


ISCAR SUMOCHAM drilling head ICP-2M k7, IC908, Ø DC: 23,5mm

Order data

Order number	231742 23,5
GTIN	7291075288636
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-2M

Main area of application **ISO P**. Higher accuracy and better surface quality due to **4 guide chamfers**. Optimum roundness of the bore, low axial forces, increased stability, increased metal removal rate.

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

Technical description

Coating	TiAlN
Number of changes/inserts	2
for base body size	23
Feed f in steel < 900 N/mm ²	0.35 mm/rev.
Ø D	23.5 mm
Series	SUMOCHAM
Iscar item designation	ICP 235-2M IC908
Geometry	ICP-2M
Point angle	154 degrees
Manufacturer's designation	ICP 235-2M IC908
Grade	IC908
Tool material	Carbide
Type of product	Drilling head for boring

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	100 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	55 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	35 m/min	H
GG(G)	suitable only under restricted conditions	120 m/min	K
CuZn	suitable only under restricted conditions	155 m/min	N

Oil	suitable only under restricted conditions
wet maximum	suitable