

**ISCAR SUMOCHAM drilling head ICP k7, IC908, Ø DC: 12,5mm****Order data**

| | |
|--------------|---------------|
| Order number | 231740 12,5 |
| GTIN | 7291075247190 |
| 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 **The minimum order quantity corresponds to one pack unit quantity (VPE) or a multiple thereof.**

Technical description

| | |
|--|--------------------------|
| Coating | TiAlN |
| Feed f in steel $< 900 \text{ N/mm}^2$ | 0.24 mm/rev. |
| for base body size | 12 |
| $\varnothing D$ | 12.5 mm |
| Number of changes/inserts | 2 |
| Series | SUMOCHAM |
| Iscar item designation | ICP 125 IC908 |
| Feed f_z in steel $< 55 \text{ HRC}$ | 0.14 mm/rev. |
| Geometry | ICP |
| Point angle | 154 degrees |
| Manufacturer's designation | ICP 125 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 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 | | |