



1 Select the collet with the clamping tolerance that corresponds to the diameter of the drill to be sharpened and proceed with assembly as shown in these 2 images.

Adjust the clamping so that the drill bit can slide for setting.



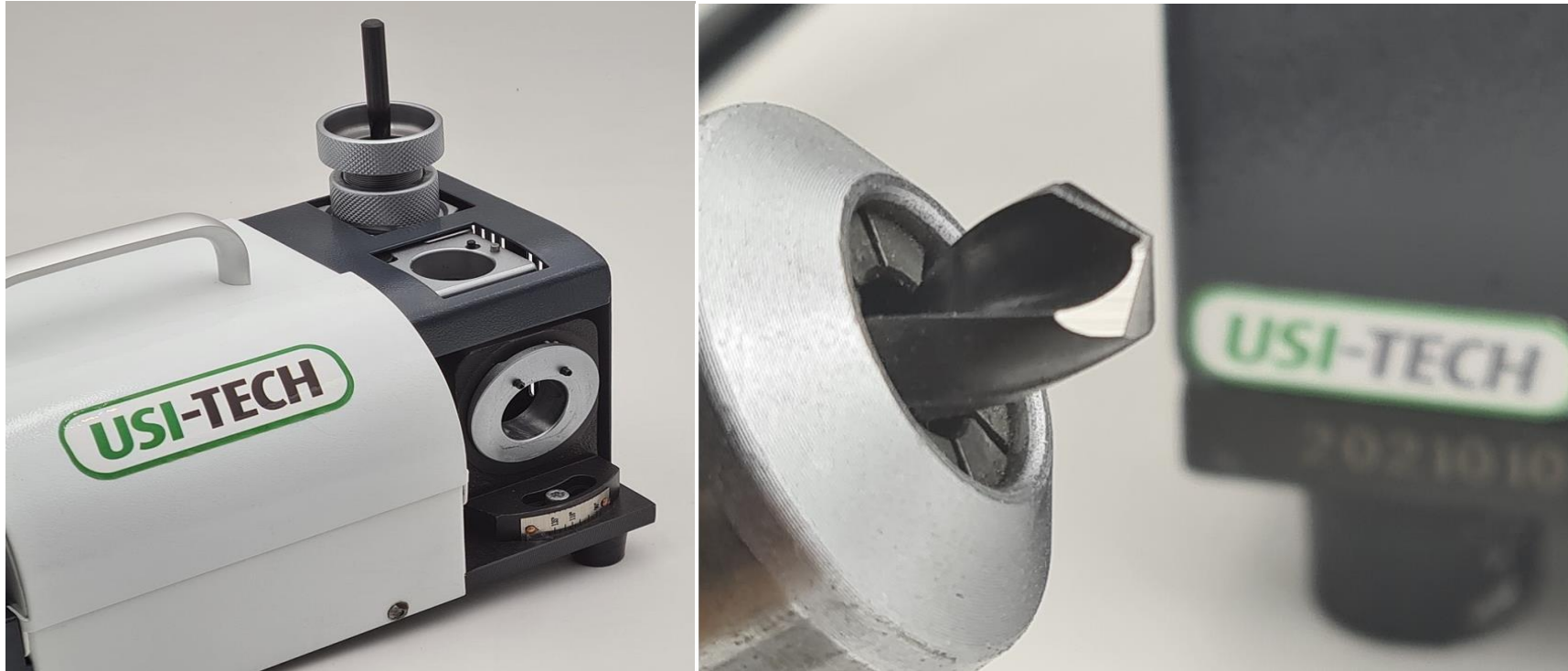
2. Adjust the sharpening positioning finger by positioning the sharpening diameter to be sharpened.

Place the assembly in the steady rest as shown in the picture and push the tip of the drill bit to the stop, turning it to the right until one of the two lips of the drill bit is also at the stop.

Hold the assembly and tighten the chuck to lock it in place.



3 After motor start-up. Place the chuck in the grinding base, taking care to position the flat of the chuck with the two small locating pins (as shown in the picture). Press lightly on the grinding wheel with a smooth, continuous movement, turning clockwise until there is no grinding noise. Then remove the chuck and repeat the operation, rotating the assembly through 180° to sharpen the other cutting edge.



4. Clearing the draft :

After starting the motor. Position the chuck over the grinding base (as shown in the picture), aligning the flat of the chuck with the locating pins, and allow it to descend in a smooth, continuous movement until there is no more grinding noise. Then remove the chuck and repeat the operation, rotating the assembly through 180° to release the other relief.



5 Tip clearance :

After starting the motor. Position the chuck over the grinding base (as shown in the picture), aligning the flat of the chuck with the locating pins, and allow it to descend in a smooth, continuous movement until there is no grinding noise. Then remove the chuck and repeat the operation, rotating the assembly through 180° to clear the other side of the tip.