Spade Drill

Modular indexable drilling — Ø9.5 to Ø114.48 mm, one body takes carbide, powder HSS or cobalt HSS inserts

SD SERIES



Drill bodies and inserts across the diameter range

Drill body naming

SD 10 H -168 -XP 32

SD	Spade drill body
10	Series — 10, 15, 20, 25 …
H	Groove: H spiral · S straight
168	Effective drilling depth (mm)
XP	Shank: XP side-lock · MT Morse taper
32	Shank size — XP 25/32/40/50 · MT 2/3/4/5

Insert naming

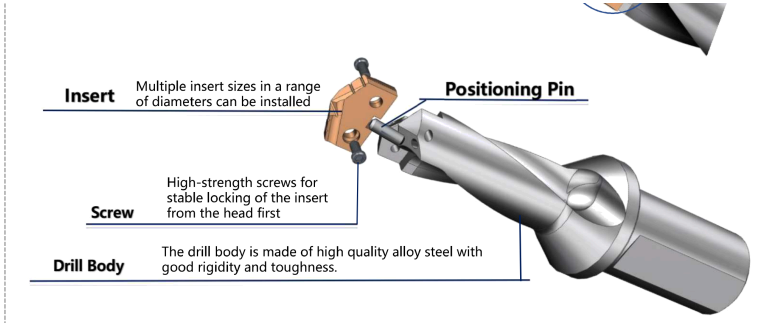
50.00mm — S2 — ST — A

50.00mm	External diameter
Material	S2 HSS with cobalt (HSS-E) · S6 powder HSS · G2 cemented carbide
Groove	ST universal · DT strong chipbreaking universal
Coating	A TiAlN · H AlCrN · P AlTiN · D DLC

Insert range

Applicable body	Insert diameter	Thickness	Point angle	HSS-E	Powder HSS	Carbide
SDY0–SDZ0	φ9.5–φ12.9	2.38	132°	S2STA S2DTH S2DTP	S6STA S6DTH S6DTP	G2STA G2DTH G2DTP
SD00–SD05	φ13.0–φ17.5	3.18				
SD10–SD15	φ17.6–φ24.4	3.97				
SD20–SD25	φ24.5–φ35.0	4.76				
SD30–SD35	φ35.1–φ47.9	6.35				
SD40–SD45	φ48.0–φ65.28	7.94				
SD50–SD55	φ65.3–φ89.08	11.11	144°			
SD70	φ89.1–φ114.48					

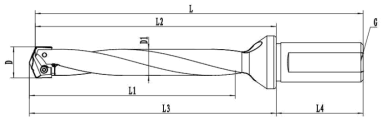
Side-lock body — how it goes together



Drill Body Dimensions — Ø9.5 to Ø17.5

SD SERIES

Side-lock type spade drill bodies — dimensions in mm





Y0 Series (φ9.5–φ11.0)						
Model	L1	L2	L3	L	D1	G
SDY0H-19-XP16	19	47.6	50	95.6	9.4	G1/16
SDY0H-32-XP20	32	61.1	63.5	111.1	9.4	G1/8
SDY0H-60-XP20	60	89.7	92.1	139.7	9.4	G1/8
SDY0H-111-XP20	111	140.5	142.9	190.5	9.4	G1/8
SDY0H-222-XP20	222	251.7	254.1	301.7	9.4	G1/8
SDY0H-290-XP20	290	319.9	322.3	369.9	9.4	G1/8

Z0 Series (φ11.1–φ12.9)						
Model	L1	L2	L3	L	D1	G
SDZ0H-19-XP16	19	47.6	50	95.6	10.4	G1/16
SDZ0H-32-XP20	32	61.1	63.5	111.1	10.4	G1/8
SDZ0H-60-XP20	60	89.7	92.1	139.7	10.4	G1/8
SDZ0H-111-XP20	111	140.5	142.9	190.5	10.4	G1/8
SDZ0H-222-XP20	222	251.7	254.1	301.7	10.4	G1/8
SDZ0H-290-XP20	290	319.9	322.3	369.9	10.4	G1/8

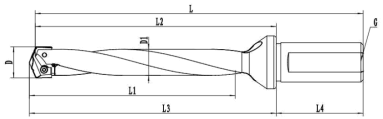
00 Series (φ13.0–φ17.5)						
Model	L1	L2	L3	L	D1	G
SD00H-23-XP20	23	47.6	50.4	97.6	12.4	G1/8
SD00H-35-XP20	35	63.5	66.3	113.5	12.4	G1/8
SD00H-64-XP20	64	92.1	94.9	142.1	12.4	G1/8
SD00H-114-XP20	114	142.9	145.7	192.9	12.4	G1/8
SD00H-178-XP20	178	206.4	209.1	256.4	12.4	G1/8
SD00H-240-XP20	240	268.6	271.3	318.6	12.4	G1/8
SD00H-295-XP20	295	323.9	326.7	373.9	12.4	G1/8
SD00H-387-XP20	387	416	418.8	466	12.4	G1/8

05 Series (φ15.5–φ17.5)						
Model	L1	L2	L3	L	D1	G
SD05H-23-XP20	23	47.6	50.4	97.6	14.7	G1/8
SD05H-35-XP20	35	63.5	66.3	113.5	14.7	G1/8
SD05H-64-XP20	64	92.1	94.9	142.1	14.7	G1/8
SD05H-114-XP20	114	142.9	145.7	192.9	14.7	G1/8
SD05H-178-XP20	178	206.4	209.1	256.4	14.7	G1/8
SD05H-240-XP20	240	268.6	271.3	318.6	14.7	G1/8
SD05H-295-XP20	295	323.9	326.7	373.9	14.7	G1/8
SD05H-387-XP20	387	416	418.8	466	14.7	G1/8

Drill Body Dimensions — Ø17.6 to Ø35.0

SD SERIES

Side-lock type spade drill bodies — dimensions in mm





10 Series (φ17.6–φ24.4)						
Model	L1	L2	L3	L	D1	G
SD10H-48-XP25	48	75.8	79.4	131.8	17	G1/8
SD10H-67-XP25	67	107.2	110.7	163.1	17	G1/8
SD10H-118-XP25	118	154.8	158.4	210.8	17	G1/8
SD10H-168-XP25	168	205.6	209.2	261.6	17	G1/8
SD10H-218-XP25	218	255.3	258.9	311.3	17	G1/8
SD10H-270-XP25	270	307.2	310.8	363.2	17	G1/8
SD10H-365-XP25	365	402.2	405.8	458.2	17	G1/8
SD10H-457-XP25	457	494.5	498.1	550.5	17	G1/8
SD10H-569-XP25	569	602.5	606.1	658.5	17	G1/8

15 Series (φ22.0–φ24.4)						
Model	L1	L2	L3	L	D1	G
SD15H-57-XP25	57	88.5	92.1	144.5	21.2	G1/8
SD15H-67-XP25	67	107.2	110.7	163.1	21.2	G1/8
SD15H-118-XP25	118	154.8	158.4	210.8	21.2	G1/8
SD15H-168-XP25	168	205.6	209.2	261.6	21.2	G1/8
SD15H-218-XP25	218	255.3	258.9	311.3	21.2	G1/8
SD15H-270-XP25	270	307.2	310.8	363.2	21.2	G1/8
SD15H-365-XP25	365	400.2	405.8	458.2	21.2	G1/8
SD15H-457-XP25	457	494.5	498.1	550.5	21.2	G1/8
SD15H-569-XP25	569	602.5	606.1	658.5	21.2	G1/8

20 Series (φ24.5–φ35.0)						
Model	L1	L2	L3	L	D1	G
SD20H-57-XP32	57	88.5	92.1	148.5	23.9	G1/4
SD20H-86-XP32	86	128.6	132.2	188.6	23.9	G1/4
SD20H-137-XP32	137	179.4	183	239.4	23.9	G1/4
SD20H-187-XP32	187	230.2	233.8	290.2	23.9	G1/4
SD20H-237-XP32	237	279.9	283.5	339.9	23.9	G1/4
SD20H-289-XP32	289	331.8	335.4	391.8	23.9	G1/4
SD20H-400-XP32	400	442.8	446.4	502.8	23.9	G1/4
SD20H-511-XP32	511	554.1	557.7	614.1	23.9	G1/4
SD20H-692-XP32	692	735.1	738.7	795.1	23.9	G1/4

25 Series (φ30.0–φ35.0)						
Model	L1	L2	L3	L	D1	G
SD25H-86-XP32	86	123.4	127	183.4	29.2	G1/4
SD25H-92-XP32	92	128.6	132.2	188.6	29.2	G1/4
SD25H-137-XP32	137	179.4	183	239.4	29.2	G1/4
SD25H-187-XP32	187	230.2	233.8	290.2	29.2	G1/4
SD25H-237-XP32	237	279.9	283.5	339.9	29.2	G1/4
SD25H-289-XP32	289	331.8	335.4	391.8	29.2	G1/4
SD25H-400-XP32	400	442.8	446.4	502.8	29.2	G1/4
SD25H-511-XP32	511	554.1	557.7	614.1	29.2	G1/4

Drill Body Dimensions — Ø35.1 to Ø114.48

SD SERIES

Side-lock type spade drill bodies — dimensions in mm

30 Series (φ35.1–φ47.9)						
Model	L1	L2	L3	L	D1	G
SD30H-76-XP40	76	125	129.8	195	34.2	G1/4
SD30H-121-XP40	121	173	177.8	243	34.2	G1/4
SD30H-165-XP40	165	217.5	222.3	287.5	34.2	G1/4
SD30H-210-XP40	210	261.9	266.7	331.9	34.2	G1/4
SD30H-260-XP40	260	312.3	317.1	382.3	34.2	G1/4
SD30H-349-XP40	349	401.6	406.4	471.6	34.2	G1/4
SD30H-450-XP40	450	502.6	507.4	518.6	34.2	G1/4
SD30H-559-XP40	559	611.1	615.9	681.1	34.2	G1/4
SD30H-787-XP40	787	839.7	844.5	909.7	34.2	G1/4

40 Series (φ48.0–φ65.28)						
Model	L1	L2	L3	L	D1	G
SD40H-130-XP40	130	179.4	184.2	249.4	47.2	G1/4
SD40H-232-XP40	232	281	285.8	351	47.2	G1/4
SD40H-350-XP40	350	399.2	404	469.2	47.2	G1/4
SD40H-422-XP40	422	471.5	476.3	541.5	47.2	G1/4
SD40H-525-XP40	525	574.2	579	644.2	47.2	G1/4
SD40H-625-XP40	625	674.7	679.5	744.7	47.2	G1/4
SD40H-879-XP40	879	928.7	933.5	998.7	47.2	G1/4

50 Series (φ65.3–φ89.08)						
Model	L1	L2	L3	L	D1	G
SD50H-171-XP50	171	235	240	315	62.5	G1/4
SD50H-350-XP50	350	414	419	494	62.5	G1/4
SD50H-464-XP50	464	528	553	608	62.5	G1/4
SD50H-660-XP50	660	724	729	804	62.5	G1/4
SD50H-800-XP50	800	984	989	1064	62.5	G1/4

35 Series (φ42.0–φ47.9)						
Model	L1	L2	L3	L	D1	G
SD35H-76-XP40	76	125	129.8	195	41.2	G1/4
SD35H-121-XP40	121	173	177.8	243	41.2	G1/4
SD35H-165-XP40	165	217.5	222.3	287.5	41.2	G1/4
SD35H-210-XP40	210	261.9	266.7	331.9	41.2	G1/4
SD35H-260-XP40	260	312.3	317.1	382.3	41.2	G1/4
SD35H-349-XP40	349	401.6	406.4	471.6	41.2	G1/4
SD35H-559-XP40	559	611.1	615.9	681.1	41.2	G1/4
SD35H-787-XP40	787	839.7	844.5	909.7	41.2	G1/4

45 Series (φ56.0–φ65.28)						
Model	L1	L2	L3	L	D1	G
SD45H-130-XP40	130	179.4	184.2	249.4	54.2	G1/4
SD45H-232-XP40	232	281	285.8	351	54.2	G1/4
SD45H-350-XP40	350	399.2	404	469.2	54.2	G1/4
SD45H-422-XP40	422	471.5	476.3	541.5	54.2	G1/4
SD45H-525-XP40	525	574.2	579	644.2	54.2	G1/4
SD45H-625-XP40	625	674.7	679.5	744.7	54.2	G1/4
SD45H-879-XP40	879	928.7	933.5	998.7	54.2	G1/4

70 Series (φ89.1–φ114.48)						
Model	L1	L2	L3	L	D1	G
SD70H-200-XP50	200	275	280	355	87	G1/4
SD70H-400-XP50	400	475	480	555	87	G1/4
SD70H-800-XP50	800	875	880	955	87	G1/4