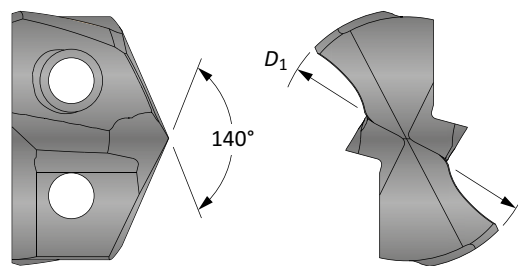
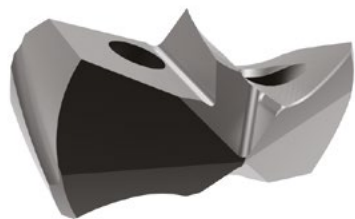







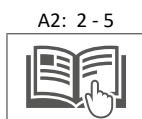
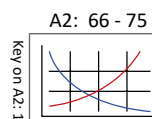
GEN3SYS®XT Pro Drill Inserts

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



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
13.00	0.5118	-	XTP13-13.00	XTK13-13.00	XTN13-13.00
13.10	0.5156	33/64	XTP13-13.10	XTK13-13.10	XTN13-13.10
13.20	0.5197	-	XTP13-13.20	XTK13-13.20	XTN13-13.20
13.30	0.5236	-	XTP13-13.30	XTK13-13.30	XTN13-13.30
13.40	0.5276	-	XTP13-13.40	XTK13-13.40	XTN13-13.40
13.49	0.5313	17/32	XTP13-13.49	XTK13-13.49	XTN13-13.49
13.50	0.5315	-	XTP13-13.50	XTK13-13.50	XTN13-13.50
13.60	0.5354	-	XTP13-13.60	XTK13-13.60	XTN13-13.60
13.70	0.5394	-	XTP13-13.70	XTK13-13.70	XTN13-13.70
13.80	0.5433	-	XTP13-13.80	XTK13-13.80	XTN13-13.80
13.89	0.5469	35/64	XTP13-13.89	XTK13-13.89	XTN13-13.89

Inserts sold in multiples of 1



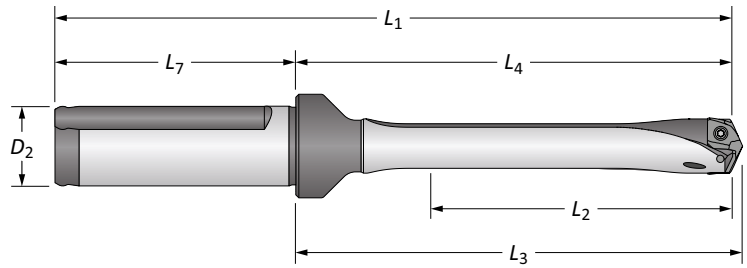
Sizes not shown are available upon request.







When ordering, please follow the example below:

Metric:	13.16mm, Steel, 13 series = use Part No. XTP13-13.16
Imperial:	0.5180", Steel, 13 series = use Part No. XTP13-13.16




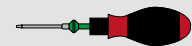

GEN3SYS®XT Pro Drill Insert Holders

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



Flute	Body					Shank			Part No.
	Length	L ₂	L ₄	L ₃	L ₁	L ₇	D ₂	Flat	
 Straight	3xD	42.0	69.2	71.5	119.2	50.0	20.0	YES	HXT0313S-20FM
	3xD	42.0	69.2	71.5	119.2	50.0	20.0	NO	HXT0313S-20CM
	5xD	70.0	97.3	99.5	147.3	50.0	20.0	YES	HXT0513S-20FM
	5xD	70.0	97.3	99.5	147.3	50.0	20.0	NO	HXT0513S-20CM
	7xD	98.0	125.3	127.5	175.3	50.0	20.0	YES	HXT0713S-20FM
	7xD	98.0	125.3	127.5	175.3	50.0	20.0	NO	HXT0713S-20CM
	10xD	140.0	167.0	169.4	217.0	50.0	20.0	YES	 HXT1013S-20FM
	10xD	140.0	167.0	169.4	217.0	50.0	20.0	NO	 HXT1013S-20CM
 Straight	3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	YES	HXT0313S-075F
	3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	NO	HXT0313S-075C
	5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	YES	HXT0513S-075F
	5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	NO	HXT0513S-075C
	7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	YES	HXT0713S-075F
	7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	NO	HXT0713S-075C
	10xD	5-33/64	6-37/64	6-43/64	8-39/64	2-1/32	3/4	YES	 HXT1013S-075F
	10xD	5-33/64	6-37/64	6-43/64	8-39/64	2-1/32	3/4	NO	 HXT1013S-075C


Connection Accessories

 Insert Screws	 Nylon Locking Screws	 Insert Driver	 Preset Torque Hand Driver	 Replacement Tips	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

 = Metric (mm)
 = Imperial (in)

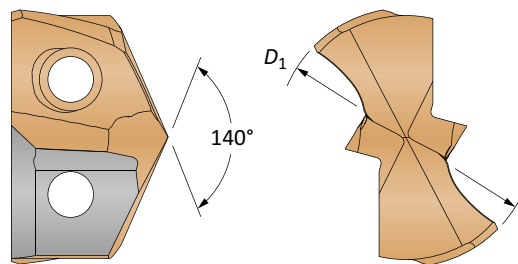
Screws sold in multiples of 10

 **WARNING** Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. 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.



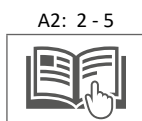
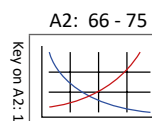
GEN3SYS®XT Drill Inserts

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



Carbide Substrate	Insert			Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
	D ₁ mm	D ₁ inch	Fractional Equivalent				
K35 (C1)	13.00	0.5118	–	7C113P-13	7C113P-13LR	–	–
	13.08	0.5156	33/64	7C113P-.515	7C113P-.515LR	–	–
	13.10	0.5157	–	7C113P-13.1	–	–	–
	13.20	0.5197	–	7C113P-13.2	–	–	–
	13.49	0.5312	17/32	7C113P-0017	7C113P-0017LR	–	–
	13.50	0.5315	–	7C113P-13.5	7C113P-13.5LR	–	–
	13.60	0.5354	–	7C113P-13.6	–	–	–
	13.70	0.5394	–	7C113P-13.7	–	–	–
	13.80	0.5433	–	7C113P-13.8	–	–	–
K20 (C2)	13.89	0.5469	35/64	7C113P-.546	7C113P-.546LR	–	–
	13.00	0.5118	–	7C213P-13	7C213P-13LR	7C213P-13CI	7C213P-13AS
	13.08	0.5156	33/64	7C213P-.515	7C213P-.515LR	7C213P-.515CI	7C213P-.515AS
	13.10	0.5157	–	7C213P-13.1	–	–	–
	13.20	0.5197	–	7C213P-13.2	–	–	–
	13.49	0.5312	17/32	7C213P-0017	7C213P-0017LR	7C213P-0017CI	7C213P-0017AS
	13.50	0.5315	–	7C213P-13.5	7C213P-13.5LR	7C213P-13.5CI	7C213P-13.5AS
	13.60	0.5354	–	7C213P-13.6	–	–	–
	13.70	0.5394	–	7C213P-13.7	–	–	–
13.80	0.5433	–	7C213P-13.8	–	–	–	
13.89	0.5469	35/64	7C213P-.546	7C213P-.546LR	7C213P-.546CI	7C213P-.546AS	

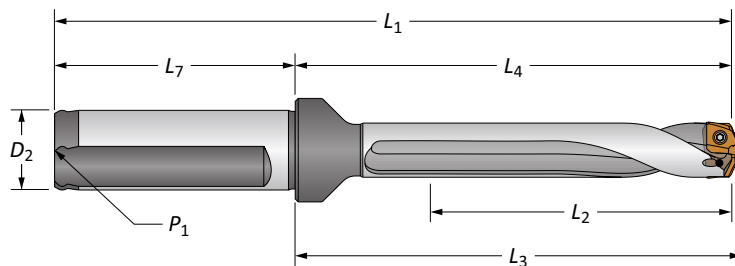
Inserts sold in multiples of 1



Sizes not shown are available upon request.	
When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. XTP13-13.16
Imperial:	0.5180", Steel, 13 series = use Part No. XTP13-13.16

GEN3SYS®XT Standard Drill Insert Holders

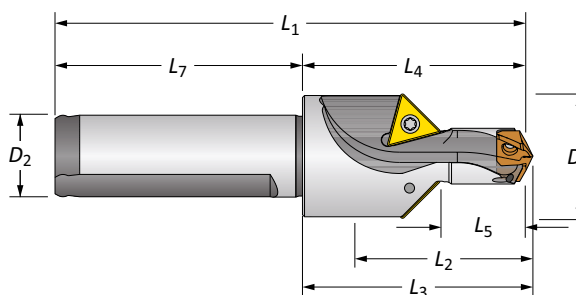
13 Series | Diameter Range: 13.00mm - 13.99mm (0.5118" - 0.5511")



Straight and Helical

Flute	Length	Body					Shank				Flat	Part No.
		L ₂	L ₄	L ₃	L ₁	L ₇	D ₂	P ₁				
	3xD	42.0	69.2	71.5	119.2	50.0	20.0	1/8*	YES	60313S-20FM		
	5xD	70.0	97.3	99.5	147.3	50.0	20.0	1/8*	YES			
	7xD	98.0	125.3	127.5	175.3	50.0	20.0	1/8*	YES			
	Stub	16.0	43.0	45.2	93.0	50.0	20.0	1/8*	YES	60113H-20FM		
	3xD	42.0	69.2	71.5	119.2	50.0	20.0	1/8*	YES	60313H-20FM		
	3xD	42.0	69.2	71.5	119.2	50.0	20.0	1/8*	NO	60313H-20CM		
	5xD	70.0	97.3	99.5	147.3	50.0	20.0	1/8*	YES	60513H-20FM		
	5xD	70.0	97.3	99.5	147.3	50.0	20.0	1/8*	NO	60513H-20CM		
	7xD	98.0	125.3	127.5	175.3	50.0	20.0	1/8*	YES	60713H-20FM		
	7xD	98.0	125.3	127.5	175.3	50.0	20.0	1/8*	NO	60713H-20CM		
	3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	1/8	YES	60313S-075F		
	5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	1/8	YES	60513S-075F		
	7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	1/8	YES	60713S-075F		
	Stub	5/8	1-11/16	1-25/32	3-23/32	2-1/32	3/4	1/8	YES	60113H-075F		
	3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	1/8	YES	60313H-075F		
	3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	1/8	NO	60313H-075C		
	5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	1/8	YES	60513H-075F		
	5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	1/8	NO	60513H-075C		
	7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	1/8	YES	60713H-075F		
	7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	1/8	NO	60713H-075C		

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step		Body				Shank		Part No.		Chamfer Insert
	D ₅	L ₅	L ₂	L ₄	L ₃	L ₁	L ₇	D ₂			
	25.8	19.5	25.4	43.0	45.2	93.0	50.0	20.0	60113C45-20FM	TCMT-110204	
	1-1/64	49/64	1	1-11/16	1-25/32	3-23/32	2-1/32	3/4	60113C45-075F	TCMT-110204	

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

Chamfer inserts sold separately in multiples of 10 | Screws sold in multiples of 10

= Metric (mm)
 = Imperial (in)