



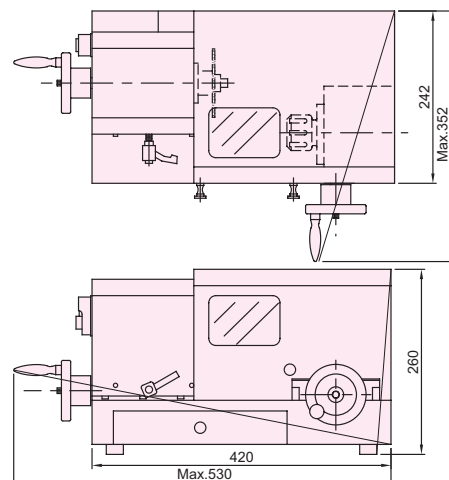
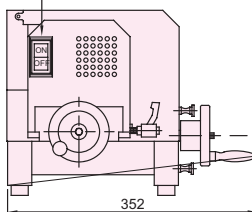
Rods Cutting-Off Unit



THROUGH
HOLE Ø11



SWITCH



Accessories for VEC-20



Flange x2/set



For H.S.S.
Cutting Wheel x 5 Pcs

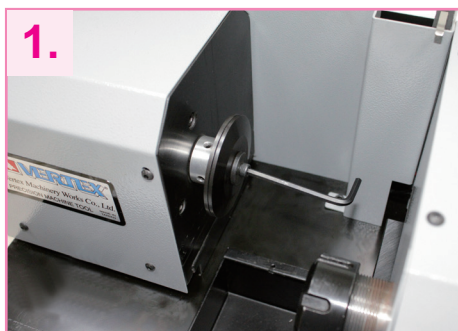


For Carbide
Diamond cutting wheel x1 Pc

STANDARD ACCESSORIES:

ORDER NO.	SIZE	FOR END MILL MATERIAL	WEIGHT (KG)	CODE NO.
VEC-20-C	E60WA Ø105xØd16x1t 4" x 1 mm x 5 pcs/set	H.S.S.	0.10	8001-550
VEC-20-D	SDC Ø110 x Ød16 x 1.36t x 1 pcs	CARBIDE	0.08	8001-551
VEC-20-FLANGE	Ø76 x 5 2 pcs/set		0.24	8001-552

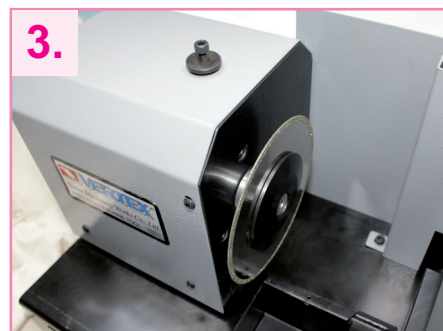
HOW TO CHANGE CUTTING WHEEL.



1. ● Open the case cover,
USE the HEX.WRENCH
to loose the flange's
screw (Wear glove when
operating)



2. ● Take out the 2nd flange
clean the area with wind
blow.



3. ● Take out the 1st screw.
● Take out the 1st flange.
● Remove the cutting
wheel.



4. ● Put 2nd flange back. The Side go in first.
● Put on new cutting wheel.
● Put 1st flange back. The side go in first
● Lock back the screw, close the case cover.
● Turn on the power to test.
● Ready to USE.



5. ● Drawer for storage.
● Accessories for VEC-20

※ LOCK THE CUTTING WHEEL GENTLY
TO PREVENT BREAKAGE



Precision End Mill Grinder

ORDER NO.VEG-13 CODE NO.8001-510



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

1. High Efficiency, High Quality Grinding Slip, Good Grinding Results
2. Quality Assurance: $\pm 0.02\text{mm}$
3. Easy Operation, For Urgent Need, Low cost, Save Money

ORDER NO.	CAPACITY END Mill DIA.	MOTOR	SPEED	POWER	AXIAL-ANGLE	CODE NO.
VEG-13	$\varnothing 4\sim\varnothing 13\text{mm}$	450W	6000rpm	AC- 1100or220 1PH 50/60HZ	NO.1 END MILL FLAT SLOT ANGLE 30° NO.2 SECOND RADIAL ANGLE 20° NO.3 CUTTING ANGLE 6°	8001-510

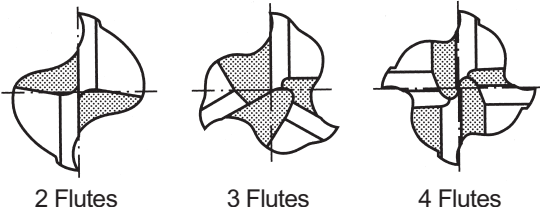
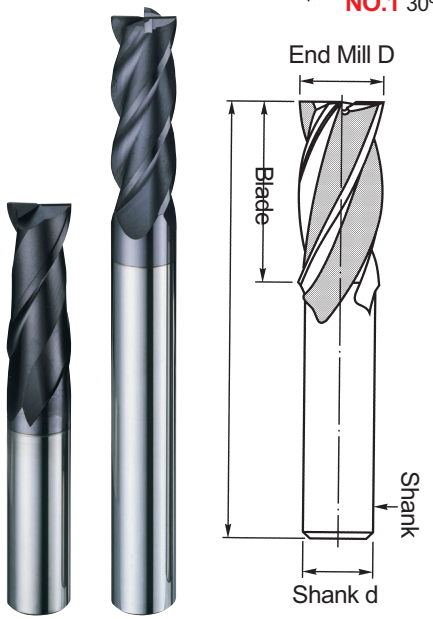
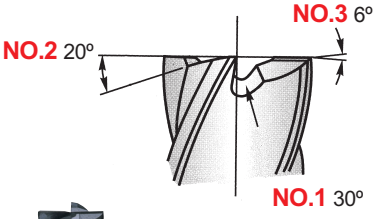
WEIGHT 17kgs **PACKING SIZE** 320x260x300mm

Accessories

Diamond Grinding Wheel: SDC 300 x1 For $\varnothing 4\sim\varnothing 6\text{mm}$
SDC 300 x1 For $\varnothing 8\sim\varnothing 13\text{mm}$
Grind Holder Unit: Square Type For 2 & 4 Flutes End Mill x1 Set
Hex. Type For 3 Flutes End Mill x1 Set
ER-20 Collet: $\varnothing 4,\varnothing 5,\varnothing 6,\varnothing 7,\varnothing 8,\varnothing 9,\varnothing 10,\varnothing 11,\varnothing 12,\varnothing 13\text{ mm}$, 10pcs/set
Wrench: 1pc

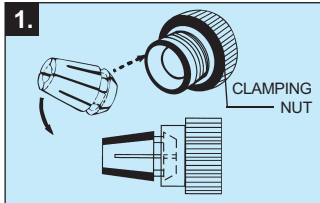
Optional Accessories

ORDER NO.	Grind Wheel	CODE NO.
VEG-13D	CBN 300 x 1 For $\varnothing 4\sim\varnothing 6\text{mm}$	8001-511
VEG-13E	CBN 300 x 1 For $\varnothing 8\sim\varnothing 13\text{mm}$	8001-512
VEG-13T	SBC 200 x For 2 Flute $\varnothing 4\sim\varnothing 13\text{mm}$	8001-513

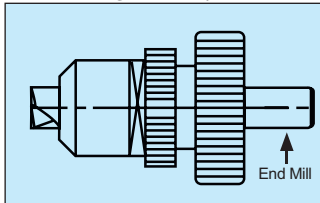




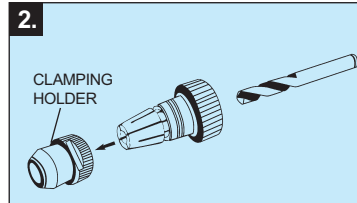
A. HOW TO INSTALL HOLDER UNIT FOR END MILL



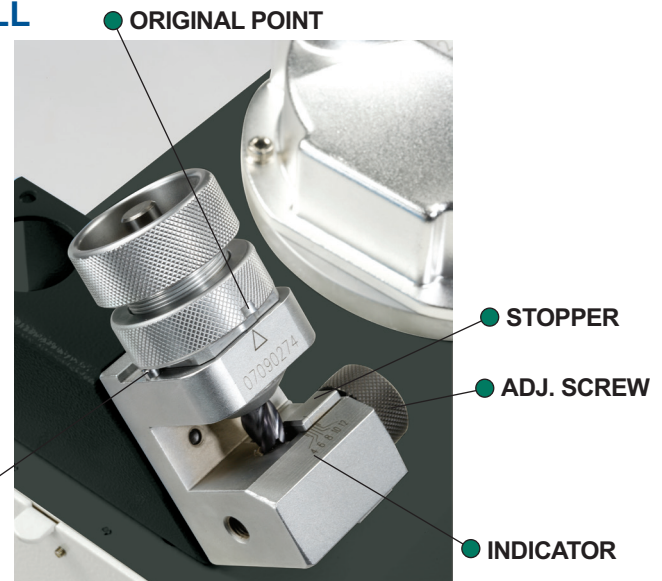
Please confirm the drill size and pick up proper collet. Assemble collet into clamping nut by 45 degree. (Before insert the drill into the clamping holder.)



HOLDER UNIT



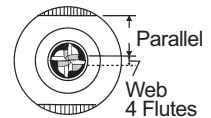
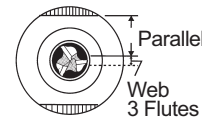
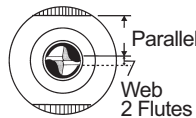
Insert the drill, lock the clamping holder but not tightened, allow the drill can still move. Insert the end mill, lock the clamping Holder, let the end mill blade length 35mm out, (don't tightened the clamping Holder)



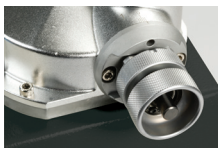
B. HOW TO SET THE HOLDER UNIT AT THE CHECKING STOCK (For length and Angle Setting)



- 1 Turn the Adjust screw to the Indicator for the end mill size.
- 2 Place Clamping unit and aim the original point at the checking stock and insert stopper until the end mill is touching the bottom.
- 3 Turn the Holder unit clockwise, and touch against PIN, turn the end mill clockwise touch against stopper.
- 4 Tighten the holder unit and take out all unit. And make sure the Holder unit tightened.



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



- 1 Aim the original point at hole on No.1 to grind end mill Flute Slot Angle 30°
- 2 Insert the holder and touch against the No.1 surface, until the grind noise is off.
- 3 Take out turn 180° and continue to grind next Flute, repeat these step by turning 90° and insert.

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



- 1 Insert the Holder unit and aim the original point at screw, touch the No2's surface until the grinding noise is off.
- 2 Take out and insert, repeat these steps if you want to grind 4 Flutes, you must complete 4 times grind process.
- 3 Movable Stock, 2T is for 2 Flute, 3T is for 3 Flute, 4T is for 4 Flute, please loosen 2 screws when grind different Flutes (choice from 2,3,4 Flutes).
When grinding, please note:
2 Flutes, turn all the way down to the end of the screw track until the 2T mark is match with screw.
3 Flutes, turn until the 3T mark is match with screw

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



- 1 Place the Holder unit aim the original point at screw and insert into No3.
- 2 Touch against the No3. surface until the grinding noise is off
- 3 Now move the Holder unit right and left.
- 4 Repeat these steps to complete 4 Flutes grind process.

F. HOW TO CHANGE GRIND WHEEL



- 1 Use 4mm Hex. Wrench, take out 3 screws of grinding stock, remove the grinding stock.
- 2 Take out the locking 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.