



Easy to grinding
3/4 or 1/2 circle gun drill

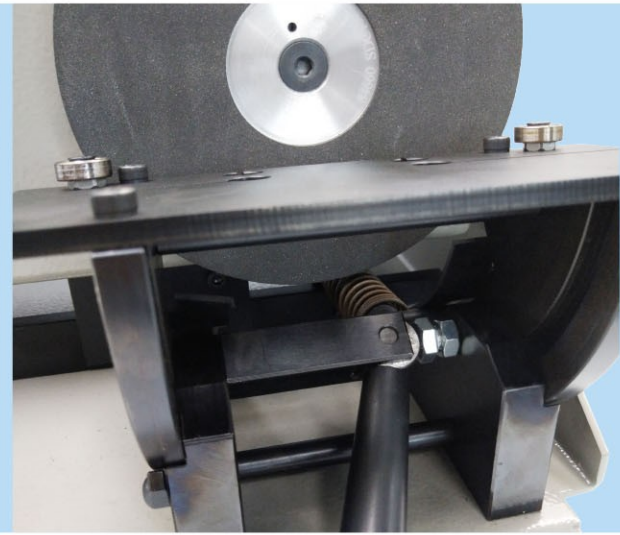
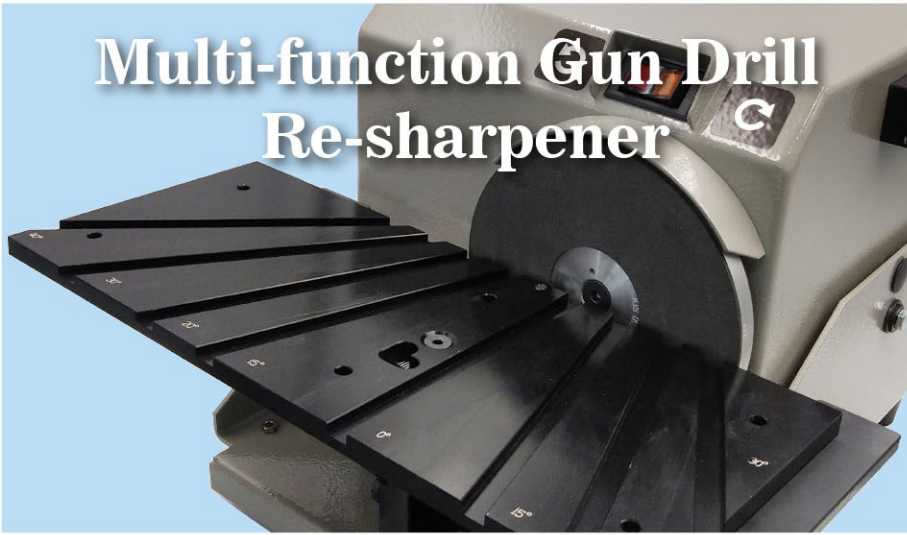
Use high quality resin bonded diamond wheel

Be able to apply lathe tool or insert grinding

Multi-function Gun Drill Re-sharpener

Adjustable angle for workbench
Movable workbench

Multi-function Gun Drill Re-sharpener

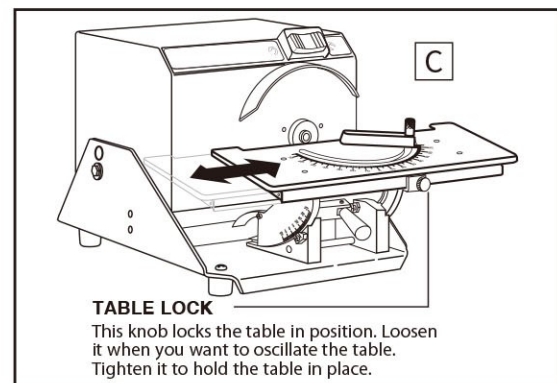
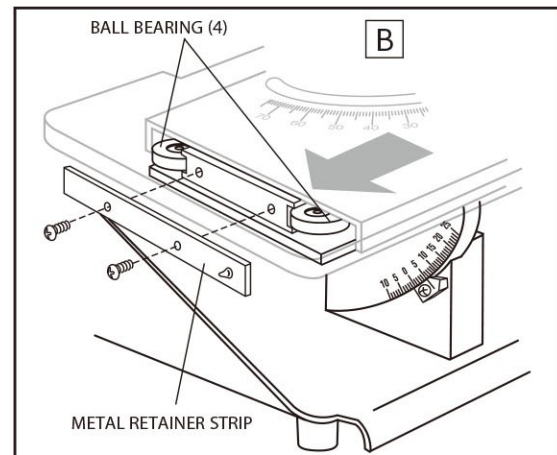
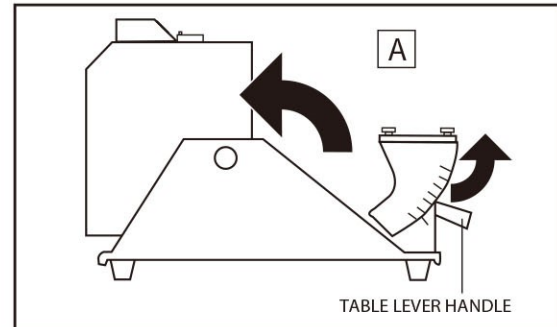


READ ALL DIRECTIONS before attempting setup or installation of this machine.

I .Installation

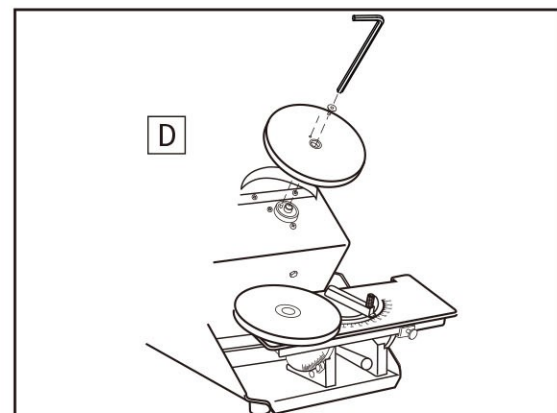
※ Please unplug the power cord before changing or adjusting anything.

1. Unpack the machine and parts on a suitable work surface.
2. Rotate the motor housing up and back until the wheel spindle is oriented in the vertical position.(A)
3. For easier table installation, loosen table support by pulling the handle left. Rotate the support up until it is at approximately 0°. Lock handle.
4. Note there are four (4) ball bearings mounted on the table support structure. These bearings allow the table to roll.
5. Place the table face down on your work bench. Find the metal retainer strip located at each end. From only one trip, remove the two screws with a Phillips screwdriver (B). Note the small rubber bumper.
6. Turn the table face up and start the table onto the first set of bearings, making sure they locate properly in the machined tracks.
7. Slide table across until the second set of bearing* contacts to the end of the track (B).Confirm proper alignment, then slide table the rest of the way.
8. Replace the retainer bar with the two Phillips head screws. Make sure the rubber bumper is oriented properly. It should be directly across from the rubber bumper on the other side and the rubber pointy nub on the outside.
9. See C for how to lock table.
*A definite resistance will be encountered with engaging the second set of bearings. This is due to the preloaded design in which the bearings actually squeeze the mating track. Align bearings with machined track before using any force. When properly aligned, only a slight nudge is required to urge the table over the second set.



Attaching A Wheel (D)

- Select the wheel you wish to use.
Attach wheel to machine with the flat head machine screw using the 5mm hex L-wrench.
To ensure proper wheel trueness, make sure that the back of the wheel and the spindle face are clean when mounting wheels.



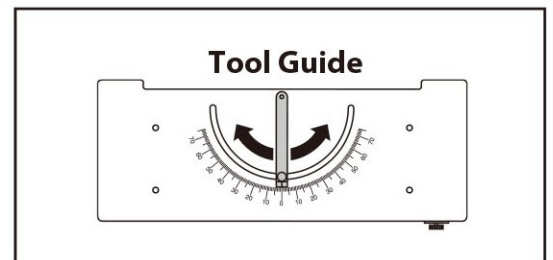
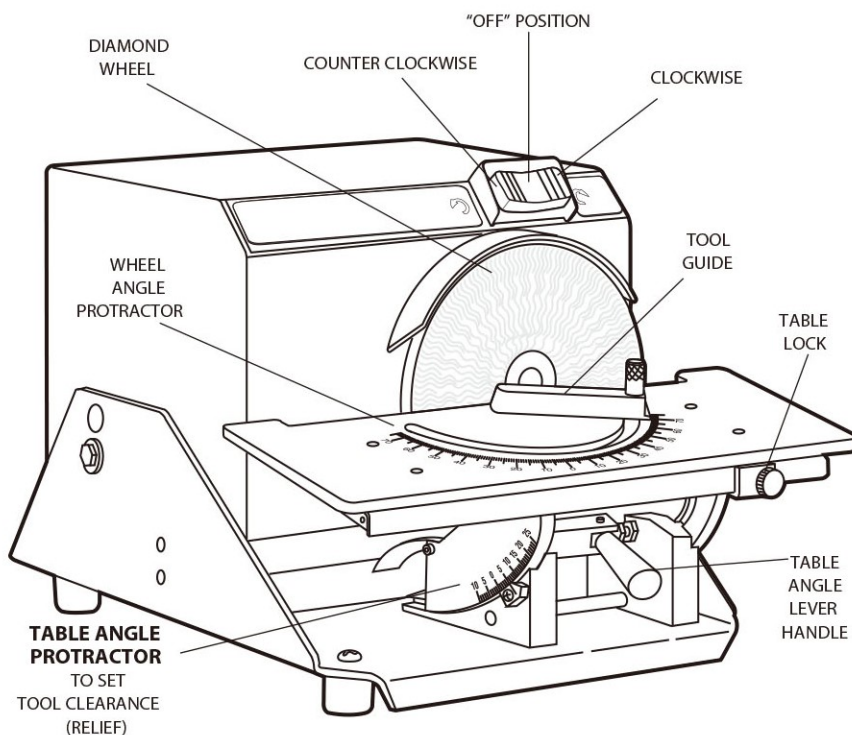
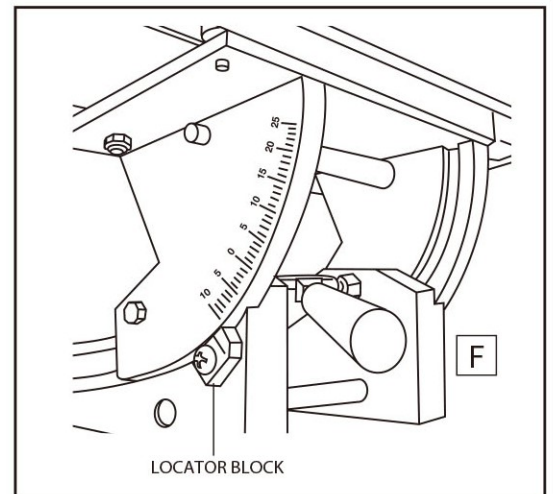
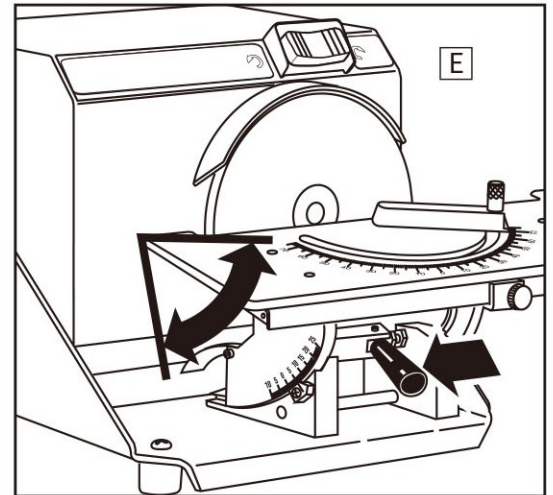


II .Table Position

The vertical wheel position allows use of the calibrated table and tool guide. Two tool angles can be simultaneously controlled. Tool clearance (relief) can be adjusted by setting the table elevation. To set table elevation:

1. Slide table to the right.
2. Pull the table lever handle left to free the table, allowing you to change the angle.
3. Set the elevation scale to desired degree (0° is square to wheel). Tighten locking knob (E).

NOTE: To ensure proper elevation accuracy, the hinged surface between the main motor housing and the side support arms must be kept clean. Make sure that no metal particles or obstructions are stuck to the holding magnet or their mating surfaces. The table is factory calibrated, but you may want to calibrate it yourself sometime in the future. With the table angle unlocked, place a square against the table and wheel, then lock the table. This is a perfect 90° -OR- 0° on the angle protractor. Loosen the locator block and align mark with the 0° mark on the protractor and tighten the locator block (F). The tool guide is adjustable to 75° either side of 0°. Loosen the knurled locking screw in the tool guide. Set angle to desired degree on scale and tighten locking screw.

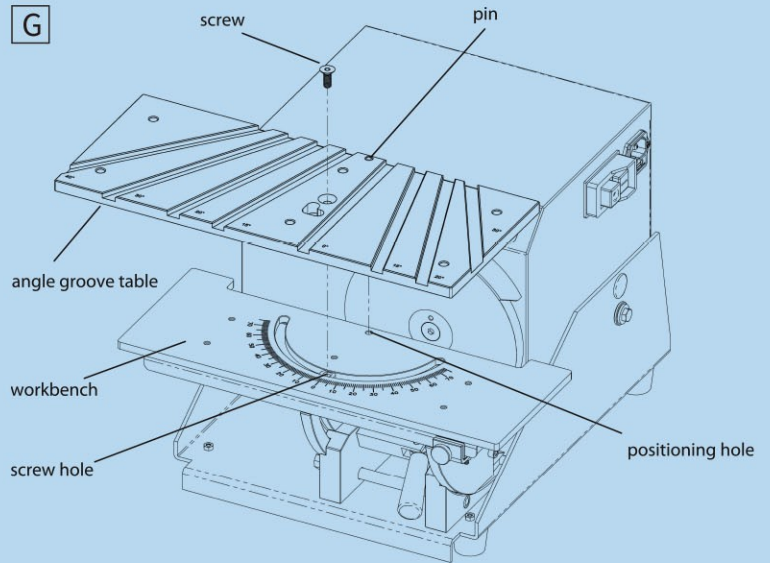


Model	gun drill grinder
Drill Diameter	20mm Max.
Power Supply	AC110V 50/60Hz AC220V (Opt.)
R.P.M. of Motor	1170 R.P.M.
R.P.M. of Wheel	300 R.P.M.
Workbench angle	-10° +25°
Workbench travel	69mm max.
Grinding Wheel	Resin SD#250 grinding wheel
Weight	N.W. 16.2 Kg / G.W. 25.1 Kg
Machine Size	L: 355mm, W: 280mm, H: 260mm
Packing Size	L: 450mm, W: 370mm, H: 430mm
Type of Thinning	3/4 or 1/2 circle
Standard Accessories	Angle groove table x 1
	6 x 16mm Countersunk flat head socket screw x 1
	Workbench x 1
	Workpiece guide x 1
	workpiece guide fixed screw x 1
	8 x 16mm Countersunk flat head socket screw x 1
	Workbench fixed screw x 1
	Chuck set x 1 set
	1/2 gun drill fixed plate x 1
	Rubber foot pad x 2
	4 x 35mm screw x 2
	Hexagon Wrench 3mm x 1, 4mm x 1, 5mm x 1, 8x10mm open-end wrench x 1

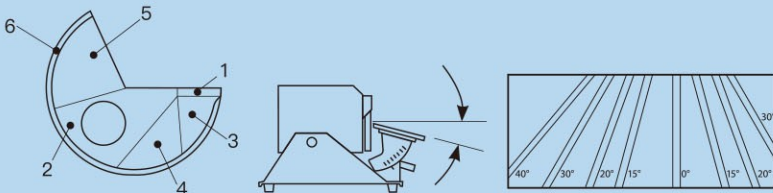
III. Gun Drill Grinding Steps

1. Angle groove table installation

Align the positioning pin of the angle groove table with the positioning hole of the table, Then align the screw with screw hole and lock it. (G)



2. Gun drill grinding steps



FOR STANDARD FACETED GUN DRILLS

Sharpening Sequence 1 ▶ 2 ▶ 3 ▶ 4 ▶ 5 ▶ 6	TABLE ANGLE	SLOT ANGLE FOR		Comments
		3/4 Round	1/2 Round	
1. Primary Relief	12° Down	30° Left	20° Left	Grind until wear is removed from cutting edge. Use fine wheel or ceramic lap for finishing. Grind "Y" slightly long because step 3 will shorten it.
2. Inner Relief	12° Down	20° Right	15° Right	Maintain D/4 (.25 times drill diameter) or as specified by drill supplier. Use caliper or calibrated magnifier to measure. Some applications may use other values such as D/3.
3. Secondary Relief	20° Down	30° Left	20° Left	Maintain "Y" of .01"-.03" (0,2-0,8mm) or as specified by drill manufacturer.
4. Front Clearance	25° Down	0° Center	0° Center	Grind until triangle just reaches the bottom of the primary relief ground in step 1.
5. Oil Clearance	IMPORTANT!		SKIP STEP 5	Rotate drill holder on its side.
	25° Down	20° Right		Grind until triangle just reaches the top cutting surface.
6. Chamfer	Rotate Wheel to horizontal position			Remove drill from holder. Hand rotate to chamfer the periphery at 10°-20° from the drill axis or as specified by drill supplier. The width of chamfer is normally about the same as the "Y" of Step 1. Chamfer should NOT enter the primary relief.



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