

### ***21. SPECIAL ACCESSORY FOR BSG 60 COUNTERSINK AND CUTTER SHARPENING DEVICE SZVR***



## 22. FIXATION & ALIGNMENT OF COUNTERSINK

**SZVR Basic version: curve for countersinks with 3 cutting edges + Curve for cutters**

Place your countersink in the suitable collet and let project approx. **10 mm** outside. Then softly tighten the collet nut. Now press the body of the SZVR downwards until it snaps in (Pay attention, that the grid pins can snap in, eventually turn a little).

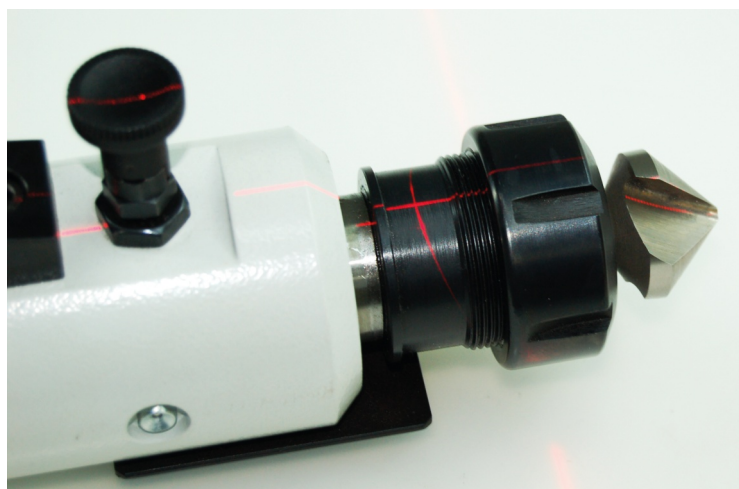


Press body of SZVR downwards till it snaps in.

After the SZVR is snapped in, softly press against the grid pin snaps in again. This grants that the alignment position of the countersink is attained.

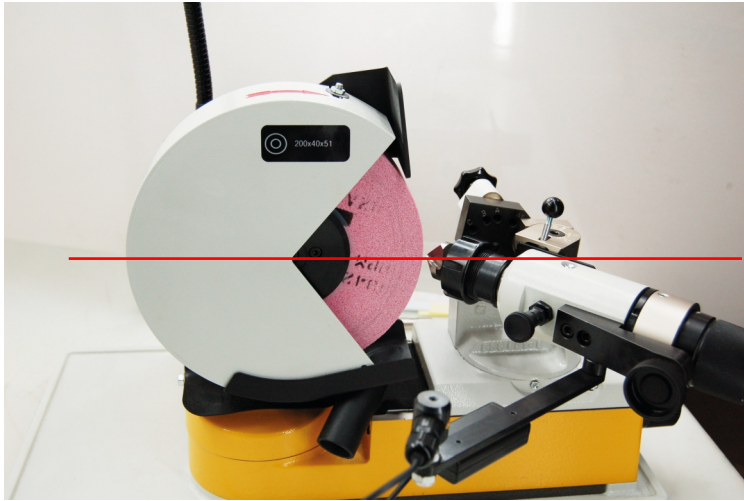
Press the **ON** bottom of the laser and turn the countersink in the collet until one cutting edge is in line to the laser beam. Then fix the collet nut.

Loosen the grid pin and the SZVR snaps back to the start position.





### 23. GRINDING OF COUNTERSINK



Fix the support plate of the **BSG 60** with the star knob screw in boring hole **A**. The stepless clearance angle adjustment has to be turned to scale value **2**.

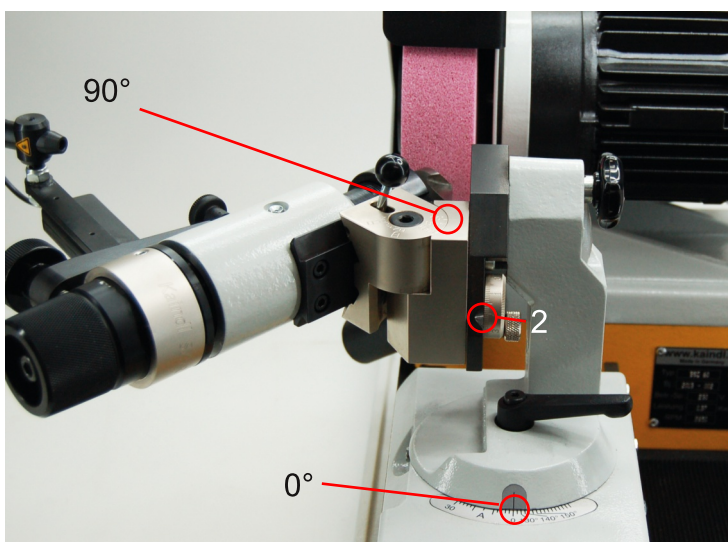
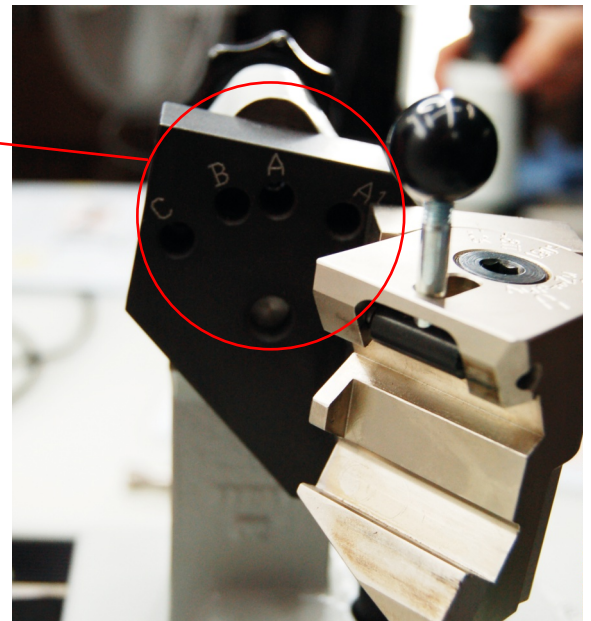
This grants that the virtual line, going through the center of the SZVR, meets the middle of the grinding wheel (For older machines change the clearance angle accordingly).

The prism support fix to **90°**.

Looking points

Slide the **SZVR** on the prism support to the stop. By turning the handwheel of the SZVR to the right and carefully feeding with the prism feed, you can now sharpen the cutting edges of the countersink.

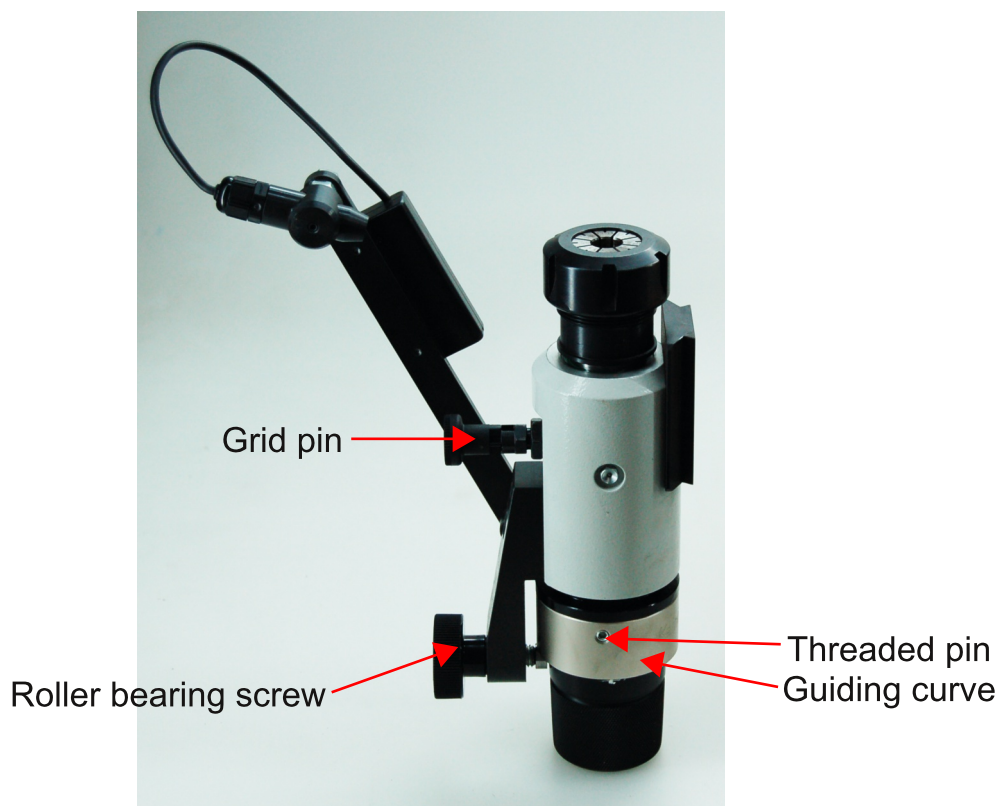
**A freshly dressed and parallel aligned grinding wheel is required.**



## ***24. CHANGE OF GUIDING CURVE FOR CUTTERS***

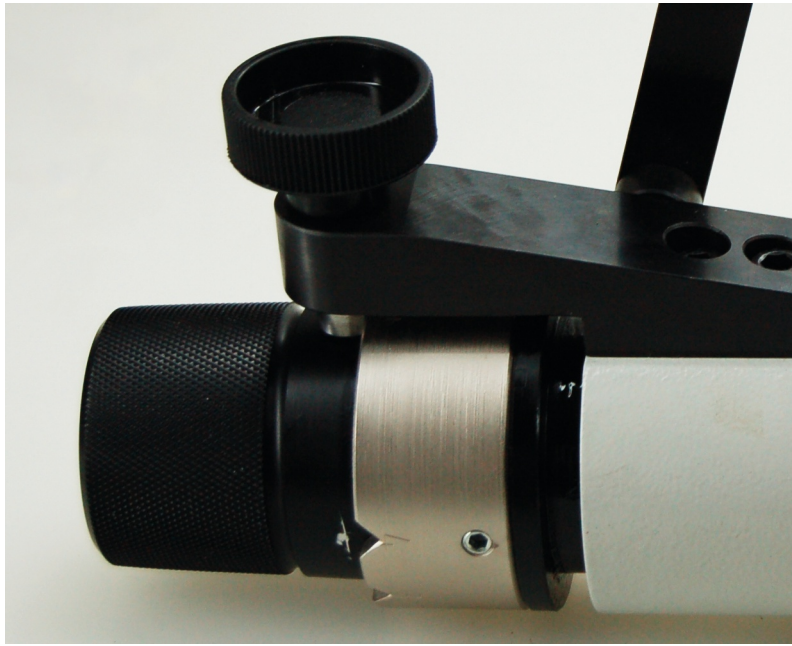
For changing the guiding curve, press the body downwards in order of the SZVR snaps in the grid pin. Now loosen the roller bearing screw and therefore turn back the bearing as far as possible.

Loosen the threaded pin of the guiding pin and remove the guiding curve. By turning the guiding curve, you can sharpen the head for 2, 3 oder 4 flute cutters. Now mount the cutter guiding curve in reverse sequence. Pay attention that the threaded pin is fixed in the corresponding groove.



### ***25. GRINDING OF 2, 3 OR 4 FLUTE CUTTERS***

After changing to the suitable grinding curve, fix the cutter in the corresponding collet and softly fix with the collet nut. Turn the handwheel so that it snaps in the correct groove number. For 3 flute cutters No. 3, for 2 or 4 flute number 4.



When the **SZVR** is snapped in, align one cutting edge of the cutter so that comes in line with the laser beam. (see picture).  
Now fix the collet nut.





### Grinding of the main cutting edge:

Slide the **SZVR** onto prism to the stop and lock with the star knob screw in hole **A**. Adjust the clearance angle on the machine, depending on your cutter between **0,5 and 1,5**. Fix the prism support at **180°** (see picture).

By carefully feeding with the prism feed now sharpen the first side of the cutter. Note the measure on the scale and got back for two turns. Turn the hand wheel to the next suitable lock. Grind now the second side onto the previously noted measure. At the 3 - or 4-cutter you have to grind the other sides accordingly.

### Grinding the clearance angle of the cutter:

For grinding the clearance angle, lock star knob screw in hole **B**. The grinding procedure is identical to the description before.

