



## ISCAR SUMOCHAM drill body Parallel shank DCN R, 12xD, Size: 9,5



### Order data

|              |               |
|--------------|---------------|
| Order number | 231720 9,5    |
| GTIN         | 7291075297287 |
| Item class   | 23K           |

### Description

#### Version:

SUMOCHAM interchangeable head drilling system for highly efficient drilling with interchangeable cutting edges. Unique clamping mechanism for convenient fixing of the cutter insert without additional clamping screw. Versatile material use due to comprehensive cutter insert range. Optimum tool stability with simultaneously helical coolant channels for high concentricity and lowest possible axial run-out of the bore. Other available versions: base body with round shank, base body for machining chamfers on bores when a chamfer ring is attached, base 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. For drilling depths of  $8 \times D$  and more, piloting of at least  $1.5 \times DC$  with same cutter insert required. Drilling convex / concave surfaces: Radius of curvature  $> 15 \times DC$  required, reduce feed rate by up to 50%. For cross holes, the maximum permissible diameter is 1/4 of the nominal diameter DC. Stack drilling requires stable conditions, reduce gaps between workpiece elements. Oblique drill entry and exit up to  $7^\circ$  inclination possible with reduced feed rate (approx. 20 - 30%). Designation convention  $8 \times D$ : DCN [size]-[L1]-[ØDS]A-[L/D] Designation convention  $12 \times D$ : DCN [size]-[L1]-[ØDS]R-[L/D] Examples: No. 231715 6 DCN 060-048-12A-8D No. 231720 8 DCN 080-096-12R-12D

### Technical description

|                  |              |
|------------------|--------------|
| Dia. range $D_c$ | 9.5 - 9.9 mm |
|------------------|--------------|

|                            |                          |
|----------------------------|--------------------------|
| Shank type                 | Plain shank with h6      |
| Overhang $L_1$             | 114 mm                   |
| Series                     | SUMOCHAM                 |
| Shank $\varnothing D_s$    | 12 mm                    |
| Flute length $L_c$         | 115.7 mm                 |
| Number of cutting edges Z  | 2                        |
| Shank length $L_s$         | 45 mm                    |
| Iscar item designation     | DCN 095-114-12R-12D      |
| Pilot drill required       | yes, pilot drill         |
| Manufacturer's designation | DCN 095-114-12R-12D      |
| Version                    | 12xD                     |
| Shank                      | Plain shank with h6      |
| Use for drilling           | convex                   |
| Use for drilling           | Drilling through a stack |
| Use for drilling           | concave                  |
| Use for drilling           | Cross drilling           |
| Through-coolant            | yes                      |
| Type of product            | Insindexable Drill       |