VACUUM CNC

Vacuum clamping for cnc machines

Catalogue 2025

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Vacuum-CNC

Vacuum-CNC is a Spanish company specialized in vacuum clamping solutions for numerical control machines.
Thanks to its experience and knowledge in the wood industry, it has developed and patented an innovative vacuum pod system, with the brand's own characteristics: speed, simplicity, efficiency and savings. Furthermore, at Vacuum-CNC we work every day to improve our systems and obtain new products that facilitate the work of our clients.
All this has consolidated the brand internationally, showing itself as a real alternative to the clamping solutions existing until now on the market.

SISTEMA VACUUM-CNC

The main difference between our brand and others consists on separate the vacuum block in two pieces, base (inferior black part in contact with the milling center) and the cup (superior red part which holds the board or the piece to work out), this division offers quite huge advantages:

- Easy and fast to exchange the suction area.

- All the cups turn 360 degrees staying fixed when turning on the vacuum.

- It allows us to work at many different heights:
    - By fixing intermediate lifters between the base and the cup.
    - By placing cups of different heights.

- All of our vacuum cups have touch valve, so we can hold the vacuum block on the table even if they do not need to be used without losing vacuum.

- It allows, in case of a broken cup or need of a new suction area, to replace only the cup, what leads to a significant economic saving.

- The cups enclose the superior vacuum by a sealing rubber, very affordable and easy to replace. If It gets broken (until a 7mm depth) we can fix the vacuum cup at 100% of its capacity simply by changing the damaged gum part.

- For enterprises that have more than one mechanising centre with different vacuum cups, thanks to our system in two pieces it could be studied the point of combining the heights so that we can use the same cups in both milling centres (sometimes it may be necessary to change the height in which it works, otherwise, the combination is not possible).

- For the majority of models it exists the cup system with board lifter, very useful for sliding and placing the tabletop on the machine, mainly in nesting table machines.

"Compact" System

The compact is the simplest model. It is made in one piece, with no possibility of turning or change the suction surface.
However, in some models we have found it interesting to manufacture it, offering a cheaper option in those cases that do not require the versatility of the Vacuum-cnc System.
Thanks to being made of technical plastic, It won't affect the mill in case of an accident.
As long as it's possible, It will include the spotted tablet to create different suction zones or to enlarge its useful life.
All the vacuum cups have a touch valve which retains the vacuum.
For the compact system it also exists the possibility of adding the rise panel option.

VACUUM BLOCK BS01

FOR SCM AND MORBIDELLI

Vacuum block for different models of SCM and Mordibelli. Due to the technical plastic used, the legs won't stretch as the original ones, which its fixation to the bar decreases with the use.
This model takes all the advantages of the Vacuum-cnc system.

BASES

Standard set (Base + Cup): 120 X 120 X 32.7 mm

(Different heights available)

MEASURES:

120 X 120 X 17.7 mm

Alongside the CA cups of 15 mm gives the height of the manufacturer (32.7 mm)

BS01N

- BS01N Standard base

BS01R

- BS01R Base with hose connection: For machines with vacuum direct to the vacuum block

CUPS

CA12015T
120 x 120 x 15

CA10015T
120 x 100 x 15

CA08015N
120 x 80 x 15

CA07015N
120 x 70 x 15

CA06015N
120 x 60 x 15

CA05015N
120 x 50 x 15

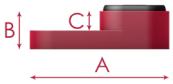
CA04015N
120 x 40 x 15

CA03515N
120 x 35 x 15

CA03015N
120 x 30 x 15

CA05015D
120 x 50 x 15

CA05015L
120 x 50 x 15

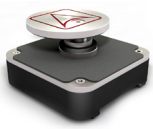


A: 120 B: 15 C: 7

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR01N



MEASURES:

120 X 120 X 32.7 mm

*SCM / Morbidelli is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers CNC of SCM / Morbidelli.

VACUUM BLOCK BS03

FOR SCM AND MORBIDELLI

The base gets screwed only once, from there we will have all the options of the Vacuum-cnc system.
It has a metal plaque of 3 mm which makes it totally rigid at the time of screwing.
In difference with the original ones, this system allows us working with narrow cups and realising every kind of tasks. Both in the Vacuum-cnc and in the compact model we will maintain the height of the manufacturer.

Standard set (Base + Cup): **158 X 120 X 21.4 mm**

(Differents heights available)

BASES

BS03N

MEDIDAS:
158 X 120 X 6.4 mm
Alongside the CB cups of 15 mm gives the height of the manufacturer.
(21.4 mm)

CUPS

CB12015T
158 x 120 x 15

CB10015T
158 x 100 x 15

CB08015N
158 x 80 x 15

CB07015N
158 x 70 x 15

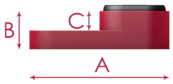
CB06015N
158 x 60 x 15

CB05015N
158 x 50 x 15

CB04015N
158 x 40 x 15

CB03515N
158 x 35 x 15

CB03015N
158 x 30 x 15



A: 120 B: 15 C: 7

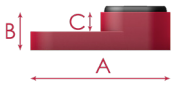
COMPACT

KB03-12021T
158 x 120 x 21.4

KB03-07021T
158 x 70 x 21.4

KB03-06021T
158 x 60 x 21.4

Underside



A: 120 B: 21.4 C: 7

*(Possibility of making different heights and shapes depending on the customer needs).

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VACUUM BLOCK BS05

FOR SCM AND MORBIDELLI

Vacuum block for different models of SCM. Due to the technical plastic used, the legs won't stretch as the original ones, which it's fixation to the bar decreases by the use.
This model takes all the advantages of the Vacuum-cnc system.

Standard set (Base + Cup): **145 X 145 X 50 mm**

(Different heights available)

BASES

BS05N

MEASURES:
145 X 145 X 20 mm
Alongside the CC of 30 mm gives the height of the manufacturer.
(50 mm)

CUPS

CC14530T
145 x 145 x 30

CC10030T
145 x 100 x 30

CC08030N
145 x 80 x 30

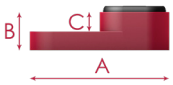
CC07030N
145 x 70 x 30

CC06030N
145 x 60 x 30

CC05030N
145 x 50 x 30

CC04030N
145 x 40 x 30

CC03530N
145 x 35 x 30

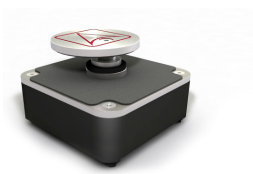


A: 145 B: 30 C: 18

*(Possibility of making different heights and shapes depending on the customer needs)

CLAMPS

PR05N



MEASURES:
145 X 145 X 50 mm

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VACUUM BLOCK BS08

FOR SCM AND MORBIDELLI

The base it's screwed only once, from there we will have all the options from the Vacuum-cnc system. It incorporates a metal plaque of 3 mm which gives a total rigidity when it comes to screwing. In difference with the original ones it allows us to work with narrow cups and realize every kind of tasks.In the compact model we'll keep the manufacturer's height.

Standard set (Base + Cup): **158 X 120 X 35.4 mm**

(Different heights available)

BASES

BS08N

MEASURES:

158 X 120 X 20.4 mm

Alongside CB cups of 15 mm gives the height of the manufacturer (35.4 mm)

CUPS

CB12015T
158 x 120 x 15

CB10015T
158 x 100 x 15

CB08015N
158 x 80 x 15

CB07015N
158 x 70 x 15

CB06015N
158 x 60 x 15

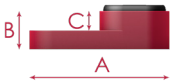
CB05015N
158 x 50 x 15

CB04015N
158 x 40 x 15

CB03515N
158 x 35 x 15

CB03015N
158 x 30 x 15

CB05015L
158 x 50 x 15



A: 120 B: 15 C: 7

COMPACT

KB08-12035T
158 x 120 x 35.4

KB08-07035N
158 x 70 x 35.4

KB08-06035N
158 x 60 x 35.4

Underside

A: 120 B: 35 C: 7

*(Possibility of making different heights and shapes depending on the customer needs).

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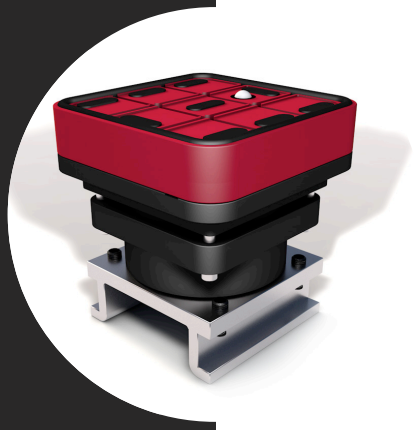


VACUUM BLOCK BS09

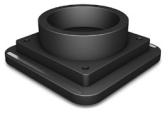
FOR SCM AND MORBIDELLI (Tech Z25)

Suction cup model designed to work above the bars of the machine, achieving a much larger suction surface and greater grip. This also allows cutting or drilling the boards without damaging surfaces. This model is compatible with multiple interchangeable suction cups of different sizes, including the panel lifter system (CC14530P).
This model takes advantage of all the advantages of the Vacuum-cnc system.

Standard set (Base + Cup): **145 X 145 X 32 / 42 mm**
(Different heights available)

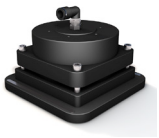
BASES

BS09N

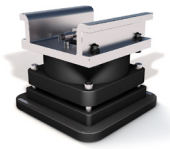


MEASURES:
145 X 145 X 55 mm (12 mm over the bars)
Alongside CC cups of 20 o 30 mm gives the height of the manufacturer (32 o 42 mm). It can be used on models where the original metal cylinder can be used. Otherwise it is necessary to use the BS09C.

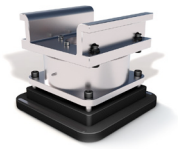
BS09C



MEASURES:
145 X 145 X 85 mm (12 mm over the bars)
It is placed directly over the original support, in case the original metal cylinder is not available.



BS09C + Original support*



BS09N + Original support and cylinder*

* Vacuum cnc does not sell the original support and the original metal cylinder.

CUPS

CC14520TR
145 x 145 x 20

CC10020TR
145 x 100 x 20

CC08020R
145 x 80 x 20

CC07020R
145 x 70 x 20

A: 145 B: 20 C: 10

CC06020R
145 x 60 x 20

CC05020R
145 x 50 x 20

CC04020R
145 x 40 x 20

CC14530TR
145 x 145 x 30

CC10030TR
145 x 100 x 30

CC08030R
145 x 80 x 30

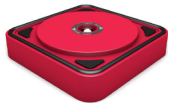
CC07030R
145 x 70 x 30

A: 145 B: 30 C: 18

CC06030R
145 x 60 x 30

CC05030R
145 x 50 x 30

CC04030R
145 x 40 x 30



CC14530P
145 x 35 x 30

*(Possibility of making different heights and shapes depending on the customer needs).

*SCM / Morbidelli is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of SCM / Morbidelli.

VACUUM BLOCK BS14

FOR MORBIDELLI PLANET

Big and sturdy vacuum blocks, especial for machines with edgebander included. Due to the technical plastic used, the legs won't stretch as the original ones, which it's fixation to the bar decreases by the use.
This model makes use of all the advantages from the Vacuum-cnc system.

Standard set (Base + Cup): **145 X 145 X 110 mm**

(Different heights available)

BASES

BS14N

MEASURES:
145 X 145 X 36 mm
Alongside CN cups of 74 mm gives the height of the manufacturer (110 mm)

CUPS

CN14574T
145 x 145 x 74

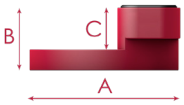
CN10074T
145 x 100 x 74

CN08074N
145 x 80 x 74

CN07074N
145 x 70 x 74

CN06074N
145 x 60 x 74

CN05074N
145 x 50 x 74



A: 145 B: 74 C: 54

*(Possibility of making different heights and shapes depending on the customer needs).

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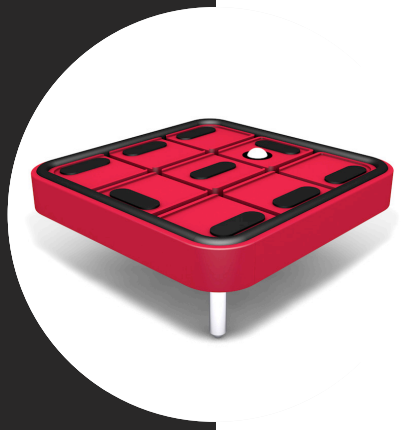


VACUUM BLOCK KC24

FOR SCM AND MORBIDELLI (Tech Z25)

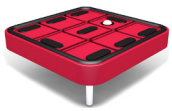
This kind of vacuum pod is placed over the original, allowing to lift the height of work beneath the bars.
Thanks to it we can outline the pieces, make passing mills and drills.
It's only made the compact model, the turn remains at 90 degrees.

COMPACT

Standard Measures: **145 X 145 X 20 mm**

(Different heights available)

KC24-14520T

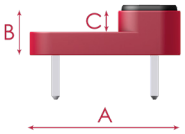


MEASURES:
145 X 145 X 20 mm

Underside

KC24-06020N

MEASURES:
145 X 60 X 20 mm



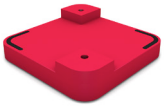
A: 145 B: 20 C: 10

KC24-05020N

MEASURES:
145 X 50 X 20 mm

KC24-14520I

MEASURES:
145 X 145 X 20 mm



Underside

*(Possibility of making different heights, shapes and suction areas depending on the customer needs).

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VACUUM BLOCK BS28

FOR SCM AND MORBIDELLI

This model can be coupled to both self-positioning and manual positioning consoles.
The plastic material of which are made protects the tools of being broken in case of crash.
This model takes advantage of the Vacuum-cnc system.

Standard set (Base + Cup): **145 X 145 X 50 / 75 mm**

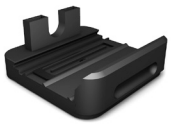
(Different heights available)

BASES

BS28N

MEASURES:
145 X 145 X 20 mm
Alongside CC cups of 30 mm and 55 mm gives the height of the manufacturer (50 mm and 75 mm).

BS28G



- **BS28N Standard Base**
- **BS28S Base with self-positioning support**

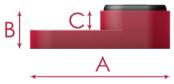
CUPS

CC14530T
145 x 145 x 30

CC10030T
145 x 100 x 30

CC08030N
145 x 80 x 30

CC07030N
145 x 70 x 30



A: 145 B: 30 C: 18

CC06030N
145 x 60 x 30

CC05030N
145 x 50 x 30

CC04030N
145 x 40 x 30

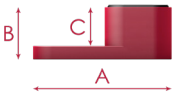
CC03530N
145 x 35 x 30

CC14555T
145 x 145 x 55

CC10055T
145 x 100 x 55

CC08055N
145 x 80 x 55

CC07055N
145 x 70 x 55



A: 145 B: 55 C: 40

CC06055N
145 x 60 x 55

CC05055N
145 x 50 x 55

CC04055N
145 x 40 x 55

CC03555N
145 x 35 x 55

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR28N

MEASURES:
145 X 145 X 50 / 75 mm

*SCM / Morbidelli is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of SCM / Morbidelli.

VACUUM BLOCK BS13

FOR CONSOLES OF 1 CIRCUIT HOMAG, MASTERWOOD, FELDER, WEEKE AND OTHERS

Vacuum block of one circuit with numerous options of suction areas.
It offers a huge grip to the bars thanks to our patented rubber.
Improved triggers that guarantee a great durability and a greater using comfort.
This model takes advantage of all the Vacuum-cnc system.

Standard set (Base + Cup): **120 X 158 X 50 mm**

(Different heights available)

BASES

BS13N

MEASURES:
120 X 158 X 30 mm
Alongside CV or CB cups of 20 mm gives a height of the manufacturer (50 mm)

CUPS

CV15820T
120 x 158 x 20

CV10020T
120 x 100 x 20

CV08020N
120 x 80 x 20

CV07020N
120 x 70 x 20

CV06020N
120 x 60 x 20

CV05020N
120 x 50 x 20

CV04020N
120 x 40 x 20

A: 158 B: 20 C: 10

CB12020T
158 x 120 x 20

CB10020T
158 x 100 x 20

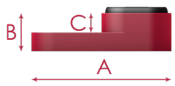
CB08020N
158 x 80 x 20

CB07020N
158 x 70 x 20

CB06020N
158 x 60 x 20

CB05020N
158 x 50 x 20

CB04020N
158 x 40 x 20

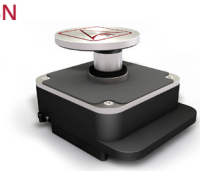


A: 120 B: 20 C: 10

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR13N



MEASURES:
158 X 120 X 50 mm

*Homag, Masterwood and Felder is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Homag, Masterwood, Felder and more.

VACUUM BLOCK BS13-40

FOR CONSOLES OF 1 CIRCUIT HOMAG, MASTERWOOD, FELDER, WEEKE AND OTHERS

Vacuum block of one circuit with numerous options of suction areas.
It offers a huge grip to the bars thanks to our patented rubber.
Improved triggers that guarantee a great durability and a greater using comfort.
This model takes advantage of all the Vacuum-cnc system.

Standard set (Base + Cup): **120 X 158 X 100 mm**

(Different heights available)

BASES

BS13N-40

MEASURES:
120 X 158 X 40 mm
Alongside CM cups of 60 mm gives a height of 100 mm.

CUPS

CM15860T
120 x 158 x 60

CM12060T
120 x 120 x 60

CM10060T
120 x 100 x 60

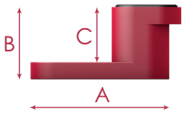
CM08060N
120 x 80 x 60

CM07060N
120 x 70 x 60

CM06060N
120 x 60 x 60

CM05060N
120 x 50 x 60

CM04060N
120 x 40 x 60



A: 145 B: 60 C: 45

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR11N

MEASURES:
158 X 120 X 100 mm

*Homag, Masterwood and Felder is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Homag, Masterwood, Felder and more.

VACUUM BLOCK BS13-51

FOR CONSOLES OF 1 CIRCUIT HOMAG, MASTERWOOD, FELDER, WEEKE AND OTHERS

Vacuum block of one circuit with numerous options of suction areas.
It offers a huge grip to the bars thanks to our patented rubber.
Improved triggers that guarantee a great durability and a greater using comfort.
This model takes advantage of all the Vacuum-cnc system.

Standard set (Base + Cup): 120 X 158 X 125 mm

(Different heights available)

BASES

BS13N-51

MEASURES:
120 X 158 X 51 mm
Alongside CM cups of 74 mm gives a height of 125 mm.

CUPS

CM15874T
120 x 158 x 74

CM12074T
120 x 120 x 74

CM10074T
120 x 100 x 74

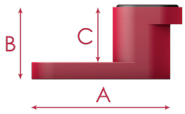
CM08074N
120 x 80 x 74

CM07074N
120 x 70 x 74

CM06074N
120 x 60 x 74

CM05074N
120 x 50 x 74

CM04074N
120 x 40 x 74



A: 145 B: 74 C: 59

*(Possibility of making different heights and shapes depending on the customer needs).

*Homag, Masterwood and Felder is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Homag, Masterwood, Felder and more.

VACUUM BLOCK BS17

FOR CONSOLES OF 2 CIRCUITS HOMAG, MASTERWOOD, FELDER, WEEKE AND MORE

Vacuum cup of double circuit very versatile, as it offers a lot of alternatives of both heights and suction areas.
It possesses a great grip to the bars thanks to its patented rubber by Vacuum-cnc.
This model takes advantage of all the Vacuum-cnc system.

Standard set (Base + Cup): **120 X 158 X 50 / 75 / 100 / 125 mm**

(Different heights available)

BASES

BS17N-40

MEASURES:
120 X 158 X 40 mm
Alongside the CM cups of 60 mm gives the height of the manufacturer (100 mm).

BS17N-51

MEASURES:
120 X 158 X 51 mm
Alongside the CM cups of 74 mm gives the height of the manufacturer (125 mm).

BS17N-25

MEASURES:
120 X 158 X 25 mm
Alongside the CB or CV cups of 25 mm gives the height of the manufacturer (50 mm and 75 mm).

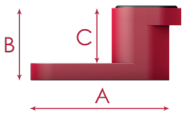
CUPS

CM15860T
120 x 158 x 60

CM12060T
120 x 120 x 60

CM10060T
120 x 100 x 60

CM08060N
120 x 80 x 60



A: 145 B: 60 C: 45

CM07060N
120 x 70 x 60

CM06060N
120 x 60 x 60

CM05060N
120 x 50 x 60

CM04060N
120 x 40 x 60

CV15825T
120 x 158 x 25

CV07025N
120 x 70 x 25

CV06025N
120 x 60 x 25

A: 158 B: 25 C: 13

CB12025T
158 x 120 x 25

CB07025N
158 x 70 x 25

CB06025N
158 x 60 x 25

A: 120 B: 25 C: 13

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR17N

MEASURES:
158 X 120 X 100 / 50 mm

*Homag, Masterwood and Felder is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Homag, Masterwood, Felder and more.

VACUUM CNC

VACUUM BLOCK BS18

FOR CONSOLES OF 2 CIRCUITS HOMAG, MASTERWOOD, FELDER, WEEKE AND MORE

Vacuum cup of double circuit very versatile, as it offers a wide range of alternatives both of height and suction. It possesses a great grip to the bars thanks to its patented rubber by Vacuum cnc. The difference with the BS17 is that the bottom rubber is cut 20 mm respect to the base length, what is necessary for certain models of consoles.

Standard set (Base + Cup): **120 X 158 X 50 / 75 / 100 / 125 mm**

(Different heights available)

BASES

BS18N-40

MEASURES:
120 X 158 X 40 mm
Alongside the CM cups of 60 mm gives the height of the manufacturer (100 mm).

BS18N-25

MEASURES:
120 X 158 X 25 mm
Alongside the CB or CV cups of 25 mm gives the height of the manufacturer (50 mm and 75 mm).

BS18N-51

MEASURES:
120 X 158 X 51 mm
Alongside the CM cups of 74 mm gives the height of the manufacturer (125 mm).

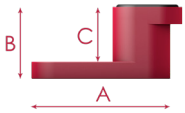
CUPS

CM15860T
120 x 158 x 60

CM12060T
120 x 120 x 60

CM10060T
120 x 100 x 60

CM08060N
120 x 80 x 60



A: 145 B: 60 C: 45

CM07060N
120 x 70 x 60

CM06060N
120 x 60 x 60

CM05060N
120 x 50 x 60

CM04060N
120 x 40 x 60

CV15825T
120 x 158 x 25

CV07025N
120 x 70 x 25

CV06025N
120 x 60 x 25

A: 158 B: 25 C: 13

CB12025T
158 x 120 x 25

CB07025N
158 x 70 x 25

CB06025N
158 x 60 x 25

A: 120 B: 25 C: 13

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR18N

MEASURES:
158 X 120 X 100 / 50 mm

*Homag, Masterwood and Felder is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Homag, Masterwood, Felder and more.

VACUUM BLOCK KC19

FOR HOMAG AND WEEKE

Compact vacuum pod for old Homag and Weeke models.
Possibility of different suction areas.
It maintains the same measurements as the manufacturer.

COMPACT

Standard set: **145 X 145 X 36 mm**

(Different heights available)

KC19-14536T

MEASURES:
145 X 145 X 36 mm

Underside

KC19-06036N

MEASURES
145 X 60 X 36 mm

KC19-06036M

MEASURES:
60 X 145 X 36 mm

A: 145 B: 36 C: 10

*(Possibility of making different heights and shapes depending on the customer needs).

*Homag and Weeke is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Homag and Weeke.

VACUUM BLOCK KG10

FOR BIESSE

Vacuum cup suitable with biesse 's consoles to hitch with circular ring.
These models are sorted with the fixing ring apart, as many customers prefer to reuse which they already have.

Standard measures: 132 X 132 X 29 / 48 mm

(Different heights available)

COMPACT

KG10-13229T
132 x 132 x 29

KG10-10029T
132 x 100 x 29

KG10-08029N
132 x 80 x 29

KG10-07029N
132 x 70 x 29

Underside

KG10-06029N
132 x 60 x 29

KG10-05029N
132 x 50 x 29

KG10-04029N
132 x 40 x 29

KG10-03529N
132 x 35 x 29

A: 132 B: 29 C: 12

KG10-13248T
132 x 132 x 48

KG10-10048T
132 x 100 x 48

KG10-08048N
132 x 80 x 48

KG10-07048N
132 x 70 x 48

KG10-06048N
132 x 60 x 48

KG10-05048N
132 x 50 x 48

KG10-04048N
132 x 40 x 48

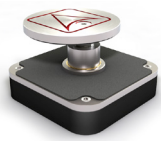
KG10-03548N
132 x 35 x 48

A: 132 B: 48 C: 28

Fixing ring for Biesse

CLAMPS

PR10N



MEASURES:
132 X 132 X 29 / 48 / 74 mm

VACUUM CNC

*Biesse is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers CNC of Biesse.

VACUUM BLOCK KF12

FOR BIESSE

Vacuum cup model suitable with Biesse 's consoles to hitch with circular crown.
This crown is an independent article as a lot of clients prefer to reuse which they already have.

Standard measures: 132 X 145 X 29 / 48 mm

(Different heights available)

COMPACT

KF12-14529T
132 x 145 x 29

KF12-10029T
132 x 100 x 29

KF12-08029N
132 x 80 x 29

KF12-07029N
132 x 70 x 29

Underside

KF12-06029N
132 x 60 x 29

KF12-05029N
132 x 50 x 29

KF12-04029N
132 x 40 x 29

KF12-03529N
132 x 35 x 29

KF12-05029L
132 x 50 x 29

KF12-05029D
132 x 50 x 29

A: 145 B: 29 C: 12

KF12-14548T
132 x 145 x 48

KF12-10048T
132 x 100 x 48

KF12-08048N
132 x 80 x 48

KF12-07048N
132 x 70 x 48

KF12-06048N
132 x 60 x 48

KF12-05048N
132 x 50 x 48

KF12-04048N
132 x 40 x 48

KF12-03548N
132 x 35 x 48

KF12-05048L
132 x 50 x 48

KF12-05048D
132 x 50 x 48

A: 145 B: 48 C: 28

Fixing ring for Biesse

*Biesse is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers CNC of Biesse.

VACUUM CNC

VACUUM BLOCK KN12

FOR BIESSE

Vacuum cup model suitable with Biesse's consoles to hitch with circular crown.
This crown is an independent article as a lot of clients prefer to reuse which they already have.
The same happens with the aluminium plate at the bottom, which is also sold separately.
For these models, in case you want to reuse the original plate, the smallest model that exists is 55 mm width. With the Vacuum cnc aluminium plate we can make them as far as 35 mm width.

COMPACT

Standard measures: 132 X 145 X 29 / 48 / 74 mm

(Different heights available)

KN12-10029T
132 x 100 x 29

KN12-08029N
132 x 80 x 29

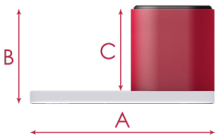
KN12-07029N
132 x 70 x 29

KN12-06029N
132 x 60 x 29

KN12-05029N
132 x 50 x 29

KN12-04029N
132 x 40 x 29

KN12-03529N
132 x 35 x 29



A: 145 B: 29 C: 23

KN12-10048T
132 x 100 x 74

KN12-08048N
132 x 80 x 74

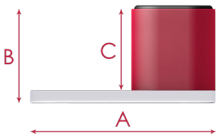
KN12-07048N
132 x 70 x 74

KN12-06048N
132 x 60 x 74

KN12-05048N
132 x 50 x 74

KN12-04048N
132 x 40 x 74

KN12-03548N
132 x 35 x 74



A: 145 B: 48 C: 42

1/2

VACUUM BLOCK KN12

FOR BIESSE

Vacuum cup model suitable with Biesse's consoles to hitch with circular crown.
This crown is an independent article as a lot of clients prefer to reuse which they already have.
The same happens with the aluminium plate at the bottom, which is also sold separately.
For these models, in case you want to reuse the original plate, the smallest model that exists is 55 mm width. With the Vacuum cnc aluminium plate we can make them as far as 35 mm width.

COMPACT

Standard measures: **132 X 145 X 29 / 48 / 74 mm**

(Different heights available)

KN12-10074T
132 x 100 x 74

KN12-08074N
132 x 80 x 74

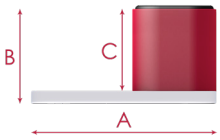
KN12-07074N
132 x 70 x 74

KN12-06074N
132 x 60 x 74

KN12-05074N
132 x 50 x 74

KN12-04074N
132 x 40 x 74

KN12-03574N
132 x 35 x 74



A: 145 B: 74 C: 68

Fixing ring for Biesse

Inferior aluminium plate

*Biesse is a registered and protected trademark. These products have been developed by Vacuum-CNC specifically for machining centers CNC of Biesse.

2/2

VACUUM BLOCK BS15

FOR BIESSE

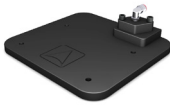
In this model we screw the base in which normally the original vacuum pod gets screwed. From there, with just a click we can modify the suction surface just exchanging the cups.
This vacuum block takes advantage of all the improvements of the Vacuum-cnc system, although it also exists the compact model.

Standard set (Base + Cup): 160 X 150 X 24 mm

(Different heights available)

BASES

BS15N



MEASURES:
160 X 150 X 9 mm
Alongside CL cups of 15 mm gives the height of the manufacturer (24 mm).

CUPS

CL15015T
160 x 150 x 15

CL10015T
160 x 100 x 15

CL08015N
160 x 80 x 15

CL07015N
160 x 70 x 15

CL06015N
160 x 60 x 15

CL05015N
160 x 50 x 15

CL04015N
160 x 40 x 15

A: 150 B: 15 C: 7

COMPACT

KL15-15024T
160 x 150 x 24

Underside

*(Possibility of making different heights and shapes depending on the customer needs).

VACUUM CNC

*Biesse is a registered and protected trademark. These products have been developed by Vacuum-CNC specifically for machining centers CNC of Biesse.

VACUUM BLOCK BS07

FOR BUSELLATO

System that improves clamping to the machine by coupling to the original aluminum piston for fixing the suction cups to the bar.
It also improves the clamping of the piece to be machined since it increases the suction area.
It allows changing the different suction surfaces of the vacuum pod with a click, thanks to the Vacuum-cnc system.

Standard set (Base + Cup): **155 X 155 X 55 mm**

(Different heights available)

BASES

BS07R

MEASURES:
155 X 155 X 25 mm
Alongside the CD of 30 mm gives the height of the manufacturer (55 mm). This model need the original pneumatic piston to the subjection to the bar.

CUPS

CD15530T
155 x 155 x 30

CD10030T
155 x 100 x 30

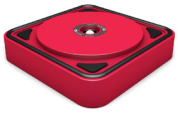
CD08030N
155 x 80 x 30

CD07030N
155 x 70 x 30

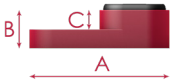
CD06030N
155 x 60 x 30

CD05030N
155 x 50 x 30

CD04030N
155 x 40 x 30



CD15530P
155 x 155 x 30



A: 155 B: 30 C: 18

*(Possibility of making different heights and shapes depending on the customer needs).

*Busellato is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Casadei Busellato.

VACUUM CNC

VACUUM BLOCK BS25

FOR BUSELLATO

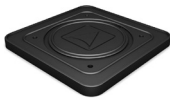
In this model we screw the base in which normally the original vacuum pod gets screwed.
From there, with just a click we can modify the suction surface just exchanging the cups.
It improves the clamping of the piece to be machined since it increases the suction area.
It has all the advantages of the Vacuum-cnc system.

Standard set (Base + Cup): **155 X 155 X 35 mm**

(Different heights available)

BASES

BS25N



MEASURES:
155 X 155 X 12 mm
Alongside the CD/R cups of 23 mm gives the height of the manufacturer (35 mm).

CUPS

CD15523R
155 x 155 x 23

CD10023R
155 x 100 x 23

CD08023R
155 x 80 x 23

CD07023R
155 x 70 x 23

CD06023R
155 x 60 x 23

CD05023R
155 x 50 x 23

CD04023R
155 x 40 x 23

A: 155 B: 23 C: 12

*(Possibility of making different heights and shapes depending on the customer needs).

*Busellato is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Casadei Busellato.

VACUUM BLOCK BS26

FOR BUSELLATO

Once we screw the base to the pneumatic pistons, we will not have to do this again.
Then, we place the more convenient cup with a simple click, being able to change it very quickly.
It improves the clamping of the piece to be machined since it increases the suction area.
It has all the advantages of the Vacuum-cnc system.

Standard set (Base + Cup): 155 X 155 X 55 mm

(Different heights available)

BASES

BS26N

MEASURES:
155 X 155 X 25 mm
Alongside the CD cups of 30 mm gives the height of the manufacturer (55 mm).

CUPS

CD15530T
155 x 155 x 30

CD10030T
155 x 100 x 30

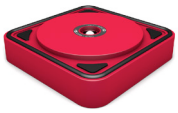
CD08030N
155 x 80 x 30

CD07030N
155 x 70 x 30

CD06030N
155 x 60 x 30

CD05030N
155 x 50 x 30

CD04030N
155 x 40 x 30



CD155030P
155 x 155 x 30

A: 155 B: 30 C: 18

*(Possibility of making different heights and shapes depending on the customer needs).

*Busellato is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Casadei Busellato.

VACUUM BLOCK BS06

FOR NESTING TABLE MACHINES WITH MARTYR

Vacuum pod model designed to work on martyr in nesting table machines.
With the possibility of external vacuum help.
Over the base we can place multiple cup sizes with different suction areas.
It has all the advantages of the Vacuum-cnc system.

Standard set (Base + Cup): **145 X 145 X 50 mm**

(Different heights available)

BASES

BS06N

BS06R

MEASURES:
145 X 145 X 30 mm
Alongside the CC cups of 20 or 30 mm gives the height of the manufacturer (50 or 60 mm).

- **BS06N: Standard model**
- **BS06R: Model with valve**

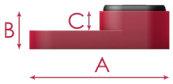
CUPS

CC14520T
145 x 145 x 20

CC10020T
145 x 100 x 20

CC08020N
145 x 80 x 20

CC07020N
145 x 70 x 20



A: 145 B: 20 C: 10

CC06020N
145 x 60 x 20

CC05020N
145 x 50 x 20

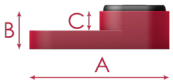
CC04020N
145 x 40 x 20

CC14530T
145 x 145 x 30

CC10030T
145 x 100 x 30

CC08030N
145 x 80 x 30

CC07030N
145 x 70 x 30

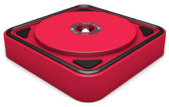


A: 145 B: 30 C: 18

CC06030N
145 x 60 x 30

CC05030N
145 x 50 x 30

CC04030N
145 x 40 x 30



CC14530P
145 x 35 x 30

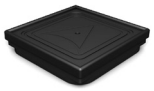
*(Possibility of making different heights and shapes depending on the customer needs).

VACUUM BLOCK BS16

FOR NESTING OR GRID TABLES

System of Vacuum cup for grid tables, We can distinguish the model N and the model H depending on the depth of the canal.
The inferior rubber is reversible, so we can double the length of its useful life.
The board lifter system (with cup CA12030P), initially thought for this model, is one of our main products: It allows you to load and unload the boards easily, with no need of external help and without having damaged or moved none the rubbers of the vacuum block.

BASES



Standard set (Base + Cup): **120 X 120 X 50 / 75 mm**

(Different heights available)

MEASURES:
120 X 120 X 20 mm
Depending on the client 's needs It can be possible placing the CA cups of 20 mm or 30 mm. The bases are distinguished by the depth of the canal:

- BS16H: 7 mm (normally for Homag, Felder, Masterwood, etc).
- BS16N: 6 mm (normally for models of table SCM, Morbidelli, etc).

CUPS

CA12030T
120 x 120 x 30

CA10030T
120 x 100 x 30

CA08030N
120 x 80 x 30

CA07030N
120 x 70 x 30

CA06030N
120 x 60 x 30

CA05030N
120 x 50 x 30

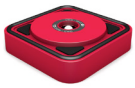
CA04030N
120 x 40 x 30

CA03530N
120 x 35 x 30

CA03030N
120 x 30 x 30

CA05030D
120 x 50 x 30

CA05030L
120 x 50 x 30



CA12030P
120 x 120 x 30

A: 120 B: 30 C: 18

*(Possibility of making different heights and shapes depending on the customer needs).

VACUUM BLOCK BS16

FOR NESTING OR GRID TABLES

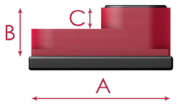
System of Vacuum cup for grid tables, We can distinguish the model N and the model H depending on the depth of the canal.
The inferior rubber is reversible, so we can double the length of its useful life.
The board lifter system (with cup CA12030P), initially thought for this model, is one of our main products: It allows you to load and unload the boards easily, with no need of external help and without having damaged or moved none the rubbers of the vacuum block.

COMPACT

KA16-12025T
120 x 120 x 25

KA16-07025N
120 x 70 x 25

KA16-06025N
120 x 60 x 25



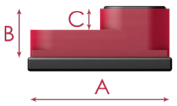
A: 120 B: 25 C: 10

Underside

KA16-12050T
120 x 120 x 50

KA16-07050N
120 x 70 x 50

KA16-06050N
120 x 60 x 50



A: 120 B: 50 C: 28

ELEVATORS

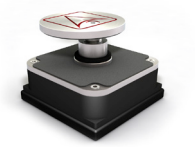
EA12010N
120 x 120 x 10

EA12020N
120 x 120 x 20

EA12030N
120 x 120 x 30

CLAMPS

PR16N



MEASURES:
120 X 120 X 50 mm

VACUUM BLOCK BS02

FOR SAOM, RIERGE, COSMEC, ETC.

Vacuum pod of one circuit with numerous options of suction areas.
It possesses a great grip to the bars thanks to its patented rubber by Vacuum cnc.
Triggers improved that guarantee a great durability and a greater using comfort.
This model takes advantage of all of the Vacuum-cnc system.

Standard set (Base + Cup): **120 X 120 X 50 mm**

(Different heights available)

BASES

BS02N

MEASURES:
120 X 120 X 30 mm
Alongside the CA cups of 20 mm gives the height of the manufacturer (50 mm).
There is an option of maintaining the original height with the
lifting board included in the compact model.

CUPS

CA12020T
120 x 120 x 20

CA10020T
120 x 100 x 20

CA08020N
120 x 80 x 20

CA07020N
120 x 70 x 20

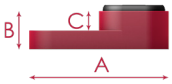
CA06020N
120 x 60 x 20

CA05020N
120 x 50 x 20

CA04020N
120 x 40 x 20

CA03520N
120 x 35 x 20

CA03020N
120 x 30 x 20



A: 120 B: 20 C: 10

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR02N

MEASURES:
120 X 120 X 50 mm

*Saom, Rierge y Cosmec is a registered and protected trademark. These products have been developed by VacuumCNC specifically for machining centers of Saom, Rierge and Cosmec.

VACUUM CNC

VACUUM BLOCK KP04

FOR NIPUER

Vacuum pod specific for milling doors machines.
As it is made in plastic it doesn't affect the milling machine in case of crashing with the vacuum cup.
All of them include a touch valve to not lose the vacuum even if it is not being used.

Standard models: **150 X 120 / 70 / 50 X 55 mm**

(Different heights available)

COMPACT

KP04-12055T

MEASURES:
150 X 120 X 55 mm

KP04-07055N

MEASURES:
150 X 70 X 55 mm

KP04-05055N

MEASURES:
150 X 50 X 55 mm

*(Possibility of making different heights, shapes and suction areas depending on the customer needs).

*Nipuer is a registered and protected trademark. These products have been developed by Vacuum-CNC specifically for machining centers of Nipuer.

VACUUM BLOCK BS20

FOR EGURKO AND RIERGE

Vacuum pod model equivalent to the Egurko, Bermaq, Rierge, etc.
We offer two options:

- The Vacuum-cnc system, divided in two pieces and with the characteristics of the brand, speed, efficacy and saving. It increases the height from 19 mm to 30 mm.
- The compact system, in one piece but improving the benefits of grip for an optimum milling.

Standard set (Base + Cup): **158 X 120 X 30 / 48 mm**

(Different heights available)

BASES

BS20N

BS20N18

MEASURES:
158 X 120 X 10 mm
Alongside the CB cups of 20 mm gives the height of the manufacturer (30 mm).
There can be different official measures

It also exists the option of the base with 18 mm height, which alongside the CB cups of 18 mm gives the height of the manufacturer (48 mm).

CUPS

CB15820T
158 x 120 x 20

CB10020T
158 x 100 x 20

CB08020N
158 x 80 x 20

CB07020N
158 x 70 x 20

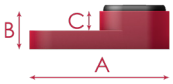
CB06020N
158 x 60 x 20

CB05020N
158 x 50 x 20

CB04020N
158 x 40 x 20

CB03520N
158 x 35 x 20

CB03020N
158 x 30 x 20



A: 120 B: 20 C: 10

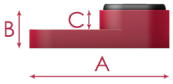
COMPACT

KB20-12019T
158 x 120 x 19

KB20-06019N
158 x 100 x 19

KB20-05019N
158 x 80 x 19

Underside



A: 120 B: 19 C: 7

*(Possibility of making different heights and shapes depending on the customer needs).

*Egurko y Rierge is a registered and protected trademark. These products have been developed by Vacuum cnc specifically for machining centers of Egurko and Rierge.

VACUUM BLOCK BS23

MAGNETIC POSITIONING FOR METALIC TABLE

Vacuum block of one circuit with numerous options of suction areas.
It possesses a huge grip to the bars/magnetic tables thanks to their patented rubber by Vacuum cnc.
This model takes advantage of all the Vacuum-cnc system goods.

Standard set (Base + Cup): **120 X 120 X 52 mm**

(Different heights available)

BASES

BS23N

MEASURES:
120 X 120 X 22 mm
Alongside the CA cups of 30 mm gives the height of the manufacturer (52 mm).

CUPS

CA12030T
120 x 120 x 30

CA10030T
120 x 100 x 30

CA08030N
120 x 80 x 30

CA07030N
120 x 70 x 30

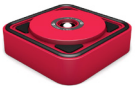
CA06030N
120 x 60 x 30

CA05030N
120 x 50 x 30

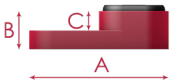
CA04030N
120 x 40 x 30

CA03530N
120 x 35 x 30

CA03030N
120 x 30 x 30



CA12030P
120 x 120 x 30



A: 120 B: 30 C: 18

*(Possibility of making different heights and shapes depending on the customer needs).

VACUUM BLOCK BS27

FOR FLAT TABLES

Vacuum pod for flat table, very versatile thanks to the infinite possibilities of suction surfaces that gives our system of changing cups.It has a great grip to the bars thanks to its patented rubber by Vacuum cnc. This model takes advantage of all the improvements of the Vacuum-cnc system.
The plastic material of which it is made protects the tools of braking in case of an accident. Valid for milling all kinds of materials (derivatives of plastic and wood, crystal etc.)

Standard set (Base + Cup): **132 X 132 X 50 / 60 / 100 mm**

(Different heights available)

BASES

BS27N-30

MEASURES:
132 X 132 X 30 mm
Alongside the CG cups of 20 mm, 30 mm and 70 mm gives the height of the manufacturer (50, 60 and 100 mm).

BS27N-40

MEASURES:
132 X 132 X 40 mm
Alongside the CG cups of 20 mm gives the height of the manufacturer (60 mm).

BS27N-50

MEASURES:
132 X 132 X 50 mm
Alongside the CG cups of 50 mm gives the height of the manufacturer (100 mm).

CUPS

CG13230T
132 x 132 x 30

CG10030T
132 x 100 x 30

CG08030N
132 x 80 x 30

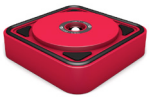
CG07030N
132 x 70 x 30

CG06030N
132 x 60 x 30

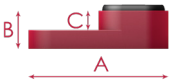
CG05030N
132 x 50 x 30

CG04030N
132 x 40 x 30

CG03530N
132 x 35 x 30



CG13230P
132 x 132 x 30



A: 132 B: 30 C: 18

*(Possibility of making different heights and shapes depending on the customer needs).

VACUUM BLOCK BS27

FOR FLAT TABLES

Vacuum pod for flat table, very versatile thanks to the infinite possibilities of suction surfaces that gives our system of changing cups.It has a great grip to the bars thanks to its patented rubber by Vacuum cnc. This model takes advantage of all the improvements of the Vacuum-cnc system.
The plastic material of which it is made protects the tools of braking in case of an accident. Valid for milling all kinds of materials (derivatives of plastic and wood, crystal etc.)

CUPS

CG13270T
132 x 132 x 70

CG10070T
132 x 100 x 70

CG08070N
132 x 80 x 70

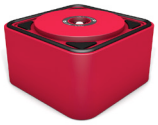
CG07070N
132 x 70 x 70

CG06070N
132 x 60 x 70

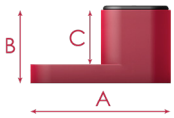
CG05070N
132 x 50 x 70

CG04070N
132 x 40 x 70

CG03570N
132 x 35 x 70



CG13270P
132 x 132 x 70

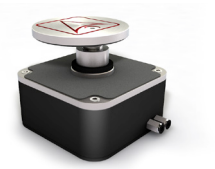


A: 132 B: 70 C: 50

*(Possibility of making different heights and shapes depending on the customer needs).

CLAMPS

PR27N



MEASURES:
132 X 132 X 50 mm

2/2

ELEVATORS

COMPATIBLE WITH ALL OUR BASES AND CUPS

Piece that complements the VACUUM BLOCK allowing to work at different heights depending on the client's needs. It is placed between the base and the cup with a single click.

MODELS

Available for all suction cup models

EA12010N

MEASURES:
120 X 120 X 10 mm

EA12020N

MEASURES:
120 X 120 X 20 mm

EA12030N

MEASURES:
120 X 120 X 30 mm

EA12040N

MEASURES:
120 X 120 X 40 mm

EA12050N

MEASURES:
120 X 120 X 50 mm

* In addition to the model shown (EA), there are elevators for all the sizes of our suction cups:
- EB: 158 x 120 mm
- EC: 145 x 145 mm
- ED: 155 x 155 mm
- EF: 132 x 145 mm
- EG: 132 x 132 mm
- EJ: 120 x 140 mm
- EL: 160 x 150 mm
- EM: 120 x 130 mm

*(Possibility of making different heights and shapes depending on the customer needs).

MECHANICAL CLAMPS

SPECIFIC MODELS FOR EACH MACHINE

Mechanical clamps activated by vacuum.
They turn on when activating the vacuum in the machine and they position as any other kind of vacuum pod, without hose connection or screws unless is absolutely necessary. Clamping forces of up to 700 N.
All of our vertical presses include two elevator caps of 25 and 50 mm for being able of lifting the height, until a recommended maximum of 100 mm, allowing us to realize all kind of tasks.

MODELS

The available heights are according with the vacuum cup model.

PR01N

MEASURES:
120 X 120 X 32.7 mm

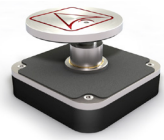
PR02N

MEASURES:
120 X 120 X 50 mm

PR05N

MEASURES:
145 X 145 X 50 mm

PR10N



MEASURES:
132 X 132 X 29 / 48 / 74 mm

PR13N

MEASURES:
158 X 120 X 50 / 100 / 125 mm

PR16N

MEASURES:
120 X 120 X 50 mm

PR17N

MEASURES:
158 X 120 X 100 / 50 mm

PR27N

MEASURES:
132 X 132 X 50 mm

PR28N

MEASURES:
145 X 145 X 50 / 75 mm

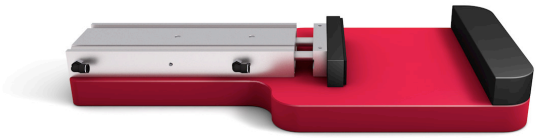
*(Possibility of making different heights and shapes depending on the customer needs).

HORIZONTAL CLAMP

PNEUMATIC ACTUATION

It is positioned on the bases of the different machines, with the possibility of 360º rotation.
Ideal for different jobs on medium and small size profiles.
By making horizontal pressure, it leaves the upper face free for the design of frets, borders, drawings, etc.
A very interesting option for its operation is to place a T, and use the air from the pneumatic pistons of the machine.

Ref: **PH01N**



MEASURES:
145 X 320 X 30 mm

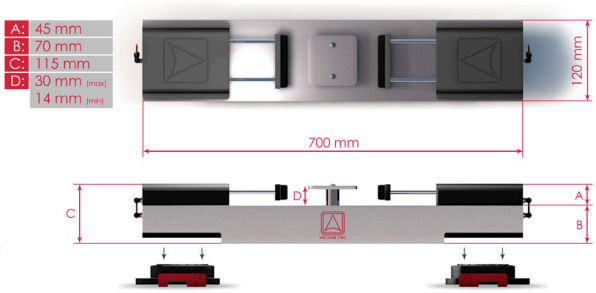
100 mm opening distance. Travel up to 150 mm. Pneumatic elbows for 6 mm hose.

DOOR JAMB CLAMP

ACTIVATED BY VACUUM

By acting with the vacuum that the machine carries, it does not need to have any type of external installation. Designed for fixing fences, slats and moldings from 40 to 190 mm.
It is positioned on two Vacuum-cnc bases and adapts to all machines, both bar and table.
It is a double clamp, designed to be able to do at the same time, both the box of the hinges, as the closing of the slide.

Ref: **PRCS1**

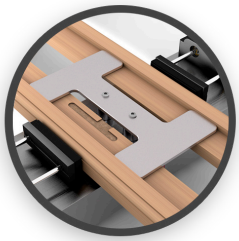


MEASURES:
700 X 150 X 120 mm

Ease of assembly and disassembly. No need to make any modifications to your machine.

Two upper stop options available:

OPTION A:
Standar stop
More options working on the side of the clamp.



OPTION B:
H shaped stop
Specific for hinges. More precision working on top of the clamp.

VACUUM CNC

NESTING MODULE

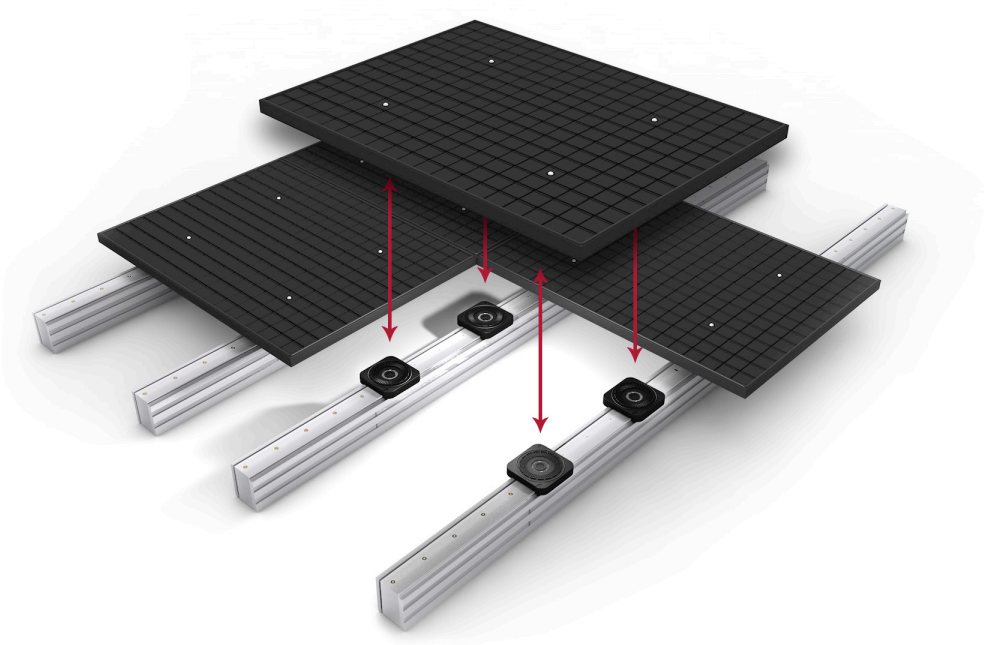
COMPATIBLE WITH ALL OUR BASES

Convert any or part of any pod & rail cnc machine into a nesting table.
It is placed over four Vacuum-cnc bases, facilitating assembly and disassembly.
The best choice for precision work on the Z-axis on pod & rail machines.

Ref: **MMN**

MEASURES:
680 X 910 X 30 mm

Each module has four anchor points to hold the martyr, essential both for the proper functioning of the tables and to extend their useful life.
Possibility of adding extra vacuum intakes, to increase the flow rate and allow greater division of the work table.



*(Possibility of making different heights and shapes depending on the customer needs)

OTHER PRODUCTOS

VACUUM PUMPS

Ref: **Becker KVT 3.60**

MEASURES:
704 X 353 X 328 mm
Rotary vane vacuum pumps. Oil-free and air-cooled. Included: Integrated suction filter, vacuum regulating valve and integrated blow off valve.

Ref: **Becker Picchio 2200**

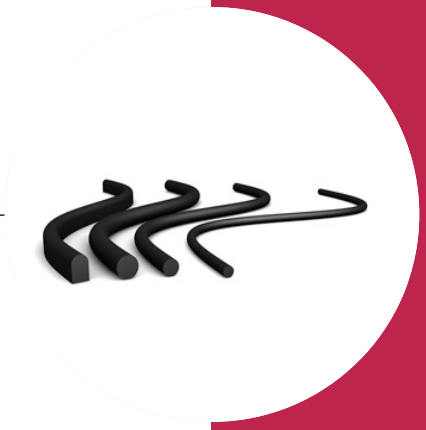
MEASURES:
703 X 353 X 328 mm
Rotary vane vacuum pumps. Oil-free and air-cooled.

Ref: **Becker VT 4.40**

MEDIDAS:
572 X 280 X 290 mm
Rotary vane vacuum pumps. Oil-free and air-cooled. Included: Integrated suction filter, vacuum regulating valve and blow off valve.

SPARE PARTS

RUBERS, VALVES AND SUPPORTS



Spare parts for the repair of Vacuum-cnc suction cups.

RUBERS

GO-04
Diameter: 4 mm

GO-05
Diameter: 5 mm

GO-06
Diameter: 6 mm

GO-07
Diameter: 7 mm

GO-08
Diameter: 8 mm

GO-09
6 x 9 mm

VALVES

VALVE
Ball diameter: 10 mm

SUPPORTS

Support 25
25 x 12 x 4 mm

Support 30
30 x 12 x 4 mm

Support 35
35 x 12 x 4 mm

Support 44
44 x 12 x 4 mm

Support 50
50 x 12 x 4 mm

VACUUM CNC
Door jamb clamp
activated by vacuum
© Patented System
BLOCK BS17
VACUUM CNC
Vacuum clamping for cnc machines
NESTING MODULE
VACUUM CNC
Vacuum clamping for cnc machines
VACUUM BLOCK BS17
VACUUM CNC
Vacuum clamping for cnc machines
Fast Exchange
360
Different heights

VACUUM CNC

www.vacuum-cnc.com