

INSTRUCTION MANUAL

PP-13C Precision Drill Sharpener (240V) 3-13mm - 1/8"-1/2"



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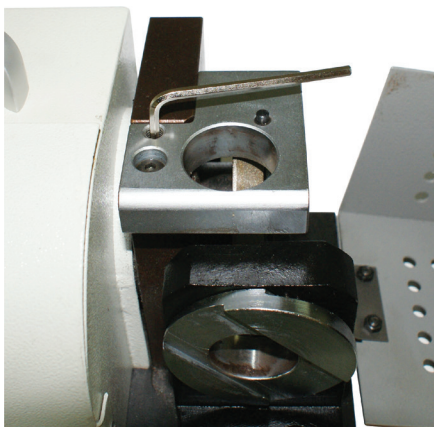
Cutter & Tool Grinder



PP-13C Drill Bit Grinding Machine



- Fast and accurate grinding operation suitable for even inexperienced operators
- Cost effective with high benifiets
- Diamond wheel for long life and accurate angles
- Electronically controlled powerful motor
- Bearing locking device for accurate location of the angle setting



The Dead centre point of the machine can be set by using the allen screws under the grinding wheel cover. (as shown)

This allows the machine to be adjusted so that the wheel is in the correct place to insure prolonged life of the cutting tool when ground on the machine. This is normally set by the factory and may never be required to be adjust. If the wheel is changed or wear takes place, this is usually when the adjustment may be required.



- Dead centre point - suitable for drilling hard materials with high rigidity. Enables long life & produces less heat



- Dead centre point - can cause drills to wander when drilling a hole with out a pilot.



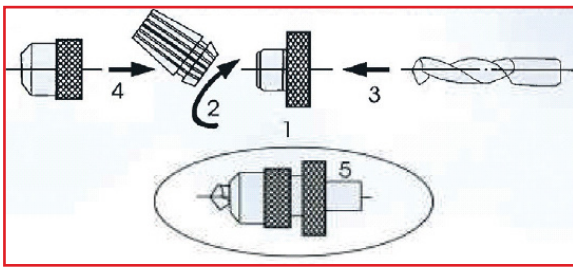
- Dead centre point - this configuration is the most popular profile for most steel applications



- Dead centre point - splitting the point is good for aluminum, copper, plastic and mild steel when no pilot hole is drilled. Holds the drill true.

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PP-13C Drill Bit Grinding Machine



1 Assembly of the Drill with the Collet Chuck

Assemble the drill in the collet chuck according to steps 1,2,3,4 above



2 Setup the Drill in the Collet Chuck ready for Sharpening

First dial up the size of the drill to be ground and then place the drill chuck in the opening above the dial. Slide the drill into the chuck from the top and twist the drill clockwise until it stops.

Now twist the drill chuck clockwise until it stops and then tighten the drill chuck using the top knurled section.

The drill is set now ready to grind.



3 Grinding the Leading Edge Angle

Turn on the drill sharpener and then place the drill chuck in the hole in the base of the machine in the location slot. Move the chuck in slowly until the grinding takes place and rotate the chuck in a clockwise and anti clockwise direction until the drill chuck in completely home and the grinding stops. Take out the chuck and rotate the chuck 180° then repeat the operation.



4 Grinding Heel Clearance Angle

Once the drill has been ground then place the chuck in the top hole with the location slot. Rotate back a forth until all grinding stops. Take out the chuck and rotate 180° and repeat the operation.

The amount of grinding in this operation determines the severity of the split point or amount of relief

It is advisable to remove the chuck often and view the results.

Item	Model	PP-13C
Grinding capacity		φ3~φ13mm
Leading edge angle		90° ~135°
Power supply		AC110V AC220V (Single-phase)
Horsepower		1/4HP 180W
RPM		5300 rpm
Diamond grinding wheel		CBN#200
Weight		Net Weight:9.5kgs Gross:10kgs
Packing Size L×W×H		31×18×19cm
Standard parts:		Grip:φ3,4,5,6,7,8,9,10,11,12,13×11pcs Grip Holder Grou:1pcs Hexagon Spanner:4m/m×1pcs

- Special accessories(grip):φ2,2.5,3.5,4.5,5.5,6.5,7.5,8.5,9.5,10.5,11.5,12.5 totally 11.
- What are listed are those certified by CE. If you need CE, additional fees will be charged.
- We retain the right to change the specifications without notification.

