



ISCAR SUMOCHAM drill body Weldon shank DCN A, 1.5×D, Size: 21



Order data

Order number	231702 21
GTIN	7291075290608
Item class	23K

Description

Version:

SUMOCHAM interchangeable head drilling system for **highly efficient drilling** with interchangeable drilling heads. **Unique clamping mechanism** for convenient fixing of the drilling head without additional clamping screw. **Versatile material use** due to comprehensive drilling head range. **Optimum tool stability** with twisted cooling channels for **high concentricity** and **lowest possible axial run-out** of the bore. **Other available versions:** drill body with round shank, drill body for machining chamfers on bores when a chamfer ring is attached, drill body especially for use in multi-spindle, sliding headstock and production lathes. **Tolerance class:** IT8-IT9, concentricity: 0.03 mm.

Application:

With drilling heads **No. 231740 – 231790.**

Supplied with:

Drill body incl. assembly key for drilling heads.

Note:

- **Always select a strategy with medium cutting speeds and high feed rates.**
- **No rapid traverse and no spindle anti-clockwise rotation during retraction.**
- **Drilling convex / concave surfaces: Radius of curvature $> 15 \times D_c$ required, reduce feed rate by up to 50%.**
- **For cross holes, the maximum permissible diameter is 1/4 of the nominal diameter D_c .**
- **Stack drilling requires stable conditions, reduce gaps between workpiece elements.**
- **Oblique drill entry and exit up to 7° inclination possible with reduced feed rate (approx. 20 - 30%).**
- **Designation convention: DCN [size]-[L₁]-[ØD_s]A-[L/D]**

Examples:

No. 231702 6 DCN 060-009-12A-1.5D

No. 231705 6 DCN 060-018-12A-3D

Technical description

Dia. range D_c	21 - 21.9 mm
Series	SUMOCHAM
Shank length L_s	56 mm
Reach L_1	32 mm
Shank $\varnothing D_s$	25 mm
Number of cutting edges Z	2
Iscar item designation	DCN 210-032-25A-1.5D
Manufacturer's designation	DCN 210-032-25A-1.5D
Version	1.5xD
Shank	ISO 9766
Use for drilling	Cross drilling
Use for drilling	Drilling through a stack
Use for drilling	concave
Use for drilling	convex
Through-coolant	yes
Type of product	Insindexable Drill