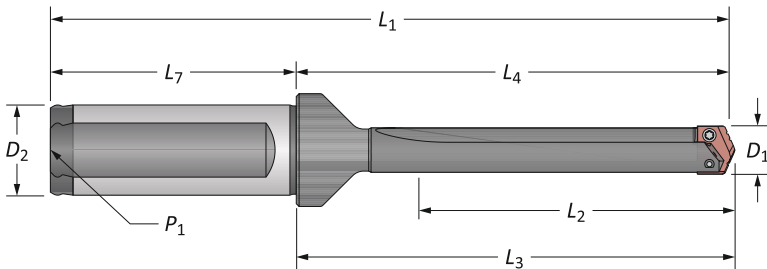


A

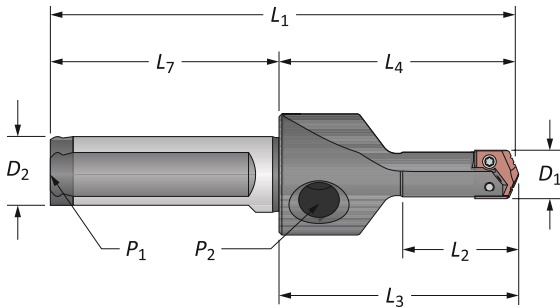
DRILLING

T-A Drill Insert Holders

Z Series | Flange Shank



Stub Length



C

REAMING

Straight Flute

		Body					Shank			Part No.
Length		D <sub>1</sub>	L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	L <sub>7</sub>	P <sub>1</sub>	
i	Stub	7/16 - 1/2	3/4	1-7/8	1-31/32	3-3/4	5/8	1-7/8	1/16	210Z0S-063F
	Short	7/16 - 1/2	1-1/4	2-13/32	2-1/2	4-7/16	3/4	2-1/32	1/8	220Z0S-075F
	Standard	7/16 - 1/2	2-3/8	3-17/32	3-5/8	5-9/16	3/4	2-1/32	1/8	240Z0S-075F
	Extended	7/16 - 1/2	4-3/8	5-17/32	5-5/8	7-9/16	3/4	2-1/32	1/8	⚠ 250Z0S-075F
m	Stub	11.5 - 12.5	19.1	47.6	50.0	95.6	16.0	48.0	1/16*	210Z0S-16FM
	Short	11.5 - 12.5	31.8	61.1	63.5	111.1	20.0	50.0	1/8*	220Z0S-20FM
	XL	11.5 - 12.5	222.3	251.7	254.1	301.7	20.0	50.0	1/8*	⚠ 270Z0S-20FM
	3XL	11.5 - 12.5	290.5	319.9	322.3	369.9	20.0	50.0	1/8*	⚠ 290Z0S-20FM

\*Metric thread to BSP and ISO 7-1

**NOTE:** Stub length holders have a 1/8" side pipe tap (P<sub>2</sub>)

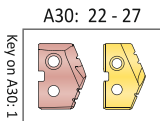
E

THREADING

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	7.4 in-lbs (84 N-cm)


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



i = Imperial (in)

m = Metric (mm)

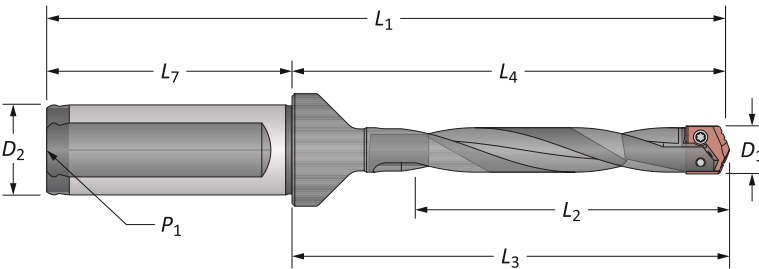
Screws sold in quantities of 10


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



T-A Drill Insert Holders

Z Series | Flange Shank



Helical Flute

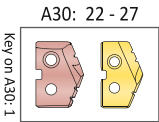
		Body					Shank			Part No.
Length		D <sub>1</sub>	L <sub>2</sub>	L <sub>4</sub>	L <sub>3</sub>	L <sub>1</sub>	D <sub>2</sub>	L <sub>7</sub>	P <sub>1</sub>	
i	Standard	7/16 - 1/2	2-3/8	3-17/32	3-5/8	5-9/16	3/4	2-1/32	1/8	240Z0H-075F
	Standard Plus	7/16 - 1/2	3-3/8	4-35/64	4-41/64	6-43/64	3/4	2-1/32	1/8	245Z0H-075F
	Extended	7/16 - 1/2	4-3/8	5-17/32	5-5/8	7-9/16	3/4	2-1/32	1/8	250Z0H-075F
	Long	7/16 - 1/2	7-1/16	8-1/4	8-11/32	10-3/8	3/4	2-1/32	1/8	260Z0H-075F
m	Standard	11.5 - 12.5	60.3	89.7	92.1	139.7	20.0	50.0	1/8*	240Z0H-20FM
	Standard Plus	11.5 - 12.8	86.0	115.4	117.8	165.4	20.0	50.0	1/8*	245Z0H-20FM
	Extended	11.5 - 12.5	111.1	140.5	142.9	190.5	20.0	50.0	1/8*	250Z0H-20FM
	Long	11.5 - 12.8	180.0	209.4	211.8	259.4	20.0	50.0	1/8*	260Z0H-20FM

\*Metric thread to BSP and ISO 7-1

Connection Accessories

Insert Screws	Nylon Locking Screws	Insert Driver	Preset Torque Hand Driver	Replacement Tips	Admissible Tightening Torque*
7247-IP7-1	7247N-IP7-1	8IP-7	8IP-7TL	8IP-7B	7.4 in-lbs (84 N-cm)

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



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

Screws sold in quantities of 10

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