

TM 9-3415-226-10

DEPARTMENT OF THE ARMY TECHNICAL MANUAL

OPERATOR'S MANUAL

GRINDING MACHINE, DRILL
(BLACK DIAMOND SAW AND
MACHINE WORKS, INC.,
MODEL DD2)
(3415-517-1050)

HEADQUARTERS, DEPARTMENT OF THE ARMY

WAGO 9072-A—June

JUNE 1965

OPERATING INSTRUCTIONS

for



DRILL GRINDERS



Drill Size

Adjust gauge jaws at the left of holder to loosely fit diameter of drill to be ground.



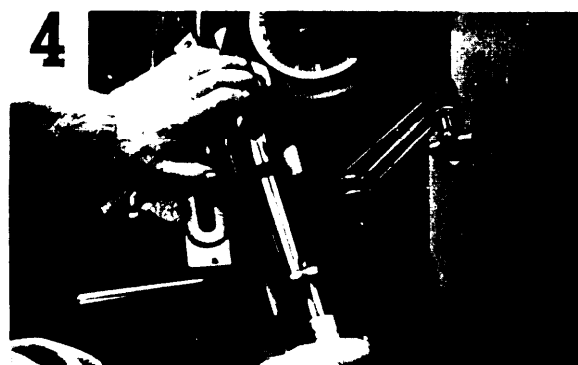
Positioning Drill

Place drill in V with outer corner of cutting lip firmly against lip rest and project end of drill about 1/16" beyond it. Adjust tail-stock to length of drill.



Positioning Holder

Move and clamp the entire holder to a position where the drill will be about 1/16" from the grinding wheel when holder is at right angles to it.



Grinding

With left hand holding drill firmly with the lower lip against the lip rest as shown, use the right hand to swing the holder back and forth. Feed with micrometer screw. Finish grinding both lips with the same adjustment.