

# Drill Re-Sharpening Machine

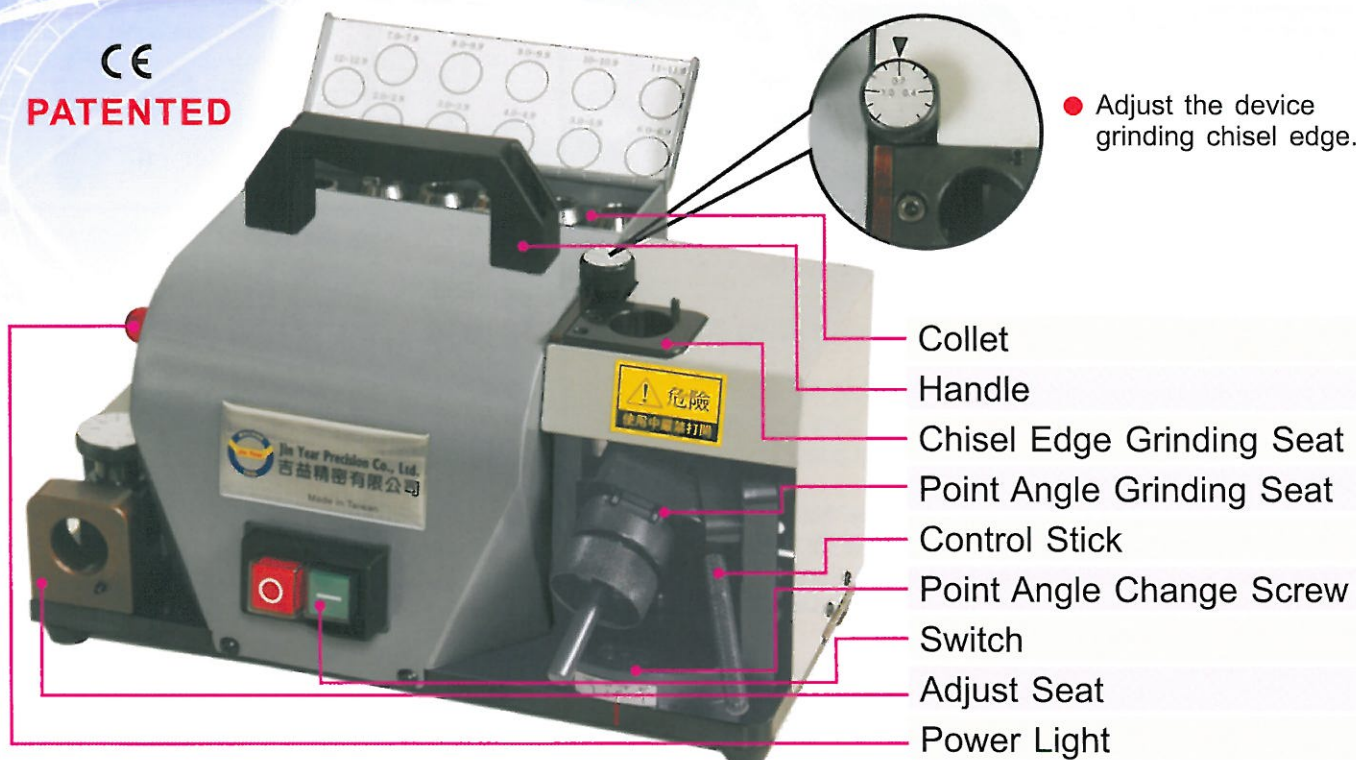
**NEW**

"Accurate+Sharp+Durable" Can meet your demand

★ First to research and development "up to down" swinging grinding way

CE

**PATENTED**



Key Point: 1. This machine has the "CE safety authentication".  
2. Operates is fast and simple. The quality is stable.  
3. Point Angle 90°~135°.(Generally is suitable 118°)  
4. Chisel edge grinding. Can adjusting by your demand.  
5. It's the first to research and development "up to down" swinging grinding way.  
The drill grinding is sharpest, the most durable.

Very sharp



More blunt



● Our company research and develops, swing the drill grinding from up to down, very sharp.

● Generally rotate the drill grind from left to right, more blunt.



UP  
DOWN

● The way to grind drill, swing for the most standard method of grinding from up to down, the drill grinding is sharpest, the most durable.

Specifications	JD-213	JD-1326
Drill Diameter	Ø2.0~Ø13.0	Ø13~Ø26
Point Angle	90°~135°	90°~135°
Power Supply	AC-110V,220V	AC-110V,220V
R.P.M of Motor	5100 R.P.M	4200 R.P.M
Grinding Wheel	CBN#200	CBN#150
Net Weight	8kg	26kg
Standard Accessories	Colletx11pcs Collet holder x1set Hexagon wrench 4mm/6mm (two kind of each)	Colletx13pcs Collet holder x1set Hexagon wrench 4mm/6mm (two kind of each)



# The operation showed

※ First put the handle and control stick in the right place. Make sure drill's material quality. Choose the suitable grinding wheel to use. Original machine provides the CBN grinding wheel. (The HSS material quality is suitable for the CBN grinding wheel. The tungsten steel material quality is suitable for the SD grinding wheel.) The drills material quality usually is HSS.

There are six steps.

## Step 1: Adjust the scale

- ⊗ At first, rotate right to the end of scale knob, and then rotate left to the size fitting the diameter of grinding drill.

## Step 2: Choose the suitable collet, put and insert in the collet chuck nut②

- ⊗ While inserting and putting the collet chuck nut② in the collet, the collet must be put after sloping first while inserting the neck of collet.

## Step 3: Installing sequence of the whole collet chuck setⒸ

- ⊗ Put the fixed base① and collet chuck nut② together first. Then put the drill in and lock it.
- ⊗ When you are locking, remember keep some space for the drill to adjust.

## Step 4: Adjust the point angle of the drill

- (1) First put the whole collet chuck setⒸ into adjust seatⒹ, after totally closely fitting, and rotate the fixed base① to the right side.
- (2) The drill reaches the inmost place of the adjust seatⒹ, rotate the drill to the right.
- (3) Rotate the collet chuck nut② right, and lock the drill tightly.
  - ※ After these actions, take out the chillet chuck setⒸ. Please make sure the drill edge and the fixed base① chamfer place is parallel. If it's not, please do **Step 4** again. Until they all parallel.

## Step 5: Grinding drill bit

The scale is 90 degrees ~135 degrees.

The drill bit generally is 118 degrees.

- ⊗ Turn on the power. Put the collet chuck setⒸ into point angle grinding seatⒺ. Make sure the collet chuck setⒸ chamfer place aimed at the point angle grinding seatⒺ pin, rotate to right side, push it reach grinding wheel lightly. **Swing from up to down**. Until the grinding sounds disappear. Then the collet chuck setⒸ rotate to left side, push it reach grinding wheel lightly. **Swing from up to down**. Until the grinding sounds disappear too. Take out collet chuck setⒸ, turn it 180 degree upside down. Put it in, and make sure chamfer place and pin again. Swing from up to down. Until the grinding sounds disappear.

## Step 6: Grinding chisel edge of the drill.

- ⊗ Put the collet chuck setⒸ into chisel edge grinding seatⒻ. Make sure collet chuck setⒸ chamfer place aimed at the chisel edge grinding seatⒻ pin. Then push it reach grinding wheel lightly. This time we swing from left to right, until the grinding sounds disappear. Take out collet chuck setⒸ, turn it 180 degree upside down. Put it in, and make sure chamfer place and pin again. Same way grinding, until the grinding sound disappear too.

## ※ Adjuster grinding chisel edge(see picture 6)

It can always do the adjustment by your demand. Usually the chisel edge a thickness of 7mm

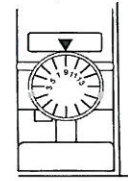
## ※ Replacement of the grinding wheel (Make sure the power off. Pull out the electric wire. Safety first.)

- (1) Loosen the screw from the machine. Open the top. (see picture A)
- (2) Loosen fixed grinding wheel screw to change wheel. ( see picture B)

## ※ Replacement of the fuse (Make sure the power off. Pull out the electric wire. Safety first.)

- (1) Take out the fuse box. (see picture A)
- (2) Change the new fuse. And put it back. (see picture A)

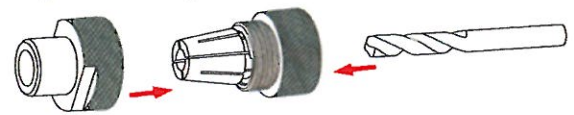
### Step 1: Adjust the scale



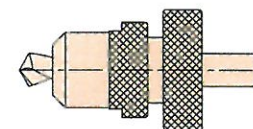
### Step 2: Put the collet into the collet chuck nut 2



### Step 3: Installing the whole collet chuck set

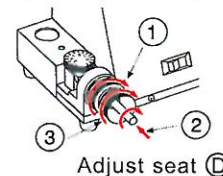


fixed base.① collet + collet chuck nut.② drill.③

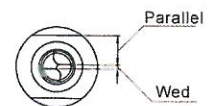


collet chuck setⒸ

### Step 4: Adjust the point angle of the drill



Adjust seat Ⓓ



### Step 5: Grinding drill bit

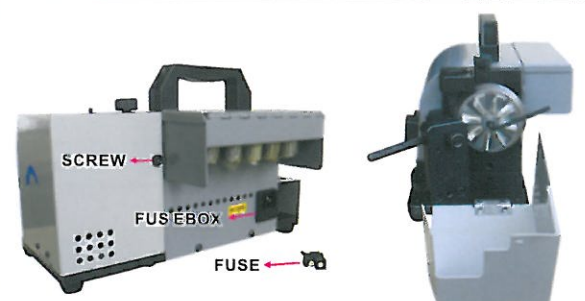


Point angle grinding seatⒺ

### Step 6: Grinding chisel edge of the drill



Chisel edge grinding seatⒻ



Picture A

Picture B