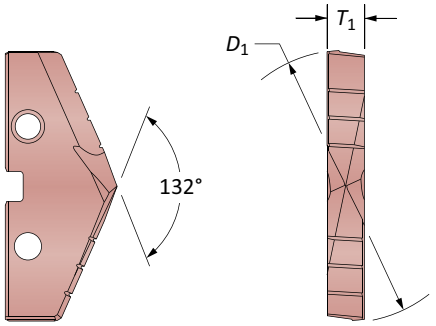
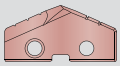
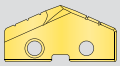
GEN2 T-A® Drill Inserts

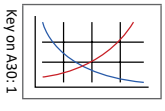
4 Series | HSS | Diameter Range: 46.99mm - 65.28mm (1.850" - 2.570")



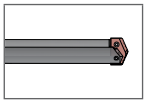
HSS Inserts – Super Cobalt

Insert				Part No.	
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	 AM200®	 TiN
48.00	1.8898	–	7.94	**454H-48**	**454T-48**
48.42	1.9063	1-29/32		**454H-0129**	**454T-0129**
49.00	1.9291	–		**454H-49**	**454T-49**
49.21	1.9375	1-15/16		**454H-0130**	**454T-0130**
50.00	1.9685	–		**454H-50**	**454T-50**
50.01	1.9688	1-31/32		**454H-0131**	**454T-0131**
50.80	2.0000	2		**454H-0200**	**454T-0200**
51.00	2.0079	–		**454H-51**	**454T-51**
51.59	2.0313	2-1/32		**454H-0201**	**454T-0201**
52.00	2.0472	2-3/64		**454H-52**	**454T-52**
52.39	2.0625	2-1/16		**454H-0202**	**454T-0202**
53.00	2.0866	–		**454H-53**	**454T-53**
53.18	2.0938	2-3/32		**454H-0203**	**454T-0203**
53.98	2.1250	2-1/8		**454H-0204**	**454T-0204**
54.00	2.1260	–		**454H-54**	**454T-54**
54.77	2.1563	2-5/32		**454H-0205**	**454T-0205**
55.00	2.1654	–		**454H-55**	**454T-55**
55.56	2.1875	2-3/16		**454H-0206**	**454T-0206**
56.00	2.2047	–		**454H-56**	**454T-56**
56.36	2.2188	2-7/32		**454H-0207**	**454T-0207**
57.00	2.2441	–		**454H-57**	**454T-57**
57.15	2.2500	2-1/4		**454H-0208**	**454T-0208**
57.94	2.2813	2-9/32		**454H-0209**	**454T-0209**
58.00	2.2835	–		**454H-58**	**454T-58**
58.74	2.3125	2-5/16		**454H-0210**	**454T-0210**
59.00	2.3228	–		**454H-59**	**454T-59**
59.53	2.3438	2-11/32		**454H-0211**	**454T-0211**
60.00	2.3622	–		**454H-60**	**454T-60**
60.33	2.3750	2-3/8		**454H-0212**	**454T-0212**
61.00	2.4016	–		**454H-61**	**454T-61**
61.12	2.4063	2-13/32		**454H-0213**	**454T-0213**
61.91	2.4375	2-7/16		**454H-0214**	**454T-0214**
62.00	2.4409	–		**454H-62**	**454T-62**
62.71	2.4688	2-15/32		**454H-0215**	**454T-0215**
63.00	2.4803	–		**454H-63**	**454T-63**
63.50	2.5000	2-1/2		**454H-0216**	**454T-0216**
64.00	2.5197	–		**454H-64**	**454T-64**
64.29	2.5313	2-17/32		**454H-0217**	**454T-0217**
65.00	2.5591	–		**454H-65**	**454T-65**
65.09	2.5625	2-9/16		**454H-0218**	**454T-0218**

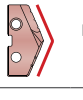
A30: 112 - 143



A30: 90 - 92



A30: 4 - 6



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

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

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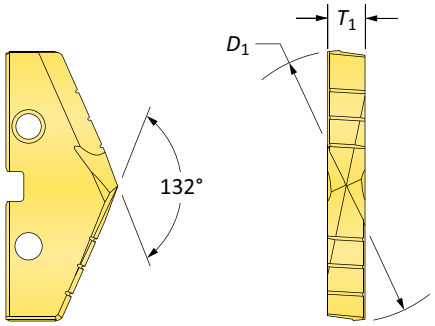
GEN2 T-A® Drill Inserts

4 Series | HSS | Diameter Range: 46.99mm - 65.28mm (1.850” - 2.570”)

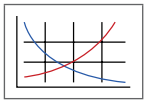


HSS Inserts – HSS

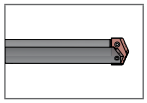
Insert				Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	TiN
48.00	1.8898	–	7.94	**434T-48**
48.42	1.9063	1-29/32		**434T-0129**
49.00	1.9291	–		**434T-49**
49.21	1.9375	1-15/16		**434T-0130**
50.00	1.9685	–		**434T-50**
50.01	1.9688	1-31/32		**434T-0131**
50.80	2.0000	2		**434T-0200**
51.00	2.0079	–		**434T-51**
51.59	2.0313	2-1/32		**434T-0201**
52.00	2.0472	2-3/64		**434T-52**
52.39	2.0625	2-1/16		**434T-0202**
53.00	2.0866	–		**434T-53**
53.18	2.0938	2-3/32		**434T-0203**
53.98	2.1250	2-1/8		**434T-0204**
54.00	2.1260	–		**434T-54**
54.77	2.1563	2-5/32		**434T-0205**
55.00	2.1654	–		**434T-55**
55.56	2.1875	2-3/16		**434T-0206**
56.00	2.2047	–		**434T-56**
56.36	2.2188	2-7/32		**434T-0207**
57.00	2.2441	–		**434T-57**
57.15	2.2500	2-1/4		**434T-0208**
57.94	2.2813	2-9/32		**434T-0209**
58.00	2.2835	–		**434T-58**
58.74	2.3125	2-5/16		**434T-0210**
59.00	2.3228	–		**434T-59**
59.53	2.3438	2-11/32		**434T-0211**
60.00	2.3622	–		**434T-60**
60.33	2.3750	2-3/8		**434T-0212**
61.00	2.4016	–		**434T-61**
61.12	2.4063	2-13/32		**434T-0213**
61.91	2.4375	2-7/16		**434T-0214**
62.00	2.4409	–		**434T-62**
62.71	2.4688	2-15/32		**434T-0215**
63.00	2.4803	–		**434T-63**
63.50	2.5000	2-1/2		**434T-0216**
64.00	2.5197	–		**434T-64**
64.29	2.5313	2-17/32		**434T-0217**
65.00	2.5591	–		**434T-65**
65.09	2.5625	2-9/16		**434T-0218**

A30: 112 - 143

Key on A30: 1



A30: 90 - 92



A30: 4 - 6

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

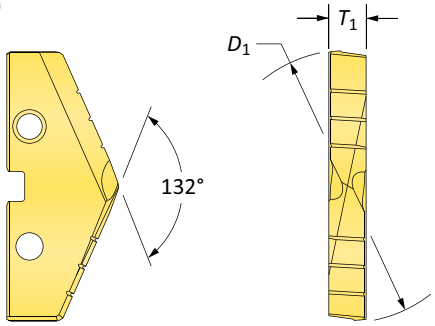
Inserts sold in quantities of 1

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

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

T-A® Original Drill Inserts

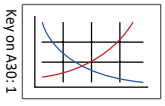
4 Series | HSS | Diameter Range: 46.99mm - 65.28mm (1.850” - 2.570”)



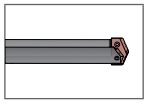
HSS Inserts – Super Cobalt

Insert				Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	TiN
48.00	1.8898	–	7.94	**154T-48**
48.42	1.9063	1-29/32		**154T-0129**
49.00	1.9291	–		**154T-49**
49.21	1.9375	1-15/16		**154T-0130**
50.00	1.9685	–		**154T-50**
50.01	1.9688	1-31/32		**154T-0131**
50.80	2.0000	2		**154T-0200**
51.00	2.0079	–		**154T-51**
51.59	2.0313	2-1/32		**154T-0201**
52.00	2.0472	2-3/64		**154T-52**
52.39	2.0625	2-1/16		**154T-0202**
53.00	2.0866	–		**154T-53**
53.18	2.0938	2-3/32		**154T-0203**
53.98	2.1250	2-1/8		**154T-0204**
54.00	2.1260	–		**154T-54**
54.77	2.1563	2-5/32		**154T-0205**
55.00	2.1654	–		**154T-55**
55.56	2.1875	2-3/16		**154T-0206**
56.00	2.2047	–		**154T-56**
56.36	2.2188	2-7/32		**154T-0207**
57.00	2.2441	–		**154T-57**
57.15	2.2500	2-1/4		**154T-0208**
57.94	2.2813	2-9/32		**154T-0209**
58.00	2.2835	–		**154T-58**
58.74	2.3125	2-5/16		**154T-0210**
59.00	2.3228	–		**154T-59**
59.53	2.3438	2-11/32		**154T-0211**
60.00	2.3622	–		**154T-60**
60.33	2.3750	2-3/8		**154T-0212**
61.00	2.4016	–		**154T-61**
61.12	2.4063	2-13/32		**154T-0213**
61.91	2.4375	2-7/16		**154T-0214**
62.00	2.4409	–		**154T-62**
62.71	2.4688	2-15/32		**154T-0215**
63.00	2.4803	–		**154T-63**
63.50	2.5000	2-1/2		**154T-0216**
64.00	2.5197	–		**154T-64**
64.29	2.5313	2-17/32		**154T-0217**
65.00	2.5591	–		**154T-65**
65.09	2.5625	2-9/16		**154T-0218**

A30: 112 - 143



A30: 90 - 92



A30: 4 - 6

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

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

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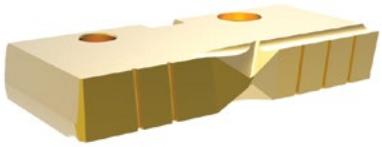
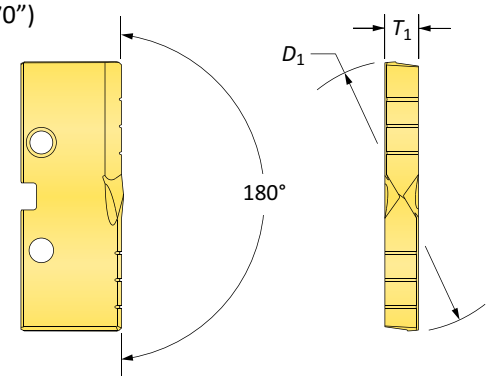
T-A® Original Drill Inserts

4 Series | HSS | Diameter Range: 46.99mm - 65.28mm (1.850” - 2.570”)



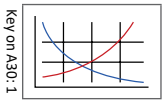
Flat Bottom



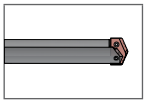
HSS Inserts – Super Cobalt

Insert				Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	TiN
48.00	1.8898	–	7.94	**154T-48-FB**
48.42	1.9063	1-29/32		**154T-0129-FB**
49.00	1.9291	–		**154T-49-FB**
49.21	1.9375	1-15/16		**154T-0130-FB**
50.00	1.9685	–		**154T-50-FB**
50.01	1.9688	1-31/32		**154T-0131-FB**
50.80	2.0000	2		**154T-0200-FB**
51.00	2.0079	–		**154T-51-FB**
51.59	2.0313	2-1/32		**154T-0201-FB**
52.00	2.0472	2-3/64		**154T-52-FB**
52.39	2.0625	2-1/16		**154T-0202-FB**
53.00	2.0866	–		**154T-53-FB**
53.18	2.0938	2-3/32		**154T-0203-FB**
53.98	2.1250	2-1/8		**154T-0204-FB**
54.00	2.1260	–		**154T-54-FB**
54.77	2.1563	2-5/32		**154T-0205-FB**
55.00	2.1654	–		**154T-55-FB**
55.56	2.1875	2-3/16		**154T-0206-FB**
56.00	2.2047	–		**154T-56-FB**
56.36	2.2188	2-7/32		**154T-0207-FB**
57.00	2.2441	–		**154T-57-FB**
57.15	2.2500	2-1/4		**154T-0208-FB**
57.94	2.2813	2-9/32		**154T-0209-FB**
58.00	2.2835	–		**154T-58-FB**
58.74	2.3125	2-5/16		**154T-0210-FB**
59.00	2.3228	–		**154T-59-FB**
59.53	2.3438	2-11/32		**154T-0211-FB**
60.00	2.3622	–		**154T-60-FB**
60.33	2.3750	2-3/8		**154T-0212-FB**
61.00	2.4016	–		**154T-61-FB**
61.12	2.4063	2-13/32		**154T-0213-FB**
61.91	2.4375	2-7/16		**154T-0214-FB**
62.00	2.4409	–		**154T-62-FB**
62.71	2.4688	2-15/32		**154T-0215-FB**
63.00	2.4803	–		**154T-63-FB**
63.50	2.5000	2-1/2		**154T-0216-FB**
64.00	2.5197	–		**154T-64-FB**
64.29	2.5313	2-17/32		**154T-0217-FB**
65.00	2.5591	–		**154T-65-FB**
65.09	2.5625	2-9/16		**154T-0218-FB**

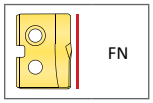
A30: 112 - 143



A30: 90 - 92



A30: 4 - 6



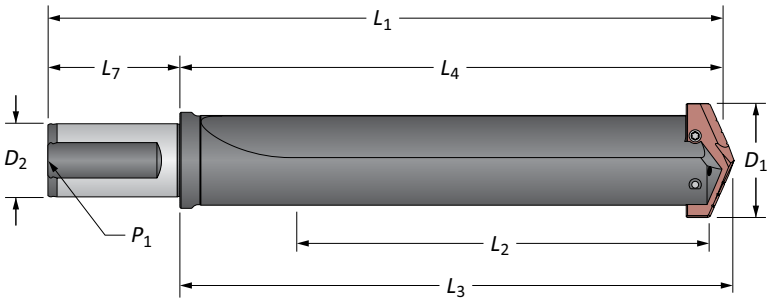
Inserts sold in quantities of 1

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

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

T-A® Drill Insert Holders

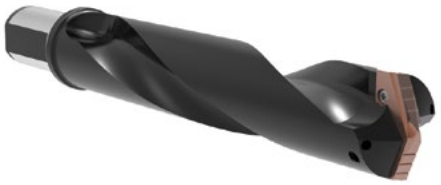
4 Series | Flanged Shank

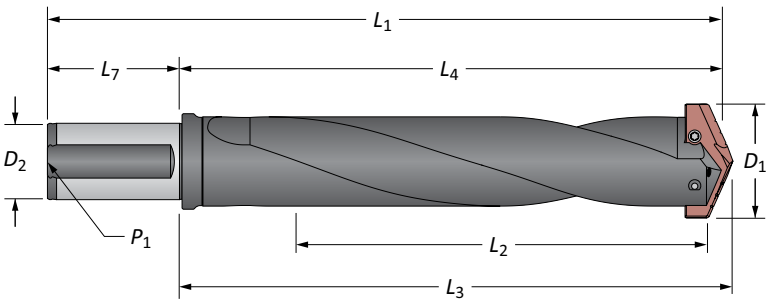


Straight Flute

	Length	D_1	Body L_2	Body L_4	Body L_3	Body L_1	Shank D_2	Shank L_7	Shank P_1	Part No.
m	Short	48.0 - 65.0	130.2	179.4	184.0	249.4	40.0	70.0	1/4*	**22040S-40FM**
m	Extended	48.0 - 65.0	422.3	471.5	476.0	541.5	40.0	70.0	1/4*	⚠ **25040S-40FM**
m	XL	48.0 - 65.0	625.0	674.7	679.0	744.7	40.0	70.0	1/4*	⚠ **27040S-40FM**
m	3XL	48.0 - 65.0	879.0	928.7	933.0	998.7	40.0	70.0	1/4*	⚠ **29040S-40FM**
i	Short	1-29/32 - 2-9/16	5-1/8	7-1/6	7-1/4	9-3/4	1-1/2	2-11/16	1/4	**22040S-150F**
i	Standard	1-29/32 - 2-9/16	9-1/8	11-1/16	11-1/4	13-3/4	1-1/2	2-11/16	1/4	**24040S-150F**

*Metric thread to BSP and ISO 7-1





Helical Flute

	Length	D_1	Body L_2	Body L_4	Body L_3	Body L_1	Shank D_2	Shank L_7	Shank P_1	Part No.
m	Standard	48.0 - 65.0	231.8	281.0	285.8	351.0	40.0	70.0	1/4*	**24040H-40FM**
i	Standard	1-29/32 - 2-9/16	9-1/8	11-1/16	11-1/4	13-3/4	1-1/2	2-11/16	1/4	**24040H-150F**

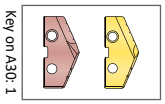
*Metric thread to BSP and ISO 7-1

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 μ = 0.14 and develop 90% of ultimate yield strength

A30: 86 - 89

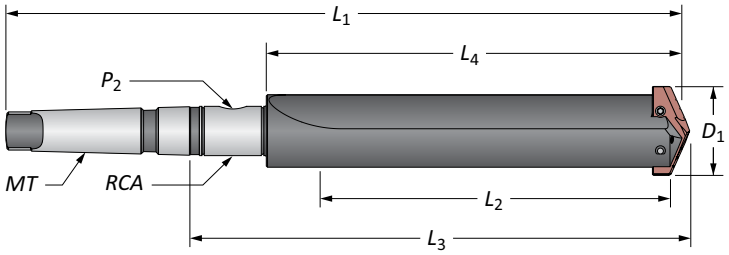


m = Metric (mm)
i = Imperial (in)
Screws sold in quantities of 10

⚠ **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

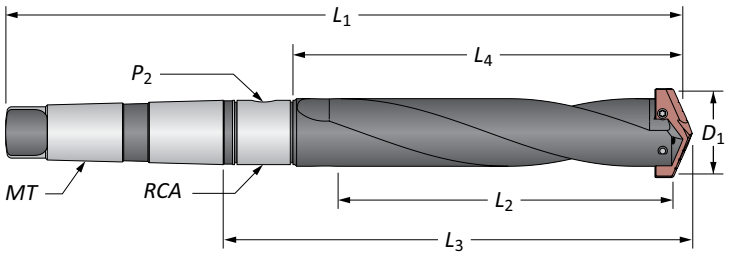
4 Series | Taper Shank



Straight Flute

	Length	D_1	Body L_2	Body L_4	Body L_4	Body L_1	Shank MT	Shank P_2	Shank RCA	Part No.
ⓜ	Short	48.0 - 65.0	130.1	165.1	219.1	363.5	#5**	1/4*	2T-5SRM	**22040S-005M**
ⓜ	Extended	48.0 - 65.0	422.3	457.2	511.2	655.6	#5**	1/4*	2T-5SRM	⚠ **25040S-005M**
ⓜ	XL	48.0 - 65.0	625.0	660.4	714.4	858.8	#5**	1/4*	2T-5SRM	⚠ **27040S-005M**
ⓜ	3XL	48.0 - 65.0	879.0	914.4	968.4	1112.8	#5**	1/4*	2T-5SRM	⚠ **29040S-005M**
ⓘ	Short	1-29/32 - 2-9/16	5-1/8	6-1/2	8-5/8	13-1/16	#4	1/4	2T-4SR	**22040S-004I**
ⓘ	Short	1-29/32 - 2-9/16	5-1/8	6-1/2	8-5/8	14-5/16	#5	1/4	2T-5SR	**22040S-005I**
ⓘ	Standard	1-29/32 - 2-9/16	9-1/8	10-1/2	12-5/8	17-1/16	#4	1/4	2T-4SR	**24040S-004I**
ⓘ	Standard	1-29/32 - 2-9/16	9-1/8	10-1/2	12-5/8	18-5/16	#5	1/4	2T-5SR	**24040S-005I**
ⓘ	Extended	1-29/32 - 2-9/16	16-5/8	18	20-1/8	25-13/16	#5	1/4	2T-5SR	⚠ **25040S-005I**
ⓘ	XL	1-29/32 - 2-9/16	24-5/8	26	28-1/8	33-13/16	#5	1/4	2T-5SR	⚠ **27040S-005I**
ⓘ	3XL	1-29/32 - 2-9/16	34-5/8	36	38-1/8	43-13/16	#5	1/4	2T-5SR	⚠ **29040S-005I**

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

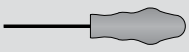
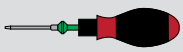


Helical Flute

	Length	D_1	Body L_2	Body L_3	Body L_4	Body L_1	Shank MT	Shank P_2	Shank RCA	Part No.
ⓜ	Standard	48.0 - 65.0	231.8	266.7	320.7	465.1	#5**	1/4*	2T-5SRM	**24040H-005M**

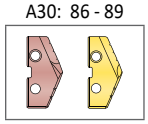
*Metric thread to BSP and ISO 7-1
**Per ISO 296 type BEK

Connection Accessories

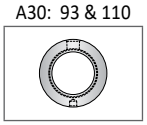
Insert Screws	Nylon Locking Screws	 Insert Driver	 Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7514-IP20-1	7514N-IP20-1	8IP-20	8IP-20TL	8IP-20B	1370 N-cm (121.3 in-lbs)

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

A30: 86 - 89



A30: 93 & 110

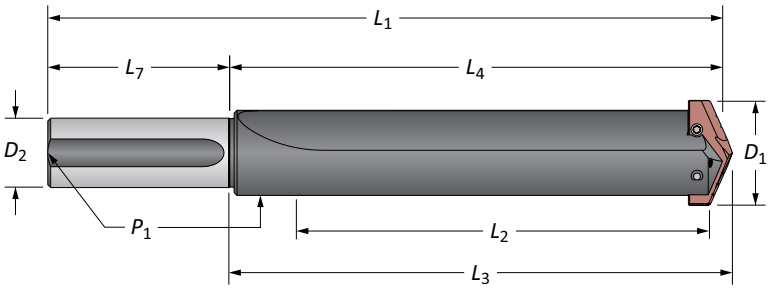


ⓜ = Metric (mm)
ⓘ = Imperial (in)
Screws sold in quantities of 10

⚠ **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

4 Series | Straight Shank



Straight Flute

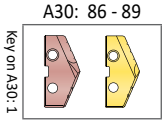
	Length	D_1	Body L_2	Body L_4	Body L_3	Body L_1	Shank D_2	Shank L_7	Shank P_1	Part No.
	Short	1-29/32 - 2-9/16	5-1/8	6-1/2	6-11/16	10-1/2	1-1/2	4	1/4	**22040S-150L**
	Short	1-29/32 - 2-9/16	5-1/8	6-1/2	6-11/16	10-1/2	1-3/4	4	1/4	**22040S-175L**
	Standard	1-29/32 - 2-9/16	9-1/8	10-1/2	10-11/16	14-1/2	1-1/2	4	1/4	**24040S-150L**
ⓘ	Standard	1-29/32 - 2-9/16	9-1/8	10-1/2	10-11/16	14-1/2	1-3/4	4	1/4	**24040S-175L**
	Extended	1-29/32 - 2-9/16	16-5/8	18	18-3/16	22	1-1/2	4	1/4	⚠ **25040S-150L**
	XL	1-29/32 - 2-9/16	24-5/8	26	26-3/16	30	1-1/2	4	1/4	⚠ **27040S-150L**
	3XL	1-29/32 - 2-9/16	34-5/8	36	36-3/16	40	1-1/2	4	1/4	⚠ **29040S-150L**

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 μ = 0.14 and develop 90% of ultimate yield strength

A30: 86 - 89



ⓜ = Metric (mm)
ⓘ = Imperial (in)
Screws sold in quantities of 10

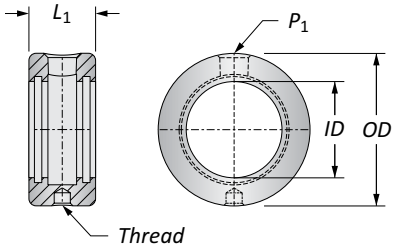
⚠ **WARNING** Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A30: 150 for deep hole drilling guidelines in this section of the catalog. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available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

T-A® Drill Accessories

4 Series | Rotary Coolant Adapters | Torx® Plus Screws

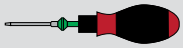
Rotary Coolant Adapter (RCA) and Accessories

	ID	*OD*	L_1	Driving Rod Thread	P_1	Part No.	RCA O-Rings	
							Kit Part No.**	Replacements
ⓜ	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
ⓘ	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



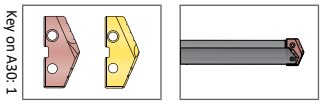
*Thread to BSP and ISO 7-1
**RCA Repair Kit includes (2) O-rings, (2) snap rings, and (2) thrust washers
⚠ Refer to page A30: 110 for proper RCA assembly and safety information

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 μ = 0.14 and develop 90% of ultimate yield strength

A30: 86 - 89
A30: 90 - 92
Key on A30: 1



ⓜ = Metric (mm)
ⓘ = Imperial (in)
Inserts sold separately
Screws sold in packs of 10
O-rings sold in packs of 10

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