

STMD STMD i1-13.0

Vibration damped turning tool holder – modular



MAQ AB

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Price and dimensions

More technical data on page 2

Diameter (inch)	Length (inch)		
1	13.0		

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	1 inch
Adaptive interface workpiece direction	SL25
No clamping region (S)	4.7 inch
Recommended maximum overhang (OHX)	Approx. 10 inch
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)	1 inch
Functional length (LF)	13.0 inch
Body material	Steel
Weight of item	1.7 kg
Recommended clamping length	3 inch (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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