

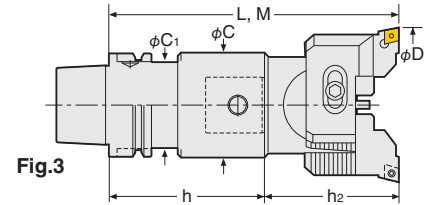
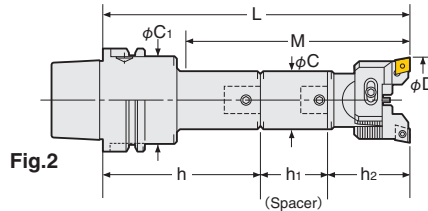
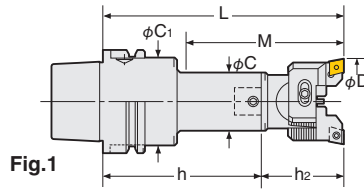
HSK BALANCE-CUT BORING ARBOR (RAC-E)

NIKKEN

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

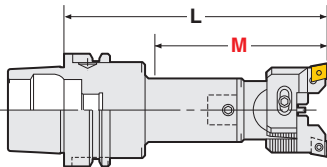


RAC-E



TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.	P.280		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK63A	HSK 63A-RAC25-135E	25~32	67	15	24	HSK 63A-Q12- 80	—	12-RAC 25- 55E	CC07-C	1.7	1
	-165E		105			-Q12-110	—			1.8	
	-180E		112			-Q12- 80	SP12-12-45			1.8	
	-RAC32-150E	32~45	77	19	30	-Q16- 95	—	16-RAC 32- 55E	CC08-C	2.1	1
	-180E		110			-Q16-125	—			2.3	
	-195E		122			-Q16- 95	SP16-16-45			2.3	
	-RAC43-150E	43~55	97	40	50	-Q20- 80	—	20-RAC 43- 70E	CC12-C	2.4	1
	-180E		130			-Q20-110	—			2.6	
	-210E		157			-Q20- 80	SP20-20-60			2.9	
	-RAC53-165E	53~70	135	53	52.4	-Q26- 95	—	26-RAC 53- 70E	CC12-C	2.2	1
	-210E		180			-Q26-140	—			3.0	
	-225E		195			-Q26- 95	SP26-26-60			2.9	
	-RAC70-180E	70~100	180	64	52.4	-Q34- 95	—	34-RAC 70- 85E	CC12-C	4.5	3
	-195E		195			-Q34-110	—			4.9	
	-240E		240			-Q34- 95	SP34-34-60			5.9	
-RAC100-195E	100~130	195	83	—	42-RAC100-100E	—	—	—	6.5	—	

- ★“C” grade (Coated) inserts are supplied as standard with the head. P.280 Please refer P.124 for cutting condition.
- ★Please refer P.297 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. HSK63A-RAC53-165E-C
- ★For HSK40A or 50A, modular connection system is applied. Please refer P.297 for Base Holder.
- ★When L length is required longer than standard, please specify the boring depth M.
- ★Lubrication Pipe is optional. Please refer P.278



★Code No. of RAC25 and RAC32 are changed to RAC25E and RAC32E.
e.g. HSK63A-RAC25-135 → HSK63A-RAC25-135E
12-RAC25- 55 → 12-RAC25- 55E



High Pressure Coolant Through Tool

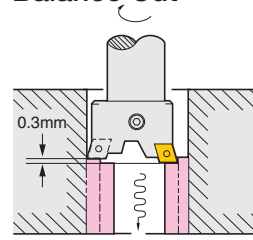
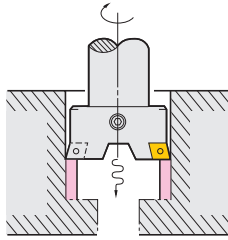
HSK BALANCE-CUT BORING ARBOR (RAC-E)



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.285, P.286

■ **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	C	C ₁	Shank Code No.	Spacer Code No.	P.280		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK100A	HSK100A-RAC 25-150E	25~32	67	15	24	HSK100A-Q12- 95	—	12-RAC 25- 55E	CC07-C	3.9	1
	-180E		105			-Q12-125				4.1	
	-195E		112			-Q12- 95				4.0	2
	-RAC 32-180E	32~45	77	31	50	-Q16-125N	—	16-RAC 32- 55E	CC08-C	4.6	1
	-210E		110			-Q16-155				4.8	
	-225E		122			-Q16-125N				4.8	2
	-RAC 43-180E	43~55	97	40	60	-Q20-110	—	20-RAC 43- 70E	CC12-C	4.9	1
	-195E		130			-Q20-125				5.0	
	225E		142			-Q20-110				5.3	2
	-240E	157	-Q20-110	5.4	1						
	-RAC 53-210E	53~70	117	53		65	-Q26-140	—	26-RAC 53- 70E	6.1	
	-240E		182				-Q26-170N			6.2	
	-270E		177		-Q26-140		6.8			2	
	-RAC 70-255E	70~100	202	64	80	-Q34-170	—	34-RAC 70- 85E	CC12-C	8.7	1
	-285E		232			-Q34-200				9.1	
	-315E		262			-Q34-170				10.1	2
	-RAC100-225E	100~130	225	83	83	-Q42-125	—	42-RAC100-100E	CC12-C	11.7	1
	-290E		290			-Q42-190				11.7	
-315E	315		-Q42-125			15.1				2	

★“C” grade (Coated) inserts are supplied as standard with the head. P.280 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.297 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. HSK100A-RAC53-210E-C
 e.g. HSK100A-RAC25-150 → HSK100A-RAC25-150E
 ★For HSK40A or 50A, modular connection system is applied. Please refer P.297 for Base Holder. 12-RAC25- 55 → 12-RAC25- 55E
 ★HSK100A-RAC100-375E, 425E and 475E are also available.
 ★Lubrication Pipe is optional. Please refer P.278

Insert tip for RAC-E

● : best ○ : good

Material	Steel		●	
	Stainless Steel		●	
	Cast Iron		○	●
Aluminium				
		Coated Carbide M	Coated Carbide K	
		Grade	C	
		Material	AC630M	AC410K
		Nose R		
RAC25E		CC07-○0.4	●	●
		CC07-○0.8	●	●
RAC25E(CC08), RAC32E		CC08-○0.4	●	●
		CC08-○0.8	●	●
RAC43E - RAC530E		CC12-○0.4	●	●
		CC12-○0.8	●	●

Please add the grade indication into ○, and add the insert tip material indication at the end off the Code No. e.g. CC12-C8(AC630M)

★Minimum order quantity : 10pcs.