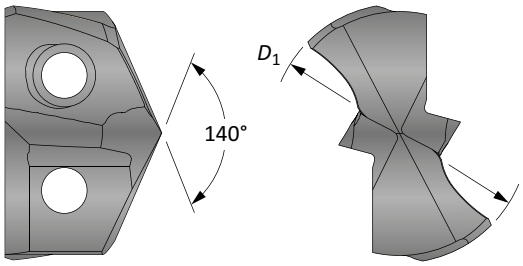
GEN3SYS®XT Pro Drill Inserts

11 Series | Diameter Range: 11.00mm - 11.99mm (0.4331” - 0.4723”)



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
11.00	0.4331	–	**XTP11-11.00**	**XTK11-11.00**	**XTN11-11.00**
11.11	0.4375	7/16	**XTP11-11.11**	**XTK11-11.11**	**XTN11-11.11**
11.20	0.4409	–	**XTP11-11.20**	**XTK11-11.20**	**XTN11-11.20**
11.30	0.4449	–	**XTP11-11.30**	**XTK11-11.30**	**XTN11-11.30**
11.40	0.4488	–	**XTP11-11.40**	**XTK11-11.40**	**XTN11-11.40**
11.50	0.4528	–	**XTP11-11.50**	**XTK11-11.50**	**XTN11-11.50**
11.51	0.4531	29/64	**XTP11-11.51**	**XTK11-11.51**	**XTN11-11.51**
11.60	0.4567	–	**XTP11-11.60**	**XTK11-11.60**	**XTN11-11.60**
11.70	0.4606	–	**XTP11-11.70**	**XTK11-11.70**	**XTN11-11.70**
11.80	0.4646	–	**XTP11-11.80**	**XTK11-11.80**	**XTN11-11.80**
11.91	0.4688	15/32	**XTP11-11.91**	**XTK11-11.91**	**XTN11-11.91**

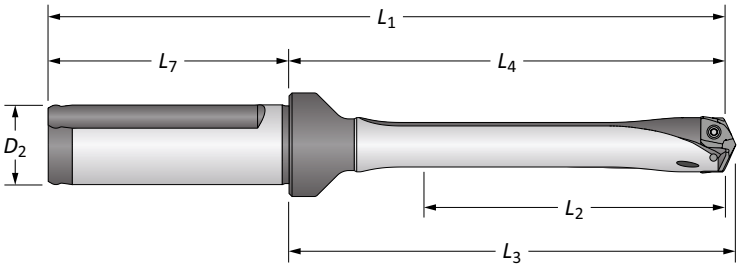
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

11 Series | Diameter Range: 11.00mm - 11.99mm (0.4331” - 0.4723”)



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank Flat	Part No.
m	Straight	3xD	36.0	62.6	64.7	110.6	48.0	16.0	YES	HXT0311S-16FM
		3xD	36.0	62.6	64.7	110.6	48.0	16.0	NO	HXT0311S-16CM
		5xD	60.0	86.6	88.6	134.6	48.0	16.0	YES	HXT0511S-16FM
		5xD	60.0	86.6	88.6	134.6	48.0	16.0	NO	HXT0511S-16CM
		7xD	84.0	110.6	112.6	158.6	48.0	16.0	YES	HXT0711S-16FM
		7xD	84.0	110.6	112.6	158.6	48.0	16.0	NO	HXT0711S-16CM
		10xD	119.9	146.6	148.4	194.6	48.0	16.0	YES	⚠ HXT1011S-16FM
		10xD	119.9	146.6	148.4	194.6	48.0	16.0	NO	⚠ HXT1011S-16CM
i	Straight	3xD	1-27/64	2-29/64	2-17/32	4-21/64	1-7/8	5/8	YES	HXT0311S-063F
		3xD	1-27/64	2-29/64	2-17/32	4-21/64	1-7/8	5/8	NO	HXT0311S-063C
		5xD	2-23/64	3-13/32	3-31/64	5-9/32	1-7/8	5/8	YES	HXT0511S-063F
		5xD	2-23/64	3-13/32	3-31/64	5-9/32	1-7/8	5/8	NO	HXT0511S-063C
		7xD	3-19/64	4-11/32	4-27/64	6-7/32	1-7/8	5/8	YES	HXT0711S-063F
		7xD	3-19/64	4-11/32	4-27/64	6-7/32	1-7/8	5/8	NO	HXT0711S-063C
		10xD	4-23/32	5-49/64	5-27/32	7-41/64	1-7/8	5/8	YES	⚠ HXT1011S-063F
		10xD	4-23/32	5-49/64	5-27/32	7-41/64	1-7/8	5/8	NO	⚠ HXT1011S-063C

Connection Accessories

Insert Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
71843-IP6-1	8IP-6	8IP-6TL	8IP-6B	50 N-cm (4.4 in-lbs)

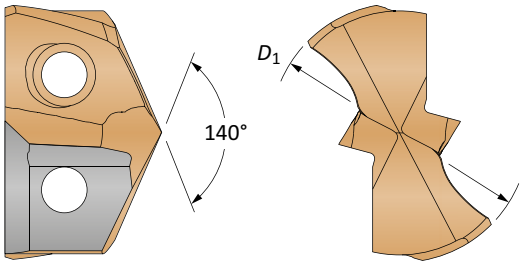
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

11 Series | Diameter Range: 11.00mm - 11.99mm (0.4331” - 0.4723”)



Insert							
Carbide Substrate	D_1 mm	D_1 inch	Fractional Equivalent	Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
K35 (C1)	11.00	0.4331	–	**7C111P-11**	**7C111P-11LR**	–	–
	11.11	0.4375	7/16	**7C111P-0014**	**7C111P-0014LR**	–	–
	11.50	0.4528	–	**7C111P-11.5**	**7C111P-11.5LR**	–	–
	11.51	0.4531	29/64	**7C111P-.453**	**7C111P-.453LR**	–	–
	11.91	0.4688	15/32	**7C111P-0015**	**7C111P-0015LR**	–	–
K20 (C2)	11.00	0.4331	–	**7C211P-11**	**7C211P-11LR**	**7C211P-11CI**	**7C211P-11AS**
	11.11	0.4375	7/16	**7C211P-0014**	**7C211P-0014LR**	**7C211P-0014CI**	**7C211P-0014AS**
	11.50	0.4528	–	**7C211P-11.5**	**7C211P-11.5LR**	**7C211P-11.5CI**	**7C211P-11.5AS**
	11.51	0.4531	29/64	**7C211P-.453**	**7C211P-.453LR**	**7C211P-.453CI**	**7C211P-.453AS**
	11.91	0.4688	15/32	**7C211P-0015**	**7C211P-0015LR**	**7C211P-0015CI**	**7C211P-0015AS**

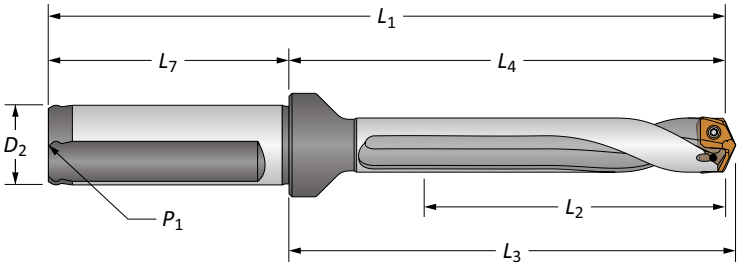
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Imperial:	0.5200”, 13 series, C2 = use Part No. **7C213P-.5200**
Metric:	13.20mm, 13 series, C2 = use Part No. **7C213P-13.20**

GEN3SYS®XT Standard Drill Insert Holders

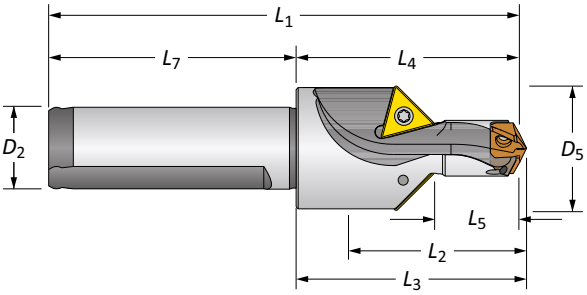
11 Series | Diameter Range: 11.00mm - 11.99mm (0.4331” - 0.4723”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	36.0	62.6	64.7	110.6	48.0	16.0	1/16*	YES	**60311S-16FM**
		5xD	60.0	86.6	88.6	134.6	48.0	16.0	1/16*	YES	**60511S-16FM**
		7xD	84.0	110.6	112.6	158.6	48.0	16.0	1/16*	YES	**60711S-16FM**
	Helical	Stub	16.0	42.6	44.7	90.6	48.0	16.0	1/16*	YES	**60111H-16FM**
		3xD	36.0	62.6	64.7	110.6	48.0	16.0	1/16*	YES	**60311H-16FM**
		3xD	36.0	62.6	64.7	110.6	48.0	16.0	1/16*	NO	**60311H-16CM**
		5xD	60.0	86.6	88.6	134.6	48.0	16.0	1/16*	YES	**60511H-16FM**
		5xD	60.0	86.6	88.6	134.6	48.0	16.0	1/16*	NO	**60511H-16CM**
		7xD	84.0	110.6	112.6	158.6	48.0	16.0	1/16*	YES	**60711H-16FM**
		7xD	84.0	110.6	112.6	158.6	48.0	16.0	1/16*	NO	**60711H-16CM**
i	Straight	3xD	1-27/64	2-29/64	2-17/32	4-21/64	1-7/8	5/8	1/16	YES	**60311S-063F**
		5xD	2-23/64	3-13/32	3-31/64	5-9/32	1-7/8	5/8	1/16	YES	**60511S-063F**
		7xD	3-19/64	4-11/32	4-27/64	6-7/32	1-7/8	5/8	1/16	YES	**60711S-063F**
	Helical	Stub	5/8	1-43/64	1-3/4	3-35/64	1-7/8	5/8	1/16	YES	**60111H-063F**
		3xD	1-27/64	2-29/64	2-17/32	4-21/64	1-7/8	5/8	1/16	YES	**60311H-063F**
		3xD	1-27/64	2-29/64	2-17/32	4-21/64	1-7/8	5/8	1/16	NO	**60311H-063C**
		5xD	2-23/64	3-13/32	3-31/64	5-9/32	1-7/8	5/8	1/16	YES	**60511H-063F**
		5xD	2-23/64	3-13/32	3-31/64	5-9/32	1-7/8	5/8	1/16	NO	**60511H-063C**
		7xD	3-19/64	4-11/32	4-27/64	6-7/32	1-7/8	5/8	1/16	YES	**60711H-063F**
		7xD	3-19/64	4-11/32	4-27/64	6-7/32	1-7/8	5/8	1/16	NO	**60711H-063C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	24.1	16.5	23.8	42.2	44.3	90.2	48.0	16.0	**60111C45-16FM**	TCMT-110204
i	61/64	21/32	15/16	1-43/64	1-3/4	3-35/64	1-7/8	5/8	**60111C45-063F**	TCMT-110204

Connection Accessories

Insert Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
71843-IP6-1	8IP-6	8IP-6TL	8IP-6B	50 N-cm (4.4 in-lbs)

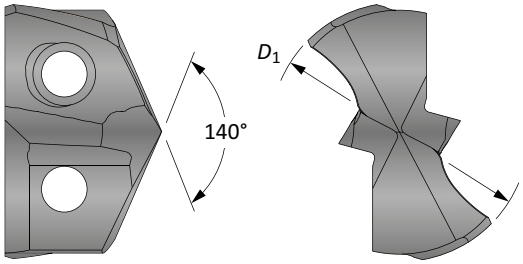
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
12.00	0.4724	–	**XTP12-12.00**	**XTK12-12.00**	**XTN12-12.00**
12.10	0.4764	–	**XTP12-12.10**	**XTK12-12.10**	**XTN12-12.10**
12.20	0.4803	–	**XTP12-12.20**	**XTK12-12.20**	**XTN12-12.20**
12.30	0.4844	31/64	**XTP12-12.30**	**XTK12-12.30**	**XTN12-12.30**
12.40	0.4882	–	**XTP12-12.40**	**XTK12-12.40**	**XTN12-12.40**
12.50	0.4921	–	**XTP12-12.50**	**XTK12-12.50**	**XTN12-12.50**
12.60	0.4961	–	**XTP12-12.60**	**XTK12-12.60**	**XTN12-12.60**
12.70	0.5000	1/2	**XTP12-12.70**	**XTK12-12.70**	**XTN12-12.70**
12.80	0.5039	–	**XTP12-12.80**	**XTK12-12.80**	**XTN12-12.80**
12.90	0.5079	–	**XTP12-12.90**	**XTK12-12.90**	**XTN12-12.90**

Inserts sold in multiples of 1

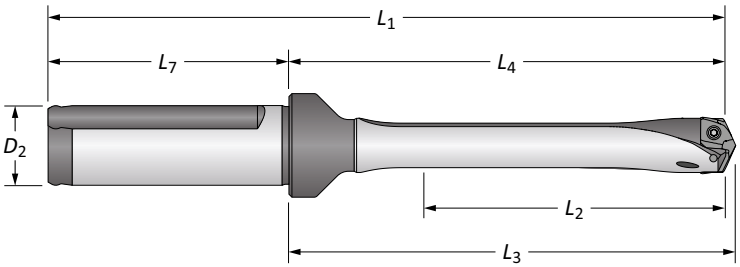
A2: 66 - 75
Key on A2: 1

A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank Flat	Part No.
m	Straight	3xD	39.0	66.6	68.8	116.6	50.0	20.0	YES	**HXT0312S-20FM**
		3xD	39.0	66.6	68.8	116.6	50.0	20.0	NO	**HXT0312S-20CM**
		5xD	65.0	92.5	94.8	142.6	50.0	20.0	YES	**HXT0512S-20FM**
		5xD	65.0	92.5	94.8	142.6	50.0	20.0	NO	**HXT0512S-20CM**
		7xD	91.0	118.5	120.8	168.5	50.0	20.0	YES	**HXT0712S-20FM**
		7xD	91.0	118.5	120.8	168.5	50.0	20.0	NO	**HXT0712S-20CM**
		10xD	129.9	157.5	159.7	207.5	50.0	20.0	YES	⚠ **HXT1012S-20FM**
		10xD	129.9	157.5	159.7	207.5	50.0	20.0	NO	⚠ **HXT1012S-20CM**
i	Straight	3xD	1-17/32	2-5/8	2-45/64	4-21/32	2-1/32	3/4	YES	**HXT0312S-075F**
		3xD	1-17/32	2-5/8	2-45/64	4-21/32	2-1/32	3/4	NO	**HXT0312S-075C**
		5xD	2-9/16	3-41/64	3-47/64	5-43/64	2-1/32	3/4	YES	**HXT0512S-075F**
		5xD	2-9/16	3-41/64	3-47/64	5-43/64	2-1/32	3/4	NO	**HXT0512S-075C**
		7xD	3-37/64	4-21/32	4-3/4	6-11/16	2-1/32	3/4	YES	**HXT0712S-075F**
		7xD	3-37/64	4-21/32	4-3/4	6-11/16	2-1/32	3/4	NO	**HXT0712S-075C**
		10xD	5-7/64	6-13/64	6-9/32	8-15/64	2-1/32	3/4	YES	⚠ **HXT1012S-075F**
		10xD	5-7/64	6-13/64	6-9/32	8-15/64	2-1/32	3/4	NO	⚠ **HXT1012S-075C**

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

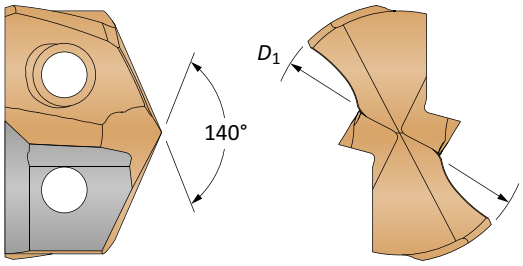
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ **WARNING** Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

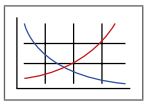
12 Series | Diameter Range: 12.00mm - 12.99mm (0.4724” - 0.5117”)



Insert							
Carbide Substrate	**D_1 mm**	**D_1 inch**	**Fractional Equivalent**	**Standard Part No.**	**Low Rake Part No.**	**Cast Iron Part No.**	**Stainless Part No.**
K35 (C1)	12.00	0.4724	–	**7C112P-12**	**7C112P-12LR**	–	–
	12.30	0.4844	31/64	**7C112P-.484**	**7C112P-.484LR**	–	–
	12.50	0.4921	–	**7C112P-12.5**	**7C112P-12.5LR**	–	–
	12.60	0.4961	–	**7C112P-12.6**	–	–	–
	12.70	0.5000	1/2	**7C112P-0016**	**7C112P-0016LR**	–	–
	12.80	0.5039	–	**7C112P-12.8**	–	–	–
K20 (C2)	12.00	0.4724	–	**7C212P-12**	**7C212P-12LR**	**7C212P-12CI**	**7C212P-12AS**
	12.30	0.4844	31/64	**7C212P-.484**	**7C212P-.484LR**	**7C212P-.484CI**	**7C212P-.484AS**
	12.50	0.4921	–	**7C212P-12.5**	**7C212P-12.5LR**	**7C212P-12.5CI**	**7C212P-12.5AS**
	12.60	0.4961	–	**7C212P-12.6**	–	–	–
	12.70	0.5000	1/2	**7C212P-0016**	**7C212P-0016LR**	**7C212P-0016CI**	**7C212P-0016AS**
	12.80	0.5039	–	**7C212P-12.8**	–	–	–

Inserts sold in multiples of 1

A2: 66 - 75



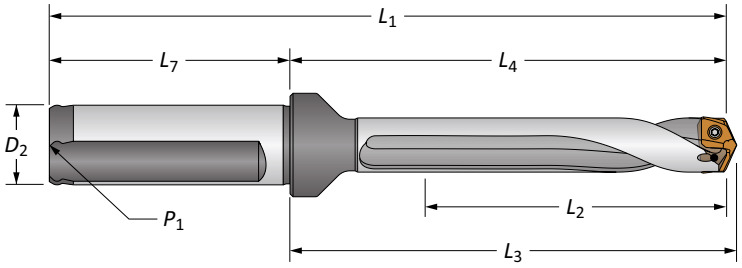
Key on A2: 1

A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

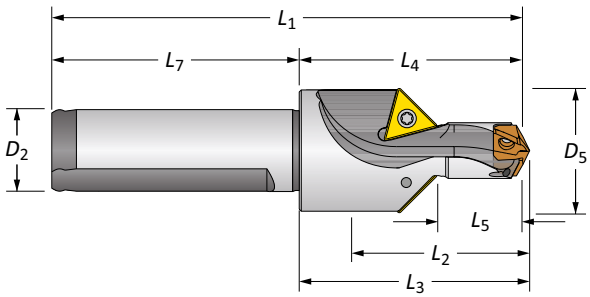
12 Series | Diameter Range: 12.00mm - 12.99mm (0.4724” - 0.5117”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	39.0	66.6	68.8	116.6	50.0	20.0	1/8*	YES	**60312S-20FM**
		5xD	65.0	92.6	94.8	142.6	50.0	20.0	1/8*	YES	**60512S-20FM**
		7xD	91.0	118.5	120.8	168.5	50.0	20.0	1/8*	YES	**60712S-20FM**
	Helical	Stub	16.0	43.2	45.4	93.2	50.0	20.0	1/8*	YES	**60112H-20FM**
		3xD	39.0	66.6	68.8	116.6	50.0	20.0	1/8*	YES	**60312H-20FM**
		3xD	39.0	66.6	68.8	116.6	50.0	20.0	1/8*	NO	**60312H-20CM**
		5xD	65.0	92.6	94.8	142.6	50.0	20.0	1/8*	YES	**60512H-20FM**
		5xD	65.0	92.6	94.8	142.6	50.0	20.0	1/8*	NO	**60512H-20CM**
		7xD	91.0	118.5	120.8	168.5	50.0	20.0	1/8*	YES	**60712H-20FM**
		7xD	91.0	118.5	120.8	168.5	50.0	20.0	1/8*	NO	**60712H-20CM**
i	Straight	3xD	1-17/32	2-5/8	2-45/64	4-21/32	2-1/32	3/4	1/8	YES	**60312S-075F**
		5xD	2-9/16	3-41/64	3-47/64	5-43/64	2-1/32	3/4	1/8	YES	**60512S-075F**
		7xD	3-37/64	4-21/32	4-3/4	6-11/16	2-1/32	3/4	1/8	YES	**60712S-075F**
	Helical	Stub	5/8	1-45/64	1-25/32	3-47/64	2-1/32	3/4	1/8	YES	**60112H-075F**
		3xD	1-17/32	2-5/8	2-45/64	4-21/32	2-1/32	3/4	1/8	YES	**60312H-075F**
		3xD	1-17/32	2-5/8	2-45/64	4-21/32	2-1/32	3/4	1/8	NO	**60312H-075C**
		5xD	2-9/16	3-41/64	3-47/64	5-43/64	2-1/32	3/4	1/8	YES	**60512H-075F**
		5xD	2-9/16	3-41/64	3-47/64	5-43/64	2-1/32	3/4	1/8	NO	**60512H-075C**
		7xD	3-37/64	4-21/32	4-3/4	6-11/16	2-1/32	3/4	1/8	YES	**60712H-075F**
		7xD	3-37/64	4-21/32	4-3/4	6-11/16	2-1/32	3/4	1/8	NO	**60712H-075C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	24.8	18.0	35.2	43.2	45.4	93.2	50.0	20.0	**60112C45-20FM**	TCMT-110204
i	31/32	45/64	63/64	1-45/64	1-25/32	3-47/64	2-1/32	3/4	**60112C45-075F**	TCMT-110204

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

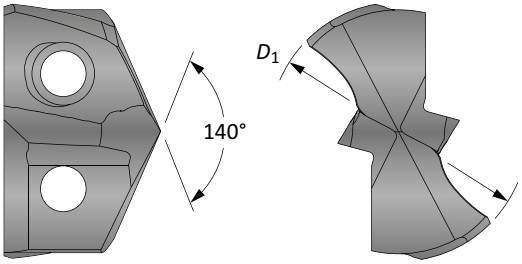
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

13 Series | Diameter Range: 13.00mm - 13.99mm (0.5118” - 0.5511”)



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
13.00	0.5118	–	**XTP13-13.00**	**XTK13-13.00**	**XTN13-13.00**
13.10	0.5156	33/64	**XTP13-13.10**	**XTK13-13.10**	**XTN13-13.10**
13.20	0.5197	–	**XTP13-13.20**	**XTK13-13.20**	**XTN13-13.20**
13.30	0.5236	–	**XTP13-13.30**	**XTK13-13.30**	**XTN13-13.30**
13.40	0.5276	–	**XTP13-13.40**	**XTK13-13.40**	**XTN13-13.40**
13.49	0.5313	17/32	**XTP13-13.49**	**XTK13-13.49**	**XTN13-13.49**
13.50	0.5315	–	**XTP13-13.50**	**XTK13-13.50**	**XTN13-13.50**
13.60	0.5354	–	**XTP13-13.60**	**XTK13-13.60**	**XTN13-13.60**
13.70	0.5394	–	**XTP13-13.70**	**XTK13-13.70**	**XTN13-13.70**
13.80	0.5433	–	**XTP13-13.80**	**XTK13-13.80**	**XTN13-13.80**
13.89	0.5469	35/64	**XTP13-13.89**	**XTK13-13.89**	**XTN13-13.89**

Inserts sold in multiples of 1

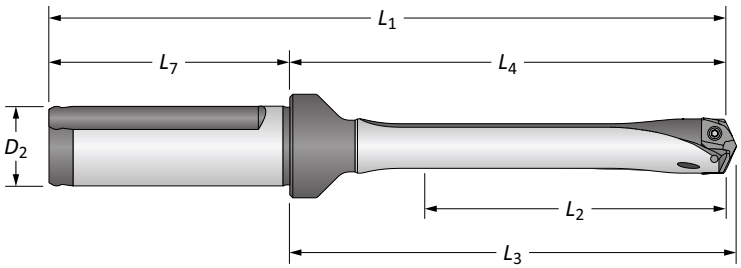
A2: 66 - 75
Key on A2: 1

A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

13 Series | Diameter Range: 13.00mm - 13.99mm (0.5118” - 0.5511”)



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank Flat	Part No.
m	Straight	3xD	42.0	69.2	71.5	119.2	50.0	20.0	YES	HXT0313S-20FM
		3xD	42.0	69.2	71.5	119.2	50.0	20.0	NO	HXT0313S-20CM
		5xD	70.0	97.3	99.5	147.3	50.0	20.0	YES	HXT0513S-20FM
		5xD	70.0	97.3	99.5	147.3	50.0	20.0	NO	HXT0513S-20CM
		7xD	98.0	125.3	127.5	175.3	50.0	20.0	YES	HXT0713S-20FM
		7xD	98.0	125.3	127.5	175.3	50.0	20.0	NO	HXT0713S-20CM
		10xD	140.0	167.0	169.4	217.0	50.0	20.0	YES	⚠ HXT1013S-20FM
		10xD	140.0	167.0	169.4	217.0	50.0	20.0	NO	⚠ HXT1013S-20CM
i	Straight	3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	YES	HXT0313S-075F
		3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	NO	HXT0313S-075C
		5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	YES	HXT0513S-075F
		5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	NO	HXT0513S-075C
		7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	YES	HXT0713S-075F
		7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	NO	HXT0713S-075C
		10xD	5-33/64	6-37/64	6-43/64	8-39/64	2-1/32	3/4	YES	⚠ HXT1013S-075F
		10xD	5-33/64	6-37/64	6-43/64	8-39/64	2-1/32	3/4	NO	⚠ HXT1013S-075C

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

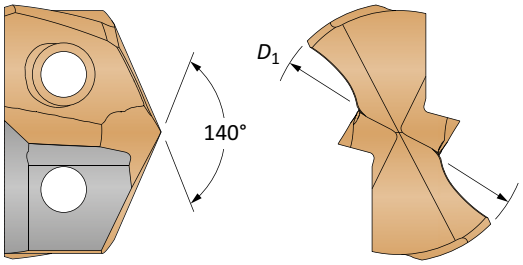
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

13 Series | Diameter Range: 13.00mm - 13.99mm (0.5118” - 0.5511”)



Insert							
Carbide Substrate	**D_1 mm**	**D_1 inch**	**Fractional Equivalent**	**Standard Part No.**	**Low Rake Part No.**	**Cast Iron Part No.**	**Stainless Part No.**
K35 (C1)	13.00	0.5118	–	**7C113P-13**	**7C113P-13LR**	–	–
	13.08	0.5156	33/64	**7C113P-.515**	**7C113P-.515LR**	–	–
	13.10	0.5157	–	**7C113P-13.1**	–	–	–
	13.20	0.5197	–	**7C113P-13.2**	–	–	–
	13.49	0.5312	17/32	**7C113P-0017**	**7C113P-0017LR**	–	–
	13.50	0.5315	–	**7C113P-13.5**	**7C113P-13.5LR**	–	–
	13.60	0.5354	–	**7C113P-13.6**	–	–	–
	13.70	0.5394	–	**7C113P-13.7**	–	–	–
	13.80	0.5433	–	**7C113P-13.8**	–	–	–
	13.89	0.5469	35/64	**7C113P-.546**	**7C113P-.546LR**	–	–
K20 (C2)	13.00	0.5118	–	**7C213P-13**	**7C213P-13LR**	**7C213P-13CI**	**7C213P-13AS**
	13.08	0.5156	33/64	**7C213P-.515**	**7C213P-.515LR**	**7C213P-.515CI**	**7C213P-.515AS**
	13.10	0.5157	–	**7C213P-13.1**	–	–	–
	13.20	0.5197	–	**7C213P-13.2**	–	–	–
	13.49	0.5312	17/32	**7C213P-0017**	**7C213P-0017LR**	**7C213P-0017CI**	**7C213P-0017AS**
	13.50	0.5315	–	**7C213P-13.5**	**7C213P-13.5LR**	**7C213P-13.5CI**	**7C213P-13.5AS**
	13.60	0.5354	–	**7C213P-13.6**	–	–	–
	13.70	0.5394	–	**7C213P-13.7**	–	–	–
	13.80	0.5433	–	**7C213P-13.8**	–	–	–
	13.89	0.5469	35/64	**7C213P-.546**	**7C213P-.546LR**	**7C213P-.546CI**	**7C213P-.546AS**

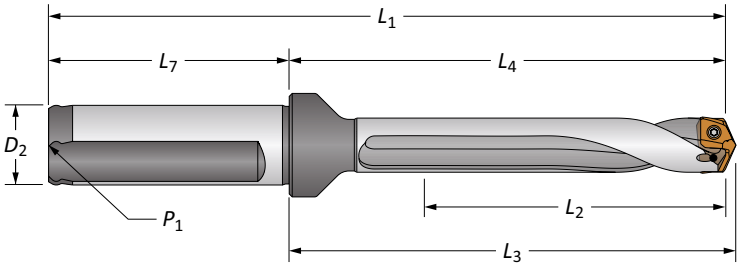
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

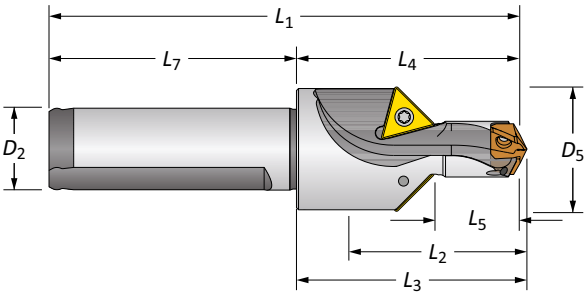
13 Series | Diameter Range: 13.00mm - 13.99mm (0.5118” - 0.5511”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	42.0	69.2	71.5	119.2	50.0	20.0	1/8*	YES	**60313S-20FM**
		5xD	70.0	97.3	99.5	147.3	50.0	20.0	1/8*	YES	**60513S-20FM**
		7xD	98.0	125.3	127.5	175.3	50.0	20.0	1/8*	YES	**60713S-20FM**
	Helical	Stub	16.0	43.0	45.2	93.0	50.0	20.0	1/8*	YES	**60113H-20FM**
		3xD	42.0	69.2	71.5	119.2	50.0	20.0	1/8*	YES	**60313H-20FM**
		3xD	42.0	69.2	71.5	119.2	50.0	20.0	1/8*	NO	**60313H-20CM**
		5xD	70.0	97.3	99.5	147.3	50.0	20.0	1/8*	YES	**60513H-20FM**
		5xD	70.0	97.3	99.5	147.3	50.0	20.0	1/8*	NO	**60513H-20CM**
		7xD	98.0	125.3	127.5	175.3	50.0	20.0	1/8*	YES	**60713H-20FM**
		7xD	98.0	125.3	127.5	175.3	50.0	20.0	1/8*	NO	**60713H-20CM**
i	Straight	3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	1/8	YES	**60313S-075F**
		5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	1/8	YES	**60513S-075F**
		7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	1/8	YES	**60713S-075F**
	Helical	Stub	5/8	1-11/16	1-25/32	3-23/32	2-1/32	3/4	1/8	YES	**60113H-075F**
		3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	1/8	YES	**60313H-075F**
		3xD	1-21/32	2-23/32	2-13/16	4-3/4	2-1/32	3/4	1/8	NO	**60313H-075C**
		5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	1/8	YES	**60513H-075F**
		5xD	2-3/4	3-13/16	3-29/32	5-27/32	2-1/32	3/4	1/8	NO	**60513H-075C**
		7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	1/8	YES	**60713H-075F**
		7xD	3-55/64	4-59/64	5-1/64	6-61/64	2-1/32	3/4	1/8	NO	**60713H-075C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	25.8	19.5	25.4	43.0	45.2	93.0	50.0	20.0	**60113C45-20FM**	TCMT-110204
i	1-1/64	49/64	1	1-11/16	1-25/32	3-23/32	2-1/32	3/4	**60113C45-075F**	TCMT-110204

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

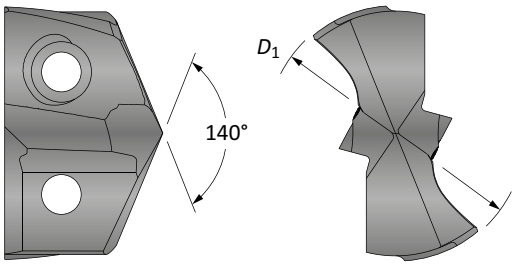
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert			Part No.	Part No.	Part No.
D_1 mm	D_1 inch	Fractional Equivalent	P	K	N
14.00	0.5512	–	**XTP14-14.00**	**XTK14-14.00**	**XTN14-14.00**
14.10	0.5551	–	**XTP14-14.10**	**XTK14-14.10**	**XTN14-14.10**
14.20	0.5591	–	**XTP14-14.20**	**XTK14-14.20**	**XTN14-14.20**
14.29	0.5625	9/16	**XTP14-14.29**	**XTK14-14.29**	**XTN14-14.29**
14.40	0.5669	–	**XTP14-14.40**	**XTK14-14.40**	**XTN14-14.40**
14.50	0.5709	–	**XTP14-14.50**	**XTK14-14.50**	**XTN14-14.50**
14.60	0.5748	–	**XTP14-14.60**	**XTK14-14.60**	**XTN14-14.60**
14.68	0.5781	13/64	**XTP14-14.68**	**XTK14-14.68**	**XTN14-14.68**
14.80	0.5827	–	**XTP14-14.80**	**XTK14-14.80**	**XTN14-14.80**
14.90	0.5866	–	**XTP14-14.90**	**XTK14-14.90**	**XTN14-14.90**

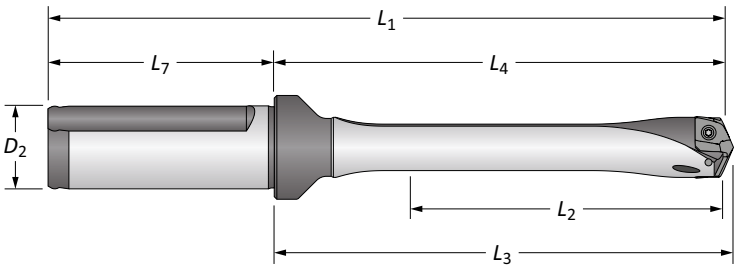
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Body Length	L_2	L_4	L_3	L_1	Shank L_7	D_2	Flat	Part No.
m	Straight	3xD	45.0	72.4	75.0	122.4	50.0	20.0	YES	HXT0314S-20FM
		3xD	45.0	72.4	75.0	122.4	50.0	20.0	NO	HXT0314S-20CM
		5xD	75.0	102.4	104.9	152.4	50.0	20.0	YES	HXT0514S-20FM
		5xD	75.0	102.4	104.9	152.4	50.0	20.0	NO	HXT0514S-20CM
		7xD	105.0	132.4	134.9	182.4	50.0	20.0	YES	HXT0714S-20FM
		7xD	105.0	132.4	134.9	182.4	50.0	20.0	NO	HXT0714S-20CM
		10xD	149.9	177.4	179.8	227.4	50.0	20.0	YES	⚠ HXT1014S-20FM
		10xD	149.9	177.4	179.8	227.4	50.0	20.0	NO	⚠ HXT1014S-20CM
i	Straight	3xD	1-49/64	2-27/32	2-61/64	4-7/8	2-1/32	3/4	YES	HXT0314S-075F
		3xD	1-49/64	2-27/32	2-61/64	4-7/8	2-1/32	3/4	NO	HXT0314S-075C
		5xD	2-61/64	4-1/32	4-1/8	6-1/16	2-1/32	3/4	YES	HXT0514S-075F
		5xD	2-61/64	4-1/32	4-1/8	6-1/16	2-1/32	3/4	NO	HXT0514S-075C
		7xD	4-1/8	5-13/64	5-5/16	7-15/64	2-1/32	3/4	YES	HXT0714S-075F
		7xD	4-1/8	5-13/64	5-5/16	7-15/64	2-1/32	3/4	NO	HXT0714S-075C
		10xD	5-29/32	6-63/64	7-5/64	9-1/64	2-1/32	3/4	YES	⚠ HXT1014S-075F
		10xD	5-29/32	6-63/64	7-5/64	9-1/64	2-1/32	3/4	NO	⚠ HXT1014S-075C

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

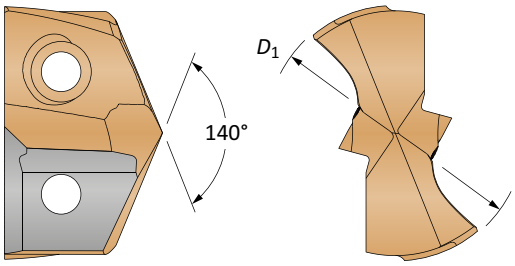
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	**D_1 mm**	**D_1 inch**	**Fractional Equivalent**	**Standard Part No.**	**Low Rake Part No.**	**Cast Iron Part No.**	**Stainless Part No.**
K35 (C1)	14.00	0.5512	–	**7C114P-14**	**7C114P-14LR**	–	–
	14.10	0.5551	–	**7C114P-14.1**	–	–	–
	14.20	0.5591	–	**7C114P-14.2**	–	–	–
	14.29	0.5625	9/16	**7C114P-0018**	**7C114P-0018LR**	–	–
	14.50	0.5709	–	**7C114P-14.5**	**7C114P-14.5LR**	–	–
	14.60	0.5748	–	**7C114P-14.6**	–		
	14.68	0.5781	37/64	**7C114P-.578**	**7C114P-.578LR**	–	–
	14.80	0.5827	–	**7C114P-14.8**	**7C114P-14.8LR**	–	–
K20 (C2)	14.00	0.5512	–	**7C214P-14**	**7C214P-14LR**	**7C214P-14CI**	**7C214P-14AS**
	14.10	0.5551	–	**7C214P-14.1**	–	–	–
	14.20	0.5591	–	**7C214P-14.2**	–	–	–
	14.29	0.5625	9/16	**7C214P-0018**	**7C214P-0018LR**	**7C214P-0018CI**	**7C214P-0018AS**
	14.50	0.5709	–	**7C214P-14.5**	**7C214P-14.5LR**	**7C214P-14.5CI**	**7C214P-14.5AS**
	14.60	0.5748	–	**7C214P-14.6**	–	–	–
	14.68	0.5781	37/64	**7C214P-.578**	**7C214P-.578LR**	**7C214P-.578CI**	**7C214P-.578AS**
	14.80	0.5827	–	**7C214P-14.8**	**7C214P-14.8LR**	**7C214P-14.8CI**	**7C214P-14.8AS**

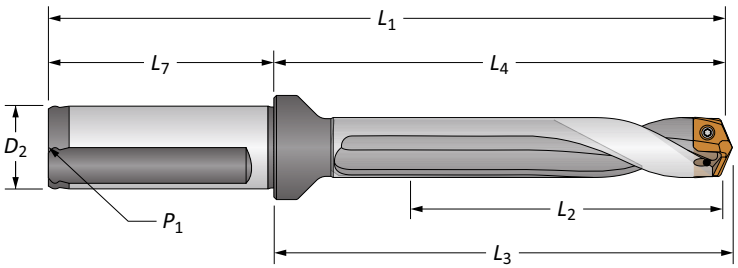
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

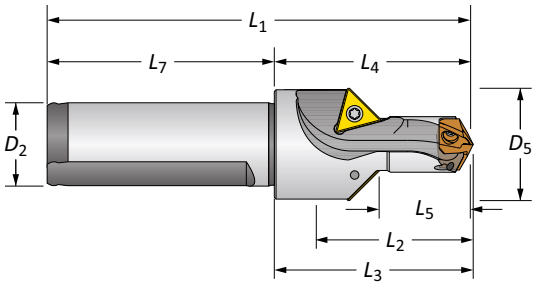
14 Series | Diameter Range: 14.00mm - 14.99mm (0.5512” - 0.5905”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	45.0	72.4	75.0	122.4	50.0	20.0	1/8*	YES	**60314S-20FM**
m	Straight	5xD	75.0	102.4	104.9	152.4	50.0	20.0	1/8*	YES	**60514S-20FM**
m	Straight	7xD	105.0	132.4	134.9	182.4	50.0	20.0	1/8*	YES	**60714S-20FM**
m	Helical	Stub	17.5	44.6	47.2	94.6	50.0	20.0	1/8*	YES	**60114H-20FM**
m	Helical	3xD	45.0	72.4	75.0	122.4	50.0	20.0	1/8*	YES	**60314H-20FM**
m	Helical	3xD	45.0	72.4	75.0	122.4	50.0	20.0	1/8*	NO	**60314H-20CM**
m	Helical	5xD	75.0	102.4	104.9	152.4	50.0	20.0	1/8*	YES	**60514H-20FM**
m	Helical	5xD	75.0	102.4	104.9	152.4	50.0	20.0	1/8*	NO	**60514H-20CM**
m	Helical	7xD	105.0	132.4	134.9	182.4	50.0	20.0	1/8*	YES	**60714H-20FM**
m	Helical	7xD	105.0	132.4	134.9	182.4	50.0	20.0	1/8*	NO	**60714H-20CM**
i	Straight	3xD	1-49/64	2-27/32	2-61/64	4-7/8	2-1/32	3/4	1/8	YES	**60314S-075F**
i	Straight	5xD	2-61/64	4-1/32	4-1/8	6-1/16	2-1/32	3/4	1/8	YES	**60514S-075F**
i	Straight	7xD	4-1/8	5-13/64	5-5/16	7-15/64	2-1/32	3/4	1/8	YES	**60714S-075F**
i	Helical	Stub	11/16	1-3/4	1-55/64	3-25/32	2-1/32	3/4	1/8	YES	**60114H-075F**
i	Helical	3xD	1-49/64	2-27/32	2-61/64	4-7/8	2-1/32	3/4	1/8	YES	**60314H-075F**
i	Helical	3xD	1-49/64	2-27/32	2-61/64	4-7/8	2-1/32	3/4	1/8	NO	**60314H-075C**
i	Helical	5xD	2-61/64	4-1/32	4-1/8	6-1/16	2-1/32	3/4	1/8	YES	**60514H-075F**
i	Helical	5xD	2-61/64	4-1/32	4-1/8	6-1/16	2-1/32	3/4	1/8	NO	**60514H-075C**
i	Helical	7xD	4-1/8	5-13/64	5-5/16	7-15/64	2-1/32	3/4	1/8	YES	**60714H-075F**
i	Helical	7xD	4-1/8	5-13/64	5-5/16	7-15/64	2-1/32	3/4	1/8	NO	**60714H-075C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	26.7	21.0	26.8	44.6	47.2	94.6	50.0	20.0	**60114C45-20FM**	TCMT-110204
i	1-3/64	53/64	1-3/64	1-3/4	1-55/64	3-25/32	2-1/32	3/4	**60114C45-075F**	TCMT-110204

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

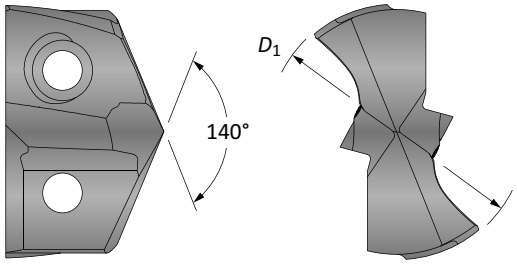
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
15.00	0.5906	–	**XTP15-15.00**	**XTK15-15.00**	**XTN15-15.00**
15.08	0.5938	19/32	**XTP15-15.08**	**XTK15-15.08**	**XTN15-15.08**
15.20	0.5984	–	**XTP15-15.20**	**XTK15-15.20**	**XTN15-15.20**
15.30	0.6024	–	**XTP15-15.30**	**XTK15-15.30**	**XTN15-15.30**
15.40	0.6063	–	**XTP15-15.40**	**XTK15-15.40**	**XTN15-15.40**
15.48	0.6094	33/64	**XTP15-15.48**	**XTK15-15.48**	**XTN15-15.48**
15.50	0.6102	–	**XTP15-15.50**	**XTK15-15.50**	**XTN15-15.50**
15.60	0.6142	–	**XTP15-15.60**	**XTK15-15.60**	**XTN15-15.60**
15.70	0.6181	–	**XTP15-15.70**	**XTK15-15.70**	**XTN15-15.70**
15.80	0.6220	–	**XTP15-15.80**	**XTK15-15.80**	**XTN15-15.80**
15.88	0.6250	5/8	**XTP15-15.88**	**XTK15-15.88**	**XTN15-15.88**

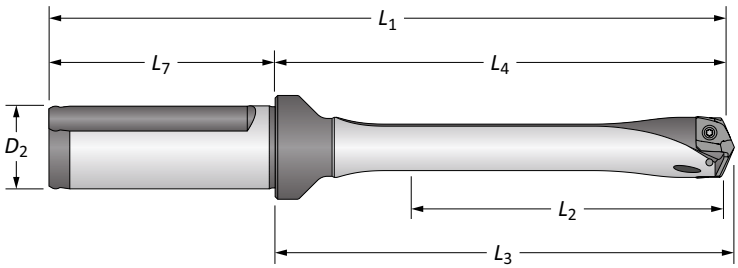
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Body Length	L_2	L_4	L_3	L_1	Shank L_7	D_2	Flat	Part No.
m	Straight	3xD	48.0	75.1	77.6	125.1	50.0	20.0	YES	HXT0315S-20FM
		3xD	48.0	75.1	77.6	125.1	50.0	20.0	NO	HXT0315S-20CM
		5xD	80.0	107.0	109.6	157.0	50.0	20.0	YES	HXT0515S-20FM
		5xD	80.0	107.0	109.6	157.0	50.0	20.0	NO	HXT0515S-20CM
		7xD	112.0	139.0	141.6	189.0	50.0	20.0	YES	HXT0715S-20FM
		7xD	112.0	139.0	141.6	189.0	50.0	20.0	NO	HXT0715S-20CM
		10xD	159.9	186.9	189.5	236.9	50.0	20.0	YES	⚠ HXT1015S-20FM
		10xD	159.9	186.9	189.5	236.9	50.0	20.0	NO	⚠ HXT1015S-20CM
i	Straight	3xD	1-57/64	2-61/64	3-3/64	4-63/64	2-1/32	3/4	YES	HXT0315S-075F
		3xD	1-57/64	2-61/64	3-3/64	4-63/64	2-1/32	3/4	NO	HXT0315S-075C
		5xD	3-9/64	4-13/64	4-5/16	6-15/64	2-1/32	3/4	YES	HXT0515S-075F
		5xD	3-9/64	4-13/64	4-5/16	6-15/64	2-1/32	3/4	NO	HXT0515S-075C
		7xD	4-13/32	5-15/32	5-37/64	7-1/2	2-1/32	3/4	YES	HXT0715S-075F
		7xD	4-13/32	5-15/32	5-37/64	7-1/2	2-1/32	3/4	NO	HXT0715S-075C
		10xD	6-19/64	7-23/64	7-29/64	9-25/64	2-1/32	3/4	YES	⚠ HXT1015S-075F
		10xD	6-19/64	7-23/64	7-29/64	9-25/64	2-1/32	3/4	NO	⚠ HXT1015S-075C

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

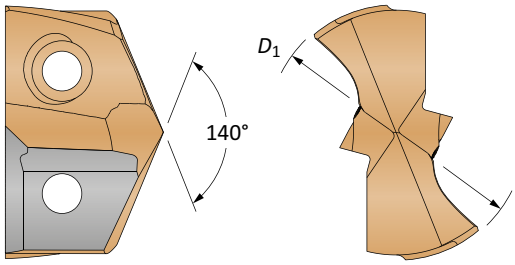
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	D_1 mm	D_1 inch	Fractional Equivalent	Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
K35 (C1)	15.00	0.5906	–	**7C115P-15**	**7C115P-15LR**	–	–
	15.08	0.5938	19/32	**7C115P-0019**	**7C115P-0019LR**	–	–
	15.25	0.6004	–	**7C115P-15.25**	**7C115P-15.25LR**	–	–
	15.30	0.6024	–	**7C115P-15.3**	–	–	–
	15.48	0.6094	39/64	**7C115P-.609**	**7C115P-.609LR**	–	–
	15.50	0.6103	–	**7C115P-15.5**	**7C115P-15.5LR**	–	–
	15.60	0.6142	–	**7C115P-15.6**	–	–	–
	15.70	0.6181	–	**7C115P-.618**	**7C115P-.618LR**	–	–
	15.80	0.6220	–	**7C115P-15.8**	–	–	–
	15.88	0.6250	5/8	**7C115P-0020**	**7C115P-0020LR**	–	–
K20 (C2)	15.00	0.5906	–	**7C215P-15**	**7C215P-15LR**	**7C215P-15CI**	**7C215P-15AS**
	15.08	0.5938	19/32	**7C215P-0019**	**7C215P-0019LR**	**7C215P-0019CI**	**7C215P-0019AS**
	15.25	0.6004	–	**7C215P-15.25**	**7C215P-15.25LR**	**7C215P-15.25CI**	**7C215P-15.25AS**
	15.30	0.6024	–	**7C215P-15.3**	–	–	–
	15.48	0.6094	39/64	**7C215P-.609**	**7C215P-.609LR**	**7C215P-.609CI**	**7C215P-.609AS**
	15.50	0.6103	–	**7C215P-15.5**	**7C215P-15.5LR**	**7C215P-15.5CI**	**7C215P-15.5AS**
	15.60	0.6142	–	**7C215P-15.6**	–	–	–
	15.70	0.6181	–	**7C215P-.618**	**7C215P-.618LR**	**7C215P-.618CI**	**7C215P-.618AS**
	15.80	0.6220	–	**7C215P-15.8**	–	–	–
	15.88	0.6250	5/8	**7C215P-0020**	**7C215P-0020LR**	**7C215P-0020CI**	**7C215P-0020AS**

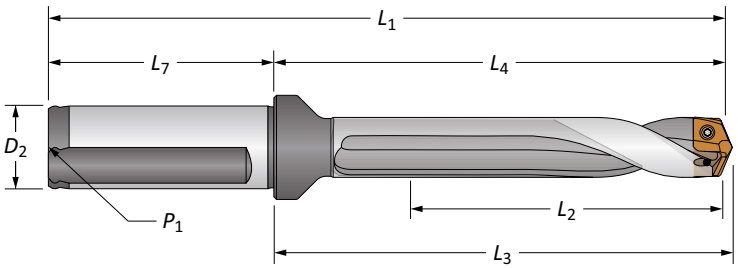
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

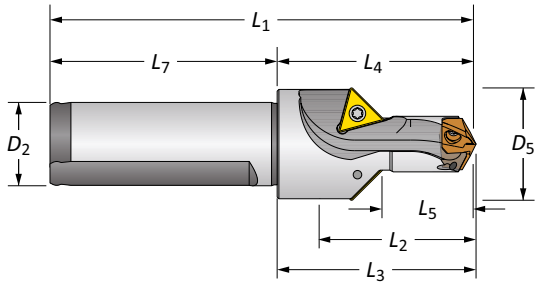
15 Series | Diameter Range: 15.00mm - 15.99mm (0.5906” - 0.6298”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	48.0	75.1	77.6	125.1	50.0	20.0	1/8*	YES	**60315S-20FM**
		5xD	80.0	107.0	109.6	157.0	50.0	20.0	1/8*	YES	**60515S-20FM**
		7xD	112.0	139.0	141.6	189.0	50.0	20.0	1/8*	YES	**60715S-20FM**
	Helical	Stub	17.5	44.3	46.8	94.3	50.0	20.0	1/8*	YES	**60115H-20FM**
		3xD	48.0	75.1	77.6	125.1	50.0	20.0	1/8*	YES	**60315H-20FM**
		3xD	48.0	75.1	77.6	125.1	50.0	20.0	1/8*	NO	**60315H-20CM**
		5xD	80.0	107.0	109.6	157.0	50.0	20.0	1/8*	YES	**60515H-20FM**
		5xD	80.0	107.0	109.6	157.0	50.0	20.0	1/8*	NO	**60515H-20CM**
		7xD	112.0	139.0	141.6	189.0	50.0	20.0	1/8*	YES	**60715H-20FM**
		7xD	112.0	139.0	141.6	189.0	50.0	20.0	1/8*	NO	**60715H-20CM**
i	Straight	3xD	1-57/64	2-61/64	3-3/64	4-63/64	2-1/32	3/4	1/8	YES	**60315S-075F**
		5xD	3-9/64	4-13/64	4-5/16	6-15/64	2-1/32	3/4	1/8	YES	**60515S-075F**
		7xD	4-13/32	5-15/32	5-37/64	7-1/2	2-1/32	3/4	1/8	YES	**60715S-075F**
	Helical	Stub	11/16	1-3/4	1-27/32	3-25/32	2-1/32	3/4	1/8	YES	**60115H-075F**
		3xD	1-57/64	2-61/64	3-3/64	4-63/64	2-1/32	3/4	1/8	YES	**60315H-075F**
		3xD	1-57/64	2-61/64	3-3/64	4-63/64	2-1/32	3/4	1/8	NO	**60315H-075C**
		5xD	3-9/64	4-13/64	4-5/16	6-15/64	2-1/32	3/4	1/8	YES	**60515H-075F**
		5xD	3-9/64	4-13/64	4-5/16	6-15/64	2-1/32	3/4	1/8	NO	**60515H-075C**
		7xD	4-13/32	5-15/32	5-37/64	7-1/2	2-1/32	3/4	1/8	YES	**60715H-075F**
		7xD	4-13/32	5-15/32	5-37/64	7-1/2	2-1/32	3/4	1/8	NO	**60715H-075C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	27.0	22.5	26.9	44.3	46.8	94.3	50.0	20.0	**60115C45-20FM**	TCMT-110204
i	1-1/16	57/64	1-1/16	1-47/64	1-27/32	3-49/64	2-1/32	3/4	**60115C45-075F**	TCMT-110204

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	84 N-cm (7.4 in-lbs)

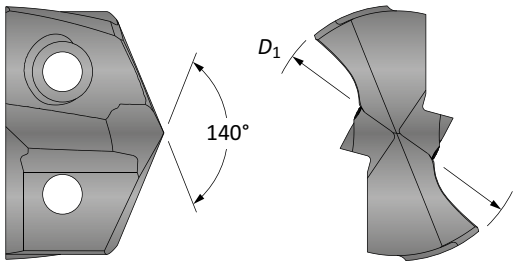
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
16.00	0.6299	–	**XTP16-16.00**	**XTK16-16.00**	**XTN16-16.00**
16.08	0.6331	–	**XTP16-16.08**	**XTK16-16.08**	**XTN16-16.08**
16.20	0.6378	–	**XTP16-16.20**	**XTK16-16.20**	**XTN16-16.20**
16.27	0.6406	41/64	**XTP16-16.27**	**XTK16-16.27**	**XTN16-16.27**
16.40	0.6457	–	**XTP16-16.40**	**XTK16-16.40**	**XTN16-16.40**
16.50	0.6496	–	**XTP16-16.50**	**XTK16-16.50**	**XTN16-16.50**
16.60	0.6535	–	**XTP16-16.60**	**XTK16-16.60**	**XTN16-16.60**
16.67	0.6563	21/32	**XTP16-16.67**	**XTK16-16.67**	**XTN16-16.67**
16.80	0.6614	–	**XTP16-16.80**	**XTK16-16.80**	**XTN16-16.80**
16.90	0.6654	–	**XTP16-16.90**	**XTK16-16.90**	**XTN16-16.90**

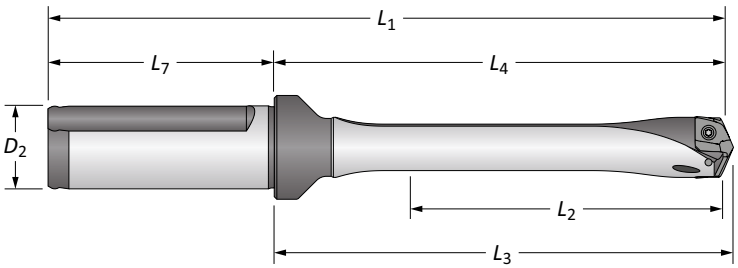
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Body Length	L_2	L_4	L_3	L_1	Shank L_7	D_2	Flat	Part No.
m	Straight	3xD	51.0	81.3	84.2	131.3	50.0	20.0	YES	HXT0316S-20FM
		3xD	51.0	81.3	84.2	131.3	50.0	20.0	NO	HXT0316S-20CM
		5xD	85.0	115.3	118.2	165.3	50.0	20.0	YES	HXT0516S-20FM
		5xD	85.0	115.3	118.2	165.3	50.0	20.0	NO	HXT0516S-20CM
		7xD	119.0	149.3	152.2	199.3	50.0	20.0	YES	HXT0716S-20FM
		7xD	119.0	149.3	152.2	199.3	50.0	20.0	NO	HXT0716S-20CM
		10xD	169.9	200.0	203.2	250.0	50.0	20.0	YES	⚠ HXT1016S-20FM
		10xD	169.9	200.0	203.2	250.0	50.0	20.0	NO	⚠ HXT1016S-20CM
i	Straight	3xD	2	3-13/64	3-5/16	5-15/64	2-1/32	3/4	YES	HXT0316S-075F
		3xD	2	3-13/64	3-5/16	5-15/64	2-1/32	3/4	NO	HXT0316S-075C
		5xD	3-11/32	4-17/32	4-21/32	6-9/16	2-1/32	3/4	YES	HXT0516S-075F
		5xD	3-11/32	4-17/32	4-21/32	6-9/16	2-1/32	3/4	NO	HXT0516S-075C
		7xD	4-11/16	5-7/8	5-63/64	7-29/32	2-1/32	3/4	YES	HXT0716S-075F
		7xD	4-11/16	5-7/8	5-63/64	7-29/32	2-1/32	3/4	NO	HXT0716S-075C
		10xD	6-11/16	7-7/8	8	9-29/32	2-1/32	3/4	YES	⚠ HXT1016S-075F
		10xD	6-11/16	7-7/8	8	9-29/32	2-1/32	3/4	NO	⚠ HXT1016S-075C

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
72556-IP8-1	72556N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)

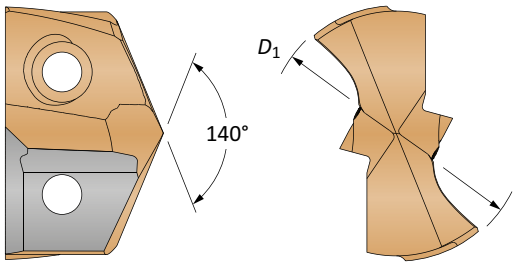
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	D_1 mm	D_1 inch	Fractional Equivalent	Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
K35 (C1)	16.00	0.6299	–	**7C116P-16**	**7C116P-16LR**	–	–
	16.08	0.6331	–	**7C116P-16.08**	**7C116P-16.08LR**	–	–
	16.27	0.6406	41/64	**7C116P-.640**	**7C116P-.640LR**	–	–
	16.50	0.6496	–	**7C116P-16.5**	**7C116P-16.5LR**	–	–
	16.67	0.6563	21/32	**7C116P-0021**	**7C116P-0021LR**	–	–
K20 (C2)	16.00	0.6299	–	**7C216P-16**	**7C216P-16LR**	**7C216P-16CI**	**7C216P-16AS**
	16.08	0.6331	–	**7C216P-16.08**	**7C216P-16.08LR**	**7C216P-16.08CI**	**7C216P-16.08AS**
	16.27	0.6406	41/64	**7C216P-.640**	**7C216P-.640LR**	**7C216P-.640CI**	**7C216P-.640AS**
	16.50	0.6496	–	**7C216P-16.5**	**7C216P-16.5LR**	**7C216P-16.5CI**	**7C216P-16.5AS**
	16.67	0.6563	21/32	**7C216P-0021**	**7C216P-0021LR**	**7C216P-0021CI**	**7C216P-0021AS**

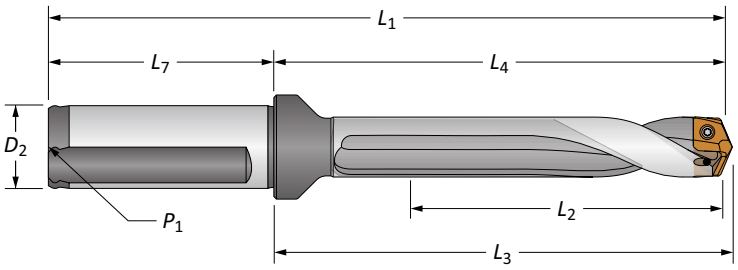
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

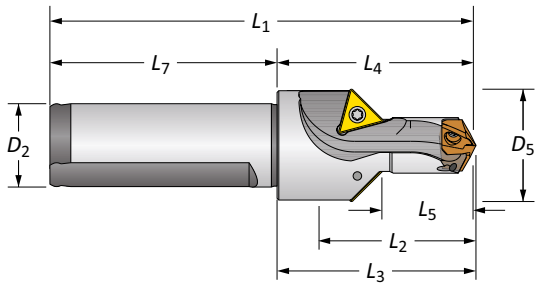
16 Series | Diameter Range: 16.00mm - 16.99mm (0.6299” - 0.6692”)



Straight and Helical

	Flute	Body Length	L_2	L_4	L_3	L_1	Shank L_7	D_2	P_1	Flat	Part No.
m	Straight	3xD	51.0	81.3	84.2	131.3	50.0	20.0	1/8*	YES	**60316S-20FM**
		5xD	85.0	115.3	118.2	165.3	50.0	20.0	1/8*	YES	**60516S-20FM**
		7xD	119.0	149.3	152.2	199.3	50.0	20.0	1/8*	YES	**60716S-20FM**
	Helical	Stub	21.0	50.8	53.7	100.8	50.0	20.0	1/8*	YES	**60116H-20FM**
		3xD	51.0	81.3	84.2	131.3	50.0	20.0	1/8*	YES	**60316H-20FM**
		3xD	51.0	81.3	84.2	131.3	50.0	20.0	1/8*	NO	**60316H-20CM**
		5xD	85.0	115.3	118.2	165.3	50.0	20.0	1/8*	YES	**60516H-20FM**
		5xD	85.0	115.3	118.2	165.3	50.0	20.0	1/8*	NO	**60516H-20CM**
		7xD	119.0	149.3	152.2	199.3	50.0	20.0	1/8*	YES	**60716H-20FM**
		7xD	119.0	149.3	152.2	199.3	50.0	20.0	1/8*	NO	**60716H-20CM**
i	Straight	3xD	2	3-13/64	3-5/16	5-15/64	2-1/32	3/4	1/8	YES	**60316S-075F**
		5xD	3-11/32	4-17/32	4-21/32	6-9/16	2-1/32	3/4	1/8	YES	**60516S-075F**
		7xD	4-11/16	5-7/8	5-63/64	7-29/32	2-1/32	3/4	1/8	YES	**60716S-075F**
	Helical	Stub	13/16	2	2-7/64	4-1/32	2-1/32	3/4	1/8	YES	**60116H-075F**
		3xD	2	3-13/64	3-5/16	5-15/64	2-1/32	3/4	1/8	YES	**60316H-075F**
		3xD	2	3-13/64	3-5/16	5-15/64	2-1/32	3/4	1/8	NO	**60316H-075C**
		5xD	3-11/32	4-17/32	4-21/32	6-9/16	2-1/32	3/4	1/8	YES	**60516H-075F**
		5xD	3-11/32	4-17/32	4-21/32	6-9/16	2-1/32	3/4	1/8	NO	**60516H-075C**
		7xD	4-11/16	5-7/8	5-63/64	7-29/32	2-1/32	3/4	1/8	YES	**60716H-075F**
		7xD	4-11/16	5-7/8	5-63/64	7-29/32	2-1/32	3/4	1/8	NO	**60716H-075C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	L_5	Body L_2	L_4	L_3	L_1	Shank L_7	D_2	Part No.	Chamfer Insert
m	27.0	24.0	33.1	50.8	53.7	100.8	50.0	20.0	**60116C45-20FM**	TCMT-110204
i	1-1/16	61/64	1-19/64	2	2-7/64	4-1/32	2-1/32	3/4	**60116C45-075F**	TCMT-110204

Connection Accessories

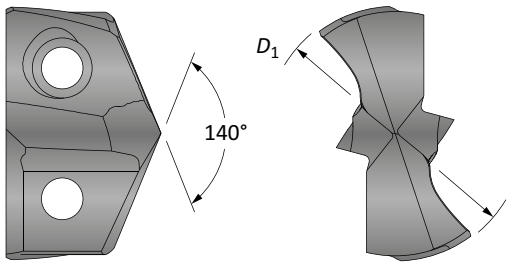
Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
72556-IP8-1	72556N-IP8-1	8IP-8	8IP-8TL	8IP-8B	175 N-cm (15.5 in-lbs)

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

m = Metric (mm)
Chamfer inserts sold separately in multiples of 10 | Screws sold in multiples of 10 i = Imperial (in)

GEN3SYS®XT Pro Drill Inserts

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



Insert			Part No.	Part No.	Part No.
D_1 mm	D_1 inch	Fractional Equivalent	P	K	N
17.00	0.6693	–	**XTP17-17.00**	**XTK17-17.00**	**XTN17-17.00**
17.07	0.6719	43/64	**XTP17-17.07**	**XTK17-17.07**	**XTN17-17.07**
17.10	0.6732	–	**XTP17-17.10**	**XTK17-17.10**	**XTN17-17.10**
17.20	0.6772	–	**XTP17-17.20**	**XTK17-17.20**	**XTN17-17.20**
17.30	0.6811	–	**XTP17-17.30**	**XTK17-17.30**	**XTN17-17.30**
17.40	0.6850	–	**XTP17-17.40**	**XTK17-17.40**	**XTN17-17.40**
17.46	0.6875	11/16	**XTP17-17.46**	**XTK17-17.46**	**XTN17-17.46**
17.50	0.6890	–	**XTP17-17.50**	**XTK17-17.50**	**XTN17-17.50**
17.60	0.6929	–	**XTP17-17.60**	**XTK17-17.60**	**XTN17-17.60**
17.70	0.6969	–	**XTP17-17.70**	**XTK17-17.70**	**XTN17-17.70**
17.80	0.7008	–	**XTP17-17.80**	**XTK17-17.80**	**XTN17-17.80**
17.86	0.7031	45/64	**XTP17-17.86**	**XTK17-17.86**	**XTN17-17.86**
17.90	0.7047	–	**XTP17-17.90**	**XTK17-17.90**	**XTN17-17.90**

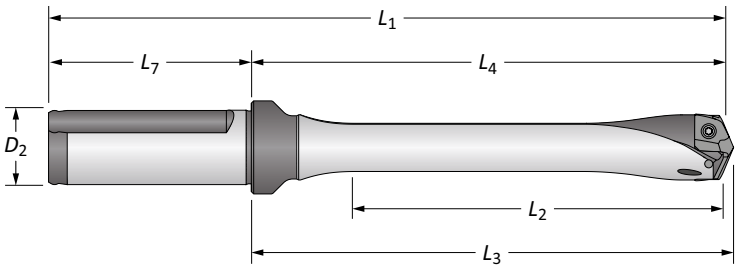
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank Flat	Part No.
m	Straight	3xD	54.0	84.1	87.0	134.1	50.0	20.0	YES	HXT0317S-20FM
		3xD	54.0	84.1	87.0	134.1	50.0	20.0	NO	HXT0317S-20CM
		5xD	90.0	120.0	122.9	170.0	50.0	20.0	YES	HXT0517S-20FM
		5xD	90.0	120.0	122.9	170.0	50.0	20.0	NO	HXT0517S-20CM
		7xD	126.0	156.0	158.9	206.0	50.0	20.0	YES	HXT0717S-20FM
		7xD	126.0	156.0	158.9	206.0	50.0	20.0	NO	HXT0717S-20CM
		10xD	179.8	209.9	212.8	259.9	50.0	20.0	YES	⚠ HXT1017S-20FM
		10xD	179.8	209.9	212.8	259.9	50.0	20.0	NO	⚠ HXT1017S-20CM
i	Straight	3xD	2-1/8	3-19/64	3-27/64	5-21/64	2-1/32	3/4	YES	HXT0317S-075F
		3xD	2-1/8	3-19/64	3-27/64	5-21/64	2-1/32	3/4	NO	HXT0317S-075C
		5xD	3-35/64	4-23/32	4-27/32	6-3/4	2-1/32	3/4	YES	HXT0517S-075F
		5xD	3-35/64	4-23/32	4-27/32	6-3/4	2-1/32	3/4	NO	HXT0517S-075C
		7xD	4-61/64	6-9/64	6-1/4	8-11/64	2-1/32	3/4	YES	HXT0717S-075F
		7xD	4-61/64	6-9/64	6-1/4	8-11/64	2-1/32	3/4	NO	HXT0717S-075C
		10xD	7-5/64	8-17/64	8-3/8	10-19/64	2-1/32	3/4	YES	⚠ HXT1017S-075F
		10xD	7-5/64	8-17/64	8-3/8	10-19/64	2-1/32	3/4	NO	⚠ HXT1017S-075C

Connection Accessories

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

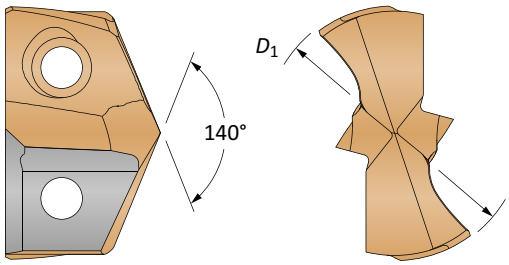
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	**D_1 mm**	**D_1 inch**	**Fractional Equivalent**	**Standard Part No.**	**Low Rake Part No.**	**Cast Iron Part No.**	**Stainless Part No.**
K35 (C1)	17.00	0.6693		**7C117P-17**	**7C117P-17LR**	–	–
	17.07	0.6719	43/64	**7C117P-.671**	**7C117P-.671LR**	–	–
	17.10	0.6732		**7C117P-17.1**	**7C117P-17.1LR**	–	–
	17.20	0.6772		**7C117P-17.2**	**7C117P-17.2LR**	–	–
	17.46	0.6875	11/16	**7C117P-0022**	**7C117P-0022LR**	–	–
	17.50	0.6890		**7C117P-17.5**	**7C117P-17.5LR**	–	–
	17.86	0.7031	45/64	**7C117P-.703**	**7C117P-.703LR**	–	–
K20 (C2)	17.00	0.6693		**7C217P-17**	**7C217P-17LR**	**7C217P-17CI**	**7C217P-17AS**
	17.07	0.6719	43/64	**7C217P-.671**	**7C217P-.671LR**	**7C217P-.671CI**	**7C217P-.671AS**
	17.10	0.6732		**7C217P-17.1**	**7C217P-17.1LR**	**7C217P-17.1CI**	**7C217P-17.1AS**
	17.20	0.6772		**7C217P-17.2**	**7C217P-17.2LR**	**7C217P-17.2CI**	**7C217P-17.2AS**
	17.46	0.6875	11/16	**7C217P-0022**	**7C217P-0022LR**	**7C217P-0022CI**	**7C217P-0022AS**
	17.50	0.6890		**7C217P-17.5**	**7C217P-17.5LR**	**7C217P-17.5CI**	**7C217P-17.5AS**
	17.86	0.7031	45/64	**7C217P-.703**	**7C217P-.703LR**	**7C217P-.703CI**	**7C217P-.703AS**

Inserts sold in multiples of 1

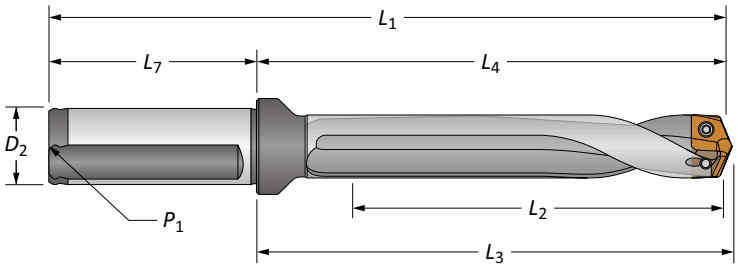
A2: 66 - 75
Key on A2: 1

A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

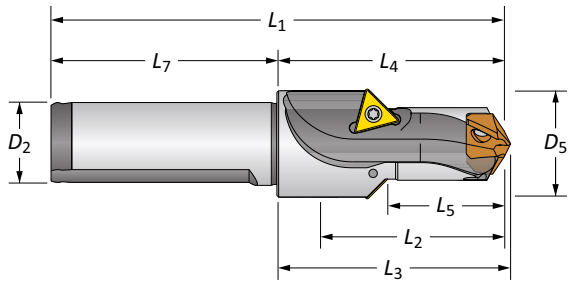
17 Series | Diameter Range: 17.00mm - 17.99mm (0.6693” - 0.7086”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	54.0	84.1	87.0	134.1	50.0	20.0	1/8*	YES	**60317S-20FM**
		5xD	90.0	120.0	122.9	170.0	50.0	20.0	1/8*	YES	**60517S-20FM**
		7xD	126.0	156.0	158.9	206.0	50.0	20.0	1/8*	YES	**60717S-20FM**
	Helical	Stub	21.0	50.5	53.4	100.5	50.0	20.0	1/8*	YES	**60117H-20FM**
		3xD	54.0	84.1	87.0	134.1	50.0	20.0	1/8*	YES	**60317H-20FM**
		3xD	54.0	84.1	87.0	134.1	50.0	20.0	1/8*	NO	**60317H-20CM**
		5xD	90.0	120.0	122.9	170.0	50.0	20.0	1/8*	YES	**60517H-20FM**
		5xD	90.0	120.0	122.9	170.0	50.0	20.0	1/8*	NO	**60517H-20CM**
		7xD	126.0	156.0	158.9	206.0	50.0	20.0	1/8*	YES	**60717H-20FM**
		7xD	126.0	156.0	158.9	206.0	50.0	20.0	1/8*	NO	**60717H-20CM**
i	Straight	3xD	2-1/8	3-19/64	3-27/64	5-21/64	2-1/32	3/4	1/8	YES	**60317S-075F**
		5xD	3-35/64	4-23/32	4-27/32	6-3/4	2-1/32	3/4	1/8	YES	**60517S-075F**
		7xD	4-61/64	6-9/64	6-1/4	8-11/64	2-1/32	3/4	1/8	YES	**60717S-075F**
	Helical	Stub	13/16	1-63/64	2-7/64	4-1/64	2-1/32	3/4	1/8	YES	**60117H-075F**
		3xD	2-1/8	3-19/64	3-27/64	5-21/64	2-1/32	3/4	1/8	YES	**60317H-075F**
		3xD	2-1/8	3-19/64	3-27/64	5-21/64	2-1/32	3/4	1/8	NO	**60317H-075C**
		5xD	3-35/64	4-23/32	4-27/32	6-3/4	2-1/32	3/4	1/8	YES	**60517H-075F**
		5xD	3-35/64	4-23/32	4-27/32	6-3/4	2-1/32	3/4	1/8	NO	**60517H-075C**
		7xD	4-61/64	6-9/64	6-1/4	8-11/64	2-1/32	3/4	1/8	YES	**60717H-075F**
		7xD	4-61/64	6-9/64	6-1/4	8-11/64	2-1/32	3/4	1/8	NO	**60717H-075C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	25.4	25.5	33.3	50.5	53.4	108.6	50.0	20.0	**60117C45-20FM**	TCMT-110204
i	1	1	1-5/16	1-63/64	2-7/64	4-1/64	2-1/32	3/4	**60117C45-075F**	TCMT-110204

Connection Accessories

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

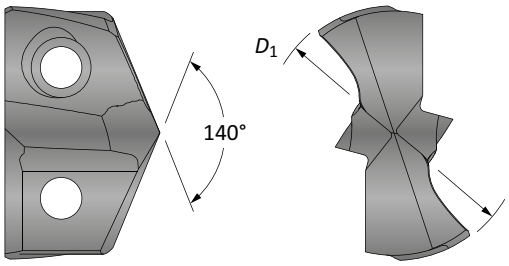
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert			Part No.	Part No.	Part No.
D_1 mm	D_1 inch	Fractional Equivalent	P	K	N
18.00	0.7087	–	XTP18-18.00	XTK18-18.00	XTN18-18.00
18.10	0.7126	–	XTP18-18.10	XTK18-18.10	XTN18-18.10
18.20	0.7165	–	XTP18-18.20	XTK18-18.20	XTN18-18.20
18.26	0.7188	23/32	XTP18-18.26	XTK18-18.26	XTN18-18.26
18.30	0.7205	–	XTP18-18.30	XTK18-18.30	XTN18-18.30
18.40	0.7244	–	XTP18-18.40	XTK18-18.40	XTN18-18.40
18.50	0.7283	–	XTP18-18.50	XTK18-18.50	XTN18-18.50
18.60	0.7323	–	XTP18-18.60	XTK18-18.60	XTN18-18.60
18.65	0.7344	47/64	XTP18-18.65	XTK18-18.65	XTN18-18.65
18.70	0.7362	–	XTP18-18.70	XTK18-18.70	XTN18-18.70
18.80	0.7402	–	XTP18-18.80	XTK18-18.80	XTN18-18.80
18.90	0.7441	–	XTP18-18.90	XTK18-18.90	XTN18-18.90
19.00	0.7480	–	XTP18-19.00	XTK18-19.00	XTN18-19.00
19.05	0.7500	3/4	XTP18-19.05	XTK18-19.05	XTN18-19.05
19.10	0.7520	–	XTP18-19.10	XTK18-19.10	XTN18-19.10
19.20	0.7559	–	XTP18-19.20	XTK18-19.20	XTN18-19.20
19.25	0.7580	–	XTP18-19.25	XTK18-19.25	XTN18-19.25
19.30	0.7598	–	XTP18-19.30	XTK18-19.30	XTN18-19.30
19.40	0.7638	–	XTP18-19.40	XTK18-19.40	XTN18-19.40
19.45	0.7656	49/64	XTP18-19.45	XTK18-19.45	XTN18-19.45
19.50	0.7677	–	XTP18-19.50	XTK18-19.50	XTN18-19.50
19.60	0.7717	–	XTP18-19.60	XTK18-19.60	XTN18-19.60
19.70	0.7756	–	XTP18-19.70	XTK18-19.70	XTN18-19.70
19.80	0.7795	–	XTP18-19.80	XTK18-19.80	XTN18-19.80
19.84	0.7813	25/32	XTP18-19.84	XTK18-19.84	XTN18-19.84
19.90	0.7835	–	XTP18-19.90	XTK18-19.90	XTN18-19.90

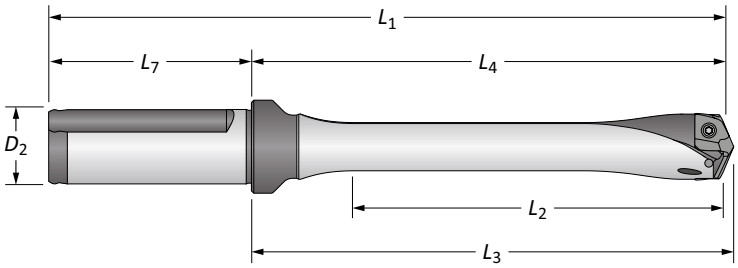
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Flat	Part No.
m	Straight	3xD	60.0	94.0	96.8	150.0	56.0	25.0	YES	HXT0318S-25FM
		3xD	60.0	94.0	96.8	150.0	56.0	25.0	NO	HXT0318S-25CM
		5xD	100.0	134.0	136.8	190.0	56.0	25.0	YES	HXT0518S-25FM
		5xD	100.0	134.0	136.8	190.0	56.0	25.0	NO	HXT0518S-25CM
		7xD	140.0	174.0	176.8	230.0	56.0	25.0	YES	HXT0718S-25FM
		7xD	140.0	174.0	176.8	230.0	56.0	25.0	NO	HXT0718S-25CM
		10xD	199.9	234.1	236.7	290.1	56.0	25.0	YES	⚠ HXT1018S-25FM
		10xD	199.9	234.1	236.7	290.1	56.0	25.0	NO	⚠ HXT1018S-25CM
i	Straight	3xD	2-23/64	3-45/64	3-13/16	5-63/64	2-9/32	1	YES	HXT0318S-100F
		3xD	2-23/64	3-45/64	3-13/16	5-63/64	2-9/32	1	NO	HXT0318S-100C
		5xD	3-15/16	5-17/64	5-25/64	7-35/64	2-9/32	1	YES	HXT0518S-100F
		5xD	3-15/16	5-17/64	5-25/64	7-35/64	2-9/32	1	NO	HXT0518S-100C
		7xD	5-33/64	6-27/32	6-61/64	9-1/8	2-9/32	1	YES	HXT0718S-100F
		7xD	5-33/64	6-27/32	6-61/64	9-1/8	2-9/32	1	NO	HXT0718S-100C
		10xD	7-7/8	9-7/32	9-5/16	11-31/64	2-9/32	1	YES	⚠ HXT1018S-100F
		10xD	7-7/8	9-7/32	9-5/16	11-31/64	2-9/32	1	NO	⚠ HXT1018S-100C

Connection Accessories

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

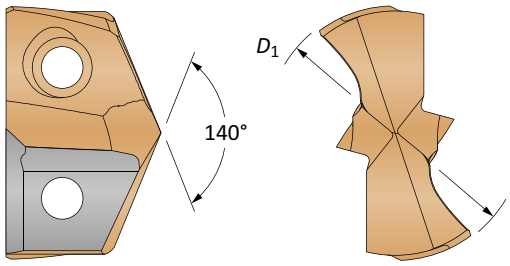
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	**D_1 mm**	**D_1 inch**	**Fractional Equivalent**	**Standard Part No.**	**Low Rake Part No.**	**Cast Iron Part No.**	**Stainless Part No.**
K35 (C1)	18.00	0.7087	–	**7C118P-18**	**7C118P-18LR**	–	–
	18.26	0.7188	23/32	**7C118P-0023**	**7C118P-0023LR**	–	–
	18.50	0.7283	–	**7C118P-18.5**	**7C118P-18.5LR**	–	–
	18.65	0.7344	47/64	**7C118P-.734**	**7C118P-.734LR**	–	–
	19.00	0.7480	–	**7C118P-19**	**7C118P-19LR**	–	–
	19.05	0.7500	3/4	**7C118P-0024**	**7C118P-0024LR**	–	–
	19.25	0.7580	–	**7C118P-.758**	**7C118P-.758LR**	–	–
	19.45	0.7656	49/64	**7C118P-.765**	**7C118P-.765LR**	–	–
	19.50	0.7677	–	**7C118P-19.5**	**7C118P-19.5LR**	–	–
	19.80	0.7795	–	**7C118P-19.8**	**7C118P-19.8LR**	–	–
	19.85	0.7813	25/32	**7C118P-0025**	**7C118P-0025LR**	–	–
K20 (C2)	18.00	0.7087	–	**7C218P-18**	**7C218P-18LR**	**7C218P-18CI**	**7C218P-18AS**
	18.26	0.7188	23/32	**7C218P-0023**	**7C218P-0023LR**	**7C218P-0023CI**	**7C218P-0023AS**
	18.50	0.7283	–	**7C218P-18.5**	**7C218P-18.5LR**	**7C218P-18.5CI**	**7C218P-18.5AS**
	18.65	0.7344	47/64	**7C218P-.734**	**7C218P-.734LR**	**7C218P-.734CI**	**7C218P-.734AS**
	19.00	0.7480	–	**7C218P-19**	**7C218P-19LR**	**7C218P-19CI**	**7C218P-19AS**
	19.05	0.7500	3/4	**7C218P-0024**	**7C218P-0024LR**	**7C218P-0024CI**	**7C218P-0024AS**
	19.25	0.7580	–	**7C218P-.758**	**7C218P-.758LR**	**7C218P-.758CI**	**7C218P-.758AS**
	19.45	0.7656	49/64	**7C218P-.765**	**7C218P-.765LR**	**7C218P-.765CI**	**7C218P-.765AS**
	19.50	0.7677	–	**7C218P-19.5**	**7C218P-19.5LR**	**7C218P-19.5CI**	**7C218P-19.5AS**
	19.80	0.7795	–	**7C218P-19.8**	**7C218P-19.8LR**	**7C218P-19.8CI**	**7C218P-19.8AS**
	19.85	0.7813	25/32	**7C218P-0025**	**7C218P-0025LR**	**7C218P-0025CI**	**7C218P-0025AS**

Inserts sold in multiples of 1

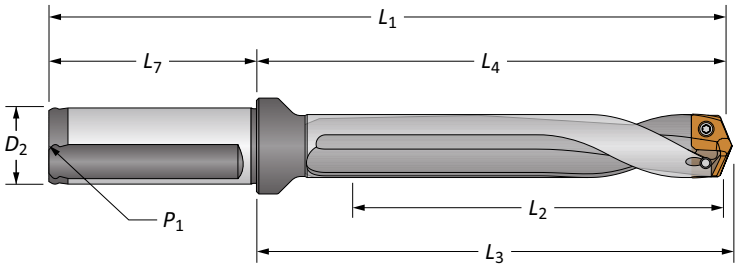
A2: 66 - 75
Key on A2: 1

A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

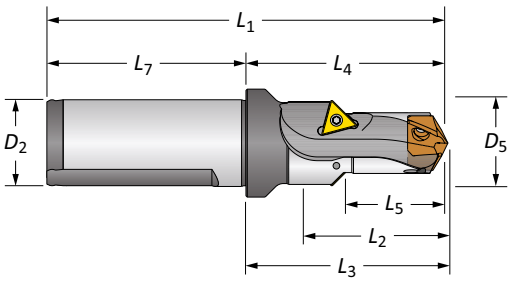
18 Series | Diameter Range: 18.00mm - 19.99mm (0.7087” - 0.7873”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	60.0	94.0	96.8	150.0	56.0	25.0	1/8*	YES	**60318S-25FM**
		5xD	100.0	134.0	136.8	190.0	56.0	25.0	1/8*	YES	**60518S-25FM**
		7xD	140.0	174.0	176.8	230.0	56.0	25.0	1/8*	YES	**60718S-25FM**
	Helical	Stub	22.0	56.0	58.8	112.0	56.0	25.0	1/8*	YES	**60118H-25FM**
		3xD	60.0	94.0	96.8	150.0	56.0	25.0	1/8*	YES	**60318H-25FM**
		3xD	60.0	94.0	96.8	150.0	56.0	25.0	1/8*	NO	**60318H-25CM**
		5xD	100.0	134.0	136.8	190.0	56.0	25.0	1/8*	YES	**60518H-25FM**
		5xD	100.0	134.0	136.8	190.0	56.0	25.0	1/8*	NO	**60518H-25CM**
		7xD	140.0	174.0	176.8	230.0	56.0	25.0	1/8*	YES	**60718H-25FM**
		7xD	140.0	174.0	176.8	230.0	56.0	25.0	1/8*	NO	**60718H-25CM**
i	Straight	3xD	2-23/64	3-45/64	3-13/16	5-63/64	2-9/32	1	1/8	YES	**60318S-100F**
		5xD	3-15/16	5-17/64	5-25/64	7-35/64	2-9/32	1	1/8	YES	**60518S-100F**
		7xD	5-33/64	6-27/32	6-61/64	9-1/8	2-9/32	1	1/8	YES	**60718S-100F**
	Helical	Stub	7/8	2-13/64	2-5/16	4-31/64	2-9/32	1	1/8	YES	**60118H-100F**
		3xD	2-23/64	3-45/64	3-13/16	5-63/64	2-9/32	1	1/8	YES	**60318H-100F**
		3xD	2-23/64	3-45/64	3-13/16	5-63/64	2-9/32	1	1/8	NO	**60318H-100C**
		5xD	3-15/16	5-17/64	5-25/64	7-35/64	2-9/32	1	1/8	YES	**60518H-100F**
		5xD	3-15/16	5-17/64	5-25/64	7-35/64	2-9/32	1	1/8	NO	**60518H-100C**
		7xD	5-33/64	6-27/32	6-61/64	9-1/8	2-9/32	1	1/8	YES	**60718H-100F**
		7xD	5-33/64	6-27/32	6-61/64	9-1/8	2-9/32	1	1/8	NO	**60718H-100C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	25.1	27	35.2	56.0	58.8	114.8	56.0	25.0	**60118C45-25FM**	TCMT-110204
i	63/64	1-1/16	1-25/64	2-13/64	2-5/16	4-31/64	2-9/32	1	**60118C45-100F**	TCMT-110204

Connection Accessories

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

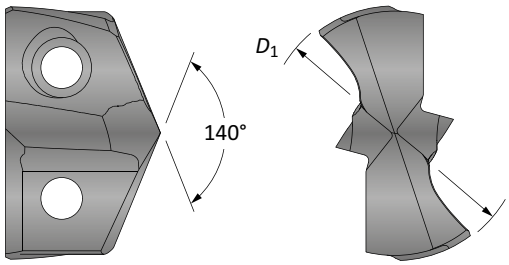
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
20.00	0.7874	–	**XTP20-20.00**	**XTK20-20.00**	**XTN20-20.00**
20.10	0.7913	–	**XTP20-20.10**	**XTK20-20.10**	**XTN20-20.10**
20.20	0.7953	–	**XTP20-20.20**	**XTK20-20.20**	**XTN20-20.20**
20.24	0.7969	51/64	**XTP20-20.24**	**XTK20-20.24**	**XTN20-20.24**
20.30	0.7992	–	**XTP20-20.30**	**XTK20-20.30**	**XTN20-20.30**
20.40	0.8031	–	**XTP20-20.40**	**XTK20-20.40**	**XTN20-20.40**
20.50	0.8071	–	**XTP20-20.50**	**XTK20-20.50**	**XTN20-20.50**
20.60	0.8110	–	**XTP20-20.60**	**XTK20-20.60**	**XTN20-20.60**
20.64	0.8125	13/16	**XTP20-20.64**	**XTK20-20.64**	**XTN20-20.64**
20.70	0.8150	–	**XTP20-20.70**	**XTK20-20.70**	**XTN20-20.70**
20.80	0.8189	–	**XTP20-20.80**	**XTK20-20.80**	**XTN20-20.80**
20.90	0.8228	–	**XTP20-20.90**	**XTK20-20.90**	**XTN20-20.90**
21.00	0.8268	–	**XTP20-21.00**	**XTK20-21.00**	**XTN20-21.00**
21.10	0.8307	–	**XTP20-21.10**	**XTK20-21.10**	**XTN20-21.10**
21.20	0.8346	–	**XTP20-21.20**	**XTK20-21.20**	**XTN20-21.20**
21.30	0.8386	–	**XTP20-21.30**	**XTK20-21.30**	**XTN20-21.30**
21.40	0.8425	–	**XTP20-21.40**	**XTK20-21.40**	**XTN20-21.40**
21.43	0.8438	27/32	**XTP20-21.43**	**XTK20-21.43**	**XTN20-21.43**
21.50	0.8465	–	**XTP20-21.50**	**XTK20-21.50**	**XTN20-21.50**
21.60	0.8504	–	**XTP20-21.60**	**XTK20-21.60**	**XTN20-21.60**
21.70	0.8543	–	**XTP20-21.70**	**XTK20-21.70**	**XTN20-21.70**
21.80	0.8583	–	**XTP20-21.80**	**XTK20-21.80**	**XTN20-21.80**
21.83	0.8594	55/64	**XTP20-21.83**	**XTK20-21.83**	**XTN20-21.83**
21.90	0.8622	–	**XTP20-21.90**	**XTK20-21.90**	**XTN20-21.90**

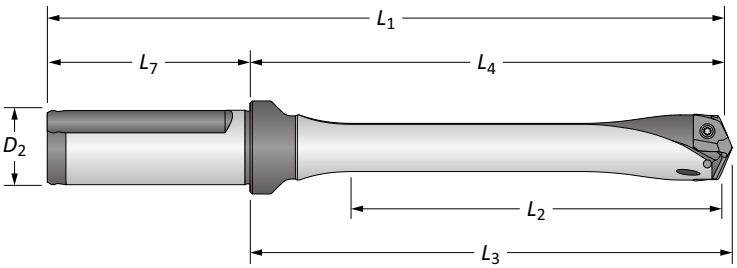
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Body Length	L_2	L_4	L_3	L_1	Shank L_7	D_2	Flat	Part No.
m	Straight	3xD	66.0	100.1	102.9	156.1	56.0	25.0	YES	**HXT0320S-25FM**
		3xD	66.0	100.1	102.9	156.1	56.0	25.0	NO	**HXT0320S-25CM**
		5xD	110.0	144.1	146.9	200.1	56.0	25.0	YES	**HXT0520S-25FM**
		5xD	110.0	144.1	146.9	200.1	56.0	25.0	NO	**HXT0520S-25CM**
		7xD	154.0	188.1	190.9	244.1	56.0	25.0	YES	**HXT0720S-25FM**
		7xD	154.0	188.1	190.9	244.1	56.0	25.0	NO	**HXT0720S-25CM**
		10xD	219.9	254.0	256.8	310.0	56.0	25.0	YES	⚠ **HXT1020S-25FM**
		10xD	219.9	254.0	256.8	310.0	56.0	25.0	NO	⚠ **HXT1020S-25CM**
i	Straight	3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	YES	**HXT0320S-100F**
		3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	NO	**HXT0320S-100C**
		5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	YES	**HXT0520S-100F**
		5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	NO	**HXT0520S-100C**
		7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	YES	**HXT0720S-100F**
		7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	NO	**HXT0720S-100C**
		10xD	8-21/32	10	10-7/64	12-9/32	2-9/32	1	YES	⚠ **HXT1020S-100F**
		10xD	8-21/32	10	10-7/64	12-9/32	2-9/32	1	NO	⚠ **HXT1020S-100C**

Connection Accessories

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

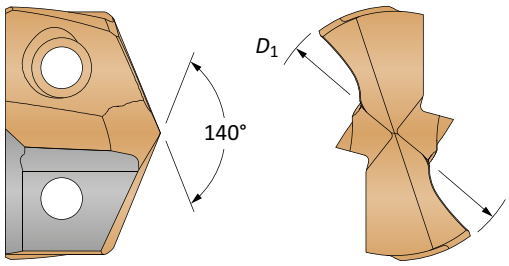
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	**D_1 mm**	**D_1 inch**	**Fractional Equivalent**	**Standard Part No.**	**Low Rake Part No.**	**Cast Iron Part No.**	**Stainless Part No.**
K35 (C1)	20.00	0.7874	–	**7C120P-20**	**7C120P-20LR**	–	–
	20.24	0.7969	51/64	**7C120P-.796**	**7C120P-.796LR**	–	–
	20.50	0.8071	–	**7C120P-20.5**	**7C120P-20.5LR**	–	–
	20.64	0.8125	13/16	**7C120P-0026**	**7C120P-0026LR**	–	–
	21.00	0.8268	–	**7C120P-21**	**7C120P-21LR**	–	–
	21.43	0.8438	27/32	**7C120P-0027**	**7C120P-0027LR**	–	–
	21.50	0.8465	–	**7C120P-21.5**	**7C120P-21.5LR**	–	–
	21.83	0.8594	55/64	**7C120P-.859**	**7C120P-.859LR**	–	–
K20 (C2)	20.00	0.7874	–	**7C220P-20**	**7C220P-20LR**	**7C220P-20CI**	**7C220P-20AS**
	20.24	0.7969	51/64	**7C220P-.796**	**7C220P-.796LR**	**7C220P-.796CI**	**7C220P-.796AS**
	20.50	0.8071	–	**7C220P-20.5**	**7C220P-20.5LR**	**7C220P-20.5CI**	**7C220P-20.5AS**
	20.64	0.8125	13/16	**7C220P-0026**	**7C220P-0026LR**	**7C220P-0026CI**	**7C220P-0026AS**
	21.00	0.8268	–	**7C220P-21**	**7C220P-21LR**	**7C220P-21CI**	**7C220P-21AS**
	21.43	0.8438	27/32	**7C220P-0027**	**7C220P-0027LR**	**7C220P-0027CI**	**7C220P-0027AS**
	21.50	0.8465	–	**7C220P-21.5**	**7C220P-21.5LR**	**7C220P-21.5CI**	**7C220P-21.5AS**
	21.83	0.8594	55/64	**7C220P-.859**	**7C220P-.859LR**	**7C220P-.859CI**	**7C220P-.859AS**

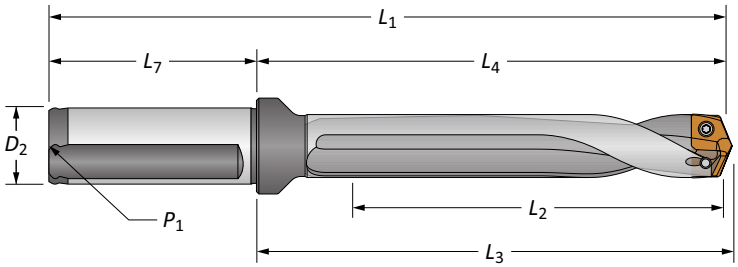
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

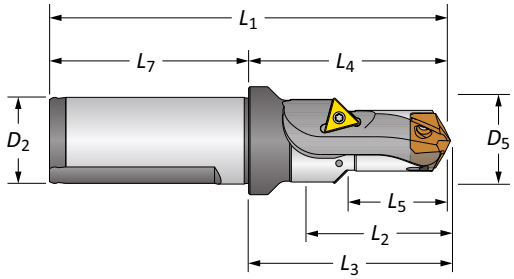
20 Series | Diameter Range: 20.00mm - 21.99mm (0.7874” - 0.8660”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	66.0	100.1	102.9	156.1	56.0	25.0	1/8*	YES	**60320S-25FM**
		5xD	110.0	144.1	146.9	200.1	56.0	25.0	1/8*	YES	**60520S-25FM**
		7xD	154.0	188.1	190.9	244.1	56.0	25.0	1/8*	YES	**60720S-25FM**
	Helical	Stub	24.0	57.6	60.4	113.6	56.0	25.0	1/8*	YES	**60120H-25FM**
		3xD	66.0	100.1	102.9	156.1	56.0	25.0	1/8*	YES	**60320H-25FM**
		3xD	66.0	100.1	102.9	156.1	56.0	25.0	1/8*	NO	**60320H-25CM**
		5xD	110.0	144.1	146.9	200.1	56.0	25.0	1/8*	YES	**60520H-25FM**
		5xD	110.0	144.1	146.9	200.1	56.0	25.0	1/8*	NO	**60520H-25CM**
		7xD	154.0	188.1	190.9	244.1	56.0	25.0	1/8*	YES	**60720H-25FM**
		7xD	154.0	188.1	190.9	244.1	56.0	25.0	1/8*	NO	**60720H-25CM**
i	Straight	3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	1/8	YES	**60320S-100F**
		5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	1/8	YES	**60520S-100F**
		7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	1/8	YES	**60720S-100F**
	Helical	Stub	15/16	2-17/64	2-3/8	4-35/64	2-9/32	1	1/8	YES	**60120H-100F**
		3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	1/8	YES	**60320H-100F**
		3xD	2-19/32	3-15/16	4-3/64	6-7/32	2-9/32	1	1/8	NO	**60320H-100C**
		5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	1/8	YES	**60520H-100F**
		5xD	4-21/64	5-43/64	5-25/32	7-61/64	2-9/32	1	1/8	NO	**60520H-100C**
		7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	1/8	YES	**60720H-100F**
		7xD	6-1/16	7-13/32	7-33/64	9-11/16	2-9/32	1	1/8	NO	**60720H-100C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	27.2	30.0	37.1	57.6	60.4	116.5	56.0	25.0	**60120C45-25FM**	TCMT-110204
i	1-5/64	1-3/16	1-29/64	2-17/64	2-3/8	4-35/64	2-9/32	1	**60120C45-100F**	TCMT-110204

Connection Accessories

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

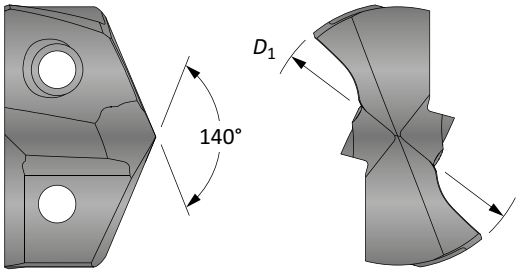
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



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

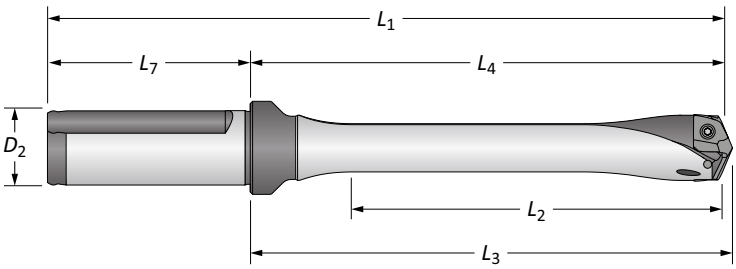
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank Flat	Part No.
m	Straight	3xD	72.0	105.3	108.3	161.3	56.0	25.0	YES	HXT0322S-25FM
		3xD	72.0	105.3	108.3	161.3	56.0	25.0	NO	HXT0322S-25CM
		5xD	120.0	153.3	156.2	209.3	56.0	25.0	YES	HXT0522S-25FM
		5xD	120.0	153.3	156.2	209.3	56.0	25.0	NO	HXT0522S-25CM
		7xD	167.9	201.3	204.2	257.3	56.0	25.0	YES	HXT0722S-25FM
		7xD	167.9	201.3	204.2	257.3	56.0	25.0	NO	HXT0722S-25CM
		10xD	239.9	273.0	276.2	329.0	56.0	25.0	YES	⚠ HXT1022S-25FM
		10xD	239.9	273.0	276.2	329.0	56.0	25.0	NO	⚠ HXT1022S-25CM
i	Straight	3xD	2-53/64	4-9/64	4-17/64	6-27/64	2-9/32	1	YES	HXT0322S-100F
		3xD	2-53/64	4-9/64	4-17/64	6-27/64	2-9/32	1	NO	HXT0322S-100C
		5xD	4-23/32	6-1/32	6-5/32	8-5/16	2-9/32	1	YES	HXT0522S-100F
		5xD	4-23/32	6-1/32	6-5/32	8-5/16	2-9/32	1	NO	HXT0522S-100C
		7xD	6-39/64	7-59/64	8-3/64	10-13/64	2-9/32	1	YES	HXT0722S-100F
		7xD	6-39/64	7-59/64	8-3/64	10-13/64	2-9/32	1	NO	HXT0722S-100C
		10xD	9-7/16	10-3/4	10-7/8	13-1/32	2-9/32	1	YES	⚠ HXT1022S-100F
		10xD	9-7/16	10-3/4	10-7/8	13-1/32	2-9/32	1	NO	⚠ HXT1022S-100C

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

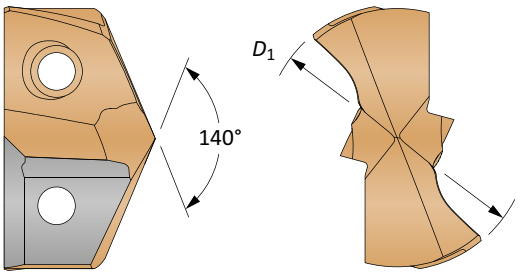
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	**D_1 mm**	**D_1 inch**	**Fractional Equivalent**	**Standard Part No.**	**Low Rake Part No.**	**Cast Iron Part No.**	**Stainless Part No.**
K35 (C1)	22.00	0.8661	–	**7C122P-22**	**7C122P-22LR**	–	–
	22.23	0.8750	7/8	**7C122P-0028**	**7C122P-0028LR**	–	–
	22.50	0.8858	–	**7C122P-22.5**	–	–	–
	22.62	0.8906	57/64	**7C122P-.890**	**7C122P-.890LR**	–	–
	23.00	0.9055	–	**7C122P-23**	**7C122P-23LR**	–	–
	23.02	0.9063	29/32	**7C122P-0029**	**7C122P-0029LR**	–	–
	23.42	0.9219	59/64	**7C122P-.921**	**7C122P-.921LR**	–	–
	23.50	0.9252	–	**7C122P-23.5**	–	–	–
	23.81	0.9375	15/16	**7C122P-0030**	**7C122P-0030LR**	–	–
K20 (C2)	22.00	0.8661	–	**7C222P-22**	**7C222P-22LR**	**7C222P-22CI**	**7C222P-22AS**
	22.23	0.8750	7/8	**7C222P-0028**	**7C222P-0028LR**	**7C222P-0028CI**	**7C222P-0028AS**
	22.50	0.8858		**7C222P-22.5**	–	–	–
	22.62	0.8906	57/64	**7C222P-.890**	**7C222P-.890LR**	**7C222P-.890CI**	**7C222P-.890AS**
	23.00	0.9055	–	**7C222P-23**	**7C222P-23LR**	**7C222P-23CI**	**7C222P-23AS**
	23.02	0.9063	29/32	**7C222P-0029**	**7C222P-0029LR**	**7C222P-0029CI**	**7C222P-0029AS**
	23.42	0.9219	59/64	**7C222P-.921**	**7C222P-.921LR**	**7C222P-.921CI**	**7C222P-.921AS**
	23.50	0.9252		**7C222P-23.5**	–	–	–
	23.81	0.9375	15/16	**7C222P-0030**	**7C222P-0030LR**	**7C222P-0030CI**	**7C222P-0030AS**

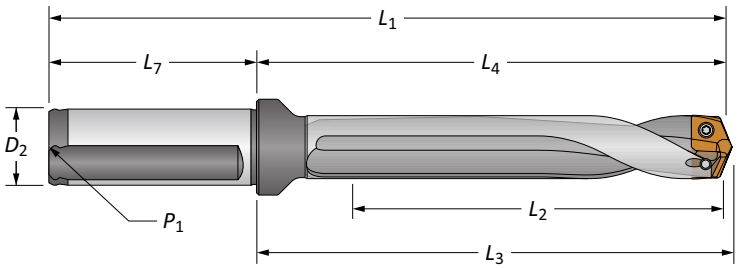
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

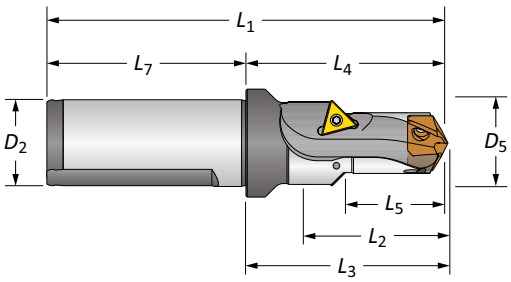
22 Series | Diameter Range: 22.00mm - 23.99mm (0.8661” - 0.9448”)



Straight and Helical

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

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	29.0	33.0	40.5	60.0	63.0	119.0	56.0	25.0	**60122C45-25FM**	TCMT-110204
i	1-9/64	1-19/64	1-19/32	2-23/64	2-31/64	4-41/64	2-9/32	1	**60122C45-100F**	TCMT-110204

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

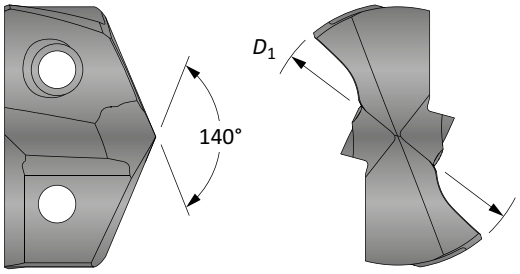
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert			Part No.	Part No.	Part No.
D_1 mm	D_1 inch	Fractional Equivalent	P	K	N
24.00	0.9449	–	XTP24-24.00	XTK24-24.00	XTN24-24.00
24.10	0.9488	–	XTP24-24.10	XTK24-24.10	XTN24-24.10
24.20	0.9528	–	XTP24-24.20	XTK24-24.20	XTN24-24.20
24.30	0.9567	–	XTP24-24.30	XTK24-24.30	XTN24-24.30
24.40	0.9606	–	XTP24-24.40	XTK24-24.40	XTN24-24.40
24.50	0.9646	–	XTP24-24.50	XTK24-24.50	XTN24-24.50
24.61	0.9688	31/32	XTP24-24.61	XTK24-24.61	XTN24-24.61
24.70	0.9724	–	XTP24-24.70	XTK24-24.70	XTN24-24.70
24.80	0.9764	–	XTP24-24.80	XTK24-24.80	XTN24-24.80
24.90	0.9803	–	XTP24-24.90	XTK24-24.90	XTN24-24.90
25.00	0.9843	63/64	XTP24-25.00	XTK24-25.00	XTN24-25.00
25.10	0.9882	–	XTP24-25.10	XTK24-25.10	XTN24-25.10
25.20	0.9921	–	XTP24-25.20	XTK24-25.20	XTN24-25.20
25.30	0.9961	–	XTP24-25.30	XTK24-25.30	XTN24-25.30
25.40	1.0000	1	XTP24-25.40	XTK24-25.40	XTN24-25.40
25.50	1.0039	–	XTP24-25.50	XTK24-25.50	XTN24-25.50
25.60	1.0080	–	XTP24-25.60	XTK24-25.60	XTN24-25.60
25.70	1.0118	–	XTP24-25.70	XTK24-25.70	XTN24-25.70
25.78	1.0150	1-1/16	XTP24-25.78	XTK24-25.78	XTN24-25.78
25.90	1.0197	–	XTP24-25.90	XTK24-25.90	XTN24-25.90

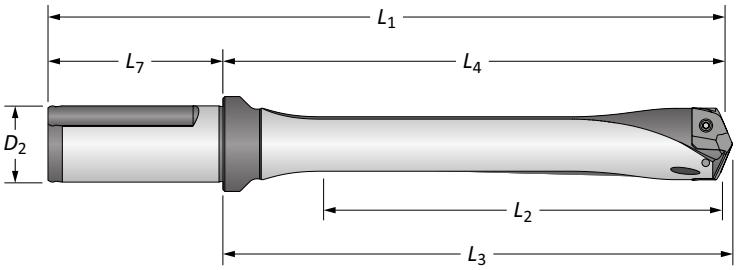
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Body Length	L_2	L_4	L_3	L_1	Shank L_7	D_2	Flat	Part No.
m	Straight	3xD	78.0	113.8	116.8	169.8	56.0	25.0	YES	HXT0324S-25FM
		3xD	78.0	113.8	116.8	169.8	56.0	25.0	NO	HXT0324S-25CM
		5xD	130.0	165.8	168.7	221.8	56.0	25.0	YES	HXT0524S-25FM
		5xD	130.0	165.8	168.7	221.8	56.0	25.0	NO	HXT0524S-25CM
		7xD	182.0	217.8	220.7	273.8	56.0	25.0	YES	HXT0724S-25FM
		7xD	182.0	217.8	220.7	273.8	56.0	25.0	NO	HXT0724S-25CM
		10xD	259.9	295.7	298.7	351.7	56.0	25.0	YES	⚠ HXT1024S-25FM
		10xD	259.9	295.7	298.7	351.7	56.0	25.0	NO	⚠ HXT1024S-25CM
i	Straight	3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	YES	HXT0324S-100F
		3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	NO	HXT0324S-100C
		5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	YES	HXT0524S-100F
		5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	NO	HXT0524S-100C
		7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	YES	HXT0724S-100F
		7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	NO	HXT0724S-100C
		10xD	10-15/64	11-41/64	11-49/64	13-59/64	2-9/32	1	YES	⚠ HXT1024S-100F
		10xD	10-15/64	11-41/64	11-49/64	13-59/64	2-9/32	1	NO	⚠ HXT1024S-100C

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

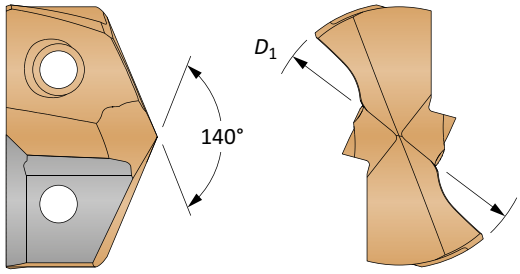
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	D_1 mm	D_1 inch	Fractional Equivalent	Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
K35 (C1)	24.00	0.9449	–	**7C124P-24**	**7C124P-24LR**	–	–
	24.50	0.9646	–	**7C124P-24.5**	–	–	–
	24.61	0.9688	31/32	**7C124P-0031**	**7C124P-0031LR**	–	–
	25.00	0.9843	63/64	**7C124P-25**	**7C124P-25LR**	–	–
	25.40	1.0000	1	**7C124P-0100**	**7C124P-0100LR**	–	–
	25.50	1.0039	–	**7C124P-25.5**	–	–	–
	25.60	1.0080	–	**7C124P-1.008**	**7C124P-1.008LR**	–	–
	25.65	1.0098	–	**7C124P-25.65**	–	–	–
	25.80	1.0156	1-1/64	**7C124P-1.015**	**7C124P-1.015LR**	–	–
K20 (C2)	24.00	0.9449	–	**7C224P-24**	**7C224P-24LR**	**7C224P-24CI**	**7C224P-24AS**
	24.50	0.9646	–	**7C224P-24.5**	–	–	–
	24.61	0.9688	31/32	**7C224P-0031**	**7C224P-0031LR**	**7C224P-0031CI**	**7C224P-0031AS**
	25.00	0.9843	63/64	**7C224P-25**	**7C224P-25LR**	**7C224P-25CI**	**7C224P-25AS**
	25.40	1.0000	1	**7C224P-0100**	**7C224P-0100LR**	**7C224P-0100CI**	**7C224P-0100AS**
	25.50	1.0039	–	**7C224P-25.5**	–	–	–
	25.60	1.0080	–	**7C224P-1.008**	**7C224P-1.008LR**	**7C224P-1.008CI**	**7C224P-1.008AS**
	25.65	1.0098	–	**7C224P-25.65**	–	–	–
	25.80	1.0156	1-1/64	**7C224P-1.015**	**7C224P-1.015LR**	**7C224P-1.015CI**	**7C224P-1.015AS**

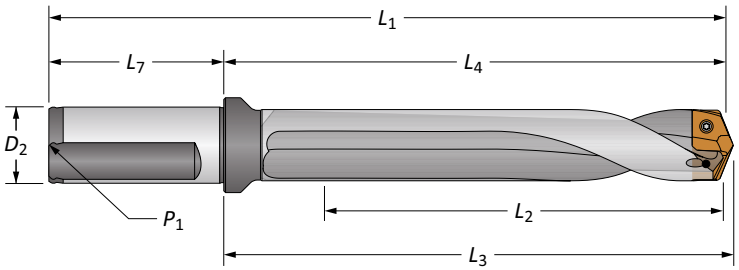
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

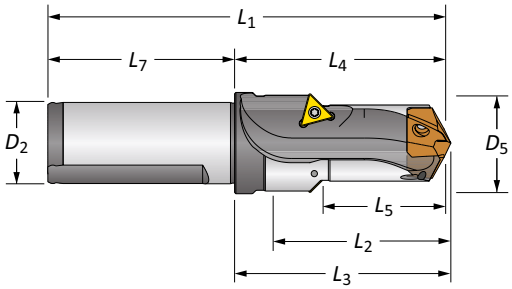
24 Series | Diameter Range: 24.00mm - 25.99mm (0.9449” - 1.0235”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	78.0	113.8	116.8	169.8	56.0	25.0	1/8*	YES	**60324S-25FM**
		5xD	130.0	165.8	168.7	221.8	56.0	25.0	1/8*	YES	**60524S-25FM**
		7xD	182.0	217.8	220.7	273.8	56.0	25.0	1/8*	YES	**60724S-25FM**
	Helical	Stub	28.5	64.2	67.1	120.2	56.0	25.0	1/8*	YES	**60124H-25FM**
		3xD	78.0	113.8	116.8	169.8	56.0	25.0	1/8*	YES	**60324H-25FM**
		3xD	78.0	113.8	116.8	169.8	56.0	25.0	1/8*	NO	**60324H-25CM**
		5xD	130.0	165.8	168.7	221.8	56.0	25.0	1/8*	YES	**60524H-25FM**
		5xD	130.0	165.8	168.7	221.8	56.0	25.0	1/8*	NO	**60524H-25CM**
		7xD	182.0	217.8	220.7	273.8	56.0	25.0	1/8*	YES	**60724H-25FM**
		7xD	182.0	217.8	220.7	273.8	56.0	25.0	1/8*	NO	**60724H-25CM**
i	Straight	3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	1/8	YES	**60324S-100F**
		5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	1/8	YES	**60524S-100F**
		7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	1/8	YES	**60724S-100F**
	Helical	Stub	1-1/8	2-17/32	2-41/64	4-13/16	2-9/32	1	1/8	YES	**60124H-100F**
		3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	1/8	YES	**60324H-100F**
		3xD	3-1/16	4-31/64	4-19/32	6-49/64	2-9/32	1	1/8	NO	**60324H-100C**
		5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	1/8	YES	**60524H-100F**
		5xD	5-7/64	6-17/32	6-41/64	8-13/16	2-9/32	1	1/8	NO	**60524H-100C**
		7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	1/8	YES	**60724H-100F**
		7xD	7-5/32	8-37/64	8-11/16	10-55/64	2-9/32	1	1/8	NO	**60724H-100C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	31.0	36.0	45.5	64.2	67.1	123.0	56.0	25.0	**60124C45-25FM**	TCMT-110204
i	1-7/32	1-27/64	1-51/64	2-17/32	2-41/64	4-13/16	2-9/32	1	**60124C45-100F**	TCMT-110204

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	305 N-cm (27.0 in-lbs)

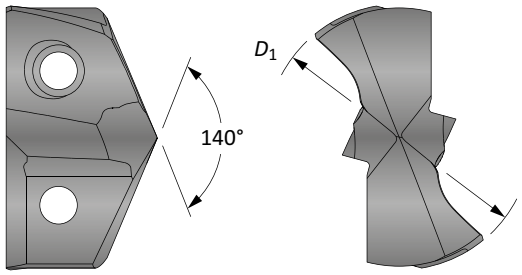
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

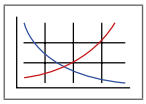
26 Series | Diameter Range: 26.00mm - 28.99mm (1.0236” - 1.1416”)



Insert			Part No.	Part No.	Part No.
D_1 mm	D_1 inch	Fractional Equivalent	P	K	N
26.00	1.0236	–	XTP26-26.00	XTK26-26.00	XTN26-26.00
26.10	1.0276	–	XTP26-26.10	XTK26-26.10	XTN26-26.10
26.20	1.0313	1-1/32	XTP26-26.20	XTK26-26.20	XTN26-26.20
26.30	1.0354	–	XTP26-26.30	XTK26-26.30	XTN26-26.30
26.40	1.0394	–	XTP26-26.40	XTK26-26.40	XTN26-26.40
26.50	1.0433	–	XTP26-26.50	XTK26-26.50	XTN26-26.50
26.57	1.0460	1-3/64	XTP26-26.57	XTK26-26.57	XTN26-26.57
26.60	1.0472	–	XTP26-26.60	XTK26-26.60	XTN26-26.60
26.70	1.0512	–	XTP26-26.70	XTK26-26.70	XTN26-26.70
26.80	1.0551	–	XTP26-26.80	XTK26-26.80	XTN26-26.80
26.90	1.0591	–	XTP26-26.90	XTK26-26.90	XTN26-26.90
26.99	1.0625	1-1/16	XTP26-26.99	XTK26-26.99	XTN26-26.99
27.00	1.0630	–	XTP26-27.00	XTK26-27.00	XTN26-27.00
27.10	1.0669	–	XTP26-27.10	XTK26-27.10	XTN26-27.10
27.20	1.0709	–	XTP26-27.20	XTK26-27.20	XTN26-27.20
27.30	1.0748	–	XTP26-27.30	XTK26-27.30	XTN26-27.30
27.40	1.0787	–	XTP26-27.40	XTK26-27.40	XTN26-27.40
27.50	1.0827	–	XTP26-27.50	XTK26-27.50	XTN26-27.50
27.60	1.0866	–	XTP26-27.60	XTK26-27.60	XTN26-27.60
27.70	1.0906	–	XTP26-27.70	XTK26-27.70	XTN26-27.70
27.78	1.0938	1-3/32	XTP26-27.78	XTK26-27.78	XTN26-27.78
27.90	1.0984	–	XTP26-27.90	XTK26-27.90	XTN26-27.90
28.00	1.1024	–	XTP26-28.00	XTK26-28.00	XTN26-28.00
28.10	1.1063	–	XTP26-28.10	XTK26-28.10	XTN26-28.10
28.17	1.1090	1-7/64	XTP26-28.17	XTK26-28.17	XTN26-28.17
28.20	1.1102	–	XTP26-28.20	XTK26-28.20	XTN26-28.20
28.30	1.1142	–	XTP26-28.30	XTK26-28.30	XTN26-28.30
28.40	1.1181	–	XTP26-28.40	XTK26-28.40	XTN26-28.40
28.50	1.1220	–	XTP26-28.50	XTK26-28.50	XTN26-28.50
28.58	1.1250	1-1/8	XTP26-28.58	XTK26-28.58	XTN26-28.58
28.70	1.1299	–	XTP26-28.70	XTK26-28.70	XTN26-28.70
28.80	1.1339	–	XTP26-28.80	XTK26-28.80	XTN26-28.80
28.90	1.1378	–	XTP26-28.90	XTK26-28.90	XTN26-28.90

Inserts sold in multiples of 1

A2: 66 - 75



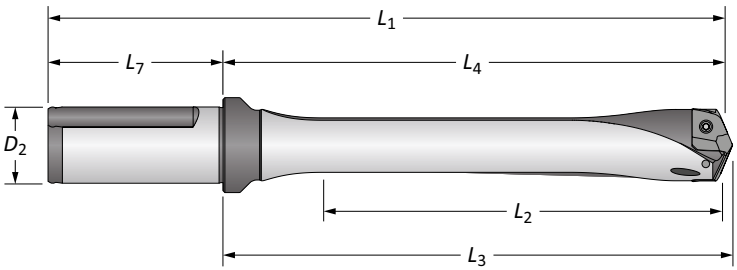
Key on A2: 1

A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Flat	Part No.
m	Straight	3xD	87.0	128.1	130.9	188.1	60.0	32.0	YES	**HXT0326S-32FM**
		3xD	87.0	128.1	130.9	188.1	60.0	32.0	NO	**HXT0326S-32CM**
		5xD	145.0	186.0	188.8	246.0	60.0	32.0	YES	**HXT0526S-32FM**
		5xD	145.0	186.0	188.8	246.0	60.0	32.0	NO	**HXT0526S-32CM**
		7xD	203.0	244.0	246.8	304.0	60.0	32.0	YES	**HXT0726S-32FM**
		7xD	203.0	244.0	246.8	304.0	60.0	32.0	NO	**HXT0726S-32CM**
		10xD	289.9	331.4	334.4	391.4	60.0	32.0	YES	⚠ **HXT1026S-32FM**
		10xD	289.9	331.4	334.4	391.4	60.0	32.0	NO	⚠ **HXT1026S-32CM**
i	Straight	3xD	3-27/64	5-1/16	5-11/64	7-11/32	2-9/32	1-1/4	YES	**HXT0326S-125F**
		3xD	3-27/64	5-1/16	5-11/64	7-11/32	2-9/32	1-1/4	NO	**HXT0326S-125C**
		5xD	5-45/64	7-11/32	7-29/64	9-5/8	2-9/32	1-1/4	YES	**HXT0526S-125F**
		5xD	5-45/64	7-11/32	7-29/64	9-5/8	2-9/32	1-1/4	NO	**HXT0526S-125C**
		7xD	7-63/64	9-5/8	9-47/64	11-29/32	2-9/32	1-1/4	YES	**HXT0726S-125F**
		7xD	7-63/64	9-5/8	9-47/64	11-29/32	2-9/32	1-1/4	NO	**HXT0726S-125C**
		10xD	11-13/32	13-3/64	13-11/64	15-21/64	2-9/32	1-1/4	YES	⚠ **HXT1026S-125F**
		10xD	11-13/32	13-3/64	13-11/64	15-21/64	2-9/32	1-1/4	NO	⚠ **HXT1026S-125C**

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

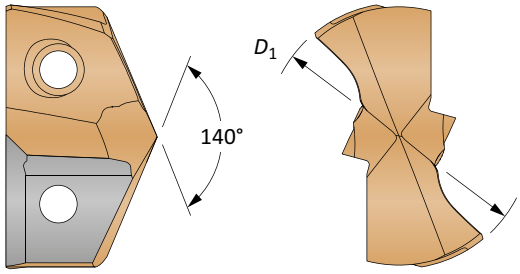
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	D_1 mm	D_1 inch	Fractional Equivalent	Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
K35 (C1)	26.00	1.0236	–	**7C126P-26**	**7C126P-26LR**	–	–
	26.20	1.0313	1-1/32	**7C126P-0101**	**7C126P-0101LR**	–	–
	26.50	1.0433	–	**7C126P-26.5**	–	–	–
	26.59	1.0469	1-3/64	**7C126P-1.046**	**7C126P-1.046LR**	–	–
	26.99	1.0625	1-1/16	**7C126P-0102**	**7C126P-0102LR**	–	–
	27.00	1.0630	–	**7C126P-27**	**7C126P-27LR**	–	–
	27.50	1.0827	–	**7C126P-27.5**	–	–	–
	27.78	1.0938	1-3/32	**7C126P-0103**	**7C126P-0103LR**	–	–
	28.00	1.1024		**7C126P-28**	**7C126P-28LR**	–	–
	28.18	1.1094	1-7/64	**7C126P-1.109**	**7C126P-1.109LR**	–	–
	28.50	1.1220	–	**7C126P-28.5**	–	–	–
	28.58	1.1250	1-1/8	**7C126P-0104**	**7C126P-0104LR**	–	–
K20 (C2)	26.00	1.0236	–	**7C226P-26**	**7C226P-26LR**	**7C226P-26CI**	**7C226P-26AS**
	26.20	1.0313	1-1/32	**7C226P-0101**	**7C226P-0101LR**	**7C226P-0101CI**	**7C226P-0101AS**
	26.50	1.0433	–	**7C226P-26.5**	–	–	–
	26.59	1.0469	1-3/64	**7C226P-1.046**	**7C226P-1.046LR**	**7C226P-1.046CI**	**7C226P-1.046AS**
	26.99	1.0625	1-1/16	**7C226P-0102**	**7C226P-0102LR**	**7C226P-0102CI**	**7C226P-0102AS**
	27.00	1.0630	–	**7C226P-27**	**7C226P-27LR**	**7C226P-27CI**	**7C226P-27AS**
	27.50	1.0827	–	**7C226P-27.5**	–	–	–
	27.78	1.0938	1-3/32	**7C226P-0103**	**7C226P-0103LR**	**7C226P-0103CI**	**7C226P-0103AS**
	28.00	1.1024		**7C226P-28**	**7C226P-28LR**	**7C226P-28CI**	**7C226P-28AS**
	28.18	1.1094	1-7/64	**7C226P-1.109**	**7C226P-1.109LR**	**7C226P-1.109CI**	**7C226P-1.109AS**
	28.50	1.1220	–	**7C226P-28.5**	–	–	–
	28.58	1.1250	1-1/8	**7C226P-0104**	**7C226P-0104LR**	**7C226P-0104CI**	**7C226P-0104AS**

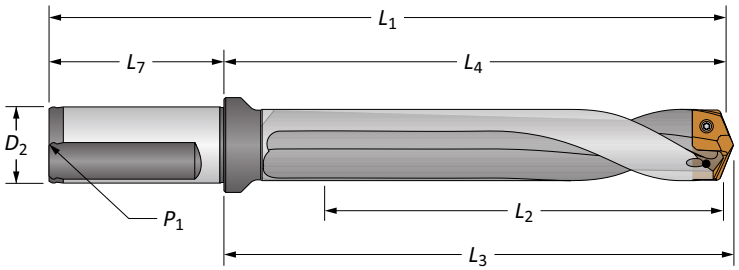
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

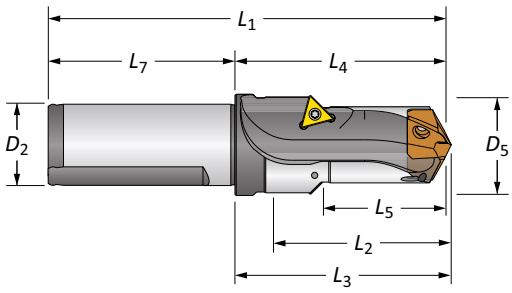
26 Series | Diameter Range: 26.00mm - 28.99mm (1.0236” - 1.1416”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	87.0	128.1	130.9	188.1	60.0	32.0	1/8*	YES	**60326S-32FM**
		5xD	145.0	186.0	188.8	246.0	60.0	32.0	1/8*	YES	**60526S-32FM**
		7xD	203.0	244.0	246.8	304.0	60.0	32.0	1/8*	YES	**60726S-32FM**
	Helical	Stub	32.0	72.9	75.7	132.9	60.0	32.0	1/8*	YES	**60126H-32FM**
		3xD	87.0	128.1	130.9	188.1	60.0	32.0	1/8*	YES	**60326H-32FM**
		3xD	87.0	128.1	130.9	188.1	60.0	32.0	1/8*	NO	**60326H-32CM**
		5xD	145.0	186.0	188.8	246.0	60.0	32.0	1/8*	YES	**60526H-32FM**
		5xD	145.0	186.0	188.8	246.0	60.0	32.0	1/8*	NO	**60526H-32CM**
		7xD	203.0	244.0	246.8	304.0	60.0	32.0	1/8*	YES	**60726H-32FM**
		7xD	203.0	244.0	246.8	304.0	60.0	32.0	1/8*	NO	**60726H-32CM**
i	Straight	3xD	3-27/64	5-1/16	5-11/64	7-11/32	2-9/32	1-1/4	1/8	YES	**60326S-125F**
		5xD	5-45/64	7-11/32	7-29/64	9-5/8	2-9/32	1-1/4	1/8	YES	**60526S-125F**
		7xD	7-63/64	9-5/8	9-47/64	11-29/32	2-9/32	1-1/4	1/8	YES	**60726S-125F**
	Helical	Stub	1-1/4	2-7/8	2-63/64	5-5/32	2-9/32	1-1/4	1/8	YES	**60126H-125F**
		3xD	3-27/64	5-1/16	5-11/64	7-11/32	2-9/32	1-1/4	1/8	YES	**60326H-125F**
		3xD	3-27/64	5-1/16	5-11/64	7-11/32	2-9/32	1-1/4	1/8	NO	**60326H-125C**
		5xD	5-45/64	7-11/32	7-29/64	9-5/8	2-9/32	1-1/4	1/8	YES	**60526H-125F**
		5xD	5-45/64	7-11/32	7-29/64	9-5/8	2-9/32	1-1/4	1/8	NO	**60526H-125C**
		7xD	7-63/64	9-5/8	9-47/64	11-29/32	2-9/32	1-1/4	1/8	YES	**60726H-125F**
		7xD	7-63/64	9-5/8	9-47/64	11-29/32	2-9/32	1-1/4	1/8	NO	**60726H-125C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	34.0	39.0	52.1	72.9	75.7	132.9	60.0	32.0	**60126C45-32FM**	TCMT-110204
i	1-11/32	1-17/32	2-3/64	2-7/8	2-63/64	5-5/32	2-9/32	1-1/4	**60126C45-125F**	TCMT-110204

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

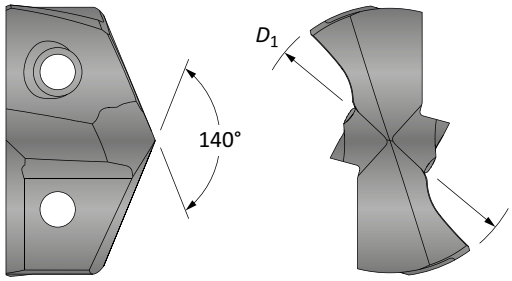
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert			Part No.	Part No.	Part No.
D_1 mm	D_1 inch	Fractional Equivalent	P	K	N
29.00	1.1417	–	XTP29-29.00	XTK29-29.00	XTN29-29.00
29.10	1.1457	–	XTP29-29.10	XTK29-29.10	XTN29-29.10
29.20	1.1496	–	XTP29-29.20	XTK29-29.20	XTN29-29.20
29.30	1.1535	–	XTP29-29.30	XTK29-29.30	XTN29-29.30
29.37	1.1563	1-5/32	XTP29-29.37	XTK29-29.37	XTN29-29.37
29.40	1.1575	–	XTP29-29.40	XTK29-29.40	XTN29-29.40
29.50	1.1614	–	XTP29-29.50	XTK29-29.50	XTN29-29.50
29.60	1.1654	–	XTP29-29.60	XTK29-29.60	XTN29-29.60
29.70	1.1693	–	XTP29-29.70	XTK29-29.70	XTN29-29.70
29.80	1.1732	–	XTP29-29.80	XTK29-29.80	XTN29-29.80
29.90	1.1772	–	XTP29-29.90	XTK29-29.90	XTN29-29.90
30.00	1.1811	–	XTP29-30.00	XTK29-30.00	XTN29-30.00
30.10	1.1850	–	XTP29-30.10	XTK29-30.10	XTN29-30.10
30.16	1.1875	1-3/16	XTP29-30.16	XTK29-30.16	XTN29-30.16
30.20	1.1890	–	XTP29-30.20	XTK29-30.20	XTN29-30.20
30.30	1.1929	–	XTP29-30.30	XTK29-30.30	XTN29-30.30
30.40	1.1969	–	XTP29-30.40	XTK29-30.40	XTN29-30.40
30.50	1.2008	–	XTP29-30.50	XTK29-30.50	XTN29-30.50
30.60	1.2047	–	XTP29-30.60	XTK29-30.60	XTN29-30.60
30.70	1.2087	–	XTP29-30.70	XTK29-30.70	XTN29-30.70
30.80	1.2126	–	XTP29-30.80	XTK29-30.80	XTN29-30.80
30.90	1.2165	–	XTP29-30.90	XTK29-30.90	XTN29-30.90
30.96	1.2188	1-7/32	XTP29-30.96	XTK29-30.96	XTN29-30.96
31.00	1.2205	–	XTP29-31.00	XTK29-31.00	XTN29-31.00
31.10	1.2244	–	XTP29-31.10	XTK29-31.10	XTN29-31.10
31.20	1.2283	–	XTP29-31.20	XTK29-31.20	XTN29-31.20
31.30	1.2323	–	XTP29-31.30	XTK29-31.30	XTN29-31.30
31.40	1.2362	–	XTP29-31.40	XTK29-31.40	XTN29-31.40
31.50	1.2402	–	XTP29-31.50	XTK29-31.50	XTN29-31.50
31.60	1.2441	–	XTP29-31.60	XTK29-31.60	XTN29-31.60
31.70	1.2480	–	XTP29-31.70	XTK29-31.70	XTN29-31.70
31.75	1.2500	1-1/4	XTP29-31.75	XTK29-31.75	XTN29-31.75
31.80	1.2520	–	XTP29-31.80	XTK29-31.80	XTN29-31.80
31.90	1.2559	–	XTP29-31.90	XTK29-31.90	XTN29-31.90

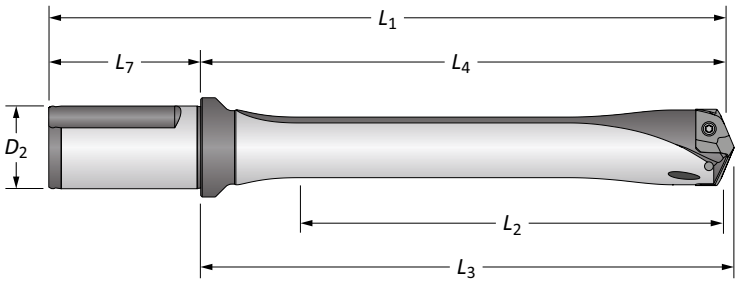
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Flat	Part No.
m	Straight	3xD	96.0	136.2	139.1	196.2	60.0	32.0	YES	**HXT0329S-32FM**
		3xD	96.0	136.2	139.1	196.2	60.0	32.0	NO	**HXT0329S-32CM**
		5xD	160.0	200.1	203.1	260.1	60.0	32.0	YES	**HXT0529S-32FM**
		5xD	160.0	200.1	203.1	260.1	60.0	32.0	NO	**HXT0529S-32CM**
		7xD	224.0	264.1	267.1	324.1	60.0	32.0	YES	**HXT0729S-32FM**
		7xD	224.0	264.1	267.1	324.1	60.0	32.0	NO	**HXT0729S-32CM**
		10xD	319.9	360.4	363.6	420.4	60.0	32.0	YES	⚠ **HXT1029S-32FM**
		10xD	319.9	360.4	363.6	420.4	60.0	32.0	NO	⚠ **HXT1029S-32CM**
i	Straight	3xD	3-25/32	5-3/8	5-1/2	7-21/32	2-9/32	1-1/4	YES	**HXT0329S-125F**
		3xD	3-25/32	5-3/8	5-1/2	7-21/32	2-9/32	1-1/4	NO	**HXT0329S-125C**
		5xD	6-19/64	7-29/32	8-1/64	10-3/16	2-9/32	1-1/4	YES	**HXT0529S-125F**
		5xD	6-19/64	7-29/32	8-1/64	10-3/16	2-9/32	1-1/4	NO	**HXT0529S-125C**
		7xD	8-13/16	10-27/64	10-17/64	12-45/64	2-9/32	1-1/4	YES	**HXT0729S-125F**
		7xD	8-13/16	10-27/64	10-17/64	12-45/64	2-9/32	1-1/4	NO	**HXT0729S-125C**
		10xD	12-19/32	14-3/16	14-5/16	16-15/32	2-9/32	1-1/4	YES	⚠ **HXT1029S-125F**
		10xD	12-19/32	14-3/16	14-5/16	16-15/32	2-9/32	1-1/4	NO	⚠ **HXT1029S-125C**

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

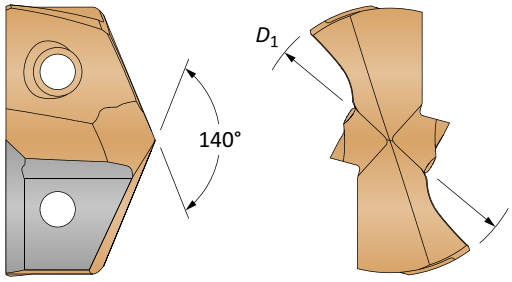
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ **WARNING** Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	D_1 mm	D_1 inch	Fractional Equivalent	Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
K35 (C1)	29.00	1.1417	–	**7C129P-29**	**7C129P-29LR**	–	–
	29.37	1.1563	1-5/32	**7C129P-0105**	**7C129P-0105LR**	–	–
	29.50	1.1614		**7C129P-29.5**	–	–	–
	30.00	1.1811	–	**7C129P-30**	**7C129P-30LR**	–	–
	30.16	1.1875	1-3/16	**7C129P-0106**	**7C129P-0106LR**	–	–
	30.50	1.2008	–	**7C129P-30.5**	**7C129P-30.5LR**	–	–
	30.96	1.2188	1-7/32	**7C129P-0107**	**7C129P-0107LR**	–	–
	31.00	1.2205	–	**7C129P-31**	**7C129P-31LR**	–	–
	31.50	1.2402	–	**7C129P-31.5**	–	–	–
	31.75	1.2500	1-1/4	**7C129P-0108**	**7C129P-0108LR**	–	–
K20 (C2)	29.00	1.1417	–	**7C229P-29**	**7C229P-29LR**	**7C229P-29CI**	**7C229P-29AS**
	29.37	1.1563	1-5/32	**7C229P-0105**	**7C229P-0105LR**	**7C229P-0105CI**	**7C229P-0105AS**
	29.50	1.1614	–	**7C229P-29.5**	–	–	–
	30.00	1.1811	–	**7C229P-30**	**7C229P-30LR**	**7C229P-30CI**	**7C229P-30AS**
	30.16	1.1875	1-3/16	**7C229P-0106**	**7C229P-0106LR**	**7C229P-0106CI**	**7C229P-0106AS**
	30.50	1.2008	–	**7C229P-30.5**	**7C229P-30.5LR**	**7C229P-30.5CI**	**7C229P-30.5AS**
	30.96	1.2188	1-7/32	**7C229P-0107**	**7C229P-0107LR**	**7C229P-0107CI**	**7C229P-0107AS**
	31.00	1.2205	–	**7C229P-31**	**7C229P-31LR**	**7C229P-31CI**	**7C229P-31AS**
	31.50	1.2402	–	**7C229P-31.5**	–	–	–
	31.75	1.2500	1-1/4	**7C229P-0108**	**7C229P-0108LR**	**7C229P-0108CI**	**7C229P-0108AS**

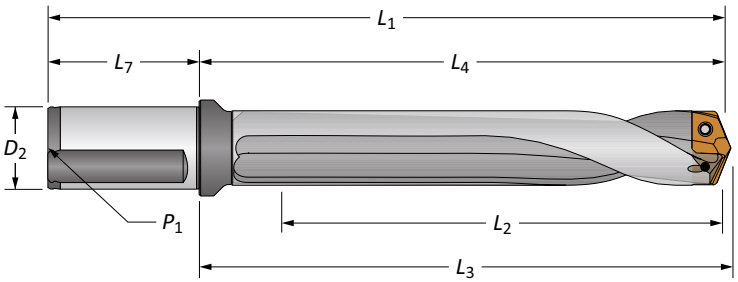
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

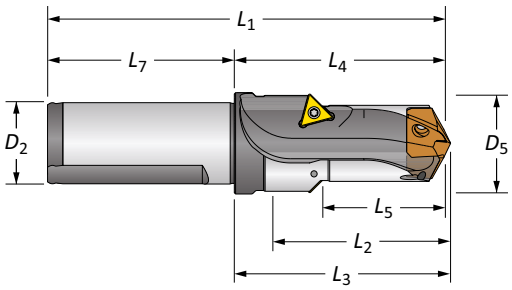
29 Series | Diameter Range: 29.00mm - 31.99mm (1.1417” - 1.2597”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	96.0	136.2	139.1	196.2	60.0	32.0	1/4*	YES	**60329S-32FM**
		5xD	160.0	200.1	203.1	260.1	60.0	32.0	1/4*	YES	**60529S-32FM**
		7xD	224.0	264.1	267.1	324.1	60.0	32.0	1/4*	YES	**60729S-32FM**
	Helical	Stub	35.0	75.2	78.2	135.2	60.0	32.0	1/4*	YES	**60129H-32FM**
		3xD	96.0	136.2	139.1	196.2	60.0	32.0	1/4*	YES	**60329H-32FM**
		3xD	96.0	136.2	139.1	196.2	60.0	32.0	1/4*	NO	**60329H-32CM**
		5xD	160.0	200.1	203.1	260.1	60.0	32.0	1/4*	YES	**60529H-32FM**
		5xD	160.0	200.1	203.1	260.1	60.0	32.0	1/4*	NO	**60529H-32CM**
		7xD	224.0	264.1	267.1	324.1	60.0	32.0	1/4*	YES	**60729H-32FM**
		7xD	224.0	264.1	267.1	324.1	60.0	32.0	1/4*	NO	**60729H-32CM**
i	Straight	3xD	3-25/32	5-3/8	5-1/2	7-21/32	2-9/32	1-1/4	1/4	YES	**60329S-125F**
		5xD	6-19/64	7-29/32	8-1/64	10-3/16	2-9/32	1-1/4	1/4	YES	**60529S-125F**
		7xD	8-13/16	10-27/64	10-17/64	12-45/64	2-9/32	1-1/4	1/4	YES	**60729S-125F**
	Helical	Stub	1-3/8	2-31/32	3-5/64	5-1/4	2-9/32	1-1/4	1/4	YES	**60129H-125F**
		3xD	3-25/32	5-3/8	5-1/2	7-21/32	2-9/32	1-1/4	1/4	YES	**60329H-125F**
		3xD	3-25/32	5-3/8	5-1/2	7-21/32	2-9/32	1-1/4	1/4	NO	**60329H-125C**
		5xD	6-19/64	7-29/32	8-1/64	10-3/16	2-9/32	1-1/4	1/4	YES	**60529H-125F**
		5xD	6-19/64	7-29/32	8-1/64	10-3/16	2-9/32	1-1/4	1/4	NO	**60529H-125C**
		7xD	8-13/16	10-27/64	10-17/64	12-45/64	2-9/32	1-1/4	1/4	YES	**60729H-125F**
		7xD	8-13/16	10-27/64	10-17/64	12-45/64	2-9/32	1-1/4	1/4	NO	**60729H-125C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	37.1	43.5	55.9	75.2	78.2	135.2	60.0	32.0	**60129C45-32FM**	TCMT-16T304
i	1-29/64	1-23/32	2-13/64	2-31/32	3-5/64	5-1/4	2-9/32	1-1/4	**60129C45-125F**	TCMT-16T304

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

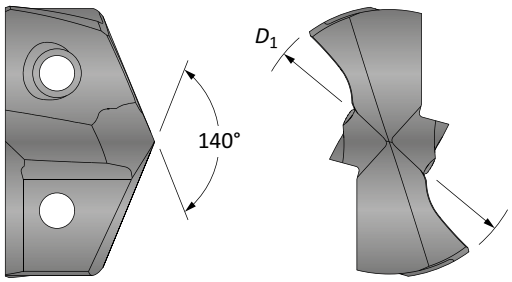
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

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

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

GEN3SYS®XT Pro Drill Inserts

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



Insert					
D_1 mm	D_1 inch	Fractional Equivalent	Part No. P	Part No. K	Part No. N
32.00	1.2598	–	XTP32-32.00	XTK32-32.00	XTN32-32.00
32.10	1.2638	–	XTP32-32.10	XTK32-32.10	XTN32-32.10
32.15	1.2657	1-17/64	XTP32-32.15	XTK32-32.15	XTN32-32.15
32.20	1.2677	–	XTP32-32.20	XTK32-32.20	XTN32-32.20
32.30	1.2717	–	XTP32-32.30	XTK32-32.30	XTN32-32.30
32.40	1.2756	–	XTP32-32.40	XTK32-32.40	XTN32-32.40
32.50	1.2795	–	XTP32-32.50	XTK32-32.50	XTN32-32.50
32.55	1.2813	1-9/32	XTP32-32.55	XTK32-32.55	XTN32-32.55
32.60	1.2835	–	XTP32-32.60	XTK32-32.60	XTN32-32.60
32.70	1.2874	–	XTP32-32.70	XTK32-32.70	XTN32-32.70
32.80	1.2913	–	XTP32-32.80	XTK32-32.80	XTN32-32.80
32.90	1.2953	–	XTP32-32.90	XTK32-32.90	XTN32-32.90
33.00	1.2992	–	XTP32-33.00	XTK32-33.00	XTN32-33.00
33.10	1.3031	–	XTP32-33.10	XTK32-33.10	XTN32-33.10
33.20	1.3071	–	XTP32-33.20	XTK32-33.20	XTN32-33.20
33.30	1.3110	–	XTP32-33.30	XTK32-33.30	XTN32-33.30
33.34	1.3125	1-5/16	XTP32-33.34	XTK32-33.34	XTN32-33.34
33.40	1.3150	–	XTP32-33.40	XTK32-33.40	XTN32-33.40
33.50	1.3189	–	XTP32-33.50	XTK32-33.50	XTN32-33.50
33.60	1.3228	–	XTP32-33.60	XTK32-33.60	XTN32-33.60
33.70	1.3268	–	XTP32-33.70	XTK32-33.70	XTN32-33.70
33.80	1.3307	–	XTP32-33.80	XTK32-33.80	XTN32-33.80
33.90	1.3346	–	XTP32-33.90	XTK32-33.90	XTN32-33.90
34.00	1.3386	–	XTP32-34.00	XTK32-34.00	XTN32-34.00
34.10	1.3425	–	XTP32-34.10	XTK32-34.10	XTN32-34.10
34.13	1.3438	1-11/32	XTP32-34.13	XTK32-34.13	XTN32-34.13
34.20	1.3465	–	XTP32-34.20	XTK32-34.20	XTN32-34.20
34.30	1.3504	–	XTP32-34.30	XTK32-34.30	XTN32-34.30
34.40	1.3543	–	XTP32-34.40	XTK32-34.40	XTN32-34.40
34.50	1.3583	–	XTP32-34.50	XTK32-34.50	XTN32-34.50
34.60	1.3622	–	XTP32-34.60	XTK32-34.60	XTN32-34.60
34.70	1.3661	–	XTP32-34.70	XTK32-34.70	XTN32-34.70
34.80	1.3701	–	XTP32-34.80	XTK32-34.80	XTN32-34.80
34.90	1.3740	–	XTP32-34.90	XTK32-34.90	XTN32-34.90
34.93	1.3750	1-3/8	XTP32-34.93	XTK32-34.93	XTN32-34.93
35.00	1.3780	–	XTP32-35.00	XTK32-35.00	XTN32-35.00

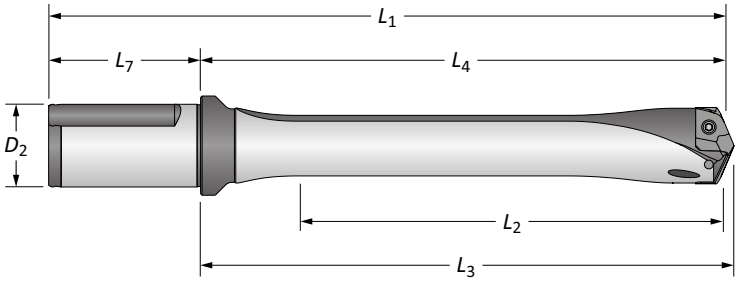
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Pro Drill Insert Holders

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



	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank Flat	Part No.
m	Straight	3xD	105.0	157.7	161.3	227.7	60.0	32.0	YES	HXT0332S-32FM
		3xD	105.0	157.7	161.3	227.7	60.0	32.0	NO	HXT0332S-32CM
		5xD	175.0	227.7	231.3	297.7	60.0	32.0	YES	HXT0532S-32FM
		5xD	175.0	227.7	231.3	297.7	60.0	32.0	NO	HXT0532S-32CM
		7xD	244.9	297.7	301.3	367.7	60.0	32.0	YES	HXT0732S-32FM
		7xD	244.9	297.7	301.3	367.7	60.0	32.0	NO	HXT0732S-32CM
		10xD	350.0	402.8	406.4	462.8	60.0	32.0	YES	⚠ HXT1032S-32FM
		10xD	350.0	402.8	406.4	462.8	60.0	32.0	NO	⚠ HXT1032S-32CM
i	Straight	3xD	4-9/64	6-7/32	6-23/64	8-29/32	2-11/16	1-1/2	YES	HXT0332S-150F
		3xD	4-9/64	6-7/32	6-23/64	8-29/32	2-11/16	1-1/2	NO	HXT0332S-150C
		5xD	6-57/64	8-31/32	9-7/64	11-21/32	2-11/16	1-1/2	YES	HXT0532S-150F
		5xD	6-57/64	8-31/32	9-7/64	11-21/32	2-11/16	1-1/2	NO	HXT0532S-150C
		7xD	9-41/64	11-23/32	11-55/64	14-13/32	2-11/16	1-1/2	YES	HXT0732S-150F
		7xD	9-41/64	11-23/32	11-55/64	14-13/32	2-11/16	1-1/2	NO	HXT0732S-150C
		10xD	13-25/32	15-55/64	16	18-35/64	2-11/16	1-1/2	YES	⚠ HXT1032S-150F
		10xD	13-25/32	15-55/64	16	18-35/64	2-11/16	1-1/2	NO	⚠ HXT1032S-150C

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7495-IP15-1	7495N-IP15-1	8IP-15	8IP-15TL	8IP-15B	690 N-cm (61.0 in-lbs)

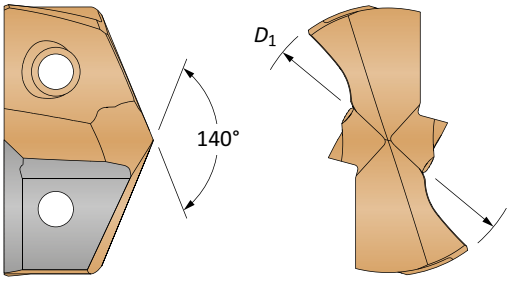
*Tightening torques are calculated with a friction coefficient of μ = 0.14 and develop 90% of ultimate yield strength

m = Metric (mm)
i = Imperial (in)
Screws sold in multiples of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A2: 65 for deep hole drilling guidelines in this section of the catalogue. Visit **www.alliedmachine.com** for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

GEN3SYS®XT Drill Inserts

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



Insert							
Carbide Substrate	D_1 mm	D_1 inch	Fractional Equivalent	Standard Part No.	Low Rake Part No.	Cast Iron Part No.	Stainless Part No.
K35 (C1)	32.00	1.2598	–	**7C132P-32**	**7C132P-32LR**	–	–
	32.15	1.2658	1-17/64	**7C132P-32.15**	**7C132P-32.15LR**	–	–
	32.50	1.2795	–	**7C132P-32.5**	**7C132P-32.5LR**	–	–
	32.55	1.2813	1-9/32	**7C132P-0109**	**7C132P-0109LR**	–	–
	33.00	1.2992	–	**7C132P-33**	**7C132P-33LR**	–	–
	33.34	1.3125	1-5/16	**7C132P-0110**	**7C132P-0110LR**	–	–
	33.50	1.3189	–	**7C132P-33.5**	**7C132P-33.5LR**	–	–
	34.00	1.3386	–	**7C132P-34**	**7C132P-34LR**	–	–
	34.13	1.3438	1-11/32	**7C132P-0111**	**7C132P-0111LR**	–	–
	34.50	1.3583	–	**7C132P-34.5**	**7C132P-34.5LR**	–	–
	34.93	1.3750	1-3/8	**7C132P-0112**	**7C132P-0112LR**	–	–
	35.00	1.3780	–	**7C132P-35**	**7C132P-35LR**	–	–
K20 (C2)	32.00	1.2598	–	**7C232P-32**	**7C232P-32LR**	**7C232P-32CI**	**7C232P-32AS**
	32.15	1.2658	1-17/64	**7C232P-32.15**	**7C232P-32.15LR**	**7C232P-32.15CI**	**7C232P-32.15AS**
	32.50	1.2795	–	**7C232P-32.5**	**7C232P-32.5LR**	**7C232P-32.5CI**	**7C232P-32.5AS**
	32.55	1.2813	1-9/32	**7C232P-0109**	**7C232P-0109LR**	**7C232P-0109CI**	**7C232P-0109AS**
	33.00	1.2992	–	**7C232P-33**	**7C232P-33LR**	**7C232P-33CI**	**7C232P-33AS**
	33.34	1.3125	1-5/16	**7C232P-0110**	**7C232P-0110LR**	**7C232P-0110CI**	**7C232P-0110AS**
	33.50	1.3189	–	**7C232P-33.5**	**7C232P-33.5LR**	**7C232P-33.5CI**	**7C232P-33.5AS**
	34.00	1.3386	–	**7C232P-34**	**7C232P-34LR**	**7C232P-34CI**	**7C232P-34AS**
	34.13	1.3438	1-11/32	**7C232P-0111**	**7C232P-0111LR**	**7C232P-0111CI**	**7C232P-0111AS**
	34.50	1.3583	–	**7C232P-34.5**	**7C232P-34.5LR**	**7C232P-34.5CI**	**7C232P-34.5AS**
	34.93	1.3750	1-3/8	**7C232P-0112**	**7C232P-0112LR**	**7C232P-0112CI**	**7C232P-0112AS**
	35.00	1.3780	–	**7C232P-35**	**7C232P-35LR**	**7C232P-35CI**	**7C232P-35AS**

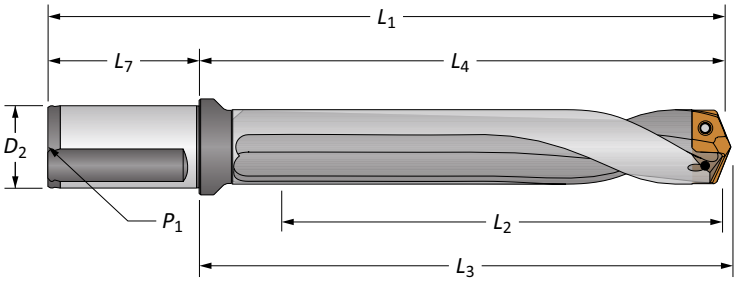
Inserts sold in multiples of 1

A2: 66 - 75
Key on A2: 1
A2: 2 - 5

Sizes not shown are available upon request. When ordering, please follow the example below:	
Metric:	13.16mm, Steel, 13 series = use Part No. **XTP13-13.16**
Imperial:	0.5180”, Steel, 13 series = use Part No. **XTP13-13.16**

GEN3SYS®XT Standard Drill Insert Holders

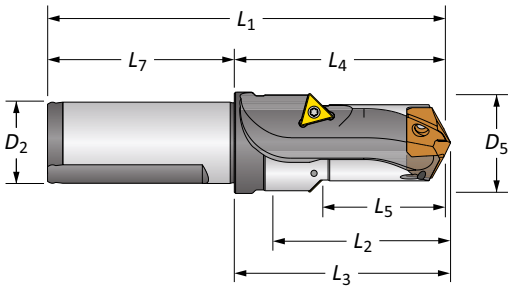
32 Series | Diameter Range: 32.00mm - 35.00mm (1.2598” - 1.3780”)



Straight and Helical

	Flute	Length	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Shank P_1	Shank Flat	Part No.
m	Straight	3xD	105.0	157.7	161.3	227.7	70.0	40.0	1/4*	YES	**60332S-40FM**
		5xD	175.0	227.7	231.3	297.7	70.0	40.0	1/4*	YES	**60532S-40FM**
		7xD	244.9	297.7	301.3	367.7	70.0	40.0	1/4*	YES	**60732S-40FM**
	Helical	Stub	38.0	90.7	94.2	160.7	70.0	40.0	1/4*	YES	**60132H-40FM**
		3xD	105.0	157.7	161.3	227.7	70.0	40.0	1/4*	YES	**60332H-40FM**
		3xD	105.0	157.7	161.3	227.7	70.0	40.0	1/4*	NO	**60332H-40CM**
		5xD	175.0	227.7	231.3	297.7	70.0	40.0	1/4*	YES	**60532H-40FM**
		5xD	175.0	227.7	231.3	297.7	70.0	40.0	1/4*	NO	**60532H-40CM**
		7xD	244.9	297.7	301.3	367.7	70.0	40.0	1/4*	YES	**60732H-40FM**
		7xD	244.9	297.7	301.3	367.7	70.0	40.0	1/4*	NO	**60732H-40CM**
i	Straight	3xD	4-9/64	6-7/32	6-23/64	8-29/32	2-11/16	1-1/2	1/4	YES	**60332S-150F**
		5xD	6-57/64	8-31/32	9-7/64	11-21/32	2-11/16	1-1/2	1/4	YES	**60532S-150F**
		7xD	9-41/64	11-23/32	11-55/64	14-13/32	2-11/16	1-1/2	1/4	YES	**60732S-150F**
	Helical	Stub	1-1/2	3-37/64	3-45/64	6-1/4	2-11/16	1-1/2	1/4	YES	**60132H-150F**
		3xD	4-9/64	6-7/32	6-23/64	8-29/32	2-11/16	1-1/2	1/4	YES	**60332H-150F**
		3xD	4-9/64	6-7/32	6-23/64	8-29/32	2-11/16	1-1/2	1/4	NO	**60332H-150C**
		5xD	6-57/64	8-31/32	9-7/64	11-21/32	2-11/16	1-1/2	1/4	YES	**60532H-150F**
		5xD	6-57/64	8-31/32	9-7/64	11-21/32	2-11/16	1-1/2	1/4	NO	**60532H-150C**
		7xD	9-41/64	11-23/32	11-55/64	14-13/32	2-11/16	1-1/2	1/4	YES	**60732H-150F**
		7xD	9-41/64	11-23/32	11-55/64	14-13/32	2-11/16	1-1/2	1/4	NO	**60732H-150C**

*Thread to BSP and ISO 7-1



Drill / Chamfer

	Step D_5	Step L_5	Body L_2	Body L_4	Body L_3	Body L_1	Shank L_7	Shank D_2	Part No.	Chamfer Insert
m	40.1	48.0	62.4	90.7	94.2	160.6	70.0	40.0	**60132C45-40FM**	TCMT-16T304
i	1-37/64	1-57/64	2-29/64	3-37/64	3-23/32	6-1/4	2-11/16	1-1/2	**60132C45-150F**	TCMT-16T304

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	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 μ = 0.14 and develop 90% of ultimate yield strength

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

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