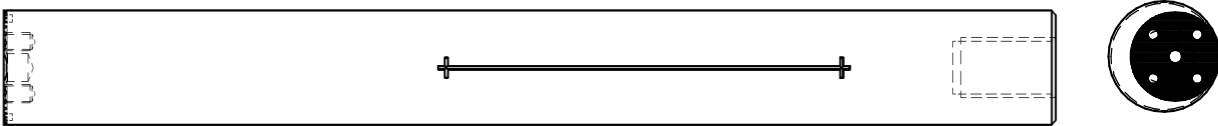


# STMD STMD M50-518-40

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)		
50	518		

## Description:

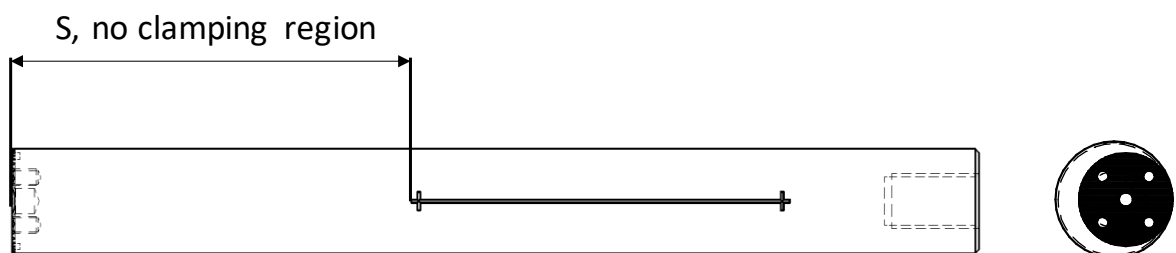
STMD turning tool holder

## Supplied with:

Insex screws M6X14, 3 pcs  
Allen wrench, 1 pcs  
Coolant adapter G3/4, 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	50
Adaptive interface workpiece direction	SL40
No clamping region (S)	140 mm
Maximum overhang (OHX)	Approx. 420 mm
Coolant entry form	Axial concentric
Coolant exit form	1C – axial
Coolant entry thread size	G ¾
Max coolant pressure	70 bar
Alignment aid property	Central groove
Connection diameter (DCON)	50 mm
Functional length (LF)	518 mm
Body material	Steel
Weight of item	8.0 kg
Recommended clamping length	150 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 40      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	0.63	1.11	2.44	3.84	
200	0.46	0.99	2.25	3.41	
150	0.66	0.97	2.27	3.73	

8xD DOC = 0.5mm

Speed	Feed				
	0.05**	0.10	0.15	0.20	
300	1.12	1.62	2.38	4.20	
200	0.72	0.99	2.22	3.33	
150	0.42	1.03	2.29	3.51	

9xD DOC = 0.5mm

Speed	Feed				
	0.05**	0.10	0.15	0.20	
300	0.76	1.01	2.31	3.99	
200	0.53	0.90	2.15	3.05	
150	0.53	1.11	2.31	3.43	

\* 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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