



## ISCAR SUMOCHAM drill body Weldon shank DCN A, 8xD, Size: 21



### Order data

Order number	231715 21
GTIN	7291075291797
Item class	23K

### Description

#### Version:

SUMOCHAM interchangeable head drilling system for highly efficient drilling with interchangeable cutting edges. Unique clamping mechanism for convenient fixing of the cutter insert without additional clamping screw. Versatile material use due to comprehensive cutter insert range. Optimum tool stability with simultaneously helical coolant channels for high concentricity and lowest possible axial run-out of the bore. Other available versions: base body with round shank, base body for machining chamfers on bores when a chamfer ring is attached, base body especially for use in multi-spindle, sliding headstock and production lathes. Tolerance class: IT8-IT9, concentricity: 0.03 mm.

#### Application:

With drilling heads No. 231740 – 231790.

#### Supplied with:

Drill body incl. assembly key for drilling heads.

#### Note:

Always select a strategy with medium cutting speeds and high feed rates. No rapid traverse and no spindle anti-clockwise rotation during retraction. For drilling depths of 8xD and more, piloting of at least 1.5 × DC with same cutter insert required. Drilling convex / concave surfaces: Radius of curvature > 15 × DC required, reduce feed rate by up to 50%. For cross holes, the maximum permissible diameter is 1/4 of the nominal diameter DC. Stack drilling requires stable conditions, reduce gaps between workpiece elements. Oblique drill entry and exit up to 7° inclination possible with reduced feed rate (approx. 20 - 30%). Designation convention 8xD: DCN [size]-[L1]-[ØDS]A-[L/D] Designation convention 12xD: DCN [size]-[L1]-[ØDS]R-[L/D] Examples: No. 231715 6 DCN 060-048-12A-8D No. 231720 8 DCN 080-096-12R-12D

### Technical description

Overhang L <sub>1</sub>	168 mm
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Shank type	ISO 9766
Series	SUMOCHAM
Dia. range $D_c$	21 - 21.9 mm
Flute length $L_c$	171.18 mm
Number of cutting edges Z	2
Shank length $L_s$	56 mm
Shank $\varnothing D_s$	25 mm
Iscar item designation	DCN 210-168-25A-8D
Pilot drill required	yes, pilot drill
Manufacturer's designation	DCN 210-168-25A-8D
Version	8xD
Shank	ISO 9766
Use for drilling	concave
Use for drilling	convex
Use for drilling	Cross drilling
Use for drilling	Drilling through a stack
Through-coolant	yes
Type of product	Indexable Drill