



# CNC D-500 Vac Bed Instructions V1.1

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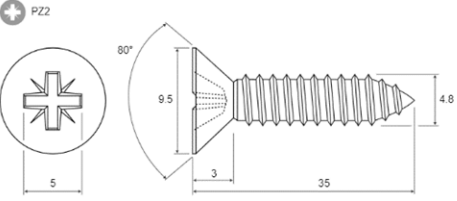
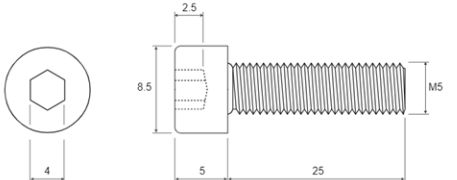
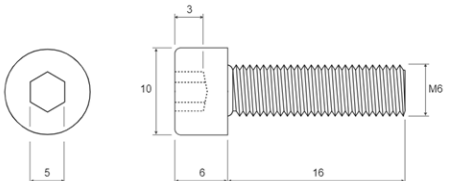

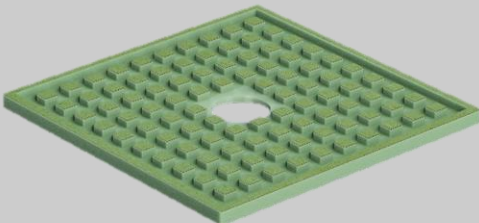
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## Checklist

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Name	Dimensions	Quantity	Packing Check	Customer Check
Hose Adaptor		1	<input type="checkbox"/>	<input type="checkbox"/>
90° Elbow Joint Pipe		1	<input type="checkbox"/>	<input type="checkbox"/>
Pipe		1	<input type="checkbox"/>	<input type="checkbox"/>

Name	Dimensions	Quantity	Packing Check	Customer Check
<b>5 x 35mm Wood Screws</b>		12	<input type="checkbox"/>	<input type="checkbox"/>
<b>M5 x 25mm</b>		30	<input type="checkbox"/>	<input type="checkbox"/>
<b>M6 x 16mm</b>		4	<input type="checkbox"/>	<input type="checkbox"/>
<b>MDF Base Bed</b>		1	<input type="checkbox"/>	<input type="checkbox"/>
<b>MDF Vac Bed</b>		1	<input type="checkbox"/>	<input type="checkbox"/>

CNCDesign

Limited

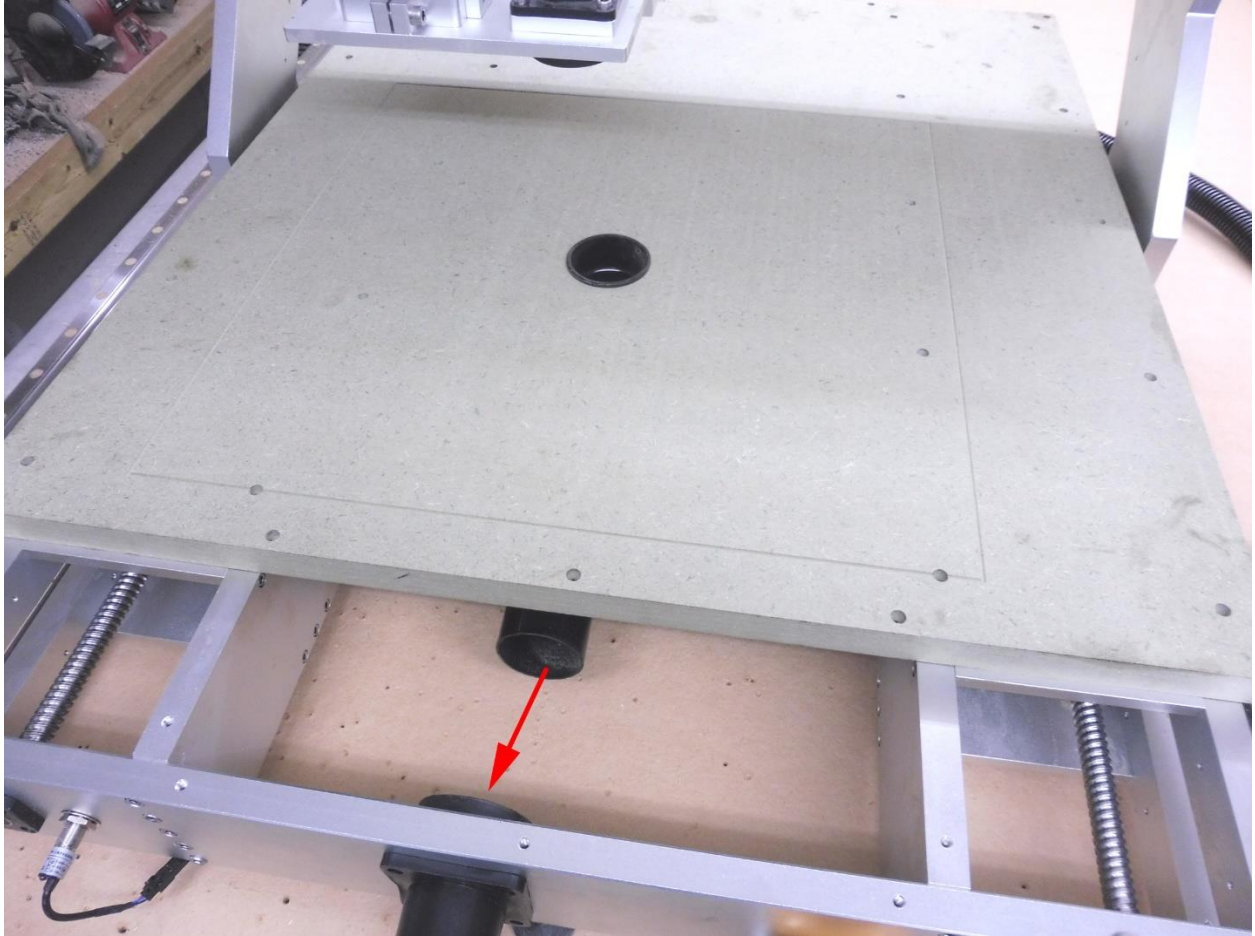
# Build Instructions

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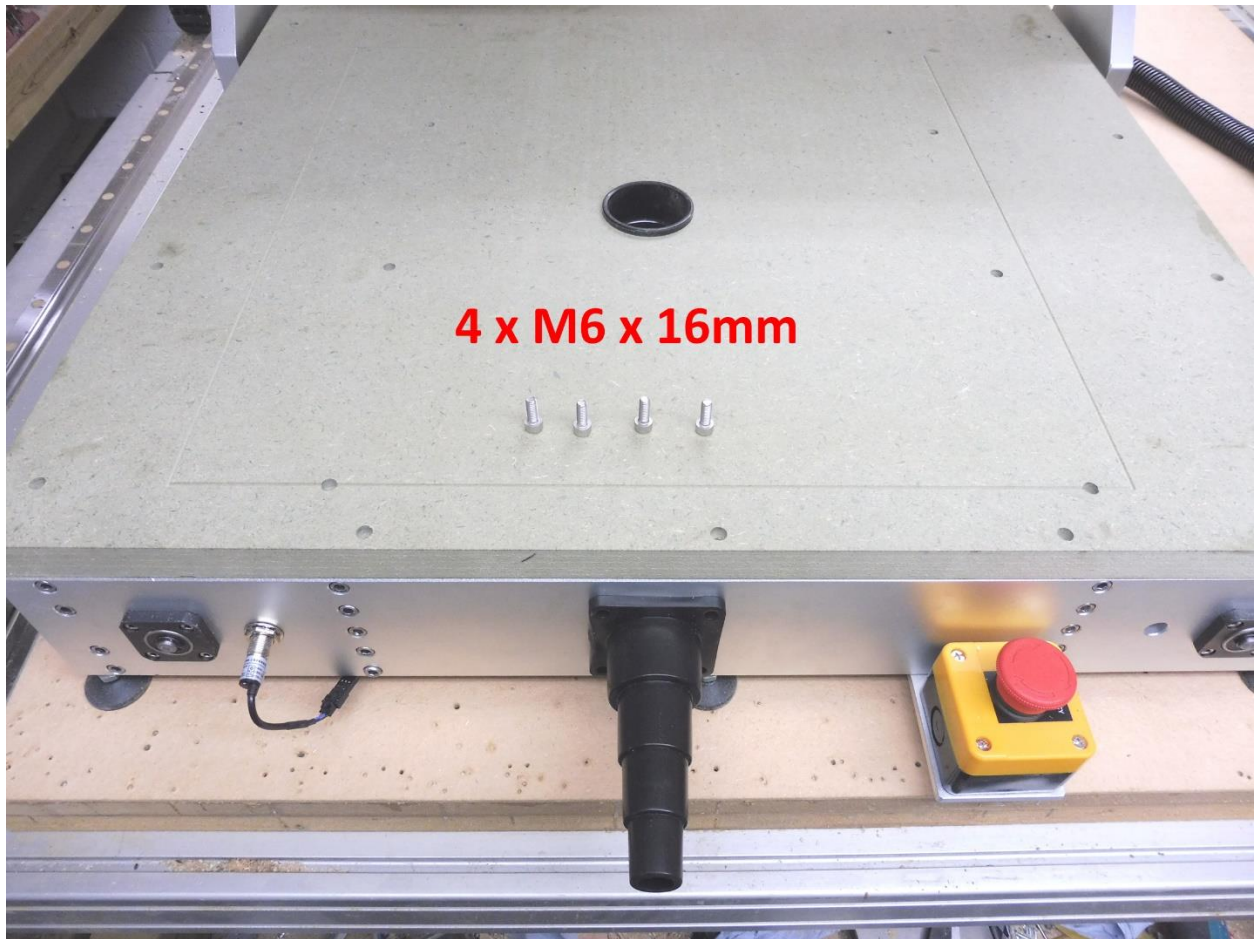




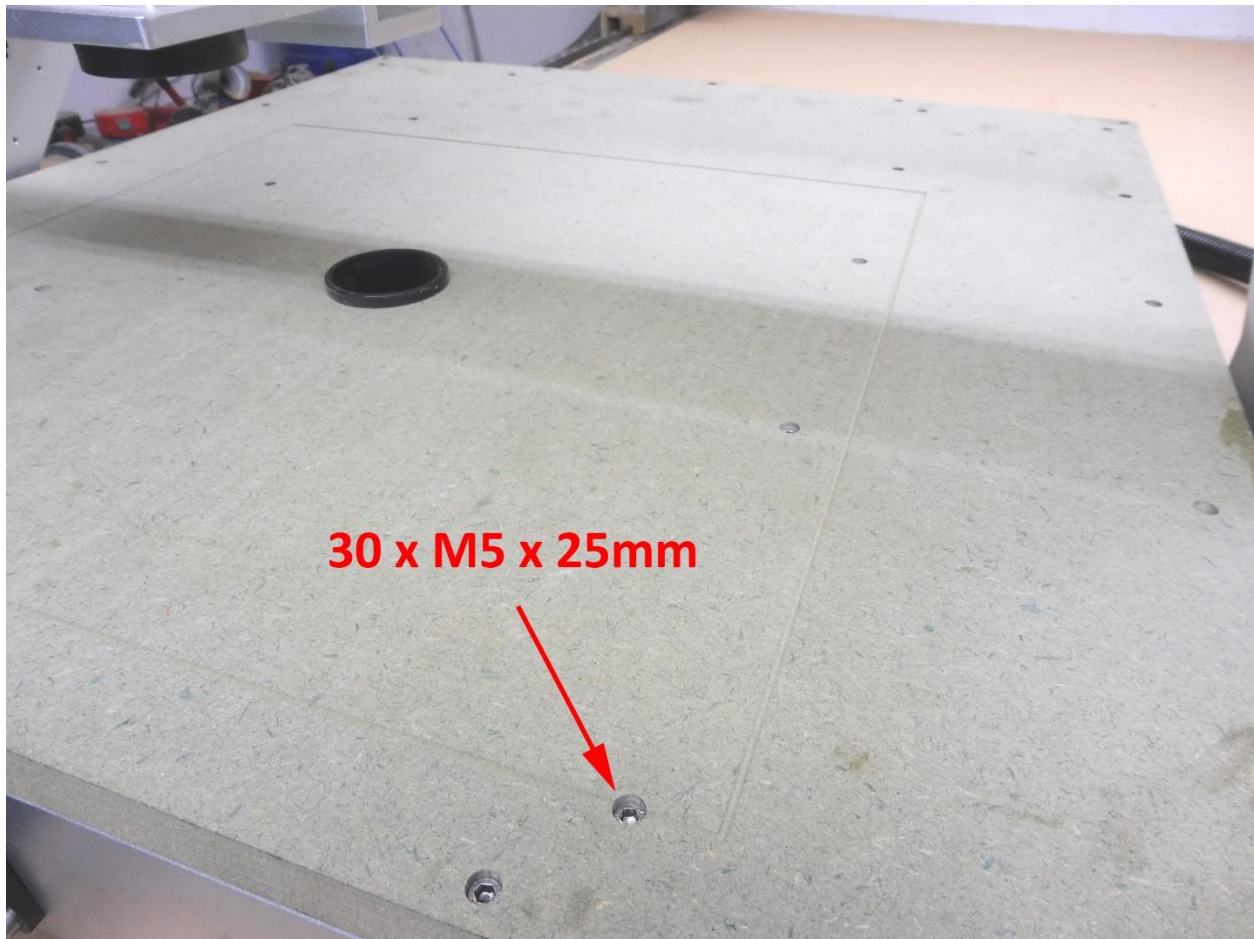
Place the 50mm pipe into the 90-degree angled connector.  
Then push the other end of the connector into the back of the 25mm  
base MDF.



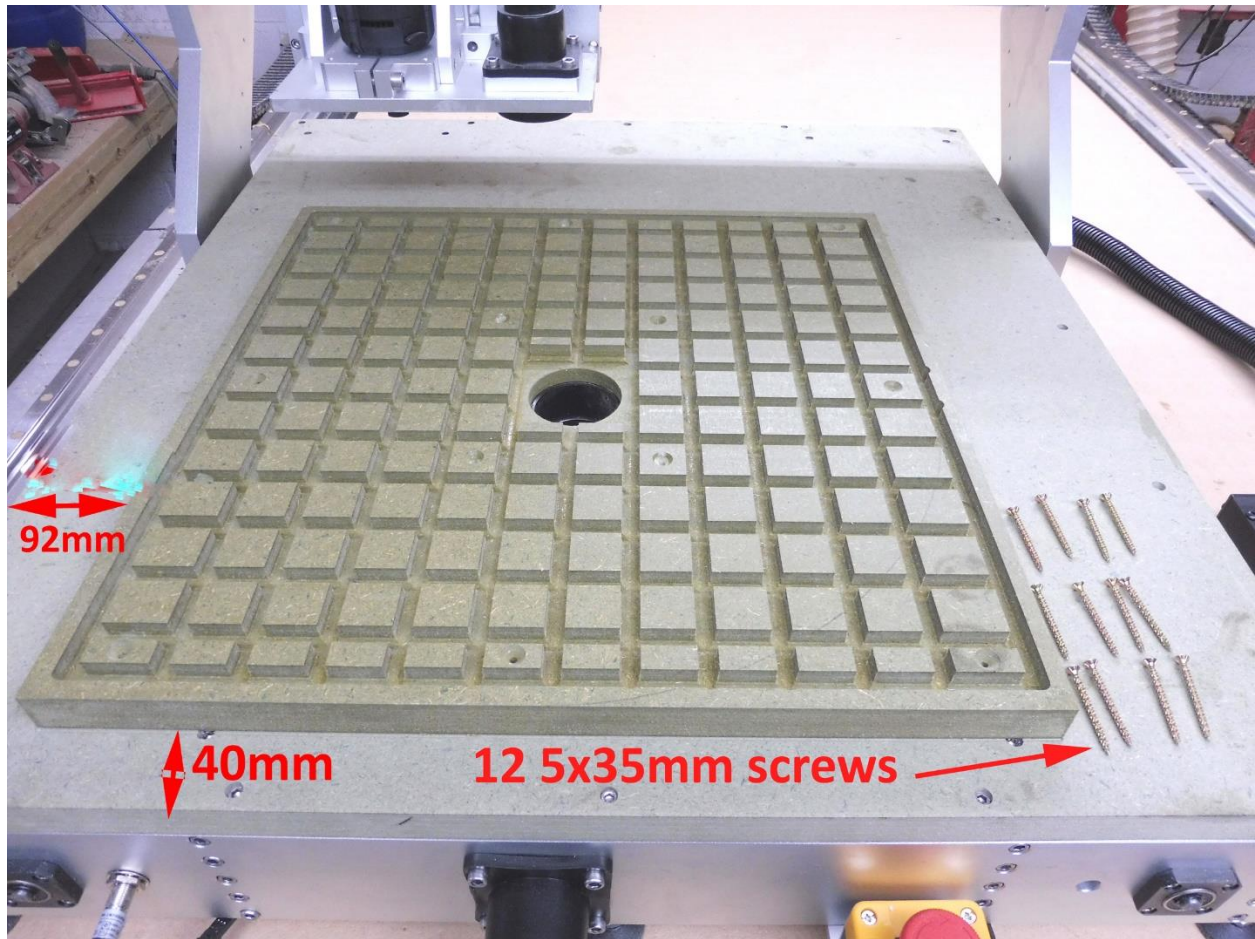
Push the rubber front hose adapter in through the frame.  
Flip the base over and line up with the rubber adapter.  
Make sure the engraved lines on the base match as shown in picture above.



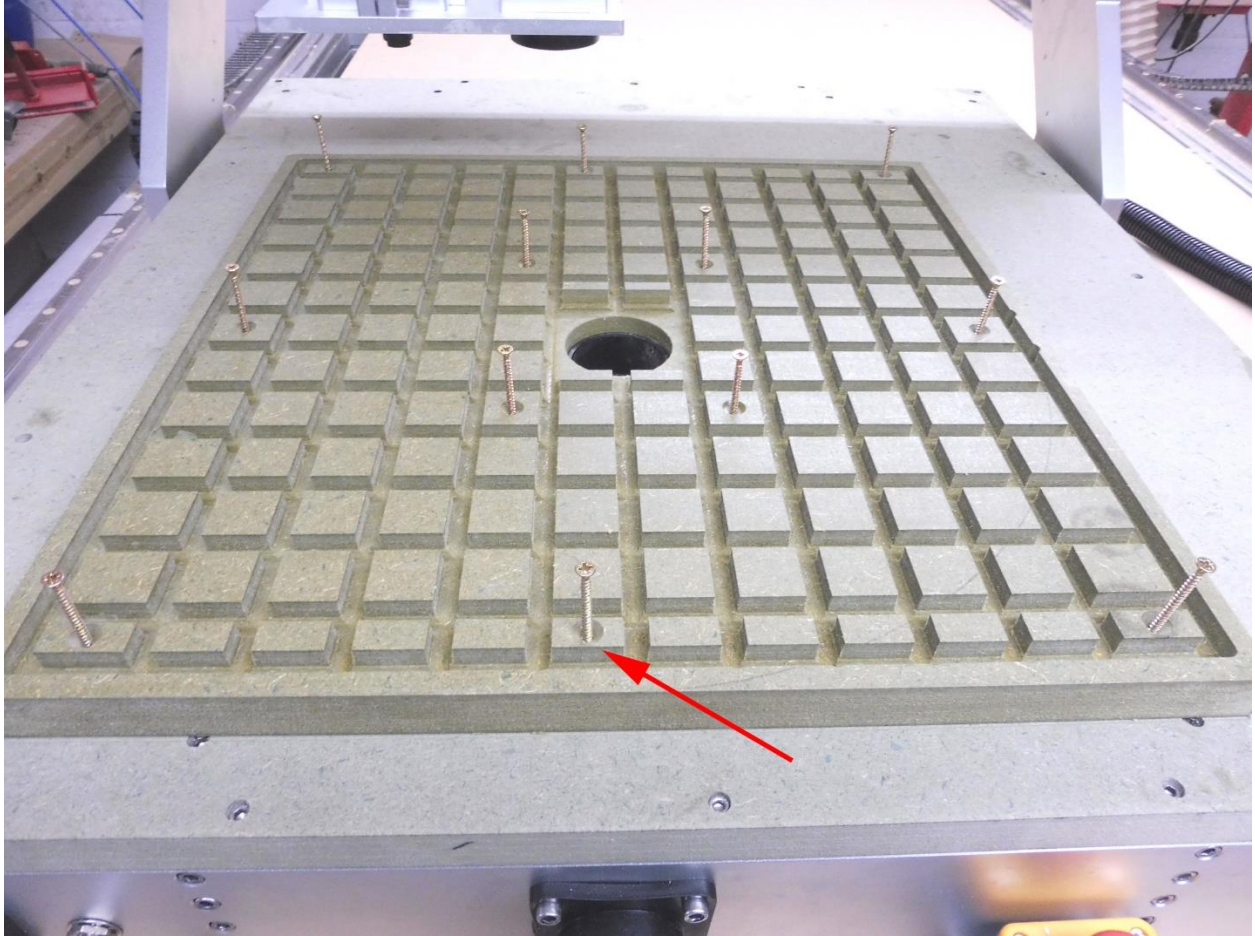
Bolt in the M6 x 16mm screws into the rubber hose adapter.



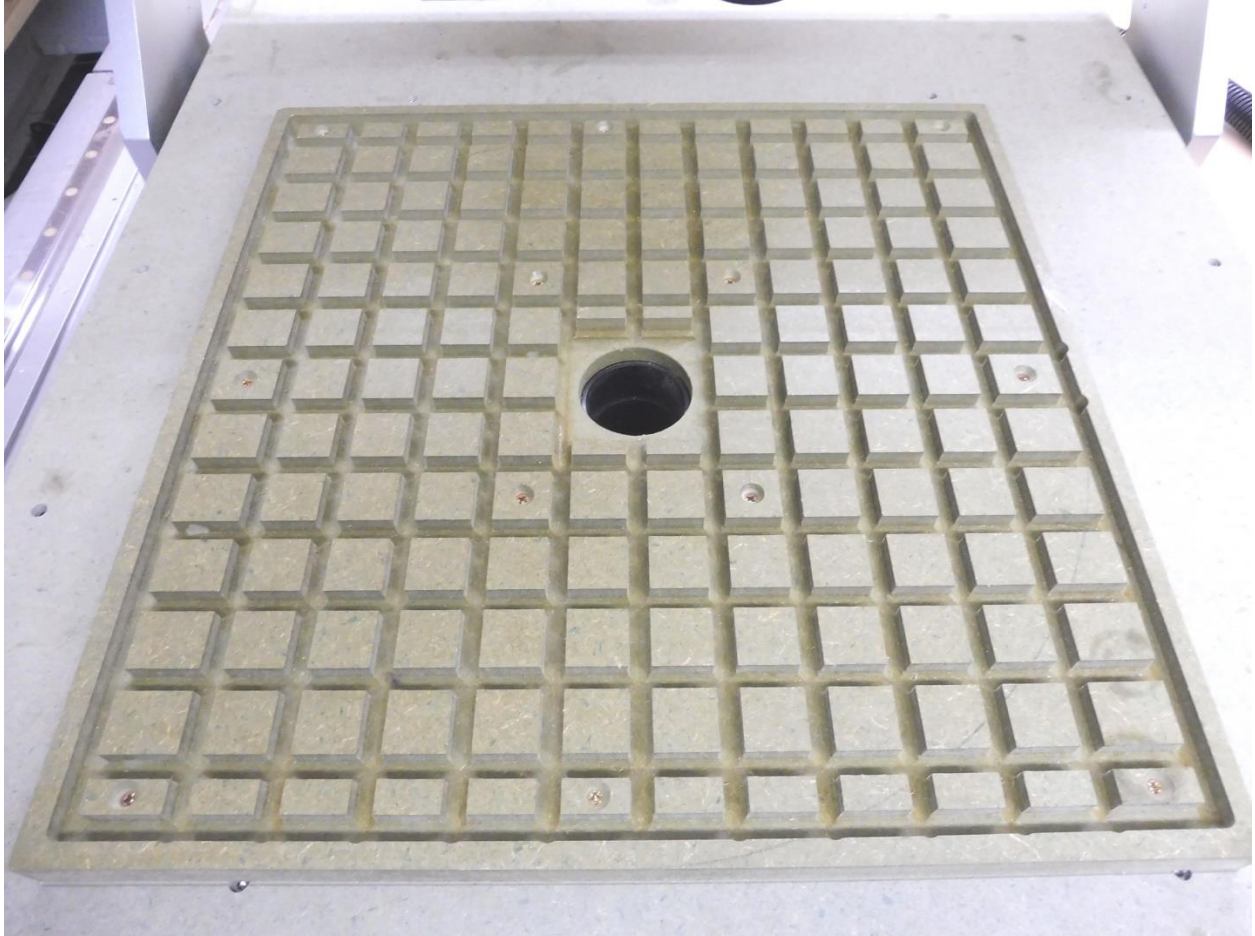
Insert the M5 x 25mm screws into the base and bolt down till level with pockets in the MDF.



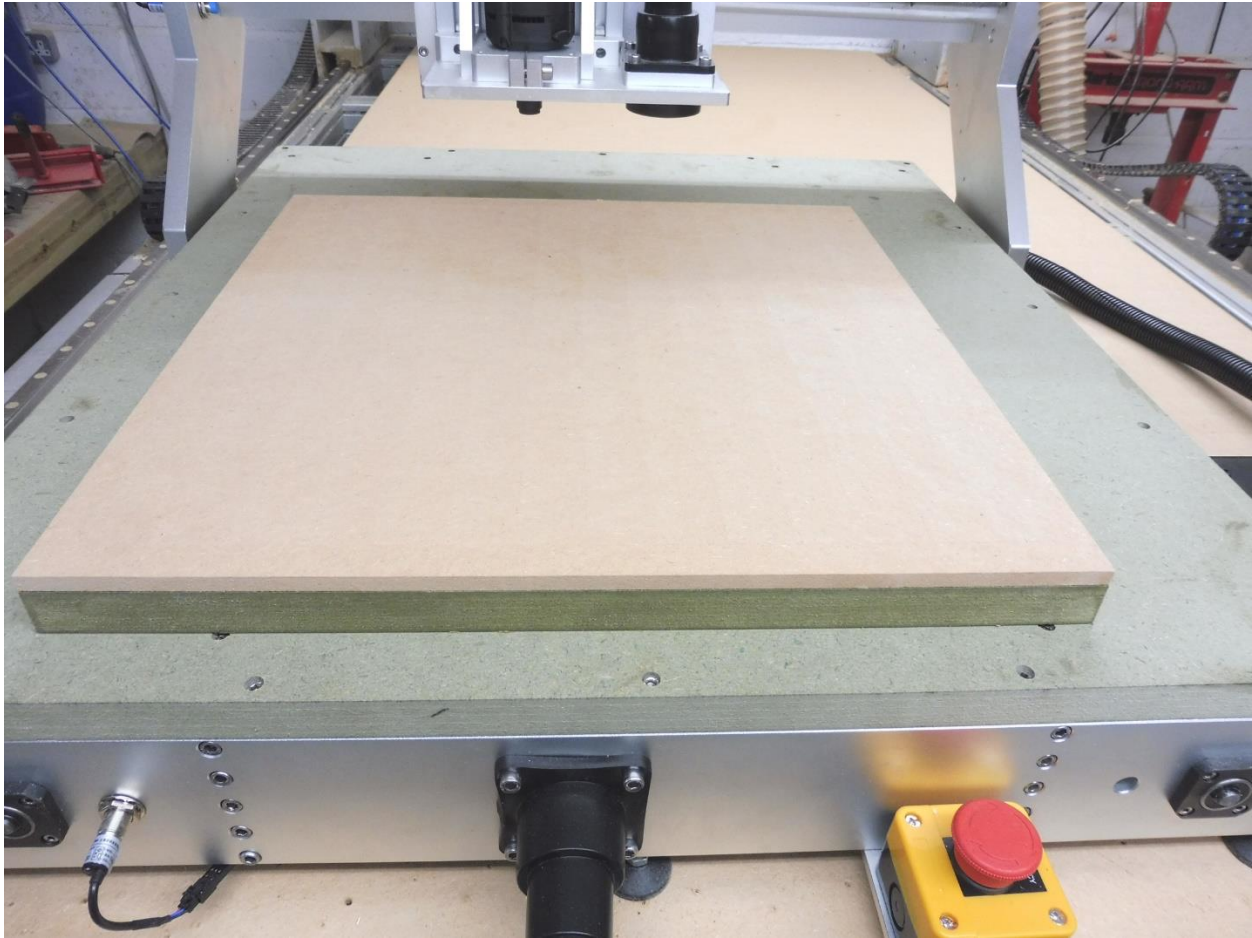
Line up the plenum grid with the engraved lines on the base MDF.  
The plenum grid should be varnished with a couple of coats to make it more air tight and also be dry before using.  
You can either varnish it before you fit it to the base or varnish it afterwards.



Insert the 12 screws into the plenum grid.



Make sure the plenum grid is kept lined up with the engraved lines on the MDF base and screw down nice and tight.



Next place the porous 12mm MDF spoil board on top of the plenum grid.

Now attach your vacuum to the rubber adapter hose and turn on. This should now suck down the spoil board securely to the grid.

You can now skim the top of the spoil board to remove the shiny surface.

Once this side is skimmed, flip it over and skim the other side.

You should only need to skim off approximately 1mm to get rid of the surface and this will then make the spoil board porous and create a thin vacuum across the top of it.

After skimming both sides, some people like to glue down the spoil board and others prefer to leave it loose and let the vacuum hold it in place.

Leaving it loose has the advantage that you do not have to skim the board all the way down to get to the glue when it is time to change it, but you will need to make sure it is aligned each time before placing your work piece on it.