

**NEW**

**FAST EASY**

**NO.2 FOR SECOND RADIAL ANGLE 20°**

**ADJUST SCREW FOR DULL OR SHARP**

**CHECKING STOCK FOR CHECK END MILL PARALLEL WITH HOLDER UNIT**

**NO.3 FOR CUTTING ANGLE 6° GRIND ALL SURFACE OF END MILL 6° TAIL**

**GRINDING STOCK MADE OF CAST IRON**

**NO.1 FOR END MILL FLAT SLOT ANGLE 30°**



**ORIGINAL POINT**

**VEG-13A**

**VEG-25A**

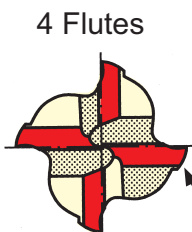
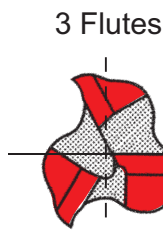
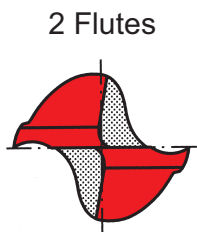
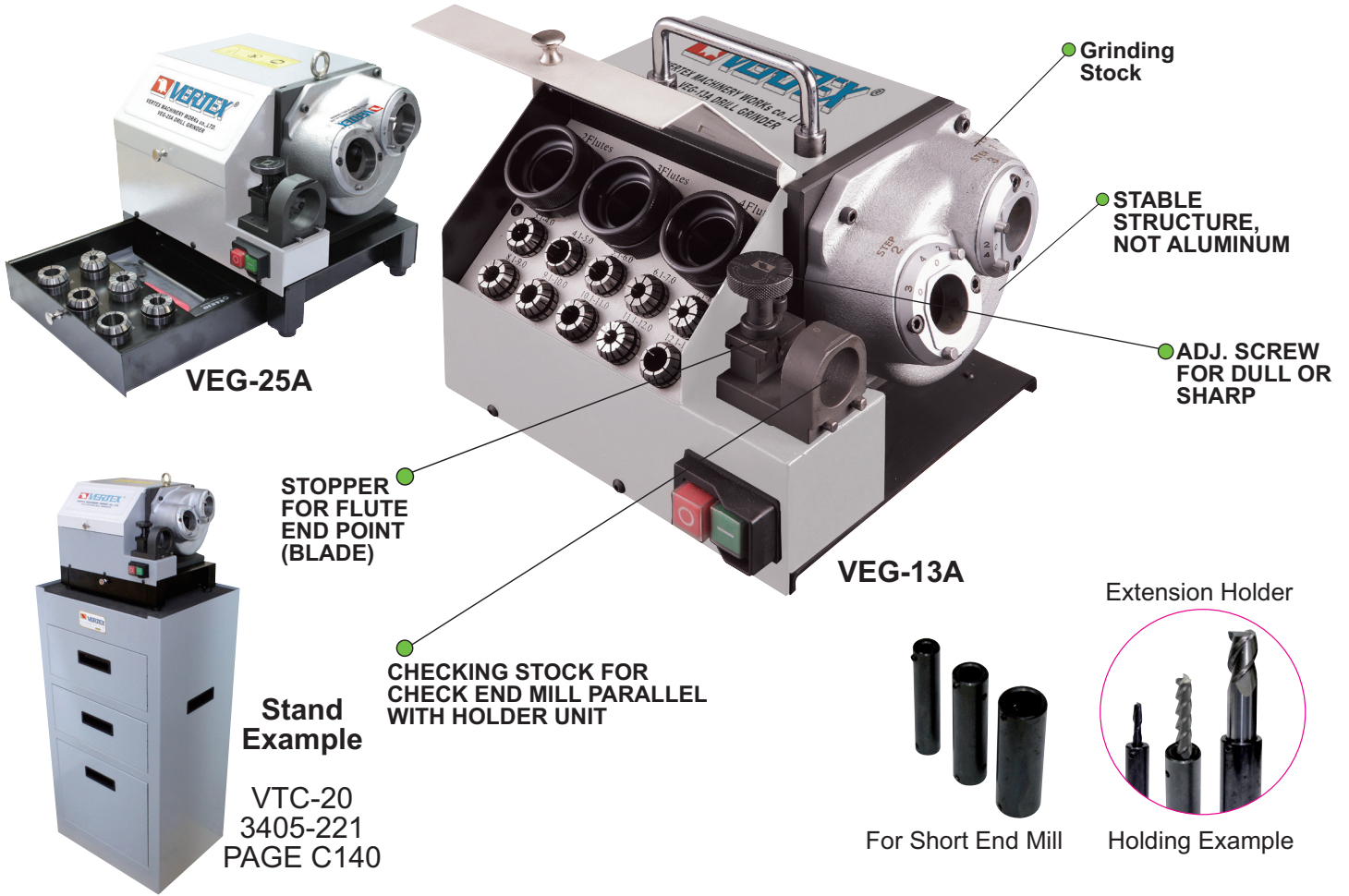
**For End Mill Re-sharpening, 2, 3, 4 Number Flute Precision Efficient, Easy operation, Short processing time, Grinding Diameter from 4-13 mm. Reasonable Price, Fast, Rigid, Simplified Step**

1. High Efficiency, High Quality Grinding Slip, Good Grinding Results
2. Quality Assurance: ±0.02mm, Strong, Reliable, Grinding Stock Won't Bend.
3. Easy Operation, For Urgent Need, Low cost, Save Money

ORDER NO.	VEG-13A	VEG-25A
CAPACITY END MILL DIA.	ø4~ø13mm	ø12~ø25mm
MOTOR	300W	500W
SPEED	4300rpm	4300rpm
POWER	AC-110 or 220 1PH 50/60HZ	AC-110 or 220 1PH 50/60HZ
AXIAL-ANGLE	NO.1 END MILL FLAT SLOT ANGLE 30° NO.2 SECOND RADIAL ANGLE 20° NO.3 CUTTING ANGLE 6°	NO.1 END MILL FLAT SLOT ANGLE 30° NO.2 SECOND RADIAL ANGLE 20° NO.3 CUTTING ANGLE 6°
STANDARD ACCSSORIES	ALLOY STEEL COLLET ER-20 COLLET: Ø4, 5, 6, 7, 8, 9, 10, 11, 12, 13mm 10 pcs/set WRENCH:1PC SDC 300 x1 For ø4~ø6mm SDC 270 x1 For ø7~ø13mm Square Type For 4 Flutes End Mill x 1 Set Hex. Type For 3 Flutes End Mill x 1 Set Parallel Type For 2 Flutes End Mill x 1 Set Ø4-Ø5, Ø6-Ø8, Ø10-Ø12mm EXTENSION HOLDER FOR EACH ONE.	ALLOY STEEL COLLET ER-40 COLLET: Ø12, 16, 18, 20, 22, 25mm 6 pcs/set WRENCH:1PC SDC 150 x1 For ø12~ø25mm CBN 150 x1 For ø12~ø25mm Square Type For 4 Flutes End Mill x 1 Set Hex. Type For 3 Flutes End Mill x 1 Set Parallel Type For 2 Flutes End Mill x 1 Set
PACKING SIZE	320x260x300mm	365x293x345mm
WEIGHT (kg)	17	31
CODE NO.	8001-510A	8001-520A

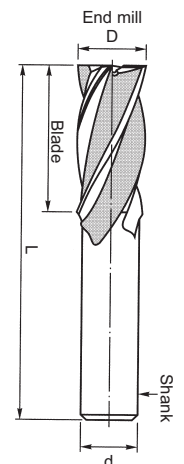
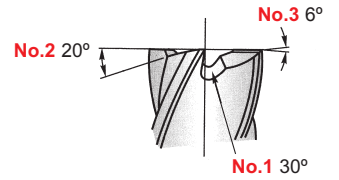
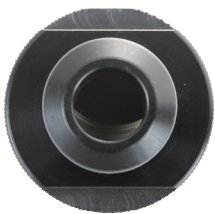


# Precision End Mill Grinder



LONG BLADE FOR ORIGINAL POINT CHECKING

LONG BLADE FOR ORIGINAL POINT CHECKING



## Optional Accessories

※ Each holder unit has mark 2, 3 and 4 on it.

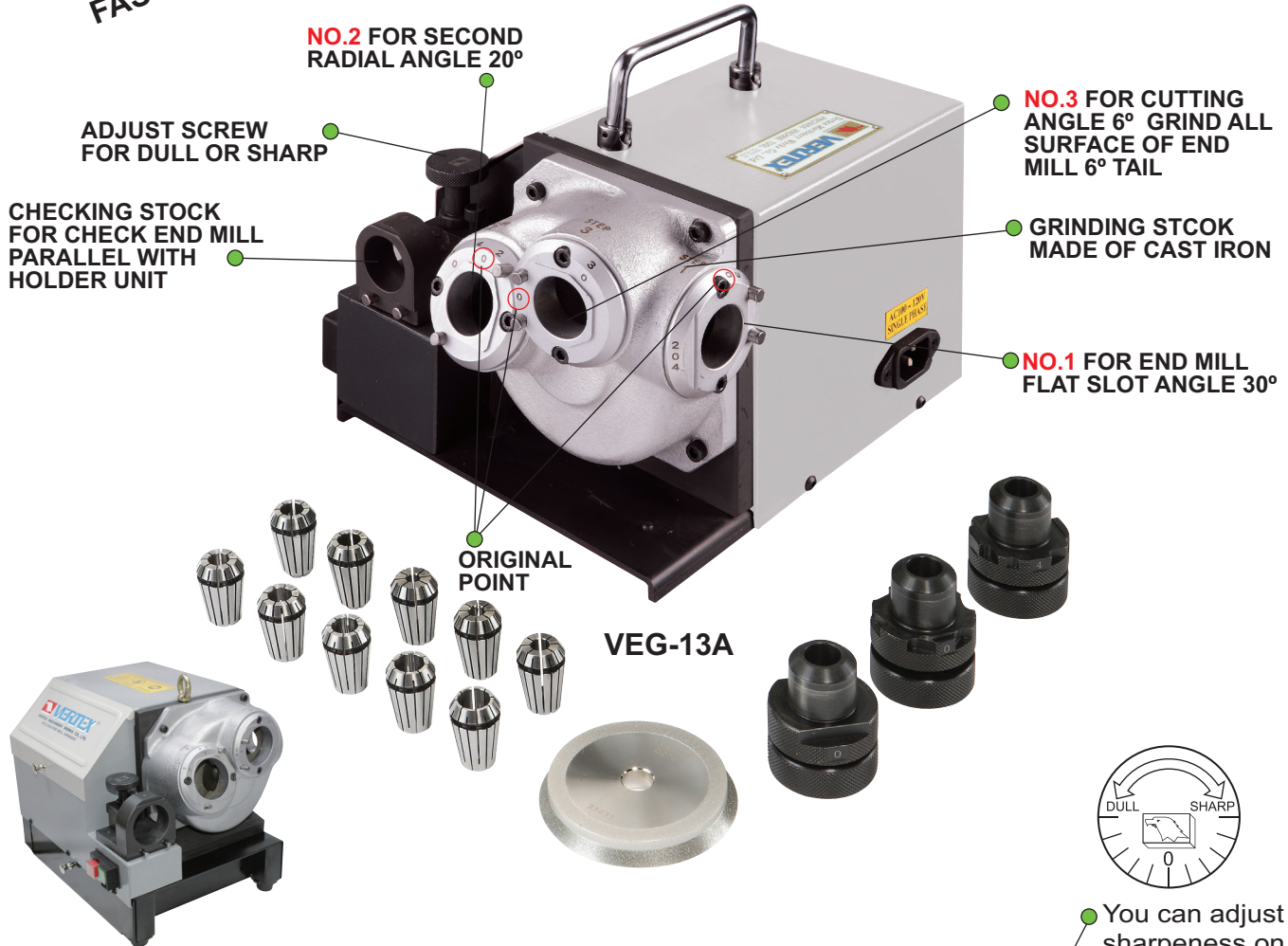
ORDER NO.	Grind Wheel	FOR END MILL MATERIAL	Weight (kg)	CODE NO.
VEG-13BS	CBN 300 x1 For $\phi 4\sim\phi 6$ mm	H.S.S.	0.35	8001-511A
VEG-13BL	CBN 270 x1 For $\phi 7\sim\phi 13$ mm	H.S.S.	0.35	8001-512A
VEG-13DS	SDC 300 x1 For $\phi 4\sim\phi 6$ mm	CARBIDE	0.35	8001-514A
VEG-13DL	SDC 270 x1 For $\phi 7\sim\phi 13$ mm	CARBIDE	0.35	8001-515A
VEG-25BSV	CBN 150 x1 For $\phi 12\sim\phi 25$ mm	H.S.S.		8001-516V
VEG-25DSV	SDC 150 x1 For $\phi 12\sim\phi 25$ mm	CARBIDE		8001-517V





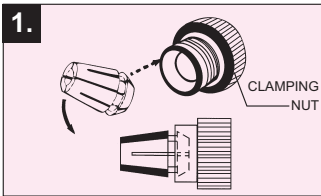
**NEW**

**FAST EASY**

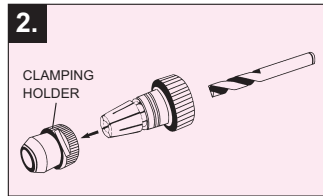


**VEG-25A**

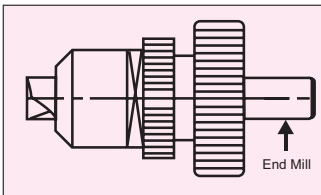
## A. HOW TO INSTALL HOLDER UNIT FOR END MILL



**1.** Please confirm the end mill size and pick up proper collet. Assemble collet into clamping nut by 45 degree. (Before insert the end mill into the clamping holder.)



**2.** Insert the end mill, lock the clamping holder but not tightened, allow the end mill can still move. Insert the end mill, let the end mill blade length 35mm out, (don't tightened the clamping Holder)



HOLDER UNIT

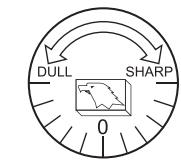
Extension: To attach on the end mill allow you to rotate it when it's length is too short for setting.



HEX. WRENCH



Stopper for flute end point (blade)



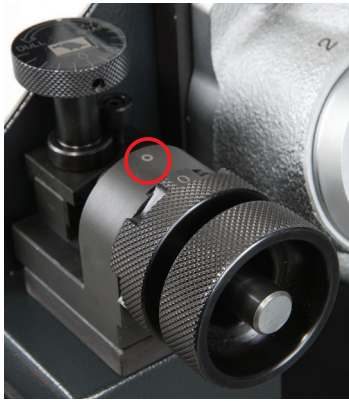
You can adjust the sharpness on the round plate, move toward dull and sharp mark.

PLEASE CHOOSE CORRECT WHEEL FOR GRINDING.  
SDC300 MARK 4-6 mm  
SDC270 MARK 7-13mm



## B. HOW TO SET THE HOLDER UNIT AT THE CHECKING STOCK

(For length and angle setting)



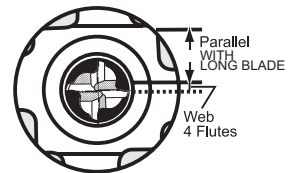
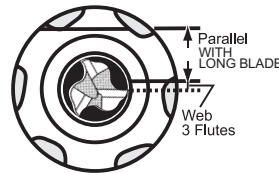
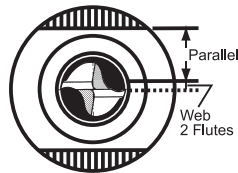
Original Point

- 1) Please make sure the blade of the end mill set in the position like we show below. Hold the end mill but not tight up. Always use 0 to check!  
 ※ You can adjust the sharpness on the round plate, move toward dull and sharp mark.
- 2) Aim at 0 mark and insert holder unit into checking stock. Turn clockwise a little bit, make sure the blade is touching the stock, lock the holder now.  
 ※ When take out the holder unit, please turn the round plate counter clockwise so you can take out smoothly.

**CAUTION:** 1 Make sure the web blade of drill is parallel to the slot of clamping holder.

2 When the end mill blade is broken, the first grind job please turn to the dull side. And grind 2 times in order to get perfect result.

3. While setting, please align the end mill long blade to be parallelized with holder unit slot.



## C. HOW TO GRIND NO1. END MILL FLUTE SLOT ANGLE 30°



- 1) Aim the original point at hole on No1. to grind end mill Flute Slot Angle 30°
- 2) Insert the holder and touch against the No1. surface, until the grind noise is off.

※ Always begin with 0.

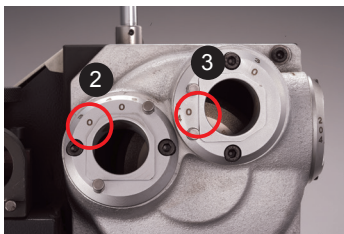
※ While grinding, please turn holder unit right and left a little, against pins.

- 3) (2 Flutes) Please insert and take out turn 180° and repeat step 1~2;  
 (3 Flutes) Please insert and take out turn 120° and repeat step 1~2, two times;  
 (4 Flutes) Please insert and take out turn 90° and repeat step 1~2, three times.

※ While grinding, holder unit shall touch / match most of the grinding stock and move smoothly.

※ Each holder will match each hole's pin, smart design.

## D. HOW TO GRIND END MILL'S NO2. SECOND RIDIAL ANGLE 20° BACK ANGLE



- 1) Insert the Holder unit and aim the original point, touch the No2's surface until the grinding noise is off.

※ Always begin with 0.

※ While grinding, please turn holder unit right and left a little, against pins.

- 2) (2 Flutes) Please insert and take out turn 180° and repeat step 1~2;  
 (3 Flutes) Please insert and take out turn 120° and repeat step 1~2, two times;  
 (4 Flutes) Please insert and take out turn 90° and repeat step 1~2, three times.

## E. HOW TO GRIND END MILL NO3. CUTTING ANGLE 6°



- 1) Place holder unit and aim at hole NO.3, touch the NO.3's surface until the grinding noise is off.

※ Always begin with 0.

※ While grinding, please turn holder unit right and left a little, against pins.

- 2) (2 Flutes) Please insert and take out turn 180° and repeat step 1~2;  
 (3 Flutes) Please insert and take out turn 120° and repeat step 1~2, two times;

- (4 Flutes) Please insert and take out turn 90° and repeat step 1~2, three times.

## F. HOW TO CHANGE GRIND WHEEL



- 1 Use 4mm Hex. Wrench, take out 4 screws of grinding stock, remove the grinding stock.

- 2 Take out the locking screw of the grind wheel and remove the grind wheel.

- 3 Replace the old one with a new grind wheel.

- 4 Lock back the screw, install the grinding stock and lock 3 screws.

※ When grind  $\varnothing 4\sim 6\text{mm}$  please use correct diamond wheel.  
 $\varnothing 7\sim 13\text{mm}$

**CAUTION:** When open, please **un-plug** the power core.