ISCAR SUMOCHAM drill body Weldon shank DCN A, 3×D, Size: 26

Order data

Order number	231705 26
GTIN	7291075290998
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.**
- **Drilling convex / concave surfaces: Radius of curvature > 15 × D_C required, reduce feed rate by up to 50%.**
- **For cross holes, the maximum permissible diameter is 1/4 of the nominal diameter D_C.**
- **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: DCN [size]-[L_1]-[ØD_S]A-[L/D]**
  Examples:
  No. 231702 6 DCN 060-009-12A-1.5D
  No. 231705 6 DCN 060-018-12A-3D

Technical description

Number of cutting edges Z	2
Dia. range D_c	26 - 26.9 mm
Series	SUMOCHAM
Reach L_1	78 mm
Shank length L_s	60 mm
Shank ∅ D_s	32 mm
Iscar item designation	DCN 260-078-32A-3D
Manufacturer's designation	DCN 260-078-32A-3D
Version	3×D
Shank	ISO 9766
Use for drilling	convex
Use for drilling	concave
Use for drilling	Cross drilling
Use for drilling	Drilling through a stack
Through-coolant	yes
Type of product	Insdexable Drill