



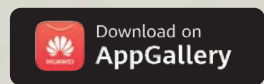
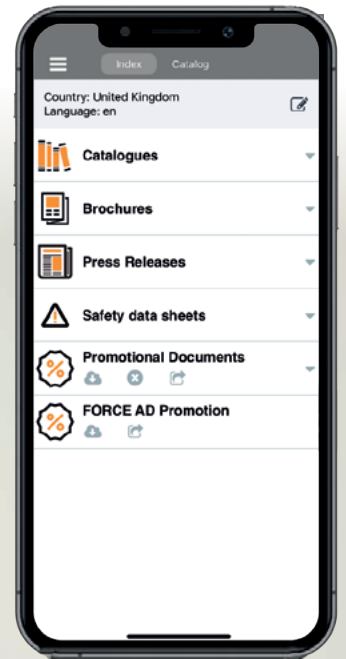
# DORMER PRAMET



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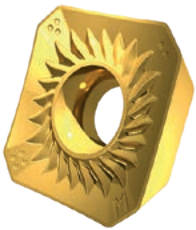
SSD13F

## VERSATILE FACE MILLING

### INTRODUCTION



A new face milling assortment for general engineering and maintenance, repair and operations has been launched. The latest Pramet range includes two economical and precise inserts (SDMT and SDET) for depths of cut up to 6.4 mm. Several geometries and cutters are available for machining a wide range of materials.



SDMT-M

- Versatile pressed insert
- Steels, cast irons and hard steels
- Medium cuts



SDMT-R

- Versatile pressed insert
- Steels, cast irons and hard steels
- Rough cuts



## MILLING CUTTERS AND INSERTS

### INSERTS FEATURES & BENEFITS

Application-specific geometries and grades.

**EASY TO SELECT AND USE**  
for a wide range of workpiece materials.

Geometries M and R on economical pressed insert (SDMT 13).

**LIGHT, MEDIUM AND ROUGH CUTS**  
in steels, cast irons and hard steels.

Sharp geometry F on precision ground insert (SDET 13).

**SECURE AND SAFE**  
machining in stainless steels and heat resistant super alloys (HRSA).

Polished and extra sharp geometry FA on specific ground insert (SDET 13).

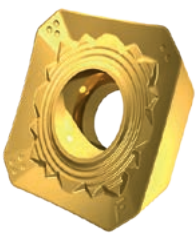
**PRODUCTIVE MILLING**  
in non-ferrous materials.

Wide wiper edge design on all geometries.

**HIGH SURFACE QUALITY**  
across multiple applications, from heavy roughing to finishing.

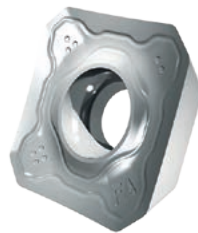
Additional wiper insert XDET 13 available.

**PRODUCTIVE AND HIGH SURFACE QUALITY**  
in larger diameter cutters.



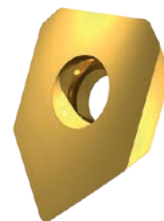
**SDET-F**

- Precision ground insert
- Stainless steels & HRSA
- Light to medium cuts



**SDET-FA**

- Precision ground insert
- Non-ferrous materials
- Light to rough cuts



**XDET**

- Wiper insert
- Steels, cast irons, stainless steels
- High quality surface finish



## SSD13F

## VERSATILE FACE MILLING

### CUTTERS SSD13F – FEATURES & BENEFITS

Weldon and shell-style cutters in diameters 32 – 250 mm (1.25 – 10.00 inch).



**MULTIPLE CHOICES**  
for a wide range of machine sizes.

Carbide shim on cutter seating place.

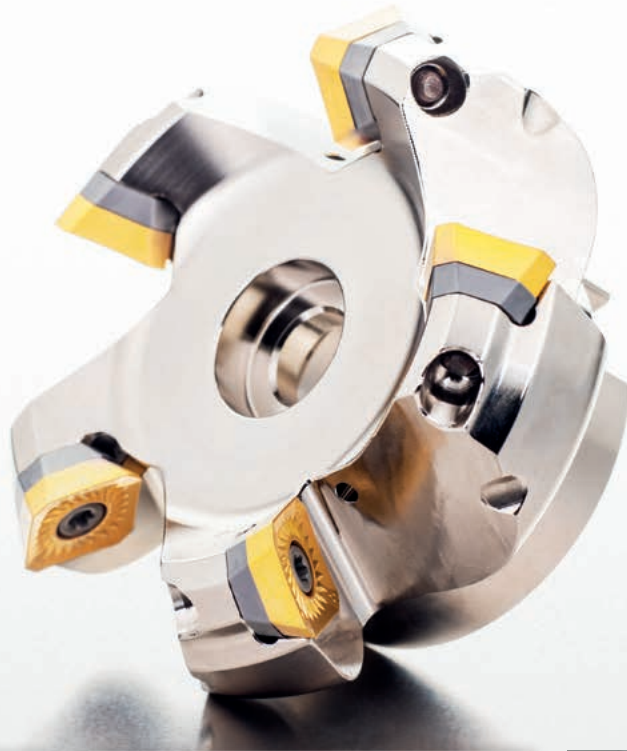


**EXTRA PROTECTION FOR HIGH DURABILITY**  
of cutter body, while providing insert stability and process security.

Internal coolant on entire assortment, including large-sized diameters.



**IMPROVED TOOL LIFE**  
and better chip evacuation, providing high surface quality and reliability.





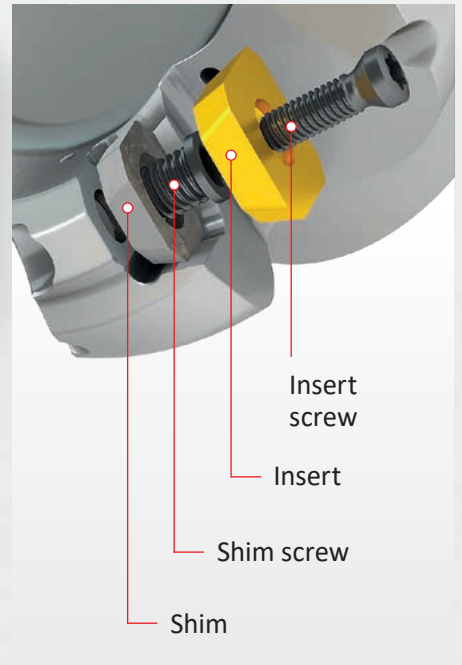
SSD13F

- Weldon shank
- DC range  
32 – 40 mm  
1.25 – 1.50 inch




SSD13F

- Shell body
- DC range  
40 – 250 mm  
1.50 – 10.00 inch





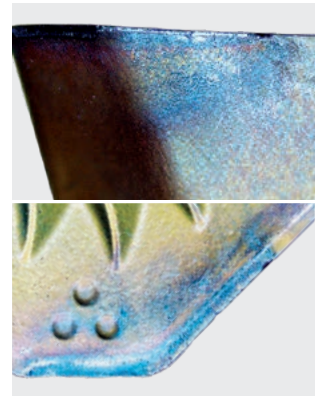
## MILLING CUTTERS AND INSERTS

### FACE MILLING EXAMPLES

Workpiece: Carbon steel plate (215 HB)  
 Material: 1.1191 / C45  
 Cutter: 63A05R-S45SD13F-C  
 Coolant: Compressed air

Cutting conditions			
$v_c$ (m/min)	$f_z$ (mm)	$a_p$ (mm)	$a_e$ (mm)
250	0.25	2	50
Insert geometry			Tool life (min)
SDMT 13T3AFSN-M:M8330			97

SDMT 13T3AFSN-M:M8330, 97 min

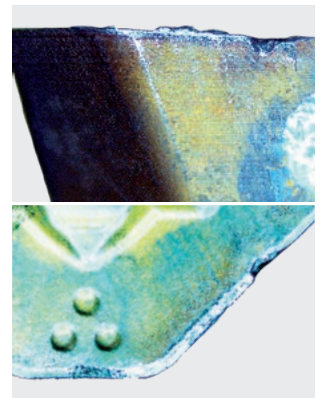


WMG P2.2

Workpiece: Stainless steel plate (145 HB)  
 Material: 1.4404 / 316L  
 Cutter: 63A05R-S45SD13F-C  
 Coolant: Compressed air

Cutting conditions			
$v_c$ (m/min)	$f_z$ (mm)	$a_p$ (mm)	$a_e$ (mm)
120	0.15	2	50
Insert geometry			Tool life (min)
SDET 13T3AFSN-F:M6330			42

SDET 13T3AFSN-F:M6330, 42 min

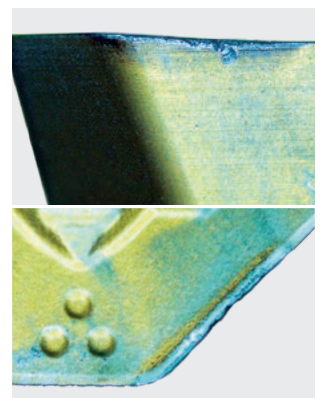


WMG M3.1

Workpiece: Stainless steel plate (145 HB)  
 Material: 1.4404 / 316L  
 Cutter: 63A05R-S45SD13F-C  
 Coolant: Soluble oil emulsion (~ 10%)

Cutting conditions			
$v_c$ (m/min)	$f_z$ (mm)	$a_p$ (mm)	$a_e$ (mm)
80	0.15	2	50
Insert geometry			Tool life (min)
SDET 13T3AFSN-F:M6330			100

SDET 13T3AFSN-F:M6330, 100 min

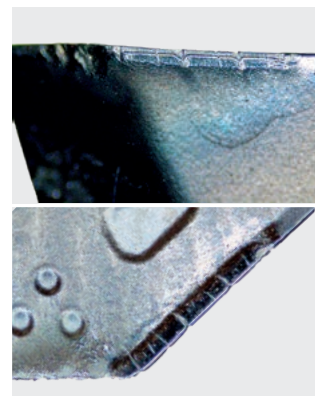


WMG M3.1

Workpiece: Cast iron plate (205 HB)  
 Material: GG25 / FC250  
 Cutter: 63A05R-S45SD13F-C  
 Coolant: Compressed air

Cutting conditions			
$v_c$ (m/min)	$f_z$ (mm)	$a_p$ (mm)	$a_e$ (mm)
300	0.4	2	50
Insert geometry			Tool life (min)
SDMT 13T3AFSN-R:M5315			42

SDMT 13T3AFSN-R:M5315, 42 min



WMG K1.2



# SSD13F



PRAMET

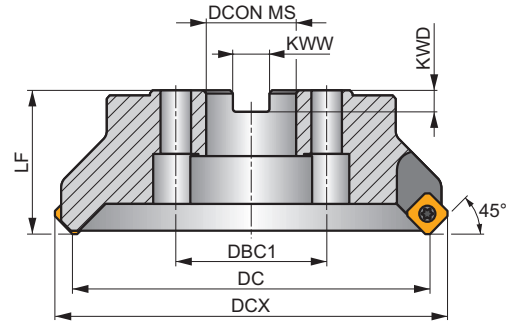
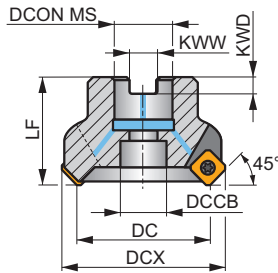
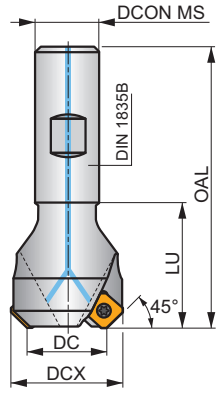
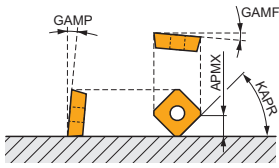
S



## VER SD13 45° Face Mill with Positive Design and Internal Coolant

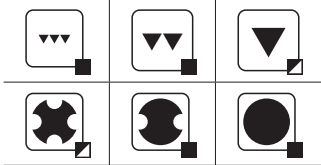
Highly versatile 45° face mill utilising single sided SD.. 13 style inserts with APMX of 6.4 mm. Suited for a wide range of applications in any workpiece material. Weldon and arbor style available, with differential tooth pitch. Body treated for longer tool life, carbide shims on seating place for process security.

KAPR	45°
APMX	6.4 mm



DC 40 – 125 mm

DC 160 – 250 mm



	0.04 - 0.32
	0.04 - 0.28



Product	DC	DCX	OAL	DCON MS	DCCB	DBC1	LU	LF	KWW	KWD	GAMF	GAMP	max.		kg	Material				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
32N3R045B25-SSD13F-C	32	44.9	120	25	-	-	45	-	-	-	-15	15	3	-	16100	✓	0.43	GI341	C0610	-
40N3R045B32-SSD13F-C	40	53.5	120	32	-	-	45	-	-	-	-7	15	3	-	14400	✓	0.72	GI341	C0610	-
40A03R-S45SD13F-C	40	53.5	-	16	14	-	-	40	8.4	5.6	-7	15	3	-	14400	✓	0.27	GI341	C0611	-
50A04R-S45SD13F-C	50	63.5	-	22	18	-	-	40	10.4	6.3	-7	15	4	✓	12900	✓	0.51	GI341	C0612	-
63A05R-S45SD13F-C	63	76.4	-	22	18	-	-	40	10.4	6.3	-7	15	5	✓	11500	✓	0.53	GI341	C0612	-
80A07R-S45SD13F-C	80	93.4	-	27	22	-	-	50	12.4	7	-7	15	7	✓	10200	✓	1.32	GI341	C0613	AC001
100A08R-S45SD13F-C	100	112.9	-	32	45	-	-	50	14.4	8	-12	15	8	✓	9100	✓	1.83	GI341	C0613	AC002
100A10R-S45SD13F-C	100	112.9	-	32	45	-	-	50	14.4	8	-12	15	10	-	9100	✓	1.94	GI341	C0613	AC002
125A08R-S45SD13F-C	125	137.8	-	40	56	-	-	63	16.4	9	-12	15	8	✓	8100	✓	3.41	GI341	C0613	AC003
125A12R-S45SD13F-C	125	137.8	-	40	56	-	-	63	16.4	9	-12	15	12	-	8100	✓	3.31	GI341	C0613	AC003
160C10R-S45SD13F-C	160	172.8	-	40	-	66.7	-	63	16.4	9	-12	15	10	✓	7200	✓	6.69	GI341	C0614	-
160C14R-S45SD13F-C	160	172.8	-	40	-	66.7	-	63	16.4	9	-12	15	14	✓	7200	✓	6.62	GI341	C0614	-
200C12R-S45SD13F-C	200	212.8	-	60	-	101.6	-	63	25.7	14	-12	15	12	✓	6400	✓	9.06	GI341	C0615	-
200C16R-S45SD13F-C	200	212.8	-	60	-	101.6	-	63	25.7	14	-12	15	16	✓	6400	✓	11.85	GI341	C0615	-
250C14R-S45SD13F-C	250	262.8	-	60	-	101.6	-	63	25.7	14	-12	15	14	✓	5700	✓	19.50	GI341	C0616	-
250C20R-S45SD13F-C	250	262.8	-	60	-	101.6	-	63	25.7	14	-12	15	20	✓	5700	✓	19.20	GI341	C0616	-

GI341	SDET 13T3..	SDMT 13T3..
		XDET 13T3..



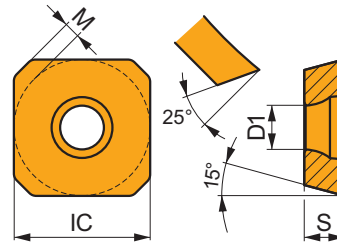
CO610	US 63513-T15P	3.0	M 3.5	13	Flag T15P	–	–	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
CO611	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 0830C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
CO612	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HSD 1025C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
CO613	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
CO614	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1240C	SDW 1103AF	MS 3507	HXK 3.5	CAC 160C	HSD 0825C	HXK 5
CO615	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 200C	HSD 1025C	HXK 7
CO616	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 250C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

## SDET 13

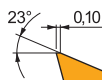


	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
13T3	13.385	4.40	1.5	3.97



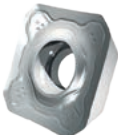
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



F geometry is sharp and used for finishing, suitable for large overhang or thin walled and slim workpiece applications. Designed with highly positive rake, narrow T-land and rounding of cutting edge for light machining.

SDET 13T3AFSN-F	M6330	–	■	250	0.15	3.0	■	175	0.14	3.0	–	–	–	–	–	–	■	70	0.11	2.4	–	–	–		
	M8310	–	■	315	0.15	3.0	■	160	0.14	3.0	■	295	0.15	3.0	–	–	–	–	–	–	–	–	–		
	M8330	–	■	285	0.15	3.0	■	170	0.14	3.0	■	270	0.15	3.0	■	855	0.18	3.0	■	70	0.11	2.4	–	–	–
	M8340	–	■	265	0.15	3.0	■	155	0.14	3.0	■	250	0.15	3.0	–	–	–	■	65	0.11	2.4	–	–	–	
	M9340	–	■	330	0.15	3.0	■	195	0.14	3.0	–	–	–	–	–	–	–	■	80	0.11	2.4	–	–	–	



FA geometry is sharp and used for non-ferrous alloys machining, suitable for large overhang or thin walled and slim workpiece applications. Polished and ground design with highly positive rake.

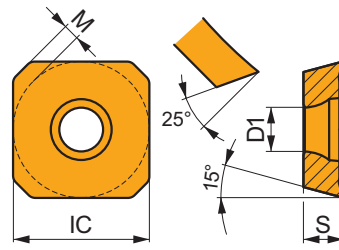
SDET 13T3AFFN-FA	HF7	–	■	–	–	–	–	–	–	–	–	–	–	■	360	0.12	3.0	–	–	–	–	–	–
	M0315	–	■	–	–	–	–	–	–	–	–	–	–	■	840	0.12	3.0	–	–	–	–	–	–



# SDMT 13

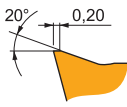


	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
13T3	13.385	4.40	1.5	3.97



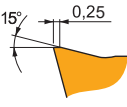
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



M geometry is versatile and the first choice for a wide range of working conditions. Designed with positive rake, medium T-land and rounding of cutting edge for medium machining.

<b>SDMT 13T3AFSN-M</b>	<b>8215</b>	–	■	245	0.30	3.0	☑	145	0.27	3.0	■	230	0.30	3.0	–	–	–	☑	60	0.24	2.4	■	45	0.21	1.0
	<b>M6330</b>	–	■	215	0.30	3.0	■	150	0.27	3.0	–	–	–	–	–	–	–	■	60	0.24	2.4	–	–	–	
	<b>M8330</b>	–	■	245	0.30	3.0	■	145	0.27	3.0	■	230	0.30	3.0	–	–	–	■	60	0.24	2.4	☑	45	0.21	1.0
	<b>M8340</b>	–	■	225	0.30	3.0	■	135	0.27	3.0	☑	210	0.30	3.0	–	–	–	–	55	0.24	2.4	–	–	–	
	<b>M9325</b>	–	■	295	0.30	3.0	–	–	–	–	■	280	0.30	3.0	–	–	–	–	–	–	–	☑	55	0.21	1.0
	<b>M9340</b>	–	■	265	0.30	3.0	■	155	0.27	3.0	–	–	–	–	–	–	–	■	65	0.24	2.4	–	–	–	



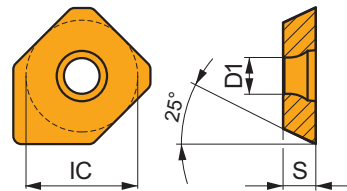
R geometry is strong and used for roughing and heavy working conditions. Designed with slightly positive rake, wide T-land and rounding of cutting edge for rough machining.

<b>SDMT 13T3AFSN-R</b>	<b>M5315</b>	–	☑	285	0.35	3.0	–	–	–	–	■	270	0.35	3.0	–	–	–	–	–	–	■	55	0.25	1.0
	<b>M8310</b>	–	■	255	0.35	3.0	☑	130	0.32	3.0	■	240	0.35	3.0	–	–	–	–	–	–	■	50	0.25	1.0
	<b>M8330</b>	–	■	240	0.35	3.0	☑	140	0.32	3.0	■	225	0.35	3.0	–	–	–	–	–	–	☑	45	0.25	1.0
	<b>M8340</b>	–	■	220	0.35	3.0	☑	130	0.32	3.0	☑	205	0.35	3.0	–	–	–	–	–	–	–	–	–	–
	<b>M9325</b>	–	■	280	0.35	3.0	–	–	–	–	■	265	0.35	3.0	–	–	–	–	–	–	☑	55	0.25	1.0

# XDET 13



	IC	D1	S
	(mm)	(mm)	(mm)
13T3	13.385	4.40	3.97



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



Wiper design for improved surface finish when machining with large cutters and high feed rates.

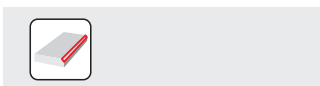
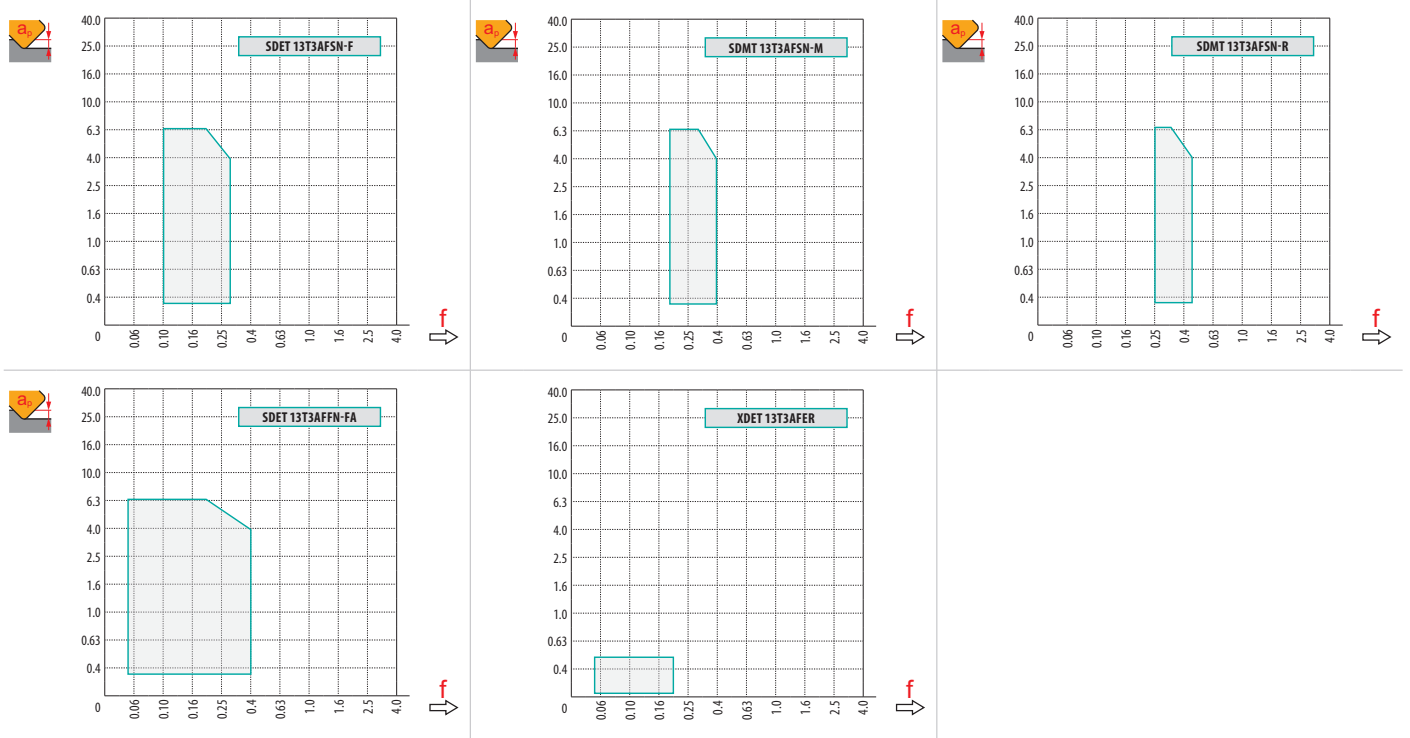
<b>XDET 13T3AFER</b>	<b>8215</b>	–	■	420	0.10	0.2	☑	250	0.09	0.2	■	395	0.10	0.2	–	–	–	–	–	–	–	–	–	–
	<b>M8330</b>	–	■	395	0.10	0.2	☑	235	0.09	0.2	■	375	0.10	0.2	–	–	–	–	–	–	–	–	–	–



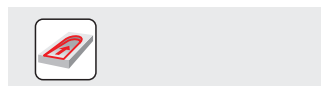


$a_s$ / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

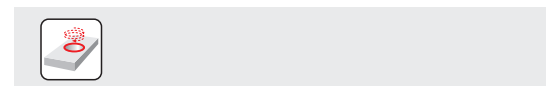
	SDET 13-F	SDMT 13-M	SDMT 13-R	SDET 13-FA	XDET 13
	-	-	-	-	-
	1.75	1.75	1.75	1.75	8.19



DC	X.V	$f_{max}$
32	1.22	0.15
40	1.26	0.16
50	1.30	0.18
63	1.34	0.20
80	1.39	0.22
100	1.43	0.24
125	1.48	0.26
160	1.53	0.29
200	1.58	0.33
250	1.63	0.36



DC	RPMX	APMX/II
32	14.1°	6.4/27
40	11.8°	6.4/32
50	9.8°	6.4/39
63	7.7°	6.4/49
80	5.2°	6.4/72
100	4.1°	6.4/91
125	3.2°	5.45/100
160	1.0°	1.6/100
200	0.4°	0.55/100
250	0.3°	0.4/100



DC	DMIN	DMAX	$f_{SMAX}^{DMIN}$	$f_{SMAX}^{DMAX}$
32	60.0	89.8	1.7	1.7
40	75.0	107.0	1.7	1.7
50	94.0	127.0	1.7	1.7
63	120.0	152.8	1.7	1.7
80	155.0	186.8	1.7	1.7
100	193.0	225.8	1.7	1.7
125	245.0	275.6	1.7	1.7
160	322.0	345.6	1.7	1.7
200	405.0	425.6	1.7	1.7
250	505.0	525.6	1.7	1.7



1.5
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