

Vacuum Clamping Add-on for Project: EVS™, Project V2™, and Project: V4™ Vacuum Press Systems

The Project: EVS, V2, and V4 vacuum press systems can be used for much more than just veneering. With this clamping kit you can use the massive holding power of vacuum to instantly hold work pieces to your bench top for sanding, routing, carving and more. The latching pneumatic foot pedal can instantly apply or release vacuum to or from clamping jigs on your work bench. Vacuum clamping jigs are required to complete this clamping system. We offer everything needed to [make custom jigs](#) or simply order our versatile [Podz™ clamping jigs](#).

By using a 3-way latching foot valve, pressure can be applied to the clamping jigs and release as needed. This kit doesn't force the pump to run continuously. Instead, the pump only runs when the vacuum reservoirs need to be recharged. Whether it's a simple hold down jig or a production run of vacuum template projects, you're going to get a kick out of using the power of vacuum to hold projects in place.

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System Compatibility

This kit is an add-on for the Project V2™, V4™, and EVS™ vacuum press systems.

Parts List



Latching
Foot Valve



1/4" NPT Short
Street Elbow



1/4" NPT Long
Street Elbow



2" Brass
Pipe



Vacuum
Filter



Brass
Barb Elbow



Brass Vacuum
Clamping Fitting



1/4" NPT Brass
Hex Plug



Composite Plastic
Base Plate & Upright



12 Ft. Vacuum
Jig Tube



Miscellaneous
Screws



Thread Sealing
Tape

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Pneumatics Assembly

1. Remove the four rubber feet on the bottom of the foot pedal using a screw driver. Discard the screws but save the rubber feet and the small washers.
2. Use the four #6 x 1/2" coarse-thread screws (included) to attach the rubber feet to the bottom of the composite plastic base plate. Pilot holes are not required for this step. The thicker rubber feet should be attached at the back of the base plate. The thinner rubber feet should be attached at the front of the base plate. Do not over-tighten the screws.
3. Attach the composite plastic "upright" piece to the base. This part fits snugly into the recess in the plastic base plate. Use the included black screws to secure the upright to the base plate. Pilot holes are not required. Do not over-tighten the screws.
4. All metal-to-metal connections will require thread-sealing tape. Wrap the tape clockwise around the fittings. Do not apply the tape to the brass fittings that will be attached to the vacuum filter.
5. Remove the plastic plugs from the three ports on the foot valve.
6. Use an Allen wrench to attach the brass hex plug to the B port on the foot valve.
7. Attach the brass street elbow to port "A" on the foot valve. When it is tight, it should be facing toward the "B" port.
8. Attach the 2" brass pipe to the street elbow from the previous step. The easiest way to tighten this fitting is with a pair of vice-grips. To prevent marring the brass, you can wrap masking tape around the pipe. There is no need to excessively tighten this fitting.
9. Remove the filter cover and filter element from the filter head being careful not to lose the rubber sealing ring inside.
10. Attach the filter head to the brass pipe on the foot pedal assembly. The arrow on the side of the filter head shows the correct direction of the vacuum flow. It should be pointing towards the foot pedal. The filter head is made from a soft composite plastic so be sure to avoid cross-threading as the fittings are attached. When the filter just becomes snug, continue tightening until the filter is parallel to the body of the foot valve as shown in the pictures on the next page. Do not over tighten the brass fittings that attach to the filter head.
11. Re-attach the filter element and filter cover to the filter head.
12. Attach the long brass street elbow to port "P" on the foot valve. When tight, the open port should be facing upward.
13. Attach the brass vacuum clamp fitting to the long brass street elbow.
14. Set the foot pedal assembly onto the composite plastic base plate so that the open port on the vacuum filter is inserted through the hole in the plastic upright support.
15. When positioning the foot pedal assembly, allow 1/8" of space so the clear filter canister can be removed for cleaning. Once the pedal is in the correct position, mark the base plate and drill a 5/32" pilot hole (1/2" deep) at the mounting tab on the left and right sides of the foot pedal.
16. Attach the foot pedal to the base plate with the included #12 x 3/4" screws.
17. Attach the brass barbed elbow to the remaining port on the filter. This fitting should be facing upward when fully tightened. Do not over-tighten this fitting.
18. Attach the blue vacuum jig tubing to the barbed fitting from the previous step. The other end of the tubing is connected to your vacuum clamping jig.

Instructions for Use

The Project: EVS, V2, and V4 vacuum press kits include a "lock-on" connector that is attached to the braided vacuum tube. Clip the lock-on connector to the brass vacuum clamping fitting on the foot pedal assembly. Be sure that the foot pedal is disengaged. Now open the vacuum valve on the vacuum press and turn on the system.

Attach the vacuum tubing from your vacuum jigs to the brass barbed elbow on the foot pedal assembly. Place the clamping jigs on a non-porous surface and set the project piece on top of the vacuum clamps. Depress the foot pedal until it clicks and then release. This will open the flow of vacuum to the jigs and will instantly clamp the project in place.

To release the clamping pressure, depress the foot pedal again.

The final assembly should appear as shown in the pictures below.

