

DRILLING

15-2022

MAY 2022

METRIC

# NPA

New Product Announcement



Self Centering  
Insert



Cost Effective  
Insert



Internal coolant



**SUMOCHAM**  
CHAMDRILL LINE

## QCP Drilling Heads in New Size of 4.5mm



Self Centering  
Insert



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## **SUMOCHAM** CHAMDRILL LINE

### Highlights

#### ISCAR Expands the SUMOCHAM QCP Drilling Heads Range to Include Small Diameters from 4.5mm

The QCP drilling heads ensure a hole tolerance of IT8-IT9 and can be mounted on any **SUMOCHAM** standard drill body with the appropriate pocket size.

#### Availability

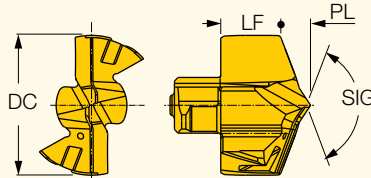
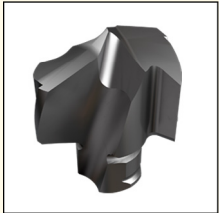
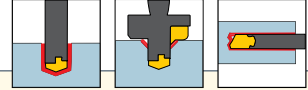
In stock.


[Click for Short Video](#)

### SUMOCHAM CHAMDRILL LINE

#### QCP-2M

Exchangeable Self-Centering Drilling Head for DCN Drills,  
for ISO P & K Materials with High Surface Finish Results



Designation	Dimensions					SSC <sup>(2)</sup>	 SK DCN	IC908
	DC	LF	PL	SIG				
QCP 045 <sup>(1)</sup>	4.50	2.84	0.910	136	4.5	SK DCN 4-4.99	●	
QCP 046 <sup>(1)</sup>	4.60	2.82	0.930	136	4.5	SK DCN 4-4.99	●	
QCP 048 <sup>(1)</sup>	4.80	2.78	0.970	136	4.5	SK DCN 4-4.99	●	
QCP 050 <sup>(1)</sup>	5.00	3.05	1.030	136	5	SK DCN 5-5.99	●	
QCP 051 <sup>(1)</sup>	5.10	3.03	1.050	136	5	SK DCN 5-5.99	●	
QCP 055 <sup>(1)</sup>	5.50	2.95	1.190	136	5	SK DCN 5-5.99	●	

• Can provide high surface finish of up to 1.6 Ra hole cylindricity and straightness of up to 0.05 mm

<sup>(1)</sup> Single margin

<sup>(2)</sup> Seat size code

### SUMOCHAM CHAMDRILL LINE

#### Recommended Machining Conditions

ISO	Material	Condition	Tensile Strength [N/mm <sup>2</sup> ]	Hardness HB	Mtl. No.	Feed vs. Drill Diameter			
						v m/min	D=4-4.9	D=5-5.9	
							mm/rev		
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	420	125	1	80-110-140	0.04 0.06 0.08	0.07 0.09 0.11
		>= 0.25 %C	Annealed	650	190	2	80-105-130		
		< 0.55 %C	Quenched and tempered	850	250	3	80-100-120		
		>= 0.55 %C	Annealed	750	220	4	70-90-110		
			Quenched and tempered	1000	300	5	50-70-90		
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	80-100-120	0.04 0.06 0.08	0.07 0.10 0.13	
		Quenched and tempered	930	275	7	70-90-110			
			1000	300	8	50-70-90			
			1200	350	9	40-55-70			
	High alloyed steel, cast steel, and tool steel	Annealed	680	200	10	50-70-90	0.06 0.07 0.08	0.07 0.09 0.10	
		Quenched and tempered	1100	325	11	40-60-80			
	Stainless steel and cast steel	Ferritic/martensitic	680	200	12	40-55-70	0.05 0.06 0.07	0.06 0.07 0.08	
		Martensitic	820	240	13	40-55-70			
K	Grey cast iron (GG)	Ferritic/pearlitic		180	15	90-125-160	0.04 0.06 0.08	0.1 0.13 0.15	
		Pearlitic		260	16	80-110-140			
	Nodular cast iron (GGG)	Ferritic		160	17	90-135-180			
		Pearlitic		250	18	80-110-140			
	Malleable cast iron	Ferritic		130	19	90-125-160			
		Pearlitic		230	20	80-110-140			

■ Recommended cutting data

According to wear results, conditions can be changed in order to optimize performance. The data refers to IC908.