

# STMD STMD M12-144

Vibration damped turning tool holder – Modular

## Price and dimensions

More technical data on page 2

Diameter (mm)	Length (mm)	Workable length (mm)
12	144	72-108

## Description:

STMD turning tool holder

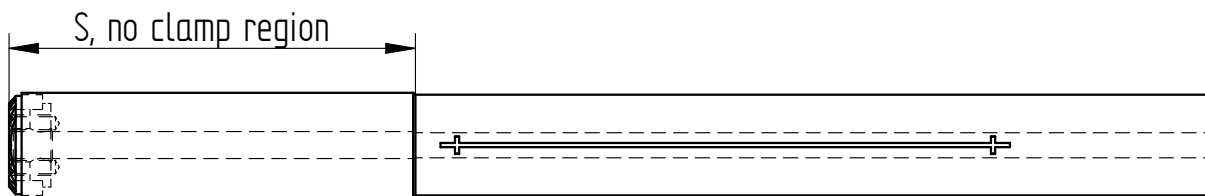
## Supplied with:

Head screws M2 DIN912	3 pc
Allen wrench	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 – 1000 N



Download drawing:

STEP

## Technical data

























Adaptive interface machine direction	16
Adaptive interface workpiece direction	SL12
No clamping region (S)	50 mm
Maximum overhang (OHX), including cutter head	Approx. 108 mm
Coolant entry form	NA
Coolant exit form	3C – central and peripheral
Coolant entry thread size	NA
Max coolant pressure	70 bar
Alignment aid property	Central groove
Connection diameter (DCON)	12 mm
Functional length (LF)	144 mm
Body material	Carbide reinforced steel
Weight of item	0.18 kg
Recommended clamping length	36 mm (3XD)
Method of cutting off	Grinding carbide

## Quality / Product performance reference\*

Product: MAQ STMD M12- 144 with SDUCR-12



Test date: 2019

<u>6XD</u>	 1	 1	 1	 1	 1	 1
<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
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: 0.25 mm

Cutting insert:

DCMT 070204-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)