



## ISCAR SUMOCHAM drilling head ICM k7, IC908, Ø DC: 14mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 231750 14     |
| GTIN         | 7291075244816 |
| 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**.

#### ICM

Main area of application **ISO M, ISO S** (especially Inconel and titanium) as well as ISO N. Cutting edge with negative chamfer and special rounding – especially for stainless steel machining.

#### 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<sub>c</sub>]-[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

|   |                          |
|---|--------------------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.2 mm/rev.              |
| for base body size                                | 14                       |
| Ø D   | 14 mm                    |
| Series  | SUMOCHAM                 |
| Iscar item designation                            | ICM 140 IC908            |
| Feed f in Inconel®                                | 0.15 mm/rev.             |
| Geometry  | ICM                      |
| Point angle                                       | 154 degrees              |
| Manufacturer's designation                        | ICM 140 IC908            |
| Grade   | IC908                    |
| Tool material                                     | Carbide                  |
| Type of product                                   | Drilling head for boring |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 155 m/min      | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 120 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable only under restricted conditions | 100 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable only under restricted conditions | 90 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable only under restricted conditions | 100 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 70 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 55 m/min       | P        |

|                              |   |           |   |
|------------------------------|---|-----------|---|
| TOOLOX 33                    | suitable only under restricted conditions | 70 m/min  | H |
| TOOLOX 44                    | suitable                                  | 60 m/min  | H |
| INOX < 900 N/mm <sup>2</sup> | suitable                                  | 50 m/min  | M |
| INOX > 900 N/mm <sup>2</sup> | suitable                                  | 50 m/min  | M |
| Ti > 850 N/mm <sup>2</sup>   | suitable                                  | 35 m/min  | S |
| Inconel                      | suitable                                  | 35 m/min  | S |
| GG(G)                        | suitable only under restricted conditions | 120 m/min | K |
| CuZn                         | suitable                                  | 155 m/min | N |
| Oil                          | suitable only under restricted conditions |           |   |
| wet maximum                  | suitable                                  |           |   |