



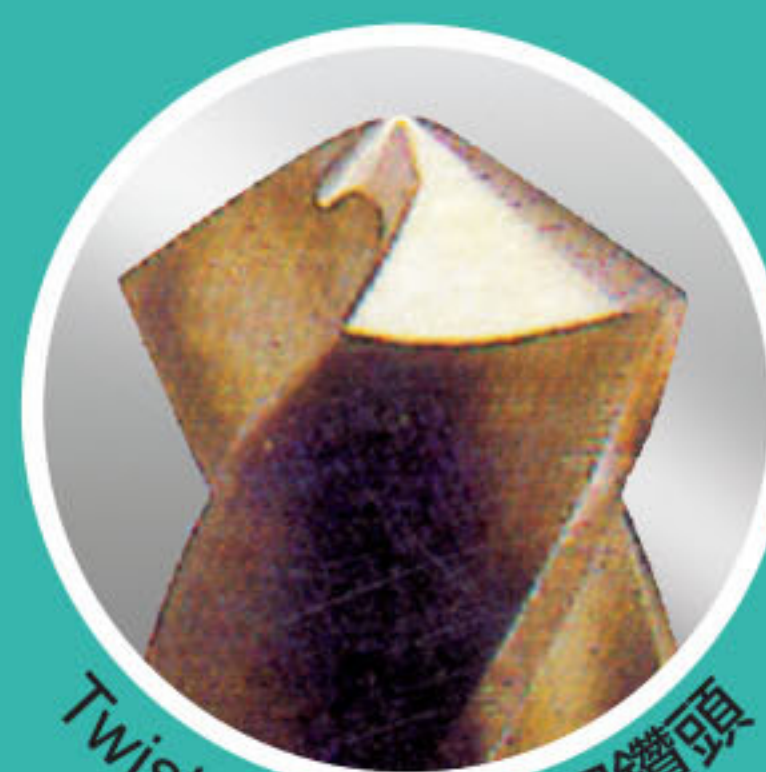
GS-20

www.gsc-tw.com

DUAL HEAD DRILL BIT GRINDER



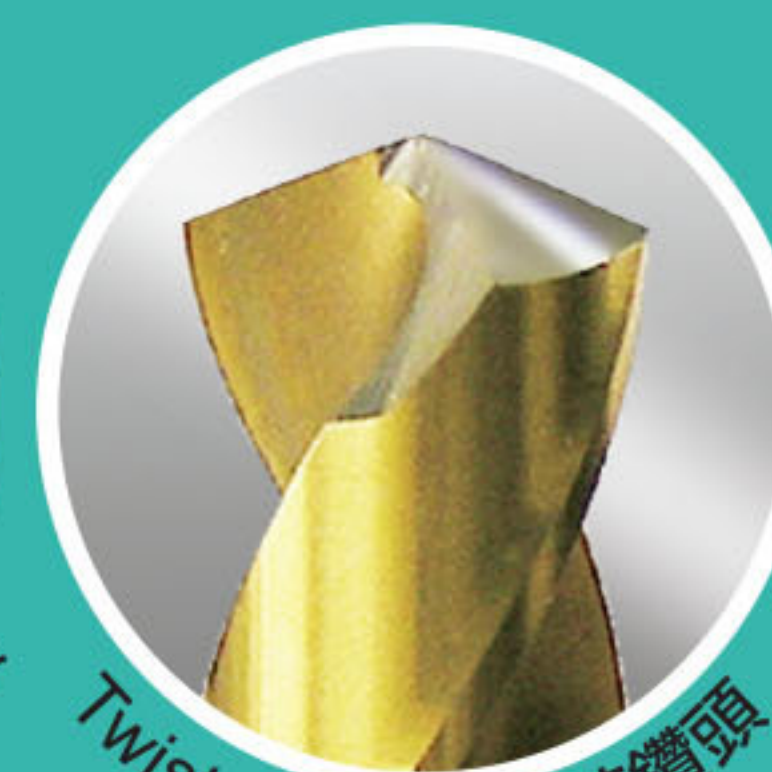
Model	GS-20
Drill Diameter	Φ2 ~ 20mm
Point Angle	90° ~ 140°
Power Supply	AC110V 50/60Hz / AC220V 50Hz Single-Phase(Opt.)
R.P.M. of Motor	5300 R.P.M.
Grinding Wheel	CBN #200 (For HSS Drill Bits)
Weight	N.W. 12.5Kg / G.W. 13.0Kg
Machine Size	L:290mm, W:140mm, H:200mm
Packing Size	L:360mm, W:215mm, H: 265mm
Type of Thinning	X Thinning
Standard Accessories	ER20 Collet x 12 pcs (2.5,3,4,5,6,7,8,9,10,11,12,13mm)
	ER25 Collets 7pcs (14,15,16,17,18,19,20mm)
	ER20 Chuck set x 1, ER25 Chuck set x 1 (4pcs)
	Metal Shim 3pcs (0.1mm x 2, 0.3mm x 1)
Optional Accessories	Hexagon Wrench 3mm x 1, 4mm x 1
	SD #200 Grinding Wheel for Carbide Drills ER20 Imperial Collets Φ3.5 ~ 12.5mm



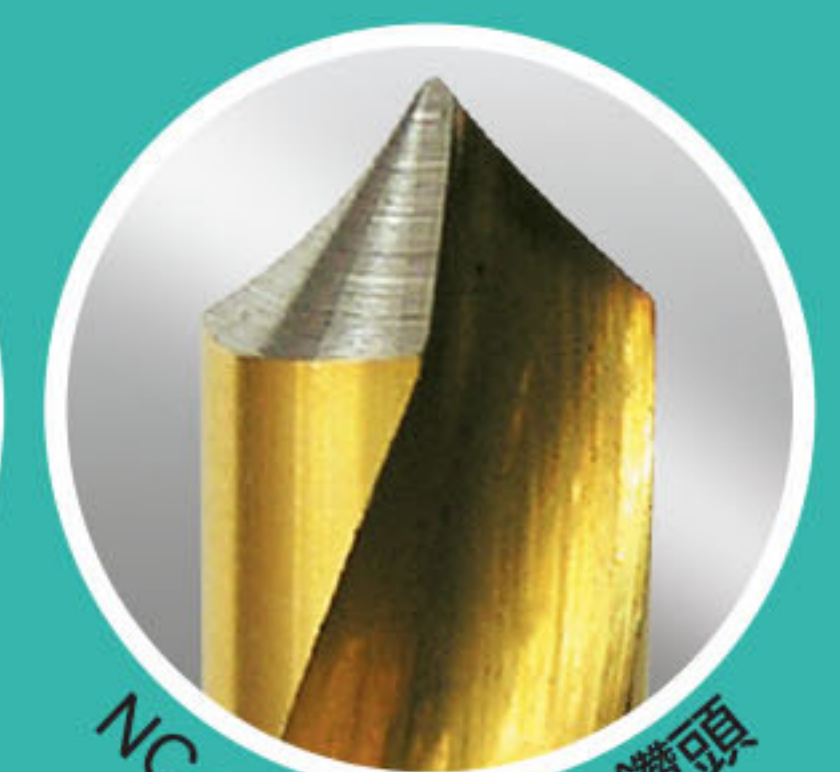
Twist drill bits 泛用鑽頭



Deep-slot drill bits 深孔鑽頭



Twist drill bits 麻花鑽頭

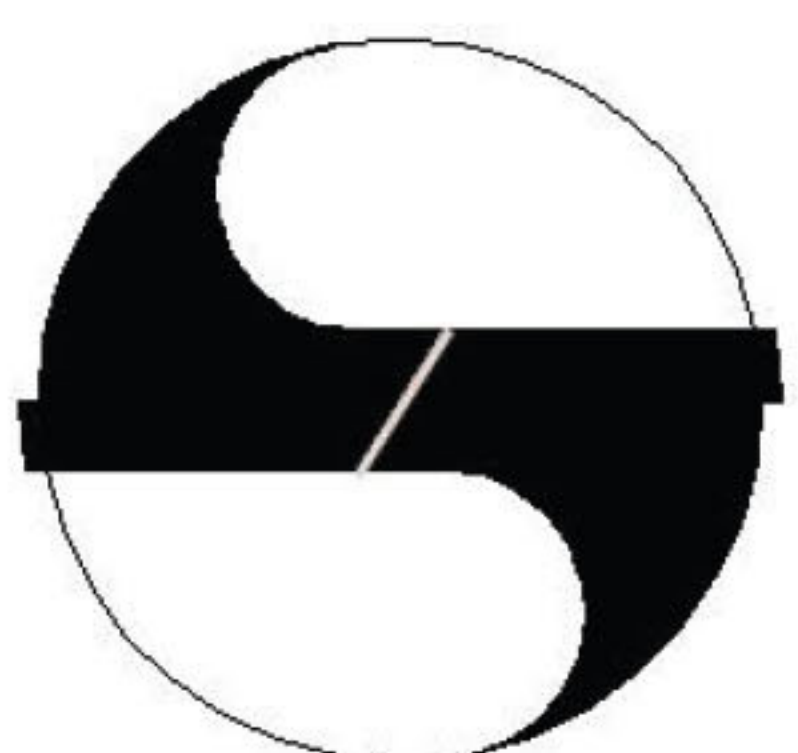
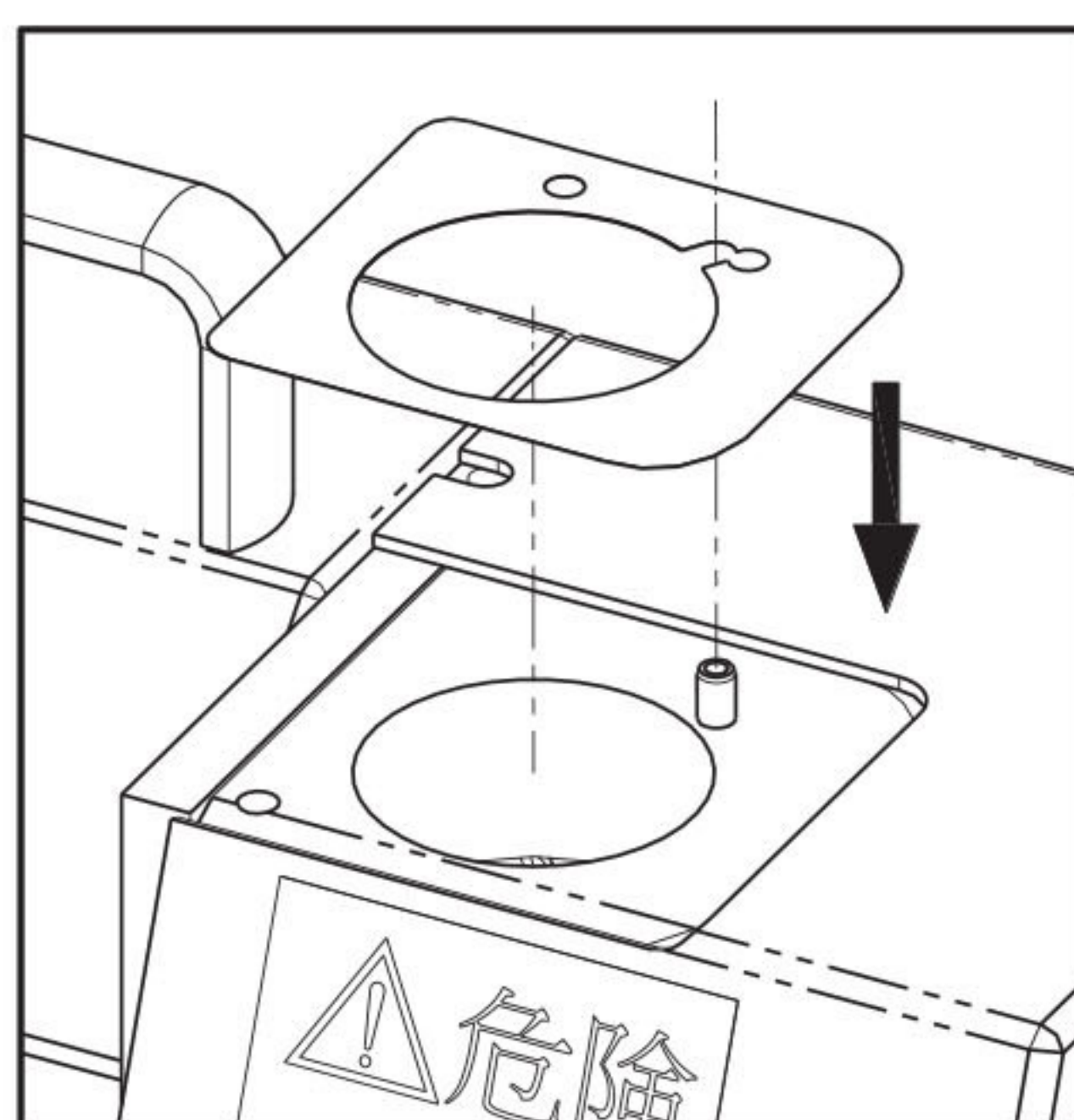


NC spotting 定位鑽頭

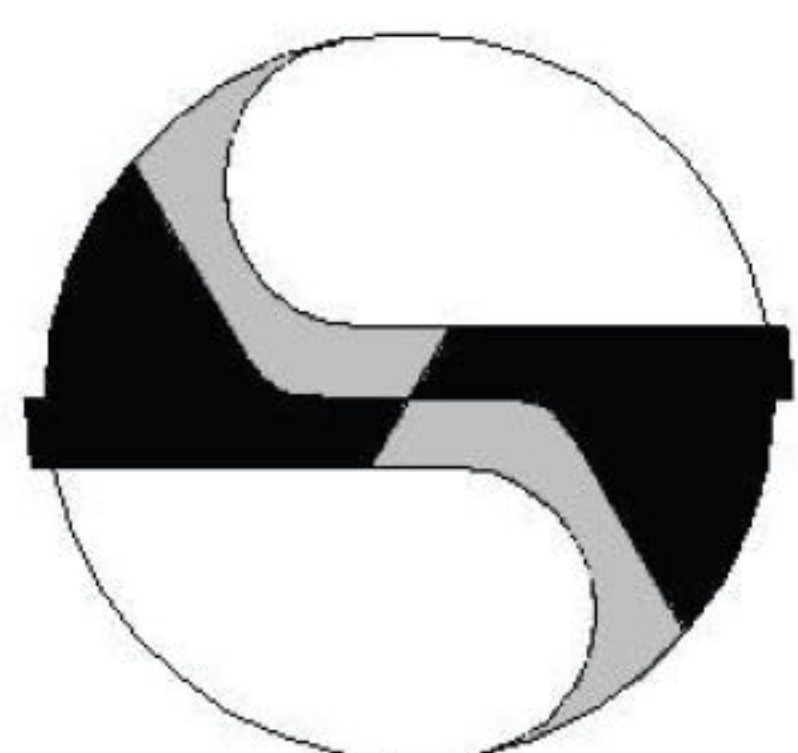
The Use of Metal Shims

There are 3 Metal Shims as standard accessories in the machine. 2 pcs of 0.1mm and 1pcs of 0.3mm.

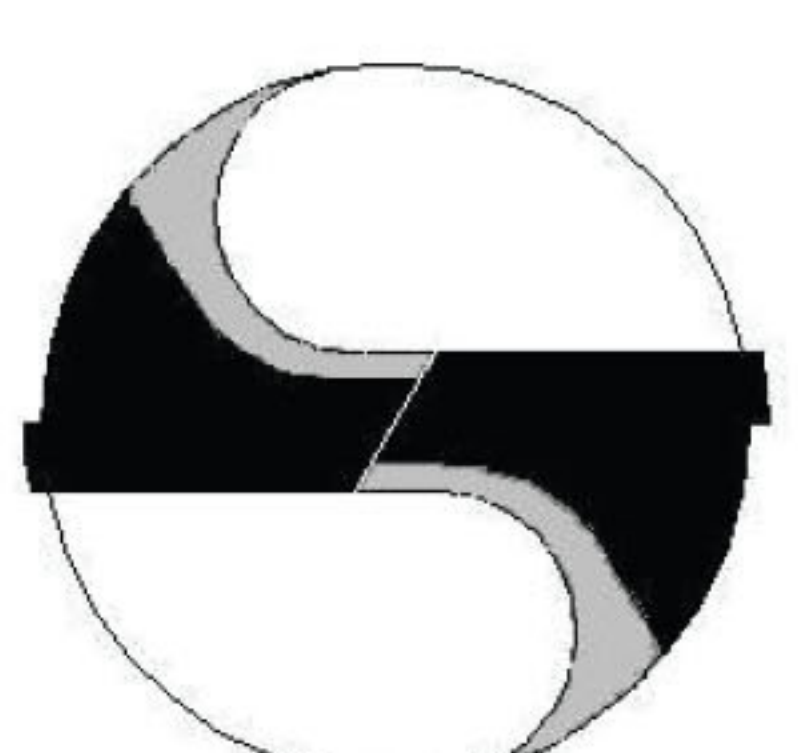
Adding one shim of 0.1mm will expand 0.2mm of the point size, adding 0.3mm shim will expand 0.6mm of the point size and so on.



Tip of drill without thinning, use only the Cutting Lip Grinding Shelf to sharpen this form.



Web Thinning made by normal grinding procedure without adding metal shims. Point size: 0.2mm - 0.4mm

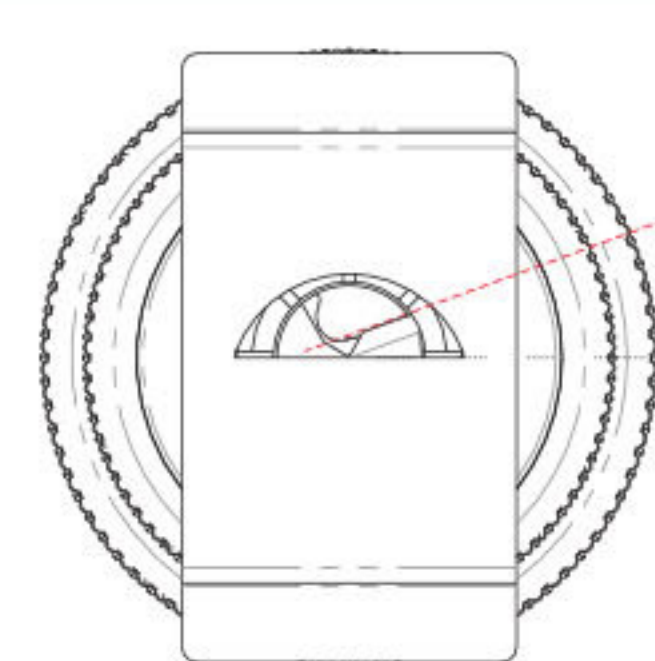
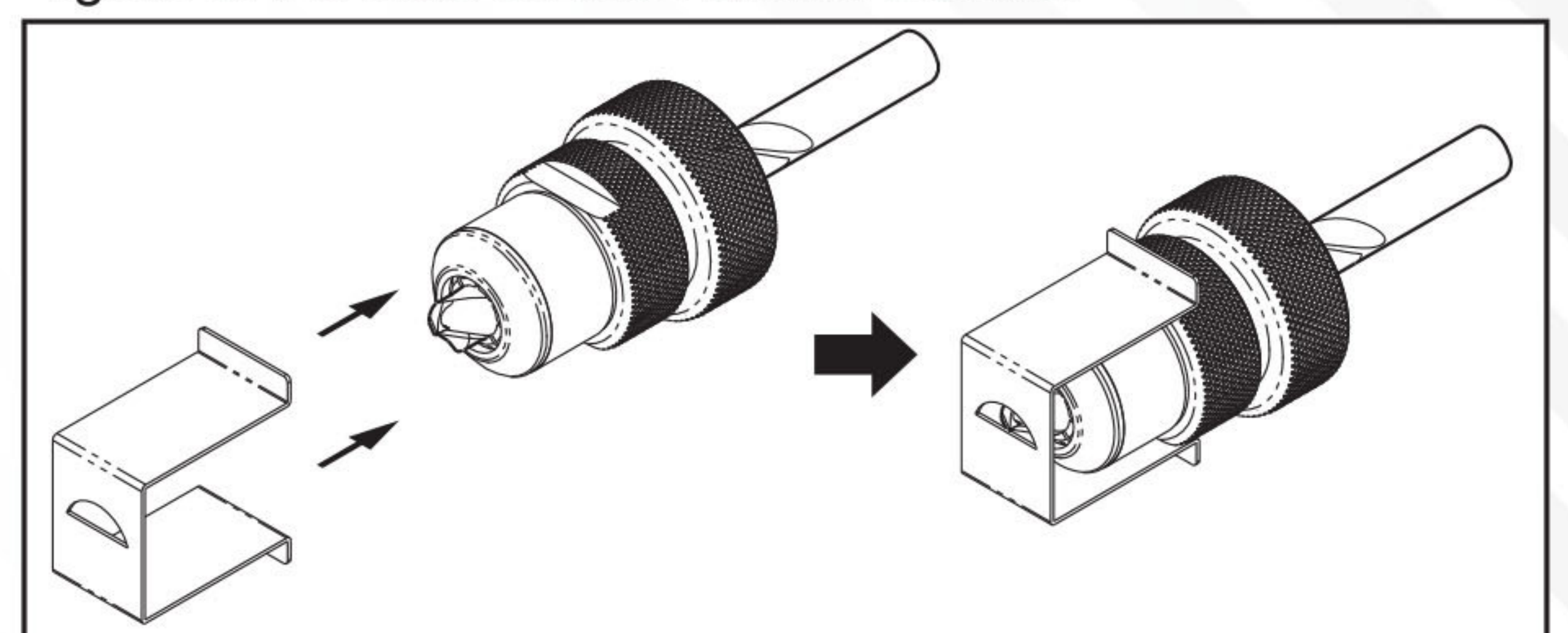


Web thinning result with metal shims. Point size: 0.4mm or bigger depend on the shims added.

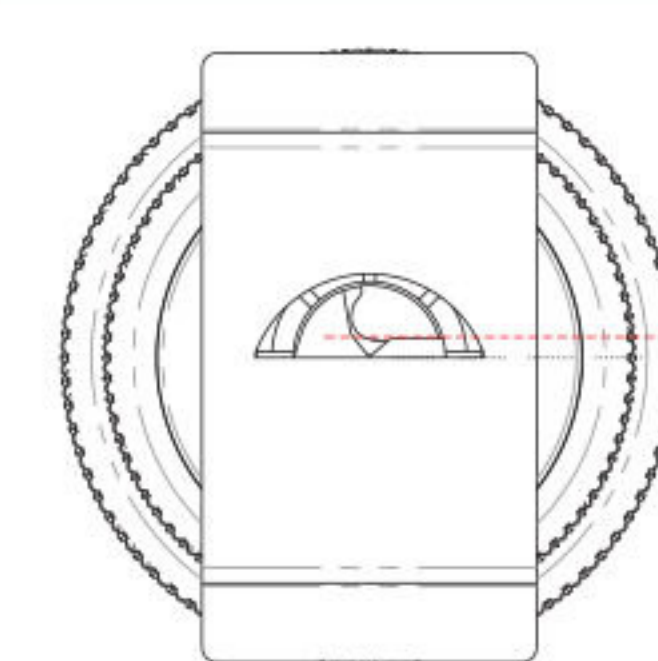
The Use of the Parallel Alignment Devise

Align the Parallel Devise with the two slots of on the Clamping Nut, then connect them as shown in the left picture.

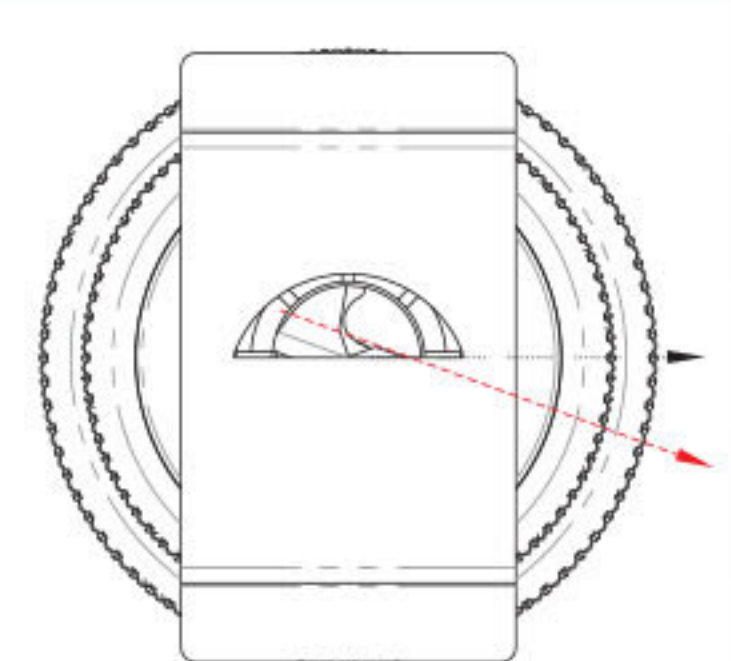
Verify the Parallelism of the Drill's Cutting Lip with the flat figure of the hole on the Parallel Devise.



Incorrect
Please decrease scale



Correct
Cutting lip parallel



Incorrect
Please increase scale



GS-20

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攜帶式

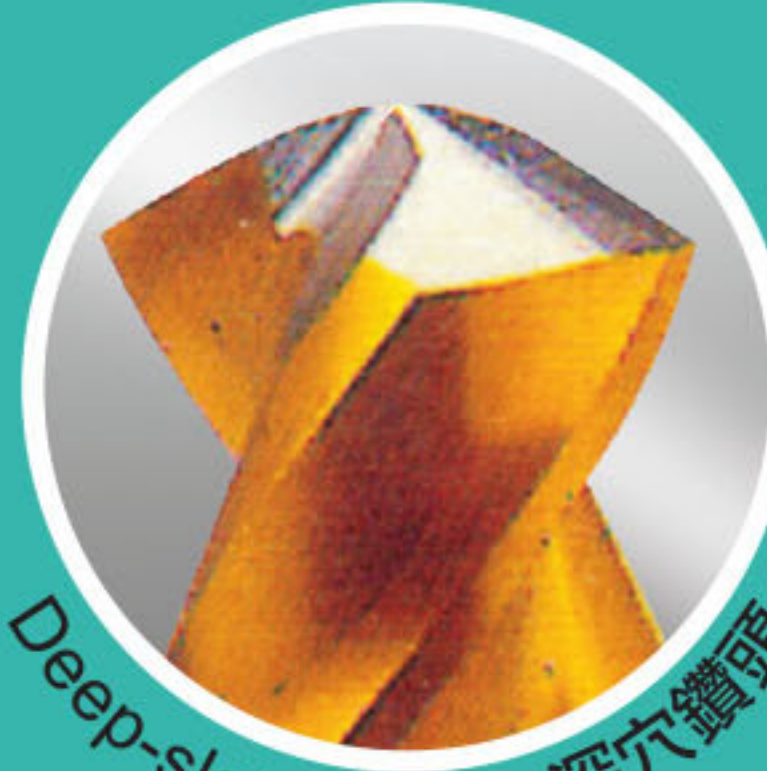
鑽頭研磨機



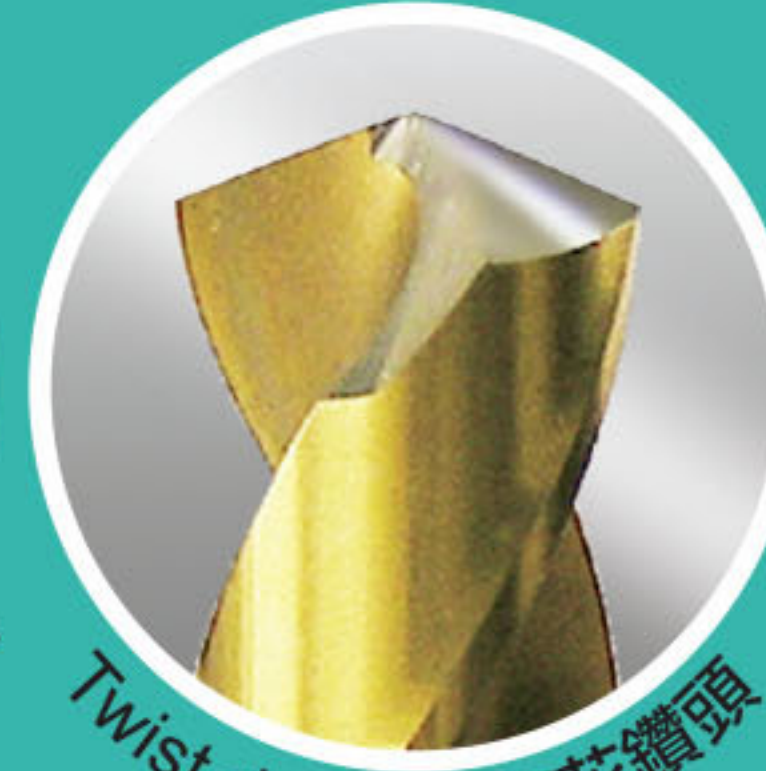
機種	GS-20
研磨尺寸	Φ2 ~ 20mm
先端角	90° ~ 140°
電源	單相AC110V 50/60Hz / AC220V 50Hz (可選配)
馬達迴轉數	5300 R.P.M.
研磨砂輪	CBN #200 (HSS高速鋼麻花鑽頭用)
重量	N.W. 12.5Kg / G.W. 13.0Kg
機器長寬高	L:290mm, W:140mm, H:200mm
包裝長寬高	L:360mm, W:215mm, H: 265mm
研磨形狀	X 形
標準附件	ER20 筒夾 x 12個 (2.5,3,4,5,6,7,8,9,10,11,12,13mm)
	ER25 筒夾 x 7個 (14,15,16,17,18,19,20mm)
	ER20及ER25夾頭組各1組 (4pcs)
	墊片3片 (0.1mm x 2, 0.3mm x 1)
選購/選配	六角板手 3mm x 1, 4mm x 1
	SD #200 研磨砂輪(錫鋼鑽頭用)
	ER20 點數筒夾 Φ3.5 ~ 12.5mm



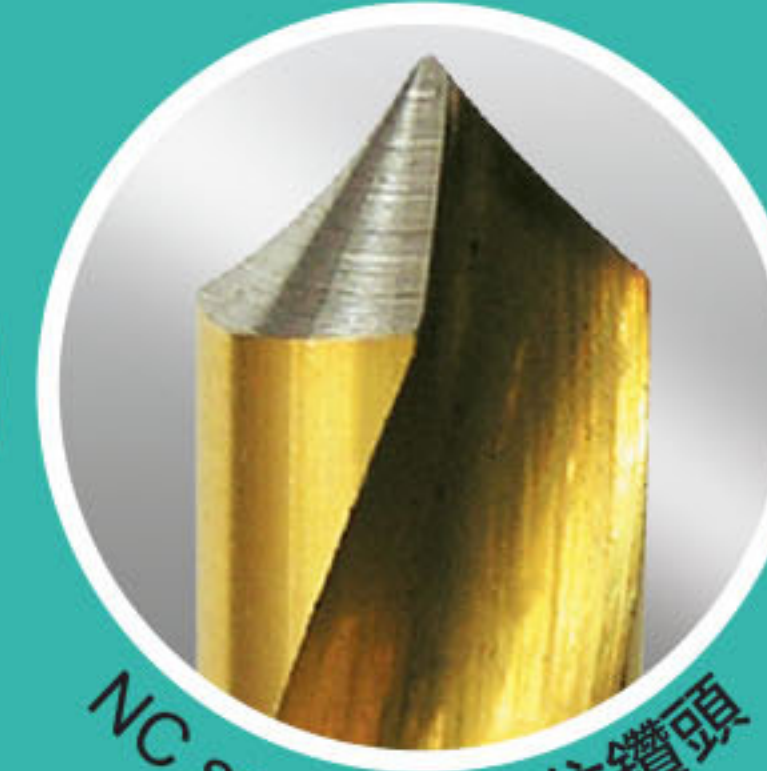
Twist drill bits 泛用鑽頭



Deep-slot drill bits 深穴鑽頭



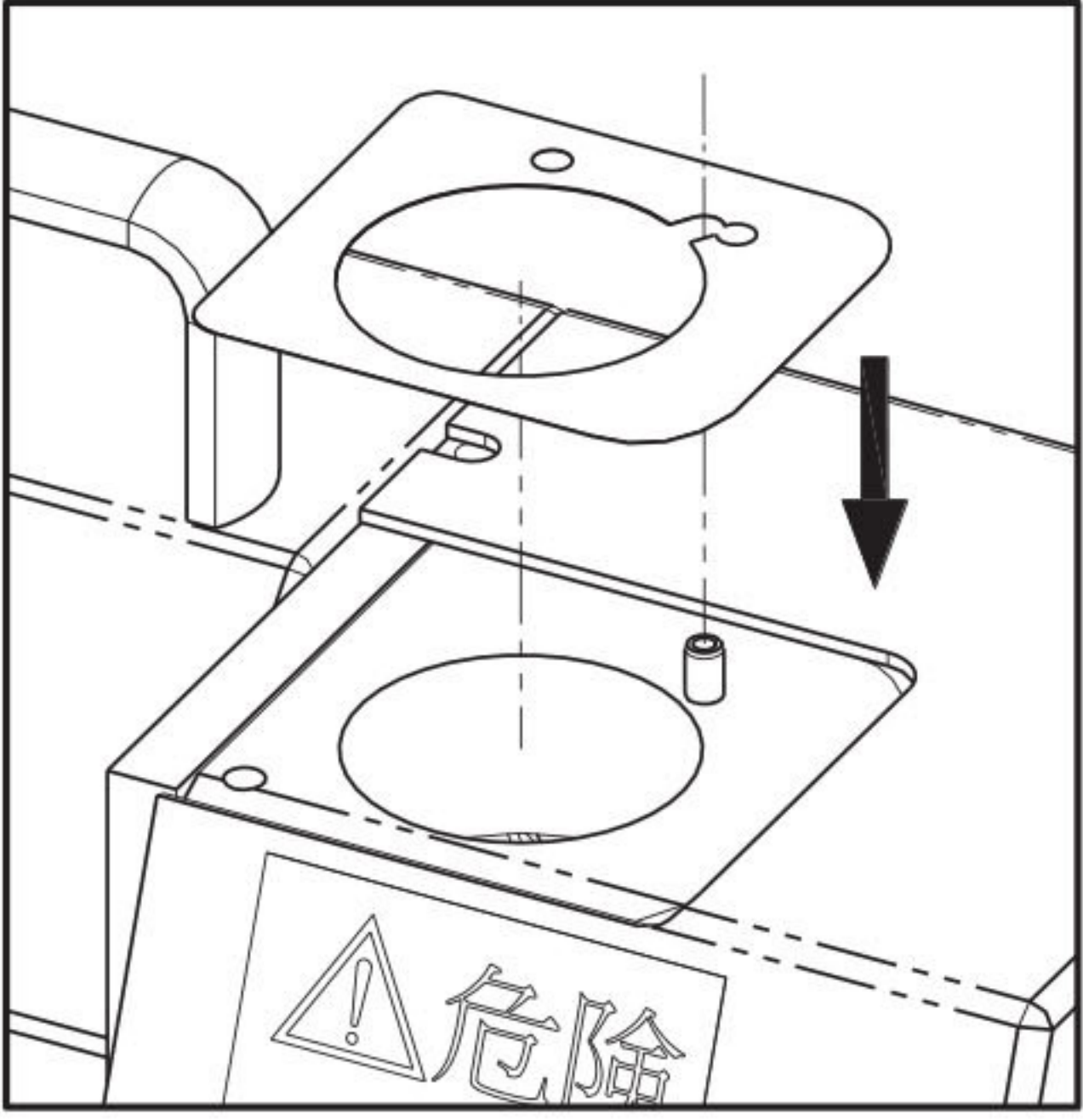
Twist drill bits 麻花鑽頭



NC spotting 定位鑽頭

靜點研磨座墊片之使用

- a).共有3個墊片置於附件中，墊片厚度0.1mm有2片，0.3mm有1片，每增加一墊片，皆會增加2倍的中心靜點厚度。
- 例如：一片0.1mm厚度墊片可增加0.2mm的中心靜點厚度；0.3mm厚度墊片可增加0.6mm的中心靜點厚度之以此類推。
- b).靜點研磨座鐵片上缺孔，對準彈簧銷輕輕嵌入，並平貼靜點研磨座，如(右圖)。



無中心靜點
只有研磨刀刃口情況下，鑽頭尖端不會產生中心靜點



標準中心靜點厚度
無加墊片研磨下，中心靜點厚度為0.2mm-0.4mm

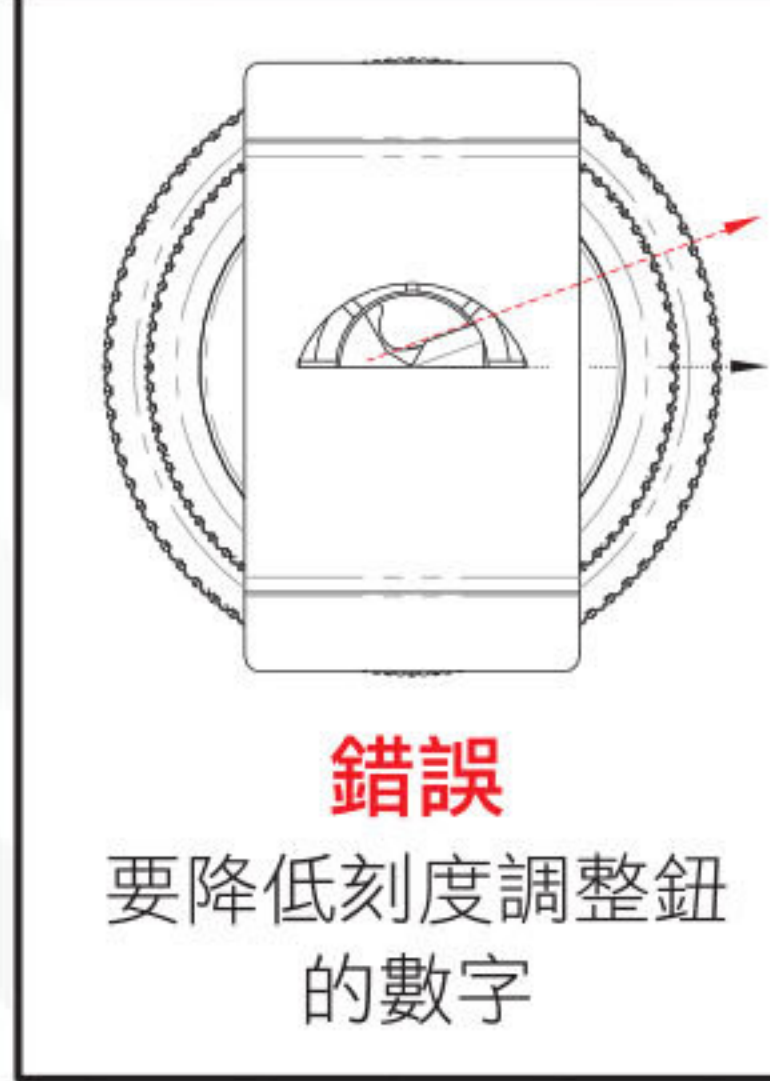
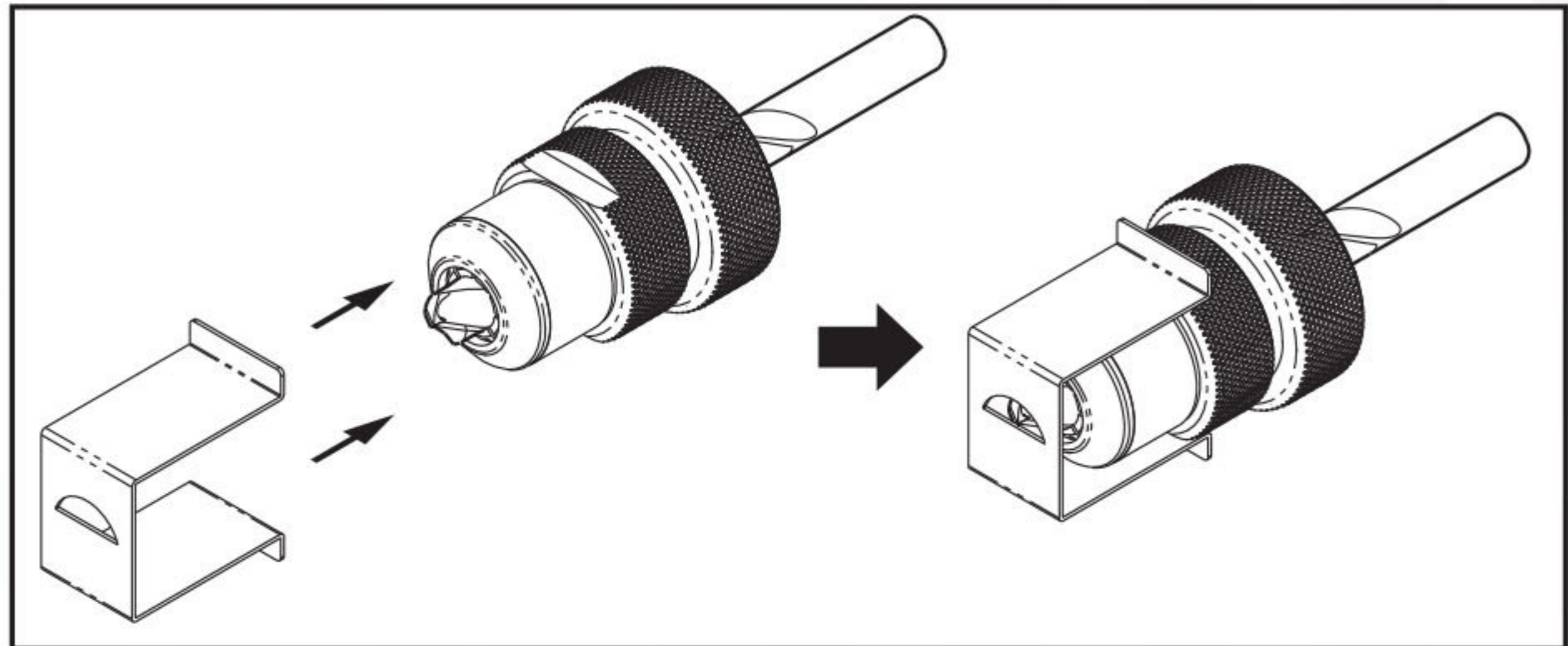


增加中心靜點厚度
放置墊片來增加中心靜點厚度為0.4mm或依墊片厚度增加

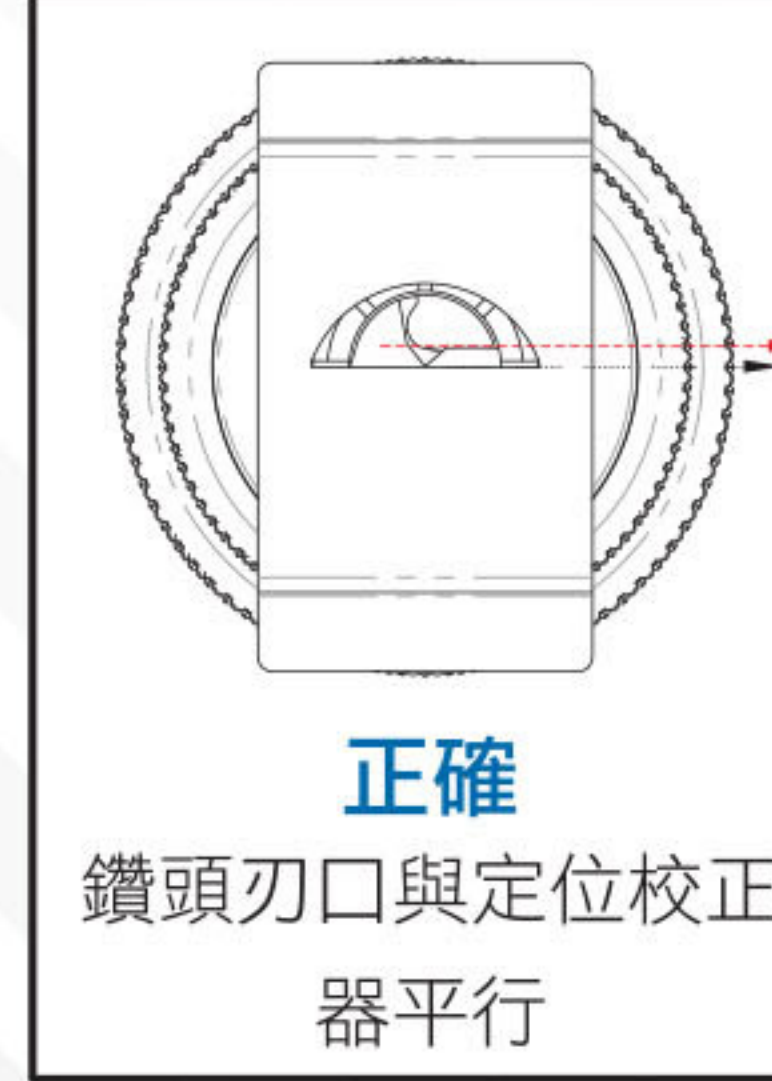
定位校正器之使用

將定位校正器平行插入夾頭組的二個缺口至底。如下圖所示

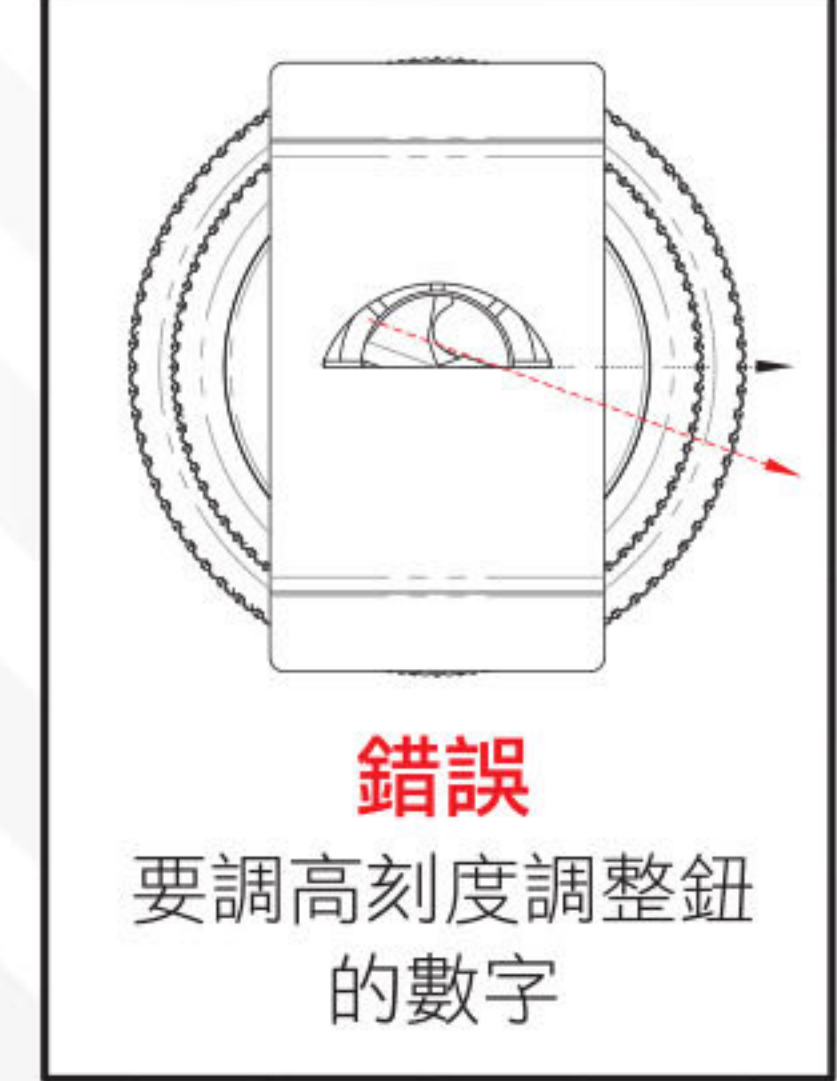
鑽頭之刀刃口，貼近定位校正器，須平行定位校正器之缺口。請參考下圖之示意圖



錯誤
要降低刻度調整鈕的數字



正確
鑽頭刃口與定位校正器平行



錯誤
要調高刻度調整鈕的數字