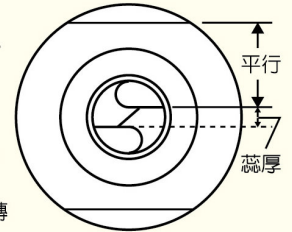


### 操作說明：

- 先確定鑽頭材質，並選用合適之砂輪使用，原機配備CBN砂輪。  
(CBN砂輪適用HSS材質) (SD砂輪適用錫鋼材質)
- 將調整台調整刻度歸零：順時針旋轉到底，逆時針調到“0”的位置。
- A) 選擇適用筒夾放入夾頭座。(以45度將筒夾嵌入夾頭座)  
B) 放入順序：筒夾及夾頭座與固定夾頭螺帽連接，再將鑽頭由夾頭座方向放入直到鑽頭凸出約5mm。  
※應保持鑽頭少許調整空間。
- A) 將調整台刻度，調到欲修磨鑽頭之外徑尺寸。  
參考值：12mm 刻度調到12的位置  
12.2mm 刻度調到12.5的位置  
12.6mm 刻度調到13的位置  
B) 夾頭固定具組，放入調整台架且完全密接後，以順時針方向向右旋轉定位。  
C) 鑽頭先端插入底部後，以順時針方向向右旋轉定位。  
D) 夾頭固定具組，以順時針方向向右旋轉到底後並鎖緊。  
E) 取出夾頭固定具組時微微向左邊旋轉，然後取出。  
※夾頭固定具組取出後，確定鑽頭刀口與固定座缺口線平行，若不平行，需要重新調整。  
鑽頭刀口若比夾頭組缺口線低，要將刻度數字增加，若是較高時要將刻度鈕數字降低。
- 起動開關等馬達迴轉安定後(約10秒鐘)，將夾頭固定具組置入 I 號研磨座，夾頭組缺口部位對準研磨座之2支插銷後，輕輕推抵磨石左右轉動緩緩向前推到底，直到研磨聲音靜止取出，再轉180度，以同樣方式研磨到無聲為止。  
※GS-21鑽頭研磨尺寸由 $\Phi 12\text{mm} \sim \Phi 26\text{mm}$   
※GS-34鑽頭研磨尺寸由 $\Phi 12\text{mm} \sim \Phi 34\text{mm}$   
※先端角可調整角度如下：(90度 僅供中心鑽頭研磨)  
 $\Phi 12\text{mm} \sim \Phi 26\text{mm}$  90度 $\sim 140$ 度  
 $\Phi 26.1\text{mm} \sim \Phi 32\text{mm}$  118度 $\sim 140$ 度  
 $\Phi 32.1\text{mm} \sim \Phi 34\text{mm}$  125度 $\sim 140$ 度  
※研磨時不可握住鑽柄，用力將影響中心不平均。
- 研磨中心靜點時，將夾頭組放入 II 號研磨座，輕輕推抵砂輪，放入到底後，左右旋轉到無聲為止，取出轉向180度，以同樣方式研磨另一邊到無聲為止。  
※中心靜點研磨時，夾頭固定具組上、下取付動作，以夾頭固定具組缺口線約中心的位置對準研磨座上之定位銷。
- 研磨鑽頭後斜角時，將夾頭組放入 III 號研磨座，輕輕推抵砂輪，放入到底到研磨至無聲為止，取出轉向180度，以同樣方式研磨另一邊到無聲為止。  
※後斜角研磨一般使用在先端角125度 $\sim 140$ 度的鑽頭。
- 機器上所有接觸孔研磨好鑽頭後，必須立刻清潔，以利下次使用。



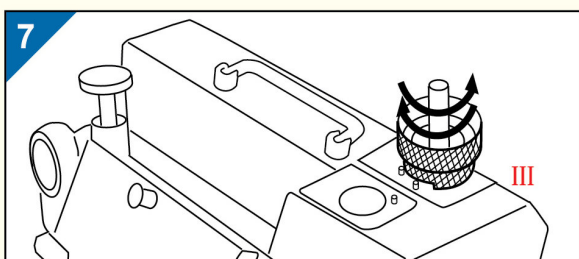
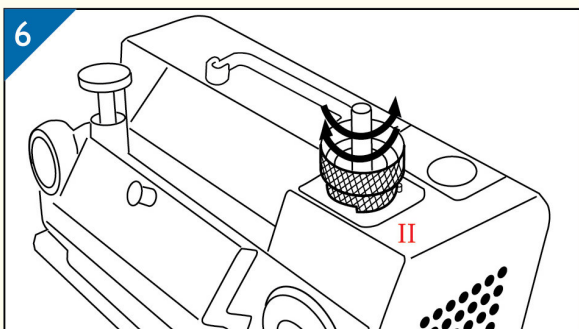
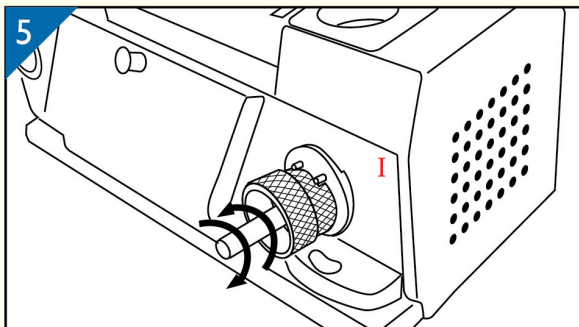
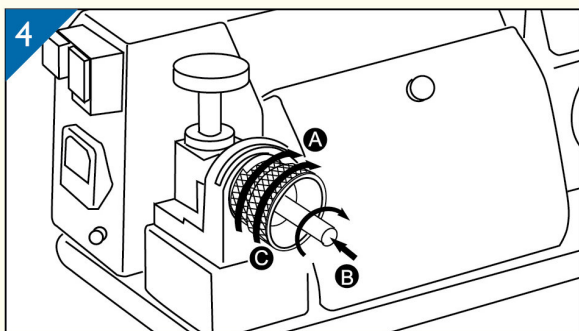
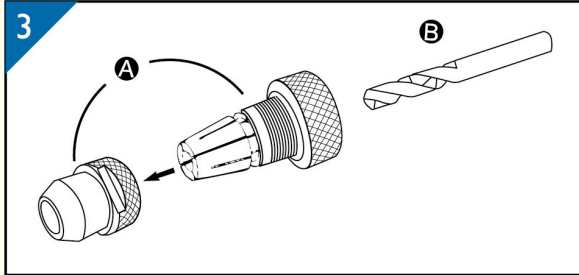
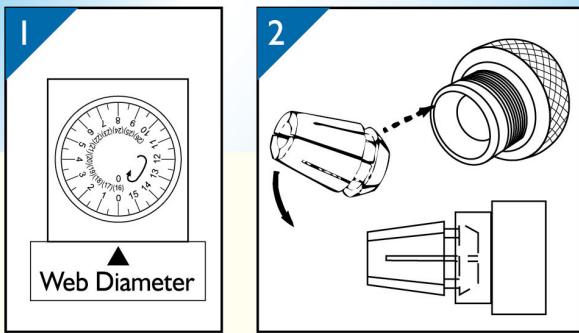
- 附註：1. 研磨深穴鑽頭時，調整台刻度數字加大。  
2. 研磨高螺旋鑽頭時，刻度調整加大一倍(Dx2)如鑽頭之長度(刃長)有縮短時，刻度再加大一或二格。  
例：深穴鑽頭(高螺旋之鑽頭)，刻度調整加大一倍再加一或二格，如有縮短時再加大調整刻度一或二格，但必須確認刀口與夾頭固定組之缺口線平行。



# Drill Bit Grinder

GS-21

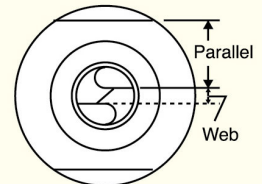
GS-34



## OPERATION

- Determine the drill material, then choose the proper grinding wheel, CBN grinding wheel is the standard accessory. (CBN for HSS material drills) (SDC for carbide material drills)
- Reset the scales of Web Adjustment Shelf to zero: turn it by clockwise to the bottom and then counterclockwise to zero.
- Choose the right size of collet. Put collet into collet chuck.
  - \*Insert collet into collet chuck by 45° angle.
  - B. The order of setting operation: Put the collet into collet chuck and screw in a little bit by clamping nut, then insert the drill through the collet chuck and push in until the drill is out of the clamping nut about 5mm.
    - \*Do not fully fasten the clamping nut with collet chuck, keep the drill able to be adjusted.
- A. Adjust the scale of Web Adjustment Shelf according to the drill diameter.
  - Example: 12mm adjust the scale to 12
  - 12.2mm adjust the scale to 12.5
  - 12.6mm adjust the scale to 13
- Insert the chuck set into the Web Adjustment Shelf. Then connect it tightly. Turn it right to the end.
- Plug the drill to the end and turn it right to the end.
- Turn the chuck set right to the end and tightens it.
- Turn the chuck set a little to the left and taking it out gently.
  - \*Make sure that the cutting lip of drill is parallel with the slot of clamping nut before grinding job started.
  - If it is not parallel, adjust it again.

Attention! If the cutting lip is downward, must increase the scale of Web Adjustment Shelf. If it is upward, please decrease the scale of the Web Adjustment Shelf.



\*When the flute length of a drill becomes shorter, the thickness of a drill web would become thicker. So, for the same diameter of drills, the shorter length of a drill, the higher scale of Web Adjustment Shelf need to be increased.

- Turn the power switch on and wait until the motor rotation is stable (about 10 seconds), put the chuck set into Shelf I. The slot of clamping nut must fit with the two pins on the grinding shelf. Insert the drill gently into Shelf I until reach the grinding slip. Grind the drill by moving left and right until the noise stops. And then turn to the other side. Grind the drill with the same way.
  - \*GS-21: The grinding size of drill is 12mm~26mm.
  - \*GS-34: The grinding size of drill is 12mm~34mm.
  - \*Adjustable point angle as follows: 90° for NC spotting only.
  - 12mm~26mm - 90° to 140°
  - 26.1mm~32mm - 118° to 140°
  - 32.1mm~34mm - 125° to 140°
  - \*While grinding, don't hold the stem of the drill, it will affect the accuracy.
- For grinding the center of drill and the web of drill, insert the chuck set into Shelf II and move left and right until the noise stops. After that turn the chuck set to the other side and grinds it by the same way until noise stops.
  - \*The insertion and ejection of the clamping nut set from Web Thinning Shelf, must make sure that the center part of the slot in clamping nut is fitted with the pin of Shelf II.
- For grinding the Secondary relief of the drill, please insert the holder set to Shelf III, grind until noise stops, then turn to the other side and grind with the same way.
  - \*The sharpening drill angle must be 125~140 degree.
- Please clean the ash on each grinding shelf after finishing the grinding job.

Remark: 1. For grinding the (long drill) deep hole drill, increase the scale of Web Adjustment Shelf.  
2. The high spiral drill bit: Based on the size and specification, increase the adjustments on the scale (Diameterx2).



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