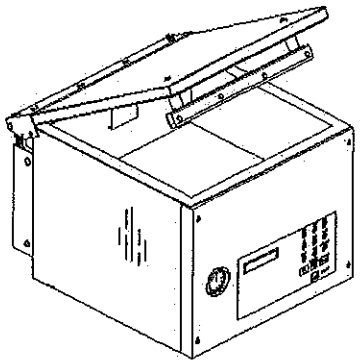
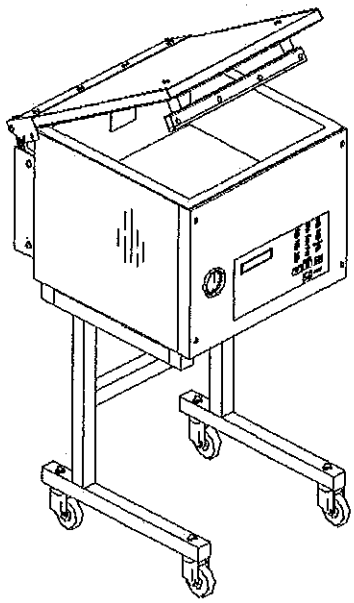
VACUUM PACKAGING MACHINE

MODELS 350 & 350D





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

BK46710

Safe Operation Practices

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

General Operation

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

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

Service

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

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

Warning-Your responsibility:

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

INSTALLATION NOTICE FOR MODELS:

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

IN ORDER TO RESPECT NSF REGULATIONS:

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

VACUUM PACKAGING MACHINE

MODEL 350, 350D

(MC-40)

GENERAL TABLE OF CONTENTS

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

TABLE OF CONTENTS

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 recommanded by the producer. Never exceed maximum quantity of oil indicated, when adding or changing oil. Verify weekly.

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

2. ELECTRICAL CONNECTION:

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

All vacuum machines are supplied with an electrical schematic drawing.

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

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

3.OPERATION:

3.1 Working principles:

A vacuum packaging cycle is made of 3 stages. First the vacuum is made, the air is completly 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.

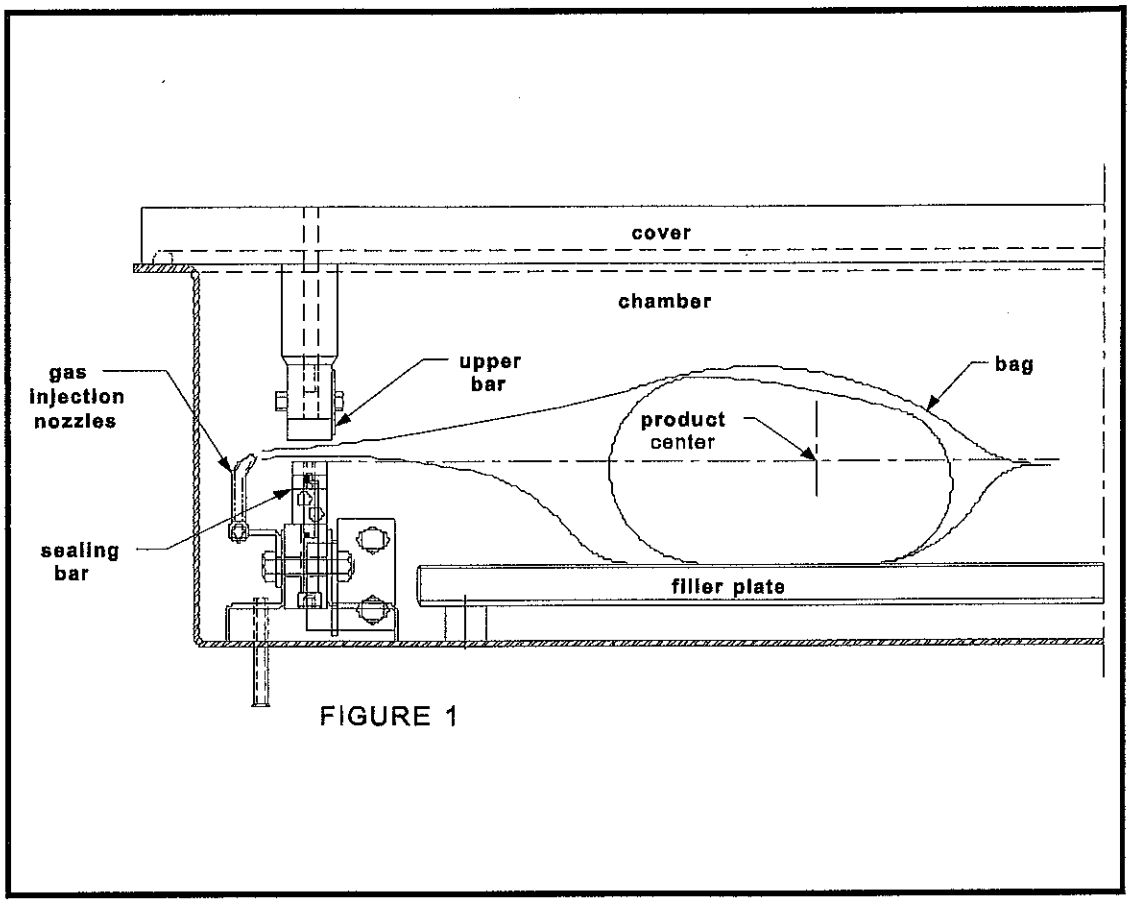


FIGURE 1

3.2 Special packaging:

3.2.1 Gas flushing (option):

There is an atmospheric pressure of 1 kg/ sq. cm (14 lbs/sq. inch) upon products when fully evacuated. Products which can be damaged by high pressure must be packaged with a partial vacuum, or the pressure must be counterbalance by inflating the bag with gas (nitrogen or carbon dioxide) before sealing after evacuation.

For gas flushing, the bags are placed on the sealing bars, the open end placed over the gas nozzles mounted alongside the sealing bar. After evacuation, the vacuum valve closes and the gas valve opens. Gas time (sec.) can be set in the program menu.

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

3.2.2 Electrical bag cut (optional):

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

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 10 and the keyboard detail on page 11.

3.3.1 Basics:

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

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

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

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

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

In program submenu, use key "ESC" to get back to the programs menu. Strike any key to clear the error messages which may be displayed on LCD screen.

3.3.2 Functions menu:

3.3.2.1 Create a program:

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

3.3.2.2 Delete a program:

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

3.3.2.3 Select operating mode:

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

3.3.3 Programs menu:

3.3.3.1 Program identification:

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

Example: EXAMPLE 1 (9 characters)

→ keys 2, 2, ENTER	→	E
keys 8, 8, 8, ENTER	→	X
keys 1, ENTER	→	A
keys 5, ENTER	→	M
keys 6, ENTER	→	P
keys 4, 4, 4, ENTER	→	L
keys 2, 2, ENTER	→	E
keys 9, 9, 9, ENTER	→	space
keys 1, 1, 1, 1, ENTER	→	1

key ENTER to validate the characters string

3.3.3.2 Vacuum time setting:

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

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

3.3.3.3 Gas time setting:

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

3.3.3.4 Sealing time setting:

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

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

3.3.4 Vacuum cycle execution:

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

- vacuum time status during vacuum sequence,
- gas time status during gas flush sequence,
- sealing time status during sealing sequence,
- ATM message level during atmosphere sequence.7

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

3.3.5 System monitor:

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

-MENUS STRUCTURE-

- **Functions menu:**
  "F1 CREATE A PRGM"
  "F2 DELETE A PRGM"
  "F3 SELECT OPMODE" (automatic units only)

- **Programs menu:**
  "Pxx NAME"
  Program submenu:

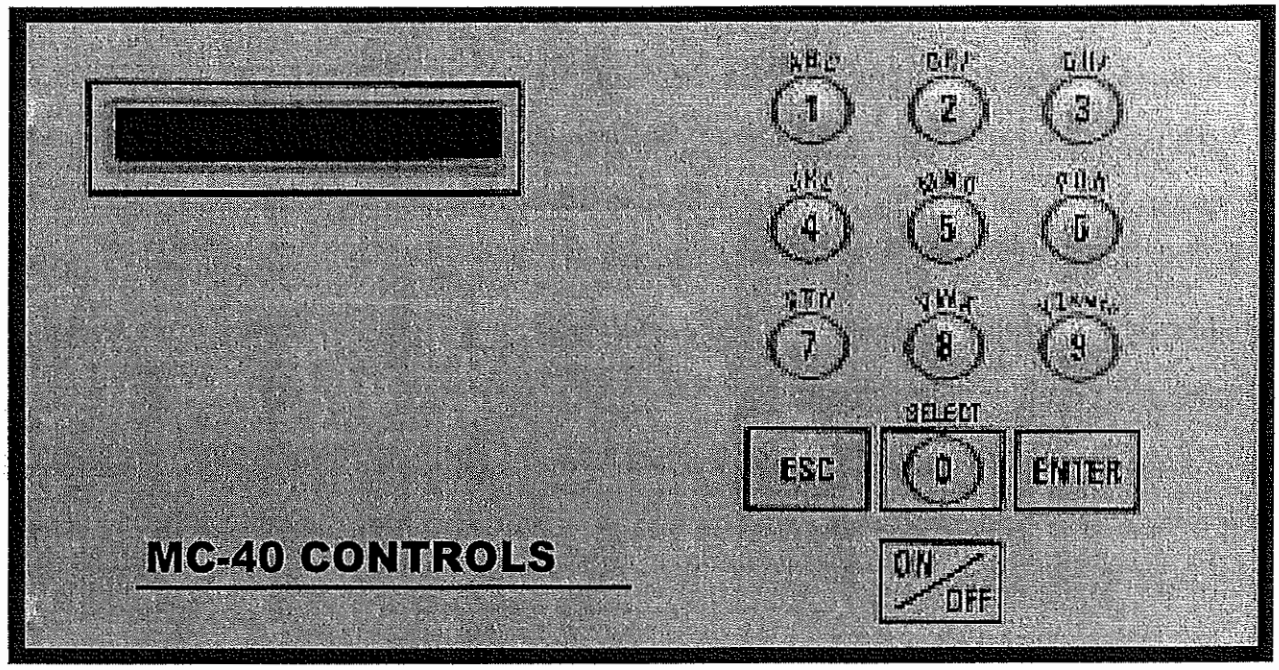
"VACUUM: xx.xs"	(10 – 199s)
"GAS FLUSH: xx.xs"	(0 – 99s) (units with gas option)
"SEAL TIME: x.xxs"	(0.00s - maximum unit allocated setting)
"Pxx NAME"	(12 characters)

- **Diagnostics menu** (keys "ESC" & "POWER" for access):

"DIAGNOSTICS MENU" (access code required)
"D1 INPUTS TEST"
"D2 OUTPUTS TEST"
"D3 MODEL SELECT"
"D4 GAS OPTION"
"D5 SEALING TIME"
"D6 COOLING TIME"
"D7 OFFSET CALIB."
"D8 VACUUM SENSOR"
"D9 SIPROMAC PUB"
"D10 LOADING TIME" (automatic units only)
"D11 UNLOADNG TIME" (automatic units only)
"SYSTEM MONITOR" (no access code required)
"SOFTWARE: R x.xx"
"WORK HRS: xxxxx"
"CYCLES: xxxxxxx"

-KEYBOARD DETAILS-

MC-40 CONTROLS



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

3.4 Daily cleaning:

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

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

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

Verify at vacuum hose connections and valve connections.

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

Warning: Verify connections of measuring equipment before verifying machine.

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

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

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

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

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

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

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

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

4.4 Fault in the valve:

Vacuum or air valve does not open.

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

4.5 MC40 Control board failure

NOTE: Refer to menu structure on page 9.

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

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

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

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

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

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

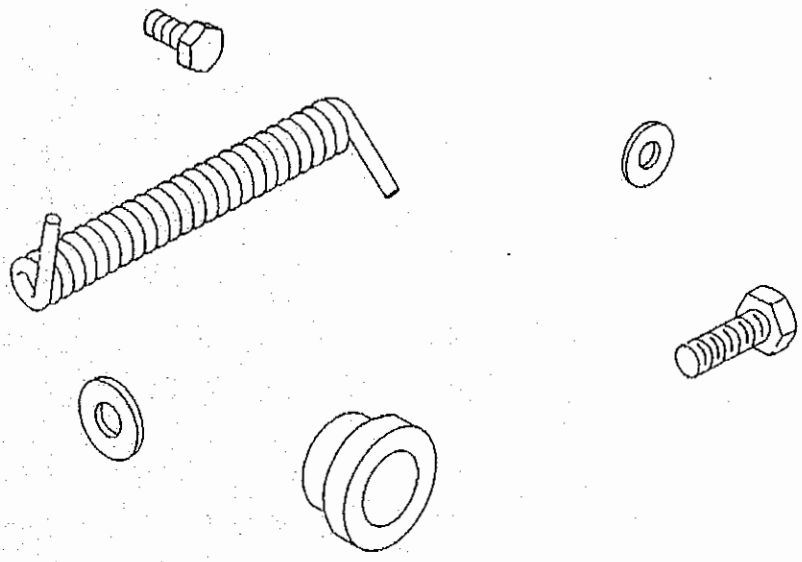
Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

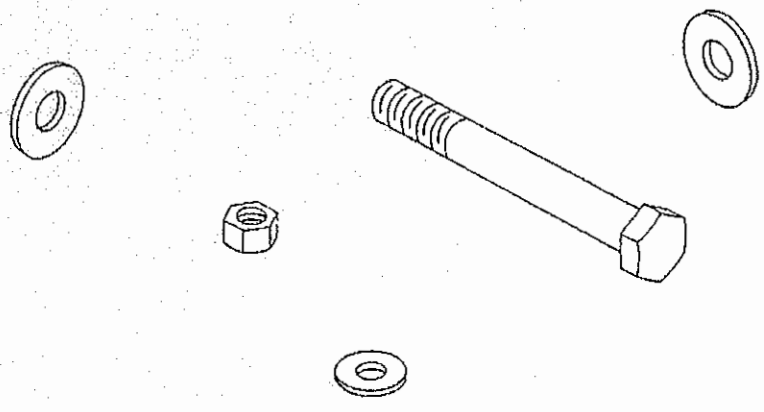
Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

Check vacuum in chamber with precision vacuumeter.

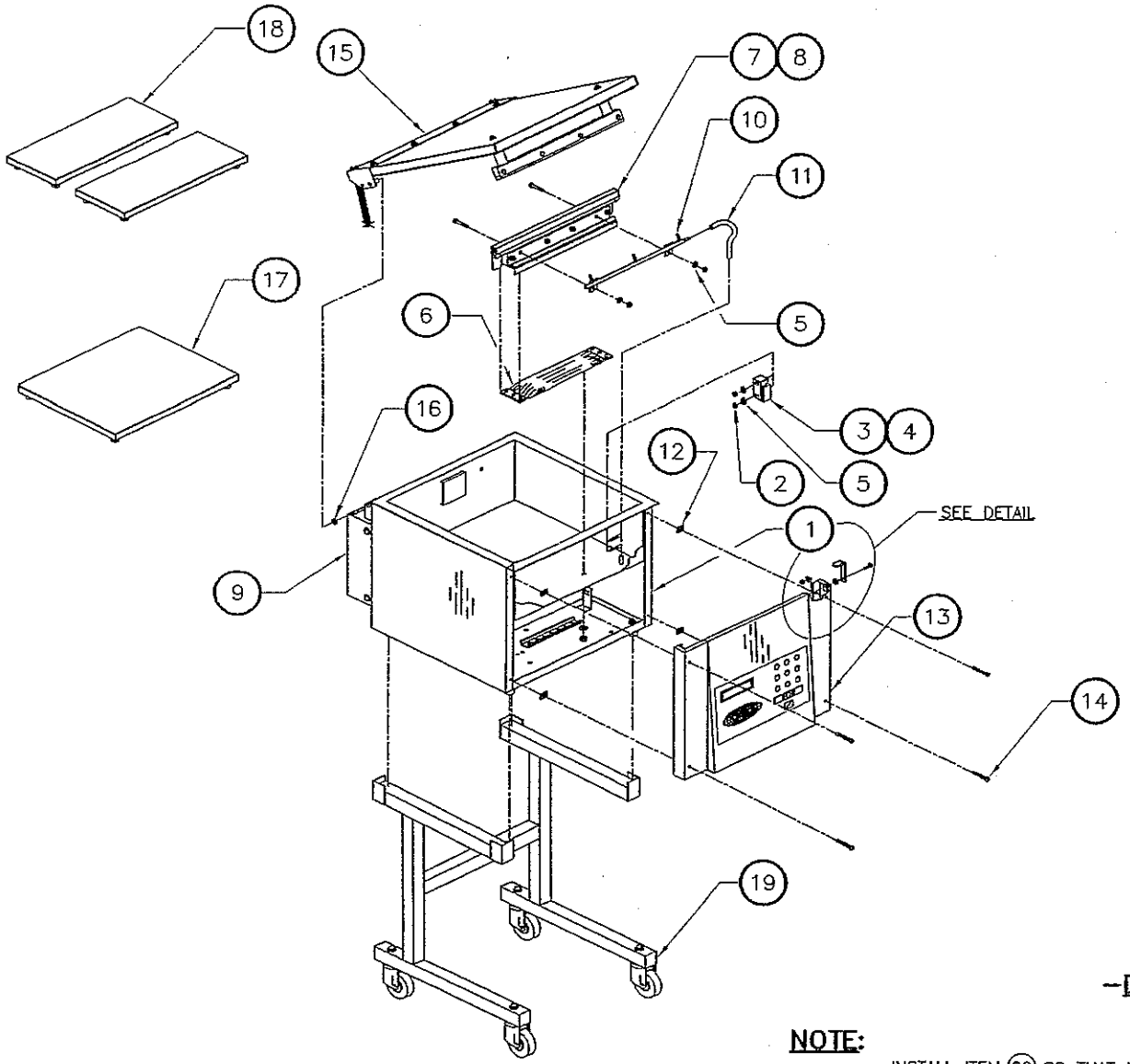
Check function of cycle with various settings of timers.



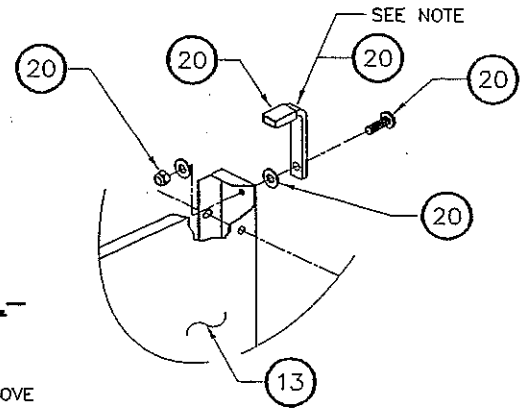
MECHANICAL DRAWING



005-0610



ITEM	#PART	DESCRIPTION	QT.
1	004-0229	VACUUM 350 PRE-ASSEMBLY	1
2	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	4
3	002-0029	LEFT SEAL BAR GUIDE BLOCK	1
4	002-0030	RIGHT SEAL BAR GUIDE BLOCK	1
5	051-0740	FLAT WASHER 1/4" S/S	7
6	005A0045	BELLOWS ASSEMBLY	1
7	005-0046	SEAL BAR ASSEMBLY W/ SUPPORT	1
8	005-0558	BAG CUT SEAL BAR ASS'Y W/ SUPPORT (OPT.)	1
9	004-0446	REAR PANNEL PRE-ASSEMBLY	1
10	005B0042	GAS INJECTION BAR ASS'Y (OPT.)	1
11	008-0464	GAS INJECTION CONNECTION TUBE (OPT.)	1
12	056-0020	SPRING NUT 1/4"-20 NC.	4
13	005-0609	MC-40 FRONT PANNEL ASSEMBLY	1
14	051-0264	SCREW 1/4"-20 NC. X 2" PAN PHIL. S/S	4
15	005-0266	COVER ASSEMBLY	1
16	058-0030	SPACERS	2
17	005-0278	FILLER PLATE ASSEMBLY	1
18	005-0364	HALF FILLER PLATE ASSEMBLY	2
19	005-0037	STAND ASSEMBLY (OPT.)	1
20	004A1651	COVER HOLD DOWN PRE-ASS'Y	1



-DETAIL-

NOTE:

- INSTALL ITEM (20) SO THAT IT CAN MOVE FREELY BUT WITHOUT TOO MUCH LOOSENESS

NOTE:

- FOR GAS INJECTION KIT INSTALLATION SEE DRAWING NO. 010-0034

NOTE:

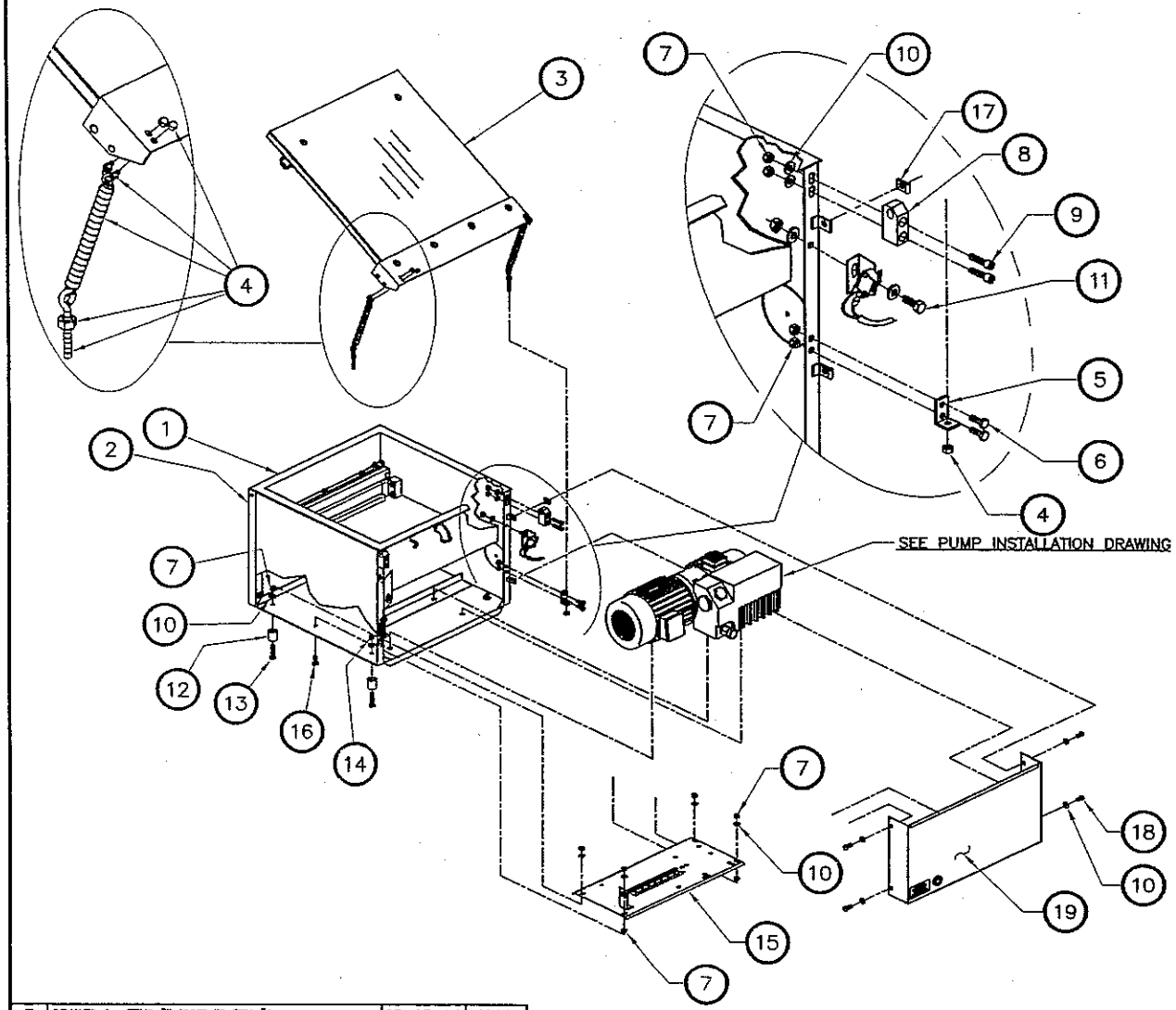
- USE THIS DRAWING ALONG WITH DRAWING NO. 005-0612 TO ASSEMBLE THE MACHINE. NO PARTICULAR ORDER SHOWN.

LET.	MODIFICATION	DATE	INT.
B	MODIF. #A-0351 COVER HOLD DOWN ÉTAIT OPTIONNEL	04-06-11	J.C.
A	MODIFIED VIEW STRUCTURE & REAR PANEL/ ANNULED #057-0550 PLASTIC PLUG BUTTON 3 1/2"ø	00-10-31	S.L.

MACHINE: 350	TOLERANCE: METRIC / INCH	SIPROMAC	
PART: MC-40 FRONT VIEW ASSEMBLY	USINAGE ± 0.1 / ± 0.004"	ST-GERMAIN DE GRANTHAM QUÉBEC CANADA	
	TOLÉRIE ± 0.5 / ± 0.020"		
	SOUDAGE ± 0.5 / ± 0.020"		
	N.T.S.		
ITEM:	CNC:	M-I	QT. 1
MAT:	DWG BY A.P. DATE 98-05-01	NO. 005-0610	
	APP. DATE 04-06-30		

005–0612

ITEM	#PART	DESCRIPTION	QT.
1	004–0229	VACUUM 350 PRE–ASSEMBLY	1
2	004–0445	MC–40 FRONT PANNEL PRE–ASS'Y	1
3	005–0266	COVER ASSEMBLY	1
4	004A1224	SPRING ASSEMBLY	2
5	001–1337	SPRING SUPPORT	2
6	051–0180	HEX. BOLT 1/4"–20 NC. X 1/2" S/S	4
7	051–0580	HEX. NUT 1/4"–20 NC. S/S	16
8	002–0024	HINGE BLOCK	2
9	051–0232	SCREW 1/4–20x 1–1/4"SKT CAP SS	4
10	051–0740	FLAT WASHER 1/4"	16
11	004–0261	LIMIT SWITCH ASSEMBLY	1
12	002–0022	FEET	4
13	051–0250	HEX. BOLT 1/4"–20 NC. X 1 1/2" S/S	4
14	051–0581	HEX. NUT 1/4"–20 NC. NYLON LOCK S/S	2
15	004–0042	ELECTRICAL SUPPORT PRE–ASS'Y	1
16	051–0190	HEX. BOLT 1/4"–20 NC. X 3/4" S/S	2
17	056–0002	SPRING NUT 1/4"–20 NC.	4
18	051–0185	SCREW 1/4"–20 NC. X 1/2" PAN PHIL. S/S	4
19	004–0361	REAR PANNEL PRE–ASSEMBLY	1



NOTE: – USE THIS DRAWING ALONG WITH DRAWING NO. 005–0610 TO ASSEMBLE THE MACHINE NO PARTICULAR ORDER SHOWN.

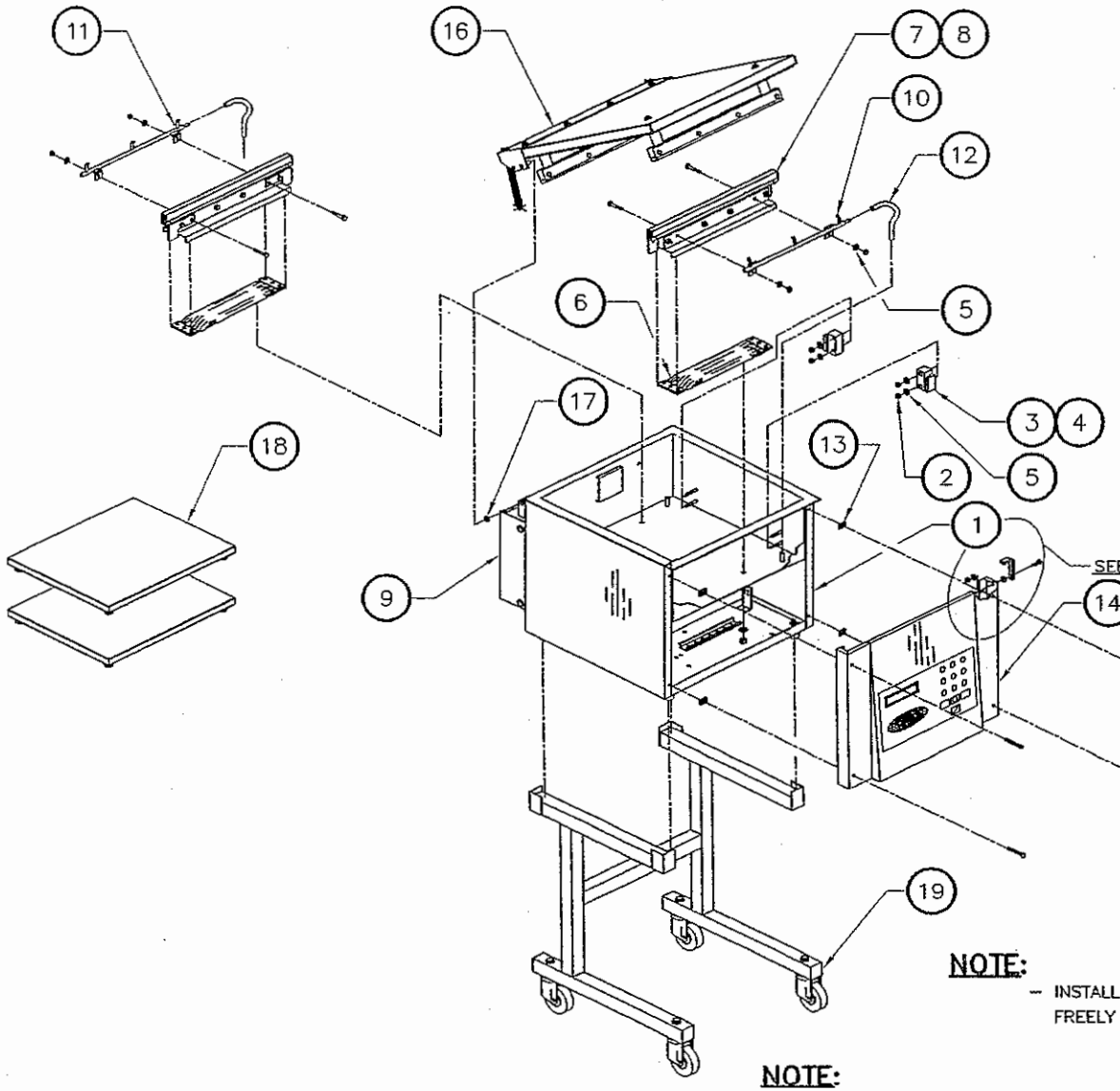
LET.	MODIFICATION	DATE	INT.
E	REMOVED 4 x ITEMS #7 ADDED TO ITEM #4	05–05–04	M.A.L.
D	#9 051–0232 WAS 051–0251, #7 051–0580 WAS #14 051–0581	04–11–22	M.A.L.
C	MODIFIED VIEW ITEM #1 & REMOVED "CONDENSATOR"	00–11–09	S.L.
B	ITEM #7 130–5025 WAS 056–0015 MODIFIED ASS'Y	98–11–24	S.L.
A	REDRAWN / MODIFED VIEW 004–0361 WAS 004–0446	98–11–23	S.L.

MACHINE: 350
PART: MC–40 REAR VIEW ASSEMBLY
ITEM:
MAT:
CNC:
TOLERANCE: USINAGE / TOLERE / SOUDAGE — METRIC ± 0.1 / ± 0.5 / ± 0.5 — INCH ± 0.004" / ± 0.020" / ± 0.020"
N.T.S.
DWG BY: A.P.
APP.
DATE: 98–06–02
DATE:
M–I
QT. 1
NO. 005–0612

SIPROMAC
ST–GERMAIN DE GRANTHAM
QUEBEC CANADA

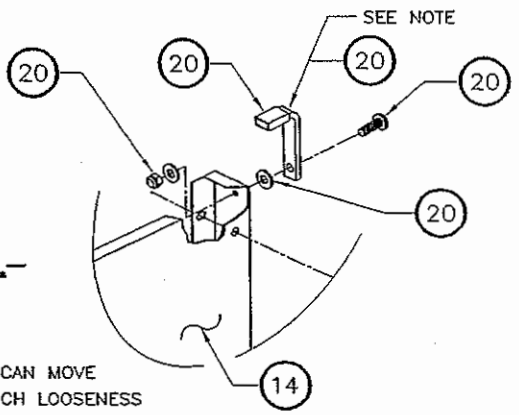
005-0611

NOTE:
- FOR GAS INJECTION KIT INSTALLATION SEE DRAWING NO. 010-0035



ITEM	#PART	DESCRIPTION	QT.
1	004-0230	VACUUM 350D PRE-ASSEMBLY	1
2	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	8
3	002-0029	LEFT SEAL BAR GUIDE BLOCK	2
4	002-0030	RIGHT SEAL BAR GUIDE BLOCK	2
5	051-0740	FLAT WASHER 1/4" S/S	14
6	005A0045	BELLOWS ASSEMBLY	2
7	005-0046	SEAL BAR ASSEMBLY W/ SUPPORT	2
8	005-0558	BAG CUT SEAL BAR ASS'Y W/ SUPPORT (OPT.)	2
9	004-0446	REAR PANNEL PRE-ASSEMBLY	1
10	005B0042	FRONT GAS INJECTION BAR ASS'Y (OPT.)	1
11	005A0807	REAR GAS INJECTION BAR ASS'Y (OPT.)	1
12	008-0464	GAS INJECTION CONNECTION TUBE (OPT.)	2
13	056-0020	SPRING NUT 1/4"-20 NC. .	4
14	005-0609	MC-40 FRONT PANNEL ASSEMBLY	1
15	051-0264	SCREW 1/4"-20 NC. X 2" PAN PHIL. S/S	4
16	005-0481	COVER ASSEMBLY	1
17	058-0030	SPACERS	2
18	005-0365	FILLER PLATE ASSEMBLY	2
19	005-0037	STAND ASSEMBLY (OPT.)	1
20	004A1651	COVER HOLD DOWN PRE-ASS'Y	1

-DETAIL-



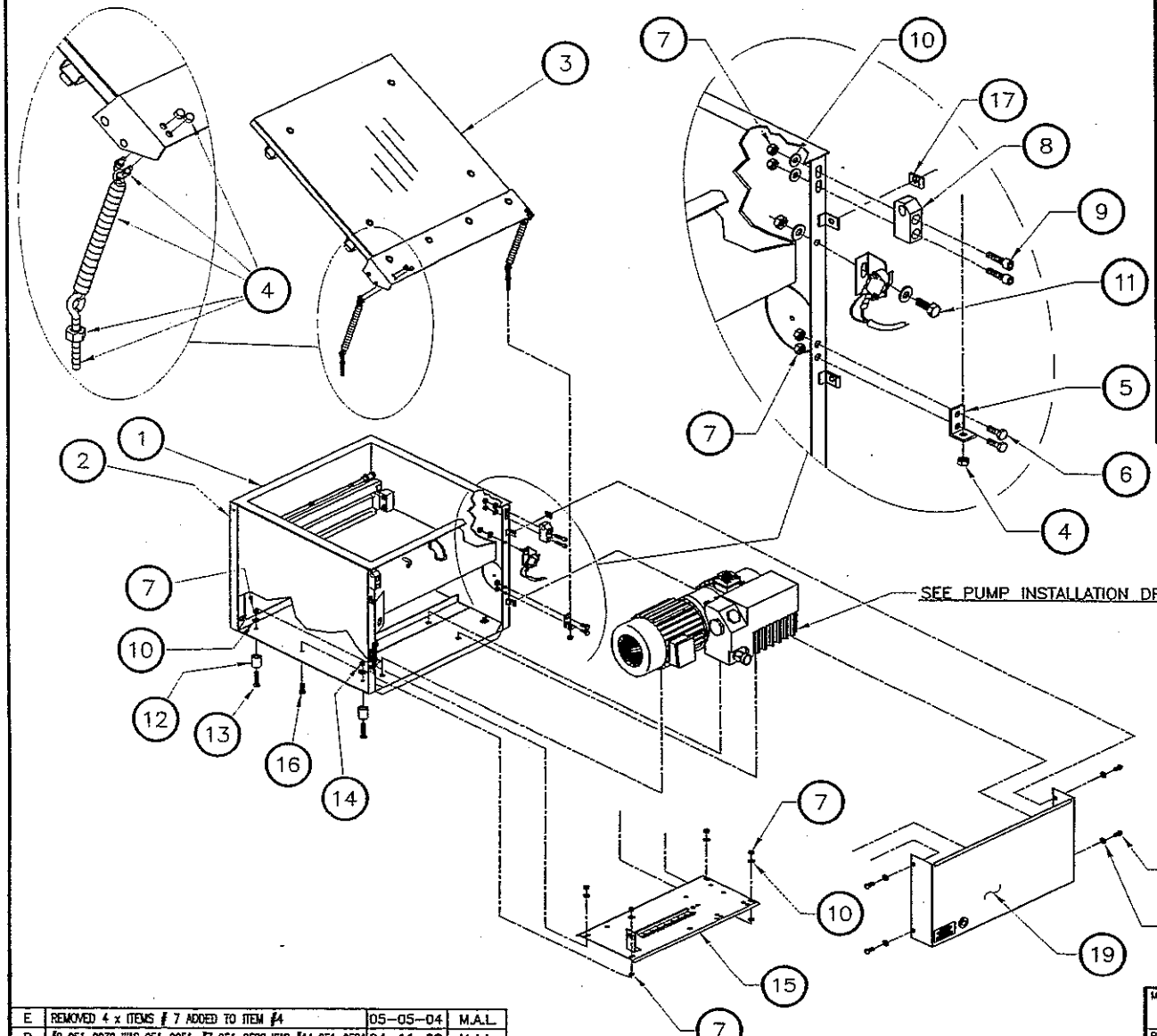
NOTE:
- INSTALL ITEM (20) SO THAT IT CAN MOVE FREELY BUT WITHOUT TOO MUCH LOOSENESS

NOTE:
- USE THIS DRAWING ALONG WITH DRAWING NO. 005-0613 TO ASSEMBLE THE MACHINE. NO PARTICULAR ORDER SHOWN.

LET.	MODIFICATION	DATE	INT.
C	MODIF. #A-0351 COVER HOLD DOWN ÉTAIT OPTIONNEL	04-06-11	J.G.
B	MODIF. #A-358 GAS FLUSH AV./ARR. GAUCHE/DROITE	03-02-21	J.G.
A	MODIFIED VIEW STRUCTURE & REAR PANEL/ ANNULED #057-0550 PLASTIC PLUG BUTTON 3 1/2"ø	00-10-31	S.L.

MACHINE: 350D
PART: MC-40 FRONT VIEW ASSEMBLY
TOLERANCE: USINAGE ± 0.1 (± 0.004") / TOLERIC ± 0.5 (± 0.020") / SOUDAGE ± 0.5 (± 0.020") — N.T.S.
SIPROMAC — ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM: — CNC: — M-1 — QT. 1
MAT: — DWG BY A.P. — DATE 98-06-01 — APP. — DATE 99-08-30 — NO. 005-0611

005-0613



ITEM	#PART	DESCRIPTION	QT.
1	004-0230	VACUUM 350D PRE-ASSEMBLY	1
2	004-0445	MC-40 FRONT PANNEL PRE-ASS'Y	1
3	005-0481	COVER ASSEMBLY	1
4	004A1224	SPRING ASSEMBLY	2
5	001-1337	SPRING SUPPORT	2
6	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	4
7	051-0580	HEX. NUT 1/4"-20 NC. S/S	16
8	002-0024	HINGE BLOCK	2
9	051-0232	SCREW 1/4-20x 1-1/4"SKT CAP SS	4
10	051-0740	FLAT WASHER 1/4"	16
11	004-0261	LIMIT SWITCH ASSEMBLY	1
12	002-0022	FEET	4
13	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	4
14	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	2
15	004-0042	ELECTRICAL SUPPORT PRE-ASS'Y	1
16	051-0190	HEX. BOLT 1/4"-20 NC. X 3/4" S/S	2
17	056-0002	SPRING NUT 1/4"-20 NC.	4
18	051-0185	SCREW 1/4"-20 NC. X 1/2" PAN PHIL S/S	4
19	004-0361	REAR PANNEL PRE-ASSEMBLY	1

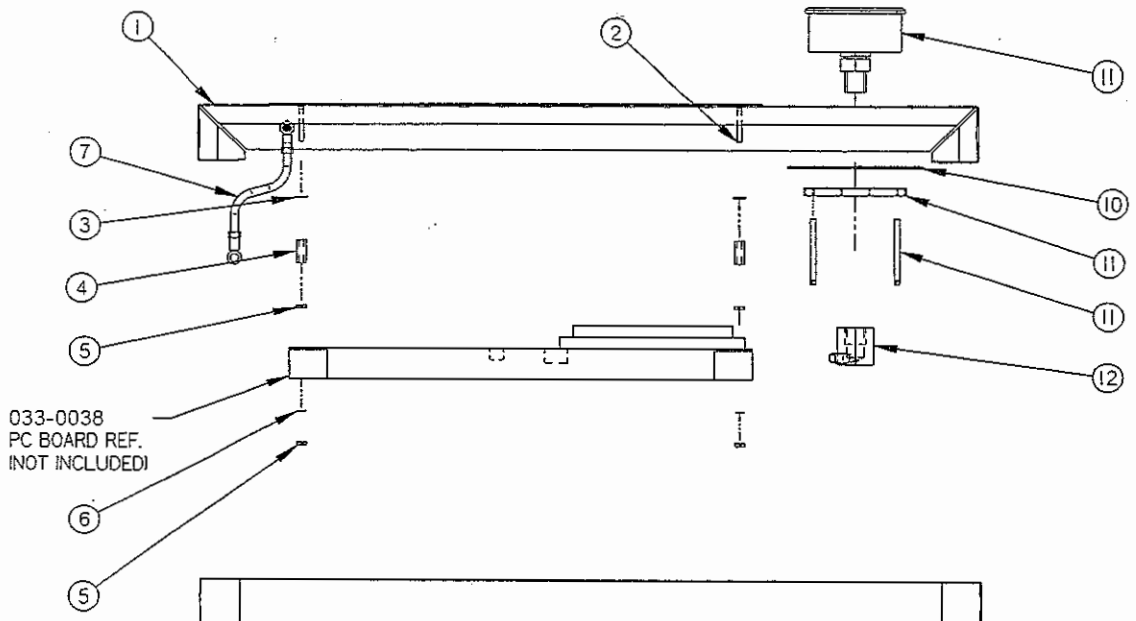
NOTE: - USE THIS DRAWING ALONG WITH DRAWING NO. 005-0611 TO ASSEMBLE THE MACHINE NO PARTICULAR ORDER SHOWN.

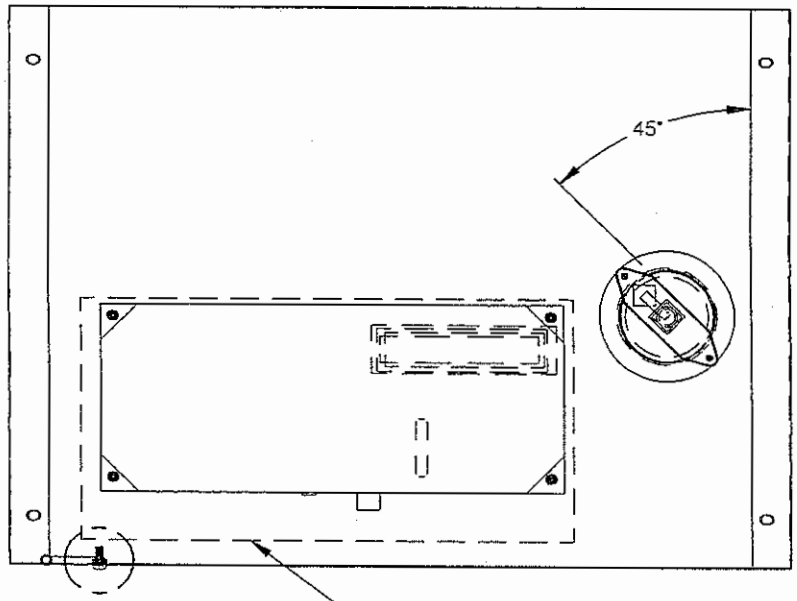
LET.	MODIFICATION	DATE	INT.
E	REMOVED 4 x ITEMS # 7 ADDED TO ITEM #4	05-05-04	M.A.L.
D	#9 051-0232 WAS 051-0251, #7 051-0580 WAS #14 051-0581	04-11-22	M.A.L.
C	MODIFIED VIEW ITEM #1 & REMOVED "CONDENSATOR"	00-11-09	S.L.
B	ITEM #7 130-5025 WAS 056-0015 MODIFIED ASS'Y	98-11-25	S.L.
A	REDRAWN / MODIFED VIEW 004-0361 WAS 004-0446	98-11-23	S.L.

MACHINE: 350D
PART: MC-40 REAR VIEW ASSEMBLY
ITEM:
MAT:
CNC:
TOLERANCE: METRIC / INCH — USINAGE ± 0.1 / ± 0.004" — TOLERIE ± 0.5 / ± 0.020" — SOUDAGE ± 0.5 / ± 0.020"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
M-I
QT. 1
DWG BY A.P. DATE 98-06-02
APP. DATE
NO. 005-0613

005B0832

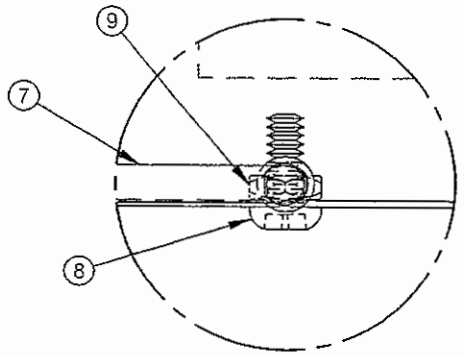
ITEM	PART #	DESCRIPTION	QT.
1	001B3123	FRONT FLAT PANEL	1
2	051-0089	SCREW 4-40 x 1" FLAT SLOT SS	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	8
6	051-0715	WASHER #4 LOCK SS	4
7		GROUND WIRE	1
8	051-0144	SCREW #10-24 N.C 1/2"PAN PHIL. S/S	1
9	051-0571	NUT #10-24 S/S	1
10	001-1869	VACCUM GAGE FIXATION RING	1
11	114-0260	VACUUM GAGE W/ SUPPORT	1
12	101-0160	ELBOW 90° 1/4FNPTx1/4"HOSE	1





A

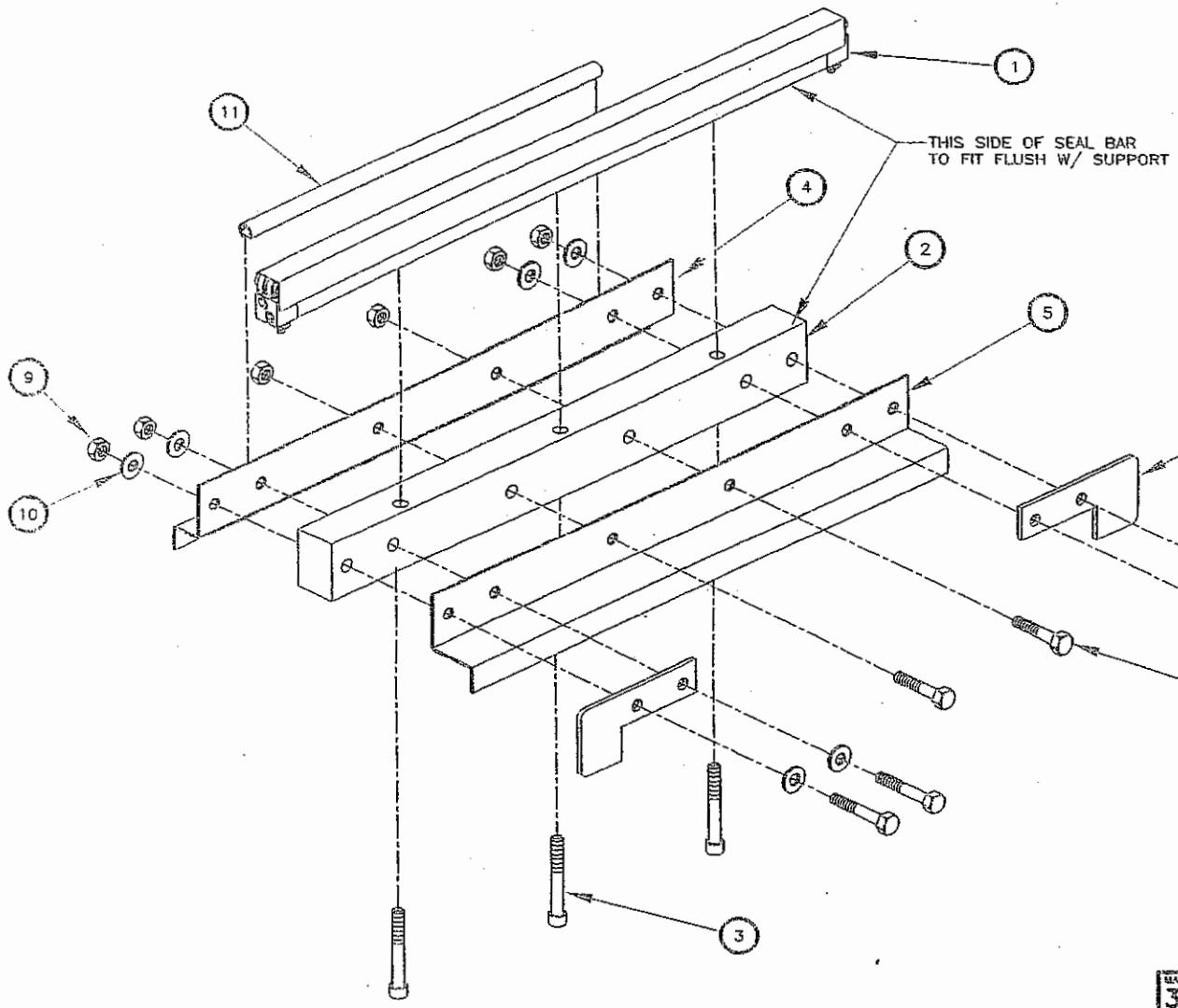
POSITION CAREFULLY IN REGARDS
TO OPENING IN ITEM #1



DETAIL A

LET.	MODIFICATION	DATE	INT.

MACHINE: 350 & 350D	DEPT. TOL. USINAGE / TOLERIE / SOUDAGE — METRIC: ± 0.1 / ± 0.5 / ± 0.5 — INCH: ± 0.004" / ± 0.020" / ± 0.020"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART: MC-40 FRONT FLAT PANEL ASS'Y	N.T.S.		
ITEM:	CNC:	DEPT. M	QTY. 1
MAT.	DWG BY M.A.L. DATE 04-11-30	NO. 005B0832	
	APP. BY DATE 05-01-03		



ITEM	PART #	DESCRIPTION	QT.
1	005--0267	SEAL BAR PRE-ASSEMBLY	1
2	002A0509	SEAL BAR SUPPORT (TABLE)	1
3	051-0256	CAP HEX. SKT. BOLT 1/4"-20 NC X 1 3/4" S/S	3
4	001A1952	EXTERIOR BELLOWS COVER	1
5	001-1953	INTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0255	HEX. BOLT 1/4"-20 NC. X 1 3/4" S/S	4
8	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	2
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	6
10	051-0740	FLAT WASHER 1/4" S/S	8
11	038-0230	SYNERGIC DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 267) PVC (0.92)	1

MACHINE	QTY
420A	4
350D	2
350	1

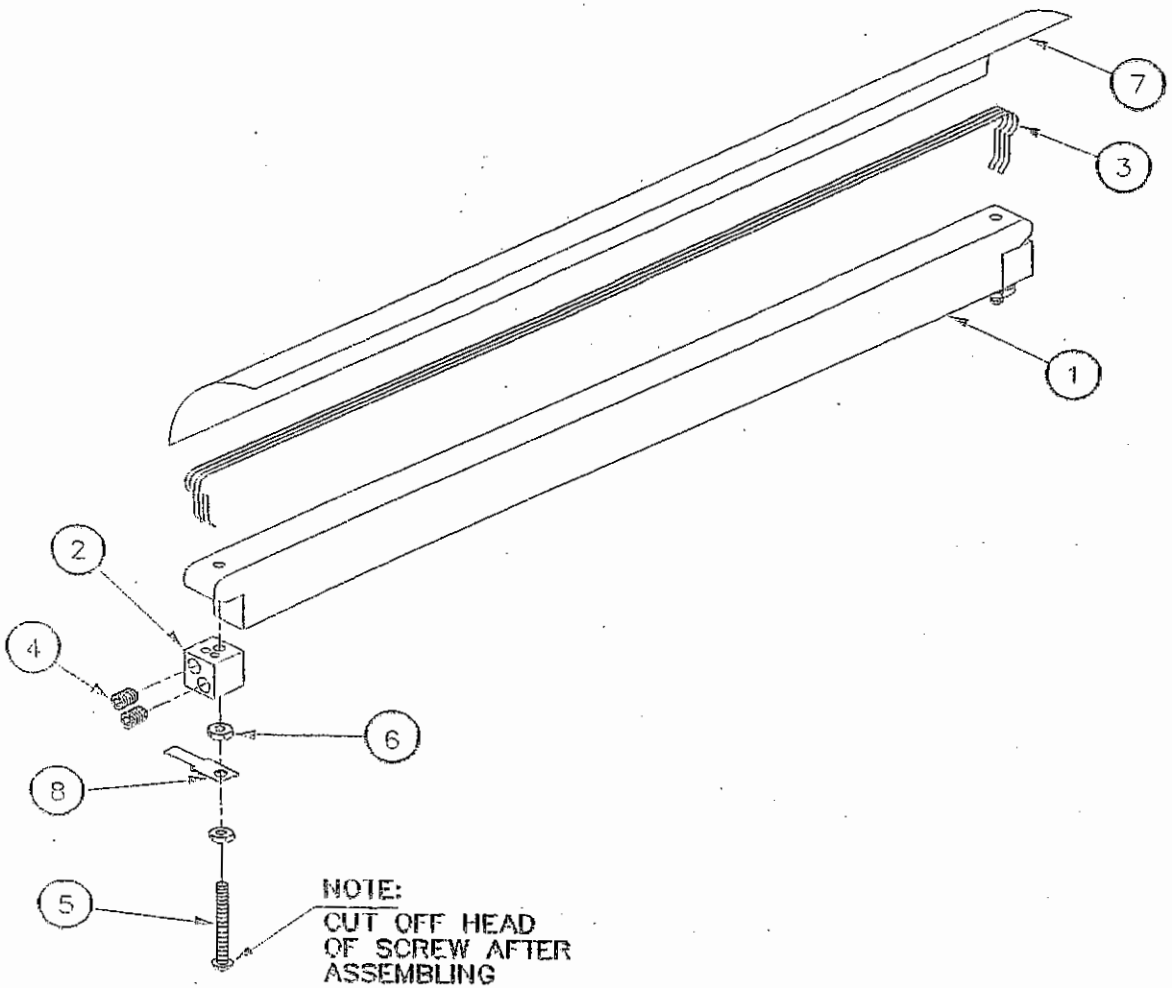
MACHINE: 300, 350, 350D & 420A
PART: SEAL BAR ASSEMBLY W/ SUPPORT
METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°
INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:
CHG:
SCALE
QT. SEE LIST
MAT:
DWG BY M.A.LEBLANC DATE 05-05-09
CHK'D DATE 05-05-11
NO. 005A0046

LT.	MODIFICATION	DATE	INT.
D	REDRAWN/ADDED 300	05-05-09	M.A.L.

005A0046

005-0267

ITEM	#PART	DESCRIPTION	QT.
1	002-0015	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEM. STD TWIN (2x566 mm EA.)	3.90
4	052-0395	SET SCREW 1/4"-20 X 5/16" (OVAL POINT)	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 (436mm EA.)	0.055
8	027-0400	CONNECTOR ADAPTOR	2

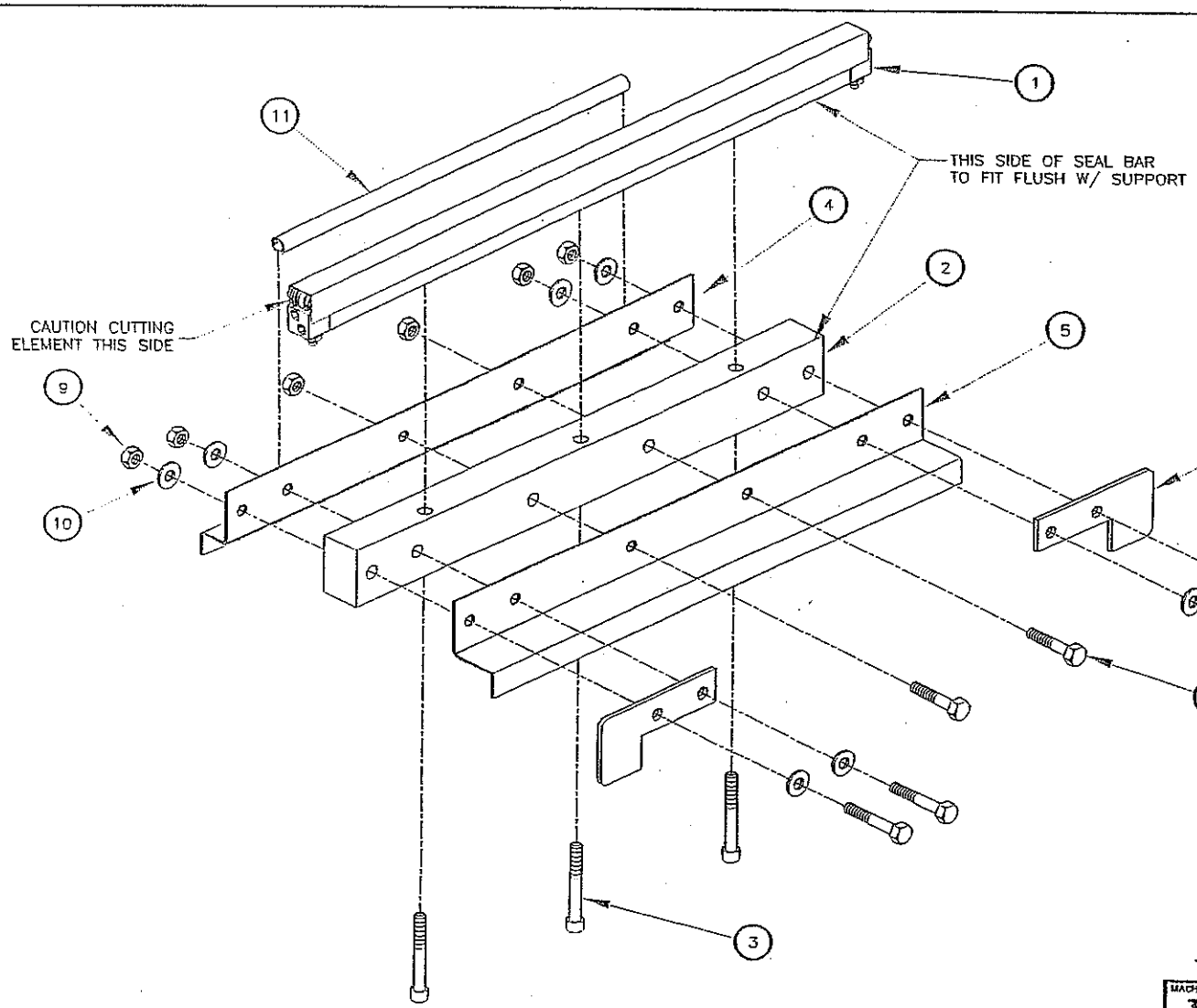


MACHINE	QTY
420A	4
350D	2
350	1
300	1

MACHINE: 300, 350, 350D & 420A
PART: SEAL BAR PRE-ASSEMBLY
ITEM:
QTY: M | QT. SEE LIST
MAT:
TOLERANCE (METRIC / INCH): USINAGE ± 0.1 / ± 0.004"; TOLÉRIE ± 0.5 / ± 0.020"; SOUDAGE ± 0.5 / ± 0.020"
N.T.S.
DWN BY A. PROVENCHER | DATE 97-09-03
APP. | DATE
NO. 005-0267

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

LET.	MODIFICATION	DATE	INT.
E	ADDED 300	05-09-27	M.A.L.
D	MODIFICATION #A-0388 (CONNECTEUR)	04-04-19	J.G.
C	REDRAWN/ MODIF. A-0216	97-09-03	A.P.



ITEM	PART #	DESCRIPTION	QT.
1	005-0382	SEAL BAR PRE-ASSEMBLY	1
2	002A0509	SEAL BAR SUPPORT (TABLE)	1
3	051-0256	CAP HEX. SKT. BOLT 1/4"-20 NC X 1 3/4" S/S	3
4	001A1952	EXTERIOR BELLOWS COVER	1
5	001-1953	INTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0255	HEX. BOLT 1/4"-20 NC. X 1 3/4" S/S	4
8	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	2
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	6
10	051-0740	FLAT WASHER 1/4" S/S	8
11	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 267) PVC (0.92)	1

-BAG CUT OPTION-

	QTY
420A	4
350D	2
350	1
300	1
MACHINE	QTY

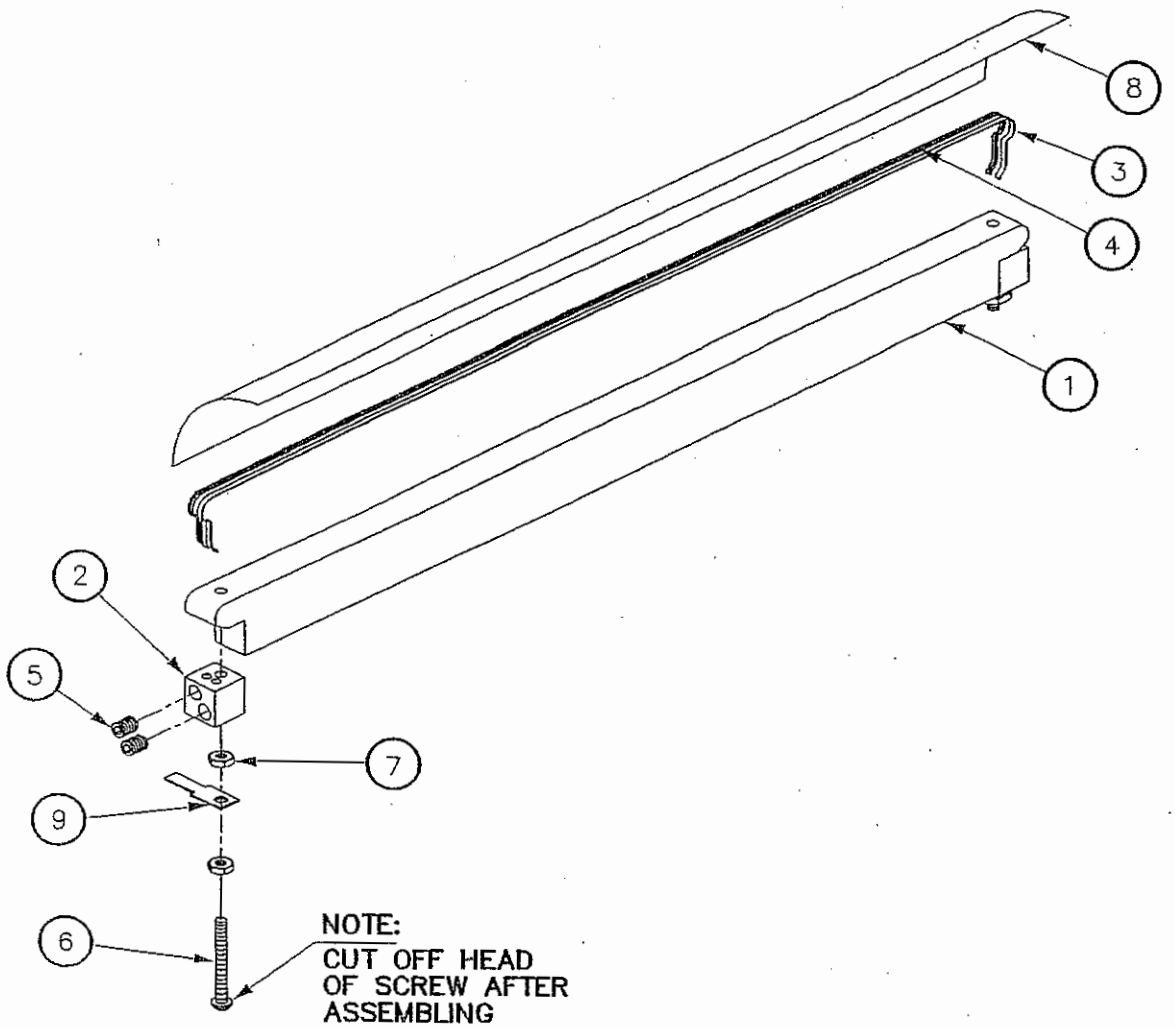
REDRAWN	05-05-09	M.A.L.
MODIFICATION	DATE	INT.

MACHINE: 300, 350, 350D & 420A
PART: SEAL BAR ASSEMBLY W/ SUPPORT
METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°
INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:
CHG:
SCALE:
QT: SEE LIST
MAT:
DWN BY: MA.LEBLANC DATE 05-05-09
APP: DATE 05-06-22
NO. 005A0558

005A0558

005-0382

ITEM	#PART	DESCRIPTION	QT.
1	002-0015	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0230	REFLEX BAND 2.5 MM (566mm EA.)	0.057
4	039-0270	"T" PROFILE CUT. ELEM. (566mm EA.)	0.057
5	052-0395	SET SCREW 1/4"-20 X 5/16" (OVAL POINT)	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 (436mm EA.)	0.055
9	027-0400	CONNECTOR ADAPTOR	2

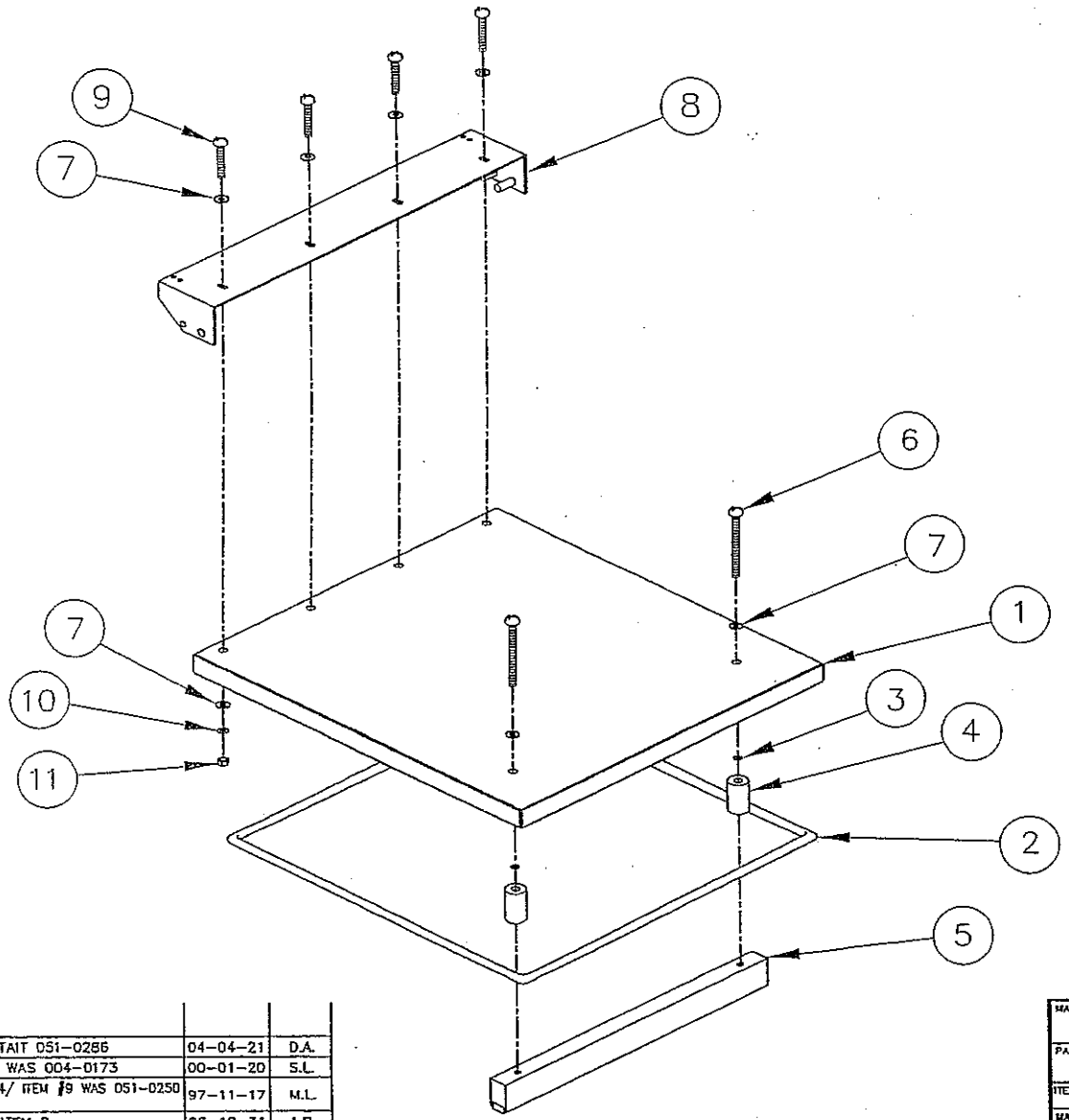


-BAG CUT OPTION-

MACHINE	QTY
420A	4
350D	2
350	1
300	1

LET.	MODIFICATION	DATE	INT.
F	MODIFICATION #A-0398 (CONNECTEUR)	04-04-19	J.G.
E	ADDED 300	98-06-03	L.M.
D	REDRAWN/ MODIF. A-0216	97-09-03	A.P.

MACHINE: 300, 350, 350D & 420A
PART: SEAL BAR PRE-ASSEMBLY
TOLERANCE: USINAGE ± 0.1 (± 0.004") TOLERIE ± 0.5 (± 0.020") SOUDAGE ± 0.5 (± 0.020")
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA
ITEM:
CNC:
MAT:
DWG BY A.P. DATE 97-09-03
APP. DATE 04-06-04
M
QT. SEE LIST
NO. 005-0382



ITEM	PART #	DESCRIPTION	QT.
1	002-0025	COVER	1
2	179-0005	COVER GASKET	6.6
3	076-0010	"O" RING	2
4	002-0026	UPPER SEAL BAR SPACER	2
5	004A0173	UPPER SEAL BAR ASS'Y	1
6	051-0289	SCREW 1/4"-20 NC. x 3 1/2" PAN PHIL S/S	2
7	051-0740	FLAT WASHER 1/4" S/S	10
8	004-0021	COVER HINGE ASS'Y	1
9	051-0249	SCREW 1/4"-20 NC. X 1 1/2" PAN PHIL S/S	4
10	051-0750	LOCK WASHER 1/4" S/S	4
11	051-0580	HEX. NUT 1/4"-20 NC S/S	4

LET.	MODIFICATION	DATE	INT.
E	ITEM 6 051-0289 ETAIT 051-0286	04-04-21	D.A.
D	REDRAWN 004A0173 WAS 004-0173	00-01-20	S.L.
C	ITEM #6 WAS 051-0284/ ITEM #9 WAS 051-0250 FOR N.S.F.	97-11-17	M.L.
B	REDRAWN/MODIFIED ITEM 8	96-10-31	A.P.

MACHINE: 350

PART: COVER ASSEMBLY

METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°

INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

ITEM:

CNC:

SCALE:

QT. 1

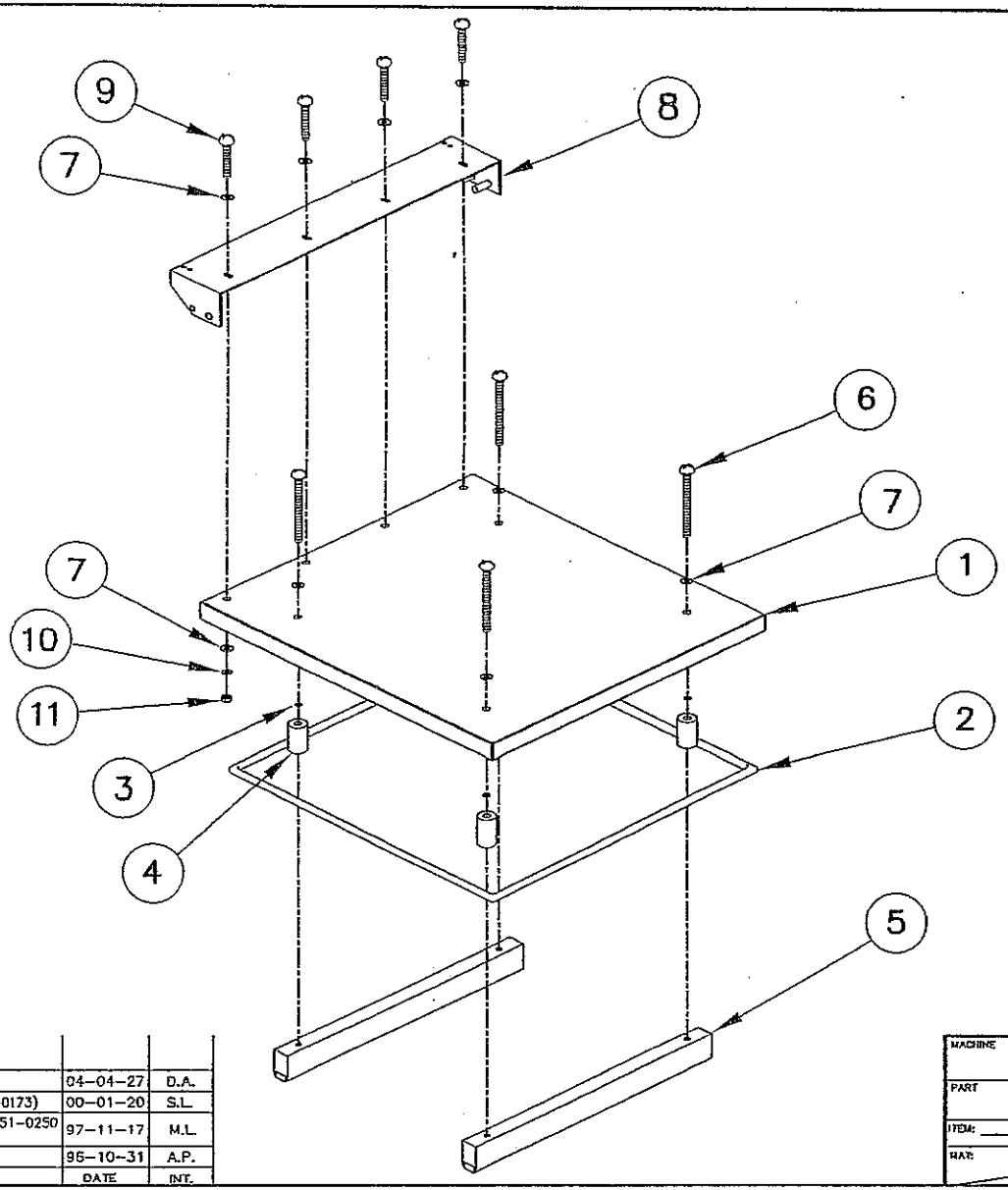
MAT:

DWG BY A.P. DATE 96-10-31

APP. DATE 04-04-21

NO. 005-0266

005-0266



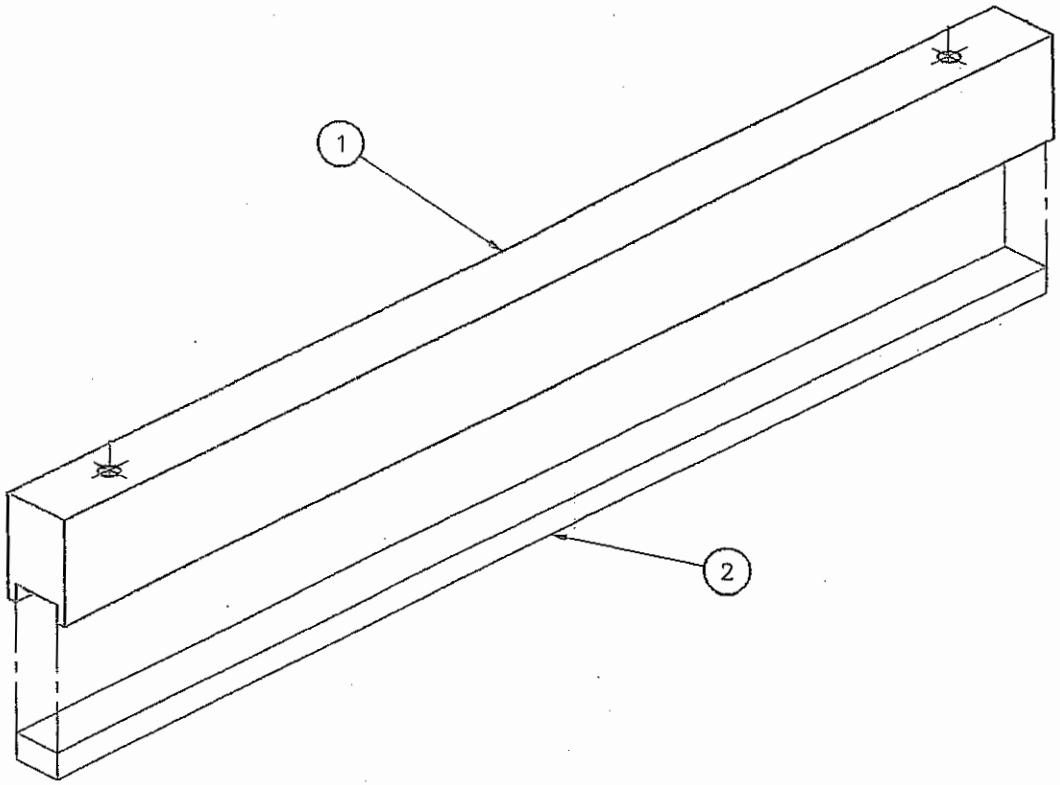
ITEM	PART #	DESCRIPTION	QT.
1	002-0392	COVER	1
2	179-0005	COVER GASKET	6.6
3	076-0010	"O" RING	4
4	002-0026	UPPER SEAL BAR SPACER	4
5	004A0173	UPPER SEAL BAR ASS'Y	2
6	051-0289	SCREW 1/4"-20 NC. x 3 1/2" PAN PHIL S/S	4
7	051-0740	FLAT WASHER 1/4" S/S	12
8	004-0021	COVER HINGE ASS'Y	1
9	051-0249	SCREW 1/4"-20 NC. X 1 1/2" PAN PHIL S/S	4
10	051-0750	LOCK WASHER 1/4" S/S	4
11	051-0580	HEX. NUT 1/4"-20 NC S/S	4

LET.	MODIFICATION	DATE	INT.
E	ITEM #5 051-0289 ETAIT 051-0286	04-04-27	D.A.
D	REDRAWN ITEM #5 (004A0173 WAS 004-0173)	00-01-20	S.L.
C	ITEM #6 WAS 051-0284/ ITEM #9 WAS 051-0250 FOR N.S.F.	97-11-17	M.L.
B	REDRAWN/MODIFIED ITEM 8	96-10-31	A.P.

MACHINE: 350D
PART: COVER ASSEMBLY
METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°
INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:
CNC:
SCALE:
QT. 1
MAT:
DWG BY A.P. DATE 96-10-31
APP. DATE 04-04-27
NO 005-0481

005-0481

ITEM	PART #	DESCRIPTION	QT.
1	002A0377	UPPER SEAL BAR SUPPORT	1
2	008-0291	UPPER SEAL BAR RUBBER	1

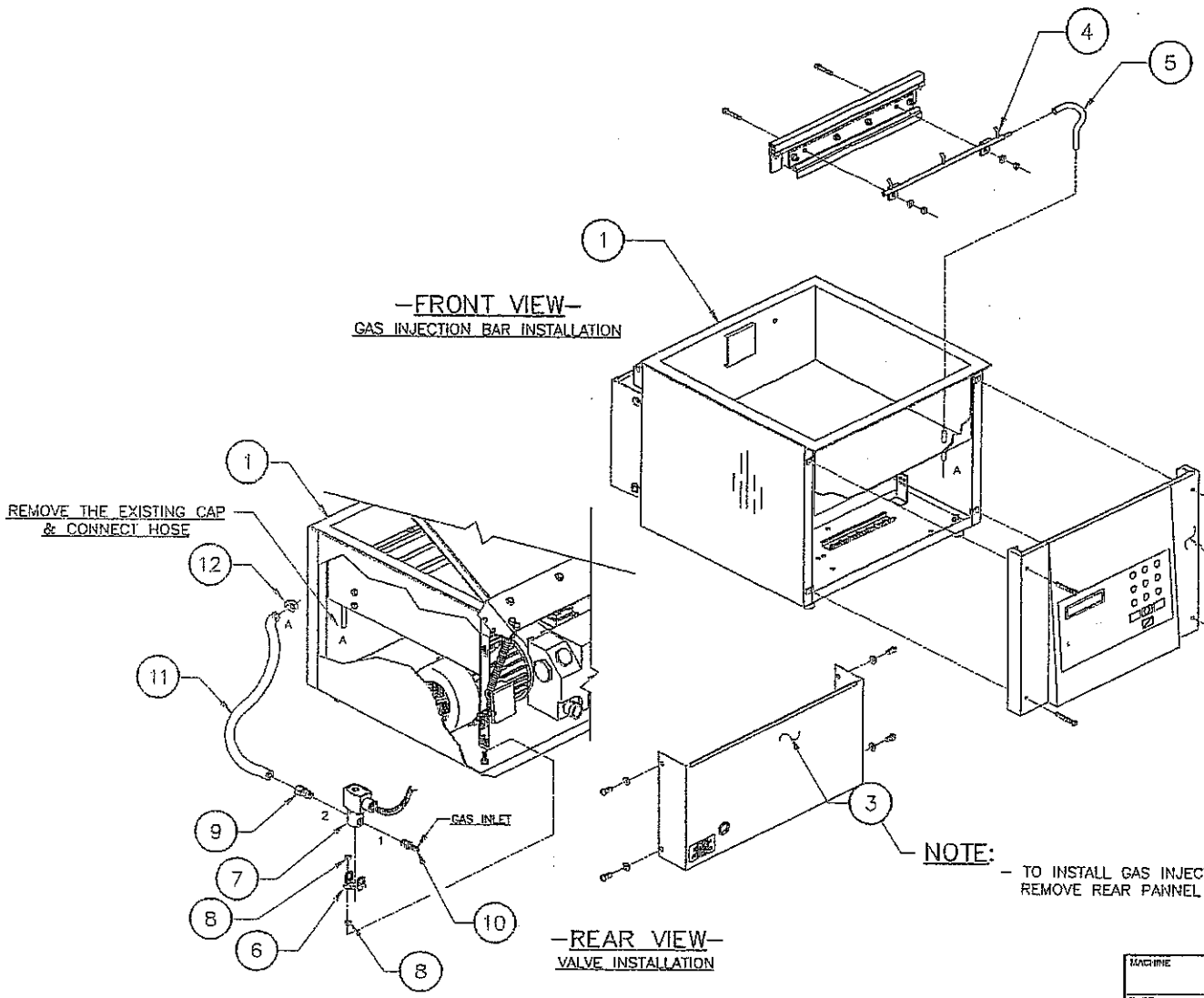


MACHINE	QTY
350D	2
350	1
300	1

MACHINE: 300, 350 & 350D
PART: UPPER SEAL BAR PRE-ASS'Y
METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°
INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
ITEM:
CNC:
SCALE
QT. SEE LIST
MAT:
DRG BY S. LAROUCHE DATE 99-08-02
APP.
DATE
NO. 004A0173

LET.	MODIFICATION	DATE	INT.
C	REDRAWN	99-08-02	S.L.

004A0173



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	005B0042	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

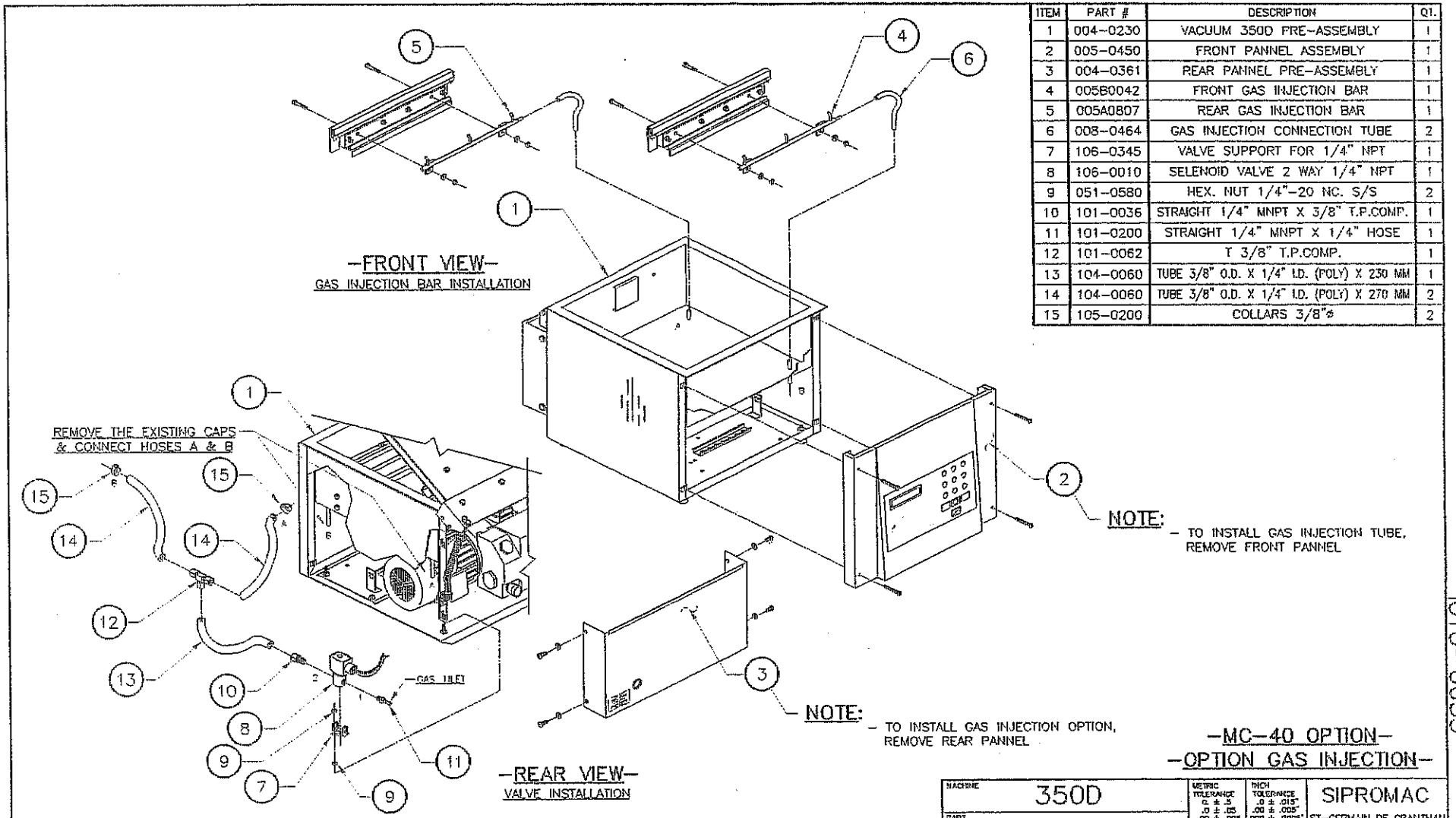
-MC-40 OPTION-
-OPTION GAS INJECTION-

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

MACHINE: 350	METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PART: GAS INJECTION KIT INSTALLATION	N.T.S.		
ITEM:	CNC:	SCALE: M-I	QT. 1
MAT:	DWG BY: A. PROVENCHER DATE: 98-06-05	NO. 010-0034	
	APP. DATE		

010-0034

ITEM	PART #	DESCRIPTION	QT.
1	004-0230	VACUUM 350D PRE-ASSEMBLY	1
2	005-0450	FRONT PANNEL ASSEMBLY	1
3	004-0361	REAR PANNEL PRE-ASSEMBLY	1
4	005B0042	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	SELENOID 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"ø	2



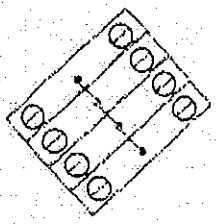
-MC-40 OPTION-
-OPTION GAS INJECTION-

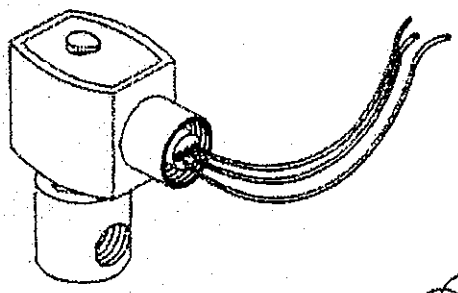
LET.	MODIFICATION	DATE	INT.
C	MODIF. #A-356	03-02-21	J.G.
B	MODIFIED VIEW (REMOVED "CONDENSATOR")	00-11-09	S.L.
A	MODIFIED VIEW/ REAR PANEL & REMOVED 3 1/2"ø PLUG BUTTON	00-11-01	S.L.

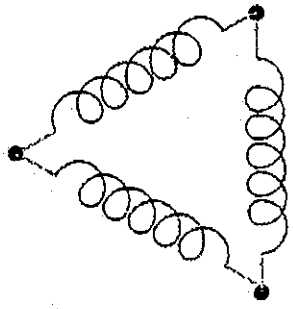
MACHINE: 350D	METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: GAS INJECTION KIT INSTALLATION		N.T.S.	
ITEM:	CNC:	SCALE: M-1-1	QT. 1
MAT:	DWG: A. PROVENCHER DATE 98-06-03 APP: LT DATE		NO. 010-0035

010-0035

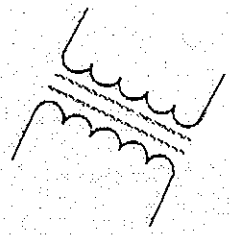
NOTES

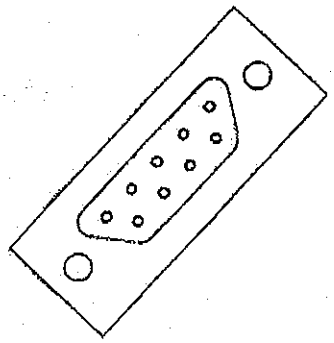


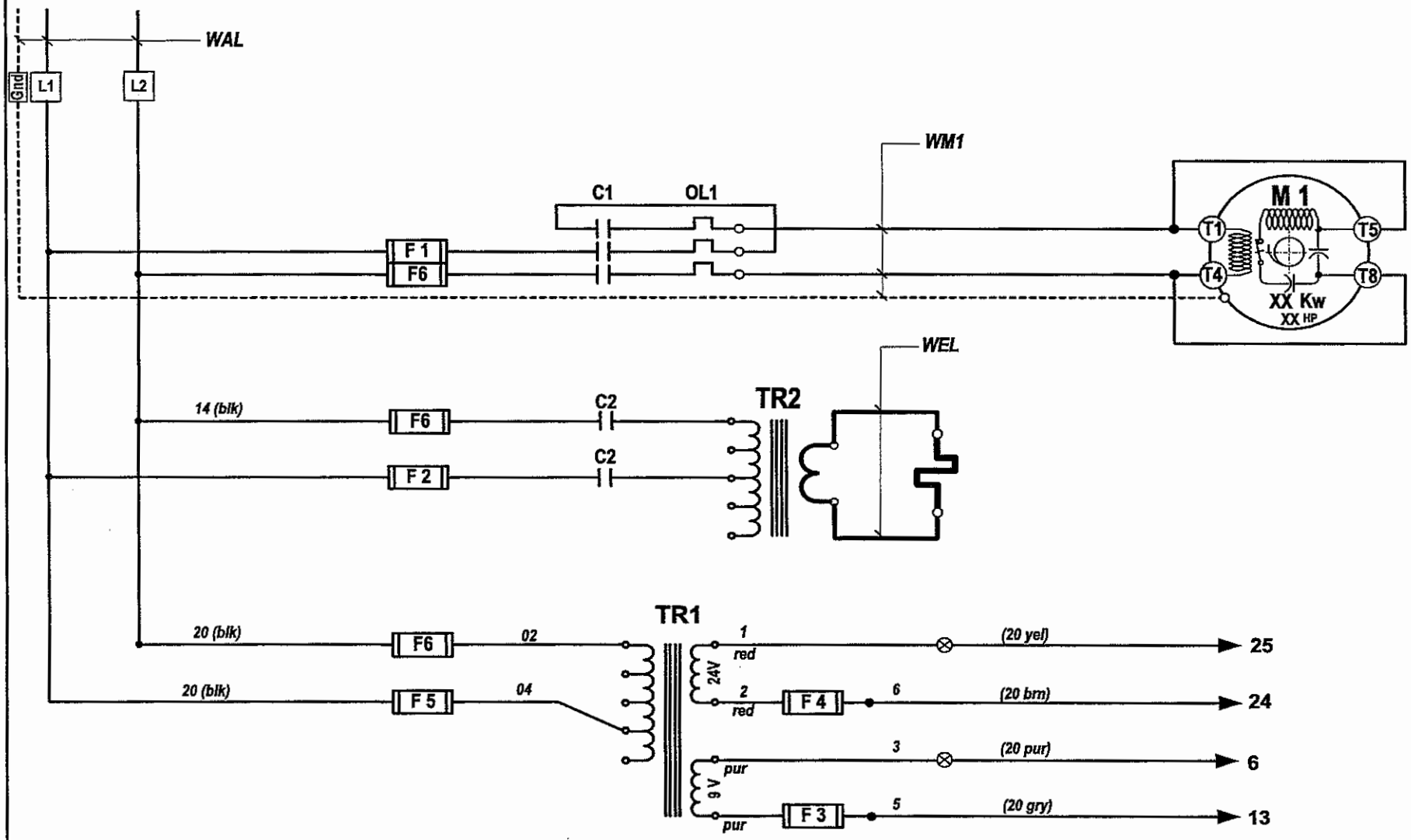




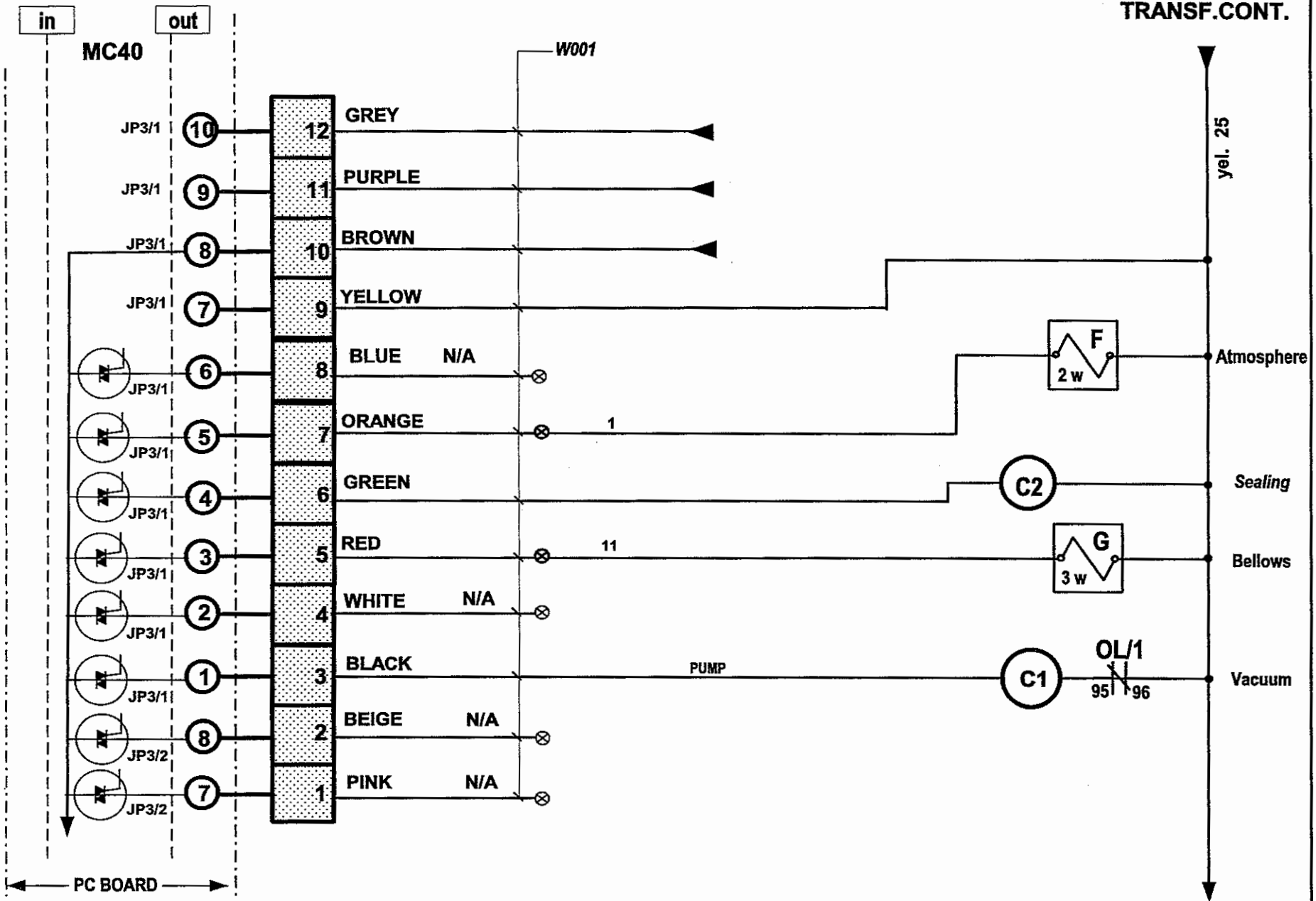
ELECTRICAL DRAWING







category VACUUM PACK	model 350	volt. 1Ph 60Hz					SIPROMAC St-Germain de Grantham QUEBEC ,CANADA
system MC-40		circuit power	year 05	month 01	day 18	block	
usual fonctions							
options			concept PP	draw PP	app DL		006-0220 PAGE 1 de 3



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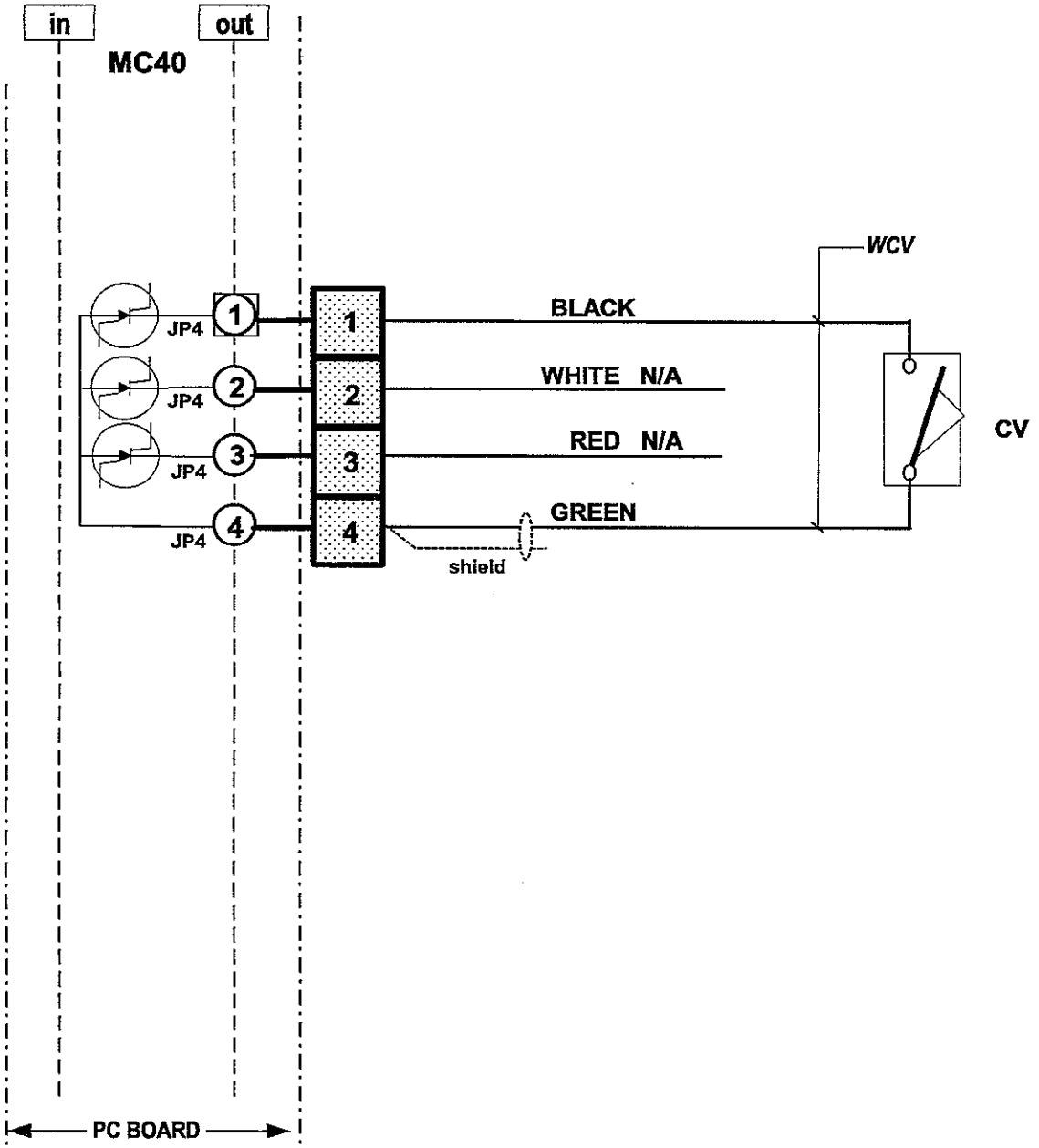
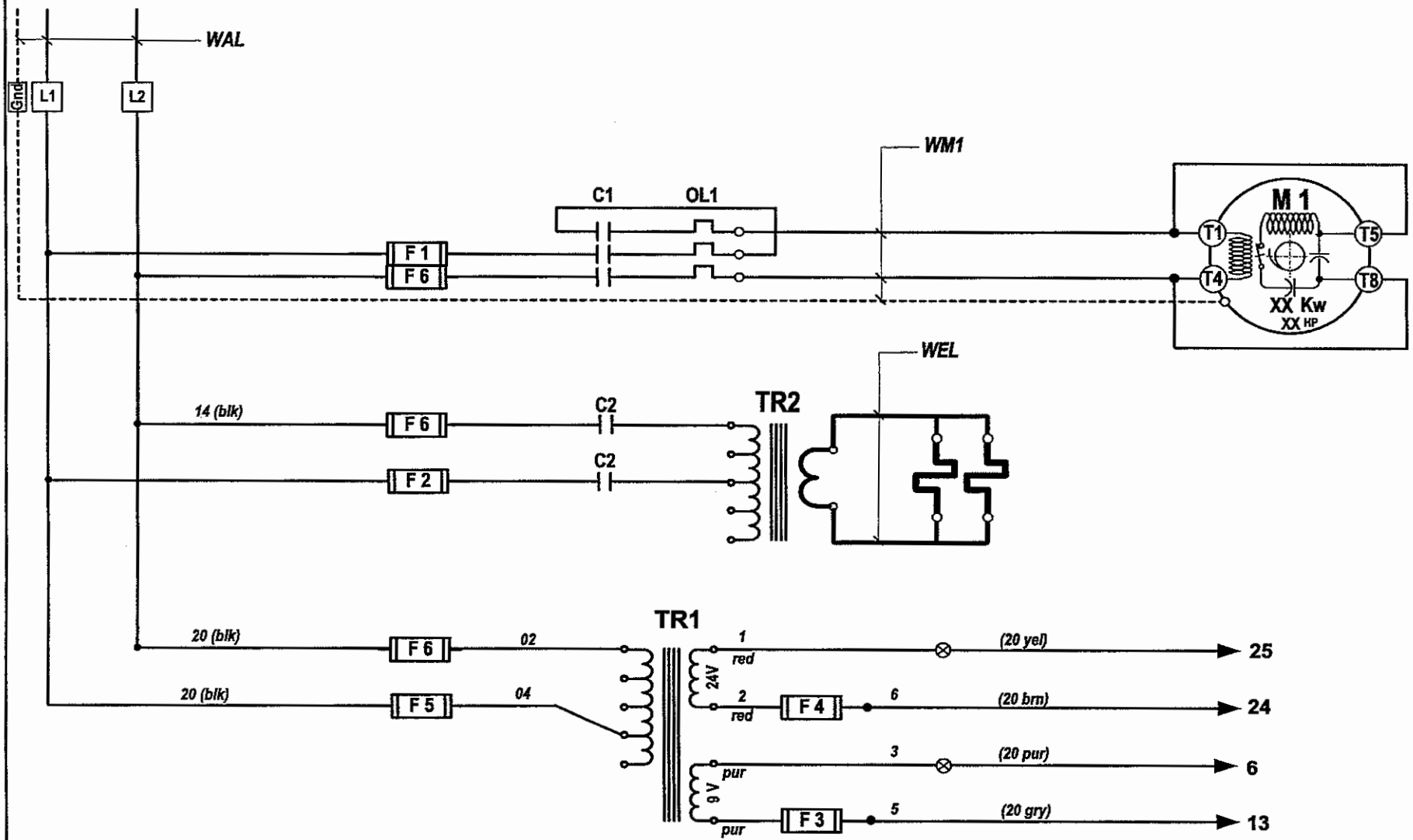
system	Control MC-40			circuit	control	year 05	month 01	day 18	block	St-Germain de Grantham QUEBEC ,CANADA
usual fonctions	MC-40									
options						concept PP	draw PP	app DL	006-0220	PAGE 2 de 3

TRANSF.CONT.



yel. 25

category: VACUUM PACK	model: 350	volt: 24V 60Hz					SIPROMAC St-Germain de Grantham QUEBEC ,CANADA	
system: Control MC-40		circuit: control	year: 05	month: 01	day: 18	block:		
usual fonctions: MC-40			concept: PP	draw: PP	app: DL		006-0220	PAGE 3 de 3
options:								



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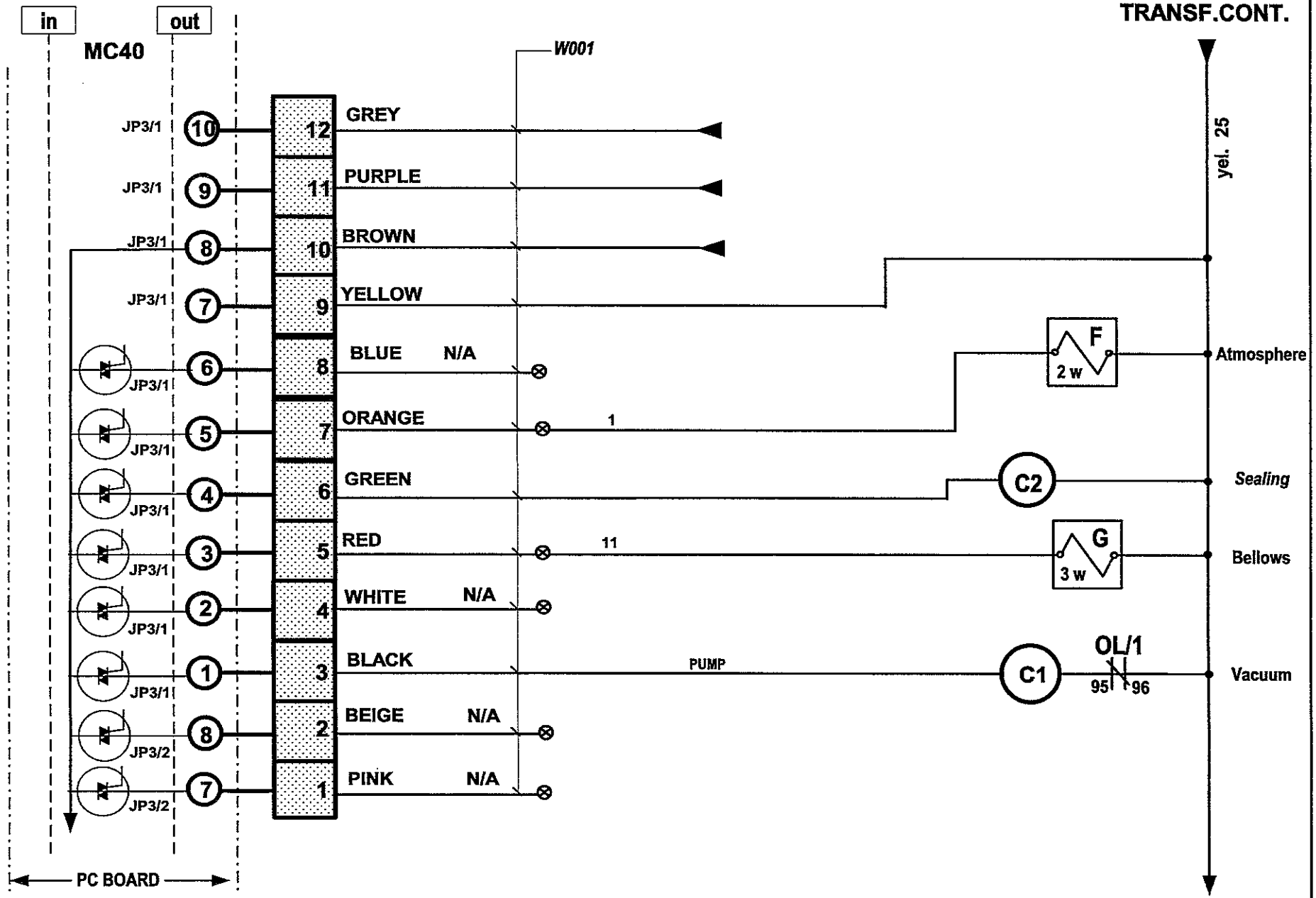
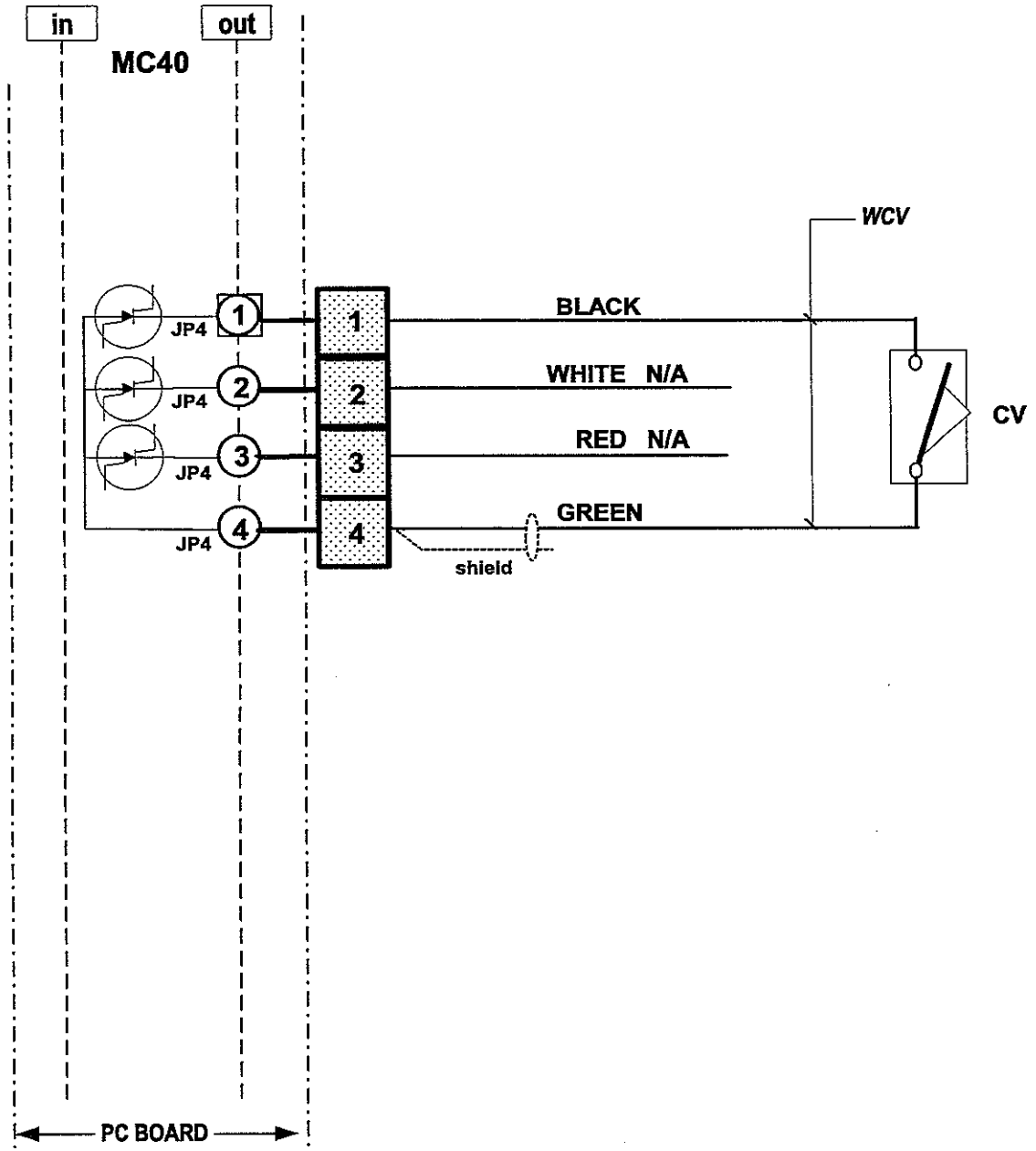
system MC-40		circuit power	year 05	month 01	day 18	block	
usual fonctions			concept PP	draw PP	app DL	006-0320 PAGE 1 de 3	
options							



category: VACUUM PACK	model: 350D	volt: 24V 60Hz					SIPROMAC
system: Control MC-40		circuit: control	year: 05	month: 01	day: 18	block:	St-Germain de Grantham QUEBEC ,CANADA
usual fonctions: MC-40							
options:			concept: PP	draw: PP	app: DL	006-0320	PAGE 2 de 3

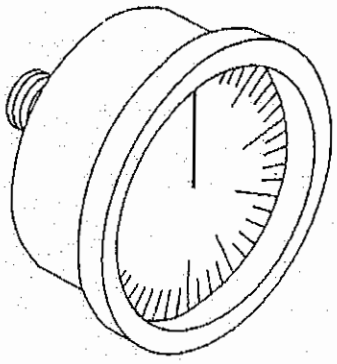
TRANSF.CONT.



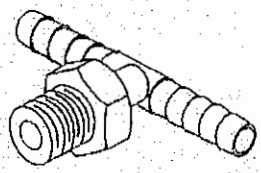
yel. 25

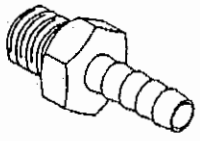
category: VACUUM PACK	model: 350D	volt: 24V 60Hz					SIPROMAC St-Germain de Grantham QUEBEC ,CANADA	
system: Control MC-40		circuit: control	year: 05	month: 01	day: 18	block:		
usual fonctions: MC-40			concept: PP	draw: PP	app: DL	006-0320 PAGE 3 de 3		
options:								

NOTES



PNEUMATIC DRAWING





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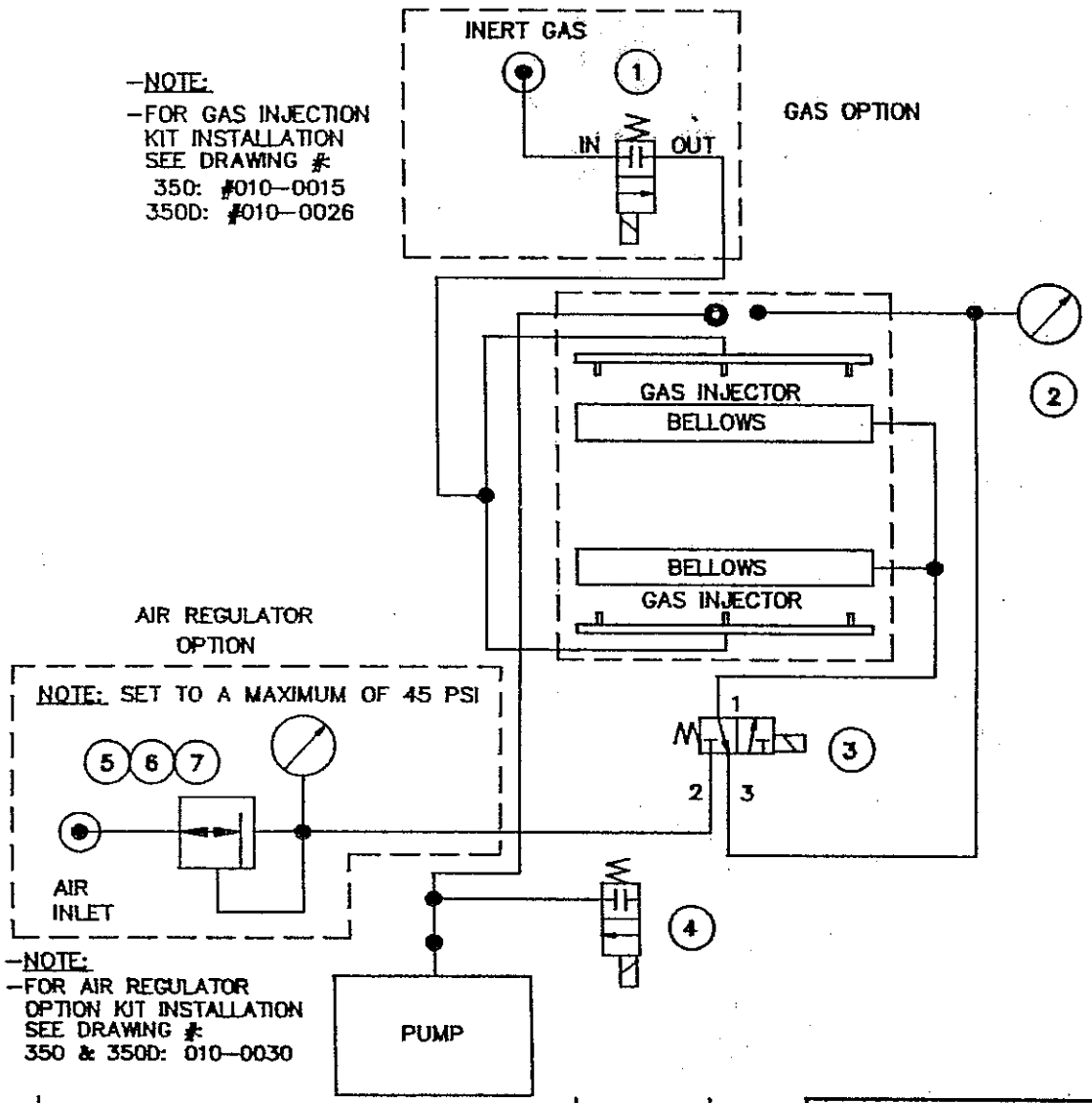


ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	1*
2	114-0260	VACUUM GAUGE	1
3	106-0070	BELLOWS VALVE	1
4	106-0020	ATMOSPHERE VALVE	1
5	114-0147	PRESSURE REGULATOR	1*
6	114-0245	PRESSURE GAUGE	1*
7	114-0170	PRESSURE REGULATOR SUPPORT	1*
*: OPTION			

LET.	MODIFICATION	DATE	INT.
A	RE-DRAWN	97-03-11	M.L.

MACHINE: 350 & 350D

PART: PNEUMATIC

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

ITEM: | CNC: | SCALE | QT. 1

MAT:

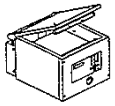
DWG BY M.LAVIGNE | DATE 97-03-11

APP. | DATE

NO. 007-0022

NOTES

BK46710



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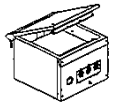

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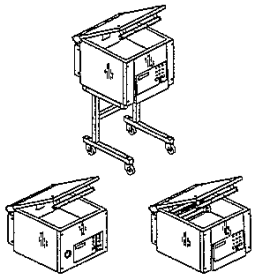

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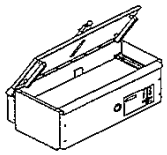

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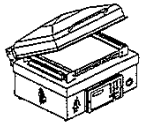

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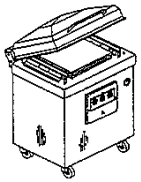

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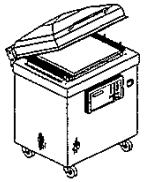

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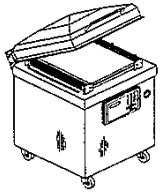

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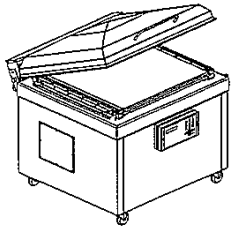

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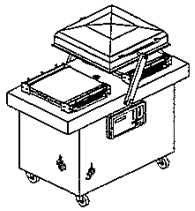
VACUUM PACKAGING MACHINES



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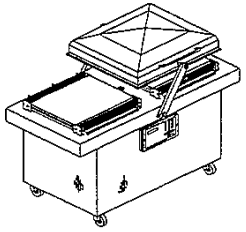

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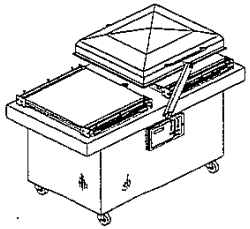

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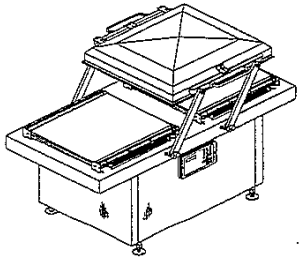

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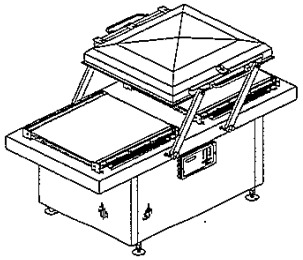

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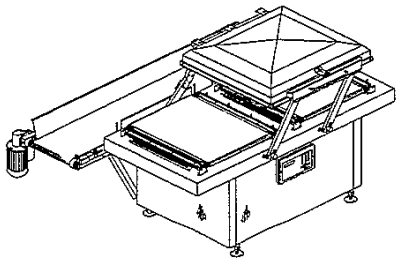

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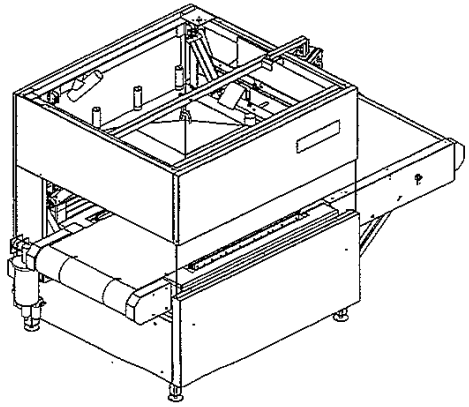

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