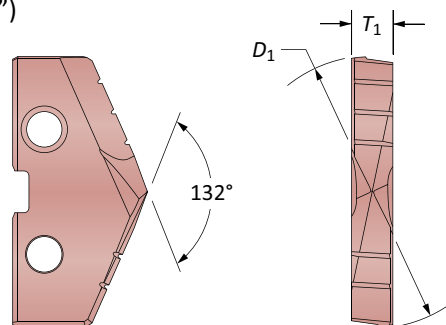


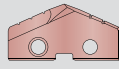
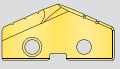


GEN2 T-A® Drill Inserts

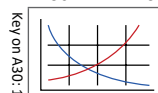
3 Series | HSS | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")



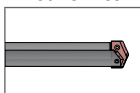
HSS Inserts – Premium Cobalt

Insert				Part No.	
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	 AM200®	 TiN
35.72	1.4063	1-13/32	6.35	483H-0113	483T-0113
36.00	1.4173	–		483H-36	483T-36
36.51	1.4375	1-7/16		483H-0114	483T-0114
37.00	1.4567	–		483H-37	483T-37
37.31	1.4688	1-15/32		483H-0115	483T-0115
38.00	1.4961	–		483H-38	483T-38
38.10	1.5000	1-1/2		483H-0116	483T-0116
38.89	1.5313	1-17/32		483H-0117	483T-0117
39.00	1.5354	–		483H-39	483T-39
39.29	1.5470	–		483H-1.547	483T-1.547
39.69	1.5625	1-9/16		483H-0118	483T-0118
40.00	1.5748	–		483H-40	483T-40
40.48	1.5938	1-19/32		483H-0119	483T-0119
41.00	1.6142	–		483H-41	483T-41
41.28	1.6250	1-5/8		483H-0120	483T-0120
42.00	1.6535	–		483H-42	483T-42
42.07	1.6563	1-21/32		483H-0121	483T-0121
42.86	1.6875	1-11/16		483H-0122	483T-0122
43.00	1.6929	–		483H-43	483T-43
43.66	1.7188	1-23/32		483H-0123	483T-0123
44.00	1.7323	–		483H-44	483T-44
44.45	1.7500	1-3/4		483H-0124	483T-0124
45.00	1.7717	–		483H-45	483T-45
45.24	1.7813	1-25/32		483H-0125	483T-0125
45.50	1.7913	–		483H-45.5	483T-45.5
45.64	1.7970	–		483H-1.797	483T-1.797
46.00	1.8110	–		483H-46	483T-46
46.04	1.8125	1-13/16		483H-0126	483T-0126
46.83	1.8438	1-27/32		483H-0127	483T-0127
47.00	1.8504	–		483H-47	483T-47
47.63	1.8750	1-7/8		483H-0128	483T-0128

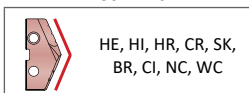
A30: 112 - 143



A30: 82 - 85



A30: 4 - 6

HE, HI, HR, CR, SK,
BR, CI, NC, WCCoatings not listed above
can be supplied as
non-stocked standards.

Inserts sold in quantities of 1

TiN = 131T-XXXX

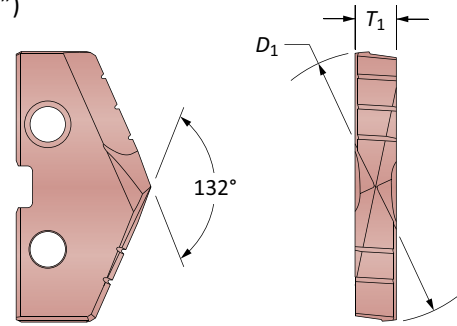
TiAlN = 131A-XXXX

TiCN = 131N-XXXX

AM200® = 131H-XXXX

GEN2 T-A® Drill Inserts

3 Series | HSS | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")



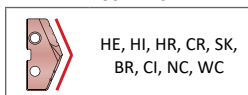
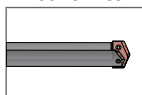
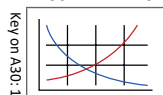
HSS Inserts – Super Cobalt

Insert				Part No.	
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	AM200®	TiN
35.72	1.4063	1-13/32	6.35	453H-0113	453T-0113
36.00	1.4173	–		453H-36	453T-36
36.51	1.4375	1-7/16		453H-0114	453T-0114
37.00	1.4567	–		453H-37	453T-37
37.31	1.4688	1-15/32		453H-0115	453T-0115
38.00	1.4961	–		453H-38	453T-38
38.10	1.5000	1-1/2		453H-0116	453T-0116
38.89	1.5313	1-17/32		453H-0117	453T-0117
39.00	1.5354	–		453H-39	453T-39
39.29	1.5470	–		453H-1.547	453T-1.547
39.69	1.5625	1-9/16		453H-0118	453T-0118
40.00	1.5748	–		453H-40	453T-40
40.48	1.5938	1-19/32		453H-0119	453T-0119
41.00	1.6142	–		453H-41	453T-41
41.28	1.6250	1-5/8		453H-0120	453T-0120
42.00	1.6535	–		453H-42	453T-42
42.07	1.6563	1-21/32		453H-0121	453T-0121
42.86	1.6875	1-11/16		453H-0122	453T-0122
43.00	1.6929	–		453H-43	453T-43
43.66	1.7188	1-23/32		453H-0123	453T-0123
44.00	1.7323	–		453H-44	453T-44
44.45	1.7500	1-3/4		453H-0124	453T-0124
45.00	1.7717	–		453H-45	453T-45
45.24	1.7813	1-25/32		453H-0125	453T-0125
45.50	1.7913	–		453H-45.5	453T-45.5
45.64	1.7970	–		453H-1.797	453T-1.797
46.00	1.8110	–		453H-46	453T-46
46.04	1.8125	1-13/16		453H-0126	453T-0126
46.83	1.8438	1-27/32		453H-0127	453T-0127
47.00	1.8504	–		453H-47	453T-47
47.63	1.8750	1-7/8		453H-0128	453T-0128

A30: 112 - 143

A30: 82 - 85

A30: 4 - 6



Coatings not listed above can be supplied as non-stocked standards.



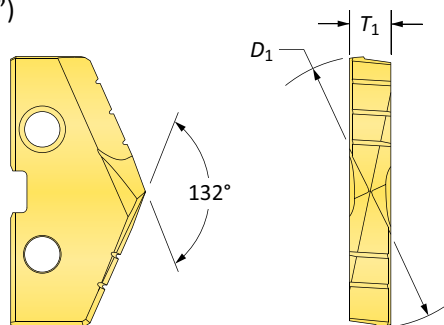
Inserts sold in quantities of 1

TiN = 131T-XXXX	TiAlN = 131A-XXXX
TiCN = 131N-XXXX	AM200® = 131H-XXXX



GEN2 T-A® Drill Inserts

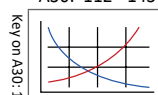
3 Series | HSS | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")



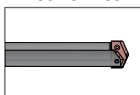
HSS Inserts – Premium Cobalt

Insert				Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	TiN
35.72	1.4063	1-13/32	6.35	483T-0113
36.00	1.4173	–		483T-36
36.51	1.4375	1-7/16		483T-0114
37.00	1.4567	–		483T-37
37.31	1.4688	1-15/32		483T-0115
38.00	1.4961	–		483T-38
38.10	1.5000	1-1/2		483T-0116
38.89	1.5313	1-17/32		483T-0117
39.00	1.5354	–		483T-39
39.29	1.5470	–		483T-1.547
39.69	1.5625	1-9/16		483T-0118
40.00	1.5748	–		483T-40
40.48	1.5938	1-19/32		483T-0119
41.00	1.6142	–		483T-41
41.28	1.6250	1-5/8		483T-0120
42.00	1.6535	–		483T-42
42.07	1.6563	1-21/32		483T-0121
42.86	1.6875	1-11/16		483T-0122
43.00	1.6929	–		483T-43
43.66	1.7188	1-23/32		483T-0123
44.00	1.7323	–		483T-44
44.45	1.7500	1-3/4		483T-0124
45.00	1.7717	–		483T-45
45.24	1.7813	1-25/32		483T-0125
45.50	1.7913	–		483T-45.5
45.64	1.7970	–		483T-1.797
46.00	1.8110	–		483T-46
46.04	1.8125	1-13/16		483T-0126
46.83	1.8438	1-27/32		483T-0127
47.00	1.8504	–		483T-47
47.63	1.8750	1-7/8		483T-0128

A30: 112 - 143



A30: 82 - 85



A30: 4 - 6

HE, HI, HR, CR, SK,
BR, CI, NC, WCCoatings not listed above
can be supplied as
non-stocked standards.

Inserts sold in quantities of 1

TiN = 131T-XXXX

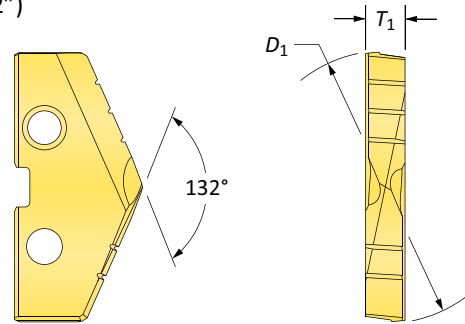
TiAlN = 131A-XXXX

TiCN = 131N-XXXX

AM200® = 131H-XXXX

T-A® Original Drill Inserts

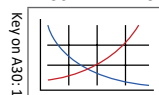
3 Series | HSS | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")



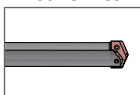
HSS Inserts – Super Cobalt

Insert				Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	TiN
35.72	1.4063	1-13/32	6.35	153T-0113
36.00	1.4173	–		153T-36
36.51	1.4375	1-7/16		153T-0114
37.00	1.4567	–		153T-37
37.31	1.4688	1-15/32		153T-0115
38.00	1.4961	–		153T-38
38.10	1.5000	1-1/2		153T-0116
38.89	1.5313	1-17/32		153T-0117
39.00	1.5354	–		153T-39
39.29	1.5470	–		153T-1.547
39.69	1.5625	1-9/16		153T-0118
40.00	1.5748	–		153T-40
40.48	1.5938	1-19/32		153T-0119
41.00	1.6142	–		153T-41
41.28	1.6250	1-5/8		153T-0120
42.00	1.6535	–		153T-42
42.07	1.6563	1-21/32		153T-0121
42.86	1.6875	1-11/16		153T-0122
43.00	1.6929	–		153T-43
43.66	1.7188	1-23/32		153T-0123
44.00	1.7323	–		153T-44
44.45	1.7500	1-3/4		153T-0124
45.00	1.7717	–		153T-45
45.24	1.7813	1-25/32		153T-0125
45.50	1.7913	–		153T-45.5
45.64	1.7970	–		153T-1.797
46.00	1.8110	–		153T-46
46.04	1.8125	1-13/16		153T-0126
46.83	1.8438	1-27/32		153T-0127
47.00	1.8504	–		153T-47
47.63	1.8750	1-7/8		153T-0128

A30: 112 - 143



A30: 82 - 85



A30: 4 - 6



HI, HR, CR, SK,
BR, CI, NC, WC

Coatings not listed above
can be supplied as
non-stocked standards.



Inserts sold in quantities of 1

TiN = 131T-XXXX

TiAlN = 131A-XXXX

TiCN = 131N-XXXX

AM200® = 131H-XXXX

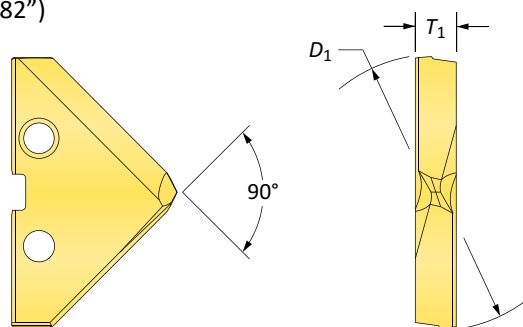


T-A® Original Drill Inserts

3 Series | HSS | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")



90° Spot & Chamfer



HSS Inserts – Super Cobalt

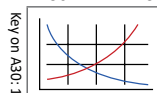
Insert				Part No.		
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	 TiN	 TiAlN	 TiCN
35.72	1.4063	1-13/32	6.35	153T-0113-SP	153A-0113-SP	153N-0113-SP
36.00	1.4173	–		153T-36-SP	153A-36-SP	153N-36-SP
36.51	1.4375	1-7/16		153T-0114-SP	153A-0114-SP	153N-0114-SP
37.00	1.4567	–		153T-37-SP	153A-37-SP	153N-37-SP
37.31	1.4688	1-15/32		153T-0115-SP	153A-0115-SP	153N-0115-SP
38.00	1.4961	–		153T-38-SP	153A-38-SP	153N-38-SP
38.10	1.5000	1-1/2		153T-0116-SP	153A-0116-SP	153N-0116-SP
38.89	1.5313	1-17/32		153T-0117-SP	153A-0117-SP	153N-0117-SP
39.00	1.5354	–		153T-39-SP	153A-39-SP	153N-39-SP
39.29	1.5470	–		153T-1.547-SP	153A-1.547-SP	153N-1.547-SP
39.69	1.5625	1-9/16		153T-0118-SP	153A-0118-SP	153N-0118-SP
40.00	1.5748	–		153T-40-SP	153A-40-SP	153N-40-SP
40.48	1.5938	1-19/32		153T-0119-SP	153A-0119-SP	153N-0119-SP
41.00	1.6142	–		153T-41-SP	153A-41-SP	153N-41-SP
41.28	1.6250	1-5/8		153T-0120-SP	153A-0120-SP	153N-0120-SP
42.00	1.6535	–		153T-42-SP	153A-42-SP	153N-42-SP
42.07	1.6563	1-21/32		153T-0121-SP	153A-0121-SP	153N-0121-SP
42.86	1.6875	1-11/16		153T-0122-SP	153A-0122-SP	153N-0122-SP
43.00	1.6929	–		153T-43-SP	153A-43-SP	153N-43-SP
43.66	1.7188	1-23/32		153T-0123-SP	153A-0123-SP	153N-0123-SP
44.00	1.7323	–		153T-44-SP	153A-44-SP	153N-44-SP
44.45	1.7500	1-3/4		153T-0124-SP	153A-0124-SP	153N-0124-SP
45.00	1.7717	–		153T-45-SP	153A-45-SP	153N-45-SP
45.24	1.7813	1-25/32		153T-0125-SP	153A-0125-SP	153N-0125-SP
45.50	1.7913	–		153T-45.5-SP	153A-45.5-SP	153N-45.5-SP
45.64	1.7970	–		153T-1.797-SP	153A-1.797-SP	153N-1.797-SP
46.00	1.8110	–		153T-46-SP	153A-46-SP	153N-46-SP
46.04	1.8125	1-13/16		153T-0126-SP	153A-0126-SP	153N-0126-SP
46.83	1.8438	1-27/32		153T-0127-SP	153A-0127-SP	153N-0127-SP
47.00	1.8504	–		153T-47-SP	153A-47-SP	153N-47-SP
47.63	1.8750	1-7/8		153T-0128-SP	153A-0128-SP	153N-0128-SP

Inserts sold in quantities of 1

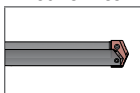
Coatings not listed above
can be supplied as
non-stocked standards.

TiN = 131T-XXXX	TiAlN = 131A-XXXX
TiCN = 131N-XXXX	AM200® = 131H-XXXX

A30: 112 - 143



A30: 82 - 85

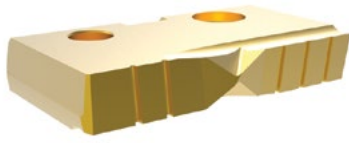


A30: 4 - 6

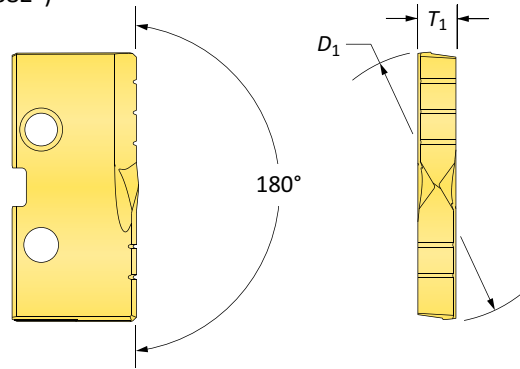


T-A® Original Drill Inserts

3 Series | HSS | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")

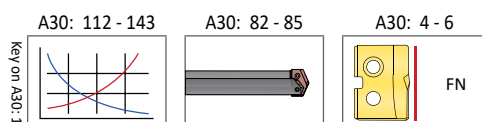


Flat Bottom



HSS Inserts – Super Cobalt

Insert				Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	TiN
35.72	1.4063	1-13/32	6.35	153T-0113-FB
36.00	1.4173	–		153T-36-FB
36.51	1.4375	1-7/16		153T-0114-FB
37.00	1.4567	–		153T-37-FB
37.31	1.4688	1-15/32		153T-0115-FB
38.00	1.4961	–		153T-38-FB
38.10	1.5000	1-1/2		153T-0116-FB
38.89	1.5313	1-17/32		153T-0117-FB
39.00	1.5354	–		153T-39-FB
39.29	1.5470	–		153T-1.547-FB
39.69	1.5625	1-9/16		153T-0118-FB
40.00	1.5748	–		153T-40-FB
40.48	1.5938	1-19/32		153T-0119-FB
41.00	1.6142	–		153T-41-FB
41.28	1.6250	1-5/8		153T-0120-FB
42.00	1.6535	–		153T-42-FB
42.07	1.6563	1-21/32		153T-0121-FB
42.86	1.6875	1-11/16		153T-0122-FB
43.00	1.6929	–		153T-43-FB
43.66	1.7188	1-23/32		153T-0123-FB
44.00	1.7323	–		153T-44-FB
44.45	1.7500	1-3/4		153T-0124-FB
45.00	1.7717	–		153T-45-FB
45.24	1.7813	1-25/32		153T-0125-FB
45.50	1.7913	–		153T-45.5-FB
45.64	1.7970	–		153T-1.797-FB
46.00	1.8110	–		153T-46-FB
46.04	1.8125	1-13/16		153T-0126-FB
46.83	1.8438	1-27/32		153T-0127-FB
47.00	1.8504	–		153T-47-FB
47.63	1.8750	1-7/8		153T-0128-FB



Coatings not listed above can be supplied as non-stocked standards.



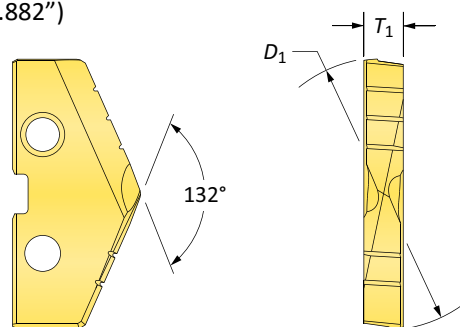
TiN = 131T-XXXX	TiAlN = 131A-XXXX
TiCN = 131N-XXXX	AM200® = 131H-XXXX

Inserts sold in quantities of 1

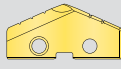
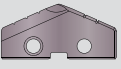


T-A® Original Drill Inserts

3 Series | Carbide | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")



Carbide Inserts – K20 (C2)

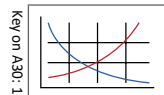
Insert				Part No.	
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	 TiN	 TiAlN
35.72	1.4063	1-13/32	6.35	1C23T-0113	1C23A-0113
36.00	1.4173	–		1C23T-36	1C23A-36
36.51	1.4375	1-7/16		1C23T-0114	1C23A-0114
37.00	1.4567	–		1C23T-37	1C23A-37
37.31	1.4688	1-15/32		1C23T-0115	1C23A-0115
38.00	1.4961	–		1C23T-38	1C23A-38
38.10	1.5000	1-1/2		1C23T-0116	1C23A-0116
38.89	1.5313	1-17/32		1C23T-0117	1C23A-0117
39.00	1.5354	–		1C23T-39	1C23A-39
39.29	1.5470	–		1C23T-1.547	1C23A-1.547
39.69	1.5625	1-9/16		1C23T-0118	1C23A-0118
40.00	1.5748	–		1C23T-40	1C23A-40
40.48	1.5938	1-19/32		1C23T-0119	1C23A-0119
41.00	1.6142	–		1C23T-41	1C23A-41
41.28	1.6250	1-5/8		1C23T-0120	1C23A-0120
42.00	1.6535	–		1C23T-42	1C23A-42
42.07	1.6563	1-21/32		1C23T-0121	1C23A-0121
42.86	1.6875	1-11/16		1C23T-0122	1C23A-0122
43.00	1.6929	–		1C23T-43	1C23A-43
43.66	1.7188	1-23/32		1C23T-0123	1C23A-0123
44.00	1.7323	–		1C23T-44	1C23A-44
44.45	1.7500	1-3/4		1C23T-0124	1C23A-0124
45.00	1.7717	–		1C23T-45	1C23A-45
45.24	1.7813	1-25/32		1C23T-0125	1C23A-0125
45.50	1.7913	–		1C23T-45.5	1C23A-45.5
45.64	1.7970	–		1C23T-1.797	1C23A-1.797
46.00	1.8110	–		1C23T-46	1C23A-46
46.04	1.8125	1-13/16		1C23T-0126	1C23A-0126
46.83	1.8438	1-27/32		1C23T-0127	1C23A-0127
47.00	1.8504	–		1C23T-47	1C23A-47
47.63	1.8750	1-7/8		1C23T-0128	1C23A-0128

Inserts sold in quantities of 1

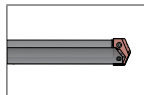
Coatings not listed above
can be supplied as
non-stocked standards.

TiN = 131T-XXXX	TiAlN = 131A-XXXX
TiCN = 131N-XXXX	AM200® = 131H-XXXX

A30: 112 - 143



A30: 82 - 85

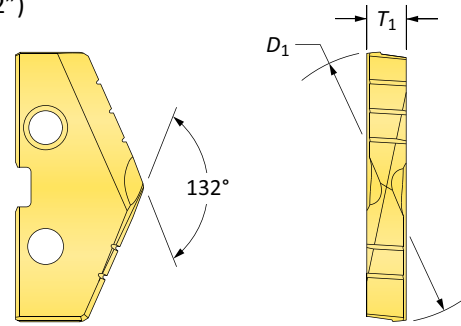
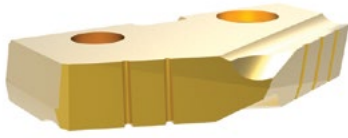


A30: 4 - 6

HI, HR, CR, SK,
NP, IN, RN, CN,
AN, BR, NC, WC

T-A® Original Drill Inserts

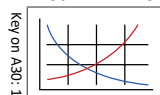
3 Series | HSS | Diameter Range: 34.36mm - 47.80mm (1.353" - 1.882")



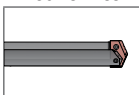
Carbide Inserts – P40 (C5)

Insert				Part No.	
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	TiN	TiAlN
35.72	1.4063	1-13/32	6.35	1C53T-0113	1C53A-0113
36.00	1.4173	–		1C53T-36	1C53A-36
36.51	1.4375	1-7/16		1C53T-0114	1C53A-0114
37.00	1.4567	–		1C53T-37	1C53A-37
37.31	1.4688	1-15/32		1C53T-0115	1C53A-0115
38.00	1.4961	–		1C53T-38	1C53A-38
38.10	1.5000	1-1/2		1C53T-0116	1C53A-0116
38.89	1.5313	1-17/32		1C53T-0117	1C53A-0117
39.00	1.5354	–		1C53T-39	1C53A-39
39.29	1.5470	–		1C53T-1.547	1C53A-1.547
39.69	1.5625	1-9/16		1C53T-0118	1C53A-0118
40.00	1.5748	–		1C53T-40	1C53A-40
40.48	1.5938	1-19/32		1C53T-0119	1C53A-0119
41.00	1.6142	–		1C53T-41	1C53A-41
41.28	1.6250	1-5/8		1C53T-0120	1C53A-0120
42.00	1.6535	–		1C53T-42	1C53A-42
42.07	1.6563	1-21/32		1C53T-0121	1C53A-0121
42.86	1.6875	1-11/16		1C53T-0122	1C53A-0122
43.00	1.6929	–		1C53T-43	1C53A-43
43.66	1.7188	1-23/32		1C53T-0123	1C53A-0123
44.00	1.7323	–		1C53T-44	1C53A-44
44.45	1.7500	1-3/4		1C53T-0124	1C53A-0124
45.00	1.7717	–		1C53T-45	1C53A-45
45.24	1.7813	1-25/32		1C53T-0125	1C53A-0125
45.50	1.7913	–		1C53T-45.5	1C53A-45.5
45.64	1.7970	–		1C53T-1.797	1C53A-1.797
46.00	1.8110	–		1C53T-46	1C53A-46
46.04	1.8125	1-13/16		1C53T-0126	1C53A-0126
46.83	1.8438	1-27/32		1C53T-0127	1C53A-0127
47.00	1.8504	–		1C53T-47	1C53A-47
47.63	1.8750	1-7/8		1C53T-0128	1C53A-0128

A30: 112 - 143



A30: 82 - 85



A30: 4 - 6



HI, HR, CR, SK,
NP, IN, RN, CN,
AN, BR, NC, WC

Coatings not listed above
can be supplied as
non-stocked standards.



Inserts sold in quantities of 1

TiN = 131T-XXXX	TiAlN = 131A-XXXX
TiCN = 131N-XXXX	AM200® = 131H-XXXX

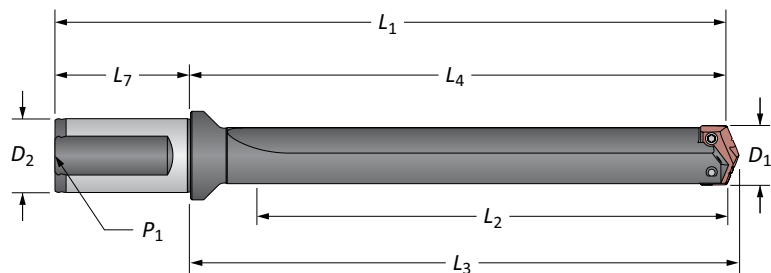


T-A® Drill Insert Holders

3 Series | Flanged Shank

A

DRILLING

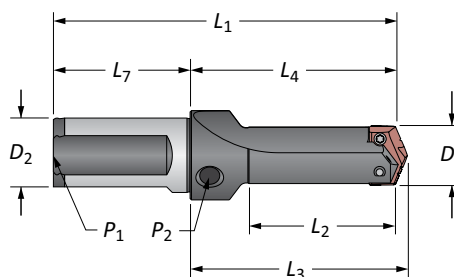


B

BORING



Stub Length



C

REAMING

Straight Flute

	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₄	L ₃	L ₁	D ₂	L ₇	P ₁	
m	Stub	36.0 - 47.0	76.2	125.0	129.8	195.0	40.0	70.0	1/4*	21030S-40FM
	Short	36.0 - 47.0	120.7	173.0	177.8	243.0	40.0	70.0	1/4*	22030S-40FM
	Extended	36.0 - 47.0	349.3	401.6	406.4	471.6	40.0	70.0	1/4*	25030S-40FM
	XL	36.0 - 47.0	558.8	611.1	615.9	681.1	40.0	70.0	1/4*	27030S-40FM
	3XL	36.0 - 47.0	787.4	839.7	844.5	909.7	40.0	70.0	1/4*	29030S-40FM
i	Stub	1-13/32 - 1-7/8	3	4-59/64	5-7/64	7-39/64	1-1/2	2-11/16	1/4	21030S-150F
	Short	1-13/32 - 1-7/8	4-3/4	6-13/16	7	9-1/2	1-1/2	2-11/16	1/4	22030S-150F
	Intermediate	1-13/32 - 1-7/8	6-1/2	8-9/16	8-3/4	11-1/4	1-1/2	2-11/16	1/4	23030S-150F
	Standard	1-13/32 - 1-7/8	8-1/4	10-5/16	10-1/2	13	1-1/2	2-11/16	1/4	24030S-150F

*Metric thread to BSP and ISO 7-1

NOTE: Stub length holders have a 1/4" side pipe tap (P₂)

D

BURNISHING

E

THREADING

Connection Accessories

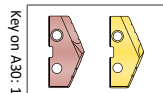
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7514-IP20-1	7514N-IP20-1	8IP-20	8IP-20TL	8IP-20B	1370 N-cm (121.3 in-lbs)

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

X

SPECIALS

A30: 74 - 81



m = Metric (mm)

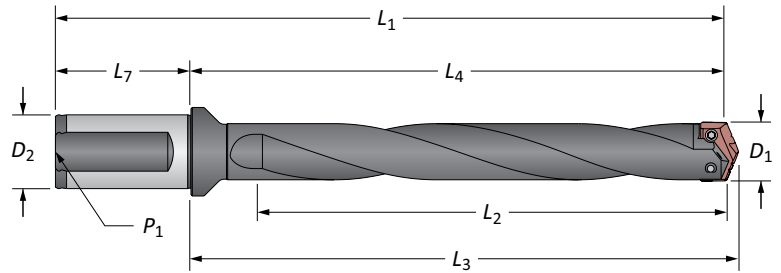
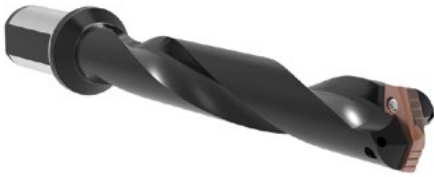
i = Imperial (in)

Screws sold in quantities of 10

WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A30: 150 for deep hole drilling guidelines in this section of the catalog. Visit www.alliedmachine.com for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

T-A® Drill Insert Holders

3 Series | Flanged Shank



Helical Flute

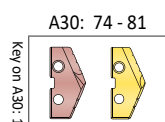
			Body				Shank			
Length		D_1	L_2	L_4	L_3	L_1	D_2	L_7	P_1	Part No.
m	Intermediate	36.0 - 47.0	165.1	217.5	222.3	287.5	40.0	70.0	1/4*	23030H-40FM
	Standard	36.0 - 47.0	209.6	261.9	266.7	331.9	40.0	70.0	1/4*	24030H-40FM
i	Intermediate	1-13/32 - 1-7/8	6-1/2	8-9/16	8-3/4	11-1/4	1-1/2	2-11/16	1/4	23030H-150F
	Standard	1-13/32 - 1-7/8	8-1/4	10-5/16	10-1/2	13	1-1/2	2-11/16	1/4	24030H-150F

*Metric thread to BSP and ISO 7-1

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	8IP-20TL	8IP-20B	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



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

Screws sold in quantities of 10

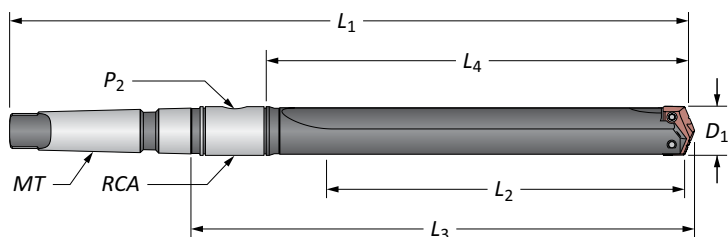


T-A® Drill Insert Holders

3 Series | Taper Shank

A

DRILLING



B

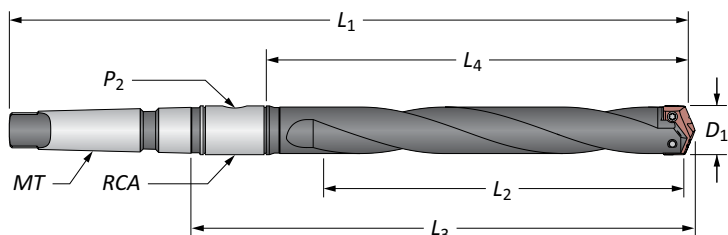
BORING

Straight Flute

	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₄	L ₃	L ₁	MT	P ₂	RCA	
M	Short	36.0 - 47.0	120.6	152.4	206.4	319.1	#4**	1/4*	2T-4SRM	22030S-004M
	Extended	36.0 - 47.0	349.3	381.0	435.0	547.7	#4**	1/4*	2T-4SRM	⚠ 25030S-004M
	XL	36.0 - 47.0	558.8	590.6	644.6	757.2	#4**	1/4*	2T-4SRM	⚠ 27030S-004M
	3XL	36.0 - 47.0	787.4	819.2	873.2	985.8	#4**	1/4*	2T-4SRM	⚠ 29030S-004M
I	Short	1-13/32 - 1-7/8	4-3/4	6	8-1/8	12-9/16	#4	1/4	2T-4SR	22030S-004I
	Short	1-13/32 - 1-7/8	4-3/4	6	8-1/8	13-13/16	#5	1/4	2T-5SR	22030S-005I
	Intermediate	1-13/32 - 1-7/8	6-1/2	7-3/4	9-7/8	14-5/16	#4	1/4	2T-4SR	23030S-004I
	Standard	1-13/32 - 1-7/8	8-1/4	9-1/2	11-5/8	16-1/16	#4	1/4	2T-4SR	24030S-004I
	Standard	1-13/32 - 1-7/8	8-1/4	9-1/2	11-5/8	17-5/16	#5	1/4	2T-5SR	24030S-005I
	Extended	1-13/32 - 1-7/8	13-3/4	15	17-1/8	21-9/16	#4	1/4	2T-4SR	⚠ 25030S-004I
	XL	1-13/32 - 1-7/8	22	22-1/4	25-3/8	29-13/16	#4	1/4	2T-4SR	⚠ 27030S-004I
	3XL	1-13/32 - 1-7/8	31	32-1/4	34-3/8	38-13/16	#4	1/4	2T-4SR	⚠ 29030S-004I

*Metric thread to BSP and ISO 7-1

**Per ISO 296 type BEK

C
REAMING

Helical Flute

	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₃	L ₄	L ₁	MT	P ₂	RCA	
M	Intermediate	36.0 - 47.0	165.1	196.9	250.9	363.6	#4	1/4*	2T-4SRM	23030H-004M
	Standard	36.0 - 47.0	209.5	241.3	295.3	408.0	#4	1/4*	2T-4SRM	24030H-004M

*Metric thread to BSP and ISO 7-1 | **Per ISO 296 type BEK

F

THREADING

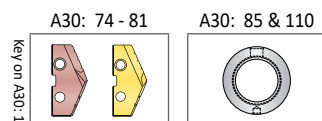
Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7514-IP20-1	7514N-IP20-1	8IP-20	8IP-20TL	8IP-20B	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

X

SPECIALS



M = Metric (mm)

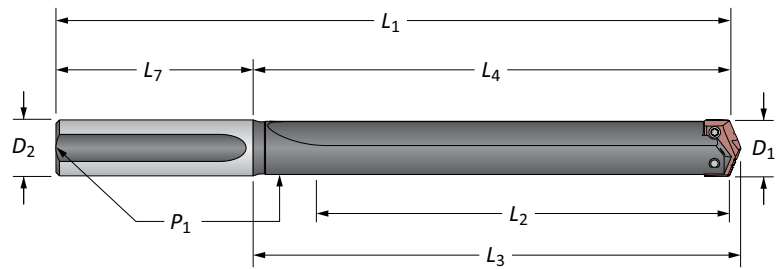
I = Imperial (in)

Screws sold in quantities of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A30: 150 for deep hole drilling guidelines in this section of the catalog. Visit www.alliedmachine.com for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

T-A® Drill Insert Holders

3 Series | Straight Shank



Straight Flute

	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₄	L ₃	L ₁	D ₂	L ₇	P ₁	
i	Short	1-13/32 - 1-7/8	4-3/4	6	6-3/16	10	1-1/4	4	1/4	22030S-125L
	Short	1-13/32 - 1-7/8	4-3/4	6	6-3/16	10	1-1/2	4	1/4	22030S-150L
	Intermediate	1-13/32 - 1-7/8	6-1/2	7-3/4	7-15/16	11-3/4	1-1/2	4	1/4	23030S-150L
	Standard	1-13/32 - 1-7/8	8-1/4	9-1/2	9-11/16	13-1/2	1-1/4	4	1/4	24030S-125L
	Standard	1-13/32 - 1-7/8	8-1/4	9-1/2	9-11/16	13-1/2	1-1/2	4	1/4	24030S-150L
	Extended	1-13/32 - 1-7/8	13-3/4	15-3/16	15-3/16	19	1-1/4	4	1/4	25030S-125L
	XL	1-13/32 - 1-7/8	22	23-7/16	23-7/16	27-1/4	1-1/2	4	1/4	27030S-150L
	3XL	1-13/32 - 1-7/8	31	32-7/16	32-7/16	36-1/4	1-1/2	4	1/4	29030S-150L

T-A® Drill Accessories

3 Series | Rotary Coolant Adapters | Torx® Plus Screws

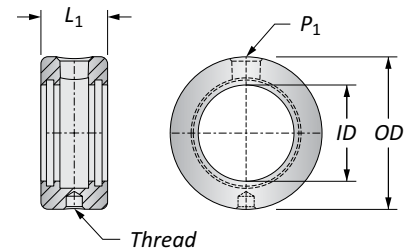
Rotary Coolant Adapter (RCA) and Accessories

	ID	OD	L ₁	Driving Rod Thread	P ₁	Part No.	RCA O-Rings	
							Kit Part No.**	Replacements
m	31.75	63.50	34.92	M10 x 1.50	1/4*	2T-4SRM	2T1-4SR	2T1-4OR-10
	44.45	76.20	34.92	M10 x 1.50	1/4*	2T-5SRM	2T1-5SR	2T1-5OR-10
i	1-1/4	2-1/2	1-3/8	3/8-16	1/4	2T-4SR	2T1-4SR	2T1-4OR-10
	1-3/4	3	1-3/8	3/8-16	1/4	2T-5SR	2T1-5SR	2T1-5OR-10

*Thread to BSP and ISO 7-1

**RCA Repair Kit includes (2) O-rings, (2) snap rings, and (2) thrust washers

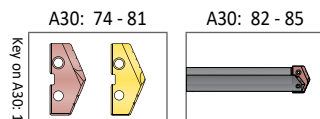
Refer to page A30: 110 for proper RCA assembly and safety information



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	8IP-20TL	8IP-20B	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



m = Metric (mm)

i = Imperial (in)

Inserts sold separately
Screws sold in packs of 10
O-rings sold in packs of 10

WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A30: 150 for deep hole drilling guidelines in this section of the catalog. Visit www.alliedmachine.com for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.