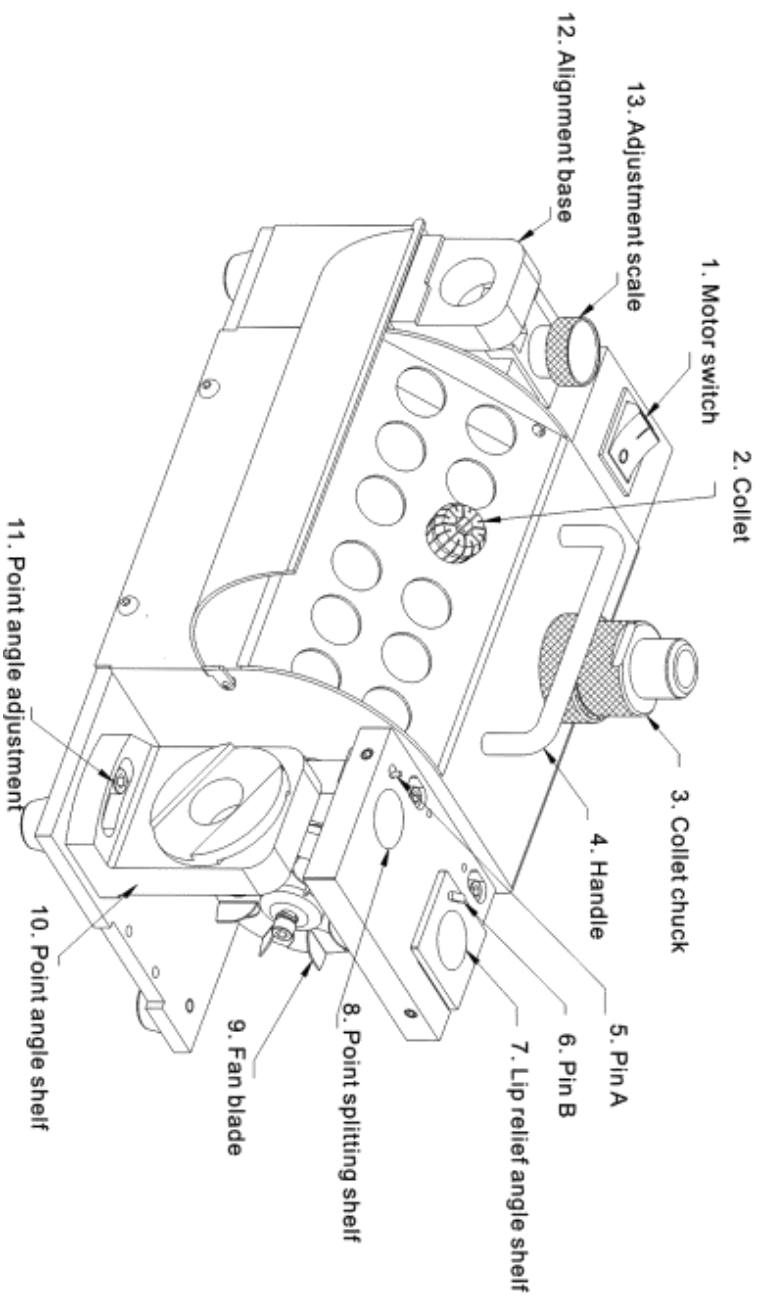


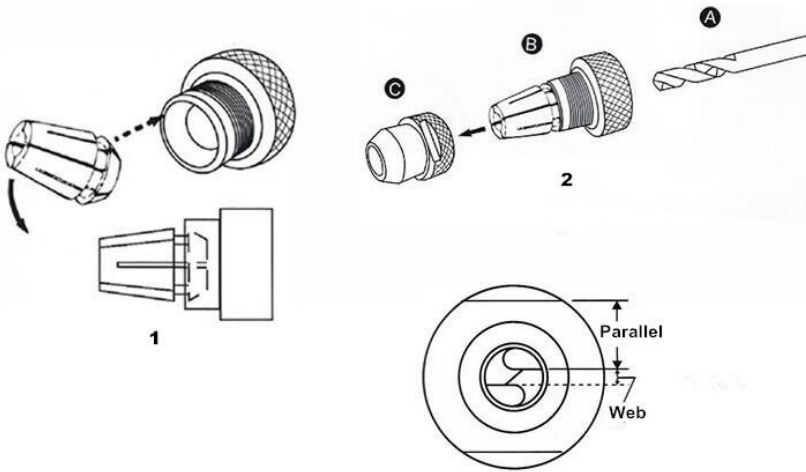


Model	Grinding Range	Point angle	Power	Motor/ Speed	Weight	Dimension
13D	Φ3(2)-φ 13(15)	100°(95°)- 135°	220V, 50/60HZ	120W/ 4400rpm	10KG	32×18×19 cm

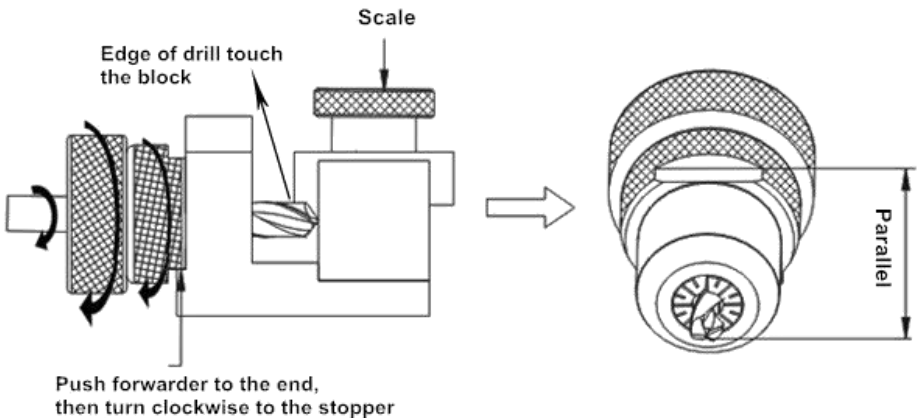
Standard Equipment	Grinding wheel :CBN (for HSS)×1 piece
	11 collets: φ3-φ13
	collet chuck ×1 piece
	Electric wire: 1piece
	2 pcs hexagon wrench (2.5mm, 4mm)
Optional Equipment	grinding wheel :SD (for Carbide)
	ER20 collet: φ2.5, φ3.5 φ4.5 φ5.5 φ14, φ15
	Collet chuck: φ15mm



※ Do not fully fasten the clamping nut with collet chuck, keep the drill able to be adjusted.

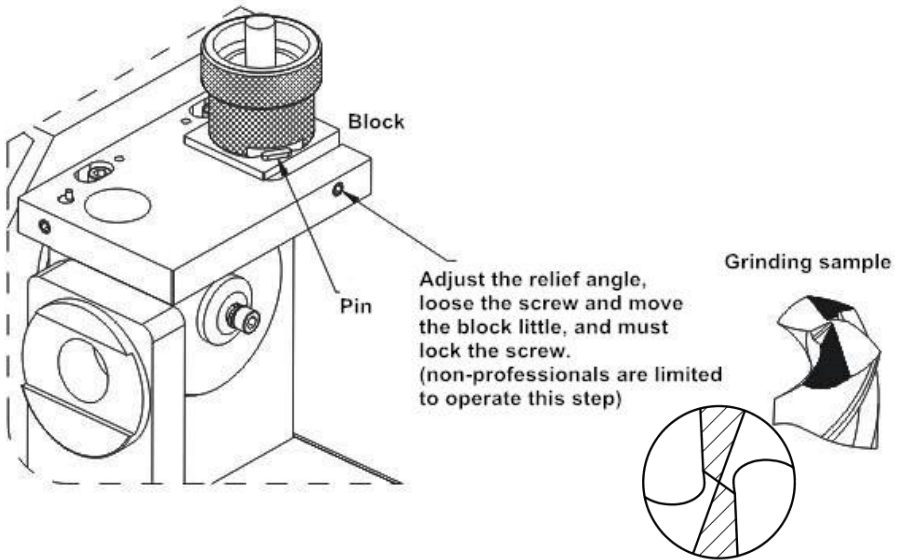


※ Make sure the cutting lip of drill is parallel with the slot of clamping nut before grinding job started. If it is not parallel, adjust it again.

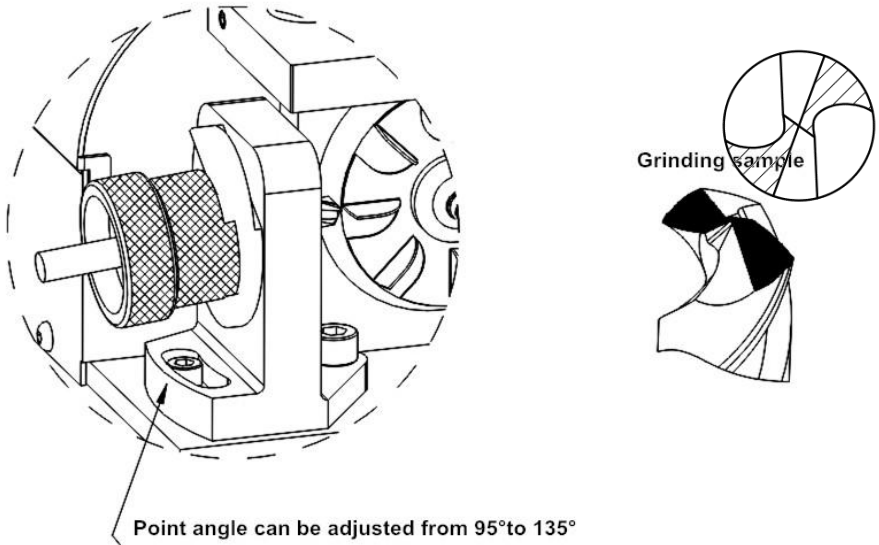


Attention: If the cutting lip is downward, must increase the scale of web adjustment shelf. If it is upward, please decrease the scale of the web adjustment

* While grinding, don't hold the stem of drill, it will affect the accuracy.

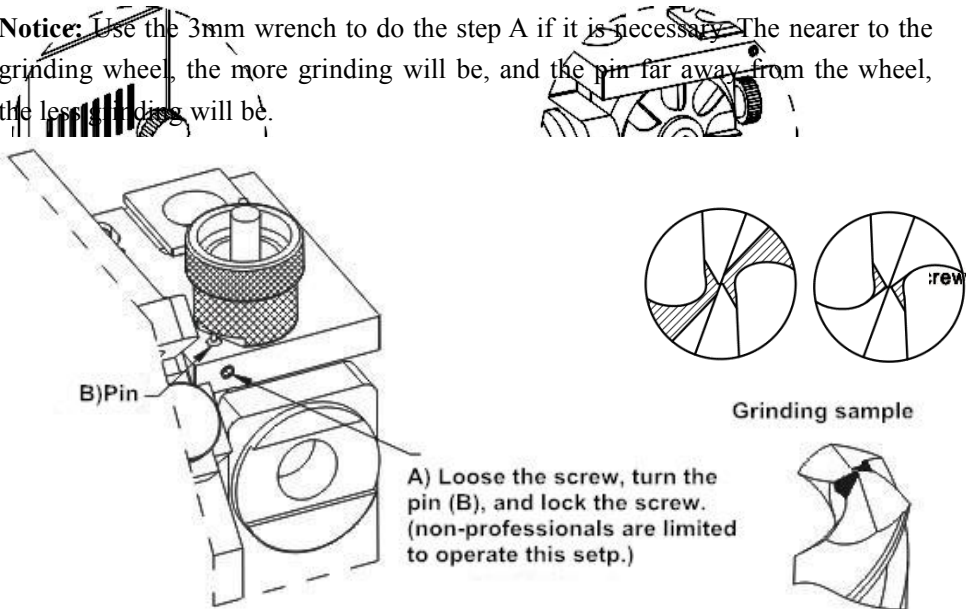


Grind the lip relief angle



Point grinding point splitting

Notice: Use the 3mm wrench to do the step A if it is necessary. The nearer to the grinding wheel, the more grinding will be, and the pin far away from the wheel, the less grinding will be.

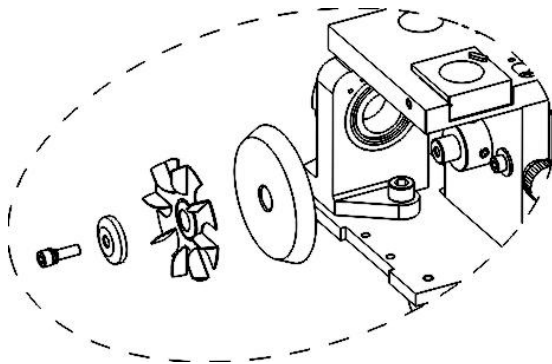


REPLACING THE WHEEL

A. Open the wheel cover

1. Make sure it is safe that the power cord is unplugged
2. Then use the 4mm hex wrench to loose the screw to open the cover.

B. Take out the grinding wheel



1. Use the brush to clean the machine, then use dry cloth to clean the surface.
2. If you just use the the machine, please wait 3 minutes after the grinding temperature is fall.
3. Use the left hand to hold the wheel, then use the 4mm hex wrench to loose the screw counterclockwise by right hand.
4. Take out the diamond grinding wheel on the machine.
5. Replace the new grinding wheel.
6. Put the wheel into the principal axis of motor, and tighten the screw and the wheel cover to complete.

Notice: motor principal axis is very precise, if wrong work may be leading to the damage, thus affecting grinding wheel position.

