

# STMD STMD M32-320

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)		
32	320		

## Description:

STMD turning tool holder

## Supplied with:

Insex screws M5X12, 3 pcs  
Allen wrench, 1 pcs  
Coolant adapter G1/2, 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>32</b>
Adaptive interface workpiece direction	<b>SL32</b>
No clamping region (S)	<b>115 mm</b>
Recommended maximum overhang (OHX)	<b>Approx. 255 mm</b>
Coolant entry form	<b>Axial concentric</b>
Coolant exit form	<b>3C – axial and periphery</b>
Coolant entry thread size	<b>G ½</b>
Max coolant pressure	<b>70 bar</b>
Alignment aid property	<b>Central groove</b>
Connection diameter (DCON)	<b>32 mm</b>
Functional length (LF)	<b>320 mm</b>
Body material	<b>Steel</b>
Weight of item	<b>2.1 kg</b>
Recommended clamping length	<b>96 mm (3XD)</b>
Method of cutting off	<b>Slot turning / Sawing</b>

# Quality / Product performance reference\*

**Depth of cut:** 0.5 mm      **Nose radius:** 0.4 mm  
**Cutter head:** MAQ SDUCR 32      **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	0.96	1.35	2.41	4.11
200	0.71	1.40	2.18	3.79
150	0.60	1.26	2.55	4.15

8xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	2.88	1.15	2.62	4.00
200	0.48	0.96	2.35	3.23
150	0.41	0.93	2.40	3.58

9xD DOC = 0.5mm

Speed	Feed			
	0.05**	0.10	0.15	0.20
300	1.23	1.21	2.29	3.74
200	0.74	1.16	2.34	3.32
150	0.76	1.24	2.34	3.64

\* 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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