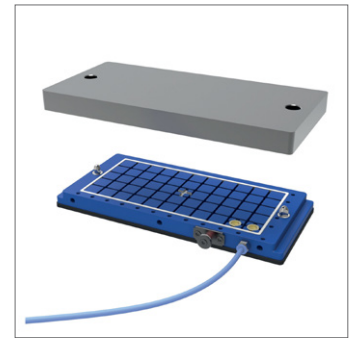
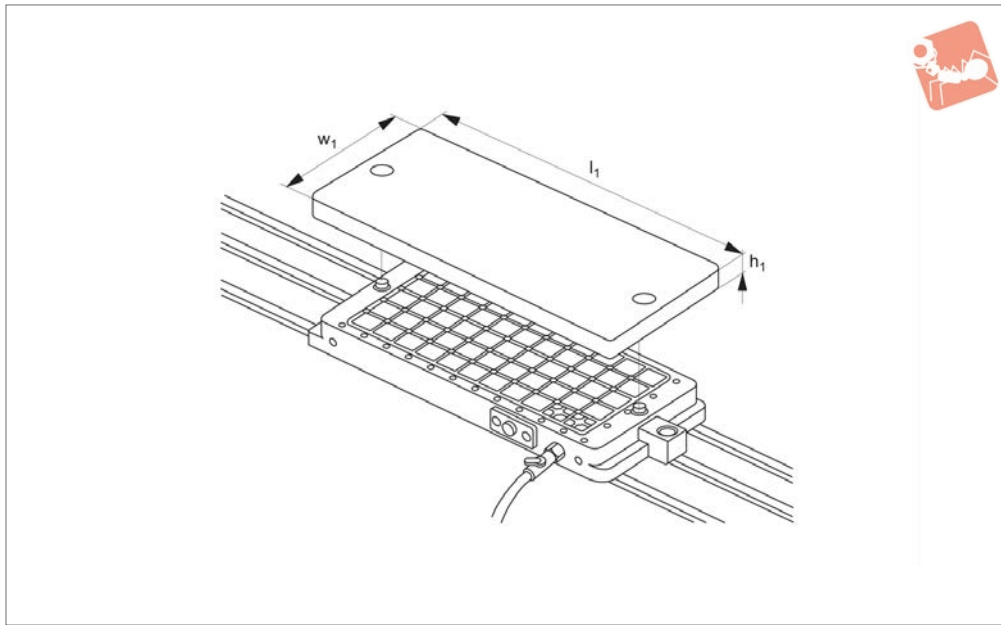




VacMagic VM100 Palletising System

for quick fixture change

Vacuum Clamping Systems



19710

VACUUM CLAMPING SYSTEMS

Technical Notes

Use as a quick fixture palletising system - blank pallets available, see part no. 19710.W0325.

Mount to grid plate or T-slot table with clamps provided.

Operates from 70-100 psi shop air, no need

for vacuum pumps and coolant traps.

Will accept the standard 19730.W0150 vacuum pallet, increasing your vacuum platform to over 360mm x 315mm.

Remove 12mm pins for grinding/ machining thin material, use set screws to locate and aid in holding force.

Tips

Clamp in a vice to reduce setup time.

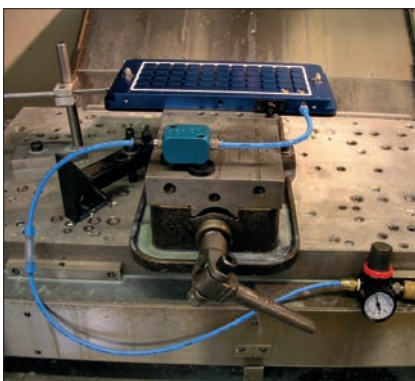
Important Notes

Set includes everything necessary to get your 19710 running within minutes of opening the box - excludes regulator.

Order No.	Description	l_1	h_1	w_1
19710.W0110	Gasket - Black per foot	-	-	-
19710.W0114	Gasket - White per foot	-	-	-
19710.W0300	Complete System - Base, 2 Pallets and Clamps	-	-	-
19710.W0325	Blank Pallet	318	25	150
19710.W0375	Base and Clamps	315	25	140

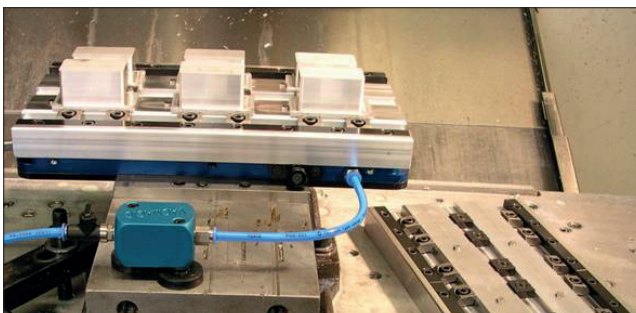


Applications

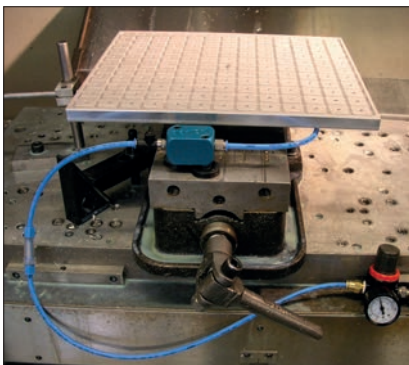


More than just a vacuum system - a fully flexible clamping and fixturing solution.

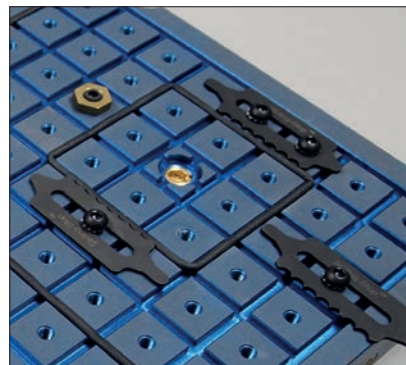
Mount the base unit to the grid plate, T-slot table or in a vice.



Make your own vacuum fixtures for fully flexible fixturing.



Will accept the standard 19730.W0150 pallet, increasing your vacuum platform to over 360 x 315mm.



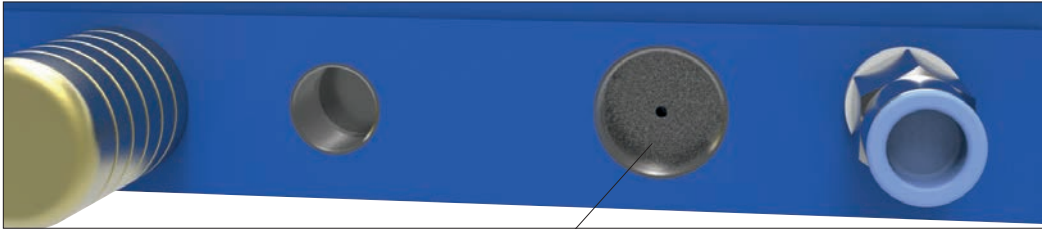
Sliding stop 12042 used to assist in low profile positioning on our vacuum system.



Maintenance

Very little maintenance is necessary to keep your system up and running. Using general housekeeping practices will ensure your system operates properly for years to come.

- Brass filters may require periodic cleaning to prevent clogging and airflow obstruction. Remove the filters, soak in a cleaning solvent, and apply compressed air from the rear of the filter. This should be done in a safe manner to avoid personal injury to yourself or others. Then, simply dry and re-install the filters.
- The Venturi generator may become obstructed with foreign objects or blocked up by coolant if the system has not been used for a while. Simply remove the supply valve and check/remove any small objects that may be interfering with the air supply. While the supply valve is removed, use a 0,9mm pin to clear any debris build-up that may have accumulated in the Venturi generator (see image below).
- The low vacuum indicator may also require periodic cleaning. Remove this and clean with light oil before re-installing.
- A visual inspection of all O-rings and white gasket material should be done on a regular basis: O-rings monthly, white gasket material weekly.



Supply valve removed exposing Venturi generator

Troubleshooting

This is a very simple operating system. Any problems can be easily rectified with the information contained in this manual or by contacting us directly.

- Check air pressure.
- Ensure gasket material is protruding above the fixture plate and continuous with no gaps.
- Clean brass filters.
- Check front of Venturi generator for obstructions.
- Ensure locating pins are fully seated (diamond and solid).
- Through hole for vacuum pallets should be a minimum of 0.25 inch diameter.
- Check that all top plate mounting bolts are tight and below the surface of the plate.
- Check air lines for leaks.
- Check workpiece for flatness.
- Check exhaust air for restricted flow.