

CARTRIDGE for RAC BORING HEAD

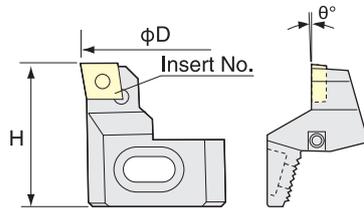


RAC Base () is common for all types of cartridges.
Please select suitable cartridge and insert tip for your application such as material and machining.

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



S.RCC-E Cartridge



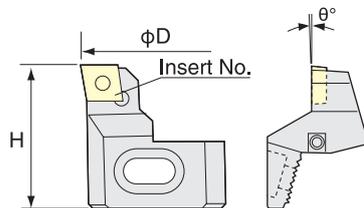
Set Code No.	Boring Range D	H	θ	Insert Code No.	
				Steel, Stainless Steel	Cast Iron
S.RCC- 25E	25 ~ 32	41	0°	CC08-C (AC630M)	CC08-C (AC410K)
				CC07-C (AC630M)	CC07-C (AC410K)
- 32E	32 ~ 45	41	+3°	CC08-C (AC630M)	CC08-C (AC410K)
- 43E	43 ~ 55	46		CC12-C (AC630M)	CC12-C (AC410K)
- 53E	53 ~ 70	50			
- 70E	70 ~ 100	55			
-100E	100 ~ 130	57			

★Insert tips are supplied as an option.
☞ P.12 Please refer ☞ P.85 for cutting condition.
★Please order set of cartridges. e.g S.RCC-70E
★2 stepped balance cut with H=0.3 cartridge is also available. e.g. S.RCC-70E (0.3)

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



S.RCC Cartridge



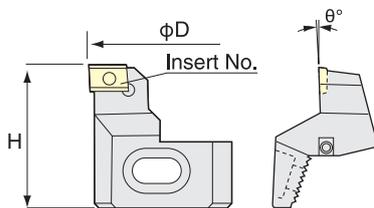
Set Code No.	D	H	θ	Insert Code No.	
				Iron and Cast Iron	
S.RCC- 43	43 ~ 55	46	-3°	CN08	
- 53	53 ~ 70	50			
- 70	70 ~ 100	55			
-100	100 ~ 130	57			

★Insert tips are supplied as an option.
☞ P.14 Please refer ☞ P.85 for cutting condition.
★Please order set of cartridges. e.g S.RCC-70
★When CN08 insert (CN00120400) in the market is used, please use the eccentric bolt type cartridge (S.RCC-00Q) ☞ P.89. Nikken CN08-08 insert can be used on the eccentric bolt type cartridge.
★2 stepped balance cut with H=0.3 cartridge is also available. e.g. S.RCC-70 (0.3)

For Aluminum



S.RCC-A Cartridge



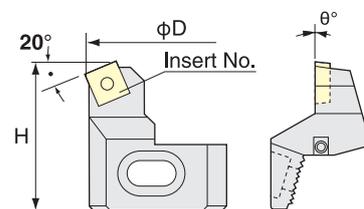
Set Code No.	D	H	θ	Insert Code No.	
				For Aluminum	
S.RCC- 25A	25 ~ 32	38	+6°	AEG12	
- 32A	32 ~ 45	41			
- 43A	43 ~ 55	46			
- 53A	53 ~ 70	50		AEG16	
- 70A	70 ~ 100	55			
-100A	100 ~ 130	57			

★Insert tips are supplied as an option.
☞ P.16 Please refer ☞ P.85 for cutting condition.
★Please order set of cartridges. e.g S.RCC-70A
★2 stepped balance cut with H=0.3 cartridge is also available. e.g. S.RCC-70A (0.3)
★S.RCC-A cartridge can be used for the bottom face finishing of iron and cast iron.

For Through Hole and Multi Sheets



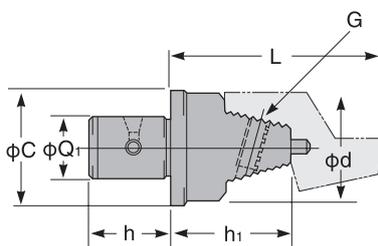
S.RCC-K Cartridge



Set Code No.	D	H	θ	Insert Code No.	
				Steel, Stainless Steel	Cast Iron
S.RCC- 25K	25 ~ 32	41	0°	SC09-C (AC630M)	SC09-C (AC410K)
- 32K	32 ~ 45			SC12-C (AC630M)	SC12-C (AC410K)
- 43K	43 ~ 55	46			
- 53K	53 ~ 70	50			
- 70K	70 ~ 100	55			
-100K	100 ~ 130	57			

★Insert tips are supplied as an option.
☞ P.18 Please refer ☞ P.85 for cutting condition.
★Please order set of cartridges. e.g S.RCC-70E

Dimension of RAC Base



Code No.	Boring Range	h	h ₁	C	G	d
	D					
12-RAC 25- 55B	25~33	18	31	24	M5	23
12-RAC025- 55B						
16-RAC 32- 55B	32~45	22	31	31	M6	30
20-RAC 43- 70B	43~55	24	42	40		35
26-RAC 53- 70B	53~70	28	40	50	M8	45
26-RAC 70- 70B						38
34-RAC 70- 85B	70~100	36	53	64		60
42-RAC100-100B						66
	100~130	42	66	83		

★Dimension "L" is "58mm" in combination of RCC-25K and 12-RAC25-55B.
★For centre through tool coolant type except 26-RAC70-70B, please add "-C" at the end of Code No. e.g. 34-RAC70-85B-C