



**ALLIED MACHINE  
& ENGINEERING**

**WOHLHAUPTER®**

Holemaking Solutions for Today's Manufacturing



Boring



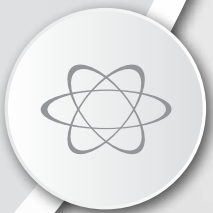
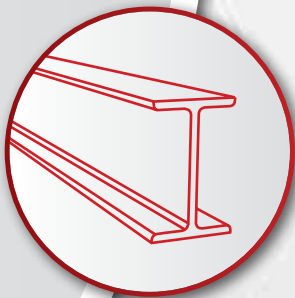
Reaming



Burnishing



Threading



Specials



## Structural Steel Solutions

### ► DRILLING

Replaceable Insert Drills

## North America

### Allied Machine

120 Deeds Drive  
Dover, OH 44622  
United States

### Allied Machine

485 West 3rd Street  
Dover, OH 44622  
United States

### ThreadMills USA™

4185 Crosstowne Ct #B  
Evans, GA 30809  
United States

### Superion™

1285 S Patton St.  
Xenia, OH 45385  
United States

## Europe

### Allied Machine Europe

93 Vantage Point  
Pensnett Estate  
Kingswinford  
West Midlands  
DY6 7FR, United Kingdom

### Wohlhaupter® GmbH

Maybachstrasse 4  
72636 Frickenhausen  
Germany

## Asia

### Wohlhaupter® India

B-23, 2nd Floor  
B Block Community Centre  
Janakpuri, New Delhi - 110058  
India



Allied Machine & Engineering is a worldwide leader in holmaking and finishing solutions. We are committed to providing practical and dependable solutions to our customers through innovative designs and superior customer and technical support.

We continue to expand our product offering in order to provide new and different solutions. With Field Sales Engineers located around the world, we position ourselves to provide technical support on site, right at your spindle.



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& ENGINEERING**

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Holmaking Solutions for Today's Manufacturing

[www.alliedmachine.com](http://www.alliedmachine.com)

## The Foundation

Since 1941, Allied Machine & Engineering has provided dependable and practical holemaking solutions to the world. What was once a small job shop in Ohio is now a worldwide leader in cutting tool technology. With three manufacturing facilities in Ohio, one in Georgia, another in Germany and headquarters in both the United States and Europe, Allied Machine is positioned to bring innovative solutions and technical expertise directly to the customers' hands.



## The Beginning

Harold E. Stokey founded Allied Machine & Engineering to aid the war effort, manufacturing taper bearing lock nuts for the production of M1 tanks. Years later, after a sales meeting gone wrong, Stokey possessed a warehouse stocked with spade drill inserts. He set forth into the industry that would become Allied Machine's thriving identity: holemaking.



## The T-A®

When Harold's son, William H. Stokey, became the president and CEO, he developed the Throw Away, or T-A®, spade drill insert system. The T-A® revolutionised the holemaking industry, launching Allied Machine ahead of the competition. Since then, numerous innovations and advancements have been created from the T-A®'s inspiration.



## The Innovation

Since the development of the T-A®, Allied Machine has expanded its product offering to support a vast range of customer applications, including large diameter and deep hole drilling, boring, reaming, burnishing, porting and threading.

## The People

Allied Machine understands that high quality products are only one facet of success. Our customer support is crucial to what we do and that's why we make sure the best engineers and customer service associates are in place to assist our customers around the world.

## The Future

With over 75 years of experience, Allied Machine has encountered the challenges of growth and success. By investing in cutting edge technology and the brightest and sharpest minds, our knowledge and capabilities continue to expand and grow every day.



**Steve Stokey**

Executive Vice President  
Allied Machine & Engineering Corp.

**Frank-M. Wohlhaupter**

Managing Director  
Wohlhaupter GmbH

**Paul Crawford**

Managing Director  
AMEC Europe

**Mike Stokey**

Executive Vice President  
Allied Machine & Engineering Corp.

Allied Machine Dover, OH, USA



Wohlhaupter GmbH, Frickenhausen, Germany



Allied Machine Europe, Kingswinford, UK



**ALLIED MACHINE  
& ENGINEERING**

Holemaking Solutions for Today's Manufacturing

**WOHLHAUPTER**



**SUPERION**

**CRITERION**

# Structural Steel Drilling Solutions

Replaceable Insert Drilling System | GEN3SYS® XT Pro ST | T-A® Original and GEN2 T-A® Structural Steel

▶ GEN3SYS®XT Pro ST and XT ST Diameter Range: 12.00mm - 35.00mm (0.4331" - 1.3780")

▶ T-A® Structural Steel Diameter Range: 12.98mm - 47.80mm (0.511" - 1.882")



## Take on Tough Drilling

Allied Machine's Structural Steel Drilling System is designed for maximum performance in structural steel materials and applications. These solutions utilise the GEN3SYS XT Pro, XT ST, T-A Original, and GEN2 T-A Structural Steel designs and capabilities.

With multiple geometries and coatings, you're sure to find the solution that is right for you. Tough drilling is tough no more.

Excellent chip control	Improves hole quality and surface finish	Provides maximum durability and stability
------------------------	--	---

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

### **WARNING**

**WARNING** (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

**NOTICE** means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

**NOTE** and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

Visit [www.alliedmachine.com](http://www.alliedmachine.com) for the most up-to-date information and procedures.

## Applicable Industries

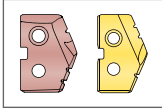


Structural Steel

## Structural Steel Drilling Solutions Contents

### Reference Icons

The following icons will appear throughout the catalog to help you navigate between products.



#### Corresponding T-A Inserts

Refers to the corresponding T-A insert items that connect with each specific holder series



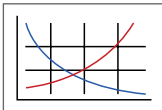
#### Corresponding T-A Holders

Refers to the corresponding T-A holder items that connect with each specific insert series



#### Setup / Assembly Information

Detailed instructions and information regarding the corresponding part(s)



#### Recommended Cutting Data

Speed and feed recommendations for optimum and safe drilling

### GEN3SYS® XT AND XT Pro System

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### T-A® Drilling System

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Series	GEN3SYS XT Pro ST Diameter Range	
	Metric (mm)	Imperial (inch)
12	12.00 - 12.99	0.4724 - 0.5117
13	13.00 - 13.99	0.5118 - 0.5511
14	14.00 - 14.99	0.5512 - 0.5905
15	15.00 - 15.99	0.5906 - 0.6298
16	16.00 - 16.99	0.6299 - 0.6692
17	17.00 - 17.99	0.6693 - 0.7086
18	18.00 - 19.99	0.7087 - 0.7873
20	20.00 - 21.99	0.7874 - 0.8660
22	22.00 - 23.99	0.8661 - 0.9448
24	24.00 - 25.99	0.9449 - 1.0235
26	26.00 - 28.99	1.0236 - 1.1416
29	29.00 - 31.99	1.1417 - 1.2597
32	32.00 - 35.00	1.2598 - 1.3780

Series	T-A Structural Steel Diameter Range	
	Metric (mm)	Imperial (inch)
0	12.98 - 17.65	0.511 - 0.695
1	17.53 - 24.38	0.690 - 0.960
2	24.41 - 35.05	0.961 - 1.380
3	34.36 - 47.80	1.353 - 1.882



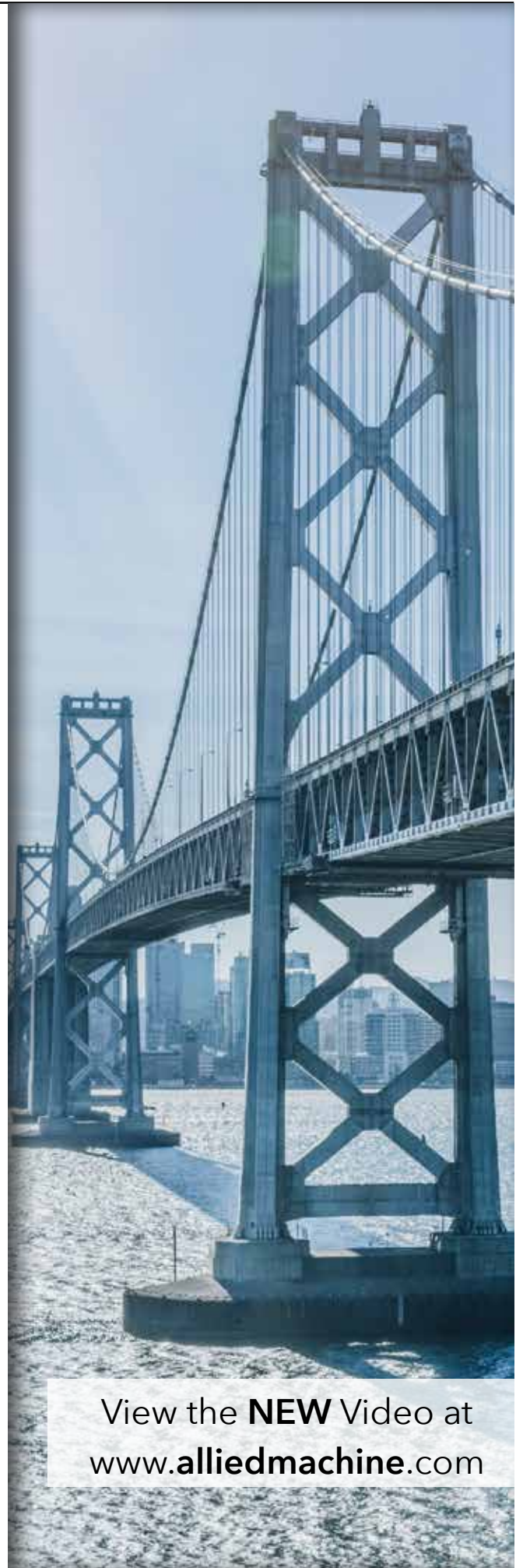
## GEN3SYS® XT Pro ST Structural Steel Drilling System

# GEN3SYS® XT PRO *ST*

## REPLACEABLE TIP HIGH PENETRATION STRUCTURAL STEEL *SOLUTION*

The challenge of drilling structural steel materials is about to get a whole lot easier. Developed through a rigorous and thorough testing process, the modified and improved XT Pro ST is a product of innovation.

Achieve the **consistent performance** you need and exceed your current parameters.



View the **NEW** Video at  
[www.alliedmachine.com](http://www.alliedmachine.com)

GEN3SYS® XT ST and Pro ST

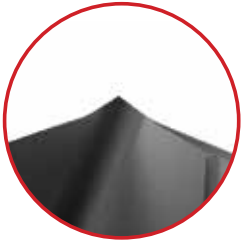
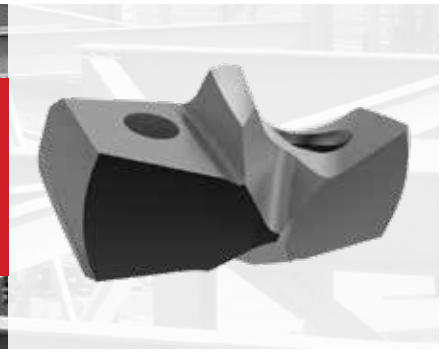
T-A® Structural Steel

Cutting Data & Guaranteed Application Forms

GEN3SYS® XT Pro ST Structural Steel Drilling System

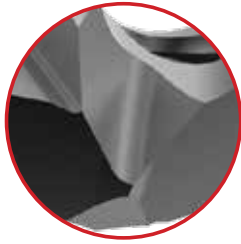


GEN3SYS® XT Pro **ST**  
STRUCTURAL STEEL ENHANCEMENTS



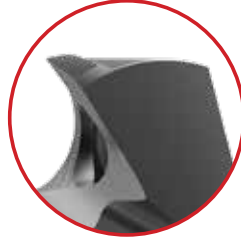
**New Point Design**

Increases stability without hindering penetration



**Redesigned Insert**

Provides consistent performance and adds durability



**Improved Geometry**

Extends tool life and increases insert strength without increasing horsepower consumption



**AM420**

**AM420 Coating**

Increases heat threshold and extends tool life

**Get the Consistency You Need**

The challenge of drilling structural steel materials is about to get a whole lot easier. Developed through a rigorous and thorough testing process, the modified and improved XT ST insert is a product of innovation.

Achieve the **consistent performance** you need while matching or even exceeding your current parameters.

**Tough Drilling is Tough No More**

Structural steel applications can prove to be difficult to machine, so you need a drill that's been put through the fire to ensure it can conquer those challenging applications.

Rigorous testing and countless hours of design and programming make the XT Pro ST the optimal drill for structural steel applications.

- Diameter range: 12mm - 35mm
- Holders available in 3xD, 5xD, and 7xD lengths
- Flanged shank with flat
- Through Tool Coolant
- Fits on to existing GEN3SYS®XT ST holders



3xD

5xD

7xD



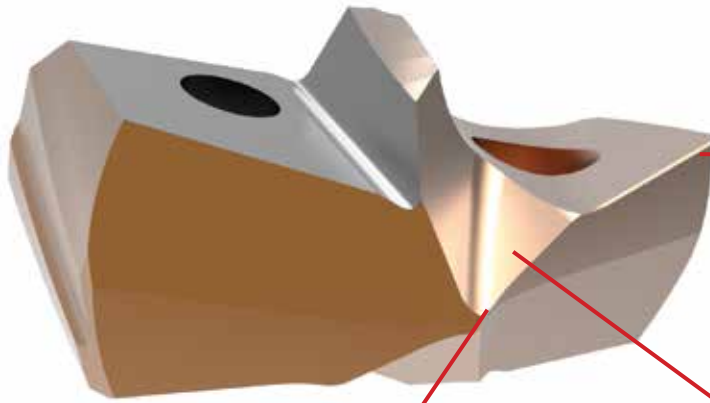
**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.



# GEN3SYS® XT Structural Steel Drilling System

## STRUCTURAL STEEL

## GEN3SYS® XT ST



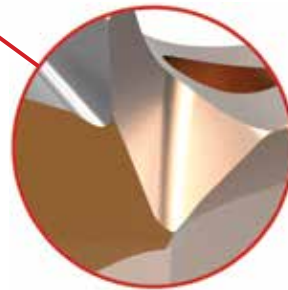
Available in AM300® Coating



**Improved Radial Rake**  
Improves chip control



**Spur Point**  
Increases stability



**Improved Notch Point**  
Reduces lead-off



### Holder Anatomy

1. Flanged Shank with Flat
2. Coolant Inlet
3. Flute (straight only)
4. Coolant Outlets



Straight Flute

**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.





## Structural Steel Drilling

### Achieving Optimal Results in Structural Steel

Drilling in structural steel materials can be a difficult process, and achieving optimal results becomes a major issue. Allied Machine's structural steel drilling solutions have been specifically designed to produce the best results in the toughest materials. With solutions in both the T-A® and GEN3SYS® XT Pro product lines, you have multiple options to solve your application problems.



### Insert Style Comparison

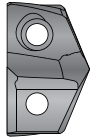
	 GEN3SYS® XT Pro ST GEN3SYS®XT ST	 Original T-A® Thin Wall	 Original T-A® Notch Point®	 Original T-A® 150° Structural Steel	 GEN2 T-A® High Efficiency
High penetration	<input checked="" type="checkbox"/>				
Material less than 6mm thick		<input checked="" type="checkbox"/>			
Material over 6mm thick	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Reduced exit burr			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Includes Notch Point® geometry			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Available from carbide	<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>
Stocked in common sizes for the Structural Steel industry	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>



## GEN3SYS® XT Pro ST / GEN3SYS® XT ST Drill Insert Nomenclature

### GEN3SYS®XT Pro Drill Inserts

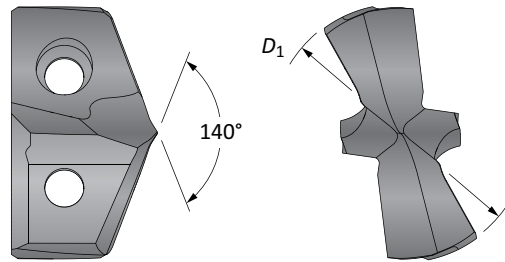
<b>XT</b>	<b>ST</b>	<b>20</b>	-	<b>20.00</b>
1	2	3		4



1. XT Pro ST Drill Insert	2. Geometry	3. Series	4. Diameter (mm)															
XT = XT Pro insert	ST = Structural Steel	<table border="0"> <tr> <td>12 = 12 series</td> <td>17 = 17 series</td> <td>26 = 26 series</td> </tr> <tr> <td>13 = 13 series</td> <td>18 = 18 series</td> <td>29 = 29 series</td> </tr> <tr> <td>14 = 14 series</td> <td>20 = 20 series</td> <td>32 = 32 series</td> </tr> <tr> <td>15 = 15 series</td> <td>22 = 22 series</td> <td></td> </tr> <tr> <td>16 = 16 series</td> <td>24 = 24 series</td> <td></td> </tr> </table>	12 = 12 series	17 = 17 series	26 = 26 series	13 = 13 series	18 = 18 series	29 = 29 series	14 = 14 series	20 = 20 series	32 = 32 series	15 = 15 series	22 = 22 series		16 = 16 series	24 = 24 series		For complete list of diameter ranges by series, see contents page.
12 = 12 series	17 = 17 series	26 = 26 series																
13 = 13 series	18 = 18 series	29 = 29 series																
14 = 14 series	20 = 20 series	32 = 32 series																
15 = 15 series	22 = 22 series																	
16 = 16 series	24 = 24 series																	

#### Reference Key

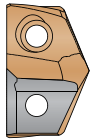
Symbol	Attribute
$D_1$	Insert diameter



Sizes not shown are available upon request.	
When ordering, please follow the example below:	
<b>Metric:</b>	20.10mm, 20 series = use Part No. <b>XTST20-20.10</b>
<b>Imperial:</b>	0.7913", 20 series = use Part No. <b>XTST20-20.10</b>

### GEN3SYS®XT ST Drill Inserts

<b>7</b>	<b>C2</b>	<b>14</b>	<b>P</b>	-	<b>0018</b>	<b>ST</b>
1	2	3	4		5	6

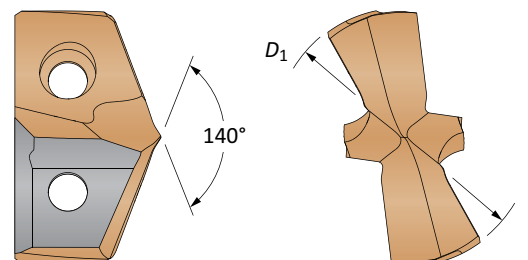


1. XT Drill Insert	2. Insert Material	3. Series	4. Coating												
7 = XT insert	C2 = K20 (C2) carbide	<table border="0"> <tr> <td>12 = 12 series</td> <td>17 = 17 series</td> <td>24 = 24 series</td> </tr> <tr> <td>14 = 14 series</td> <td>18 = 18 series</td> <td>26 = 26 series</td> </tr> <tr> <td>15 = 15 series</td> <td>20 = 20 series</td> <td>29 = 29 series</td> </tr> <tr> <td>16 = 16 series</td> <td>22 = 22 series</td> <td>32 = 32 series</td> </tr> </table>	12 = 12 series	17 = 17 series	24 = 24 series	14 = 14 series	18 = 18 series	26 = 26 series	15 = 15 series	20 = 20 series	29 = 29 series	16 = 16 series	22 = 22 series	32 = 32 series	P = AM300®
12 = 12 series	17 = 17 series	24 = 24 series													
14 = 14 series	18 = 18 series	26 = 26 series													
15 = 15 series	20 = 20 series	29 = 29 series													
16 = 16 series	22 = 22 series	32 = 32 series													

5. Diameter	6. Geometry
18 = Metric 0102 = Inch	ST = Structural steel

#### Reference Key

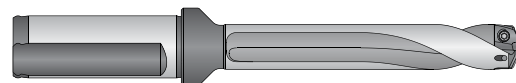
Symbol	Attribute
$D_1$	Insert diameter



## GEN3SYS® XT Structural Steel Drill Holder Nomenclature

### GEN3SYS®XT Structural Steel Drill Holders

<b>ST</b>	<b>03</b>	<b>12</b>	<b>0</b>	-	<b>20</b>	<b>FM</b>
1	2	3	4		5	6

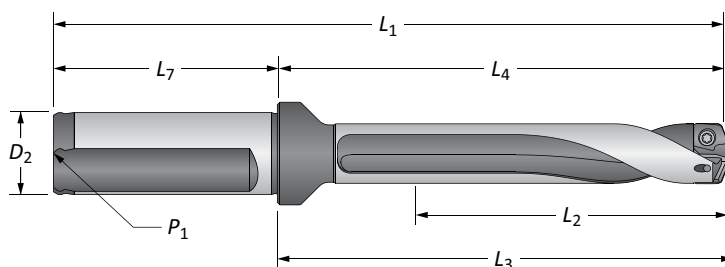


<b>1. Holder</b> ST = Structural steel holder	<b>2. Length</b> 03 = 3x Diameter 05 = 5x Diameter 07 = 7x Diameter	<b>3. Series</b> 12 = 12 series    17 = 17 series    26 = 26 series 13 = 13 series    18 = 18 series    29 = 29 series 14 = 14 series    20 = 20 series    32 = 32 series 15 = 15 series    22 = 22 series 16 = 16 series    24 = 24 series	<b>4. Body Diameter</b> 0 = Standard 5 = Oversized
--	--	--	--

<b>5. Shank Diameter</b> <table border="1"> <thead> <tr> <th colspan="2">Metric (mm)</th> <th colspan="2">Imperial (in)</th> </tr> </thead> <tbody> <tr> <td>16 = 16mm</td> <td>32 = 32mm</td> <td>063 = 5/8"</td> <td>125 = 1-1/4"</td> </tr> <tr> <td>20 = 20mm</td> <td>40 = 40mm</td> <td>075 = 3/4"</td> <td>150 = 1-1/2"</td> </tr> <tr> <td>25 = 25mm</td> <td></td> <td>100 = 1"</td> <td></td> </tr> </tbody> </table>	Metric (mm)		Imperial (in)		16 = 16mm	32 = 32mm	063 = 5/8"	125 = 1-1/4"	20 = 20mm	40 = 40mm	075 = 3/4"	150 = 1-1/2"	25 = 25mm		100 = 1"		<b>6. Shank Style</b> F = Flanged with flat FM = Flanged metric with flat C = Cylindrical (no flat) CM = Cylindrical metric (no flat)
Metric (mm)		Imperial (in)															
16 = 16mm	32 = 32mm	063 = 5/8"	125 = 1-1/4"														
20 = 20mm	40 = 40mm	075 = 3/4"	150 = 1-1/2"														
25 = 25mm		100 = 1"															

#### Reference Key

Symbol	Attribute
$D_2$	Shank diameter
$L_1$	Overall length
$L_2$	Drill depth
$L_3$	Holder reference length
$L_4$	Holder body length
$L_7$	Shank length
$P_1$	Rear pipe tap





**NOTICE:** GEN3SYS®XT Structural Steel Holders are suitable for both GEN3SYS®XT Pro ST and GEN3SYS®XT ST Inserts ONLY.

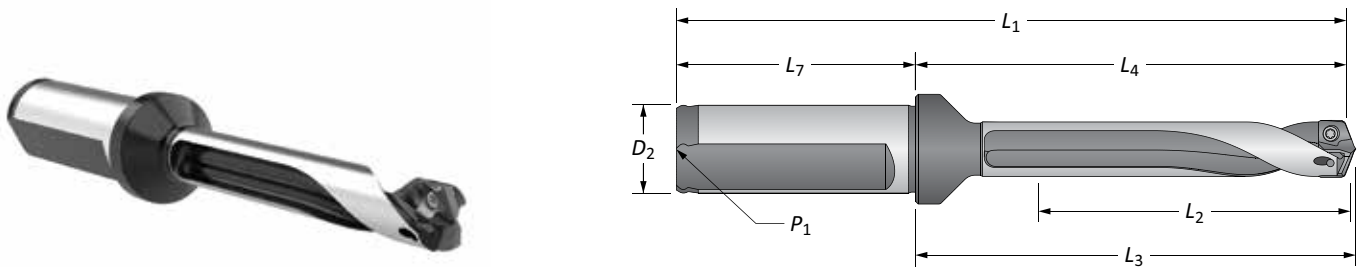
**GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System**

12 Series | Diameter Range: 12.00mm - 12.99mm (0.4724" - 0.5117")



**Inserts**

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
12.00	0.4724	-	XTST12-12.00	7C212P-12ST




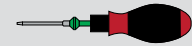



**Holders**

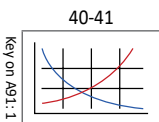
Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b> 3xD	39.0	66.6	68.6	116.6	50	20	3.18*	YES	ST03120-20FM
5xD	65.0	92.6	94.8	142.6	50	20	3.18*	YES	ST05120-20FM
7xD	91.0	118.5	120.8	168.5	50	20	3.18*	YES	ST07120-20FM
<b>i</b> 3xD	1-17/32	2-5/8	2-45/64	4-21/32	2-1/32	3/4	1/8	YES	ST03120-075F
5xD	2-9/16	3-41/64	3-47/64	5-43/64	2-1/32	3/4	1/8	YES	ST05120-075F
7xD	3-37/64	4-43/64	4-3/4	6-45/64	2-1/32	3/4	1/8	YES	ST07120-075F

\*Thread to BSP and ISO 7-1

**Connection Accessories**

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

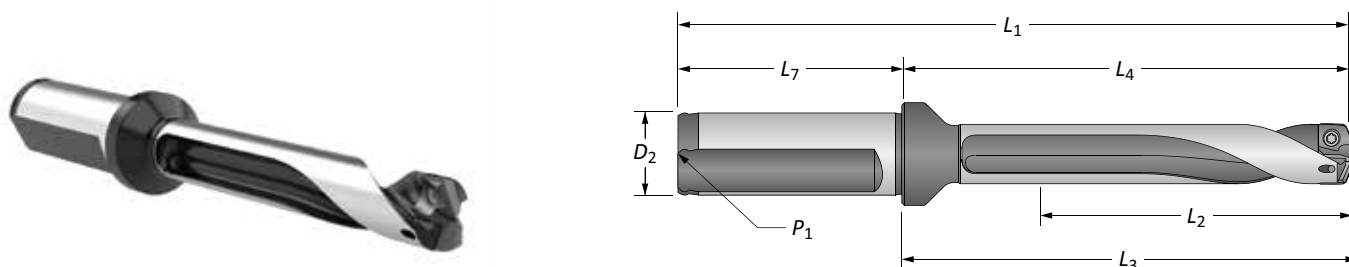
## GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System

13 Series | Diameter Range: 13.00mm - 13.99mm (0.5118" - 0.5111")



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
13.00	0.5118	-	XTST13-13.00	7C212P-13ST








### Holders

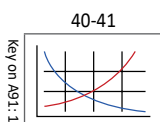
	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b>	3xD	39.0	66.6	68.6	116.6	50	20	3.18*	YES	ST03120-20FM
	5xD	65.0	92.6	94.8	142.6	50	20	3.18*	YES	ST05120-20FM
	7xD	91.0	118.5	120.8	168.5	50	20	3.18*	YES	ST07120-20FM
<b>i</b>	3xD	1-17/32	2-5/8	2-45/64	4-21/32	2-1/32	3/4	1/8	YES	ST03120-075F
	5xD	2-9/16	3-41/64	3-47/64	5-43/64	2-1/32	3/4	1/8	YES	ST05120-075F
	7xD	3-37/64	4-43/64	4-3/4	6-45/64	2-1/32	3/4	1/8	YES	ST07120-075F

\*Thread to BSP and ISO 7-1

### Connection Accessories

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



**m** = Metric (mm)  
**i** = Imperial (in)



Inserts sold in multiples of 1 | Screws sold in multiples of 10

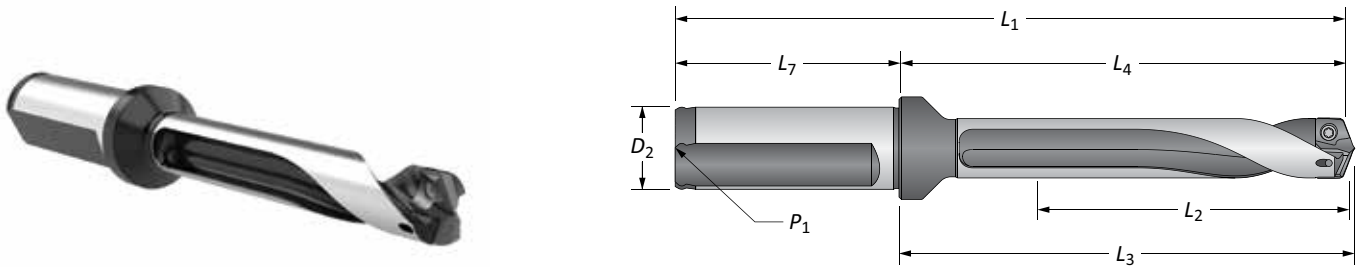
**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

**GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System**

14 Series | Diameter Range: 14.00mm - 14.99mm (0.5512" - 0.5905")


**Inserts**






Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
14.00	0.5512	–	<b>XTST14-14.00</b>	<b>7C214P-14ST</b>
14.29	0.5625	9/16	<b>XTST14-14.29</b>	<b>7C214P-0018ST</b>

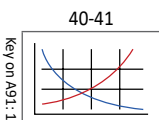

**Holders**

	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b>	3xD	45.0	72.4	75.0	122.4	50	20	3.18*	YES	<b>ST03140-20FM</b>
	5xD	75.0	102.4	104.9	152.4	50	20	3.18*	YES	<b>ST05140-20FM</b>
	7xD	104.9	132.3	134.9	182.3	50	20	3.18*	YES	<b>ST07140-20FM</b>
<b>i</b>	3xD	1-25/32	2-27/32	2-61/64	4-7/8	2-1/32	3/4	1/8	YES	<b>ST03140-075F</b>
	5xD	2-61/64	4-1/32	4-1/8	6-1/16	2-1/32	3/4	1/8	YES	<b>ST05140-075F</b>
	7xD	4-9/64	5-13/64	5-5/16	7-15/64	2-1/32	3/4	1/8	YES	<b>ST07140-075F</b>

\*Thread to BSP and ISO 7-1

**Connection Accessories**

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

 \*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength

**m** = Metric (mm)

**i** = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

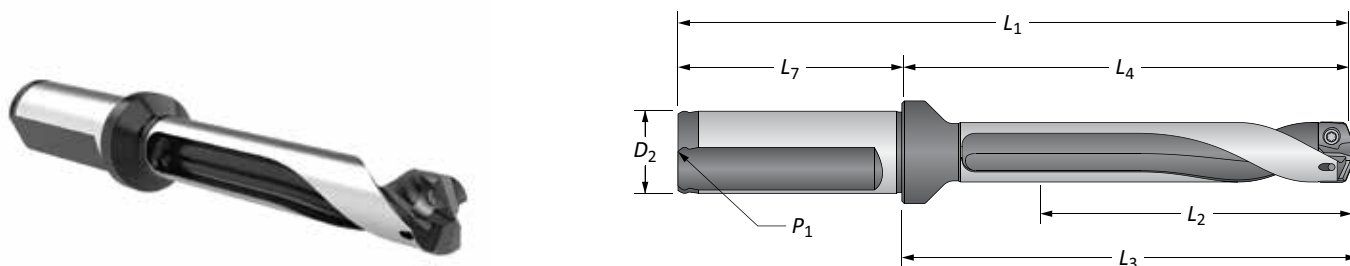
## GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System

15 Series | Diameter Range: 15.00mm - 15.99mm (0.5906" - 0.6298")



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
15.00	0.5906	–	<b>XTST15-15.00</b>	<b>7C215P-15ST</b>
15.88	0.6250	5/8	<b>XTST15-15.88</b>	<b>7C215P-0020ST</b>




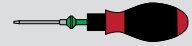



### Holders

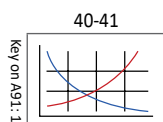
	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b>	3xD	48.0	75.1	77.6	125.1	50	20	3.18*	YES	<b>ST03150-20FM</b>
	5xD	80.0	107.0	109.6	157.0	50	20	3.18*	YES	<b>ST05150-20FM</b>
	7xD	111.9	139.0	141.6	189.0	50	20	3.18*	YES	<b>ST07150-20FM</b>
<b>i</b>	3xD	1-57/64	2-61/64	3-3/64	4-63/64	2-1/32	3/4	1/8	YES	<b>ST03150-075F</b>
	5xD	3-5/32	4-7/32	4-5/16	6-1/4	2-1/32	3/4	1/8	YES	<b>ST05150-075F</b>
	7xD	4-27/64	5-15/32	5-37/64	7-1/2	2-1/32	3/4	1/8	YES	<b>ST07150-075F</b>

\*Thread to BSP and ISO 7-1

### Connection Accessories

					Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

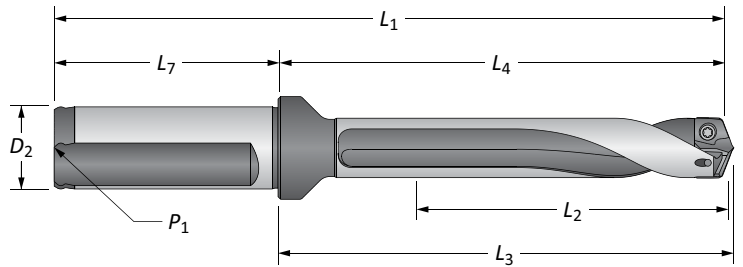
**GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System**

16 Series | Diameter Range: 16.00mm - 16.99mm (0.6299" - 0.6692")



**Inserts**

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
16.00	0.6299	-	XTST16-16.00	7C216P-16ST



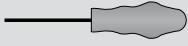




**Holders**

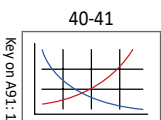
Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
3xD	51.0	81.3	84.2	131.3	50	20	3.18*	YES	ST03160-20FM
5xD	84.9	115.3	118.2	165.3	50	20	3.18*	YES	ST05160-20FM
7xD	118.9	149.3	152.2	199.3	50	20	3.18*	YES	ST07160-20FM
3xD	3-1/64	3-13/64	3-5/16	5-15/64	2-1/32	3/4	1/8	YES	ST03160-075F
5xD	3-23/64	4-17/32	4-21/32	6-9/16	2-1/32	3/4	1/8	YES	ST05160-075F
7xD	4-11/16	5-7/8	5-63/64	7-29/32	2-1/32	3/4	1/8	YES	ST07160-075F

\*Thread to BSP and ISO 7-1

**Connection Accessories**

					Admissible Tightening Torque*
72556-IP8-1	72556N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



m = Metric (mm)  
i = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10

**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.





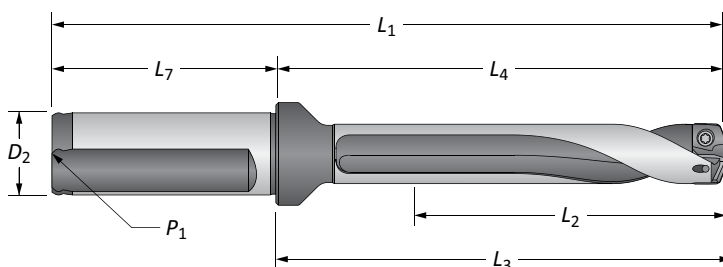
## GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System

17 Series | Diameter Range: 17.00mm - 17.99mm (0.6693" - 0.7086")



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
17.00	0.6693	-	<b>XTST17-17.00</b>	<b>7C217P-17ST</b>
17.46	0.6875	11/16	<b>XTST17-17.46</b>	<b>7C217P-0022ST</b>








### Holders

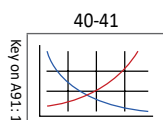
Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b> 3xD	54.0	84.1	87.0	134.1	50	20	3.18*	YES	<b>ST03170-20FM</b>
<b>m</b> 5xD	89.9	120.0	122.9	170.0	50	20	3.18*	YES	<b>ST05170-20FM</b>
<b>m</b> 7xD	125.9	156.0	158.9	206.0	50	20	3.18*	YES	<b>ST07170-20FM</b>
<b>i</b> 3xD	2-1/8	3-5/16	3-27/64	5-11/32	2-1/32	3/4	1/8	YES	<b>ST03170-075F</b>
<b>i</b> 5xD	3-35/64	4-23/32	4-27/32	6-3/4	2-1/32	3/4	1/8	YES	<b>ST05170-075F</b>
<b>i</b> 7xD	4-31/32	6-9/64	6-1/4	8-11/64	2-1/32	3/4	1/8	YES	<b>ST07170-075F</b>

\*Thread to BSP and ISO 7-1

### Connection Accessories

					Admissible Tightening Torque*
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	
72567-IP8-1	72567N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

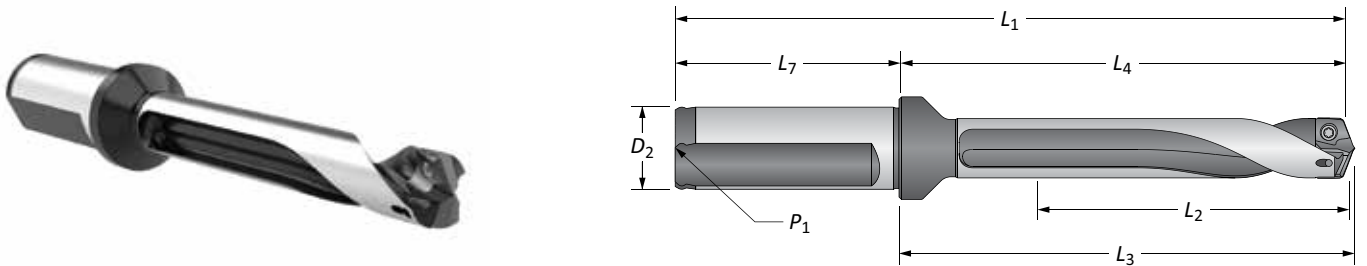
**GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System**

18 Series | Diameter Range: 18.00mm - 19.99mm (0.7087" - 0.7873")



**Inserts**

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
18.00	0.7087	-	<b>XTST18-18.00</b>	<b>7C218P-18ST</b>
19.00	0.7480	-	<b>XTST18-19.00</b>	<b>7C218P-19ST</b>








**HOLDERS**

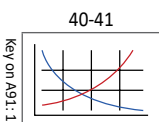
	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
m	3xD	60.0	94.0	97.1	144.0	50	20	3.18*	YES	<b>ST03180-20FM</b>
	5xD	99.9	134.0	137.1	184.0	50	20	3.18*	YES	<b>ST05180-20FM</b>
	7xD	139.9	174.0	177.1	224.0	50	20	3.18*	YES	<b>ST07180-20FM</b>
i	3xD	2-3/8	3-45/64	3-53/64	5-63/64	2-9/32	1	1/8	YES	<b>ST03180-075F</b>
	5xD	3-15/16	5-9/32	5-25/64	7-9/16	2-9/32	1	1/8	YES	<b>ST05180-075F</b>
	7xD	5-33/64	6-27/32	6-31/32	9-1/8	2-9/32	1	1/8	YES	<b>ST07180-075F</b>

\*Thread to BSP and ISO 7-1

**Connection Accessories**

					Admissible Tightening Torque*
Insert Screws 7375-IP9-1	Nylon Locking Screws 7375N-IP9-1	Insert Driver 8IP-9	Preset Torque Hand Driver 8IP-9TL	Replacement Tips 8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



m = Metric (mm)  
i = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

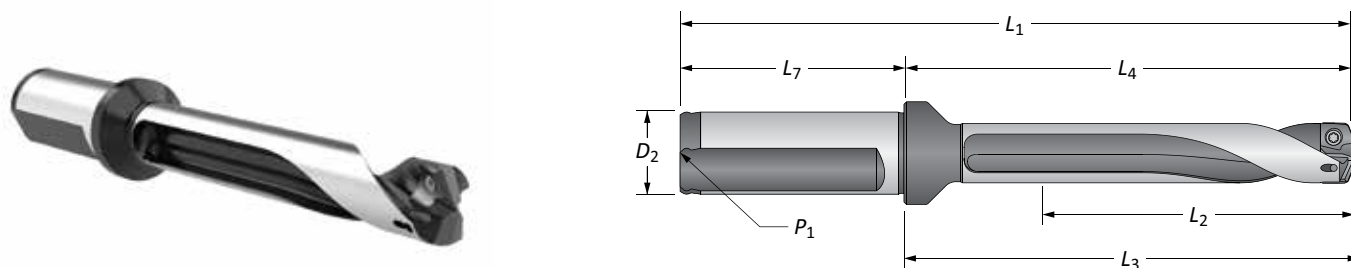
### GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System

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



**Inserts**

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
20.00	0.7874	–	XTST20-20.00	7C220P-20ST
20.64	0.8125	13/16	XTST20-20.64	7C220P-0026ST
21.00	0.8268	–	XTST20-21.00	7C220P-21ST
21.82	0.8594	55/64	XTST20-21.82	7C220P-0026ST




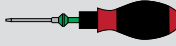



**Holders**

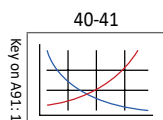
Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>M</b> 3xD	66.0	100.1	103.3	156.1	56	25	3.18*	YES	<b>ST03200-25FM</b>
<b>M</b> 5xD	110.0	144.1	147.2	200.1	56	25	3.18*	YES	<b>ST05200-25FM</b>
<b>M</b> 7xD	153.9	188.1	191.2	244.1	56	25	3.18*	YES	<b>ST07200-25FM</b>
<b>I</b> 3xD	2-17/32	3-15/16	4-1/16	6-7/32	2-9/32	1	1/8	YES	<b>ST03200-100F</b>
<b>I</b> 5xD	4-11/32	5-43/64	5-51/64	7-61/64	2-9/32	1	1/8	YES	<b>ST05200-100F</b>
<b>I</b> 7xD	6-1/16	7-13/32	7-17/32	9-11/16	2-9/32	1	1/8	YES	<b>ST07200-100F</b>

\*Thread to BSP and ISO 7-1

**Connection Accessories**

					Admissible Tightening Torque*
7375-IP9-1	7375N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



**M** = Metric (mm)  
**I** = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

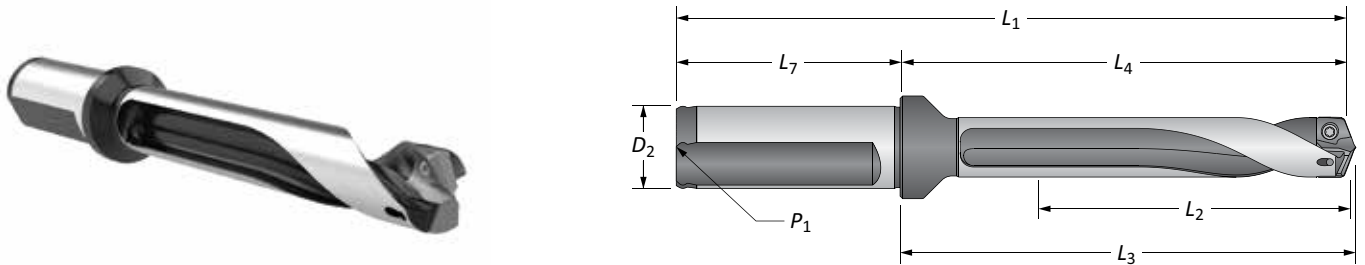
**GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System**

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



**Inserts**

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
22.00	0.8661	–	<b>XTST22-22.00</b>	<b>7C222P-22ST</b>
22.23	0.8750	7/8	<b>XTST22-22.23</b>	<b>7C222P-0028ST</b>
23.00	0.9055	–	<b>XTST22-23.00</b>	<b>7C222P-23ST</b>
23.81	0.9375	15/16	<b>XTST22-23.81</b>	<b>7C222P-0030ST</b>




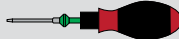



**HOLDERS**

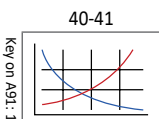
Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
3xD	72.0	105.3	108.7	161.3	56	25	3.18*	YES	<b>ST03220-25FM</b>
3xD	72.0	105.3	108.7	161.3	56	25	3.18*	YES	<b>ST03225-25FM**</b>
5xD	119.9	153.3	156.7	209.3	56	25	3.18*	YES	<b>ST05220-25FM</b>
5xD	119.9	153.3	156.7	209.3	56	25	3.18*	YES	<b>ST05225-25FM**</b>
7xD	167.9	201.3	204.7	257.3	56	25	3.18*	YES	<b>ST07220-25FM</b>
7xD	167.9	201.3	204.7	257.3	56	25	3.18*	YES	<b>ST07225-25FM**</b>
3xD	2-53/64	4-9/64	4-9/32	6-27/64	2-9/32	1	1/8	YES	<b>ST03220-100F</b>
3xD	2-53/64	4-9/64	4-9/32	6-27/64	2-9/32	1	1/8	YES	<b>ST03225-100F**</b>
5xD	4-23/32	6-1/32	6-11/64	8-5/16	2-9/32	1	1/8	YES	<b>ST05220-100F</b>
5xD	4-23/32	6-1/32	6-11/64	8-5/16	2-9/32	1	1/8	YES	<b>ST05225-100F**</b>
7xD	6-39/64	7-59/64	8-1/16	10-13/64	2-9/32	1	1/8	YES	<b>ST07220-100F</b>
7xD	6-39/64	7-59/64	8-1/16	10-13/64	2-9/32	1	1/8	YES	<b>ST07225-100F**</b>

\*Thread to BSP and ISO 7-1 | \*\*Oversized body holder (minimum drill diameter = 23mm)

**Connection Accessories**

					Admissible Tightening Torque*
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

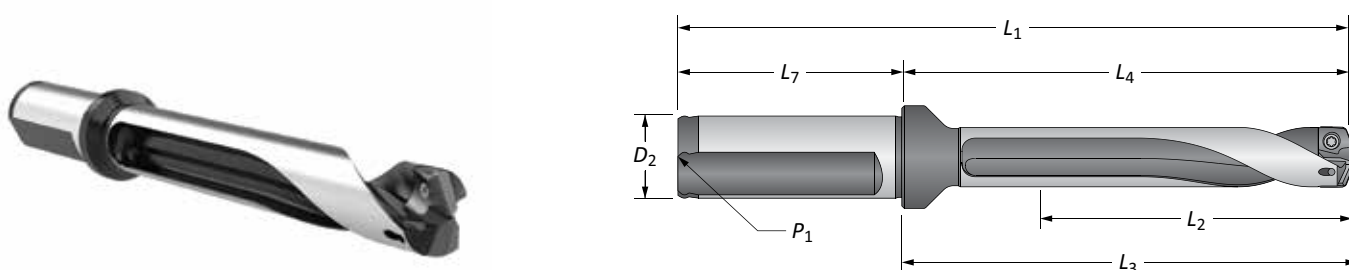
## GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System

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



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
24.00	0.9449	-	XTST24-24.00	7C224P-24ST
24.60	0.9685	-	XTST24-24.60	-
25.00	0.9843	-	-	7C224P-25ST
25.40	1.0000	1	XTST24-25.40	7C224P-0100ST
25.78	1.0150	-	XTST24-25.78	-




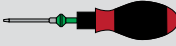



### Holder

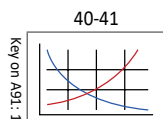
Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
$\text{m}$ 3xD	78.0	113.8	117.3	169.8	56	25	3.18*	YES	ST03240-25FM
$\text{m}$ 5xD	129.9	165.8	169.2	221.8	56	25	3.18*	YES	ST05240-25FM
$\text{m}$ 7xD	181.9	217.8	221.2	273.8	56	25	3.18*	YES	ST07240-25FM
$\text{i}$ 3xD	3-5/64	4-31/64	4-5/8	6-49/64	2-9/32	1	1/8	YES	ST03240-100F
$\text{i}$ 5xD	5-1/8	6-17/32	6-21/32	8-13/16	2-9/32	1	1/8	YES	ST05240-100F
$\text{i}$ 7xD	7-11/64	8-37/64	8-45/64	10-55/64	2-9/32	1	1/8	YES	ST07240-100F

\*Thread to BSP and ISO 7-1

### Connection Accessories

					Admissible Tightening Torque*
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



$\text{m}$  = Metric (mm)  
 $\text{i}$  = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.

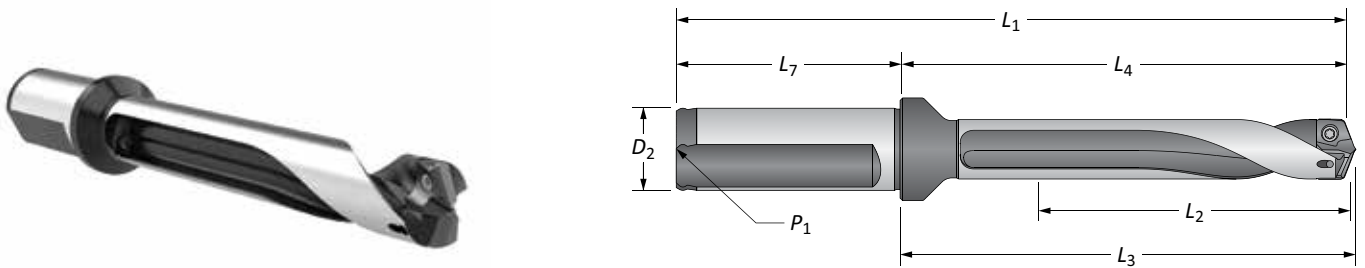
**GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System**

26 Series | Diameter Range: 26.00mm - 28.99mm (1.0236" - 1.1416")



**Inserts**

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
26.00	1.0236	–	<b>XTST26-26.00</b>	<b>7C226P-26ST</b>
26.99	1.0625	1-1/16	<b>XTST26-26.99</b>	<b>7C226P-0102ST</b>
27.00	1.0630	–	<b>XTST26-27.00</b>	<b>7C226P-27ST</b>
28.00	1.1024	–	<b>XTST26-28.00</b>	<b>7C226P-28ST</b>
28.58	1.1250	1-1/8	<b>XTST26-28.58</b>	<b>7C226P-0104ST</b>




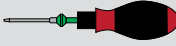



**Holders**

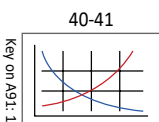
Length	Body				Shank				Part No.
	$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
<b>m</b> 3xD	87.0	128.1	131.4	188.1	60	32	6.35*	YES	<b>ST03260-32FM</b>
<b>m</b> 5xD	145.0	186.1	189.4	246.1	60	32	6.35*	YES	<b>ST05260-32FM</b>
<b>m</b> 7xD	202.9	244.0	247.4	304.0	60	32	6.35*	YES	<b>ST07260-32FM</b>
<b>i</b> 3xD	3-27/64	5-1/16	5-3/16	7-11/32	2-9/32	1-1/4	1/4	YES	<b>ST03260-125F</b>
<b>i</b> 5xD	5-23/32	7-11/32	7-31/64	9-5/8	2-9/32	1-1/4	1/4	YES	<b>ST05260-125F</b>
<b>i</b> 7xD	7-63/64	9-5/8	9-49/64	11-29/32	2-9/32	1-1/4	1/4	YES	<b>ST07260-125F</b>

\*Thread to BSP and ISO 7-1

**Connection Accessories**

					Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



**m** = Metric (mm)  
**i** = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10



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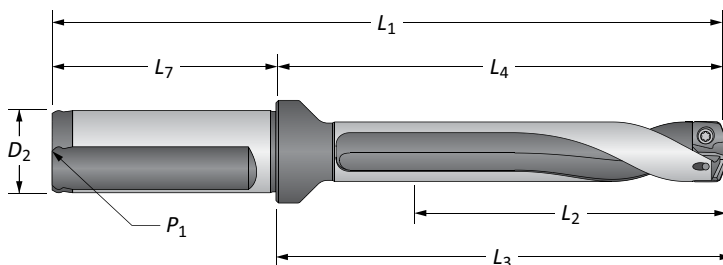
## GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System

29 Series | Diameter Range: 29.00mm - 31.99mm (1.1417" - 1.2597")



### Inserts

Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
29.00	1.1417	-	XTST29-29.00	7C229P-29ST
30.00	1.1811	-	XTST29-30.00	7C229P-30ST
30.16	1.1875	1-3/16	XTST29-30.16	7C229P-0106ST
30.50	1.2007	-	-	7C229P-30.5ST
31.00	1.2205	-	XTST29-31.00	7C229P-31ST
31.75	1.2500	1-1/4	XTST29-31.75	7C229P-0108ST




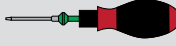



### Holders

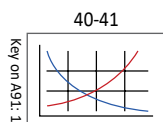
	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
Ⓜ	3xD	96.0	136.2	139.7	196.2	60	32	6.35*	YES	ST03290-32FM
	5xD	159.9	200.1	203.7	260.1	60	32	6.35*	YES	ST05290-32FM
	7xD	223.9	264.1	267.7	324.1	60	32	6.35*	YES	ST07290-32FM
Ⓛ	3xD	3-25/32	5-3/8	5-33/64	7-21/32	2-9/32	1-1/4	1/4	YES	ST03290-125F
	5xD	6-19/64	7-29/32	8-3/64	10-3/16	2-9/32	1-1/4	1/4	YES	ST05290-125F
	7xD	8-13/16	10-27/64	10-9/16	12-45/64	2-9/32	1-1/4	1/4	YES	ST07290-125F

\*Thread to BSP and ISO 7-1

### Connection Accessories

					Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



Ⓜ = Metric (mm)  
Ⓛ = Imperial (in)



Inserts sold in multiples of 1 | Screws sold in multiples of 10

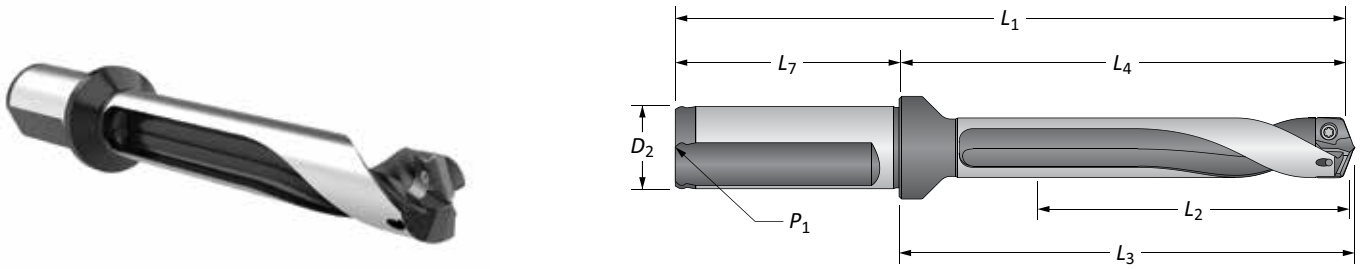
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**GEN3SYS® XT Pro ST / GEN3SYS® XT ST Structural Steel Drilling System**

32 Series | Diameter Range: 32.00mm - 35.00mm (1.2598" - 1.3780")



Insert				
$D_1$ mm	$D_1$ inch	Fractional Equivalent	XT Pro ST Part No.	XT ST Part No.
32.00	1.2598	–	<b>XTST32-32.00</b>	<b>7C232P-32ST</b>
33.00	1.2992	–	<b>XTST32-33.00</b>	<b>7C232P-33ST</b>
33.34	1.3125	1-5/16	<b>XTST32-33.34</b>	<b>7C232P-0110ST</b>
34.00	1.3386	–	<b>XTST32-34.00</b>	<b>7C232P-34ST</b>
34.93	1.3750	1-3/8	<b>XTST32-34.93</b>	<b>7C232P-0112ST</b>




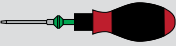



**Holders**

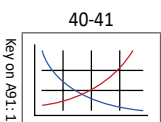
	Length	Body				Shank				Part No.
		$L_2$	$L_4$	$L_3$	$L_1$	$L_7$	$D_2$	$P_1$	Flat	
m	3xD	105.0	157.7	162.0	217.7	60	32	6.35*	YES	<b>ST03320-32FM</b>
	3xD	105.0	157.7	162.0	227.7	70	40	6.35*	YES	<b>ST03320-40FM</b>
	5xD	175.0	227.7	232.0	287.7	60	32	6.35*	YES	<b>ST05320-32FM</b>
	5xD	175.0	227.7	232.0	297.7	70	40	6.35*	YES	<b>ST05320-40FM</b>
	7xD	244.9	297.7	302.2	357.7	60	32	6.35*	YES	<b>ST07320-32FM</b>
	7xD	244.9	297.7	302.2	367.7	70	40	6.35*	YES	<b>ST07320-40FM</b>
i	3xD	4-9/64	6-7/32	6-3/8	8-29/32	2-11/16	1-1/2	1/4	YES	<b>ST03320-150F</b>
	5xD	6-59/64	8-31/32	9-1/8	11-21/32	2-11/16	1-1/2	1/4	YES	<b>ST05320-150F</b>
	7xD	9-41/64	11-23/32	11-57/64	14-13/32	2-11/16	1-1/2	1/4	YES	<b>ST07320-150F</b>

\*Thread to BSP and ISO 7-1

**Connection Accessories**

					Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

\*Tightening torques are calculated with a friction coefficient of  $\mu = 0.14$  and develop 90% of ultimate yield strength



m = Metric (mm)  
i = Imperial (in)

Inserts sold in multiples of 1 | Screws sold in multiples of 10

**NOTICE:** GEN3SYS XT Structural Steel holders are specifically designed to be used only with XT Pro ST or XT ST geometry inserts. Using other GEN3SYS XT Pro or XT insert geometries in these holders could lead to chip packing and tool failure. Contact Application Engineering for questions regarding proper use of tools.