

## **ISCAR DEEP DRILL**

**New Guide Pads Grade and Design  
for Deep Hole Drilling Tools**

# ISCAR DEEP DRILL

## Highlights

**The guide pad series for deep hole tools is being expanded with a new IC928 grade and double chamfer feature.**

The IC928 grade has excellent chipping resistance and coating adhesion by using its own cemented carbide base material, which prolongs life by suppressing sudden defects, especially in a water soluble environment and in exotic materials.

The double chamfer at the edge of the guide pad helps smooth entry into the machining hole, prevents premature wear, reduces the risk of guide pad damage, and improves surface finish by minimizing the risk of scratching the hole surface.



Suitable for all deep drilling families - Tri-Fine, Fine-Beam, UNIDEX (STS/DTS)

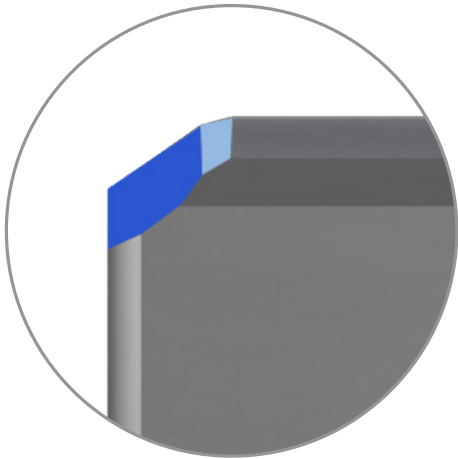
## ISCAR DEEP DRILL

### Features

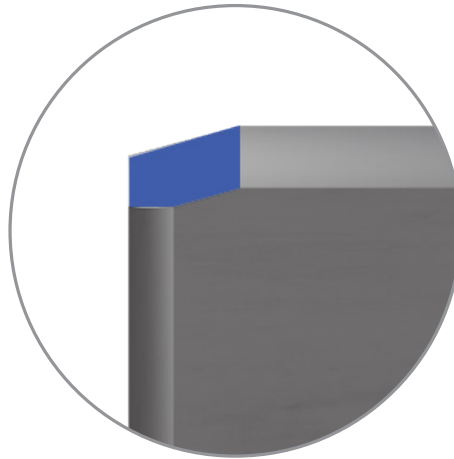
- New grade IC928 offers outstanding fracture resistance in oil and water-soluble environments
- Adopting a double chamfer greatly reduces the risk of chipping when entering a machined hole

\* Double chamfer feature will also apply to other existing grades in the future

**Double Chamfer**



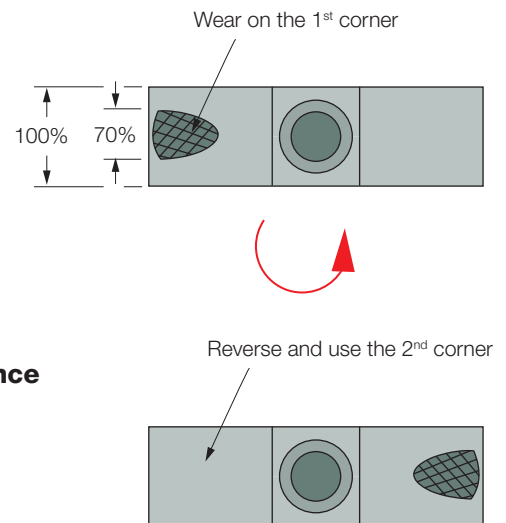
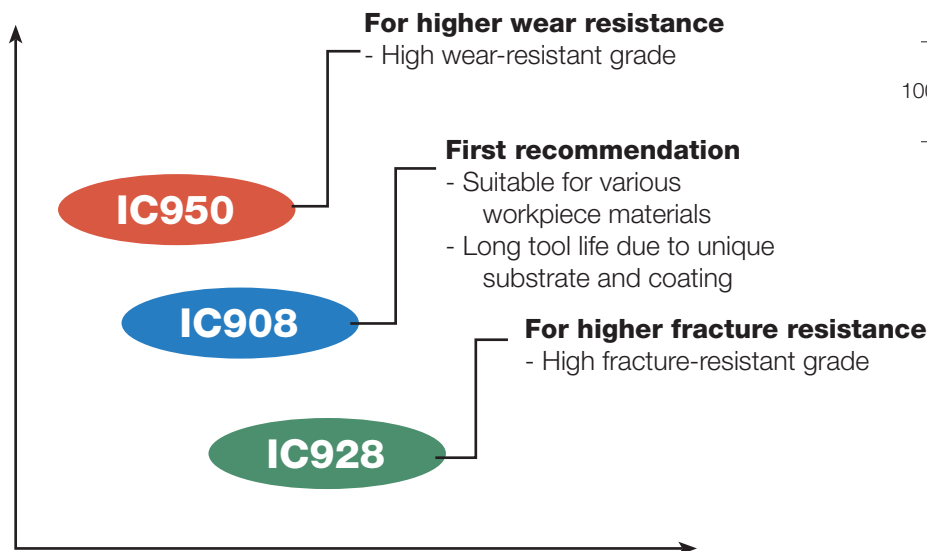
**Conventional**



### Guide pads

Guide pads are subject to wear, like inserts

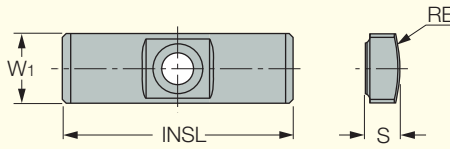
- Each guide pad can be used on two sides. When the first corner wears out 70% of the width, reverse the guide pad to use the second corner.
- Replace with a new guide pad when the second corner wears out.



# ISCAR DEEP DRILL

## GPS

Deep Drilling Solid Carbide Guide Pads



	Designation	Dimensions				Tough ↔ Hard		
		W1	RE	INSL	S	IC928	IC950	IC908
<b>NEW</b>	GPS-04-16-055-DC	4.0	5.50	16.00	2.0	•		•
	GPS-04-16-055	4.0	5.50	16.00	2.0			•
<b>NEW</b>	GPS-05-18-060-DC	5.0	6.00	18.00	2.5	•		•
	GPS-05-18-060	5.0	6.00	18.00	2.5			•
<b>NEW</b>	GPS-05-18-075-DC	5.0	7.50	18.00	2.5	•		•
	GPS-05-18-075	5.0	7.50	18.00	2.5			•
	GPS-06-20-075	6.0	7.50	20.00	3.0		•	•
<b>NEW</b>	GPS-06-20-085-DC	6.0	8.50	20.00	3.0	•		•
	GPS-06-20-085	6.0	8.50	20.00	3.0		•	•
<b>NEW</b>	GPS-06-20-100-DC	6.0	10.00	20.00	3.0	•		•
	GPS-06-20-100	6.0	10.00	20.00	3.0		•	•
<b>NEW</b>	GPS-06-20-120-DC	6.0	12.00	20.00	3.0	•		•
	GPS-06-20-120	6.0	12.00	20.00	3.0		•	•
<b>NEW</b>	GPS-07-20-120-DC	7.0	12.00	20.00	3.5	•		•
	GPS-07-20-120	7.0	12.00	20.00	3.5		•	•
<b>NEW</b>	GPS-08-25-155-DC	8.0	15.50	25.00	4.5	•		•
	GPS-08-25-155	8.0	15.50	25.00	4.5		•	•
<b>NEW</b>	GPS-10-30-200-DC	10.0	20.00	30.00	4.5	•		•
	GPS-10-30-200	10.0	20.00	30.00	4.5		•	•
<b>NEW</b>	GPS-10-35-200-DC	10.0	20.00	35.00	4.5	•		•
	GPS-10-35-200	10.0	20.00	35.00	6.0		•	•
<b>NEW</b>	GPS-12-35-250-DC	12.0	25.00	35.00	5.5	•		•
	GPS-12-35-250	12.0	25.00	35.00	5.5		•	•
<b>NEW</b>	GPS-14-40-250-DC	14.0	25.00	40.00	7.5	•		•
	GPS-14-40-250	14.0	25.00	40.00	7.5			•
<b>NEW</b>	GPS-18-40-300-DC	18.0	30.00	40.00	9.0	•		•
	GPS-18-40-300	18.0	30.00	40.00	9.0			•

\*DC- Double Chamfer

priority	Grade Recommendation					
	Oil Coolant			Water Based Coolant		
	1	2	3	1	2	3
<b>ISO-P</b>	950	908	928	928	908	-
<b>ISO-K</b>	950	908	928	928	908	-
<b>ISO-M</b>	928	908	950	928	908	-
<b>ISO-S</b>	928	908	950	928	908	-