



DROPON™ DIAMOND GRINDING HEADS

User Instructions

Inland DropOn™ grinding heads must be used with the Inland DropOn Adapter, Inland No. DB-ADP.

Safety

- It is extremely important to wear proper eye protection. We highly recommend that you wear safety goggles rather than safety glasses. You can also use the Inland [FaceShield™](#) or [MagnaShield™](#) in conjunction with proper eye wear for added protection. **NOTE:** A shield alone is not adequate eye protection.
- DO NOT wear loose clothing or any accessories (long necklaces, bracelets, shirts with long fringes, and similar) that might get caught by the grinder head while it is on your machine.

Installing and Changing Grinding Heads

1. Apply a generous amount of Inland [Motor Shaft Lubricant](#) or other non-water soluble grease to the inside of the DropOn bit sleeve and the outside of the DropOn Adapter. This seals debris from getting inside both parts.
2. Make sure the set screw on the adapter is screwed in enough to allow the sleeve to slide onto the adapter and then slide the diamond DropOn sleeve onto the adapter. The tiny "keybar" on the inside of the sleeve must align with the "keyway" groove on the adapter. Slide the sleeve all the way down onto the adapter.
3. Now install the adapter with the sleeve onto your machine. Loosen the set screw on the adapter using the allen wrench provided by turning it counterclockwise and slide onto the motor shaft so that the set screw sits over the flat side of the motor shaft. Do not force! It should slide on easily. Contact [customer service](#) at 1-800-521-8428, ext. 306 if you have problems.
4. Lower it down until just over 1/8" of the diamond is exposed above the work surface. This is the standard thickness of most glasses. If you are working with a thicker material, lower it down until the amount of diamond exposed above the work surface is slightly greater than the height of the material you are shaping. Secure the head to the shaft by turning the set screw clockwise with the allen wrench provided. **IMPORTANT:** Always secure the head to the flat side of the motor shaft. Tightening the head to the rounded side can scar the shaft and prevent head removal!

Changing Heads

The full size sleeves have the same amount of usable diamond surface as our standard diamond heads. Half size sleeves are an economical alternative when you occasionally need a special grit and don't want to invest in a full size head. Also, the 1" diameter and the 3/4" diameter sleeves fit on the same adapter making the DropOn bit system even more flexible and economical.

1. Once the adapter is installed you can change head sizes and grits by simply sliding off the sleeve in use and sliding on a new one. Make sure to coat the inside of the sleeve and the outside of the adapter with Motor Shaft Lubricant™ whenever you change sleeves.
2. When the exposed diamond no longer grinds efficiently, loosen the set screw and move the head on the motor shaft to expose a fresh section of diamond and re-secure.
3. Refer to your machine's owner's manual for how to use diamond grinding heads properly on your machine.

Helpful Tips

- If a white powder forms around the head as you grind, check both your sponge placement and the coolant level in the reservoir. If you are using a drilling head check to make sure your sponge is loaded with coolant and you are holding against both the diamond surface and your material.
- You will notice that grinding with smaller heads is slower than standard heads. This is due to the smaller diameter and is normal.
- Always tighten heads to the flat side of the motor shaft. Tightening to the round side can scar the shaft and prevent the head from being removed.
- Remove the grinding heads from your machine if you are not using it for long periods.
- You can use Inland [DiamondCoolant™](#) to help increase grinding efficiency and prolong life of your diamond grinding and drilling heads.



Grits and Uses

- SuperFine™ Grit - For very soft glasses, mirror or when the edge will be left exposed. Leaves a chip free edge.
- Fine Grit - For softer, more delicate glasses and mirror. Leaves a minimal chip line.
- Standard Grits - For normal grinding and drilling
- SpeedGrit™ - For fast removal of material and grinding out large areas.
- SuperSpeed™ Grit - For extremely fast and aggressive removal where the edge won't be seen or will be retouched with a finer grit head.
- SuperBond™ - Special brazed metal bonding holds the diamonds more secure to the core and provide the aggressive grinding of a single layer diamond tool for fast work.
- DoubleDiamond™ - Two layers of diamond that last more than twice as long as conventional heads

Service

If you have any questions or comments regarding the use of this or any Inland product please call Inland Customer Service at 1-800-521-8428 9 AM to 5 PM EST, email us at helpdesk@inlandcraft.com, or write us at:

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