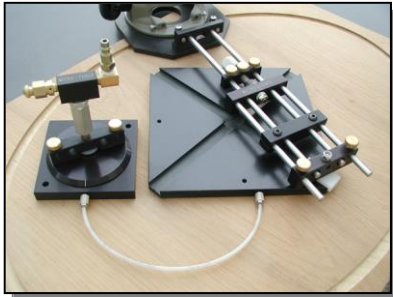


# Ellipse Vacuum Kit

12970 Branford Street Unit M, Arleta, CA 91331 Phone 1-800-480-6427  
Email: [microfence@microfence.com](mailto:microfence@microfence.com) Website: [www.microfence.com](http://www.microfence.com)



Our **Vacuum Center Assembly (VCA)** can be used as a remote generator to hold the **Standard Ellipse Plate** (new version) in position.\* The kit comes with a machined aluminum platform for the **VCA**, two Parker Mini-loc connectors, 6 feet of vacuum tubing, and the necessary gaskets you'll need to convert your Ellipse Jig to a vacuum hold-down.

\* Axes Plates purchased prior to 8/1/02 were not ported for this vacuum attachment. They can be retro-fitted or replaced with the newer version. (See reverse side.)

Your package should include the following parts pictured below:

the aluminum vacuum block or "pod"

8 ¾ " square gasket (truncated corners)

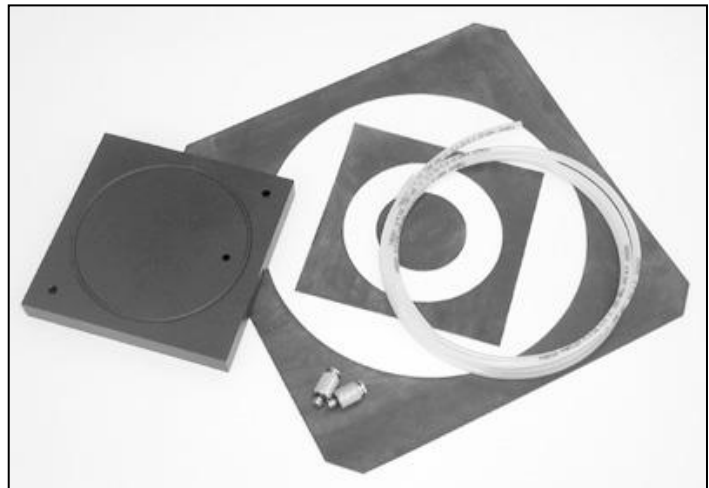
4 ½ " square gasket

2" round gasket

Two Parker Mini-loc Connectors

6' vacuum tubing

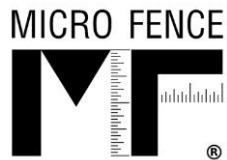
3/32 allen wrench\* (not pictured)



\*On the bottom of the aluminum vacuum block, you will see a 10-32 allen set screw installed that has been wrapped with teflon tape. This "plug" can be removed and the 4 ½" gasket can be installed if you wish the remote "pod" to be held down by vacuum as well. (When re-installing the set screw, be sure to re-wrap with the teflon tape).

## Installing the Gaskets:

To install the 8 ¾" gasket on the bottom of the 9 ¼" Axes Plate (T-Slot version as of 10/08), we suggest placing the gasket face-down on a clean surface as you remove the white adhesive protection liner. Leaving the gasket face-down, firmly press the bottom of the axes plate down on the gasket. (It is far easier to control placement taking advantage of the plate's rigidity than trying to apply the flexible gasket to the plate.)



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**Technique:** Draw the outline of the 9 1/4" Axes Plate on layout paper or board and place the 8 3/4" gasket face down ( adhesive protection liner removed), with a 1/4" border showing around the perimeter. Guide the bottom of the Axes Plate onto the gasket using the outline as a reference. Press firmly to bond gasket to plate.

The gasket adhesive will remain pliable and reseatable for several hours after the removal of the backing, so don't worry if the initial placement is not aligned to your satisfaction. Simply peel off gently and re-position. The adhesive will cure to maximum adhesion in about 24 hours, or if vacuum is applied to the plate.

The 2" round gasket should be applied at the center of the Axes plate inside the circular cut-out of the 8 3/4". It is provided to eliminate any collapsing of the axes plate at center under vacuum load. This will affect how smoothly the dovetail slides travel in the axes ways of the plate.

**Note:** The rubber gaskets must be kept as clean and dust-free as possible. When cleaning, use a glass or surface cleaner such as Windex. Using petroleum-based solvents may affect the adhesive backing.

## Installing the Connectors:

Cut the vacuum tubing squarely with a fresh razor blade or equivalent to desired length. Be sure the port of the connector is clean and free of debris. Insert the tubing into the connector until it bottoms. A slight twisting motion will ease the insertion. Pull on tubing to verify it is properly retained in the fitting. To disassemble, simply push the collet against the body and remove tubing. If the tubing kinks or becomes fatigued at the back of the connector, remove, re-cut and re-install.

Screw the connectors into the ports machined in the sides of the Axes Plate and the aluminum VCA "pod." You are ready to place the VCA on the remote pod and attach the air line. (see the Vacuum Center Assembly instructions for air pressure recommendations)

**Retro-fitting the Axes Plate:** If you have an Axes Plate that pre-dates Aug. 1, 2002 it will not be drilled with the necessary holes for the Ellipse Vacuum Kit. **Micro Fence®** can retro-machine the plate for you or you can do it yourself. The diagram below shows the positioning of the holes you will need to drill and the specifications for the drilled and tapped hole needed in the side of the plate. Call **1-800-480-6427** if you have further questions.

