

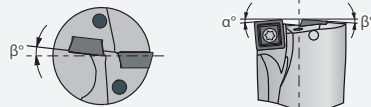
# ZTD series

## Indexable drills ZTD02/03/04/05

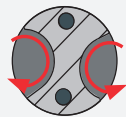
ZTD02



- For machining of steel, stainless steel, cast iron and heat-resistant alloys.
- Drilling bodies with PVD coated surfaces.
- Big chip pocket for better chip removal.
- Optional adapter for inner cooling in conventional machines.
- Diameter range 13.0–50.0 mm



Precise insert seat and stable insert clamping



Big chip pocket



Adapter for inner cooling

### Insert grades

**YB6338**

CVD  
P15–P35

**YBG205**

PVD  
P10–P30  
M20–M30  
S15–S35

**YBG212**

PVD  
M10–M25

### Chip breakers

-PM



• Steel and cast iron

-EM



• Stainless steel and heat-resistant alloys

# ZD – 03 300 – XP – 32 W C 05 – 02

1

2

3

4

5

6

7

8

9

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

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

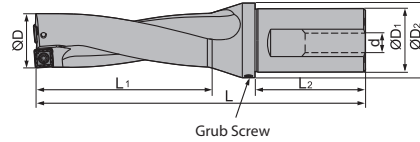
Technical Information

E

Index

## Indexable drills series

ZTD02



Article	*	Stock	Dimensions [mm]								kg	Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	L	d				
ZTD02-130-XP20-SP05-02	*	•	13	20	25	31	50	98	M13×1	0.165	SPGT0502**	ZTD-XP20-Thin	
ZTD02-140-XP20-SP05-02	*	•	14	20	25	33	50	100	M13×1	0.171	SPGT0502**	ZTD-XP20-Thin	
ZTD02-150-XP20-SP05-02	*	•	15	20	25	35	50	102	M13×1	0.176	SPGT0502**	ZTD-XP20-Thin	
ZTD02-160-XP20-SP05-02	*	•	16	20	25	37	50	104	M13×1	0.184	SPGT0502**	ZTD-XP20-Thin	
ZTD02-170-XP25-SP06-02	*	•	17	25	32	39	56	117	M16×1,5	0.325	SPGT0602**	ZTD-XP20-Thin	
ZTD02-180-XP25-SP06-02	*	•	18	25	32	41	56	119	M16×1,5	0.332	SPGT0602**	ZTD-XP25-Thin	
ZTD02-190-XP25-SP06-02	*	•	19	25	32	43	56	121	M16×1,5	0.342	SPGT0602**	ZTD-XP25-Thin	
ZTD02-200-XP25-SP06-02	*	•	20	25	32	45	56	123	M16×1,5	0.353	SPGT0602**	ZTD-XP25-Thin	
ZTD02-210-XP25-SP06-02	*	•	21	25	32	47	56	125	M16×1,5	0.35	SPGT0602**	ZTD-XP25-Thin	
ZTD02-220-XP25-SP07-02	*	•	22	25	32	49	56	127	M16×1,5	0.367	SPGT07T3**	ZTD-XP25-Thin	
ZTD02-230-XP25-SP07-02	*	•	23	25	32	51	56	129	M16×1,5	0.38	SPGT07T3**	ZTD-XP25-Thin	
ZTD02-240-XP25-SP07-02	*	•	24	25	32	53	56	131	M16×1,5	0.443	SPGT07T3**	ZTD-XP25-Thin	
ZTD02-250-XP25-SP07-02	*	•	25	25	32	55	56	133	M16×1,5	0.41	SPGT07T3**	ZTD-XP25-Thin	
ZTD02-260-XP25-SP07-02	*	•	26	25	32	57	56	135	M16×1,5	0.454	SPGT07T3**	ZTD-XP25-Thin	
ZTD02-270-XP25-SP07-02	*	•	27	25	32	59	56	137	M16×1,5	0.445	SPGT07T3**	ZTD-XP25-Thin	
ZTD02-280-XP32-SP09-02	*	•	28	32	37	61	60	146	M22×2	0.661	SPGT0904**	ZTD-XP32-Thin	
ZTD02-290-XP32-SP09-02	*	•	29	32	37	63	60	148	M22×2	0.682	SPGT0904**	ZTD-XP32-Thin	
ZTD02-300-XP32-SP09-02	*	•	30	32	37	65	60	150	M22×2	0.702	SPGT0904**	ZTD-XP32-Thin	
ZTD02-310-XP32-SP09-02	*	•	31	32	37	67	60	152	M22×2	0.759	SPGT0904**	ZTD-XP32-Thin	
ZTD02-320-XP32-SP09-02	*	•	32	32	37	69	60	154	M22×2	0.742	SPGT0904**	ZTD-XP32-Thin	
ZTD02-330-XP32-SP09-02	*	•	33	32	37	71	60	156	M22×2	0.774	SPGT0904**	ZTD-XP32-Thin	
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**		
ZTD02-450-XP40-SP14-02	*	•	45	40	52	95	70	205	(BSPT)RC1/4	1.76	SPGT1405**		

• Ex stock    ○ On demand




\* Internal cooling

System code > C7

Grade selection > C5




Technical info > C165

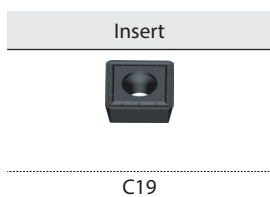
Cutting data > C22

Article	*	Stock	Dimensions [mm]							d		Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	L					
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					M6x6 (7.0Nm)	M8x8 (10.2Nm)
	Screw	I60M2x4,3 (0.5Nm)	I60M2,2x5,5 (0.8Nm)	I60M2.5*6.5 (1.0Nm)	I60M3,5x8 (2.7Nm)	I60M4x10 (3.4Nm)	I60M5x13 (6.7Nm)
	Wrench	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

System code > C7

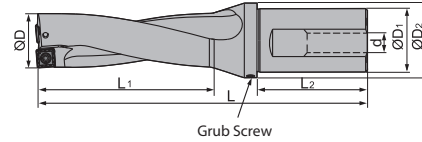
Grade selection > C5

Technical info > C165

Cutting data > C22

### Indexable drills series

ZTD03



Article	*	Stock	Dimensions [mm]								kg	Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	L	d				
ZTD03-130-XP20-SP05-02	*	●	13	20	25	44	50	111	M13×1	0.179	SPGT0502**	ZTD-XP20-Thin	
ZTD03-140-XP20-SP05-02	*	●	14	20	25	47	50	114	M13×1	0.186	SPGT0502**	ZTD-XP20-Thin	
ZTD03-150-XP20-SP05-02	*	●	15	20	25	50	50	117	M13×1	0.195	SPGT0502**	ZTD-XP20-Thin	
ZTD03-160-XP20-SP05-02	*	●	16	20	25	53	50	120	M13×1	0.214	SPGT0502**	ZTD-XP20-Thin	
ZTD03-170-XP25-SP06-02	*	●	17	25	32	56	56	134	M16×1,5	0.32	SPGT0602**	ZTD-XP25-Thin	
ZTD03-180-XP25-SP06-02	*	●	18	25	32	59	56	137	M16×1,5	0.331	SPGT0602**	ZTD-XP25-Thin	
ZTD03-190-XP25-SP06-02	*	●	19	25	32	62	56	140	M16×1,5	0.342	SPGT0602**	ZTD-XP25-Thin	
ZTD03-200-XP25-SP06-02	*	●	20	25	32	65	56	143	M16×1,5	0.356	SPGT0602**	ZTD-XP25-Thin	
ZTD03-210-XP25-SP06-02	*	●	21	25	32	68	56	146	M16×1,5	0.391	SPGT0602**	ZTD-XP25-Thin	
ZTD03-220-XP25-SP07-02	*	●	22	25	32	71	56	149	M16×1,5	0.391	SPGT07T3**	ZTD-XP25-Thin	
ZTD03-230-XP25-SP07-02	*	●	23	25	32	74	56	152	M16×1,5	0.442	SPGT07T3**	ZTD-XP25-Thin	
ZTD03-240-XP25-SP07-02	*	●	24	25	32	77	56	155	M16×1,5	0.485	SPGT07T3**	ZTD-XP25-Thin	
ZTD03-250-XP25-SP07-02	*	●	25	25	32	80	56	158	M16×1,5	0.492	SPGT07T3**	ZTD-XP25-Thin	
ZTD03-260-XP25-SP07-02	*	●	26	25	32	83	56	161	M16×1,5	0.497	SPGT07T3**	ZTD-XP25-Thin	
ZTD03-270-XP25-SP07-02	*	●	27	25	32	86	56	164	M16×1,5	0.521	SPGT07T3**	ZTD-XP25-Thin	
ZTD03-280-XP32-SP09-02	*	●	28	32	37	89	60	174	M22×2	0.75	SPGT0904**	ZTD-XP32-Thin	
ZTD03-290-XP32-SP09-02	*	●	29	32	37	92	60	177	M22×2	0.777	SPGT0904**	ZTD-XP32-Thin	
ZTD03-300-XP32-SP09-02	*	●	30	32	37	95	60	180	M22×2	0.81	SPGT0904**	ZTD-XP32-Thin	
ZTD03-310-XP32-SP09-02	*	●	31	32	37	98	60	183	M22×2	0.831	SPGT0904**	ZTD-XP32-Thin	
ZTD03-320-XP32-SP09-02	*	●	32	32	37	101	60	186	M22×2	0.867	SPGT0904**	ZTD-XP32-Thin	
ZTD03-330-XP32-SP09-02	*	●	33	32	37	104	60	189	M22×2	0.928	SPGT0904**	ZTD-XP32-Thin	
ZTD03-340-XP40-SP11-02	*	●	34	40	47	107	70	207	(BSPT)RC1/4	1.33	SPGT1104**		
ZTD03-350-XP40-SP11-02	*	●	35	40	47	110	70	210	(BSPT)RC1/4	1.371	SPGT1104**		
ZTD03-360-XP40-SP11-02	*	●	36	40	47	113	70	213	(BSPT)RC1/4	1.414	SPGT1104**		
ZTD03-370-XP40-SP11-02	*	●	37	40	47	116	70	216	(BSPT)RC1/4	1.448	SPGT1104**		
ZTD03-380-XP40-SP11-02	*	●	38	40	47	119	70	219	(BSPT)RC1/4	1.498	SPGT1104**		
ZTD03-390-XP40-SP11-02	*	●	39	40	47	122	70	222	(BSPT)RC1/4	1.554	SPGT1104**		
ZTD03-400-XP40-SP11-02	*	●	40	40	47	125	70	225	(BSPT)RC1/4	1.667	SPGT1104**		
ZTD03-410-XP40-SP11-02	*	●	41	40	47	128	70	228	(BSPT)RC1/4	1.653	SPGT1104**		
ZTD03-420-XP40-SP14-02	*	●	42	40	52	131	70	241	(BSPT)RC1/4	1.903	SPGT1405**		
ZTD03-430-XP40-SP14-02	*	●	43	40	52	134	70	244	(BSPT)RC1/4	1.951	SPGT1405**		
ZTD03-440-XP40-SP14-02	*	●	44	40	52	137	70	247	(BSPT)RC1/4	2.039	SPGT1405**		
ZTD03-450-XP40-SP14-02	*	●	45	40	52	140	70	250	(BSPT)RC1/4	2.12	SPGT1405**		

● Ex stock ○ On demand




\* Internal cooling

System code > C7

Grade selection > C5




Technical info > C165

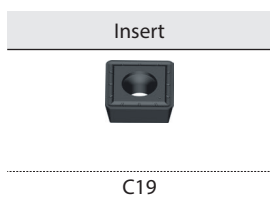
Cutting data > C22

Article	* Stock	Dimensions [mm]							d		Inserts 	Adapter 
		ØD	ØD1	ØD2	L1	L2	L					
ZTD03-460-XP40-SP14-02	* ●	46	40	52	143	70	253	(BSPT)RC1/4	2.186	SPGT1405**		
ZTD03-470-XP40-SP14-02	* ●	47	40	52	146	70	256	(BSPT)RC1/4	2.264	SPGT1405**		
ZTD03-480-XP40-SP14-02	* ●	48	40	52	149	70	259	(BSPT)RC1/4	2.341	SPGT1405**		
ZTD03-490-XP40-SP14-02	* ●	49	40	52	152	70	262	(BSPT)RC1/4	2.43	SPGT1405**		
ZTD03-500-XP40-SP14-02	* ●	50	40	52	155	70	265	(BSPT)RC1/4	2.52	SPGT1405**		

● Ex stock ○ On demand

\* Internal cooling

Spare parts							
	Insert	SPGT0502**	SPGT0602**	SPGT07T3**	SPGT0904**	SPGT1104**	SPGT1405**
	Grub screw					M6x6 (7.0Nm)	M8x8 (10.2Nm)
	Screw	I60M2x4,3 (0.5Nm)	I60M2,2x5,5 (0.8Nm)	I60M2.5*6.5 (1.0Nm)	I60M3,5x8 (2.7Nm)	I60M4x10 (3.4Nm)	I60M5x13 (6.7Nm)
	Wrench	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

System code > C7

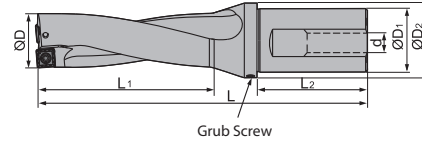
Grade selection > C5

Technical info > C165

Cutting data > C22

### Indexable drills series

ZTD04



Article	*	Stock	Dimensions [mm]								kg	Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	L	d				
ZTD04-130-XP20-SP05-02	*	●	13	20	25	57	50	124	M13×1	0.185	SPGT0502**	ZTD-XP20-Thin	
ZTD04-140-XP20-SP05-02	*	○	14	20	25	61	50	128	M13×1	0.195	SPGT0502**	ZTD-XP20-Thin	
ZTD04-150-XP20-SP05-02	*	○	15	20	25	65	50	132	M13×1	0.205	SPGT0502**	ZTD-XP20-Thin	
ZTD04-160-XP20-SP05-02	*	●	16	20	25	69	50	136	M13×1	0.216	SPGT0502**	ZTD-XP20-Thin	
ZTD04-170-XP25-SP06-02	*	●	17	25	32	73	56	151	M16×1,5	0.333	SPGT0602**	ZTD-XP25-Thin	
ZTD04-180-XP25-SP06-02	*	●	18	25	32	77	56	155	M16×1,5	0.347	SPGT0602**	ZTD-XP25-Thin	
ZTD04-190-XP25-SP06-02	*	●	19	25	32	81	56	159	M16×1,5	0.362	SPGT0602**	ZTD-XP25-Thin	
ZTD04-200-XP25-SP06-02	*	●	20	25	32	85	56	163	M16×1,5	0.381	SPGT0602**	ZTD-XP25-Thin	
ZTD04-210-XP25-SP06-02	*	●	21	25	32	89	56	167	M16×1,5	0.4	SPGT0602**	ZTD-XP25-Thin	
ZTD04-220-XP25-SP07-02	*	●	22	25	32	93	56	171	M16×1,5	0.391	SPGT07T3**	ZTD-XP25-Thin	
ZTD04-230-XP25-SP07-02	*	●	23	25	32	97	56	175	M16×1,5	0.484	SPGT07T3**	ZTD-XP25-Thin	
ZTD04-240-XP25-SP07-02	*	●	24	25	32	101	56	179	M16×1,5	0.513	SPGT07T3**	ZTD-XP25-Thin	
ZTD04-250-XP25-SP07-02	*	●	25	25	32	105	56	183	M16×1,5	0.494	SPGT07T3**	ZTD-XP25-Thin	
ZTD04-260-XP25-SP07-02	*	●	26	25	32	109	56	187	M16×1,5	0.535	SPGT07T3**	ZTD-XP25-Thin	
ZTD04-270-XP25-SP07-02	*	●	27	25	32	113	56	191	M16×1,5	0.582	SPGT07T3**	ZTD-XP25-Thin	
ZTD04-280-XP32-SP09-02	*	●	28	32	37	117	60	202	M22×2	0.653	SPGT0904**	ZTD-XP32-Thin	
ZTD04-290-XP32-SP09-02	*	●	29	32	37	121	60	206	M22×2	0.846	SPGT0904**	ZTD-XP32-Thin	
ZTD04-300-XP32-SP09-02	*	●	30	32	37	125	60	210	M22×2	0.893	SPGT0904**	ZTD-XP32-Thin	
ZTD04-310-XP32-SP09-02	*	●	31	32	37	129	60	214	M22×2	0.914	SPGT0904**	ZTD-XP32-Thin	
ZTD04-320-XP32-SP09-02	*	●	32	32	37	133	60	218	M22×2	0.966	SPGT0904**	ZTD-XP32-Thin	
ZTD04-330-XP32-SP09-02	*	●	33	32	37	137	60	222	M22×2	1.016	SPGT0904**	ZTD-XP32-Thin	
ZTD04-340-XP40-SP11-02	*	●	34	40	47	141	70	241	(BSPT)RC1/4	1.46	SPGT1104**		
ZTD04-350-XP40-SP11-02	*	●	35	40	47	145	70	245	(BSPT)RC1/4	1.52	SPGT1104**		
ZTD04-360-XP40-SP11-02	*	●	36	40	47	149	70	249	(BSPT)RC1/4	1.579	SPGT1104**		
ZTD04-370-XP40-SP11-02	*	●	37	40	47	153	70	253	(BSPT)RC1/4	1.592	SPGT1104**		
ZTD04-380-XP40-SP11-02	*	●	38	40	47	157	70	257	(BSPT)RC1/4	1.801	SPGT1104**		
ZTD04-390-XP40-SP11-02	*	●	39	40	47	161	70	261	(BSPT)RC1/4	1.801	SPGT1104**		
ZTD04-400-XP40-SP11-02	*	●	40	40	47	165	70	265	(BSPT)RC1/4	1.874	SPGT1104**		
ZTD04-410-XP40-SP11-02	*	●	41	40	47	169	70	269	(BSPT)RC1/4	1.861	SPGT1104**		
ZTD04-420-XP40-SP14-02	*	●	42	40	52	173	70	283	(BSPT)RC1/4	2.168	SPGT1405**		
ZTD04-430-XP40-SP14-02	*	●	43	40	52	177	70	287	(BSPT)RC1/4	2.17	SPGT1405**		
ZTD04-440-XP40-SP14-02	*	●	44	40	52	181	70	291	(BSPT)RC1/4	2.31	SPGT1405**		
ZTD04-450-XP40-SP14-02	*	●	45	40	52	185	70	295	(BSPT)RC1/4	2.421	SPGT1405**		

● Ex stock    ○ On demand




\* Internal cooling

System code > C7

Grade selection > C5




Technical info > C165

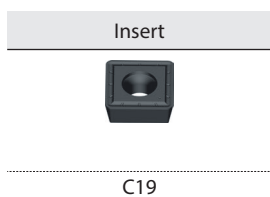
Cutting data > C22

Article	* Stock	Dimensions [mm]							d		Inserts 	Adapter 
		ØD	ØD1	ØD2	L1	L2	L					
ZTD04-460-XP40-SP14-02	* ●	46	40	52	189	70	299	(BSPT)RC1/4	2.507	SPGT1405**		
ZTD04-470-XP40-SP14-02	* ●	47	40	52	193	70	303	(BSPT)RC1/4	2.612	SPGT1405**		
ZTD04-480-XP40-SP14-02	* ●	48	40	52	197	70	307	(BSPT)RC1/4	2.66	SPGT1405**		
ZTD04-490-XP40-SP14-02	* ●	49	40	52	201	70	311	(BSPT)RC1/4	2.836	SPGT1405**		
ZTD04-500-XP40-SP14-02	* ●	50	40	52	205	70	315	(BSPT)RC1/4	2.954	SPGT1405**		

● Ex stock ○ On demand

\* Internal cooling

Spare parts							
	Insert	SPGT0502**	SPGT0602**	SPGT07T3**	SPGT0904**	SPGT1104**	SPGT1405**
	Grub screw					M6x6 (7.0Nm)	M8x8 (10.2Nm)
	Screw	I60M2x4,3 (0.5Nm)	I60M2.5x6.5 (1.0Nm)	I60M2.5x6.5 (1.0Nm)	I60M3,5x8 (2.7Nm)	I60M4x10 (3.4Nm)	I60M5x13 (6.7Nm)
	Wrench	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

System code > C7

Grade selection > C5

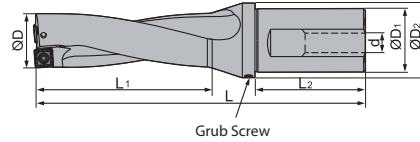
Technical info > C165

Cutting data > C22



### Indexable drills series

ZTD05



Grub Screw

Article	*	Stock	Dimensions [mm]								kg	Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	L	d				
ZTD05-170-XP25-SP06-02	*	•	17	25	32	90	56	168	M13×1	0.374	SPGT0602**	ZTD-XP25-Thin	
ZTD05-180-XP25-SP06-02	*	•	18	25	32	95	56	173	M13×1	0.394	SPGT0602**	ZTD-XP25-Thin	
ZTD05-190-XP25-SP06-02	*	•	19	25	32	100	56	178	M13×1	0.415	SPGT0602**	ZTD-XP25-Thin	
ZTD05-200-XP25-SP06-02	*	•	20	25	32	105	56	183	M13×1	0.44	SPGT0602**	ZTD-XP25-Thin	
ZTD05-210-XP25-SP06-02	*	•	21	25	32	110	56	188	M16×1,5	0.466	SPGT0602**	ZTD-XP25-Thin	
ZTD05-220-XP25-SP07-02	*	•	22	25	32	115	56	193	M16×1,5	0.476	SPGT07T3**	ZTD-XP25-Thin	
ZTD05-230-XP25-SP07-02	*	○	23	25	32	120	56	198	M16×1,5	0.507	SPGT07T3**	ZTD-XP25-Thin	
ZTD05-240-XP25-SP07-02	*	•	24	25	32	125	56	203	M16×1,5	0.542	SPGT07T3**	ZTD-XP25-Thin	
ZTD05-250-XP25-SP07-02	*	•	25	25	32	130	56	208	M16×1,5	0.561	SPGT07T3**	ZTD-XP25-Thin	
ZTD05-260-XP25-SP07-02	*	•	26	25	32	135	56	213	M16×1,5	0.613	SPGT07T3**	ZTD-XP25-Thin	
ZTD05-270-XP25-SP07-02	*	•	27	25	32	140	56	218	M16×1,5	0.665	SPGT07T3**	ZTD-XP25-Thin	
ZTD05-280-XP32-SP09-02	*	•	28	32	37	145	60	230	M16×1,5	0.891	SPGT0904**	ZTD-XP32-Thin	
ZTD05-290-XP32-SP09-02	*	•	29	32	37	150	60	235	M16×1,5	0.965	SPGT0904**	ZTD-XP32-Thin	
ZTD05-300-XP32-SP09-02	*	•	30	32	37	155	60	240	M16×1,5	0.959	SPGT0904**	ZTD-XP32-Thin	
ZTD05-310-XP32-SP09-02	*	•	31	32	37	160	60	245	M16×1,5	1.042	SPGT0904**	ZTD-XP32-Thin	
ZTD05-320-XP32-SP09-02	*	•	32	32	37	165	60	250	M22×2	1.11	SPGT0904**	ZTD-XP32-Thin	
ZTD05-330-XP32-SP09-02	*	•	33	32	37	170	60	255	M22×2	1.117	SPGT0904**	ZTD-XP32-Thin	
ZTD05-340-XP40-SP11-02	*	•	34	40	47	175	70	275	M22×2	1.57	SPGT1104**		
ZTD05-350-XP40-SP11-02	*	•	35	40	47	180	70	280	M22×2	1.65	SPGT1104**		
ZTD05-360-XP40-SP11-02	*	•	36	40	47	185	70	285	M22×2	1.712	SPGT1104**		
ZTD05-370-XP40-SP11-02	*	•	37	40	47	190	70	290	M22×2	1.802	SPGT1104**		
ZTD05-380-XP40-SP11-02	*	•	38	40	47	195	70	295	(BSPT)RC1/4	1.873	SPGT1104**		
ZTD05-390-XP40-SP11-02	*	•	39	40	47	200	70	300	(BSPT)RC1/4	1.962	SPGT1104**		
ZTD05-400-XP40-SP11-02	*	•	40	40	47	205	70	305	(BSPT)RC1/4	2.068	SPGT1104**		
ZTD05-410-XP40-SP11-02	*	•	41	40	47	210	70	310	(BSPT)RC1/4	2.167	SPGT1104**		
ZTD05-420-XP40-SP14-02	*	•	42	40	52	215	70	325	(BSPT)RC1/4	2.39	SPGT1405**		
ZTD05-430-XP40-SP14-02	*	•	43	40	52	220	70	330	(BSPT)RC1/4	2.502	SPGT1405**		
ZTD05-440-XP40-SP14-02	*	•	44	40	52	225	70	335	(BSPT)RC1/4	2.612	SPGT1405**		
ZTD05-450-XP40-SP14-02	*	•	45	40	52	230	70	340	(BSPT)RC1/4	2.733	SPGT1405**		
ZTD05-460-XP40-SP14-02	*	•	46	40	52	235	70	345	(BSPT)RC1/4	2.854	SPGT1405**		
ZTD05-470-XP40-SP14-02	*	•	47	40	52	240	70	350	(BSPT)RC1/4	2.894	SPGT1405**		
ZTD05-480-XP40-SP14-02	*	•	48	40	52	245	70	355	(BSPT)RC1/4	3.109	SPGT1405**		
ZTD05-490-XP40-SP14-02	*	•	49	40	52	250	70	360	(BSPT)RC1/4	3.271	SPGT1405**		
ZTD05-500-XP40-SP14-02	*	•	50	40	52	255	70	365	(BSPT)RC1/4	3.425	SPGT1405**		

• Ex stock    ○ On demand




\* Internal cooling

System code > C7


Grade selection > C5

Technical info > C165

Cutting data > C22

Spare parts						
	Insert	SPGT0602**	SPGT07T3**	SPGT0904**	SPGT1104**	SPGT1405**
	Grub screw				M6x6 (7.0Nm)	M8x8 (10.2Nm)
	Screw	I60M2.5x6.5 (1.0Nm)	I60M2.5x6.5 (1.0Nm)	I60M3,5x8 (2.7Nm)	I60M4x10 (3.4Nm)	I60M5x13 (6.7Nm)
	Wrench	WT07IP	WT06IP	WT15IP	WT15IP	WT20IP

Insert



C19

**A**

Turning

**B**

Milling

**C**

Drilling

**D**

Technical  
Information

**E**

Index

System code > C7

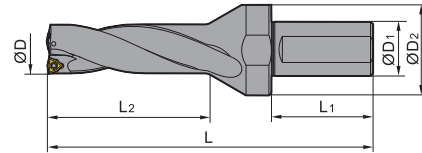
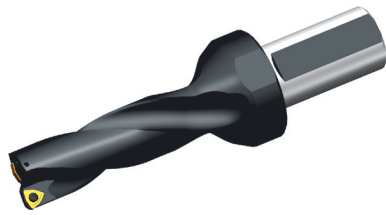
Grade selection > C5

Technical info > C165

Cutting data > C22

## 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 > C7

Grade selection > C5



Technical info > C165

Cutting data > C22


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	161	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	I60M2.5x6.5 (1.0Nm)	I60M2.5x6.5T (1.0Nm)	I60M3x7 (1.8Nm)	I60M3x7 (1.8Nm)	I60M3.5x10.4 (2.7Nm)
	Wrench	WT06IP	WT07IP	WT15IP	WT15IP	WT20IP

Insert



Medium Cut  
C20

System code > C7

Grade selection > C5

Technical info > C165

Cutting data > C22





A  
Turning  
B  
Milling  
C  
Drilling  
D  
Technical Information  
E  
Index

**W C M X 08 04 12 R – PG**



**1 2 3 4 5 6 7 8 9**

**A**



Turning

Insert shape	
W	
S	

**1**

Clearance angle	
C	
P	


**2**

Tolerance class			
			
Code	I.C [mm]	m [mm]	S [mm]
G	±0,025	±0,025	±0,130
M	±0,05-0,13	±0,08-0,18	±0,130

**3**

**B**

Milling

Fastening features (metric)	
Insert shape	
T	
X	Special

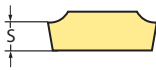
**4**

Cutting edge length l [mm]		
I.C [mm]	Insert shape	
	S	W
3,8		03
4,3		04
5,4		05
6,35	06	
6,5		06
8,0		08
8,7	08	
9,252	09	
12,7	12	

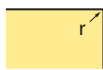
**5**

**C**

Drilling

Insert thickness S [mm]			
			
Code	S	Code	S
00	0,79	05	5,56
T0	0,99	T5	5,95
01	1,59	06	6,35
T1	1,98	T6	6,75
02	2,38	07	7,94
T2	2,58	09	9,52
03	3,18	T9	9,72
T3	3,97	11	11,11
04	4,76	12	12,70
T4	4,96		

**6**

Nose radius r [mm]	
	
Code	r
04	0,4
08	0,8
12	1,2

**7**

Rotation direction	
Code	Description
R	Right
L	Left

**8**




**E**

Index

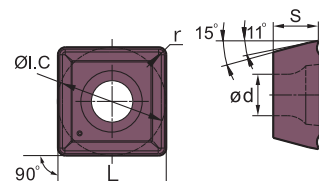















Chip breaker overview (on page C3)

**9**

SPGT	L	I.C	S	d
05 02	5	5	2.38	2.2
06 02	6	6	2.38	2.6
07 T3	7.94	7.94	3.97	2.8
09 04	9.8	9.8	4.76	4.2
11 04	11.5	11.5	4.76	4.4
14 05	14.3	14.3	5.2	5.75





-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

**Drilling inserts**

SP** drilling insert			HC <sup>1</sup> (CVD)	HC <sup>1</sup> (PVD)	HW
	<b>P</b>		 	  	
	<b>M</b>			  	
	<b>K</b>				
	<b>N</b>				
	<b>S</b>			 	
	<b>H</b>				
ISO		r	YB6338 YBD252	YBG202 YBG205 YBG212	YD201
	<b>SPGT050204-PM</b>	0.4	●	● ●	
	<b>SPGT060204-PM</b>	0.4	●	● ●	
	<b>SPGT07T308-PM</b>	0.8	●	● ●	
	<b>SPGT090408-PM</b>	0.8	●	● ●	
	<b>SPGT110408-PM</b>	0.8	●	● ●	
	<b>SPGT140512-PM</b>	1.2	●	● ●	
	<b>SPGT050204-EM</b>	0.4		● ●	
	<b>SPGT060204-EM</b>	0.4		● ●	
	<b>SPGT07T308-EM</b>	0.8		● ●	
	<b>SPGT090408-EM</b>	0.8		● ●	
	<b>SPGT110408-EM</b>	0.8		● ●	
	<b>SPGT140512-EM</b>	1.2		● ●	

● Ex stock      ○ On demand

HC<sup>1</sup> Coated carbide  
HW Uncoated carbide

Tool holder			
ZTD02	ZTD03	ZTD04	ZTD05
			
C8	C10	C12	C14

System code > C18

Grade selection > C5

Technical info > C165

Cutting data > C22



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

**A**

Turning

**B**

Milling

**C**

Drilling




**D**

Technical Information

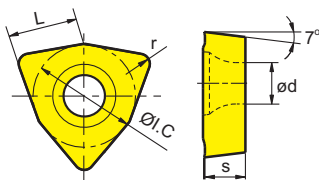
















**E**

Index

WCMX	L	I.C	S	d
03 02	3.8	5.56	2.38	2.8
04 02	4.3	6.35	2.38	3.1
05 03	5.4	7.94	3.18	3.2
06 T3	6.5	9.525	3.97	3.7
08 04	8.7	12.7	4.76	4.3

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

## Drilling inserts

WC** drilling insert			HC <sup>1</sup> (CVD)	HC <sup>1</sup> (PVD)	HW
	<b>P</b>		 	  	
	<b>M</b>			  	
	<b>K</b>				
	<b>N</b>				
	<b>S</b>			 	
	<b>H</b>				
ISO		r	YB6338 YBD252	YBG202 YBG205 YBG212	YD201
	<b>WCMX030208R-53</b>	0.8	●	●	
	<b>WCMX040208R-53</b>	0.8	●	●	○
	<b>WCMX050308R-53</b>	0.8	●	●	
	<b>WCMX06T308R-53</b>	0.8	●	●	○
	<b>WCMX080412R-53</b>	1.2	●	●	
	<b>WCMX050308-D</b>	0.8	○		
	<b>WCMX06T308-D</b>	0.8	○		
	<b>WCMX080412-D</b>	1.2	●		
	<b>WCMX030208R-PG</b>	0.8		●	
	<b>WCMX040208R-PG</b>	0.8		●	
	<b>WCMX050308R-PG</b>	0.8	○	● ○	
	<b>WCMX06T308R-PG</b>	0.8		●	
	<b>WCMX080412R-PG</b>	1.2		●	


● Ex stock      ○ On demand

HC<sup>1</sup> Coated carbide  
HW Uncoated carbide

Tool holder

ZD03

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C16



**Notes**

Dotted lines for writing notes.

**A**

Turning

**B**

Milling

**C**

Drilling

**D**

Technical  
Information

**E**

Index