

# Drill Series Certificate of conformity

Product number: \_\_\_\_\_

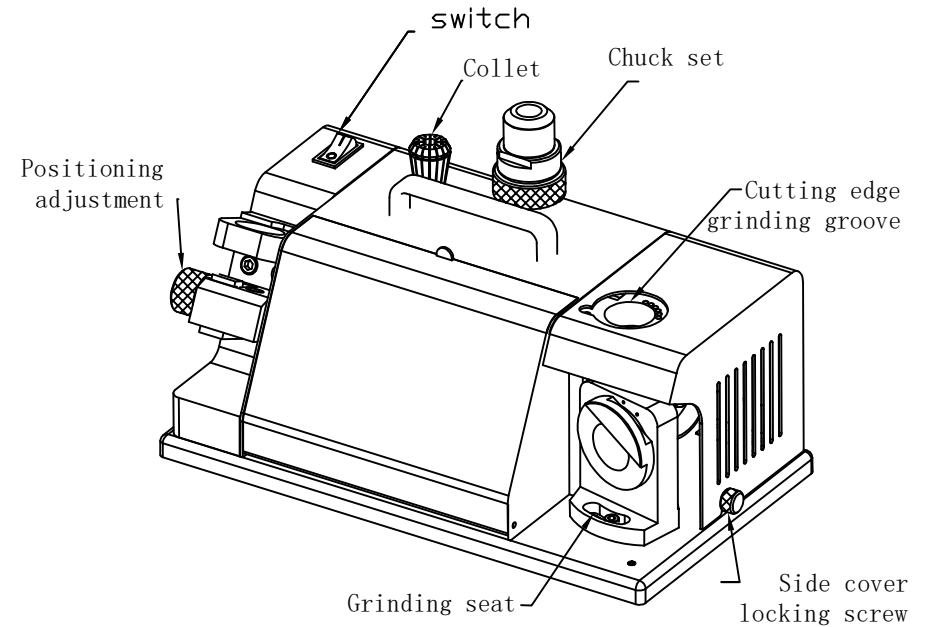
Serial number: \_\_\_\_\_

Inspectors: \_\_\_\_\_

Date of manufacture: \_\_\_\_\_

The manufacture, assembly, and performance of this product have been inspected and meet the factory quality standards.

## Z20 Drill grinder



### Main uses and characteristics

- Grinding is accurate and fast, easy to operate, and easy to grind without skill.
- Economic price, greatly save costs and improve use efficiency.
- Equipped with a Taiwanese diamond wheel, it is precise and durable.
- Electronically controlled powerful DC motor: stable frequency and strong horsepower, can be used for a long time.

model	Grinding range	power supply	Motor / Speed	weight	LxWxH
DG20M	Φ 3-Φ 20mm	AC220V 50/60HZ	120W/4800rpm	10Kg	390×220×210mm

## Z20 Standard accessories

Allen wrench	(2.5、3、4、5、6) mm
Chuck set	ER20/ER25 One set each
Collet	φ3-φ13 ER20
	φ(14、15、16、17、18、19、20) ER25
Grinding wheel	CBN or SDC

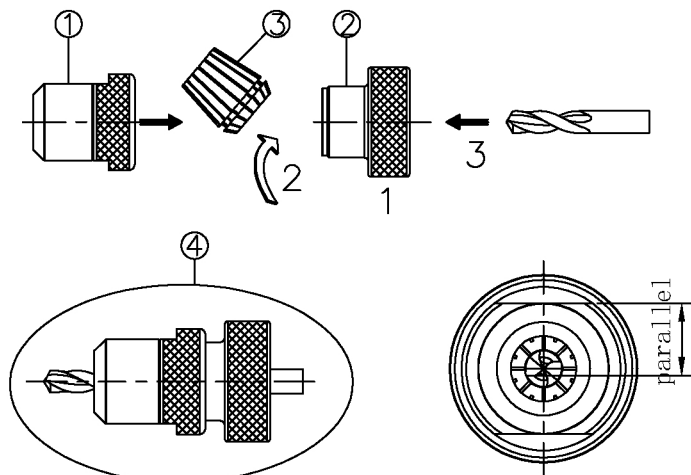
- 1.High efficiency, high quality, good grinding effect.
- 2.Theoretical design accuracy guarantee: 0.02mm.
- 3.Easy to operate, convenient for emergency, fast.
- 4.Grinding wheel CBN: suitable for grinding white steel knife.

SDC: Suitable for grinding hard alloy knives.

The above two cannot be used confusingly!

## Operating procedures

### A.Assembly of end bit clamp set with "collet" and "end bit"



\*. Please follow the steps shown in Figure 1.2.3.4 above to assemble. "Not locked"

- 1.First confirm the diameter of the drill shank, and then select the appropriate collet and tool set.
- 2.Insert the collet into the clamp at an appropriate angle and tighten the nut.
- 3.The drill is inserted into the collet and protrudes about 35mm.
- 4.Before adjusting the knife, please find out the center knife edge by visual inspection, and it should be approximately parallel to the reference groove, so as to locate the knife.

## warranty card

respected user:

The required voucher for the warranty service of this certificate, please keep it in a safe place, and it will not be replaced. When customers need technical support services, please show this certificate, we will provide you with the best quality and satisfactory service;

The following conditions are not covered by the warranty:

- 1.Failure to provide a valid warranty certificate and valid purchase certificate, or altering the warranty certificate without authorization.
- 2.The product model and body number on the warranty certificate do not match the actual product.
- 3.Damage caused by failure to use, maintain, or store as required by the product instruction manual.
- 4.Failure caused by accident, self-disassembly, man-made damage, or repair by a center other than the company's authorized center.
- 5.Damage caused by force majeure. (natural disaster)

The warranty period of this product is: from the date of purchase (the date of purchase invoice), the motor warranty for one year. Other accessories are not covered by the warranty. (Such as: packaging, product appearance man-made damage, missing accessories are not included in the warranty)

For products not covered by the warranty or beyond the warranty period, the customer still enjoys the repair service, but the maintenance cost will be charged. This card is an important basis for product warranty service, please keep it properly!

## Customer feedback form

username: \_\_\_\_\_ product name: \_\_\_\_\_

phone number: \_\_\_\_\_ Purchase date: \_\_\_\_\_

User address: \_\_\_\_\_

Signature of the operator: \_\_\_\_\_ Telephone: \_\_\_\_\_

Feedback: \_\_\_\_\_

Dealer's stamp: \_\_\_\_\_

## Precautions

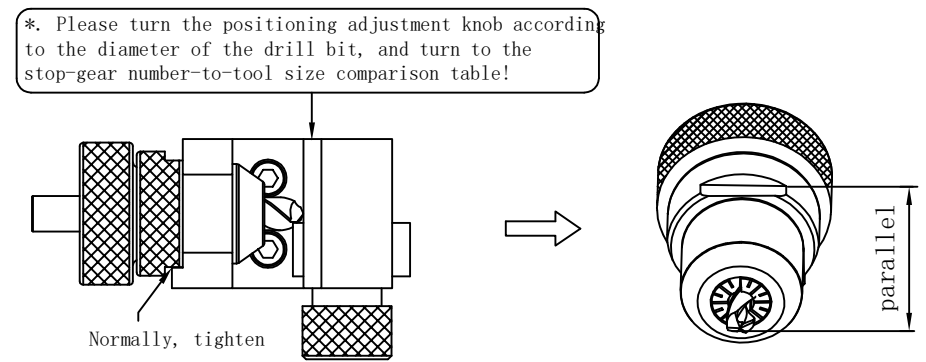
1. Check whether the voltage and frequency of the motor are consistent with the power supply before starting.
2. All antennas on the machine's power plug and socket should be tight and reliable, without loosening or poor contact.
3. Unplug immediately after malfunction or abnormal sound, and then check and repair.
4. Don't let the machine run in unmanned condition, be sure to stop running before leaving. When the external power is cut off, press the red button, otherwise the machine will run without anybody.
5. Do not operate the machine while you are tired or taking alcohol or anesthetic.
6. When the parts and accessories on the machine tool are damaged, please do not exchange them arbitrarily. Corresponding parts with the same performance should be used. It is best to use accessories of the same model from the manufacturer.

## Adjustment and operation

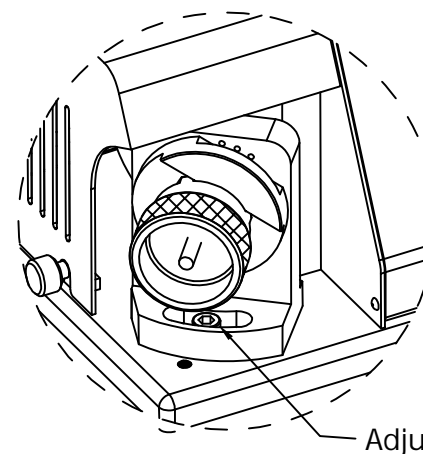
1. Before starting the machine, check whether the locking mechanisms of the machine are locked, whether there are any abnormalities, and whether the machine electrical is normal.
2. After work, the dust particles on the machine tool should be removed, and oil should be applied to the unpainted surface to prevent rust.

## B. Calibration positioning

- \*. Please turn the positioning adjustment knob according to the diameter of the drill bit, and turn to the stop-gear number-to-tool size comparison table!  
After inserting the drill clamp group into the adjustment table, turn it to the right and lock it to the bottom. After taking out the drill clamp set, confirm whether the drill blade is parallel to the core thickness. If it is not parallel, you need to set it again. If the drill bit diameter is different, the drill bit positioning block can be moved and can be adjusted by moving left and right. Once set, the clamping is good.
- \*. The center blade should be parallel to the reference line under the reference groove.

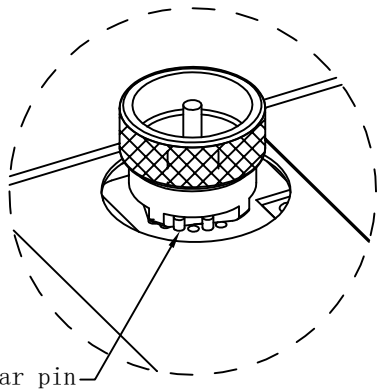


## C. Apex angle grinding



1. start the motor.
2. Put the drill fixture group into the groove of the grinding seat; determine the size of the center angle, and then slowly adjust the grinding allowance; rotate the fixture group clockwise and counterclockwise until no grinding sound can be removed, turn 180 ° Repeat the above steps to complete the grinding of the apex angle.

## D. Cutting edge grinding



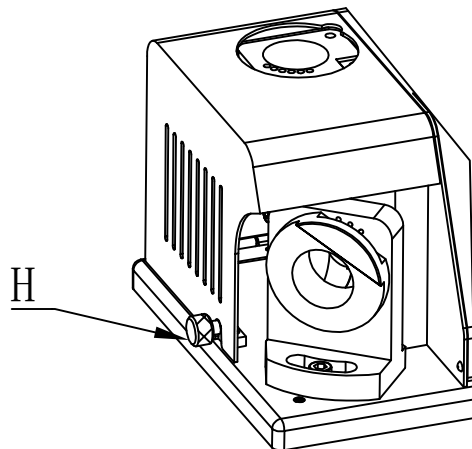
\*.After starting the motor, put the drill holder into the sharpened grinding base, and push it to the end gently, rotate it until there is no grinding sound, and then take it out. Change 180 ° and repeat the other cutting edge according to the above steps to complete the front cutting edge. Of grinding.

Adjustable rotation angle of front cutting edge

## Grinding wheel replacement

### 一. Open the side cover

1. Make sure to unplug the power cord for safety.
2. Loosen the side cover screws (H). As shown below:



## 2. Take the wheel washer

1. After removing the gland, remove the powder with a brush and wipe the surface with a dry cloth. (If it is replaced during use, please wait for 3 minutes and wait for the temperature of the grinding wheel to drop to normal temperature before removing it.) Hold the grinding wheel with your left hand, and use a 4mm hex wrench to turn it counterclockwise with your right hand. .

## 3. Dressing wheel

1. Replace with a new grinding wheel.
2. Put back the spindle of the grinding wheel, and lock the screw and the grinding wheel cover.

Power switch wiring method diagram:

