# Fitting a Sacrificial Bed

After removing the existing MDF sacrificial bed, clean the surface of the aluminum vacuum deck, removing any debris.

Marking the positions of the new fixings can be done in two ways;

1. Place the new MDF sheet in position and then mark the bed through the 6mm holes. Take off the MDF and slide the nuts into position. Place the MDF back and fix the M6 x 19mm screws.
2. Measure the distance from the X zero and place the nuts where appropriate. Place the MDF in position and fix the M6 x 19mm screws.

As the aluminum deck already has channels positioned along its surface it is easy to align the nuts with the Y axis.

The depths of the screw shoulder are cut to a depth of 17mm. It is possible to cut up to 19mm deep, however we do not recommend going any deeper.

Take care that the screw does not come in contact with the bottom of the T-slot as this will prevent the MDF from being held down and thus create vacuum bleed.

