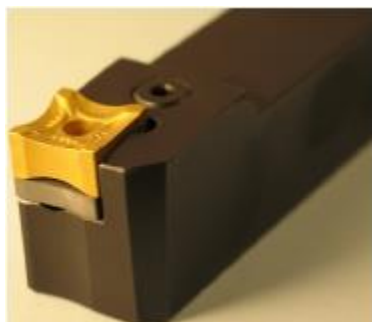


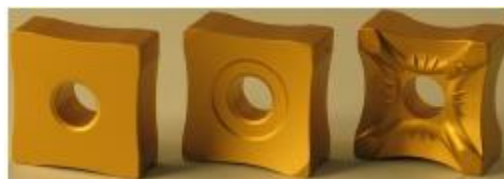


EXTERNAL SCARFING SOLUTIONS FROM STE

Our standard OD scarfing inserts are the SNMX range with 8 cutting edges. The range includes negative and positive cutting geometries and also SNMG type(our series 04). Inserts are offered in both standard and premium carbide grades. We have an insert for all materials and applications.



8 CUTTING EDGES



DIFFERENT GEOMETRIES



DIFFERENT SIZES

INSERTS AND SPARE PARTS KITS

	SNMX25...-03	SNMX25...-02	SNMX19...-04	SNMX19...-02	SNMX15...-04	SNMX15...-02
	PSX325.10	PSX325.11	PSX319.10	PSX319.11	PSX315.10	PSX315.11
PL116	PL116	PL115	PL114	PL113	PL113	PL113
V05	V05	V04	V04	V03	V03	V03

FIXING SYSTEM FOR SNMX INSERTS

SNMX GEOMETRY TYPES



PRODUCT CODE IDENTIFICATION

e.g.: SNMX 150705-02 M813G R.20

- 15 – insert edge length 15x15mm
- 07 – insert thickness 7mm
- 05 – insert corner r=0.5mm
- 02 – insert type "02"
- M813G – carbide grade
- R.20 – radius of the cutting edge

TYPE OF INSERT SELECTION

INSERT TYPE	INSERT SIZE	GRADE M813G	GRADE C912G	GRADE P712G	GRADE P812G	BACK PLATE TYPE	RADIUS RANGE
01 - NEGATIVE							
SNMX150605-01	15mm	•		•		FLAT	R7 - R100
SNMX190708-01	19mm	•		•		FLAT	R10 - R100
SNMX250924-01	25mm		•	•		FLAT	R50 - R200
02 - POSITIVE							
SNMX150705-02	15mm	•			•	CURVED	R7 - R100
SNMX190912-02	19mm	•		•		CURVED	R10 - R100
SNMX251224-02	25mm		•	•		CURVED	R50 - R200
03 - POSITIVE WITH CHIP BREAKER							
SNMX150705-03	15mm			•		FLAT	R20 - R60
SNMX250924-03	25mm			•		FLAT	up to R200
04 - POSITIVE (SNMG TYPE)							
SNMX150705-04	15mm	•			•	FLAT	R7 - R100
SNMX190808-04	19mm	•		•		FLAT	R9 - R100
05 - SUPER POSITIVE							
SNMX150705-05	15mm	•				CURVED	R9 - R60

M813G; C912G - STANDARD CARBIDE GRADES

P712G; P812G - PREMIUM CARBIDE GRADES

RADIUS CHOICE

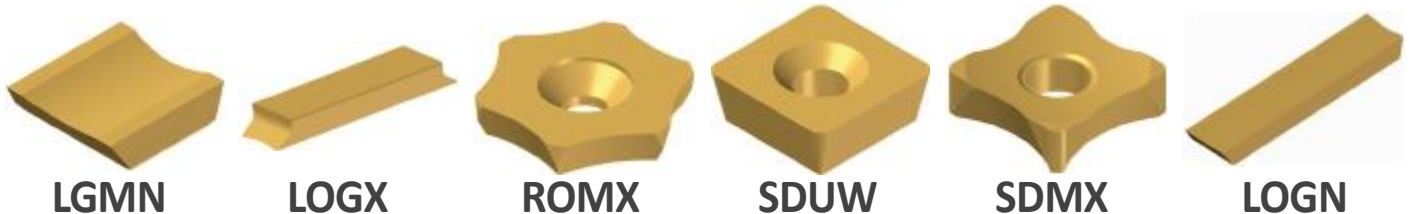
The recommended radius for specific tube diameter can be found in the tables below. This is only a guide as customers may have specific preferences that mean slight variations in selection.



TUBE DIAMETER		RADII
NEGATIVE TYPE	POSITIVE TYPE	
MIN÷MAX	MIN÷MAX	
8÷13.5	8÷13.5	7
13.5÷17	12.5÷16	9
17÷21	16÷20	11
21÷25	20÷24	13
25÷29	24÷28	15
29÷35	28÷33	18
35÷39	32÷37	20
39÷43	37÷41	22
43÷49	41÷45	25

TUBE DIAMETER		RADII
NEGATIVE TYPE	POSITIVE TYPE	
MIN÷MAX	MIN÷MAX	
49÷53	45÷50	27
53÷59	50÷54	30
59÷69	54÷62	35
69÷79	62÷70	40
79÷89	70÷78	45
89÷99	78÷85	50
99÷149	85÷120	75
149÷198	120÷150	100

OTHER SOLUTIONS FOR EXTERNAL SCARFING



LGMN

LOGX

ROMX

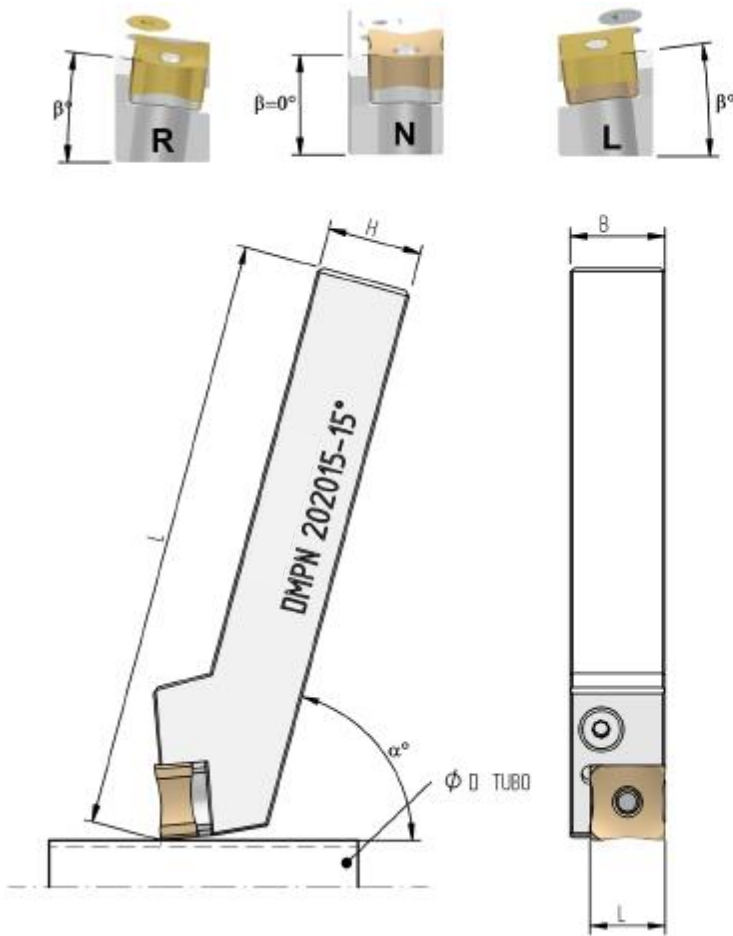
SDUW

SDMX

LOGN

External scarfing

SNMX TOOLHOLDERS



TOOLHOLDERS DIMENSIONS TABLE

TOOLHOLDER CODE		BxH	L	SUITABLE INSERT	
DMP N/R/L	202015-90	20x20	125	SNMX 15	
DMP N/R/L	202015-75				
DMP N/R/L	252515-90	25x25	150		SNMX 19
DMP N/R/L	252515-75				
DMP N/R/L	323219-75	32x32	170	SNMX 25	
DMP N/R/L	323225-75				

In addition to standard tool holders we can offer custom made versions to suit specific requirements. In this case please provide details from the table below.

DIMENSIONS	DESCRIPTION
B	SHANK WIDTH
H	SHANK HEIGHT
L	SHANK LENGTH
15/19/25	INSERT DIMENSIONS
β°	TOP RAKE ANGLE
α°	HEAD INCLINATION (75 or 90) ^o
R/N/L	DIRECTION (RIGHT/NEUTRAL/LEFT)

OTHER TUBE PROCESSING APPLICATIONS

We offer a wide range of other tube machining/processing inserts and tool holders. This includes edge milling for large diameter HF and SAW mills, end chamfering and custom designed solutions for special demands.

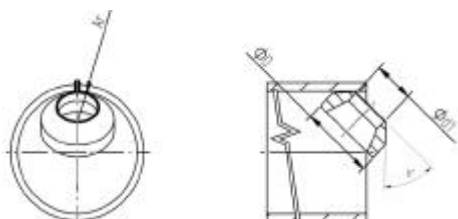


Internal scarfing

CUTTING RINGS



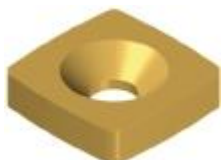
STE offers the full range of hard metal rings for internal scarfing which are available in two angles: 42° (general purpose) and 48° (Aluminized tubes), available in different carbide grades and coatings



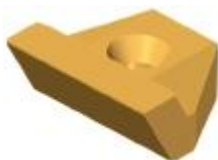
CODE	WORKING RANGE	D
SR0 AR4,5	14÷17	8
SR0 AR5,5	16÷17	
SR0 AR6,0	16÷19	10
SR0 AR6,5	17÷20	
SR1 AR07	20÷22	13
SR1 AR08	22÷24	
SR1 AR09	24÷26	19
SR2 AR10	26÷28	
SR2 AR11	28÷30	
SR2 AR12	30÷34	

CODE	WORKING RANGE	D
SR3 AR14	32÷41	22
SR3 AR17	41÷50	
SR4 AR23	48÷72	30
SR5 AR25	70÷85	35
SR5 AR28	85÷100	
SR6 AR30	90÷110	45
SR6 AR34	100÷130	
SR7 AR39	125÷160	50
SR8 AR46	150÷260	55

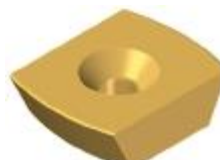
OTHER SOLUTIONS FOR INTERNAL SCARFING



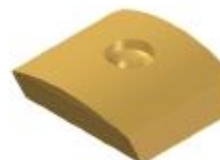
SNMW



TEMX



LOMX



LFGX

INTERNAL SCARFING TOOLS

We design and produce inside tool holders in both standard and custom designs, please contact us for more information.



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