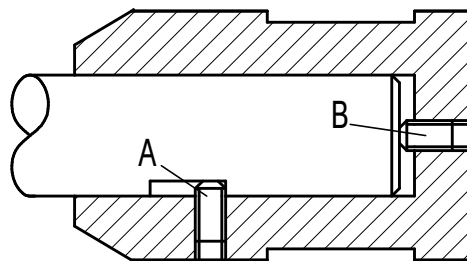


Sk.1. TYPICAL CHUCK FOR SCREWED SHANK END MILLS



SCREW A IS LIGHTLY TIGHTENED ONTO THE CUTTER'S FLAT AND SCREW B THEN USED TO MOVE THE CUTTER FORWARD SO THAT SCREW A RESTS AGAINST THE END OF THE CUTTER'S FLAT, AS SHOWN.

SCREW A IS THEN TIGHTENED FULLY AND SCREW B JUST LIGHTLY. THE CUTTER CANNOT THEN MOVE OUT OF THE ADAPTOR DUE TO THE FORCES CREATED BY THE HELICAL CUTTING ACTION.

Sk.2. ADAPTOR FOR NON THREADED SHANK END MILLS