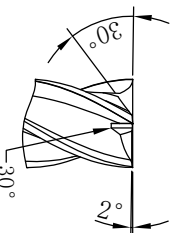


X3 Standard Accessories

Power cord	1 root
Hexagonal wrench	(3、4、5、6)mm
Clip Group	ER20(4 parts, 6 parts) 1 set of
Cylinder	ER20(φ4, φ6, φ8, φ10, φ12, φ14)
Grinding wheel	CBN230 or SDC230



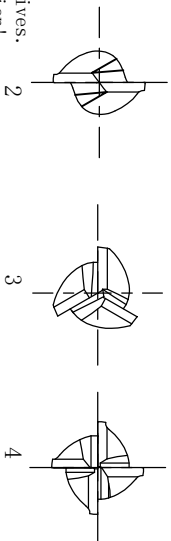
* SDC230 and CBN230 are milling cutters used to repair φ4-φ14.
1. High efficiency, good grinding effect.

2. Theoretical design accuracy guaranteed: 0.02 mm.

3. Easy to operate, for emergency convenience equipment, fast.

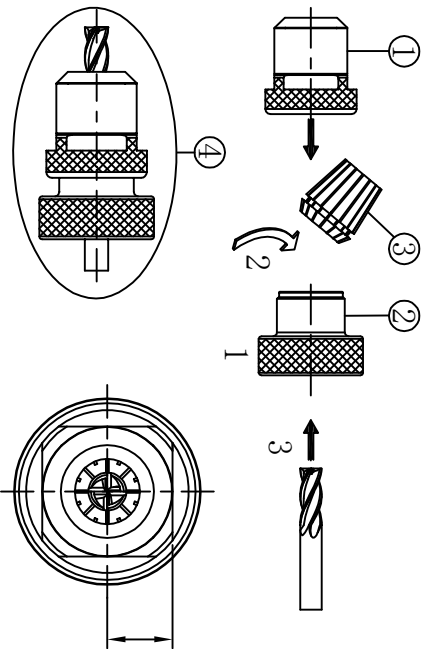
4. Grinding wheel CBN: suitable for grinding white steel knife.

SDC: Suitable for grinding hard alloy knives.
The above two can not be used in confusion!



Operating procedure

A. Assembly of the end milling cutter fixture group with "tube CLIP" and "end milling cutter"



Please assemble as shown in Figure 1.2.3.4 above. "Not locked."

1. First confirm the diameter of the cutter handle, and then select the appropriate clip and tool set.

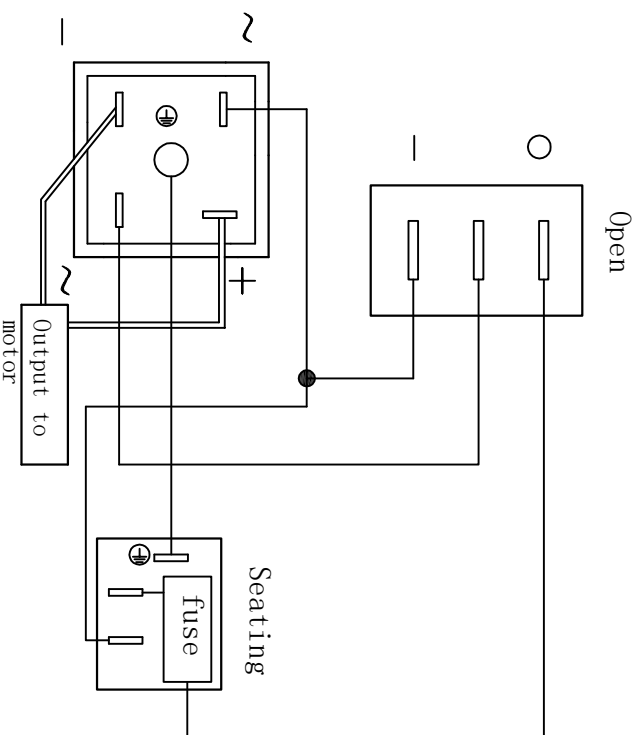
2. Embedding the holder into the fixture at the appropriate angle and locking the nut.

3. The milling cutter is loaded into the barrel and extends about 35mm.

4. Before the school knife, please visually find the central blade and parallel it to the reference slot for the location of the school knife.

(2, 4 blades with Square clips, 3 blades with hexagonal clips)

Method of power switch wiring:



matters needing attention

1. Check whether the voltage and frequency of the motor are consistent with the power supply before starting.
2. Machine power plugs, sockets on the tentacles should be secure and reliable, no loosening or contact poor appearance.
3. Unplugging the plug immediately if there is a malfunction or abnormal sound, and then perform inspection and repair.
4. Don't let the machine tools run in no one's condition, you must stop running before you can leave. If the outside world cuts off the power, press the red button, otherwise the machine will run in no one's condition.
5. Do not operate the machine under the condition of fatigue or taking alcohol or narcotic drugs.
6. When the parts and accessories on the machine tool are damaged, please do not replace them arbitrarily. The corresponding parts with the same performance should be used. Generally, the accessories of the same type of manufacturer are the best.

Adjustment and Operation

1, before starting the machine tool, and check the machine tool everywhere whether the locking mechanism is locked, there is no anomaly, and whether the machine tool electrical normal.

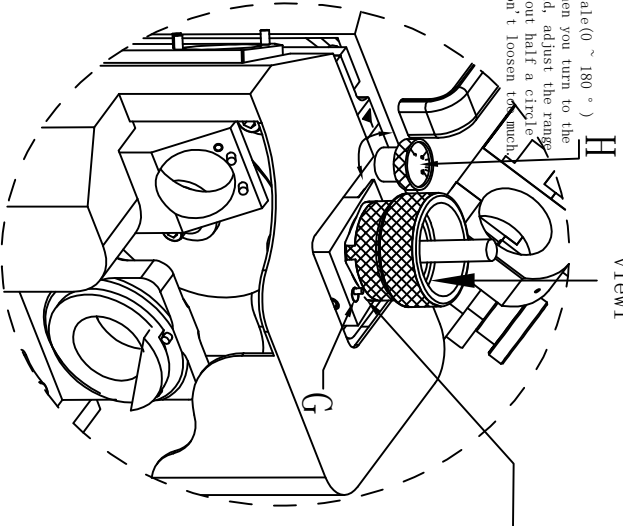
2, after the work, should clear the dust on the machine tool, and the unpainted surface painted oil to prevent rust.

D. Blade center grinding

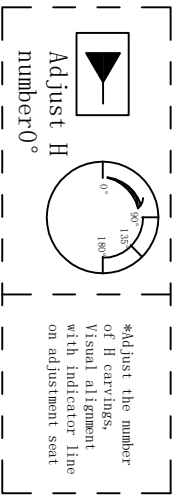
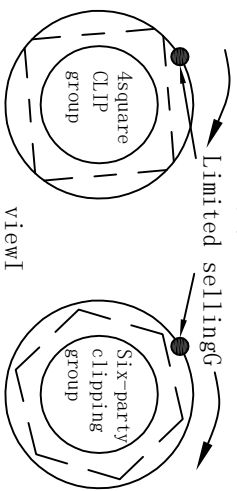
The following are the operation instructions for the details of the three types of milling cutters, and the actual conditions are specifically adjusted.

*In the clip head group, each time the grinding hole is placed, the position is overlooking, so that the limit pin is in the position where the digital flat side is left by a quarter, as shown in Figure 1

*When the grinding hole is put in, only the knob (H) that is turning to the bottom is counterclockwise returned to 90°, and the grinding edge can be left-handed. In the rest of the case, the two, three, and four blades can only be rotated to the limit so as not to remove the blade.



Scale (0° ~ 180°)
When you turn to the end, adjust the range about half a circle. Don't loosen too much.

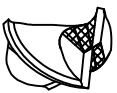


3-blade, counterclockwise (H) is turned back to 180°, the grinding hole, right-handed to the limited pin repair mill, the angle is withdrawn from the clip head group. Then rotate the clip head group 120° and grind the remaining two blades in turn.

*When repairing a 3-edge milling cutter, the number of the limiting pin Flat Square is staggered with the number facing the knife!
(For example, when the knife is used, the number is 1, 3, and 5, and the number of restricted sales corresponds to 2, 4, and 6! When repairing the 2 or 4 edge milling cutter, the number of the knife is the number of the limit pin

①、Second Blade Repair

1. Turn (H) clockwise first. When repairing the blade of the 2 blade, the method is to reverse the (H) that has been turned to the end counterclockwise to 90°, align the scale, put the clip head group into the grinding hole position, and grind it to the limit position, and then right-turn the slot. Until the limit sales G is silent, Retreat the splint group at a slight left-handed angle and rotate 180° to repair another blade.
2. Then clockwise adjust (H) to 0°, put into the clamping group, but not left-handed cutting, but directly right-turn to the limited-position pin (G) to complete the grinding of the center of the blade.



2 Blade Blade

②、Three Blade Milling

1. Turn (H) clockwise first.

When repairing the broken edge of the 1. Turn (H) clockwise first. When repairing the broken edge of the 3-blade, counterclockwise (H) is turned back to 180°, the clip head group is placed in the grinding hole, right-handed to the limited pin repair mill, and the left-hand subtle angle is withdrawn from the clip head group 120° and grind the remaining two blades in turn.

2. Clockwise adjustment (H) is 0° position. Repeat the above grinding action. Just grinding two of the three blades can be used to make the grinding cutter have a deeper groove and retain the center.



3 Blade Broken Blade

③、Four Blade Milling

1. Turn (H) clockwise to the end.

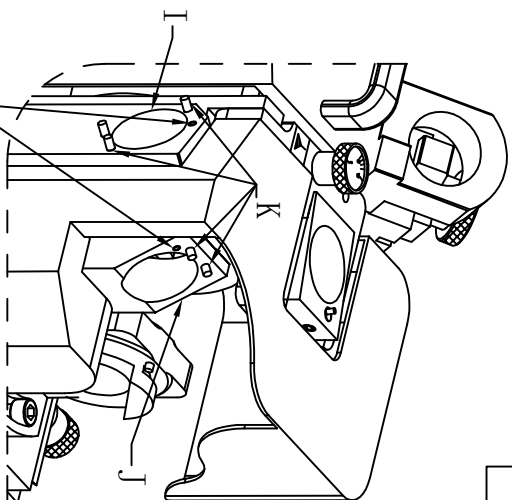
When repairing the 4-blade blade, turn counterclockwise back to 180°, put the clip head right-handed to the limited-edge pin, slightly left-handed to remove the clip head, so that the remaining three blades of the grinding edge are repaired.

2. Clockwise (H) is 0°.

* If the edge of the 4-edge milling cutter is still visible, minor trimming is required. The clip head group is placed in the grinding hole, the deep groove is aligned with the edge of the wheel, right-handed to the limit pin G, the clip head group is withdrawn at a left-handed subtle angle, and the clip head group rotates 180° to repeat the action. That is, the completion of the four-edged double-edged grinding.

E. Off-gap angle grinding

(Note: repair several edge milling cutter, select the corresponding grinding hole.)



Deep slot



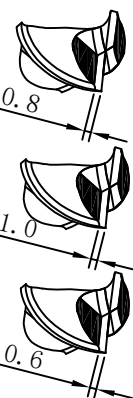
4 Blade Double Blade

*When the gap slot (I) is repairing the 3-blade milling cutter: the number of the flat square against L is the opposite of the number facing the knife!

(For example, when the knife is used, the number is 1, 3, and 5, and the number of blocks is 2, 4, and 6! It's 2, 4, 6, it's 1, 3, 5!)

The 2 edge gap angle slot (J) is inserted in the direction shown in the left figure to repair the 2 edge gap angle: The 3-and 4-blade gap angle slot (I) is the 3-and 4-blade gap angle of the repair mill. The number of the knife should be aligned with the positioning pin (K) and gently pushed to the end to silently remove; The adjusting screw (L) is used to adjust the gap angle; Repeat the above steps in another direction to complete the grinding.

Adjust 'L' tensioning
Take 2 Blades
for example
Effect description



Unscrew the screw

Under normal circumstances

Tighten the screws.

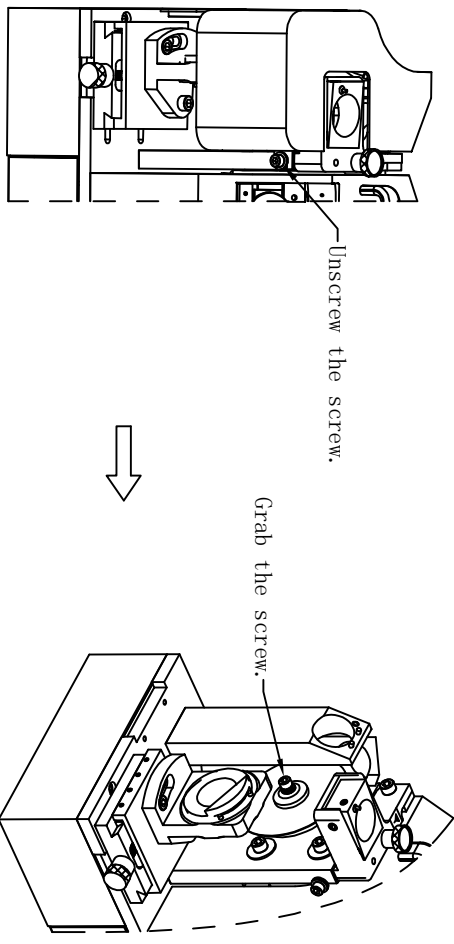
Modification effect map above



2 Blade 3 Blade 4 Blade

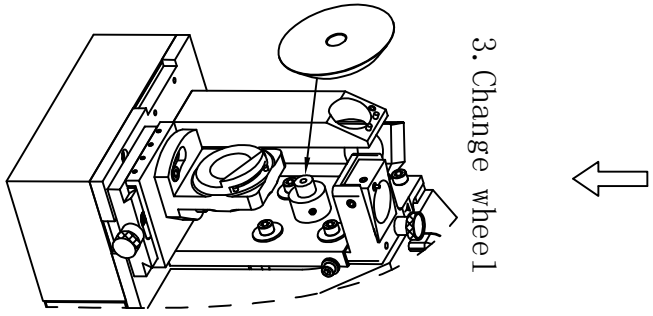
Replacement of wheel

1. Get the wheel cover.
2. Take the wheel gasket



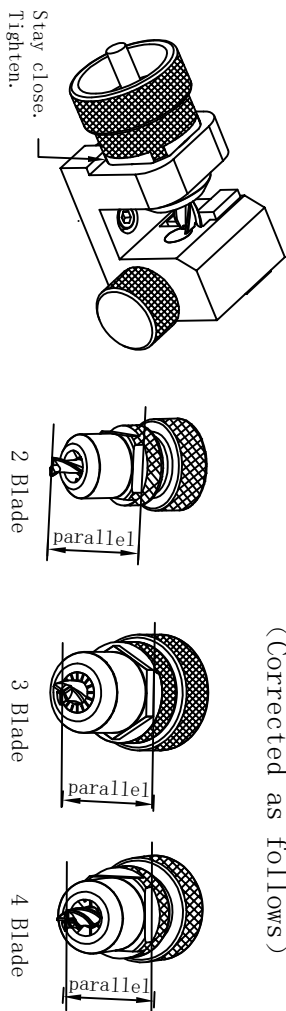
1. Make sure to unplug the power cord to ensure safety, and then use the 4mm inner hexagonal wrench to loosen the screw in the counterclockwise direction.
2. After removing the upper cover, clean the powder with a brush, and then wipe the surface with a dry cloth. (If you have just replaced it in use, please wait for 3 minutes before the temperature of the wheel has dropped to room temperature and then clear.) Hold the wheel with your left hand, turn counterclockwise with the 4mm hexagonal wrench in your right hand, and pick up the milling machine. Diamond wheel.

3. When replacing the new wheel, it should be lightly put back into the spindle of the wheel and lock back the screw and wheel cover, which is completed.
- * Precision in the assembly of the spindle of the motor, which, if poorly assembled, will result in damage to the spindle and affect the location of the wheel.



B. Calibration positioning

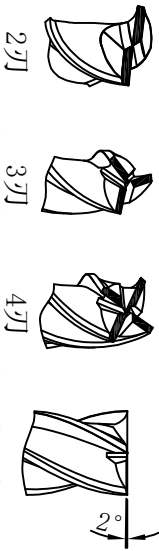
1. The fixed CLIP nut is placed in the length positioning hole, clockwise after full close connection, and rotates to the right position.
 2. The milling cutter first inserts the bottom, gently pushes the flat face to the right turn and gets stuck.
 3. Turn right to lock the top seat.
 4. Hold the fixed CLIP nut slightly to the left when taking out and take it out.
- *. The passing center blade shall be parallel to the base line under the reference slot.



C. End Grinding

- *Before grinding, please advance the longitudinal torsion wheel (E) to the appropriate grinding amount (usually the line up and down of the drag board can be aligned). When the switch light is on, the motor rotation is safe, and the milling cutter CLIP head group is placed inside the end grinding seat hole. After the clip head group and the grinder eccentric sleeve (D) are stuck (note the box prompt), gently push the bottom to grind until it is silently removed and then turn to all parties until they are ground to silence. To complete the grinding of the apex angle.

The grinding effect map is as follows



If you need to adjust the end angle, loosen the screw (F) to adjust the end surface grinding seat angle, you must lock the screw (F).

(ex-factory standard 2°, non-professionals must not adjust)
 (*When adjusting the longitudinal torsion wheel E, do not make the upper towing board advance to the end, so that it can not retreat from control.)

When grinding 2, 3, and 4 edge milling cutter: the card position number is the same as the number facing the knife! (For example, the number of the knife seat is 1, 3, and 5, and the number of the fixture group card limit is also 1, 3, and 5!)

