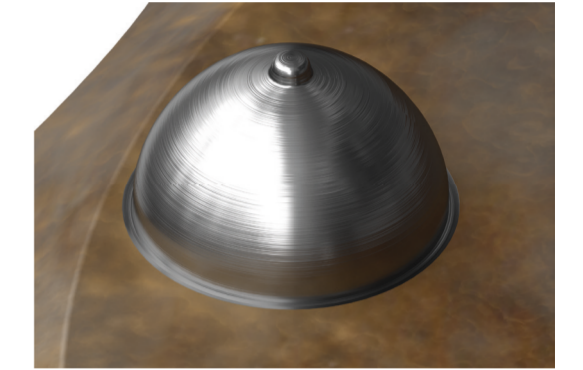
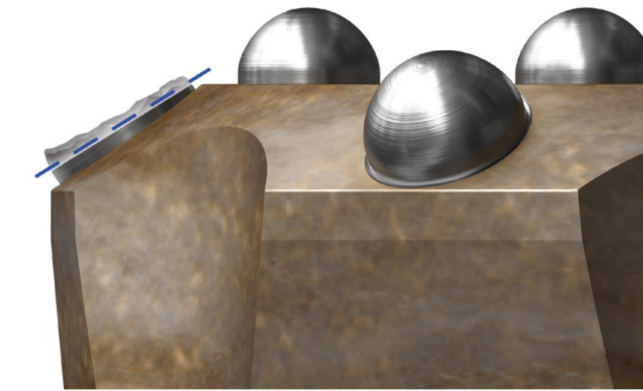
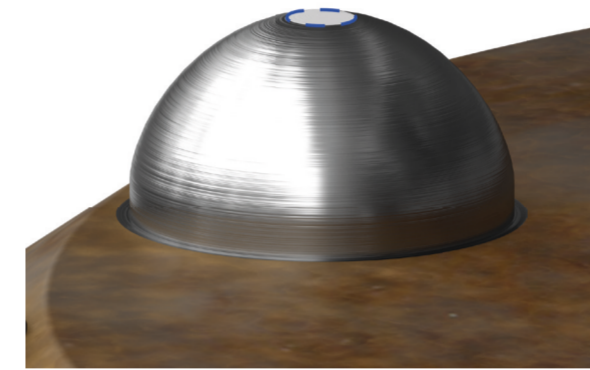
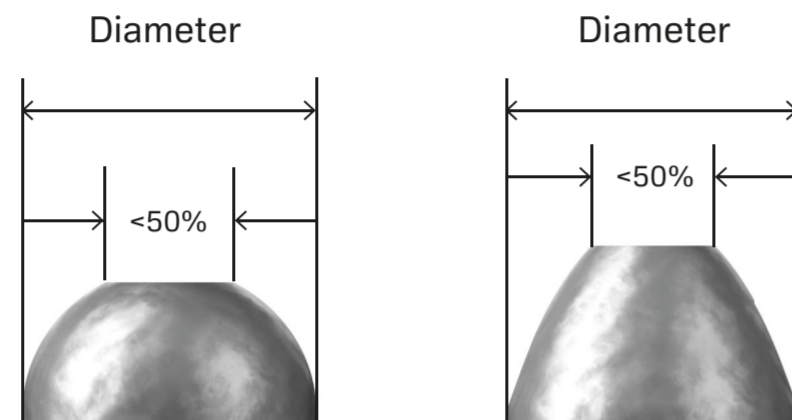


# Resharpener of button bits

Sandvik button bits are equipped with high-quality cemented carbide buttons that offer excellent wear resistance. However, once wear becomes visible, the bits should be resharpened at regular intervals to restore their original profile and maintain optimal drilling performance.



## Safety when resharpening

- Wear protective goggles
- Wear protective gloves
- Wear a dust mask
- Wear ear protectors
- Use water cooling (unless specialized air cooling is available)
- Clean and inspect the drill bit before resharpening to ensure no traces of explosives remain in the flushing holes
- Use Sandvik genuine parts to ensure safety and performance

## When to resharpen

Resharpener is recommended when the penetration rate drops noticeably, and before the wear-flat on the top of the buttons reaches 50% of the button's diameter. Timely resharpening is both practical and economical - it helps restore performance and reduces the risk of overloading the bit. Overloading can lead to premature breakage of both the buttons and the bit body steel.

## Frontal resharpening

Do not perform excessive resharpening or over-grind the buttons. Always leave a few millimeters of the original wear-flat on top of each button to preserve its profile and ensure optimal performance.

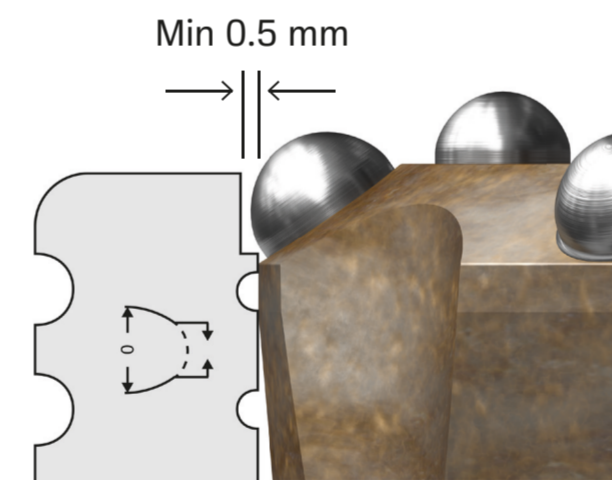
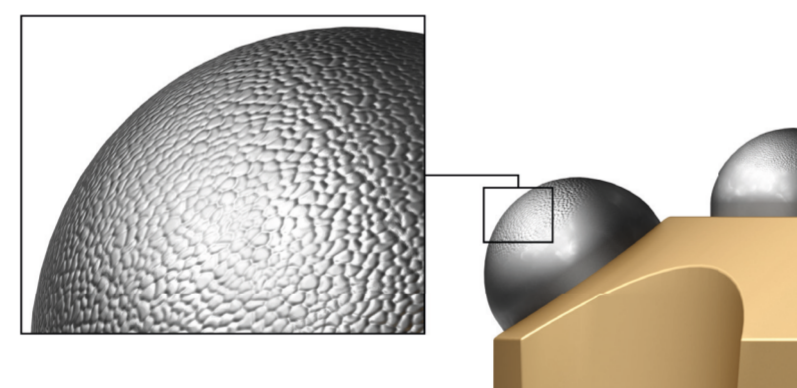
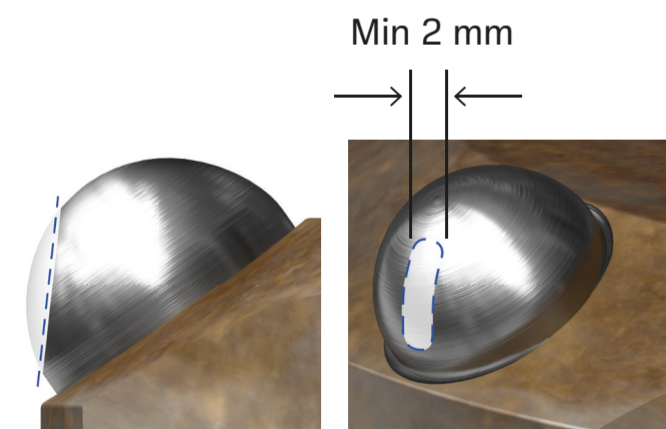
## Resharpen any broken buttons flat

A drill bit can be used as long as the gauge buttons are retaining the original bit diameter. If a button breaks, it should be ground down flat with the bit body. Leaving a broken button protruding can cause it to break apart further and damage the surrounding buttons.

## Tip formation on the top

If the button develops a tip formation after resharpening, it is time for dressing the grinding cups or removing the sediment deposits from the water flushing grooves of the cups.\*

\*Reach out to your Sandvik representative if problem is not resolved



## Gauge resharpening

Any anti-taper at the gauge buttons should be carefully ground away. However, avoid removing too much material from the outer sides of the buttons. It is recommended to leave approximately 2 millimeters of the original wear-flat intact to maintain proper overall bit diameter, and extend service life.

## Resharpener interval at little wear (snakeskin)

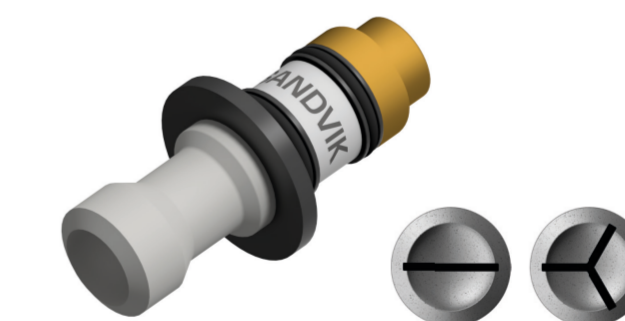
Sometimes microscopic fatigue cracks, known as "snakeskin", appears on the buttons. These cracks must be ground off immediately. Even if penetration rates remain normal and there are no visible signs of wear, the buttons should be resharpened at regular drill meter intervals.\* If not, these micro-cracks can deepen and cause the buttons to break.

Establish a resharpening schedule that fits your operation - after a fixed number of drilled holes or at the end of each shift. Resharpener on time, or slightly too early, is more cost-effective and reduces the risk of button failure.

\*Drill meter intervals differs depending on bit sizes and profile.

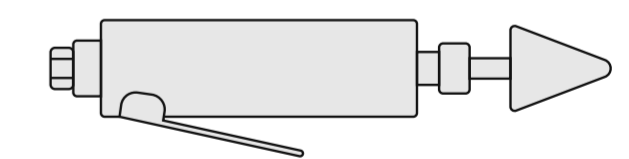
## Resharpener of gauge button steel

If needed, grind away some of the steel just below the gauge buttons to maintain a clearance of approximately 0.5 mm. Ideally, this should be done with a slight clearance angle to support proper flushing and reduce wear on the bit.



## Grinding cups

Sandvik offers grinding cups designed for both super-spherical and semi-ballistic buttons.



## Open the flushing holes

If the flushing holes or cuttings grooves become deformed, use a small grinding wheel or rotary burr to carefully reopen them.