
19	004-0275	RIGHT COVER AXIS SUPPORT	1
20	004-0129	COVER AXIS PRE-ASSY	1
21	008-0322	COVER SPRING	1
22	038-0350	SLIT CORRUG. LOOM 2" ID x 370mm (1.27')	1
23	005-0348	MICRO SWITCH COLLAR ASSY	1
24	051-0178	SCREW 1/4"-20 x 5/16" SKT SET S/S	1
25	001-1335	COVER STOPPER	1
26	057-0330	CABLE TIES 14" LONG BLACK	3
27	005-0347	ELECTRICAL BOX PRE-ASSY	1
28	001-2062	DRYER SUPPORT	2
29	051-0740	WASHER 1/4" FLAT S/S	20
30	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	12
31	101-0200	STRAIGHT 1/4" MNPT x 1/4" HOSE BARB	1
32	114-2020	FILTER / DRYER 1/4" MNPT. X 3/8" Lp. COMP.	1
33	101-0210	STRAIGHT 1/4" FNPT x 1/4" HOSE BARB	1
34	005-0323	INLET ASSEMBLY	1
35	001A2810	UPPER ELECTRICAL BOX SUPPORT	1
36	051-0581	NUT 1/4"-20 NYLON LOCK S/S	5
37	004-0273	ELECTRICAL BOX COVER ASSEMBLY	1
38	005A0461	8" COVER ASSEMBLY	1
39	005A0462	12" COVER ASSEMBLY	1
40	001-1334	SPRING COVER	1
41	051-0192	SCREW 1/4-20NC X 3/4" PAN PHILL S/S	4
42	010A0062	PUMP INSTALLATION 63M3	1
43	010A0063	PUMP INSTALLATION 100M3	1
44	004A2834	REAR PANEL PRE-ASSY	1
45	052-0420	SCREW 1/4"-20 NC x 3/4" PAN SLOT BRASS	4

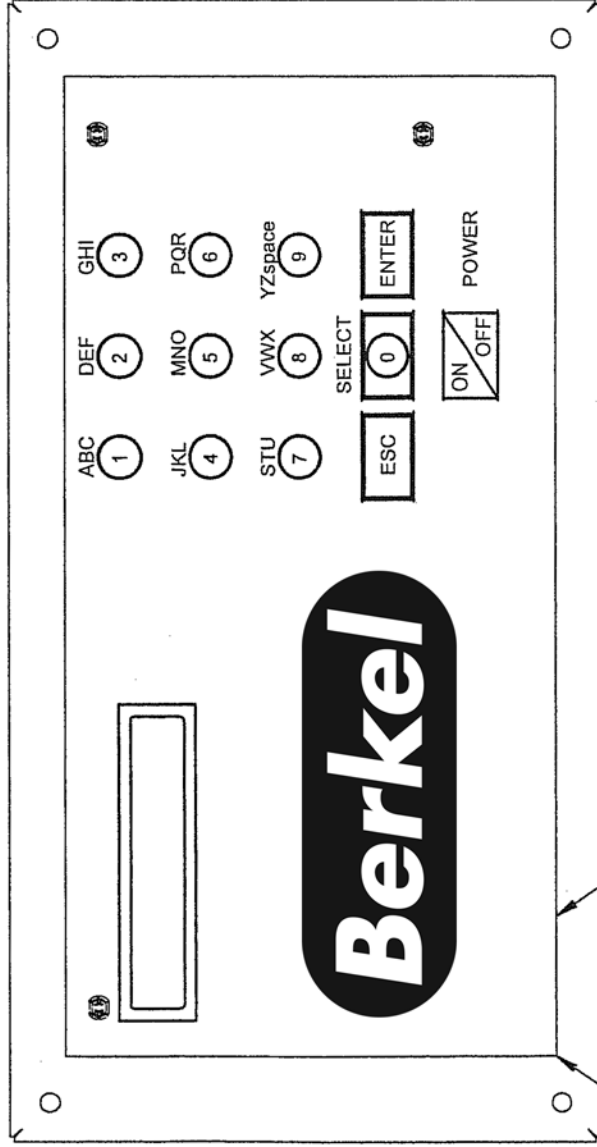
MACHINE		550A		SIPROMAC	
PART		MC-40 REAR VIEW		ST-GERMAN DE GRANTHAM QUEBEC CANADA	
ITEM	QTY	DATE	09-02-04	NO	005A0608
MAT.		APP. BY	J.G.	DATE	10-06-08
CNC		M-i		J.G.	
DATE		09-02-04		DATE	
APP. BY		J.G.		DATE	
MODIFICATION				DATE	

NOTE:
-INSTALLER POUR "GAS FLUSH" SEULEMENT.

G	REPLACER 004-071 PAR 001-1334	10-06-08	J.G.
F	REDESSINE	09-02-04	J.G.
LET.			

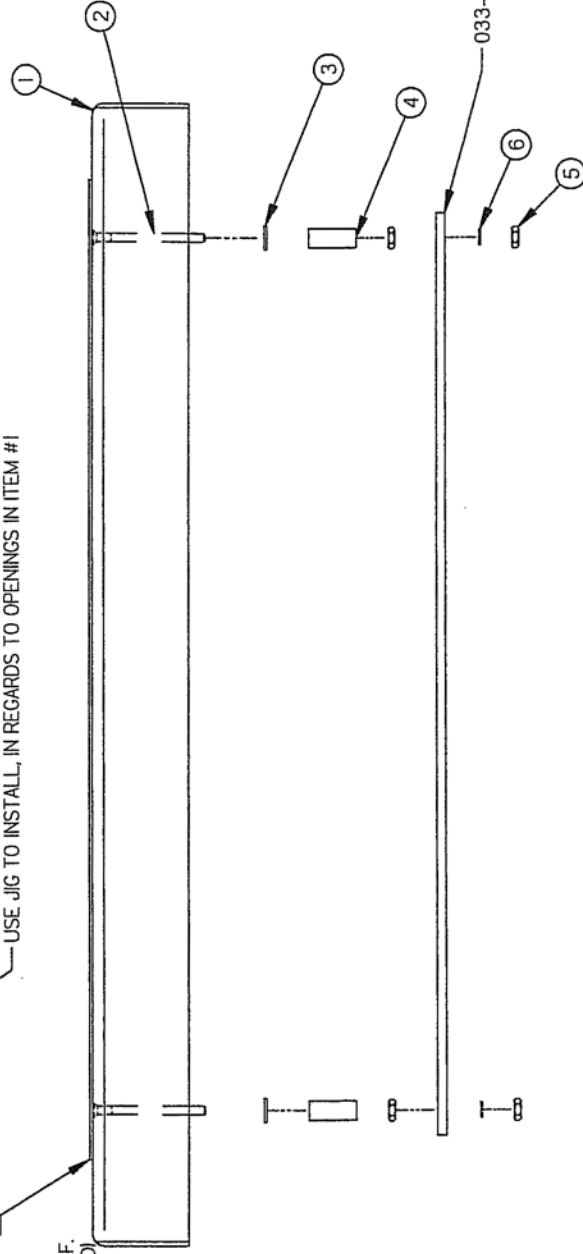
1005A0583

ITEM	PART #	DESCRIPTION	QTY
1	004A0425	FRONT MC-40 SUPPORT PRE-ASSY	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



USE JIG TO INSTALL, IN REGARDS TO OPENINGS IN ITEM #1

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



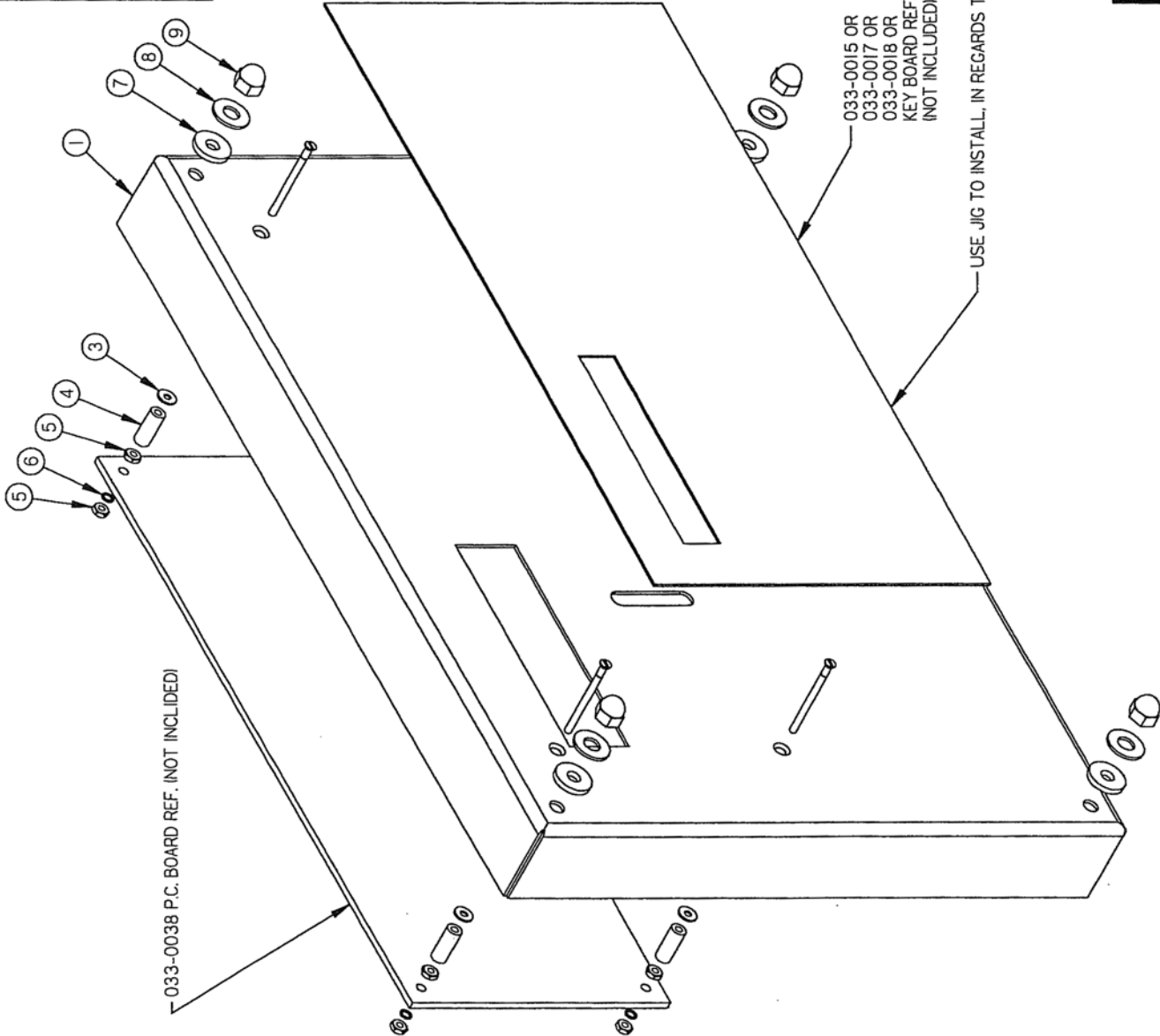
033-0038 P.C. BOARD REF. (NOT INCLUDED)

H	AJOUTER 500D	08-04-17	J.G.
G	REDRAWN	05-09-01	M.A.
LET.	MODIFICATION	DATE	INT.

MACHINE	420A, 450A, 450T, 500A, 500D, 550A, 580A, 600A, 620A & 650A	DEPT. TOL.	METRIC	INCH
USINAGE	± 0.004"	10.1	± 0.004"	
COUPE	± 0.004"	10.1	± 0.004"	
SCUDAGE	± 0.004"	10.1	± 0.004"	
PART	FRONT MC-40 SUPPORT ASSY	N.T.S.		
ITEM		CHC		
DWG BY	MAL	DATE	05-09-01	NO
APP. BY		DATE	08-04-17	
ITEM		QTY	1	
SIPROMAC				
ST-GERMAIN DE GRANBY/QUEBEC CANADA				
005A0583				

005A0779

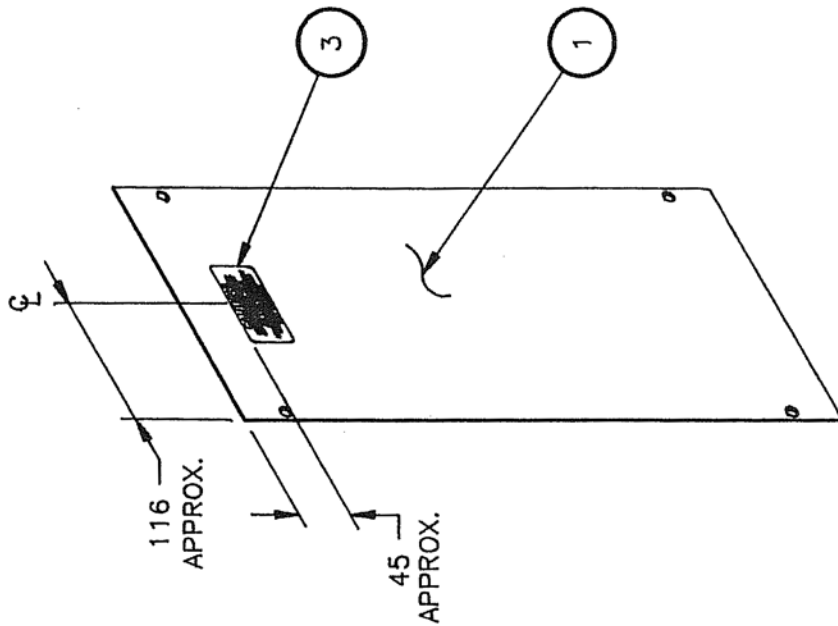
ITEM	PART #	DESCRIPTION	QT.
1	004A3166	FRONT MC-40 SUPPORT PRE-ASSY(OPT. HEATER)	1
2	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	8
6	051-0715	WASHER #4 LOCK SS	4
7	057-0089	1/4" x 5/8" O.D. EPDM RUB. SEAL, WASHER	4
8	051-0740	WASHER 1/4" FLAT S/S	4
9	051-0591	NUT 1/4"-20 ACORN S/S	4



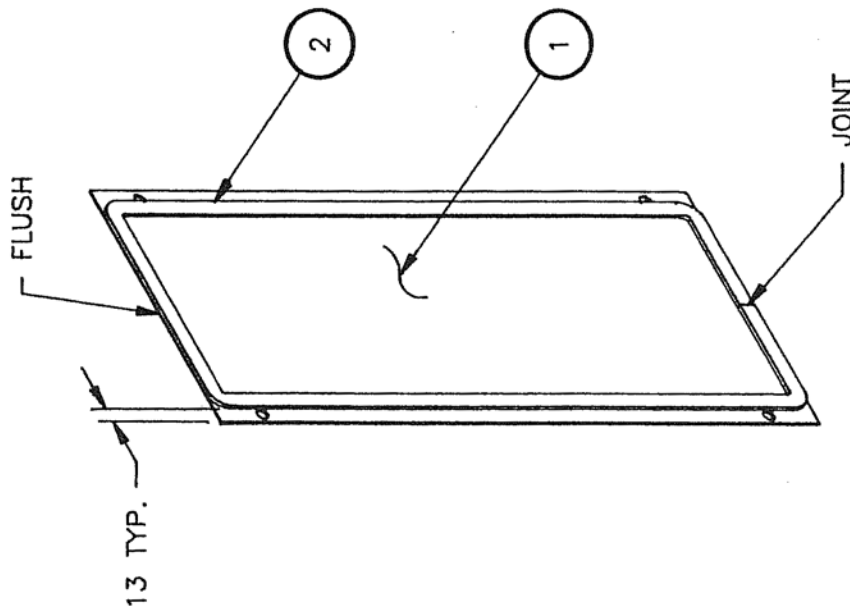
MACHINE	420A, 450A, 550A, 580A, 600A, 620A & 650A	DEPT. TOL. METRIC INCH	USINAGE ± 0.1 ± 0.004" TOLERIE ± 0.5 ± 0.020" SOUDAGE ± 0.5 ± 0.020"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	FRONT MC-40 SUPPORT ASSY(OPT. HEATER)	ITEM	DATE 10-02-03	NO. 005A0779
ITEM		DATE	DATE 10-02-03	NO. 005A0779
DATE		DATE	DATE 10-02-03	NO. 005A0779
DATE		DATE	DATE 10-02-03	NO. 005A0779

004-0273

ITEM	PART #	DESCRIPTION	QT.
1	001-1341	ELECTRICAL BOX COVER	1
2	179-0004	NEOPRENE SPONGE 1/8" X 1/2" ADHESIVE	1
3	127-0100	"CAUTION" YELLOW STICKER	1



-FRONT VIEW-

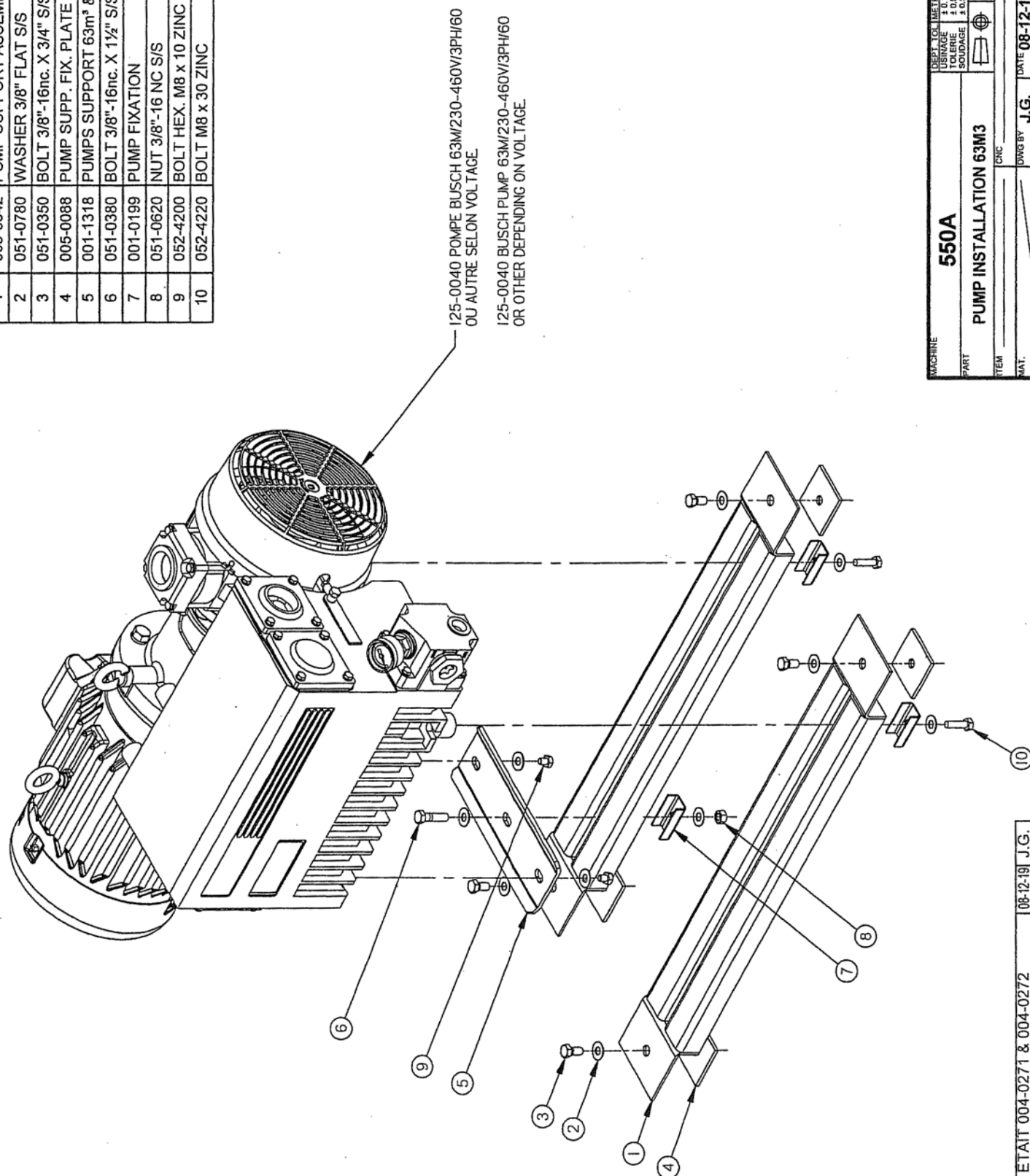




-REAR VIEW-

MACHINE 450A & 550A		SIPROMAC	
PART E-BOX COVER PRE-ASS'Y		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	CNC	INCH TOLERANCE 0.0 ± .015 0.0 ± .005 0.000 ± .0005 N.T.S.	SCALE 1
MAT:	DATE 97-01-08	NO. 004-0273	
MODIFICATION	DATE	INT.	
LET.			

1010A0062

ITEM	PART #	DESCRIPTION	QT.
1	005-0342	PUMP SUPPORT ASSEMBLY	2
2	051-0780	WASHER 3/8" FLAT S/S	10
3	051-0350	BOLT 3/8"-16nc. X 3/4" S/S	4
4	005-0088	PUMP SUPP. FIX. PLATE ASS'Y	4
5	001-1318	PUMPS SUPPORT 63m ³ & 100m ³	1
6	051-0380	BOLT 3/8"-16nc. X 1 1/2" S/S	1
7	001-0199	PUMP FIXATION	3
8	051-0620	NUT 3/8"-16 NC S/S	1
9	052-4200	BOLT HEX. M8 x 10 ZINC	2
10	052-4220	BOLT M8 x 30 ZINC	2

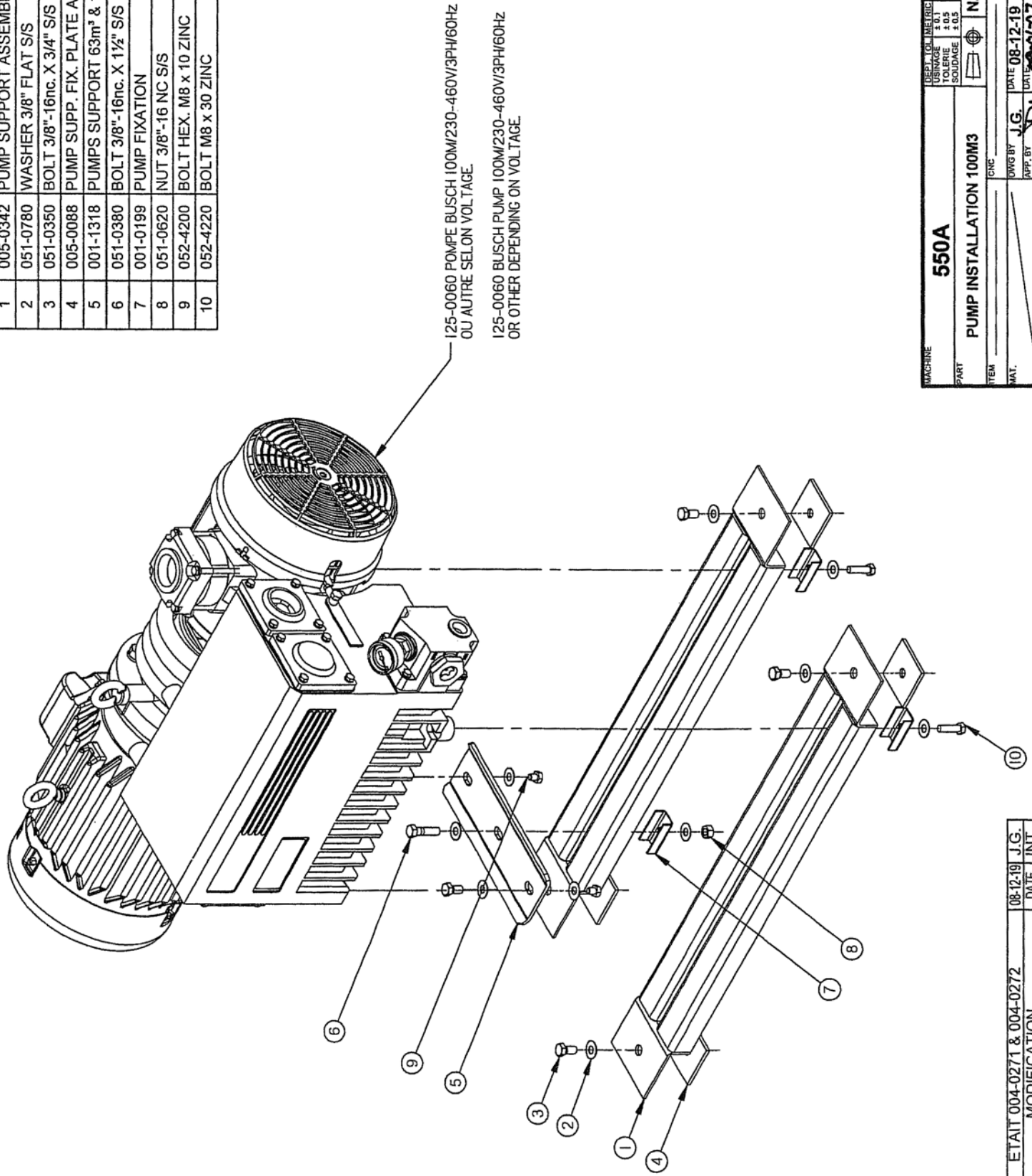



MACHINE	550A	DEPT. FOR METRIC INFO	SIPROMAC
		WEIGHT ± 0.5	ST-GERMAIN DE GRANTHAM
		LENGTH ± 0.020"	QUEBEC CANADA
PART		TOLERANCE ± 0.5	
		SOUDEAGE ± 0.5	
			N.T.S.
	PUMP INSTALLATION 63M3		
ITEM		CNC	DEPT. M-1
			QTY. 1
DATE			
DRG. BY J.G.	DATE 08-12-79		
APP. BY 	DATE 09-01-79		
			010A0062

A	ETAIT 004-0271 & 004-0272	08-12-19	J.G.
LET.	MODIFICATION	DATE	INT.

| 010A0063

ITEM	PART #	DESCRIPTION	QT
1	005-0342	PUMP SUPPORT ASSEMBLY	2
2	051-0780	WASHER 3/8" FLAT S/S	10
3	051-0350	BOLT 3/8"-16nc. X 3/4" S/S	4
4	005-0088	PUMP SUPP. FIX. PLATE ASS'Y	4
5	001-1318	PUMPS SUPPORT 63m ³ & 100m ³	1
6	051-0380	BOLT 3/8"-16nc. X 1 1/2" S/S	1
7	001-0199	PUMP FIXATION	3
8	051-0620	NUT 3/8"-16 NC S/S	1
9	052-4200	BOLT HEX. M8 x 10 ZINC	2
10	052-4220	BOLT M8 x 30 ZINC	2

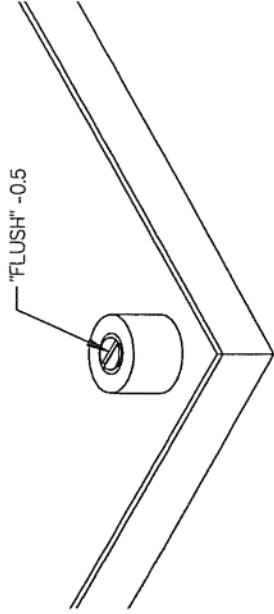
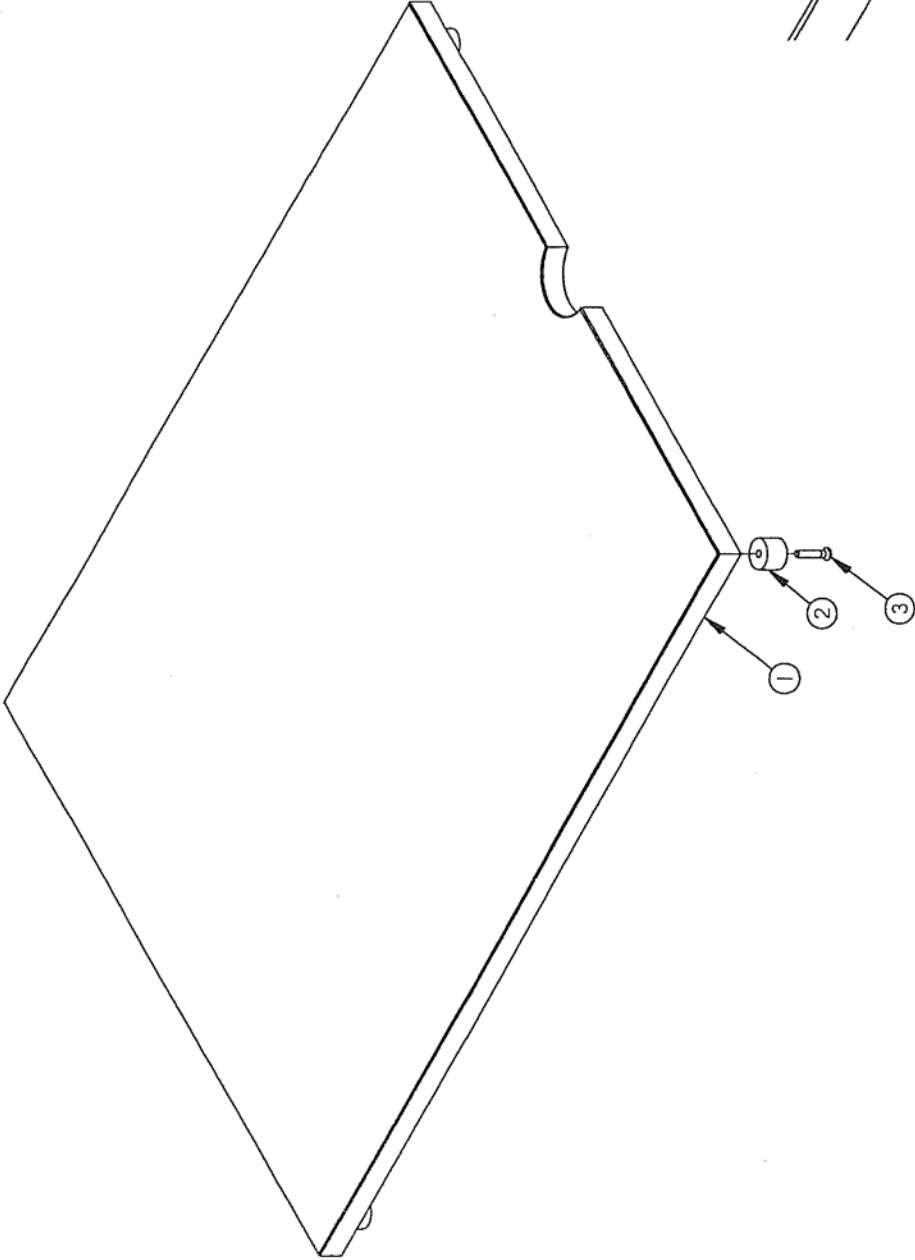


MACHINE		550A		DESPT. VOL. (M3) (GRI) INCH USAGE (M3) ± 0.004 TOLERIE ± 0.5 SQUADINE ± 0.5		SIPROMAC	
PART		PUMP INSTALLATION 100M3				ST-GERMAIN DE GRANTHAM QUÉBEC CANADA	
ITEM		CHG		DESPT.		QTY. 1	
MAT.		OWG BY J.G.		DATE 08-12-19		NO.	
		APP. BY		DATE 22-01-07		010A0063	

A	ETAIT 004-0271 & 004-0272	08-12-19	J.G.
LET.	MODIFICATION	DATE	INT.

1005A0340

ITEM	PART #	DESCRIPTION	QT.
1	008A0323	FILLER PLATE	1
2	003-0080	FILLER PLATE FOOT	4
3	054-0004	METAL SCREW #10 x 1" FLAT SLOT S/S	4

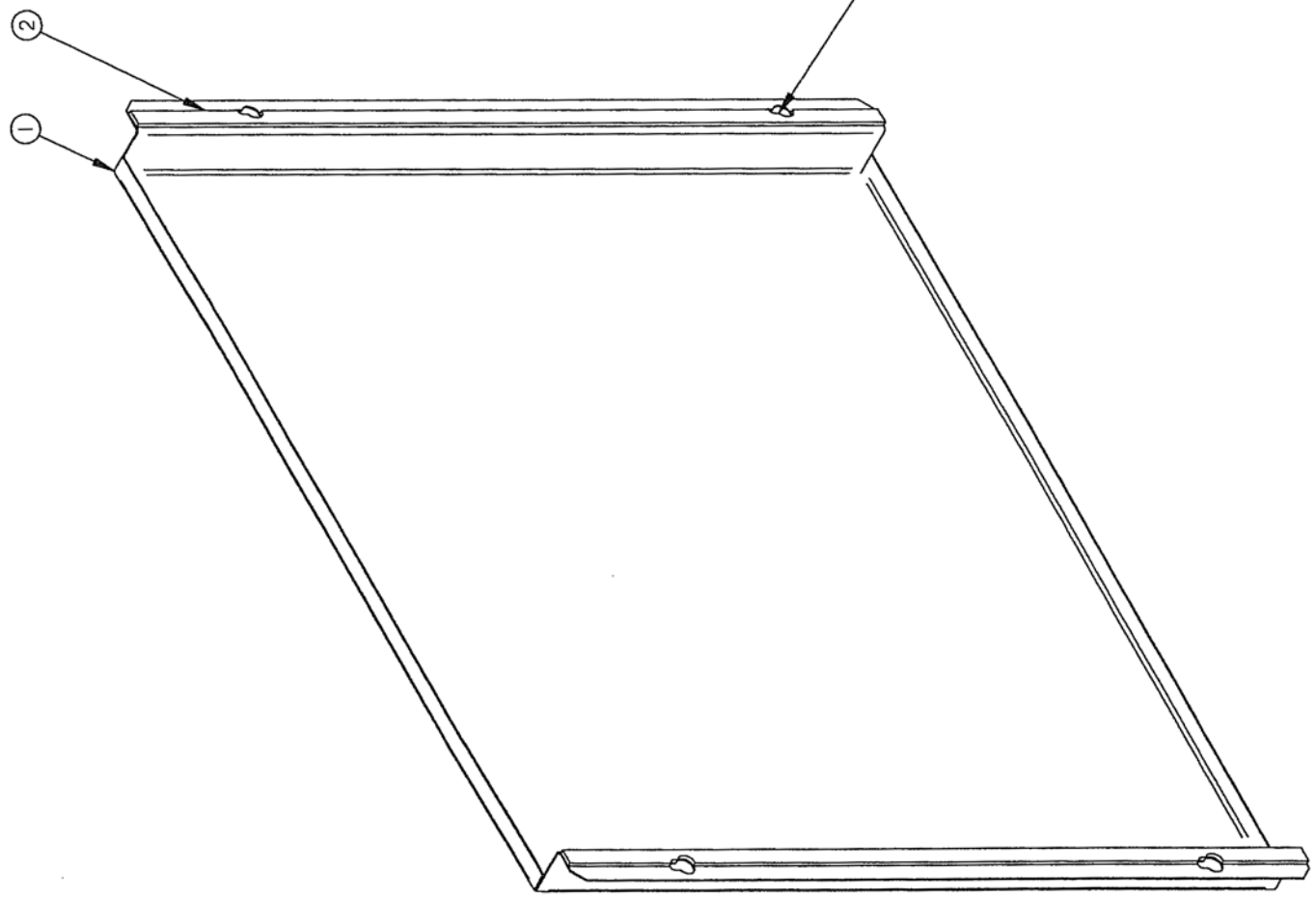


MACHINE		550A		DEPT. 101		METRIC		INCH		SIPROMAC	
PART		FILLER PLATE ASSEMBLY		TOLERANCE		± 0.1		± 0.007		ST-GERMAIN DE GRANTHAM	
ITEM		GNC		TOLERANCE		± 0.5		± 0.027		QUEBEC CANADA	
DATE		09-02-04		DATE		09-02-04		DATE		09-02-10	
BY		J.G.		BY		J.G.		BY		J.G.	
MAT.				QTY.		2		QTY.		2	
										005A0340	

B	REDESSINE MODIF #A-0445	09-02-04	J.G.
LET.	MODIFICATION	DATE	INT.

004A2834

ITEM	PART #	DESCRIPTION	QT.
1	001A4934	REAR PANEL	1
2	179-0004	NITRILE PVC 1/8" x 1/2"	2

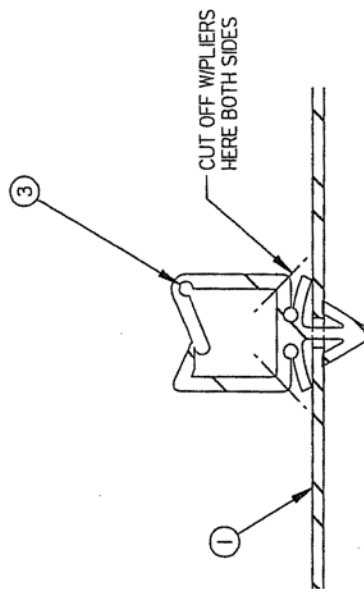
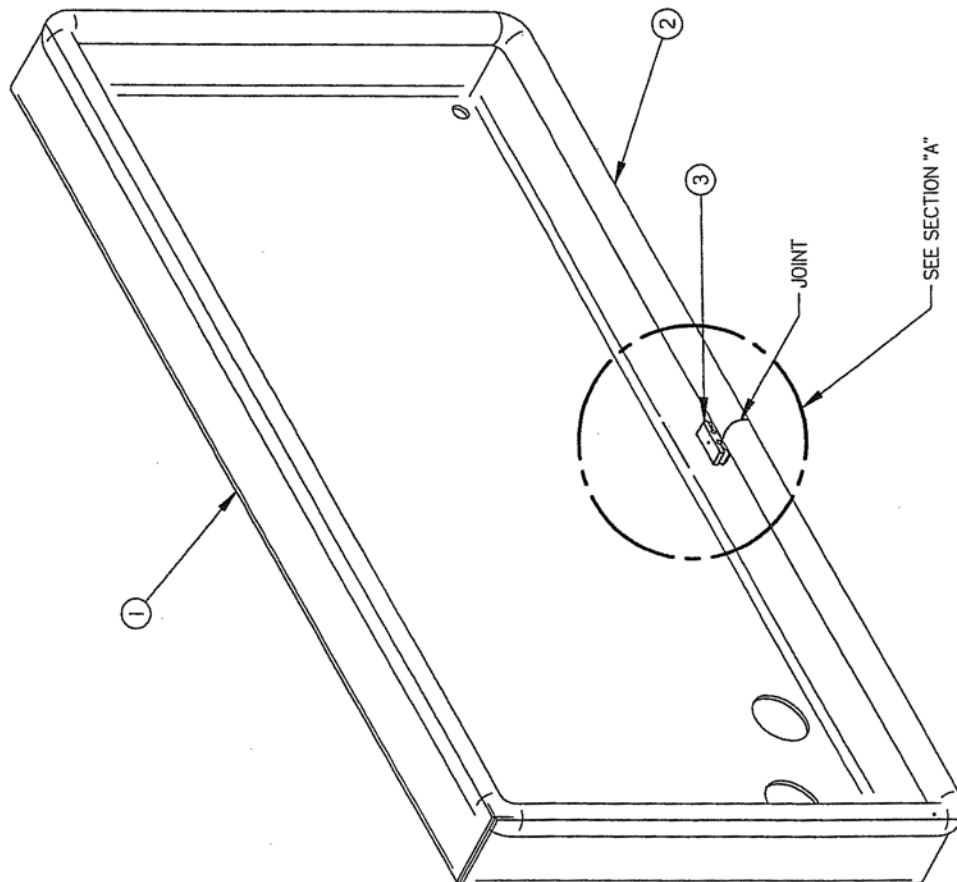


MACHINE	550A	DEPT. 101	METRIC	INCH	USINAGE	± 0.1	± 0.004"
PART	REAR PANEL PRE-ASSY	TOLERIE	± 0.5	± 0.020"	SOLDAGE	± 0.3	± 0.020"
ITEM		CNC			N.T.S.		
DATE	08-12-19	NO	004A2834	DEPT.	M	QTY.	1
DWG BY	J.G.	APP. BY					

FT	MODIFICATION	DATE	INT.
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005A0584

ITEM	PART #	DESCRIPTION	QT.
1	004A0426	REAR MC-40 SUPPORT PRE-ASS'Y	1
2	179-0019	U-CHANNEL BLACK EPDM FOAM (3.9)	1
3	057-0002	CABLE CLAMPS 9mm (11,2 X 9,3)	1



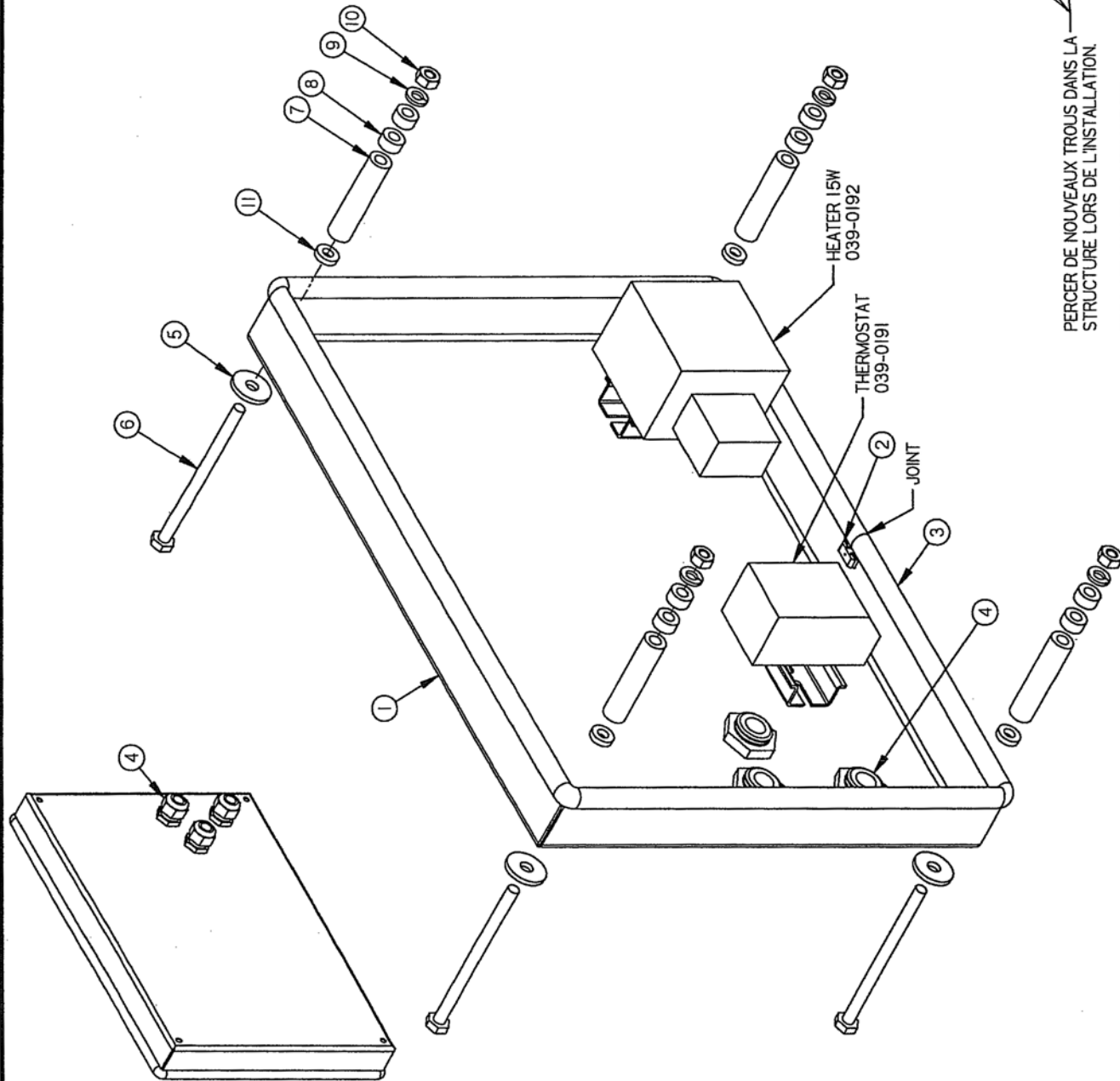
SECTION A

F	REDRAWN	05/09/01	M.A.
LET.	MODIFICATION	DATE	INT.

MACHINE	420A, 450A, 450A, 550A, 570A, 580A, 600A, 620A & 650A	DEPT. 101	METRIC	INCH	1/16	1/8	1/4	3/8	1/2	3/4	1	1 1/4	1 1/2	1 3/4	2	2 1/4	2 1/2	2 3/4	3	3 1/4	3 1/2	3 3/4	4	4 1/4	4 1/2	4 3/4	5	5 1/4	5 1/2	5 3/4	6	6 1/4	6 1/2	6 3/4	7	7 1/4	7 1/2	7 3/4	8	8 1/4	8 1/2	8 3/4	9	9 1/4	9 1/2	9 3/4	10	10 1/4	10 1/2	10 3/4	11	11 1/4	11 1/2	11 3/4	12	12 1/4	12 1/2	12 3/4	13	13 1/4	13 1/2	13 3/4	14	14 1/4	14 1/2	14 3/4	15	15 1/4	15 1/2	15 3/4	16	16 1/4	16 1/2	16 3/4	17	17 1/4	17 1/2	17 3/4	18	18 1/4	18 1/2	18 3/4	19	19 1/4	19 1/2	19 3/4	20	20 1/4	20 1/2	20 3/4	21	21 1/4	21 1/2	21 3/4	22	22 1/4	22 1/2	22 3/4	23	23 1/4	23 1/2	23 3/4	24	24 1/4	24 1/2	24 3/4	25	25 1/4	25 1/2	25 3/4	26	26 1/4	26 1/2	26 3/4	27	27 1/4	27 1/2	27 3/4	28	28 1/4	28 1/2	28 3/4	29	29 1/4	29 1/2	29 3/4	30	30 1/4	30 1/2	30 3/4	31	31 1/4	31 1/2	31 3/4	32	32 1/4	32 1/2	32 3/4	33	33 1/4	33 1/2	33 3/4	34	34 1/4	34 1/2	34 3/4	35	35 1/4	35 1/2	35 3/4	36	36 1/4	36 1/2	36 3/4	37	37 1/4	37 1/2	37 3/4	38	38 1/4	38 1/2	38 3/4	39	39 1/4	39 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1/4	81 1/2	81 3/4	82	82 1/4	82 1/2	82 3/4	83	83 1/4	83 1/2	83 3/4	84	84 1/4	84 1/2	84 3/4	85	85 1/4	85 1/2	85 3/4	86	86 1/4	86 1/2	86 3/4	87	87 1/4	87 1/2	87 3/4	88	88 1/4	88 1/2	88 3/4	89	89 1/4	89 1/2	89 3/4	90	90 1/4	90 1/2	90 3/4	91	91 1/4	91 1/2	91 3/4	92	92 1/4	92 1/2	92 3/4	93	93 1/4	93 1/2	93 3/4	94	94 1/4	94 1/2	94 3/4	95	95 1/4	95 1/2	95 3/4	96	96 1/4	96 1/2	96 3/4	97	97 1/4	97 1/2	97 3/4	98	98 1/4	98 1/2	98 3/4	99	99 1/4	99 1/2	99 3/4	100	100 1/4	100 1/2	100 3/4	101	101 1/4	101 1/2	101 3/4	102	102 1/4	102 1/2	102 3/4	103	103 1/4	103 1/2	103 3/4	104	104 1/4	104 1/2	104 3/4	105	105 1/4	105 1/2	105 3/4	106	106 1/4	106 1/2	106 3/4	107	107 1/4	107 1/2	107 3/4	108	108 1/4	108 1/2	108 3/4	109	109 1/4	109 1/2	109 3/4	110	110 1/4	110 1/2	110 3/4	111	111 1/4	111 1/2	111 3/4	112	112 1/4	112 1/2	112 3/4	113	113 1/4	113 1/2	113 3/4	114	114 1/4	114 1/2	114 3/4	115	115 1/4	115 1/2	115 3/4	116	116 1/4	116 1/2	116 3/4	117	117 1/4	117 1/2	117 3/4	118	118 1/4	118 1/2	118 3/4	119	119 1/4	119 1/2	119 3/4	120	120 1/4	120 1/2	120 3/4	121	121 1/4	121 1/2	121 3/4	122	122 1/4	122 1/2	122 3/4	123	123 1/4	123 1/2	123 3/4	124	124 1/4	124 1/2	124 3/4	125	125 1/4	125 1/2	125 3/4	126	126 1/4	126 1/2	126 3/4	127	127 1/4	127 1/2	127 3/4	128	128 1/4	128 1/2	128 3/4	129	129 1/4	129 1/2	129 3/4	130	130 1/4	130 1/2	130 3/4	131	131 1/4	131 1/2	131 3/4	132	132 1/4	132 1/2	132 3/4	133	133 1/4	133 1/2	133 3/4	134	134 1/4	134 1/2	134 3/4	135	135 1/4	135 1/2	135 3/4	136	136 1/4	136 1/2	136 3/4	137	137 1/4	137 1/2	137 3/4	138	138 1/4	138 1/2	138 3/4	139	139 1/4	139 1/2	139 3/4	140	140 1/4	140 1/2	140 3/4	141	141 1/4	141 1/2	141 3/4	142	142 1/4	142 1/2	142 3/4	143	143 1/4	143 1/2	143 3/4	144	144 1/4	144 1/2	144 3/4	145	145 1/4	145 1/2	145 3/4	146	146 1/4	146 1/2	146 3/4	147	147 1/4	147 1/2	147 3/4	148	148 1/4	148 1/2	148 3/4	149	149 1/4	149 1/2	149 3/4	150	150 1/4	150 1/2	150 3/4	151	151 1/4	151 1/2	151 3/4	152	152 1/4	152 1/2	152 3/4	153	153 1/4	153 1/2	153 3/4	154	154 1/4	154 1/2	154 3/4	155	155 1/4	155 1/2	155 3/4	156	156 1/4	156 1/2	156 3/4	157	157 1/4	157 1/2	157 3/4	158	158 1/4	158 1/2	158 3/4	159	159 1/4	159 1/2	159 3/4	160	160 1/4	160 1/2	160 3/4	161	161 1/4	161 1/2	161 3/4	162	162 1/4	162 1/2	162 3/4	163	163 1/4	163 1/2	163 3/4	164	164 1/4	164 1/2	164 3/4	165	165 1/4	165 1/2	165 3/4	166	166 1/4	166 1/2	166 3/4	167	167 1/4	167 1/2	167 3/4	168	168 1/4	168 1/2	168 3/4	169	169 1/4	169 1/2	169 3/4	170	170 1/4	170 1/2	170 3/4	171	171 1/4	171 1/2	171 3/4	172	172 1/4	172 1/2	172 3/4	173	173 1/4	173 1/2	173 3/4	174	174 1/4	174 1/2	174 3/4	175	175 1/4	175 1/2	175 3/4	176	176 1/4	176 1/2	176 3/4	177	177 1/4	177 1/2	177 3/4	178	178 1/4	178 1/2	178 3/4	179	179 1/4	179 1/2	179 3/4	180	180 1/4	180 1/2	180 3/4	181	181 1/4	181 1/2	181 3/4	182	182 1/4	182 1/2	182 3/4	183	183 1/4	183 1/2	183 3/4	184	184 1/4	184 1/2	184 3/4	185	185 1/4	185 1/2	185 3/4	186	186 1/4	186 1/2	186 3/4	187	187 1/4	187 1/2	187 3/4	188	188 1/4	188 1/2	188 3/4	189	189 1/4	189 1/2	189 3/4	190	190 1/4	190 1/2	190 3/4	191	191 1/4	191 1/2	191 3/4	192	192 1/4	192 1/2	192 3/4	193	193 1/4	193 1/2	193 3/4	194	194 1/4	194 1/2	194 3/4	195	195 1/4	195 1/2	195 3/4	196	196 1/4	196 1/2	196 3/4	197	197 1/4	197 1/2	197 3/4	198	198 1/4	198 1/2	198 3/4	199	199 1/4	199 1/2	199 3/4	200	200 1/4	200 1/2	200 3/4	201	201 1/4	201 1/2	201 3/4	202	202 1/4	202 1/2	202 3/4	203	203 1/4	203 1/2	203 3/4	204	204 1/4	204 1/2	204 3/4	205	205 1/4	205 1/2	205 3/4	206	206 1/4	206 1/2	206 3/4	207	207 1/4	207 1/2	207 3/4	208	208 1/4	208 1/2	208 3/4	209	209 1/4	209 1/2	209 3/4	210	210 1/4	210 1/2	210 3/4	211	211 1/4	211 1/2	211 3/4	212	212 1/4	212 1/2	212 3/4	213	213 1/4	213 1/2	213 3/4	214	214 1/4	214 1/2	214 3/4	215	215 1/4	215 1/2	215 3/4	216	216 1/4	216 1/2	216 3/4	217	217 1/4	217 1/2	217 3/4	218	218 1/4	218 1/2	218 3/4	219	219 1/4	219 1/2	219 3/4	220	220 1/4	220 1/2	220 3/4	221	221 1/4	221 1/2	221 3/4	222	222 1/4	222 1/2	222 3/4	223	223 1/4	223 1/2	223 3/4	224	224 1/4	224 1/2	224 3/4	225	225 1/4	225 1/2	225 3/4	226	226 1/4	226 1/2	226 3/4	227	227 1/4	227 1/2	227 3/4	228	228 1/4	228 1/2	228 3/4	229	229 1/4	229 1/2	229 3/4	230	230 1/4	230 1/2	230 3/4	231	231 1/4	231 1/2	231 3/4	232	232 1/4	232 1/2	232 3/4	233	233 1/4	233 1/2	233 3/4	234	234 1/4	234 1/2	234 3/4	235	235 1/4	235 1/2	235 3/4	236	236 1/4	236 1/2	236 3/4	237	237 1/4	237 1/2	237 3/4	238	238 1/4	238 1/2	238 3/4	239	239 1/4	239 1/2	239 3/4	240	240 1/4	240 1/2	240 3/4	241	241 1/4	241 1/2	241 3/4	242	242 1/4	242 1/2	242 3/4	243	243 1/4	243 1/2	243 3/4	244	244 1/4	244 1/2	244 3/4	245	245 1/4	245 1/2	245 3/4	246	246 1/4	246 1/2	246 3/4	247	247 1/4	247 1/2	247 3/4	248	248 1/4	248 1/2	248 3/4	249	249 1/4	249 1/2	249 3/4	250	250 1/4	250 1/2	250 3/4	251	251 1/4	251 1/2	251 3/4	252	252 1/4	252 1/2	252 3/4	253	253 1/4	253 1/2	253 3/4	254	254 1/4	254 1/2	254 3/4	255	255 1/4	255 1/2	255 3/4	256	256 1/4	256 1/2	256 3/4	257	257 1/4	257 1/2	257 3/4	258	258 1/4	258 1/2	258 3/4	259	259 1/4	259 1/2	259 3/4	260	260 1/4	260 1/2	260 3/4	261	261 1/4	261 1/2	261 3/4	262	262 1/4	262 1/2	262 3/4	263	263 1/4	263 1/2	263 3/4	264	264 1/4	264 1/2	264 3/4	265	265 1/4	265 1/2	265 3/4	266	266 1/4	266 1/2	266 3/4	267	267 1/4	267 1/2	267 3/4	268	268 1/4	268 1/2	268 3/4	269	269 1/4	269 1/2	269 3/4	270	270 1/4	270 1/2	270 3/4	271	271 1/4	271 1/2	271 3/4	272	272 1/4	272 1/2	272 3/4	273	273 1/4	273 1/2	273 3/4	274	274 1/4	274 1/2	274 3/4	275	275 1/4
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1005A0780

ITEM	PART #	DESCRIPTION	QTY.
1	004A3167	REAR MC-40 SUPPORT PRE-ASS'Y	1
2	057-0002	CABLE CLAMPS 9mm (11,2 X 9,3)	1
3	179-0019	U-CHANNEL BLACK EPDM FOAM (4.5265)	1
4	036-0409	PRESSE-ETOIPE CD13	3
5	051-0757	WASHER 1/4" FLAT THICK S/S	4
6	051-02885	BOLT 1/4-20 X 3-3/4" HEX SS	4
7	058-0139	NYLON SPACER 1/4" ID X 1/2" OD X 2-1/8"	4
8	058-0025	NYLON SPACER 0.257" ID X 0.500" OD X 1/4"	8
9	051-0750	WASHER 1/4" LOCK S/S	4
10	051-0580	NUT 1/4"-20 S/S	4
11	058-0016	NYLON SPACER .252" ID X 1/2" OD X 1/8" THK	4



COUPER AVEC DES PINCES
ICI DES 2 CÔTÉS.
CUT OFF W/PLIERS
HERE BOTH SIDES.

UTILISER LES TROUS EXISTANTS DE LA
STRUCTURE LORS DE L'INSTALLATION.
USE EXISTING HOLES IN STRUCTURE
DURING INSTALLATION.

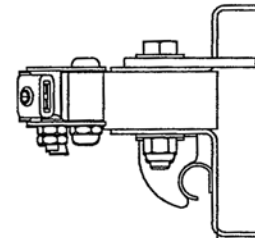
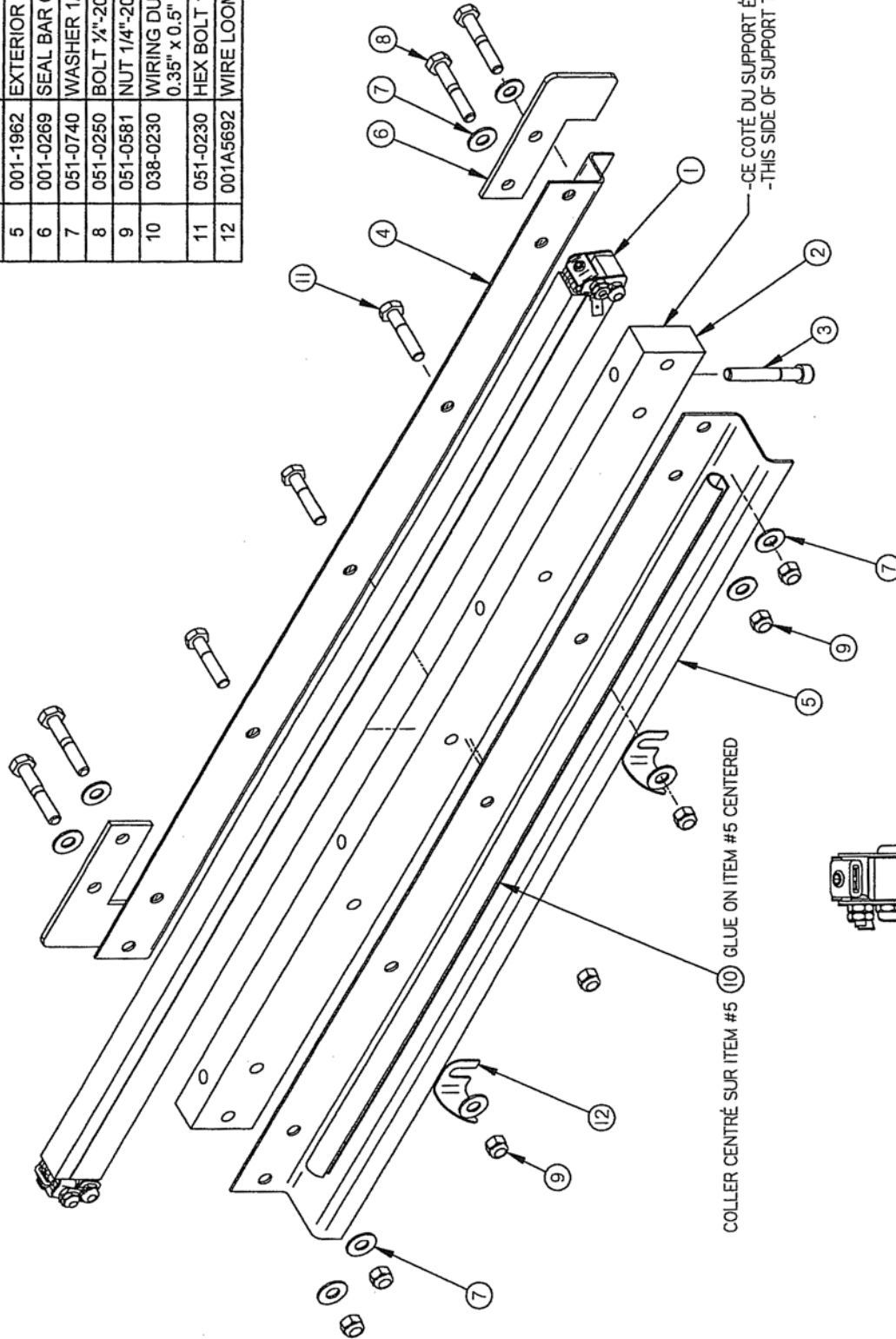
PERCER DE NOUVEAUX TROUS DANS LA
STRUCTURE LORS DE L'INSTALLATION.
DRILL NEW HOLES IN STRUCTURE
DURING INSTALLATION.

MACHINE 420A, 450A, 550A, 580A, 600A, 620A & 650A		DEPT. 101 METRIC INCH	USINAGE ± 0.1 ± 0.004	TOLERANCE ± 0.5 ± 0.020	SOUDAGE ± 0.5 ± 0.020
PART REAR MC-40 SUPPORT ASS'Y (OPT. HEATER)		N.T.S.		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM	QTY.	DATE	BY	APP.	DEPT.
1	1	10-02-03	M.D.		M-(M)-1
005A0780		10-02-01			

LET.	MODIFICATION	DATE	INT.
A	AJOUTER ITEM 058-0016 ET 058-0139 ETAT 058-0140	10-09-01	J.G.

005A0568

ITEM	PART #	DESCRIPTION	QTY.
1	005A0152	SEAL BAR PRE-ASS'Y	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOW COVER	1
5	001-1962	EXTERIOR BELLOW COVER	1
6	001-0269	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	7
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7)	1
11	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3
12	001A5692	WIRE LOOM SUPPORT #2	2



-END VIEW-

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

-TWIN SEAL OPTION -

550A & 600A

SEAL BAR ASS'Y W/SUPPORT

DEPT. 101	UNIT 101	INCH
USINAGE	± 0.1	± 0.004
TOLERIE	± 0.5	± 0.020
SOLDAGE	± 0.5	± 0.020

N.T.S.

600A	4
550A	2
MACHINE	QTY

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

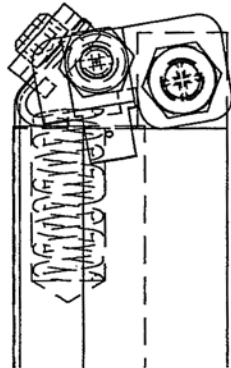
M-I (M) LISTE

005A0568

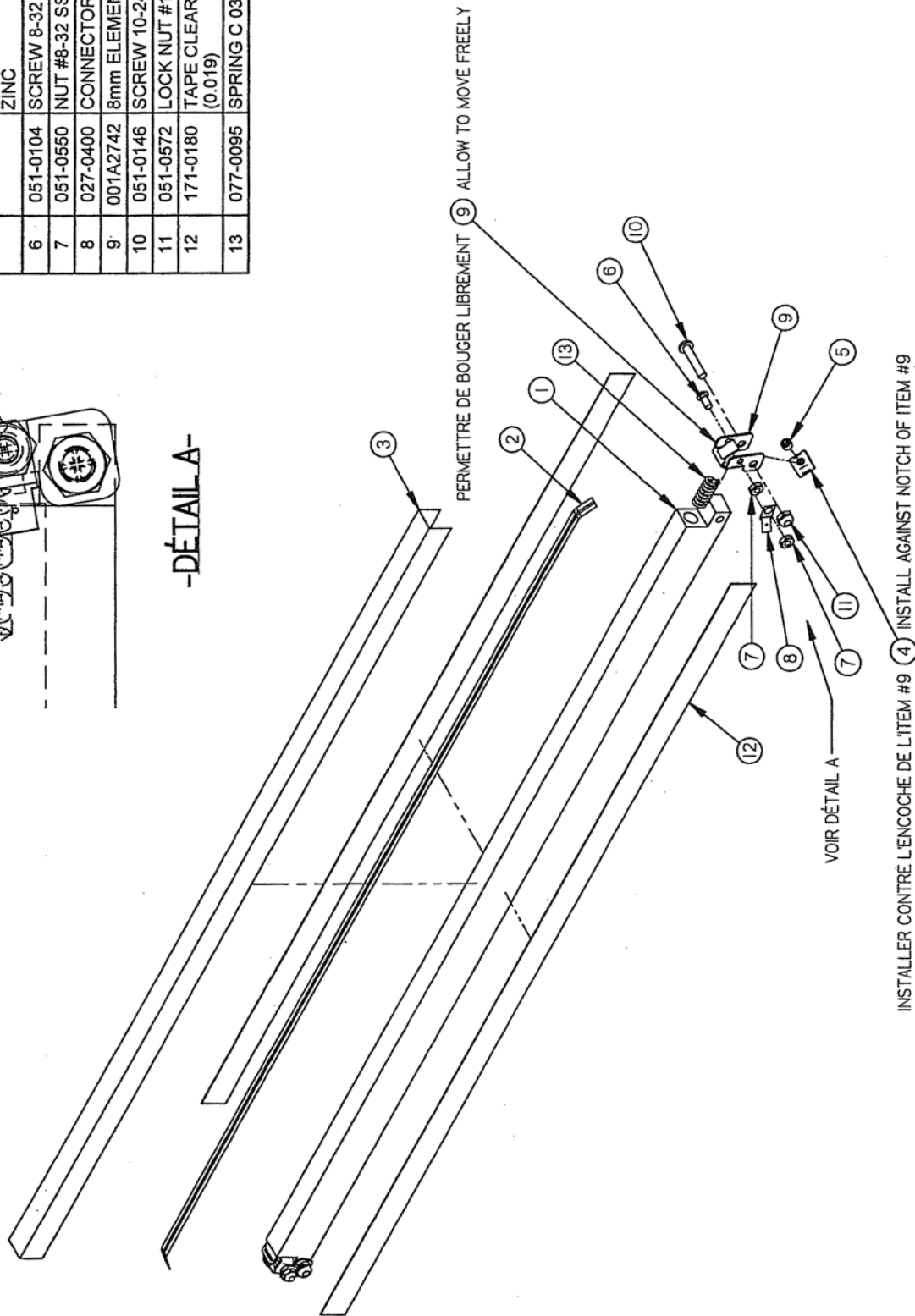
D	REDESSINE - AJOUTER 001A5692	11-08-30	J.G.
LET.	MODIFICATION	DATE	INT.

1005A0152

ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	039-0268	DOUBLE SEAM BAND (8MM) (2.3)	1
3	176-0200	TEFLON TAPE, 5MIL (0.78)	1
4	056-1401	3/8" SET SCREW BANDING BUCKLE S/S	2
5	052-0393	SCREW 1/4-28x3/16" SKT SET OVAL POINT ZINC	2
6	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
7	051-0550	NUT #8-32 SS	4
8	027-0400	CONNECTOR ADAPTOR	2
9	001A2742	8mm ELEMENT BINDER	2
10	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
11	051-0572	LOCK NUT #10-24 S/S	2
12	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2
13	077-0095	SPRING C 0360-059-1250 S/S	2



-DÉTAIL A-



INSTALLER CONTRE L'ENCOCHE DE L'ITEM #9 (4) INSTALL AGAINST NOTCH OF ITEM #9

-TWIN SEAL OPTION-

MACHINE	550A & 600A	DEPT. TOL. METRIC INCH	± 0.1 ± 0.004 ± 0.004 ± 0.002
PART	SEAL BAR PRE-ASS'Y	USINAGE	± 0.1 ± 0.004 ± 0.004 ± 0.002
ITEM		SOUDEAGE	± 0.5 ± 0.027
MAT.		N.T.S.	
DATE	05-09-13	DEPT.	
APP. BY	M.A.L.	NO	

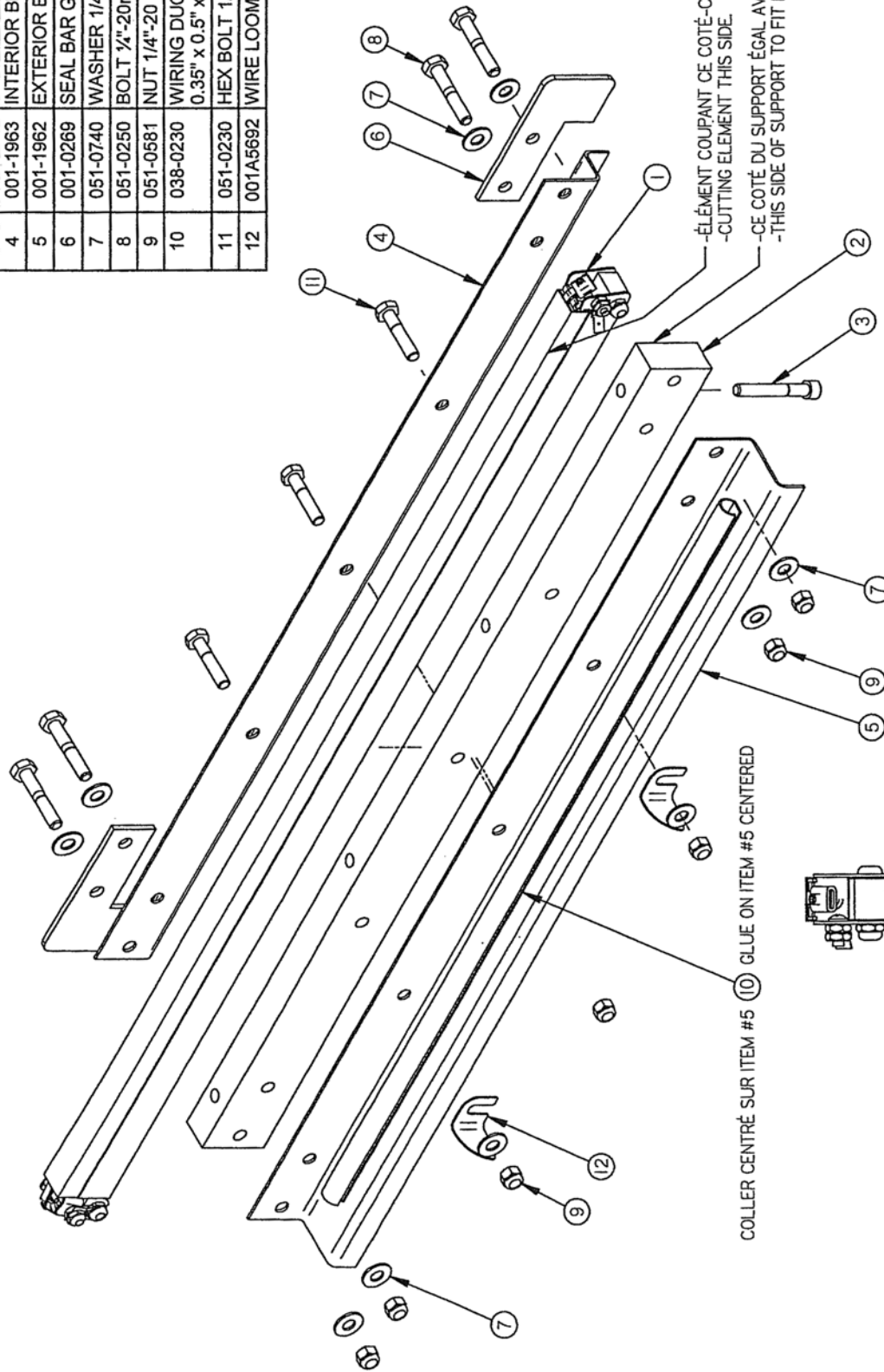
600A	4
550A	2
MACHINE	QTY
SIPROMAC	
ST-GERMAIN DE GRANBY	
QUEBEC CANADA	

M-(M)-I	LISTE
005A0152	

H	MODIF. A-463 AJOUTER 077-0095	10-06-01	J.G.
G	ADDED 052-0393	05-04-19	M.A.
F	051-0104 & 001B2742 ETAT 051-0100 & 009A0187	05-03-06	J.G.
E	REDRAWN	05-09-13	M.A.
LET.	MODIFICATION	DATE	INT.

1005B0569

ITEM	PART #	DESCRIPTION	QT.
1	005B0153	SEAL BAR PRE-ASSY	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOW COVER	1
5	001-1962	EXTERIOR BELLOW COVER	1
6	001-0269	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	7
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7))	1
11	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3
12	001A5692	WIRE LOOM SUPPORT #2	2



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

-END VIEW-

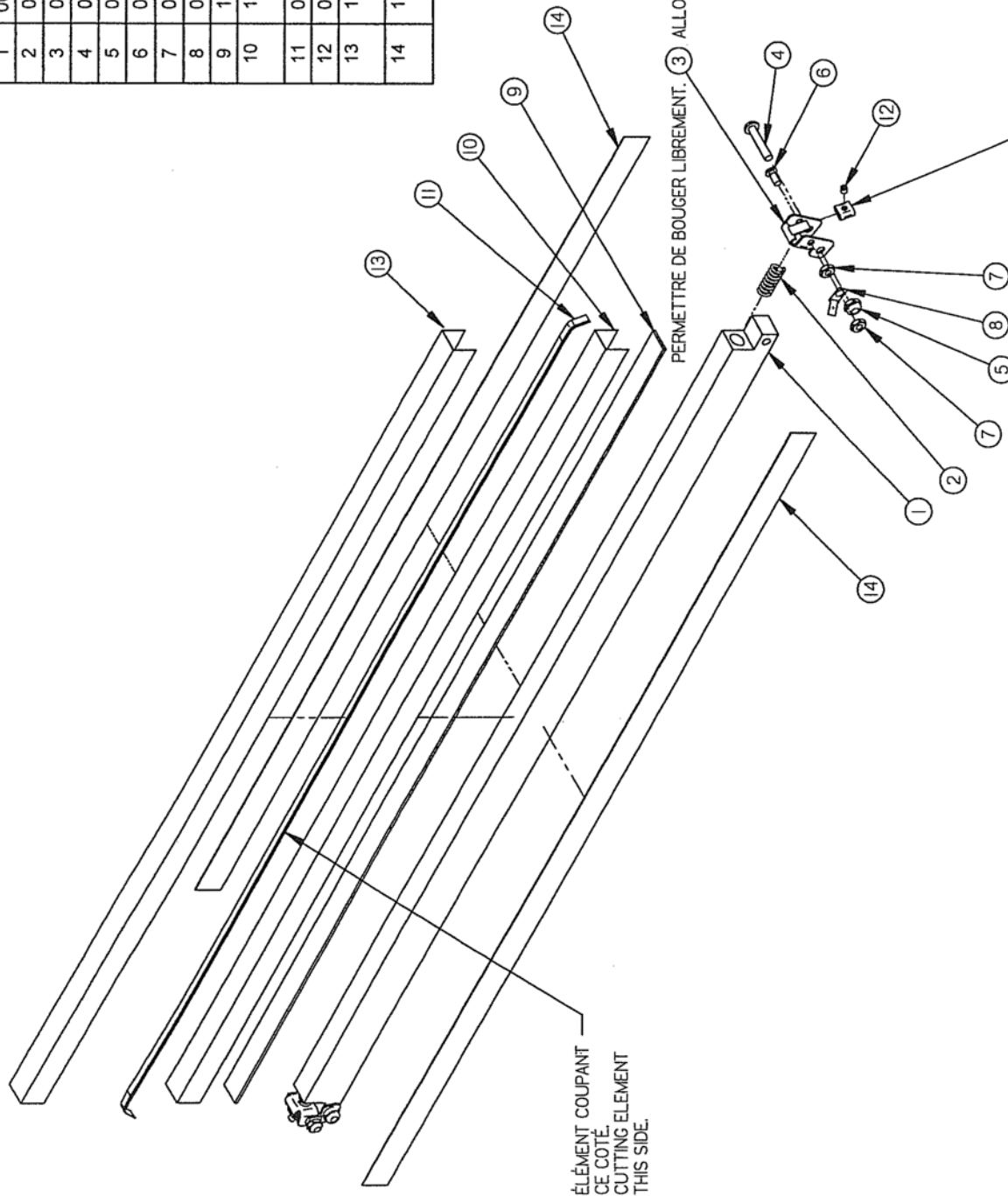
-BAG CUT OPTION-

MACHINE		550A & 600A	
PART		SEAL BAR ASSY W/SUPPORT	
ITEM		CNC	
DATE		11-08-30	
APP. BY		J.G.	
DATE		11-08-30	
M-L(M)		LISTE	
MACHINE		QTY	
600A		4	
550A		2	
MACHINE		QTY	
SIPROMAC		QTY	
ST-GERMAN DE GRANTHAM		QTY	
QUEBEC CANADA		QTY	
005B0569		QTY	

D.	REDESSINE - AJOUTER 001A5692	11-08-30	J.G.
LET.	MODIFICATION	DATE	INT.

1005B0153

ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	077-0095	SPRING C 0360-059-1250 S/S	2
3	001-2666	ELEMENT BINDER	3
4	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
5	051-0572	LOCK NUT #10-24 S/S	2
6	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
7	051-0550	NUT #8-32 SS	4
8	027-0400	CONNECTOR ADAPTOR	2
9	179-0003	SILICONE 2mm x 15mm 641.5mm (0.64)	1
10	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" 641.5mm (0.078)	1
11	039-0269	SEAL CUT ELEMENT (0.0688)	1
12	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
13	176-0203	TEFLON TAPE, 5MIL UNCOATED ZONE 641.5mm (0.064)	1
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2



PERMETTRE DE BOUGER LIBREMENT. ③ ALLOW TO MOVE FREELY.

INSTALLER CONTRE L'ENCOCHE DE L'ITEM #3 ⑫ INSTALL AGAINST NOTCH OF ITEM #3

-BAG CUT OPTION-

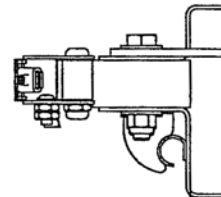
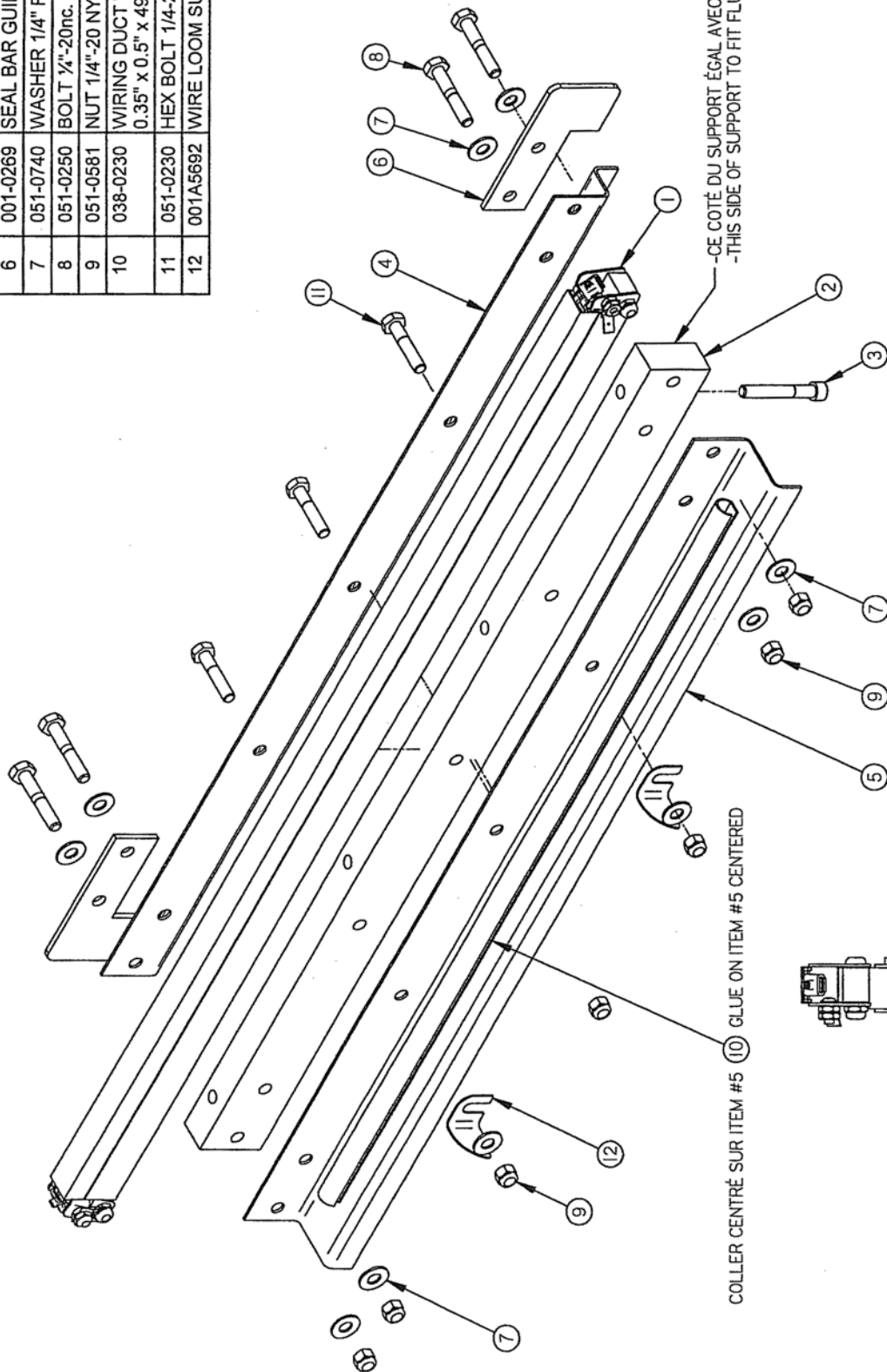
MACHINE		550A & 600A		DEPT 100 DES RECH		USINAGE ± 0.1 ± 0.004		TOLERIE ± 0.5 ± 0.020		SOUDAGE ± 0.5 ± 0.020		N.T.S.		DEPT 1		M-(M)-1		LISTE	
PART		SEAL BAR PRE-ASS'Y		GNC		DATE		06-05-29		DATE		06-05-29		DATE		06-05-29		005B0153	
ITEM		M.A.L.		APP. BY		DATE		06-05-29		DATE		06-05-29		DATE		06-05-29		005B0153	
MAT.		M.A.L.		APP. BY		DATE		06-05-29		DATE		06-05-29		DATE		06-05-29		005B0153	
MODIF. A-453 002A0314 ETAT 009A0191		REDRAWN		MODIFICATION		DATE		06-05-29		DATE		06-05-29		DATE		06-05-29		005B0153	
H		G		L.E.T.		J.G.		M.A.		INT.		INT.		INT.		INT.		INT.	

600A	4
550A	2
MACHINE	QTY

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

1005A0570

ITEM	PART #	DESCRIPTION	QT.
1	005A0370	SEAL BAR PRE-ASSY	1
2	002-0514	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	4
4	001-1963	INTERIOR BELLOW COVER	1
5	001-1962	EXTERIOR BELLOW COVER	1
6	001-0269	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	7
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 499 (1.7)	1
11	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	3
12	001A5692	WIRE LOOM SUPPORT #2	2



-END VIEW-

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

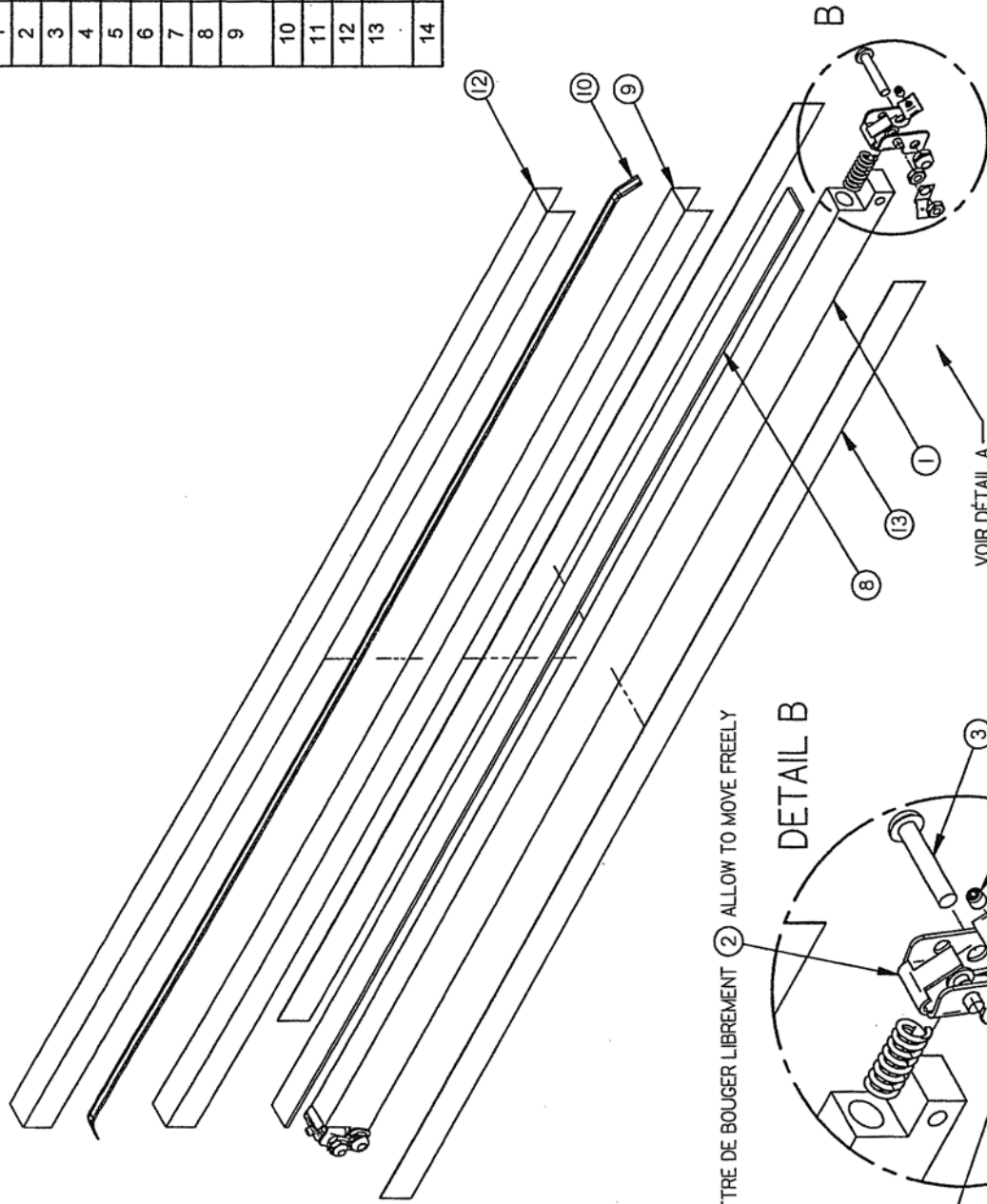
-TOP & BOTTOM SEALING OPTION-

MACHINE		550A & 600A		DEPT. TOL. (INCH)		USINAGE ±0.1 ±0.004		TOLERIE ±0.1 ±0.004		TOLEGE ±0.1 ±0.004		SOUDEGE ±0.1 ±0.004		N.T.S.	
PART		SEAL BAR ASSY W/SUPPORT		MACHINE		600A		550A		MACHINE		QTY		2	
ITEM		1		MACHINE		600A		550A		MACHINE		QTY		2	
MAT.		J.G.		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
APP. BY		J.G.		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
MODIFICATION		REDESSINE - AJOUTER 001A5692		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
LET.		C		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
INT.		J.G.		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
M-I(M)		M-I(M)		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
LIST		005A0570		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	

MACHINE		550A & 600A		DEPT. TOL. (INCH)		USINAGE ±0.1 ±0.004		TOLERIE ±0.1 ±0.004		TOLEGE ±0.1 ±0.004		SOUDEGE ±0.1 ±0.004		N.T.S.	
PART		SEAL BAR ASSY W/SUPPORT		MACHINE		600A		550A		MACHINE		QTY		2	
ITEM		1		MACHINE		600A		550A		MACHINE		QTY		2	
MAT.		J.G.		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
APP. BY		J.G.		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
MODIFICATION		REDESSINE - AJOUTER 001A5692		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
LET.		C		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
INT.		J.G.		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
M-I(M)		M-I(M)		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	
LIST		005A0570		DATE		11-08-30		DATE		11-08-30		DATE		11-08-30	

005A0370

ITEM	PART #	DESCRIPTION	QT.
1	002A0314	SEAL BAR	1
2	001-2666	ELEMENT BINDER	2
3	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
4	051-0572	LOCK NUT #10-24 S/S	2
5	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
6	051-0550	NUT #8-32 SS	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm 641.5mm (0.64)	1
9	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" 641.5mm (0.078)	1
10	039-0220	BI-ACTIVE SEALING ELEMENT (0.07)	1
11	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
12	176-0200	TEFLON TAPE, 5MIL (0.78)	1
13	171-0180	TAPE CLEAR SUPER BOND 3/4" 641.5mm (0.019)	2
14	077-0095	SPRING C 0360-059-1250 S/S	2



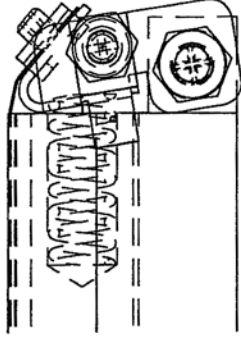
PERMETTRE DE BOUGER LIBREMENT ② ALLOW TO MOVE FREELY

DETAIL B



VOIR DETAIL A

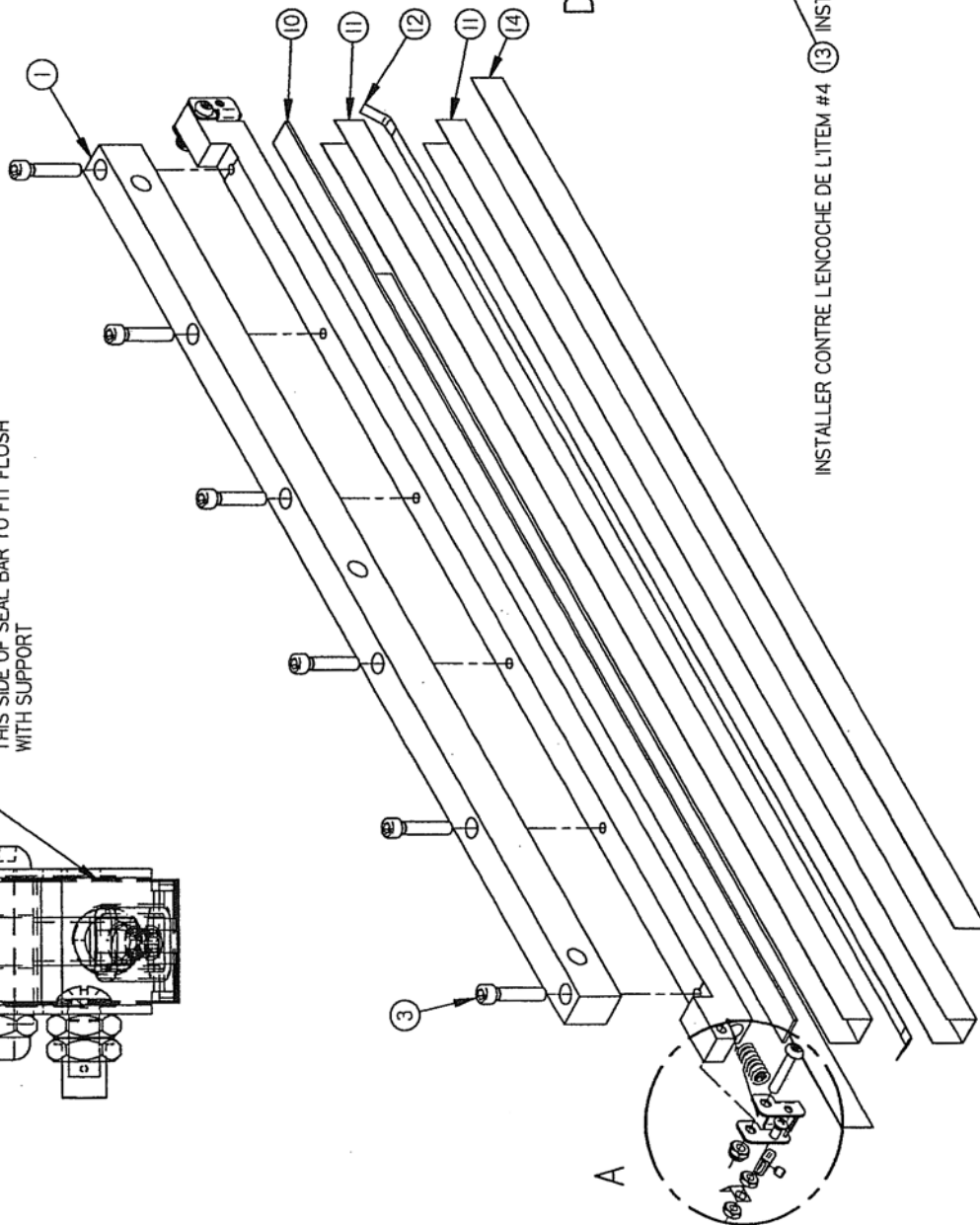
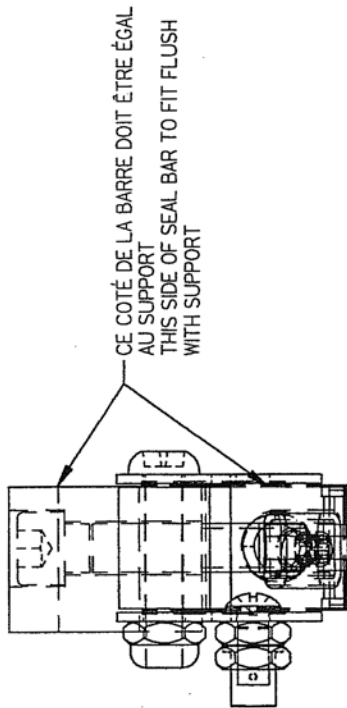
-DÉTAIL A-



-TOP & BOTTOM
SEALING OPTION-

MACHINE	550A & 600A	DEPT. TOL. METRIC INCH	USENAGE	± 0.1	± 0.004
PART	SEAL BAR PRE-ASSY	USNAGE	± 0.1	± 0.004	
ITEM		SOLDAGE	± 0.5	± 0.020	
NAT.					
DATE	07-12-17	DEPT.	N.T.S.		
APP. BY					
DATE	07-12-17				
MODIF. A-453 AJOUTER 077-0095					
REDRAWN					
MODIFICATION					
DATE					
INT.					
J.G.	10-06-01				
M.A.	07-12-17				
DATE					
INT.					
MACHINE	600A	4			
550A	2				
QUANTITY					
SIPROMAC					
ST-GERMAIN DE GRANTHAM					
QUEBEC CANADA					
M-(M)-I					
LISTE					
005A0370					

ITEM	PART #	DESCRIPTION	QT.
1	002A0537	UPPER SEAL BAR SUPPORT	1
2	002A0538	UPPER SEAL BAR	1
3	051-0232	SCREW 1/4-20x 1-1/4" SKT CAP SS	6
4	001-2666	ELEMENT BINDER	2
5	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
6	051-0572	LOCK NUT #10-24 S/S	2
7	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
8	051-0550	NUT #8-32 SS	4
9	027-0400	CONNECTOR ADAPTOR	2
10	179-0003	SILICONE 2mm x 15mm ADHESIVE 617mm (0.62)	1
11	176-0220	TEFLON TAPE, PRESS. SENSITIVE 2" 617mm (0.07)	2
12	039-0220	BI-ACTIVE SEALING ELEMENT (6mm) 660mm (0.066)	1
13	056-1400	1/4" SET SCREW BANDING BUCKLE S/S	2
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 584mm (0.018)	2
15	077-0095	SPRING C 0360-059-1250 S/S	2



DETAIL A

INSTALLER CONTRE L'ENCOCHE DE L'ITEM #4 (13) INSTALL AGAINST NOTCH OF ITEM #4

PERMETTRE DE BOUGER LIBREMENT (4) ALLOW TO MOVE FREELY

-TOP & BOTTOM SEALING OPTION-

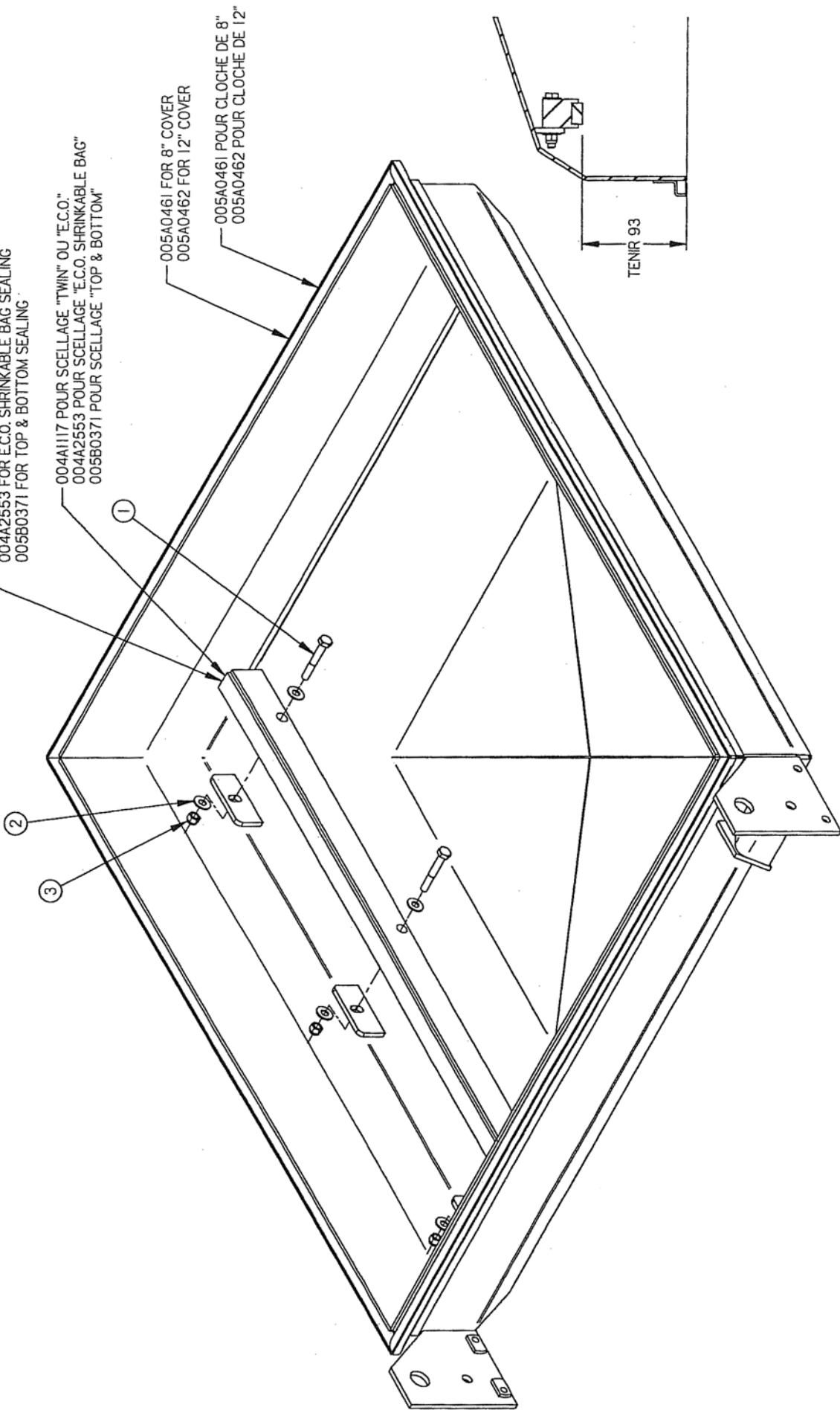
MACHINE		DEPT. TO METRIC INCH		SIPROMAC	
PART		550A		ST-GERMAN DE GRANTHAM	
UPPER SEAL BAR ASSY W/SUPPORT		UPPER SEAL BAR ASSY W/SUPPORT		QUEBEC CANADA	
ITEM	QTY	DATE	BY	DATE	BY
1	2	07-12-17	J.G.	07-12-17	J.G.
MAT.		APP. BY		APP. BY	
1005B0371		1005B0371		1005B0371	

F	MODIF. A-453 AJOUTER 077-0095	10-06-01	J.G.
E	REDESSINE	07-12-17	J.G.
LET.	MODIFICATION	DATE	INT.

1010A0064

ITEM	PART #	DESCRIPTION	QT.
1	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	6
2	051-0740	WASHER 1/4" FLAT S/S	12
3	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6

004A1117 FOR TWIN OR E.C.O. SEALING
004A2553 FOR E.C.O. SHRINKABLE BAG SEALING
005B0371 FOR TOP & BOTTOM SEALING



TENIR 93

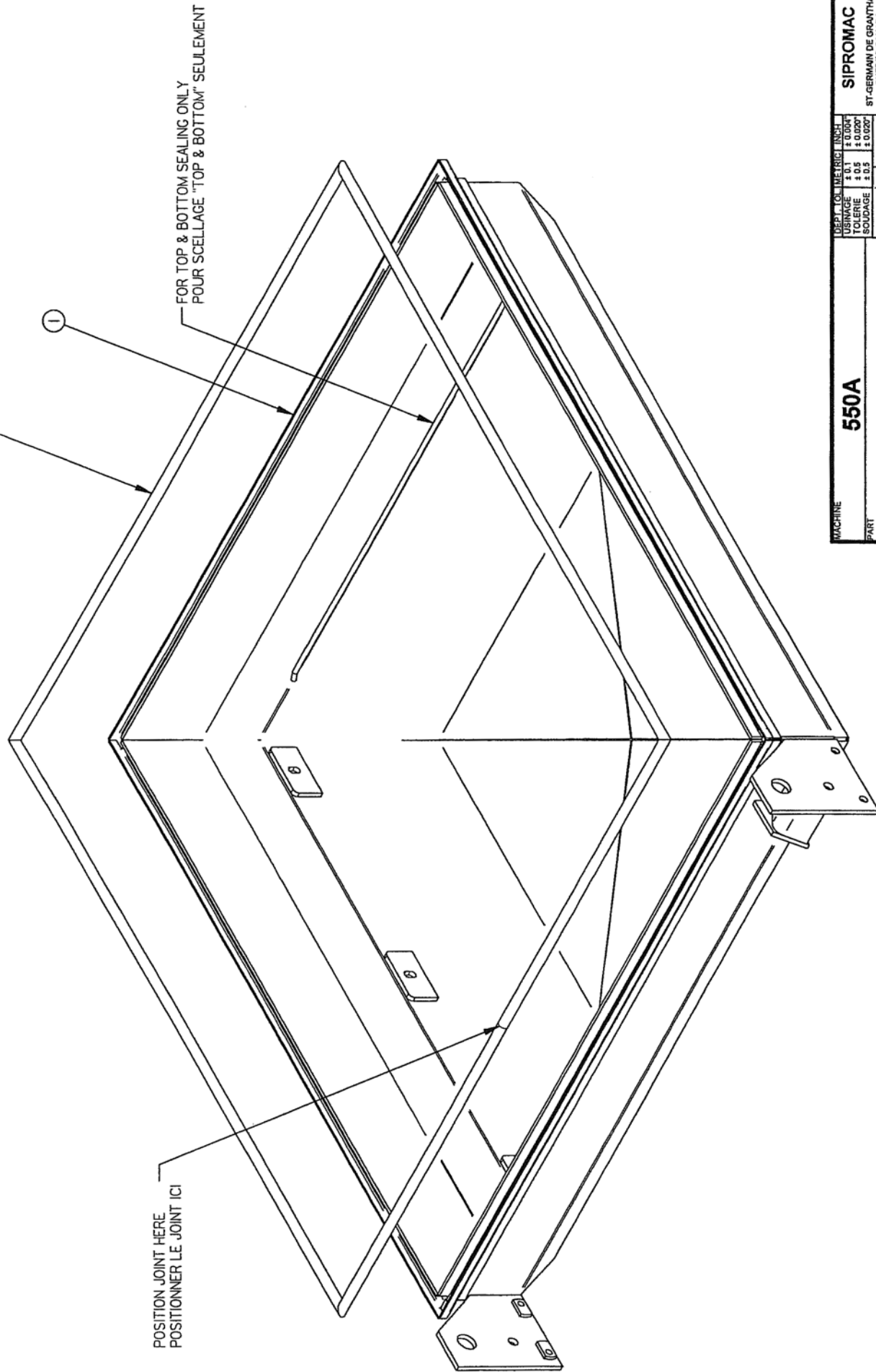
MACHINE		550A		DEPT. TOL. METRIC INCH		SIPROMAC	
PART		UPPER SEAL BAR INSTALLATION		TOLERANCE ± 0.1 TOLERANCE ± 0.0207 TOLERANCE ± 0.0207		ST GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM		CNC		N.T.S.		M-I	
DATE		09-01-06		DATE		09-01-06	
BY		J.G.		BY		J.G.	
APP. BY				APP. BY			
MODIFICATION		005-0461 & 005-0462		DATE		INT.	
LET.		A		DATE		INT.	

010A0064

1005A0461

ITEM	PART #	DESCRIPTION	QT.
1	004A0134	8" COVER PRE-ASSEMBLY	1
2	179-0020	NEOPRENE SPONGE 1/2" x 10.2'	1

USE PERMATAX RUBBER ADHESIVE 169-0010 TO GLUE ② UTILISER PERMATAX RUBBER ADHESIVE 169-0010 POUR COLLER

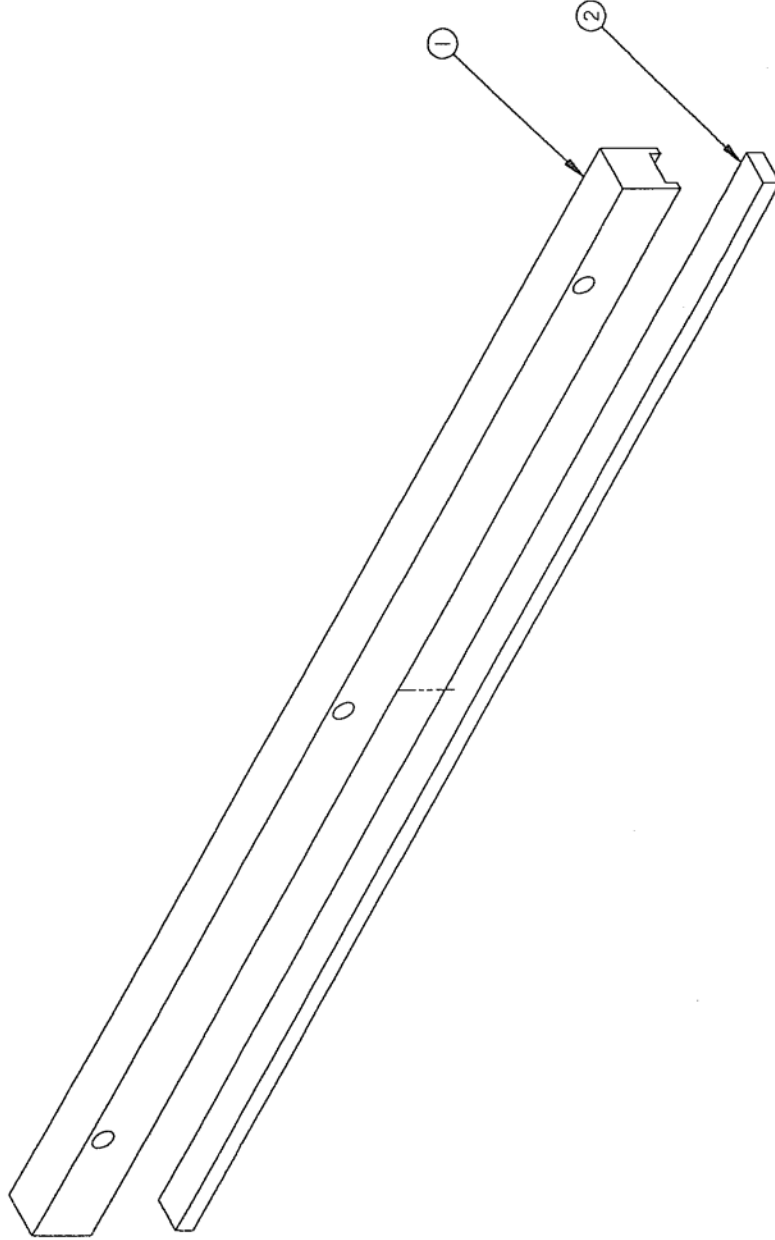


MACHINE	550A	DEPT. TO MEASURE (UNIT)	STIPROMAC
PART	8" COVER ASSEMBLY	USINAGE ± 0.001	ST-GERMAIN DE GRANTHAM
ITEM	CNC	TOLERIE ± 0.5	QUEBEC CANADA
NAT.	QWG BY J.G.	SOLDAGE ± 0.5	N.T.S.
DATE	09-01-06	DEPT.	M-I
APP. BY	J.G.	QTY.	1
MODIFICATION	09-02-23		005A0461

B	REDESSINE MODIF. #A-0444 / VOIR AUSSI 010A0064	09-01-06	J.G.
LET.	MODIFICATION	DATE	INT.

1004A1117

ITEM	PART #	DESCRIPTION	QTY.
1	002A2063	UPPER SEAL BAR SUPPORT	1
2	008-0320	UPPER SEAL BAR RUBBER	1



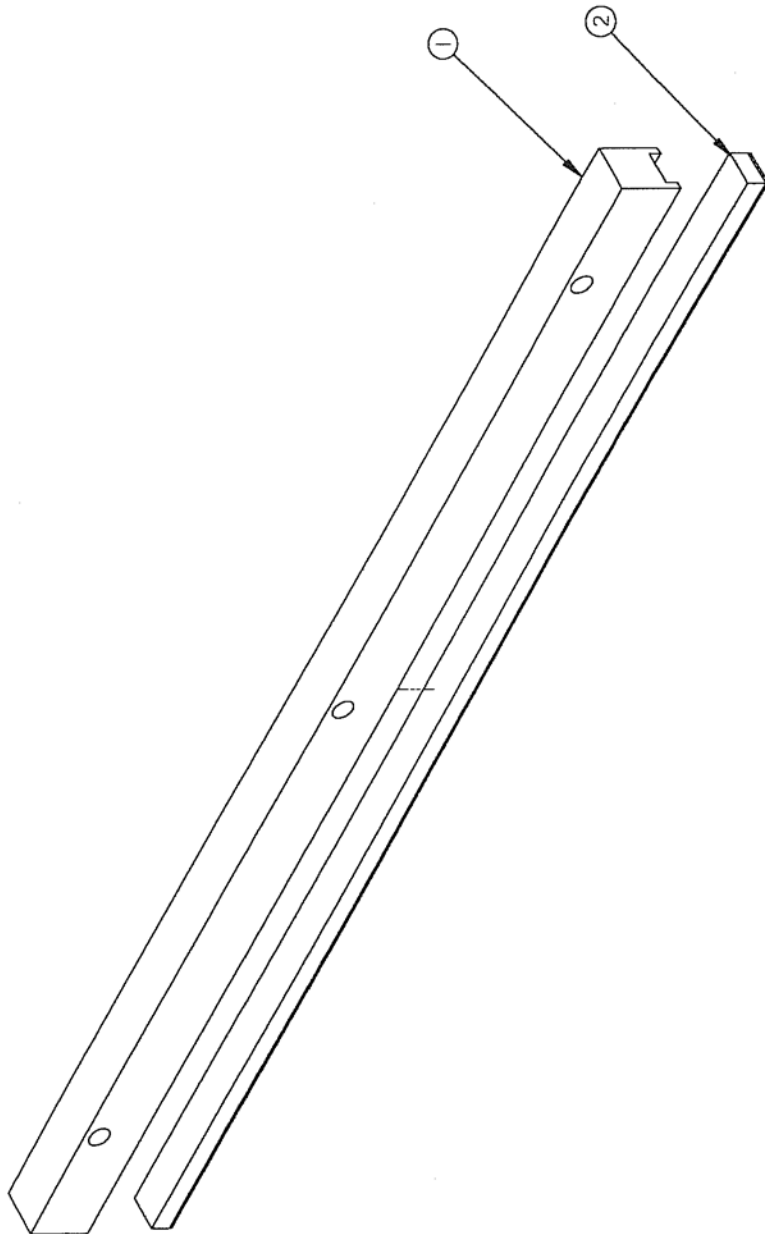
-BAG CUT OPTION & TWIN-

MACHINE		DEPT. TOL. METRIC INCH		SIPROMAC	
550A		USINAGE ± 0.1 ± 0.004"		ST-GERMAIN DE GRANTHAM	
PART		TOLERIE ± 0.5 ± 0.020"		QUEBEC CANADA	
UPPER SEAL BAR ASSEMBLY (E.C.O.) & (TWIN)		SOUDEGE ± 0.3 ± 0.020"		N.T.S.	
ITEM	CNC	DEPT.	M-I	QTY.	2
DATE	08-04-30	DATE	08-04-30	NO.	004A1117
APP. BY	J.G.	APP. BY	J.G.	DATE	08-04-30

B	MODIF. #A-0444 / AJOUTER TWIN ETAIT 004A0132	09-01-06	J.G.
A	REDESSINE VOIR AUSSI 004A2553 & 004A2554	08-04-30	J.G.
LET.	MODIFICATION	DATE	INT.

004A2553

ITEM	PART #	DESCRIPTION	QT.
1	002A2063	UPPER SEAL BAR SUPPORT	1
2	004A2554	SHRINKABLE BAG TEFLON PRE-ASSY	1



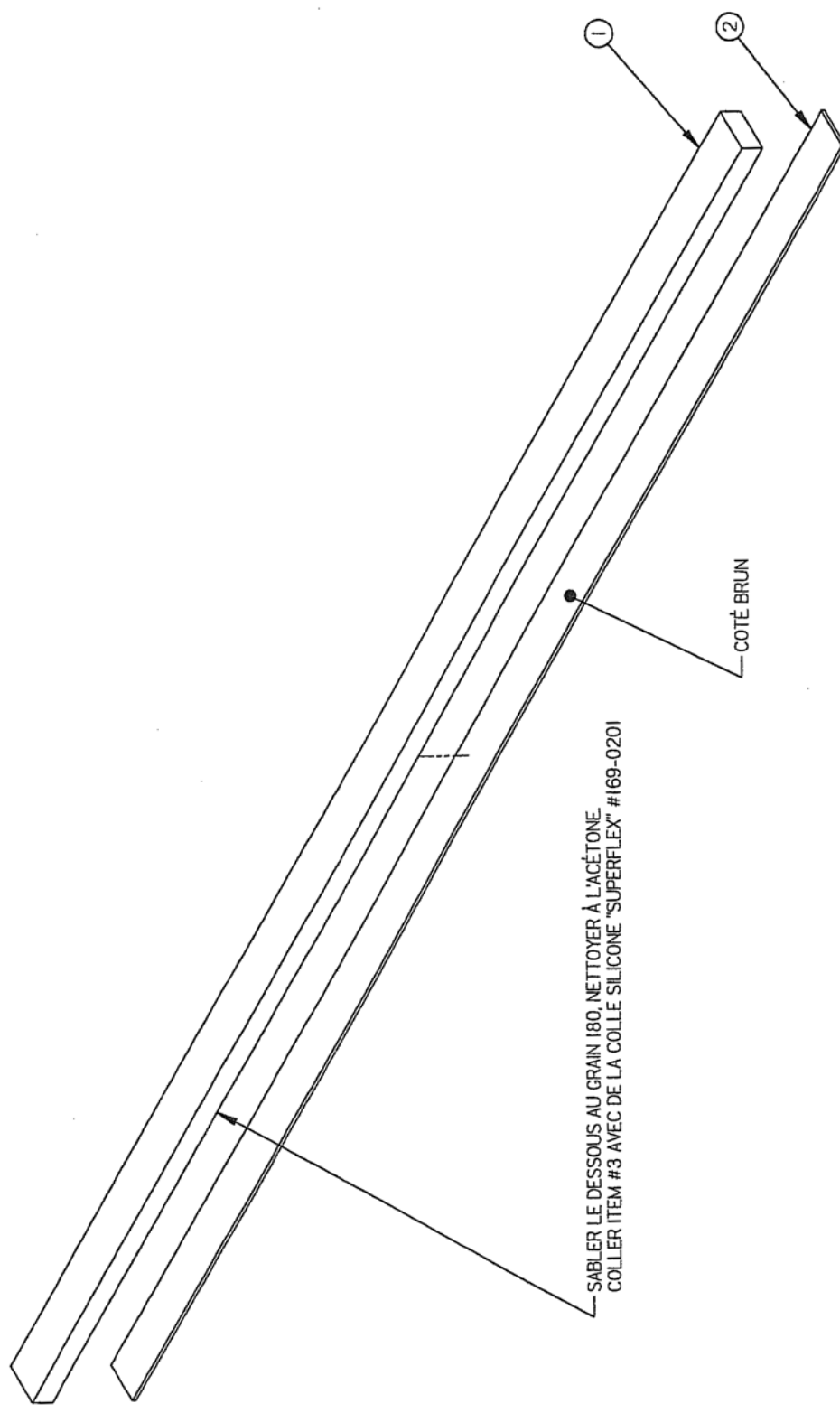
-SHRINKABLE BAG CUT OPTION-

MACHINE	550A	DEPT. 101	METRIC	INCH	SIPROMAC
PART	UPPER SEAL BAR ASSY (SHRINKABLE)	TOLERANCE	± 0.5	$\pm 0.020"$	ST-GERMAIN DE GRANTHAM
ITEM		SQUADAGE	± 0.5	$\pm 0.020"$	QUEBEC CANADA
DATE	08-04-30	DATE	08-04-30	DATE	08-04-30
BY	J.G.	BY	J.G.	BY	J.G.
APP. BY		APP. BY		APP. BY	
ITEM		ITEM		ITEM	
QTY.	2	QTY.	2	QTY.	2
					004A2553

A	ETAIT 004A1125	08-04-30	J.G.
LET.	MODIFICATION	DATE	INT.

1004A2554

ITEM	PART #	DESCRIPTION	QT.
1	008-0320	UPPER SEAL BAR RUBBER	1
2	008A0842	TEFLON CUTTING STRIP	1



-SHRINKABLE BAG CUT OPTION-

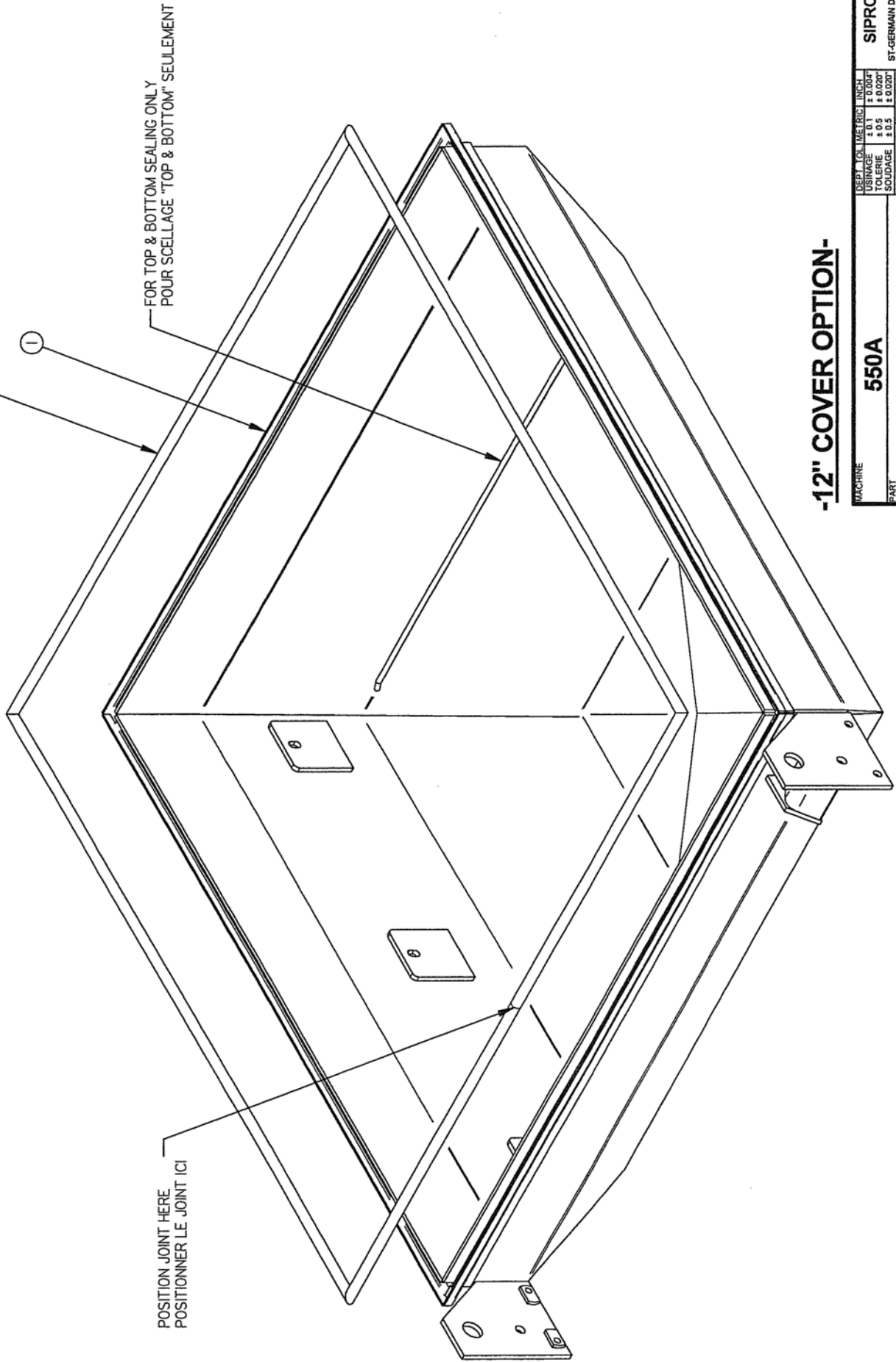
MACHINE	550A	DEPT. JOL. METRIC	INCH	SIPROMAC
PART	SHRINKABLE BAG TEFLON PRE-ASSY	TOLERIE	± 0.027	ST-GERMAIN DE GRANTHAM
ITEM	CNC	SOLDAGE	± 0.5	QUEBEC CANADA
NAT.	DATE 08-04-30	N.T.S.	DEPT.	QTY. 2
APP. BY	J.G.	DATE 08-04-30	DATE 08-04-30	004A2554

A	ETAIT 004A1125	08-04-30	J.G.
LET.	MODIFICATION	DATE	INT.

1005A0462

ITEM	PART #	DESCRIPTION	QTY.
1	004A0135	12" COVER PRE-ASSEMBLY	1
2	179-0020	NEOPRENE SPONGE 1/2" x 10.2"	1

USE PERMATEX RUBBER ADHESIVE 169-0010 TO GLUE ② UTILISER PERMATEX RUBBER ADHESIVE 169-0010 POUR COLLER

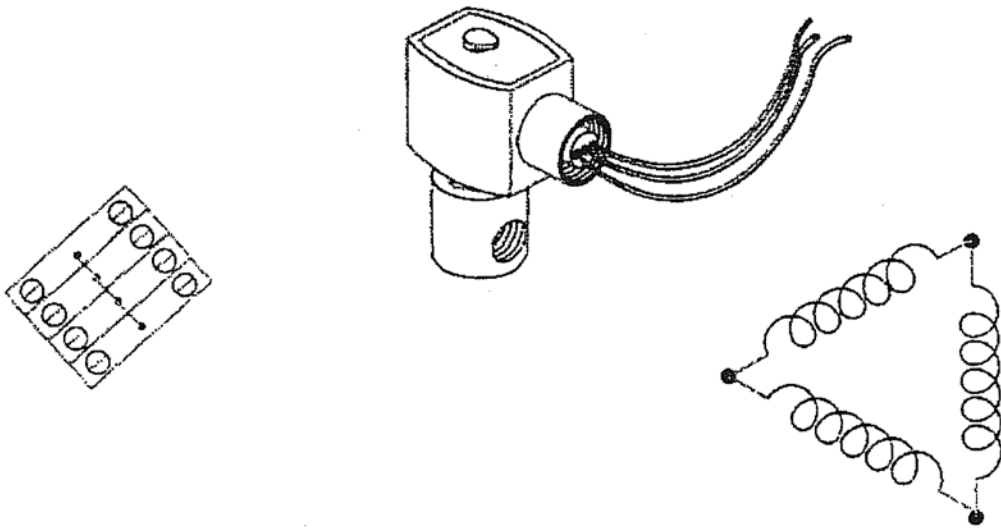


-12" COVER OPTION-

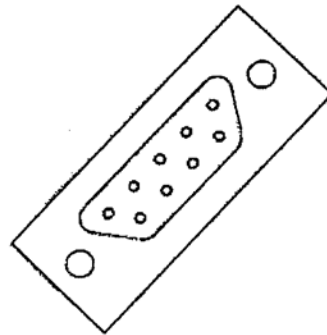
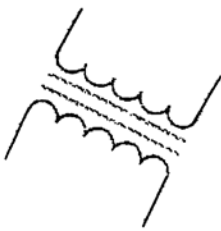
MACHINE	550A	DEPT. 101	METRIC	INCH	SIPROMAC
PART	12" COVER ASSEMBLY	TOLERANCE	± 0.5	± 0.002"	ST-GERMAIN DE GRANTHAM
ITEM	CNC	SOLDAGE	± 0.5	± 0.002"	QUEBEC CANADA
DATE	09-01-06	N.T.S.			
APP. BY	J.G.	DEPT.	M-I	QTY.	1
MODIFICATION					

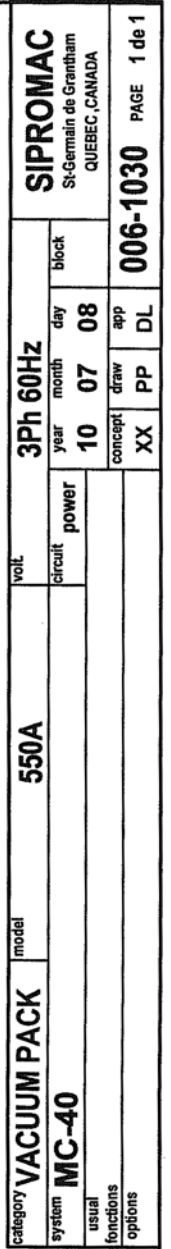
B	REDESSINE MODIF. #A-0444 / VOIR AUSSI 010A0064	09-01-06	J.G.
LET.	MODIFICATION	DATE	INT.

005A0462



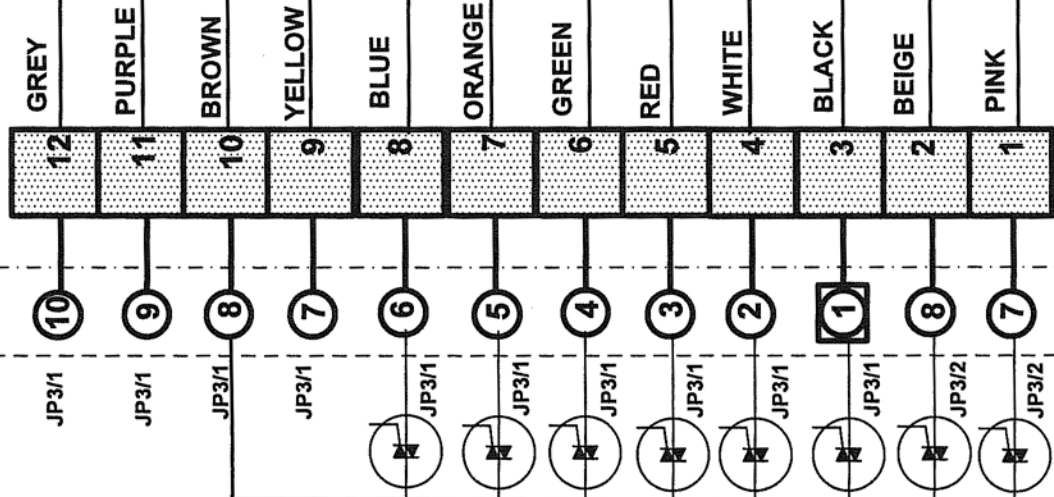
ELECTRICAL DRAWING





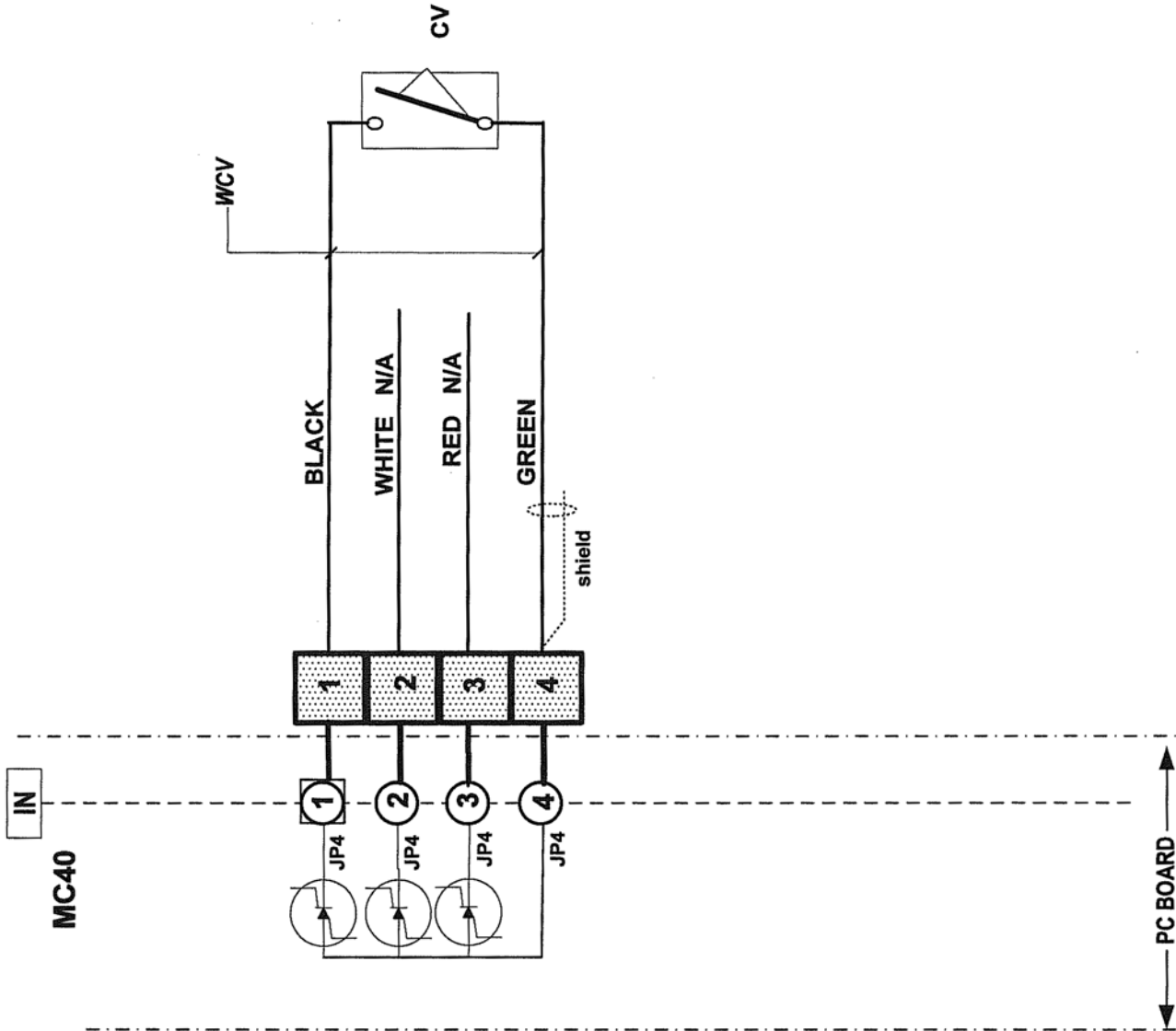
OUT

MC40



TRANSF.CONT.

category		VACUUM PACK		model	550A		volt		ALL				SIPROMAC				
system		MC-40						circuit	control		year	month	day	block	St-Germain de Grantham		
usual										10		07		08		QUEBEC, CANADA	
fonctions												concept	draw	app			
options												XX	PP	DL			
														006-1037		PAGE 1 de 2	

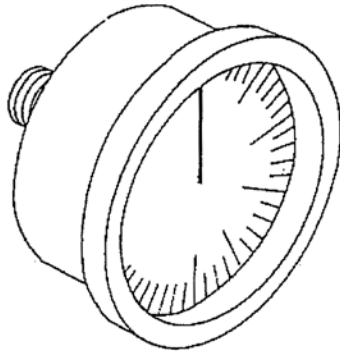


category	VACUUM PACK	model	550A	volt.	ALL				SIPROMAC				
system	MC-40			circuit	control	year	month	day	block	St-Germain de Grantham			
usual						10	07	08		QUEBEC, CANADA			
fonctions						concept	draw	app		006-1037 PAGE 2 de 2			
options						XX	PP	DL					

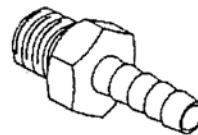
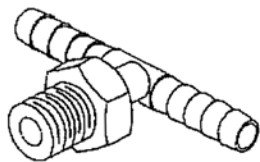
# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
028-0018	TERMINAL BLOCK M6/8 600V/50A.(8AWG)	SUPPLY	208V/3PH/60HZ	550A	L1-L2-L3		3
028-0020	GROUND TERMINAL BLOCK M6/8P	SUPPLY	208V/3PH/60HZ	550A	GND		1
028-0060	SEPARATOR M4/6	SUPPLY	208V/3PH/60HZ	550A	GND-L1-L2-L3		4
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	550A	GND		1
034-0700	FUSE HOLDER 30A/600V GOULD	VACUUM	208V/3PH/60HZ	550A	F1		3
034-0500	FUSE MIDGET 15A/250V TIME-DELAY	VACUUM RA-0040	208V/3PH/60HZ	550A	F1	A1	3
025-0030	MOTOR CONTACTOR 2HP IN 208V/3PH-CSA,UL	VACUUM RA-0040	208V/3PH/60HZ	550A	C1	A1	1
025-0160	THERMAL OVERLOAD 5.5 TO 8A-CSA,UL	VACUUM RA-0040	208V/3PH/60HZ	550A	O/L1	A1	1
030-0180	CAB TIRE	VACUUM RA-0040	208V/3PH/60HZ	550A	WM1	A1	2M.
125-0030	BUSCH RA-0040 230-460V/3PH/60HZ 2HP 6.2A	VACUUM RA-0040	208V/3PH/60HZ	550A	M1	A1	1
034-0530	FUSE MIDGET 20A/250V TIME-DELAY	VACUUM RA-0063	208V/3PH/60HZ	550A	F1	A2	3
025-0025	MOTOR CONTACTOR 3HP IN 208V/3PH-CSA,UL	VACUUM RA-0063	208V/3PH/60HZ	550A	C1	A2	1
025-0170	THERMAL OVERLOAD 7 TO 10A-CSA,UL	VACUUM RA-0063	208V/3PH/60HZ	550A	O/L1	A2	1
030-0180	CAB TIRE	VACUUM RA-0063	208V/3PH/60HZ	550A	WM1	A2	2M.
125-0040	BUSCH RA-0063 230-460V/3PH/60HZ 3HP 8.4A	VACUUM RA-0063	208V/3PH/60HZ	550A	M1	A2	1
034-0550	FUSE MIDGET 25A/250V TIME-DELAY	VACUUM RA-0100	208V/3PH/60HZ	550A	F1	A3	3
025-0030	MOTOR CONTACTOR 5HP IN 208V/3PH-CSA,UL	VACUUM RA-0100	208V/3PH/60HZ	550A	C1	A3	1
025-0190	THERMAL OVERLOAD 12 TO 18A-CSA,UL	VACUUM RA-0100	208V/3PH/60HZ	550A	O/L1	A3	1
030-0140	CAB TIRE	VACUUM RA-0100	208V/3PH/60HZ	550A	WM1	A3	2M.
125-0060	BUSCH RA-0100 230-460V/3PH/60HZ 5HP 13.6A	VACUUM RA-0100	208V/3PH/60HZ	550A	M1	A3	1
034-0700	FUSE HOLDER 30A/600V GOULD	SEALING	208V/3PH/60HZ	550A	F2		2
034-0450	FUSE MIDGET 7A/250V TIME-DELAY	SEALING TWIN SEAL	208V/3PH/60HZ	550A	F2	B1	2
029-0040	TRANSFO 500VA/208-240/24V 60HZ	SEALING TWIN SEAL	208V/3PH/60HZ	550A	TR1	B1	1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING	ALL	550A			2
025-0020	CONTACTOR ITH=25A-CSA,UL	SEALING	ALL	550A	C2		1
030-0410	TEW #10/104 BLACK	SEALING	ALL	550A	WEL		7M.
027-0210	TERMINAL FEMALE .250" INSULATED 600v 75°C	SEALING	ALL	550A	WEL		4
005A0568	SEAL BAR ASSY W/SUPPORT	SEALING TWIN SEAL	ALL	550A		B1	2
034-0470	FUSE MIDGET 10A/250V TIME-DELAY	SEALING BAG CUT	208V/3PH/60HZ	550A	F2	B2	2
029-0062	TRANSFO 750VA 208-240V/30V/60HZ	SEALING BAG CUT	208V/3PH/60HZ	550A	TR1	B2	1
005A0569	SEAL BAR ASSY W/SUPPORT	SEALING BAG CUT	ALL	550A		B2	2
034-0500	FUSE MIDGET 15A/250V TIME-DELAY	SEALING TOP & BOTTOM	208V/3PH/60HZ	550A	F2	B3	2
029-0079	TRANSFO 1000VA 208-240/24V 60H	SEALING TOP & BOTTOM	208V/3PH/60HZ	550A	TR1	B3	1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING TOP & BOTTOM	ALL	550A		B3	2
025-0020	CONTACTOR ITH=25A-CSA,UL	SEALING TOP & BOTTOM	ALL	550A	C3	B3	1
030-0120	CAB TIRE	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	3M.
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	4
005A0570	SEAL PRE ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A		B3	2
005B0371	UPPER SEAL BAR ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A		B3	2
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	208V/3PH/60HZ	550A	F5		2
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	208V/3PH/60HZ	550A	F5		2

# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
029-0009	TRANSFO 65VA/208-230V/24-9V	CONTROL TRANSFO	208V/3PH/60HZ	550A	TR2		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	550A	F3+F4		2
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	550A	F3		1
034-0240	FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	550A	F4		1
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	550A	W001		2.5M.
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	550A	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	550A	WCV		2.5M.
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	550A	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	550A	JP4		2
033-0038	MICROPROCESSOR MC-40 SENSOR VACUUM	CONTROL WITH SENSOR	ALL	550A	MC-40	C1	1
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL W/O SENSOR	ALL	550A	MC-40	C2	1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	550A		D1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	550A		D2	1
106-0010	VALVE 2WAY 24V 1/4 NPT(G22) 60HZ	OPTION GAS	ALL	550A	H	E	1
106-0030	VALVE 2WAY 24V 3/4 NPT(G95) 60HZ	ATMOSPHERE	ALL	550A	F		1
106-0070	VALVE 3WAY 24V 1/4 NPT(G176)60HZ	BELLOWS	ALL	550A	G		1
026-0610	LIMIT SWITCH LONG ROLLER 15A 250V	COVER POSITION	ALL	550A	CV		1
028-0018	TERMINAL BLOCK M6/8 600V/50A.(8AWG)	SUPPLY	460V/3PH/60HZ	550A	L1-L2-L3		3
028-0020	GROUND TERMINAL BLOCK M6/8P	SUPPLY	460V/3PH/60HZ	550A	GND		1
028-0060	SEPARATOR M4/6	SUPPLY	460V/3PH/60HZ	550A	GND-L1-L2-L3		4
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	550A	GND		1
034-0700	FUSE HOLDER 30A/600V GOULD	VACUUM	460V/3PH/60HZ	550A	F1		3
034-0480	FUSE MIDGET 10A/600V FAST ACTING	VACUUM RA-0040	460V/3PH/60HZ	550A	F1	A1	3
025-0010	MOTOR CONTACTOR 5HP IN 460V/3PH-CSA,UL	VACUUM RA-0040	460V/3PH/60HZ	550A	C1	A1	1
025-0140	THERMAL OVERLOAD 2.5 TO 4A-CSA,UL	VACUUM RA-0040	460V/3PH/60HZ	550A	O/L1	A1	1
030-0190	CAB TIRE	VACUUM RA-0040	460V/3PH/60HZ	550A	WM1	A1	2M.
125-0030	BUSCH RA-0040 230-460V/3PH/60HZ 2HP 2.6A	VACUUM RA-0040	460V/3PH/60HZ	550A	M1	A1	1
034-0510	FUSE MIDGET 15A/600V FAST ACTING	VACUUM RA-0063	460V/3PH/60HZ	550A	F1	A2	3
025-0025	MOTOR CONTACTOR 7.5HP IN 460V/3PH-CSA,UL	VACUUM RA-0063	460V/3PH/60HZ	550A	C1	A2	1
025-0150	THERMAL OVERLOAD 4 TO 6A-CSA,UL	VACUUM RA-0063	460V/3PH/60HZ	550A	O/L1	A2	1
030-0190	CAB TIRE	VACUUM RA-0063	460V/3PH/60HZ	550A	WM1	A2	2M.
125-0040	BUSCH RA-0063 230-460V/3PH/60HZ 3HP 3.9A	VACUUM RA-0063	460V/3PH/60HZ	550A	M1	A2	1
034-0540	FUSE MIDGET 20A/600V FAST ACTING	VACUUM RA-0100	460V/3PH/60HZ	550A	F1	A3	3
025-0010	MOTOR CONTACTOR 5HP IN 460/3PH-CSA,UL	VACUUM RA-0100	460V/3PH/60HZ	550A	C1	A3	1
025-0160	THERMAL OVERLOAD 5.5 TO 8A-CSA,UL	VACUUM RA-0100	460V/3PH/60HZ	550A	O/L1	A3	1
030-0190	CAB TIRE	VACUUM RA-0100	460V/3PH/60HZ	550A	WM1	A3	2M.
125-0060	BUSCH RA-0100 230-460V/3PH/60HZ 5HP 6.3A	VACUUM RA-0100	460V/3PH/60HZ	550A	M1	A3	1
034-0700	FUSE HOLDER 30A/600V GOULD	SEALING	460V/3PH/60HZ	550A	F2		2
034-0450	FUSE MIDGET 7A/250V TIME-DELAY	SEALING TWIN SEAL	460V/3PH/60HZ	550A	F2	B1	2
029-0040	TRANSFO 500VA/208-240/24V 60HZ	SEALING TWIN SEAL	460V/3PH/60HZ	550A	TR1	B1	1

# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING	ALL	550A			2
025-0020	CONTACTOR ITH=25A-CSA,UL	SEALING	ALL	550A	C2		1
030-0410	TEW #10/104 BLACK	SEALING	ALL	550A	WEL		7M.
027-0210	TERMINAL FEMALE .250" INSULATED 600v 75°C	SEALING	ALL	550A	WEL		4
005A0568	SEAL BAR ASSY W/SUPPORT	SEALING TWIN SEAL	ALL	550A		B1	2
034-0470	FUSE MIDGET 10A/250V TIME-DELAY	SEALING BAG CUT	460V/3PH/60HZ	550A	F2	B2	2
029-0062	TRANSFO 750VA 208-240V/30V/60HZ	SEALING BAG CUT	460V/3PH/60HZ	550A	TR1	B2	1
005A0569	SEAL BAR ASSY W/SUPPORT	SEALING BAG CUT	ALL	550A		B2	2
034-0500	FUSE MIDGET 15A/250V TIME-DELAY	SEALING TOP & BOTTOM	460V/3PH/60HZ	550A	F2	B3	2
029-0079	TRANSFO 1000VA 208-240/24V 60H	SEALING TOP & BOTTOM	460V/3PH/60HZ	550A	TR1	B3	1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING TOP & BOTTOM	ALL	550A		B3	2
025-0020	CONTACTOR ITH=25A-CSA,UL	SEALING TOP & BOTTOM	ALL	550A	C3	B3	1
030-0120	CAB TIRE	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	3M.
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING TOP & BOTTOM	ALL	550A	WTB	B3	4
005A0570	SEAL PRE ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A		B3	2
005B0371	UPPER SEAL BAR ASSY W/SUPPORT	SEALING TOP & BOTTOM	ALL	550A		B3	2
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	460V/3PH/60HZ	550A	F5		2
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	460V/3PH/60HZ	550A	F5		2
029-0009	TRANSFO 65VA/208-230V/24-9V	CONTROL TRANSFO	460V/3PH/60HZ	550A	TR2		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	550A	F3+F4		2
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	550A	F3		1
034-0240	FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	550A	F4		1
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	550A	W001		2.5M.
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	550A	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	550A	WCV		2.5M.
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	550A	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	550A	JP4		2
033-0038	MICROPROCESSOR MC-40 SENSOR VACUUM	CONTROL WITH SENSOR	ALL	550A	MC-40	C1	1
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL W/O SENSOR	ALL	550A	MC-40	C2	1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	550A		D1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	550A		D2	1
106-0010	VALVE 2WAY 24V 1/4 NPT(G22) 60HZ	OPTION GAS	ALL	550A	H	E	1
106-0030	VALVE 2WAY 24V 3/4 NPT(G95) 60HZ	ATMOSPHERE	ALL	550A	F		1
106-0070	VALVE 3WAY 24V 1/4 NPT(G176)60HZ	BELLOWS	ALL	550A	G		1
026-0610	LIMIT SWITCH LONG ROLLER 15A 250V	COVER POSITION	ALL	550A	CV		1

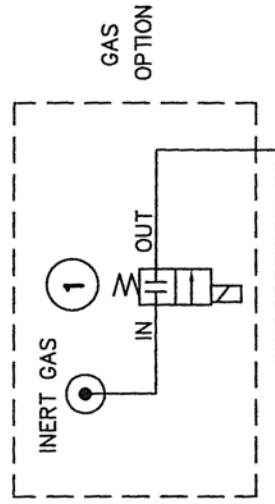


PNEUMATIC DRAWING

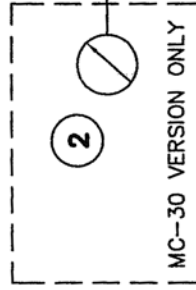
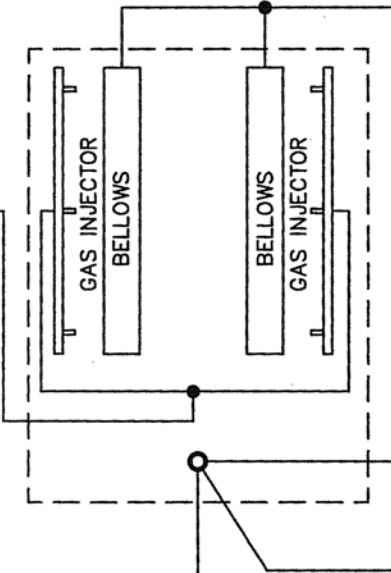


007-0018

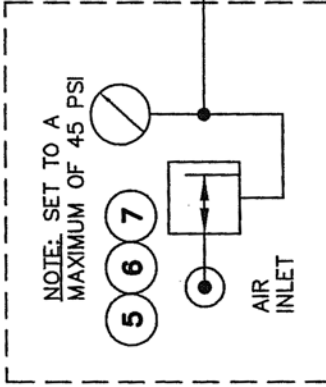
ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	1
2	114-0260	VACUUM GAUGE	1
3	106-0070	BELLOWS VALVE	1
4	106-0030	ATMOSPHERE VALVE	1
5	114-0147	PRESSURE REGULATOR	1
6	114-0245	PRESSURE GAUGE	1
7	114-0170	PRESSURE REGULATOR SUPPORT	1
8	114-2020	DRYER FILTER	1



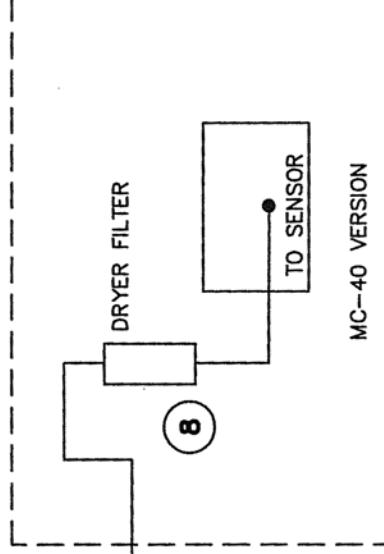
NOTE: FOR GAS INJECTION
OPTION KIT INSTALLATION
SEE DRAWING #:
450A: #010-0029
550A: #010-0013



NOTE: SET TO A
MAXIMUM OF 45 PSI

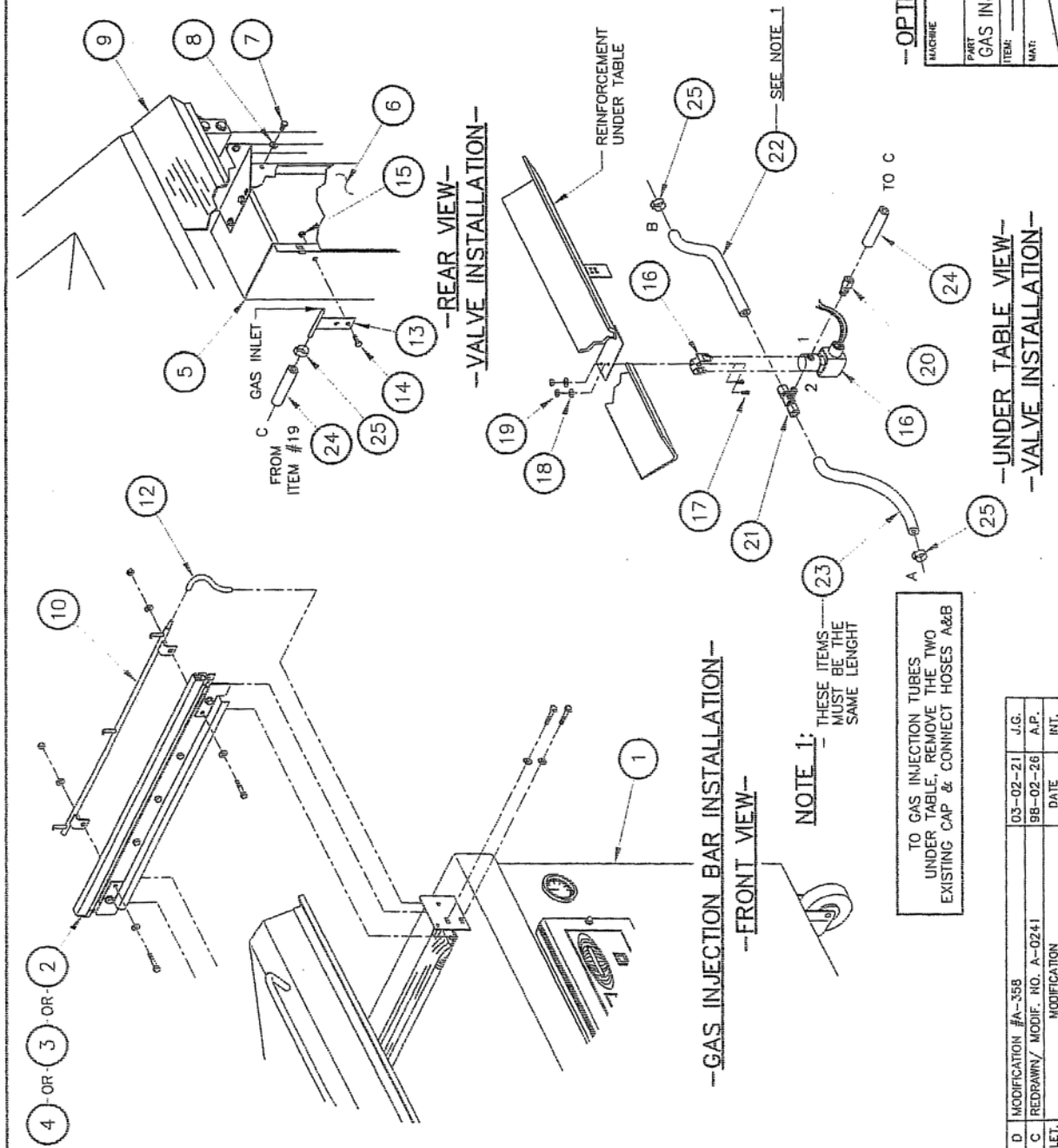


NOTE: FOR AIR REGULATOR
OPTION KIT INSTALLATION
SEE DRAWING #:
450A: #010-0033
550A: #010-0033



MACHINE		450A & 550A		SIPROMAC	
PART		PNEUMATIC DRAWING		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:	CNC:	SCALE:	QT.	1	
MAT:	DWG BY	M.L. VIGNE	DATE	97-03-12	NO.
LET.	RE-DRAWN	MODIFICATION	DATE	06-11	007-0018

ITEM	PART #	DESCRIPTION	QTY.
1	005-0338	MACHINE ASSEMBLY FRONT VIEW	1
2	005-0568	SEAL BAR ASSY W/ SUPPORT	2
3	005-0569	SEAL BAR ASSY W/ SUPPORT (BAG CUT OPT.)	2
4	005-0570	SEAL BAR ASSY W/ SUPPORT (T & B OPT.)	2
5	005-0347	ELECTRICAL BOX ASSEMBLY	1
6	004-0273	ELECTRICAL BOX COVER PRE-ASSY	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4" S/S	4
9	005-0339	MACHINE ASSEMBLY REAR VIEW	1
10	005A0810	GAS INJECTION BAR ASSEMBLY (OPTION)	1
11	005-0571	GAS INJECTION BAR ASSEMBLY (OPTION)	1
12	008-0464	GAS INJECTION CONN. TUBE (OPTION)	2
13	005-0323	GAS INLET ASSEMBLY	1
14	051-0180	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S (OPTION)	1
15	051-0580	HEX. NUT 1/4"-20 NC. S/S (OPTION)	1
16	106-0010	SELENOIDE VALVE 2 WAY 1/4" NPT W/ SUPP.	1
17	051-0100	SCREW #8-32 X 3/8" PAN PHILL. S/S	2
18	051-0720	FLAT WASHER #8 S/S	2
19	051-0550	HEX. NUT #8 S/S	2
20	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	1
21	101-0065	"T" 3/8" T.P.COMP. X 1/4" MNPT X 3/8" T.P.COMP.	1
22	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm LG.	4
23	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm LG.	2
24	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm LG.	1
25	105-0200	COLLARS 3/8"	3



NOTE 2: PARTS 1 THRU 9 ARE EXISTING PARTS
PARTS 10 THRU 25 PARTS SUPPLIED W/ KIT

-OPTION GAS INJECTION-

MACHINE	550A	SIPROMAC
PART	GAS INJECTION KIT INSTALLATION	ST-GERMAIN DE GRANTHAM
ITEM		QUEBEC CANADA
MAT:		
DATE	98-02-26	
APP.	L.T.	
QTY.	1	
NO.	010-0013	

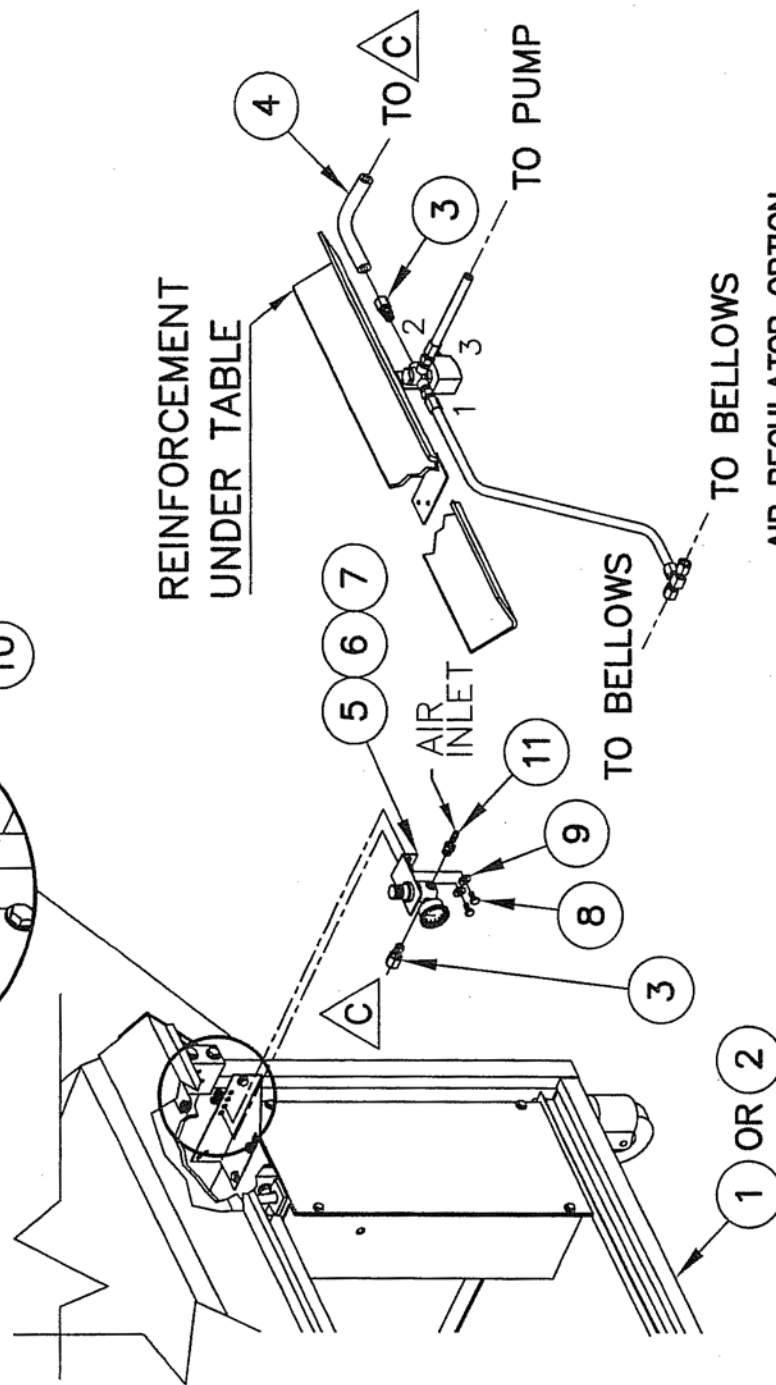
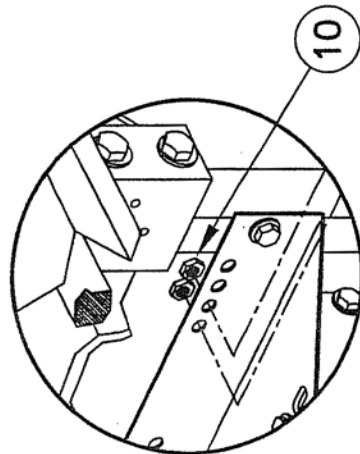
-UNDER TABLE VALVE INSTALLATION-

TO GAS INJECTION TUBES UNDER TABLE, REMOVE THE TWO EXISTING CAP & CONNECT HOSES A&B

MODIFICATION #A-358	03-02-21	J.G.
REDRAWN/ MODIF. NO. A-0241	98-02-26	A.P.
LET.	DATE	INT.

010-0033

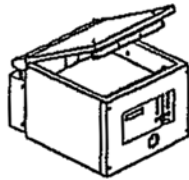
ITEM	PART #	DESCRIPTION	QT.
1	005-0411	REAR VIEW MACHINE ASSEMBLY	1
2	005-0339	REAR VIEW MACHINE ASSEMBLY	1
3	101-0036	STRAIGHT 1/4" MNPT x 3/8" T.P. COMP	2
4	104-0060	TUBE 3/8" OD x 1/4" ID (POLY) x mm LG.	2
5	114-0147	PR. REG. 0-60 PSI 1/4" NPT	1
6	114-0245	PR. GAUGE 0-60 PSI 1/8" NPT	1
7	114-0170	PRESSURE REGULATOR SUPPORT	1
8	051-0144	SCREW 10-24 x 1/2" PAN PHIL SS	2
9	051-0730	WASHER #10 FLAT S/S	2
10	051-0572	NUT #10-24 NYLON LOCK SS	2
11	101-0200	STRAIGHT 1/4" MNPT x 1/4" HOSE BARB	2



-AIR REGULATOR OPTION-

MACHINE		450A & 550A		SIPROMAC	
PART		AIR REGULATOR OPTION KIT INSTALLATION		ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM:		CNC:		SCALE: M-E QT. 1	
MAT:		DATE 97-10-07		NO. 010-0033	
DATE		DATE 05-06-20			
MODIFICATION					
B	051-0144 WAS 051-0100, 051-0572 WAS 051-0560	05-05-05	M.A.L.		
A	051-0100 WAS 051-0147, 051-0560 WAS 051-0572	05-03-23	M.A.L.		
LET.		DATE	INT.		

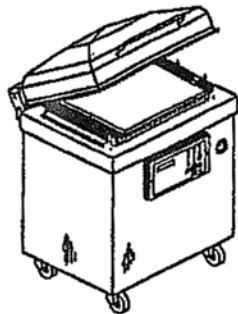
VACUUM PACKAGING MACHINES



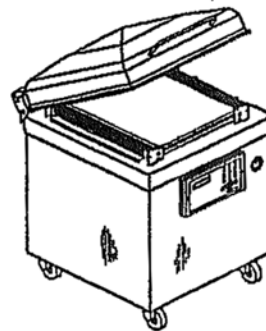
250



350/350D



450A



550A