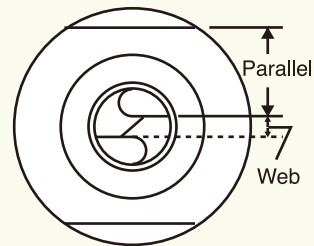


OPERATION

- Determine the drill material, then choose the proper grinding wheel, CBN grinding wheel is the standard accessory. (CBN for HSS material drills) (SD for carbide material drills)
- Preset the scale of Web Adjustment Shelf; turn it by clockwise to the end and then turn counterclockwise at zero.
- A. Choose the proper size of collet. Put collet into collet chuck.
*Insert collet into collet chuck by 45° angle.
B. The order of setting operation: Put the collet into collet chuck and screw in a little bit by clamping nut, then insert the drill through the collet chuck and push in until the drill is out of the nut about 5mm.
*Do not fully fasten the clamping nut with collet chuck, keep the drill able to be adjusted.
- A. Adjust the scale of Web Adjustment Shelf according to the drill diameter.
B. Insert the chuck set into the Web Adjustment Shelf. Then connect it tightly. Turn it right to the end.
C. Plug the drill to the end and turn it right to the end.
D. Turn the chuck set right to the end and tightens it.
E. Turn the chuck set a little to the left and taking it out gently.
*Make sure that the cutting lip of drill is parallel with the slot of clamping nut before grinding job started. If it is not parallel, adjust it again.

Attention! If the cutting lip is downward, must increase the scale of Web Adjustment Shelf. If it is upward, please decrease the scale of the Web Adjustment Shelf.
*When the flute length of a drill becomes shorter, the web thickness of a drill would become thicker. So, for the same diameter of drills, the shorter length of a drill, the higher scale of Web Adjustment Shelf need to be increased.

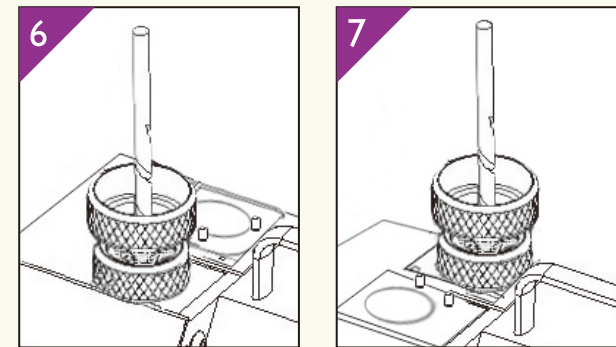
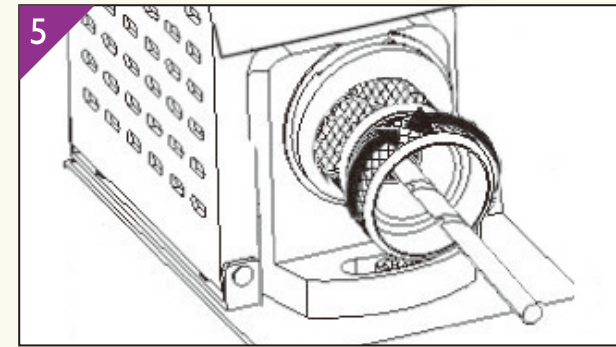
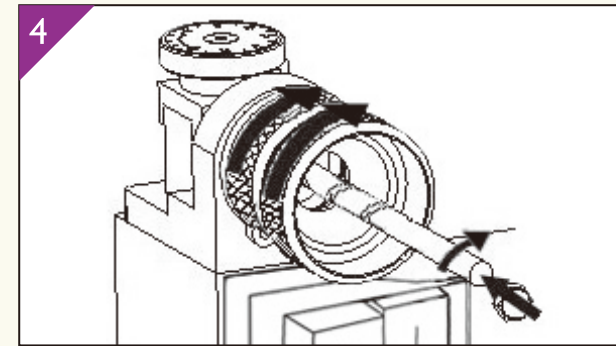
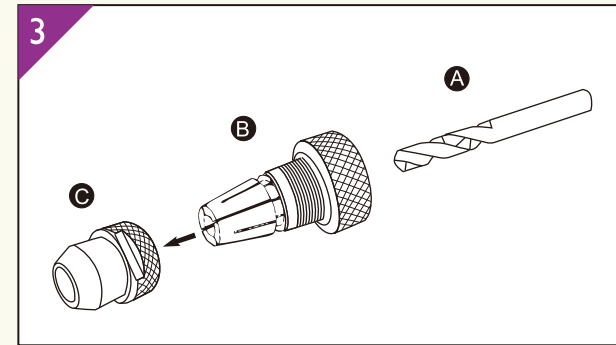
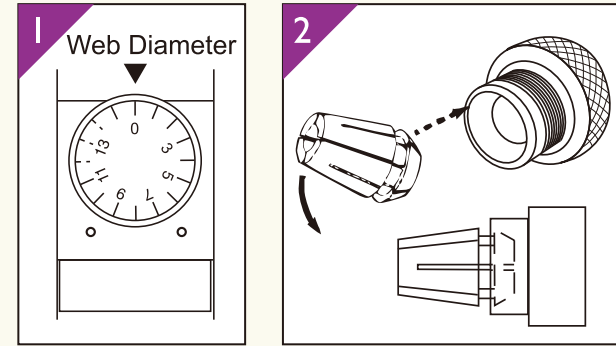


- Turn the power switch on and wait until the motor rotation is stable (about 10 seconds), put the chuck set into the grinding shelf. The slot of clamping nut must fit with the two pins of the grinding shelf. Insert the drill gently into grinding shelf until reach the grinding slip. Grind the drill by moving left and right until the noise stops. And then turn to the other side. Grind the drill with the same way.
*The grinding size of drill is 2mm~13mm.
*The point angle of drill is from 90° to 140°
*While grinding, don't hold the stem of the drill, it will affect the accuracy.
- For grinding the center of drill and the web of drill, insert the chuck set into Web Thinning Shelf and move left and right until the noise stops. After that turn the chuck set to the other side and grinds it by the same way until noise stops.

*The insertion and ejection of the clamping nut set from Web Thinning Shelf, must make sure that the center part of the slot in clamping nut is fitted with the pin of Web Thinning Shelf.

- Please clean the scraps on each grinding shelf after finishing the grinding job.

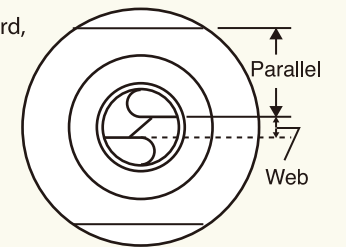
Remark: 1. For grinding the (long drill) deep hole drill, increase the scale of Web Adjustment Shelf.
2. The high spiral drill bit: Based on the size and specification, increase the adjustments on the scale (Diameterx2).



OPERATION

- A.) Please determine the drill diameter and choose the proper grinding wheel.
A. $\Phi 3.0\text{mm} \sim \Phi 4.0\text{mm}$ Please use the A Grinding Wheel
B. $\Phi 4.1\text{mm} \sim \Phi 6.0\text{mm}$ Please use the B Grinding Wheel
C. $\Phi 6.1\text{mm} \sim \Phi 9.0\text{mm}$ Please use the C Grinding Wheel
D. $\Phi 9.1\text{mm} \sim \Phi 13.0\text{mm}$ Please use the D Grinding Wheel
B.) Determine the drill material, then choose the proper grinding wheel. (CBN for HSS material drills) (SDC for carbide material drills) CBN grinding wheel is the standard accessory.
- Preset the scale of Web Adjustment Shelf; turn it by clockwise to the end and then turn counterclockwise to "zero".
- A. Choose the proper size of collet. Put collet into collet chuck.
*Insert collet into collet chuck by 45° angle.
B. The order of setting operation: Put the collet into collet chuck and fasten the clamping nut a little bit for inserting the drill through the collet chuck. Keep the drill out of the nut about 5mm and make sure the drill will not drop from the chuck set but the drill still can be adjusted.
- A. Adjust the scale of web diameter according to the drill diameter.
B. Insert the chuck set into the cutting edge grinding shelf and turn it right to the end. Make sure the chuck set tightly connecting with the grinding shelf without any gaps.
C. Push the drill into the end and turn it right until it stops by the web block.
D. Turn the chuck set right to the end and tightens it.
E. Turn the chuck set a little to the left and taking it out gently.
*Make sure that the cutting lip of drill is parallel with the slot of clamping nut before starting grinding job. If it is not parallel, adjust it again.

Attention! If the cutting lip is downward, must increase the scale of Web Adjustment Shelf. If it is upward, please decrease the scale of the Web Adjustment Shelf.



*For the same diameter of a drill, the shorter length of a drill, the higher scale of web adjustment shelf need to be increased.

- Turn the power switch on and wait until the motor rotation is stable (about 10 seconds); put the chuck set into shelf grinding (I). The slot of fix clamping nut must fit with the two pins of grinding shelf. Gently put the chuck set into shelf grinding until reach the grinding slip. Grind the drill by moving left and right until the noise stops. And then turn to the other side. Grind the drill with the same way.
*The grinding size of drill is 3mm~13mm.
*The point angle of drill is 135°
*While grinding, don't hold the stem of the drill, it will affect the accuracy.
- Put the chuck set into Grinding Shelf (II), the slot of fix clamping nut must fit with the two pin, gently put the chuck set into grinding shelf until reach the grinding slip. Grind the drill until the noise stops. Turn the chuck set to other side....
- Put the chuck set into Grinding Shelf (III), the slot of fix clamping nut must fit with the two pin, gently put the chuck set into grinding shelf until reach the grinding slip. Grind the drill until the noise stops. Turn the chuck set to other side....
- Please clean the ash on each grinding shelf after finishing the grinding job.