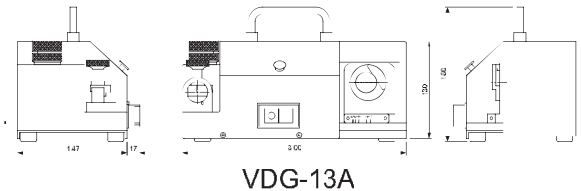




For Drill Re-sharpening

**Precision, Efficient, , Fast & Easy Operation,
Short Processing Time, Wide Grinding Range,
Reasonable Price**

1. High Efficiency, High Quality Grinding Lip, Good Grinding Results
2. Quality Assurance: $\pm 0.05\text{mm}$
3. Considerable Design, Invisible Tool Box, Delicate & Friendly Use
4. Peerless, Super Function, Durable, Strong Motor Can Work For 2 Hours.
5. Normal Drill, Center Drill, Carbide Nc Spot Drill Could Be Re-sharpen. Suit For The Drill Processs On Steel, Casting Iron, Brass And Aluminum.
6. Grind Wheel Can Be Used For 1500 Times.



ORDER NO.	VDG-13A	VDG-25
DRILL DIAMETER	Ø2.0~Ø13.0	Ø12~Ø25 (Ø8~Ø30)
CENTER POINT ANGLE	90°~140°	100°~136°
POWER SUPPLY	AC-110 or 220 1PH	AC-110 or 220 1PH
R.P.M. OF MOTOR	5100 R.P.M.	5300 R.P.M.
GRIND WHEEL	CBN #200	CBN #200
NET WEIGHT	AC-110: 9.8kgs AC-220: 9.8kgs	AC-110: 23.8kgs AC-220: 23.8kgs
OVERALL DIMENSIONS	W282xD185xH110 m/m	W380xD240xH200 m/m
STANDARD ACCESSORIES	ALLOY STEEL COLLET ER-20 COLLETx11PCS Ø3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, EACH ONE COLLET HOLDER X 1 UNIT 4mm HEXAGON WRENCH X 1 PCS FOR CHANGE WHEEL	ALLOY STEEL COLLET ER-40 COLLETx14PCS Ø12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, EACH ONE COLLET HOLDER X 1 UNIT 4mm HEXAGON WRENCH X 1 PCS FOR CHANGE WHEEL
CODE NO.	8001-012	8001-014

GRIND WHEEL

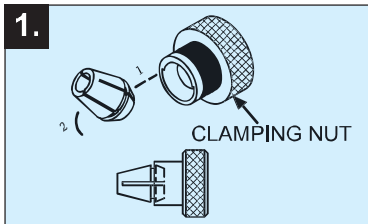
ORDER NO.	FOR DRILL MATERIAL	WHEEL	CODE NO.
VDG-13B	HSS	CBN200	8001-500
VDG-13D	CARBIDE	SDC200	8001-501
VDG-25B	HSS	CBN200	8001-504
VDG-25D	CARBIDE	SDC200	8001-505

OPTIONAL COLLET SPECIAL SIZE	ER-20	ER-40 FOR SPECIAL SIZE
	Ø3.5, 4.5, 5.5, 6.5, 7.5, 8.5, 9.5, 10.5, 11.5, 12.5	Ø8, 9, 10, 11, 26, 27, 28, 29, 30

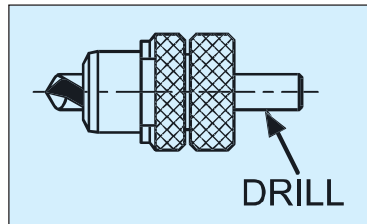


● VDG-25 allows up to size Ø8~Ø30mm, please choose optional collet Ø8, 9, 10, 11, 26, 27, 28, 29, 30mm.

A. HOW TO USE HOLDER UNIT FOR COLLET & DRILL

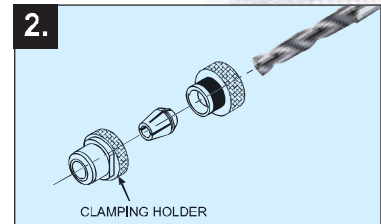


Please confirm the drill size and pick up proper collet. Assemble collet into clamping nut by 45 degree. (Before insert the drill into the clamping holder.)



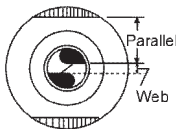
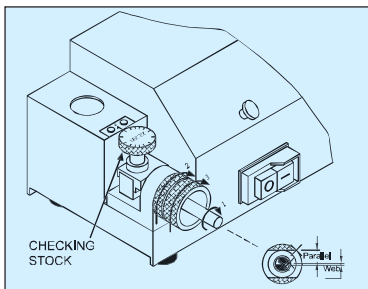
HOLDER UNIT

When drill length is less than 10mm, you need to add 1 scale on indicator.
Ex. when D=9mm, turn indicator to 10mm



Insert the drill, lock the clamping holder but not tightened, allow the drill can still move.

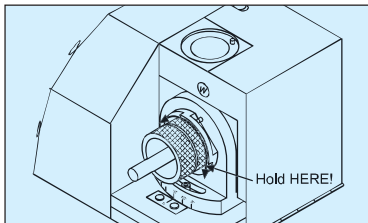
B. HOW TO SET THE HOLDER UNIT AT THE CHECKING STOCK



1. Find the drill diameter. (If the drill D. is 8.2mm) Set the indicator of scale No. as same as drill's diameter. (Please turn the indicator plate and set it between 8mm-8.5mm).
2. Insert the holder unit into the checking stock, The slot of clamping unit will match into the PIN of checking stock. (Make sure the drill is touching the checking stock.)
3. Turn the holder unit and drill to clockwise (Make sure the drill is touching the checking stock). And tighten the holder unit by turning the clamping nut

CAUTION (1.) Make sure the web blade of drill is parallel to the slot of clamping holder.
(2.) If a drill's length is less than 10mm, please add 1-2 scale onto the indicator plate.
(3.) If a drill's web blade is vary from normal drill, please check the parallel to slot of the clamping holder first, and then set the indicator.

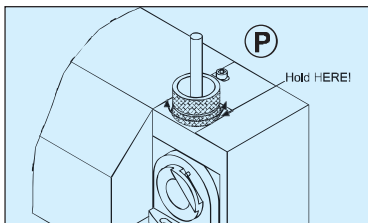
C. HOW TO GRIND THE WEB OF DRILL



1. Turn on the power.
2. Insert the holder unit into the **(W)** grind stock. The slot will match with the PIN. Let the drill reach diamond wheel smoothly. (Hold the clamping holder when turning.)
3. Grinding the drill by moving right and left. Until the grinding noise is gone.
4. Take out the holder unit. And turn 180°, Insert again like step 3. complete the web sharpening process.

CAUTION (1.) Hold and turn the clamping holder to avoid mis-grinding. Hold drill or clamping nut when turning may result in un-even surface.
(2.) To grind different angle shall adjust angle indicator before insert.

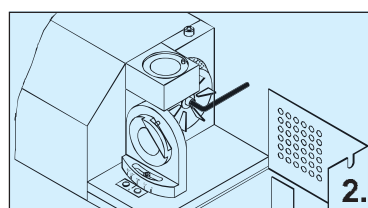
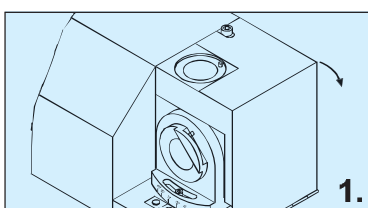
D. HOW TO GRIND CENTER POINT OF DRILL



1. Insert the holder unit into **(P)** grind stock slot and match with the PIN.
2. Turn the holder unit right and left slowly until the grind noise is off.
3. Take out the holder unit and turn oppsite 180° and repeat step 2.

NOTE: Drill under 4 mm no need to grind center point.

E. HOW TO CHANGE THE DIAMOND WHEEL



1. Loosen the screw on the wheel cover.
2. Open the cover and loosen the screw which use to lock the grind wheel.
3. Change the wheel, make sure two screws are in place and fixed.

CAUTION Do not plug in the power before the wheel cover is closed.