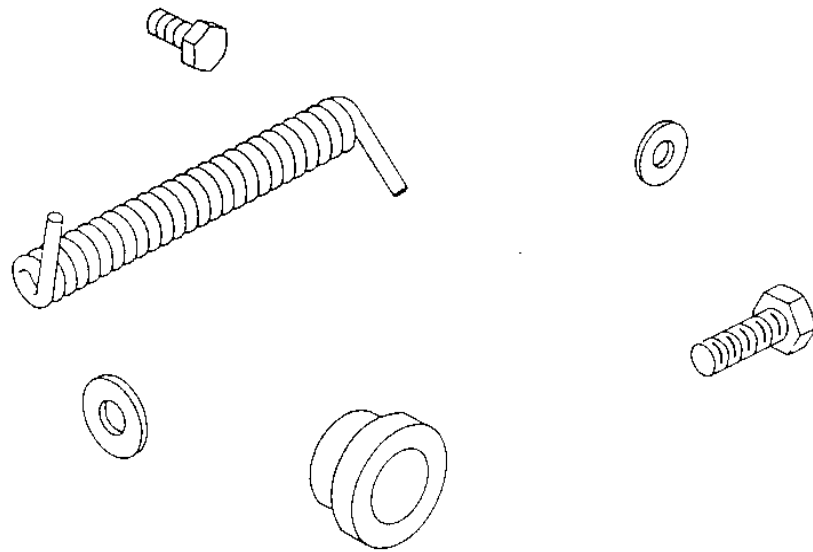


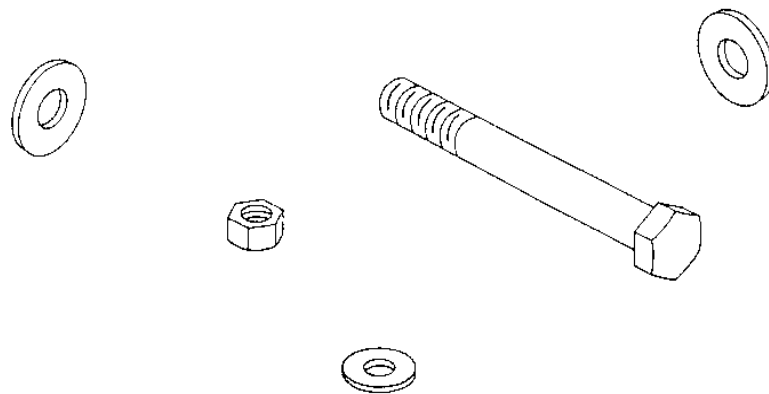


Parts List

VACCUM MACHINE **650A**

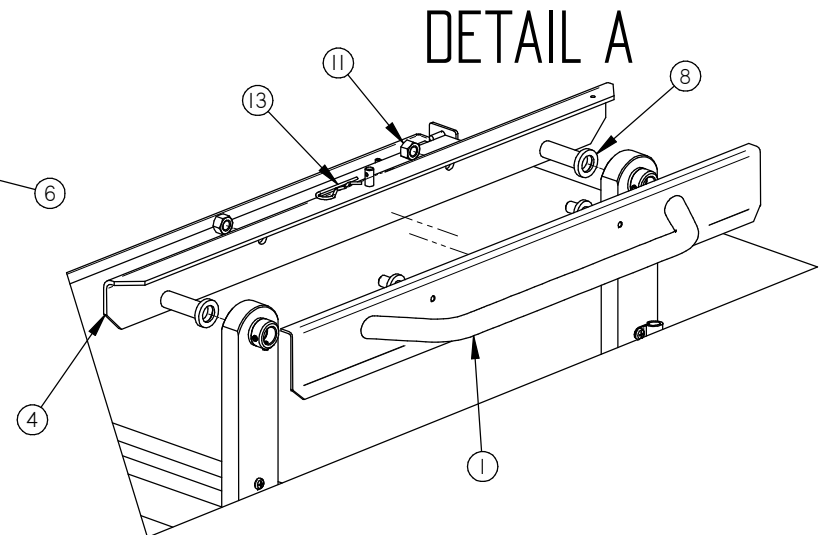
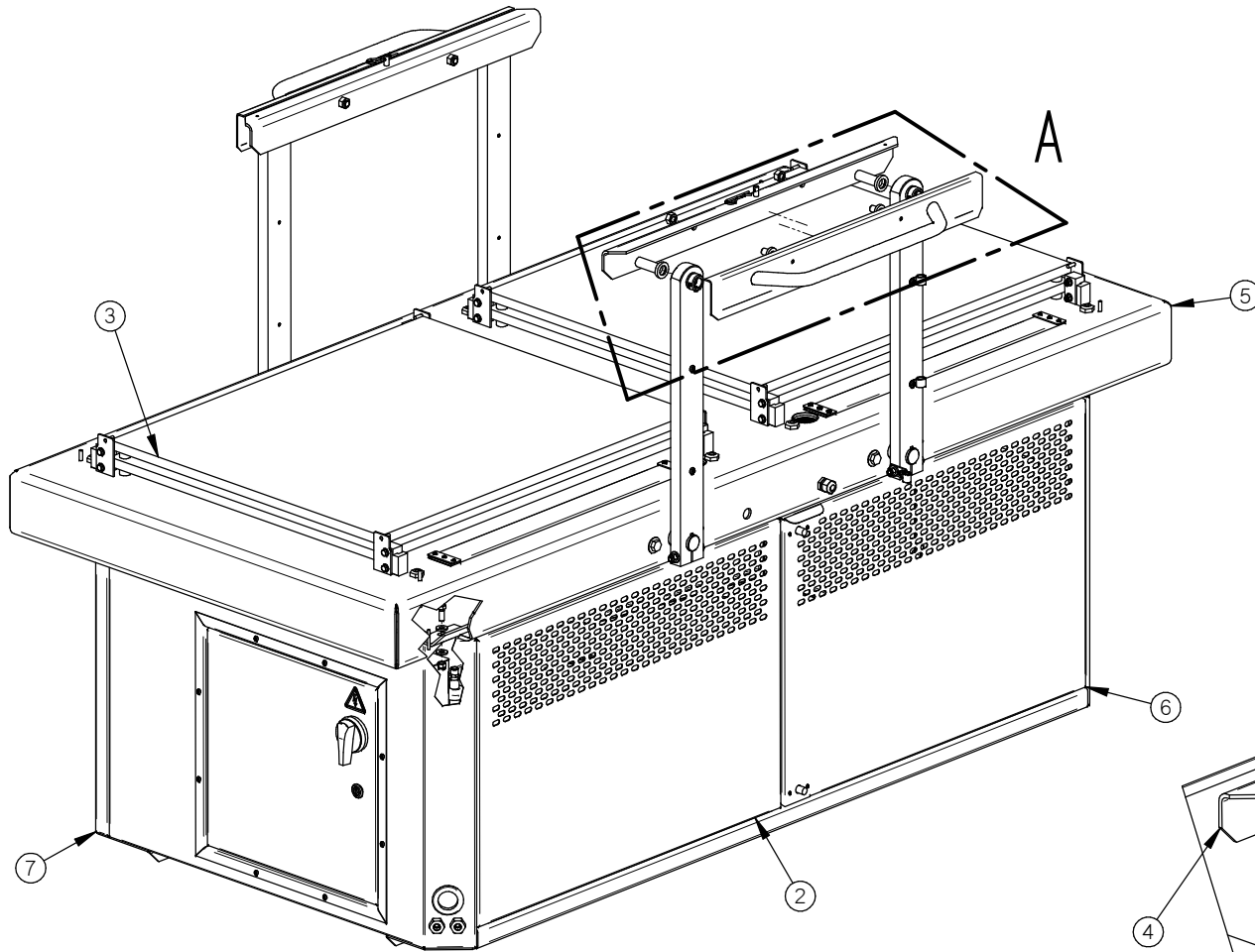


MECHANICAL DRAWING



005C0352

ITEM	PART #	DESCRIPTION	QT.
1	004A0213	COVER HANDLE ASS'Y	2
2	004A4239	LEFT REAR ACCESS DOOR PRE-ASSY	1
3	005-0349	FILLER PLATE ASSEMBLY	4
4	005-0359	ARM SUPPORT ASSEMBLY	2
5	005A1518	TABLE ASSEMBLY W/ARM	1
6	005A1519	RIGHT REAR ACCESS DOOR ASSY	1
7	005C0465	STRUCTURE ASSEMBLY	1
8	008-0368	ARM SUPPORT SPACER	4
9	051-0360	BOLT 3/8"-16nc. X 1" S/S	6
10	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	6
11	051-0630	NUT 1/2"-13 S/S	4
12	051-0783	WASHER 3/8" FLAT THICK S/S	12
13	056-0125	HITCH PIN CLIPS 3mm X 60mm S/S	2

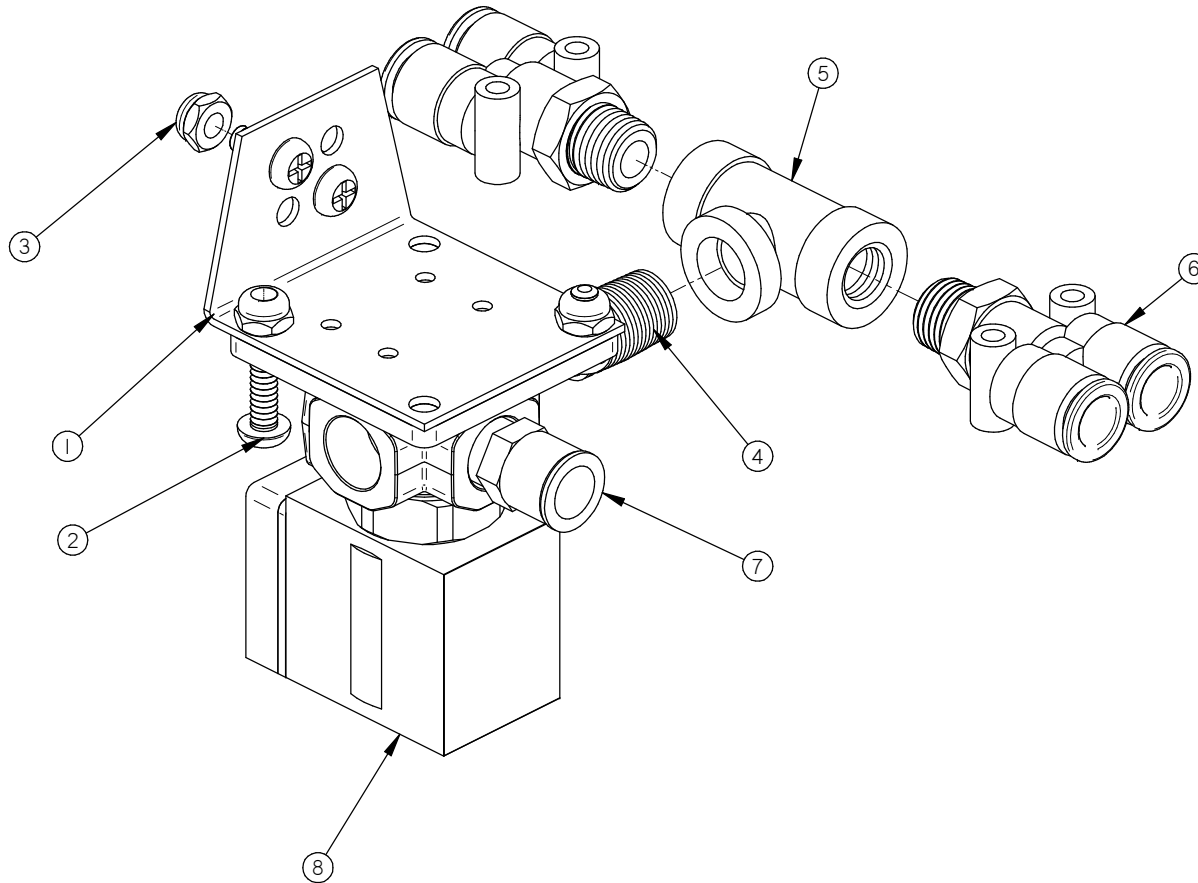


LET.	MODIFICATION	DATE	INT.
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MACHINE		650A		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		BASE MACHINE ASSY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"		
MAT.		3D DWG BY SBU		SOUDEGE	± 0.5	± 0.020"		
		2D DWG BY AG		DATE 14-07-14		NO.	005C0352	
				DATE 14-08-04		DEPT.	M	
						QTY.	1	

005A1524

ITEM	PART #	DESCRIPTION	QT.
1	001B6779	VALVE SUPPORT BRACKET	1
2	051-0144	SCREW #10-24 N.C 1/2" PAN PHIL. S/S	4
3	051-0572	NUT #10-24 NYLON LOCK S/S	4
4	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
5	100-0463	TEE 1/4" NPT S/S	1
6	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	2
7	102-0410	MALE CONN. 1/4" MNPT X 3/8" T. QUICK	1
8	106-00701	VALVE 3WAY 24V 1/4" NPT	1

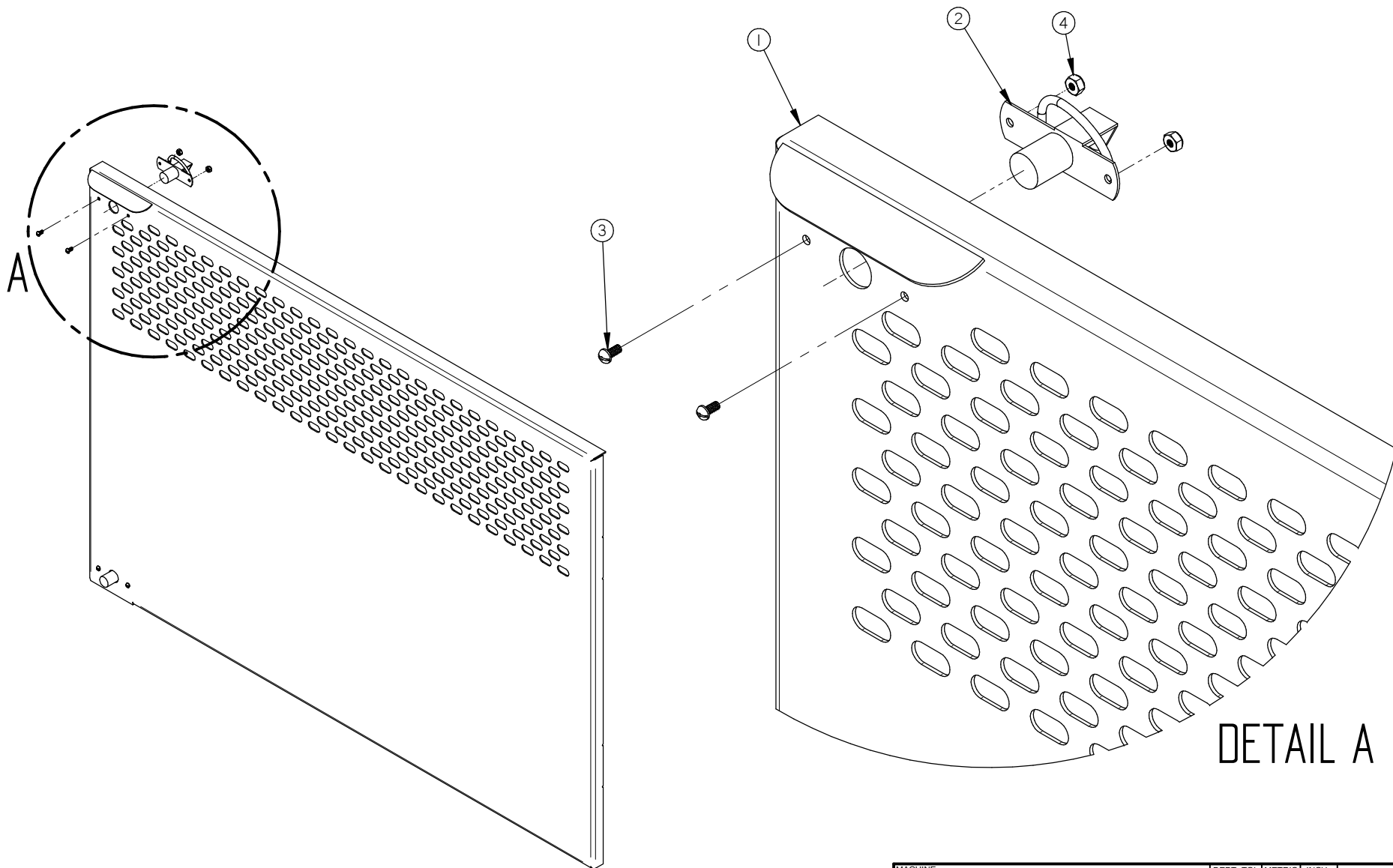


LET.	MODIFICATION	DATE	INT.
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MACHINE	650A	DEPT. TOL.	METRIC	INCH	SIPROMAC
PART	BELLOWS VALVE ASSY	USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM
ITEM	CNC	TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA
MAT.	3D DWG BY SBU	DATE	14-07-17	NO.	005A1524
	2D DWG BY XX	DATE	YY-MM-DD	DEPT.	M
				QTY.	1

005A1519

ITEM	PART #	DESCRIPTION	QT.
1	004A4238	RIGHT REAR ACCESS DOOR PRE-ASSY	1
2	056-2600	SPRING PAWL LATCHE SS KNOB	2
3	051-0071	SCREW 4-40 x 1/4" RND SLOT S/S	4
4	051-0541	NUT # 4-40 NYLON LOCK SS	4



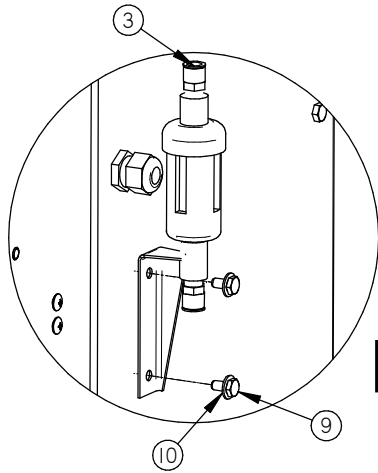
DETAIL A

LET.	MODIFICATION	DATE	INT.
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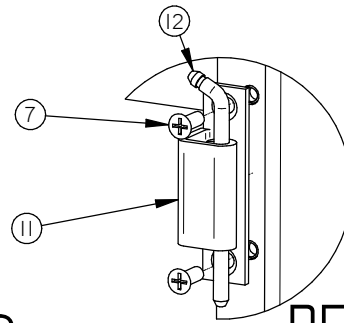
MACHINE		650A		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		RIGHT REAR ACCESS DOOR ASSY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		DWG BY SBU		SOUDEGE	± 0.5	± 0.020"	N.T.S.	
		DATE 13-09-16		DEPT.		M		QTY. 1
		APP. BY		DATE		NO. 005A1519		

005C0465

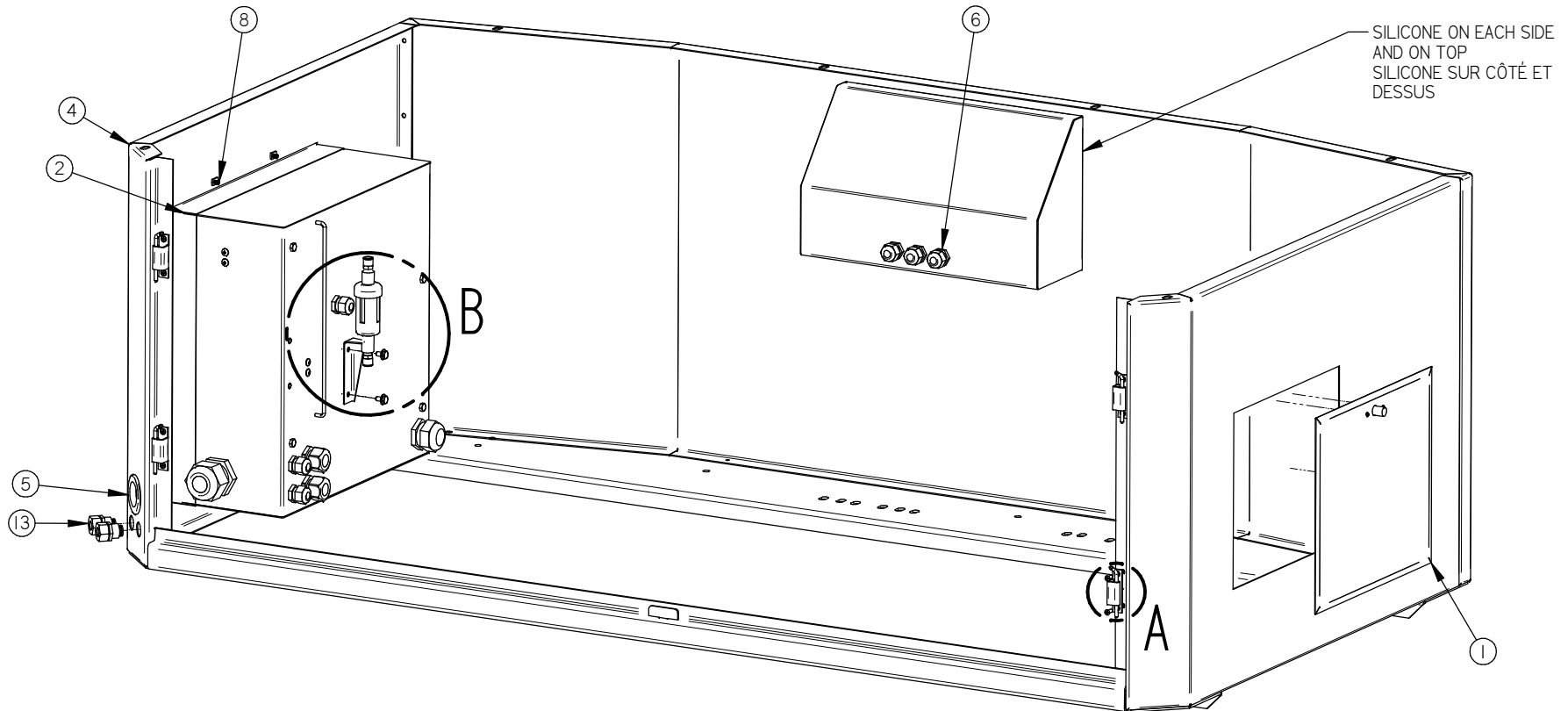
ITEM	PART #	DESCRIPTION	QT.
1	004A4090	ACCESS DOOR ASSEMBLY	1
2	004A4098	ELECTRIC BOX ASS'Y	1
3	004A4138	VACUUM SENSOR FILTER	1
4	004C0138	STRUCTURE PRE-ASSY	1
5	036-0265	GROMMET 1-1/2" ID X 2-3/8" OD RUBBER	1
6	036-0409	PRESSE-ETOUPE CD13	3
7	051-01385	SCREW 10-24 x 1/2" FLAT-UND. PHIL S/S	8
8	051-0144	SCREW #10-24 N.C 1/2" PAN PHIL. S/S	8
9	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	2
10	051-0740	WASHER 1/4" FLAT S/S	2
11	056-3010-1	HINGE CONCEALED SS304 - BASE	4
12	056-3010-3	HINGE CONCEALED SS304 - PIN	4
13	102-0551	BULKHEAD 1/4"NPT X 3/8 TUBE QUICK	2



DETAIL B



DETAIL A

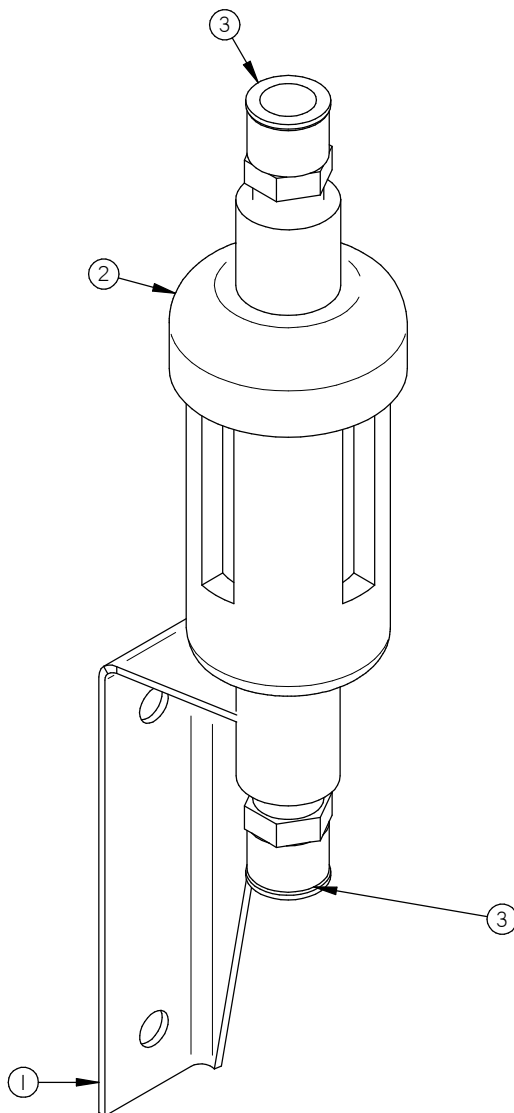


MACHINE		650A		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		STRUCTURE ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"	
DATE		14-07-16		N.T.S.		DEPT.	M-(M)-I
DATE						NO.	1
						005C0465	

LET.	MODIFICATION	DATE	INT.
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004A4138

ITEM	PART #	DESCRIPTION	QT.
1	004A4139	VACUUM SENSOR FILTER SUPPORT	1
2	114-2020	FILTER / DRYER ¼"mnpt. X 1/4"t.p. COMP.	1
3	102-0410	MALE CONN.1/4"MNPTx3/8"T.QUICK	2

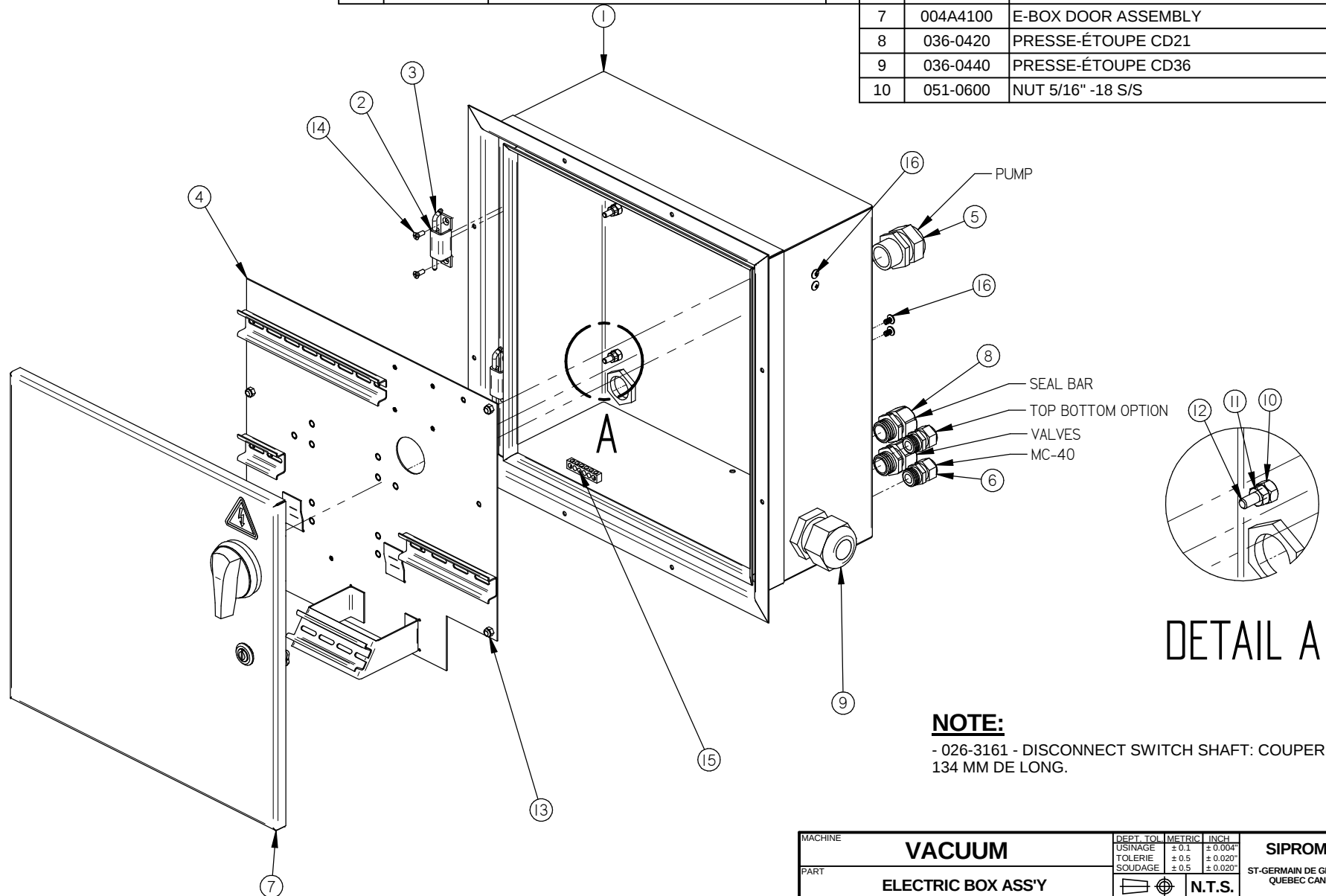


MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		VACUUM SENSOR FILTER		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM				TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.				SOUDAGE	± 0.5	± 0.020"	N.T.S.	
CNC				DEPT.		M	QTY.	1
DWG BY		SBU		DATE		13-11-19		NO.
APP. BY				DATE				004A4138

LET.	MODIFICATION	DATE	INT.
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004A4098

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
11	051-0580	NUT 1/4"-20 S/S	4	1	004A4099	E-BOX PRE-ASSY	1
12	051-0210	BOLT 1/4"-20nc. X 1" S/S	4	2	056-3010-1	HINGE CONCEALED SS304 - BASE	2
13	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4	3	056-3010-3	HINGE CONCEALED SS304 - PIN	2
14	051-0139	SCREW 10-24 x 1/2" FLAT PHIL S/S	4	4	004A4102	E-BOX FALSE BOTTOM	1
15	028-0105	GROUND BARRIER (6 HOLES)	1	5	036-0430	PRESSE-ÉTOUPE CD29	1
16	051-0128	SCREW 10-24 x 3/8" TRUSS PHIL S/S	4	6	036-0409	PRESSE-ÉTOUPE CD13	3
				7	004A4100	E-BOX DOOR ASSEMBLY	1
				8	036-0420	PRESSE-ÉTOUPE CD21	2
				9	036-0440	PRESSE-ÉTOUPE CD36	1
				10	051-0600	NUT 5/16" -18 S/S	4



NOTE:

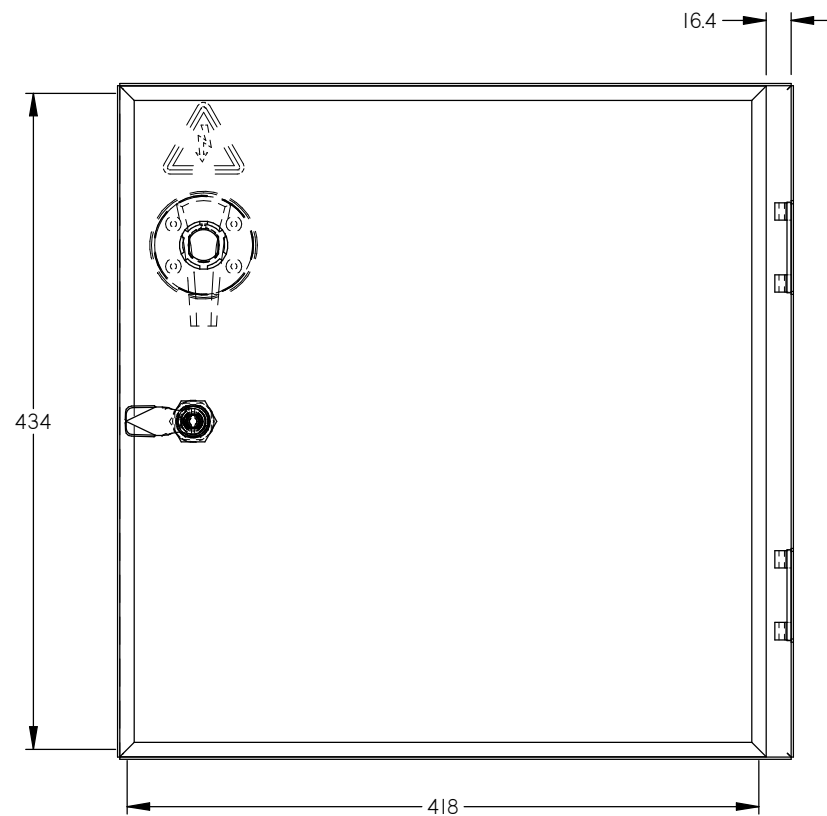
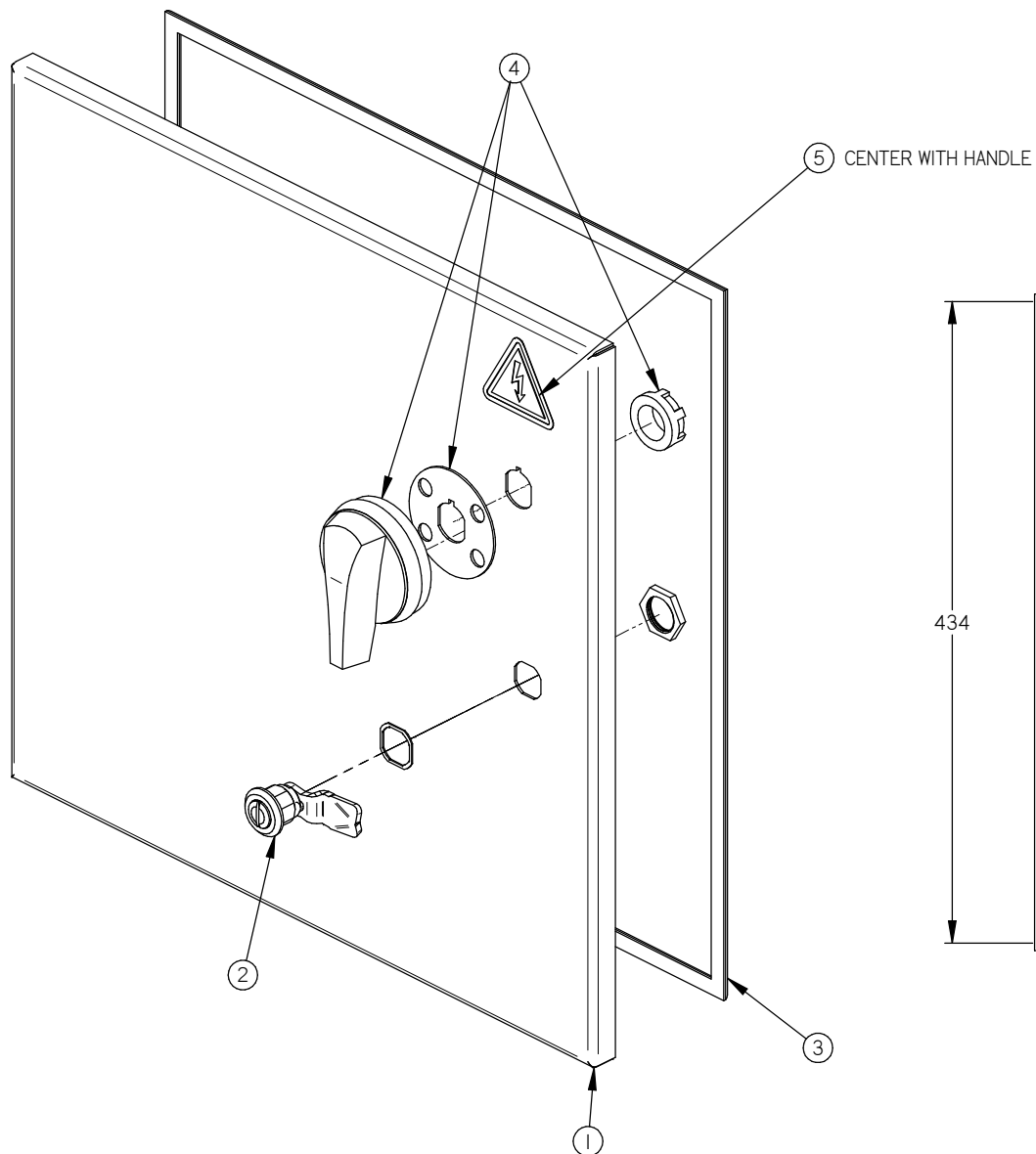
- 026-3161 - DISCONNECT SWITCH SHAFT: COUPER À 134 MM DE LONG.

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		ELECTRIC BOX ASS'Y		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		DWG BY SBU		SOUDEGE	± 0.5	± 0.020"	N.T.S.	
		DATE 13-09-23		DEPT.		M		QTY. 1
		APP. BY		DATE		004A4098		

LET.	MODIFICATION	DATE	INT.
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004A4100

ITEM	PART #	DESCRIPTION	QT.
1	004A4101	E-BOX DOOR PRE-ASSY	1
2	056-2612	CAM LOCK QUARTER TURN SS304	1
3	179-0026	D-SHAPED RUBBER SEAL 1683mm LONG	1
4	026-3160	HANDLE RED/YELLOW NEMA 4X, COMPACT, PADLOCKABLE	1
5	127-0100	STICKER ELEC.HAZARD ISO 2-1/2" TRIANGLE	1

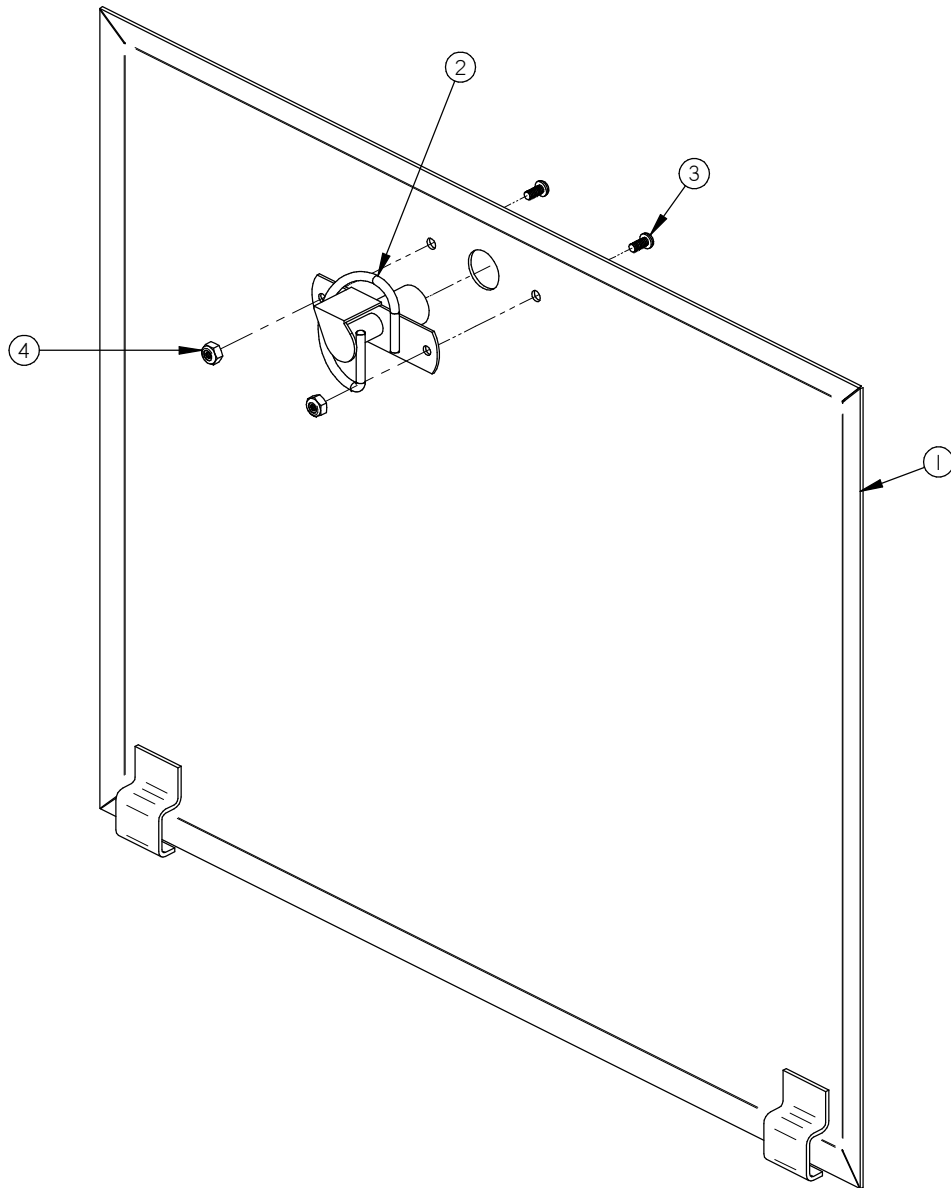


MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		E-BOX DOOR ASSEMBLY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
				TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
				SOUDAGE	± 0.5	± 0.020"	N.T.S.	
ITEM	CNC			DEPT.	M	QTY.	1	
MAT.	DWG BY	DATE	13-09-17	NO.	004A4100			
	APP. BY	DATE						

LET.	MODIFICATION	DATE	INT.
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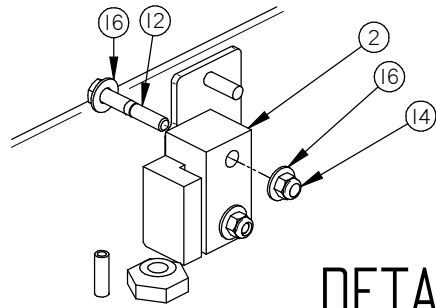
004A4090

ITEM	PART #	DESCRIPTION	QT.
1	004A4089	ACCESS PANEL PRE-ASSY	1
2	056-2600	SPRING PAWL LATCHE SS KNOB	1
3	051-0071	SCREW 4-40 x 1/4" RND SLOT S/S	2
4	051-0541	NUT # 4-40 NYLON LOCK SS	2

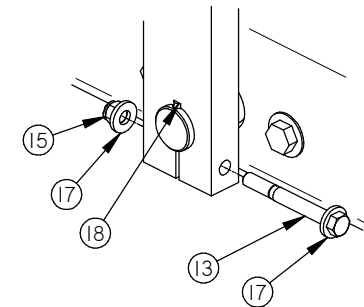
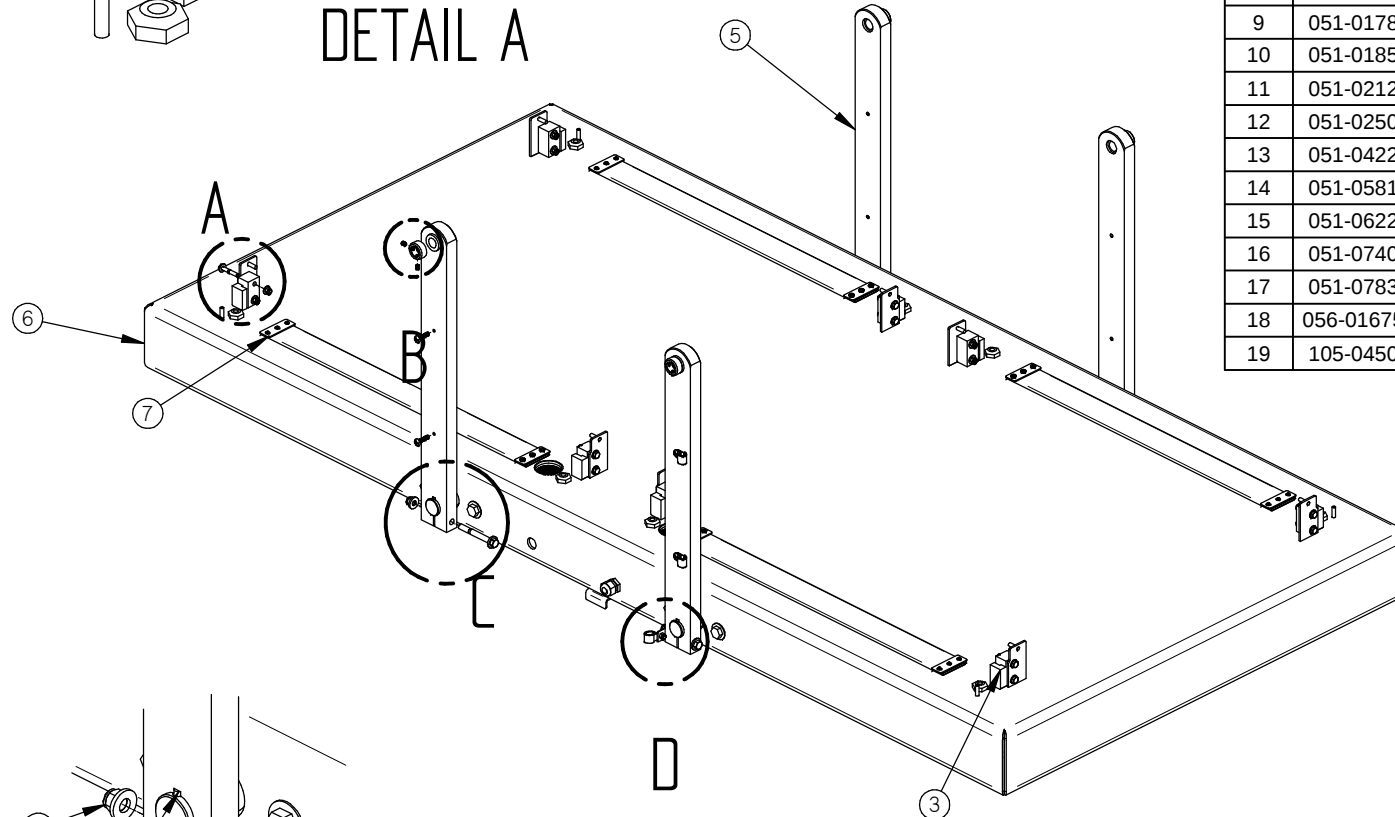


MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		ACCESS DOOR ASSEMBLY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		APP. BY SBU		DATE	13-09-11		NO. 004A4090	
LET.		MODIFICATION		DATE		INT.		QTY. 1

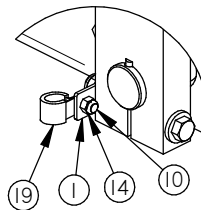
005A1518



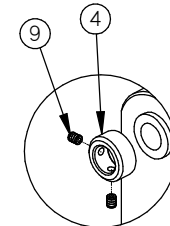
DETAIL A



DETAIL C



DETAIL D



DETAIL B

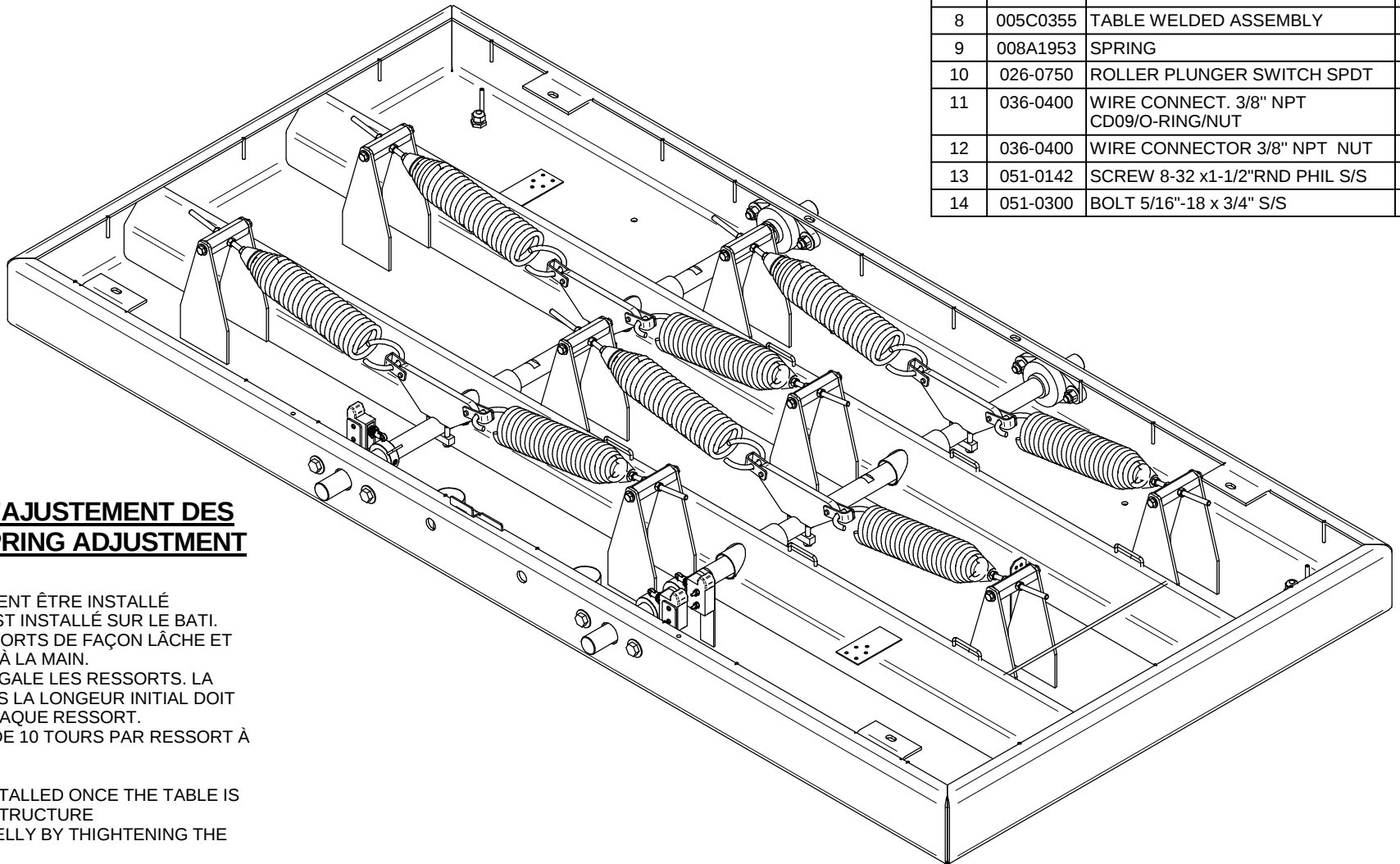
ITEM	PART #	DESCRIPTION	QT.
1	001-1876	LOWER WIRE SUPPORT	1
2	002-0326	LEFT SEAL BAR GUIDE BLOCK	4
3	002-0327	RIGHT SEAL BAR GUIDE BLOCK	4
4	002-0390	COVER ARM COLLAR	4
5	004B0383	COVER ARM ASSY	4
6	004C0137	TABLE ASSEMBLY	1
7	005-0651	BELLOWS ASSEMBLY	4
8	036-0409	PRESSE-ETOUPE CD13	1
9	051-0178	SCREW 1/4"-20 x 5/16" SKT SET S/S	8
10	051-0185	SCREW 1/4-20x 1/2"PAN PHIL S/S	1
11	051-0212	SCREW 1/4"-20 x 1" PAN PHILL S/S	8
12	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	16
13	051-0422	BOLT 3/8"-16nc. X 3/4" S/S	4
14	051-0581	NUT 1/4"-20 NYLON LOCK S/S	17
15	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	4
16	051-0740	WASHER 1/4" FLAT S/S	32
17	051-0783	WASHER 3/8" FLAT THICK S/S	8
18	056-01675	KEY 1/4" SQ. x 1 1/4" ROUNDED END S/S	4
19	105-0450	METAL CABLE CLAMPS #6 SS	3

MACHINE		650A		DEPT. TOL.	METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART		TABLE ASSEMBLY W/ARM		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		3D DWG BY SBU AG		SOUDEGE	± 0.5	± 0.020"	
		DATE 14-07-10		N.T.S.		DEPT.	M
		DATE 14-07-31				QTY.	1
						NO. 005A1518	

LET.	MODIFICATION	DATE	INT.
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004C0137

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
20	051-0760	WASHER 5/16" FLAT S/S	16	15	051-0441	BOLT 1/2"-13 x 1 1/2" SS	8	1	002A3941	SPRING ADJ. PIVOT	8
21	051-0790	WASHER 1/2" FLAT S/S	16	16	051-0560	NUT #8-32 NYLON LOCK S/S	6	2	002A4002	SPRING ADJ. PIVOT SPACER	16
22	075-1655	2 BOLT FLANGED BEARING 1-1/4" PLASTIC	4	17	051-0600	NUT 5/16" -18 S/S	16	3	002B0331	CENTRAL SHAFT	2
				18	051-0630	NUT 1/2"-13 S/S	8	4	004A3937	SHACKLE ASS'Y	8
				19	051-0720	WASHER #8 FLAT S/S	6	5	004A3968	SPRING INSERT ASSEMBLY	8
								6	005A1437	MICRO SWITCH COLLAR ASSY	3
								7	005A1517	SPRING BLOCK PRE-ASSY	4
								8	005C0355	TABLE WELDED ASSEMBLY	1
								9	008A1953	SPRING	8
								10	026-0750	ROLLER PLUNGER SWITCH SPDT	3
								11	036-0400	WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT	8
								12	036-0400	WIRE CONNECTOR 3/8" NPT NUT	8
								13	051-0142	SCREW 8-32 x1-1/2"RND PHIL S/S	6
								14	051-0300	BOLT 5/16"-18 x 3/4" S/S	16



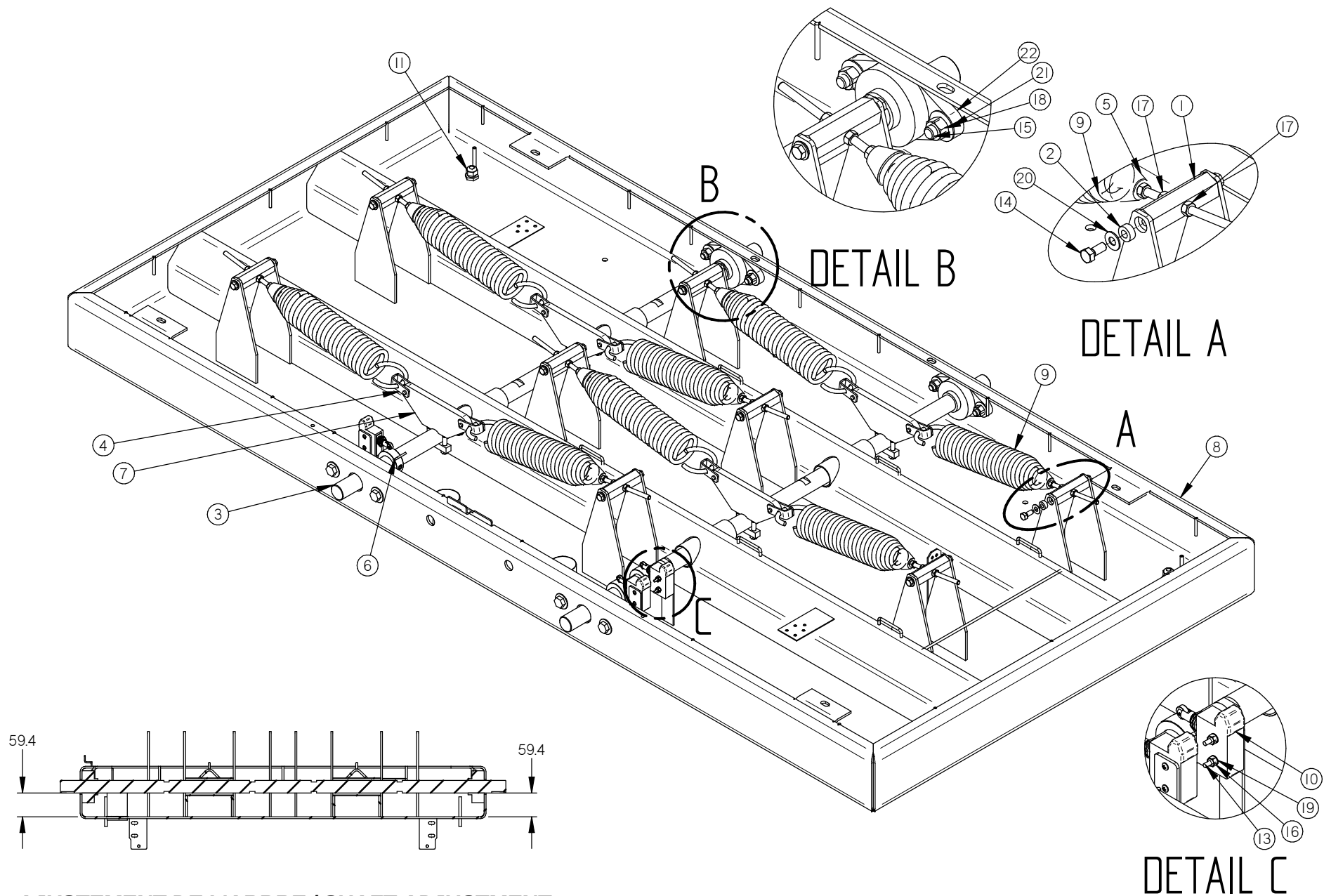
PROCÉDURE D'AJUSTEMENT DES RESSORTS / SPRING ADJUSTMENT PROCEDURE:

- LES RESSORTS DOIVENT ÊTRE INSTALLÉ LORSQUE LA TABLE EST INSTALLÉ SUR LE BATI.
 - INSTALLER LES RESSORTS DE FAÇON LÂCHE ET SERRER LES ÉCROUS À LA MAIN.
 - TENDRE DE FAÇON ÉGALE LES RESSORTS. LA LONGEUR ÉTIRÉ MOINS LA LONGEUR INITIAL DOIT ÊTRE ÉGALE POUR CHAQUE RESSORT.
 - NE PAS FAIRE PLUS DE 10 TOURS PAR RESSORT À LA FOIS

- SPRING MUST BE INSTALLED ONCE THE TABLE IS ASSEMBLED ON THE STRUCTURE
 - INSTALL THEM LOOSELY BY THIGHTENING THE NUT BY HAND
 - TENSION SPRING EQUALLY. THE STRECHTED LENGTH MINUS THE INITIAL LENGTH MUST BE THE SAME ON EACH SPRING.
 - DO NOT STRETCH THE SPRING BY MORE THAN 10 NUT TURN AT A TIME PER SPRING.

LET.	MODIFICATION	DATE	INT.
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MACHINE		650A		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		TABLE ASSEMBLY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
				TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
				SOUDAGE	± 0.5	± 0.020"	N.T.S.	
ITEM	CNC	DATE	14-07-09	DEPT.	M-I	QTY.	1	
MAT.	3D DWG BY SBU	DATE	14-10-08			NO. 004C0137		



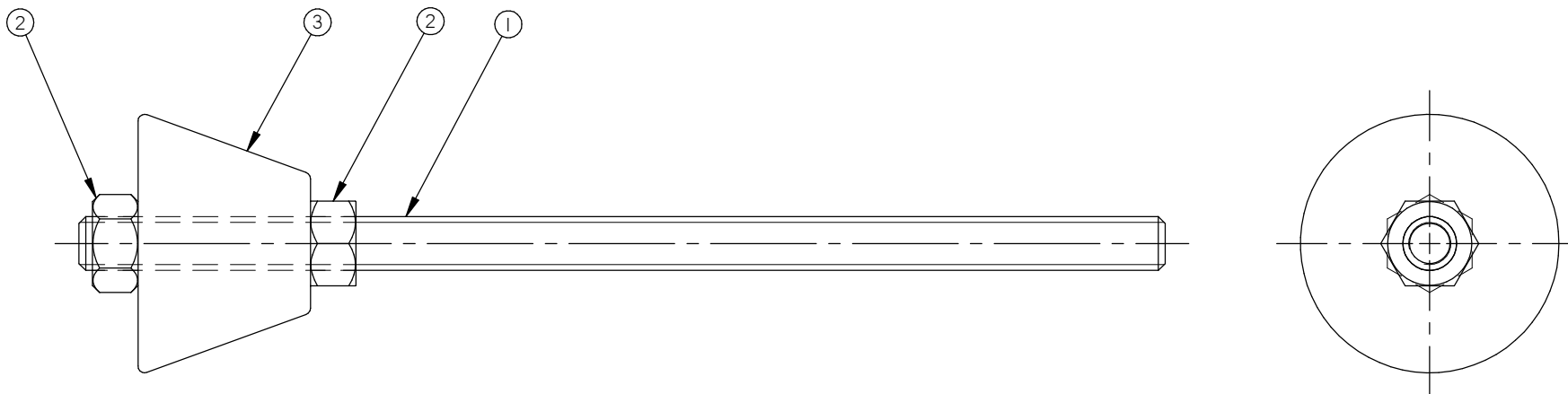
AJUSTEMENT DE L'ARBRE / SHAFT ADJUSTMENT

- UTILISER LES CALES POUR POSITIONNER L'ARBRE
 - CENTRER L'ARBRE HORIZONTALEMENT DANS LE TROU DE LA TABLE
-
- USE BLOC TO SPACE THE SHAFT ACCORDINGLY
 - CENTER SHAFT HORIZONTALLY IN THE TABLE HOLE

MACHINE		650A		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		TABLE ASSEMBLY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		3D DWG BY SBU		SOUDEGE	± 0.5	± 0.020"	NO. 004C0137	
		DATE 14-07-09		DEPT. M-I		QTY. 1		
		DATE						

004A3968

ITEM	PART #	DESCRIPTION	QT.
1	002A3989	SPRING ADJUSTMENT ROD	1
2	051-0600	NUT 5/16" -18 S/S	2
3	002B3940	SPRING INSERT	1



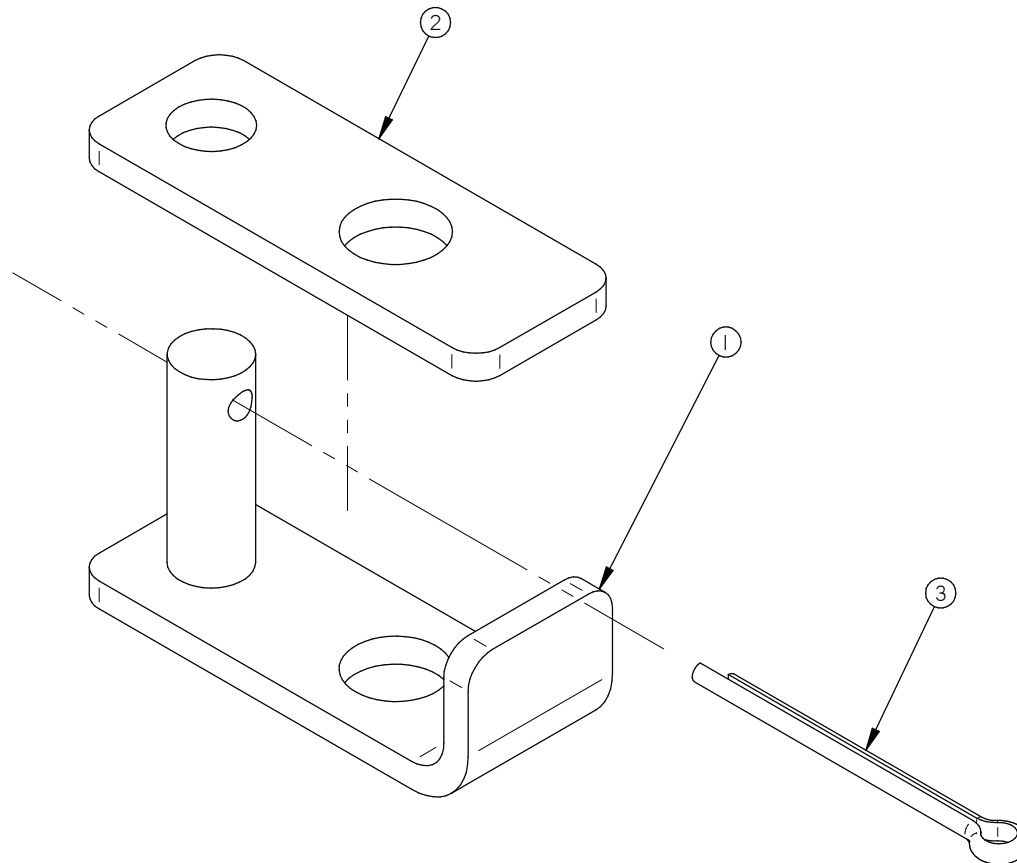
650A	8
620A	4
600A	4
420A	2
MACHINE	QTY

B	AJOUT 420A ET 650A	14-08-04	SBU
A	AJOUTER 620A	13-01-23	J.G.
LET.	MODIFICATION	DATE	INT.

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	STIPROMAC	
PART		SPRING INSERT ASSEMBLY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		DWG BY J.G.		SOUDEGE	± 0.5	± 0.020"	N.T.S.	
		DATE 13-01-15				NO.		
		APP. BY				M-(M) QTY		
		DATE				004A3968		

004A3937

ITEM	PART #	DESCRIPTION	QT.
1	004A3935	SHACKLE PRE-ASS'Y	1
2	001A6269	SHACKLE PLATE	1
3	056-0118	COTTER PIN 3/32" x 1" S/S	1



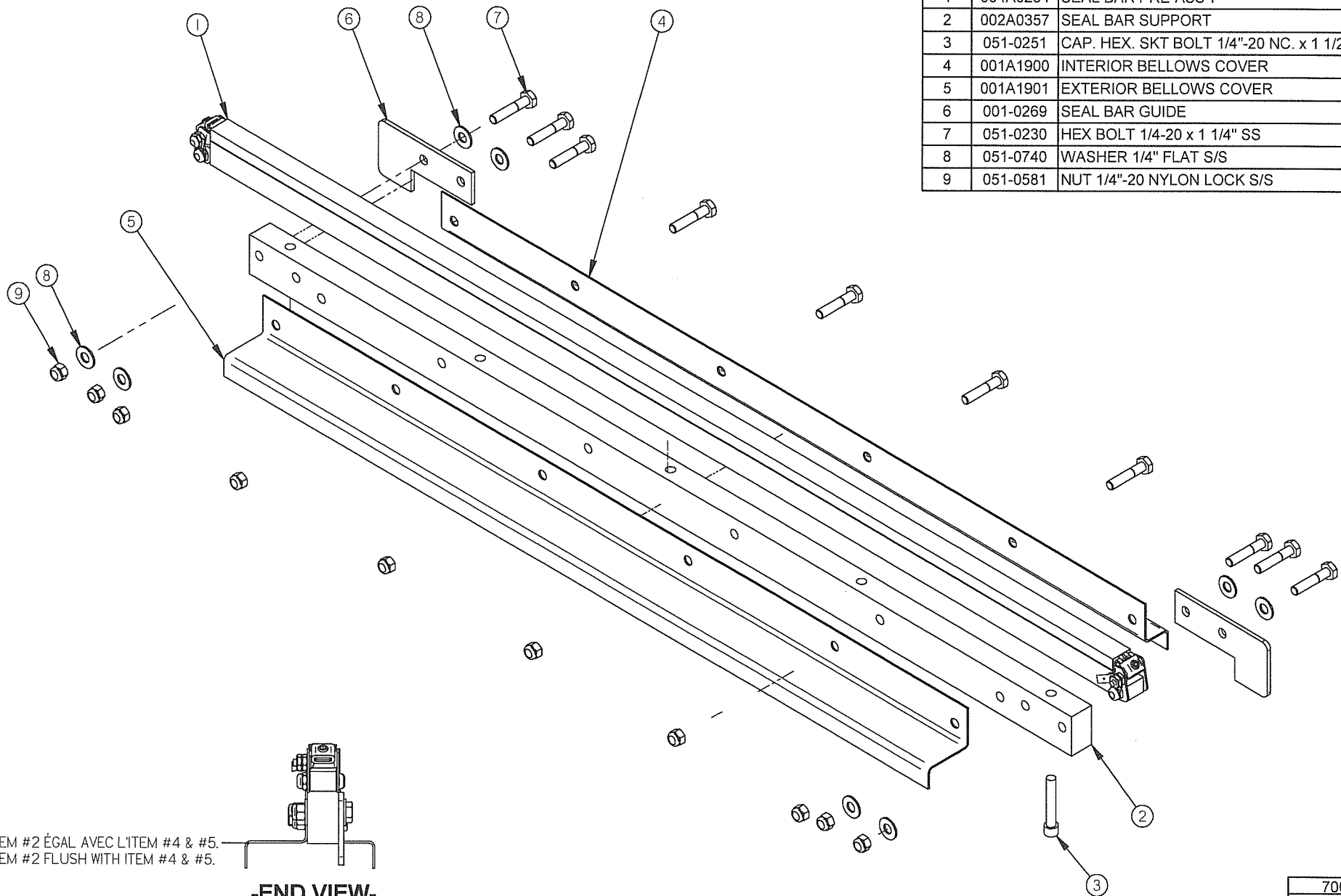
650A	8
620A	4
600A	4
420A	2
MACHINE	QTY

B	AJOUT 420A ET 650A	14-08-04	SBU
A	AJOUTER 620A	13-01-23	J.G.
LET.	MODIFICATION	DATE	INT.

MACHINE		VACUUMS		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		SHACKLE ASS'Y		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM				TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.				SOUDAGE	± 0.5	± 0.020"	N.T.S.	
DWG BY		J.G.		DATE	12-11-06		NO.	004A3937
APP. BY				DATE			M-(M) LISTE	

005C0547

ITEM	PART #	DESCRIPTION	QT.
1	004A0254	SEAL BAR PRE-ASS'Y	1
2	002A0357	SEAL BAR SUPPORT	1
3	051-0251	CAP. HEX. SKT BOLT 1/4"-20 NC. x 1 1/2"	5
4	001A1900	INTERIOR BELLOWS COVER	1
5	001A1901	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	10
8	051-0740	WASHER 1/4" FLAT S/S	8
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	10



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

-END VIEW-

-TWIN SEAL OPTION-

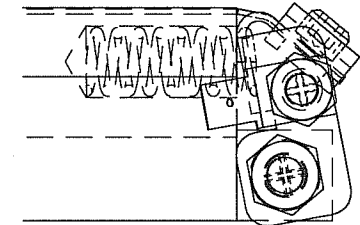
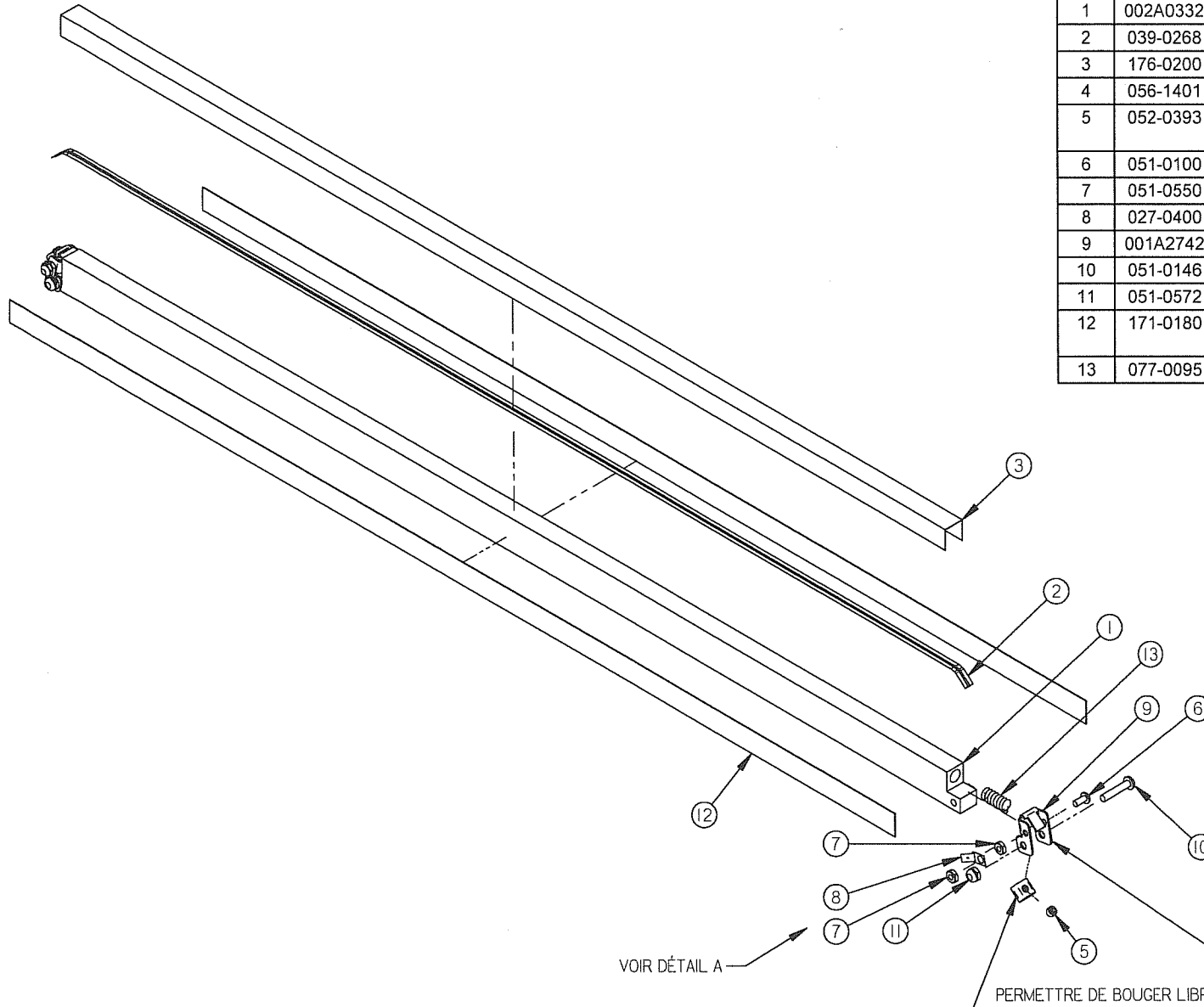
700A	4
680A	4
650A	4
MACHINE	QTY

MACHINE		DEPT. TOL. METRIC		INCH		SIPROMAC	
650A, 680A & 700A		USINAGE	± 0.1	± 0.004"		ST-GERMAIN DE GRANTHAM	
PART		TOLERIE	± 0.5	± 0.020"		QUEBEC CANADA	
SEAL BAR ASS'Y W/SUPPORT		SOUDEAGE	± 0.5	± 0.020"		MACHINE	
ITEM		CNC		DEPT.		M-I(M) QTY	
MAT.		DWG BY CF		DATE 12-04-12		LIST	
		APP. BY		DATE		005C0547	

G	REDRAWN / REMOVED WIRE DUCT	12-04-12	CF
LET.	MODIFICATION	DATE	INT.

004A0254

ITEM	PART #	DESCRIPTION	QT.
1	002A0332	SEAL BAR	1
2	039-0268	DOUBLE SEAM BAND (8MM) (3.1)	1
3	176-0200	TEFLON TAPE 5MIL (0.104)	1
4	056-1401	3/8"SET SCREW BANDING BUCKLE S/S	2
5	052-0393	SCREW 1/4-28x3/16"SKT SET OVAL POINT ZINC	2
6	051-0100	SCREW 8-32 X 3/8" PAN PHIL S/S	2
7	051-0550	NUT #8-32 SS	4
8	027-0400	CONNECTOR ADAPTOR	2
9	001A2742	8mm ELEMENT BINDER	2
10	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
11	051-0572	LOCK NUT #10-24 S/S	2
12	171-0180	TAPE CLEAR SUPER BOND 3/4" 854.5mm (0.026)	2
13	077-0095	SPRING C 0360-059-1250 S/S	2



-DÉTAIL A-

VOIR DÉTAIL A

PERMETTRE DE BOUGER LIBREMENT (9) ALLOW TO MOVE FREELY

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

-TWIN SEAL OPTION-

700A	4
680A	4
650A	4
580A	2
MACHINE	QTY

F	MODIF. A-453 AJOUTER 077-0095	10-06-01	J.G.
E	ADDED 052-0393	06-04-19	M.A.
D	REDRAWN	06-01-16	M.A.
LET.	MODIFICATION	DATE	INT.

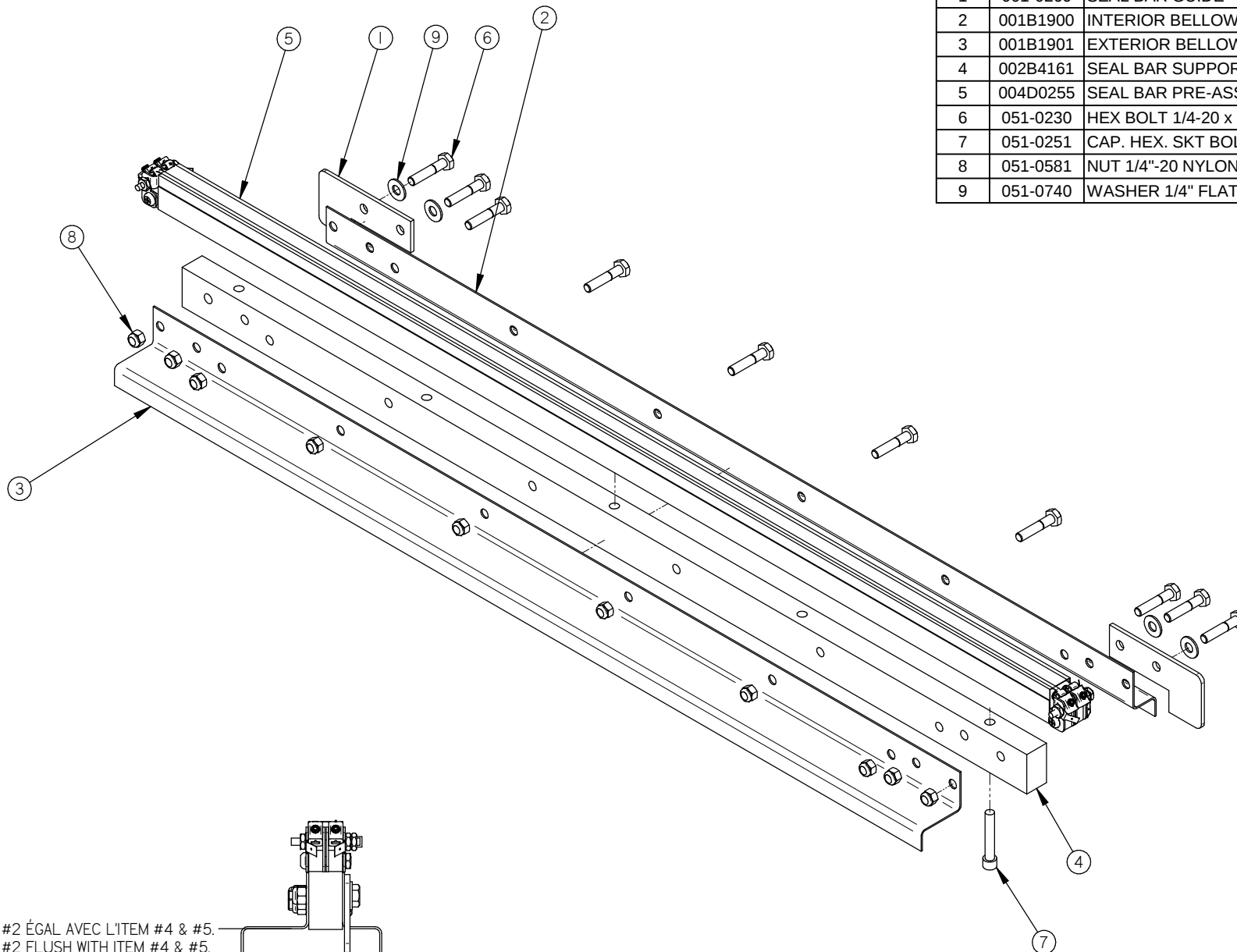
MACHINE 580A, 650A, 680A & 700A		DEPT TOL METRIC INCH	
PART SEAL BAR PRE-ASSY		USINAGE ± 0.1 ± 0.004"	
		TOLERIE ± 0.5 ± 0.020"	
		SOUDAGE ± 0.5 ± 0.020"	
		N.T.S.	
ITEM	CNC	DEPT.	NO.
MAT.	DWG BY M.A.L.	DATE 06-01-16	INT.
	APP. BY D	DATE 10-09-14	
			004A0254

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

M-(M)-I LISTE

005F0548

ITEM	PART #	DESCRIPTION	QT.
1	001-0269	SEAL BAR GUIDE	2
2	001B1900	INTERIOR BELLOWS COVER	1
3	001B1901	EXTERIOR BELLOWS COVER	1
4	002B4161	SEAL BAR SUPPORT (ECO)	1
5	004D0255	SEAL BAR PRE-ASS'Y	1
6	051-0230	HEX BOLT 1/4"-20 x 1 1/4" SS	10
7	051-0251	CAP. HEX. SKT BOLT 1/4"-20 NC. x 1 1/2"	5
8	051-0581	NUT 1/4"-20 NYLON LOCK S/S	10
9	051-0740	WASHER 1/4" FLAT S/S	4



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

-END VIEW-

-BAG CUT OPTION-

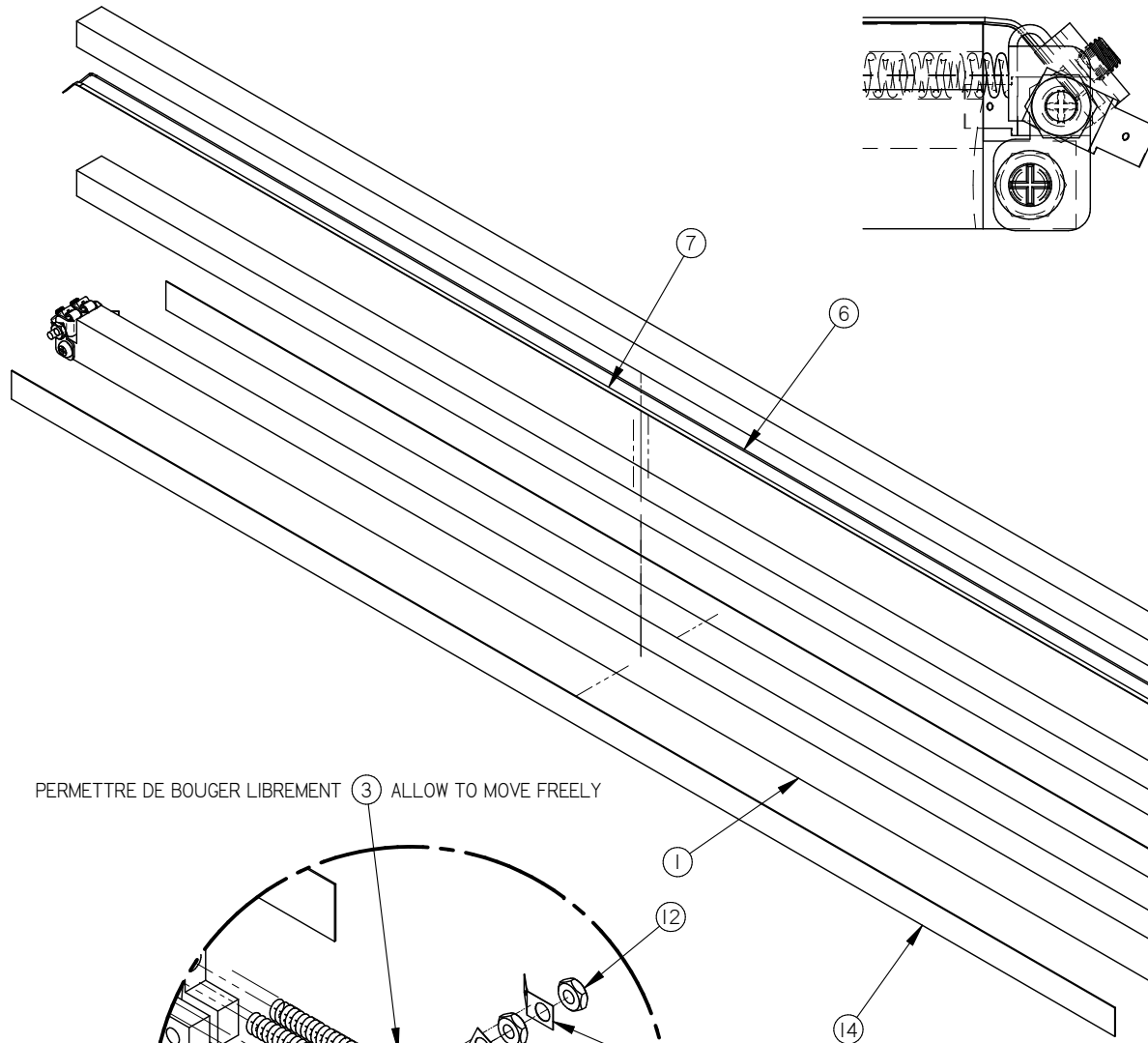
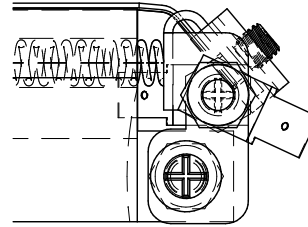
700A	4
680A	4
650A	4
MACHINE	QTY

MACHINE 650A, 680A & 700A		DEPT. TOL. METRIC	INCH	SIPROMAC	
PART SEAL BAR ASS'Y W/SUPPORT		USINAGE ± 0.1 TOLERIE ± 0.5 SOUDAGE ± 0.5	± 0.004" ± 0.020" ± 0.020"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM	CNC	N.T.S.		DEPT.	M-I-(M) QTY
MAT.	DWG BY S.L.	DATE 14-02-12	NO.	LISTE	
		DATE	005F0548		

LET.	MODIFICATION	DATE	INT.
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004D0255

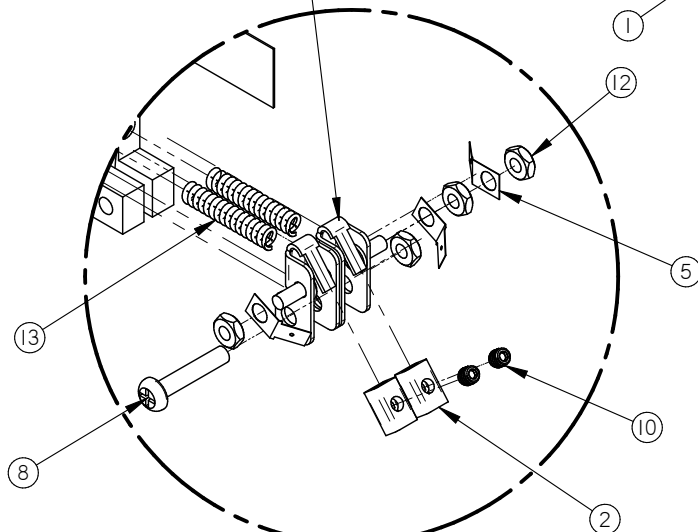
ITEM	PART #	DESCRIPTION	QT.
1	002A4171	SEAL BAR	1
2	002A4172	BANDING BUCKLE	4
3	005A1443	ELEMENT BINDER RIGHT	2
4	005A1444	ELEMENT BINDER LEFT	2
5	027-0400	CONNECTOR ADAPTOR	6
6	039-02115	ROUND CUT-OFF ELEMENT 0.9MM	1
7	039-0222	TAPERED BAND 3MM X 0.3MM	1
8	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	1
9	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	1
10	051-01752	SET SCREW 10-32 SS 3/16"	2
11	051-01752	SET SCREW 10-32 SS 3/16"	2
12	051-0550	NUT #8-32 SS	8
13	077-0014	SPRING C0240-040-1250 SS COMP.	4
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 854.5mm (0.026)	2
15	176-0200	TEFLON TAPE, 5MIL	1
16	176-0203	TEFLON TAPE UNCOATED 5MIL (0.78)	1



PERMETTRE DE BOUGER LIBREMENT (3) ALLOW TO MOVE FREELY

OVER THE ELEMENT (16) INSTALLÉ SUR L'ÉLÉMENT

UNDER THE ELEMENT (15) INSTALLÉ SOUS L'ÉLÉMENT



DETAIL A

A
-BAG CUT (ECO) -

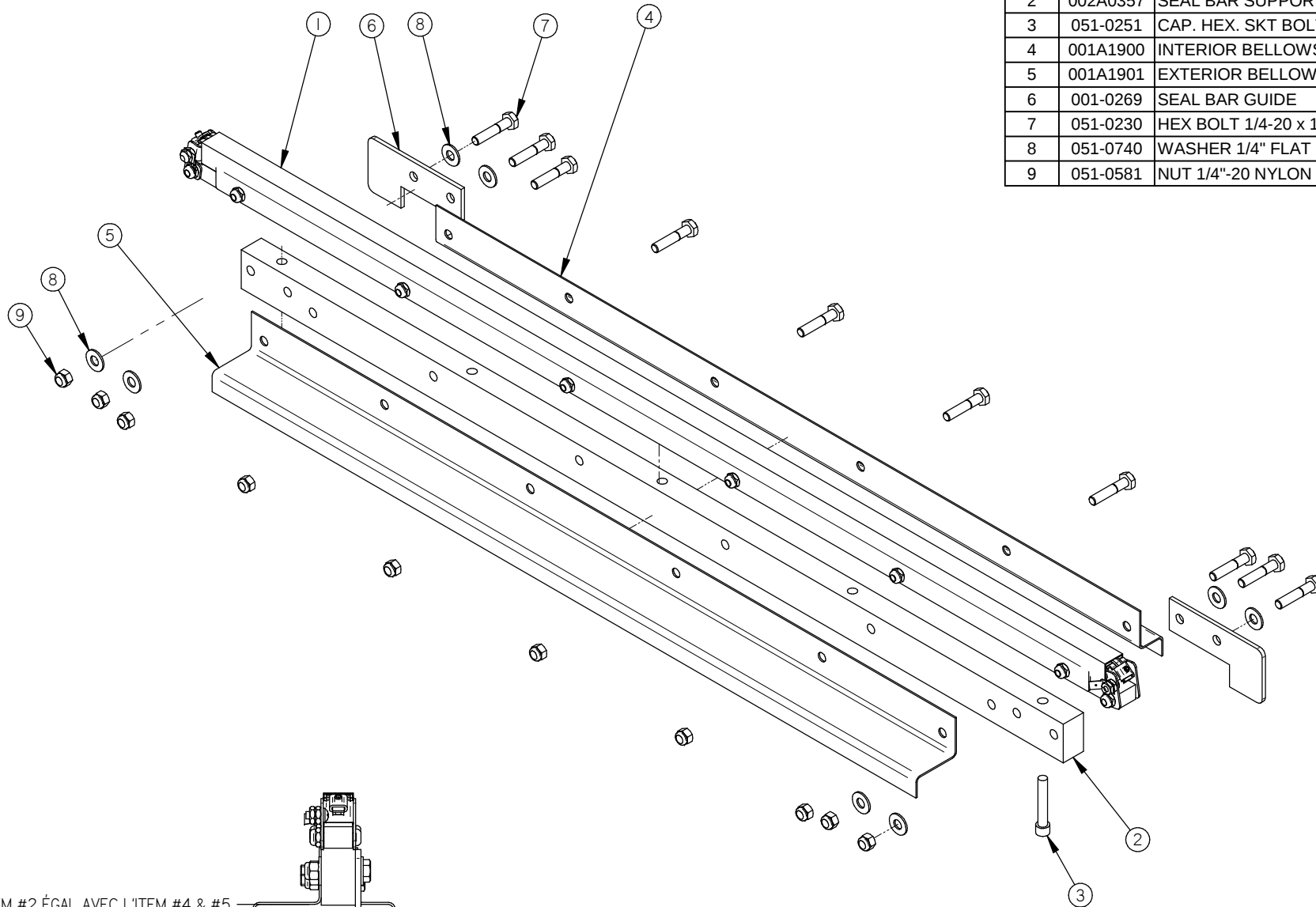
700A	4
680A	4
650A	4
MACHINE	QTY

MACHINE 650A , 680A & 700A		DEPT. TOL. METRIC INCH USINAGE ± 0.1 ± 0.004" TOLERIE ± 0.5 ± 0.020" SOUDAGE ± 0.5 ± 0.020"	STIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART SEAL BAR PRE-ASS'Y		N.T.S.		
ITEM	CNC	DEPT.	M-(M)-I	QTY LISTE
MAT.	DWG BY S.L.	DATE 14-02-12	NO. 004D0255	
	APP. BY	DATE		

LET.	MODIFICATION	DATE	INT.
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005D0549

ITEM	PART #	DESCRIPTION	QT.
1	004B0256	SEAL BAR PRE-ASS'Y	1
2	002A0357	SEAL BAR SUPPORT	1
3	051-0251	CAP. HEX. SKT BOLT 1/4"-20 NC. x 1 1/2"	5
4	001A1900	INTERIOR BELLOWS COVER	1
5	001A1901	EXTERIOR BELLOWS COVER	1
6	001-0269	SEAL BAR GUIDE	2
7	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	10
8	051-0740	WASHER 1/4" FLAT S/S	8
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	10



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

-END VIEW-

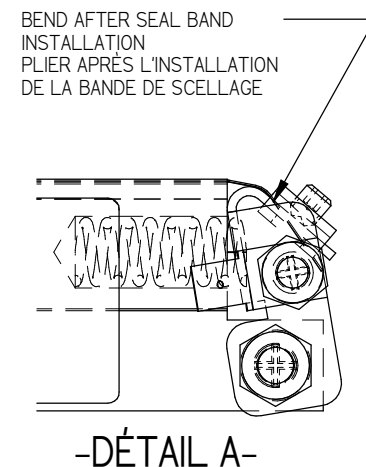
-TOP & BOTTOM SEALING OPTION-

700A	4
680A	4
650A	4
MACHINE	QTY

MACHINE 650A, 680A & 700A		DEPT. TOL. METRIC	INCH	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART SEAL BAR ASS'Y W/SUPPORT		USINAGE ± 0.1 TOLERIE ± 0.5 SOUDAGE ± 0.5	± 0.004" ± 0.020" ± 0.020"	
ITEM		N.T.S.		
MAT.	CNC	DEPT.	M-I-(M)	QTY
DWG BY SBU		DATE 13-08-12	NO. 005D0549	
APP. BY		DATE		

I	004B0256 WAS 004A0256	13-08-12	SBU
LET.	MODIFICATION	DATE	INT.

ITEM	PART #	DESCRIPTION	QT.
1	002A4129	SEAL BAR	1
2	001-2666	ELEMENT BINDER	2
3	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	8
4	051-0572	NUT #10-24 NYLON LOCK S/S	8
5	051-0100	SCREW 8-32 X 3/8" PAN PHIL S/S	2
6	051-0550	NUT #8-32 SS	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm (0.9)	1
9	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" (0.104)	1
10	039-0220	BI-ACTIVE SEALING ELEMENT (0.09)	1
11	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
12	176-0203	TEFLON TAPE, 5MIL UNCOATED ZONE 854.5mm (0.085)	1
13	077-0095	SPRING C 0360-059-1250 S/S	2
14	001-0266	TEFLON HOLD DOWN PLATE	2



-TOP & BOTTOM
SEALING OPTION-

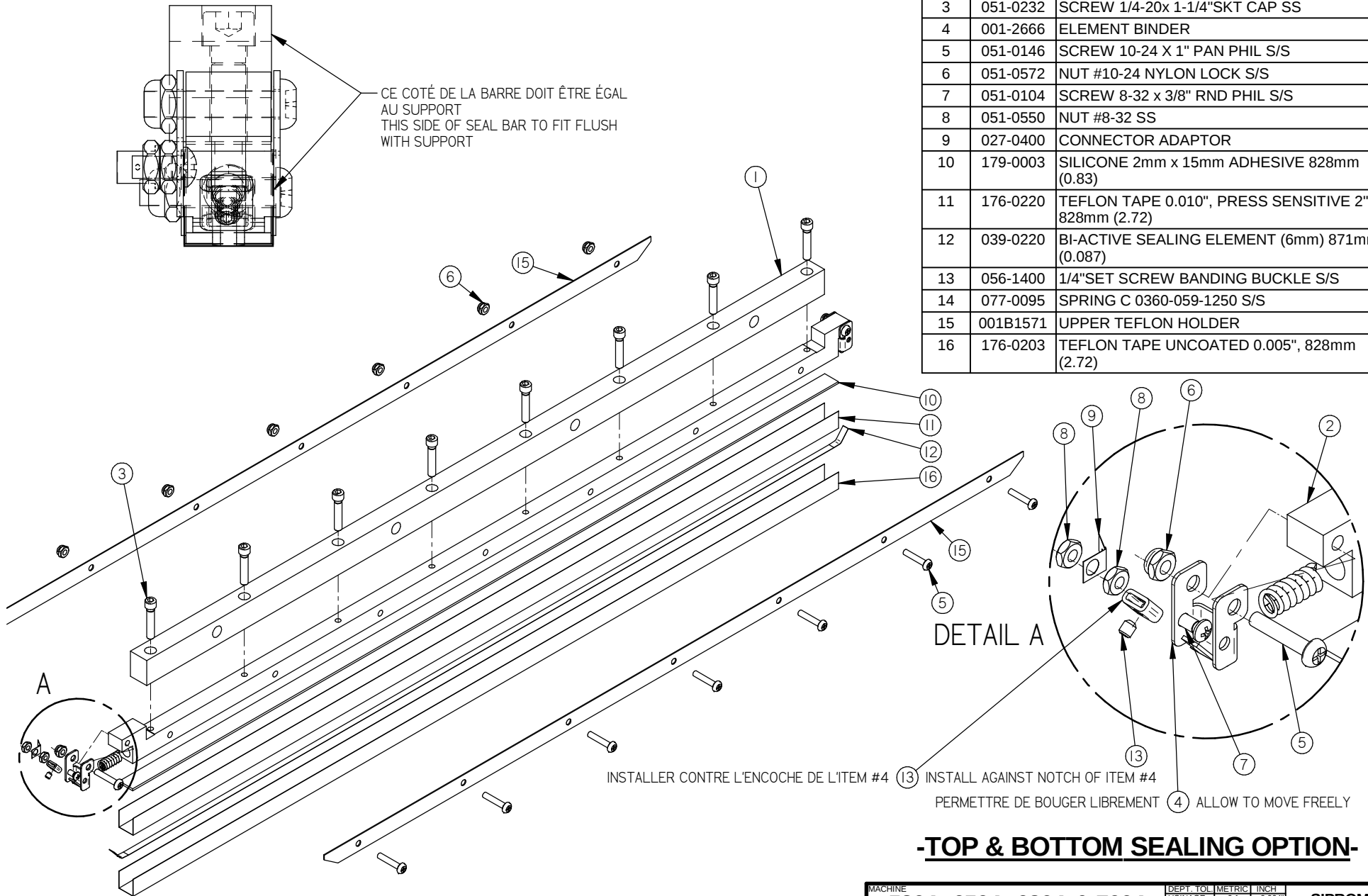
700A	4
680A	4
650A	4
580A	2
MACHINE	QTY

MACHINE 580A, 650A, 680A & 700A		DEPT. TOL. METRIC USINAGE ± 0.1 $\pm 0.004"$ TOLERIE ± 0.5 $\pm 0.020"$ SOUDEAGE ± 0.5 $\pm 0.020"$		INCH. SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART SEAL BAR PRE-ASS'Y				N.T.S.	
ITEM _____		CNC _____		DEPT. M-(M)-I QTY LISTE	
MAT. _____		DWG BY SBU APP. BY _____		DATE 13-08-12 DATE _____	
				NO. 004B0256	

G	AJOUT PINCE TEFLON, CHANGE TEFLON	13-08-12	SBU
LET.	MODIFICATION	DATE	INT.

005C0437

ITEM	PART #	DESCRIPTION	QT.
1	002B0378	UPPER SEAL BAR SUPPORT	1
2	002C0396	UPPER SEAL BAR	1
3	051-0232	SCREW 1/4-20x 1-1/4"SKT CAP SS	8
4	001-2666	ELEMENT BINDER	2
5	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	9
6	051-0572	NUT #10-24 NYLON LOCK S/S	9
7	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
8	051-0550	NUT #8-32 SS	4
9	027-0400	CONNECTOR ADAPTOR	2
10	179-0003	SILICONE 2mm x 15mm ADHESIVE 828mm (0.83)	1
11	176-0220	TEFLON TAPE 0.010", PRESS SENSITIVE 2" 828mm (2.72)	1
12	039-0220	BI-ACTIVE SEALING ELEMENT (6mm) 871mm (0.087)	1
13	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
14	077-0095	SPRING C 0360-059-1250 S/S	2
15	001B1571	UPPER TEFLON HOLDER	2
16	176-0203	TEFLON TAPE UNCOATED 0.005", 828mm (2.72)	1



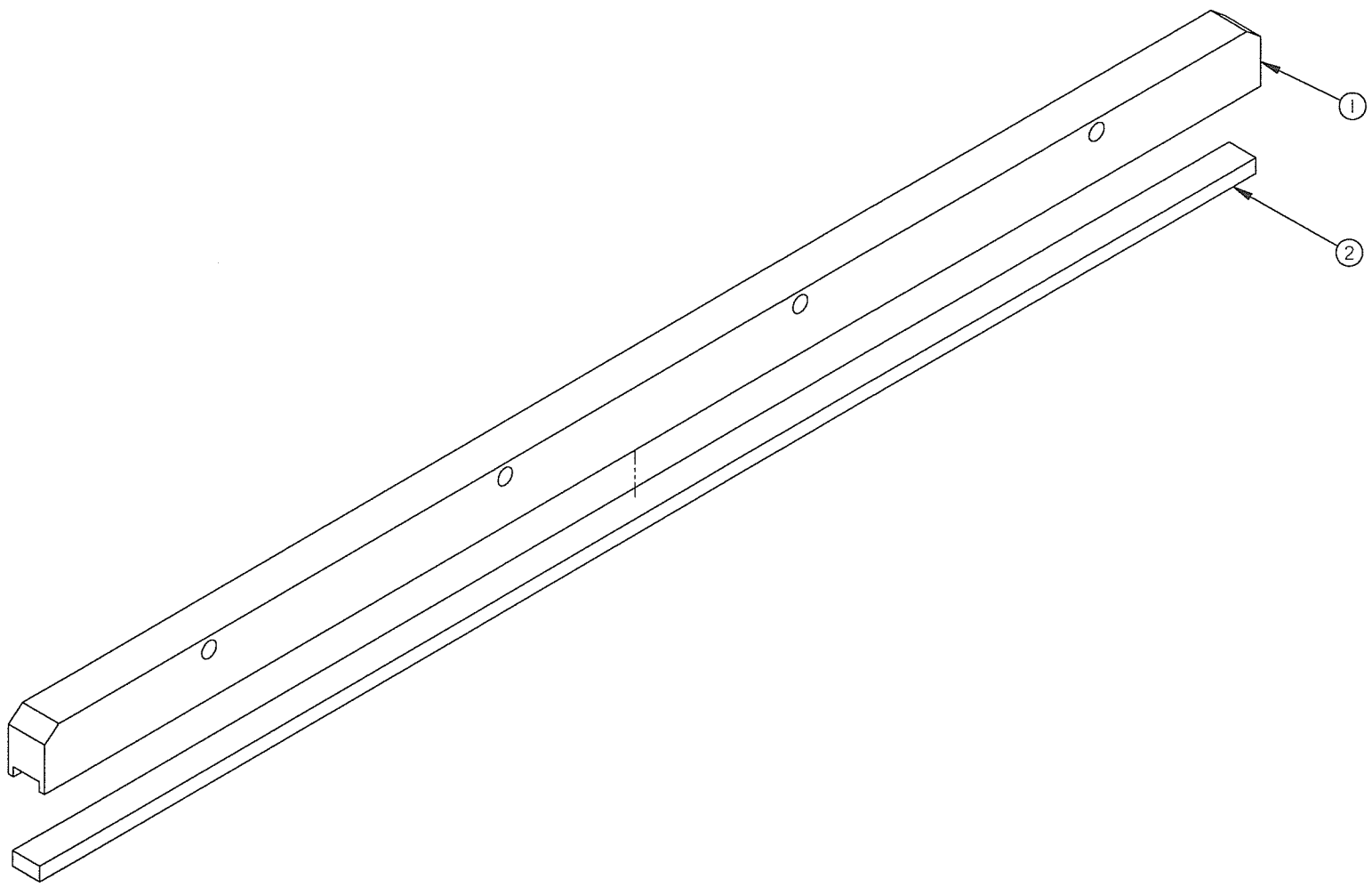
-TOP & BOTTOM SEALING OPTION-

K	AJOUT PINCE TEFLON, CHANGE TEFLON	13-08-12	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE 580A, 650A, 680A & 700A		DEPT. TOL. METRIC	INCH	SIPROMAC	
PART UPPER SEAL BAR ASS'Y W/SUPPORT		USINAGE ± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
		TOLERIE ± 0.5	± 0.020"		
		SOUDAGE ± 0.5	± 0.020"		
ITEM	CNC	DEPT.	M-T.S.	M-(M)-I	QTY. 2
MAT.	DWG BY SBU	DATE 13-08-12	NO.	005C0437	
	APP. BY	DATE			

004B0207

ITEM	PART #	DESCRIPTION	QT.
1	002B0364	UPPER SEAL BAR SUPPORT	1
2	008-0374	UPPER SEAL BAR RUBBER	1

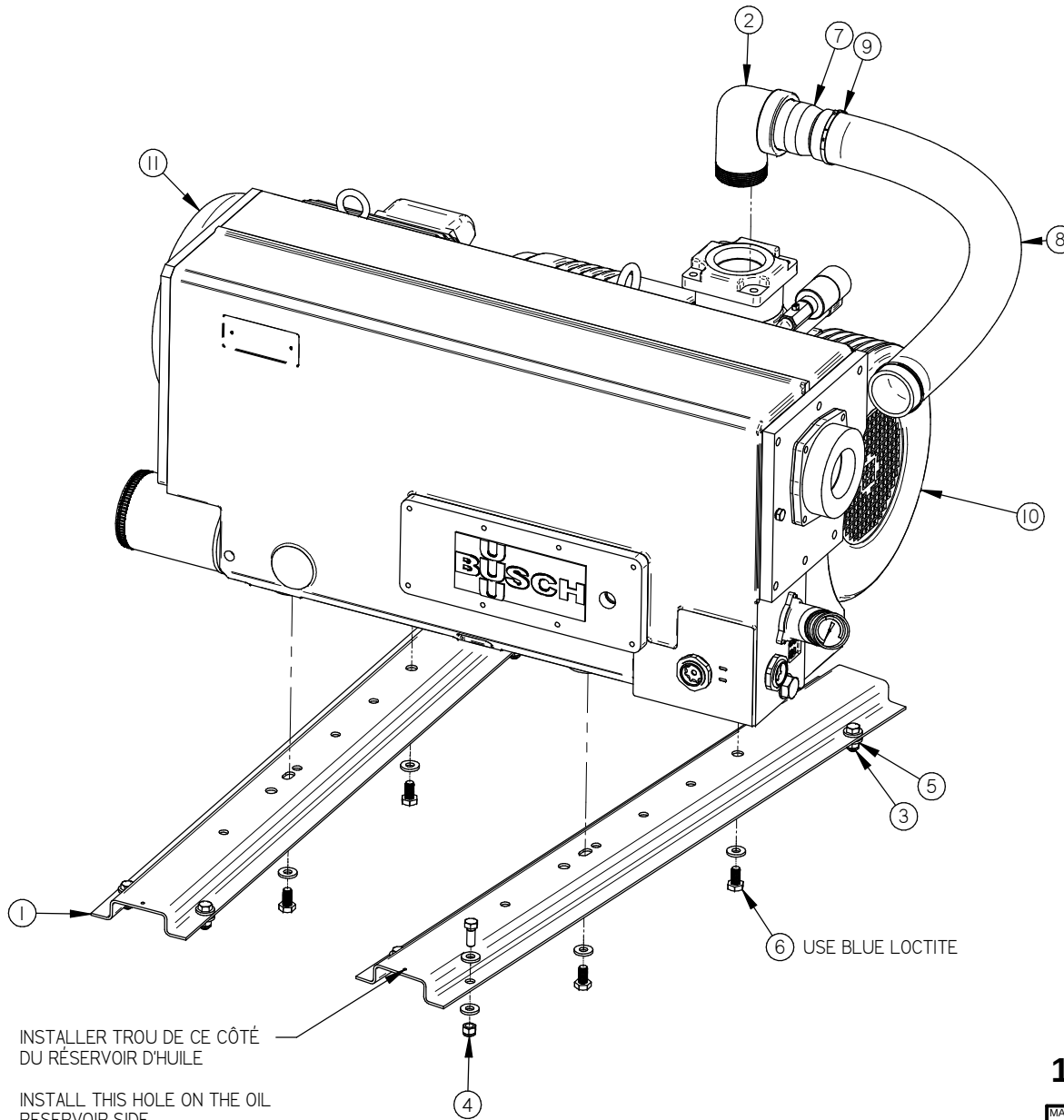


K	REDESSINE VOIR AUSSI 004A2555, 004A2556 & 004A2561	08-04-30	J.G.
LET.	MODIFICATION	DATE	INT.

MACHINE 580A, 650A, 680A & 700A		DEPT. TOL. METRIC	INCH	SIPROMAC	
PART UPPER SEAL BAR ASSEMBLY		USINAGE ± 0.1 ± 0.004"	TOLERIE ± 0.5 ± 0.020"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
		SOUDAGE ± 0.5 ± 0.020"		N.T.S.	
ITEM	CNC	DEPT.	M-I	QTY.	2
MAT.	DWG BY J.G.	DATE 08-04-30	NO.	004B0207	
	APP. BY	DATE 28-05-07			

005A1535

ITEM	PART #	DESCRIPTION	QT.
1	001B6563	PUMP SUPPORT	2
2	004A4240	BELLOWS ELBOW CONNECTOR ASSY	1
3	051-0360	BOLT 3/8"-16nc. X 1" S/S	8
4	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	8
5	051-0783	WASHER 3/8" FLAT THICK S/S	20
6	051-09931	BOLT M10 X 20MM HEX SS	4
7	100-1250	STRAIGHT 2"MNPT X 2" HOSE BARB SS	1
8	104-0151	HOSE 2"ID VACUUM TIGERFLEX 560MM	1
9	105-0258	EAR CLAMP 2" S/S	2
10	125-0070	BUSCH RA-0165 230-460V/3PH/60HZ	1
11	125-0075	BUSCH RA-0165 575V/3PH/60HZ	1

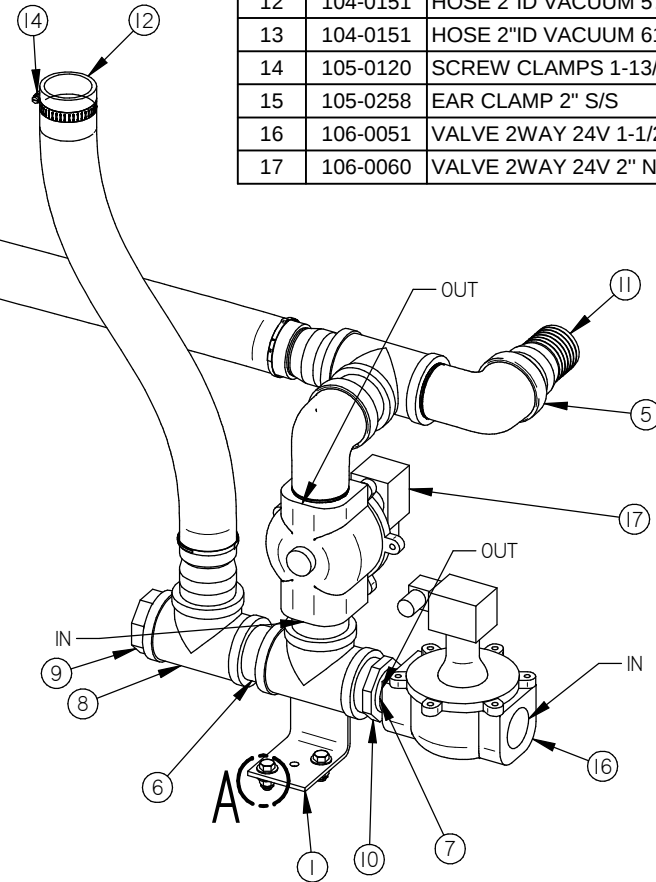
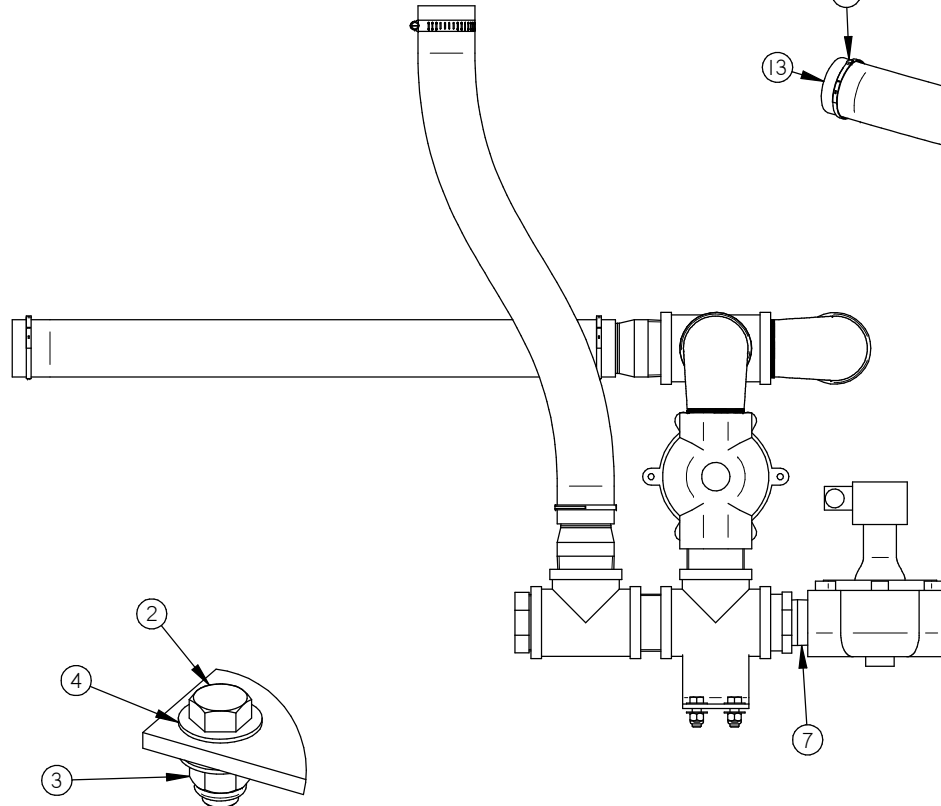
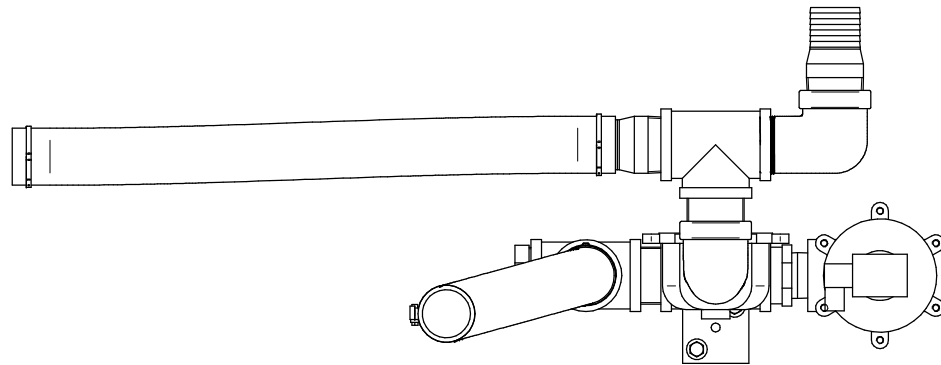


165M³ BUSCH PUMP

MACHINE		650A		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		PUMP "BUSCH" 165M³		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		3D DWG BY SBU		SOUDEGE	± 0.5	± 0.020"	N.T.S.	
		DATE 14-10-08		DEPT.		M-I		QTY. 1
		DATE 14-10-08				NO. 005A1535		

LET.	MODIFICATION	DATE	INT.
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005A1522



ITEM	PART #	DESCRIPTION	QT.
1	004-0183	VAC./ATM. VALVE SUPP. PRE-ASS'Y	1
2	051-0360	BOLT 3/8"-16nc. X 1" S/S	2
3	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	2
4	051-0780	WASHER 3/8" FLAT S/S	4
5	100-0095	STREET ELBOW 90° X 2" NPT SS	2
6	100-0250	CLOSE NIPPLE 2" NPT SS	3
7	100-0250	CLOSE NIPPLE 1-1/2"NPT S/S	1
8	100-0487	TEE 2"npt. S/S	2
9	100-0558	RED. BUSHING 2"mnpt. X 1"fnpt S/S	1
10	100-0561	RED.BUSH. 2"NPTx1-1/2"NPT SS	1
11	100-1250	STRAIGHT 2"MNPT X 2" HOSE BARB SS	3
12	104-0151	HOSE 2"ID VACUUM 572MM	1
13	104-0151	HOSE 2"ID VACUUM 610MM	1
14	105-0120	SCREW CLAMPS 1-13/16" TO 2-3/4" ALL S/S	1
15	105-0258	EAR CLAMP 2" S/S	3
16	106-0051	VALVE 2WAY 24V 1-1/2"NPT60Hz	1
17	106-0060	VALVE 2WAY 24V 2" NPT(B80) 60HZ	1

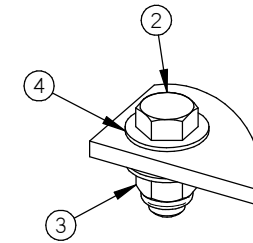
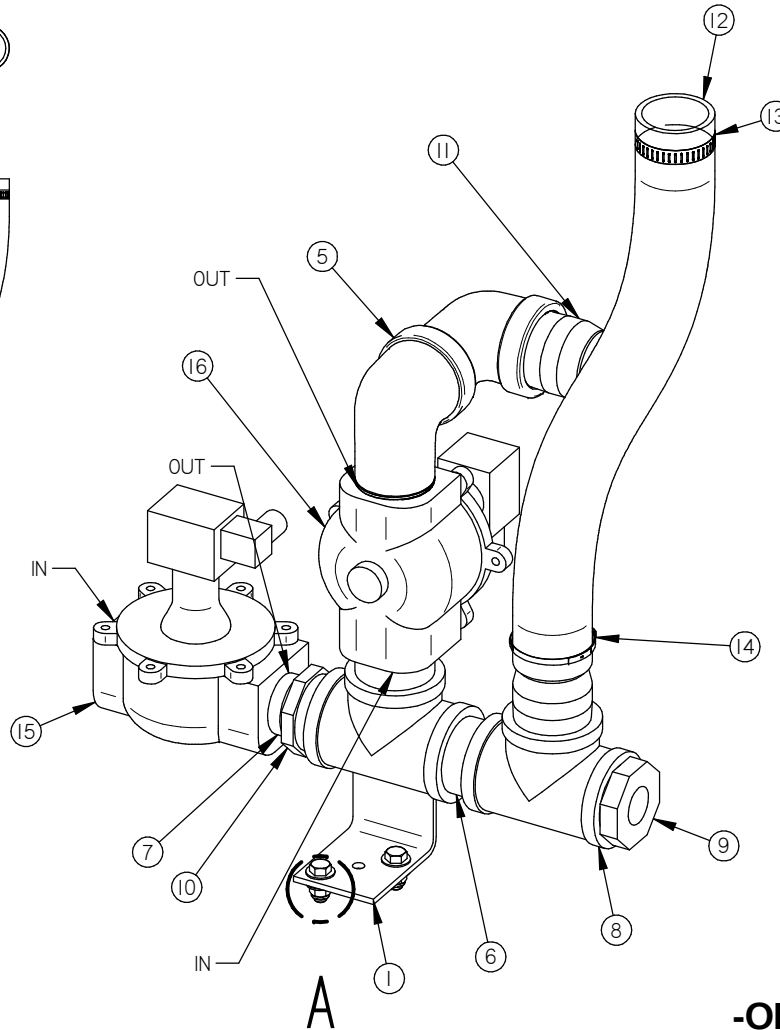
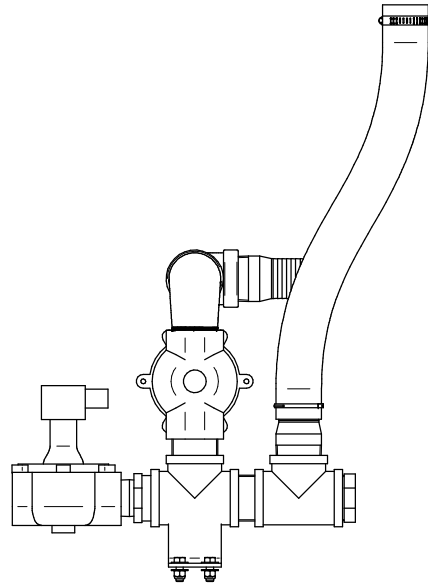
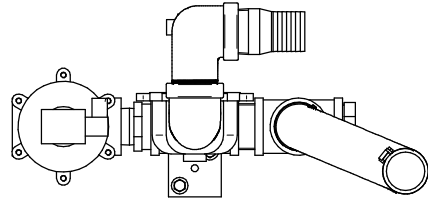
DETAIL A

-OPTION - 165M³, 255M³ & 305M³ PUMP

MACHINE		VACUUM		DEPT. TOL.		METRIC		INCH		SIPROMAC	
PART		VACUUM/ATMOSPHERE VALVE ASSY		USINAGE		± 0.1		± 0.004"		ST-GERMAIN DE GRANTHAM	
				TOLERIE		± 0.5		± 0.020"		QUEBEC CANADA	
				SOUDEGE		± 0.5		± 0.020"		N.T.S.	
ITEM		CNC		DEPT.		M		QTY.		1	
MAT.		DWG BY SBU		DATE 13-09-18		NO.		005A1522			
		APP. BY		DATE							

LET.	MODIFICATION	DATE	INT.
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005A1521



DETAIL A

ITEM	PART #	DESCRIPTION	QT.
1	004-0183	VAC./ATM. VALVE SUPP. PRE-ASS'Y	1
2	051-0360	BOLT 3/8"-16nc. X 1" S/S	2
3	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	2
4	051-0780	WASHER 3/8" FLAT S/S	4
5	100-0095	STREET ELBOW 90° X 2" NPT SS	2
6	100-0250	CLOSE NIPPLE 2" NPT SS	2
7	100-0250	CLOSE NIPPLE 1-1/2"NPT S/S	1
8	100-0487	TEE 2"npt. S/S	1
9	100-0558	RED. BUSHING 2"mnpt. X 1"fnpt S/S	1
10	100-0561	RED.BUSH. 2"NPTx1-1/2"NPT SS	1
11	100-1250	STRAIGHT 2"MNPT X 2" HOSE BARB SS	2
12	104-0151	HOSE 2"ID VACUUM 572MM	1
13	105-0120	SCREW CLAMPS 1-13/16" TO 2-3/4" ALL S/S	1
14	105-0258	EAR CLAMP 2" S/S	1
15	106-0051	VALVE 2WAY 24V 1-1/2"NPT60Hz	1
16	106-0060	VALVE 2WAY 24V 2" NPT(B80) 60HZ	1

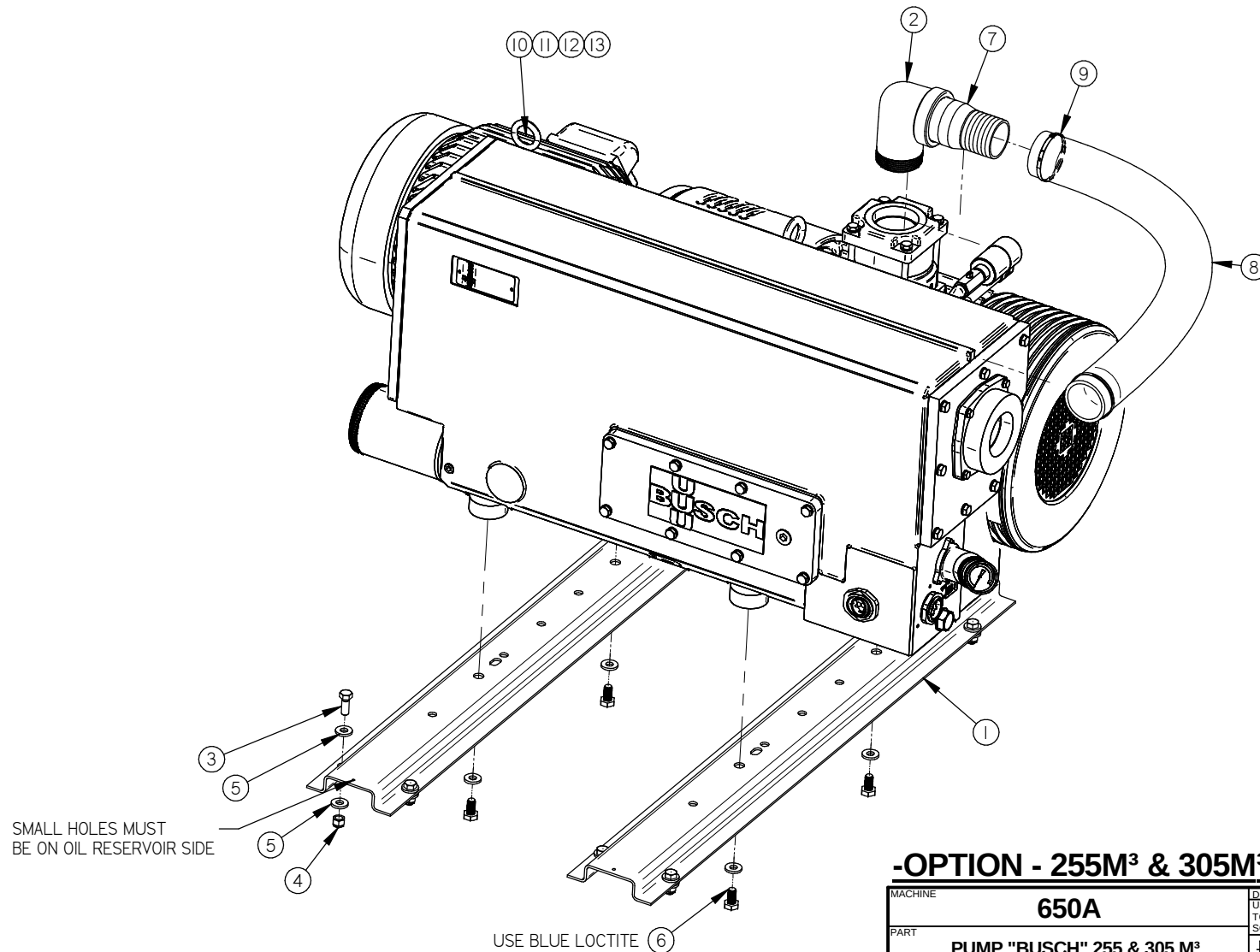
-OPTION - 165M³, 255M³ & 305M³ PUMP

MACHINE		VACUUM		DEPT. TOL	METRIC	INCH	SIPROMAC	
PART		VACUUM/ATMOSPHERE VALVE ASSY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"		
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"		
		DWG BY SBU		DATE 13-09-18		NO. 005A1521		

LET.	MODIFICATION	DATE	INT.
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005A1520

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
8	104-0151	HOSE 2"ID VACUUM TIGERFLEX 560MM	1	1	001B6563	PUMP SUPPORT	2
9	105-0258	EAR CLAMP 2" S/S	2	2	004A4240	BELLOWS ELBOW CONNECTOR ASSY	1
10	125-0080	BUSCH RA-0255 230-460V/3PH/60HZ	1	3	051-0360	BOLT 3/8"-16nc. X 1" S/S	8
11	125-0085	BUSCH RA-0255 575V/3PH/60HZ	1	4	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	8
12	125-0087	BUSCH RA-0305 230-460V/3PH/60HZ	1	5	051-0783	WASHER 3/8" FLAT THICK S/S	20
13	125-0088	BUSCH RA-0305 575V/3PH/60HZ	1	6	051-09931	BOLT M10 X 20MM HEX SS	4
				7	100-1250	STRAIGHT 2"MNPT X 2" HOSE BARB SS	1



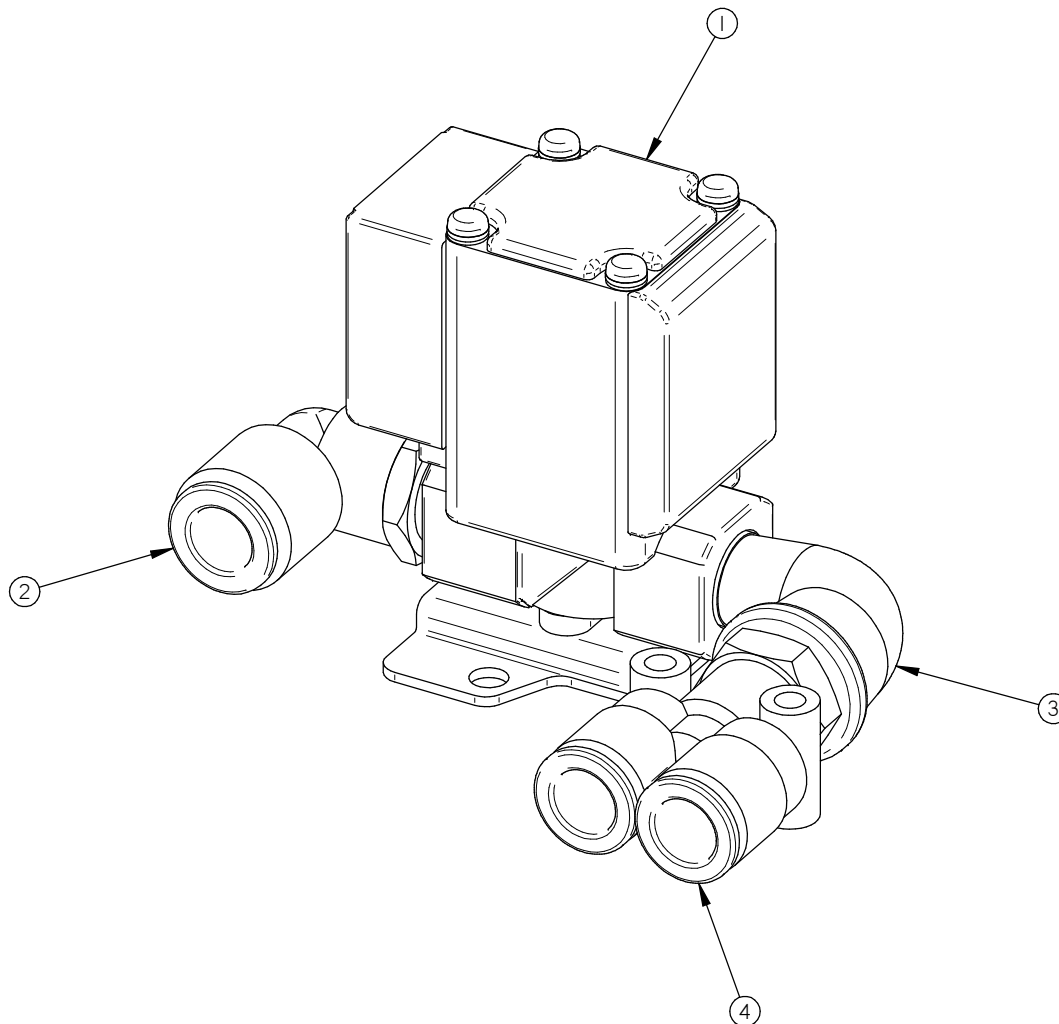
-OPTION - 255M³ & 305M³ PUMP

MACHINE		650A		DEPT. TOL.		METRIC		INCH		SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART		PUMP "BUSCH" 255 & 305 M³		USINAGE		± 0.1		± 0.004"			
				TOLERIE		± 0.5		± 0.020"			
				SOUDAGE		± 0.5		± 0.020"			
						N.T.S.					
ITEM		CNC		DEPT.		M-I		QTY.		1	
MAT.		DWG BY SBU		DATE 14-07-16		NO.		005A1520			
		APP. BY		DATE							

A	001B6563 WAS 001A6563	14-05-28	SBU
LET.	MODIFICATION	DATE	INT.

004B4113

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	VALVE 2WAY N.C. 24VAC 1/4" NPT(SMC)	1
2	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	1
3	100-0065	STREET ELBOW 1/4" NPT SS	1
4	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	1



-OPTION - GAS

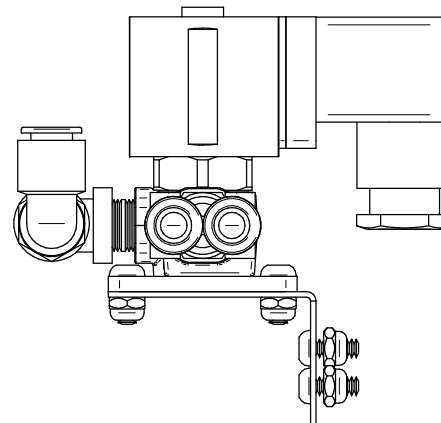
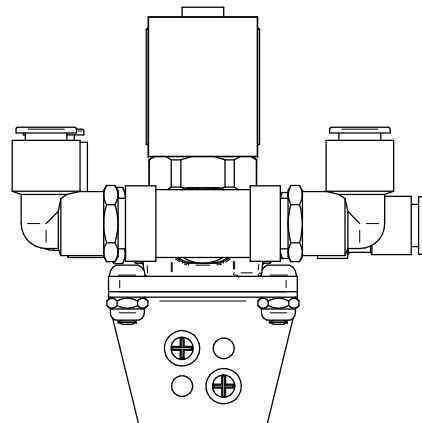
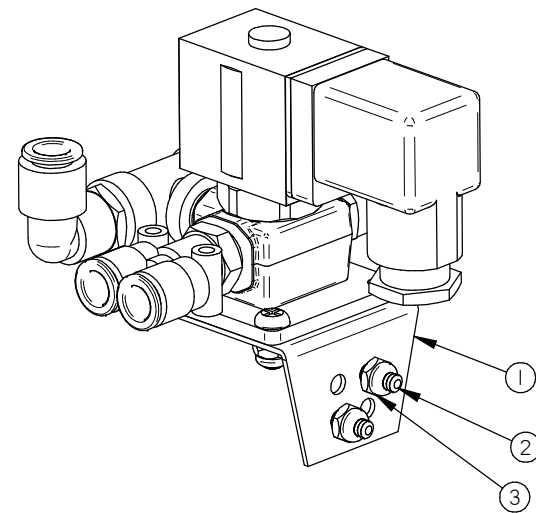
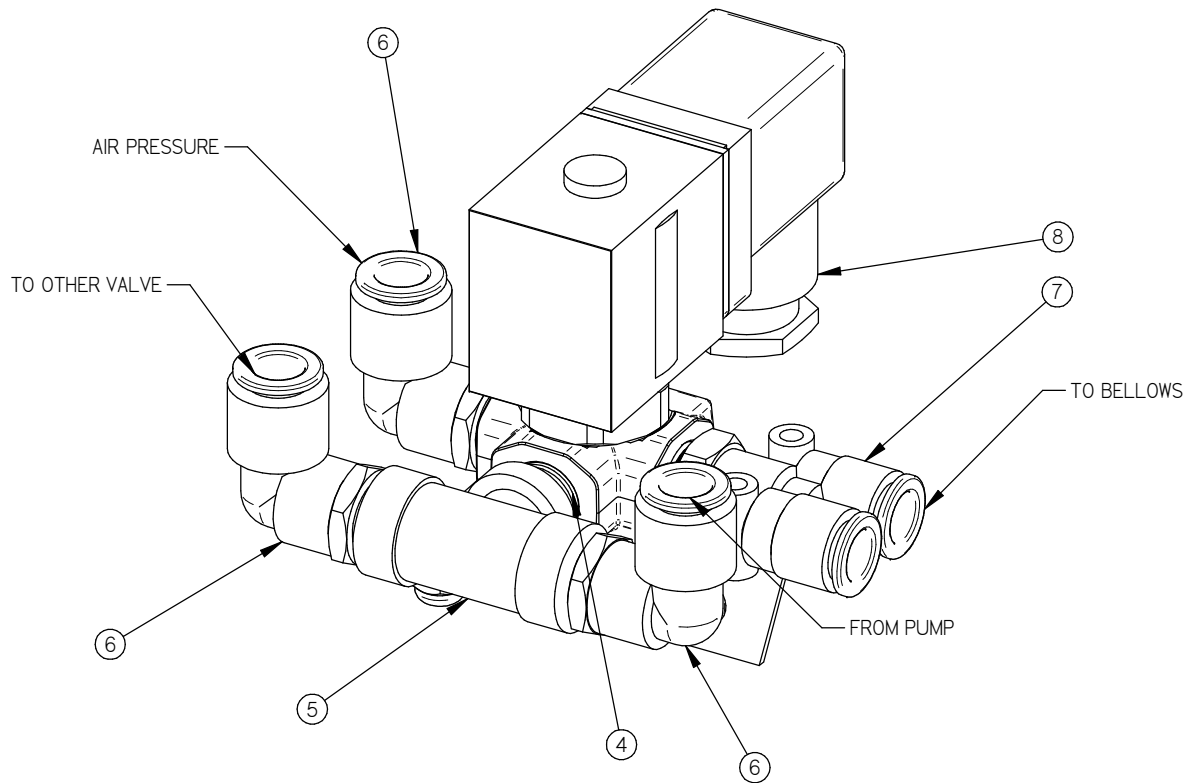
DOUBLE CHAMBER	2
SINGLE CHAMBER	1
MACHINE	QTY

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		GAS VALVE ASSEMBLY (OPTION)		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
				TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
				SOUDAGE	± 0.5	± 0.020"	N.T.S.	
ITEM	CNC			DEPT.	M	QTY	LISTE	
MAT.	DWG BY	SBU	DATE	14-05-27	NO.	004B4113		
	APP. BY		DATE					

A	VALVE UPDATE	14-05-27	SBU
LET.	MODIFICATION	DATE	INT.

004B4105

ITEM	PART #	DESCRIPTION	QT.
1	001B6779	VALVE SUPPORT BRACKET	1
2	051-0144	SCREW #10-24 N.C 1/2"PAN PHIL. S/S	4
3	051-0572	NUT #10-24 NYLON LOCK S/S	4
4	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
5	100-0463	TEE 1/4" NPT S/S	1
6	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	3
7	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	1
8	106-00701	VALVE 3WAY 24V 1/4"NPT	1



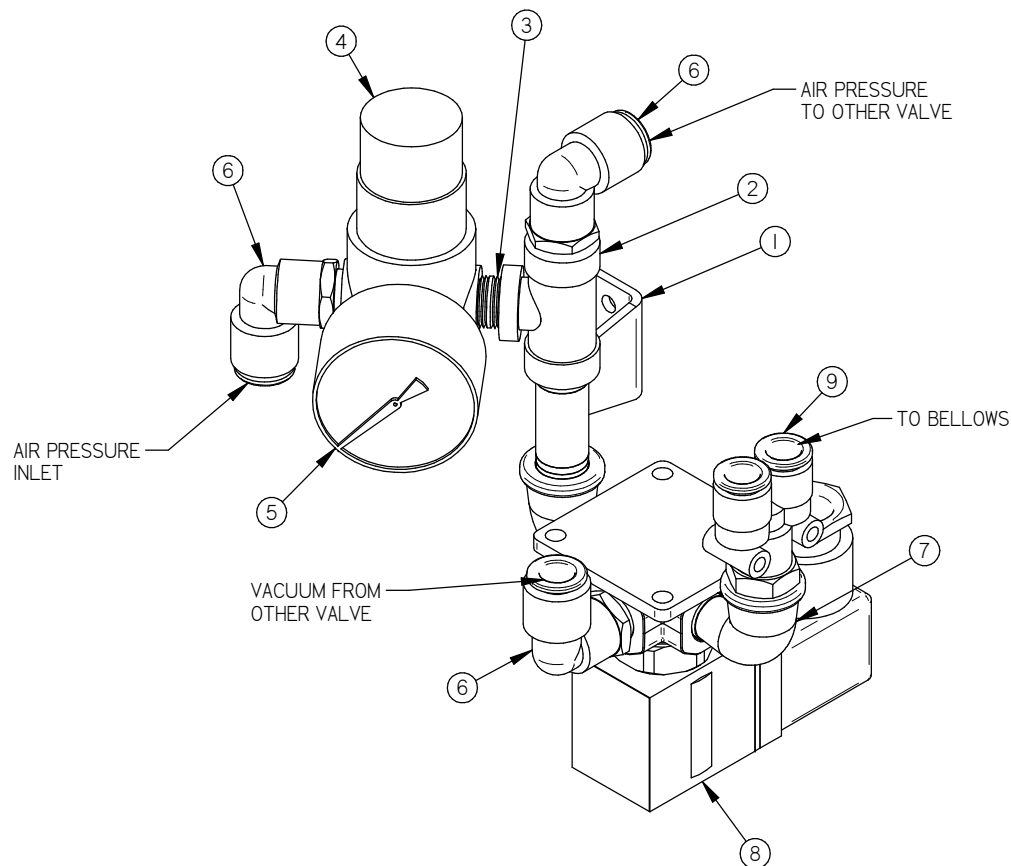
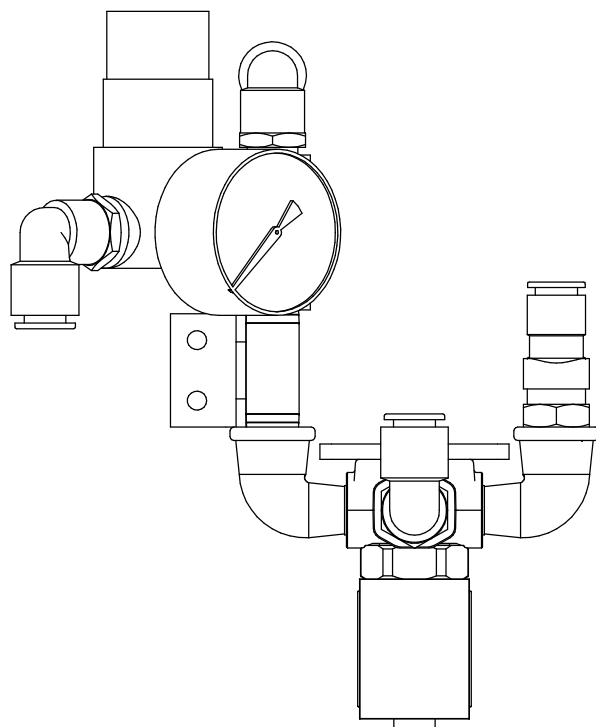
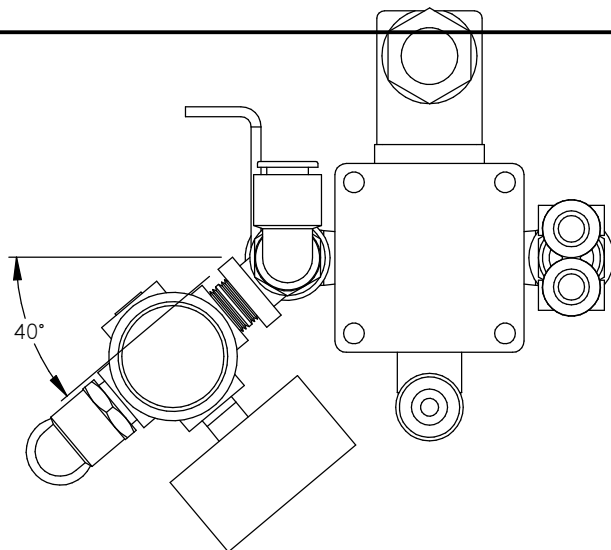
-OPTION - AIR REGULATOR

A	UPDATE VALVE	14-05-27	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	SIPROMAC	
PART		BELLOWS VALVE ASSY (OPT AIR REG)		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		DWG BY SBU		SOUDEGE	± 0.5	± 0.020"	N.T.S.	
		APP. BY		DATE	14-05-27	NO.	004B4105	
				DATE		QTY.	1	

004B4103

ITEM	PART #	DESCRIPTION	QT.
1	004A4140	AIR REGULATOR SUPPORT	1
7	100-0065	STREET ELBOW 1/4" NPT SS	2
3	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
2	100-0463	TEE 1/4" NPT S/S	1
6	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	3
9	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	1
8	106-00701	VALVE 3WAY 24V 1/4"NPT	1
4	114-0147	PRESSURE REGUL. 0-60 PSI 1/4" NPT	1
5	114-0245	PRESSURE GAUGE 60 PSI 1/8" NPT	1



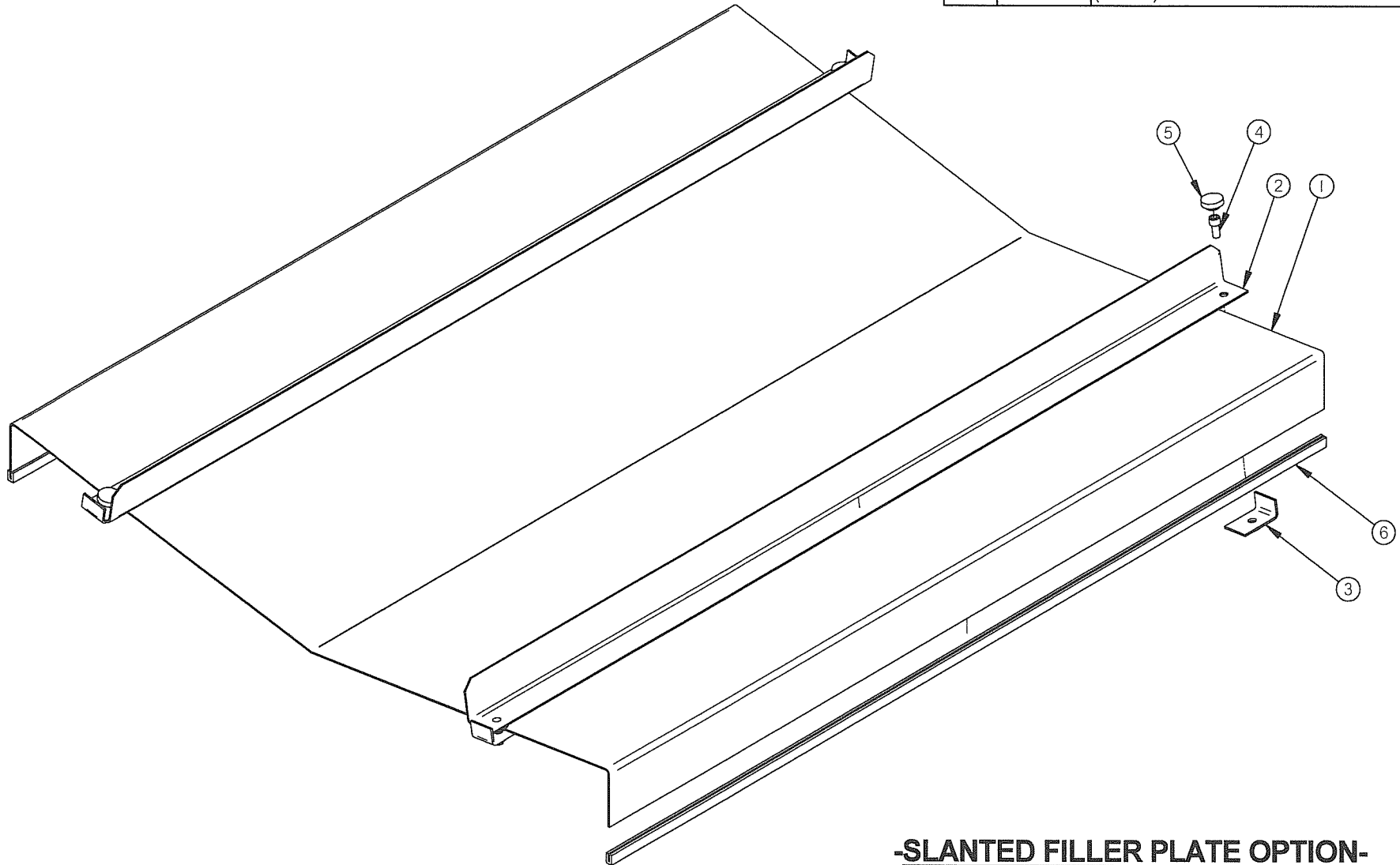
-OPTION - AIR REGULATOR

MACHINE		600A & 620A		DEPT. TOL	METRIC	INCH	SIPROMAC	
PART		AIR REGULATOR VALVE ASSY		USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
MAT.		DWG BY SBU		SOUDEGE	± 0.5	± 0.020"	N.T.S.	
DATE 14-05-27		APP. BY		DATE		DEPT. M		QTY. 1
								004B4103

A	VALVE UPDATED	14-05-27	SBU
LET.	MODIFICATION	DATE	INT.

| 005A0868

ITEM	PART #	DESCRIPTION	QT.
1	001A5413	SLANTED FILLER PLATE	1
2	001A4581	ADJUSTABLE STOPPER	2
3	005-0187	ASS. BARRURE	4
4	051-01845	BOLT 1/4"-20 x 1/2"CAP HEX SKT.S/S	4
5	057-0004	THMB SCREW KNOB 1/4"	4
6	179-0014	RUBBER 1/4"x3/8"x1/16"U SHAPED 860mm (2.8215')	2



-SLANTED FILLER PLATE OPTION-

MACHINE		650A		DEPT. TOL. METRIC INCH		SIPROMAC	
PART		SLANTED FILLER PLATE ASS'Y		USINAGE ± 0.1 ± 0.004"		ST-GERMAIN DE GRANTHAM	
ITEM		CNC		TOLERIE ± 0.5 ± 0.020"		QUEBEC CANADA	
MAT.		APP. BY J.G.		SOUDAGE ± 0.5 ± 0.020"		NO. 005A0868	
DATE 10-05-12		DATE 10-06-12		DEPT. M-I		QTY. 2	

LET.	MODIFICATION	DATE	INT.
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