

NPA

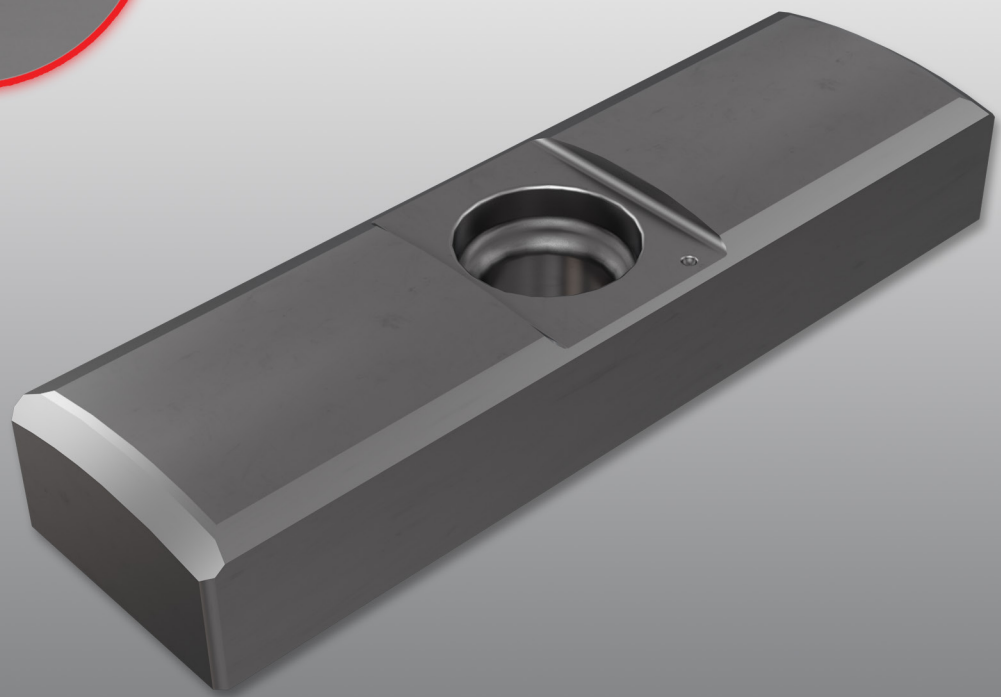
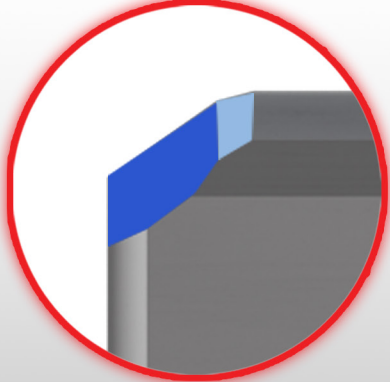
New Product Announcement

HOLE MAKING

09-2020

JUNE 2020 • METRIC

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ISCAR DEEP DRILL

REVISED

**IC908 Grade Option for
the New Double Chamfer Guide Pads**

ISCAR DEEP DRILL

Highlights

Due to the significant advantages of double chamfer guide pads for deep hole tools, the line is being expanded to include an IC908 grade option.

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.

Double chamfer guide pads will be launched with the **IC908** grade, which provides excellent wear resistance, while **IC928** (launched previously) provides excellent toughness, especially with water-based coolant.



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

- Production category:** Guide pads for indexable insert drills
- Application areas:** Carbon steel, alloy steel, cast iron, heat resistant superalloys
- Diameter range:** Ø12.00 mm - Ø293.99 mm
- Target markets:** Die & mold, heavy equipment, power generation, automotive oil & gas, and aerospace

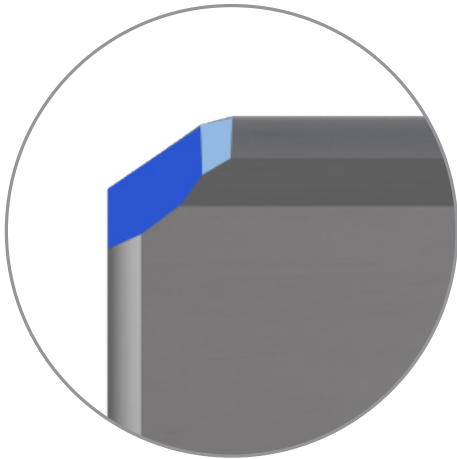
ISCAR DEEP DRILL

Features

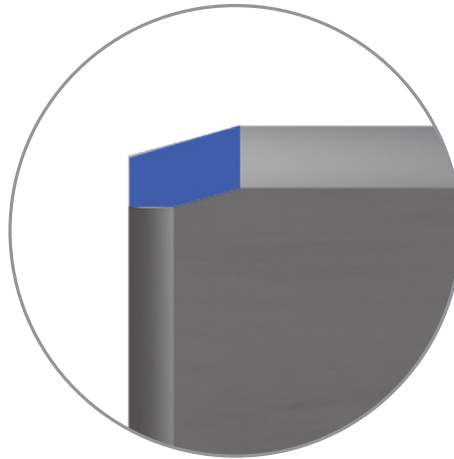
- IC908 and IC928 offers outstanding fracture resistance in oil and water-soluble environments
- Adopting a double chamfer greatly reduces the risk of chipping when entering a machined hole

*** Single chamfer guide pads will be phased out by June 2021**

Double Chamfer



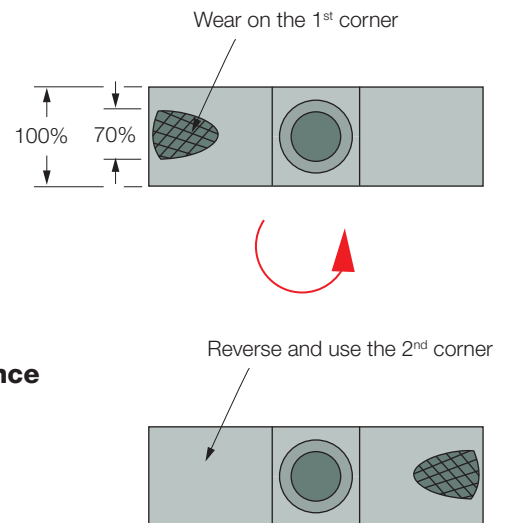
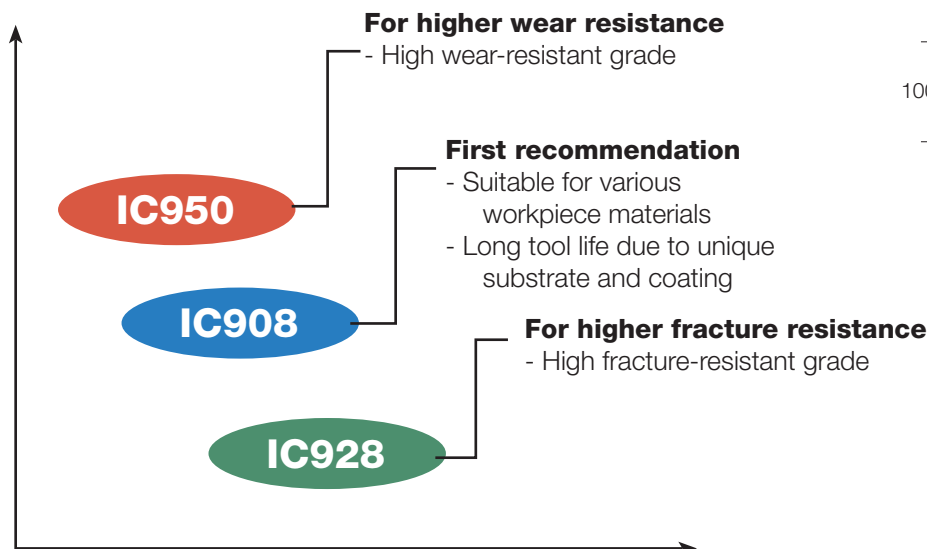
Conventional



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.



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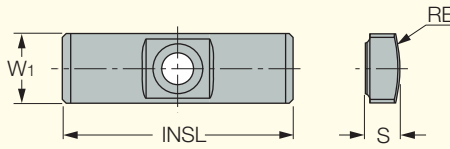
Applicability

- Guide pads with high fracture resistance for use in oil and water-soluble environments
- Dedicated carbide substrate has superior resistance to fracture and thermal cracks
- Double-chamfer geometry improves surface finish and tool life

ISCAR DEEP DRILL

GPS

Deep Drilling Solid Carbide Guide Pads



| | Designation | Dimensions | | | | Tough ↔ Hard | | |
|------------|------------------|------------|-------|-------|-----|--------------|-------|-------|
| | | W1 | RE | INSL | S | IC928 | IC950 | IC908 |
| NEW | 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 | | | ● |
| NEW | 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 | | | ● |
| NEW | 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 | | | ● |
| NEW | GPS-06-20-075-DC | 6.0 | 7.50 | 20.00 | 3.0 | | | ● |
| | GPS-06-20-075 | 6.0 | 7.50 | 20.00 | 3.0 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | ● | ● |
| NEW | 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 | | | ● |
| NEW | 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

Grade Recommendation

| Priority | Oil Coolant | | | Water Based Coolant | | |
|----------|-------------|-----|-----|---------------------|-----|---|
| | 1 | 2 | 3 | 1 | 2 | 3 |
| ISO-P | 950 | 908 | 928 | 928 | 908 | - |
| ISO-K | 950 | 908 | 928 | 928 | 908 | - |
| ISO-M | 928 | 908 | 950 | 928 | 908 | - |
| ISO-S | 928 | 908 | 950 | 928 | 908 | - |