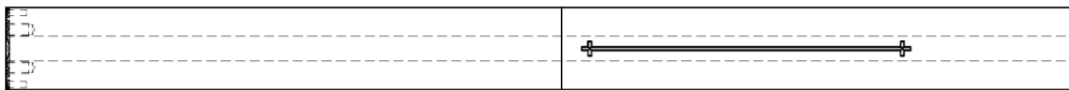
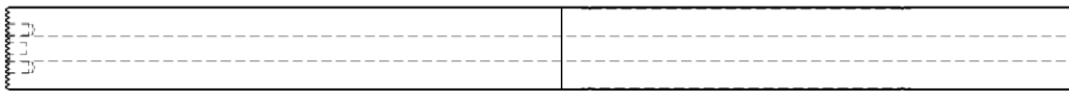


# STMD STMD M20-260

Vibration damped turning tool holder – modular



MAQ AB

[www.maqab.com](http://www.maqab.com) | [info@maqab.com](mailto:info@maqab.com)

Order product here

# Price and dimensions

More technical data on page 2

Diameter (mm)	Length (mm)		
20	260		

## Description:

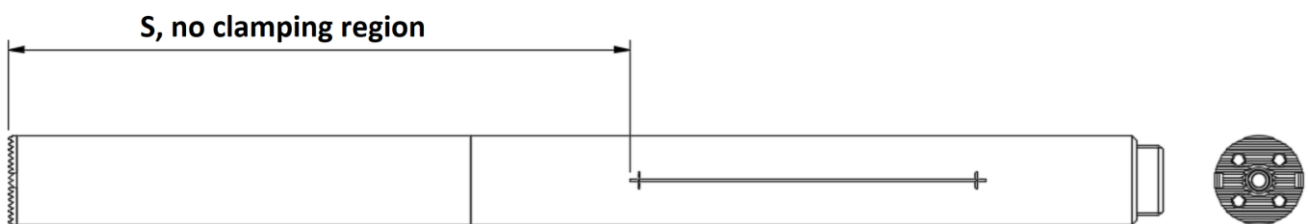
STMD turning tool holder

## Supplied with:

Insex screws M3X8, 3 pcs  
Allen wrench, 1 pcs  
Coolant adapter M16x1 - 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	20
Adaptive interface workpiece direction	SL20
No clamping region (S)	105 mm
Recommended maximum overhang (OHX)	Approx. 200 mm
Coolant entry form	Axial concentric
Coolant exit form	3C – axial and periphery
Coolant entry thread size	G ¼
Max coolant pressure	70 bar
Alignment aid property	Central groove
Connection diameter (DCON)	20 mm
Functional length (LF)	260 mm
Body material	Carbide reinforced steel
Weight of item	1.0 kg
Recommended clamping length	60 mm (3XD)
Method of cutting off	EDM Wire cutting

# 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)

MAQ AB

[www.maqab.com](http://www.maqab.com) | [info@maqab.com](mailto:info@maqab.com)

Order product here