

RAC BALANCE-CUT BORING ARBOR CUTTING DATA



CC (Positive type) RAC-E



CN (Negative type) RAC



RAC-A



RAC-K



Material

Steel 60~150m/mim. (Dry or Wet cutting)

Stainless Steel 40~80m/mim. (Wet cutting)

Cast Iron 60~150m/mim. (Dry or Wet cutting)

Aluminium, Non-ferrous metal 200~500m/mim. (Wet cutting)

Multiple Sheets, Through Hole 40~120m/mim. (Dry or Wet cutting)

Recommended cutting Speed

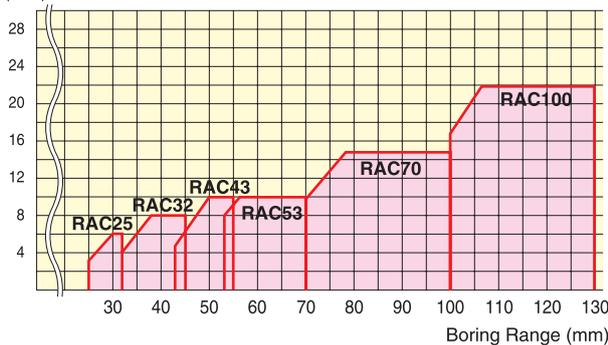
◎...Best ○...Good ---...Unsuitable

Insert		SS41	S55C	SCM	SKD	SC	FC,FCD	SUS	AL,ALC	Interrupted Cutting
Code No.	Grade									
CC	Coated Carbide M	◎	◎	◎	◎	○	○	◎	—	○
	Coated Carbide K	—	—	—	—	◎	◎	—	—	—
CN	Coated Carbide M	○	○	○	○	○	○	○	—	○
AEG	K10	—	—	—	—	—	—	—	◎	○
SC	Coated Carbide M	◎	◎	◎	◎	○	○	◎	—	○
	Coated Carbide K	—	—	—	—	◎	◎	—	—	—

- ★The cutting speed is recommended to be reduced to 50% for the interrupted cutting.
- ★When L/D is longer, the insert tip with small Nose R is recommended.
- ★When L/D is longer, the feed rate at the entrance is recommended to be reduced to 60 to 70%.

Relation between Boring Dia. & MAX. Removal

MAX. Removal on Dia. (mm)



Recommended Cutting Condition (removal, feed)

These figures are based on the application of L/D=3~3.5 times on cast iron.

Boring Range	Type	Best Condition		MAX. Condition	
		Removal mm/φ	Feed mm/rev.	Removal mm/φ	Feed mm/rev.
φ25~ 32	RAC 25	2.0~ 4.0	0.2~0.3	0.5~ 6.0	0.1~0.4
32~ 43	RAC 32	3.0~ 5.0	0.2~0.3	1.0~ 8.0	0.1~0.4
43~ 53	RAC 43	4.0~ 7.0	0.2~0.3	1.0~10.0	0.1~0.5
53~ 70	RAC 53	4.0~ 7.0	0.2~0.3	1.0~10.0	0.1~0.5
70~100	RAC 70	5.0~10.0	0.3~0.4	1.0~15.0	0.1~0.5
100~130	RAC100	7.0~12.0	0.3~0.4	1.0~22.0	0.1~0.5

PARTS LIST
INSERT TIP