

# NEW PRODUCT NEWS



Taegutec Hole Making Line

## 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.

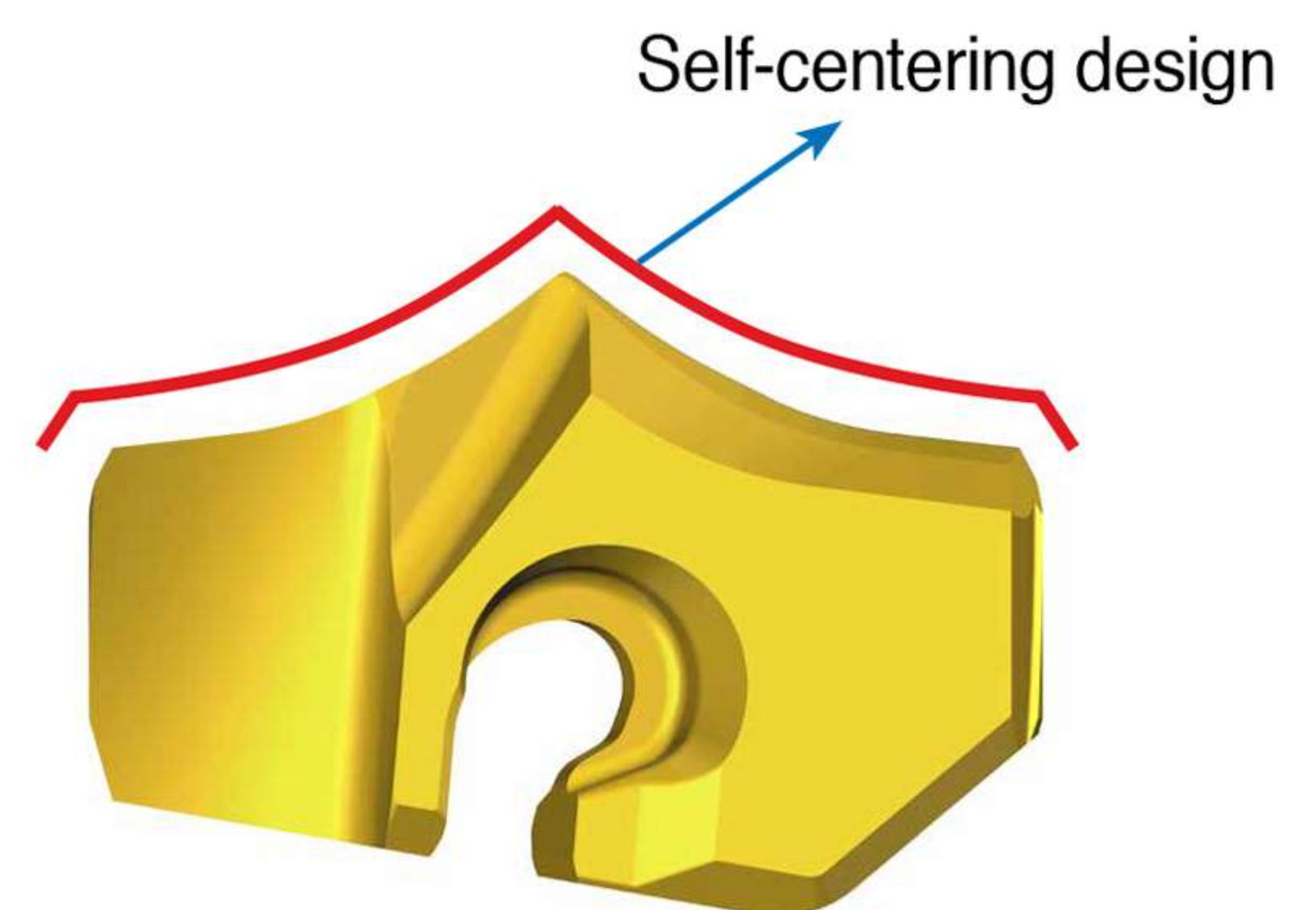
Direct drilling without a pilot hole is achievable thanks to the special edge geometry's self-centering capabilities, which shortens the process time and results in exceptional hole accuracy and surface polish.

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



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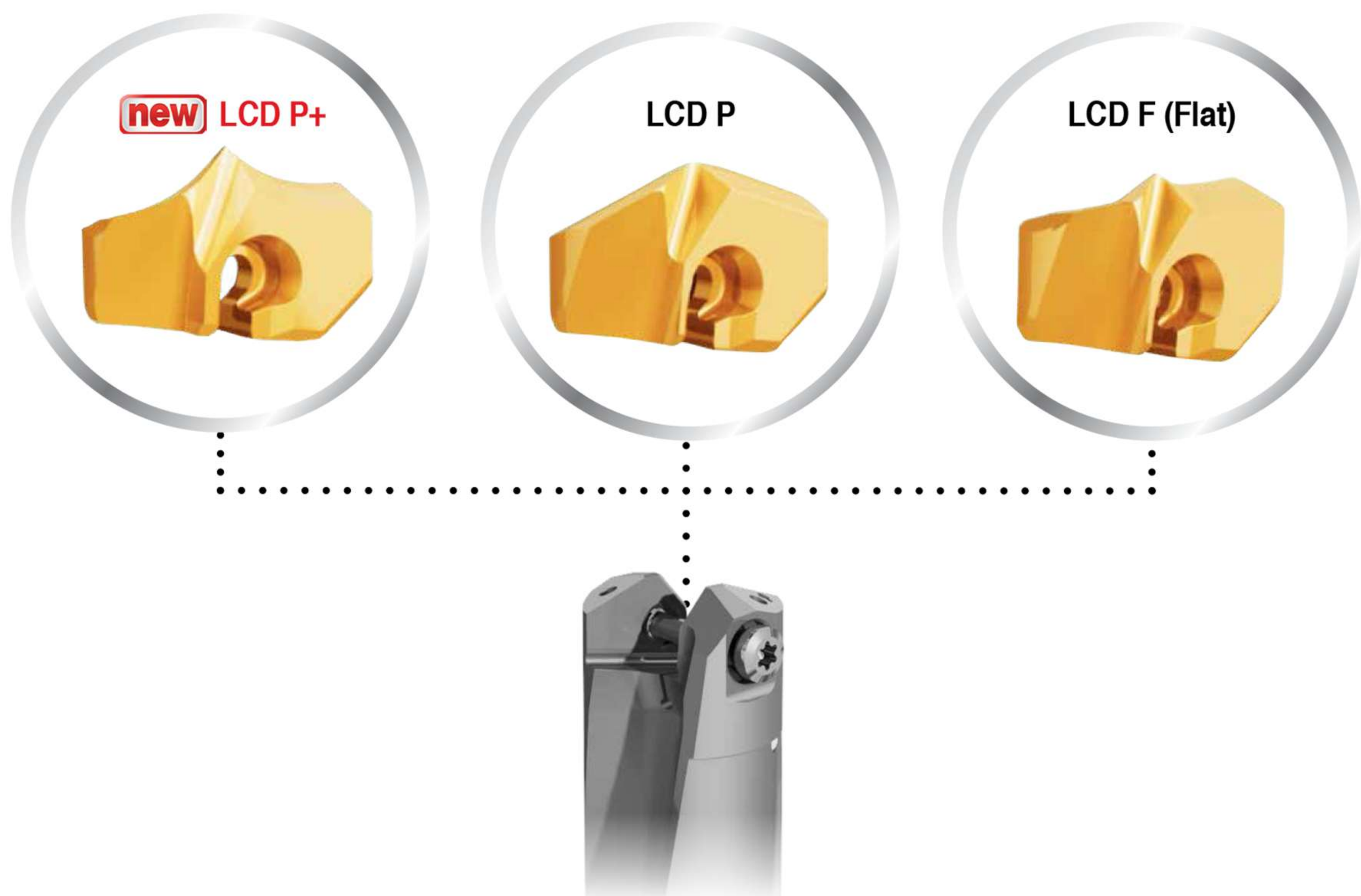
### Self centering design enables +5xD drilling without a pre-hole

- Reduced cycle time and improved productivity



### SPADE-RUSH head

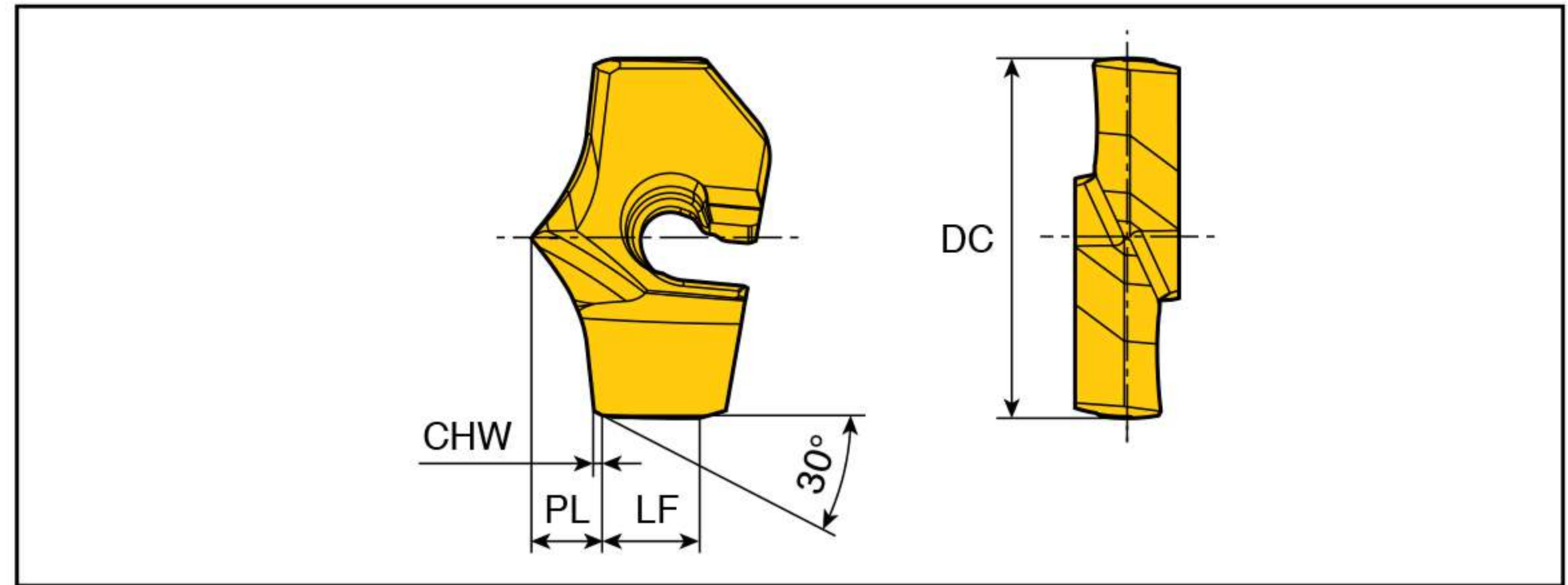
- 3 head types for one SPADE-RUSH holder



## Taegutec Hole Making Line

### LCD...-P+

#### Self-centering drill heads



Designation	Dimension (mm)					Grade
	DC	PL	LF	CHW	SSC	
<b>LCD - 200-P+</b>	20.0	4.55	5.83	0.86	20	●
<b>205-P+</b>	20.5	4.58	5.60	0.86	20	●
<b>210-P+</b>	21.0	4.60	5.36	0.86	21	●
<b>215-P+</b>	21.5	4.63	5.13	0.86	21	●
<b>220-P+</b>	22.0	4.92	6.21	0.86	22	●
<b>225-P+</b>	22.5	4.95	5.98	0.86	22	●
<b>230-P+</b>	23.0	4.97	5.74	0.86	23	●
<b>235-P+</b>	23.5	5.00	5.51	0.86	23	●
<b>240-P+</b>	24.0	5.30	5.93	0.86	24	●
<b>245-P+</b>	24.5	5.33	5.70	0.86	24	●
<b>250-P+</b>	25.0	5.35	5.46	0.86	25	●
<b>255-P+</b>	25.5	5.38	5.23	0.86	25	●
<b>260-P+</b>	26.0	5.67	7.39	0.86	26	●
<b>265-P+</b>	26.5	5.70	7.16	0.86	26	●
<b>270-P+</b>	27.0	5.72	6.92	0.86	27	●
<b>275-P+</b>	27.5	5.75	6.69	0.86	27	●
<b>280-P+</b>	28.0	5.73	7.26	0.86	28	●
<b>285-P+</b>	28.5	5.76	7.03	0.86	28	●
<b>290-P+</b>	29.0	5.78	6.79	0.86	29	●
<b>295-P+</b>	29.5	5.81	6.56	0.86	29	●
<b>300-P+</b>	30.0	6.08	9.17	0.86	30	●
<b>305-P+</b>	30.5	6.11	8.94	0.86	30	●
<b>310-P+</b>	31.0	6.13	8.70	0.86	31	●
<b>315-P+</b>	31.5	6.16	8.47	0.86	31	●
<b>320-P+</b>	32.0	6.43	9.18	0.86	32	●
<b>325-P+</b>	32.5	6.46	8.95	0.86	32	●
<b>330-P+</b>	33.0	6.48	8.71	0.86	33	●
<b>335-P+</b>	33.5	6.51	8.48	0.86	33	●
<b>340-P+</b>	34.0	6.53	8.24	0.86	34	●
<b>345-P+</b>	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 <sup>2</sup> )	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
				930	275	7	70-110	0.20-0.40	0.25-0.45	0.25-0.45
			Quenched and tempered	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%

# CONTACT US



## MEGA TECH METALWORK CO.,LTD ( Headquarter )



**Tel : 02-943-1591**



**Fax : 02-943-1592**



**Line ID : @mgt\_metalwork**



**Email : sales.m@mgtg.co.th**



**Web : <https://www.mgtg.co.th/>**



**17/4 Soi Ramintra 89  
Ramintra Khannayao  
Bangkok 10230**

