



Iron Frame Drill Bit

OPERATION

1. Determine the drill material, and then choose the proper grinding wheel.
(CBN for HSS material drills) (SD for carbide material drills)
CBN grinding wheel is the standard accessory
 2. Preset the scale of Web Adjustment Shelf (on the left hand side) ; turn it by clockwise to the end and then turn counterclockwise to "zero".
 3. A. Choose the proper size of collet. Put collet into collet chuck.
* Insert collet into collet chuck by 45° angle.
B. 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 tighten the drill by chuck set until the drill will not drop from the chuck set but the drill still can be adjusted.
 4. A. Adjust scale of web diameter (on left side) 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.
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- *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 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.
5. Turn the power switch on and wait until the motor rotation is stable (about 10 seconds); put the chuck set into left hand of cutting lip grinding shelf. 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 $\Phi 12\text{mm} \sim \Phi 26\text{mm}$.
*The point angle of drill is $160^\circ \sim 180^\circ$
*While grinding, don't hold the stem of the drill, it will affect the accuracy.
 6. Put the chuck set into Web Thinning Grinding Shelf on the top of left hand side, move left and right until the noise stops. Turn the chuck set to other side and grind it by the same way until noise stops.
 7. Please clean the ash on each grinding shelf after finishing the grinding job.