



## ISCAR SUMOCHAM drill body Weldon shank DCN A, 1.5×D, Size: 8,5



### Order data

Order number	231702 8,5
GTIN	7291075290721
Item class	23K

### Description

#### Version:

SUMOCHAM interchangeable head drilling system for **highly efficient drilling** with interchangeable drilling heads. **Unique clamping mechanism** for convenient fixing of the drilling head without additional clamping screw. **Versatile material use** due to comprehensive drilling head range. **Optimum tool stability** with twisted cooling channels for **high concentricity** and **lowest possible axial run-out** of the bore. **Other available versions:** drill body with round shank, drill body for machining chamfers on bores when a chamfer ring is attached, drill body especially for use in multi-spindle, sliding headstock and production lathes. **Tolerance class:** IT8-IT9, concentricity: 0.03 mm.

#### Application:

With drilling heads **No. 231740 – 231790.**

#### Supplied with:

Drill body incl. assembly key for drilling heads.

#### Note:

- **Always select a strategy with medium cutting speeds and high feed rates.**
- **No rapid traverse and no spindle anti-clockwise rotation during retraction.**
- **Drilling convex / concave surfaces: Radius of curvature  $> 15 \times D_c$  required, reduce feed rate by up to 50%.**
- **For cross holes, the maximum permissible diameter is 1/4 of the nominal diameter  $D_c$ .**
- **Stack drilling requires stable conditions, reduce gaps between workpiece elements.**
- **Oblique drill entry and exit up to 7° inclination possible with reduced feed rate (approx. 20 - 30%).**
- **Designation convention: DCN [size]-[L<sub>1</sub>]-[ØD<sub>s</sub>]A-[L/D]**

#### Examples:

**No. 231702 6 DCN 060-009-12A-1.5D**

**No. 231705 6 DCN 060-018-12A-3D**

## Technical description

Shank length $L_s$	45 mm
Reach $L_1$	13 mm
Series	SUMOCHAM
Dia. range $D_c$	8.5 - 8.9 mm
Shank $\varnothing D_s$	12 mm
Number of cutting edges Z	2
Iscar item designation	DCN 085-013-12A-1.5D
Manufacturer's designation	DCN 085-013-12A-1.5D
Version	1.5xD
Shank	ISO 9766
Use for drilling	Cross drilling
Use for drilling	Drilling through a stack
Use for drilling	concave
Use for drilling	convex
Through-coolant	yes
Type of product	Insindexable Drill