

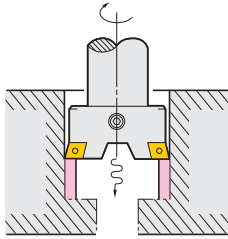
# BALANCE-CUT BORING ARBOR (RAC)



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.

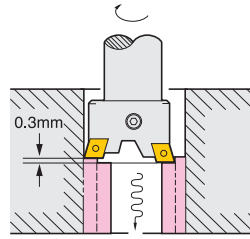
## Double Cutting Capability

Please use RAC-K for through hole boring.  
☞ P.67, P.68



## Example of 2 Stepped Balance Cut

Approx. double removal of below cutting condition is possible by **-0.3 Cartridge**.  
☞ P.70



TAPER	Code No.	Boring Range D	Boring Depth M	Coupling Dia Q	C	C <sub>1</sub>	Shank Code No.	Spacer Code No.	P.64		Weight (kg)	Fig
									Head Code No.	Tip No.		
No.50	<b>BT50-RAC 43-180</b>	43~ 55	97	20	40	60	BT50-Q20-110	—	20-RAC 43- 70	CN08-C	5.7	1
	<b>(IT50) -195</b>		130				-Q20-125				5.8	
	<b>-225</b>		142				-Q20-110				6.1	
	<b>-240</b>		157				SP20-20-45				6.2	
	<b>-RAC 53-210</b>	53~ 70	117	26	50	65	-Q26-140	—	26-RAC 53- 70	CN08-C	6.9	1
	<b>-240</b>		182				-Q26-170N				7.0	
	<b>-270</b>		177				-Q26-140				7.6	
	<b>-RAC 70-255</b>		205				-Q34-170				9.5	
	<b>-285</b>	70~100	235	34	64	80	-Q34-200	—	34-RAC 70- 85	CN08-C	9.9	1
	<b>-315</b>		265				-Q34-170				10.9	
	<b>-RAC100-225</b>		225				-Q42-125				12.5	
	<b>-290</b>		290				-Q42-190				15.2	
	<b>-325</b>	100~130	325	42	83	83	-Q42-225A	—	42-RAC100-100	CN08-C	16.5	2

★“C” grade (Coated) inserts are supplied as standard with the head. ☞ P.64 Please refer ☞ P.95 for cutting condition. ★Code No. of RAC25 and RAC32 with CC inserts are changed to RAC25E and RAC32E. Please refer ☞ P.61, P.62  
★Please refer ☞ P.85 for base holder, ☞ P.86 for spacer and ☞ P.69 for head.  
★For centre through tool 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	Steel		●	
	Stainless Steel		●	
	Cast Iron		●	
	Aluminium		●	
Applicable Arbor	Dimension	Code No.	Coated Carbide M	
			Grade	C
RAC43 - RAC530		CN08-○8	Material	AC630M
			Nose R	0.8
			●	

Please add the grade indication into ○, and add the insert tip material indication at the end of 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.92. Nikken CN08-○8 insert can be used on the eccentric bolt type cartridge.