



T-A® & GEN2 T-A® Structural Steel BT-A Drill



Features and Benefits

- Drilling range 9.50 - 160.00mm
- Multiple geometries and grades
- Range of insert coatings for all materials
- Replaceable inserts, eliminates the need for re-sharpening
- High strength tool holders provide extended tool life

AMEC's T-A® and GEN2 T-A® drill insert systems set the standard for replaceable insert technology, delivering consistent performance and reduced cost per hole, increased productivity and outstanding tool life.

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T-A® System & Benefits

T-A & BENZ T-A

BENZSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPort 432

Criterion

Thread Milling

Special Tooling

Increased productivity with high accuracy

At AMEC® we have taken our extensive and in-depth knowledge of drilling and production to create the most comprehensive and versatile T-A® product range to date. The T-A® system offers three outstanding product ranges to meet the diverse manufacturing needs in production drilling, structural engineering and deep hole drilling. Whatever your application AMEC's T-A® product range can deliver the ideal solution for your application.

High performance, outstanding tool life and excellent productivity are just some of the key benefits that are delivered by the T-A® drills. Add this to the fact that the T-A® system is also one of the most widely used drilling solutions and you get some idea why it is the preferred choice for countless manufacturing businesses, worldwide.



T-A®

T-A's extensive range of tool holders is manufactured in high strength steel with through coolant as standard. The T-A® replaceable insert technology allows significant reductions in inventory by offering a larger diameter range per holder.

Available in Y-8 Series

Features and Benefits

- Large diameter range of 9.50 to 160.00mm
- Large choice of tool holders up to 32 x diameter in straight and helical fluted options
- Easy to change inserts reduce machine down time and cost
- Extensive range of inserts grades and geometries



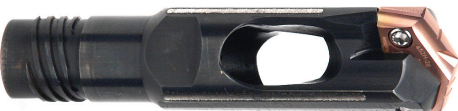
T-A® Structural steel

The versatile T-A® Structural steel system has a range of dedicated inserts and tool holders, which are designed to provide a highly effective solution for the most demanding of applications.

Available in 0-3 Series

Features and Benefits

- Dedicated body diameters to increase rigidity
- Easily adapted to all major structural steel machines
- Side and rear coolant for easy adaptation
- A dedicated range of inserts grades and geometries for all bolt hole applications



BT-A Drill

This innovative drill holder introduces T-A® replaceable insert technology to the BT-A deep hole drilling market. This allows for a significant reduction in BT-A head inventory requirements by offering interchangeable inserts and the ability to use alternative geometries including a dedicated BT geometry featuring a unique lip and point design for excellent chip control and a full insert polish to reduce edge build-up.

Available in 0-3 Series

Features and Benefits

- Maximum flexibility with a diameter range from 12.95 to 47.80mm
- Maximum drill depth 2.6 metres (as standard)
- Balanced cutting forces provide significantly increased penetration rates over brazed heads
- Laser clad bearing area, provides improved hole straightness
- Compatible with standard BTA-STS tubes



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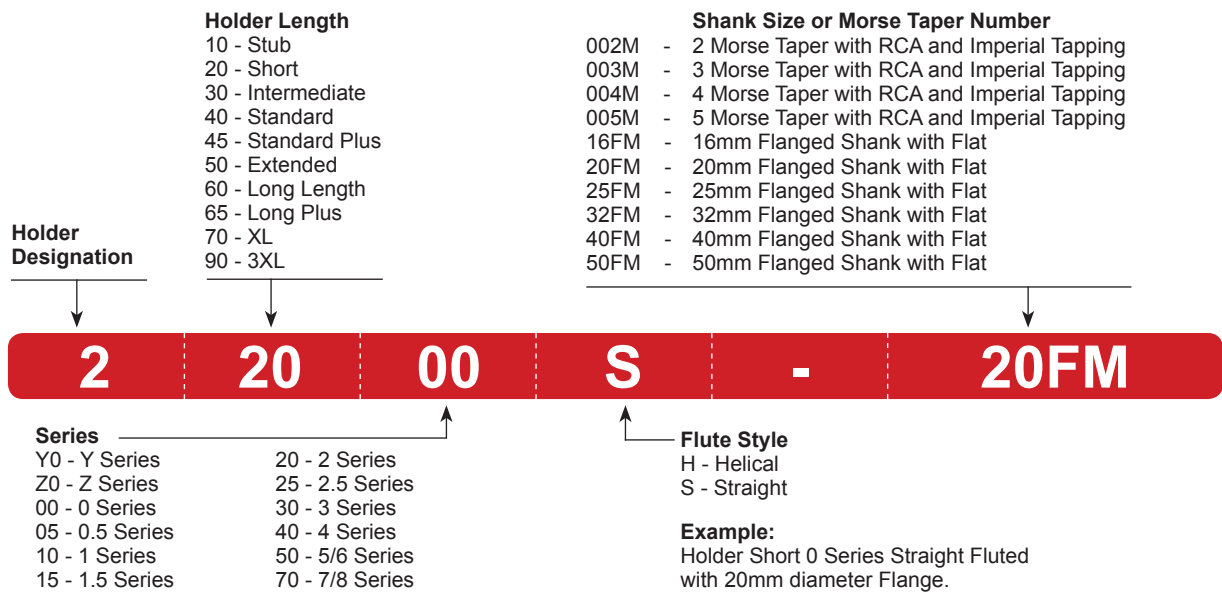


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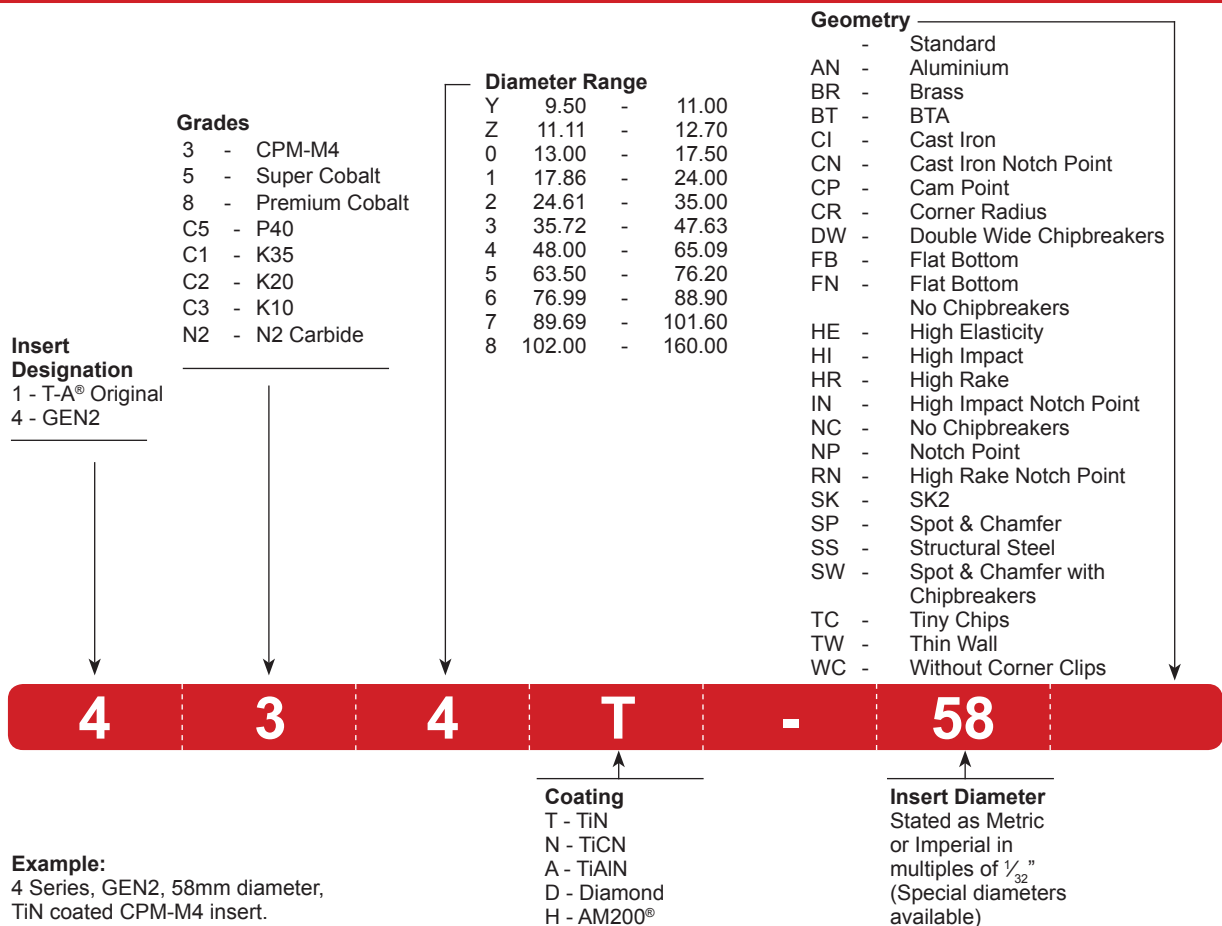
T-A® & GEN2 T-A® How to Identify Information



How to identify T-A® Holders



How to identify T-A® & GEN2 T-A® Drill Inserts



T-A® & GEN2 T-A® Series standard diameter range

Y = 9.50 to 11.07mm	4 = 46.99 to 65.28mm
Z = 11.10 to 12.95mm	5 = 62.38 to 76.20mm
0 = 12.98 to 17.65mm	6 = 76.23 to 89.08mm
1 = 17.53 to 24.38mm	7 = 87.76 to 101.60mm
2 = 24.41 to 35.05mm	8 = 101.63 to 160.00mm
3 = 34.37 to 47.80mm	

Please note: When ordering T-A® & GEN2 T-A® inserts ensure that the series ordered matches the T-A® tool holder

Example:

Tool holder - 21030S-40FM
Insert - 453H-36



Tool holder - 21030S-40FM
Insert - 452H-35





Insert Grades and Coatings

Grades

HSS CPM-M4

First choice for general purpose use, particularly suited for low rigidity difficult machining applications and deep hole drilling. Recommended for drilling most steels, cast irons and aluminium alloys up to 275 BHN 96kg.

HSS Super Cobalt

Particularly suited for good to rigid machining applications, primarily used for drilling exotic and high alloy materials, or general use when the M/min surface speed needs to be increased. For use in material hardness up to 350 BHN 121kg.

HSS Premium Cobalt

Particularly suited for rigid machining applications primarily used for drilling exotic and high alloy materials, or general use when the M/min surface speed needs to be increased. For use in material hardness up to 400 BHN 139kg.

P40 Carbide

Excellent choice for drilling free machining steel, low/medium carbon steels, alloy steels, high strength steels, tool steels and hardened steels.

K10 Carbide

AMEC's K10 insert is specifically designed for drilling grey/white cast irons. The special geometry offers substantial increase in penetration rates and provides exceptional edge strength and tool life.

K20 Carbide

Excellent choice for drilling high temperature alloys, titanium alloys, cast aluminium, wrought aluminium, SG/Nodular cast iron, grey/white iron, aluminium bronze, brass, copper, and certain stainless steels. Please refer to technical section.

K35 Carbide

Excellent choice for drilling free machining steel, low/medium carbon steels, alloy steels, high strength steels, tool steels and hardened steels.

N2 Carbide

AMEC's N2 carbide is used in conjunction with CVD diamond coating. This improves the inserts hardness, durability and performance extending tool life between 30 to 50 times over uncoated carbide.

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Coatings

AM200®

- First choice for increased heat resistance over TiN, TiCN and TiAlN with improved wear capabilities.
- Allows for improved tool life and higher penetration rates
- Over 20% increased tool life over TiAlN coating
- Colour Copper / Bronze



TiCN

- Excellent choice for wear resistance over low surface speeds
- High hardness/wear resistance
- Maximum working temperature 400°C
- Hardness HV 3500
- Colour Blue/Grey



TiN

- General purpose coating
- Improved tool life over a non coated insert
- Excellent choice for Aluminium
- Colour Gold/Yellow



TiAlN

- Excellent choice for wear resistance over high surface speeds
- Excellent oxidation resistance
- Maximum working temperature 800°C
- Hardness HV 3000
- Colour Violet/Grey



GEN2 T-A®

Geometries

GEN2 T-A® standard geometry offers substantial increases in penetration rates and tool life. As well as improved centring, smoother break-out on through holes, increased drill stability, improved chip formation, and lower drill forces.

Particularly suited for good to rigid machining applications, primarily used for drilling exotic and high alloy materials, or general use when the M/min surface speed needs to be increased

Point angle: 132° Y - 4 Series

144° 5 - 8 Series

BR, CR, HI, HR, NC, SK & WC geometries available for 5 - 8 series inclusive. See pages 11 - 14 for descriptions.

HE - High Elasticity

- Excellent chip formation in materials with very high elasticity/ductility, extremely poor chip forming characteristics.
- Effective in lower powered machines
- Material example: Low carbon steel (not suitable for stainless steel)
- Available as a non-stock standard, Y - 4 series inclusive
- Delivery 3 weeks - as a non-stock standard



Geometries

T-A® original standard geometry offers excellent penetration rates and tool life. Smooth break-out on through holes, drill stability and excellent chip formation characteristics. Particularly suited for low to high rigidity machining applications.

Also available with no chipbreakers (-NC) or without corner clips (-WC).

Point angle: 132° Y - 4 Series

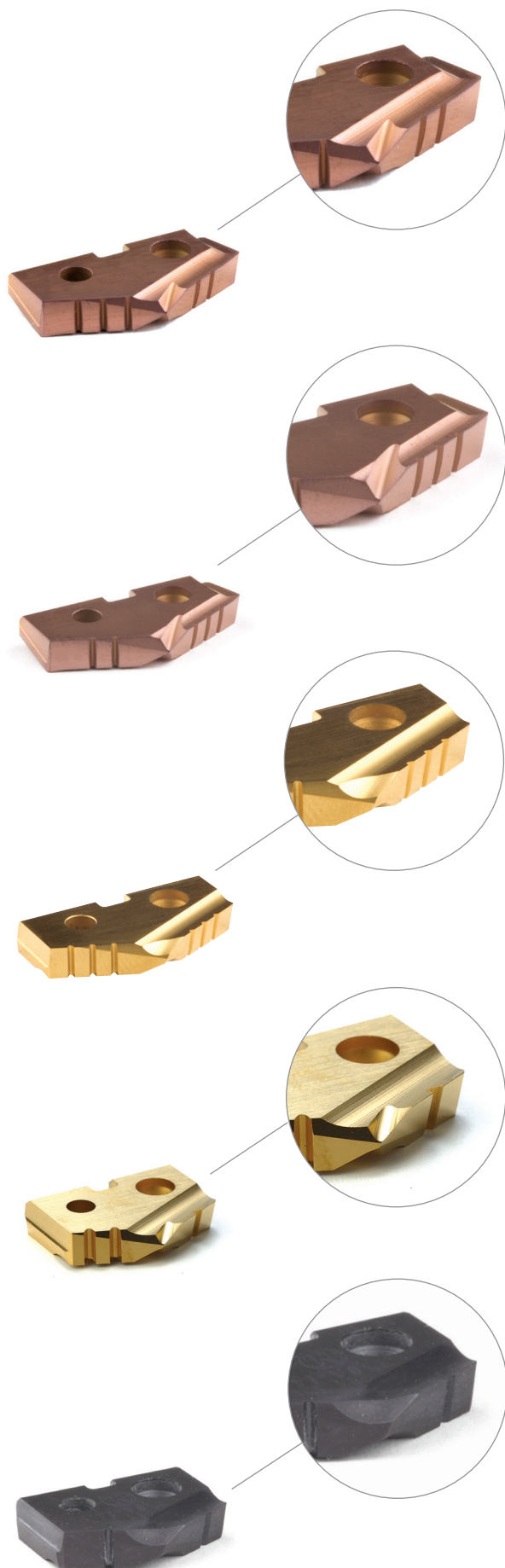
144° 5 - 8 Series

AN - Aluminium

- First choice for machining aluminium
- Enhanced geometry improves chip formation and improves hole quality
- TiN coating improves heat resistance and extends tool life
- Delivery 3 weeks - as a non-stock standard
- Delivery upon request, Y - 2 series inclusive

BR - Brass

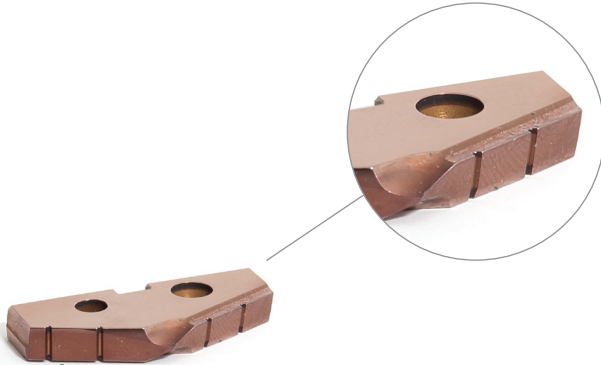
- Improved tool life due to our specialized geometry & edge preparation
- Reduced self feed tendency
- Available in all grades and coatings, Y - 2 series inclusive
- Delivery 3 weeks - as a non-stock standard





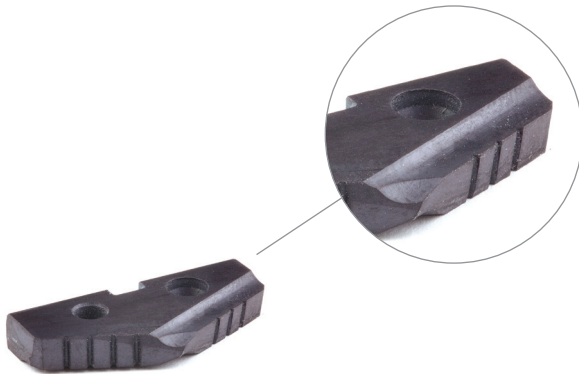
BT - BT-A geometry

- Specifically designed for use with our unique BT-A system
- Aimed at Deep Hole drilling machines that use neat cutting oil which does not disperse heat or evacuate the chip as easily soluble oil
- Unique lip and point design for excellent chip control
- Full insert polish to reduce edge build up
- Available in carbide or HSS grades with TiN, TiAlN, TiCN or AM200® coating, Y – 2 series inclusive
- Delivery 3 weeks – as a non-stock standard



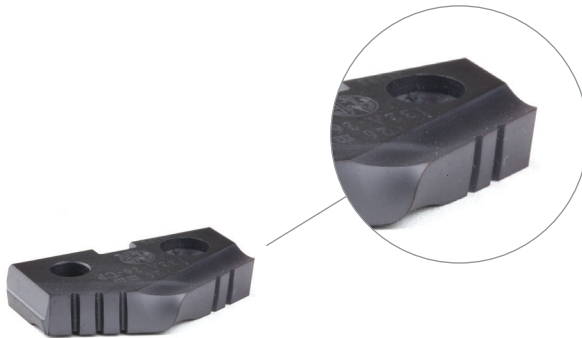
CI - Cast Iron

- Specifically designed for use in grey and white cast irons.
- Exceptional edge strength
- SK2 corner preparation for improved tool life
- Available in K10 (C3) carbide with TiAlN coating as a stock standard, Y – 2 series inclusive



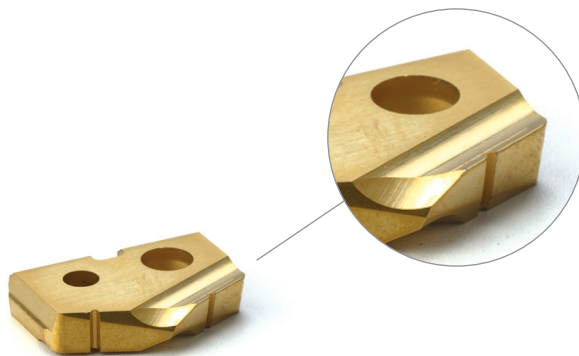
CP - Cam Point

- Helical cam ground point
- Improved drill stability and centring characteristics
- Reduction of bell mouthing when using longer holders
- Improved hole finish when using longer holders
- Target materials: Steels, cast/forged steels, cast iron
- Available in all grades and coatings, Y – 2 series inclusive
- Delivery 3 weeks - as a non-stock standard



CR - Corner Radius

- Improved exit burrs
- Excellent surface finishes in most applications
- Good heat dispersion, giving longer tool life in some applications
- Can be used in conjunction with other geometries, i.e. Flat Bottom.
- Available in all grades and coatings, Y - 2 series inclusive
- Delivery 3 weeks - as a non-stock standard





Geometries

DW - Double Wide (Oversized)

- 8 series inserts fit all existing 7 & 8 series holders
- Diameters available - 110mm, 120mm, 125mm, 130mm, 140mm, 150mm & 160mm
- Double-wide Chip Breakers to reduce thrust and power requirements and allow a reduced feed-rate whilst maintaining chip formation on most materials
- Super Cobalt grade and our proprietary AM200® coating provides increased heat resistance and improved wear capabilities
- Original chisel point offers excellent penetration rates and tool life
- Stocked in limited quantities, advanced planning is recommended
- Special Diameter up to 200mm available on request

FB - Flat Bottom

- First choice for flattening or squaring bottom of pre-existing holes with high rigidity
- When used with a stub or short length tool holder the insert may be used to counterbore holes larger than the pilot diameter (in some materials)
- Available in HSS Super Cobalt with TiN coating as stock standard
- Available in K20 Carbide with TiN coating as a non-stock standard - delivery 3 weeks, Y - 4 series inclusive
- Other coatings available upon request
- Also available as - FN (no chip breakers)

HI - High Impact

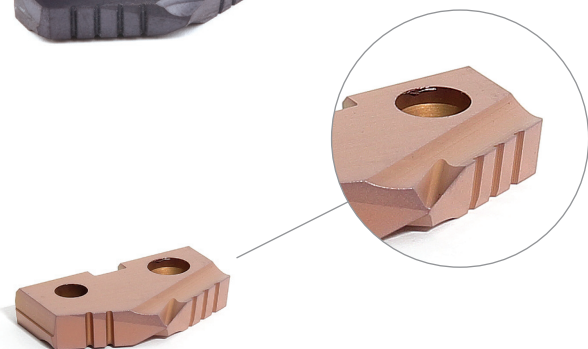
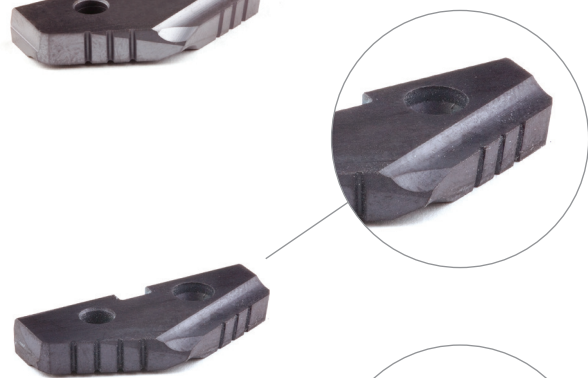
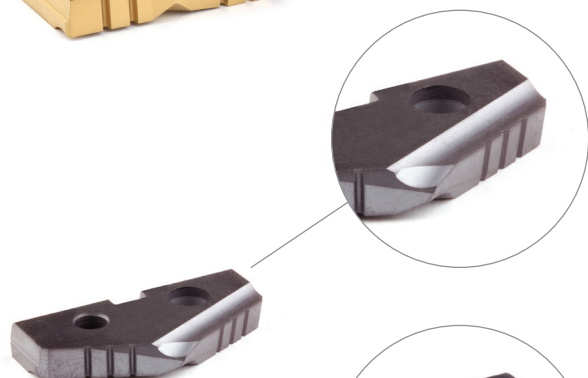
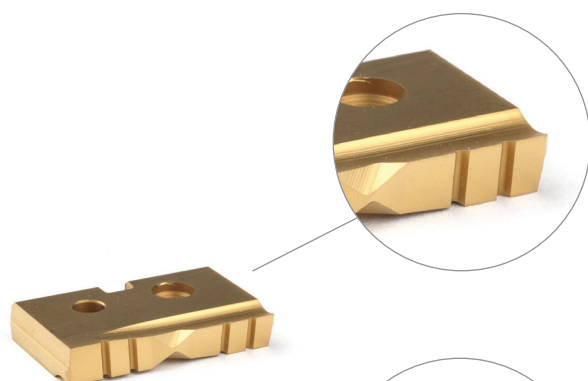
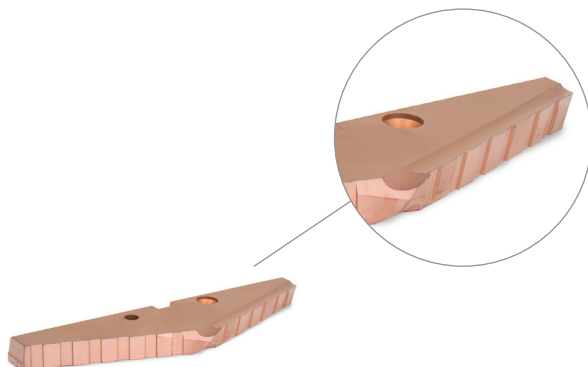
- For materials with hardness over 200 BHN (700 N/mm²)
- Enhances chip formation in materials with high elasticity/ductility and poor chip forming characteristics.
- SK corner clip for improved tool life
- Target materials, structural/cast and forged steels (not suitable for stainless steel)
- Available as a non-stock standard, Y - 2 series inclusive
- Delivery 3 weeks - as a non-stock standard

HR - High Rake

- For materials with hardness below 200 BHN (700 N/mm²)
- Improves chip formation in materials with very high elasticity/ductility, extremely poor chip forming characteristics, and low material hardness.
- SK corner clip for improved tool life
- Target materials: Soft steels, steel castings and forgings (not suitable for stainless steel)
- Available as a non-stock standard, Y - 2 series inclusive
- Delivery 3 weeks - as a non-stock standard

NP - Notch Point

- Reduced bell mouth and tool lead off
- Excellent stability in deep hole applications
- Reduced thrust
- Can be utilized in combination with other geometries including Cast Iron (-CN), High Rake (-RN), and High Impact (-IN)
- Y - 2 series inclusive





Geometries

T-A & BENZ T-A

GENSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPort 432

Criterion

Thread Milling

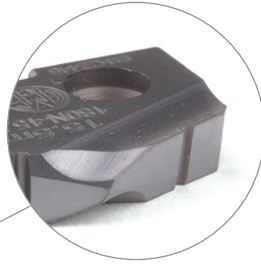
Special Tooling



Geometries

SK - Special Corner Preparation

- Ideal for machining cast iron materials
- Larger than standard corner clip
- Improved heat resistance
- Standard feature on CI, HI, HR geometries
- Available in all grades and coatings, Y - 2 series inclusive
- Delivery 3 weeks - as a non-stock standard



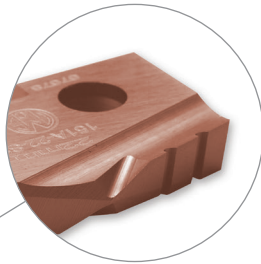
SP - Spot & Chamfer

- Highly efficient 90° Spot and Chamfer Drill Insert geometry
- Centre cutting web design for improved stability and strength
- Eliminates the need for secondary chamfering operation
- One tool will cover a wide range of applications by simply adjusting the depth
- By listing the item number with a SW, the 90° Spot and Chamfer Drill Insert will be supplied with chipbreakers
- Available in Super Cobalt, Y - 3 series inclusive
- Delivery 3 weeks - as a non-stock standard



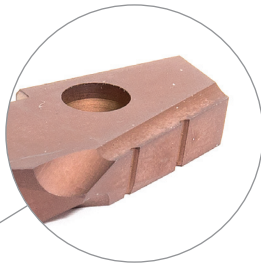
SS - Structural Steel

- 150° point angle for structural materials above 6mm thick
- Notch point design reduces exit burrs
- Available in AM200® and TiAlN coating which improves performance in oil mist applications
- Available as stock standard, 0 - 2 series inclusive



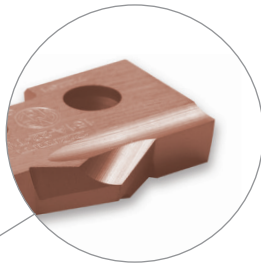
TC - Tiny Chips

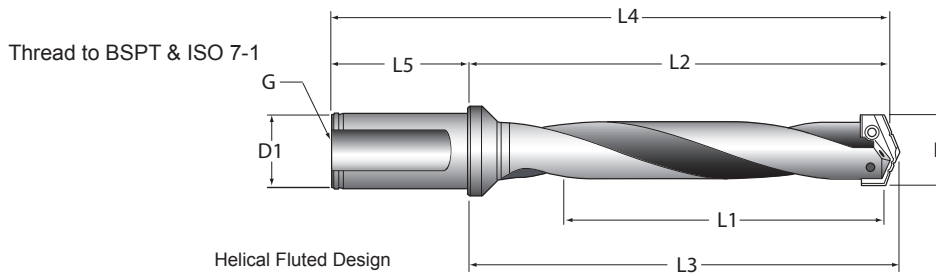
- Unique lip and point design for excellent chip control
- Improved capabilities in long-chipping materials such as low carbon steels and soft alloy steels
- Enhanced performance in lower powered machines allowing better chip formation at lower feed rates
- Available in carbide or HSS grades with TiN, TiAlN, TiCN or AM200® coating, Y - 2 series inclusive, as a non-stock standard
- Stocked in Super Cobalt with AM200® coating, 0 - 2 series inclusive



TW - Thin Wall

- Designed for thin wall material up to 6mm thick
- Excellent hole tolerance and hole quality
- Geometry allows for increased speeds and feeds which in turn increases productivity
- HSS Super Cobalt provides extraordinary toughness and wear resistance
- Available in AM200® and TiAlN coating which provides excellent heat resistance and improved tool life
- Available as stock standard, 0 - 2 series inclusive



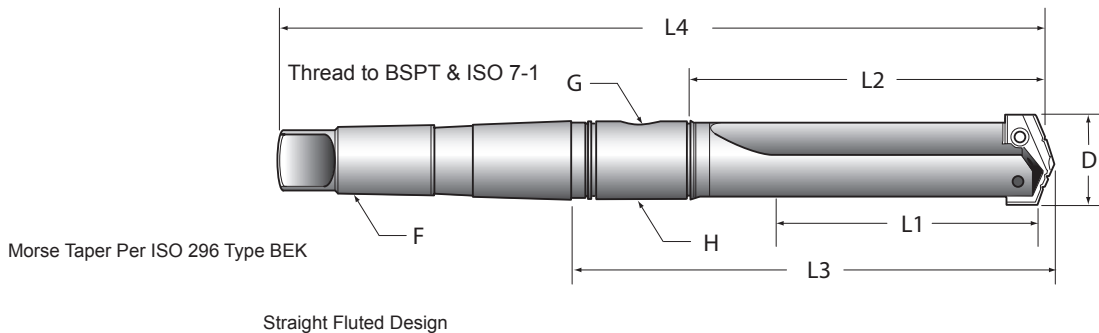


Flanged Straight Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	L5	D1	G	*
			Drill Range D (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Ref Length (mm)	Overall Length (mm)	Shank Length (mm)	Shank Diameter (mm)	Pipe Tap	
210Y0S-16FM	Stub	Straight	9.50-11.00	19	47.6	50.0	95.6	48	16.0	1/16"	1/8"
220Y0S-20FM	Short	Straight	9.50-11.00	32	61.1	63.5	111.1	50	20.0	1/8"	N/A
240Y0H-20FM	Standard	Helical	9.50-11.00	60	89.7	92.1	139.7	50	20.0	1/8"	N/A
N 245Y0H-20FM	Standard Plus	Helical	9.50-11.00	86	115.4	117.8	165.4	50	20.0	1/8"	N/A
⚠ 250Y0H-20FM	Extended	Helical	9.50-11.00	111	140.5	142.9	190.5	50	20.0	1/8"	N/A
⚠ 270Y0S-20FM	XL	Straight	9.50-11.00	222	251.7	254.1	301.7	50	20.0	1/8"	N/A
⚠ 290Y0S-20FM	3XL	Straight	9.50-11.00	290	319.9	322.3	369.9	50	20.0	1/8"	N/A

*Note: Stub Length includes additional side coolant port.



Taper Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	F	H	G
			Drill Range (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Length (mm)	Overall Length (mm)	MT	RCA	Pipe Tap
220Y0S-002M	Short	Straight	9.50-11.00	32	51.5	88	160.3	2	2SRM	1/16"
240Y0H-002M	Standard	Helical	9.50-11.00	60	80.2	116.7	188.9	2	2SRM	1/16"
⚠ 250Y0H-002M	Extended	Helical	9.50-11.00	111	130.9	167.4	239.7	2	2SRM	1/16"

N This symbol can be found throughout this catalogue and highlights NEW products!

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.



Y Series Inserts

Diameter Range 9.50 to 11.07mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Super Cobalt	9.50	0.3740	15YT-9.5	●	15YA-9.5	●	15YN-9.5	●
	9.53	0.3750	15YT-0012	○	15YA-0012	○	15YN-0012	○
	9.80	0.3860	15YT-.386	○	15YA-.386	○	15YN-.386	○
	9.92	0.3906	15YT-.390	○	15YA-.390	○	15YN-.390	○
	10.00	0.3937	15YT-10	●	15YA-10	●	15YN-10	●
	10.20	0.4016	15YT-10.2	●	15YA-10.2	●	15YN-10.2	●
	10.32	0.4063	15YT-0013	○	15YA-0013	○	15YN-0013	○
	10.50	0.4134	15YT-10.5	●	15YA-10.5	●	15YN-10.5	●
	10.72	0.4219	15YT-.421	○	15YA-.421	○	15YN-.421	○
	10.80	0.4252	15YT-10.8	●	15YA-10.8	●	15YN-10.8	●
	11.00	0.4331	15YT-11	●	15YA-11	●	15YN-11	●
HSS Premium Cobalt	9.50	0.3740	18YT-9.5	●	18YA-9.5	●	18YN-9.5	●
	9.53	0.3750	18YT-0012	○	18YA-0012	○	18YN-0012	○
	9.80	0.3860	18YT-.386	○	18YA-.386	○	18YN-.386	○
	9.92	0.3906	18YT-.390	○	18YA-.390	○	18YN-.390	○
	10.00	0.3937	18YT-10	●	18YA-10	●	18YN-10	●
	10.20	0.4016	18YT-10.2	●	18YA-10.2	●	18YN-10.2	●
	10.32	0.4063	18YT-0013	○	18YA-0013	○	18YN-0013	○
	10.50	0.4134	18YT-10.5	●	18YA-10.5	●	18YN-10.5	●
	10.72	0.4219	18YT-.421	○	18YA-.421	○	18YN-.421	○
	10.80	0.4252	18YT-10.8	●	18YA-10.8	●	18YN-10.8	●
	11.00	0.4331	18YT-11	●	18YA-11	●	18YN-11	●

Supplied in packs of 2



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	9.50	0.3740	1C2YT-9.5	●	1C2YA-9.5	●
	9.53	0.3750	1C2YT-0012	○	1C2YA-0012	○
	9.80	0.3860	1C2YT-.386	○	1C2YA-.386	○
	9.92	0.3906	1C2YT-.390	○	1C2YA-.390	○
	10.00	0.3937	1C2YT-10	●	1C2YA-10	●
	10.20	0.4016	1C2YT-10.2	●	1C2YA-10.2	●
	10.32	0.4063	1C2YT-0013	○	1C2YA-0013	○
	10.50	0.4134	1C2YT-10.5	●	1C2YA-10.5	●
	10.72	0.4219	1C2YT-.421	○	1C2YA-.421	○
	10.80	0.4252	1C2YT-10.8	●	1C2YA-10.8	●
	11.00	0.4331	1C2YT-11	●	1C2YA-11	●
P40 (C5) Carbide	9.50	0.3740	1C5YT-9.5	●	1C5YA-9.5	●
	9.53	0.3750	1C5YT-0012	○	1C5YA-0012	○
	9.80	0.3860	1C5YT-.386	○	1C5YA-.386	○
	9.92	0.3906	1C5YT-.390	○	1C5YA-.390	○
	10.00	0.3937	1C5YT-10	●	1C5YA-10	●
	10.20	0.4016	1C5YT-10.2	●	1C5YA-10.2	●
	10.32	0.4063	1C5YT-0013	○	1C5YA-0013	○
	10.50	0.4134	1C5YT-10.5	●	1C5YA-10.5	●
	10.72	0.4219	1C5YT-.421	○	1C5YA-.421	○
	10.80	0.4252	1C5YT-10.8	●	1C5YA-10.8	●
	11.00	0.4331	1C5YT-11	●	1C5YA-11	●

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

Y Series Inserts

Diameter Range 9.50 to 11.07mm



Cast Iron

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiAlN	Stk.
K10 (C3) Carbide	9.50	0.3740	1C3YA-9.5-CI	●
	9.53	0.3750	1C3YA-0012-CI	○
	9.80	0.3860	1C3YA-.386-CI	○
	9.92	0.3906	1C3YA-.390-CI	○
	10.00	0.3937	1C3YA-10-CI	●
	10.20	0.4016	1C3YA-10.2-CI	●
	10.32	0.4063	1C3YA-0013-CI	○
	10.50	0.4134	1C3YA-10.5-CI	●
	10.72	0.4219	1C3YA-.421-CI	○
	10.80	0.4252	1C3YA-10.8-CI	●
	11.00	0.4331	1C3YA-11-CI	●

Supplied in packs of 2

Coatings available as non-stock standard
H - AM200®
T - TiN
N - TiCN
(see page 10 for details)



90° Spot & Chamfer

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	9.50	0.3740	15YT-9.5-SP	◆
	9.53	0.3750	15YT-0012-SP	◆
	9.80	0.3860	15YT-.386-SP	◆
	9.92	0.3906	15YT-.390-SP	◆
	10.00	0.3937	15YT-10-SP	◆
	10.20	0.4016	15YT-10.2-SP	◆
	10.32	0.4063	15YT-0013-SP	◆
	10.50	0.4134	15YT-10.5-SP	◆
	10.72	0.4219	15YT-.421-SP	◆
	10.80	0.4252	15YT-10.8-SP	◆
	11.00	0.4331	15YT-11-SP	●

Supplied in packs of 2

Geometries available as non-stock standard
- SW
(see page 11 for details)

Coatings available as non-stock standard
H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)



Flat Bottom

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	9.50	0.3740	15YT-9.5-FB	○
	9.53	0.3750	15YT-0012-FB	○
	9.80	0.3860	15YT-.386-FB	○
	9.92	0.3906	15YT-.390-FB	○
	10.00	0.3937	15YT-10-FB	○
	10.20	0.4016	15YT-10.2-FB	○
	10.32	0.4063	15YT-0013-FB	○
	10.50	0.4134	15YT-10.5-FB	○
	10.72	0.4219	15YT-.421-FB	○
	10.80	0.4252	15YT-10.8-FB	○
	11.00	0.4331	15YT-11-FB	○

Supplied in packs of 2

Geometries available as non-stock standard
- FN
(see page 11 for details)

Coatings available as non-stock standard
H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)

Grades available as non-stock standard
K20 (C2)

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



Y Series Inserts

Diameter Range 9.50 to 11.07mm



Diamond Coated

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	Diamond	Stk.
N2	9.50	0.3740	1N2YD-9.5	◆
	9.53	0.3750	1N2YD-0012	◆
	9.80	0.3860	1N2YD-.386	◆
	9.92	0.3906	1N2YD-.390	◆
	10.00	0.3937	1N2YD-10	◆
	10.20	0.4016	1N2YD-10.2	◆
	10.32	0.4063	1N2YD-0013	◆
	10.50	0.4134	1N2YD-10.5	◆
	10.72	0.4219	1N2YD-.421	◆
	10.80	0.4252	1N2YD-10.8	◆
	11.00	0.4331	1N2YD-11	◆

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	9.50	0.3740	45YH-9.5	●
	9.53	0.3750	45YH-0012	○
	9.80	0.3860	45YH-.386	○
	9.92	0.3906	45YH-.390	○
	10.00	0.3937	45YH-10	●
	10.20	0.4016	45YH-10.2	●
	10.32	0.4063	45YH-0013	○
	10.50	0.4134	45YH-10.5	●
	10.72	0.4219	45YH-.421	○
	10.80	0.4252	45YH-10.8	●
	11.00	0.4331	45YH-11	●

Supplied in packs of 2



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K20 (C2) Carbide	9.50	0.3740	4C2YH-9.5	●
	9.53	0.3750	4C2YH-0012	○
	9.80	0.3860	4C2YH-.386	○
	9.92	0.3906	4C2YH-.390	○
	10.00	0.3937	4C2YH-10	●
	10.20	0.4016	4C2YH-10.2	●
	10.32	0.4063	4C2YH-0013	○
	10.50	0.4134	4C2YH-10.5	●
	10.72	0.4219	4C2YH-.421	○
	10.80	0.4252	4C2YH-10.8	●
	11.00	0.4331	4C2YH-11	●
K35 (C1) Carbide	9.50	0.3740	4C1YH-9.5	●
	9.53	0.3750	4C1YH-0012	○
	9.80	0.3860	4C1YH-.386	○
	9.92	0.3906	4C1YH-.390	○
	10.00	0.3937	4C1YH-10	●
	10.20	0.4016	4C1YH-10.2	●
	10.32	0.4063	4C1YH-0013	○
	10.50	0.4134	4C1YH-10.5	●
	10.72	0.4219	4C1YH-.421	○
	10.80	0.4252	4C1YH-10.8	●
	11.00	0.4331	4C1YH-11	●

Supplied in packs of 2

Geometries available as non-stock standard

- HE
(see page 11 for details)

Coatings available as non-stock standard

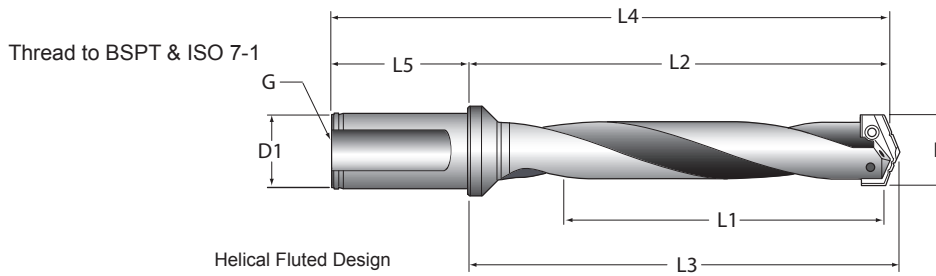
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

Geometries available as non-stock standard

- HE
(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

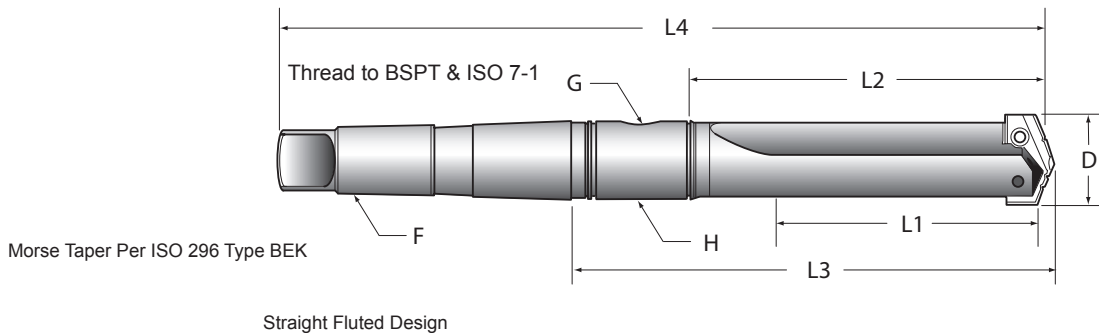


Flanged Straight Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	L5	D1	G	*
			Drill Range D (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Ref Length (mm)	Overall Length (mm)	Shank Length (mm)	Shank Diameter (mm)	Pipe Tap	
210Z0S-16FM	Stub	Straight	11.11-12.80	19.1	45.6	48.0	93.6	48	16.0	1/16"	1/8"
220Z0S-20FM	Short	Straight	11.11-12.80	32	61.1	63.5	111.1	50	20.0	1/8"	N/A
240Z0H-20FM	Standard	Helical	11.11-12.80	60	89.7	92.1	139.7	50	20.0	1/8"	N/A
N 245Z0H-20FM	Standard Plus	Helical	11.11-12.80	86	115.4	117.8	165.4	50	20.0	1/8"	N/A
⚠ 250Z0H-20FM	Extended	Helical	11.11-12.80	111	140.5	142.9	190.5	50	20.0	1/8"	N/A
N ⚠ 260Z0H-20FM	Long	Helical	11.11-12.80	180	209.4	211.8	259.4	50	20.0	1/8"	N/A
⚠ 270Z0S-20FM	XL	Straight	11.11-12.80	222.3	251.7	254.1	301.7	50	20.0	1/8"	N/A
⚠ 290Z0S-20FM	3XL	Straight	11.11-12.80	290.5	319.9	322.3	369.9	50	20.0	1/8"	N/A

*Note: Stub Length includes additional side coolant port.



Taper Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	F	H	G
			Drill Range (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Length (mm)	Overall Length (mm)	MT	RCA	Pipe Tap
220Z0S-002M	Short	Straight	11.11-12.80	32	51.5	88	160.3	2	2SRM	1/16"
240Z0H-002M	Standard	Helical	11.11-12.80	60	80.2	116.7	188.9	2	2SRM	1/16"
⚠ 250Z0H-002M	Extended	Helical	11.11-12.80	111	130.9	167.4	239.7	2	2SRM	1/16"

N This symbol can be found throughout this catalogue and highlights NEW products!

WARNING

For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.



Z Series Inserts

Diameter Range 11.10 to 12.95mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Super Cobalt	11.11	0.4375	15ZT-0014	○	15ZA-0014	○	15ZN-0014	○
	11.50	0.4528	15ZT-11.5	●	15ZA-11.5	●	15ZN-11.5	●
	11.51	0.4531	15ZT-.453	○	15ZA-.453	○	15ZN-.453	○
	11.91	0.4688	15ZT-0015	○	15ZA-0015	○	15ZN-0015	○
	12.00	0.4724	15ZT-12	●	15ZA-12	●	15ZN-12	●
	12.30	0.4844	15ZT-.484	○	15ZA-.484	○	15ZN-.484	○
	12.50	0.4921	15ZT-12.5	●	15ZA-12.5	●	15ZN-12.5	●
	12.70	0.5000	15ZT-0016	○	15ZA-0016	○	15ZN-0016	○
HSS Premium Cobalt	11.11	0.4375	18ZT-0014	○	18ZA-0014	○	18ZN-0014	○
	11.50	0.4528	18ZT-11.5	●	18ZA-11.5	●	18ZN-11.5	●
	11.51	0.4531	18ZT-.453	○	18ZA-.453	○	18ZN-.453	○
	11.91	0.4688	18ZT-0015	○	18ZA-0015	○	18ZN-0015	○
	12.00	0.4724	18ZT-12	●	18ZA-12	●	18ZN-12	●
	12.30	0.4844	18ZT-.484	○	18ZA-.484	○	18ZN-.484	○
	12.50	0.4921	18ZT-12.5	●	18ZA-12.5	●	18ZN-12.5	●
	12.70	0.5000	18ZT-0016	○	18ZA-0016	○	18ZN-0016	○
	12.80	0.5039	18ZT-12.8	●	18ZA-12.8	●	18ZN-12.8	●

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	11.11	0.4375	1C2ZT-0014	○	1C2ZA-0014	○
	11.50	0.4528	1C2ZT-11.5	●	1C2ZA-11.5	●
	11.51	0.4531	1C2ZT-.453	○	1C2ZA-.453	○
	11.91	0.4688	1C2ZT-0015	○	1C2ZA-0015	○
	12.00	0.4724	1C2ZT-12	●	1C2ZA-12	●
	12.30	0.4844	1C2ZT-.484	○	1C2ZA-.484	○
	12.50	0.4921	1C2ZT-12.5	●	1C2ZA-12.5	●
	12.70	0.5000	1C2ZT-0016	○	1C2ZA-0016	○
P40 (C5) Carbide	11.11	0.4375	1C5ZT-0014	○	1C5ZA-0014	○
	11.50	0.4528	1C5ZT-11.5	●	1C5ZA-11.5	●
	11.51	0.4531	1C5ZT-.453	○	1C5ZA-.453	○
	11.91	0.4688	1C5ZT-0015	○	1C5ZA-0015	○
	12.00	0.4724	1C5ZT-12	●	1C5ZA-12	●
	12.30	0.4844	1C5ZT-.484	○	1C5ZA-.484	○
	12.50	0.4921	1C5ZT-12.5	●	1C5ZA-12.5	●
	12.70	0.5000	1C5ZT-0016	○	1C5ZA-0016	○
	12.80	0.5039	1C5ZT-12.8	○	1C5ZA-12.8	○

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

Z Series Inserts

Diameter Range 11.10 to 12.95mm



Cast Iron

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiAlN	Stk.
K10 (C3) Carbide	11.11	0.4375	1C3ZA-0014-CI	○
	11.50	0.4528	1C3ZA-11.5-CI	●
	11.51	0.4531	1C3ZA-.453-CI	○
	11.91	0.4688	1C3ZA-0015-CI	○
	12.00	0.4724	1C3ZA-12-CI	●
	12.30	0.4844	1C3ZA-.484-CI	○
	12.50	0.4921	1C3ZA-12.5-CI	●
	12.70	0.5000	1C3ZA-0016-CI	○
	12.80	0.5039	1C3ZA-12.8-CI	○

Supplied in packs of 2

Coatings available as non-stock standard

H - AM200®
T - TiN
N - TiCN
(see page 10 for details)



90° Spot & Chamfer

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	11.11	0.4375	15ZT-0014-SP	◆
	11.50	0.4528	15ZT-11.5-SP	◆
	11.51	0.4531	15ZT-.453-SP	◆
	11.91	0.4688	15ZT-0015-SP	◆
	12.00	0.4724	15ZT-12-SP	◆
	12.30	0.4844	15ZT-.484-SP	◆
	12.50	0.4921	15ZT-12.5-SP	◆
	12.70	0.5000	15ZT-0016-SP	●
	12.80	0.5039	15ZT-12.8-SP	◆

Supplied in packs of 2

Geometries available as non-stock standard

- SW
(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)



Flat Bottom

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	11.11	0.4375	15ZT-0014-FB	○
	11.50	0.4528	15ZT-11.5-FB	○
	11.51	0.4531	15ZT-.453-FB	○
	11.91	0.4688	15ZT-0015-FB	○
	12.00	0.4724	15ZT-12-FB	○
	12.30	0.4844	15ZT-.484-FB	○
	12.50	0.4921	15ZT-12.5-FB	○
	12.70	0.5000	15ZT-0016-FB	○
	12.80	0.5039	15ZT-12.8-FB	○

Supplied in packs of 2

Geometries available as non-stock standard

- FN
(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)

Grades available as non-stock standard
K20 (C2)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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Special Tooling



Z Series Inserts

Diameter Range 11.10 to 12.95mm



Diamond Coated

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	Diamond	Stk.
N2	11.11	0.4375	1N2ZD-0014	◆
	11.50	0.4528	1N2ZD-11.5	◆
	11.51	0.4531	1N2ZD-.453	◆
	11.91	0.4688	1N2ZD-0015	◆
	12.00	0.4724	1N2ZD-12	◆
	12.30	0.4844	1N2ZD-.484	◆
	12.50	0.4921	1N2ZD-12.5	◆
	12.70	0.5000	1N2ZD-0016	◆
	12.80	0.5039	1N2ZD-12.8	◆

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	11.11	0.4375	45ZH-0014	○
	11.46	0.4510	45ZH-.451	○
	11.50	0.4528	45ZH-11.5	●
	11.51	0.4531	45ZH-.453	○
	11.91	0.4688	45ZH-0015	○
	12.00	0.4724	45ZH-12	●
	12.30	0.4844	45ZH-.484	○
	12.50	0.4921	45ZH-12.5	●
	12.70	0.5000	45ZH-0016	○
	12.80	0.5039	45ZH-12.8	○
	12.85	0.5060	45ZH-.506	○
	12.95	0.5100	45ZH-.510	○

Supplied in packs of 2



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K20 (C2) Carbide	11.11	0.4375	4C2ZH-0014	○
	11.50	0.4528	4C2ZH-11.5	●
	11.51	0.4531	4C2ZH-.453	○
	11.91	0.4688	4C2ZH-0015	○
	12.00	0.4724	4C2ZH-12	●
	12.30	0.4844	4C2ZH-.484	○
	12.50	0.4921	4C2ZH-12.5	●
	12.70	0.5000	4C2ZH-0016	○
	12.80	0.5039	4C2ZH-12.8	◆
	12.85	0.5060	4C2ZH-.506	○
K35 (C1) Carbide	11.11	0.4375	4C1ZH-0014	○
	11.50	0.4528	4C1ZH-11.5	●
	11.51	0.4531	4C1ZH-.453	◆
	11.91	0.4688	4C1ZH-0015	◆
	12.00	0.4724	4C1ZH-12	●
	12.30	0.4844	4C1ZH-.484	○
	12.50	0.4921	4C1ZH-12.5	●
	12.70	0.5000	4C1ZH-0016	○
	12.80	0.5039	4C1ZH-12.8	◆
	12.85	0.5060	4C1ZH-.506	○
	12.95	0.5100	4C1ZH-.510	○

Supplied in packs of 2

Geometries available as non-stock standard

- HE
(see page 11 for details)

Coatings available as non-stock standard

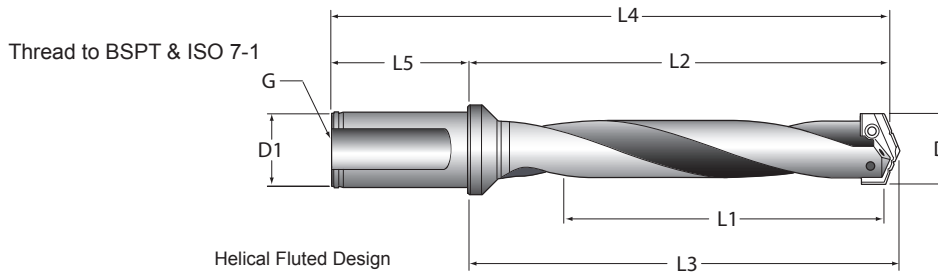
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

Geometries available as non-stock standard

- HE
(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

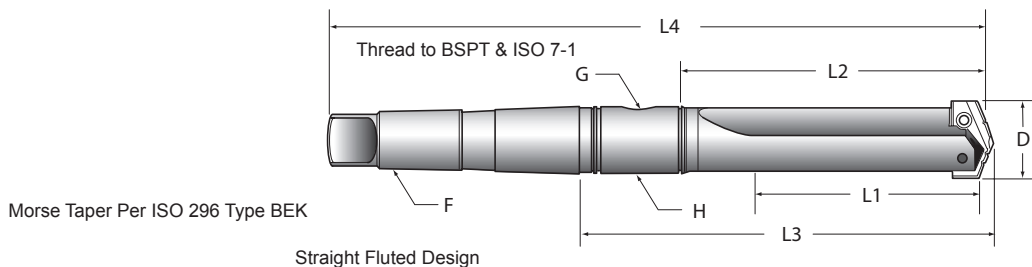


Flanged Straight Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	L5	D1	G	*
			Drill Range D (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Ref Length (mm)	Overall Length (mm)	Shank Length (mm)	Shank Diameter (mm)	Pipe Tap	
21000S-20FM	Stub	Straight	13.00-17.50	22	47.6	50.4	97.6	50	20.0	1/8"	1/8"
21005S-20FM	Stub	Straight	15.50-17.50	22	47.6	50.4	97.6	50	20.0	1/8"	N/A
22000S-20FM	Short	Straight	13.00-17.50	35	63.5	66.3	113.5	50	20.0	1/8"	N/A
22005S-20FM	Short	Straight	15.50-17.50	35	63.5	66.3	113.5	50	20.0	1/8"	N/A
24000S-20FM	Standard	Straight	13.00-17.50	64	92.1	94.9	142.1	50	20.0	1/8"	N/A
24000H-20FM	Standard	Helical	13.00-17.50	64	92.1	94.9	142.1	50	20.0	1/8"	N/A
24005H-20FM	Standard	Helical	15.50-17.50	64	92.1	94.9	142.1	50	20.0	1/8"	N/A
N 24500H-20FM	Standard Plus	Helical	13.00-17.50	89	117.6	120.4	167.6	50	20.0	1/8"	N/A
⚠ 25000H-20FM	Extended	Helical	13.00-17.50	114	142.9	145.7	192.9	50	20.0	1/8"	N/A
⚠ 25005H-20FM	Extended	Helical	15.50-17.50	114	142.9	145.7	192.9	50	20.0	1/8"	N/A
⚠ 26000H-20FM	Long	Helical	13.00-17.50	177	206.4	209.1	256.4	50	20.0	1/8"	N/A
⚠ 26005H-20FM	Long	Helical	15.50-17.50	177	206.4	209.1	256.4	50	20.0	1/8"	N/A
N ⚠ 26500H-20FM	Long Plus	Helical	13.00-17.50	240	268.6	271.4	318.6	50	20.0	1/8"	N/A
⚠ 27000S-20FM	XL	Straight	13.00-17.50	295	323.9	326.7	373.9	50	20.0	1/8"	N/A
⚠ 29000S-20FM	3XL	Straight	13.00-17.50	387	416.0	418.8	466.0	50	20.0	1/8"	N/A

*Note: Stub Length includes additional side coolant port.



Taper Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	F	H	G
			Drill Range (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Length (mm)	Overall Length (mm)	MT	RCA	Pipe Tap
22000S-002M	Short	Straight	13.00-17.50	35	55.5	92.4	164.3	2	2SRM	1/16"
22005S-002M	Short	Straight	15.50-17.50	35	55.5	92.4	164.3	2	2SRM	1/16"
24000H-002M	Standard	Helical	13.00-17.50	64	84.1	121	192.9	2	2SRM	1/16"
24005H-002M	Standard	Helical	15.50-17.50	64	84.1	121	192.9	2	2SRM	1/16"
⚠ 25000H-002M	Extended	Helical	13.00-17.50	114	135	171.8	243.7	2	2SRM	1/16"
⚠ 25005H-002M	Extended	Helical	15.50-17.50	114	135	171.8	243.7	2	2SRM	1/16"
⚠ 26000H-002M	Long	Helical	13.00-17.50	177	198.5	235.3	307.2	2	2SRM	1/16"
⚠ 26005H-002M	Long	Helical	15.50-17.50	177	198.5	235.3	307.2	2	2SRM	1/16"

N This symbol can be found throughout this catalogue and highlights NEW products!

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

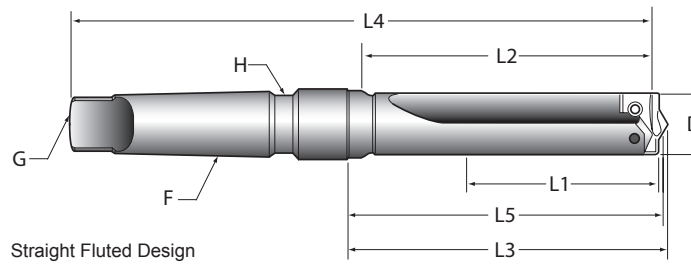
Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.



O Series Structural Steel Holders

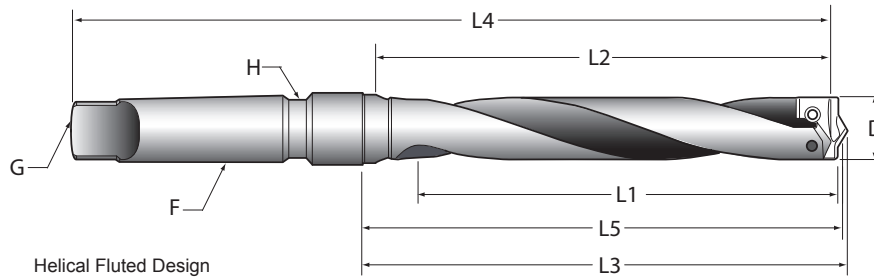


Straight Fluted Design

Short Length – Taper Shank Holders – Straight Flute

Part Number	D	L1	L2	L3	L5*	L4	F	Coolant Inlet		Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Through Tang Coolant	Through Shank Coolant	
22000S-003IS036	14	35	56	64.7	63.1	154	3	TTC	TSC	●
22005S-003IS040	16	35	56	64.7	63.1	154	3	TTC	TSC	●
22005S-003IS044	17.46	35	56	64.7	63.1	154	3	TTC	TSC	○

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.



Helical Fluted Design

Standard Length – Taper Shank Holders – Helical Flute

Part Number	D	L1	L2	L3	L5*	L4	F	Coolant Inlet		Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Through Tang Coolant	Through Shank Coolant	
24000H-003IS036	14	64	84	93.3	91.7	183	3	TTC	TSC	●
24005H-003IS040	16	64	84	93.3	91.7	183	3	TTC	TSC	●
24005H-003IS044	17.46	64	84	93.3	91.7	183	3	TTC	TSC	○

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

Extended Length – Taper Shank Holders – Helical Flute

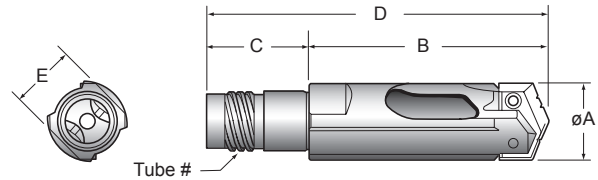
Part Number	D	L1	L2	L3	L5*	L4	F	Coolant Inlet		Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Through Tang Coolant	Through Shank Coolant	
⚠ 25000H-003IS036	14	165	240	248.8	243.7	338	3	TTC	TSC	●
⚠ 25005H-003IS044	17.5	165	240	248.8	243.7	338	3	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.
Visit www.alliedmaxcut.com for the most up-to-date information and procedures.
Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.

O Series BT-A Drill and Tubes

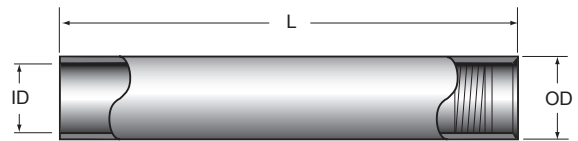


Metric Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (mm)	Reference Length (mm)	Shank Length (mm)	Overall Length (mm)	Wrench Flat (mm)	
0	BTA0-794-xx.xx	794	12.95-13.61	43.4	23	66.4	11	◆
	BTA0-795-xx.xx	795	13.62-14.63	44.6	23	67.6	12	◆
	BTA0-796-xx.xx	796	14.64-15.62	45.9	24	69.9	13	◆
	BTA0-797-xx.xx	797	15.63-16.71	45.9	24	69.9	14	◆
	BTA0-798-xx.xx	798	16.72-17.68	45.3	24	69.3	15	◆

Imperial Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (mm)	Reference Length (inch)	Shank Length (inch)	Overall Length (inch)	Wrench Flat (mm)	
0	BTA0-794-x.xxxx	794	0.5100-0.5359	1-45/64	29/32	2-39/64	11	◆
	BTA0-795-x.xxxx	795	0.5360-0.5759	1-3/4	29/32	2-21/32	12	◆
	BTA0-796-x.xxxx	796	0.5760-0.6149	1-13/16	61/64	2-3/4	13	◆
	BTA0-797-x.xxxx	797	0.6150-0.6579	1-13/16	61/64	2-3/4	14	◆
	BTA0-798-x.xxxx	798	0.6580-0.6959	1-25/32	61/64	2-47/64	15	◆



Metric Tubes

Tube Size	Tube Item Number	Metric				
		Diameter Range (mm)	Tube OD (mm)	Tube ID (mm)	Length (mm)	Stk.
794	BTAT794-63	12.78-13.59	11.0	7.0	1600	○
	BTAT794-102				2591	○
795	BTAT795-63	13.60-14.61	12.0	8.0	1600	○
	BTAT795-102				2591	○
796	BTAT796-63	14.62-15.60	13.0	8.5	1600	○
	BTAT796-102				2591	○
797	BTAT797-63	15.61-16.69	14.0	9.0	1600	○
	BTAT797-102				2591	○
798	BTAT798-63	16.70-17.68	15.0	10.0	1600	○
	BTAT798-102				2591	○

Imperial Tubes

Tube Size	Tube Item Number	Imperial				
		Diameter Range (Inch)	Tube OD (Inch)	Tube ID (Inch)	Length (Inch)	Stk.
794	BTAT794-63	0.503-0.535	0.433	0.276	63	○
	BTAT794-102				102	○
795	BTAT795-63	0.536-0.575	0.472	0.315	63	○
	BTAT795-102				102	○
796	BTAT796-63	0.576-0.614	0.512	0.335	63	○
	BTAT796-102				102	○
797	BTAT797-63	0.615-0.657	0.551	0.354	63	○
	BTAT797-102				102	○
798	BTAT798-63	0.658-0.696	0.591	0.394	63	○
	BTAT798-102				102	○



O Series Inserts

Diameter Range 13.00 to 17.50mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Super Cobalt	13.00	0.5118	150T-13	●	150A-13	●	150N-13	●
	13.10	0.5156	150T-.515	○	150A-.515	○	150N-.515	○
	13.49	0.5313	150T-0017	○	150A-0017	○	150N-0017	○
	13.50	0.5315	150T-13.5	●	150A-13.5	●	150N-13.5	●
	13.89	0.5469	150T-.546	○	150A-.546	○	150N-.546	○
	14.00	0.5512	150T-14	●	150A-14	●	150N-14	●
	14.29	0.5625	150T-0018	○	150A-0018	○	150N-0018	○
	14.50	0.5709	150T-14.5	●	150A-14.5	●	150N-14.5	●
	14.68	0.5781	150T-.578	○	150A-.578	○	150N-.578	○
	14.80	0.5827	150T-14.8	○	150A-14.8	●	150N-14.8	○
	15.00	0.5906	150T-15	●	150A-15	●	150N-15	●
	15.08	0.5938	150T-0019	○	150A-0019	○	150N-0019	○
	15.48	0.6094	150T-.609*	○	150A-.609*	○	150N-.609*	○
	15.50	0.6102	150T-15.5*	●	150A-15.5*	●	150N-15.5*	●
	15.88	0.6250	150T-0020*	○	150A-0020*	○	150N-0020*	○
	16.00	0.6299	150T-16*	●	150A-16*	●	150N-16*	●
	16.27	0.6406	150T-.640*	○	150A-.640*	○	150N-.640*	○
	16.50	0.6496	150T-16.5*	●	150A-16.5*	●	150N-16.5*	●
	16.67	0.6563	150T-0021*	○	150A-0021*	○	150N-0021*	○
	16.80	0.6614	150T-16.8*	○	150A-16.8	●	150N-16.8	○
	17.00	0.6693	150T-17*	●	150A-17*	●	150N-17*	●
	17.07	0.6719	150T-.671*	○	150A-.671*	○	150N-.671*	○
	17.46	0.6875	150T-0022*	○	150A-0022*	○	150N-0022*	○
	17.50	0.6890	150T-17.5*	●	150A-17.5*	●	150N-17.5*	●
HSS Premium Cobalt	13.00	0.5118	180T-13	●	180A-13	●	180N-13	●
	13.10	0.5156	180T-.515	○	180A-.515	○	180N-.515	○
	13.49	0.5313	180T-0017	○	180A-0017	○	180N-0017	○
	13.50	0.5315	180T-13.5	●	180A-13.5	●	180N-13.5	●
	13.89	0.5469	180T-.546	○	180A-.546	○	180N-.546	○
	14.00	0.5512	180T-14	●	180A-14	●	180N-14	●
	14.29	0.5625	180T-0018	○	180A-0018	○	180N-0018	○
	14.50	0.5709	180T-14.5	●	180A-14.5	●	180N-14.5	●
	14.68	0.5781	180T-.578	○	180A-.578	○	180N-.578	○
	14.80	0.5827	180T-14.8	●	180T-14.8	●	180T-14.8	●
	15.00	0.5906	180T-15	●	180A-15	●	180N-15	●
	15.08	0.5938	180T-0019	○	180A-0019	○	180N-0019	○
	15.48	0.6094	180T-.609*	○	180A-.609*	○	180N-.609*	○
	15.50	0.6102	180T-15.5*	●	180A-15.5*	●	180N-15.5*	●
	15.88	0.6250	180T-0020*	○	180A-0020*	○	180N-0020*	○
	16.00	0.6299	180T-16*	●	180A-16*	●	180N-16*	●
	16.27	0.6406	180T-.640*	○	180A-.640*	○	180N-.640*	○
	16.50	0.6496	180T-16.5*	●	180A-16.5*	●	180N-16.5*	●
	16.67	0.6563	180T-0021*	○	180A-0021*	○	180N-0021*	○
	17.00	0.6693	180T-17*	●	180A-17*	●	180N-17*	●
	17.07	0.6719	180T-.671*	○	180A-.671*	○	180N-.671*	○
	17.46	0.6875	180T-0022*	○	180A-0022*	○	180N-0022*	○
	17.50	0.6890	180T-17.5*	●	180A-17.5*	●	180N-17.5*	●

* Denotes inserts that will also fit 0.5 series T-A Holders

Supplied in packs of 2

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)

O Series Inserts

Diameter Range 12.98 to 17.65mm



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	13.00	0.5118	1C20T-13	●	1C20A-13	●
	13.10	0.5156	1C20T-.515	○	1C20A-.515	○
	13.49	0.5313	1C20T-0017	○	1C20A-0017	○
	13.50	0.5315	1C20T-13.5	●	1C20A-13.5	●
	13.89	0.5469	1C20T-.546	○	1C20A-.546	○
	14.00	0.5512	1C20T-14	●	1C20A-14	●
	14.29	0.5625	1C20T-0018	○	1C20A-0018	○
	14.50	0.5709	1C20T-14.5	●	1C20A-14.5	●
	14.68	0.5781	1C20T-.578	○	1C20A-.578	○
	14.80	0.5827	1C20T-14.8	○	1C20A-14.8	●
	15.00	0.5906	1C20T-15	●	1C20A-15	●
	15.08	0.5938	1C20T-0019	○	1C20A-0019	○
	15.48	0.6094	1C20T-.609*	○	1C20A-.609*	○
	15.50	0.6102	1C20T-15.5*	●	1C20A-15.5*	●
	15.70	0.6181	1C20T-.618	○	1C20A-.618	○
	15.88	0.6250	1C20T-0020*	○	1C20A-0020*	○
	16.00	0.6299	1C20T-16*	●	1C20A-16*	●
	16.27	0.6406	1C20T-.640*	○	1C20A-.640*	○
	16.50	0.6496	1C20T-16.5*	●	1C20A-16.5*	●
	16.67	0.6563	1C20T-0021*	○	1C20A-0021*	○
	16.80	0.6614	1C20T-16.8*	○	1C20A-16.8	●
	17.00	0.6693	1C20T-17*	●	1C20A-17*	●
P40 (C5) Carbide	17.07	0.6719	1C20T-.671*	○	1C20A-.671*	○
	17.46	0.6875	1C20T-0022*	○	1C20A-0022*	○
	17.50	0.6890	1C20T-17.5*	●	1C20A-17.5*	●
	13.00	0.5118	1C50T-13	●	1C50A-13	●
	13.10	0.5156	1C50T-.515	○	1C50A-.515	○
	13.49	0.5313	1C50T-0017	○	1C50A-0017	○
	13.50	0.5315	1C50T-13.5	●	1C50A-13.5	●
	13.89	0.5469	1C50T-.546	○	1C50A-.546	○
	14.00	0.5512	1C50T-14	●	1C50A-14	●
	14.29	0.5625	1C50T-0018	○	1C50A-0018	○
	14.50	0.5709	1C50T-14.5	●	1C50A-14.5	●
	14.68	0.5781	1C50T-.578	○	1C50A-.578	○
	14.80	0.5827	1C50T-14.8	●	1C50A-14.8	●
	15.00	0.5906	1C50T-15	●	1C50A-15	●
	15.08	0.5938	1C50T-0019	○	1C50A-0019	○
	15.48	0.6094	1C50T-.609*	○	1C50A-.609*	○
	15.50	0.6102	1C50T-15.5*	●	1C50A-15.5*	●
	15.70	0.6181	1C50T-.618	○	1C50A-.618	○
	15.88	0.6250	1C50T-0020*	○	1C50A-0020*	○
	15.91	0.6265	1C50T-.6265*	○	1C50A-.6265	○
	16.00	0.6299	1C50T-16*	●	1C50A-16*	●
	16.27	0.6406	1C50T-.640*	○	1C50A-.640*	○
	16.50	0.6496	1C50T-16.5*	●	1C50A-16.5*	●
	16.67	0.6563	1C50T-0021*	○	1C50A-0021*	○
	17.00	0.6693	1C50T-17*	●	1C50A-17*	●
	17.07	0.6719	1C50T-.671*	○	1C50A-.671*	○
	17.46	0.6875	1C50T-0022*	○	1C50A-0022*	○
	17.50	0.6890	1C50T-17.5*	●	1C50A-17.5*	●

Geometries available as non-stock standard

- AN - CI
- BR - IN
- BT - NC
- CN - NP
- CP - RN
- CR - SK
- HI - TC
- HR - WC

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

(see page 10 for details)

* Denotes inserts that will also fit 0.5 series T-A Holders

Supplied in packs of 2

T-A & BENZ T-A

BENZSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



O Series Inserts

Diameter Range 12.98 to 17.65mm



Cast Iron

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiAlN	Stk.
K10 (C3) Carbide	13.00	0.5118	1C30A-13-CI	●
	13.10	0.5156	1C30A-.515-CI	○
	13.49	0.5313	1C30A-0017-CI	○
	13.50	0.5315	1C30A-13.5-CI	●
	13.89	0.5469	1C30A-.546-CI	○
	14.00	0.5512	1C30A-14-CI	●
	14.29	0.5625	1C30A-0018-CI	○
	14.50	0.5709	1C30A-14.5-CI	●
	14.68	0.5781	1C30A-.578-CI	○
	14.80	0.5827	1C30A-14.8-CI	◆
	15.00	0.5906	1C30A-15-CI	●
	15.08	0.5938	1C30A-0019-CI	○
	15.48	0.6094	1C30A-.609-CI*	○
	15.50	0.6102	1C30A-15.5-CI*	●
	15.70	0.6181	1C30A-.618-CI	◆
	15.88	0.6250	1C30A-0020-CI*	○
	16.00	0.6299	1C30A-16-CI*	●
	16.27	0.6406	1C30A-.640-CI*	○
	16.50	0.6496	1C30A-16.5-CI*	●
	16.67	0.6563	1C30A-0021-CI*	○
	17.00	0.6693	1C30A-17-CI*	●
	17.07	0.6719	1C30A-.671-CI*	○
	17.46	0.6875	1C30A-0022-CI*	○
	17.50	0.6890	1C30A-17.5-CI*	●

* Denotes inserts that will also fit 0.5 series T-A Holders

Supplied in packs of 2

Coatings available as non-stock standard
H - AM200®
T - TiN
N - TiCN
(see page 10 for details)



Tiny Chip

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	13.00	0.5118	150H-13-TC	○
	13.50	0.5315	150H-13.5-TC	○
	14.00	0.5512	150H-14-TC	○
	14.50	0.5709	150H-14.5-TC	○
	15.00	0.5906	150H-15-TC	○
	15.50	0.6102	150H-15.5-TC*	○
	16.00	0.6299	150H-16-TC*	○
	16.50	0.6496	150H-16.5-TC*	○
	17.00	0.6693	150H-17-TC*	○
	17.50	0.6890	150H-17.5-TC*	○

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

* Denotes inserts that will also fit 0.5 series T-A Holder

Supplied in packs of 2



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0 Series Inserts

Diameter Range 12.98 to 17.65mm



90° Spot & Chamfer

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	13.00	0.5118	150T-13-SP	◆
	13.10	0.5156	150T-.515-SP	◆
	13.49	0.5313	150T-0017-SP	◆
	13.50	0.5315	150T-13.5-SP	◆
	13.89	0.5469	150T-.546-SP	◆
	14.00	0.5512	150T-14-SP	◆
	14.29	0.5625	150T-0018-SP	◆
	14.50	0.5709	150T-14.5-SP	◆
	14.68	0.5781	150T-.578-SP	◆
	14.80	0.5827	150T-14.8-SP	◆
	15.00	0.5906	150T-15-SP	◆
	15.08	0.5938	150T-0019-SP	◆
	15.48	0.6094	150T-.609-SP*	◆
	15.50	0.6102	150T-15.5-SP*	◆
	15.88	0.6250	150T-0020-SP*	◆
	16.00	0.6299	150T-16-SP*	◆
	16.27	0.6406	150T-640-SP*	◆
	16.50	0.6496	150T-16.5-SP*	◆
	16.67	0.6563	150T-0021-SP*	◆
	17.00	0.6693	150T-17-SP*	◆
	17.07	0.6719	150T-.671-SP*	◆
	17.46	0.6875	150T-0022-SP*	◆
	17.50	0.6890	150T-17.5-SP*	●

* Denotes inserts that will also fit 0.5 series T-A Holder

Supplied in packs of 2

Geometries available as non-stock standard

- SW
(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)



Thin Wall (for Structural Steel material up to 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200	Stk.
HSS Super Cobalt	14.00	0.5512	150A-14-TW	●	150H-14-TW	●
	14.29	0.5625	150A-0018-TW	○	150H-0018-TW	○
	15.88	0.6250	150A-0020-TW	○	150H-0020-TW	○
	16.00	0.6299	150A-16-TW	●	150H-16-TW	●
	17.46	0.6875	150A-0022-TW	○	150H-0022-TW	○

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN
N - TiCN
(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardness and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



O Series Inserts

Diameter Range 12.98 to 17.65mm



Notch Point (for Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	14.00	0.5512	150A-14-NP	●	150H-14-NP	●
	14.29	0.5625	150A-0018-NP	○	150H-0018-NP	○
	15.88	0.6250	150A-0020-NP	○	150H-0020-NP	○
	16.00	0.6299	150A-16-NP	●	150H-16-NP	●
	17.46	0.6875	150A-0022-NP	○	150H-0022-NP	○

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



150° Structural Steel (reduced exit burr on Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	14.00	0.5512	150A-14-SS	●	150H-14-SS	●
	14.29	0.5625	150A-0018-SS	○	150H-0018-SS	○
	15.88	0.6250	150A-0020-SS	○	150H-0020-SS	○
	16.00	0.6299	150A-16-SS	●	150H-16-SS	●
	17.46	0.6875	150A-0022-SS	○	150H-0022-SS	○

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



Flat Bottom

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	13.00	0.5118	150T-13-FB	○
	13.10	0.5156	150T-.515-FB	○
	13.49	0.5313	150T-0017-FB	○
	13.50	0.5315	150T-13.5-FB	○
	14.00	0.5512	150T-14-FB	○
	14.29	0.5625	150T-0018-FB	○
	14.50	0.5709	150T-14.5-FB	○
	14.68	0.5781	150T-.578-FB	○
	14.80	0.5827	150T-14.8-FB	○
	15.00	0.5906	150T-15-FB	○
	15.08	0.5938	150T-0019-FB	○
	15.50	0.6102	150T-15.5-FB	○
	15.88	0.6250	150T-0020-FB*	○
	16.00	0.6299	150T-16-FB*	○
	16.50	0.6496	150T-16.5-FB*	○
	16.67	0.6563	150T-0021-FB*	○
	17.00	0.6693	150T-17-FB*	○
	17.46	0.6875	150T-0022-FB*	○
	17.50	0.6890	150T-17.5-FB*	○

* Denotes inserts that will also fit 0.5 series T-A Holder

Supplied in packs of 2

Geometries available as non-stock standard

- FN

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

A - TiAlN

(see page 10 for details)

Grades available as non-stock standard

K20 (C2)

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

● Stock Item.

○ Stocked in limited quantities, advanced planning is recommended.

◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

0 Series Inserts

Diameter Range 12.98 to 17.65mm



Diamond Coated

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	Diamond	Stk.
N2	13.00	0.5118	1N20D-13	◆
	13.10	0.5156	1N20D-.515	◆
	13.49	0.5313	1N20D-0017	◆
	13.50	0.5315	1N20D-13.5	◆
	13.89	0.5469	1N20D-.546	◆
	14.00	0.5512	1N20D-14	◆
	14.29	0.5625	1N20D-0018	◆
	14.50	0.5709	1N20D-14.5	◆
	14.68	0.5781	1N20D-.578	◆
	14.80	0.5827	1N20D-14.8	◆
	15.00	0.5906	1N20D-15	◆
	15.08	0.5938	1N20D-0019	◆
	15.48	0.6094	1N20D-.609	◆
	15.50	0.6102	1N20D-15.5	◆
	15.88	0.6250	1N20D-0020	◆
	16.00	0.6299	1N20D-16	◆
	16.27	0.6406	1N20D-640	◆
	16.50	0.6496	1N20D-16.5	◆
	16.67	0.6563	1N20D-0021	◆
	17.00	0.6693	1N20D-17	◆
	17.07	0.6719	1N20D-.671	◆
	17.46	0.6875	1N20D-0022	◆
	17.50	0.6890	1N20D-17.5	◆

* Denotes inserts that will also fit 0.5 series T-A Holder

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	13.00	0.5118	450H-13	●
	13.10	0.5156	450H-.515	○
	13.49	0.5313	450H-0017	○
	13.50	0.5315	450H-13.5	●
	13.89	0.5469	450H-.546	○
	14.00	0.5512	450H-14	●
	14.29	0.5625	450H-0018	○
	14.50	0.5709	450H-14.5	●
	14.68	0.5781	450H-.578	○
	14.80	0.5827	450H-14.8	○
	15.00	0.5906	450H-15	●
	15.08	0.5938	450H-0019	○
	15.48	0.6094	450H-.609*	○
	15.50	0.6102	450H-15.5*	●
	15.88	0.6250	450H-0020*	○
	16.00	0.6299	450H-16*	●
	16.27	0.6406	450H-640*	○
	16.50	0.6496	450H-16.5*	●
	16.67	0.6563	450H-0021*	○
	16.80	0.6614	450H-16.8*	○
	17.00	0.6693	450H-17*	●
	17.07	0.6719	450H-.671*	○
	17.46	0.6875	450H-0022*	○
	17.50	0.6890	450H-17.5*	●

* Denotes inserts that will also fit 0.5 series T-A Holder

Supplied in packs of 2

Geometries available as non-stock standard

- HE
(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)



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T-A & GEN2 T-A

GENSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



O Series Inserts

Diameter Range 12.98 to 17.65mm

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K20 (C2) Carbide	13.00	0.5118	4C20H-13	●
	13.10	0.5156	4C20H-.515	○
	13.49	0.5313	4C20H-0017	○
	13.50	0.5315	4C20H-13.5	●
	13.89	0.5469	4C20H-.546	○
	14.00	0.5512	4C20H-14	●
	14.29	0.5625	4C20H-0018	○
	14.50	0.5709	4C20H-14.5	●
	14.68	0.5781	4C20H-.578	○
	14.80	0.5827	4C20H-14.8	◆
	15.00	0.5906	4C20H-15	●
	15.08	0.5938	4C20H-0019	○
	15.48	0.6094	4C20H-.609*	○
	15.50	0.6102	4C20H-15.5*	●
	15.70	0.6181	4C20H-.618	○
	15.88	0.6250	4C20H-0020*	○
	16.00	0.6299	4C20H-16*	●
	16.27	0.6406	4C20H-.640*	○
	16.50	0.6496	4C20H-16.5*	●
	16.67	0.6563	4C20H-0021*	○
	16.80	0.6614	4C20H-16.8*	◆
	17.00	0.6693	4C20H-17*	●
	17.07	0.6719	4C20H-.671*	○
	17.46	0.6875	4C20H-0022*	○
	17.50	0.6890	4C20H-17.5*	●

* Denotes inserts that will also fit 0.5 series T-A Holder

Supplied in packs of 2

Geometries available as non-stock standard
- HE
(see page 11 for details)

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K35 (C1) Carbide	13.00	0.5118	4C10H-13	●
	13.10	0.5156	4C10H-.515	○
	13.49	0.5313	4C10H-0017	○
	13.50	0.5315	4C10H-13.5	●
	13.89	0.5469	4C10H-.546	○
	14.00	0.5512	4C10H-14	●
	14.29	0.5625	4C10H-0018	○
	14.50	0.5709	4C10H-14.5	●
	14.68	0.5781	4C10H-.578	◆
	14.80	0.5827	4C10H-14.8	◆
	15.00	0.5906	4C10H-15	●
	15.08	0.5938	4C10H-0019	○
	15.48	0.6094	4C10H-.609*	○
	15.50	0.6102	4C10H-15.5*	●
	15.70	0.6181	4C10H-.618	◆
	15.88	0.6250	4C10H-0020*	○
	16.00	0.6299	4C10H-16*	●
	16.27	0.6406	4C10H-.640*	○
	16.50	0.6496	4C10H-16.5*	●
	16.67	0.6563	4C10H-0021*	○
	16.80	0.6614	4C10H-16.8*	◆
	17.00	0.6693	4C10H-17*	●
	17.07	0.6719	4C10H-.671*	◆
	17.46	0.6875	4C10H-0022*	○
	17.50	0.6890	4C10H-17.5*	●

* Denotes inserts that will also fit 0.5 series T-A Holder

Supplied in packs of 2

Geometries available as non-stock standard
- HE
(see page 11 for details)

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)



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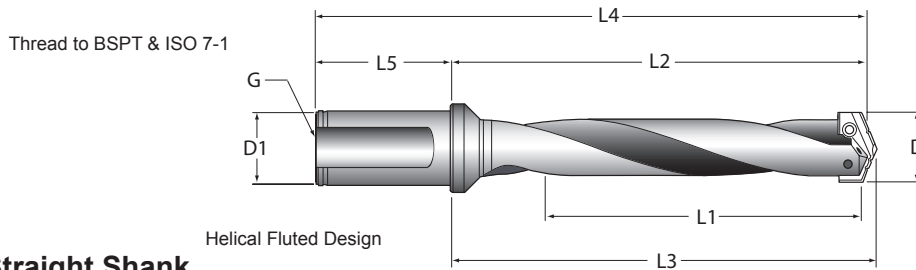


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1 Series Holders

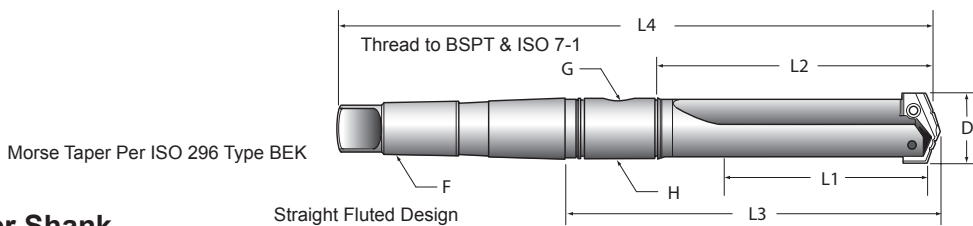


Flanged Straight Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D Drill Range D (mm)	L1 Max Drill Depth (mm)	L2 Body Length (mm)	L3 New Tool Ref Length (mm)	L4 Overall Length (mm)	L5 Shank Length (mm)	D1 Shank Diameter (mm)	G	*
21010S-25FM	Stub	Straight	18.00-24.00	47	75.8	79.4	131.8	56	25.0	1/8"	1/8"
21015S-25FM	Stub	Straight	22.00-24.00	57	88.5	92.1	144.5	56	25.0	1/8"	1/8"
22010S-25FM	Short	Straight	18.00-24.00	67	107.2	110.7	163.2	56	25.0	1/8"	N/A
22015S-25FM	Short	Straight	22.00-24.00	67	107.2	110.7	163.2	56	25.0	1/8"	N/A
23010S-25FM	Intermediate	Straight	18.00-24.00	118	154.8	158.4	210.8	56	25.0	1/8"	N/A
23015S-25FM	Intermediate	Straight	22.00-24.00	118	154.8	158.4	210.8	56	25.0	1/8"	N/A
23010H-25FM	Intermediate	Helical	18.00-24.00	118	154.8	158.4	210.8	56	25.0	1/8"	N/A
23015H-25FM	Intermediate	Helical	22.00-24.00	118	154.8	158.4	210.8	56	25.0	1/8"	N/A
24010S-25FM	Standard	Straight	18.00-24.00	168	205.6	209.2	261.6	56	25.0	1/8"	N/A
24015S-25FM	Standard	Straight	22.00-24.00	168	205.6	209.2	261.6	56	25.0	1/8"	N/A
24010H-25FM	Standard	Helical	18.00-24.00	168	205.6	209.2	261.6	56	25.0	1/8"	N/A
24015H-25FM	Standard	Helical	22.00-24.00	168	205.6	209.2	261.6	56	25.0	1/8"	N/A
N 24510H-25FM	Standard Plus	Helical	18.00-24.00	219	256.3	259.9	312.3	56	25.0	1/8"	N/A
⚠ 25010H-25FM	Extended	Helical	18.00-24.00	270	307.2	310.8	363.2	56	25.0	1/8"	N/A
⚠ 25015H-25FM	Extended	Helical	22.00-24.00	270	307.2	310.8	363.2	56	25.0	1/8"	N/A
N ⚠ 26010H-25FM	Long Length	Helical	18.00-24.00	365	402.3	405.9	458.3	56	25.0	1/8"	N/A
⚠ 27010S-25FM	XL	Straight	18.00-24.00	457	494.5	498.1	550.5	56	25.0	1/8"	N/A
⚠ 29010S-25FM	3XL	Straight	18.00-24.00	565	602.5	606.1	658.5	56	25.0	1/8"	N/A

*Note: Stub Length includes additional side coolant port.



Taper Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D Drill Range (mm)	L1 Max Drill Depth (mm)	L2 Body Length (mm)	L3 New Tool Length (mm)	L4 Overall Length (mm)	F MT	H RCA	G Pipe Tap
22010S-003M	Short	Straight	18.00-24.00	70	98.4	142.5	232.5	3	3SRM	1/8"
22015S-003M	Short	Straight	22.00-24.00	70	98.4	142.5	232.5	3	3SRM	1/8"
23010H-003M	Intermediate	Helical	18.00-24.00	121	149.2	193.3	283.3	3	3SRM	1/8"
23015H-003M	Intermediate	Helical	22.00-24.00	121	149.2	193.3	283.3	3	3SRM	1/8"
24010H-003M	Standard	Helical	18.00-24.00	172	200	244.1	334.2	3	3SRM	1/8"
24015H-003M	Standard	Helical	22.00-24.00	172	200	244.1	334.2	3	3SRM	1/8"
⚠ 25010H-003M	Extended	Helical	18.00-24.00	273	301.6	345.7	435.8	3	3SRM	1/8"
⚠ 25015H-003M	Extended	Helical	22.00-24.00	273	301.6	345.7	435.8	3	3SRM	1/8"

N This symbol can be found throughout this catalogue and highlights NEW products!

WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

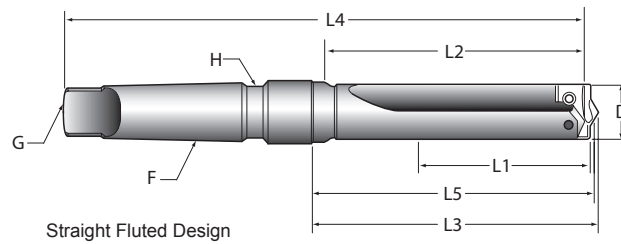
Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.

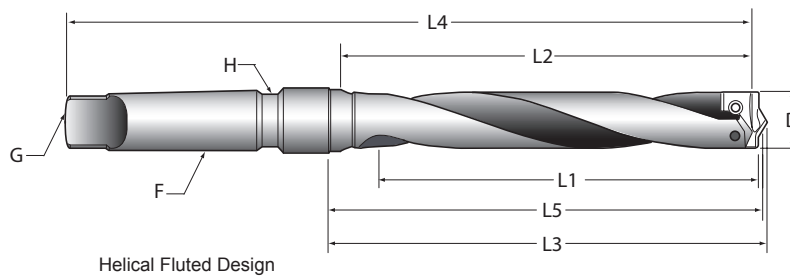


1 Series Structural Steel Holders



Short Length – Taper Shank Holders – Straight Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet Through Tang Coolant	Coolant Inlet Through Shank Coolant	
22010S-003IS045	18	70	89	108.4	106.8	197	3	TTC	TSC	○
22010S-004IS045	18	70	98	109.9	108.3	222	4	TTC	TSC	●
22015S-003IS056	22	70	98	108.4	106.8	197	3	TTC	TSC	○
22015S-004IS056	22	70	98	109.9	108.3	222	4	TTC	TSC	●
22015S-003IS060	24	70	98	108.4	106.8	197	3	TTC	TSC	○
22015S-004IS060	24	70	98	108.4	106.8	197	4	TTC	TSC	●



Standard Length – Taper Shank Holders – Helical Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet Through Tang Coolant	Coolant Inlet Through Shank Coolant	
24010H-003IS045	18	121	149	159.2	159.6	248	3	TTC	TSC	○
24010H-004IS045	18	121	149	160.8	159.2	273	4	TTC	TSC	●
24015H-003IS056	22	121	149	159.2	157.6	248	3	TTC	TSC	○
24015H-004IS056	22	121	149	160.8	159.2	273	4	TTC	TSC	●
24015H-003IS060	24	121	149	159.2	157.6	248	3	TTC	TSC	○
24015H-004IS060	24	121	149	163.8	159.2	273	4	TTC	TSC	●

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

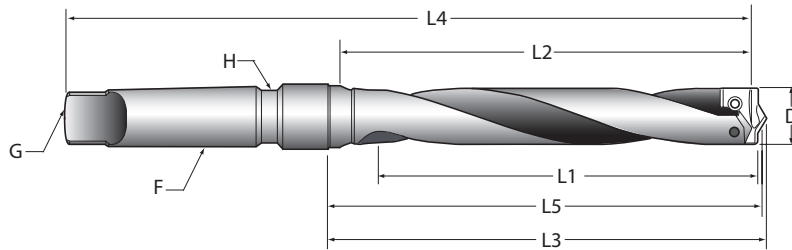
WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.

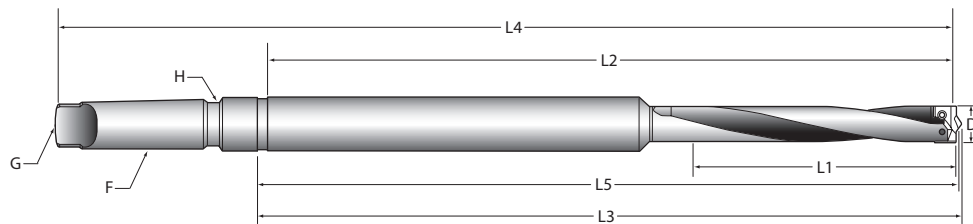
1 Series Structural Steel Holders



Extended Length – Taper Shank Holders – Helical Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet	Coolant Inlet	
⚠ 25010H-003IS045	18	165	237	247.3	241.3	336	3	TTC	TSC	○
⚠ 25010H-003IS052	22	165	237	247.3	241.3	336	3	TTC	TSC	○
⚠ 25010H-004IS052	22	165	236	247.3	245.7	360	4	TTC	TSC	●
⚠ 25015H-003IS060	24	165	237	247.3	240.5	360	3	TTC	TSC	○
⚠ 25015H-004IS060	24	165	236	247.3	245.7	360	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.



Helical Fluted Design

Long Length – Taper Shank Holders – Helical Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet	Coolant Inlet	
⚠ 26010H-004IS052	22	165	401	412.4	410.8	525	4	TTC	TSC	●
⚠ 26015H-004IS060	24	165	401	413.1	411.6	525	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

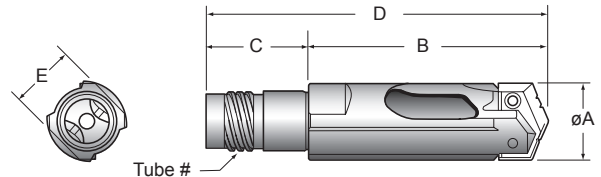
Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.



1 Series BT-A Drill and Tubes



Metric Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (mm)	Reference Length (mm)	Shank Length (mm)	Overall Length (mm)	Wrench Flat (mm)	
1	BTA1-799-xx.xx	799	17.69-18.92	58.2	25	83.2	16	◆
	BTA1-800-xx.xx	800	18.93-20.01	58.8	28	86.8	17	◆
	BTA1-801-xx.xx	801	20.02-21.81	59.4	30.5	89.9	18	◆
	BTA1-802-xx.xx	802	21.82-24.10	60.7	33	93.7	19	◆
	BTA1-803-xx.xx	803	24.11-24.38	63.9	33	96.9	21	◆

Imperial Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (mm)	Reference Length (inch)	Shank Length (inch)	Overall Length (inch)	Wrench Flat (mm)	
1	BTA1-799-x.xxxx	799	0.6960-0.7449	2-15/64	63/64	3-9/32	16	◆
	BTA1-800-x.xxxx	800	0.7450-0.7879	2-5/16	1-7/64	3-27/64	17	◆
	BTA1-801-x.xxxx	801	0.7880-0.8589	2-11/32	1-13/64	3-35/64	18	◆
	BTA1-802-x.xxxx	802	0.8590-0.9489	2-25/64	1-19/64	3-11/16	19	◆
	BTA1-803-x.xxxx	803	0.9490-0.9600	2-33/64	1-19/64	3-13/16	21	◆



Metric Tubes

Tube Size	Tube Item Number	Metric				
		Diameter Range (mm)	Tube OD (mm)	Tube ID (mm)	Length (mm)	Stk.
799	BTAT799-63	17.69-18.90	16.0	10.5	1600	○
	BTAT799-102				2591	○
800	BTAT800-63	18.91-20.00	17.0	11.5	1600	○
	BTAT800-102				2591	○
801	BTAT801-63	20.01-21.79	18.0	12.0	1600	○
	BTAT801-102				2591	○
802	BTAT802-63	21.80-24.08	20.0	13.0	1600	○
	BTAT802-102				2591	○
803	BTAT803-63	24.09-26.39	22.0	14.0	1600	○
	BTAT803-102				2591	○

Imperial Tubes

Tube Size	Tube Item Number	Imperial				
		Diameter Range (Inch)	Tube OD (Inch)	Tube ID (Inch)	Length (Inch)	Stk.
799	BTAT799-63	0.697-0.744	0.630	0.413	63	○
	BTAT799-102				102	○
800	BTAT800-63	0.745-0.787	0.669	0.453	63	○
	BTAT800-102				102	○
801	BTAT801-63	0.788-0.858	0.709	0.472	63	○
	BTAT801-102				102	○
802	BTAT802-63	0.859-0.948	0.787	0.512	63	○
	BTAT802-102				102	○
803	BTAT803-63	0.949-1.039	0.866	0.551	63	○
	BTAT803-102				102	○



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1 Series Inserts

Diameter Range 17.53 to 24.38mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS CPM-M4	17.86	0.7031	131T-.703	○	131A-.703	○	131N-.703	○
	18.00	0.7087	131T-18	●	131A-18	●	131N-18	●
	18.26	0.7188	131T-0023	○	131A-0023	○	131N-0023	○
	18.50	0.7283	131T-18.5	●	131A-18.5	●	131N-18.5	●
	18.65	0.7344	131T-.734	○	131A-.734	○	131N-.734	○
	19.00	0.7480	131T-19	●	131A-19	●	131N-19	●
	19.05	0.7500	131T-0024	○	131A-0024	○	131N-0024	○
	19.45	0.7657	131T-.765	○	131A-.765	○	131N-.765	○
	19.50	0.7677	131T-19.5	●	131A-19.5	●	131N-19.5	●
	19.84	0.7813	131T-0025	○	131A-0025	○	131N-0025	○
	20.00	0.7874	131T-20	●	131A-20	●	131N-20	●
	20.24	0.7969	131T-.796	○	131A-.796	○	131N-.796	○
	20.50	0.8071	131T-20.5	●	131A-20.5	●	131N-20.5	●
	20.64	0.8125	131T-0026	○	131A-0026	○	131N-0026	○
	21.00	0.8268	131T-21	●	131A-21	●	131N-21	●
	21.43	0.8438	131T-0027	○	131A-0027	○	131N-0027	○
	21.50	0.8465	131T-21.5	○	131A-21.5	●	131N-21.5	○
	21.83	0.8594	131T-.859*	○	131A-.859*	○	131N-.859*	○
	22.00	0.8661	131T-22*	●	131A-22*	●	131N-22*	●
	22.23	0.8750	131T-0028*	○	131A-0028*	○	131N-0028*	○
	22.50	0.8858	131T-22.5	○	131A-22.5	●	131N-22.5	○
	22.62	0.8906	131T-.890*	○	131A-.890*	○	131N-.890*	○
	23.00	0.9055	131T-23*	●	131A-23*	●	131N-23*	●
	23.02	0.9063	131T-0029*	○	131A-0029*	○	131N-0029*	○
	23.42	0.9219	131T-.921*	○	131A-.921*	○	131N-.921*	○
	23.50	0.9252	131T-23.5*	○	131A-23.5*	●	131N-23.5*	○
	23.70	0.9330	131T-23.7*	○	131A-23.7*	●	131N-23.7*	○
	23.81	0.9375	131T-0030*	○	131A-0030*	○	131N-0030*	○
	24.00	0.9449	131T-24*	●	131A-24	●	131N-24*	●
HSS Super Cobalt	17.86	0.7031	151T-.703	○	151A-.703	○	151N-.703	○
	18.00	0.7087	151T-18	●	151A-18	●	151N-18	●
	18.26	0.7188	151T-0023	○	151A-0023	○	151N-0023	○
	18.50	0.7283	151T-18.5	●	151A-18.5	●	151N-18.5	●
	18.65	0.7344	151T-.734	○	151A-.734	○	151N-.734	○
	19.00	0.7480	151T-19	●	151A-19	●	151N-19	●
	19.05	0.7500	151T-0024	○	151A-0024	○	151N-0024	○
	19.45	0.7657	151T-.765	○	151A-.765	○	151N-.765	○
	19.50	0.7677	151T-19.5	●	151A-19.5	●	151N-19.5	●
	19.84	0.7813	151T-0025	○	151A-0025	○	151N-0025	○
	20.00	0.7874	151T-20	●	151A-20	●	151N-20	●
	20.24	0.7969	151T-.796	○	151A-.796	○	151N-.796	○
	20.50	0.8071	151T-20.5	●	151A-20.5	●	151N-20.5	●
	20.64	0.8125	151T-0026	○	151A-0026	○	151N-0026	○
	21.00	0.8268	151T-21	●	151A-21	●	151N-21	●
	21.43	0.8438	151T-0027	○	151A-0027	○	151N-0027	○
	21.50	0.8465	151T-21.5	○	151A-21.5	●	151N-21.5	○

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
(see page 10 for details)

T-A & BENZ T-A

GENSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



1 Series Inserts

Diameter Range 17.53 to 24.38mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Super Cobalt	21.83	0.8594	151T-.859*	○	151A-.859*	○	151N-.859*	○
	22.00	0.8661	151T-22*	●	151A-22*	●	151N-22*	●
	22.23	0.8750	151T-0028*	○	151A-0028*	○	151N-0028*	○
	22.50	0.8858	151T-22.5	○	151A-22.5	●	151N-22.5	○
	22.62	0.8906	151T-.890*	○	151A-.890*	○	151N-.890*	○
	23.00	0.9055	151T-23*	●	151A-23*	●	151N-23*	●
	23.02	0.9063	151T-0029*	○	151A-0029*	○	151N-0029*	○
	23.42	0.9219	151T-.921*	○	151A-.921*	○	151N-.921*	○
	23.50	0.9252	151T-23.5*	○	151A-23.5*	●	151N-23.5*	○
	23.70	0.9330	151T-23.7*	○	151A-23.7*	●	151N-23.7*	○
	23.81	0.9375	151T-0030*	○	151A-0030*	○	151N-0030*	○
	24.00	0.9449	151T-24*	●	151A-24*	●	151N-24*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Premium Cobalt	17.86	0.7031	181T-.703	○	181A-.703	○	181N-.703	○
	18.00	0.7087	181T-18	●	181A-18	●	181N-18	●
	18.26	0.7188	181T-0023	○	181A-0023	○	181N-0023	○
	18.50	0.7283	181T-18.5	●	181A-18.5	●	181N-18.5	●
	18.65	0.7344	181T-.734	○	181A-.734	○	181N-.734	○
	19.00	0.7480	181T-19	●	181A-19	●	181N-19	●
	19.05	0.7500	181T-0024	○	181A-0024	○	181N-0024	○
	19.45	0.7657	181T-.765	○	181A-.765	○	181N-.765	○
	19.50	0.7677	181T-19.5	●	181A-19.5	●	181N-19.5	●
	19.84	0.7813	181T-0025	○	181A-0025	○	181N-0025	○
	20.00	0.7874	181T-20	●	181A-20	●	181N-20	●
	20.24	0.7969	181T-.796	○	181A-.796	○	181N-.796	○
	20.50	0.8071	181T-20.5	●	181A-20.5	●	181N-20.5	●
	20.64	0.8125	181T-0026	○	181A-0026	○	181N-0026	○
	21.00	0.8268	181T-21	●	181A-21	●	181N-21	●
	21.43	0.8438	181T-0027	○	181A-0027	○	181N-0027	○
	21.50	0.8465	181T-21.5	○	181A-21.5	●	181N-21.5	○
	21.83	0.8594	181T-.859*	○	181A-.859*	○	181N-.859*	○
	22.00	0.8661	181T-22*	●	181A-22*	●	181N-22*	●
	22.23	0.8750	181T-0028*	○	181A-0028*	○	181N-0028*	○
	22.50	0.8858	181T-22.5	○	181A-22.5	●	181N-22.5	○
	22.62	0.8906	181T-.890*	○	181A-.890*	○	181N-.890*	○
	23.00	0.9055	181T-23*	●	181A-23*	●	181N-23*	●
	23.02	0.9063	181T-0029*	○	181A-0029*	○	181N-0029*	○
	23.42	0.9219	181T-.921*	○	181A-.921*	○	181N-.921*	○
	23.50	0.9252	181T-23.5*	○	181A-23.5*	●	181N-23.5*	○
	23.70	0.9330	181T-23.7*	○	181A-23.7*	●	181N-23.7*	○
	23.81	0.9375	181T-0030*	○	181A-0030*	○	181N-0030*	○
	24.00	0.9449	181T-24*	●	181A-24*	●	181N-24*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)



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1 Series Inserts

Diameter Range 17.53 to 24.38mm



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	17.86	0.7031	1C21T-.703	○	1C21A-.703	○
	18.00	0.7087	1C21T-18	●	1C21A-18	●
	18.26	0.7188	1C21T-0023	○	1C21A-0023	○
	18.50	0.7283	1C21T-18.5	●	1C21A-18.5	●
	18.65	0.7344	1C21T-.734	○	1C21A-.734	○
	19.00	0.7480	1C21T-19	●	1C21A-19	●
	19.05	0.7500	1C21T-0024	○	1C21A-0024	○
	19.45	0.7657	1C21T-.765	○	1C21A-.765	○
	19.50	0.7677	1C21T-19.5	●	1C21A-19.5	●
	19.84	0.7813	1C21T-0025	○	1C21A-0025	○
	20.00	0.7874	1C21T-20	●	1C21A-20	●
	20.24	0.7969	1C21T-.796	○	1C21A-.796	○
	20.50	0.8071	1C21T-20.5	●	1C21A-20.5	●
	20.64	0.8125	1C21T-0026	○	1C21A-0026	○
	21.00	0.8268	1C21T-21	●	1C21A-21	●
	21.43	0.8438	1C21T-0027	○	1C21A-0027	○
	21.50	0.8465	1C21T-21.5	○	1C21A-21.5	●
	21.83	0.8594	1C21T-.859*	○	1C21A-.859*	○
	22.00	0.8661	1C21T-22*	●	1C21A-22*	●
	22.23	0.8750	1C21T-0028*	○	1C21A-0028*	○
	22.50	0.8858	1C21T-22.5	○	1C21A-22.5	●
	22.62	0.8906	1C21T-.890*	○	1C21A-.890*	○
	23.00	0.9055	1C21T-23*	●	1C21A-23*	●
	23.02	0.9063	1C21T-0029*	○	1C21A-0029*	○
	23.42	0.9219	1C21T-.921*	○	1C21A-.921*	○
	23.50	0.9252	1C21T-23.5*	○	1C21A-23.5*	●
	23.70	0.9330	1C21T-23.7*	○	1C21A-23.7*	●
	23.81	0.9375	1C21T-0030*	○	1C21A-0030*	○
	24.00	0.9449	1C21T-24*	●	1C21A-24	●
P40 (C5) Carbide	17.86	0.7031	1C51T-.703	○	1C51A-.703	○
	18.00	0.7087	1C51T-18	●	1C51A-18	●
	18.26	0.7188	1C51T-0023	○	1C51A-0023	○
	18.50	0.7283	1C51T-18.5	●	1C51A-18.5	●
	18.65	0.7344	1C51T-.734	○	1C51A-.734	○
	19.00	0.7480	1C51T-19	●	1C51A-19	●
	19.05	0.7500	1C51T-0024	○	1C51A-0024	○
	19.45	0.7657	1C51T-.765	○	1C51A-.765	○
	19.50	0.7677	1C51T-19.5	●	1C51A-19.5	●
	19.84	0.7813	1C51T-0025	○	1C51A-0025	○
	20.00	0.7874	1C51T-20	●	1C51A-20	●
	20.24	0.7969	1C51T-.796	○	1C51A-.796	○
	20.50	0.8071	1C51T-20.5	●	1C51A-20.5	●
	20.64	0.8125	1C51T-0026	○	1C51A-0026	○
	21.00	0.8268	1C51T-21	●	1C51A-21	●
	21.43	0.8438	1C51T-0027	○	1C51A-0027	○
	21.83	0.8594	1C51T-.859*	○	1C51A-.859*	○
	22.00	0.8661	1C51T-22*	●	1C51A-22*	●
	22.23	0.8750	1C51T-0028*	○	1C51A-0028*	○
	22.62	0.8906	1C51T-.890*	○	1C51A-.890*	○
	23.00	0.9055	1C51T-23*	●	1C51A-23*	●
	23.02	0.9063	1C51T-0029*	○	1C51A-0029*	○
	23.42	0.9219	1C51T-.921*	○	1C51A-.921*	○
	23.81	0.9375	1C51T-0030*	○	1C51A-0030*	○
	24.00	0.9449	1C51T-24*	●	1C51A-24	●

Geometries available as non-stock standard

- AN - CI
 - BR - IN
 - BT - NC
 - CN - NP
 - CP - RN
 - CR - SK
 - HI - TC
 - HR - WC
- (see page 11 for details)

Coatings available as non-stock standard

- H - AM200®
- (see page 10 for details)

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2



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1 Series Inserts

Diameter Range 17.53 to 24.38mm



Cast Iron

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TIAlN	Stk.
K10 (C3) Carbide	17.86	0.7031	1C31A-.703-CI	○
	18.00	0.7087	1C31A-18-CI	●
	18.26	0.7188	1C31A-0023-CI	○
	18.50	0.7283	1C31A-18.5-CI	●
	18.65	0.7344	1C31A-.734-CI	○
	19.00	0.7480	1C31A-19-CI	●
	19.05	0.7500	1C31A-0024-CI	○
	19.45	0.7657	1C31A-.765-CI	○
	19.50	0.7677	1C31A-19.5-CI	●
	19.84	0.7813	1C31A-0025-CI	○
	20.00	0.7874	1C31A-20-CI	●
	20.24	0.7969	1C31A-.796-CI	○
	20.50	0.8071	1C31A-20.5-CI	●
	20.64	0.8125	1C31A-0026-CI	○
	21.00	0.8268	1C31A-21-CI	●
	21.43	0.8438	1C31A-0027-CI	○
	21.83	0.8594	1C31A-.859-CI*	○
	22.00	0.8661	1C31A-22-CI*	●
	22.23	0.8750	1C31A-0028-CI*	○
	22.62	0.8906	1C31A-.890-CI*	○
	23.00	0.9055	1C31A-23-CI*	●
	23.02	0.9063	1C31A-0029-CI*	○
	23.42	0.9219	1C31A-.921-CI*	○
	23.81	0.9375	1C31A-0030-CI*	○
	24.00	0.9449	1C31A-24-CI*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Coatings available as non-stock standard

H - AM200®

T - TiN

N - TiCN

(see page 10 for details)



Tiny Chip

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	18.00	0.7087	151H-18-TC	○
	18.50	0.7283	151H-18.5-TC	○
	19.00	0.7480	151H-19-TC	○
	19.50	0.7677	151H-19.5-TC	○
	20.00	0.7874	151H-20-TC	○
	20.50	0.8071	151H-20.5-TC	○
	21.00	0.8268	151H-21-TC	○
	21.50	0.8465	151H-21.5-TC	○
	22.00	0.8661	151H-22-TC*	○
	22.50	0.8858	151H-22.5-TC*	○
	23.00	0.9055	151H-23-TC*	○
	23.50	0.9252	151H-23.5-TC*	○
	24.00	0.9449	151H-24-TC*	○

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

A - TiAlN

(see page 10 for details)

1 Series Inserts

Diameter Range 17.53 to 24.38mm



90° Spot & Chamfer

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	17.86	0.7031	151T-.703-SP	◆
	18.00	0.7087	151T-18-SP	◆
	18.26	0.7188	151T-0023-SP	◆
	18.50	0.7283	151T-18.5-SP	◆
	18.65	0.7344	151T-.734-SP	◆
	19.00	0.7480	151T-19-SP	◆
	19.05	0.7500	151T-0024-SP	◆
	19.45	0.7657	151T-.765-SP	◆
	19.50	0.7677	151T-19.5-SP	◆
	19.84	0.7813	151T-0025-SP	◆
	20.00	0.7874	151T-20-SP	◆
	20.24	0.7969	151T-.796-SP	◆
	20.50	0.8071	151T-20.5-SP	◆
	20.64	0.8125	151T-0026-SP	◆
	21.00	0.8268	151T-21-SP	◆
	21.43	0.8438	151T-0027-SP	◆
	21.83	0.8594	151T-.859-SP*	◆
	22.00	0.8661	151T-22-SP*	◆
	22.23	0.8750	151T-0028-SP*	◆
	22.62	0.8906	151T-.890-SP*	◆
	23.00	0.9055	151T-23-SP*	◆
	23.02	0.9063	151T-0029-SP*	◆
	23.42	0.9219	151T-.921-SP*	◆
	23.81	0.9375	151T-0030-SP*	◆
	24.00	0.9449	151T-24-SP*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard
- SW
(see page 11 for details)

Coatings available as non-stock standard
H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)



Thin Wall (for Structural Steel material up to 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	18.00	0.7087	151A-18-TW	●	151H-18-TW	●
	20.64	0.8125	151A-0026-TW	○	151H-0026-TW	○
	22.00	0.8661	151A-22-TW	●	151H-22-TW	●
	22.23	0.8750	151A-0028-TW	○	151H-0028-TW	○
	23.81	0.9375	151A-0030-TW	○	151H-0030-TW	○
	24.00	0.9449	151A-24-TW	●	151H-24-TW	●

Supplied in packs of 2

Coatings available as non-stock standard
T - TiN
N - TiCN
(see page 10 for details)

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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1 Series Inserts

Diameter Range 17.53 to 24.38mm



Notch Point (for Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	18.00	0.7087	151A-18-NP	●	151H-18-NP	●
	20.64	0.8125	151A-0026-NP	○	151H-0026-NP	○
	22.00	0.8661	151A-22-NP	●	151H-22-NP	●
	22.23	0.8750	151A-0028-NP	○	151H-0028-NP	○
	23.81	0.9375	151A-0030-NP	○	151H-0030-NP	○
	24.00	0.9449	151A-24-NP	●	151H-24-NP	●

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



150° Structural Steel (reduced exit burr on Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	18.00	0.7087	151A-18-SS	●	151H-18-SS	●
	20.64	0.8125	151A-0026-SS	○	151H-0026-SS	○
	22.00	0.8661	151A-22-SS	●	151H-22-SS	●
	22.23	0.8750	151A-0028-SS	○	151H-0028-SS	○
	23.81	0.9375	151A-0030-SS	○	151H-0030-SS	○
	24.00	0.9449	151A-24-SS	●	151H-24-SS	●

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



Tube Sheet

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS CPM-M4	19.25	0.7580	131H-.7580-IN	○
	19.45	0.7656	131H-.765-IN	○
	19.85	0.7813	131H-0025-IN	○
HSS Super Cobalt	19.25	0.7580	151H-.7580-IN	○
	19.45	0.7656	151H-.765-IN	○
	19.85	0.7813	151H-0025-IN	○

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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1 Series Inserts

Diameter Range 17.53 to 24.38mm



Flat Bottom

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	17.86	0.7031	151T-.703-FB	○
	18.00	0.7087	151T-18-FB	○
	18.26	0.7188	151T-0023-FB	○
	18.50	0.7283	151T-18.5-FB	○
	18.65	0.7344	151T-.734-FB	○
	19.00	0.7480	151T-19-FB	○
	19.05	0.7500	151T-0024-FB	○
	19.45	0.7656	151T-.765-FB	○
	19.50	0.7677	151T-19.5-FB	○
	19.84	0.7813	151T-0025-FB	○
	20.00	0.7874	151T-20-FB	○
	20.50	0.8071	151T-20.5-FB	○
	20.64	0.8125	151T-0026-FB	○
	21.00	0.8268	151T-21-FB	○
	21.43	0.8438	151T-0027-FB	○
	22.00	0.8661	151T-22-FB*	○
	22.23	0.8750	151T-0028-FB*	○
	23.00	0.9055	151T-23-FB*	○
	23.02	0.9063	151T-0029-FB*	○
	23.42	0.9219	151T-.921-FB*	○
	23.81	0.9375	151T-0030-FB*	○
	24.00	0.9449	151T-24-FB*	○

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- FN
(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)

Grades available as non-stock standard

K20 (C2)



Diamond Coated

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	Diamond	Stk.
N2	17.86	0.7031	1N21D-.703	◆
	18.00	0.7087	1N21D-18	◆
	18.26	0.7188	1N21D-0023	◆
	18.50	0.7283	1N21D-18.5	◆
	18.65	0.7344	1N21D-.734	◆
	19.00	0.7480	1N21D-19	◆
	19.05	0.7500	1N21D-0024	◆
	19.45	0.7656	1N21D-.765	◆
	19.50	0.7677	1N21D-19.5	◆
	19.84	0.7813	1N21D-0025	◆
	20.00	0.7874	1N21D-20	◆
	20.24	0.7969	1N21D-.796	◆
	20.50	0.8071	1N21D-20.5	◆
	20.64	0.8125	1N21D-0026	◆
	21.00	0.8268	1N21D-21	◆
	21.43	0.8438	1N21D-0027	◆
	21.83	0.8594	1N21D-.859	◆
	22.00	0.8661	1N21D-22	◆
	22.23	0.8750	1N21D-0028	◆
	22.50	0.8858	1N21D-22.5	◆
	22.62	0.8906	1N21D-.890	◆
	23.00	0.9055	1N21D-23	◆
	23.02	0.9063	1N21D-0029	◆
	23.42	0.9219	1N21D-.921	◆
	23.81	0.9375	1N21D-0030	◆
	24.00	0.9449	1N21D-24	◆

Supplied in packs of 1

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1 Series Inserts

Diameter Range 17.53 to 24.38mm

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	17.86	0.7031	451H-.703	○
	18.00	0.7087	451H-18	●
	18.26	0.7188	451H-0023	○
	18.50	0.7283	451H-18.5	●
	18.65	0.7344	451H-.734	○
	19.00	0.7480	451H-19	●
	19.05	0.7500	451H-0024	○
	19.45	0.7657	451H-.765	○
	19.50	0.7677	451H-19.5	●
	19.84	0.7813	451H-0025	○
	20.00	0.7874	451H-20	●
	20.24	0.7969	451H-.796	○
	20.50	0.8071	451H-20.5	●
	20.64	0.8125	451H-0026	○
	21.00	0.8268	451H-21	●
	21.43	0.8438	451H-0027	○
	21.50	0.8465	451H-21.5	●
	21.83	0.8594	451H-.859*	○
	22.00	0.8661	451H-22*	●
	22.23	0.8750	451H-0028*	○
	22.50	0.8858	451H-22.5	●
	22.62	0.8906	451H-.890*	○
	23.00	0.9055	451H-23*	●
	23.02	0.9063	451H-0029*	○
	23.42	0.9219	451H-.921*	○
	23.50	0.9252	451H-23.5*	●
	23.70	0.9330	451H-23.7*	●
	23.81	0.9375	451H-0030*	○
	24.00	0.9449	451H-24*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard
- HE
(see page 11 for details)

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K20 (C2) Carbide	17.86	0.7031	4C21H-.703	○
	18.00	0.7087	4C21H-18	●
	18.26	0.7188	4C21H-0023	○
	18.50	0.7283	4C21H-18.5	●
	18.65	0.7344	4C21H-.734	○
	19.00	0.7480	4C21H-19	●
	19.05	0.7500	4C21H-0024	○
	19.45	0.7657	4C21H-.765	○
	19.50	0.7677	4C21H-19.5	●
	19.84	0.7813	4C21H-0025	○
	20.00	0.7874	4C21H-20	●
	20.24	0.7969	4C21H-.796	○
	20.50	0.8071	4C21H-20.5	●
	20.64	0.8125	4C21H-0026	○
	21.00	0.8268	4C21H-21	●
	21.43	0.8438	4C21H-0027	○
	21.50	0.8465	4C21H-21.5	●
	21.83	0.8594	4C21H-.859*	○
	22.00	0.8661	4C21H-22*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard
- HE
(see page 11 for details)

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)



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1 Series Inserts

Diameter Range 17.53 to 24.38mm



GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K20 (C2) Carbide	22.23	0.8750	4C21H-0028*	○
	22.50	0.8858	4C21H-22.5	●
	22.62	0.8906	4C21H-.890*	○
	23.00	0.9055	4C21H-23*	●
	23.02	0.9063	4C21H-0029*	○
	23.42	0.9219	4C21H-.921*	○
	23.50	0.9252	4C21H-23.5*	●
	23.70	0.9330	4C21H-23.7*	●
	23.81	0.9375	4C21H-0030*	○
	24.00	0.9449	4C21H-24*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard
- HE
(see page 11 for details)

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K35 (C1) Carbide	17.86	0.7031	4C11H-.703	○
	18.00	0.7087	4C11H-18	●
	18.26	0.7188	4C11H-0023	○
	18.50	0.7283	4C11H-18.5	●
	18.65	0.7344	4C11H-.734	◆
	19.00	0.7480	4C11H-19	●
	19.05	0.7500	4C11H-0024	○
	19.45	0.7657	4C11H-.765	○
	19.50	0.7677	4C11H-19.5	●
	19.84	0.7813	4C11H-0025	○
	20.00	0.7874	4C11H-20	●
	20.24	0.7969	4C11H-.796	◆
	20.50	0.8071	4C11H-20.5	●
	20.64	0.8125	4C11H-0026	○
	21.00	0.8268	4C11H-21	◆
	21.43	0.8438	4C11H-0027	○
	21.50	0.8465	4C11H-21.5	●
	21.83	0.8594	4C11H-.859*	◆
	22.00	0.8661	4C11H-22*	●
	22.23	0.8750	4C11H-0028*	○
	22.50	0.8858	4C11H-22.5	●
	22.62	0.8906	4C11H-.890*	○
	23.00	0.9055	4C11H-23*	●
	23.02	0.9063	4C11H-0029*	○
	23.42	0.9219	4C11H-.921*	○
	23.50	0.9252	4C11H-23.5*	●
	23.70	0.9330	4C11H-23.7*	○
	23.81	0.9375	4C11H-0030*	○
	24.00	0.9449	4C11H-24*	●

* Denotes inserts that will also fit 1.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard
- HE
(see page 11 for details)

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

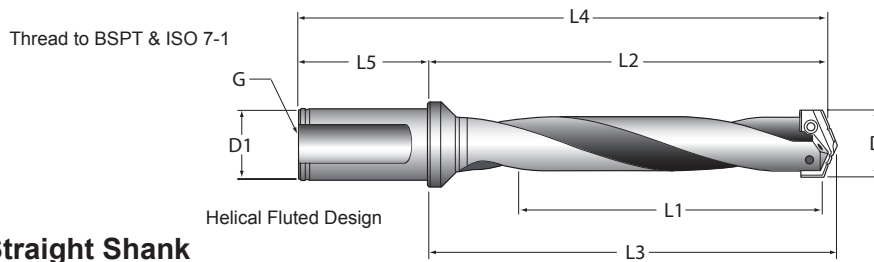
Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



2 Series Holders

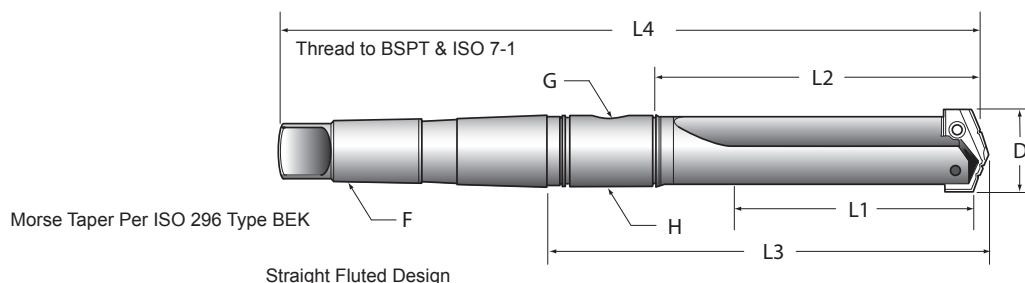


Available Ex-Stock

Flanged Straight Shank

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	L5	D1	G	*
			Drill Range D (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Ref Length (mm)	Overall Length (mm)	Shank Length (mm)	Shank Diameter (mm)	Pipe Tap	
21020S-32FM	Stub	Straight	24.50-35.00	57	88.5	92.1	148.5	60	32.0	1/4"	1/8"
21025S-32FM	Stub	Straight	30.00-35.00	92	123.4	127.0	183.4	60	32.0	1/4"	1/8"
22020S-32FM	Short	Straight	24.50-35.00	86	128.6	132.2	188.6	60	32.0	1/4"	N/A
22025S-32FM	Short	Straight	30.00-35.00	86	128.6	132.2	188.6	60	32.0	1/4"	N/A
23020S-32FM	Intermediate	Straight	24.50-35.00	137	179.4	183	239.4	60	32.0	1/4"	N/A
23020H-32FM	Intermediate	Helical	24.50-35.00	137	179.4	183	239.4	60	32.0	1/4"	N/A
23025H-32FM	Intermediate	Helical	30.00-35.00	137	179.4	183	239.4	60	32.0	1/4"	N/A
24020S-32FM	Standard	Straight	24.50-35.00	187	230.2	233.8	290.2	60	32.0	1/4"	N/A
24020H-32FM	Standard	Helical	24.50-35.00	187	230.2	233.8	290.2	60	32.0	1/4"	N/A
24025H-32FM	Standard	Helical	30.00-35.00	187	230.2	233.8	290.2	60	32.0	1/4"	N/A
N 24520H-32FM	Standard Plus	Helical	24.50-35.00	238	280.9	284.5	340.9	60	32.0	1/4"	N/A
⚠ 25020H-32FM	Extended	Helical	24.50-35.00	289	331.8	335.4	391.8	60	32.0	1/4"	N/A
⚠ 25025H-32FM	Extended	Helical	30.00-35.00	289	331.8	335.4	391.8	60	32.0	1/4"	N/A
N ⚠ 26020H-32FM	Long	Helical	24.50-35.00	410	452.9	456.5	512.9	60	32.0	1/4"	N/A
⚠ 27020S-32FM	XL	Straight	24.50-35.00	511	554.1	557.7	614.1	60	32.0	1/4"	N/A
⚠ 29020S-32FM	3XL	Straight	24.50-35.00	692	735.1	738.7	795.1	60	32.0	1/4"	N/A

*Note: Stub Length includes additional side coolant port.



Available Ex-Stock

Taper Shank

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	F	H	G
			Drill Range (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Length (mm)	Overall Length (mm)	MT	RCA	Pipe Tap
22020S-004M	Short	Straight	24.50-35.00	86	114.3	160.4	273.8	4	3SRM	1/8"
22025S-004M	Short	Straight	30.00-35.00	86	114.3	167.6	281	4	4SRM	1/4"
23020H-004M	Intermediate	Helical	24.50-35.00	137	165.1	211.2	324.6	4	3SRM	1/8"
23025H-004M	Intermediate	Helical	30.00-35.00	137	165.1	218.4	331.8	4	4SRM	1/4"
24020H-004M	Standard	Helical	24.50-35.00	188	215.9	262	375.4	4	3SRM	1/8"
24025H-004M	Standard	Helical	30.00-35.00	188	215.9	269.2	382.6	4	4SRM	1/4"
⚠ 25020H-004M	Extended	Helical	24.50-35.00	289	317.5	363.6	477	4	3SRM	1/8"
⚠ 25025H-004M	Extended	Helical	30.00-35.00	289	317.5	370.8	484.2	4	4SRM	1/4"

N This symbol can be found throughout this catalogue and highlights NEW products!

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.
Visit www.alliedmaxcut.com for the most up-to-date information and procedures.
Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.

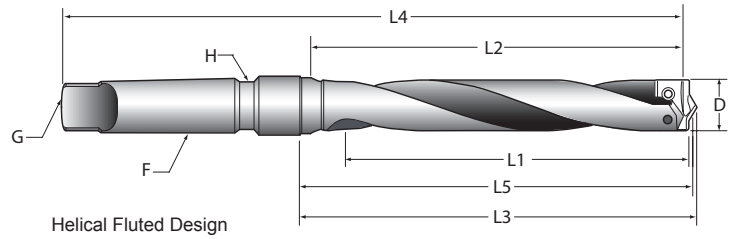
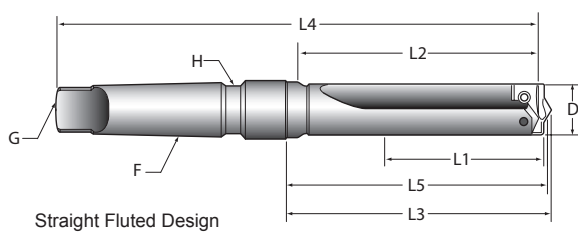
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2 Series Structural Steel Holders



Short Length – Taper Shank Holders – Straight Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet		
								Through Tang Coolant	Through Shank Coolant	
22020S-004IS100	26	86	114	126.6	124.2	238	4	TTC	TSC	●
22025S-004IS112	31-33	86	114	126.6	124.2	238	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

Standard Length – Taper Shank Holders – Helical Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet		
								Through Tang Coolant	Through Shank Coolant	
24020H-004IS100	26	137	165	177.4	175.0	289	4	TTC	TSC	●
24025H-004IS112	31	137	165	177.4	175.0	289	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

Extended Length – Taper Shank Holders – Helical Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet		
								Through Tang Coolant	Through Shank Coolant	
⚠ 25020H-003IS100	26	165	234	247.7	240.1	336	3	TTC	TSC	○
⚠ 25020H-004IS100	26	165	234	247.7	246.0	360	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

Long Length – Taper Shank Holders – Helical Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet		
								Through Tang Coolant	Through Shank Coolant	
⚠ 26020H-004IS100	26	165	406	418.3	416.3	530	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

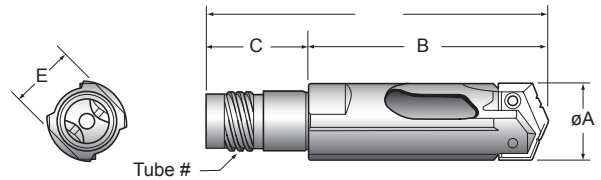
Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.



2 Series Drill and Tubes



Metric Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (mm)	Reference Length (mm)	Shank Length (mm)	Overall Length (mm)	Wrench Flat (mm)	
2	BTA2-803-xx.xx	803	24.39-26.41	78.5	33	111.5	21	◆
	BTA2-804-xx.xx	804	26.40-28.70	75.9	28	103.9	22	◆
	BTA2-805-xx.xx	805	28.71-31.01	75.4	36	111.4	25	◆
	BTA2-806-xx.xx	806	31.02-33.32	77.9	36	113.8	27	◆
	BTA2-807-xx.xx	807	33.33-35.05	77.9	36	113.8	30	◆

Imperial Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (mm)	Reference Length (inch)	Shank Length (inch)	Overall Length (inch)	Wrench Flat (mm)	
2	BTA2-803-x.xxxx	803	0.9601-1.0399	3-3/32	1-19/64	4-25/64	21	◆
	BTA2-804-x.xxxx	804	1.0400-1.1299	3	1-7/64	4-3/32	22	◆
	BTA2-805-x.xxxx	805	1.1300-1.2209	2-31/32	1-27/64	4-25/64	25	◆
	BTA2-806-x.xxxx	806	1.2210-1.3119	3-1/16	1-27/64	4-31/64	27	◆
	BTA2-807-x.xxxx	807	1.3120-1.3800	3-1/16	1-27/64	4-31/64	30	◆



Metric Tubes

Tube Size	Tube Item Number	Metric				
		Diameter Range (mm)	Tube OD (mm)	Tube ID (mm)	Length (mm)	Stk.
803	BTAT803-63	24.09-26.39	22.0	14.0	1600	○
	BTAT803-102				2591	○
804	BTAT804-63	26.40-28.68	24.0	15.5	1600	○
	BTAT804-102				2591	○
805	BTAT805-63	28.69-30.99	26.0	17.0	1600	○
	BTAT805-102				2591	○
806	BTAT806-102	31.00-33.30	28.0	18.5	2591	○
807	BTAT807-102	33.31-36.20	30.0	20.0	2591	○

Imperial Tubes

Tube Size	Tube Item Number	Imperial				
		Diameter Range (inch)	Tube OD (inch)	Tube ID (inch)	Length (inch)	Stk.
803	BTAT803-63	0.949-1.039	0.866	0.551	63	○
	BTAT803-102				102	○
804	BTAT804-63	1.040-1.129	0.945	0.610	63	○
	BTAT804-102				102	○
805	BTAT805-63	1.130-1.220	1.024	0.669	63	○
	BTAT805-102				102	○
806	BTAT806-102	1.221-1.311	1.102	0.728	102	○
807	BTAT807-102	1.312-1.425	1.181	0.787	102	○

2 Series Inserts

Diameter Range 24.41 to 35.05mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS CPM-M4	24.50	0.9646	132T-24.5	●	132A-24.5	●	132N-24.5	●
	24.61	0.9688	132T-0031	○	132A-0031	○	132N-0031	○
	25.00	0.9843	132T-25	●	132A-25	●	132N-25	●
	25.40	1.0000	132T-0100	○	132A-0100	○	132N-0100	○
	25.50	1.0004	132T-25.5	●	132A-25.5	●	132N-25.5	●
	25.80	1.0156	132T-1.1015	○	132A-1.1015	○	132N-1.1015	○
	26.00	1.0236	132T-26	●	132A-26	●	132N-26	●
	26.19	1.0313	132T-0101	○	132A-0101	○	132N-0101	○
	26.50	1.0433	132T-26.5	●	132A-26.5	●	132N-26.5	●
	26.59	1.0469	132T-1.046	○	132A-1.046	○	132N-1.046	○
	26.99	1.0625	132T-0102	○	132A-0102	○	132N-0102	○
	27.00	1.0630	132T-27	●	132A-27	●	132N-27	●
	27.50	1.0827	132T-27.5	●	132A-27.5	●	132N-27.5	●
	27.78	1.0938	132T-0103	○	132A-0103	○	132N-0103	○
	28.00	1.1024	132T-28	●	132A-28	●	132N-28	●
	28.18	1.1094	132T-1.109	○	132A-1.109	○	132N-1.109	○
	28.50	1.1220	132T-28.5	●	132A-28.5	●	132N-28.5	●
	28.58	1.1250	132T-0104	○	132A-0104	○	132N-0104	○
	29.00	1.1417	132T-29	●	132A-29	●	132N-29	●
	29.37	1.1563	132T-0105	○	132A-0105	○	132N-0105	○
	29.50	1.1614	132T-29.5	●	132A-29.5	●	132N-29.5	●
	30.00	1.1811	132T-30	●	132A-30	●	132N-30	●
	30.16	1.1875	132T-0106*	○	132A-0106*	○	132N-0106*	○
	30.50	1.2007	132T-30.5*	●	132A-30.5*	●	132N-30.5*	●
	30.96	1.2188	132T-0107*	○	132A-0107*	○	132N-0107*	○
	31.00	1.2205	132T-31*	●	132A-31*	●	132N-31*	●
	31.50	1.2402	132T-31.5*	●	132A-31.5*	●	132N-31.5*	●
	31.75	1.2500	132T-0108*	○	132A-0108*	○	132N-0108*	○
	32.00	1.2598	132T-32*	●	132A-32*	●	132N-32*	●
	32.50	1.2795	132T-32.5*	●	132A-32.5*	●	132N-32.5*	●
	32.54	1.2813	132T-0109*	○	132A-0109*	○	132N-0109*	○
	33.00	1.2992	132T-33*	●	132A-33*	●	132N-33*	●
	33.34	1.3125	132T-0110*	○	132A-0110*	○	132N-0110*	○
	33.50	1.3189	132T-33.5*	●	132A-33.5*	●	132N-33.5*	●
	34.00	1.3386	132T-34*	●	132A-34*	●	132N-34*	●
	34.13	1.3438	132T-0111*	○	132A-0111*	○	132N-0111*	○
	34.50	1.3583	132T-34.5*	●	132A-34.5*	●	132N-34.5*	●
	34.93	1.3750	132T-0112*	○	132A-0112*	○	132N-0112*	○
	35.00	1.3780	132T-35*	●	132A-35*	●	132N-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



2 Series Inserts

Diameter Range 24.41 to 35.05mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Super Cobalt	24.50	0.9646	152T-24.5	○	152A-24.5	●	152N-24.5	○
	24.61	0.9688	152T-0031	○	152A-0031	○	152N-0031	○
	25.00	0.9843	152T-25	●	152A-25	●	152N-25	●
	25.40	1.0000	152T-0100	○	152A-0100	○	152N-0100	○
	25.50	1.0004	152T-25.5	○	152A-25.5	●	152N-25.5	○
	25.80	1.0156	152T-1.1015	○	152A-1.1015	○	152N-1.1015	○
	26.00	1.0236	152T-26	●	152A-26	●	152N-26	●
	26.19	1.0313	152T-0101	○	152A-0101	○	152N-0101	○
	26.50	1.0433	152T-26.5	○	152A-26.5	●	152N-26.5	○
	26.59	1.0469	152T-1.046	○	152A-1.046	○	152N-1.046	○
	26.99	1.0625	152T-0102	○	152A-0102	○	152N-0102	○
	27.00	1.0630	152T-27	●	152A-27	●	152N-27	●
	27.50	1.0827	152T-27.5	○	152A-27.5	●	152N-27.5	○
	27.78	1.0938	152T-0103	○	152A-0103	○	152N-0103	○
	28.00	1.1024	152T-28	●	152A-28	●	152N-28	●
	28.18	1.1094	152T-1.109	○	152A-1.109	○	152N-1.109	○
	28.50	1.1220	152T-28.5	○	152A-28.5	●	152N-28.5	○
	28.58	1.1250	152T-0104	○	152A-0104	○	152N-0104	○
	29.00	1.1417	152T-29	●	152A-29	●	152N-29	●
	29.37	1.1563	152T-0105	○	152A-0105	○	152N-0105	○
	29.50	1.1614	152T-29.5	○	152A-29.5	●	152N-29.5	○
	30.00	1.1811	152T-30	●	152A-30	●	152N-30	●
	30.16	1.1875	152T-0106*	○	152A-0106*	○	152N-0106*	○
	30.50	1.2007	152T-30.5*	●	152A-30.5*	●	152N-30.5*	●
	30.96	1.2188	152T-0107*	○	152A-0107*	○	152N-0107*	○
	31.00	1.2205	152T-31*	●	152A-31*	●	152N-31*	●
	31.50	1.2402	152T-31.5*	○	152A-31.5*	●	152N-31.5*	○
	31.75	1.2500	152T-0108*	○	152A-0108*	○	152N-0108*	○
	32.00	1.2598	152T-32*	●	152A-32*	●	152N-32*	●
	32.50	1.2795	152T-32.5*	○	152A-32.5*	●	152N-32.5*	○
	32.54	1.2813	152T-0109*	○	152A-0109*	○	152N-0109*	○
	33.00	1.2992	152T-33*	●	152A-33*	●	152N-33*	●
	33.34	1.3125	152T-0110*	○	152A-0110*	○	152N-0110*	○
	33.50	1.3189	152T-33.5*	○	152A-33.5*	●	152N-33.5*	○
	34.00	1.3386	152T-34*	●	152A-34*	●	152N-34*	●
	34.13	1.3438	152T-0111*	○	152A-0111*	○	152N-0111*	○
	34.50	1.3583	152T-34.5*	○	152A-34.5*	●	152N-34.5*	○
	34.93	1.3750	152T-0112*	○	152A-0112*	○	152N-0112*	○
	35.00	1.3780	152T-35*	●	152A-35*	●	152N-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Premium Cobalt	24.50	0.9646	182T-24.5	○	182A-24.5	●	182N-24.5	○
	24.61	0.9688	182T-0031	○	182A-0031	○	182N-0031	○
	25.00	0.9843	182T-25	●	182A-25	●	182N-25	●
	25.40	1.0000	182T-0100	○	182A-0100	○	182N-0100	○
	25.50	1.0004	182T-25.5	○	182A-25.5	●	182N-25.5	○
	25.80	1.0156	182T-1.1015	○	182A-1.1015	○	182N-1.1015	○
	26.00	1.0236	182T-26	●	182A-26	●	182N-26	●
	26.19	1.0313	182T-0101	○	182A-0101	○	182N-0101	○
	26.50	1.0433	182T-26.5	○	182A-26.5	●	182N-26.5	○
	26.59	1.0469	182T-1.046	○	182A-1.046	○	182N-1.046	○

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)



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2 Series Inserts

Diameter Range 24.41 to 35.05mm



Grade	Diameter		Part Number, Coating and Availability					
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.	TiCN	Stk.
HSS Premium Cobalt	26.99	1.0625	182T-0102	○	182A-0102	○	182N-0102	○
	27.00	1.0630	182T-27	●	182A-27	●	182N-27	●
	27.50	1.0827	182T-27.5	○	182A-27.5	●	182N-27.5	○
	27.78	1.0938	182T-0103	○	182A-0103	○	182N-0103	○
	28.00	1.1024	182T-28	●	182A-28	●	182N-28	●
	28.18	1.1094	182T-1.109	○	182A-1.109	○	182N-1.109	○
	28.50	1.1220	182T-28.5	○	182A-28.5	●	182N-28.5	○
	28.58	1.1250	182T-0104	○	182A-0104	○	182N-0104	○
	29.00	1.1417	182T-29	●	182A-29	●	182N-29	●
	29.37	1.1563	182T-0105	○	182A-0105	○	182N-0105	○
	29.50	1.1614	182T-29.5	○	182A-29.5	●	182N-29.5	○
	30.00	1.1811	182T-30	●	182A-30	●	182N-30	●
	30.16	1.1875	182T-0106*	○	182A-0106*	○	182N-0106*	○
	30.50	1.2007	182T-30.5*	●	182A-30.5*	●	182N-30.5*	●
	30.96	1.2188	182T-0107*	○	182A-0107*	○	182N-0107*	○
	31.00	1.2205	182T-31*	●	182A-31*	●	182N-31*	●
	31.50	1.2402	182T-31.5*	○	182A-31.5*	●	182N-31.5*	○
	31.75	1.2500	182T-0108*	○	182A-0108*	○	182N-0108*	○
	32.00	1.2598	182T-32*	●	182A-32*	●	182N-32*	●
	32.50	1.2795	182T-32.5*	○	182A-32.5*	●	182N-32.5*	○
	32.54	1.2813	182T-0109*	○	182A-0109*	○	182N-0109*	○
	33.00	1.2992	182T-33*	●	182A-33*	●	182N-33*	●
	33.34	1.3125	182T-0110*	○	182A-0110*	○	182N-0110*	○
	33.50	1.3189	182T-33.5*	○	182A-33.5*	●	182N-33.5*	○
	34.00	1.3386	182T-34*	●	182A-34*	●	182N-34*	●
	34.13	1.3438	182T-0111*	○	182A-0111*	○	182N-0111*	○
	34.50	1.3583	182T-34.5*	○	182A-34.5*	●	182N-34.5*	○
	34.93	1.3750	182T-0112*	○	182A-0112*	○	182N-0112*	○
	35.00	1.3780	182T-35*	●	182A-35*	●	182N-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	24.50	0.9646	1C22T-24.5	○	1C22A-24.5	●
	24.61	0.9688	1C22T-0031	○	1C22A-0031	○
	25.00	0.9843	1C22T-25	●	1C22A-25	●
	25.40	1.0000	1C22T-0100	○	1C22A-0100	○
	25.50	1.0004	1C22T-25.5	○	1C22A-25.5	●
	25.80	1.0156	1C22T-1.1015	○	1C22A-1.1015	○
	26.00	1.0236	1C22T-26	●	1C22A-26	●
	26.19	1.0313	1C22T-0101	○	1C22A-0101	○
	26.50	1.0433	1C22T-26.5	○	1C22A-26.5	●
	26.59	1.0469	1C22T-1.046	○	1C22A-1.046	○
	26.99	1.0625	1C22T-0102	○	1C22A-0102	○
	27.00	1.0630	1C22T-27	●	1C22A-27	●
	27.50	1.0827	1C22T-27.5	○	1C22A-27.5	●
	27.78	1.0938	1C22T-0103	○	1C22A-0103	○
	28.00	1.1024	1C22T-28	●	1C22A-28	●
	28.18	1.1094	1C22T-1.109	○	1C22A-1.109	○
	28.50	1.1220	1C22T-28.5	○	1C22A-28.5	●
	28.58	1.1250	1C22T-0104	○	1C22A-0104	○

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - IN
- BR - NC
- CI - NP
- CN - RN
- CP - SK
- CR - TC
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)

Geometries available as non-stock standard

- AN - CI
- BR - IN
- BT - NC
- CN - NP
- CP - RN
- CR - SK
- HI - TC
- HR - WC

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

(see page 10 for details)



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2 Series Inserts

Diameter Range 24.41 to 35.05mm



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	29.00	1.1417	1C22T-29	●	1C22A-29	●
	29.37	1.1563	1C22T-0105	○	1C22A-0105	○
	29.50	1.1614	1C22T-29.5	○	1C22A-29.5	●
	30.00	1.1811	1C22T-30	●	1C22A-30	●
	30.16	1.1875	1C22T-0106*	○	1C22A-0106*	○
	30.50	1.2007	1C22T-30.5*	●	1C22A-30.5*	●
	30.96	1.2188	1C22T-0107*	○	1C22A-0107*	○
	31.00	1.2205	1C22T-31*	●	1C22A-31*	●
	31.50	1.2402	1C22T-31.5*	○	1C22A-31.5*	●
	31.75	1.2500	1C22T-0108*	○	1C22A-0108*	○
	32.00	1.2598	1C22T-32*	●	1C22A-32*	●
	32.50	1.2795	1C22T-32.5*	○	1C22A-32.5*	●
	32.54	1.2813	1C22T-0109*	○	1C22A-0109*	○
	33.00	1.2992	1C22T-33*	●	1C22A-33*	●
	33.34	1.3125	1C22T-0110*	○	1C22A-0110*	○
	33.50	1.3189	1C22T-33.5*	○	1C22A-33.5*	●
	34.00	1.3386	1C22T-34*	●	1C22A-34*	●
	34.13	1.3438	1C22T-0111*	○	1C22A-0111*	○
	34.50	1.3583	1C22T-34.5*	○	1C22A-34.5*	●
	34.93	1.3750	1C22T-0112*	○	1C22A-0112*	○
	35.00	1.3780	1C22T-35*	●	1C22A-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - CI
- BR - IN
- BT - NC
- CN - NP
- CP - RN
- CR - SK
- HI - TC
- HR - WC

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

(see page 10 for details)



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
P40 (C5) Carbide	24.50	0.9646	1C52T-24.5	●	1C52A-24.5	●
	24.61	0.9688	1C52T-0031	○	1C52A-0031	○
	25.00	0.9843	1C52T-25	●	1C52A-25	●
	25.40	1.0000	1C52T-0100	○	1C52A-0100	○
	25.50	1.0004	1C52T-25.5	●	1C52A-25.5	●
	26.00	1.0236	1C52T-26	●	1C52A-26	●
	26.19	1.0313	1C52T-0101	○	1C52A-0101	○
	26.50	1.0433	1C52T-26.5	●	1C52A-26.5	●
	26.59	1.0469	1C52T-1.046	○	1C52A-1.046	○
	26.99	1.0625	1C52T-0102	○	1C52A-0102	○
	27.00	1.0630	1C52T-27	●	1C52A-27	●
	27.50	1.0827	1C52T-27.5	●	1C52A-27.5	●
	27.78	1.0938	1C52T-0103	○	1C52A-0103	○
	28.00	1.1024	1C52T-28	●	1C52A-28	●
	28.18	1.1094	1C52T-1.109	○	1C52A-1.109	○
	28.50	1.1220	1C52T-28.5	●	1C52A-28.5	●
	28.58	1.1250	1C52T-0104	○	1C52A-0104	○
	29.00	1.1417	1C52T-29	●	1C52A-29	●
	29.37	1.1563	1C52T-0105	○	1C52A-0105	○
	29.50	1.1614	1C52T-29.5	●	1C52A-29.5	●
	30.00	1.1811	1C52T-30	●	1C52A-30	●
	30.16	1.1875	1C52T-0106*	○	1C52A-0106*	○
	30.50	1.2007	1C52T-30.5*	●	1C52A-30.5*	●
	30.96	1.2188	1C52T-0107*	○	1C52A-0107*	○
	31.00	1.2205	1C52T-31*	●	1C52A-31*	●
	31.50	1.2402	1C52T-31.5*	●	1C52A-31.5*	●
	31.75	1.2500	1C52T-0108*	○	1C52A-0108*	○

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - CI
- BR - IN
- BT - NC
- CN - NP
- CP - RN
- CR - SK
- HI - TC
- HR - WC

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

(see page 10 for details)

2 Series Inserts

Diameter Range 24.41 to 35.05mm



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
P40 (C5) Carbide	32.00	1.2598	1C52T-32*	●	1C52A-32*	●
	32.50	1.2795	1C52T-32.5*	●	1C52A-32.5*	●
	32.54	1.2813	1C52T-0109*	○	1C52A-0109*	○
	33.00	1.2992	1C52T-33*	●	1C52A-33*	●
	33.34	1.3125	1C52T-0110*	○	1C52A-0110*	○
	33.50	1.3189	1C52T-33.5*	●	1C52A-33.5*	●
	34.00	1.3386	1C52T-34*	●	1C52A-34*	●
	34.13	1.3438	1C52T-0111*	○	1C52A-0111*	○
	34.50	1.3583	1C52T-34.5*	●	1C52A-34.5*	●
	34.93	1.3750	1C52T-0112*	○	1C52A-0112*	○
	35.00	1.3780	1C52T-35*	●	1C52A-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- AN - CI
- BR - IN
- BT - NC
- CN - NP
- CP - RN
- CR - SK
- HI - TC
- HR - WC

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN

(see page 10 for details)



Cast Iron

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiAlN	Stk.
K10 Carbide	24.50	0.9646	1C32A-24.5-CI	●
	24.61	0.9688	1C32A-0031-CI	○
	25.00	0.9843	1C32A-25-CI	●
	25.40	1.0000	1C32A-0100-CI	○
	25.50	1.0040	1C32A-25.5-CI	●
	26.00	1.0236	1C32A-26-CI	●
	26.19	1.0313	1C32A-0101-CI	○
	26.50	1.0433	1C32A-26.5-CI	●
	26.59	1.0469	1C32A-1.046-CI	○
	26.99	1.0625	1C32A-0102-CI	○
	27.00	1.0630	1C32A-27-CI	●
	27.50	1.0827	1C32A-27.5-CI	●
	27.78	1.0938	1C32A-0103-CI	○
	28.00	1.1024	1C32A-28-CI	●
	28.18	1.1094	1C32A-1.109-CI	○
	28.50	1.1220	1C32A-28.5-CI	●
	28.58	1.1250	1C32A-0104-CI	○
	29.00	1.1417	1C32A-29-CI	●
	29.37	1.1563	1C32A-0105-CI	○
	29.50	1.1614	1C32A-29.5-CI	●
	30.00	1.1811	1C32A-30-CI	●
	30.16	1.1875	1C32A-0106-CI*	○
	30.50	1.2007	1C32A-30.5-CI*	●
	30.96	1.2188	1C32A-0107-CI*	○
	31.00	1.2205	1C32A-31-CI*	●
	31.50	1.2402	1C32A-31.5-CI*	●
	31.75	1.2500	1C32A-0108-CI*	○
	32.00	1.2598	1C32A-32-CI*	●
	32.50	1.2795	1C32A-32.5-CI*	●
	32.54	1.2813	1C32A-0109-CI*	○
	33.00	1.2992	1C32A-33-CI*	●
	33.34	1.3125	1C32A-0110-CI*	○
	33.50	1.3189	1C32A-33.5-CI*	●
	34.00	1.3386	1C32A-34-CI*	●
	34.13	1.3438	1C32A-0111-CI*	○
	34.50	1.3583	1C32A-34.5-CI*	●
	34.93	1.3750	1C32A-0112-CI*	○
	35.00	1.3780	1C32A-35-CI*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Coatings available as non-stock standard

H - AM200®
T - TiN
N - TiCN

(see page 10 for details)



2 Series Inserts

Diameter Range 24.41 to 35.05mm



Tiny Chip

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	24.50	0.9646	152H-24.5-TC	○
	25.00	0.9843	152H-25-TC	○
	25.50	1.0040	152H-25.5-TC	○
	26.00	1.0236	152H-26-TC	○
	26.50	1.0433	152H-26.50-TC	○
	27.00	1.0630	152H-27-TC	○
	27.50	1.0827	152H-27.5-TC	○
	28.00	1.1024	152H-28-TC	○
	28.50	1.1220	152H-28.5-TC	○
	29.00	1.1417	152H-29-TC	○
	29.50	1.1614	152H-29.5-TC	○
	30.00	1.1811	152H-30-TC	○
	30.50	1.2007	152H-30.5-TC*	○
	31.00	1.2205	152H-31-TC*	○
	31.50	1.2402	152H-31.50-TC*	○
	32.00	1.2598	152H-32-TC*	○
	32.50	1.2795	152H-32.5-TC*	○
	33.00	1.2992	152H-33-TC*	○
	33.50	1.3189	152H-33.5-TC*	○
	34.00	1.3386	152H-34-TC*	○
	34.50	1.3583	152H-34.5-TC*	○
	35.00	1.3780	152H-35-TC*	○

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Coatings available as non-stock standard
T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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2 Series Inserts

Diameter Range 24.41 to 35.05mm



90° Spot & Chamfer

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	24.50	0.9646	152T-24.5-SP	◆
	24.61	0.9688	152T-0031-SP	◆
	25.00	0.9843	152T-25-SP	◆
	25.40	1.0000	152T-0100-SP	◆
	26.00	1.0236	152T-26-SP	◆
	26.19	1.0313	152T-0101-SP	◆
	26.50	1.0433	152T-26.5-SP	◆
	26.59	1.0469	152T-1.046-SP	◆
	26.99	1.0625	152T-0102-SP	◆
	27.00	1.0630	152T-27-SP	◆
	27.50	1.0827	152T-27.5-SP	◆
	27.78	1.0938	152T-0103-SP	◆
	28.00	1.1024	152T-28-SP	◆
	28.18	1.1094	152T-1.109-SP	◆
	28.50	1.1220	152T-28.5-SP	◆
	28.58	1.1250	152T-0104-SP	◆
	29.00	1.1417	152T-29-SP	◆
	29.37	1.1563	152T-0105-SP	◆
	29.50	1.1614	152T-29.5-SP	◆
	30.00	1.1811	152T-30-SP	◆
	30.16	1.1875	152T-0106-SP*	◆
	30.50	1.2008	152T-30.5-SP*	◆
	30.96	1.2188	152T-0107-SP*	◆
	31.00	1.2205	152T-31-SP*	◆
	31.50	1.2402	152T-31.5-SP*	◆
	31.75	1.2500	152T-0108-SP*	◆
	32.00	1.2598	152T-32-SP*	◆
	32.50	1.2795	152T-32.5-SP*	◆
	32.54	1.2813	152T-0109-SP*	◆
	33.00	1.2992	152T-33-SP*	◆
	33.34	1.3125	152T-0110-SP*	◆
	33.50	1.3189	152T-33.5-SP*	◆
	34.00	1.3386	152T-34-SP*	◆
	34.13	1.3438	152T-0111-SP*	◆
	34.50	1.3583	152T-34.5-SP*	◆
	34.93	1.3750	152T-0112-SP*	◆
	35.00	1.3780	152T-35-SP*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- SW
(see page 10 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN
(see page 10 for details)

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



2 Series Inserts

Diameter Range 24.41 to 35.05mm



Thin Wall (for Structural Steel material up to 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	25.40	1.0000	152A-0100-TW	○	152H-0100-TW	○
	26.00	1.0236	152A-26-TW	●	152H-26-TW	●
	26.99	1.0625	152A-0102-TW	○	152H-0102-TW	○
	27.00	1.0630	152A-27-TW	●	152H-27-TW	●
	28.58	1.1250	152A-0104-TW	○	152H-0104-TW	○
	30.16	1.1875	152A-0106-TW	○	152H-0106-TW	○
	31.00	1.2205	152A-31-TW	●	152H-31-TW	●
	31.75	1.2500	152A-0108-TW	○	152H-0108-TW	○
	33.00	1.2992	152A-33-TW	●	152H-33-TW	●
	33.34	1.3125	152A-0110-TW	○	152H-0110-TW	○
	34.93	1.3750	152A-0112-TW	○	152H-0112-TW	○

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



Notch Point (for Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	25.40	1.0000	152A-0100-NP	○	152H-0100-NP	○
	26.00	1.0236	152A-26-NP	●	152H-26-NP	●
	26.99	1.0625	152A-0102-NP	○	152H-0102-NP	○
	27.00	1.0630	152A-27-NP	●	152H-27-NP	●
	28.58	1.1250	152A-0104-NP	○	152H-0104-NP	○
	30.16	1.1875	152A-0106-NP	○	152H-0106-NP	○
	31.00	1.2205	152A-31-NP	●	152H-31-NP	●
	31.75	1.2500	152A-0108-NP	○	152H-0108-NP	○
	33.00	1.2992	152A-33-NP	●	152H-33-NP	●
	33.34	1.3125	152A-0110-NP	○	152H-0110-NP	○
	34.93	1.3750	152A-0112-NP	○	152H-0112-NP	○

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



150° Structural Steel (reduced exit burr on Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	25.40	1.0000	152A-0100-SS	○	152H-0100-SS	○
	26.00	1.0236	152A-26-SS	●	152H-26-SS	●
	26.99	1.0625	152A-0102-SS	○	152H-0102-SS	○
	27.00	1.0630	152A-27-SS	●	152H-27-SS	●
	28.58	1.1250	152A-0104-SS	○	152H-0104-SS	○
	30.16	1.1875	152A-0106-SS	○	152H-0106-SS	○
	31.00	1.2205	152A-31-SS	●	152H-31-SS	●
	31.75	1.2500	152A-0108-SS	○	152H-0108-SS	○
	33.00	1.2992	152A-33-SS	●	152H-33-SS	●
	33.34	1.3125	152A-0110-SS	○	152H-0110-SS	○
	34.93	1.3750	152A-0112-SS	○	152H-0112-SS	○

Supplied in packs of 2

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

● Stock Item.

○ Stocked in limited quantities, advanced planning is recommended.

◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

2 Series Inserts

Diameter Range 24.41 to 35.05mm



Tube Sheet

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS CPM-M4	25.60	1.0080	132H-1.0080-IN	○
	25.80	1.0156	132H-1.015-IN	○
	26.19	1.0313	132H-0101-IN	○
HSS Super Cobalt	25.60	1.0080	152H-1.0080-IN	○
	25.80	1.0156	152H-1.015-IN	○
	26.19	1.0313	152H-0101-IN	○

Coatings available as non-stock standard

T - TiN

N - TiCN

A - TiAlN

(see page 10 for details)



Flat Bottom

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	24.50	0.9646	152T-24.5-FB	○
	24.61	0.9688	152T-0031-FB	○
	25.00	0.9843	152T-25-FB	○
	25.40	1.0000	152T-0100-FB	○
	25.50	1.0040	152T-25.5-FB	○
	25.80	1.0156	152T-1.015-FB	○
	26.00	1.0236	152T-26-FB	○
	26.19	1.0313	152T-0101-FB	○
	26.50	1.0433	152T-26.5-FB	○
	26.99	1.0625	152T-0102-FB	○
	27.00	1.0630	152T-27-FB	○
	27.50	1.0827	152T-27.5-FB	○
	27.78	1.0938	152T-0103-FB	○
	28.00	1.1024	152T-28-FB	○
	28.50	1.1220	152T-28.5-FB	○
	28.58	1.1250	152T-0104-FB	○
	29.00	1.1417	152T-29-FB	○
	29.37	1.1563	152T-0105-FB	○
	29.50	1.1614	152T-29.5-FB	○
	30.00	1.1811	152T-30-FB	○
	30.16	1.1875	152T-0106-FB*	○
	30.50	1.2007	152T-30.5-FB*	○
	30.96	1.2188	152T-0107-FB*	○
	31.00	1.2205	152T-31-FB*	○
	31.50	1.2402	152T-31.5-FB*	○
	31.75	1.2500	152T-0108-FB*	○
	32.00	1.2598	152T-32-FB*	○
	32.50	1.2795	152T-32.5-FB*	○
	32.54	1.2813	152T-0109-FB*	○
	33.00	1.2992	152T-33-FB*	○
	33.34	1.3125	152T-0110-FB*	○
	33.50	1.3189	152T-33.5-FB*	○
	34.00	1.3386	152T-34-FB*	○
	34.13	1.3438	152T-0111-FB*	○
	34.50	1.3583	152T-34.5-FB*	○
	34.93	1.3750	152T-0112-FB*	○
	35.00	1.3780	152T-35-FB*	○

Geometries available as non-stock standard

- FN

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

A - TiAlN

(see page 10 for details)

Grades available as non-stock standard

K20 (C2)

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2



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2 Series Inserts

Diameter Range 24.41 to 35.05mm



Diamond Coated

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	Diamond	Stk.
N2	24.50	0.9646	1N22D-24.5	◆
	24.61	0.9688	1N22D-0031	◆
	25.00	0.9843	1N22D-25	◆
	25.40	1.0000	1N22D-0100	◆
	25.50	1.0004	1N22D-25.5	◆
	25.80	1.0156	1N22D-1.015	◆
	26.00	1.0236	1N22D-26	◆
	26.19	1.0313	1N22D-0101	◆
	26.50	1.0433	1N22D-26.5	◆
	26.59	1.0469	152A-1.046	◆
	26.99	1.0625	1N22D-0102	◆
	27.00	1.0630	1N22D-27	◆
	27.50	1.0827	1N22D-27.5	◆
	27.78	1.0938	1N22D-0103	◆
	28.00	1.1024	1N22D-28	◆
	28.18	1.1094	1N22D-1.109	◆
	28.50	1.1220	1N22D-28.5	◆
	28.58	1.1250	1N22D-0104	◆
	29.00	1.1417	1N22D-29	◆
	29.37	1.1563	1N22D-0105	◆
	29.50	1.1614	1N22D-29.5	◆
	30.00	1.1811	1N22D-30	◆
	30.16	1.1875	1N22D-0106*	◆
	30.50	1.2007	1N22D-30.5*	◆
	30.96	1.2188	1N22D-0107*	◆
	31.00	1.2205	1N22D-31*	◆
	31.50	1.2401	1N22D-31.5*	◆
	31.75	1.2500	1N22D-0108*	◆
	32.00	1.2598	1N22D-32*	◆
	32.50	1.2795	1N22D-32.5*	◆
	32.54	1.2813	1N22D-0109*	◆
	33.00	1.2992	1N22D-33*	◆
	33.34	1.3125	1N22D-0110*	◆
	33.50	1.3189	1N22D-33.5*	◆
	34.00	1.3386	1N22D-34*	◆
	34.13	1.3438	1N22D-0111*	◆
	34.50	1.3583	1N22D-34.5*	◆
	34.93	1.3750	1N22D-0112*	◆
	35.00	1.3780	1N22D-35*	◆

Supplied in 1 piece packages



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	24.50	0.9646	452H-24.5	○
	24.61	0.9688	452H-0031	○
	24.79	0.9760	452H-.976	○
	25.00	0.9843	452H-25	●
	25.40	1.0000	452H-0100	○
	25.50	1.0039	452H-25.5	●
	25.80	1.0156	452H-1.015	○
	26.00	1.0236	452H-26	●
	26.19	1.0313	452H-0101	○
	26.50	1.0433	452H-26.5	●
	26.59	1.0469	452H-1.046	○

Geometries available as non-stock standard

- HE
(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2



+44 (0)1384 400 900



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2 Series Inserts

Diameter Range 24.41 to 35.05mm



GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	26.99	1.0625	452H-0102	○
	27.00	1.0630	452H-27	●
	27.50	1.0827	452H-27.5	●
	27.78	1.0938	452H-0103	○
	28.00	1.1024	452H-28	●
	28.18	1.1094	452H-1.109	○
	28.50	1.1220	452H-28.5	●
	28.58	1.1250	452H-0104	○
	29.00	1.1417	452H-29	●
	29.37	1.1563	452H-0105	○
	29.50	1.1614	452H-29.5	●
	30.00	1.1811	452H-30	●
	30.16	1.1875	452H-0106*	○
	30.50	1.2008	452H-30.5**	●
	30.96	1.2188	452H-0107*	○
	31.00	1.2205	452H-31*	●
	31.14	1.2260	452H-1.226*	○
	31.26	1.2310	452H-1.231*	○
	31.34	1.2340	452H-1.234*	○
	31.50	1.2402	452H-31.5*	●
	31.75	1.2500	452H-0108*	○
	32.00	1.2598	452H-32*	●
	32.50	1.2795	452H-32.5*	●
	32.54	1.2813	452H-0109*	○
	33.00	1.2992	452H-33*	●
	33.34	1.3125	452H-0110*	○
	33.50	1.3189	452H-33.5*	●
	34.00	1.3386	452H-34*	●
	34.13	1.3438	452H-0111*	○
	34.50	1.3582	452H-34.5*	●
	34.93	1.3750	452H-0112*	○
	35.00	1.3780	452H-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- HE
(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN
(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



2 Series Inserts

Diameter Range 24.41 to 35.05mm

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K20 (C2) Carbide	24.50	0.9646	4C22H-24.5	●
	24.61	0.9688	4C22H-0031	○
	25.00	0.9843	4C22H-25	●
	25.40	1.0000	4C22H-0100	○
	25.50	1.0039	4C22H-25.5	●
	25.80	1.0156	4C22H-1.015	○
	26.00	1.0236	4C22H-26	●
	26.19	1.0313	4C22H-0101	○
	26.50	1.0433	4C22H-26.5	●
	26.59	1.0469	4C22H-1.046	○
	26.99	1.0625	4C22H-0102	○
	27.00	1.0630	4C22H-27	●
	27.50	1.0827	4C22H-27.5	●
	27.78	1.0938	4C22H-0103	○
	28.00	1.1024	4C22H-28	●
	28.18	1.1094	4C22H-1.109	○
	28.50	1.1220	4C22H-28.5	●
	28.58	1.1250	4C22H-0104	○
	29.00	1.1417	4C22H-29	●
	29.37	1.1563	4C22H-0105	○
	29.50	1.1614	4C22H-29.5	●
	30.00	1.1811	4C22H-30	●
	30.16	1.1875	4C22H-0106*	○
	30.50	1.2008	4C22H-30.5*	●
	30.96	1.2188	4C22H-0107*	○
	31.00	1.2205	4C22H-31*	●
	31.14	1.2260	4C22H-1.226*	○
	31.26	1.2310	4C22H-1.231*	○
	31.34	1.2340	4C22H-1.234*	○
	31.50	1.2402	4C22H-31.5*	●
	31.75	1.2500	4C22H-0108*	○
	32.00	1.2598	4C22H-32*	●
	32.50	1.2795	4C22H-32.5*	●
	32.54	1.2813	4C22H-0109*	○
	33.00	1.2992	4C22H-33*	●
	33.34	1.3125	4C22H-0110*	○
	33.50	1.3189	4C22H-33.5*	●
	34.00	1.3386	4C22H-34*	●
	34.13	1.3438	4C22H-0111*	○
	34.50	1.3582	4C22H-34.5*	●
	34.93	1.3750	4C22H-0112*	○
	35.00	1.3780	4C22H-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- HE

(see page 11 for details)

Coatings available as non-stock standard

T - TiN

N - TiCN

A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

● Stock Item.

○ Stocked in limited quantities, advanced planning is recommended.

◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

2 Series Inserts

Diameter Range 24.41 to 35.05mm



GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
K35 (C1) Carbide	24.50	0.9646	4C12H-24.5	●
	24.61	0.9688	4C12H-0031	○
	25.00	0.9843	4C12H-25	●
	25.40	1.0000	4C12H-0100	○
	25.50	1.0039	4C12H-25.5	●
	25.80	1.0156	4C12H-1.015	○
	26.00	1.0236	4C12H-26	●
	26.19	1.0313	4C12H-0101	○
	26.50	1.0433	4C12H-26.5	●
	26.59	1.0469	4C12H-1.046	○
	26.99	1.0625	4C12H-0102	○
	27.00	1.0630	4C12H-27	●
	27.50	1.0827	4C12H-27.5	●
	27.78	1.0938	4C12H-0103	○
	28.00	1.1024	4C12H-28	●
	28.18	1.1094	4C12H-1.109	○
	28.50	1.1220	4C12H-28.5	●
	28.58	1.1250	4C12H-0104	○
	29.00	1.1417	4C12H-29	●
	29.37	1.1563	4C12H-0105	○
	29.50	1.1614	4C12H-29.5	●
	30.00	1.1811	4C12H-30	●
	30.16	1.1875	4C12H-0106*	○
	30.50	1.2008	4C12H-30.5*	●
	30.96	1.2188	4C12H-0107*	○
	31.00	1.2205	4C12H-31*	●
	31.14	1.2260	4C12H-1.226*	○
	31.26	1.2310	4C12H-1.231*	○
	31.34	1.2340	4C12H-1.234*	○
	31.50	1.2402	4C12H-31.5*	●
	31.75	1.2500	4C12H-0108*	○
	32.00	1.2598	4C12H-32*	●
	32.50	1.2795	4C12H-32.5*	●
	32.54	1.2813	4C12H-0109*	○
	33.00	1.2992	4C12H-33*	●
	33.34	1.3125	4C12H-0110*	○
	33.50	1.3189	4C12H-33.5*	●
	34.00	1.3386	4C12H-34*	●
	34.13	1.3438	4C12H-0111*	○
	34.50	1.3582	4C12H-34.5*	●
	34.93	1.3750	4C12H-0112*	○
	35.00	1.3780	4C12H-35*	●

* Denotes inserts that will also fit 2.5 series T-A Holders

Supplied in packs of 2

Geometries available as non-stock standard

- HE

(see page 11 for details)

Coatings available as non-stock standard

T - TiN

N - TiCN

A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

● Stock Item.

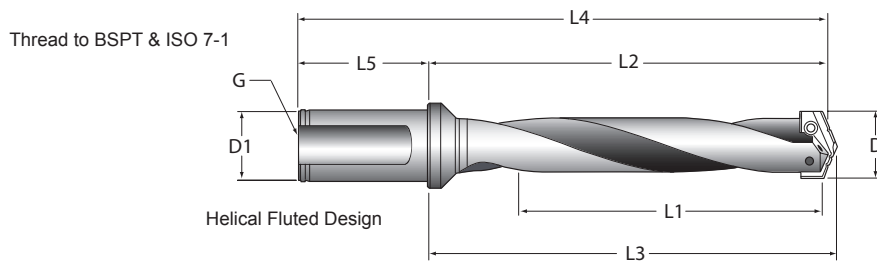
○ Stocked in limited quantities, advanced planning is recommended.

◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



3 Series Holders

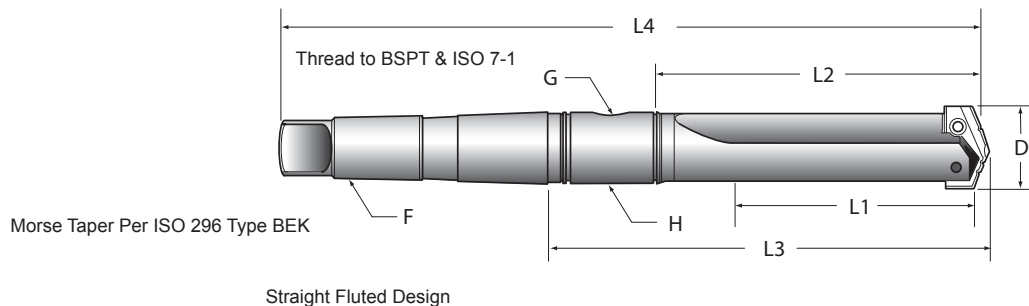


Flanged Straight Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D Drill Range D (mm)	L1 Max Drill Depth (mm)	L2 Body Length (mm)	L3 New Tool Ref Length (mm)	L4 Overall Length (mm)	L5 Shank Length (mm)	D1 Shank Diameter (mm)	G	*
21030S-40FM	Stub	Straight	36.00-47.00	76.2	125	129.8	195.0	70	40.0	1/4"	1/4"
22030S-40FM	Short	Straight	36.00-47.00	121	173	177.8	243.0	70	40.0	1/4"	N/A
23030H-40FM	Intermediate	Helical	36.00-47.00	165	217.5	222.3	287.5	70	40.0	1/4"	N/A
24030H-40FM	Standard	Helical	36.00-47.00	210	261.9	266.7	331.9	70	40.0	1/4"	N/A
⚠ 25030S-40FM	Extended	Straight	36.00-47.00	349	401.6	406.4	471.6	70	40.0	1/4"	N/A
⚠ 27030S-40FM	XL	Straight	36.00-47.00	558	611.1	615.9	681.1	70	40.0	1/4"	N/A
⚠ 29030S-40FM	3XL	Straight	36.00-47.00	787	839.7	844.5	909.7	70	40.0	1/4"	N/A

*Note: Stub Length includes additional side coolant port.



Taper Shank

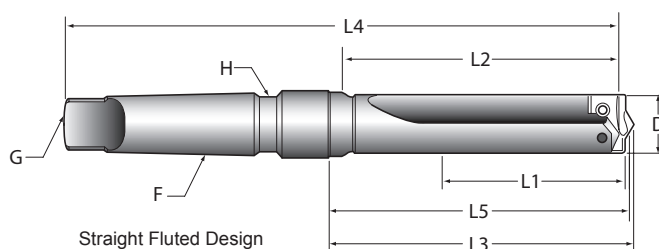
Available Ex-Stock

Part Number	Holder Type	Flute Type	D Drill Range (mm)	L1 Max Drill Depth (mm)	L2 Body Length (mm)	L3 New Tool Length (mm)	L4 Overall Length (mm)	F MT	H RCA	G Pipe Tap
22030S-004M	Short	Straight	36.00-47.00	121	152.4	206.4	319.1	4	4SRM	1/4"
23030H-004M	Intermediate	Helical	36.00-47.00	165	196.9	250.9	363.6	4	4SRM	1/4"
24030H-004M	Standard	Helical	36.00-47.00	210	241.3	295.3	408	4	4SRM	1/4"
⚠ 25030S-004M	Extended	Straight	36.00-47.00	349	381	435	547.7	4	4SRM	1/4"
⚠ 27030S-004I	XL	Straight	36.00-47.00	558	590.6	644.6	757.2	4	4SRM	1/4"
⚠ 29030S-004I	3XL	Straight	36.00-47.00	787	819.2	873.2	985.8	4	4SRM	1/4"

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.
Visit www.alliedmaxcut.com for the most up-to-date information and procedures.
Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.

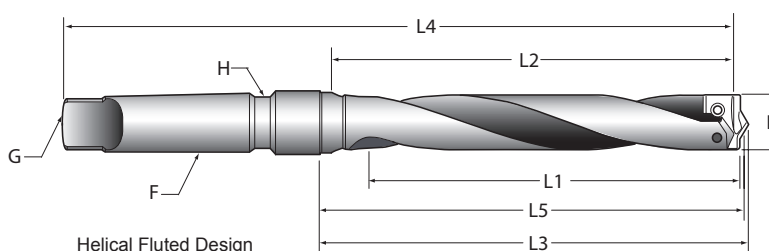
3 Series Structural Steel Holders



Short Length – Taper Shank Holders – Straight Flute

Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet		
								Through Tang Coolant	Through Shank Coolant	
22030S-004IS126	39	121	152	165.1	163.5	276	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.



Standard Length – Taper Shank Holders – Helical Flute

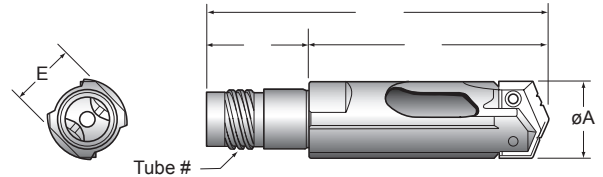
Part Number	D	L1	L2	L3	L5*	L4	F	G	H	Stk.
	Min. Drill Dia. mm	Max. Drill Depth. mm	Body Length (mm)	Ref Length mm	Ref Length mm	Overall Length mm	MT	Coolant Inlet		
								Through Tang Coolant	Through Shaft Coolant	
24030H-004IS126	35	165	197	209.6	207.9	321	4	TTC	TSC	●

*Note: Dimension if using a Structural Steel Holder with GEN2 & Structural Steel T-A® Drill Insert Geometry.

For Holder Accessories please see pages 84 - 88.



3 Series Drill and Tubes



Metric Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (mm)	Reference Length (mm)	Shank Length (mm)	Overall Length (mm)	Wrench Flat (mm)	
3	BTA3-807-xx.xx	807	35.06-36.22	96.8	36	132.8	30	◆
	BTA3-808-xx.xx	808	36.23-39.62	100	44.5	144.4	32	◆
	BTA3-809-xx.xx	809	39.63-43.00	103.1	43	146.2	36	◆
	BTA3-810-xx.xx	810	43.01-47.01	101.9	43	144.9	41	◆
	BTA3-811-xx.xx	811	47.02-47.80	103.2	43	146.2	41	◆

Imperial Heads

T-A® Series	Head Item Number	Tube Size	A	B	C	D	E	Stk.
			Diameter Range (inch)	Reference Length (inch)	Shank Length (inch)	Overall Length (inch)	Wrench Flat (mm)	
3	BTA3-807-x.xxxx	807	1.3801-1.4259	3-13/16	1-27/64	5-15/64	30	◆
	BTA3-808-x.xxxx	808	1.4260-1.5599	3-15/16	1-3/4	5-11/16	32	◆
	BTA3-809-x.xxxx	809	1.5600-1.6929	4-1/16	1-11/16	5-3/4	36	◆
	BTA3-810-x.xxxx	810	1.6930-1.8509	4-1/64	1-11/16	5-45/64	41	◆
	BTA3-811-x.xxxx	811	1.8510-1.8820	4-1/16	1-11/16	5-3/4	41	◆



Metric Tubes

Tube Size	Tube Item Number	Metric				Stk.
		Diameter Range (mm)	Tube OD (mm)	Tube ID (mm)	Length (mm)	
807	BTAT807-102	33.31-36.20	30.0	20.0	2591	○
808	BTAT808-102	36.21-39.60	33.0	23.0	2591	○
809	BTAT809-102	39.61-42.98	36.0	25.0	2591	○
810	BTAT810-102	42.99-46.99	39.0	28.0	2591	○
811	BTAT811-102	47.00-47.80	43.0	31.0	2591	○

Imperial Tubes

Tube Size	Tube Item Number	Imperial				Stk.
		Diameter Range (inch)	Tube OD (inch)	Tube ID (inch)	Length (inch)	
807	BTAT807-102	1.312-1.425	1.181	0.787	102	○
808	BTAT808-102	1.426-1.559	1.299	0.906	102	○
809	BTAT809-102	1.560-1.692	1.417	0.984	102	○
810	BTAT810-102	1.693-1.850	1.535	1.102	102	○
811	BTAT811-102	1.851-1.882	1.693	1.220	102	○

Stk. - Stock Availability.

- ◆ Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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3 Series Inserts

Diameter Range 34.37 to 47.80mm



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	35.72	1.4063	153H-0113	◆
	36.00	1.4173	153H-36	○
	36.51	1.4375	153H-0114	◆
	37.00	1.4567	153H-37	○
	37.31	1.4688	153H-0115	◆
	38.00	1.4961	153H-38	○
	38.10	1.5000	153H-0116	◆
	38.89	1.5313	153H-0117	◆
	39.00	1.5354	153H-39	○
	39.69	1.5625	153H-0118	◆
	40.00	1.5748	153H-40	○
	40.48	1.5938	153H-0119	◆
	41.00	1.6142	153H-41	○
	41.28	1.6250	153H-0120	◆
	42.00	1.6535	153H-42	○
	42.07	1.6563	153H-0121	◆
	42.86	1.6875	153H-0122	◆
	43.00	1.6929	153H-43	○
	43.66	1.7188	153H-0123	◆
	44.00	1.7323	153H-44	○
	44.45	1.7500	153H-0124	◆
	45.00	1.7717	153H-45	○
	45.24	1.7813	153H-0125	◆
	46.00	1.8110	153H-46	○
	46.04	1.8125	153H-0126	◆
	46.83	1.8438	153H-0127	◆
	47.00	1.8504	153H-47	○
	47.63	1.8750	153H-0128	◆

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	35.72	1.4063	1C23T-0113	○	1C23A-0113	○
	36.00	1.4173	1C23T-36	○	1C23A-36	●
	36.51	1.4375	1C23T-0114	○	1C23A-0114	○
	37.00	1.4567	1C23T-37	○	1C23A-37	●
	37.31	1.4688	1C23T-0115	○	1C23A-0115	○
	38.00	1.4961	1C23T-38	○	1C23A-38	●
	38.10	1.5000	1C23T-0116	○	1C23A-0116	○
	38.89	1.5313	1C23T-0117	○	1C23A-0117	○
	39.00	1.5354	1C23T-39	○	1C23A-39	●
	39.69	1.5625	1C23T-0118	○	1C23A-0118	○
	40.00	1.5748	1C23T-40	○	1C23A-40	●
	40.48	1.5938	1C23T-0119	○	1C23A-0119	○
	41.00	1.6142	1C23T-41	○	1C23A-41	●
	41.28	1.6250	1C23T-0120	○	1C23A-0120	○
	42.00	1.6535	1C23T-42	○	1C23A-42	●
	42.07	1.6563	1C23T-0121	○	1C23A-0121	○
	42.86	1.6875	1C23T-0122	○	1C23A-0122	○
	43.00	1.6929	1C23T-43	○	1C23A-43	●
	43.66	1.7188	1C23T-0123	○	1C23A-0123	○
	44.00	1.7323	1C23T-44	○	1C23A-44	●
	44.45	1.7500	1C23T-0124	○	1C23A-0124	○
	45.00	1.7717	1C23T-45	○	1C23A-45	●

Supplied in packs of 1

Geometries available as non-stock standard

- BR - HR
- CI - NC
- CR - SK
- HI - WC

(see page 11 for details)

Coatings available as non-stock standard

- T - TiN
- N - TiCN
- A - TiAlN

(see page 10 for details)

Geometries available as non-stock standard

- BR - IN
- CI - NC
- CN - NP
- CR - RN
- HI - SK
- HR - WC

(see page 11 for details)

Coatings available as non-stock standard

- H - AM200®
- N - TiCN

(see page 10 for details)



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3 Series Inserts

Diameter Range 34.37 to 47.80mm



Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	TiAlN	Stk.
K20 (C2) Carbide	45.24	1.7813	1C23T-0125	○	1C23A-0125	○
	46.00	1.8110	1C23T-46	○	1C23A-46	●
	46.04	1.8125	1C23T-0126	○	1C23A-0126	○
	46.83	1.8438	1C23T-0127	○	1C23A-0127	○
	47.00	1.8504	1C23T-47	○	1C23A-47	●
	47.63	1.8750	1C23T-0128	○	1C23A-0128	○
P40 (C5) Carbide	35.72	1.4063	1C53T-0113	○	1C53A-0113	○
	36.00	1.4173	1C53T-36	○	1C53A-36	○
	36.51	1.4375	1C53T-0114	○	1C53A-0114	○
	37.00	1.4567	1C53T-37	○	1C53A-37	○
	37.31	1.4688	1C53T-0115	○	1C53A-0115	○
	38.00	1.4961	1C53T-38	○	1C53A-38	○
	38.10	1.5000	1C53T-0116	○	1C53A-0116	○
	38.89	1.5313	1C53T-0117	○	1C53A-0117	○
	39.00	1.5354	1C53T-39	○	1C53A-39	○
	39.69	1.5625	1C53T-0118	○	1C53A-0118	○
	40.00	1.5748	1C53T-40	○	1C53A-40	○
	40.48	1.5938	1C53T-0119	○	1C53A-0119	○
	41.00	1.6142	1C53T-41	○	1C53A-41	○
	41.28	1.6250	1C53T-0120	○	1C53A-0120	○
	42.00	1.6535	1C53T-42	○	1C53A-42	○
	42.07	1.6563	1C53T-0121	○	1C53A-0121	○
	42.86	1.6875	1C53T-0122	○	1C53A-0122	○
	43.00	1.6929	1C53T-43	○	1C53A-43	○
	43.66	1.7188	1C53T-0123	○	1C53A-0123	○
	44.00	1.7323	1C53T-44	○	1C53A-44	○
	44.45	1.7500	1C53T-0124	○	1C53A-0124	○
	45.00	1.7717	1C53T-45	○	1C53A-45	○
	45.24	1.7813	1C53T-0125	○	1C53A-0125	○
	46.00	1.8110	1C53T-46	○	1C53A-46	○
	46.04	1.8125	1C53T-0126	○	1C53A-0126	○
	46.83	1.8438	1C53T-0127	○	1C53A-0127	○
	47.00	1.8504	1C53T-47	○	1C53A-47	○
	47.63	1.8750	1C53T-0128	○	1C53A-0128	○

Geometries available as non-stock standard

- BR - IN
- CI - NC
- CN - NP
- CR - RN
- HI - SK
- HR - WC
(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
(see page 10 for details)

Supplied in packs of 1



Spot & Chamfer

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	35.72	1.4063	153T-0113-SP	◆
	36.00	1.4173	153T-36-SP	◆
	36.51	1.4375	153T-0114-SP	◆
	37.00	1.4567	153T-37-SP	◆
	37.31	1.4688	153T-0115-SP	◆
	38.00	1.4961	153T-38-SP	◆
	38.10	1.5000	153T-0116-SP	◆
	38.89	1.5313	153T-0117-SP	◆
	39.00	1.5354	153T-39-SP	◆
	39.69	1.5625	153T-0118-SP	◆
	40.00	1.5748	153T-40-SP	◆
	40.48	1.5938	153T-0119-SP	◆
	41.00	1.6142	153T-41-SP	◆
	41.28	1.6250	153T-0120-SP	◆
	42.00	1.6535	153T-42-SP	◆
	42.07	1.6563	153T-0121-SP	◆
	42.86	1.6875	153T-0122-SP	◆

Geometries available as non-stock standard

- SW
(see page 11 for details)

Coatings available as non-stock standard

A - TiAlN
H - AM200®
N - TiCN
(see page 10 for details)

Supplied in packs of 1

3 Series Inserts

Diameter Range 34.37 to 47.80mm



Spot & Chamfer

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	43.00	1.6929	153T-43-SP	◆
	43.66	1.7188	153T-0123-SP	◆
	44.00	1.7323	153T-44-SP	◆
	44.45	1.7500	153T-0124-SP	◆
	45.00	1.7717	153T-45-SP	◆
	45.24	1.7813	153T-0125-SP	◆
	46.00	1.8110	153T-46-SP	◆
	46.04	1.8125	153T-0126-SP	◆
	46.83	1.8438	153T-0127-SP	◆
	47.00	1.8504	153T-47-SP	◆
	47.63	1.8750	153T-0128-SP	●

Supplied in packs of 1

Geometries available as non-stock standard

- SW

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)



Flat Bottom

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	35.72	1.4063	153T-0113-FB	○
	36.00	1.4173	153T-36-FB	●
	36.51	1.4375	153T-0114-FB	○
	37.00	1.4567	153T-37-FB	○
	37.31	1.4688	153T-0115-FB	○
	38.00	1.4961	153T-38-FB	●
	38.10	1.5000	153T-0116-FB	○
	38.89	1.5313	153T-0117-FB	○
	39.00	1.5354	153T-39-FB	●
	39.69	1.5625	153T-0118-FB	○
	40.00	1.5748	153T-40-FB	●
	40.48	1.5938	153T-0119-FB	○
	41.00	1.6142	153T-41-FB	●
	41.28	1.6250	153T-0120-FB	○
	42.00	1.6535	153T-42-FB	●
	42.07	1.6563	153T-0121-FB	○
	42.86	1.6875	153T-0122-FB	○
	43.00	1.6929	153T-43-FB	●
	43.66	1.7188	153T-0123-FB	○
	44.00	1.7323	153T-44-FB	●
	44.45	1.7500	153T-0124-FB	○
	45.00	1.7717	153T-45-FB	●
	45.24	1.7813	153T-0125-FB	○
	46.00	1.8110	153T-46-FB	●
	46.04	1.8125	153T-0126-FB	○
	46.83	1.8438	153T-0127-FB	○
	47.00	1.8504	153T-47-FB	●
	47.63	1.8750	153T-0128-FB	○

Supplied in packs of 1

Geometries available as non-stock standard

- FN

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

● Stock Item.

○ Stocked in limited quantities, advanced planning is recommended.

◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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3 Series Inserts

Diameter Range 34.37 to 47.80mm



Thin Wall (for Structural Steel material up to 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	36.51	1.4375	153A-0114-TW	○	153H-0114-TW	○
	38.10	1.5000	153A-0116-TW	○	153H-0116-TW	○
	39.00	1.5354	153A-39-TW	●	153H-39-TW	●
	39.69	1.5625	153A-0118-TW	○	153H-0118-TW	○

Supplied in packs of 1

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



Notch Point (for Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	36.51	1.4375	153A-0114-NP	○	153H-0114-NP	○
	38.10	1.5000	153A-0116-NP	○	153H-0116-NP	○
	39.00	1.5354	153A-39-NP	●	153H-39-NP	●
	39.69	1.5625	153A-0118-NP	○	153H-0118-NP	○

Supplied in packs of 1

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



150° Structural Steel (reduced exit burr on Structural Steel material over 6mm thick)

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiAlN	Stk.	AM200®	Stk.
HSS Super Cobalt	36.51	1.4375	153A-0114-SS	○	153H-0114-SS	○
	38.10	1.5000	153A-0116-SS	○	153H-0116-SS	○
	39.00	1.5354	153A-39-SS	○	153H-39-SS	○
	39.69	1.5625	153A-0118-SS	○	153H-0118-SS	○

Supplied in packs of 1

Coatings available as non-stock standard

T - TiN

N - TiCN

(see page 10 for details)



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS CPM-M4	35.72	1.4063	433T-0113	○
	36.00	1.4173	433T-36	●
	36.51	1.4375	433T-0114	○
	37.00	1.4567	433T-37	●
	37.31	1.4688	433T-0115	○
	38.00	1.4961	433T-38	●
	38.10	1.5000	433T-0116	○
	38.89	1.5313	433T-0117	○
	39.00	1.5354	433T-39	●
	39.69	1.5625	433T-0118	○
	40.00	1.5748	433T-40	●
	40.48	1.5938	433T-0119	○
	41.00	1.6142	433T-41	●
	41.28	1.6250	433T-0120	○
	42.00	1.6535	433T-42	●
	42.07	1.6563	433T-0121	○
	42.86	1.6875	433T-0122	○
	43.00	1.6929	433T-43	●
	43.66	1.7188	433T-0123	○
	44.00	1.7323	433T-44	●
	44.45	1.7500	433T-0124	○
	45.00	1.7717	433T-45	●
	45.24	1.7813	433T-0125	○
	46.00	1.8110	433T-46	●

Supplied in packs of 1

Geometries available as non-stock standard

- BR - HR

- CI - NC

- CR - SK

- HE - WC

- HI

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

A - TiAlN

(see page 10 for details)

3 Series Inserts

Diameter Range 34.37 to 47.80mm



GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS CPM-M4	46.04	1.8125	433T-0126	○
	46.83	1.8438	433T-0127	○
	47.00	1.8504	433T-47	●
	47.63	1.8750	433T-0128	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - HR
- CI - NC
- CR - SK
- HE - WC
- HI

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

A - TiAlN

(see page 10 for details)

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	TiN	Stk.	AM200®	Stk.
HSS Super Cobalt	35.72	1.4063	453T-0113	○	453H-0113	○
	36.00	1.4173	453T-36	●	453H-36	●
	36.51	1.4375	453T-0114	○	453H-0114	○
	37.00	1.4567	453T-37	●	453H-37	●
	37.31	1.4688	453T-0115	○	453H-0115	○
	38.00	1.4961	453T-38	●	453H-38	●
	38.10	1.5000	453T-0116	○	453H-0116	○
	38.89	1.5313	453T-0117	○	453H-0117	○
	39.00	1.5354	453T-39	●	453H-39	●
	39.69	1.5625	453T-0118	○	453H-0118	○
	40.00	1.5748	453T-40	●	453H-40	●
	40.48	1.5938	453T-0119	○	453H-0119	○
	41.00	1.6142	453T-41	●	453H-41	●
	41.28	1.6250	453T-0120	○	453H-0120	○
	42.00	1.6535	453T-42	●	453H-42	●
	42.07	1.6563	453T-0121	○	453H-0121	○
	42.86	1.6875	453T-0122	○	453H-0122	○
	43.00	1.6929	453T-43	●	453H-43	●
	43.66	1.7188	453T-0123	○	453H-0123	○
	44.00	1.7323	453T-44	●	453H-44	●
	44.45	1.7500	453T-0124	○	453H-0124	○
	45.00	1.7717	453T-45	●	453H-45	●
	45.24	1.7813	453T-0125	○	453H-0125	○
	46.00	1.8110	453T-46	●	453H-46	●
	46.04	1.8125	453T-0126	○	453H-0126	○
	46.83	1.8438	453T-0127	○	453H-0127	○
	47.00	1.8504	453T-47	●	453H-47	●
	47.63	1.8750	453T-0128	○	453H-0128	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - HR
- CI - NC
- CR - SK
- HE - WC
- HI

(see page 11 for details)

Coatings available as non-stock standard

N - TiCN

A - TiAlN

(see page 10 for details)

Grades available as non-stock standard

Premium Cobalt

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

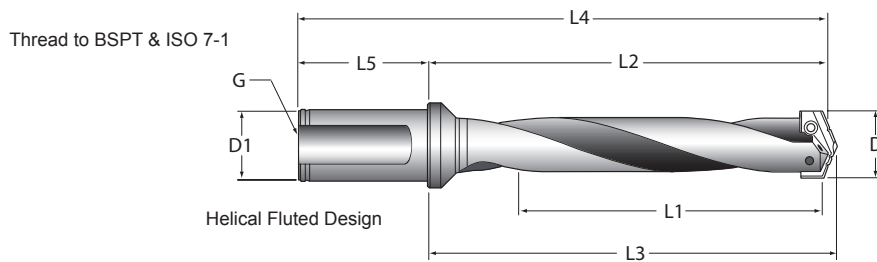
Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



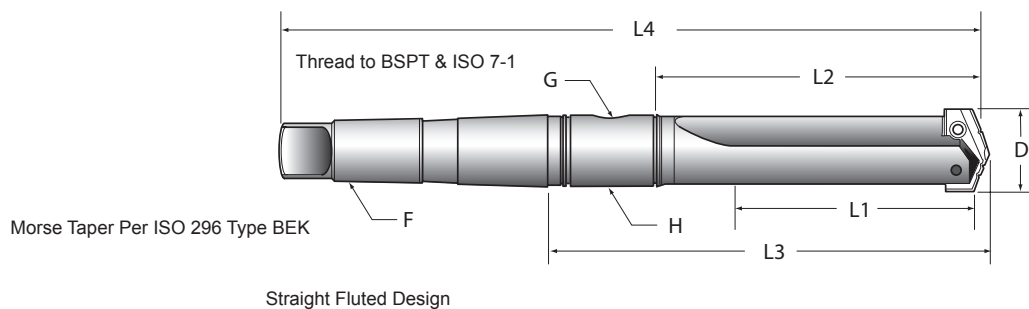
4 Series Holders



Flanged Straight Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	L5	D1	G	*
			Drill Range D (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Ref Length (mm)	Overall Length (mm)	Shank Length (mm)	Shank Diameter (mm)	Pipe Tap	
22040S-40FM	Short	Straight	48.00-65.00	130	179.4	184.2	249.4	70	40.0	1/4"	N/A
24040H-40FM	Standard	Helical	48.00-65.00	232	281.0	285.8	351.0	70	40.0	1/4"	N/A
⚠ 25040S-40FM	Extended	Straight	48.00-65.00	422	471.5	476.3	541.5	70	40.0	1/4"	N/A
⚠ 27040S-40FM	XL	Straight	48.00-65.00	625	674.7	679.5	744.7	70	40.0	1/4"	N/A
⚠ 29040S-40FM	3XL	Straight	48.00-65.00	879	928.7	933.5	998.7	70	40.0	1/4"	N/A



Taper Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	F	H	G
			Drill Range (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Length (mm)	Overall Length (mm)	MT	RCA	Pipe Tap
22040S-005M	Short	Straight	48.00-65.00	130	165.1	219.1	363.5	5	5SRM	1/4"
24040H-005M	Standard	Helical	48.00-65.00	232	266.7	320.7	465.1	5	5SRM	1/4"
⚠ 25040S-005M	Extended	Straight	48.00-65.00	422	457.0	511.2	655.6	5	5SRM	1/4"
⚠ 27040S-005I	XL	Straight	48.00-65.00	625	660.4	714.4	858.8	5	5SRM	1/4"
⚠ 29040S-005I	3XL	Straight	48.00-65.00	879	914.4	968.4	1112.8	5	5SRM	1/4"

⚠ WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.
 Visit www.alliedmaxcut.com for the most up-to-date information and procedures.
 Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.

4 Series Inserts

Diameter Range 46.99 to 65.28mm



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	48.00	1.8898	154H-48	○
	48.42	1.9063	154H-0129	◆
	49.00	1.9291	154H-49	○
	49.21	1.9375	154H-0130	◆
	50.00	1.9685	154H-50	○
	50.01	1.9688	154H-0131	◆
	50.80	2.0000	154H-0200	◆
	51.00	2.0079	154H-51	○
	51.59	2.0313	154H-0201	◆
	52.00	2.0472	154H-52	○
	52.39	2.0625	154H-0202	◆
	53.00	2.0866	154H-53	○
	53.18	2.0938	154H-0203	◆
	53.98	2.1250	154H-0204	◆
	54.00	2.1260	154H-54	○
	54.77	2.1563	154H-0205	◆
	55.00	2.1654	154H-55	○
	55.56	2.1875	154H-0206	◆
	56.00	2.2047	154H-56	○
	56.36	2.2188	154H-0207	◆
	57.00	2.2441	154H-57	○
	57.15	2.2500	154H-0208	◆
	57.94	2.2813	154H-0209	◆
	58.00	2.2835	154H-58	○
	58.74	2.3125	154H-0210	◆
	59.00	2.3228	154H-59	○
	59.53	2.3438	154H-0211	◆
	60.00	2.3622	154H-60	○
	60.33	2.3750	154H-0212	◆
	61.00	2.4016	154H-61	○
	61.12	2.4063	154H-0213	◆
	61.91	2.4375	154H-0214	◆
	62.00	2.4409	154H-62	○
	62.71	2.4688	154H-0215	◆
	63.00	2.4803	154H-63	○
	63.50	2.5000	154H-0216	◆
	64.00	2.5197	154H-64	○
	64.29	2.5313	154H-0217	◆
	65.00	2.5591	154H-65	○
	65.09	2.5625	154H-0218	◆

Supplied in packs of 1

Geometries available as non-stock standard

- BR - HR
- CI - NC
- CR - SK
- HI - WC

(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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T-A & BENZ T-A

BENSSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



4 Series Inserts

Diameter Range 46.99 to 65.28mm



Flat bottom

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS Super Cobalt	48.00	1.8898	154T-48-FB	●
	48.42	1.9063	154T-0129-FB	○
	49.00	1.9291	154T-49-FB	●
	49.21	1.9375	154T-0130-FB	○
	50.00	1.9685	154T-50-FB	●
	50.01	1.9688	154T-0131-FB	○
	50.80	2.0000	154T-0200-FB	○
	51.00	2.0079	154T-51-FB	●
	51.59	2.0313	154T-0201-FB	○
	52.00	2.0472	154T-52-FB	●
	52.39	2.0625	154T-0202-FB	○
	53.00	2.0866	154T-53-FB	●
	53.18	2.0938	154T-0203-FB	○
	53.98	2.1250	154T-0204-FB	○
	54.00	2.1260	154T-54-FB	●
	54.77	2.1563	154T-0205-FB	○
	55.00	2.1654	154T-55-FB	●
	55.56	2.1875	154T-0206-FB	○
	56.00	2.2047	154T-56-FB	●
	56.36	2.2188	154T-0207-FB	○
	57.00	2.2441	154T-57-FB	●
	57.15	2.2500	154T-0208-FB	○
	57.94	2.2813	154T-0209-FB	○
	58.00	2.2835	154T-58-FB	●
	58.74	2.3125	154T-0210-FB	○
	59.00	2.3228	154T-59-FB	●
	59.53	2.3438	154T-0211-FB	○
	60.00	2.3622	154T-60-FB	●
	60.33	2.3750	154T-0212-FB	○
	61.00	2.4016	154T-61-FB	●
	61.12	2.4063	154T-0213-FB	○
	61.91	2.4375	154T-0214-FB	○
	62.00	2.4409	154T-62-FB	●
	62.71	2.4688	154T-0215-FB	○
	63.00	2.4803	154T-63-FB	●
	63.50	2.5000	154T-0216-FB	○
	64.00	2.5197	154T-64-FB	●
	64.29	2.5313	154T-0217-FB	○
	65.00	2.5591	154T-65-FB	●
	65.09	2.5625	154T-0218-FB	○

Supplied in packs of 1

Geometries available as non-stock standard

- FN

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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4 Series Inserts

Diameter Range 46.99 to 65.28mm



GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS CPM-M4	48.00	1.8898	434T-48	●
	48.42	1.9063	434T-0129	○
	49.00	1.9291	434T-49	●
	49.21	1.9375	434T-0130	○
	50.00	1.9685	434T-50	●
	50.01	1.9688	434T-0131	○
	50.80	2.0000	434T-0200	○
	51.00	2.0079	434T-51	●
	51.59	2.0313	434T-0201	○
	52.00	2.0472	434T-52	●
	52.39	2.0625	434T-0202	○
	53.00	2.0866	434T-53	●
	53.18	2.0938	434T-0203	○
	53.98	2.1250	434T-0204	○
	54.00	2.1260	434T-54	●
	54.77	2.1563	434T-0205	○
	55.00	2.1654	434T-55	●
	55.56	2.1875	434T-0206	○
	56.00	2.2047	434T-56	●
	56.36	2.2188	434T-0207	○
	57.00	2.2441	434T-57	●
	57.15	2.2500	434T-0208	○
	57.94	2.2813	434T-0209	○
	58.00	2.2835	434T-58	●
	58.74	2.3125	434T-0210	○
	59.00	2.3228	434T-59	●
	59.53	2.3438	434T-0211	○
	60.00	2.3622	434T-60	●
	60.33	2.3750	434T-0212	○
	61.00	2.4016	434T-61	●
	61.12	2.4063	434T-0213	○
	61.50	2.4212	434T-61.5	◆
	61.91	2.4375	434T-0214	○
	62.00	2.4409	434T-62	●
	62.71	2.4688	434T-0215	○
	63.00	2.4803	434T-63	●
	63.50	2.5000	434T-0216	○
	64.00	2.5197	434T-64	●
	64.29	2.5313	434T-0217	○
	65.00	2.5591	434T-65	●
	65.09	2.5625	434T-0218	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - HR
- CI - NC
- CR - SK
- HI - WC
- HE

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

T-A & GEN2 T-A

GEN2SYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



4 Series Inserts

Diameter Range 46.99 to 65.28mm

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability			
	Ø mm	Ø Inch	AM200®	Stk.	TiN	Stk.
HSS Super Cobalt	48.00	1.8898	454H-48	●	454T-48	●
	48.42	1.9063	454H-0129	○	454T-0129	○
	49.00	1.9291	454H-49	●	454T-49	●
	49.21	1.9375	454H-0130	○	454T-0130	○
	50.00	1.9685	454H-50	●	454T-50	●
	50.01	1.9688	454H-0131	○	454T-0131	○
	50.80	2.0000	454H-0200	○	454T-0200	○
	51.00	2.0079	454H-51	●	454T-51	●
	51.59	2.0313	454H-0201	○	454T-0201	○
	52.00	2.0472	454H-52	●	454T-52	●
	52.39	2.0625	454H-0202	○	454T-0202	○
	53.00	2.0866	454H-53	●	454T-53	●
	53.18	2.0938	454H-0203	○	454T-0203	○
	53.98	2.1250	454H-0204	○	454T-0204	○
	54.00	2.1260	454H-54	●	454T-54	●
	54.77	2.1563	454H-0205	○	454T-0205	○
	55.00	2.1654	454H-55	●	454T-55	●
	55.56	2.1875	454H-0206	○	454T-0206	○
	56.00	2.2047	454H-56	●	454T-56	●
	56.36	2.2188	454H-0207	○	454T-0207	○
	57.00	2.2441	454H-57	●	454T-57	●
	57.15	2.2500	454H-0208	○	454T-0208	○
	57.94	2.2813	454H-0209	○	454T-0209	○
	58.00	2.2835	454H-58	●	454T-58	●
	58.74	2.3125	454H-0210	○	454T-0210	○
	59.00	2.3228	454H-59	●	454T-59	●
	59.53	2.3438	454H-0211	○	454T-0211	○
	60.00	2.3622	454H-60	●	454T-60	●
	60.33	2.3750	454H-0212	○	454T-0212	○
	61.00	2.4016	454H-61	●	454T-61	●
	61.12	2.4063	454H-0213	○	454T-0213	○
	61.50	2.4212	454H-61.5	○	454T-61.5	○
	61.91	2.4375	454H-0214	○	454T-0214	○
	62.00	2.4409	454H-62	●	454T-62	●
	62.71	2.4688	454H-0215	○	454T-0215	○
	63.00	2.4803	454H-63	●	454T-63	●
	63.50	2.5000	454H-0216	○	454T-0216	○
	64.00	2.5197	454H-64	●	454T-64	●
	64.29	2.5313	454H-0217	○	454T-0217	○
	65.00	2.5591	454H-65	●	454T-65	●
	65.09	2.5625	454H-0218	○	454T-0218	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - HR
- CI - NC
- CR - SK
- HE - WC
- HI

(see page 11 for details)

Coatings available as non-stock standard

N - TiCN

A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



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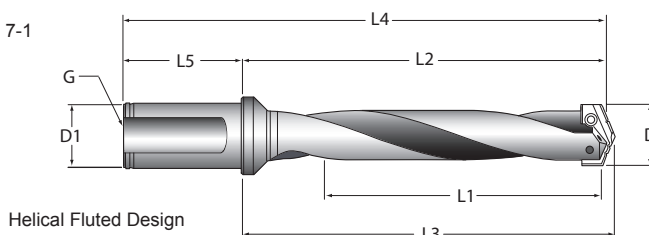


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5/6 and 7/8 Series Holders



Thread to BSPT & ISO 7-1



Helical Fluted Design

5/6 Series Flanged Straight Shank

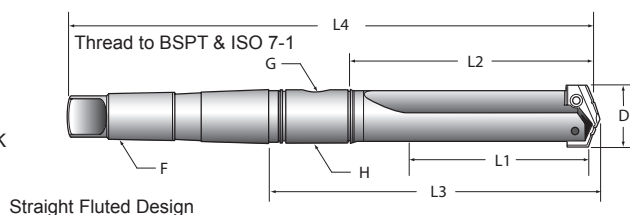
Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	L5	D1	G	*
			Drill Range D (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Ref Length (mm)	Overall Length (mm)	Shank Length (mm)	Shank Diameter (mm)	Pipe Tap	
22050S-50FM	Short	Straight	64.00-88.00	172	215.9	222.3	302.3	80	50.0	1/2"	N/A
24050H-50FM	Standard	Helical	64.00-88.00	273	317.5	323.9	403.9	80	50.0	1/2"	N/A
⚠ 25050S-50FM	Extended	Straight	64.00-88.00	464	508.0	514.4	594.4	80	50.0	1/2"	N/A

7/8 Series Flanged Straight Shank

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	L5	D1	G	*
			Drill Range D (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Ref Length (mm)	Overall Length (mm)	Shank Length (mm)	Shank Diameter (mm)	Pipe Tap	
22070S-50FM	Short	Straight	90.00-114.00	172	225.4	231.8	311.8	80	50.0	1/2"	N/A
24070H-50FM	Standard	Helical	90.00-114.00	273	327.0	333.4	413.4	80	50.0	1/2"	N/A
⚠ 25070S-50FM	Extended	Straight	90.00-114.00	556	606.9	616.0	696.0	80	50.0	1/2"	N/A

Morse Taper Per ISO 296 Type BEK



Straight Fluted Design

5/6 Series Taper Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	F	H	G
			Drill Range (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Length (mm)	Overall Length (mm)	MT	RCA	Pipe Tap
22050S-005M	Short	Straight	64.00-88.00	172	215.9	287.3	430.2	5	6SRM	1/2"
24050H-005M	Standard	Helical	64.00-88.00	273	317.5	388.9	531.8	5	6SRM	1/2"
⚠ 25050S-005M	Extended	Straight	64.00-88.00	464	508	579.4	722.3	5	6SRM	1/2"
⚠ 27050S-005I	XL	Straight	64.00-88.00	660	704.8	776.2	919.1	5	6SRM	1/2"
⚠ 29050S-005I	3XL	Straight	64.00-88.00	889	933.4	1004.8	1147.7	5	6SRM	1/2"

7/8 Series Taper Shank

Available Ex-Stock

Part Number	Holder Type	Flute Type	D	L1	L2	L3	L4	F	H	G
			Drill Range (mm)	Max Drill Depth (mm)	Body Length (mm)	New Tool Length (mm)	Overall Length (mm)	MT	RCA	Pipe Tap
22070S-005M	Short	Straight	90.00-114.00	172	225.4	296.8	439.7	5	6SRM	1/2"
24070H-005M	Standard	Helical	90.00-114.00	273	327	398.5	541.3	5	6SRM	1/2"
⚠ 25070S-005M	Extended	Straight	90.00-114.00	556	610	681	823.9	5	6SRM	1/2"
⚠ 27070S-005I	XL	Straight	90.00-114.00	685	739.7	811.2	954.0	5	6SRM	1/2"
⚠ 29070S-005I	3XL	Straight	90.00-114.00	939	993.7	1065.2	1208.0	5	6SRM	1/2"

WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

Visit www.alliedmaxcut.com for the most up-to-date information and procedures.

Technical assistance is available for your specific applications from our Application Engineering Team.

For Holder Accessories please see pages 84 - 88.



5 Series Inserts

Diameter Range 62.38 to 76.20mm



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS CPM-M4	63.50	2.5000	135H-0216	◆
	64.00	2.5197	135H-64	○
	64.29	2.5313	135H-0217	◆
	65.09	2.5625	135H-0218	◆
	65.88	2.5938	135H-0219	◆
	66.00	2.5984	135H-66	○
	66.68	2.6250	135H-0220	◆
	67.47	2.6563	135H-0221	◆
	68.00	2.6772	135H-68	○
	68.26	2.6875	135H-0222	◆
	69.05	2.7188	135H-0223	◆
	69.85	2.7500	135H-0224	◆
	70.00	2.7559	135H-70	○
	70.64	2.7813	135H-0225	◆
	71.44	2.8125	135H-0226	◆
	72.00	2.8346	135H-72	○
	72.23	2.8438	135H-0227	◆
	73.03	2.8750	135H-0228	◆
	73.82	2.9063	135H-0229	◆
	74.00	2.9134	135H-74	○
	74.41	2.9375	135H-0230	◆
	75.61	2.9688	135H-0231	◆
	76.00	2.9921	135H-76	○
	76.20	3.0000	135H-0300	◆

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN

(see page 10 for details)



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS CPM-M4	63.50	2.5000	435T-0216	○
	64.00	2.5197	435T-64	●
	64.29	2.5313	435T-0217	○
	65.09	2.5625	435T-0218	○
	65.88	2.5938	435T-0219	○
	66.00	2.5984	435T-66	●
	66.68	2.6250	435T-0220	○
	67.47	2.6563	435T-0221	○
	68.00	2.6772	435T-68	●
	68.26	2.6875	435T-0222	○
	69.05	2.7188	435T-0223	○
	69.85	2.7500	435T-0224	○
	70.00	2.7559	435T-70	●
	70.64	2.7813	435T-0225	○
	71.44	2.8125	435T-0226	○
	72.00	2.8346	435T-72	●
	72.23	2.8438	435T-0227	○
	73.03	2.8750	435T-0228	○
	73.82	2.9063	435T-0229	○
	74.00	2.9134	435T-74	●
	74.41	2.9375	435T-0230	○
	75.61	2.9688	435T-0231	○
	76.00	2.9921	435T-76	●
	76.20	3.0000	435T-0300	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN

(see page 10 for details)

5 Series Inserts

Diameter Range 62.38 to 76.20mm



GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	63.50	2.5000	455H-0216	○
	64.00	2.5197	455H-64	●
	64.29	2.5313	455H-0217	○
	65.09	2.5625	455H-0218	○
	65.88	2.5938	455H-0219	○
	66.00	2.5984	455H-66	●
	66.68	2.6250	455H-0220	○
	67.47	2.6563	455H-0221	○
	68.00	2.6772	455H-68	●
	68.26	2.6875	455H-0222	○
	69.05	2.7188	455H-0223	○
	69.85	2.7500	455H-0224	○
	70.00	2.7559	455H-70	●
	70.64	2.7813	455H-0225	○
	71.44	2.8125	455H-0226	○
	72.00	2.8346	455H-72	●
	72.23	2.8438	455H-0227	○
	73.03	2.8750	455H-0228	○
	73.82	2.9063	455H-0229	○
	74.00	2.9134	455H-74	●
	74.41	2.9375	455H-0230	○
	75.61	2.9688	455H-0231	○
	76.00	2.9921	455H-76	●
	76.20	3.0000	455H-0300	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

- T - TiN
- N - TiCN
- A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

T-A & GEN2 T-A

GEN2 S/S

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



6 Series Inserts

Diameter Range 76.23 to 89.08mm



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS CPM-M4	76.99	3.0313	136H-0301	◆
	77.79	3.0625	136H-0302	◆
	78.00	3.0709	136H-78	○
	78.58	3.0938	136H-0303	◆
	79.38	3.1250	136H-0304	◆
	80.00	3.1496	136H-80	○
	80.17	3.1563	136H-0305	◆
	80.96	3.1875	136H-0306	◆
	81.76	3.2188	136H-0307	◆
	82.00	3.2283	136H-82	○
	82.55	3.2500	136H-0308	◆
	83.34	3.2813	136H-0309	◆
	84.00	3.3071	136H-84	○
	84.14	3.3125	136H-0310	◆
	84.93	3.3438	136H-0311	◆
	85.73	3.3750	136H-0312	◆
	86.00	3.3858	136H-86	○
	86.52	3.4063	136H-0313	◆
	87.31	3.4375	136H-0314	◆
	88.00	3.4646	136H-88	○
	88.11	3.4688	136H-0315	◆
	88.90	3.5000	136H-0316	◆

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN

(see page 10 for details)



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS CPM-M4	76.99	3.0313	436T-0301	○
	77.79	3.0625	436T-0302	○
	78.00	3.0709	436T-78	●
	78.58	3.0938	436T-0303	○
	79.38	3.1250	436T-0304	○
	80.00	3.1496	436T-80	●
	80.17	3.1563	436T-0305	○
	80.96	3.1875	436T-0306	○
	81.76	3.2188	436T-0307	○
	82.00	3.2283	436T-82	●
	82.55	3.2500	436T-0308	○
	83.34	3.2813	436T-0309	○
	84.00	3.3071	436T-84	●
	84.14	3.3125	436T-0310	○
	84.93	3.3438	436T-0311	○
	85.73	3.3750	436T-0312	○
	86.00	3.3858	436T-86	●
	86.52	3.4063	436T-0313	○
	87.31	3.4375	436T-0314	○
	88.00	3.4646	436T-88	●
	88.11	3.4688	436T-0315	○
	88.90	3.5000	436T-0316	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN

(see page 10 for details)

6 Series Inserts

Diameter Range 76.23 to 89.08mm



GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	76.99	3.0313	456H-0301	○
	77.79	3.0625	456H-0302	○
	78.00	3.0709	456H-78	●
	78.58	3.0938	456H-0303	○
	79.38	3.1250	456H-0304	○
	80.00	3.1496	456H-80	●
	80.17	3.1563	456H-0305	○
	80.96	3.1875	456H-0306	○
	81.76	3.2188	456H-0307	○
	82.00	3.2283	456H-82	●
	82.55	3.2500	456H-0308	○
	83.34	3.2813	456H-0309	○
	84.00	3.3071	456H-84	●
	84.14	3.3125	456H-0310	○
	84.93	3.3438	456H-0311	○
	85.73	3.3750	456H-0312	○
	86.00	3.3858	456H-86	●
	86.52	3.4063	456H-0313	○
	87.31	3.4375	456H-0314	○
	88.00	3.4646	456H-88	●
	88.11	3.4688	456H-0315	○
	88.90	3.5000	456H-0316	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.

T-A & GEN2 T-A

GENSSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPart 432

Criterion

Thread Milling

Special Tooling



7 Series Inserts

Diameter Range 87.76 to 101.60mm



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS CPM-M4	89.96	3.5313	137H-0317	◆
	90.00	3.5433	137H-90	○
	90.49	3.5625	137H-0318	◆
	91.28	3.5938	137H-0319	◆
	92.00	3.6221	137H-92	○
	92.08	3.6250	137H-0320	◆
	92.87	3.6263	137H-0321	◆
	93.66	3.6875	137H-0322	◆
	94.00	3.7008	137H-94	○
	94.46	3.7188	137H-0323	◆
	95.25	3.7500	137H-0324	◆
	96.00	3.7795	137H-96	○
	96.04	3.7813	137H-0325	◆
	96.84	3.8125	137H-0326	◆
	97.63	3.8438	137H-0327	◆
	98.00	3.8583	137H-98	○
	98.43	3.8750	137H-0328	◆
	99.22	3.9063	137H-0329	◆
	100.00	3.9370	137H-100	○
	100.01	3.9375	137H-0330	◆
	100.81	3.9688	137H-0331	◆
	101.60	4.0000	137H-0400	◆

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS CPM-M4	89.96	3.5313	437T-0317	○
	90.00	3.5433	437T-90	●
	90.49	3.5625	437T-0318	○
	91.28	3.5938	437T-0319	○
	92.00	3.6221	437T-92	●
	92.08	3.6250	437T-0320	○
	92.87	3.6263	437T-0321	○
	93.66	3.6875	437T-0322	○
	94.00	3.7008	437T-94	●
	94.46	3.7188	437T-0323	○
	95.25	3.7500	437T-0324	○
	96.00	3.7795	437T-96	●
	96.04	3.7813	437T-0325	○
	96.84	3.8125	437T-0326	○
	97.63	3.8438	437T-0327	○
	98.00	3.8583	437T-98	●
	98.43	3.8750	437T-0328	○
	99.22	3.9063	437T-0329	○
	100.00	3.9370	437T-100	●
	100.01	3.9375	437T-0330	○
	100.81	3.9688	437T-0331	○
	101.60	4.0000	437T-0400	○

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

T - TiN
N - TiCN
A - TiAlN

(see page 10 for details)

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®
N - TiCN
A - TiAlN

(see page 10 for details)

7 and 8 Series Inserts



Diameter Range 87.76 to 101.60mm (7 Series) and 101.63 to 160.00mm (8 Series)

GEN2 T-A

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	89.96	3.5313	457H-0317	○
	90.00	3.5433	457H-90	●
	90.49	3.5625	457H-0318	○
	91.28	3.5938	457H-0319	○
	92.00	3.6221	457H-92	●
	92.08	3.6250	457H-0320	○
	92.87	3.6263	457H-0321	○
	93.66	3.6875	457H-0322	○
	94.00	3.7008	457H-94	●
	94.46	3.7188	457H-0323	○
	95.25	3.7500	457H-0324	○
	96.00	3.7795	457H-96	●
	96.04	3.7813	457H-0325	○
	96.84	3.8125	457H-0326	○
	97.63	3.8438	457H-0327	○
	98.00	3.8583	457H-98	●
	98.43	3.8750	457H-0328	○
	99.22	3.9063	457H-0329	○
	100.00	3.9370	457H-100	●
	100.01	3.9375	457H-0330	○
	100.81	3.9688	457H-0331	○
	101.60	4.0000	457H-0400	○

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS CPM-M4	102.00	4.0157	138H-102	○
	103.19	4.0625	138H-0402	◆
	104.00	4.0945	138H-104	○
	104.75	4.1250	138H-0404	◆
	106.00	4.1732	138H-106	○
	106.36	4.1875	138H-0406	◆
	107.95	4.2500	138H-0408	◆
	108.00	4.2520	138H-108	○
	109.54	4.3125	138H-0410	◆
	110.00	4.3307	138H-110	○
	111.13	4.3750	138H-0412	◆
	112.00	4.4094	138H-112	○
	112.71	4.4375	138H-0414	◆
	114.00	4.4882	138H-114	○
	114.30	4.5000	138H-0416	◆

Supplied in packs of 1

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

- T - TiN
- N - TiCN
- A - TiAlN

(see page 10 for details)

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

- T - TiN
- N - TiCN
- A - TiAlN

(see page 10 for details)

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365

For further information on Material, Hardnesses and Cutting Data, please refer to the Technical Section from page 90.

Stk. - Stock Availability.

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended.
- ◆ Non-stock standard. Normal delivery 15 to 20 days.

Any non-standard size available.



8 Series Inserts

Diameter Range 101.63 to 160.00mm



Double Wide (Oversized)

Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
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	○

120mm maximum diameter for Stainless Steels

Additional diameters up to 200mm available on request

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	TiN	Stk.
HSS CPM-M4	102.00	4.0157	438T-102	●
	103.19	4.0625	438T-0402	○
	104.00	4.0945	438T-104	●
	104.75	4.1250	438T-0404	○
	106.00	4.1732	438T-106	●
	106.36	4.1875	438T-0406	○
	107.95	4.2500	438T-0408	○
	108.00	4.2520	438T-108	●
	109.54	4.3125	438T-0410	○
	110.00	4.3307	438T-110	●
	111.13	4.3750	438T-0412	○
	112.00	4.4094	438T-112	●
	112.71	4.4375	438T-0414	○
	114.00	4.4882	438T-114	●
	114.30	4.5000	438T-0416	○

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

H - AM200®

N - TiCN

A - TiAlN

(see page 10 for details)

Supplied in packs of 1



Grade	Diameter		Part Number, Coating and Availability	
	Ø mm	Ø Inch	AM200®	Stk.
HSS Super Cobalt	102.00	4.0157	458H-102	●
	103.19	4.0625	458H-0402	○
	104.00	4.0945	458H-104	●
	104.75	4.1250	458H-0404	○
	106.00	4.1732	458H-106	●
	106.36	4.1875	458H-0406	○
	107.95	4.2500	458H-0408	○
	108.00	4.2520	458H-108	●
	109.54	4.3125	458H-0410	○
	110.00	4.3307	458H-110	●
	111.13	4.3750	458H-0412	○
	112.00	4.4094	458H-112	●
	112.71	4.4375	458H-0414	○
	114.00	4.4882	458H-114	●
	114.30	4.5000	458H-0416	○

Geometries available as non-stock standard

- BR - NC
- CR - SK
- HI - WC
- HR

(see page 11 for details)

Coatings available as non-stock standard

T - TiN

N - TiCN

A - TiAlN

(see page 10 for details)

Supplied in packs of 1

Deep Hole Drilling Guidelines

For use with AMEC® Drills greater than 9xD (Depths to Diameter)
including Extended, Long and Special Length



GEN2 T-A

T-A & GEN2 T-A

GENSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

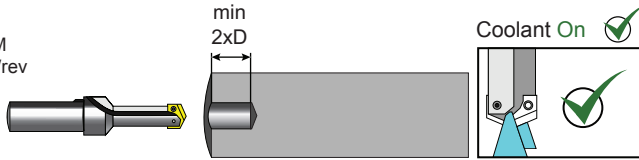
AccuPart 432

Criterion

Thread Milling

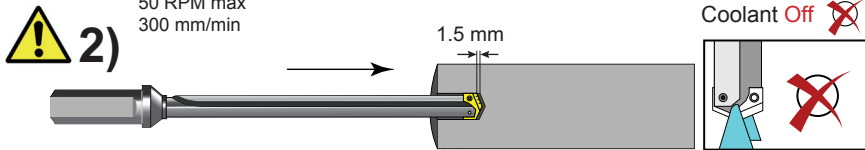
Special Tooling

1) Pilot Drill
100% RPM
100% mm/rev



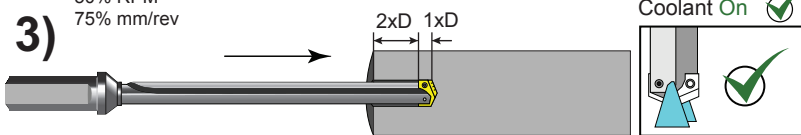
- Establish the pilot hole using the same diameter short drill to a depth of a 2xD minimum
- Utilize a pilot drill with the same or larger included point angle

2) Feed In
50 RPM max
300 mm/min



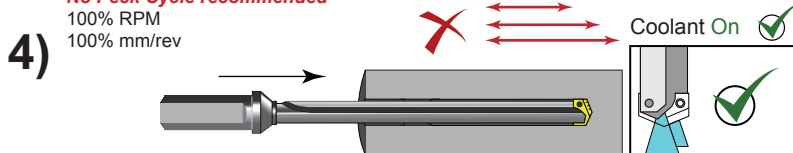
- Feed the longer drill within 1.5mm short of the established pilot hole bottom at a **maximum of 50 RPM** and 300 mm/min feed rate

3) Deep Hole Transition Drilling
50% RPM
75% mm/rev



- Drill additional 1xD past bottom of pilot hole at 50% reduction of recommended speed and 25% reduction of recommended feed
- Minimum of 1 second dwell is required to meet full speed before feeding

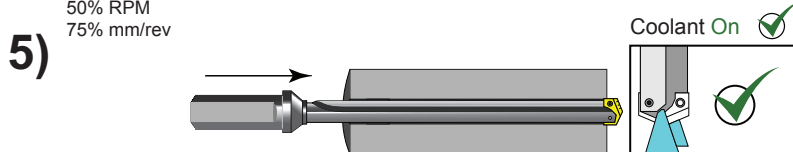
4) Deep Hole Drilling – Blind
No Peck Cycle recommended
100% RPM
100% mm/rev



- Drill to full depth at recommended speed and feed for longer drills according to Allied speed and feed charts

No peck cycle recommended

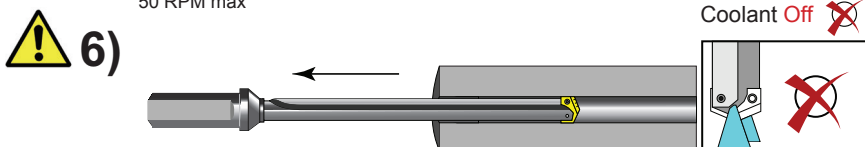
5) Deep Hole Drilling – At Breakout
50% RPM
75% mm/rev



For Through Holes Only

- Reduce speed by 50% and feed by 25% prior to break out
- Do not break out more than 3mm past the full diameter of drill

6) Drill Retract
50 RPM max



Reduce speed to a **maximum of 50 RPM** before retracting from hole

WARNING

Tool failure can cause serious injury. To prevent:

- When using this holder without support bushing, use a short holder to establish an initial hole that is 2-3 diameters deep.
- Do not rotate tool more than 50 RPM unless it is engaged with workpiece or fixture.
- Follow the Deep Hole Guidelines above and in AMEC® Catalogue for best practices in Deep Hole Drilling.
- Visit www.alliedmaxcut.com for most up-to-date information and procedures.
- For further information please contact our technical office at +44 (0) 1384 400 900 or Email: engineering@alliedmaxcut.com



Holder Accessories

T-A & BENZ T-A

GENSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPort 432

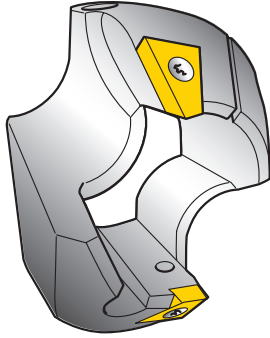
Criterion

Thread Milling

Special Tooling

T-A® Accessories

T-ACR45™ Chamfer Ring

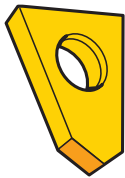


NOTE:
IC inserts
sold separately

Item Number	Fits Series	Minimum Drill Ø	Maximum Drill Ø	Maximum Chamfer Ø	A Chamfer Ring Ø	B Chamfer Ring Length	Stk.
T-ACR-45-0	0	13.00	17.50	20.68	30.48	17.17	•
T-ACR-45-1	1	17.53	21.69	26.59	34.93	20.24	•
T-ACR45-1.5	1.5	21.70	24.38	28.58	39.69	22.62	•
T-ACR45-2	2	24.41	35.05	39.83	45.64	25.40	•

T-ACR 45™ Chamfer Rings are designed for use with stub, short, intermediate and standard straight fluted T-A® Drilling System holders only in Series 0 to 2

Chamfer Ring Insert & Accessories



Item Number	Insert Screw	Torx Plus Driver
T-ACRI-45-B-C5A	72556-IP8-10	8IP-8

NOTE: Inserts sold in packs of two

Item Number	Insert Screw	Torx Plus Driver
0	7375-IP9-10	8IP-9
1 & 1.5	7495-IP15-10	8IP-15
2	7514-IP20-10	8IP-20

NOTE: Inserts sold in packs of two



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+44 (0)1384 400 105



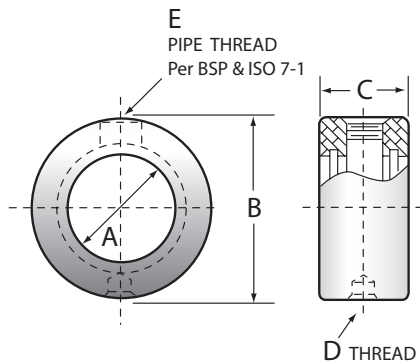
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T-A® Accessories

Rotary Coolant Adapters (RCA)

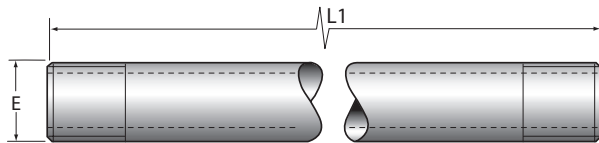


Item Number	(A) I.D.	(B) O.D.	(C) Width	(D) Thread Driving Rod	(E) Pipe Tap
2T-2SRM	19.05	44.45	22.23	M8	1/8"
2T-3SRM	25.40	53.97	28.57	M8	1/8"
2T-4SRM	31.75	63.50	34.92	M10	1/4"
2T-5SRM	44.45	76.20	34.92	M10	1/4"
2T-6SRM	57.15	95.27	44.45	M12	1/2"

Items included: (1) Inducer Ring, (2) O-Rings, (2) Snap Rings and (2) Thrust Washers.
For RCA repair kit see page 86.

Note: Always use a steady bar when using a RCA adaptor

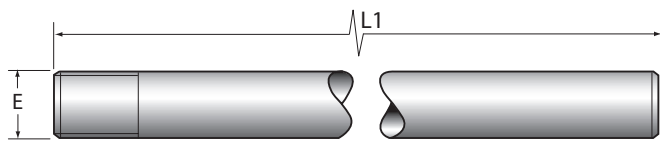
Coolant Pipe Extension/Steady Bar



Item Number	Nominal Pipe Thread E	L1 mm
302T-2SRM	1/8"	150
302T-3SRM	1/8"	150
302T-4SRM	1/4"	200
302T-5SRM	1/4"	200
302T-6SRM	1/2"	200

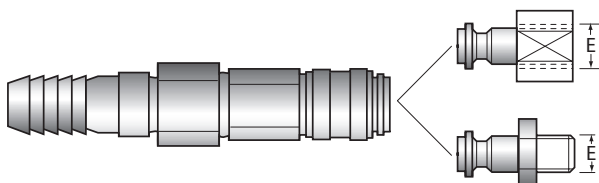
Note: Always use a steady bar when using a RCA adaptor

Solid Steady Bar



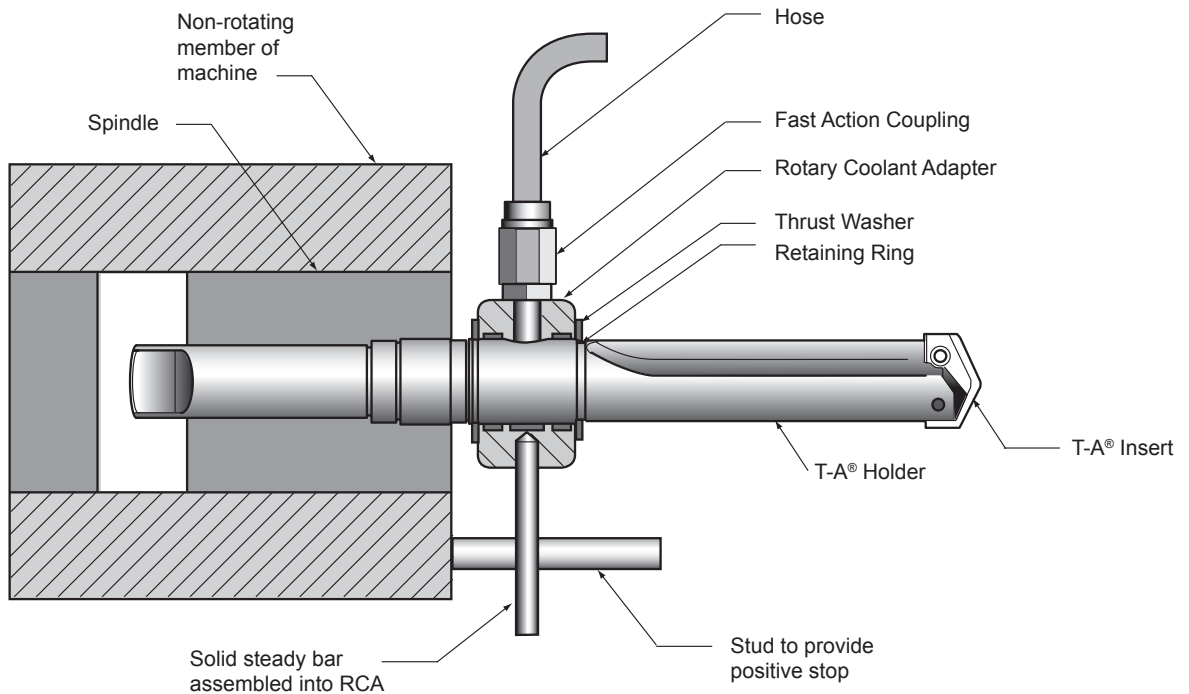
Item Number	Thread Size E	L1 mm
312T-2SRM	M8	250
312T-3SRM	M8	250
312T-4SRM	M10	250
312T-5SRM	M10	250
312T-6SRM	M12	250

Fast Action Coupling

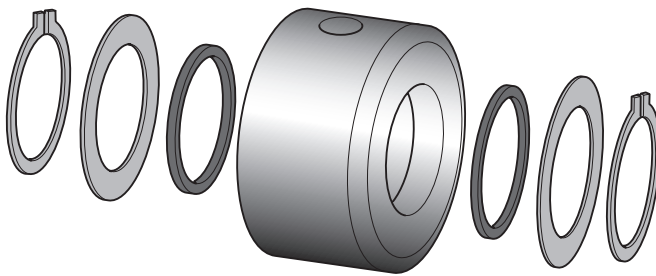


Item Number	Nominal Pipe Thread E	Hose Ø
322T-2SRM	1/8"	9mm
322T-3SRM	1/8"	9mm
322T-4SRM	1/4"	9mm
322T-5SRM	1/4"	12mm
322T-6SRM	1/2"	12mm

RCA Assembly



RCA Assembly & Repair Kit

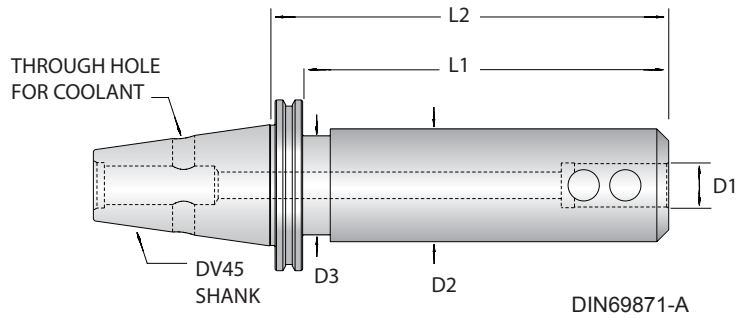


		Catalogue Number
Item Number	Drill Range	RCA Repair Kit
2T-2SRM	9.50 - 11.07mm	2T1-2SR
2T-2SRM	11.10 - 12.95mm	2T1-2SR
2T-2SRM	12.98 - 17.65mm	2T1-2SR
2T-3SRM	17.53 - 24.38mm	2T1-3SR
2T-3SRM	24.41 - 35.05mm	2T1-3SR
2T-4SRM	30.00 - 35.05mm	2T1-4SR
2T-4SRM	34.37 - 47.80mm	2T1-4SR
2T-5SRM	46.99 - 65.28mm	2T1-5SR
2T-6SRM	62.38 - 89.08mm	2T1-6SR
2T-6SRM	87.76 - 160.00mm	2T1-6SR

RCA Repair Kit includes: (2) O-Rings, (2) Snap Rings and (2) Thrust Washers

T-A® Adaptor

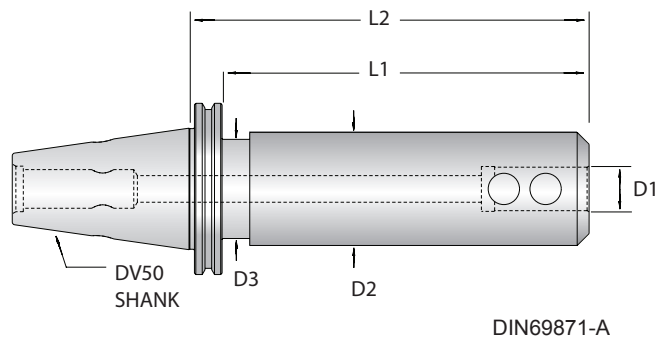
DV45 Adaptor



Includes Lateral Side Coolant Hole

Item Number	Outer Taper	D1 Inner Ø mm	D2 Ø	D3 Ø	L1	L2	Qty of Clamping Screws	Stk.
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



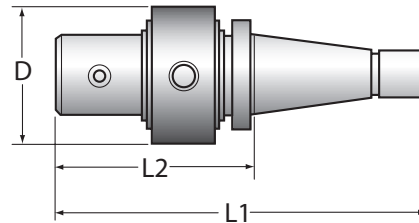
Excludes Lateral Side Coolant Hole

Item Number	Outer Taper	D1 Inner Ø mm	D2 Ø	D3 Ø	L1	L2	Qty of Clamping Screws	Stk.
AMDV50-EM50-120	DV50	50	100	69.85	100	120	2	●



T-A® Adaptors

DIN 2080 ISO Taper Shank Coolant Fed Holders



Item Number	Outer Taper	D Inner Ø mm	L1 mm	L2 mm	D Ø mm
4020-5SRM	QC40	20	188.00	94.00	76.20
4025-5SRM	QC40	25	199.00	106.00	76.20
5020-5SRM	DT50	20	227.00	100.00	76.20
5025-5SRM	DT50	25	239.00	112.00	76.20
5032-6SRM	ST50	32	254.00	127.00	95.27

Max coolant Pressure: 40 Bar. Max RPM: 3000. Suitable for Holders: Y, Z, 0, 0.5, 1, 1.5, 2.0, 2.5 series

Note: DIN 69871-A and BT50 tapers available upon request

T-A® Replacement TORX Plus Screws and Driver information

Holder Series	Drill Range	Catalogue Number			Maximum Torque (N/cm)
		TORX Plus® Hand Drivers	TORX Plus® Screws*	Nylon Locking TORX Screws*	
Y	9.5mm - 11.07mm	8IP-7	724-IP7-10	724N-IP7-10	84
Z	11.1mm - 12.95mm	8IP-7	7247-IP7-10	7247N-IP7-10	84
0	12.98mm - 17.65mm	8IP-8	72556-IP8-10	72556N-IP8-10	175
0.5	15.5mm - 17.65mm	8IP-8	72567-IP8-10	72567N-IP8-10	175
1	17.53mm - 24.38mm	8IP-9	7375-IP9-10	7375N-IP9-10	305
1.5	22.0mm - 24.38mm	8IP-9	739-IP9-10	739N-IP9-10	305
2, 2.5	24.41mm - 35.05mm	8IP-15	7495-IP15-10	7495N-IP15-10	690
3, 4	34.37mm - 65.28mm	8IP-20	7514-IP20-10	7514N-IP20-10	1370
5-8	62.38mm - 160.00mm	8IP-25	7619-IP25-10	N/A	1750

*Supplied in 10 piece packages.

T-A[®] Insert System Guidelines for Use

- Select the shortest holder possible for the application
- Use our catalogue from page 90 'Recommended Cutting Data' for guidance in selecting correct insert grade, speed and feed information.
These cutting parameters are starting conditions only and make no allowance for machine or component rigidity. For more detailed application guidelines, use our 'Electronic Product Selector' (available online at www.alliedmaxcut.com) to obtain:
 - Recommended grade of insert.
 - Recommended cutting speed.
 - Recommended cutting feed.
 - Minimum coolant requirements.
 - Machine power / thrust requirements
- Ensure the T-A[®] holder is held securely and is within 0.02/0.07mm of centreline
- The T-A[®] insert should be installed in the slot of the holder using the Torx Screws provided which should be tightened to the values listed on page 88 'Holder Accessories'.

The holder slot should be clean and free from dirt or debris.

- Check the insert outer diameter is a minimum 0.3mm larger than the holder body diameter.
- When setting up new applications, check coolant flows adequately through the tool before commencing machining.

It is best practice to:

- Drill a short hole 1 x diameter deep initially.
- The chips produced should be short in length, self coloured, not straw or blue.
- Measure the hole produced to check that it is to the desired tolerance.
- If all is correct, continue to machine the remainder of the hole.
- Ensure the drilling process is quiet and smooth with no chip packing.
- If chip packing is occurring, stop the drill and refer to the 'Problems and Solutions' guide on catalogue page 104.

Extended length holders



It is best practice to:

- Establish a pilot hole using the same diameter T-A[®] Drill Insert in a short holder to a depth of 2 - 3 diameters deep.
- Enter the pilot hole with the XL or 3XL Holder and Drill Insert with the spindle stationery or at low RPM (10 - 20).
- Increase speed and feed to recommended data in table, ensuring chips are short and are being evacuated by coolant throughout the length of the hole. If chip control is not obtained, please contact AMEC for assistance.
- At the end of the drilling cycle do not remove the holder from the hole whilst at full RPM, stop spindle or reduce to low RPM (10 - 20).

Note: Carbide inserts should not be used in Extended or longer length holders without consulting Allied Maxcut.

XL and 3XL Holders

For cutting data and coolant recommendations please refer to 'Recommended Cutting Data' - HSS inserts - Pages 90 - 92 and 'Coolant Recommendations' - Page 98 then follow the instructions at the foot of the pages for the relevant multiplying factors.

Note: Never start or continue rotation of an XL or 3XL tool holder without proper engagement within a work piece or fixture. Failure to do so could result in tool failure and/or bodily injury.

Geometries

Spot and Chamfer Inserts – SP

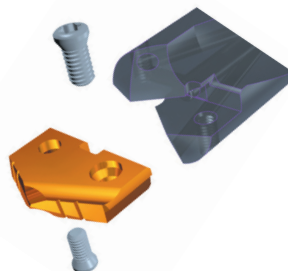
Use cutting data as per standard T-A[®] HSS Drill Inserts, in stub or short length holders. Speed should be calculated for the required spot or chamfer diameter.

Flat Bottom Insert – FB

For cutting data refer to catalogue page 93 and 96 'Recommended Cutting Data - Flat Bottom Drill Inserts'. Please contact Allied Maxcut's Engineering department for advice when attempting to drill from solid.

Tool Assembly

1. Place the T-A[®] Drill Insert into the precision ground locating pocket on the T-A[®] Holder. The holder pocket and locating pad on the drill insert assure optimum fit and repeatability.
2. Place a generous amount of Never Seize (provided in the packaging) onto the supplied TORX Plus Screws.
3. Tighten the TORX Plus Screws utilising the predetermined TORX Plus Drivers and TORX Plus Screw admissible tightening Torque outlined in the catalogue per T-A[®] Series.





Technical Section

GEN2 T-A Recommended Cutting Data – HSS Drill Inserts Y-2 Series

Material	Hardness			Speed AM200® M/min	Feed mm/rev			
	BHN	kg	N/mm²		9.5-12.95	12.98-17.53	17.53-24.38	24.41-35
Free Machining Steel	100-150	38-50	370-500	99	0.20	0.30	0.41	0.48
	150-200	50-70	500-700	91	0.18	0.28	0.38	0.43
	200-250	70-88	700-870	85	0.15	0.25	0.36	0.41
Low Carbon Steel	85-125	30-46	300-450	88	0.20	0.25	0.36	0.46
	125-175	46-62	450-600	83	0.18	0.25	0.36	0.43
	175-225	62-77	600-775	79	0.15	0.23	0.33	0.41
	225-275	77-96	775-940	73	0.13	0.23	0.33	0.41
Medium Carbon Steel	125-175	46-62	450-600	83	0.18	0.25	0.36	0.43
	175-225	62-77	600-775	79	0.15	0.23	0.33	0.41
	225-275	77-96	775-940	73	0.15	0.23	0.33	0.41
	275-325	96-111	940-1090	68	0.13	0.20	0.30	0.38
Alloy Steel	125-175	46-62	450-600	73	0.18	0.25	0.36	0.41
	175-225	62-77	600-775	68	0.15	0.23	0.33	0.41
	225-275	77-96	775-940	64	0.15	0.23	0.33	0.43
	275-325	96-111	940-1090	59	0.13	0.20	0.30	0.38
	325-375	111-129	1090-1265	54	0.10	0.18	0.28	0.36
High Strength Steel	225-300	77-104	600-1020	38	0.15	0.23	0.28	0.33
	300-350	104-121	1020-1180	30	0.13	0.20	0.25	0.30
	350-400	121-139	1180-1365	24	0.10	0.18	0.23	0.28
Structural Steel	100-150	38-50	370-500	71	0.20	0.28	0.38	0.43
	150-250	50-88	500-850	57	0.15	0.25	0.33	0.38
	250-350	88-121	850-1180	48	0.13	0.23	0.30	0.33
Tool Steel	150-200	50-70	500-700	38	0.10	0.18	0.25	0.30
	200-250	70-88	700-870	32	0.10	0.18	0.25	0.30
High Temp Alloy	140-220	49-77	480-755	13	0.10	0.18	0.23	0.28
	223-310	77-101	755-990	12	0.10	0.15	0.20	0.25
Titanium Alloy	140-220	49-77	480-755	16	0.10	0.18	0.21	0.27
	220-310	77-101	755-990	15	0.08	0.15	0.18	0.23
Aerospace Alloy S82	185-275	65-96	640-940	35	0.15	0.20	0.23	0.28
	275-350	96-121	940-1180	31	0.13	0.18	0.20	0.25
Stainless Steel 400 Series 416, 420, (303)	185-275	65-96	640-940	35	0.15	0.20	0.23	0.28
	275-350	96-121	940-1180	31	0.13	0.18	0.20	0.25
Stainless Steel 300 Series 304, 316, 17-4PH	135-185	49-65	480-640	35	0.08	0.18	0.20	0.28
	185-275	65-96	640-940	31	0.08	0.15	0.18	0.25
Super Duplex Duplex St/Stl	135-185	49-65	480-640	26	0.08	0.18	0.20	0.28
	185-275	65-96	640-940	22	0.08	0.15	0.18	0.25
Hardox	400	139	1365	21	0.08	0.15	0.20	0.23
	500	160	1600	14	0.05	0.12	0.18	0.20
	600	210	2000	N/A	N/A	N/A	N/A	N/A
Hardened Steel	300-400	104-139	1020-1365	29	0.10	0.15	0.23	0.27
	400-500	139+	1365+	14	0.06	0.12	0.18	0.24
SG/Nodular/ Grey/White Cast Iron	120-150	44-50	430-500	84	0.20	0.30	0.41	0.51
	150-200	50-70	500-700	79	0.18	0.28	0.38	0.48
	200-220	70-77	700-755	68	0.15	0.23	0.33	0.43
	220-260	77-90	755-890	57	0.13	0.20	0.28	0.36
Cast Aluminium	30	10	100	(TiCN) 229	0.23	0.38	0.46	0.58
	180	62	600	(TiCN) 122	0.20	0.33	0.40	0.50
Wrought Aluminium	30	10	100	280	0.12	0.33	0.40	0.50
	180	62	600	200	0.12	0.18	0.30	0.35
Aluminium Bronze	100-200	38-68	370-670	82	0.15	0.24	0.30	0.38
	200-250	68-87	670-855	65	0.12	0.18	0.23	0.28
Brass	100	38	370	144	0.18	0.27	0.33	0.45
Copper	60	21	200	58	0.07	0.10	0.18	0.26

Speed & Feed Multiplier for XL & 3XL tool length

When using the XL and 3XL holders, drilling parameters must be reduced (see table on opposite page).

Example – Using XL holder

Material - Free machining steel (200BHN)

Diameter & Hole Depth – 17.5mm x 280mm

Insert – Original T-A 150N-17.5 TiCN coated

Holder – 27000S-20FM

Calculation

Speed M/min = 85

X 0.80 (taken from speed & Feed Multiplier)
= 68

Feed (mm/rev) = 0.25

X 0.90 (taken from speed & Feed Multiplier)
= 0.23



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GEN2 T-A Recommended Cutting Data – HSS Drill Inserts 3-8 Series

Material	Hardness			Tool Steel Grade	Speed M/min		Feed (mm/rev)		
	BHN	kg	N/mm ²		TiN	AM200®	35 - 47.8	47.85 - 65	66 - 114.48
Free Machining Steel	100-150	38-50	370-500	HSS/SC	61	99	0.51	0.58	0.71
	150-200	50-70	500-700	HSS/SC	55	91	0.51	0.58	0.71
	200-250	70-88	700-870	HSS/SC	49	85	0.51	0.58	0.71
Low Carbon Steel	85-125	30-46	300-450	HSS/SC	52	88	0.48	0.58	0.69
	125-175	46-62	450-600	HSS/SC	49	83	0.48	0.58	0.69
	175-225	62-77	600-775	HSS/SC	46	79	0.46	0.53	0.61
	225-275	77-96	775-940	HSS/SC	43	73	0.46	0.53	0.61
Medium Carbon Steel	125-175	46-62	450-600	HSS/SC	49	83	0.48	0.58	0.69
	175-225	62-77	600-775	HSS/SC	46	79	0.46	0.53	0.61
	225-275	77-96	775-940	HSS/SC	43	73	0.46	0.53	0.61
	275-325	96-111	940-1090	SC, PC	40	68	0.41	0.48	0.56
Alloy Steel	125-175	46-62	450-600	HSS/SC	46	73	0.43	0.48	0.56
	175-225	62-77	600-775	HSS/SC	43	68	0.43	0.48	0.56
	225-275	77-96	775-940	HSS/SC	40	64	0.43	0.48	0.56
	275-325	96-111	940-1090	SC, PC	37	59	0.38	0.43	0.51
	325-375	111-129	1090-1265	SC, PC	34	54	0.38	0.43	0.51
High Strength Steel	225-300	77-104	600-1020	SC, PC	24	38	0.36	0.43	0.51
	300-350	104-121	1020-1180	SC, PC	18	30	0.36	0.43	0.51
	350-400	121-139	1180-1365	PC	15	24	0.30	0.41	0.46
Structural Steel	100-150	38-50	370-500	HSS/SC	43	71	0.46	0.53	0.66
	150-250	50-88	500-850	HSS/SC	37	57	0.41	0.48	0.61
	250-350	88-121	850-1180	SC, PC	30	49	0.36	0.43	0.51
Tool Steel	150-200	50-70	500-700	SC	24	38	0.30	0.38	0.43
	200-250	70-88	700-870	SC, PC	18	32	0.30	0.38	0.43
High Temp Alloy	140-220	49-77	480-755	SC, PC	9	13	0.30	0.38	0.38
	223-310	77-101	755-990	PC	8	12	0.25	0.30	0.30
Titanium Alloy	140-220	49-77	480-755	SC, PC	11	16	0.30	0.38	0.38
	220-310	77-101	755-990	PC	10	15	0.25	0.30	0.30
Aerospace Alloy S82	185-275	65-96	640-940	SC, PC	23	35	0.30	0.36	0.46
	275-350	96-121	940-1180	SC, PC	18	31	0.36	0.41	0.51
Stainless Steel 400 Series 416, 420, (303)	185-275	65-96	640-940	SC, PC	23	35	0.30	0.36	0.46
	275-350	96-121	940-1180	SC, PC	18	31	0.36	0.41	0.51
Stainless Steel 300 Series 304, 316, 17-4PH	135-185	49-65	480-640	SC, PC	23	35	0.30	0.36	0.46
	185-275	65-96	640-940	SC, PC	18	31	0.36	0.41	0.51
Super Duplex Duplex St/Stl	135-185	49-65	480-640	SC, PC	18	26	0.36	0.41	0.51
	185-275	65-96	640-940	SC, PC	15	22	0.30	0.36	0.46
Hardox	400	139	1365	SC, PC	14	21	0.30	0.41	0.46
	500	160	1600	PC	10	14	0.25	0.30	0.40
	600	210	2000	N/A	N/A	N/A	N/A	N/A	N/A
Hardened Steel	300-400	104-139	1020-1365	PC	15	29	0.30	0.41	0.46
	400-500	139+	1365+	PC	10	14	0.25	0.30	0.40
SG/Nodular/ Grey/White Cast Iron	120-150	44-50	430-500	HSS	52	84	0.61	0.69	0.76
	150-200	50-70	500-700	HSS	46	79	0.56	0.64	0.71
	200-220	70-77	700-755	HSS	40	68	0.46	0.53	0.61
	220-260	77-90	755-890	SC, PC	34	57	0.36	0.43	0.51
	260-320	90-104	890-1020	SC, PC	27	47	0.28	0.36	0.41
Cast Aluminium	30	10	100	HSS	183	TiCN 229	0.56	0.64	0.64
	180	62	600	HSS	91	TiCN 129	0.56	0.64	0.64
Wrought Aluminium	30	10	100	HSS	183	200	0.56	0.64	0.64
	180	62	600	HSS	91	150	0.56	0.64	0.64
Aluminium Bronze	100-200	38-68	370-670	SC	52	82	0.43	0.48	0.53
	200-250	68-87	670-855	SC	40	65	0.36	0.40	0.46
Brass	100	38	370	HSS	91	144	0.47	0.53	0.58
Copper	60	21	200	SC	40	58	0.23	0.27	0.31

Formulas: $\text{mm/min} = \text{rev/min} \cdot \text{mm/rev}$ $\text{M/min} = \text{rev/min} \cdot 0.003 \cdot \text{DIA}$ $\text{rev/min} = \text{M/min} \cdot 318.47/\text{DIA}$

SPEED AND FEED MULTIPLIER For various tool lengths

WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

	Holder Length							
	Stub	Short	Intermediate	Standard	Extended ⚠	Long ⚠	XL ⚠	3XL ⚠
SPEED	see above chart				0.90	0.85	0.80	0.75
FEED	see above chart					0.95	0.90	0.90



Technical Section



Recommended Cutting Data – HSS Drill Inserts Y-8 Series

Material	Hardness			Tool Steel Grade *	Speed M/min			Feed (mm/rev)								DW Cutting Data (110-160)	
	BHN	kg	N/mm²		TiN	TiCN	TiAlN	9.5-12.95	12.98-17.53	17.53-24.38	24.41-35	35-47.8	47.85-65	66-114.48	Speed M/min	Feed (mm/rev)	
Free Machining Steel	100-150	38-50	370-500	HSS	61	80	86	0.18	0.25	0.33	0.41	0.51	0.58	0.71	58-76	0.35	
	150-200	50-70	500-700	HSS	55	72	80	0.18	0.25	0.33	0.41	0.51	0.58	0.71			
	200-250	70-88	700-870	HSS	49	64	73	0.15	0.25	0.33	0.41	0.51	0.58	0.71			
Low Carbon Steel	85-125	30-46	300-450	HSS	52	67	76	0.15	0.23	0.30	0.38	0.48	0.58	0.69	48-66	0.3	
	125-175	46-62	450-600	HSS	49	64	73	0.15	0.23	0.30	0.38	0.48	0.58	0.69			
	175-225	62-77	600-775	HSS	46	60	69	0.13	0.20	0.25	0.36	0.46	0.53	0.61			
	225-275	77-96	775-940	HSS	43	55	64	0.13	0.20	0.25	0.36	0.46	0.53	0.61			
Medium Carbon Steel	125-175	46-62	450-600	HSS	49	64	73	0.15	0.23	0.30	0.38	0.48	0.58	0.69	48-66	0.3	
	175-225	62-77	600-775	HSS	46	60	69	0.13	0.20	0.25	0.36	0.46	0.53	0.61			
	225-275	77-96	775-940	HSS	43	55	64	0.13	0.20	0.25	0.36	0.46	0.53	0.61			
Alloy Steel	275-325	96-111	940-1090	SC, PC	40	52	60	0.10	0.18	0.23	0.30	0.41	0.48	0.56	30-36	0.28	
	125-175	46-62	450-600	HSS	46	60	64	0.15	0.20	0.25	0.36	0.43	0.48	0.56			
	175-225	62-77	600-775	HSS	43	55	60	0.13	0.20	0.25	0.36	0.43	0.48	0.56			
	225-275	77-96	775-940	HSS	40	52	55	0.13	0.18	0.25	0.36	0.43	0.48	0.56			
	275-325	96-111	940-1090	SC, PC	37	47	52	0.10	0.15	0.23	0.30	0.38	0.43	0.51			
High Strength Steel	325-375	111-129	1090-1265	SC, PC	34	44	47	0.08	0.15	0.23	0.30	0.38	0.43	0.51	22-26	0.25	
	225-300	77-104	600-1020	SC, PC	24	31	34	0.13	0.18	0.23	0.25	0.36	0.43	0.51	16-20	0.25	
Structural Steel	300-350	104-121	1020-1180	SC, PC	18	24	26	0.10	0.18	0.23	0.25	0.36	0.43	0.51			
	350-400	121-139	1180-1365	PC	15	20	21	0.08	0.15	0.20	0.23	0.30	0.41	0.46	42-54	0.3	
	100-150	38-50	370-500	HSS	43	55	61	0.15	0.25	0.30	0.36	0.46	0.53	0.66			
150-250	50-88	500-850	HSS	37	47	52	0.13	0.23	0.25	0.30	0.41	0.48	0.61				
Tool Steel	250-350	88-121	850-1180	SC, PC	30	40	43	0.10	0.20	0.23	0.25	0.36	0.43	0.51	31-38	0.23	
	150-200	50-70	500-700	SC	24	32	34	0.10	0.15	0.20	0.25	0.30	0.38	0.43			
High Temp Alloy	200-250	70-88	700-870	SC, PC	18	26	28	0.10	0.15	0.20	0.25	0.30	0.38	0.43	N/A	N/A	
	140-220	49-77	480-755	SC, PC	9	11	12	0.08	0.18	0.20	0.25	0.30	0.38	0.38			
Titanium Alloy	223-310	77-101	755-990	PC	8	9	11	0.08	0.15	0.18	0.20	0.25	0.30	0.30	N/A	N/A	
	140-220	49-77	480-755	SC, PC	11	14	15	0.08	0.18	0.20	0.25	0.30	0.38	0.38			
Aerospace Alloy S82	220-310	77-101	755-990	PC	10	11	14	0.08	0.15	0.18	0.20	0.25	0.30	0.30	22-29*	0.23*	
	185-275	65-96	640-940	SC, PC	23	29	32	0.15	0.20	0.23	0.28	0.36	0.41	0.51			
Stainless Steel 400 Series 416, 420, (303)	275-350	96-121	940-1180	SC, PC	18	24	28	0.13	0.18	0.20	0.25	0.30	0.36	0.46	22-29*	0.23*	
	185-275	65-96	640-940	SC, PC	23	29	32	0.15	0.20	0.23	0.28	0.36	0.41	0.51			
Stainless Steel 300 Series 304, 316, 17-4PH	275-350	96-121	940-1180	SC, PC	18	24	28	0.13	0.18	0.20	0.25	0.30	0.36	0.46	22-29*	0.23*	
	135-185	49-65	480-640	SC, PC	23	29	32	0.08	0.18	0.20	0.28	0.36	0.41	0.51			
Super Duplex Duplex St/Stl	185-275	65-96	640-940	SC, PC	18	24	28	0.08	0.15	0.18	0.25	0.30	0.36	0.46	16-20*	0.23*	
	135-185	49-65	480-640	SC, PC	18	22	24	0.08	0.18	0.20	0.28	0.36	0.41	0.51			
Hardox	185-275	65-96	640-940	SC, PC	15	18	20	0.08	0.15	0.18	0.25	0.30	0.36	0.46	N/A	N/A	
	400	139	1365	SC, PC	14	17	21	0.08	0.15	0.20	0.23	0.30	0.41	0.46			
	500	160	1600	PC	10	12	14	0.05	0.12	0.18	0.20	0.25	0.30	0.40			
Hardened Steel	600	210	2000	N/A	N/A	N/A	N/	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	
	300-400	104-139	1020-1365	PC	15	21	29	0.08	0.15	0.20	0.23	0.30	0.41	0.46			
SG/Nodular/ Grey/White Cast Iron	400-500	139+	1365+	PC	10	12	14	0.05	0.12	0.18	0.20	0.25	0.30	0.40	53-62	0.3	
	120-150	44-50	430-500	HSS	52	67	76	0.18	0.30	0.41	0.51	0.61	0.69	0.76			
	150-200	50-70	500-700	HSS	46	60	69	0.15	0.28	0.36	0.46	0.56	0.64	0.71			
	200-220	70-77	700-755	HSS	40	52	60	0.15	0.23	0.30	0.41	0.46	0.53	0.61			
	220-260	77-90	755-890	SC, PC	34	44	50	0.13	0.18	0.23	0.30	0.36	0.43	0.51			
Cast Aluminium	260-320	90-104	890-1020	SC, PC	27	37	41	0.1	0.15	0.18	0.23	0.28	0.36	0.41	109-146	0.32	
	30	10	100	HSS	183	229	260	0.2	0.33	0.41	0.50	0.56	0.64	0.64			
Wrought Aluminium	180	62	600	HSS	91	122	138	0.2	0.33	0.41	0.46	0.56	0.64	0.64	109-146	0.32	
	30	10	100	HSS	183	229	260	0.1	0.15	0.25	0.30	0.56	0.64	0.64			
Aluminium Bronze	180	62	600	HSS	91	122	138	0.2	0.33	0.41	0.46	0.56	0.64	0.64	35-44	0.3	
	100-200	38-68	370-670	SC	52	67	76	0.15	0.28	0.36	0.46	0.56	0.66	0.71			
Brass	200-250	68-87	670-855	SC	40	52	59	0.13	0.18	0.23	0.30	0.36	0.43	0.51	79-99	0.38	
Copper	100	38	370	HSS	91	122	137	0.18	0.30	0.41	0.51	0.61	0.71	0.76	29-36	0.2	

*only applicable up to 120mm

Formulas:

$$\text{mm/min} = \text{rev/min} \cdot \text{mm/rev}$$

$$\text{M/min} = \text{rev/min} \cdot 0.003 \cdot \text{DIA}$$

$$\text{rev/min} = \text{M/min} \cdot 318.47/\text{DIA}$$

SPEED AND FEED MULTIPLIER For various tool lengths



For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

	Holder Length						
	Stub	Short	Intermediate	Standard	Extended ⚠	Long ⚠	XL ⚠
SPEED	see above chart				0.90	0.85	0.80
FEED	see above chart					0.95	0.90



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Recommended Cutting Data - HSS Flat Bottom Drill Inserts Y-4 Series

Material	Hardness			Speed M/min			Feed (mm/rev)					
	BHN	kg	N/mm ²	TiN	TiCN	TiAlN	9.5 – 12.95mm	12.98 – 17.53mm	17.53 – 24.38mm	24.41 – 35mm	34.37 – 47.80mm	47.85 – 65mm
Free Machining Steel	100-150	38-50	370-500	52	70	76	0.15	0.23	0.28	0.35	0.41	0.46
	150-200	50-70	500-700	47	62	70	0.15	0.23	0.28	0.35	0.41	0.46
	200-250	70-88	700-870	43	56	64	0.13	0.23	0.28	0.35	0.38	0.43
Low Carbon Steel	85-125	30-46	300-450	46	59	67	0.13	0.20	0.25	0.33	0.38	0.43
	125-175	46-62	450-600	43	56	64	0.13	0.20	0.25	0.33	0.38	0.41
	175-225	62-77	600-775	40	53	59	0.10	0.18	0.23	0.30	0.36	0.41
	225-275	77-96	775-940	37	47	56	0.10	0.18	0.23	0.30	0.36	0.38
Medium Carbon Steel	125-175	46-62	450-600	43	56	64	0.13	0.20	0.25	0.33	0.38	0.46
	175-225	62-77	600-775	40	53	59	0.10	0.18	0.23	0.30	0.36	0.43
	225-275	77-96	775-940	37	47	56	0.10	0.18	0.23	0.30	0.36	0.43
	275-325	96-111	940-1090	34	46	53	0.10	0.15	0.20	0.25	0.33	0.38
Alloy Steel	125-175	46-62	450-600	40	53	56	0.13	0.18	0.23	0.30	0.33	0.41
	175-225	62-77	600-775	37	47	53	0.10	0.18	0.23	0.30	0.33	0.41
	225-275	77-96	775-940	34	44	47	0.10	0.15	0.23	0.30	0.33	0.41
	275-325	96-111	940-1090	32	41	44	0.10	0.13	0.20	0.25	0.30	0.38
	325-375	111-129	1090-1265	29	38	41	0.08	0.13	0.20	0.25	0.30	0.36
High Strength Steel	225-300	77-104	600-1020	21	26	29	0.10	0.15	0.20	0.23	0.25	0.30
	300-350	104-121	1020-1180	15	21	23	0.08	0.15	0.20	0.23	0.25	0.30
	350-400	121-139	1180-1365	13	18	20	0.08	0.13	0.18	0.20	0.23	0.28
Structural Steel	100-150	38-50	370-500	36	47	52	0.13	0.23	0.25	0.30	0.38	0.43
	150-250	50-88	500-850	32	41	44	0.10	0.20	0.23	0.25	0.33	0.41
	250-350	88-121	850-1180	26	34	37	0.10	0.18	0.20	0.23	0.30	0.38
Tool Steel	150-200	50-70	500-700	21	27	29	0.10	0.13	0.18	0.23	0.25	0.30
	200-250	70-88	700-870	15	23	24	0.10	0.13	0.18	0.23	0.23	0.28
High Temp Alloy	140-220	49-77	480-755	7	9	10	0.08	0.15	0.18	0.23	0.25	0.30
	223-310	77-101	755-990	6	7	9	0.08	0.13	0.15	0.18	0.20	0.25
Titanium Alloy	140-220	49-77	480-755	10	12	14	0.08	0.15	0.18	0.23	0.25	0.30
	220-310	77-101	755-990	8	11	12	0.08	0.13	0.15	0.18	0.20	0.25
Aerospace Alloy S82	185-275	65-96	640-940	20	26	27	0.13	0.18	0.20	0.25	0.30	0.38
	275-350	96-121	940-1180	15	21	24	0.10	0.15	0.18	0.23	0.25	0.30
Stainless Steel 400 Series 416, 420, (303)	185-275	65-96	640-940	20	26	27	0.13	0.18	0.20	0.25	0.30	0.36
	275-350	96-121	940-1180	15	21	24	0.10	0.15	0.18	0.23	0.25	0.28
Stainless Steel 300 Series 304, 316, 17-4PH	135-185	49-65	480-640	20	26	27	0.13	0.18	0.20	0.25	0.30	0.36
	185-275	65-96	640-940	15	21	24	0.10	0.15	0.18	0.23	0.25	0.28
Super Duplex Duplex St/Stl	135-185	49-65	480-640	20	26	27	0.13	0.18	0.20	0.25	0.30	0.36
	185-275	65-96	640-940	15	21	24	0.10	0.15	0.18	0.23	0.25	0.28
Hardox	400	139	1365									
	500	160	1600	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
	600	210	2000									
Hardened Steel	300-400	104-139	1020-1365	13	18	20	0.08	0.13	0.18	0.20	0.27	0.38
	400-500	139+	1365+	8	10	12	0.06	0.10	0.15	0.18	0.23	0.28
SG/Nodular/ Grey/White Cast Iron	120-150	44-50	430-500	46	59	67	0.15	0.25	0.36	0.43	0.48	0.51
	150-200	50-70	500-700	40	53	59	0.13	0.23	0.30	0.41	0.46	0.48
	200-220	70-77	700-755	34	46	53	0.13	0.20	0.25	0.36	0.41	0.43
	220-260	77-90	755-890	29	38	46	0.10	0.15	0.20	0.25	0.33	0.33
Cast Aluminium	30	10	100	160	198	228	0.18	0.28	0.36	0.43	0.46	0.48
	180	62	600	79	107	122	0.18	0.28	0.36	0.41	0.43	0.48
Wrought Aluminium	30	10	100	160	198	228	0.18	0.28	0.36	0.43	0.46	0.48
	180	62	600	79	107	122	0.18	0.28	0.36	0.41	0.43	0.48
Aluminium Bronze	100-200	38-68	370-670	40	53	59	0.13	0.23	0.30	0.41	0.51	0.61
	200-250	68-87	670-855	29	38	46	0.10	0.15	0.20	0.25	0.31	0.38
Brass	100	38	370	46	59	67	0.15	0.25	0.36	0.43	0.53	0.63
Copper	60	21	200	35	40	45	0.05	0.08	0.15	0.20	0.25	0.35

Formulas: $\text{mm/min} = \text{rev/min} \cdot \text{mm/rev}$

$\text{M/min} = \text{rev/min} \cdot 0.003 \cdot \text{DIA}$

$\text{rev/min} = \text{M/min} \cdot 318.47/\text{DIA}$

SPEED AND FEED MULTIPLIER For various tool lengths

WARNING For Deep Hole Drilling Guidelines refer to page 83 in the Technical Section.

	Holder Length							
	Stub	Short	Intermediate	Standard	Extended ⚠	Long ⚠	XL ⚠	3XL ⚠
SPEED	see above chart				0.90	0.85	0.80	0.75
FEED	see above chart					0.95	0.90	0.90



Technical Section

GEN2 T-A Recommended Cutting Data – Carbide Drill Inserts Y-2 Series

Material	Hardness			Grade	AM200® Speed M/min	Feed (mm/rev)			
	BHN	kg	N/mm²			9.5-12.95	12.98-17.53	17.53-24.38	24.41-35
Free Machining Steel	100-150	38-50	370-500	C1/K35	146	0.20	0.30	0.41	0.48
	150-200	50-70	500-700	C1/K35	126	0.18	0.28	0.38	0.43
	200-250	70-88	700-870	C1/K35	119	0.15	0.25	0.36	0.41
Low Carbon Steel	85-125	30-46	300-450	C1/K35	137	0.20	0.25	0.36	0.46
	125-175	46-62	450-600	C1/K35	119	0.18	0.25	0.36	0.43
	175-225	62-77	600-775	C1/K35	108	0.15	0.23	0.33	0.41
	225-275	77-96	775-940	C1/K35	95	0.13	0.23	0.33	0.41
Medium Carbon Steel	125-175	46-62	450-600	C1/K35	119	0.18	0.25	0.36	0.43
	175-225	62-77	600-775	C1/K35	108	0.15	0.23	0.33	0.41
	225-275	77-96	775-940	C1/K35	95	0.15	0.23	0.33	0.41
	275-325	96-111	940-1090	C1/K35	80	0.13	0.20	0.30	0.38
Alloy Steel	125-175	46-62	450-600	C1/K35	115	0.18	0.25	0.36	0.43
	175-225	62-77	600-775	C1/K35	105	0.15	0.23	0.33	0.43
	225-275	77-96	775-940	C1/K35	95	0.15	0.23	0.33	0.41
	275-325	96-111	940-1090	C1/K35	87	0.13	0.20	0.30	0.38
	325-375	111-129	1090-1265	C1/K35	78	0.10	0.18	0.28	0.36
High Strength Steel	225-300	77-104	600-1020	C1/K35	70	0.15	0.23	0.28	0.33
	300-350	104-121	1020-1180	C1/K35	63	0.13	0.20	0.25	0.30
	350-400	121-139	1180-1365	C1/K35	56	0.10	0.18	0.23	0.28
Structural Steel	100-150	38-50	370-500	C1/K35	108	0.20	0.28	0.38	0.43
	150-250	50-88	500-850	C1/K35	87	0.15	0.25	0.33	0.38
	250-350	88-121	850-1180	C1/K35	80	0.13	0.23	0.30	0.33
Tool Steel	150-200	50-70	500-700	C1/K35	78	0.10	0.18	0.25	0.30
	200-250	70-88	700-870	C1/K35	59	0.10	0.18	0.25	0.30
High Temp Alloy	140-220	49-77	480-755	C2/K20	37	0.10	0.18	0.23	0.28
	223-310	77-101	755-990	C2/K20	29	0.10	0.15	0.20	0.25
Titanium Alloy	140-220	49-77	480-755	C2/K20	42	0.10	0.18	0.21	0.27
	220-310	77-101	755-990	C2/K20	33	0.08	0.15	0.18	0.23
Aerospace Alloy S82	185-275	65-96	640-940	C2/K20	73	0.12	0.16	0.18	0.22
	275-350	96-121	940-1180	C2/K20	56	0.10	0.14	0.16	0.19
Stainless Steel 400 Series 416, 420, (303)	185-275	65-96	640-940	C2/K20	73	0.18	0.23	0.30	0.36
	275-350	96-121	940-1180	C2/K20	56	0.15	0.20	0.28	0.30
Stainless Steel 300 Series 304, 316, 17-4PH	135-185	49-65	480-640	C2/K20	73	0.14	0.18	0.24	0.29
	185-275	65-96	640-940	C2/K20	56	0.12	0.16	0.22	0.24
Super Duplex Duplex St/Stl	135-185	49-65	480-640	C2/K20	38	0.12	0.17	0.22	0.26
	185-275	65-96	640-940	C2/K20	30	0.10	0.15	0.18	0.22
Hardox	400	139	1365	C2/K20	45	0.07	0.12	0.20	0.25
	500	160	1600	C2/K20	37	0.05	0.10	0.15	0.20
	600	210	2000	C2/K20	30	0.04	0.08	0.12	0.16
Hardened Steel	300-400	104-139	1020-1365	C1/K35	47	0.10	0.15	0.23	0.27
	400-500	139+	1365+	C1/K35	37	0.06	0.12	0.18	0.24
SG/Nodular/ Grey/White Cast Iron	120-150	44-50	430-500	C2/K20	152	0.20	0.30	0.38	0.48
	150-200	50-70	500-700	C2/K20	146	0.18	0.28	0.33	0.43
	200-220	70-77	700-755	C2/K20	131	0.15	0.23	0.30	0.38
	220-260	77-90	755-890	C2/K20	113	0.13	0.20	0.28	0.33
	260-320	90-104	890-1020	C2/K20	102	0.13	0.18	0.25	0.28
Cast Aluminium	30	10	100	C2/K20	300	0.23	0.38	0.46	0.58
	180	62	600	TiCN	225	0.20	0.33	0.40	0.50
Wrought Aluminium	30	10	100	C2/K20	426	0.12	0.33	0.40	0.50
	180	62	600	C2/K20	300	0.12	0.18	0.30	0.35
Aluminium Bronze	100-200	38-68	370-670	C2/K20	110	0.15	0.24	0.30	0.38
	200-250	68-87	670-855	C2/K20	90	0.12	0.18	0.23	0.28
Brass	100	38	370	C2/K20	200	0.18	0.27	0.33	0.45
Copper	60	21	200	C2/K20	130	0.07	0.10	0.18	0.26

Formulas: $\text{mm/min} = \text{rev/min} \cdot \text{mm/rev}$ $\text{M/min} = \text{rev/min} \cdot 0.003 \cdot \text{DIA}$ $\text{rev/min} = \text{M/min} \cdot 318.47/\text{DIA}$

P	M	K	N	S	H
Steel N/mm²	Stainless Steel N/mm²	Cast and Ductile Iron N/mm²	Non-ferrous Material N/mm²	High Temperature Materials N/mm²	Hardened Materials N/mm²
<1365	<940	<1020	<855	<990	<1365

Material	Hardness			Carbide Grade	Speed M/min			Feed (mm/rev)				
	BHN	kg	N/mm ²		TiN	TiCN	TiAlN	9.5 – 12.95mm	12.98 – 17.53mm	17.53 – 24.38mm	24.41 – 35mm	34.37 – 47.80mm
Free Machining Steel	100-150	38-50	370-500	C5 P40	96	115	128	0.20	0.30	0.38	0.45	0.53
	150-200	50-70	500-700	C5 P40	85	100	110	0.18	0.28	0.35	0.40	0.48
	200-250	70-88	700-870	C5 P40	79	90	104	0.15	0.25	0.33	0.38	0.43
Low Carbon Steel	85-125	30-46	300-450	C5 P40	91	110	119	0.20	0.25	0.33	0.43	0.48
	125-175	46-62	450-600	C5 P40	79	90	104	0.18	0.25	0.33	0.40	0.45
	175-225	62-77	600-775	C5 P40	73	82	95	0.15	0.23	0.30	0.38	0.43
Medium Carbon Steel	225-275	77-96	775-940	C5 P40	64	75	83	0.13	0.23	0.30	0.38	0.43
	125-175	46-62	450-600	C5 P40	79	90	104	0.18	0.25	0.33	0.40	0.45
	175-225	62-77	600-775	C5 P40	73	84	95	0.15	0.23	0.30	0.38	0.43
Alloy Steel	225-275	77-96	775-940	C5 P40	67	72	83	0.15	0.23	0.30	0.38	0.43
	275-325	96-111	940-1090	C5 P40	55	62	70	0.13	0.20	0.28	0.35	0.40
	125-175	46-62	450-600	C5 P40	76	87	99	0.18	0.25	0.33	0.40	0.45
High Strength Steel	175-225	62-77	600-775	C5 P40	70	80	92	0.15	0.23	0.30	0.38	0.43
	225-275	77-96	775-940	C5 P40	64	72	83	0.15	0.23	0.30	0.38	0.43
	275-325	96-111	940-1090	C5 P40	61	68	76	0.13	0.20	0.28	0.35	0.40
Structural Steel	325-375	111-129	1090-1265	C5 P40	52	60	67	0.10	0.18	0.25	0.33	0.38
	225-300	77-104	600-1020	C5 P40	49	55	61	0.15	0.23	0.25	0.30	0.38
	300-350	104-121	1020-1180	C5 P40	43	49	55	0.13	0.20	0.23	0.28	0.35
Tool Steel	350-400	121-139	1180-1365	C5 P40	37	43	49	0.10	0.18	0.20	0.25	0.30
	100-150	38-50	370-500	C5 P40	73	84	95	0.20	0.28	0.35	0.40	0.45
	150-250	50-88	500-850	C5 P40	61	68	76	0.15	0.25	0.30	0.35	0.40
High Temp Alloy	250-350	88-121	850-1180	C5 P40	55	62	70	0.13	0.23	0.28	0.30	0.35
	150-200	50-70	500-700	C5 P40	49	58	67	0.10	0.18	0.23	0.28	0.33
	200-250	70-88	700-870	C5 P40	37	45	52	0.10	0.18	0.23	0.28	0.33
Titanium Alloy	140-220	49-77	480-755	C2/K20	24	28	32	0.10	0.18	0.23	0.28	0.33
	223-310	77-101	755-990	C2/K20	18	22	26	0.10	0.15	0.20	0.25	0.30
	140-220	49-77	480-755	C2/K20	30	32	38	0.10	0.18	0.23	0.28	0.33
Aerospace Alloy S82	220-310	77-101	755-990	C2/K20	24	28	33	0.10	0.15	0.20	0.25	0.30
	185-275	65-96	640-940	C2/K20	49	57	64	0.17	0.22	0.29	0.35	0.40
	275-350	96-121	940-1180	C2/K20	37	43	49	0.14	0.19	0.27	0.30	0.35
Stainless Steel 400 Series 416, 420, (303)	185-275	65-96	640-940	C2/K20	49	57	64	0.17	0.22	0.29	0.35	0.40
	275-350	96-121	940-1180	C2/K20	37	43	49	0.14	0.19	0.27	0.30	0.35
	135-185	49-65	480-640	C2/K20	49	57	64	0.13	0.17	0.22	0.26	0.30
Stainless Steel 300 Series 304, 316, 17-4PH	185-275	65-96	640-940	C2/K20	37	43	49	0.11	0.14	0.20	0.22	0.25
	135-185	49-65	480-640	C2/K20	25	29	33	0.11	0.15	0.19	0.23	0.27
	185-275	65-96	640-940	C2/K20	19	22	25	0.09	0.13	0.18	0.20	0.23
Super Duplex Duplex St/Stl	400	139	1365	C2/K20	23	30	35	0.07	0.12	0.20	0.25	0.30
	500	160	1600	C2/K20	15	21	26	0.05	0.10	0.15	0.20	0.25
	600	210	2000	C2/K20	11	16	22	0.04	0.08	0.12	0.16	0.20
Hardox	300-400	104-139	1020-1365	C5 P40	34	39	43	0.10	0.18	0.23	0.28	0.33
	400-500	139+	1365+	C5 P40	20	23	25	0.08	0.15	0.20	0.23	0.28
	120-150	44-50	430-500	C2/K20	98	127	141	0.20	0.30	0.38	0.48	0.58
SG/Nodular/ Grey/White Cast Iron	150-200	50-70	500-700	C2/K20	82	102	122	0.18	0.28	0.33	0.43	0.53
	200-220	70-77	700-755	C2/K20	73	93	110	0.15	0.23	0.30	0.38	0.45
	220-260	77-90	755-890	C2/K20	64	79	95	0.13	0.20	0.28	0.33	0.38
Cast Aluminium	260-320	90-104	890-1020	C2/K20	55	69	83	0.13	0.18	0.25	0.28	0.33
	30	10	100	C2/K20	366	410	460	0.25	0.38	0.45	0.50	0.55
	180	62	600	C2/K20	244	275	306	0.23	0.33	0.40	0.45	0.50
Wrought Aluminium	30	10	100	C2/K20	366	410	460	0.10	0.15	0.25	0.30	0.36
	180	62	600	C2/K20	244	275	306	0.20	0.28	0.36	0.45	0.50
	100-200	38-68	370-670	C2/K20	85	100	110	0.13	0.20	0.25	0.36	0.42
Aluminium Bronze	200-250	68-87	670-855	C2/K20	64	79	94	0.10	0.15	0.18	0.25	0.33
	100	38	370	C2/K20	130	160	184	0.15	0.23	0.28	0.38	0.45
	60	21	200	C2/K20	80	100	120	0.15	0.08	0.10	0.15	0.25

Formulas:

mm/min = rev/min • mm/rev

M/min = rev/min • 0.003 • DIA

rev/min = M/min • 318.47/DIA

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365



Technical Section



Recommended Cutting Data – Carbide Flat Bottom Inserts Y-2 Series

Material	Hardness			Carbide Grade	Speed M/min				Feed (mm/rev)			
	BHN	kg	N/mm ²		TiN	TiCN	TiAlN	AM200®	9.5 – 12.95mm	12.98 – 17.53mm	17.53 – 24.38mm	24.41 – 35mm
Free Machining Steel	100-150	38-50	370-500	C2	82	98	110	126	0.17	0.26	0.32	0.39
	150-200	50-70	500-700	C2	73	85	94	110	0.15	0.24	0.30	0.35
	200-250	70-88	700-870	C2	67	76	88	102	0.13	0.22	0.28	0.32
Low Carbon Steel	85-125	30-46	300-450	C2	79	94	102	117	0.17	0.22	0.28	0.37
	125-175	46-62	450-600	C2	67	76	88	102	0.15	0.22	0.28	0.35
	175-225	62-77	600-775	C2	61	70	81	93	0.13	0.19	0.26	0.32
Medium Carbon Steel	225-275	77-96	775-940	C2	55	64	70	81	0.11	0.19	0.26	0.32
	125-175	46-62	450-600	C2	67	76	88	102	0.15	0.22	0.28	0.35
	175-225	62-77	600-775	C2	61	72	81	93	0.13	0.19	0.26	0.32
Alloy Steel	225-275	77-96	775-940	C2	55	61	70	81	0.13	0.19	0.26	0.32
	275-325	96-111	940-1090	C2	46	53	61	70	0.11	0.17	0.24	0.30
	125-175	46-62	450-600	C2	64	75	85	99	0.15	0.22	0.28	0.35
High Strength Steel	175-225	62-77	600-775	C2	59	67	79	91	0.13	0.19	0.26	0.32
	225-275	77-96	775-940	C2	55	61	70	81	0.13	0.19	0.26	0.32
	275-325	96-111	940-1090	C2	52	58	66	76	0.11	0.17	0.24	0.30
Structural Steel	325-375	111-129	1090-1265	C2	44	50	58	67	0.09	0.15	0.22	0.28
	225-300	77-104	600-1020	C2	41	47	52	59	0.13	0.19	0.22	0.26
	300-350	104-121	1020-1180	C2	37	41	47	55	0.11	0.17	0.19	0.24
Tool Steel	350-400	121-139	1180-1365	C2	30	37	41	47	0.09	0.15	0.17	0.22
	100-150	38-50	370-500	C2	62	72	81	93	0.17	0.24	0.30	0.35
	150-250	50-88	500-850	C2	52	58	66	76	0.13	0.22	0.28	0.30
Titanium Alloy	250-350	88-121	850-1180	C2	47	53	61	70	0.11	0.19	0.25	0.26
	150-200	50-70	500-700	C2	41	49	58	67	0.09	0.15	0.19	0.24
	200-250	70-88	700-870	C2	30	37	44	50	0.09	0.15	0.19	0.24
Aerospace Alloy S82	140-220	49-77	480-755	C2	21	23	27	32	0.09	0.15	0.19	0.24
	223-310	77-101	755-990	C2	15	18	21	24	0.09	0.13	0.17	0.22
	140-220	49-77	480-755	C2	26	28	33	40	0.08	0.14	0.17	0.20
Stainless Steel 400 Series 416, 420, (303)	220-310	77-101	755-990	C2	21	25	29	30	0.08	0.12	0.15	0.18
	185-275	65-96	640-940	C2	43	50	37	40	0.15	0.17	0.25	0.30
	275-350	96-121	940-1180	C2	33	38	28	32	0.13	0.15	0.23	0.25
Stainless Steel 300 Series 304, 316, 17-4PH	185-275	65-96	640-940	C2	43	50	56	64	0.15	0.20	0.25	0.30
	275-350	96-121	940-1180	C2	33	38	43	49	0.13	0.18	0.23	0.25
	135-185	49-65	480-640	C2	28	33	37	40	0.13	0.17	0.21	0.25
Super Duplex Duplex St/Stl	185-275	65-96	640-940	C2	21	25	28	32	0.11	0.15	0.19	0.21
	135-185	49-65	480-640	C2	22	26	29	33	0.10	0.14	0.17	0.20
	185-275	65-96	640-940	C2	17	19	22	26	0.08	0.12	0.15	0.17
Hardox	400	139	1365	C2	20	26	31	39	0.06	0.10	0.16	0.20
	500	160	1600	C2	13	18	23	31	0.04	0.08	0.12	0.16
	600	210	2000	C2	10	14	19	25	0.03	0.06	0.10	0.13
Hardened Steel	300-400	104-139	1020-1365	C2	30	34	38	41	0.08	0.14	0.18	0.22
	400-500	139+	1365+	C2	18	20	22	33	0.06	0.12	0.16	0.18
	120-150	44-50	430-500	C2	82	108	120	137	0.17	0.26	0.32	0.41
SG/Nodular/ Grey/White Cast Iron	150-200	50-70	500-700	C2	70	87	104	119	0.15	0.24	0.28	0.38
	200-220	70-77	700-755	C2	61	79	94	108	0.13	0.19	0.26	0.32
	220-260	77-90	755-890	C2	55	67	81	93	0.11	0.17	0.24	0.28
	260-320	90-104	890-1020	C2	47	58	70	81	0.11	0.15	0.22	0.24
Cast Aluminium	30	10	100	C2	160	198	228	N/A	0.22	0.32	0.41	0.43
	180	62	600	C2	79	107	122	N/A	0.19	0.28	0.35	0.39
Wrought Aluminium	30	10	100	C2	292	328	368	390	0.12	0.18	0.23	0.25
	180	62	600	C2	195	220	245	260	0.10	0.16	0.20	0.22
Aluminium Bronze	100-200	38-68	370-670	C2	73	85	95	105	0.10	0.16	0.20	0.29
	200-250	68-87	670-855	C2	55	68	81	87	0.08	0.12	0.14	0.20
Brass	100	38	370	C2	112	138	160	185	0.12	0.18	0.22	0.30
Copper	60	21	200	C2	68	85	105	117	0.04	0.06	0.08	0.12

Formulas:

mm/min = rev/min • mm/rev

M/min = rev/min • 0.003 • DIA

rev/min = M/min • 318.47/DIA

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365



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Thin Wall (TW) & 150° Structural Steel (SS) Recommended Cutting Data

Grade	Material Hardness (BHN)	Speed(M/min) Mist Coolant TIAN	Speed(M/min) Mist Coolant AM200®	FEED (mm/rev)			
				14mm – 16mm	18mm – 24mm	25mm – 35mm	36mm – 47mm
HSS Super Cobalt	100 - 150	34	40	0.25	0.30	0.38	0.45
	150 – 250	31	35	0.23	0.28	0.35	0.40
	250 – 350	28	32	0.20	0.25	0.28	0.38

GEN2 T-A HSS Super Cobalt Drill Inserts Recommended Cutting Data

Grade	Material Hardness (BHN)	Speed(M/min) Mist Coolant AM200®	FEED (mm/rev)			
			14mm – 16mm	18mm – 24mm	25mm – 35mm	36mm – 47mm
HSS Super Cobalt	100 - 150	40	0.25	0.30	0.38	0.45
	150 – 250	35	0.23	0.28	0.35	0.40
	250 – 350	32	0.20	0.25	0.28	0.38

GEN2 T-A Carbide Drill Inserts Recommended Cutting Data

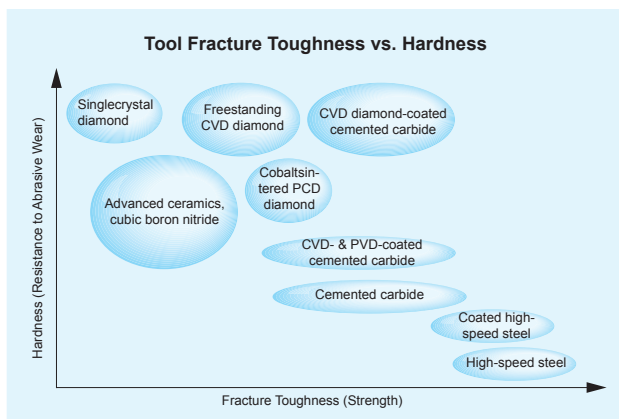
Grade	Material Hardness (BHN)	Speed(M/min) Mist Coolant AM200®	FEED (mm/rev)			
			14mm – 16mm	18mm – 24mm	25mm – 35mm	36mm – 47mm
K35 Carbide	100 - 150	75	0.25	0.30	0.38	0.45
	150 – 250	61	0.23	0.28	0.35	0.40
	250 – 350	57	0.20	0.25	0.28	0.38

• 0.95 multiplier for feed rate on Long Length Holder

IMPORTANT NOTE: - The speeds and feeds listed above are considered a general guideline for all Structural Steel applications. In the case of extreme ductile steels a further reduction in speed of 20% should be applied. Factory technical assistance is also available for your specific applications through our Application Engineering Team

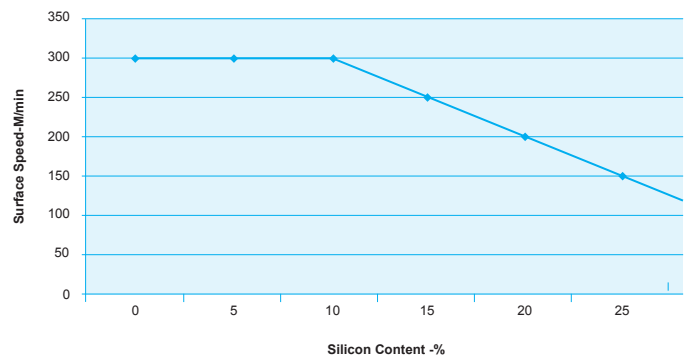
Diamond Film Coated Inserts

Allied's Diamond film inserts combine the best features of a tough carbide grade with a hard, durable, Crystalline Diamond CVD coating.



The hardness values of tooling materials are indexed in relation to their toughness.

CVD Diamond Film Surface Speed Guide - Aluminium/Silicon alloys



Customer Benefits

- High penetration rates
- Increased toughness compared to PCD
- 30-50 times increase in tool life over un-coated carbide tools in non-ferrous / non-metallic materials.

Target Materials

Polymer Matrix Composites (PMC) -Kevlar, Plastics, Carbon Fibre, Fibreglass, Graphite and Resin materials.

Metal Matrix Composites (MMC) -

Aluminium Alloys, Brass, Bronze, Copper and its alloys, Lead Alloys, Magnesium Alloys and Precious metals.

Ceramic Matrix Composites (CMC) -

Soft Carbide & Ceramics in the green or pre-sintered state.

Materials not suitable for Diamond Film inserts.

Beryllium, Chrome, hard CMC's, Cobalt based materials, Iron base materials, Molybdenum, Nickel base materials, Titanium alloys, hard Tungsten alloys.

Starting Point for Diamond Film Drilling Parameters

Material Group:	Speed M/min	Feed mm/rev	Vacuum	Coolant
PMC's (polymer matrix composites)	75 - 600	0.025 - 0.38	Yes	Air
MMC's (metal matrix composites)	30 - 300	0.076 - 0.5	No	Water sol
CMC's (ceramic matrix composites)	15 - 75	0.025 - 0.25	Yes	Air





Technical Section



Coolant Recommendations

Material	Hardness			Coolant Pressure Bar											
				Coolant Flow Rate - L/Min											
				HSS Inserts (AM200 [®] , TiN, TiCN, TiAlN Coated) Diameter Range						Carbide Inserts (AM200 [®] , TiN, TiCN, TiAlN)					
	BHN	kg	N/mm ²	9.5 - 12.95	12.98 - 17.53	17.54 - 24.38	24.39 - 35.0	35.1 - 47.8	47.85 - 65.0	66.0 - 114.48	9.5 - 12.95	12.98 - 17.53	17.53 - 24.38	24.41 - 35	34.37 - 47.8
Free Machining Steel	100-250	38-88	370-870	12.8 9.6	8.3 11.4	9.6 19.7	7.9 30.3	6.9 53.0	3.5 125.0	6.2 167.0	20 12.2	16.5 16.3	16.5 25.2	15.2 41.5	12 71.9
Low Carbon Steel	85-275	30-96	300-940	11.8 9.5	6.2 9.8	6.6 15.9	5.5 26.5	5.2 45.4	2.8 114.0	4.5 144.0	17.5 11.4	11 13.3	11 20.6	11.8 36.5	9.0 62
Medium Carbon Steel	125-325	46-111	450-1090	11.4 9.1	5.9 9.8	6.2 15.5	5.2 22.7	4.8 45.4	2.8 114.0	4.5 144.0	17.2 11.3	9.7 12.5	10.4 20	10.4 33.8	7.5 57
Alloy Steel	125-375	46-129	450-1265	11.4 9.1	5.2 9.1	5.5 14.8	4.8 22.7	4.2 41.6	2.4 106.0	3.5 125.0	16.5 11.1	9.3 12.3	9.7 19.3	7.9 30	7.2 55.8
High Strength Steel	225-400	77-139	600-1365	10.7 9.1	4.2 8.3	3.5 11.7	2.0 19.0	2.0 30.0	1.7 87.0	2.0 98.0	14.5 10.4	5.2 9.1	4.1 12.6	3.1 18.8	2.7 33.6
Structural Steel	100-350	38-121	370-1180	11.4 9.1	5.9 9.8	5.5 14.8	3.8 23.0	3.5 38.0	2.0 98.0	3.5 125.0	15.8 10.8	9.0 12	7.9 17.5	6.9 27.8	5.2 47.1
Tool Steel	150-250	50-88	500-870	10.7 9.1	4.2 8.3	3.5 11.7	2.0 19.0	2.0 30.0	1.7 87.0	2.0 98.0	14.5 10.4	5.2 9.1	4.8 13.6	3.4 19.7	3.1 36.5
High Temp Alloy	140-310	49-101	480-990	10.7 9.1	4.5 8.7	3.8 12.1	2.4 18.9	2.0 30.0	2.0 98.0	3.1 125.0	16.5 11.1	11.4 13.5	12.4 21.9	11 35.4	9.0 62
Titanium Alloy	140-310	49-101	480-990	10.7 9.1	4.5 8.7	3.8 12.1	2.4 18.9	2.0 30.0	2.0 98.0	3.1 125.0	16.5 11.1	11.4 13.5	12.4 21.9	11 35.4	9.0 62
Austenitic Stainless Steel	135-275	49-96	480-940	11.8 9.5	5.9 9.8	5.2 14.0	3.8 23.0	3.5 38.0	2.0 98.0	3.1 117.0	22.7 13	16.5 16.3	17.9 26.3	17.2 44.2	13.1 75
400 Series/ 17-4PH (303) Stainless Steel	185-350	65-121	640-1180	11.8 9.5	5.9 9.8	5.2 14.0	3.8 23.0	3.5 38.0	2.0 98.0	3.1 117.0	22.7 13	16.5 16.3	17.9 26.3	17.2 44.2	13.1 75
Super Duplex Duplex St/Sl	135-275	49-96	480-940	11.8 9.5	5.9 9.8	5.2 14.0	3.8 23.0	3.5 38.0	2.0 98.0	3.1 117.0	22.7 13	16.5 16.3	17.9 26.3	17.2 44.2	13.1 75
Hardened Steel	300-500	104-139	1020-1365	10.7 9.1	4.2 8.3	3.5 11.7	2.0 19.0	2.0 30.0	1.7 87.0	2.0 98.0	14.5 10.4	5.2 9.1	4.8 13.6	3.4 19.7	3.1 36.5
SG/Modular/ Cast Iron Grey/White	120-320	44-104	430-1020	11.0 9.1	4.5 8.7	4.2 12.5	2.8 19.0	2.4 34.0	2.0 98.0	2.4 106.0	15.5 10.7	7.2 10.8	6.2 15.4	6.2 26.5	5.5 48.7
Cast Aluminium	30-180	62	600	14.5 10.0	12.4 14.0	15.8 23.0	11.0 34.0	8.6 61.0	3.5 125.0	5.5 159.0	24.1 13.4	22 18.8	21.7 29	19.6 47.2	13.8 77
Wrought Aluminium	30-180	62	600	14.5 10.0	12.4 14.0	15.8 23.0	11.0 34.0	8.6 61.0	3.5 125.0	5.5 159.0	24.1 13.4	22 18.8	21.7 29	19.6 47.2	13.8 77
Aluminium Bronze	100-250	38-87	370-855	12.8 9.6	8.3 11.4	9.7 19.7	8.0 30.3	6.9 53.0	3.5 125.0	6.2 167.0	20 12.2	16.5 16.3	16.5 25.2	15.2 41.5	12 71.9
Brass	100	38	370	11.0 9.1	4.5 8.7	4.2 12.5	2.8 19.0	2.4 34.0	2.0 98.0	2.4 106.0	24.1 13.4	22 18.8	21.7 29	19.6 47.2	13.8 77
Copper	60	-	-	12.8 9.6	8.3 11.4	9.7 19.7	8.0 30.3	6.9 53.0	3.5 125.0	6.2 167.0	20 12.2	16.5 16.3	16.5 25.2	15.2 41.5	12 71.9

COOLANT MULTIPLIER

Holder Length							
Stub	Short	Intermediate	Standard	Extended	Long	XL	3XL
see above chart				1.3	1.5	2	2

COOLANT RECOMMENDATION:

Example To drill 25mm diameter hole in alloy steel with a hardness value 125-325 BHN

Standard holder = 4.8 Bar, 22.7 L/Min
 XL holder = 4.8 x 2 = 9.6 Bar, 22.7 x 2 = 45.4 L/Min
 3XL holder = 4.8 x 3 = 14.4 Bar, 22.7 x 3 = 68.1 L/Min



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Material Cross Reference

Material Class	German	DIN	French	UK	Swedish	Spanish	USA
Free Machining Steel	1.0718	96MnPB28	S250Pb		1914	F.2112 – 11SMnPb28	12L13
	1.0721	10S20	10F1	210M15		F.2121 – 10 S 20	1108
	1.0722	10SPb20	10PbF2			F.2122 – 10 SPb 20	11L08
	1.0723	15S20		210A15	1922	F.210F	
	1.0736	9SMn36	S300	240M07 EN 1B		F.2113-12 SMn 35	1215
	1.0737	9MnPb36	S300Pb		1926	F.2114 – 12 SMnPb 35	12L14
Low Carbon Steel	1.0301	C10	AF34C10/XC10	045M10			1010
	1.0401	C15	AF37C12/XC18	080M15;040A15	1350	F.111	1015
	1.0402	C22	AF42C20/XC25	050A20/055M15-EN2C	1450	F.112	1020
	1.0406	C25	AF50C30	070M26		F.221	1025
	1.0711	9S20		220M07			1212
	1.0715	9SMn28	S250	230M07	1912	F.2111-11SMn28	1213
	1.1121	Ck10	XC10	040A10	1265	F.1510 – C 10 k	1010
	1.1133	20Mn5	20M5	120M19		F.1515 – 20Mn 6	1022/1518
	1.1141	Ck15	XC15/C15E	080M15 EN32C	1370	F.1511 – C 16 k	1015
	1.1151	Ck22	XC25/C22E	050A20		F.1120 – C 25 k	1020/1023
	1.1158	Ck25	XC25/C25E	070M26		F.1120 – C 25 k	1025
	1.5622	14Ni6	15N6/15Ni6			F.2641 – 15 Ni 6	A350-LF5
	1.5752	14NiCr14	12NC15	655M13/A12 EN 36A			3310/9314
Medium Carbon Steel	1.7015	15Cr3	12C3	523M15			5015
	1.0501	C35	AF55C35/XC38	060A35	1550	F.113	1035
	1.0503	C45	AF65C45/C45	080M46	1650	F.114	1045
	1.0511	C40	AF60C40/C40			F.114.A	1040
	1.0535	C55	C55	070M55	1655		1055
	1.0601	C60	AF70C55/C60	080A62-EN 43D		F.115	1060
	1.0726	35S20	35MF6	212M36 EN 8M	1957	F.210G	1140
	1.0727	45S20	45MF4	212M44	1973		1146
	1.0903	51Si7	51S7	250A53 EN 45	2090	F.1450 – 50 Si 7	9255
	1.0904	55Si7	55S7	250A53	2085	F.1440 – 56 Si 7	9255
	1.0909	60Si7	60S7	250A58		F.1441 – 60 Si 7	9260
	1.0961	60SiCr7	60SC7	250A61		F.1442 – 60 SiCr 8	9262
	1.1165	30Mn5	35M5/30Mn5	120M36/150M28		F.1203 – 36 Mn5	1330
	1.1166	34Mn5	35M5/34Mn5			F.8211 – 30 Mn5	1536
	1.1167	36Mn5	40M5/36Mn5	150M36 EN 15	2120	F.1203 – 36 Mn5	1335
	1.117	28Mn6	20M5/28Mn6	150M 28 EN 14A			1330
	1.118	Cm35	XC32/C35R	080M36	1572	F.1135 – C 35 K-1	1035
	1.1186	Ck40	XC42H1/C40E	060A40/080A40			1040
	1.1191	Ck45	XC42H1/C45/XC45	080M46/060A47	1672	F.1140 – C 45 k	1045
	1.1201	Cm45	XC42H1/C45R	080M46	1660	F.1145 – C 45 k	1045
	1.1203	Ck55	XC55H1/C55E	060A57/070M55		F.1150 – C 55 k	1055
	1.1206	Ck50	XC48H1/C50E	080M50			1050
	1.1213	Cf53	XC48H1TS	060A52	1674		1050
	1.1221	Ck60	XC60/C60E/2C60	060A62	1665/1678	F.511/F.512	1060
	1.1231	Ck67	XC68	060A67	1770		1070
	1.7003	38Cr2	38C2/38Cr5			38 Cr 3	
Alloy Steel	1.1248/1269	Ck75	XC75/C75E/XC90	060A78	1774/1778	F.513/514/515	1080/1078/1086
	1.1274	Ck101	XC100	060A96	1870		1095
	1.233	35CrMo4/47CrMo4	34CD4/35CrMo4/42CD4	708A37/708M40	2234/2244		4135/4142
	1.571/.5711	36NiCr6/40NiCr6	35NC6	640A35/640M40 EN111A			3135/3140
	1.5736	36NiCr10	30NC11				3435
	1.6523/43	21NiCrMo2	20NCD2	805M20/805A20 EN 362	2506	F.1522 – 20 NiCrMo 2	8620/8720
	1.6546	40NiCrMo22	40NCD2	311-Type 7		F.1204 – 40 NiCrMo2	8740
	1.6587	17CrNiMo8	18NCD6	820A16		F.1560 – 14 NiCrMo13	
	1.6657	14NiCrMo134	16NCD13	832M13		F.1569 – 14 NiCrMo 131	
	1.7006	46Cr2	42C2/46Cr2				5045/5046
	1.703	28Cr4		530A30			5130
	1.7033	34Cr4	32C4/34Cr4	530A32 EN18B		F.8221 – 35 Cr 4/F.224	5132
	1.7034	37Cr4	38C4/37Cr4	530A36		F.1201 – 38 Cr 4	5135
	1.7035	41Cr4	42C4/41Cr4	530M40/530A40 EN 18		F.1202 – 42 Cr 4	5140
	1.7045	42Cr4	42C4TS	530A40	2245	F.1202 – 42 Cr 4	5140
	1.7131	16MnCr5	16MC5	527M17	2511	F.1515 – 16 MnCr 5	5115
	1.7147	20MnCr5	20MC5			F.150.D	5120
	1.7176	55Cr3	55C3	527A60 EN 48	2253	F.1431 – 55 Cr3	5155
	1.7218	25CrMo4	25CD4/25CrMo4	1717CDS110	2225	F.8330 – AM 25 CrMo4	4130
	1.722	34CrMo4	35CD4/34CrMo4	708A37 EN 19B	2234	F.8231 – AM 34 CrMo4	4135/4137
	1.7225	42CrMo4	42CD4/42CrMo4	708M40 EN 19A	2244	F.8232 – 42 CrMo4	4140/4142
High Strength Alloy Steel	1.7228	50CrMo4	50CrMo4	708A47			4150
	1.8159	50CrV4	50CV4/51CrV4	735A50 EN 47	2230	F.1430 – 51 CrV4	6150
	1.8507	34CrAlMo5	30CAD6.12	905M31		F.1741 – 34 CrAlMo5	A355Cl.D
	1.8509	41CrAlMo7	40CAD6.12	905M39 EN 41B	2940	F.1740 – 41 CrAlMo7	A355Cl.A
	1.5755	31NiCr14	18NC13	653M31		F.123	
	1.6511	36CrNiMo4	40NCD3/36CrNiMo4	816M40 EN 110		F.1280 – 35 NiCrMo4	9840
	1.6562	40NiCrMo73		817M40			4340
	1.658	30CrNiMo8	30CND8/30CrNiMo8	823M30			
	1.6582	34CrNiMo8	35NCD6/34CrNiMo6	817M40 EN 24	2541	F.1272 – 40 NiCrMo 7	4340
	1.6746	32NiCrMo145	35NCD14	830M31		F.1262 – 32 NiCrMo 12	
	1.6747	30NiCrMo166	35NCD16	835M30		F.1260 – 32 NiCrMo 16	
	1.8515	31CrMoV139	30CD12	722M24 EN 40B	2240	F.1712 – 31 CrMo 12	
	1.8523	39CrMoV139		897M39 EN 40C			



Material Cross Reference

Material Class	German	DIN	French	UK	Swedish	Spanish	USA
Structural Steel	1.0038	RSt37-2	E24-2NE/S235JRG2	4360-40C	1312		A570 (36)
	1.0044	St44-2	E28-2/S275JR	4360-43B	1412	A 430B	A570 (40)
	1.005	St50-2	A50-2/E295	4360-50B	2172		A570 (50)
	1.006/007	St60-2/St70-2	A60-2/E335-A70-2/E360	4360-55E			
	1.0116	St37-3	E24-3;-4/S235J2G3	4360-40C/D-1449-37C	1313	A360 C;D	A284/A573/A611
	1.033	St12	DC01	1449 – 2/3/4CR		AP 00	A366/1012/A619
	1.0333	St13		1449 2CR; 3CR		AP 02	1008
	1.0338	St14	DC04	1449 1CR; 2CR		AP 04	A620
	1.0345	H I	A37CP;AP/P235GH	1501Gr.161-360/400	1330	A 37 RC I;RA II	A516Gr.65;-55
	1.0347	RRSt13	DC03	3CR			A619
	1.0425	H II	A42CP;AP/P265GH	161-400;	1430	A42 RC 1	
	1.0473	19Mn6	A52CP;AP/P335GH		2101/2102	A 47 RB II	A537
	1.0481	17Mn4	A48CP;AP/P295GH			A 47 RC1; RA II	A516 (70)
	1.0562	StE355	E355R/FP/S355N		2132	AE 355 KG;DD	A633 (C)
	1.057	St52-3	E36-3;E36-4/S355J2G3	4360-50B;50C;50D	2132	A 510 C;D	
	1.5415	15Mo3	15D3/15Mo3	1501-240	2912	F.2601 – 16 Mo 3	A204 (A)
	1.5423	16Mo5		1503-245-420		F.2602 – 16 Mo 5	4520
	1.5637	10Ni14	12N14/12Ni14	1501-503-690		F.152	A350-LF3
	1.5713	13NiCr6	10NC6				3115
	1.5732	14NiCr10	14NC11			F.1540 – 15 NiCr 11	3415
High Temperature Alloys	1.7335	13CrMo44	15CD3.05	620Gr.27;31	2216	F.2631 – 14 CrMo 4 5	A182-F11;F12
	1.7337	16CrMo44	15CD4.5	620Gr.27	2216		A387 (12)
	1.738	10CrMo910	12CD9.10/10CrMo9-10	622Gr.31;45	2218	TU.H	A182F22
	1.7715	14MoV63		660/440		F.2621 – 13 MoCrV6	
	1.8902	StE420	E420RIFP/S420N	4360-55E		AE 420 KG	A633Gr.E
	1.8905	StE460	E460RIFP/S460N			AE 460 KG	A633Gr.E
	1.4864	X12NiCrSi3616	Z12NCS37.18	NA17		F.3313-X 12 CrNi 36-16	330
	1.4865	G-X40NiCrSi3818		330C40			
	1.4876	X10NiCrAlTi3320	Z8NC3221	NA15(H)		F.3545-X 9NiCr 33-21	B163
	2.436	NiCu30Fe	NU30	3072-76/NA13			4544/SB127/164
	2.4375	NiCu30Al		3072-76/NA18/3146			4676
	2.4602	NiCr17Mo17FeW	NC 17 DWY				5388 C
	2.463	NiCr20Ti	NC 20 T	HR5/203-4/703-B	MH-05		
	2.4631	NiCr20TiAl	NC 20 TA	HR 401HR601/736B	MH-07		
	2.4634	NiCo20Cr15MoAlTi	NCKD 20 ATV	HR 3/5007	MH-14		
	2.4636	NiCo15Cr15MoAlTi	NCKD 20 AT				687
	2.465	NiCr20Co19MoTi	NCK 20 D	HR 10			
	2.4662	NiCr15MoTi	Z8 NCDT 42		MH-16		5660C
	2.4665	NiCr22Fe18Mo	Nc 22 FeD	HR 6/204	MH-03		5536E
	2.4668	NiCr19Fe19NbMo	NC 19 FeNb	HR 8	MH-06		
	2.4669	NiCr16FeTi	NC 15 Fe TNb	HR 505			5542G
Titanium Alloys	2.467	G-NiCr13Al6MoNb	NC 13 AD	HC 203	MH-31		5391A
	2.4674	NiCo15Cr10MoAlTi	NK 15 CAT	HC 204			
	2.4676	NiCo10W10Cr9AlTi					
	2.4816	NiCr15Fe	NC 15 Fe	3072-76			5540
	2.4856	NiCr22Mo9Nb	NC 22 FeDNB				5581
	2.4858	NiCr21Mo	NC 21 FeDU	3072-76			
	2.4973	NiCr19Co11MoTi	NC 19 KDT				
	2.4983	NiCr18Co18MoAlTi	NCK 19 DAT				684
		NiFe33Cr17Mo	NW 11 AC	HR 207/5047			
	3.7024/25	Ti99,8	T-35	TA.1		Ti-PO1	
Stainless Steels	3.7124	TiCu2	T-U2	TA.21-24/52-55/58		Ti-P11	
	3.7154	TiAl6Zr5Mo0,5Si0,2	T-A6ZD	TA.43/44		Ti-P67	
	3.7184	TiAl4Mo4Sn2Si0,5	T-A4DE	TA.45-51/57		Ti-P68	
	3.7034/35	Ti99,7	T-40	TA-2/34/5		Ti-PO2	4941/42/51/4902
	3.7064/65	Ti99,5	T-60	TA-6/7/8/9		Ti-PO4	4901/21
	3.7164/65	TiAl6V4	T-A6V	TA.10-13/28/56		Ti-P63	491128/35/54/65/67
			T-50	DTD5023/5283			4900
	1.4	X6Cr13	Z6013/Z6Cr13	403S17	2301	F.3110-X6 Cr 13	403
	1.4001	X7Cr14	Z3014	403S17	2301	F.8401-AM-X12 Cr 13	410S
	1.4002	X6CrAl13	Z6CA13/Z6CrAl13	405S17	2302	F.3111-X6 CrAl13	405
	1.4005	X12CrS13	Z12CF13/Z12CrS13	416S21	2380	F.3411-X12 CrS 13	416
	1.4006	X10Cr13	Z12C13/Z12Cr13	410S21 ENEN56A	2302	F.3401-X12 Cr 13	410/CA-15
	1.4016	X6Cr17	Z8C17/Z6Cr17	430S1 EN 60	2320	F.3113-X8 Cr17	430
	1.4021	X20Cr13	Z20C13/Z20Cr13	420S37	2303	F.3402-X20 Cr 13	420
	1.4028	X30Cr13	Z20C13/Z20Cr13	420S45	2304	F.3403-X30 Cr 13	
	1.4031	X38Cr13	Z40C14/Z40Cr14		2304	F.3404-X40 Cr 13	
	1.4034	X46Cr13	Z40C14/Z40Cr14	420S45 EN 56D		F.3405-X46 Cr 13	
	1.4057	X20CrNi172	Z15CN16.02	431S29 EN 57	2321	F.3427-X15 CrNi16	431
	1.4104	X12CrMoS17	Z10CF17		2383	F.3117-X10 CrS17	430F
	1.4113	X6CrMo17	Z8CD17.01	434S17	2325		434
	1.4125	X105CrMo17	Z100CD17				440C
	1.4301	X5CrNi1810	Z6CN18.09	304S15 EN 58E	2332	F.3451-X5 CrNi18-10	304/304H
	1.4303	X5CrNi1812	Z8CN18.12	305S19		F.3513-X8CrNi.18-12	308;305
	1.4305	X10CrNiS189	Z10CNF18.09	303S21 EN 58M	2346	F.3508-X10CrNiS18-09	303
	1.4306	G-X2CrNi189/1911	Z2CN18.10/Z3CN19.10m	304S12/S11/C12	2333/52	F.3503-X 2CrNi19-10	304L



Material Cross Reference

Material Class	German	DIN	French	UK	Swedish	Spanish	USA
Stainless Steels	1.4308	G-X6CrNi189	Z6CN18.10M	304C15	2333		CF-8
	1.431	X12CrNi177	Z12CN17.07	301S21		F.3517-X12CrNi17 07	301
	1.4311	X2CrNiN1810	Z2CN18.10Az	304S62	2371		304LN
	1.4312	G-X10CrNi188	Z10CN18.9M	302C25			
	1.4313	G-X5CrNi134	Z4CND13.4M	425C11	2385		CA6-NM
	1.4401	X5CrNiMo17122	Z6CND17.11	316S16/S31 EN 58J	2347	F.3543-X5CrNiMo17-12/03	316/316L
	1.4404	X2CrNiMo17132	Z2CND18.13	316S11/S12	2348	F.3533-X 2CrNiMo17 12-03	316L
	1.4406	2CrNiMoN17122	Z2CND17.12Az	316S61			316LN
	1.4408	G-X6CrNiMo1810		316C16	2343	F.8414-AM-X7 CrNiMo20 10	CF-8M
	1.4429	X2CrNiMo17133	Z2CND17.13Az	316S62	2375		316LN
	1.4435	X2CrNiMo18143	Z2CND17.13	316S11/S12	2353	F.3533-Z 2 CrNiMo 17-12-03	316L
	1.4436	X5CrNiMo17133	Z6CND17.12	316S16	2343	F.3534-X 6 CrNiMo 17-12-03	316
	1.4438	X2CrNiMo18164	Z2CND19.15	317S12	2367		317L
	1.4449	X5CrNiMo1713		317S16			317
	1.4452	G-X5CrNiNb189	Z6NNb18.10M	347C17			
	1.446	X8CrNiMo275			2324	F.3309-X 8CrNiMo27-05	329
	1.451	X6CrTi17	Z8CT17			F.3114-X8CrTi17	XM8/430Ti
	1.4512	X5CrTi12	Z6CT12	409S19			409
	1.4541	X6CrNiTi1810	Z6CNT18.10	321S12/S31 EN 58B	2337	F.3553-X 7 CrNiTi 18-11	321
	1.4542	X5CrNiCuNb1714	Z6CNU17.04				630
	1.4546	X5CrNiNb1810		347S17/S18			348
	1.455	X6CrNiNb1810	Z6CNNb18.10	347S17/S31 EN 58F	2338	F.3552-X 7 CrNiNb 18-11	347
	1.4571	X6CrNiMoTi17122	Z6CNDT17.12	320S31/S17 EN58J	2350	F.3552-X 6 CrNiMoTi17-12-03	316Ti
	1.4573	X10CrNiMoTi1812		320S33			316Ti
	1.458	X6CrNiMoNb17122	Z6CNDNb17.12/19.13	318S17			316Cb
	1.4718	X45CrSi93	Z45CS9	401S45 EN52		F.3220-X 4 CrSi 09-03	HNv3
	1.4724	X10CrAl13	Z10C13	403S17		F.13152-X 10 CrAl13	
	1.4731	X40CrSiMo102	Z40CSD10			F.3221-X 40 CrSiMo 10-02	
	1.4742	X10CrAl18	Z10CAS18	430S15		F.3153-X 10 CrAl 18	430
	1.4747	X80CrNiSi20	Z80CSN20.02	443S65 EN 59		F.3222-X 80CrSiNi20-02	HNv6
	1.4762	X10CrAl24	Z10CAS24			F.3154-X 10 CrAl24	446
	1.4828	X15CrNiS2012	Z15CNS20.12	309S24			309
	1.4833	X7CrNi2314	Z15CN24.13	309S24			309S
	1.4837	G-X40CrNiSi2520		309C30			
	1.4841	X15CrNiSi2520	Z15CNS25.20			F.3310-X15 CrNiSi 25-20	314/310
	1.4845	X12CrNi2521	Z12CN25.20	310S24	2361	F.331	310S
	1.4848	G-X40CrNiSi2520		310C40		F.8452-AM-X 40 CrNi 25 20	HK
	1.4871	X53CrMnNiN219	Z5CMN21.09	349S54		F.3217-X 53 CrMnNi 21-09	EV8
	1.4873	X45CrNiW189	Z35CNWS14.14	331S40		F.3211-X45 CrNiSiW 28-09	
	1.4878	X12CrNiTi189	T6CNT18.12(B)	321S20	2337	F.3523-X 6CrNiTi 18 11	321
	1.5662	X8Ni9	Z8N9	1501-509;510		F.2645 - X 8 Ni 09	A353
	1.568	12Ni19	Z18N5				2515
Tool Steels	0.962	G-X260NiCr42		Grade2A			A532IBNiCr-LC
	0.9625	G-X330NiCr42		Grade2B			A532IANiCr-HC
	0.963	G-X300CrNiSi952		Grade2C;D;E			A532IDNi-HiCr
	0.964	G-X300CrMoNi152		Grade3A;B			
	0.9645	G-X260CrMoNi202		Grade3C			A532IID20%CrMo-LC
	0.965	G-X260Cr27		Grade3D			A532IIIA25%Cr
	0.9655	G-X300CrMo271		Grade3E			A532IIIA25%Cr
	1.1525	C80W1	Y190;Y180				W108
	1.1545	C105W1	Y1105		1880		W110
	1.1645	C105W2				F.5117 C102	
	1.1663	C125W	Y2120			F.5123 C120	W112
	1.1673	C135W	Y2140				
	1.175/1625	C75W/C80W1		BW1A/BW1B		F.1507 C80	W1
	1.2067	100Cr6	Y100C6	BL3		F.5230 100 Cr6	L3
	1.208	X210Cr12	Z200C12	BD3		F.5212 X210 Cr12	D3
	1.221	115CrV3					L2
	1.2343	X38CrMoV51	Z38CDV5	BH11		F.5317 X37 CrMoV5	H11
	1.2344	X40CrMoV51	Z40CDV5	BH13	2242	F.5318 X40 CrMoV5	H13
	1.2363	X100CrMoV51	Z100CDV5	BA2	2260	F.5227 X100 CrMoV5	A2
	1.2365	X32CrMoV33	Z32DCV28	BH10		F.5313 CrMoV 12	H10
	1.2379	X155CrVMo121	Z160CDV12	BD2			D2
	1.2419	105WCr6	105WC13			F.5233 105 WCr5	
	1.2436	X210CrW12			2312	F.5213 X210 CrW12	
	1.251	100MnCrW4		BO1	2140	F.5220 95 MnCrW5	O1
	1.2542	45WCrV7		BS1	2710	F.5241 45 WCrSi 8	S1
	1.255	60WCrV7	55WC20				
	1.2567	X30WCrV53	Z32WCV5				
	1.2581	X30WCrV93	Z30WCV9	BH21		F.5323 X30 WCrV9	H21
	1.2601	X165CrMoV12			2310	F.5211 X160 CrMoV12	
	1.2606	X37CrMoW51	Z35CWDV5	BH12			H12
	1.2713	55NiCrMoV6	55NCDV7			F.528	L6
	1.2833	100V1	Y1105V	BW2			W210
	1.2842	90MnCrV8	90MV8	BO2			2
	1.3202	S12-1-4-5		BT15		F.5563 12-1-5-5	T15





Material Cross Reference

Material Class	German	DIN	French	UK	Swedish	Spanish	USA
Tool Steels	1.3207	S10-4-3-10	Z130WKCDV10-10-04-03			F.553 10-4-3-10	
	1.3243	S6-5-2-5	Z85WDKCDV06-05-05-04-02		2723	F.5613 6-5-2-5	
	1.3246	S7-4-2-5	Z110WKCDV07-05-04-04-02			F.5613 6-5-2-5	M41
	1.3247	S2-10-1-8	Z110DKCWW09-08-04-02-01	BT42		F.5615 7-4-2-5	M42
	1.3249	S2-9-2-8		BM34		F.5611 2-9-2-8	M33/M34
	1.3255	S18-1-2-5	Z80WKCV18-05-04-01	BT4		F.5530 18-1-1-5	T4
	1.3265	S18-1-2-10		BT5		F.5540 18-0-2-10	T5
	1.3342	SC6-5-2	Z90WDCV06-05-04-03				M3
	1.3343	S6-5-2	Z85WDCV06-05-04-02	BM2	2722	F.5603 6-5-2	M2
	1.3344	S6-5-3	Z130WDCV06-05-04-04			F.5605 6-5-3	M3Class2
	1.3346	S2-9-1	Z85DCWV08-04-02-01	BM1			H41/M1
	1.3348	S2-9-2	Z100DCWV09-04-02-02		2782	F.5607 2-9-2	M7
	1.3355	S18-0-1	Z80WCV18-04-01	BT1		F.5520 18-0-1	T1
	1.3401	X120Mn12	Z120M12/Z120Mn12			F.82551-AM-X 120 Mn 12	A128(A)
	1.3505	100Cr6	100C6	534A99	2258	F.1310 – 100 Cr 6	52100
Hardened Steel				HARDOX 400/500/600			
Cast Aluminium	3.2151	G-AISI6Cu4	A-S5U	LM4-LM22	4230	L-2660	3,192
	3.2161	G-AISI8Cu3	A-S9U3	LM24	4252	L-2630	3,801
	3.2341	G-AISI5Mg	A-S4G	DTD716B			
	3.2371	G-AISI7Mg	A-S7GO,3	2L99/LM25	4244		A356.2
	3.2373	G-AISI9Mg	A7-S10G		4253		
	3.2381	G-AISI10Mg	A-S10G	LM9	4253	L-2560	A360
	3.2583	G-AISI12Cu	A-S12U	LM20	4260	L-2530	4,131
	3.3561	G-AIMg5	A-G6	LM5			5,141
	3.3581	G-AISI12	A-S13	LM6	4261	L-2520	A413
	3.3591	G-AIMg10	A-G10-Y4	LM10		L-2310	520
		AlSi17Cu4					390
		AlSi18-25CuNiMg		LM28/LM29			393
	3.0205	Al99	A4	1C	144010	L-3001	1200
	3.0255	Al99,5	A5	1B	144007	L-3051	1050A
Wrought Aluminium	3.0257	E-Al	A5/L	1E	144008	L-3052	1350A
	3.0275	Al99,7	A7		144005	L-3071	1070A
	3.0285	Al99,8	A8	1A	144004	L-3081	1080A
	3.0385	Al99,98R	A99	1			1199
	3.0505	AlMn0,5Mg0,5		N31			3105
	3.0525	AlMn1Mg0,5	A-M1G0,5				3005
	3.0526	AlMnMg1	A-M1G	N4		L-3820	3004
	3.0915	AlFeSi	A-FeS				8011A
	3.1255	AlCuSiMn	A-U4SG	H15	144338	L-3130	2014
	3.1305	AlCu2,5Mg0,5	A-U2G	3L86/HR13		L-3180	2117
	3.1325	AlCuMg1	A-U4G	H14		L-3120	2017A
	3.1355	AlCuMg2	A-U4G1	2L98		L-3140	2024
	3.1645	AlCuMgPb	A-U4Pb		144335	L-3121	2003
	3.1655	AlCuBiPb	A-U5PbBi	FC1	144355	L-3182	2011
	3.2305	E-AlMgSi		91E		L-3431	6101B
	3.2307	Al99,85MgSi	A85-GS	BTR6			6463
	3.2315	Al-Si1 Mg	A-SGMO,7	H30	144212	L-3451	6181
	3.3206	AlMGSi0,5		H9	144103	L-3441	6060
	3.3207	E-AlMgSi0,5	A-GS/L	BTRE6	144102		6101C
	3.3315	AlMg1	A-GO,6	N41	144106	L-3350	5005A
	3.3316	AlMg1,5	A-G1,5	3L44		L-3380	5050B
	3.3345	AlMg4,5					5082
	3.3523	AlMg2,5	A-G2,5C	N5Mg3,5	144120	L-3360	5052
	3.3525	AlMg2Mn0,3	A-G2M	N4			5251
	3.3535	AlMg3	A-G3M		144133	L-3390	5754
	3.3537	AlMg2,7Mn	A-G2,5MC	N51			5454
	3.3547	AlMg4,5Mn	5083	N8	144140	L-3321	5083
	3.3555	AlMg5		N6	144146	L-3320	5056A
	3.4335	AlZn4,5Mg1	A-Z5G	H17	144425	L-3741	7020
	3.4345	AlZnMgCu0,5	A-Z5Gu0,6				7022
	3.4365	AlZnMgCu1,5	A-Z5GU	2L95		L-3710	7075
SG/Nodular Cast Iron	0.704	GGG-40	FGS-400-12	420/12	0717-02		60-40-18
	0.7043	GGG-40.3	FGS370-17	370/17	0717-15		
	0.705	GGG-50	FGS500-7	500/7	0727-02		65-45-12
	0.706	GGG-60	FGS 600-3	600/3	0732-03		80-55-06
	0.707	GGG-70	FGS 700-2	700/2	0737-01		100-70-03
	0.708	GGG-80	FGS 800-2	800/2			120-90-02
	0.8035	GTW-35-04	MB 35-7	W 340/3			
	0.804	GTW-40-05	MB 40-10	W 410/4			
	0.8045	GTW-45-07					
	0.8135	GTS-35-10	MN 35-10	B 340/12	SIS 08 15-00		32510
	0.8145	GTS-45-06	MP 50-5	P 440/7	SIS 08 54-00		
	0.8155	GTS-55-04	MP 60-3	P 540/5	SIS 08 56-00		
	0.8165	GTS-65-02			SIS 08 62-03		
	0.817	GTS 70-02	MP 70-2	P 690/2	SIS 08 62-03		70 003



Material Cross Reference

Material Class	German	DIN	French	UK	Swedish	Spanish	USA
Grey/White Cast Iron	0.6025	GG25	Ft25D/FGL250	Grade 260	0125-00	FG 25	A48-40B
	0.601	GG10	Ft10D/FGL100		0110-00	FG 10	A48-20B
	0.6015	GG15	Ft15D/FGL150	Grade 150	0115-00	FG 15	A48-25B
	0.602	GG20	Ft20D-FGL200	Grade 220	0120-00	FG20	A48-30B
	0.603	GG30	Ft30D/FGL300	Grade 300	0130-00	FG 30	A48-45B
	0.6035	GG35	Ft35D/FGL350	Grade 350	0135-00	FG35	A48-50B
	0.604	GG40	Ft40D/FGL400	Grade 400	0140-00		A48-60B
Bronze Aluminium- Bronze Tin Bronze	2.0918	CuAl5As	CuAl6				C 60 800
	2.092	CuAl8	CuAl8				C 61 000
	2.0932	CuAl8Fe3	CuAl7Fe2	CA 106			C 61 400
	2.0936	CuAl10Fe3Mn2	CuAl9Fe3Mn2	CA 105			C 62 300
	2.094	CuA/10Fe	CuAl9Fe3	AB 1			C 95 200
	2.094	G-FeA/BzF50	CuAl9Fe3	AB 1			B 505
	2.096	CuAl9Mn2	CuAl9Mn2				
	2.0966	CuA/10Ni5Fe4	CuAl9Ni5Fe3Mn	CA 104			C 63 200
	2.097	G-NiABzF50	CuAl9Ni5Fe	AB 2			C 95 800
	2.0978	CuAl11NiFe5	CuAl11Ni5Fe5				
	2.1188	G-CuPb20Sn	CuPb20Sn5	LB5			C 94100
Brass	2.022/2.032	CuZn5	CuZn5	CZ 125/101			C 21000/34500
	2.034	G-CuZn37Pb	CuZn40-Y30	PCB 3			C 85700
	2.036/2.041	CuZn40/44Pb2	CuZn40/44Pb2	CZ 109/CZ130			C 28000/38500
	2.046	CuZn20Al2	CuZn22Al2	CZ 110			C 68700
	2.047	CuZn28Sn1		CZ 111			C 44300
	2.053	CuZn38Sn1		CZ 112			C 46400
	2.055	CuZn40Al2		CZ 114			C 67400
	2.0591	G-CuZn38Al		PCB1, DCB 3			C 86400
	2.0592	G-CuZn35Al1	CuZn40-Y30	HTB 1			C 86400
	2.0596	G-CuZn34Al2					C 86200
	2.0598	G-CuZn25Al5		HTB 3			C 86300
	2.105	G-CuSn10Zn		G1			C 90500
	2.1052	G-CuSn12	CuSn12	Pb2			C 90800
	2.106	G-CuSn12Ni		CT2			C 91700
	2.1086	G-CuSn10		CT1			C 90250
	2.109	G-CuSn7ZnPb	CuSn7Pb6Zn4				C 93200
	2.1093	G-CuSn6ZnNi		LG4			C 92410
	2.1096	G-CuSn5ZnPb/RG5	CuPb5Sn5Zn5	LG2			C 83600
	2.1176	G-CuPb10Sn	CuPb10Sn10	LB2			C 93700
	2.1182	G-CuPb15Sn		LB1			C 93800
	2.1293	CuCrZr		CC 102			C 18100
Copper Copper/ Nickel Alloys	2.0815	G-CuNi10					C 96200
	2.083	CuNi25	CiNi25	CN 105			C 71300
	2.0835	G-CuNi30		CN 2			C 96400
	2.0842	CuNi44Mn1	CuNi44				C 72150
	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN 102			C 70600
	2.0882	CuNi30Mn1Fe	CuNi30Mn1Fe	CN 107			C 71500
	2.1245	CuBe1,7	CuBe1,7	CB 101			C 17000
	2.1247	CuBe2	CuBe1,9				C 17200
	2.1285	CuCo2Be		C112			C 17500
	2.131	CuFe2P					C 19400
		CuNi9Sn2					C 72500
		CuNi30Fe2Mn2	CuNi30Fe2Mn2	CN 108			C 71640
	2.004	OF-Cu	Cu-c1/C2	Cu-OF C 103/110			OF
	2.006	E-Cu57	Cu-a1/A2	Cu-ETP-2 C 101			C 11000
	2.0065	E-Cu58	Cu-a1	Cu-ETP-2 C 101			C 11000
	2.007	Se-Cu					C 10300
	2.0076	SW-Cu	Cu-b2				C 1200
	2.009	SF-Cu	Cu-b1	Cu-DHP C 106			C 12200
	2.1191	Cu-Ag 0,1P					C 10700
	2.1203	Cu-AG 0,1		CuAg-4			C 11600

P	M	K	N	S	H
Steel N/mm ²	Stainless Steel N/mm ²	Cast and Ductile Iron N/mm ²	Non-ferrous Material N/mm ²	High Temperature Materials N/mm ²	Hardened Materials N/mm ²
<1365	<940	<1020	<855	<990	<1365



Problem and Solutions

	Use of Standard & Extended Holders	Starting on an inclined surface	Worn or mis-aligned spindle	Use of low rigidity spindle	Poor work piece support
Accelerated corner wear			2,6,7		
Spiral or large diameter at hole start	1,2,3,4,27		2,6,7,27	2,4,8,27	10,26,27
Insert Chipping				2,4,8,9	8,9,10,26
Blue Chips					
Built Up Edge (BUE)					
Chatter	1,2,3,4,27	1,3,4,5	2,6,7	2,4,8	8,10,26
Chip Packing					
Chipping of point	1,2,3,4,27	1,3,4,5	2,6,7	2,4,8,9	
Damaged or broken tools		1,3,4,5	2,6,7	2,4,8,9	8,9,10
Excessive margin wear		1,3,4,5	2,6,7		8,9,10
High flank wear					
Hole lead off	1,2,3,4,27	1,3,4,5	2,6,7,27	2,4,8	
Hole out of position	1,2,3,4,27			2,4,8	
Hole out of round		1,3,4,5			8,10,26,27
Notching of insert					
Oversize hole			2,6,7,27		
Poor hole finish			2,6,7		8,10
Poor tool life					
Power Fluctuation of load metre					
Retraction spiral	1,2,3,4,27	1,3,4,5	2,6,7	2,4,8	8,9,10,27
Step burnt on insert					

Solutions

1. Use a short holder to drill a pilot hole 1 x D deep.
2. Spot hole with stub tool of same or greater included angle as T-A insert.
3. Decrease feed minimum 50% until full diameter established.
4. Use special holder with wear pads or chrome bearing area to work with drill bushing.
5. Spot face to provide flat entry surface.
6. Align spindle or turret or tailstock.
7. Repair spindle.
8. Reduce penetration rate to fall within physical limits of machine set up, but do not fall below feed threshold required to form a chip or speed threshold to cut material.
9. Use tougher grade tool steel with high wear resistant coating (i.e. if using Premium Cobalt (PC) use Super Cobalt. If using Super Cobalt use CPM-M4
10. Provide additional support for the workpiece.
11. Run coolant through holder when drilling greater than 1xD
12. Increase coolant volume and pressure through the holder
13. Reduce penetration rate to fall within coolant limitations, but do not fall below feed threshold required to form a chip or speed threshold to cut material
14. Add peck cycle to clear chips, do not remove insert from hole during peck

External coolant-Low pressure/Volume	Interrupted Cuts	Drilling hardened materials	Poor material microstructure	Poor chip control	Spot drilled holes	High wear resistant tool grades
11,12,13,19		12,18,19,20			2,23	
	2,15,16,17,4,9		9,20,21,22,23		2,23	9,26
11,12,13		12,18,19,20				
11,12,13		12,13,18,19,20	9,20,21,23			
	2,4,15,16,17				2,23	
11,12,13,14				12,14,19,24,25		
	2,9,15,16,17					
9,11,12,13,14	2,4,15,16,17	12,18,19,20	9,20,21,23	12,19,24,25		9,26
	2,15,16,17			12,19,24,25		
11,12,13,19,20		12,18,19,20	9,20,21,23			
	2,4,15,16,17,27		9,20,21,23	12,19,24,25	2,23,27	
	2,4,15,16,17,27					
	2,4,15,16,17					
			9,20,21,23		2,23	
11,12,13,14	2,15,16,17			12,19,24,25,27		
11,12,13,14	2,15,16,17			12,19,24,25		
11,12,13,14,19,20	2,15,16,17	12,18,19,20	9,20,21,23	12,14,19,24,25	2,23	
11,12,13,14				12,19,24,25		
11,12,13,18,20		12,18,19,20				

- Pre-mill or spot face entry or exit to remove interruption.
- Decrease feed up to 50% through entry or exit interruption using Nyloc screws to retain insert.
- Use short holders in low impact entry cuts.
- Reduce speed if a step or burn diameter is worn on insert. Calculate the speed at worn diameter, reduce this velocity by 10% and apply to original tool diameter.
- Improve quality and condition of coolant (water soluble preferred at 7-8% dilution with EP additive).
- Use more heat and wear resistant tool grade. If using CPM-M4 use Super Cobalt. If using Super Cobalt, use Premium Cobalt. If using Premium Cobalt, use Carbide (if micro structure problems present). Use most wear resistant coating - TiCN / TiAlN / AM200®.
- Anneal or normalise parts if all cutting tools exhibiting poor tool life.
- For hard spots, use tougher grade tool steel with high wear resistant coating (i.e. If using Premium Cobalt (PC) use Super Cobalt. If using Super Cobalt, use CPM-M4).
- Reduce feed, but not below threshold of good chip formation.
- Increase feed to recommended levels.
- Contact AMEC or use one of chip enhancement geometries page at front of catalogue.
- Increase rigidity of set up.
- Use AMEC's Notch Point Geometry.



Tap Drill Information

METRIC – m – Profile Screw Thread						
Tap Size	Tap Drill Size	Decimal Equivalent	* Theo % Thread	Probable Mean Oversize	Probable Hole Size	** Probable % Thread
12 x 1.75	10.2mm	.4016"	79%	0.075mm	10.28mm	76%
	$\frac{13}{32}$ "	.4063"	74%	0.075mm	10.40mm	71%
12 x 1.25	$\frac{27}{64}$ "	.4219"	79%	0.075mm	10.79mm	74%
	10.8mm	.4252"	74%	0.075mm	10.88mm	69%
14 x 2.0	$\frac{15}{32}$ "	.4688"	81%	0.075mm	11.98mm	78%
	12.0mm	.4724"	77%	0.075mm	12.08mm	74%
14 x 1.5	12.5mm	.4921"	77%	0.075mm	12.58mm	73%
16 x 2.0	14.0mm	.5512"	77%	0.075mm	14.08mm	74%
16 x 1.5	14.5mm	.5709"	77%	0.075mm	14.58mm	73%
	$\frac{37}{64}$ "	.5781"	68%	0.075mm	14.76mm	64%
18 x 2.5	15.5mm	.6102"	77%	0.075mm	15.58mm	75%
18 x 1.5	16.5mm	.6496"	77%	0.075mm	16.58mm	73%
	$\frac{21}{32}$ "	.6563"	68%	0.075mm	16.75mm	64%
20 x 2.5	$\frac{11}{16}$ "	.6875"	78%	0.075mm	17.54mm	76%
	17.5mm	.6890"	77%	0.075mm	17.58mm	74%
20 x 1.5	18.5mm	.7283"	77%	0.075mm	18.58mm	73%
	$\frac{47}{64}$ "	.7344"	69%	0.075mm	18.66mm	65%
22 x 2.5	$\frac{49}{64}$ "	.7656"	79%	0.075mm	19.52mm	76%
	19.5mm	.7677"	77%	0.075mm	19.58mm	75%
22 x 1.5	20.5mm	.8071"	77%	0.075mm	20.58mm	73%
	$\frac{13}{16}$ "	.8125"	70%	0.075mm	20.71mm	66%
24 x 3	$\frac{13}{16}$ "	.8125"	86%	0.075mm	20.71mm	84%
	21.0mm	.8268"	76%	0.075mm	21.08mm	75%
24 x 2	22.0mm	.8661"	77%	0.075mm	22.08mm	74%
	$\frac{7}{8}$ "	.8750"	68%	0.075mm	22.30mm	65%
27 x 3	24.0mm	.9449"	77%	0.075mm	24.08mm	75%

* Based on nominal tap drill diameter.

** Based on 0.075mm probable mean oversize

To Calculate % of full thread for a given hole Ø:

$$\% \text{ Thread} = \frac{76.93}{\text{Pitch (mm)}} \times (\text{Basic major } \varnothing \text{ mm} - \text{Drill hole size mm})$$

Taper Pipe Thread (BSP & ISO 7-1)						
Tap Size	Tap Drill Size	Decimal Equivalent	* Theo % Thread	Probable Mean Oversize	Probable Hole Size	** Probable % Thread
$\frac{1}{4}$ " - 19	$\frac{7}{16}$ "	.4325"	N/A	0.075mm	11.19mm	N/A
$\frac{3}{8}$ " - 19	$\frac{37}{64}$ "	.5781"	N/A	0.075mm	14.76mm	N/A
$\frac{1}{2}$ " - 14	$\frac{23}{32}$ "	.7188"	N/A	0.075mm	18.33mm	N/A
$\frac{3}{4}$ " - 14	$\frac{15}{16}$ "	.9375"	N/A	0.075mm	23.89mm	N/A

The above tap drill information represents probable thread percentages for the standard tap drills stocked at AMEC®. Special blade diameters may be required in order to meet a user specific percentage of thread requirements.

The 0.075mm probable mean oversize hole condition is based on optimum cutting conditions. Probable % of full thread may vary based on less ideal cutting conditions.