DORMER PRAMET

SCARFING

2020

PRAMET

CONTENTS

FEATURES AND BENEFITS 4

NAVIGATOR 9

INSERTS 10

CUTTING RINGS 16

HOLDERS 18

TECHNICAL INFORMATION 21

SCARFING

TOOLS FOR EXTERNAL AND INTERNAL TUBE WELD SCARFING

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

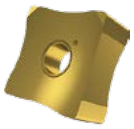
- Inserts for removal of weld bed from outside of tube diameter in a wide range of geometries and radii
- Rings for internal diameter scarfing in a wide range of sizes and grades
- Toolholders for external scarfing

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

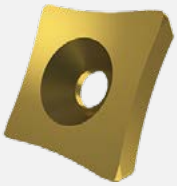
SNMA 1506, 2509

SPUB

LDGN

PSR

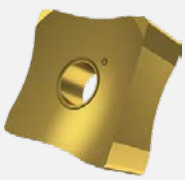
NEW ITEMS



NEW

SPUB 19

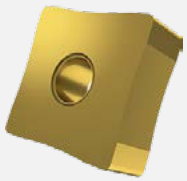
- Positive single-sided inserts with 11° clearance angle
- Four cutting edges



NEW

SNMX 1507

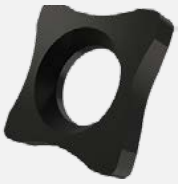
- Negative, double sided inserts
- Eight cutting edges and concave top



NEW

SNMA 1506

- Negative, double sided inserts
- Eight cutting edges and flat top



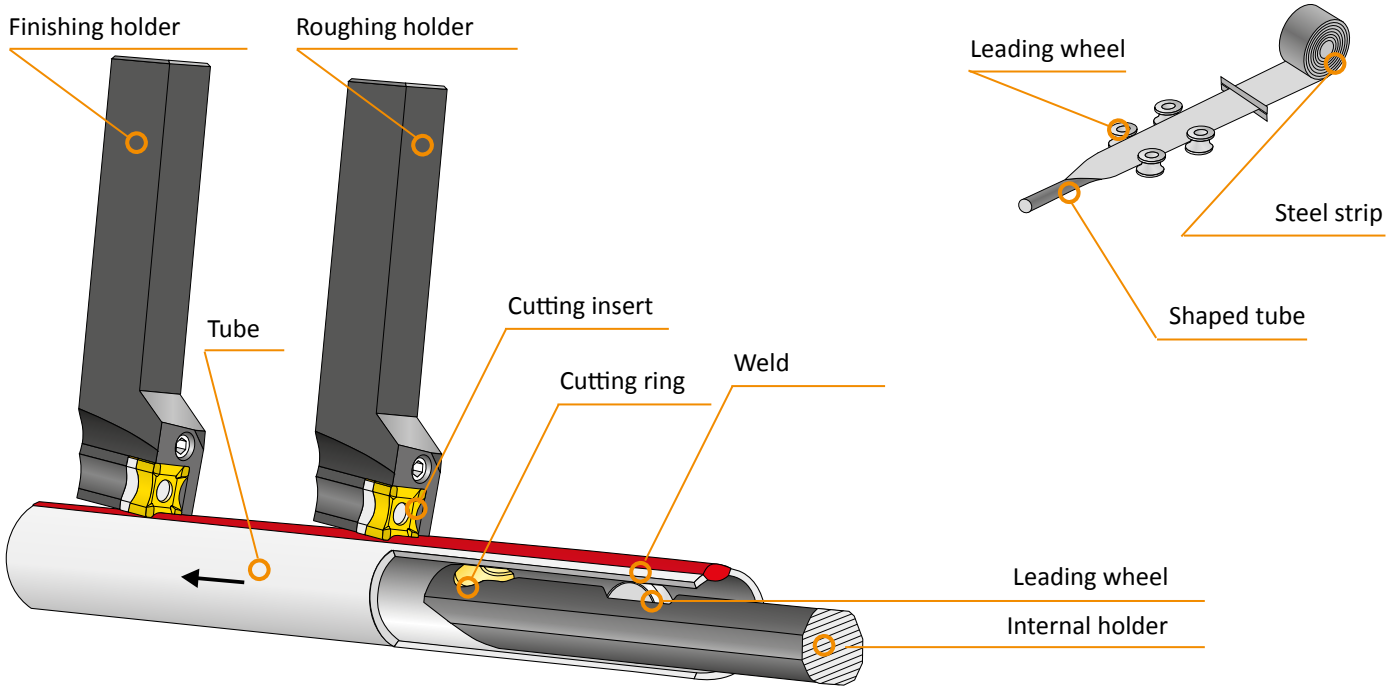
NEW

SNU

- Shims allow clamping of inserts SNMX 2512 and SNMX 1507, with concave top, into our current holders.

SCARFING

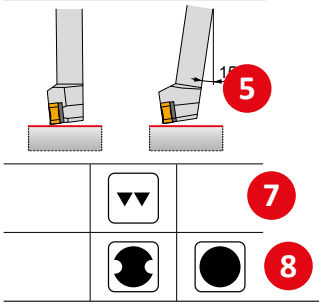
TOOLS FOR EXTERNAL AND INTERNAL TUBE WELD SCARFING

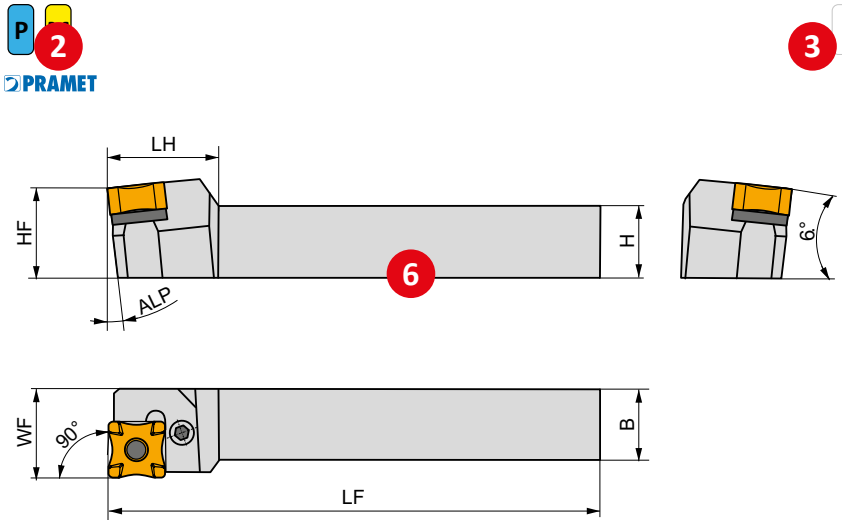


WHAT INSERT SHOULD I USE FOR MY TUBE DIAMETER ?

PAGE OVERVIEW

1 PXFN(RL)





	H [in]	B [in]	HF [in]	WF [in]	LF [in]	LH [in]	ALP [°]	lbs			
PXFNR/L 2525 [illegible]	.984	.984	.984	[illegible]	7.874	1.575	6	[illegible]	[illegible]	[illegible]	[illegible]
PXFNR/L 252[illegible]	.984	.984	.984	[illegible]	9.843	1.772	6	[illegible]	[illegible]	[illegible]	[illegible]
PXFNR/L 3232 S 25	1.260	1.260	1.575	1.575	9.843	1.969	6	4.850	GI199	PX 60	AT010

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

				Nm					
PX40	SNU 150310-R	PU 03	US 36	6,0	M8x1	1.024	NT 05	MT 07	HKX 4
PX50	SNU 190410-R	PU 05	US 38	8,0	M10x1	1.142	NT 06	MT 06	HXK 5
PX60	SNU 250424-R	PU 06	US 47	8,0	M12x1	1.299	NT 08	MT 08	HXK 5

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

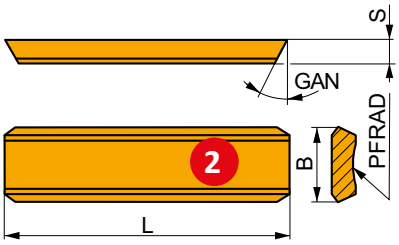
1	Designation of tool holder type	7	Achievable surface quality	13	Group of compatible inserts [2]
2	Material group recommendations	8	Character of cut/working conditions	14	Group of spare parts [2), 3)]
3	Clamping system of insert	9	Possible applications	15	Group of accessories [2), 3)]
4	Illustrative 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.

PAGE OVERVIEW

1 LDGN				
	L	3 S	B	GAN
13,05	2.362	.197	.591	30°

PRAMET



i		ISO		P	M	K	N	S	H	PFRAD	ODW
		LDGN 130560-R25	6640	■	■					.985	1.340-1.770
		LDGN 130560-R30	6640	■	■					1.180	1.615-2.125
		LDGN 130560-R35	6640	■	■					1.380	1.890-2.480
		LDGN 130560-R40	6640	■	■					1.575	2.125-2.835
4	5	LDGN 6 0-R45	7	■	■	8				9	2 .190 10

1	Designation of insert type (group)
2	Schematic drawing of insert
3	Table with insert sizes [mm]
4	Icons - specific features, cutting edge type and picture of representative insert
5	Profile of main cutting edge

6	ISO code of insert
7	Grade
8	Application area of insert
9	Radius
10	Tube diameter

ICONS AND SYMBOLS

Priority use

Possible use

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

Icons - scarfing holders

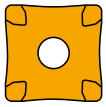
General features of tools	
P M K N S H / P M K N H S	Material groups
▼▼ ▼▼	Medium machining – good surface quality
	Unstable working conditions
	Very unstable working conditions
	External scarfing
	Internal scarfing

Icons and symbols - inserts

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

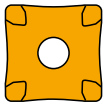
NAVIGATOR - ISO INSERTS

SNMX 15-R



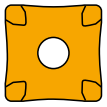
10

SNMX 19-R



11

SNMX 25-R



12

SNMX 1507-R

12

SNMX 2512-R

13

SNMA 1506-R

14

SNMA 2509-R

15

SPUB 19-R

15

LDGN

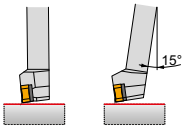
16

PSR

16 -17

NAVIGATOR - TOOLS

PFXN(RL) EXT

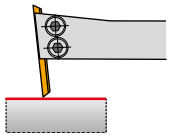


SN..
15 19 25

■	25x25 --- 32x32

18 10-15

XLCD(N) EXT



LDGN
13

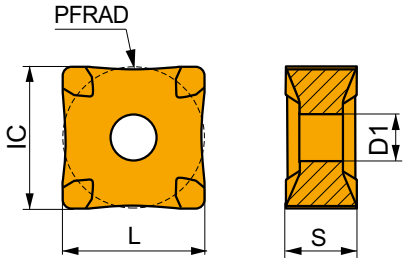
■	25x25

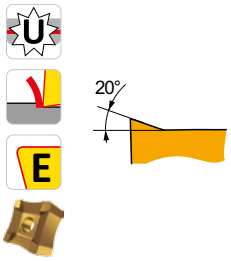
19 16

SNMX 15-R

PRAMET

	L	IC	D1	S
SNMX 15	.625	.625	.203	.321



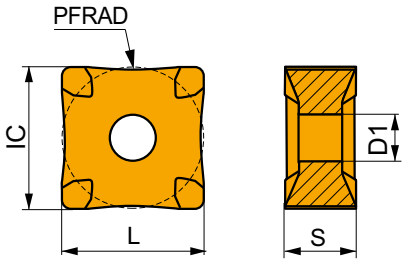


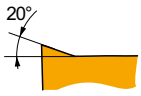
ISO		P	M	K	N	S	H	PFRAD	ODW
SNMX 15-R00	**T9335**	■	■					0	0-0
SNMX 15-R07	**T9335**	■	■					.275	.395-.510
	6640	■	■					.275	.395-.470
SNMX 15-R09	**T9335**	■	■					.355	.470-.630
	6640	■	■					.355	.470-.630
SNMX 15-R11	**T9335**	■	■					.435	.590-.750
	6640	■	■					.435	.590-.750
SNMX 15-R13	**T9335**	■	■					.510	.710-.905
	6640	■	■					.510	.710-.905
SNMX 15-R15	**T9335**	■	■					.590	.785-1.065
	6640	■	■					.590	.785-1.065
SNMX 15-R18	**T9335**	■	■					.710	.945-1.260
	6640	■	■					.710	.945-1.260
SNMX 15-R20	**T9335**	■	■					.785	1.065-1.415
	6640	■	■					.785	1.065-1.415
SNMX 15-R22	**T9335**	■	■					.865	1.180-1.535
	6640	■	■					.865	1.180-1.535
SNMX 15-R25	**T9335**	■	■					.985	1.340-1.770
	6640	■	■					.985	1.340-1.770
SNMX 15-R27	**T9335**	■	■					1.065	1.455-1.890
	6640	■	■					1.065	1.455-1.890
SNMX 15-R30	**T9335**	■	■					1.180	1.615-2.125
	6640	■	■					1.180	1.615-2.125
SNMX 15-R35	**T9335**	■	■					1.380	1.890-2.480
	6640	■	■					1.380	1.890-2.480
SNMX 15-R40	**T9335**	■	■					1.575	2.125-2.835
	6640	■	■					1.575	2.125-2.835
SNMX 15-R45	**T9335**	■	■					1.770	2.400-3.190
	6640	■	■					1.770	2.400-3.190
SNMX 15-R50	**T9335**	■	■					1.970	2.675-3.545
	6640	■	■					1.970	2.675-3.545
SNMX 15-R60	**T9335**	■	■					2.360	3.505-4.410
	6640	■	■					2.360	3.505-4.410
SNMX 15-R90	**6640**	■	■					3.545	5.235-6.655

SNMX 19-R

PRAMET

	L	IC	D1	S
SNMX 19	.750	.750	.313	.321



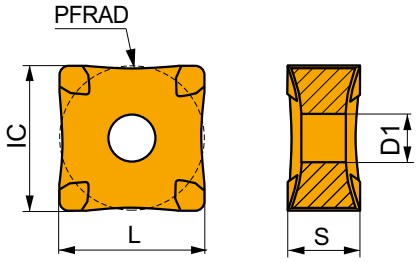


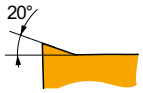
ISO		P	M	K	N	S	H	PFRAD	ODW
SNMX 19-R00	**T9335**	■	■					0	0-0
SNMX 19-R10	**T9335**	■	■					.395	.550-.710
	6640	■	■					.395	.550-.710
SNMX 19-R12	**T9335**	■	■					.470	.630-.825
	6640	■	■					.470	.630-.825
SNMX 19-R15	**T9335**	■	■					.590	.785-1.065
	6640	■	■					.590	.785-1.065
SNMX 19-R18	**T9335**	■	■					.710	.945-1.260
SNMX 19-R20	**T9335**	■	■					.785	1.065-1.415
	6640	■	■					.785	1.065-1.415
SNMX 19-R22	**T9335**	■	■					.865	1.180-1.535
SNMX 19-R25	**T9335**	■	■					.985	1.340-1.770
	6640	■	■					.985	1.340-1.770
SNMX 19-R30	**T9335**	■	■					1.180	1.615-2.125
	6640	■	■					1.180	1.615-2.125
SNMX 19-R35	**T9335**	■	■					1.380	1.890-2.480
	6640	■	■					1.380	1.890-2.480
SNMX 19-R40	**T9335**	■	■					1.575	2.125-2.835
	6640	■	■					1.575	2.125-2.835
SNMX 19-R45	**T9335**	■	■					1.770	2.400-3.190
	6640	■	■					1.770	2.400-3.190
SNMX 19-R50	**T9335**	■	■					1.970	2.675-3.545
	6640	■	■					1.970	2.675-3.545
SNMX 19-R55	**T9335**	■	■					2.165	3.190-4.055
	6640	■	■					2.165	3.190-4.055
SNMX 19-R60	**T9335**	■	■					2.360	3.505-4.410
	6640	■	■					2.360	3.505-4.410
SNMX 19-R65	**T9335**	■	■					2.560	3.780-4.805
	6640	■	■					2.560	3.780-4.805
SNMX 19-R75	**T9335**	■	■					2.955	4.370-5.550
SNMX 19-R80	**T9335**	■	■					3.150	4.645-5.905
	6640	■	■					3.150	4.645-5.905
SNMX 19-R85	**T9335**	■	■					3.345	4.960-6.260
SNMX 19-R90	**T9335**	■	■					3.545	5.235-6.655
	6640	■	■					3.545	5.235-6.655

SNMX 25-R

PRAMET

	L	IC	D1	S
SNMX 25	1.000	1.000	.359	.480



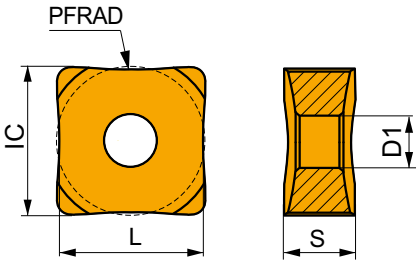


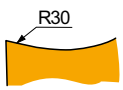
ISO		P	M	K	N	S	H	PFRAD	ODW
SNMX 25-R00	T9335	■	■					0	0-0
SNMX 25-R50	T9335	■	■					1.970	2.625-3.500
SNMX 25-R80	T9335	■	■					3.150	2.625-3.501
	6640	■	■					3.150	2.625-3.502
SNMX 25-R100	T9335	■	■					3.935	2.625-3.503
	6640	■	■					3.935	2.625-3.504
SNMX 25-R120	T9335	■	■					4.725	2.625-3.505
	6640	■	■					4.725	2.625-3.506
SNMX 25-R140	T9335	■	■					5.510	2.625-3.507
	6640	■	■					5.510	2.625-3.508
SNMX 25-R160	T9335	■	■					6.300	2.625-3.509
	6640	■	■					6.300	2.625-3.510
SNMX 25-R180	T9335	■	■					7.085	2.625-3.511
SNMX 25-R200	T9335	■	■					7.875	2.625-3.512
	6640	■	■					7.875	2.625-3.513

SNMX 1507-R

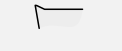
PRAMET

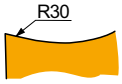
	L	IC	D1	S
1507	.625	.625	.203	.305





ISO		P	M	K	N	S	H	PFRAD	ODW
SNMX 150708-R09	6640	■	■					.355	.510-.630
SNMX 150708-R11	6640	■	■					.435	.630-.750
SNMX 150708-R13	6640	■	■					.510	.750-.905
SNMX 150708-R15	6640	■	■					.590	.865-1.065
SNMX 150708-R18	6640	■	■					.710	1.025-1.260
SNMX 150708-R20	6640	■	■					.785	1.140-1.415
SNMX 150708-R22	6640	■	■					.865	1.260-1.535
SNMX 150708-R25	6640	■	■					.985	1.455-1.770
SNMX 150708-R27	6640	■	■					1.065	1.535-1.890
SNMX 150708-R30	6640	■	■					1.180	1.730-2.125



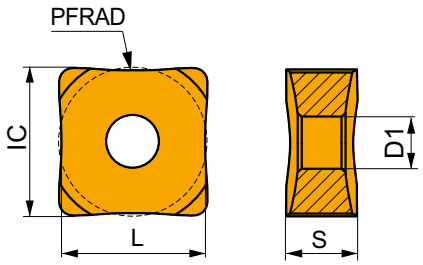


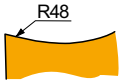
ISO		P	M	K	N	S	H	PFRAD	ODW
SNMX 150708-R35	6640	■	■					1.380	2.010-2.480
SNMX 150708-R40	6640	■	■					1.575	2.285-2.835
SNMX 150708-R42	6640	■	■					1.655	2.400-2.955
SNMX 150708-R45	6640	■	■					1.770	2.600-3.190
SNMX 150708-R50	6640	■	■					1.970	2.875-3.660
SNMX 150708-R60	6640	■	■					2.360	3.465-4.370
SNMX 150708-R65	6640	■	■					2.560	3.740-4.725
SNMX 150708-R70	6640	■	■					2.755	4.015-5.120
SNMX 150708-R75	6640	■	■					2.955	4.330-5.470
SNMX 150708-R80	6640	■	■					3.150	4.605-5.825
SNMX 150708-R90	6640	■	■					3.545	5.155-6.575
SNMX 150708-R100	6640	■	■					3.935	5.750-7.325
SNMX 150708-R105	6640	■	■					4.135	6.025-7.675

SNMX 2512-R

PRAMET

	L	IC	D1	S
2512	1.000	1.000	.361	.472



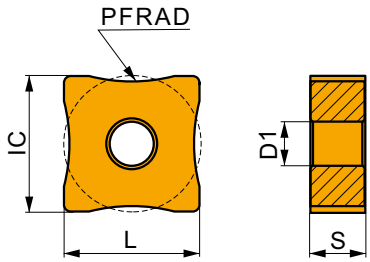


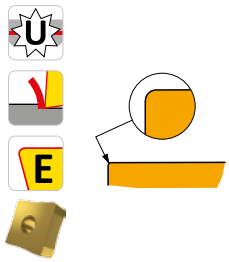
ISO		P	M	K	N	S	H	PFRAD	ODW
SNMX 251224-R00	T9335	■	■					0	0-0
SNMX 251224-R25	T9335	■	■					1.970	1.375-1.750
SNMX 251224-R30	T9335	■	■					3.150	1.625-2.125
SNMX 251224-R35	T9335	■	■					3.150	1.875-2.500
SNMX 251224-R40	T9335	■	■					3.935	2.125-2.875
SNMX 251224-R55	T9335	■	■					3.935	3.250-4.000
SNMX 251224-R80	T9335	■	■					4.725	4.625-5.875
SNMX 251224-R100	T9335	■	■					4.725	5.875-7.375
SNMX 251224-R120	T9335	■	■					5.510	7.000-8.875

SNMA 1506-R

	L	IC	D1	S
1506	.625	.625	.203	.250

PRAMET



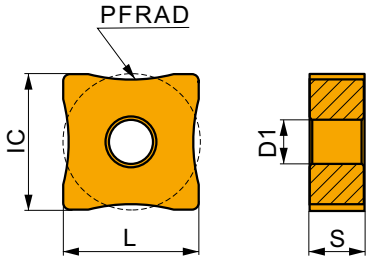


ISO		P	M	K	N	S	H	PFRAD	ODW
SNMA 150608-R09	**6640**	■	■					.355	.510-.630
SNMA 150608-R11	**6640**	■	■					.435	.630-.785
SNMA 150608-R13	**6640**	■	■					.510	.750-.945
SNMA 150608-R15	**6640**	■	■					.590	.865-1.100
SNMA 150608-R18	**6640**	■	■					.710	1.065-1.300
SNMA 150608-R20	**6640**	■	■					.785	1.180-1.455
SNMA 150608-R22	**6640**	■	■					.865	1.300-1.615
SNMA 150608-R25	**6640**	■	■					.985	1.455-1.850
SNMA 150608-R27	**6640**	■	■					1.065	1.575-1.970
SNMA 150608-R30	**6640**	■	■					1.180	1.730-2.205
SNMA 150608-R35	**6640**	■	■					1.380	2.045-2.560
SNMA 150608-R40	**6640**	■	■					1.575	2.325-2.955
SNMA 150608-R42	**6640**	■	■					1.655	2.440-3.070
SNMA 150608-R45	**6640**	■	■					1.770	2.640-3.305
SNMA 150608-R50	**6640**	■	■					1.970	2.915-3.700
SNMA 150608-R60	**6640**	■	■					2.360	3.505-4.410
SNMA 150608-R65	**6640**	■	■					2.560	3.780-4.805
SNMA 150608-R70	**6640**	■	■					2.755	4.095-5.155
SNMA 150608-R75	**6640**	■	■					2.955	4.370-5.550
SNMA 150608-R80	**6640**	■	■					3.150	4.645-5.905
SNMA 150608-R90	**6640**	■	■					3.545	5.235-6.655
SNMA 150608-R105	**6640**	■	■					4.135	6.100-7.755
SNMA 150608-R120	**6640**	■	■					4.725	7.010-8.860

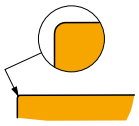
SNMA 2509-R

PRAMET

	L	IC	D1	S
2509	1.000	1.000	.359	.375



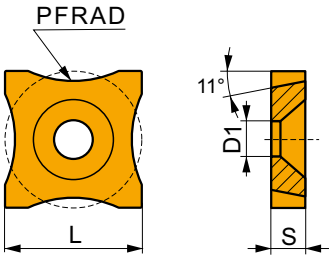
ISO		P	M	K	N	S	H	PFRAD	ODW
SNMA 250924-R00	T9335	■	■					0	0-0
SNMA 250924-R60	T9335	■	■					2.360	3.505-4.410



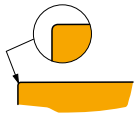
SPUB 19-R

PRAMET

	L	IC	D1	S
SPUB 19	.750	.750	.203	.187



ISO	ANSI		P	M	K	N	S	H	PFRAD	ODW
SPUB 19-R00 *	SPUB-63-M	T9335	■	■					0	0-0
		6640	■	■					0	0-0
SPUB 19-R12	SPUB-63-B	T9335	■	■					.470	.710-.865
		6640	■	■					.470	.710-.865
SPUB 19-R15	SPUB-63-C	T9335	■	■					.590	.865-1.100
		6640	■	■					.590	.865-1.100
SPUB 19-R20	SPUB-63-D	T9335	■	■					.785	1.140-1.455
		6640	■	■					.785	1.140-1.455
SPUB 19-R25	SPUB-63-E	T9335	■	■					.985	1.455-1.850
		6640	■	■					.985	1.455-1.850
SPUB 19-R30	SPUB-63-F	T9335	■	■					1.180	1.770-2.245
		6640	■	■					1.180	1.770-2.245
SPUB 19-R40	SPUB-63-G	T9335	■	■					1.575	2.360-2.990
		6640	■	■					1.575	2.360-2.990
SPUB 19-R50	SPUB-63-H	T9335	■	■					1.970	2.955-3.740
		6640	■	■					1.970	2.955-3.740
SPUB 19-R63	SPUB-63-I	T9335	■	■					2.480	3.740-4.725
		6640	■	■					2.480	3.740-4.725

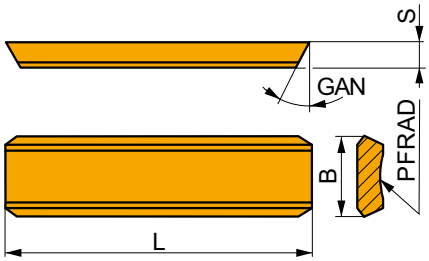


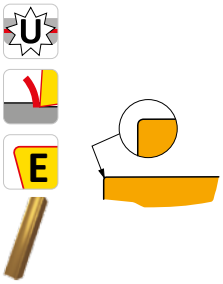
* This insert has 11° positive clearance all around.

LDGN

PRAMET

L	S	B	GAN
2.362	.197	.591	30°
13,05			

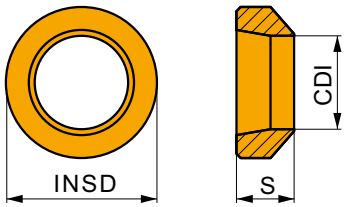




ISO		P	M	K	N	S	H	PFRAD	ODW
LDGN 130560-R25	6640	■	■					.985	1.340-1.770
LDGN 130560-R30	6640	■	■					1.180	1.615-2.125
LDGN 130560-R35	6640	■	■					1.380	1.890-2.480
LDGN 130560-R40	6640	■	■					1.575	2.125-2.835
LDGN 130560-R45	6640	■	■					1.770	2.400-3.190

PSR

PRAMET



ISO		P	M	K	N	S	H	INSD	CDI	S	PFRAD	IDW
PSR0-R3.5	T9335	■	■					.236	.118	.138	.135	.470-.530
PSR0-R4	T9335	■	■					.236	.138	.138	.155	.470-.550
PSR0-R4.5	T9335	■	■					.315	.157	.157	.180	.530-.750
	5040	■						.315	.157	.157	.180	.530-.750
	S45	■						.315	.157	.157	.180	.530-.750
PSR0/10-R4.5*	T9335	■	■					.394	.157	.157	.180	.530-.750
PSR0-R5.5	T9335	■	■					.315	.197	.157	.225	.630-.785
	5040	■						.315	.197	.157	.225	.630-.785
PSR0/10-R5.5*	T9335	■	■					.394	.197	.157	.225	.630-.785
PSR0-R6	T9335	■	■					.394	.217	.177	.250	.670-.785
	5040	■	◪					.394	.217	.177	.250	.670-.785
PSR0-R6.5	T9335	■	■					.394	.236	.177	.270	.670-.825
	5040	■						.394	.236	.177	.270	.670-.825
	S45	■						.394	.236	.177	.270	.670-.825
PSR0-5-R6.5*	T9335	■	■					.394	.236	.197	.270	.670-.865
PSR0-R7	T9335	■	■					.394	.256	.177	.290	.670-.865
	S45	■						.394	.256	.177	.290	.785-.865

ISO		P	M	K	N	S	H	INSD	CDI	S	PFRAD	IDW
PSR1-R7	T9335	■	■					.512	.236	.197	.270	.785-.865
	5040	■						.512	.236	.197	.270	.785-.865
	S45	■						.512	.236	.197	.270	.785-.865
PSR1-R7.5	T9335	■	■					.512	.268	.197	.305	.825-.905
PSR1-R8	T9335	■	■					.512	.276	.197	.315	.865-.945
	5040	■						.512	.276	.197	.315	.865-.945
	S45	■						.512	.276	.197	.315	.865-.945
PSR1-R9	T9335	■	■					.512	.315	.197	.360	.945-1.025
	5040	■						.512	.315	.197	.360	.985-1.100
	S45	■						.512	.315	.197	.360	.985-1.100
PSR1-R10	T9335	■	■					.512	.354	.197	.400	.985-1.100
	5040	■						.512	.354	.197	.400	.985-1.100
	S45	■						.512	.354	.197	.400	.985-1.100
PSR2-R9	T9335	■	■					.748	.315	.315	.360	.945-1.025
PSR2-R10	T9335	■	■					.748	.354	.315	.400	1.025-1.100
	5040	■						.748	.354	.315	.400	1.025-1.100
	S45	■						.748	.354	.315	.400	1.025-1.100
PSR2-R11	T9335	■	■					.748	.394	.315	.450	1.100-1.180
	5040	■						.748	.394	.315	.450	1.100-1.180
	S45	■						.748	.394	.315	.450	1.100-1.180
PSR2-R12	T9335	■	■					.748	.433	.315	.490	1.180-1.340
	5040	■						.748	.433	.315	.490	1.180-1.340
	S45	■						.748	.433	.315	.490	1.180-1.340
PSR2-R13	T9335	■	■					.748	.469	.315	.530	1.220-1.380
PSR2-R14	T9335	■	■					.748	.492	.315	.565	1.260-1.615
PSR3-R12	T9335	■	■					.866	.433	.394	.490	1.180-1.340
PSR3-R14	T9335	■	■					.866	.472	.394	.540	1.260-1.615
	5040	■						.866	.472	.394	.540	1.260-1.615
	S45	■						.866	.472	.394	.540	1.260-1.615
PSR3-R17	T9335	■	■					.866	.591	.394	.675	1.415-1.615
	5040	■						.866	.591	.394	.675	1.415-1.615
	S45	■						.866	.591	.394	.675	1.415-1.615
PSR4-R20	T9335	■	■					1.181	.669	.472	.765	1.615-1.970
PSR4-R23	T9335	■	■					1.181	.787	.472	.900	1.890-2.245
	5040	■						1.181	.787	.472	.900	1.890-2.245
	S45	■						1.181	.787	.472	.900	1.890-2.245
PSR5-R25	T9335	■	■					1.378	.866	.472	.990	2.755-3.345
	5040	■						1.378	.866	.472	.990	2.755-3.345
	S45	■						1.378	.866	.472	.990	2.755-3.345
PSR5-R28	T9335	■	■					1.378	.984	.472	1.120	3.345-3.935
	5040	■						1.378	.984	.472	1.120	3.345-3.935
	S45	■						1.378	.984	.472	1.120	3.345-3.935
PSR6-R34	T9335	■	■					1.772	1.181	.591	1.345	3.935-5.120
	5040	■						1.772	1.181	.591	1.345	3.935-5.120
	S45	■						1.772	1.181	.591	1.345	3.935-5.120
PSR7-R39	T9335	■	■					1.969	1.378	.591	1.555	4.920-5.510
	S45	■						1.969	1.378	.591	1.555	4.920-5.510
PSR8-R46	T9335	■	■					2.165	1.575	.709	1.795	5.510-7.085
	5040	■						2.165	1.575	.709	1.795	5.510-7.085

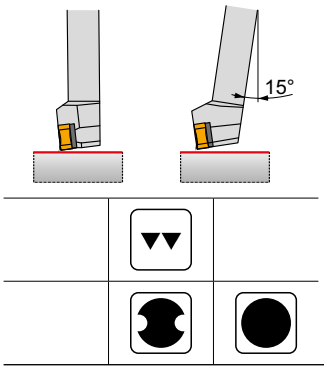
* rings deviating from standard dimension
* INSD, S - modification

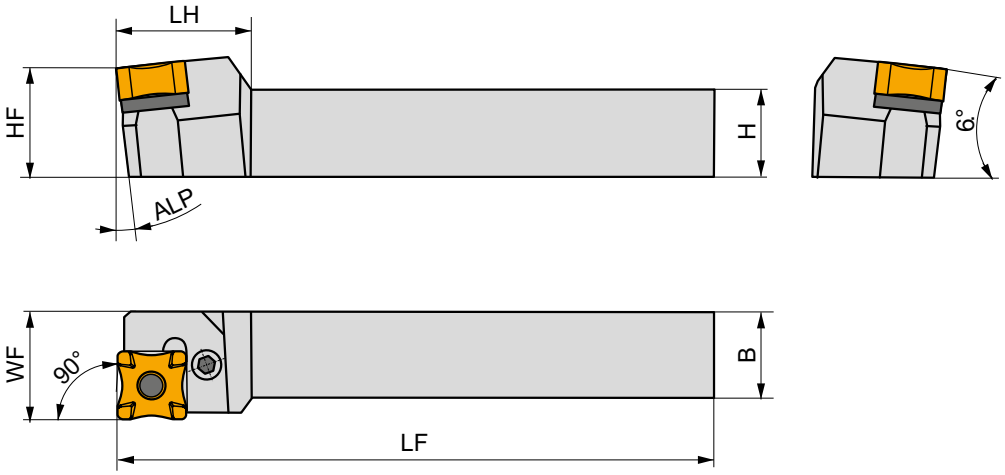
PXFN(RL)

P M

PRAMET

P





	H [in]	B [in]	HF [in]	WF [in]	LF [in]	LH [in]	ALP [°]	lbs			
PXFNR/L 2525 R 15	.984	.984	.984	.984	7.874	1.575	6	2.315	GI185	PX 40	AT009
PXFNR/L 2525 S 19	.984	.984	.984	.984	9.843	1.772	6	2.866	GI186	PX 50	-
PXFNR/L 3232 S 25	1.260	1.260	1.575	1.575	9.843	1.969	6	4.850	GI199	PX 60	AT010
PXFNR/L 2525 R 15/15	.984	.984	.984	.984	7.874	1.575	20	2.315	GI185	PX 40	AT009
PXFNR/L 2525 S 19/15	.984	.984	.984	.984	9.843	1.969	20	2.866	GI186	PX 50	-

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

				Nm					
PX40	SNU 150310-R	PU 03	US 36	6,0	M8x1	1.024	NT 05	MT 07	HKX 4
PX50	SNU 190410-R	PU 05	US 38	8,0	M10x1	1.142	NT 06	MT 06	HXK 5
PX60	SNU 250424-R	PU 06	US 47	8,0	M12x1	1.299	NT 08	MT 08	HXK 5

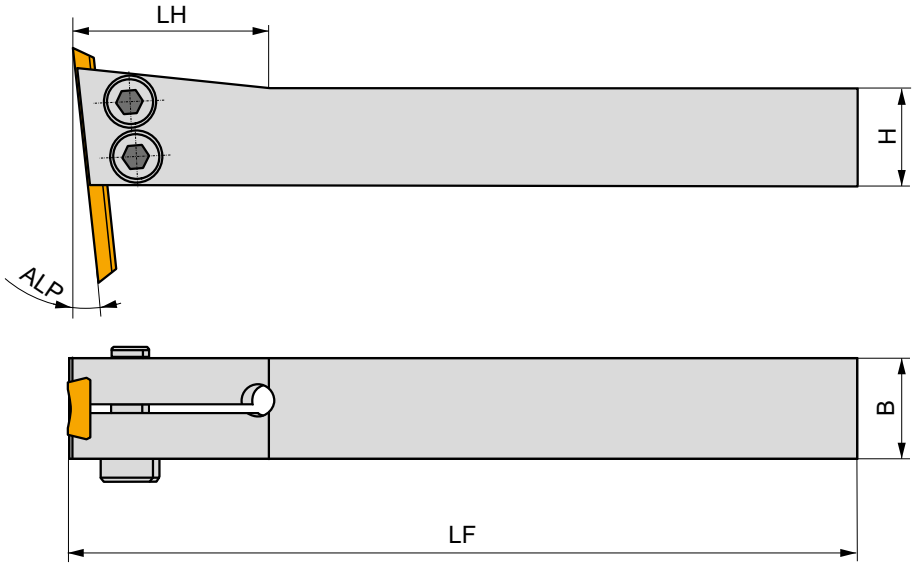
AT009	SNMX 150708-R..	SNU 150410-CX
AT010	SNMX 251224-R..	SNU 250524-CX

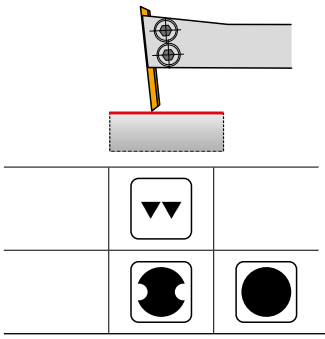
XLCDN

P M

PRAMET

P





	H [in]	B [in]	LF [in]	LH [in]	ALP [°]	lbs		
XLCDN 2525 R 15	.984	.984	7.874	1.969	6	2.425	GI187	PX10

GI187	LDGN 130560…

PX10	HS 0825	M8	.984	HKX 6

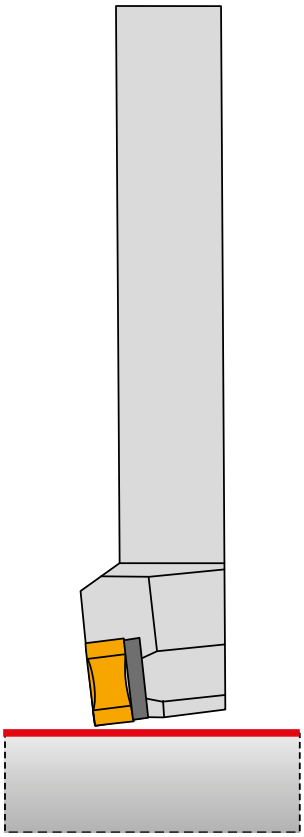
TECHNICAL INFORMATION

GRADES FOR SCARFING

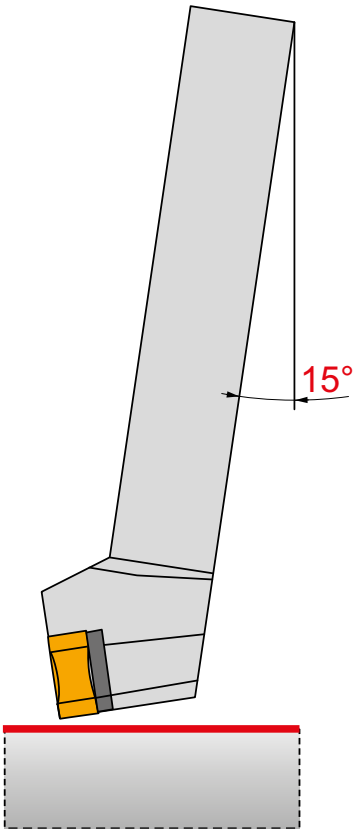
Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Substrate	Coating	Colour	Coolant benefit	General purpose	High speed tube mills	Low speed tube mills
T9335	P20 - P45	■				FGM	MT-CVD		+ + +	✓	✓	
	M15 - M40	■										
6640	P20 - P45	■				H	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	×	Uncoated grade
S	Substrate with cubic carbides		

PXFN(RL) - VARIOUS HOLDERS ACCORDING TO HEAD INCLINATION

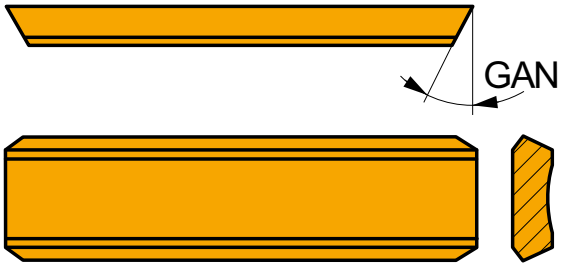


PXFN(RL) ...



PXFN(RL) ... /15

LDGN – INSERTS SUITABLE FOR REGRINDING

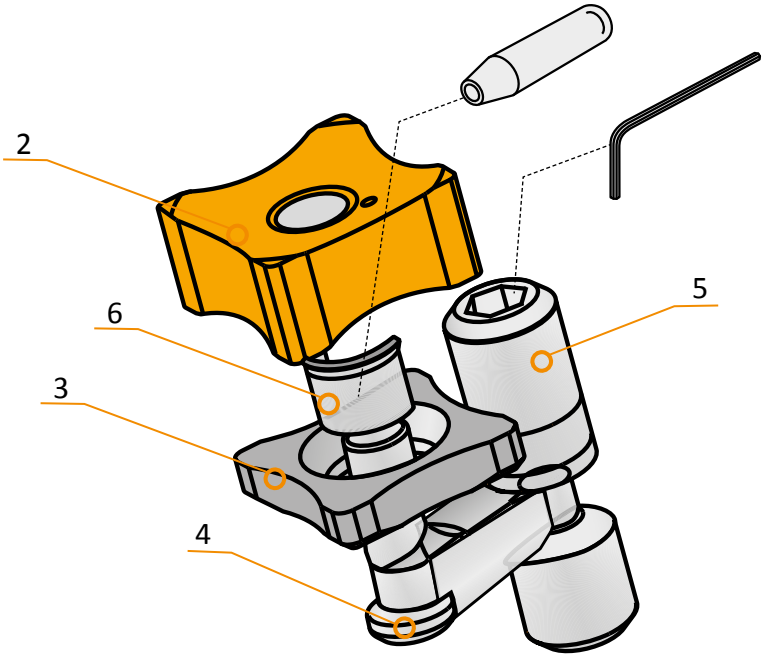


Offers long tool life due to total length of insert (2.4 inch), which can be ground several times to a minimum length of 1 inch.

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.

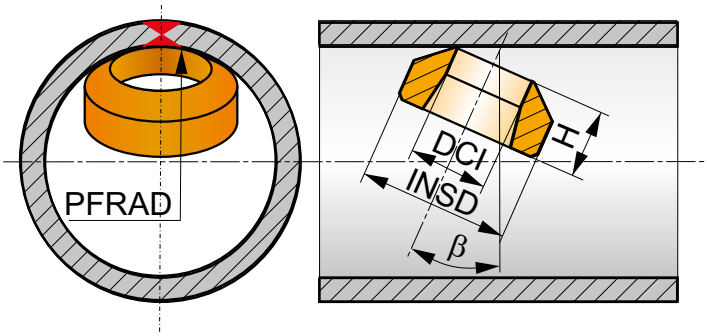
PXFN(RL) - VARIOUS SPARE PARTS ACCORDING TO INSERT SHAPE



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

SCARFING RINGS - HOW TO CALCULATE WORKING RADIUS PFRAD

Working radius PFRAD circle of osculatory DCI



$$\textbf{PFRAD} = \frac{DCI}{2x\sin\beta}$$

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

www.dormerpramet.com
youtube.com/dormerpramet
facebook.com/dormerprametsocial
linkedin.com/company/dormerpramet
twitter.com/dormerpramet
instagram.com/dormerprametsocial

DORMER PRAMET