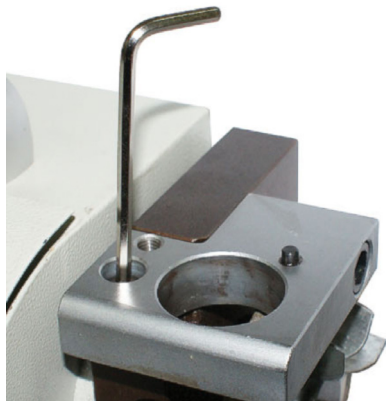


D112

**PP-26 DRILL SHARPENER**



- ❑ Fast and accurate grinding operation suitable for even inexperienced operators
- ❑ Cost effective with high benefits
- ❑ 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 ensure 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.



Fig.1

- ❑ General purpose point is used in a wide variety of materials. (Fig.1) This is the most common drill point used in the industry  
 The disadvantage with this type of centre point is that it can cause drills to wander when drilling a hole without first drilling a pilot hole.  
 Angles range between 118°- 135°

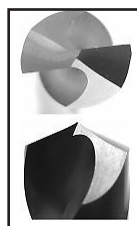
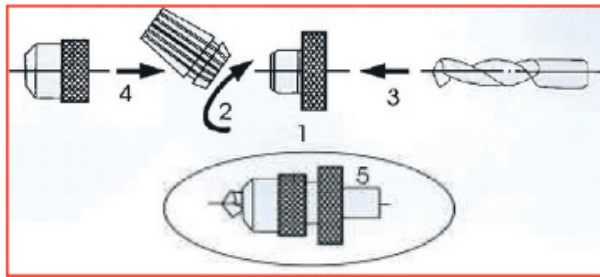


Fig.2

- ❑ A second operation can produce a split point on the drill cutting edge. This centre point allows for the drilling of holes without a pilot drill.  
 Suitable for most steel applications. Split self centering points minimizes the chisel length, and reduces thrust. The split point produces a positive rake angle improving the chip cutting ability at the center of the drill point (Fig.2)



## 1 Assembly of the Drill with the Collet Chuck

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



## 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

MODEL	PP-26
Capacity	12 - 26mm
Voltage	240V
Power	450Watts
Amp	2.5A
Speed	3000rpm
Grinding Wheel	CBN#200
Grinding Angle	118 - 140°
Point Angle	90 - 145°
Collet System	Modified ER40

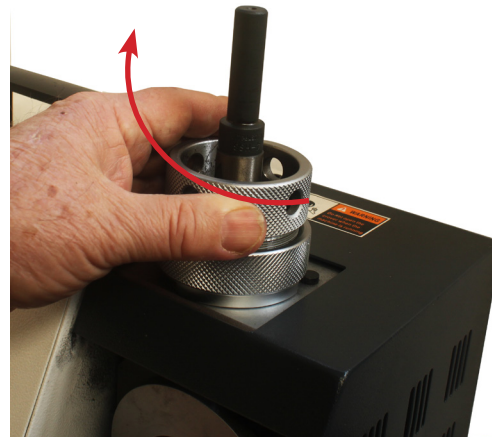


## 2 Setup the Drill in the Collet Chuck ready for Sharpening

First rotate the dial fully clockwise until it can no longer rotate. Wind the dial anti-clockwise to dial up the size of the drill to be ground and then place the drill chuck in the opening in front of the dial. Slide the drill into the chuck from the rear 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 outer knurled section.

The drill is set now ready to grind.



## 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.

Remove 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