

# STMD STMD M20-200

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)		
20	200		

## 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 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>20</b>
Adaptive interface workpiece direction	<b>SL20</b>
No clamping region (S)	<b>80 mm</b>
Recommended maximum overhang (OHX)	<b>Approx. 160 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>200 mm</b>
Body material	<b>Steel</b>
Weight of item	<b>0.5 kg</b>
Recommended clamping length	<b>60 mm (3XD)</b>
Method of cutting off	<b>Slot turning / Sawing</b>
Recommended temperature range	<b>5 ~ 35 °C</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

7xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	3.41	0.97	2.08	3.69
200	4.14	1.14	2.23	3.30
150	0.60	1.15	2.49	3.50

8xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	3.29	1.19	2.28	3.76
200	0.77	1.44	2.43	3.22
150	0.86	1.91	3.23	3.78

9xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	0.94	1.21	2.05	3.78
200	1.09	1.25	2.55	3.40
150	1.09	1.49	2.85	3.78

\* 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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