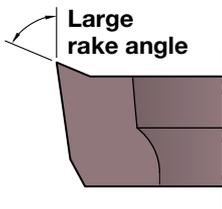


● Automates rounded chamfering for both the front and back.



**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.

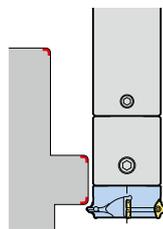


**CK BORING SYSTEM CKB Type**

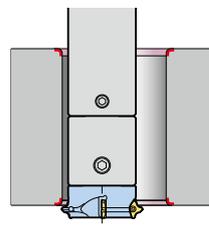
Modular type round chamfering tool. CK extensions allow front/back chamfering of deep holes, as well as grooves or steps at the distance.



**BIG** + KAISER  
BIG DAISHOWA



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



Front and back chamfering of deep holes

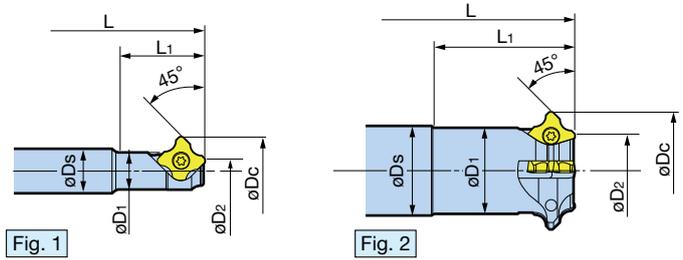


It is well known that changing the chamfer of the workpiece from the C-plane to the R-plane will considerably change the texture of the workpiece. This can be considered an added value.

## Automated rounded chamfering.

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

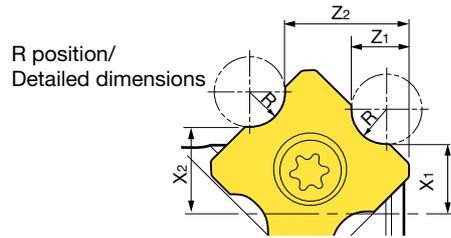
### Front and back round chamfering



#### 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	L1	Number of inserts	R	X1	Z1	X2	Z2	Insert Model
<b>ST10-RC061B-15</b>	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	
<b>ST16-RC121B-30</b>	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	
<b>ST16-RC064B-30</b>	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	
<b>ST32-RC124B-50</b>	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	

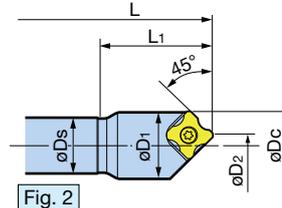
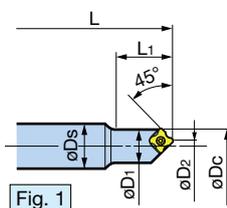
1. Inserts must be ordered separately.
2. Insert clamping screws and wrench are included.

### 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

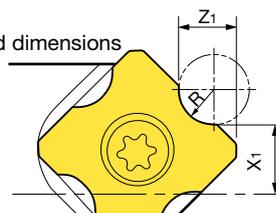


● Model Description

**ST16** - **RC** **06** **1** - **20**

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

R position/Detailed dimensions



Model	Fig.	øDc	øDs	øD1	øD2	L	L1	Number of inserts	R	X1	Z1	Insert Model
<b>ST16-RC061-20</b>	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	
<b>ST20-RC121-40</b>	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-CUTTER
- Insert size
- R Size
- Grade



Uses 4 corners

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

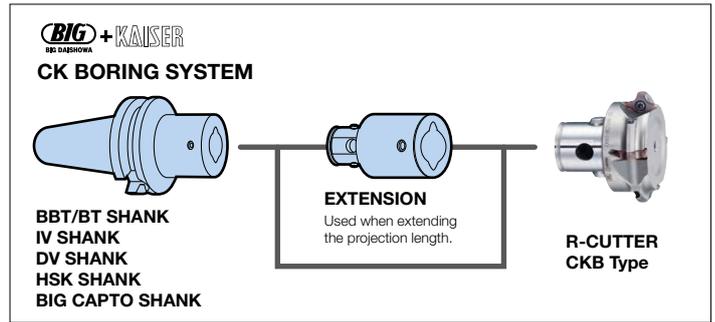
Insert set in a packet of 2 pcs. is also available.  
 Please add **-2P** before the grade when ordering.

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

**BIG** + **KAISER** CK BORING SYSTEM

[CKB Type] Front and back chamfering

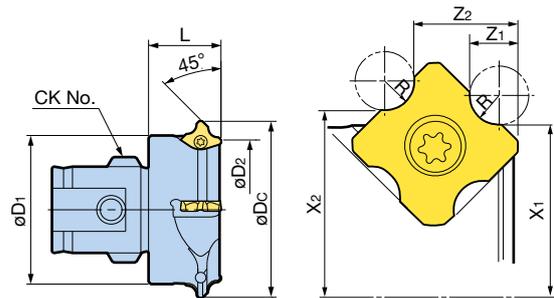
- Automated rounded chamfering.



● Model Description

**CKB3** - **RC** **06** **4** **B** - **15**

- Projection length (L)
- Double chamfering
- Number of flutes
- Compatible insert size
- R-CUTTER
- CK No.



Model	CK No.	øDc	øD1	øD2	L	Number of flutes	R	X <sub>1</sub>	Z <sub>1</sub>	X <sub>2</sub>	Z <sub>2</sub>	Insert Model	Weight (kg)
<b>CKB3-RC064B-15</b>	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		
<b>CKB5-RC124B-25</b>	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.

