

**ISCAR SUMOCHAM drilling head ICP k7, IC908, Ø DC: 21,5mm****Order data**

Order number	231740 21,5
GTIN	7291075247312
Item class	23J

**Description****Version:**

**Vee ground** drilling head for precise positioning and stable seating. Angled, **radial stop surfaces** for a significant increase in clamping force due to the cutting forces acting during machining. For productive drilling with **high feed rates**.

**ICP**

Main area of application **ISO P, ISO M** (especially duplex) as well as **ISO H**. Unique cutting edge preparation for the best possible compromise between cutting edge stability and cutting sharpness.

**Note:**

Cutting data applies for the base body 5×D. Drill pilot holes exclusively with drilling head of the same type – in particular for drilling heads FCP and QCP-2M. Please observe the application instructions for the base body. Cutting tolerance of the inserts: **k7** (positive toleranced cutting edge diameter).

Designation convention: [type] [Ø D<sub>c</sub>]-[addition] [cutting material]

Examples:

No. 231740 6.5 ICP 065 IC908

No. 231742 18.5 ICP 185-2M IC908

No. 231745 18.5 HCP 185-IQ IC908

## Technical description

Series	SUMOCHAM
Coating	TiAlN
Ø D	21.5 mm
for base body size	21
Number of changes/inserts	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.35 mm/rev.
Iscar item designation	ICP 215 IC908
Feed f <sub>z</sub> in steel < 55 HRC	0.2 mm/rev.
Geometry	ICP
Point angle	154 degrees
Manufacturer's designation	ICP 215 IC908
Grade	IC908
Tool material	Carbide
Type of product	Drilling head for boring

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 55 HRC	suitable	35 m/min	H
Steel < 60 HRC	suitable	35 m/min	H
TOOLOX 33	suitable	70 m/min	H
TOOLOX 44	suitable	60 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable	35 m/min	H

INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	S
Inconel	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	120 m/min	K
CuZn	suitable only under restricted conditions	155 m/min	N
Oil	suitable only under restricted conditions		
wet maximum	suitable		