

19. Carefully bring the wheel over to the drill (it may bite fiercely so care must be taken). Gently feed the wheel across the drill point.
(Too much care cannot be exercised at this time).
20. Repeat the whole sequence until sufficient has been cleared off both sides of the drill point to sharpen it.
21. Stop motor - set wheel to rear rest position.
22. Swinghead 'D' away from the wheel and remove the whole head 'E' by lifting it off its location pin. Check the point for evenness of grinding. If correctly ground, remove from collet. If not repeat the process until evenly ground.

NOTE: Unevenly ground drills will result in oversize holes.

N.B. for 4 flute drills, the collet clicks at each 90° position. Grind in the same manner as for 2 flute drills.

POINT THINNING (if required)

2 flutes only

1. Leave the drill in position in the collet after sharpening.
2. Swivel wheel to front stop position.
3. Ensure drill cutting edge 'F' is uppermost, feed handle 'J' in so that the grinding wheel almost touches the drill cutting edge.
4. Start motor.
5. Feed handle 'J' in until the wheel just touches and cleans the point and cleans the trailing edge.
6. The amount of 'feed in' will vary with the drill size. Care must be taken not to remove too much.

FOR WHEEL DRESSING AND TRIMMING - SEE LEAFLET