HEAVY MACHINING
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 ROUGHING - TURNING**
- **HEAVY ROUGHING - MILLING**
- **SPECIAL THREADING OF PIPES**
- **SCARFING**
- **CHAMFERING OF PIPES**
- **BAR PEELING**
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 UPGRADE 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.

**SMART AND STRONG**

Cartridge: KHS-LOMR08
Inserts: LOMT 08

**HIGH RELIABILITY FOR HARD SHAFTS**

Inserts: LNUN 42
a_p = 30mm

**DOUBLE DEPTH OF CUT**

Inserts: 2x LNXU 40
a_p = 50mm

**TRIPLE PRODUCTIVITY**

Inserts: 3x LNXU 40
a_p = 80mm

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

RELIABLE AND PRODUCTIVE IN EXTREMELY TOUGH CONDITIONS
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 UPIGRADE grades, and high efficiency is supported by our unique Milling cutters developed specifically for Heavy Milling applications.

WE LOOK FORWARD TO YOUR CHALLENGE
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.

Set of cutters for machining a special profile in Hardox 500

Cutter body for radius R36
Inserts: LPEX 19

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

SLSN
LNET 16 + SNEX 13
LNEX 16 + SNET 13
a_p = 104 mm

F6OSB22X
SBMR 22 + SBKX 22
a_p = 15 mm

F9OTB27X
TBMR 27
a_p = 18 mm

W60SP25P
SPGN 25
a_p = 18 mm

W90SP25P
SPUN 25
a_p = 22 mm

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

PEELING WITH SIGNIFICANTLY REDUCED VIBRATION
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.

STANDARD ASSORTMENT

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

SCARFING

WHEN A SMOOTH SURFACE IS NEEDED
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.

Detailed information about the standard range can be found in the Scarfing catalogue.
SPECIAL THREADING TOOLS FOR THE TUBE INDUSTRY

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.

EDGE PREPARATION FOR SAFETY WELDS

We can meet requirements for different edge preparation procedures – including chamfering of metal sheets before forming into tubes up to 1500 mm diameter or beveling 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.
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.