



## ISCAR SUMOCHAM drill body Parallel shank DCN R, 12xD, Size: 21



### Order data

Order number	231720 21
GTIN	7291075297126
Item class	23K

### Description

#### Version:

SUMOCHAM interchangeable head drilling system for highly efficient drilling with interchangeable cutting edges. Unique clamping mechanism for convenient fixing of the cutter insert without additional clamping screw. Versatile material use due to comprehensive cutter insert range. Optimum tool stability with simultaneously helical coolant channels for high concentricity and lowest possible axial run-out of the bore. Other available versions: base body with round shank, base body for machining chamfers on bores when a chamfer ring is attached, base 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. For drilling depths of  $8 \times D$  and more, piloting of at least  $1.5 \times DC$  with same cutter insert required. Drilling convex / concave surfaces: Radius of curvature  $> 15 \times DC$  required, reduce feed rate by up to 50%. For cross holes, the maximum permissible diameter is 1/4 of the nominal diameter DC. Stack drilling requires stable conditions, reduce gaps between workpiece elements. Oblique drill entry and exit up to  $7^\circ$  inclination possible with reduced feed rate (approx. 20 - 30%). Designation convention  $8 \times D$ : DCN [size]-[L1]-[ØDS]A-[L/D] Designation convention  $12 \times D$ : DCN [size]-[L1]-[ØDS]R-[L/D] Examples: No. 231715 6 DCN 060-048-12A-8D No. 231720 8 DCN 080-096-12R-12D

### Technical description

Number of cutting edges Z	2
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Series	SUMOCHAM
Dia. range $D_c$	21 - 21.9 mm
Shank type	Plain shank with h6
Overhang $L_1$	252 mm
Shank $\varnothing D_s$	25 mm
Flute length $L_c$	255.8 mm
Shank length $L_s$	56 mm
Iscar item designation	DCN 210-252-25R-12D
Pilot drill required	yes, pilot drill
Manufacturer's designation	DCN 210-252-25R-12D
Version	12xD
Shank	Plain shank with h6
Use for drilling	convex
Use for drilling	Drilling through a stack
Use for drilling	concave
Use for drilling	Cross drilling
Through-coolant	yes
Type of product	Insdexable Drill