

DORMER PRAMET

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 **DORMER**

 **PRAMET**



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OVER 100 YEARS OF EXPERIENCE

COMPLETE SUPPLIER

Dormer Pramet is a complete supplier of rotary and indexable cutting tools for drilling, turning, milling and threading.

Our portfolio of cutting tools offers one of the broadest ranges on the market – or perhaps THE broadest.

Our global Dormer and Pramet brands offer robust tools and indexable cutting tools, from HSS to carbide and from general machining to high-performance tools for specific applications – a total of around 26,000 unique products for machining virtually all applications and material types.

We also offer tools for customer-specific applications.

Find out more about us on our website:



HIGH-SPEED STEEL DRILLS



Dormer Pramet's famous HSS and HSS-E drills are available in a range of types to suit every requirement and application.

These drills are available separately, or in sets. The most popular sets are A095201 and A095204, but we have many more to choose from. For example A095209, which includes 1 – 10 mm with drills in 0.1 mm increments.

The PFX series is the obvious choice for the most demanding drilling applications, such as deep holes.

Our famous A130 Morse taper drills can also be used for heavier drilling, and we offer long PFX Morse taper drills as well, e.g. A951/952.

These are some of our best known items, but we offer more HSS and HSS-E products too; step drills, countersinks, reamers, centre drills, etc.

Features and benefits:

- Made of high-grade or cobalt-alloyed high-speed steel.
- Versatile for use in most materials.
- TiN, TiAlN or Alcrona coating depending on the drill type.



A095201-A095204

HSS jobber drill set with A002 drills, TiN-tip coated.



A095209

HSS jobber drill set with A002 drills, TiN-tip coated.



Our **ADX drills** are a popular, well-known range of high-performance drills for production drilling.

The unique tip design allows the drill to remove far more material per unit of time and with greater precision than a standard drill.

The ADX is the obvious choice for your CNC machine when you need a robust drill that can handle slightly unstable conditions where carbide drills are not viable.



A553

ADX HSS-E (5% cobalt) jobber drill, TiAlN Top coated with coolant feed.



A510

ADX HSS jobber drill, TiN coated. High performance drill, able to produce high quality and accurate holes.



A002

Our popular standard drill with TiN-coated tip. These drills can be used on most materials and cut smoothly, which enhances tool performance and allows them to work faster than conventional drills.



A951

HSS PFX extra long series taper shank drill (DIN 1870 Series 1), bright finish. Used for deep holes or long reach applications.



A920

PFX HSS-E (5% cobalt) stub drill, bright finish. Used for drilling long chipping materials.

Our **PFX drills** have a parabolic flute construction that is specially designed to transport chips more efficiently out of the hole. This prevents the workpiece material from sticking. Our PFX drills also have a self-centering point design that provides precise positioning and low cutting forces. These drills are available in lengths from 3xD up to 25xD.



CARBIDE DRILLS

Our Force series of drills are our most productive drills, designed for production drilling in controlled machines where efficient and reliable cutting and long tool life are required.

Force-X is our most versatile drill and can be used for most material types, while Force-M is designed primarily for stainless steel as this material has slightly different requirements to regular steels.

Force-X is available with internal coolant feed and for 3xD, 5xD and 8xD deep blind holes, while Force-M also has coolant feed and is available for 3xD and 5xD deep holes.

Force-N is designed for aluminium drilling. This is currently only available on order for 5xD or 8xD drilling depths, but it can also be supplied for deeper holes on request.

Features and benefits:

- Unique CTW flute design for efficient chip evacuation.
- Very versatile, capable of working with most types of material.
- Economical production drill.
- Drill depth 3xD to 8xD.

R120 and R100 are both solid carbide drills that can be used in most materials, but where the requirement for productivity is not critical.



R120
Solid carbide stub drill, bright finish.



R100
Solid carbide jobber drill, bright finish.



R453
FORCE-X solid carbide 5xD drill with coolant feed, TiAlN coated.



R459
FORCE-X solid carbide 8xD drill with coolant feed, TiAlN coated.



R457
FORCE-X solid carbide 3xD drill with coolant feed, TiAlN coated.

HYDRA DRILLS

Combining high precision with versatility, our Hydra drills are the ideal solution for series production with short stoppages, as the drill head can be swapped easily.

The Hydra's hardened steel drill bodies are made for 1.5D, 3xD, 5xD, 8xD and 12xD depths.

The carbide heads are available in diameters from 11.91 to 42 mm.

The heads are available in three versions; for steel, stainless steel and cast iron.

Features and benefits

- Consistent high performance after a large number of head swaps.
- Reduced inventory costs – a single body can be used with lots of different drill heads and sizes.
- Versatile – a common shank size with flat enables holding in many tooling systems.
- Easy to swap heads, resulting in short machine stoppages. The heads can be changed without removing the drill from the machine.
- High precision fit between head and body ensures outstanding hole accuracy and stability.



R950, R960, R970

R950 is designed for steel.

R960 is designed for stainless steel.

R970 is designed for cast iron.



H8512

HYDRA body 12xD, with coolant feed, nickel plated.

H851, H853, H855, H858

HYDRA body, 1.5xD-8xD, with coolant feed, nickel plated.



INDEXABLE DRILLS

Indexable drills are a type of drill that can cope with drilling operations that are impossible for regular drill types, such as drilling on convex and inclined surfaces, cross hole drilling, enlarging existing holes, etc.

Our indexable drills are available with indexable inserts for steel, stainless steel and cast iron.

Features and benefits:

- ↳ Universal tools that can cope with lots of different drilling operations.
- ↳ Efficient, with high cutting capacity.
- ↳ Inserts are available for steel, stainless steel and cast iron.
- ↳ Inserts have 4 cutting edges providing greater economy.



XPET

SD geometry with positive design for central inserts.



SCET

UD geometry with universal design for periphery inserts.



802D

2xD 802D indexable insert drill body with internal coolant feed.



803D

3xD 803D indexable insert drill body with internal coolant feed.



804D

4xD 804D indexable insert drill body with internal coolant feed.



805D

5xD 805D indexable insert drill body with internal coolant feed.

ROUGHING AND FINISHING BORING HEADS



Dormer Pramet offers a wide range of boring heads, both roughing tools and finishing tools, for producing diameters from 8 mm to 500 mm.

Tool shanks and extenders are also available, of course, in addition to the boring heads. Moreover, all these tools are available in complete sets.

Features and benefits:

- ↳ Wide range of boring heads and accessories.
- ↳ Diameters from 8 to 500 mm.
- ↳ 75° entry angle for through holes.
- ↳ 90° angle for blind holes.



F75 / F90

75° finishing boring head, small bore – Ø24 up to Ø82 mm.



D75-C / D90-C

75° roughing boring head, medium bore – Ø80 up to Ø220 mm.



D75-BB / D90-BB

75° roughing boring head, large bore – Ø220 up to Ø500 mm.



BORING HEAD SETS

EXTERNAL ISO TURNING

The Dormer Pramet turning range includes inserts and tool holders for all types of external turning applications.

Our indexable inserts are designed using state-of-the-art technology, in terms of both geometry and grade.

Our chipbreakers are designed for and adapted to the materials they will be used to machine. The best inserts for your turning operations can all be found here.

Features and benefits:

- Wide range of tool holders and indexable inserts.
- Varieties developed using state-of-the-art technology.
- Efficient chipbreakers suitable for all types of workpiece materials.



DDJNR 2525 M 15
External double clamp
turning holder with 93°
cutting angle for DN.. insert

**DNMG150604E-
FM:T7335**



PCLNR
External lever lock turning
holder with 95° cutting angle
for CN.. insert.

**CNMG120408E-
FM:T8430**
FM geometry with positive
design for fine-finish to semi-
rough machining in steel,
stainless steel and cast iron,
and superalloys in
continuous and slightly inter-
rupted machining.



INTERNAL ISO TURNING

Internal turning often places greater demands on the tool than external turning.

Chipbreaking and chip evacuation have to be as efficient as possible.

Dormer Pramet offers boring bars for almost all internal turning applications.

Features and benefits:

- ↳ Tool holders are available for most turning applications.
- ↳ Smooth cutting geometries that reduce the risk of vibration.
- ↳ Innovative chipbreakers reduce the risk of chip “nesting”.
- ↳ Boring bars available with internal coolant to help with cooling and chip evacuation.



TCMT
110204E-FM:T9325
FM geometry for finish to semi-rough machining of steel, stainless steel and cast iron, and in continuous to slightly interrupted cuts.

A16R-STFCR 11



TCMT
110204E-NF1:T9325
NF1 geometry with positive design for fine-finish to semi-rough machining in stainless steel and superalloys, also suitable for steel, hardened materials and non ferritic materials. For continuous machining.

A20S-STFCR 11
Internal screw lock boring bar with 91° cutting angle for TC.. insert.



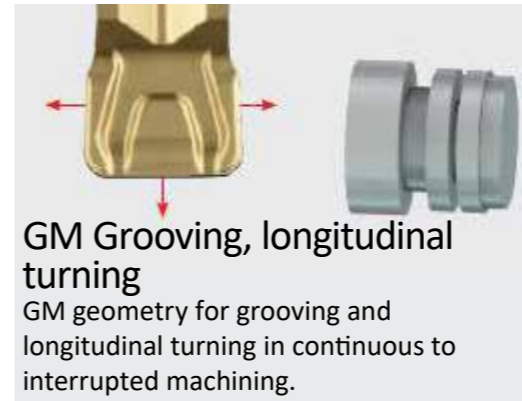
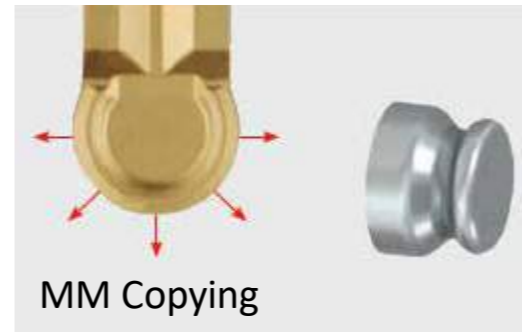
GROOVING AND PARTING-OFF

All kinds of inserts and tool holders for parting-off can be found here, including both solid holders and blade type tools for mounting on tool blocks.

Our tools can be used for both internal and external grooving.

Features and benefits:

- Wide range of inserts with one or more edges for better economy.
- Insert types that can also be used for forming and longitudinal turning.

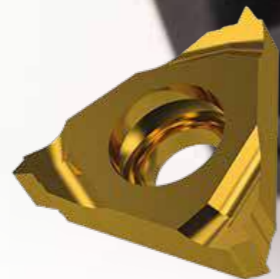


THREAD TURNING

The Dormer Pramet range includes indexable inserts and tool holders for both internal and external turning of the most common thread forms.

Features and benefits:

- Wide range of insert types.
- Full and partial profile inserts.



TN16NL100M:T8030

SIR 2325 Q 16
Internal screw clamped
threading holder for TN
11, 16 or 22 insert.



TN16ER100M:T8030

SER 2525 M 16

External screw clamped threading
holder for TN 16 or 22 inserts.

KEYWAY MILLING

The Dormer Pramet turning catalogue also includes tools for broaching keyways.

These can be found under Broaching.

Features and benefits:

- Single or double-edged indexable inserts.
- Several insert widths to choose from.
- Suitable insert holders are available as part of the programme.



PHZ 1512-10



HZ1006-60 C11



HZ-2

THREADING SETS

As with the drills, Dormer Pramet also has a number of different variants of threading sets.

The smaller ones also come with suitable drills, making life easier for machinists and skilled workers – you always have all the tools you need to hand.

The more extensive sets also include tap wrenches and dies with associated die stocks.

Features and benefits:

- Wide range of combinations and thread forms.
- Choose from straight flute universal hand taps, spiral point or spiral flute machine taps or straight flute serial taps.

Drill and tap set

Set of EP/EX or Shark line taps with A002 or A108 drills.



Threading sets for hand tapping

Set of taps, dies and tap wrenches, various sizes.



MACHINE TAPS

Dormer Pramet is famous for offering an enormous range of machine taps for almost all available tapping systems.

Here you can choose from the traditional HSS taps, such as the straight fluted E500 (which can also be used for manual tapping), to more advanced EX-type spiral flute taps or EP-type spiral point taps.

The latter are made of cobalt-alloyed high-speed powder steel, HSS-E PM, which combines high wear resistance and heat resistance with outstanding toughness.

Features and benefits:

- Wide range of tap types and dimensions.
- Made of high-grade HSS, HSS-E or HSS-E PM high-speed steel.
- Universal – can be used for threading most materials.



EP10

HSS-E-PM spiral point machine tap, metric fine, DIN standard.



EX00

HSS-E-PM 45° spiral flute tap, metric, DIN standard, with bright finish.



EX01

HSS-E-PM 45° spiral flute tap, metric, DIN standard, steam tempered.

SHARK TAPS

Dormer's material-specific DIN taps, known as SHARK LINE, are renowned for their high performance and are easy to recognise thanks to the colour rings indicating the material type(s) for which they are designed.



Features and benefits:

- The colour ring on the shank indicates suitability for specific materials and makes tool selection quick and easy.
- The edges of the machine taps with spiral flute are specially treated in order to enhance edge strength and reduce the risk of chipping. This significantly increases the service life of the taps.
- Designed to control chip evacuation - reduces the risk of chips "bird nesting".



CARBIDE TAPS

Dormer Pramet carbide taps are available in straight flute, spiral flute and forming tap styles.

Our forming taps are suitable for most types of material with sufficient flow properties.

These taps offer outstanding abrasion resistance and are suitable for CNC machines.

Features and benefits:

- Robust design and high abrasion resistance.
- Superior performance.
- Suitable for hard and abrasive materials.
- Also available as a thread forming tap for malleable materials.



THREAD MILLING CUTTERS

Thread milling is a useful alternative where the material can cause problems when creating threads with taps.

The milling cutters can be used to produce the preferred thread tolerance, and in the event of a breakage, the pieces can be picked out of the hole without destroying the workpiece.

These thread milling cutters are available for common thread forms M, MF, UNF/UNC, G and NPT.

Features and benefits:

- Superior performance.
- Can produce right or left-handed threads.
- Full thread form all the way down to the bottom of the hole.
- Multiple thread dimensions with the same pitch are possible with the same milling cutter.
- Economical alternative to large tap sizes.



T205

Carbide 15° spiral flute machine tap, metric, DIN standard. The 15° spiral flute makes it great for threading blind holes.



T210

Carbide straight flute machine tap, with TiCN coating, metric, DIN standard. TiCN-coated for superior performance.



T215

Carbide thread forming tap, metric, DIN standard. The carbide provides superior performance.



J200

Solid carbide thread milling cutter with countersink, metric. Alcrona Pro-coated for best results in a variety of materials.



J215

Solid carbide thread milling cutter with high helix and through coolant, metric. Through coolant for better chip evacuation and with 27° helix for smoother operation.



J260

Solid carbide thread milling cutter, NPT. Alcrona Pro-coated for best results in a variety of materials.

SOLID CARBIDE MILLING CUTTERS

Dormer's solid carbide milling range includes end mills for the most common operations and material types.

This range includes everything from economical options when you don't need specific application tools, to top quality, high performance tools for when function and quality are crucial.

Features and benefits:

- Wide selection of cutting lengths depending on application.
- Milling cutters are available for dynamic milling.
- Unequal flute designs reduce vibration and improve surface finish.



S216
For stainless steels, superalloys.



S521
End mills for hardened tool steels.



S654
High-performance end mills for aluminium alloys.



S768
Suitable for most material groups.



S802HA
A range of versatile end mills that can handle most material types.



S933
An economical option with 2-, 3- and 4-cut end mills, also available in sets.

SHOULDER MILLS

Dormer Pramet has always offered a very wide range of indexable cutting tools.

These include shoulder mills, which come in a range of types - from smaller, double edge end mills such as the SAD07D with ADMX inserts to the impressively deep shoulder mills such as the J(T)-SSAP.

Features and benefits:

- Wide range of true 90° shoulder mills.
- Several mounting options, e.g. cylindrical, modular and arbor style.
- Wide range of inserts that can be used to machine most materials.
- Wide range of nose radii, 0.4-5.0 mm.
- Economical double-sided insert types are available, e.g. LNGX.

J(T)-SSAP

Long edge end mill for AP..15 and SP..12 inserts. Suitable for a variety of applications, including shoulder, face, slot and plunge milling.



SAD11E

FORCE AD11 square shoulder mill with internal coolant. Treated for long tool life.



STN16

ECON TN16 square shoulder mill with internal coolant. Treated for long tool life.



ADM INSERTS

Available in sizes 16, 11 and 07.



SHOULDER MILLS



SAD07D

FORCE AD07 square shoulder mill with internal coolant.



SLN12

ECON LN12 square shoulder mill with internal coolant.



SAD16

FORCE AD16 square shoulder mill with internal coolant.

FACE MILLS



Our range of face mills also offers a variety of choices based on your needs.

Our face milling range includes everything from smaller 45° end mills to arbor style face mills 315 mm in diameter.

Features and benefits:

- Wide range of positive and negative milling cutter combinations.
- Wide range of indexable inserts that can be used to machine most work materials.
- Economical double-sided insert types are available, e.g. HNGX.

SHN06C

ECON HN06 45° face mill with double negative design and internal coolant. Economical 12-edge indexable insert, treated for long tool life.



SPN13

PENTA HD 57° face mill with double negative design for heavy face milling. Treated for long tool life.



SOE06Z

Universal face mill with positive design and internal coolant. Treated for long tool life.



HIGH-FEED MILLING CUTTERS

High-feed milling is a method that is increasingly being used to make machining more efficient.

Dormer Pramet's smooth cutting high-feed milling cutters are available in a range of types, such as modular, cylindrical or arbor style.

Features and benefits:

- Efficient method for productive milling.
- Several mill types to choose from.
- Feed up to 2.5 mm / z.
- Cutting depth up to 2.0 mm.



SSN11

Next generation, high-feed milling cutter for SN.. 11 inserts with internal coolant. Treated for long tool life.



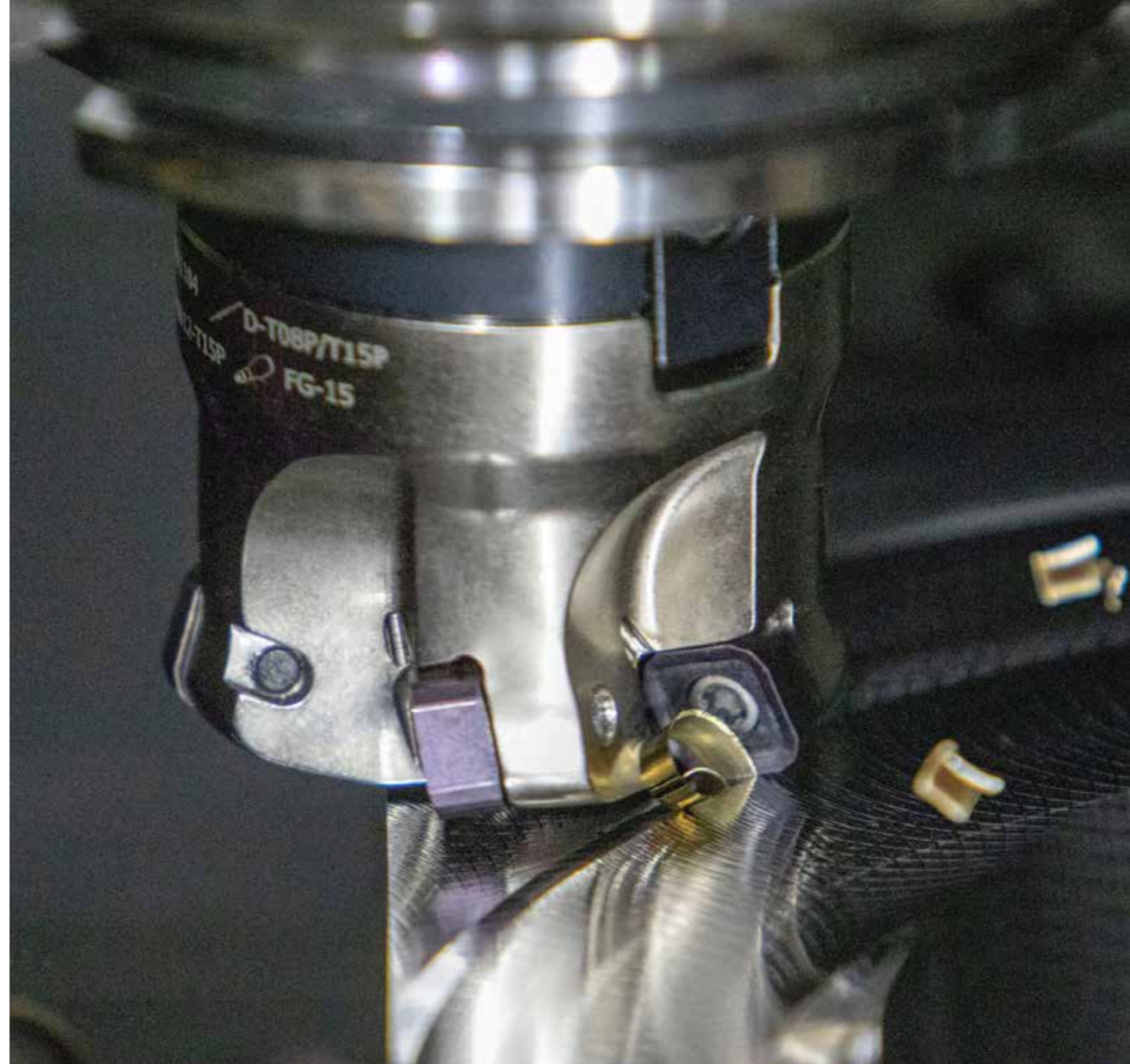
SBN10

Next generation, high-feed milling cutter for BN.. 10 inserts with internal coolant. Useful for a variety of applications.



SZD09

FEED ZD09 high-feed milling cutter with internal coolant. Treated for long tool life.



SLOT AND CHAMFER MILLING CUTTERS

Dormer Pramet offers a wide range of slot milling cutters and chamfer milling cutters made of HSS or HSS-E, and with indexable inserts.

This range also includes T-slot milling cutters, dove tail and inverted dove tail cutters and profile milling cutters.

Features and benefits:

- Wide range of both HSS and indexable milling cutters.
- Available with adjustable angle.
- Standard angles 15°-75° are also available.



COPY MILLING CUTTERS

Copy milling is often used to produce mould tools, usually made of tough tool steels.

This places stringent demands on tool geometry and coating so as to achieve the best results and tool life.

Dormer Pramet has a tried and tested range of HSS-E and solid carbide copy milling cutters, as well as indexable milling cutters.



Features and benefits:

- Solid profile milling cutters are available in several lengths in order to reach into complicated moulds.
- Indexable milling cutters offer superior performance.
- Available to accommodate insert sizes 05, 07, 10, 12, 16, 20.

2516

45° chamfer milling cutter for TCMX 16 insert with internal coolant.



C810

HSS T-slot milling cutter. The bright finish prevents workpiece material from sticking to the cutting edges of the tool.



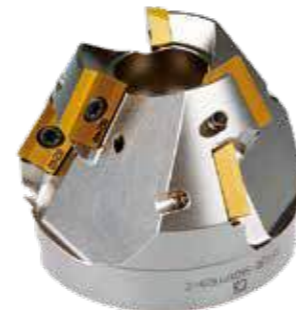
F-SCC

T-slot milling cutter for CCMX insert with internal coolant.



SXP16

Long edge chamfer milling cutter for XPHT 16 insert with internal coolant.



SRD12

Copy milling cutter for round RD.. 12 inserts with internal coolant. Treated for long tool life.



K2 SRC

Copy and profile end mills, available in cylindrical and modular style, in diameters from Ø8 to Ø32 mm. Treated for long tool life.



SVC22C

Indexable milling cutters for machining non ferrous materials, with internal coolant.



ROTARY BURRS

Solid carbide burrs are very useful tools for finishing component edges and welded joints, for example.

Our range includes carbide burrs for most applications.

Features and benefits:

- Wide range of burrs for different materials.
- Uncoated and coated variants.
- Unique overlapping cutting geometry.
- Many different shapes to cope with most applications.



P880
Set of rotary burrs in various shapes and sizes.



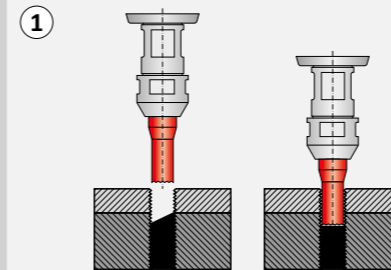
ROTARY BURRS FOR BOLT REMOVAL

1st stage rotary burr

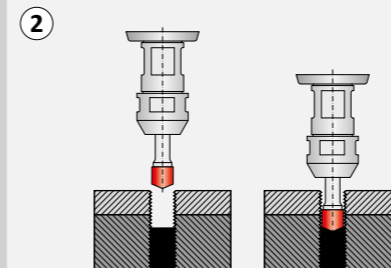
for broken bolt removal, cylinder with end cut. Used to flatten the surface of the broken bolt. Then use P101 to provide a centre for the subsequent drill. Designed with plain sides to ensure no damage to the thread.



USE



STRAIGHT CYLINDRICAL WITH ENDCUT



150° COUNTERSINK



CUTTING TYPES

HOW TO USE THE TOOL

- Select an appropriate burr size for the bolt
- Use a right-hand rotary sander
- Make sure the burr is aligned with the bolt
- File the fracture surface flat – Operation ①
- Create a centring – Operation ②

TOOL HOLDERS

Find suitable holders for your tools in our comprehensive range of tool holders.

This range includes tool holders for solid and indexable rotary tools, turning tools and all related accessories.



MORSE-FMH2



2080-CC-ER



ISO-60-MTS



VDI-B1



69871



HSK-A-CC-OZ



ACCESSORIES

We offer a very extensive range of accessories for our chucks and tool holders, such as collets of various kinds, available individually and in sets.

You will find everything you are looking for here.



ER-C



K-ER



PS-69872



AC-CC-ER



ER-C-SET-WP



RAILWAYS

We have been supplying the railway industry with products for decades thanks to over a century of experience of cutting tools for this industry.

During this time, we have developed lots of items in our range and are always introducing new ones to meet our customers' needs.

The railway industry comprises of lots of different components that need to be processed in a variety of ways. Having the right cutting tools is crucial. We offer a wide range of standard and custom turning tools for turning railway wheels and axles, as well as drilling tools and milling cutters for rails, couplings and wagon parts.



We offer lots of insert designs for dynamic rail milling.

These come in different sizes (diameters 290mm, 600mm and 900mm), with different clamping systems for use in different machine types, e.g. 600mm milling cutter diameter, suitable for the most common repair trains and rail vehicles and in different profiles.



HEAVY MACHINING

Our range of heavy-duty tools includes both turning and milling products.

We focus here on cutting the first layer of material on large cast or forged workpieces.

Larger high-volume manufacturers, material suppliers and suppliers of pretreated steel bars are our typical customers. These operations require highly reliable tools that can work in very demanding conditions.

Our extensive expertise has resulted in a broad customer base of companies that use Dormer Pramet tools to machine everything from cruise ship crankshafts to components for enormous wind turbines!

We offer a wide range of geometries for the best chip control, that provide reliable and long tool life, and fast machining of custom tools. We also specialise in offering solutions for bar peeling and scarfing operations.



GENERAL MACHINING

General machining involves machining applications that do not come under a specific industry segment, but instead encompass a broad range of machining applications.

Typical customers include small to medium-sized workshops, which normally use standard tools offering high flexibility suitable for lots of different materials.

These customers may in turn have subcontractors at two or more stages who may have their own specialist applications using CNC machines, for example. They are all looking for products offering outstanding reliability and easy, fast delivery. Some of these smaller workshops may produce large numbers of parts for a single customer, but usually they produce a wide range of parts for lots of customers, and often in small quantities.

Typically, these customers need tools offering the best possible performance with the capability to machine as many material types as possible.



REPAIR AND MAINTENANCE INDUSTRY



Repair and maintenance represents a large proportion of all applications in the machining industry and requires a wide range of cutting tools.

This is critical to keeping businesses running.

Our comprehensive repair and maintenance offering supports a wide range of applications. This includes repairing and replacing equipment and machinery in many types of industries, such as aerospace and aviation, energy, construction, and food and beverages.

Holemaking, tapping, milling, broaching, countersinking and deburring are typical product applications.

Maintenance and repair work also requires the right tools at the right time. Reliable solutions are critical if customers are to succeed on their first attempt and reduce downtime.



MANUFACTURE AND ASSEMBLY OF AIRFRAMES



We are a leading supplier of tools to the aerospace industry, for manufacturing, assembly and repair of airframes and aircraft components.

Our range is of the highest standard, and is relied on by some of the world's leading aircraft manufacturers.

Our company has more than 50 years of experience of supplying the aerospace industry thanks to our Dormer and Precision Twist Drill brands. We have significantly increased our expertise, capacity and product offering since acquiring California-based HP Wetmore Tool & Engineering in January 2019.

We specialise in rotary high-speed steel (HSS), cobalt-alloyed and carbide tools. All our tools are produced at our plants in the US and Brazil and are manufactured to National Aerospace Standards (NAS) for quality, reliability and safety.



DIE AND MOULD

We are a global supplier of tooling to the Die and Mould industry. Our assortment sets the highest standards, including the process security which is expected by die and mould makers.

Our assortment focuses on indexable and round tools, which are widely used in die and mould applications.

Within our indexable range we offer a wide choice of high-feed cutters, as well as tools for face, shoulder and importantly copy milling. Indexable drilling and boring products are also on offer.

For round tools we cover hole-making, milling and fine profiling, tapping and reaming.

With our portfolio of tools you can apply all types of operations from roughing, semi-finishing to fine finishing. Our tools are designed to cover a variety of material groups, including steels, pre-hardened and hardened steels, stainless steels, cast irons and non-ferrous alloys.

In addition, we manufacture made to order custom tools for various application needs, while offering technical advice, CAD/CAM support locally and complete customer service.



CABINET VENDING SOLUTIONS

Managing procurement and checking stock in your warehouse can be time-consuming and complicated, and does not always provide an accurate snapshot of what you actually have - or do not have - in stock.

Dormer Pramet storage cabinets provide a solution that allows you to keep track of what you have in stock and when you need to reorder items.

These storage cabinets are available in a number of variants.

Choose the one that best suits your needs.





www.dormerpramet.com
info.int@dormerpramet.com

Customer and technical support:
00 420 583 381 520
00 44 1246 571300, option 3

DORMER PRAMET

**Holemaking
Catalogue**



**Threading
Catalogue**



**Turning
Catalogue**



**Milling
Catalogue**



Website

