


**ISCAR SUMOCHAM drilling head FCP k7, IC908, Ø DC: 25,5mm**

**Order data**

Order number	231790 25,5
GTIN	7291075298888
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**.

**FCP**

Main application **ISO P** and **ISO K**, secondary application ISO M. **Flat head geometry** with centring point. Advantageous for radial displacement and oblique material exit.

**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**

Number of changes/inserts	2
Ø D	25.5 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.35 mm/rev.
Series	SUMOCHAM
for base body size	25
Coating	TiAlN
Iscar item designation	FCP 255 IC908
Geometry	FCP
Point angle	140 degrees
Manufacturer's designation	FCP 255 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 only under restricted conditions	35 m/min	H
Steel < 60 HRC	suitable	35 m/min	H
TOOLOX 33	suitable only under restricted conditions	70 m/min	H
TOOLOX 44	suitable	60 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
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		