

BALANCE-CUT BORING ARBOR (RAC-E)



Rough Boring — For Steel, Stainless Steel and Cast Iron
CC Insert (Positive type)



RAC-E

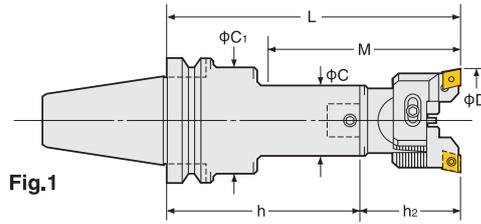


Fig.1

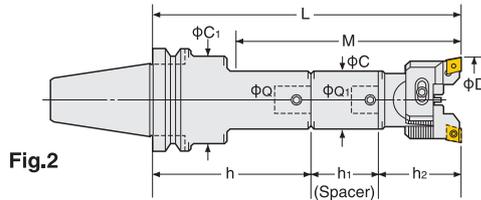
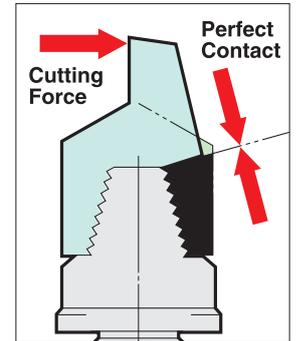


Fig.2

Power of Shoulder Support



TAPER	Code No.	Boring Range D	Boring Depth M	Cupling Dia Q	C	C ₁	Shank Code No.	Spacer Code No.	P.12		Weight (kg)	Fig
									Head Code No.	Tip No.		
No.40	BT40-RAC 25-135E	25~32	67	12	24	35	BT40-Q12- 80	—	12-RAC 25- 55E	CC07-C	2.0	1
	(IT40) -165E		105				-Q12-110				2.1	
	-180E		112				-Q12- 80				2.1	
	-RAC 32-150E	32~45	77	16	31	42	-Q16- 95	—	16-RAC 32- 55E	CC08-C	2.4	1
	-180E		110				-Q16-125				2.6	
	-195E		122				-Q16- 95				2.6	
	-RAC 43-150E	43~55	97	20	40	50	-Q20- 80	—	20-RAC 43- 70E	—	2.7	1
	-180E		130				-Q20-110				2.9	
	-210E		157				-Q20- 80				3.2	
	-RAC 53-165E	53~70	135	26	50	64	-Q26- 95	—	26-RAC 53- 70E	CC12-C	2.5	1
	-210E		180				-Q26-140				3.3	
	-225E		195				-Q26- 95				3.2	
	-RAC 70-180E	70~100	180	34	64	64	-Q34- 95	—	34-RAC 70- 85E	—	4.8	1
	-195E		195				-Q34-110				5.2	
	-240E		240				-Q34- 95				6.2	
	-RAC100-195E	100~130	195	42	83	62	-Q42- 95	—	42-RAC100-100E	—	6.8	1

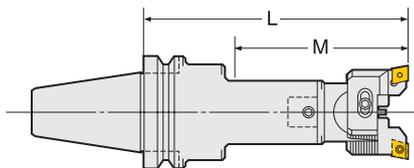
★“C” grade (Coated) inserts are supplied as standard with the head. P.12 Please refer P.85 for cutting condition.

★Please refer P.37 for base holder, P.38 for spacer and P.19 for head.

★For centre through tool coolant type, please add “-C” at the end of Code No. e.g. BT40-RAC53-165E-C

★When L length is required longer than standard, please specify the boring depth M.

★BT30 is a modular type. Please refer to P.37 for the base holder.



High Pressure Coolant Through Tool

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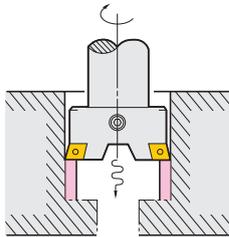


Balance cut boring bar executes boring in 2 cartridge inserts absorbing the vibration each other. The faster the feed rate, the better swarf ejection. This is ideal for rough and medium boring.

Double Cutting Capability

Please use RAC-K for through hole boring.

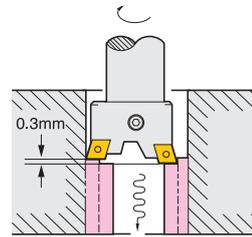
☞ P.17, P.18



Example of 2 Stepped Balance Cut

Approx. double removal of below cutting condition is possible by **-0.3 Cartridge**.

☞ P.20



TAPER	Code No.	Boring Range D	Boring Depth M	Cupling Dia Q	C	C ₁	Shank Code No.	Spacer Code No.	P.12		Weight (kg)	Fig
									Head Code No.	Tip No.		
No.50	BT50-RAC 25-150E	25~ 32	67	12	24	44	BT50-Q12- 95	—	12-RAC 25- 55E	CC07-C	4.7	1
	(IT50) -180E		105				-Q12-125				4.9	
	-195E		112				-Q12- 95				4.8	
	-RAC 32-180E	32~ 45	77	16	31	50	-Q16-125N	—	16-RAC 32- 55E	CC08-C	5.4	1
	-210E		110				-Q16-155				5.6	
	-225E		122				-Q16-125N				5.6	
	-RAC 43-180E	43~ 55	97	20	40	60	-Q20-110	—	20-RAC 43- 70E	—	5.7	1
	-195E		130				-Q20-125				5.8	
	-225E		142				-Q20-110				6.1	
	-240E	53~ 70	157	26	50	65	-Q26-140	—	26-RAC 53- 70E	—	6.2	2
	-RAC 53-210E		117				-Q26-170N				6.9	
	-240E		182				-Q26-140				7.0	
	-270E	70~100	177	34	64	80	-Q34-170	—	34-RAC 70- 85E	—	7.6	1
	-RAC 70-255E		205				-Q34-200				9.5	
	-285E		235				-Q34-170				9.9	
	-315E	100~130	265	42	83	83	-Q42-125	—	42-RAC100-100E	—	10.9	2
	-RAC100-225E		225				-Q42-190				12.5	
	-290E		290				-Q42-225A				15.2	
-325E		325								16.5	2	

★“C” grade (Coated) inserts are supplied as standard with the head. ☞ P.12 Please refer ☞ P.85 for cutting condition.

★Please refer ☞ P.37 for base holder, ☞ P.38 for spacer and ☞ P.19 for head.

★For centre through tool coolant type, please add “-C” at the end of Code No. e.g. BT50-RAC53-210E-C

★BT50-RAC100-375E, 425E and 475E are also available.

Insert tip for RAC-E

● : best ○ : good

Material	Steel		Stainless Steel		Cast Iron		Aluminium	
	Coated Carbide M	Coated Carbide K						
	Grade	C	Grade	C	Grade	C	Grade	C
Material	AC630M	AC410K	Material	AC630M	AC410K	Material	AC630M	AC410K
RAC025E	CC07-○4	0.4	●	●				
	CC07-○8	0.8	●	●				
RAC25E(CC08), RAC32E	CC08-○4	0.4	●	●				
	CC08-○8	0.8	●	●				
RAC43E - RAC530E	CC12-○4	0.4	●	●				
	CC12-○8	0.8	●	●				

Please add the grade indication into ○, and add the insert tip material indication at the end of the Code No. e.g. CC12-C8 (AC630M)

★Minimum order quantity : 10pcs.