

HSK BALANCE-CUT BORING ARBOR (RAC-K)

NIKKEN

Rough Boring—For Through Hole and Multi Sheets



RAC-K

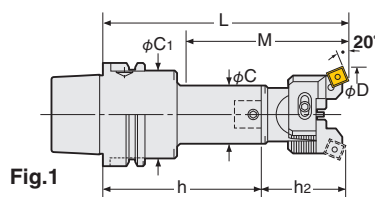


Fig.1

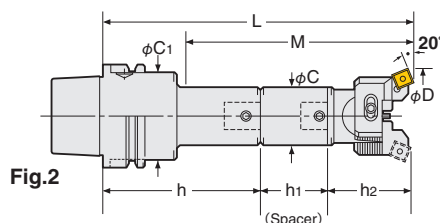


Fig.2

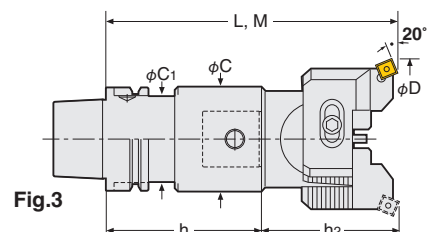


Fig.3

TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.	P.286		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK63A	HSK 63A-RAC25-135K	25~32	67	15	24	HSK 63A-Q12- 80	—	12-RAC 25- 55K	SC09	1.7	1
	-165K		105			-Q12-110				1.8	
	-180K		112			-Q12- 80	SP12-12-45			1.8	
	-RAC32-150K	32~45	77	19	30	-Q16- 95	—	16-RAC 32- 55K	SC09	2.1	1
	-180K		110			-Q16-125				2.3	
	-195K		122			-Q16- 95	SP16-16-45			2.3	
	-RAC43-150K	43~55	97	40	50	-Q20- 80	—	20-RAC 43- 70K	SC12	2.4	1
	-180K		130			-Q20-110				2.6	
	-210K		157			-Q20- 80	SP20-20-60			2.9	
	-RAC53-165K	53~70	135	53	50	-Q26- 95	—	26-RAC 53- 70K	SC12	2.2	1
	-210K		180			-Q26-140				3.0	
	-225K		195			-Q26- 95	SP26-26-60			2.9	
	-RAC70-180K	70~100	180	64	52.4	-Q34- 95	—	34-RAC 70- 85K	SC12	4.5	3
	-195K		195			-Q34-110				4.9	
	-240K		240			-Q34- 95	SP34-34-60			5.9	
	-RAC100-195K	100~130	195	83		-Q42- 95	—	42-RAC100-100K		6.5	

★“C” grade (Coated) inserts are supplied as standard with the head. P.286 Please refer P.124 for cutting condition.

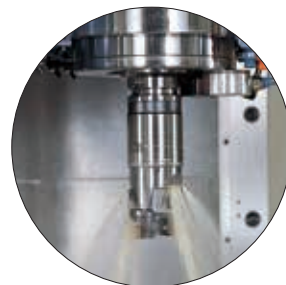
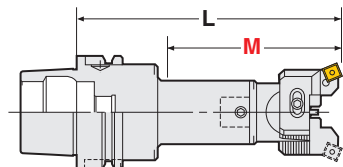
★Please refer P.297 for base holder, P.108 for spacer and P.85 for head.

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



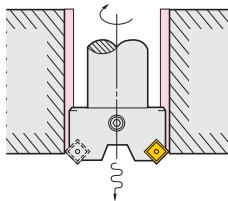
High Pressure Coolant Through Tool

HSK BALANCE-CUT BORING ARBOR (RAC-K)

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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



TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Spacer Code No.	P.286		Weight (kg)	Fig
								Head Code No.	Tip No.		
HSK100A	HSK100A-RAC 25-150K	25~32	67	15	24	HSK100A-Q12- 95	—	12-RAC 25- 55K	SC09	3.9	1
	-180K		105			-Q12-125	4.1				
	-195K		112			-Q12- 95	SP12-12-45			4.0	2
	-RAC 32-180K	32~45	77	-Q16-125N	—	16-RAC 32- 55K	4.6	1			
	-210K		110	-Q16-155			4.8				
	-225K		122	-Q16-125N	SP16-16-45		4.8	2			
	-RAC 43-180K	43~55	97	40	60	-Q20-110	—		20-RAC 43- 70K	SC12	4.9
	-195K		130			-Q20-125		5.0			
	225K		142			-Q20-110	SP20-20-45	5.3			2
	-240K		157			-Q20-110	SP20-20-60	5.4			
	-RAC 53-210K	53~70	117	53	65	-Q26-140	—	26-RAC 53- 70K	6.1		1
	-240K		182			-Q26-170N			6.2		
	-270K		177			-Q26-140	SP26-26-60		6.8		2
	-RAC 70-255K	70~100	202	64	80	-Q34-170	—	34-RAC 70- 85K	8.7		
	-285K		232			-Q34-200			9.1		
	-315K		262			-Q34-170	SP34-34-60		10.1		2
	-RAC100-225K	100~130	225	83	83	-Q42-125	—	42-RAC100-100K	11.7		
	-290K		290			-Q42-190			11.7		
	-315K		315			-Q42-125	SP42-42-90		15.1		2

★“C” grade (Coated) inserts are supplied as standard with the head. P.286 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-RAC53-210K-C

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

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

★Lubrication Pipe is optional. Please refer P.278

Insert tip for RAC-K

● : best ○ : good

Material	Steel	●			
	Stainless Steel	●			
	Cast Iron	○	●		
	Aluminium				
		Coated Carbide M	Coated Carbide K		
		Grade	C		
		Material	AC630M	AC410K	
Applicable Arbor	Dimension	Code No.	Nose R		
RAC25K, RAC32K		SC09-○4 SCMT070204N	0.4	●	●
RAC43K-RAC100K		SC12-○8 SCMT120408N	0.8	●	●

Please add the grade indication into ○, and add the insert tip material indication at the end off the Code No. e.g. SC12-C8 (AC630M)

★Minimum order quantity : 10pcs.