

# STMD STMD M12-180 STFCR

Vibration damped turning tool holder – Monoblock



## Price and dimensions

More technical data on page 2

Diameter (mm)	Length (mm)	Workable length (mm)
16	268	84-132

## Description:

STMD turning tool holder

## Supplied with:

Insert screws M2.2	1 pc
Insert screw key	1 pc

## Note:

Cylindrical shank without clamping feature.  
With central groove for alignment.  
Application ranges – 7-11 xD  
Refer to product performance datasheet below.

Maximum cutting force – 480 N



Download drawing:

STEP

DWG

## Technical data































Adaptive interface machine direction	12
Adaptive interface workpiece direction	TCMT 0902XX
No clamping region (S)	69 mm
Maximum overhang (OHX), including cutter head	Approx. 144 mm
Coolant entry form	Axial with connector
Coolant exit form	Central
Coolant entry thread size	NA
Max coolant pressure	70 bar
Alignment aid property	Central groove
Connection diameter (DCON)	12 mm
Functional length (LF)	192 mm
Body material	Carbide reinforced steel
Weight of item	0.3 kg
Recommended clamping length	36 mm (3XD)
Method of cutting off	Grinding carbide

## Quality / Product performance reference\*

Product: MAQ STMD M16- 268 with SDUCR-16



Test date: 2021-12-22

<u>11XD</u>	 1	 1	 1	 1	 1	 1
<u>12XD</u>	 1	 1	 1	 1	 1	 1
<u>13XD</u>	 1	 1	 1	 1	 1	 1
<u>14XD</u>	 1	 1	 1	 1	 1	 1
<u>15xD</u>	 1	 1	 1	 1	 1	 1
Overhang / Feed (mm/rev)	<u>0.12</u>		<u>0.15</u>		<u>0.20</u>	
Theoretical surface Ra (µm)	<u>1.2</u>		<u>2.60</u>		<u>4.63</u>	

Depth of cut: 0.25 mm

Cutting insert:

DCMT 070204-FP P25C


Workpiece: 4340 Steel HRC 30


Cutting Speed: 200 m/min


Nose radius: 0.4 mm

Cutting condition: Wet

Vibration level:

1: No vibration 

2: Acceptable 

3: Strong vibration 

Surface finish: 

1: Good

2: Acceptable

3: Not acceptable

\* 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)