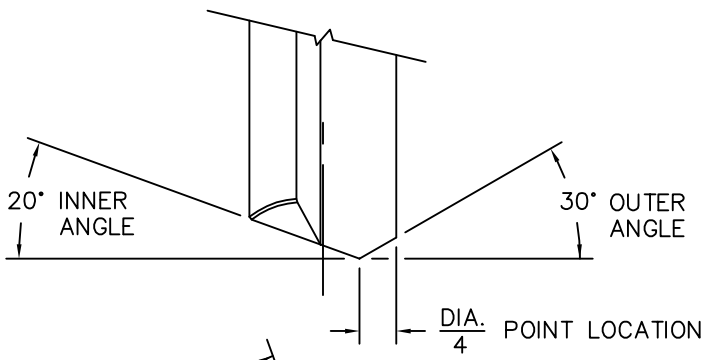
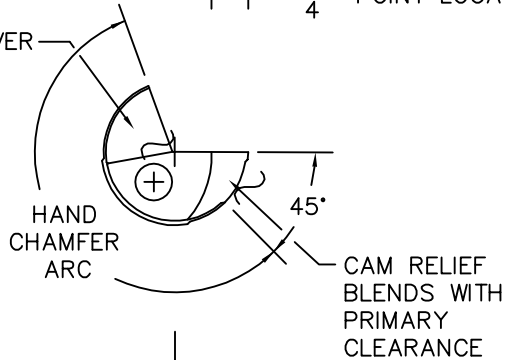


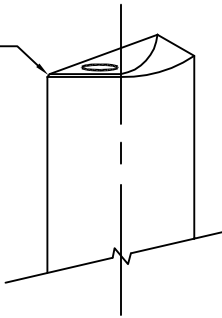
DESCRIPTION OF REVISION	BY	CHK	DATE	REV. LTR.
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.071 DIA. AND OVER  
USE 20° DUBOFF  
UP TO .070 DIA.  
USE 25° DUBOFF



$\frac{.005}{.010} \times 70^\circ$



DRILL DIA.	CAM #	SINE BLOCK (PRIMARY CLEARANCE ANGLE)
UP TO .1562	1	NO SINE BLOCK (16°)
.1563 - .3594	2	UP TO .1719 DIA.
.3595 - .5469	3	USE 12° SINE BLOCK FOR .1720 DIA. AND UP
.5470 - .7500	4	
.7501 - .9687	5	
.9688 - 1.4844	6	
1.4845 - 2.0000	7	

ADVANCE = .235 X DIAMETER

NOTES:

- ALL DIM'S NOT SHOWN ARE MANUFACTURERS STANDARDS.
- WHEN ELDORADO MODEL 'B' OR 'C' SHARPENING FIXTURE IS USED THE ABOVE NOSEGRIND IS OBTAINED AS FOLLOWS:
  - SELECT SINE BLOCK AND CAM FROM ABOVE TABLE  
CALCULATE ADVANCE USING ABOVE FORMULA.
  - GRIND 30° OUTER ANGLE; ROTATE CLOCKWISE APPROX. 150° TO REACH POINT LOCATION.
  - GRIND 20° INNER ANGLE USING CALCULATED ADVANCE.
  - GRIND DUBOFF USING CAM 'O' WITHIN LIMITS OF CAM POCKET.
  - REMOVE GUNDRILL; HAND GRIND CHAMFER AS SHOWN.
- REFER TO FORMS 23, 792 & 521C(TABLE B-1) FOR DETAILS.

MANUFACTURING TOLERANCES		
DRILL DIA.	ANGLES	POINT LOC.
UP TO .375	±1°	±.002
.375 AND OVER	±2°	±.005

THIS IS A PROPRIETARY DESIGN OF ELDORADO. REPRODUCTION, MANUFACTURE OR USE OF ANY ASSEMBLY, SUBASSEMBLY, OR PART INDICATED HEREIN OR THE USE OF THE DESIGN OF ANY SUCH ASSEMBLY, SUBASSEMBLY, OR PART IS PERMISSIBLE ONLY IF EXPRESSLY AUTHORIZED IN WRITING BY DME Tool.

DO NOT SCALE DRAWING INCH DIMENSIONS ARE PRIMARY UNLESS OTHERWISE SPECIFIED		DRILL MASTERS-ELDORADO TOOL 336 BOSTON POST RD. MILFORD, CONNECTICUT U.S.A.	
INCH TOLERANCES 1 PLACE ±.03 2 PLACES ±.015 3 PLACES ±.005 ANGLES ±1 deg. NON-ACCUMULATIVE		DESIGNER .MKIembara DATE .5/2/07 TITLE N8 NOSEGRIND	CHECKER . RELEASED . SUPERSEDES . REF.
METRIC TOLERANCES(mm) WHOLE NO. ±.8 1 PLACE ±.4 2 PLACES ±.13 ANGLES ±1 deg.		SCALE NONE	SHT. 1 OF 1 DWG. NO. . REV.