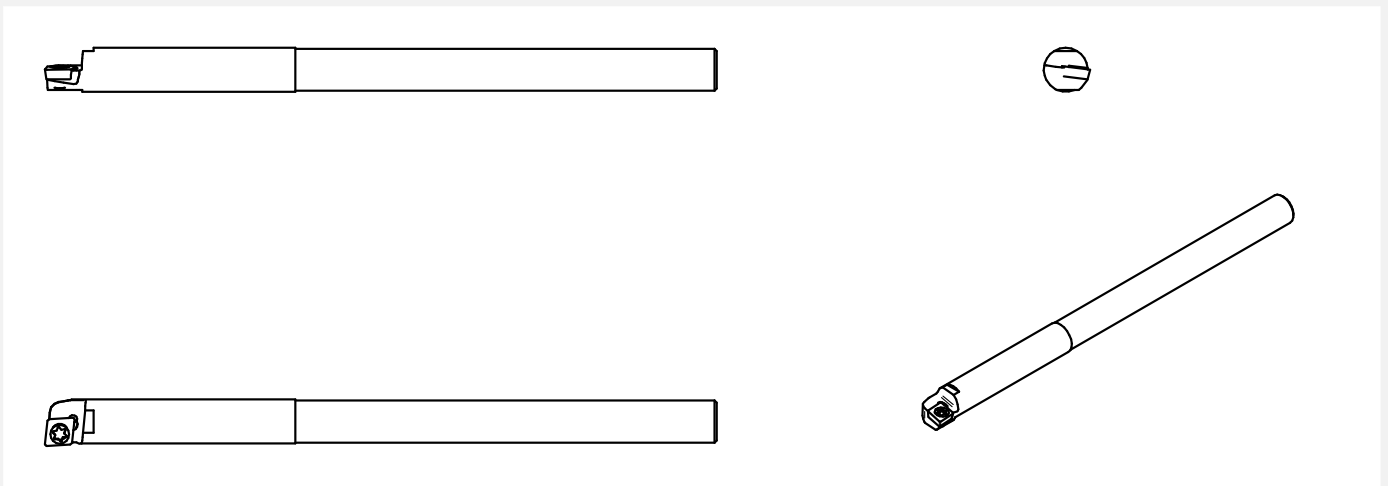


# STMD I 5/16-4.7 SCLCR

Vibration damped turning tool holder – Monoblock



## Dimensions

More technical data on page 2

Diameter (inch)	Length (inch)	Workable length (inch)
5/16	4.7	2.204-3.464

## Description:

STMD turning tool holder

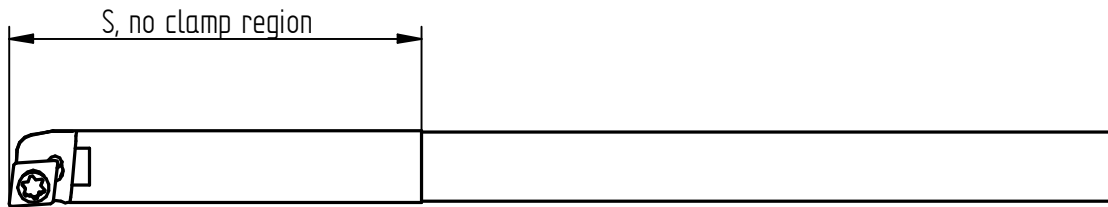
## Supplied with:

Insert screws M2.5	1 pc
Insert screw key	1 pc

## Note:

Cylindrical shank without clamping feature.  
With central groove for alignment.  
Application ranges – 7-11 xD  
Refer to product performance datasheet below.

Maximum cutting force – 260 N



Download drawing:

STEP

DWG

## Technical data

Adaptive interface machine direction	5/16"
Adaptive interface workpiece direction	CCMT 0602XX
No clamping region (S)	1.9"
Maximum overhang (OHX), including cutter head	Approx. 3.44
Coolant entry form	Axial central
Coolant exit form	Two exits, to insert and to workpiece
Coolant entry thread size	M7x0.5
Max coolant pressure	70 bar
Alignment aid property	Central groove
Connection diameter (DCON)	5/16"
Functional length (LF)	5"
Body material	Carbide reinforced steel
Weight of item	0.15 kg
Recommended clamping length	0,94" (3XD)
Method of cutting off	Grinding carbide

## Quality / Product performance reference\*

Product: MAQ STMD I 5/16-4.7 SCLCR



Test date: 2022-09-30

<u>7XD</u>	1	1	1	1	1	1
<u>8XD</u>	1	1	1	1	1	1
<u>9XD</u>	1	1	1	1	1	1
<u>10XD</u>	1	1	1	1	1	1
Overhang / Feed (inch/rev)	<u>0.0047</u>		<u>0.0059</u>		<u>0.0066</u>	
Theoretical surface Ra (µm)	<u>1.2</u>		<u>2.60</u>		<u>4.63</u>	

Depth of cut: **0.0098 inch**

Cutting insert:

**CCMT 060204-FP P25C**

**Workpiece: 4340 Steel HRC 30**

**Cutting Speed: 656 feet/min**

**Nose radius: 0.0157 inch**

**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)