

STMD STMD M25-255

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)		
25	255		

Description:

STMD turning tool holder

Supplied with:

Insex screws M4X9, 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






Technical data

Adaptive interface machine direction	25
Adaptive interface workpiece direction	SL25
No clamping region (S)	100 mm
Recommended maximum overhang (OHX)	Approx. 180 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)	25 mm
Functional length (LF)	255 mm
Body material	Steel
Weight of item	1.1 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: 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	0.75	1.05	2.13	3.86
200	0.68	0.99	2.31	3.85
150	0.64	1.20	2.68	3.95

8xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	0.59	1.04	2.15	3.80
200	0.82	1.11	2.19	3.02
150	1.10	1.24	2.59	3.84

9xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	0.72	1.39	2.31	3.35
200	0.75	1.36	2.41	3.66
150	0.98	1.53	2.63	4.59

* 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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