35° OIL RELEASE ANGLE

.005/.010 X 70°
(.13/.25) HAND CHAMFER

SECONDARY RELIEF BLENDS
WITH PRIMARY CLEARANCE

DUBOFF Φ 35°

DIAMETER

POINT LOCATION = DIA/4

35°±1°

35°±1°

0° OUTER ANGLE

NOSEGRRIND DETAIL

0°–35°–35°

Φ 16° PRIMARY

R1 RELIEF

1. ALL DIMENSIONS NOT SHOWN SHALL BE MANUFACTURERS STANDARDS.
2. ALL DIM'S IN [ ] ARE MILLIMETERS.
3. FOR NOSEGRRIND SHOWN USE ELDO MODEL 'B' SHARPENING FIXTURE,
4. HAND CHAMFER AS SHOWN.
5. DIAMETER CANNOT BE MEASURED DIRECTLY DUE TO R1 RELIEF.

MANUFACTURING TOLERANCES

<table>
<thead>
<tr>
<th>DRILL DIA.</th>
<th>ANGLES</th>
<th>POINT LOC</th>
</tr>
</thead>
<tbody>
<tr>
<td>UP TO .375</td>
<td>±1°</td>
<td>±.002</td>
</tr>
<tr>
<td>.375 AND OVER</td>
<td>±2°</td>
<td>±.005</td>
</tr>
</tbody>
</table>

COPPER GRIND

GUNDRIIL

0/35/35