



# SAFEWAY

## SAFEWAY PRECISION DRILL SHARPENER



### Features

User friendly with simple operations.  
Diamond wheel supplied for long life  
Manufactured from steel with no die cast or plastic components  
240 Volt motor  
Grinds drills to precision points in a range of angles from 110 - 135 deg.  
Other features are split point and back relieving

Model SA-1300 3-13mm Cap. (D114)  
Drills held in ER20 Collets supplied

Model SA-2500 12-25mm Cap. (D115)  
Drills held in ER40 Collets supplied

### Setup Instructions

1. Select the correct collet. Collets have 1mm of movement allowing for both imperial and metric drills. Ensure that the collet is placed in the adapter correctly so as to hold it securely, and allow for the collet to release when the adapter is unscrewed (Fig.1)



Fig.1

2. Set the setting gauge so that the size of the drill is against on the yellow line. (Fig.2)

Fig.2





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## DRILL SHARPENERS

### Setup Instructions Cont.

3. Place the holder in the setting gauge insuring that the holder has been turned clockwise so that holder is hard up against the stop pin. Place the drill in the holder and with the drill point sitting on the base of the setting gauge rotate clockwise until the drill flute comes to a stop against the setting gauge. Then tighten. (Fig.3)

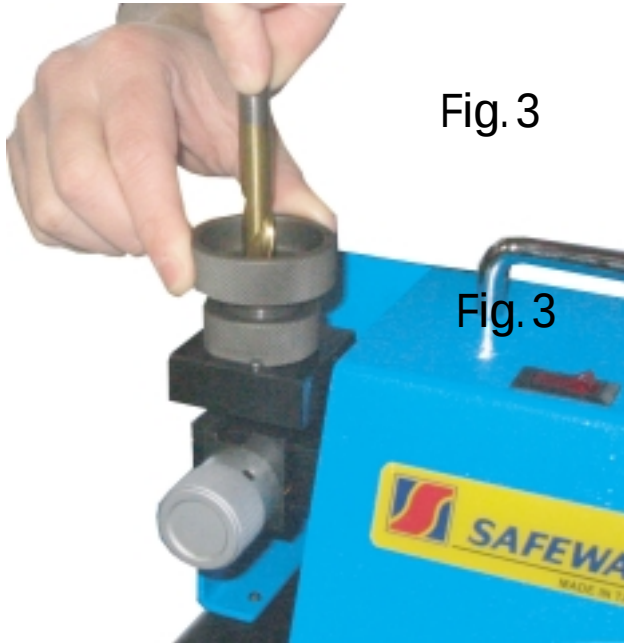


Fig. 3

4. Loosen the socket head cap screw that secures the point grinding locator and set the point angle SA-1300 100-135 deg. SA-2500 90-140 deg. (Fig.4)

Fig. 4



5. Take the holder and place in the grinding locator which uses the two pins to set the correct position of the drill. Slowly insert until the drill touches the wheel then rotate back and forth slowly moving the holder deeper into the locator until the wheel sparks out. Withdraw the holder and rotate 180 deg. and complete the operation for the other side of the drill point (Fig.5)



Fig. 5

6. To split the point or back relieve the drill, place the adaptor in the top locator. (Fig.6) For just split point locate the holder against the pin (Fig.7) at the full clockwise position and rotate slightly anti clockwise. For back relieving rotate anti clockwise until adaptor comes to rest on the pin (Fig.8)



Fig. 6

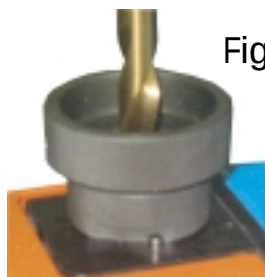


Fig. 7

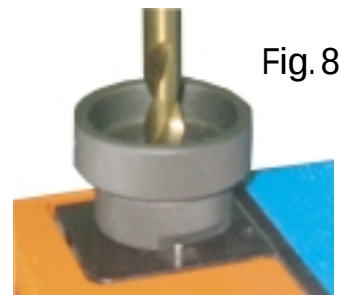


Fig. 8



# SAFEWAY

## DRILL SHARPENERS

### Setup Instructions Cont.

3. Place the holder in the setting gauge insuring that the holder has been turned clockwise so that holder is hard up against the stop pin. Place the drill in the holder and with the drill point sitting on the base of the setting gauge rotate clockwise until the drill flute comes to a stop against the setting gauge. Then tighten. (Fig.3)

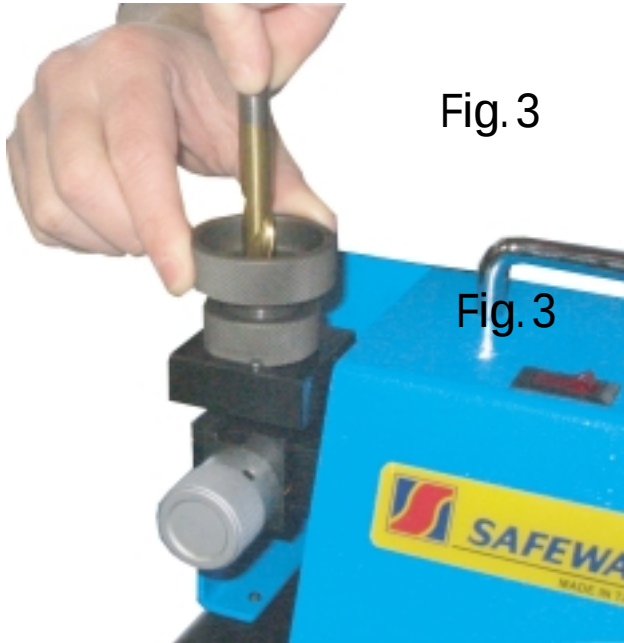


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Fig. 5

6. To split the point or back relieve the drill, place the adaptor in the top locator. (Fig.6) For just split point locate the holder against the pin (Fig.7) at the full clockwise position and rotate slightly anti clockwise. For back relieving rotate anti clockwise until adaptor comes to rest on the pin (Fig.8)



Fig. 6

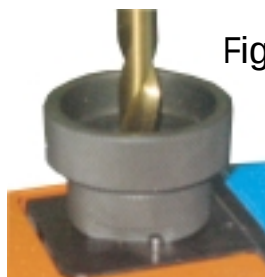


Fig. 7

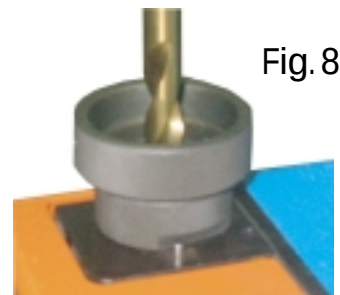


Fig. 8



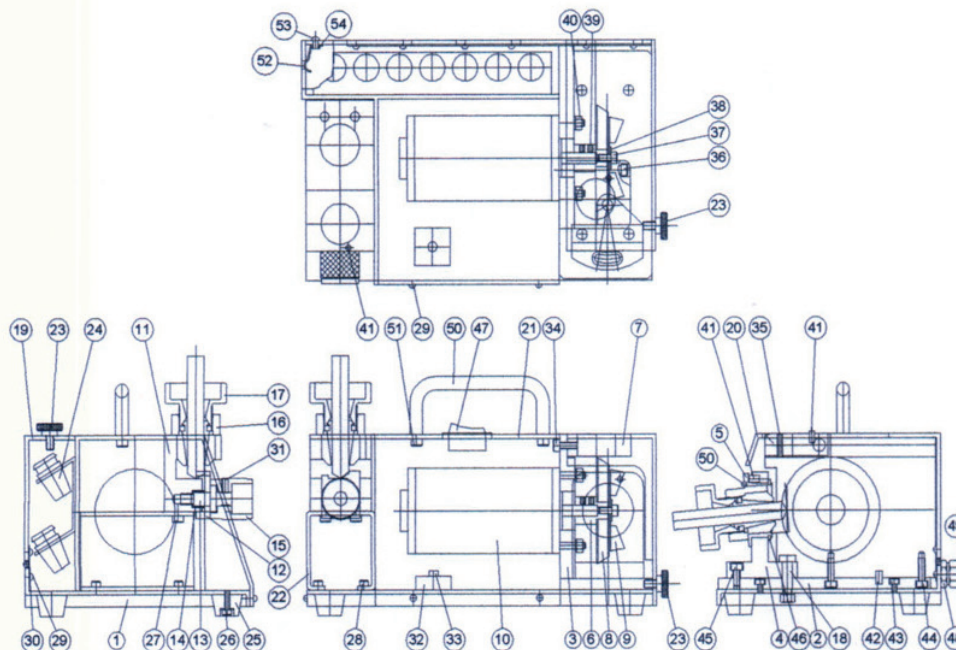
# D114 SAFEWAY SA-1300 DRILL SHARPENER

# D115 SAFEWAY SA-2400 DRILL SHARPENER

Please note when ordering SA-2400 parts just change the SA-1300 on the drawing under Part number to SA-2400

## SAFEWAY MACHINERY INDUSTRY CORPORATION PART LIST

|             |           |       |         |                        |      |              |
|-------------|-----------|-------|---------|------------------------|------|--------------|
| Computer No | 078201300 | Model | SA-1300 | Drill Drinding Machine | Date | 13 Sep. 2004 |
|-------------|-----------|-------|---------|------------------------|------|--------------|



|    |              |             |                            |    |        |                                           |              |             |                  |   |        |
|----|--------------|-------------|----------------------------|----|--------|-------------------------------------------|--------------|-------------|------------------|---|--------|
| No | Computer No  | Part No     | Part Name                  | Q  | Remark | 32                                        | 078201300-02 | SA-1300-026 | Bridge Diode     | 1 | 100    |
| 1  | 078201300-00 | SA-1300-001 | Base Bracket               | 1  |        | 33                                        | SCM04x15L    | SCM04x15L   | Socket Cap Screw | 1 | M4x15L |
| 2  | 078201300-00 | SA-1300-002 | Base Plate                 | 1  |        | 34                                        | SCM05x15L    | SCM05x15L   | Socket Cap Screw | 1 | M5x15L |
| 3  | 078201300-00 | SA-1300-003 | Motor Bracket              | 1  |        | 35                                        | SSM04x16L    | SSM04x16L   | Set Screw        | 1 | M4x16L |
| 4  | 078201300-00 | SA-1300-004 | Angle Bracket              | 1  |        | No Computer No Part No Part Name Q Remark |              |             |                  |   |        |
| 5  | 078201300-00 | SA-1300-005 | Angle Cam                  | 1  |        | 36                                        | SCM05x50L    | SCM05x50L   | Socket Cap Screw | 1 | M5x50L |
| 6  | 078201300-00 | SA-1300-006 | Sleeve                     | 1  |        | 37                                        | SCM05x10L    | SCM05x10L   | Socket Cap Screw | 1 | M5x10L |
| 7  | 078201300-00 | SA-1300-007 | Chisel edge Bracket        | 1  |        | 38                                        | WS05         | WS05        | Washer           | 1 | M5     |
| 8  | 078201300-00 | SA-1300-008 | Wheel (#200)               | 1  |        | 39                                        | SSM04x06L    | SSM04x06L   | Set Screw        | 2 | M4x6L  |
|    | 078201300-03 | SA-1300-038 | Wheel (#400)               | 1  |        | 40                                        | HN05         | HN05        | Nut              | 2 | M5     |
| 9  | 078201300-00 | SA-1300-009 | Fan                        | 1  |        | 41                                        | PIN04x08L    | PIN04x08L   | Pin              | 3 | 4x8L   |
| 10 | 078201300-01 | SA-1300-010 | Motor (110V)               | 1  | DC110V | 42                                        | PIN05x08L    | PIN05x08L   | Pin              | 2 | 5x8L   |
|    | 078201300-04 | SA-1300-040 | Motor(220V)                | 1  | DC220V | 43                                        | SCM04x08L    | SCM04x08L   | Socket Cap Screw | 4 | M4x8L  |
| 11 | 078201300-01 | SA-1300-011 | Length Pre-setting Bracket | 1  |        | 44                                        | SCM05x15L    | SCM05x15L   | Socket Cap Screw | 3 | M5x15L |
| 12 | 078201300-01 | SA-1300-012 | Position Pre-setting block | 1  |        | 45                                        | SCM05x12L    | SCM05x12L   | Socket Cap Screw | 1 | M5x12L |
| 13 | 078201300-01 | SA-1300-013 | Position Pre-setting Screw | 1  |        | 46                                        | SR-R40       | SR-R40      | Snap Ring        | 1 | R40    |
| 14 | 078201300-01 | SA-1300-014 | Spring                     | 1  |        | 47                                        | 078201300-02 | SA-1300-027 | Switch           | 1 |        |
| 15 | 078201300-01 | SA-1300-015 | Scale                      | 1  |        |                                           | 078201300-04 | SA-1300-041 | Switch (CE)      | 1 | CE     |
| 16 | 078201300-01 | SA-1300-016 | Collet Holder              | 1  |        | 48                                        | 078201300-02 | SA-1300-028 | Cable Nut        | 1 |        |
| 17 | 078201300-01 | SA-1300-017 | Collet Nut                 | 1  |        | 49                                        | 078201300-02 | SA-1300-029 | Cable Nut        | 1 |        |
| 18 | 078201300-01 | SA-1300-018 | Shaft                      | 1  |        | 50                                        | 078201300-03 | SA-1300-030 | Handle           | 1 |        |
| 19 | 078201300-01 | SA-1300-019 | Back Cover                 | 1  |        | 51                                        | SCM05x10L    | SCM05x10L   | Socket Cap Screw | 2 | M5x10L |
| 20 | 078201300-02 | SA-1300-020 | Side Cover                 | 1  |        | 52                                        | 078201300-03 | SA-1300-031 | Power Cable      | 1 |        |
| 21 | 078201300-02 | SA-1300-021 | Front Cover                | 1  |        | 53                                        | 078201300-03 | SA-1300-032 | Plug             | 1 |        |
| 22 | 078201300-02 | SA-1300-022 | Bracket                    | 1  |        | 54                                        | 078201300-03 | SA-1300-033 | Name Plate       | 1 |        |
| 23 | 078201300-02 | SA-1300-023 | Knob                       | 1  |        | 55                                        | 078201300-03 | SA-1300-034 | carton           | 1 |        |
| 24 | ER20         | ER20        | ER20 Collet                | 13 | φ 3-13 | 56                                        | 078201300-03 | SA-1300-035 | Attention Sign   | 1 |        |
| 25 | 078201300-02 | SA-1300-024 | Rubber Pad                 | 4  |        | 57                                        | 078201300-03 | SA-1300-036 | AC110-120V sign  | 1 |        |
| 26 | SCM04x15L    | SCM04x15L   | Socket Cap Screw           | 2  | M4x15L | 58                                        | 078201300-03 | SA-1300-037 | AC220-240V sign  | 1 |        |
|    | SCM04x25L    | SCM04x25L   | Socket Cap Screw           | 2  | M4x25L |                                           |              |             |                  |   |        |
| 27 | SCM05x12L    | SCM05x12L   | Socket Cap Screw           | 2  | M5x12L |                                           |              |             |                  |   |        |
| 28 | SCM04x08L    | SCM04x08L   | Socket Cap Screw           | 4  | M4x8L  |                                           |              |             |                  |   |        |
| 29 | SDM03x06L    | SCM03x06L   | Round Socket Cap Screw     | 12 | M3x6L  |                                           |              |             |                  |   |        |
| 30 | 078201300-02 | SA-1300-025 | Leaf                       | 3  |        |                                           |              |             |                  |   |        |
| 31 | SCM05x10L    | SCM05x10L   | Socket Cap Screw           | 1  | M5x10L |                                           |              |             |                  |   |        |