



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





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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)

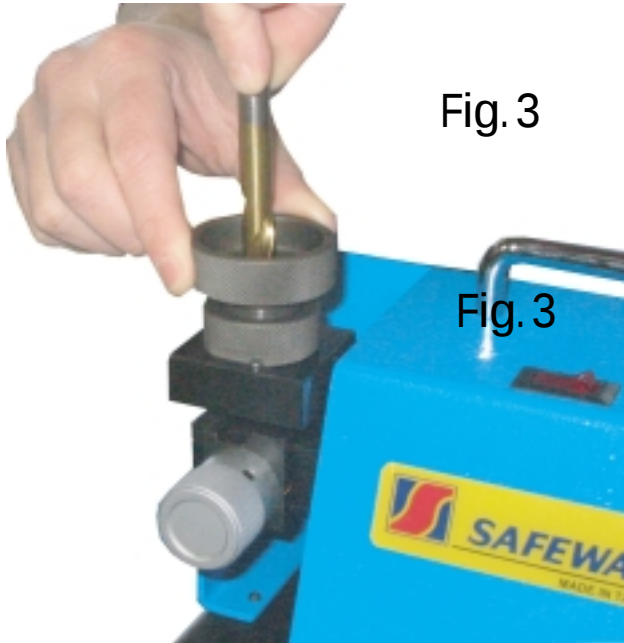


Fig. 3

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

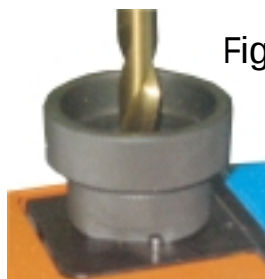


Fig. 7

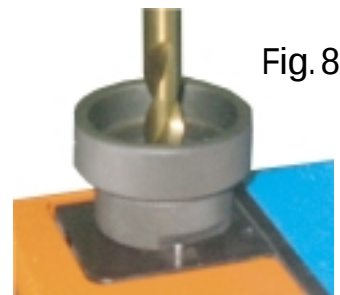


Fig. 8



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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)

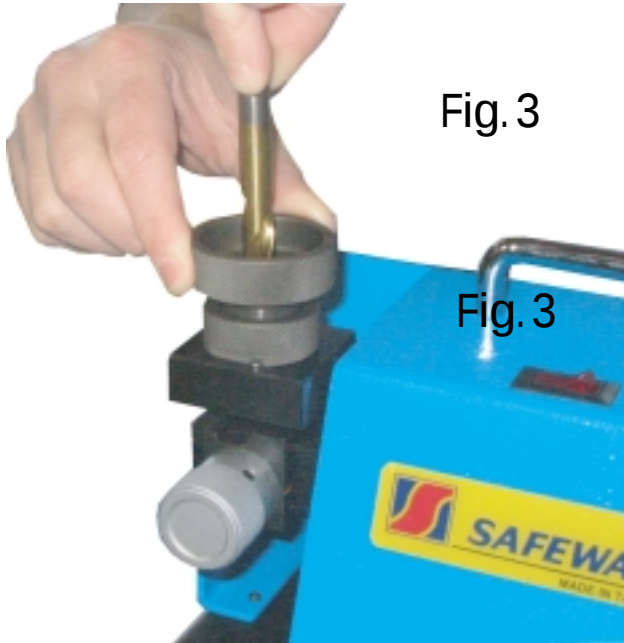


Fig. 3

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)



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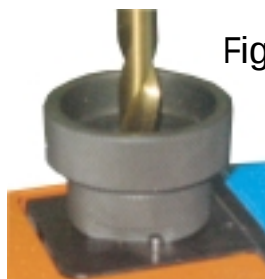


Fig. 7

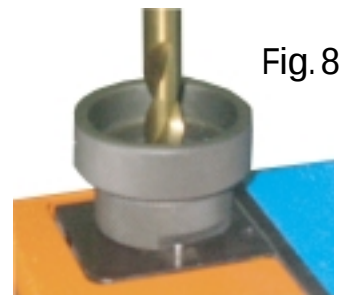


Fig. 8

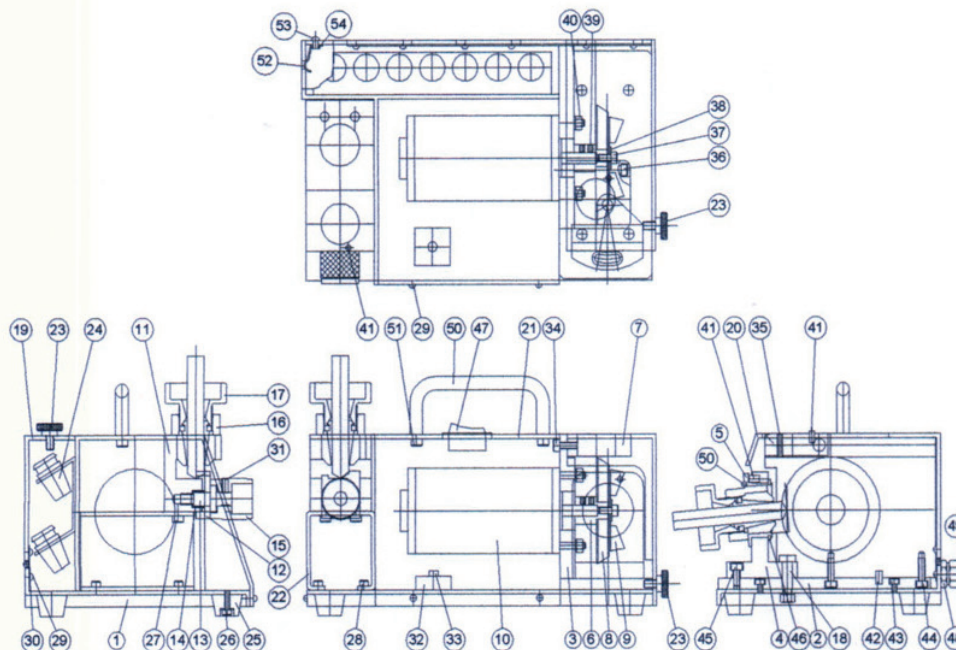
D114 SAFEWAY SA-1300 DRILL SHARPENER

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