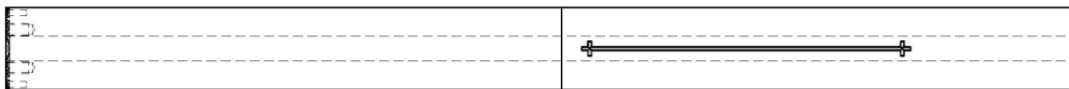


# STMD STMD M20-260

Vibration damped turning tool holder – modular



MAQ AB

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# Price and dimensions

More technical data on page 2

Diameter (mm)	Length (mm)	Price USD	Price EUR
20	260	\$ 1,245	€ 1,121

## Description:

STMD turning tool holder

## Supplied with:

Insex screws M3X8, 3 pcs  
Allen wrench, 1 pcs  
Coolant adapter G1/4, 1 pcs

## Note:

Cylindrical shank without clamping feature.  
With central groove for alignment.  
Recommended application range up to 12XD  
Refer to product performance datasheet  
below.  
Maximum cutting depth (To be updated) mm.



## Download drawing

 **STEP**




 **DWG**

## Technical data

Adaptive interface machine direction	<b>20</b>
Adaptive interface workpiece direction	<b>SL20</b>
No clamping region (S)	<b>105 mm</b>
Recommended maximum overhang (OHX)	<b>Approx. 200 mm</b>
Coolant entry form	<b>Axial concentric</b>
Coolant exit form	<b>3C – axial and periphery</b>
Coolant entry thread size	<b>G ¼</b>
Max coolant pressure	<b>70 bar</b>
Alignment aid property	<b>Central groove</b>
Connection diameter (DCON)	<b>20 mm</b>
Functional length (LF)	<b>260 mm</b>
Body material	<b>Carbide reinforced steel</b>
Weight of item	<b>1.0 kg</b>
Recommended clamping length	<b>60 mm (3XD)</b>
Method of cutting off	<b>EDM Wire cutting</b>

# Quality / Product performance reference\*

**Depth of cut:** 0.5 mm      **Nose radius:** 0.4 mm  
**Cutter head:** MAQ SDUCR 20      **Cutting insert:** DCMT 11T304  
**Coolant:** On      **Workpiece material:** 34 CrNiMo, HRC 28-30  
**Units:** Feed: mm/rev; Speed: m/min; Ra: µm

		
Quiet with good/medium surface quality	Slight to medium vibrations with medium to bad surface quality	Strong vibrations / Insert broken

## Surface finish (Ra) table

10xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	3.47	1.39	2.56	4.11
200	4.27	1.30	2.32	3.62
150	0.57	1.44	2.45	4.03

11xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	N.A	1.46	2.48	4.00
200	N.A	N.A	2.36	3.74
150	N.A	1.74	2.71	3.96

12xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	N.A	1.47	2.50	4.11
200	N.A	4.61	2.83	3.62
150	N.A	N.A	3.66	4.25

\* The actual product performance is dependent on the rigidity of the clamping methods, and the table is used as reference

\*\* In actual machining, avoid using depth of cut or feed rate below 0.07mm when working with carbide insert (the edge radius)

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