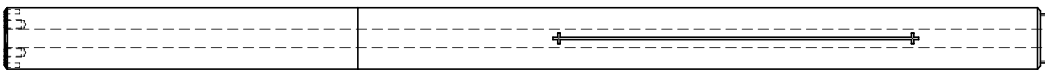
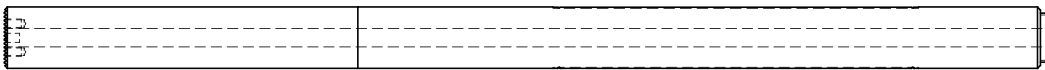


STMD STMD M25-430

Vibration damped turning tool holder – modular



Price and dimensions

More technical data on page 2

Diameter (mm)	Length (mm)		
25	430		

Description:

STMD turning tool holder

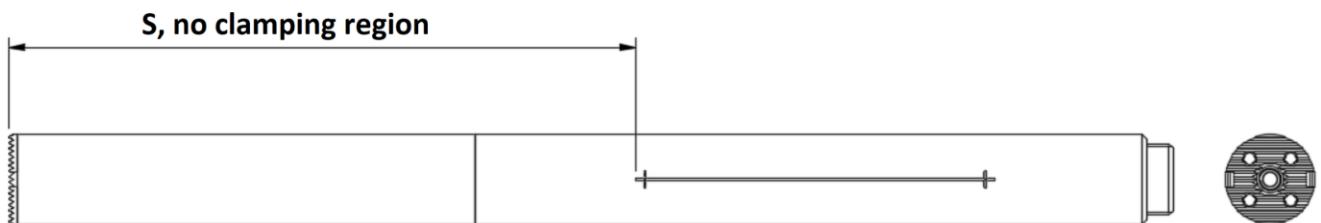
Supplied with:

Insex screws M4X9,	3 pcs
Allen wrench,	1 pc
Coolant adapter, M20x1 - G1/4	1 pc

Note:

Cylindrical shank without clamping feature.
 With central groove for alignment.
 Application ranges - up to 15XD
 Refer to product performance datasheet below.

Maximum cutting force – 1200 N



Download drawing:

STEP

DWG

Technical data

Adaptive interface machine direction	25
Adaptive interface workpiece direction	SL25
No clamping region (S)	146 mm
Maximum overhang (OHX)	Approx. 350 mm
Coolant entry form	Axial concentric
Coolant exit form	3C – central and periphery
Coolant entry thread size	M20x1 Male, G ¼*
Max coolant pressure	70 bar
Alignment aid property	Central groove
Connection diameter (DCON)	25 mm
Functional length (LF)	430 mm
Body material	Carbide reinforced steel
Weight of item	3.2 kg
Recommended clamping length	75 mm (3XD)
Method of cutting off	EDM Wire cutting

* With a coolant adapter from M20x1 female to G1/4 female

Quality / Product performance reference*

Product: STMD M25-430
Cutter head: MAQ SDUCR 25 - 1
Cutting Insert: DCMT 11T304 P25C
Workpiece: 34CrNiMo HRC28-30
Cutting speed: 200 m/min
Depth of cut: 0,5 mm
Feed rate: in mm/rev
Coolant: On

Feed (mm/rev)	0,10	0,15	0,20
Setup			
12xD	1,30	2,07	3,17
13xD	1,09	2,10	2,88
14xD	0,94	1,48	2,76
15xD	NA	NA	2,51
Surface roughness (Ra) measurement in µm			

Quiet with good/medium surface quality	Slight/medium vibrations with medium surface quality	Strong vibrations / Insert broken

* 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)