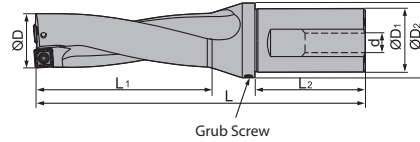


### Indexable drills series

ZTD05



Article	*	Stock	Dimensions [mm]								kg	Inserts
			ØD	ØD1	ØD2	L1	L2	L	d			
ZTD05-170-XP25-SP06-02	*	o	17	25	32	90	56	168	M13x1	0.374	SPGT0602**	
ZTD05-180-XP25-SP06-02	*	o	18	25	32	95	56	173	M13x1	0.394	SPGT0602**	
ZTD05-190-XP25-SP06-02	*	o	19	25	32	100	56	178	M13x1	0.415	SPGT0602**	
ZTD05-200-XP25-SP06-02	*	o	20	25	32	105	56	183	M13x1	0.44	SPGT0602**	
ZTD05-210-XP25-SP06-02	*	o	21	25	32	110	56	188	M16x1,5	0.466	SPGT0602**	
ZTD05-220-XP25-SP07-02	*	o	22	25	32	115	56	193	M16x1,5	0.476	SPGT07T3**	
ZTD05-230-XP25-SP07-02	*	o	23	25	32	120	56	198	M16x1,5	0.507	SPGT07T3**	
ZTD05-240-XP25-SP07-02	*	o	24	25	32	125	56	203	M16x1,5	0.542	SPGT07T3**	
ZTD05-250-XP25-SP07-02	*	o	25	25	32	130	56	208	M16x1,5	0.561	SPGT07T3**	
ZTD05-260-XP25-SP07-02	*	o	26	25	32	135	56	213	M16x1,5	0.613	SPGT07T3**	
ZTD05-270-XP25-SP07-02	*	o	27	25	32	140	56	218	M16x1,5	0.665	SPGT07T3**	
ZTD05-280-XP32-SP09-02	*	o	28	32	37	145	60	230	M16x1,5	0.891	SPGT0904**	
ZTD05-290-XP32-SP09-02	*	o	29	32	37	150	60	235	M16x1,5	0.965	SPGT0904**	
ZTD05-300-XP32-SP09-02	*	o	30	32	37	155	60	240	M16x1,5	0.959	SPGT0904**	
ZTD05-310-XP32-SP09-02	*	o	31	32	37	160	60	245	M16x1,5	1.042	SPGT0904**	
ZTD05-320-XP32-SP09-02	*	o	32	32	37	165	60	250	M22x2	1.11	SPGT0904**	
ZTD05-330-XP32-SP09-02	*	o	33	32	37	170	60	255	M22x2	1.117	SPGT0904**	
ZTD05-340-XP40-SP11-02	*	o	34	40	47	175	70	275	M22x2	1.57	SPGT1104**	
ZTD05-350-XP40-SP11-02	*	o	35	40	47	180	70	280	M22x2	1.65	SPGT1104**	
ZTD05-360-XP40-SP11-02	*	o	36	40	47	185	70	285	M22x2	1.712	SPGT1104**	
ZTD05-370-XP40-SP11-02	*	o	37	40	47	190	70	290	M22x2	1.802	SPGT1104**	
ZTD05-380-XP40-SP11-02	*	o	38	40	47	195	70	295	(BSPT)RC1/4	1.873	SPGT1104**	
ZTD05-390-XP40-SP11-02	*	o	39	40	47	200	70	300	(BSPT)RC1/4	1.962	SPGT1104**	
ZTD05-400-XP40-SP11-02	*	o	40	40	47	205	70	305	(BSPT)RC1/4	2.068	SPGT1104**	
ZTD05-410-XP40-SP11-02	*	o	41	40	47	210	70	310	(BSPT)RC1/4	2.167	SPGT1104**	
ZTD05-420-XP40-SP14-02	*	o	42	40	52	215	70	325	(BSPT)RC1/4	2.39	SPGT1405**	
ZTD05-430-XP40-SP14-02	*	o	43	40	52	220	70	330	(BSPT)RC1/4	2.502	SPGT1405**	
ZTD05-440-XP40-SP14-02	*	o	44	40	52	225	70	335	(BSPT)RC1/4	2.612	SPGT1405**	
ZTD05-450-XP40-SP14-02	*	o	45	40	52	230	70	340	(BSPT)RC1/4	2.733	SPGT1405**	
ZTD05-460-XP40-SP14-02	*	o	46	40	52	235	70	345	(BSPT)RC1/4	2.854	SPGT1405**	
ZTD05-470-XP40-SP14-02	*	o	47	40	52	240	70	350	(BSPT)RC1/4	2.894	SPGT1405**	
ZTD05-480-XP40-SP14-02	*	o	48	40	52	245	70	355	(BSPT)RC1/4	3.109	SPGT1405**	
ZTD05-490-XP40-SP14-02	*	o	49	40	52	250	70	360	(BSPT)RC1/4	3.271	SPGT1405**	
ZTD05-500-XP40-SP14-02	*	o	50	40	52	255	70	365	(BSPT)RC1/4	3.425	SPGT1405**	

● Ex stock    ○ On demand

\* Internal cooling

System code > C9




Grade selection > C8

Technical info > C201

Cutting data > C36


**A**

Turning

Spare parts		SPGT0602**	SPGT07T3**	SPGT0904**	SPGT1104**	SPGT1405**
	Grub screw				M6×6 (7.0Nm)	M8×8 (10.2Nm)
	Screw	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	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP

**B**

Milling

Insert

C34

**C**

Drilling

**D**

Technical  
Information

**E**

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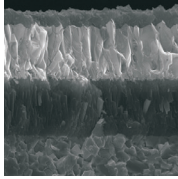

System code > C9

Grade selection > C8

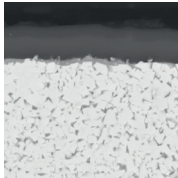
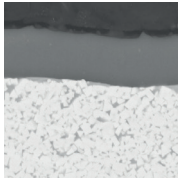
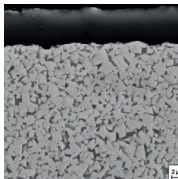
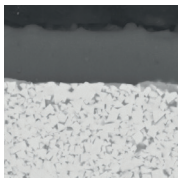
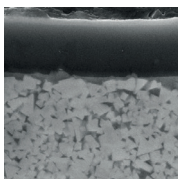
Technical info > C201

Cutting data > C36

## Coated cemented carbide CVD

Grade	ISO	Micro structure	Grade description
<b>YB6338</b>	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.
<b>YBD252</b>	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.

## Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
<b>YBG105</b>	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.
<b>YBG202</b>	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.
<b>YBS203</b>	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.
<b>YBG205</b>	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.
<b>YB9320</b>	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

A

Turning

B

Milling

C

Drilling

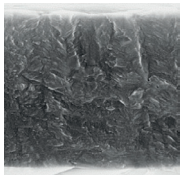
D

Technical  
Information

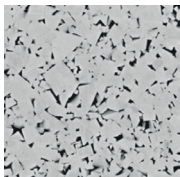
E

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**Coated cemented carbide PVD**

Grade	ISO	Micro structure	Grade description
<b>YBG212</b>	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
<b>YD201</b>	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

**D**Technical  
Information**E**

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## Application fields of grades – indexable drills

	ISO	HC <sup>1</sup> (CVD)	HC <sup>1</sup> (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					

<b>P</b>	Steel
<b>M</b>	Stainless steel
<b>K</b>	Cast iron

<b>N</b>	Non-ferrous alloys
<b>S</b>	Heat-resistant alloys
<b>H</b>	Hardened materials

HC<sup>1</sup> 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]
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
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