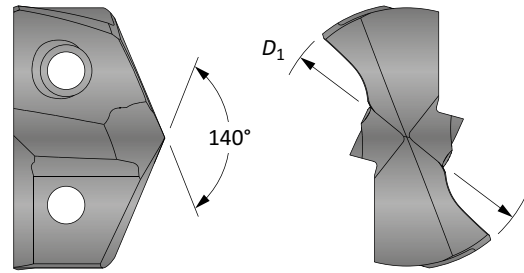
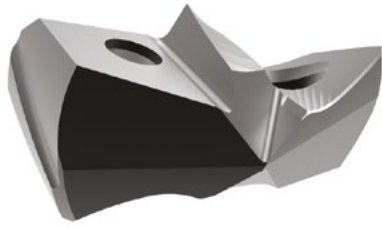







GEN3SYS®XT Pro Drill Inserts

22 Series | Diameter Range: 22.00mm - 23.99mm (0.8661" - 0.9448")

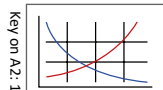


Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
22.00	0.8661	-	XTP22-22.00	XTK22-22.00	XTN22-22.00
22.10	0.8701	-	XTP22-22.10	XTK22-22.10	XTN22-22.10
22.20	0.8740	-	XTP22-22.20	XTK22-22.20	XTN22-22.20
22.23	0.8750	7/8	XTP22-22.23	XTK22-22.23	XTN22-22.23
22.30	0.8780	-	XTP22-22.30	XTK22-22.30	XTN22-22.30
22.40	0.8819	-	XTP22-22.40	XTK22-22.40	XTN22-22.40
22.50	0.8858	-	XTP22-22.50	XTK22-22.50	XTN22-22.50
22.62	0.8906	57/64	XTP22-22.62	XTK22-22.62	XTN22-22.62
22.70	0.8937	-	XTP22-22.70	XTK22-22.70	XTN22-22.70
22.80	0.8976	-	XTP22-22.80	XTK22-22.80	XTN22-22.80
22.90	0.9016	-	XTP22-22.90	XTK22-22.90	XTN22-22.90
23.00	0.9055	-	XTP22-23.00	XTK22-23.00	XTN22-23.00
23.02	0.9063	29/32	XTP22-23.02	XTK22-23.02	XTN22-23.02
23.10	0.9094	-	XTP22-23.10	XTK22-23.10	XTN22-23.10
23.20	0.9134	-	XTP22-23.20	XTK22-23.20	XTN22-23.20
23.30	0.9173	-	XTP22-23.30	XTK22-23.30	XTN22-23.30
23.42	0.9219	59/64	XTP22-23.42	XTK22-23.42	XTN22-23.42
23.50	0.9252	-	XTP22-23.50	XTK22-23.50	XTN22-23.50
23.60	0.9291	-	XTP22-23.60	XTK22-23.60	XTN22-23.60
23.70	0.9331	-	XTP22-23.70	XTK22-23.70	XTN22-23.70
23.81	0.9375	15/16	XTP22-23.81	XTK22-23.81	XTN22-23.81
23.90	0.9409	-	XTP22-23.90	XTK22-23.90	XTN22-23.90

Inserts sold in multiples of 1

A2: 66 - 75

A2: 2 - 5

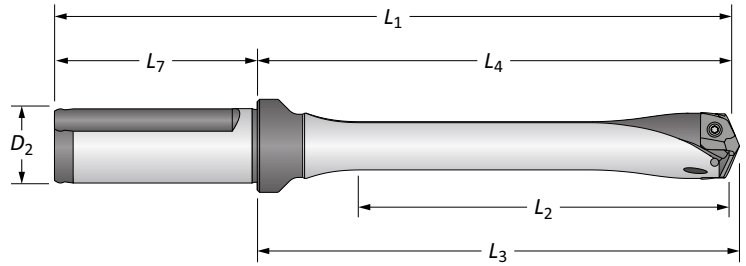








Sizes not shown are available upon request.
When ordering, please follow the example below:

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




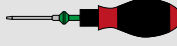

GEN3SYS® XT Pro Drill Insert Holders

22 Series | Diameter Range: 22.00mm - 23.99mm (0.8661" - 0.9448")




Flute	Body					Shank			Flat	Part No.
	Length	L ₂	L ₄	L ₃	L ₁	L ₇	D ₂			
 Straight	3xD	72.0	105.3	108.3	161.3	56.0	25.0	YES	HXT0322S-25FM	
	3xD	72.0	105.3	108.3	161.3	56.0	25.0	NO	HXT0322S-25CM	
	5xD	120.0	153.3	156.2	209.3	56.0	25.0	YES	HXT0522S-25FM	
	5xD	120.0	153.3	156.2	209.3	56.0	25.0	NO	HXT0522S-25CM	
	7xD	167.9	201.3	204.2	257.3	56.0	25.0	YES	HXT0722S-25FM	
	7xD	167.9	201.3	204.2	257.3	56.0	25.0	NO	HXT0722S-25CM	
	10xD	239.9	273.0	276.2	329.0	56.0	25.0	YES	 HXT1022S-25FM	
	10xD	239.9	273.0	276.2	329.0	56.0	25.0	NO	 HXT1022S-25CM	
 Straight	3xD	2-53/64	4-9/64	4-17/64	6-27/64	2-9/32	1	YES	HXT0322S-100F	
	3xD	2-53/64	4-9/64	4-17/64	6-27/64	2-9/32	1	NO	HXT0322S-100C	
	5xD	4-23/32	6-1/32	6-5/32	8-5/16	2-9/32	1	YES	HXT0522S-100F	
	5xD	4-23/32	6-1/32	6-5/32	8-5/16	2-9/32	1	NO	HXT0522S-100C	
	7xD	6-39/64	7-59/64	8-3/64	10-13/64	2-9/32	1	YES	HXT0722S-100F	
	7xD	6-39/64	7-59/64	8-3/64	10-13/64	2-9/32	1	NO	HXT0722S-100C	
	10xD	9-7/16	10-3/4	10-7/8	13-1/32	2-9/32	1	YES	 HXT1022S-100F	
	10xD	9-7/16	10-3/4	10-7/8	13-1/32	2-9/32	1	NO	 HXT1022S-100C	

Connection Accessories

					Admissible Tightening Torque*
739-IP9-1	739N-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

 = Metric (mm)

 = Imperial (in)

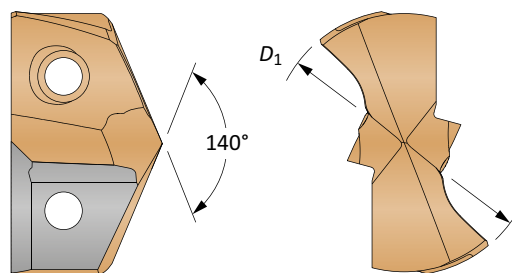
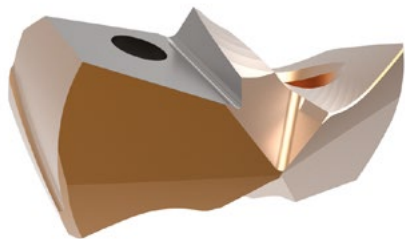
Screws sold in multiples of 10

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

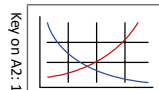
22 Series | Diameter Range: 22.00mm - 23.99mm (0.8661" - 0.9448")



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)	22.00	0.8661	–	7C122P-22	7C122P-22LR	–	–
	22.23	0.8750	7/8	7C122P-0028	7C122P-0028LR	–	–
	22.50	0.8858	–	7C122P-22.5	–	–	–
	22.62	0.8906	57/64	7C122P-.890	7C122P-.890LR	–	–
	23.00	0.9055	–	7C122P-23	7C122P-23LR	–	–
	23.02	0.9063	29/32	7C122P-0029	7C122P-0029LR	–	–
	23.42	0.9219	59/64	7C122P-.921	7C122P-.921LR	–	–
	23.50	0.9252	–	7C122P-23.5	–	–	–
K20 (C2)	23.81	0.9375	15/16	7C122P-0030	7C122P-0030LR	–	–
	22.00	0.8661	–	7C222P-22	7C222P-22LR	7C222P-22CI	7C222P-22AS
	22.23	0.8750	7/8	7C222P-0028	7C222P-0028LR	7C222P-0028CI	7C222P-0028AS
	22.50	0.8858	–	7C222P-22.5	–	–	–
	22.62	0.8906	57/64	7C222P-.890	7C222P-.890LR	7C222P-.890CI	7C222P-.890AS
	23.00	0.9055	–	7C222P-23	7C222P-23LR	7C222P-23CI	7C222P-23AS
	23.02	0.9063	29/32	7C222P-0029	7C222P-0029LR	7C222P-0029CI	7C222P-0029AS
	23.42	0.9219	59/64	7C222P-.921	7C222P-.921LR	7C222P-.921CI	7C222P-.921AS
23.50	0.9252	–	7C222P-23.5	–	–	–	
23.81	0.9375	15/16	7C222P-0030	7C222P-0030LR	7C222P-0030CI	7C222P-0030AS	

Inserts sold in multiples of 1

A2: 66 - 75



A2: 2 - 5



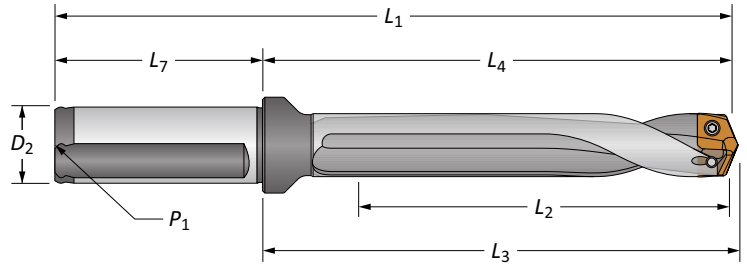
Sizes not shown are available upon request.

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

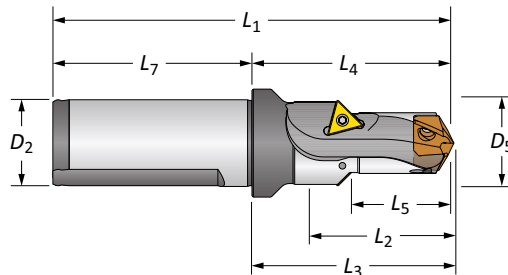
22 Series | Diameter Range: 22.00mm - 23.99mm (0.8661" - 0.9448")






Straight and Helical

Flute	Length	Body					Shank				Part No.
		L_2	L_4	L_3	L_1	L_7	D_2	P_1	Flat		
 Straight	3xD	72.0	105.3	108.3	161.3	56.0	25.0	1/8*	YES	60322S-25FM	
	5xD	120.0	153.3	156.2	209.3	56.0	25.0	1/8*	YES	60522S-25FM	
	7xD	168.0	201.3	204.2	257.3	56.0	25.0	1/8*	YES	60722S-25FM	
 Helical	Stub	27.0	60.1	63.0	116.1	56.0	25.0	1/8*	YES	60122H-25FM	
	3xD	72.0	105.3	108.3	161.3	56.0	25.0	1/8*	YES	60322H-25FM	
	3xD	72.0	105.3	108.3	161.3	56.0	25.0	1/8*	NO	60322H-25CM	
	5xD	120.0	153.3	156.2	209.3	56.0	25.0	1/8*	YES	60522H-25FM	
	5xD	120.0	153.3	156.2	209.3	56.0	25.0	1/8*	NO	60522H-25CM	
	7xD	168.0	201.3	204.2	257.3	56.0	25.0	1/8*	YES	60722H-25FM	
	7xD	168.0	201.3	204.2	257.3	56.0	25.0	1/8*	NO	60722H-25CM	
 Straight	3xD	2-53/64	4-9/64	4-17/64	6-27/64	2-9/32	1	1/8	YES	60322S-100F	
	5xD	4-23/32	6-1/32	6-5/32	8-5/16	2-9/32	1	1/8	YES	60522S-100F	
	7xD	6-39/64	7-59/64	8-3/64	10-13/64	2-9/32	1	1/8	YES	60722S-100F	
	Stub	1-1/16	2-23/64	2-31/64	4-41/64	2-9/32	1	1/8	YES	60122H-100F	
	3xD	2-53/64	4-9/64	4-17/64	6-27/64	2-9/32	1	1/8	YES	60322H-100F	
	3xD	2-53/64	4-9/64	4-17/64	6-27/64	2-9/32	1	1/8	NO	60322H-100C	
	5xD	4-23/32	6-1/32	6-5/32	8-5/16	2-9/32	1	1/8	YES	60522H-100F	
	5xD	4-23/32	6-1/32	6-5/32	8-5/16	2-9/32	1	1/8	NO	60522H-100C	
	7xD	6-39/64	7-59/64	8-3/64	10-13/64	2-9/32	1	1/8	YES	60722H-100F	
	7xD	6-39/64	7-59/64	8-3/64	10-13/64	2-9/32	1	1/8	NO	60722H-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		
	29.0	33.0	40.5	60.0	63.0	119.0	56.0	25.0	60122C45-25FM	TCMT-110204
	1-9/64	1-19/64	1-19/32	2-23/64	2-31/64	4-41/64	2-9/32	1	60122C45-100F	TCMT-110204

Connection Accessories

 Insert Screws	 Nylon Locking Screws	 Insert Driver	 Preset Torque Hand Driver	 Replacement Tips	Admissible Tightening Torque*
739-IP9-1	739N-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)