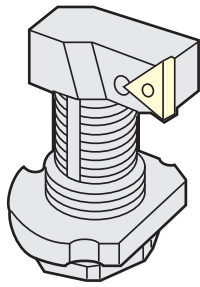


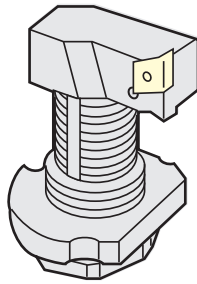
ZMAC ADVANCED BORING UNIT PARTS LIST



BT



ZMAC-V



ZMAC-VR

NIKKEN ZMAC-V Boring Heads come complete with the ZMAC-V Boring Unit. Specify the part No. in the table below when ordering spares.

Triangular Insert Heads and Rhomboid Insert Heads use different boring units, cartridges, insert tips, insert clamp bolts, and insert clamp handles, but all other parts are common to both.

Other manufacturers' ISO standard insert tips available on the market may have different insert clamp hole diameters, so please contact us regarding use.

* Boring heads that use ISO standard insert tips available on the market are also available with us.

ZMAC Advanced (ISO) Boring Head

P.95

* The ZMAC units and new ZMAC-V, ZMAC-VR units are interchangeable.

ZMAC-V Style	Boring Range	Unit	Triangular Insert	Insert Clamp Screw	Insert Clamp Handle	Lock Screw	Adjustment Handle	Unit Clamp Bolt	
ZMAC16 -V	15.9~20.2	M 2HZ- 16V	3MP-C,B	M2045	T-6	M361	M 2HZL-A	M2045	
ZMAC20 -V	19.8~25.2	M 2HZ- 20V				M362	M 2HZL-B		
ZMAC25 -V	24.8~32.2	M 3HZ- 25V				M363	M 3HZL		
ZMAC32 -V	31.8~42.2	M 4HZ- 32V	4MP-C,B	M2055	T-6	M365	M 4HZL	M2577	
ZMAC42 -V	41.8~55.2	M 5HZ- 42V				M364	M 5HZL		
ZMAC55 -V	54.8~70.2	M 5HZ- 55V	6MP-C,B	M2577 (M2562D) [*]	T-8	M366	M 7HZL	M3090	
ZMAC70 -V	69.8~85.2	M 7HZ- 70V				M360			
ZMAC85 -V	84.8~100.2	M10HZ- 85V				M367	M10HZL		M4012
ZMAC100-V	99.5~140.5	M10HZ-100V				M368			
ZMAC140-V	139.5~180.5	M10HZ-140V				M369			

- ★Each Unit and Cartridge are supplied without Insert Tip.
- ★Cartridge for base forming of bore is an option.
- Please specify the diameter and width of base forming.
- ★For Diamond Insert Tip (6MP-D), M2562D* must be used.
- ★Cartridge can not be supplied alone, please order ZMAC-V unit.



Special cartridge example for necking is available. Please contact us with the work piece drawing.

ZMAC-VR Style	Boring Range	Unit	Insert	Insert Clamp Screw	Insert Clamp Handle
ZMAC32 -VR	31.8~42.2	M 4HZ- 32VR	CC06-C	M2560	T-8
ZMAC42 -VR	41.8~55.2	M 5HZ- 42VR		M2577	
ZMAC55 -VR	54.8~70.2	M 5HZ- 55VR	CC08-C	M4090	T-15
ZMAC70 -VR	69.8~85.2	M 7HZ- 70VR		M4012	
ZMAC85 -VR	84.8~100.2	M10HZ- 85VR	CC12-C	M5012	T-15
ZMAC100-VR	99.5~140.5	M10HZ-100VR			
ZMAC140-VR	139.5~180.5	M10HZ-140VR			

The cartridge head can be exchanged itself for the head bigger equal to ZMAC42-V.

Boring Range	Cartridge Head		Head Clamp Bolt
41.8~55.2	M 5HZ- 42 CH	M 5HZ- 42RCH	M512C
54.8~70.2	M 7HZ- 70 CH	M 7HZ- 70RCH	M625
69.8~85.2	M10HZ- 85 CH	M10HZ- 85RCH	M825
99.5~140.5	M10HZ-100 CH	M10HZ-100RCH	M835
139.5~180.5	M10HZ-100 CH	M10HZ-100RCH	M835

- ★Each Unit and Cartridge are supplied without Insert Tip.
- ★Cartridge can not be supplied alone, please order ZMAC-V unit.

- Detach Attach**
- Loosen head clamp bolt after boring diameter is set to little larger than the MIN. boring diameter.
 - Insert the head into cartridge, then tighten head clamp bolt temporary.
 - Loosen side lock bolt.
 - Rotate the dial ring 0.2~0.3mm to minus direction.
 - Tighten head clamp bolt by pushing the head to the support portion of the main body.