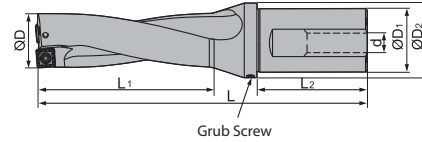


Indexable drills series

ZTD02



Grub Screw

Article	*	Stock	Dimensions [mm]								kg	Inserts
			ØD	ØD1	ØD2	L1	L2	L	d			
ZTD02-130-XP20-SP05-02	*	•	13	20	25	31	50	98	M13×1	0.165	SPGT0502**	
ZTD02-140-XP20-SP05-02	*	•	14	20	25	33	50	100	M13×1	0.171	SPGT0502**	
ZTD02-150-XP20-SP05-02	*	•	15	20	25	35	50	102	M13×1	0.176	SPGT0502**	
ZTD02-160-XP20-SP05-02	*	•	16	20	25	37	50	104	M13×1	0.184	SPGT0502**	
ZTD02-170-XP25-SP06-02	*	•	17	25	32	39	56	117	M16×1,5	0.325	SPGT0602**	
ZTD02-180-XP25-SP06-02	*	•	18	25	32	41	56	119	M16×1,5	0.332	SPGT0602**	
ZTD02-190-XP25-SP06-02	*	•	19	25	32	43	56	121	M16×1,5	0.342	SPGT0602**	
ZTD02-200-XP25-SP06-02	*	•	20	25	32	45	56	123	M16×1,5	0.353	SPGT0602**	
ZTD02-210-XP25-SP06-02	*	•	21	25	32	47	56	125	M16×1,5	0.35	SPGT0602**	
ZTD02-220-XP25-SP07-02	*	•	22	25	32	49	56	127	M16×1,5	0.367	SPGT07T3**	
ZTD02-230-XP25-SP07-02	*	•	23	25	32	51	56	129	M16×1,5	0.38	SPGT07T3**	
ZTD02-235-XP25-SP07-02	*	○	23.5	25	32	52	56	130	M16×1,5	0.361	SPGT07T3**	
ZTD02-240-XP25-SP07-02	*	•	24	25	32	53	56	131	M16×1,5	0.443	SPGT07T3**	
ZTD02-250-XP25-SP07-02	*	•	25	25	32	55	56	133	M16×1,5	0.41	SPGT07T3**	
ZTD02-260-XP25-SP07-02	*	•	26	25	32	57	56	135	M16×1,5	0.454	SPGT07T3**	
ZTD02-270-XP25-SP07-02	*	•	27	25	32	59	56	137	M16×1,5	0.445	SPGT07T3**	
ZTD02-280-XP32-SP09-02	*	•	28	32	37	61	60	146	M22×2	0.661	SPGT0904**	
ZTD02-290-XP32-SP09-02	*	•	29	32	37	63	60	148	M22×2	0.682	SPGT0904**	
ZTD02-300-XP32-SP09-02	*	•	30	32	37	65	60	150	M22×2	0.702	SPGT0904**	
ZTD02-310-XP32-SP09-02	*	•	31	32	37	67	60	152	M22×2	0.759	SPGT0904**	
ZTD02-320-XP32-SP09-02	*	•	32	32	37	69	60	154	M22×2	0.742	SPGT0904**	
ZTD02-330-XP32-SP09-02	*	•	33	32	37	71	60	156	M22×2	0.774	SPGT0904**	
ZTD02-340-XP40-SP11-02	*	•	34	40	47	73	70	173	(BSPT)RC1/4	1.2	SPGT1104**	
ZTD02-350-XP40-SP11-02	*	•	35	40	47	75	70	175	(BSPT)RC1/4	1.23	SPGT1104**	
ZTD02-360-XP40-SP11-02	*	•	36	40	47	77	70	177	(BSPT)RC1/4	1.26	SPGT1104**	
ZTD02-370-XP40-SP11-02	*	•	37	40	47	79	70	179	(BSPT)RC1/4	1.29	SPGT1104**	
ZTD02-380-XP40-SP11-02	*	•	38	40	47	81	70	181	(BSPT)RC1/4	1.33	SPGT1104**	
ZTD02-390-XP40-SP11-02	*	•	39	40	47	83	70	183	(BSPT)RC1/4	1.39	SPGT1104**	
ZTD02-400-XP40-SP11-02	*	•	40	40	47	85	70	185	(BSPT)RC1/4	1.43	SPGT1104**	
ZTD02-410-XP40-SP11-02	*	•	41	40	47	87	70	187	(BSPT)RC1/4	1.44	SPGT1104**	
ZTD02-420-XP40-SP14-02	*	•	42	40	52	89	70	199	(BSPT)RC1/4	1.62	SPGT1405**	
ZTD02-430-XP40-SP14-02	*	•	43	40	52	91	70	201	(BSPT)RC1/4	1.67	SPGT1405**	
ZTD02-440-XP40-SP14-02	*	•	44	40	52	93	70	203	(BSPT)RC1/4	1.71	SPGT1405**	

• 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	d			
ZTD02-450-XP40-SP14-02	*	•	45	40	52	95	70	205	(BSPT)RC1/4	1.76	SPGT1405**	
ZTD02-460-XP40-SP14-02	*	•	46	40	52	97	70	207	(BSPT)RC1/4	1.81	SPGT1405**	
ZTD02-470-XP40-SP14-02	*	•	47	40	52	99	70	209	(BSPT)RC1/4	1.87	SPGT1405**	
ZTD02-480-XP40-SP14-02	*	•	48	40	52	101	70	211	(BSPT)RC1/4	1.92	SPGT1405**	
ZTD02-490-XP40-SP14-02	*	•	49	40	52	103	70	213	(BSPT)RC1/4	1.98	SPGT1405**	
ZTD02-500-XP40-SP14-02	*	•	50	40	52	105	70	215	(BSPT)RC1/4	2.05	SPGT1405**	

• Ex stock ◦ On demand

* Internal cooling

Spare parts							
Insert	SPGT0502**	SPGT0602**	SPGT07T3**	SPGT0904**	SPGT1104**	SPGT1405**	
 Grub screw					M6×6 (7.0Nm)	M8×8 (10.2Nm)	
 Screw	I60M2×4.3 (0.5Nm)	I60M2.2×5.5 (0.8Nm)	I60M2.5×6.5 (1.0Nm)	I60M3.5×8 (2.7Nm)	I60M4×10 (3.4Nm)	I60M5×13 (6.7Nm)	
 Wrench	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP	

Insert



C34

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

Index

System code > C9

Grade selection > C8

Technical info > C201

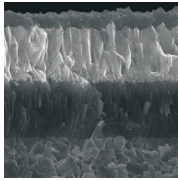

Cutting data > C36



A

Turning

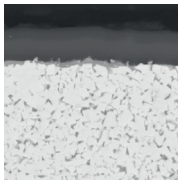
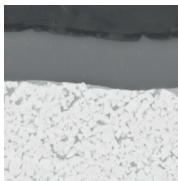
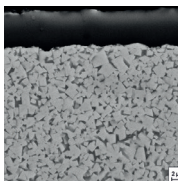
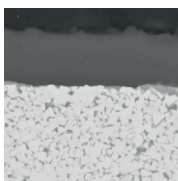
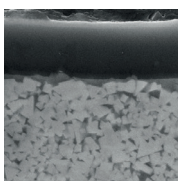
Coated cemented carbide CVD

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

E

Index

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			
	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

E

Index