

# *Operation Manual*



*Model :GS-35*

## RECYCLING



Do not dispose of electrical appliances as unsorted municipal waste, use separate collection facilities.

Contact your local government for information regarding the collection systems available.

If electrical appliances are disposed of in landfills or dumps, hazardous substances can leak into the groundwater and get into the food chain, damaging your health and well-being.

When replacing old appliances with new ones, the retailer is legally obligated to take back your old appliance for disposal at least for free of charge.

Ground, cord-connected tools intended for use on a supply circuit having a nominal rating less than 150 volts:

**Warning:**

*"WARNING !* When using electric tools basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury including the following. Read all these instructions before attempting to operate this product and save these instructions."

1. - Keep work area clear
  - Cluttered areas and benches invite injuries.
  
2. - Consider work area environment
  - Do not expose tools to rain.
  - Do not use tools in damp or wet locations.
  - Keep work area well lit.
  - Do not use tools in the presence of flammable liquids or gases.
  
3. - Guard against electric shock
  - Avoid body contact with earthed or grounded surfaces (e.g. pipes; radiators, ranges, refrigerators)
  
4. - Keep other persons away
  - Do not let persons, especially children, not involved in the work touch the tool or the extension cord and keep them away from the work area.
  
5. - Store idle tools
  - When not in use, tools should be stored in a dry locked-up place, out of reach of children.
  
6. - Do not force the tool
  - It will do the job better and safer at the rate for which it was intended.
  
7. - Use the right tool
  - Do not force small tools to do the job of a heavy duty tools.
  - Do not use tools for purposes not intended; for example do not use circular saws to cut tree limbs or logs.

8. - Dress properly
  - Do not wear loose clothing or jewellery, they can be caught in moving parts.
  - Non-skid footwear is recommended when working outdoors.
  - Wear protective hair covering to contain long hair.
9. - Use protective equipment - Use safety glasses.
  - Use face or dust mask if working operations create dust.
10. - Connect dust extraction equipment
  - If the tool is provided for the connection of dust extraction and collecting equipment, ensure these are connected and properly used.
11. - Do not abuse the cord
  - Never yank the cord to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.
12. - Secure work
  - Where possible use clamps or a vice to hold the work. It is safer than using your hand.
13. - Do not overreach
  - Keep proper footing and balance at all times.
14. - Maintain Tools with care .
  - Keep cutting tools sharp and clean for better and safer performance.
  - Follow instruction for lubricating and changing accessories.
  - Inspect tools cords periodically and if damaged have them repaired by and authorized service facility.
  - Inspect extension cords periodically and replace if damaged.
  - Keep handles dry, clean and free from oil and grease.
15. - Disconnect tools
  - When not in use, before servicing and when changing accessories such as blades, bits and cutters, disconnect tools from the power supply.
16. - Remove adjusting keys and wrenches
  - Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
17. - Avoid unintentional starting
  - Ensure switch is in "off" position when plugging in.



## Warning:

1. KEEP GUARDS IN PLACE and In working order.
2. REMOVE ADJUSTING KEYS AND WRENCHES. Form habit of checking to see that keys and adjusting wrenches are removed from 1001 before turning it on.
3. KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents.
4. DON'T USE IN DANGEROUS ENVIRONMENT. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. KEEP CHILDREN AWAY. All visitors should be kept safe distance from work area.
6. MAKE WORKSHOP KID PROOF with padlocks, master switches, or by removing starter keys.
7. DON'T FORCE TOOL. It will do the job better and safer at the rate for which it was designed.
8. USE RIGHT TOOL. Don't force tool or attachment to do a job for which it was not designed.
9. USE PROPER EXTENSION CORD. Make sure your extension cord is In good.
10. WEAR PROPER APPAREL. Do not wear loose clothing, gloves, neckties, lings, bracelets, or other jewelry which may get caught in moving parts, Nonslip footwear is recommended. Wear protective hair covering to contain long hair.

Exception: The reference to gloves may be omitted from the instructions for a grinder.

11. ALWAYS USE SAFETY GLASSES. Also use lace or dust mask ~ cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
12. SECURE WORK. Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
13. DON'T OVERREACH. Keep proper footing and balance at all times.
14. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for best and safest performance. Follow Instructions for lubricating and changing accessories.
15. DISCONNECT TOOLS before servicing; when changing accessories, such as blades, bits, cutters, and the like.
16. REDUCE THE RISK OF UNINTENTIONAL STARTING. Make sure switch is in off position before plugging in.
17. USE RECOMMENDED ACCESSORIES. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
18. NEVER STAND ON TOOL. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.

19. CHECK DAMAGED PARTS. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
20. DIRECTION OF FEED. Feed work into a blade or cutter against the direction of rotation of the blade or culler only.
21. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. Don't leave tool until it comes to a complete stop.

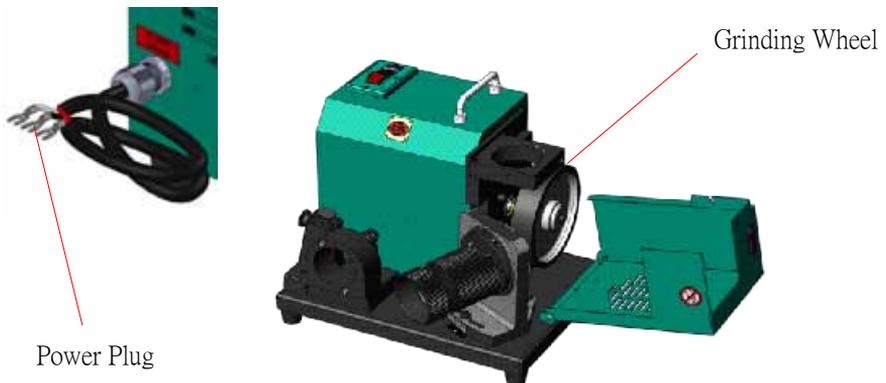
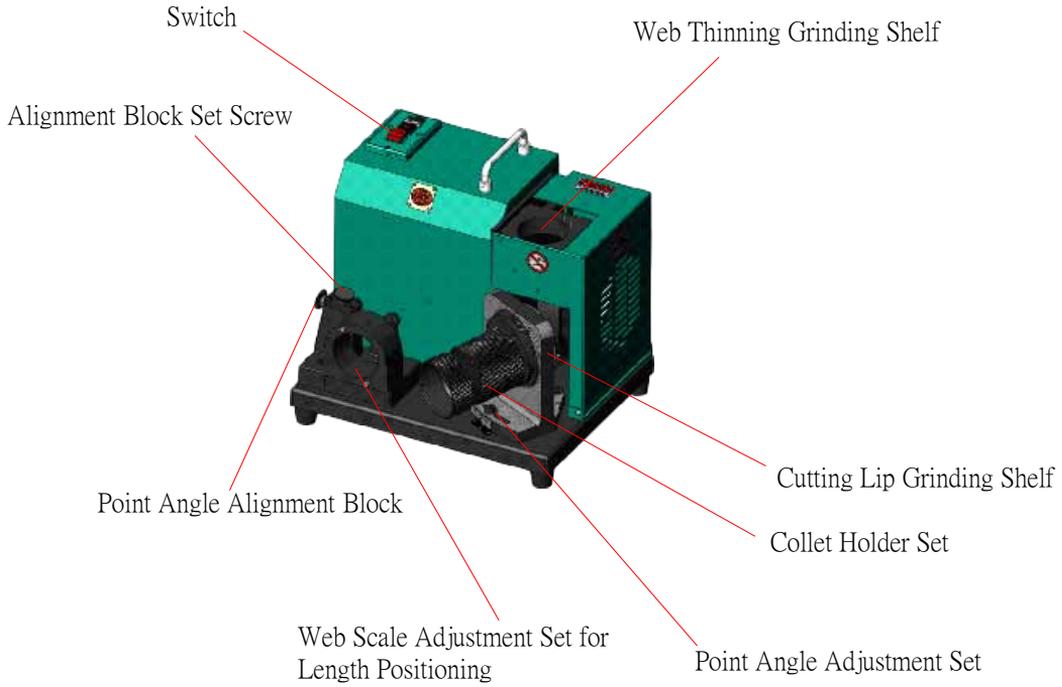
## **INDOOR USED!!!**

**WARNING:** DO NOT EXPOSE TO RAIN OR USE IN DAMP LOCATIONS and  
AVERTISSEMENT: NE PAS EXPOSER A LA PLUIE ET NE PAS UTILISER DANS  
LES EMPLACEMENTS HUMIDES

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# *Devices and components name of the Drill Regrinding Machine*



# Machine Installation Instruction

## A. Environment Selection :

1. Please place the machine on the “flat” working table hig.
2. Dry Environment, away from any liquid.
3. Make sure power plug and power line are installed in proper location.

## B. Power Supply :

Make sure the power supply is 220V or 380V(option) according to your region.

Please check the switch is in off position before power plug connect into your local switch.

## C. Motor Rotary Testing:

1. Connect the power plug into your local switch.
2. Check the grinding wheel protection cover is fastened by the screw.
3. Turn the switch on and quickly turn off the switch to check the grinding wheel rotary - counter clockwise. (as illustrated: Diagram:3-1)
4. Turn on the switch and listen the machine running.



(Diagram:3-1)

(Machine equipped with AC220V 3-Phase or 380V(option) ,Slightly grinding sound is normal.)

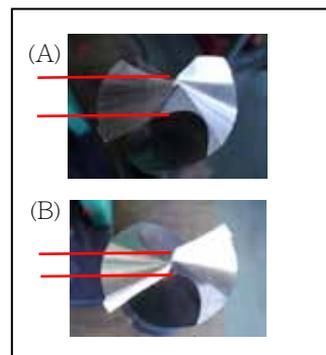
## Type of Drill for sharpening

This machine is design for General HSS / Carbide Twist Drill sharpening.

Universal Twist Drills



The drills has two type: (A) and (B).  
(A) has a web thickness big than (B) as illustrated:  
(Diagram:4-3)



(Diagram:4-3)

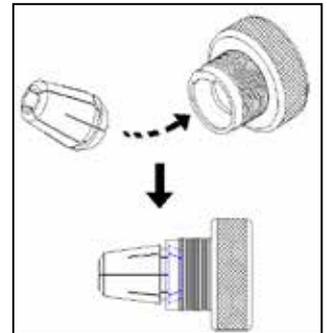
# Standard Operational Steps

1. Determine the drill material to choose grinding wheel :

- HSS material drill use CBN grinding wheel (Standard).
- Carbide / Tungsten material use SDC grinding wheel

2. Choosing the Proper Collet:

- According to the drill diameter and choose the same size of collet. Eg: 43.1-44mm drill, use 44mm collet; 49.1-50mm drills, use 50mm collet.



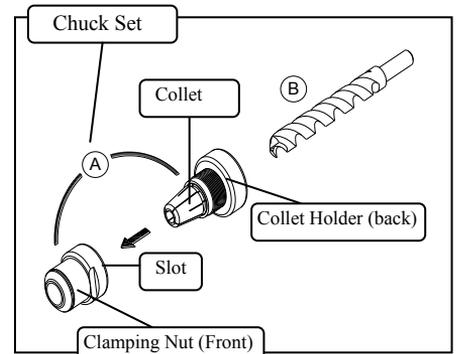
(Diagram:4-1)

3. Make sure there are no dusts or scraps inside the collet and the collet holder.

4. insert the collet into collet holder by 45° as illustrated:(Diagram:4-1)

5. Assembling Steps:

Drill (B) Insert collet into collet holder and assemble them with the clamping nut. as illustrated: (Diagram:4-2)



(Diagram:4-2)

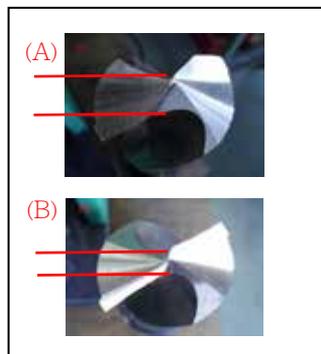
6. Web Scale Adjustment :

① Determine drill web: The drills has two type: (A) and (B). (A) has a big web than (B) as illustrated: (Diagram:4-3)

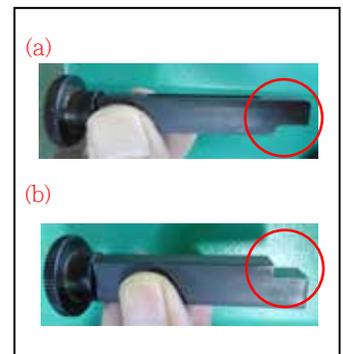
② Adjustment: Adjust the Web Block according to the drill web thickness type.

(1) drill type(A), set alignment block as (a).

(2) drill type(B), set alignment block as (b). as illustrated(Diagram: 4-3,4-4 & 4-5)



(Diagram:4-3)



(Diagram:4-4)



(Diagram:4-5)

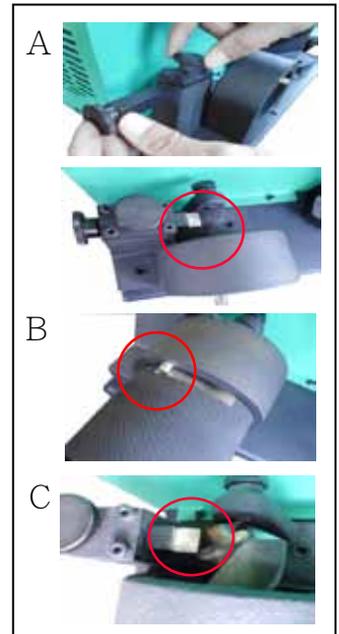
## 7. Drill Positining:

- A. Inserting the point angle alignment block into the setting holder and tighten the screw.
- B. Inserting the chuck set fitly into the adjustment set and turn it clockwise to the end.
- C. Push the drill to the end and turn slowly the drill by clockwise until it is blocked by the alignment block.

Tighten the clamping nut and the chuck by clockwise.

Take the chuck set out by turn it counter clockwise.

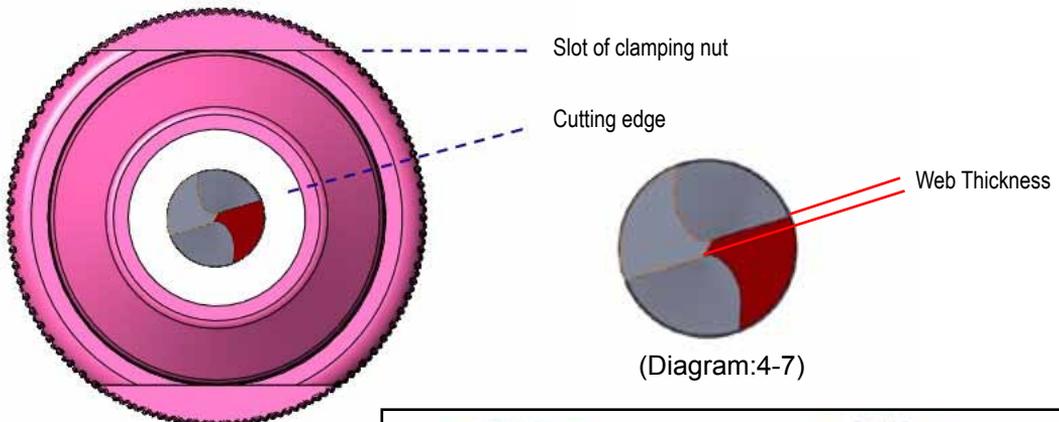
See illustrated: (Diagram:4-5)



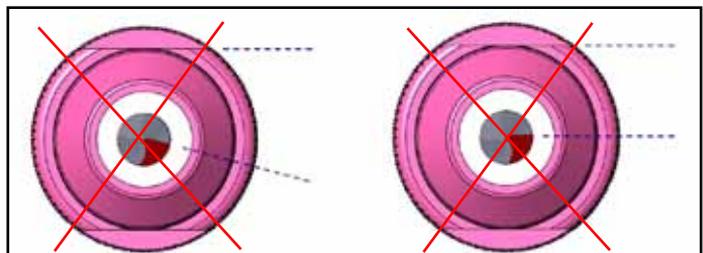
(Diagram:4-5)

### **Always keep higher before starting the grinding procedure.**

Note: After taking the chuck set out, please make sure **the cutting edge of the drill is higher than the slot of clamping nut** as (Diagram:4-6), if it is lower or parallel, please take out the alignment block ,turn it 180 degree and insert it do again. (see illustrated: Diagram:4-3, 4-4 and Diagram: 4-5)



(Diagram:4-6)



(Diagram:4-8)

# Standard Operational Steps

## 8. Twist Drill grinding : Cutting Lip Grinding:(Point Angle)

Turn on the switch, when the motor rotation is stable (about 10 seconds), put the chuck set into the grinding shelf and connected them closely.

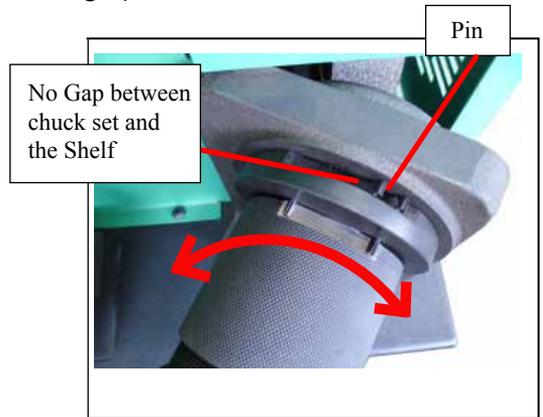
**!** Please verify the Point Angle of the Drill before starting the grinding procedure. (118°~140°)

The slot of the fixed clamping nut must be fitted with the two pins on the grinding shelf.

Grind the drill by moving left and right until the noise stops.

Turn to the other side and grind the drill by the same way. (See as illustrated: Diagram: 4-9)

※ Point Angle 118°~140° is available for Shelf adjustment.



(Diagram:4-9)

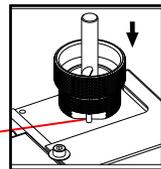
**!** While grinding, please do not hold the drill shank, it may influence the drill position and caused the missing of accuracy.

## 9. Twist Drill grinding : Web / Center Thinning

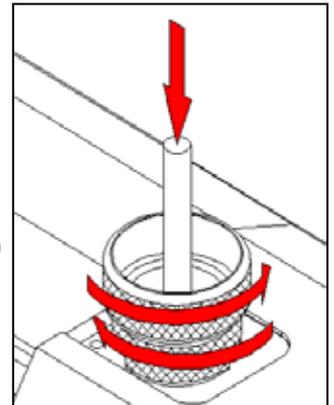
Insert gently the chuck set into web thinning Shelf until reach the grinding slip, then grind the drill by moving left and right until the noise stops. Take out chuck set, turn the chuck set to the other side and grind by the same way. (See as illustrated : Diagram 4-10)

**!** Please Make sure the center part of clamping nut slot aligns to the pin, when putting in or taking out the chuck set. (Diagram:4-10-1)

Align the center of the holder set slot with the Pin on the Shelf



(Diagram:4-10-1)



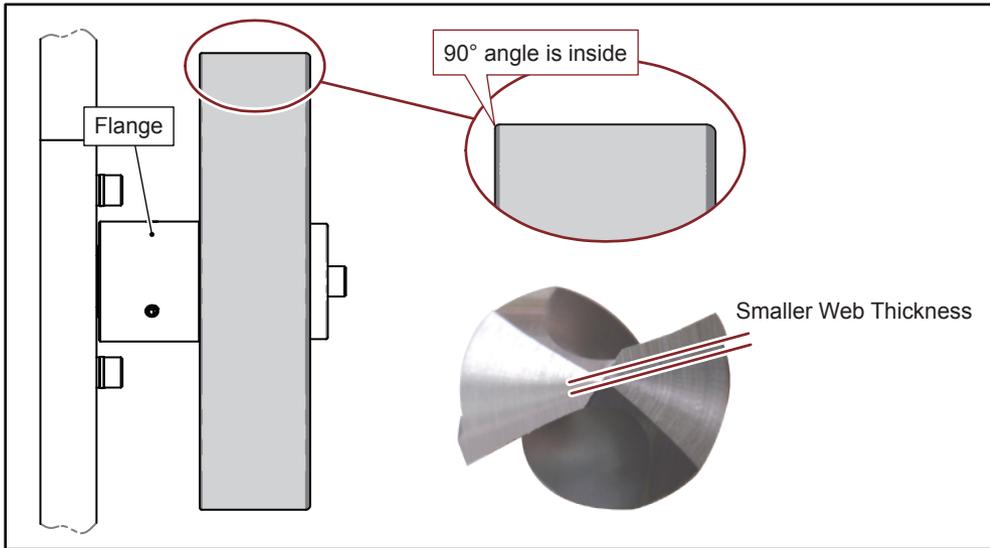
(Diagram:4-10)

# Standard Operational Steps

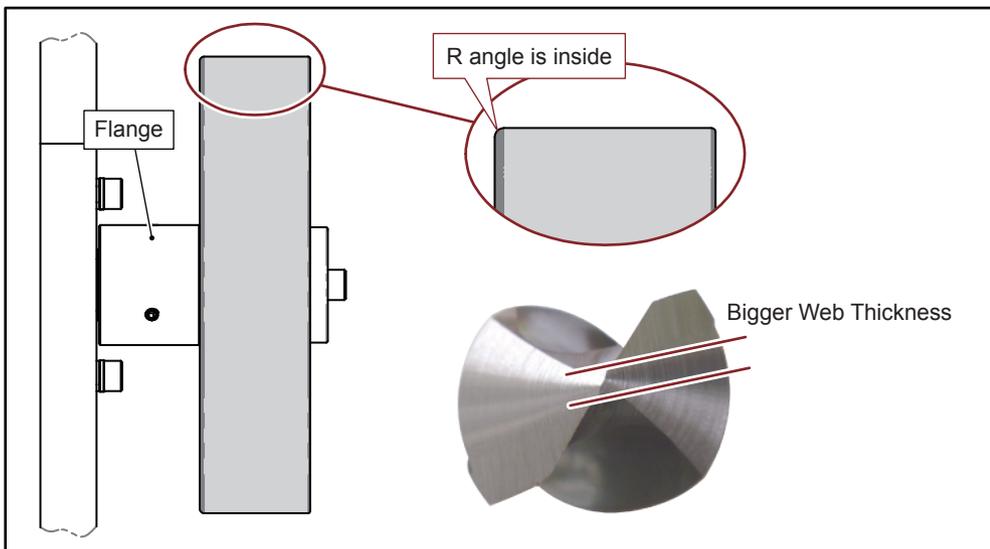
## 10. Changeable Web Thickness

When the wheel initially installed, the side 90° angle should be inside is standard. The Web Thickness is smaller. (Diagram: 4-11)

You can get the Bigger Web Thickness by changing wheel to another side (R angle). (Diagram: 4-12)



(Diagram: 4-11)



(Diagram: 4-12)