

High tension steel plate  
correspondence re-sharpening  
machine

**ROKEN [S2000]**

# Instruction Manual

- To use this machine safely, before beginning operation, please read this instruction manual thoroughly and gain an ample understanding of the machine. After reading this manual, always store it and use it when there is something you do not understand or when trouble has occurred.



Grinding range	Φ6.5 to Φ10.0
Whetstone	Φ121 CBN #170
Motor	65W
Speed	2850 / 3440 rpm
Power requirement	AC230V 50 / 60 Hz
Weight	8kg
Dimensions	W210 x D225 x H225
Accessories	Φ8.0 Φ8.2 Φ9.0 Φ10.0 Holder Pipe 1pcs per size *Standard specification in Japan
	Holder ring 1pcs
	Hexagon wrench 1pcs

\*The size of holder pipe varies depending on the contract.

\*Φ9.0 holder pipe is suitable for our Super Cutter Φ8.2 and Gekkou KINTAROU Φ8.2.

- Specifications and appearance are subject to change without notice to upgrade safety and improve quality.
- The contents of this manual should be complete, but if you find any unclear points, errors, or omissions, please contact us

Manufacturer & Seller

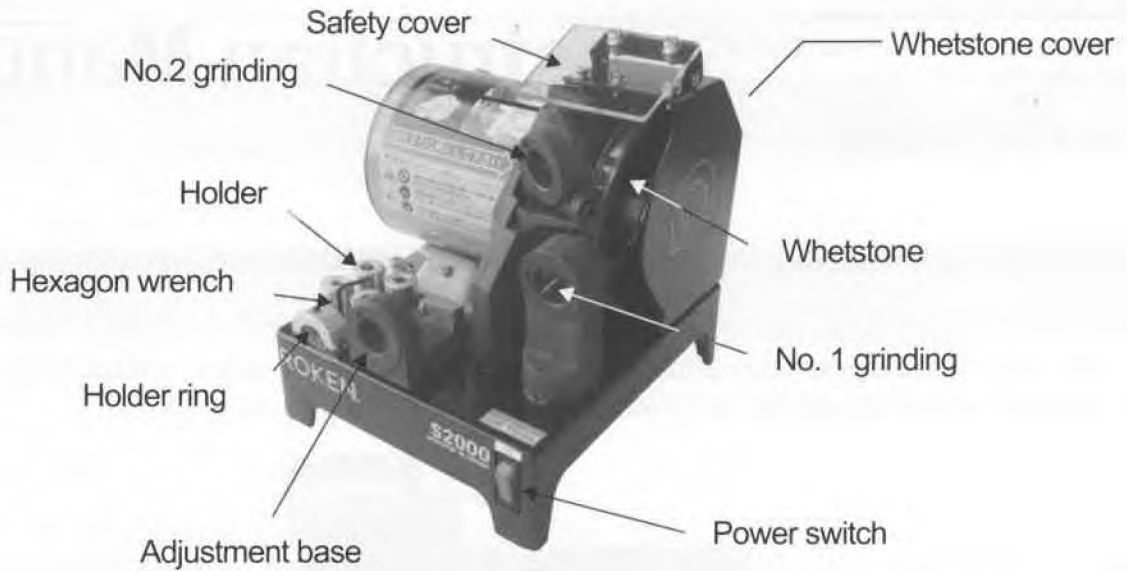
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## 1. Name of each part



## 2. Operation

### Adjustment

Fixing screw



1. Insert a holder of the same diameter as the [spot cutter] to be -sharpened into the hole of the adjustment base as far as it will go.

\* $\Phi 9.0$  holder pipe for Super Cutter  $\Phi 8.2$  and Gekkou KINTAROU  $\Phi 8.2$ .

Push the fixing screws forward.

Stopper



2. Insert the [spot cutter] into the holder until the end of the cutter contacts the "stopper" and then tighten the "fixing screw".

Fix so that the fixing screw does not enter the groove of the [spot cutter].

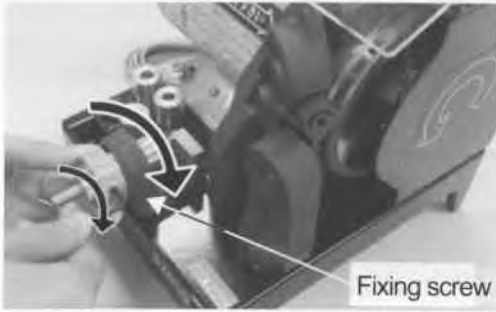
Pin



3. Insert the holder ring.  
Insert the ring so that the adjustment base side "pin" is at the groove of the holder ring.

Don't put a pin in this hole.



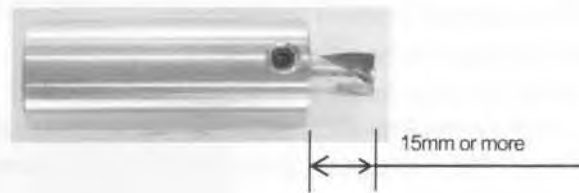


4. Tighten the holder ring fixing screw by turning both the [spot cutter] and holder ring to the right until they stop.



5. This ends adjustment.

It may not be possible to adjust spot cutters which have been repeatedly re-sharpened or spot drills and other drills having a short overall length. In such cases, go to step (3) after inserting the cutter into the holder in reverse and fixing it as shown in the figure.



## No.1 Grinding

■ Set the power switch to the ON position.



1. Insert the work adjusted at the preceding item at No. 1 grinding and engage the [No. 1 grinding side pin] and [holder ring groove].



2. While pushing it gently, repeatedly turn the holder ring to the left and right until it stops. Repeat this operation until there is no more grinding sound.

This ends re-sharpening of one blade.



3. To re-sharpen the other blade, pull out the holder ring midway and turn it 180° so that it is engaged with the groove at the other side.

Re-sharpen the other blade by repeating (1)→(2).

This ends No. 1 grinding.

\* Yume Cutter doesn't need No.2 grinding.

## No. 2 grinding

There are two different No2. grindings between 8.0mm-10.0mm and 6.5mm.

### 8.0mm~10.0mm



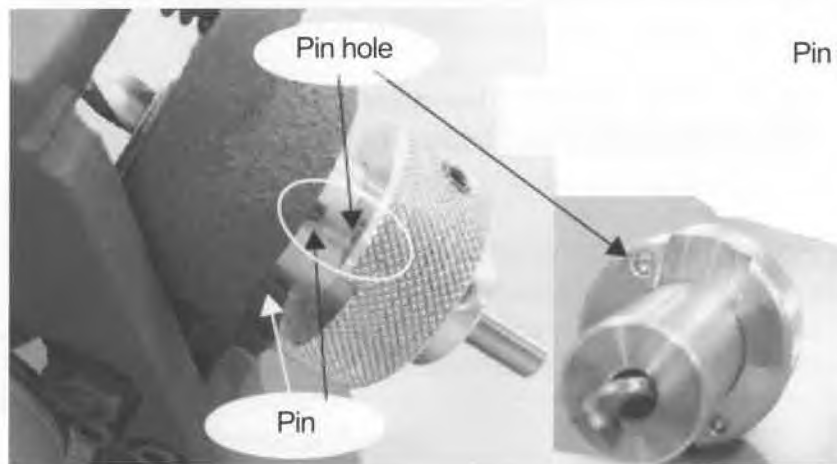
1. Insert the work re-sharpened by No. 1 grinding of item 1 above into No. 2 grinding and engage the [two No. 2 grinding side pins] and the [holder ring groove]. While pushing lightly, tilt to the whetstone side until it This ends re-sharpening of one blade.



2. To re-sharpen the other blade, pull out the holder ring midway and turn it 180° so that it is engaged with the opposite side groove. Re-sharpen the other blade by repeating step (1).

### 6.5mm

No2. grindings for 6.5mm use the pin hole(see picture). It is only for 6.5mm.



1. While pushing lightly, tilt to the whetstone side until it stops. This ends re-sharpening of one blade.

2. To re-sharpen the other blade, pull out the holder ring midway and fit in above pin of No.2 grinding and opposite side pin hole. While pushing lightly, tilt to the whetstone side until it stops.

Please see the instruction on the product too.

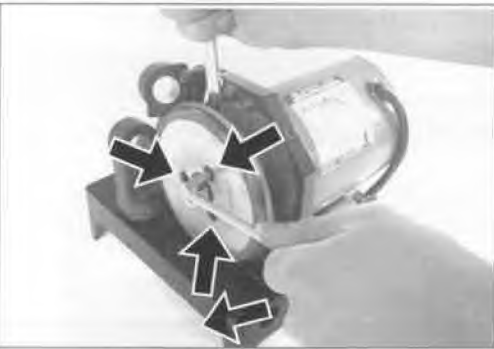
### 3. Whetstone replacement

- Sparking or burning of the tip of the drill indicate that the whetstone has reached the end of its life. Replace the whetstone as described below.
  - Before replacing the whetstone, always set the power switch to the OFF position and disconnect the power cord plug from the receptacle.
  - Use our genuine whetstone.



1. Loosen the 3 screws using a 3mm hexagon wrench and remove the whetstone.

The 3mm hexagon wrench is not supplied with this machine. Procure it separately.



2. Hook a 13mm wrench to the shaft of the motor and fix the shaft and remove the 3 bolts shown in the photograph using a 5mm hexagon wrench.

Never loosen the center nut



3. Remove the old whetstone and install the new whetstone.
4. Hook a 13mm wrench to the motor shaft and fix the shaft and equally tighten the 3 bolts.
5. Return the whetstone cover to its original position.

Please read first

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**SAFETY PRECAUTIONS**



**DANGER**

- Never touch the rotating whetstone or motor rotating parts with your hands or body. There is the danger of serious injury.



**WARNING**

**1. Installation site**

- Install the machine on a level and firm base.
- Do not install it at the following places:
  - Where dust is prevalent and vibrations are generated.
  - Where the machine will be exposed to water, chemicals, etc.
  - Where inflammable gas is generated. The sparks generated during grinding may start a fire or cause an explosion.

**2. Clothing, Protective gear**

- The worker must wear protective goggles. If the drill breaks, there is the danger of serious injury by direct contact with the broken pieces.
- The worker must always wear a protective mask. The dust may be inhaled and damage the throat, lungs, or other respiratory organs.
- Do not wear a necktie, clothing with open cuffs, net gloves, etc. Cover long hair with a hair cover, etc. There is the danger of serious injury by the hair getting caught in the spinning whetstone and rotating parts.

**3. During use**

- Work with your face away from the machine. There is the danger of direct contact with broken pieces and serious injury if the drill should break.
- Do not use this machine in applications other than grinding of drills.
- Insert the power plug after verifying that the power switch on the machine is in the OFF position. If the power plug is inserted while the switch is in the ON position, the whetstone will spin naturally and is dangerous.

**4. After use**

- Pull the power plug from the receptacle after setting the power switch on the machine to the OFF position.
- Do not use your finger or a tool to stop a whetstone being rotated by inertia. There is the danger of serious injury and whetstone or tool damage.

**5. Maintenance and inspection**

- Before replacing or cleaning the whetstone set the machine power switch to the OFF position, verify that the whetstone is not spinning and disconnect the power plug from the receptacle. There is the danger of electric shock and serious injury if the switch is set to ON by mistake and the whetstone is rotated.

**Handling precautions**

- When an abnormal sound, abnormal odor, or other abnormality is detected, stop the machine, set the machine power switch to the OFF position and disconnect the power cord plug from the receptacle and contact your local dealer or us.
- Do not place tools or heavy objects on the power cord.
- Do not use the machine when the power cord is scratched, cracked or otherwise damaged.
- Do not use the standard borazon electrodeposited whetstone of this machine to re-sharpen carbide drills.
- When cleaning the machine, be careful that the machine body does not get wet.
- Periodically remove the grinding powder using a brush or by blowing with compressed air.
- When the machine body gets dirty, wipe the body with a cloth dampened with water and then dry it. Do not use benzene, paint thinner or other organic solvent.
- Do not perform tooting or dressing for the standard borazon whetstone of this machine.