

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

9 DIFFERENT GASKET CONFIGURATIONS POSSIBLE WITH #1 HAVING THE GREATEST HOLDING FORCE

(# 46400) ROTARY VACUUM CHUCK

(# 46455) ROTARY FITTING

(# 46050) COOLANT TRAP SUPPLIED WITH TUBING, FITTING AND FILTER

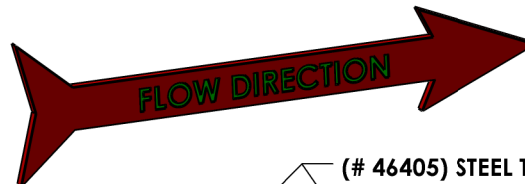
(# 46405) STEEL TUBING 5/16" (8MM) DIA, CUT TWO PCS TO LENGTH AS NEEDED

(# 46350) 115V ELECTRIC VACUUM PUMP ASSEMBLY SUPPLIED WITH TUBING, FITTINGS, FILTER AND PSI VACUUM GAUGE

(# 45111) BLACK .170 DIA GASKET MATERIAL

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

(# 46450) SACRIFICIAL VACUUM PLATE. WHEN CUSTOM PART GASKET GEOMETRY IS NEEDED. MOUNTS DIRECTLY TO THE FACE OF THE VACUUM CHUCK VIA M6 TAPPED HOLES. 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****

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES	
FRACTIONS +/- 1/32 ANGLES +/- 1/2°	DECIMALS .XX = .030 .XXX = .010 .XXXX = .005 .XXXXX = .001
BREAK ALL SHARP EDGES 1/64 X 45°	
DRAWN BY:	TAK
ENG. APPROVAL:	SM
MANF. APPROVAL:	DB



TITLE:
ASSEMBLY INSTRUCTIONS
ROTARY VACUUM CHUCK

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