

STMD STMD M25-330

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 | 330 | | |

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 12XD
Refer to product performance datasheet
below.
Maximum cutting depth (To be updated) mm



Download drawing

 STEP




 DWG

Technical data

| | |
|--|---------------------------------|
| Adaptive interface machine direction | 25 |
| Adaptive interface workpiece direction | SL25 |
| No clamping region (S) | 120 mm |
| Recommended maximum overhang (OHX) | Approx. 255 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) | 330 mm |
| Body material | Steel |
| Weight of item | 1.7 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

10xD DOC = 0.5mm

| Speed | Feed | | | |
|-------|--------|------|------|------|
| | 0.05** | 0.10 | 0.15 | 0.20 |
| 300 | 1.10 | 1.48 | 2.86 | 4.26 |
| 200 | 0.95 | 1.83 | 2.55 | 3.48 |
| 150 | 0.66 | 1.40 | 2.81 | 3.77 |

11xD DOC = 0.5mm

| Speed | Feed | | | |
|-------|--------|------|------|------|
| | 0.05** | 0.10 | 0.15 | 0.20 |
| 300 | N.A | 2.02 | 2.03 | 4.02 |
| 200 | N.A | 4.78 | 2.31 | 3.15 |
| 150 | N.A | 1.79 | 2.52 | 4.25 |

12xD DOC = 0.5mm

| Speed | Feed | | | |
|-------|--------|------|------|------|
| | 0.05** | 0.10 | 0.15 | 0.20 |
| 300 | N.A | N.A | 5.13 | 4.5 |
| 200 | N.A | N.A | 4.88 | 3.73 |
| 150 | N.A | N.A | N.A | 4.50 |

* 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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