

# Plastic and Wood Point (60 to 90 Degrees)

1/16" through 1/2" (1.5 - 13 mm)

## Drill Sharpening Attachment

(DAREX Part # 4700)

### Installation and Operating Instructions



#### Installation

Loosen and remove the wing nut. Lift the standard sharpening fixture off of the compound and install the 4700 attachment. The 118 mark on the compound will be the pointer for what setting you need for the 60 or the 90 point angle. ( see fig 1)

#### Operating Instructions

1. Insert drill loosely into chuck and insert the chuck in the alignment fixture. Rotate the chuck clockwise until the arrow on the chuck meets with the 60 to 90 point angle arrow on the clamping band. Tighten the knob on the chuck. ( See fig. 2 )
2. Sharpen the drill as normally done. (The relief on this sharp of a point angle will not be as defined as a flatter angle drill bit.)

#### Grinding Cutting Edge To a Negative Rake

(For drilling composites, plastics and soft materials.)

1. Upon completing the sharpening of the drill point - loosen the drill in the chuck. Put the chuck in the setting fixture and put chuck arrow at the 90 degree mark on the clamping band and tighten drill in the chuck.
2. Unlock point splitter chuck holding fixture lever - rotate fixture counterclockwise so that the "V" mark on fixture is approximately 1/16" to the left of the "D" mark on the bronze compound.
3. Turn cross feed knob so point splitter compound moves to the point approximately 1/2" from the original point split setting - locating the drill point center at the right edge of wheel.
4. Rotate the chuck so that the cutting lip points straight down and is parallel to the side of the wheel. ( See fig.3 )
5. Adjust the cross feed knob carefully so a very small amount of the cutting lip is ground off - leaving at least 50% of the margin.
6. Noting the location of the chuck arrow at the clamping band, loosen band lock, rotate chuck 180 degrees, so the opposite arrow comes to that same band location. Lock band down and tip drill down to grind the other lip.

Note: Depending upon what type of material being drilled, you might want to experiment with different negative rake angles. To change this angle go back to line "2" and reset fixture.



Figure 1

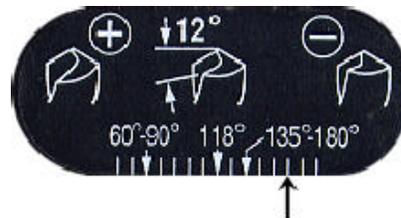


Figure 2



Figure 3

DAREX

Tech Sheet 4700 Rev. 0997

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