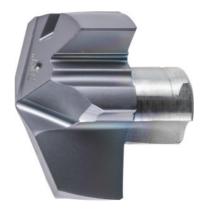


## ISCAR SUMOCHAM drilling head ICP k7, IC908, Ø DC: 20mm



## **Order data**

Order number	231740 20
GTIN	7291075247275
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**

ØD	20 mm		
Coating	TiAIN		
Series	SUMOCHAM		
Feed f in steel < 900 N/mm <sup>2</sup>	0.35 mm/rev.		
Number of changes/inserts	2		
for base body size	20		
Iscar item designation	ICP 200 IC908		
Feed $f_z$ in steel < 55 HRC	0.2 mm/rev.		
Geometry	ICP		
Point angle	154 degrees		
Manufacturer's designation	ICP 200 IC908		
Grade	IC908		
Tool material	Carbide		
Type of product	Drilling head for boring		

# User data

	Suitability	$\mathbf{V}_{c}$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	100 m/min	Р
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	Р
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	Р
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	Р
Steel < 1400 N/mm <sup>2</sup>	suitable	55 m/min	Р
Steel < 55 HRC	suitable	35 m/min	Н
Steel < 60 HRC	suitable	35 m/min	Н
TOOLOX 33	suitable	70 m/min	Н
TOOLOX 44	suitable	60 m/min	Н
HARDOX 500 < 1600 N/ mm <sup>2</sup>	suitable	35 m/min	Н

# **⚠** Hoffmann Group

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		