





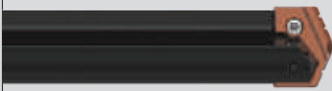
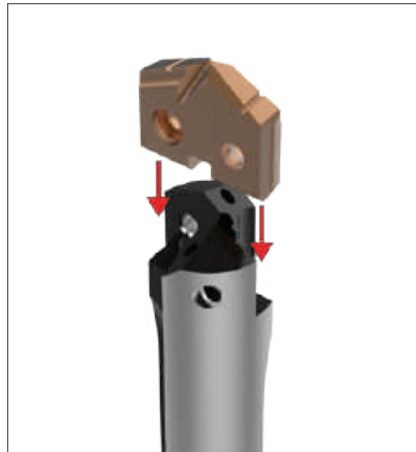


Insert Comparison and Assembly Information

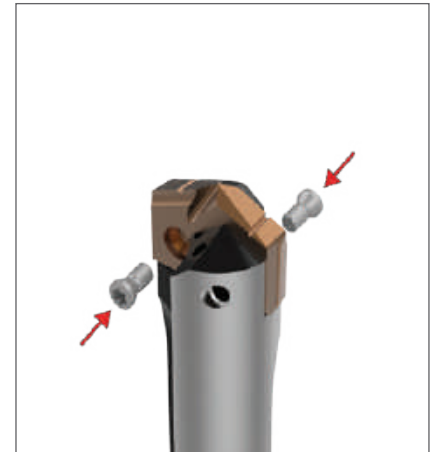
				
		T-A Pro Inserts	T-A GEN2 Inserts	T-A Inserts
A DRILLING				
		<input checked="" type="checkbox"/>		
B BORING		<input checked="" type="checkbox"/>		
		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
C REAMING		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>



Step 1: Align the flats on the T-A Pro insert with the flats on the ears of the holder.



Step 2: Slide the insert into the precision ground locating pocket on the holder. The insert should not be turned, rotated, or twisted for locking purposes. The holder pocket and locating pads on the insert assure optimum fit and repeatability.



Step 3: Apply a generous amount of E-Z Break® (provided in the packaging) onto the supplied TORX® Plus screws.

Tighten the TORX Plus screws to the recommended torque value specified in the catalog by series. A preset torx driver is available to assure that the proper torque is applied.

T-A Pro Drilling System Information



Advanced Design Capabilities

The advanced T-A Pro insert combines a coating and geometry specifically designed to achieve optimal results in ISO material drilling applications. With quick connectivity to existing T-A drill insert holders, the T-A Pro insert can be interchanged with previous T-A inserts with ease, resulting in minimal setup times so you can immediately increase your productivity.

T-A Pro Inserts Connect with:

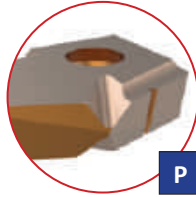


T-A Pro holders

T-A holders

P - Steels

- Designed to provide increased penetration rates and tool life in steel applications
- Superior geometry and edge provides excellent chip control
- Allied's multilayer AM300 coating increases heat resistance and improves tool life



P

M - Stainless Steel

- Designed for all stainless steels and heat-resistant super alloys
- Geometry optimized for improved chip formation while minimizing exit burr
- Allied's new AM460 coating provides industry leading tool life in stainless and HRSA materials



M

K - Cast Irons

- Uniquely designed for cast/ductile iron applications
- Geometry developed for maximum tool life, reduced exit burr, and improved hole finish
- Allied's multilayer TiAlN coating provides increased abrasion resistance and tool life



K

X - High-Speed Steel Materials

- Improved chip geometry for excellent chip control in all materials
- Long tool life and high-process security for the most challenging applications
- Allied's multilayer AM200 coating combines excellent heat resistance and high lubricity for wide application use



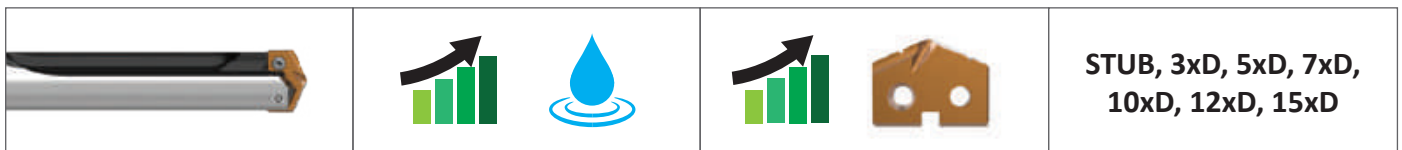
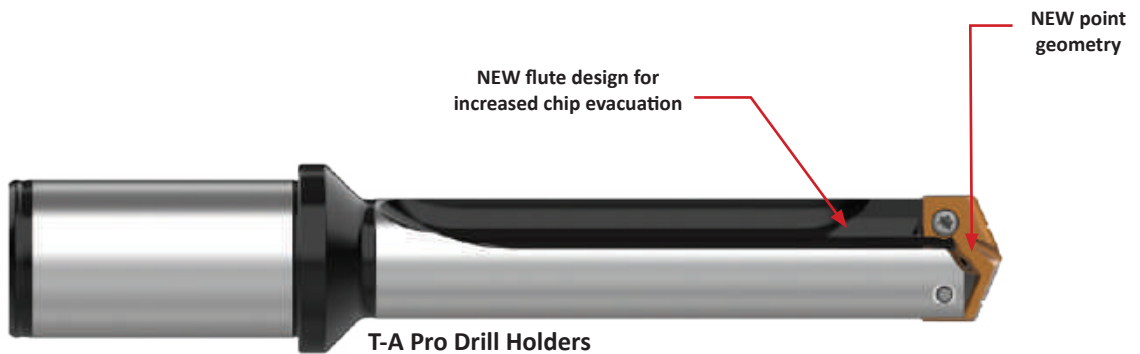
X

N - Non-ferrous Materials

- Designed for applications in aluminum, brass, and copper
- The geometry yields excellent chip control in these softer materials
- TiCN coating gives the versatility to run in a variety of materials while reducing buildup



N



Straight flutes



Proprietary coolant outlets improve coolant flow



Provides increased insert life

**STUB, 3xD, 5xD, 7xD,
10xD, 12xD, 15xD**

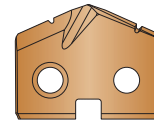
Available in STUB, 3xD, 5xD, 7xD,
10xD, 12xD, and 15xD



Product Nomenclature

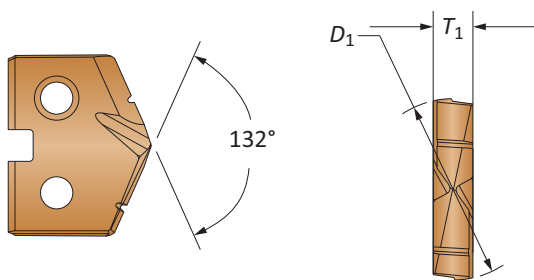
A
DRILLING
B
BORING
C
REAMING
D
BURNISHING
E
THREADING
X
SPECIALS

T-A Pro Drill Inserts



TA	P	0	–	15.00
1	2	3		4

1. T-A Pro Drill Insert	2. ISO Material / Geometry	3. Series	4. Diameter (mm)
TA = TA Pro insert	P = Steel K = Cast iron N = Non-ferrous M = Stainless Steel X = HSS	Z = Z series 0 = 0 series 1 = 1 series 2 = 2 series 3 = 3 series	For complete list of diameter ranges by series, see contents page.



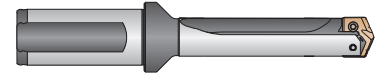
Reference Key

Symbol	Attribute
D_1	Insert diameter
T_1	Insert thickness

Product Nomenclature

T-A Pro Drill Holders

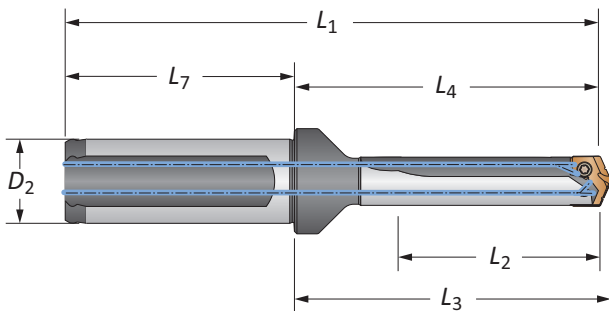
HTA	1	A	05	-	100	C
1	2	3	4		5	6



1. Holder HTA = TA Pro holder		2. Series Z = Z Series 0 = 0 Series 1 = 1 Series 2 = 2 Series 3 = 3 Series		3. Body Diameter A = A body diameter B = B body diameter C = C body diameter D = D body diameter		4. Length 01 = Stub Length 03 = 3x Diameter 05 = 5x Diameter 07 = 7x Diameter 10 = 10x Diameter 12 = 12x Diameter 15 = 15x Diameter	
5. Shank Diameter				6. Shank Style			
Metric (mm) 20 = 20mm 25 = 25mm 32 = 32mm 40 = 40mm		Imperial (inch) 075 = 3/4" 100 = 1" 125 = 1-1/4" 150 = 1-1/2"		F = Flanged with flat FM = Flanged metric with flat C = Cylindrical (no flat) CM = Cylindrical metric (no flat)			

Holder Ordering Information

The series designator (Z series, 0 series, etc.) in the top corner of each page is for your reference when ordering. Please refer to these series designators when placing an order. For example, a Z series drill insert only fits into a Z series holder.



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

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