



**ALLIED MACHINE  
& ENGINEERING**

**WOHLHAUPTER®**

Holemaking Solutions for Today's Manufacturing



Boring



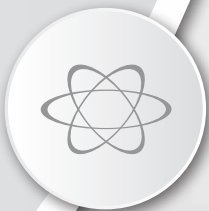
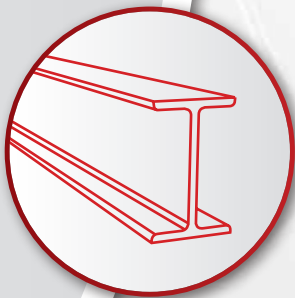
Reaming



Burnishing



Threading



Specials



## Structural Steel Solutions

► *DRILLING*

Replaceable Insert & Indexable Drills



SECTION

---

# A91

---

Structural Steel Solutions

# Structural Steel Drilling Solutions

T-A® and GEN2 T-A® | GEN3SYS® XT Pro and GEN3SYS® XT | 4TEX® Drill

- ▶ **T-A® and GEN2 T-A® Diameter Range:** 14.00 mm - 47.82 mm (0.5512" - 1.8829")
- ▶ **GEN3SYS® XT Pro and GEN3SYS® XT Diameter Range:** 12.00 mm - 35.00 mm (0.4724" - 1.3780")
- ▶ **4TEX® Drill Diameter Range:** 12.00 mm - 39.67 mm (0.472" - 1.562")\*

\*See the 4TEX Drill catalogue (A55-4TX) for all diameters available.



## Take on Tough Drilling

Allied Machine's structural steel drilling system is designed for maximum performance in structural steel materials and applications. These solutions utilise the T-A, GEN2 T-A, GEN3SYS XT Pro, GEN3SYS XT, and 4TEX drill designs and capabilities.

With multiple geometries and coatings, you're sure to find the solution that is right for you. Tough drilling is tough no more.

Your safety and the safety of others is very important. This catalogue contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalogue, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalogue. Safety messages follow these words.

### **WARNING**

**WARNING** (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

**NOTICE** means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

**NOTE** and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

Visit [www.alliedmachine.com](http://www.alliedmachine.com) for the most up-to-date information and procedures.

Excellent chip control

Improves hole quality and surface finish

Provides maximum durability and stability

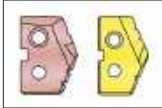
## Applicable Industries



Structural Steel

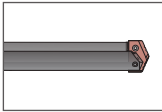
## Reference Icons

The following icons will appear throughout the catalogue to help you navigate between products.



### Corresponding T-A & GEN2 T-A Inserts

Refers to the corresponding T-A insert items that connect with each specific holder series



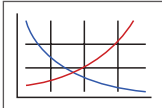
### Corresponding T-A Holders

Refers to the corresponding T-A holder items that connect with each specific insert series



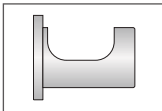
### Setup / Assembly Information

Detailed instructions and information regarding the corresponding part(s)



### Recommended Cutting Data

Speed and feed recommendations for optimum and safe drilling



### Eccentric Sleeves

Refers to the corresponding eccentric sleeve for the holder



### Through Coolant Option

Indicates that the product is coolant through

T-A® and GEN2 T-A® Diameter Range		
Series	Metric (mm)	Imperial (inch)
0	14.00 - 17.67	0.5512 - 0.6959
1	17.53 - 24.40	0.6900 - 0.9609
2	24.41 - 35.06	0.9610 - 1.3809
3	34.37 - 47.82	1.3530 - 1.8829

GEN3SYS® XT Pro and GEN3SYS® XT Diameter Range		
Series	Metric (mm)	Imperial (inch)
12	12.00 - 12.99	0.4724 - 0.5117
13	13.00 - 13.99	0.5118 - 0.5511
14	14.00 - 14.99	0.5512 - 0.5905
15	15.00 - 15.99	0.5906 - 0.6298
16	16.00 - 16.99	0.6299 - 0.6692
17	17.00 - 17.99	0.6693 - 0.7086
18	18.00 - 19.99	0.7087 - 0.7873
20	20.00 - 21.99	0.7874 - 0.8660
22	22.00 - 23.99	0.8661 - 0.9448
24	24.00 - 25.99	0.9449 - 1.0235
26	26.00 - 28.99	1.0236 - 1.1416
29	29.00 - 31.99	1.1417 - 1.2597
32	32.00 - 35.00	1.2598 - 1.3780

4TEX® Drill Diameter Range*		
Series	Metric (mm)	Imperial (inch)
03	12.00 - 13.00	0.472 - 0.512
04	14.00 - 15.00	0.551 - 0.591
05	15.88 - 18.00	0.625 - 0.709
06	19.00 - 21.00	0.748 - 0.827
07	22.00 - 26.00	0.866 - 1.024
09	27.00 - 31.75	1.063 - 1.250
11	32.00 - 38.10	1.260 - 1.500
14	39.00 - 39.67	1.535 - 1.562

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.

## T-A® and GEN2 T-A® Drilling System

T-A and GEN2 T-A System Overview . . . . .	2 - 4
Nomenclature . . . . .	5
0 Series . . . . .	6 - 9
1 Series . . . . .	10 - 13
2 Series . . . . .	14 - 17
3 Series . . . . .	18 - 20
Deep Hole Drilling Guidelines . . . . .	21

## GEN3SYS® XT Pro and GEN3SYS® XT System

GEN3SYS XT Pro and GEN3SYS XT System Overview . . . . .	22 - 23
Product Nomenclature . . . . .	24 - 25
12 - 13 Series . . . . .	26 - 27
14 - 15 Series . . . . .	28 - 29
16 - 17 Series . . . . .	30 - 31
18 - 20 Series . . . . .	32 - 33
22 - 24 Series . . . . .	34 - 35
26 - 29 Series . . . . .	36 - 37
32 Series . . . . .	38

## 4TEX® Drill System

Safety Information . . . . .	40
4TEX Overview . . . . .	41 - 44
Product Nomenclature . . . . .	45
03 Series . . . . .	46
04 Series . . . . .	47
05 Series . . . . .	48 - 49
06 Series . . . . .	50 - 51
07 Series . . . . .	52 - 53
09 Series . . . . .	54 - 55
11 Series . . . . .	56 - 57
14 Series . . . . .	58 - 59
Eccentric Sleeves . . . . .	60
Diameter Adjustment . . . . .	61
Center Height Alignment . . . . .	62 - 63

## Recommended Cutting Data

T-A and GEN2 T-A System . . . . .	64 - 65
GEN3SYS XT Pro and GEN3SYS XT System . . . . .	66 - 67
4TEX Drill System . . . . .	68
4TEX Drill Insert Recommendations   Troubleshooting . . . . .	69
Online Tools . . . . .	70 - 71
Customer Support . . . . .	72 - 73
Guaranteed Application . . . . .	74



## Structural Steel Drilling

### Achieving Optimal Results in Structural Steel

Drilling in structural steel materials can be a difficult process, and achieving optimal results becomes a major issue. Allied Machine's structural steel drilling solutions have been specifically designed to produce the best results in the toughest materials. With solutions in both the T-A® and GEN3SYS® XT Pro product lines, you have multiple options to solve your application problems.



### Insert Style Comparison

						
	GEN3SYS® XT Pro Structural Steel	GEN3SYS® XT Structural Steel	T-A® Thin Wall	T-A® Notch Point®	T-A® 150° Structural Steel	GEN2 T-A® High Efficiency
High penetration	<input checked="" type="checkbox"/>					
Material less than 6 mm (7/16") thick			<input checked="" type="checkbox"/>			
Material over 6 mm (7/16") thick	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Reduced exit burr				<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Includes Notch Point® geometry				<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Available from carbide	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>
Stocked in common sizes for the structural steel industry	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>



A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

**Case Study Example**

# CASE STUDY

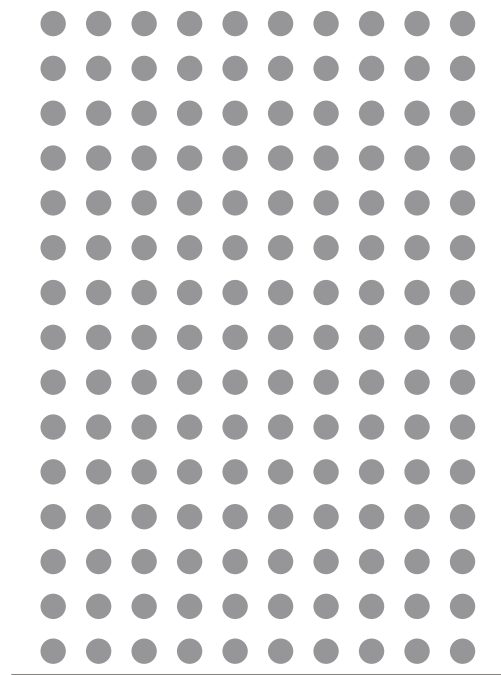


## The **PROOF** is in the **NUMBERS**

**Competitor Insert Tool Life**  
(number of holes = 20)



**T-A Structural Steel Insert Tool Life**  
(number of holes = 1,500)



Overall **SAVINGS** of  
**89%**



**Project Profile:** Structural Steel H-Beam Construction  
**Tooling Solution:** T-A® Structural Steel Drilling System

**The Problem:**  
Previously, the customer was using a competitor spade drill running at the following parameters:

- 650 RPM
- 0.25 mm/rev (0.010 IPR)
- 165.1 mm/min (6.5 IPM)

The tool drilled a 22.23 mm (0.875") diameter hole to a 11.11 mm (0.4375") depth. The drill had a tool life of **only 20 holes**.  
The poor tool performance was brought to the attention of the technician, who was familiar with Allied Machine products. The following day, Allied Machine tooling was brought in for testing. The customer needed improvement in the tool life of the inserts.

**The Solution:**  
Allied Machine recommended the T-A structural steel drilling system.

- **Insert** = 151A-0028-TW (#1 series T-A insert with TiAlN coating and thin wall geometry)
- **Holder** = 25010H-004IS052 (#1 series T-A holder with #4 Morse Taper shank and helical flute)

The tool ran at the following parameters:

- 440 RPM
- 0.25 mm/rev (0.010 IPR)
- 111.7 mm/min (4.4 IPM)

The tool achieved the desired diameter and depth. But most of all, the tool produced **1,500 holes**.

**Summary:**  
The customer was able to take advantage of Allied Machine's vast experience in the structural steel drilling niche. Allied's wide variety of stocked solutions for specific customer problems allows for a remarkable increase in tool life.  
The T-A structural steel drilling system defeated the competition, resulting in a **cost per hole savings of 89%** for the customer.



A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS



## T-A® and GEN2 T-A® Structural Steel Drilling System

# STRUCTURAL STEEL ENHANCEMENTS T-A® & GEN2 T-A®

### GEN2 T-A Insert

Available in AM300® and AM200® Coatings



#### High Efficiency (-HE)

- Improves performance.
- Improves tool life.
- Improves chip formation in structural steel materials.

### T-A Inserts

Available in AM200® and TiAlN Coatings



#### Thin Wall (-TW)

- Designed for drilling 6 mm (7/16") thick or less H-beam or structural materials.
- Increases hole diameter tolerance.
- Improves hole roundness.
- Decreases material deflection.



#### Notch Point® (-NP)

- Provides excellent self-centering characteristics.
- Reduces bell mouth and tool lead-off.
- Reduces axial thrust requirements.



#### Structural Steel (-SS)

- Designed for drilling 6 mm (7/16") thick or thicker H-beam or structural materials.
- Reduces exit burrs.
- Increases stability.
- Lowers drilling forces.
- Includes Notch Point® web geometry.



#### Holder Anatomy

1. Morse Taper Shank
2. Coolant Inlet
3. Flute (straight or helical)
4. Built-up Body Diameter
5. Coolant Outlets



Straight Flute



Helical Flute

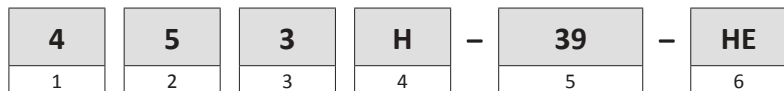
A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS





## T-A® and GEN2 T-A® Drill Nomenclature

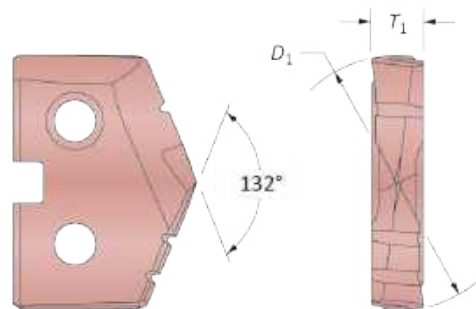
### T-A and GEN2 T-A Drill Inserts



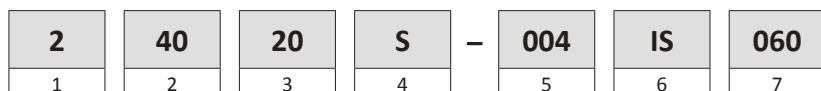
1. Insert	2. Material	3. Series	4. Coating	5. Diameter	6. Geometry
1 = T-A 4 = GEN2 T-A	5 = Super cobalt C1 = K35 (C1) carbide	0 = 0 series 1 = 1 series 2 = 2 series 3 = 3 series	P = AM300® H = AM200® A = TiAlN	13 = Metric 0.515 = Decimal 0017 = Inch	TW = Thin Wall NP = Notch Point® SS = Structural Steel HE = High Efficiency

#### Reference Key

Symbol	Attribute
$D_1$	Insert diameter
$T_1$	Insert thickness



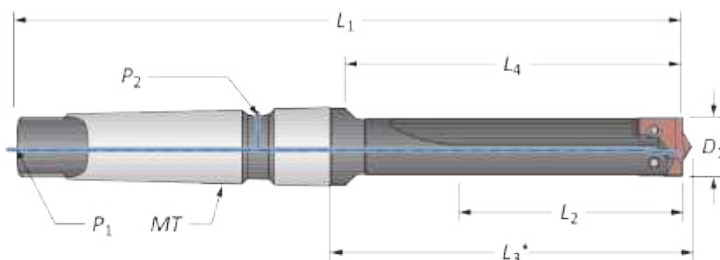
### T-A Drill Holders



1. Holder	2. Length	3. Series	4. Flute
2 = T-A holder	20 = Short 40 = Standard 50 = Extended 60 = Long	00 = 0 series 05 = 0.5 series 10 = 1 series 15 = 1.5 series 20 = 2 series 25 = 2.5 series 30 = 3 series	S = Straight H = Helical
5. Shank Designator	6. Shank Code	7. Minimum Insert Diameter	
003 = 3MT 004 = 4MT	IS = Imperial Morse taper structural steel	In increments of 0.40 mm	

#### Reference Key

Symbol	Attribute	Symbol	Attribute
$D_1$	Drill insert range	$L_4$	Flute length
$L_1$	Overall length	$P_1$	Rear pipe tap
$L_2$	Drill depth	$P_2$	Side pipe tap
$L_{3^*}$	Holder reference length	MT	Morse taper size

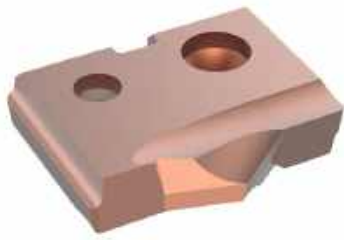


\* $L_3$  is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

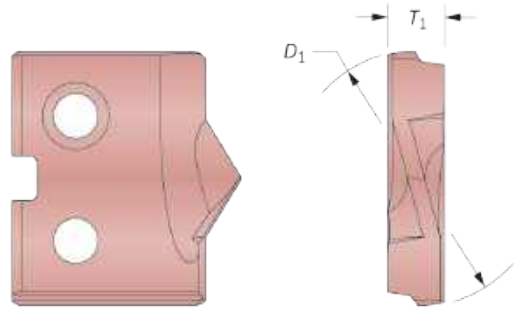


## T-A® Structural Steel Drill Inserts

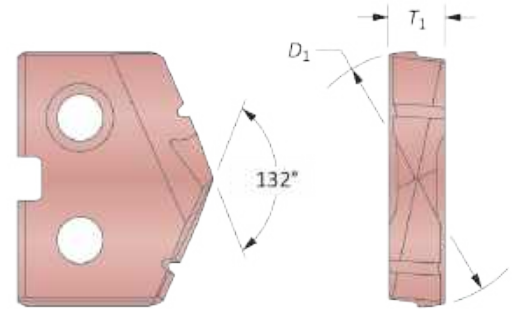
0 Series | Diameter Range: 14.00 mm - 17.67 mm (0.5512" - 0.6959")



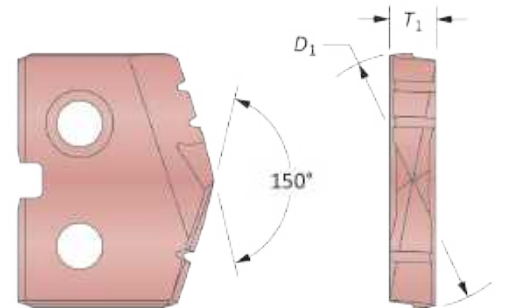
**Thin Wall**  
For material up to 6 mm (7/16") thick



**Notch Point®**  
For material over 6 mm (7/16") thick

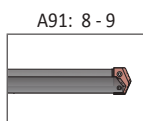
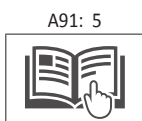
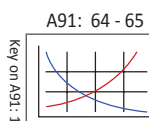


**150° Structural Steel**  
For material over 6 mm (7/16") thick  
and for reduced exit burr



### HSS Inserts – Super Cobalt

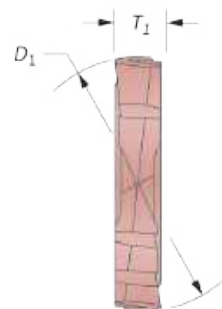
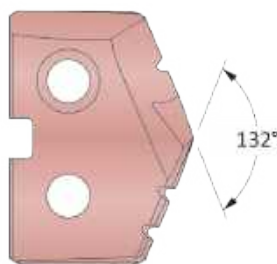
Series	Insert				Thin Wall		Notch Point®		150° Structural Steel	
	D <sub>1</sub> mm	D <sub>1</sub> inch	Fractional Equivalent	T <sub>1</sub>	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.
0	14.00	0.5512	–	3.18	150H-14-TW	150A-14-TW	150H-14-NP	150A-14-NP	150H-14-SS	150A-14-SS
	14.29	0.5625	9/16	3.18	150H-0018-TW	150A-0018-TW	150H-0018-NP	150A-0018-NP	150H-0018-SS	150A-0018-SS
0.5	15.88	0.6250	5/8	3.18	150H-0020-TW	150A-0020-TW	150H-0020-NP	150A-0020-NP	150H-0020-SS	150A-0020-SS
	16.00	0.6299	–	3.18	150H-16-TW	150A-16-TW	150H-16-NP	150A-16-NP	150H-16-SS	150A-16-SS
	17.46	0.6875	11/16	3.18	150H-0022-TW	150A-0022-TW	150H-0022-NP	150A-0022-NP	150H-0022-SS	150A-0022-SS







## GEN2 T-A® Structural Steel Drill Inserts

0 Series | Diameter Range: 14.00 mm - 17.67 mm (0.5512" - 0.6959")



HSS Inserts – Super Cobalt | Carbide Inserts – K35 (C1)

Series	Insert				Part No.	
	$D_1$ mm	$D_1$ inch	Fractional Equivalent	$T_1$	 Super Cobalt	 K35 (C1)
0	14.00	0.5512	–	3.18	450H-14-HE	4C10P-14-HE
	14.29	0.5625	9/16	3.18	450H-0018-HE	4C10P-0018-HE
0.5	15.88	0.6250	5/8	3.18	450H-0020-HE	4C10P-0020-HE
	16.00	0.6299	–	3.18	450H-16-HE	4C10P-16-HE
	17.46	0.6875	11/16	3.18	450H-0022-HE	4C10P-0022-HE

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

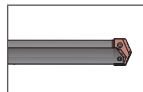
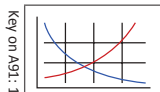
X

SPECIALS

A91: 64 - 65

A91: 5

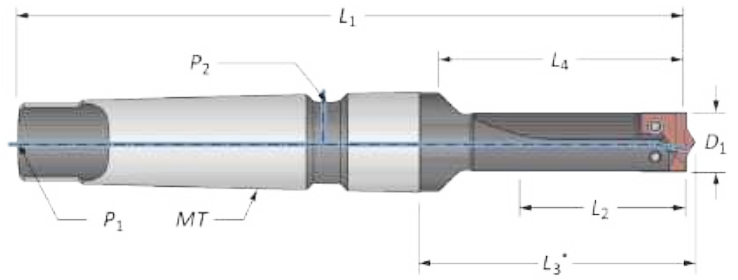
A91: 8 - 9



Inserts sold in multiples of 2.

## T-A® Structural Steel Drill Insert Holders

0 Series | Taper Shank



### Straight Flute #3 Morse Taper

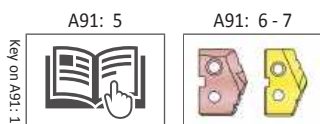
Series	Length	D <sub>1</sub>	Body				Shank			Part No.	
			L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub> *	L <sub>1</sub>	MT	P <sub>1</sub>	P <sub>2</sub>		
m	0	Short	14.29	30.51	57.94	59.89	156.36	#3	TTC	TSC	22000S-003IS036
	0.5	Short	15.88	30.86	57.94	59.89	156.36	#3	TTC	TSC	22005S-003IS040
		Short	17.46	30.58	57.94	59.89	156.36	#3	TTC	TSC	22005S-003IS044
i	0	Short	0.5625	1.201	2.281	2.358	6.156	#3	TTC	TSC	22000S-003IS036
	0.5	Short	0.6250	1.215	2.281	2.358	6.156	#3	TTC	TSC	22005S-003IS040
		Short	0.6875	1.204	2.281	2.358	6.156	#3	TTC	TSC	22005S-003IS044

\*L<sub>3</sub> is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

### Connection Accessories

Series	Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
0	72556-IP8-1	72556N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)
0.5	72567-IP8-1	72567N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



A91: 8

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

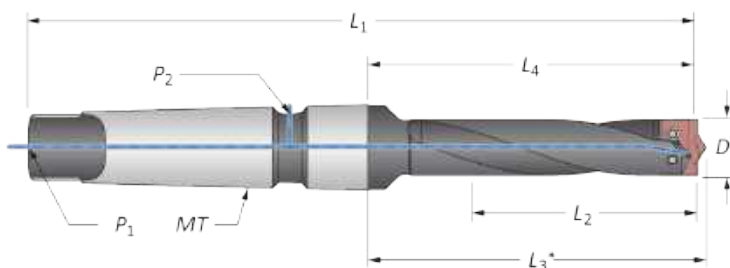
m = Metric (mm)  
i = Imperial (in)

Screws sold in multiples of 10.



## T-A® Structural Steel Drill Insert Holders

0 Series | Taper Shank



### Helical Flute #3 Morse Taper

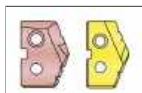
Series	Length	D <sub>1</sub>	Body				Shank			Part No.	
			L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub> *	L <sub>1</sub>	MT	P <sub>1</sub>	P <sub>2</sub>		
m	0	Standard	14.29	76.23	86.51	88.47	184.94	#3	TTC	TSC	24000H-003IS036
	Extended	14.29	180.37	242.21	244.17	340.64	#3	TTC	TSC	⚠ 25000H-003IS036	
m	0.5	Standard	15.88	76.58	86.51	88.47	184.94	#3	TTC	TSC	24005H-003IS040
		Standard	17.46	76.94	86.51	88.47	184.94	#3	TTC	TSC	24005H-003IS044
	Extended	17.46	181.08	242.21	244.17	340.64	#3	TTC	TSC	⚠ 25005H-003IS044	
i	0	Standard	0.5625	3.001	3.406	3.483	7.281	#3	TTC	TSC	24000H-003IS036
		Extended	0.5625	7.101	9.536	9.613	13.411	#3	TTC	TSC	⚠ 25000H-003IS036
	0.5	Standard	0.6250	3.015	3.406	3.483	7.281	#3	TTC	TSC	24005H-003IS040
		Standard	0.6875	3.029	3.406	3.483	7.281	#3	TTC	TSC	24005H-003IS044
		Extended	0.6875	7.129	9.536	9.613	13.411	#3	TTC	TSC	⚠ 25005H-003IS044

\*L<sub>3</sub> is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

A91: 5

A91: 6 - 7

Key on A91: 1



m = Metric (mm)

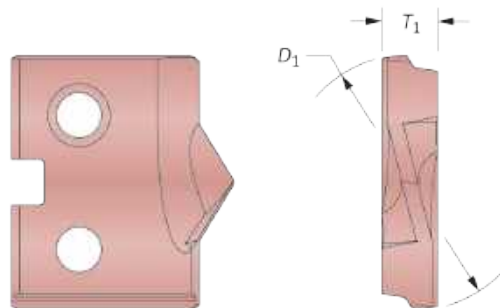
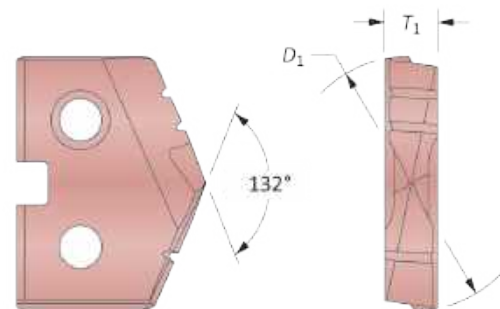
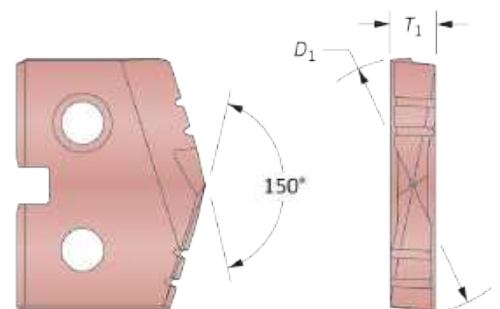
i = Imperial (in)

Screws sold in multiples of 10.

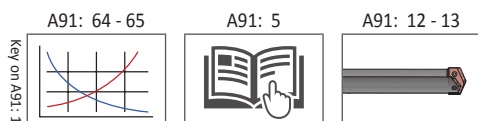
**WARNING** Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A91: 21 for deep hole drilling guidelines in this section of the catalogue. Visit [www.alliedmachine.com/DeepHoleGuidelines](http://www.alliedmachine.com/DeepHoleGuidelines) for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

**T-A® Structural Steel Drill Inserts**

1 Series | Diameter Range: 17.53 mm - 24.40 mm (0.6900" - 0.9609")

**Thin Wall**  
For material up to 6 mm (7/16") thick.**Notch Point®**  
For material over 6 mm (7/16") thick.**150° Structural Steel**  
For material over 6 mm (7/16") thick  
and for reduced exit burr.**HSS Inserts – Super Cobalt**

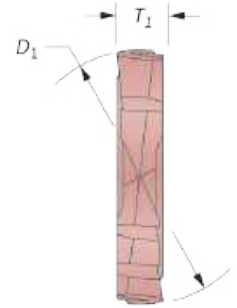
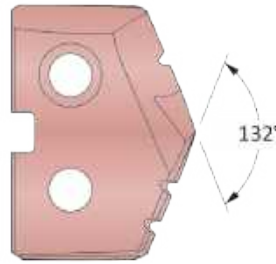
Series	Insert				Thin Wall		Notch Point®		150° Structural Steel	
	D <sub>1</sub> mm	D <sub>1</sub> inch	Fractional Equivalent	T <sub>1</sub>	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.
1	18.00	0.7087	–	3.97	151H-18-TW	151A-18-TW	151H-18-NP	151A-18-NP	151H-18-SS	151A-18-SS
	20.64	0.8125	13/16	3.97	151H-0026-TW	151A-0026-TW	151H-0026-NP	151A-0026-NP	151H-0026-SS	151A-0026-SS
	21.00	0.8268	–	3.97	151H-21-TW	151A-21-TW	151H-21-NP	151A-21-NP	151H-21-SS	151A-21-SS
	22.00	0.8661	–	3.97	151H-22-TW	151A-22-TW	151H-22-NP	151A-22-NP	151H-22-SS	151A-22-SS
1.5	22.23	0.8750	7/8	3.97	151H-0028-TW	151A-0028-TW	151H-0028-NP	151A-0028-NP	151H-0028-SS	151A-0028-SS
	23.81	0.9375	15/16	3.97	151H-0030-TW	151A-0030-TW	151H-0030-NP	151A-0030-NP	151H-0030-SS	151A-0030-SS
	24.00	0.9449	–	3.97	151H-24-TW	151A-24-TW	151H-24-NP	151A-24-NP	151H-24-SS	151A-24-SS





Inserts sold in multiples of 2.

## GEN2 T-A® Structural Steel Drill Inserts

1 Series | Diameter Range: 17.53 mm - 24.40 mm (0.6900" - 0.9609")



HSS Inserts – Super Cobalt | Carbide Inserts – K35 (C1)

Series	Insert				Part No.	
	$D_1$ mm	$D_1$ inch	Fractional Equivalent	$T_1$	 Super Cobalt	 K35 (C1)
1	18.00	0.7087	–	3.97	451H-18-HE	4C11P-18-HE
	20.64	0.8125	13/16	3.97	451H-0026-HE	4C11P-0026-HE
	21.00	0.8268	–	3.97	451H-21-HE	4C11P-21-HE
	22.00	0.8661	–	3.97	451H-22-HE	4C11P-22-HE
1.5	22.23	0.8750	7/8	3.97	451H-0028-HE	4C11P-0028-HE
	23.81	0.9375	15/16	3.97	451H-0030-HE	4C11P-0030-HE
	24.00	0.9449	–	3.97	451H-24-HE	4C11P-24-HE

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

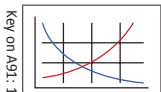
X

SPECIALS

A91: 64 - 65

A91: 5

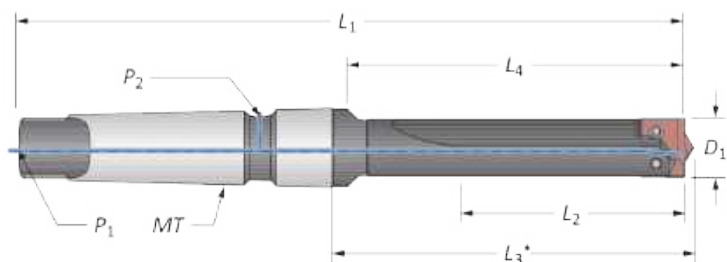
A91: 12 - 13



Inserts sold in multiples of 2.

## T-A® Structural Steel Drill Insert Holders

1 Series | Taper Shank



### Straight Flute #3 Morse Taper

Series	Length	$D_1$	Body				Shank			Part No.
			$L_2$	$L_4$	$L_3^*$	$L_1$	MT	$P_1$	$P_2$	
1	Short	17.86	64.97	100.43	103.58	198.86	#3	TTC	TSC	22010S-003IS045
	Short	20.64	64.97	100.43	103.58	198.86	#3	TTC	TSC	22010S-003IS052
1.5	Short	22.23	65.33	100.43	103.58	198.86	#3	TTC	TSC	22015S-003IS056
	Short	23.81	65.68	100.43	103.58	198.86	#3	TTC	TSC	22015S-003IS060
1	Short	0.7031	2.558	3.954	4.078	7.829	#3	TTC	TSC	22010S-003IS045
	Short	0.8125	2.558	3.954	4.078	7.829	#3	TTC	TSC	22010S-003IS052
1.5	Short	0.8750	2.572	3.954	4.078	7.829	#3	TTC	TSC	22015S-003IS056
	Short	0.9375	2.586	3.954	4.078	7.829	#3	TTC	TSC	22015S-003IS060

\* $L_3$  is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

### Straight Flute #4 Morse Taper

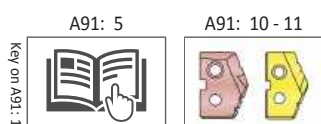
Series	Length	$D_1$	Body				Shank			Part No.
			$L_2$	$L_4$	$L_3^*$	$L_1$	MT	$P_1$	$P_2$	
1	Short	17.86	64.97	100.43	103.58	224.26	#4	TTC	TSC	22010S-004IS045
	Short	20.64	64.97	100.43	103.58	224.26	#4	TTC	TSC	22010S-004IS052
1.5	Short	22.23	65.33	100.43	103.58	224.26	#4	TTC	TSC	22015S-004IS056
	Short	23.81	65.68	100.43	103.58	224.26	#4	TTC	TSC	22015S-004IS060
1	Short	0.7031	2.558	3.954	4.078	8.829	#4	TTC	TSC	22010S-004IS045
	Short	0.8125	2.558	3.954	4.078	8.829	#4	TTC	TSC	22010S-004IS052
1.5	Short	0.8750	2.572	3.954	4.078	8.829	#4	TTC	TSC	22015S-004IS056
	Short	0.9375	2.586	3.954	4.078	8.829	#4	TTC	TSC	22015S-004IS060

\* $L_3$  is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

### Connection Accessories

Series	Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
1	7375-IP9-1	7375N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)
1.5	739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

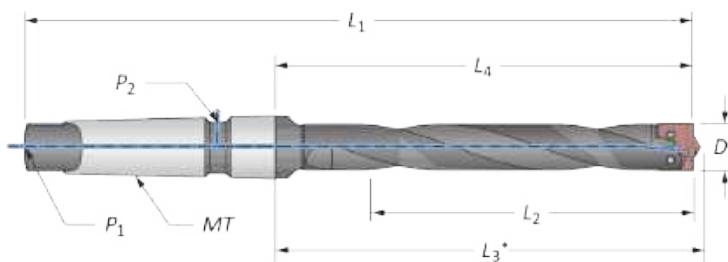






## T-A® Structural Steel Drill Insert Holders

1 Series | Taper Shank



### Helical Flute #3 Morse Taper

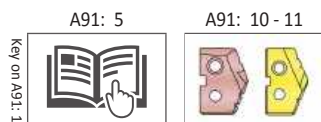
Series	Length	D <sub>1</sub>	Body				Shank			Part No.	
			L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub> *	L <sub>1</sub>	MT	P <sub>1</sub>	P <sub>2</sub>		
m	1	Standard	17.86	137.74	151.23	154.38	249.66	#3	TTC	TSC	24010H-003IS045
		Standard	20.64	137.74	151.23	154.38	249.66	#3	TTC	TSC	24010H-003IS052
	Extended	17.86	180.54	239.34	242.49	337.77	#3	TTC	TSC	⚠ 25010H-003IS045	
		20.64	180.54	239.34	242.49	337.77	#3	TTC	TSC	⚠ 25010H-003IS052	
	1.5	Standard	22.23	140.18	151.23	154.38	249.66	#3	TTC	TSC	24015H-003IS056
		Standard	23.81	140.44	151.23	154.38	249.66	#3	TTC	TSC	24015H-003IS060
Extended	23.81	181.25	239.34	242.49	337.77	#3	TTC	TSC	⚠ 25015H-003IS060		
i	1	Standard	0.7031	5.423	5.954	6.078	9.829	#3	TTC	TSC	24010H-003IS045
		Standard	0.8125	5.423	5.954	6.078	9.829	#3	TTC	TSC	24010H-003IS052
	Extended	0.7031	7.108	9.423	9.547	13.298	#3	TTC	TSC	⚠ 25010H-003IS045	
		0.8125	7.108	9.423	9.547	13.298	#3	TTC	TSC	⚠ 25010H-003IS052	
	1.5	Standard	0.8750	5.519	5.954	6.078	9.829	#3	TTC	TSC	24015H-003IS056
		Standard	0.9375	5.529	5.954	6.078	9.829	#3	TTC	TSC	24015H-003IS060
Extended	0.9375	7.136	9.423	9.547	13.298	#3	TTC	TSC	⚠ 25015H-003IS060		

\*L<sub>3</sub> is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

### Helical Flute #4 Morse Taper

Series	Length	D <sub>1</sub>	Body				Shank			Part No.	
			L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub> *	L <sub>1</sub>	MT	P <sub>1</sub>	P <sub>2</sub>		
m	1	Standard	17.86	134.57	151.23	154.38	275.06	#4	TTC	TSC	24010H-004IS045
		Standard	20.64	134.57	151.23	154.38	275.06	#4	TTC	TSC	24010H-004IS052
	Extended	20.64	169.88	237.74	240.89	361.57	#4	TTC	TSC	⚠ 25010H-004IS052	
		Long	20.64	166.7	402.77	405.92	526.59	#4	TTC	TSC	⚠ 26010H-004IS052
	1.5	Standard	22.23	136.42	151.23	154.38	275.06	#4	TTC	TSC	24015H-004IS056
		Standard	23.81	137.44	151.23	154.38	275.06	#4	TTC	TSC	24015H-004IS060
Extended	23.81	173.13	237.74	240.89	361.57	#4	TTC	TSC	⚠ 25015H-004IS060		
Long	23.81	173.13	403.58	406.73	527.41	#4	TTC	TSC	⚠ 26015H-004IS060		
i	1	Standard	0.7031	5.298	5.954	6.078	10.829	#4	TTC	TSC	24010H-004IS045
		Standard	0.8125	5.298	5.954	6.078	10.829	#4	TTC	TSC	24010H-004IS052
	Extended	0.8125	6.688	9.360	9.484	14.235	#4	TTC	TSC	⚠ 25010H-004IS052	
		0.8125	6.563	15.857	15.981	20.732	#4	TTC	TSC	⚠ 26010H-004IS052	
	1.5	Standard	0.8750	5.371	5.954	6.078	10.829	#4	TTC	TSC	24015H-004IS056
		Standard	0.9375	5.411	5.954	6.078	10.829	#4	TTC	TSC	24015H-004IS060
Extended	0.9375	6.816	9.360	9.484	14.235	#4	TTC	TSC	⚠ 25015H-004IS060		
Long	0.9375	6.816	15.889	16.013	20.764	#4	TTC	TSC	⚠ 26015H-004IS060		

\*L<sub>3</sub> is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.



m = Metric (mm)

i = Imperial (in)

Screws sold in multiples of 10.

**⚠ WARNING** Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A91: 21 for deep hole drilling guidelines in this section of the catalogue. Visit [www.alliedmachine.com/DeepHoleGuidelines](http://www.alliedmachine.com/DeepHoleGuidelines) for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

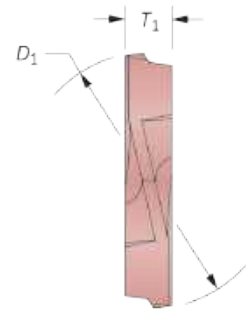
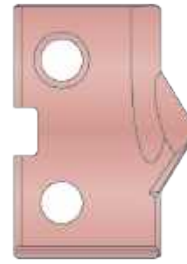


## T-A® Structural Steel Drill Inserts

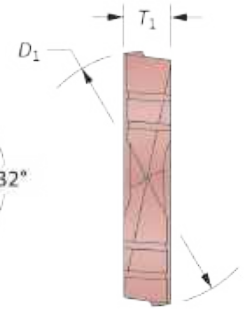
2 Series | Diameter Range: 24.41 mm - 35.06 mm (0.9610" - 1.3809")



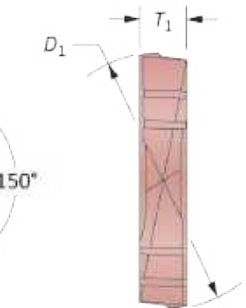
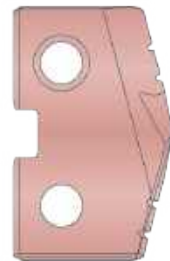
**Thin Wall**  
For material up to 6 mm (7/16") thick.



**Notch Point®**  
For material over 6 mm (7/16") thick.



**150° Structural Steel**  
For material over 6 mm (7/16") thick  
and for reduced exit burr.



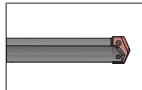
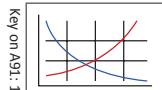
### HSS Inserts – Super Cobalt

Series	Insert				Thin Wall		Notch Point®		150° Structural Steel	
	D <sub>1</sub> mm	D <sub>1</sub> inch	Fractional Equivalent	T <sub>1</sub>	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.
2	25.40	1.0000	1	4.76	152H-0100-TW	152A-0100-TW	152H-0100-NP	152A-0100-NP	152H-0100-SS	152A-0100-SS
	26.00	1.0236	–	4.76	152H-26-TW	152A-26-TW	152H-26-NP	152A-26-NP	152H-26-SS	152A-26-SS
	26.99	1.0625	1-1/16	4.76	152H-0102-TW	152A-0102-TW	152H-0102-NP	152A-0102-NP	152H-0102-SS	152A-0102-SS
	27.00	1.0630	–	4.76	152H-27-TW	152A-27-TW	152H-27-NP	152A-27-NP	152H-27-SS	152A-27-SS
	28.58	1.1250	1-1/8	4.76	152H-0104-TW	152A-0104-TW	152H-0104-NP	152A-0104-NP	152H-0104-SS	152A-0104-SS
2.5	30.16	1.1875	1-3/16	4.76	152H-0106-TW	152A-0106-TW	152H-0106-NP	152A-0106-NP	152H-0106-SS	152A-0106-SS
	31.00	1.2205	–	4.76	152H-31-TW	152A-31-TW	152H-31-NP	152A-31-NP	152H-31-SS	152A-31-SS
	31.75	1.2500	1-1/4	4.76	152H-0108-TW	152A-0108-TW	152H-0108-NP	152A-0108-NP	152H-0108-SS	152A-0108-SS
	33.00	1.2992	–	4.76	152H-33-TW	152A-33-TW	152H-33-NP	152A-33-NP	152H-33-SS	152A-33-SS
	33.34	1.3125	1-5/16	4.76	152H-0110-TW	152A-0110-TW	152H-0110-NP	152A-0110-NP	152H-0110-SS	152A-0110-SS
	34.93	1.3750	1-3/8	4.76	152H-0112-TW	152A-0112-TW	152H-0112-NP	152A-0112-NP	152H-0112-SS	152A-0112-SS

A91: 64 - 65

A91: 5

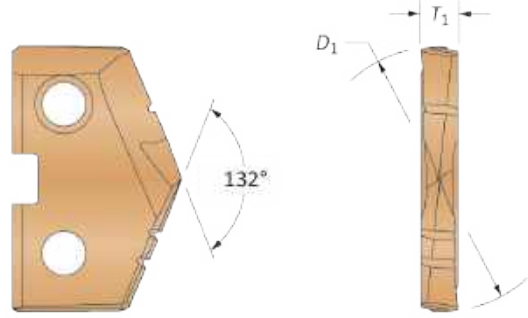
A91: 16 - 17





Inserts sold in multiples of 2.

## GEN2 T-A® Structural Steel Drill Inserts

2 Series | Diameter Range: 24.41 mm - 35.06 mm (0.9610" - 1.3809")

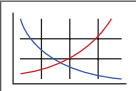


HSS Inserts – Super Cobalt | Carbide Inserts – K35 (C1)

Series	Insert				Part No.	
	$D_1$ mm	$D_1$ inch	Fractional Equivalent	$T_1$	 Super Cobalt	 K35 (C1)
2	25.40	1.0000	1	4.76	452H-0100-HE	4C12P-0100-HE
	26.00	1.0236	–	4.76	452H-26-HE	4C12P-26-HE
	26.99	1.0625	1-1/16	4.76	452H-0102-HE	4C12P-0102-HE
	27.00	1.0630	–	4.76	452H-27-HE	4C12P-27-HE
	28.58	1.1250	1-1/8	4.76	452H-0104-HE	4C12P-0104-HE
2.5	30.16	1.1875	1-3/16	4.76	452H-0106-HE	4C12P-0106-HE
	31.00	1.2205	–	4.76	452H-31-HE	4C12P-31-HE
	31.75	1.2500	1-1/4	4.76	452H-0108-HE	4C12P-0108-HE
	33.00	1.2992	–	4.76	452H-33-HE	4C12P-33-HE
	33.34	1.3125	1-5/16	4.76	452H-0110-HE	4C12P-0110-HE
	34.93	1.3750	1-3/8	4.76	452H-0112-HE	4C12P-0112-HE


A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

A91: 64 - 65




Key on A91: 1

A91: 5



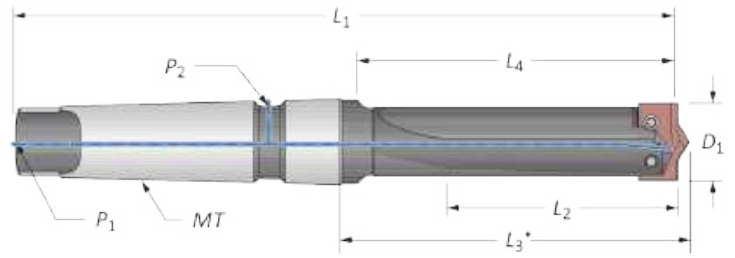
A91: 16 - 17



Inserts sold in multiples of 2.

## T-A® Structural Steel Drill Insert Holders

2 Series | Taper Shank



### Straight Flute #4 Morse Taper

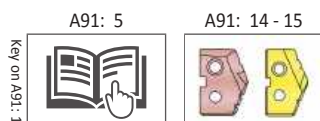
Series	Length	$D_1$	Body				Shank			Part No.	
			$L_2$	$L_4$	$L_3^*$	$L_1$	MT	$P_1$	$P_2$		
m	2	Short	25.40	81.56	116.18	120.02	240.00	#4	TTC	TSC	22020S-004IS100
	2.5	Short	30.16	82.63	116.18	120.02	240.00	#4	TTC	TSC	22025S-004IS112
i	2	Short	1.0000	3.211	4.574	4.725	9.449	#4	TTC	TSC	22020S-004IS100
	2.5	Short	1.1875	3.253	4.574	4.725	9.449	#4	TTC	TSC	22025S-004IS112

\* $L_3$  is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

### Connection Accessories

Series	Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
2	7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)
2.5	7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



A91: 16

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

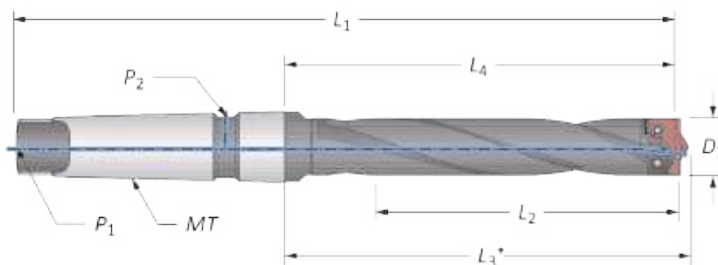
m = Metric (mm)  
i = Imperial (in)

Screws sold in multiples of 10.



## T-A® Structural Steel Drill Insert Holders

2 Series | Taper Shank



### Helical Flute #3 Morse Taper

Series	Length	D <sub>1</sub>	Body				Shank			Part No.	
			L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub> *	L <sub>1</sub>	MT	P <sub>1</sub>	P <sub>2</sub>		
<b>m</b>	2	Extended	25.4	181.41	239.06	242.9	337.49	#3	TTC	TSC	<b>25020H-003IS100</b>
<b>i</b>	2	Extended	1.0000	7.142	9.412	9.563	13.287	#3	TTC	TSC	<b>25020H-003IS100</b>

\*L<sub>3</sub> is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

### Helical Flute #4 Morse Taper

Series	Length	D <sub>1</sub>	Body				Shank			Part No.	
			L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub> *	L <sub>1</sub>	MT	P <sub>1</sub>	P <sub>2</sub>		
<b>m</b>	2	Standard	25.40	148.72	166.98	170.82	290.80	#4	TTC	TSC	<b>24020H-004IS100</b>
		Extended	25.40	172.01	237.62	241.45	361.44	#4	TTC	TSC	<b>25020H-004IS100</b>
		Long	25.40	172.01	408.20	412.04	532.03	#4	TTC	TSC	<b>26020H-004IS100</b>
<b>m</b>	2.5	Standard	30.16	148.72	166.98	170.82	290.80	#4	TTC	TSC	<b>24025H-004IS112</b>
<b>i</b>	2	Standard	1.0000	5.855	6.574	6.725	11.449	#4	TTC	TSC	<b>24020H-004IS100</b>
		Extended	1.0000	6.772	9.355	9.506	14.230	#4	TTC	TSC	<b>25020H-004IS100</b>
		Long	1.0000	6.772	16.071	16.222	20.946	#4	TTC	TSC	<b>26020H-004IS100</b>
<b>i</b>	2.5	Standard	1.1875	5.855	6.574	6.725	11.449	#4	TTC	TSC	<b>24025H-004IS112</b>

\*L<sub>3</sub> is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

A

DRILLING

B

BORING

C

REAMING

D

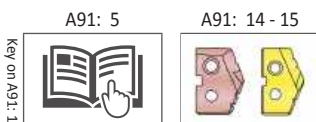
BURNISHING

E

THREADING

X

SPECIALS



**m** = Metric (mm)  
**i** = Imperial (in)  
 Screws sold in multiples of 10.

**WARNING** Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A91: 21 for deep hole drilling guidelines in this section of the catalogue. Visit [www.alliedmachine.com/DeepHoleGuidelines](http://www.alliedmachine.com/DeepHoleGuidelines) for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

3

 DRILLING | Structural Steel Solutions | T-A® and GEN2 T-A® Replaceable Insert Drills

### T-A® Structural Steel Drill Inserts

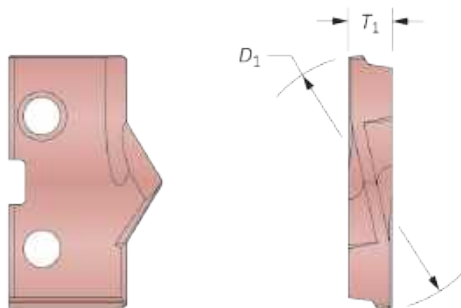
3 Series | Diameter Range: 34.37 mm - 47.82 mm (1.3530" - 1.8829")

A

DRILLING



**Thin Wall**  
For material up to 6 mm (7/16") thick.

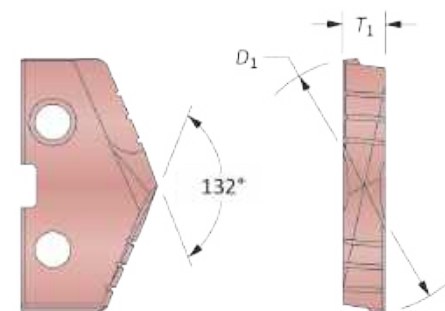


B

BORING



**Notch Point®**  
For material over 6 mm (7/16") thick.

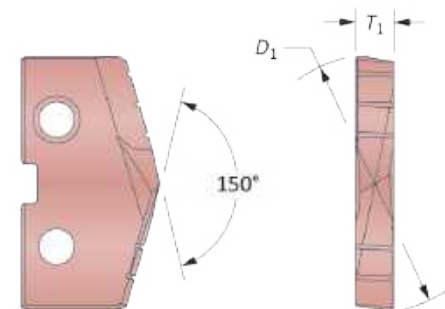


C

REAMING



**150° Structural Steel**  
For material over 6 mm (7/16") thick  
and for reduced exit burr.



D

BURNISHING

HSS Inserts – Super Cobalt

Insert				Thin Wall		Notch Point®		150° Structural Steel	
$D_1$ mm	$D_1$ inch	Fractional Equivalent	$T_1$	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.	AM200® Part No.	TiAlN Part No.
36.51	1.4375	1-7/16	6.35	153H-0114-TW	153A-0114-TW	153H-0114-NP	153A-0114-NP	153H-0114-SS	153A-0114-SS
38.10	1.5000	1-1/2	6.35	153H-0116-TW	153A-0116-TW	153H-0116-NP	153A-0116-NP	153H-0116-SS	153A-0116-SS
39.00	1.5354	-	6.35	153H-39-TW	153A-39-TW	153H-39-NP	153A-39-NP	153H-39-SS	153A-39-SS
39.69	1.5625	1-9/16	6.35	153H-0118-TW	153A-0118-TW	153H-0118-NP	153A-0118-NP	153H-0118-SS	153A-0118-SS

E

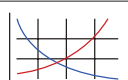
THREADING

X


SPECIALS

Key on A91: 1


A91: 64 - 65



A91: 5



A91: 20



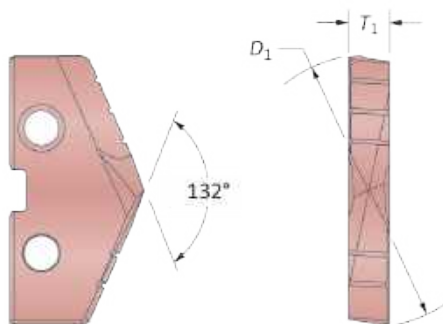
Inserts sold in multiples of 1.

A91: 18


www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

### GEN2 T-A® Structural Steel Drill Inserts

3 Series | Diameter Range: 34.37 mm - 47.82 mm (1.3530" - 1.8829")



#### HSS Inserts – Super Cobalt

Insert				Part No.
$D_1$ mm	$D_1$ inch	Fractional Equivalent	$T_1$	 Super Cobalt
36.51	1.4375	1-7/16	6.35	453H-0114-HE
38.10	1.5000	1-1/2	6.35	453H-0116-HE
39.00	1.5354	–	6.35	453H-39-HE
39.69	1.5625	1-9/16	6.35	453H-0118-HE

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

F

THREADING

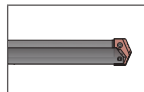
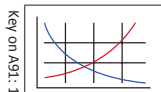
X

SPECIALS

A91: 64 - 65

A91: 5

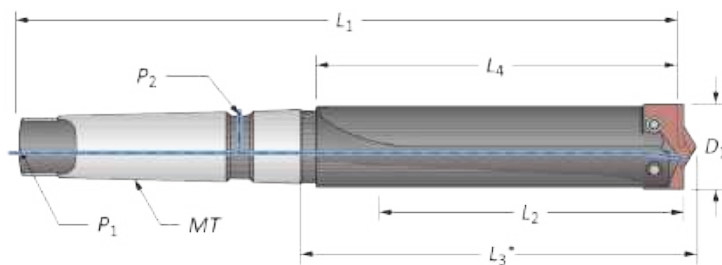
A91: 20



Inserts sold in multiples of 1.

## T-A® Structural Steel Drill Insert Holders

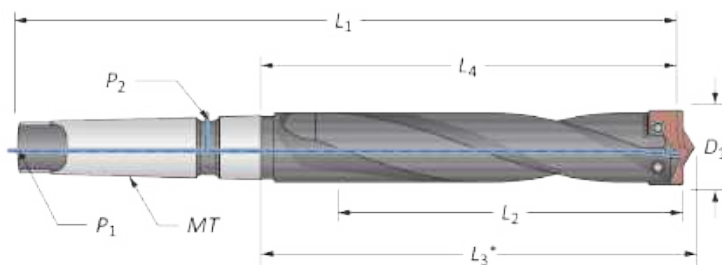
3 Series | Taper Shank



### Straight Flute #4 Morse Taper

Length	$D_1$	Body				Shank			Part No.
		$L_2$	$L_4$	$L_3^*$	$L_1$	MT	$P_1$	$P_2$	
Short	1.4063	4.441	6.037	6.250	10.912	#4	TTC	TSC	22030S-004IS126

\* $L_3$  is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.



### Helical Flute #4 Morse Taper

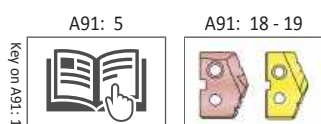
Length	$D_1$	Body				Shank			Part No.
		$L_2$	$L_4$	$L_3^*$	$L_1$	MT	$P_1$	$P_2$	
Standard	1.4063	7.118	7.787	8.000	12.662	#4	TTC	TSC	24030H-004IS126

\* $L_3$  is 1.60 mm (0.063") shorter if using a structural steel holder with Notch Point®, GEN2 T-A®, or 150° structural steel T-A® drill insert geometry.

### Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7514-IP20-1	7514N-IP20-1	8IP-20	–	–	1370 N-cm (121.3 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



A91: 20

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

 = Metric (mm)  
 = Imperial (in)

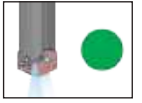



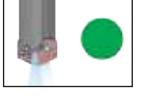
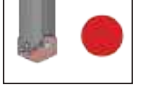
Screws sold in multiples of 10.



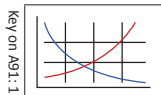


## Deep Hole Drilling Guidelines

For Use with Drills Greater than 9xD (Extended, Long, XL, 3XL, and Special Length)

<p><b>1. Pilot Hole</b> 100 % RPM 100% mm/rev (IPR)</p>	<p>Establish the pilot hole using the same diameter short drill to a depth of 2xD minimum. Utilise a pilot drill with the same or larger included point angle.</p>	<p><b>Coolant ON</b></p> 
<p><b>2. Feed-in</b> 50 RPM max 300 mm/min (12 IPM)</p>	<p>Feed the longer drill within 1.5 mm (1/16") short of the established pilot hole bottom at a <b>maximum of 50 RPM</b> and 300 mm/min (12 IPM) feed rate.</p>	<p><b>Coolant OFF</b></p> 
<p><b>3. Deep Hole Transition Drilling</b> 50 % RPM 75% mm/rev (IPR)</p>	<p>Drill additional 1xD past the bottom of the pilot hole at 50% reduction of recommended speed and 25% reduction of recommended feed. Minimum of 1 second dwell is required to meet full speed before feeding.</p>	<p><b>Coolant ON</b></p> 
<p><b>4. Deep Hole Drilling - Blind</b> 100% RPM 100% mm/rev (IPR)</p>	<p>Drill to full depth at recommended speed and feed for longer drill according to Allied speed and feed charts. <b>No peck cycle recommended.</b></p>	<p><b>Coolant ON</b></p> 
<p><b>5. Deep Hole Drilling - at Breakout</b> 50% RPM 75% mm/rev (IPR)</p>	<p><b>For through holes only:</b> Reduce speed by 50% and feed by 25% prior to breakout. Do not breakout more than 3 mm (1/8") past the full diameter of the drill.</p>	<p><b>Coolant ON</b></p> 
<p><b>2. Drill Retract</b> 50 RPM max</p>	<p>Reduce speed to a <b>maximum of 50 RPM</b> before retracting from the hole.</p>	<p><b>Coolant OFF</b></p> 

A91: 64 - 65



**WARNING** Tool failure can cause serious injury. To prevent:

- When using holders without support bushing, use a short T-A® holder to establish an initial hole that is a minimum of 2 diameters deep.
- Do not rotate tool holders more than 50 RPM unless it is engaged with the workpiece or fixture.

Visit [www.alliedmachine.com/DeepHoleGuidelines](http://www.alliedmachine.com/DeepHoleGuidelines) for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)



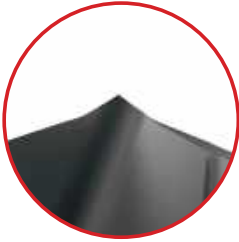
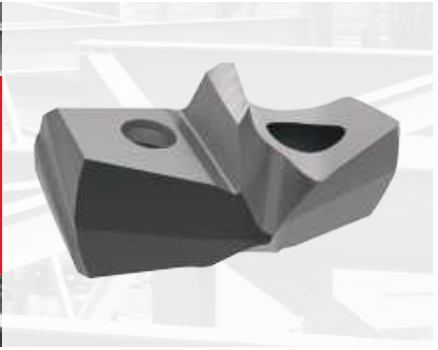
## GEN3SYS® XT Pro Structural Steel Drilling System

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS



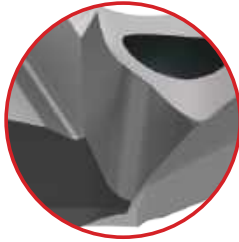
# GEN3SYS® XT Pro **ST**

## STRUCTURAL STEEL ENHANCEMENTS



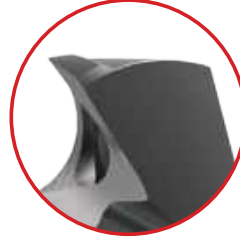
### New Point Design

Increases stability without hindering penetration



### Redesigned Insert

Provides consistent performance and adds durability



### Improved Geometry

Extends tool life and increases insert strength without increasing horsepower consumption



### AM420

**AM420 Coating**  
Increases heat threshold and extends tool life

### Get the Consistency You Need

The challenge of drilling structural steel materials is about to get easier. Developed through a rigorous and thorough testing process, the modified and improved XTST insert is a product of innovation.

Achieve the **consistent performance** you need while matching or even exceeding your current parameters.

### Tough Drilling is Tough No More

Structural steel applications can prove to be difficult to machine, so you need a drill that's been put through the fire to ensure it can conquer those challenging applications.

Rigorous testing and countless hours of design and programming make the XT Pro structural steel insert the optimal drill for structural steel applications.

- Diameter range: 12.00 mm - 35.00 mm (0.4724" - 1.3780").
- Holders available in 1.5xD, 3xD, 5xD, and 7xD lengths.
- Flanged shank with flat.

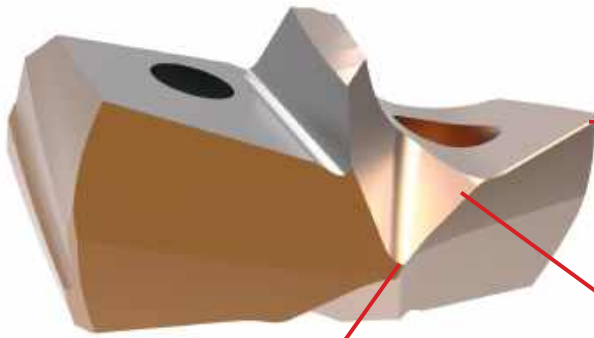


**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*



GEN3SYS® XT Structural Steel Drilling System

# GEN3SYS XT STRUCTURAL STEEL



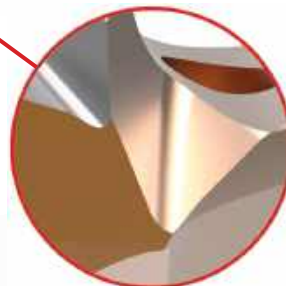
Available in AM300® coating



**Improved Radial Rake**  
Improves chip control



**Spur Point**  
Increases stability



**Improved Notch Point**  
Reduces lead-off



**Holder Anatomy**

1. Flanged Shank with Flat
2. Coolant Inlet
3. Flute (straight only)
4. Coolant Outlets



Straight Flute



1.5xD

3xD

5xD

7xD

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*



## GEN3SYS® XT Pro / GEN3SYS® XT Drill Nomenclature

A  
DRILLING

### GEN3SYS XT Pro Drill Inserts

<b>XT</b>	<b>ST</b>	<b>20</b>	–	<b>20.00</b>
1	2	3		4

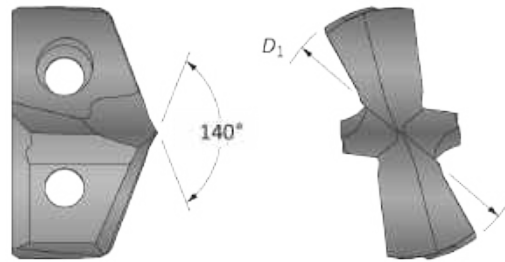


1. XT Pro Drill Insert	2. Geometry	3. Series	4. Diameter (mm)															
XT = XT Pro insert	ST = Structural Steel	<table border="0"> <tr> <td><b>12</b> = 12 series</td> <td><b>17</b> = 17 series</td> <td><b>26</b> = 26 series</td> </tr> <tr> <td><b>13</b> = 13 series</td> <td><b>18</b> = 18 series</td> <td><b>29</b> = 29 series</td> </tr> <tr> <td><b>14</b> = 14 series</td> <td><b>20</b> = 20 series</td> <td><b>32</b> = 32 series</td> </tr> <tr> <td><b>15</b> = 15 series</td> <td><b>22</b> = 22 series</td> <td></td> </tr> <tr> <td><b>16</b> = 16 series</td> <td><b>24</b> = 24 series</td> <td></td> </tr> </table>	<b>12</b> = 12 series	<b>17</b> = 17 series	<b>26</b> = 26 series	<b>13</b> = 13 series	<b>18</b> = 18 series	<b>29</b> = 29 series	<b>14</b> = 14 series	<b>20</b> = 20 series	<b>32</b> = 32 series	<b>15</b> = 15 series	<b>22</b> = 22 series		<b>16</b> = 16 series	<b>24</b> = 24 series		For complete list of diameter ranges by series, see contents page.
<b>12</b> = 12 series	<b>17</b> = 17 series	<b>26</b> = 26 series																
<b>13</b> = 13 series	<b>18</b> = 18 series	<b>29</b> = 29 series																
<b>14</b> = 14 series	<b>20</b> = 20 series	<b>32</b> = 32 series																
<b>15</b> = 15 series	<b>22</b> = 22 series																	
<b>16</b> = 16 series	<b>24</b> = 24 series																	

B  
BORING

#### Reference Key

Symbol	Attribute
$D_1$	Insert diameter

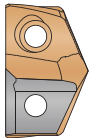


Sizes not shown are available upon request. When ordering, please follow the example below:	
<b>Metric:</b>	20.10 mm, 20 series = use Part No. <b>XTST20-20.10</b>
<b>Imperial:</b>	0.7913", 20 series = use Part No. <b>XTST20-20.10</b>

C  
REAMING

### GEN3SYS XT Drill Inserts

<b>7</b>	<b>C2</b>	<b>20</b>	<b>P</b>	–	<b>20</b>	<b>ST</b>
1	2	3	4		5	6



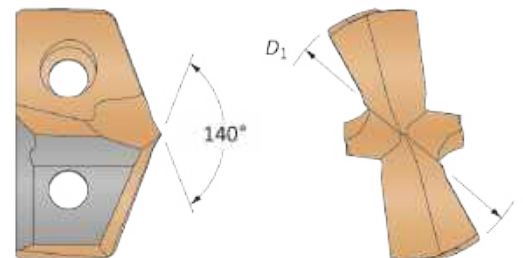
1. XT Drill Insert	2. Insert Material	3. Series	4. Coating												
7 = XT insert	C2 = C2 (K20) carbide	<table border="0"> <tr> <td><b>12</b> = 12 series</td> <td><b>17</b> = 17 series</td> <td><b>24</b> = 24 series</td> </tr> <tr> <td><b>14</b> = 14 series</td> <td><b>18</b> = 18 series</td> <td><b>26</b> = 26 series</td> </tr> <tr> <td><b>15</b> = 15 series</td> <td><b>20</b> = 20 series</td> <td><b>29</b> = 29 series</td> </tr> <tr> <td><b>16</b> = 16 series</td> <td><b>22</b> = 22 series</td> <td><b>32</b> = 32 series</td> </tr> </table>	<b>12</b> = 12 series	<b>17</b> = 17 series	<b>24</b> = 24 series	<b>14</b> = 14 series	<b>18</b> = 18 series	<b>26</b> = 26 series	<b>15</b> = 15 series	<b>20</b> = 20 series	<b>29</b> = 29 series	<b>16</b> = 16 series	<b>22</b> = 22 series	<b>32</b> = 32 series	P = AM300®
<b>12</b> = 12 series	<b>17</b> = 17 series	<b>24</b> = 24 series													
<b>14</b> = 14 series	<b>18</b> = 18 series	<b>26</b> = 26 series													
<b>15</b> = 15 series	<b>20</b> = 20 series	<b>29</b> = 29 series													
<b>16</b> = 16 series	<b>22</b> = 22 series	<b>32</b> = 32 series													

F  
THREADING

5. Diameter	6. Geometry
<b>18</b> = Metric <b>0102</b> = Imperial	ST = Structural steel

#### Reference Key

Symbol	Attribute
$D_1$	Insert diameter



X  
SPECIALS

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*



## GEN3SYS® XT Pro / GEN3SYS® XT Drill Nomenclature

### GEN3SYS XT Structural Steel Drill Holders

<b>ST</b>	<b>03</b>	<b>20</b>	<b>0</b>	-	<b>25</b>	<b>FM</b>
1	2	3	4		5	6

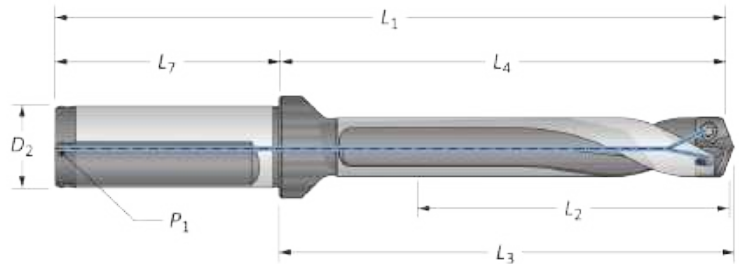


1. Holder	2. Length	3. Series	4. Body Diameter
ST = Structural steel holder	<b>01</b> = 1.5xD <b>03</b> = 3xD <b>05</b> = 5xD <b>07</b> = 7xD	<b>12</b> = 12 series <b>17</b> = 17 series <b>26</b> = 26 series <b>13</b> = 13 series <b>18</b> = 18 series <b>29</b> = 29 series <b>14</b> = 14 series <b>20</b> = 20 series <b>32</b> = 32 series <b>15</b> = 15 series <b>22</b> = 22 series <b>16</b> = 16 series <b>24</b> = 24 series	<b>0</b> = Standard <b>5</b> = Oversized

5. Shank Diameter	6. Shank Style								
<table border="1"> <thead> <tr> <th>Metric (mm)</th> <th>Imperial (in)</th> </tr> </thead> <tbody> <tr> <td><b>16</b> = 16 mm    <b>32</b> = 32 mm</td> <td><b>063</b> = 5/8"    <b>125</b> = 1-1/4"</td> </tr> <tr> <td><b>20</b> = 20 mm    <b>40</b> = 40 mm</td> <td><b>075</b> = 3/4"    <b>150</b> = 1-1/2"</td> </tr> <tr> <td><b>25</b> = 25 mm</td> <td><b>100</b> = 1"</td> </tr> </tbody> </table>	Metric (mm)	Imperial (in)	<b>16</b> = 16 mm <b>32</b> = 32 mm	<b>063</b> = 5/8" <b>125</b> = 1-1/4"	<b>20</b> = 20 mm <b>40</b> = 40 mm	<b>075</b> = 3/4" <b>150</b> = 1-1/2"	<b>25</b> = 25 mm	<b>100</b> = 1"	<b>FM</b> = Flanged metric with flat <b>F</b> = Flanged with flat <b>CM</b> = Cylindrical metric (no flat) <b>C</b> = Cylindrical (no flat)
Metric (mm)	Imperial (in)								
<b>16</b> = 16 mm <b>32</b> = 32 mm	<b>063</b> = 5/8" <b>125</b> = 1-1/4"								
<b>20</b> = 20 mm <b>40</b> = 40 mm	<b>075</b> = 3/4" <b>150</b> = 1-1/2"								
<b>25</b> = 25 mm	<b>100</b> = 1"								

#### Reference Key

Symbol	Attribute
$D_2$	Shank diameter
$L_1$	Overall length
$L_2$	Drill depth
$L_3$	Holder reference length
$L_4$	Holder body length
$L_7$	Shank length
$P_1$	Rear pipe tap



**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

12

DRILLING | Structural Steel Solutions | GEN3SYS® XT Pro and GEN3SYS® XT Replaceable Insert Drills

**GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System**

12 Series | Diameter Range: 12.00 mm - 12.99 mm (0.4724" - 0.5117")

GEN3SYS® XT Pro

GEN3SYS® XT

Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
12.00	0.4724	–	XTST12-12.00	7C212P-12ST

Holders

Length	Body				Shank				Part No.	
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat		
M	1.5xD	19.5	47.1	49.3	97.1	50.0	20	1/8 BSPT	YES	ST01120-20FM
	3xD	39.0	66.6	68.8	116.6	50.0	20	1/8 BSPT	YES	ST03120-20FM
	5xD	65.0	92.6	94.8	142.6	50.0	20	1/8 BSPT	YES	ST05120-20FM
	7xD	90.9	118.5	120.8	168.6	50.0	20	1/8 BSPT	YES	ST07120-20FM
I	1.5xD	0.766	1.859	1.938	3.891	2.031	3/4	1/8 NPT	YES	ST01120-075F
	3xD	1.531	2.625	2.703	4.656	2.031	3/4	1/8 NPT	YES	ST03120-075F
	5xD	2.563	3.641	3.734	5.672	2.031	3/4	1/8 NPT	YES	ST05120-075F
	7xD	3.578	4.672	4.750	6.688	2.031	3/4	1/8 NPT	YES	ST07120-075F

Connection Accessories

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

A91: 66 - 67

A91: 24 - 25

M = Metric (mm)

I = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

A91: 26

[www.alliedmachine.com](http://www.alliedmachine.com) | +44 (0) 1384 400 900 | [enquiries.eu@alliedmachine.com](mailto:enquiries.eu@alliedmachine.com)A  
DRILLINGB  
BORINGC  
REAMINGD  
BURNISHINGE  
THREADINGX  
SPECIALS

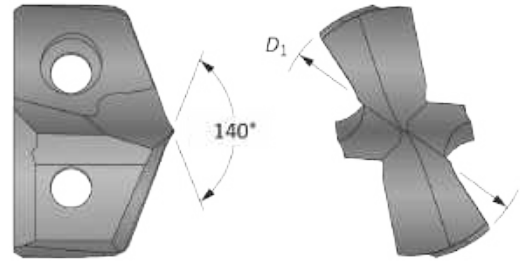


## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

13 Series | Diameter Range: 13.00 mm - 13.99 mm (0.5118" - 0.5511")

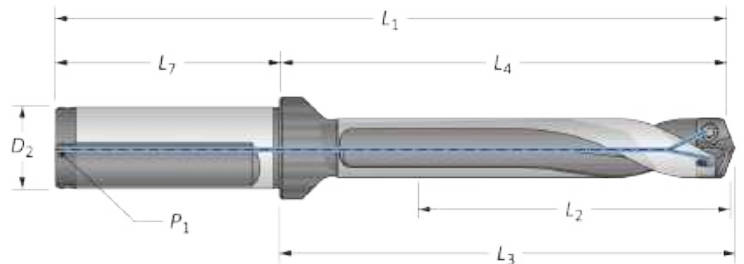


GEN3SYS® XT Pro



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
13.00	0.5118	-	XTST13-13.00	-



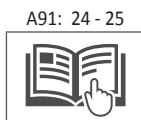
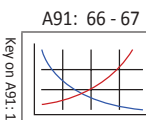
### Holders

Length	Body				Shank				Part No.	
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat		
<b>m</b>	1.5xD	21.1	48.1	50.3	99.7	50.0	20	1/8 BSPT	YES	ST01130-20FM
	3xD	42.1	69.1	71.3	120.7	50.0	20	1/8 BSPT	YES	ST03130-20FM
	5xD	69.9	97.2	99.4	148.8	50.0	20	1/8 BSPT	YES	ST05130-20FM
	7xD	97.9	125.4	127.6	177.0	50.0	20	1/8 BSPT	YES	ST07130-20FM
<b>i</b>	1.5xD	0.828	1.891	1.984	3.922	2.031	3/4	1/8 NPT	YES	ST01130-075F
	3xD	1.656	2.719	2.813	4.750	2.031	3/4	1/8 NPT	YES	ST03130-075F
	5xD	2.750	3.828	3.906	5.859	2.031	3/4	1/8 NPT	YES	ST05130-075F
	7xD	3.859	4.938	5.031	6.969	2.031	3/4	1/8 NPT	YES	ST07130-075F

### Connection Accessories

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

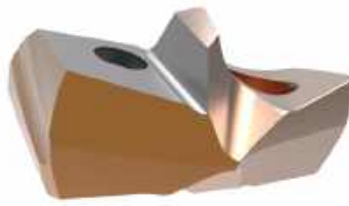
**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

**GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System**

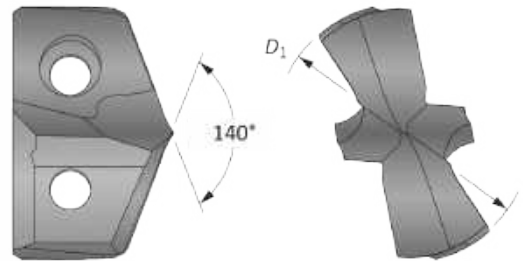
14 Series | Diameter Range: 14.00 mm - 14.99 mm (0.5512" - 0.5905")



GEN3SYS® XT Pro



GEN3SYS® XT

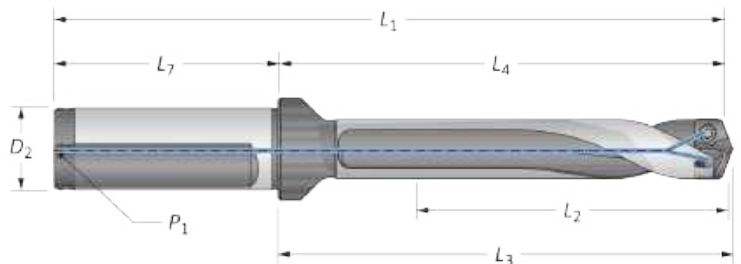


**Inserts**

Insert				
D <sub>1</sub> mm	D <sub>1</sub> inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
14.00	0.5512	-	XTST14-14.00	7C214P-14ST
14.29	0.5626	9/16	XTST14-14.29	7C214P-0018ST



REAMING



**Holders**

	Length	Body				Shank				Part No.
		L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	P <sub>1</sub>	Flat	
m	1.5xD	22.5	49.9	52.5	99.9	50.0	20	1/8 BSPT	YES	ST01140-20FM
	3xD	45.0	72.4	75.0	122.4	50.0	20	1/8 BSPT	YES	ST03140-20FM
	5xD	75.0	102.4	104.9	152.4	50.0	20	1/8 BSPT	YES	ST05140-20FM
	7xD	104.9	132.3	134.9	182.3	50.0	20	1/8 BSPT	YES	ST07140-20FM
i	1.5xD	0.906	1.953	2.063	3.984	2.031	3/4	1/8 NPT	YES	ST01140-075F
	3xD	1.781	2.844	2.953	4.875	2.031	3/4	1/8 NPT	YES	ST03140-075F
	5xD	2.953	4.031	4.125	6.063	2.031	3/4	1/8 NPT	YES	ST05140-075F
	7xD	4.141	5.203	5.313	7.234	2.031	3/4	1/8 NPT	YES	ST07140-075F

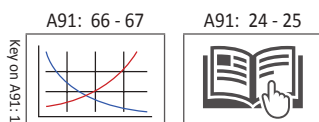
BURNISHING

**Connection Accessories**

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

THREADING



SPECIALS

m = Metric (mm)  
i = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)



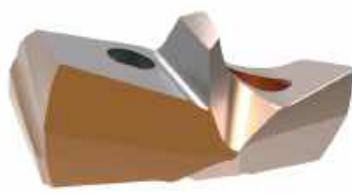


## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

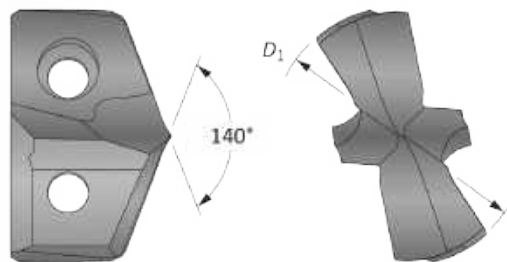
15 Series | Diameter Range: 15.00 mm - 15.99 mm (0.5906" - 0.6298")



GEN3SYS® XT Pro

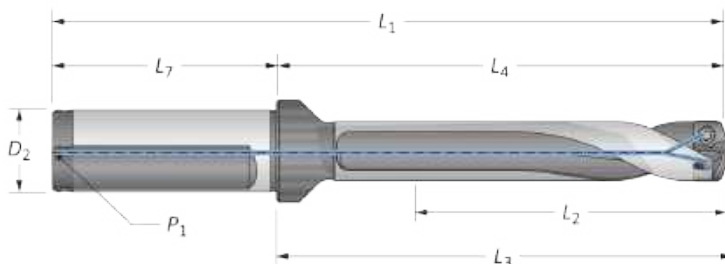


GEN3SYS® XT



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
15.00	0.5906	–	XTST15-15.00	–
15.88	0.6252	5/8	XTST15-15.88	7C215P-0020ST



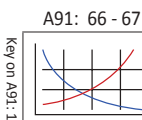
### Holders

	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b>	1.5xD	24.0	51.1	53.6	101.1	50.0	20	1/8 BSPT	YES	ST01150-20FM
	3xD	48.0	75.1	77.6	125.1	50.0	20	1/8 BSPT	YES	ST03150-20FM
	5xD	80.0	107.0	109.6	157.0	50.0	20	1/8 BSPT	YES	ST05150-20FM
	7xD	111.9	139.0	141.6	189.0	50.0	20	1/8 BSPT	YES	ST07150-20FM
<b>i</b>	1.5xD	0.953	2.016	2.109	4.047	2.031	3/4	1/8 NPT	YES	ST01150-075F
	3xD	1.891	2.953	3.047	4.984	2.031	3/4	1/8 NPT	YES	ST03150-075F
	5xD	3.156	4.219	4.313	6.234	2.031	3/4	1/8 NPT	YES	ST05150-075F
	7xD	4.422	5.469	5.578	7.500	2.031	3/4	1/8 NPT	YES	ST07150-075F

### Connection Accessories

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



A91: 24 - 25



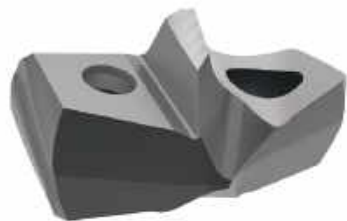
**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

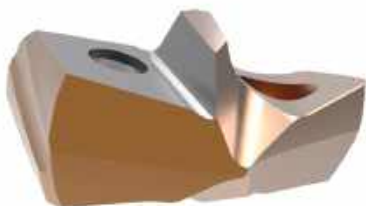
**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

**GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System**

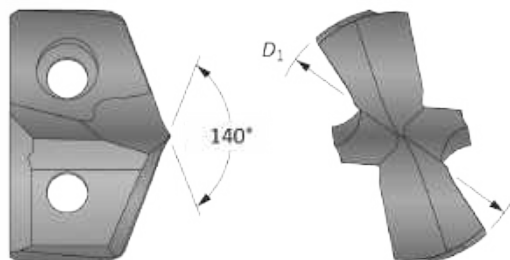
16 Series | Diameter Range: 16.00 mm - 16.99 mm (0.6299" - 0.6692")



GEN3SYS® XT Pro

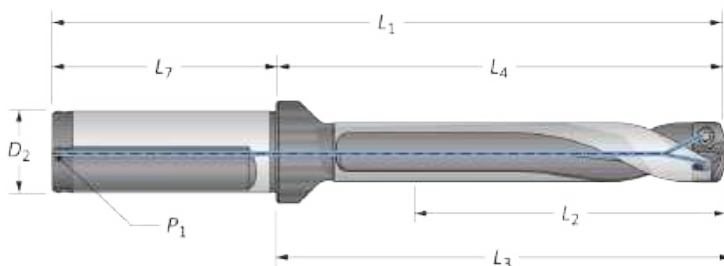


GEN3SYS® XT



**Inserts**

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
16.00	0.6299	-	XTST16-16.00	7C216P-16ST



**Holders**

Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
1.5xD	25.5	55.8	58.7	105.8	50.0	20	1/8 BSPT	YES	ST01160-20FM
3xD	51.0	81.3	84.2	131.3	50.0	20	1/8 BSPT	YES	ST03160-20FM
5xD	84.9	115.3	118.2	165.3	50.0	20	1/8 BSPT	YES	ST05160-20FM
7xD	118.9	149.3	152.2	199.3	50.0	20	1/8 BSPT	YES	ST07160-20FM
1.5xD	1.016	2.203	2.313	4.234	2.031	3/4	1/8 NPT	YES	ST01160-075F
3xD	3.016	3.203	3.313	5.234	2.031	3/4	1/8 NPT	YES	ST03160-075F
5xD	3.359	4.531	4.656	6.563	2.031	3/4	1/8 NPT	YES	ST05160-075F
7xD	4.688	5.875	5.984	7.906	2.031	3/4	1/8 NPT	YES	ST07160-075F

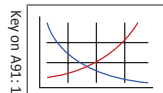
**Connection Accessories**

					Admissible Tightening Torque*
72556-IP8-1	72556N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

A91: 66 - 67

A91: 24 - 25



$\text{M}$  = Metric (mm)  
 $\text{I}$  = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

A  
DRILLING

B  
BORING

C  
REAMING

D  
BURNISHING

E  
THREADING

X  
SPECIALS

## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

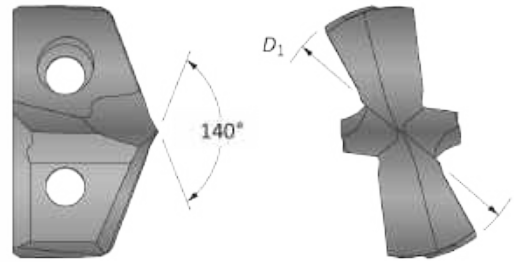
17 Series | Diameter Range: 17.00 mm - 17.99 mm (0.6693" - 0.7086")



GEN3SYS® XT Pro

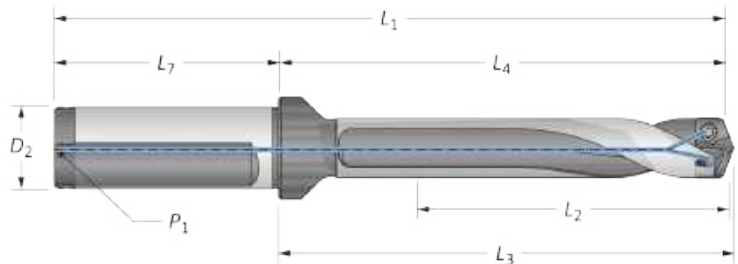


GEN3SYS® XT



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
17.00	0.6693	–	XTST17-17.00	–
17.46	0.6876	11/16	XTST17-17.46	7C217P-0022ST



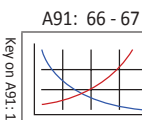
### Holders

	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
m	1.5xD	27.0	57.1	60.0	107.1	50.0	20	1/8 BSPT	YES	ST01170-20FM
	3xD	54.0	84.1	87.0	134.1	50.0	20	1/8 BSPT	YES	ST03170-20FM
	5xD	89.9	120.0	122.9	170.0	50.0	20	1/8 BSPT	YES	ST05170-20FM
	7xD	125.9	156.0	158.9	206.0	50.0	20	1/8 BSPT	YES	ST07170-20FM
i	1.5xD	1.063	2.250	2.359	4.281	2.031	3/4	1/8 NPT	YES	ST01170-075F
	3xD	2.125	3.313	3.422	5.344	2.031	3/4	1/8 NPT	YES	ST03170-075F
	5xD	3.547	4.719	4.844	6.750	2.031	3/4	1/8 NPT	YES	ST05170-075F
	7xD	4.969	6.141	6.250	8.172	2.031	3/4	1/8 NPT	YES	ST07170-075F

### Connection Accessories

					Admissible Tightening Torque*
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	
72567-IP8-1	72567N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



m = Metric (mm)  
i = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

18

DRILLING | Structural Steel Solutions | GEN3SYS® XT Pro and GEN3SYS® XT Replaceable Insert Drills

**GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System**

18 Series | Diameter Range: 18.00 mm - 19.99 mm (0.7087" - 0.7873")

GEN3SYS® XT Pro

GEN3SYS® XT

Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
18.00	0.7087	–	XTST18-18.00	7C218P-18ST
19.00	0.7480	–	XTST18-19.00	–

Holders

Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
1.5xD	30.0	64.0	67.1	114.0	50.0	20	1/8 BSPT	YES	<b>ST01180-20FM</b>
3xD	60.0	94.0	97.1	144.0	50.0	20	1/8 BSPT	YES	<b>ST03180-20FM</b>
5xD	99.9	134.0	137.1	184.0	50.0	20	1/8 BSPT	YES	<b>ST05180-20FM</b>
7xD	139.9	174.0	177.1	224.0	50.0	20	1/8 BSPT	YES	<b>ST07180-20FM</b>
1.5xD	1.188	2.531	2.641	4.797	2.281	1	1/8 NPT	YES	<b>ST01180-100F</b>
3xD	2.375	3.703	3.828	5.984	2.281	1	1/8 NPT	YES	<b>ST03180-100F</b>
5xD	3.938	5.281	5.391	7.563	2.281	1	1/8 NPT	YES	<b>ST05180-100F</b>
7xD	5.516	6.844	6.969	9.125	2.281	1	1/8 NPT	YES	<b>ST07180-100F</b>

Connection Accessories

					Admissible Tightening Torque*
7375-IP9-1	7375N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

A91: 66 - 67

A91: 24 - 25

M = Metric (mm)

I = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

A91: 32

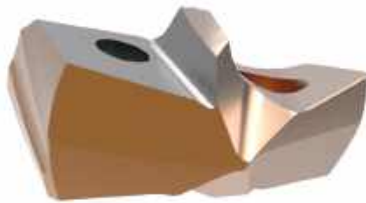
[www.alliedmachine.com](http://www.alliedmachine.com) | +44 (0) 1384 400 900 | [enquiries.eu@alliedmachine.com](mailto:enquiries.eu@alliedmachine.com)A  
DRILLINGB  
BORINGC  
REAMINGD  
BURNISHINGE  
THREADINGX  
SPECIALS

## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

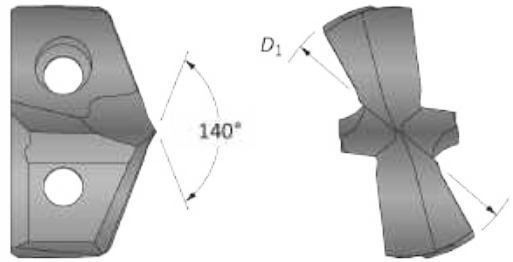
20 Series | Diameter Range: 20.00 mm - 21.99 mm (0.7874" - 0.8660")



GEN3SYS® XT Pro

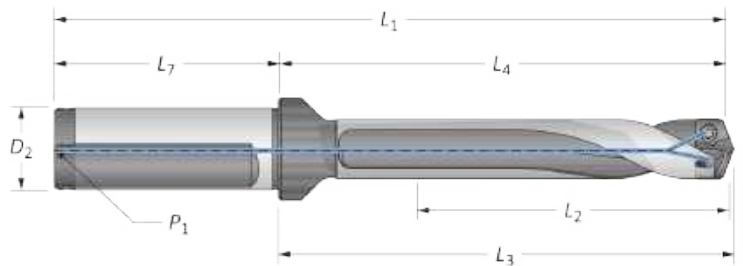


GEN3SYS® XT



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
20.00	0.7874	–	XTST20-20.00	7C220P-20ST
20.64	0.8126	13/16	XTST20-20.64	7C220P-0026ST
21.00	0.8268	–	XTST20-21.00	–
21.82	0.8591	–	XTST20-21.82	–



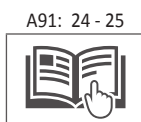
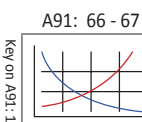
### Holders

	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b>	1.5xD	33.0	67.1	70.3	123.1	56.0	25	1/8 BSPT	YES	ST01200-25FM
	3xD	66.0	100.1	103.3	156.1	56.0	25	1/8 BSPT	YES	ST03200-25FM
	5xD	110.0	144.1	147.2	200.1	56.0	25	1/8 BSPT	YES	ST05200-25FM
	7xD	153.9	188.1	191.2	244.1	56.0	25	1/8 BSPT	YES	ST07200-25FM
<b>i</b>	1.5xD	1.234	2.641	2.766	4.922	2.281	1	1/8 NPT	YES	ST01200-100F
	3xD	2.531	3.938	4.063	6.219	2.281	1	1/8 NPT	YES	ST03200-100F
	5xD	4.344	5.672	5.797	7.953	2.281	1	1/8 NPT	YES	ST05200-100F
	7xD	6.063	7.406	7.531	9.688	2.281	1	1/8 NPT	YES	ST07200-100F

### Connection Accessories

					Admissible Tightening Torque*
7375-IP9-1	7375N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

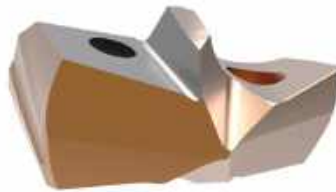
**GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System**

22 Series | Diameter Range: 22.00 mm - 23.99 mm (0.8661" - 0.9448")

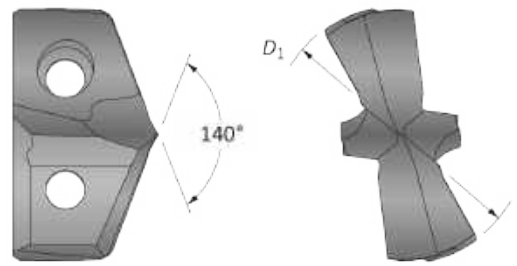
A  
DRILLING



GEN3SYS® XT Pro



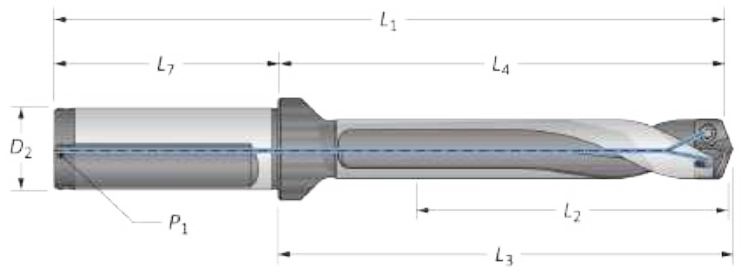
GEN3SYS® XT



**Inserts**

Insert				
D <sub>1</sub> mm	D <sub>1</sub> inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
22.00	0.8661	-	XTST22-22.00	7C222P-22ST
22.23	0.8752	7/8	XTST22-22.23	7C222P-0028ST
23.00	0.9055	-	XTST22-23.00	-
23.81	0.9374	15/16	XTST22-23.81	7C222P-0030ST

B  
BORING



**Holders**

Length	Body				Shank				Part No.
	L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	P <sub>1</sub>	Flat	
1.5xD	36.0	69.3	72.7	125.3	56.0	25	1/8 BSPT	YES	ST01220-25FM
1.5xD	36.0	69.3	72.7	125.3	56.0	25	1/8 BSPT	YES	ST01225-25FM
3xD	72.0	105.3	108.7	161.3	56.0	25	1/8 BSPT	YES	ST03220-25FM
3xD	72.0	105.3	108.7	161.3	56.0	25	1/8 BSPT	YES	ST03225-25FM*
5xD	119.9	153.3	156.7	209.3	56.0	25	1/8 BSPT	YES	ST05220-25FM
5xD	119.9	153.3	156.7	209.3	56.0	25	1/8 BSPT	YES	ST05225-25FM*
7xD	167.9	201.3	204.7	257.3	56.0	25	1/8 BSPT	YES	ST07220-25FM
7xD	167.9	201.3	204.7	257.3	56.0	25	1/8 BSPT	YES	ST07225-25FM*
1.5xD	1.406	2.719	2.859	5.000	2.281	1	1/8 NPT	YES	ST01220-100F
1.5xD	1.406	2.719	2.859	5.000	2.281	1	1/8 NPT	YES	ST01225-100F
3xD	2.828	4.141	4.281	6.422	2.281	1	1/8 NPT	YES	ST03220-100F
3xD	2.828	4.141	4.281	6.422	2.281	1	1/8 NPT	YES	ST03225-100F*
5xD	4.719	6.031	6.172	8.313	2.281	1	1/8 NPT	YES	ST05220-100F
5xD	4.719	6.031	6.172	8.313	2.281	1	1/8 NPT	YES	ST05225-100F*
7xD	6.609	7.922	8.063	10.203	2.281	1	1/8 NPT	YES	ST07220-100F
7xD	6.609	7.922	8.063	10.203	2.281	1	1/8 NPT	YES	ST07225-100F*

\*Oversized body holder (minimum drill diameter = 23 mm)

D  
BURNISHING

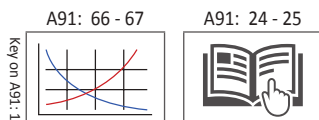
**Connection Accessories**

					Admissible Tightening Torque*
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

F  
THREADING

X  
SPECIALS



**M** = Metric (mm)  
**I** = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

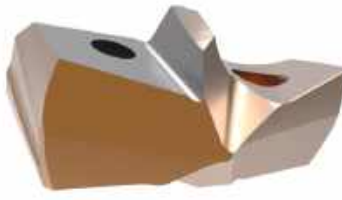
**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: engineering.eu@alliedmachine.com*

## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

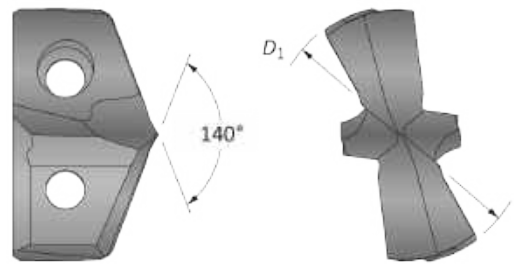
24 Series | Diameter Range: 24.00 mm - 25.99 mm (0.9449" - 1.0235")



GEN3SYS® XT Pro

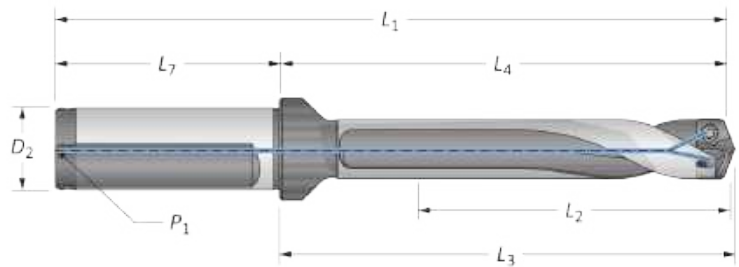


GEN3SYS® XT



Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
24.00	0.9449	–	XTST24-24.00	7C224P-24ST
24.60	0.9685	–	XTST24-24.60	–
25.40	1.0000	1	XTST24-25.40	7C224P-0100ST
25.78	1.0150	–	XTST24-25.78	–



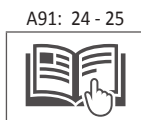
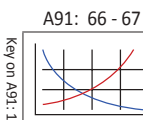
Holders

	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b>	1.5xD	39.0	74.8	78.3	130.8	56.0	25	1/8 BSPT	YES	ST01240-25FM
	3xD	78.0	113.8	117.3	169.8	56.0	25	1/8 BSPT	YES	ST03240-25FM
	5xD	129.9	165.8	169.2	221.8	56.0	25	1/8 BSPT	YES	ST05240-25FM
	7xD	181.9	217.8	221.2	273.8	56.0	25	1/8 BSPT	YES	ST07240-25FM
<b>i</b>	1.5xD	1.547	2.953	3.094	5.234	2.281	1	1/8 NPT	YES	ST01240-100F
	3xD	3.078	4.484	4.625	6.766	2.281	1	1/8 NPT	YES	ST03240-100F
	5xD	5.125	6.531	6.656	8.813	2.281	1	1/8 NPT	YES	ST05240-100F
	7xD	7.172	8.578	8.703	10.859	2.281	1	1/8 NPT	YES	ST07240-100F

Connection Accessories

					Admissible Tightening Torque*
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



**m** = Metric (mm)  
**i** = Imperial (in)

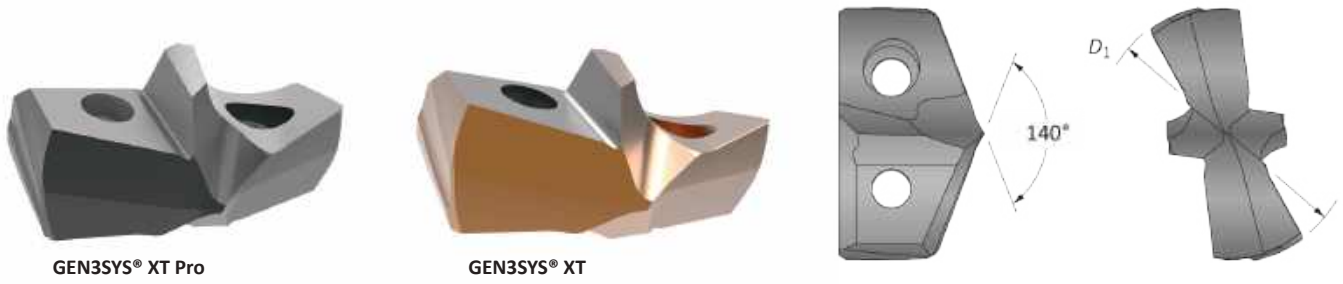
Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

26 Series | Diameter Range: 26.00 mm - 28.99 mm (1.0236" - 1.1416")

A  
DRILLING

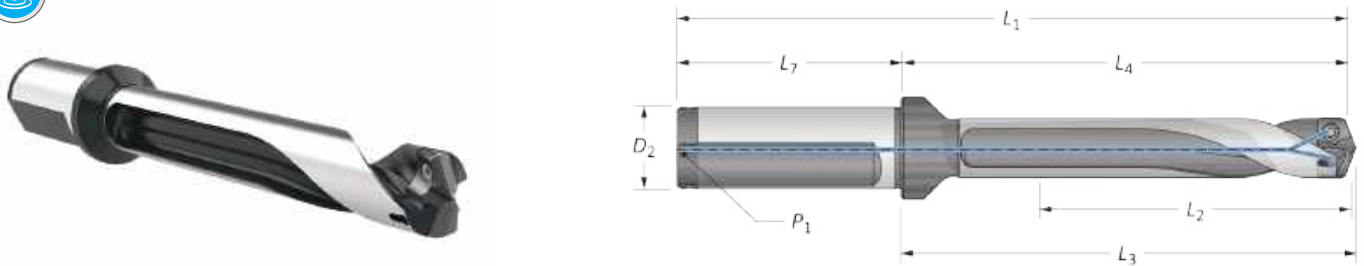


B  
BORING

### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
26.00	1.0236	–	XTST26-26.00	7C226P-26ST
26.99	1.0626	1-1/16	XTST26-26.99	7C226P-0102ST
27.00	1.0630	–	XTST26-27.00	7C226P-27ST
28.00	1.1024	–	XTST26-28.00	7C226P-28ST
28.58	1.1252	1-1/8	XTST26-28.58	7C226P-0104ST

C  
REAMING



D  
BURNISHING

### Holders

	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
m	1.5xD	43.5	84.6	87.9	144.6	60.0	32	1/4 BSPT	YES	ST01260-32FM
	3xD	87.0	128.1	131.4	188.1	60.0	32	1/4 BSPT	YES	ST03260-32FM
	5xD	145.0	186.1	189.4	246.1	60.0	32	1/4 BSPT	YES	ST05260-32FM
	7xD	202.9	244.0	247.4	304.0	60.0	32	1/4 BSPT	YES	ST07260-32FM
i	1.5xD	1.703	3.344	3.469	5.625	2.281	1-1/4	1/4 NPT	YES	ST01260-125F
	3xD	3.422	5.063	5.188	7.344	2.281	1-1/4	1/4 NPT	YES	ST03260-125F
	5xD	5.719	7.344	7.484	9.625	2.281	1-1/4	1/4 NPT	YES	ST05260-125F
	7xD	7.984	9.625	9.766	11.906	2.281	1-1/4	1/4 NPT	YES	ST07260-125F

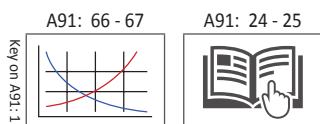
E  
THREADING

### Connection Accessories

					Admissible Tightening Torque*
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

X  
SPECIALS



m = Metric (mm)  
i = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

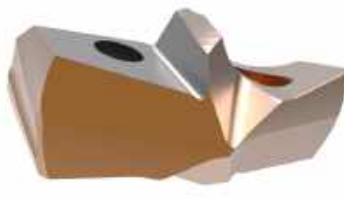


## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

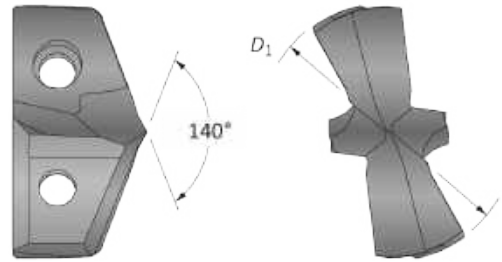
29 Series | Diameter Range: 29.00 mm - 31.99 mm (1.1417" - 1.2597")



GEN3SYS® XT Pro

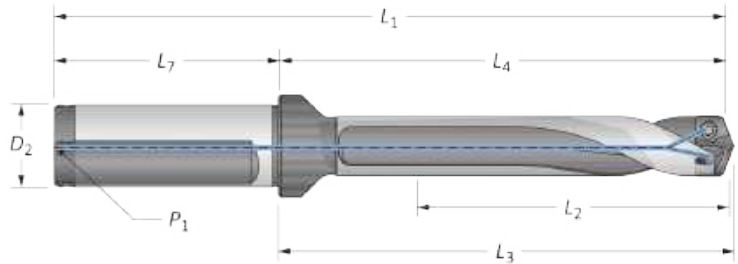


GEN3SYS® XT



Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
29.00	1.1417	-	XTST29-29.00	7C229P-29ST
30.00	1.1811	-	XTST29-30.00	7C229P-30ST
30.16	1.1874	1-3/16	XTST29-30.16	7C229P-0106ST
31.00	1.2205	-	XTST29-31.00	7C229P-31ST
31.75	1.2500	1-1/4	XTST29-31.75	7C229P-0108ST



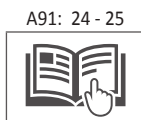
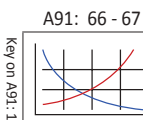
HOLDERS

	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b>	1.5xD	48.0	88.2	91.7	148.2	60.0	32	1/4 BSPT	YES	ST01290-32FM
	3xD	96.0	136.2	139.7	196.2	60.0	32	1/4 BSPT	YES	ST03290-32FM
	5xD	159.9	200.1	203.7	260.1	60.0	32	1/4 BSPT	YES	ST05290-32FM
	7xD	223.9	264.1	267.7	324.1	60.0	32	1/4 BSPT	YES	ST07290-32FM
<b>i</b>	1.5xD	1.891	3.328	3.625	5.766	2.281	1-1/4	1/4 NPT	YES	ST01290-125F
	3xD	3.781	5.375	5.516	7.656	2.281	1-1/4	1/4 NPT	YES	ST03290-125F
	5xD	6.297	7.906	8.047	10.188	2.281	1-1/4	1/4 NPT	YES	ST05290-125F
	7xD	8.813	10.422	10.563	12.703	2.281	1-1/4	1/4 NPT	YES	ST07290-125F

Connection Accessories

					Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

32

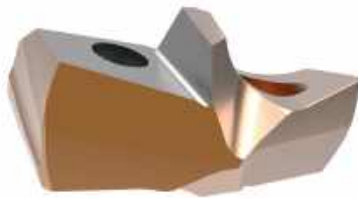
 DRILLING | Structural Steel Solutions | GEN3SYS® XT Pro and GEN3SYS® XT Replaceable Insert Drills

## GEN3SYS® XT Pro / GEN3SYS® XT Structural Steel Drilling System

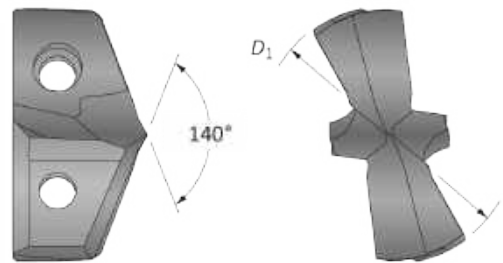
32 Series | Diameter Range: 32.00 mm - 35.00 mm (1.2598" - 1.3780")





GEN3SYS® XT Pro



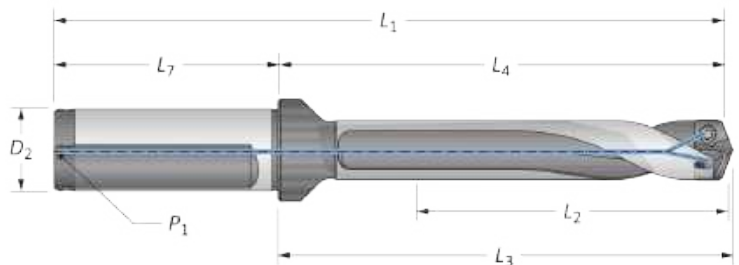
GEN3SYS® XT



Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	GEN3SYS® XT Pro Part No.	GEN3SYS® XT Part No.
32.00	1.2598	–	XTST32-32.00	7C232P-32ST
33.00	1.2992	–	XTST32-33.00	7C232P-33ST
33.34	1.3126	1-5/16	XTST32-33.34	7C232P-0110ST
34.00	1.3386	–	XTST32-34.00	–
34.93	1.3752	1-3/8	XTST32-34.93	7C232P-0112ST



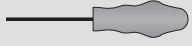






Holders


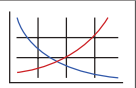

Length	Body				Shank				Flat	Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$			
1.5xD	52.5	105.2	109.5	165.2	60.0	32	1/4 BSPT	YES	ST01320-32FM	
1.5xD	52.5	105.2	109.5	173.5	70.0	40	1/4 BSPT	YES	ST01320-40FM	
3xD	105.0	157.7	162.0	217.7	60.0	32	1/4 BSPT	YES	ST03320-32FM	
3xD	105.0	157.7	162.0	227.7	70.0	40	1/4 BSPT	YES	ST03320-40FM	
5xD	175.0	227.7	232.0	287.7	60.0	32	1/4 BSPT	YES	ST05320-32FM	
5xD	175.0	227.7	232.0	297.7	70.0	40	1/4 BSPT	YES	ST05320-40FM	
7xD	244.9	297.7	302.2	357.7	60.0	32	1/4 BSPT	YES	ST07320-32FM	
7xD	244.9	297.7	302.0	367.7	70.0	40	1/4 BSPT	YES	ST07320-40FM	
1.5xD	2.078	4.156	4.313	6.828	2.688	1-1/2	1/4 NPT	YES	ST01320-150F	
3xD	4.141	6.219	6.375	8.891	2.688	1-1/2	1/4 NPT	YES	ST03320-150F	
5xD	6.922	8.969	9.125	11.656	2.688	1-1/2	1/4 NPT	YES	ST05320-150F	
7xD	9.641	11.719	11.891	14.406	2.688	1-1/2	1/4 NPT	YES	ST07320-150F	

Connection Accessories

					Admissible Tightening Torque*
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength.

A91: 66 - 67      A91: 24 - 25

 Ⓜ = Metric (mm)  
 ⓘ = Imperial (in)

Inserts sold in multiples of 1. | Screws sold in multiples of 10.

**NOTICE:** Structural steel GEN3SYS holders are specifically designed to be used only with GEN3SYS XT Pro and GEN3SYS XT structural steel geometry inserts. Using other GEN3SYS XT or XT Pro insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

A91: 38

[www.alliedmachine.com](http://www.alliedmachine.com) | +44 (0) 1384 400 900 | [enquiries.eu@alliedmachine.com](mailto:enquiries.eu@alliedmachine.com)
A  
DRILLINGB  
BORINGC  
REAMINGD  
BURNISHINGE  
THREADINGX  
SPECIALS





## 4TEX® Drill Safety Information



### Mechanical / Physical Hazards

Operating cutting tools may present both mechanical and physical hazards. These hazards can result in serious injury to workers or those near machines and damage to machines and the cutting tools. Cutting tools and/or assemblies may break or come loose when in operation causing projectile metal fragments. Metal chips produced by cutting tools have sharp edges and may be very hot. To minimise the risk of mechanical or physical hazards:

- Always secure all components of the cutting tool assembly before operating.
- Wear cut-resistant gloves when handling cutting tool components and assemblies.
- Do not touch metal chips produced by the cutting tools with your hands.
- Always wear appropriate personal protective equipment including safety goggles or glasses with side shields.
- Immediately discontinue use of damaged cutting tools.
- To avoid machine tool damage, make sure the machine has adequate power and torque for the cutting tool when operating. See catalogue for power and torque requirements.
- Operating long cutting tools at high spindle speeds can result in a high risk of tool failure and serious injury.

### Dust and Fume Hazards

Grinding, welding, cutting or burning hard metals such as high-speed steel, cobalt or carbides produces hazardous dust and/or fumes. Continued long-term exposure to hazardous dust and fumes can cause serious health issues. To minimise the risk of dust and fume hazards:

- Do not regrind or sharpen cutting tools without using adequate ventilation.
- Use appropriate personal protective equipment such as approved respirator to avoid inhalation, swallowing, or skin contact with the hazardous dust and/or fumes.
- Do not eat, drink, or smoke in the machine operation area. Always wash skin prior to eating, drinking, or smoking to avoid hazardous ingestion.

### Sensitising Hazards

Components of an assembled cutting tool are made from a variety of metal elements that may cause allergic skin reactions with prolonged skin contact. To minimise the risk of allergic skin reactions:

- Avoid skin contact with cutting tools.
- Wear appropriate gloves and protective clothing.
- Wash skin and launder clothing after handling cutting tools to reduce the risk of skin allergies.

### Preventive Safety Measure Applicable to all Hazards

- Prior to using cutting tools, always read Allied Machine's Safety Data Sheets, product catalogue, and product labels for additional warnings for the Allied Machine product being used.
- For machining safety, only operate equipment when all necessary guards, interlocks and other safety devices are in place and functional. Use all appropriate safety guards or machine encapsulations to securely collect particles such as chips or cutting elements that may become projectiles.

#### Through Hole

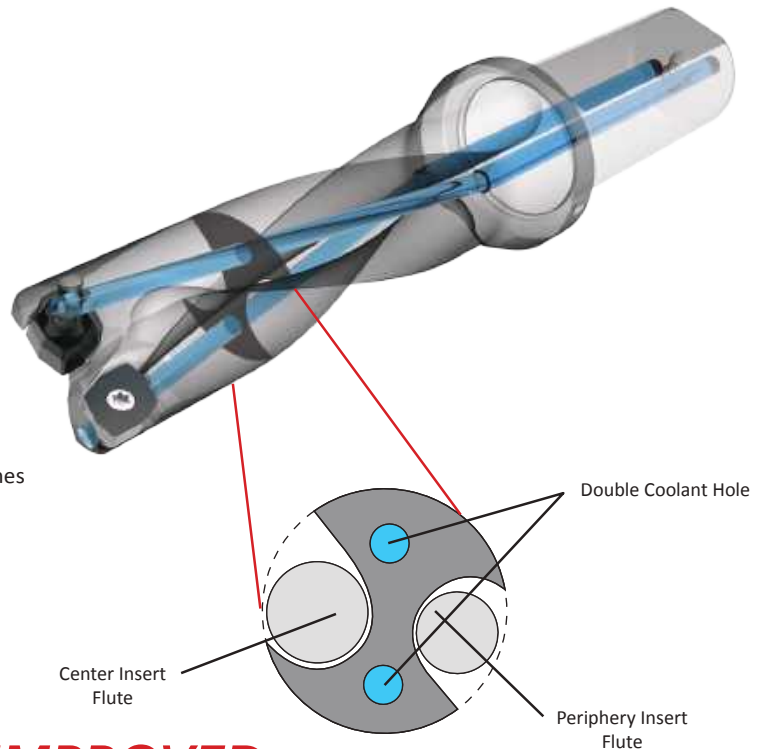
- With through holes, a **sharp-edged disk** is created as tool breakout occurs.
  - ▲ Proper personal protective equipment must be used to prevent injury (e.g. wear cut-resistant gloves).



4TEX® Drilling System

## 4TEX Drill *Advantages*

- ✓ **Superior chip evacuation**  
provided by the two twisted coolant holes
- ✓ **Improved hole size**  
from the increased holder rigidity
- ✓ **Longer tool life**  
provided by the four-sided insert design
- ✓ **Optimal chip formation**  
with ISO-specific insert geometry/coating combinations
- ✓ **Competitive cycle times**  
due to single effective cutting when using light duty machines



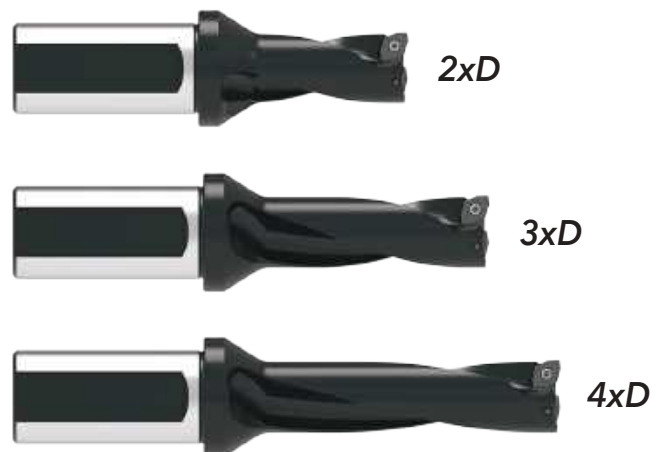
## DESIGNED TO GIVE YOU *IMPROVED* HOLE SIZE AND STRAIGHTNESS

- The two twisted coolant holes allow the core to remain intact, making the core thicker and stronger for improved hole straightness even in uneven surfaces.
- The enlarged dual coolant outlets increase the coolant volume, which improves the chip evacuation resulting in improved hole size.
- The flute space of the internal cutting edge side (where chips get stuck most often) is 1.6x larger than typical IC drills, helping to mitigate catastrophic failures and improves hole sizes.

### *LONGER* TOOL LIFE



### AVAILABLE *LENGTHS*

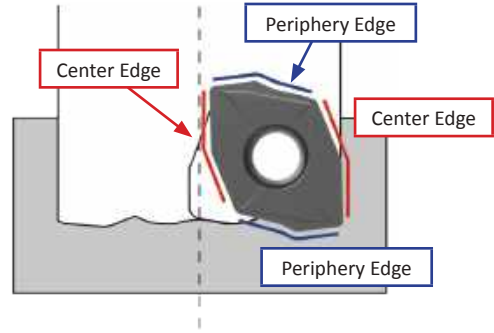


A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

Insert Information

# 4 CUTTING EDGES

- Each insert has two inner cutting edges and two outer cutting edges.
- Economical solution that increases tool life because of the ability to rotate the inserts.
- Available in ISO material-specific geometry/coating combinations.



Periphery Insert



Periphery edge chip formation:



Center Insert



Center edge chip formation:






ISO Material	Geometry	Coating	Description
<b>P</b>	General Rake	AM480	A general purpose geometry that provides excellent chip formation in most steels including free-machining, medium- and high-carbon steels. A P30 carbide substrate for improved toughness and AM480 coating, a proprietary wear resistant multilayer PVD coating to improve tool life.
<b>S M</b>	High Rake	AM485	A higher rake geometry that provides excellent chip formation in both stainless steels and high-temperature alloys. A tough M25 carbide substrate coated with AM485, a high heat resistance proprietary multilayer PVD coating.
<b>H</b>	Low Rake	AM480	A lower rake geometry to improve edge strength in both hardened tool steels and high-strength alloys. With a P30 carbide substrate for improved toughness and coated with AM480, a proprietary multilayer PVD coating to improve resistance against tool wear.
<b>K</b>	General Rake	AM480	With a general purpose geometry, the K inserts can be used in grey cast irons as well as ductile irons. A high wear-resistant K10 carbide substrate to improve tool life and coated with AM480, a proprietary multilayer PVD coating to improve resistance against tool wear.
<b>N</b>	High Rake	TiCN	A higher rake cutting geometry provides excellent chip formation in nonferrous materials. An M15/K15 carbide substrate paired with TiCN coating for improved lubricity to resist built-up material, increasing tool life and maintaining chip formation.

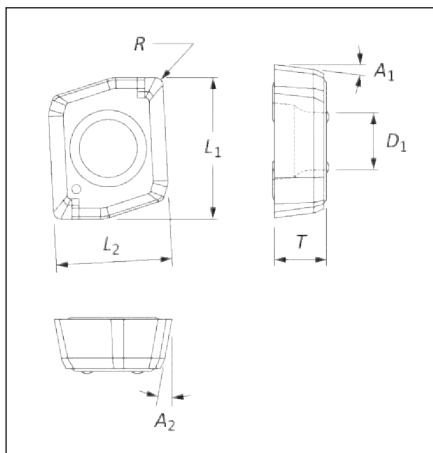
A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS



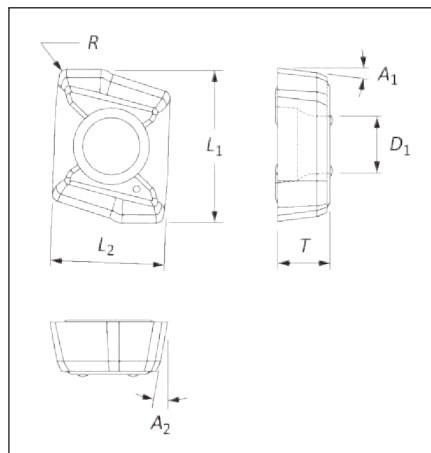
## Insert Information

Series	Insert Prefix	Dimension (mm)					Angle		Shape
		$L_1$	$L_2$	$T$	$D_1$	$R$	$A_1$	$A_2$	
03	4T-030203C-x	5.60	4.80	2.30	2.40	0.30	7°	10°	 Style 1
	4T-030203P-x	6.38	4.77	2.30	2.40	0.30	7°	10°	 Style 2
04	4T-040203-x	6.21	5.06	2.60	2.45	0.30	13°	10°	 Style 3
05	4T-05T203-x	7.26	5.48	2.76	2.55	0.30	13°	7°	
06	4T-06T204-x	8.59	6.44	2.89	2.79	0.40	13°	7°	
07	4T-070305-x	10.21	8.02	3.24	3.00	0.50	13°	7°	
09	4T-09T306-x	12.18	9.55	4.03	3.64	0.60	13°	7°	
11	4T-11T306-x	14.50	11.61	4.06	4.62	0.60	13°	7°	
14	4T-140408-x	17.99	14.40	4.88	5.76	0.80	13°	7°	

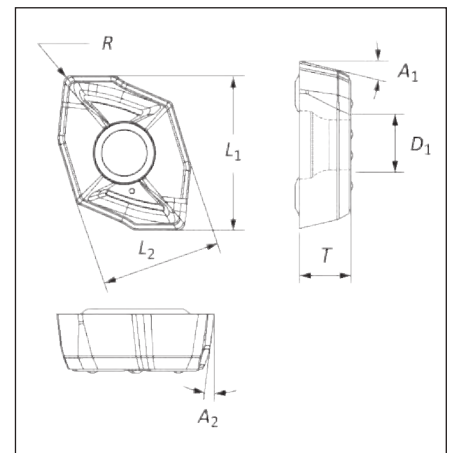
Style 1



Style 2



Style 3



**4TEX® Drill Interrupted Cuts**

**(DON'T) PARDON THE INTERRUPTION**

The 4TEX drill is the premium solution when the cut is interrupted. The indexable carbide insert design provides multiple points of stability, so the entire cutting edge does not require engagement while still providing the hole quality required.



**QUICK TROUBLESHOOTING**

	<p><b>Starting on Angled Surfaces</b></p> <ul style="list-style-type: none"> <li>• Reduce entry feed by 20 - 50%.</li> <li>• Use lower rake geometry if insert chipping occurs.</li> </ul>
	<p><b>Angled Bore Exit</b></p> <ul style="list-style-type: none"> <li>• Reduce entry feed by 50% on breakout.</li> <li>• Use tough insert and stable corner radius.</li> </ul>
	<p><b>Starting on Convex Surfaces</b></p> <ul style="list-style-type: none"> <li>• Reduce entry feed by 50%.</li> <li>• Use lower rake geometry if insert chipping occurs.</li> </ul>
	<p><b>Drilling Through a Cross Hole</b></p> <ul style="list-style-type: none"> <li>• Reduce feed rate by 50% if necessary.</li> <li>• Use good coolant flow and monitor chip packing.</li> <li>• Use lower rake geometry if insert chipping occurs.</li> </ul>
	<p><b>Chain Drilling</b></p> <ul style="list-style-type: none"> <li>• Use good coolant flow.</li> <li>• Reduce feed rate by 50% for interrupted cut.</li> <li>• Use lower rake geometry if insert chipping occurs.</li> </ul>

**THE PROOF IS IN THE CHIPS**

<p>COMPETITOR</p>	<p>4TEX® Drill</p>
<b>S</b>	
<p>COMPETITOR</p>	<p>4TEX® Drill</p>
<b>P</b>	
<p>COMPETITOR</p>	<p>4TEX® Drill</p>
<b>M</b>	

A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

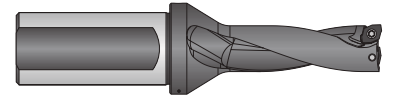




## Product Nomenclature

### 4TEX Drill Holders

<b>D4</b>	<b>03</b>	<b>1200</b>	<b>M</b>	-	<b>20</b>	<b>FM</b>
1	2	3*	4		5	6



1. Length-to-Diameter-Ratio
<b>D2</b> = 2xD
<b>D3</b> = 3xD
<b>D4</b> = 4xD

2. Series	
<b>03</b> = 03 series	<b>07</b> = 07 series
<b>04</b> = 04 series	<b>09</b> = 09 series
<b>05</b> = 05 series	<b>11</b> = 11 series
<b>06</b> = 06 series	<b>14</b> = 14 series

3. Diameter*
<b>1200</b> = 12 mm
<b>0750</b> = 0.0750"

4. Diameter Style
<b>M</b> = Metric
<b>I</b> = Imperial

5. Shank Diameter	
Metric	Imperial
<b>20</b> = 20 mm	<b>075</b> = 0.750"
<b>25</b> = 25 mm	<b>100</b> = 1.000"
<b>32</b> = 32 mm	<b>125</b> = 1.250"
<b>40</b> = 40 mm	<b>150</b> = 1.500"

6. Shank Style
<b>FM</b> = Metric flanged shank
<b>F</b> = Imperial flanged shank

**\*Ordering Nonstocked Diameters:**

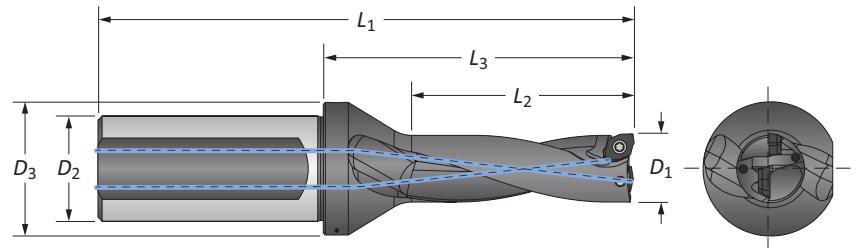
Nonstocked diameters are available upon request. Please refer to price list for applicable process fees.

**Ordering example:**

Metric: 03 Series (12.65 mm) = D2031265M-20FM  
 Imperial: 03 Series (Ø 0.480") = D2030480I-075F

**Reference Key**

Symbol	Attribute
<b>D<sub>1</sub></b>	Drill diameter
<b>D<sub>2</sub></b>	Shank diameter
<b>D<sub>3</sub></b>	Flange diameter
<b>L<sub>1</sub></b>	Assembled overall length
<b>L<sub>2</sub></b>	Drill depth
<b>L<sub>3</sub></b>	Reference length



03

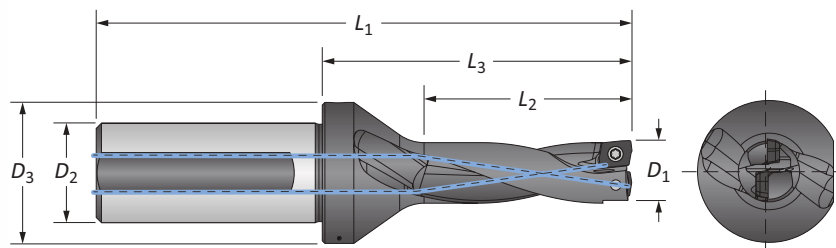
 DRILLING | Structural Steel Solutions | 4TEX® Indexable Drill

**4TEX® Drill Holders | Metric Shank | Imperial Shank**

03 Series | Diameter Range: 12.00 mm - 13.00 mm (0.472" - 0.512")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.





Metric Shank

Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	12.00	0.472	–	24.00	45.40	88.40	20.00	27.00	0.50	<b>D2031200M-20FM</b>
	13.00	0.512	–	26.00	47.40	90.40	20.00	27.00	0.30	<b>D2031300M-20FM</b>
3xD	12.00	0.472	–	36.00	57.40	100.40	20.00	27.00	0.50	<b>D3031200M-20FM</b>
	13.00	0.512	–	39.00	60.40	103.40	20.00	27.00	0.30	<b>D3031300M-20FM</b>
4xD	12.00	0.472	–	48.00	69.40	112.40	20.00	27.00	0.50	<b>D4031200M-20FM</b>
	13.00	0.512	–	52.00	73.40	116.40	20.00	27.00	0.30	<b>D4031300M-20FM</b>

Imperial Shank

Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	12.00	0.472	–	0.945	1.787	3.480	0.750	1.063	0.020	<b>D2031200M-075F</b>
	13.00	0.512	–	1.024	1.866	3.559	0.750	1.063	0.012	<b>D2031300M-075F</b>
3xD	12.00	0.472	–	1.417	2.260	3.953	0.750	1.063	0.020	<b>D3031200M-075F</b>
	13.00	0.512	–	1.535	2.378	4.071	0.750	1.063	0.012	<b>D3031300M-075F</b>
4xD	12.00	0.472	–	1.890	2.732	4.425	0.750	1.063	0.020	<b>D4031200M-075F</b>
	13.00	0.512	–	2.047	2.890	4.583	0.750	1.063	0.012	<b>D4031300M-075F</b>

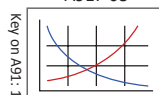
IC Inserts

ISO Material	Style	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	Center	<b>4T-030203C-P</b>	7241-T6-1	8T-6	0.5 N-m (4.4 in-lbs)
	Periphery	<b>4T-030203P-P</b>			
S M	Center	<b>4T-030203C-M</b>			
	Periphery	<b>4T-030203P-M</b>			
H	Center	<b>4T-030203C-H</b>			
	Periphery	<b>4T-030203P-H</b>			
K	Center	<b>4T-030203C-K</b>			
	Periphery	<b>4T-030203P-K</b>			
N	Center	<b>4T-030203C-N</b>			
	Periphery	<b>4T-030203P-N</b>			

Expected Hole Tolerances

Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010

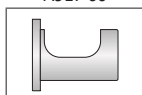
A91: 68



A91: 61 - 63



A91: 60



Key on A91: 1

Ⓜ = Metric (mm)

Ⓢ = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

A91: 46

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

A DRILLING

B BORING

C REAMING

D BURNISHING

E THREADING

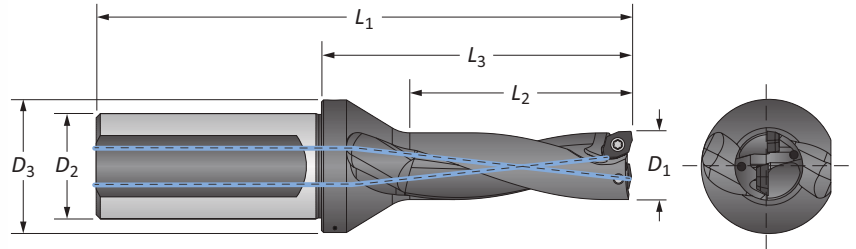
X SPECIALS



**4TEX® Drill Holders | Metric Shank | Imperial Shank**

04 Series | Diameter Range: 14.00 mm - 15.00 mm (0.551" - 0.591")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



**Metric Shank**

Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	14.00	0.551	–	28.00	49.40	92.40	20.00	27.00	0.40	<b>D2041400M-20FM</b>
	14.29	0.563	9/16	28.55	49.40	92.40	20.00	27.00	0.30	<b>D2040562I-20FM</b>
	15.00	0.591	–	30.00	51.40	94.40	20.00	27.00	0.20	<b>D2041500M-20FM</b>
3xD	14.00	0.551	–	42.00	63.40	106.40	20.00	27.00	0.40	<b>D3041400M-20FM</b>
	14.29	0.563	9/16	42.82	63.40	106.40	20.00	27.00	0.30	<b>D3040562I-20FM</b>
	15.00	0.591	–	45.00	66.40	109.40	20.00	27.00	0.20	<b>D3041500M-20FM</b>
4xD	14.00	0.551	–	56.00	77.40	120.40	20.00	27.00	0.40	<b>D4041400M-20FM</b>
	14.29	0.563	9/16	57.10	77.40	120.40	20.00	27.00	0.30	<b>D4040562I-20FM</b>
	15.00	0.591	–	60.00	81.40	124.40	20.00	27.00	0.20	<b>D4041500M-20FM</b>

**Imperial Shank**

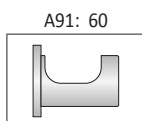
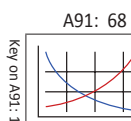
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	14.00	0.551	–	1.102	1.945	3.638	0.750	1.063	0.016	<b>D2041400M-075F</b>
	14.29	0.563	9/16	1.124	1.945	3.638	0.750	1.063	0.013	<b>D2040562I-075F</b>
	15.00	0.591	–	1.181	2.024	3.717	0.750	1.063	0.008	<b>D2041500M-075F</b>
3xD	14.00	0.551	–	1.654	2.496	4.189	0.750	1.063	0.016	<b>D3041400M-075F</b>
	14.29	0.563	9/16	1.686	2.496	4.189	0.750	1.063	0.013	<b>D3040562I-075F</b>
	15.00	0.591	–	1.772	2.614	4.307	0.750	1.063	0.008	<b>D3041500M-075F</b>
4xD	14.00	0.551	–	2.205	3.047	4.740	0.750	1.063	0.016	<b>D4041400M-075F</b>
	14.29	0.563	9/16	2.248	3.047	4.740	0.750	1.063	0.013	<b>D4040562I-075F</b>
	15.00	0.591	–	2.362	3.205	4.898	0.750	1.063	0.008	<b>D4041500M-075F</b>

**IC Inserts**

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
<b>P</b>	<b>4T-040203-P</b>	7241-T6-1	8T-6	0.5 N-m (4.4 in-lbs)
<b>S</b> <b>M</b>	<b>4T-040203-M</b>			
<b>H</b>	<b>4T-040203-H</b>			
<b>K</b>	<b>4T-040203-K</b>			
<b>N</b>	<b>4T-040203-N</b>			

**Expected Hole Tolerances**

Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010



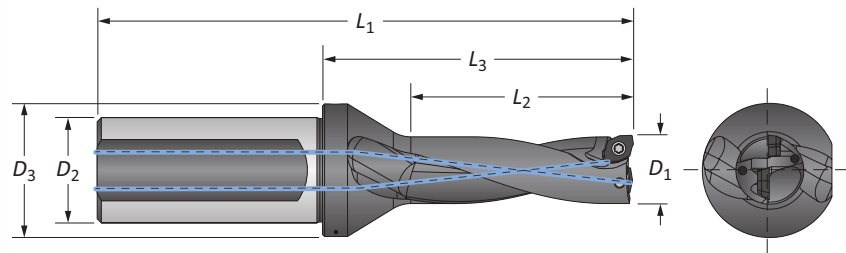
**m** = Metric (mm)  
**i** = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

## 4TEX® Drill Holders | Metric Shank

05 Series | Diameter Range: 15.88 mm - 18.00 mm (0.625" - 0.709")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Metric Shank

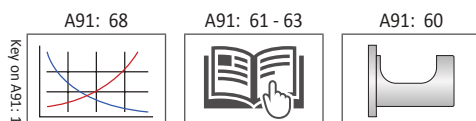
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	15.88	0.625	5/8	31.75	54.50	108.50	25.00	32.00	0.70	D2050625I-25FM
	16.00	0.630	-	32.00	55.50	109.50	25.00	32.00	0.70	D2051600M-25FM
	17.00	0.669	-	34.00	57.50	111.50	25.00	32.00	0.40	D2051700M-25FM
	17.46	0.687	11/16	34.90	57.50	111.50	25.00	32.00	0.30	D2050687I-25FM
	18.00	0.709	-	36.00	59.50	113.50	25.00	32.00	0.20	D2051800M-25FM
3xD	15.88	0.625	5/8	47.63	70.00	124.00	25.00	32.00	0.70	D3050625I-25FM
	16.00	0.630	-	48.00	71.50	125.50	25.00	32.00	0.70	D3051600M-25FM
	17.00	0.669	-	51.00	74.50	128.50	25.00	32.00	0.40	D3051700M-25FM
	17.46	0.687	11/16	52.35	74.50	128.50	25.00	32.00	0.30	D3050687I-25FM
	18.00	0.709	-	54.00	77.50	131.50	25.00	32.00	0.20	D3051800M-25FM
4xD	15.88	0.625	5/8	63.50	85.50	139.50	25.00	32.00	0.70	D4050625I-25FM
	16.00	0.630	-	64.00	87.50	141.50	25.00	32.00	0.70	D4051600M-25FM
	17.00	0.669	-	68.00	91.50	145.50	25.00	32.00	0.40	D4051700M-25FM
	17.46	0.687	11/16	69.80	91.50	145.50	25.00	32.00	0.30	D4050687I-25FM
	18.00	0.709	-	72.00	95.50	149.50	25.00	32.00	0.20	D4051800M-25FM

### IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-05T203-P	7243-T6-1	8T-6	0.5 N-m (4.4 in-lbs)
S	4T-05T203-M			
H	4T-05T203-H			
K	4T-05T203-K			
N	4T-05T203-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010

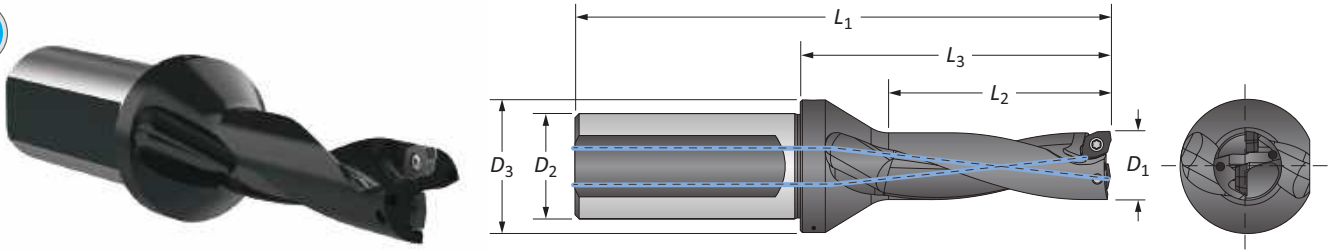




## 4TEX® Drill Holders | Imperial Shank

05 Series | Diameter Range: 15.88 mm - 18.00 mm (0.625" - 0.709")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Imperial Shank

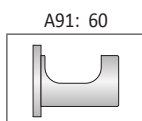
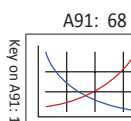
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	15.88	0.625	5/8	1.250	2.146	4.272	1.000	1.260	0.029	D2050625I-100F
	16.00	0.630	–	1.260	2.185	4.311	1.000	1.260	0.028	D2051600M-100F
	17.00	0.669	–	1.339	2.264	4.390	1.000	1.260	0.016	D2051700M-100F
	17.46	0.687	11/16	1.374	2.264	4.390	1.000	1.260	0.012	D2050687I-100F
	18.00	0.709	–	1.417	2.343	4.469	1.000	1.260	0.008	D2051800M-100F
3xD	15.88	0.625	5/8	1.875	2.756	4.882	1.000	1.260	0.029	D3050625I-100F
	16.00	0.630	–	1.890	2.815	4.941	1.000	1.260	0.028	D3051600M-100F
	17.00	0.669	–	2.008	2.933	5.059	1.000	1.260	0.016	D3051700M-100F
	17.46	0.687	11/16	2.061	2.933	5.059	1.000	1.260	0.012	D3050687I-100F
	18.00	0.709	–	2.126	3.051	5.177	1.000	1.260	0.008	D3051800M-100F
4xD	15.88	0.625	5/8	2.500	3.366	5.492	1.000	1.260	0.029	D4050625I-100F
	16.00	0.630	–	2.520	3.445	5.571	1.000	1.260	0.028	D4051600M-100F
	17.00	0.669	–	2.677	3.602	5.728	1.000	1.260	0.016	D4051700M-100F
	17.46	0.687	11/16	2.748	3.602	5.728	1.000	1.260	0.012	D4050687I-100F
	18.00	0.709	–	2.835	3.760	5.886	1.000	1.260	0.008	D4051800M-100F

### IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-05T203-P	7243-T6-1	8T-6	0.5 N-m (4.4 in-lbs)
S	4T-05T203-M			
H	4T-05T203-H			
K	4T-05T203-K			
N	4T-05T203-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010



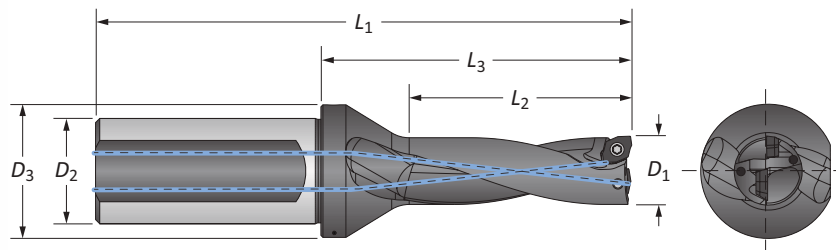
m = Metric (mm)  
i = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

## 4TEX® Drill Holders | Metric Shank

06 Series | Diameter Range: 19.00 mm - 21.00 mm (0.748" - 0.827")\*



\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Metric Shank

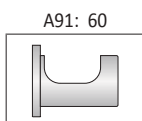
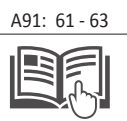
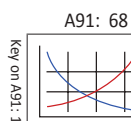
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	19.00	0.748	–	38.00	59.40	113.40	25.00	32.00	0.80	D2061900M-25FM
	20.00	0.787	–	40.00	61.40	115.40	25.00	32.00	0.50	D2062000M-25FM
	20.64	0.813	13/16	41.25	62.40	116.40	25.00	32.00	0.40	D2060812I-25FM
	21.00	0.827	–	42.00	63.40	117.40	25.00	32.00	0.30	D2062100M-25FM
3xD	19.00	0.748	–	57.00	78.40	132.40	25.00	32.00	0.80	D3061900M-25FM
	20.00	0.787	–	60.00	81.40	135.40	25.00	32.00	0.50	D3062000M-25FM
	20.64	0.813	13/16	61.87	82.90	136.90	25.00	32.00	0.40	D3060812I-25FM
	21.00	0.827	–	63.00	84.40	138.40	25.00	32.00	0.30	D3062100M-25FM
4xD	19.00	0.748	–	76.00	97.40	151.40	25.00	32.00	0.80	D4061900M-25FM
	20.00	0.787	–	80.00	101.40	155.40	25.00	32.00	0.50	D4062000M-25FM
	20.64	0.813	13/16	82.49	103.40	157.40	25.00	32.00	0.40	D4060812I-25FM
	21.00	0.827	–	84.00	105.40	159.40	25.00	32.00	0.30	D4062100M-25FM

### IC Inserts

ISO Material	Part No.	 Insert Screw	 Torx® Driver	Admissible Tightening Torque
P	4T-06T204-P	72251-T7-1	8T-7	0.8 N-m (7.1 in-lbs)
S	4T-06T204-M			
H	4T-06T204-H			
K	4T-06T204-K			
N	4T-06T204-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010



Ⓜ = Metric (mm)  
Ⓢ = Imperial (in)

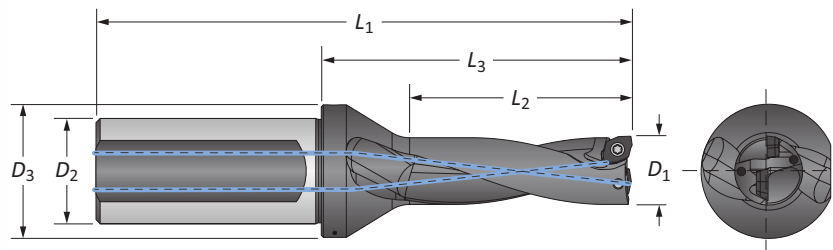
IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.



## 4TEX® Drill Holders | Imperial Shank

06 Series | Diameter Range: 19.00 mm - 21.00 mm (0.748" - 0.827")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Imperial Shank

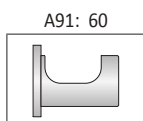
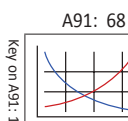
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank			Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>	Max Offset	
2xD	19.00	0.748	–	1.496	2.339	4.465	1.000	1.260	0.031	<b>D2061900M-100F</b>
	20.00	0.787	–	1.575	2.417	4.543	1.000	1.260	0.020	<b>D2062000M-100F</b>
	20.64	0.813	13/16	1.624	2.457	4.583	1.000	1.260	0.015	<b>D2060812I-100F</b>
	21.00	0.827	–	1.654	2.496	4.622	1.000	1.260	0.012	<b>D2062100M-100F</b>
3xD	19.00	0.748	–	2.244	3.087	5.213	1.000	1.260	0.031	<b>D3061900M-100F</b>
	20.00	0.787	–	2.362	3.205	5.331	1.000	1.260	0.020	<b>D3062000M-100F</b>
	20.64	0.813	13/16	2.436	3.264	5.390	1.000	1.260	0.015	<b>D3060812I-100F</b>
	21.00	0.827	–	2.480	3.323	5.449	1.000	1.260	0.012	<b>D3062100M-100F</b>
4xD	19.00	0.748	–	2.992	3.835	5.961	1.000	1.260	0.031	<b>D4061900M-100F</b>
	20.00	0.787	–	3.150	3.992	6.118	1.000	1.260	0.020	<b>D4062000M-100F</b>
	20.64	0.813	13/16	3.248	4.071	6.197	1.000	1.260	0.015	<b>D4060812I-100F</b>
	21.00	0.827	–	3.307	4.150	6.276	1.000	1.260	0.012	<b>D4062100M-100F</b>

### IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-06T204-P	72251-T7-1	8T-7	0.8 N-m (7.1 in-lbs)
S M	4T-06T204-M			
H	4T-06T204-H			
K	4T-06T204-K			
N	4T-06T204-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010



m = Metric (mm)  
i = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

07

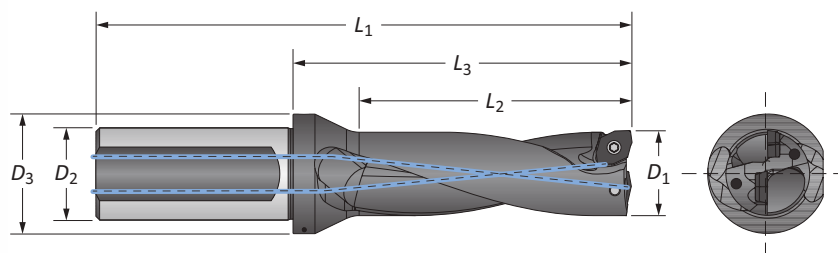
 DRILLING | Structural Steel Solutions | 4TEX® Indexable Drill

## 4TEX® Drill Holders | Metric Shank

07 Series | Diameter Range: 22.00 mm - 26.00 mm (0.866" - 1.024")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.





Metric Shank

Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	22.00	0.866	–	44.00	64.90	118.90	25.00	33.00	1.20	D2072200M-25FM
	22.22	0.875	7/8	44.45	64.90	118.90	25.00	33.00	1.10	D2070875I-25FM
	23.00	0.906	–	46.00	66.90	120.90	25.00	33.00	0.90	D2072300M-25FM
	23.81	0.937	15/16	47.60	67.90	121.90	25.00	33.00	7.40	D2070937I-25FM
	24.00	0.945	–	48.00	68.90	122.90	25.00	33.00	0.70	D2072400M-25FM
	25.40	1.000	–	50.80	70.90	124.90	25.00	33.00	0.30	D2071000I-25FM
3xD	26.00	1.024	–	52.00	72.90	126.90	25.00	33.00	0.20	D2072600M-25FM
	22.00	0.866	–	66.00	86.90	140.90	25.00	33.00	1.20	D3072200M-25FM
	22.22	0.875	7/8	66.68	86.90	140.90	25.00	33.00	1.10	D3070875I-25FM
	23.00	0.906	–	69.00	89.90	143.90	25.00	33.00	0.90	D3072300M-25FM
	23.81	0.937	15/16	71.40	91.40	145.40	25.00	33.00	7.40	D3070937I-25FM
	24.00	0.945	–	72.00	92.90	146.90	25.00	33.00	0.70	D3072400M-25FM
4xD	25.40	1.000	–	76.20	95.90	149.90	25.00	33.00	0.30	D3071000I-25FM
	26.00	1.024	–	78.00	99.00	153.00	25.00	33.00	0.20	D3072600M-25FM
	22.00	0.866	–	88.00	109.00	163.00	25.00	33.00	1.20	D4072200M-25FM
	22.22	0.875	7/8	88.90	108.90	162.90	25.00	33.00	1.10	D4070875I-25FM
	23.00	0.906	–	92.00	113.00	167.00	25.00	33.00	0.90	D4072300M-25FM
	23.81	0.937	15/16	95.20	114.90	168.90	25.00	33.00	7.40	D4070937I-25FM
24.00	0.945	–	96.00	117.00	171.00	25.00	33.00	0.70	D4072400M-25FM	
25.40	1.000	–	101.60	120.90	174.90	25.00	33.00	0.30	D4071000I-25FM	
26.00	1.024	–	104.00	125.00	179.00	25.00	33.00	0.20	D4072600M-25FM	

IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-070305-P	72568-T8-1	8T-8	1.2 N-m (10.6 in-lbs)
S	4T-070305-M			
H	4T-070305-H			
K	4T-070305-K			
N	4T-070305-N			

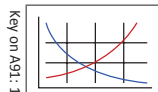
Expected Hole Tolerances

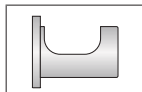
Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010

A91: 68

A91: 61 - 63

A91: 60





Ⓜ = Metric (mm)

Ⓢ = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

A91: 52

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

X

SPECIALS

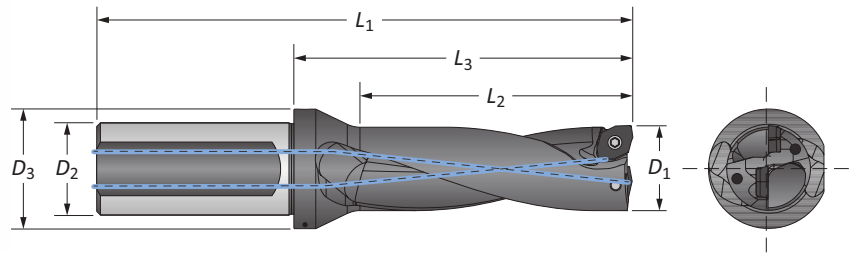




## 4TEX® Drill Holders | Imperial Shank

07 Series | Diameter Range: 22.00 mm - 26.00 mm (0.866" - 1.024")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Imperial Shank

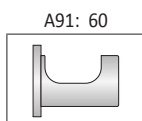
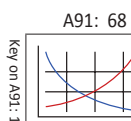
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	22.00	0.866	–	1.732	2.555	4.681	1.000	1.299	0.047	D2072200M-100F
	22.22	0.875	7/8	1.750	2.555	4.681	1.000	1.299	0.043	D2070875I-100F
	23.00	0.906	–	1.811	2.634	4.760	1.000	1.299	0.035	D2072300M-100F
	23.81	0.937	15/16	1.874	2.673	4.799	1.000	1.299	0.292	D2070937I-100F
	24.00	0.945	–	1.890	2.713	4.839	1.000	1.299	0.028	D2072400M-100F
	25.40	1.000	–	2.000	2.791	4.917	1.000	1.299	0.013	D2071000I-100F
3xD	26.00	1.024	–	2.047	2.870	4.996	1.000	1.299	0.008	D2072600M-100F
	22.00	0.866	–	2.598	3.421	5.547	1.000	1.299	0.047	D3072200M-100F
	22.22	0.875	7/8	2.625	3.421	5.547	1.000	1.299	0.043	D3070875I-100F
	23.00	0.906	–	2.717	3.539	5.665	1.000	1.299	0.035	D3072300M-100F
	23.81	0.937	15/16	2.811	3.598	5.724	1.000	1.299	0.292	D3070937I-100F
	24.00	0.945	–	2.835	3.657	5.783	1.000	1.299	0.028	D3072400M-100F
4xD	25.40	1.000	–	3.000	3.776	5.902	1.000	1.299	0.013	D3071000I-100F
	26.00	1.024	–	3.071	3.894	6.020	1.000	1.299	0.008	D3072600M-100F
	22.00	0.866	–	3.465	4.287	6.413	1.000	1.299	0.047	D4072200M-100F
	22.22	0.875	7/8	3.500	4.287	6.413	1.000	1.299	0.043	D4070875I-100F
	23.00	0.906	–	3.622	4.445	6.571	1.000	1.299	0.035	D4072300M-100F
	23.81	0.937	15/16	3.748	4.524	6.650	1.000	1.299	0.292	D4070937I-100F
4xD	24.00	0.945	–	3.780	4.602	6.728	1.000	1.299	0.028	D4072400M-100F
	25.40	1.000	–	4.000	4.760	6.886	1.000	1.299	0.013	D4071000I-100F
	26.00	1.024	–	4.094	4.917	7.043	1.000	1.299	0.008	D4072600M-100F

### IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-070305-P	72568-T8-1	8T-8	1.2 N-m (10.6 in-lbs)
S	4T-070305-M			
H	4T-070305-H			
K	4T-070305-K			
N	4T-070305-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.10 / +0.20	-0.004 / +0.008
3xD	-0.10 / +0.20	-0.004 / +0.008
4xD	-0.10 / +0.25	-0.004 / +0.010



m = Metric (mm)  
i = Imperial (in)

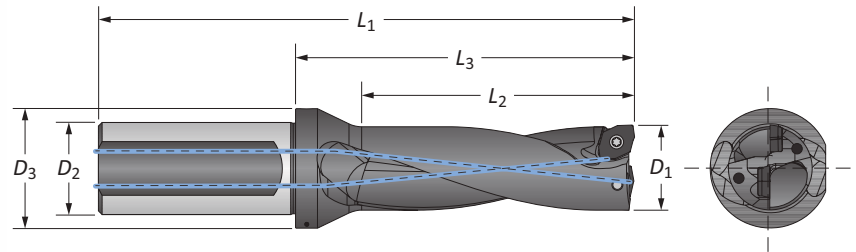
IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.



## 4TEX® Drill Holders | Metric Shank

09 Series | Diameter Range: 27.00 mm - 31.75 mm (1.063" - 1.250")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



## Metric Shank

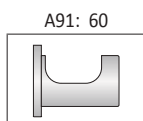
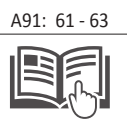
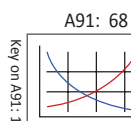
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	27.00	1.063	–	54.00	76.70	135.70	32.00	41.00	1.60	D2092700M-32FM
	28.00	1.102	–	56.00	78.70	137.70	32.00	41.00	1.30	D2092800M-32FM
	28.58	1.125	1-1/8	57.15	79.70	138.70	32.00	41.00	1.20	D2091125I-32FM
	29.00	1.142	–	58.00	80.70	139.70	32.00	41.00	1.10	D2092900M-32FM
	30.00	1.181	–	60.00	82.70	141.70	32.00	43.00	0.80	D2093000M-32FM
	30.15	1.187	1-3/16	60.30	82.70	141.70	32.00	43.00	0.82	D2091187I-32FM
	31.00	1.220	–	62.00	84.70	143.70	32.00	43.00	0.60	D2093100M-32FM
3xD	27.00	1.063	–	81.00	103.70	162.70	32.00	41.00	1.60	D3092700M-32FM
	28.00	1.102	–	84.00	106.70	165.70	32.00	41.00	1.30	D3092800M-32FM
	28.58	1.125	1-1/8	85.73	108.20	167.20	32.00	41.00	1.20	D3091125I-32FM
	29.00	1.142	–	87.00	109.70	168.70	32.00	41.00	1.10	D3092900M-32FM
	30.00	1.181	–	90.00	112.70	171.70	32.00	43.00	0.80	D3093000M-32FM
	30.15	1.187	1-3/16	90.45	112.70	171.70	32.00	43.00	0.82	D3091187I-32FM
	31.00	1.220	–	93.00	115.70	174.70	32.00	43.00	0.60	D3093100M-32FM
4xD	27.00	1.063	–	108.00	130.70	189.70	32.00	41.00	1.60	D4092700M-32FM
	28.00	1.102	–	112.00	134.70	193.70	32.00	41.00	1.30	D4092800M-32FM
	28.58	1.125	1-1/8	114.30	136.70	195.70	32.00	41.00	1.20	D4091125I-32FM
	29.00	1.142	–	116.00	138.70	197.70	32.00	41.00	1.10	D4092900M-32FM
	30.00	1.181	–	120.00	142.70	201.70	32.00	43.00	0.80	D4093000M-32FM
	30.15	1.187	1-3/16	120.60	142.70	201.70	32.00	43.00	0.82	D4091187I-32FM
	31.00	1.220	–	124.00	146.70	205.70	32.00	43.00	0.60	D4093100M-32FM
31.75	1.250	1-1/4	127.00	148.70	207.70	32.00	43.00	0.50	D4091250I-32FM	

## IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-09T306-P	738-T10-1	8T-10	2.0 N-m (17.7 in-lbs)
S	4T-09T306-M			
H	4T-09T306-H			
K	4T-09T306-K			
N	4T-09T306-N			

## Expected Hole Tolerances

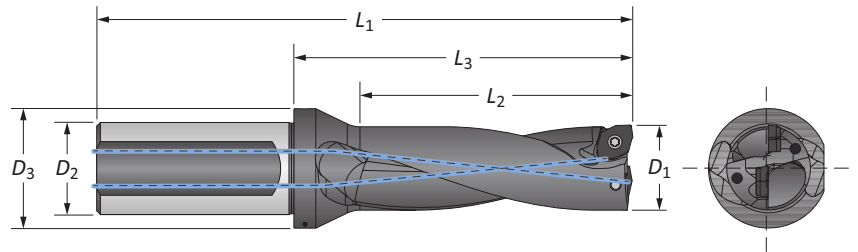
Length	mm	in
2xD	-0.15 / +0.25	-0.006 / +0.010
3xD	-0.15 / +0.25	-0.006 / +0.010
4xD	-0.15 / +0.30	-0.006 / +0.012



## 4TEX® Drill Holders | Imperial Shank

09 Series | Diameter Range: 27.00 mm - 31.75 mm (1.063" - 1.250")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Imperial Shank

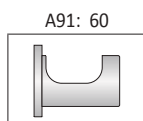
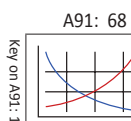
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	27.00	1.063	–	2.126	3.020	5.343	1.250	1.614	0.063	D2092700M-125F
	28.00	1.102	–	2.205	3.098	5.421	1.250	1.614	0.051	D2092800M-125F
	28.58	1.125	1-1/8	2.250	3.138	5.461	1.250	1.614	0.046	D2091125I-125F
	29.00	1.142	–	2.283	3.177	5.500	1.250	1.614	0.043	D2092900M-125F
	30.00	1.181	–	2.362	3.256	5.579	1.250	1.693	0.031	D2093000M-125F
	30.15	1.187	1-3/16	2.374	3.256	5.579	1.250	1.693	0.032	D2091187I-125F
	31.00	1.220	–	2.441	3.335	5.657	1.250	1.693	0.024	D2093100M-125F
31.75	1.250	1-1/4	2.500	3.374	5.697	1.250	1.693	0.019	D2091250I-125F	
3xD	27.00	1.063	–	3.189	4.083	6.406	1.250	1.614	0.063	D3092700M-125F
	28.00	1.102	–	3.307	4.201	6.524	1.250	1.614	0.051	D3092800M-125F
	28.58	1.125	1-1/8	3.375	4.260	6.583	1.250	1.614	0.046	D3091125I-125F
	29.00	1.142	–	3.425	4.319	6.642	1.250	1.614	0.043	D3092900M-125F
	30.00	1.181	–	3.543	4.437	6.760	1.250	1.693	0.031	D3093000M-125F
	30.15	1.187	1-3/16	3.561	4.437	6.760	1.250	1.693	0.032	D3091187I-125F
	31.00	1.220	–	3.661	4.555	6.878	1.250	1.693	0.024	D3093100M-125F
31.75	1.250	1-1/4	3.750	4.614	6.937	1.250	1.693	0.019	D3091250I-125F	
4xD	27.00	1.063	–	4.252	5.146	7.469	1.250	1.614	0.063	D4092700M-125F
	28.00	1.102	–	4.409	5.303	7.626	1.250	1.614	0.051	D4092800M-125F
	28.58	1.125	1-1/8	4.500	5.382	7.705	1.250	1.614	0.046	D4091125I-125F
	29.00	1.142	–	4.567	5.461	7.783	1.250	1.614	0.043	D4092900M-125F
	30.00	1.181	–	4.724	5.618	7.941	1.250	1.693	0.031	D4093000M-125F
	30.15	1.187	1-3/16	4.748	5.618	7.941	1.250	1.693	0.032	D4091187I-125F
	31.00	1.220	–	4.882	5.776	8.098	1.250	1.693	0.024	D4093100M-125F
31.75	1.250	1-1/4	5.000	5.854	8.177	1.250	1.693	0.019	D4091250I-125F	

### IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-09T306-P	738-T10-1	8T-10	2.0 N-m (17.7 in-lbs)
S	4T-09T306-M			
H	4T-09T306-H			
K	4T-09T306-K			
N	4T-09T306-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.15 / +0.25	-0.006 / +0.010
3xD	-0.15 / +0.25	-0.006 / +0.010
4xD	-0.15 / +0.30	-0.006 / +0.012



m = Metric (mm)  
i = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

11

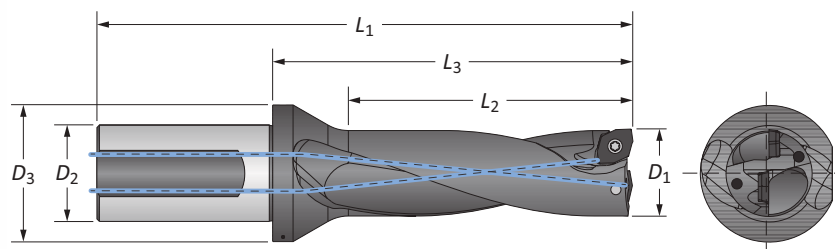
 DRILLING | Structural Steel Solutions | 4TEX® Indexable Drill

## 4TEX® Drill Holders | Metric Shank

11 Series | Diameter Range: 32.00 mm - 38.10 mm (1.260" - 1.500")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.





Metric Shank

Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	32.00	1.260	–	64.00	100.40	169.40	40.00	54.00	2.20	<b>D2113200M-40FM</b>
	33.00	1.299	–	66.00	102.40	171.40	40.00	54.00	1.90	<b>D2113300M-40FM</b>
	33.32	1.312	1-5/16	66.65	102.40	171.40	40.00	54.00	1.84	<b>D2111312I-40FM</b>
	34.00	1.339	–	68.00	104.40	173.40	40.00	54.00	1.70	<b>D2113400M-40FM</b>
	34.92	1.375	1-3/8	69.85	104.40	173.40	40.00	54.00	1.42	<b>D2111375I-40FM</b>
38.10	1.500	1-1/2	76.20	112.40	181.40	40.00	54.00	0.69	<b>D2111500I-40FM</b>	
3xD	32.00	1.260	–	96.00	132.40	201.40	40.00	54.00	2.20	<b>D3113200M-40FM</b>
	33.00	1.299	–	99.00	135.40	204.40	40.00	54.00	1.90	<b>D3113300M-40FM</b>
	33.32	1.312	1-5/16	99.97	135.40	204.40	40.00	54.00	1.84	<b>D3111312I-40FM</b>
	34.00	1.339	–	102.00	138.40	207.40	40.00	54.00	1.70	<b>D3113400M-40FM</b>
	34.92	1.375	1-3/8	104.78	138.40	207.40	40.00	54.00	1.42	<b>D3111375I-40FM</b>
38.10	1.500	1-1/2	114.30	150.40	219.40	40.00	54.00	0.69	<b>D3111500I-40FM</b>	
4xD	32.00	1.260	–	128.00	154.40	223.40	40.00	54.00	2.20	<b>D4113200M-40FM</b>
	33.00	1.299	–	132.00	158.40	227.40	40.00	54.00	1.90	<b>D4113300M-40FM</b>
	33.32	1.312	1-5/16	133.30	158.40	227.40	40.00	54.00	1.84	<b>D4111312I-40FM</b>
	34.00	1.339	–	136.00	162.40	231.40	40.00	54.00	1.70	<b>D4113400M-40FM</b>
	34.92	1.375	1-3/8	139.70	162.40	231.40	40.00	54.00	1.42	<b>D4111375I-40FM</b>
38.10	1.500	1-1/2	152.40	178.40	247.40	40.00	54.00	0.69	<b>D4111500I-40FM</b>	

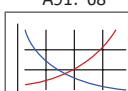
IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
<b>P</b>	<b>4T-11T306-P</b>	7488-T15-1	8T-15	3.5 N-m (30.9 in-lbs)
<b>S</b> <b>M</b>	<b>4T-11T306-M</b>			
<b>H</b>	<b>4T-11T306-H</b>			
<b>K</b>	<b>4T-11T306-K</b>			
<b>N</b>	<b>4T-11T306-N</b>			


Expected Hole Tolerances

Length	mm	in
2xD	-0.15 / +0.25	-0.006 / +0.010
3xD	-0.15 / +0.25	-0.006 / +0.010
4xD	-0.15 / +0.30	-0.006 / +0.012

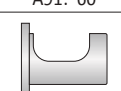
A91: 68



A91: 61 - 63



A91: 60



A91: 56

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

**m** = Metric (mm)  
**i** = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

X

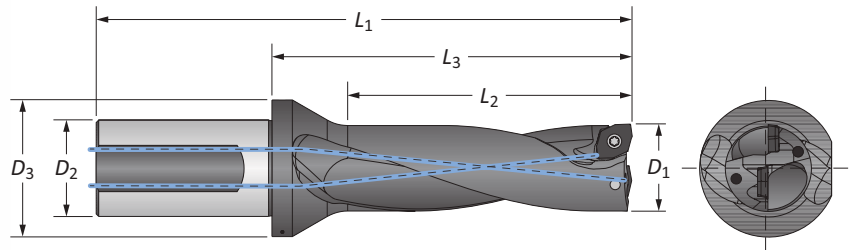
SPECIALS



## 4TEX® Drill Holders | Imperial Shank

11 Series | Diameter Range: 32.00 mm - 38.10 mm (1.260" - 1.500")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Imperial Shank

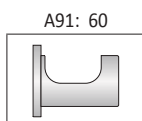
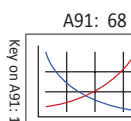
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	32.00	1.260	–	2.520	3.953	6.669	1.500	2.126	0.087	D2113200M-150F
	33.00	1.299	–	2.598	4.031	6.748	1.500	2.126	0.075	D2113300M-150F
	33.32	1.312	1-5/16	2.624	4.031	6.748	1.500	2.126	0.073	D2111312I-150F
	34.00	1.339	–	2.677	4.110	6.827	1.500	2.126	0.067	D2113400M-150F
	34.92	1.375	1-3/8	2.750	4.110	6.827	1.500	2.126	0.056	D2111375I-150F
	38.10	1.500	1-1/2	3.000	4.425	7.142	1.500	2.126	0.027	D2111500I-150F
3xD	32.00	1.260	–	3.780	5.213	7.929	1.500	2.126	0.087	D3113200M-150F
	33.00	1.299	–	3.898	5.331	8.047	1.500	2.126	0.075	D3113300M-150F
	33.32	1.312	1-5/16	3.936	5.331	8.047	1.500	2.126	0.073	D3111312I-150F
	34.00	1.339	–	4.016	5.449	8.165	1.500	2.126	0.067	D3113400M-150F
	34.92	1.375	1-3/8	4.125	5.449	8.165	1.500	2.126	0.056	D3111375I-150F
	38.10	1.500	1-1/2	4.500	5.921	8.638	1.500	2.126	0.027	D3111500I-150F
4xD	32.00	1.260	–	5.039	6.079	8.795	1.500	2.126	0.087	D4113200M-150F
	33.00	1.299	–	5.197	6.236	8.953	1.500	2.126	0.075	D4113300M-150F
	33.32	1.312	1-5/16	5.248	6.236	8.953	1.500	2.126	0.073	D4111312I-150F
	34.00	1.339	–	5.354	6.394	9.110	1.500	2.126	0.067	D4113400M-150F
	34.92	1.375	1-3/8	5.500	6.394	9.110	1.500	2.126	0.056	D4111375I-150F
	38.10	1.500	1-1/2	6.000	7.024	9.740	1.500	2.126	0.027	D4111500I-150F

### IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
P	4T-11T306-P	7488-T15-1	8T-15	3.5 N-m (30.9 in-lbs)
S	4T-11T306-M			
H	4T-11T306-H			
K	4T-11T306-K			
N	4T-11T306-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.15 / +0.25	-0.006 / +0.010
3xD	-0.15 / +0.25	-0.006 / +0.010
4xD	-0.15 / +0.30	-0.006 / +0.012



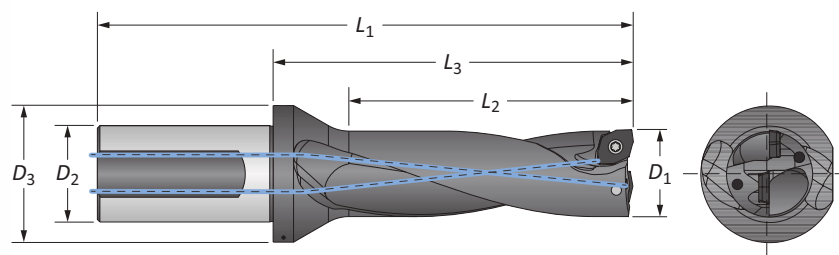
m = Metric (mm)  
i = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

## 4TEX® Drill Holders | Metric Shank

14 Series | Diameter Range: 39.00 mm - 39.67 mm (1.535" - 1.562")\*



\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Metric Shank

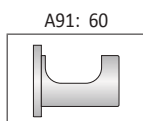
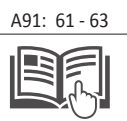
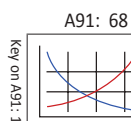
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	39.00	1.535	–	78.00	110.40	179.40	40.00	54.00	2.80	<b>D2143900M-40FM</b>
	39.67	1.562	1-9/16	79.40	110.40	179.40	40.00	54.00	2.61	<b>D2141562I-40FM</b>
3xD	39.00	1.535	–	117.00	149.40	218.40	40.00	54.00	2.80	<b>D3143900M-40FM</b>
	39.67	1.562	1-9/16	119.02	149.40	218.40	40.00	54.00	2.61	<b>D3141562I-40FM</b>
4xD	39.00	1.535	–	156.00	188.40	257.40	40.00	54.00	2.80	<b>D4143900M-40FM</b>
	39.67	1.562	1-9/16	158.70	188.40	257.40	40.00	54.00	2.61	<b>D4141562I-40FM</b>

### IC Inserts

ISO Material	Part No.	 Insert Screw	 Torx® Driver	Admissible Tightening Torque
<b>P</b>	4T-140408-P	7595-T20-1	8T-20	4.5 N-m (39.8 in-lbs)
<b>S</b> <b>M</b>	4T-140408-M			
<b>H</b>	4T-140408-H			
<b>K</b>	4T-140408-K			
<b>N</b>	4T-140408-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.20 / +0.30	-0.008 / +0.012
3xD	-0.20 / +0.30	-0.008 / +0.012
4xD	-0.20 / +0.35	-0.008 / +0.014



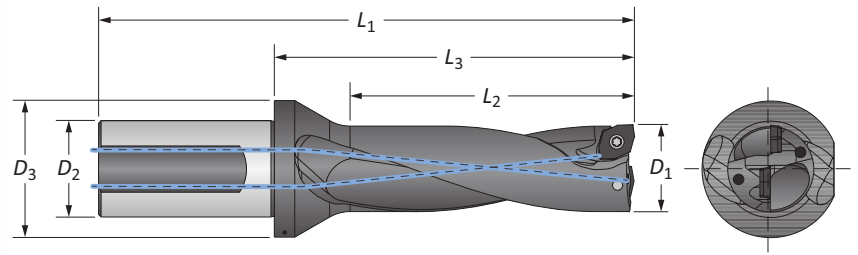
**m** = Metric (mm)  
**i** = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

## 4TEX® Drill Holders | Imperial Shank

14 Series | Diameter Range: 39.00 mm - 39.67 mm (1.535" - 1.562")\*

\*See the 4TEX drill catalogue (A55-4TX) for all diameters available.



### Imperial Shank

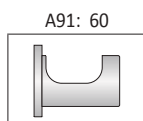
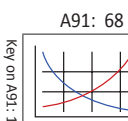
Length	D <sub>1</sub>		Fractional Equivalent	Body			Shank		Max Offset	Part No.
	mm	in		L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>		
2xD	39.00	1.535	–	3.071	4.346	7.063	1.500	2.126	0.110	<b>D2143900M-150F</b>
	39.67	1.562	1-9/16	3.124	4.346	7.063	1.500	2.126	0.103	<b>D2141562I-150F</b>
3xD	39.00	1.535	–	4.606	5.882	8.598	1.500	2.126	0.110	<b>D3143900M-150F</b>
	39.67	1.562	1-9/16	4.686	5.882	8.598	1.500	2.126	0.103	<b>D3141562I-150F</b>
4xD	39.00	1.535	–	6.142	7.417	10.134	1.500	2.126	0.110	<b>D4143900M-150F</b>
	39.67	1.562	1-9/16	6.248	7.417	10.134	1.500	2.126	0.103	<b>D4141562I-150F</b>

### IC Inserts

ISO Material	Part No.	Insert Screw	Torx® Driver	Admissible Tightening Torque
<b>P</b>	4T-140408-P	7595-T20-1	8T-20	4.5 N-m (39.8 in-lbs)
<b>S</b> <b>M</b>	4T-140408-M			
<b>H</b>	4T-140408-H			
<b>K</b>	4T-140408-K			
<b>N</b>	4T-140408-N			

### Expected Hole Tolerances

Length	mm	in
2xD	-0.20 / +0.30	-0.008 / +0.012
3xD	-0.20 / +0.30	-0.008 / +0.012
4xD	-0.20 / +0.35	-0.008 / +0.014

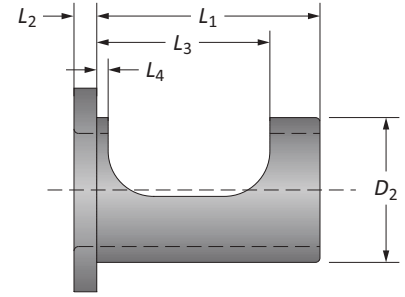
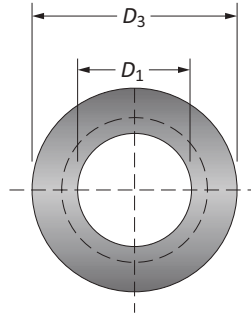


**m** = Metric (mm)  
**i** = Imperial (in)

IC inserts sold in quantities of 10.  
Insert screws sold in quantities of 10.

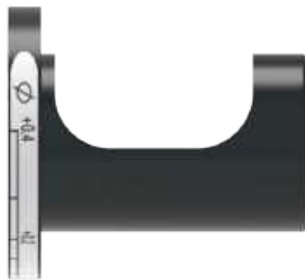
## Eccentric Sleeves

For Cutting Diameter / Center Height Adjustment



Sleeve Dimensions								Adjustment Range		
	$D_1$	$D_2$	$D_3$	$L_2$	$L_3$	$L_4$	$L_1$	Part No.	Diameter*	Center Height
m	25.00	32.00	49.00	6.00	39.00	2.50	54.00	SLEEVE-25FM	-0.20 to +0.40	-0.15 to +0.20
	32.00	40.00	58.00	6.00	43.00	2.50	59.00	SLEEVE-32FM	-0.20 to +0.40	-0.15 to +0.20
	40.00	50.00	74.00	6.00	49.00	3.00	69.00	SLEEVE-40FM	-0.20 to +0.40	-0.20 to +0.30
i	0.750	1.000	1.614	0.157	1.593	0.118	1.837	SLEEVE-075F	-0.008 to +0.016	-0.006 to +0.008
	1.000	1.250	1.929	0.236	1.593	0.098	1.995	SLEEVE-100F	-0.008 to +0.016	-0.006 to +0.008
	1.250	1.500	2.283	0.236	1.693	0.098	2.087	SLEEVE-125F	-0.008 to +0.016	-0.006 to +0.008
	1.500	2.000	2.913	0.236	1.929	0.118	2.481	SLEEVE-150F	-0.008 to +0.024	-0.008 to +0.012

\*Diameter adjustment range refers to the cutting diameter.



**Milling Applications**  
Peripheral Adjustment Position



**Lathe Applications**  
Front Adjustment Position

m = Metric (mm)  
i = Imperial (in)





## Diameter Adjustment

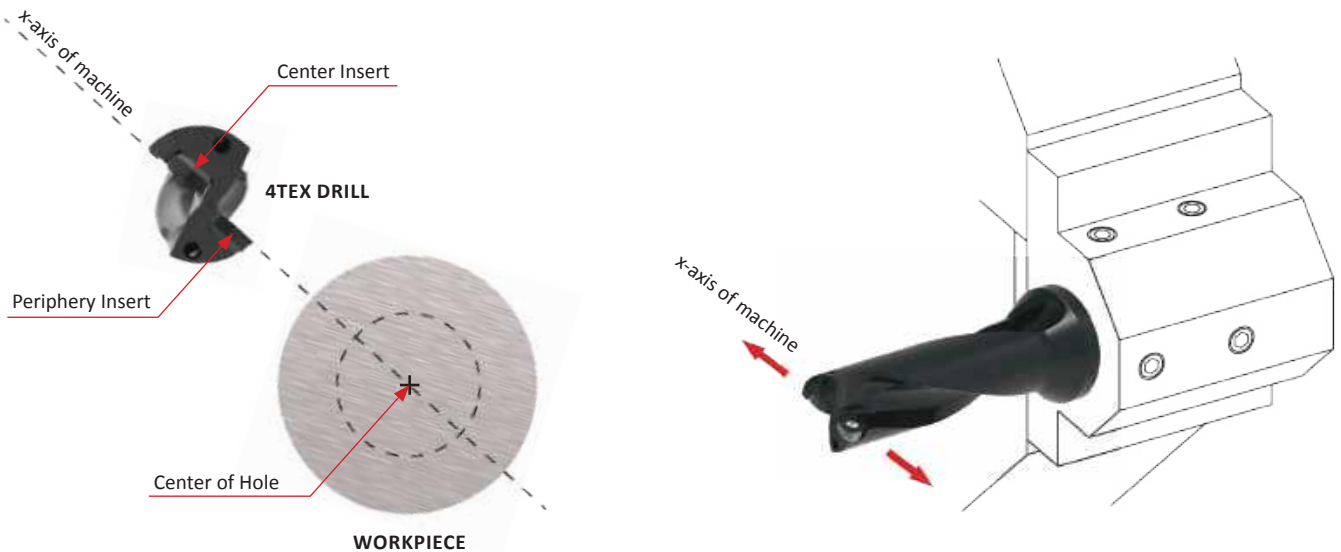
### Milling and Lathe Applications



#### For Milling Applications

1. Assemble the 4TEX drill, eccentric sleeve, and tool holder. Do not tighten the tool holder set screws.
2. Using the peripheral marks for milling machines, align the reference indentation on the holder with the 0 (zero) mark on the eccentric sleeve to have no offset.
3. Rotate the sleeve in the (+) or (-) direction to increase or decrease the nominal diameter.
4. Once the drill has arrived at the desired diameter, firmly tighten the top set screw first and then tighten the bottom set screw.

**NOTICE:** Eccentric sleeves are to be used with side-locking tool holders only. Damage may result with other styles of tool holders.



#### For Lathe Applications

1. Assemble the 4TEX drill into the lathe turret with the top face of the inserts parallel to the x-axis of the machine. This will allow for the diameter offsets to be made using the lathe's x-axis.
2. To increase the nominal diameter, offset the x-axis so the periphery insert moves away from the center of the hole.
3. To decrease the nominal diameter, offset the x-axis so the periphery insert moves toward the center of the hole.

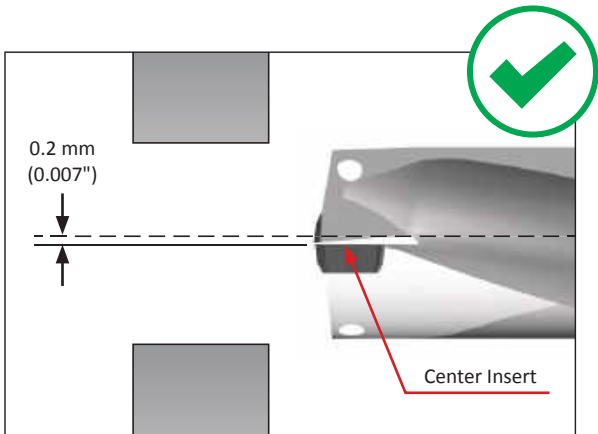
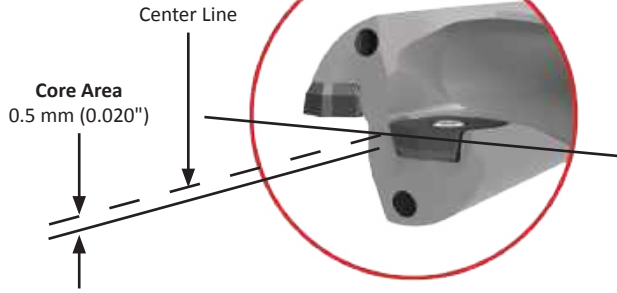
**NOTE:** Eccentric sleeve is not required when adjusting the diameter of the hole on a lathe.



# Center Height Alignment

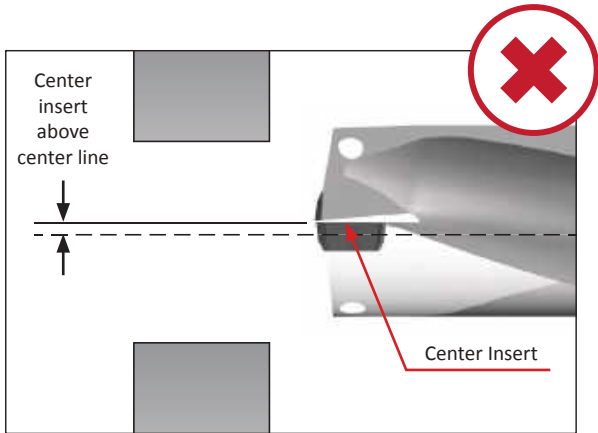
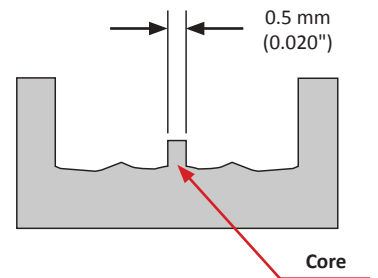
## Proper Center Line Position

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS



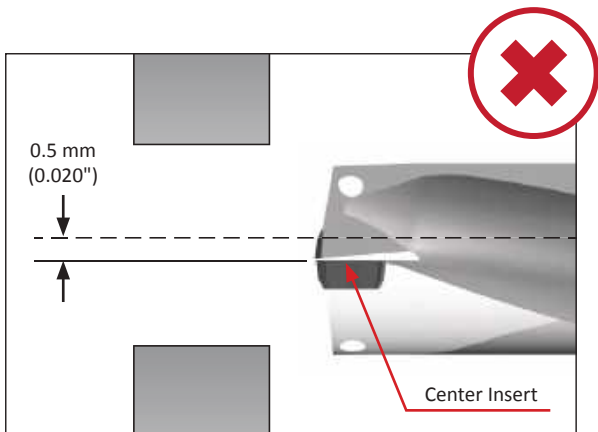
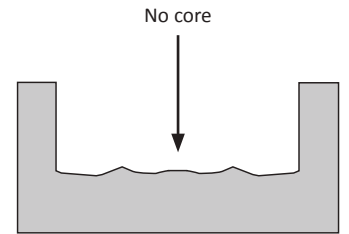
### Proper Center Height Alignment

- The correct center height alignment will position the center insert 0.2 mm (0.007") below the center line.



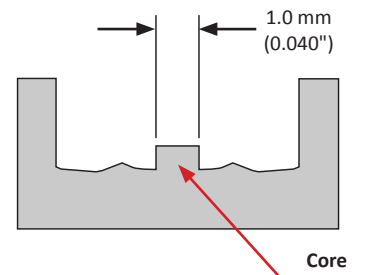
### Center Insert Above the Center Line

- This will cause fracturing of the center insert.
- Requires center height adjustment.



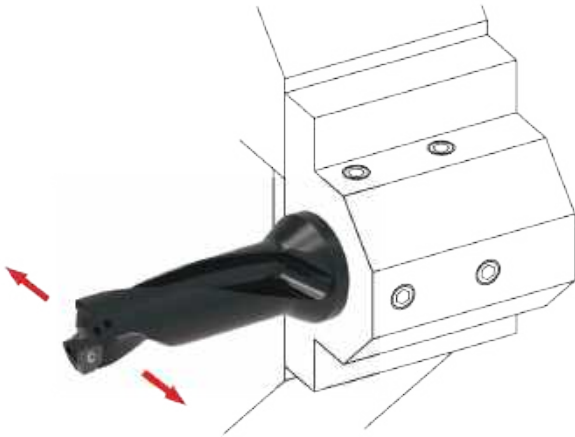
### Center Insert Too Far Below Center Line

- This will cause the drill to interfere with the drilled hole.
- This will impede chip evacuation on the periphery insert.
- Requires center height adjustment.



## Center Height Alignment

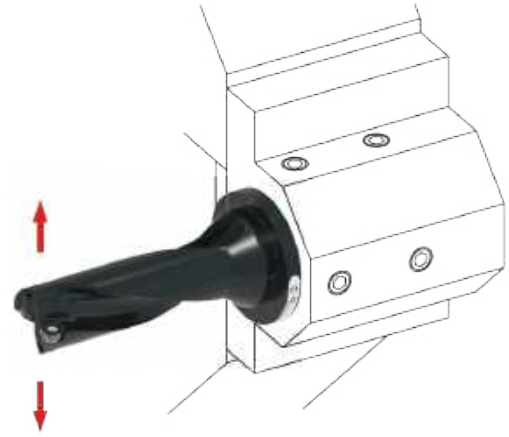
### How to Correct Issues



#### Method 1: Adjustment with X-Axis

1. Rotate the drill body so the position of the center line of the inserts is perpendicular to the lathe's x-axis.
2. Use the x-axis to offset the position of the center line in a (+) or (-) direction to increase or decrease the center core diameter at the bottom of the hole.

**NOTE:** This method does not allow diameter adjustments using the x-axis.



#### Method 2: Adjustment with Eccentric Sleeve

1. Assemble the drill to the turret using the eccentric sleeve, positioning the center line of the inserts parallel to the x-axis.
2. Align the reference indentation on the drill to the "0" setting on the flange face.
3. Rotate the sleeve (+) or (-) to increase or decrease the center height of the inserts in order to increase or decrease the core diameter at the bottom of the hole.

**NOTE:** This method still allows diameter adjustments using the x-axis.

**NOTE (applies to both methods):** Adjusting the center line of the inserts may affect the hole diameter produced. Method two is preferred to make center height adjustments and compensate for hole diameter with the x-axis.





## Recommended Cutting Data | Metric (mm)

T-A® | GEN2 T-A®





### Thin Wall Inserts Super Cobalt

ISO	Material	Speed (M/min) - Mist Coolant		Feed Rate (mm/rev) by Diameter				
		Hardness (BHN)	 AM200® Speed	 TiAlN Speed	0 series (12.98 mm - 17.67 mm)	1 series (17.53 mm - 24.40 mm)	2 series (24.41 mm - 35.06 mm)	3 series (34.37 mm - 47.82 mm)
P	Structural Steel	100 - 150	39	34	0.30	0.45	0.48	0.50
	A36, A285, A516, etc.	150 - 250	35	31	0.28	0.40	0.43	0.48
		250 - 350	32	28	0.25	0.36	0.40	0.45




### Notch Point® and 150° Structural Steel Inserts Super Cobalt


ISO	Material	Speed (M/min) - Mist Coolant		Feed Rate (mm/rev) by Diameter				
		Hardness (BHN)	 AM200® Speed	 TiAlN Speed	0 series (12.98 mm - 17.67 mm)	1 series (17.53 mm - 24.40 mm)	2 series (24.41 mm - 35.06 mm)	3 series (34.37 mm - 47.82 mm)
P	Structural Steel	100 - 150	39	34	0.25	0.30	0.36	0.45
	A36, A285, A516, etc.	150 - 250	35	31	0.23	0.28	0.30	0.40
		250 - 350	35	28	0.20	0.25	0.28	0.36



### GEN2 T-A Inserts Super Cobalt

ISO	Material	Speed (M/min) - Mist Coolant		Feed Rate (mm/rev) by Diameter			
		Hardness (BHN)	 AM200® Speed	0 series (12.98 mm - 17.67 mm)	1 series (17.53 mm - 24.40 mm)	2 series (24.41 mm - 35.06 mm)	3 series (34.37 mm - 47.82 mm)
P	Structural Steel	100 - 150	39	0.25	0.30	0.36	0.46
	A36, A285, A516, etc.	150 - 250	35	0.23	0.28	0.30	0.40
		250 - 350	35	0.20	0.25	0.28	0.36

### GEN2 T-A Inserts Carbide C1 (K35)

ISO	Material	Speed (M/min) - Mist Coolant		Feed Rate (mm/rev) by Diameter			
		Hardness (BHN)	 AM300® Speed	0 series (12.98 mm - 17.67 mm)	1 series (17.53 mm - 24.40 mm)	2 series (24.41 mm - 35.06 mm)	3 series (34.37 mm - 47.82 mm)
P	Structural Steel	100 - 150	50	0.20	0.28	0.38	0.43
	A36, A285, A516, etc.	150 - 250	47	0.15	0.25	0.33	0.38
		250 - 350	43	0.13	0.23	0.30	0.33

**NOTE:** The speeds and feeds listed above are based on a rigid setup using air mist through tool coolant. Speed may be increased up to 50% if using high pressure flood or through coolant.  
**NOTE:** If drilling dry without coolant, speed must be reduced significantly based on setup, drill depth, and material hardness. Up to 50% speed and feed reduction may be necessary in these types of applications. Contact the Application Engineering department for assistance. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*



A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

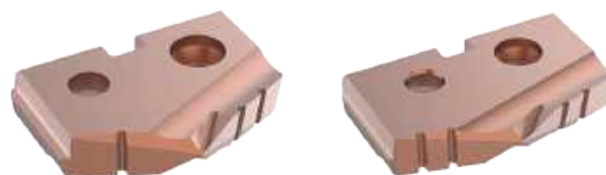
## Recommended Cutting Data | Imperial (inch)

T-A® | GEN2 T-A®





### Thin Wall Inserts Super Cobalt

ISO	Material	Speed (SFM) - Mist Coolant		Feed Rate (IPR) by Diameter				
		Hardness (BHN)	 AM200® Speed	 TiAlN Speed	0 series (0.5110" - 0.6959")	1 series (0.6900" - 0.9609")	2 series (0.9610" - 1.3809")	3 series (1.3530" - 1.8829")
P	Structural Steel	100 - 150	125	110	0.012	0.018	0.019	0.020
	A36, A285,	150 - 250	115	100	0.011	0.016	0.017	0.019
	A516, etc.	250 - 350	105	90	0.010	0.014	0.016	0.018




### Notch Point® and 150° Structural Steel Inserts Super Cobalt


ISO	Material	Speed (SFM) - Mist Coolant		Feed Rate (IPR) by Diameter				
		Hardness (BHN)	 AM200® Speed	 TiAlN Speed	0 series (0.5110" - 0.6959")	1 series (0.6900" - 0.9609")	2 series (0.9610" - 1.3809")	3 series (1.3530" - 1.8829")
P	Structural Steel	100 - 150	125	110	0.010	0.012	0.014	0.018
	A36, A285,	150 - 250	115	100	0.009	0.011	0.012	0.016
	A516, etc.	250 - 350	105	90	0.008	0.010	0.011	0.014



### GEN2 T-A Inserts Super Cobalt

ISO	Material	Speed (SFM) - Mist Coolant		Feed Rate (IPR) by Diameter			
		Hardness (BHN)	 AM200® Speed	0 series (0.5110" - 0.6959")	1 series (0.6900" - 0.9609")	2 series (0.9610" - 1.3809")	3 series (1.3530" - 1.8829")
P	Structural Steel	100 - 150	125	0.010	0.012	0.014	0.018
	A36, A285,	150 - 250	115	0.009	0.011	0.012	0.016
	A516, etc.	250 - 350	105	0.008	0.010	0.011	0.014

### GEN2 T-A Inserts Carbide C1 (K35)

ISO	Material	Speed (SFM) - Mist Coolant		Feed Rate (IPR) by Diameter			
		Hardness (BHN)	 AM300® Speed	0 series (0.5110" - 0.6959")	1 series (0.6900" - 0.9609")	2 series (0.9610" - 1.3809")	3 series (1.3530" - 1.8829")
P	Structural Steel	100 - 150	165	0.008	0.011	0.015	0.017
	A36, A285,	150 - 250	155	0.006	0.010	0.013	0.015
	A516, etc.	250 - 350	140	0.005	0.009	0.012	0.013

**NOTE:** The speeds and feeds listed above are based on a rigid setup using air mist through tool coolant. Speed may be increased up to 50% if using high pressure flood or through coolant.  
**NOTE:** If drilling dry without coolant, speed must be reduced significantly based on setup, drill depth, and material hardness. Up to 50% speed and feed reduction may be necessary in these types of applications. Contact the Application Engineering department for assistance. email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS




## Recommended Cutting Data


GEN3SYS® XT Pro (XTST) | GEN3SYS® XT

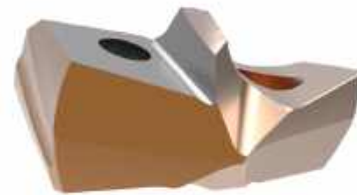


Metric (mm)


ISO	Material	Speed (M/min) Mist Coolant		Feed Rate (mm/rev) by Diameter				
		Hardness (BHN)	 AM420 Speed	12 series (12.00 mm - 12.99 mm)	13 series (13.00 mm - 13.99 mm)	14 series (14.00 mm - 14.99 mm)	15 series (15.00 mm - 15.99 mm)	16 series (16.00 mm - 16.99 mm)
P	Structural Steel A36, A285, A516, etc.	100 - 150	107	0.20	0.22	0.25	0.25	0.30
		150 - 250	91	0.18	0.20	0.23	0.23	0.25
		250 - 350	79	0.15	0.17	0.20	0.20	0.23

Imperial (inch)


ISO	Material	Speed (SFM) Mist Coolant		Feed Rate (IPR) by Diameter				
		Hardness (BHN)	 AM420 Speed	12 series (0.4724" - 0.5117")	13 series (0.5118" - 0.5511")	14 series (0.5512" - 0.5905")	15 series (0.5906" - 0.6298")	16 series (0.6299" - 0.6692")
P	Structural Steel A36, A285, A516, etc.	100 - 150	350	0.008	0.009	0.010	0.010	0.012
		150 - 250	300	0.007	0.008	0.009	0.009	0.010
		250 - 350	260	0.006	0.007	0.008	0.008	0.009



Metric (mm)

ISO	Material	Speed (M/min) Mist Coolant		Feed Rate (mm/rev) by Diameter				
		Hardness (BHN)	 AM300® Speed	12 series (12.00 mm - 12.99 mm)	14 series (14.00 mm - 14.99 mm)	15 series (15.00 mm - 15.99 mm)	16 series (16.00 mm - 16.99 mm)	17 series (17.00 mm - 17.99 mm)
P	Structural Steel A36, A285, A516, etc.	100 - 150	107	0.20	0.25	0.25	0.30	0.30
		150 - 250	91	0.18	0.23	0.23	0.25	0.25
		250 - 350	79	0.15	0.20	0.20	0.23	0.23

Imperial (inch)

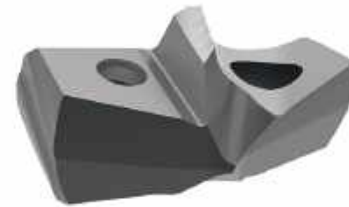
ISO	Material	Speed (SFM) Mist Coolant		Feed Rate (IPR) by Diameter				
		Hardness (BHN)	 AM300® Speed	12 series (0.4724" - 0.5117")	14 series (0.5512" - 0.5905")	15 series (0.5906" - 0.6298")	16 series (0.6299" - 0.6692")	17 series (0.6693" - 0.7086")
P	Structural Steel A36, A285, A516, etc.	100 - 150	350	0.008	0.010	0.010	0.012	0.012
		150 - 250	300	0.007	0.009	0.009	0.010	0.010
		250 - 350	260	0.006	0.008	0.008	0.009	0.009

Speed and Feed Multiplier

	Depth of Cut	
	<= 1.5xD	> 1.5xD
Speed	See above chart	0.75
Feed	See above chart	0.90

**NOTE:** The speeds and feeds listed above are based on a rigid setup using air mist through tool coolant. Speed may be increased up to 50% if using high pressure flood or through coolant.  
**NOTE:** If drilling dry without coolant, speed must be reduced significantly based on setup, drill depth, and material hardness. Up to 50% speed and feed reduction may be necessary in these types of applications. Contact the Application Engineering department for assistance. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*  
**NOTE:** If drilling material thickness of 12.7 mm (0.500") or less, a minimum of 10% reduction in feed is required to minimise material deflection.

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

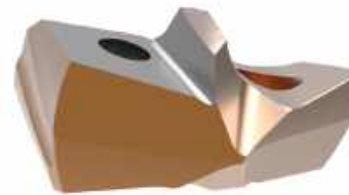


Feed Rate (mm/rev) by Diameter

17 series (17.00 mm - 17.99 mm)	18 series (18.00 mm - 19.99 mm)	20 series (20.00 mm - 21.99 mm)	22 series (22.00 mm - 23.99 mm)	24 series (24.00 mm - 25.99 mm)	26 series (26.00 mm - 28.99 mm)	29 series (29.00 mm - 31.99 mm)	32 series (32.00 mm - 35.00 mm)
0.30	0.36	0.38	0.41	0.43	0.46	0.48	0.48
0.25	0.30	0.36	0.38	0.41	0.43	0.46	0.46
0.23	0.28	0.30	0.33	0.36	0.38	0.41	0.41

Feed Rate (IPR) by Diameter

17 series (0.6693" - 0.7086")	18 series (0.7087" - 0.7873")	20 series (0.7874" - 0.8660")	22 series (0.8661" - 0.9448")	24 series (0.9449" - 1.0235")	26 series (1.0236" - 1.1416")	29 series (1.1417" - 1.2597")	32 series (1.2598" - 1.3780")
0.012	0.014	0.015	0.016	0.017	0.018	0.019	0.019
0.010	0.012	0.014	0.015	0.016	0.017	0.018	0.018
0.009	0.011	0.012	0.013	0.014	0.015	0.016	0.016



Feed Rate (mm/rev) by Diameter

18 series (18.00 mm - 19.99 mm)	20 series (20.00 mm - 21.99 mm)	22 series (22.00 mm - 23.99 mm)	24 series (24.00 mm - 25.99 mm)	26 series (26.00 mm - 28.99 mm)	29 series (29.00 mm - 31.99 mm)	32 series (32.00 mm - 35.00 mm)
0.36	0.38	0.41	0.43	0.46	0.48	0.48
0.30	0.36	0.38	0.41	0.43	0.46	0.46
0.28	0.30	0.33	0.36	0.38	0.41	0.41

Feed Rate (IPR) by Diameter

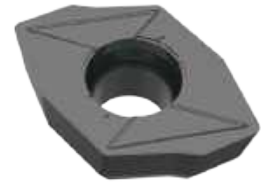
18 series (0.7087" - 0.7873")	20 series (0.7874" - 0.8660")	22 series (0.8661" - 0.9448")	24 series (0.9449" - 1.0235")	26 series (1.0236" - 1.1416")	29 series (1.1417" - 1.2597")	32 series (1.2598" - 1.3780")
0.014	0.015	0.016	0.017	0.018	0.019	0.019
0.012	0.014	0.015	0.016	0.017	0.018	0.018
0.011	0.012	0.013	0.014	0.015	0.016	0.016

**NOTE:** The speeds and feeds listed above are based on a rigid setup using air mist through tool coolant. Speed may be increased up to 50% if using high pressure flood or through coolant.  
**NOTE:** If drilling dry without coolant, speed must be reduced significantly based on setup, drill depth, and material hardness. Up to 50% speed and feed reduction may be necessary in these types of applications. Contact the Application Engineering department for assistance. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*  
**NOTE:** If drilling material thickness of 12.7 mm (0.500") or less, a minimum of 10% reduction in feed is required to minimise material deflection.



## Recommended Drilling Data | Metric (mm) | Imperial (inch)

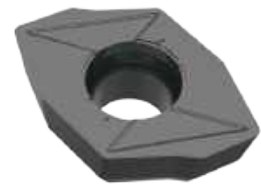
4TEX® Indexable Drill



### Metric (mm)

ISO	Material	Hardness (BHN)	Speed (m/min)	Feed Rate (mm/rev) by Diameter - 2xD, 3xD*			
				03, 04 Series (12.00 mm - 15.00 mm)	05 Series (15.88 mm - 18.00 mm)	06, 07 Series (19.00 mm - 26.00 mm)	09, 11, 14 Series (27.00 mm - 39.67 mm)
P	Structural Steel	100 - 150	100 - 185	0.05 - 0.13	0.07 - 0.13	0.08 - 0.13	0.08 - 0.13
	A36, A285,	150 - 250	100 - 185	0.05 - 0.13	0.07 - 0.13	0.08 - 0.13	0.08 - 0.13
	A516, etc.	250 - 350	100 - 185	0.05 - 0.13	0.07 - 0.13	0.08 - 0.13	0.08 - 0.13

\*For 4xD tools, begin at low end of feed recommendation.



### Imperial (inch)

ISO	Material	Hardness (BHN)	Speed (SFM)	Feed Rate (IPR) by Diameter - 2xD, 3xD*			
				03, 04 Series (0.472" - 0.591")	05 Series (0.625" - 0.709")	06, 07 Series (0.748" - 1.024")	09, 11, 14 Series (1.063" - 1.562")
P	Structural Steel	100 - 150	330 - 600	0.0015 - 0.0055	0.0025 - 0.0065	0.003 - 0.008	0.003 - 0.008
	A36, A285,	150 - 250	330 - 600	0.0015 - 0.0055	0.0025 - 0.0065	0.003 - 0.008	0.003 - 0.008
	A516, etc.	250 - 350	330 - 600	0.0015 - 0.0055	0.0025 - 0.0065	0.003 - 0.008	0.003 - 0.008

\*For 4xD tools, begin at low end of feed recommendation.

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS





## Insert Geometry Recommendations | Troubleshooting

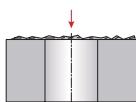
4TEX® Indexable Drill




### Insert Geometry Recommendations

ISO	Material	Hardness (BHN)	Geometry				
			P	M	K	N	H
P	Structural Steel A36, A285, A516, etc.	100 - 150	○	●			
		150 - 250	○	●			
		250 - 350	●				○

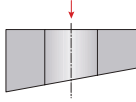
### Troubleshooting

- 

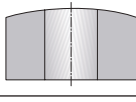
**Starting on Uneven Surfaces**

  - Reduce entry feed by 50% if necessary.
- 

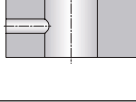
**Starting on Angled Surfaces**

  - Reduce entry feed by 20 - 50%.
  - Use lower rake geometry if insert chipping occurs.
- 

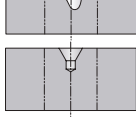
**Angled Bore Exit**

  - Reduce entry feed by 50% on breakout.
  - Use tough insert and stable corner radius.
- 

**Starting on Convex Surfaces**

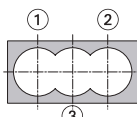
  - Reduce entry feed by 50%.
  - Use lower rake geometry if insert chipping occurs.
- 

**Drilling Through a Cross Hole**

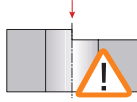
  - Reduce feed rate 50% if necessary.
  - Use good coolant flow and monitor chip packing.
  - Use lower rake geometry if insert chipping occurs.
- 

**Drilling on a Groove or Large Centering Box**

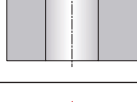
  - Reduce entry feed.
  - Use lower rake geometry for center insert.

- 


**Chain Drilling**

  - Use good coolant flow.
  - Reduce feed rate by 50% for interrupted cut.
  - Use lower rake geometry if insert chipping occurs.
- 

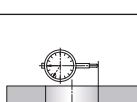
**Starting on an Edge**

  - Reduce entry feed rate by 50%.
  - Use lower rake geometry if insert chipping occurs.
- 


**Starting on a Welded Seam**

  - Reduce entry feed rate by 50%.
  - Use lower rake geometry if insert chipping occurs.
- 

**Drilling Through Stacked Plates**

  - Not recommended.
- 

**Opening an Existing Hole**

  - Use flood coolant.
- 

**Adjustable**

  - For mills, use eccentric sleeve with end mill holder.
  - For lathes, use x-axis to adjust offset  $\phi$ .

**NOTE:** Refer to maximum offset  $\phi$  in data tables.

## Europe

### Allied Machine & Engineering Co. (Europe) Ltd

93 Vantage Point  
Pensnett Estate  
Kingswinford  
West Midlands  
DY6 7FR England

#### Phone:

+44 (0) 1384 400 900

### Wohlhaupter® GmbH

Maybachstrasse 4  
Postfach 1264  
72636 Frickenhausen  
Germany

#### Phone:

+49 (0) 7022 408-0

## United States

### Allied Machine & Engineering

120 Deeds Drive  
Dover OH 44622  
United States

#### Phone:

+1.330.343.4283

#### Toll Free USA and Canada:

800.321.5537

#### Toll Free USA and Canada:

800.223.5140

### Allied Machine & Engineering

485 W Third Street  
Dover OH 44622  
United States

#### Phone:

+1.330.343.4283

#### Toll Free USA and Canada:

800.321.5537

## Asia

### Wohlhaupter® India Pvt. Ltd.

B-23, 3rd Floor  
B Block Community Centre  
Janakpuri, New Delhi - 110058  
India

#### Phone:

+91 (0) 11.41827044

Your local Allied Machine representative:

[www.alliedmachine.com](http://www.alliedmachine.com)

Allied Machine & Engineering Co. Europe Ltd is registered to **ISO 9001:2015** by bsi.

Allied Machine & Engineering is registered to **ISO 9001:2015** by DQS.

Wohlhaupter GmbH is registered to **ISO 9001:2015** by QUACERT.

