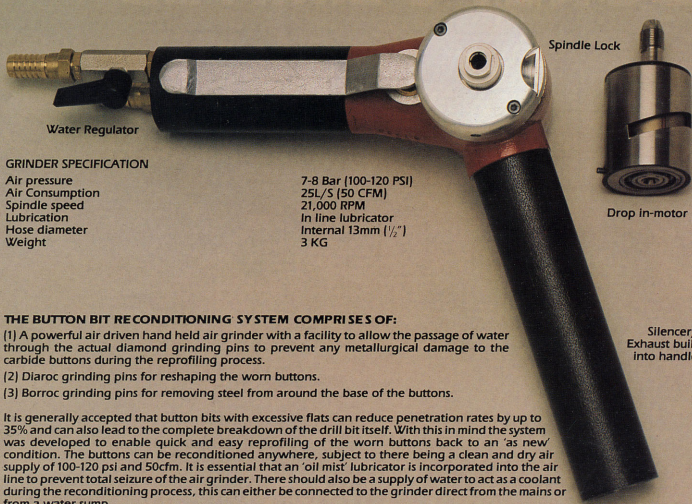


AIR GRINDER WITH DROP IN MOTOR



Water Regulator

Spindle Lock

Drop in-motor

Silencer/
Exhaust built
into handle

GRINDER SPECIFICATION

Air pressure
Air Consumption
Spindle speed
Lubrication
Hose diameter
Weight

7-8 Bar (100-120 PSI)
25L/S (50 CFM)
21,000 RPM
In line lubricator
Internal 13mm (1/2")
3 KG

THE BUTTON BIT RECONDITIONING SYSTEM COMPRISES OF:

- (1) A powerful air driven hand held air grinder with a facility to allow the passage of water through the actual diamond grinding pins to prevent any metallurgical damage to the carbide buttons during the reprofiling process.
- (2) Diaroc grinding pins for reshaping the worn buttons.
- (3) Borroc grinding pins for removing steel from around the base of the buttons.

It is generally accepted that button bits with excessive flats can reduce penetration rates by up to 35% and can also lead to the complete breakdown of the drill bit itself. With this in mind the system was developed to enable quick and easy reprofiling of the worn buttons back to an 'as new' condition. The buttons can be reconditioned anywhere, subject to there being a clean and dry air supply of 100-120 psi and 50cfm. It is essential that an 'oil mist' lubricator is incorporated into the air line to prevent total seizure of the air grinder. There should also be a supply of water to act as a coolant during the reconditioning process, this can either be connected to the grinder direct from the mains or from a water sump.

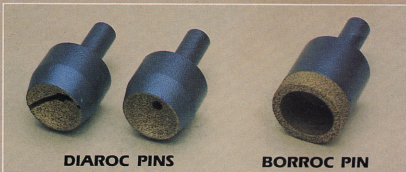
USE OF GRINDING TOOLS

For optimum performance it is recommended that reprofiling should occur when the flats on the buttons are about one third of the buttons diameter and always before the flats reach one half of the buttons diameter. Select the correct size diaroc pin and ensure that the water flushing is operational. Place the diaroc pin on top of the worn button and proceed with the reprofiling using a circular and rocking motion. Do not apply too much pressure as this will cause the grinding pin to 'load' and reduce the grinding rate.

If the diaroc pin catches on the steel body of the bit, replace it with correct size borroc pin and remove the steel from around the base of the button.

DO NOT ROCK THE GRINDER WHEN USING A BORROC PIN.

To expose the diamond in a used or 'loaded' pin, lightly clean the grinding face with an abrasive dressing stick or a piece of old grinding wheel.



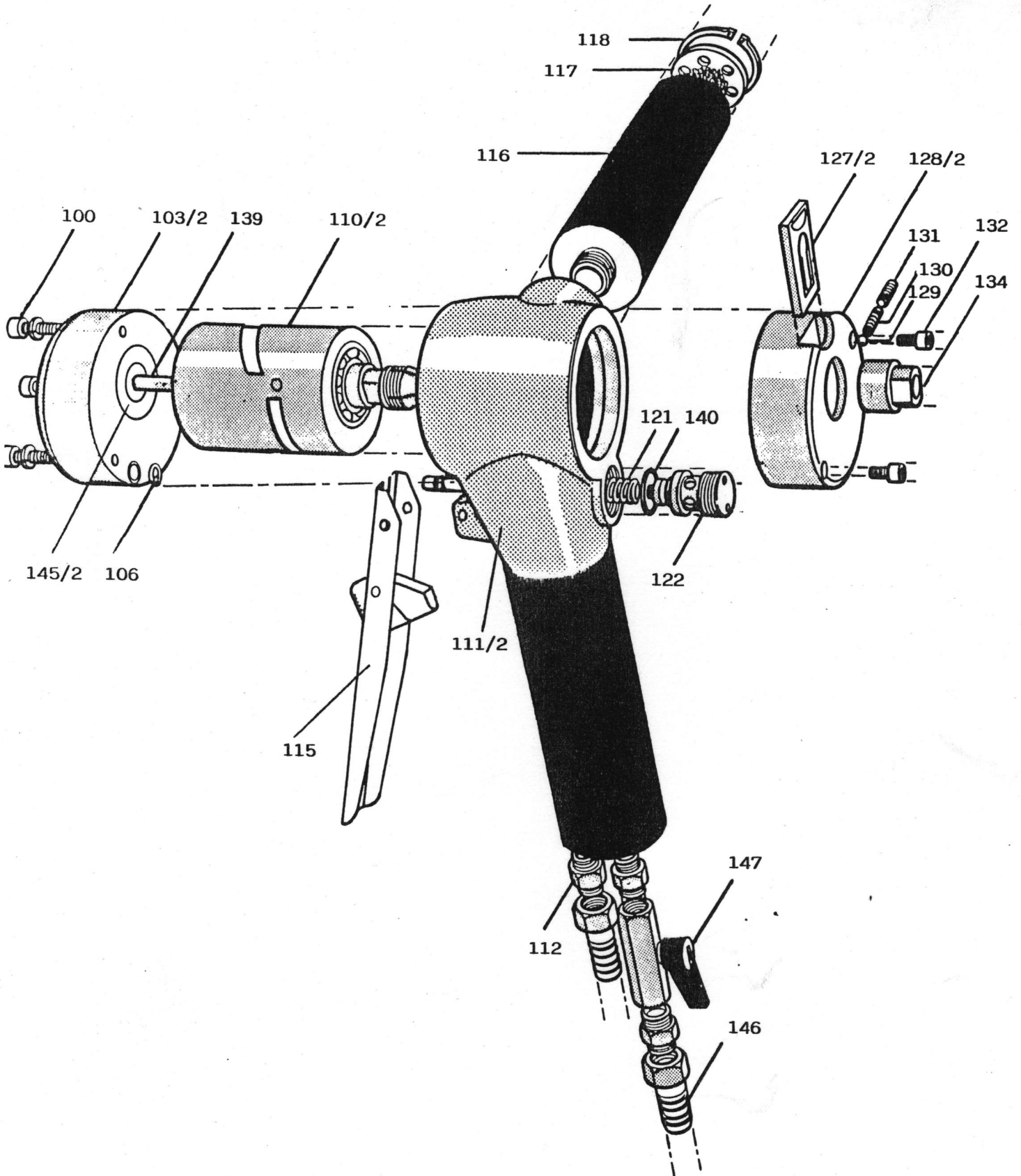
DIAROC PINS

BORROC PIN

| | 6 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 16 |
|-------------|---|---|---|----|----|----|----|----|----|
| DIAROC PINS | | | | | | | | | |
| BORROC PINS | | | | | | | | | |

Larger diameter pins are available upon request

MK11 AIR GRINDER



BUTTON BIT RECONDITIONING SYSTEM



REGULAR USE OF THE SYSTEM

- Extends the life of your Button bits
- Ensures maximum Penetration rates
- Reduces breakdown on bits
- Results in high savings on overall drilling costs



2009/08/06



2009/08/06



2009/08/06