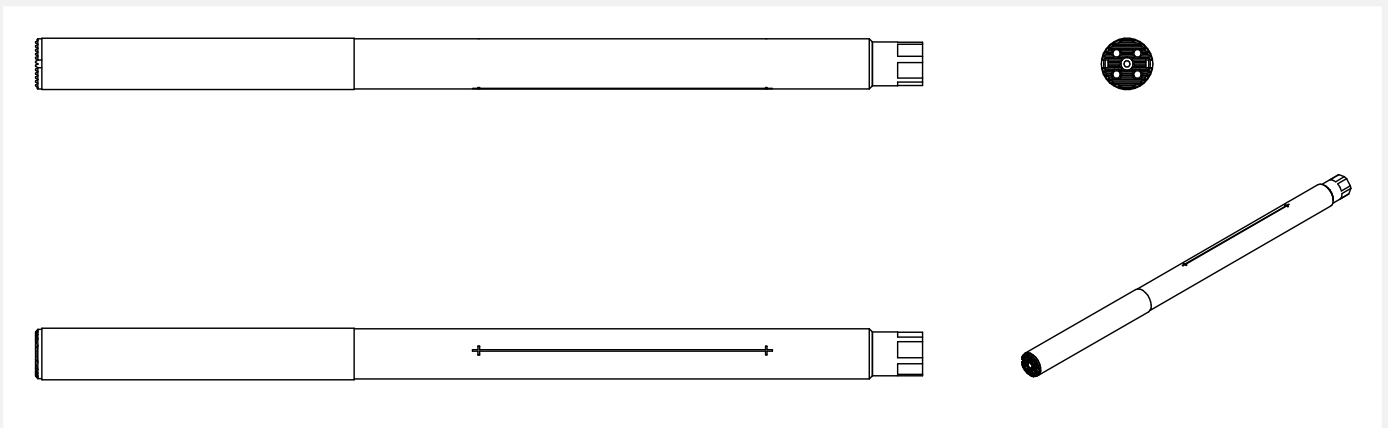


STMD STMD M32-544

Vibration damped turning tool holder – Modular



Price and dimensions

More technical data on page 2

Diameter (mm)	Length (mm)	Workable length (mm)
32	544	352- 480

Description:

STMD turning tool holder

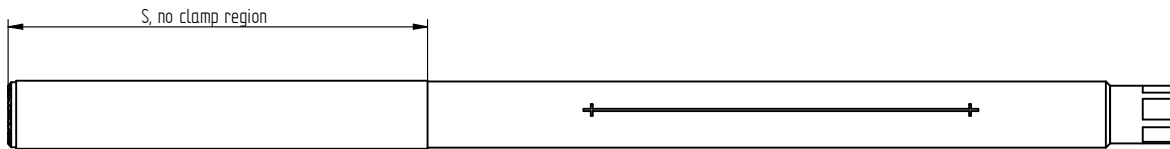
Supplied with:

Head screws M5 DIN912	3 pc
Allen wrench	1 pc
Coolant adapter M24x1 – G 1/4	1 pc

Note:

Cylindrical shank without clamping feature.
With central groove for alignment.
Application ranges – 11-15 xD
Refer to product performance datasheet below.

Maximum cutting force – 3 000 N



Download drawing:

STEP

DWG

Technical data































Adaptive interface machine direction	32
Adaptive interface workpiece direction	SL32
No clamping region (S)	178 mm
Maximum overhang (OHX), including cutter head	Approx. 480 mm
Coolant entry form	Axial
Coolant exit form	3C – central and peripheral
Coolant entry thread size	G ¼ (with adapter)
Max coolant pressure	70 bar
Alignment aid property	Central groove
Connection diameter (DCON)	32 mm
Functional length (LF)	544 mm
Body material	Carbide reinforced steel
Weight of item	6.4 kg
Recommended clamping length	96 mm (3XD)
Method of cutting off	Grinding carbide

Quality / Product performance reference*

Product: MAQ STMD M32- 544 with SDUCR-32



Test date: 2021-09-21

<u>11XD</u>	 1	 1	 1	 1	 1	 1
<u>12XD</u>	 1	 1	 1	 1	 1	 1
<u>13XD</u>	 1	 1	 1	 1	 1	 1
<u>14XD</u>	 2	 2	 1	 1	 1	 1
<u>15xD</u>	 3	 3	 2	 2	 1	 1
Overhang / Feed (mm/rev)	<u>0.12</u>		<u>0.15</u>		<u>0.20</u>	
Theoretical surface Ra (µm)	<u>1.2</u>		<u>2.60</u>		<u>4.63</u>	

Depth of cut: 0.5 mm

Cutting insert:

DCMT 11T304-FP P25C


Workpiece: 4340 Steel HRC 30


Cutting Speed: 200 m/min


Nose radius: 0.4 mm

Cutting condition: Wet

Vibration level:

1: No vibration 

2: Acceptable 

3: Strong vibration 

Surface finish: 

1: Good

2: Acceptable

3: Not acceptable

* 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)