



# GS-21 / GS-34

# Drill Bit Grinder

www.gsc-tw.com



ER50 Collet & Collet Holder



Twist drill bits



Deep-slot drill bits



Twist drill bits



NC spotting



Grinding heel drill

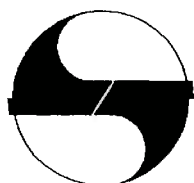
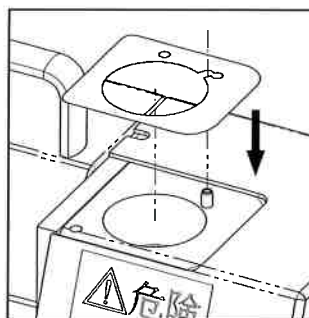


Model	GS-21	GS-34
Drill Diameter	Φ 12~26mm	Φ 12~34mm
Point Angle	90° ~140°	
Power Supply	AC110V 50/60Hz AC220V(Opt.)	
R.P.M of Motor	4600 R.P.M.	
Grinding Wheel	CBN#200	
Weight	N.W 19.8Kg G.W 22Kg	N.W 24Kg G.W 30Kg
Machine Size	L:365mm W:204mm H:223mm	
Packing Size	L:430mm W:270mm H:270mm	L:460mm W:430mm H:340mm
Type of Thinning	X Thinning	
Standard Accessories	ER32 Collet X 15 pcs	ER32 Collet X 15 pcs
	ER32 Collet Holder X 1 set	ER32 Collet Holder X 1 set
	ER50 Collet X 5 pcs	ER50 Collet X 5 pcs
	ER50 Collet Holder X 1 set	ER50 Collet Holder X 1 set
	Metal Shim 0.1mmX2 pcs / 0.3mmX1 pcs	
	Hexagon Wrench 3mmx1, 5mmx1	
	Optional SD Grinding Wheel for Carbide Drills	

## The Use of Metal Shims

There are 3 Metal Shims as standard accessories in the machine. 2 pcs of 0.1mm and 1pcs of 0.3mm.

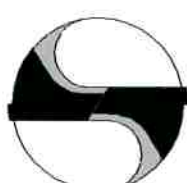
Adding one shim of 0.1mm will expand 0.2mm of the point size, adding 0.3mm shim will expand 0.6mm of the point size and so on.



Tip of drill without thinning, use only the Cutting Lip Grinding Shelf to sharpen this form.



Web Thinning made by normal grinding procedure without adding metal shims. Point size: 0.2mm - 0.4mm

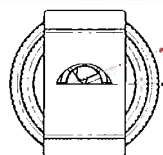
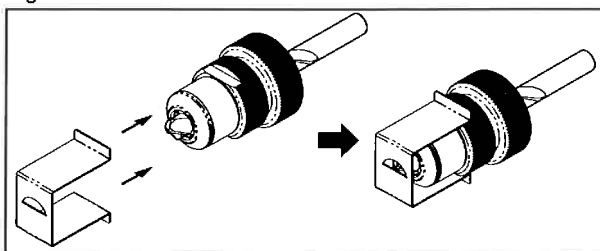


Web thinning result with metal shims. Point size: 0.4mm or bigger depend on the shims added.

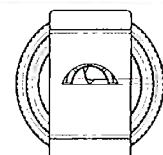
## The Use of the Parallel Alignment Devise

Align the Parallel Devise with the two slots of on the Clamping Nut, then connect them as shown in the left picture.

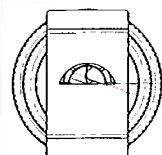
Verify the Parallelism of the Drill's Cutting Lip with the flat figure of the hole on the Parallel Devise.



**Incorrect**  
Please decrease scale



**Correct**  
Cutting lip parallel



**Incorrect**  
Please increase scale