

User manual



L'Art de la Pulvérisation

Air dryers



Air dryers

1. GENERAL INFORMATION

- 1.1. Functional description
- 1.2. Safe use of the dryer

2. TECHNICAL DESCRIPTION

- 2.1. Operation
- 2.2. Refrigeration circuit
 - 2.2.1. Diagram
 - 2.2.2. Refrigeration compressor (1M1)
 - 2.2.3. Condenser (CND)
 - 2.2.4. Filter dryer (FF)
 - 2.2.5. Capillary tube (CT)
 - 2.2.6. Aluminium heat exchanger
 - 2.2.7. Safety thermostat (TS)
- 2.3. Air circuit

3. INSTALLATION

- 3.1. Acceptance and transport
- 3.2. Installation location
- 3.3. Installation layout
- 3.4. Connection to the network
- 3.5. Condensate drainage

4. START-UP

- 4.1. Before starting
- 4.2. Start-up

5. OPERATION

- 5.1. Control panel
- 5.2. Standard operation
- 5.3. Programming
- 5.4. Alarms
- 5.5. Alarm History

6. MAINTENANCE, TROUBLESHOOTING, SPARE PARTS AND DISPOSAL

- 6.1. Inspection and maintenance
 - 6.1.1. Cleaning the drain solenoid valve
- 6.2. Troubleshooting
- 6.3. End of life

LIST OF APPENDICES

- A. Technical specifications
- B. Legend
- C. Dryer dimensions
- D. Electrical diagrams
- E. Exploded view – Recommended spare parts



General information

1.1. Functional Description

The refrigeration cycle air dryers have been designed to remove condensate from compressed air through cooling; they are compact and energy-efficient. The operating principle of the dryers described in this manual is illustrated by the air and refrigeration circuit diagrams (sections 2.2 and 2.3).

The air supplied to various applications is virtually free of moisture, while the condensate collected in the separator is discharged to the outside through dedicated drain devices. Before leaving the dryer, the treated air is preheated in counterflow relative to the incoming air. This helps reduce the size of the unit and prevents the formation of condensation on the external surface of the line tubing.



The dryer is already equipped with all necessary control, safety, and regulation devices and therefore does not require any auxiliary components.



Overloading the equipment—within the maximum operating limits—may reduce dryer performance (higher dew point) but does not compromise safety.

The electrical circuit (Appendix E) has a minimum protection rating of IP 42; the user is responsible for providing line protection and grounding in accordance with the electrical standards in force in their country.

1.2. Safe use of the dryer

Symbols applied to the dryer and indicated in the manual.

	General warning		Do not touch electrical hazard
	Danger - high voltage, electrical current		Prohibition of maintenance to unqualified personnel
	Danger point		Environmental requirements
	Mandatory consulting the manual		Recyclable materials

From a safety standpoint, this equipment has been designed and manufactured in compliance with current European directives. Therefore, all installation, operation, and maintenance activities must be carried out in accordance with the instructions in this manual.



All operations related to installation, maintenance, and inspection that require access to the dryer must be performed by qualified personnel.



The manufacturer shall not be held liable for any use of the dryer that is different from or not in compliance with the instructions provided in this manual.



Technical description

2.1. Operation

The dryer described in this manual essentially consists of two separate circuits: one for compressed air, divided into two heat exchangers, and the other, a refrigeration circuit.

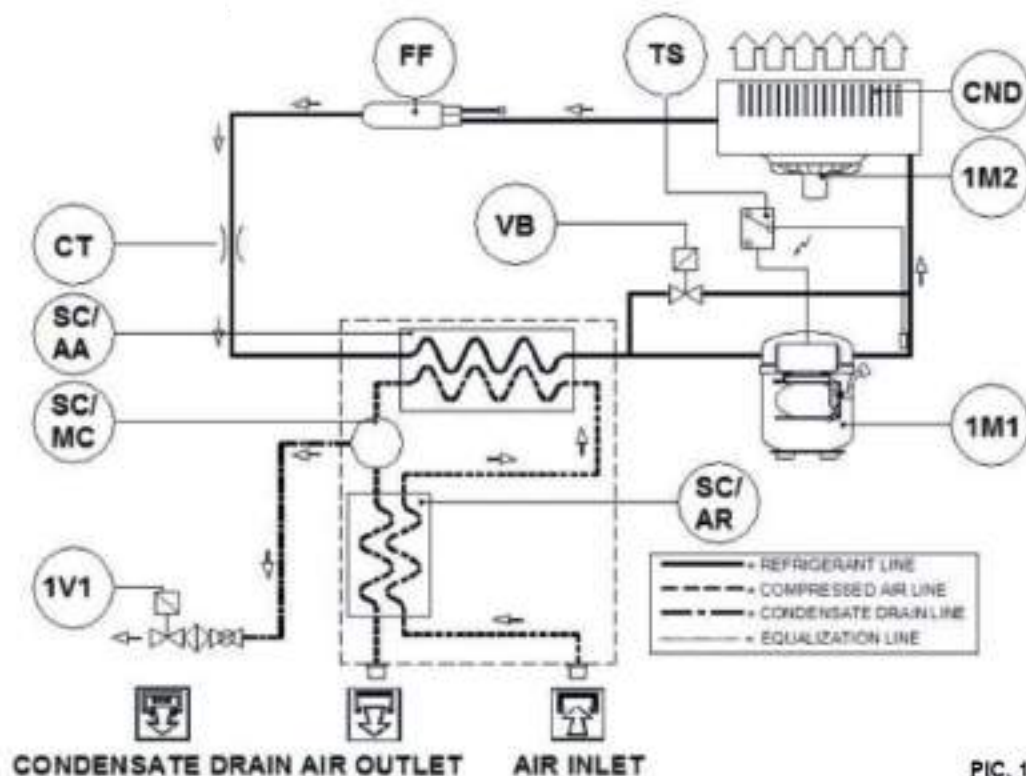
The hot and humid air first passes through an air-to-air heat exchanger before entering the evaporator (air/refrigerant heat exchanger), where it is cooled through contact with the refrigeration circuit, causing the moisture to condense. The condensed moisture is then separated and expelled via a separator.

The cold air then passes back through the air-to-air exchanger, where it is partially reheated by the incoming air, which begins to cool down in this pre-refrigeration stage.

The refrigeration circuit used in this process is primarily composed of a refrigeration compressor, a condenser, and an evaporator, also referred to as the air/refrigerant heat exchanger.

2.2. Refrigeration Circuit

2.2.1. Diagram



PIC. 1



2.2.2 . Refrigeration compressor (1M1)

The refrigeration compressor acts as the system's motor. It compresses the refrigerant gas coming from the evaporator (low-pressure zone) to the condensation pressure level (high-pressure zone). All compressors are manufactured by leading companies and are designed for applications requiring high compression ratios and significant temperature variations. Their hermetically sealed construction ensures perfect gas containment, providing high energy efficiency and a long service life.

Mechanically, the compression unit is supported by dampers that significantly reduce noise emissions and vibration transmission. The electric motor is cooled by the suction refrigerant gas, which passes through the motor windings before reaching the compression cylinders. An internal thermal protection device safeguards the compressor from excessive temperatures and overcurrents. This protection resets automatically once normal temperature conditions are restored.

2.2.3. Condenser (CND)

The condenser is where the gas from the compressor is cooled and condensed into liquid form. Mechanically, it consists of a circuit of copper pipes (for gas transport) embedded in a pack of aluminum fins. Cooling occurs thanks to an axial fan that forces ambient air through the finned pack, using pressure generated inside the dryer.

It is essential that the ambient temperature does not exceed the rated value. It is also very important to **KEEP THE UNIT FREE FROM DUST AND OTHER DEBRIS.**

2.2.4. Filter dryer (FF)

Traces of moisture, residues that may accumulate inside the cooling system, or dense compounds formed after prolonged dryer use can reduce compressor lubrication and clog the capillary tube. The function of the filter dryer, placed upstream of the capillary tube, is to trap impurities and prevent them from circulating within the system.

2.2.5. Capillary tube (CT)

The capillary tube is a narrow copper tube located between the receiver and the evaporator, which restricts the flow of refrigerant. This restriction causes a pressure drop that is proportional to the target temperature in the evaporator: the lower the pressure at the capillary tube outlet, the lower the temperature in the evaporator.

The capillary tube's length and diameter are precisely dimensioned to match the expected evaporator performance; no maintenance or calibration is required.



2.2.6 . Aluminium heat exchanger (SC)

The air/air heat exchanger, the air/refrigerant heat exchanger, and the condensate separator (demister type) are integrated into a single module. The counterflow of compressed air in the air/air heat exchanger ensures maximum heat transfer. The large cross-section of the exchanger channels reduces air velocity and decreases the energy required for flow. The generous dimensions of the air/refrigerant heat exchanger, combined with the counterflow of the refrigerant gas, ensure complete evaporation of the refrigerant (preventing liquid return to the compressor).

The high-efficiency condensate separator is positioned between the heat exchangers. It requires no maintenance, and the coalescing effect guarantees a high level of moisture separation.

2.2.7. Safety thermostat (TS)

This system also acts as a protective measure for the compressor. When the dryer is operating with the correct amount of refrigerant, the discharge temperature remains stable. If not, the discharge temperature rises above the standard threshold, and the safety thermostat shuts off power to the compressor. Discharge temperature also increases if the condenser is dirty or the fan fails.

2.3. Air circuit

The function of the dryer is to dehumidify compressed air. Any use of the machine outside the conditions described in Appendix A must be approved by the manufacturer.

Installation

3.1. Acceptance and transport

Upon delivery, the customer must inspect the dryer entirely and ensure that all items listed in the shipping documents are present.



Any claim regarding missing or damaged items must be submitted directly to our headquarters or the nearest distributor within eight (8) days of receiving the goods.

The dryer must always be kept in an upright position, as indicated by the symbols on the packaging. Use handling equipment that is properly rated for the weight of the machine. Do not remove the packaging until the dryer has been placed in its final installation location.

The original packaging should be retained at least for the entire duration of the product's warranty. Be sure to dispose of packaging materials in accordance with local regulations.

Do not remove any panels, either during transport or while positioning the dryer.

In case of non-use, the dryer must be stored in its packaging and in a dust-free location protected from high temperatures (max. 50°C, with relative humidity not exceeding 90%).

If storage exceeds 12 months, please contact the manufacturer.



3.2. Installation location

The following conditions must be met to ensure a suitable installation environment:



- Protect the machine from weather elements and direct sunlight.
- The support base must be level and capable of bearing the machine's weight.
- Ambient temperature must comply with the values listed on the nameplate (Appendices A and B).
- The room must be clean, dry, and free from drafts (we recommend directing hot air toward the outside).
- Ensure sufficient space around the dryer for proper cooling and for easy access during maintenance and inspections.

The intake air must be free from flammable fumes or vapors to avoid the risk of explosion or fire.

3.3. Installation layout



Before installation, ensure that:

- **No part of the equipment is under pressure.**
- **No part of the equipment is electrically energized.**
- **The connecting pipes to the dryer are clean.**



Only after verifying these conditions should installation proceed.



Connect the dryer to the compressed air line as shown in the installation diagrams. Once completed:

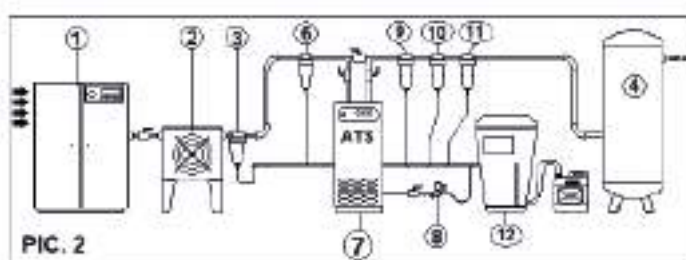
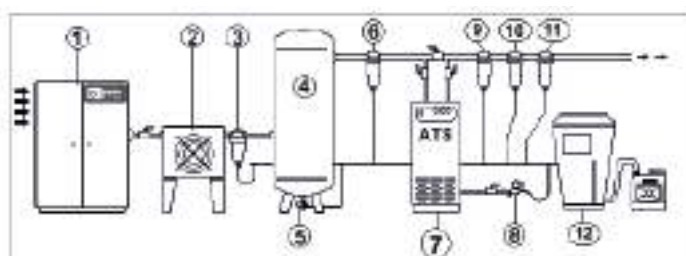


- **Position the dryer so that all control instruments are clearly visible, ensuring optimal operation.**



- **Install a 3 µm dust filter, which is essential for the proper functioning of the dryer's internal components.**
- **Install a bypass system to isolate the dryer from the equipment and facilitate any future maintenance operations.**

1	Air Compressor
2	After cooler
3	Condensate separator
4	Receiver
5	Automatic Drain
6	Dust Filter 3µ
7	Dryer
8	Solenoid drain valve
9	Coalescing Filter 1µ
10	Coalescing Filter 0.01µ
11	Activated carbon filter 0.003
12	mg/m ³ Water/Oil Separator



PIC. 2



3.4. Connection to the network

DANGER – Presence of High Voltage.
PROPER HANDLING PROCEDURES MUST BE USED TO AVOID ELECTRIC SHOCK.



Connection to the power supply must be performed by qualified personnel. All protection systems must comply with the electrical regulations in force in your country.

Before connecting the unit to the electrical supply, check that the available voltage and frequency match the nameplate data. A voltage tolerance of $\pm 5\%$ is allowed.

The dryers are already equipped with a power cable.

The main power socket must be fitted with a residual-current circuit breaker with overload protection (RCBO), and a qualified technician must check that the power cable cross-section is adequate and complies with local regulations. The cable must be sized according to the dryer's electrical consumption (see nameplate values).

Do not connect the dryer until you are certain that the network voltage and frequency are stable and match the data on the nameplate.

The user is responsible for providing line protection and grounding in accordance with the national electrical standards of the country of use.

3.5. Condensate drainage



The condensate is discharged at the same pressure as the incoming air.

Never direct the condensate drain stream at any person.

Do not release the condensate into the environment.



The condensate collected in the dryer contains oil particles released by the compressor.

We recommend installing an oil/water separator to collect condensate from compressors, dryers, tanks, filters, etc.

The dryer can be equipped with either a timed drain controlled by an electronic board or a capacitive drain (see Appendix G).



Start-up

4.1. Before starting



Before starting the unit, ensure that all functional parameters match the nameplate data. The dryer is tested and pre-set before shipping, meaning no additional adjustments are needed for operation. However, during the first hours of use, its proper functioning should be monitored.

4.2. Start-up

Upon delivery, the customer must inspect the dryer entirely and ensure that all items listed in the shipping documents are present.



1. Ensure that all instructions from the INSTALLATION SITE (section 3.2) and INSTALLATION LAYOUT (section 3.3) have been followed.
2. If the screen is off, press the START / STOP button for 3 seconds to power on.
3. The display will show the current temperature.
4. The unit will start after a one-minute safety delay.
5. Wait 5 to 10 minutes for the machine to reach standard operating parameters.
6. Slowly open the air outlet valve, then gradually open the air inlet valve.
7. Allow air to flow slowly into the dryer.
8. Check that all connecting pipes are properly tightened and secured.

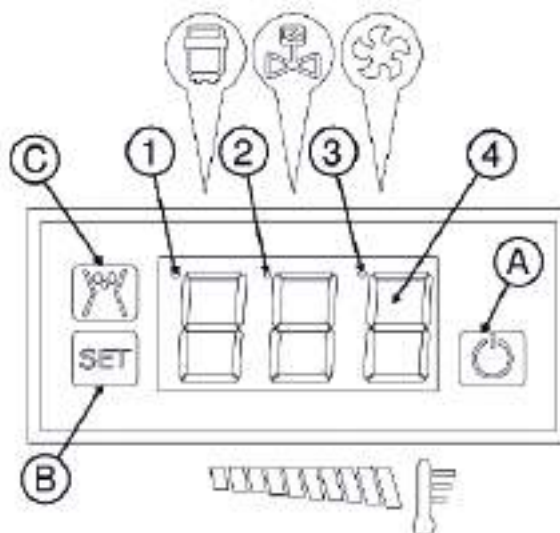
Before disconnecting the dryer from electrical power supply, press START/STOP key for at least 3 seconds. After that wait 10 minutes before switching the dryer on again, in order to allow freon pressure re-balance.

Fonctionnement

5.1. Control panel

The machines in this series are equipped with an electronic system that allows reset operations to be carried out from a digital control panel located on the front of the dryer.

The control panel, as shown in the diagram, consists of three buttons: (START / STOP (A), SET (B), DRAIN TEST (C)) and three indicator lights identified by icons.





No	LED	ICON	STATUS	DESCRIPTION
1	LED COMP		ON	Compressor energized
2	LED VALVE		ON	Condensate drain energized
3	LED FAN		ON	Fan energized
4	DISPLAY		OFF	UNIT SWITCH OFF
			3	DEWPOINT TEMPATURE
A	START / STOP key			Activates and deactivates the process
B	SET key			Parameter setting entry (depend on the current display)
C	DRAIN TEST key			Manual drain test

5.2. Standard operation

START / STOP key: Pushed for 3 seconds, it activates or deactivates the process. When the process is deactivated, the display not shows. During the dryer operation, the COMP LED (1) is on.

5.3. Programming

The device controls the compressor, fan and condensate drain solenoid of the dryer, and allows the calibration of the operating parameters. In case of particular requirements concerning the operation management the user can change the setting of the programmed parameters. The parameters (Pr1-8), which can be set up, are show on table.

How to set up

- To enter the configuration mode, press and hold the SET (B) button for at least 3 seconds.
- The first parameter, Pr1, will appear.
- Use the DRAIN (C) button to increase or decrease the value.
- To confirm and move to the next parameter, press the SET (B) button.
- To save and return to the normal display, press and hold the SET (B) button for 3 seconds.
- If no action is taken for 30 seconds, the system will automatically exit configuration mode.



Parameter	Description	Unit	Range	Default	Note
Pr1	Drain time	sec	1-10	1	Adjust depending on condition 0 to use with no loss drain
Pr2	Drain cycle time	sec	0-600	120	
Pr3	Auto reset time	min	1-19	5	Manufactory use only
Pr4	Sensor type		0-3	0	
Pr5	Fan set point	°C	25-52	42/46*	
Pr6	Fan hysteresis	°C	1-10	1/2**	
Pr7	Fan offset	°C	-5 / +5	0	
Pr8	Dew point offset	°C	-5 / +5	0	

The fan setpoint is 42°C for models DGO24-216, and 46°C for models TRAIE330-440.

The fan hysteresis is 1°C for models DGO42-240, and 2°C for models DGO330-440.

5.4. Alarms

Message	Description	Conditions	Actions
ES	Energy saving	Dewpoint lower than -1 °C over 6 minutes	Wait 5 minutes for auto restart working function
AdP	High dewpoint alarm	Dewpoint higher than 17 °C Over 6 minutes	Switch off the unit to reset if alarm persists contact service
P1	Dewpoint probe alarm	All problem with dewpoint probe	Change probe / dryer will not stop to work
P2	Fan probe alarm	All problem with fan probe	Change probe / dryer will not stop to work fan motor keep running

5.5. Alarm history

The device can show the alarm history, indicating how many alarm events occurred during the last operation.

To access the alarm history display:

1. Press and hold SET (B) and DRAIN TEST (C) simultaneously for 2 seconds.
2. You will see “E”, showing the number of energy-saving events.
 - Press SET (B) for 1 second to reset this value.
 - Press DRAIN (C) for 1 second to go to the next alarm history entry.
3. You will then see “S”, indicating the number of sensor time-related issues.
 - Press SET (B) for 1 second to reset this value.
 - Press DRAIN (C) for 1 second to go to the next alarm history entry.
4. You will then see “d”, indicating the number of high dew point alarms that occurred.
 - To return to the normal display, press and hold SET (B) and DRAIN TEST (C) for 2 seconds.



Maintenance, troubleshooting, spare parts and disposal

The dryer is a refrigeration unit and, as such, all maintenance operations must comply with the safety regulations in force in the country of installation.

6.1. Inspection and maintenance

Before carrying out any maintenance, ensure that:

1. No part of the system is under pressure.
2. No part of the system is electrically energized.

WEEKLY or EVERY 40 OPERATING HOURS

- Check the temperature on the control panel display.
- Visually inspect the regular discharge of condensate.



MONTHLY or EVERY 200 OPERATING HOURS

- Clean the condenser using a jet of compressed air, being careful not to damage the aluminum fins of the cooling coil.
- Clean the condensate drain solenoid valve according to the procedure described in section 6.1.1.
- After these operations, check that the dryer is functioning properly.

YEARLY or EVERY 2000 OPERATING HOURS

- Check the condition of the condensate drain hose and replace it if necessary.
- Check the tightness and proper fastening of all connecting pipes.
- After these operations, ensure the unit is functioning properly.

6.1.1 . Cleaning the drain solenoid valve



1. Close the ball valve located upstream of the mechanical filter at the solenoid valve inlet.
2. Depressurize the filter by pressing the DRAIN button on the control panel.
3. Unscrew the filter cap to access the metal cartridge, then clean it with a jet of compressed air.
4. Reassemble the unit and reopen the inlet and outlet valves.





6.2. Troubleshooting



Repairs and any inspection or maintenance tasks must only be performed by qualified personnel. For refrigeration circuit maintenance, contact a certified refrigeration technician.

FAULT	REMEDY
Control panel screen does not light up	Check for power supply.
	Check electrical wiring.
	Check electronic board; replace if problem persists.
Compressor does not start	Check electrical wiring and electronic board.
	Internal thermal protection has been triggered; wait 1 hour and check again. If the issue persists, stop the unit and contact a refrigeration technician.
	Check electrical parts of the compressor.
Fan does not run	Replace if the compressor is short-circuited.
	Check the protection fuse (if present) and replace.
	Check the electrical wiring.
	Check the wiring and electronic board; replace if needed.
	Replace fan if it is short-circuited.
No condensate discharge (no air or water)	Check electrical wiring.
	Prefilter is dirty; clean it.
	Drain solenoid coil is burnt; replace.
	Drain solenoid valve is clogged or stuck; clean or replace it.
	Check electronic board; replace if necessary.
	If the screen temperature is lower than normal, contact a refrigeration technician.
Continuous air discharge from the condensate drain	Drain solenoid valve is blocked; clean or replace it.
	Check the condensate drain timing parameters.
	Check the electronic board and replace if necessary.
Water in downstream piping	Dryer is off; turn it on.
	Bypass system (if present) is open; close it.
	No condensate discharge; refer to relevant section.
	Temperature on display is higher than nominal; see troubleshooting section.
Temperature on screen is higher than nominal	Check correct air inlet/outlet connections.
	Compressor does not start; refer to related section.
	Fan not running; refer to related section.
	Inlet air flow rate and/or temperature exceed nameplate values; return to nominal conditions.
	Ambient temperature exceeds rated conditions; restore proper environment.
	Condenser is dirty; clean it.
	No condensate discharge; refer to relevant section.
	Evaporator temperature probe is misaligned or faulty; check it.
	Refrigerant leak; stop the unit and contact a refrigeration technician.
	Check wiring.



FAULT	REMEDY
Compressed air does not pass through the dryer	Check correct inlet/outlet air connections.
	If temperature on screen is too low, contact a refrigeration technician.
	Evaporator probe is misaligned or faulty; verify.
	Check for clogged pipes and clear if needed.
	Check bypass system (if installed) is correctly configured.
	Check electronic board; replace if necessary.

Important :

The temperature probe is extremely delicate. Do not unplug or remove it from its housing. For any issue, contact the service center as soon as possible.

6.3. End of life

When decommissioning the dryer, it must be dismantled into groups of homogeneous materials.



Part	Material
Refrigerant fluid	R134.a, R407C – HFC, Oil
Canopy and Supports	Carbon steel, Epoxy paint
Refrigeration Compressor	Steel, Copper, Aluminum, Oil
Aluminum heat exchanger	Aluminum
Condenser Unit	Aluminum, Copper, Carbon steel
Pipe	Copper
Fan	Aluminum, Copper, Steel
Valve	Brass, Steel
Electronic Level Drain	PVC, Aluminum, Steel
Insulation Material	Synthetic gum without CFC, Polystyrene, Polyurethane
Electric cable	Copper, PVC
Electric Parts	PVC, Copper, Brass



Follow applicable safety and environmental regulations when disposing of each type of material.

The refrigerant contains small quantities of lubricating oil released by the refrigeration compressor.

Do not release it into the environment.

Drain it from the unit using proper equipment before sending the machine to a certified recycling center for proper treatment and disposal.



Appendices

A. Technical specifications

Dryers Air flow rate		42	60	120
Air flow rate	l/min	700	1000	2000
	scfm	24,5	35	70
Air connections	BSP-F	G 3/4"		
Refrigerant		R134a		
Fan motor working pressure	barg	Running 11 / Stop 8		
Weight	kg	23	24	
Air inlet temperature	°C	35° (Max 70°)		
Ambient temperature	°C	25° (Min 5- Max 50°)		
Working pressure	barg	7 (Max 16)		
Pressure dew point	°C	3° (Max 10°)		

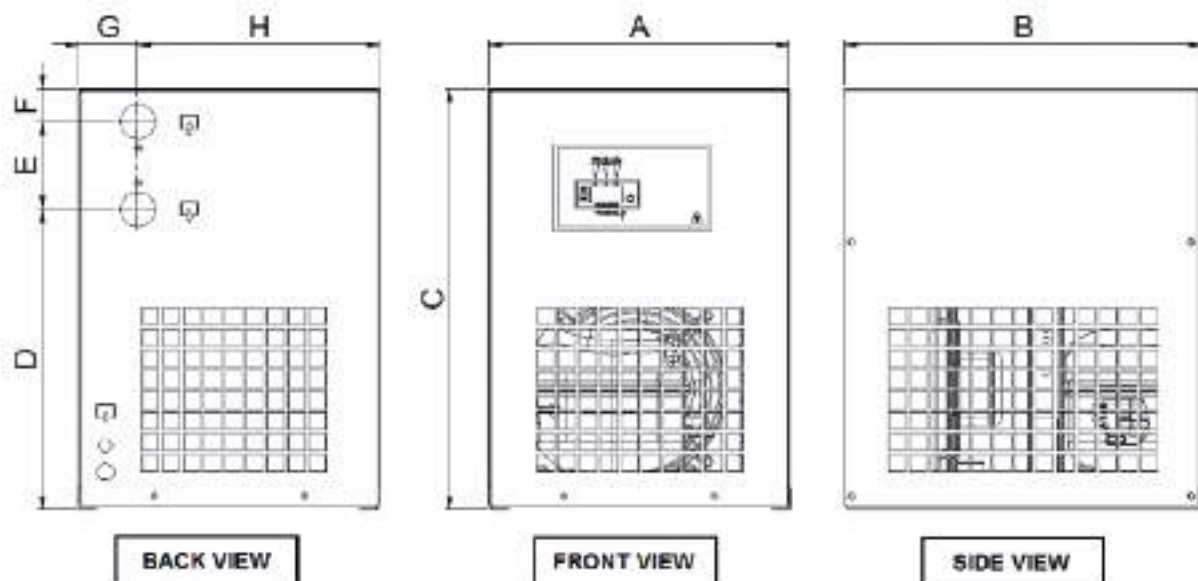
Power supply	V/Ph/Hz	230/1/50		
Nominal consumption	kW	0.18	0.22	0.32
Nominal current	A	1.14	1.30	1.45
Full load current	A	1.31	1.44	1.58
Locked rotor current	A	4	4	6



B. Legend

1A1	Electronical controller
1S1	Main switch
1M1	Refrigerant compressor
1M2	Fan motor
1R1	NTC probe L=0.8m
1R2	NTC probe L=2.5m
CND	Condenser
FF	Filter dryer
SC	Aluminum heat-exchanger
SC / AA	Aluminum exchanger air - air
SC / AR	Aluminum exchanger air - refrigerant
SC / MC	Mixing chamber
VB	By-pass valve
TS	Thermal switch
1B1	Coil drain valve
RBF	Filter
1V1	Solenoid valve
CT	Capillary tube

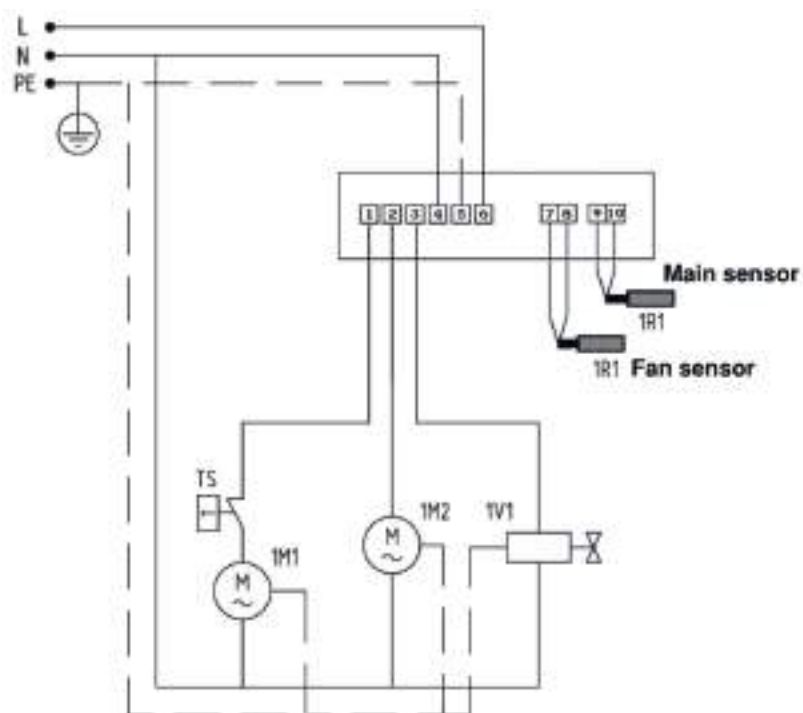
C. Dryer dimensions



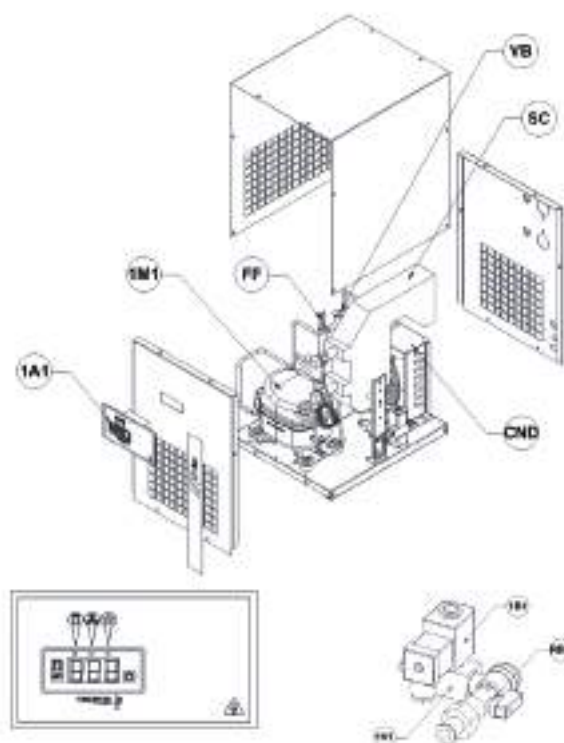
MODEL	A	B	C	D	E	F	G	H	 & 		
	mm	mm	mm	mm	mm	mm	mm	mm	inch	mm	V/ph/Hz
SEC30PACK	305	373	440	340	65	35	45	260	BSP 3/4"	D.6	230/1/50
SEC60PACK	305	373	440	340	65	35	45	260	BSP 3/4"		
SEC120PACK	345	409	480	343	100	37	67	278	BSP 3/4"		



D. Electrical diagrams



D. Exploded view - Recommended spare parts





The suggested spare parts list will enable you to promptly intervene in case of abnormal operation, so avoiding to wait for the spares delivery. In case of failure of other parts, for example inside the refrigerating circuit, the replacement must mandatory be worked out by a refrigerating systems specialist or in our factory.

	DESCRIPTION OF THE SPARE PARTS	CODE	42	60	120
1A1	Electronic controller	0EB.00004	1♦	1♦	1♦
1S1	Main switch	250.0016.00.00-WH 332.TSWO.21.00			
1R1	NTC probe L=0.8m	0EP.00006	2♦	2♦	2♦
1R2	NTC probe L=2.5m	0EP.00007			
VB	By pass valve	142.2950.00.00 142.4536.00.00	1	1	1
1B1	Coil CS728 220-240V 50/60	240.T100.01.00	1♦	1♦	1♦
1V1	Solenoid CS728 Conn 1/2"	0RV.00000	1♦	1♦	1♦
RBF	Strainer CS728 Conn1/2" 6	0RV.S0000	1	1	1
1M2	Fan motor	210.0130.00.00	1	1	
		210.0131.00.00			1
		210.0132.00.00			
	Fan blade	213.0061.00.00	1	1	
		213.0062.00.00			1
		213.0063.00.00			
	Fan grid	213.0065.00.00	1	1	
		213.0066.00.00			1
FF	Dehydration filter	0EF.C0003			
		210.D350.02.B0			
		630.0049.00.00	1	1	1
		630.0050.00.00			
CND	Condenser	630.0075.00.00			
		921.0020.D0.00-00	1		
		921.0035.D0.00		1	
		921.0108.00.00			1
		921.0150.D0.00-BOI			
		921.0195.00.00			
		921.0013.01.00			
1M1	Refrigerant compressor	921.0365.00.00			
		921.0480.D0.00			
		201.0102.00.00	1		
		201.0100.00.00		1	
		201.0101.00.00			1
		201.0110.00.00-CH			
		201.T135.VH.SM			
SC	Aluminum heat exchanger	201.T102.00.00			
		201.T103.00.00			
		920.5088.00.00	1	1	
		920.5105.00.00			1
		920.5089.00.00			
		920.5161.00.00			
		920.5090.00.00			
TH	Safety Thermostat	920.1326.00.00			
		920.1327.00.00			
		0ET.00000	1	1	1

NOTE - To order the suggested spare parts or any other part, it's necessary to quote the data reported on the identification plate.



Contact SGI Pastry

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