



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



Order data

| | |
|--------------|---------------|
| Order number | 231710 8,5 |
| GTIN | 7291075291339 |
| 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

| | |
|----------------------------|--------------------------|
| Shank $\varnothing D_s$ | 12 mm |
| Series | SUMOCHAM |
| Number of cutting edges Z | 2 |
| Dia. range D_c | 8.5 - 8.9 mm |
| Shank length L_s | 45 mm |
| Reach L_1 | 42 mm |
| Iscar item designation | DCN 085-042-12A-5D |
| Manufacturer's designation | DCN 085-042-12A-5D |
| Version | 5xD |
| 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 |