



IN BOARD 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 IN BOARD GASKET

- When cutting repetitive parts where you want maximum hold and minimal tabs.
- When you are building a Dedicated Fixture (not a sacrificial spoilboard).
- You need consistent cuts, z-depth and repeatability across multiple shifts and programs.

TOOLS & PREP



- Non-porous fixture board (Baltic birch, HDPE)
- Ensure that the vacuum grid table below is properly gasketed, preventing leak
- Optional: Chamfer Bit Tooling to leave a slight chamfer at the top of the gasketing channel to be cut

STEP-BY-STEP

1. Use a non-porous fixture board (this is a fixture, not a spoilboard).
2. Offset your part CAD inward to cut a gasket channel near the toolpath
 - Optional: Chamfer the channel top slightly to prevent pinching and help parts seal flush.
3. Port vacuum through the Dedicated Fixture with holes/slots to feed each part/zone.
4. Create a vacuum cavity (using a grid patten, channels or a pocket) used to extract the air from
5. Install gasket into channels, do not stretch.
6. Gasket should stick proud above channel by 1/16"
7. Gasket for for waste/offcuts so they do not fly off
8. Turn vacuum ON, test with one part, then scale



QUICK ERROR CHECKS

- No downdraft: vacuum must be ported to pockets/areas (holes/slots).
- Pinched gasket: add chamfer/relief and correct gasket height.
- Through-holes in parts? Make sure they to gasket them to ensure 100% vacuum cavity seal.

MAINTENANCE

- Inspect channels and gasket edges regularly; replace gasket when compressed or nicked.

ADDITIONAL ASSISTANCE NEEDED?

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