

Secoroc Rock Drilling Tools

Product catalogue – Grinding equipment





Secoroc Grinding equipment – for drillers who prefer to spend less money on drilling

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You've probably known for a long time that regular grinding is essential for productivity. But what you may not know is just how important it is.

We decided to crunch some numbers and find out.

By wearing down your button bits by a third you'll slow down your penetration rate by 30%. But more importantly you'll increase your running costs by at least 40%! And why? Because the hole will take longer to drill and your labour and rig running costs will escalate. And at the end of the day you'll have drilled fewer holes.

Staying sharp makes a lot of business sense

Maintaining penetration can save you money. Firstly, you need good grinding equipment for a start – and you won't find any better than ours. And secondly, you need to spend time and energy grinding your bits. But the rewards are significant. For an investment amounting to just 2% of your overall drilling costs, you can restore your worn bits to their former glory. And with these bits you cut the time and manpower needed to drill the hole. In fact, you can reduce overall drilling costs up to 30%. How? By using the market's widest selection of efficient, ergonomically

designed grinding machines for fixed installations and field operations - Secoroc Grind Matic.

Get the sharpest advice

There are many different types of bits, some with inserts and others with buttons – and they come in many different sizes. To further complicate matters, no two rocks are the same. Consequently, bit wear differs. There's only one good piece of advice we can give you: don't make a decision before talking to us. And remember, thanks to our extensive service network, a good regrind is only a phone call away.



The right tools to get you back on the cutting edge



Every regrinding operation requires its own special tool. The wrong one can easily damage your bits. With Secoroc Grind Matic grinding equipment – complemented by a global service organization – you needn't worry. Your bits will soon be as good as new.

Grinding solutions for every job site

We provide mobile and fixed grinders for tapered, threaded, DTH- and COPROD button bits, as well as for crosstype bits and integrals with chisel inserts. Whatever the button profile, we have the solution to match. Naturally, we also offer a full range of accessories, including grinding wheels, grinding cups and bit holders. Check out our selection. We probably already have the ideal machine for your site.



Diamonds are a driller's best friend

If you need to grind steel and cemented carbide in a single operation, you won't find better tools than our patented diamond grinding wheels for spherical and ballistic

A machine for every occasion

Grinding machine	Button bits	DTH/COPROD bits	Reaming bits	Cross-type bits	Integrals
Grind Matic BQ2					
Grind Matic Jazz					
Grind Matic Manual B					
Grind Matic HG					
Grind Matic BQ2-DTH	☒				
Grind Matic Manual B-DTH*	☒				
Grind Matic X					
Grind Matic Swing					
Grind Matic Senior					

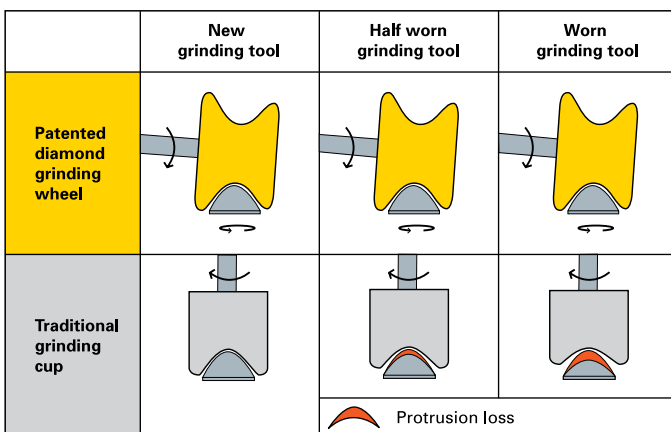
Recommended ☒ Can be used

* Can be used for ODEX pilot bits and reaming bits.



A useful tip: Use a Secoroc grinding template, and you'll see when it's time for a regrind.

Use the best grinding tool



cemented carbide buttons. Thanks to the diamond-coated steel body, these grinding wheels retain their profile throughout their working life. So when used in our semi-automatic grinding machines (Grind Matic Jazz, BQ2 and BQ2-DTH), or their manual counterparts (Manual B/Manual B-DTH), these wheels always deliver perfect results. There's no other way to grind spherical and ballistic buttons properly.

Grinding cups for button bits, COPROD and down-the-hole bits

Grinding cups are used, for smaller grinding volumes, to grind both button and down-the-hole bits in air powered hand-held grinding machines. Featuring a special mixture of

abrasive, Secoroc grinding cups are able to grind cemented carbide and steel in a single operation. You can use either air or water as a coolant.

It's safe to say that hand-held grinding has never been cheaper, easier or quicker.

Silicon carbide grinding wheels for cross-type bits and integrals

When grinding insert bits, it's vital that the thickness of the grinding wheel is in proportion to the diameter of the bit – to prevent damage to the inserts. What's more, to avoid overheating the cemented carbide inserts, be sure to select a grinding wheel that's too soft rather than too hard.

Secoroc Grind Matic BQ2

Semi-automatic grinding machine for button bits

Electrical specifications	Product No.	Product code
220 V 3-phase 50 Hz	87003801	3800-49
220 V 3-phase 60 Hz	87003805	3800-60
380 V 3-phase 50 Hz	87003800	3800-52
415 V 3-phase 50 Hz	87003802	3800-54
415 V 3-phase 60 Hz	87003804	3800-62
440 V 3-phase 60 Hz	87003806	3800-63

Accessories included in delivery

Allen key, 8 mm (1 piece)
Centering cup, 11 mm (1 piece)
Centering device (1 piece)
Coolant concentrate, 0,5 l
Grinding wheel, uncoated for centering
Protective goggles
Operator's instructions and spare parts list
Box wrench, 15 mm

Grinding capacity

Maximum height of drill bit	200 mm (7 ⁷ / ₈ "
Maximum diameter of drill bit	127 mm (5")
Minimum distance between buttons	3,5 mm (9/64")

Technical data

Air pressure, max.	7 bar (101.5 psi)
Air pressure, min.	6 bar (87 psi)
Air consumption	40 l/min
Capacity of cooling-fluid tank	22 l
Output, spindle motor	1,00 kW
Output, driving plate motor	0,15 kW
Output, coolant pump motor	0,10 kW
Speed, spindle	14900 r/min
Speed, table (50 Hz)	46 r/min
Speed, table (60 Hz)	55 r/min
Voltage working lighting	12 V
Weight, excluding packaging	222 kg (490 lb)
Transport dimension	L 1160 x W 1030 x H 1730 mm (6 ³ / ₄ " x 4" x 4 ⁵ / ₈ "

NOTE:

Grind Matic BQ2 must be completed with grinding wheels, centering cups, bitholders (indicate button size and thread dimension) and indexing templates.

Grinding wheels

Refer to pages 12–13

Centering cups

Refer to page 12

Bitholders

Refer to page 14

Indexing templates

Refer to pages 15–17



Grind Matic BQ2 is a fast, semi-automatic grinder specially designed for our profiled diamond grinding wheels, allowing you to precision-grind cemented carbide buttons and steel in the same operation. BQ2 is so easy to use that one operator can readily handle more than one machine at a time.

The machine also offers a number of novel features. To begin with, a time relay has replaced the pulse counter. And our new grinding spindle allows you to change grinding wheels without fuss or tools.

We've also introduced an electric locking device to ensure the same stroke length regardless of bit height. To use BQ2, simply connect the machine to electricity and air.



New improved control panel.

Secoroc Grind Matic BQ2-DTH

Semi-automatic grinding machine for DTH- and COPROD bits

Electrical specifications	Product No.	Product code
220 V 3-phase 50 Hz	87003901	3900-49
220 V 3-phase 60 Hz	87003904	3900-60
380 V 3-phase 50 Hz	87003900	3900-52
415 V 3-phase 50 Hz	87003902	3900-54
415 V 3-phase 60 Hz	87003905	3900-62
440 V 3-phase 60 Hz	87003906	3900-63

Accessories included in delivery

Coolant concentrate, 0,5 l
Protective goggles
Operator's instructions and spare parts list
Box wrench, 15 mm
Allen key, 8 mm

Optional accessories	Product No.	Product code
Auxiliary set for grinding threaded bits (excl. bitholder and templates)	87003939	9500-3939

Grinding capacity

Maximum height of drill bit	650 mm (2'15/8")
Maximum diameter of drill bit	178 mm (7")
Minimum distance between buttons	3,5 mm (9/64")

Technical data

Air pressure, max.	7 bar (101.5 psi)
Air pressure, min.	6 bar (87 psi)
Air consumption	40 l/min
Capacity of cooling-fluid tank	22 l
Output, spindle motor	3,00 kW
Output, table drive motor	0,15 kW
Output, coolant pump motor	0,10 kW
Speed, spindle	14900 r/min
Speed, table (50 Hz)	22 r/min
Speed, table (60 Hz)	26 r/min
Voltage working lighting	12 V
Weight, excluding packaging	345 kg (760 lb)
Transport dimension	L 1200 x W 1200 x H 1700 mm (49 1/4" x 49 1/4" x 69 1/4")

NOTE:

Grind Matic BQ2-DTH must be completed with grinding wheels, centering cups and bitholders (indicate button size, bit diameter and type of hammer).

Grinding wheels

Refer to page 13

Centering cups

Refer to page 12

Bitholders

Refer to page 14



Grind Matic BQ2-DTH is a fast machine. And with speed comes greater efficiency. We've included an indexing bitholder and an automatic centering arm. Combine these novel features with a more powerful grinding motor, as well as a fourfold increase in bit rotation speed, and you're looking at vastly superior grinding capacity.

Grind Matic BQ2-DTH is designed with the driller in mind. Add to that a handy time relay for setting grinding time, a tiltable

bitholder to help you handle heavier bits more easily plus an electric locking device, and you'll find this is a highly rational grinding machine.

Moreover, Grind Matic BQ2-DTH is built to last. The spindle bearing is protected by a splashguard. And all electrical and pneumatic components are housed in a cabinet on the side of the machine, protecting them from dust, dirt and water.

Secoroc Grind Matic Jazz

Rig-mounted, semi-automatic grinding machine for tapered, threaded, DTH- and COPROD bits

	Product No.	Product code
Grind Matic Jazz, std	87004100	9500-4100
Main bit holder for threaded bits included in delivery		

	Product No.	Product code
Grind Matic Jazz, DTH	87004300	9500-4300
Main bit holder for DTH/COPROD bits included in delivery		

Accessories included in delivery

Box wrench, 11 mm
 Box wrench, 16 mm
 Protective goggles
 Operator's instructions and spare parts list

Optional accessories	Product No.	Product code
Anti-freeze kit	87004315	9500-4315
Main bit holder for DTH/ COPROD bits	87004268	9500-4268
Main bit holder for threaded bits	87004214	9500-4214
Mounting bracket for Atlas Copco drill rig		
- with cabin	87004388	9500-4388
- without cabin	87004456	9500-4456
3-leg stand	87004450	9500-4450
Centering tool	87004465	9500-4465

Grinding capacity

Maximum distance between bit holder and grinding wheel	250 mm (9 ⁷ / ₈ "
Maximum diameter of drill bit	254 mm (10")
Minimum diameter of drill bit	35 mm (1 ³ / ₈ "
Minimum distance between buttons	3,5 mm (9 ¹ / ₆₄ "

Technical data

Air pressure, max.	7 bar (101,5 psi)
Air pressure, min.	6 bar (87 psi)
Air consumption	1500 l/min
Coolant container	3 l
Output, spindle motor	1,00 kW
Speed, spindle	15000 r/min
Voltage	24 V
Weight, excluding packaging	90 kg (198 lb)
Transport dimension	L 800 x W 500 x H 700 mm (2'7 ¹ / ₂ " x 1'7 ⁵ / ₈ " x 2'3 ¹ / ₂ "

NOTE:

Grind Matic Jazz must be completed with grinding wheels, centering cups, bitholders and indexing templates.

Grinding wheels

Refer to page 13



Mobile perfection

The latest addition to the Secoroc range of grinding equipment, Grind Matic Jazz is the only rig-mounted, semi-automatic grinder that delivers perfection. Featuring patented profiled diamond grinding wheels, it restores worn spherical and ballistic buttons to their former glory.

Grinding on the move

Grind Matic Jazz is easily retrofitted to most rigs. Mounted in front of the cab, the grinder is unobtrusive when not in use, but swings out for easy access when it's time to sharpen your bits.

Thanks to low air consumption you can drill and grind simultaneously – with full effect. Mounting is easy. Simply bolt your Jazz onto the rig, hook up the air hose, connect the power, check the mist cooling water tank and you're ready to grind.

Grinds all shapes and sizes

Equipped with a timer, Grind Matic Jazz is readily centred on each button and activated by the operator. This operation is repeated button by button. Jazz handles bit sizes from 35 mm (1³/₈") up to 254 mm (10") DTH bits.

Secoroc Grind Matic Manual B

Hand-held portable grinding machine for button bits

	Product No.	Product code
Grind Matic Manual B	87001890	9424

Accessories included in delivery

Allen key, 4 mm
Centering fingers (4 pcs)
Hand-held grinder, 30000 r/min
Open end spanner, 14 mm (2 pcs)
Protective goggles
Operator's instructions and spare parts list

Optional accessories	Product No.	Product code
Set of 5 centering fingers	87001935	9500-1935

Grinding capacity

Maximum diameter of bit skirt	90 mm (3 ⁹ / ₁₆ "
Threaded bits, maximum diameter	127 mm (5")
Retrac, maximum diameter	127 mm (5")*
Tube drilling, maximum diameter	152 mm (6")*

* Large clamping device necessary

Technical data

Air pressure, max.	7 bar (101.5 psi)
Air consumption	900 l/min
Coolant container	10 l
Idling speed of hand-held grinder	30000 r/min
Speed of bit rotation	0-45 r/min
Weight, excluding packaging	55 kg (121.3 lb)
Weight, including packaging	90 kg (198.4 lb)
Transport dimension	L 1200 x W 800 x H 850 mm (3'11 ¹ / ₄ " x 2'7 ¹ / ₂ " x 2'9 ¹ / ₂ "

NOTE:

Grind Matic Manual B must be completed with grinding wheels and bitholders.

Grinding wheels

Refer to page 13

Bitholders

Refer to page 14



Grind Matic Manual B is an air-powered grinding machine, equipped with diamond grinding wheels, for spherical and ballistic buttons. Mounted in a box fitted with wheels and handles, Manual B is mobile and easy to set up. A separate water tank provides efficient cooling.

Grinding couldn't be easier

By simply folding the box support legs and connecting the air hose and the hose to the water cooler container, you'll have the machine up and running in no time. The

hand-held part of Manual B is a straight air-powered grinder specially designed for Grind Matic diamond grinding wheels. The bitholder, driven by an air-powered angle-gear, is fitted in the bottom of the box. A steel spring is mounted in the profile of the grinding wheel where it functions as a centering device, facilitating easy grinding.



Secoroc Grind Matic Manual B-DTH

Hand-held portable grinding machine for DTH- and COPROD bits

	Product No.	Product code
Grind Matic Manual B-DTH	87002300	9425

Accessories included in delivery

Allen key, 5 mm
 Allen key, 6 mm
 Centering fingers (4 pcs)
 Grinding belt (4 pcs)*
 Hand-held grinder (spherical, 30 000 r/min)
 Open end spanner, 14 mm (2 pcs)
 Protective goggles
 Operator's instructions and spare parts list

*) When ordering gauge grinding unit,
 Product No. 87002302 / Product code 9500-2302.

Optional accessories	Product No.	Product code
Gauge grinding unit complete	87002302	9500-2302
Centering fingers (set of 5 pcs), 30000 r/min	87001935	9500-1935
Clamping device for threaded bits	87002401	9500-2401
Hand-held grinder (ballistic, 30000 r/min)	87001913	9500-1913

Grinding capacity

Maximum height of drill bit	506 mm (1'7 ⁷ / ₈ ")
Maximum diameter of drill bit	203 mm (8")
Maximum diameter of bit shank	170 mm (6 ³ / ₄ ")

Technical data

Air pressure, max.	7 bar (101.5 psi)
Air consumption (incl. gauge grinding)	1500 l/min
Air consumption (excl. gauge grinding)	1380 l/min
Coolant container	10 l
Dimension of grinding belt	50 x 1500 mm (2" x 4'11")
Idling speed of hand-held grinder	18000 r/min
Speed of bit rotation	0-45 r/min
Weight, excluding packaging	110 kg (253 lb)
Weight, including packaging	148 kg (326 lb)
Weight of gauge grinding unit, net	27,5 kg (60.6 lb)
Weight of gauge grinding unit, gross	35 kg (77.2 lb)
Transport dimension	L 1200 x W 800 x H 940 mm (3'11 ¹ / ₄ " x 2'7 ¹ / ₂ " x 3'1")

NOTE: Grind Matic Manual B-DTH must be completed with grinding wheels and bitholders.

Grinding wheels

Refer to page 13

Bitholders

Refer to page 14



Grind Matic Manual B-DTH is a hand-held grinder for grinding down-the-hole bits. Equipped with a few simple accessories, it also grinds threaded button bits. The machine is air-powered and uses Grind Matic diamond grinding wheels for grinding spherical and ballistic buttons. The Manual B-DTH is mounted in a box fitted with wheels and handles. A separate water tank provides efficient cooling.

Smooth and swift operation

Simply connect your Manual B-DTH to air

and water, and it's ready to use.

The bitholder, driven by an air-powered angle gear, is mounted in the bottom of the box. The hand-held part of Manual B-DTH is a straight, air-powered grinder specially adapted to our diamond grinding wheels. A steel spring is mounted in the profile of the grinding wheel where it functions as a centering device, greatly simplifying the grinding operation. As an optional accessory, Grind Matic Manual B-DTH can be fitted with a belt grinder for gauge grinding.

Secoroc Grind Matic HG

Hand-held grinding machine for button bits

Grind Matic HG	Product No. 87002435	Product code 9542
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Accessories included in delivery

Adjustable angle connector
 Allen key, 2 mm
 Allen key, 3 mm
 Allen key, 5 mm
 Claw coupling (6,3 mm)
 Grease gun
 Hose (PVC 03)
 Hose (PVC 6; L = 0,1 m)
 Hose clamp (7–8,5 mm)
 Hose clamp (11–13 mm)
 Hose clamp (26–38 mm)
 Nipple
 Pipe (L = 0,3 m)
 Seal kit
 Seat
 Support ring
 Operator's instructions and spare parts list

Optional accessories	Product No.	Product code
Lubricator	87002750	9500-2750
Reconditioning tool for grinding cups	87002810	9500-2810

Grinding capacity

Button size 7–20 mm (9/32"–25/32")

Technical data

Air pressure, max.	7 bar (101.5 psi)
Air consumption, unloaded	3000 l/min
Air consumption, loaded (at 6 bar, 86 psi)	2520 l/min
Hose dimension, air	12,5 mm (1/2")
Hose dimension, water	6,3 mm (1/4")
Idling speed	17000 r/min
Water flushing pressure, max.	4,5 bar (65.3 psi)
Weight, excluding hoses	2,8 kg (6.2 lb)

Grinding cups

Refer to page 12



Grind Matic HG is a complete manual grinding system comprising a grinding machine, grinding cup and a specially designed chuck. The grinding cups are equipped with a rubber bushing, preventing the transmission of vibrations to the machine. The cups can be cooled with either air or water. QuickSnap, our cleverly designed chuck, allows you to change grinding cups quickly and easily. Add to that silent and almost vibrationless operation, and the Grind Matic HG is one of the most operator-friendly hand-held grinders on the market.


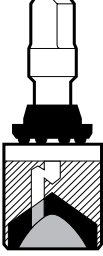
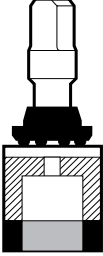


QuickSnap, our ingenious chuck, allows you to change grinding cups quickly and easily.

Centering cups for Grind Matic BQ2/BQ2-DTH/Jazz

For button size	Product No.	Product code
7,0 mm	87001040	9500-1040
8,0 mm	87000842	9500-0842
9,0 mm	87001047	9500-1047
10,0 mm	87001041	9500-1041
11,0 mm	87000840	9500-0840
12,0 mm	87001042	9500-1042
12,7 mm	87000839	9500-0839
13,0 mm	87001385	9500-1385
14,0 mm	87001043	9500-1043
14,5 mm	87001443	9500-1443
15,0 mm	87001386	9500-1386
16,0 mm	87001387	9500-1387
18,0 mm	87003943	9500-3943
19,0 mm	87003944	9500-3944

Diamond grinding cups for Grind Matic HG

	Dimension, mm	Product No.	Product code	
For sperical buttons 	7,0	87002566	9500-2566	
	8,0	87002567	9500-2567	
	9,0	87002568	9500-2568	
	10,0	87002569	9500-2569	
	11,0	87002570	9500-2570	
	12,0	87002571	9500-2571	
	13,0	87002572	9500-2572	
	14,0	87002573	9500-2573	
	15,0	87002574	9500-2574	
	16,0	87002575	9500-2575	
	18,0	87002576	9500-2576	
	19,0	87004558	9500-4558	
	20,0	87002577	9500-2577	
	For ballistic buttons 	7,0	87002579	9500-2579
		8,0	87002580	9500-2580
		9,0	87002581	9500-2581
		10,0	87002582	9500-2582
		11,0	87002583	9500-2583
		12,0	87002584	9500-2584
13,0		87002585	9500-2585	
14,0		87002586	9500-2586	
15,0	87002587	9500-2587		
16,0	87002588	9500-2588		
For steel removal around buttons 	7-8	87002700	9500-2700	
	9-10	87002701	9500-2701	
	11-12	87002702	9500-2702	
	13-14	87002703	9500-2703	
	15-16	87002704	9500-2704	
	17-18	87002840	9500-2840	
	19-20	87002841	9500-2841	

Grinding wheels for steel grinding Boron nitride – Button bits

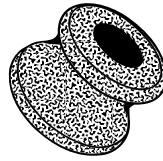
Grind Matic BQ2/BQ2-DTH

Dimension	Product No.	Product code
10-14 mm	87001530	9500-1530
Spacer for 10 mm button	87001631	9500-1631
Spacer for 11 mm button	87001632	9500-1632
Spacer for 12 mm button	87001633	9500-1633
Spacer for 13 mm button	87001634	9500-1634
Spacer for 14 mm button	87001635	9500-1635



Diamond grinding wheels for button bits

Grind Matic BQ2
 Grind Matic BQ2-DTH
 Grind Matic Jazz
 Grind Matic Manual B
 Grind Matic Manual B-DTH



Standard diamond-grain wheels

Dimension, mm	Product No.	Product code
Spherical		
7	87001028	9500-1028
8	87001026	9500-1026
9	87001389	9500-1389
10	87001023	9500-1023
11	87003406	9500-3406
12	87001024	9500-1024
13	87001339	9500-1339
14	87001025	9500-1025
15	87001384	9500-1384
16	87001027	9500-1027
18	87003964	9500-3964
19	87003966	9500-3966
Ballistic		
7	87003407	9500-3407
8	87003408	9500-3408
9	87003409	9500-3409
10	87003410	9500-3410
11	87003411	9500-3411
12	87003412	9500-3412
13	87003413	9500-3413
14	87003414	9500-3414
15	87003415	9500-3415
16	87003416	9500-3416
18	87003965	9500-3965
19	87003967	9500-3967
Full Ballistic		
9	87004359	9500-4359

Large diamond-grain wheels

Dimension, mm	Product No.	Product code
Spherical		
7	87004554	9500-4554
8	87004555	9500-4555
9	87003969	9500-3969
10	87003970	9500-3970
11	87003971	9500-3971
12	87003972	9500-3972
13	87003973	9500-3973
Ballistic		
7	87004556	9500-4556
8	87004557	9500-4557
9	87003974	9500-3974
10	87003975	9500-3975
11	87003976	9500-3976
12	87003977	9500-3977

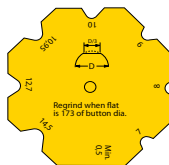
Grind Matic Manual B-DTH

(with the 18 000 rpm grinder)

Dimension, mm	Product No.	Product code
Spherical		
12	87002043	9500-2043
13	87002044	9500-2044
14	87002045	9500-2045
15	87002046	9500-2046
16	87002032	9500-2032
18	87002097	9500-2097
19	87002174	9500-2174

Grinding templates for button bits

	Product No.	Product code
Button bits, spherical	90002944	9104
Button bits, ballistic	90503414	9105
Button bits DTH, spherical	90510753	9129
Button bits DTH, ballistic	90510758	9130



Bitholders for button bits

Grind Matic BQ2/Jazz/BQ

	Product No.	Product code
Threaded bits		
Holder R25	87003475	9500-3475
Holder R28	87003476	9500-3476
Holder SR28	87003960	9500-3960
Holder R32	87003477	9500-3477
Holder SR32	87003962	9500-3962
Holder SR35	87003956	9500-3956
Holder R38, T38	87003478	9500-3478
Holder SR38	87003978	9500-3978
Holder SR38 retrac, guide	87004081	9500-4081
Holder T45	87003479	9500-3479
Holder TC45	87004569	9500-4569
Holder T51 and retrac	87003521	9500-3521
Holder T60	87004562	9500-4562
Tube bits		
Holder ST58	87003522	9500-3522
Holder ST68	87003523	9500-3523
Tapered bits		
Holder 7° taper	87003524	9500-3524
Holder 12° taper	87003525	9500-3525
Reaming bits		
Holder 64, 76 and 89 mm reamer	87003526	9500-3526
Holder 89,102 and 127 mm reamer	87003527	9500-3527
Guide bits		
Holder SR35 guide bit	87004056	9500-4056
Holder R32 guide bit	87003992	9500-3992
By using the auxillary set part 87003939 (Product No.) / 9500-3939 (Product code), Grind Matic BQ2-DTH can also use the above bit holders for threaded bits.		


Grind Matic Manual B

(for clamping device compl. 87000772 / 9500-0772 Grind Matic B)

	Product No.	Product code
Threaded bit		
R25	87000792	9500-0792
R28	87000793	9500-0793
SR28	87003961	9500-3961
R32	87000794	9500-0794
R32	87001848	9500-1848
SR32	87003963	9500-3963
R35	87003360	9500-3360
SR35	87003957	9500-3957
R38/T38	87000795	9500-0795
SR38	87003979	9500-3979
T45	87000796	9500-0796
T51	87000802	9500-0802
Tapered bit		
with 7° taper	87001044	9500-1044
with 12° taper	87001045	9500-1045
Tube bit		
ST58	87001726	9500-1726
ST68	87001573	9500-1573
Reaming bit		
64, 76, 89 mm ¹⁾	87000798	9500-0798
89, 102, 127 mm ¹⁾	87000799	9500-0799
¹⁾ Centering pin for bitholders 9500-0798 and 9500-0799.	87001070	9500-1070
Clamping device for regrinding retrac bits 64–127 mm and TDS bits 89–152 mm (ST58, ST68) without bitholder (to complete 87000772 / 9500-0772).	87001930	9500-1930

Grind Matic BQ2-DTH/Manual B-DTH/Jazz-DTH

Down-the-hole bits and COPROD bits	Product No.	Product code
COP 32	87002420	9500-2420
COP 34	87003691	9500-3691
DHD3.5	87004514	9500-4514
DHD340	87002391	9500-2391
DHD350	87002390	9500-2390
DHD360	87002389	9500-2389
DHD380	87004523	9500-4523
TD 40	87004604	9500-4604
RC 50	87004605	9500-4605
QL40	87004515	9500-4515
QL50	87004033	9500-4033
QL60	87004002	9500-4002
QL80	87004516	9500-4516
COPROD 76	87004414	9500-4414
COPROD 89	87003155	9500-3155
COPROD 102	87004415	9500-4415
COPROD 127	87002396	9500-2396

Down-the-hole bits and COPROD bits	Product No.	Product code
Grind Matic Manual B-DTH only		
Threaded bits* T38	87002148	9500-2148
Threaded bits* T45	87002149	9500-2149
Threaded bits* T51	87002147	9500-2147
Threaded bits* ST58	87002158	9500-2158
Threaded bits* ST68	87002154	9500-2154
* Clamping device for threaded bits		
	87002401	9500-2401

Indexing templates for Grind Matic BQ2, Jazz and BQ

Thread	Drill bit		Indexing template	
	Product No.	Product code	Product No.	Product code
R25				
R25	90510448	102-5033-17,39-20	87003484	9500-3484
R25	90510274	102-5033-17-67,39-20	87003484	9500-3484
R25	90505181	102-5035-27,39-20	87003483	9500-3483
R25	90509723	102-5035-27-67,39-20	87003483	9500-3483
R25	90505295	102-5037-27,39-20	87003483	9500-3483
R25	90505179	102-5038-27,39-20	87003483	9500-3483
R25	90505180	102-5038-27-67,39-20	87003483	9500-3483
R25	90510206	102-5038-56,39-20	87003494	9500-3494
R25	90505175	102-5041-27,39-20	87003499	9500-3499
R25	90510662	102-5041-27-67-30,39-20	87003499	9500-3499
R25	90510207	102-5041-56,39-20	87003482	9500-3482
R25	90505145	102-5045-27,39-20	87003480	9500-3480
R25	90510208	102-5045-56,39-20	87003482	9500-3482
R25	90505353	102-5051-27,39-20	87003485	9500-3485
R28				
R28	90505296	107-5037-27,39-20	87003483	9500-3483
R28	90505177	107-5038-27,39-20	87003483	9500-3483
R28	90505178	107-5038-27-67,39-20	87003483	9500-3483
R28	90505173	107-5041-27,39-20	87003499	9500-3499
R28	90505174	107-5041-27-67,39-20	87003499	9500-3499
R28	90505169	107-5043-27,39-20	87003499	9500-3499
R28	90509467	107-5045-37,39-20	87003481	9500-3481
R28	90509468	107-5045-37-67,39-20	87003481	9500-3481
R28	90509470	107-5048-37-67,39-20	87003486	9500-3486
R28	90510396	107-5076-20,49-20	87003559	9500-3559
R28	90510397	107-6051,49-20	87003487	9500-3487
SR28				
SR28	90514200	125-5033-17,39-20	87003484	9500-3484
SR28	90514117	125-5033-41,39-20	87004037	9500-4037
SR28	90514137	125-5033-41-67,39-20	87004037	9500-4037
SR28	90514322	125-5035-27,39-20	87003483	9500-3483
SR28	90514102	125-5035-27-67,39-20	87003483	9500-3483
SR28	90514167	125-5037-99,39-20	87003483	9500-3483
SR28	90514282	125-5038-27,39-20	87003483	9500-3483
R32				
R32	90505172	103-5041-27-67,39-20	87003499	9500-3499
R32	90510744	103-5041-34-67,39-20	87003492	9500-3492
R32	90510209	103-5041-56,39-20	87003482	9500-3482
R32	90505164	103-5043-27,39-20	87003499	9500-3499
R32	90505168	103-5043-27-67,39-20	87003499	9500-3499
R32	90511793	103-5043-27-Z,39-20	87003830	9500-3830
R32	90510769	103-5043-37-67,39-20	87003486	9500-3486
R32	90510210	103-5043-56,39-20	87003494	9500-3494
R32	90504373	103-5045-27,39-20	87003480	9500-3480
R32	90512011	103-5045-27-67,39-20	87003480	9500-3480
R32	90511539	103-5045-27-Z,39-20	87003480	9500-3480
R32	90510503	103-5045-34,39-20	87003492	9500-3492
R32	90510275	103-5045-34-67,39-20	87003492	9500-3492
R32	90509457	103-5045-37,39-20	87003481	9500-3481
R32	90509459	103-5045-37-30-67,39-20	87003481	9500-3481

Thread	Drill bit		Indexing template	
	Product No.	Product code	Product No.	Product code
R32	90509460	103-5045-37-67,39-20	87003481	9500-3481
R32	90504401	103-5045-39,39-20	87003488	9500-3488
R32	90510211	103-5045-56,39-20	87003482	9500-3482
R32	90504374	103-5048-27,39-20	87003485	9500-3485
R32	90510160	103-5048-27-Z,39-20	87003485	9500-3485
R32	90509461	103-5048-37,39-20	87003486	9500-3486
R32	90509463	103-5048-37-30-67,39-20	87003486	9500-3486
R32	90509464	103-5048-37-67,39-20	87003486	9500-3486
R32	90510450	103-5051,39-20	87003496	9500-3496
R32	90504566	103-5051-27,39-20	87003485	9500-3485
R32	90510451	103-5051-34,39-20	87003492	9500-3492
R32	90509465	103-5051-37,39-20	87003481	9500-3481
R32	90509466	103-5051-37-67,39-20	87003481	9500-3481
R32	90510795	103-5054-24-45-67,39-20	87003493	9500-3493
R32	90509480	103-5054-37,39-20	87003486	9500-3486
R32	90509481	103-5054-37-67,39-20	87003486	9500-3486
R32	90510453	103-5057-20,39-20	87003495	9500-3495
R32	90510454	103-5057-20-67,39-20	87003495	9500-3495
R32	90510303	103-5064,49-20	87003489	9500-3489
R32	90510381	103-5064-45,49-20	87003489	9500-3489
R32	90510327	103-5064-67,49-20	87003489	9500-3489
R32	90510353	103-5076,49-20	87003493	9500-3493
R32	90510821	103-5076-42-24-67,49-20	87003951	9500-3951
R32	90510843	103-5089-42-24,49-20	87003955	9500-3955
R32	90510820	103-5089-42-24-67,49-20	87003955	9500-3955
R32	90510842	103-5102-42-24,49-20	87003955	9500-3955
R32	90510781	103-5102-42-24-67,49-20	87003955	9500-3955
R32	90510302	103-6051,49-20	87003487	9500-3487
R32	90510308	103-6051-45,49-20	87003487	9500-3487
R32	90510328	103-6064,49-20	87003487	9500-3487
R32	90510364	103-6064-45,49-20	87003487	9500-3487
R32	90510414	103-6064-45-67,49-20	87003487	9500-3487
R32	90510504	103-6076-45,49-20	87003498	9500-3498
R35				
R35	90514343	109-6054-67,49-20	87004048	9500-4048
SR35				
SR35	90513844	128-5043-27,39-20	87003499	9500-3499
SR35	90513840	128-5045-37-67,39-12	87003481	9500-3481
SR35	90513839	128-5045-37-67,39-20	87003481	9500-3481
SR35	90513841	128-5045-39,39-20	87003488	9500-3488
SR35	90513843	128-5048-37-67,39-20	87003486	9500-3486
SR35	90514150	128-5048-39,39-20	87004048	9500-4048
SR35	90514595	128-5051-24-45-67,39-20	87003493	9500-3493
SR35	90513842	128-5051-37-67,39-20	87003481	9500-3481
SR35	90513871	128-5054-37-67,39-20	87003486	9500-3486
SR35	90513870	128-5064-67,49-20	87003489	9500-3489
SR35	90513869	128-5076-42-24-67,49-20	87003951	9500-3951
SR35	90513848	128-5089-42-24,49-20	87003955	9500-3955
SR35	90513849	128-5089-42-24-67,49-20	87003955	9500-3955
SR35	90513850	128-5102-42-24,49-20	87003955	9500-3955
SR35	90513851	128-5102-42-24-67,49-20	87003955	9500-3955

Indexing templates for Grind Matic BQ2, Jazz and BQ

Thread	Drill bit		Indexing template	
	Product No.	Product code	Product No.	Product code
R38				
R38	90510304	104-5064,49-20	87003489	9500-3489
R38	90510318	104-5076,49-20	87003493	9500-3493
R38	90510794	104-5076-20-45,49-20	87003559	9500-3559
R38	90510323	104-5089,49-20	87003493	9500-3493
T38				
T38	90510316	135-5064-20,49-20	87003490	9500-3490
T38	90513748	135-5064-21,49-20	87003559	9500-3559
T38	90510348	135-5064-22,49-20	87003488	9500-3488
T38	90510309	135-5064-45,49-20	87003489	9500-3489
T38	90510365	135-5064-45-67,49-20	87003489	9500-3489
T38	90510413	135-5064-67,49-20	87003489	9500-3489
T38	90510350	135-5070-20,49-20	87003495	9500-3495
T38	90510319	135-5076,49-20	87003493	9500-3493
T38	90510321	135-5076-20,49-20	87003559	9500-3559
T38	90513749	135-5076-21,49-20	87003559	9500-3559
T38	90513760	135-5076-21-67,49-20	87003559	9500-3559
T38	90510354	135-5076-22,49-20	87003495	9500-3495
T38	90510366	135-5076-45,49-20	87003493	9500-3493
T38	90510312	135-5076-45-67,49-20	87003493	9500-3493
T38	90510324	135-5089,49-20	87003493	9500-3493
T38	90510417	135-5089-20,49-20	87003714	9500-3714
T38	90513763	135-5089-21-67,49-20	87003883	9500-3883
T38	90510367	135-5089-45,49-20	87003493	9500-3493
T38	90510329	135-5102,49-20	87003493	9500-3493
T38	90513776	135-5127-42-24,49-20	87003954	9500-3954
T38	90513775	135-5127-42-24-67,49-20	87003954	9500-3954
T38	90510307	135-6064,49-20	87003487	9500-3487
T38	90510347	135-6064-21,49-20	87003487	9500-3487
T38	90513805	135-6064-21-45-67,49-20	87003487	9500-3487
T38	90510524	135-6064-21-67,49-20	87003487	9500-3487
T38	90510311	135-6064-45,49-20	87003487	9500-3487
T38	90510368	135-6064-45-67,49-20	87003487	9500-3487
T38	90514631	135-6064-48-45-67,49-20	87003985	9500-3985
T38	90510306	135-6064-67,49-20	87003487	9500-3487
T38	90510352	135-6070,49-20	87003559	9500-3559
T38	90510707	135-6070-21,49-20	87003749	9500-3749
T38	90513832	135-6070-21-67,49-20	87003749	9500-3749
T38	90510384	135-6070-45-67,49-20	87003559	9500-3559
T38	90510351	135-6070-67,49-20	87003559	9500-3559
T38	90510330	135-6076,49-20	87003559	9500-3559
T38	90513806	135-6076-21,49-20	87003953	9500-3953
T38	90510810	135-6076-21-45,49-20	87003953	9500-3953
T38	90510811	135-6076-21-45-67,49-20	87003953	9500-3953
T38	90513807	135-6076-21-67,49-20	87003953	9500-3953
T38	90510369	135-6076-45,49-20	87003498	9500-3498
T38	90510370	135-6076-45-67,49-20	87003498	9500-3498
T38	90510331	135-6076-67,49-20	87003559	9500-3559
T38	90513804	135-6076-99-45-67,49-20	87003498	9500-3498
T38	90510332	135-6089,49-20	87003559	9500-3559

Thread	Drill bit		Indexing template	
	Product No.	Product code	Product No.	Product code
T38	90513808	135-6089-21,49-20	87003500	9500-3500
T38	90513809	135-6089-21-67,49-20	87003500	9500-3500
T38	90510654	135-6089-45-67,49-20	87003500	9500-3500
T38	90510355	135-6089-67,49-20	87003559	9500-3559
T38	90513810	135-6102-21,49-20	87003500	9500-3500
T38	90513762	135-6102-21-67,49-20	87003500	9500-3500
T45				
T45	90510320	136-5076,49-20	87003493	9500-3493
T45	90510322	136-5076-20,49-20	87003559	9500-3559
T45	90513761	136-5076-21-45,49-20	87003559	9500-3559
T45	90510371	136-5076-45,49-20	87003493	9500-3493
T45	90510386	136-5076-45-67,49-20	87003493	9500-3493
T45	90510325	136-5089,49-20	87003493	9500-3493
T45	90513751	136-5089-21-45,49-20	87003883	9500-3883
T45	90510780	136-5089-21-67,49-20	87003883	9500-3883
T45	90510372	136-5089-45,49-20	87003493	9500-3493
T45	90510390	136-5089-45-67,49-20	87003493	9500-3493
T45	90510326	136-5102,49-20	87003493	9500-3493
T45	90510888	136-5102-21,49-20	87003713	9500-3713
T45	90510889	136-5102-21-67,49-20	87003713	9500-3713
T45	90510373	136-5102-45,49-20	87003493	9500-3493
T45	90513778	136-5127-42-24,49-20	87003954	9500-3954
T45	90513818	136-5152-42-24,49-20	87003954	9500-3954
T45	90510782	136-5152-42-24-67,49-20	87003954	9500-3954
T45	90510782	136-5152-42-67,49-20	87003954	9500-3954
T45	90510478	136-6070,49-20	87003559	9500-3559
T45	90510479	136-6070-45,49-20	87003559	9500-3559
T45	90510385	136-6070-45-67,49-20	87003559	9500-3559
T45	90510333	136-6076,49-20	87003559	9500-3559
T45	90513750	136-6076-21,49-20	87003953	9500-3953
T45	90510808	136-6076-21-45,49-20	87003953	9500-3953
T45	90510809	136-6076-21-45-67,49-20	87003953	9500-3953
T45	90510313	136-6076-45,49-20	87003498	9500-3498
T45	90510314	136-6076-45-67,49-20	87003498	9500-3498
T45	90510334	136-6076-67,49-20	87003559	9500-3559
T45	90510800	136-6076-99-45,49-20	87003498	9500-3498
T45	90510801	136-6076-99-45-67,49-20	87003498	9500-3498
T45	90510335	136-6089,49-20	87003559	9500-3559
T45	90513752	136-6089-21,49-20	87003500	9500-3500
T45	90510692	136-6089-21-45,49-20	87003500	9500-3500
T45	90510772	136-6089-21-45-67,49-20	87003500	9500-3500
T45	90510374	136-6089-45,49-20	87003500	9500-3500
T45	90510375	136-6089-45-67,49-20	87003500	9500-3500
T45	90510336	136-6089-67,49-20	87003559	9500-3559
T45	90510337	136-6102,49-20	87003559	9500-3559
T45	90513811	136-6102-21,49-20	87003500	9500-3500
T45	90510392	136-6102-45,49-20	87003500	9500-3500
T45	90510376	136-6102-45-67,49-20	87003500	9500-3500
T45	90510399	136-6115,49-20	87003500	9500-3500
T45	90513836	136-6127-21,49-20	87003500	9500-3500

Indexing templates for Grind Matic BQ2, Jazz and BQ

Thread	Drill bit		Indexing template	
	Product No.	Product code	Product No.	Product code
TC45				
TC45	90515791	170-6064-48-67,49-20	87003985	9500-3985
TC45	90516017	170-6057-67,39-20	87004048	9500-4048
T51				
T51	90510338	137-5089,49-20	87003493	9500-3493
T51	90510357	137-5089-20,49-20	87003884	9500-3884
T51	9051 0527	137-5089-21,49-20	87003883	9500-3883
T51	90513764	137-5089-21-45,49-20	87003883	9500-3883
T51	90510377	137-5089-45,49-20	87003493	9500-3493
T51	90510339	137-5102,49-20	87003493	9500-3493
T51	90510317	137-5102-20,49-20	87003714	9500-3714
T51	90510807	137-5102-21,49-20	87003713	9500-3713
T51	90510855	137-5102-21-45,49-20	87003713	9500-3713
T51	90510841	137-5102-21-45-67,49-20	87003713	9500-3713
T51	90514563	137-5102-22,49-20	87004053	9500-4053
T51	90510378	137-5102-45,49-20	87003493	9500-3493
T51	90510340	137-5115-20,49-20	87004036	9500-4036
T51	90510791	137-5115-20-45,49-20	87004036	9500-4036
T51	90510818	137-5115-21,49-20	87003713	9500-3713
T51	90510819	137-5115-21-67,49-20	87003713	9500-3713
T51	90510361	137-5127-20,49-20	87003561	9500-3561
T51	90510790	137-5127-20-45,49-20	87003561	9500-3561
T51	90510873	137-5127-21,49-12	87003713	9500-3713
T51	90513747	137-5127-21,49-20	87003713	9500-3713
T51	90510395	137-5140-36,49-20	87003560	9500-3560
T51	90510362	137-5152-21,49-20	87003560	9500-3560
T51	90510341	137-6089,49-20	87003559	9500-3559
T51	90513813	137-6089-21,49-20	87003500	9500-3500
T51	90510773	137-6089-21-45,49-20	87003500	9500-3500
T51	90510696	137-6089-21-45-67,49-20	87003500	9500-3500
T51	90513814	137-6089-21-67,49-20	87003500	9500-3500
T51	90510391	137-6089-45,49-20	87003500	9500-3500
T51	90510380	137-6089-45-67,49-20	87003500	9500-3500
T51	90510343	137-6102,49-20	87003559	9500-3559
T51	90510824	137-6102-21,49-20	87003500	9500-3500
T51	90510825	137-6102-21-45,49-20	87003500	9500-3500
T51	90513756	137-6102-21-67,49-20	87003500	9500-3500
T51	90510415	137-6102-45,49-20	87003500	9500-3500
T51	90510379	137-6102-45-67,49-20	87003500	9500-3500
T51	90510346	137-6102-67,49-20	87003559	9500-3559
T51	90510344	137-6115,49-20	87003500	9500-3500
T51	90510874	137-6115-21,49-20	87003952	9500-3952
T51	90510826	137-6115-21-45,49-20	87003750	9500-3750
T51	90510655	137-6115-45,49-20	87003500	9500-3500
T51	90510407	137-6115-67,49-20	87003500	9500-3500
T51	90510406	137-6127,49-20	87003500	9500-3500
T51	90513815	137-6127-21,49-20	87003500	9500-3500
T51	90513757	137-6127-21-45,49-20	87003500	9500-3500
T51	90510656	137-6127-45,49-20	87003500	9500-3500
ST58				
ST58	90510522	151-5089-21,49-20	87003883	9500-3883
ST58	90510789	151-5102-21,49-20	87003713	9500-3713

Thread	Drill bit		Indexing template	
	Product No.	Product code	Product No.	Product code
ST58	90513754	151-5152-42-24,49-20	87003954	9500-3954
ST58	90510831	151-6089-21-36-67,49-20	87003500	9500-3500
ST58	90513887	151-6089-35-67,49-20	87003950	9500-3950
T60				
T60	90514298	157-5089-47-67,49-20	87003500	9500-3500
T60	90515778	157-5115-21,49-20	87003713	9500-3713
T60	90515472	157-6102-41,49-20	87004576	9500-4576
T60	90515474	157-6102-50-45,49-20	87004577	9500-4577
T60	90515481	157-6102-50-45-67,49-20	87004577	9500-4577
T60	90515478	157-6102-45-67,49-20	87004578	9500-4578
T60	90515470	157-6115-41,49-20	87004576	9500-4576
T60	90516063	157-6115-45,49-20	87004578	9500-4578
T60	90515477	157-6115-45-67,49-20	87004578	9500-4578
T60	90515452	157-6115-50-45,49-20	87004579	9500-4579
T60	90515484	157-6115-50-45-67,49-20	87004579	9500-4579
T60	90515431	157-6127-41,49-20	87004576	9500-4576
T60	90515449	157-6127-45-67,49-20	87004578	9500-4578
T60	90515476	157-6127-50-45,49-20	87004580	9500-4580
T60	90515485	157-6127-50-45-67,49-20	87004580	9500-4580
T60	90515450	157-6140-41,49-20	87004576	9500-4576
T60	90515475	157-6140-45-67,49-20	87004578	9500-4578
T60	90515467	157-6140-50-45,49-20	87004582	9500-4582
T60	90515486	157-6140-50-45-67,49-20	87004582	9500-4582
T60	90515473	157-6152-41,49-20	87004576	9500-4576
T60	90515420	157-6152-45-67,49-20	87004578	9500-4578
T60	90515468	157-6152-50-45,49-20	87004582	9500-4582
T60	90515487	157-6152-50-45-67,49-20	87004582	9500-4582
ST68				
ST68	90510494	152-5102-21,49-20	87003713	9500-3713
ST68	90510777	152-5102-21-67,49-20	87003713	9500-3713
ST68	90510701	152-5115-21-67,49-20	87003713	9500-3713
ST68	90509829	152-5115-36-20-67,39-06	87003500	9500-3500
Taper bit				
11° H22				
11°	90509966	179-9038-27-67,39-20	87003908	9500-3908
11°	90510119	179-9038-27-67,50-20	87003908	9500-3908
12° H22				
12°	90509841	177-9032-17-67,39-20	87003711	9500-3711
12°	90510698	177-9033-17,39-20	87003711	9500-3711
12°	90509842	177-9033-17-67,39-20	87003711	9500-3711
6° reaming bit				
6°	90510459	175-5064,39-20	87003501	9500-3501
6°	90510460	175-5076,39-20	87003563	9500-3563
6°	90510461	175-5089,39-20	87003560	9500-3560
12° reaming bit				
12°	90510174	187-5089-20,39-20	87003560	9500-3560
12°	90510468	187-5102,39-20	87003500	9500-3500
12°	90510469	187-5102-20,39-20	87003564	9500-3564
12°	90510470	187-5127,39-20	87003562	9500-3562

Secoroc Grind Matic X

Grinding machine for cross-type bits

Electrical specifications	Product No.	Product code
220 V 3-phase 50 Hz	87002499	9502-49
220 V 3-phase 60 Hz	87002507	2507
380 V 3-phase 50 Hz	87000608	9502-52
380 V 3-phase 60 Hz	87002508	9502-61
415 V 3-phase 50 Hz	87002502	9525
415 V 3-phase 60 Hz	87002509	9502-62
440 V 3-phase 60 Hz	87002510	9502-63

Accessories included in delivery

Flange washer
Mandrel, complete
Protective goggles
Wheel dresser
Operator's instructions and spare parts list

Grinding capacity

Maximum diameter of cross-type bit 64 mm (2¹⁷/₃₂"

Technical data Grind Matic X (380 V, 50 Hz)

Output 1,70 kW
Idling speed, 50 Hz 1400 r/min
Idling speed, 60 Hz 1680 r/min

Output, grinding device 0,37 kW
Automatic grinding action, 50 Hz 117 strokes/min
Automatic grinding action, 60 Hz 140 strokes/min

Grinding wheel, frontal grinding:
Maximum diameter 300 mm (11¹³/₁₆"
Maximum width 68 mm (2¹¹/₁₆"

Grinding wheel, gauge grinding:
Diameter 300 mm (11¹³/₁₆"
Width 32 mm (1¹/₄"

Weight, excluding packaging 235 kg (518 lb)
Weight, including packaging 360 kg (794 lb)

Grinding wheels

Refer to page 19

Bitholder and mandrel

Refer to page 19



Secoroc Grind Matic XR/XX

On request

Grind Matic X is ideal for fast, precision grinding of cross-type bits. The bit is locked firmly into the expander on the bitholder. All you have to do is move the bit towards the grinding wheel – the machine takes care of the rest.

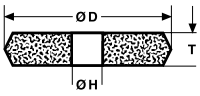
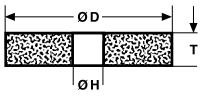
Grind Matic X comes as a fully self-contained unit in right-hand mount configuration.

Bitholders are available for different thread sizes.



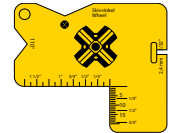
Grind Matic X comes with a tiltable bitholder making bit changing easy and safe.

Ceramic grinding wheels for cross-type bits

	Bit dimension	Dimension (D x T x H), mm	Product No.	Product code
	29 mm	300 x 19 x 32	87002619	9500-2619
	35 mm	300 x 23 x 32	87002594	9555
	38–41 mm	300 x 26 x 32	87002595	9556
	43 mm	300 x 28 x 32	87002618	9579
	45 mm	300 x 29 x 32	87002597	9558
	48–51 mm	300 x 32 x 32	87002616	9577
	57 mm	300 x 38 x 32	87002600	9561
	76 mm	300 x 52 x 32	87002603	9564
	Gauge grinding wheels			
	–	200 x 13 x 32	87002613	9574
	–	200 x 25 x 32	87002620	9587
	–	300 x 32 x 32	87002615	9576

Grinding template for cross-type bits

	Product No.	Product code
Cross-type bits	90002611	9102



Bitholders/Mandrels for cross-type bits



Bitholder	Product No.	Product code
Cross-type bits		
R22	87000580	9500-0580
R25	87000581	9500-0581
R28	87000582	9500-0582
R32	87000583	9500-0583
T38	87000584	9500-0584
T45	87000585	9500-0585
T51	87003275	9500-3275
Tapered bits		
22 mm rod, 7°	87000594	9500-0594
22 mm rod, 11°	87000640	9500-0640
22 mm rod, 12°	87000595	9500-0595
25 mm rod, 7°	87000596	9500-0596
25 mm rod, 11°	87000641	9500-0641
25 mm rod, 12°	87000597	9500-0597
28 mm rod, 12°	87000598	9500-0598

Mandrel	Product No.	Product code
Cross-type bits		
R22	87000329	9500-0329
R25	87000330	9500-0330
R28	87000331	9500-0331
R32	87000332	9500-0332
R38/T38	87000333	9500-0333
T45	87000334	9500-0334
T51	87003276	9500-3276
Tapered bits		
22 mm rod, 7°	87000346	9500-0346
22 mm rod, 11°	87000255	9500-0255
22 mm rod, 12°	87000345	9500-0345
25 mm rod, 11°	87000344	9500-0344
25 mm rod, 12°	87000347	9500-0347

Bitholder complete

If you frequently change bit size, we recommend our bitholders, including mandrel, mandrel holder, pull rod, rubber sleeves, thrust plate and locking handle.

Optional grinding mandrel

Grind Matic X comes with one optional grinding mandrel (870003xx / 9500-03xx) for one thread size and corresponding flange washer for the width of the grinding wheel. Additional grinding mandrels and flange washers are charged as extra accessories. Specify the thread and diameter of the bits to be reground. If you regularly change bit size, we recommend our complete range of bitholders.

Selection of flange washers for cross-type bits

For each bit size, you need an inner flange washer to align the grinding wheel correctly. The size of the flange washer corresponds to the thickness of the grinding wheel, which in turn corresponds to the diameter of the bit.

Example: Grinding a 45 mm cross-type bit requires a grinding wheel with a width of 29 mm. To align the wheel correctly, you need an inner flange washer, 87002632 (Product No.) / 9500-0235-29 (Product code).

Bit diameter	Grinding wheel width									
	19	21	23	26	29	32	35	38	40	52
29 mm										
31 mm										
35 mm										
38-41 mm										
43-45 mm										
48-51 mm										
57 mm										
76 mm										

Flange washers

Inner flange washers for centering of grinding wheels

Grinding wheels, width	Product No.	Product code
23 mm	87002627	9500-0235-23
26 mm	87002629	9500-0235-26
28 mm	87002631	9500-0235-28
29 mm	87002632	9500-0235-29
32 mm	87002634	9500-0235-32
38 mm	87002640	9500-0235-38
52 mm	87002649	9500-0235-52
68 mm	87002654	9500-0235-68

Secoroc Grind Matic Swing

Grinding machine for integrals

	Product No.	Product code
Grind Matic Swing	87002482	9544

Accessories included in delivery

- Grinding wheel Grind Master Soft
- Pin wrench
- Protective goggles
- Operator's instructions and spare parts list

Optional accessories	Product No.	Product code
Grinding wheel Grind Master Hard	87002589	9550
Grinding wheel Grind Master Soft	87002811	9500-2811
Chuck bushing wear gauge H19 (0,75")	90002667	9131
H22 (0,85")	90002668	9132
H25 (1")	90002669	9133

Technical data

Air pressure, max.	7 bar (101.5 psi)
Air consumption (at 6 bar, 86 psi)	1500 l/min
Cutting-edge angle	110°
Cutting-edge radius	80 mm (3 ⁵ / ₃₂ "
Gauge grinding arrangement included	
Hose connections, air	12,5 mm (1/2")
water	6,3 mm (1/4")
Idling speed	4080 r/min
Power output	1,10 kW
Size of grinding wheel	
D x T x H	125 x 63 x 32 mm (4 ⁷ / ₈ " x 2 ¹⁵ / ₃₂ " x 1 ¹ / ₄ "
DI x TI	80 x 50 mm (3 ⁵ / ₃₂ " x 2")
Spindle diameter	16 mm (5/8")
Weight incl. grinding wheel and 1,5 m water hose	27,5 kg (61 lb)

Grinding wheels

Refer to page 23



Grind Matic Swing for integral drill rods is quickly mounted by bolting it on to the rig or on to a work bench. It can also be placed on the side of the rig using old, worn out integral drill rods.

Dry grinding is carried out with a soft grinding wheel, while wet grinding uses a hard grinding wheel.

But remember, under no circumstances should you use a grinding wheel intended for wet grinding when the operation you're performing is dry grinding.

Grind Matic Swing has a fixed setting for

grinding, giving a cutting-edge angle of 110° and a cutting edge radius of 80 mm.

Frontal grinding

In frontal grinding, the integral drill must be locked in the pneumatic clamping device and the grinding machine swung to-and-fro while feeding is carried out using the feed screw.

Gauge grinding

In gauge grinding, the grinding device is locked and the integral drill rod rotated by hand against the grinding wheel.

Secoroc Grind Matic Senior

Grinding machine for integrals

Electrical specifications	Product No.	Product code
220 V 3-phase 50 Hz	87002485	9511-49
220 V 3-phase 60 Hz	87002493	9427
380 V 3-phase 50 Hz	87135402	9511-52
380 V 3-phase 60 Hz	87002494	9428
415 V 3-phase 50 Hz	87002488	9519
415 V 3-phase 60 Hz	87002495	9511-62
440 V 3-phase 60 Hz	87002496	0799-8151-63

Accessories included in delivery

Grease gun
Grinding wheel, Grind Master Hard
Protective goggles
Socket wrench
Wrench
Operator's instructions and spare parts list

Optional accessories	Product No.	Product code
Grinding wheels		
Grind Master Hard	87002591	9552
Grind Master Soft	87002813	9500-2813
Spacer plate		
for H19 integral	87000519	9500-0519
Chuck bushing wear guage		
H19 (0.75")	90002667	9131
H22 (0.85")	90002668	9132
H25 (1")	90002669	9133

Technical data

Air pressure, max.	7 bar (101.5 psi)
Cutting-edge angle, adjustable	90–130°
Grinding wheel	
D x T x H	200 x 102 x 32 mm (7 ⁷ / ₈ " x 4" x 1 ¹ / ₄ ")
DI x TI	150 x 80 mm (5 ⁷ / ₈ " x 3 ⁵ / ₃₂ ")
Cutting-edge radius, adjustable	80–130 mm (3 ⁵ / ₃₂ "–5 ¹ / ₈ ")
Idling speed, electric 50 Hz	2840 r/min
Idling speed, electric 60 Hz	1690 r/min
Output 3-phase	1,50 kW
Rod hex. max.	25 mm (1")
Weight excluding packaging	105 kg (232 lb)
Weight including packaging	120 kg (265 lb)
Transport dimension	L 800 x W 600 x H 650 mm (2'7 ¹ / ₂ " x 1'11 ⁵ / ₈ " x 2'1 ⁵ / ₈ ")

Grinding wheels

Refer to page 23



Grind Matic Senior is a sturdy and dependable stationary integral grinding machine with a pneumatic clamp designed for grinding larger volumes. Senior features an easily adjustable cutting edge radius and angle. The resettable feed wheel ensures that each flank is precision-ground.

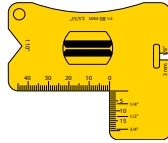
Grind Matic Senior grinding wheels are available for both wet grinding (hard grinding wheel) and dry grinding (soft grinding wheel).

Gauge grinding is performed with the swinging arm in a locked position and the integral drill rod rotated by hand against the grinding wheel.



Grinding template for Integral rods

	Product No.	Product code
Integral rods	90002610	9101



Ceramic grinding wheels for chisel bit

	Grinding machine	Dimension, mm		Product No.	Product code
		D x T x H (mm)	DI x TI (mm)		
	Grind Matic Swing	125 x 63 x 32	80 x 50, hard	87002589	9550
	"	125 x 63 x 32	80 x 50, soft	87002811	9500-2811
	Grind Matic Senior	200 x 102 x 32	150 x 80, hard	87002591	9552
	"	200 x 102 x 32	150 x 80, soft	87002813	9500-2813



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