

# Machinist Set up for Unibits

## T6Unibit, Sharpen Unibits (step drill bits)

## T-Unibit

This attachment allows for quick sharpening of unibits (step drill bits) using the Tradesman Machinist DC variable speed bench grinder and unibit wheel. A fence allows for controlled travel past the wheel, each pass taking a few thousandths of material.



Sharpened Unibit

### Instructions:

1. Set depth of cut adjustment. Position three setscrews so that the unibit fence is at desired depth of cut.
2. Tighten the two mounting bolts to secure the unibit fence to Tradesman side plate.
3. Position the unibit. Away from the wheel, press and hold unibit against the bottom and outer face of the fence.

4. Grinding. While maintaining light pressure against the fence, slide the unibit back and forth past the wheel. Each pass should remove a couple of thousandths of an inch. Repeat until inside face of the unibit is evenly ground to the cutting lip - a few passes should do it.

5. Removing the burr. This sharpening process will produce a small burr on the outside of the cutting lip. Remove this burr to complete the sharpening process. A quick pass of a wire brush works well.