

DORMER PRAMET

SCARFING

2020



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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

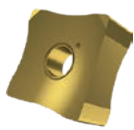
BENEFITS

- **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

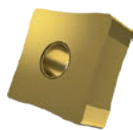
INSERT TYPES



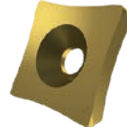
SNMX 15, 19, 25



SNMX 2512, 1507



SNMA 1506, 2509



SPUB



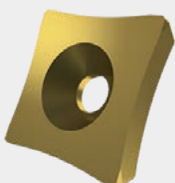
LDGN



PSR

NEW ITEMS

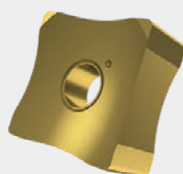
NEW



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

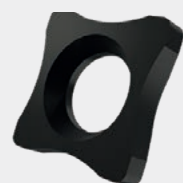
NEW



SNMA 1506

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

NEW

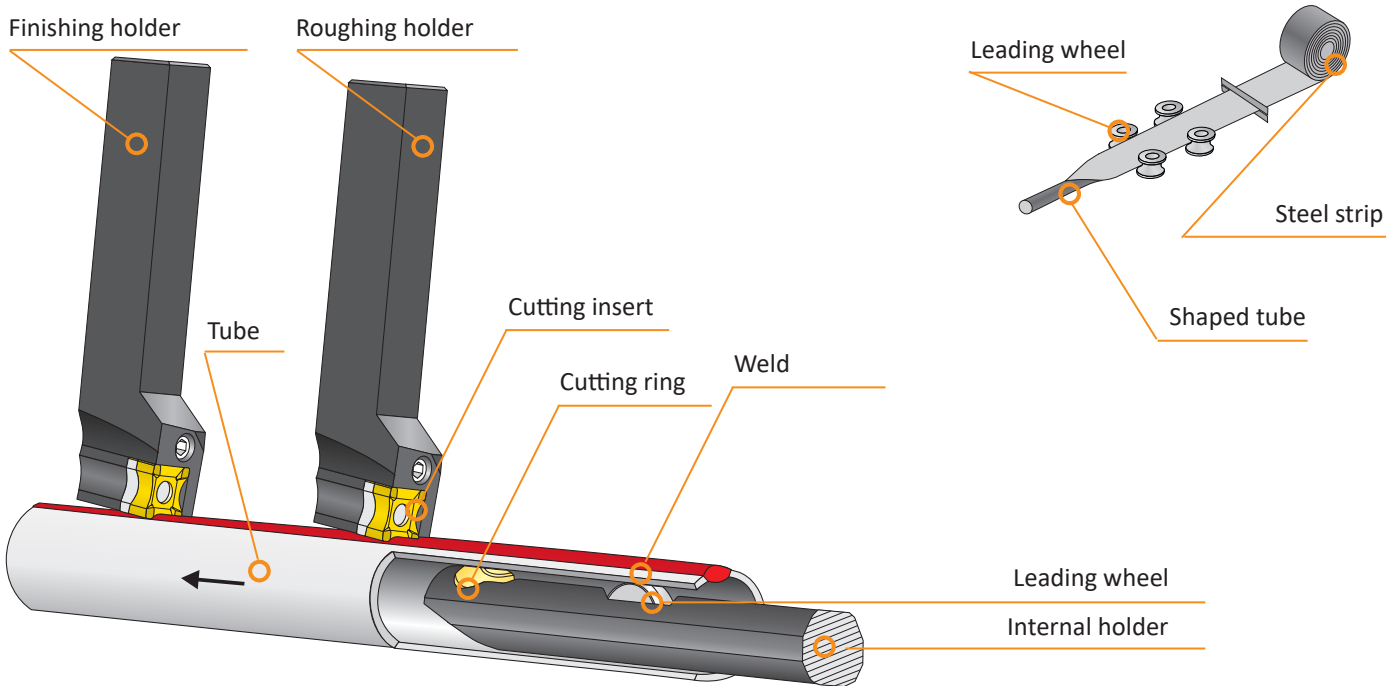


SNU

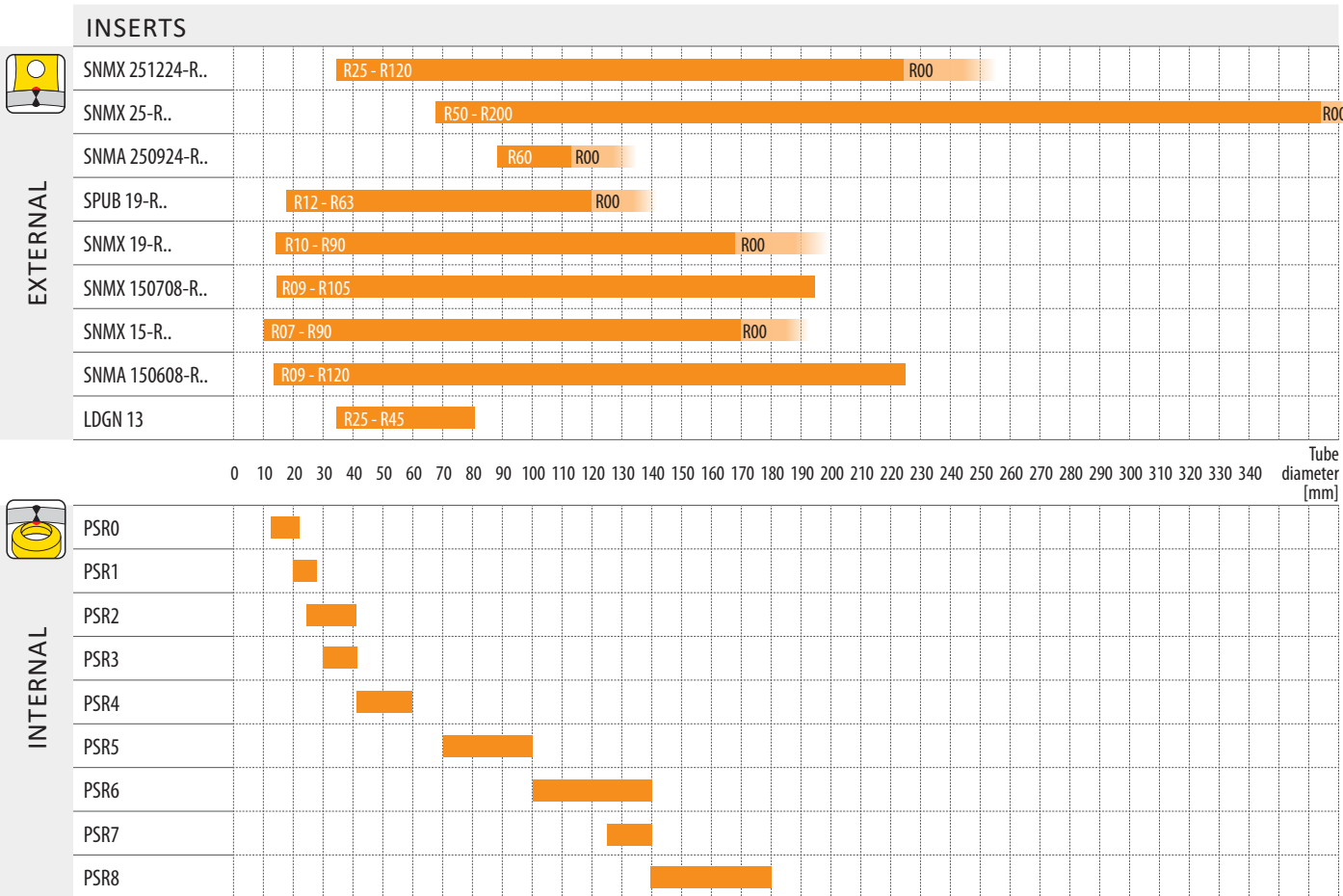
- Shims allow clamping of inserts SNMX 2512 and SNMX 1507, with concave top, into our current holders.

SCARFING

TOOLS FOR EXTERNAL AND INTERNAL TUBE WELD SCARFING



WHAT INSERT SHOULD I USE FOR MY TUBE DIAMETER ?



<

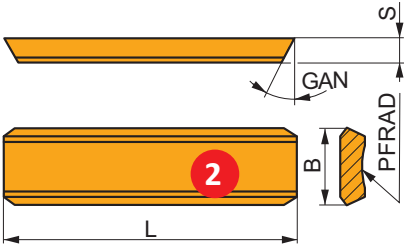
1	Designation of tool holder type	7	Achievable surface quality	13	Group of compatible inserts ²⁾
2	Material group recommendations	8	Character of cut/working conditions	14	Group of spare parts ^{2), 3)}
3	Clamping system of insert	9	Possible applications	15	Group of accessories ^{2), 3)}
4	Illustrative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

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

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

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

1 LDGN				
	L	3	B	GAN
13,05	60,00	5,00	15,00	30°



   		ISO		P	M	K	N	S	H	PFRAD	
		LDGN 130560-R25	6640							25	34-45
		LDGN 130560-R30	6640							30	41-54
		LDGN 130560-R35	6640							35	48-63
		LDGN 130560-R40	6640							40	51-63
		LDGN 130560-R45	6640							45	51-63

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

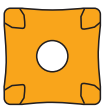
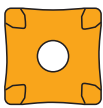
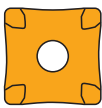
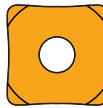
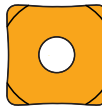
Icons - scarfing holders

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

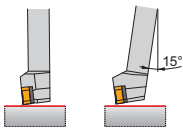
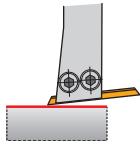
Icons and symbols - inserts

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

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				

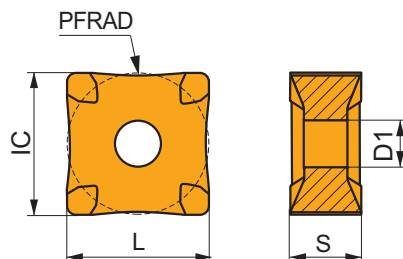
NAVIGATOR - TOOLS

PXFN(RL) EXT		XLCD(N) EXT	
			
			
 18		 19	
 10-15		 16	

SNMX 15-R



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



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

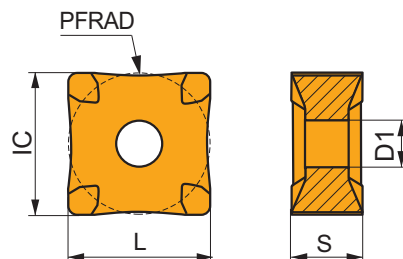


20°

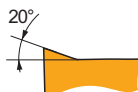
SNMX 19-R

PRAMET

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



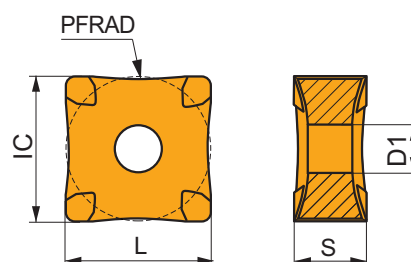
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		SNMX 19-R00	T9335	■	■					0	0-0
		SNMX 19-R10	T9335	■	■					10	14-18
			6640	■	■					10	14-18
		SNMX 19-R12	T9335	■	■					12	16-21
			6640	■	■					12	16-21
		SNMX 19-R15	T9335	■	■					15	20-27
			6640	■	■					15	20-27
		SNMX 19-R18	T9335	■	■				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



SNMX 25-R



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

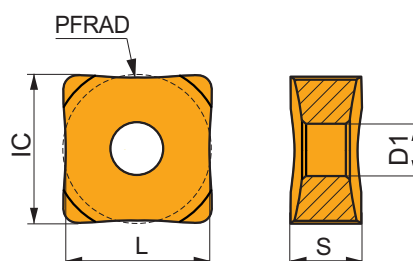


i		ISO		P	M	K	N	S	H	PFRAD	ODW
		SNMX 25-R00	T9335	■	■					0	0-0
		SNMX 25-R50	T9335	■	■					50	68-90
		SNMX 25-R80	T9335	■	■					80	118-150
			6640	■	■					80	118-150
		SNMX 25-R100	T9335	■	■					100	148-188
			6640	■	■					100	148-188
		SNMX 25-R120	T9335	■	■					120	178-225
			6640	■	■					120	178-225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

SNMX 1507-R



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

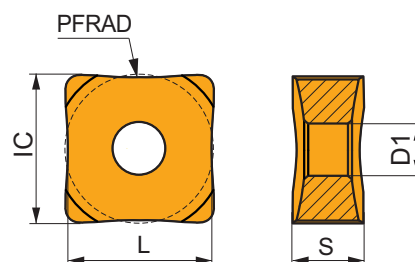


i		ISO		P	M	K	N	S	H	PFRAD	ODW
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		SNMX 150708-R11	6640	■	■					11	16-19
		SNMX 150708-R13	6640	■	■					13	19-23
		SNMX 150708-R15	6640	■	■					15	22-27
		SNMX 150708-R18	6640	■	■					18	26-32
		SNMX 150708-R20	6640	■	■					20	29-36
		SNMX 150708-R22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

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

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



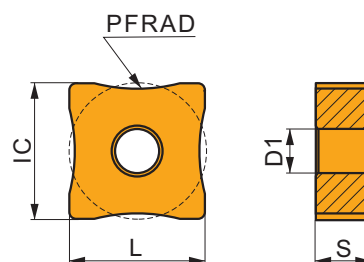


         	ISO								PFRAD	
	SNMX 251224-R00	T9335	■	■					0	0-0
	SNMX 251224-R25	T9335	■	■					25	34-45
	SNMX 251224-R30	T9335	■	■					30	41-54
	SNMX 251224-R35	T9335	■	■					35	48-63
	SNMX 251224-R40	T9335	■	■					40	54-72
	SNMX 251224-R55	T9335	■	■					55	81-103
	SNMX 251224-R80	T9335	■	■					80	118-150
	SNMX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

SNMA 1506-R



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

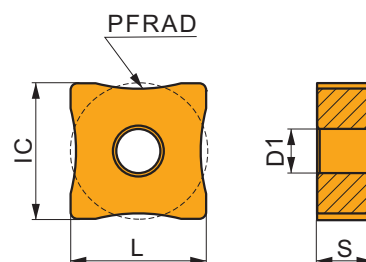


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		SNMA 150608-R11	6640	■	■					11	16-20
		SNMA 150608-R13	6640	■	■					13	19-24
		SNMA 150608-R15	6640	■	■					15	22-28
		SNMA 150608-R18	6640	■	■					18	27-33
		SNMA 150608-R20	6640	■	■					20	30-37
		SNMA 150608-R22	6640	■	■					22	33-41
		SNMA 150608-R25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

SNMA 2509-R

PRAMET

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

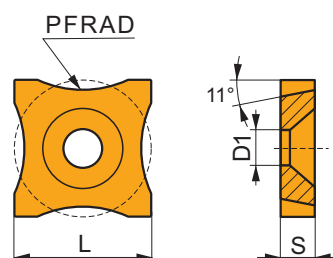


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   		SNMA 250924-R00	T9335							0	0-0
		SNMA 250924-R60	T9335							60	89-112

SPUB 19-R

PRAMET

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

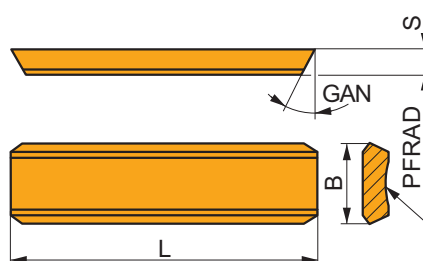


* This insert has 11° positive clearance all around.

LDGN

PRAMET

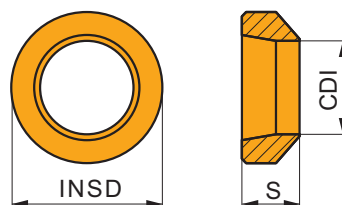
	L	S	B	GAN
13,05	60,00	5,00	15,00	30°



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

PSR

PRAMET



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

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

* rings deviating from standard dimension

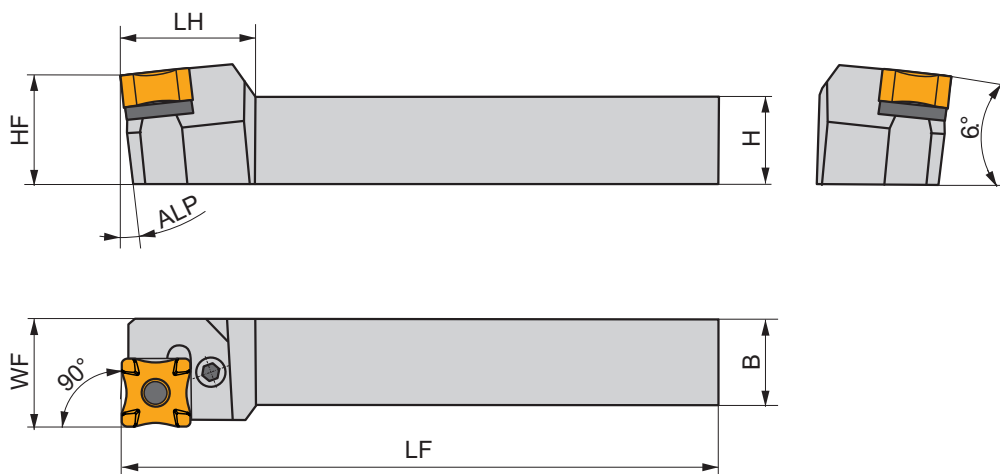
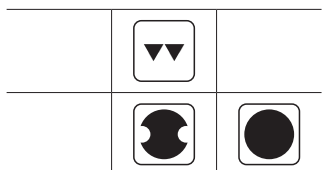
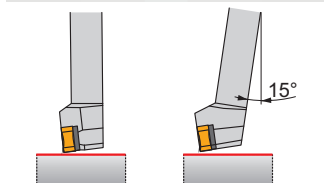
* INSD, S - modification

PXFN(RL)



PRAMET

P



	H	B	HF	WF	LF	LH	ALP	kg			
	[mm]	[mm]		[mm]	[mm]	[mm]	[°]				
PXFNR/L 2525 R 15	25	25	25	25	200	40	6	1,05	GI185	PX 40	AT009
PXFNR/L 2525 S 19	25	25	25	25	250	45	6	1,3	GI186	PX 50	-
PXFNR/L 3232 S 25	32	32	40	40	250	50	6	2,2	GI199	PX 60	AT010
PXFNR/L 2525 R 15/15	25	25	25	25	200	40	20	1,05	GI185	PX 40	AT009
PXFNR/L 2525 S 19/15	25	25	25	25	250	50	20	1,3	GI186	PX 50	-

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

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

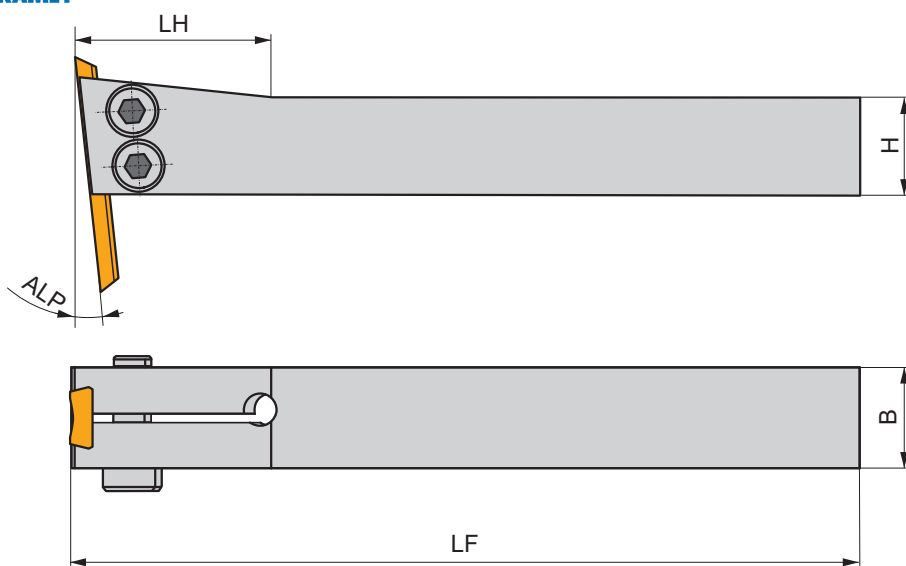
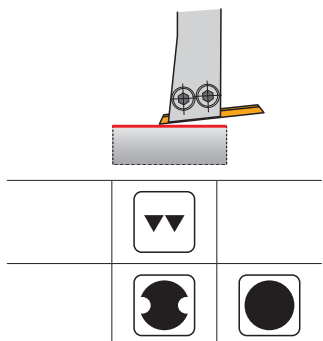
AT009	SNMX 150708-R..	SNU 150410-CX
AT010	SNMX 251224-R..	SNU 250524-CX

XLCDN



P

PRAMET



	H	B	LF	LH	ALP	kg	GI187	PX10
	[mm]	[mm]	[mm]	[mm]	[°]			
XLCDN 2525 R 15	25	25	200	50	6	1,10	GI187	PX10

GI187	LDGN 130560...
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PX10	HS 0825	M8	25	HXK 6
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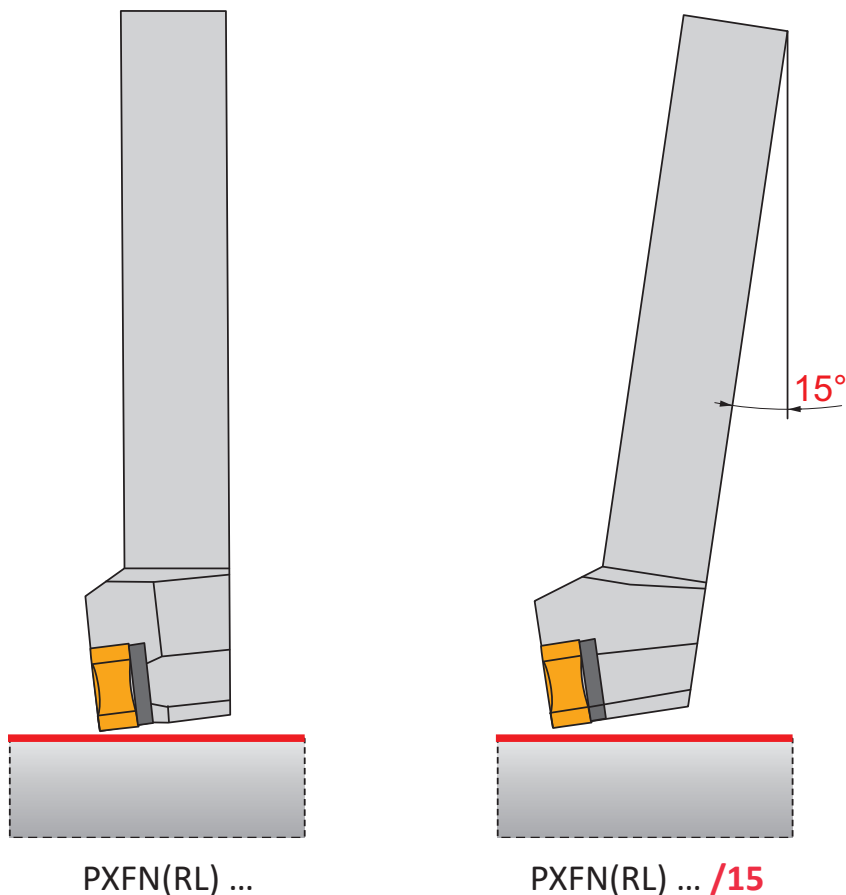
TECHNICAL INFORMATION

GRADES FOR SCARFING

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

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

PXFN(RL) - VARIOUS HOLDERS ACCORDING TO HEAD INCLINATION



LDGN – INSERTS SUITABLE FOR REGRINDING

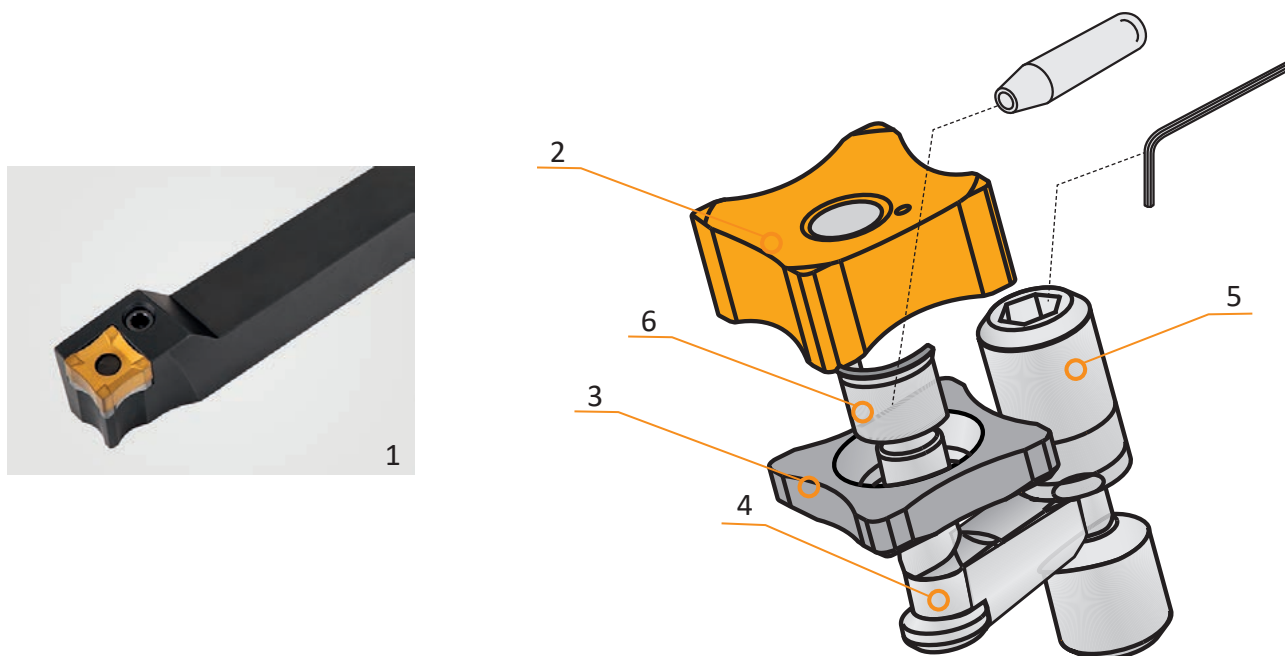


Offers long tool life due to total length of insert (60mm), which can be ground several times to a minimum length of 25mm.

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

Suitable for small cross section of scarf.

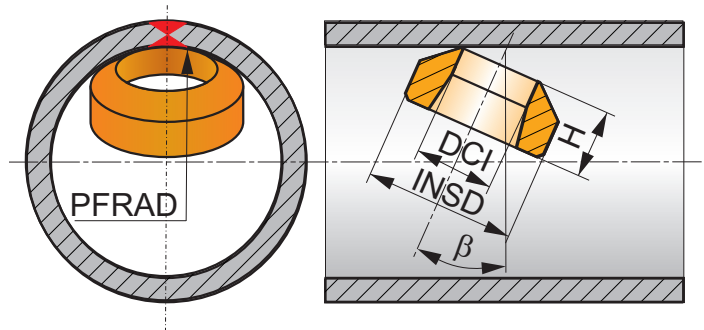
PXFN(RL) - VARIOUS SPARE PARTS ACCORDING TO INSERT SHAPE



1	2	3	4	5	6	7	8
PXFN(RL) 2525 R 15 PXFN(RL) 2525 R 15/15							
							
PXFN(RL) 2525 S 19 PXFN(RL) 2525 S 19/15							
							
PXFN(RL) 3232 S 25							
							

SCARFING RINGS - HOW TO CALCULATE WORKING RADIUS PFRAD

Working radius PFRAD circle of osculatory DCI



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

DCI - internal rings diameter

β - angle of ring rotation

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

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