

DRILLING

12-2022

APRIL 2022

METRIC

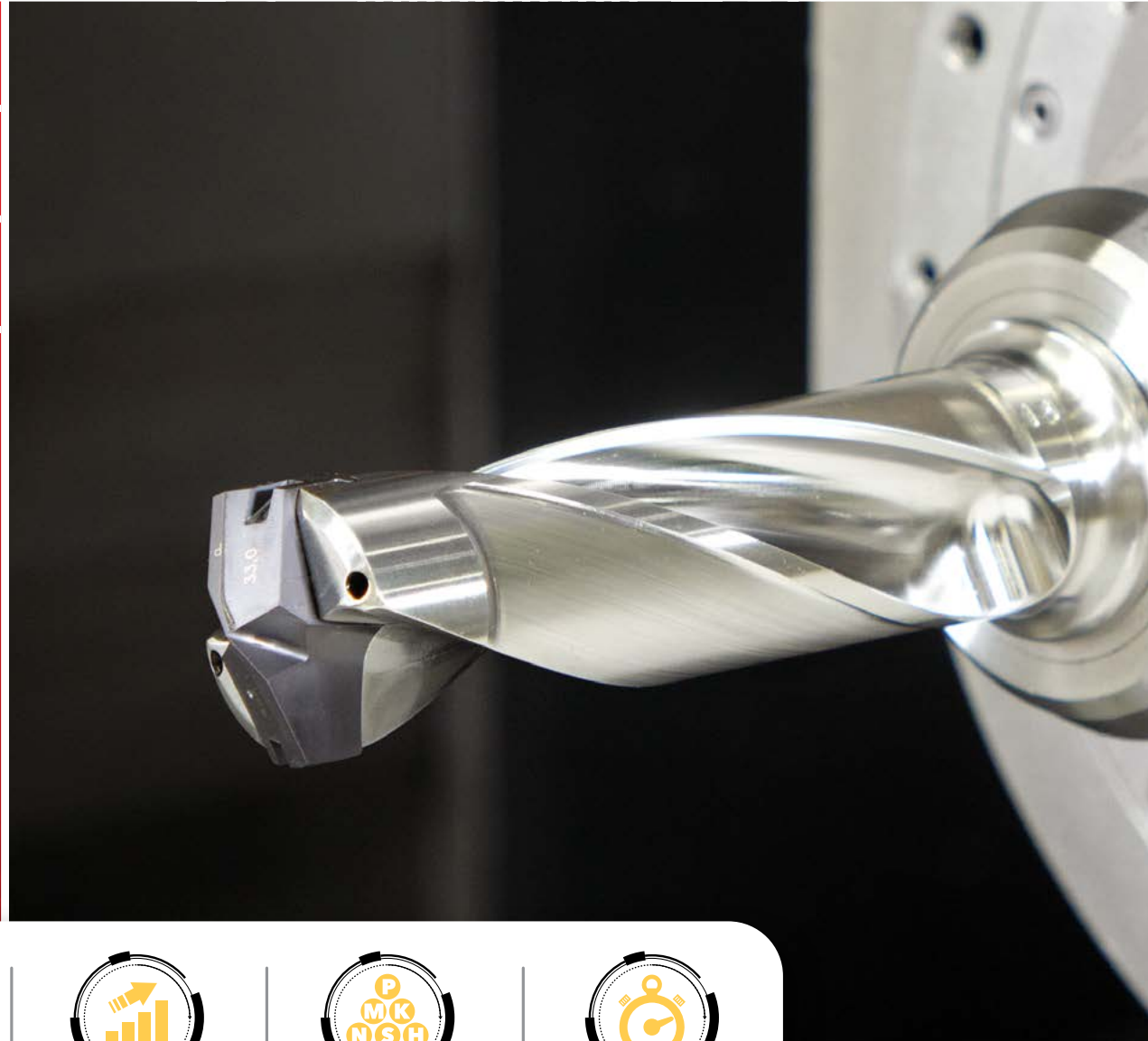
NPA

New Product Announcement

Automation
MILLING Machin
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Connectivity
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Productivity
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NEW Threading
NEW Met
ISCAR
Smart
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STRY4.0
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Automation
MILLING Machin
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Systems
Innovation DRILLING
Connectivity
mation



High Productivity



For Stainless Steel,
Steel and Super
Alloys Materials



No Steup Time



CHAM IQ DRILL

700 LINE

New Large Diameter IFP Drilling Heads for Machining ISO P, ISO M and High Temp. Alloys (ISO S) Materials

METRIC



High Productivity



For Stainless Steel,
Steel and Super
Alloys Materials



No Setup Time

NPA

New Product Announcement

CHAMIQDRILL

700 LINE

Highlights

A New Drilling Head Geometry in 33-40mm Diameters for Machining ISO P, ISO M and ISO S Materials

- The new IFP drill heads can be mounted on any CHAMIQDRILL drill featuring the appropriate pocket size
- High wear resistance
- Stable and predictable wear progression
- IT10 tolerance can be obtained
- Produced from IC908 grade – a PVD coated fine submicron grain substrate
- The drill head is designed with a honed cutting edge
- Before using IFP geometry inserts with a drill **above 5xD ratio**, a **Pre-Hole should be prepared** by using a DFN 1.5xD to guide the drill (an endmill can be used)

Availability

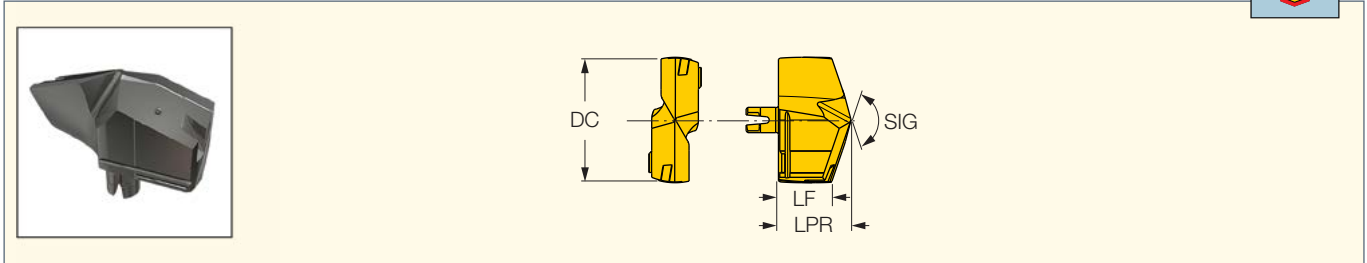
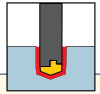
In stock.

CHAM IQ DRILL

700 LINE

IFP-IQ

Exchangeable DFN Drill Heads for Machining ISO P, ISO M and High Temp. Alloys (ISO S) Materials



Designation	Dimensions					IC908
	DC	LPR	LF	SSC ⁽¹⁾	SIG	
IFP 330-IQ	33.00	18.50	13.48	33.0	140	●
IFP 332-IQ	33.20	18.50	13.45	33.0	140	●
IFP 335-IQ	33.50	18.50	13.41	33.0	140	●
IFP 340-IQ	34.00	19.70	14.53	34.0	140	●
IFP 345-IQ	34.50	19.70	14.46	34.0	140	●
IFP 350-IQ	35.00	19.70	14.38	35.0	140	●
IFP 355-IQ	35.50	19.70	14.30	35.0	140	●
IFP 360-IQ	36.00	20.80	15.33	36.0	140	●
IFP 362-IQ	36.20	20.80	15.30	36.0	140	●
IFP 365-IQ	36.50	20.80	15.25	36.0	140	●
IFP 370-IQ	37.00	20.80	15.18	37.0	140	●
IFP 375-IQ	37.50	20.80	15.10	37.0	140	●
IFP 380-IQ	38.00	22.00	16.22	38.0	140	●
IFP 381-IQ	38.10	22.00	16.21	38.0	140	●
IFP 385-IQ	38.50	22.00	16.15	38.0	140	●
IFP 390-IQ	39.00	22.00	16.07	39.0	140	●
IFP 392-IQ	39.20	22.00	16.04	39.0	140	●
IFP 395-IQ	39.50	22.00	16.00	39.0	140	●
IFP 397-IQ	39.70	22.00	15.97	39.0	140	●
IFP 400-IQ	40.00	22.00	15.92	39.0	140	●

• Intermediate sizes can be supplied on request • Before using IFP geometry inserts with a drill above 5xD ratio, a pre-hole should be prepared by using a DFN 1.5xD to guide the drill (an endmill can be used)

⁽¹⁾ Seat size code

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New Product Announcement

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700 LINE

Cutting Condition Recommendations

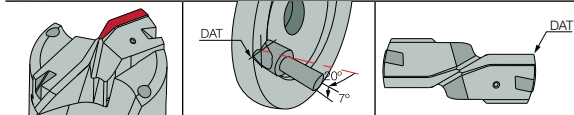
Mtl. No.	V m/min	IFP		
		CHAMIQDRILL		
Feed vs. Drill Diameter		D=33.0-40.0		
		mm/rev		
1	80-110-140	0.30	0.40	0.50
2	80-105-130			
3	80-100-120			
4	70-90-110			
5	50-70-90			
6	80-100-120	0.30	0.40	0.50
7	70-90-110			
8	50-70-90			
9	40-55-70			
10	50-70-90			
11	40-60-80	0.25	0.30	0.35
12	40-60-80	0.20	0.27	0.35
13				
14	30-50-70	0.20	0.27	0.35
31	30-45-60	0.16	0.20	0.25
32	20-35-50			
33				
34				
35				
36	20-35-50	0.18	0.22	0.27
37				

• Recommended cutting data

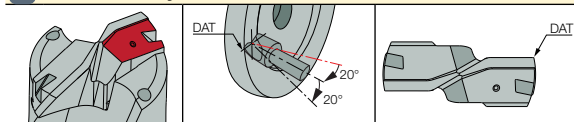
Regrinding Instructions for IFP Geometry

After each grinding operation, rotate the drill 180° and repeat the grinding procedure.

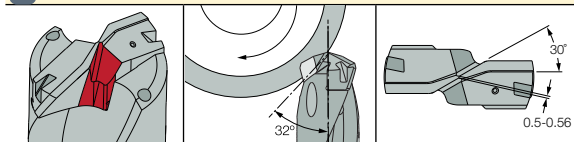
1 Primary Clearance



2 Secondary Clearance



3 Chisel



4 Edge Preparation

