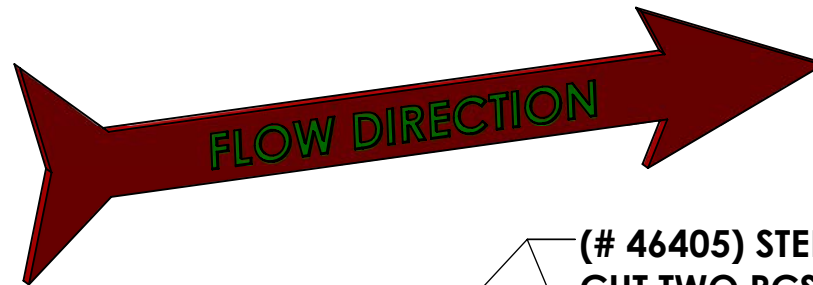


GASKET CONFIGURATIONS	VACUUM CHAMBER SURFACE AREA	HOLDING FORCE GENERATED
1	68 sq in	816 lbs
2	58 sq in	696 lbs
3	45 sq in	540 lbs
4	34 sq in	408 lbs
5	25 sq in	300 lbs
6	17 sq in	204 lbs
7	10 sq in	120 lbs
8	5 sq in	60 lbs
9	2 sq in	24 lbs



(# 46405) STEEL TUBING 5/16" (8MM) DIA, CUT TWO PCS TO LENGTH AS NEEDED

(# 46300) OR (# 46330) ELECTRIC VACUUM PUMP ASSEMBLY COMES WITH COOLANT TRAP AND FITTINGS

9 DIFFERENT GASKET CONFIGURATIONS AVAILABLE WITH #1 HAVING THE LARGEST HOLDING FORCE

(# 46400) ROTARY VACUUM CHUCK

(# 46455) ROTARY FITTING

COOLANT TRAP

(# 45111) BLACK .170 DIA GASKET MATERIAL

(# 45155) (4) PCS ADJUSTABLE VACUUM GRIPPERS THREAD INTO FACE OF VACUUM CHUCK WHEN INCREASED HOLDING FORCE IS NEEDED

(# 45450) SACRIFICIAL VACUUM PLATE. WHEN CUSTOM PART GASKET GEOMETRY IS NEEDED. MOUNTS DIRECTLY TO THE FACE OF THE VACUUM CHUCK VIA M6 TAPPED HOLES. INSTALL GASKET IN BETWEEN SACRIFICIAL PLATE AND ROTO-VAC GASKET IS INSTALLED ON INWARD SIDE OF MOUNTING BOLT HOLE CIRCLE TO ENSURE SEAL

The ROTO-VAC™ vacuum system is designed for light to moderate machining of composites and mild alloys. During R&D it was discovered we could remove material at a higher rate than anticipated using our own custom vacuum grippers. We recommend a minimum of 2 grippers be used when needed, with the grippers protruding slightly above the face of the chuck. Tap with mallet to seat grippers while vacuum pump is on. The adjustable grippers will increase lateral holding force 200-400% above holding force listed for each chamber. General machining practices and common sense will ensure safe operation and prevent personal injury and equipment damage.
 ****As always please contact Mitee-Bite with any questions before using product****

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES

FRACTIONS +/- 1/32	DECIMALS .X = .030
ANGLES +/- 1/2°	.XX = .010
	.XXX = .005
	.XXXX = .001



TITLE: ASSEMBLY INSTRUCTIONS
 ROTARY VACUUM CHUCK

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BREAK ALL SHARP EDGES
 1/64 X 45°
 DRAWN BY: TAK
 ENG. APPROVAL: TAK
 MANF. APPROVAL: N/A

SIZE	DWG. NO.	REV
B	T10309	A
DATE: 04/26/17	SCALE: 1:12	SHEET 1 OF 1