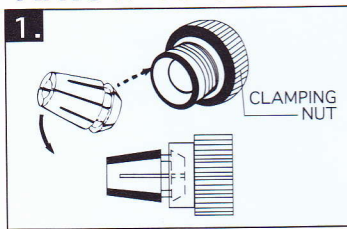
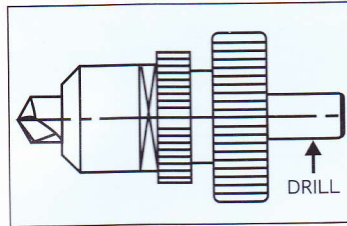


Precision Drill Grinder

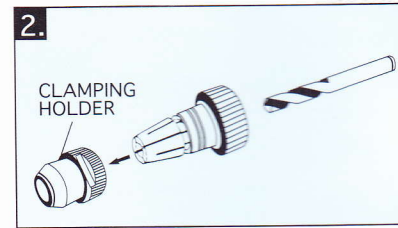
A. HOW TO USE HOLDER UNIT FOR COLLET & DRILL



Please confirm the drill size and pick up proper collet. Assemble collet into clamping nut by 45 degree. (Before insert the drill into the clamping holder.)

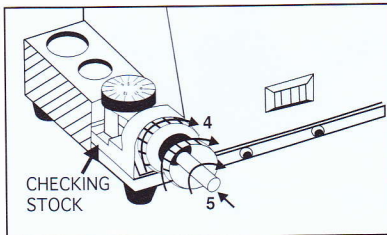


HOLDER UNIT



In sert the drill, lock the clamping holder but not tightened, allow the drill can still move.

B. HOW TO SET THE HOLDER UNIT AT THE CHECKING STOCK

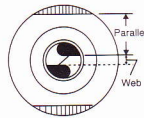


- 1 Find the drill diameter. (If the drill D. is 8.2mm) Set the indicator of scale No. as same as drill's diameter. (Please turn the indicator plate and set it between 8mm-8.5mm.)
- 2 Insert the holder unit into the checking stock, The slot of clamping unit will match into the PIN of checking stock. (Make sure the drill is touching the checking stock.)
- 3 Turn the holder unit and drill to clockwise (Make sure the drill is touching the checking stock). And tighten the holder unit by turning the clamping nut.

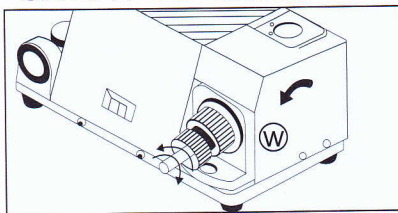
CAUTION 1 Make sure the web blade of drill is parallel to the slot of clamping holder.

2 If a drill's length is less than 10mm, please add 1-2 scale onto the indicator plate.

3 If a drill's web blade is vary from normal drill, please check the parallel to slot of the clamping holder first, and then set the indicator.



C. HOW TO GRIND THE WEB OF DRILL

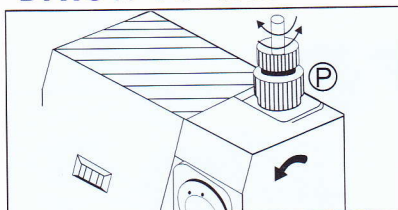


- 1 Turn on the power.
- 2 Insert the holder unit into the (W) grind stock. The slot will match with the PIN. Let the drill reach diamond wheel smoothly. (Hold the clamping holder when turning.)
- 3 Grinding the drill by moving right and left. Until the grinding noise is gone.
- 4 Take out the holder unit. And turn 180°, Insert again like step 3. complete the web sharpening process.

CAUTION 1 Hold and turn the clamping holder to avoid mis-grinding. Hold drill or clamping nut when turning may result in un-even surface.

2 To grind different angle shall adjust angle indicator before insert.

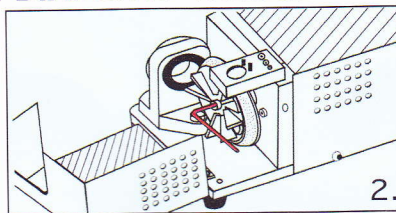
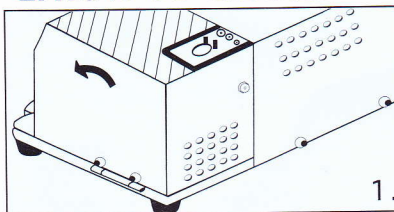
D. HOW TO GRIND CENTER POINT OF DRILL



- 1 Insert the holder unit into (P) grind stock slot and match with the PIN.
- 2 Turn the holder unit right and left slowly until the grind noise is off.
- 3 Take out the holder unit and turn oppsite 180° and repeat step 2.

NOTE: Drill under 4 mm no need to grind center point.

E. HOW TO CHANGE THE DIAMOND WHEEL



- 1 Loosen the screw on the wheel cover.
- 2 Open the cover and loosen the screw which use to lock the grind wheel.
- 3 Change the wheel, make sure two screws are in place and fixed.

CAUTION Do not plug in the power before the wheel cove is close.

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