

## Drill Doctor Xp Manual

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## Book Descriptions:

# Drill Doctor Xp Manual

With its standard Diamond Sharpening Wheel it will sharpen highspeed steel, cobalt, TiNcoated, carbide and masonry drill bits. It has been designed and engineered to sharpen three of the most common drill bit types. The Heel will always be lower than the Cutting Edge. Large bits are sharpened just like any other bit. It is important to sharpen these bits so that the entire face of the drill bit is sharpened. A large bit requires more pressure and will require more halfturns to sharpen it. It may take two or three complete sharpenings repeat all steps to re sharpen a very dull or chipped large drill bit. Push and hold the Alignment Button. Partially insert the Chuck in the Alignment Port, but do not push the Chuck all the way in. Use the Chuck Knob to rotate the bit until it can be held by the Bit Clamp Arms in the narrowest width of the bit. Make sure that the bit is touching the Drill Stop, then release the Alignment Button. Turn the Chuck until the Alignment Guide on the Chuck aligns with the 118. Now, push the Chuck the rest of the way in. Tighten the Chuck, remove, and tighten again. Sharpen the small bit as usual, but use very light pressure and an even number of turns. The bit should only briefly contact the wheel. 1. Align the bit with the Masonry Sharpening Marks Insert the bit into the Chuck and line up the carbide insert on the tip of the bit so that it is parallel to the Masonry Sharpening Marks on the end of the chuck. Tighten the Chuck just to the point where the bit slides in and out. Set the depth Set the depth by lining up the Sharpening Guide with the Cam Guide. Making sure the Cam stays against Cam Guide, push the Chuck into the Sharpening Port until it stops and tighten the Chuck. Make sure carbide insert is still aligned with Masonry Sharpening Marks Remove the Chuck and tighten again. 2. Sharpening Port Cam Guide Sharpening Guide Masonry Sharpening Marks Masonry Drill Bits To sharpen a masonry bit, you do not turn the chuck. <http://www.f2dassociates.com/userfiles/cpm-machine-user-manual.xml>

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