

SETTING AND GRINDING INSTRUCTIONS FOR DRILL SHARPENING MACHINE

A. NORMAL DRILL POINT GRINDING (2FLUTE DRILLS)

1. Set swivel base 'B' - $\frac{3}{8}$ " from corner of base 'A'
2. Ensure motor platform 'C' is screwed down to bottom position.
3. Ensure collet head 'D' scribed line is in top central position.
4. Swivel the head at 45° by pulling out plunger.
5. Select correct collet for drill size required.
6. Place collet into head 'E'.
7. Place drill in collet and move out so that the cutting edge 'F' is in contact with the setting piece 'G'. (This is variable with size of drill used.)
8. Tighten the collet to grip the drill and re-check drill position with setting piece 'G'.
9. Wind handle 'H' back to ensure drill does not touch the wheel.
10. Swing the head back into central position until it locks ensuring the top slide is far enough back.
11. Set wheel handle in top position.
- 11a Moving handle 'H', feed the topslide into the wheel.
12. Check to see if drill is moving onto the centre bottom of the wheel. Further check now by swivelling the wheel over the drill to check for even contact each side of the drill. Correct, by moving handle 'J' backwards or forwards to centralize.
13. Set wheel to T.D.C. over drill.
14. Start motor.
15. Feed handle 'H' a few thou' into the wheel moving the wheel continually through an arc of 180°. Check for even grinding of the drill point and correct as at (12).

N.B.

16. When .002"/.003" has been fed on after contact with the wheel, set the wheel in the backrest position to stop the motor.
17. Release collet body lock 'K'. Move through 180° checking the drill flutes. The collet will lock automatically in position.
18. Re-start motor.