

# STMD STMD i1 ½ - 20.8-1C

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)		
1.5	20.8		

## Description:

STMD turning tool holder

## Supplied with:

Insex screws M6X14, 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 12XD  
Reference product performance datasheet to be updated.  
Maximum cutting depth (To be updated) mm.



Download drawing

STEP




DWG

## Technical data

Adaptive interface machine direction	<b>1.5 inch</b>
Adaptive interface workpiece direction	<b>SL40</b>
No clamping region (S)	<b>7.5 inch</b>
Recommended maximum overhang (OHX)	<b>Approx. 17.7 inch</b>
Coolant entry form	<b>Axial concentric</b>
Coolant exit form	<b>1C – Axial</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>1.5 inch</b>
Functional length (LF)	<b>20.8 inch</b>
Body material	<b>Steel</b>
Weight of item	<b>5.0 kg</b>
Recommended clamping length	<b>4.5 inch (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 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 – To be updated

10xD DOC = 0.5mm

Speed	Feed				
		0.05**	0.10	0.15	0.20
300					
200					
150					

11xD DOC = 0.5mm

Speed	Feed				
		0.05**	0.10	0.15	0.20
300					
200					
150					

12xD DOC = 0.5mm

Speed	Feed				
		0.05**	0.10	0.15	0.20
300					
200					
150					

\* 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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