



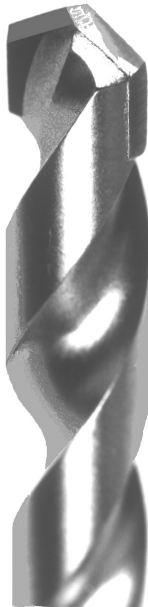
Heritage Industrial Products Corp.
W4278 Jean Street
Appleton, WI 54913

800-236-2119 (Voice)
920-733-7461 (Fax)

heritageindustrial@sbcglobal.net

www.heritageindustrial.net

TUFSHOT - HARD METAL DRILL BITS



The **TufShot** Hard Metal Drilling System is a revolution in hard metal hole making. Using a unique design and high-tech manufacturing techniques, we have created a drilling system which easily penetrates materials that would destroy other bits. The tip of our **TufShot** is a composite material designed for maximum hardness and resistance to wear. The tip is bonded to the high speed steel shank using a proprietary technique which absorbs the varying rates of expansion between the tip and shank, yet retains the tip securely even at high drilling temperatures. The tip is ground to produce a cutting action different from any other bit. Finally, the **TufShot** is

plated in a new type of heat-treated nickel which is chemically integrated into the surface of the shank. This produces a revolutionary drilling system which can penetrate the hardest materials and withstand extreme drilling temperatures without damaging the tip or the shank.

Now you can drill hardened tool steel - A2, M2, D2, H13, S7 and others. Even drill magnesium wear plate, files, taps and bearing races up to 70 Rc. An economical substitute for solid carbide drill bits or Electrical Discharge Machining, **TufShots** can save you money and drill materials you couldn't drill before. A tool steel shank makes the **TufShot** much less brittle than solid carbide and reduces breakage. In addition, the shank is slightly smaller than the head, eliminating seizing and breaking even when drilling the hardest materials. *Do you ever need to drill material you know would destroy the best high speed steel bit; even a solid carbide or carbide tipped bit?* Here may be your answer.

TufShot Hard Metal Drill Bits

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TUFSHOT - FRACTIONAL SIZES

| PART NUMBER | SIZE | OVERALL LENGTH | FLUTE LENGTH | PRICE EACH |
|-------------|----------------|----------------|--------------|------------|
| 425-125-S | 0.1250 (1/8) | 2-3/4 | 1-1/2 | \$18.90 |
| 425-139-S | 0.139 | 2-3/4 | 1-1/4 | 18.90 |
| 425-156-S | 0.1562 (5/32) | 2-3/4 | 1-1/4 | 19.53 |
| 425-166-S | 0.166 | 2-3/4 | 1-1/4 | 19.53 |
| 425-188-S | 0.1875 (3/16) | 3-1/2 | 1-3/4 | 20.32 |
| 425-200-S | 0.200 | 3-1/2 | 1-3/4 | 20.32 |
| 425-219-S | 0.2188 (7/32) | 3-1/2 | 1-3/4 | 21.33 |
| 425-233-S | 0.233 | 3-1/2 | 1-3/4 | 21.33 |
| 425-250-S | 0.2500 (1/4) | 4-1/4 | 2-1/4 | 22.65 |
| 425-267-S | 0.267 | 4-1/4 | 2-1/4 | 22.65 |
| 425-281-S | 0.2812 (9/32) | 4-1/4 | 2-1/4 | 24.04 |
| 425-301-S | 0.301 | 4-1/4 | 2-1/4 | 24.04 |
| 425-313-S | 0.3125 (5/16) | 4-1/2 | 2-1/4 | 25.48 |
| 425-332-S | 0.332 | 4-1/2 | 2-1/4 | 25.48 |
| 425-344-S | 0.3438 (11/32) | 4-1/2 | 2-1/2 | 30.12 |
| 425-362-S | 0.362 | 4-1/2 | 2-1/2 | 30.12 |
| 425-375-S | 0.3750 (3/8) | 5 | 2-3/4 | 33.05 |
| 425-403-S | 0.403 | 5 | 2-3/4 | 33.05 |
| 425-406-S | 0.4062 (13/32) | 6 | 3-3/4 | 38.04 |
| 425-428-S | 0.428 | 6 | 3-3/4 | 38.04 |
| 425-438-S | 0.4375 (7/16) | 6 | 3-3/4 | 41.26 |
| 425-463-S | 0.463 | 6 | 3-3/4 | 41.26 |
| 425-469-S | 0.4688 (15/32) | 6 | 3-3/8 | 55.89 |
| 425-496-S | 0.496 | 6 | 3-3/8 | 55.89 |
| 425-500-S | 0.5000 (1/2) | 6 | 3-1/2 | 62.92 |
| 425-524-S | 0.524 | 6 | 3-1/2 | 62.92 |
| 425-563-S | 0.5625 (9/16) | 6 | 3-1/2 | 79.70 |
| 425-586-S | 0.586 | 6 | 3-1/2 | 79.70 |
| 425-625-S | 0.6250 (5/8) | 6 | 3-1/2 | 104.13 |
| 425-653-S | 0.653 | 6 | 3-1/2 | 104.13 |
| 425-688-S | 0.6875 (11/16) | 6 | 3 | 142.05 |
| 425-750-S | 0.7500 (3/4) | 6 | 3 | 142.05 |
| 425-779-S | 0.779 | 6 | 3 | 142.05 |
| 425-813-S | 0.8125 (13/16) | 6 | 3 | 191.70 |
| 425-875-S | 0.8750 (7/8) | 6 | 3 | 191.70 |
| 425-908-S | 0.908 | 6 | 3 | 191.70 |
| 425-938-S | 0.9375 (15/16) | 6 | 3 | 219.18 |
| 425-1000-S | 1.0000 (1) | 6 | 3 | 219.18 |
| 425-1039-S | 1.039 | 6 | 3 | 219.18 |

ASSORTMENTS

| | | |
|-----------|--|----------|
| 425-7-S | 1/8, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2 | \$211.72 |
| 425-S7-S | .139, .200, .267, .332, .403, .463, .524 | 211.72 |
| 425-9-S | 1/8, 5/32, 3/16, 7/32, 1/4, 9/32, 5/16, 11/32, 3/8 | 212.96 |
| 425-S9-S | .139, .166, .200, .233, .267, .301, .332, .362, .403 | 212.96 |
| 425-13-S | 1/8, 5/32, 3/16, 7/32, 1/4, 9/32, 5/16, 11/32, 3/8, 13/32, 7/16, 15/32, 1/2 | 388.93 |
| 425-S13-S | .139, .166, .200, .233, .267, .301, .332, .362, .403, .428, .463, .496, .524 | 388.93 |

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TufShot - Fractional Sizes

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TUFSHOT - EXTENDED LENGTH

| SIZE | 6" LENGTH | | | | 9" LENGTH | | | | 12" LENGTH | | | |
|----------------|-------------|--------------|---------|------------|-------------|--------------|-------|-------------|-------------|--------------|-------|--|
| | PART NUMBER | FLUTE LENGTH | PRICE | | PART NUMBER | FLUTE LENGTH | PRICE | | PART NUMBER | FLUTE LENGTH | PRICE | |
| 0.1250 (1/8) | 429-125X6 | 1-1/2 | \$31.56 | | | | | | | | | |
| 0.139 | 429-139X6 | 1-1/4 | 31.56 | | | | | | | | | |
| 0.1562 (5/32) | 429-156X5F | 3-1/4 | 29.22 | | | | | | | | | |
| 0.166 | 429-166X5F | 3-1/4 | 29.22 | | | | | | | | | |
| 0.1875 (3/16) | 429-188X5F | 3-3/4 | 31.10 | | | | | | | | | |
| 0.200 | 429-200X5F | 3-3/4 | 31.10 | | | | | | | | | |
| 0.2188 (7/32) | 429-219X6 | 1-3/4 | 35.47 | | | | | | | | | |
| 0.233 | 429-233X6 | 1-3/4 | 35.47 | | | | | | | | | |
| 0.2500 (1/4) | 429-250X6 | 2-1/4 | 39.52 | 429-250X9 | 2-1/4 | \$42.57 | | 429-250X12 | 2-1/4 | \$46.26 | | |
| 0.2500 (1/4) | 429-250X6F | 4 | 44.20 | 429-250X9F | 7 | 64.96 | | 429-250X12F | 10 | 70.09 | | |
| 0.263 | 429-263X6 | 2-1/4 | 39.52 | 429-263X9 | 2-1/4 | 42.57 | | 429-263X12 | 2-1/4 | 46.26 | | |
| 0.263 | 429-263X6F | 4 | 44.20 | 429-263X9F | 7 | 64.96 | | 429-263X12F | 10 | 70.09 | | |
| 0.2812 (9/32) | 429-281X6 | 2-1/4 | 41.99 | 429-281X9 | 2-1/4 | 45.22 | | 429-281X12 | 2-1/4 | 48.75 | | |
| 0.301 | 429-301X6 | 2-1/4 | 41.99 | 429-301X9 | 2-1/4 | 45.22 | | 429-301X12 | 2-1/4 | 48.75 | | |
| 0.3125 (5/16) | 429-313X6 | 2-1/4 | 48.64 | 429-313X9 | 2-1/4 | 52.39 | | 429-313X12 | 2-1/4 | 56.14 | | |
| 0.3125 (5/16) | 429-313X6F | 4 | 51.49 | 429-313X9F | 7 | 72.42 | | 429-313X12F | 10 | 77.42 | | |
| 0.332 | 429-332X6 | 2-1/4 | 48.64 | 429-332X9 | 2-1/4 | 52.39 | | 429-332X12 | 2-1/4 | 56.14 | | |
| 0.332 | 429-332X6F | 4 | 51.49 | 429-332X9F | 7 | 72.42 | | 429-332X12F | 10 | 77.42 | | |
| 0.3438 (11/32) | | | | 429-344X9 | 2-1/2 | 54.60 | | 429-344X12 | 2-1/2 | 58.80 | | |
| 0.362 | | | | 429-362X9 | 2-1/2 | 54.60 | | 429-362X12 | 2-1/2 | 58.80 | | |
| 0.3750 (3/8) | | | | 429-375X9 | 2-3/4 | 61.38 | | 429-375X12 | 2-3/4 | 66.10 | | |
| 0.3750 (3/8) | | | | 429-375X9F | 7 | 86.30 | | 429-375X12F | 10 | 92.26 | | |
| 0.393 | | | | 429-393X9 | 2-3/4 | 61.38 | | 429-393X12 | 2-3/4 | 66.10 | | |
| 0.393 | | | | 429-393X9F | 7 | 86.30 | | 429-393X12F | 10 | 92.26 | | |
| 0.4062 (13/32) | | | | 429-406X9 | 3-3/4 | 72.98 | | 429-406X12 | 3-3/4 | 78.62 | | |
| 0.428 | | | | 429-428X9 | 3-3/4 | 72.98 | | 429-428X12 | 3-3/4 | 78.62 | | |
| 0.4375 (7/16) | | | | 429-438X9 | 3-3/4 | 81.30 | | 429-438X12 | 3-3/4 | 87.55 | | |
| 0.4375 (7/16) | | | | 429-438X9F | 7 | 97.80 | | 429-438X12F | 10 | 104.56 | | |
| 0.463 | | | | 429-463X9 | 3-3/4 | 81.30 | | 429-463X12 | 3-3/4 | 87.55 | | |
| 0.463 | | | | 429-463X9F | 7 | 97.80 | | 429-463X12F | 10 | 104.56 | | |
| 0.4688 (15/32) | | | | 429-469X9 | 3-3/8 | 99.22 | | 429-469X12 | 3-3/8 | 106.85 | | |
| 0.496 | | | | 429-496X9 | 3-3/8 | 99.22 | | 429-496X12 | 3-3/8 | 106.85 | | |
| 0.5000 (1/2) | | | | 429-500X9 | 3-1/2 | 119.57 | | 429-500X12 | 3-1/2 | 128.78 | | |
| 0.5000 (1/2) | | | | 429-500X9F | 7 | 135.28 | | 429-500X12F | 10 | 144.95 | | |
| 0.524 | | | | 429-524X9 | 3-1/2 | 119.57 | | 429-524X12 | 3-1/2 | 128.78 | | |
| 0.524 | | | | 429-524X9F | 7 | 135.28 | | 429-524X12F | 10 | 144.95 | | |

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TufShot - Fractional Sizes, Extended Length

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TUFSHOT - METRIC SIZES

| PART NUMBER | SIZE | OVERALL LENGTH | FLUTE LENGTH | PRICE EACH |
|-------------|---|----------------|--------------|------------|
| 428-M35-S | 3.5MM (0.138) | 2-3/4 | 1-1/4 | \$ 18.90 |
| 428-M40-S | 4.0MM (0.158) | 2-3/4 | 1-1/4 | 19.53 |
| 428-M50-S | 5.0MM (0.197) | 3-1/2 | 1-3/4 | 20.32 |
| 428-M55-S | 5.5MM (0.217) | 3-1/2 | 1-3/4 | 21.33 |
| 428-M65-S | 6.5MM (0.256) | 4-1/4 | 2-1/4 | 22.65 |
| 428-M70-S | 7.0MM (0.276) | 4-1/4 | 2-1/4 | 24.04 |
| 428-M75-S | 7.5MM (0.295) | 4-1/4 | 2-1/4 | 24.04 |
| 428-M80-S | 8.0MM (0.315) | 4-1/2 | 2-1/4 | 25.48 |
| 428-M85-S | 8.5MM (0.335) | 4-1/2 | 2-1/2 | 30.12 |
| 428-M90-S | 9.0MM (0.354) | 4-1/2 | 2-1/2 | 30.12 |
| 428-M95-S | 9.5MM (0.374) | 5 | 2-3/4 | 33.05 |
| 428-M100-S | 10.0MM (0.394) | 5 | 2-3/4 | 33.05 |
| 428-M105-S | 10.5MM (0.413) | 6 | 3-3/4 | 37.48 |
| 428-M110-S | 11.0MM (0.433) | 6 | 3-3/4 | 41.26 |
| 428-M115-S | 11.5MM (0.453) | 6 | 3-3/4 | 41.26 |
| 428-M120-S | 12.0MM (0.472) | 6 | 3-3/8 | 55.89 |
| 428-M125-S | 12.5MM (0.492) | 6 | 3-3/8 | 55.89 |
| 428-M130-S | 13.0MM (0.512) | 6 | 3-1/2 | 62.92 |
| 428-M135-S | 13.5MM (0.532) | 6 | 3-1/2 | 79.70 |
| 428-M140-S | 14.0MM (0.551) | 6 | 3-1/2 | 79.70 |
| 428-M145-S | 14.5MM (0.571) | 6 | 3-1/2 | 79.70 |
| 428-M150-S | 15.0MM (0.591) | 6 | 3-1/2 | 104.13 |
| 428-M155-S | 15.5MM (0.610) | 6 | 3-1/2 | 104.13 |
| 428-M160-S | 16.0MM (0.630) | 6 | 3-1/2 | 104.13 |
| 428-M165-S | 16.5MM (0.650) | 6 | 3-1/2 | 104.13 |
| 428-M175-S | 17.5MM (0.689) | 6 | 3 | 142.05 |
| 428-M180-S | 18.0MM (0.709) | 6 | 3 | 142.05 |
| 428-M185-S | 18.5MM (0.728) | 6 | 3 | 142.05 |
| 428-M190-S | 19.0MM (0.748) | 6 | 3 | 142.05 |
| 428-M195-S | 19.5MM (0.768) | 6 | 3 | 191.70 |
| 428-M200-S | 20.0MM (0.787) | 6 | 3 | 191.70 |
| 428-M205-S | 20.5MM (0.807) | 6 | 3 | 191.70 |
| 428-M210-S | 21.0MM (0.826) | 6 | 3 | 191.70 |
| 428-M215-S | 21.5MM (0.847) | 6 | 3 | 191.70 |
| 428-M220-S | 22.0MM (0.866) | 6 | 3 | 191.70 |
| 428-M225-S | 22.5MM (0.886) | 6 | 3 | 191.70 |
| 428-M230-S | 23.0MM (0.906) | 6 | 3 | 191.70 |
| 428-M235-S | 23.5MM (0.925) | 6 | 3 | 219.18 |
| 428-M240-S | 24.0MM (0.945) | 6 | 3 | 219.18 |
| 428-M245-S | 24.5MM (0.965) | 6 | 3 | 219.18 |
| 428-M250-S | 25.0MM (0.984) | 6 | 3 | 219.18 |
| 428-M255-S | 25.5MM (1.004) | 6 | 3 | 219.18 |
| 428-M260-S | 26.0MM (1.024) | 6 | 3 | 219.18 |
| 428-M18-S | 18 PIECE ASSORTMENT, 3.5MM - 13.0MM, METAL CASE | | | \$562.03 |

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TUFSHOT - EXTENDED LENGTH

| SIZE | 6" LENGTH | | | 9" LENGTH | | | 12" LENGTH | | |
|----------------|-------------|--------------|---------|-------------|--------------|---------|--------------|--------------|---------|
| | PART NUMBER | FLUTE LENGTH | PRICE | PART NUMBER | FLUTE LENGTH | PRICE | PART NUMBER | FLUTE LENGTH | PRICE |
| 3.5MM (0.138) | 429-M35X6 | 1-1/4 | \$31.56 | | | | | | |
| 4.0MM (0.158) | 429-M40X5F | 1-1/4 | 29.22 | | | | | | |
| 5.0MM (0.197) | 429-M50X5F | 1-3/4 | 31.10 | | | | | | |
| 5.5MM (0.217) | 429-M55X6 | 1-3/4 | 35.47 | | | | | | |
| 6.5MM (0.256) | 429-M65X6 | 2-1/4 | 39.52 | 429-M65X9 | 2-1/4 | \$42.57 | | | |
| 6.5MM (0.256) | 429-M65X6F | 4 | 56.47 | 429-M65X9F | 7 | 64.96 | | | |
| 7.0MM (0.276) | 429-M70X6 | 2-1/4 | 41.99 | 429-M70X9 | 2-1/4 | 45.22 | | | |
| 7.5MM (0.295) | 429-M75X6 | 2-1/4 | 41.99 | 429-M75X9 | 2-1/4 | 45.22 | | | |
| 8.0MM (0.315) | 429-M80X6 | 2-1/4 | 48.64 | 429-M80X9 | 2-1/4 | 52.39 | 429-M80X12 | 2-1/4 | \$52.42 |
| 8.0MM (0.315) | 429-M80X6F | 4 | 62.95 | 429-M80X9F | 7 | 72.42 | 429-M80X12F | 10 | 72.28 |
| 8.5MM (0.335) | | | | 429-M85X9 | 2-1/2 | 54.60 | 429-M85X12 | 2-1/2 | 58.80 |
| 9.0MM (0.354) | | | | 429-M90X9 | 2-1/2 | 54.60 | 429-M90X12 | 2-1/2 | 58.80 |
| 9.5MM (0.374) | | | | 429-M95X9 | 2-3/4 | 61.38 | 429-M95X12 | 2-3/4 | 66.10 |
| 9.5MM (0.374) | | | | 429-M95X9F | 7 | 86.30 | 429-M95X12F | 10 | 86.57 |
| 10.0MM (0.394) | | | | 429-M100X9 | 3-3/4 | 61.38 | 429-M100X12 | 3-3/4 | 66.10 |
| 10.5MM (0.413) | | | | 429-M105X9 | 3-3/4 | 72.98 | 429-M105X12 | 3-3/4 | 74.11 |
| 11.0MM (0.433) | | | | 429-M110X9 | 3-3/4 | 76.66 | 429-M110X12 | 3-3/4 | 82.56 |
| 11.0MM (0.433) | | | | 429-M110X9F | 7 | 97.80 | 429-M110X12F | 10 | 98.59 |
| 11.5MM (0.453) | | | | 429-M115X9 | 3-3/4 | 76.66 | 429-M115X12 | 3-3/4 | 82.56 |
| 11.5MM (0.453) | | | | 429-M115X9F | 7 | 97.80 | 429-M115X12F | 10 | 98.59 |
| 12.0MM (0.472) | | | | 429-M120X9 | 3-3/8 | 99.22 | 429-M120X12 | 3-3/8 | 106.85 |
| 12.5MM (0.492) | | | | 429-M125X9 | 3-3/8 | 99.22 | 429-M125X12 | 3-3/8 | 106.85 |
| 13.0MM (0.512) | | | | 429-M130X9 | 3-1/2 | 119.57 | 429-M130X12 | 3-1/2 | 128.78 |
| 13.0MM (0.512) | | | | 429-M130X9F | 7 | 135.28 | 429-M130X12F | 10 | 144.95 |

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TUFSHOT - HARD METAL DRILLING

APPLICATION INFORMATION

When drilling hard metals use high drill speeds and heavy pressure. A drill press is required. The TufShot may be allowed to generate substantial heat; use a water based coolant to avoid excessive heat. When using automatic feed equipment start with a light feed rate (about 1"/minute) and increase to find the optimum feed rate. Reduced speed may increase drill life in some applications. Reduce feed rate when approaching break-through. When using a TufShot to enlarge an existing hole, reduce the speed by half. Also, reduce the feed and flood cool with a water based coolant. When a pilot hole is required, use the smallest practical size.

RECOMMENDED SPEEDS

| SIZE RANGE | RPM |
|--|------|
| 0.125 - 0.137, (1/8, 0.137, 3.5MM) | 4500 |
| 0.151 - 0.166, (5/32, 4.0MM) | 3670 |
| 0.177 - 0.200, (3/16, 5.0MM) | 3050 |
| 0.198 - 0.233, (7/32, 5.5MM) | 2620 |
| 0.236 - 0.263, (1/4, 6.5MM) | 2300 |
| 0.255 - 0.301, (9/32, 7.0 - 7.5MM) | 2040 |
| 0.275 - 0.332, (5/16, 8.0MM) | 1850 |
| 0.314 - 0.362, (11/32, 8.5 - 9.0MM) | 1660 |
| 0.340 - 0.393, (3/8, 9.5 - 10.0MM) | 1550 |
| 0.395 - 0.428, (13/32, 10.5MM) | 1410 |
| 0.395 - 0.463, (7/16, 11.0 - 11.5MM) | 1300 |
| 0.434 - 0.496, (15/32, 12.0 - 12.5MM) | 1220 |
| 0.434 - 0.524, (1/2, 13.0MM) | 1150 |
| 0.473 - 0.586, (9/16, 13.5 - 14.5MM) | 1000 |
| 0.553 - 0.653, (5/8, 15.0 - 16.5MM) | 900 |
| 0.669 - 0.779, (11/16, 3/4, 17.5 - 19.0MM) | 750 |
| 0.750 - 0.908, (13/16, 7/8, 19.5 - 23.0MM) | 655 |
| 0.908 - 1.039, (15/16, 1, 23.5 - 26.0MM) | 570 |

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TufShot - Application Information