For safe and effective operation, read these instructions fully before use.
**GENERAL SAFETY WARNINGS**

This tool is designed for specific applications as defined in the instructions and should not be modified and/or used for any other applications. Before using the Vacuum Clamp Pods, read, understand and follow all instructions and safety information provided. **KEEP THESE INSTRUCTIONS FOR FUTURE REFERENCE.**

> For any tool used in conjunction with this product, always read, understand and follow the instructions and safety warnings for that tool.

> Before using this product, review and verify that all tools to be used with it have safety equipment installed and are in proper working order as defined by the tools’ owner’s manuals.

> Do not use this product until you have read and are confident you understand the:

  - Product Specific Safety Warnings (below);
  - Connecting the Vacuum Clamp Pods;
  - Securing Vacuum Pods to T-Track;
  - Securing Vacuum Pods to Another Surface;
  - Using the Vacuum Clamp Pods;
  - Troubleshooting.

> Remain alert and use good judgment when using this tool. Do not use this tool if you are in any way impaired by medications, alcohol, drugs or fatigue.

> Dress appropriately and remove all jewelry, secure loose clothing and tie up long hair before using this tool.

> It is the sole responsibility of the purchaser of this tool to ensure that any third party reads and complies with all the instructions and safety precautions outlined in this manual prior to using the tool.

> Maintain these instructions and warnings as long as you own the tool. Keep this booklet in a place where it will be readily available for reference.

> The user assumes all risk for the proper use of this tool and for ensuring product suitability for intended application.

> Always wear safety glasses in compliance with ANSI safety standards and hearing protection and follow all standard shop safety practices including:

  - Keep your work area well lit and clean;
  - Use dust collection tools and dust face masks to reduce exposure to dust;
  - Use accessory safety equipment such as feather boards, push sticks and push blocks whenever appropriate;
  - Do not use power tools in explosive environments (e.g., in the presence of flammable liquids, fumes or dust);
  - Keep children and bystanders away while operating your tools;
  - Maintain proper footing at all times and do not overreach;
  - Do not force the tool;
  - Unplug all power tools before making any adjustments or changing accessories.

> These warnings and instructions do not represent the total of all information available regarding tool safety, use and technique. Always seek out opportunities to learn more and improve your skills and knowledge.

**WARNING:** Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to www.P65Warnings.ca.gov/wood.

---

**WARNING**

**PRODUCT SPECIFIC SAFETY WARNINGS**

> Vacuum Clamp Pods are recommended for use only when attached to a horizontal surface. Use on a vertical surface increases risk of dangerous workpiece release.

> Always test the strength of the suction hold before machining the workpiece. A weak hold could allow the workpiece to release, potentially causing serious injury.

> The Vacuum Clamp Pods must be attached securely to a work surface and connected to each other and to the vacuum pump.

> The Vacuum Clamp Pods are not for use while making through cuts on the workpiece.

> Use the appropriate number of pods to hold and support your workpiece.

> Avoid large overhangs to reduce risk of workpiece tilting and breaking the vacuum seal.

> Make sure both the surface of the workpiece and the gasket and ball valve of the Vacuum Clamp Pods are clean and free of debris. Any buildup could interfere with the strength of the seal and the pods’ holding power.

> Vacuum hold will be stronger on tighter-grained woods and less-porous materials.

> Do not expose body parts to the vacuum pressure.
Connecting the Vacuum Clamp Pods

If using with the Gast Vacuum Pump Kit (52881, sold separately) or another vacuum pump that generates about 25"Hg of suction, it is recommended that a maximum of four Vacuum Clamp Pods be connected in a series. Additional Vacuum Clamp Pods may be linked if a more powerful vacuum pump is used.

1. Use scissors or a utility knife to carefully cut the included clear rubber tube to sections of desired lengths.

2. One of the Vacuum Clamp Pods will have a brass barb fitting on one side and a brass plug fitting on the other. Push the end of one section of PVC tubing onto the brass barb fitting on that Pod until it passes at least the third barb. Fig. 1.

   NOTICE: Do not use soap or any other lubricant on the brass barb fitting to make the tubing slide on easier. Lubricant could compromise the seal or be drawn into the vacuum pump, potentially causing damage.

3. Press the other end of that section of tubing onto one of the brass barb fittings on the other Vacuum Clamp Pod, again until it passes at least the third barb.

4. Press one end of the remaining section of tubing onto the other brass barb fitting on the second Vacuum Clamp Pod as you did on the others.

5. Press the connector fitting from the pump into the other end of that section of tubing.

Connecting additional pods to the series: Use a 1/2" wrench to unscrew and remove the brass plug fitting from the last Vacuum Clamp Pod and replace with the included extra brass barb fitting. Fig. 2. Then connect to the additional pods with tubing. Additional 8' sections of tubing are available (58991, sold separately).

Removing tubing from the brass barb fittings: Carefully cut the tubing away at the end of the fitting. Then cut the tubing that remains on the fitting lengthwise along the fitting and peel it away.

Securing Vacuum Pods to T-Tracks

1. Install the T-bolts in the larger holes in the metal tabs on the Vacuum Clamp Pods and thread on the flip-down knobs.

2. Slide the Vacuum Pods' T-bolts into the T-track and position as desired. Fig. 3. Tighten the flip-down knobs to secure.

Securing Vacuum Pods to Another Surface

1. Position the Vacuum Pods as desired on the work surface. Fig. 3.

2. Drive panhead screws (not included) through the small holes in the metal tabs to secure.

Using the Vacuum Clamp Pods

1. Turn on the vacuum pump.

2. Position the workpiece as desired and press it onto the Vacuum Clamp Pods, checking to be sure that all pods are engaged. Depending on the flatness of your material, you might need to apply pressure at different points on the workpiece.

   NOTICE: Make sure that the workpiece covers the entire top surface of all Vacuum Clamp Pods to create a tight seal; otherwise, vacuum pressure cannot be achieved.

3. Once all Vacuum Clamp Pods are engaged, check the pressure gauge on the vacuum pump to be sure that it’s maintaining suction.

4. Push and pull on the workpiece to verify a strong hold.

WARNING: Always test the strength of the suction hold before machining the workpiece. A weak hold could allow the workpiece to release, potentially causing serious injury.

5. To release the workpiece, turn off or unplug the vacuum pump and wait a few seconds for the the suction to let go.

Check Rockler.com for updates. If you have further questions, please contact our Technical Support Department at 1-800-260-9663 or support@rockler.com
## Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Potential Cause</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>No vacuum pressure</td>
<td>Improperly connected tubing</td>
<td>At each brass barbed fitting, make sure the end of the tube has been advanced past at least three barbs.</td>
</tr>
<tr>
<td></td>
<td>Loose fittings</td>
<td>Check all brass fittings and tighten with a 1/2&quot; wrench, if necessary.</td>
</tr>
<tr>
<td></td>
<td>Compressed or kinked tubing</td>
<td>Make sure nothing is squeezing the tubing and that the tubing has no kinks.</td>
</tr>
<tr>
<td></td>
<td>Hole or other damage in tubing</td>
<td>Cut away damaged section and reconnect or install replacement hose (58991, sold separately).</td>
</tr>
<tr>
<td></td>
<td>Ball valve is stuck open by debris</td>
<td>Turn pod upside down and push on valve until debris falls out.</td>
</tr>
<tr>
<td></td>
<td>Dusty workpiece or Vacuum Clamp Pods</td>
<td>Wipe, vacuum or blow away dust from workpiece and pods.</td>
</tr>
<tr>
<td></td>
<td>Uneven mounting surface</td>
<td>Make sure the Vacuum Clamp Pods are mounted on a flat surface.</td>
</tr>
<tr>
<td></td>
<td>Uneven workpiece</td>
<td>If workpiece is warped, try to reposition. If workpiece is severely warped, another hold-down method might be required.</td>
</tr>
<tr>
<td></td>
<td>Porous material or defect (such as a knot or crack) in the workpiece</td>
<td>Try to reposition the workpiece. If workpiece is excessively porous, another hold-down method might be required.</td>
</tr>
<tr>
<td></td>
<td>Improper positioning of workpiece</td>
<td>Make sure the workpiece doesn’t overhang the Vacuum Clamp Pods too far.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Make sure that the workpiece covers the entire top surface of all Vacuum Clamp Pods to create a tight seal.</td>
</tr>
<tr>
<td></td>
<td>Damaged gasket on pod</td>
<td>Replace with included extra gasket. A 4-pack of replacement gaskets also is available (51231, sold separately).</td>
</tr>
</tbody>
</table>