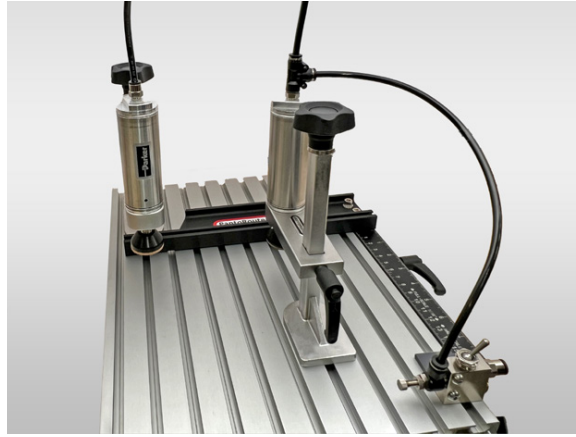


# Air Clamp Kit Assembly and Use



Air Control Kit



Universal Clamp Base



Air Clamp Arm



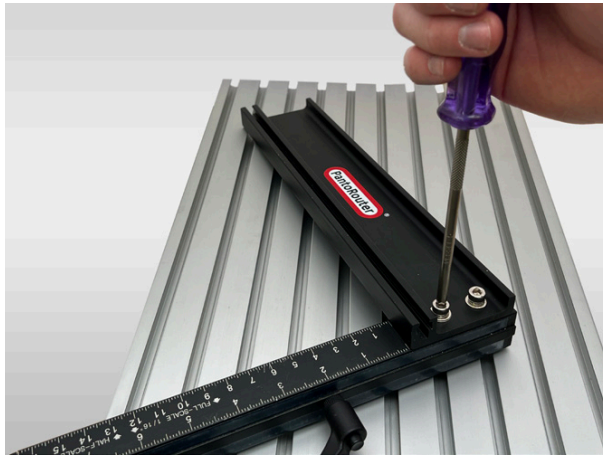
Pneumatic Cylinder



## Stiffening Bars

Install the Stiffening Bars according to the directions included in the Stiffening Bar Box.

### Cut Out Centering Scale Fence Assembly



Remove and reserve the two screws from the existing Centering Scale Fence and lift the top rectangular fence section off.



If the Centering Pins do not come out easily, place the fence on a flat workbench and apply a little pressure to the top of the fence and the pins will pop out.

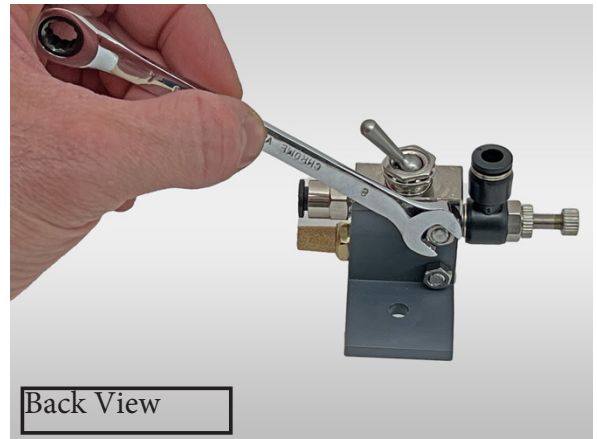
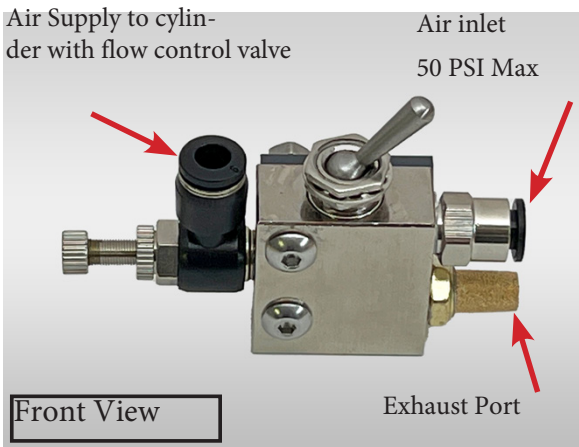


Install the Centering Pins in the new Cut Out Centering Scale Fence.

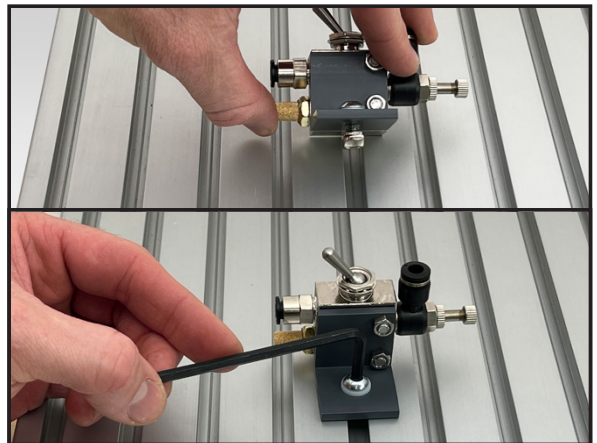
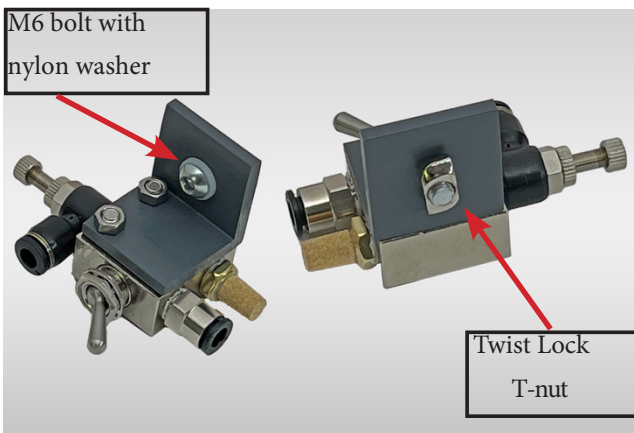


Slide the square portion of the Centering Scale Fence in the back slot of the table and lock the lever knob. Make sure the threaded holes of the nut plate are visible through the alignment holes on the top face of the square extrusion. Drop the alignment pins of the new rectangular fence section into the alignment holes and re-install the two bolts.

### Air Control Assembly



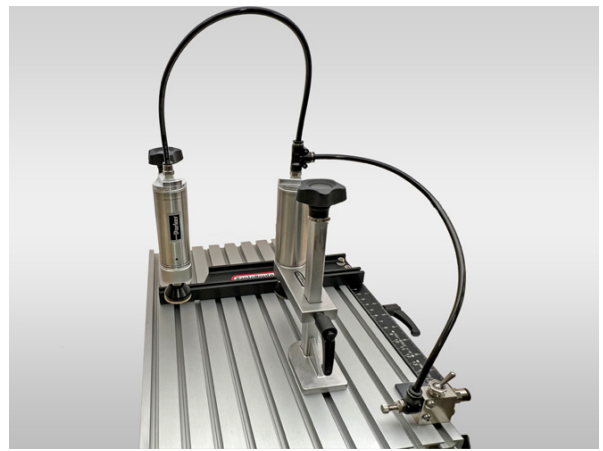
Align the mounting bracket with the control switch mounting holes and install the two M5 bolts with corresponding nuts. Tighten with a 3mm hex wrench and an 8mm end wrench. The bracket will go against the face of the switch that has writing on it. When looking at the front of the assembly, the two bolt heads will be on the left-hand side.



Install the M6 screw and nylon washer in the mounting bracket and loosely thread on the twist lock T-nut. The twist lock T-nut fits in the table slots and locks in place when the bolt is tightened. Minimal pressure is needed to hold the switch in place.

## Pneumatic Cylinder and Tubing

Thread the quick-connect air fitting into the top of the pneumatic cylinder and tighten with a 12mm wrench. The fittings already have a thread coating so no Teflon tape is needed. Each Air Clamp arm comes with a T-fitting and a straight fitting. When using 2 air clamps, one of each type of fitting will be used as shown in the photos below.



Cut two 16” sections of the provided hose to connect the two cylinders and switch. The hose cuts easily with scissors or wire cutters. Simply press the hose into the fitting. Remove the tube by retracting the black retaining ring and gently pulling the tube out. A maximum of 50 PSI is recommended for use on the PantoRouter® Table. The pressure can be regulated at the air compressor or with a separate air regulator. Scan the QR code for an affordable small air regulator. The flow control valve on the switch allows the operator to control the speed the cylinder arm extends and retracts, however it DOES NOT regulate the PSI. Excessive pressure can result in table damage.

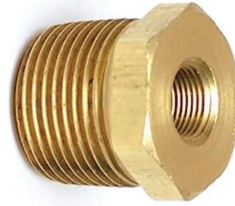


## Options for connecting to your compressed air system

The fitting shipped with the PantoRouter® Air Clamps is 6mm OD x 1/8" male pipe thread. These tube fittings are readily available on Amazon and other online sources and adapter fittings are available at Home Depot, Lowes and most hardware stores. There are numerous styles of compressed air connectors so select the style and pipe size required then adapt to the 1/8" fitting we provide. Here's an example.



**Compressed air male coupler with 1/4" female pipe thread.**



**1/8" female pipe thread to 1/4" male pipe thread bushing.**



**6mm OD tube push connect fitting X 1/8" male pipe thread.**