



ISCAR SUMOCHAM drilling head ICP-2M k7, IC908, Ø DC: 12,5mm



Order data

| | |
|--------------|---------------|
| Order number | 231742 12,5 |
| GTIN | 7291075287387 |
| 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 **The minimum order quantity corresponds to one pack unit quantity (VPE) or a multiple thereof.**

Technical description

| | |
|---|--------------------------|
| Coating | TiAlN |
| Series | SUMOCHAM |
| for base body size | 12 |
| Ø D | 12.5 mm |
| Feed f in steel < 900 N/mm ² | 0.24 mm/rev. |
| Number of changes/inserts | 2 |
| Iscar item designation | ICP 125-2M IC908 |
| Geometry | ICP-2M |
| Point angle | 154 degrees |
| Manufacturer's designation | ICP 125-2M 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 | | |