

ZSD Drilling System

Indexable Drills ZSD02/03/04/05



– EN –



ZCC Cutting Tools Europe GmbH

your Partner | your Value

ZSD series

Indexable drills ZSD02/03/04/05

- For machining of steel, stainless steel, cast iron and heat-resistant alloys.
- Drilling bodies with special design for high rigidity.
- **Three chip breakers with wiper function for a wide range of applications.**
- Diameter range 12.0–50.0 mm

ZSD02

Insert grades

YB9320	YBG212	YBS203	YB6338
PVD	PVD	PVD	CVD
P10 – P30	P20-P35	M15 – M35	P20-P30
M10 – M25	M10 – M25	S10 – S30	K20 – K30

Chip breakers

- Mark of cut conners for optimal positioning
- **Wiper-Technology:** Excellent surface quality and precise drilling

-XM



- All-rounder geometry with a lot good chip control for steel and cast

-EM



- Optimized geometry with a very good chip control for stainless steel and super alloys

-LM



- light cutting geometry with very good chip control for soft steels

ZSD – 03 300 – XP – 32 S P 09 – 02**A**

Turning

B

Milling

C

Drilling

DTechnical
Information**E**

Index

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

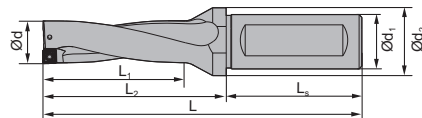
8

Number of teeth

9

Indexable drills series

ZSD02



Articel	*	Stock	Dimensions [mm]								Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	LS	L	kg		
ZSD02-120-XP20-SP04-02	*	•	12.0	20	25	27	44	50	94		SPMX040204**	
ZSD02-125-XP20-SP04-02	*	•	12.5	20	25	28	45	50	95		SPMX040204**	
ZSD02-130-XP20-SP04-02	*	•	13.0	20	25	29	46	50	96		SPMX040204**	
ZSD02-135-XP20-SP04-02	*	•	13.5	20	25	30	47	50	97		SPMX040204**	
ZSD02-140-XP20-SP04-02	*	•	14.0	20	25	31	48	50	98		SPMX040204**	
ZSD02-145-XP20-SP04-02	*	•	14.5	20	25	32	49	50	99		SPMX040204**	
ZSD02-150-XP20-SP05-02	*	•	15.0	20	25	33	50	50	100		SPMX050204**	
ZSD02-155-XP20-SP05-02	*	•	15.5	20	25	34	51	50	101		SPMX050204**	
ZSD02-160-XP20-SP05-02	*	•	16.0	20	25	35	52	50	102		SPMX050204**	
ZSD02-165-XP20-SP05-02	*	•	16.5	20	25	36	53	50	103		SPMX050204**	
ZSD02-170-XP20-SP05-02	*	•	17.0	20	25	37	54	50	104		SPMX050204**	
ZSD02-175-XP20-SP05-02	*	•	17.5	20	25	38	55	50	105		SPMX050204**	
ZSD02-180-XP25-SP06-02	*	•	18.0	25	32	39	57	56	113		SPMX060204**	
ZSD02-185-XP25-SP06-02	*	•	18.5	25	32	40	58	56	114		SPMX060204**	
ZSD02-190-XP25-SP06-02	*	•	19.0	25	32	41	59	56	115		SPMX060204**	
ZSD02-195-XP25-SP06-02	*	•	19.5	25	32	42	60	56	116		SPMX060204**	
ZSD02-200-XP25-SP06-02	*	•	20.0	25	32	43	61	56	117		SPMX060204**	
ZSD02-205-XP25-SP06-02	*	•	20.5	25	32	44	62	56	118		SPMX060204**	
ZSD02-210-XP25-SP06-02	*	•	21.0	25	32	45	63	56	119		SPMX060204**	
ZSD02-215-XP25-SP06-02	*	•	21.5	25	32	46	64	56	120		SPMX060204**	
ZSD02-220-XP25-SP06-02	*	•	22.0	25	32	47	65	56	121		SPMX060204**	
ZSD02-225-XP25-SP07-02	*	•	22.5	25	32	48	66	56	122		SPMX07T308**	
ZSD02-230-XP25-SP07-02	*	•	23.0	25	32	49	67	56	123		SPMX07T308**	
ZSD02-235-XP25-SP07-02	*	•	23.5	25	32	50	68	56	124		SPMX07T308**	
ZSD02-240-XP25-SP07-02	*	•	24.0	25	32	51	69	56	125		SPMX07T308**	
ZSD02-245-XP25-SP07-02	*	•	24.5	25	32	52	70	56	126		SPMX07T308**	
ZSD02-250-XP25-SP07-02	*	•	25.0	25	32	53	71	56	127		SPMX07T308**	
ZSD02-255-XP25-SP07-02	*	•	25.5	25	32	54	72	56	128		SPMX07T308**	
ZSD02-260-XP25-SP07-02	*	•	26.0	25	32	55	73	56	129		SPMX07T308**	
ZSD02-265-XP25-SP07-02	*	•	26.5	25	32	56	74	56	130		SPMX07T308**	
ZSD02-270-XP25-SP07-02	*	•	27.0	25	32	57	75	56	131		SPMX07T308**	
ZSD02-275-XP25-SP07-02	*	•	27.5	25	32	58	76	56	132		SPMX07T308**	
ZSD02-280-XP32-SP09-02	*	•	28.0	32	37	59	79	60	139		SPMX090408**	

• Ex stock ○ On demand

* Internal cooling

Articel	✱	Stock	Dimensions [mm]							Inserts 	Adapter 
			ØD	ØD1	ØD2	L1	L2	LS	L		
ZSD02-290-XP32-SP09-02	✱	●	29,0	32	37	60	81	60	141	SPMX090408**	
ZSD02-300-XP32-SP09-02	✱	●	30,0	32	37	61	83	60	143	SPMX090408**	
ZSD02-310-XP32-SP09-02	✱	●	31,0	32	37	65	85	60	145	SPMX090408**	
ZSD02-320-XP32-SP09-02	✱	●	32,0	32	37	67	87	60	147	SPMX090408**	
ZSD02-330-XP32-SP09-02	✱	●	33,0	32	37	69	89	60	149	SPMX090408**	
ZSD02-340-XP40-SP11-02	✱	●	34,0	40	47	71	96	70	166	SPMX110408**	
ZSD02-350-XP40-SP11-02	✱	●	35,0	40	47	73	98	70	168	SPMX110408**	
ZSD02-360-XP40-SP11-02	✱	●	36,0	40	47	75	100	70	170	SPMX110408**	
ZSD02-370-XP40-SP11-02	✱	●	37,0	40	47	77	102	70	172	SPMX110408**	
ZSD02-380-XP40-SP11-02	✱	●	38,0	40	47	79	104	70	174	SPMX110408**	
ZSD02-390-XP40-SP11-02	✱	●	39,0	40	47	81	106	70	176	SPMX110408**	
ZSD02-400-XP40-SP11-02	✱	●	40,0	40	47	83	108	70	178	SPMX110408**	
ZSD02-410-XP40-SP11-02	✱	●	41,0	40	47	85	110	70	180	SPMX110408**	
ZSD02-420-XP40-SP14-02	✱	●	42,0	40	52	87	119	70	189	SPMX140512**	
ZSD02-430-XP40-SP14-02	✱	●	43,0	40	52	89	121	70	191	SPMX140512**	
ZSD02-440-XP40-SP14-02	✱	●	44,0	40	52	91	123	70	193	SPMX140512**	
ZSD02-450-XP40-SP14-02	✱	●	45,0	40	52	93	125	70	195	SPMX140512**	
ZSD02-460-XP40-SP14-02	✱	●	46,0	40	52	95	127	70	197	SPMX140512**	
ZSD02-470-XP40-SP14-02	✱	●	47,0	40	52	97	129	70	199	SPMX140512**	
ZSD02-480-XP40-SP14-02	✱	●	48,0	40	52	99	131	70	201	SPMX140512**	
ZSD02-490-XP40-SP14-02	✱	●	49,0	40	52	102	133	70	203	SPMX140512**	
ZSD02-500-XP40-SP14-02	✱	●	50,0	40	52	103	135	70	205	SPMX140512**	
ZSD02-510-XP50-SP14-02	✱	●	51,0	50	57	105	137	80	217	SPMX110408**	
ZSD02-520-XP50-SP14-02	✱	●	52,0	50	57	107	139	80	219	SPMX140512**	
ZSD02-530-XP50-SP14-02	✱	●	53,0	50	57	109	141	80	221	SPMX140512**	
ZSD02-540-XP50-SP09-04	✱	●	54,0	50	57	111	143	80	223	SPMX090408**	
ZSD02-550-XP50-SP09-04	✱	●	55,0	50	57	113	145	80	225	SPMX090408**	
ZSD02-560-XP50-SP09-04	✱	●	56,0	50	57	115	147	80	227	SPMX090408**	
ZSD02-570-XP50-SP09-04	✱	●	57,0	50	57	117	149	80	229	SPMX090408**	
ZSD02-580-XP50-SP09-04	✱	●	58,0	50	57	119	151	80	231	SPMX090408**	
ZSD02-590-XP50-SP09-04	✱	●	59,0	50	57	121	153	80	233	SPMX090408**	
ZSD02-600-XP50-SP09-04	✱	●	60,0	50	57	123	155	80	235	SPMX090408**	

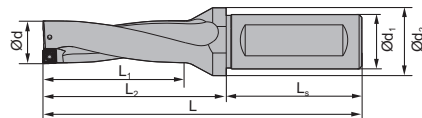
● Ex stock ○ On demand

✱ Internal cooling

Spare parts								
	WSP	SPMX040204**	SPMX050204**	SPMX060204**	SPMX07T308**	SPMX090408**	SPMX110408**	SPMX140512**
	Screw	I60M2x4.3	I60M2x4.3	I60M2.2x5.5	I60M2.5x6.5	I60M3.5x8	I60M4x10	I60M5x13
	Wrench	WT06IP	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP

Indexable drills series

ZSD03



Articel	*	Stock	Dimensions [mm]							Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	LS	L		
ZSD03-120-XP20-SP04-02	*	•	12.0	20	25	39	55	50	105	SPMX040204**	
ZSD03-125-XP20-SP04-02	*	•	12.5	20	25	41	57	50	107	SPMX040204**	
ZSD03-130-XP20-SP04-02	*	•	13.0	20	25	42	58	50	108	SPMX040204**	
ZSD03-135-XP20-SP04-02	*	•	13.5	20	25	44	60	50	110	SPMX040204**	
ZSD03-140-XP20-SP04-02	*	•	14.0	20	25	45	61	50	111	SPMX040204**	
ZSD03-145-XP20-SP04-02	*	•	14.5	20	25	47	63	50	113	SPMX040204**	
ZSD03-150-XP20-SP05-02	*	•	15.0	20	25	48	64	50	114	SPMX050204**	
ZSD03-155-XP20-SP05-02	*	•	15.5	20	25	50	66	50	116	SPMX050204**	
ZSD03-160-XP20-SP05-02	*	•	16.0	20	25	51	67	50	117	SPMX050204**	
ZSD03-165-XP20-SP05-02	*	•	16.5	20	25	53	69	50	119	SPMX050204**	
ZSD03-170-XP20-SP05-02	*	•	17.0	20	25	54	70	50	120	SPMX050204**	
ZSD03-175-XP20-SP05-02	*	•	17.5	20	25	56	72	50	122	SPMX050204**	
ZSD03-180-XP25-SP06-02	*	•	18.0	25	32	57	75	56	131	SPMX060204**	
ZSD03-185-XP25-SP06-02	*	•	18.5	25	32	59	77	56	133	SPMX060204**	
ZSD03-190-XP25-SP06-02	*	•	19.0	25	32	60	78	56	134	SPMX060204**	
ZSD03-195-XP25-SP06-02	*	•	19.5	25	32	62	80	56	136	SPMX060204**	
ZSD03-200-XP25-SP06-02	*	•	20.0	25	32	63	81	56	137	SPMX060204**	
ZSD03-205-XP25-SP06-02	*	•	20.5	25	32	65	83	56	139	SPMX060204**	
ZSD03-210-XP25-SP06-02	*	•	21.0	25	32	66	84	56	140	SPMX060204**	
ZSD03-215-XP25-SP06-02	*	•	21.5	25	32	68	86	56	142	SPMX060204**	
ZSD03-220-XP25-SP06-02	*	•	22.0	25	32	69	87	56	143	SPMX060204**	
ZSD03-225-XP25-SP07-02	*	•	22.5	25	32	71	89	56	145	SPMX07T308**	
ZSD03-230-XP25-SP07-02	*	•	23.0	25	32	72	91	56	147	SPMX07T308**	
ZSD03-235-XP25-SP07-02	*	•	23.5	25	32	74	93	56	149	SPMX07T308**	
ZSD03-240-XP25-SP07-02	*	•	24.0	25	32	75	94	56	150	SPMX07T308**	
ZSD03-245-XP25-SP07-02	*	•	24.5	25	32	77	96	56	152	SPMX07T308**	
ZSD03-250-XP25-SP07-02	*	•	25.0	25	32	78	97	56	153	SPMX07T308**	
ZSD03-255-XP25-SP07-02	*	•	25.5	25	32	80	99	56	155	SPMX07T308**	
ZSD03-260-XP25-SP07-02	*	•	26.0	25	32	81	100	56	156	SPMX07T308**	
ZSD03-265-XP25-SP07-02	*	•	26.5	25	32	83	102	56	158	SPMX07T308**	
ZSD03-270-XP25-SP07-02	*	•	27.0	25	32	84	104	56	160	SPMX07T308**	
ZSD03-275-XP25-SP07-02	*	•	27.5	25	32	86	106	56	162	SPMX07T308**	
ZSD03-280-XP32-SP09-02	*	•	28.0	32	37	87	109	60	169	SPMX090408**	

• Ex stock ○ On demand

* Internal cooling

Articel	*	Stock	Dimensions [mm]							Inserts 	Adapter 
			ØD	ØD1	ØD2	L1	L2	LS	L		
ZSD03-290-XP32-SP09-02	*	•	29.0	32	37	90	112	60	172	SPMX090408**	
ZSD03-300-XP32-SP09-02	*	•	30.0	32	37	93	115	60	175	SPMX090408**	
ZSD03-310-XP32-SP09-02	*	•	31.0	32	37	96	118	60	178	SPMX090408**	
ZSD03-320-XP32-SP09-02	*	•	32.0	32	37	99	121	60	181	SPMX090408**	
ZSD03-330-XP32-SP09-02	*	•	33.0	32	37	102	124	60	184	SPMX090408**	
ZSD03-340-XP40-SP11-02	*	•	34.0	40	47	105	130	70	200	SPMX110408**	
ZSD03-350-XP40-SP11-02	*	•	35.0	40	47	108	133	70	203	SPMX110408**	
ZSD03-360-XP40-SP11-02	*	•	36.0	40	47	111	136	70	206	SPMX110408**	
ZSD03-370-XP40-SP11-02	*	•	37.0	40	47	114	139	70	209	SPMX110408**	
ZSD03-380-XP40-SP11-02	*	•	38.0	40	47	117	142	70	212	SPMX110408**	
ZSD03-390-XP40-SP11-02	*	•	39.0	40	47	120	145	70	215	SPMX110408**	
ZSD03-400-XP40-SP11-02	*	•	40.0	40	47	123	148	70	218	SPMX110408**	
ZSD03-410-XP40-SP11-02	*	•	41.0	40	47	126	151	70	221	SPMX110408**	
ZSD03-420-XP40-SP14-02	*	•	42.0	40	52	129	161	70	231	SPMX140512**	
ZSD03-430-XP40-SP14-02	*	•	43.0	40	52	132	164	70	234	SPMX140512**	
ZSD03-440-XP40-SP14-02	*	•	44.0	40	52	135	167	70	237	SPMX140512**	
ZSD03-450-XP40-SP14-02	*	•	45.0	40	52	138	170	70	240	SPMX140512**	
ZSD03-460-XP40-SP14-02	*	•	46.0	40	52	141	173	70	243	SPMX140512**	
ZSD03-470-XP40-SP14-02	*	•	47.0	40	52	144	176	70	245	SPMX140512**	
ZSD03-480-XP40-SP14-02	*	•	48.0	40	52	147	179	70	249	SPMX140512**	
ZSD03-490-XP40-SP14-02	*	•	49.0	40	52	150	182	70	252	SPMX140512**	
ZSD03-500-XP40-SP14-02	*	•	50.0	40	52	153	185	70	255	SPMX140512**	
ZSD03-510-XP50-SP14-02	*	•	51,0	50	57	156	188	80	268	SPMX110408**	
ZSD03-520-XP50-SP14-02	*	•	52,0	50	57	159	191	80	271	SPMX140512**	
ZSD03-530-XP50-SP14-02	*	•	53,0	50	57	162	194	80	274	SPMX140512**	
ZSD03-540-XP50-SP09-04	*	•	54,0	50	57	165	197	80	277	SPMX090408**	
ZSD03-550-XP50-SP09-04	*	•	55,0	50	57	168	200	80	280	SPMX090408**	
ZSD03-560-XP50-SP09-04	*	•	56,0	50	57	171	203	80	283	SPMX090408**	
ZSD03-570-XP50-SP09-04	*	•	57,0	50	57	174	206	80	286	SPMX090408**	
ZSD03-580-XP50-SP09-04	*	•	58,0	50	57	177	209	80	289	SPMX090408**	
ZSD03-590-XP50-SP09-04	*	•	59,0	50	57	180	212	80	292	SPMX090408**	
ZSD03-600-XP50-SP09-04	*	•	60,0	50	57	183	215	80	295	SPMX090408**	

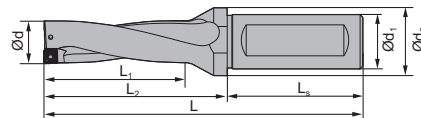
• Ex stock ○ On demand

* Internal cooling

Spare parts								
	WSP	SPMX040204**	SPMX050204**	SPMX060204**	SPMX07T308**	SPMX090408**	SPMX110408**	SPMX140512**
	Screw	I60M2x4.3	I60M2x4.3	I60M2.2x5.5	I60M2.5x6.5	I60M3.5x8	I60M4x10	I60M5x13
	Wrench	WT06IP	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP

Indexable drills series

ZSD04



Articel	*	Stock	Dimensions [mm]								Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	L3	L	kg		
ZSD04-120-XP20-SP04-02	*	•	12.0	20	25	51	67	50	117		SPMX040204**	
ZSD04-125-XP20-SP04-02	*	•	12.5	20	25	53	69	50	119		SPMX040204**	
ZSD04-130-XP20-SP04-02	*	•	13.0	20	25	55	71	50	121		SPMX040204**	
ZSD04-135-XP20-SP04-02	*	•	13.5	20	25	57	73	50	123		SPMX040204**	
ZSD04-140-XP20-SP04-02	*	•	14.0	20	25	59	75	50	125		SPMX040204**	
ZSD04-145-XP20-SP04-02	*	•	14.5	20	25	61	77	50	127		SPMX040204**	
ZSD04-150-XP20-SP05-02	*	•	15.0	20	25	63	79	50	129		SPMX050204**	
ZSD04-155-XP20-SP05-02	*	•	15.5	20	25	65	81	50	131		SPMX050204**	
ZSD04-160-XP20-SP05-02	*	•	16.0	20	25	67	83	50	133		SPMX050204**	
ZSD04-165-XP20-SP05-02	*	•	16.5	20	25	69	85	50	135		SPMX050204**	
ZSD04-170-XP20-SP05-02	*	•	17.0	20	25	71	87	50	137		SPMX050204**	
ZSD04-175-XP20-SP05-02	*	•	17.5	20	25	73	89	50	139		SPMX050204**	
ZSD04-180-XP25-SP06-02	*	•	18.0	25	32	75	93	56	149		SPMX060204**	
ZSD04-185-XP25-SP06-02	*	•	18.5	25	32	77	95	56	151		SPMX060204**	
ZSD04-190-XP25-SP06-02	*	•	19.0	25	32	79	97	56	153		SPMX060204**	
ZSD04-195-XP25-SP06-02	*	•	19.5	25	32	81	99	56	155		SPMX060204**	
ZSD04-200-XP25-SP06-02	*	•	20.0	25	32	83	101	56	157		SPMX060204**	
ZSD04-205-XP25-SP06-02	*	•	20.5	25	32	85	103	56	159		SPMX060204**	
ZSD04-210-XP25-SP06-02	*	•	21.0	25	32	87	105	56	161		SPMX060204**	
ZSD04-215-XP25-SP06-02	*	•	21.5	25	32	89	107	56	163		SPMX060204**	
ZSD04-220-XP25-SP06-02	*	•	22.0	25	32	91	109	56	165		SPMX060204**	
ZSD04-225-XP25-SP07-02	*	•	22.5	25	32	93	111	56	167		SPMX07T308**	
ZSD04-230-XP25-SP07-02	*	•	23.0	25	32	95	114	56	170		SPMX07T308**	
ZSD04-235-XP25-SP07-02	*	•	23.5	25	32	97	116	56	172		SPMX07T308**	
ZSD04-240-XP25-SP07-02	*	•	24.0	25	32	99	118	56	174		SPMX07T308**	
ZSD04-245-XP25-SP07-02	*	•	24.5	25	32	101	120	56	176		SPMX07T308**	
ZSD04-250-XP25-SP07-02	*	•	25.0	25	32	103	122	56	178		SPMX07T308**	
ZSD04-255-XP25-SP07-02	*	•	25.5	25	32	105	125	56	181		SPMX07T308**	
ZSD04-260-XP25-SP07-02	*	•	26.0	25	32	107	126	56	182		SPMX07T308**	
ZSD04-265-XP25-SP07-02	*	•	26.5	25	32	109	128	56	184		SPMX07T308**	
ZSD04-270-XP25-SP07-02	*	•	27.0	25	32	111	131	56	187		SPMX07T308**	
ZSD04-275-XP25-SP07-02	*	•	27.5	25	32	113	134	56	190		SPMX07T308**	
ZSD04-280-XP32-SP09-02	*	•	28.0	32	37	115	139	60	199		SPMX090408**	

• Ex stock ○ On demand

* Internal cooling

Articel	✱	Stock	Dimensions [mm]								Inserts 	Adapter 
			ØD	ØD1	ØD2	L1	L2	LS	L	kg		
ZSD04-290-XP32-SP09-02	✱	•	29.0	32	37	119	143	60	203		SPMX090408**	
ZSD04-300-XP32-SP09-02	✱	•	30.0	32	37	123	147	60	207		SPMX090408**	
ZSD04-305-XP32-SP09-02	✱	•	30.5	32	37	125	149	60	209		SPMX090408**	
ZSD04-310-XP32-SP09-02	✱	•	31.0	32	37	127	151	60	211		SPMX090408**	
ZSD04-320-XP32-SP09-02	✱	•	32.0	32	37	131	155	60	215		SPMX090408**	
ZSD04-330-XP32-SP09-02	✱	•	33.0	32	37	135	159	60	219		SPMX090408**	
ZSD04-340-XP40-SP11-02	✱	•	34.0	40	47	139	164	70	234		SPMX110408**	
ZSD04-350-XP40-SP11-02	✱	•	35.0	40	47	143	168	70	238		SPMX110408**	
ZSD04-360-XP40-SP11-02	✱	•	36.0	40	47	147	172	70	242		SPMX110408**	
ZSD04-370-XP40-SP11-02	✱	•	37.0	40	47	151	176	70	246		SPMX110408**	
ZSD04-380-XP40-SP11-02	✱	•	38.0	40	47	155	180	70	250		SPMX110408**	
ZSD04-390-XP40-SP11-02	✱	•	39.0	40	47	159	184	70	254		SPMX110408**	
ZSD04-400-XP40-SP11-02	✱	•	40.0	40	47	163	188	70	258		SPMX110408**	
ZSD04-405-XP40-SP11-02	✱	•	40.5	40	47	165	190	70	260		SPMX110408**	
ZSD04-410-XP40-SP11-02	✱	•	41.0	40	47	167	192	70	262		SPMX110408**	
ZSD04-420-XP40-SP14-02	✱	•	42.0	40	52	171	203	70	273		SPMX140512**	
ZSD04-430-XP40-SP14-02	✱	•	43.0	40	52	175	207	70	277		SPMX140512**	
ZSD04-440-XP40-SP14-02	✱	•	44.0	40	52	179	211	70	281		SPMX140512**	
ZSD04-450-XP40-SP14-02	✱	•	45.0	40	52	183	215	70	285		SPMX140512**	
ZSD04-460-XP40-SP14-02	✱	•	46.0	40	52	187	219	70	289		SPMX140512**	
ZSD04-470-XP40-SP14-02	✱	•	47.0	40	52	191	223	70	293		SPMX140512**	
ZSD04-480-XP40-SP14-02	✱	•	48.0	40	52	195	227	70	297		SPMX140512**	
ZSD04-490-XP40-SP14-02	✱	•	49.0	40	52	199	231	70	301		SPMX140512**	
ZSD04-500-XP40-SP14-02	✱	•	50.0	40	52	203	235	70	305		SPMX140512**	
ZSD04-510-XP50-SP14-02	✱	○	51,0	50	57	207	239	80	319		SPMX110408**	
ZSD04-520-XP50-SP14-02	✱	○	52,0	50	57	211	243	80	323		SPMX140512**	
ZSD04-530-XP50-SP14-02	✱	○	53,0	50	57	215	247	80	327		SPMX140512**	
ZSD04-540-XP50-SP09-04	✱	○	54,0	50	57	219	251	80	331		SPMX090408**	
ZSD04-550-XP50-SP09-04	✱	○	55,0	50	57	223	255	80	335		SPMX090408**	
ZSD04-560-XP50-SP09-04	✱	○	56,0	50	57	227	259	80	339		SPMX090408**	
ZSD04-570-XP50-SP09-04	✱	○	57,0	50	57	231	263	80	343		SPMX090408**	
ZSD04-580-XP50-SP09-04	✱	○	58,0	50	57	235	267	80	347		SPMX090408**	
ZSD04-590-XP50-SP09-04	✱	○	59,0	50	57	239	271	80	351		SPMX090408**	
ZSD04-600-XP50-SP09-04	✱	○	60,0	50	57	243	275	80	355		SPMX090408**	

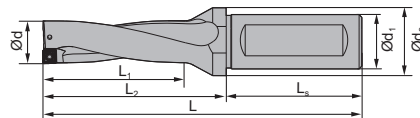
• Ex stock ○ On demand

✱ Internal cooling

Spare parts								
	WSP	SPMX040204**	SPMX050204**	SPMX060204**	SPMX07T308**	SPMX090408**	SPMX110408**	SPMX140512**
	Screw	I60M2x4.3	I60M2x4.3	I60M2.2x5.5	I60M2.5x6.5	I60M3.5x8	I60M4x10	I60M5x13
	Wrench	WT06IP	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP

Indexable drills series

ZSD05



Articel	*	Stock	Dimensions [mm]								Inserts	Adapter
			ØD	ØD1	ØD2	L1	L2	L3	L	kg		
ZSD05-120-XP20-SP04-02	*	•	12.0	20	25	63	79	50	129		SPMX040204**	
ZSD05-125-XP20-SP04-02	*	•	12.5	20	25	66	82	50	132		SPMX040204**	
ZSD05-130-XP20-SP04-02	*	•	13.0	20	25	68	84	50	134		SPMX040204**	
ZSD05-135-XP20-SP04-02	*	•	13.5	20	25	71	87	50	137		SPMX040204**	
ZSD05-140-XP20-SP04-02	*	•	14.0	20	25	73	89	50	139		SPMX040204**	
ZSD05-145-XP20-SP04-02	*	•	14.5	20	25	76	91	50	141		SPMX040204**	
ZSD05-150-XP20-SP05-02	*	•	15.0	20	25	78	94	50	144		SPMX050204**	
ZSD05-155-XP20-SP05-02	*	•	15.5	20	25	81	97	50	147		SPMX050204**	
ZSD05-160-XP20-SP05-02	*	•	16.0	20	25	83	99	50	149		SPMX050204**	
ZSD05-165-XP20-SP05-02	*	•	16.5	20	25	86	102	50	152		SPMX050204**	
ZSD05-170-XP20-SP05-02	*	•	17.0	20	25	88	104	50	154		SPMX050204**	
ZSD05-175-XP20-SP05-02	*	•	17.5	20	25	91	107	50	157		SPMX050204**	
ZSD05-180-XP25-SP06-02	*	•	18.0	25	32	93	112	56	167		SPMX060204**	
ZSD05-185-XP25-SP06-02	*	•	18.5	25	32	96	114	56	170		SPMX060204**	
ZSD05-190-XP25-SP06-02	*	•	19.0	25	32	98	116	56	172		SPMX060204**	
ZSD05-195-XP25-SP06-02	*	•	19.5	25	32	101	119	56	175		SPMX060204**	
ZSD05-200-XP25-SP06-02	*	•	20.0	25	32	103	121	56	177		SPMX060204**	
ZSD05-205-XP25-SP06-02	*	•	20.5	25	32	106	124	56	180		SPMX060204**	
ZSD05-210-XP25-SP06-02	*	•	21.0	25	32	108	126	56	182		SPMX060204**	
ZSD05-215-XP25-SP06-02	*	•	21.5	25	32	111	129	56	185		SPMX060204**	
ZSD05-220-XP25-SP06-02	*	•	22.0	25	32	113	131	56	187		SPMX060204**	
ZSD05-225-XP25-SP07-02	*	•	22.5	25	32	116	134	56	190		SPMX07T308**	
ZSD05-230-XP25-SP07-02	*	•	23.0	25	32	118	138	56	194		SPMX07T308**	
ZSD05-235-XP25-SP07-02	*	•	23.5	25	32	121	141	56	197		SPMX07T308**	
ZSD05-240-XP25-SP07-02	*	•	24.0	25	32	123	143	56	199		SPMX07T308**	
ZSD05-245-XP25-SP07-02	*	•	24.5	25	32	126	146	56	202		SPMX07T308**	
ZSD05-250-XP25-SP07-02	*	•	25.0	25	32	128	148	56	204		SPMX07T308**	
ZSD05-255-XP25-SP07-02	*	•	25.5	25	32	131	151	56	207		SPMX07T308**	
ZSD05-260-XP25-SP07-02	*	•	26.0	25	32	133	153	56	209		SPMX07T308**	
ZSD05-265-XP25-SP07-02	*	•	26.5	25	32	136	156	56	212		SPMX07T308**	
ZSD05-270-XP25-SP07-02	*	•	27.0	25	32	138	158	56	214		SPMX07T308**	
ZSD05-275-XP25-SP07-02	*	•	27.5	25	32	141	161	56	217		SPMX07T308**	
ZSD05-280-XP32-SP09-02	*	•	28.0	32	37	143	163	60	223		SPMX090408**	

• Ex stock ○ On demand

* Internal cooling

Articel	*	Stock	Dimensions [mm]								Inserts 	Adapter 
			ØD	ØD1	ØD2	L1	L2	LS	L	kg		
ZSD05-290-XP32-SP09-02	*	•	29,0	32	37	148	168	60	228		SPMX090408**	
ZSD05-300-XP32-SP09-02	*	•	30,0	32	37	153	173	60	233		SPMX090408**	
ZSD05-310-XP32-SP09-02	*	•	31,0	32	37	158	178	60	238		SPMX090408**	
ZSD05-320-XP32-SP09-02	*	•	32,0	32	37	163	183	60	243		SPMX090408**	
ZSD05-330-XP32-SP09-02	*	•	33,0	32	37	168	189	60	249		SPMX090408**	
ZSD05-340-XP40-SP11-02	*	•	34,0	40	47	173	198	70	268		SPMX110408**	
ZSD05-350-XP40-SP11-02	*	•	35,0	40	47	178	203	70	273		SPMX110408**	
ZSD05-360-XP40-SP11-02	*	•	36,0	40	47	183	208	70	278		SPMX110408**	
ZSD05-370-XP40-SP11-02	*	•	37,0	40	47	188	213	70	283		SPMX110408**	
ZSD05-380-XP40-SP11-02	*	•	38,0	40	47	193	218	70	288		SPMX110408**	
ZSD05-390-XP40-SP11-02	*	•	39,0	40	47	198	223	70	293		SPMX110408**	
ZSD05-400-XP40-SP11-02	*	•	40,0	40	47	203	228	70	298		SPMX110408**	
ZSD05-410-XP40-SP11-02	*	•	41,0	40	47	208	233	70	303		SPMX110408**	
ZSD05-420-XP40-SP14-02	*	•	42,0	40	52	213	245	70	315		SPMX140512**	
ZSD05-430-XP40-SP14-02	*	•	43,0	40	52	218	250	70	320		SPMX140512**	
ZSD05-440-XP40-SP14-02	*	•	44,0	40	52	223	255	70	325		SPMX140512**	
ZSD05-450-XP40-SP14-02	*	•	45,0	40	52	228	260	70	330		SPMX140512**	
ZSD05-460-XP40-SP14-02	*	•	46,0	40	52	233	265	70	335		SPMX140512**	
ZSD05-470-XP40-SP14-02	*	•	47,0	40	52	238	270	70	340		SPMX140512**	
ZSD05-480-XP40-SP14-02	*	•	48,0	40	52	243	275	70	345		SPMX140512**	
ZSD05-490-XP40-SP14-02	*	•	49,0	40	52	248	280	70	350		SPMX140512**	
ZSD05-500-XP40-SP14-02	*	•	50,0	40	52	253	285	70	355		SPMX140512**	
ZSD05-510-XP50-SP14-02	*	○	51,0	50	57	258	290	80	370		SPMX110408**	
ZSD05-520-XP50-SP14-02	*	○	52,0	50	57	263	295	80	375		SPMX140512**	
ZSD05-530-XP50-SP14-02	*	○	53,0	50	57	268	300	80	380		SPMX140512**	
ZSD05-540-XP50-SP09-04	*	○	54,0	50	57	273	305	80	385		SPMX090408**	
ZSD05-550-XP50-SP09-04	*	○	55,0	50	57	278	310	80	390		SPMX090408**	
ZSD05-560-XP50-SP09-04	*	○	56,0	50	57	283	315	80	395		SPMX090408**	
ZSD05-570-XP50-SP09-04	*	○	57,0	50	57	288	320	80	400		SPMX090408**	
ZSD05-580-XP50-SP09-04	*	○	58,0	50	57	293	325	80	405		SPMX090408**	
ZSD05-590-XP50-SP09-04	*	○	59,0	50	57	298	330	80	410		SPMX090408**	
ZSD05-600-XP50-SP09-04	*	○	60,0	50	57	303	335	80	415		SPMX090408**	

• Ex stock ○ On demand

* Internal cooling

Spare parts								
	WSP	SPMX040204**	SPMX050204**	SPMX060204**	SPMX07T308**	SPMX090408**	SPMX110408**	SPMX140512**
	Screw	I60M2x4.3	I60M2x4.3	I60M2.2x5.5	I60M2.5x6.5	I60M3.5x8	I60M4x10	I60M5x13
	Wrench	WT06IP	WT06IP	WT07IP	WT07IP	WT15IP	WT15IP	WT20IP

Notes

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Turning

B

Milling

C

Drilling

D

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SPMX	L	I.C	S	d
04 02	4	4	2,38	2,2
05 02	5	5	2,38	2,2
06 02	6	6	2,38	2,5
07 T3	7,94	7,94	3,97	2,8
09 04	9,8	9,8	4,30	4,1
11 04	11,5	11,5	4,76	4,4
14 05	14,3	14,3	5,20	5,5

Drilling inserts

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

SP** drilling insert		HC ¹ (CVD)				HC ¹ (PVD)				HW			
		P	● ●			● ● ● ●							
		M	●			● ● ● ●							
		K	●										
		N								●			
		S				● ● ●							
		H											
ISO		r	YB6338 YBD252			YBG202 YBG205 YBG212 YBG320 YBS203				YD201			
	SPMX040204-XM	0,4	●				●						
	SPMX050204-XM	0,4	●				○ ●						
	SPMX060204-XM	0,4	●				●						
	SPMX07T308-XM	0,8	●				○ ●						
	SPMX090408-XM	0,8	●				●						
	SPMX110408-XM	0,8	●				●						
	SPMX140512-XM	1,2	●				●						
	SPMX040204-EM	0,4					● ○						
	SPMX050204-EM	0,4					● ○						
	SPMX060204-EM	0,4					● ○						
	SPMX07T308-EM	0,8					● ○						
	SPMX090408-EM	0,8					● ○						
	SPMX110408-EM	0,8					● ○						
	SPMX140512-EM	1,2					● ○						
	SPMX040204-LM	0,4					●						
	SPMX050204-LM	0,4					●						
	SPMX060204-LM	0,4					●						
	SPMX07T308-LM	0,8					●						
	SPMX090408-LM	0,8					●						
	SPMX110408-LM	0,8					●						
	SPMX140512-LM	1,2					●						

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

A

Turning

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Indexable drills

Material group		Composition / structure / heat treatment		HB	Machining group	ZSD*		ZSD*		
						SPMX04		SPMX05/06		
						v _c [m/min]	f [mm]	v _c [m/min]	f [mm]	
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	200-300	0,05-0,08	200-300	0,05-0,10	
		approx. 0,45 % C	annealed	190	2	200-300	0,05-0,08	200-300	0,05-0,10	
		approx. 0,45 % C	tempered	250	3	200-300	0,05-0,08	200-300	0,05-0,10	
		approx. 0,75 % C	annealed	270	4	200-300	0,05-0,08	200-300	0,05-0,10	
		approx. 0,75 % C	tempered	300	5	200-300	0,05-0,08	200-300	0,05-0,10	
	Low-alloyed steel		annealed	180	6	140-220	0,05-0,08	140-220	0,05-0,10	
			tempered	275	7	140-220	0,05-0,08	140-220	0,05-0,10	
			tempered	300	8	140-220	0,05-0,08	140-220	0,05-0,10	
			tempered	350	9	140-220	0,05-0,08	140-220	0,05-0,10	
High-alloyed steel and high-alloyed tool steel		annealed	200	10	120-180	0,05-0,08	120-180	0,05-0,10		
		hardened and tempered	325	11	120-180	0,05-0,08	120-180	0,05-0,10		
M	Stainless steel	ferritic/martensitic	annealed	200	12	110-230	0,05-0,08	110-230	0,05-0,10	
		martensitic	tempered	240	13	110-230	0,05-0,08	110-230	0,05-0,10	
		austenitic	quench hardened	180	14	110-230	0,05-0,08	110-230	0,05-0,10	
		austenitic-ferritic		230	15	110-230	0,05-0,08	110-230	0,05-0,10	
K	Grey cast iron	perlitic/ferritic		180	16	170-240	0,05-0,08	170-240	0,05-0,10	
		perlitic (martensitic)		260	17	170-240	0,05-0,08	170-240	0,05-0,10	
	Cast iron with spheroidal graphite	ferritic		160	18	130-200	0,05-0,08	130-200	0,05-0,10	
		perlitic		250	19	130-200	0,05-0,08	130-200	0,05-0,10	
	Malleable cast iron	ferritic		130	20	120-220	0,05-0,08	120-220	0,05-0,10	
		perlitic		230	21	120-220	0,05-0,08	120-220	0,05-0,10	
N	Aluminium wrought alloys	cannot be hardened		60	22					
		hardenable	hardened	100	23					
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24					
		≤ 12 % Si, hardenable	hardened	90	25					
		> 12 % Si, cannot be hardened		130	26					
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27					
		CuZn, CuSnZn		90	28					
CuSn, Pb-free copper, electrolytic copper		100	29							
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30					
			hardened	280	31					
		Ni or Co bass	annealed	250	32					
			hardened	350	33					
			cast	320	34					
	Titanium alloys	pure titanium		R _m 400	35					
		α and β alloys	hardened	R _m 1050	36					
H	Hardened steel		hardened and tempered	55 HRC	37					
			hardened and tempered	60 HRC	38					
	Hard cast iron		cast	400	39					
	Hardened cast iron		hardened and tempered	55 HRC	40					
X	Non-metallic materials	Thermoplasts			41					
		Thermosetting plastics			42					
		Plastic, glass-fibre reinforced GFRP			43					
		Plastic, carbon fibre reinforced CFRP			44					
		Graphite			45					
		Wood			46					

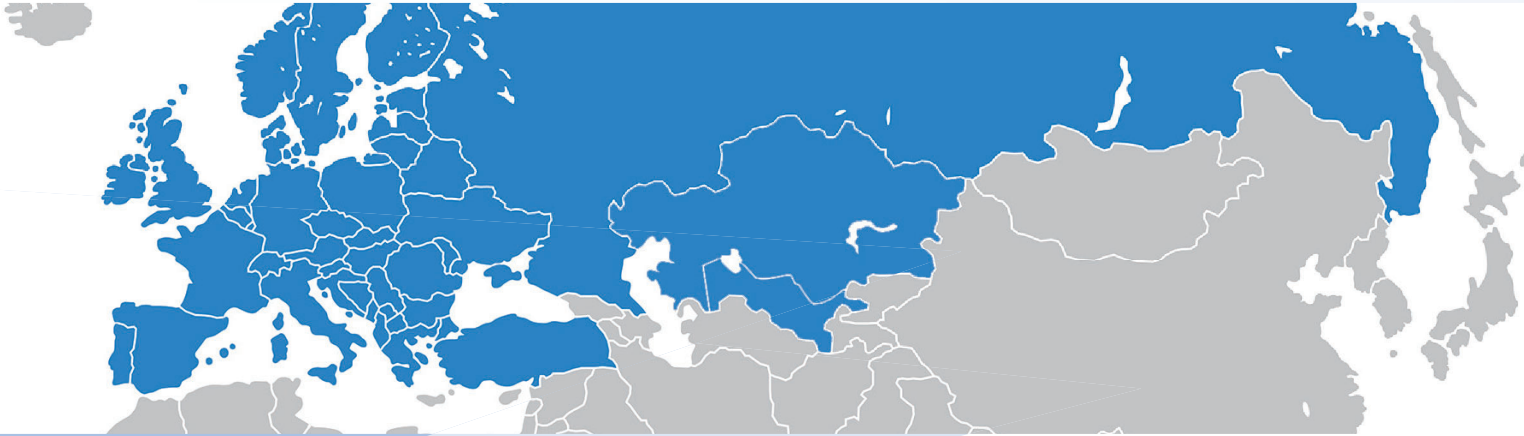
Note: The given cutting values are guide values, which were determined under ideal conditions.
 The values have to be adapted in individual cases.
 With hole depths of 5xD adjust the cutting data accordingly to the application.
 For examples of material for cutting tool groups view page D22.



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