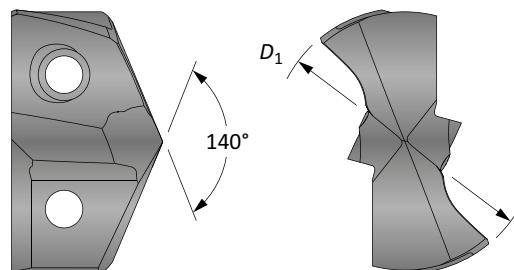
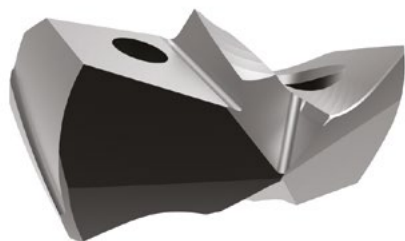







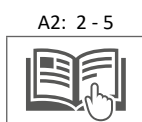
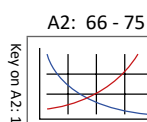
## GEN3SYS®XT Pro Drill Inserts

24 Series | Diameter Range: 24.00mm - 25.99mm (0.9449" - 1.0235")



Insert					
$D_1$ mm	$D_1$ inch	Fractional Equivalent	Part No. <b>P</b>	Part No. <b>K</b>	Part No. <b>N</b>
24.00	0.9449	-	XTP24-24.00	XTK24-24.00	XTN24-24.00
24.10	0.9488	-	XTP24-24.10	XTK24-24.10	XTN24-24.10
24.20	0.9528	-	XTP24-24.20	XTK24-24.20	XTN24-24.20
24.30	0.9567	-	XTP24-24.30	XTK24-24.30	XTN24-24.30
24.40	0.9606	-	XTP24-24.40	XTK24-24.40	XTN24-24.40
24.50	0.9646	-	XTP24-24.50	XTK24-24.50	XTN24-24.50
24.61	0.9688	31/32	XTP24-24.61	XTK24-24.61	XTN24-24.61
24.70	0.9724	-	XTP24-24.70	XTK24-24.70	XTN24-24.70
24.80	0.9764	-	XTP24-24.80	XTK24-24.80	XTN24-24.80
24.90	0.9803	-	XTP24-24.90	XTK24-24.90	XTN24-24.90
25.00	0.9843	63/64	XTP24-25.00	XTK24-25.00	XTN24-25.00
25.10	0.9882	-	XTP24-25.10	XTK24-25.10	XTN24-25.10
25.20	0.9921	-	XTP24-25.20	XTK24-25.20	XTN24-25.20
25.30	0.9961	-	XTP24-25.30	XTK24-25.30	XTN24-25.30
25.40	1.0000	1	XTP24-25.40	XTK24-25.40	XTN24-25.40
25.50	1.0039	-	XTP24-25.50	XTK24-25.50	XTN24-25.50
25.60	1.0080	-	XTP24-25.60	XTK24-25.60	XTN24-25.60
25.70	1.0118	-	XTP24-25.70	XTK24-25.70	XTN24-25.70
25.78	1.0150	1-1/64	XTP24-25.78	XTK24-25.78	XTN24-25.78
25.90	1.0197	-	XTP24-25.90	XTK24-25.90	XTN24-25.90

Inserts sold in multiples of 1

A  
DRILLINGB  
BORINGC  
REAMINGD  
BURNISHINGE  
THREADINGX  
SPECIALS

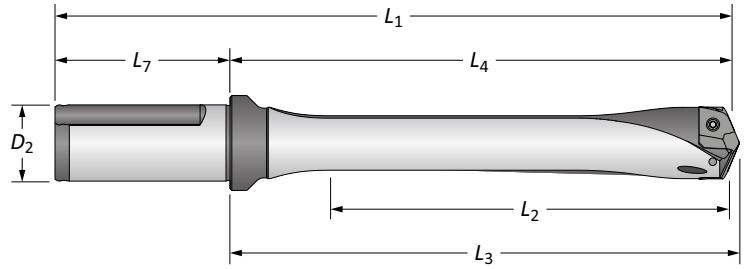
Sizes not shown are available upon request.







When ordering, please follow the example below:

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




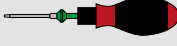

## GEN3SYS®XT Pro Drill Insert Holders

24 Series | Diameter Range: 24.00mm - 25.99mm (0.9449" - 1.0235")




Flute	Body					Shank			Part No.
	Length	L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	Flat	
 Straight	3xD	78.0	113.8	116.8	169.8	56.0	25.0	YES	HXT0324S-25FM
	3xD	78.0	113.8	116.8	169.8	56.0	25.0	NO	HXT0324S-25CM
	5xD	130.0	165.8	168.7	221.8	56.0	25.0	YES	HXT0524S-25FM
	5xD	130.0	165.8	168.7	221.8	56.0	25.0	NO	HXT0524S-25CM
	7xD	182.0	217.8	220.7	273.8	56.0	25.0	YES	HXT0724S-25FM
	7xD	182.0	217.8	220.7	273.8	56.0	25.0	NO	HXT0724S-25CM
	10xD	259.9	295.7	298.7	351.7	56.0	25.0	YES	 HXT1024S-25FM
	10xD	259.9	295.7	298.7	351.7	56.0	25.0	NO	 HXT1024S-25CM
 Straight	3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	YES	HXT0324S-100F
	3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	NO	HXT0324S-100C
	5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	YES	HXT0524S-100F
	5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	NO	HXT0524S-100C
	7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	YES	HXT0724S-100F
	7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	NO	HXT0724S-100C
	10xD	10-15/64	11-41/64	11-49/64	13-59/64	2-9/32	1	YES	 HXT1024S-100F
	10xD	10-15/64	11-41/64	11-49/64	13-59/64	2-9/32	1	NO	 HXT1024S-100C

### Connection Accessories

					<b>Admissible Tightening Torque*</b>
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)

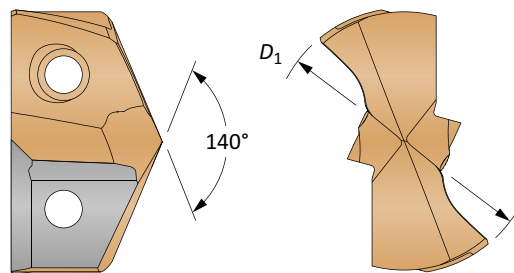
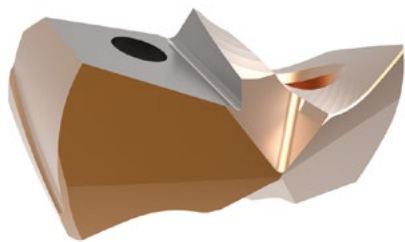
Screws sold in multiples of 10

**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](http://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.



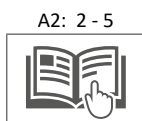
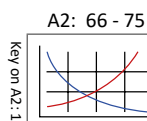
## GEN3SYS®XT Drill Inserts

24 Series | Diameter Range: 24.00mm - 25.99mm (0.9449" - 1.0235")



Carbide Substrate	Insert			Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
	D <sub>1</sub> mm	D <sub>1</sub> inch	Fractional Equivalent				
K35 (C1)	24.00	0.9449	–	7C124P-24	7C124P-24LR	–	–
	24.50	0.9646	–	7C124P-24.5	–	–	–
	24.61	0.9688	31/32	7C124P-0031	7C124P-0031LR	–	–
	25.00	0.9843	63/64	7C124P-25	7C124P-25LR	–	–
	25.40	1.0000	1	7C124P-0100	7C124P-0100LR	–	–
	25.50	1.0039	–	7C124P-25.5	–	–	–
	25.60	1.0080	–	7C124P-1.008	7C124P-1.008LR	–	–
	25.65	1.0098	–	7C124P-25.65	–	–	–
K20 (C2)	25.80	1.0156	1-1/64	7C124P-1.015	7C124P-1.015LR	–	–
	24.00	0.9449	–	7C224P-24	7C224P-24LR	7C224P-24CI	7C224P-24AS
	24.50	0.9646	–	7C224P-24.5	–	–	–
	24.61	0.9688	31/32	7C224P-0031	7C224P-0031LR	7C224P-0031CI	7C224P-0031AS
	25.00	0.9843	63/64	7C224P-25	7C224P-25LR	7C224P-25CI	7C224P-25AS
	25.40	1.0000	1	7C224P-0100	7C224P-0100LR	7C224P-0100CI	7C224P-0100AS
	25.50	1.0039	–	7C224P-25.5	–	–	–
	25.60	1.0080	–	7C224P-1.008	7C224P-1.008LR	7C224P-1.008CI	7C224P-1.008AS
25.65	1.0098	–	7C224P-25.65	–	–	–	
25.80	1.0156	1-1/64	7C224P-1.015	7C224P-1.015LR	7C224P-1.015CI	7C224P-1.015AS	

Inserts sold in multiples of 1

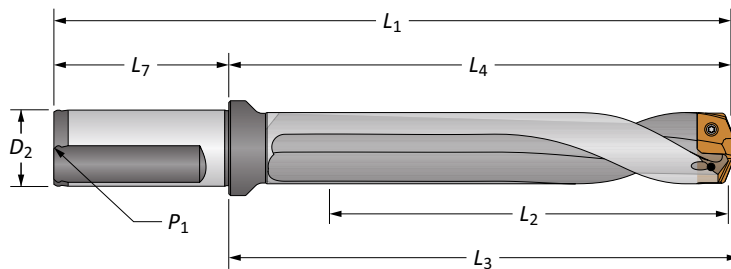


Sizes not shown are available upon request.  
When ordering, please follow the example below:

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

**GEN3SYS®XT Standard Drill Insert Holders**

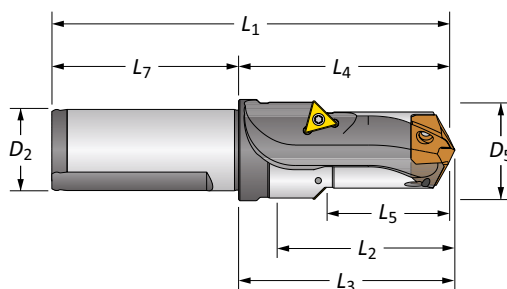
24 Series | Diameter Range: 24.00mm - 25.99mm (0.9449" - 1.0235")



**Straight and Helical**

Flute	Length	Body					Shank				Part No.
		L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	P <sub>1</sub>	Flat		
	3xD	78.0	113.8	116.8	169.8	56.0	25.0	1/8*	YES	<b>60324S-25FM</b>	
	5xD	130.0	165.8	168.7	221.8	56.0	25.0	1/8*	YES	<b>60524S-25FM</b>	
	7xD	182.0	217.8	220.7	273.8	56.0	25.0	1/8*	YES	<b>60724S-25FM</b>	
	Stub	28.5	64.2	67.1	120.2	56.0	25.0	1/8*	YES	<b>60124H-25FM</b>	
	3xD	78.0	113.8	116.8	169.8	56.0	25.0	1/8*	YES	<b>60324H-25FM</b>	
	3xD	78.0	113.8	116.8	169.8	56.0	25.0	1/8*	NO	<b>60324H-25CM</b>	
	5xD	130.0	165.8	168.7	221.8	56.0	25.0	1/8*	YES	<b>60524H-25FM</b>	
	5xD	130.0	165.8	168.7	221.8	56.0	25.0	1/8*	NO	<b>60524H-25CM</b>	
	7xD	182.0	217.8	220.7	273.8	56.0	25.0	1/8*	YES	<b>60724H-25FM</b>	
	7xD	182.0	217.8	220.7	273.8	56.0	25.0	1/8*	NO	<b>60724H-25CM</b>	
	3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	1/8	YES	<b>60324S-100F</b>	
	5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	1/8	YES	<b>60524S-100F</b>	
	7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	1/8	YES	<b>60724S-100F</b>	
	Stub	1-1/8	2-17/32	2-41/64	4-13/16	2-9/32	1	1/8	YES	<b>60124H-100F</b>	
	3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	1/8	YES	<b>60324H-100F</b>	
	3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	1/8	NO	<b>60324H-100C</b>	
	5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	1/8	YES	<b>60524H-100F</b>	
	5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	1/8	NO	<b>60524H-100C</b>	
	7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	1/8	YES	<b>60724H-100F</b>	
	7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	1/8	NO	<b>60724H-100C</b>	

\*Thread to BSP and ISO 7-1



**Drill / Chamfer**

Step	Body					Shank		Part No.	Chamfer Insert	
	D <sub>5</sub>	L <sub>5</sub>	L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub>	L <sub>1</sub>	L <sub>7</sub>			D <sub>2</sub>
	31.0	36.0	45.5	64.2	67.1	123.0	56.0	25.0	<b>60124C45-25FM</b>	TCMT-110204
	1-7/32	1-27/64	1-51/64	2-17/32	2-41/64	4-13/16	2-9/32	1	<b>60124C45-100F</b>	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	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

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

= Metric (mm)  
 = Imperial (in)