



ISCAR SUMOCHAM drilling head ICM k7, IC908, Ø DC: 24,5mm



Order data

| | |
|--------------|---------------|
| Order number | 231750 24,5 |
| GTIN | 7291075243987 |
| 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_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

| | |
|---|--------------------------|
| Series | SUMOCHAM |
| Ø D | 24.5 mm |
| Feed f in stainless steel > 900 N/mm ² | 0.24 mm/rev. |
| Coating | TiAlN |
| Number of changes/inserts | 2 |
| for base body size | 24 |
| Iscar item designation | ICM 245 IC908 |
| Feed f in Inconel® | 0.18 mm/rev. |
| Geometry | ICM |
| Point angle | 154 degrees |
| Manufacturer's designation | ICM 245 IC908 |
| Grade | IC908 |
| Tool material | Carbide |
| Type of product | Drilling head for boring |

User data

| | Suitability | V _c | 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 ² | suitable only under restricted conditions | 100 m/min | P |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 90 m/min | P |
| Steel < 900 N/mm ² | suitable only under restricted conditions | 100 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 70 m/min | P |

| | | | |
|--------------------------------|---|-----------|---|
| Steel < 1400 N/mm ² | 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 ² | suitable | 50 m/min | M |
| INOX > 900 N/mm ² | suitable | 50 m/min | M |
| Ti > 850 N/mm ² | 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 | | |