



# ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing



Boring



Reaming



Burnishing



Threading



Specials



## AccuPort 432<sup>®</sup>

► *PORTING*

Hydraulic Port Contour Cutters

## North America

**Allied Machine**  
120 Deeds Drive  
Dover, OH 44622  
United States

**Allied Machine**  
485 West 3rd Street  
Dover, OH 44622  
United States

### ThreadMills USA™

4185 Crosstowne Ct #B  
Evans, GA 30809  
United States

### Superior®

1285 S Patton St.  
Xenia, OH 45385  
United States

## Europe

**Allied Machine Europe**  
93 Vantage Point  
Pensnett Estate  
Kingswinford  
West Midlands  
DY6 7FR, United Kingdom

### Wohlhaupter™ GmbH

Maybachstrasse 4  
Postfach 1264  
72636 Frickenhausen  
Germany

## Asia

**Wohlhaupter™ India**  
B-23, 2nd Floor  
B Block Community Centre  
Janakpuri, New Delhi - 110058  
India



Allied Machine & Engineering is a worldwide leader in holemaking and finishing solutions. We are committed to providing practical and dependable solutions to our customers through innovative designs and superior customer and technical support.

We continue to expand our product offering in order to provide new and different solutions. With Field Sales Engineers located around the world, we position ourselves to provide technical support on site, right at your spindle.



[www.alliedmachine.com](http://www.alliedmachine.com)



# ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing

## AccuPort 432®

### The Foundation

Since 1941, Allied Machine & Engineering has provided dependable and practical holemaking solutions to the world. What was once a small job shop in Ohio is now a worldwide leader in cutting tool technology. With three manufacturing facilities in Ohio, one in Georgia, another in Germany, and headquarters in both the United States and Europe, Allied Machine is positioned to bring innovative solutions and technical expertise directly to the customers' hands.



### The Beginning

Harold E. Stokey founded Allied Machine & Engineering to aid the war effort, manufacturing taper bearing lock nuts for the production of M1 tanks. Years later, after a sales meeting gone wrong, Stokey possessed a warehouse stocked with spade drill inserts. He set forth into the industry that would become Allied Machine's thriving identity: holemaking.



### The T-A®

When Harold's son, William H. Stokey, became the president and CEO, he developed the Throw Away, or T-A, spade drill insert system. The T-A revolutionized the holemaking industry, launching Allied Machine ahead of the competition. Since then, numerous innovations and advancements have been created from the T-A's inspiration.



### The Innovation

Since the development of the T-A, Allied Machine has expanded its product offering to support a vast range of customer applications, including large diameter and deep hole drilling, boring, reaming, burnishing, porting, and threading.

### The People

Allied Machine understands that high quality products are only one facet of success. Our customer support is crucial to what we do, and that's why we make sure the best engineers and customer service associates are in place to assist our customers around the world.

### The Future

With over 75 years of experience, Allied Machine has encountered the challenges of growth and success. By investing in cutting edge technology and the brightest and sharpest minds, our knowledge and capabilities continue to expand and grow every day.



**Steve Stokey**  
Executive Vice President

**William H. Stokey**  
President and CEO

**Mike Stokey**  
Executive Vice President



## Replaceable Insert Drills

- Reduce costs by decreasing setup time and utilizing a single holder for the lives of multiple inserts
- Provide flexibility to quickly switch between inserts with different geometries
- Products:
  - GEN3SYS® XT | GEN3SYS® XT Pro
  - T-A® | T-A® GEN2
  - High Performance | Universal



## Indexable Insert Drills

- Protect your investment and reduce your inventory with replaceable cartridges that allow the same holder to be used repeatedly
- Indexable inserts increase productivity and tool life while reducing costs
- Products:
  - 4TEX® Drill
  - Revolution Drill®
  - Opening Drill®



## Replaceable / Indexable Insert Drills

- Drill large diameter holes and maximize penetration rates even on low horsepower machines
- Delivers strength and versatility needed for any deep hole drilling application
- Holders cover a range of sizes with the replaceable heads determining the cutting diameter
- Products:
  - APX™ Drill



## Solid Carbide Drills

- Offer greater strength and stability when drilling tougher materials
- Available in diameters from 3mm - 20mm
- Can be made-to-order specifically for your application (Superion® quoted specials)
  - ASC 320®
  - Superion®



## Structural Steel Solutions

- Deliver outstanding performance and durability in structural steel applications
- Designed to produce optimal results in difficult-to-machine materials
- Available in multiple lengths and diameters
- T-A® style drills have different insert geometry options to improve performance, depending on material
- Products:
  - T-A® | T-A® GEN2
  - GEN3SYS® XT Pro



## BTA (STS) Machining Solutions

- The internal ejection system flushes chips and debris from the hole with no interference to the cutting process
- Utilizes the advantages of the T-A® drill insert
- Designed to significantly increase penetration rates over brazed heads and traditional gun drills
- Products:
  - BT-A Drill



## Hydraulic Port Contour Cutters

- Save significant time and money by performing four processes in one step
- Replaceable insert design reduces costs, inventory, and setup times
- Available in four industry specifications:
  - Imperial: SAE J-1926
  - Metric: ISO 6149-1:2006
  - Military: SAE AS5202
  - John Deere: JDS-G173.1
- Products:
  - AccuPort 432®



## Enhanced Special Drilling Capabilities

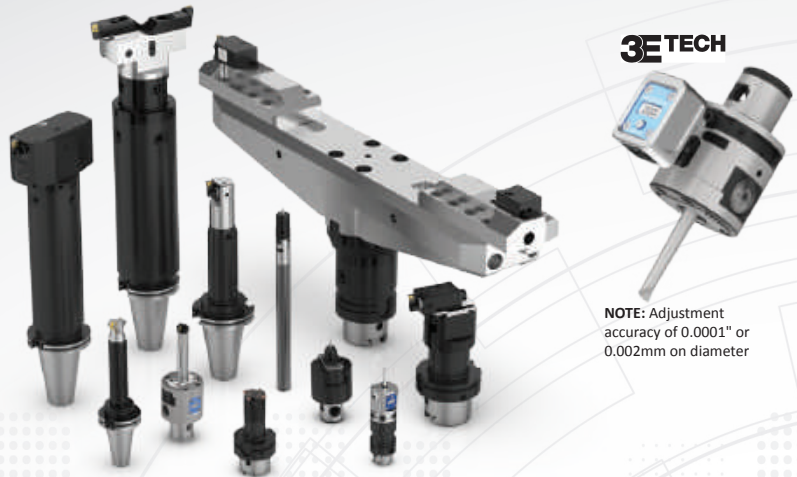
- Allied Machine engineers are available to meet with you to evaluate your application and recommend the best solution for you
- Special drilling solutions can incorporate advanced features such as adjustable diameter locations, multiple steps, additional coolant designs, special lengths and diameters, and more
- Special drills can drastically reduce your cost per hole and increase your overall productivity by eliminating multiple processes and increasing tool life



# WOHLHAUPTER®

## High Precision Boring Systems

- Designs available for high volume applications that increase rigidity to improve performance
- Versatile boring heads that are flexible with changing applications while maintaining excellent performance
- Provides high precision with absolute repeatability to ensure every part is held to tolerance
- Offers an industry leading modular shank connection that maintains rigidity and reduces inventory on your boring system
- Available with both digital and analog settings
- Products:
  - Wohlhaupter™ Boring Tools



NOTE: Adjustment accuracy of 0.0001" or 0.002mm on diameter



# CRITERION®

## Modular Boring Systems

- The modular capabilities are ideal for use across multiple different projects
- Offers versatile boring heads suitable for job shops and tooling rooms
- Provides an economical solution for low volume and/or short-term production applications
- Offers finish boring solutions
- Products:
  - Criterion® Boring Tools

# S.C.A.M.I.®

## Expandable Reaming Solutions

- Expandable cutting diameters accommodate for wear, which extends tool life
- Replaceable cutting heads and rings reduce waste and improve production time versus solid high speed steel and carbide reamers
- Holds tight tolerances to ensure processes are performed to accurate specifications
- Reduces tooling costs because many items are available for reconditioning
- Products:
  - ALVAN® Reamers



# S.C.A.M.I.®

## Roller Burnishing Solutions

- Produce excellent surface finishes
- Provide accurate size control
- Increase surface hardness
- Solutions for both through hole and blind hole applications
- Products:
  - S.C.A.M.I.® Roller Burnishing Tools





## Solid Carbide Thread Mills

- Available with coolant through options
- Covers a wide range of thread forms
- Provides optimal solutions for both high production projects and short-run applications
- Products
  - AccuThread™ 856
  - AccuThread™ T3
  - ThreadMills USA™



## Replaceable Insert Thread Mills

- Three insert lengths are available that cover a wide range of thread forms
- Holders can utilize inserts with different pitches and thread forms
- Repeatability is achieved by both the bolt-in style and the pin style locking systems
- Increases tool life by 25 - 50% with Allied Machine's AM210® coating
- Products
  - AccuThread™ 856: Bolt-in Style
  - AccuThread™ 856: Pin Style



## SPECIAL CAPABILITIES


When it comes to designing and developing special solutions for customers, Allied Machine is the top choice. If your application requires special tooling, give us a call. Our engineered specials are developed by the brightest engineers in the industry. Most of our standard tooling can be altered as specials, or we can create entirely new concepts for particularly unique applications.

One special tooling solution is Insta-Quote®, the online system that allows you to design your own special tooling 24/7. Receive a quote and drawings within minutes just by following the steps.

And with the addition of Superior® technology and capabilities, we can customize made-to-order solid carbide tools to achieve optimal results for your applications.

Whatever your application, Allied Machine has the answer.



Insta-Quote® 



 SUPERION®





**Increase the production and success of your applications today.**

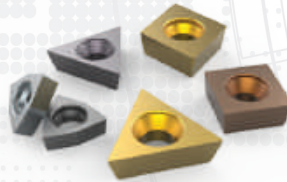
- Direct access to 2D drawings and 3D models
- Assemble and view tool images in your browser
- Download drawings for use in most machining software programs
- Browse products, search item numbers, and save assemblies for future use

[toolmd.com](http://toolmd.com)

## WOHLHAUPTER® Boring Insert Selector

**Find the best insert for your application.**

- Generate the correct boring insert for your job in just six easy steps
- Choose type, shape, substrate, insert form, nose radius, and material
- Order easily by adding the item to your cart



[alliedmachine.com/bis](http://alliedmachine.com/bis)

## Product Selector

**Use the product selector to find the right tool for your application.**

- Follow guided steps to generate the right tool for your application
- Learn about your recommended tool and how to maximize its performance



[alliedmachine.com/productselector](http://alliedmachine.com/productselector)



# Insta-Code®

**Eliminate the wait. Get your program now.**

- Choose the best thread mill for your application
- Create program code for your machine
- Available as a PC download app (that can be used offline)
- Website app available 24/7



Insta-Code also has a  
**Cycle Time Calculator**

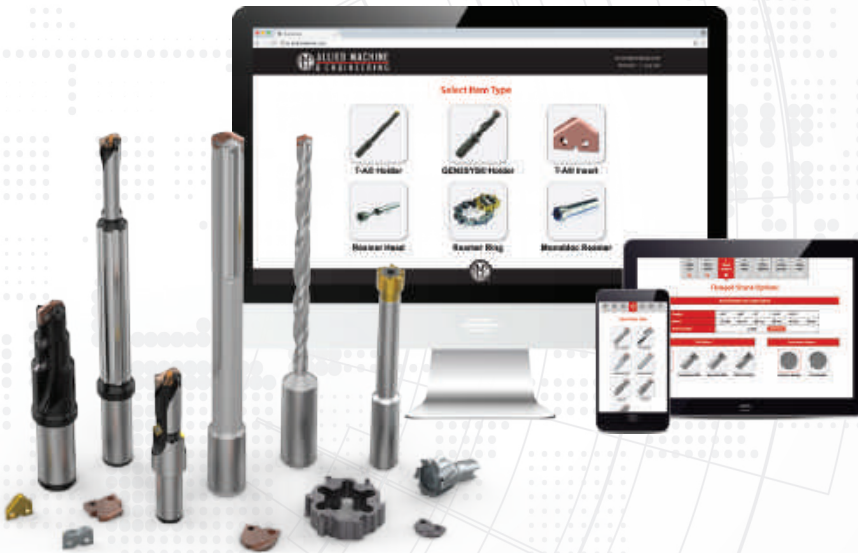
[alliedmachine.com/InstaCode](http://alliedmachine.com/InstaCode)

# Insta-Quote®

**Design your custom tooling and receive a drawing and quote...all within minutes.**

- Design and quote your own tooling
- Generate the solution you need in just a few steps
- Features the following products

- T-A® Inserts
- T-A® Holders
- GEN3SYS® XT Holders
- ALVAN® Reamers



[iq.alliedmachine.com](http://iq.alliedmachine.com)

## Solution Hub App

**All Allied all the time.**

- Quickly look up product information
- Links to our free online tools
- Locate distributors
- Stay up to date on news and events



## Machinist Tool App

**Quickly convert cutting tool parameters for the machine inputs you need.**

- Input data to calculate the RPM and speed and feed rates
- Also features the Boring Insert Selector
- Access product literature right at your fingertips



# AccuPort 432®

Replaceable Insert Port Contour Cutters | J1926 | ISO6149 | AS5202 | JDG173.1



## High Performance Multi-Step Action

Durable and precise, the AccuPort 432 holders provide a strong and rigid platform for the drilling of hydraulic ports. The precision ground insert location on each holder ensures total repeatability and simple, uncomplicated changing of the replaceable inserts.

With the AccuPort technology, you can drill and finish port forms in **ONE** operation. Save time and money with AccuPort.

Single operation hydraulic port cutting system	No pre-drilling required	Replaceable inserts eliminate regrinding and resetting
------------------------------------------------	--------------------------	--------------------------------------------------------

## Applicable Industries



Aerospace



Agriculture



Automotive



Marine /  
Shipbuilding

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

### **WARNING**

**WARNING** (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

**NOTICE** means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

**NOTE** and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

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

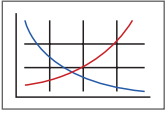
**Reference Icons**

The following icons will appear throughout the catalog to help you navigate between products.



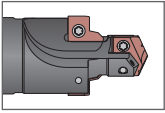
**Setup / Assembly Information**

Detailed instructions and information regarding the corresponding part(s)



**Recommended Cutting Data**

Speed and feed recommendations for optimum and safe drilling



**Accuport 432 Holders**

Refers to the full details of the holder items included in each kit



**Port and Thread Finishing Kits**

Lists the available kits complete with AccuPort tool and AccuThread™ solid carbide thread mill

**Introduction Information**

Product Overview . . . . . 2 - 4  
 Product Nomenclature . . . . . 5

**Port Specifications**

SAE J-1926 / ISO 11926-1 / MS-16142 . . . . . 6 - 11  
 ISO 6149-1:2006 / SAE J-2244/1 . . . . . 12 - 13  
 SAE AS5202 / AND10050 . . . . . 14 - 15  
 JDS-G173.1 . . . . . 16 - 17

**Port and Thread Finishing Kits**

SAE J-1926 / ISO 11926-1 / MS-16142 . . . . . 18 - 21  
 ISO 6149-1:2006 / SAE J-2244/1 . . . . . 22 - 25  
 SAE AS5202 / AND10050 . . . . . 26 - 27  
 JDS-G173.1 . . . . . 28

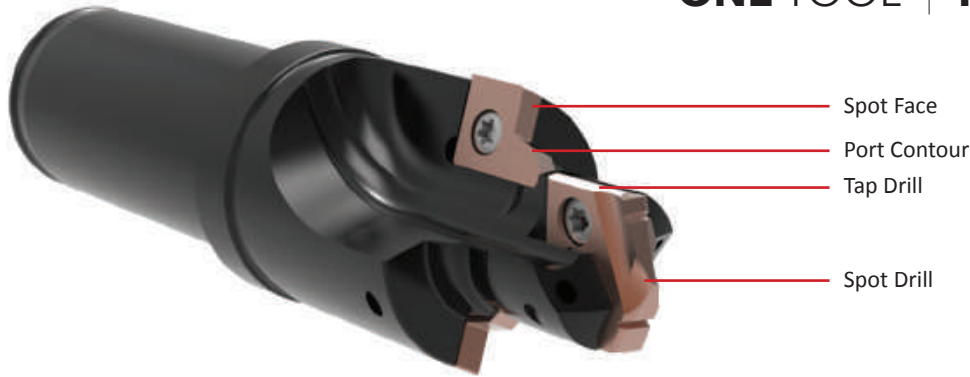
**Recommended Cutting Data (Imperial)**

Imperial (inch)	[	HSS . . . . . 30 - 31
		Carbide . . . . . 32 - 33
Metric (mm)	[	HSS . . . . . 34 - 35
		Carbide . . . . . 36 - 37

**Product Overview**

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

**ONE TOOL | FOUR OPERATIONS**


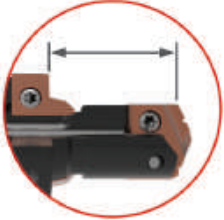








**Advanced Solutions, Outstanding Results**

As designers and manufacturing engineers push the limits of production technology to improve productivity and performance, Allied Machine has continued to innovate and develop new solutions like the unique AccuPort 432 hydraulic port contour cutter system. Every product in the AccuPort system is designed to deliver maximum performance in a diverse range of hydraulic port cutting applications and demanding manufacturing environments.

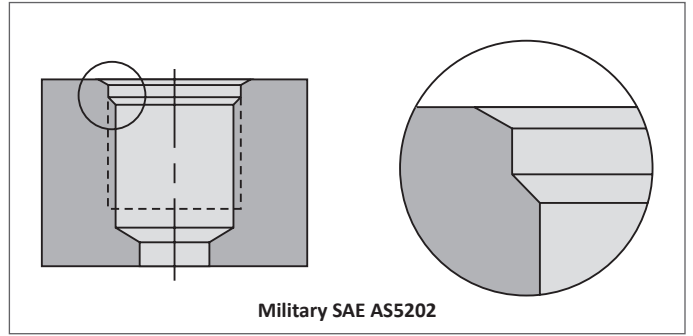
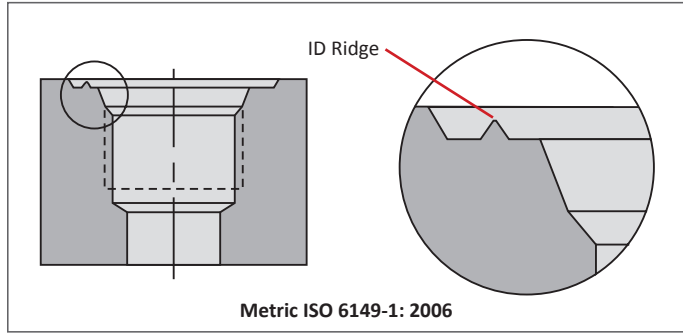
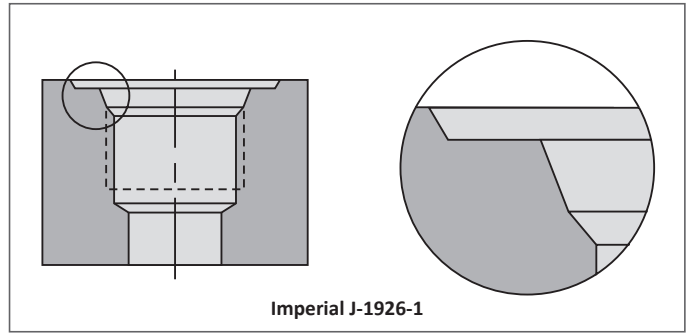
Using precision replaceable inserts for both the drilling and port forming operations, AccuPort eliminates the need for tool regrinding and enables absolute repeatability, excellent surface finish, and reduced cost-per-hole. The AccuPort drills, forms, and precision-finishes the hydraulic port in **one** pass. This replaces up to three separate cutting operations in a single tool to deliver outstanding improvements in productivity, accuracy, and repeatability.

Hydraulic systems are present in an incredibly diverse range of industries. Anywhere a hydraulic port is required, AccuPort can provide a more cost effective and higher performance solution in a fraction of the time taken for traditional methods using separate drills, special forming tools, and spot facers.

Port Specification	Notes
<p><b>Imperial</b> SAE J-1926 ISO 11926-1 MS-16142</p> 	<p>Extended minor diameter length option also available</p> 
<p><b>Metric</b> ISO 6149-1:2006 SAE J-2244/1</p> 	<p>Holders made with ID ridge Utilizes inserts with or without ID ridge</p>  ID ridge  No ID ridge 
<p><b>Military</b> SAE AS5202</p> 	<p>Also conforms to AND10050 specification by using an alternate tap drill size for a UN thread</p>
<p><b>John Deere</b> JDS-G173.1</p> 	<p>Adheres to John Deere port standards</p>

### Choosing the Right System

Every product in the AccuPort 432 product line is designed to deliver maximum performance in a diverse range of hydraulic port cutting applications and demanding manufacturing environments. The innovative design delivers the best possible range of benefits in terms of productivity, cost-per-hole, and tool life.



### Common Industry Sectors and Components



**Aerospace**  
Pumps  
Landing Gear  
Brake Cylinders  
Manifolds



**Agriculture**  
Pumps  
Manifolds  
Cylinders and Rams  
Gear Pumps



**Automotive**  
Motor Valves  
Relief Valves  
Brake Cylinders  
Power Steering Pumps



**Marine / Shipbuilding**  
Pumps  
Cylinders and Rams  
Motors  
Manifolds

### The Complete Package





Producing fully finished threaded hydraulic ports has never been easier. The Port and Thread Finishing Kit includes the AccuPort 432 contour cutter with a dedicated AccuThread™ solid carbide threadmill in a single kit. You also receive the T-A® inserts and port form inserts needed to complete the assembly.

Port kits incorporate the AccuThread solid carbide threadmills to increase the manufacturing flexibility by allowing hydraulic ports to be produced in just two operations. In addition, where a unique port profile is required, Allied Machine provides a dedicated special tooling solution using our extensive tool design and manufacturing experience to meet precise specifications.



## Replaceable Inserts Overview

T-A® Drill Insert Grades			
<b>HSS Super Cobalt</b> (Original T-A® / GEN2 T-A®)	<b>Carbide C5 (P40)</b> (Original T-A® only)	<b>Carbide C1 (K10)</b> (GEN2 T-A® only)	<b>Carbide C3 (K35)</b> (Original T-A® only)
Suited for good to rigid machining applications, used for drilling exotic and high alloy materials, or general use when surface speed needs to be increased for use in material hardness up to 350 BHN 121kg.	Excellent for drilling free machining steel, low/medium carbon steels, alloy steels, high strength steels, tool steels, and hardened steels.	Excellent for drilling free machining steel, low/medium carbon steels, alloy steels, high strength steels, tool steels, and hardened steels.	Designed for drilling grey/white cast irons. The special geometry offers substantial increases in penetration rates and provides exceptional edge strength and tool life.

Port Form Inserts	GEN2 T-A Inserts		Original T-A Inserts
 AM200®      TiAlN	 AM300®	 AM200®	 TiN

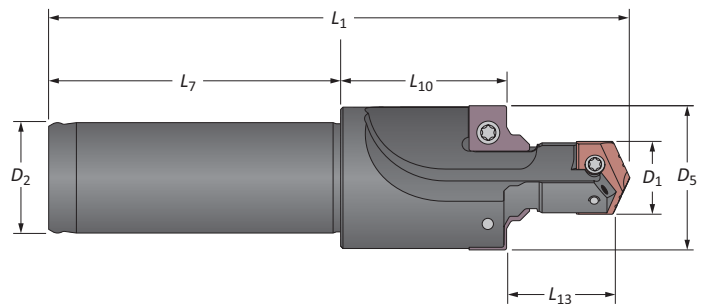
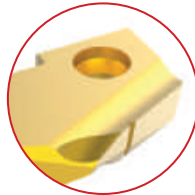
### GEN2 T-A Standard Geometry

- Designed for rigid machining applications, primarily used for drilling exotic and high alloy materials
- Ideal for general use when the surface speed needs to be increased



### Original T-A Standard Geometry

- First choice for machining aluminum
- Enhanced geometry improves chip formation and hole quality
- TiN coating improves heat resistance and extends tool life



### Made-to-Order Tool Specifications

Scan and email a copy of the table below to Allied's Application Engineering Department to receive pricing for a made-to-order AccuPort 432 Port Contour Cutter.

Send emails to [appeng@alliedmachine.com](mailto:appeng@alliedmachine.com)

Tube Dash No.	Specification	Port Thread Size	D <sub>1</sub>	L <sub>13</sub>	D <sub>5</sub>	L <sub>10</sub>	L <sub>1</sub>	D <sub>2</sub>	L <sub>7</sub>
	<input type="checkbox"/> J1926 <input type="checkbox"/> ISO 6149 <input type="checkbox"/> ISO 6149 (no ridge) <input type="checkbox"/> JDS-G173.1 <input type="checkbox"/> AS5202								

<b>Company Name</b> <input type="text"/>	<b>Contact Name</b> <input type="text"/>	<b>Phone</b> <input type="text"/>
<b>Distributor Name</b> <input type="text"/>	<b>Fax</b> <input type="text"/>	

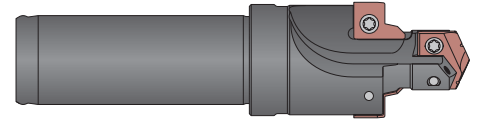
A DRILLING  
 B BORING  
 C REAMING  
 D BURNISHING  
 E THREADING  
 X SPECIALS



## Product Nomenclature

### AccuPort 432 Holders

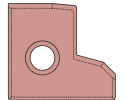
<b>J1926</b>	-	<b>04</b>		<b>Y</b>	-	<b>063F</b>
1		2		3		4



1. Port Specifications	2. Port Tube Dash No.	3. T-A® Insert Series	4. Shank Configuration												
<b>J1926</b> = Imperial - J1926-1 <b>X1926</b> = Imperial - J1926-1 (extended minor length) <b>I6149</b> = Metric (ISO) - 6149-1 <b>G1731</b> = John Deere - G173.1 <b>AS5202</b> = Military - AS5202	<b>04</b> <b>14</b> <b>05</b> <b>16</b> <b>06</b> <b>18</b> <b>08</b> <b>20</b> <b>10</b> <b>24</b> <b>12</b> <b>32</b>	<b>Y</b> = Y series <b>Z</b> = Z series <b>0</b> = 0 series <b>1</b> = 1 series <b>2</b> = 2 series <b>3</b> = 3 series <b>4</b> = 4 series	<table border="1"> <thead> <tr> <th>Imperial</th> <th>Metric</th> </tr> </thead> <tbody> <tr> <td><b>063F</b> = 5/8" flanged</td> <td><b>16FM</b> = 16mm flanged</td> </tr> <tr> <td><b>075F</b> = 3/4" flanged</td> <td><b>20FM</b> = 20mm flanged</td> </tr> <tr> <td><b>100F</b> = 1" flanged</td> <td><b>25FM</b> = 25mm flanged</td> </tr> <tr> <td><b>125F</b> = 1-1/4" flanged</td> <td><b>32FM</b> = 32mm flanged</td> </tr> <tr> <td><b>150F</b> = 1-1/2" flanged</td> <td></td> </tr> </tbody> </table>	Imperial	Metric	<b>063F</b> = 5/8" flanged	<b>16FM</b> = 16mm flanged	<b>075F</b> = 3/4" flanged	<b>20FM</b> = 20mm flanged	<b>100F</b> = 1" flanged	<b>25FM</b> = 25mm flanged	<b>125F</b> = 1-1/4" flanged	<b>32FM</b> = 32mm flanged	<b>150F</b> = 1-1/2" flanged	
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<b>150F</b> = 1-1/2" flanged															

### AccuPort 432 Port Form Inserts

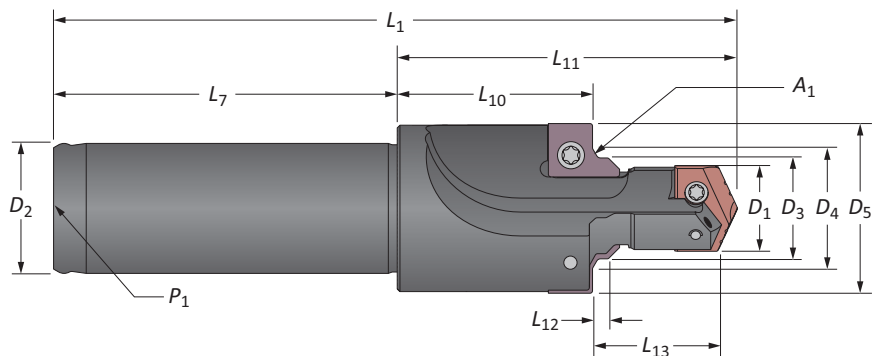
<b>J1926</b>	-	<b>02</b>		<b>R</b>	-	<b>C5</b>		<b>A</b>
1		2		3		4		5



1. Port Specifications	2. Insert Size	3. Port Specifications	4. Substrate	5. Coating
<b>J1926</b> = Imperial <b>I6149</b> = Metric (ISO) <b>G1731</b> = John Deere <b>AS5202</b> = Military	<b>02</b> <b>10</b> <b>03</b> <b>11</b> <b>04</b> <b>12</b> <b>05</b> <b>14</b> <b>06</b> <b>16</b> <b>07</b> <b>20</b> <b>08</b> <b>24</b> <b>09</b> <b>32</b>	<b>Blank</b> = No ID ridge <b>R</b> = ID ridge	<b>C5</b> = C5 carbide <b>C3</b> = C3 carbide	<b>A</b> = TiAlN <b>H</b> = AM200®

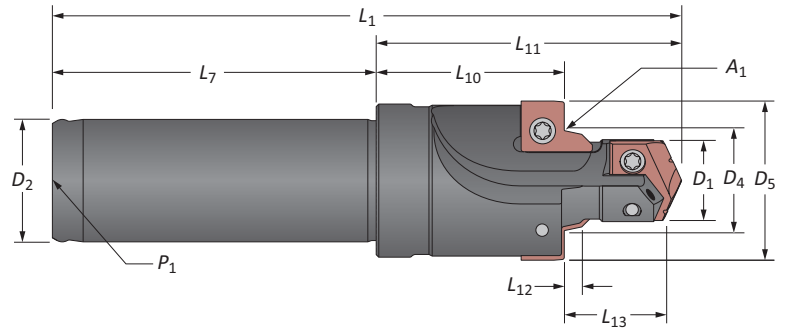
### Reference Key

Symbol	Attribute
$A_1$	Seal angle
$D_1$	Minor diameter
$D_2$	Shank diameter
$D_3$	Pilot diameter
$D_4$	Seal angle diameter
$D_5$	Spot face diameter
$L_1$	Overall length
$L_7$	Shank length
$L_{10}$	Spot face to shoulder length
$L_{11}$	Total head length
$L_{12}$	Seal angle length
$L_{13}$	Minor diameter length
$P_1$	Rear pipe tap



## SAE J-1926 / ISO 11926-1 / MS-16142

### Imperial Shank Holders



Tube Dash No.	Cutting			Seal Angle			Holder			Shank			Port Thread Size	Part No.
	D <sub>1</sub>	L <sub>13</sub> *	D <sub>5</sub>	A <sub>1</sub>	D <sub>4</sub>	L <sub>12</sub>	L <sub>11</sub>	L <sub>10</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	P <sub>1</sub>		
-4	0.386	0.551	0.840	12°	0.490	0.106	1.527	0.896	3.402	1.875	0.625	1/16	7/16-20 UNF-2B	J1926-04Y-063F
-5	0.453	0.551	0.926	12°	0.553	0.106	1.527	0.885	3.402	1.875	0.625	1/16	1/2-20 UNF-2B	J1926-05Z-063F
-6	0.512	0.610	0.989	12°	0.618	0.106	1.857	1.144	3.826	1.969	0.750	1/8	9/16-18 UNF-2B	J1926-060-075F
-8	0.689	0.689	1.206	15°	0.813	0.106	1.982	1.150	3.951	1.969	0.750	1/8	3/4-16 UNF-2B	J1926-080-075F
-10	0.807	0.787	1.344	15°	0.945	0.106	2.140	1.185	4.421	2.281	1.000	1/8	7/8-14 UNF-2B	J1926-101-100F
<b>i</b> -12	0.984	0.906	1.655	15°	1.150	0.138	2.640	1.530	4.921	2.281	1.250	1/4	1 1/16-12 UN-2B	J1926-122-125F
-14	1.102	0.906	1.781	15°	1.276	0.138	2.640	1.504	4.921	2.281	1.250	1/4	1 3/16-12 UN-2B	J1926-142-125F
-16	1.231	0.906	1.934	15°	1.400	0.138	2.640	1.477	4.921	2.281	1.250	1/4	1 5/16-12 UN-2B	J1926-162-125F
-20	1.535	0.906	2.306	15°	1.715	0.138	3.062	1.835	5.750	2.688	1.500	1/4	1 5/8-12 UN-2B	J1926-203-150F
-24	1.791	0.906	2.564	15°	1.965	0.138	3.062	1.778	5.750	2.688	1.500	1/4	1 7/8-12 UN-2B	J1926-243-150F
-32	2.421	0.906	3.470	15°	2.589	0.138	3.812	2.393	6.500	2.688	1.500	1/4	2 1/2-12 UN-2B	J1926-324-150F
<b>m</b> -4	9.80	14.00	21.30	12°	12.50	2.70	38.80	22.80	86.40	47.60	15.90	1/16	7/16-20 UNF-2B	J1926-04Y-063F
-5	11.50	14.00	23.50	12°	14.10	2.70	38.80	22.50	86.40	47.60	15.90	1/16	1/2-20 UNF-2B	J1926-05Z-063F
-6	13.00	15.50	25.10	12°	15.70	2.70	47.20	29.00	97.20	50.00	19.10	1/8	9/16-18 UNF-2B	J1926-060-075F
-8	17.50	17.50	30.60	15°	20.70	2.70	50.30	29.20	100.40	50.00	19.10	1/8	3/4-16 UNF-2B	J1926-080-075F
-10	20.50	20.00	34.10	15°	24.00	2.70	54.40	30.10	112.30	57.90	25.40	1/8	7/8-14 UNF-2B	J1926-101-100F
<b>m</b> -12	25.00	23.00	42.00	15°	29.20	3.50	67.10	38.90	125.00	57.90	31.80	1/4	1 1/16-12 UN-2B	J1926-122-125F
-14	28.00	23.00	45.20	15°	32.40	3.50	67.10	38.20	125.00	57.90	31.80	1/4	1 3/16-12 UN-2B	J1926-142-125F
-16	31.20	23.00	49.10	15°	35.60	3.50	67.10	37.50	125.00	57.90	31.80	1/4	1 5/16-12 UN-2B	J1926-162-125F
-20	39.00	23.00	58.50	15°	43.60	3.50	77.80	46.60	146.00	68.30	38.10	1/4	1 5/8-12 UN-2B	J1926-203-150F
-24	45.50	23.00	65.10	15°	49.90	3.50	77.80	45.20	146.00	68.30	38.10	1/4	1 7/8-12 UN-2B	J1926-243-150F
-32	61.50	23.00	88.10	15°	65.80	3.50	96.80	60.80	165.10	68.30	38.10	1/4	2 1/2-12 UN-2B	J1926-324-150F

\*Port contour cutters are available with extended pilot length (L<sub>13</sub>). See pages A92: 10-11 for items.

A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

A92: 30 - 37 Key on A92: 1

A92: 2 - 4

A92: 18 - 21

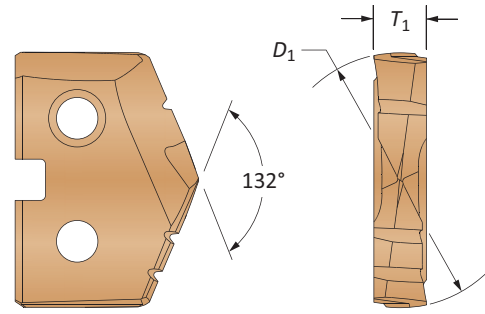
**i** = Imperial (in)  
**m** = Metric (mm)





SAE J-1926 / ISO 11926-1 / MS-16142

Inserts



See section A3 for complete T-A insert details

Original T-A® / GEN2 T-A® Drill Inserts

Tube Dash No.	AccuPort Part No.	T-A® Insert Series	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque*
			Super Cobalt (AM200)	Carbide (AM300®)			
-4	J1926-04Y-063F	Y	45YH-.386	4C1YP-.386	724-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-5	J1926-05Z-063F	Z	45ZH-11.5	4C1ZP-11.5	7247-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-6	J1926-060-075F	0	450H-13	4C10P-13	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	J1926-080-075F	0	450H-0022	4C10P-0022	72567-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	J1926-101-100F	1	451H-20.5	4C11P-20.5	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-12	J1926-122-125F	2	452H-25	4C12P-25	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-14	J1926-142-125F	2	452H-28	4C12P-28	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-16	J1926-162-125F	2	452H-1.231	4C12P-1.231	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-20	J1926-203-150F	3	453H-39	1C53A-39	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-24	J1926-243-150F	3	453H-45.5	1C53A-45.5	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-32	J1926-324-150F	4	454H-61.5	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)

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

Port Form Drill Inserts

Tube Dash No.	AccuPort Part No.	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque*
		C3 Carbide (AM200®)	C5 Carbide (TiAlN)			
-4	J1926-04Y-063F	J1926-02-C3H	J1926-02-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-5	J1926-05Z-063F	J1926-03-C3H	J1926-03-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-6	J1926-060-075F	J1926-03-C3H	J1926-03-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	J1926-080-075F	J1926-07-C3H	J1926-07-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	J1926-101-100F	J1926-04-C3H	J1926-04-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-12	J1926-122-125F	J1926-08-C3H	J1926-08-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-14	J1926-142-125F	J1926-08-C3H	J1926-08-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-16	J1926-162-125F	J1926-09-C3H	J1926-09-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-20	J1926-203-150F	J1926-10-C3H	J1926-10-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-24	J1926-243-150F	J1926-11-C3H	J1926-11-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-32	J1926-324-150F	J1926-12-C3H	J1926-12-C5A	7375-IP9-1	8IP-9	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

A92: 30 - 37

A92: 2 - 4

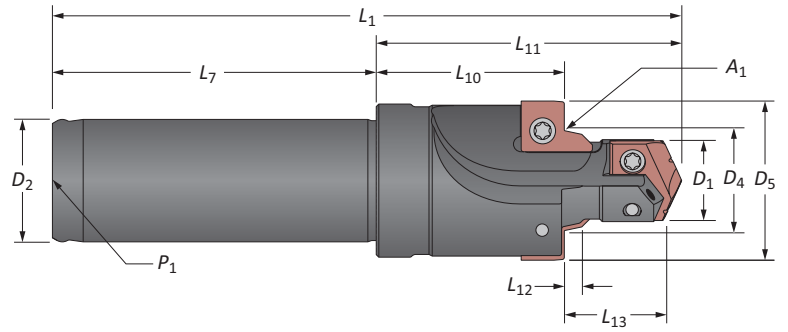
A92: 18 - 21

Y - 2 series T-A inserts sold in multiples of 2  
 3 - 4 series T-A inserts sold in multiples of 1  
 Port form inserts sold in multiples of 2  
 Insert screws sold in multiples of 10

J  
 A DRILLING  
 B BORING  
 C REAMING  
 D BURNISHING  
 E THREADING  
 X SPECIALS

SAE J-1926 / ISO 11926-1 / MS-16142

Metric Shank Holders



Tube Dash No.	Cutting			Seal Angle			Holder			Shank			Port Thread Size	Part No.
	D <sub>1</sub>	L <sub>13</sub>	D <sub>5</sub>	A <sub>1</sub>	D <sub>4</sub>	L <sub>12</sub>	L <sub>11</sub>	L <sub>10</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	P <sub>1</sub>		
-4	0.386	0.551	0.840	12°	0.490	0.106	1.527	0.896	3.180	1.650	0.630	1/16**	7/16-20 UNF-2B	J1926-04Y-16FM
-5	0.453	0.551	0.926	12°	0.553	0.106	1.527	0.885	3.650	1.650	0.630	1/16**	1/2-20 UNF-2B	J1926-05Z-16FM
-6	0.512	0.610	0.989	12°	0.618	0.106	1.857	1.144	3.510	1.650	0.787	1/8**	9/16-18 UNF-2B	J1926-060-20FM
-8	0.689	0.689	1.206	15°	0.813	0.106	1.982	1.150	3.630	1.650	0.787	1/8**	3/4-16 UNF-2B	J1926-080-20FM
-10	0.807	0.787	1.344	15°	0.945	0.106	2.140	1.185	4.230	2.091	0.984	1/8**	7/8-14 UNF-2B	J1926-101-25FM
<b>i</b> -12	0.984	0.906	1.655	15°	1.150	0.138	2.640	1.530	4.920	2.280	1.260	1/4**	1 1/16-12 UN-2B	J1926-122-32FM
-14	1.102	0.906	1.781	15°	1.276	0.138	2.640	1.504	4.920	2.280	1.260	1/4**	1 3/16-12 UN-2B	J1926-142-32FM
-16	1.231	0.906	1.934	15°	1.400	0.138	2.640	1.477	4.920	2.280	1.260	1/4**	1 5/16-12 UN-2B	J1926-162-32FM
-20	1.535	0.906	2.306	15°	1.715	0.138	3.062	1.835	5.640	2.580	1.260	1/4**	1 5/8-12 UN-2B	J1926-203-32FM*
-24	1.791	0.906	2.564	15°	1.965	0.138	3.062	1.778	5.640	2.580	1.260	1/4**	1 7/8-12 UN-2B	J1926-243-32FM*
-32	2.421	0.906	3.470	15°	2.589	0.138	3.812	2.393	6.390	2.580	1.260	1/4**	2 1/2-12 UN-2B	J1926-324-32FM*
<b>m</b> -4	9.80	14.00	21.30	12°	12.50	2.70	38.80	22.80	80.70	41.90	16.00	1/16**	7/16-20 UNF-2B	J1926-04Y-16FM
-5	11.50	14.00	23.50	12°	14.10	2.70	38.80	22.50	92.80	41.90	16.00	1/16**	1/2-20 UNF-2B	J1926-05Z-16FM
-6	13.00	15.50	25.10	12°	15.70	2.70	47.20	29.00	89.10	41.90	20.00	1/8**	9/16-18 UNF-2B	J1926-060-20FM
-8	17.50	17.50	30.60	15°	20.70	2.70	50.30	29.20	92.30	41.90	20.00	1/8**	3/4-16 UNF-2B	J1926-080-20FM
-10	20.50	20.00	34.10	15°	24.00	2.70	54.40	30.10	107.40	53.10	25.00	1/8**	7/8-14 UNF-2B	J1926-101-25FM
<b>m</b> -12	25.00	23.00	42.00	15°	29.20	3.50	67.10	38.90	125.00	57.90	32.00	1/4**	1 1/16-12 UN-2B	J1926-122-32FM
-14	28.00	23.00	45.20	15°	32.40	3.50	67.10	38.20	125.00	57.90	32.00	1/4**	1 3/16-12 UN-2B	J1926-142-32FM
-16	31.20	23.00	49.10	15°	35.60	3.50	67.10	37.50	125.00	57.90	32.00	1/4**	1 5/16-12 UN-2B	J1926-162-32FM
-20	39.00	23.00	58.50	15°	43.60	3.50	77.80	46.60	143.30	65.50	32.00	1/4**	1 5/8-12 UN-2B	J1926-203-32FM*
-24	45.50	23.00	65.10	15°	49.90	3.50	77.80	45.20	143.30	65.50	32.00	1/4**	1 7/8-12 UN-2B	J1926-243-32FM*
-32	61.50	23.00	88.10	15°	65.80	3.50	96.80	60.80	162.30	65.50	32.00	1/4**	2 1/2-12 UN-2B	J1926-324-32FM*

**\*NOTICE:** Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.  
**\*\*** Metric thread to BSP and ISO 7-1

A92: 30 - 37 Key on A92: 1

A92: 2 - 4

A92: 18 - 21

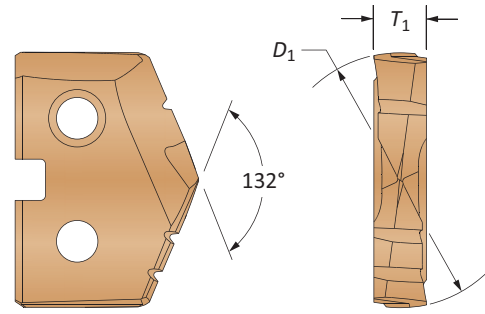
**i** = Imperial (in)  
**m** = Metric (mm)

A DRILLING  
 B BORING  
 C REAMING  
 D BURNISHING  
 E THREADING  
 X SPECIALS



SAE J-1926 / ISO 11926-1 / MS-16142

Inserts



See section A3 for complete T-A insert details

Original T-A® / GEN2 T-A® Drill Inserts

Tube Dash No.	AccuPort Part No.	T-A® Insert Series	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque**
			Super Cobalt (AM200)	Carbide (AM300®)			
-4	J1926-04Y-16FM	Y	45YH-.386	4C1YP-.386	724-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-5	J1926-05Z-16FM	Z	45ZH-11.5	4C1ZP-11.5	7247-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-6	J1926-060-20FM	0	450H-13	4C10P-13	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	J1926-080-20FM	0	450H-0022	4C10P-0022	72567-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	J1926-101-25FM	1	451H-20.5	4C11P-20.5	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-12	J1926-122-32FM	2	452H-25	4C12P-25	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-14	J1926-142-32FM	2	452H-28	4C12P-28	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-16	J1926-162-32FM	2	452H-1.231	4C12P-1.231	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-20	J1926-203-32FM*	3	453H-39	1C53A-39	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-24	J1926-243-32FM*	3	453H-45.5	1C53A-45.5	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-32	J1926-324-32FM*	4	454H-61.5	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)

\*NOTICE: Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

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

Port Form Drill Inserts

Tube Dash No.	AccuPort Part No.	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque**
		C3 Carbide (AM200®)	C5 Carbide (TiAlN)			
-4	J1926-04Y-16FM	J1926-02-C3H	J1926-02-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-5	J1926-05Z-16FM	J1926-03-C3H	J1926-03-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-6	J1926-060-20FM	J1926-03-C3H	J1926-03-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	J1926-080-20FM	J1926-07-C3H	J1926-07-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	J1926-101-25FM	J1926-04-C3H	J1926-04-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-12	J1926-122-32FM	J1926-08-C3H	J1926-08-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-14	J1926-142-32FM	J1926-08-C3H	J1926-08-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-16	J1926-162-32FM	J1926-09-C3H	J1926-09-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-20	J1926-203-32FM*	J1926-10-C3H	J1926-10-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-24	J1926-243-32FM*	J1926-11-C3H	J1926-11-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-32	J1926-324-32FM*	J1926-12-C3H	J1926-12-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)

\*NOTICE: Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

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

A92: 30 - 37

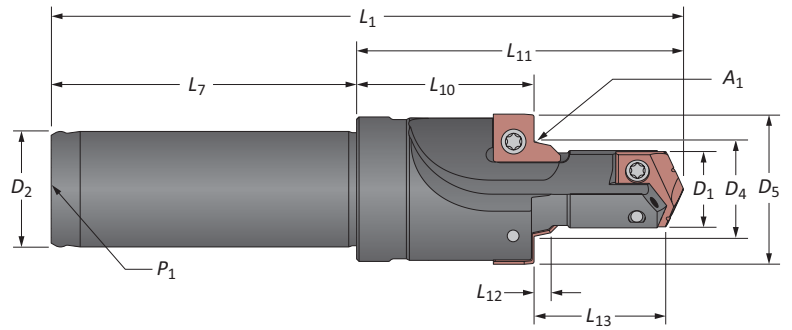
A92: 2 - 4

A92: 18 - 21

Y - 2 series T-A inserts sold in multiples of 2  
 3 - 4 series T-A inserts sold in multiples of 1  
 Port form inserts sold in multiples of 2  
 Insert screws sold in multiples of 10

## SAE J-1926 / ISO 11926-1 / MS-16142

Imperial Shank Holders | Extended Minor Diameter Lengths ( $L_{13}$ )



Tube Dash No.	Cutting			Seal Angle			Holder			Shank			Port Thread Size	Part No.
	$D_1$	$L_{13}$	$D_5$	$A_1$	$D_4$	$L_{12}$	$L_{11}$	$L_{10}$	$L_1$	$L_7$	$D_2$	$P_1$		
-4	0.386	0.801	0.840	12°	0.490	0.106	1.777	0.896	3.650	1.875	0.625	1/16	7/16-20 UNF-2B	X1926-04Y-063F
-5	0.453	0.801	0.926	12°	0.553	0.106	1.777	0.885	3.650	1.875	0.625	1/16	1/2-20 UNF-2B	X1926-05Z-063F
-6	0.512	0.860	0.989	12°	0.618	0.106	2.107	1.144	4.070	1.969	0.750	1/8	9/16-18 UNF-2B	X1926-060-075F
-8	0.689	0.939	1.206	15°	0.813	0.106	2.232	1.150	4.200	1.969	0.750	1/8	3/4-16 UNF-2B	X1926-080-075F
-10	0.807	1.037	1.344	15°	0.945	0.106	2.390	1.185	4.670	2.281	1.000	1/8	7/8-14 UNF-2B	X1926-101-100F
<b>i</b> -12	0.984	1.156	1.655	15°	1.150	0.138	2.890	1.530	5.170	2.281	1.250	1/4	1 1/16-12 UN-2B	X1926-122-125F
-14	1.102	1.156	1.781	15°	1.276	0.138	2.890	1.504	5.170	2.281	1.250	1/4	1 3/16-12 UN-2B	X1926-142-125F
-16	1.231	1.156	1.934	15°	1.400	0.138	2.890	1.477	5.170	2.281	1.250	1/4	1 5/16-12 UN-2B	X1926-162-125F
-20	1.535	1.156	2.306	15°	1.715	0.138	3.312	1.835	6.000	2.688	1.500	1/4	1 5/8-12 UN-2B	X1926-203-150F
-24	1.791	1.156	2.564	15°	1.965	0.138	3.312	1.778	6.000	2.688	1.500	1/4	1 7/8-12 UN-2B	X1926-243-150F
-32	2.421	1.156	3.470	15°	2.589	0.138	4.062	2.393	6.750	2.688	1.500	1/4	2 1/2-12 UN-2B	X1926-324-150F
<b>m</b> -4	9.80	20.30	21.30	12°	12.50	2.70	45.10	22.80	92.80	47.60	15.90	1/16	7/16-20 UNF-2B	X1926-04Y-063F
-5	11.50	20.30	23.50	12°	14.10	2.70	45.10	22.50	92.80	47.60	15.90	1/16	1/2-20 UNF-2B	X1926-05Z-063F
-6	13.00	21.80	25.10	12°	15.70	2.70	53.50	29.00	103.50	50.00	19.10	1/8	9/16-18 UNF-2B	X1926-060-075F
-8	17.50	23.80	30.60	15°	20.70	2.70	56.70	29.20	106.70	50.00	19.10	1/8	3/4-16 UNF-2B	X1926-080-075F
-10	20.50	26.30	34.10	15°	24.00	2.70	60.70	30.10	118.60	57.90	25.40	1/8	7/8-14 UNF-2B	X1926-101-100F
<b>m</b> -12	25.00	29.30	42.00	15°	29.20	3.50	73.40	38.90	131.30	57.90	31.80	1/4	1 1/16-12 UN-2B	X1926-122-125F
-14	28.00	29.30	45.20	15°	32.40	3.50	73.40	38.20	131.30	57.90	31.80	1/4	1 3/16-12 UN-2B	X1926-142-125F
-16	31.20	29.30	49.10	15°	35.60	3.50	73.40	37.50	131.30	57.90	31.80	1/4	1 5/16-12 UN-2B	X1926-162-125F
-20	39.00	29.30	58.50	15°	43.60	3.50	84.10	46.60	152.40	68.30	38.10	1/4	1 5/8-12 UN-2B	X1926-203-150F
-24	45.50	29.30	65.10	15°	49.90	3.50	84.10	45.20	152.40	68.30	38.10	1/4	1 7/8-12 UN-2B	X1926-243-150F
-32	61.50	29.30	88.10	15°	65.80	3.50	103.20	60.80	171.40	68.30	38.10	1/4	2 1/2-12 UN-2B	X1926-324-150F

A92: 30 - 37 Key on A92: 1

A92: 2 - 4

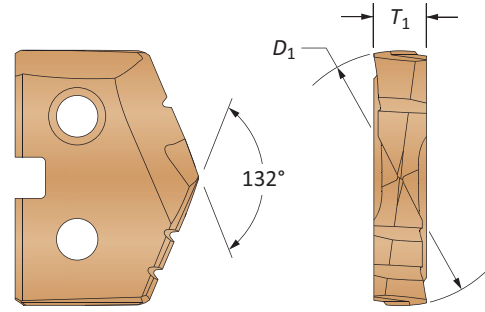
A92: 18 - 21

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



SAE J-1926 / ISO 11926-1 / MS-16142

Inserts



See section A3 for complete T-A insert details

Original T-A® / GEN2 T-A® Drill Inserts

Tube Dash No.	AccuPort Part No.	T-A® Insert Series	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque*
			Super Cobalt (AM200)	Carbide (AM300®)			
-4	X1926-04Y-063F	Y	45YH-.386	4C1YP-.386	724-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-5	X1926-05Z-063F	Z	45ZH-11.5	4C1ZP-11.5	7247-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-6	X1926-060-075F	0	450H-13	4C10P-13	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	X1926-080-075F	0	450H-0022	4C10P-0022	72567-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	X1926-101-100F	1	451H-20.5	4C11P-20.5	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-12	X1926-122-125F	2	452H-25	4C12P-25	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-14	X1926-142-125F	2	452H-28	4C12P-28	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-16	X1926-162-125F	2	452H-1.231	4C12P-1.231	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-20	X1926-203-150F	3	453H-39	1C53A-39	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-24	X1926-243-150F	3	453H-45.5	1C53A-45.5	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-32	X1926-324-150F	4	454H-61.5	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)

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

Port Form Drill Inserts

Tube Dash No.	AccuPort Part No.	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque*
		C3 Carbide (AM200®)	C5 Carbide (TiAlN)			
-4	X1926-04Y-063F	J1926-02-C3H	J1926-02-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-5	X1926-05Z-063F	J1926-03-C3H	J1926-03-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-6	X1926-060-075F	J1926-03-C3H	J1926-03-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	X1926-080-075F	J1926-07-C3H	J1926-07-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	X1926-101-100F	J1926-04-C3H	J1926-04-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-12	X1926-122-125F	J1926-08-C3H	J1926-08-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-14	X1926-142-125F	J1926-08-C3H	J1926-08-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-16	X1926-162-125F	J1926-09-C3H	J1926-09-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-20	X1926-203-150F	J1926-10-C3H	J1926-10-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-24	X1926-243-150F	J1926-11-C3H	J1926-11-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-32	X1926-324-150F	J1926-12-C3H	J1926-12-C5A	7375-IP9-1	8IP-9	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

A92: 30 - 37

A92: 2 - 4

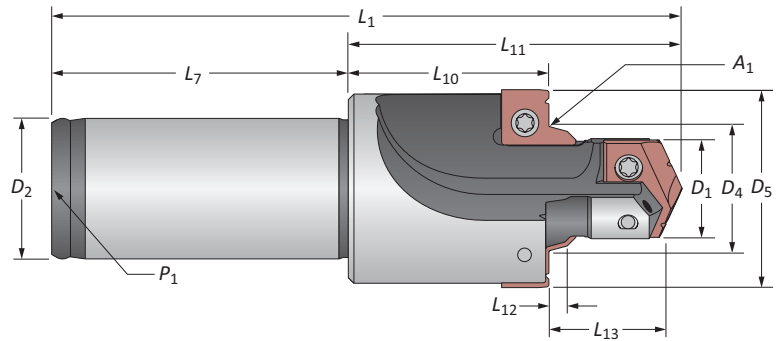
A92: 18 - 21

Y - 2 series T-A inserts sold in multiples of 2  
 3 - 4 series T-A inserts sold in multiples of 1  
 Port form inserts sold in multiples of 2  
 Insert screws sold in multiples of 10

X  
 A DRILLING  
 B BORING  
 C REAMING  
 D BURNISHING  
 E THREADING  
 X SPECIALS

## ISO 6149-1:2006 / SAE J-2244/1

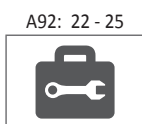
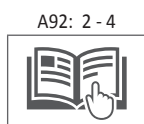
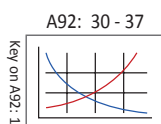
### Metric Shank Holders



Tube Dash No.	Cutting			Seal Angle			Holder			Shank			Port Thread Size	Part No.
	D <sub>1</sub>	L <sub>13</sub>	D <sub>5</sub>	A <sub>1</sub>	D <sub>4</sub>	L <sub>12</sub>	L <sub>11</sub>	L <sub>10</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	P <sub>1</sub>		
-4	0.413	0.556	0.945	15°	0.544	0.102	1.527	0.876	3.180	1.650	0.630	1/16**	M12 X 1.5	I6149-04RY-16FM
-5	0.492	0.556	1.024	15°	0.623	0.102	1.527	0.858	3.180	1.650	0.630	1/16**	M14 X 1.5	I6149-05RZ-16FM
-6	0.571	0.615	1.102	15°	0.702	0.102	1.857	1.116	3.510	1.650	0.787	1/8**	M16 X 1.5	I6149-06R0-20FM
-8	0.650	0.674	1.181	15°	0.781	0.102	1.982	1.164	3.630	1.650	0.787	1/8**	M18 X 1.5	I6149-08R0-20FM
-10	0.807	0.717	1.339	15°	0.938	0.102	2.140	1.246	4.230	2.091	0.984	1/8**	M22 X 1.5	I6149-10R1-25FM
<b>i</b> -12	0.984	0.874	1.575	15°	1.159	0.130	2.640	1.552	4.920	2.280	1.260	1/4**	M27 X 2	I6149-12R2-32FM
-14	1.102	0.874	1.733	15°	1.277	0.130	2.640	1.526	4.920	2.280	1.260	1/4**	M30 X 2	I6149-14R2-32FM
-16	1.220	0.874	1.929	15°	1.395	0.130	2.640	1.499	4.920	2.280	1.260	1/4**	M33 X 2	I6149-16R2-32FM
-20	1.575	0.895	2.362	15°	1.749	0.130	3.062	1.828	5.640	2.280	1.260	1/4**	M42 X 2	I6149-20R3-32FM*
-24	1.811	0.993	2.602	15°	1.985	0.130	3.062	1.676	5.640	2.280	1.260	1/4**	M48 X 2	I6149-24R3-32FM*
-32	2.283	1.092	2.992	15°	2.458	0.130	3.812	2.228	6.390	2.280	1.260	1/4**	M60 X 2	I6149-32R4-32FM*
<b>m</b> -4	10.50	14.10	24.00	15°	13.81	2.60	38.80	22.20	80.70	41.90	16.00	1/16**	M12 X 1.5	I6149-04RY-16FM
-5	12.50	14.10	26.00	15°	15.80	2.60	38.80	21.80	80.70	41.90	16.00	1/16**	M14 X 1.5	I6149-05RZ-16FM
-6	14.50	15.60	28.00	15°	17.80	2.60	47.20	28.30	89.10	41.90	20.00	1/8**	M16 X 1.5	I6149-06R0-20FM
-8	16.50	17.10	30.00	15°	19.80	2.60	50.30	29.60	92.20	41.90	20.00	1/8**	M18 X 1.5	I6149-08R0-20FM
-10	20.50	18.20	34.00	15°	23.80	2.60	54.40	31.60	107.50	53.10	25.00	1/8**	M22 X 1.5	I6149-10R1-25FM
<b>m</b> -12	25.00	22.20	40.00	15°	29.40	3.30	67.10	39.40	125.00	57.90	32.00	1/4**	M27 X 2	I6149-12R2-32FM
-14	28.00	22.20	44.00	15°	32.40	3.30	67.10	38.80	125.00	57.90	32.00	1/4**	M30 X 2	I6149-14R2-32FM
-16	31.00	22.20	49.00	15°	35.40	3.30	67.10	38.10	125.00	57.90	32.00	1/4**	M33 X 2	I6149-16R2-32FM
-20	40.00	22.70	60.00	15°	44.40	3.30	77.80	46.40	143.30	57.90	32.00	1/4**	M42 X 2	I6149-20R3-32FM*
-24	46.00	25.20	66.10	15°	50.40	3.30	77.80	42.60	143.30	57.90	32.00	1/4**	M48 X 2	I6149-24R3-32FM*
-32	58.00	27.70	76.00	15°	62.40	3.30	96.80	56.60	162.30	57.90	32.00	1/4**	M60 X 2	I6149-32R4-32FM*

**\*NOTICE:** Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

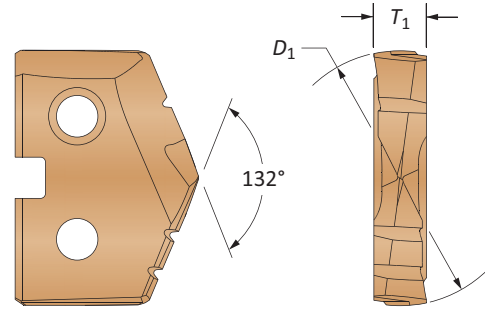
\*\* Metric thread to BSP and ISO 7-1





ISO 6149-1:2006 / SAE J-2244/1

Inserts



See section A3 for complete T-A insert details

Original T-A® / GEN2 T-A® Drill Inserts

Tube Dash No.	AccuPort Part No.	T-A® Insert Series	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque**
			Super Cobalt (AM200)	Carbide (AM300®)			
-4	I6149-04RY-16FM	Y	45YH-10.5	4C1YP-10.5	724-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-5	I6149-05RZ-16FM	Z	45ZH-12.5	4C1ZP-12.5	7247-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-6	I6149-06R0-20FM	0	450H-14.5	4C10P-14.5	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	I6149-08R0-20FM	0	450H-16.5	4C10P-16.5	72567-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	I6149-10R1-25FM	1	451H-20.5	4C11P-20.5	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-12	I6149-12R2-32FM	2	452H-25	4C12P-25	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-14	I6149-14R2-32FM	2	452H-28	4C12P-28	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-16	I6149-16R2-32FM	2	452H-31	4C12P-31	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-20	I6149-20R3-32FM*	3	453H-40	1C53A-40	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-24	I6149-24R3-32FM*	3	453H-46	1C53A-46	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-32	I6149-32R4-32FM*	4	454H-58	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)

\*NOTICE: Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

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

Port Form Drill Inserts

Tube Dash No.	AccuPort Part No.	Part No. - C3 Carbide (AM200®)		Part No. - C5 Carbide (TiAlN)		Insert Screw	Insert Driver	Admissible Tightening Torque**
		ID Ridge	No ID Ridge	ID Ridge	No ID Ridge			
-4	I6149-04RY-16FM	I6149-04R-C3H	I6149-04-C3H	I6149-04R-C5A	I6149-04-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-5	I6149-05RZ-16FM	I6149-04R-C3H	I6149-04-C3H	I6149-04R-C5A	I6149-04-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-6	I6149-06R0-20FM	I6149-06R-C3H	I6149-06-C3H	I6149-06R-C5A	I6149-06-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	I6149-08R0-20FM	I6149-06R-C3H	I6149-06-C3H	I6149-06R-C5A	I6149-06-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	I6149-10R1-25FM	I6149-04R-C3H	I6149-04-C3H	I6149-04R-C5A	I6149-04-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-12	I6149-12R2-32FM	I6149-12R-C3H	I6149-12-C3H	I6149-12R-C5A	I6149-12-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-14	I6149-14R2-32FM	I6149-14R-C3H	I6149-14-C3H	I6149-14R-C5A	I6149-14-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-16	I6149-16R2-32FM	I6149-16R-C3H	I6149-16-C3H	I6149-16R-C5A	I6149-16-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-20	I6149-20R3-32FM*	I6149-20R-C3H	I6149-20-C3H	I6149-20R-C5A	I6149-20-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-24	I6149-24R3-32FM*	I6149-24R-C3H	I6149-24-C3H	I6149-24R-C5A	I6149-24-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-32	I6149-32R4-32FM*	I6149-32R-C3H	I6149-32-C3H	I6149-32R-C5A	I6149-32-C5A	7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)

\*NOTICE: Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

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

A92: 30 - 37

A92: 2 - 4

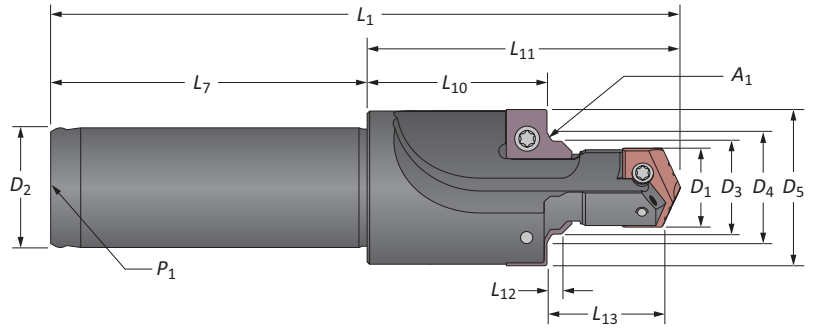
A92: 22 - 25

Y - 2 series T-A inserts sold in multiples of 2  
 3 - 4 series T-A inserts sold in multiples of 1  
 Port form inserts sold in multiples of 2  
 Insert screws sold in multiples of 10

A DRILLING B BORING C REAMING D BURNISHING E THREADING X SPECIALS

SAE AS5202 / AND10050

Imperial Shank Holders



Tube Dash No.	Cutting				Seal Angle			Holder				Shank			Port Thread Size	Port Thread Size*	Part No.
	D <sub>1</sub>	D <sub>1</sub> *	L <sub>13</sub>	D <sub>5</sub>	A <sub>1</sub>	D <sub>4</sub>	L <sub>12</sub>	D <sub>3</sub>	L <sub>11</sub>	L <sub>10</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	P <sub>1</sub>			
-4	0.390	0.386	0.661	0.875	60°	0.564	0.083	0.454	1.637	0.896	3.510	1.875	0.625	1/16	7/16-20 UNJF-3B	7/16-20 UNF-3B	AS5202-04Y-063F
-5	0.453	0.451	0.661	0.916	60°	0.625	0.083	0.517	1.637	0.882	3.510	1.875	0.625	1/16	1/2-20 UNJF-3B	1/2-20 UNF-3B	AS5202-05Z-063F
-6	0.510	0.506	0.714	0.979	60°	0.688	0.083	0.580	1.940	1.119	3.910	1.969	0.750	1/8	9/16-18 UNJF-3B	9/16-18 UNF-3B	AS5202-06Z-075F
-8	0.689	0.688	0.839	1.198	60°	0.875	0.094	0.769	2.107	1.125	4.080	1.969	0.750	1/8	3/4-16 UNJF-3B	3/4-16 UNF-3B	AS5202-080-075F
-10	0.807	0.801	0.935	1.354	60°	1.002	0.107	0.896	2.290	1.189	4.570	2.281	1.000	1/8	7/8-14 UNJF-3B	7/8-14 UNF-3B	AS5202-101-100F
i -12	0.984	0.976	1.069	1.635	60°	1.237	0.125	1.086	2.765	1.494	5.050	2.281	1.250	1/4	1 1/16-12 UNJ-3B	1 1/16-12 UN-3B	AS5202-122-125F
-14	1.109	1.102	1.069	1.775	60°	1.363	0.125	1.211	2.765	1.465	5.050	2.281	1.250	1/4	1 3/16-12 UNJ-3B	1 3/16-12 UN-3B	AS5202-142-125F
-16	1.234	1.226	1.069	1.920	60°	1.487	0.125	1.336	2.765	1.437	5.050	2.281	1.250	1/4	1 5/16-12 UNJ-3B	1 5/16-12 UN-3B	AS5202-162-125F
-20	1.547	1.535	1.121	2.280	60°	1.799	0.125	1.648	3.187	1.745	5.880	2.688	1.500	1/4	1 5/8-12 UNJ-3B	1 5/8-12 UN-3B	AS5202-203-150F
-24	1.797	1.791	1.132	2.570	60°	2.050	0.125	1.898	3.187	1.676	5.880	2.688	1.500	1/4	1 7/8-12 UNJ-3B	1 7/8-12 UN-3B	AS5202-243-150F
-32	2.421	2.413	1.373	3.490	60°	2.676	0.125	2.524	3.687	1.802	6.380	2.688	1.500	1/4	2 1/2-12 UNJ-3B	2 1/2-12 UN-3B	AS5202-324-150F
-4	9.90	9.80	16.79	22.23	60°	14.34	2.11	11.53	41.58	22.76	89.20	47.63	15.88	1/16	7/16-20 UNJF-3B	7/16-20 UNF-3B	AS5202-04Y-063F
-5	11.50	11.45	16.79	23.27	60°	15.88	2.11	13.13	41.58	22.39	89.20	47.63	15.88	1/16	1/2-20 UNJF-3B	1/2-20 UNF-3B	AS5202-05Z-063F
-6	12.95	12.85	18.14	24.87	60°	17.46	2.11	14.73	49.28	28.43	99.29	50.01	19.05	1/8	9/16-18 UNJF-3B	9/16-18 UNF-3B	AS5202-06Z-075F
-8	17.50	17.46	21.31	30.43	60°	22.23	2.39	19.53	53.52	28.57	103.53	50.01	19.05	1/8	3/4-16 UNJF-3B	3/4-16 UNF-3B	AS5202-080-075F
-10	20.50	20.35	23.75	34.39	60°	25.46	2.72	22.76	58.17	30.19	116.10	57.94	25.40	1/8	7/8-14 UNJF-3B	7/8-14 UNF-3B	AS5202-101-100F
m -12	25.00	24.80	27.15	41.53	60°	31.42	3.18	27.58	70.23	37.94	128.17	57.94	31.75	1/4	1 1/16-12 UNJ-3B	1 1/16-12 UN-3B	AS5202-122-125F
-14	28.17	28.00	27.15	45.09	60°	34.61	3.18	30.76	70.23	37.22	128.17	57.94	31.75	1/4	1 3/16-12 UNJ-3B	1 3/16-12 UN-3B	AS5202-142-125F
-16	31.34	31.15	27.15	48.77	60°	37.77	3.18	33.93	70.23	36.51	128.17	57.94	31.75	1/4	1 5/16-12 UNJ-3B	1 5/16-12 UN-3B	AS5202-162-125F
-20	39.29	39.00	28.47	57.91	60°	45.69	3.18	41.86	80.95	44.32	149.23	68.28	38.10	1/4	1 5/8-12 UNJ-3B	1 5/8-12 UN-3B	AS5202-203-150F
-24	45.64	45.50	28.75	65.28	60°	52.07	3.18	48.21	80.95	42.58	149.23	68.28	38.10	1/4	1 7/8-12 UNJ-3B	1 7/8-12 UN-3B	AS5202-243-150F
-32	61.49	61.30	34.87	88.65	60°	67.97	3.18	64.11	93.65	45.78	161.93	68.28	38.10	1/4	2 1/2-12 UNJ-3B	2 1/2-12 UN-3B	AS5202-324-150F

\*AND10050 specifications shown in red

A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

A92: 30 - 37 A92: 2 - 4 A92: 26 - 27

Key on A92: 1

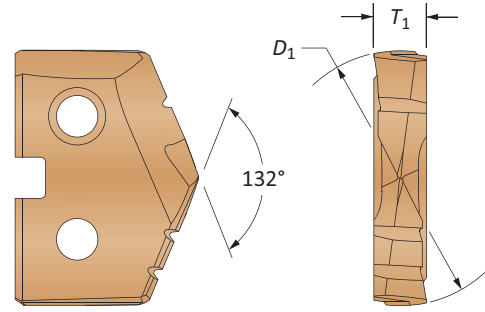
i = Imperial (in)  
m = Metric (mm)





SAE AS5202 / AND10050

Inserts



See section A3 for complete T-A insert details

Original T-A® / GEN2 T-A® Drill Inserts

Tube Dash No.	AccuPort Part No.	T-A® Insert Series	Part No.				Insert Screw	Insert Driver	Admissible Tightening Torque*
			Super Cobalt (AM200®)		Carbide (AM300®)				
-4	AS5202-04Y-063F	Y	45YH-.390	45YH-.386	4C1YP-.390	4C1YP-.386	724-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-5	AS5202-05Z-063F	Z	45ZH-11.5	45ZH-.451	4C1ZP-11.5	4C1ZP-.451	7247-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-6	AS5202-06Z-075F	Z	45ZH-.510	45ZH-.506	4C1ZP-.510	4C1ZP-.506	72567-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-8	AS5202-080-075F	0	450H-17.5	450H-0022	4C10P-17.5	4C10P-0022	72567-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	AS5202-101-100F	1	451H-20.5	451H-.801	4C11P-20.5	4C11P-.801	739-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-12	AS5202-122-125F	2	452H-25	452H-.976	4C12P-25	4C12P-.976	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-14	AS5202-142-125F	2	452H-1.109	452H-28	4C12P-1.109	4C12P-28	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-16	AS5202-162-125F	2	452H-1.234	452H-1.226	4C12P-1.234	4C12P-1.226	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-20	AS5202-203-150F	3	453H-1.547	453H-39	1C53A-1.547	1C53A-39	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-24	AS5202-243-150F	3	453H-1.797	453H-45.5	1C53A-1.797	1C53A-45.5	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-32	AS5202-324-150F	4	454H-2.421	454H-2.413	-	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)

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

NOTE: AND10050 specifications shown in red

Port Form Drill Inserts

Tube Dash No.	AccuPort Part No.	Part No.		Insert Driver	Admissible Tightening Torque*
		C5 Carbide (TiAlN)	Insert Screw		
-4	AS5202-04Y-063F	AS5202-04-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-5	AS5202-05Z-063F	AS5202-05-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-6	AS5202-06Z-075F	AS5202-06-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	AS5202-080-075F	AS5202-08-C5A	72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	AS5202-101-100F	AS5202-10-C5A	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-12	AS5202-122-125F	AS5202-12-C5A	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-14	AS5202-142-125F	AS5202-14-C5A	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-16	AS5202-162-125F	AS5202-16-C5A	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-20	AS5202-203-150F	AS5202-20-C5A	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-24	AS5202-243-150F	AS5202-24-C5A	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-32	AS5202-324-150F	AS5202-32-C5A	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)

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

Key on A92-1

A92: 30 - 37

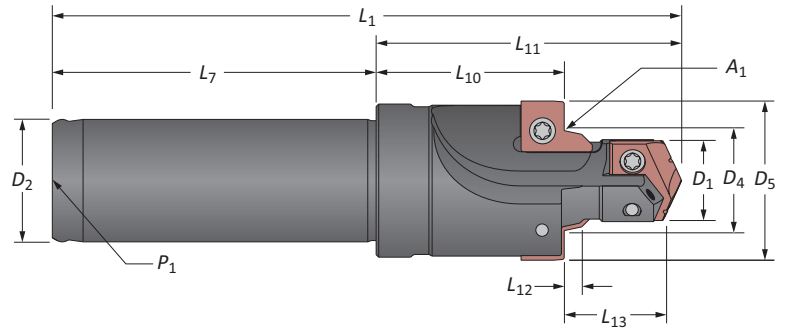
A92: 2 - 4

A92: 26 - 27

Y - 2 series T-A inserts sold in multiples of 2  
 3 - 4 series T-A inserts sold in multiples of 1  
 Port form inserts sold in multiples of 2  
 Insert screws sold in multiples of 10

### JDS-G173.1

#### Metric Shank Holders



Tube Dash No.	Cutting			Seal Angle			Holder			Shank			Port Thread Size	Part No.
	D <sub>1</sub>	L <sub>13</sub>	D <sub>5</sub>	A <sub>1</sub>	D <sub>4</sub>	L <sub>12</sub>	L <sub>11</sub>	L <sub>10</sub>	L <sub>1</sub>	L <sub>7</sub>	D <sub>2</sub>	BSPT TAP		
-4	0.413	0.709	0.945	15°	0.547	0.104	1.670	0.875	3.320	1.650	0.630	1/16**	M12 X 1.5	G1731-04Y-16FM
-5	0.492	0.709	1.024	15°	0.626	0.104	1.670	0.858	3.320	1.650	0.630	1/16**	M14 X 1.5	G1731-05Z-16FM
-6	0.571	0.748	1.142	15°	0.705	0.104	1.977	1.117	3.630	1.650	0.787	1/8**	M16 X 1.5	G1731-06O-20FM
-8	0.650	0.827	1.220	15°	0.783	0.104	2.127	1.161	3.770	1.650	0.787	1/8**	M18 X 1.5	G1731-08O-20FM
-10	0.807	0.866	1.378	15°	0.941	0.104	2.280	1.246	4.370	2.090	0.984	1/8**	M22 X 1.5	G1731-101-25FM
-12	0.984	1.063	1.614	15°	1.161	0.132	2.820	1.553	5.100	2.280	1.260	1/4**	M27 X 2	G1731-122-32FM
<b>i</b> -14	1.102	1.063	1.732	15°	1.280	0.132	2.820	1.526	5.100	2.280	1.260	1/4**	M30 X 2	G1731-142-32FM
-16	1.221	1.063	1.969	15°	1.398	0.132	2.820	1.500	5.100	2.280	1.260	1/4**	M33 X 2	G1731-162-32FM
-18	1.417	1.063	2.165	15°	1.594	0.132	3.207	1.844	5.780	2.580	1.260	1/4**	M38 X 2	G1731-183-32FM*
-20	1.575	1.063	2.402	15°	1.752	0.132	3.207	1.809	5.780	2.580	1.260	1/4**	M42 X 2	G1731-203-32FM*
-24	1.811	1.142	2.638	15°	1.988	0.132	3.207	1.687	5.780	2.580	1.260	1/4**	M48 X 2	G1731-243-32FM*
-32	2.284	1.260	3.031	15°	2.461	0.132	3.967	2.300	6.550	2.580	1.260	1/4**	M60 X 2	G1731-324-32FM*
C***	0.728	0.787	1.299	15°	0.862	0.104	2.140	1.281	4.230	2.090	0.984	1/8**	M20 X 1.5	G1731-CV1-25FM
<hr/>														
-4	10.50	18.00	24.00	15°	13.90	2.65	42.42	22.20	84.50	41.90	16.00	1/16**	M12 X 1.5	G1731-04Y-16FM
-5	12.50	18.00	26.00	15°	15.90	2.65	42.42	21.80	84.50	41.90	16.00	1/16**	M14 X 1.5	G1731-05Z-16FM
-6	14.50	19.00	29.00	15°	17.90	2.65	50.22	28.40	92.20	41.90	20.00	1/8**	M16 X 1.5	G1731-06O-20FM
-8	16.50	21.00	31.00	15°	19.90	2.65	54.03	29.50	95.80	41.90	20.00	1/8**	M18 X 1.5	G1731-08O-20FM
-10	20.50	22.00	35.00	15°	23.90	2.65	57.91	31.60	111.00	53.10	25.00	1/8**	M22 X 1.5	G1731-101-25FM
-12	25.00	27.00	41.00	15°	29.50	3.35	71.63	39.40	129.60	57.90	32.00	1/4**	M27 X 2	G1731-122-32FM
<b>m</b> -14	28.00	27.00	44.00	15°	32.50	3.35	71.63	39.70	129.60	57.90	32.00	1/4**	M30 X 2	G1731-142-32FM
-16	31.00	27.00	50.00	15°	35.50	3.35	71.63	38.10	129.60	57.90	32.00	1/4**	M33 X 2	G1731-162-32FM
-18	36.00	27.00	55.00	15°	40.50	3.35	81.46	46.80	146.80	65.50	32.00	1/4**	M38 X 2	G1731-183-32FM*
-20	40.00	27.00	61.00	15°	44.50	3.35	81.46	45.90	146.80	65.50	32.00	1/4**	M42 X 2	G1731-203-32FM*
-24	46.00	29.00	67.00	15°	50.50	3.35	81.46	42.80	146.80	65.50	32.00	1/4**	M48 X 2	G1731-243-32FM*
-32	58.00	32.00	77.00	15°	62.50	3.35	100.76	58.40	166.40	65.50	32.00	1/4**	M60 X 2	G1731-324-32FM*
C***	18.50	20.00	33.00	15°	21.90	2.65	54.36	32.50	107.40	53.10	25.00	1/8**	M20 X 1.5	G1731-CV1-25FM

**\*NOTICE:** Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

\*\* Metric thread to BSP and ISO 7-1

\*\*Cartridge cavity

A92: 30 - 37

A92: 2 - 4

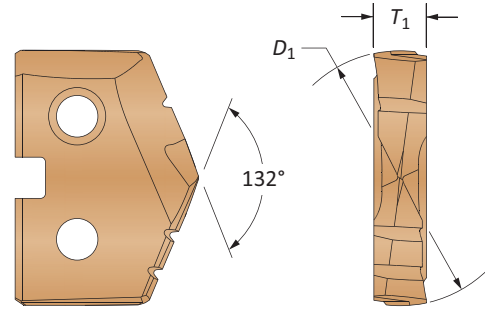
A92: 28

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



JDS-G173.1

Inserts



See section A3 for complete T-A insert details

GEN2 T-A® Drill Inserts

Tube Dash No.	AccuPort Part No.	T-A® Insert Series	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque**
			Super Cobalt (AM200)	Carbide (AM300®)			
-4	G1731-04Y-16FM	Y	45YH-10.5	4C2YP-10.5	724-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-5	G1731-05Z-16FM	Z	45ZH-12.5	4C2ZP-12.5	7247-IP7-1	8IP-7	7.4 in/lbs (84 N-cm)
-6	G1731-060-20FM	0	450H-14.5	4C20P-14.5	72567-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	G1731-080-20FM	0	450H-16.5	4C20P-16.5	72567-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	G1731-101-25FM	1	451H-20.5	4C21P-20.5	739-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-12	G1731-122-32FM	2	452H-25	4C22P-25	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-14	G1731-142-32FM	2	452H-28	4C22P-28	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-16	G1731-162-32FM	2	452H-31	4C22P-31	7495-IP15-1	8IP-15	61.0 in/lbs (690 N-cm)
-18	G1731-183-32FM*	3	453H-36	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-20	G1731-203-32FM*	3	453H-40	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-24	G1731-243-32FM*	3	453H-46	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
-32	G1731-324-32FM*	4	454H-58	-	7514-IP20-1	8IP-20	121.3 in/lbs (1370 N-cm)
C***	G1731-CV1-25FM	1	451H-18.5	4C21P-18.5	739-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)

\*NOTICE: Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

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

\*\*\*Cartridge cavity

Port Form Drill Inserts

Tube Dash No.	AccuPort Part No.	Part No.		Insert Screw	Insert Driver	Admissible Tightening Torque**
		C3 Carbide (AM200®)				
-4	G1731-04Y-16FM	G1731-01-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-5	G1731-05Z-16FM	G1731-01-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-6	G1731-060-20FM	G1731-02-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-8	G1731-080-20FM	G1731-02-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-10	G1731-101-25FM	G1731-02-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-12	G1731-122-32FM	G1731-03-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-14	G1731-142-32FM	G1731-03-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)
-16	G1731-162-32FM	G1731-04-C3H		7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-18	G1731-183-32FM*	G1731-04-C3H		7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-20	G1731-203-32FM*	G1731-05-C3H		7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-24	G1731-243-32FM*	G1731-05-C3H		7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
-32	G1731-324-32FM*	G1731-06-C3H		7375-IP9-1	8IP-9	27.0 in/lbs (305 N-cm)
C***	G1731-CV1-25FM	G1731-02-C3H		72556-IP8-1	8IP-8	15.5 in/lbs (175 N-cm)

\*NOTICE: Due to the cutting forces generated by this tool, a mechanical chuck is required. Please contact Application Engineering with any questions.

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

\*\*\*Cartridge cavity

A92: 30 - 37

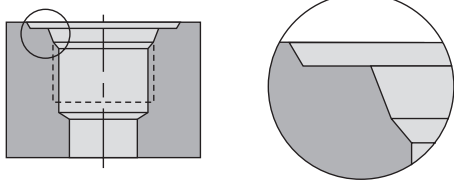
A92: 2 - 4

A92: 28

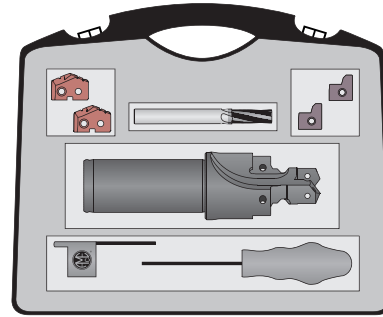
Y - 2 series T-A inserts sold in multiples of 2  
 3 - 4 series T-A inserts sold in multiples of 1  
 Port form inserts sold in multiples of 2  
 Insert screws sold in multiples of 10

## Port and Thread Finishing Kits

J1926 | Imperial | Ferrous Materials

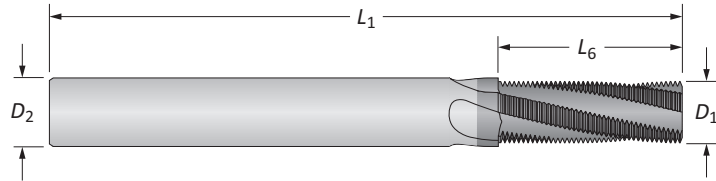


SAE J-1926-1 / ISO 11926-1



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			GEN2 T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (AM200®)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (AM210®)	Qty	
-4	J1926-04Y-063F	7/16-20 UNF-2B	1	45YH-.386	2	J1926-02-C5A	2	TMAK0438-20	1	ATKK04-1926
-5	J1926-05Z-063F	1/2-20 UNF-2B	1	45ZH-11.5	2	J1926-03-C5A	2	TMAK0438-20	1	ATKK05-1926
-6	J1926-060-075F	9/16-18 UNF-2B	1	450H-13	2	J1926-03-C5A	2	TMAK0563-18	1	ATKK06-1926
-8	J1926-080-075F	3/4-16 UNF-2B	1	450H-0022	2	J1926-07-C5A	2	TMAK0750-16	1	ATKK08-1926
-10	J1926-101-100F	7/8-14 UNF-2B	1	451H-20.5	2	J1926-04-C5A	2	TMAK0875-14	1	ATKK10-1926
-12	J1926-122-125F	1-1/16-12 UN-2B	1	452H-25	2	J1926-08-C5A	2	TMAK1063-12	1	ATKK12-1926
-14	J1926-142-125F	1-3/16-12 UN-2B	1	452H-28	2	J1926-08-C5A	2	TMAK1063-12	1	ATKK14-1926
-16	J1926-162-125F	1-5/16-12 UN-2B	1	452H-1.231	2	J1926-09-C5A	2	TMAK1063-12	1	ATKK16-1926
-20	J1926-203-150F	1-5/8-12 UN-2B	1	453H-39	1	J1926-10-C5A	2	TMAK1063-12	1	ATKK20-1926
-24	J1926-243-150F	1-7/8-12 UN-2B	1	453H-45.5	1	J1926-11-C5A	2	TMAK1063-12	1	ATKK24-1926
-32	J1926-324-150F	2-1/2-12 UN-2B	1	454H-61.5	1	J1926-12-C5A	2	TMAK1063-12	1	ATKK32-1926



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4 to -5	20	0.335	0.600	0.375	3.5	4	TMAK0438-20
-6	18	0.370	0.666	0.375	3.5	4	TMAK0563-18
-8	16	0.495	0.750	0.500	3.5	4	TMAK0750-16
-10	14	0.495	0.857	0.500	3.5	4	TMAK0875-14
-12 to -32	12	0.495	0.917	0.500	3.5	4	TMAK1063-12

AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE AS5202 port form specifications.

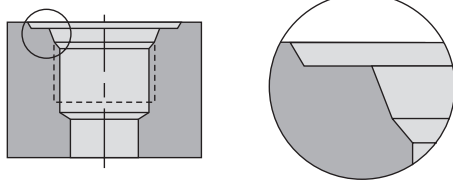
A92: 30 - 37      A92: 2 - 4      A92: 6 - 7

Key on A92: 1

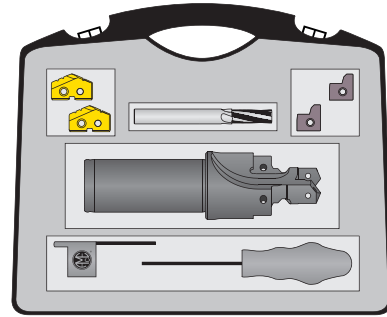


## Port and Thread Finishing Kits

J1926 | Imperial | Non-Ferrous Materials

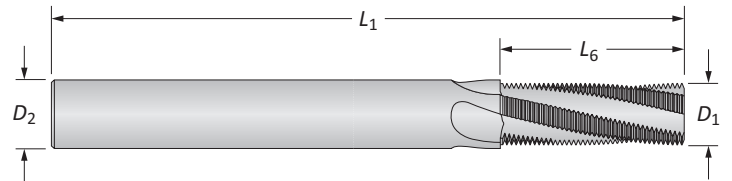


SAE J-1926-1 / ISO 11926-1



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			Original T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (TiN)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (Uncoated)	Qty	
-4	J1926-04Y-063F	7/16-20 UNF-2B	1	15YT-386	2	J1926-02-C5A	2	TMAU0438-20	1	ATKU04-1926
-5	J1926-05Z-063F	1/2-20 UNF-2B	1	15ZT-11.5	2	J1926-03-C5A	2	TMAU0438-20	1	ATKU05-1926
-6	J1926-060-075F	9/16-18 UNF-2B	1	150T-13	2	J1926-03-C5A	2	TMAU0563-18	1	ATKU06-1926
-8	J1926-080-075F	3/4-16 UNF-2B	1	150T-0022	2	J1926-07-C5A	2	TMAU0750-16	1	ATKU08-1926
-10	J1926-101-100F	7/8-14 UNF-2B	1	151T-20.5	2	J1926-04-C5A	2	TMAU0875-14	1	ATKU10-1926
-12	J1926-122-125F	1-1/16-12 UN-2B	1	152T-25	2	J1926-08-C5A	2	TMAU1063-12	1	ATKU12-1926
-14	J1926-142-125F	1-3/16-12 UN-2B	1	152T-28	2	J1926-08-C5A	2	TMAU1063-12	1	ATKU14-1926
-16	J1926-162-125F	1-5/16-12 UN-2B	1	152T-1.231	2	J1926-09-C5A	2	TMAU1063-12	1	ATKU16-1926
-20	J1926-203-150F	1-5/8-12 UN-2B	1	453T-39	1	J1926-10-C5A	2	TMAU1063-12	1	ATKU20-1926
-24	J1926-243-150F	1-7/8-12 UN-2B	1	453T-45.5	1	J1926-11-C5A	2	TMAU1063-12	1	ATKU24-1926
-32	J1926-324-150F	2-1/2-12 UN-2B	1	454T-61.5	1	J1926-12-C5A	2	TMAU1063-12	1	ATKU32-1926



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4 to -5	20	0.335	0.600	0.375	3.5	4	TMAU0438-20
-6	18	0.370	0.666	0.375	3.5	4	TMAU0563-18
-8	16	0.495	0.750	0.500	3.5	4	TMAU0750-16
-10	14	0.495	0.857	0.500	3.5	4	TMAU0875-14
-12 to -32	12	0.495	0.917	0.500	3.5	4	TMAU1063-12

AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE A5202 port form specifications.

Key on A92-1

A92: 30 - 37

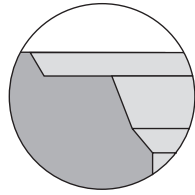
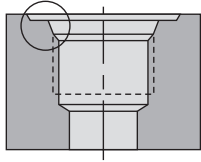
A92: 2 - 4

A92: 6 - 7

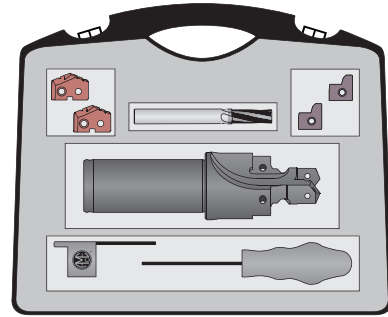
J  
A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

## Port and Thread Finishing Kits

J1926 | Metric | Ferrous Materials

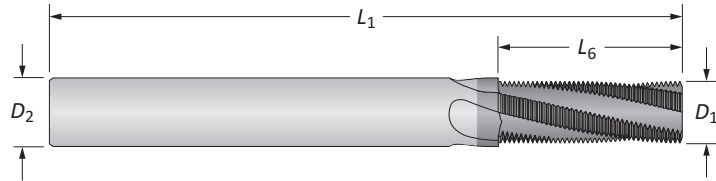


SAE J-1926-1 / ISO 11926-1



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			GEN2 T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (AM200®)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (AM210®)	Qty	
-4	J1926-04Y-16FM	7/16-20 UNF-2B	1	45YH-.386	2	J1926-02-C5A	2	TMAK0438-20M	1	ATKK04-1926M
-5	J1926-05Z-16FM	1/2-20 UNF-2B	1	45ZH-11.5	2	J1926-03-C5A	2	TMAK0438-20M	1	ATKK05-1926M
-6	J1926-060-20FM	9/16-18 UNF-2B	1	450H-13	2	J1926-03-C5A	2	TMAK0563-18M	1	ATKK06-1926M
-8	J1926-080-20FM	3/4-16 UNF-2B	1	450H-0022	2	J1926-07-C5A	2	TMAK0750-16M	1	ATKK08-1926M
-10	J1926-101-25FM	7/8-14 UNF-2B	1	451H-20.5	2	J1926-04-C5A	2	TMAK0875-14M	1	ATKK10-1926M
-12	J1926-122-32FM	1-1/16-12 UN-2B	1	452H-25	2	J1926-08-C5A	2	TMAK1063-12M	1	ATKK12-1926M
-14	J1926-142-32FM	1-3/16-12 UN-2B	1	452H-28	2	J1926-08-C5A	2	TMAK1063-12M	1	ATKK14-1926M
-16	J1926-162-32FM	1-5/16-12 UN-2B	1	452H-1.231	2	J1926-09-C5A	2	TMAK1063-12M	1	ATKK16-1926M
-20	J1926-203-32FM	1-5/8-12 UN-2B	1	453H-39	1	J1926-10-C5A	2	TMAK1063-12M	1	ATKK20-1926M
-24	J1926-243-32FM	1-7/8-12 UN-2B	1	453H-45.5	1	J1926-11-C5A	2	TMAK1063-12M	1	ATKK24-1926M
-32	J1926-324-32FM	2-1/2-12 UN-2B	1	454H-61.5	1	J1926-12-C5A	2	TMAK1063-12M	1	ATKK32-1926M



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4 to -5	20	8.51	15.24	10.00	73.00	4	TMAK0438-20M
-6	18	9.40	16.92	10.00	73.00	4	TMAK0563-18M
-8	16	11.94	19.05	12.00	84.00	4	TMAK0750-16M
-10	14	11.94	21.77	12.00	84.00	4	TMAK0875-14M
-12 to -32	12	11.94	23.29	12.00	84.00	4	TMAK1063-12M

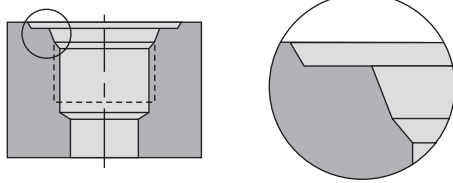
AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE AS5202 port form specifications.

A92: 30 - 37      A92: 2 - 4      A92: 8 - 9

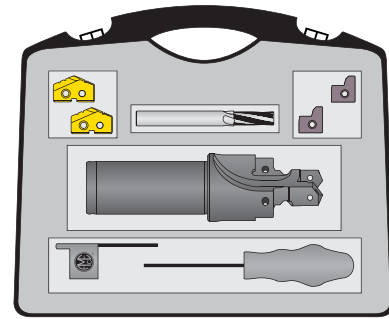


## Port and Thread Finishing Kits

J1926 | Metric | Non-Ferrous Materials

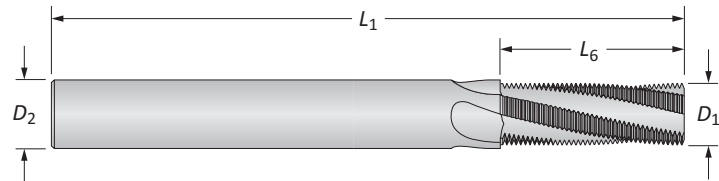


SAE J-1926-1 / ISO 11926-1



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			Original T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (TiN)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (Uncoated)	Qty	
-4	J1926-04Y-16FM	7/16-20 UNF-2B	1	15YT-.386	2	J1926-02-C5A	2	TMAU0438-20M	1	ATKU04-1926M
-5	J1926-05Z-16FM	1/2-20 UNF-2B	1	15ZT-11.5	2	J1926-03-C5A	2	TMAU0438-20M	1	ATKU05-1926M
-6	J1926-06O-20FM	9/16-18 UNF-2B	1	15OT-13	2	J1926-03-C5A	2	TMAU0563-18M	1	ATKU06-1926M
-8	J1926-08O-20FM	3/4-16 UNF-2B	1	15OT-0022	2	J1926-07-C5A	2	TMAU0750-16M	1	ATKU08-1926M
-10	J1926-10I-25FM	7/8-14 UNF-2B	1	15IT-20.5	2	J1926-04-C5A	2	TMAU0875-14M	1	ATKU10-1926M
-12	J1926-12Z-32FM	1-1/16-12 UN-2B	1	15ZT-25	2	J1926-08-C5A	2	TMAU1063-12M	1	ATKU12-1926M
-14	J1926-14Z-32FM	1-3/16-12 UN-2B	1	15ZT-28	2	J1926-08-C5A	2	TMAU1063-12M	1	ATKU14-1926M
-16	J1926-16Z-32FM	1-5/16-12 UN-2B	1	15ZT-1.231	2	J1926-09-C5A	2	TMAU1063-12M	1	ATKU16-1926M
-20	J1926-20Z-32FM	1-5/8-12 UN-2B	1	453T-39	1	J1926-10-C5A	2	TMAU1063-12M	1	ATKU20-1926M
-24	J1926-24Z-32FM	1-7/8-12 UN-2B	1	453T-45.5	1	J1926-11-C5A	2	TMAU1063-12M	1	ATKU24-1926M
-32	J1926-32Z-32FM	2-1/2-12 UN-2B	1	454T-61.5	1	J1926-12-C5A	2	TMAU1063-12M	1	ATKU32-1926M



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4 to -5	20	8.51	15.24	10.00	73.00	4	TMAU0438-20M
-6	18	9.40	16.92	10.00	73.00	4	TMAU0563-18M
-8	16	11.94	19.05	12.00	84.00	4	TMAU0750-16M
-10	14	11.94	21.77	12.00	84.00	4	TMAU0875-14M
-12 to -32	12	11.94	23.29	12.00	84.00	4	TMAU1063-12M

AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE A5202 port form specifications.

Key on A92-1

A92: 30 - 37

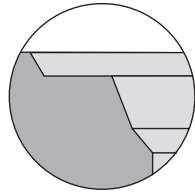
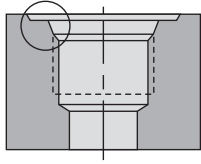
A92: 2 - 4

A92: 8 - 9

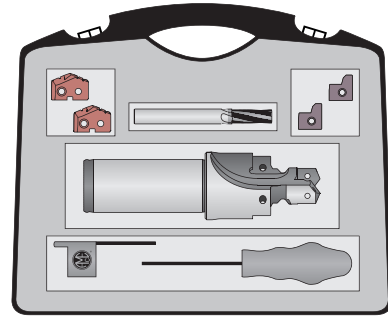
J  
 A DRILLING  
 B BORING  
 C REAMING  
 D BURNISHING  
 E THREADING  
 X SPECIALS

## Port and Thread Finishing Kits

I6149 | No ID Ridge | Ferrous Materials

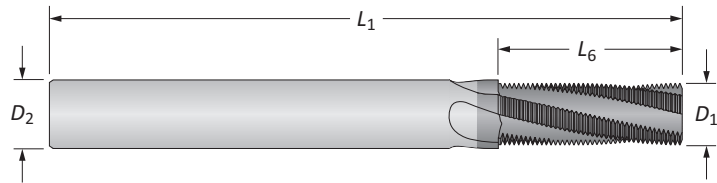


ISO 6149-1:2006 / SAE J-2244/1



### Port and Thread Finishing Kits

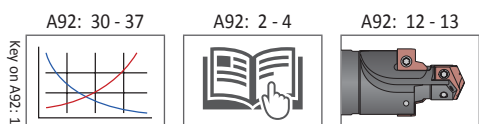
Tube Dash No.	AccuPort 432			GEN2 T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (AM200®)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (AM210®)	Qty	
-4	I6149-04RY-16FM	M12 X 1.5	1	45YH-10.5	2	I6149-04-C5A	2	TMMK1000-150M	1	ATKK04-6149
-5	I6149-05RZ-16FM	M14 X 1.5	1	45ZH-12.5	2	I6149-04-C5A	2	TMMK1400-150M	1	ATKK05-6149
-6	I6149-06RO-20FM	M16 X 1.5	1	45OH-14.5	2	I6149-06-C5A	2	TMMK1400-150M	1	ATKK06-6149
-8	I6149-08RO-20FM	M18 X 1.5	1	45OH-16.5	2	I6149-06-C5A	2	TMMK1800-150M	1	ATKK08-6149
-10	I6149-10R1-25FM	M22 X 1.5	1	451H-20.5	2	I6149-04-C5A	2	TMMK1800-150M	1	ATKK10-6149
-12	I6149-12R2-32FM	M27 X 2	1	452H-25	2	I6149-12-C5A	2	TMMK2000-200M	1	ATKK12-6149
-14	I6149-14R2-32FM	M30 X 2	1	452H-28	2	I6149-14-C5A	2	TMMK2000-200M	1	ATKK14-6149
-16	I6149-16R2-32FM	M33 X 2	1	452H-31	2	I6149-16-C5A	2	TMMK2000-200M	1	ATKK16-6149
-20	I6149-20R3-32FM	M42 X 2	1	453H-40	1	I6149-20-C5A	2	TMMK2000-200M	1	ATKK20-6149
-24	I6149-24R3-32FM	M48 X 2	1	453H-46	1	I6149-24-C5A	2	TMMK2000-200M	1	ATKK24-6149
-32	I6149-32R4-32FM	M60 X 2	1	454H-58	1	I6149-32-C5A	2	TMMK2000-200M	1	ATKK32-6149



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		$D_1$	$L_6$	$D_2$	$L_1$		
-4	1.50	7.40	19.50	8.00	64.00	4	TMMK1000-150M
-5 to -6	1.50	10.90	27.00	12.00	84.00	4	TMMK1400-150M
-8 to -10	1.50	11.90	31.50	12.00	84.00	4	TMMK1800-150M
-12 to -32	2.00	11.95	30.00	12.00	84.00	4	TMMK2000-200M

AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE AS5202 port form specifications.

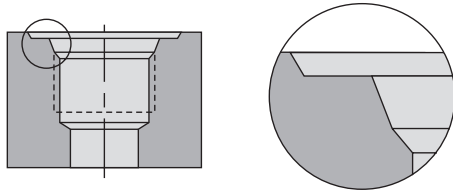




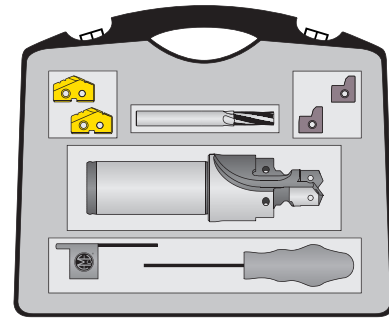


## Port and Thread Finishing Kits

I6149 | No ID Ridge | Non-Ferrous Materials

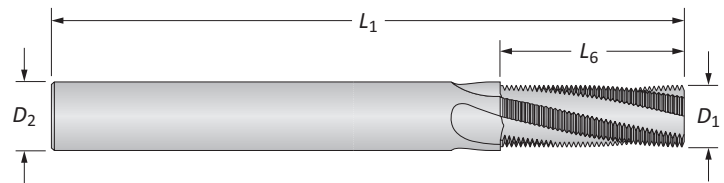


ISO 6149-1:2006 / SAE J-2244/1



### Port and Thread Finishing Kits

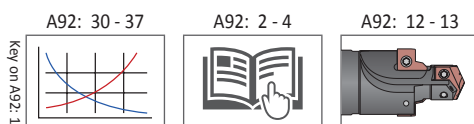
Tube Dash No.	AccuPort 432			Original T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (TiN)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (Uncoated)	Qty	
-4	I6149-04RY-16FM	M12 X 1.5	1	15YT-10.5	2	I6149-04-C5A	2	TMMU1000-150M	1	ATKU04-6149
-5	I6149-05RZ-16FM	M14 X 1.5	1	15ZT-12.5	2	I6149-04-C5A	2	TMMU1400-150M	1	ATKU05-6149
-6	I6149-06RO-20FM	M16 X 1.5	1	150T-14.5	2	I6149-06-C5A	2	TMMU1400-150M	1	ATKU06-6149
-8	I6149-08RO-20FM	M18 X 1.5	1	150T-16.5	2	I6149-06-C5A	2	TMMU1800-150M	1	ATKU08-6149
-10	I6149-10R1-25FM	M22 X 1.5	1	151T-20.5	2	I6149-04-C5A	2	TMMU1800-150M	1	ATKU10-6149
-12	I6149-12R2-32FM	M27 X 2	1	152T-25	2	I6149-12-C5A	2	TMMU2000-200M	1	ATKU12-6149
-14	I6149-14R2-32FM	M30 X 2	1	152T-28	2	I6149-14-C5A	2	TMMU2000-200M	1	ATKU14-6149
-16	I6149-16R2-32FM	M33 X 2	1	152T-31	2	I6149-16-C5A	2	TMMU2000-200M	1	ATKU16-6149
-20	I6149-20R3-32FM	M42 X 2	1	453T-40	1	I6149-20-C5A	2	TMMU2000-200M	1	ATKU20-6149
-24	I6149-24R3-32FM	M48 X 2	1	453T-46	1	I6149-24-C5A	2	TMMU2000-200M	1	ATKU24-6149
-32	I6149-32R4-32FM	M60 X 2	1	454T-58	1	I6149-32-C5A	2	TMMU2000-200M	1	ATKU32-6149



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4	1.50	7.40	19.50	8.00	64.00	4	TMMU1000-150M
-5 to -6	1.50	10.90	27.00	12.00	84.00	4	TMMU1400-150M
-8 to -10	1.50	11.90	31.50	12.00	84.00	4	TMMU1800-150M
-12 to -32	2.00	11.95	30.00	12.00	84.00	4	TMMU2000-200M

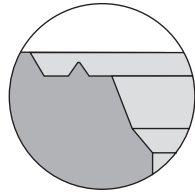
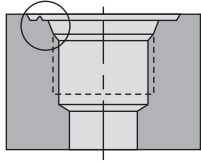
AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE A5202 port form specifications.



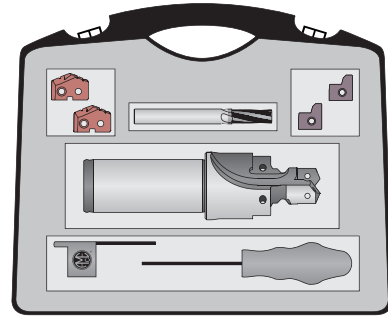
A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

## Port and Thread Finishing Kits

I6149 | ID Ridge | Ferrous Materials

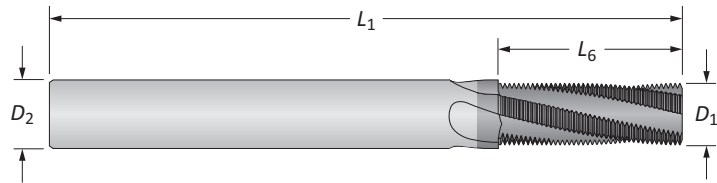


ISO 6149-1:2006 / SAE J-2244/1



### Port and Thread Finishing Kits

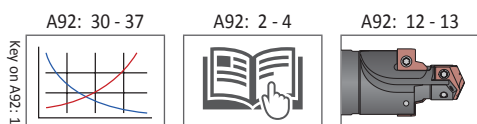
Tube Dash No.	AccuPort 432			GEN2 T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (AM200®)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (AM210®)	Qty	
-4	I6149-04RY-16FM	M12 X 1.5	1	45YH-10.5	2	I6149-04R-C5A	2	TMMK1000-150M	1	ATKK04R-6149
-5	I6149-05RZ-16FM	M14 X 1.5	1	45ZH-12.5	2	I6149-04R-C5A	2	TMMK1400-150M	1	ATKK05R-6149
-6	I6149-06R0-20FM	M16 X 1.5	1	450H-14.5	2	I6149-06R-C5A	2	TMMK1400-150M	1	ATKK06R-6149
-8	I6149-08R0-20FM	M18 X 1.5	1	450H-16.5	2	I6149-06R-C5A	2	TMMK1800-150M	1	ATKK08R-6149
-10	I6149-10R1-25FM	M22 X 1.5	1	451H-20.5	2	I6149-04R-C5A	2	TMMK1800-150M	1	ATKK10R-6149
-12	I6149-12R2-32FM	M27 X 2	1	452H-25	2	I6149-12R-C5A	2	TMMK2000-200M	1	ATKK12R-6149
-14	I6149-14R2-32FM	M30 X 2	1	452H-28	2	I6149-14R-C5A	2	TMMK2000-200M	1	ATKK14R-6149
-16	I6149-16R2-32FM	M33 X 2	1	452H-31	2	I6149-16R-C5A	2	TMMK2000-200M	1	ATKK16R-6149
-20	I6149-20R3-32FM	M42 X 2	1	453H-40	1	I6149-20R-C5A	2	TMMK2000-200M	1	ATKK20R-6149
-24	I6149-24R3-32FM	M48 X 2	1	453H-46	1	I6149-24R-C5A	2	TMMK2000-200M	1	ATKK24R-6149
-32	I6149-32R4-32FM	M60 X 2	1	454H-58	1	I6149-32R-C5A	2	TMMK2000-200M	1	ATKK32R-6149



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		$D_1$	$L_6$	$D_2$	$L_1$		
-4	1.50	7.40	19.50	8.00	64.00	4	TMMK1000-150M
-5 to -6	1.50	10.90	27.00	12.00	84.00	4	TMMK1400-150M
-8 to -10	1.50	11.90	31.50	12.00	84.00	4	TMMK1800-150M
-12 to -32	2.00	11.95	30.00	12.00	84.00	4	TMMK2000-200M

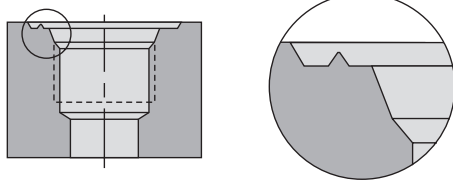
AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE AS5202 port form specifications.



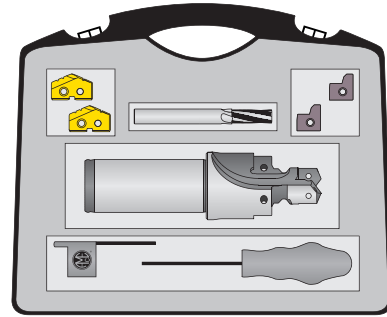


## Port and Thread Finishing Kits

I6149 | ID Ridge | Non-Ferrous Materials

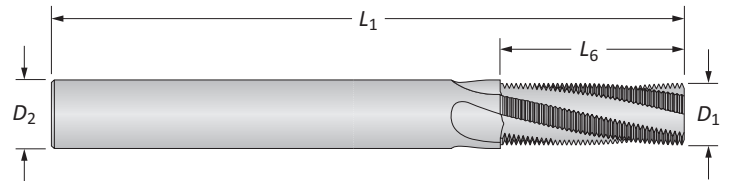


ISO 6149-1:2006 / SAE J-2244/1



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			Original T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (TiN)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (Uncoated)	Qty	
-4	I6149-04RY-16FM	M12 X 1.5	1	15YT-10.5	2	I6149-04R-C5A	2	TMMU1000-150M	1	ATKU04R-6149
-5	I6149-05RZ-16FM	M14 X 1.5	1	15ZT-12.5	2	I6149-04R-C5A	2	TMMU1400-150M	1	ATKU05R-6149
-6	I6149-06RO-20FM	M16 X 1.5	1	15OT-14.5	2	I6149-06R-C5A	2	TMMU1400-150M	1	ATKU06R-6149
-8	I6149-08RO-20FM	M18 X 1.5	1	15OT-16.5	2	I6149-06R-C5A	2	TMMU1800-150M	1	ATKU08R-6149
-10	I6149-10R1-25FM	M22 X 1.5	1	151T-20.5	2	I6149-04R-C5A	2	TMMU1800-150M	1	ATKU10R-6149
-12	I6149-12R2-32FM	M27 X 2	1	152T-25	2	I6149-12R-C5A	2	TMMU2000-200M	1	ATKU12R-6149
-14	I6149-14R2-32FM	M30 X 2	1	152T-28	2	I6149-14R-C5A	2	TMMU2000-200M	1	ATKU14R-6149
-16	I6149-16R2-32FM	M33 X 2	1	152T-31	2	I6149-16R-C5A	2	TMMU2000-200M	1	ATKU16R-6149
-20	I6149-20R3-32FM	M42 X 2	1	453T-40	1	I6149-20R-C5A	2	TMMU2000-200M	1	ATKU20R-6149
-24	I6149-24R3-32FM	M48 X 2	1	453T-46	1	I6149-24R-C5A	2	TMMU2000-200M	1	ATKU24R-6149
-32	I6149-32R4-32FM	M60 X 2	1	454T-58	1	I6149-32R-C5A	2	TMMU2000-200M	1	ATKU32R-6149



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4	1.50	7.40	19.50	8.00	64.00	4	TMMU1000-150M
-5 to -6	1.50	10.90	27.00	12.00	84.00	4	TMMU1400-150M
-8 to -10	1.50	11.90	31.50	12.00	84.00	4	TMMU1800-150M
-12 to -32	2.00	11.95	30.00	12.00	84.00	4	TMMU2000-200M

AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE A5202 port form specifications.

Key on A92: 1

A92: 30 - 37

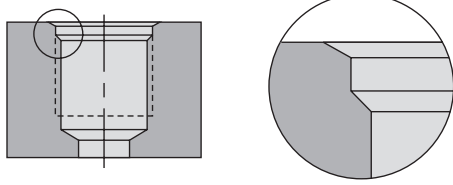
A92: 2 - 4

A92: 12 - 13

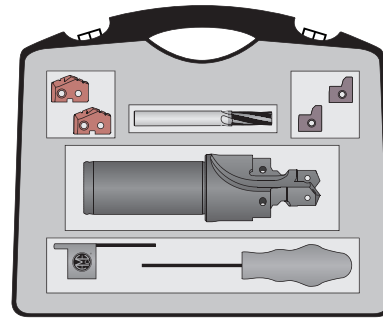
A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

## Port and Thread Finishing Kits

AS5202 | Ferrous Materials

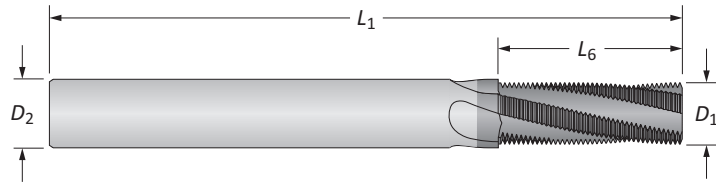


SAE AS5202



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			GEN2 T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (AM200®)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (AM210®)	Qty	
-4	AS5202-04Y-063F	7/16-20 UNJF-3B	1	45YH-.390	2	AS5202-04-C5A	2	TMAK0438-20	1	ATKK04-5202
-5	AS5202-05Z-063F	1/2-20 UNJF-3B	1	45ZH-11.5	2	AS5202-05-C5A	2	TMAK0438-20	1	ATKK05-5202
-6	AS5202-06Z-075F	9/16-18 UNJF-3B	1	45ZH-.510	2	AS5202-06-C5A	2	TMAK0563-18	1	ATKK06-5202
-8	AS5202-080-075F	3/4-16 UNJF-3B	1	450H-17.5	2	AS5202-08-C5A	2	TMAK0750-16	1	ATKK08-5202
-10	AS5202-101-100F	7/8-14 UNJF-3B	1	451H-20.5	2	AS5202-10-C5A	2	TMAK0875-14	1	ATKK10-5202
-12	AS5202-122-125F	1-1/16-12 UNJ-3B	1	452H-25	2	AS5202-12-C5A	2	TMAK1063-12	1	ATKK12-5202
-14	AS5202-142-125F	1-3/16-12 UNJ-3B	1	452H-1.109	2	AS5202-14-C5A	2	TMAK1063-12	1	ATKK14-5202
-16	AS5202-162-125F	1-5/16-12 UNJ-3B	1	452H-1.234	2	AS5202-16-C5A	2	TMAK1063-12	1	ATKK16-5202
-20	AS5202-203-150F	1-5/8-12 UNJ-3B	1	453H-1.547	1	AS5202-20-C5A	2	TMAK1063-12	1	ATKK20-5202
-24	AS5202-243-150F	1-7/8-12 UNJ-3B	1	453H-1.797	1	AS5202-24-C5A	2	TMAK1063-12	1	ATKK24-5202
-32	AS5202-324-150F	2-1/2-12 UNJ-3B	1	454H-61.5	1	AS5202-32-C5A	2	TMAK1063-12	1	ATKK32-5202



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4 to -5	20	0.335	0.600	0.375	3.5	4	TMAK0438-20
-6	18	0.370	0.666	0.375	3.5	4	TMAK0563-18
-8	16	0.495	0.750	0.500	3.5	4	TMAK0750-16
-10	14	0.495	0.857	0.500	3.5	4	TMAK0875-14
-12 to -32	12	0.495	0.917	0.500	3.5	4	TMAK1063-12

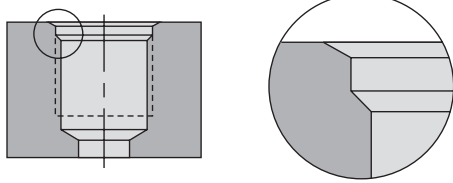
AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE AS5202 port form specifications.

A92: 30 - 37      A92: 2 - 4      A92: 14 - 15

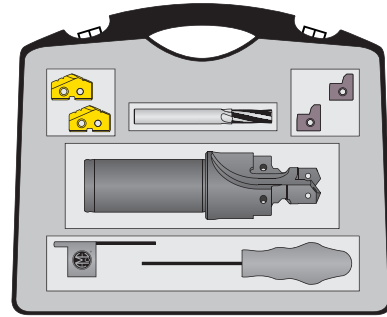


## Port and Thread Finishing Kits

AS5202 | Non-Ferrous Materials

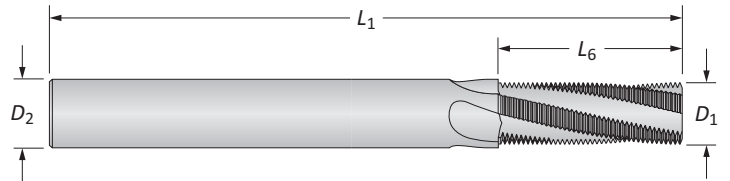


SAE AS5202



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			Original T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (TiN)	Qty	C5 Carbide (TiAlN)	Qty	Part No. (Uncoated)	Qty	
-4	AS5202-04Y-063F	7/16-20 UNJF-3B	1	15YT-.390	2	AS5202-04-C5A	2	TMAU0438-20	1	ATKU04-5202
-5	AS5202-05Z-063F	1/2-20 UNJF-3B	1	15ZT-11.5	2	AS5202-05-C5A	2	TMAU0438-20	1	ATKU05-5202
-6	AS5202-06Z-075F	9/16-18 UNJF-3B	1	15ZT-.510	2	AS5202-06-C5A	2	TMAU0563-18	1	ATKU06-5202
-8	AS5202-080-075F	3/4-16 UNJF-3B	1	150T-17.5	2	AS5202-08-C5A	2	TMAU0750-16	1	ATKU08-5202
-10	AS5202-101-100F	7/8-14 UNJF-3B	1	151T-20.5	2	AS5202-10-C5A	2	TMAU0875-14	1	ATKU10-5202
-12	AS5202-122-125F	1-1/16-12 UNJ-3B	1	152T-25	2	AS5202-12-C5A	2	TMAU1063-12	1	ATKU12-5202
-14	AS5202-142-125F	1-3/16-12 UNJ-3B	1	152T-1.109	2	AS5202-14-C5A	2	TMAU1063-12	1	ATKU14-5202
-16	AS5202-162-125F	1-5/16-12 UNJ-3B	1	152T-1.234	2	AS5202-16-C5A	2	TMAU1063-12	1	ATKU16-5202
-20	AS5202-203-150F	1-5/8-12 UNJ-3B	1	453T-1.547	1	AS5202-20-C5A	2	TMAU1063-12	1	ATKU20-5202
-24	AS5202-243-150F	1-7/8-12 UNJ-3B	1	453T-1.797	1	AS5202-24-C5A	2	TMAU1063-12	1	ATKU24-5202
-32	AS5202-324-150F	2-1/2-12 UNJ-3B	1	454T-61.5	1	AS5202-32-C5A	2	TMAU1063-12	1	ATKU32-5202



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		D <sub>1</sub>	L <sub>6</sub>	D <sub>2</sub>	L <sub>1</sub>		
-4 to -5	20	0.335	0.600	0.375	3.5	4	TMAU0438-20
-6	18	0.370	0.666	0.375	3.5	4	TMAU0563-18
-8	16	0.495	0.750	0.500	3.5	4	TMAU0750-16
-10	14	0.495	0.857	0.500	3.5	4	TMAU0875-14
-12 to -32	12	0.495	0.917	0.500	3.5	4	TMAU1063-12

AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE AS5202 port form specifications.

A92: 30 - 37

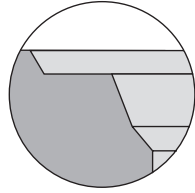
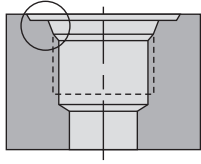
A92: 2 - 4

A92: 14 - 15

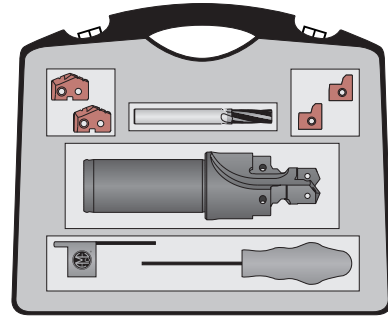
Key on A92: 1

## Port and Thread Finishing Kits

G1731 | Ferrous Materials

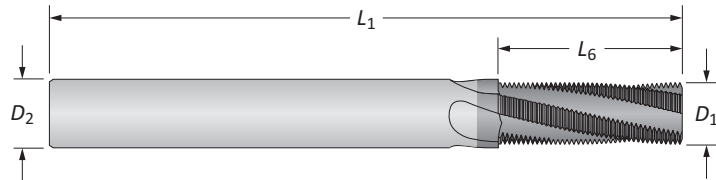


JDS-G173.1



### Port and Thread Finishing Kits

Tube Dash No.	AccuPort 432			GEN2 T-A® Insert		Port Form Insert		AccuThread™ Thread Mill		Kit Part No.
	Part No.	Port Thread Size	Qty	Super Cobalt (AM200®)	Qty	C3 Carbide (AM200®)	Qty	Part No. (AM210®)	Qty	
-4	G1731-04Y-16FM	M12 X 1.5	1	45YH-10.5	2	G1731-01-C3H	2	TMMK1000-150M	1	ATKK04-G1731
-5	G1731-05Z-16FM	M14 X 1.5	1	45ZH-12.5	2	G1731-01-C3H	2	TMMK1400-150M	1	ATKK05-G1731
-6	G1731-06O-20FM	M16 X 1.5	1	45OH-14.5	2	G1731-02-C3H	2	TMMK1400-150M	1	ATKK06-G1731
-8	G1731-08O-20FM	M18 X 1.5	1	45OH-16.5	2	G1731-02-C3H	2	TMMK1800-150M	1	ATKK08-G1731
-10	G1731-10I-25FM	M22 X 1.5	1	45IH-20.5	2	G1731-02-C3H	2	TMMK1800-150M	1	ATKK10-G1731
-12	G1731-12Z-32FM	M27 X 2	1	45ZH-25	2	G1731-03-C3H	2	TMMK2000-200M	1	ATKK12-G1731
-14	G1731-14Z-32FM	M30 X 2	1	45ZH-28	2	G1731-03-C3H	2	TMMK2000-200M	1	ATKK14-G1731
-16	G1731-16Z-32FM	M33 X 2	1	45ZH-31	2	G1731-04-C3H	2	TMMK2000-200M	1	ATKK16-G1731
-18	G1731-18Z-32FM	M38 X 2	1	45ZH-36	1	G1731-04-C3H	2	TMMK2000-200M	2	ATKK18-G1731
-20	G1731-20Z-32FM	M42 X 2	1	45ZH-40	1	G1731-05-C3H	2	TMMK2000-200M	1	ATKK20-G1731
-24	G1731-24Z-32FM	M48 X 2	1	45ZH-46	1	G1731-05-C3H	2	TMMK2000-200M	1	ATKK24-G1731
-32	G1731-32Z-32FM	M60 X 2	1	45ZH-58	1	G1731-06-C3H	2	TMMK2000-200M	1	ATKK32-G1731



### AccuThread™ Port Specific Solid Carbide Thread Mills

Port Size	Pitch	Thread Mill				Flutes	Part No.
		$D_1$	$L_6$	$D_2$	$L_1$		
-4	1.50	7.40	19.50	8.00	64.00	4	TMMK1000-150M
-5 to -6	1.50	10.90	27.00	12.00	84.00	4	TMMK1400-150M
-8 to -10	1.50	11.90	31.50	12.00	84.00	4	TMMK1800-150M
-12 to -32	2.00	11.95	30.00	12.00	84.00	4	TMMK2000-200M

AccuPort 432 specific thread mills - International Unified Series (UN) manufactured specifically for use with AccuPort 432 hydraulic port forms. The length of cut allows full thread with one pass. Conforms with J1926 and SAE AS5202 port form specifications.

A92: 30 - 37      A92: 2 - 4      A92: 16 - 17

Key on A92: 1



## Recommended Drilling Data | Imperial (inch)

HSS

ISO	Material	Hardness (BHN)	Grade	Speed (SFM)				Feed Rate (IPR) by Tube Size and T-A® Insert Series					
				TiN	TiAlN	TiCN	AM200®	Tube No. 4 - 5	Tube No. 6 - 8	Tube No. 10	Tube No. 12 - 16	Tube No. 20 - 24	Tube No. 32
								T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3	T-A Series 4
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 150	HSS	200	280	260	325	0.007	0.010	0.013	0.016	0.020	0.023
		150 - 200	HSS	180	260	235	300	0.007	0.010	0.013	0.016	0.020	0.023
		200 - 250	HSS	160	240	210	280	0.006	0.010	0.013	0.016	0.020	0.023
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 125	HSS	170	250	220	290	0.006 ❖	0.009	0.012	0.015	0.019	0.023
		125 - 175	HSS	160	240	210	275	0.006 ❖	0.009	0.012	0.015	0.019	0.023
		175 - 225	HSS	150	225	195	260	0.005 ❖	0.008	0.010	0.014	0.018	0.021
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 175	HSS	160	240	210	275	0.006	0.009	0.012	0.015	0.019	0.023
		175 - 225	HSS	150	225	195	260	0.005	0.008	0.010	0.014	0.018	0.021
		225 - 275	HSS	140	210	180	240	0.005	0.008	0.010	0.014	0.018	0.021
	Alloy Steel 4140, 5140, 8640, etc.	125 - 175	HSS	150	210	195	240	0.006	0.008	0.010	0.014	0.017	0.019
		175 - 225	HSS	140	195	180	225	0.005	0.008	0.010	0.014	0.017	0.019
		225 - 275	HSS	130	180	170	210	0.005	0.007	0.010	0.014	0.017	0.019
		275 - 325	SC	120	170	155	195	0.004	0.006	0.009	0.012	0.015	0.017
	High Strength Alloy 4340, 4330V, 300M, etc.	325 - 375	SC	110	155	145	180	0.003	0.006	0.009	0.012	0.015	0.017
		225 - 300	SC	80	110	100	125	0.005 ❖	0.007	0.009	0.010	0.014	0.017
		300 - 350	SC	60	85	80	100	0.004 ❖	0.007	0.009	0.010	0.014	0.017
	Structural Steel A36, A285, A516, etc.	350 - 400	SC	50	70	65	80	0.003 ❖	0.006	0.008	0.009	0.012	0.015
		100 - 150	HSS	140	200	180	235	0.006 ❖	0.010	0.012	0.014	0.018	0.021
150 - 250		HSS	120	170	155	190	0.005 ❖	0.009	0.010	0.012	0.016	0.019	
Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	250 - 350	SC	100	140	130	160	0.004 ❖	0.009	0.009	0.010	0.014	0.017	
	150 - 200	SC	80	110	105	125	0.004 ❖	0.006	0.008	0.010	0.014	0.015	
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	200 - 250	SC	60	90	85	105	0.004 ❖	0.006	0.008	0.010	0.012	0.015
		140 - 220	SC	30	40	35	45	0.003 ❖	0.007	0.008	0.010	0.012	0.015
M	Stainless Steel 400 Series 416, 420, 303, etc.	220 - 310	SC	25	35	30	40	0.003 ❖	0.006	0.007	0.008	0.010	0.012
		185 - 275	SC	75	105	95	110	0.006 ❖	0.008	0.009	0.011	0.012	0.016
K	Nodular, Grey, Ductile Cast Iron	275 - 350	SC	60	90	80	100	0.005 ❖	0.007	0.008	0.010	0.012	0.014
		120 - 150	HSS	170	250	220	290	0.007	0.012	0.016	0.020	0.024	0.027
		150 - 200	HSS	150	225	195	260	0.006	0.011	0.014	0.018	0.022	0.025
		200 - 220	HSS	130	195	170	225	0.006	0.009	0.012	0.016	0.018	0.021
		220 - 260	SC	110	165	145	190	0.005	0.007	0.009	0.012	0.014	0.017
260 - 320	SC	90	135	120	155	0.004	0.006	0.007	0.009	0.012	0.014		
N	Aluminum	30	HSS	600	850	750	-	0.008	0.013	0.016	0.020	0.022	0.025
		180	HSS	300	450	400	-	0.008	0.013	0.016	0.018	0.022	0.025

### Formulas

<p>1. <b>RPM = (3.82 • SFM) / DIA</b></p> <p>where:</p> <p>RPM = revolutions per minute (rev/min)</p> <p>SFM = speed (ft/min)</p> <p>DIA = finish diameter of drill (inch)</p>	<p>2. <b>SFM = RPM • 0.262 • DIA</b></p> <p>where:</p> <p>SFM = speed (ft/min)</p> <p>RPM = revolutions per minute (rev/min)</p> <p>DIA = diameter of drill (inch)</p>	<p>3. <b>IPM = RPM • IPR</b></p> <p>where:</p> <p>IPM = Feed rate</p> <p>RPM = revolutions per minute (rev/min)</p> <p>IPR = feed rate (in/rev)</p>
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**IMPORTANT:** The speeds and feeds listed above are a general starting point for all applications. Refer to the Coolant Recommendation charts for coolant requirements to run at the recommended speeds and feeds. Factory technical assistance is also available through our Application Engineering Team. Due to potential chip formation issues, contact our Application Engineering Team for assistance machining materials marked with a ❖.



## Coolant Recommendations | Imperial (inch)

HSS

ISO	Material	Pressure / Flow Rate	Tube No. 4 - 5	Tube No. 6 - 8	Tube No. 10	Tube No. 12 - 16	Tube No. 20 - 24	Tube No. 32
			T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3	T-A Series 4
P	<b>Free Machining Steel</b> 1118, 1215, 12L14, etc.	PSI	175 - 185	100 - 120	105 - 140	80 - 115	75 - 100	40 - 50
		GPM	2.5 - 2.6	2.8 - 3.0	4.4 - 5.2	7 - 8	12 - 14	30 - 33
	<b>Low Carbon Steel</b> 1010, 1020, 1025, 1522, 1144, etc.	PSI	165 - 170	75 - 90	75 - 95	60 - 80	55 - 75	30 - 40
		GPM	2.4 - 2.5	2.4 - 2.6	3.7 - 4.2	6 - 7	11 - 12	26 - 30
	<b>Medium Carbon Steel</b> 1030, 1040, 1050, 1527, 1140, 1151, etc.	PSI	160 - 165	70 - 85	70 - 90	55 - 75	50 - 70	30 - 40
		GPM	2.3 - 2.4	2.3 - 2.6	3.7 - 4.2	5 - 6	10 - 12	26 - 30
	<b>Alloy Steel</b> 4140, 5140, 8640, etc.	PSI	160 - 165	65 - 75	65 - 80	50 - 70	45 - 60	30 - 35
		GPM	2.3 - 2.4	2.2 - 2.4	3.5 - 3.9	5 - 6	10 - 11	26 - 28
	<b>High Strength Alloy</b> 4340, 4330V, 300M, etc.	PSI	150 - 155	55 - 60	45 - 50	25 - 30	25 - 30	20 - 25
		GPM	2.3 - 2.4	2.1 - 2.2	2.9 - 3.1	4 - 5	7 - 8	21 - 23
	<b>Structural Steel</b> A36, A285, A516, etc.	PSI	160 - 165	75 - 85	65 - 80	40 - 55	40 - 50	25 - 30
		GPM	2.3 - 2.4	2.4 - 2.6	3.5 - 3.9	5 - 6	9 - 10	23 - 26
	<b>Tool Steel</b> H-13, H-21, A-4, O-2, S-3, etc.	PSI	150 - 155	55 - 60	45 - 50	25 - 30	25 - 30	20 - 25
		GPM	2.3 - 2.4	2.1 - 2.2	2.9 - 3.1	4 - 5	7 - 8	21 - 23
S	<b>High Temp Alloy</b> Hastelloy B, Inconel 600, etc.	PSI	150 - 155	60 - 65	50 - 55	30 - 35	25 - 30	25 - 30
		GPM	2.3 - 2.4	2.2 - 2.3	3.1 - 3.2	4 - 5	7 - 8	23 - 26
M	<b>Stainless Steel 400 Series</b> 416, 420, 303, etc.	PSI	171	86	75	55	51	29
		GPM	3	3	4	6	10	26
K	<b>Nodular, Grey, Ductile Cast Iron</b>	PSI	160	65	61	41	35	29
		GPM	2	2	3	5	9	26
N	<b>Aluminum</b>	PSI	210	180	230	159	125	51
		GPM	3	4	6	9	16	33

**IMPORTANT:** The coolant pressure and flow rate recommendations above represent a good approximation to obtain optimum tool life and chip evacuation at Allied's recommended speeds and feeds. If lower coolant capabilities exist in a drilling application, the AccuPort 432 Port Contour Cutter will still function at reduced penetration rates. Contact our Application Engineering Department for a more specific recommendation of coolant requirements and/or speeds and feeds.

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

## Recommended Drilling Data | Imperial (inch)

Carbide

ISO	Material	Hardness (BHN)	Grade	Speed (SFM)			Feed Rate (IPR) by Tube Size and T-A® Insert Series				
				TiN	TiAlN	AM200®	Tube No. 4 - 5	Tube No. 6 - 8	Tube No. 10	Tube No. 12 - 16	Tube No. 20 - 24
							T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 150	C1, C5	320	420	480	0.008	0.012	0.015	0.018	0.021
		150 - 200	C1, C5	280	360	415	0.007	0.011	0.014	0.016	0.019
		200 - 250	C1, C5	260	340	390	0.006	0.010	0.013	0.015	0.017
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 125	C1, C5	300	390	450	0.008 ❖	0.010	0.013	0.017	0.019
		125 - 175	C1, C5	260	340	390	0.007 ❖	0.010	0.013	0.016	0.018
		175 - 225	C1, C5	240	310	355	0.006 ❖	0.009	0.012	0.015	0.017
		225 - 275	C1, C5	210	270	310	0.005 ❖	0.009	0.012	0.015	0.017
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 175	C1, C5	260	340	390	0.007	0.010	0.013	0.016	0.018
		175 - 225	C1, C5	240	310	355	0.006	0.009	0.012	0.015	0.017
		225 - 275	C1, C5	210	270	310	0.006	0.009	0.012	0.015	0.017
		275 - 325	C1, C5	180	230	265	0.005	0.008	0.011	0.014	0.016
	Alloy Steel 4140, 5140, 8640, etc.	125 - 175	C1, C5	250	325	375	0.007	0.010	0.013	0.016	0.018
		175 - 225	C1, C5	230	300	345	0.006	0.009	0.012	0.015	0.017
		225 - 275	C1, C5	210	270	310	0.006	0.009	0.012	0.015	0.017
		275 - 325	C1, C5	200	250	285	0.005	0.008	0.011	0.014	0.016
		325 - 375	C1, C5	170	220	255	0.004	0.007	0.010	0.013	0.015
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 300	C1, C5	160	200	230	0.006 ❖	0.009	0.010	0.012	0.015
		300 - 350	C1, C5	140	180	205	0.005 ❖	0.008	0.009	0.011	0.014
		350 - 400	C1, C5	120	160	185	0.004 ❖	0.007	0.008	0.010	0.012
	Structural Steel A36, A285, A516, etc.	100 - 150	C1, C5	240	310	355	0.008 ❖	0.011	0.014	0.016	0.018
150 - 250		C1, C5	200	250	285	0.006 ❖	0.010	0.012	0.014	0.016	
250 - 350		C1, C5	180	230	265	0.005 ❖	0.009	0.011	0.012	0.014	
Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 200	C1, C5	160	220	255	0.004 ❖	0.007	0.009	0.011	0.013	
	200 - 250	C1, C5	120	170	195	0.004 ❖	0.007	0.009	0.011	0.013	
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 220	C2	80	105	120	0.004 ❖	0.007	0.009	0.011	0.013
		220 - 310	C2	60	85	95	0.004 ❖	0.006	0.008	0.010	0.012
M	Stainless Steel 400 Series 416, 420, 303, etc.	185 - 275	C2	160	210	240	0.007 ❖	0.009	0.012	0.014	0.016
		275 - 350	C2	120	160	185	0.006 ❖	0.008	0.011	0.012	0.014
K	Nodular, Grey, Ductile Cast Iron	120 - 150	C2, C3	320	460	500	0.008	0.012	0.015	0.019	0.023
		150 - 200	C2, C3	270	400	480	0.007	0.011	0.013	0.017	0.021
		200 - 220	C2, C3	240	360	430	0.006	0.009	0.012	0.015	0.018
		220 - 260	C2, C3	210	310	370	0.005	0.008	0.011	0.013	0.015
		260 - 320	C2, C3	180	270	335	0.005	0.007	0.010	0.011	0.013
N	Aluminum	30	C2	1200	1500	-	0.010	0.015	0.018	0.020	0.022
		180	C2	800	1000	-	0.009	0.013	0.016	0.018	0.020

### Formulas

<p>1. <b>RPM = (3.82 • SFM) / DIA</b></p> <p>where:</p> <p>RPM = revolutions per minute (rev/min)</p> <p>SFM = speed (ft/min)</p> <p>DIA = finish diameter of drill (inch)</p>	<p>2. <b>SFM = RPM • 0.262 • DIA</b></p> <p>where:</p> <p>SFM = speed (ft/min)</p> <p>RPM = revolutions per minute (rev/min)</p> <p>DIA = diameter of drill (inch)</p>	<p>3. <b>IPM = RPM • IPR</b></p> <p>where:</p> <p>IPM = Feed rate</p> <p>RPM = revolutions per minute (rev/min)</p> <p>IPR = feed rate (in/rev)</p>
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## Coolant Recommendations | Imperial (inch)

Carbide

ISO	Material	Pressure / Flow Rate	Tube No.	Tube No.	Tube No.	Tube No.	Tube No.
			4 - 5	6 - 8	10	12 - 16	20 - 24
			T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3
P	<b>Free Machining Steel</b> 1118, 1215, 12L14, etc.	PSI	195	140	160	140	155
		GPM	2.6	3.3	5.5	9	18
	<b>Low Carbon Steel</b> 1010, 1020, 1025, 1522, 1144, etc.	PSI	180	105	105	110	115
		GPM	2.5	2.9	4.4	8	15
	<b>Medium Carbon Steel</b> 1030, 1040, 1050, 1527, 1140, 1151, etc.	PSI	175	100	90	100	75
		GPM	2.5	2.8	4.1	7	13
	<b>Alloy Steel</b> 4140, 5140, 8640, etc.	PSI	165	85	100	75	70
		GPM	2.4	2.6	4.3	6	12
	<b>High Strength Alloy</b> 4340, 4330V, 300M, etc.	PSI	160	65	55	40	35
		GPM	2.4	2.3	3.2	5	8
	<b>Structural Steel</b> A36, A285, A516, etc.	PSI	175	115	105	75	70
		GPM	2.5	3	4.4	6	12
	<b>Tool Steel</b> H-13, H-21, A-4, O-2, S-3, etc.	PSI	155	60	55	40	35
		GPM	2.4	2.2	3.2	5	8
S	<b>High Temp Alloy</b> Hastelloy B, Inconel 600, etc.	PSI	150 - 155	60 - 65	50 - 55	30 - 35	25 - 30
		GPM	2.3 - 2.4	2.2 - 2.3	3.1 - 3.2	4 - 5	7 - 8
M	<b>Stainless Steel 400 Series</b> 416, 420, 303, etc.	PSI	329	239	260	250	190
		GPM	3	4	7	12	20
K	<b>Nodular, Grey, Ductile Cast Iron</b>	PSI	225	104	90	90	80
		GPM	3	3	4	7	13
N	<b>Aluminum</b>	PSI	350	319	315	284	200
		GPM	4	5	8	12	20

**IMPORTANT:** The coolant pressure and flow rate recommendations above represent a good approximation to obtain optimum tool life and chip evacuation at Allied's recommended speeds and feeds. If lower coolant capabilities exist in a drilling application, the AccuPort 432 Port Contour Cutter will still function at reduced penetration rates. Contact our Application Engineering Department for a more specific recommendation of coolant requirements and/or speeds and feeds.

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

## Recommended Drilling Data | Metric (mm)

HSS

ISO	Material	Hardness (BHN)	Grade	Speed (M/min)				Feed Rate (mm/rev) by Tube Size and T-A® Insert Series					
				TiN	TiAlN	TiCN	AM200®	Tube No. 4 - 5	Tube No. 6 - 8	Tube No. 10	Tube No. 12 - 16	Tube No. 20 - 24	Tube No. 32
								T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3	T-A Series 4
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 150	HSS	61	85	79	92	0.18	0.25	0.33	0.41	0.51	0.58
		150 - 200	HSS	55	79	72	87	0.18	0.25	0.33	0.41	0.51	0.58
		200 - 250	HSS	49	73	64	81	0.15	0.25	0.33	0.41	0.51	0.58
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 125	HSS	52	76	67	84	0.15 ❖	0.23	0.30	0.38	0.48	0.58
		125 - 175	HSS	49	73	64	81	0.15 ❖	0.23	0.30	0.38	0.48	0.58
		175 - 225	HSS	46	69	59	76	0.13 ❖	0.20	0.25	0.36	0.46	0.53
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 175	HSS	49	73	64	79	0.15	0.23	0.30	0.38	0.48	0.58
		175 - 225	HSS	46	69	59	75	0.13	0.20	0.25	0.36	0.46	0.53
		225 - 275	HSS	43	64	55	70	0.13	0.20	0.25	0.36	0.46	0.53
	Alloy Steel 4140, 5140, 8640, etc.	125 - 175	HSS	46	64	59	69	0.15	0.20	0.25	0.36	0.43	0.48
		175 - 225	HSS	43	59	55	66	0.13	0.20	0.25	0.36	0.43	0.48
		225 - 275	HSS	40	55	52	60	0.13	0.18	0.25	0.36	0.43	0.48
		275 - 325	SC	37	52	47	56	0.10	0.15	0.23	0.30	0.38	0.43
	High Strength Alloy 4340, 4330V, 300M, etc.	325 - 375	SC	34	47	44	55	0.08	0.15	0.23	0.30	0.38	0.43
		225 - 300	SC	24	34	30	37	0.13 ❖	0.18	0.23	0.25	0.36	0.43
		300 - 350	SC	18	26	24	27	0.10 ❖	0.18	0.23	0.25	0.36	0.43
	Structural Steel A36, A285, A516, etc.	350 - 400	SC	15	21	20	23	0.08 ❖	0.15	0.20	0.23	0.30	0.38
		100 - 150	HSS	43	61	55	67	0.15 ❖	0.25	0.30	0.36	0.46	0.53
150 - 250		HSS	37	52	47	56	0.13 ❖	0.23	0.25	0.30	0.41	0.48	
Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	250 - 350	SC	30	43	40	47	0.10 ❖	0.20	0.23	0.25	0.36	0.43	
	150 - 200	SC	24	34	32	37	0.10	0.15	0.20	0.25	0.30	0.38	
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	200 - 250	SC	18	27	26	31	0.10	0.15	0.20	0.25	0.30	0.38
		140 - 220	SC	30	40	35	45	0.08 ❖	0.18	0.20	0.25	0.30	0.38
M	Stainless Steel 400 Series 416, 420, 303, etc.	220 - 310	SC	25	35	30	40	0.08 ❖	0.15	0.18	0.20	0.25	0.30
		185 - 275	SC	23	32	29	33	0.15 ❖	0.20	0.23	0.28	0.36	0.41
K	Nodular, Grey, Ductile Cast Iron	275 - 350	SC	18	27	24	29	0.13 ❖	0.18	0.20	0.25	0.30	0.36
		120 - 150	HSS	52	76	67	82	0.18	0.30	0.41	0.51	0.61	0.69
		150 - 200	HSS	46	69	59	75	0.15	0.28	0.36	0.46	0.56	0.64
		200 - 220	HSS	40	59	52	66	0.15	0.23	0.30	0.41	0.46	0.53
		220 - 260	SC	34	50	44	55	0.13	0.18	0.23	0.30	0.36	0.43
260 - 320	SC	27	41	37	44	0.10	0.15	0.18	0.23	0.30	0.36		
N	Aluminum	30	HSS	183	259	229	-	0.20	0.33	0.41	0.51	0.56	0.64
		180	HSS	91	137	122	-	0.20	0.33	0.41	0.46	0.56	0.64

### Formulas

<p>1. <b>RPM = (318.47 • M/min) / DIA</b></p> <p>where:</p> <p>RPM = revolutions per minute (rev/min)</p> <p>M/min = speed (M/min)</p> <p>DIA = finish diameter of drill (mm)</p>	<p>2. <b>M/min = RPM • 0.003 • DIA</b></p> <p>where:</p> <p>M/min = speed (M/min)</p> <p>RPM = revolutions per minute (rev/min)</p> <p>DIA = diameter of drill (mm)</p>	<p>3. <b>IPM = RPM • mm/rev</b></p> <p>where:</p> <p>IPM = feed rate</p> <p>RPM = revolutions per minute (rev/min)</p> <p>mm/rev = feed rate (mm/rev)</p>
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## Coolant Recommendations | Metric (mm)

HSS

ISO	Material	Pressure / Flow Rate	Tube No. 4 - 5	Tube No. 6 - 8	Tube No. 10	Tube No. 12 - 16	Tube No. 20 - 24	Tube No. 32
			T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3	T-A Series 4
P	<b>Free Machining Steel</b> 1118, 1215, 12L14, etc.	BAR	12 - 13	7 - 8	7 - 10	6 - 8	6 - 7	3 - 4
		LPM	9.5 - 9.8	10.6 - 11.4	16.7 - 19.7	26.5 - 30.3	45.4 - 53.0	114 - 125
	<b>Low Carbon Steel</b> 1010, 1020, 1025, 1522, 1144, etc.	BAR	11 - 12	5 - 6	5 - 7	4 - 6	4 - 5	2 - 3
		LPM	9.1 - 9.5	9.1 - 9.8	14.0 - 15.9	22.7 - 26.5	41.6 - 45.4	98 - 114
	<b>Medium Carbon Steel</b> 1030, 1040, 1050, 1527, 1140, 1151, etc.	BAR	11	5 - 6	5 - 6	4 - 5	3 - 5	2 - 3
		LPM	8.7 - 9.1	8.7 - 9.8	13.6 - 15.5	18.9 - 22.7	37.9 - 45.4	98 - 114
	<b>Alloy Steel</b> 4140, 5140, 8640, etc.	BAR	11	5 - 6	5	3 - 5	3 - 4	2
		LPM	8.7 - 9.1	13.2 - 14.8	8.3 - 9.1	18.9 - 22.7	34.1 - 37.9	87 - 98
	<b>High Strength Alloy</b> 4340, 4330V, 300M, etc.	BAR	10 - 11	4 - 5	3 - 4	2	2	2
		LPM	8.7 - 9.1	7.9 - 8.3	11.0 - 11.7	15.1 - 18.9	26.5 - 30.3	79 - 87
	<b>Structural Steel</b> A36, A285, A516, etc.	BAR	11	5 - 6	5 - 6	3 - 4	3	2
		LPM	8.7 - 9.1	9.1 - 9.8	13.2 - 14.8	18.9 - 22.7	34.1 - 37.9	87 - 98
	<b>Tool Steel</b> H-13, H-21, A-4, O-2, S-3, etc.	BAR	4	10 - 11	3	2	2	1 - 2
		LPM	7.9 - 8.3	8.7 - 9.1	11.0 - 11.7	15.1 - 18.9	26.5 - 30.3	79 - 87
S	<b>High Temp Alloy</b> Hastelloy B, Inconel 600, etc.	BAR	10 - 11	4 - 5	3 - 4	2	2	2
		LPM	8.7 - 9.1	8.3 - 8.7	11.7 - 12.1	15.1 - 18.9	26.5 - 30.3	87 - 98
M	<b>Stainless Steel 400 Series</b> 416, 420, 303, etc.	BAR	11.4 - 11.7	4.8 - 5.8	4.5 - 5.2	2.7 - 3.8	2.7 - 3.4	1.7 - 2
		LPM	9.1 - 9.5	8.7 - 9.8	13.2 - 14	18.9 - 22.7	34.1 - 37.9	87 - 98
K	<b>Nodular, Grey, Ductile Cast Iron</b>	BAR	10.7 - 11.0	4.1 - 4.5	3.4 - 4.1	2 - 2.7	2 - 2.4	1.7 - 2
		LPM	8.7 - 9.1	8.3 - 8.7	11.7 - 12.5	15.1 - 18.9	30.3 - 34.1	87 - 98
N	<b>Aluminum</b>	BAR	13.1 - 14.5	9.6 - 12.4	10.3 - 15.8	7.9 - 11	6.2 - 8.6	2.7 - 3.4
		LPM	9.8 - 10.2	12.5 - 14	20.1 - 23.1	30.3 - 34.1	53 - 60.6	114 - 125

**IMPORTANT:** The coolant pressure and flow rate recommendations above represent a good approximation to obtain optimum tool life and chip evacuation at Allied's recommended speeds and feeds. If lower coolant capabilities exist in a drilling application, the AccuPort 432 Port Contour Cutter will still function at reduced penetration rates. Contact our Application Engineering Department for a more specific recommendation of coolant requirements and/or speeds and feeds.

A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS



## Recommended Drilling Data | Metric (mm)

Carbide

ISO	Material	Hardness (BHN)	Grade	Speed (M/min)			Feed Rate (mm/rev) by Tube Size and T-A® Insert Series				
				TiN	TiAlN	AM200®	Tube No. 4 - 5	Tube No. 6 - 8	Tube No. 10	Tube No. 12 - 16	Tube No. 20 - 24
							T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 150	K35, P40	98	128	146	0.020	0.30	0.38	0.46	0.53
		150 - 200	K35, P40	85	110	126	0.18	0.28	0.36	0.41	0.48
		200 - 250	K35, P40	79	104	119	0.15	0.25	0.33	0.38	0.43
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 125	K35, P40	91	119	137	0.20 ❖	0.25	0.33	0.43	0.48
		125 - 175	K35, P40	79	104	119	0.18 ❖	0.25	0.33	0.41	0.46
		175 - 225	K35, P40	73	94	108	0.15 ❖	0.23	0.30	0.38	0.43
		225 - 275	K35, P40	64	82	94	0.13 ❖	0.23	0.30	0.38	0.43
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 175	K35, P40	79	104	119	0.18	0.25	0.33	0.41	0.46
		175 - 225	K35, P40	73	94	108	0.15	0.23	0.30	0.38	0.43
		225 - 275	K35, P40	64	82	94	0.15	0.23	0.30	0.38	0.43
		275 - 325	K35, P40	55	70	81	0.13	0.20	0.28	0.36	0.41
	Alloy Steel 4140, 5140, 8640, etc.	125 - 175	K35, P40	76	99	114	0.18	0.25	0.33	0.41	0.46
		175 - 225	K35, P40	70	91	105	0.15	0.23	0.30	0.38	0.43
		225 - 275	K35, P40	64	82	94	0.15	0.23	0.30	0.38	0.43
		275 - 325	K35, P40	61	76	87	0.13	0.20	0.28	0.36	0.41
		325 - 375	K35, P40	52	67	78	0.10	0.18	0.25	0.33	0.38
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 300	K35, P40	49	61	73	0.15 ❖	0.23	0.25	0.30	0.38
		300 - 350	K35, P40	43	55	62	0.13 ❖	0.20	0.23	0.28	0.36
		350 - 400	K35, P40	37	49	56	0.10 ❖	0.18	0.20	0.25	0.30
	Structural Steel A36, A285, A516, etc.	100 - 150	K35, P40	73	94	108	0.20 ❖	0.28	0.36	0.41	0.46
150 - 250		K35, P40	61	76	87	0.15 ❖	0.25	0.30	0.36	0.41	
250 - 350		K35, P40	55	70	81	0.13 ❖	0.23	0.28	0.30	0.36	
Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 200	K35, P40	49	67	78	0.10 ❖	0.18	0.23	0.28	0.33	
	200 - 250	K35, P40	37	52	59	0.10 ❖	0.18	0.23	0.28	0.33	
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 220	K20	24	32	36	0.10 ❖	0.18	0.23	0.28	0.33
		220 - 310	K20	18	26	29	0.10 ❖	0.15	0.20	0.25	0.30
M	Stainless Steel 400 Series 416, 420, 303, etc.	185 - 275	K20	49	64	73	0.18 ❖	0.23	0.30	0.36	0.41
		275 - 350	K20	37	49	46	0.15 ❖	0.20	0.28	0.30	0.36
K	Nodular, Grey, Ductile Cast Iron	120 - 150	K20, K10	98	140	152	0.20	0.30	0.38	0.48	0.58
		150 - 200	K20, K10	82	122	146	0.18	0.28	0.33	0.43	0.53
		200 - 220	K20, K10	73	110	131	0.15	0.23	0.30	0.38	0.46
		220 - 260	K20, K10	64	94	113	0.13	0.20	0.28	0.33	0.38
		260 - 320	K20, K10	55	82	102	0.13	0.18	0.25	0.28	0.33
N	Aluminum	30	K20	366	457	-	0.25	0.38	0.46	0.51	0.56
		180	K20	244	305	-	0.23	0.33	0.41	0.46	0.51

### Formulas

<p>1. <math>RPM = (318.47 \cdot M/min) / DIA</math></p> <p>where:</p> <p>RPM = revolutions per minute (rev/min)</p> <p>M/min = speed (M/min)</p> <p>DIA = finish diameter of drill (mm)</p>	<p>2. <math>M/min = RPM \cdot 0.003 \cdot DIA</math></p> <p>where:</p> <p>M/min = speed (M/min)</p> <p>RPM = revolutions per minute (rev/min)</p> <p>DIA = diameter of drill (mm)</p>	<p>3. <math>IPM = RPM \cdot mm/rev</math></p> <p>where:</p> <p>IPM = feed rate</p> <p>RPM = revolutions per minute (rev/min)</p> <p>mm/rev = feed rate (mm/rev)</p>
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The table and equations on this page are found in the *Machinery's Handbook*. Permission to simplify and print the equations is granted by the Editor of the *Machinery's Handbook*.

**IMPORTANT:** The speeds and feeds listed above are a general starting point for all applications. Refer to the Coolant Recommendation charts for coolant requirements to run at the recommended speeds and feeds. Factory technical assistance is also available through our Application Engineering Team. Due to potential chip formation issues, contact our Application Engineering Team for assistance machining materials marked with a ❖.

## Coolant Recommendations | Metric (mm)

Carbide

ISO	Material	Pressure / Flow Rate	Tube No.	Tube No.	Tube No.	Tube No.	Tube No.
			4 - 5	6 - 8	10	12 - 16	20 - 24
			T-A Series Y - Z	T-A Series 0	T-A Series 1	T-A Series 2	T-A Series 3
P	<b>Free Machining Steel</b> 1118, 1215, 12L14, etc.	BAR	20	16	17	15	12
		LPM	12.2	16.3	25.3	41.5	71.9
	<b>Low Carbon Steel</b> 1010, 1020, 1025, 1522, 1144, etc.	BAR	11.4	13.3	20.6	36.5	62
		LPM	17	10	10	10	8
	<b>Medium Carbon Steel</b> 1030, 1040, 1050, 1527, 1140, 1151, etc.	BAR	17	9	10	8	7
		LPM	11.1	12.3	19.3	30	55.8
	<b>Alloy Steel</b> 4140, 5140, 8640, etc.	BAR	10.4	9.1	12.6	18.8	33.6
		LPM	16	9	8	7	5
	<b>High Strength Alloy</b> 4340, 4330V, 300M, etc.	BAR	15	5	5	3	3
		LPM	10.4	9.1	13.6	19.7	36.5
	<b>Structural Steel</b> A36, A285, A516, etc.	BAR	16	9	8	7	5
		LPM	10.8	12	17.5	27.8	47.1
	<b>Tool Steel</b> H-13, H-21, A-4, O-2, S-3, etc.	BAR	15	5	5	3	3
		LPM	10.4	9.1	13.6	19.7	36.5
S	<b>High Temp Alloy</b> Hastelloy B, Inconel 600, etc.	BAR	17	11.4	12.4	11	9
		LPM	11.1	13.5	21.9	35.4	62
M	<b>Stainless Steel 400 Series</b> 416, 420, 303, etc.	BAR	22.7	16.5	17.9	17.2	13.1
		LPM	13	16.3	26.3	44.2	75
K	<b>Nodular, Grey, Ductile Cast Iron</b>	BAR	15.5	7.2	6.2	6.2	5.5
		LPM	10.7	10.8	15.4	26.5	48.7
N	<b>Aluminum</b>	BAR	24.1	22	21.7	19.6	13.8
		LPM	13.4	18.8	29	47.2	77

**IMPORTANT:** The coolant pressure and flow rate recommendations above represent a good approximation to obtain optimum tool life and chip evacuation at Allied's recommended speeds and feeds. If lower coolant capabilities exist in a drilling application, the AccuPort 432 Port Contour Cutter will still function at reduced penetration rates. Contact our Application Engineering Department for a more specific recommendation of coolant requirements and/or speeds and feeds.

A  
DRILLING  
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# Guaranteed Test / Demo Application Form

Distributor PO # \_\_\_\_\_

The following must be filled out completely before your test will be considered

## Distributor Information

Company Name: \_\_\_\_\_  
 Contact: \_\_\_\_\_  
 Account Number: \_\_\_\_\_  
 Phone: \_\_\_\_\_  
 Email: \_\_\_\_\_

## End User Information

Company Name: \_\_\_\_\_  
 Contact: \_\_\_\_\_  
 Industry: \_\_\_\_\_  
 Phone: \_\_\_\_\_  
 Email: \_\_\_\_\_

**Current Process** List all tooling, coatings, substrates, speeds and feeds, tool life, and any problems you are experiencing

\_\_\_\_\_

\_\_\_\_\_

**Test Objective** List what would make this a successful test (i.e. penetration rate, finish, tool life, hole size, etc.)

\_\_\_\_\_

\_\_\_\_\_

## Application Information

Hole Diameter: _____ in/mm	Tolerance: _____	Material: _____ (4150 / A36 / Cast Iron / etc.)
Pre-existing Diameter: _____ in/mm	Depth of Cut: _____ in/mm	Hardness: _____ (BHN / Rc)
Required Finish: _____ RMS	State: _____ (Casting / Hot rolled / Forging)	

## Machine Information

Machine Type: _____ (Lathe / Screw machine / Machine center / etc.)	Builder: _____ (Haas, Mori Seiki, etc.)	Model #: _____
Shank Required: _____ (CAT50 / Morse taper, etc.)		Power: _____ HP/KW
Rigidity: _____	Orientation: _____	Tool Rotating: _____
<input type="checkbox"/> Excellent	<input type="checkbox"/> Vertical	<input type="checkbox"/> Yes
<input type="checkbox"/> Good	<input type="checkbox"/> Horizontal	<input type="checkbox"/> No
<input type="checkbox"/> Poor		Thrust: _____ lbs/N

## Coolant Information

Coolant Delivery: _____ (Through tool / Flood)	Coolant Pressure: _____ PSI / bar
Coolant Type: _____ (Air mist, oil, synthetic, water soluble, etc.)	Coolant Volume: _____ GPM / LPM

## Requested Tooling

QTY	Item Number	QTY	Item Number



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Allied Machine & Engineering ("Allied Machine") warrants to original equipment manufacturers, distributors, industrial and commercial users of its products for one year from the original date of sale that each new product manufactured or supplied by Allied Machine shall be free from defects in material and workmanship.

Allied Machine's sole and exclusive obligation under this warranty is limited to, at its option, without additional charge, replacing or repairing this product or issuing a credit. For this warranty to be applied, the product must be returned freight prepaid to the plant designated by an Allied Machine representative and which, upon inspection, is determined by Allied Machine to be defective in material and workmanship.

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

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