

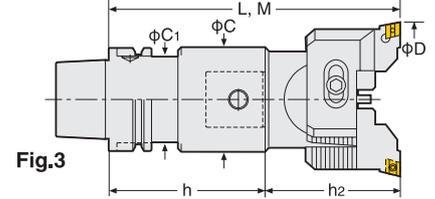
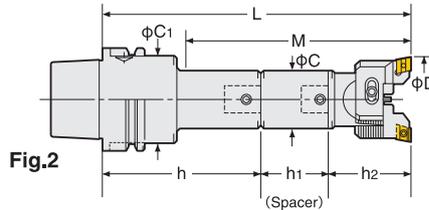
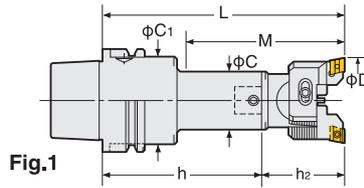
HSK BALANCE-CUT BORING ARBOR (RAC-A)

NIKKEN

Rough Boring—For Aluminium

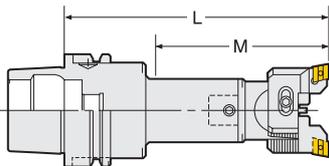


RAC-A



TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.	P.68		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK63A	HSK 63A-RAC25-135A	25~32	67	15	24	HSK 63A-Q12- 80	—	12-RAC 25- 55A	AEG12	1.7	1
	-165A		105			-Q12-110	—			1.8	
	-180A		112			-Q12- 80	SP12-12-45			1.8	
	-RAC32-150A	32~45	77	19	30	-Q16- 95	—	16-RAC 32- 55A	AEG12	2.1	1
	-180A		110			-Q16-125	—			2.3	
	-195A		122			-Q16- 95	SP16-16-45			2.3	
	-RAC43-150A	43~55	97	40	50	-Q20- 80	—	20-RAC 43- 70A	AEG16	2.4	1
	-180A		130			-Q20-110	—			2.6	
	-210A		157			-Q20- 80	SP20-20-60			2.9	
	-RAC53-165A	53~70	135	53	50	-Q26- 95	—	26-RAC 53- 70A	AEG16	2.2	1
	-210A		180			-Q26-140	—			3.0	
	-225A		195			-Q26- 95	SP26-26-60			2.9	
	-RAC70-180A	70~100	180	64	52.4	-Q34- 95	—	34-RAC 70- 85A	AEG16	4.5	3
	-195A		195			-Q34-110	—			4.9	
	-240A		240			-Q34- 95	SP34-34-60			5.9	
	-RAC100-195A	100~130	195	83	—	-Q42- 95	—	42-RAC100-100A	—	6.5	—

- ★“F” grade inserts are supplied as standard with the head. P.68 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-RAC53-165A-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.



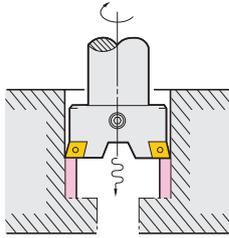
High Pressure Coolant Through Tool

HSK BALANCE-CUT BORING ARBOR (RAC-A)

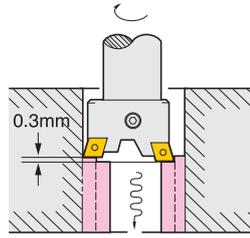


Balance cut boring bar executes boring in 2 cartridge inserts absorbing the vibration each other. The faster the feed rate, the better swarf ejection. This is Ideal for rough and medium boring.

Double Cutting Capability



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.68		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK100A	HSK100A-RAC 25-150A	25~32	67	15	24	HSK100A-Q12- 95	—	12-RAC 25- 55A	AEG12	3.9	1
	-180A		105			-Q12-125				4.1	
	-195A		112			-Q12- 95				4.0	2
	-RAC 32-180A	32~45	77	31	50	-Q16-125N	—	16-RAC 32- 55A	AEG12	4.6	1
	-210A		110			-Q16-155				4.8	
	-225A		122			-Q16-125N				4.8	2
	-RAC 43-180A	43~55	97	40	60	-Q20-110	—	20-RAC 43- 70A	AEG16	4.9	1
	-195A		130			-Q20-125				5.0	
	225A		142			-Q20-110				5.3	2
	-240A		157			-Q20-110				5.4	
	-RAC 53-210A	53~70	117	53	65	-Q26-140	—	26-RAC 53- 70A	AEG16	6.1	1
	-240A		182			-Q26-170N				6.2	
	-270A		177			-Q26-140				6.8	2
	-RAC 70-255A	70~100	202	64	80	-Q34-170	—	34-RAC 70- 85A	AEG16	8.7	1
	-285A		232			-Q34-200				9.1	
	-315A		262			-Q34-170				10.1	2
	-RAC100-225A	100~130	225	83	83	-Q42-125	—	42-RAC100-100A	AEG16	11.7	1
	-290A		290			-Q42-190				11.7	
-315A	315		-Q42-125			15.1				2	

- ★“F” grade inserts are supplied as standard with the head. ☞ P.68 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-RAC53-210A-C
- ★For HSK40A or 50A, modular connection system is applied. Please refer ☞ P.79 for Base Holder.
- ★HSK100A-RAC100-375A, 425A and 475A are also available.

Insert tip for RAC-A

Material	Steel		Code No.	Material	Grade
	Stainless Steel	Cast Iron			
Material	Aluminium		AEG12-○1	Coated Carbide K	F
Applicable Arbor	Dimension		Nose R	Material	Grade
RAC25A, RAC32A		(AEGT090304L)	0.1	●	●
			0.2	●	●
			0.4	●	●
RAC43A-RAC530A		(AEGT150304L)	0.1	●	●
			0.2	●	●
			0.4	●	●

Please add the grade indication into ○, and add the insert tip material indication at the end off the Code No. e.g. AEG16-F2 (KW10)

★Minimum order quantity : 10pcs.

HSK