ISCAR SUMOCHAM drilling head ICP-2M k7, IC908, Ø DC: 22mm

Order data

Order number	231742 22
GTIN	7291075289053
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-2M
Main area of application **ISO P**. Higher accuracy and better surface quality due to **4 guide chamfers**. Optimum roundness of the bore, low axial forces, increased stability, increased metal removal rate.
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

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Technical description

Number of changes/inserts	2
Coating	TiAlN
for base body size	22
Feed f in steel < 900 N/mm^2	0.35 mm/rev.
Ø D	22 mm
Series	SUMOCHAM
Iscar item designation	ICP 220-2M IC908
Geometry	ICP-2M
Point angle	154 degrees
Manufacturer's designation	ICP 220-2M IC908
Grade	IC908
Tool material	Carbide
Type of product	Drilling head for boring

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm^2	suitable	100 m/min	P
Steel < 750 N/mm^2	suitable	90 m/min	P
Steel < 900 N/mm^2	suitable	100 m/min	P
Steel < 1100 N/mm^2	suitable	70 m/min	P
Steel < 1400 N/mm^2	suitable	55 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	35 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