Large Drill Attachment

(DAREX Part # 4200)

Installation and Operating Instructions

Installation

Mount sharpening fixture as shown in Figure 1. Unscrew wing nut, remove standard sharpening fixture assembly. Replace with the # 4200 fixture assembly and secure with wing nut.



Figure 1

Operating Instructions

- 1. Insert drill into chuck
 - A Adjust the chuck drill closing knob to hold drill loosely. (Drills should be loose enough to slide back and forth easily.)
 - B Drill should protrude approximately one inch from end of chuck. (See Fig. 2)



Figure 2

- 2. Setting drill to length and aligning for relief.
 - A Insert chuck into alignment fixture, making sure the flutes of the drill go between the two stop pins allowing the drill to go all the way in. Continue pushing the chuck in as far as it will go.
 - B Grasp wing cam and rotate chuck CLOCKWISE until alignment arrow coincides with arrow on the

lip relief scale. To set for more relief locate the chuck arrow a line or so to the left of the alignment arrow or to the right for less relief. (Never turn chuck counterclockwise, merely rotate chuck around again to make sure the cutting lips are against the stop pins inside of the alignment tube.) (See Fig. 3)



Figure 3

3. Secure drill in the chuck.

Grasp the chuck body with your left hand. With your right hand, turn drill closing knob until drill is firm in the chuck. Make sure the chuck does not rotate in the alignment when tightening or the setting will change. Pull the chuck out of the alignment fixture and complete the tightening process.

4. Setting the point angle

Loosen the wing nut on the sharpening fixture and rotate the fixture to the desired point angle mark. Use the corner angle of the fixture base as the pointer. (See fig. 4)



Figure 4

5. Sharpening the drill

Use the same procedure for sharpening as shown on page 3 in the operating instructions. (M5OPS Rev: 0796)

Tips

- 1 To sharpen 90 degree drills in this fixture : When aligning the drill, hold the chuck about 1/4" from being inserted all the way into the alignment port. This procedure will allow the drill to extend out of the chuck further and eliminate the sharpening mechanism from touching the wheel while sharpening.
- 2 To grind drills upwards of 1" the wheel positioning knob may need to be used to position the drill point in such a way so as to make sure it is being covered completely by the wheel in the grinding process.

