Your Drill Doctor® SB is two bit-sharpening tools in one. To sharpen your 

**Spade Bit Sharpening**

**Module with Pivoting Spade Bit Sharpening Clutch-Drive System**

**Features of Your BLUE SPADE BITS**

- Sharpening Trigger
- Wheel-Adjustment Slider
- SHARPENING UNIT
- SPADE BIT HOLDER
- Wheel Guard
- Tip Sharpening Wheel
- Power Switch
- Wheel Adjustments
- Small-Bit Collet
- 6-foot Power Cord
- SPADE BIT Holder (Detail Above)
- Angle Adjustment Lever
- Sharpening Port
- SPRING BIT
- ORANGE Spade Bit
- SHARPENING UNIT (See other side)
- SPADE BIT HOLDER
- Aligning Spade Bits
- Before proceeding with your bit alignment. 

**NOTE:**

- Use the single guidelines shown as a reference.
- Use the double guidelines shown as a reference.
- There will be sparks at this point if the bit contacts the sharpening wheel. Flip the bit over to the other side and repeat steps A1 through A4.
- Slowly push the wheel adjustment slider to the right to move the sharpening wheel out of the way.
- Turn the unit on. The motor will be running, but the clutch is disengaged. Note: Both modules will feel snug) until the flat makes firm contact with the sharpening wheel. Flip the SB with the red switch on the spade bit holder.

**Advanced Spade Bit Functions**

**To Sharpen Screw-Tip Spade Bits**

- Use the small-bit collet to secure a bit that is too small to clamp well in the spade bit holder.
- Use the red small-bit collet to secure a bit that is too small or to grind off the screw threads as the bit is sharpened.

**To Sharpen Small Spade Bits**

- Use the wheel adjustment slider to set the wheel and the flat of the SB in contact with the sharpening wheel. Flip the SB to the other side and repeat steps B1 through B4.

**To Sharpen Larger Spade Bits**

- Use the red small-bit collet to secure a bit that is too small to clamp well in the spade bit holder.
- Use the small-bit collet to clamp well in the spade bit holder.
How to Sharpen Your Twist Bits

For Best Results

1. Only sharpen twist bits. 
   - To ensure a precise grind, use a twist bit. 
   - Avoid using the unit to sharpen other types of drills, such as spade bits.

2. Sharpen twist bits only one at a time. 
   - Do not sharpen two or more twist bits simultaneously.

3. Sharpen with the chuck shank in the unit. 
   - Place the chuck shank in the unit. This will tighten the chuck completely to stop it.

4. While sharpening, use a twist drill that is the same as or larger than the diameter of your bit. 
   - Insert the drill bit into the unit and tighten it with the chuck knob.

Twist & Masonry Bit Sharpening Features

Alignment Marks

Alignment Port

SB Triangle

Fingers

Chuck Alignment Triangle

Chuck Knob

Diamond Sharpening Wheel Access Cover

Guide Marks

Cam

7⁄16 to 1⁄2-inch bits—16 to 20 half turns
3⁄32 to 1⁄4-inch bits—4 to 8 half turns
- Always turn the chuck an even number of half turns.
- Adjust the alignment port to cover the chuck alignment marks.
- Make sure the chuck is in the correct orientation for your bit.
- For Best Results, follow the guidelines. To sharpen your twist bits, including masonry bits, follow the steps below.

Part A: Aligning Twist Bits

1. Insert your drill bit into the front of the sharpening unit.
2. Align the alignment port (SB triangle) lines up with the port-alignment mark (white triangle) lines up with the alignment port, making sure the bit is in the port.
3. While keeping the bit against the drill stop, rotate the unit until the alignment port lines up with the alignment port.
4. Keep the bit against the drill stop and rotate the unit until the alignment port lines up with the alignment port.
5. Repeat Steps 3 and 4 until the alignment port lines up with the alignment port.
6. When the alignment port lines up with the alignment port, the bit is ready to be sharpened.

Part B: Sharpening Twist Bits

1. Turn the chuck to the shank until the bit is secure in the chuck. This will tighten the chuck completely to stop it.
2. While keeping the chuck steady, rotate the unit until the alignment port lines up with the alignment port.
3. While keeping the chuck steady, rotate the unit until the alignment port lines up with the alignment port.
4. While keeping the chuck steady, rotate the unit until the alignment port lines up with the alignment port.
5. While keeping the chuck steady, rotate the unit until the alignment port lines up with the alignment port.
6. While keeping the chuck steady, rotate the unit until the alignment port lines up with the alignment port.

Part A: Aligning Masonry Bits

1. Insert your masonry bit into the alignment port. 
2. Align the alignment port (SB triangle) lines up with the port-alignment mark (white triangle) lines up with the alignment port, making sure the bit is in the port.
3. When the alignment port lines up with the alignment port, the bit is ready to be sharpened.

Part B: Sharpening Masonry Bits

1. Insert the unit into the alignment port. 
2. Align the alignment port (SB triangle) lines up with the port-alignment mark (white triangle) lines up with the alignment port, making sure the bit is in the port.
3. When the alignment port lines up with the alignment port, the bit is ready to be sharpened.

Replacement Parts in Order

Replacement Grits

- Coarse 100x ........... PP31326GF
- Standard Grit 46x... PP60060GF
- Fine Grit 60x .......... PP60061GF

Replacement Grinding Wheel

- For Twist Bit Sharpening
- Standard Th 3, 76-3100GF
- Coarse Th 4, 76-3100GF
- Standard Th 5, 76-3100GF

- For Masonry Bit Sharpening
- Standard Th 6, 76-3100GF

If you experience any difficulty with this tool or seem to be missing any parts, Please Do Not Return It to the Retailer. We are committed to your satisfaction and are ready to help you!

Call us at 800-597-6170.

3. The product has not been dismantled and no service or repairs have been attempted.
2. The product has been operated for the purpose intended as described in the operating instructions and has not been abused or mishandled in any way.
1. A copy of the proof of purchase is provided.

Your Drill Doctor is warranted to be free of defects due to workmanship or design for 3 years from the purchase date. If your Drill Doctor fails to operate, or if any operating instructions and has not been abused or mishandled in any way.

Drill Doctor® is a registered trademark of Darex, LLC.

Darex, LLC
P.O. Box 730
Ashland, OR 97520
Phone: 1-800-418-1439
Fax: 541-552-1377
Web: www.DrillDoctor.com

Parts List

- Coarse Grit 100x .......... PP31326GF
- Standard Grit 46x... PP60060GF
- Fine Grit 60x .......... PP60061GF

- Replacement Grits
- Replacement Grinding Wheel

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