

CARTRIDGE for RAC BORING HEAD

NIKKEN

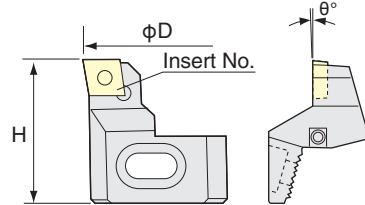
B1

RAC Base () is common for all types of cartridges.

Please select suitable cartridge and insert tip for your application such as material and machining.

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

S.RCC-E Cartridge



Set Code No.	Boring Range D	H	θ	Insert Code No.	
				Steel, Stainless Steel	Cast Iron
S.RCC- 25E	25 ~ 32	41	0°	CC08-C (AC630M)	CC08-C (AC410K)
				CC07-C (AC630M)	CC07-C (AC410K)
- 32E	32 ~ 45	41	+3°	CC08-C (AC630M)	CC08-C (AC410K)
- 43E	43 ~ 55	46		CC12-C (AC630M)	CC12-C (AC410K)
- 53E	53 ~ 70	50			
- 70E	70 ~ 100	55			
-100E	100 ~ 130	57			

★Code No. of RAC25 and RAC32 with CC inserts are changed to RAC25E and RAC32E.

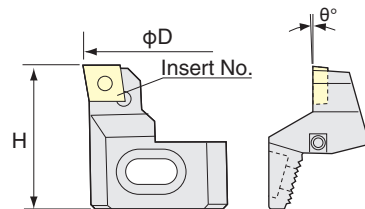
★Insert tips are supplied as an option.  P.78 Please refer  P.124 for cutting condition.

★Please order set of cartridges. e.g S.RCC-70E



★2 stepped balance cut with H=0.3 cartridge is also available. e.g. S.RCC-70E (0.3)

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


S.RCC Cartridge



Set Code No.	D	H	θ	Insert Code No.	
				Iron and Cast Iron	
S.RCC- 43	43 ~ 55	46	-3°	CN08	
- 53	53 ~ 70	50			
- 70	70 ~ 100	55			
-100	100 ~ 130	57			

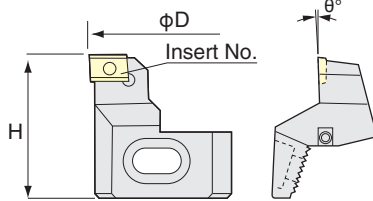
★Insert tips are supplied as an option.  P.80 Please refer  P.124 for cutting condition.

★Please order set of cartridges. e.g S.RCC-70



★When CN08 insert (CN00120400) in the market is used, please use the eccentric bolt type cartridge (S.RCC-00Q)  P.120. Nikken CN08-08 insert can be used on the eccentric bolt type cartridge.

For Aluminum

S.RCC-A Cartridge



Set Code No.	D	H	θ	Insert Code No.	
				For Aluminum	
S.RCC- 25A	25 ~ 32	38	+6°	AEG12	
- 32A	32 ~ 45	41			
- 43A	43 ~ 55	46		AEG16	
- 53A	53 ~ 70	50			
- 70A	70 ~ 100	55			
-100A	100 ~ 130	57			

★Insert tips are supplied as an option.  P.82 Please refer  P.124 for cutting condition.

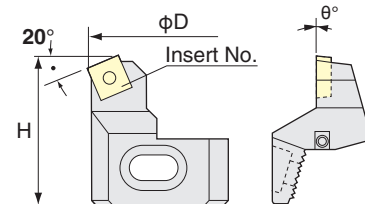
★Please order set of cartridges. e.g S.RCC-70A

★2 stepped balance cut with H=0.3 cartridge is also available. e.g. S.RCC-70A (0.3)



★S.RCC-A cartridge can be used for the bottom face finishing of iron and cast iron.

For Through Hole and Multi Sheets

S.RCC-K Cartridge

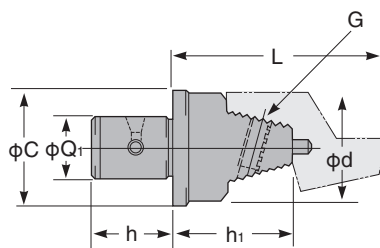


Set Code No.	D	H	θ	Insert Code No.	
				Steel, Stainless Steel	Cast Iron
S.RCC- 25K	25 ~ 32	41	0°	SC09-C (AC630M)	SC09-C (AC410K)
- 32K	32 ~ 45	41		SC12-C (AC630M)	SC12-C (AC410K)
- 43K	43 ~ 55	46			
- 53K	53 ~ 70	50			
- 70K	70 ~ 100	55			
-100K	100 ~ 130	57			

★Insert tips are supplied as an option.  P.84 Please refer  P.124 for cutting condition.

★Please order set of cartridges. e.g S.RCC-70E

Dimension of RAC Base



Code No.	Boring Range D	h	h ₁	C	G	d
12-RAC025- 55B						
16-RAC 32- 55B	32~45	22	31	31	M6	30
20-RAC 43- 70B						
26-RAC 43- 70B	43~55	24	42	40	M8	35
26-RAC 53- 70B						
26-RAC 70- 70B*	53~70	28	40	50	M8	45
34-RAC 70- 85B						
42-RAC100-100B	70~100	36	53	64	M8	60
	100~130	42	66	83	M8	70

★Dimension "L" is "58mm" in combination of RCC-25K and 12-RAC25-55B.

*For centre through coolant type except 26-RAC70-70B,

please add "-C" at the end of Code No. e.g. 34-RAC70-85B-C