



GEN3SYS® and GEN3SYS® XT

Coolant Recommendations - Inch and Metric

IMPORTANT: The coolant pressure and flow rate recommendations below represent a good approximation to obtain optimum tool life and chip evacuation at Allied recommended speeds and feeds. If lower coolant capabilities exist in a drilling application, the GEN3SYS® High Penetration Drilling System will still function at reduced penetration rates. Contact our Application Engineering Department for a more specific recommendation of coolant requirements and/or speeds and feeds.

Stub, 3xD, 5xD, Holder Lengths

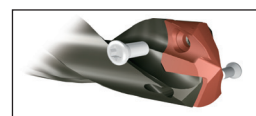
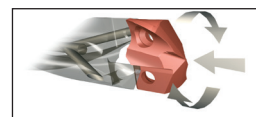
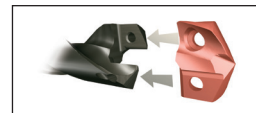
Series	Pressure		Flow Rate	
	PSI	BAR	GPM	LPM
11 mm	500	35	5	19
12 mm	500	35	5	19
13 mm	475	33	5.5	21
14 mm	450	32	6	23
15 mm	430	30	7	27
16 mm	410	29	8	31
17 mm	385	27	8.5	33
18 mm	360	25	9	35
20 mm	300	21	10	38
22 mm	300	21	11	42
24 mm	300	21	11	42
26 mm	300	21	12	46
29 mm	300	21	12	46
32 mm	300	21	12	46

7xD Holder Length

Series	Pressure		Flow Rate	
	PSI	BAR	GPM	LPM
11 mm	750	53	7,5	29
12 mm	750	53	7,5	29
13 mm	713	50	8,25	32
14 mm	675	48	9	35
15 mm	645	45	10,5	40
16 mm	615	44	12	46
17 mm	578	40	12,75	49
18 mm	540	38	13,5	52
20 mm	450	32	15	57
22 mm	450	32	16,5	63
24 mm	450	32	16,5	63
26 mm	450	32	18	69
29 mm	450	32	18	69
32 mm	450	32	18	69

Assembly of GEN3SYS and GEN3SYS XT Tools:

1. Align the flats on the GEN3SYS or GEN3SYS XT Drill Insert with the flats on the ears of the GEN3SYS Holder.
2. Slide the GEN3SYS or GEN3SYS XT Drill Insert into the precision ground locating pocket on the GEN3SYS Holder. The drill insert should not be turned, rotated, or twisted for locking purposes. The holder pocket and locating pads on the drill insert assure optimum fit and repeatability.
3. Place a generous amount of E-Z Break (provided in the packaging) onto the supplied TORX Plus Screws.
4. Tighten the TORX Plus Screws to the recommended torque value specified in the catalog by series. A preset torx driver is available to assure that the proper torque is applied.



Revolution & Opening

APX

GEN3SYS & GEN3SYS XT

Original T-A & GEN2 T-A

AccuPort 432

ASC 320

Special Tooling