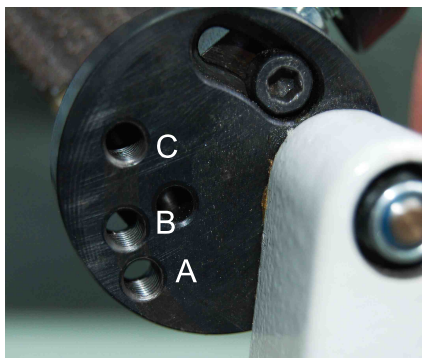
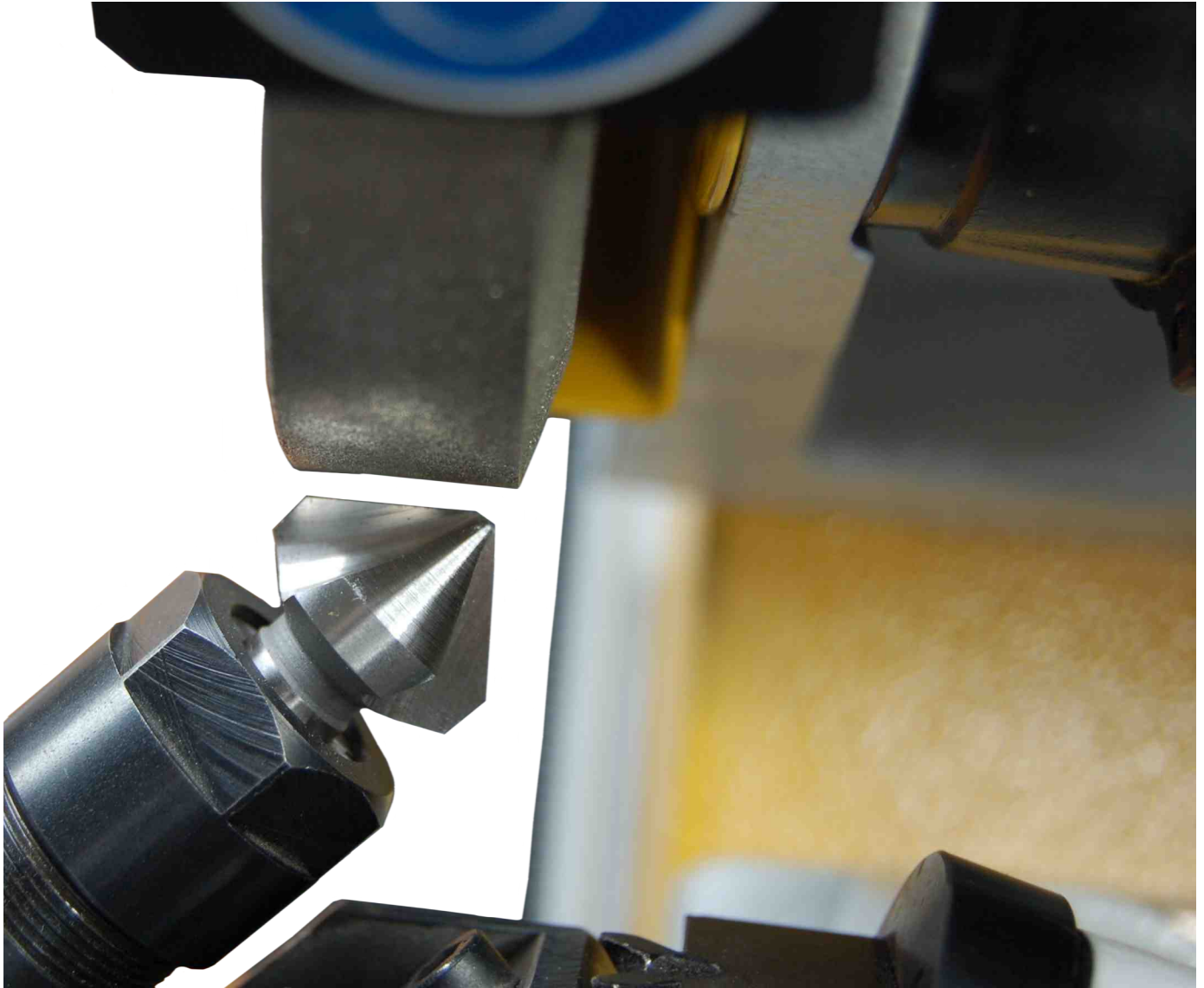


### 18. COUNTERSINK SHARPENING DEVICE SVR 20



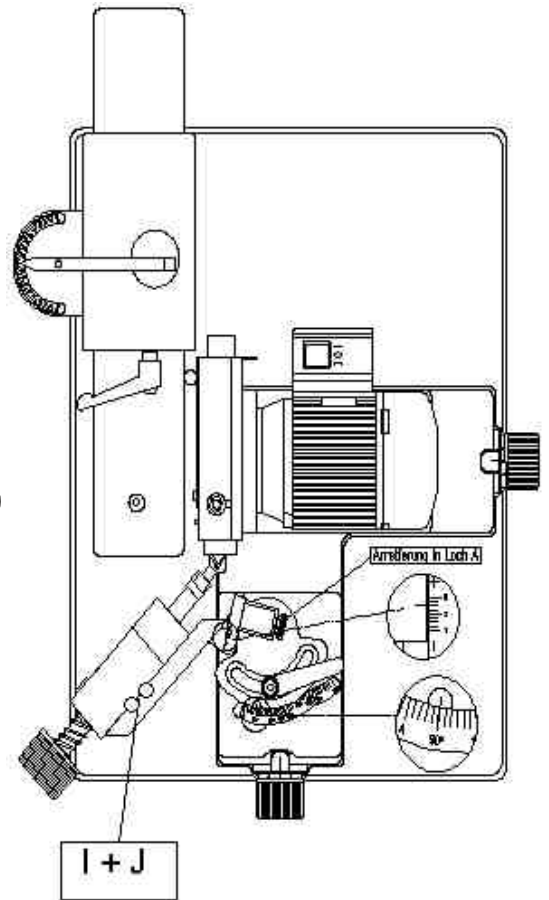
Fix in hole A

### 19. COUNTERSINK SHARPENING DEVICE SVR 20

For sharpening countersinks with the BSM 20 / SZ, this special accessory type SVR 20 is required. Arrest the turning mechanism on the BSM 20 drill sharpening machine in hole **A** (see picture on page 26). Fix the stepless clearance angle adjustment on the third graduation mark from above (see picture). The prism rest fix at **90°** (see draw).

Place your countersink inside the collets of the SVR 20 and align one cutting edge parallel to the line on the SVR 20, below the collets nut (see also drawing E). With the screw **I** and **J** (see the drawing on the right) you can adjust the distance between the SVR 20 and the grinding wheel. For bigger countersinks the SVR is positioned backwards and can only fixed with one screw on the adaptor plate. Slide the SVR 20 on the turning mechanism to the stop dog and fix with the clamping screw.

By turning the hand wheel of the SVR 20 clockwise and carefully moving forward with the prism feed on the BSM 20 you can sharpen the flutes of your countersink.



It is absolutely recommended grinding with a clean and parallel dressed grinding wheel.

For one-flute countersinks you have to mount the special cam (Art No. 10605) for adjusting see drawing **F**.

**ATTENTION!** When you align the tip of countersink parallel to the graduation line on the SVR 20, take care that the bigger hole is on this side.

