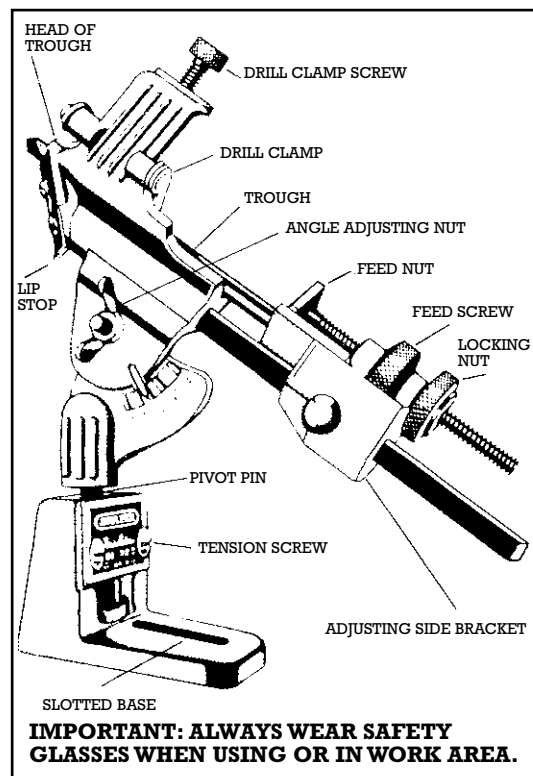
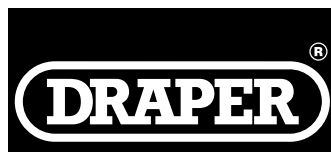


WARNING:

The Health and Safety Executive recommend in their document HS(G)17 that grinding is only performed on the face of the grinding wheel and not on the side of the wheel. To grind on the side of the wheel could cause wear and weaken the wheel.



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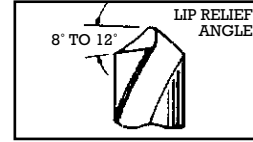
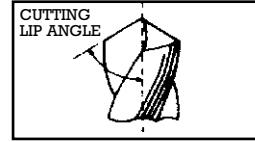
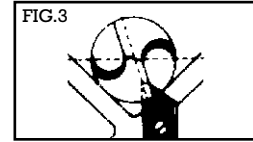
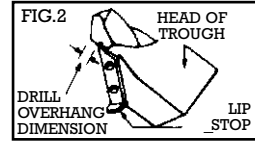
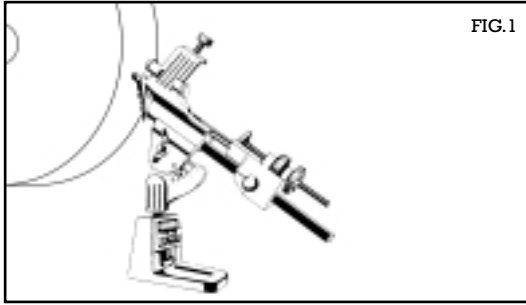
DRILL GRINDING ATTACHMENT

STOCK No.10751 PART No.1180

• INSTRUCTIONS •

IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY TO ENSURE THE SAFE AND EFFECTIVE USE OF THIS TOOL.





To produce the best results, the attachment must be situated in the right position in conjunction with your bench grinder. With the varying designs in bench grinders, either the bench grinder or the attachment may have to be raised with packing.

The attachment must also be securely fixed with bolt washers and butterfly nut in the slotted base, which also helps with adjustment.

The attachment must be positioned so that it brings the head of the trough to the face of the wheel (Fig. 1).

Varying positions can be obtained with the aid of the slotted base, pivot pin and adjusting nut, for setting the drill angle.

Operating Instructions:

1. Unscrew drill clamp and lip stop just enough to allow for the drill to be inserted into trough. At the same time, release the locking nut and adjust the feed screw on the slide bracket, allowing the drill to protrude at the trough head. The feed screw nut

should now be adjusted to produce the overhang required. (See table for overhang and Fig. 2). Tighten locking nut on slide bracket, raise the lip stop and secure behind cutting edge of the drill and tighten drill clamp. (Fig. 3).

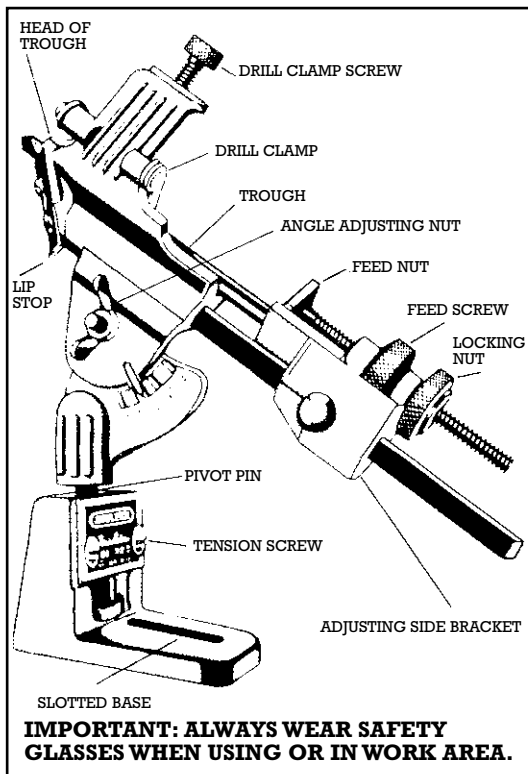
2. Unscrew butterfly nut on the base and move whole unit until drill tip touches the grinding surface and then secure.
3. Swing the attachment back and forth on the pivot pin so that the drill tip just touches the grinder.
4. Start grinder and slowly swing attachment back and forth, using the feed screw to achieve grinding.
5. Experience with use will tell you when an edge has been ground. At this point turn off grinder, release drill clamp screw and turn drill bit over to grind the opposite angle. Tighten clamp and commence as before.

Drill angles obtainable and overhang required:

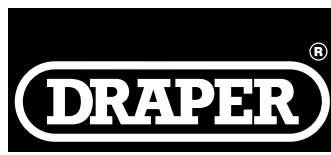
Angle	Overhang	Usage
88°	1.16"	Hard materials, thin sheet. Helps to prevent snatching.
68°	Half drill diameter	Small drill for high volume production.
59°	Half drill diameter	General purpose drilling.
49°	Drill diameter	Soft materials, (plastic, wood, lead, copper, light alloy, etc.)
41°	As required	Countersinks.

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