



SAFEWAY

SAFEWAY PRECISION DRILL SHARPENER



Features

- User friendly with simple operations.
- Diamond wheel supplied for long life
- Manufactured from steel with no die cast or plastic components
- 240 Volt motor
- Grinds drills to precision points in a range of angles from 110 - 135 deg.
- Other features are split point and back relieving

Model SA-1300 3-13mm Cap. (D114)
Drills held in ER20 Collets supplied

Model SA-2500 12-25mm Cap. (D115)
Drills held in ER40 Collets supplied

Setup Instructions

1. Select the correct collet. Collets have 1mm of movement allowing for both imperial and metric drills. Ensure that the collet is placed in the adapter correctly so as to hold it securely, and allow for the collet to release when the adapter is unscrewed (Fig.1)



Fig.1

2. Set the setting gauge so that the size of the drill is against on the yellow line. (Fig.2)



Fig.2



Setup Instructions Cont.

3. Place the holder in the setting gauge insuring that the holder has been turned clockwise so that holder is hard up against the stop pin. Place the drill in the holder and with the drill point sitting on the base of the setting gauge rotate clockwise until the drill flute comes to a stop against the setting gauge. Then tighten. (Fig.3)

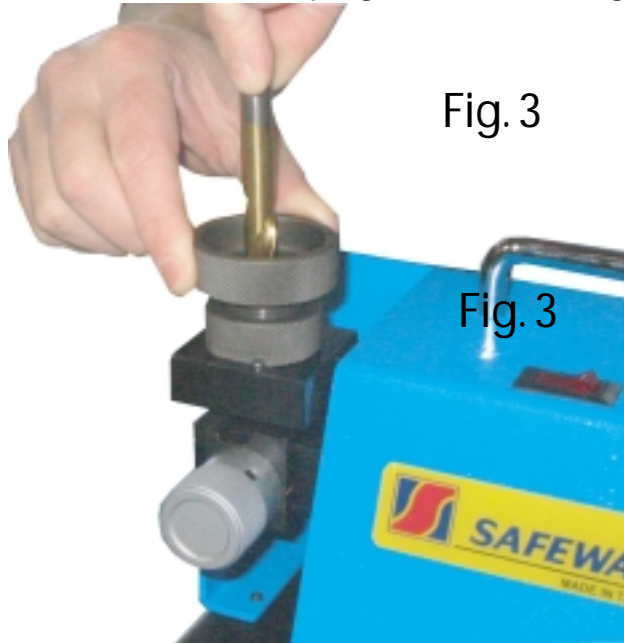


Fig. 3

4. Loosen the socket head cap screw that secures the point grinding locator and set the point angle SA-1300 100-135 deg. SA-2500 90-140 deg. (Fig.4)



Fig. 4

5. Take the holder and place in the grinding locator which uses the two pins to set the correct position of the drill. Slowly insert until the drill touches the wheel then rotate back and forth slowly moving the holder deeper into the locator until the wheel sparks out. Withdraw the holder and rotate 180 deg. and complete the operation for the other side of the drill point (Fig.5)



Fig. 5

6. To split the point or back relieve the drill, place the adaptor in the top locator. (Fig.6) For just split point locate the holder against the pin (Fig.7) at the full clockwise position and rotate slightly anti clockwise. For back relieving rotate anti clockwise until adaptor comes to rest on the pin (Fig.8)



Fig. 6

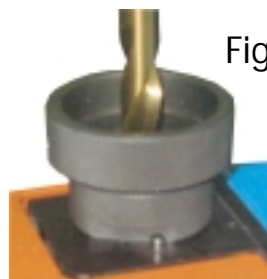


Fig. 7

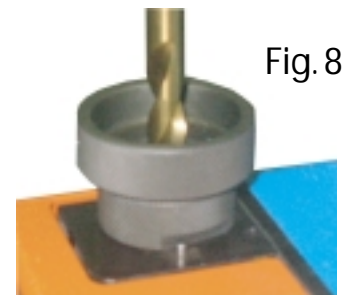


Fig. 8



Setup Instructions Cont.

3. Place the holder in the setting gauge insuring that the holder has been turned clockwise so that holder is hard up against the stop pin. Place the drill in the holder an with the drill point sitting on the base of the setting gauge rotate clockwise until the drill flute comes to a stop against the setting gauge. Then tighten. (Fig.3)

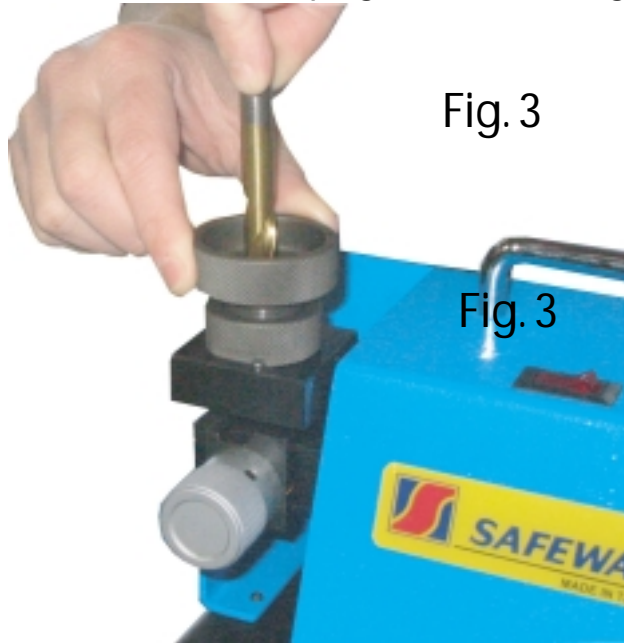


Fig. 3

4. Loosen the socket head cap screw that secures the point grinding locator and set the point angle SA-1300 100-135 deg. SA-2500 90-140 deg. (Fig.4)



Fig. 4

5. Take the holder and place in the grinding locator which uses the two pins to set the correct position of the drill. Slowly insert until the drill touches the wheel then rotate back and forth slowly moving the holder deeper into the locator until the wheel sparks out. Withdraw the holder and rotate 180 deg. and complete the operation for the other side of the drill point (Fig.5)



Fig. 5

6. To split the point or back relieve the drill, place the adaptor in the top locator. (Fig.6) For just split point locate the holder against the pin (Fig.7) at the full clockwise position and rotate slightly anti clockwise. For back relieving rotate anti clockwise until adaptor comes to rest on the pin (Fig.8)



Fig. 6

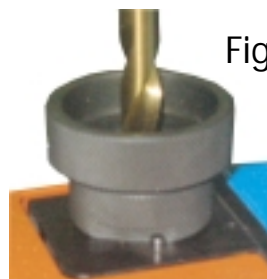


Fig. 7

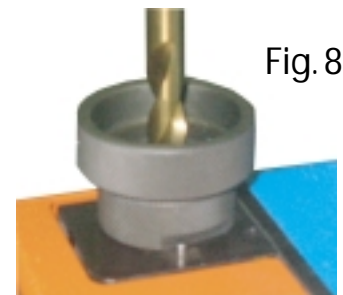


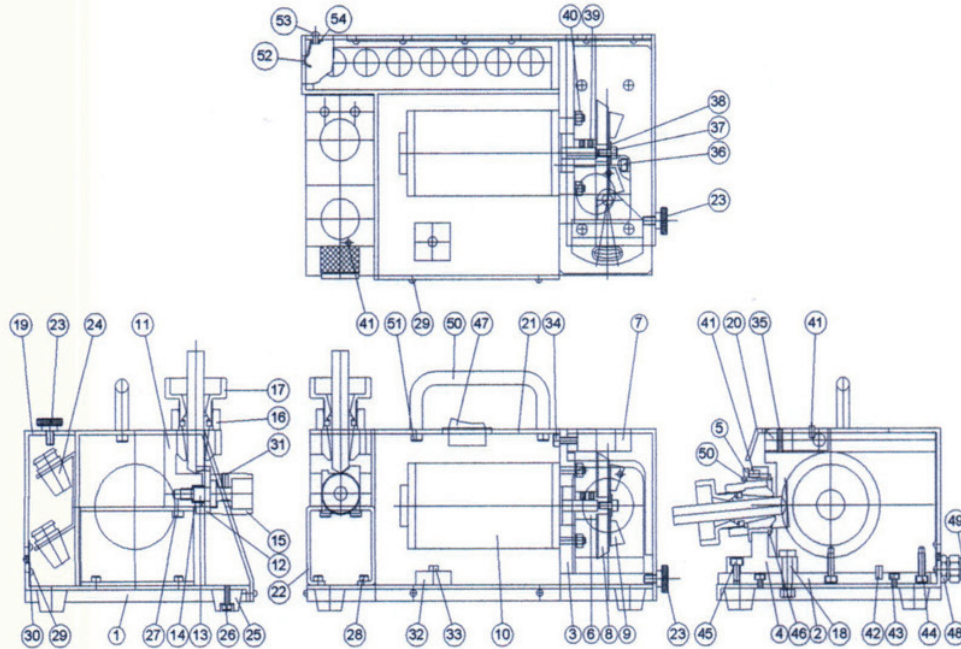
Fig. 8

**D114 SAFEWAY SA-1300 DRILL SHARPENER
D115 SAFEWAY SA-2400 DRILL SHARPENER**

Please note when ordering SA-2400 parts just change the SA-1300 on the drawing under Part number to SA-2400

**SAFEWAY MACHINERY INDUSTRY CORPORATION
PART LIST**

Computer No	078201300	Model	SA-1300	Drill Drinding Machine	Date	13 Sep. 2004
-------------	-----------	-------	---------	------------------------	------	--------------



No	Computer No	Part No	Part Name	Q	Remark
					32 078201300-02 SA-1300-026 Bridge Diode 1 100
1	078201300-00	SA-1300-001	Base Bracket	1	
2	078201300-00	SA-1300-002	Base Plate	1	
3	078201300-00	SA-1300-003	Motor Bracket	1	
4	078201300-00	SA-1300-004	Angle Bracket	1	
5	078201300-00	SA-1300-005	Angle Cam	1	
6	078201300-00	SA-1300-006	Sleeve	1	
7	078201300-00	SA-1300-007	Chisel edge Bracket	1	
8	078201300-00	SA-1300-008	Wheel (#200)	1	
	078201300-03	SA-1300-038	Wheel (#400)	1	
9	078201300-00	SA-1300-009	Fan	1	
10	078201300-01	SA-1300-010	Motor (110V)	1	DC110V
	078201300-04	SA-1300-040	Motor(220V)	1	DC220V
11	078201300-01	SA-1300-011	Length Pre-setting Bracket	1	
12	078201300-01	SA-1300-012	Position Pre-setting block	1	
13	078201300-01	SA-1300-013	Position Pre-setting Screw	1	
14	078201300-01	SA-1300-014	Spring	1	
15	078201300-01	SA-1300-015	Scale	1	
16	078201300-01	SA-1300-016	Collet Holder	1	
17	078201300-01	SA-1300-017	Collet Nut	1	
18	078201300-01	SA-1300-018	Shaft	1	
19	078201300-01	SA-1300-019	Back Cover	1	
20	078201300-02	SA-1300-020	Side Cover	1	
21	078201300-02	SA-1300-021	Front Cover	1	
22	078201300-02	SA-1300-022	Bracket	1	
23	078201300-02	SA-1300-023	Knob	1	
24	ER20	ER20	ER20 Collet	13	φ 3-13
25	078201300-02	SA-1300-024	Rubber Pad	4	
26	SCM04x15L	SCM04x15L	Socket Cap Screw	2	M4x15L
	SCM04x25L	SCM04x25L	Socket Cap Screw	2	M4x25L
27	SCM05x12L	SCM05x12L	Socket Cap Screw	2	M5x12L
28	SCM04x08L	SCM04x08L	Socket Cap Screw	4	M4x8L
29	SDM03x06L	SCM03x06L	Round Socket Cap Screw	12	M3x6L
30	078201300-02	SA-1300-025	Leaf	3	
31	SCM05x10L	SCM05x10L	Socket Cap Screw	1	M5x10L
					33 SCM04x15L SCM04x15L Socket Cap Screw 1 M4x15L
					34 SCM05x15L SCM05x15L Socket Cap Screw 1 M5x15L
					35 SSM04x16L SSM04x16L Set Screw 1 M4x16L
					No Computer No Part No Part Name Q Remark
					36 SCM05x50L SCM05x50L Socket Cap Screw 1 M5x50L
					37 SCM05x10L SCM05x10L Socket Cap Screw 1 M5x10L
					38 WS05 WS05 Washer 1 M5
					39 SSM04x06L SSM04x06L Set Screw 2 M4x6L
					40 HN05 HN05 Nut 2 M5
					41 PIN04x08L PIN04x08L Pin 3 4x8L
					42 PIN05x08L PIN05x08L Pin 2 5x8L
					43 SCM04x08L SCM04x08L Socket Cap Screw 4 M4x8L
					44 SCM05x15L SCM05x15L Socket Cap Screw 3 M5x15L
					45 SCM05x12L SCM05x12L Socket Cap Screw 1 M5x12L
					46 SR-R40 SR-R40 Snap Ring 1 R40
					47 078201300-02 SA-1300-027 Switch 1
					078201300-04 SA-1300-041 Switch (CE) 1 CE
					48 078201300-02 SA-1300-028 Cable Nut 1
					49 078201300-02 SA-1300-029 Cable Nut 1
					50 078201300-03 SA-1300-030 Handle 1
					51 SCM05x10L SCM05x10L Socket Cap Screw 2 M5x10L
					52 078201300-03 SA-1300-031 Power Cable 1
					53 078201300-03 SA-1300-032 Plug 1
					54 078201300-03 SA-1300-033 Name Plate 1
					55 078201300-03 SA-1300-034 carton 1
					56 078201300-03 SA-1300-035 Attention Sign 1
					57 078201300-03 SA-1300-036 AC110-120V sign 1
					58 078201300-03 SA-1300-037 AC220-240V sign 1