

DORMER  PRAMET

SCARFING

2020



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CUTTING RINGS

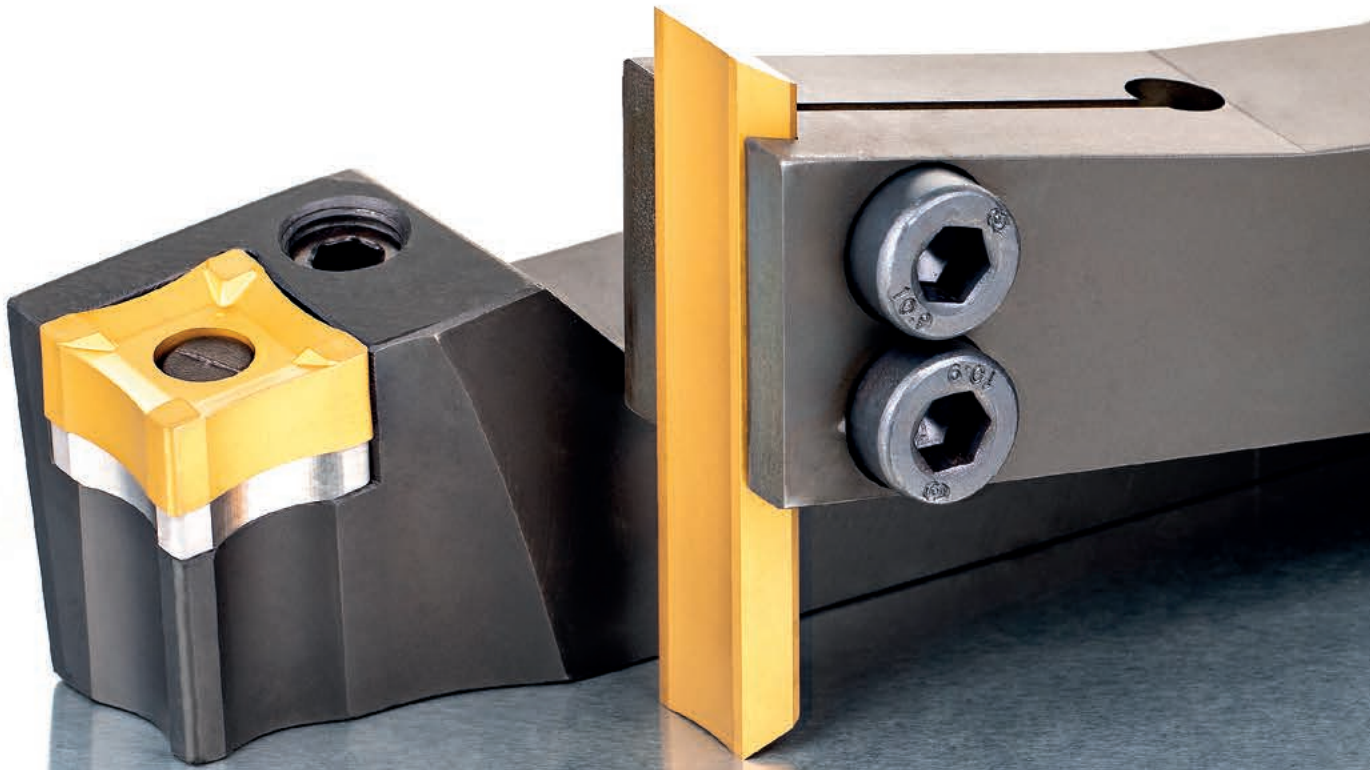
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We offer an assortment of tools for processing welded pipes, known as scarfing. Our range is made up of tough coated cemented carbide inserts suitable for handling extreme heat. The geometry of the cutting edge provides excellent tube surface quality, increasing tool life.

We have recently added to our scarfing range with a new positive insert for external weld bed removal. Also, our existing assortment has been expanded with additional sizes of inserts, rings and spare parts to further meet your needs.



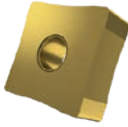



OUR OFFER

- Inserts for removal of weld bed from outside of tube diameter in a wide range of geometries and radii
- Rings for internal diameter scarfing in a wide range of sizes and grades
- Toolholders for external scarfing

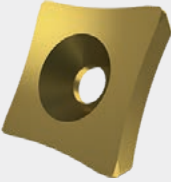
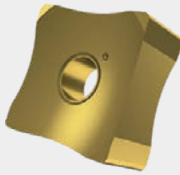

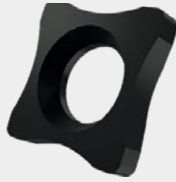
BENEFITS

- **High quality surface finish** – due to cutting edge accuracy
- **Prolonged tool life** - grades with very good thermal and chipping resistance
- **Versatile** - Available in grades 6640 and T9335
- **Operation reliability** - stable clamping eliminates insert vibration

INSERT TYPES

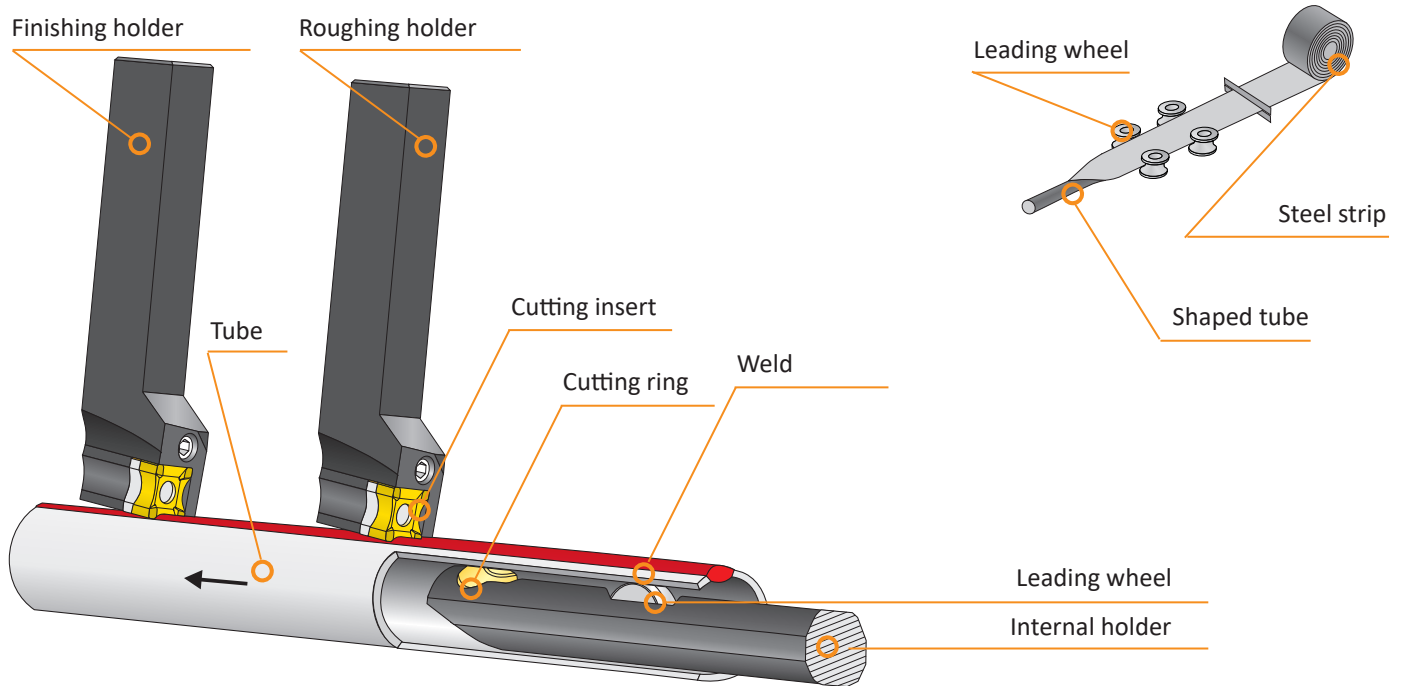
					
SNMX 15, 19, 25	SNMX 2512, 1507	SNMA 1506, 2509	SPUB	LDGN	PSR

NEW ITEMS

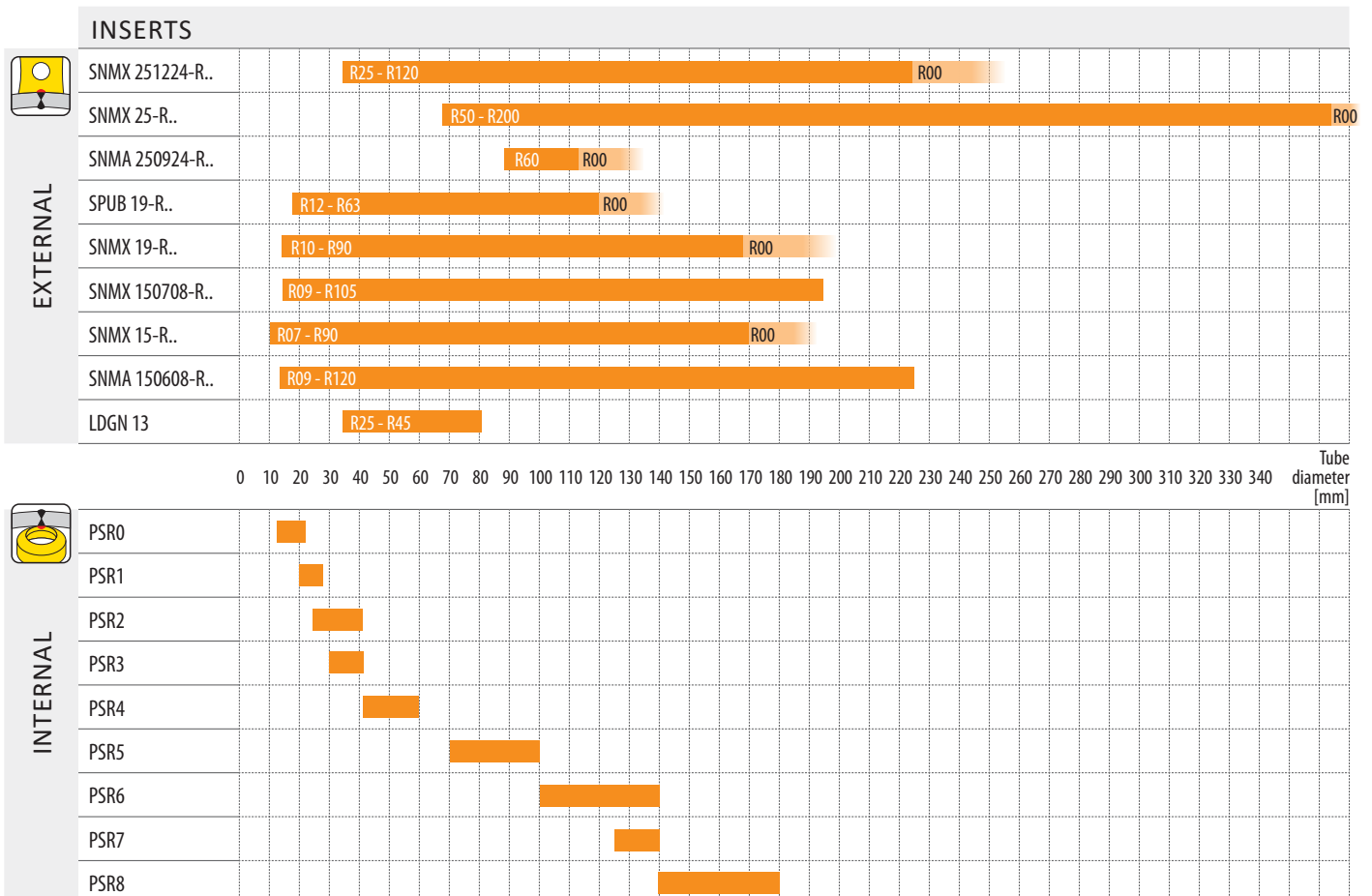
<div style="text-align: right;">NEW</div>  <div style="text-align: right;">SPUB 19</div> <ul style="list-style-type: none"> • Positive single-sided inserts with 11° clearance angle • Four cutting edges 	<div style="text-align: right;">NEW</div>  <div style="text-align: right;">SNMX 1507</div> <ul style="list-style-type: none"> • Negative, double sided inserts • Eight cutting edges and concave top 	<div style="text-align: right;">NEW</div>  <div style="text-align: right;">SNMA 1506</div> <ul style="list-style-type: none"> • Negative, double sided inserts • Eight cutting edges and flat top 	<div style="text-align: right;">NEW</div>  <div style="text-align: right;">SNU</div> <ul style="list-style-type: none"> • Shims allow clamping of inserts SNMX 2512 and SNMX 1507, with concave top, into our current holders.
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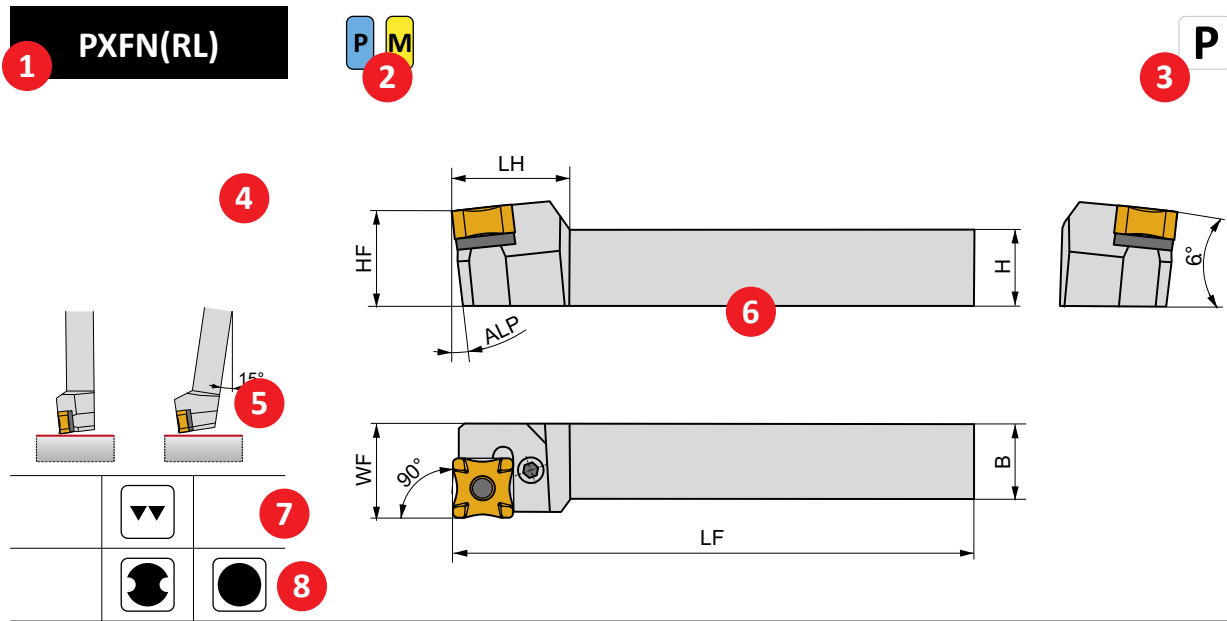
SCARFING

TOOLS FOR EXTERNAL AND INTERNAL TUBE WELD SCARFING



WHAT INSERT SHOULD I USE FOR MY TUBE DIAMETER ?





9

	H	B	HF	WF	OAL	LH	ALP	kg	GI	PX	AT
	[mm]	[mm]		[mm]	[mm]	[mm]	[°]				
PXFNR/L 2525 R 15	25	25	25	25	200	40	6	1,05	GI185	PX 40	AT009
PXFNR/L 2525	25	25	25	25	250	45	6	1,2	GI185	PX 40	AT009
PXFNR/L 3232 S 25	32	32	40	40	250	50	6	2,2	GI199	PX 60	AT010



16

GI185	SNMX 15-R..
GI186	SNMX 19-R..
GI199	SNMX 25-R..



17

PX40	SNU 150310-R	PU 03	US 36	MT 07	HXK 4
PX50	SNU 190410-R	PU 05	US 38	MT 06	HXK 5
PX60	SNU 250424-R	PU 06	US 39	MT 08	HXK 5



18

AT009	SNMX 150708-R..	SNU 150410-CX
AT010	SNMX 251224-R..	SNU 250524-CX


1	Designation of tool holder type	7	Achievable surface quality	13	Group of compatible inserts ²⁾
2	Material group recommendations	8	Character of cut/working conditions	14	Group of spare parts ^{2), 3)}
3	Clamping system of insert	9	Possible applications	15	Group of accessories ^{2), 3)}
4	Illustrative picture ¹⁾	10	ISO code of holder	16	Compatible inserts
5	Inclination angle	11	Dimensions [mm] and angles [°] of holder	17	Spare parts
6	Schematic drawing of tool	12	Weight [kg]	18	Special accessories

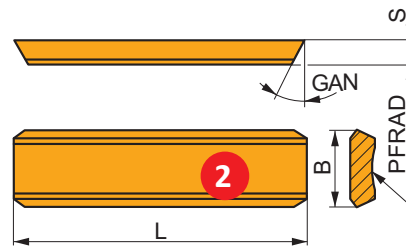
¹⁾ Turning holder is primarily displayed in its right-hand design (R)








²⁾ Code for Group of compatible inserts, spare parts and special accessories is used only for purposes of this catalogue. It cannot be used for orders.

³⁾ Spare parts and special accessories icons are designed schematically for ease of understanding. They aren't included in the list of icons. Screws are, in some cases, completed with info on torque value in Nm, length of screw and size of thread.

1 LDGN


	L	3	B	GAN
13,05	60,00	5,00	15,00	30°





		ISO		P	M	K	N	S	H	PFRAD	
		LDGN 130560-R25	6640	■	■					25	34-45
		LDGN 130560-R30	6640	■	■					30	41-54
		LDGN 130560-R35	6640	■	■					35	48-63
4 	5 	LDGN 130560-R40	6640	■	■					9	51-63
E 		LDGN 130560-R45	6640	■	■					9	51-63

- | | | | |
|----------|---|-----------|----------------------------|
| 1 | Designation of insert type (group) | 6 | ISO code of insert |
| 2 | Schematic drawing of insert | 7 | Grade |
| 3 | Table with insert sizes [mm] | 8 | Application area of insert |
| 4 | Icons - specific features, cutting edge type and picture of representative insert | 9 | Radius |
| 5 | Profile of main cutting edge | 10 | Tube diameter |







ICONS AND SYMBOLS

 Priority use









 Icon absence - tool is not recommended for specific operation or group of materials or it does not have specific feature

 Possible use

Icons - scarfing holders

General features of tools	
	Material groups
	Medium machining – good surface quality
	Unstable working conditions
	Very unstable working conditions
	External scarfing
	Internal scarfing

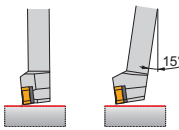

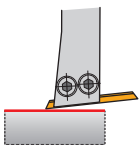







Icons and symbols - inserts

Features	
	Universal wide range option
	For tough materials (long chipping)
	Rounded edge
Conditions of use	
	Main application
	Secondary application
	Stable working conditions
	Unstable working conditions
	Very unstable working conditions

NAVIGATOR - ISO INSERTS

<p>SNMX 15-R</p>  <p> 10</p>	<p>SNMX 19-R</p>  <p> 11</p>	<p>SNMX 25-R</p>  <p> 12</p>	<p>SNMX 1507-R</p>  <p> 12</p>	<p>SNMX 2512-R</p>  <p> 13</p>
<p>SNMA 1506-R</p>  <p> 14</p>	<p>SNMA 2509-R</p>  <p> 15</p>			
<p>SPUB 19-R</p>  <p> 15</p>				
<p>LDGN</p>  <p> 16</p>				
<p>PSR</p>  <p> 16-17</p>				

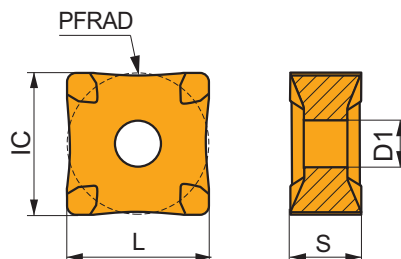
NAVIGATOR - TOOLS

<p>PXFN(RL) EXT</p>		<p>XLCD(N) EXT</p>	
	<p>SN..</p>  <p>15 19 25</p>		<p>LDGN</p>  <p>13</p>
	<p>25x25 32x32</p>		<p>25x25</p>
<p> 18</p>	<p> 10-15</p>	<p> 19</p>	<p> 16</p>

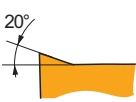
SNMX 15-R



	L	IC	D1	S
SNMX 15	15,875	15,875	5,16	8,15



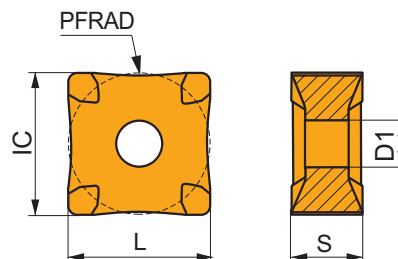
i	↙	ISO	Image	Material Properties						PFRAD	ODW
				P	M	K	N	S	H		
		SNMX 15-R00	T9335	■	■					0	0-0
		SNMX 15-R07	T9335	■	■					7	10-13
			6640	■	■					7	10-12
		SNMX 15-R09	T9335	■	■					9	12-16
			6640	■	■					9	12-16
		SNMX 15-R11	T9335	■	■					11	15-19
			6640	■	■					11	15-19
		SNMX 15-R13	T9335	■	■					13	18-23
			6640	■	■					13	18-23
		SNMX 15-R15	T9335	■	■					15	20-27
			6640	■	■					15	20-27
		SNMX 15-R18	T9335	■	■					18	24-32
			6640	■	■					18	24-32
		SNMX 15-R20	T9335	■	■					20	27-36
			6640	■	■					20	27-36
		SNMX 15-R22	T9335	■	■					22	30-39
			6640	■	■					22	30-39
		SNMX 15-R25	T9335	■	■					25	34-45
			6640	■	■					25	34-45
		SNMX 15-R27	T9335	■	■					27	37-48
			6640	■	■					27	37-48
		SNMX 15-R30	T9335	■	■					30	41-54
			6640	■	■					30	41-54
		SNMX 15-R35	T9335	■	■					35	48-63
			6640	■	■					35	48-63
		SNMX 15-R40	T9335	■	■					40	54-72
			6640	■	■					40	54-72
		SNMX 15-R45	T9335	■	■					45	61-81
			6640	■	■					45	61-81
		SNMX 15-R50	T9335	■	■					50	68-90
			6640	■	■					50	68-90
		SNMX 15-R60	T9335	■	■					60	89-112
			6640	■	■					60	89-112
		SNMX 15-R90	6640	■	■					90	133-169



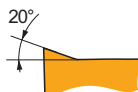
SNMX 19-R



	L	IC	D1	S
SNMX 19	19,050	19,050	7,95	8,15



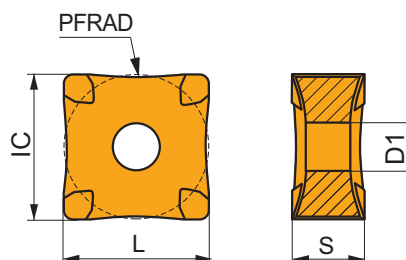
i	ISO	T9335	P	M	K	N	S	H	PFRAD	ODW
	SNMX 19-R00	T9335	■	■					0	0-0
	SNMX 19-R10	T9335	■	■					10	14-18
		6640	■	■					10	14-18
	SNMX 19-R12	T9335	■	■					12	16-21
		6640	■	■					12	16-21
	SNMX 19-R15	T9335	■	■					15	20-27
		6640	■	■					15	20-27
	SNMX 19-R18	T9335	■	■					18	24-32
	SNMX 19-R20	T9335	■	■					20	27-36
		6640	■	■					20	27-36
	SNMX 19-R22	T9335	■	■					22	30-39
	SNMX 19-R25	T9335	■	■					25	34-45
		6640	■	■					25	34-45
	SNMX 19-R30	T9335	■	■					30	41-54
		6640	■	■					30	41-54
	SNMX 19-R35	T9335	■	■					35	48-63
		6640	■	■					35	48-63
	SNMX 19-R40	T9335	■	■					40	54-72
		6640	■	■					40	54-72
	SNMX 19-R45	T9335	■	■					45	61-81
		6640	■	■					45	61-81
	SNMX 19-R50	T9335	■	■					50	68-90
		6640	■	■					50	68-90
	SNMX 19-R55	T9335	■	■					55	81-103
		6640	■	■					55	81-103
	SNMX 19-R60	T9335	■	■					60	89-112
		6640	■	■					60	89-112
	SNMX 19-R65	T9335	■	■					65	96-122
		6640	■	■					65	96-122
	SNMX 19-R75	T9335	■	■					75	111-141
	SNMX 19-R80	T9335	■	■					80	118-150
		6640	■	■					80	118-150
	SNMX 19-R85	T9335	■	■					85	126-159
	SNMX 19-R90	T9335	■	■					90	133-169
		6640	■	■					90	133-169



SNMX 25-R



	L	IC	D1	S
SNMX 25	25,400	25,400	9,12	12,20

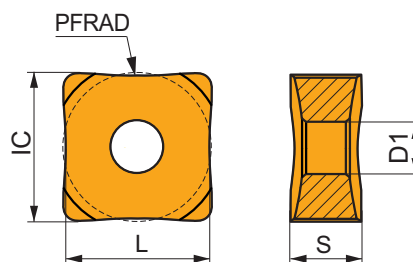


i	ISO	T9335	P	M	K	N	S	H	PFRAD	ODW
	SNMX 25-R00	T9335	■	■					0	0-0
	SNMX 25-R50	T9335	■	■					50	68-90
	SNMX 25-R80	T9335	■	■					80	118-150
	SNMX 25-R100	6640	■	■					80	118-150
		T9335	■	■					100	148-188
	SNMX 25-R120	6640	■	■					100	148-188
		T9335	■	■					120	178-225
	SNMX 25-R140	6640	■	■					120	178-225
		T9335	■	■					140	207-263
	SNMX 25-R160	6640	■	■					140	207-263
		T9335	■	■					160	237-300
	SNMX 25-R180	6640	■	■					160	237-300
T9335		■	■					180	266-338	
SNMX 25-R200	6640	■	■					180	266-338	
	T9335	■	■					200	296-376	
		6640	■	■				200	296-376	









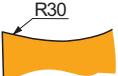
SNMX 1507-R



	L	IC	D1	S
1507	15,875	15,875	5,16	7,75



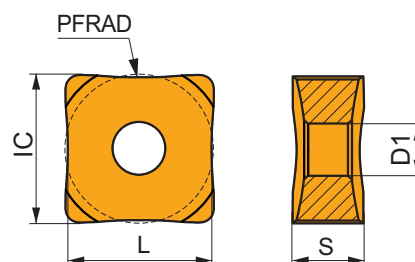
i	ISO	6640	P	M	K	N	S	H	PFRAD	ODW
	SNMX 150708-R09	6640	■	■					9	13-16
	SNMX 150708-R11	6640	■	■					11	16-19
	SNMX 150708-R13	6640	■	■					13	19-23
	SNMX 150708-R15	6640	■	■					15	22-27
	SNMX 150708-R18	6640	■	■					18	26-32
	SNMX 150708-R20	6640	■	■					20	29-36
	SNMX 150708-R22	6640	■	■					22	32-39
	SNMX 150708-R25	6640	■	■					25	37-45
	SNMX 150708-R27	6640	■	■					27	39-48
	SNMX 150708-R30	6640	■	■					30	44-54
	SNMX 150708-R35	6640	■	■					35	51-63
	SNMX 150708-R40	6640	■	■					40	58-72
	SNMX 150708-R42	6640	■	■					42	61-75
	SNMX 150708-R45	6640	■	■					45	66-81










		ISO		P	M	K	N	S	H	PFRAD	
   		SNMX 150708-R50	6640	■	■					50	73-93
		SNMX 150708-R60	6640	■	■					60	88-111
		SNMX 150708-R65	6640	■	■					65	95-120
		SNMX 150708-R70	6640	■	■					70	102-130
		SNMX 150708-R75	6640	■	■					75	110-139
		SNMX 150708-R80	6640	■	■					80	117-148
		SNMX 150708-R90	6640	■	■					90	131-167
		SNMX 150708-R100	6640	■	■					100	146-186
SNMX 150708-R105	6640	■	■					105	153-195		

SNMX 2512-R



	L	IC	D1	S
2512	25,400	25,400	9,17	12,00

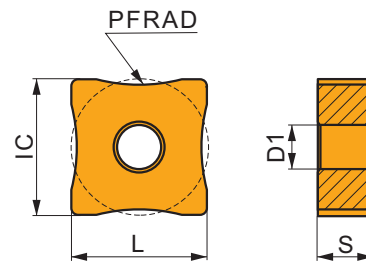


		ISO		P	M	K	N	S	H	PFRAD	
   		SNMX 251224-R00	T9335	■	■					0	0-0
		SNMX 251224-R25	T9335	■	■					25	34-45
		SNMX 251224-R30	T9335	■	■					30	41-54
		SNMX 251224-R35	T9335	■	■					35	48-63
		SNMX 251224-R40	T9335	■	■					40	54-72
		SNMX 251224-R55	T9335	■	■					55	81-103
		SNMX 251224-R80	T9335	■	■					80	118-150
		SNMX 251224-R100	T9335	■	■					100	148-188
SNMX 251224-R120	T9335	■	■					120	178-225		

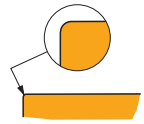
SNMA 1506-R

PRAMET

	L	IC	D1	S
1506	15,875	15,875	5,16	6,35



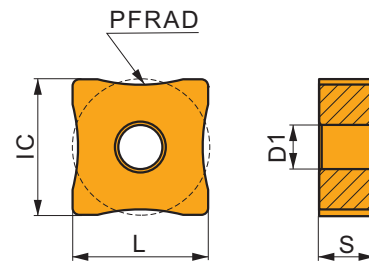
i	ISO	6640	Material Groups						PFRAD	ODV
			P	M	K	N	S	H		
	SNMA 150608-R09	6640	■	■				9	13-16	
	SNMA 150608-R11	6640	■	■				11	16-20	
	SNMA 150608-R13	6640	■	■				13	19-24	
	SNMA 150608-R15	6640	■	■				15	22-28	
	SNMA 150608-R18	6640	■	■				18	27-33	
	SNMA 150608-R20	6640	■	■				20	30-37	
	SNMA 150608-R22	6640	■	■				22	33-41	
	SNMA 150608-R25	6640	■	■				25	37-47	
	SNMA 150608-R27	6640	■	■				27	40-50	
	SNMA 150608-R30	6640	■	■				30	44-56	
	SNMA 150608-R35	6640	■	■				35	52-65	
	SNMA 150608-R40	6640	■	■				40	59-75	
	SNMA 150608-R42	6640	■	■				42	62-78	
	SNMA 150608-R45	6640	■	■				45	67-84	
	SNMA 150608-R50	6640	■	■				50	74-94	
	SNMA 150608-R60	6640	■	■				60	89-112	
	SNMA 150608-R65	6640	■	■				65	96-122	
	SNMA 150608-R70	6640	■	■				70	104-131	
	SNMA 150608-R75	6640	■	■				75	111-141	
	SNMA 150608-R80	6640	■	■				80	118-150	
	SNMA 150608-R90	6640	■	■				90	133-169	
	SNMA 150608-R105	6640	■	■				105	155-197	
	SNMA 150608-R120	6640	■	■				120	178-225	



SNMA 2509-R



	L	IC	D1	S
2509	25,400	25,400	9,12	9,52

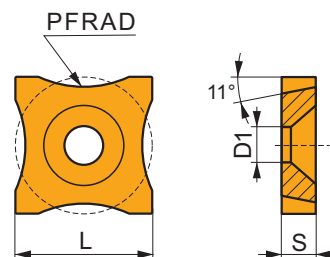


i	ISO	T9335	P	M	K	N	S	H	PFRAD	ODW
U E	SNMA 250924-R00	T9335	■	■					0	0-0
	SNMA 250924-R60	T9335	■	■					60	89-112

SPUB 19-R



	L	IC	D1	S
SPUB 19	19,050	19,050	5,15	4,75



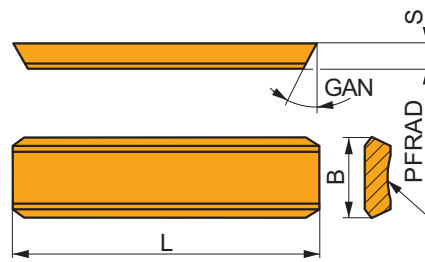
i	ISO	ANSI	T9335	P	M	K	N	S	H	PFRAD	ODW
U E	SPUB 19-R00 *	SPUB-63-M	T9335	■	■					0	0-0
			6640	■	■					0	0-0
	SPUB 19-R12	SPUB-63-B	T9335	■	■					12	18-22
			6640	■	■					12	18-22
	SPUB 19-R15	SPUB-63-C	T9335	■	■					15	22-28
			6640	■	■					15	22-28
	SPUB 19-R20	SPUB-63-D	T9335	■	■					20	29-37
			6640	■	■					20	29-37
	SPUB 19-R25	SPUB-63-E	T9335	■	■					25	37-47
			6640	■	■					25	37-47
	SPUB 19-R30	SPUB-63-F	T9335	■	■					30	45-57
			6640	■	■					30	45-57
	SPUB 19-R40	SPUB-63-G	T9335	■	■					40	60-76
			6640	■	■					40	60-76
	SPUB 19-R50	SPUB-63-H	T9335	■	■					50	75-95
			6640	■	■					50	75-95
SPUB 19-R63	SPUB-63-I	T9335	■	■					63	95-120	
		6640	■	■					63	95-120	

* This insert has 11° positive clearance all around.

LDGN

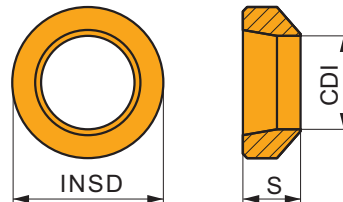


	L	S	B	GAN
13,05	60,00	5,00	15,00	30°










		ISO		P	M	K	N	S	H	PFRAD	
 		LDGN 130560-R25	6640	■	■					25	34-45
		LDGN 130560-R30	6640	■	■					30	41-54
		LDGN 130560-R35	6640	■	■					35	48-63
		LDGN 130560-R40	6640	■	■					40	54-72
		LDGN 130560-R45	6640	■	■					45	61-81

PSR



	ISO		P	M	K	N	S	H	INSD	CDI	S	PFRAD	
	PSR0-R3.5	T9335	■	■					6,0	3,0	3,5	3,4	12-13,5
	PSR0-R4	T9335	■	■					6,0	3,5	3,5	4,0	12-14
	PSR0-R4.5	T9335	■	■					8,0	4,0	4,0	4,6	13,5-19
		5040	■	■					8,0	4,0	4,0	4,6	13,5-19
		S45	■	■					8,0	4,0	4,0	4,6	13,5-19
	PSR0/10-R4.5*	T9335	■	■					10,0	4,0	4,0	4,6	13,5-19
	PSR0-R5.5	T9335	■	■					8,0	5,0	4,0	5,7	16-20
		5040	■	■					8,0	5,0	4,0	5,7	16-20
	PSR0/10-R5.5*	T9335	■	■					10,0	5,0	4,0	5,7	16-20
	PSR0-R6	T9335	■	■					10,0	5,5	4,5	6,3	17-20
		5040	■	■	▣				10,0	5,5	4,5	6,3	17-20
	PSR0-R6.5	T9335	■	■					10,0	6,0	4,5	6,8	17-21
		5040	■	■					10,0	6,0	4,5	6,8	17-21
		S45	■	■					10,0	6,0	4,5	6,8	17-21
	PSR0-5-R6.5*	T9335	■	■					10,0	6,0	5,0	6,8	17-22
PSR0-R7	T9335	■	■					10,0	6,5	4,5	7,4	17-22	
	S45	■	■					10,0	6,5	4,5	7,4	20-22	

i	ISO								INSD	CDI	S	PFRAD	
			P	M	K	N	S	H					
	PSR1-R7	T9335	■	■				13,0	6,0	5,0	6,8	20-22	
		5040	■	■				13,0	6,0	5,0	6,8	20-22	
		S45	■	■				13,0	6,0	5,0	6,8	20-22	
	PSR1-R7.5	T9335	■	■				13,0	6,8	5,0	7,8	21-23	
		PSR1-R8	T9335	■	■				13,0	7,0	5,0	8,0	22-24
			5040	■	■				13,0	7,0	5,0	8,0	22-24
	PSR1-R9	S45	■	■				13,0	7,0	5,0	8,0	22-24	
		T9335	■	■				13,0	8,0	5,0	9,1	24-26	
		5040	■	■				13,0	8,0	5,0	9,1	25-28	
PSR1-R10	S45	■	■				13,0	8,0	5,0	9,1	25-28		
	T9335	■	■				13,0	9,0	5,0	10,2	25-28		
	5040	■	■				13,0	9,0	5,0	10,2	25-28		
	PSR2-R9	S45	■	■				13,0	9,0	5,0	10,2	25-28	
		PSR2-R10	T9335	■	■				19,0	8,0	8,0	9,1	24-26
		5040	■	■				19,0	9,0	8,0	10,2	26-28	
	PSR2-R11	S45	■	■				19,0	9,0	8,0	10,2	26-28	
		T9335	■	■				19,0	10,0	8,0	11,4	28-30	
		5040	■	■				19,0	10,0	8,0	11,4	28-30	
	PSR2-R12	S45	■	■				19,0	10,0	8,0	11,4	28-30	
		T9335	■	■				19,0	11,0	8,0	12,5	30-34	
		5040	■	■				19,0	11,0	8,0	12,5	30-34	
PSR2-R13	S45	■	■				19,0	11,0	8,0	12,5	30-34		
	PSR2-R14	T9335	■	■				19,0	11,9	8,0	13,5	31-35	
	5040	■	■				19,0	12,5	8,0	14,3	32-41		
	PSR3-R12	S45	■	■				22,0	9,0	8,0	10,2	26-28	
		PSR3-R14	T9335	■	■				22,0	12,0	10,0	13,7	32-41
		5040	■	■				22,0	12,0	10,0	13,7	32-41	
	PSR3-R17	S45	■	■				22,0	12,0	10,0	13,7	32-41	
		T9335	■	■				22,0	15,0	10,0	17,1	36-41	
		5040	■	■				22,0	15,0	10,0	17,1	36-41	
	PSR4-R20	S45	■	■				22,0	15,0	10,0	17,1	36-41	
		PSR4-R23	T9335	■	■				30,0	17,0	12,0	19,4	41-50
		5040	■	■				30,0	20,0	12,0	22,8	48-57	
	PSR5-R25	S45	■	■				30,0	20,0	12,0	22,8	48-57	
		T9335	■	■				35,0	22,0	12,0	25,1	70-85	
		5040	■	■				35,0	22,0	12,0	25,1	70-85	
	PSR5-R28	S45	■	■				35,0	22,0	12,0	25,1	70-85	
		T9335	■	■				35,0	25,0	12,0	28,5	85-100	
		5040	■	■				35,0	25,0	12,0	28,5	85-100	
	PSR6-R34	S45	■	■				35,0	25,0	12,0	28,5	85-100	
		T9335	■	■				45,0	30,0	15,0	34,2	100-130	
		5040	■	■				45,0	30,0	15,0	34,2	100-130	
PSR7-R39	S45	■	■				45,0	30,0	15,0	34,2	100-130		
	T9335	■	■				50,0	35,0	15,0	39,5	125-140		
	5040	■	■				50,0	35,0	15,0	39,5	125-140		
PSR8-R46	T9335	■	■				55,0	40,0	18,0	45,6	140-180		
	5040	■	■				55,0	40,0	18,0	45,6	140-180		

* rings deviating from standard dimension

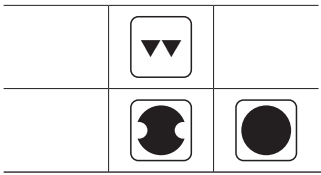
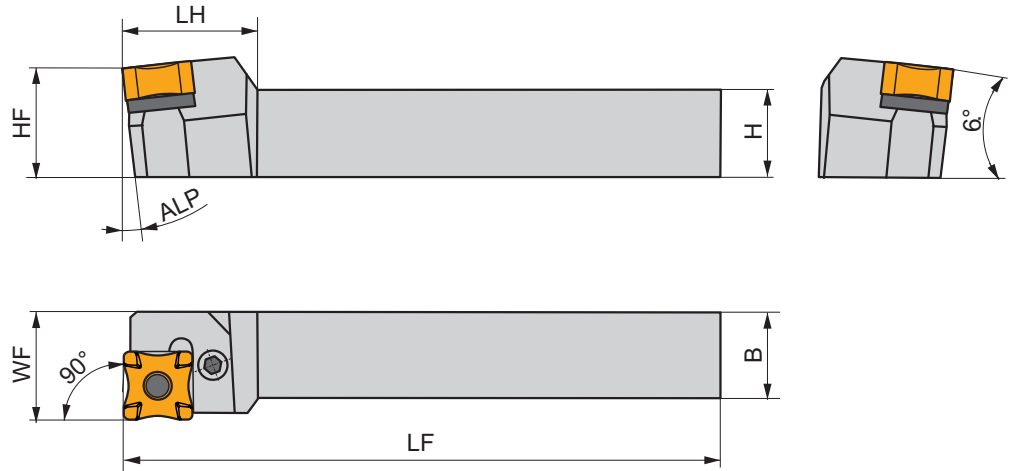
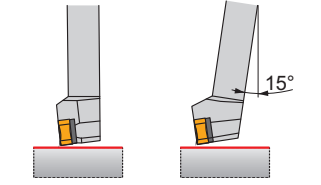
* INSD, S - modification

PXFN(RL)



PRAMET

P



	H	B	HF	WF	LF	LH	ALP	kg			
	[mm]	[mm]		[mm]	[mm]	[mm]	[°]				
PXFNR/L 2525 R 15	25	25	25	25	200	40	6	1,05	G185	PX 40	AT009
PXFNR/L 2525 S 19	25	25	25	25	250	45	6	1,3	G186	PX 50	-
PXFNR/L 3232 S 25	32	32	40	40	250	50	6	2,2	G199	PX 60	AT010
PXFNR/L 2525 R 15/15	25	25	25	25	200	40	20	1,05	G185	PX 40	AT009
PXFNR/L 2525 S 19/15	25	25	25	25	250	50	20	1,3	G186	PX 50	-

G185	SNMX 15-R..
G186	SNMX 19-R..
G199	SNMX 25-R..

PX40	SNU 150310-R	PU 03	US 36	6,0	M8x1	26	NT 05	MT 07	HXK 4
PX50	SNU 190410-R	PU 05	US 38	8,0	M10x1	29	NT 06	MT 06	HXK 5
PX60	SNU 250424-R	PU 06	US 47	8,0	M12x1	36	NT 08	MT 08	HXK 5

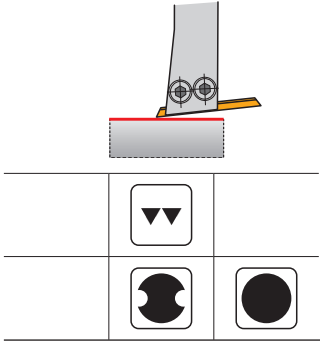
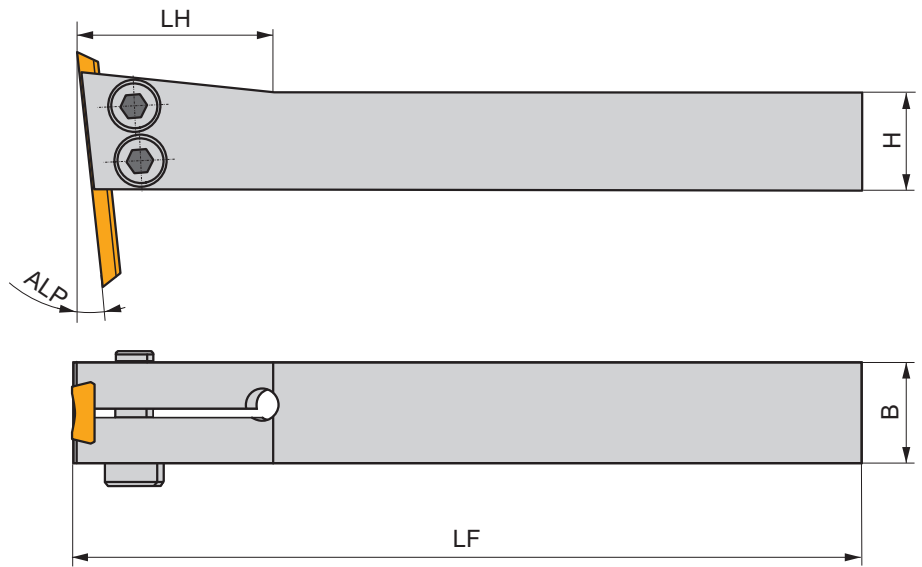
AT009	SNMX 150708-R..	SNU 150410-CX
AT010	SNMX 251224-R..	SNU 250524-CX

XLCDN

P M

P

PRAMET



	H	B	LF	LH	ALP	kg	G1187	PX10
	[mm]	[mm]	[mm]	[mm]	[°]			
XLCDN 2525 R 15	25	25	200	50	6	1,10	G1187	PX10

G1187	LDGN 130560...							
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PX10	HS 0825	M8	25	HXK 6			
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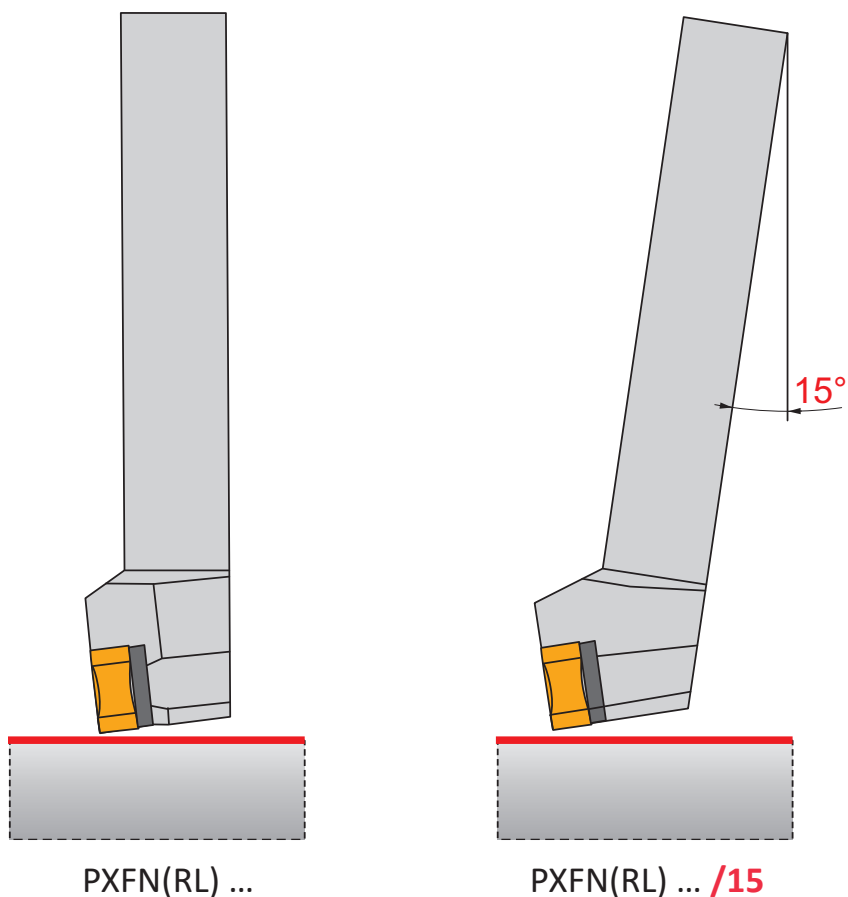
TECHNICAL INFORMATION

GRADES FOR SCARFING

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Substrate	Coating	Colour	Coolant benefit	General purpose	High speed tube mills	Low speed tube mills
T9335	P20 - P45	■				FGM	MT-CVD		+++	✓	✓	
	M15 - M40	■										
6640	P20 - P45	■				H	MT-CVD		+++	✓		✓
	M15 - M40	■										
5040	P30 - P45	■				S	MT-CVD		++	✓		✓
	M30 - M40	□										
S45	P30 - P45	■				S	X		++			✓
	M30 - M40	□										

Substrate		Coating	
H	WC-Co based substrate	MT-CVD	Medium-temperature chemical method of coating
FGM	Functionally graded substrate	X	Uncoated grade
S	Substrate with cubic carbides		

PXFN(RL) - VARIOUS HOLDERS ACCORDING TO HEAD INCLINATION



LDGN – INSERTS SUITABLE FOR REGRINDING

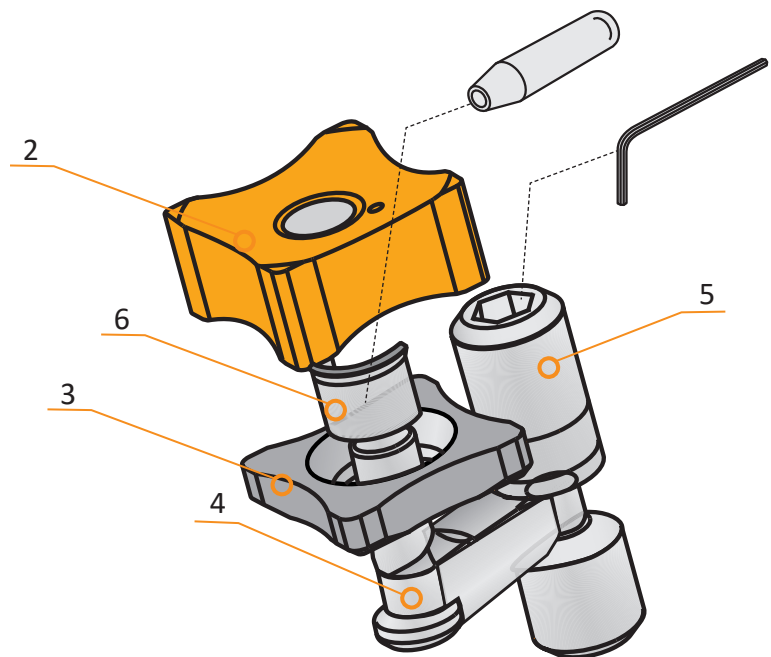





























Offers long tool life due to total length of insert (60mm), which can be ground several times to a minimum length of 25mm.

Rake angle GAN can be easily modified (more or less positive) by grinding the insert to optimize the scarfing process.

Suitable for small cross section of scarf.

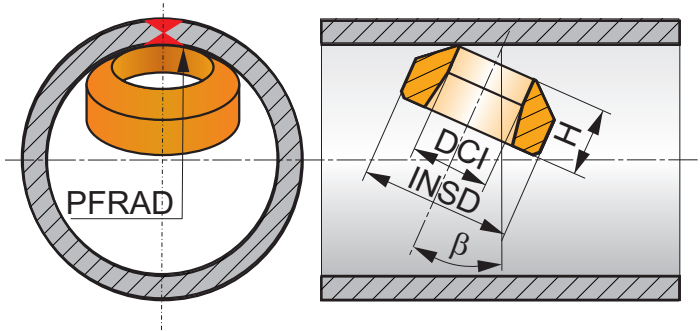
PXFN(RL) - VARIOUS SPARE PARTS ACCORDING TO INSERT SHAPE



1	2	3	4	5	6	7	8
PXFNR/L 2525 R 15 PXFNRL 2525 R 15/15	 SNMX 15-Rxx	 SNU 150310-R					
	 SNMX 150708-Rxx	 SNU 150410-CX	PU 03	US 36	NT 07	MT 07	HXK 4
PXFNRL 2525 S 19 PXFNRL 2525 S 19/15	 SNMX 19-Rxx	 SNU 190410-R					
	 SNMX 19-Rxx	 SNU 250424-R	PU 05	US 38	NT 06	MT 06	HXK 5
PXFNRL 3232 S 25	 SNMX 25-Rxx	 SNU 250424-R					
	 SNMX 251224-Rxx	 SNU 250524-CX	PU 06	US 47	NT 08	MT 08	HXK 5

SCARFING RINGS - HOW TO CALCULATE WORKING RADIUS PFRAD

Working radius PFRAD circle of osculatory DCI



$$\text{PFRAD} = \frac{\text{DCI}}{2 \times \sin \beta}$$

DCI - internal rings diameter

β - angle of ring rotation

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**.

Argentina

T: 54 (11) 6777-6777
F: 54 (11) 4441-4467
info.ar@dormerpramet.com

Austria

T: +31 10 2080 240
info.at@dormerpramet.com

Belgium & Luxembourg

T: +32 3 440 59 01
info.be@dormerpramet.com

Brazil

T: +55 11 5660 3000
info.br@dormerpramet.com

Canada

T: (888) 336 7637
En Français: (888) 368 8457
F: (905) 542 7000
cs.canada@dormerpramet.com

China

T: +86 21 2416 0508
info.cn@dormerpramet.com

Croatia

T: +385 98 407 489
info.hr@dormerpramet.com

Czech Republic

T: +420 583 381 111
F: +420 583 215 401
info.cz@dormerpramet.com

Denmark

T: 808 82106
info.se@dormerpramet.com

Finland

T: 0205 44 7003
info.fi@dormerpramet.com

France

T: +33 (0)2 47 62 57 01
F: +33 (0)2 47 62 52 00
info.fr@dormerpramet.com

Germany

T: +49 9131 933 08 70
F: +49 9131 933 08 742
info.de@dormerpramet.com

Hungary

T: +36-96 / 522-846
F: +36-96 / 522-847
info.hu@dormerpramet.com

India

T: +91 11 4601 5686
info.in@dormerpramet.com

Italy

T: +39 02 30 70 54 44
info.it@dormerpramet.com

Kazakhstan

T: +7 771 305 11 45
info.kz@dormerpramet.com

Mexico

T: +52 (555) 7293981
F: +52 (555) 7293981
cs.mexico@dormerpramet.com

Netherlands

T: +31 10 2080 240
info.nl@dormerpramet.com

Norway

T: 800 10 113
info.se@dormerpramet.com

Poland

T: +48 32 78-15-890
F: +48 32 78-60-406
info.pl@dormerpramet.com

Portugal

T: +351 21 424 54 21
info.pt@dormerpramet.com

Romania

T: +4(0)730 015 885
info.ro@dormerpramet.com

Russia

T: +7 (495) 775 10 28
Ф: +7 (499) 763 38 90
info.ru@dormerpramet.com

Slovakia

T: +421 (41) 764 54 60
F: +421 (41) 763 74 49
info.sk@dormerpramet.com

Slovenia

T: +385 98 407 489
info.si@dormerpramet.com

Spain

T: +34 935717722
info.es@dormerpramet.com

Sweden

responsible for Iceland
T: +46 35 16 52 96
info.se@dormerpramet.com

Switzerland

T: +31 10 2080 240
info.ch@dormerpramet.com

Turkey

T: +90 533 212 45 47
info.tr@dormerpramet.com

Ukraine

T: +38 056 736 30 21
F: +38 067 220 97 48
info.ua@dormerpramet.com

United Kingdom

responsible for Ireland
T: 0870 850 4466
F: 0870 850 8866
info.uk@dormerpramet.com

United States of America

T: (800) 877-3745
F: (847) 783-5760
cs@dormerpramet.com

Other countries

South America

T: +55 11 5660 3000
info.br@dormerpramet.com

Adria

T: +420 583 381 527
F: +420 583 381 401
info.rcee@dormerpramet.com

Rest of the World

Dormer Pramet International UK
T: +44 1246 571338
F: +44 1246 571339
info.int@dormerpramet.com

Dormer Pramet International CZ

T: +420 583 381 520
F: +420 583 215 401
info.int.cz@dormerpramet.com



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