

2

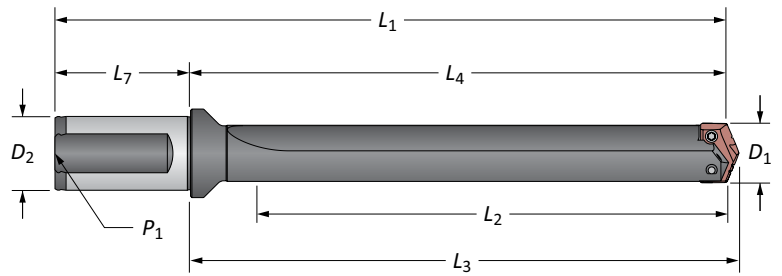
 DRILLING | T-A® Replaceable Insert Drilling System

T-A® Drill Insert Holders

2 Series | Flanged Shank

A

DRILLING

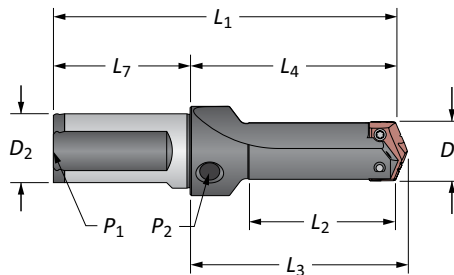



B

BORING



Stub Length



C

REAMING

Straight Flute

Series	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₄	L ₃	L ₁	D ₂	L ₇	P ₁	
2	Stub	25.0 - 35.0	57.2	88.5	92.1	148.5	32.0	60.0	1/4*	21020S-32FM
	Short	25.0 - 35.0	85.7	128.6	132.2	188.6	32.0	60.0	1/4*	22020S-32FM
	XL	25.0 - 35.0	511.0	554.1	557.7	614.1	32.0	60.0	1/4*	⚠ 27020S-32FM
	3XL	25.0 - 35.0	692.0	735.1	738.7	795.1	32.0	60.0	1/4*	⚠ 29020S-32FM
2.5	Stub	30.0 - 35.0	92.1	123.4	127.0	183.4	32.0	60.0	1/4*	21025S-32FM
	Short	30.0 - 35.0	85.7	128.6	132.2	188.6	32.0	60.0	1/4*	22025S-32FM
2	Stub	31/32 - 1-3/8	2-1/4	3-31/64	3-5/8	5-49/64	1-1/4	2-9/32	1/4	21020S-125F
	Short	31/32 - 1-3/8	3-5/8	5-1/16	5-13/64	7-11/32	1-1/4	2-9/32	1/4	22020S-125F
	Intermediate	31/32 - 1-3/8	5-3/8	7-1/16	7-13/64	9-11/32	1-1/4	2-9/32	1/4	23020S-125F
	Standard	31/32 - 1-3/8	7-3/8	9-1/16	9-13/64	11-11/32	1-1/4	2-9/32	1/4	24020S-125F
	Extended	31/32 - 1-3/8	11-3/8	13-1-16	13-13/64	15-11/32	1-1/4	2-9/32	1/4	⚠ 25020S-125F
2.5	Stub	1-3/16 - 1-3/8	3-5/8	4-55/64	5	7-9/64	1-1/4	2-9/32	1/4	21025S-125F
	Short	1-3/16 - 1-3/8	3-5/8	5-1/16	5-13/64	7-11/32	1-1/4	2-9/32	1/4	22025S-125F
	Intermediate	1-3/16 - 1-3/8	5-3/8	7-1/16	7-13/64	9-11/32	1-1/4	2-9/32	1/4	23025S-125F
	Standard	1-3/16 - 1-3/8	7-3/8	9-1/16	9-13/64	11-11/32	1-1/4	2-9/32	1/4	24025S-125F
	Extended	1-3/16 - 1-3/8	11-3/8	13-1-16	13-13/64	15-11/32	1-1/4	2-9/32	1/4	⚠ 25025S-125F

*Metric thread to BSP and ISO 7-1

NOTE: Stub length holders have a 1/8" side pipe tap (P₂)

D

BURNISHING

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 $\mu = 0.14$ and develop 90% of ultimate yield strength

E

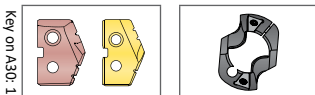
THREADING

X

SPECIALS

A30: 58 - 67

A30: 73 & 113



Ⓜ = Metric (mm)

Ⓢ = Imperial (in)

Screws sold in quantities of 10

⚠ WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A30: 148 for deep hole drilling guidelines in this section of the catalog. 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.

A30: 68

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