

HSK ZMAC ADVANCED BORING ARBOR (ZMAC-VR)



Boring for Semi-Finishing—ZMAC-VR



ZMAC-VR

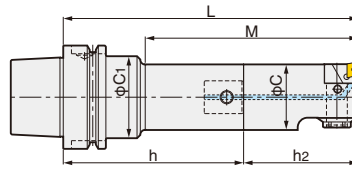


Fig.1

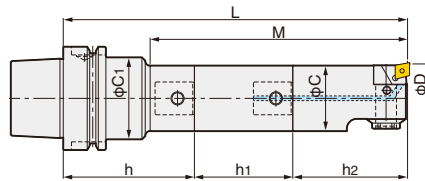


Fig.2

ZMAC100-VR, 140-VR

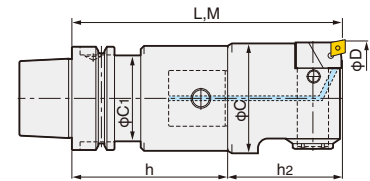









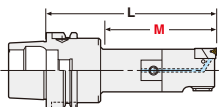
Fig.3

Code No. of the insert tip  are shown.

JAPAN PAT.

TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Extension Spacer Code No.	P.280		Weight (kg)	Fig	
								Head No.	Insert No.			
HSK63A	HSK63A-ZMAC32R-150V	31.8~42.2	77	31	42	HSK63A-Q16- 95	—	16-ZMAC32R- 55V	CC06-C	2.2	1	
	-180V		110			-Q16-125				2.4		
	-195V		122			-Q16- 95				2.4		
		ZMAC42R-150V	41.8~55.2	97	40	50	-Q20- 80	—	20-ZMAC42R- 70V	CC06-C	2.7	1
	-180V	130		-Q20-110			2.9					
	-210V	157		-Q20- 80			3.1					
		ZMAC55R-165V	54.8~70.2	135	53	50	-Q26- 95	—	26-ZMAC55R- 70V	CC06-C	3.6	1
	-180V	180		-Q26-140			4.3					
	-225V	195		-Q26- 95			4.3					
		ZMAC70R-165V	69.8~85.2	165	67	52.4	-Q34- 95	—	34-ZMAC70R- 70V	CC08-C	5.1	4
	-180V	180		-Q34-110			5.5					
	-225V	225		-Q34- 95			6.5					
	ZMAC85R-195V	84.8~100.2	195	83	52.4	-Q42- 95	—	42-ZMAC85R-100V		8.7		

- ★MIN. dial readout : ZMAC25-VR & smaller is 0.02mm on diameter. ZMAC32-VR and larger are 0.01mm on diameter.
- ★“C” grade (Coated) insert for Steel, Stainless & Cast Iron is supplied as Standard with the head (Smooth boring & Long tool-life).  Please refer  for cutting condition. We would recommend “B” grade (CBN) insert for Hardened Steel & High Speed boring of Cast Iron.
- ★Please refer  for base holder,  for spacer and  for head.
- ★Centre Through Tool Coolant function is available as standard.
- ★For HSK40A or 50A, modular connection system is applied. Please refer  for Base Holder.
- ★When L length is required longer than standard, please specify boring depth M.



High Pressure Coolant Through Tool

 Boring Arbor with Extension Spacer

 ZMAC-V for Multi-Stage Boring Bar 

Please contact us for the special boring bar.



HSK ZMAC ADVANCED BORING ARBOR (ZMAC-VR)



Insert Tip for ZMAC-VR

●:best ○:good

Material	Steel		●	○
	Stainless Steel		●	
	Cast Iron		○	●
Aluminium				
High Speed finish for Cast Iron				
Hardened Steel				
High Speed finish for Aluminium				
			Coated Carbide M	Coated Carbide K
			Grade C	
			Material	
			Nose R	
			AC630M	AC410K

Applicable Arbor	Dimension	Code No.	Nose R	AC630M	AC410K
ZMAC32-VR, ZMAC42-VR, ZMAC55-VR		CC06-○4	0.4	●	●
		CC06-○8	0.8	●	●
		CC08-○4	0.4	●	●
ZMAC70-VR, ZMAC85-VR		CC08-○4	0.4	●	●
		CC08-○8	0.8	●	●
		CC12-○4	0.4	●	●
ZMAC100-VR, ZMAC140-VR		CC12-○4	0.4	●	●
		CC12-○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. CC12-C8(AC630M)

There is the CBN insert tip which both corners can be used. Please refer P.119 for ISO code of the insert tip.



Code No. of the insert tip are shown.

TAPER	Code No.	Boring Range D	Boring Depth M	C	C ₁	Shank Code No.	Extension Spacer Code No.	P.280		Weight (kg)	Fig
								Head No.	Insert No.		
HSK100A	HSK100A-ZMAC 32R-180V	31.8~42.2	77	31	50	HSK100A-Q16-125N	—	16-ZMAC 32R- 55V	CC06-C	4.7	1
	-210V		110			-Q16-155				4.8	
	-225V		122			-Q16-125N				4.9	
	-ZMAC 42R-180V	41.8~55.2	97	40	60	-Q20-110	—	20-ZMAC 42R- 70V	CC06-C	5.2	1
	-195V		130			-Q20-125				5.2	
	-225V		142			-Q20-110				5.6	
	-240V		157			-Q20-110				5.7	
	-ZMAC 55R-210V	54.8~70.2	117	53	65	-Q26-140	—	26-ZMAC 55R- 70V	CC06-C	6.7	1
	-240V		182			-Q26-170N				6.8	
	-270V		177			-Q26-140				8.3	
	-ZMAC 70R-240V	69.8~85.2	187	67	80	-Q34-170	—	34-ZMAC 70R- 70V	CC08-C	9.2	1
	-270V		217			-Q34-200				9.8	
	-300V		247			-Q34-170				10.7	
	-ZMAC 85R-225V	84.8~100.2	187	83	—	-Q42-125	—	42-ZMAC 85R-100V	CC08-C	11.7	1
	-290V		252			-Q42-190				14.2	
	-315V		277			-Q42-125				15.2	
	-ZMAC100R-225V	99.5~140.5	225	95	83	-Q42-125	—	42-ZMAC100R-100V	CC12-C	11.6	4
	-290V		290			-Q42-190				14.3	
	-325V		325			-Q42-225A				17.0	
	-375V		375			-Q42-275A				19.7	
	-425V		425			-Q42-325A				22.4	
	-ZMAC140R-225V		139.5~180.5			225				135	
	-290V	290		-Q42-190	15.7						
	-325V	325		-Q42-225A	18.4						
-375V	375	-Q42-275A		21.1							
-425V	425	-Q42-325A		23.8							

★MIN. dial readout : ZMAC25-VR & smaller is 0.02mm on diameter. ZMAC32-VR and larger are 0.01mm on diameter.
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 ★"C" grade (Coated) Insert for Steel, Stainless&Cast Iron is supplied as Standard with the head (Smooth boring & Long tool-life). P.280
 We would recommend "B" grade (CBN) insert for Hardened Steel & High Speed boring of Cast Iron. Please refer P.117 for cutting condition.
 ★Please refer P.283 for base holder, P.102 for spacer and P.87, P.88 for head.