('ak-sēz) AXYZ™ AUTOMATION INC.

Vacuum Ready Option (For Series Tables only)

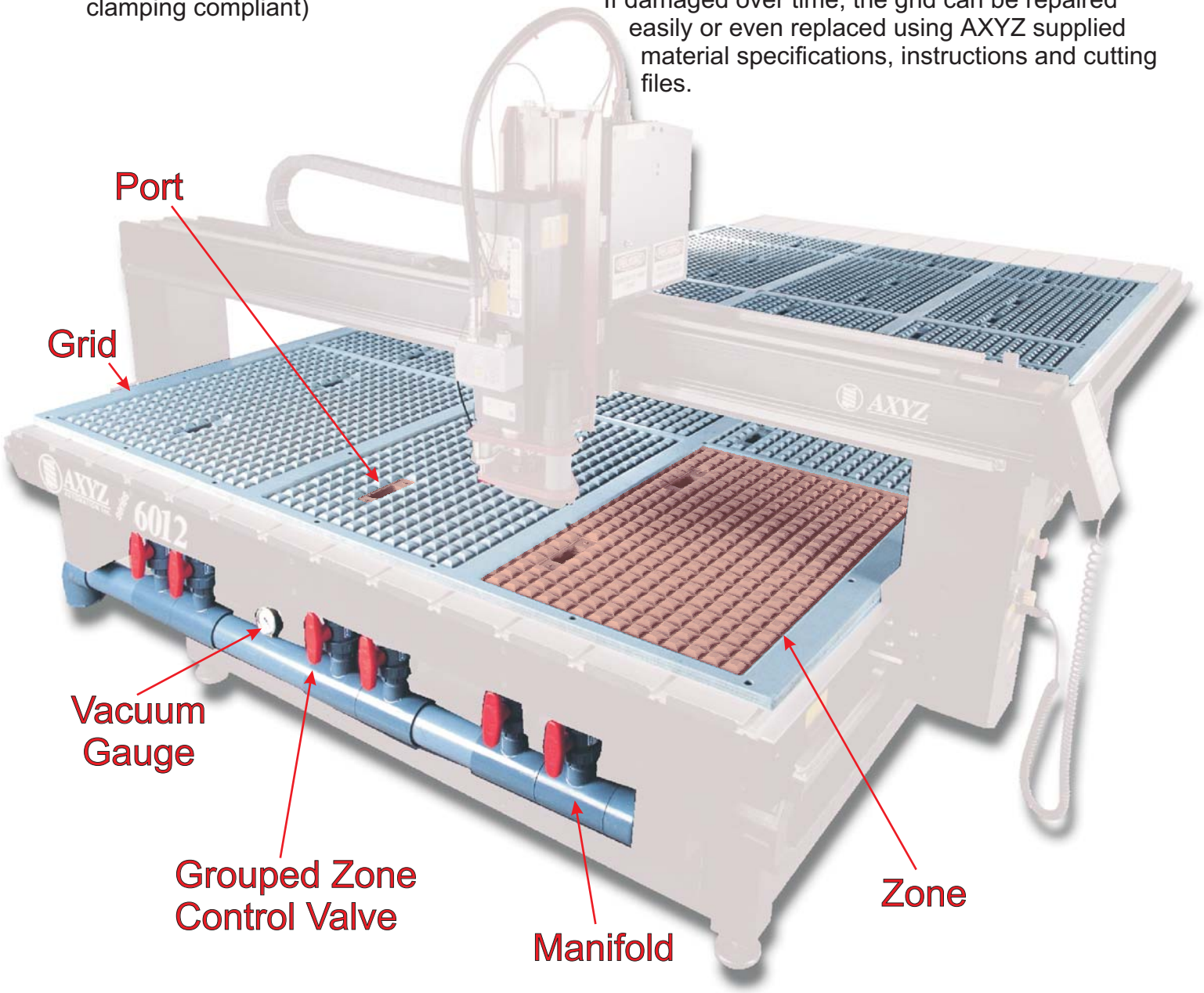
Included

- Vacuum manifold complete with Vacuum Gauge, 3 x 10ft of 4” pvc pipe, 3 x 90 degree elbows, valving and flanges to control grouped zones.
- Factory cut and sealed standard grid. Note, 4000 series available in 5’ width(full coverage) and 4’ width(side clamping compliant)

Description

The Vacuum Ready option provides you with all the hardware required to hook up a vacuum pump or blower to the router table.(see Vacuum Option Spec Sheet for available pumps and blowers). Each Series Table size configuration is shipped with a standard grid layout with custom grid layouts available to suit specific applications or fixtures.

If damaged over time, the grid can be repaired easily or even replaced using AXYZ supplied material specifications, instructions and cutting files.



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Precision Vacuum Grid Design

The new vacuum grid design has incorporated three new features:

1. There is a gasket installed around each section of the grid. This ensures there is no leakage through the margins between the grid and the waste board making the entire vacuum system more efficient.
2. There are threaded metal inserts installed in the grid along the outside edges. These inserts allow the user to screw the waste board down to the grid so there is no problem with movement or warping of the waste board.
3. There are small indentations around the grid to allow for the installation of pop-up material alignment fixtures.

There are several ways to use the new system:

1. In cases where the flatness of the table is not critical it can be used exactly the same way as it has been used in the past. Simply lay a ¼ inch sheet of MDF over the grid, suck it down with the vacuum and lay the material on top. The advantage of the new grid is that this process will be more efficient because of the gaskets preventing any side leakage. If the customer is concerned about the waste board shifting you can now screw it down using the inserts.
2. If it is critical that you operate on a flat surface a ¾ inch MDF waste board is installed with screws into the inserts. A planning bit is used to plane the surface of the waste board perfectly flat. The user has to re-plane the surface every once in a while when the efficiency drops. The MDF is quite thick and since it is very flat every re-planning procedure only takes a very small amount of the waste board away so a single sheet will last a long time.
3. If it is critical to operate on a flat surface but the parts are large and do not need the most efficient vacuum operation the machine can be set up with the ¾ inch MDF, planned flat, but a ¼ inch MDF is placed on top. The user just replaces the ¼ inch MDF as required and the ¾ inch MDF will remain undamaged and still provide the perfectly flat surface. The only disadvantage is that there is some loss of vacuum along the margin between the ¾ and ¼ MDF board.

The vacuum system can be ordered in two ways:

1. The standard vacuum package includes the installed grid with the gasket installed. It includes ¼" MDF sheets cut to fit the grid.
2. The "high precision" vacuum package that will include the ¾" MDF, installed and screwed down. The ¾" sheet will be milled flat. ¼" material will be supplied cut to fit on top. A CD with the flat milling files and the files to make new ¾ and ¼ waste boards as well as a 1 ½" milling bit along with the appropriate collet will be supplied as the vacuum system "accessories" kit.

A standard package can be upgraded to a "precision" package at any time. The accessories kit will be supplied with the precision package automatically, however, the accessories kit can be ordered separately.