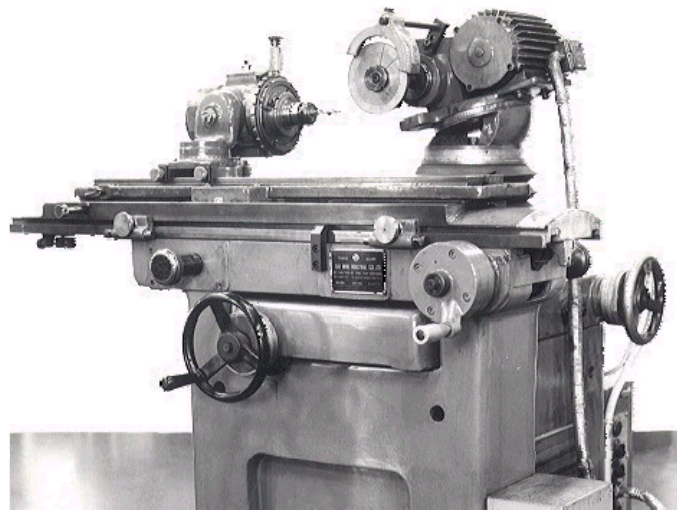


REGRINDING MANUAL FOR SOLID CARBIDE DRILL

MWE / MWS type

April 30, 2009



MITSUBISHI MATERIALS CORPORATION CARBIDE & TOOLS DIVISION

■ Checking conditions of the cutting edge

- Check wear conditions of and damage to the cutting edge.
- If there is serious damage such as fracture on the cutting edge, grind the edge until the damage is all gone.

■ Grinding first relief face

Fig.1

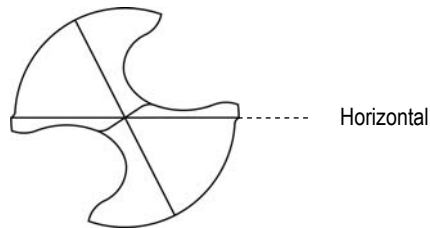


Fig.2

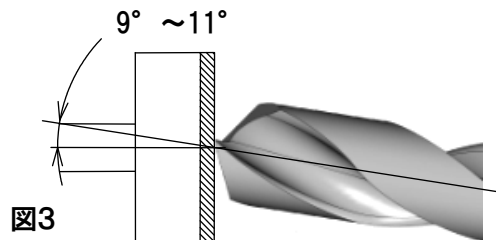
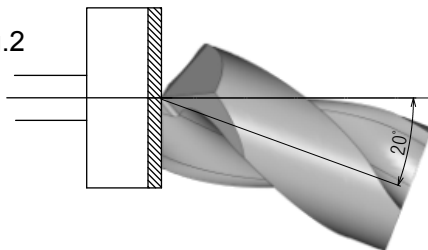
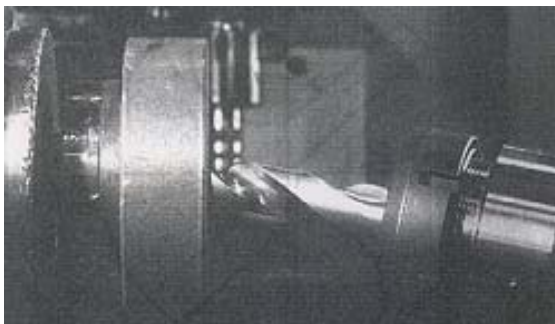


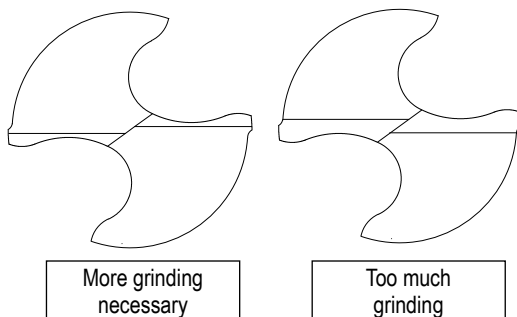
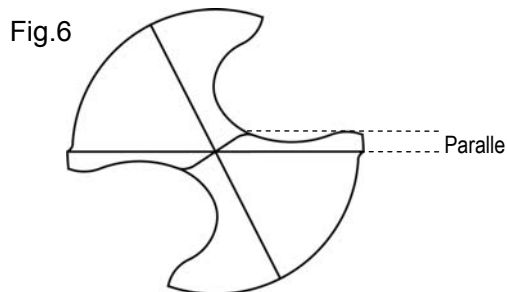
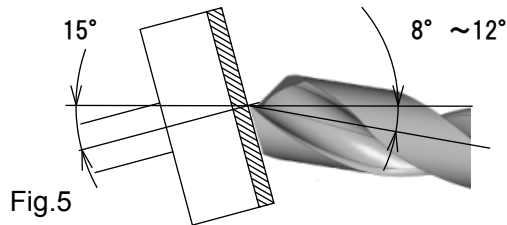
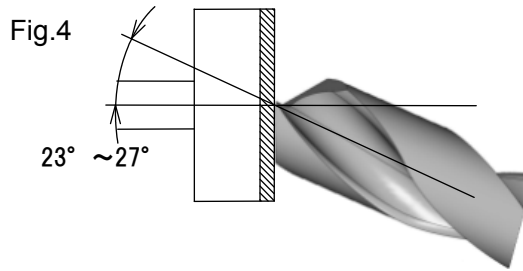
图3



- Install the drill by using collet chuck. As shown in **fig.1**, set the drill phase in order that the corner of center cutting edge and the shoulder of outer peripheral edge become parallel to each other when seen from the top.
- As shown in **fig.2**, rotate the drill (work head) 20° so that the point angle will be 140° .
- As shown in **fig.3**, set inclination angle of the drill (work head) at $9^\circ \sim 11^\circ$. This angle will become first relief angle.
- Finishing first relief face on one side of the cutting edge, index the drill 180° and grind the other side until both sides are at the same position.
*Depth of cut is $0.02 \sim 0.03\text{mm/path}$.
- Finally decrease depth of cut to about 0.01mm , and finish both sides at the position.
- For finishing, repeat oscillation 2 ~ 3 times as slow as possible. This also serves for the purpose of spark-out.
- Grind until there is no wear or fracture left on the cutting edge. (Please pay attention to the damage at the margin, too.)

- Grind until lip height difference (axial runout of front cutting edge) is 0.02mm or less.

■ Grinding second relief face



- After grinding first relief face, grind second relief face.
- As shown in **fig.2** of the previous section, keep rotation angle of the drill (work head) at 20°.
- As shown in **fig.4**, set inclination angle of the drill (work head) at 23°~ 27°. If inclination angle of the drill (work head) cannot be increased to 23°~27°, get the wheel inclined 15° as shown in **fig.5**.

- Grind second relief face, and the ridgeline of first and second relief face will appear.
- As shown in **fig.6**, it is ideal that the ridgeline is parallel to the line connecting the corner of center cutting edge and the shoulder of outer peripheral edge. Adjust the drill phase while grinding.
- Grind until ridgelines on both sides become one line. By this, the center point at the top will be formed. As such, please be careful not to grind too much or too little.

■ Grinding thinning face

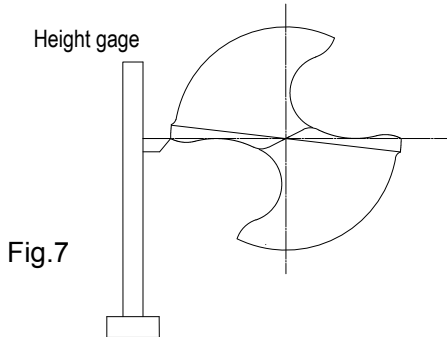


Fig.7

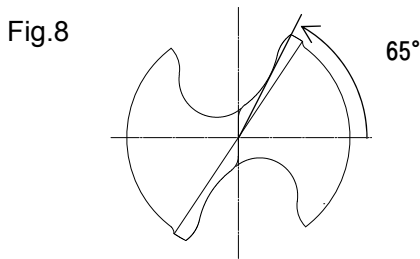


Fig.8

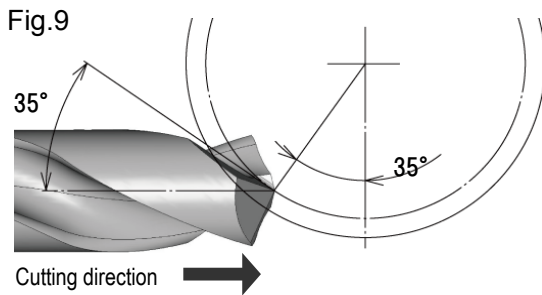


Fig.9

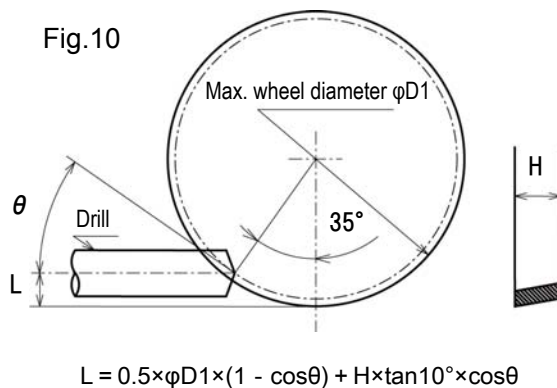
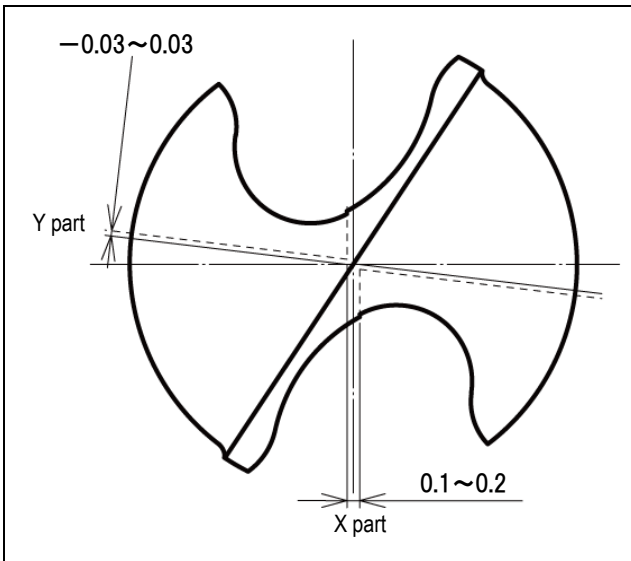


Fig.10

- After grinding second relief face, grind thinning face. Type of the thinning is **X-thinning**.
- First, set the work head horizontal so that the center of the drill will be horizontal. Drill rotation angle is 0°. Set the direction of table oscillation parallel with the center line of the drill.
- As shown in **fig.7**, set the drill phase so that the line connecting the shoulder of both sides will be horizontal by using a device such as height gage.
- Then, as shown in **fig.8**, rotate the drill counter clockwise 65° when seen from the top.
- Set the vertical position of the wheel so that the open angle of the thinning from the drill center will be 35°, as shown in **fig.9**.
- As shown in **fig.10**, set the wheel height so that the center line of the drill will be higher than the bottom of the the wheel edge by "L". (Please refer to the formula in figure 10.)
- As shown in **fig.9**, grind the thinning face by sliding the table to the direction shown by the arrowhead, pressing the drill against the wheel. Grind slowly adjusting the top end of cut by using a device such as a stopper.



- Adjust the wheel position while grinding so that the measurements of the thinning (X part, Y part) will be the same as those of **fig.10**. (Dotted lines show the final positions.)
- (Grinding tip) To make the task easy, grind the two cutting edges alternately, using a mirror to check the configuration while grinding.

■ Honing

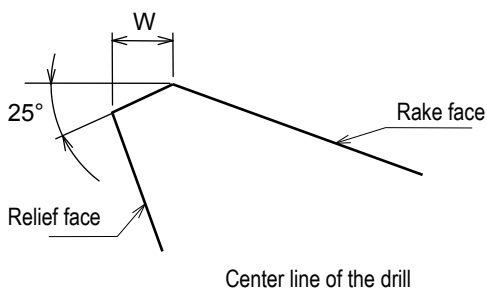
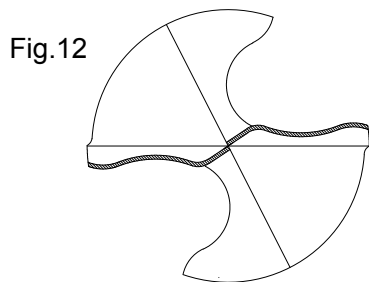
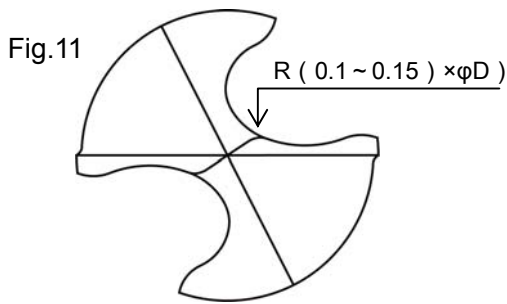


Fig.13

- After grinding thinning face, grind honed edges. This is the last procedure for regrinding.
- First, as shown in **fig.11**, grind the edge at the cross section of the thinning edge and major cutting edge with diamond file until it becomes R-shaped.
- Appropriate R size is approximately $(0.1 \sim 0.15) \times \varnothing D$.
- As shown in **fig.12**, thoroughly grind honed edges on both sides evenly. First, use a diamond file with grain size #400 for honing, and finish by using a hand lap with grain size #1500.
- As shown in **fig.13**, honing angle is 25° .
- Change honing width in accordance with tool diameter (Please refer to **table 1**).

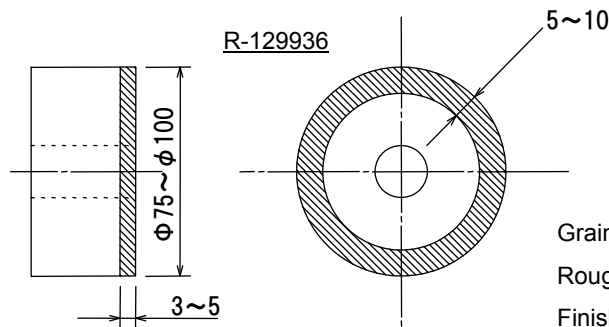
Table.1		Unit (mm)
Tool diameter φD	Honing width W	
$\varphi 5$ less	0.025~0.05	
$\varphi 5$ over $\varphi 10$ less	0.05~0.1	
$\varphi 10$ over $\varphi 20$ less	0.10~0.15	

This is the end of regrinding. Please ascertain that all the following specifications are fulfilled before using WSTAR drill again.

- Lip height difference (axial runout of front cutting edge) < 0.02mm
- There is no damage left on the cutting edge.
- Appropriate honing is applied to the edge.
- There is no grinding burr.

■ Grinding tools for first and second relief face

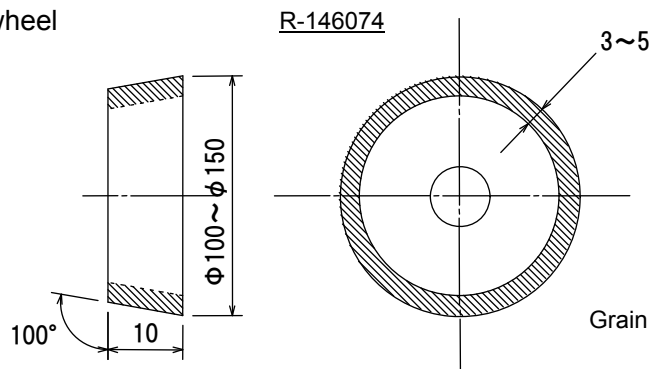
Diamond wheel



Grain size
 Rough grind : #200
 Finish grind : #400 over

■ Grinding tools for thinning face

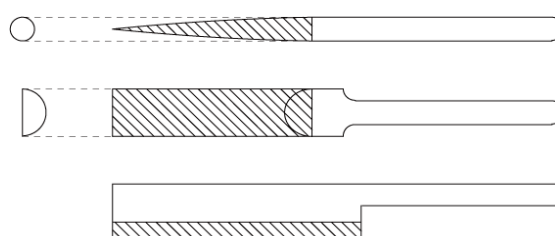
Diamond wheel



Grain size: #400 over

■ Grinding tools for honing

Diamond file



Round file: P-56006C
 Grain size: #600

Half round file: P-68852
 Grain size: #400

Hand hone: 000064
 Grain size: #1500

※ Diamond wheels and diamond files above are available at our divisions and sales offices. To order these products, please contact one of our sales offices or divisions near from you. (Order numbers are underlined in the right column of the table.)