



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

DO NOT SCALE DRAWING
STANDARD MANUFACTURING
TOLERANCES APPLY

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

DRILL DIA.	CAM #	SINE BLOCK (PRIMARY CLEARANCE ANGLE)
UP TO .1562	1	NO SINE BLOCK (16°) UP TO .1719 DIA.
.1563 - .3594	2	USE 12" SINE BLOCK FOR .1720 DIA. AND UP
.3595 - .5469	3	
.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 ±0' WITHIN LIMITS OF CAM POCKET.
 - REMOVE GUNDRILL; HAND GRIND CHAMFER AS SHOWN.
- REFER TO FORMS 23, 792 & 521C(TABLE B-1) FOR DETAILS.

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<small>DO NOT SCALE DRAWING INCH DIMENSIONS ARE PRIMARY UNLESS OTHERWISE SPECIFIED</small>		DRILL MASTERS—ELDORADO TOOL 336 BOSTON POST RD. MILFORD, CONNECTICUT U.S.A.	
<small>INCH TOLERANCES</small> FRACTIONAL ± 1/32 2 PLACES ± .010 3 PLACES ± .005 4 PLACES ± .0005 ANGLES ± 1/2	DESIGNED _____ DATE _____ DRAWN D.J.S. 1/27/12 CHECKED _____ RELEASED D.J.S. 1/27/12 SUPERSEDES _____	TITLE NOSEGRIND N8 STANDARD	REF. _____
<small>METRIC TOLERANCES [MM]</small> WHOLE NO. ± .8 1 PLACE ± .4 2 PLACES ± .13 ANGLES ± 1/2	SCALE NONE SHT. 1 OF 1	DWG. NO. DE90-0005	REV. _____