



## Press release Unshrinking Device 03/06

### Unshrinking if cutters break

***Very often if a cutter breaks during machining, hardly any of it is left protruding from the chuck, there is just a stump that cannot be gripped. Haimer has developed a special device to cope with this problem, one that makes it simple to remove the stump from the shrink fit chuck.***

- 10 The Haimer unshrinking device is a simple but effective aid for unshrinking broken cutters. What usually happens after a collision is that the stump of the cutter left in the shrink fit chuck cannot be gripped and it is often so tightly stuck that it does not just slip out of the chuck of its own accord, even if heated. In such cases the operator has to actively help to remove the stump. The easiest thing to do here is to use the new unshrinking device that Haimer offers as an optional accessory. It is kept in a swivel drawer in the work area of the Power Clamp shrink fit machine and can be used whenever it is
- 20 needed.

- The principle is as simple as it is effective. Instead of using the usual adapter disk for mounting the chuck, an unshrink device is inserted in the shrink fit machine. The operator clamps a mandrel into this. The mandrels come in six different sizes – two lengths, three diameters – that will fit each chuck size. Next the operator slips the shrink fit chuck over the mandrel in such a way that the cutter shank is seated. The chuck is then heated inductively as usual. As soon the shrinking temperature is reached and the shank has expanded, the chuck's own weight
- 30 makes it slip down of its own accord and the cutter stump falls

out of the top. If it sticks, the operator can help quite simply by hand. A rubber mat is attached to the base of the device that prevents the chuck from being damaged when it slips down. It cannot fall off the unshrinking device because it is held vertically by the mandrel. When the unshrinking procedure is completed, the operator puts the appropriate cooling element on the chuck, it cools down, all finished.



40 **B1\_Unshrinking device.jpg**

*The unshrinking device replaces the adapter disk that is normally used for mounting the chuck. Next the chuck is slipped over the mandrel. Illustration: Haimer*



**B2\_Unshrinking device with spool.jpg**

The chuck is slipped over the mandrel and heated inductively. When the shrinking temperature is reached, the chuck releases the stump of the cutter and slips down onto the rubber mat.

50 Illustration: Haimer



***B3\_Unshrinking device in swivel drawer.jpg:***

*The unshrinking device is kept in a swivel drawer in the work area of the Power Clamp shrink fit machine. There are six different mandrels available. Illustration: Haimer*

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Please find further information at [www.haimer.de](http://www.haimer.de) or give us a call by dialling: +49 (0) 82 57 / 99 88-0.

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