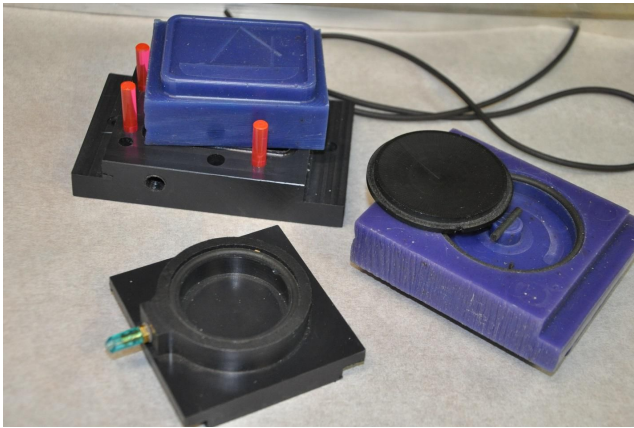


Vacuum holding fixture

Pete Sorenson

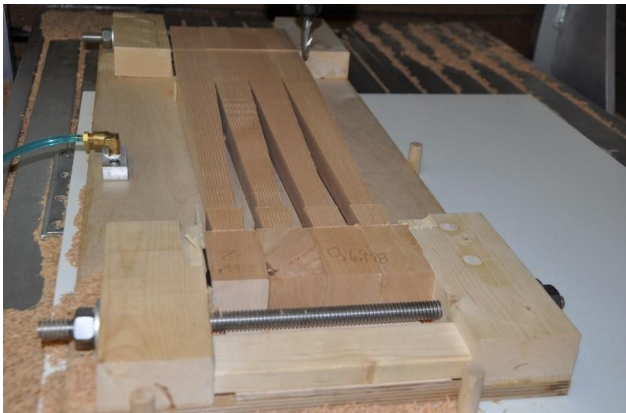
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- 1) Allows the removal and replacing of the part before it is completed.
- 2) There are no metal fasteners in cutter path
- 3) X and Y "Zero" can be a standard location.
- 4) Any "through holes" will need seals.
- 5) Cannot cut through the part



The three fixtures in the picture were designed for small projects. 1) The one with the red pegs has ledges for the hold-down clamps. The red pegs are plastic to avoid dulling the cutter if there is a programming error. 2) The black circular fixture has ledges on the bottom to fit a small vise. It was machined in the vise for a specific project. 3) The Blue Wax fixture is also vise mounted. The ledge on the top side is used to "Zero" the machine relative to the fixture. As it was used for some thin parts it has a support post in the center.

The rubber cord for the seal is **1/8" EPDM closed cell foam. MSC #31944622**



A large dedicated fixture. This made 4 legs at a time. Note that the vacuum connection is on the top of the fixture.



This is the fixture mounting plate showing the arrangement of the 3 pegs to locate a fixture and the 1/8 foam used for a seal. . The seal is held in place with scotch tape.