

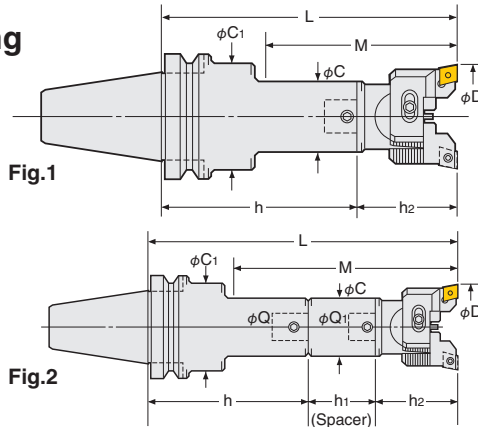
BALANCE-CUT BORING ARBOR (RAC)

NIKKEN

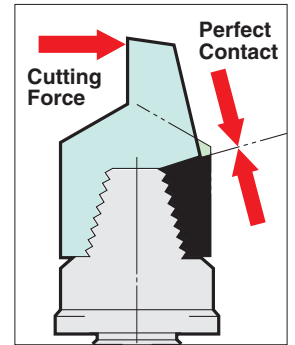
Rough Boring— For Heavy Duty Boring of Iron and Cast Iron
CN Insert (Negative type)



Heavy Duty Boring

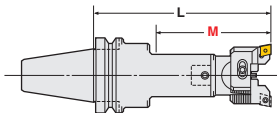


Power of Shoulder Support



TAPER	Code No.	Boring Range D	Boring Depth M	Coupling Dia Q	C	C ₁	Shank Code No.	Spacer Code No.	P.80		Weight (kg)	Fig
									Head Code No.	Tip No.		
No.40	BT40-RAC 43-150	43~55	97	20	40	50	BT40-Q20- 80	—	20-RAC 43- 70	CN08-C	2.7	1
	(IT40) -180		130				-Q20-110	—			2.9	
	-210		157				-Q20- 80	SP20-20-60			3.2	
	-RAC 53-165	53~70	135	26	50	-Q26- 95	—	26-RAC 53- 70	2.5	1		
	-210		180			-Q26-140	—		3.3			
	-225		195			-Q26- 95	SP26-26-60		3.2			
	-RAC 70-180	70~100	180	34	64	-Q34- 95	—	34-RAC 70- 85	4.8	1		
	-195		195			-Q34-110	—		5.2			
	-240		240			-Q34- 95	SP34-34-60		6.2			
	-RAC100-195	100~130	195	42	83	62	-Q42- 95	—	42-RAC100-100	6.8	1	

- ★“C” grade (Coated) inserts are supplied as standard with the head. P.80 Please refer P.124 for cutting condition.
- ★Please refer P.107 for base holder, P.108 for spacer and P.85 for head.
- ★For centre through coolant type, please add “-C” at the end of Code No. e.g. BT40-RAC53-165-C
- ★When L length is required longer than standard, please specify the boring depth M.



★Code No. of RAC25 and RAC32 with CC inserts are changed to RAC25E and RAC32E. Please refer P.77, P.78



High Pressure Coolant Through Tool

BALANCE-CUT BORING ARBOR (RAC)

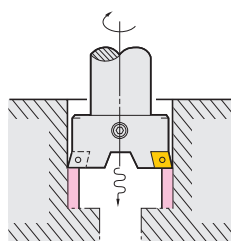
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Balance cut boring bar executes boring in 2 cartridge inserts absorbing the vibration each other. The faster the feed rate, the better swarf ejection. This is ideal for rough and medium boring.

Double Cutting Capability

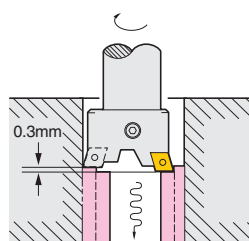
Please use RAC-K for through hole boring.

☞ P.83, P.84



Example of 2 Stepped Balance Cut

Approx. double removal of below cutting condition is possible by -0.3 Cartridge. ☞ P.86



TAPER	Code No.	Boring Range D	Boring Depth M	Coupling Dia Q	C	C ₁	Shank Code No.	Spacer Code No.	P.80		Weight (kg)	Fig
									Head Code No.	Tip No.		
No.50	BT50-RAC 43-180	43~ 55	97	20	40	60	BT50-Q20-110	—	20-RAC 43- 70	CN08-C	5.7	1
	(IT50) -195		130				-Q20-125					
	-225		142				-Q20-110					6.1
	-240		157				SP20-20-45					6.2
	-RAC 53-210	53~ 70	117	26	50	65	-Q26-140	—	26-RAC 53- 70	CN08-C	6.9	1
	-240		182				-Q26-170N					
	-270		177				-Q26-140					7.6
	-RAC 70-255	70~100	205	34	64	80	-Q34-170	—	34-RAC 70- 85	CN08-C	9.5	1
	-285		235				-Q34-200					
	-315		265				-Q34-170					10.9
	-RAC100-225	100~130	225	42	83	83	-Q42-125	SP34-34-60	42-RAC100-100	CN08-C	12.5	1
	-290		290				-Q42-190					
	-325		325				-Q42-225A					16.5
	-325		325				-Q42-225A					16.5

★“C” grade (Coated) inserts are supplied as standard with the head. ☞ P.80 Please refer ☞ P.124 for cutting condition. ★Code No. of RAC25 and RAC32 with CC inserts are changed to RAC25E and RAC32E. Please refer ☞ P.77, P.78
 ★Please refer ☞ P.107 for base holder, ☞ P.108 for spacer and ☞ P.85 for head.
 ★For centre through coolant type, please add “-C” at the end of Code No. e.g. BT50-RAC53-210-C
 ★BT50-RAC100-375, 425 and 475 are also available.

Insert tip for RAC for Heavy Duty Boring

Material	Material		
	Steel	●	
Stainless Steel	●		
Cast Iron	●		
Aluminium	●		
	Coated Carbide M		
	Grade	C	
	Material	AC630M	
Applicable Arbor	Dimension	Code No.	Nose R
RAC43 - RAC530		CN08-○8	0.8

Please add the grade indication into ○, and add the insert tip material indication at the end off the Code No. e.g. CC08-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.120. Nikken CN08-○8 insert can be used on the eccentric bolt type cartridge.

BT