RAC BALANCE-CUT BORING ARBOR CUTTING DATA NIKKEN

CC (Positive type) RAC-E

CN (Negative type) RAC

RAC-A

RAC-K

Material

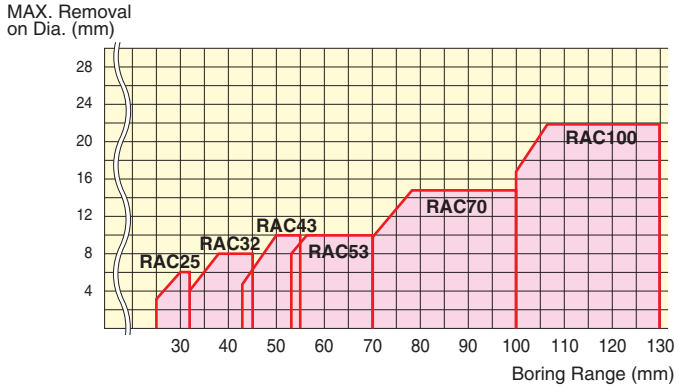
Steel	60～150m/mim. (Dry or Wet cutting)
Stainless Steel	40～80m/mim. (Wet cutting)
Cast Iron	60～150m/mim. (Dry or Wet cutting)
Aluminium, Non-ferrous metal	200～500m/mim. (Wet cutting)
Multiple Sheets, Through Hole	40～120m/mim. (Dry or Wet cutting)

Recommended cutting Speed ◎…Best ○…Good —…Unsuitable

Insert			SS41	S55C	SCM	SKD	SC	FC,FCD	SUS	AL,ALC	Interrupted Cutting
Code No.		Grade									
	CC	Coated Carbide M	◎ 60～120	◎ 60～150	◎ 60～150	◎ 50～80	○ 80～120	○ 60～150	◎ 40～80	—	○
		Coated Carbide K	—	—	—	—	◎ 80～120	◎ 60～150	—	—	—
	CN	Coated Carbide M	○ 60～120	○ 60～150	○ 60～150	○ 50～80	○ 50～80	○ 60～150	○ 40～80	—	○
	AEG	K10	—	—	—	—	—	—	—	◎ 400～800	○
	SC	Coated Carbide M	◎ 60～120	◎ 60～150	◎ 60～150	◎ 50～80	○ 80～120	○ 60～150	◎ 40～80	—	○
		Coated Carbide K	—	—	—	—	◎ 80～120	◎ 60～150	—	—	—

★The cutting speed is recommended to be reduced to 50% for the interrupted cutting.
★When L/D is longer, the insert tip with small Nose R is recommended.
★When L/D is longer, the feed rate at the entrance is recommended to be reduced to 60 to 70%.

Relation between Boring Dia. & MAX. Removal



Recommended Cutting Condition (removal,feed)

These figures are based on the application of L/D=3～3.5 times on cast iron.

Boring Range	Type	Best Condition		MAX. Condition	
		Removal mm/φ	Feed mm/rev.	Removal mm/φ	Feed mm/rev.
φ25～ 32	RAC 25	2.0～ 4.0	0.2～0.3	0.5～ 6.0	0.1～0.4
32～ 43	RAC 32	3.0～ 5.0	0.2～0.3	1.0～ 8.0	0.1～0.4
43～ 53	RAC 43	4.0～ 7.0	0.2～0.3	1.0～10.0	0.1～0.5
53～ 70	RAC 53	4.0～ 7.0	0.2～0.3	1.0～10.0	0.1～0.5
70～100	RAC 70	5.0～10.0	0.3～0.4	1.0～15.0	0.1～0.5
100～130	RAC100	7.0～12.0	0.3～0.4	1.0～22.0	0.1～0.5