



## How to Improve the Safety of High-Speed Cutters-to change the clamp way

Simulation calculation and cracking test shows that high-speed cutter is not suitable for friction clamping, but a clamping way with central hole or screw clamping, or tool structure with special designed inserts to prevent being thrown off. The direction clamping force of cutter holder and cutter should be consistent with that of centrifugal force of cutters, pretightening force of screws should be controlled, to avoid the damage caused by overload. For shank cutter with small diameter, it can be used hydraulic collet chuck or thermal expansion and contraction collet chuck to achieve high precision and high rigidity of clamping.

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