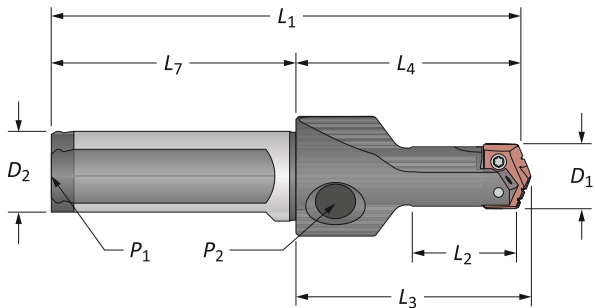
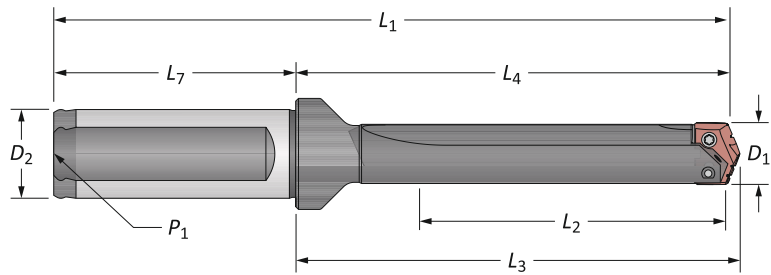




T-A Drill Insert Holders

1 Series | Flange Shank



Stub Length

Straight Flute

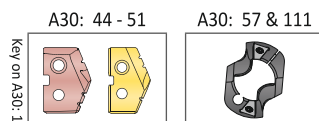
Series	Length	D ₁	Body				Shank			Part No.
			L ₂	L ₄	L ₃	L ₁	D ₂	L ₇	P ₁	
i	Stub	45/64 - 15/16	1-7/8	2-63/64	3-1/8	5-17/64	1	2-9/32	1/8	21010S-100F
	Short	45/64 - 15/16	2-5/8	4-7/32	4-23/64	6-1/2	1	2-9/32	1/8	22010S-100F
	Intermediate	45/64 - 15/16	4-5/8	6-3/32	6-15/64	8-3/8	1	2-9/32	1/8	23010S-100F
	Standard	45/64 - 15/16	6-5/8	8-3/32	8-15/64	10-3/8	1	2-9/32	1/8	24010S-100F
	Extended	45/64 - 15/16	10-5/8	12-3/32	12-15/64	14-3/8	1	2-9/32	1/8	▲ 25010S-100F
i	Stub	55/64 - 15/16	2-1/4	3-31/64	3-5/8	5-49/64	1	2-9/32	1/8	21015S-100F
	Short	55/64 - 15/16	2-5/8	4-7/32	4-23/64	6-1/2	1	2-9/32	1/8	22015S-100F
	Intermediate	55/64 - 15/16	4-5/8	6-3/32	6-15/64	8-3/8	1	2-9/32	1/8	23015S-100F
	Standard	55/64 - 15/16	6-5/8	8-3/32	8-15/64	10-3/8	1	2-9/32	1/8	24015S-100F
	Extended	55/64 - 15/16	10-5/8	12-3/32	12-15/64	14-3/8	1	2-9/32	1/8	▲ 25015S-100F
m	Stub	18.0 - 24.0	47.6	75.8	79.4	131.8	25.0	56.0	1/8*	21010S-25FM
	Short	18.0 - 24.0	66.7	107.2	110.7	163.2	25.0	56.0	1/8*	22010S-25FM
	XL	18.0 - 24.0	457.0	494.5	498.1	550.5	25.0	56.0	1/8*	▲ 27010S-25FM
	3XL	18.0 - 24.0	569.0	602.5	606.1	658.5	25.0	56.0	1/8*	▲ 29010S-25FM
	Stub	22.0 - 24.0	57.2	88.5	92.1	144.5	25.0	56.0	1/8*	21015S-25FM
	Short	22.0 - 24.0	66.7	107.2	110.7	163.2	25.0	56.0	1/8*	22015S-25FM

*Metric thread to BSP and ISO 7-1

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

Connection Accessories

Series	Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
1	7375-IP9-1	7375N-IP9-1	8IP-9	8IP-9TL	8IP-9B	27.0 in-lbs (305 N-cm)
1.5	739-IP9-1	739N-IP9-1	8IP-9	8IP-9TL	8IP-9B	27.0 in-lbs (305 N-cm)

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

i = Imperial (in)

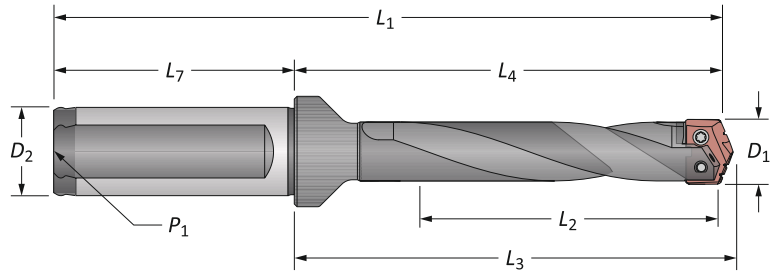
m = Metric (mm)

Screws sold in quantities of 10









WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A30: 146 for deep hole drilling guidelines in this section of the catalog. Visit www.alliedmachine.com/DeepHoleGuidelines for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.

T-A Drill Insert Holders

1 Series | Flange Shank


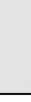
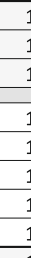









Helical Flute

Series	Length	D ₁	Body				Shank			Part No.	
			L ₂	L ₄	L ₃	L ₁	D ₂	L ₇	P ₁		
i	1	Intermediate	45/64 - 15/16	4-5/8	6-3/32	6-15/64	8-3/8	1	2-9/32	1/8	23010H-100F
	Standard	45/64 - 15/16	6-5/8	8-3/32	8-15/64	10-3/8	1	2-9/32	1/8	24010H-100F	
	Standard Plus	45/64 - 15/16	8-5/8	10-3/32	10-15/64	12-33/64	1	2-9/32	1/8	 24510H-100F	
	Extended	45/64 - 15/16	10-5/8	12-3/32	12-15/64	14-3/8	1	2-9/32	1/8	 25010H-100F	
	Long	45/64 - 15/16	14-3/8	15-27/32	15-63/64	18-17/64	1	2-9/32	1/8	 26010H-100F	
1.5	Intermediate	55/64 - 15/16	4-5/8	6-3/32	6-15/64	8-3/8	1	2-9/32	1/8	23015H-100F	
	Standard	55/64 - 15/16	6-5/8	8-3/32	8-15/64	10-3/8	1	2-9/32	1/8	24015H-100F	
	Extended	55/64 - 15/16	10-5/8	12-3/32	12-15/64	14-3/8	1	2-9/32	1/8	 25015H-100F	
m	1	Intermediate	18.0 - 24.0	117.5	154.8	158.4	210.8	25.0	56.0	1/8*	23010H-25FM
	Standard	18.0 - 24.0	168.3	205.6	209.2	261.6	25.0	56.0	1/8*	24010H-25FM	
	Standard Plus	18.0 - 24.0	219.0	256.3	259.9	312.3	25.0	56.0	1/8*	 24510H-25FM	
	Extended	18.0 - 24.0	269.9	307.2	310.8	363.2	25.0	56.0	1/8*	 25010H-25FM	
	Long	18.0 - 24.0	365.0	402.3	405.9	458.3	25.0	56.0	1/8*	 26010H-25FM	
	1.5	Intermediate	22.0 - 24.0	117.5	154.8	158.4	210.8	25.0	56.0	1/8*	23015H-25FM
		Standard	22.0 - 24.0	168.3	205.6	209.2	261.6	25.0	56.0	1/8*	24015H-25FM
Extended		22.0 - 24.0	269.9	307.2	310.8	363.2	25.0	56.0	1/8*	 25015H-25FM	

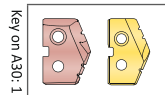
*Metric thread to BSP and ISO 7-1

Connection Accessories

Series	Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
1	 7375-IP9-1	 7375N-IP9-1	 8IP-9	 8IP-9TL	 8IP-9B	27.0 in-lbs (305 N-cm)
1.5	 739-IP9-1	 739N-IP9-1	 8IP-9	 8IP-9TL	 8IP-9B	27.0 in-lbs (305 N-cm)

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

A30: 44 - 51



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

Screws sold in quantities of 10

WARNING Refer to Speed and Feed charts for recommended adjustments to speeds and feeds. Refer to page A30: 146 for deep hole drilling guidelines in this section of the catalog. Visit www.alliedmachine.com/DeepHoleGuidelines for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.