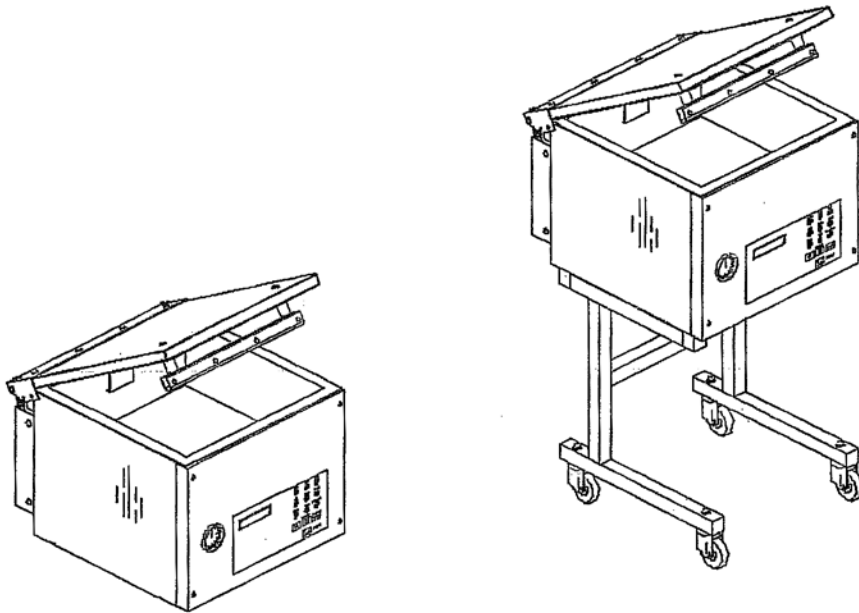




# VACUUM PACKAGING MACHINE

## MODELS 350 & 350D

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



## OWNERS MANUAL



## IMPORTANT SAFETY INSTRUCTIONS

### SAVE THESE INSTRUCTIONS



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

#### **General Operation**

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

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

## **Service**

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

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



### Warning-Your responsibility:

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

## **INSTALLATION NOTICE FOR MODELS:**

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

### IN ORDER TO RESPECT NSF REGULATIONS:

The table on which the machine has to be installed, should be of open frame type, to avoid dirt accumulation, and to allow easy cleaning under the machine.



VACUUM PACKAGING MACHINE

**MODEL 350, 350D**

**(MC-40)**

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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.

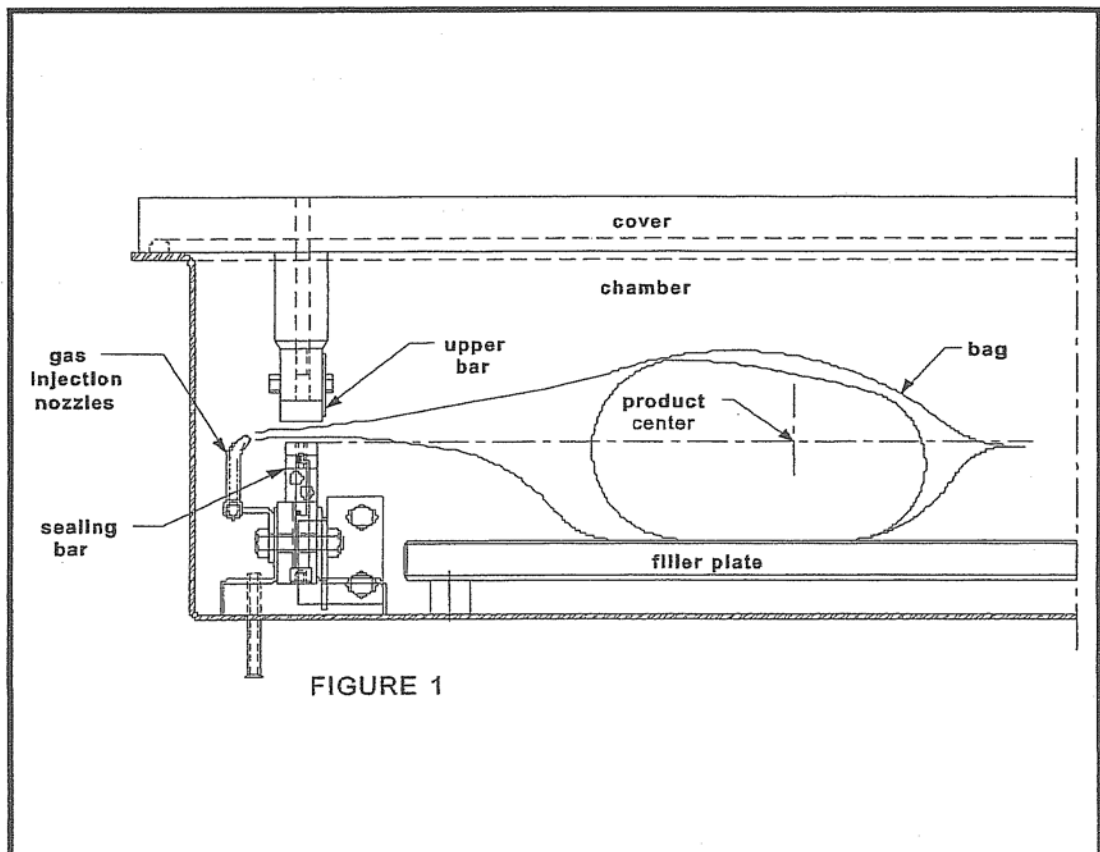
### **3.OPERATION:**

#### **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 13 and the keyboard detail on page 14.

### **3.3.1 Basics:**

Use key "POWER" to power ON / OFF the vacuum packaging machine. When the unit is energized, the identification of the last executed program is displayed on LCD screen. To disconnect, use the "POWER" key to turn off the machine , then remove plug from outlet. Do not unplug by pulling on cord. To unplug, grasp the plug, not the cord. Unplug from outlet when not in use and before servicing or cleaning.

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

In functions menu, use key "SELECT" to select a function and key "ENTER" to accede and executed the selection.

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

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

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

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

### **3.3.2 Functions menu:**

#### **3.3.2.1 Create a program:**

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

#### **3.3.2.2 Delete a program:**

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

#### **3.3.2.3 Select operating mode:**

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

### **3.3.3 Programs menu:**

#### **3.3.3.1 Program identification:**

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

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

### **3.3.3.2 Vacuum time setting (sensor disabled):**

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

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

### **3.3.3.3 Vacuum level setting (sensor enabled)**

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

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

### **3.3.3.4 Vacuum plus time setting (sensor enabled)**

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

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

### **3.3.3.5 Gas time setting (sensor disabled)**

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

### **3.3.3.6 Gas flush level setting: (sensor enabled)**

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

### **3.3.3.7 Sealing time setting:**

For a selected program set the sealing, starting with the seconds; the decimal point is automatically inserted following the first digit entry and the validation is automatically performed following the third digit entry (the new sealing time is blinking). The sealing time is truncated to the nearest half hundredth. In a middle of an acquisition, use key "ENTER" to validate the sealing time and key "ESC" to come backward and start over with a new acquisition (the old sealing time is blinking).

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

### **3.3.4 Vacuum cycle execution:**

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

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

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

### **3.3.5 System monitor:**

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



## -MENUS STRUCTURE-

- **Functions menu:**
  - "F1 CREATE A PRGM"
  - "F2 DELETE A PRGM"
  - "F3 SELECT OPMODE" (automatic units only)
- **Programs menu:**
  - "Pxx NAME"
  - Program submenu:
    - "VACUUM: xx.x%" (10.0% - 99.5%)
    - "VACUUM PLUS: xxs" (0s - 99s)
    - "VACUUM: xx.xs" (10 - 199s) (sensor disabled in D8 menu)
    - "GAS FLUSH: xx.xs" (0 - 99s) (units with gas option) (sensor disabled in D8)
    - "GAS FLUSH: xx.x%" (0.0% - 10% below the vacuum level) (units with gas option)
    - "SEAL TIME: x.xxs" (0.00s - maximum unit allocated setting)
    - "Pxx NAME" (12 characters)
- **Diagnostics menu** (keys "ESC" & "POWER" for access):
  - "DIAGNOSTICS MENU" (access code required)
  - "D1 INPUTS TEST"
  - "D2 OUTPUTS TEST"
  - "D3 MODEL SELECT"
  - "D4 GAS OPTION"
  - "D5 SEALING TIME"
  - "D6 COOLING TIME"
  - "D7 OFFSET CALIB"
  - "D8 VACUUM SENSOR"
  - "D9 SIPROMAC PUB"
  - "D10 LOADING TIME" (automatic units only)
  - "D11 UNLOADNG TIME" (automatic units only)
  - "SYSTEM MONITOR" (no access code required)
  - "SOFTWARE: R x.xx"
  - "WORK HRS: xxxxx"
  - "CYCLES: xxxxxxxx"

# -KEYBOARD DETAILS-

## MC-40 CONTROLS





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

### **3.4 Daily cleaning**

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

**Cleaning instructions for gas injection nozzles:** Periodically on a regular basis the gas injection nozzles must be removed with the connection tube and soaked in a food grade soap and water solution, then dried and re-installed.

## **4. TROUBLE SHOOTING:**

### **4.1 Failure during packaging cycle:**

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

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

### **4.2 Insufficient vacuum:**

#### **4.2.1 Leakage in the bag:**

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

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

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

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

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

#### **4.2.2 No leakage in the bag:**

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

Vacuum time is too short:

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

#### **4.2.3 Insufficient vacuum in chamber:**

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

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

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

Verify at vacuum hose connections and valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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

### **4.3 Faulty seal:**

#### **4.3.1 Insufficient seal:**

Damaged teflon or silicone rubber.

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

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

#### **4.3.2 No seal:**

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contacting does not work.

#### **4.3.3 Permanent sealing current:**

Contacting is jammed check sealing transformer for damage through overload.

#### **4.3.4 Seal does not stick:**

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

### **4.4 Fault in the valve:**

Vacuum or air valve does not open.

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

#### **4.5 MC40 Control board failure**

NOTE: Refer to menu structure on page 13.

This board software is allowing access to a "Diagnostics Menu". Only qualified service technicians are authorized to access this menu by entering a security password.

By acceding either the "D1 input test" feature or the "D2 output test" feature, a trained technician will be able to quickly know the origin of the problem: pump, sealing system, pneumatic problem, security switches problem, etc...

Keep in mind that in most cases trouble is due to a leakage, loose electrical Keynesian or evident damage to the main component: vacuum pump, valves..., electrical contactors, thermal overload, fuses holder or transformer.

For assistance do not hesitate to contact your local service technicians.

#### **5. Regular maintenance:**

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

Check switch-point of micro switch, adjust if necessary.

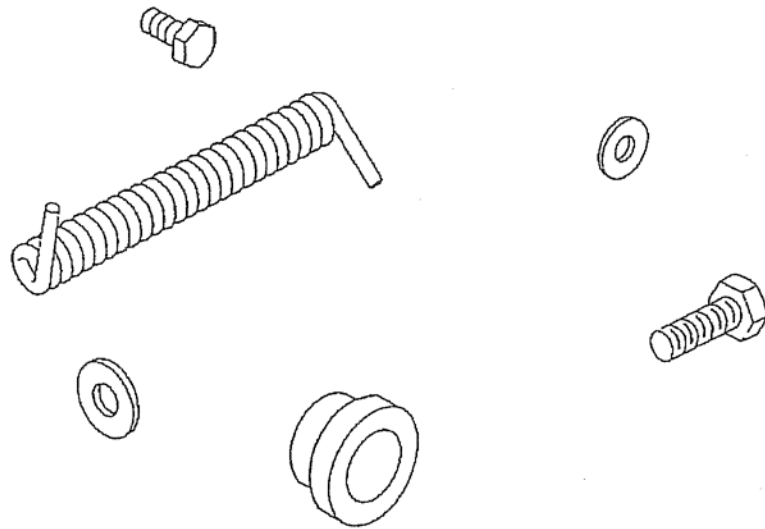
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

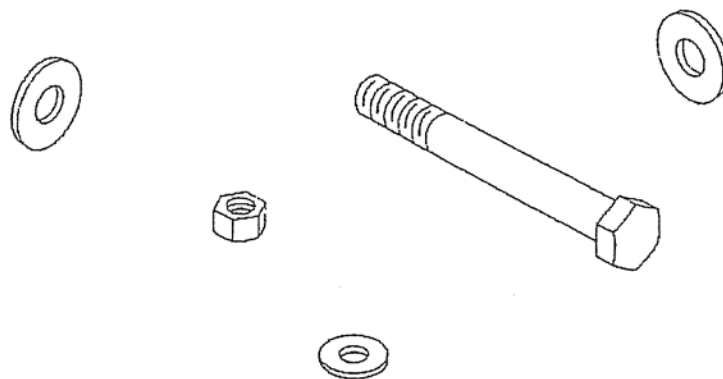
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

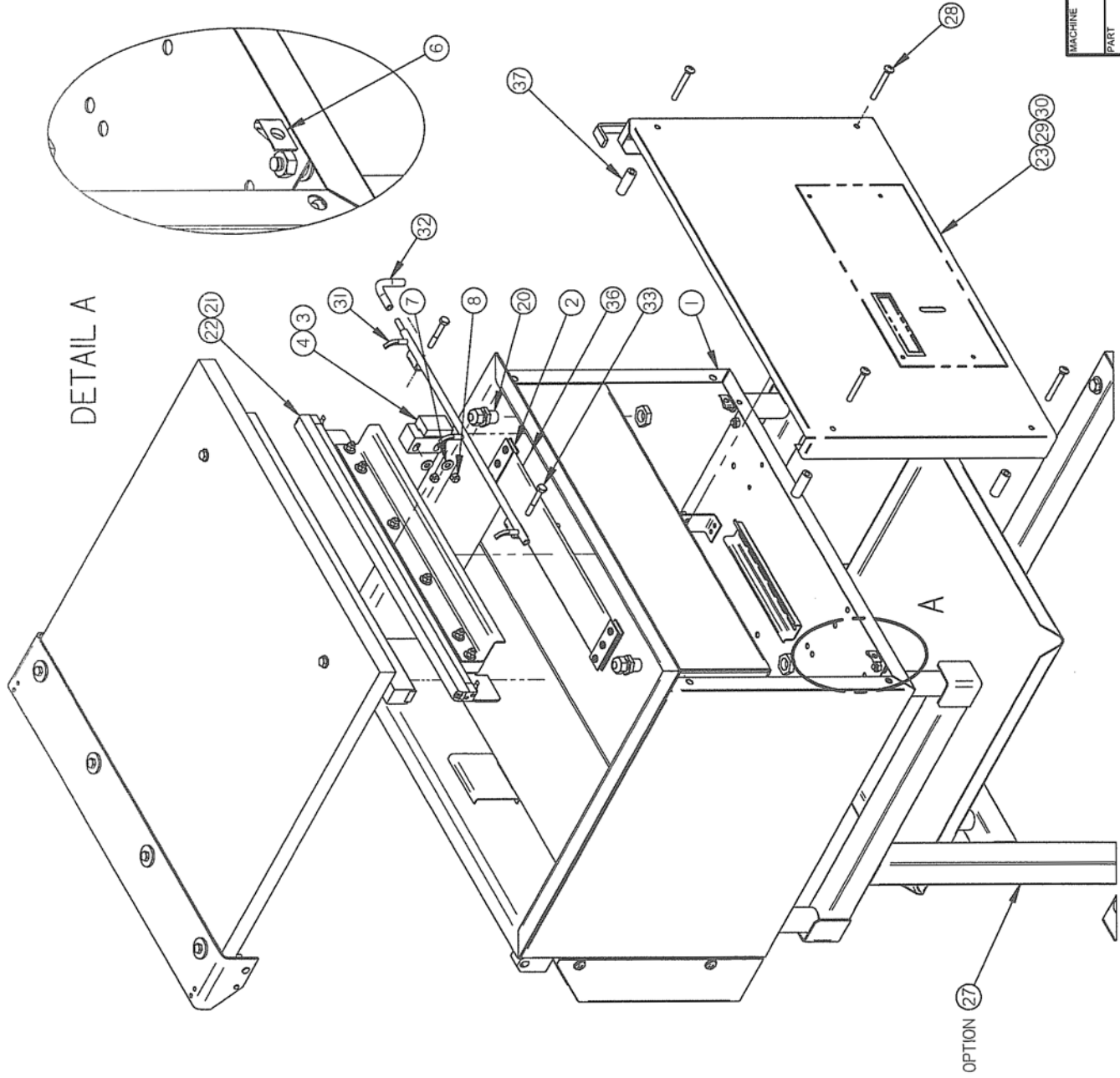
Check function of cycle with various settings of timers.



# MECHANICAL DRAWING

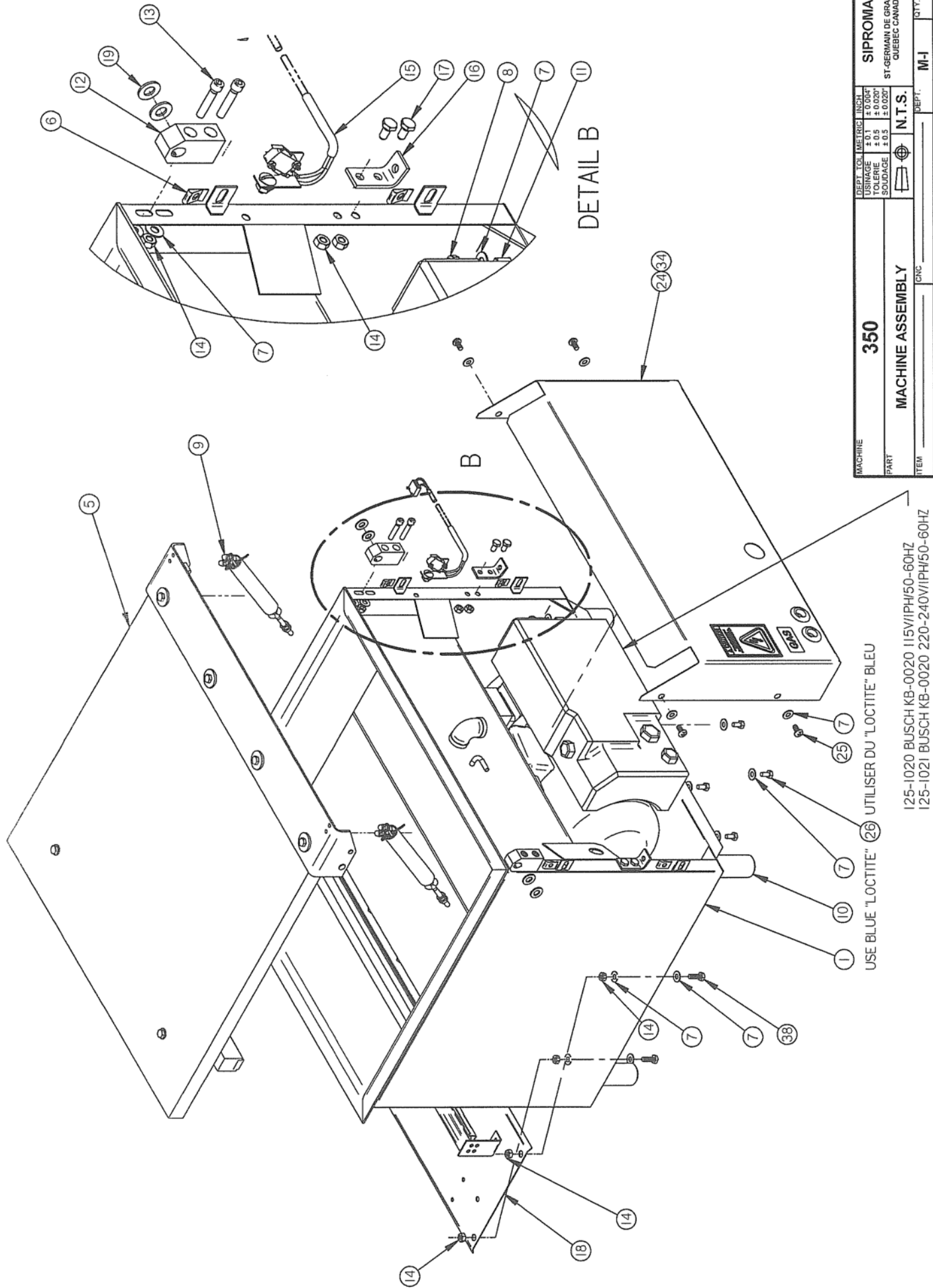


ITEM	PART #	DESCRIPTION	QT.
1	004A0229	VACUUM PRE-ASSEMBLY	1
2	005-0532	BELLOWS ASSEMBLY	1
3	002-0029	LEFT SEAL BAR GUIDE BLOCK	1
4	002-0030	RIGHT SEAL BAR GUIDE BLOCK	1
5	005A0266	COVER ASSMBLY	1
6	056-0020	SPRING NUT 1/4"-20 STEEL	8
7	051-0740	WASHER 1/4" FLAT S/S	28
8	051-0581	NUT 1/4"-20 NYLON LOCK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



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

REDESSINE MODIF. A-462 ETAIT AUSSI 005-0612 12-11-26 J.G.  
 DATE INT.  
 MODIFICATION

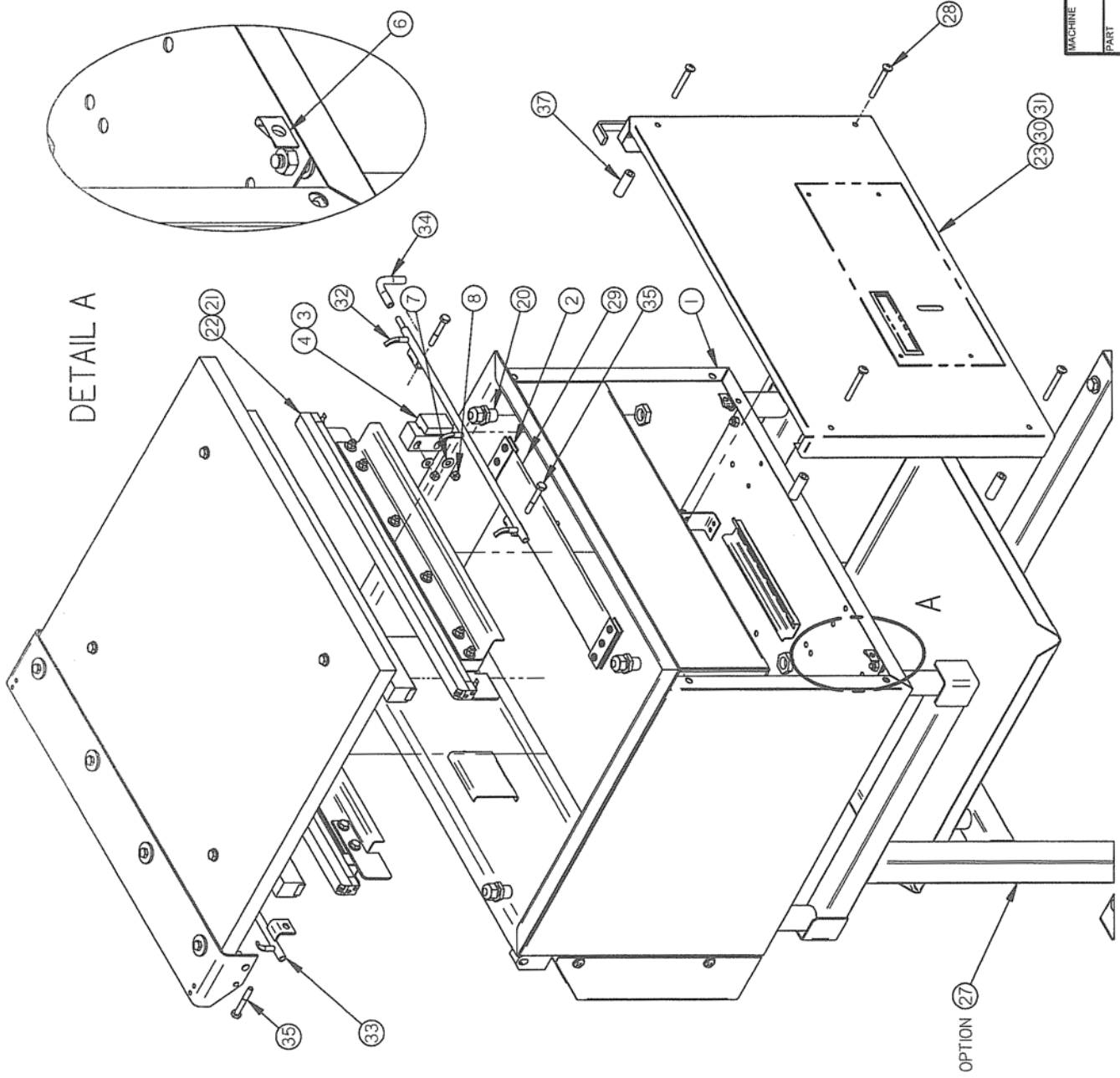


MACHINE	<b>350</b>		DEPT. TOI. METRIC INCH	± 0.1	± 0.004"
PART	MACHINE ASSEMBLY		USINAGE	± 0.5	± 0.020"
ITEM	CNC		TOLERIE	± 0.5	± 0.020"
MAT.	APP. BY J.G.		SOUDAGE	± 0.5	± 0.020"
	DATE 12-11-27	NO	N.T.S.		
			DEPT. M-I		
			QTY. 1		
			<b>005A0610</b>		

UTILISER DU "LOCTITE" (26)

125-1020 BUSCH KB-0020 115V/1PH/50-60HZ  
 125-1021 BUSCH KB-0020 220-240V/1PH/50-60HZ

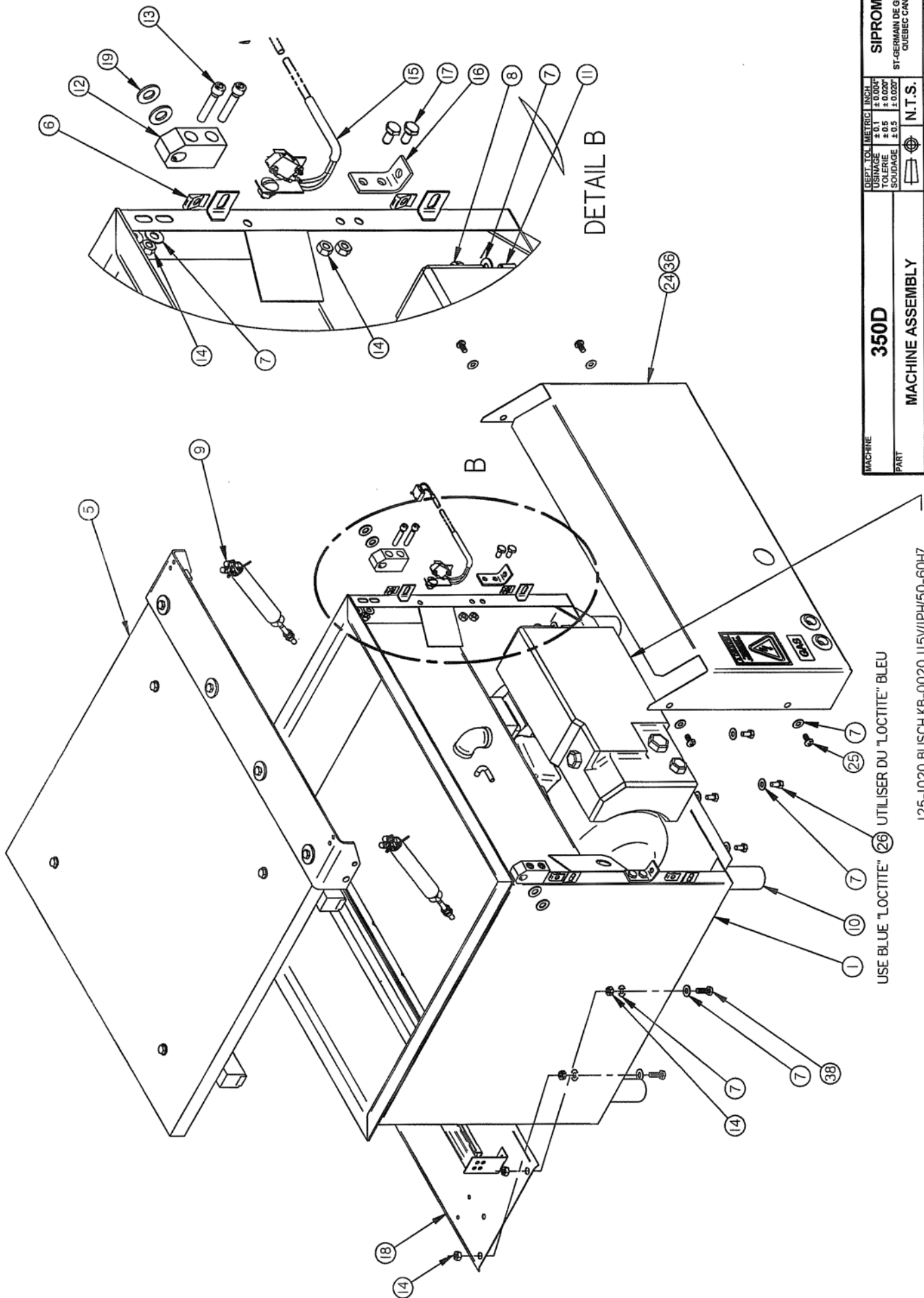




ITEM	PART #	DESCRIPTION	QT.
1	004A0230	VACUUM PRE-ASSEMBLY	1
2	005-0532	BELLOWS ASSEMBLY	1
3	002-0029	LEFT SEAL BAR GUIDE BLOCK	2
4	002-0030	RIGHT SEAL BAR GUIDE BLOCK	2
5	005A0481	COVER ASSEMBLY	1
6	056-0020	SPRING NUT 1/4"-20 STEEL	8
7	051-0740	WASHER 1/4" FLAT S/S	32
8	051-0581	NUT 1/4"-20 NYLON LOCK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

MACHINE		DEPT. TOL. METRIC INCH	SIPROMAC
PART		USINAGE ± 0.1 ± 0.004	ST-GERMAIN DE GRANTHAM
ITEM		TOLERANCE ± 0.5 ± 0.0027	QUEBEC CANADA
MAT.		SOUDAGE ± 0.5 ± 0.0027	
MACHINE ASSEMBLY		N.T.S.	
DATE	DATE	DEPT.	QTY.
12-11-27	12-11-27	M-1	1
APP. BY	DATE	NO. 005A0611	
J.G.			

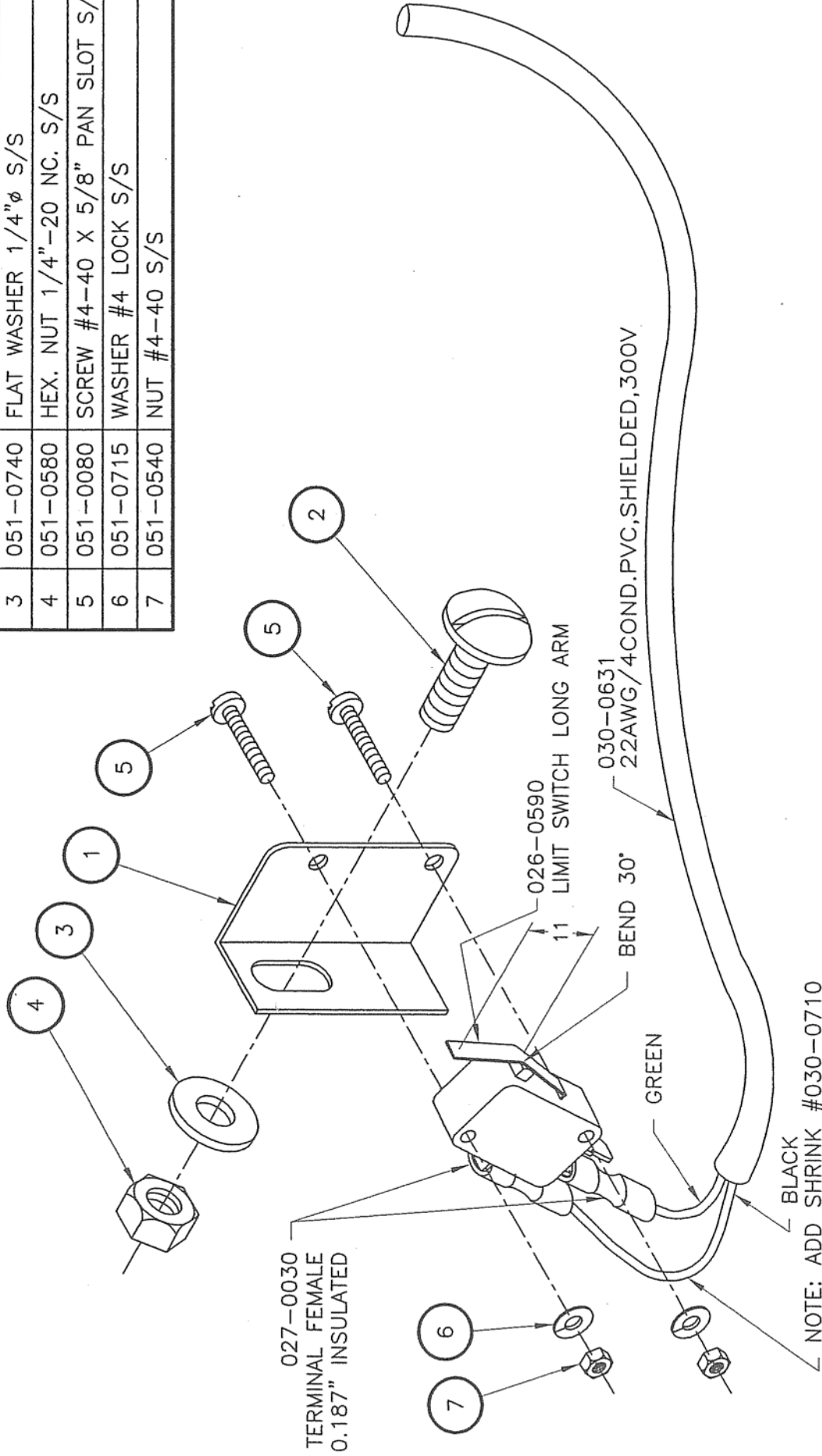
LET.	A	REDESSINE MODIF. A-462 ETAIT AUSSI 005-0613	12-11-26	J.G.
		MODIFICATION	DATE	INT.



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

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

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" 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

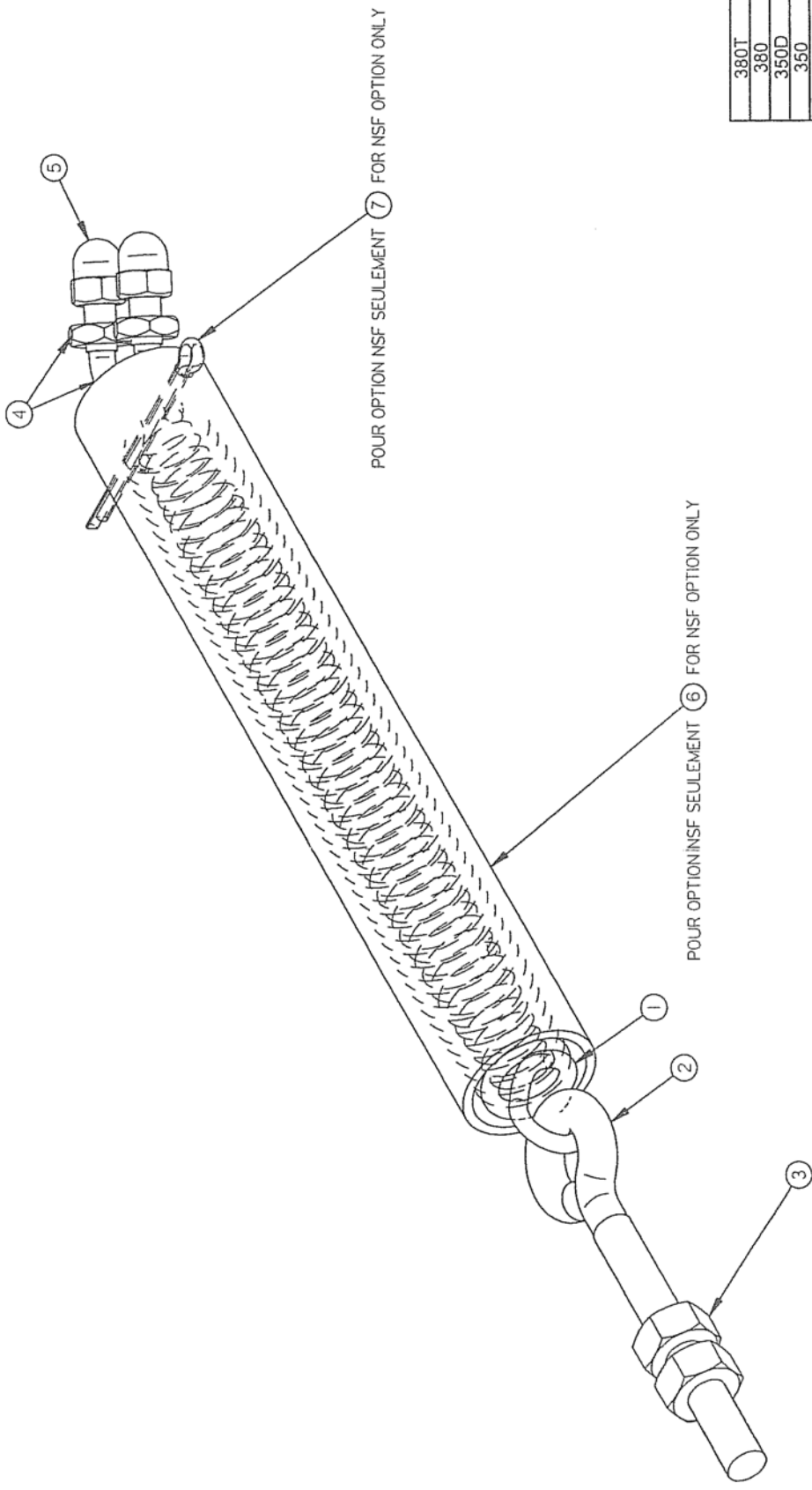


NOTE: ADD SHRINK #030-0710

MACHINE	250, 350, 350D, 380 & 380T	MACHINE	250, 350, 350D, 380 & 380T
PART		LIMIT SWITCH ASSEMBLY	
ITEM:		CNC:	
MATERIAL:		DATE 97-11-11	
DRAWN BY: M. LAVIGNE		NO. 004-0261	
DATE 97-11-11		DEPT. M-1	
APP.		QT. 1	
MODIFICATION		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA	
DATE 97-11-11		SIPROMAC	
INT.		TOLERANCE	
		.0 ± .015"	
		.0 ± .005"	
		.000 ± .0005"	
		N.T.S.	
		METRIC TOLERANCE	
		0. ± .5	
		0. ± .05	
		.00 ± .005	
		.000 ± .0005	
		ANGLE ± 1'	
G A&R 300 & 300D SEE 004A3374 / 030-0631 WAS 030-0610		10-11-16 D.A.	
F #2 051-01865 TRUSS SLOT WAS 051-0180 HEX		10-11-10 D.A.	
E AJ OUTER 300D		06-05-24 M.A.L.	
D AJ OUTER 380T		06-01-26 M.A.L.	
C AJ OUTER 380		03-02-12 Y.C.	
B ADDED 300		98-05-22 D.A.	
A REDRAWN		97-11-11 M.L.	
LET.		DATE	
MODIFICATION		INT.	

# 004A1224

ITEM	PART #	DESCRIPTION	QT.
1	009A0152	SPRING BLACK	1
2	056-0150	EYE BOLT 1/4"-20 x 3" ZINC	1
3	051-0580	NUT 1/4"-20 S/S	2
4	056-2500	U-BOLT CABLE CLAMP THRD #10-24	1
5	051-0570	NUT #10-24 ACORN SS	2
6	008A1603	SPRING PROTECTION TUBE	1
7	056-0118	COTTER PIN 3/32" x 1" S/S	1



POUR OPTION NSF SEULEMENT (7) FOR NSF OPTION ONLY

POUR OPTION NSF SEULEMENT (6) FOR NSF OPTION ONLY

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

MACHINE		DEPT. TOL. METRIC INCH
300, 350, 350D 380 & 380T	USURAGE ± 0.1	± 0.004
PART	TOLERIE ± 0.5	± 0.020"
SPRING PRE-ASSEMBLY	SOUDEAGE ± 0.5	± 0.020"
ITEM	DEPT.	N.T.S.
DATE 03-02-17	NO	004A1224
APP. BY		

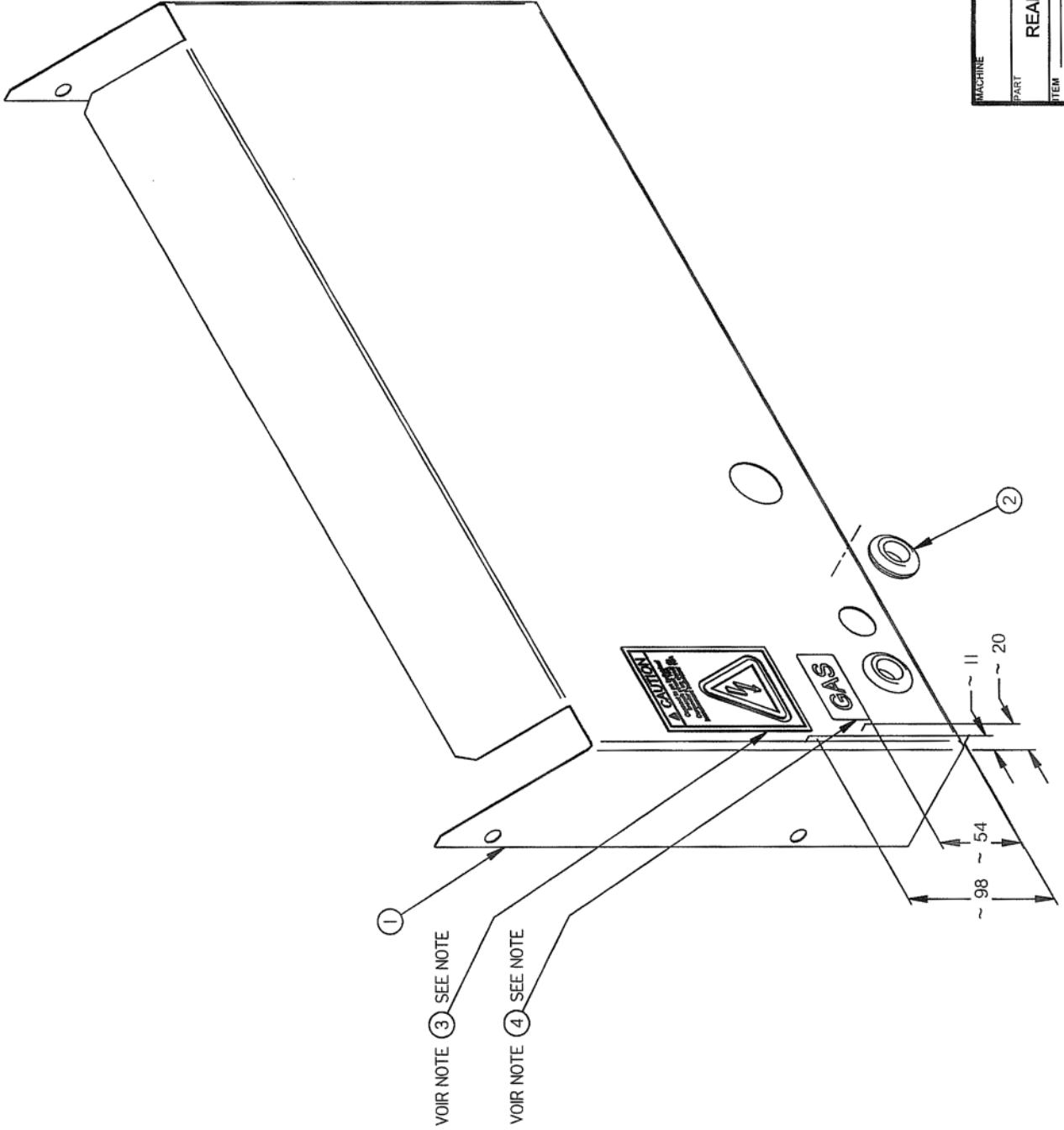
LET.	MODIFICATION	DATE	INT.
E	AJOUTER ITEM 008A1603 & 056-0118 (NSF)	10-11-09	J.G.
D	ADDED ITEM #3 051-0580 QTY : 2	05-05-05	M.A.
C	ADDED 380T	05-02-03	M.A.
B	009A0152 WAS 077-0002	04-12-07	M.A.
A	AJOUTER 380 DANS CARTOUCHE	03-09-04	J.P.

**004A0361**

ITEM	PART #	DESCRIPTION	QT.
1	001A0565	REAR PANEL	1
2	036-0200	GROMMET 5/8"IDx1 1/8"OD RUBBER	2
3	127-0115	STICKER ELEC. CONN. 15A 2-1/2" X 3-3/4"	1
4	127-0041	STICKER " GAS " YELLOW/BLACK 1" x 2"	1

127-0120 POUR 350D / 127-0120 FOR 350D

"GAS FLUSH" OPTION SEULEMENT / GAS FLUSH OPTION ONLY



VOIR NOTE ③ SEE NOTE

VOIR NOTE ④ SEE NOTE

**PART NUMBERS**  
 - FOR 350 USE **004A0361.350**  
 - FOR 350D USE **004A0361.350D**

**NOTE:**

-FOR AIR REGULATOR / SOFT AIR OPTION  
 USE # 004B3857 REAL PANEL

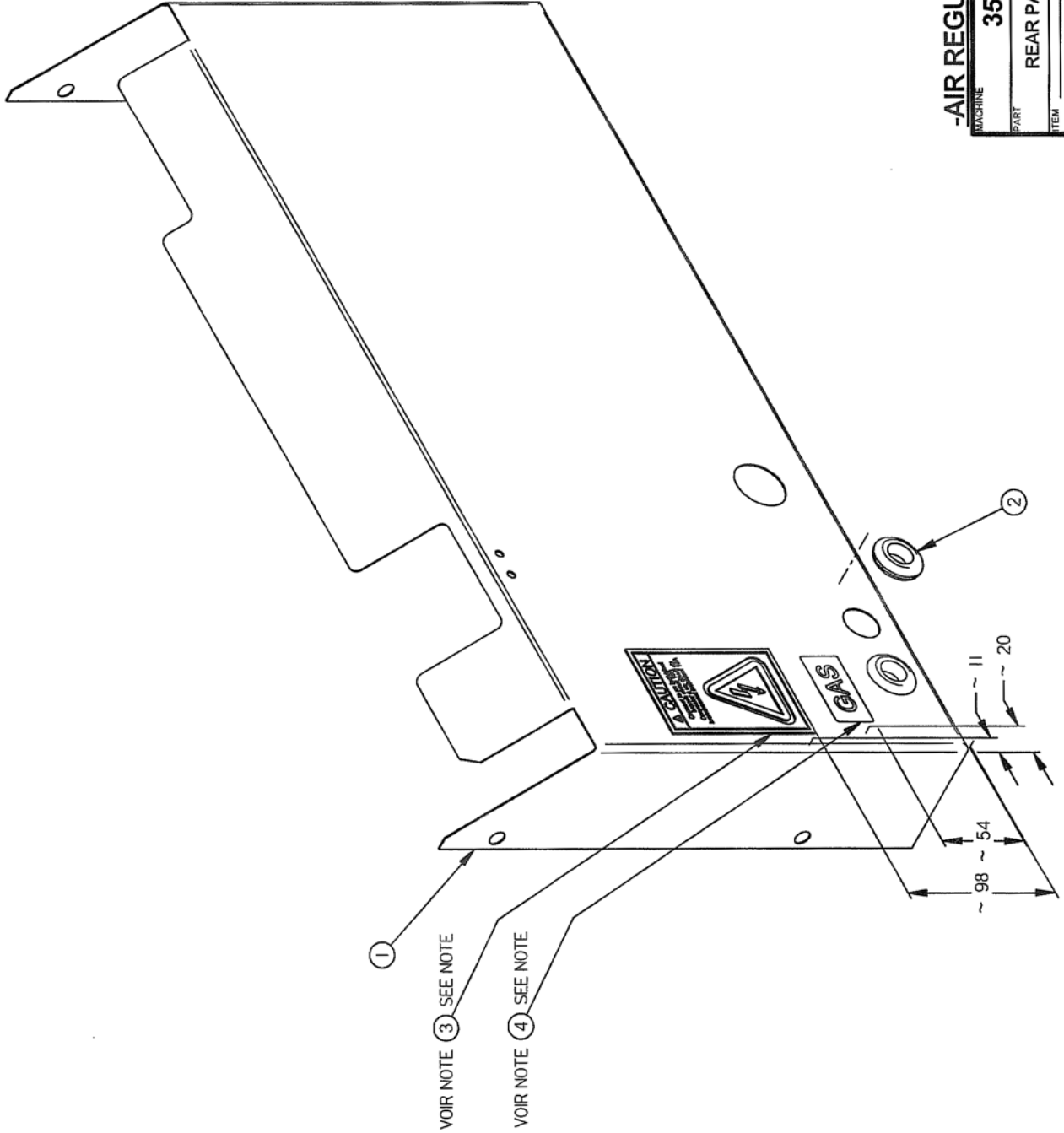
MACHINE	350 & 350D		DEPT. 101	M.I.C.	NO	004A0361
PART	REAR PANNEL PRE-ASS'Y		USINAGE ± 0.1	F O S	DATE	12-10-15
ITEM			SOLDERIE ± 0.025	N.T.S.	APP. BY	J.G.
MAT.			SOUDAGE ± 0.3		DATE	12-10-15
					DEPT.	M-I
					QTY.	1

F	REDESSINE MODIF. #A-462 (+60mm)	12-10-15	J.G.
LET.	MODIFICATION	DATE	INT.

**004B3857**

ITEM	PART #	DESCRIPTION	QT.
1	001B6141	REAR PANNEL	1
2	036-0200	GROMMET 5/8"IDx1 1/8"OD RUBBER	2
3	127-0115	STICKER ELEC. CONN. 15A 2-1/2" X 3-3/4"	1
4	127-0041	STICKER " GAS " YELLOW/BLACK 1" x 2"	1

127-0120 POUR 350D / 127-0120 FOR 350D  
"GAS FLUSH" OPTION SEULEMENT / GAS FLUSH OPTION ONLY



**PART NUMBERS**

- FOR 350 USE **004B3857.350**

- FOR 350D USE **004B3857.350D**

**NOTE:**

-FOR STD REAR PANNEL  
USE # 004A0361

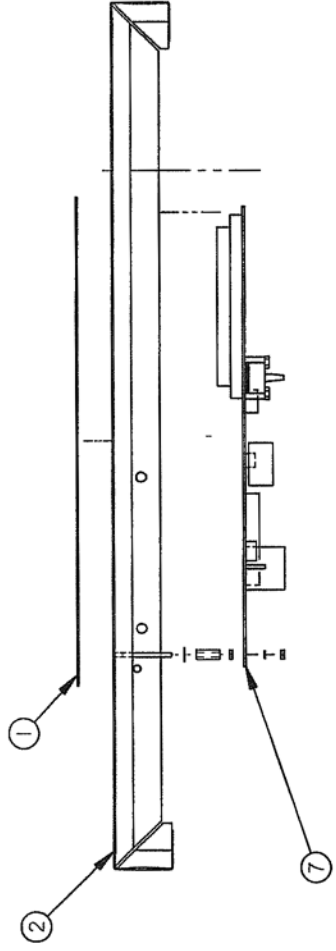
**-AIR REGULATOR/ SOFT AIR OPTION -**

MACHINE	DEPT. 101 METRIC INCH		
PART	USINAGE ± 0.1	TOLERANCE ± 0.004	SIPROMAC
ITEM	COLONNE ± 0.3	± 0.007	ST-GERMAIN DE GRANTHAM
MAT.	SOUDEUSE ± 0.3	± 0.007	QUEBEC CANADA
			N.T.S.
	CHC	DEPT.	M-I
	DATE 12-10-15	NO	004B3857
	APP. BY J.G.	DATE	

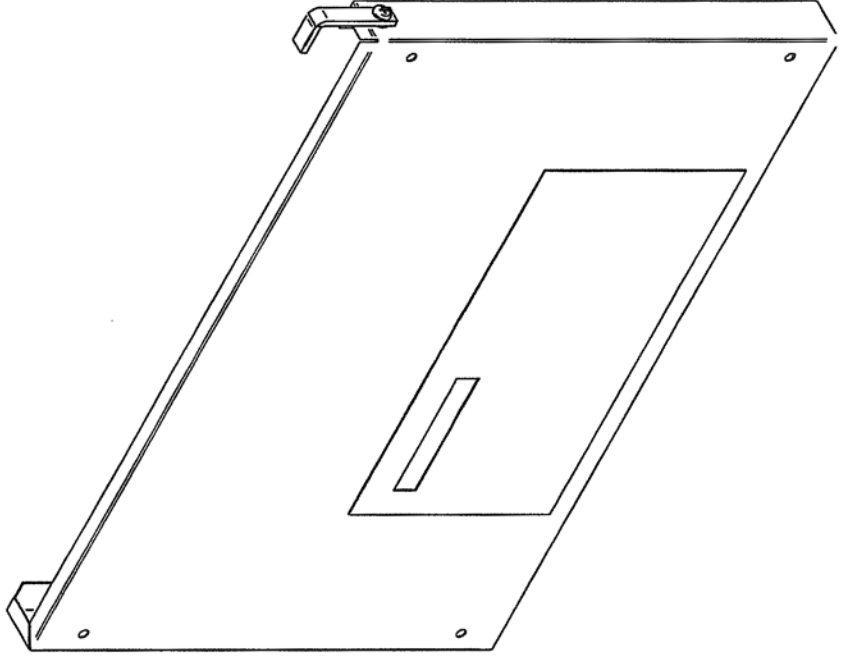
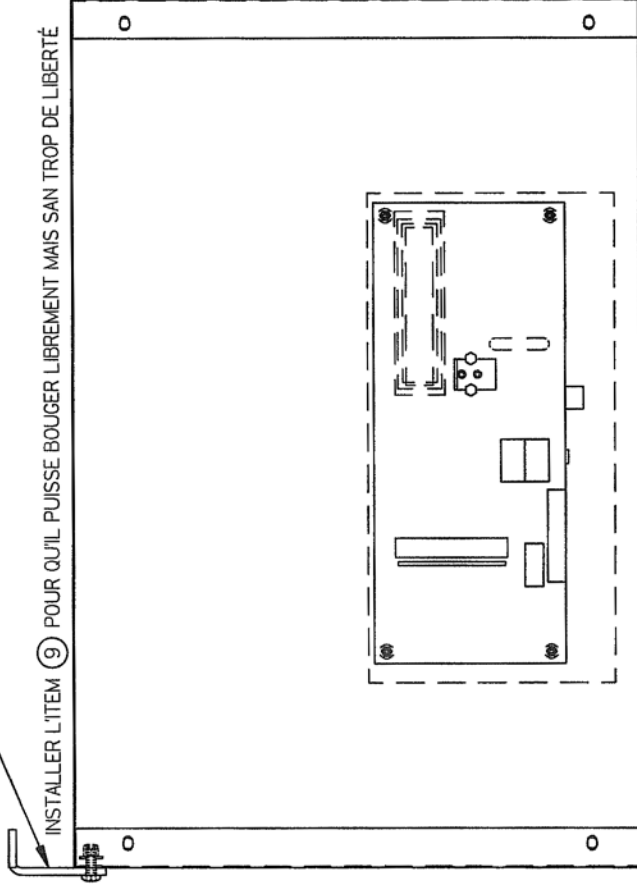
A	REDESSINE MODIF. #A-462 (+60mm)	12-10-15	J.G.
LET.	MODIFICATION	DATE	INT.

1005C0832

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



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



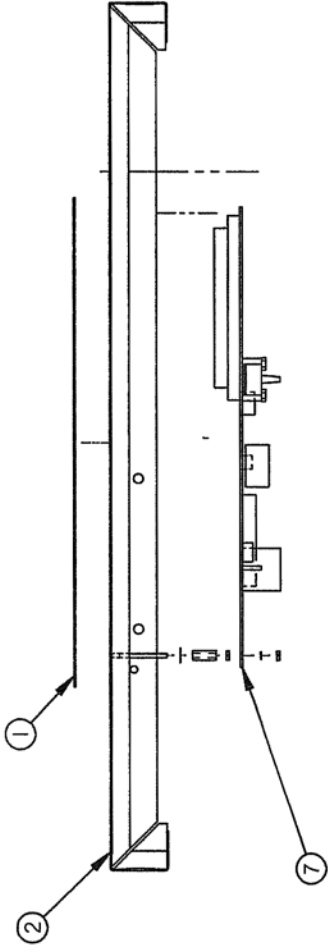
**-VACUUM SENSOR OPTION-  
-SIPROMAC OPTION -**

MACHINE		DEPT. LOC. METRIC INCH		SIPROMAC	
PART		USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		TOLERANCE ± 0.5	± 0.002"	QUEBEC CANADA	
MAT.		SOUDAGE ± 0.5	± 0.027"	N.T.S.	
FRONT PANEL ASSY W/VAC SEN (SI)		N.T.S.		DEPT. M-11	
350 & 350D		DATE 12-10-15		NO. 1	
DWG BY J.G.		DATE 12-10-15		NO. 1	
APP. BY		DATE 12-10-15		NO. 1	
REDESSINE MODIF. #A-462		DATE 12-10-15		NO. 1	
MODIFICATION		DATE 12-10-15		NO. 1	
LET. A		DATE 12-10-15		NO. 1	
REDESSINE MODIF. #A-462		DATE 12-10-15		NO. 1	
MODIFICATION		DATE 12-10-15		NO. 1	
LET. A		DATE 12-10-15		NO. 1	

005C0832

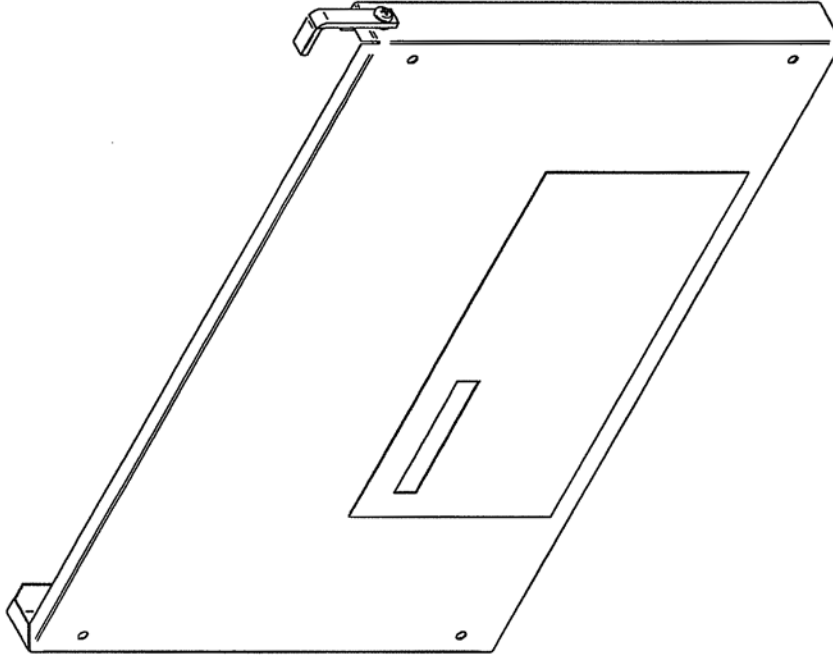
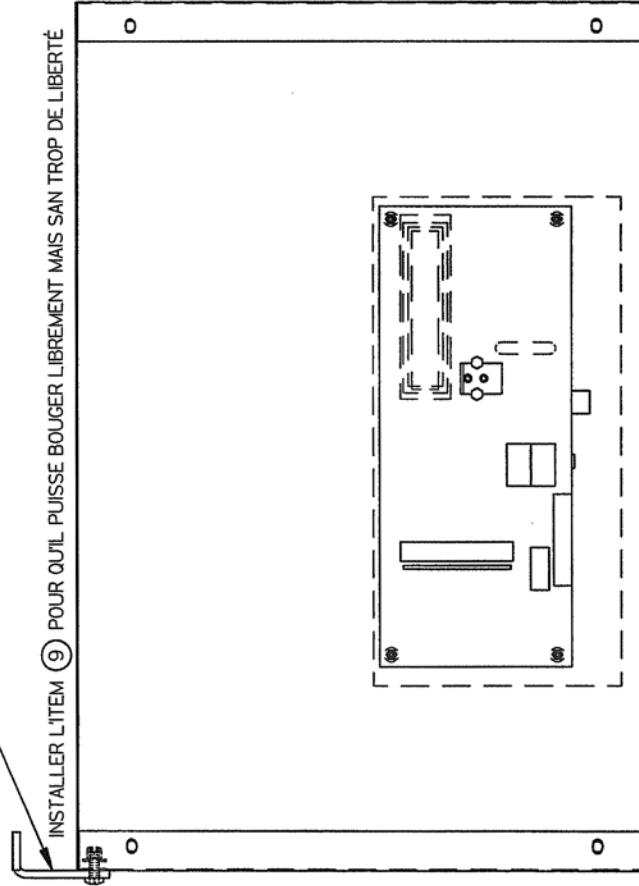
1005B1341

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



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

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



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

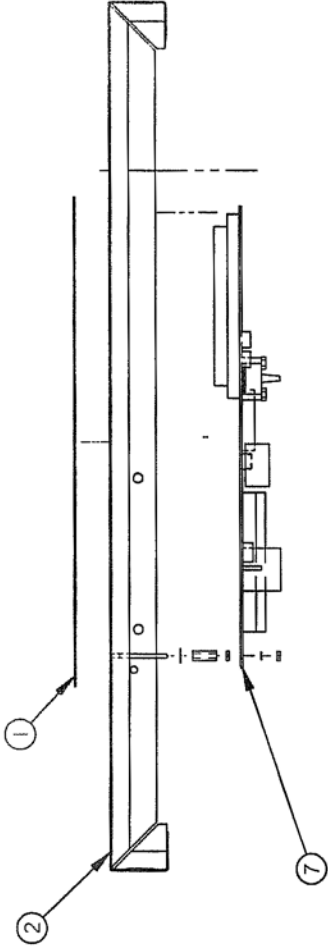
MACHINE	350 & 350D	DEPT. TOU	MMETRIC	INCH	USINAGE	± 0.1	± 0.004	SIPPROMAC
PART	FRONT PANEL ASSY WVAC SEN (BK)	TOLERANCE	± 0.5	± 0.020"	SOLDAGE	± 0.3	± 0.050"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM	CNC	DATE	12-10-15	NO.	N.T.S.	DEPT.	M-(M)-1	QTY.
APP. BY	J.G.	DATE	12-10-15	NO.				005B1341
REVISION		DATE		INT.				

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

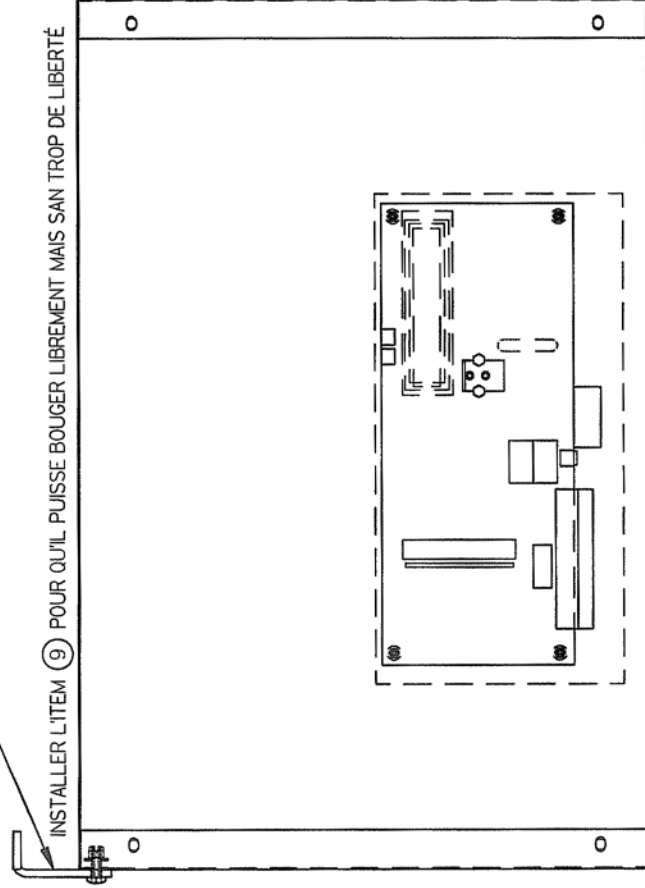


005B1339

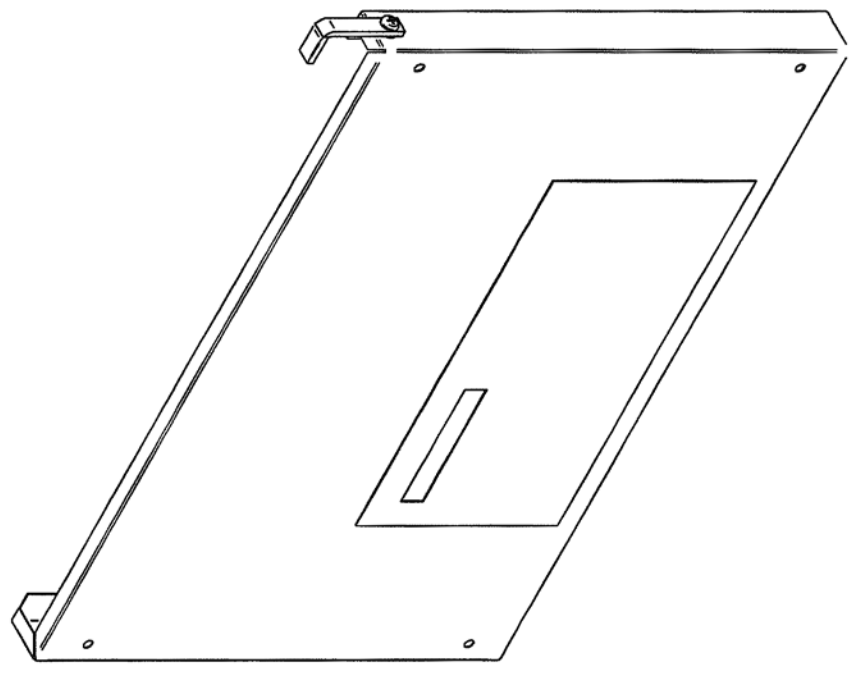
ITEM	PART #	DESCRIPTION	QT.
1	033-0019	MC-40 KEYBOARD "BSA"	1
2	001C3123	FRONT FLAT PANEL	1
3	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
4	051-0720	WASHER #8 FLAT S/S	4
5	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
6	051-0540	NUT #4-40 HEX S/S	8
7	033-0038	MC-40 SENSOR VACUUM	1
8	051-0715	WASHER #4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



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



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



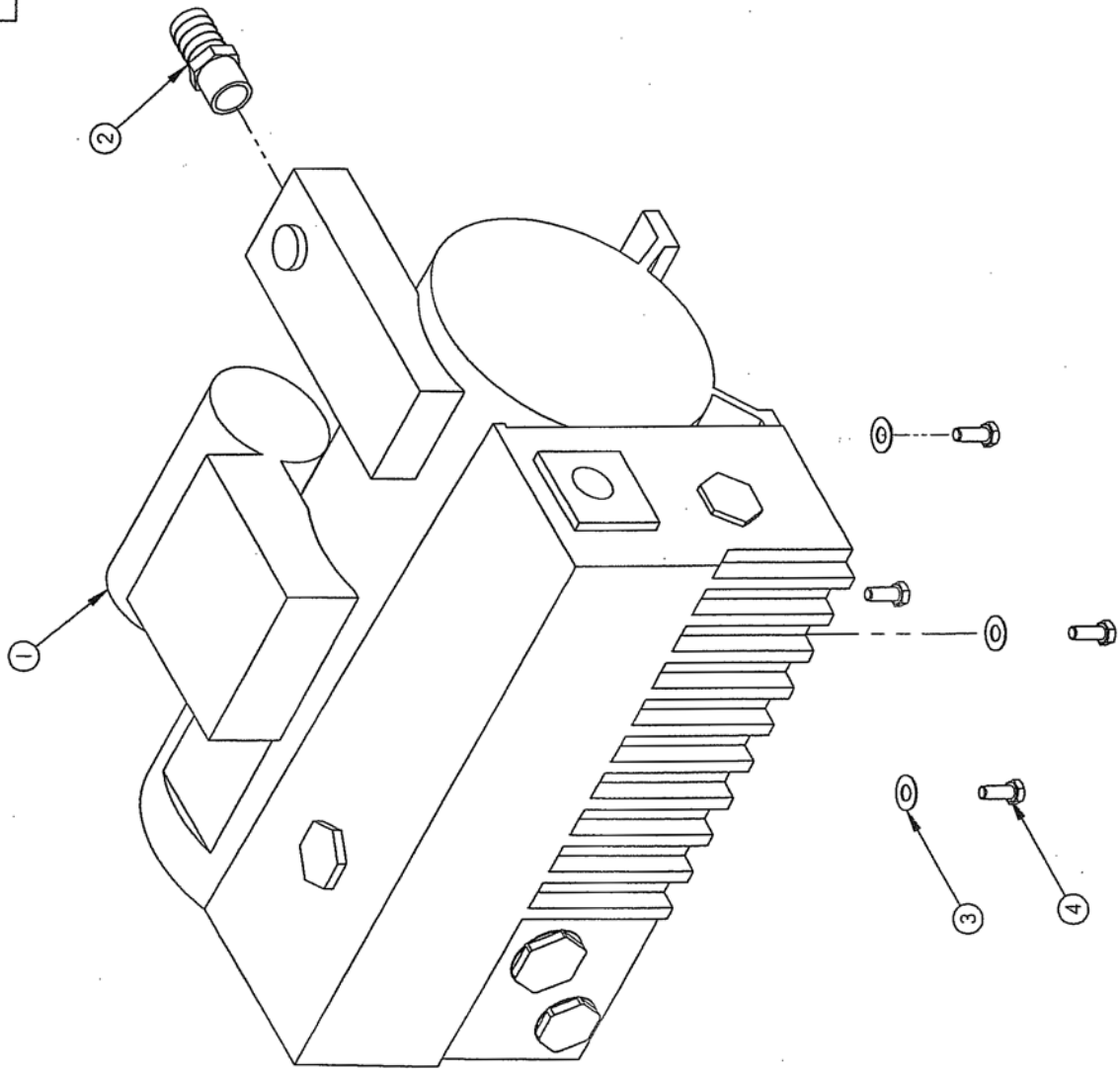
**-VACUUM SENSOR OPTION-  
-BSA OPTION -**

MACHINE		DEPT. TOL. METRIC INCH		SIPROMAC	
350 & 350D		USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
PART		TOLERIE ± 0.5	± 0.007"	QUEBEC CANADA	
FRONT PANEL ASS'Y W/VAC SEN (BSA)		SOUDAGE ± 0.5	± 0.007"	N.T.S.	
ITEM		CNC		DEPT.	
MAT.		DWG BY J.G.		M-(M)-1	
MODIFICATION		DATE 12-10-15		NO.	
A REDESSINE MODIF #A-462 ETAIT SANS VAC. SENSOR		DATE 12-10-15		J.G.	
LET.		DATE		INT.	
				005B1339	

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

1004-0346

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

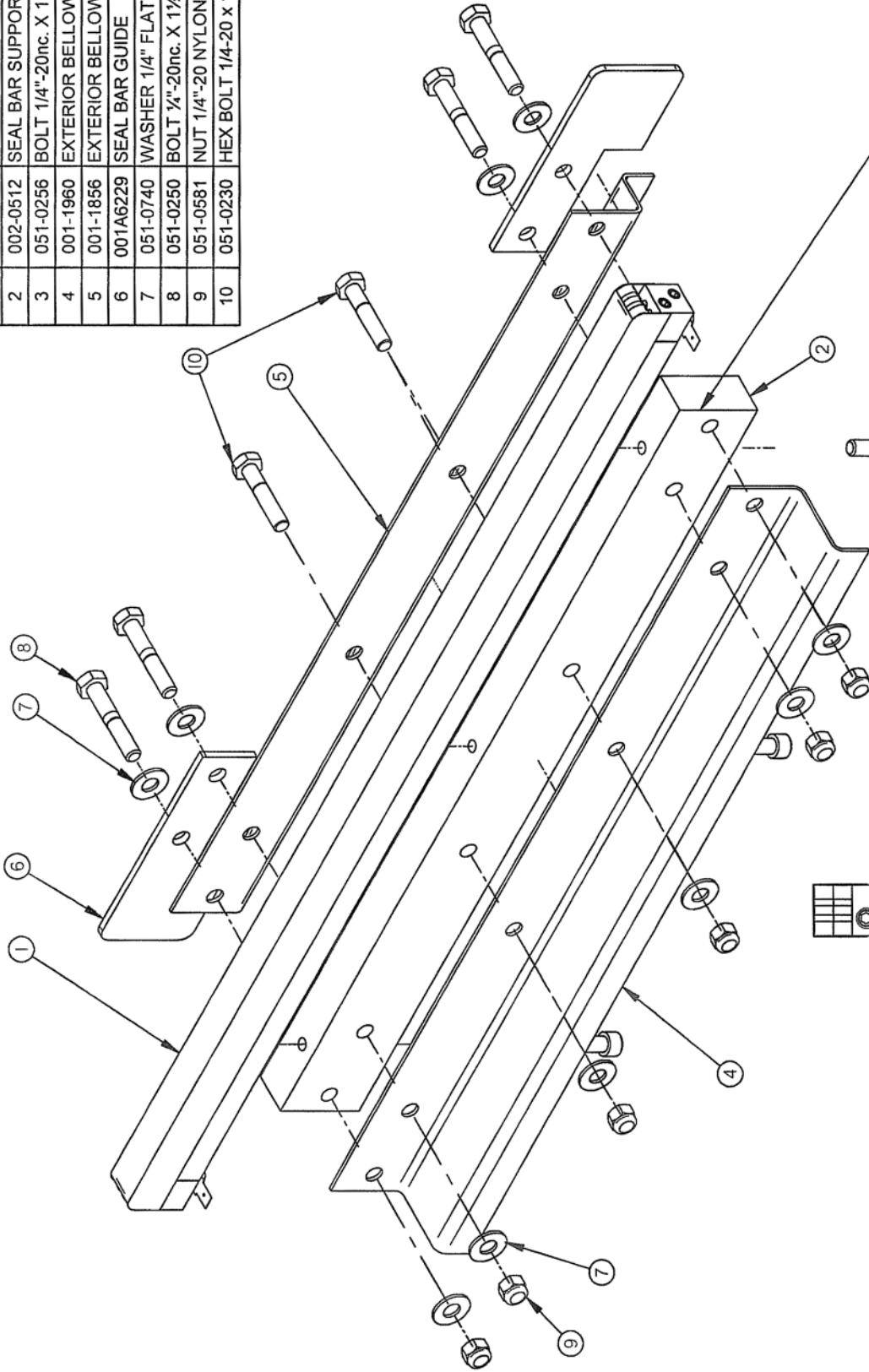


MACHINE	DEPT. TOL. METRIC	INCH	SIPROMAC
350, 350D, 380 & 380T	USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANITHAM
PART	TOLERIE ± 0.5	± 0.020"	QUEBEC CANADA
"BUSCH" PUMP INSTALLATION	SOUDAGE ± 0.5	± 0.020"	
ITEM	CNC	DEPT.	M
QTY.			1
DATE	02-03-11	NO.	004-0346
APP. BY	[Signature]	DATE	02-03-11

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

# 005A1355

ITEM	PART #	DESCRIPTION	QT.
1	004-0352	SEAL BAR PRE-ASSEMBLY	1
2	002-0512	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	3
4	001-1960	EXTERIOR BELLOWS COVER	1
5	001-1856	EXTERIOR BELLOWS COVER	1
6	001A6229	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	10
8	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	2



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

## -TWIN SEAL OPTION-

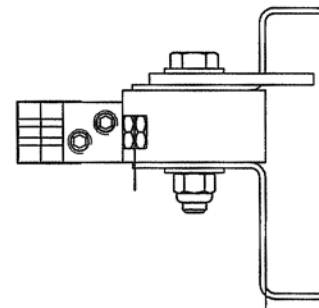
350D	2
350	1
300D	2
300	1
MACHINE	QTY

SIPROMAC  
 ST-GERMAIN DE GRANTHAM  
 QUEBEC CANADA

DEPT.	TOL. METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"
N.T.S.		
DATE	12-09-24	
APP. BY	J.G.	
DEPT.	M-I-(M)	LIST

# 005A1355

## -END VIEW-

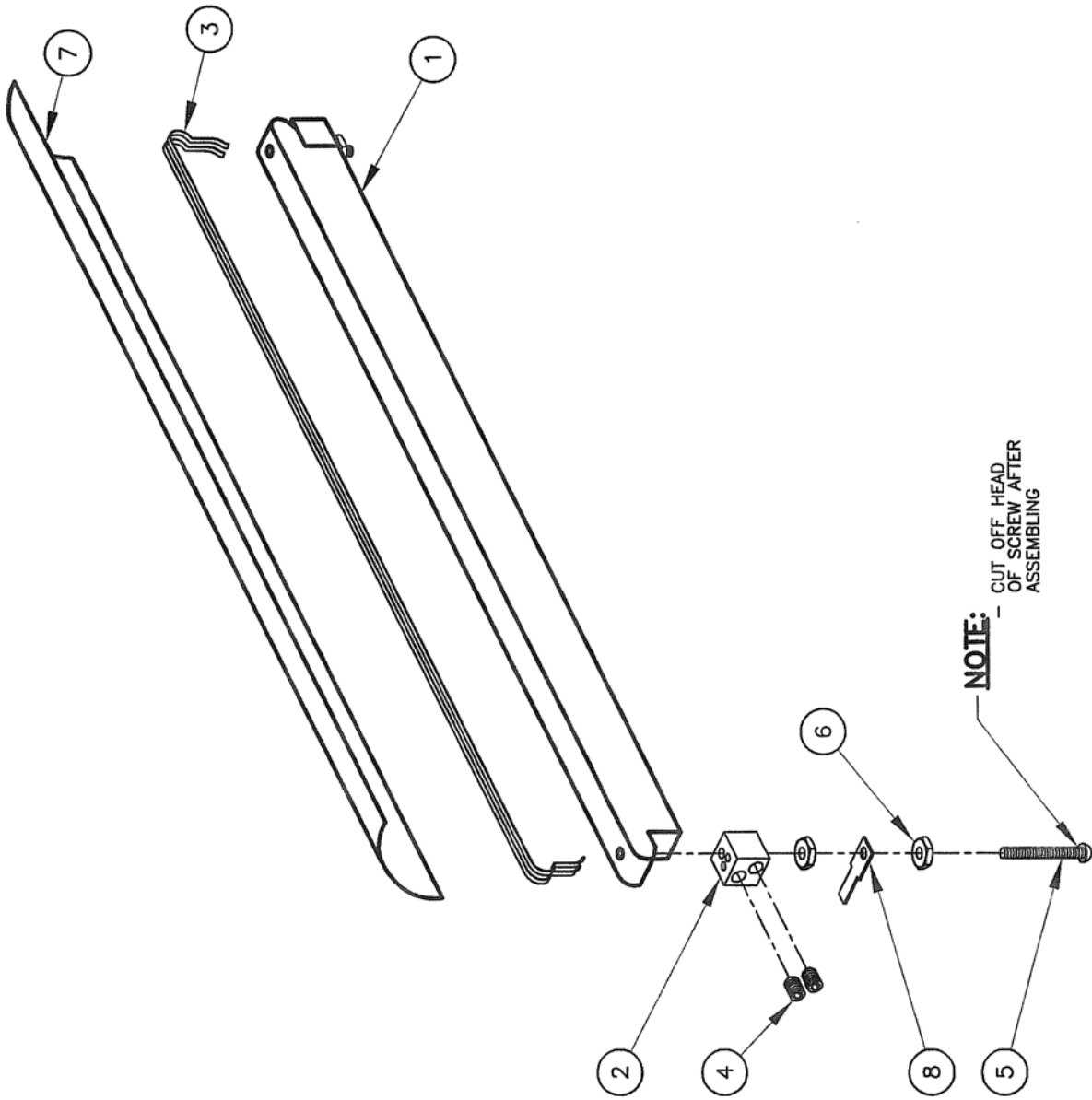


-ITEM #2 ÉGAL AVEC L'ITEM #4 & #5.  
 -ITEM #2 FLUSH WITH ITEM #4 & #5.

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

004-0352

ITEM	#PART	DESCRIPTION	QT.
1	002-0481	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEM. STD TWIN (2x626mm EA.)	4.31
4	052-0395	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	4
5	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
6	051-0550	NUT #8-32 S/S	4
7	176-0200	TEFLON TAPE 5S ADHESIVE X 2" X (496mm EA.)	0.063
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2



450T	2
450A	2
400	2
3500	2
350	1
3000	2
300	1
MACHINE QTÉ:	
SIPROMAC	
ST-GERMAIN DE GRANTHAM	
QUEBEC CANADA	
URP#:	M-1
QT:	2

**VOIR LISTE**

PART SEAL BAR PRE-ASSEMBLY

ITEM: \_\_\_\_\_ CNG: \_\_\_\_\_

DATE 98-02-10

DATE \_\_\_\_\_

DATE 98-02-10

DATE \_\_\_\_\_

DATE 98-02-10

DATE \_\_\_\_\_

DATE 98-02-10

DATE \_\_\_\_\_

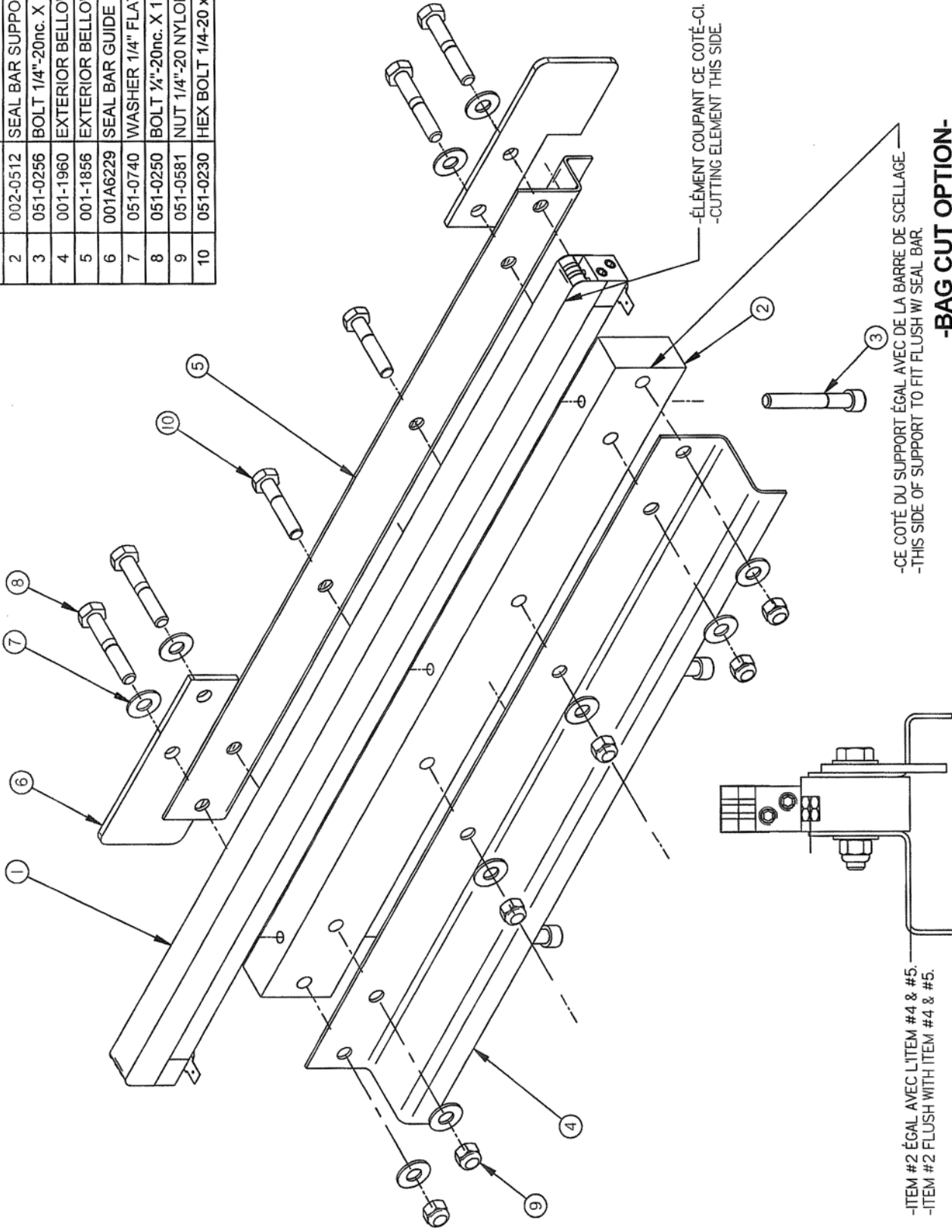
DATE 98-02-10

DATE \_\_\_\_\_

F	ADDED 300, 3000, 350 & 3500 WAS 005-0267	12-09-24	J.G.
E	ADDED 450T WAS 005-0377	08-05-26	D.A.
D	MODIFICATION #A-0398 (CONNECTEUR)	04-04-19	J.G.
C	ADDED 400	98-05-06	S.L.
B	REDRAWN	98-02-10	A.P.
LET.	MODIFICATION	DATE	INT.

# 005A1356

ITEM	PART #	DESCRIPTION	QT.
1	004-0355	BAG CUT SEAL BAR PRE-ASSEMBLY	1
2	002-0512	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	3
4	001-1960	EXTERIOR BELLOW COVER	1
5	001-1856	EXTERIOR BELLOW COVER	1
6	001A6229	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	10
8	051-0250	BOLT 3/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6
10	051-0230	HEX BOLT 1/4"-20 x 1 1/4" SS	2



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

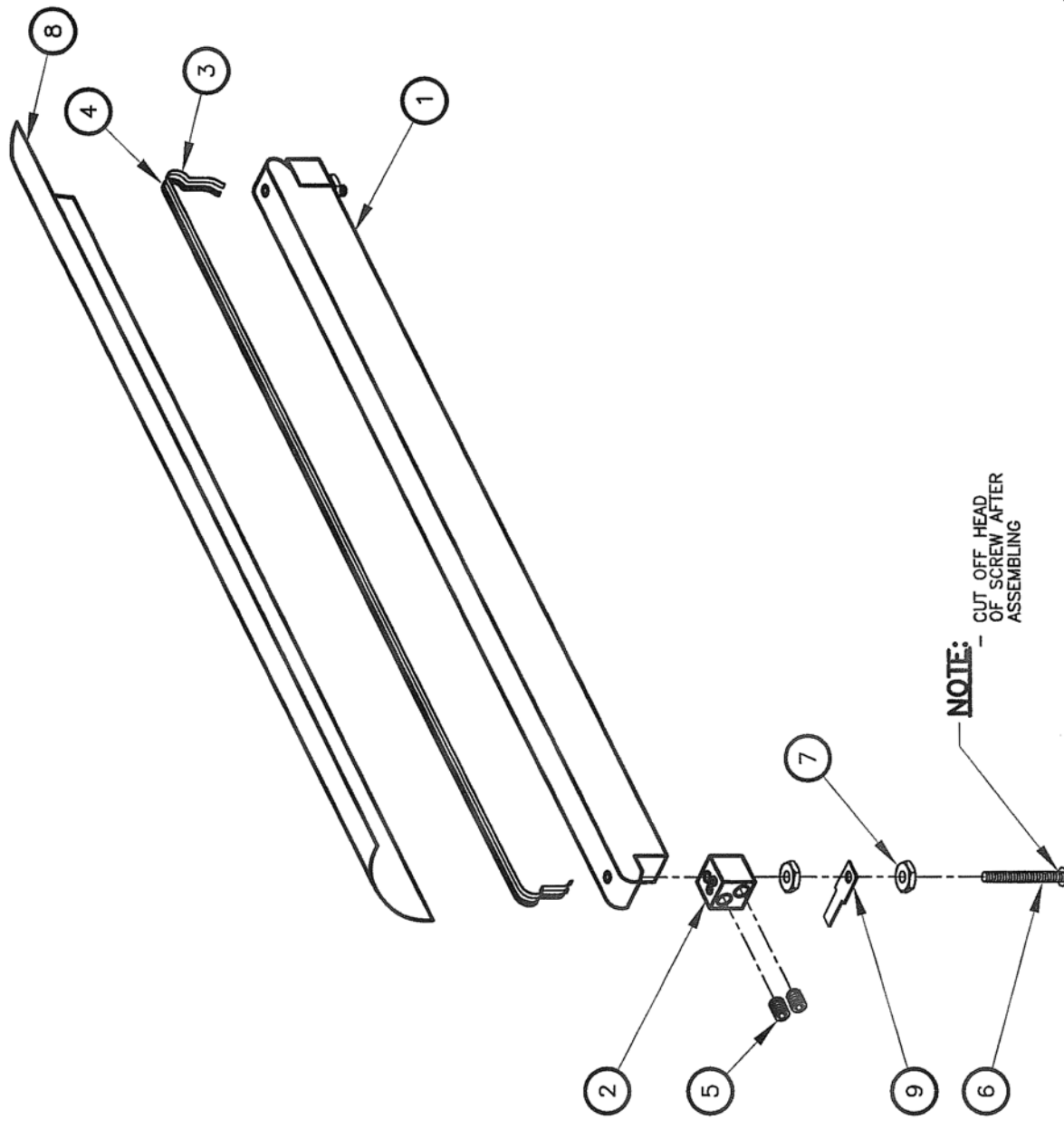
**-END VIEW-**

**-BAG CUT OPTION-**

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

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

ITEM	#PART	DESCRIPTION	QT.
1	002-04B1	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0230	REFLEX BAND 2.5MM (626mm EA.)	0.063
4	039-0270	"T" PROFILE CUT. ELEM. (626mm EA.)	0.063
5	052-0395	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	4
6	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
7	051-0550	NUT #8-32 S/S	4
8	176-0200	TEFLON TAPE 5S ADHESIVE X 2" X (496mm EA.)	0.063
9	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2



**NOTE:**  
CUT OFF HEAD  
OF SCREW AFTER  
ASSEMBLING

LET.	MODIFICATION	DATE	INT.
F	ADDED 300, 3000, 350 & 3500 WAS 005-0267	12-09-24	J.G.
E	ADDED 450T WAS 005-0383	08-05-26	D.A.
D	MODIFICATION #A-0398 (CONNECTEUR)	04-04-19	J.G.
C	ADDED 400	99-05-06	S.L.
B	REDRAWN	98-02-10	A.P.

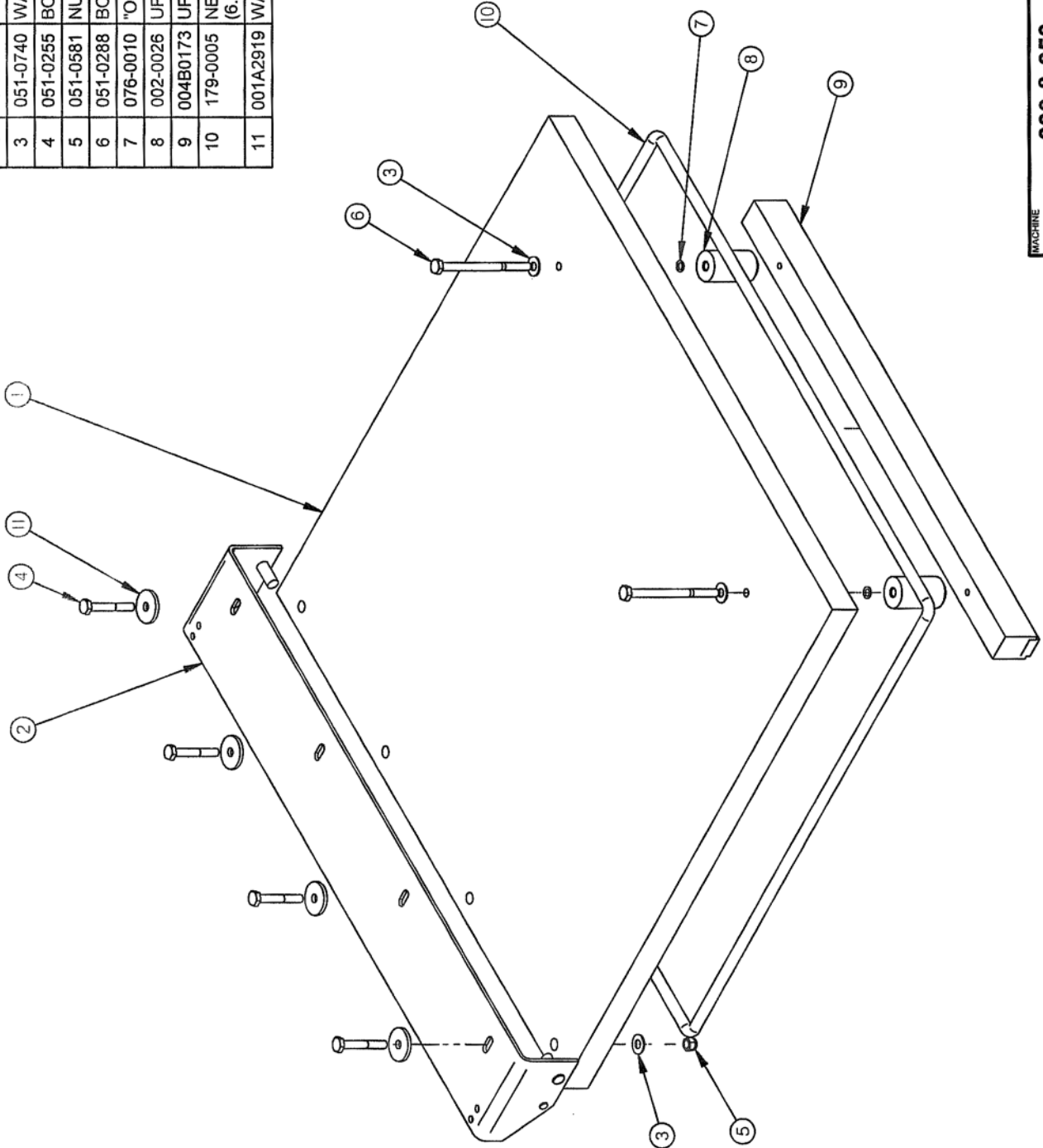
450T	2
450A	2
400	2
3500	2
350	1
3000	2
300	1
MACHINE	QT.

**-BAG CUT OPTION-**

MACHINE	VOIR LISTE		USINAGE	± 0.1	INCH	± 0.004"
PART	SEAL BAR PRE-ASSEMBLY		TOLERANCE	± 0.5	METRIC	± 0.020"
ITEM:	CNC	DATE	98-02-10	STAMP	N.T.S.	
MAT:	DWS APP.	A.P.	DATE	M-1	QT.	LISTE
						SIPROMAC
						ST-GERMAIN DE GRANTHAM
						QUEBEC CANADA
						004-0355

005A0266

ITEM	PART #	DESCRIPTION	QT.
1	002A0025	PLEXI COVER	1
2	004A0021	COVER HINGE ASSEMBLY	1
3	051-0740	WASHER 1/4" FLAT S/S	6
4	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	4
5	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
6	051-0288	BOLT 1/4-20 x 3 1/2" S/S	2
7	076-0010	"O" RING 1/4" x 3/8" x 1/16"	2
8	002-0026	UPPER SEAL BAR SPACER	2
9	004B0173	UPPER SEAL BAR PRE-ASS'Y	1
10	179-0005	NEOPRENE SPONGE 3/8" O.D. 2042mm (6.7')	1
11	001A2919	WASHER 0.381" ID X 1.062" OD X 3	4



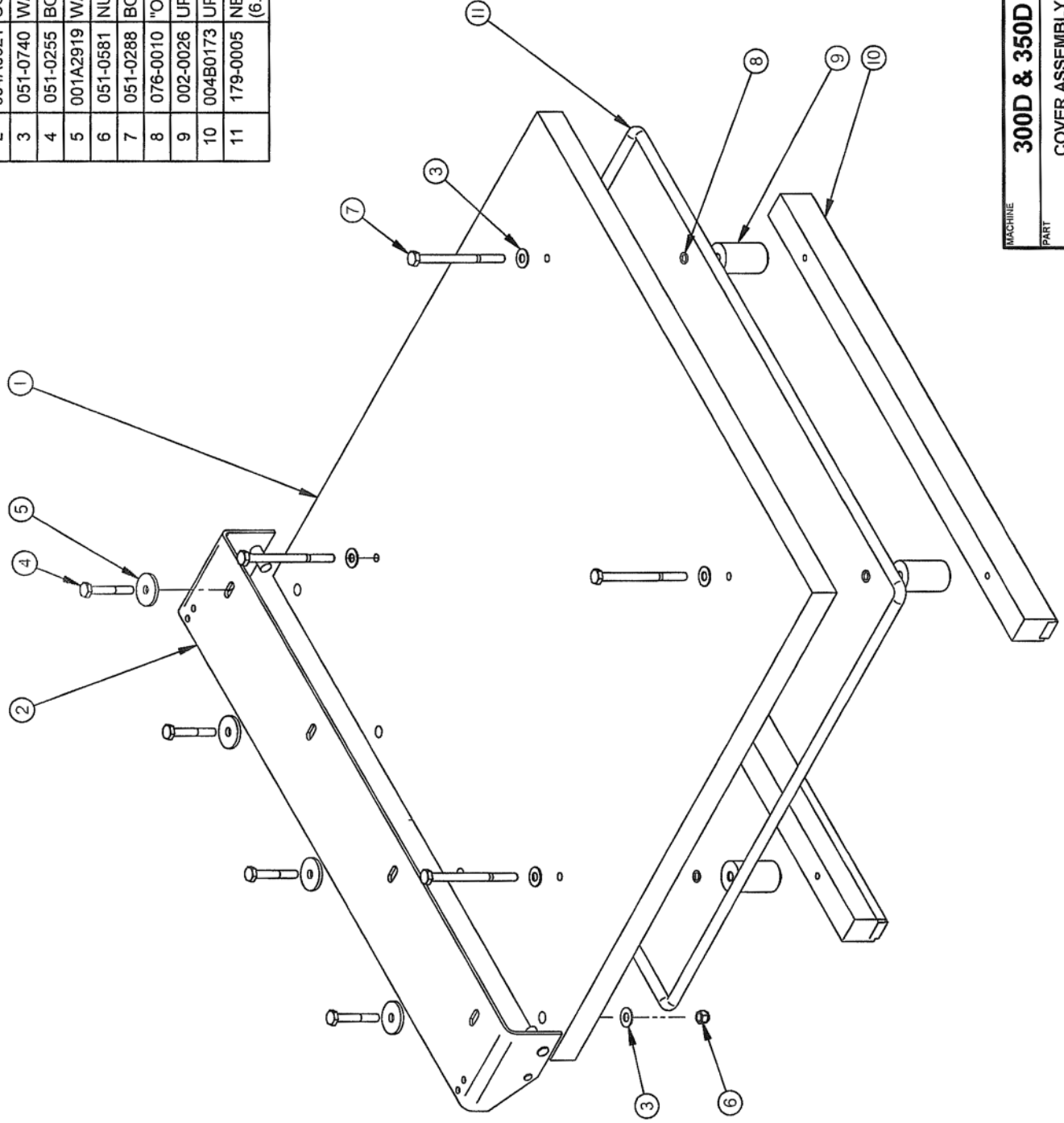
MACHINE	300 & 350	DEPT. TOL. METRIC INCH	±0.1 ±0.004
PART	COVER ASSEMBLY	USINAGE	±0.1 ±0.004
ITEM	CNC	TOLERIE	±0.5 ±0.020
MAT.	DWG BY J.G.	SOUDAGE	±0.5 ±0.020
	DATE 12-10-15	N.T.S.	
	APP. BY	DEPT.	M-(M)
		NO.	005A0266
		QTY.	1

LET. \_\_\_\_\_ DATE INT. \_\_\_\_\_

MODIFICATION

005A0481

ITEM	PART #	DESCRIPTION	QT.
1	002A0392	PLEXI COVER	1
2	004A0021	COVER HINGE ASSEMBLY	1
3	051-0740	WASHER 1/4" FLAT S/S	8
4	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	4
5	001A2919	WASHER 0.381" ID X 1.062" OD X 3	4
6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4
7	051-0288	BOLT 1/4-20 x 3 1/2" S/S	4
8	076-0010	"O" RING 1/4" x 3/8" x 1/16"	4
9	002-0026	UPPER SEAL BAR SPACER	4
10	004B0173	UPPER SEAL BAR PRE-ASS'Y	2
11	179-0005	NEOPRENE SPONGE 3/8" O.D. 2042mm (6.7')	1



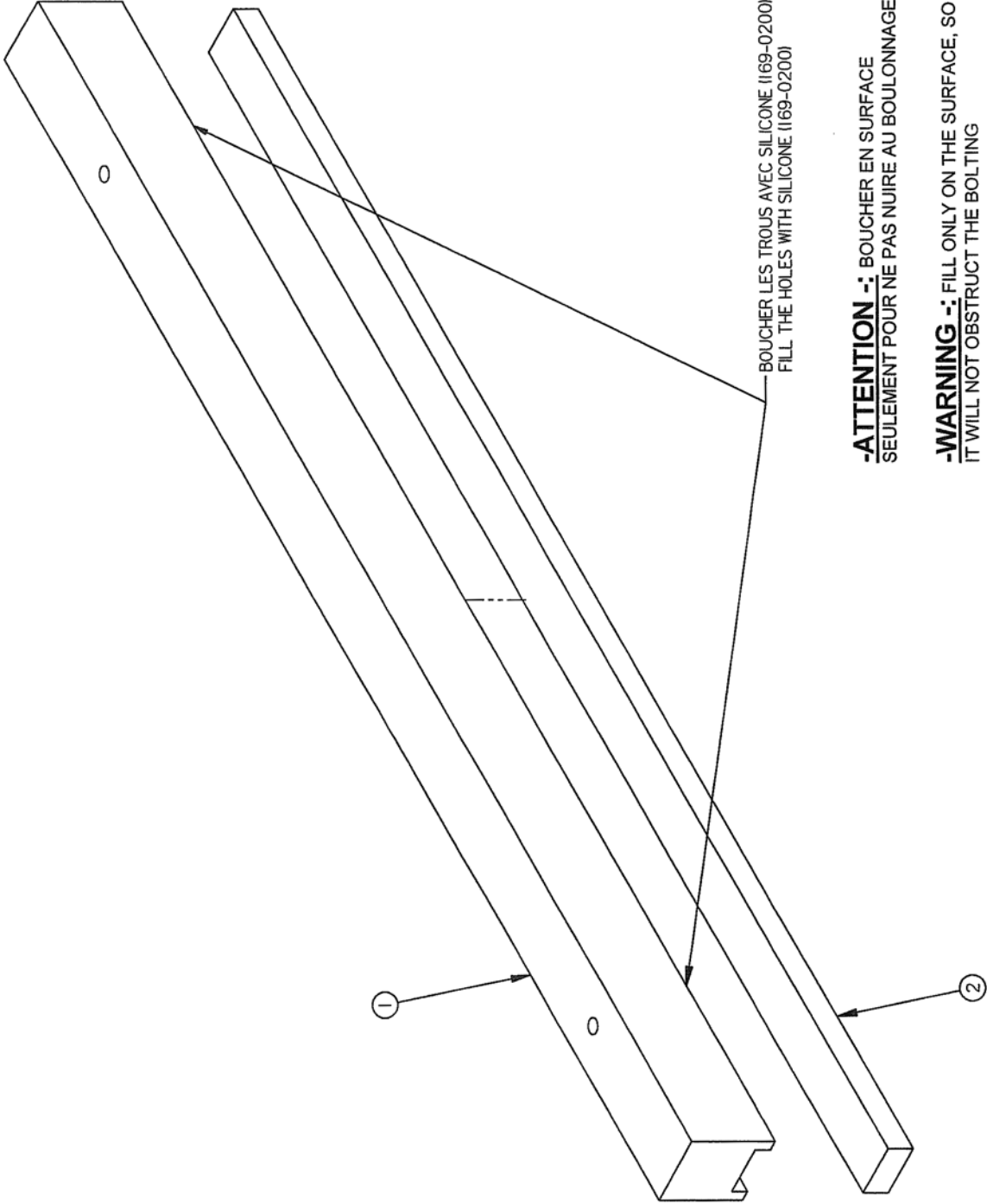
MACHINE	300D & 350D	DEPT. TOL. METRIC INCH	SIPROMAC
PART	COVER ASSEMBLY	USINAGE ± 0.1 ± 0.004	ST-GERMAIN DE GRANTHAM
ITEM		TOLERIE ± 0.5 ± 0.003	QUEBEC CANADA
MAT.		SOUDAGE ± 0.5 ± 0.025	
		N.T.S.	
		DEPT.	M-(M) QTY. 1
		DATE 12-10-15	NO. 005A0481
		DWG BY J.G.	
		APP. BY	

LET. \_\_\_\_\_ DATE INT. \_\_\_\_\_ MODIFICATION \_\_\_\_\_



004B0173

ITEM	PART #	DESCRIPTION	QTY.
1	002B0377	UPPER SEAL BAR SUPPORT	1
2	008A0291	UPPER SEAL BAR RUBBER	1



**-ATTENTION -:** BOUCHER EN SURFACE  
SEULEMENT POUR NE PAS NUIRE AU BOULONNAGE

**-WARNING -:** FILL ONLY ON THE SURFACE, SO  
IT WILL NOT OBSTRUCT THE BOLTING

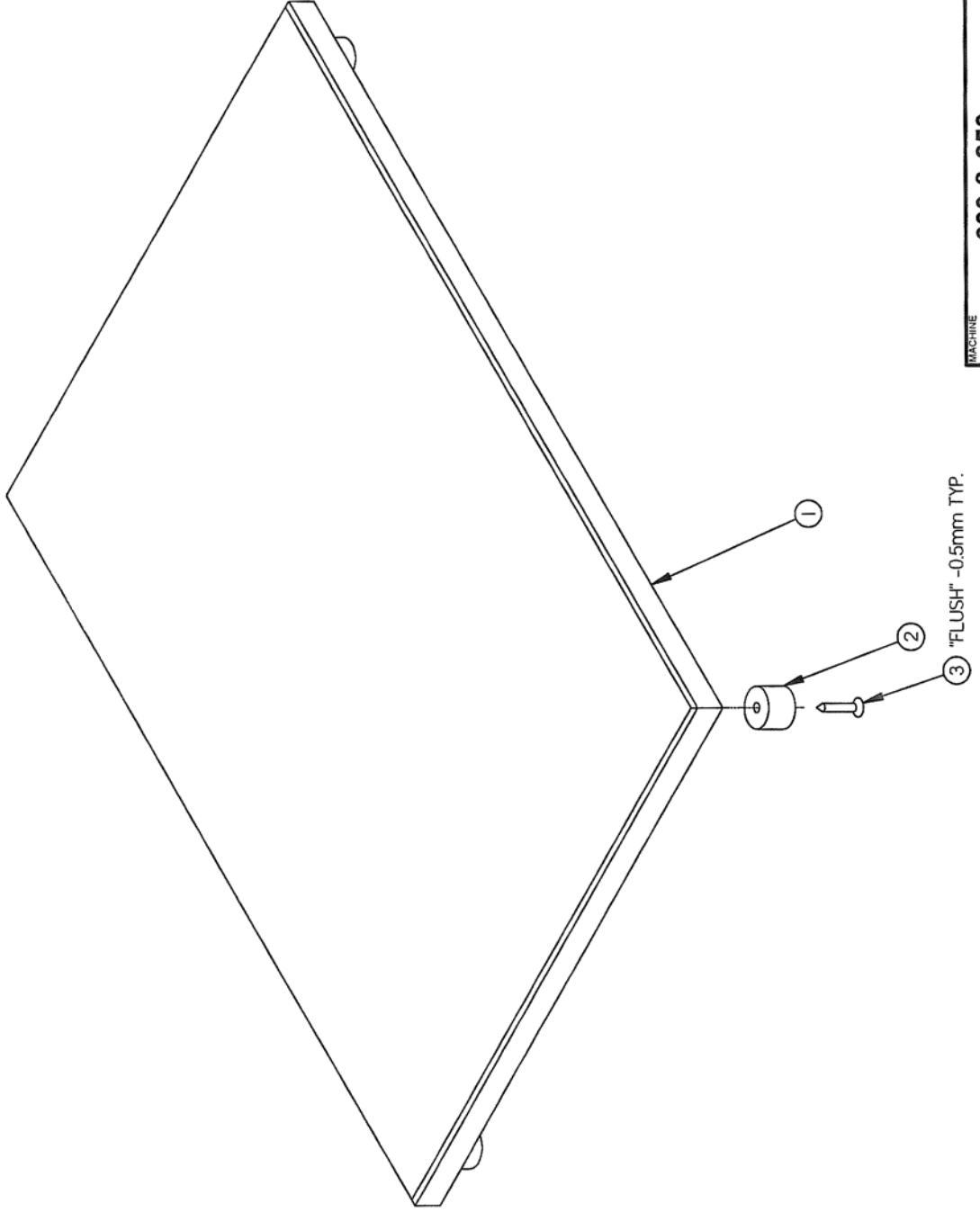
350D	2
350	1
300D	2
300	1
MACHINE	QTY

MACHINE	DEPT. / TOU. / METRIC / INCH	NO.	LISTE
300, 300D, 350 & 350D	USINAGE ± 0.1 ± 0.004 TOLERIE ± 0.5 ± 0.020 SOUDAGE ± 0.5 ± 0.020	12-10-15	M-(M)
PART	UNIT	DATE	NO.
UPPER SEAL BAR PRE-ASS'Y	CNC	12-10-15	004B0173
ITEM	DWG BY	APP. BY	
	J.G.		
MAT.			

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

**005A0278**

ITEM	PART #	DESCRIPTION	QTY.
1	008A0270	FILLER PLATE	1
2	003-0080	FILLER PLATE FOOT	4
3	054-0019	METAL SCREW #10x1"FLAT PHIL S/S	4

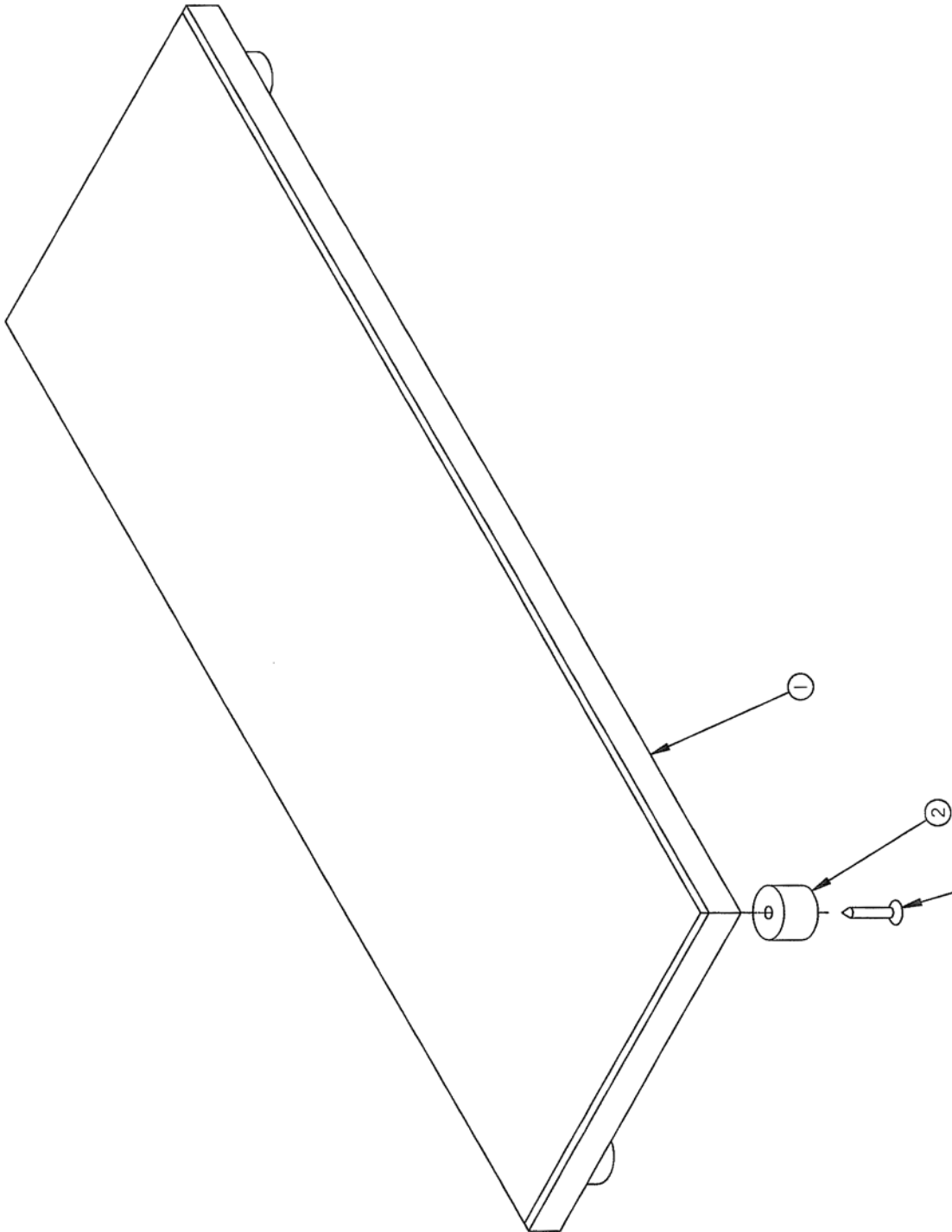


MACHINE	300 & 350			DEPT.	M	QTY.	1
PART	FILLER PLATE ASS'Y			NO.	005A0278		
ITEM	CNC	DATE	12-10-15	DATE	12-10-15	DATE	12-10-15
MAT.	J.G.			DATE	J.G.		
	APP. BY			DATE	APP. BY		
	N.T.S.			DATE	N.T.S.		
	ST-GERMAIN DE GRANTHAM			DATE	ST-GERMAIN DE GRANTHAM		
	QUEBEC CANADA			DATE	QUEBEC CANADA		

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

005A0364

ITEM	PART #	DESCRIPTION	QT.
1	008A0337	HALF FILLER PLATE	1
2	003-0080	FILLER PLATE FOOT	4
3	054-0019	METAL SCREW #10x1"FLAT PHIL S/S	4

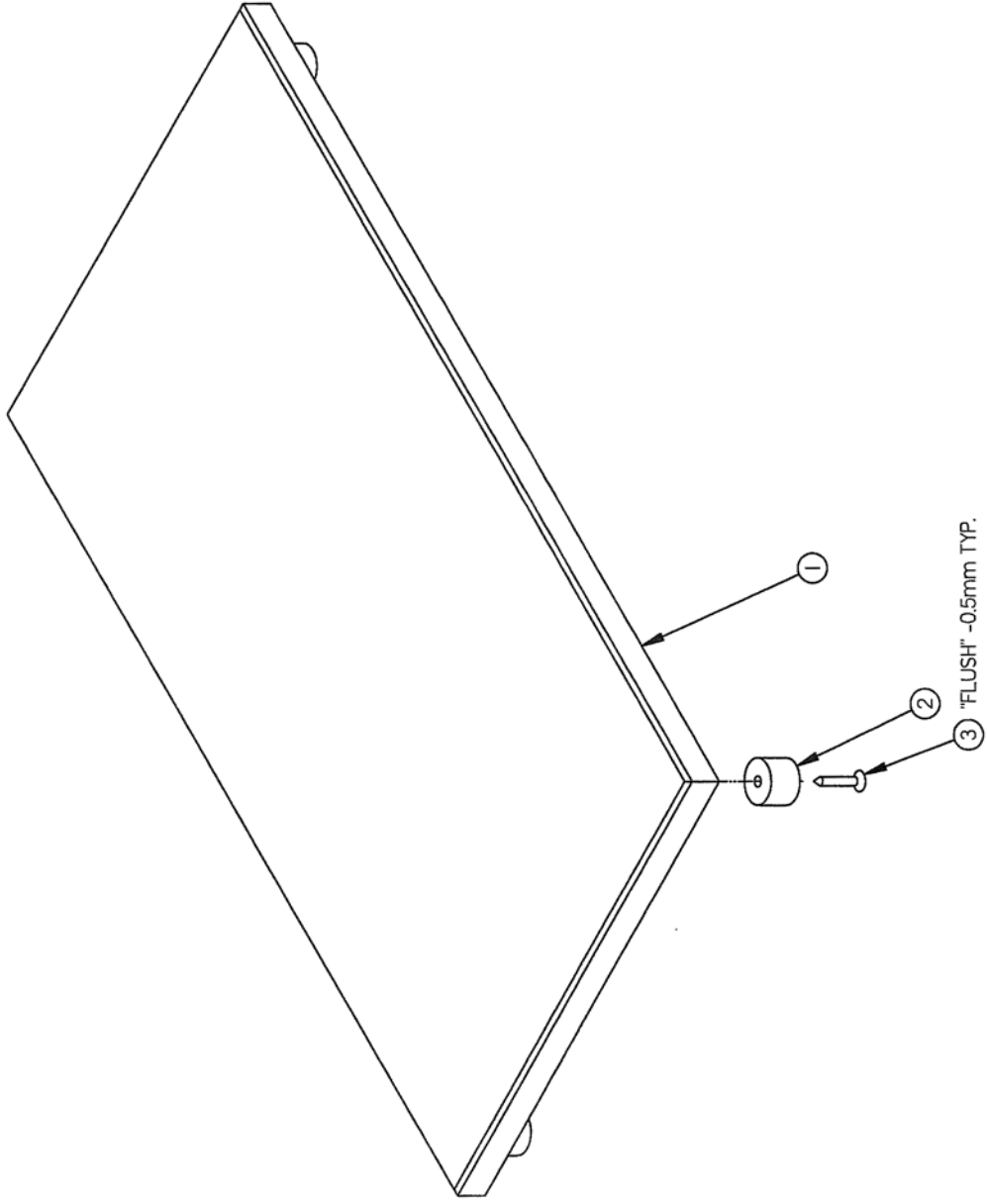


MACHINE	300 & 350	DEPT. TOL. METRIC	INCH	SIPROMAC
PART	HALF FILLER PLATE ASS'Y	USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM
ITEM		COUPE ± 0.3	± 0.002"	QUEBEC CANADA
		SOUDAGE ± 0.3	± 0.002"	
		N.T.S.		
		DEPT.	M	QTY. 2
		DATE	12-10-15	NO
		APP. BY	J.G.	005A0364
		DATE		

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

# 005A0365

ITEM	PART #	DESCRIPTION	QT.
1	008A0338	FILLER PLATE	1
2	003-0080	FILLER PLATE FOOT	4
3	054-0019	METAL SCREW #10x1"FLAT PHIL S/S	4

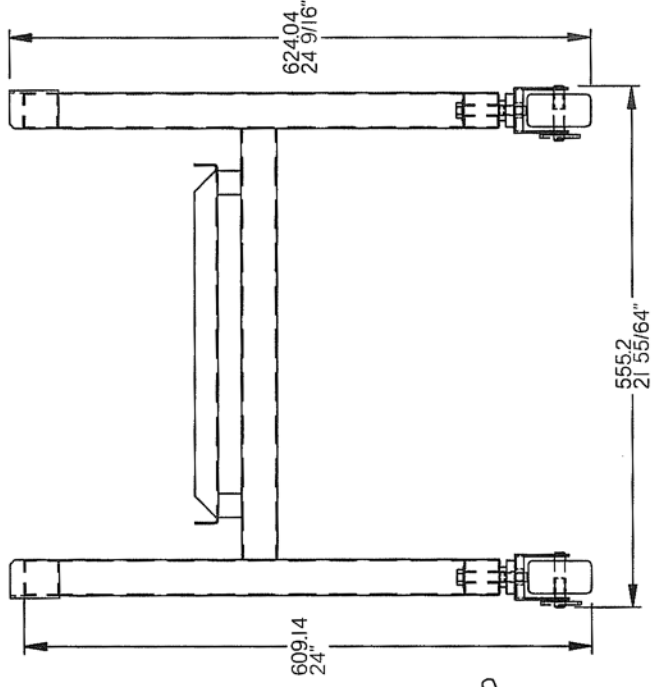
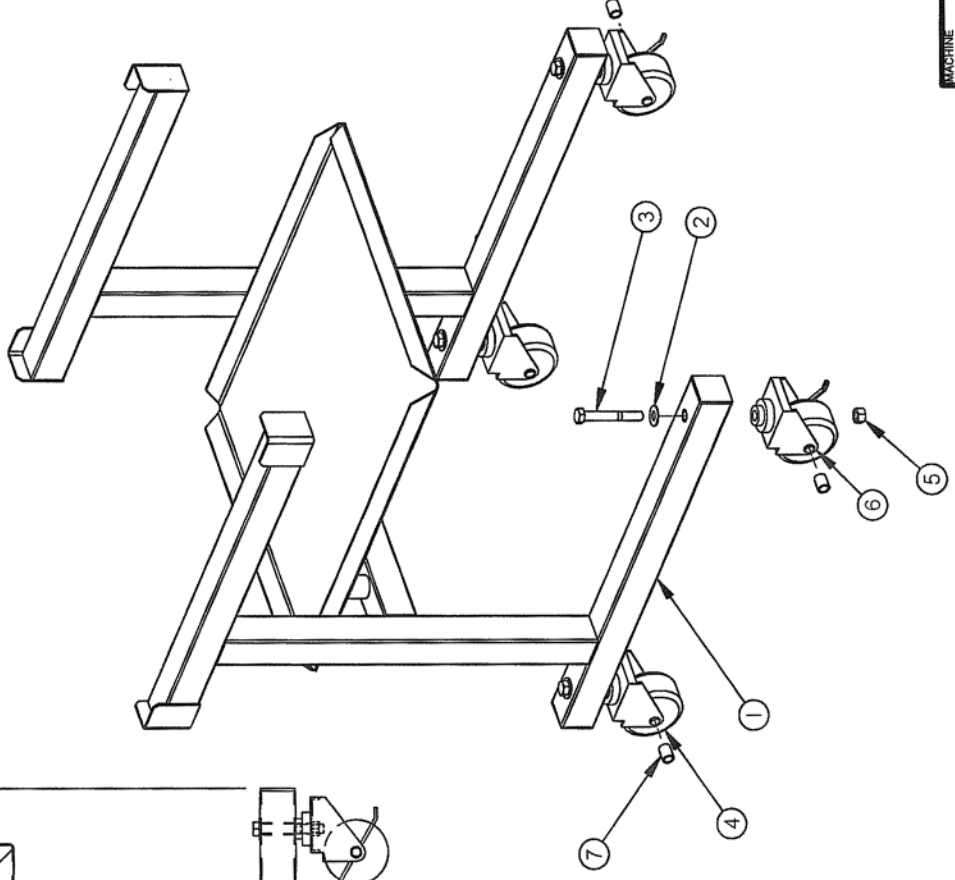
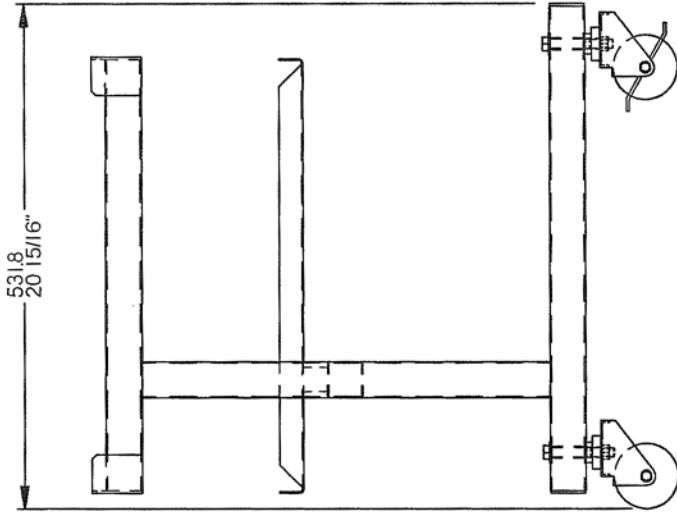


MACHINE	300D & 350D	DEPT. TOI	METRIC	INCH	SIPROMAC
PART	FILLER PLATE ASS'Y	USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM
ITEM		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA
DATE	12-10-15	SOLDAGE	± 0.5	± 0.020"	
DWG BY	J.G.	N.T.S.		DEPT.	M
APP. BY		N.T.S.		NO	005A0365
RECESSINE MODIF.	A-462	N.T.S.		QTY.	2
MODIFICATION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

C.	RECESSINE MODIF.	A-462	J.G.
LET.	MODIFICATION		DATE

1005B1031

ITEM	PART #	DESCRIPTION	QT.
1	005B1347	STAND PRE-ASSY (SHELF)	1
2	051-0780	WASHER 3/8" FLAT S/S	4
3	051-0410	BOLT 3/8"-nc. X 2.75" S/S	4
4	130-0190	PL. CASTER SWIVEL W/OUT BRAKE	2
5	051-0620	NUT 3/8"-16 NC S/S	4
6	130-0195	PL. CASTER SWIVEL W/BRAKE	2
7	075-0040	BUSHING 3/8" x 1/2" x 5/8" PLAIN	4

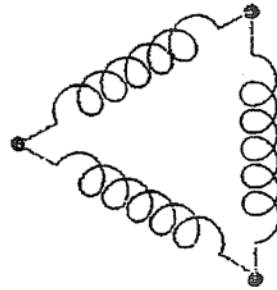
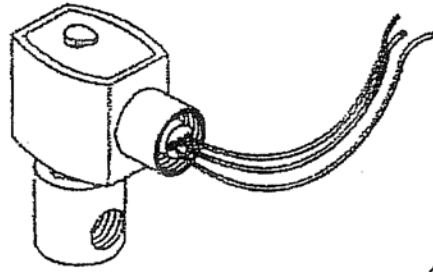
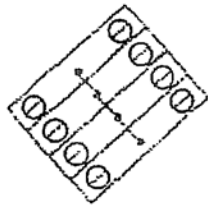


555.2  
21 55/64"

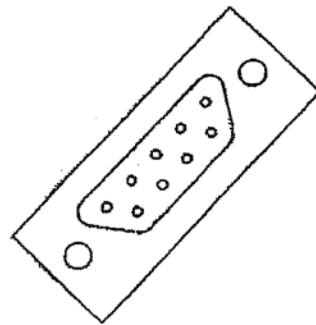
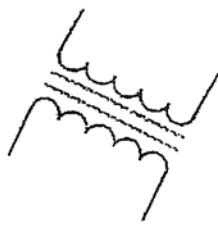
**-STAND OPTION-**

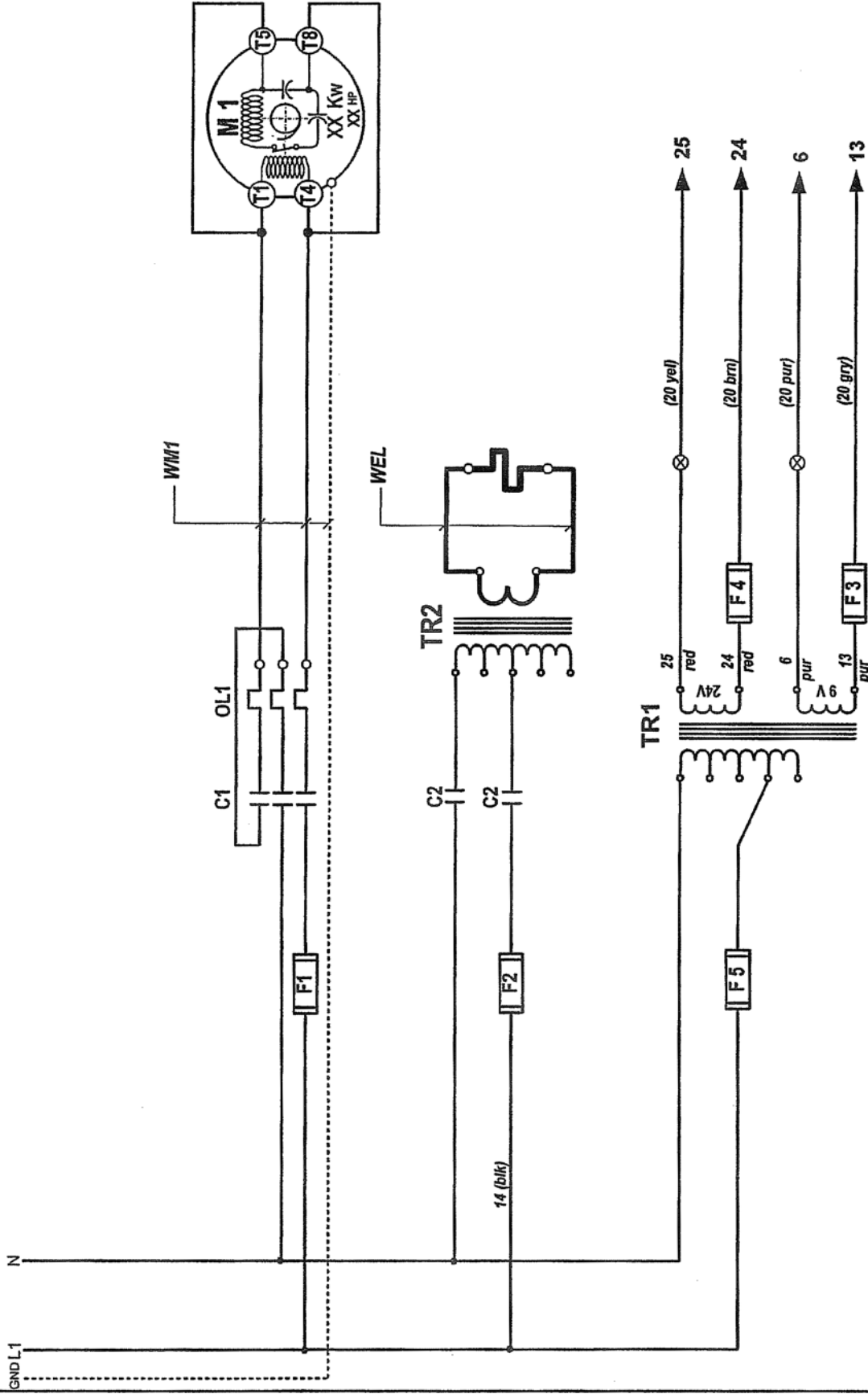
MACHINE <b>300, 300D, 350 &amp; 350D</b>		DEPT. TOL. METRIC INCH USINAGE ± 0.1 ± 0.004 TOLERIE ± 0.5 ± 0.020 SOUDAGE ± 0.5 ± 0.030	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART <b>STAND ASSEMBLY</b>		ITEM CNC	DEPT. M-1
DATE 12-10-15		DATE 12-10-15	NO. 1
APP. BY J.G.		MATERIAL <b>005B1031</b>	

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



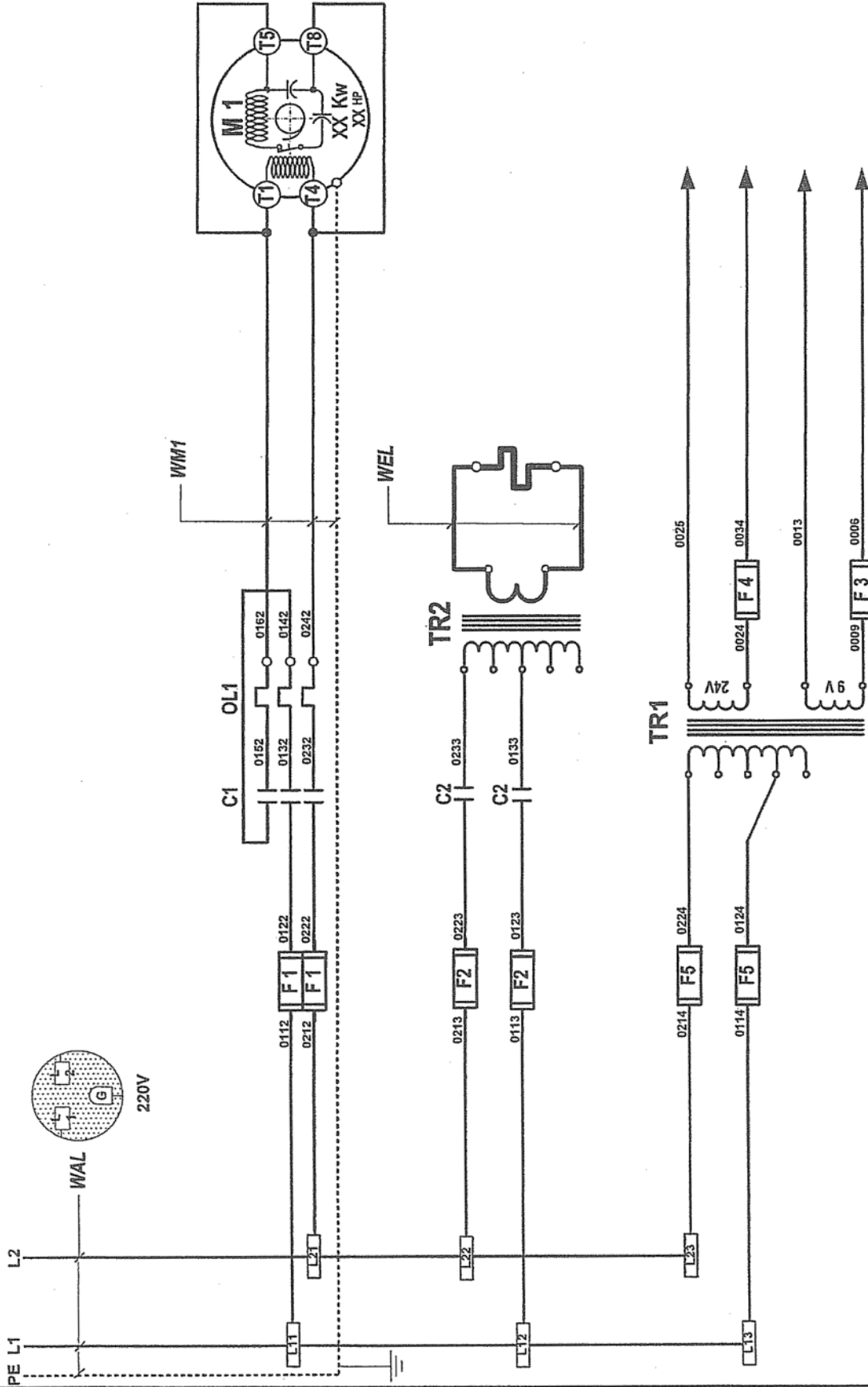
**ELECTRICAL DRAWING**





category	VACUUM PACK	model	350	vol.	120V/1PH/60HZ
system	MC-40	circuit	power	year	10 07 08
usage		block		month	day
functions		concept	XX	draw	app
options		DL	PP	DL	
			006-0220	PAGE 1 de 1	

**SIPROMAC**  
St-Germain de Grantham  
QUEBEC, CANADA

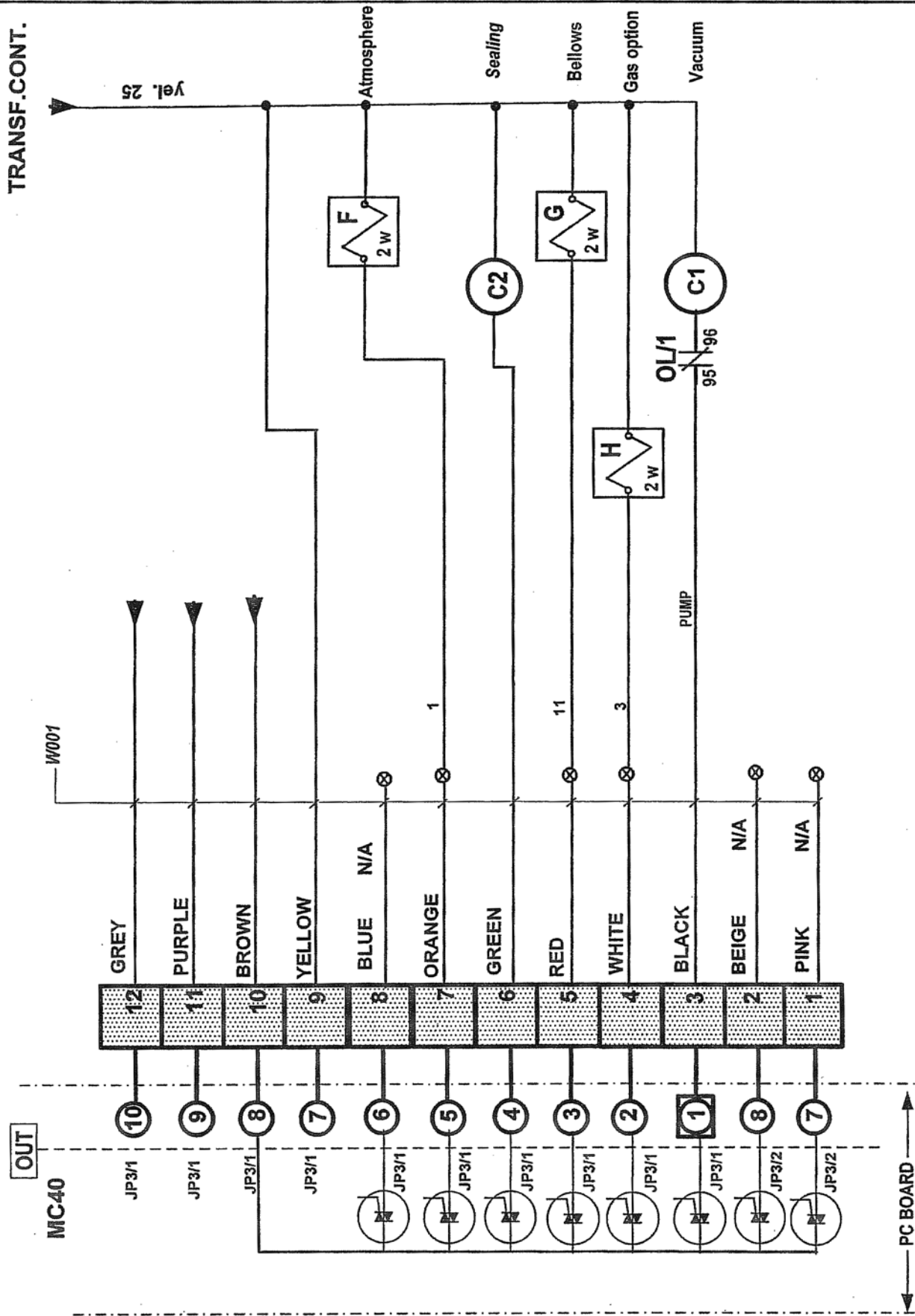


! All unmarked wires are caliber #14 AWG. (006-0200 page 1)

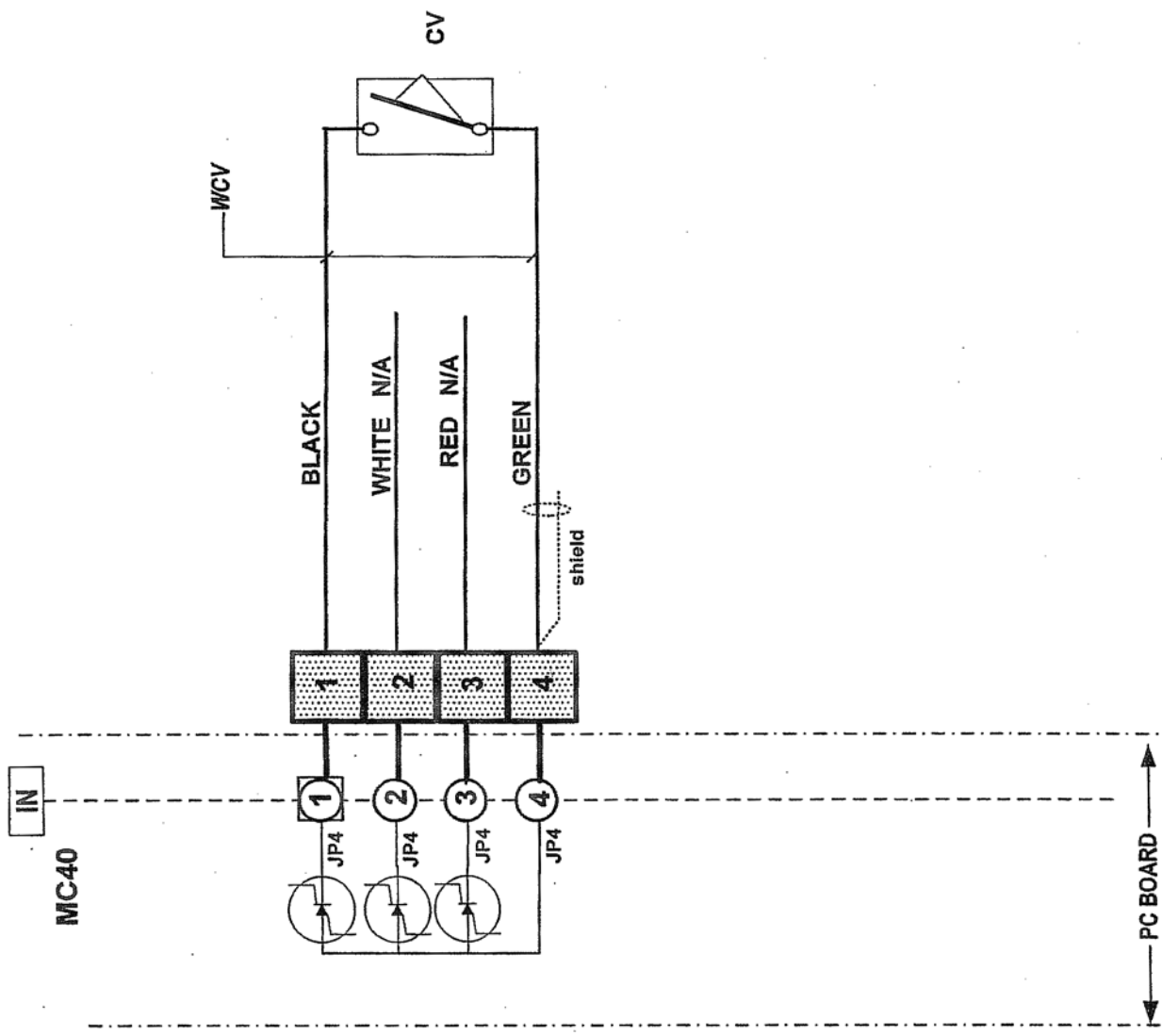
category	VACUUM PACK	model	MC-40	vol	350	220V 1Ph 60Hz			SIPROMAC		
system				circuit		year	month	day	block	St-Germain de Grantham	
usual				power		05	04	25		QUEBEC, CANADA	
fonctions						concept	draw	app	DL	006-0200 PAGE 1 de 1	
options						PP	PP				



TRANSF.CONT.



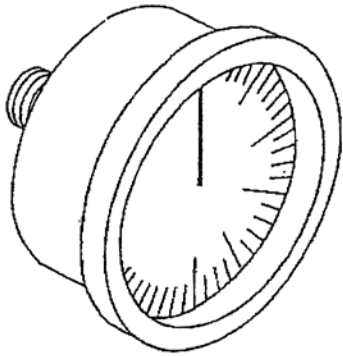
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system	MC-40	circuit	control	year	10
usual		month	07	day	08
fonctions		concept	XX	draw	PP
options		block		app	DL
				006-0237	PAGE 1 de 2
				SIPROMAC	
				St-Germain de Grantham	
				QUEBEC, CANADA	



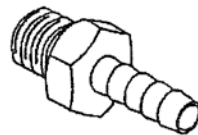
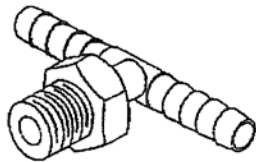
category	VACUUM PACK	model	350	vol.	ALL				
system	MC-40			circuit	control	year	month	day	block
usual				draw	XX	10	07	08	08
fonctions				app	PP				DL
options				concept	XX				
				006-0237		PAGE 2 de 2			
				SIPROMAC		St-Germain de Grantham QUEBEC, CANADA			

# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
036-1500	MALE PLUG 15 AMP./ 125 V.	SUPPLY	120V/1PH/60HZ	350	GND-L1-N		1
030-0120	CAB TIRE	SUPPLY	120V/1PH/60HZ	350	GND-L1-N		3 M.
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	350	GND		1
034-0755	FUSE HOLDER 30A 1 POLE	VACUUM KB-20	120V/1PH/60HZ	350	F1		1
034-0530	FUSE MIDGET 20A/250V TIME-DELAY	VACUUM KB-20	120V/1PH/60HZ	350	F1		1
025-0030	MOTOR CONTACTOR 1HP IN 120V-CSA,UL	VACUUM KB-20	120V/1PH/60HZ	350	C1		1
025-0190	THERMAL OVERLOAD 1/2 TO 1/8A-CSA,UL	VACUUM KB-20	120V/1PH/60HZ	350	O/L1		1
030-0430	TEW #14/41 BLACK	VACUUM KB-20	120V/1PH/60HZ	350	WM1		1M.
030-0440	TEW #14/41 GREEN	VACUUM KB-20	120V/1PH/60HZ	350	WM1		0.5M.
125-1020	VACUUM PUMP 110-120V/1PH/60HZ 0.75KW 13A	VACUUM KB-20	120V/1PH/60HZ	350	M1		1
034-0755	FUSE HOLDER 30A 1 POLE	SEALING	120V/1PH/60HZ	350	F2		1
034-0450	FUSE MIDGET 7A/250V TIME-DELAY	SEALING	120V/1PH/60HZ	350	F2		1
025-0020	CONTACTOR 1TH=25A-CSA,UL	SEALING	120V/1PH/60HZ	350	C2		1
029-0014	TRANSFO 250VA, 120V/24V 60HZ	SEALING	120V/1PH/60HZ	350	TR2		1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING	ALL	350	WEL		2
030-0410	TEW #10/104 BLACK	SEALING	ALL	350	WEL		1.5M.
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING	ALL	350	WEL		2
005A0046	SEAL BAR ASSEMBLY W/SUPPORT	SEALING TWIN SEAL	ALL	350		A1	1
005A0558	SEAL BAR ASSEMBLY W/SUPPORT	SEALING BAG CUT	ALL	350		A2	1
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	120V/1PH/60HZ	350	F5		1
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	120V/1PH/60HZ	350	F5		1
029-0008	TRANSFO 65VA/120V/24-9V	CONTROL TRANSFO	120V/1PH/60HZ	350	TR1		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	350	F3+F4		2
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	350	F3		1
034-0240	FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	350	F4		1
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	350	W001		1M.
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	350	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	350	WCV		2M.
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	350	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	350	JP4		2
033-0038	MICROPROCESSOR MC-40 SENSOR VACUUM	CONTROL WITH SENSOR	ALL	350	MC-40	B1	1
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL W/O SENSOR	ALL	350	MC-40	B2	1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	350		C1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	350		C2	1
106-0020	VALVE 2WAY 24V 1/2 NPT(G94) 60HZ	ATMOSPHERE	ALL	350	F		1
106-0070	VALVE 3WAY 24V 1/4 NPT(G176) 60HZ	BELLOWS	ALL	350	G		1
106-0010	VALVE 2WAY 24V 1/4 NPT(G22) 60HZ	OPTION GAS	ALL	350	H	D	1
004-0261	LIMIT SWITCH ASSY 15A 250V	COVER POSITION	ALL	350	CV		1
036-1512	MALE PLUG 15 AMP./ 250 V.	SUPPLY	220V/1PH/60HZ	350	GND-L1-L2		1
030-0160	CAB TIRE	SUPPLY	220V/1PH/60HZ	350	GND-L1-L2		3 M.

# SIPRO	PART DESCRIPTION	PART APPLICATION	MACHINE VOLTAGE	MACHINE	REF.	OPT.	QTY
028-0105	GROUND BARRIER (6 HOLES)	SUPPLY	ALL	350	GND		1
034-0755	FUSE HOLDER 30A 1 POLE	VACUUM KB-20	220V/1PH/60HZ	350	F1		2
034-0500	FUSE MIDGET 15A/250V TIME-DELAY	VACUUM KB-20	220V/1PH/60HZ	350	F1		2
025-0010	MOTOR CONTACTOR 1HP IN 220V MONO-CSA,UL	VACUUM KB-20	220V/1PH/60HZ	350	C1		1
025-0160	THERMAL OVERLOAD 5.6 TO 8A-CSA,UL	VACUUM KB-20	220V/1PH/60HZ	350	O/L1		1
030-0430	TEW #14/41 BLACK	VACUUM KB-20	220V/1PH/60HZ	350	WM1		1M
030-0440	TEW #14/41 GREEN	VACUUM KB-20	220V/1PH/60HZ	350	WM1		0.5M
125-1021	BUSCH KB-0020 220-240V/1PH/60HZ 0.75KW 6.5A	VACUUM KB-20	220V/1PH/60HZ	350	M1		1
034-0755	FUSE HOLDER 30A 1 POLE	SEALING	220V/1PH/60HZ	350	F2		2
034-0445	FUSE MIDGET 5A/250V TIME-DELAY	SEALING	220V/1PH/60HZ	350	F2		2
025-0020	CONTACTOR 1TH=25A-CSA,UL	SEALING	220V/1PH/60HZ	350	C2		1
029-0018	TRANSFO 250VA 220V/24V 50/60HZ	SEALING	220V/1PH/60HZ	350	TR2		1
027-0220	TERMINAL ROUND STUD #10 600v 75°C	SEALING	ALL	350	WEL		2
030-0410	TEW #10/104 BLACK	SEALING	ALL	350	WEL		1.5M
027-0065	TERMINAL FLAG FEMALE YELLOW .250"	SEALING	ALL	350	WEL		2
005A0046	SEAL BAR ASSEMBLY W/SUPPORT	SEALING TWIN SEAL	ALL	350		A1	1
005A0558	SEAL BAR ASSEMBLY W/SUPPORT	SEALING BAG CUT	ALL	350		A2	1
034-0740	FUSE HOLDER M4/8SF	CONTROL TRANSFO	220V/1PH/60HZ	350	F5		2
034-0200	FUSE 5X20MM 3/4A 250V T-DELAY	CONTROL TRANSFO	220V/1PH/60HZ	350	F5		2
029-0007	TRANSFO 65VA/220-230-460V/24-9	CONTROL TRANSFO	220V/1PH/60HZ	350	TR1		1
034-0740	FUSE HOLDER M4/8SF	CONTROL 9VAC+24VAC	ALL	350	F3+F4		2
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	CONTROL 9VAC	ALL	350	F3		1
034-0240	FUSE 5X20MM 4A/250V TIME DELAY	CONTROL 24VAC	ALL	350	F4		1
030-0590	20AWG/12COND.PVC,UNSHIELD.300V	OUTPUT CONTROL	ALL	350	W001		1M
036-0740	12 CONTACTS CONNECTOR	OUTPUT CONTROL	ALL	350	JP3/1-2		1
030-0631	22AWG/4COND.PVC,SHIELDED,300V.	INPUT CONTROL	ALL	350	WCV		2M
036-0820	0.156" CENTERLINE CRIMP HOUSING	INPUT CONTROL	ALL	350	JP4		1
036-0850	0.156" CENTERLINE CRIMP TERMINAL	INPUT CONTROL	ALL	350	JP4		2
033-0038	MICROPROCESSOR MC-40 SENSOR VACUUM	CONTROL WITH SENSOR	ALL	350	MC-40	B1	1
033-00385	MICROPROCESSOR MC-40 NO SENSOR VAC.	CONTROL W/O SENSOR	ALL	350	MC-40	B2	1
033-0015	MEMBRANE MC-40 SIPROMAC	CONTROL SIPROMAC	ALL	350		C1	1
033-0018	MEMBRANE MC-40 BERKEL	CONTROL BERKEL	ALL	350		C2	1
106-0020	VALVE 2WAY 24V 1/2 NPT(G94) 60HZ	ATMOSPHERE	ALL	350	F		1
106-0070	VALVE 3WAY 24V 1/4 NPT(G176)60HZ	BELLOWS	ALL	350	G		1
106-0010	VALVE 2WAY 24V 1/4 NPT(G22) 60HZ	OPTION GAS	ALL	350	H	D	1
004-0261	LIMIT SWITCH ASSY 16A 250V	COVER POSITION	ALL	350	CV		1

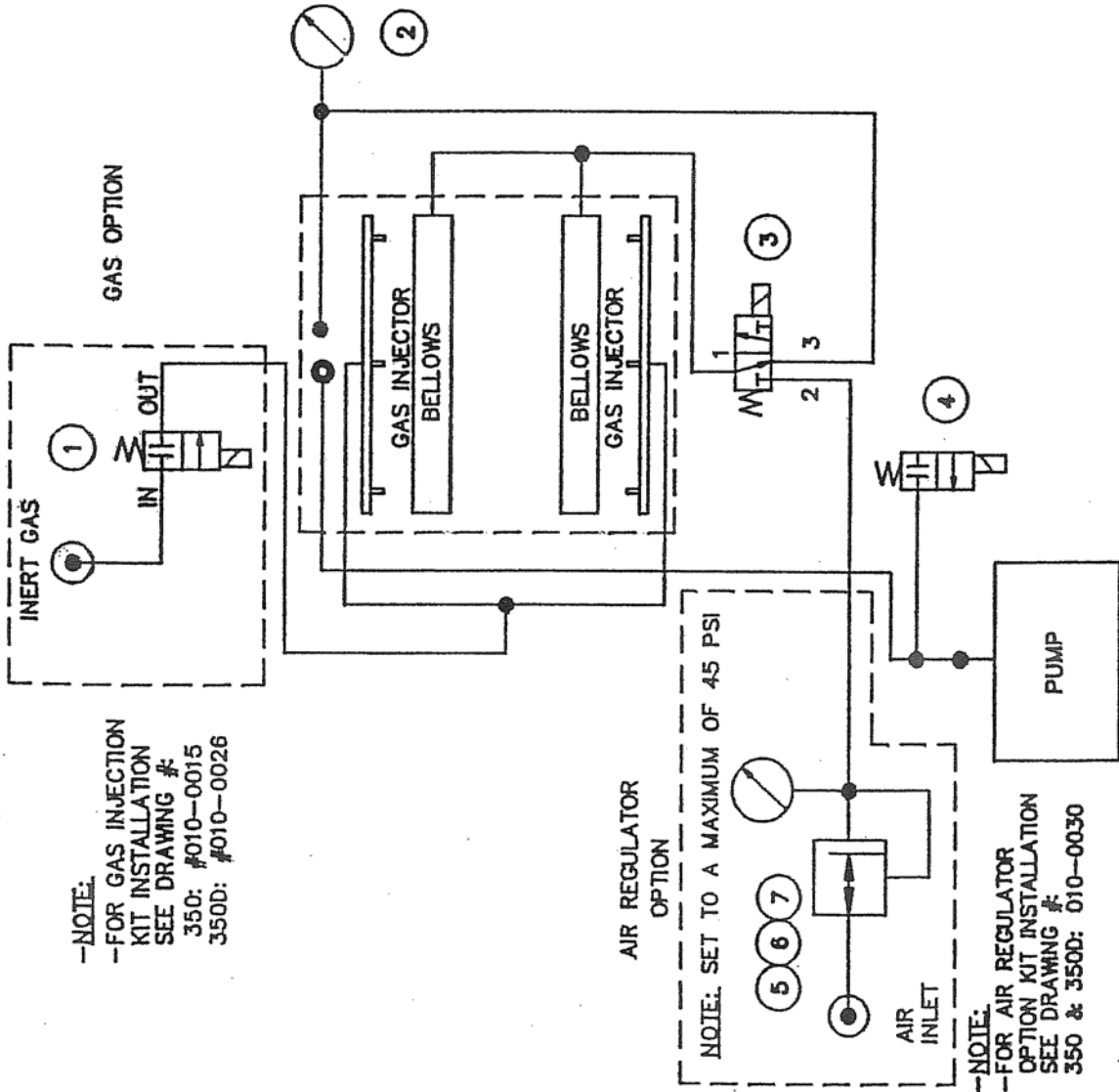


# PNEUMATIC DRAWING



007-0022

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	1*
2	114-0260	VACUUM GAUGE	1
3	106-0070	BELLOWS VALVE	1
4	106-0020	ATMOSPHERE VALVE	1
5	114-0147	PRESSURE REGULATOR	1*
6	114-0245	PRESSURE GAUGE	1*
7	114-0170	PRESSURE REGULATOR SUPPORT	1*
* : OPTION			



-NOTE:  
 -FOR GAS INJECTION  
 KIT INSTALLATION  
 SEE DRAWING #:  
 350: #010-0015  
 350D: #010-0026

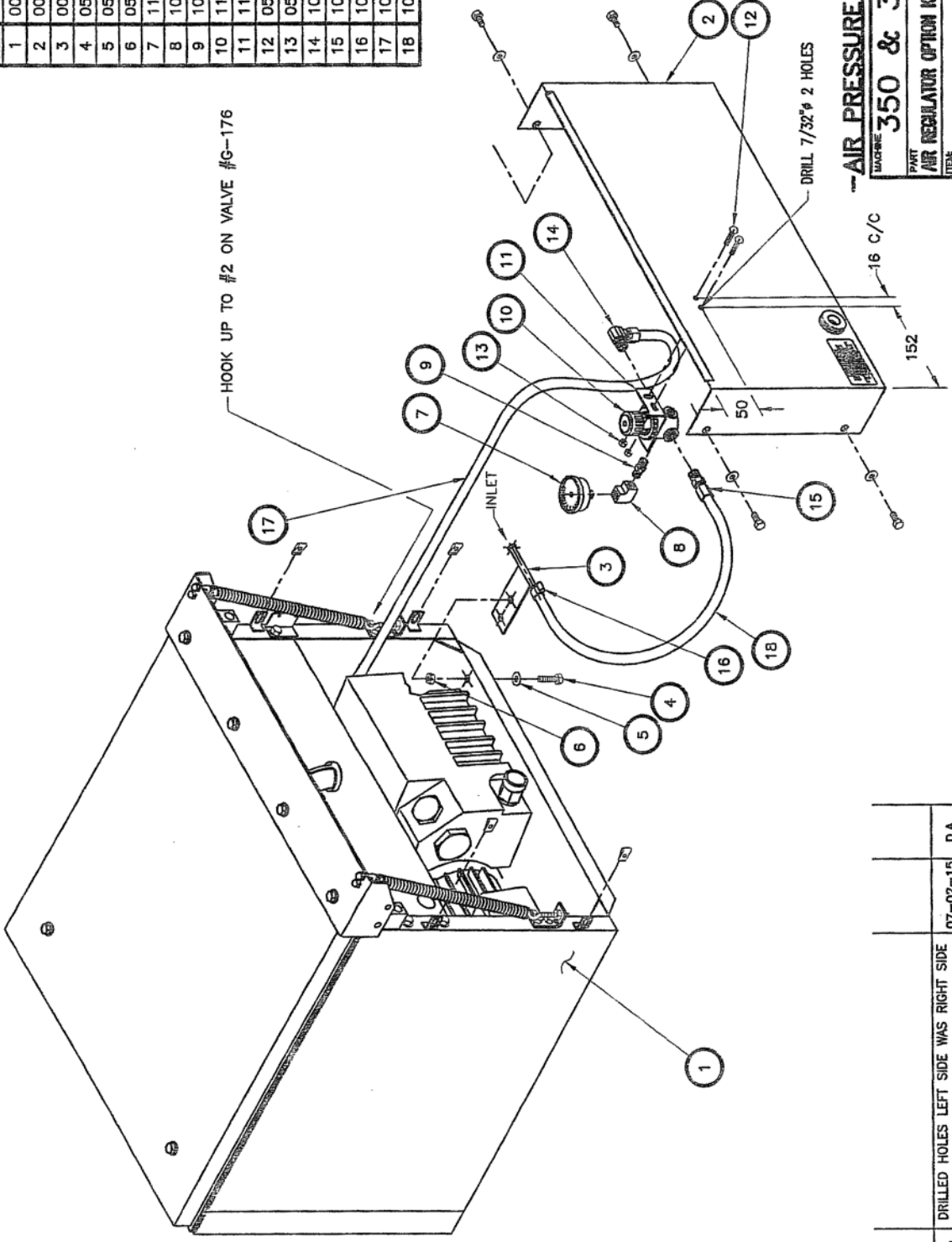
AIR REGULATOR  
 OPTION  
 NOTE: SET TO A MAXIMUM OF 45 PSI

-NOTE:  
 -FOR AIR REGULATOR  
 OPTION KIT INSTALLATION  
 SEE DRAWING #:  
 350 & 350D: 010-0030

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



ITEM	PART #	DESCRIPTION	QT.
1	005-0426	MACHINE ASSEMBLY REAR VIEW	1
2	004-0361	REAR PANNEL PRE-ASSEMBLY	1
3	005-0323	GAS INLET ASSEMBLY	1
4	051-0180	BOLT 1/4"-20 NC X 1/2" S/S	1
5	051-0740	FLAT WASHER 1/4" S/S	1
6	051-0581	NYLON NUT 1/4"-20 NC S/S	1
7	114-0245	PRESSURE GAUGE 0-60 PSI. 1/8" NPT.	1
8	101-0608	ELBOW 90° 1/8" NPT. BR.	1
9	101-0302	HEX. NIPPLE 1/8" NPT. BR.	1
10	114-0147	PRESSURE REGULATOR 0-60 PSI. 1/4" NPT.	1
11	114-0170	PRESSURE REGULATOR SUPPORT W/ LOCKING COLLAR	1
12	051-0108	SCREW #8-32 NC. X 1/2" (PAN PHIL.) S/S	2
13	051-0560	NUT #8-32 NC. S/S NYLON	2
14	101-0058	ELBOW 90° 1/4" MNPT X 3/8" T.P. COMP.	1
15	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P. COMP.	1
16	105-0200	1 EAR CLAMP 3/8" ZINC	1
17	104-0060	TUBE 3/8" O.D. X 1/4" I.D. X 1M. LG. POLYURENE	4
18	104-0060	TUBE 3/8" O.D. X 1/4" I.D. X 1M. LG. POLYURENE	1

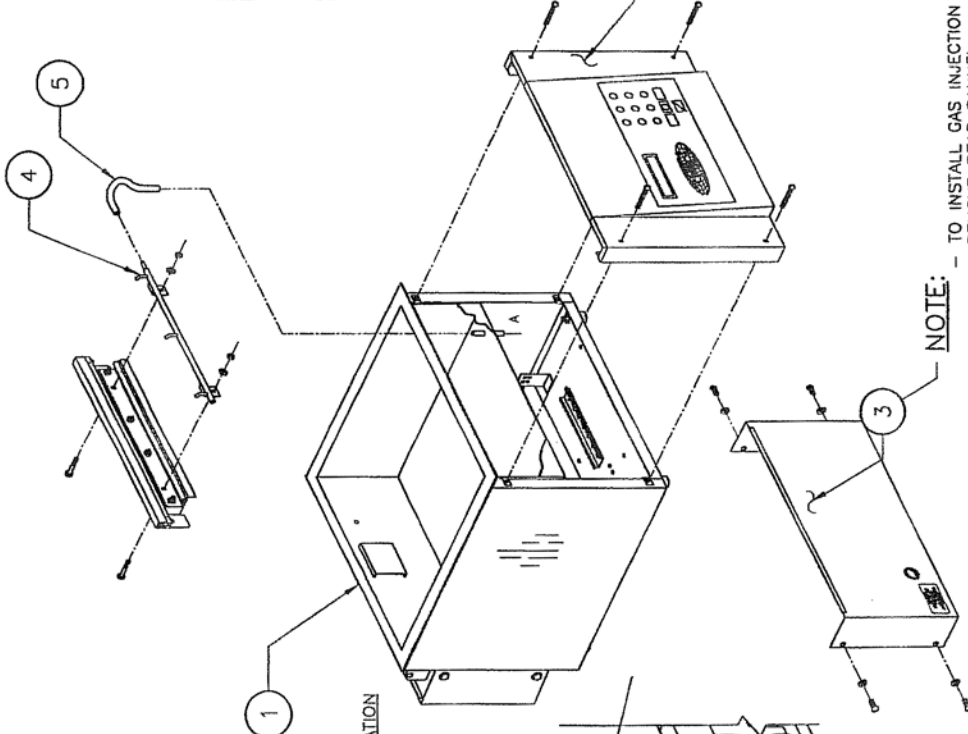


**AIR PRESSURE REGULATOR OPTION-**

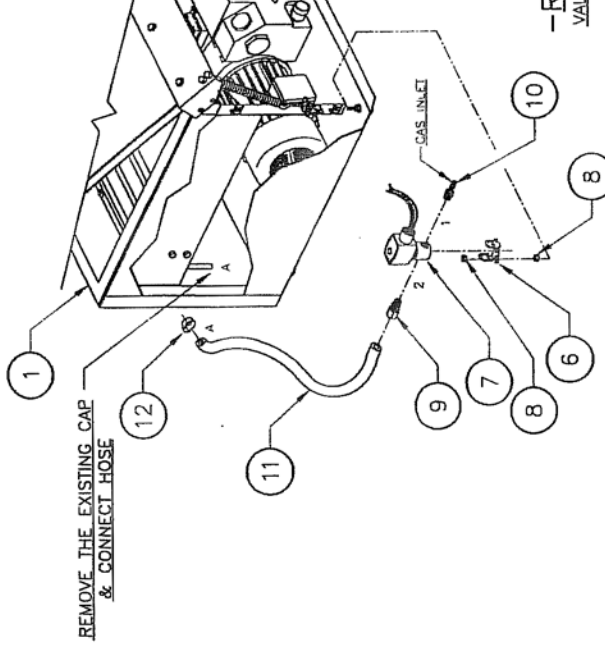
MACHINE	350 & 350D	STANDARD TOLERANCE	± .015"	FINISH	ST-GERMAN DE GRANTHAM
PART	AIR REGULATOR OPTION KIT INSTALLATION	± .005"	± .0005"	ANGLE ± 1°	QUEBEC CANADA
ITEM		± .001"	± .0001"		
DATE	97-01-28				
APP.	DAVE				
REV.					
DATE	97-02-15				
REV.					

DRILLED HOLES LEFT SIDE WAS RIGHT SIDE	07-02-15	D.A.
152 WAS 61 / 50 WAS 64	97-04-08	A.P.
MODIFICATION NO: A-0196	DATE	INT.
LET.		

ITEM	PART #	DESCRIPTION	QT.
1	004-0229	VACUUM 350 PRE-ASSEMBLY	1
2	005-0609	MC-40 FRONT PANNEL ASSEMBLY	1
3	004-0446	REAR PANNEL PRE-ASSEMBLY	1
4	005B00042	GAS INJECTION BAR	1
5	008-0464	GAS INJECTION CONNECTION TUBE	1
6	106-0345	VALVE SUPPORT FOR 1/4" NPT	1
7	106-0010	SELENOID VALVE 2 WAY 1/4" NPT	1
8	051-0580	HEX. NUT 1/4"-20 NC. S/S	2
9	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	1
10	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
11	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) X 610 MM	1
12	105-0200	COLLARS 3/8"Ø	1



FRONT VIEW - GAS INJECTION BAR INSTALLATION



REAR VIEW - VALVE INSTALLATION

NOTE: - TO INSTALL GAS INJECTION TUBE, REMOVE FRONT PANNEL

NOTE: - TO INSTALL GAS INJECTION OPTION, REMOVE REAR PANNEL

MC-40 OPTION - OPTION GAS INJECTION -

MACHINE 350

PART GAS INJECTION KIT INSTALLATION

ITEM: \_\_\_\_\_ DATE: \_\_\_\_\_

MAT: \_\_\_\_\_ DATE: \_\_\_\_\_

INC: \_\_\_\_\_

APP: \_\_\_\_\_

DATE 98-06-05

ST-A. PROVINCHEUR

ST-GERMAIN DE GRANTHAM

ST-GERMAIN DE GRANTHAM

QUEBEC CANADA

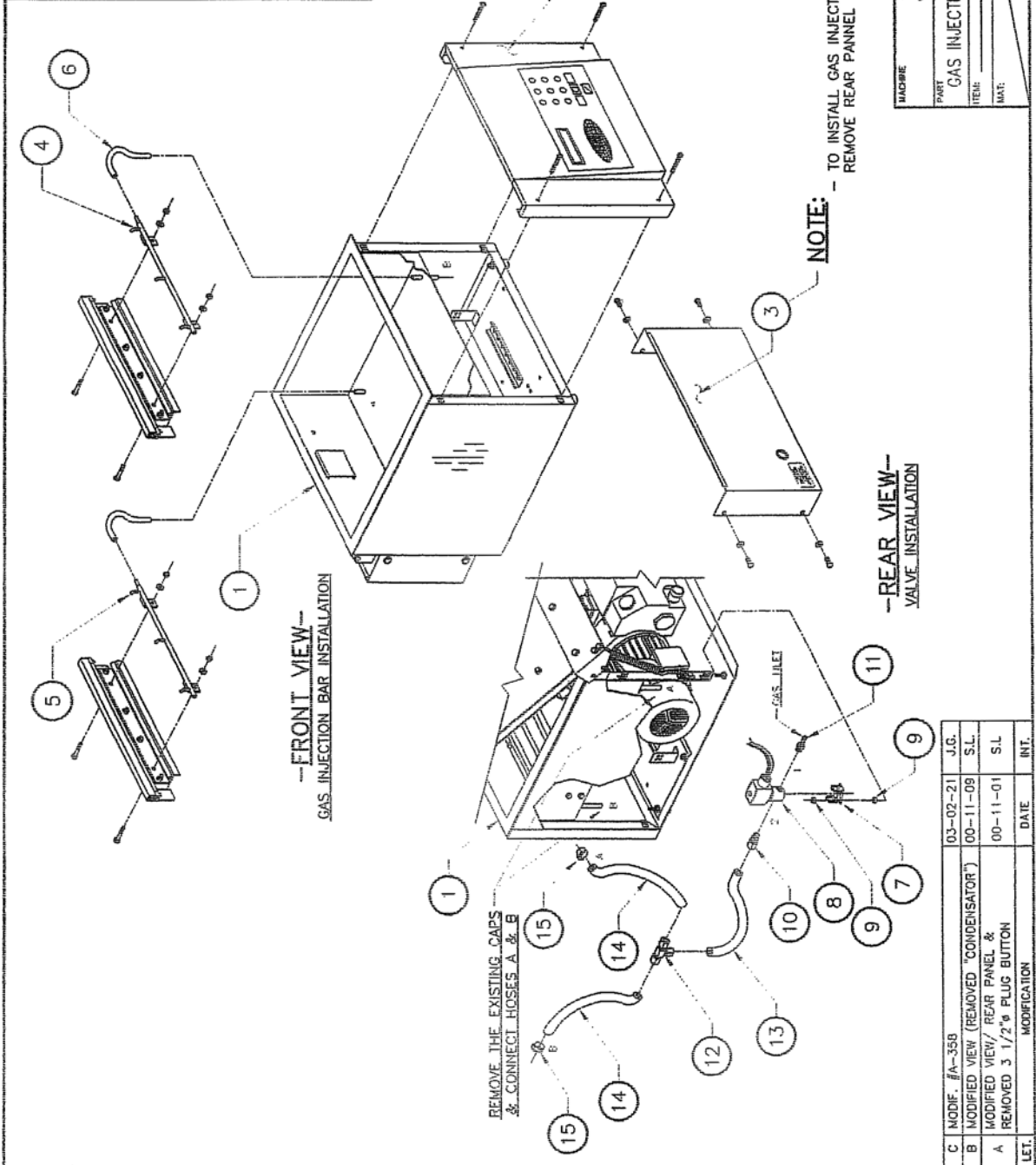
Q10-0034

Q10-0034

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



ITEM	PART #	DESCRIPTION	QTY
1	004-0230	VACUUM 3500 PRE-ASSEMBLY	1
2	005-0450	FRONT PANNEL ASSEMBLY	1
3	004-0361	REAR PANNEL PRE-ASSEMBLY	1
4	00590042	FRONT GAS INJECTION BAR	1
5	005A0807	REAR GAS INJECTION BAR	1
6	008-0464	GAS INJECTION CONNECTION TUBE	2
7	106-0345	VALVE SUPPORT FOR 1/4" NPT	1
8	106-0010	SOLENOID VALVE 2 WAY 1/4" NPT	1
9	051-0580	HEX. NUT 1/4"-20 NC. S/S	2
10	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	1
11	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
12	101-0062	T 3/8" T.P.COMP.	1
13	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) X 230 MM	1
14	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY) X 270 MM	2
15	105-0200	COLLARS 3/8"	2



**MODEL** 3500  
**PART** GAS INJECTION KIT INSTALLATION  
**ITEM** \_\_\_\_\_  
**MAT** \_\_\_\_\_

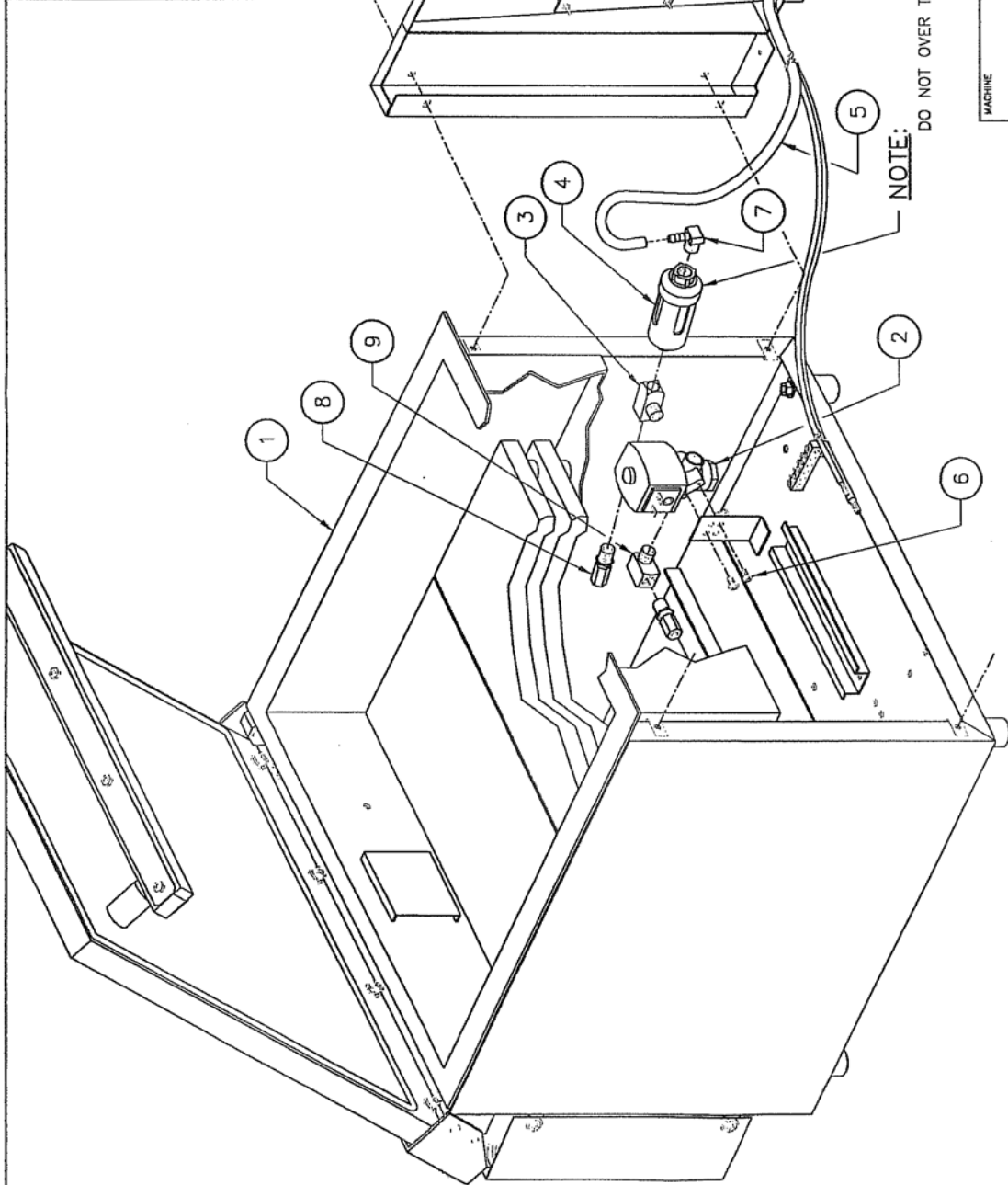
**METRIC TOLERANCE:**  
 .005 ± .001  
 .002 ± .001  
 .001 ± .001  
 .0005 ± .0005  
 .0002 ± .0002  
 .0001 ± .0001  
 ANGLES ± 1°  
 N.T.S.

**DATE** 98-06-05  
**BY** \_\_\_\_\_  
**CHK** \_\_\_\_\_  
**APP** \_\_\_\_\_  
**PROVINCIAL** \_\_\_\_\_  
**DATE** \_\_\_\_\_  
**BY** \_\_\_\_\_  
**CHK** \_\_\_\_\_  
**APP** \_\_\_\_\_

**ST-GERMAIN DE GRANTHAU**  
**QUEBEC CANADA**  
**SIPROMAC**  
**OPTION M-10**  
**1010-0035**

MOD.	#	DATE	INT.
C	103-02-21	J.G.	
B	00-11-09	S.L.	
A	00-11-01	S.L.	

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

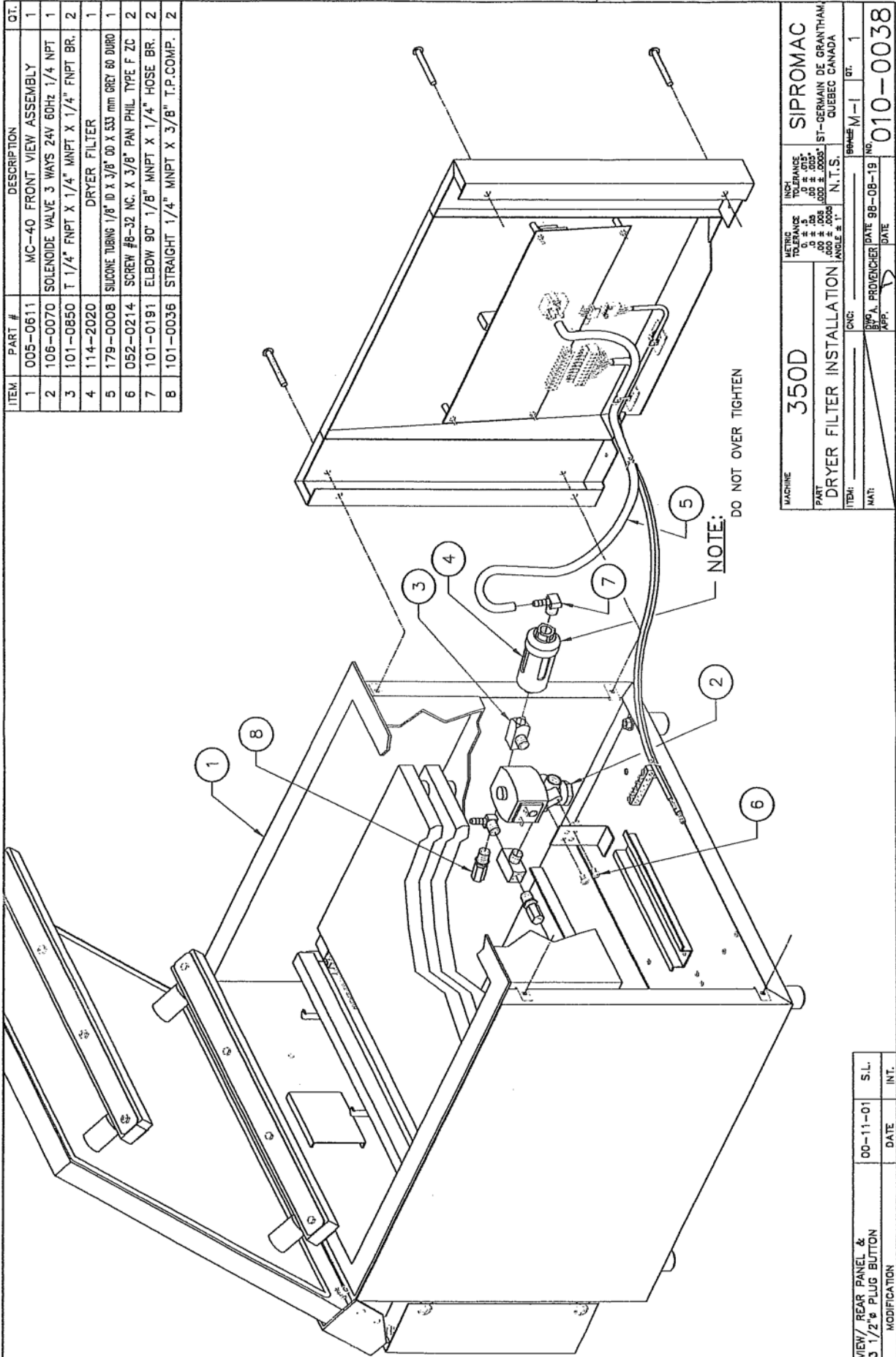


NOTE: DO NOT OVER TIGHTEN

MACHINE	350	INCH TOLERANCE	± .001	FORM M-1	QT.	1
PART	DRYER FILTER INSTALLATION	METRIC TOLERANCE	± .005	NO.	98-06-19	
ITEM:	ONC:	DATE	DATE	SIPROMAC		
MAT:	APP:	DATE		ST-GERMAIN DE GRANTHAM		
				QUEBEC CANADA		
				N.T.S.		
				1010-0037		

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

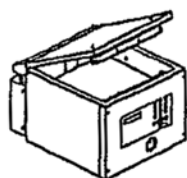
ITEM	PART #	DESCRIPTION	QT.
1	005-0611	MC-40 FRONT VIEW ASSEMBLY	1
2	106-0070	SOLENOID VALVE 3 WAYS 24V 60Hz 1/4 NPT	1
3	101-0850	T 1/4" FNPT X 1/4" MNPT X 1/4" FNPT BR.	2
4	114-2020	DRYER FILTER	1
5	179-0008	SILICONE TUBING 1/8" ID X 3/8" OD X 533 mm GREY 80 DURO	1
6	052-0214	SCREW #8-32 NC. X 3/8" PAN PHIL. TYPE F ZC	2
7	101-0191	ELBOW 90° 1/8" MNPT X 1/4" HOSE BR.	2
8	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	2



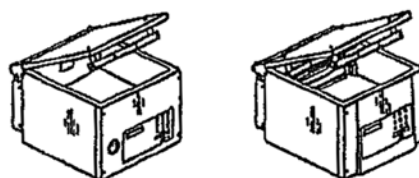
MACHINE	350D	INCH TOLERANCE	± .005	STAMP M-I	QT.	1
PART	DRYER FILTER INSTALLATION	METRIC TOLERANCE	± .000	SIPROMAC	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM		± .000	N.T.S.	DATE	98-08-19	
MAT		DATE		NO.	010-0038	
APP.		DATE				

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

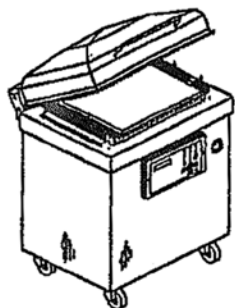
# VACUUM PACKAGING MACHINES



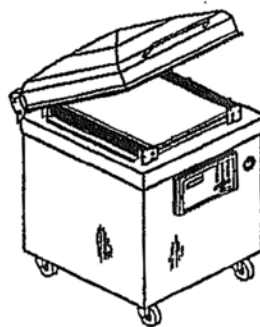
250



350/350D



450A



550A