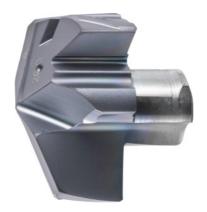


## ISCAR SUMOCHAM drilling head ICP-2M k7, IC908, Ø DC: 25,5mm



## **Order data**

Order number	231742 25,5
GTIN	7291075288803
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] [ $\varnothing$  D<sub>c</sub>]-[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**

for base body size	25		
Number of changes/inserts	2		
Series	SUMOCHAM		
Feed f in steel < 900 N/mm <sup>2</sup>	0.35 mm/rev.		
Coating	TiAlN		
ØD	25.5 mm		
Iscar item designation	ICP 255-2M IC908		
Geometry	ICP-2M		
Point angle	154 degrees		
Manufacturer's designation	ICP 255-2M IC908		
Grade	IC908		
Tool material	Carbide		
Type of product	Drilling head for boring		

## **User data**

	Suitability	<b>V</b> <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	100 m/min	Р
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	Р
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	Р
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	Р
Steel < 1400 N/mm <sup>2</sup>	suitable	55 m/min	Р
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	н
Steel < 60 HRC	suitable only under restricted conditions	35 m/min	н
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	