

Sheet Metal/Wood Point Drill Attachment

1/16" through 1/2" (2.5 -20 mm)

(DAREX Part # 4500)

Installation and Operating Instructions



DAREX

Installation

The #4500 attachment uses the chuck and alignment fixture that comes with your standard Darex Drill Sharpener. All that is required for mounting is to take the standard sharpening mechanism off by removing the wing nut and then attaching the #4500 sharpening mechanism. Set the point angle at two marks to the left of 180 as shown.

Operating Instructions

Before attempting to sharpen a drill using the sheet metal/wood point attachment make sure you have learned to use your sharpener using the Standard Operating Instructions. Once you have mastered standard drill points, learning to use this attachment will be very simple

Position the drill using the standard chuck and alignment fixtures and the same procedure as you would for a standard drill. The only difference is you must align the chuck arrow with the second mark from the right on the chuck band as shown. (See Fig. 2)

With the grinder turned off place the chuck into the sharpening mechanism and using the wheel positioning knob, position the drill so that the center of the drill is off the left edge of the grinding wheel about 1/16" as shown. (See Fig. 3)

Now sharpen the drill as you would a standard point, rotating the chuck in a clockwise direction.

Adjusting the Relief Angle

To increase or decrease the relief angle, loosen the two bolts "A" shown below and slide the fixture arrow towards the + for more and - for less relief. Retighten the bolts making sure the fixture is perpendicular to the base.

Tips

- 1 By using different point angle settings, you can achieve many different point styles. The further to the left (towards 135) you set the point angle arrow the shorter center point you will produce. At the 180 angle setting you will produce a longer center point.
- 2 The further off the left hand edge of the grinding wheel the thicker the center part of the drill will become. This setting is made by turning the wheel positioning knob.
- 3 If the center tip of the drill is too wide or flat, the point splitter of your M-5 is used to sharpen or thin it. Some experimentation will be required to find the proper position for your application.

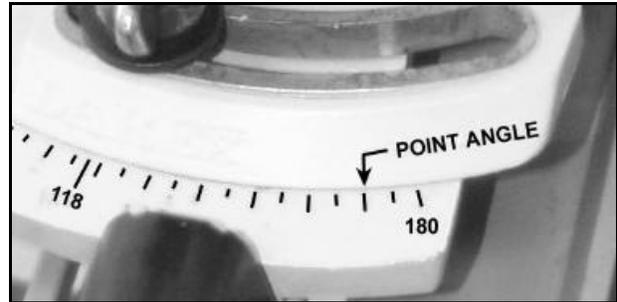


Figure 1

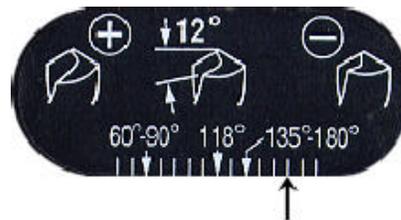


Figure 2



Figure 3

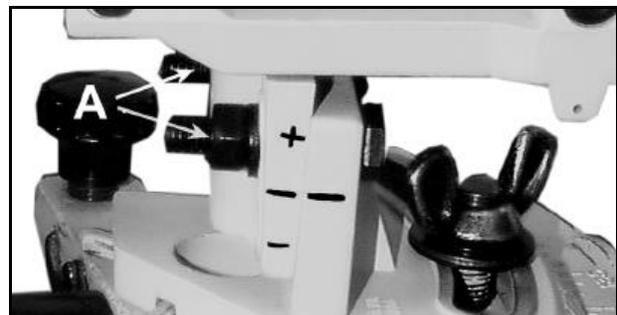


Figure 4

Tech Sheet 4500 Rev. 0997

P.O. Box 277
Ashland, Oregon 97520
(541) 488-2224