

# VM300 QUICK START GUIDE

**Congratulations!!**

You are on the way to simplifying and improving your set-ups and versatility of your machining center!

Please feel free to contact us with any questions anytime

800-543-3580 • 603-539-4538  
Engineers@MiteeBite.com



Part Number 45175 and all accessories



Recently added items include:

Vacuum Gauge (12), Gasket Installation Tool, Set of Diamond Taper Pins, Vacuum Grease, 3 Carbide End Mills for custom vacuum plates, and a 4mm "Y" Connector which allows connections of the Vacuum Gauge and Low Pressure Trip Switch (LPTS) at the same time.



VM300 component checklist.



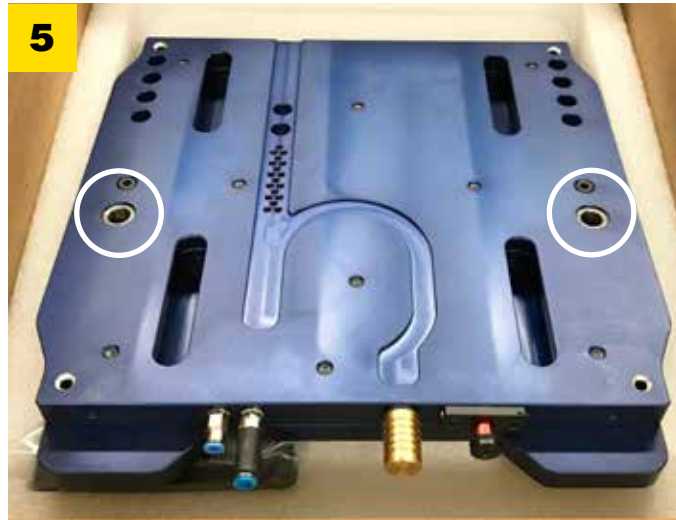
Custom packaging for your VM300 Base Unit (Receiver) (PN 45175).



Additional accessories stored under Base Unit.



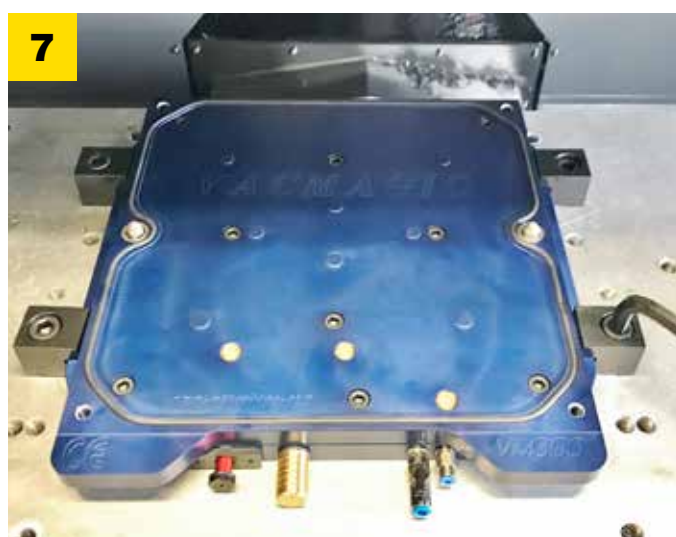
Top of VM300 Receiver.



Bottom of Receiver identifying precision drill bushing for quick installation and alignment. Centerline = 10.630"/270mm.



Machine platform with diamond taper pins allows quick and precise installation and removal of your tooling. Base Unit placed on these pins for location and rigidity.



Secure with mounting clamps.



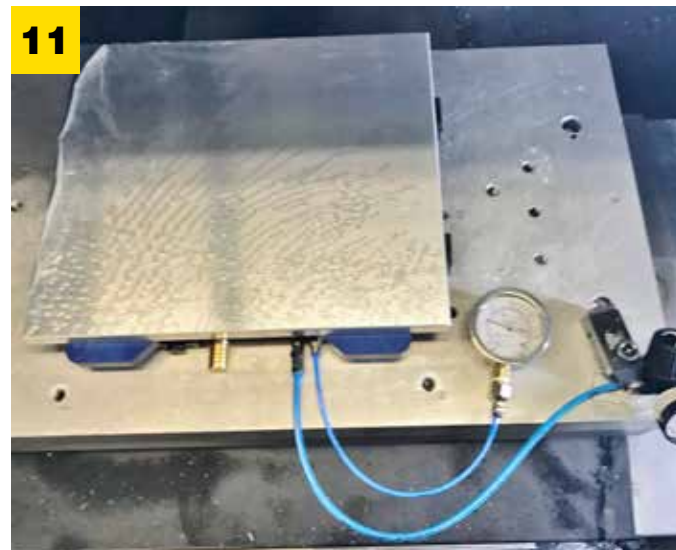
Assemble Regulator and attach with 6mm tubing to Supply Valve. Using 4mm tubing, attach Vacuum Gauge and/or Low Pressure Trip Switch fitting (located next to Supply Valve).



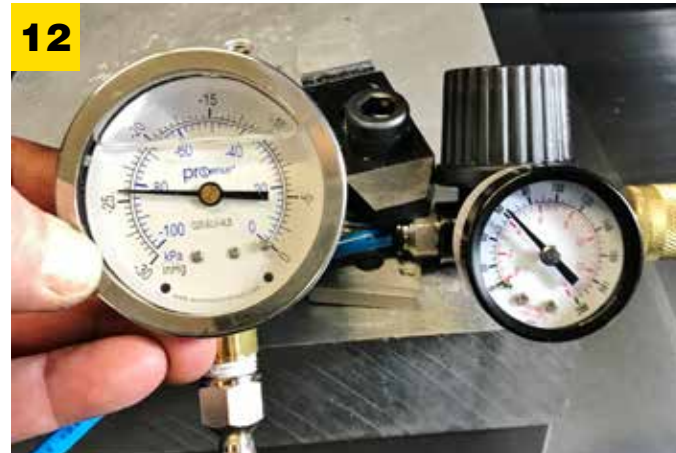
Adjust air pressure to 70-75 PSI or 5 bar.



Bottom of Blank Pallet (PN 45130 or 45135) identifying precision drill bushings and grip points.  $\varnothing = 10.630"/270mm$ .



Blank pallet placed on receiver. Ready to machine as a mechanical fixture pallet, custom vacuum pallet or mount your vise eliminating the process of indicating every time.



With Blank Pallet installed adjust air pressure with regulator until highest vacuum is obtained.



Visual red indicator identifying vacuum off.



Visual indicator identifying vacuum on.



VM300 Vacuum Pallet (PN 45150) ships with 1 pack each: Fixture Clamps (PN 50206) and Sliding Stops (PN 44200).



Bottom of Vacuum Pallet identifying through hole in center and both precision drill bushing.  $\varnothing = 10.630"/270mm$ .



Vacuum Pallet placed on Base Unit.



Sealing Gasket installed in channel.



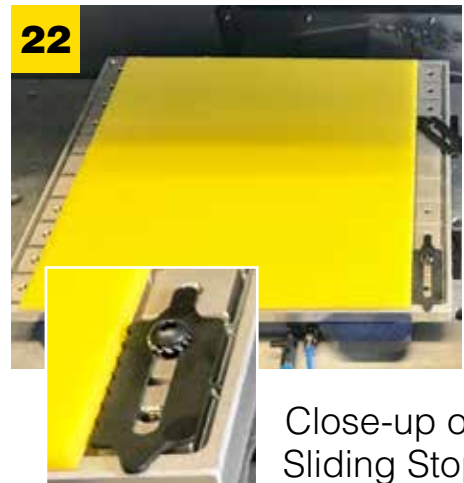
Close up of recommended method of sealing chamber. Place end of Gasket approximately 25% into perpendicular slot. Cut with scissors for clean straight end.



Take care in adjusting Gasket to obtain best seal possible. Ensure Gasket is in contact with bottom of slot, check entire length for gaps using flashlight. Vacuum Grease (PN 45094) and Installation Tool included to ease installation.



Vacuum pallet ready for workpiece.



Workpiece positioned against Sliding Stops (PN 44200).



Open supply valve and check indicator and gauge for proper pressure. If using LPTS we recommend mounting on backside of machine and adjust LPTS using gauge.



This Vacuum System can be configured to stop machining functions immediately. Have a qualified technician connect Low Pressure Trip Switch to the FEED HOLD circuit. This LPTS has an adjustment screw between the two prongs allowing you to set the "trip" pressure.

**You are now ready to machine!**