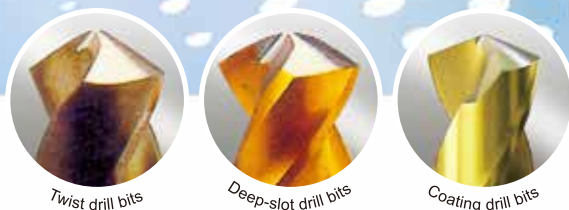


Twist Drills Resharpener

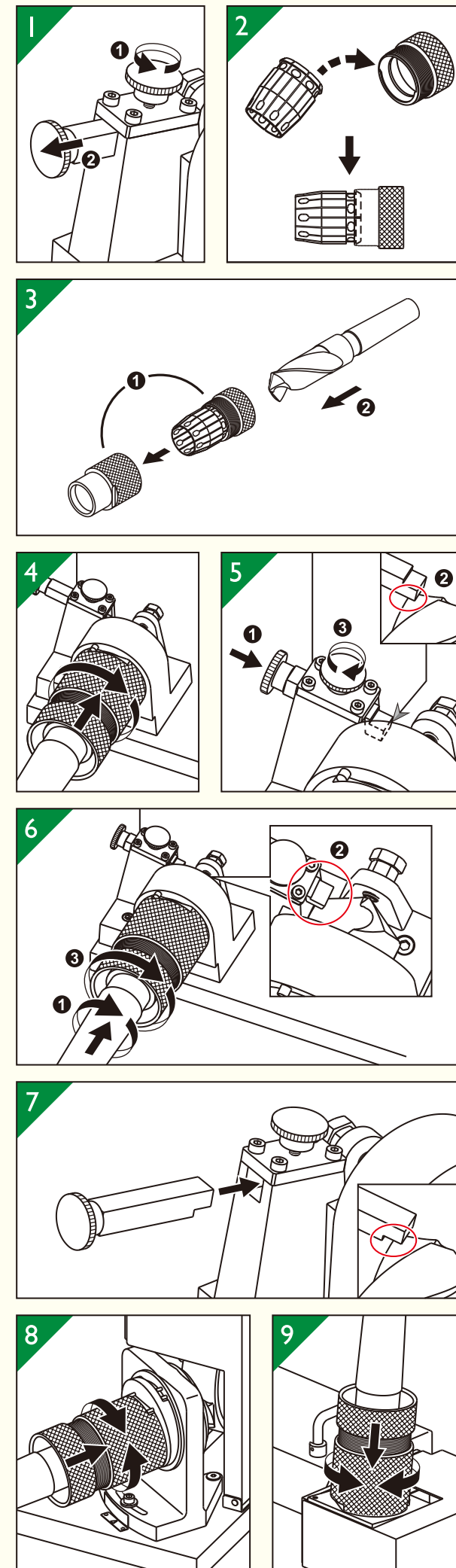
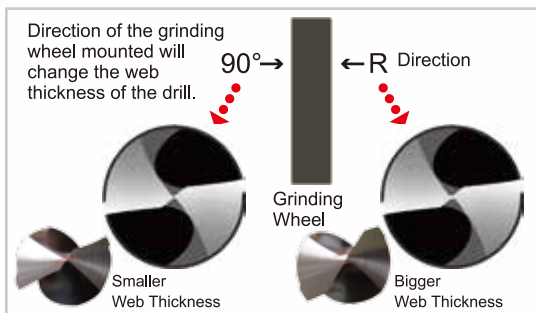
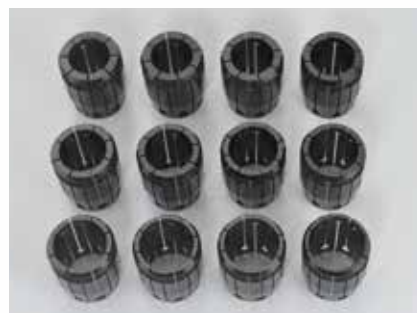
Super affordable and easy to carry features

Super Function
Economy



Model	GS-52
Drill Diameter	Φ 34.1mm~ Φ 52mm
Point Angle	118°~ 140°
Power Supply	AC220V 3-Phase or 380V(Opt.)
R.P.M of Motor	50Hz / 2800 R.P.M. , 60Hz / 3330 R.P.M.
Grinding Wheel	CBN #100 (For HSS Drill Bits)
Weight	N.W. 29.2Kg / G.W. 30.5Kg
Machine Size	L:384mm W:285mm H:312mm
Packing Size	L:470mm W:360mm H:440mm
Type of Thinning	X Thinning
Standard Accessories	Chuck Set x 1 sets (2pcs) Hexagon Wrench 3mmx1, 5mmx1
Optional Accessories	Collet Φ 35,36,37,38,39,40,41,42,43,44,45,46,47,48,49,50,51,52mm Wooden Box for Collets Plastic Box for Collets

For Φ34.1~52mm Twist Drill Resharpener
Adjustable Point Angle 118° - 140°
All Collets Φ35~52mm is Opt.
Wooden Box and Plastic Box is Opt.



OPERATION

- I. Choose the proper grinding wheel according to the material of the drill.
 - HSS material drill use CBN grinding wheel (Standard).
 - Carbide / Tungsten material drill use SD grinding wheel (Optional).
- II. Preset the position of the alignment block. (Fig. 1)
 1. Loosen the screw by counterclockwise.
 2. Pull out the alignment block to the end.
- III. Chuck set assembly:
 1. Choose the proper collet according to the drill diameter.
 2. Put the collet into collet holder by 45° angle. (Fig. 2)
 3. Screw in a little bit by clamping nut (Fig. 3 step ①), then insert the drill through the chuck set (Fig. 3 step ②) and push in until the drill is out of the clamping nut about 30 mm.
 - * Do not fully tighten the chuck set, keep the drill is still able to be adjusted.
- IV. Drill positioning:
 1. Insert the chuck set into the positioning shelf and fit them with no gaps, then turn the chuck set clockwise until it stops by the pin. (Fig. 4)
 2. Adjust the alignment block to proper position. (Fig. 5)
 - ① Slowly move alignment block inward.
 - ② Turn the drill clockwise until the outer corner of the drill's lip touches the tip of the alignment block.
 - ③ Tighten the screw by clockwise to lock the alignment block.
 3. Push the drill to the end and slowly turn it clockwise until it stops by the alignment block. (Fig. 6 step ①, ②)
 4. Turn the collet holder clockwise to secure the drill. (Fig. 6 step ③)
 5. Gently turn the chuck set counterclockwise and take it out.
 - * Make sure the drill's cutting edge is angled towards the slot of clamping nut before starting the grinding procedure.
 - * If the drill's cutting edge is parallel to or angled away from the slot of clamping nut, take out the alignment block and turn it upside down to make the slot face downwards (Fig. 7). Then reposition the drill.
- V. Web Thinning Adjustment:

When the grinding wheel is initially installed, the side with 90° angle will face inside by default, this will provide a smaller Web Thickness. You can get a bigger Web Thickness by changing the wheel to the other side (R angle).
- VI. Drill Grinding:
 - * Do not hold the drill shank while grinding, it may affect the grinding accuracy.
 - 1. Verify the drill's point angle and adjust the angle of the cutting lip grinding shelf to the same before grinding procedure. (Angle adjustment available is 118° - 140°)
 - 2. Turn the power switch on and wait about 10 seconds until the motor rotation is stable.
 - 3. Cutting Lip Grinding (Fig. 8)

Insert the chuck set into the cutting lip grinding shelf, align the slot of clamping nut to the two pins on the grinding shelf, push the chuck set gently and turn it clockwise and counterclockwise until the grinding noise stops. Turn the chuck set to the other side and grind the drill in the same way.
 - 4. Web Thinning (Fig. 9)
 - * When inserting or taking out the chuck set, the center part of the clamping nut slot should align to the two pins on the grinding shelf. Insert the chuck set into the web thinning grinding shelf, push the chuck set gently and turn it clockwise and counterclockwise until the grinding noise stops. Turn the chuck set to the other side and grind the drill in the same way.
- VII. Please clean the ash on each grinding shelf after finishing the grinding job.

