




20

DRILLING | GEN3SYS® XT Pro and XT High Penetration Replaceable Insert Drilling System

GEN3SYS®XT Pro Drill Inserts

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

Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
20.00	0.7874	-	XTP20-20.00	XTK20-20.00	XTN20-20.00
20.10	0.7913	-	XTP20-20.10	XTK20-20.10	XTN20-20.10
20.20	0.7953	-	XTP20-20.20	XTK20-20.20	XTN20-20.20
20.24	0.7969	51/64	XTP20-20.24	XTK20-20.24	XTN20-20.24
20.30	0.7992	-	XTP20-20.30	XTK20-20.30	XTN20-20.30
20.40	0.8031	-	XTP20-20.40	XTK20-20.40	XTN20-20.40
20.50	0.8071	-	XTP20-20.50	XTK20-20.50	XTN20-20.50
20.60	0.8110	-	XTP20-20.60	XTK20-20.60	XTN20-20.60
20.64	0.8125	13/16	XTP20-20.64	XTK20-20.64	XTN20-20.64
20.70	0.8150	-	XTP20-20.70	XTK20-20.70	XTN20-20.70
20.80	0.8189	-	XTP20-20.80	XTK20-20.80	XTN20-20.80
20.90	0.8228	-	XTP20-20.90	XTK20-20.90	XTN20-20.90
21.00	0.8268	-	XTP20-21.00	XTK20-21.00	XTN20-21.00
21.10	0.8307	-	XTP20-21.10	XTK20-21.10	XTN20-21.10
21.20	0.8346	-	XTP20-21.20	XTK20-21.20	XTN20-21.20
21.30	0.8386	-	XTP20-21.30	XTK20-21.30	XTN20-21.30
21.40	0.8425	-	XTP20-21.40	XTK20-21.40	XTN20-21.40
21.43	0.8438	27/32	XTP20-21.43	XTK20-21.43	XTN20-21.43
21.50	0.8465	-	XTP20-21.50	XTK20-21.50	XTN20-21.50
21.60	0.8504	-	XTP20-21.60	XTK20-21.60	XTN20-21.60
21.70	0.8543	-	XTP20-21.70	XTK20-21.70	XTN20-21.70
21.80	0.8583	-	XTP20-21.80	XTK20-21.80	XTN20-21.80
21.83	0.8594	55/64	XTP20-21.83	XTK20-21.83	XTN20-21.83
21.90	0.8622	-	XTP20-21.90	XTK20-21.90	XTN20-21.90

Inserts sold in multiples of 1

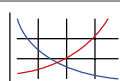
F

THREADING

X


SPECIALS

A2: 66 - 75



Key on A2: 1

A2: 2 - 5



Sizes not shown are available upon request.
When ordering, please follow the example below:

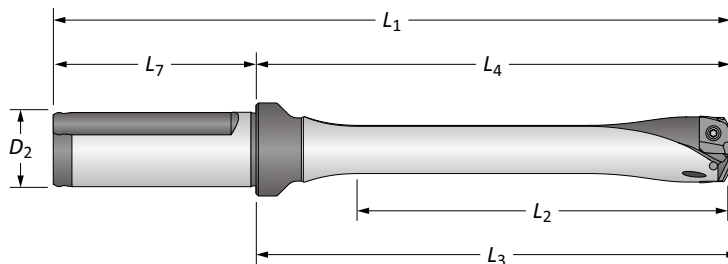
Metric:	13.16mm, Steel, 13 series = use Part No. XTP13-13.16
Imperial:	0.5180", Steel, 13 series = use Part No. XTP13-13.16

A20: 40

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GEN3SYS®XT Pro Drill Insert Holders

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



Flute	Body					Shank			Flat	Part No.
	Length	L ₂	L ₄	L ₃	L ₁	L ₇	D ₂			
(m) Straight 	3xD	66.0	100.1	102.9	156.1	56.0	25.0	YES	HXT0320S-25FM	
	3xD	66.0	100.1	102.9	156.1	56.0	25.0	NO	HXT0320S-25CM	
	5xD	110.0	144.1	146.9	200.1	56.0	25.0	YES	HXT0520S-25FM	
	5xD	110.0	144.1	146.9	200.1	56.0	25.0	NO	HXT0520S-25CM	
	7xD	154.0	188.1	190.9	244.1	56.0	25.0	YES	HXT0720S-25FM	
	7xD	154.0	188.1	190.9	244.1	56.0	25.0	NO	HXT0720S-25CM	
	10xD	219.9	254.0	256.8	310.0	56.0	25.0	YES	⚠ HXT1020S-25FM	
	10xD	219.9	254.0	256.8	310.0	56.0	25.0	NO	⚠ HXT1020S-25CM	
(i) Straight 	3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	YES	HXT0320S-100F	
	3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	NO	HXT0320S-100C	
	5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	YES	HXT0520S-100F	
	5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	NO	HXT0520S-100C	
	7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	YES	HXT0720S-100F	
	7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	NO	HXT0720S-100C	
	10xD	8-21/32	10	10-7/64	12-9/32	2-9/32	1	YES	⚠ HXT1020S-100F	
	10xD	8-21/32	10	10-7/64	12-9/32	2-9/32	1	NO	⚠ HXT1020S-100C	

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)

Screws sold in multiples of 10

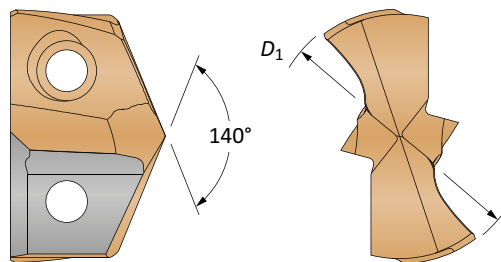
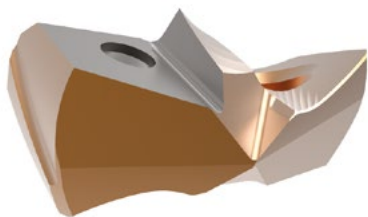
⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit www.alliedmachine.com for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

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



GEN3SYS®XT Drill Inserts

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

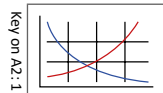


Carbide Substrate	Insert			Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
	D ₁ mm	D ₁ inch	Fractional Equivalent				
K35 (C1)	20.00	0.7874	–	7C120P-20	7C120P-20LR	–	–
	20.24	0.7969	51/64	7C120P-.796	7C120P-.796LR	–	–
	20.50	0.8071	–	7C120P-20.5	7C120P-20.5LR	–	–
	20.64	0.8125	13/16	7C120P-0026	7C120P-0026LR	–	–
	21.00	0.8268	–	7C120P-21	7C120P-21LR	–	–
	21.43	0.8438	27/32	7C120P-0027	7C120P-0027LR	–	–
	21.50	0.8465	–	7C120P-21.5	7C120P-21.5LR	–	–
K20 (C2)	21.83	0.8594	55/64	7C120P-.859	7C120P-.859LR	–	–
	20.00	0.7874	–	7C220P-20	7C220P-20LR	7C220P-20CI	7C220P-20AS
	20.24	0.7969	51/64	7C220P-.796	7C220P-.796LR	7C220P-.796CI	7C220P-.796AS
	20.50	0.8071	–	7C220P-20.5	7C220P-20.5LR	7C220P-20.5CI	7C220P-20.5AS
	20.64	0.8125	13/16	7C220P-0026	7C220P-0026LR	7C220P-0026CI	7C220P-0026AS
	21.00	0.8268	–	7C220P-21	7C220P-21LR	7C220P-21CI	7C220P-21AS
	21.43	0.8438	27/32	7C220P-0027	7C220P-0027LR	7C220P-0027CI	7C220P-0027AS
21.50	0.8465	–	7C220P-21.5	7C220P-21.5LR	7C220P-21.5CI	7C220P-21.5AS	
21.83	0.8594	55/64	7C220P-.859	7C220P-.859LR	7C220P-.859CI	7C220P-.859AS	

Inserts sold in multiples of 1

A2: 66 - 75

A2: 2 - 5



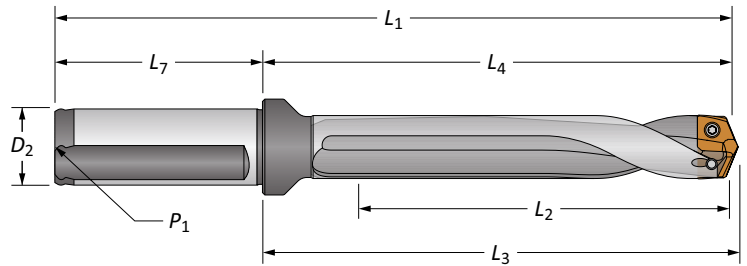
Sizes not shown are available upon request.

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

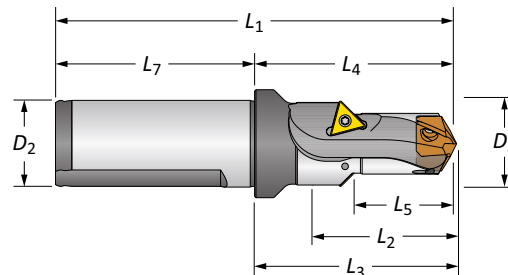
20 Series | Diameter Range: 20.00mm - 21.99mm (0.7874" - 0.8660")






Straight and Helical

Flute	Body						Shank				Part No.
	Length	L ₂	L ₄	L ₃	L ₁	L ₇	D ₂	P ₁	Flat		
 Straight	3xD	66.0	100.1	102.9	156.1	56.0	25.0	1/8*	YES	60320S-25FM	
	5xD	110.0	144.1	146.9	200.1	56.0	25.0	1/8*	YES	60520S-25FM	
	7xD	154.0	188.1	190.9	244.1	56.0	25.0	1/8*	YES	60720S-25FM	
 Helical	Stub	24.0	57.6	60.4	113.6	56.0	25.0	1/8*	YES	60120H-25FM	
	3xD	66.0	100.1	102.9	156.1	56.0	25.0	1/8*	YES	60320H-25FM	
	3xD	66.0	100.1	102.9	156.1	56.0	25.0	1/8*	NO	60320H-25CM	
	5xD	110.0	144.1	146.9	200.1	56.0	25.0	1/8*	YES	60520H-25FM	
	5xD	110.0	144.1	146.9	200.1	56.0	25.0	1/8*	NO	60520H-25CM	
	7xD	154.0	188.1	190.9	244.1	56.0	25.0	1/8*	YES	60720H-25FM	
	7xD	154.0	188.1	190.9	244.1	56.0	25.0	1/8*	NO	60720H-25CM	
 Straight	3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	1/8	YES	60320S-100F	
	5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	1/8	YES	60520S-100F	
	7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	1/8	YES	60720S-100F	
	Stub	15/16	2-17/64	2-3/8	4-35/64	2-9/32	1	1/8	YES	60120H-100F	
	3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	1/8	YES	60320H-100F	
	3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	1/8	NO	60320H-100C	
	5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	1/8	YES	60520H-100F	
	5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	1/8	NO	60520H-100C	
	7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	1/8	YES	60720H-100F	
	7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	1/8	NO	60720H-100C	




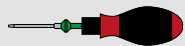

*Thread to BSP and ISO 7-1



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		
	27.2	30.0	37.1	57.6	60.4	116.5	56.0	25.0	60120C45-25FM	TCMT-110204
	1-5/64	1-3/16	1-29/64	2-17/64	2-3/8	4-35/64	2-9/32	1	60120C45-100F	TCMT-110204


Connection Accessories

 Insert Screws	 Nylon Locking Screws	 Insert Driver	 Preset Torque Hand Driver	 Replacement Tips	Admissible Tightening Torque*
7375-IP9-1	7375N-IP9-1	8IP-9	8IP-9TL	8IP-9B	

*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)