

BT-A Drill

BTA (STS) Deep Hole Machining System

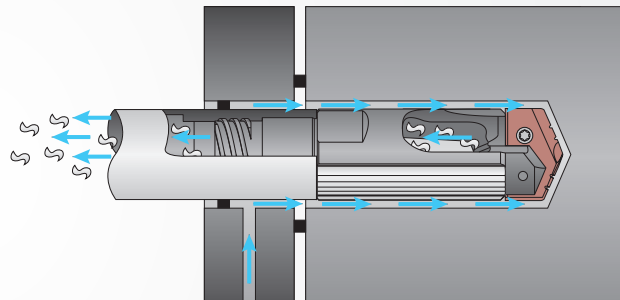
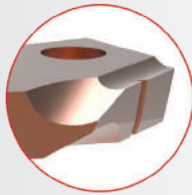
- ✓ **Improve hole straightness**
with the laser clad bearing area
- ✓ **Eliminate the need for resharpening**
with replaceable cutting edges
- ✓ **Reduce your inventory**
with the replaceable T-A® feature
- ✓ **Compatibility**
heads are compatible with standard BTA-STS systems
- ✓ **Balanced cutting forces**



2x INCREASE in penetration rates over traditional BTA heads

Original T-A Insert: BT-A Geometry (-BT)

- Low thrust web geometry reduces Z-axis requirements
- Tiny chip (-TC) lip geometry improves chip formation
- Polished cutting surface eliminates material build-up



BT-A Single Tube System

Material Ejection with *EFFICIENCY*

The BT-A Drill (using the single tube system, or STS) conquers deep hole applications in ways other drills simply cannot. The internal ejection system flushes chips and debris from the hole with no interference to the cutting process.

By utilizing the countless advantages of the T-A® drill insert, the BT-A design significantly increases penetration rates over brazed heads and traditional gun drills. A specific BT geometry has also been developed to increase productivity in these types of drilling applications.

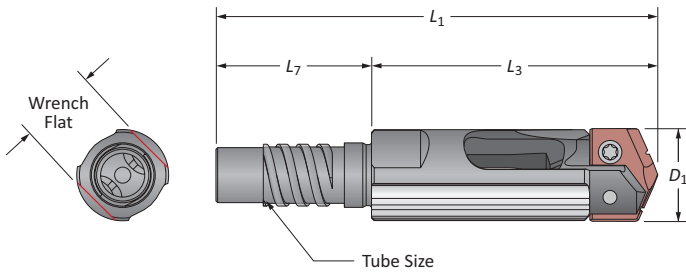


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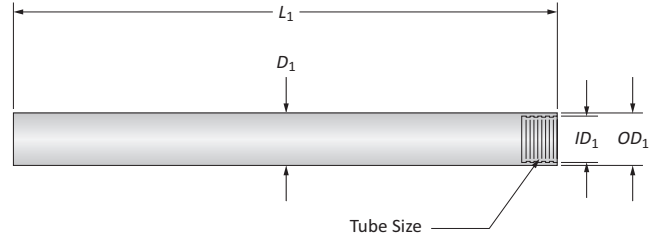
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BT-A Drill | Holders & Tubes



D_1 = Drill insert range L_1 = Overall length
 L_3 = Holder reference length L_7 = Shank length



D_1 = Body diameter L_1 = Overall length
 ID_1 = Internal diameter OD_1 = Outer diameter

BT-A Drill Holders

Tube Size	D_1	Holder			Part No.	T-A® Insert	Wrench Flat (mm)
		L_3	L_1	L_7			
794	0.5100 - 0.5359	1-45/64	2-39/64	29/32	BTA0-794-X.XXXX	1C10H-XXXX-BT	11
795	0.5360 - 0.5759	1-3/4	2-21/32	29/32	BTA0-795-X.XXXX	1C10H-XXXX-BT	12
796	0.5760 - 0.6149	1-13/16	2-3/4	61/64	BTA0-796-X.XXXX	1C10H-XXXX-BT	13
797	0.6150 - 0.6579	1-13/16	2-3/4	61/64	BTA0-797-X.XXXX	1C10H-XXXX-BT	14
798	0.6580 - 0.6959	1-25/32	2-47/64	61/64	BTA0-798-X.XXXX	1C10H-XXXX-BT	15
799	0.6960 - 0.7449	2-15/64	3-9/32	63/64	BTA1-799-X.XXXX	1C11H-XXXX-BT	16
800	0.7450 - 0.7879	2-5/16	3-27/64	1-7/64	BTA1-800-X.XXXX	1C11H-XXXX-BT	17
801	0.7880 - 0.8589	2-11/32	3-35/64	1-13/64	BTA1-801-X.XXXX	1C11H-XXXX-BT	18
802	0.8590 - 0.9489	2-25/64	3-11/16	1-19/64	BTA1-802-X.XXXX	1C11H-XXXX-BT	19
803	0.9490 - 0.9600	2-33/64	3-13/16	1-19/64	BTA1-803-X.XXXX	1C11H-XXXX-BT	21
803	0.9601 - 1.0399	3-3/32	4-25/64	1-19/64	BTA2-803-X.XXXX	1C12H-XXXX-BT	21
804	1.0400 - 1.1299	3	4-3/32	1-7/64	BTA2-804-X.XXXX	1C12H-XXXX-BT	22
805	1.1300 - 1.2209	2-31/32	4-25/64	1-27/64	BTA2-805-X.XXXX	1C12H-XXXX-BT	25
806	1.2210 - 1.3119	3-1/16	4-31/64	1-27/64	BTA2-806-X.XXXX	1C12H-XXXX-BT	27
807	1.3120 - 1.3800	3-1/16	4-31/64	1-27/64	BTA2-807-X.XXXX	1C12H-XXXX-BT	30
807	1.3801 - 1.4259	3-13/16	5-15/64	1-27/64	BTA3-807-X.XXXX	-	30
808	1.4260 - 1.5599	3-15/16	5-11/16	1-3/4	BTA3-808-X.XXXX	-	32
809	1.5600 - 1.6929	4-1/16	5-3/4	1-11/16	BTA3-809-X.XXXX	-	36
810	1.6930 - 1.8509	4-1/64	5-45/64	1-11/16	BTA3-810-X.XXXX	-	41
811	1.8510 - 1.8820	4-1/16	5-3/4	1-11/16	BTA3-811-X.XXXX	-	41
794	12.95 - 13.61	43.4	66.4	23	BTA0-794-XX.XX	1C10H-XXXX-BT	11
795	13.62 - 14.63	44.6	67.6	23	BTA0-795-XX.XX	1C10H-XXXX-BT	12
796	14.64 - 15.62	45.9	69.9	24	BTA0-796-XX.XX	1C10H-XXXX-BT	13
797	15.63 - 16.71	45.9	69.9	24	BTA0-797-XX.XX	1C10H-XXXX-BT	14
798	16.72 - 17.68	45.3	69.3	24	BTA0-798-XX.XX	1C10H-XXXX-BT	15
799	17.69 - 18.92	58.2	83.2	25	BTA1-799-XX.XX	1C11H-XXXX-BT	16
800	18.93 - 20.01	58.8	86.8	28	BTA1-800-XX.XX	1C11H-XXXX-BT	17
801	20.02 - 21.81	59.4	89.9	30.5	BTA1-801-XX.XX	1C11H-XXXX-BT	18
802	21.82 - 24.10	60.7	93.7	33	BTA1-802-XX.XX	1C11H-XXXX-BT	19
803	24.11 - 24.38	63.9	96.9	33	BTA1-803-XX.XX	1C11H-XXXX-BT	21
803	24.39 - 26.41	78.5	111.5	33	BTA2-803-XX.XX	1C12H-XXXX-BT	21
804	26.42 - 28.70	75.9	103.9	28	BTA2-804-XX.XX	1C12H-XXXX-BT	22
805	28.71 - 31.01	75.4	111.4	36	BTA2-805-XX.XX	1C12H-XXXX-BT	25
806	31.02 - 33.32	77.9	113.8	36	BTA2-806-XX.XX	1C12H-XXXX-BT	27
807	33.33 - 35.05	77.9	113.8	36	BTA2-807-XX.XX	1C12H-XXXX-BT	30
807	35.06 - 36.22	96.8	132.8	36	BTA3-807-XX.XX	-	30
808	36.23 - 39.62	100.0	144.4	44.5	BTA3-808-XX.XX	-	32
809	39.63 - 43.00	103.1	146.2	43	BTA3-809-XX.XX	-	36
810	43.01 - 47.01	101.9	144.9	43	BTA3-810-XX.XX	-	41
811	47.02 - 47.80	103.2	146.2	43	BTA3-811-XX.XX	-	41

BT-A Tubes

Tube Size	D_1 Range	Tube			Part No.
		OD_1	ID_1	L_1	
794	0.510 - 0.535	0.433	0.276	63	BTAT794-63
794	0.510 - 0.535	0.433	0.276	102	BTAT794-102
795	0.536 - 0.575	0.472	0.315	63	BTAT795-63
795	0.536 - 0.575	0.472	0.315	102	BTAT795-102
796	0.576 - 0.614	0.512	0.335	63	BTAT796-63
796	0.576 - 0.614	0.512	0.335	102	BTAT796-102
797	0.615 - 0.657	0.551	0.354	63	BTAT797-63
797	0.615 - 0.657	0.551	0.354	102	BTAT797-102
798	0.658 - 0.696	0.591	0.394	63	BTAT798-63
798	0.658 - 0.696	0.591	0.394	102	BTAT798-102
799	17.69 - 18.90	16.0	10.5	1600	BTAT799-63
799	17.69 - 18.90	16.0	10.5	2591	BTAT799-102
800	18.91 - 20.00	17.0	11.5	1600	BTAT800-63
800	18.91 - 20.00	17.0	11.5	2591	BTAT800-102
801	20.01 - 21.79	18.0	12.0	1600	BTAT801-63
801	20.01 - 21.79	18.0	12.0	2591	BTAT801-102
802	21.80 - 24.08	20.0	13.0	1600	BTAT802-63
802	21.80 - 24.08	20.0	13.0	2591	BTAT802-102
803	24.09 - 26.39	22.0	14.0	1600	BTAT803-63
803	24.09 - 26.39	22.0	14.0	2591	BTAT803-102
803	0.949 - 1.039	0.866	0.551	63	BTAT803-63
803	0.949 - 1.039	0.866	0.551	102	BTAT803-102
804	1.040 - 1.129	0.945	0.610	63	BTAT804-63
804	1.040 - 1.129	0.945	0.610	102	BTAT804-102
805	1.130 - 1.220	1.024	0.669	63	BTAT805-63
805	1.130 - 1.220	1.024	0.669	102	BTAT805-102
806	1.221 - 1.311	1.102	0.728	102	BTAT806-102
807	1.312 - 1.425	1.181	0.787	102	BTAT807-102
807	1.312 - 1.425	1.181	0.787	102	BTAT807-102
808	1.426 - 1.559	1.299	0.906	102	BTAT808-102
809	1.560 - 1.692	1.417	0.984	102	BTAT809-102
810	1.693 - 1.850	1.535	1.102	102	BTAT810-102
811	1.851 - 1.882	1.693	1.220	102	BTAT811-102
807	1.312 - 1.425	1.181	0.787	102	BTAT807-102
808	1.426 - 1.559	1.299	0.906	102	BTAT808-102
809	1.560 - 1.692	1.417	0.984	102	BTAT809-102
810	1.693 - 1.850	1.535	1.102	102	BTAT810-102
811	1.851 - 1.882	1.693	1.220	102	BTAT811-102

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

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