



GRID GASKET APP NOTES

Seal your vacuum grid to reduce leaks under the spoilboard
for stronger, more consistent hold-down of your parts.

WHEN TO USE GRID GASKETING

- When operating any CNC router that relies on vacuum for part-hold.
- When looking to eliminate the need for tabs, extra passes/onion skins due to weak vacuum.
- When spoilboards tend to warp or twist over time causing vacuum loss.

TOOLS & PREP

- Calipers (or a precise ruler) to measure channel width and depth.
- Compressed air + clean rags (keep channels dry and dust-free).
- Scissors/knife for clean cuts.



STEP-BY-STEP (ONE ZONE AT A TIME)



1. Match gasket shape to channel shape:
 - Square channels = square gasket; round channels = round gasket.
2. Measure channel width and depth.
 - Choose gasket with the same width as the channel.
 - Choose gasket so height sits proud about channel by 1/16"
3. Clean channels. Dry-fit a short piece to confirm snug fit.
4. Press gasket into channels (DO NOT STRETCH).
5. Cut butt joints; miter corners; do not overlap; Do not use glues.
6. Reinstall spoilboard, turn vacuum on, confirm board is fully pulled down flush.
7. Surface/flycut as needed to improve vacuum flow.

QUICK ERROR CHECKS

- Leaks could be happening at joints/corners: redo any gaps or overlaps.
- Debris under gasket: clean channels and reinstall.
- Spoilboard not bottoming out: some material might be stuck under spoilboard preventing flush.

MAINTENANCE

- It is recommended to start inspecting Grid Gasket recovery at the 500 hours of machine time.
- A worn gasket results in leaks. Replacing on a scheduled basis maximizes part-hold.

ADDITIONAL ASSISTANCE NEEDED?

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