

HSK BALANCE-CUT BORING ARBOR (RAC)

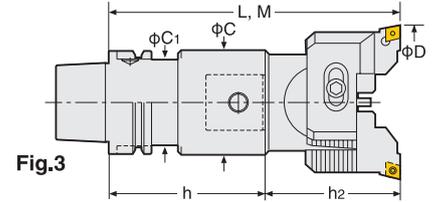
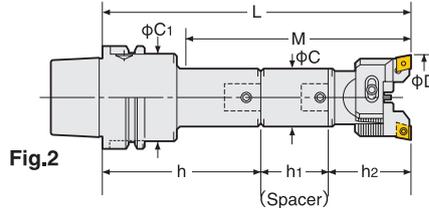
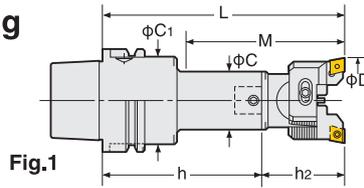
NIKKEN

Rough Boring — For Heavy Duty Boring of Iron and Cast Iron
CN Insert (Negative type)



Heavy Duty Boring

RAC



TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.	P.66		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK63A	HSK 63A-RAC43-150	43~55	97	40	50	HSK 63A-Q20- 80	—	20-RAC 43- 70	CN08-C	2.4	1
	-180		130			—	2.6				
	-210		157			SP20-20-60	2.9			2	
	-RAC53-165	53~70	135	53	-Q26- 95	—	26-RAC 53- 70	CN08-C	2.2	1	
	-210		180		-Q26-140	—			3.0		
	-225		195		-Q26- 95	SP26-26-60			2.9		2
	-RAC70-180	70~100	180	64	-Q34- 95	—	34-RAC 70- 85	CN08-C	4.5	3	
	-195		195		-Q34-110	—			4.9		
	-240		240		-Q34- 95	SP34-34-60			5.9		
	-RAC100-195	100~130	195	83	-Q42- 95	—	42-RAC100-100	—	6.5		

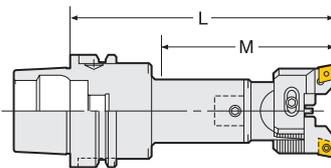
★“C” grade (Coated) inserts are supplied as standard with the head. P.66 Please refer P.85 for cutting condition.

★Please refer P.79 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. HSK63A-RAC53-165-C

★For HSK40A or 50A, modular connection system is applied. Please refer P.79 for Base Holder.

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



High Pressure Coolant Through Tool

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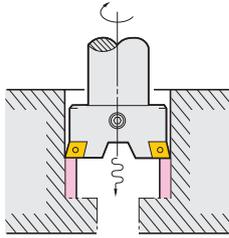


Balance cut boring bar executes boring in 2 cartridge inserts absorbing the vibration each other. The faster the feed rate, the better swarf ejection. This is ideal for rough and medium boring.

Double Cutting Capability

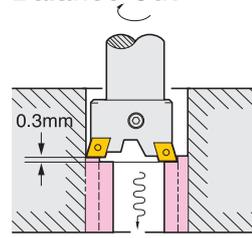
Please use RAC-K for through hole boring.

☞ P.69, P.70



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	C	C ₁	Shank Code No.	Spacer Code No.	P.66		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK100A	HSK100A-RAC 43-180	43~55	97	40	60	HSK100A-Q20-110	—	20-RAC 43- 70	CN08-C	4.9	1
	-195		130			-Q20-125				5.0	
	225		142			-Q20-110				5.3	
	-240		157			-Q20-110				5.4	
	-RAC 53-210	53~70	117	53	65	-Q26-140	—	26-RAC 53- 70	CN08-C	6.1	1
	-240		182			-Q26-170N				6.2	
	-270		177			-Q26-140				6.8	
	-RAC 70-255	70~100	202	64	80	-Q34-170	—	34-RAC 70- 85	CN08-C	8.7	1
	-285		232			-Q34-200				9.1	
	-315		262			-Q34-170				10.1	
	-RAC100-225		225			-Q42-125				11.7	
	-290	100~130	290	83	83	-Q42-190	—	42-RAC100-100	CN08-C	11.7	1
	-315		315			-Q42-125				15.1	

- ★“C” grade (Coated) inserts are supplied as standard with the head. ☞ P.66 Please refer ☞ P.85 for cutting condition.
- ★Please refer ☞ P.79 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. HSK100A-RAC53-210-C
- ★For HSK40A or 50A, modular connection system is applied. Please refer ☞ P.79 for Base Holder.
- ★HSK100A-RAC100-375, 425 and 475 are also available.
- ★Code No. of RAC25 and RAC32 with CC inserts are changed to RAC25E and RAC32E. Please refer ☞ P.63, P.64

Insert tip for RAC for Heavy Duty Boring

Material	Steel	●	
	Stainless Steel	●	
Material	Cast Iron	●	
	Aluminium	●	
		Coated Carbide M	
		Grade	
		C	
		Material	
		AC630M	
Applicable Arbor	Dimension	Code No.	Nose R
RAC43 - RAC530	 (CNMM120408)	CN08-○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. CN08-C8(AC630M)

- ★Minimum order quantity : 10pcs.
- ★When CN08 insert (CN○1204○) in the market is used, please use the eccentric bolt type cartridge (S.RCC-○Q)
- ☞ P.82. Nikken CN08-○8 insert can be used on the eccentric bolt type cartridge.

HSK