

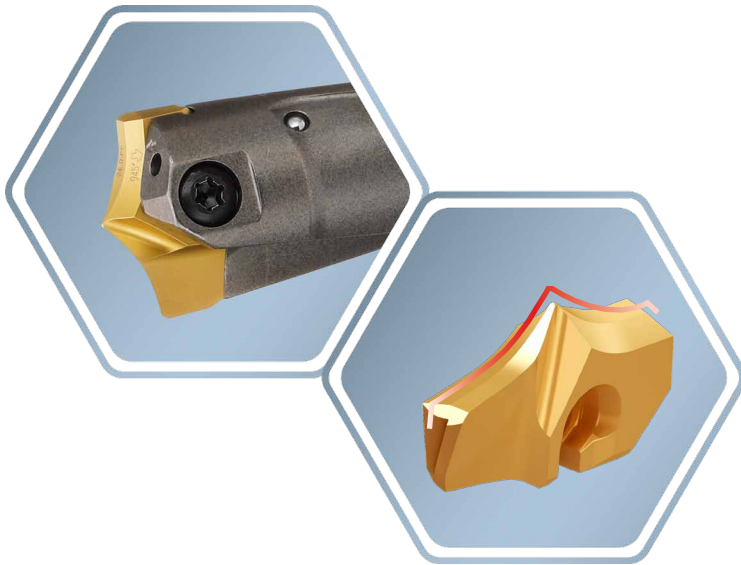
NPN

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.

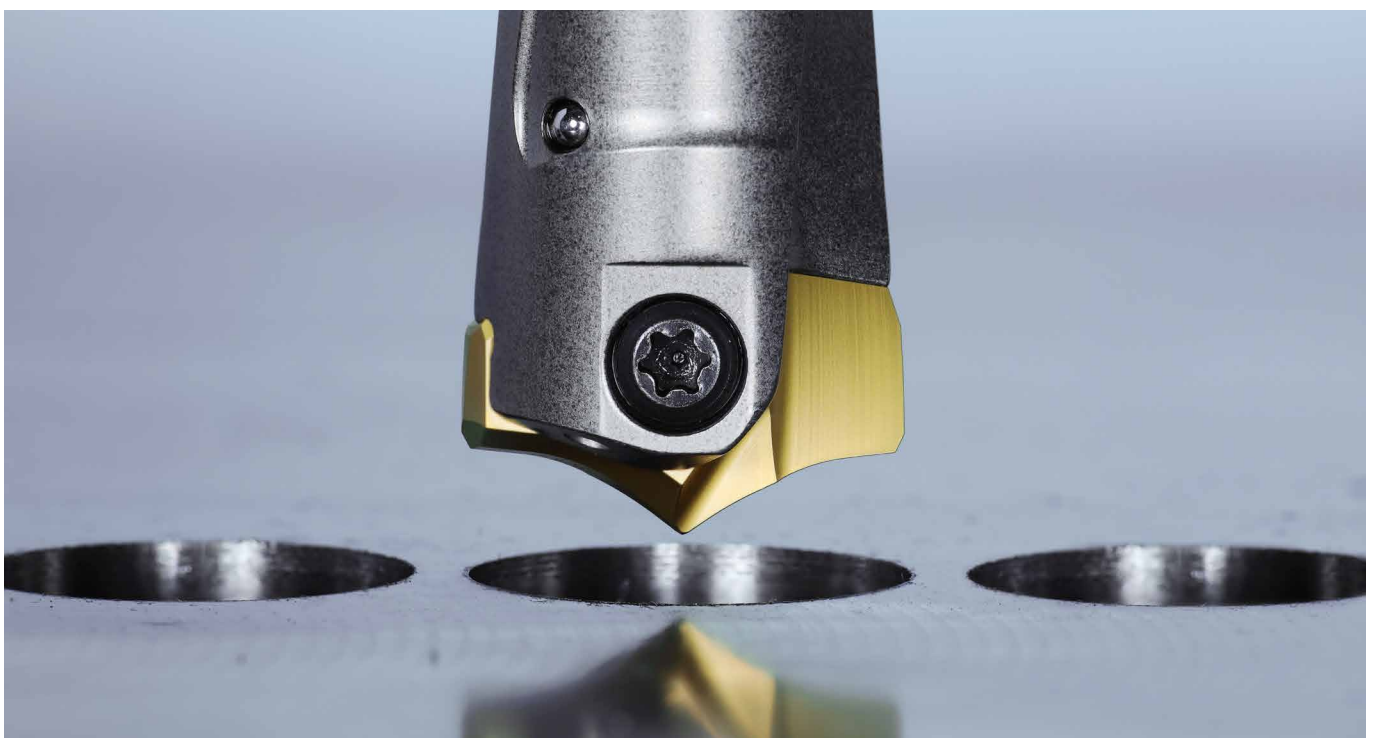
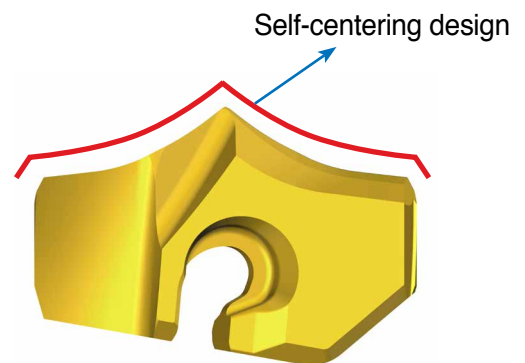
Direct drilling without a pilot hole is achievable thanks to the special edge geometry's self-centering capabilities, which shortens the process time and results in exceptional hole accuracy and surface polish.

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.

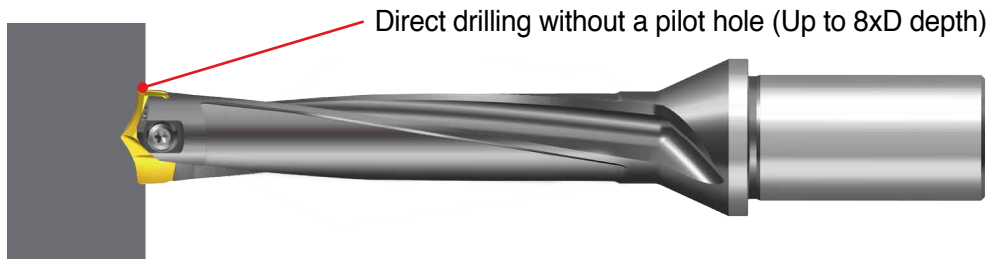
Features

- 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



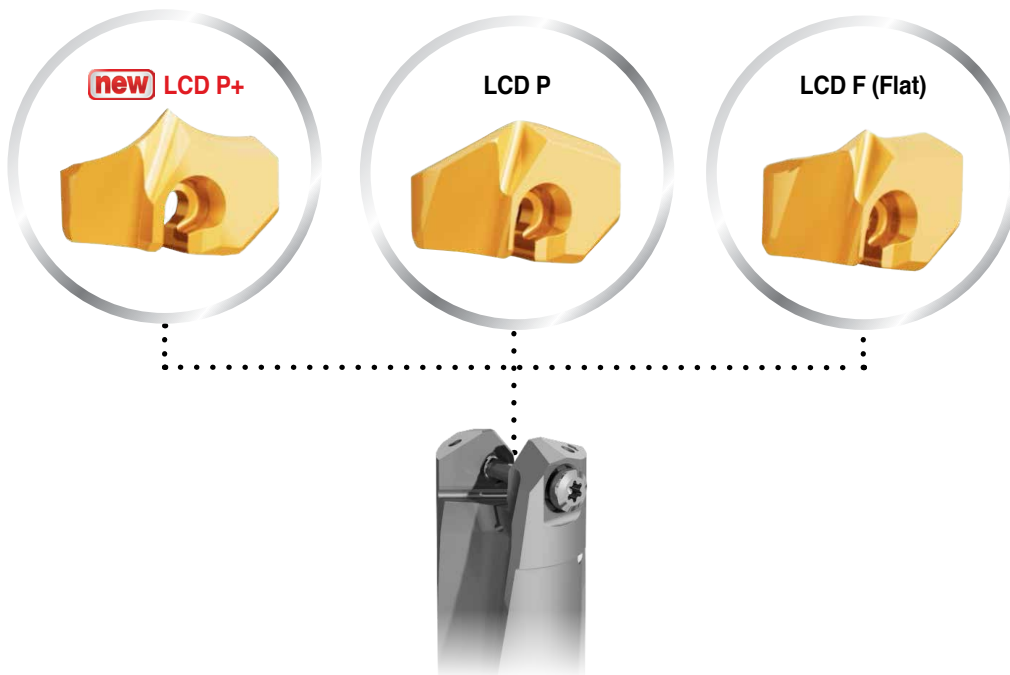
Self centering design enables +5xD drilling without a pre-hole

- Reduced cycle time and improved productivity



SPADE-RUSH head

- 3 head types for one SPADE-RUSH holder



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
		Quenched and tempered	1000	300	5	50-90	0.25-0.45	0.30-0.50	0.30-0.50	
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	80-120	0.20-0.40	0.25-0.45	0.25-0.45	
		Quenched and tempered	930	275	7	70-110	0.20-0.40	0.25-0.45	0.25-0.45	
			1000	300	8	50-90	0.20-0.40	0.25-0.45	0.25-0.45	
		1200	350	9	40-70	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%