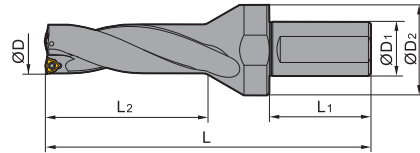


Indexable drills series

ZD03



Article	*	Stock	Dimensions [mm]							kg	Inserts
			ØD	ØD1	ØD2	L1	L2	L			
ZD03-160-XP25-WC03-02	*	•	16	25	32	56	52	129	0.33	WCMX0302**	
ZD03-170-XP25-WC03-02	*	•	17	25	32	56	55	133	0.33	WCMX0302**	
ZD03-180-XP25-WC03-02	*	•	18	25	32	56	58	137	0.35	WCMX0302**	
ZD03-190-XP25-WC03-02	*	•	19	25	32	56	61	140	0.36	WCMX0302**	
ZD03-200-XP25-WC03-02	*	•	20	25	32	56	64	143	0.37	WCMX0302**	
ZD03-210-XP25-WC04-02	*	•	21	25	45	56	67	153	0.51	WCMX0402**	
ZD03-220-XP25-WC04-02	*	•	22	25	45	56	70	156	0.54	WCMX0402**	
ZD03-230-XP25-WC04-02	*	•	23	25	45	56	73	159	0.55	WCMX0402**	
ZD03-240-XP25-WC04-02	*	•	24	25	45	56	76	162	0.57	WCMX0402**	
ZD03-250-XP25-WC04-02	*	•	25	25	45	56	79	165	0.6	WCMX0402**	
ZD03-260-XP32-WC05-02	*	•	26	32	55	60	83	176	0.93	WCMX0503**	
ZD03-270-XP32-WC05-02	*	•	27	32	55	60	86	180	0.97	WCMX0503**	
ZD03-280-XP32-WC05-02	*	•	28	32	55	60	89	184	1.01	WCMX0503**	
ZD03-290-XP32-WC05-02	*	•	29	32	55	60	92	188	1.05	WCMX0503**	
ZD03-300-XP32-WC05-02	*	•	30	32	55	60	95	192	1.08	WCMX0503**	
ZD03-310-XP40-WC06-02	*	•	31	40	60	70	98	203	1.44	WCMX06T3**	
ZD03-320-XP40-WC06-02	*	•	32	40	60	70	101	206	1.48	WCMX06T3**	
ZD03-330-XP40-WC06-02	*	•	33	40	60	70	104	209	1.52	WCMX06T3**	
ZD03-340-XP40-WC06-02	*	•	34	40	60	70	107	212	1.55	WCMX06T3**	
ZD03-350-XP40-WC06-02	*	•	35	40	60	70	110	215	1.61	WCMX06T3**	
ZD03-360-XP40-WC06-02	*	•	36	40	60	70	113	218	1.66	WCMX06T3**	
ZD03-370-XP40-WC06-02	*	•	37	40	60	70	116	221	1.71	WCMX06T3**	
ZD03-380-XP40-WC06-02	*	•	38	40	60	70	119	225	1.76	WCMX06T3**	
ZD03-390-XP40-WC06-02	*	•	39	40	60	70	122	228	1.82	WCMX06T3**	
ZD03-400-XP40-WC06-02	*	•	40	40	60	70	125	231	1.93	WCMX06T3**	
ZD03-410-XP40-WC06-02	*	•	41	40	60	70	128	234	1.94	WCMX06T3**	
ZD03-420-XP40-WC08-02	*	•	42	40	60	70	131	239	2.18	WCMX0804**	
ZD03-430-XP40-WC08-02	*	•	43	40	60	70	134	242	2.245	WCMX0804**	
ZD03-440-XP40-WC08-02	*	•	44	40	60	70	137	245	2.34	WCMX0804**	
ZD03-450-XP40-WC08-02	*	•	45	40	60	70	140	248	2.34	WCMX0804**	
ZD03-460-XP40-WC08-02	*	•	46	40	60	70	143	251	2.49	WCMX0804**	
ZD03-470-XP40-WC08-02	*	•	47	40	60	70	146	253	2.88	WCMX0804**	
ZD03-480-XP40-WC08-02	*	•	48	40	70	70	149	255	2.55	WCMX0804**	

• Ex stock ◦ On demand


* Internal cooling

System code > C9

Grade selection > C8



Technical info > C201

Cutting data > C36


Article	*	Stock	Dimensions [mm]							kg	Inserts 
			ØD	ØD1	ØD2	L1	L2	L			
ZD03-490-XP40-WC08-02	*	○	49	40	70	70	152	257	2.619	WCMX0804**	
ZD03-500-XP40-WC08-02	*	●	50	40	70	70	155	259	2.62	WCMX0804**	
ZD03-510-XP40-WC08-02	*	○	51	40	70	70	158	261	2.62	WCMX0804**	
ZD03-520-XP40-WC08-02	*	○	52	40	70	70	70	263	2.808	WCMX0804**	
ZD03-530-XP40-WC08-02	*	○	53	40	70	70	164	265	2.906	WCMX0804**	
ZD03-540-XP40-WC08-02	*	●	54	40	70	70	167	267	2.983	WCMX0804**	
ZD03-550-XP40-WC08-02	*	○	55	40	70	70	170	269	3.126	WCMX0804**	
ZD03-560-XP40-WC08-02	*	○	56	40	70	70	173	271	3.157	WCMX0804**	
ZD03-580-XP40-WC08-02	*	●	58	40	70	70	179	275	3.501	WCMX0804**	

● Ex stock ○ On demand

* Internal cooling

Spare parts						
	Insert	WCMX0302**	WCMX0402**	WCMX0503**	WCMX06T3**	WCMX0804**
	Screw	I60M2.5×6.5 (1.0Nm)	I60M2.5×6.5T (1.0Nm)	I60M3×7 (1.8Nm)	I60M3×7 (1.8Nm)	I60M3.5×10.4 (2.7Nm)
	Wrench	WT06IP	WT07IP	WT15IP	WT15IP	WT20IP

Insert



Medium Cut

C35

System code > C9

Grade selection > C8

Technical info > C201

Cutting data > C36



A

Turning

B

Milling

C

Drilling

D

Technical Information

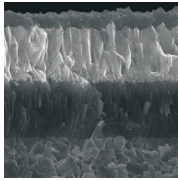

E

Index

A

Turning

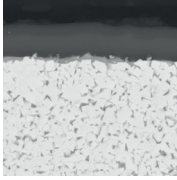
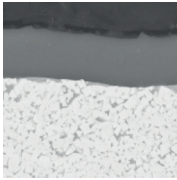
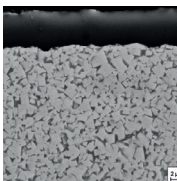
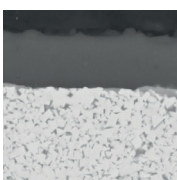
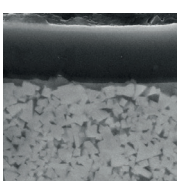
Coated cemented carbide CVD

Grade	ISO	Micro structure	Grade description
YB6338	P20 - P40 K20 - K40		CVD coated P20–P40/K20–K40 carbide substrate for operation with higher cutting speed and feed rate in steel and cast iron.
YBD252	K20 - K35		CVD coated K20–K35 carbide substrate. Optimized for medium to roughing operation of cast iron and Steel. Good wear resistance and toughness at higher cutting speed.

B

Milling

Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBG105	S05 - S20		PVD multilayer coated S05–S20 carbide substrate for finishing to medium application of super alloy material but also stainless steel. Good wear resistance and thermal stability in a wide application field.
YBG202	P10 - P30 M10 - M25		PVD coated M10–M25/P10–P30 carbide substrate for finishing to medium application of stainless steel and steel (milling). Good wear resistance in a wide application field.
YBS203	S15 - S25		For processing heat-resistant materials. A special carbon substrate and the latest PVD coating technology enable a very good wear behaviour, high fracture toughness and high thermal stability.
YBG205	P10 - P30 M20 - M40 S15-S25		PVD multilayer coated P10–P30/M20–M40/S15–S25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (milling). Excellent wear resistance and thermal stability in a wide range of applications.
YB9320	P10 - P30 M10 - M25		PVD multilayer coated P10–P30/M10–M25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (grooving/milling). Optimised coating stability for higher wear resistance and thermal stability in a wide range of applic

C

Drilling

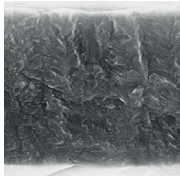
D

Technical Information

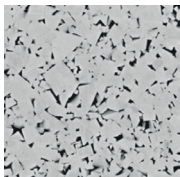
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Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBG212	P25 - P35 M25-M40		PVD coated M25–M40/P25–P35 carbide substrate for steel and stainless steel. Especially for inner insert at drilling operation.

Uncoated cemented carbide

Grade	ISO	Micro structure	Grade description
YD201	K10 - K30 N10 - N30		Uncoated N10–N30/K10–K30 carbide substrate for medium application in aluminum and other material.

A

Turning

B

Milling

C

Drilling

DTechnical
Information**E**

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Application fields of grades – indexable drills

	ISO	HC ¹ (CVD)	HC ¹ (PVD)	HT	HW	PCBN & PCD
A Turning	P01					
	P10					
	P20	YBD252	YBG202			
	P30	YB6338	YBG205			
	P40		YBG212			
B Milling	M01					
	M10		YBG202			
	M20		YB9320			
	M30		YBG205			
	M40		YBS203			
C Drilling	K01					
	K10	YBD252	YBG202			
	K20	YB6338	YBG205			
	K30					
	K40					YBG212
D Technical Information	N01					
	N10					
	N20				YD201	
	N30					
E Index	S01		YBG202			
	S10		YB9320			
	S20		YBG205			
	S30		YBS203			YBG212
H	H01					
	H10					
	H20					
	H30					

P	Steel
M	Stainless steel
K	Cast iron

N	Non-ferrous alloys
S	Heat-resistant alloys
H	Hardened materials

HC¹ Coated cemented carbide
 HT Uncoated cermet
 HW Uncoated cemented carbide

ZSD – 03 300 – XP – 32 S P 09 – 02

1 2 3 4 5 6 7 8 9

Type	
Code	Description
ZSD	Indexable drill (SPMX*)
ZTD	Indexable drill (SPGT*)
ZD	Indexable drill (WCMX*)

1

L/D relation	
Code	Description
02	2xD
03	3xD
04	4xD
05	5xD

2

Diameter [mm]	
Code	Description
130	13
...	



3

Shank type	
Code	Description
XP	Weldon shank

4

Coupling size [mm]



5

Insert shape
W 
S 

6

Clearance angle	
Code	Description
C	7°
P	11°

7

Cutting edge length [mm]		
Code	Insert shape	
	 W	 S
03	3,8	
04	4,3	
05	5,4	5
06	6,5	6
08	8,7	7,94
09		9,8
11		11,5
12		12,7
14		14,3

8

Number of teeth

9

A

Turning

B

Milling

C

Drilling

D

Technical Information

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