20° INNER ANGLE
30° OUTER ANGLE
.071 DIA. AND OVER
USE 20° DUBOFF
UP TO .070 DIA.
USE 25° DUBOFF

HAND CHAMFER ARC
CAM RELIEF BLENDS WITH PRIMARY CLEARANCE
.005 X 70° .010

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&quot;</td>
<td>±.002</td>
</tr>
<tr>
<td>.375 AND OVER</td>
<td>±2&quot;</td>
<td>±.005</td>
</tr>
</tbody>
</table>

ADVANCE = .235 X DIAMETER

NOTES:
1. ALL DIM'S NOT SHOWN ARE MANUFACTURERS STANDARDS.

2. WHEN ELDORADO MODEL 'B' OR 'C' SHARPENING FIXTURE IS USED THE ABOVE NOSEGRIIND IS OBTAINED AS FOLLOWS:
   A) SELECT SINE BLOCK AND CAM FROM ABOVE TABLE
   B) GRIND 30° OUTER ANGLE; ROTATE CLOCKWISE APPROX. 150° TO REACH POINT LOCATION.
   C) GRIND 20° INNER ANGLE USING CALCULATED ADVANCE.
   D) GRIND DUBOFF USING CAM 'O' WITHIN LIMITS OF CAM POCKET.
   E) REMOVE GUNDRIILL; HAND GRIND CHAMFER AS SHOWN.

3. REFER TO FORMS 23, 792 & 521C(TABLE B-1) FOR DETAILS.

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