



ISCAR SUMOCHAM drilling head FCP k7, IC908, Ø DC: 27mm



Order data

| | |
|--------------|---------------|
| Order number | 231790 27 |
| GTIN | 7291075298246 |
| 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**.

FCP

Main application **ISO P** and **ISO K**, secondary application ISO M. **Flat head geometry** with centring point. Advantageous for radial displacement and oblique material exit.

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

| | |
|---|--------------------------|
| Ø D | 27 mm |
| Number of changes/inserts for base body size | 2 27 |
| Coating | TiAlN |
| Series | SUMOCHAM |
| Feed f in steel < 900 N/mm ² | 0.4 mm/rev. |
| Iscar item designation | FCP 270 IC908 |
| Geometry | FCP |
| Point angle | 140 degrees |
| Manufacturer's designation | FCP 270 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 | 35 m/min | H |
| TOOLOX 33 | suitable only under restricted conditions | 70 m/min | H |
| TOOLOX 44 | suitable | 60 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 |
| 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 | | |