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# NPA

New Product Announcement

DRILLING

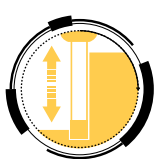
35-2024

JUNE 2024

METRIC



High Productivity



Long Overhang



Internal Coolant



## **SOLIDDRILL**

# Introducing New Extra Long Solid Carbide Drills for Cast Iron Machining





High Productivity



Long Overhang



Internal Coolant

# NPA

## New Product Announcement

### SOLIDDRILL

## Highlights

### New SCD-IXC Long Drills Increase Cast Iron Machining Performance

Due to the success of our long drills line in the market, we have now added an additional geometry for cast iron. The combination of the low helix flute and the triple-margin design increases tool rigidity, resulting in optimal performance.

#### Features

- **135° point geometry** – split point geometry for superior drilling penetration and accuracy.
- **Triple-margin design** – improves tool rigidity and process stability.
- **Polished flutes** - chip evacuation is improved during deep-hole drilling when the flutes are polished.
- **Coolant holes** – cooling the cutting edges improves cutting edges tool life and chip evacuation process.
- **Multi layer coating** increases wear resistance and prolongs tool life.

The chamfer at the cutting corner is to reinforce and protect it from premature wear.

[Click for Short Video](#)

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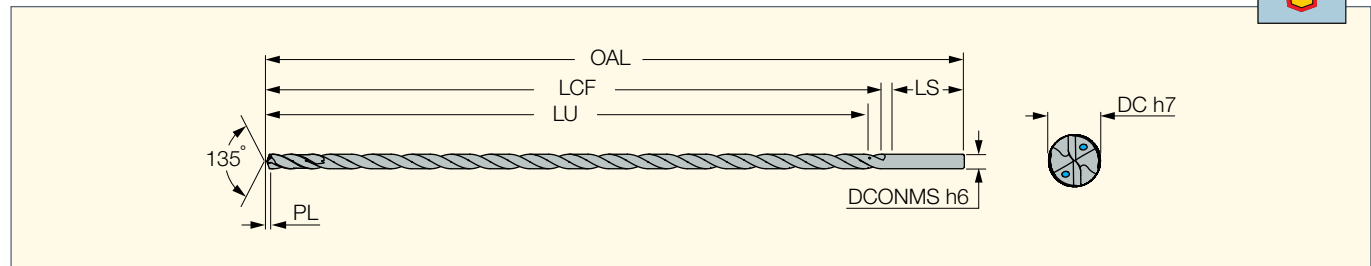
## New Product Announcement

### SOLIDDRILL

#### SCD-IXC16

Solid Carbide Drills with Internal Coolant Channels,  
Drilling Depth 16xD, for Machining ISO K Materials

<https://www.iscar.com/eCatalog/Family.aspx?fnun=5208&map=DR&GFSTYP=M&srch=1>



Designation	Dimensions							IC908
	DC	DCONMS	OAL	LU	LCF	PL	LS	
SCD 030-056-060 IXC16	3.00	6.00	100.00	56.00	60.00	0.620	36.00	●
SCD 032-055-060 IXC16	3.20	6.00	100.00	55.00	60.00	0.660	36.00	●
SCD 033-055-060 IXC16	3.30	6.00	100.00	55.00	60.00	0.680	36.00	●
SCD 035-055-060 IXC16	3.50	6.00	100.00	55.00	60.00	0.730	36.00	●
SCD 038-069-060 IXC16	3.80	6.00	115.00	69.00	75.00	0.790	36.00	●
SCD 040-069-060 IXC16	4.00	6.00	115.00	69.00	75.00	0.830	36.00	●
SCD 042-069-060 IXC16	4.20	6.00	115.00	69.00	75.00	0.870	36.00	●
SCD 045-083-060 IXC16	4.50	6.00	130.00	83.00	90.00	0.930	36.00	●
SCD 047-083-060 IXC16	4.70	6.00	130.00	83.00	90.00	0.970	36.00	●
SCD 048-083-060 IXC16	4.80	6.00	130.00	83.00	90.00	0.990	36.00	●
SCD 050-082-060 IXC16	5.00	6.00	130.00	82.00	90.00	1.040	36.00	●
SCD 055-100-060 IXC16	5.50	6.00	150.00	100.00	108.00	1.140	36.00	●
SCD 058-099-060 IXC16	5.80	6.00	150.00	99.00	108.00	1.200	36.00	●
SCD 060-099-060 IXC16	6.00	6.00	150.00	99.00	108.00	1.240	36.00	●
SCD 065-115-080 IXC16	6.50	8.00	165.00	115.00	125.00	1.350	36.00	●
SCD 068-115-080 IXC16	6.80	8.00	165.00	115.00	125.00	1.410	36.00	●
SCD 070-115-080 IXC16	7.00	8.00	165.00	115.00	125.00	1.450	36.00	●
SCD 075-129-080 IXC16	7.50	8.00	180.00	129.00	140.00	1.550	36.00	●
SCD 078-128-080 IXC16	7.80	8.00	180.00	128.00	140.00	1.620	36.00	●
SCD 080-128-080 IXC16	8.00	8.00	180.00	128.00	140.00	1.660	36.00	●
SCD 085-147-100 IXC16	8.50	10.00	205.00	147.00	160.00	1.760	40.00	●
SCD 088-147-100 IXC16	8.80	10.00	205.00	147.00	160.00	1.820	40.00	●
SCD 090-147-100 IXC16	9.00	10.00	205.00	147.00	160.00	1.860	40.00	●
SCD 098-165-100 IXC16	9.80	10.00	225.00	165.00	180.00	2.030	40.00	●
SCD 100-165-100 IXC16	10.00	10.00	225.00	165.00	180.00	2.070	40.00	●
SCD 102-175-120 IXC16	10.20	12.00	240.00	175.00	190.00	2.110	45.00	●
SCD 108-174-120 IXC16	10.80	12.00	240.00	174.00	190.00	2.240	45.00	●
SCD 115-198-120 IXC16	11.50	12.00	265.00	198.00	215.00	2.380	45.00	●
SCD 120-197-120 IXC16	12.00	12.00	265.00	197.00	215.00	2.490	45.00	●

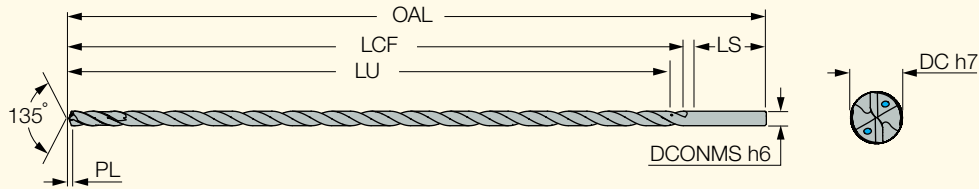
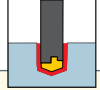
• Based on DIN 6537 standard

### SOLIDDRILL

#### SCD-IXC20

Solid Carbide Drills with Internal Coolant Channels,  
Drilling Depth 20xD, for Machining ISO K Materials

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5210&mapp=DR&GFSTYP=M&srch=1>



Designation	Dimensions							IC908
	DC	DCONMS	OAL	LU	LCF	PL	LS	
SCD 030-076-060 IXC20	3.00	6.00	120.00	76.00	80.0	0.620	36.0	●
SCD 032-075-060 IXC20	3.20	6.00	120.00	75.00	80.0	0.660	36.0	●
SCD 033-075-060 IXC20	3.30	6.00	120.00	75.00	80.0	0.680	36.0	●
SCD 035-075-060 IXC20	3.50	6.00	120.00	75.00	80.0	0.730	36.0	●
SCD 038-084-060 IXC20	3.80	6.00	130.00	84.00	90.0	0.790	36.0	●
SCD 040-084-060 IXC20	4.00	6.00	130.00	84.00	90.0	0.830	36.0	●
SCD 042-104-060 IXC20	4.20	6.00	160.00	104.00	110.0	0.870	36.0	●
SCD 045-103-060 IXC20	4.50	6.00	160.00	103.00	110.0	0.930	36.0	●
SCD 047-113-060 IXC20	4.70	6.00	160.00	113.00	120.0	0.970	36.0	●
SCD 048-113-060 IXC20	4.80	6.00	160.00	113.00	120.0	0.990	36.0	●
SCD 050-112-060 IXC20	5.00	6.00	160.00	112.00	120.0	1.040	36.0	●
SCD 055-132-060 IXC20	5.50	6.00	185.00	132.00	140.0	1.140	36.0	●
SCD 058-131-060 IXC20	5.80	6.00	185.00	131.00	140.0	1.200	36.0	●
SCD 060-131-060 IXC20	6.00	6.00	185.00	131.00	140.0	1.240	36.0	●
SCD 065-150-080 IXC20	6.50	8.00	210.00	150.00	160.0	1.350	36.0	●
SCD 068-150-080 IXC20	6.80	8.00	210.00	150.00	160.0	1.410	36.0	●
SCD 070-149-080 IXC20	7.00	8.00	210.00	149.00	160.0	1.450	36.0	●
SCD 075-169-080 IXC20	7.50	8.00	230.00	169.00	180.0	1.550	36.0	●
SCD 078-168-080 IXC20	7.80	8.00	230.00	168.00	180.0	1.620	36.0	●
SCD 080-168-080 IXC20	8.00	8.00	230.00	168.00	180.0	1.660	36.0	●
SCD 085-182-100 IXC20	8.50	10.00	260.00	182.00	195.0	1.760	40.0	●
SCD 088-217-100 IXC20	8.80	10.00	290.00	217.00	230.0	1.820	40.0	●
SCD 090-217-100 IXC20	9.00	10.00	290.00	217.00	230.0	1.860	40.0	●
SCD 098-215-100 IXC20	9.80	10.00	290.00	215.00	230.0	2.030	40.0	●
SCD 100-215-100 IXC20	10.00	10.00	290.00	215.00	230.0	2.070	40.0	●
SCD 102-253-120 IXC20	10.20	12.00	315.00	253.00	268.0	2.110	45.0	●
SCD 108-252-120 IXC20	10.80	12.00	315.00	252.00	268.0	2.240	45.0	●
SCD 110-252-120 IXC20	11.00	12.00	315.00	252.00	268.0	2.280	45.0	●
SCD 115-251-120 IXC20	11.50	12.00	315.00	251.00	268.0	2.380	45.0	●
SCD 120-250-120 IXC20	12.00	12.00	315.00	250.00	268.0	2.490	45.0	●

• Based on DIN 6537 standard

# NPA

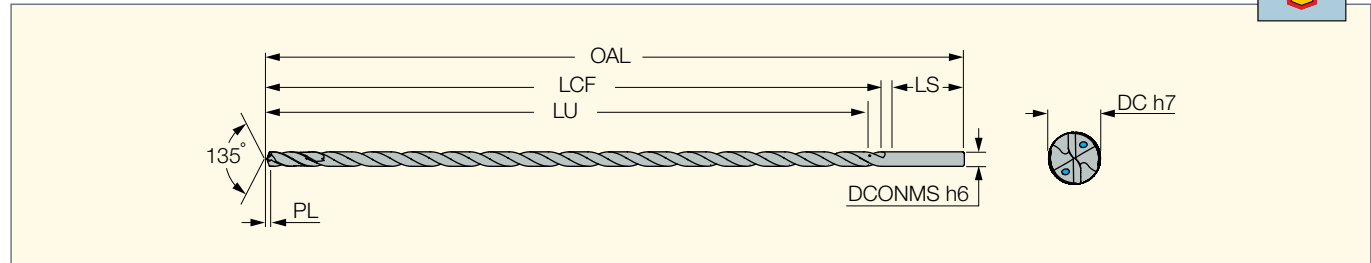
## New Product Announcement

### SOLIDDRILL

#### SCD-IXC30

Solid Carbide Drills with Internal Coolant Channels,  
Drilling Depth 30xD, for Machining ISO K Materials

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5211&map=DR&GFSTYP=M&srch=1>



Designation	Dimensions							IC908
	DC	DCONMS	OAL	LU	LCF	PL	LS	
SCD 030-101-060 IXC30	3.00	6.00	150.00	101.00	105.0	0.620	36.0	●
SCD 032-100-060 IXC30	3.20	6.00	150.00	100.00	105.0	0.660	36.0	●
SCD 033-130-060 IXC30	3.30	6.00	185.00	130.00	135.0	0.680	36.0	●
SCD 035-130-060 IXC30	3.50	6.00	185.00	130.00	135.0	0.730	36.0	●
SCD 038-129-060 IXC30	3.80	6.00	185.00	129.00	135.0	0.790	36.0	●
SCD 040-129-060 IXC30	4.00	6.00	185.00	129.00	135.0	0.830	36.0	●
SCD 042-129-060 IXC30	4.20	6.00	185.00	129.00	135.0	0.870	36.0	●
SCD 045-158-060 IXC30	4.50	6.00	215.00	158.00	165.0	0.930	36.0	●
SCD 047-158-060 IXC30	4.70	6.00	215.00	158.00	165.0	0.970	36.0	●
SCD 048-158-060 IXC30	4.80	6.00	215.00	158.00	165.0	0.990	36.0	●
SCD 050-158-060 IXC30	5.00	6.00	215.00	158.00	165.0	1.040	36.0	●
SCD 055-172-060 IXC30	5.50	6.00	230.00	172.00	180.0	1.140	36.0	●
SCD 058-171-060 IXC30	5.80	6.00	230.00	171.00	180.0	1.200	36.0	●
SCD 060-171-060 IXC30	6.00	6.00	230.00	171.00	180.0	1.240	36.0	●
SCD 065-205-080 IXC30	6.50	8.00	280.00	205.00	215.0	1.350	36.0	●
SCD 068-220-080 IXC30	6.80	8.00	280.00	220.00	230.0	1.410	36.0	●
SCD 070-219-080 IXC30	7.00	8.00	280.00	219.00	230.0	1.450	36.0	●
SCD 075-219-080 IXC30	7.50	8.00	280.00	219.00	230.0	1.550	36.0	●
SCD 078-253-080 IXC30	7.80	8.00	315.00	253.00	265.0	1.620	36.0	●
SCD 080-253-080 IXC30	8.00	8.00	315.00	253.00	265.0	1.660	36.0	●
SCD 085-282-100 IXC30	8.50	10.00	350.00	282.00	295.0	1.760	40.0	●
SCD 088-317-100 IXC30	8.80	10.00	380.00	317.00	330.0	1.820	40.0	●
SCD 090-317-100 IXC30	9.00	10.00	380.00	317.00	330.0	1.860	40.0	●
SCD 098-315-100 IXC30	9.80	10.00	380.00	315.00	330.0	2.030	40.0	●
SCD 100-315-100 IXC30	10.00	10.00	380.00	315.00	330.0	2.070	40.0	●

• Based on DIN 6537 standard

### SOLIDDRILL

#### Recommended Drilling Procedure for Deep Hole Drilling

- 1 Drill a pilot hole 1-2xD deep with a short drill. The pilot drill should be 0.03-0.05 mm larger than the long drill and its point angle should also be larger (over 135°).
- 2 Enter the pre-hole using low feed and rotate at low speed (50-100 RPM) until it engages the material.
- 3 Activate the coolant system and increase rotation speed to the recommended cutting parameter, maintain for 2-3 seconds, then continue at recommended drilling feed. **No pecking is required.**
- 4 After having reached the required depth, reduce speed to 50-100 RPM before retracting from the hole.

