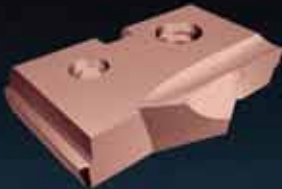




ALLIED MACHINE & ENGINEERING CORP.

Exclusive Structural Steel T-A[®] Drilling System



U.S. Patent No.: 7,147,414
Other International Patents Pending



U.S. Patent No.: 6,685,402 & 6,986,628
& 7,114,893 & 7,371,035
Euro Patent No.: 1,372,894 DE, GB, IT, FR
Other U.S. & International Patents Pending



U.S. Patent No.: 6,685,402 & 6,986,628
& 7,114,893 & 7,371,035
Euro Patent No.: 1,372,894 DE, GB, IT, FR
Other U.S. & International Patents Pending



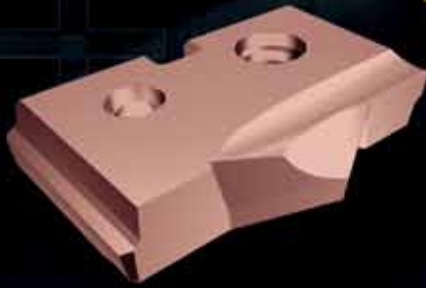
U.S. Patent No.: 6,685,402 & 6,986,628 & 7,011,478
& 7,018,145 & 7,144,893 & 7,241,089 & 7,371,035
Euro Patent No.: 1,372,894 DE, GB, IT, FR
Korean Patent No.: 764140
Other U.S. & International Patents Pending

Represented by:



T-A[®] Structural Steel Drilling System

Insert Features and Benefits



U.S. Patent No.: 7,147,414
Other International Patents Pending

T-A[®] Thin Wall Geometry Insert

For material up to 7/16" thick

- **AM200[®] Coating allows for:**
 - Increased tool life
 - Better heat resistance
- **Patented blade design for thin wall I-Beam and steel plate applications**
 - Provides better hole tolerance
 - Increased productivity
 - Superior hole quality
- **Made from Super Cobalt**
 - Offers excellent wear resistance while maintaining toughness

T-A[®] Notch Point[®] and 150° Geometry Insert

For material greater than 7/16" thick



U.S. Patent No.: 6,685,402 & 6,986,628 &
7,114,893 & 7,371,035
Euro Patent No: 1 372 894 DE, GB, IT, FR
Other U.S. & International Patents Pending

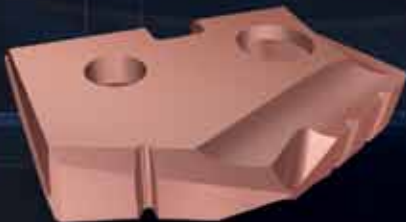
- **AM200[®] Coating allows for:**
 - Increased tool life
 - Better heat resistance
- **Patented design provides:**
 - Excellent centering ability
 - Less tool lead off
 - Significant reduction in bell mousing
 - Reduction in thrust
 - Better chip control
- **Made from Super Cobalt**
 - Offers excellent wear resistance while maintaining toughness
- **150° Structural Steel Drill Insert offers the same features as the Notch Point[®] in addition to producing a reduced exit burr**



U.S. Patent No.: 6,685,402 & 6,986,628
& 7,114,893 & 7,371,035
Euro Patent No: 1 372 894 DE, GB, IT, FR
Other U.S. & International Patents Pending

GEN2 T-A[®] Drill Inserts

For material greater than 7/16" thick



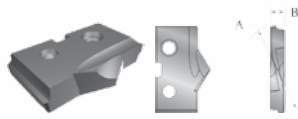
U.S. Patent No.: 6,685,402 & 6,986,628 & 7,011,478
& 7,018,145 & 7,144,893 & 7,241,089 & 7,371,035
Euro Patent No.: 1 372 894 DE, GB, IT, FR
Korean Patent No.: 764140
Other U.S. & International Patents Pending

- **AM200[®] Coating allows for:**
 - Increased tool life
 - Better heat resistance
- **Patented design provides:**
 - Lower drilling forces
 - Increased drill stability
 - Improved chip formation



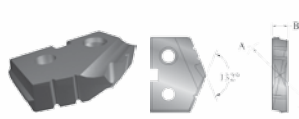
Structural T-A[®] Drill Inserts

TiAIN Coating



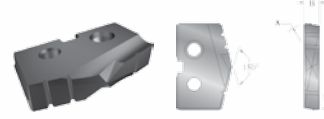
Thin Wall

U.S. Patent No.: 7,147,414
Other U.S. & International Patents Pending



Notch Point

U.S. Patent No.: 6,685,402 & 6,986,628
& 7,114,893 & 7,371,035
Euro Patent No: 1 372 894 DE, GB, IT, FR
Other U.S. & International Patents Pending



150° Structural Steel

U.S. Patent No.: 6,685,402 & 6,986,628 & 7,114,893 & 7,371,035
Euro Patent No: 1 372 894 DE, GB, IT, FR
Other U.S. & International Patents Pending

Series	Material	A (Diameter)			B Thickness	Item Number, Coating, and Availability					
		Fractional Equivalent	(mm)	(Inch)		Thin Wall TiAIN	●	Notch Point [®] TiAIN	●	150° Structural Steel	●
0	Super Cobalt	-	14,00	0.5512	1/8"	150A-14-TW	○	150A-14-NP	○	150A-14-SS	○
		9/16"	14,29	0.5625		150A-0018-TW	○	150A-0018-NP	○	150A-0018-SS	○
		5/8"	15,88	0.6250		150A-0020-TW	○	150A-0020-NP	○	150A-0020-SS	○
		-	16,00	0.6299		150A-16-TW	○	150A-16-NP	○	150A-16-SS	○
		11/16"	17,46	0.6875		150A-0022-TW	○	150A-0022-NP	○	150A-0022-SS	○
1		-	18,00	0.7087	5/32"	151A-18-TW	○	151A-18-NP	○	151A-18-SS	○
		13/16"	20,64	0.8125		151A-0026-TW	○	151A-0026-NP	○	151A-0026-SS	○
		-	22,00	0.8661		151A-22-TW	○	151A-22-NP	○	151A-22-SS	○
		7/8"	22,23	0.8750		151A-0028-TW	○	151A-0028-NP	○	151A-0028-SS	○
		15/16"	23,81	0.9375		151A-0030-TW	○	151A-0030-NP	○	151A-0030-SS	○
2		-	24,00	0.9449	3/16"	151A-24-TW	○	151A-24-NP	○	151A-24-SS	○
		1"	25,40	1.0000		152A-0100-TW	○	152A-0100-NP	○	152A-0100-SS	○
		-	26,00	1.0236		152A-26-TW	○	152A-26-NP	○	152A-26-SS	○
		1-1/16"	26,99	1.0625		152A-0102-TW	○	152A-0102-NP	○	152A-0102-SS	○
		-	27,00	1.0630		152A-27-TW	○	152A-27-NP	○	152A-27-SS	○
	1-1/8"	28,58	1.1250	152A-0104-TW		○	152A-0104-NP	○	152A-0104-SS	○	
	1-3/16"	30,16	1.1875	152A-0106-TW		○	152A-0106-NP	○	152A-0106-SS	○	
	-	31,00	1.2205	152A-31-TW		○	152A-31-NP	○	152A-31-SS	○	
	1-1/4"	31,75	1.2500	152A-0108-TW		○	152A-0108-NP	○	152A-0108-SS	○	
	-	33,00	1.2992	152A-33-TW		○	152A-33-NP	○	152A-33-SS	○	
3	1-5/16"	33,34	1.3125	1/4"	152A-0110-TW	○	152A-0110-NP	○	152A-0110-SS	○	
	1-3/8"	34,93	1.3750		152A-0112-TW	○	152A-0112-NP	○	152A-0112-SS	○	
	1-7/16"	36,51	1.4375		153A-0114-TW	○	153A-0114-NP	○	153A-0114-SS	○	
	1-1/2"	38,10	1.5000		153A-0116-TW	○	153A-0116-NP	○	153A-0116-SS	○	
	-	39,00	1.5354		153A-39-TW	○	153A-39-NP	○	153A-39-SS	○	
	1-9/16"	39,69	1.5625	153A-0118-TW	○	153A-0118-NP	○	153A-0118-SS	○		

- Availability Codes
- Stocked
- ▲ Non-Stocked



Structural T-A® Drill Inserts

AM200® Coating



Thin Wall

U.S. Patent No.: 7,147,414
Other U.S. & International Patents Pending



Notch Point

U.S. Patent No.: 6,685,402 & 6,986,628
& 7,114,893 & 7,371,035
Euro Patent No: 1 372 894 DE, GB, IT, FR
Other U.S. & International Patents Pending



150° Structural Steel

U.S. Patent No.: 6,685,402 & 6,986,628 & 7,114,893 & 7,371,035
Euro Patent No: 1 372 894 DE, GB, IT, FR
Other U.S. & International Patents Pending



GEN2 T-A®

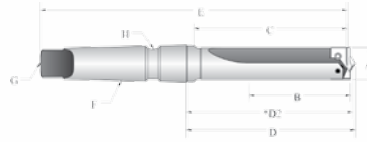
U.S. Patent No.: 6,685,402 & 6,986,628 & 7,011,478 & 7,018,145 & 7,144,893 & 7,241,089 & 7,371,035
Euro Patent No.: 1 372 894 DE, GB, IT, FR
Korean Patent No.: 764140
Other U.S. & International Patents Pending

Series	Material	A (Diameter)			B	Item Number, Coating, and Availability							
		Fractional Equivalent	(mm)	(Inch)		Thick-ness	Thin Wall AM200®	Notch Point® AM200®	150° Structural Steel AM200®	GEN2 T-A® HSS AM200®	GEN2 T-A® Carbide AM200®		
							●	●	●	●	●		
0	Super Cobalt	-	14,00	0.5512	1/8"	150H-14-TW	150H-14-NP	150H-14-SS	450H-14	4C10H-14			
		9/16"	14,29	0.5625		150H-0018-TW	150H-0018-NP	150H-0018-SS	450H-0018	4C10H-0018			
		5/8"	15,88	0.6250		150H-0020-TW	150H-0020-NP	150H-0020-SS	450H-0020	4C10H-0020			
		-	16,00	0.6299		150H-16-TW	150H-16-NP	150H-16-SS	450H-16	4C10H-16			
		11/16"	17,46	0.6875		150H-0022-TW	150H-0022-NP	150H-0022-SS	450H-0022	4C10H-0022			
1		-	18,00	0.7087	5/32"	151H-18-TW	151H-18-NP	151H-18-SS	451H-18	4C11H-18			
		13/16"	20,64	0.8125		151H-0026-TW	151H-0026-NP	151H-0026-SS	451H-0026	4C11H-0026			
		-	21,00	0.8268		151H-21-TW	151H-21-NP	151H-21-SS	451H-21	4C11H-21			
		-	22,00	0.8661		151H-22-TW	151H-22-NP	151H-22-SS	451H-22	4C11H-22			
		7/8"	22,23	0.8750		151H-0028-TW	151H-0028-NP	151H-0028-SS	451H-0028	4C11H-0028			
		15/16"	23,81	0.9375		151H-0030-TW	151H-0030-NP	151H-0030-SS	451H-0030	4C11H-0030			
		-	24,00	0.9449		151H-24-TW	151H-24-NP	151H-24-SS	451H-24	4C11H-24			
2		1"	25,40	1.0000	3/16"	152H-0100-TW	152H-0100-NP	152H-0100-SS	452H-0100	4C12H-0100			
		-	26,00	1.0236		152H-26-TW	152H-26-NP	152H-26-SS	452H-26	4C12H-26			
		1-1/16"	26,99	1.0625		152H-0102-TW	152H-0102-NP	152H-0102-SS	452H-0102	4C12H-0102			
		-	27,00	1.0630		152H-27-TW	152H-27-NP	152H-27-SS	452H-27	4C12H-27			
		1-1/8"	28,58	1.1250		152H-0104-TW	152H-0104-NP	152H-0104-SS	452H-0104	4C12H-0104			
		1-3/16"	30,16	1.1875		152H-0106-TW	152H-0106-NP	152H-0106-SS	452H-0106	4C12H-0106			
		-	31,00	1.2205		152H-31-TW	152H-31-NP	152H-31-SS	452H-31	4C12H-31			
		1-1/4"	31,75	1.2500		152H-0108-TW	152H-0108-NP	152H-0108-SS	452H-0108	4C12H-0108			
	-	33,00	1.2992	152H-33-TW		152H-33-NP	152H-33-SS	452H-33	4C12H-33				
	1-5/16"	33,34	1.3125	152H-0110-TW		152H-0110-NP	152H-0110-SS	452H-0110	4C12H-0110				
3	1-3/8"	34,93	1.3750	152H-0112-TW	152H-0112-NP	152H-0112-SS	452H-0112	4C12H-0112					
	1-7/16"	36,51	1.4375	1/4"	153H-0114-TW	153H-0114-NP	153H-0114-SS	453H-0114	-				
	1-1/2"	38,10	1.5000		153H-0116-TW	-	153H-0116-SS	453H-0116	-				
	-	39,00	1.5354		153H-39-TW	-	153H-39-SS	453H-39	-				
1-9/16"	39,69	1.5625	153H-0118-TW		-	153H-0118-SS	453H-0118	-					

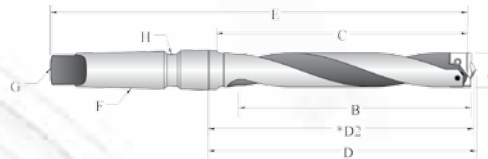
- Availability Codes
- Stocked
- ▲ Non-Stocked

Structural T-A® Holders

Short and Standard Length
Inch



SHORT LENGTH - Taper Shank Holder - Straight Flute											
Series	Item Number	A	B	C	D	*D2	E	F	G	H	●
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
0	22000S-003IS036	9/16"	1-3/8"	2-3/16"	2-35/64"	2-31/64"	6-1/16"	#3	TTC	TSC	○
0.5	22005S-003IS040	5/8"	1-3/8"	2-3/16"	2-35/64"	2-31/64"	6-1/16"	#3	TTC	TSC	○
	22005S-003IS044	11/16"	1-3/8"	2-3/16"	2-35/64"	2-31/64"	6-1/16"	#3	TTC	TSC	○
1	22010S-003IS045	18mm	2-3/4"	3-7/8"	4-17/64"	4-13/64"	7-3/4"	#3	TTC	TSC	○
	22010S-004IS045	18mm	2-3/4"	3-7/8"	4-21/64"	4-17/64"	8-3/4"	#4	TTC	TSC	○
	22010S-003IS052	13/16"	2-3/4"	3-7/8"	4-17/64"	4-13/64"	7-3/4"	#3	TTC	TSC	○
	22010S-004IS052	13/16"	2-3/4"	3-7/8"	4-21/64"	4-17/64"	8-3/4"	#4	TTC	TSC	○
1.5	22015S-003IS056	7/8"	2-3/4"	3-7/8"	4-17/64"	4-13/64"	7-3/4"	#3	TTC	TSC	○
	22015S-004IS056	7/8"	2-3/4"	3-7/8"	4-21/64"	4-17/64"	8-3/4"	#4	TTC	TSC	○
	22015S-003IS060	15/16"	2-3/4"	3-7/8"	4-17/64"	4-13/64"	7-3/4"	#3	TTC	TSC	○
	22015S-004IS060	15/16"	2-3/4"	3-7/8"	4-21/64"	4-17/64"	8-3/4"	#4	TTC	TSC	○
2	22020S-004IS100	1" - 1-3/8"	3-3/8"	4-1/2"	4-63/64"	4-57/64"	9-3/8"	#4	TTC	TSC	○
2.5	22025S-004IS112	1-3/16" - 1-3/8"	3-3/8"	4-1/2"	4-63/64"	4-57/64"	9-3/8"	#4	TTC	TSC	○
3	22030S-004IS126	1-13/32" - 1-7/8"	4-3/4"	6"	6-1/2"	6-7/16"	10-7/8"	#4	TTC	TSC	○



STANDARD LENGTH - Taper Shank Holder - Helical Flute											
Series	Item Number	A	B	C	D	*D2	E	F	G	H	●
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
0	24000H-003IS036	9/16"	2-1/2"	3-5/16"	3-43/64"	3-39/64"	7-3/16"	#3	TTC	TSC	○
0.5	24005H-003IS040	5/8"	2-1/2"	3-5/16"	3-43/64"	3-39/64"	7-3/16"	#3	TTC	TSC	○
	24005H-003IS044	11/16"	2-1/2"	3-5/16"	3-43/64"	3-39/64"	7-3/16"	#3	TTC	TSC	○
1	24010H-003IS045	18mm	4-3/4"	5-7/8"	6-17/64"	6-13/64"	9-3/4"	#3	TTC	TSC	○
	24010H-004IS045	18mm	4-3/4"	5-7/8"	6-21/64"	6-17/64"	9-3/4"	#4	TTC	TSC	○
	24010H-003IS052	13/16"	4-3/4"	5-7/8"	6-17/64"	6-13/64"	9-3/4"	#3	TTC	TSC	○
	24010H-004IS052	13/16"	4-3/4"	5-7/8"	6-21/64"	6-17/64"	10-3/4"	#4	TTC	TSC	○
1.5	24015H-003IS056	7/8"	4-3/4"	5-7/8"	6-17/64"	6-13/64"	9-3/4"	#3	TTC	TSC	○
	24015H-004IS056	7/8"	4-3/4"	5-7/8"	6-21/64"	6-17/64"	10-3/4"	#4	TTC	TSC	○
	24015H-003IS060	15/16"	4-3/4"	5-7/8"	6-17/64"	6-13/64"	9-3/4"	#3	TTC	TSC	○
	24015H-004IS060	15/16"	4-3/4"	5-7/8"	6-21/64"	6-17/64"	10-3/4"	#4	TTC	TSC	○
2	24020H-004IS100	1" - 1-3/8"	5-3/8"	6-1/2"	6-63/64"	6-57/64"	11-3/8"	#4	TTC	TSC	○
2.5	24025H-004IS112	1-3/16" - 1-3/8"	5-3/8"	6-1/2"	6-63/64"	6-57/64"	11-3/8"	#4	TTC	TSC	○
3	24030H-004IS126	1-13/32" - 1-7/8"	6-1/2"	7-3/4"	8-1/4"	8-3/16"	12-5/8"	#4	TTC	TSC	○

* If using Structural Steel Holder with Notch Point®, GEN2 T-A®, or 150° Structural Steel T-A® Drill Insert Geometry.

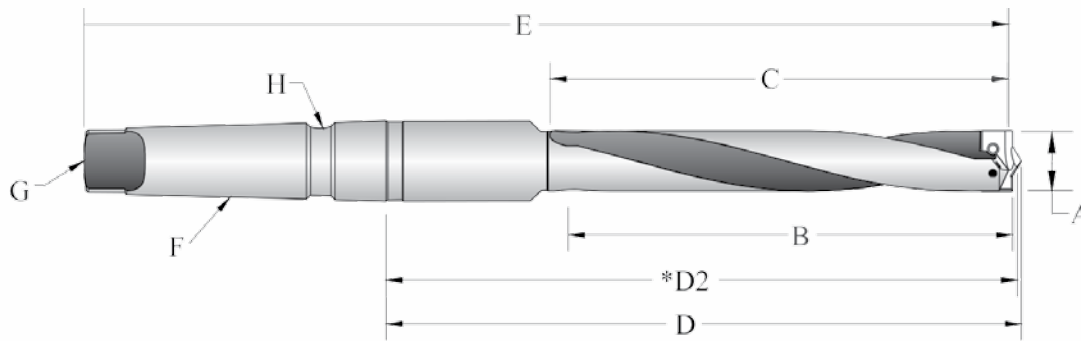
TTC = Through Tang Coolant
TSC = Through Shank Coolant

- Availability Codes
- Stocked
- ▲ Non-Stocked



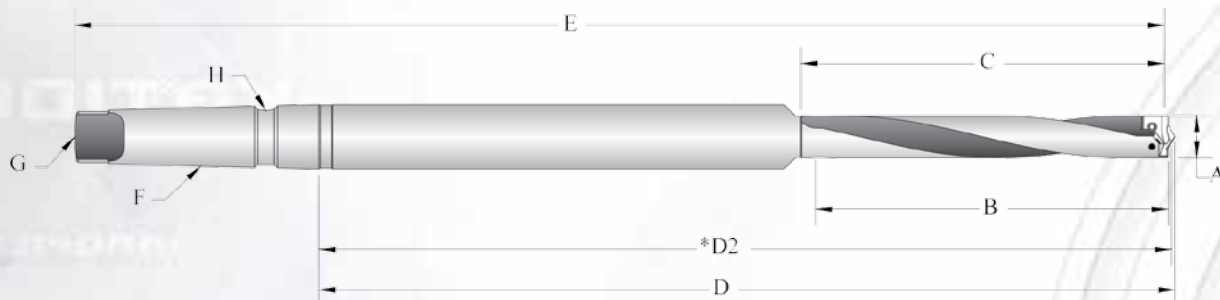
Structural T-A[®] Drill Inserts

Extended and Long Length
Inch



EXTENDED LENGTH - Taper Shank Holder - Straight Flute

Series	Item Number	A	B	C	D	*D2	E	F	G	H	●
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
0.5	25005H-003IS044	11/16"	6-1/2"	9-7/16"	9-51/64"	9-19/32"	13-5/16"	#3	TTC	TSC	○
1	25010H-003IS045	18mm	6-1/2"	9-11/32"	9-47/64"	9-1/2"	13-7/32"	#3	TTC	TSC	○
	25010H-003IS052	13/16"	6-1/2"	9-11/32"	9-47/64"	9-1/2"	13-7/32"	#3	TTC	TSC	○
	25010H-004IS052	13/16"	6-1/2"	9-9/32"	9-47/64"	9-43/64"	14-5/32"	#4	TTC	TSC	○
1.5	25015H-003IS060	15/16"	6-1/2"	9-11/32"	9-47/64"	9-15/64"	13-7/32"	#3	TTC	TSC	○
	25015H-004IS060	15/16"	6-1/2"	9-9/32"	9-47/64"	9-43/64"	14-5/32"	#4	TTC	TSC	○
2	22020H-003IS100	1" - 1-3/8"	6-1/2"	9-11/32"	9-3/4"	9-29/64"	13-7/32"	#3	TTC	TSC	○
	25020H-004IS100	1" - 1-3/8"	6-1/2"	9-7/32"	9-3/4"	9-43/64"	14-5/32"	#4	TTC	TSC	○



LONG LENGTH - Taper Shank Holder - Helical Flute

Series	Item Number	A	B	C	D	*D2	E	F	G	H	●
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
1	26010H-004IS052	13/16"	6-1/2"	15-25/32"	16-15/64"	16-11/64"	20-21/32"	#4	TTC	TSC	○
1.5	26015H-004IS060	15/16"	6-1/2"	15-13/16"	16-13/64"	16-13/64"	20-11/16"	#4	TTC	TSC	○
2	26020H-004IS100	1" - 1-3/8"	6-1/2"	16"	16-25/64"	16-25/64"	20-7/8"	#4	TTC	TSC	○

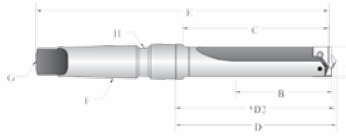
* If using Structural Steel Holder with Notch Point[®], GEN2 T-A[®], or 150° Structural Steel T-A[®] Drill Insert Geometry.

TTC = Through Tang Coolant
TSC = Through Shank Coolant

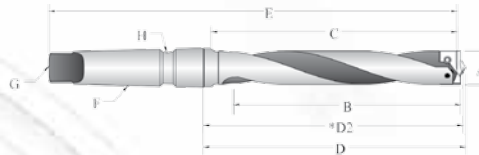
- Availability Codes
- Stocked
- ▲ Non-Stocked

Structural T-A® Holders

Short and Standard Length
Metric



SHORT LENGTH - Taper Shank Holder - Straight Flute											
Series	Item Number	A	B	C	D	*D2	E	F	G	H	①
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
0	22000S-003IS036	14	35	56	64.7	63.1	154	#3	TTC	TSC	○
0.5	22005S-003IS040	16	35	56	64.7	63.1	154	#3	TTC	TSC	○
	22005S-003IS044	17.5	35	56	64.7	63.1	154	#3	TTC	TSC	○
1	22010S-003IS045	18	70	98	108.4	106.8	197	#3	TTC	TSC	○
	22010S-004IS045	18	70	98	109.9	108.3	222	#4	TTC	TSC	○
	22010S-003IS052	21	70	98	108.4	106.8	197	#3	TTC	TSC	○
	22010S-004IS052	21	70	98	109.9	108.3	222	#4	TTC	TSC	○
1.5	22015S-003IS056	22	70	98	108.4	106.8	197	#3	TTC	TSC	○
	22015S-004IS056	22	70	98	109.9	108.3	222	#4	TTC	TSC	○
	22015S-003IS060	24	70	98	108.4	106.8	197	#3	TTC	TSC	○
	22015S-004IS060	24	70	98	109.9	108.3	222	#4	TTC	TSC	○
2	22020S-004IS100	26	86	114	126.6	124.2	238	#4	TTC	TSC	○
2.5	22025S-004IS112	31	86	114	126.6	124.2	238	#4	TTC	TSC	○
3	22030S-004IS126	39	121	152	165.1	163.5	276	#4	TTC	TSC	○



STANDARD LENGTH - Taper Shank Holder - Helical Flute											
Series	Item Number	A	B	C	D	*D2	E	F	G	H	①
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
0	24000H-003IS036	14	64	84	93.3	91.7	183	#3	TTC	TSC	○
0.5	24005H-003IS040	16	64	84	93.3	91.7	183	#3	TTC	TSC	○
	24005H-003IS044	17.5	64	84	93.3	91.7	183	#3	TTC	TSC	○
1	24010H-003IS045	18	121	149	159.2	157.6	248	#3	TTC	TSC	○
	24010H-004IS045	18	121	149	160.8	159.2	273	#4	TTC	TSC	○
	24010H-003IS052	21	121	149	159.2	157.6	248	#3	TTC	TSC	○
	24010H-004IS052	21	121	149	160.8	159.2	273	#4	TTC	TSC	○
1.5	24015H-003IS056	22	121	149	159.2	157.6	248	#3	TTC	TSC	○
	24015H-004IS056	22	121	149	160.8	159.2	273	#4	TTC	TSC	○
	24015H-003IS060	24	121	149	159.2	157.6	248	#3	TTC	TSC	○
	24015H-004IS060	24	121	149	160.8	159.2	273	#4	TTC	TSC	○
2	24020H-004IS100	26	137	165	177.4	175.0	289	#4	TTC	TSC	○
2.5	24025H-004IS112	31	137	165	177.4	175.0	289	#4	TTC	TSC	○
3	24030H-004IS126	39	165	197	209.6	207.9	321	#4	TTC	TSC	○

* If using Structural Steel Holder with Notch Point®, GEN2 T-A®, or 150° Structural Steel T-A® Drill Insert Geometry.

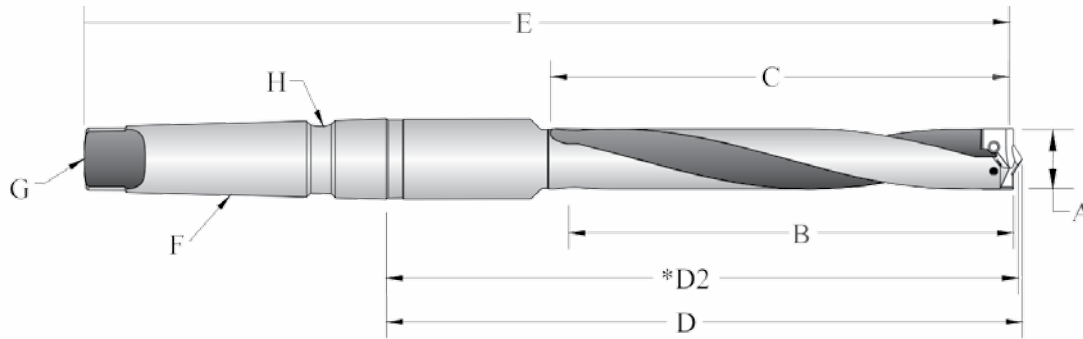
TTC = Through Tang Coolant
TSC = Through Shank Coolant

- ① Availability Codes
- Stocked
- ▲ Non-Stocked



Structural T-A[®] Drill Inserts

Extended and Long Length
Metric



EXTENDED LENGTH - Taper Shank Holder - Straight Flute

Series	Item Number	A	B	C	D	*D2	E	F	G	H	①
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
0.5	25005H-003IS044	17.5	165	240	248.8	243.7	338	#3	TTC	TSC	○
1	25010H-003IS045	18	165	237	247.3	241.3	336	#3	TTC	TSC	○
	25010H-003IS052	22	165	237	247.3	241.3	336	#3	TTC	TSC	○
	25010H-004IS052	22	165	236	247.3	245.7	360	#4	TTC	TSC	○
1.5	25015H-003IS060	24	165	237	247.3	234.5	336	#3	TTC	TSC	○
	25015H-004IS060	24	165	236	247.3	245.7	360	#4	TTC	TSC	○
2	22020H-003IS100	26	165	237	247.7	240.1	336	#3	TTC	TSC	○
	25020H-004IS100	26	165	234	247.7	245.7	360	#4	TTC	TSC	○



LONG LENGTH - Taper Shank Holder - Helical Flute

Series	Item Number	A	B	C	D	*D2	E	F	G	H	①
		Drill Dia. or Range	Max Drill Depth	Body Length	Ref. Length	Ref. Length	Overall Length	MT	Coolant Inlet Style		
1	26010H-004IS052	22	165	401	412.4	410.8	525	#4	TTC	TSC	○
1.5	26015H-004IS060	24	165	401	413.1	411.6	525	#4	TTC	TSC	○
2	26020H-004IS100	26	165	406	418.3	416.3	530	#4	TTC	TSC	○

* If using Structural Steel Holder with Notch Point[®] or 150° Structural Steel T-A[®] Drill Insert Geometry.

TTC = Through Tang Coolant
TSC = Through Shank Coolant

- ① Availability Codes
- Stocked
- ▲ Non-Stocked

Structural Steel T-A®

Recommended Speeds & Feeds
Inch



Super Cobalt Thin Wall Drill Insert

Material	Material Hardness (BHN)	-TW TiAlN Mist Coolant (SFM)	-TW AM200® Mist Coolant (SFM)	Feed (IPR)			
				9/16" to 11/16"	13/16" to 15/16"	1" to 1-3/8"	1-13/32" to 1-7/8"
Structural Steel A36, A285, A516, etc.	100 - 150	110	125	0.012	0.018	0.019	0.020
	150 - 250	100	115	0.011	0.016	0.017	0.019
	250 - 350	90	105	0.010	0.014	0.016	0.018

Super Cobalt Notch Point and 150° Degree Structural Steel Drill Insert

Material	Material Hardness (BHN)	-NP & -SS TiAlN Mist Coolant (SFM)	-NP & -SS AM200® Mist Coolant (SFM)	Feed (IPR)			
				9/16" to 11/16"	13/16" to 15/16"	1" to 1-3/8"	1-13/32" to 1-7/8"
Structural Steel A36, A285, A516, etc.	100 - 150	110	125	0.010	0.012	0.014	0.018
	150 - 250	100	115	0.009	0.011	0.012	0.016
	250 - 350	90	105	0.008	0.010	0.011	0.014

Super Cobalt GEN2 T-A® Drill Insert

Material	Material Hardness (BHN)	Mist Coolant (SFM)	Feed (IPR)			
			9/16" to 11/16"	13/16" to 15/16"	1" to 1-3/8"	1-13/32" to 1-7/8"
Structural Steel A36, A285, A516, etc.	100 - 150	125	0.010	0.012	0.014	0.018
	150 - 250	115	0.009	0.011	0.012	0.016
	250 - 350	105	0.008	0.010	0.011	0.014

C1 Carbide GEN2 T-A® Drill Insert

Material	Material Hardness (BHN)	AM200® Coolant (SFM)	Feed (IPR)			
			9/16" to 11/16"	13/16" to 15/16"	1" to 1-3/8"	1-13/32" to 1-7/8"
Structural Steel A36, A285, A516, etc.	100 - 150	165	0.008	0.011	0.015	0.017
	150 - 250	155	0.006	0.010	0.013	0.015
	250 - 350	140	0.005	0.009	0.012	0.013

Note: The above speed and feed recommendations are based on a rigid setup utilizing air mist through tool coolant. Speed may be increased up to 50% if using high pressure flood or through coolant.

Note: If drilling dry without coolant, speed must be reduced significantly based on setup, drill depth, and material hardness. Up to 50% speed and feed reduction may be necessary in these types of applications.

For technical assistance, call 800.321.5537
For international calls, call +1 330.343.4283



Structural Steel T-A®

Recommended Speeds & Feeds
Metric

Super Cobalt Thin Wall Drill Insert

Material	Material Hardness (BHN)	-TW TiAlN Mist Coolant (m/min)	-TW AM200® Mist Coolant (m/min)	Feed (mm/rev)			
				14mm to 16mm	18mm to 24mm	25mm to 35mm	36mm to 47mm
Structural Steel A36, A285, A516, etc.	100 - 150	34	39	0.30	0.45	0.48	0.50
	150 - 250	31	35	0.28	0.40	0.43	0.48
	250 - 350	28	32	0.25	0.36	0.40	0.45

Super Cobalt Notch Point and 150° Degree Structural Steel Drill Insert

Material	Material Hardness (BHN)	-NP & -SS TiAlN Mist Coolant (m/min)	-NP & -SS AM200® Mist Coolant (m/min)	Feed (mm/rev)			
				14mm to 16mm	18mm to 24mm	25mm to 35mm	36mm to 47mm
Structural Steel A36, A285, A516, etc.	100 - 150	34	39	0.25	0.30	0.36	0.45
	150 - 250	31	35	0.23	0.28	0.30	0.40
	250 - 350	28	32	0.20	0.25	0.28	0.36

Super Cobalt GEN2 T-A® Drill Insert

Material	Material Hardness (BHN)	AM200® Mist Coolant (m/min)	Feed (mm/rev)			
			14mm to 16mm	18mm to 24mm	25mm to 35mm	36mm to 47mm
Structural Steel A36, A285, A516, etc.	100 - 150	39	0.25	0.30	0.36	0.46
	150 - 250	35	0.23	0.28	0.30	0.40
	250 - 350	32	0.20	0.25	0.28	0.36

C1 Carbide GEN2 T-A® Drill Insert

Material	Material Hardness (BHN)	AM200® Mist Coolant (m/min)	Feed (mm/rev)			
			14mm to 16mm	18mm to 24mm	25mm to 35mm	36mm to 47mm
Structural Steel A36, A285, A516, etc.	100 - 150	50	0.20	0.28	0.38	0.43
	150 - 250	47	0.15	0.25	0.33	0.38
	250 - 350	43	0.13	0.23	0.30	0.33

Note: The above speed and feed recommendations are based on a rigid setup utilizing air mist through tool coolant. Speed may be increased up to 50% if using high pressure flood or through coolant.

Note: If drilling dry without coolant, speed must be reduced significantly based on setup, drill depth, and material hardness. Up to 50% speed and feed reduction may be necessary in these types of applications.

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Warranty



Allied Machine & Engineering Corp. warrants to original equipment manufacturers, distributors, industrial and commercial users of its products, that each new product manufactured or supplied by Allied Machine shall be free from defects in material and workmanship.

Allied's obligation under this warranty is limited to furnishing without additional charge a replacement or, at its option repairing or issuing credit for any product which shall within one year from the date of sale be returned freight prepaid to the plant designated by an Allied representative and which upon inspection is determined by Allied to be defective in materials or workmanship.

Complete information as to operating conditions, machine setup, and application of cutting fluid should accompany any product returned for inspection. The provisions of this warranty shall not apply to any Allied product which has been subjected to misuse, improper operating conditions, machine setup or application of cutting fluid or which has been repaired or altered if such repair or alteration in the judgement of Allied would adversely affect performance of the product.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Allied shall have no liability or responsibility on any claim of any kind, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of any product sold hereunder, in excess of the cost of replacement or repair as provided herein. IN NO EVENT SHALL ALLIED MACHINE & ENGINEERING CORP. BE LIABLE FOR ANY SPECIAL INCIDENTAL OR CONSEQUENTIAL DAMAGES. Allied makes no other warranty, express or implied, except as set forth above, and Allied neither assumes nor authorizes any other person or entity to assume for it any other obligation or liability in connection with any of its products.

ALL PRICES, DELIVERIES, DESIGNS, AND MATERIALS ARE SUBJECT TO CHANGE WITHOUT NOTICE.

WARNING
Cutting tools, tooling and metalworking machines may fail during use. Use safety glasses, appropriate safety equipment and exercise personal safety at all times while operating machinery.



Made in the U.S.A.



Allied Machine & Engineering Corp.

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Other Product Literature:

Allied Drilling Products DRILLS, HOLDERS, AND ACCESSORIES



Allied Drilling Products are designed and manufactured by Allied Machine & Engineering Corp. The combination of premium materials, along with unique geometry and coatings allows for the finest drilling systems in the metal cutting industry, resulting in the lowest cost per hole.

Literature Order Number: ADP

GEN3SYS® & GEN3SYS® XT HIGH PENETRATION DRILLING SYSTEM



The GEN3SYS® High Penetration Drilling System offers diameters from 12mm-32mm (0.4724"-1.2596"). GEN3SYS® XT offers a range from 11mm-35mm (0.4331"-1.378"). Standard GEN3SYS® holders will work for both GEN3SYS® and GEN3SYS® XT inserts. Holder offerings are lengths of 3xD, 5xD, and 7xD, as well as Stub length holders for the GEN3SYS® XT product line. Helical and Straight flutes available.

Literature Order Number: GEN3

AccuThread 856® THREAD MILLING PRODUCTS



AccuThread 856® specific Thread Mills conform with J1928 and SAE A55202. AccuThread 856® has a thicker core and a helical flute which offers increased strength and rigidity when cutting forces are applied. AccuThread 856® provides superior thread forms compared to other competitive thread mills and taps.

Literature Order Number: AT856

High Performance and Universal Style DRILLS, HOLDERS, AND ACCESSORIES



This catalog lists the widest variety of Spade Drills and Holders in our industry. Our TiN, TiAlN, and TiCN coated High Performance Spade Drills (31/32" to 5") offer a 100% to 500% increase in productivity and an extended tool life of 3 to 20 times over uncoated tools.

Literature Order Number: HPLU

ALVAN® Expandable Reamers



The ALVAN® product line includes both monobloc and ring style expandable reamers, offered with carbide, cermet, PCD and CBN cutting edges and are available in sizes from 0.228 inch to 7.858 inch (5.8 mm to 200.8 mm) diameters.

Literature Order Number: ALV

BT-A

REPLACEABLE TIP SINGLE TUBE BTA TOOL & ACCESSORIES



Allied's BT-A tool offers a bearing area for improved straightness, as well as more balanced cutting forces. This tool also provides significantly increased penetration rates over brazed heads and traditional gun drills. The BT-A's patent-pending design allows for replaceable cutting edges, eliminating the need for re-sharpening. This tool is compatible with standard BTA-STS Systems.

Literature Order Number: BTAFL

i-Form

CUSTOM INDEXABLE DRILL/FORM TOOL SYSTEM



With i-Form, you can design complex forms for any style hole with increased productivity in mind. The i-Form design (blade and form inserts) provides custom engineered forms that allow for complex design, replaceable cutting edges, and improved consistency while outperforming brazed and solid carbide tools.

Literature Order Number: IFFL



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