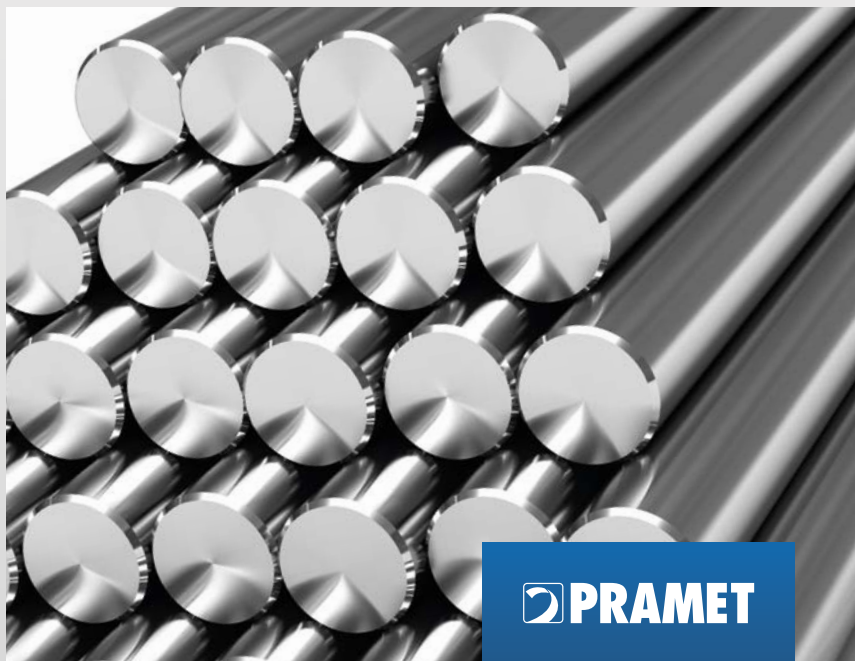


DORMER PRAMET

HEAVY MACHINING

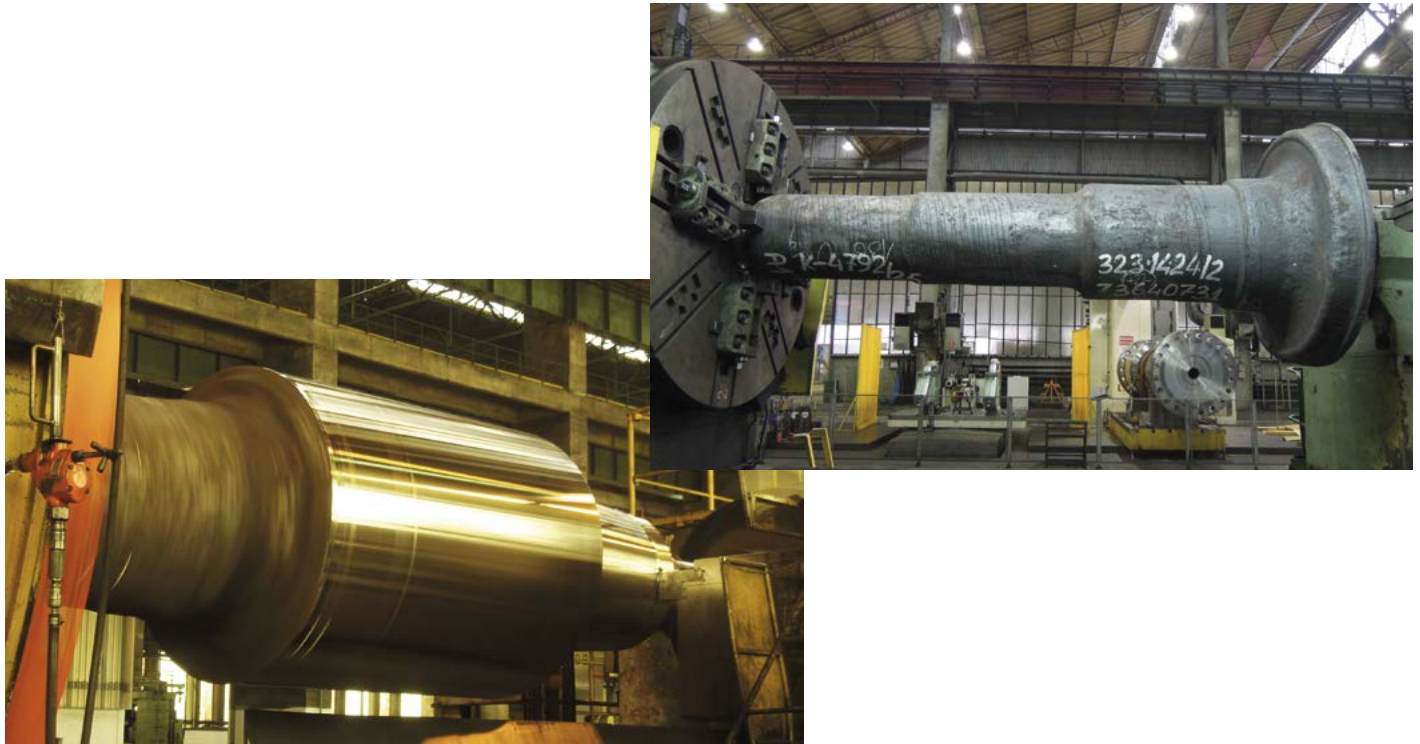
Scarfig, Bar Peeling, Tube & Pipe



 PRAMET

In the Heavy machining sector we focus on removing the first layer of material from large-scale forgings, castings, rolling, welding and oxy acetylene-cut work pieces. These are operations that require high reliability of cutting tools working in very tough conditions. Through long-term cooperation with leading factories in many countries, we have developed specific tooling for:

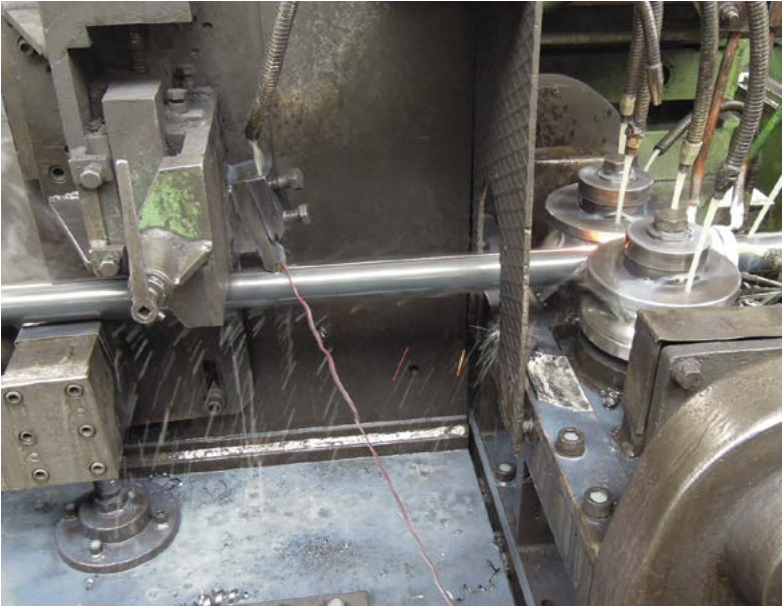
HEAVY TURNING



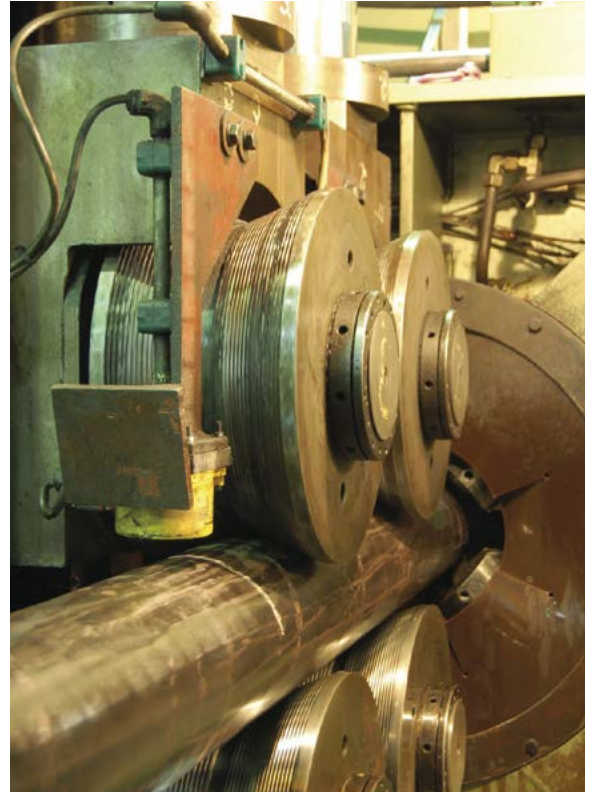
HEAVY MILLING



SCARFING



BAR PEELING



SPECIAL THREADING



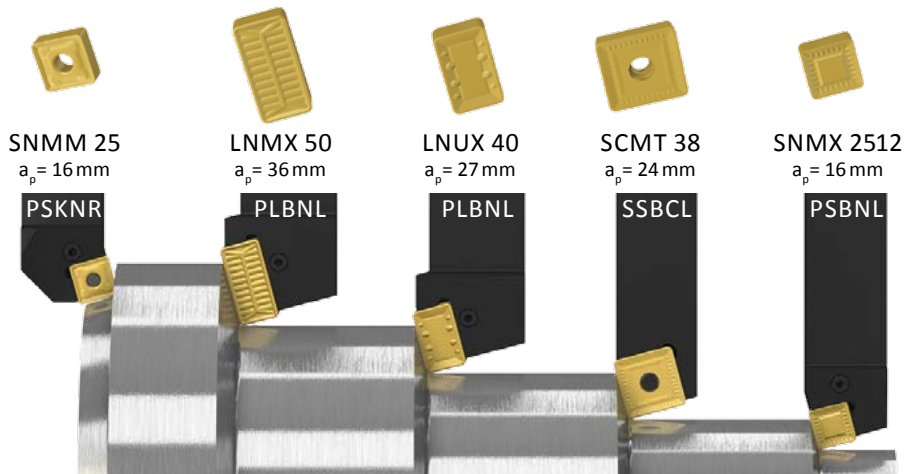
CHAMFERING OF TUBES



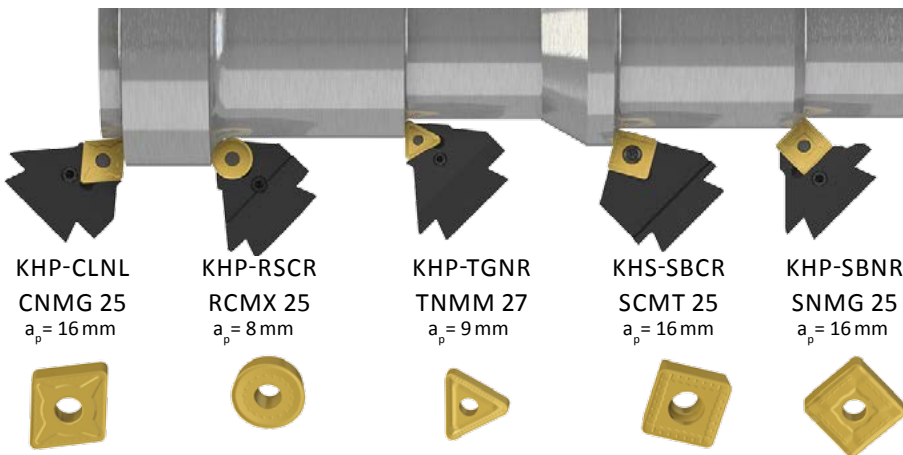
HEAVY TURNING

Heavy Turning operations include machining large Shafts with uneven surfaces or skin from forging or casting with a combination of continuous or interrupted cuts. As a possible solution we can offer indexable inserts with cutting edge lengths from 25 – 50 mm and tool holders with a range of approach angles to cover all common applications, all conditions and variations in machine power.

Depending on demands for productivity and machine rigidity we can offer a selection of positive or negative inserts, geometries and corresponding cross section of tool holder. Heavy Turning applications can achieve high metal removal rates to a level of 1500 kg/hour. Productive cutting conditions are set-up using our UP!GRADE grades. To support quick tool change we offer the unique KH cassettes system which allows the user to replace the head of the tool within 30 seconds.



**"CHOOSE
THE MOST
EFFICIENT
TOOLS"**

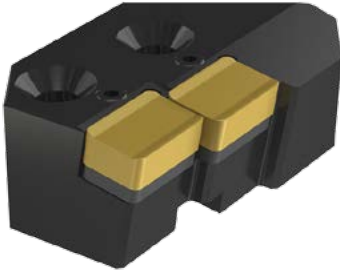


**"LOOKING
FOR A QUICK
CHANGE?"**



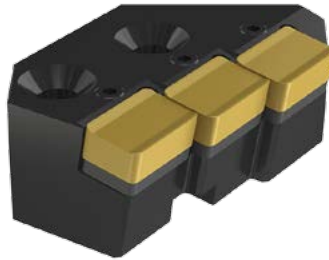
DOUBLE DEPTH OF CUT

Inserts: 2x LNUX 40
 $a_p = 50\text{mm}$



TRIPLE PRODUCTIVITY

Inserts: 3x LNUX 40
 $a_p = 80\text{mm}$



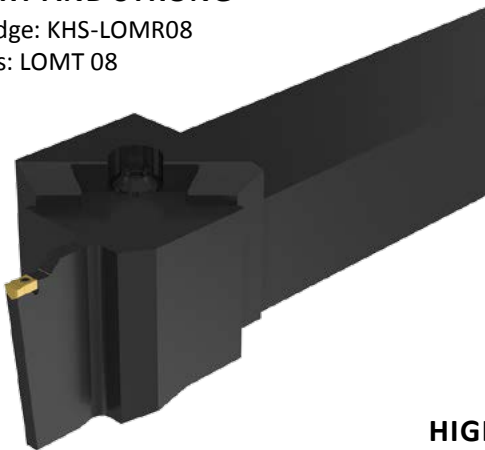
SMART AND STRONG

Tool holder cross-section
100x100 with KH cartridges



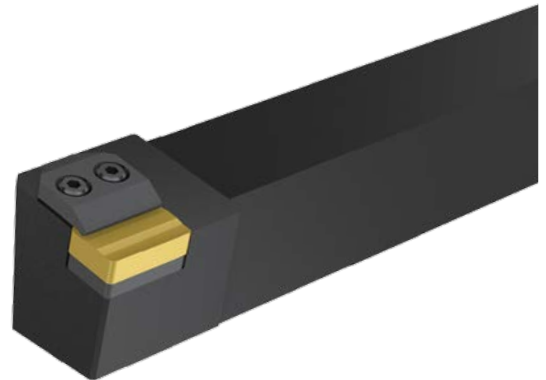
SMART AND STRONG

Cartridge: KHS-LOMR08
Inserts: LOMT 08



HIGH RELIABILITY FOR HARD SHAFTS

Inserts: LNUN 42
 $a_p = 30\text{mm}$



In support of requirements for specific technologies, various technologies or special machine tools or clamping systems, we can offer a service to develop and manufacture tailor-made tools. We enjoy any challenge to find the solution for non-standard applications.



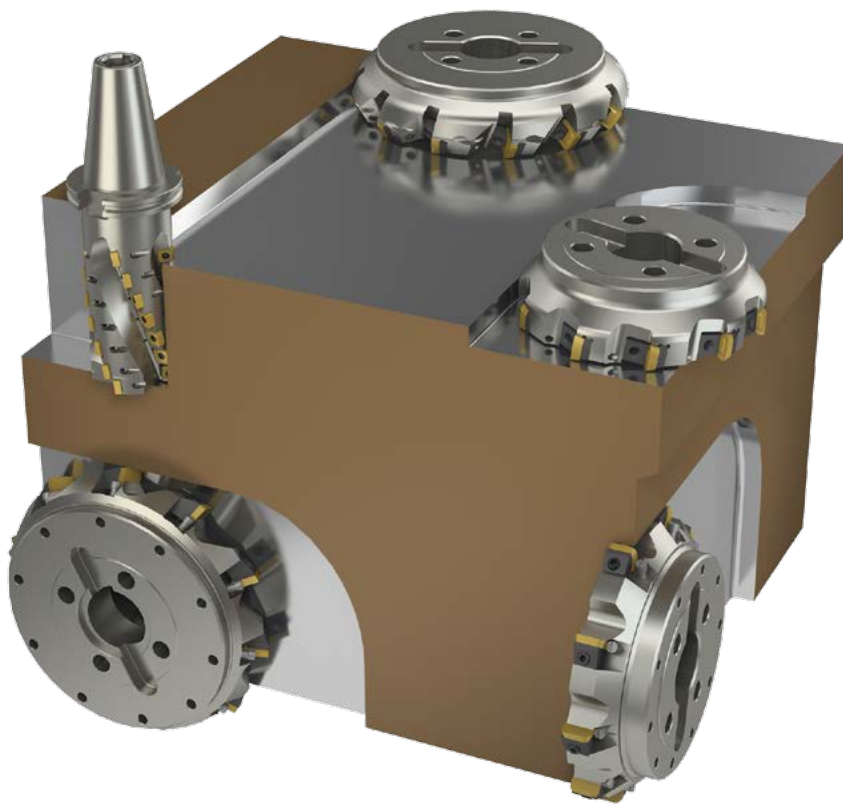
HEAVY MILLING

Heavy Milling operations often involve machining complicated castings which could be polluted by sand or forgings with hard skins or scale. Our aim is to offer an optimal solution based upon the rigidity of machine, workpiece clamping, machine power and specific customer requirements. Depending on the approach angle we can divide the tools into groups: Face milling cutters, 90° Shoulder milling cutters, Helical milling cutters, Chamfer milling cutters and Special milling cutters. The main priorities are high metal removal rate and reliability of cutting edge. Insert reliability is provided by using our UP!GRADE grades. and high efficiency is supported by our unique Milling cutters developed specifically for Heavy Milling applications.

**"RELIABLE AND
PRODUCTIVE IN
EXTREMELY TOUGH
CONDITIONS"**

SLSN

LNET 16 + SNEX 13
LNEX 16 + SNET 13
 $a_p = 104 \text{ mm}$



F60SB22X

SBMR 22 + SBKX 22
 $a_p = 15 \text{ mm}$

F90TB27X

TBMR 27
 $a_p = 18 \text{ mm}$

W60SP25P

SPGN 25
 $a_p = 18 \text{ mm}$

W90SP25P

SPUN 25
 $a_p = 22 \text{ mm}$



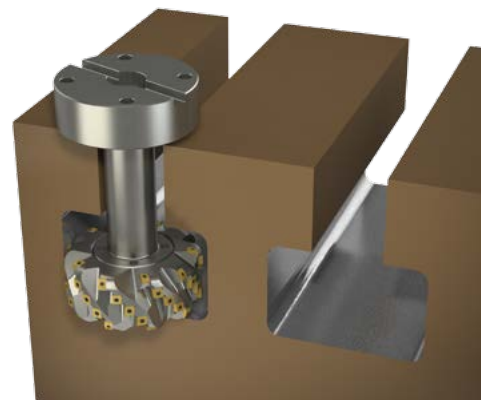
Our experienced designers have developed many special tools for Heavy Roughing operations including T-slot cutters, large diameter Disc milling cutters, Specific shape cutters and special Tangential milling cutters.

"WE LOOK FORWARD TO YOUR CHALLENGE"



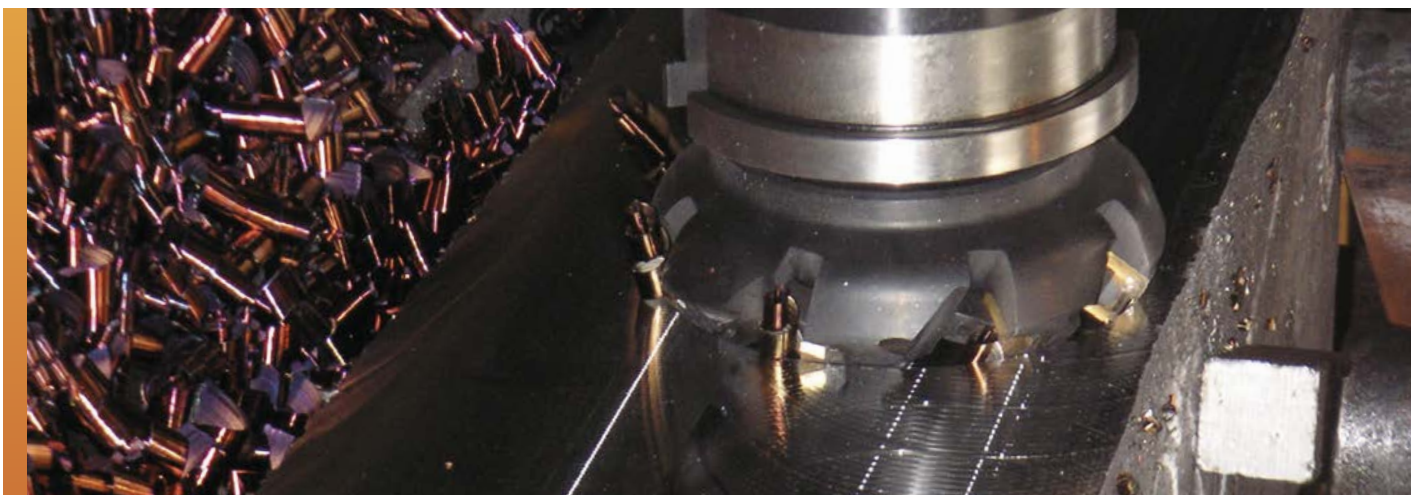
Cutter body for radius R36
Inserts: LPEX 19

Set of cutters for machining a special profile in Hardox 500



Cutter body for T- slot 250x160
Inserts: LCEX 19, CNM 563

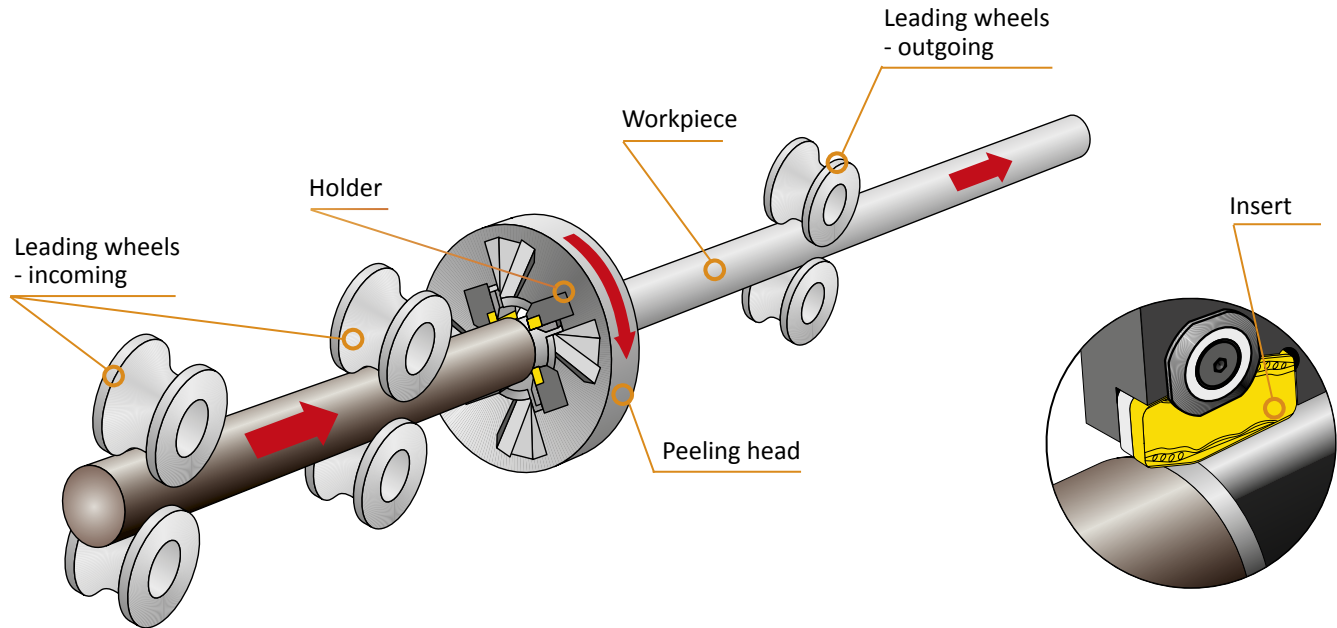
Cutter body D=560
Inserts: XNHQ 16; XCEW 14



BAR PEELING

In Bar Peeling applications, the most important criteria are high productivity, dimensional accuracy of machined bars and excellent surface quality. With many years of experience we are able to offer a wide range of inserts with specific geometries suitable for Steel, Stainless steel as well as difficult to machine materials. Clamping systems and cassettes can be provided on request.

**PEELING
WITH
SIGNIFICANTLY
REDUCED
VIBRATION**



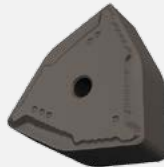
STANDARD ASSORTMENT



LNGF 30



RNGH 38



WNMJ 20



SPECIAL

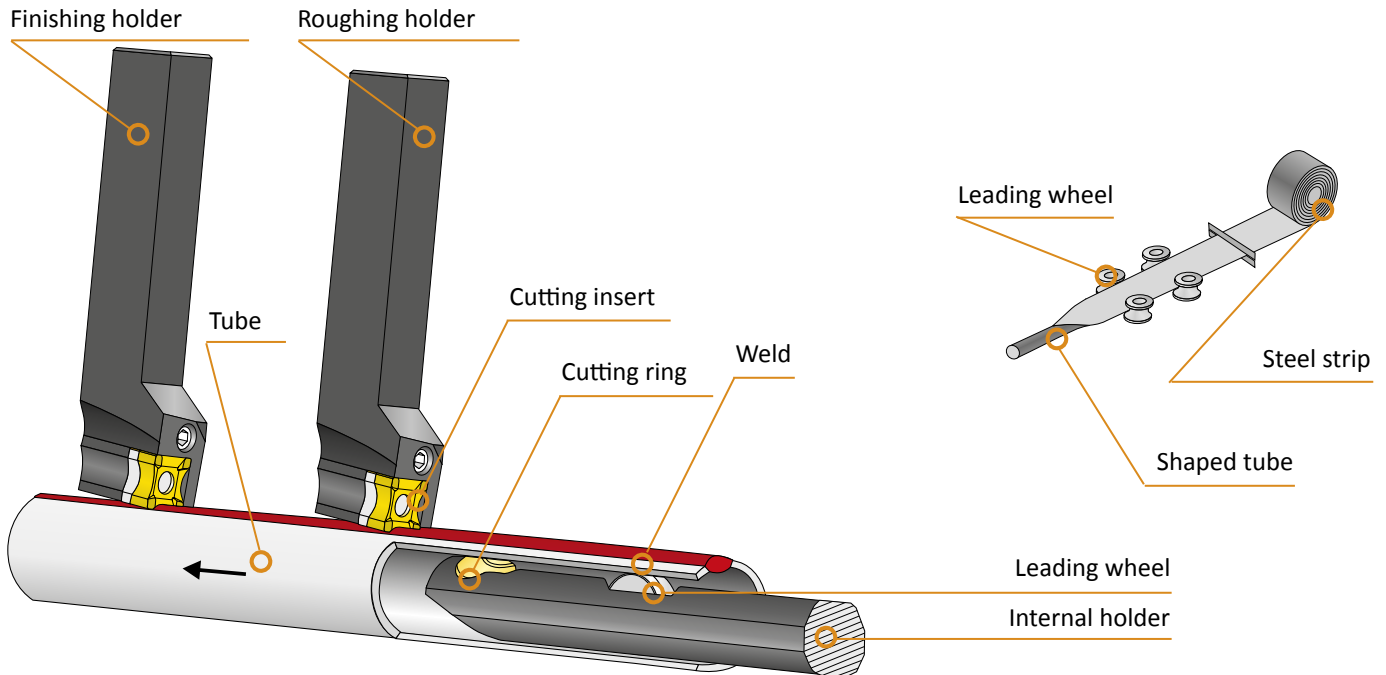
Detailed information about the standard range can be found in Pramet brochure 2017.1



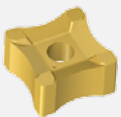
SCARFING

Cutting the weld deposit is one of last operations during tube production. The main requirement of this application is very good surface quality and, high productivity with minimum defects on the weld. We can offer a complete set of tool holders and a wide range of indexable inserts for external as well as internal operations. Tools are designed for all common tube diameters.

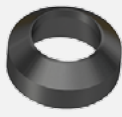
**"WHEN
A SMOOTH
SURFACE
IS NEEDED"**



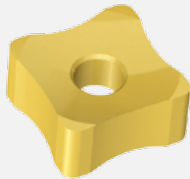
STANDARD ASSORTMENT



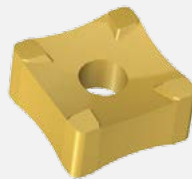
SNMX 15



PSR



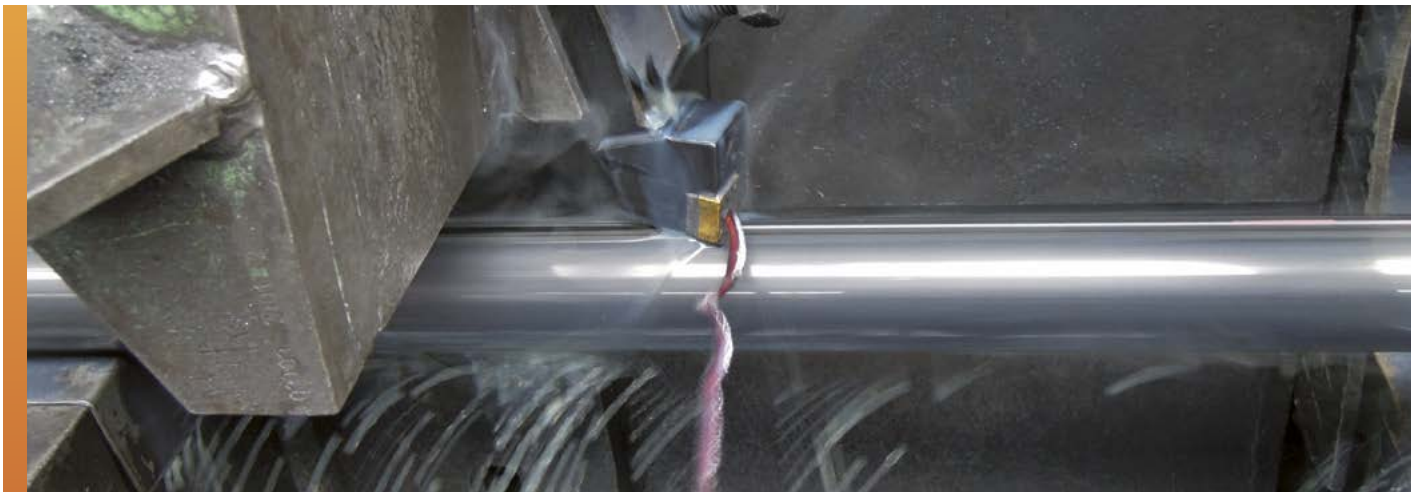
SNMX 2512



SNMX 25



Detailed information about the standard range can be found in the Scarfing catalogue.

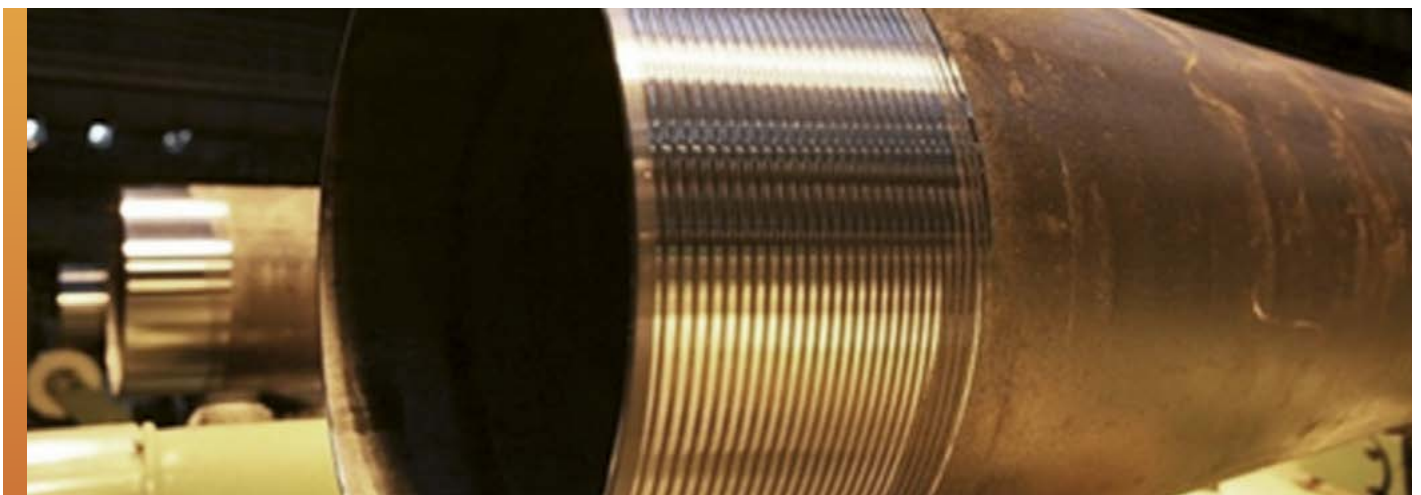
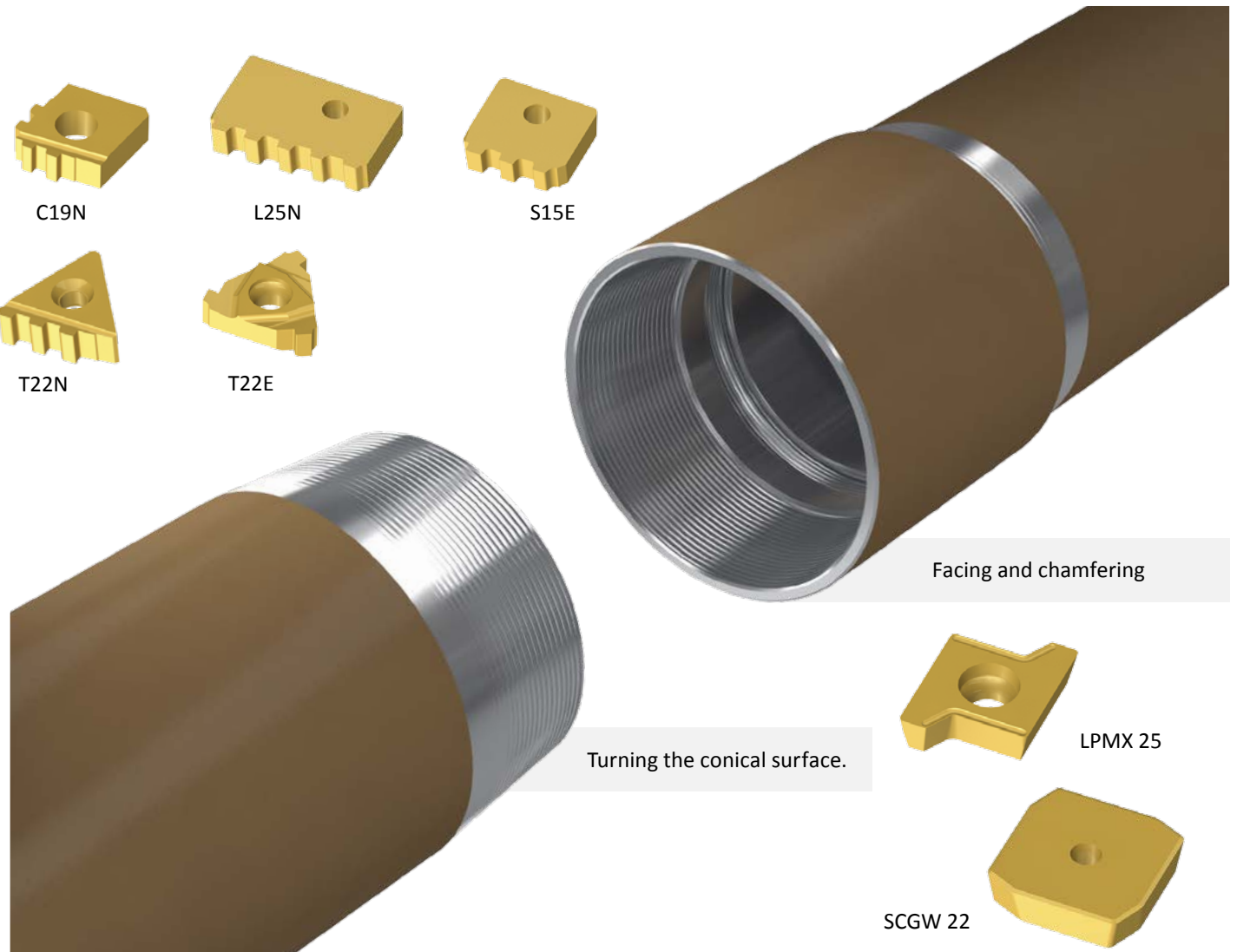


SPECIAL THREADING

We offer a large line of threading tools for Tube producers. These tools are designed for standard thread profiles as well as special profiles. Precise indexable inserts are manufactured using specific technology in order to achieve unique cutting edge quality and profile precision. Our priority is customer satisfaction.

Dormer Pramet also offer many special tools used for tube pre-threading operations.

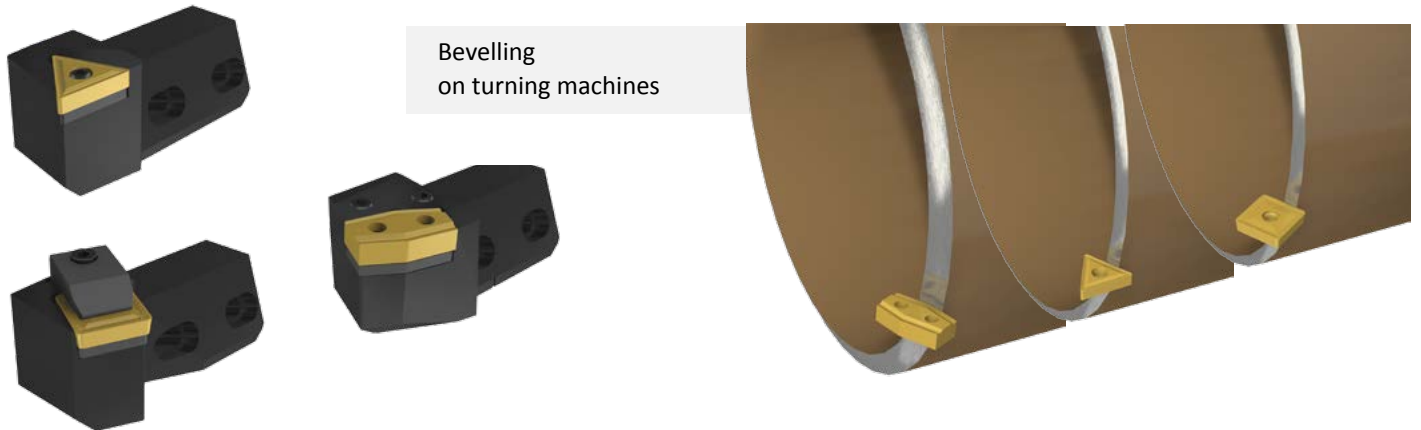
**"SPECIAL
THREADING
TOOLS FOR THE
TUBE INDUSTRY"**



CHAMFERING OF TUBES

We can meet requirements for different edge preparation procedures – including chamfering of metal sheets before forming into tubes up to 1500 mm diameter or bevelling the face of pipes. We provide options for a wide range of chamfer angles and chamfer widths, suitable for various machined materials and types of weld. Our range of chamfering tools are developed by our Custom tools department to ensure your specific requirements are met.

**EDGE
PREPARATION
FOR SAFETY
WELDS**



SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

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