

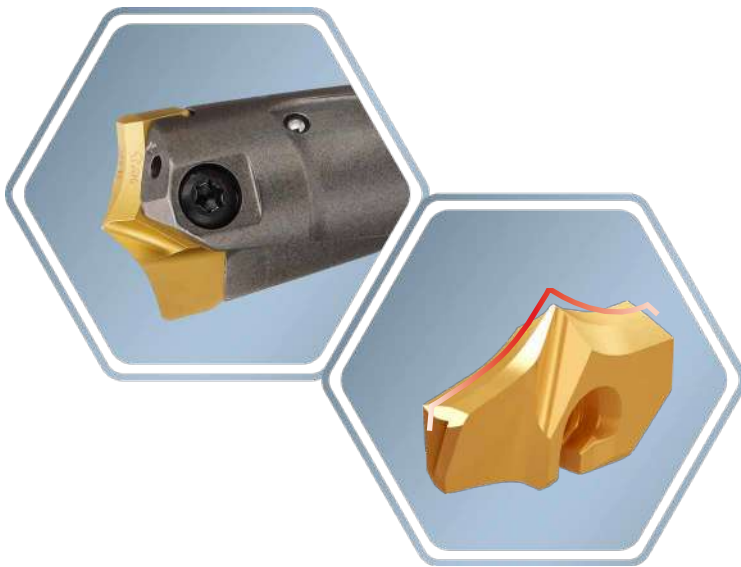
NPN

New Product News



SPADERUSH

Self-Centering Drill Head with Unique P+ Edge Geometry for Large Diameter Drills



KEY POINT

The SPADE-RUSH product line now includes a P+ head geometry for large diameter hole making.

The head-changeable SPADE-RUSH series from TaeguTec now features a P+ drill head, which boosts production while lowering costs, making it the best possible choice.

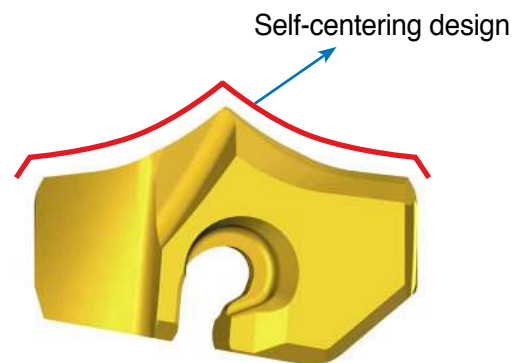
Direct drilling without a pilot hole is achievable thanks to the special edge geometry's self-centering capabilities, which shortens the process time and results in exceptional hole accuracy and surface polish.

Additionally, the new multilayered coating grade increases tool longevity, and the optimized high-rigidity flute shape enables chip evacuation with less resistance.

Please contact the product manager for more information.

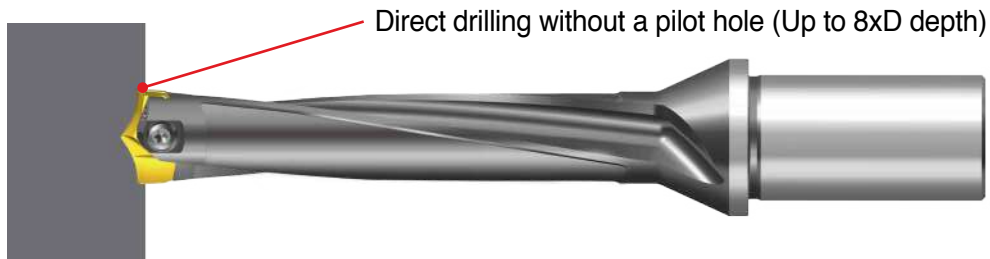
Features

- Unique P+ self-centering geometry design
- Excellent hole accuracy and premium surface finish
- Improved cylindricity and straightness
- Rigid clamping for reliable performance and long tool life
- Head diameter range: Ø20-34.5 mm (0.5 mm increments)
- Compatible with the existing SPADE-RUSH holders
- Head indexing on the machine means reduced cycle and tool change time
- Optimally suited for steel and cast iron applications



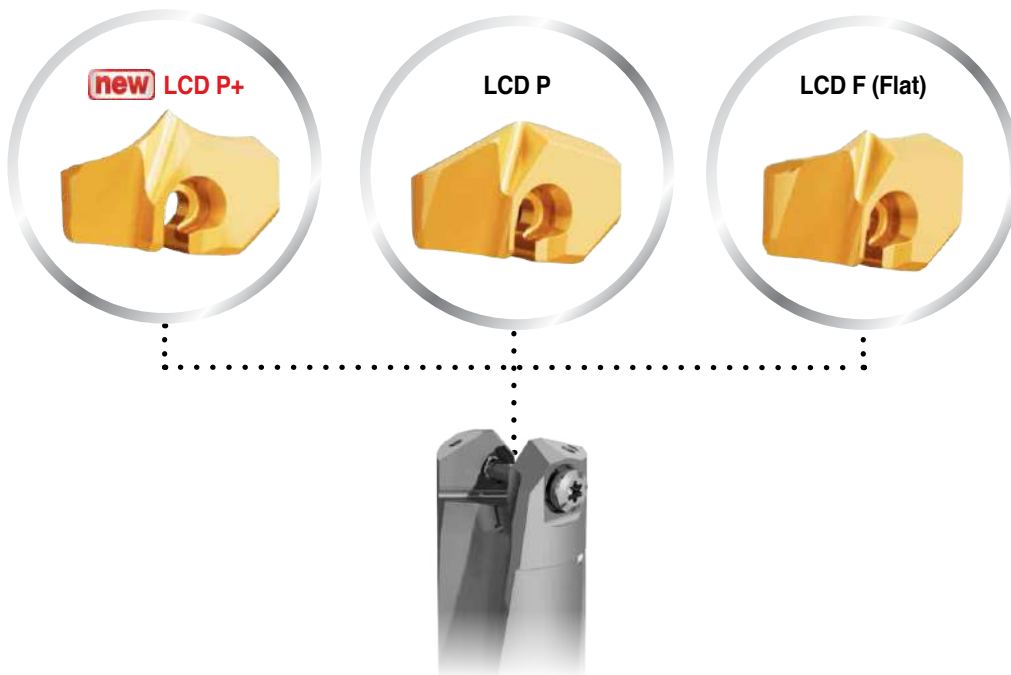
Self centering design enables +5xD drilling without a pre-hole

- Reduced cycle time and improved productivity



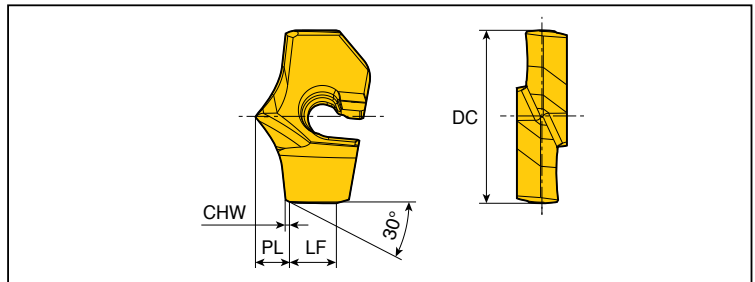
SPADE-RUSH head

- 3 head types for one SPADE-RUSH holder



LCD...-P+

Self-centering drill heads



Designation	Dimension (mm)					Grade
	DC	PL	LF	CHW	SSC	
LCD - 200-P+	20.0	4.55	5.83	0.86	20	●
205-P+	20.5	4.58	5.60	0.86	20	●
210-P+	21.0	4.60	5.36	0.86	21	●
215-P+	21.5	4.63	5.13	0.86	21	●
220-P+	22.0	4.92	6.21	0.86	22	●
225-P+	22.5	4.95	5.98	0.86	22	●
230-P+	23.0	4.97	5.74	0.86	23	●
235-P+	23.5	5.00	5.51	0.86	23	●
240-P+	24.0	5.30	5.93	0.86	24	●
245-P+	24.5	5.33	5.70	0.86	24	●
250-P+	25.0	5.35	5.46	0.86	25	●
255-P+	25.5	5.38	5.23	0.86	25	●
260-P+	26.0	5.67	7.39	0.86	26	●
265-P+	26.5	5.70	7.16	0.86	26	●
270-P+	27.0	5.72	6.92	0.86	27	●
275-P+	27.5	5.75	6.69	0.86	27	●
280-P+	28.0	5.73	7.26	0.86	28	●
285-P+	28.5	5.76	7.03	0.86	28	●
290-P+	29.0	5.78	6.79	0.86	29	●
295-P+	29.5	5.81	6.56	0.86	29	●
300-P+	30.0	6.08	9.17	0.86	30	●
305-P+	30.5	6.11	8.94	0.86	30	●
310-P+	31.0	6.13	8.70	0.86	31	●
315-P+	31.5	6.16	8.47	0.86	31	●
320-P+	32.0	6.43	9.18	0.86	32	●
325-P+	32.5	6.46	8.95	0.86	32	●
330-P+	33.0	6.48	8.71	0.86	33	●
335-P+	33.5	6.51	8.48	0.86	33	●
340-P+	34.0	6.53	8.24	0.86	34	●
345-P+	34.5	6.56	8.01	0.86	34	●

► SSC: Seat size code

●: Standard items

Recommended Cutting Conditions

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)	Feed (mm/rev) vs. drill diameter			
							Ø 20-25.9	Ø 26-29.9	Ø 30-34.9	
P	Non-alloy steel	<0.25%C	Annealed	420	125	1	80-140	0.25-0.45	0.30-0.50	0.30-0.50
		>=0.25%C	Annealed	650	190	2	80-130	0.25-0.45	0.30-0.50	0.30-0.50
	and cast steel, free cutting steel	<0.55%C	Quenched and tempered	850	250	3	80-120	0.25-0.45	0.30-0.50	0.30-0.50
		>=0.55%C	Annealed	750	220	4	70-110	0.25-0.45	0.30-0.50	0.30-0.50
	Low alloy steel and cast steel (less than 5% of alloying elements)	Quenched and tempered	1000	300	5	50-90	0.25-0.45	0.30-0.50	0.30-0.50	
			1200	350	9	40-70	0.20-0.40	0.25-0.45	0.25-0.45	
		Annealed	600	200	6	80-120	0.20-0.40	0.25-0.45	0.25-0.45	
			930	275	7	70-110	0.20-0.40	0.25-0.45	0.25-0.45	
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-90	0.20-0.30	0.25-0.35	0.25-0.35	
		Quenched and tempered	1100	325	11	40-80	0.20-0.30	0.25-0.35	0.25-0.35	
	K	Cast iron nodular (GGG)	Ferritic		160	15	90-180	0.30-0.50	0.35-0.55	0.35-0.55
Pearlitic				250	16	80-140	0.30-0.50	0.35-0.55	0.35-0.55	
Grey cast iron (GG)		Ferritic		180	17	90-165	0.30-0.50	0.35-0.55	0.35-0.55	
		Pearlitic		260	18	80-140	0.30-0.50	0.35-0.55	0.35-0.55	
Malleable cast iron		Ferritic		130	19	90-160	0.30-0.50	0.35-0.55	0.35-0.55	
		Pearlitic		230	20	80-140	0.30-0.50	0.35-0.55	0.35-0.55	

Steel Cast iron

► For deep hole drilling (+8xD), reduce the cutting parameters by 30%