

# **VEVOR<sup>®</sup>**

**TOUGH TOOLS, HALF PRICE**

Technical Support and E-Warranty Certificate [www.vevor.com/support](http://www.vevor.com/support)

## **DRILL BITS SHARPENER**

**MODEL: MR-13B**

We continue to be committed to provide you tools with competitive price.

"Save Half", "Half Price" or any other similar expressions used by us only represents an estimate of savings you might benefit from buying certain tools with us compared to the major top brands and does not necessarily mean to cover all categories of tools offered by us. You

are kindly reminded to verify carefully when you are placing an order with us if you are actually saving half in comparison with the top major brands.

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## NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

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This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

	<p>Warning-To reduce the risk of injury, user must read instructions manual carefully.</p>
  	<p>Always wear ANSI approved safety goggles when working with tools and equipment.</p> <p>Wear eye protection.</p> <p>Wear ear protection.</p> <p>Wear protective gloves.</p>
	<p>Compliance is a EC &amp; UK security certification.</p>
	<p><b>CORRECT DISPOSAL</b></p> <p>This product is subject to the provision of European Directive 2012/19/EC. The symbol showing a wheeled bin crossed through indicates that the product requires separate refuse collection in the European Union. This applies to the product and all accessories marked with this symbol. Products marked as such may not be discarded with normal domestic waste, but must be taken to a collection point for recycling electrical and electronic devices</p>

## Safety Warnings and Precautions

Thank you for using this product. In order to make sure that you can operate the machine correctly, read this instruction carefully before operation and keep it properly for future reference. Please be sure to read the precautions and safety rules in this page to ensure your safe use. This manual will outline safety warnings and precautions, operating, maintenance and cleaning. The warnings and instructions reviewed in this manual cannot cover all possible conditions and situations that may occur. Caution and common sense are not built into this product, since we believe that the uses will comply with these codes.

## **Please read ALL the instructions before using your machine.**

- 1. Keep work area clean.** Cluttered areas invite injuries.
- 2. Observe work area conditions.** Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep work area well lit. Do not use electrically powered tools in the presence of flammable gasses or liquids.
- 3. Keep children away.** Children must never be allowed in the work area, Do not let them handle machines, tools, or extension cords.
- 4. Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
- 5. Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. There are certain applications for which this tool was designed. It will do the job better and more safely at the rate for which it was intended. Do not modify this tool and do not use this tool for a purpose for which it was not intended.
- 6. Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts.  
Protective, electrically non-conductive clothes and no-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair
- 7. Use eye and ear protection.** Always wear ANSI approved impact safety goggles. Wear a full face shield if you are producing metal filings or wood chips.
- 8. Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines.
- 9. Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and if damaged, have them repaired by an authorized technician. The handles must be kept clean, dry, and free from oil and grease at all times. Please power off and unplug before maintenance and cleaning.
- 10. Avoid unintentional starting.** Be sure the switch is in the Off position when not in use and before plugging in.

11. **Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
12. **Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the tool if any switch does not turn On and Off properly.
13. **Guard against electric shock.** Prevent body contact with grounded surfaces such as pipes, radiators, ranges, and refrigerator enclosures.
14. **Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with tool.
15. **Do not operate tool if under the influence of alcohol or drugs.** Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.
16. **Maintenance.** For your safety, maintenance should be performed regularly by a qualified technician.
17. Never use the machine around flammable materials.
18. **Do NOT** immerse the appliance in water or any other liquid.
19. This product cannot be used for other purposes. Not suitable for commercial use. **INDOOR USE ONLY.**
20. Do not use alcohol, gasoline, etc. as coolant.
21. **Keep bystanders a safe distance away from work area. Anyone entering the work area must wear personal protective equipment.** Fragments of work piece or of a broken accessory may fly away and cause injury beyond immediate area of operation.
22. **Operations for which the power tool was not designed may create a hazard and cause personal injury.**
23. **Do not use accessories which are not specifically designed and recommended by the tool manufacturer.** Just because the accessory can be attached to your power tool, it does not assure safe operation.

24. **The rated speed of the accessory must be at least equal to the maximum speed marked in the user manual.** Accessories running faster than their rated speed can break and fly apart.

25. This appliance is not intended for use by young or infirm persons unless supervised by a responsible person to ensure that they can use the appliance safely. Young children should be supervised to ensure that they do not play with the appliance. Children and pets should stay away from the product.

26. Do not apply this unit to any other purposes than the indicated usage.

27. Do not use it outdoors or for commercial purposes. 29. **DO NOT CLEAN IT WITH ANY ABRASIVE MATERIAL.**

28. Never leave it unattended while in use.

**Note: Performance of this tool (if powered by line voltage ) may vary depending on variations in local line voltage. Extension cord usage may also affect tool performance.**

**⚠ Warning: The warnings, cautions, and instructions discussed in this instruction discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator of the tool.**

29. If the grinding wheel comes loose, turn off the machine immediately and check that it is mounted securely, and that is not damaged.

30. Never try to stop the grinding wheel with your hands, even if you are wearing safety gloves. The wheel will cut through gloves and your hand, causing serious injury. Never operate tool without the **Grinding Wheel Cover** in place.

31. If the supply cord is damaged, it must be replaced by a special cord or assembly available from the manufacturer or its service agent.

**SAVE THESE INSTRUCTIONS**

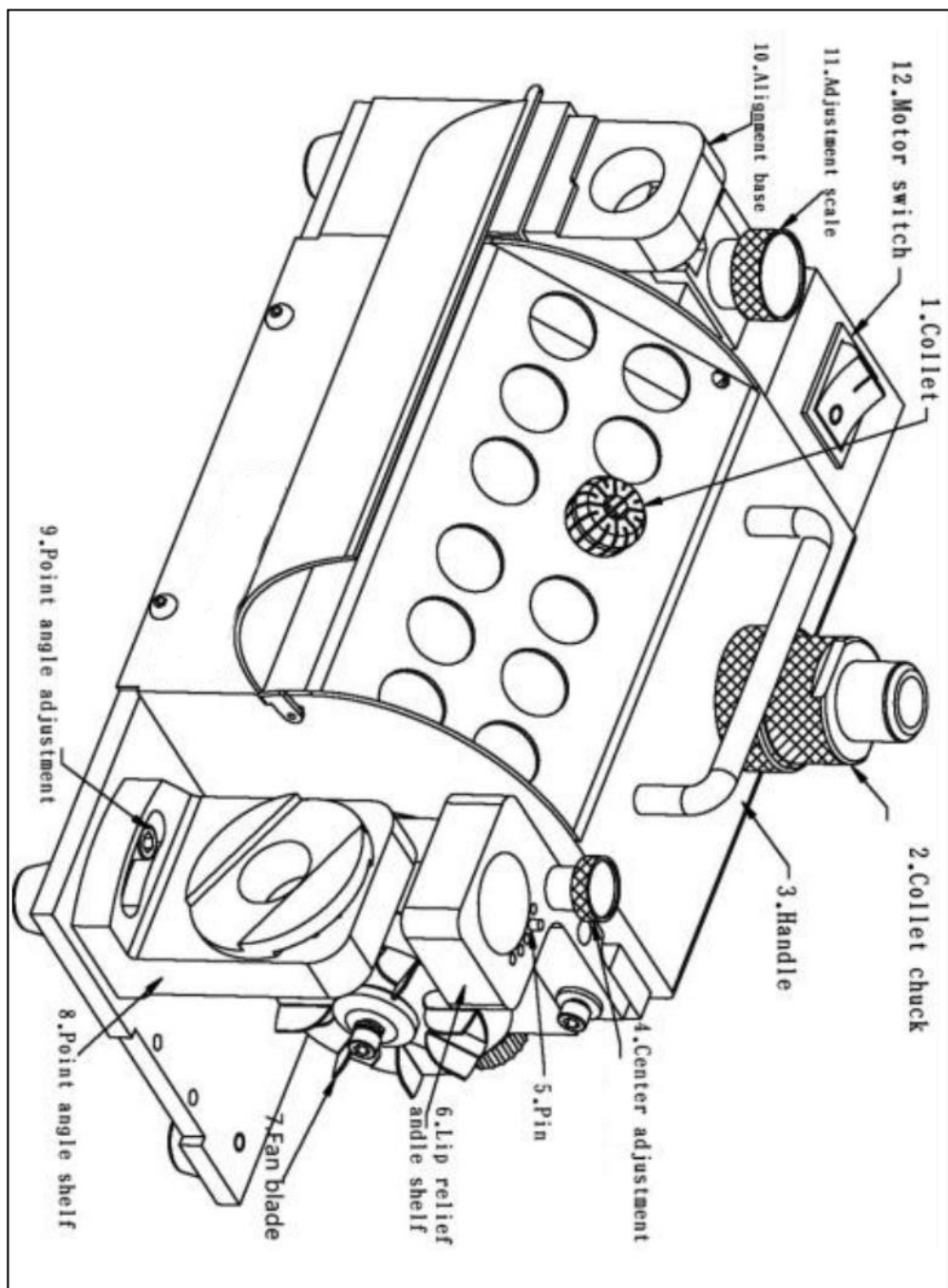
## MAIN APPLICATION AND CHARACTERISTICS

1. Grinding is accurate and rapid, easy operation with no skill to grind.
2. Economical price that greatly reduces the cost and improves the use effect.
3. With diamond grinding wheel, it can be equipped directly with an accurate angle and long service life.
4. The electrically controlled and powerful DC motor: stable frequency, strong horsepower and long service life.
5. The machine is set up with the function of adjusting a point (central point) size, which can effectively coordinate with the material of drill hole and the rotation speed. It can control the quality precision and prolong the service life of the drill bit.

## PRODUCT PARAMETERS

MODEL	Voltage	Motor Power	GRINDING RANGE	POINT ANGLE	GRINDING WHEEL
MR-13B	North America: AC120V 60Hz	120W	Φ3~Φ13mm	95°~ 135°	CBN (for HSS)×1 SD (for Carbide)×1
	European Union: AC220-240V 50Hz				CBN (for HSS)×1 SD (for Carbide)×1

**PARTS:** ER20 collets: φ3-φ13 (11pcs) ,  
 collet chuck (ER20) ×1      Electric wire×1  
 2 pcs hexagon wrench



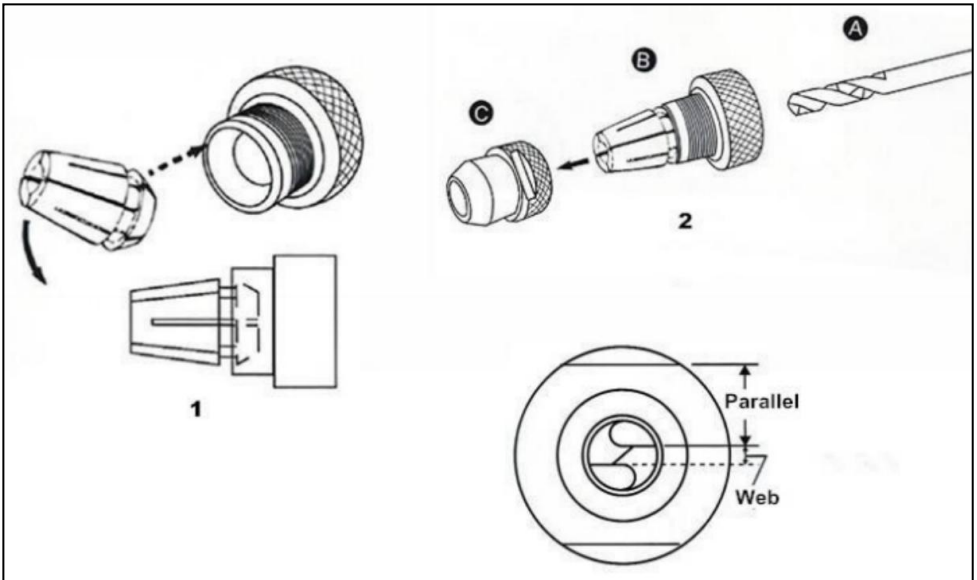


# OPERATIONS

## A. Setup the drill bit to the ER collet chuck.

\*Please follow step 1,2 to set up the drill bit to the chuck (without tightening)

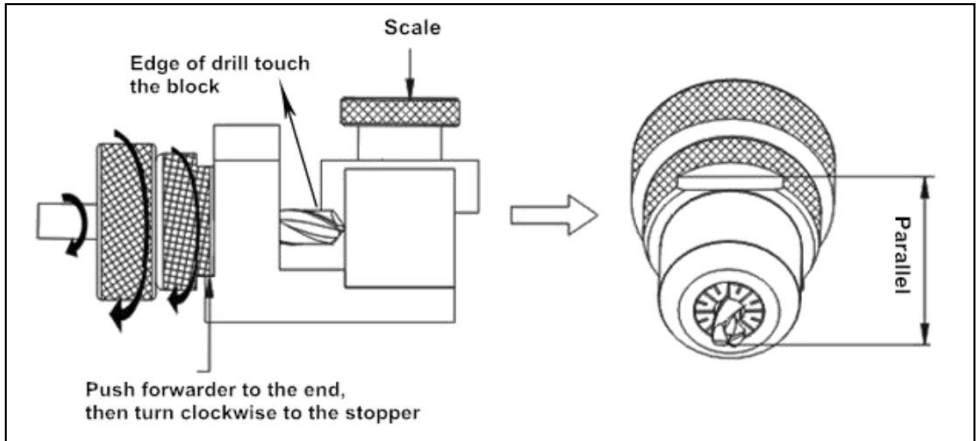
1. Determine diameter of your drill bit, and then select the proper collet and collet chuck.
  2. Insert collet into collet chuck by 45° angle, and tighten nut slightly.
  3. Insert drill bit into collet chuck and nuts out 35mm or so from the collet chuck, but do not tightened the drill too tight.
- ※ Do not fully fasten the clamping nut with collet chuck, keep the drill able to be adjusted.



## B. Align drill bit

1. Reset the scale ring: turn the ring all the way clockwise, and then turn it anti-clockwise to the number same as the drill's size.
2. Insert the chuck set into the web adjustment shelf. Then connect it tightly. Turn it clockwise to the end.

3. Plug the drill to the end and turn it clockwise to the end.
  4. Turn the chuck set clockwise to the end and tightens it.
  5. Turn the chuck set a little to the anti-clockwise and taking it out gently.
- ※ Make sure the cutting lip of drill is parallel with the slot of clamping nut before grinding job started. If it is not parallel, adjust it again.



Attention: If the cutting lip is downward, must increase the scale of web adjustment shelf. If it is upward, please decrease the scale of the web adjustment shelf.

When the flute length of a drill becomes shorter, the web thickness of a drill would become thicker. So, for the same diameter of drills, the shorter length of a drill, the higher scale of web adjustment shelf need to be increased.

### **C. Grind the point angle**

Turn the power switch on and wait until the motor rotation is stable (about 10 seconds), put the chuck set into the point angle grinding shelf.

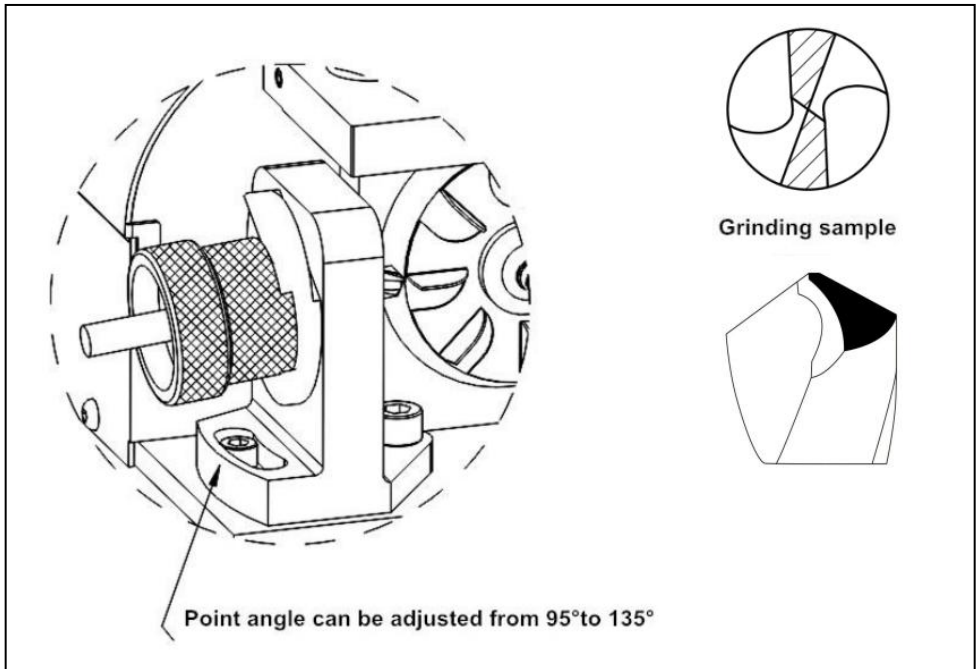
The slot of clamping nut must fit with the two pins of the grinding shelf.

Insert the drill gently into grinding shelf until reach the grinding wheel.

Grind the drill by moving left and right until the grinding sound disappears.

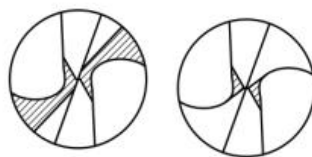
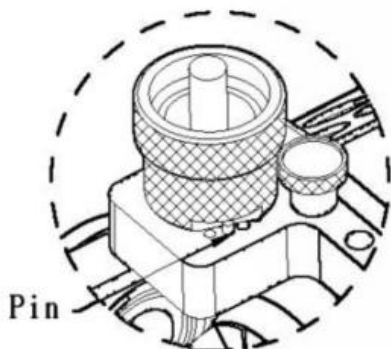
And then turn to the other side, do the same to grind the drill.

- \* The grinding size of drill is 2mm-13mm(15mm)
- \* The point angle of drill is from 95° to 135° .
- \* While grinding, don't hold the stem of drill, it will affect the accuracy.

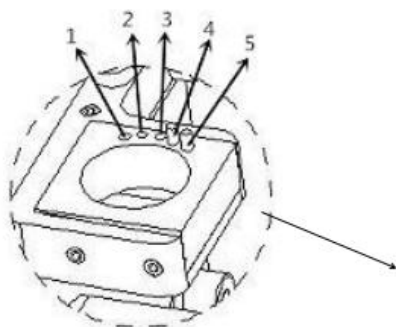


#### **D. Grind the lip relief angle**

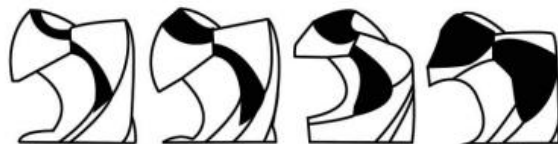
Put the chuck set into the point splitting shelf. The slot of clamping nut must fit with the pin of the grinding shelf. Insert the drill gently into grinding shelf until reach the grinding wheel. Grind the drill by moving left and right until the grinding sound disappears. Turn back to the center of pin and take out, then turn to the other side, do the same to grind the drill.



Grinding sample



**Notice:** The lip relief angle is adjustable by taking out the pin to the another holes. Our standard is the smallest(in the position of No.4&5) for grinding the lip relief face. If need big size for the relief face, put the pin near to the grinding wheel, then grind. There are four positions such as: NO.4&5, No.3&4, No.3, No.1&2.



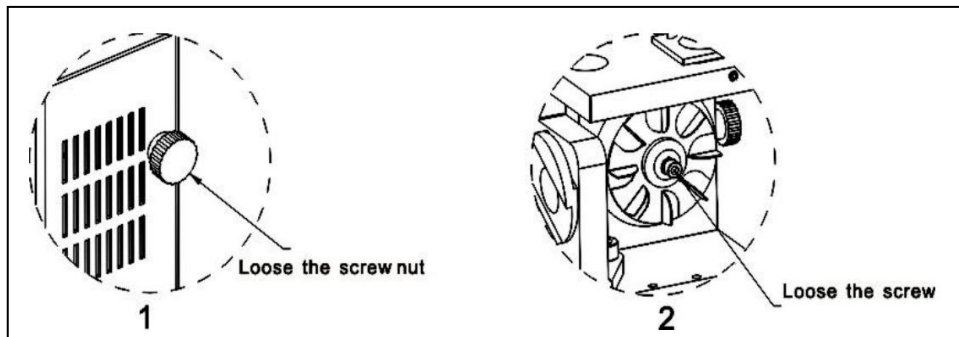
Four types of lip relief face

## CLEAN AND MAINTENANCE

Please clean the whole unit with an air blow gun, especially the holes before and after use.

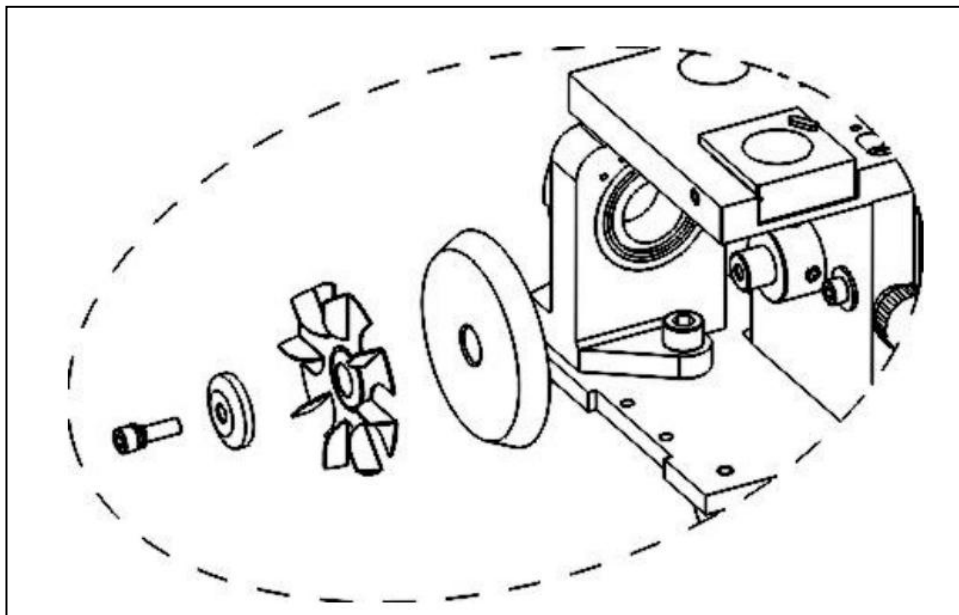
# REPLACING THE WHEEL

## A. Open the wheel cover



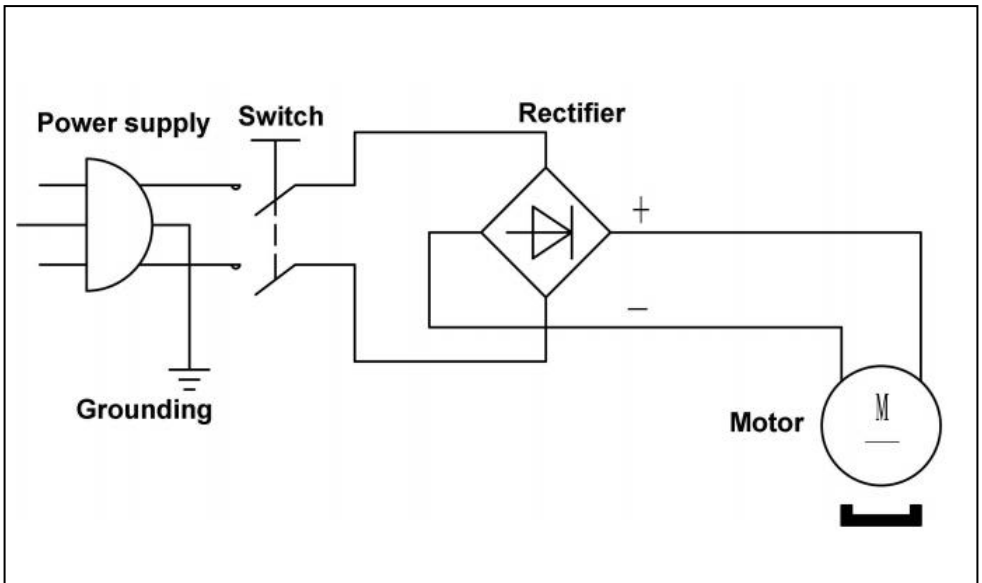
1. Make sure it is safe that the power cord is unplugged
2. Then use the 4mm hex wrench to loose the screw to open the cover.

## B. Take out the grinding wheel



1. Use the brush to clean the machine, then use dry cloth to clean the surface.
2. If you just use the the machine, please wait 3 minutes after the grinding temperature is fall.
3. Use the left hand to hold the wheel, then use the 4mm hex wrench to loose the screw counterclockwise by right hand.
4. Take out the diamond grinding wheel on the machine.
5. Replace the new grinding wheel.
6. Put the wheel into the principal axis of motor, and tighten the screw and the wheel cover to complete.

Notice: motor principal axis is very precise, if wrong work may be leading to the damage, thus affecting grinding wheel position.



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