

HSK BALANCE-CUT BORING ARBOR (RAC-A)

NIKKEN

Rough Boring—For Aluminium



RAC-A

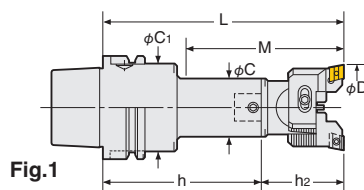


Fig.1

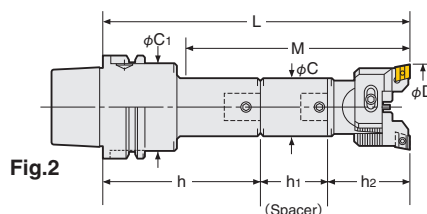


Fig.2

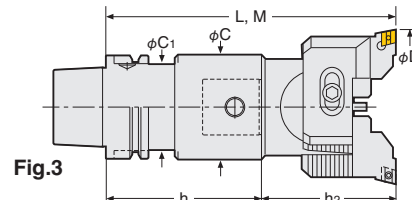


Fig.3

TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.	P.284		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK63A	HSK 63A-RAC25-135A	25~32	67	15	24	HSK 63A-Q12- 80	—	12-RAC 25- 55A	AEG12	1.7	1
	-165A		105			-Q12-110				1.8	
	-180A		112			-Q12- 80	SP12-12-45			1.8	2
	-RAC32-150A	32~45	77	19	30	-Q16- 95	—	16-RAC 32- 55A	AEG12	2.1	1
	-180A		110			-Q16-125				2.3	
	-195A		122			-Q16- 95	SP16-16-45			2.3	2
	-RAC43-150A	43~55	97	40	50	-Q20- 80	—	20-RAC 43- 70A	AEG16	2.4	1
	-180A		130			-Q20-110				2.6	
	-210A		157			-Q20- 80	SP20-20-60			2.9	2
	-RAC53-165A	53~70	135	53	50	-Q26- 95	—	26-RAC 53- 70A	AEG16	2.2	1
	-210A		180			-Q26-140				3.0	
	-225A		195			-Q26- 95	SP26-26-60			2.9	2
	-RAC70-180A	70~100	180	64	52.4	-Q34- 95	—	34-RAC 70- 85A	AEG16	4.5	3
	-195A		195			-Q34-110				4.9	
	-240A		240			-Q34- 95	SP34-34-60			5.9	
	-RAC100-195A	100~130	195	83		-Q42- 95	—	42-RAC100-100A		6.5	

★“F” grade inserts are supplied as standard with the head. P.284 Please refer P.124 for cutting condition.

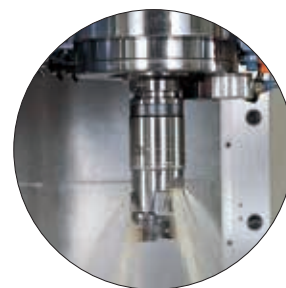
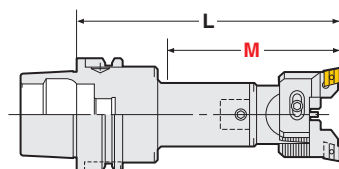
★Please refer P.297 for base holder, P.108 for spacer and P.85 for head.

★For centre through coolant type, please add “-C” at the end of Code No. e.g. HSK63A-RAC53-165A-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



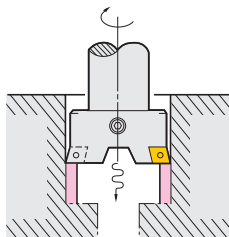
High Pressure Coolant Through Tool

HSK BALANCE-CUT BORING ARBOR (RAC-A)

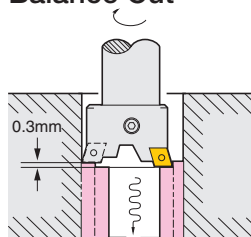
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Balance cut boring bar executes boring in 2 cartridge inserts absorbing the vibration each other. The faster the feed rate, the better swarf ejection. This is Ideal for rough and medium boring.

Double Cutting Capability



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.284		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK100A	HSK100A-RAC 25-150A	25~32	67	15	24	HSK100A-Q12- 95	—	12-RAC 25- 55A	AEG12	3.9	1
	-180A		105			-Q12-125	4.1				
	-195A		112			-Q12- 95	4.0				
	-RAC 32-180A	32~45	77	-Q16-125N	—	16-RAC 32- 55A	4.6	1			
	-210A		110	-Q16-155			4.8				
	-225A		122	-Q16-125N			4.8				
	-RAC 43-180A	43~55	97	40	60	-Q20-110	—	20-RAC 43- 70A	AEG16	4.9	1
	-195A		130			-Q20-125				5.0	
	225A		142			-Q20-110				5.3	2
	-240A		157			-Q20-110				5.4	
	-RAC 53-210A	53~70	117	53	65	-Q26-140	—	26-RAC 53- 70A		6.1	1
	-240A		182			-Q26-170N				6.2	
	-270A		177			-Q26-140				6.8	
	-RAC 70-255A	70~100	202	64	80	-Q34-170	—	34-RAC 70- 85A		8.7	1
	-285A		232			-Q34-200				9.1	
	-315A		262			-Q34-170				10.1	
	-RAC100-225A	100~130	225	83	83	-Q42-125	—	42-RAC100-100A		11.7	1
	-290A		290			-Q42-190				11.7	
	-315A		315			-Q42-125				15.1	

★"F" grade inserts are supplied as standard with the head. P.284 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. HSK100A-RAC53-210A-C

★For HSK40A or 50A, modular connection system is applied. Please refer P.297 for Base Holder.

★HSK100A-RAC100-375A, 425A and 475A are also available.

★Lubrication Pipe is optional. Please refer P.278

Insert tip for RAC-A

Material	Steel	Stainless Steel	Cast Iron	Aluminium	Coated Carbide K	Grade	F
Applicable Arbor	Dimension	Code No.	Nose R	Material	KW10		
RAC25A, RAC32A		AEG12-01	0.1	●			
		AEG12-02	0.2	●			
		AEG12-04	0.4	●			
RAC43A-RAC530A		AEG16-01	0.1	●			
		AEG16-02	0.2	●			
		AEG16-04	0.4	●			

★Minimum order quantity : 10pcs.

Please add the grade indication into ○, and add the insert tip material indication at the end off the Code No.
e.g. AEG16-F2 (KW10)