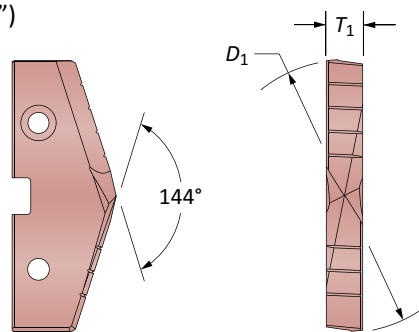




GEN2 T-A® Drill Inserts

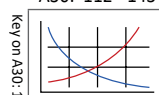
7 Series | HSS | Diameter Range: 89.10mm - 101.60mm (3.508" - 4.000")



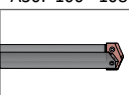
HSS Inserts – Super Cobalt | HSS

Insert				Super Cobalt Part No.	HSS Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	AM200®	TiN
89.69	3.5313	3-17/32	11.11	457H-0317	437T-0317
90.00	3.5433	–		457H-90	437T-90
90.49	3.5625	3-9/16		457H-0318	437T-0318
91.28	3.5938	3-19/32		457H-0319	437T-0319
92.00	3.6221	–		457H-92	437T-92
92.08	3.6250	3-5/8		457H-0320	437T-0320
92.87	3.6563	3-21/32		457H-0321	437T-0321
93.66	3.6875	3-11/16		457H-0322	437T-0322
94.00	3.7008	–		457H-94	437T-94
94.46	3.7188	3-23/32		457H-0323	437T-0323
95.25	3.7500	3-3/4		457H-0324	437T-0324
96.00	3.7795	–		457H-96	437T-96
96.04	3.7813	3-25/32		457H-0325	437T-0325
96.84	3.8125	3-13/16		457H-0326	437T-0326
97.63	3.8438	3-27/32		457H-0327	437T-0327
98.00	3.8583	–		457H-98	437T-98
98.43	3.8750	3-7/8		457H-0328	437T-0328
99.22	3.9063	3-29/32		457H-0329	437T-0329
100.00	3.9370	–		457H-100	437T-100
100.01	3.9375	3-15/16		457H-0330	437T-0330
100.81	3.9688	3-31/32		457H-0331	437T-0331
101.60	4.0000	4		457H-0400	437T-0400

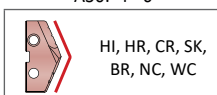
A30: 112 - 143



A30: 106 - 108



A30: 4 - 6

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

Inserts sold in quantities of 1

TiN = 131T-XXXX

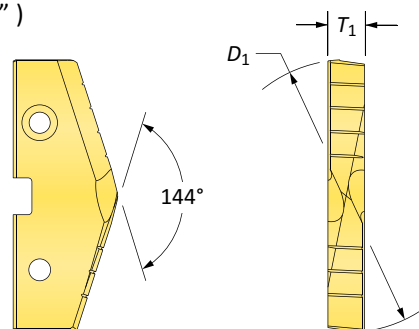
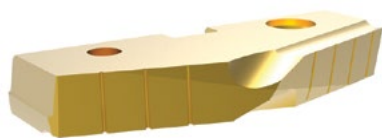
TiAlN = 131A-XXXX

TiCN = 131N-XXXX

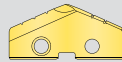
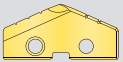
AM200® = 131H-XXXX

T-A® Original Drill Inserts

7 Series | HSS | Diameter Range: 89.10mm - 101.60mm (3.508" - 4.000")

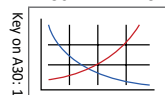


HSS Inserts – Super Cobalt | HSS

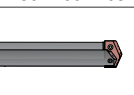
Insert				Super Cobalt Part No.*	HSS Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	 TiN	 TiN
89.69	3.5313	3-17/32	11.11	157T-0317	137T-0317
90.00	3.5433	–		157T-90	137T-90
90.49	3.5625	3-9/16		157T-0318	137T-0318
91.28	3.5938	3-19/32		157T-0319	137T-0319
92.00	3.6221	–		157T-92	137T-92
92.08	3.6250	3-5/8		157T-0320	137T-0320
92.87	3.6563	3-21/32		157T-0321	137T-0321
93.66	3.6875	3-11/16		157T-0322	137T-0322
94.00	3.7008	–		157T-94	137T-94
94.46	3.7188	3-23/32		157T-0323	137T-0323
95.25	3.7500	3-3/4		157T-0324	137T-0324
96.00	3.7795	–		157T-96	137T-96
96.04	3.7813	3-25/32		157T-0325	137T-0325
96.84	3.8125	3-13/16		157T-0326	137T-0326
97.63	3.8438	3-27/32		157T-0327	137T-0327
98.00	3.8583	–		157T-98	137T-98
98.43	3.8750	3-7/8		157T-0328	137T-0328
99.22	3.9063	3-29/32		157T-0329	137T-0329
100.00	3.9370	–		157T-100	137T-100
100.01	3.9375	3-15/16		157T-0330	137T-0330
100.81	3.9688	3-31/32		157T-0331	137T-0331
101.60	4.0000	4		157T-0400	137T-0400

*Available as non-stocked standard

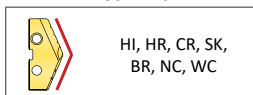
A30: 112 - 143



A30: 106 - 108



A30: 4 - 6

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

Inserts sold in quantities of 1

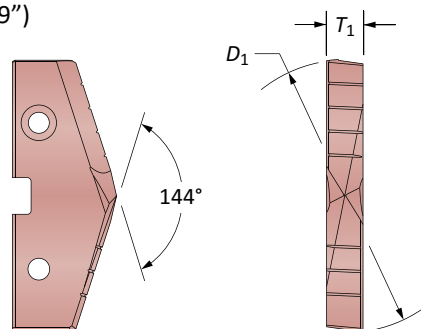
TiN = 131T-XXXX	TiAlN = 131A-XXXX
TiCN = 131N-XXXX	AM200® = 131H-XXXX



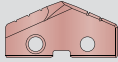
GEN2 T-A® Drill Inserts

8 Series | HSS | Diameter Range: 101.63mm - 160.00mm (4.001" - 6.299")

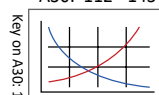
(for use with 7 series holders)



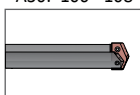
HSS Inserts – Super Cobalt | HSS

Insert				Super Cobalt Part No.	HSS Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	 AM200®	 TiN
102.00	4.0157	4-1/64	11.11	458H-102	438T-102
103.19	4.0625	4-1/16		458H-0402	438T-0402
104.00	4.0945	4-3/32		458H-104	438T-104
104.75	4.1250	4-1/8		458H-0404	438T-0404
106.00	4.1732	–		458H-106	438T-106
106.36	4.1875	4-3/16		458H-0406	438T-0406
107.95	4.2500	4-1/4		458H-0408	438T-0408
108.00	4.2520	–		458H-108	438T-108
109.54	4.3125	4-5/16		458H-0410	438T-0410
110.00	4.3307	–		458H-110	438T-110
111.13	4.3750	4-3/8		458H-0412	438T-0412
112.00	4.4094	–		458H-112	438T-112
112.71	4.4375	4-7/16		458H-0414	438T-0414
114.00	4.4882	–		458H-114	438T-114
114.30	4.5000	4-1/2		458H-0416	438T-0416

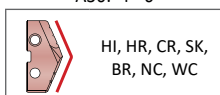
A30: 112 - 143



A30: 106 - 108



A30: 4 - 6



HI, HR, CR, SK,
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

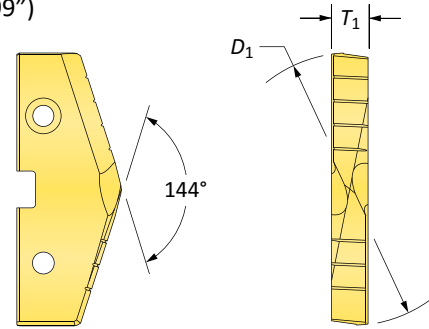
TiCN = 131N-XXXX

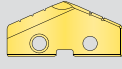
AM200® = 131H-XXXX

T-A® Original Drill Inserts

8 Series | HSS | Diameter Range: 101.63mm - 160.00mm (4.001" - 6.299")

(for use with 7 series holders)

**HSS Inserts – Super Cobalt | HSS**

Insert				Super Cobalt Part No.*	HSS Part No.
D_1 mm	D_1 inch	Fractional Equivalent	T_1 mm	 TiN	 TiN
102.00	4.0157	4-1/64	11.11	158T-102	138T-102
103.19	4.0625	4-1/16		158T-0402	138T-0402
104.00	4.0945	4-3/32		158T-104	138T-104
104.75	4.1250	4-1/8		158T-0404	138T-0404
106.00	4.1732	–		158T-106	138T-106
106.36	4.1875	4-3/16		158T-0406	138T-0406
107.95	4.2500	4-1/4		158T-0408	138T-0408
108.00	4.2520	–		158T-108	138T-108
109.54	4.3125	4-5/16		158T-0410	138T-0410
110.00	4.3307	–		158T-110	138T-110
111.13	4.3750	4-3/8		158T-0412	138T-0412
112.00	4.4094	–		158T-112	138T-112
112.71	4.4375	4-7/16		158T-0414	138T-0414
114.00	4.4882	–		158T-114	138T-114
114.30	4.5000	4-1/2		158T-0416	138T-0416

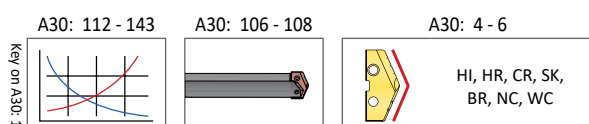
*Available as non-stocked standard

DOUBLE WIDE (Oversized)

Grade	Diameter		Part Number & Coating
	mm	Inch	AM200®
HSS Super Cobalt	110.00	4.3307	158H-110-DW
	120.00	4.7244	158H-120-DW
	125.00	4.9213	158H-125-DW
	130.00	5.1181	158H-130-DW
	140.00	5.5118	158H-140-DW
	150.00	5.9055	158H-150-DW
	160.00	6.2992	158H-160-DW

*Available as non-stocked standard. Additional Diameters up to 200mm available on request.
120mm maximum diameter for Stainless Steel

Supplied in packs of 1

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

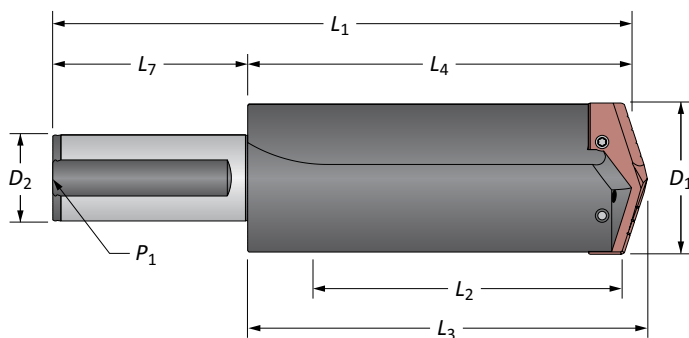


T-A® Drill Insert Holders

7 Series | Flanged Shank

A

DRILLING



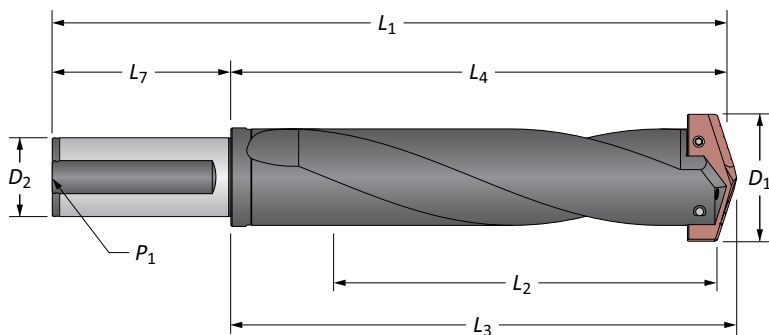
Straight Flute

Length		D_1	Body				Shank			Part No.
m			L_2	L_4	L_3	L_1	D_2	L_7	P_1	
	Short	90.0 - 114.0	172	225.4	231.8	311.8	50.0	80.0	1/2*	22070S-50FM
	Extended	90.0 - 114.0	556	606.9	616	696	50.0	80.0	1/2*	25070S-50FM
i	Short	3-17/32 - 4-1/2	6-49/64	8-7/8	9-1/8	13-5/8	2	4-1/2	1/2	22070S-200F
	Extended	3-17/32 - 4-1/2	21-57/64	23-57/64	24-1/4	27-3/4	2	4-1/2	1/2	25070S-200F

*Metric thread to BSP and ISO 7-1

C

REAMING



Helical Flute

Length		D_1	Body				Shank			Part No.
m			L_2	L_4	L_3	L_1	D_2	L_7	P_1	
	Standard	90.0 - 114.0	273	327	333.4	413.4	50.0	80.0	1/2*	24070H-50FM
i	Standard	3-17/32 - 4-1/2	10-3/4	12-7/8	13-1/8	17-5/8	2	4-1/2	1/2	24070H-200F

*Metric thread to BSP and ISO 7-1

F

THREADING

Connection Accessories

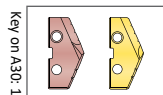
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7619-IP25-1	—	8IP-25	—	—	1750 N-cm (155.0 in-lbs)

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

X

SPECIALS

A30: 102 - 105



m = Metric (mm)

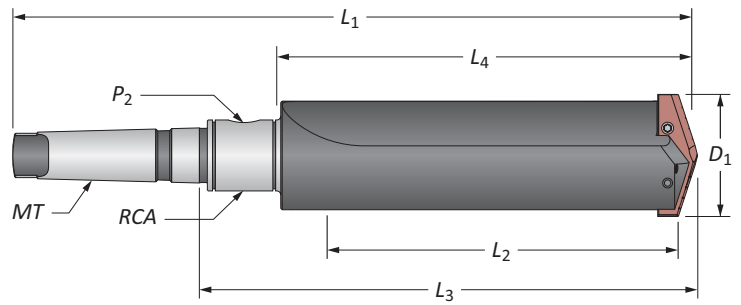
i = Imperial (in)

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

7 Series | Taper Shank

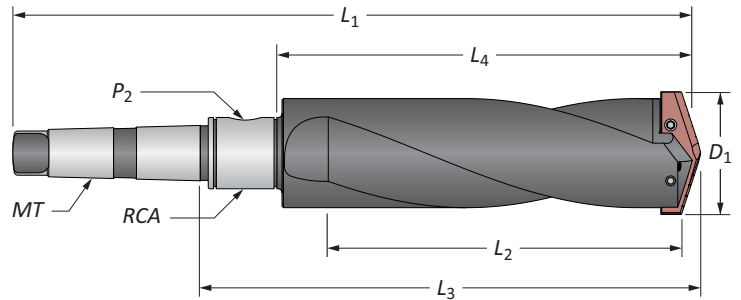


Straight Flute

	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₃	L ₄	L ₁	MT	P ₂	RCA	
m	Short	90.0 - 114.0	171.5	296.8	225.4	439.7	#5**	1/2*	2T-6SRM	22070S-005M
	Extended	90.0 - 114.0	555.6	681.1	609.6	823.9	#5**	1/2*	2T-6SRM	⚠ 25070S-005M
	XL	90.0 - 114.0	685.0	811.2	739.7	954.0	#5**	1/2*	2T-6SRM	⚠ 27070S-005M
	3XL	90.0 - 114.0	939.0	1065.2	993.7	1208.0	#5**	1/2*	2T-6SRM	⚠ 29070S-005M
i	Short	3-17/32 - 4-1/2	6-3/4	11-11/16	8-7/8	17-5/16	#5	1/2	2T-6SR	22070S-005I
	Standard	3-17/32 - 4-1/2	10-3/4	15-11/16	12-7/8	21-5/16	#5	1/2	2T-6SR	24070S-005I
	Extended	3-17/32 - 4-1/2	21-7/8	26-13/16	24	32-7/16	#5	1/2	2T-6SR	⚠ 25070S-005I
	XL	3-17/32 - 4-1/2	27	31-15/16	29-1/8	37-9/16	#5	1/2	2T-6SR	⚠ 27070S-005I
	3XL	3-17/32 - 4-1/2	37	41-5/16	39-1/8	47-9/16	#5	1/2	2T-6SR	⚠ 29070S-005I

*Metric thread to BSP and ISO 7-1

**Per ISO 296 type BEK



Helical Flute

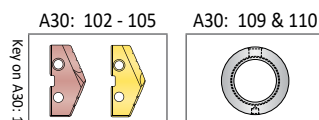
	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₄	L ₃	L ₁	MT	P ₂	RCA	
m	Standard	90.0 - 114.0	273.1	327.0	398.5	541.3	#5**	1/2*	2T-6SRM	24070H-005M

*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*
7619-IP25-1	—	8IP-25	—	—	1750 N-cm (155.0 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)

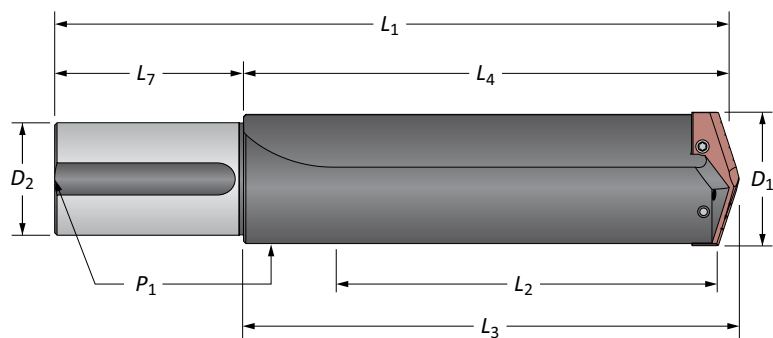
Screws sold in quantities of 10

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

7 Series | Straight Shank



Straight Flute

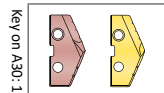
Length	D_1	Body				Shank			Part No.
		L_2	L_4	L_3	L_1	D_2	L_7	P_1	
Short	3-17/32 - 4-1/2	6-3/4	8-7/8	9-1/8	13-7/8	3	5	1/2	22070S-300L
Standard	3-17/32 - 4-1/2	10-3/4	12-7/8	13-1/8	17-7/8	3	5	1/2	24070S-300L
Extended	3-17/32 - 4-1/2	21-7/8	24	24-1/4	29	3	5	1/2	⚠ 25070S-300L
XL	3-17/32 - 4-1/2	27	29-1/8	29-3/8	34-1/8	3	5	1/2	⚠ 27070S-300L
3XL	3-17/32 - 4-1/2	37	39-1/8	39-3/8	44-1/8	3	5	1/2	⚠ 29070S-300L

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7619-IP25-1	—	8IP-25	—	—	1750 N-cm (155.0 in-lbs)

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

A30: 102 - 105



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 Accessories

7/8 Series | Rotary Coolant Adapters | Torx® Plus Screws

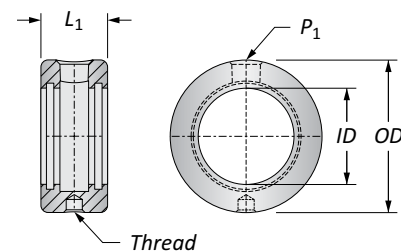
Rotary Coolant Adapter (RCA) and Accessories

ID	OD	L ₁	Driving Rod Thread	P ₁	Part No.	RCA O-Rings	
						Kit Part No.**	Replacements
 57.15	95.27	44.45	M12 x 1.75	1/2*	 2T-6SRM	2T1-6SR	2T1-6OR-10
 2-1/4	3-3/4	1-3/4	1/2-13	1/2	 2T-6SR	2T1-6SR	2T1-6OR-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

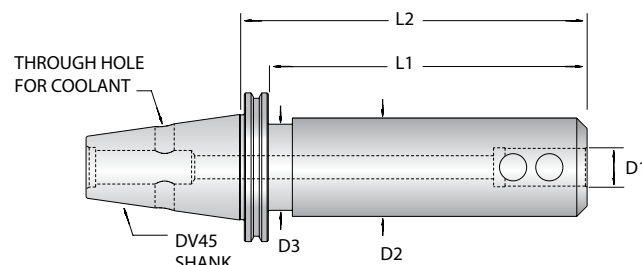


Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7619-IP25-1	—	8IP-25	—	—	1750 N-cm (155.0 in-lbs)

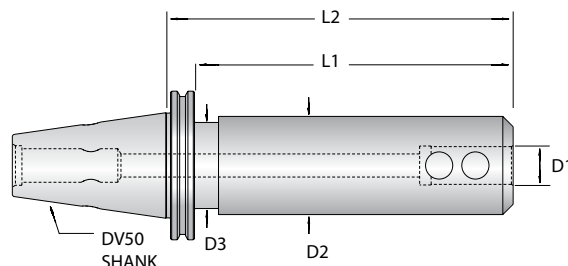
*Tightening torques are calculated with a friction coefficient of $\mu = 0.14$ and develop 90% of ultimate yield strength

DV45 & DV50 Adaptors



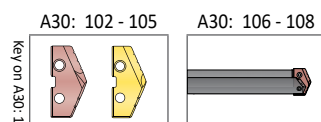
DV45 Adaptor

Item Number	Outer Taper	D1 Inner Ø mm	D2 Ø	D3 Ø	L1	L2	Qty of Clamping Screws
AMDV45-EM20-120	DV45	20	52	57	101	120	1
AMDV45-EM25-120	DV45	25	65	57	101	120	2
AMDV45-EM32-120	DV45	32	78	57	101	120	2
AMDV45-EM20-230	DV45	20	52	57	211	230	1
AMDV45-EM25-230	DV45	25	65	57	211	230	2
AMDV45-EM32-230	DV45	32	78	57	211	230	2



DV50 Adaptor

Item Number	Outer Taper	D1 Inner Ø mm	D2 Ø	D3 Ø	L1	L2	Qty of Clamping Screws
AMDV45-EM50-120	DV50	50	100	69.858	100	120	2



 = Metric (mm)

 = 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.