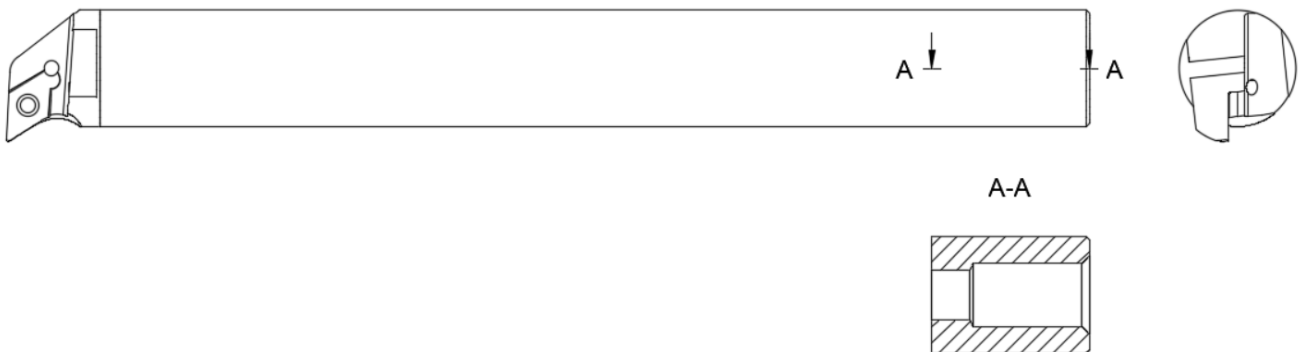


# STMD M25-205 SDUCR

Vibration damped turning tool holder – Solid Body



MAQ AB

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# Price and dimensions

More technical data on page 2

Diameter (mm)	Length (mm)	Price USD	Price EUR
25	205	\$ 475	€ 427

## Description:

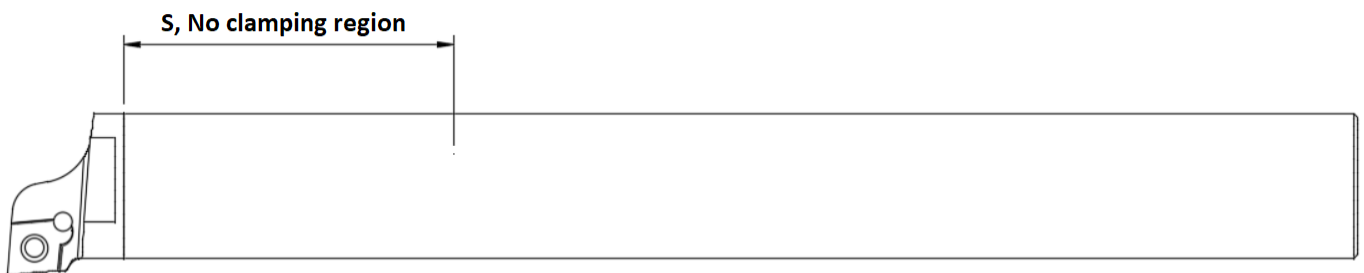
STMD turning tool holder

## Supplied with:

insert  
Insert key

## Note:

Cylindrical shank without clamping feature.  
With central groove for alignment.  
Recommended application ranges up to 6XD  
Reference product performance datasheet  
below.  
Maximum cutting depth (To be updated) mm.



## Download drawing

 STEP




 DWG

## Technical data

Adaptive interface machine direction	25 mm
No clamping region (S)	57 mm
Recommended maximum overhang (OHX)	Approx. 150 mm
Coolant entry form	Axial concentric
Coolant exit form	1C – Axial
Coolant entry thread size	G ¼
Max coolant pressure	70 bar
Alignment aid property	Flat surface on cutter head
Connection diameter (DCON)	25 mm
Functional length (LF)	205 mm
Body material	Steel
Weight of item	0.6 kg
Recommended clamping length	75 mm (3XD)
Method of cutting off	Slot turning / Sawing

# Quality / Product performance reference\*

Depth of cut: 0.5 mm      Nose radius: 0.4 mm  
 Cutter head: MAQ SDUCR 25      Cutting insert: DCMT 11T304  
 Coolant: On      Workpiece material: 34 CrNiMo, HRC 28-30  
 Units: Feed: mm/rev; Speed: m/min; Ra:  $\mu\text{m}$

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

## Surface finish (Ra) table

4xD DOC = 0.5mm

Speed	Feed		
	0.10	0.15	0.20
200	0.48	0.57	1.22

5xD DOC = 0.5mm

Speed	Feed		
	0.10	0.15	0.20
200	0.50	1.07	3.09

6xD DOC = 0.5mm

Speed	Feed		
	0.10	0.15	0.20
200	0.89	0.63	1.03

(RA) = Arithmetic Average of the roughness profile ( $\mu\text{m}$ )

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

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