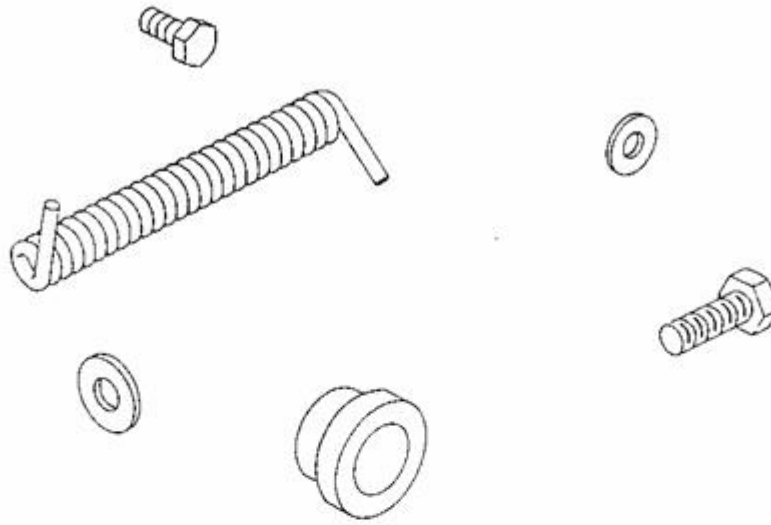


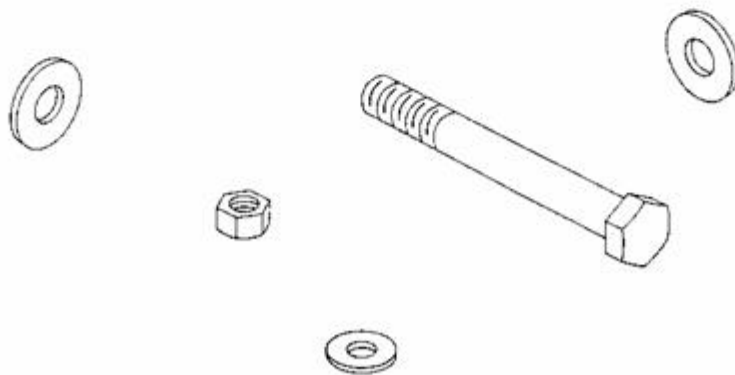


Parts List

VACUUM TUMBLER
VT-500

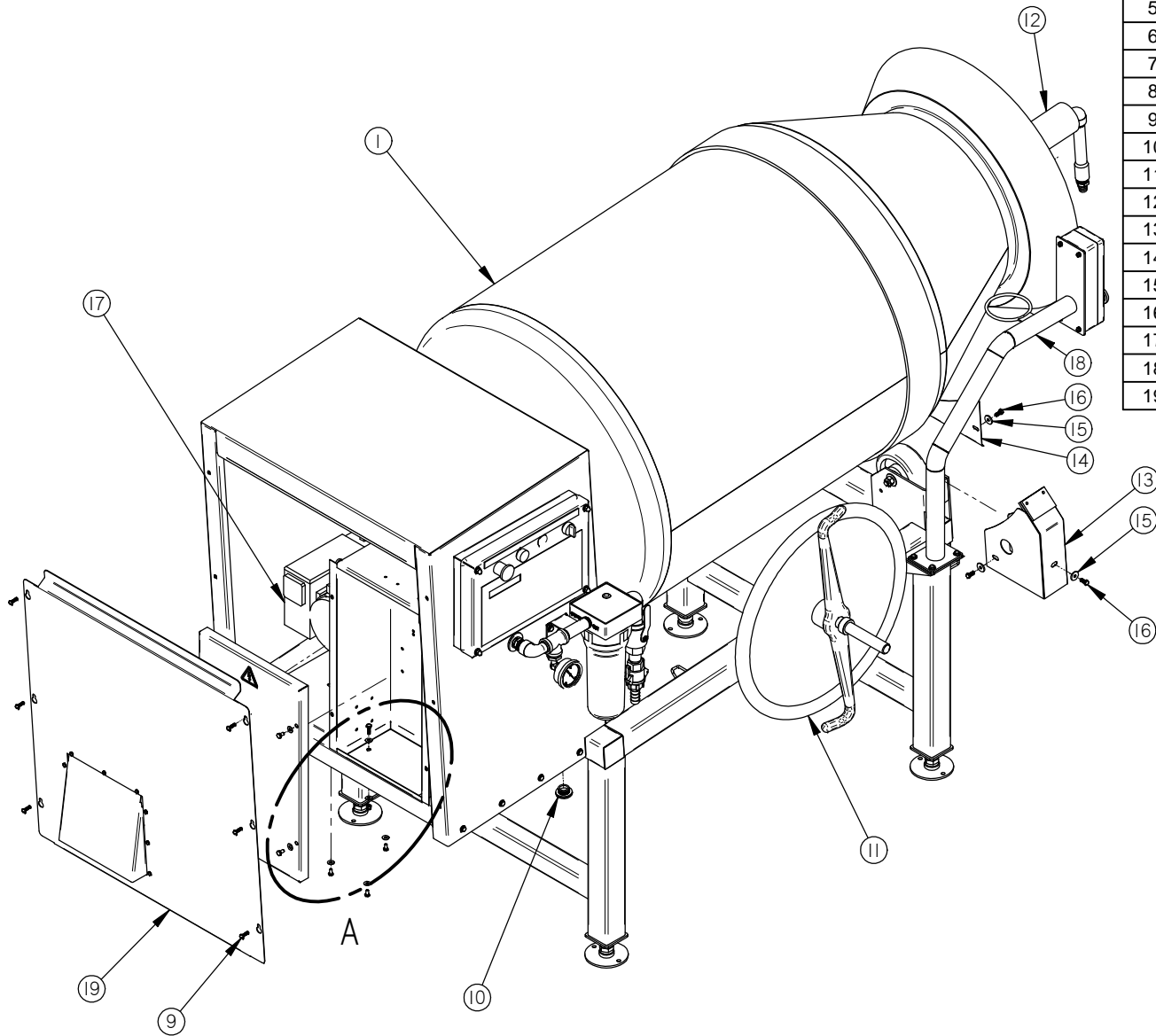


MECHANICAL DRAWING

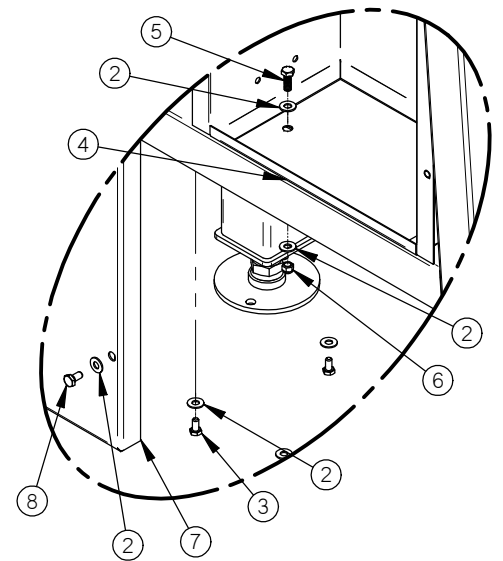


005D1292

ITEM	PART #	DESCRIPTION	QT.
1	005D1293	TUMBLER PRE-ASSEMBLY	1
2	051-0740	WASHER 1/4" FLAT S/S	11
3	051-0948	BOLT M6 x 12 SS	3
4	004-0431	ELECTRICAL BOX PRE-ASSEMBLY	1
5	051-0190	BOLT 1/4-20 x 3/4" HEX S/S	2
6	051-0581	NUT 1/4"-20 NYLON LOCK S/S	2
7	005-0587	E-BOX COVER PRE-ASS'Y	1
8	052-0402	BOLT. HEX. 1/4"-20 NC. x 1/2" BRASS	4
9	052-0420	SCREW 1/4"-20 N.C x 3/4" PAN SLOT BRASS	6
10	102-0750	PLASTIC DRUM PLUG 3/4"NPT	1
11	005B1296	COVER ASSEMBLY	1
12	005A1303	SWIVEL JOINT ASS'Y	1
13	005A1302	WHEEL COVER ASS'Y	2
14	001A5931	CYLINDER GUARD	1
15	051-0757	WASHER 1/4" FLAT THICK S/S	6
16	051-0189	BOLT 1/4-20 x 5/8" HEX S/S	6
17	007A0146	KB-20 PUMP HOOK-UP ASS'Y	1
18	005B1326	JOG ASSEMBLY	1
19	004A3956	REAR STRUCTURE PANEL ASSEMBLY	1



DETAIL A

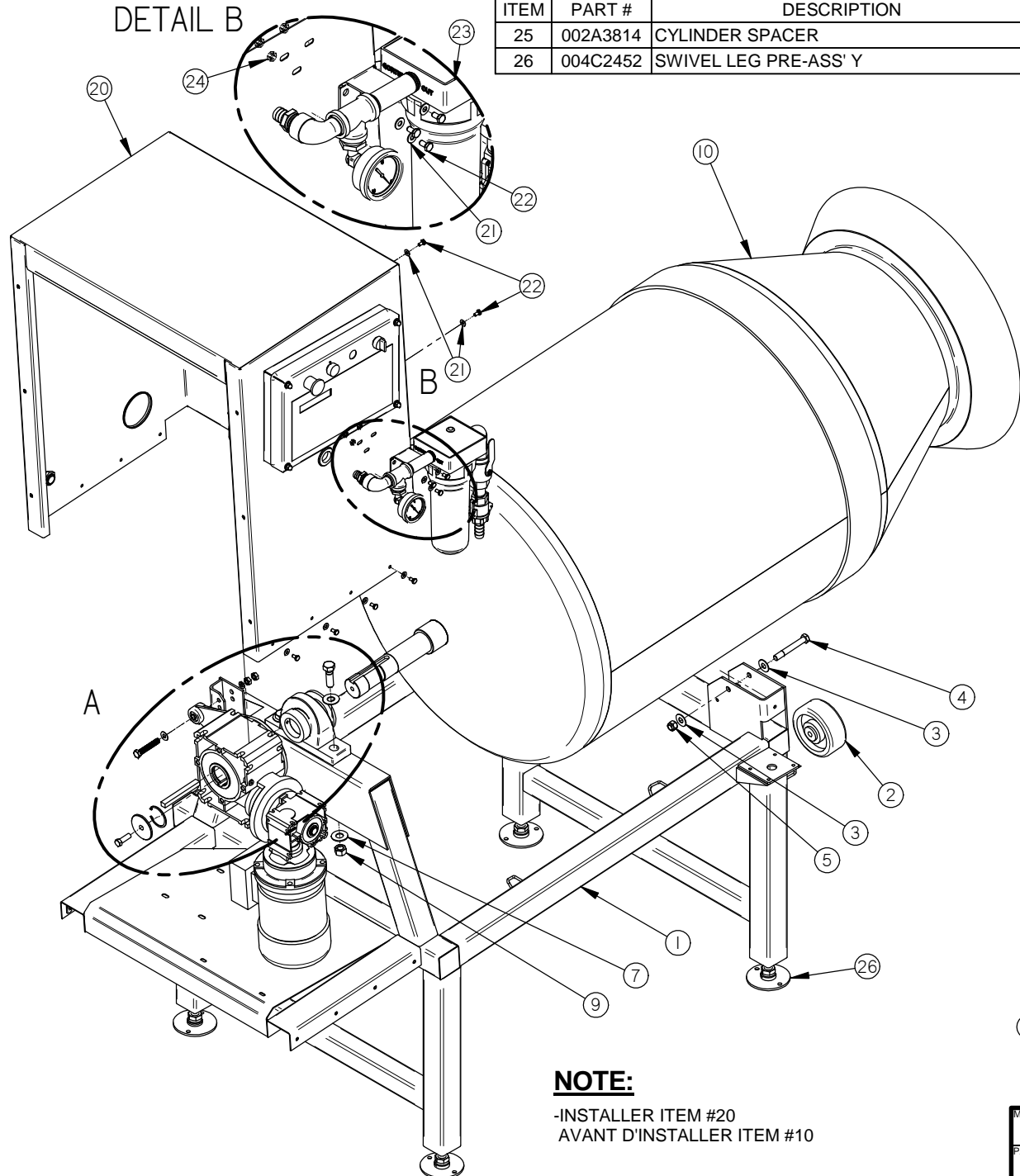


B	NEW COVER DESIGN	13-11-15	SBU
A	REDESSINE	12-09-10	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		VT-500		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		VACUUM TUMBLER ASSEMBLY		USINAGE	± 0.1 ± 0.004"	
ITEM		CNC		TOLERIE	± 0.5 ± 0.020"	
MAT.		APP. BY		SOUDEGE	± 0.5 ± 0.020"	N.T.S.
		DWG BY SBU		DATE 13-11-14		DEPT. M-I QTY. 1
		APP. BY		DATE		005D1292

005D1293

DETAIL B

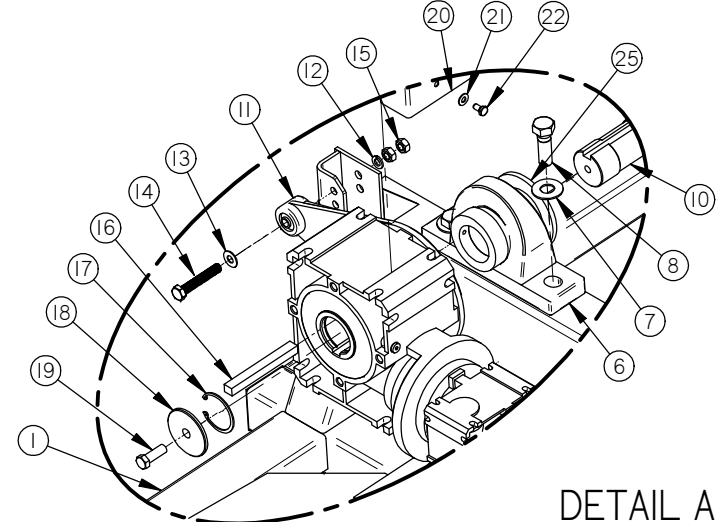


ITEM	PART #	DESCRIPTION	QT.
25	002A3814	CYLINDER SPACER	1
26	004C2452	SWIVEL LEG PRE-ASS'Y	4

ITEM	PART #	DESCRIPTION	QT.
1	004C3620	FRAME PRE-ASS'Y	1
2	130-0064	POLYURETHANE WHEEL 5" DIA. X 2" THREAD	2
3	051-0790	WASHER 1/2" FLAT S/S	4
4	003A0374	WHEEL AXIS	2
5	051-0631	NUT 1/2"-13nc. NYLON LOCK S/S	2
6	075-2500	PILLOW BLOCK 2 C/W EXCENT.COL	1
7	051-0800	WASHER 5/8" FLAT S/S	4
8	051-0458	BOLT 5/8"-11nc. X 2" S/S	2
9	051-0650	NUT 5/8"-11 SS	2
10	005B1295	CYLINDER ASSEMBLY	1
11	004A3629	GEARBOX ASSMBLY	1
12	051-0781	WASHER 3/8" LOCK S/S	1
13	051-0780	WASHER 3/8" FLAT S/S	1
14	051-0999	BOLT M10 x 65MM HEX S/S	1
15	051-1082	NUT M10 SS	2
16	008A1745	GEARBOX KEY	1
17	056-0437	RET.RING INT. 1-15/16" STEEL	1
18	002A3779	GEARBOX WASHER	1
19	051-0421	BOLT 7/16"-14NC x 1-1/4" S/S	1
20	005B1300	STRUCTURE ASSEMBLY	1
21	051-0740	WASHER 1/4" FLAT S/S	16
22	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	13
23	005A1301	SEPARATOR ASSEMBLY	1
24	051-0580	NUT 1/4"-20 S/S	3

NOTE:
-INSTALLER ITEM #20
AVANT D'INSTALLER ITEM #10

DETAIL A

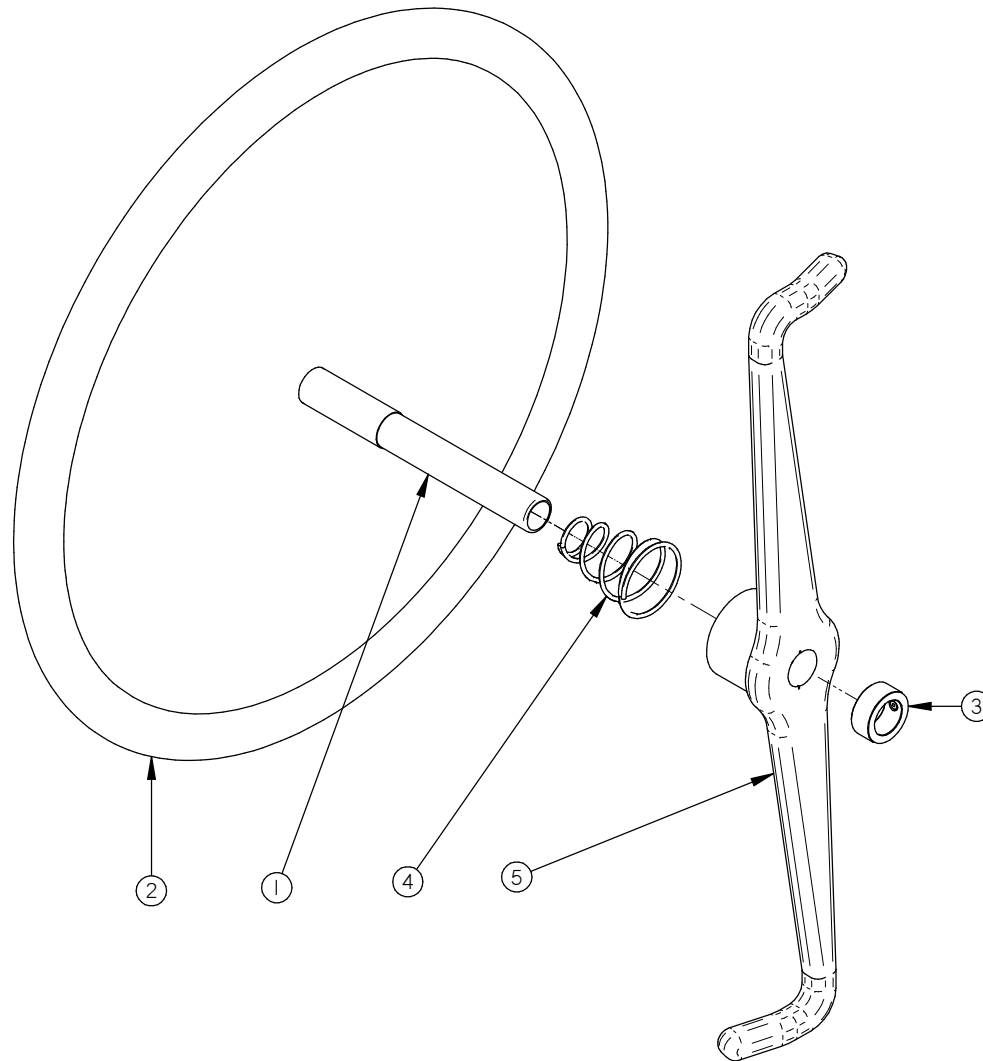


B	005B1295 WAS 005A1295	13-11-15	SBU
A	REDESSINE / AJOUT PATTE AJUSTABLE	12-09-10	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		DEPT. TOL. METRIC		INCH		SIPROMAC	
VT-500		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA		
PART		TOLERIE	± 0.5	± 0.020"			
TUMBLER PRE-ASSEMBLY		SOUDAGE	± 0.5	± 0.020"			
ITEM		CNC	DEPT.		M-I		QTY. 1
MAT.		DWG BY SBU	DATE 13-11-14		NO. 005D1293		
		APP. BY	DATE				

005B1296

ITEM	PART #	DESCRIPTION	QT.
1	004B3618	COVER PRE-ASSEMBLY	1
2	008A1746	COVER GASKET	1
3	105-0436	SCREW COLLAR 1" X 1-1/2" X 5/8" ALL SS	1
4	077-0601	CONICAL COMPRESSION SPRING 2.25"OD X 1.125"OD X 3"L X 0.120"W (0.24" COMP.)	1
5	005A1416	LOCK BAR W/ HUB	1

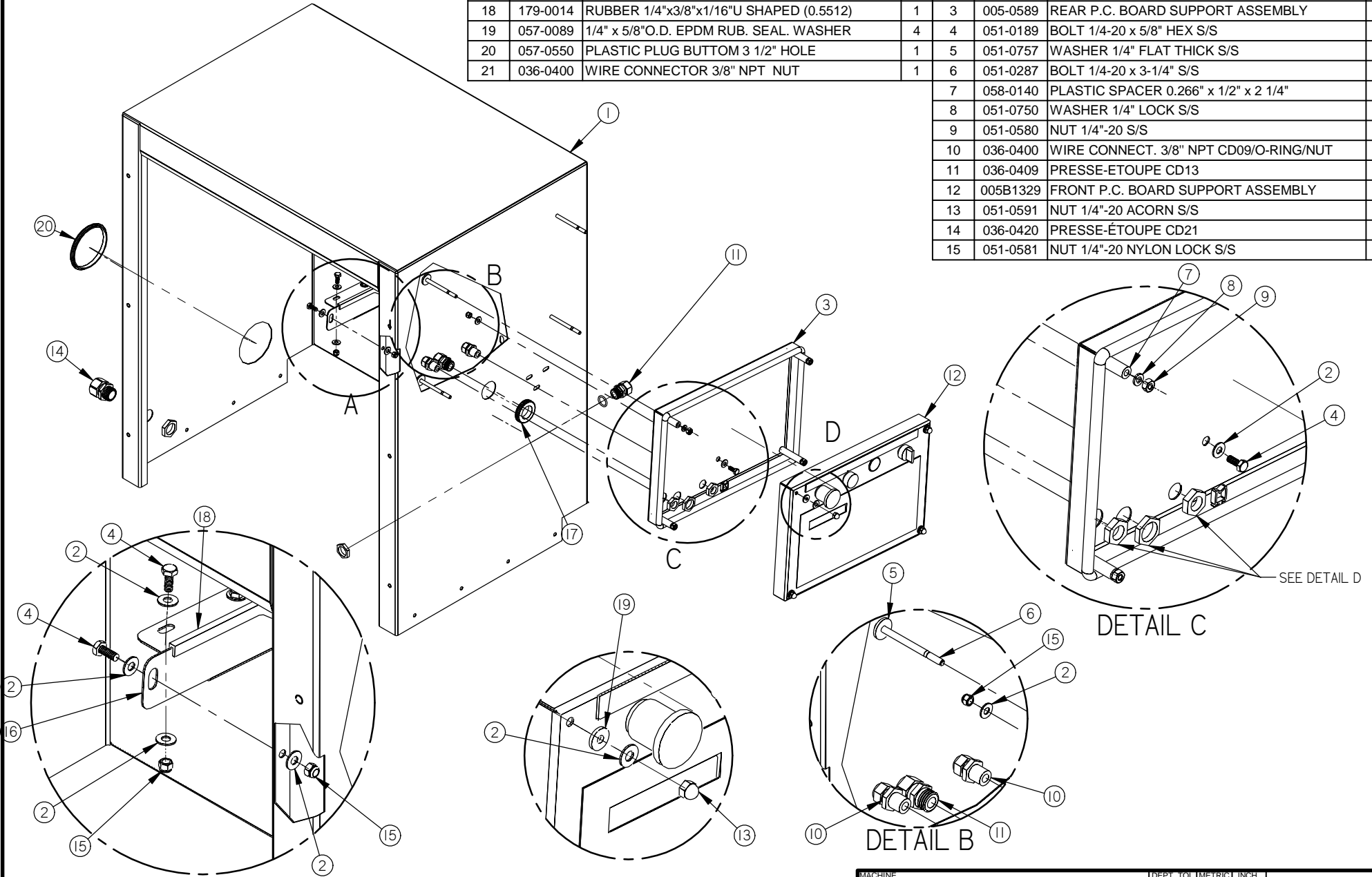


MACHINE		VT-500		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		COVER ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM				TOLERIE	± 0.5	± 0.020"	
MAT.				SOUDEAGE	± 0.5	± 0.020"	N.T.S.
		CNC		DEPT.		M-I-(M)	QTY. 1
		DWG BY SBU	DATE 13-11-14	NO.		005B1296	
		APP. BY	DATE				

B	NEW DESIGN	13-11-14	SBU
LET.	MODIFICATION	DATE	INT.

005B1300

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
16	001A5922	UPPER E-BOX SUPPORT	1	1	004A3621	STRUCTURE PRE-ASS'Y	1
17	036-0250	GROMMET 1 1/8ID x 1 7/8OD RUBBER	1	2	051-0740	WASHER 1/4" FLAT S/S	12
18	179-0014	RUBBER 1/4"x3/8"x1/16"U SHAPED (0.5512)	1	3	005-0589	REAR P.C. BOARD SUPPORT ASSEMBLY	1
19	057-0089	1/4" x 5/8"O.D. EPDM RUB. SEAL. WASHER	4	4	051-0189	BOLT 1/4-20 x 5/8" HEX S/S	4
20	057-0550	PLASTIC PLUG BUTTOM 3 1/2" HOLE	1	5	051-0757	WASHER 1/4" FLAT THICK S/S	4
21	036-0400	WIRE CONNECTOR 3/8" NPT NUT	1	6	051-0287	BOLT 1/4-20 x 3-1/4" S/S	4
				7	058-0140	PLASTIC SPACER 0.266" x 1/2" x 2 1/4"	4
				8	051-0750	WASHER 1/4" LOCK S/S	4
				9	051-0580	NUT 1/4"-20 S/S	4
				10	036-0400	WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT	2
				11	036-0409	PRESSE-ÉTOUPE CD13	2
				12	005B1329	FRONT P.C. BOARD SUPPORT ASSEMBLY	1
				13	051-0591	NUT 1/4"-20 ACORN S/S	4
				14	036-0420	PRESSE-ÉTOUPE CD21	1
				15	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4



DETAIL A

DETAIL D

DETAIL C

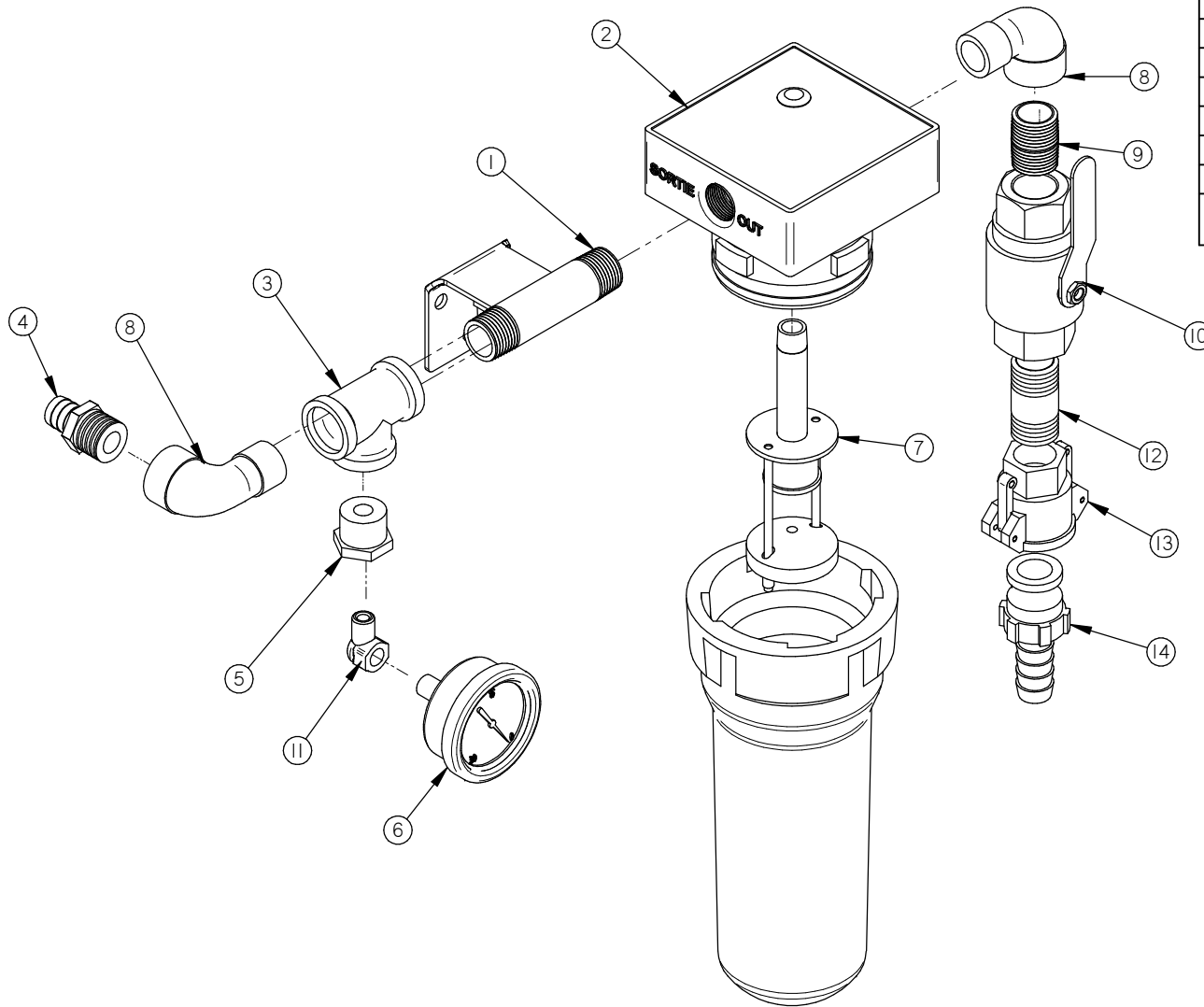
DETAIL B

C	005A1329 NOW 005B1329	12-09-10	SBU
B	AJOUTER 036-0409 SUR DEVANT	12-07-17	J.G.
A	REDESSINE (005A1329 ÉTAIT 005-0588)	12-01-10	J.G.
LET.	MODIFICATION	DATE	INT.

MACHINE		DEPT. TOL. METRIC		INCH		SIPROMAC	
VT-500		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA		
PART		TOLERIE	± 0.5	± 0.020"			
STRUCTURE ASSEMBLY		SOUDAGE	± 0.5	± 0.020"			
ITEM		CNC		N.T.S.		DEPT. M-I	
MAT.		DWG BY J.G.		DATE 12-01-10		NO. 005B1300	
		APP. BY		DATE		QTY. 1	

005A1301

ITEM	PART #	DESCRIPTION	QT.
1	004-0372	SEPARATOR SUPPORT PRE-ASS'Y	1
2	003-0106	SEPARATOR BODY	1
3	101-0870	T 3/4"NPT BR	1
4	101-0280	STRAIGHT 3/4" MNPT x 3/4" HOSE BARB	1
5	101-0945	RED. BUSH. 3/4"npt X 1/4"npt. BR	1
6	114-0280	VAC GAUGE 0-30HG 1/4" MNPT REAR PORT(W/GLYC)	1
7	005A1163	FLOW STOPPER ASSEMBLY	1
8	100-0080	STREET ELBOW 3/4"npt. S/S	2
9	100-0235	CLOSE NIPPLE 3/4"npt, S/S	1
10	107-0061	BALL VALVE 3/4" NPT BRASS FOR STEAM	1
11	101-0660	ELBOW STREET 90° X 1/4" NPT BRASS	1
12	100-0360	NIPPLE 3/4"npt. X 2" S/S	1
13	102-0904	FEMALE COUPLER 3/4" X 3/4" FNPT WHITE	1
14	102-0902	MALE ADAPTER 3/4" X 3/4" HOSE BARB WHITE	1

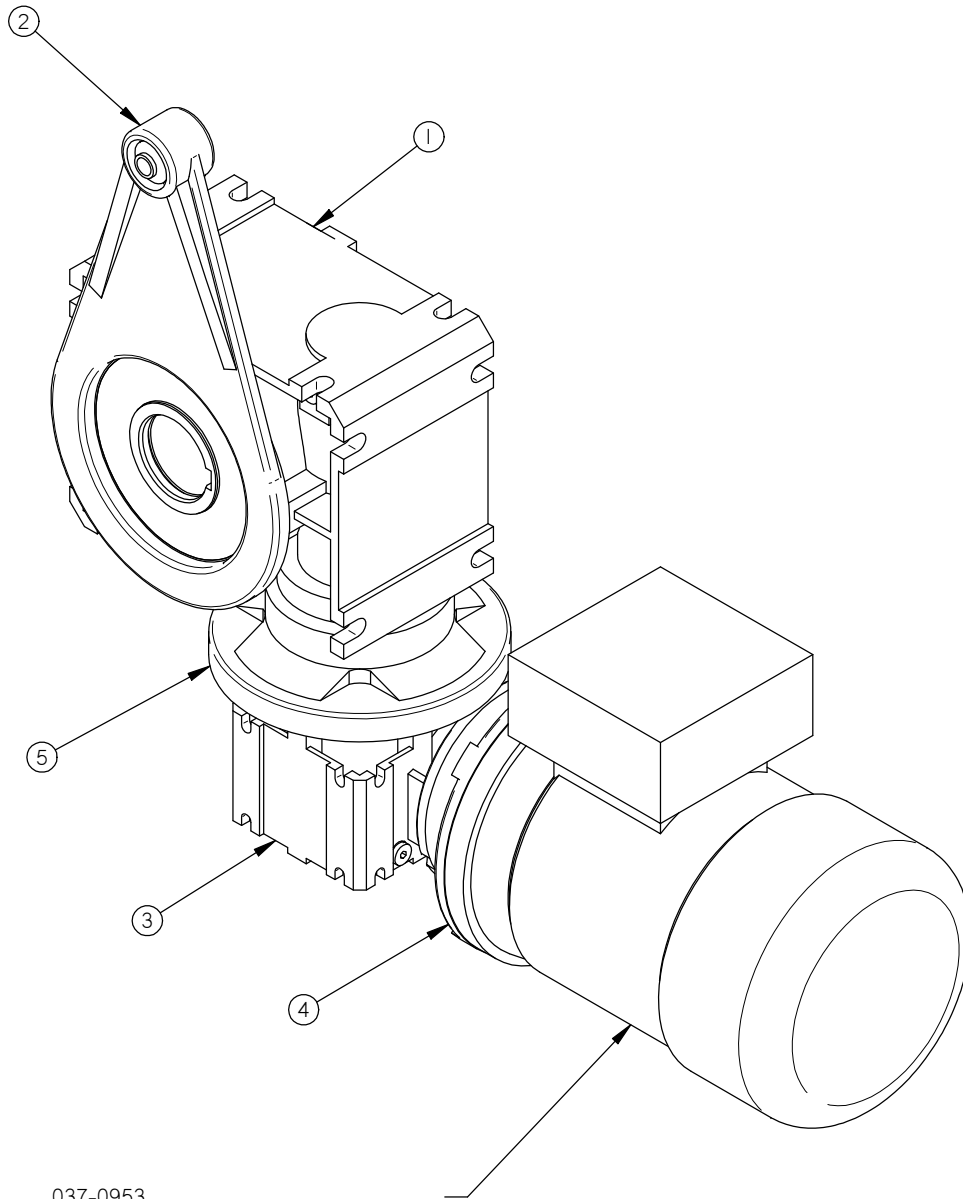


B	REPLACE 101-0280 BY #13,14 & 15	12-03-08	CF
A	CHANGER CERTAINE PIÈCE DE L'ASS'Y	11-12-15	CF
LET.	MODIFICATION	DATE	INT.

MACHINE		VT-500		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		SEPARATOR ASSEMBLY		USINAGE ± 0.1	± 0.004"	
ITEM		CNC		TOLERIE ± 0.5	± 0.020"	
MAT.		DWG BY V.G. (CF)		DATE 11-08-17	NO.	1
APP. BY		DATE		005A1301		

004A3629

ITEM	PART #	DESCRIPTION	QT.
1	037-0944	MODULE WORM GEARBOX 1SI75	1
2	037-09215	MODULE TORQUE ARM 1SI75	1
3	037-0941	MODULE WORM GEARBOX 1SI40	1
4	037-0946	MODULE NEMA 56C MOTOR ADAPTER 1SI40	1
5	037-0936	MODULE DOUBLE WORM GEAR ADAPTER SI40	1



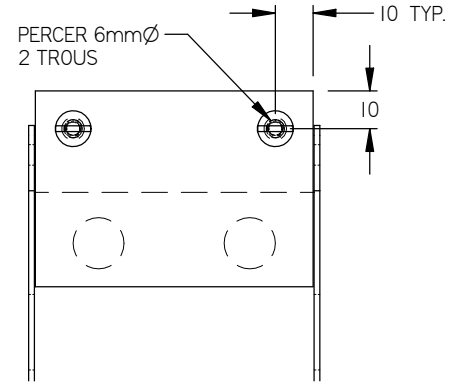
037-0953
MOTOR 80S/4-56C, 3/4HP, 230-460V-60HZ

LET.	MODIFICATION	DATE	INT.

MACHINE		DEPT. TOL. METRIC		INCH		SIPROMAC	
VT-500		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA		
PART		TOLERIE	± 0.5	± 0.020"			
GEARBOX ASSMBLY		SOUDAGE	± 0.5	± 0.020"			
ITEM		CNC		DEPT.		M-I-(M) QTY. 1	
MAT.		DWG BY J.G.		DATE 11-08-24		NO. 004A3629	
		APP. BY		DATE			

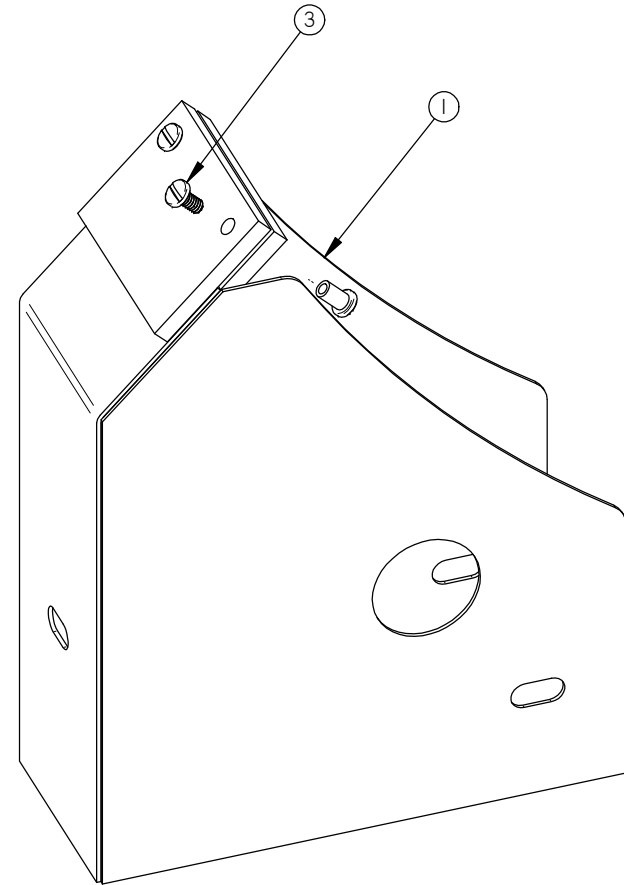
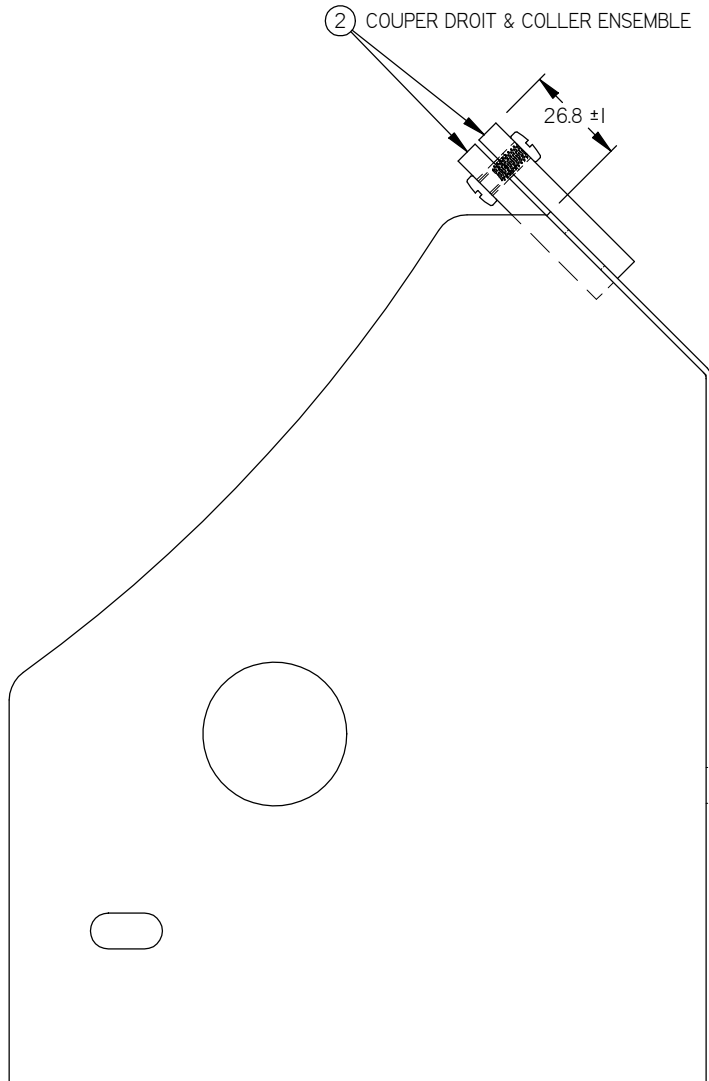
005A1302

ITEM	PART #	DESCRIPTION	QT.
1	004A3622	WHEEL COVER PRE-ASS'Y	1
2	179-0150	VINYL/BUNA-N FOAM RUBBER WITH ADHESIVE 73.5mm (0.0057)	2
3	057-0110	10-24 X 3/8" BINDING POST BLACK PLAST.	2



② COUPER DROIT & COLLER ENSEMBLE

26.8 ±1

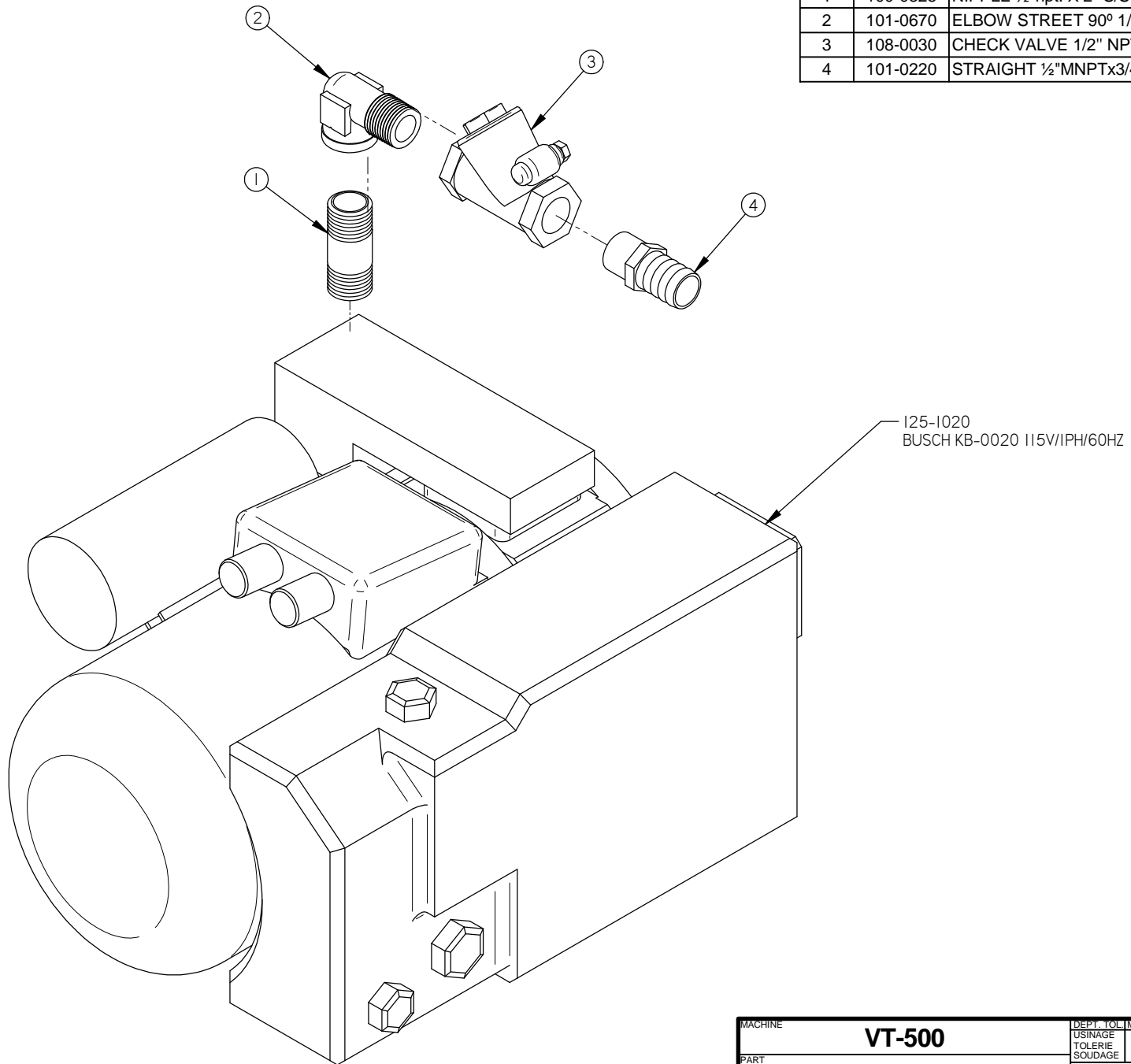


LET.	MODIFICATION	DATE	INT.
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MACHINE	VT-500		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	WHEEL COVER ASS'Y		USINAGE ± 0.1 ± 0.004	TOLERIE ± 0.5 ± 0.020	
			SOUDAGE ± 0.5 ± 0.020	N.T.S.	
ITEM	CNC	DEPT.	M	QT.	2
MAT.	DWG BY V.G. (CF)	DATE 11-08-18	NO.	005A1302	
	APP. BY	DATE			

007A0146

ITEM	PART #	DESCRIPTION	QT.
1	100-0325	NIPPLE 1/2"npt. X 2" S/S	1
2	101-0670	ELBOW STREET 90° 1/2" NPT. BR.	1
3	108-0030	CHECK VALVE 1/2" NPT STEAM	1
4	101-0220	STRAIGHT 1/2"MNPTx3/4" HOSE BARB BRASS	1

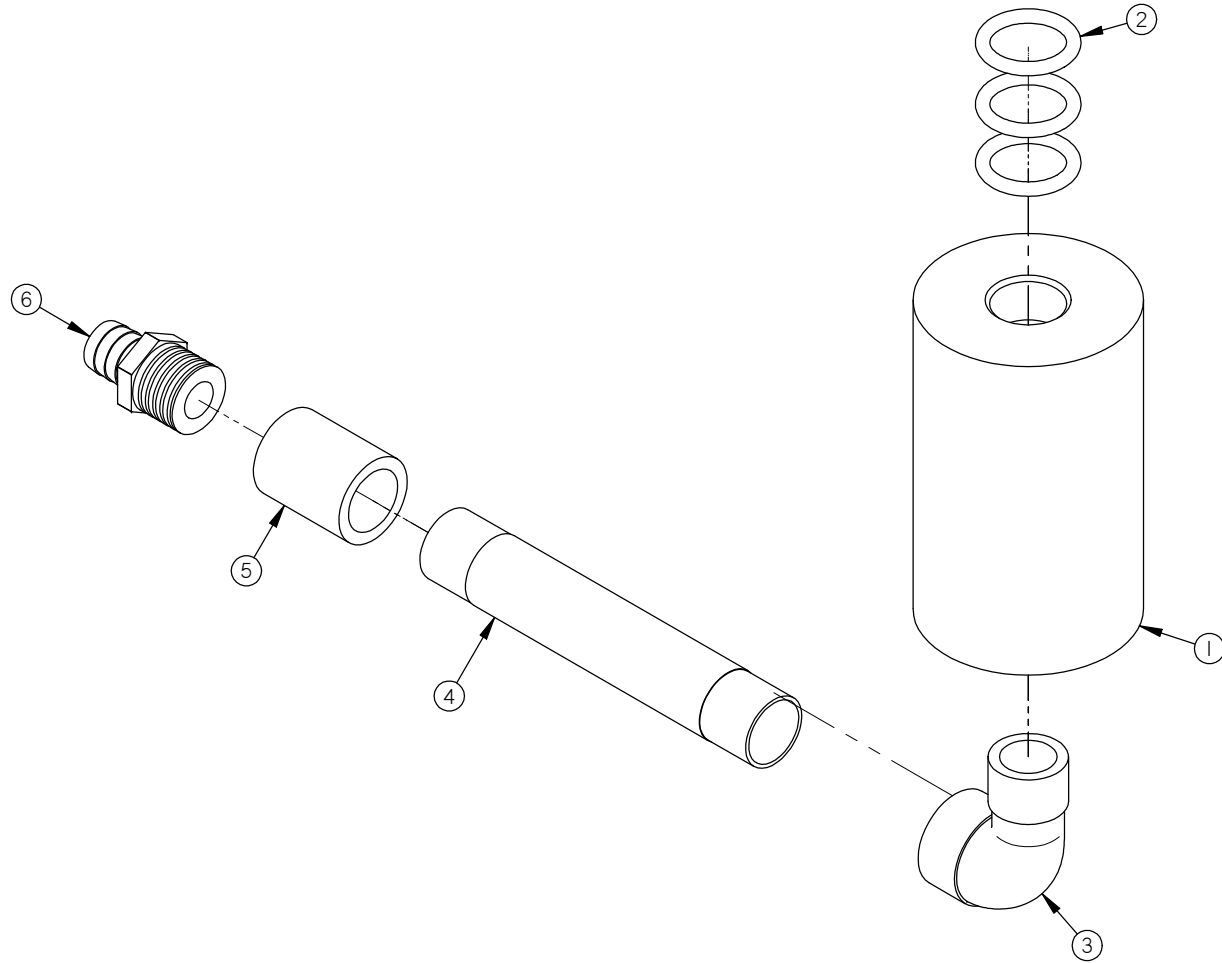


LET.	MODIFICATION	DATE	INT.
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MACHINE		VT-500		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		KB-20 PUMP HOOK-UP ASS'Y		USINAGE ± 0.1 ± 0.004	N.T.S.	
ITEM		CNC		TOLERIE ± 0.5 ± 0.020		
MAT.		APP. BY CF		SOUDAGE ± 0.5 ± 0.020		
		DATE 11-12-15		DEPT.	M-I	QTY. 1
		DATE		NO. 007A0146		

005A1303

ITEM	PART #	DESCRIPTION	QT.
1	002-0053	SWIVEL JOINT	1
2	076-0130	"O" RING 1" I.D. x 1 3/8" O.D. x 3/16"	3
3	100-0080	STREET ELBOW 3/4" npt. S/S	1
4	100-0370	NIPPLE 3/4" npt X 6" S/S	1
5	100-0130	COUPLING 3/4" NPT SS	1
6	101-0280	STRAIGHT 3/4" MNPT x 3/4" HOSE BARB	1

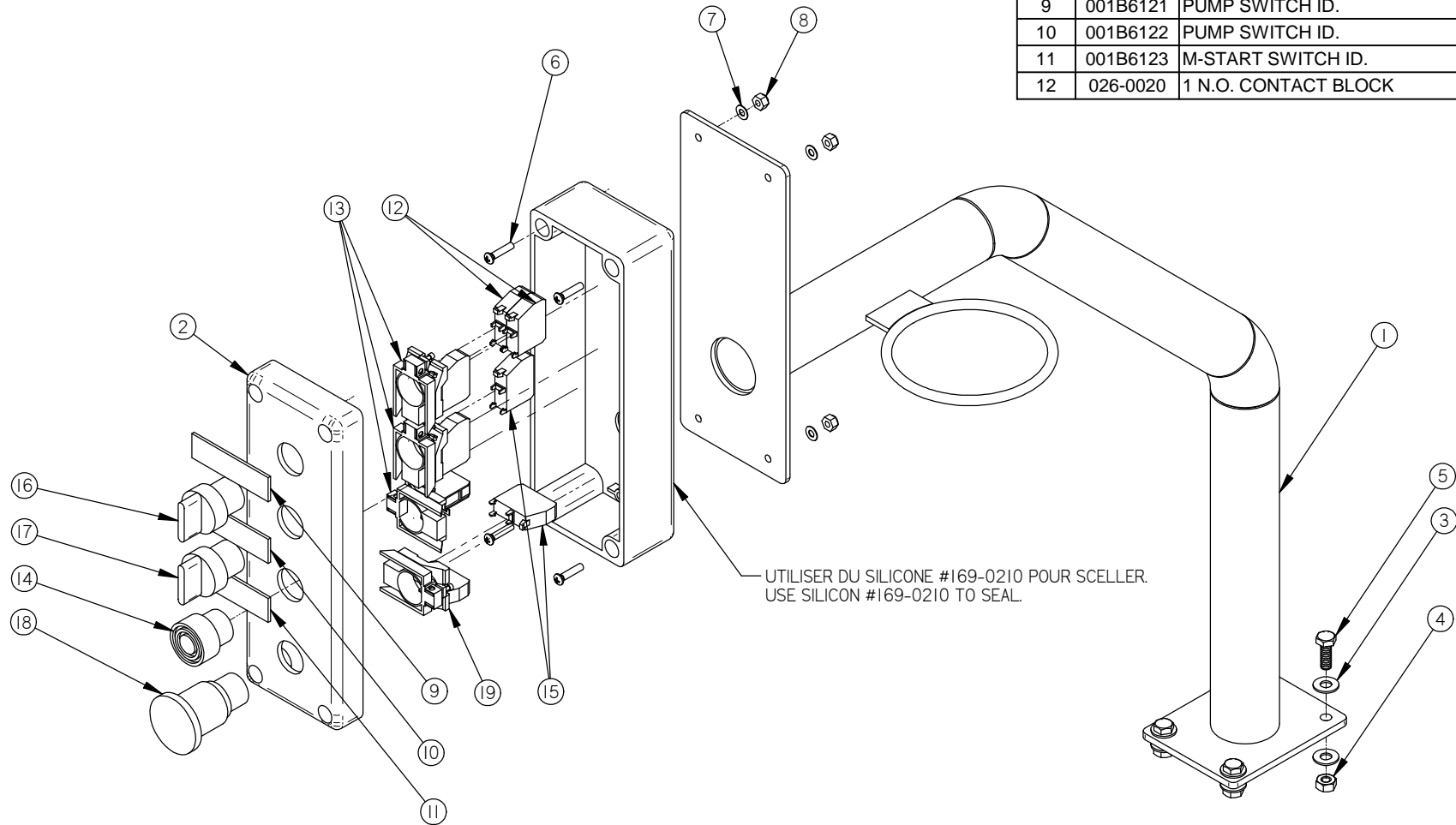


LET.	MODIFICATION	DATE	INT.
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MACHINE	VT-500		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART	SWIVEL JOINT ASS'Y		USINAGE ± 0.1 ± 0.004	TOLERIE ± 0.5 ± 0.020	
ITEM	CNC	DATE	11-08-23	N.T.S.	
MAT.	DWG BY V.G. (CF)	APP. BY	DATE	DEPT. M	QTY. 1
				005A1303	

005B1326

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
13	026-0010	1 N.O. CONTACT WITH BASE	3	1	004A3834	JOG PRE-ASS'Y	1
14	026-0110	BLACK CAP PUSH BUTTON (WATER)	1	2	003A0310	CONTROL BOX (JOG)	1
15	026-0030	1 N.C. CONTACT BLOCK	2	3	051-0740	WASHER 1/4" FLAT S/S	8
16	026-0050	3 POSITION SELECTOR	1	4	051-0580	NUT 1/4"-20 S/S	4
17	026-0040	2 POSITION SELECTOR	1	5	051-0190	BOLT 1/4-20 x 3/4" HEX S/S	4
18	026-0150	EMERGENCY BUTTON (PULL-PUSH)	1	6	051-0111	SCREW 8-32 x 3/4" RND PHIL S/S	4
19	026-0025	1 N.C. CONTACT WITH BASE	1	7	051-0720	WASHER #8 FLAT S/S	4
				8	051-0560	NUT #8-32 NYLON LOCK S/S	4
				9	001B6121	PUMP SWITCH ID.	1
				10	001B6122	PUMP SWITCH ID.	1
				11	001B6123	M-START SWITCH ID.	1
				12	026-0020	1 N.O. CONTACT BLOCK	2

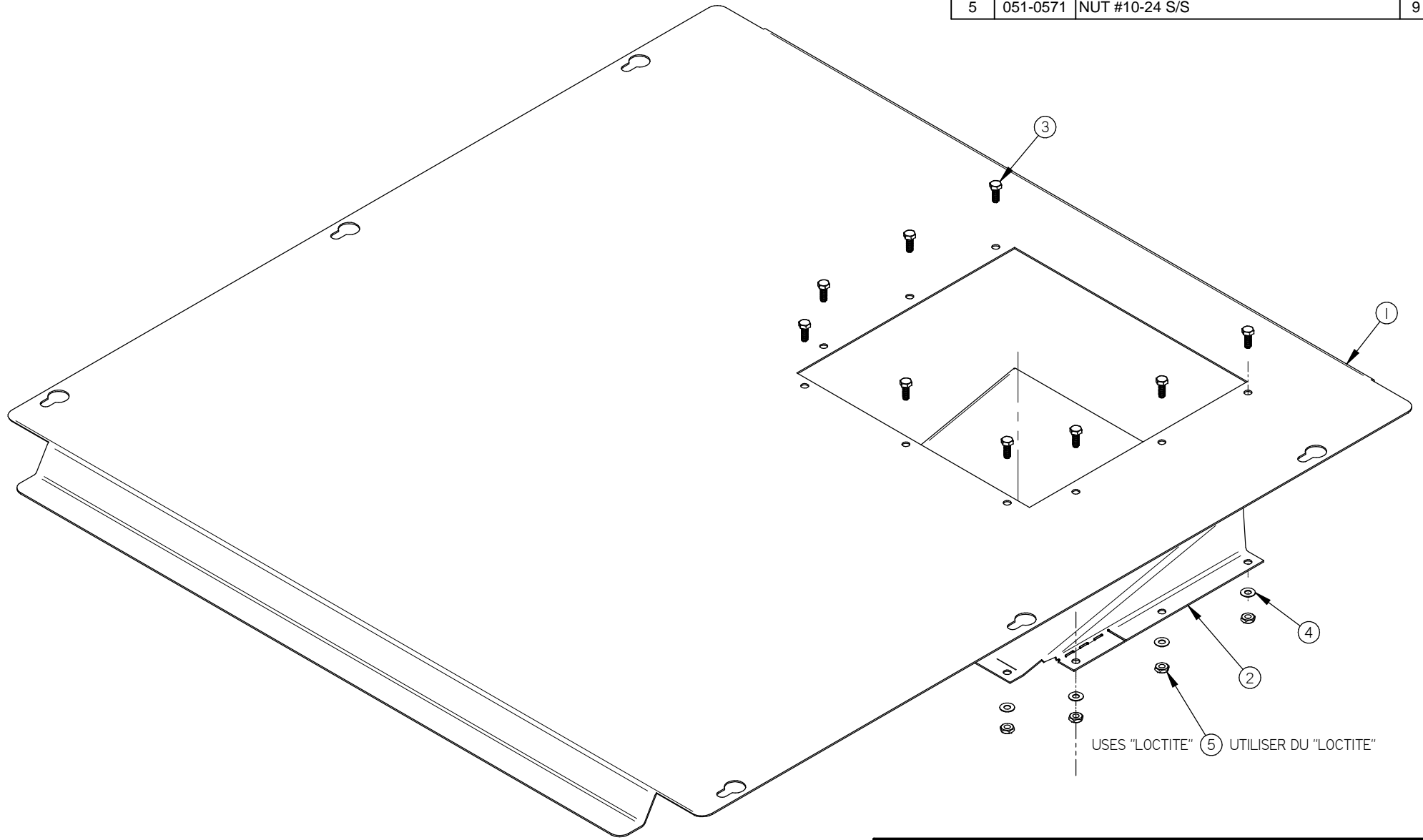


A	CHANGEMENT BOUTON	12-09-10	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		VT-500		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		JOG ASSEMBLY		USINAGE ± 0.1	± 0.004"	
				TOLERIE ± 0.5	± 0.020"	
ITEM		CNC		SOUDEGE ± 0.5	± 0.020"	N.T.S.
MAT.		DWG BY J.G.		DATE 12-01-10		DEPT. M-(I) QTY. 1
		APP. BY		DATE		005B1326

004A3956

ITEM	PART #	DESCRIPTION	QT.
1	001A5906	STRUCTURE ACCES PANEL	1
2	001A6298	EXHAUST DUCT	1
3	051-01435	SCREW 10-24 x 1/2" HEX S/S	9
4	051-0730	WASHER #10 FLAT S/S	9
5	051-0571	NUT #10-24 S/S	9



USES "LOCTITE" ⑤ UTILISER DU "LOCTITE"

MACHINE		VT-500		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		REAR STRUCTURE PANEL ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		DATE		NO.	
LET.		MODIFICATION		DATE		INT.	
		DWG BY J.G.		DATE 12-12-06		NO. 004A3956	
		APP. BY		DATE		M-I	
						QTY. 1	

LET. MODIFICATION DATE INT.