

HSK BALANCE-CUT BORING ARBOR (RAC)

NIKKEN

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



Heavy Duty Boring

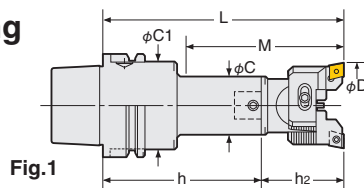


Fig.1

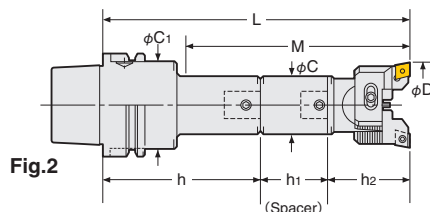


Fig.2

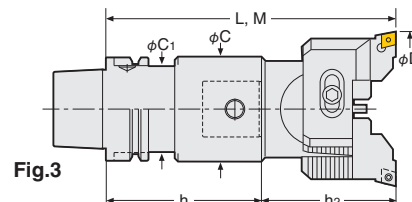


Fig.3

TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.			Weight (kg)	Fig	
								Head Code No.	Tip No.			
HSK63A	HSK 63A-RAC43-150	43~55	97	40	50	HSK 63A-Q20- 80	—	20-RAC 43- 70	CN08-C	2.4	1	
	-180		130			-Q20-110				2.6		
	-210		157			-Q20- 80				SP20-20-60	2.9	2
	-RAC53-165	53~70	135	53		52.4	-Q26- 95	—		26-RAC 53- 70	2.2	1
	-210		180				-Q26-140				3.0	
	-225		195				-Q26- 95				SP26-26-60	2.9
	-RAC70-180	70~100	180	64	-Q34- 95		—	34-RAC 70- 85		4.5	3	
	-195		195		-Q34-110					4.9		
	-240		240		-Q34- 95					SP34-34-60		5.9
	-RAC100-195	100~130	195	83	-Q42- 95	—	42-RAC100-100	6.5				

★“C” grade (Coated) inserts are supplied as standard with the head. P.282 Please refer P.124 for cutting condition.

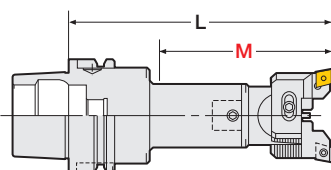
★Please refer P.297 for base holder, P.108 for spacer and P.85 for head.

★For centre through coolant type, please add“-C” at the end of Code No. e.g. HSK63A-RAC53-165-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 with CC inserts are changed to RAC25E and RAC32E. Please refer P.279, P.280



High Pressure Coolant Through Tool

HSK BALANCE-CUT BORING ARBOR (RAC)

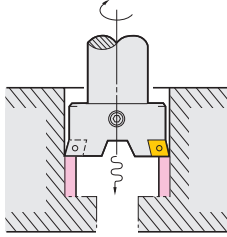
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Balance cut boring bar executes boring in 2 cartridge inserts absorbing the vibration each other. The faster the feed rate, the better swarf ejection. This is ideal for rough and medium boring.

Double Cutting Capability

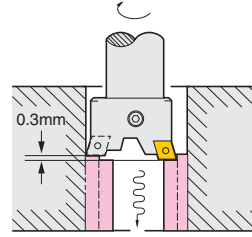
Please use RAC-K for through hole boring.

☞ P.285, P.286



Example of 2 Stepped Balance Cut

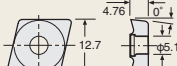
Approx. double removal of below cutting condition is possible by -0.3 Cartridge. ☞ P.86



TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.	P.282		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK100A	HSK100A-RAC 43-180	43~55	97	40	60	HSK100A-Q20-110	—	20-RAC 43- 70	CN08-C	4.9	1
	-195		130			-Q20-125				5.0	
	225		142			-Q20-110	SP20-20-45			5.3	2
	-240		157			-Q20-110	SP20-20-60			5.4	
	-RAC 53-210	53~70	117	53	65	-Q26-140	—	26-RAC 53- 70		6.1	1
	-240		182			-Q26-170N				6.2	
	-270		177			-Q26-140	SP26-26-60			6.8	2
	-RAC 70-255	70~100	202	64	80	-Q34-170	—	34-RAC 70- 85		8.7	1
	-285		232			-Q34-200				9.1	
	-315		262			-Q34-170	SP34-34-60			10.1	2
	-RAC100-225	100~130	225	83	83	-Q42-125	—	42-RAC100-100		11.7	1
	-290		290			-Q42-190				11.7	
	-315		315			-Q42-125	SP42-42-90			15.1	2

★“C” grade (Coated) inserts are supplied as standard with the head. ☞ P.282 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.279, P.280
 ★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-RAC53-210-C
 ★For HSK40A or 50A, modular connection system is applied. Please refer ☞ P.297 for Base Holder.
 ★HSK100A-RAC100-375, 425 and 475 are also available.
 ★Lubrication Pipe is optional. Please refer ☞ P.278

Insert tip for RAC for Heavy Duty Boring

Material	Steel	●	
	Stainless Steel	●	
	Cast Iron	●	
	Aluminium		
		Coated Carbide M	
		Grade	C
		Material	AC630M
Applicable Arbor	Dimension	Code No.	Nose R
RAC43 - RAC530	 (CNMM120408)	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.

HSK