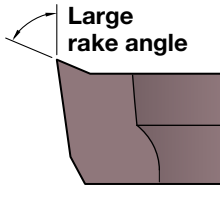


- Automates rounded chamfering for both the front and back.



Excellent sharpness with new insert shape!

R-CUTTER is the first in the industry to use an insert with a large rake angle that's capable of producing clean surfaces with no vertical streaking.



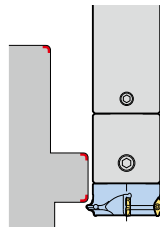
Four corners can be used for better economic efficiency

A throw-away insert that allows all four corners to be used, making cost reduction possible.

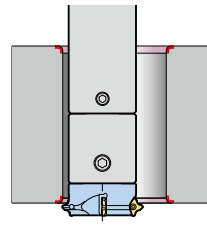


CK BORING SYSTEM CKB Type

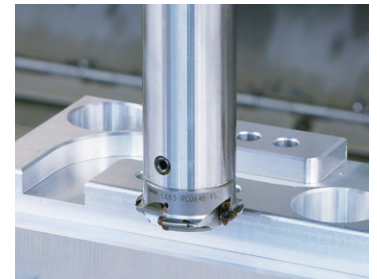
Modular type round chamfering tool.
CK extensions allow front/back chamfering of deep holes, as well as grooves or steps at the distance.



Front and back chamfering of grooves and steps located at a distance



Front and back chamfering of deep holes



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Advice



It is well known that changing the chamfer of the workpiece from the C-plane to the R-plane will considerably change the texture of the workpiece. This can be considered an added value.

Automated rounded chamfering.

- Supports chamfering for both front and back.
- 4 inserts vastly improve efficiency!

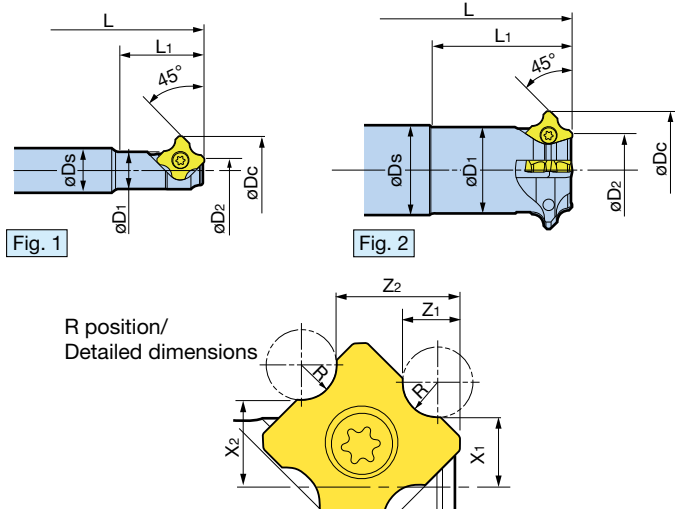
Front and back round chamfering



Model Description

ST10 - RC 06 1 B - 15

- Projection length (L₁)
- Front & back chamfering
- Number of inserts
- Compatible insert size
- R-CUTTER
- Shank diameter



Model	Fig.	øDc	øDs	øD1	øD2	L	L ₁	Number of inserts	R	X ₁	Z ₁	X ₂	Z ₂	Insert Model
ST10-RC061B-15	1	12.3	10	6.6	4.4	78	15	1	0.5	3.61	1.93	4.30	5.78	RC06....
									1	3.35	2.18	4.04	5.53	
									1.5	3.09	2.43	3.78	5.28	
									2	2.83	2.68	3.52	5.03	
ST16-RC121B-30	1	24.4	16	13.3	8.6	103	30	1	1	7.17	3.79	8.56	11.63	RC12....
									2	6.65	4.29	8.03	11.13	
									3	6.13	4.79	7.51	10.63	
									4	5.60	5.29	6.99	10.13	
ST16-RC064B-30	2	21	16	15.2	13.2	101	30	4	0.5	7.89	1.93	8.59	5.78	RC06....
									1	7.64	2.18	8.34	5.53	
									1.5	7.39	2.43	8.09	5.28	
									2	7.13	2.68	7.84	5.03	
ST32-RC124B-50	2	42	32	30.8	26.3	141	50	4	1	15.85	3.79	17.26	11.63	RC12....
									2	15.33	4.29	16.75	11.13	
									3	14.83	4.79	16.24	10.63	
									4	14.31	5.29	15.73	10.13	

1. Inserts must be ordered separately.

2. Insert clamping screws and wrench are included.

Cutting Conditions

Workpiece material	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	Coolant
Unalloyed Steel, Carbon Steel, Alloy Steel	100 - 350	0.05 - 0.2	Dry
Pre-hardened Steel HRC40 or less	60 - 80	0.05 - 0.1	Wet
Stainless Steel	100 - 250	0.08 - 0.2	Dry/Wet
Cast Iron	100 - 350	0.05 - 0.25	Dry
Aluminum, Non-ferrous	100 - 800	0.05 - 0.25	Dry/Wet

1. This table is a guideline for selecting cutting parameters. Adjust them as needed according to the machine and workpiece conditions.

2. Generally, wet cutting effectively improves surface finish.

3. Wet cutting effectively suppresses built-up edges occurring on stainless steel or aluminum.

Front round chamfering



Model Description

ST16 - RC 06 1 - 20

- Projection length (L₁)
- Number of inserts
- Compatible insert size
- R-CUTTER
- Shank diameter

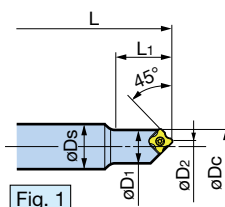


Fig. 1

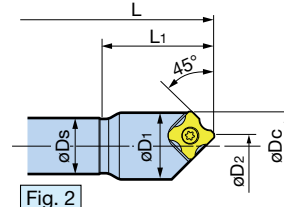
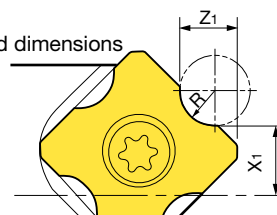


Fig. 2

R position/Detailed dimensions



Model	Fig.	øDc	øDs	øD1	øD2	L	L ₁	Number of inserts	R	X ₁	Z ₁	Insert Model
ST16-RC061-20	1	12.3	16	11.9	4.5	94	20	1	0.5	3.61	1.93	RC06....
									1	3.35	2.18	
									1.5	3.09	2.43	
									2	2.83	2.68	
ST20-RC121-40	2	24.4	20	23.8	8.9	121	40	1	1	7.17	3.79	RC12....
									2	6.65	4.29	
									3	6.13	4.79	
									4	5.60	5.29	

1. Inserts must be ordered separately.

2. Insert clamping screws and wrench are included.

<Insert PAT.>

Model Description

RC 06 050 (ACP300)

- R Size
- Insert size
- R-CUTTER
- Grade



Uses 4 corners

Type	Insert Model	R size	Insert Clamping Screw Set Model
RC06	RC06050 (ACP300)	R0.5	S2TS-T6
	RC06100 (ACP300)	R1.0	
	RC06150 (ACP300)	R1.5	
	RC06200 (ACP300)	R2.0	
RC12	RC12100 (ACP300)	R1.0	S4S-T15
	RC12200 (ACP300)	R2.0	
	RC12300 (ACP300)	R3.0	
	RC12400 (ACP300)	R4.0	

1. Inserts are available in packets of 10 pcs.

2. Insert is coated carbide.

3. The insert clamping screw set contains 10 screws and 1 wrench.

4. Insert Clamp Screws and tightening wrench are consumables. Order periodically for replacement or spares.

Insert set in a packet of 2 pcs. is also available.
Please add **-2P** before the grade when ordering.

Example: **RC06050-2P(ACP300)**

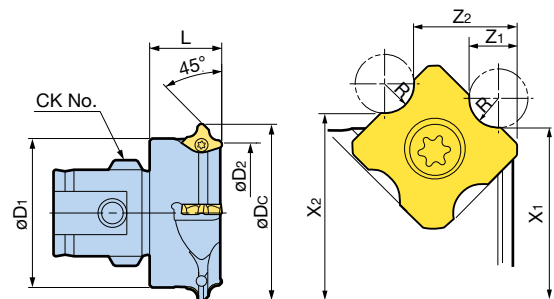
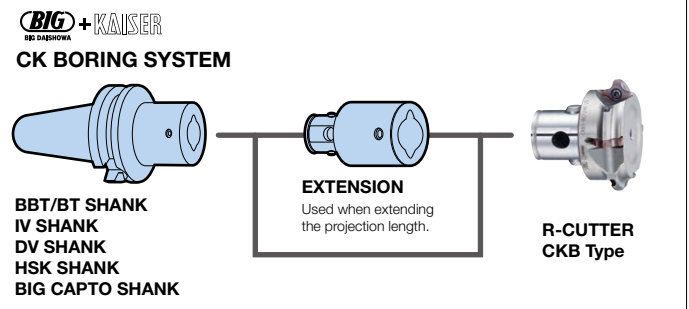
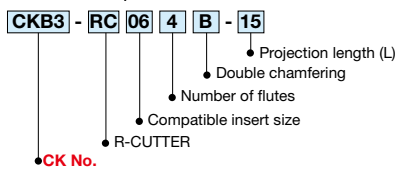
BIG + **KAISER** CK BORING SYSTEM

[CKB Type] Front and back chamfering

- Automated rounded chamfering.



● Model Description



Model	CK No.	øDc	øD1	øD2	L	Number of flutes	R	X ₁	Z ₁	X ₂	Z ₂	Insert Model	Weight (kg)
CKB3-RC064B-15	CK3	37	31	29.2	15	4	0.5	15.86	1.93	16.56	5.78	RC06...	0.12
							1	15.61	2.18	16.31	5.53		
							1.5	15.36	2.43	16.06	5.28		
							2	15.11	2.68	15.81	5.03		
CKB5-RC124B-25	CK5	62	50	46.3	25	4	1	25.81	3.79	27.22	11.63	RC12...	0.50
							2	25.31	4.29	26.72	11.13		
							3	24.80	4.79	26.21	10.63		
							4	24.30	5.29	25.71	10.13		

1. Inserts must be ordered separately.
2. Insert clamping screws and wrench are included.
3. Values in the table are reference only. Measure accurate values with a presetter.

Modular boring system with secure and accurate connection mechanism

CK BORING SYSTEM
CK BORING SYSTEM

Supports various boring applications with abundant heads and accessories.



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