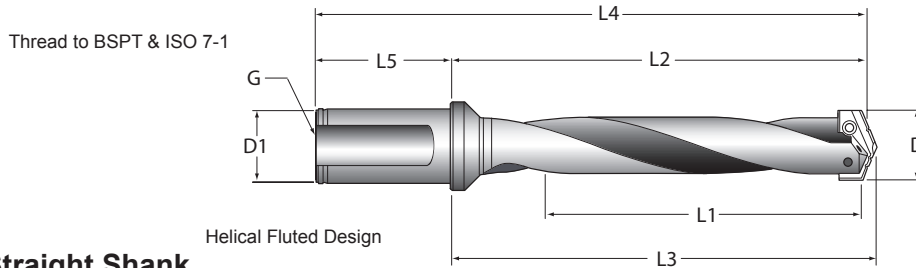


# 1 Series Holders

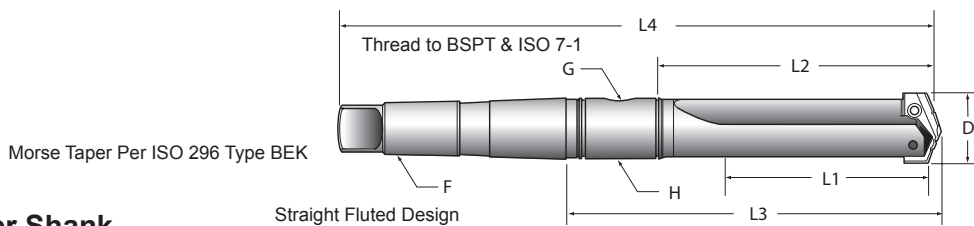


## Flanged Straight Shank

Available Ex-Stock

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

\*Note: Stub Length includes additional side coolant port.



## Taper Shank

Available Ex-Stock

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

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

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

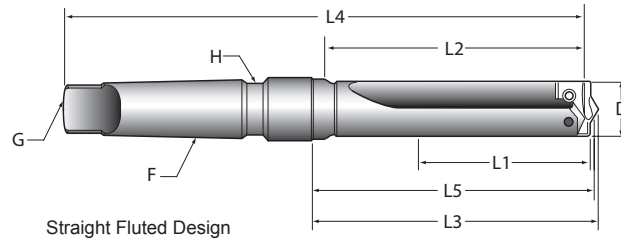
Visit [www.alliedmaxcut.com](http://www.alliedmaxcut.com) for the most up-to-date information and procedures.

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

For Holder Accessories please see pages 84 - 88.

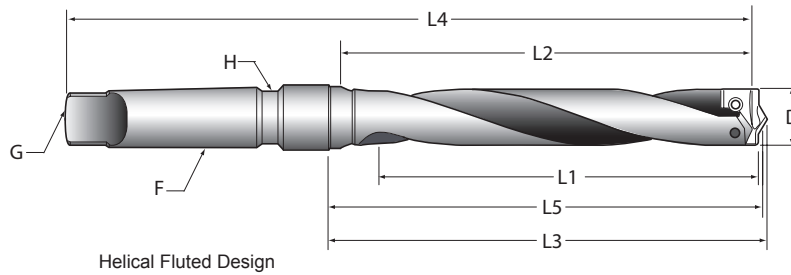


# 1 Series Structural Steel Holders



## Short Length – Taper Shank Holders – Straight Flute

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



## Standard Length – Taper Shank Holders – Helical Flute

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

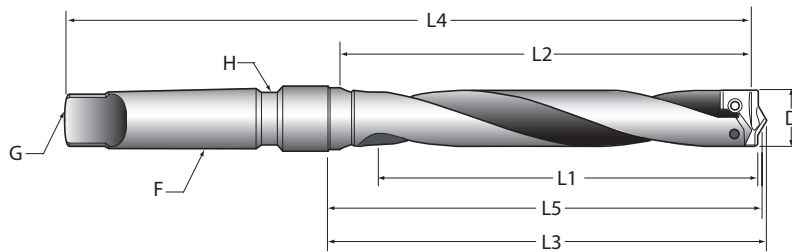
### Stk. - Stock Availability.

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

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

**For Holder Accessories please see pages 84 - 88.**

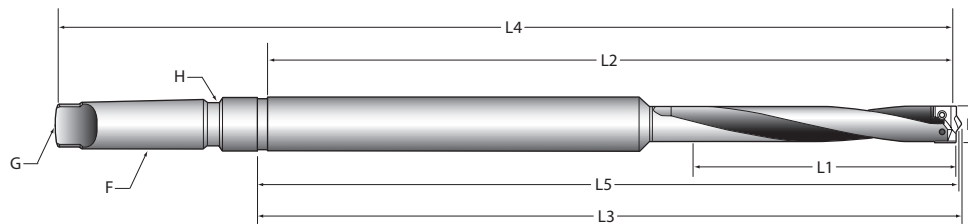
# 1 Series Structural Steel Holders



## Extended Length – Taper Shank Holders – Helical Flute

Part Number	D Min. Drill Dia. mm	L1 Max. Drill Depth. mm	L2 Body Length (mm)	L3 Ref Length mm	L5* Ref Length mm	L4 Overall Length mm	F MT	Coolant Inlet		Stk.
								G Through Tang Coolant	H Through Shank Coolant	
<span style="color: yellow;">⚠</span> 25010H-003IS052	22	165	237	247.3	241.3	336	3	TTC	TSC	○
<span style="color: yellow;">⚠</span> 25010H-004IS052	22	165	236	247.3	245.7	360	4	TTC	TSC	●
<span style="color: yellow;">⚠</span> 25015H-003IS060	24	165	237	247.3	240.5	360	3	TTC	TSC	○
<span style="color: yellow;">⚠</span> 25015H-004IS060	24	165	236	247.3	245.7	360	4	TTC	TSC	●

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



Helical Fluted Design

## Long Length – Taper Shank Holders – Helical Flute

Part Number	D Min. Drill Dia. mm	L1 Max. Drill Depth. mm	L2 Body Length (mm)	L3 Ref Length mm	L5* Ref Length mm	L4 Overall Length mm	F MT	Coolant Inlet		Stk.
								G Through Tang Coolant	H Through Shank Coolant	
<span style="color: yellow;">⚠</span> 26015H-004IS060	24	165	401	413.1	411.6	525	4	TTC	TSC	●

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

### Stk. - Stock Availability.

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

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

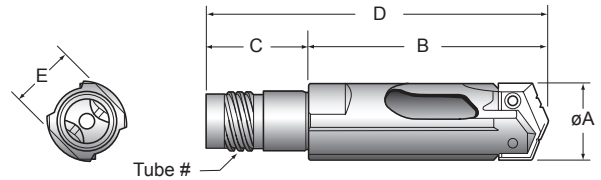
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For Holder Accessories please see pages 84 - 88.



# 1 Series BT-A Drill and Tubes

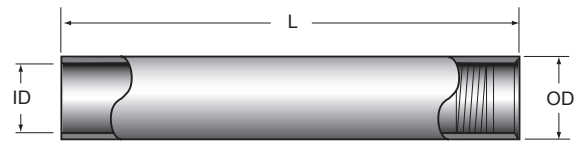


## Metric Heads

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

## Imperial Heads

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



## Metric Tubes

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

## Imperial Tubes

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



# 1 Series Inserts

Diameter Range 17.53 to 24.38mm



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

### Geometries available as non-stock standard

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

(see page 11 for details)

### Coatings available as non-stock standard

H - AM200®

(see page 10 for details)

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

Supplied in packs of 2

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

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

### Stk. - Stock Availability.

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

Any non-standard size available.



# 1 Series Inserts

Diameter Range 17.53 to 24.38mm

T-A & BENZ T-A

GENSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPort 432

Criterion

Thread Milling

Special Tooling



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

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

Supplied in packs of 2

### Geometries available as non-stock standard

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

### Coatings available as non-stock standard

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



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

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

Supplied in packs of 2

### Geometries available as non-stock standard

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

### Coatings available as non-stock standard

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



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# 1 Series Inserts

Diameter Range 17.53 to 24.38mm



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

### Geometries available as non-stock standard

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

### Coatings available as non-stock standard

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

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

Supplied in packs of 2



# 1 Series Inserts

Diameter Range 17.53 to 24.38mm



## Cast Iron

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

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

Supplied in packs of 2

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



## Tiny Chip

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

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

Supplied in packs of 2

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

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# 1 Series Inserts

Diameter Range 17.53 to 24.38mm



## 90° Spot & Chamfer

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

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

Supplied in packs of 2

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

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



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

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

Supplied in packs of 2

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

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

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

### Stk. - Stock Availability.

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

Any non-standard size available.



# 1 Series Inserts

Diameter Range 17.53 to 24.38mm



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

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

Supplied in packs of 2

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



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

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

Supplied in packs of 2

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



## Tube Sheet

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

Supplied in packs of 2

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

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

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

### Stk. - Stock Availability.

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

Any non-standard size available.

# 1 Series Inserts

Diameter Range 17.53 to 24.38mm



## Flat Bottom

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

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

Supplied in packs of 2

**Geometries available as non-stock standard**

- FN  
(see page 11 for details)

**Coatings available as non-stock standard**

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

**Grades available as non-stock standard**

K20 (C2)



## Diamond Coated

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

Supplied in packs of 1



# 1 Series Inserts

Diameter Range 17.53 to 24.38mm

## GEN2 T-A

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

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

Supplied in packs of 2

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

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

## GEN2 T-A

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

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

Supplied in packs of 2

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

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

T-A & GEN2 T-A  
GEN2SYS  
APX  
Revolution & Core Drill  
ASC 320 Solid Carbide  
AccuPort 432  
Criterion  
Thread Milling  
Special Tooling

# 1 Series Inserts

Diameter Range 17.53 to 24.38mm



**GEN2 T-A**

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

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

Supplied in packs of 2

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

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

**GEN2 T-A**

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

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

Supplied in packs of 2

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

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

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

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

**Stk. - Stock Availability.**

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

**Any non-standard size available.**