

**DORMER  PRAMET**

**SCARFING**

2020





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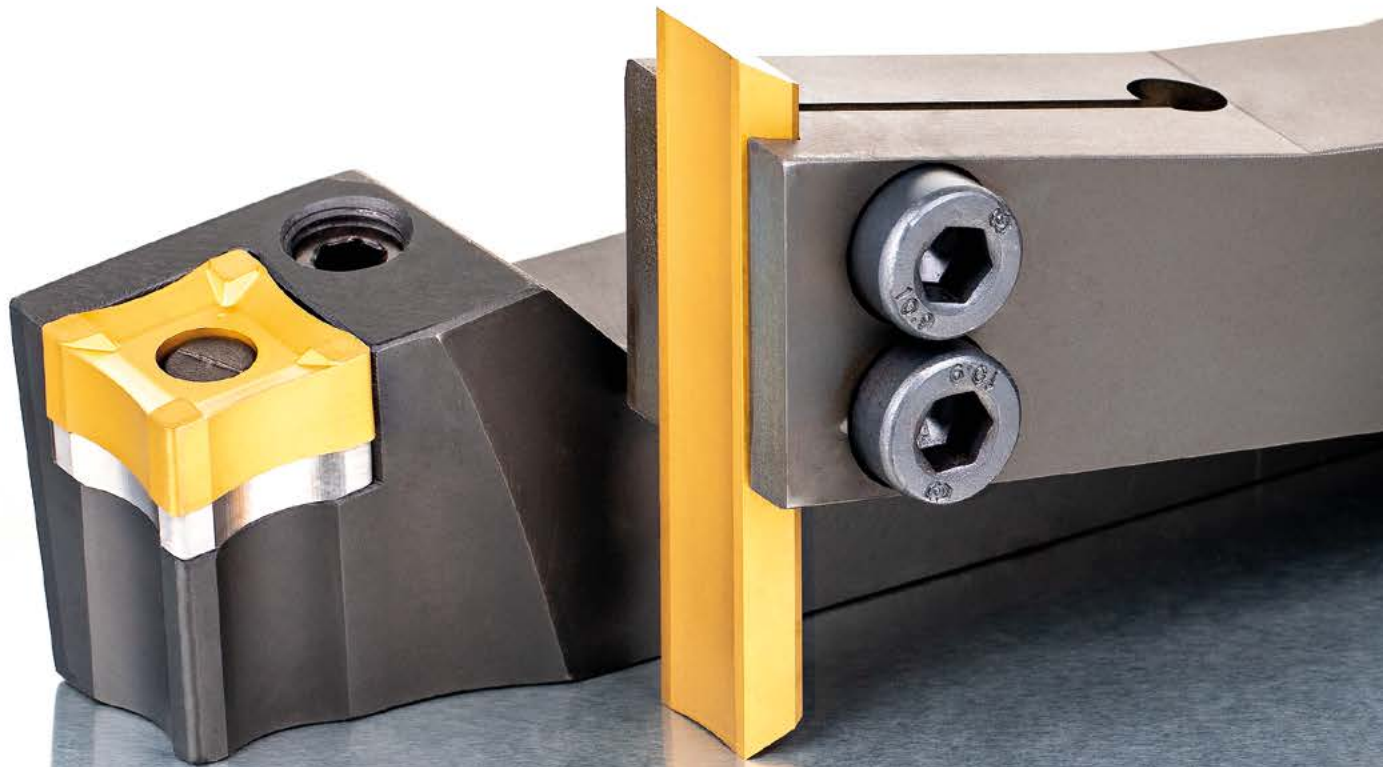
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# SCARFING

## 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

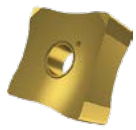
### BENEFITS

- **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



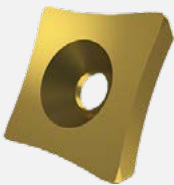
LDGN



PSR

### NEW ITEMS

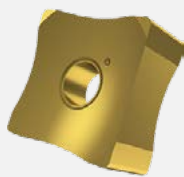
**NEW**



SPUB 19

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

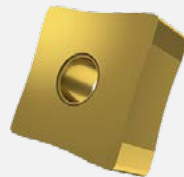
**NEW**



SNMX 1507

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

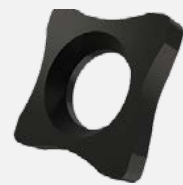
**NEW**



SNMA 1506

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

**NEW**

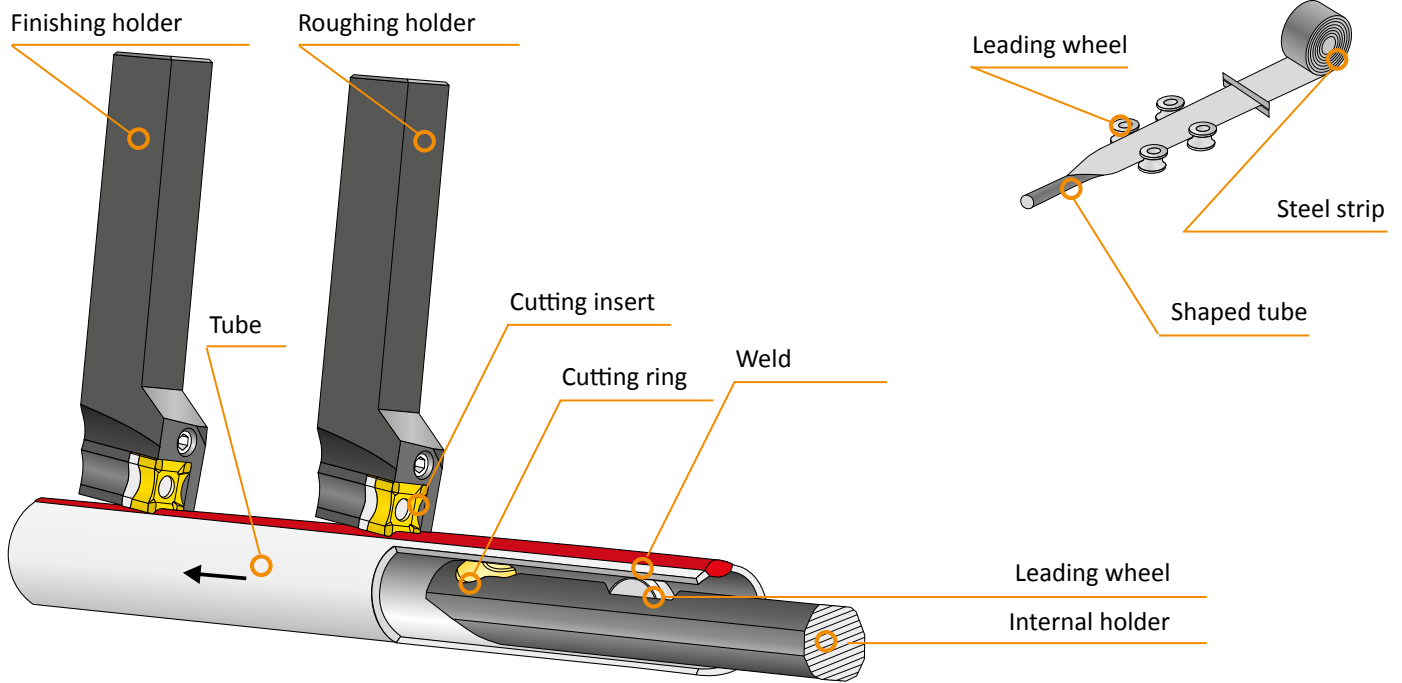


SNU

- 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 ?

INSERTS		Tube diameter [in]
EXTERNAL	SNMX 251224-R..	R25 - R120 R00
	SNMX 25-R..	R50 - R200 R00
	SNMA 250924-R..	R60 R00
	SPUB 19-R..	R12 - R63 R00
	SNMX 19-R..	R10 - R90 R00
	SNMX 150708-R..	R09 - R105
	SNMX 15-R..	R07 - R90 R00
	SNMA 150608-R..	R09 - R120
	LDGN 13	R25 - R45
INTERNAL	PSR0	0.4 - 0.8
	PSR1	0.8 - 1.2
	PSR2	1.2 - 1.6
	PSR3	1.6 - 2.0
	PSR4	2.0 - 3.2
	PSR5	3.2 - 4.4
	PSR6	4.4 - 6.0
	PSR7	6.0 - 8.0
	PSR8	8.0 - 13.6

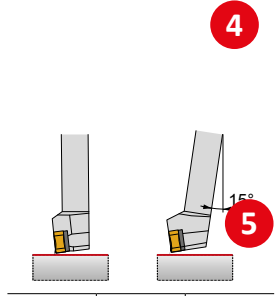
**1** P XFN(RL)




**2**

P

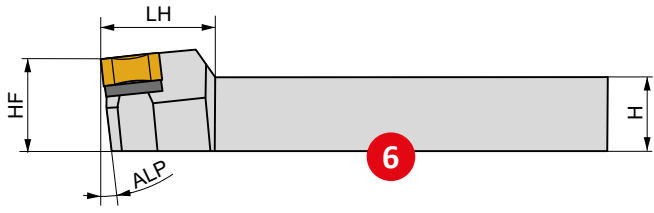
**3**



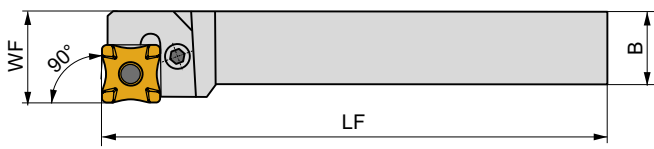
**4**

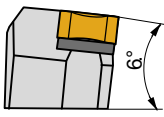


**5**

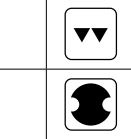


**6**

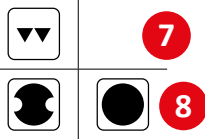





**8**






**7**




**8**




**9**

	H	B	HF	WF	OAL	LH	ALP	kg			
	[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	<b>12</b>	<b>13</b>	<b>14</b>	<b>15</b>
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	HXX 4
PX50	SNU 190410-R	PU 05	US 38	MT 06	HXX 5
PX60	SNU 250424-R	PU 06	US 39	MT 08	HXX 5



**18**

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

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

<sup>1)</sup> Turning holder is primarily displayed in its right-hand design (R)


<sup>2)</sup> 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.

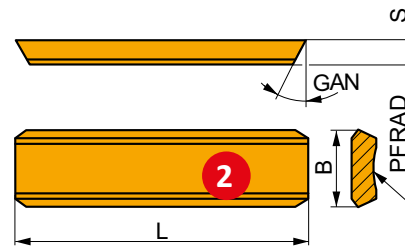
<sup>3)</sup> Spare parts and special accessories icons are designed schematically for ease of understanding. They aren't included in the list of icons. Screws are, in some cases, completed with info on torque value in Nm, length of screw and size of thread.










## PAGE OVERVIEW

### 1 LDGN

	L	<b>3</b>	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
<b>4</b>	<b>5</b>	LDGN 130560-R40	6640	■	■		<b>8</b>			<b>9</b>	<b>10</b>
		LDGN 130560-R45	6640	■	■						

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




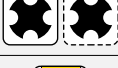


9 Radius

10 Tube diameter









## ICONS AND SYMBOLS

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

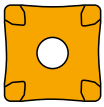

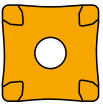

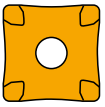

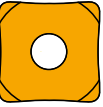

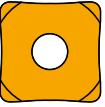



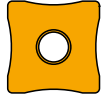

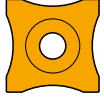





### Icons - scarfing holders

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

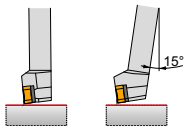

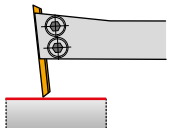







### Icons and symbols - inserts

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

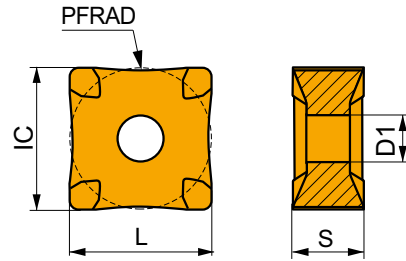
## NAVIGATOR - TOOLS

<p><b>PFXN(RL) EXT</b></p>		<p><b>XLCD(N) EXT</b></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	.625	.625	.203	.321

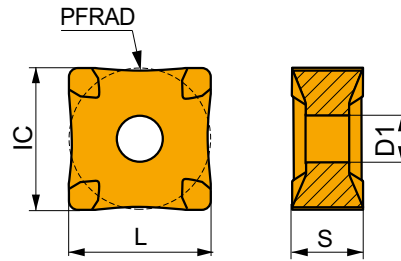


		ISO		P	M	K	N	S	H	PFRAD	
		SNMX 15-R00	T9335	■	■					0	0-0
		SNMX 15-R07	T9335	■	■					.275	.395-.510
			6640	■	■					.275	.395-.470
		SNMX 15-R09	T9335	■	■					.355	.470-.630
			6640	■	■					.355	.470-.630
		SNMX 15-R11	T9335	■	■					.435	.590-.750
			6640	■	■					.435	.590-.750
		SNMX 15-R13	T9335	■	■					.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

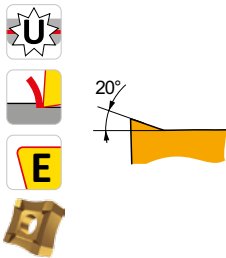
# SNMX 19-R



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



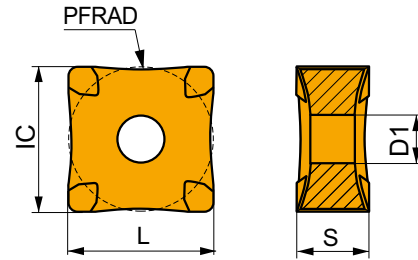
i	↖	ISO	Image	Material						PFRAD	ODW
				P	M	K	N	S	H		
		SNMX 19-R00	T9335	■	■					0	0-0
		SNMX 19-R10	T9335	■	■					.395	.550-.710
			6640	■	■					.395	.550-.710
		SNMX 19-R12	T9335	■	■					.470	.630-.825
			6640	■	■					.470	.630-.825
		SNMX 19-R15	T9335	■	■					.590	.785-1.065
			6640	■	■					.590	.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



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

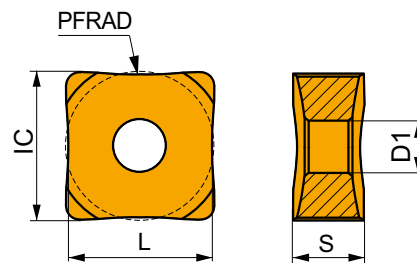


i	ISO	P	M	K	N	S	H	PFRAD	ODW
	SNMX 25-R00	T9335	■	■				0	0-0
	SNMX 25-R50	T9335	■	■				1.970	2.625-3.500
	SNMX 25-R80	T9335	■	■				3.150	2.625-3.501
		6640	■	■				3.150	2.625-3.502
	SNMX 25-R100	T9335	■	■				3.935	2.625-3.503
		6640	■	■				3.935	2.625-3.504
	SNMX 25-R120	T9335	■	■				4.725	2.625-3.505
		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



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



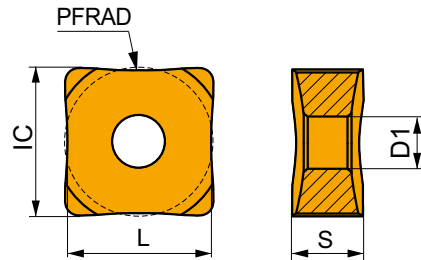
i	ISO	P	M	K	N	S	H	PFRAD	ODW
	SNMX 150708-R09	6640	■	■				.355	.510-.630
	SNMX 150708-R11	6640	■	■				.435	.630-.750
	SNMX 150708-R13	6640	■	■				.510	.750-.905
	SNMX 150708-R15	6640	■	■				.590	.865-1.065
	SNMX 150708-R18	6640	■	■				.710	1.025-1.260
	SNMX 150708-R20	6640	■	■				.785	1.140-1.415
	SNMX 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





i	ISO	P	M	K	N	S	H	PFRAD	ODW
   									

## SNMX 2512-R

PRAMET

	L	IC	D1	S
2512	1.000	1.000	.361	.472

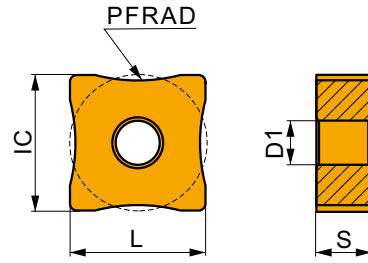


i	ISO	P	M	K	N	S	H	PFRAD	ODW
   									

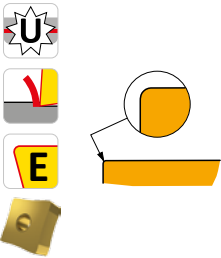
# SNMA 1506-R



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



i	↙	ISO								PFRAD	
				P	M	K	N	S	H		
		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

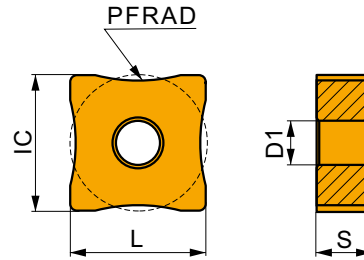




# SNMA 2509-R



	L	IC	D1	S
2509	1.000	1.000	.359	.375

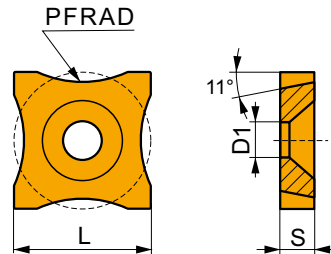


i	ISO	Material	P	M	K	N	S	H	PFRAD	ODW
	SNMA 250924-R00	T9335	■	■					0	0-0
	SNMA 250924-R60	T9335	■	■					2.360	3.505-4.410

# SPUB 19-R



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



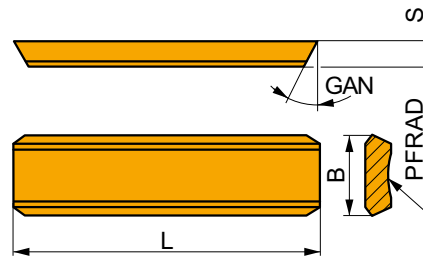
i	ISO	ANSI	Material	P	M	K	N	S	H	PFRAD	ODW
	SPUB 19-R00 *	SPUB-63-M	T9335	■	■					0	0-0
			6640	■	■					0	0-0
	SPUB 19-R12	SPUB-63-B	T9335	■	■					.470	.710-.865
			6640	■	■					.470	.710-.865
	SPUB 19-R15	SPUB-63-C	T9335	■	■					.590	.865-1.100
			6640	■	■					.590	.865-1.100
	SPUB 19-R20	SPUB-63-D	T9335	■	■					.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

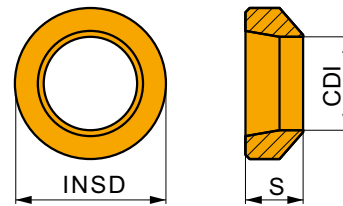


	L	S	B	GAN
13,05	2.362	.197	.591	30°








		ISO		P	M	K	N	S	H	PFRAD	
		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



	ISO		P	M	K	N	S	H	INSD	CDI	S	PFRAD	
	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
		T9335	■	■					.394	.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
		T9335	■	■					.394	.236	.177	.270	.670-825
	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

i	ISO								INSD	CDI	S	PFRAD	
			P	M	K	N	S	H					
	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

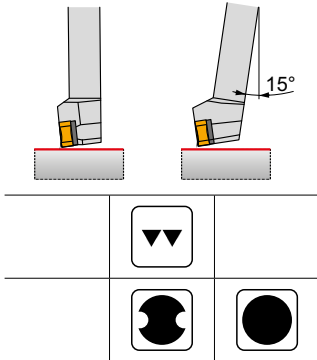
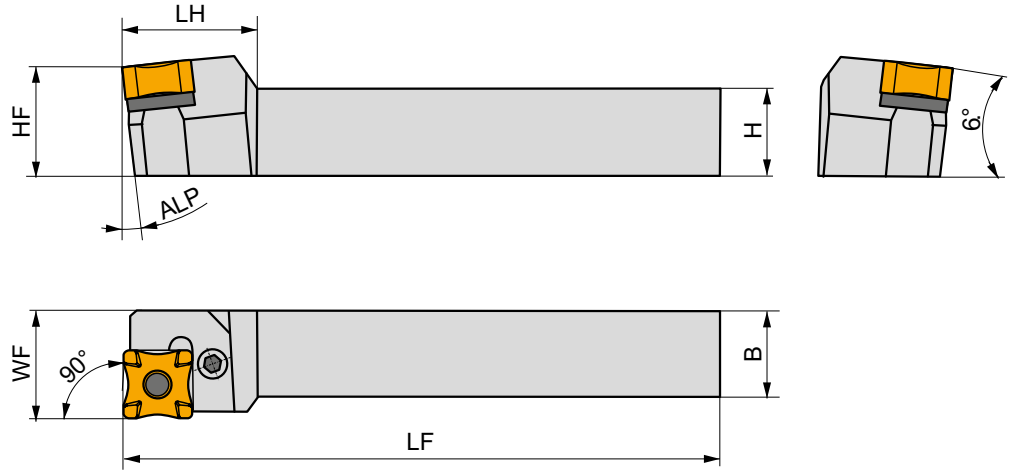
\* INSD, S - modification

# PXFN(RL)



PRAMET

P



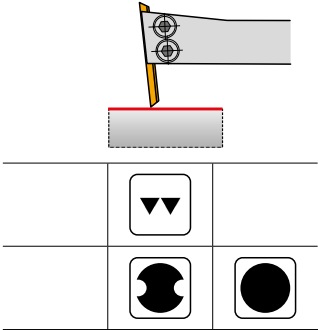
	H	B	HF	WF	LF	LH	ALP	lbs			
	[in]	[in]	[in]	[in]	[in]	[in]	[°]				
<b>PXFNR/L 2525 R 15</b>	.984	.984	.984	.984	7.874	1.575	6	2.315	G1185	PX 40	AT009
<b>PXFNR/L 2525 S 19</b>	.984	.984	.984	.984	9.843	1.772	6	2.866	G1186	PX 50	-
<b>PXFNR/L 3232 S 25</b>	1.260	1.260	1.575	1.575	9.843	1.969	6	4.850	G1199	PX 60	AT010
<b>PXFNR/L 2525 R 15/15</b>	.984	.984	.984	.984	7.874	1.575	20	2.315	G1185	PX 40	AT009
<b>PXFNR/L 2525 S 19/15</b>	.984	.984	.984	.984	9.843	1.969	20	2.866	G1186	PX 50	-

G1185	SNMX 15-R..
G1186	SNMX 19-R..
G1199	SNMX 25-R..

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

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

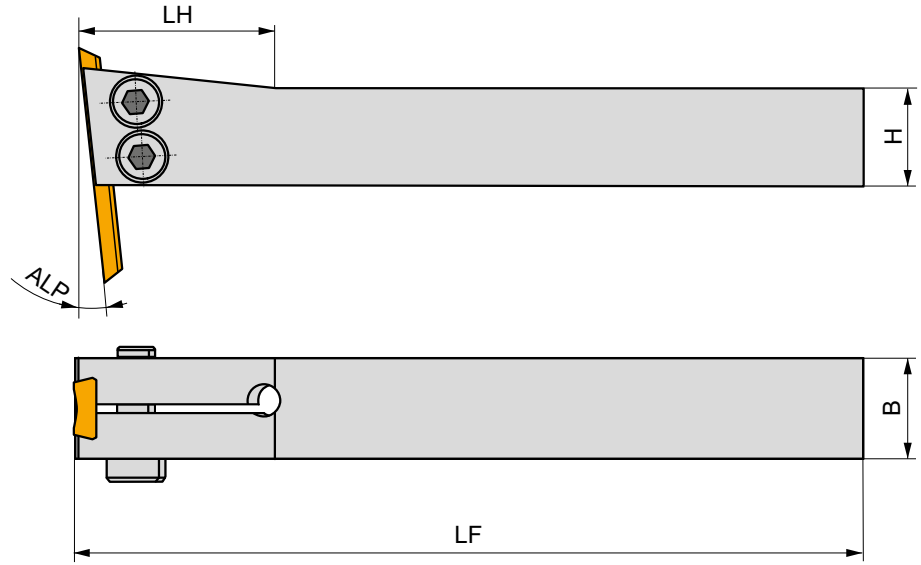
# XLCDN



**P M**

**PRAMET**

**P**



	H	B	LF	LH	ALP	lbs		
	[in]	[in]	[in]	[in]	[°]			
<b>XLCDN 2525 R 15</b>	.984	.984	7.874	1.969	6	2.425	G1187	PX10

G1187	LDGN 130560...	

PX10	HS 0825	M8	.984	HKX 6



# TECHNICAL INFORMATION

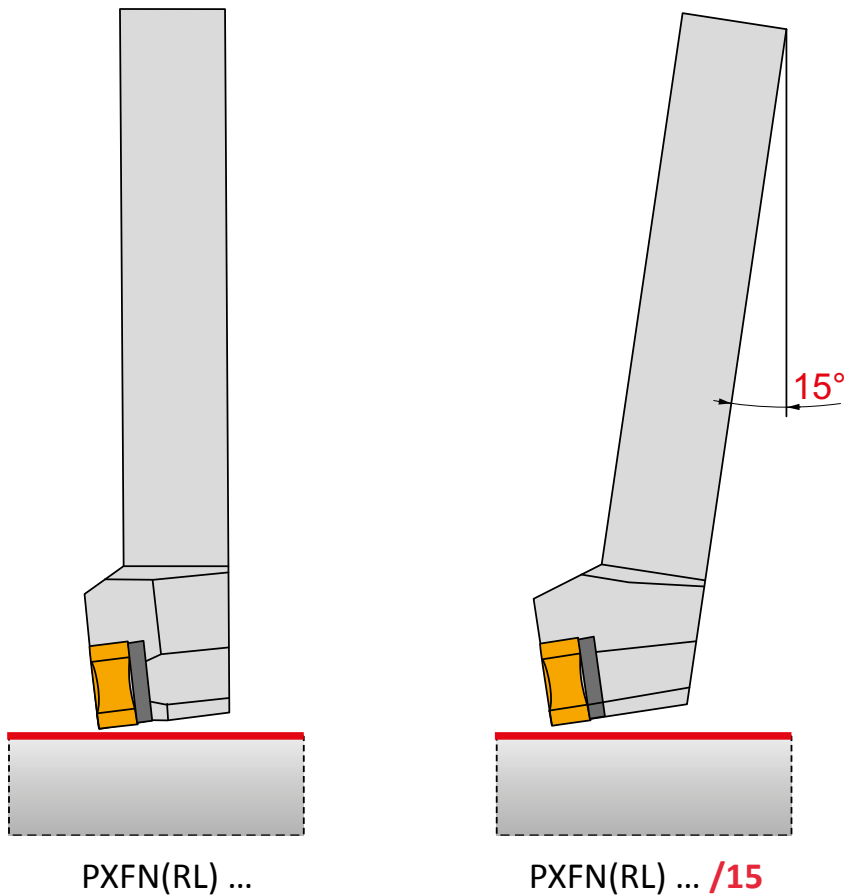
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## GRADES FOR SCARFING

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	□										

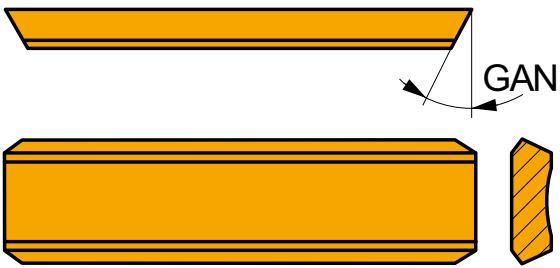
Substrate		Coating	
H	WC-Co based substrate	MT-CVD	Medium-temperature chemical method of coating
FGM	Functionally graded substrate	X	Uncoated grade
S	Substrate with cubic carbides		

## PXFN(RL) - VARIOUS HOLDERS ACCORDING TO HEAD INCLINATION





## LDGN – INSERTS SUITABLE FOR REGRINDING

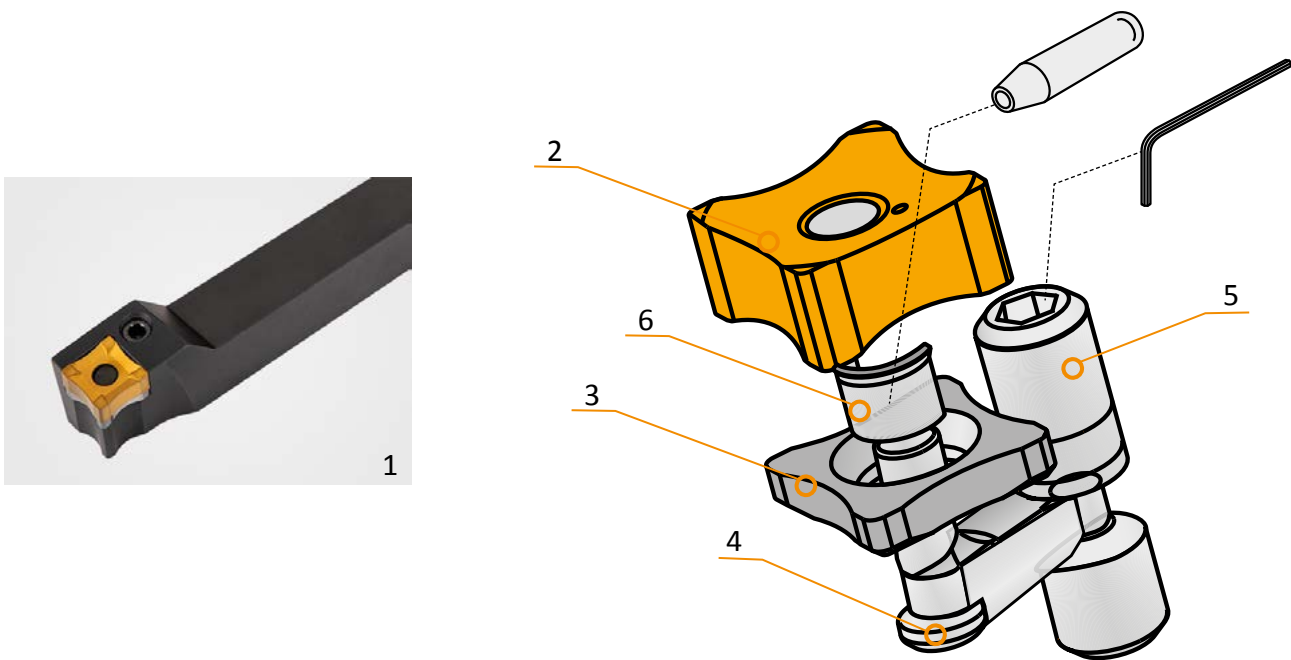


Offers long tool life due to total length of insert (2.4 inch), which can be ground several times to a minimum length of 1 inch.

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.

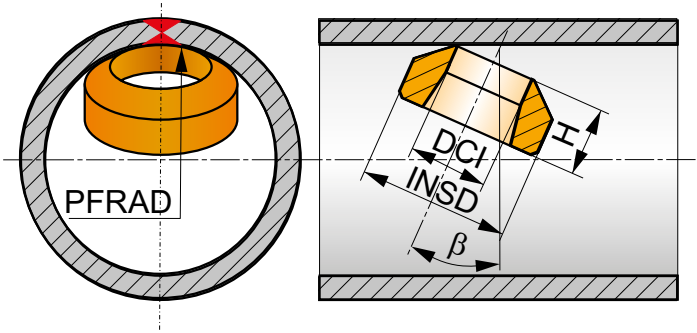
## PXFN(RL) - VARIOUS SPARE PARTS ACCORDING TO INSERT SHAPE



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	PU 03	US 36	NT 07	MT 07	HKX 4
PXFNR/L 2525 S 19 PXFNR/L 2525 S 19/15							
	SNMX 150708-Rxx	SNU 150410-CX	PU 05	US 38	NT 06	MT 06	HKX 5
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	PU 06	US 47	NT 08	MT 08	HKX 5
	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



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

DCI - internal rings diameter

$\beta$  - 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**.

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