


**ISCAR SUMOCHAM drilling head HCP-IQ k7, IC908, Ø DC: 12,5mm**

**Order data**

Order number	231745 12,5
GTIN	7291075333367
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

Series	SUMOCHAM
Feed f in steel < 900 N/mm <sup>2</sup>	0.24 mm/rev.
for base body size	12
Ø D	12.5 mm
Iscar item designation	HCP 125-IQ IC908
Geometry	HCP-IQ
Point angle	135 degrees
Manufacturer's designation	HCP 125-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		

