



GS-21 / GS-34

Drill Bit Grinder

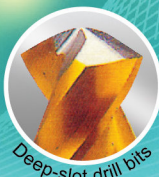
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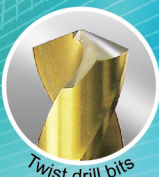
ER50 Collet & Collet Holder



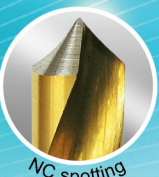
Twist drill bits



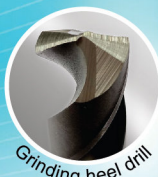
Deep-slot drill bits



Twist drill bits



NC spotting



Grinding heel drill

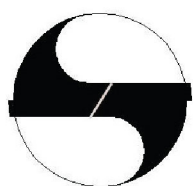
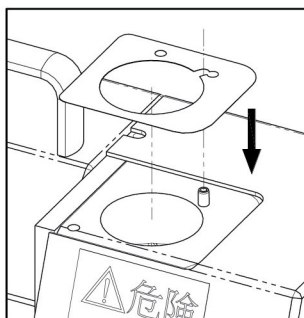


Model	GS-21	GS-34
Drill Diameter	Φ 12~26mm	Φ 12~34mm
Point Angle	90° ~140°	
Power Supply	AC110V 50/60Hz AC220V(Opt.)	
R.P.M of Motor	4600 R.P.M.	
Grinding Wheel	CBN#200	
Weight	N.W 19.8Kg G.W 22Kg	N.W 24Kg G.W 30Kg
Machine Size	L:365mm W:204mm H:223mm	
Packing Size	L:430mm W:270mm H:270mm	L:460mm W:430mm H:340mm
Type of Thinning	X Thinning	
Standard Accessories	ER32 Collet X 15 pcs	ER32 Collet X 15 pcs
	ER32 Collet Holder X 1 set	ER32 Collet Holder X 1 set
	ER50 Collet X 5 pcs	ER50 Collet X 5 pcs
	ER50 Collet Holder X 1 set	ER50 Collet Holder X 1 set
	Metal Shim 0.1mmX2 pcs / 0.3mmX1 pcs	
	Hexagon Wrench 3mmx1 , 5mmx1	
	Optional SD Grinding Wheel for Carbide Drills	

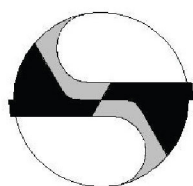
The Use of Metal Shims

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

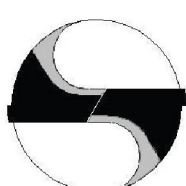
Adding one shim of 0.1mm will expand 0.2mm of the point size, adding 0.3mm shim will expand 0.6mm of the point size and so on.



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

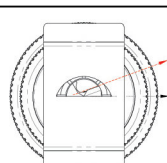
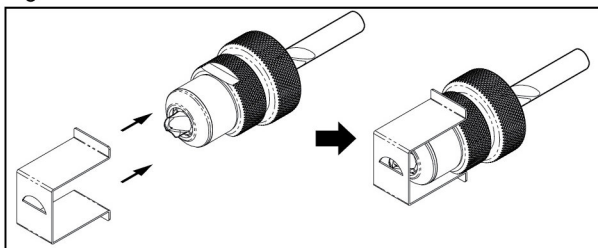


Web thinning result with metal shims. Point size: 0.4mm or bigger depend on the shims added.

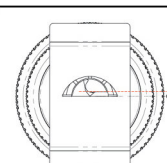
The Use of the Parallel Alignment Devise

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

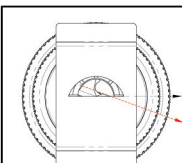
Verify the Parallelism of the Drill's Cutting Lip with the flat figure of the hole on the Parallel Devise.



Incorrect
Please decrease scale



Correct
Cutting lip parallel



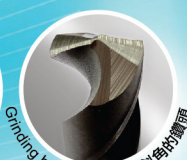
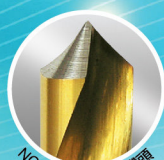
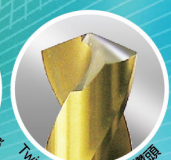
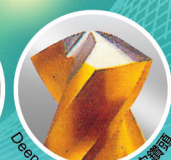
Incorrect
Please increase scale



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攜帶式鑽頭研磨機



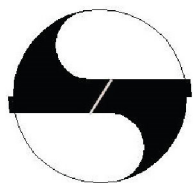
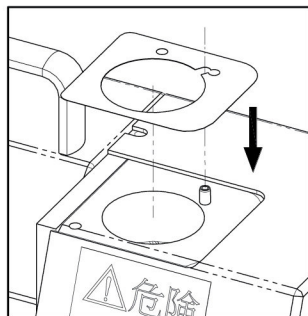
機 型	GS-21	GS-34
研 磨 尺 寸	Φ 12~26mm	Φ 12~34mm
先 端 角	90° ~140°	
電 源	單相 AC110V 50/60Hz AC220V(Opt.)	
迴 轉 數	4600 R.P.M.	
CBN鑽石砂輪	CBN#200普通鑽頭用	
重 量	N.W 19.8Kg G.W 22Kg	N.W 24Kg G.W 30Kg
機 器 長 寬 高	L:365mm W:204mm H:223mm	
包 裝 長 寬 高	L:430mm W:270mm H:270mm	L:460mm W:430mm H:340mm
研 磨 形 狀	X 形	
標 準 附 件	筒夾x15個	ER32 筒夾x 15個
		ER32 夾頭組x 1組
	夾頭組x1組	ER50 筒夾x 5個
		ER50 夾頭組x 1組
	墊片 3 pcs 0.1mmx2, 0.3mmx1	
六角扳手3mmx1, 5mmx1		
備註：（另備有鑄鋼鑽頭專用的鑽石砂輪）		

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。

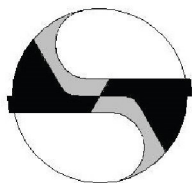
例如：一片0.1mm厚度墊片可增加0.2mm的中心靜點厚度；0.3mm厚度墊片可增加0.6mm的中心靜點厚度之以此類推。

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)。



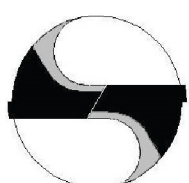
無中心靜點

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

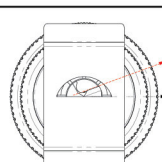
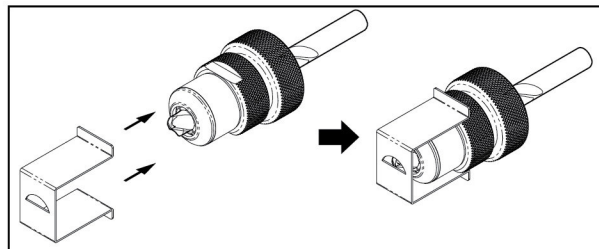
放置墊片來增加中心靜點厚度為0.4mm或依墊片厚度增加

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。

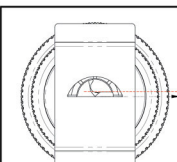
如下圖所示

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



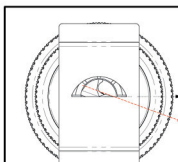
錯誤

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