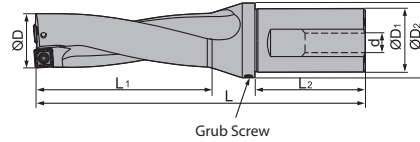


Indexable drills series

ZTD04



Article	*	Stock	Dimensions [mm]								kg	Inserts
			ØD	ØD1	ØD2	L1	L2	L	d			
ZTD04-130-XP20-SP05-02	*	o	13	20	25	57	50	124	M13x1	0.185	SPGT0502**	
ZTD04-140-XP20-SP05-02	*	o	14	20	25	61	50	128	M13x1	0.195	SPGT0502**	
ZTD04-150-XP20-SP05-02	*	o	15	20	25	65	50	132	M13x1	0.205	SPGT0502**	
ZTD04-160-XP20-SP05-02	*	o	16	20	25	69	50	136	M13x1	0.216	SPGT0502**	
ZTD04-165-XP25-SP06-02	*	o	16.5	25	32	71	56	137	M16x1,5	0.332	SPGT0602**	
ZTD04-170-XP25-SP06-02	*	o	17	25	32	73	56	151	M16x1,5	0.333	SPGT0602**	
ZTD04-180-XP25-SP06-02	*	o	18	25	32	77	56	155	M16x1,5	0.347	SPGT0602**	
ZTD04-190-XP25-SP06-02	*	o	19	25	32	81	56	159	M16x1,5	0.362	SPGT0602**	
ZTD04-200-XP25-SP06-02	*	o	20	25	32	85	56	163	M16x1,5	0.381	SPGT0602**	
ZTD04-210-XP25-SP06-02	*	o	21	25	32	89	56	167	M16x1,5	0.4	SPGT0602**	
ZTD04-215-XP25-SP07-02	*	o	21.5	25	32	91	56	165	M16x1,5	0.407	SPGT07T3**	
ZTD04-220-XP25-SP07-02	*	o	22	25	32	93	56	171	M16x1,5	0.391	SPGT07T3**	
ZTD04-230-XP25-SP07-02	*	o	23	25	32	97	56	175	M16x1,5	0.484	SPGT07T3**	
ZTD04-240-XP25-SP07-02	*	o	24	25	32	101	56	179	M16x1,5	0.513	SPGT07T3**	
ZTD04-250-XP25-SP07-02	*	o	25	25	32	105	56	183	M16x1,5	0.494	SPGT07T3**	
ZTD04-260-XP25-SP07-02	*	o	26	25	32	109	56	187	M16x1,5	0.535	SPGT07T3**	
ZTD04-270-XP25-SP07-02	*	o	27	25	32	113	56	191	M16x1,5	0.582	SPGT07T3**	
ZTD04-275-XP25-SP07-02	*	o	27.5	25	32	115	56	192	M16x1,5	0.571	SPGT07T3**	
ZTD04-280-XP32-SP09-02	*	o	28	32	37	117	60	202	M22x2	0.653	SPGT0904**	
ZTD04-290-XP32-SP09-02	*	o	29	32	37	121	60	206	M22x2	0.846	SPGT0904**	
ZTD04-300-XP32-SP09-02	*	o	30	32	37	125	60	210	M22x2	0.893	SPGT0904**	
ZTD04-310-XP32-SP09-02	*	o	31	32	37	129	60	214	M22x2	0.914	SPGT0904**	
ZTD04-320-XP32-SP09-02	*	o	32	32	37	133	60	218	M22x2	0.966	SPGT0904**	
ZTD04-330-XP32-SP09-02	*	o	33	32	37	137	60	222	M22x2	1.016	SPGT0904**	
ZTD04-340-XP40-SP11-02	*	o	34	40	47	141	70	241	(BSPT)RC1/4	1.46	SPGT1104**	
ZTD04-350-XP40-SP11-02	*	o	35	40	47	145	70	245	(BSPT)RC1/4	1.52	SPGT1104**	
ZTD04-360-XP40-SP11-02	*	o	36	40	47	149	70	249	(BSPT)RC1/4	1.579	SPGT1104**	
ZTD04-370-XP40-SP11-02	*	o	37	40	47	153	70	253	(BSPT)RC1/4	1.592	SPGT1104**	
ZTD04-380-XP40-SP11-02	*	o	38	40	47	157	70	257	(BSPT)RC1/4	1.801	SPGT1104**	
ZTD04-390-XP40-SP11-02	*	o	39	40	47	161	70	261	(BSPT)RC1/4	1.801	SPGT1104**	
ZTD04-400-XP40-SP11-02	*	o	40	40	47	165	70	265	(BSPT)RC1/4	1.874	SPGT1104**	
ZTD04-410-XP40-SP11-02	*	o	41	40	47	169	70	269	(BSPT)RC1/4	1.861	SPGT1104**	
ZTD04-420-XP40-SP14-02	*	o	42	40	52	173	70	283	(BSPT)RC1/4	2.168	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			
ZTD04-430-XP40-SP14-02	*	o	43	40	52	177	70	287	(BSPT)RC1/4	2.17	SPGT1405**	
ZTD04-440-XP40-SP14-02	*	o	44	40	52	181	70	291	(BSPT)RC1/4	2.31	SPGT1405**	
ZTD04-450-XP40-SP14-02	*	o	45	40	52	185	70	295	(BSPT)RC1/4	2.421	SPGT1405**	
ZTD04-460-XP40-SP14-02	*	o	46	40	52	189	70	299	(BSPT)RC1/4	2.507	SPGT1405**	
ZTD04-470-XP40-SP14-02	*	o	47	40	52	193	70	303	(BSPT)RC1/4	2.612	SPGT1405**	
ZTD04-480-XP40-SP14-02	*	o	48	40	52	197	70	307	(BSPT)RC1/4	2.66	SPGT1405**	
ZTD04-490-XP40-SP14-02	*	o	49	40	52	201	70	311	(BSPT)RC1/4	2.836	SPGT1405**	
ZTD04-500-XP40-SP14-02	*	o	50	40	52	205	70	315	(BSPT)RC1/4	2.954	SPGT1405**	
ZTD04-520-XP50-SP07-04	*	o	52	50	62	213	80	325	(BSPT)RC1/4	3.685	SPGT07T3**	
ZTD04-530-XP50-SP07-04	*	o	53	50	62	217	80	329	(BSPT)RC1/4	3.777	SPGT07T3**	
ZTD04-540-XP50-SP09-04	*	o	54	50	57	222	80	333	(BSPT)RC1/4	3.906	SPGT0904**	
ZTD04-545-XP50-SP09-04	*	o	54.5	50	68	221	80	335	(BSPT)RC1/4	4.167	SPGT0904**	
ZTD04-595-XP50-SP09-04	*	o	59.5	50	68	241	80	355	(BSPT)RC1/4	4.784	SPGT0904**	

• Ex stock o 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

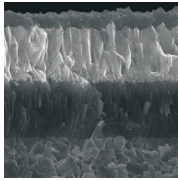

E

Index

A

Turning

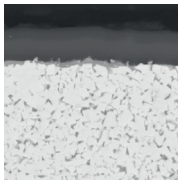
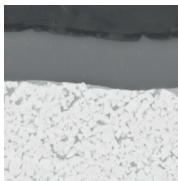
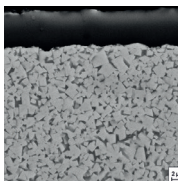
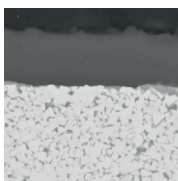
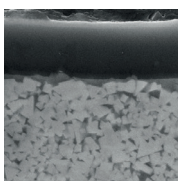
Coated cemented carbide CVD

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

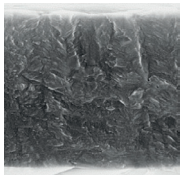
D

Technical Information

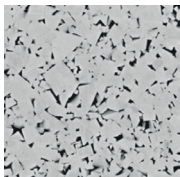
E

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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

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Milling

C

Drilling

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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
F Index	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

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