# 18. SPECIAL ACCESSORY

COUNTERSINK SHARPENING DEVICE SVR 31

For sharpening countersinks, you need a special accessory to the BSG 60 the countersink sharpening device SVR 31. First fix the support plate in boring **A**. Then adjust the stepless clearance angle adjustment to No. **2**.

This grants that the imagined line goes trough the center of the clamping prism and meets the center of the grinding wheel. (For older models you may have to change the clearance angle). The prism support

Picture 1

place to **90°**. Now put your countersink in the collet of the SVR 31 and align one cutting edge as shown in picture 2, page 17 to the graduation line.
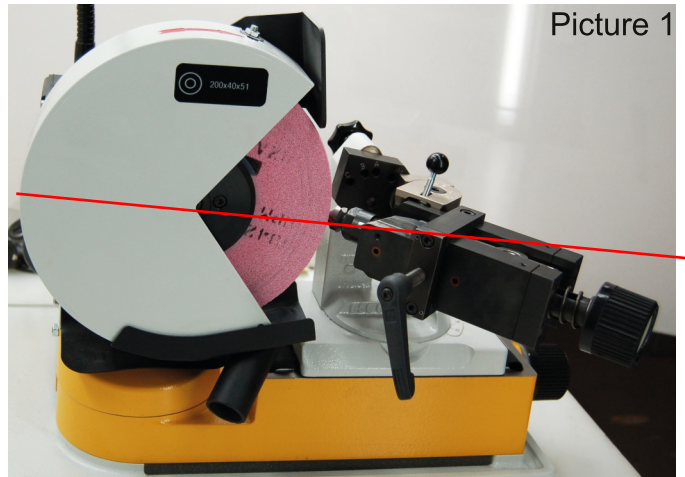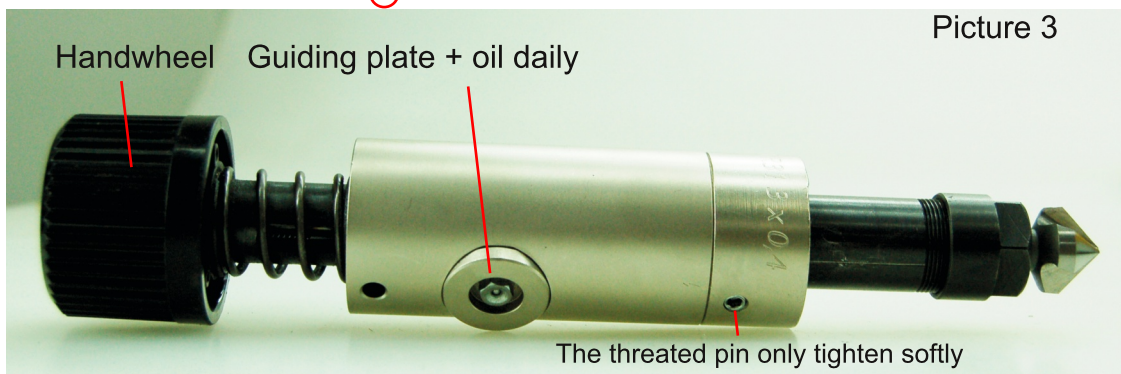

Picture 2
90°
0°
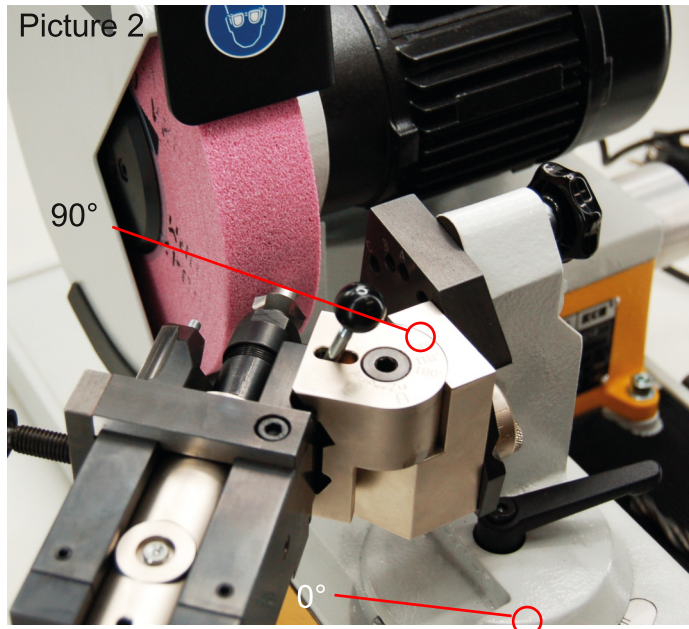
Move the prism to the stop on the prism support and fix the locking pin. Then fix the SVR 31 with the guinding plate (picture 3) on top in the prism. Prism range **20 - 40 mm**. By turning the handwheel of your SVR 31 clock-wise and carefully moving the prism feed, sharpen the cutting edges of your countersink.

A clean and parallel dressed grinding wheel is recommended.

Picture 3
Handwheel   Guiding plate + oil daily
The threated pin only tighten softly

19. ALIGNMENT OF THE COUNTERSINK

SVR 31 Basic adjustment: Cam for countersinks with 3 cutters and 10 mm collet + nut.

For cross countersinks you need a one step cam (special accessory).
The adjustment is made as shown on picture 1.

<u>ATTENSION:</u> Adjustment of the countersink hole on center of back flush with the alignment mark.

Alignment of cross-countersinks
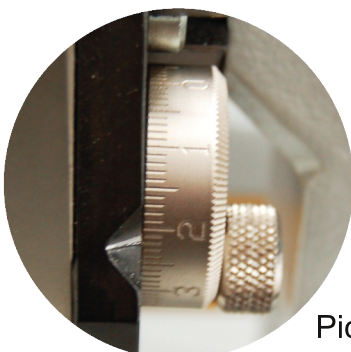
wrong   right
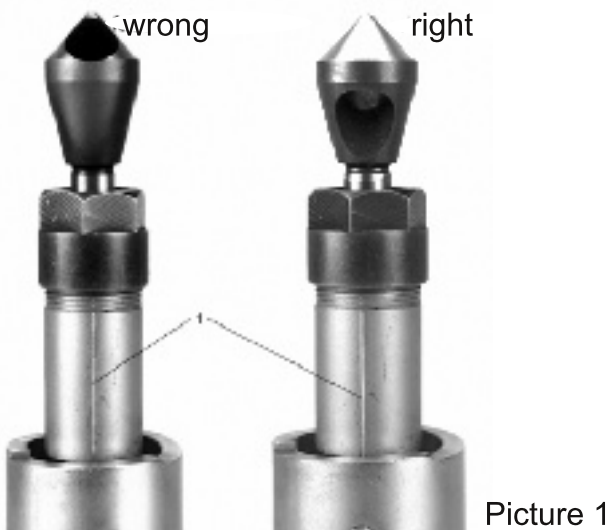
Alignment countersinks

Picture 1

Picture 2

OPTIONALLY AVAILABLE

Cam for
cross-countersinks

Collet
6/8/12 mm

Adjust clearance angle to mark No. **2**

Screw star knob screw in hole No. **A**

Picture 3

Picture 4

20. CHANGE OF THE CAM OF THE SVR 31

In case you have to change the cam of your SVR 31 loosen the threated pin with an allen key SW 3,0 (see picture).
Place the SVR 31 with the handwheel on a flat surface.
By hand, press down the body (against spring tension). With your other hand, draw the cam **beside the roller bearing**, upside out of the body.

The inset of the cam is done reversely.

Please pay attention that threadet pin is mounted on the provided notch.

Draw the cam beside the roll bearing upside out

threaded pin

receiving body