

# STMD STMD M40-408-1C

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
40	408	\$ 1,148	€ 1,033

## Description:

STMD turning tool holder

## Supplied with:

Insex screws M6X14, 3 pcs  
Allen wrench, 1 pcs  
Coolant adapter G1/2, 1 pcs

## Note:

Cylindrical shank without clamping feature.  
With central groove for alignment.  
Recommended application range up to 9XD  
Refer to product performance datasheet below.  
Maximum cutting depth (To be updated) mm.



## Download drawing

 STEP




 DWG

## Technical data

Adaptive interface machine direction	<b>40</b>
Adaptive interface workpiece direction	<b>SL40</b>
No clamping region (S)	<b>140 mm</b>
Recommended maximum overhang (OHX)	<b>Approx. 330 mm</b>
Coolant entry form	<b>Axial concentric</b>
Coolant exit form	<b>1C – axial</b>
Coolant entry thread size	<b>G ½</b>
Max coolant pressure	<b>70 bar</b>
Alignment aid property	<b>Central groove</b>
Connection diameter (DCON)	<b>40 mm</b>
Functional length (LF)	<b>408 mm</b>
Body material	<b>Steel</b>
Weight of item	<b>3.9 kg</b>
Recommended clamping length	<b>120 mm (3XD)</b>
Method of cutting off	<b>Slot turning / Sawing</b>

# Quality / Product performance reference\*

**Depth of cut:** 0.5 mm      **Nose radius:** 0.4 mm  
**Cutter head:** MAQ SDUCR 40      **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

7xD DOC = 0.5mm

Speed	Feed	0.05**	0.10	0.15	0.20
	300	0.54	1.04	2.00	3.89
200	0.49	0.88	2.20	3.51	
150	0.62	0.94	2.24	3.94	

8xD DOC = 0.5mm

Speed	Feed	0.05**	0.10	0.15	0.20
	300	0.63	1.13	2.22	3.73
200	0.53	1.06	2.40	3.38	
150	0.62	1.09	2.37	3.52	

9xD DOC = 0.5mm

Speed	Feed	0.05**	0.10	0.15	0.20
	300	N.A	1.59	2.57	4.04
200	N.A	1.51	2.41	3.81	
150	N.A	4.94	2.97	3.66	

\* 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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