



## ISCAR SUMOCHAM drilling head HCP-IQ k7, IC908, Ø DC: 9mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 231745 9      |
| GTIN         | 7291075333299 |
| 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**.

#### HCP-IQ

Main area of application **ISO P** and **ISO K**. **Best possible centring capability**, machining of curved surfaces. **Not for use in ductile materials**.

#### 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 **The minimum order quantity corresponds to one pack unit quantity (VPE) or a multiple thereof.**

## Technical description

|   |                          |
|---|--------------------------|
| for base body size                      | 9                        |
| Series                                  | SUMOCHAM                 |
| Ø D                                     | 9 mm                     |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.16 mm/rev.             |
| Iscar item designation                  | HCP 090-IQ IC908         |
| Geometry                                | HCP-IQ                   |
| Point angle                             | 140 degrees              |
| Manufacturer's designation              | HCP 090-IQ 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        |
| TOOLOX 33                      | suitable only under restricted conditions | 70 m/min       | H        |
| TOOLOX 44                      | suitable                                  | 60 m/min       | H        |
| GG(G)                          | suitable only under restricted conditions | 120 m/min      | K        |
| CuZn                           | suitable only under restricted conditions | 155 m/min      | N        |
| Oil                            | suitable only under restricted conditions |                |          |
| wet maximum                    | suitable                                  |                |          |

