

STMD STMD M60-808-40

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) | | |
|---------------|-------------|--|--|
| 60 | 808 | | |

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 ranges up to 11XD.
Reference product performance datasheet to be updated.
Maximum cutting depth mm.



Download drawing

STEP




DWG

Technical data

| | |
|--|--------------------------|
| Adaptive interface machine direction | 60 |
| Adaptive interface workpiece direction | SL40 |
| No clamping region (S) | 250 mm |
| Recommended maximum overhang (OHX) | Approx. 690 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) | 60 mm |
| Functional length (LF) | 808 mm |
| Body material | Steel |
| Weight of item | 16.4 kg |
| Recommended clamping length | 180 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

9xD DOC = 0.5mm

| Speed | Feed | | |
|-------|------|------|------|
| | 0.10 | 0.15 | 0.20 |
| 200 | 1.43 | 2.45 | 3.77 |

10xD DOC = 0.5mm

| Speed | Feed | | |
|-------|------|------|------|
| | 0.10 | 0.15 | 0.20 |
| 200 | 1.70 | 2.63 | 3.90 |

11xD DOC = 0.5mm

| Speed | Feed | | |
|-------|------|------|------|
| | 0.10 | 0.15 | 0.20 |
| 200 | NA | NA | NA |

* The actual product performance is dependent on the rigidity of the clamping methods, and the table is used as reference.

(RA) = Arithmetic Average of the roughness profile (µm)

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