

Large Drill Attachment LEX050

Congratulations on the purchase of your **Darex XT-3000** Large Drill Attachment. (21 mm—30 mm) As part of the assembly (see picture from left to right) you should have a SA16565XA Large drill alignment, SA16575CA Sharpening fixture,



and SA16500TA Large Drill Chuck.

By now you are familiar with the 'quick disconnect' feature of your **XT-3000**. Start by placing the Large Drill Alignment on the top of your **XT-3000**. Rotate the 'Docking Lever' clockwise to securely lock the fixture in place. In a similar manner, remove your current sharpening fixture and replace it with the Large Drill Sharpening



Fixture.

Now would be a great time to determine the point angle of the drill that is to be sharpened and adjust both the sharpening fixture and alignment to that point angle. The Sharpening fixture is adjusted by pulling the red lever towards (counter clockwise) the operator and sliding the fixture to the point angle desired. Lock the fixture by returning the red lever to its original position. The



alignment is adjusted by rotating the black lever located at on the front of the alignment fixture. As per the decal, rotating the lever towards the operator will reduce the amount of relief ground onto the drill and pushing the lever away from the operator will increase the relief. Placing the pin at the midway point on the decal is a good starting place for 118° drills. For 135°-150° drills start with the alignment 2 marks towards the operator. You can set the alignment at any setting necessary to achieve the amount of relief desired.

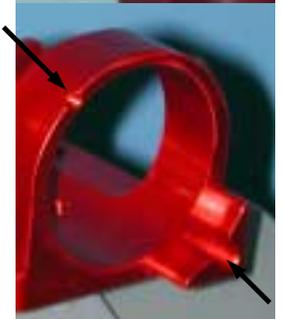


Place the drill in the chuck and turn the chuck knob clockwise until the drill slides freely through the chuck jaws. Next slide the Chuck and drill into the alignment rotating the chuck until one of the



'cam dogs' aligns with the mating 'notch' in the fixture.

You will notice the opposite 'dog' aligns with a reference mark machined into the alignment fixture.



Now push the drill through the chuck until it contacts the stop. Rotate the drill clockwise until



Incorrect

Correct

the outer edge of the cutting lip is touching the pins in the setting fixture.

Firmly tighten the chuck by turning the knob clockwise while the chuck is still in the fixture. Remove the chuck and drill. The drill is now aligned and set to length to the chuck cam for the necessary grinding.

Slide the chuck into the Sharpening fixture and rotate the Chuck clockwise applying slight pressure into the wheel. It is also necessary to keep the cam up against the swing cam follower bearing.



Try to sharpen the drill in such a manner that the drill is off the wheel before you reposition your hand on the chuck.

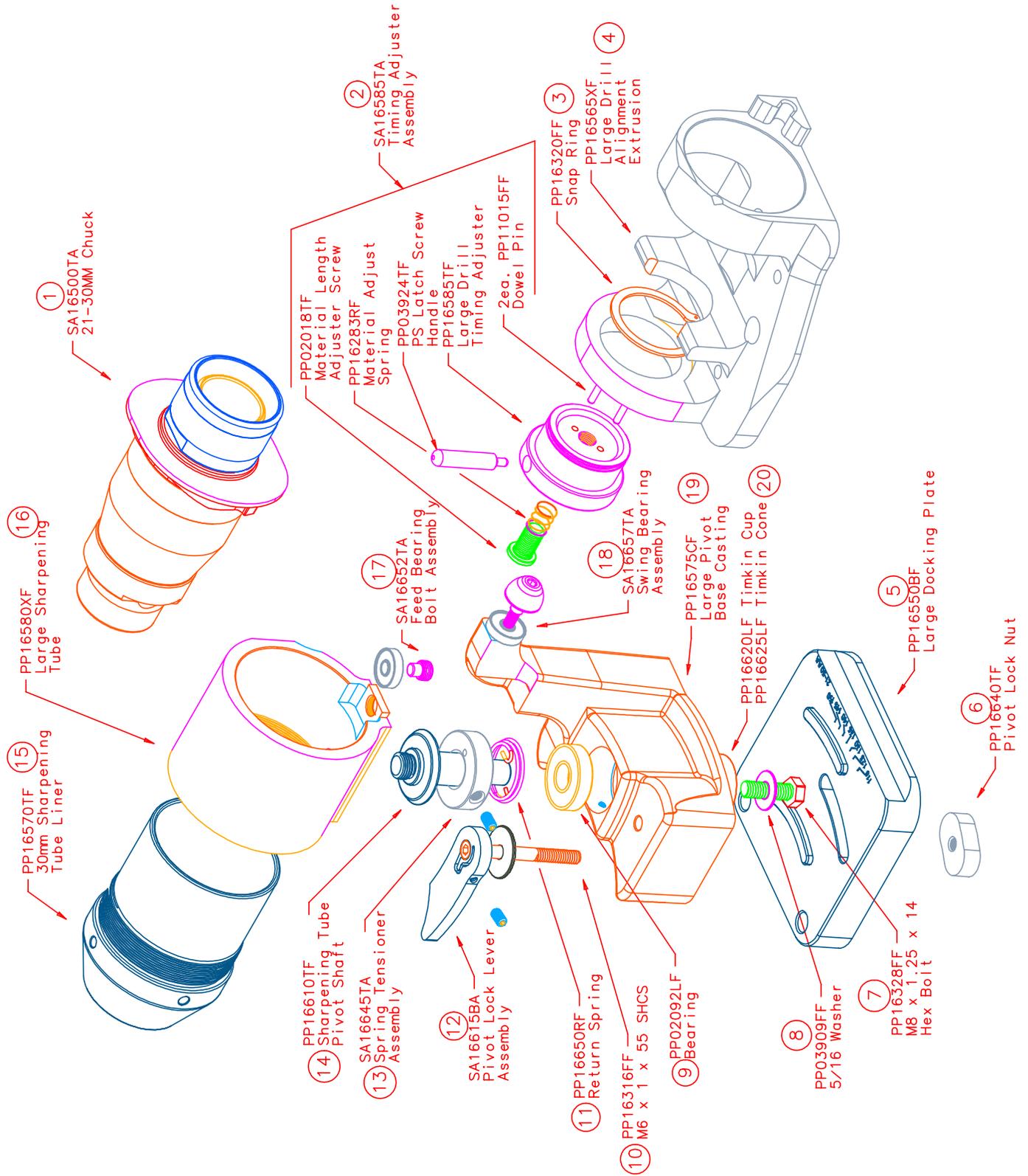


Grinding time will vary depending on wheel condition and amount of material removal but it should require a minimum of 8-10 rotations.

NOTE: The MTO drill stop setting is adjustable using a 5/32" or 4 mm hex key if you think more or less material removal is desired.

Please Note, you do not have the ability to split drills from 21 mm to 30 mm on the XT-3000.

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SA16615BA	Pivot Lock Lever Assembly	
	PP16615BF	Pivot lock lever
	PP16630FF	5mmX8mm SSS
SA16585TA	Timing Adjuster Assembly	
	PP16283RF	Material adjust spring
	PP16285TF	Material adjust screw
	PP03924TF	PS Latch Screw Handle
	PP16585TF	Large Drill Timing Adjuster
	PP11015FF	1/8" Dowel Pins
SA16652TA	Feed Bearing Assembly	
	PP16652TF	Feed Bearing Bolt
	PP08560LF	Bearing
SA16657TA	Swing Bearing Assembly	
	PP16655LF	Swing Bearing
	PP16657TF	Swing Bearing Bolt
SA16645TA	Spring Tensioner Assembly	
	PP16645TF	Spring Tensioner
	PP12280FF	M6 x 1 x 8mm SSS
SA16500TA	21-30 MM Chuck	
	PP16500TF	Large chuck Body 21-30mm
	PP16505TF	21-30mm chuck cam
	PP16510TF	21-30mm chuck knob
	PP16515TF	21-30mm Closing sleeve
	PP16520TF	21-30mm closing screw
	PP16525NF	Thrust Washer
	PP16530SF	Jaws
	PP16535TF	Jaw guide
	PP16472FF	Snap ring
	PP16540LF	Jaw race
	PP12560RF	Jaw springs
	PP16440FF	Jaw key screw