

**ISCAR SUMOCHAM drilling head ICP k7, IC908, Ø DC: 26mm****Order data**

Order number	231740 26
GTIN	7291075247442
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_c]-[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

Series	SUMOCHAM
Coating	TiAlN
Feed f in steel $< 900 \text{ N/mm}^2$	0.4 mm/rev.
for base body size	26
Number of changes/inserts	2
$\varnothing D$	26 mm
Iscar item designation	ICP 260 IC908
Feed f_z in steel $< 55 \text{ HRC}$	0.22 mm/rev.
Geometry	ICP
Point angle	154 degrees
Manufacturer's designation	ICP 260 IC908
Grade	IC908
Tool material	Carbide
Type of product	Drilling head for boring

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	55 m/min	P
Steel $< 55 \text{ HRC}$	suitable	35 m/min	H
Steel $< 60 \text{ HRC}$	suitable	35 m/min	H
TOOLOX 33	suitable	70 m/min	H
TOOLOX 44	suitable	60 m/min	H
HARDOX 500 $< 1600 \text{ N/mm}^2$	suitable	35 m/min	H

INOX < 900 N/mm ²	suitable only under restricted conditions	50 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	50 m/min	M
Ti > 850 N/mm ²	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		