



## ISCAR SUMOCHAM drill body Weldon shank DCN A, 3×D, Size: 8,5



### Order data

|              |               |
|--------------|---------------|
| Order number | 231705 8,5    |
| GTIN         | 7291075290820 |
| 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]-[L<sub>i</sub>]-[ØD<sub>s</sub>]A-[L/D]**

#### Examples:

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

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

## Technical description

|                            |                          |
|----------------------------|--------------------------|
| Reach $L_1$                | 25 mm                    |
| Shank $\varnothing D_s$    | 12 mm                    |
| Dia. range $D_c$           | 8.5 - 8.9 mm             |
| Number of cutting edges Z  | 2                        |
| Shank length $L_s$         | 45 mm                    |
| Series                     | SUMOCHAM                 |
| Iscar item designation     | DCN 085-025-12A-3D       |
| Manufacturer's designation | DCN 085-025-12A-3D       |
| Version                    | 3xD                      |
| Shank                      | ISO 9766                 |
| Use for drilling           | convex                   |
| Use for drilling           | concave                  |
| Use for drilling           | Cross drilling           |
| Use for drilling           | Drilling through a stack |
| Through-coolant            | yes                      |
| Type of product            | Insindexable Drill       |