

Tube Scarfig



DIAMIL

tube & bar tools specialists

OMCD GROUP

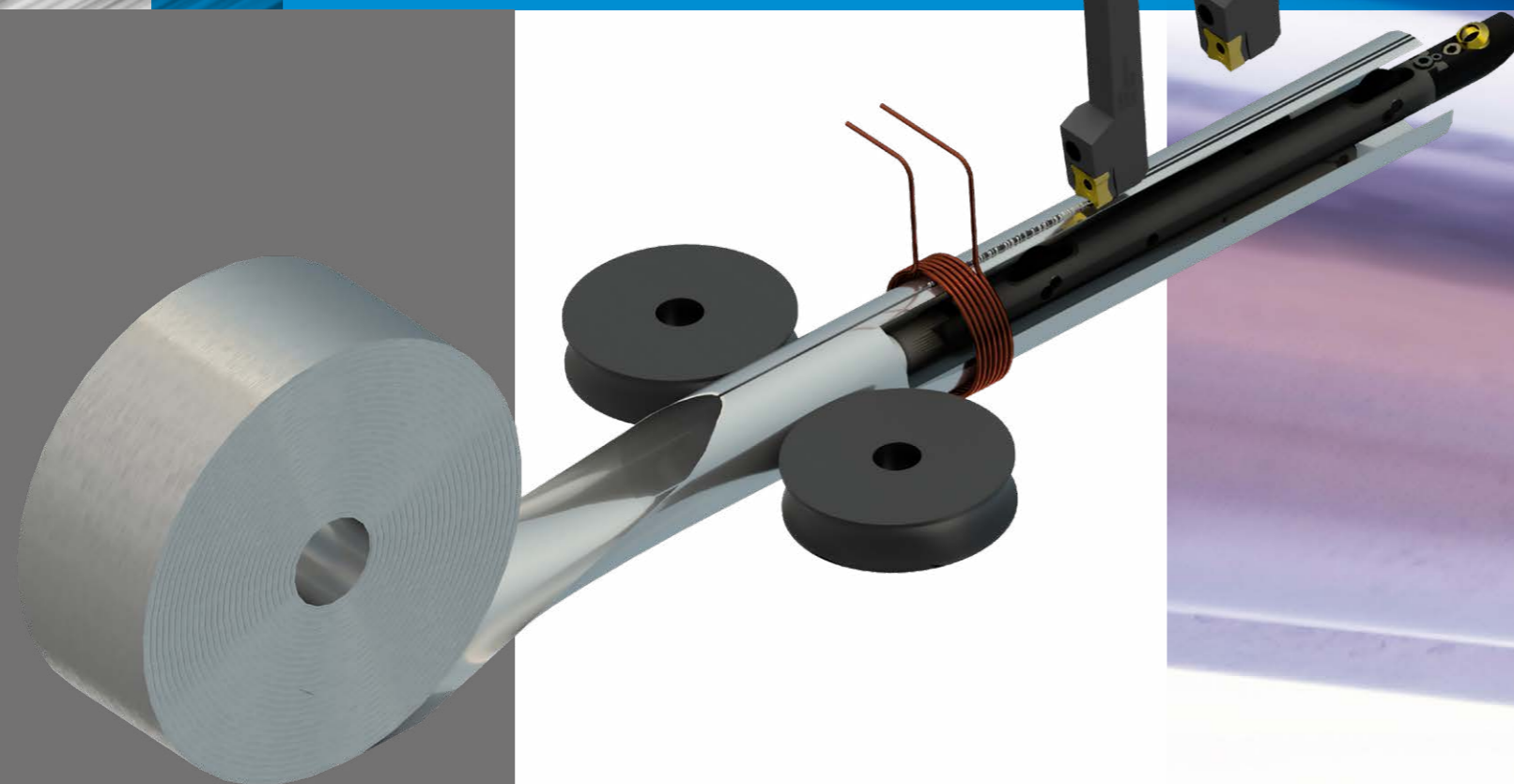
The Italian brand

of tube & bar tools specialists

The added value of DIAMIL is that the people in charge of the design and the production of inserts **know firsthand** any problem and each aspect related to **the forming of the tube**: from sheet metal dragging wheels, to items for pipe end bevelling, up to the inserts and tools for the internal and external tube scarfing.

The know-how and experience of such a competent staff allow to create **products and solutions in line with the real needs** of the market, both for standard and customized items.

*We are what we repeatedly do.
Therefore, excellence is not an action, but a habit.*
Aristotele



External Scarfing

After forming and welding, the newly created pipe needs a removal of the excess material left on the outer surface of the welding area during the process.

Our Hard Metal Grades for External Scarfing

P812G

Application range M25-M35 / P25-P35
CVD Multilayer Coating.

Very versatile grade that can be used for a wide variety of applications. Balances wear resistance and toughness very well, achieving excellent performance with most materials. Coating complements the grade, providing additional wear and high temperature resistance.

P8DBC

Application range M25-M35 / P25-P35
Multilayer mixed technology coating.
Premium version of the P812G grade, of which it maintains the main characteristics.

The special coating has been developed to obtain a surface layer with increased hardness and reduced roughness, to improve the performance in case of complex materials such as stainless steels and galvanized.

D812G

Application range M30-M45 / P30-P45
CVD Multilayer Coating.

Grade with high toughness, able to withstand the heaviest applications both in case of continuous and interrupted cutting. The grain size and composition have been specifically designed to reduce the risk of chipping and breakage to almost zero.

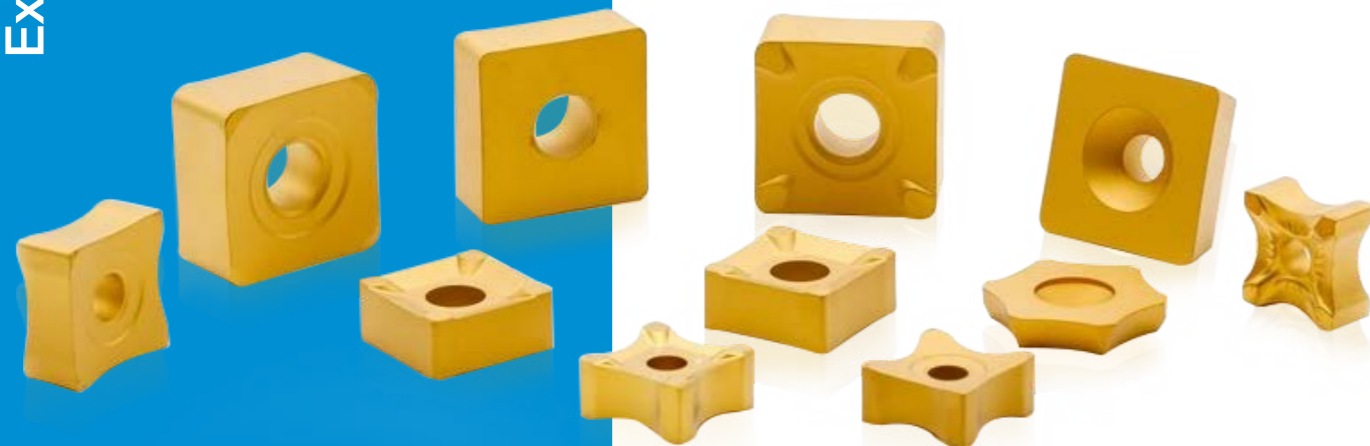
D8DBC

Application range M30-M45/P30-P45
Multilayer mixed technology coating.
Premium version of the D812G grade, of which it maintains the main characteristics.

The special coating has been developed to obtain a surface layer with increased hardness and reduced roughness, to improve the performance in case of complex materials such as stainless steels and galvanized.

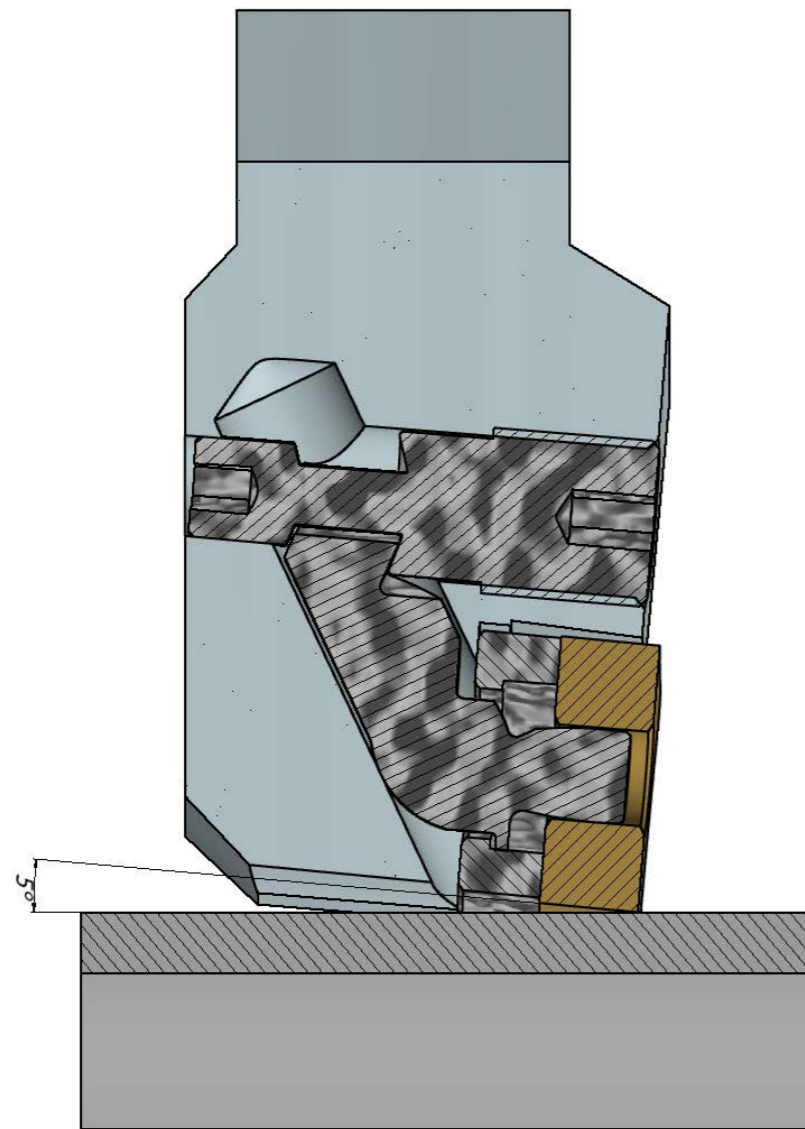
For this purpose, Diamil has developed several product lines to cover every need:

1. STANDARD INSERTS | SNMX TYPES
2. POSITIVE INSERTS
3. POSITIVE INSERTS for thick tubes
4. SPECIAL INSERTS for bright finishing tubes



Standard inserts SNMX Type 01

These inserts are suitable for Carbon steels, where the quality of the surface of the scarfed area is not a critical parameter. Removed cord can be thick.

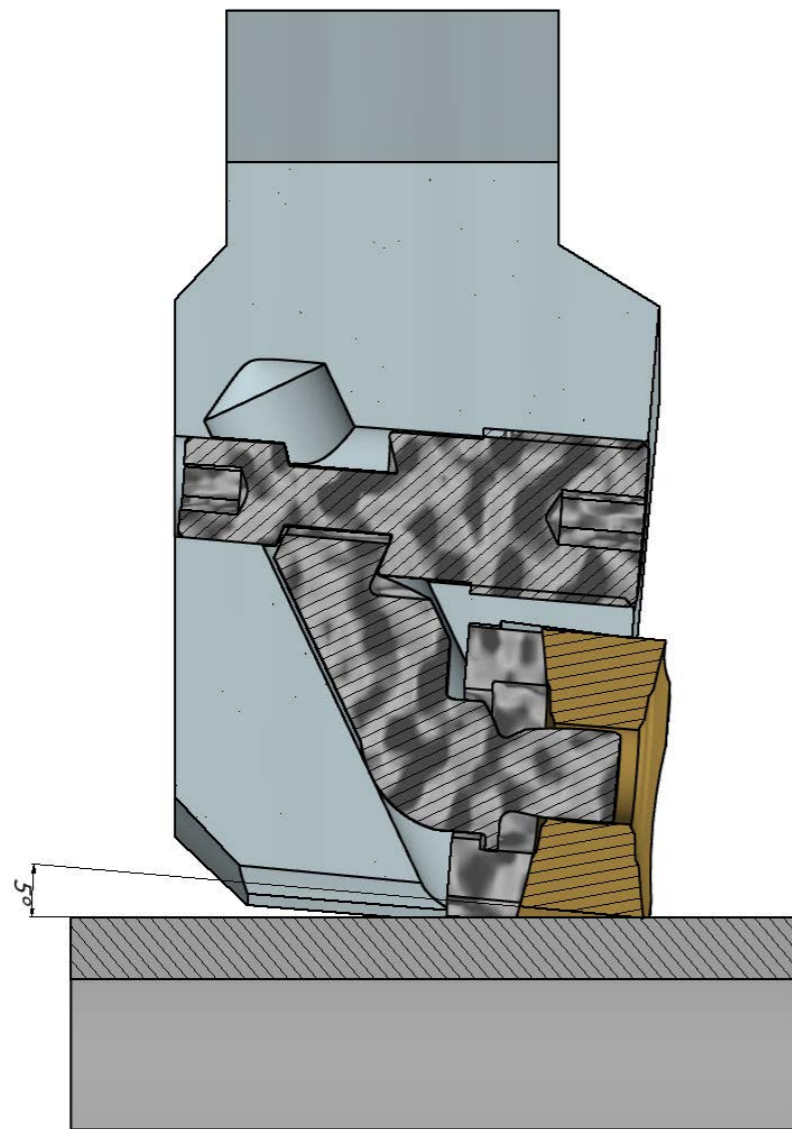


Radius	Tube Outer diameter		Grade		HPSX 15-01 R	V03	PL113
	Min.	Max.	P812G	P8DBC			
Cod. SNMX 15 - 01			P812G	P8DBC			
R07	8	13,5	◆	◆			
R09	13	17	◆	◆			
R11	16	21	◆	◆			
R13	20	25	◆	◆			
R15	24	29	◆	◆			
R18	27	35	◆	◆			
R20	33	39	◆	◆			
R22	36	42	◆	◆			
R25	40	48	◆	◆			
R27	45	52	◆	◆			
R30	50	58	◆	◆			
R35	56	68	◆	◆			
R40	65	78	◆	◆			
R45	75	88	◆	◆			
R50	85	98	◆	◆			
R60	96	117	◆	◆			
R70	115	137	◆	◆			
R75	134	147	◆	◆			
R80	145	156	◆	◆			
R90	155	176	◆	◆			
R100	175	195	◆	◆			
Cod. SNMX 19 - 01			P812G	P8DBC			
R18	27	35	◆	◆			
R20	33	39	◆	◆			
R22	36	42	◆	◆			
R25	40	48	◆	◆			
R30	48	58	◆	◆			
R35	56	68	◆	◆			
R40	65	78	◆	◆			
R45	75	88	◆	◆			
R50	85	98	◆	◆			
R55	95	108	◆	◆			
R60	105	118	◆	◆			
R75	118	147	◆	◆			
R80	145	156	◆	◆			
R90	155	176	◆	◆			
R100	175	195	◆	◆			
Cod. SNMX 25 - 01			D812G	D8DBC			
R00	-	-	◆	◆			
R30	39	58	◆	◆			
R40	57	78	◆	◆			
R50	78	98	◆	◆			
R60	96	117	◆	◆			
R70	115	137	◆	◆			
R80	137	156	◆	◆			
R90	155	176	◆	◆			
R120	176	235	◆	◆			
R140	230	275	◆	◆			
R160	270	315	◆	◆			
R180	310	355	◆	◆			
					HPSX 25-01 R	V05	PL116

Legend: ◆ Available in Stock - ◆ On request

Standard inserts SNMX Type 02

This is our standard geometry. It is suitable for most applications. The spherical surface profile makes the cutting edge sharper and enables a more efficient cut, resulting in a smoother surface of the scarfed area.

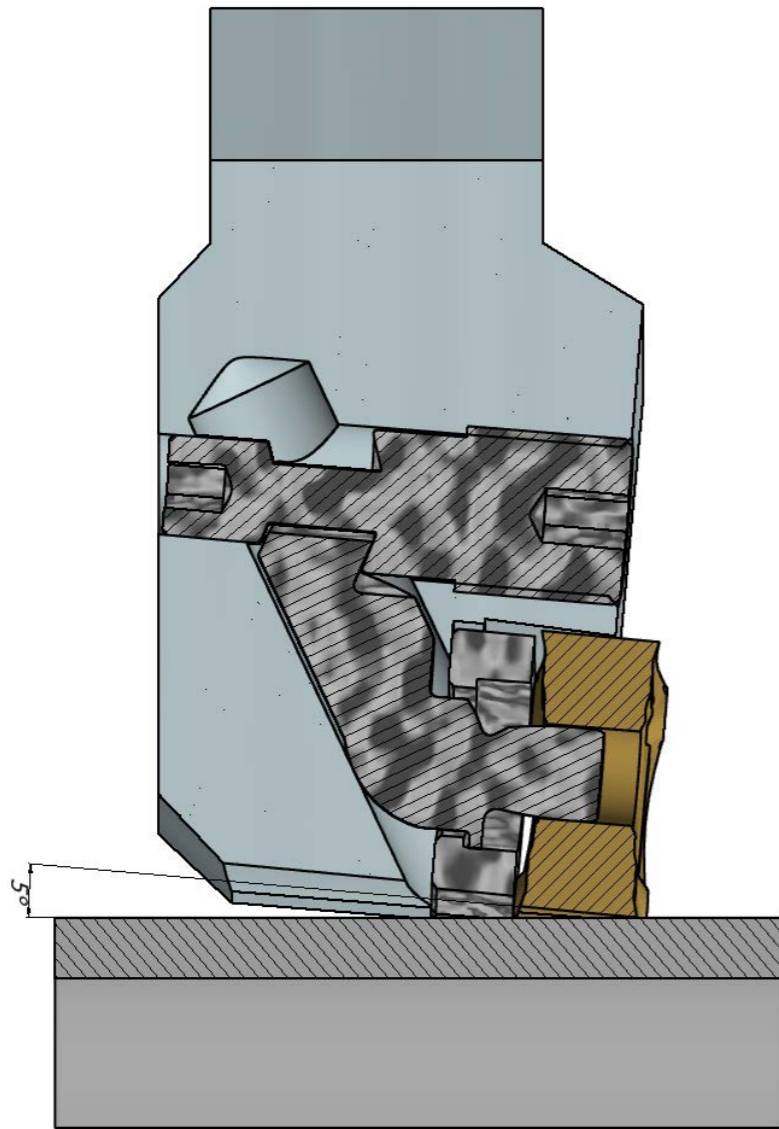


Radius	Tube Outer diameter		Grade		HPSX 15-02 R	V03	PL113
	Min.	Max.	P812G	P8DBC			
Cod. SNMX 15 - 02							
R07	8	13	◆	◆			
R09	12,5	16	◆	◆			
R11	15	19	◆	◆			
R13	17	23	◆	◆			
R15	21	28	◆	◆			
R18	26	33	◆	◆			
R20	30	37	◆	◆			
R22	34	41	◆	◆			
R25	38	45	◆	◆			
R27	43	50	◆	◆			
R30	48	54	◆	◆			
R35	52	62	◆	◆			
R40	60	70	◆	◆			
R45	68	78	◆	◆			
R50	76	85	◆	◆			
R60	83	97	◆	◆			
R70	95	110	◆	◆			
R75	106	120	◆	◆			
R80	115	130	◆	◆			
R90	125	140	◆	◆			
R100	135	150	◆	◆			
Cod. SNMX 19 - 02							
R18	26	33	◆	◆			
R20	30	37	◆	◆			
R22	34	41	◆	◆			
R25	38	45	◆	◆			
R30	48	54	◆	◆			
R35	52	62	◆	◆			
R40	60	70	◆	◆			
R45	68	78	◆	◆			
R50	76	85	◆	◆			
R55	80	92	◆	◆			
R60	90	97	◆	◆			
R75	97	120	◆	◆			
R80	115	130	◆	◆			
R90	125	140	◆	◆			
R100	135	150	◆	◆			
Cod. SNMX 25 - 02							
R00	-	-	◆	◆			
R30	38	54	◆	◆			
R40	54	70	◆	◆			
R50	70	85	◆	◆			
R60	85	97	◆	◆			
R70	95	110	◆	◆			
R80	110	130	◆	◆			
R90	125	140	◆	◆			
R100	130	150	◆	◆			
R110	135	165	◆	◆			
R120	140	180	◆	◆			
R140	175	205	◆	◆			
R160	200	240	◆	◆			
R180	235	280	◆	◆			

Legend: ◆ Available in Stock - ◆ On request

Standard inserts SNMX Type 03

Type 03 is the only scarfing insert on the market that include a chip breaker, capable of improving the control of the removed bead and consequently of reducing the formation of large hanks, dangerous for the machine operator. Its shape is also more stable than the model 02 and the cutting edge is sharper.

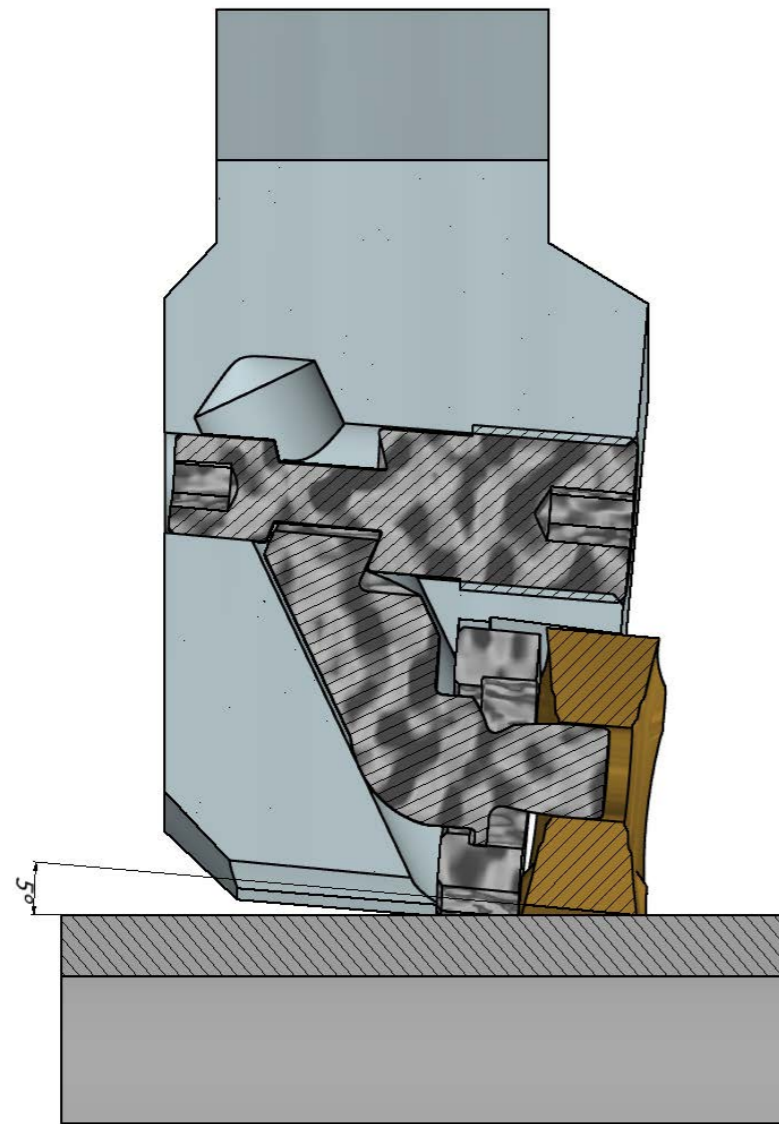


Radius	Tube Outer diameter		Grade		HPSX 15-01 R	V03	PL113
	Min.	Max.	P812G	P8DBC			
Cod. SNMX 15 - 04			P812G	P8DBC			
R07	8	13	◆	◆			
R09	12,5	16	◆	◆			
R11	15	19	◆	◆			
R13	17	23	◆	◆			
R15	21	28	◆	◆			
R18	26	33	◆	◆			
R20	30	37	◆	◆			
R22	34	41	◆	◆			
R25	38	45	◆	◆			
R27	43	50	◆	◆			
R30	48	54	◆	◆			
R35	52	62	◆	◆			
R40	60	70	◆	◆			
R45	68	78	◆	◆			
R50	76	85	◆	◆			
R60	83	97	◆	◆			
R70	95	110	◆	◆			
R75	106	120	◆	◆			
R80	115	130	◆	◆			
R90	125	140	◆	◆			
R100	135	150	◆	◆			
Cod. SNMX 19-03			P812G	P8DBC			
R18	27	35	◆	◆			
R20	33	39	◆	◆			
R22	36	42	◆	◆			
R25	40	48	◆	◆			
R30	48	58	◆	◆			
R35	56	68	◆	◆			
R40	65	78	◆	◆			
R45	75	88	◆	◆			
R50	85	98	◆	◆			
R55	95	108	◆	◆			
R60	105	118	◆	◆			
R75	118	147	◆	◆			
R80	145	156	◆	◆			
R90	155	176	◆	◆			
R100	175	195	◆	◆			
Cod. SNMX 25 - 03			D812G	D8DBC			
R00	-	-	◆	◆			
R<100	All the radii On request		◆	◆			
R100	120	150	◆	◆			
R120	145	180	◆	◆			
R140	175	210	◆	◆			
R160	205	240	◆	◆			
R180	235	270	◆	◆			
R200	265	300	◆	◆			
R220	295	330	◆	◆			
R240	325	360	◆	◆			
R260	355	390	◆	◆			
R280	385	420	◆	◆			
R300	415	450	◆	◆			
					HPSX 25-01 R	V05	PL116

Legend: ◆ Available in Stock - ◆ On request

Standard inserts SNMX Type 04 | SNMG

Type 4 is a development of 02 Type, with higher stability and sharper cutting edge which improve performances, especially with stainless and galvanized steels.

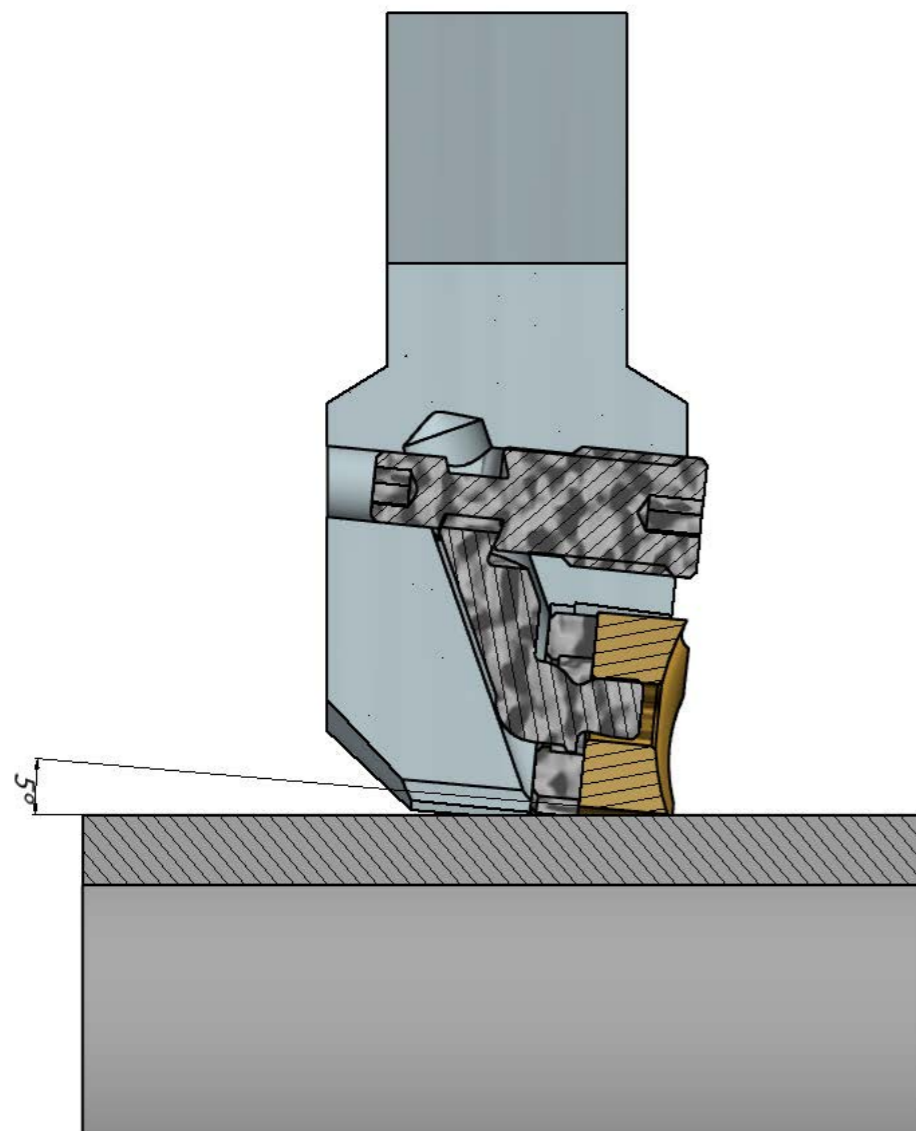


Radius	Tube Outer diameter		Grade		HPSX 15-01 R	V03	PL113
	Min.	Max.	P812G	P8DBC			
Cod. SNMX 15 - 04			P812G	P8DBC			
R07	8	13	◆	◆			
R09	12,5	16	◆	◆			
R11	15	19	◆	◆			
R13	17	23	◆	◆			
R15	21	28	◆	◆			
R18	26	33	◆	◆			
R20	30	37	◆	◆			
R22	34	41	◆	◆			
R25	38	45	◆	◆			
R27	43	50	◆	◆			
R30	48	54	◆	◆			
R35	52	62	◆	◆			
R40	60	70	◆	◆			
R45	68	78	◆	◆			
R50	76	85	◆	◆			
R60	83	97	◆	◆			
R70	95	110	◆	◆			
R75	106	120	◆	◆			
R80	115	130	◆	◆			
R90	125	140	◆	◆			
R100	135	150	◆	◆			
Cod. SNMX 19 - 04			P812G	P8DBC			
R00	-	-	◆	◆			
R11	15	19	◆	◆			
R13	17	23	◆	◆			
R15	21	28	◆	◆			
R18	26	33	◆	◆			
R20	30	37	◆	◆			
R22	34	41	◆	◆			
R25	38	45	◆	◆			
R30	45	54	◆	◆			
R35	52	62	◆	◆			
R40	60	70	◆	◆			
R45	68	78	◆	◆			
R55	78	92	◆	◆			
R60	90	97	◆	◆			
R75	97	120	◆	◆			
R100	120	150	◆	◆			
Cod. SNMX 19 - 04 - Convex			P812G	P8DBC			
R80	Direct profile tubes		◆	◆			
R100	Direct profile tubes		◆	◆	HPSX 19-04 R	V04	PL115
R200	Direct profile tubes		◆	◆			
Cod. SNMX 25 - 04			D812G	D8DBC			
R00	-	-	◆	◆			
R<100	All the radii On request		◆	◆			
R100	120	150	◆	◆			
R120	145	180	◆	◆			
R140	175	210	◆	◆			
R160	205	240	◆	◆			
R180	235	270	◆	◆			
R200	265	300	◆	◆			
R220	295	330	◆	◆			
R240	325	360	◆	◆			
R260	355	390	◆	◆			
R280	385	420	◆	◆			
R300	415	450	◆	◆			
					HPSX 25-01 R	V05	PL116

Legend: ◆ Available in Stock - ◆ On request

Standard inserts SNMX Type 05

Type 5 is a single face insert very similar to model 02 but with a deeper spherical profile, which makes the cutting edge much sharper. This “super positive” profile makes it perfect for special machining of stainless and aluminized steels.




Radius	Tube Outer diameter		Grade		HPSX 15-01 R	V03	PL113
	Min.	Max.	P812G	P8DBC			
Cod. SNMX 15 - 04							
R07	8	13	◆	◆			
R09	12,5	16	◆	◆			
R11	15	19	◆	◆			
R13	17	23	◆	◆			
R15	21	28	◆	◆			
R18	26	33	◆	◆			
R20	30	37	◆	◆			
R22	34	41	◆	◆			
R25	38	45	◆	◆			
R27	43	50	◆	◆			
R30	48	54	◆	◆			
R35	52	62	◆	◆			
R40	60	70	◆	◆			
R45	68	78	◆	◆			
R50	76	85	◆	◆			
R60	83	97	◆	◆			
R70	95	110	◆	◆			
R75	106	120	◆	◆			
R80	115	130	◆	◆			
R90	125	140	◆	◆			
R100	135	150	◆	◆			

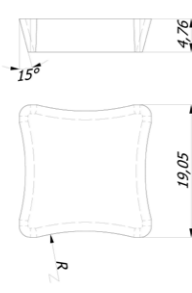
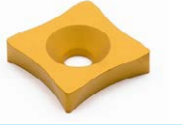
Legend: ◆ Available in Stock - ◆ On request

Positive Inserts

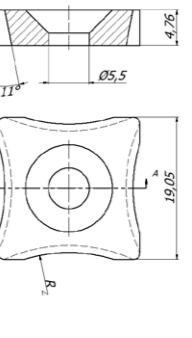
Thanks to the sharp cutting edge, these inserts are suitable for machining thin tubes and difficult materials like stainless steels, aluminium and galvanized steels.




Radius	Tube Outer diameter		Grade	
	Min.	Max.	P812G	P8DBC
SDUN 190416				
R00	-	-	◆	◆
R15	18	28	◆	◆
R20	27	37	◆	◆
R25	36	45	◆	◆
R30	44	54	◆	◆
R35	52	62	◆	◆
R40	60	70	◆	◆
R45	68	78	◆	◆
R50	76	92	◆	◆
R60	90	105	◆	◆
R70	103	120	◆	◆

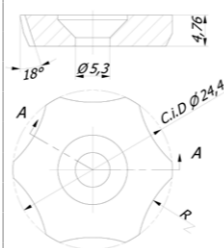
Radius	Tube Outer diameter		Grade	
	Min.	Max.	P812G	P8DBC
SPUB 190408				
R00	-	-	◆	◆
R9.5	12	17	◆	◆
R12	16	22	◆	◆
R15	21	27	◆	◆
R20	27	36	◆	◆
R22	32	40	◆	◆
R25	37	45	◆	◆
R30	42	51	◆	◆
R40	51	68	◆	◆
R50	67	85	◆	◆
R65	85	104	◆	◆
R75	100	120	◆	◆
R90	120	144	◆	◆
R100	135	160	◆	◆
R150	160	240	◆	◆



Legend: ◆ Available in Stock - ◆ On request



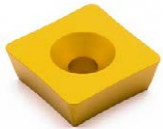
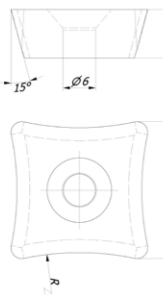
Radius	Tube Outer diameter		Grade	
	Min.	Max.	P812G	P8DBC
ROMX 2404				
R10 (DET3)	10	15	◆	◆
R11	15	19	◆	◆
R12	17	21	◆	◆
R13 (DET5)	18,5	23	◆	◆
R14	20	25	◆	◆
R15	22	27,5	◆	◆
R16 (DET7)	23	29	◆	◆
R17	24	31	◆	◆
R18	25,5	33	◆	◆
R19	26,5	34,5	◆	◆
R20	28	36	◆	◆
R21 (DET8)	29,5	38	◆	◆
R22	31	39,5	◆	◆
R23	33	41	◆	◆
R24	34	43	◆	◆
R27 (DET9)	38	48	◆	◆
R28	39,5	50	◆	◆
R30	42	51	◆	◆
R35	49	59,5	◆	◆
R38 (DET10)	53	64	◆	◆
R40	56	68	◆	◆
R45	63	76	◆	◆
R47 (DET11)	66	80	◆	◆
R50	70	85	◆	◆
R60 (DET12)	84	96	◆	◆
R70	98	112	◆	◆
R73 (DET13)	102	117	◆	◆


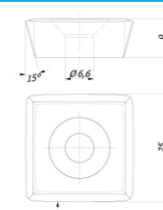



Legend: ◆ Available in Stock - ◆ On request

Positive Inserts for thick Tubes

The positive cutting edge, in combination with generous size and very robust cutting edge geometry, makes these inserts perfect in case of thick pipes.

	Radius	Tube Outer diameter		Grade	
		min.	max.		
		SDUW 250920		D812G	D8DBC
	R00	-	-	◆	◆
	R40	56	70	◆	◆
	R50	70	85	◆	◆
	R60	84	96	◆	◆
	R70	96	115	◆	◆
	R85	115	136	◆	◆
	R100	136	155	◆	◆
	R120	155	190	◆	◆
	R150	190	240	◆	◆
	R200	240	320	◆	◆


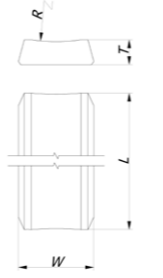
	Radius	Tube Outer diameter		Grade	
		min.	max.		
		SDMW 250920T		D812G	D8DBC
	R00	-	-	◆	◆
	On request	-	-	◆	◆


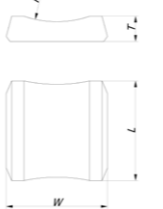
	Radius	Tube Outer diameter		Grade	
		min.	max.		
		SDGN 3209		D812G	D8DBC
	R00	-	-	◆	◆

Legend: ◆ Available in Stock - ◆ On request

Bright finishing tube

This is a special line of inserts with very sharp cutting edge. Useful for reaching very smooth surfaces.

	Main sizes				Grade		
	L	W	T	R			
		LDGN 150560				P812G	P8DBC
	60	15,05	5	0	◆	◆	
	60	15,05	5	14	◆	◆	
	60	15,05	5	18	◆	◆	
	60	15,05	5	20	◆	◆	
	60	15,05	5	25	◆	◆	
	60	15,05	5	30	◆	◆	
	60	15,05	5	35	◆	◆	
	60	15,05	5	40	◆	◆	
	60	15,05	5	50	◆	◆	
	60	15,05	5	60	◆	◆	
	60	15,05	5	◆	◆	◆	

	Main sizes				Grade		
	L	W	T	R			
		LGMN 2005				D812G	D8DBC
	19,8	20	5	◆	◆	◆	

Legend: ◆ Available in Stock - ◆ On request

Tools for External Scarfing

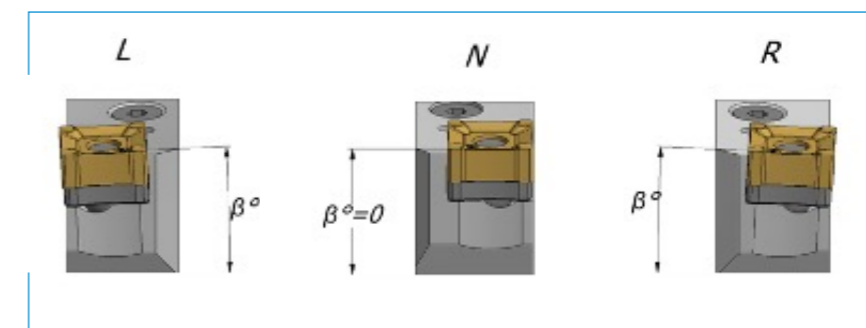
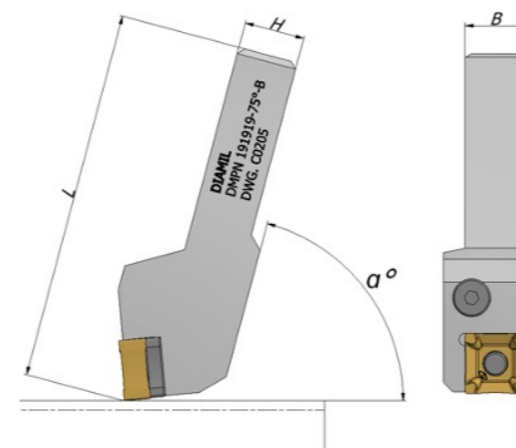
Thanks to our skilled technicians, we design and produce all the tools, fixing systems and carbide supports, needed to hold the inserts during the scarfing process. We can offer both, standard tools and special ones, developed in accordance with the customer needs.

The following chart includes our ready in stock standard tools:

Code	H	B	α	L	Type
SNMX15-01 SNMX15-02 SNMX15-03 SNMX15-04 SNMX15-05					
DMPN202015-90	20	20	90°	180	N
DMPL202015-90					L
DMPR202015-90					R
DMPN202015-75	20	20	75°	180	N
DMPL202015-75					L
DMPR202015-75					R
DMPN252515-90	25	25	90°	180	N
DMPL252515-90					L
DMPR252515-90					R
DMPN252515-75	25	25	75°	180	N
DMPL252515-75					L
DMPR252515-75					R
SNMX19-01 SNMX19-02					
DMPN252519-90A	25	25	90°	180	N
DMPL252519-90A					L
DMPR252519-90A					R
DMPN252519-75A	25	25	75°	180	N
DMPL252519-75A					L
DMPR252519-75A					R
SNMX19-03 SNMX19-04					
DMPN202019-90B	20	20	90°	180	N
DMPL202019-90B					L
DMPR202019-90B					R
DMPN252519-90B	25	25	90°	180	N
DMPL252519-90B					L
DMPR252519-90B					R
DMPN252519-75B	25	25	75°	180	N
DMPL252519-75B					L
DMPR252519-75B					R
SNMX25-01 SNMX25-02 SNMX25-03 SNMX25-04					
DMPN323225-90	32	32	90°	250	N
DMPL323225-90					L
DMPR323225-90					R
DMPN323225-75	32	32	75°	250	N
DMPL323225-75					L
DMPR323225-75					R



External Scarfing





Internal Scarfing

Depending on the use of the tubes, it may be required that the weld bead on the inside surface of the welded area also has to be removed. In this case, it is necessary to use inserts specifically designed.

Our Hard Metal Grades for Internal Scarfing

All the inserts are Made in Italy entirely designed and manufactured in our factory, from the powder mixing through grinding and finishing of the cutting edge, to the final operations: the coating process, which can be CVD or PVD.

M112G

Application range M35-M50 / P35-P50
CVD Multilayer Coating.

Standard grade for internal scarfing. Medium grain size provides excellent stress resistance, minimizing the possibility of cracking and chipping. High-thickness coating increases resistance to wear and high temperatures.

M1DBC

Application range M35-M50 / P35-P50
Multilayer mixed technology coating.

Premium version of the M112G grade, of which it retains the main features. The special coating has been developed to obtain a surface layer with increased hardness and reduced roughness, to improve the performance in case of complex materials such as stainless steels and galvanized.


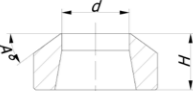
Depending on the type of chuck used and the characteristics of the tube itself, there are different types of inserts:

1. STANDARD RINGS
2. NAIL TYPE INSERTS
3. TOMB STONE TYPE INSERTS



Cutting Rings



Standard product line for internal de-burring rings, used in case of pipes up to 5mm thickness. Our line includes inserts with 42° cutting angle, used for the most common applications, as well as rings with 48° cutting angle (on request), which are normally used in case of aluminized tubes. They can be mounted on all types of RI-ME chucks, both mechanical and hydraulic.

	Code	Main size				Tube Inner Diameter		Grade	
		D	H	d	A	Min.	Max.	M112G	M1DBC
		SR - AR							
	SR0-AR4.5	8	4	4	42°	14	17	◆	◆
	SR0-AR5.5	8	4	5	42°	16	17	◆	◆
	SR0-AR06	10	4,5	5,5	42°	16	19	◆	◆
	SR0-AR6.5	10	4,5	6	42°	17	20	◆	◆
	SR1 - AR07	13	5	6	42°	20	22	◆	◆
	SR1 AR08	13	5	7	42°	22	24	◆	◆
	SR1 AR09	13	5	8	42°	24	26	◆	◆
	SR2 AR10	19	8	9	42°	26	28	◆	◆
	SR2 AR11	19	8	10	42°	28	30	◆	◆
	SR2 AR12	19	8	11	42°	30	34	◆	◆
	SR3 AR14	22	10	12	42°	32	41	◆	◆
	SR3 AR17	22	10	15	42°	41	50	◆	◆
	SR4 AR17.5	30	12	15	42°	48	58	◆	◆
	SR4 AR20	30	12	17	42°	54	66	◆	◆
	SR4 AR23	30	12	20	42°	62	72	◆	◆
	SR5 AR25	35	12	22	42°	70	85	◆	◆
	SR5 AR28	35	12	25	42°	85	100	◆	◆
	SR6 AR30	45	15	26	42°	90	110	◆	◆
	SR6 AR34	45	15	30	42°	100	130	◆	◆
	SR7 AR39	50	15	35	42°	125	160	◆	◆
	SR8 AR46	55	18	40	42°	150	260	◆	◆

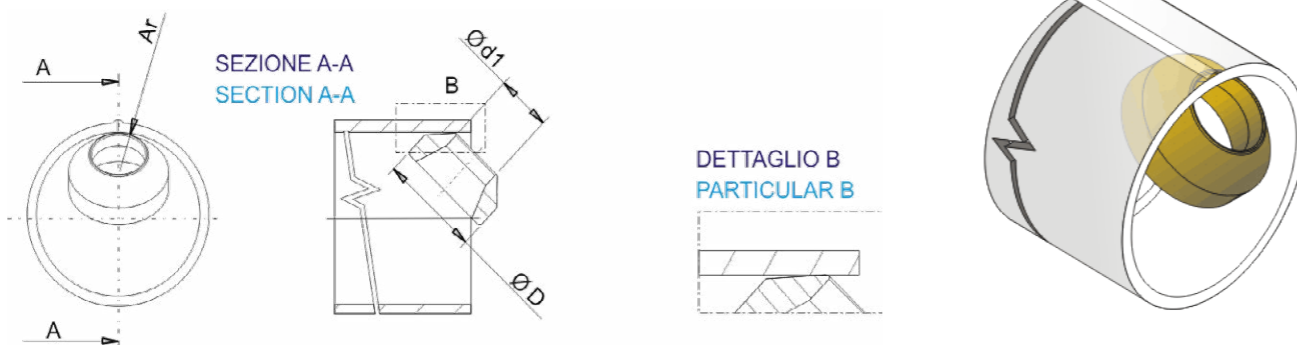
Legend: ◆ Available in Stock - ◆ On request

Special Nail Type

Inserts for internal scarfing, equivalent to the standard cutting rings, but specific for a particular line of pneumatic chucks.

	Code	Main size				Grade	
		W	L	H	R	M112G	M1DBC
		XFHX					
	XFHX 0506-R07	12	19	06	07	◆	◆
	XFHX 0607-R09	12	19	07	09	◆	◆
	XFHX 0609-R08	12	19	09	08	◆	◆
	XFHX 0808-R10	12	19	08	10	◆	◆
	XFHX 0909-R13	12	19	09	13	◆	◆
	XFHX 0909-R14	12	19	09	14	◆	◆
	XFHX 0909-R17	12	19	09	17	◆	◆
	XFHX 0909-R19	12	19	09	19	◆	◆
	XFHX 0911-R16	12	19	11	16	◆	◆
	XFHX 1415-R19	12	19	15	19	◆	◆
	XFHX 1415-R25	12	19	15	25	◆	◆
	XFHX 1415-R29	12	19	15	29	◆	◆
	XFHX 1416-R32	12	19	16	32	◆	◆



Legend: ◆ Available in Stock - ◆ On request


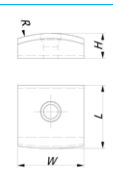


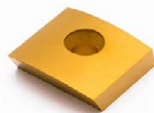
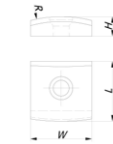
Nail Type

for thin Tubes

Special internal inserts with one single cutting edge. Used for thin tubes and fast forward speeds.

	Code	Main size				Grade	
		W	L	H	R		
		LOGX				M112G	M1DBC
	LOGX 1708	16	17	8	◆	◆	◆

	Code	Main size				Grade	
		W	L	H	R		
		LFGX				M112G	M1DBC
	LFGX 1608	16	17	8	◆	◆	◆
	LFGX 2509	25	24	9,52	◆	◆	◆

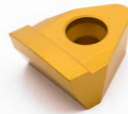
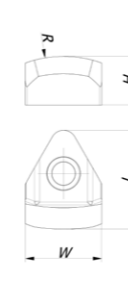
	Code	Main size				Grade	
		W	L	H	R		
		SOGX				M112G	M1DBC
	SOGX 2507	25	24,6	8	◆	◆	◆

Legend: ◆ Available in Stock - ◆ On request

Tomb Stone Type

for thick Tubes

The very strong cutting edge allows the removal of the bead in heavy conditions and is therefore indicated in case of thick tubess.


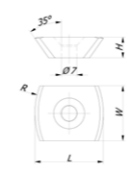
	Code	Main size				Grade	
		W	L	H	R		
		TEMX				M112G	M1DBC
	TEMX 1409	22	28,4	14	20	◆	◆
					25	◆	◆
					30	◆	◆
					35	◆	◆
					40	◆	◆
					50	◆	◆
					◆	◆	◆
	TEMX 3509	35	29,9	14,6	50	◆	◆
					70	◆	◆
					◆	◆	◆


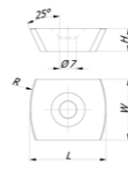
Legend: ◆ Available in Stock - ◆ On request

Tomb Stone Type

(US standard)

Double cutting edges tomb-stone inserts mostly used in the oil & gas tubes manufacturing

	Code	Main size				Grade	
		W	L	H	R		
		LFGW				M112G	M1DBC
	LFGW 3109	25	31	9,52	1.6"	◆	◆
					◆	◆	◆

	Code	Main size				Grade	
		W	L	H	R		
		LOMX				M112G	M1DBC
	LOMX 2509	25	31,75	9,52	◆	◆	◆

Legend: ◆ Available in Stock - ◆ On request

Tools for Internal Scarfing

Diamil produces tools for internal deburring and cutting ring holders, using carbide for wear parts (wheels and pins).

Tool's code	I.D. Working Range	Ring's holder	Carbide rings
RI-ME 014	14-17 mm	SH 014 - SR 0	SR 0 - AR 4,5
RI-ME 017	17-21 mm	SH 017 - SR 0	SR 0 - AR 4,5 SR 0 - AR 6,5
RI-ME 1	20-26 mm	SH 1 - SR 0	SR 0 - AR 6,5
		SH 1 - SR 1	SR 1 - AR 7 SR 1 - AR 8 SR 1 - AR 9
			SR 1 - AR 7
RI-ME 2	26-34 mm	SH 2 - SR 1	SR 1 - AR 8 SR 1 - AR 9
			SH 2 - SR 2
		SH 3 - SR 2	
			SH 3 - SR 3
RI-ME 4	48-72 mm	SH 4 - SR 3	
		SH 4 - SR 4	SR 4 - AR 23
RI-ME 5	70-100 mm	SH 5 - SR 4	SR 4 - AR 23
		SH 5 - SR 5	SR 5 - AR 25 SR 5 - AR 28
RI-ME 6	100-130 mm		SH 6 - SR 5
		SH 6 - SR 6	SR 6 - AR 34
RI-ME 7	125-160 mm	SH 7 - SR 6	SR 6 - AR 34
		SH 7 - SR 7	SR 7 - AR 39
RI-ME 8	150-260 mm	SH 8 - SR 7	SR 7 - AR 39
		SH 8 - SR 8	SR 8 - AR 46

The RI-ME are to be produced and are available on request.



Internal Scarfing

Chamfering and sheet metal preparation

To complete the line of products needed in pipe welding, Diamil supplies a wide range of inserts for pipe beveling and sheet metal preparation and all related spare parts, such as: as beveling heads, tool cartridges and clamping systems. Upon specific request, the technical department can design the entire system for the customer.

Our Hard Metal Grades for Chamfering

All the inserts are Made in Italy entirely designed and manufactured in our factory, from the powder mixing through grinding and finishing of the cutting edge, to the final operations: the coating process, which can be CVD or PVD.

P40

Application range
P35-P45 / M35-M45
Uncoated

The high toughness of the grade makes it perfect for roughing applications with both continuous and interrupted cutting. The surface polishing optimizes chip evacuation.

D812G

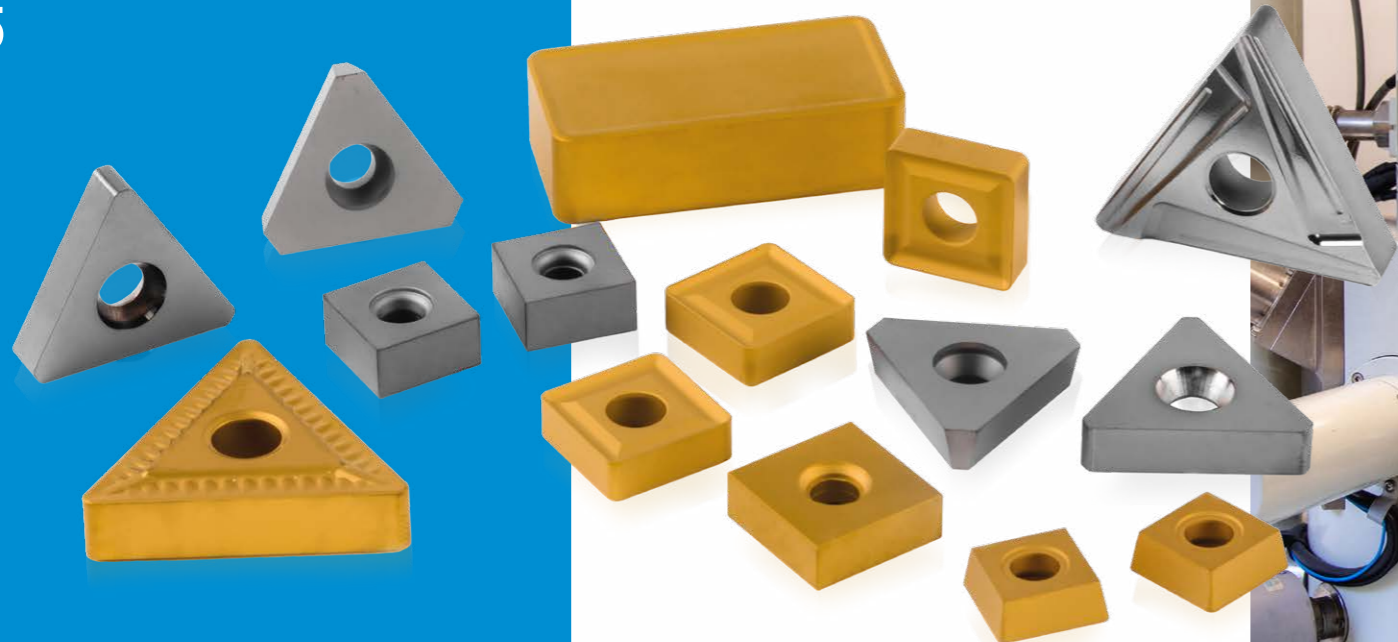
Application range
M30-M45 / P30-P45
CVD Multilayer Coating.

Grade with high toughness, able to withstand the heaviest applications, both in case of continuous and interrupted cutting. The grain size and composition have been specifically designed to reduce the risk of chipping and breakage to almost zero.

M112G


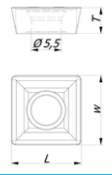
Application range
M35-M50 / P35-P50
CVD Multilayer Coating.


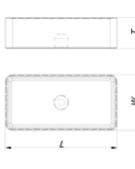
Standard grade for internal scarfing. Medium grain size provides excellent stress resistance, minimizing the possibility of cracking and chipping. High-thickness coating increases resistance to wear and high temperatures.


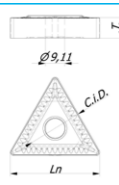



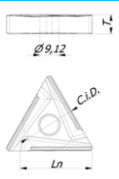
Insert


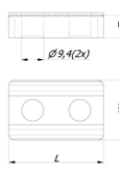
for pipe-end bevelling

	Main size			Grade
	W	L	T	
	SPMT 120408-HM1			D812G
	12,7	12,7	4,76	◆

	Main size			Grade
	W	L	T	
	LNMR 501432-HR4			D812G
	25,4	50,8	14,2	◆

	Main size			Grade
	Ln	C.i.D.	T	
	TNMM 440916 SN			D812G
	44	25,4	9,52	◆


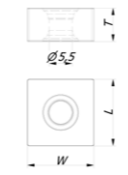
	Main size			Grade	
	Ln	C.i.D.	T	P40	D812G
	TNMM 440916 SL			◆	◆
	35	25,4	9,52		


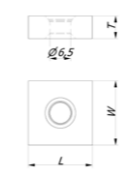
	Main size			Grade	
	W	L	T	M112G	M1DBC
	LNUX 400924			◆	◆
	25,4	40	9,52		

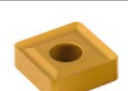
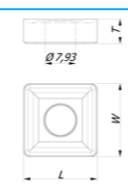
Legend: ◆ Available in Stock - ◆ On request

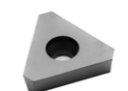
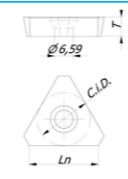
Insert

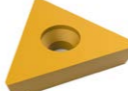
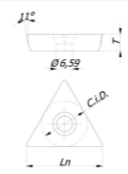
for sheet metal preparation

	Main size			Grade
	W	L	T	
	SNGQ 150700-S			M112G
	15,8	15,8	7,94	◆

	Main size			Grade
	W	L	T	
	SNMC 200700			M112G
	20	20	7	◆

	Main size			Grade
	W	L	T	
	SNMM 190616-HM2			D812G
	25	31	9,52	◆

	Main size			Grade
	Ln	C.i.D.	T	
	TPEX 3307XX			M112G
	25	31,75	9,52	◆

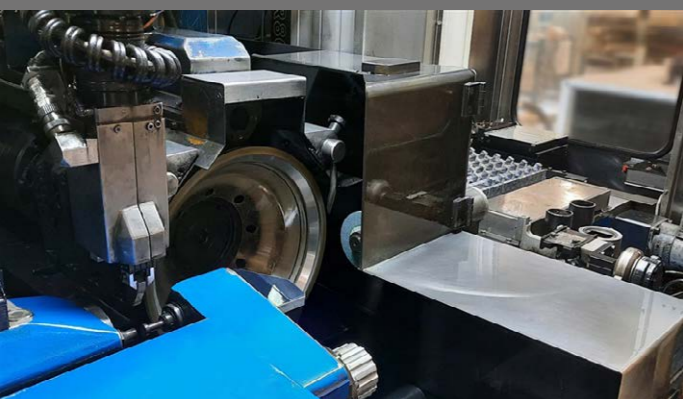
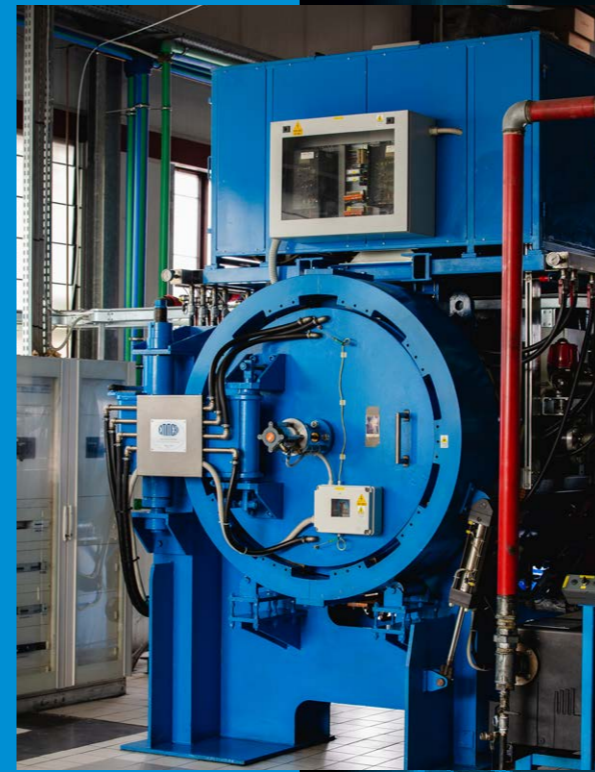
	Main size			Grade
	Ln	C.i.D.	T	
	TPEX 330716			M112G
	25	31,75	9,52	◆

Legend: ◆ Available in Stock - ◆ On request

The Company

Diamil, thanks to **over 30 years of experience** in the field, created a team able to **support customers in any technical issue** from machine settings to customized tools design for special machining.

With the aim of giving to **the customer the best service**, Diamil based its offer on a mixture of competence, **high quality products** and customized solutions.



Customer Service Competence

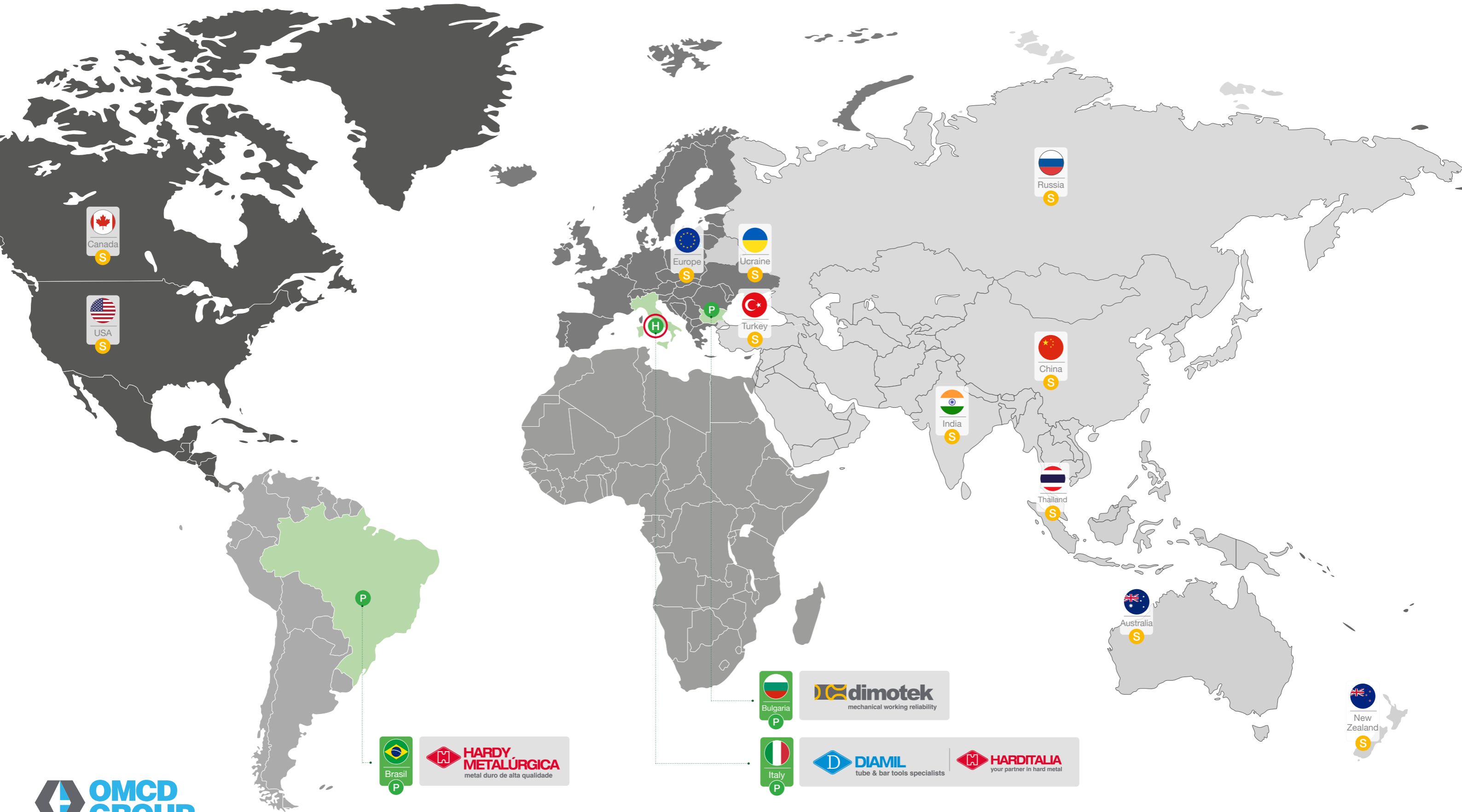
Our skills at your disposal!
We provide expertise and support to the customer being at his side, aware that service add an extra value to a high performance product.



In the word

- Europe
- Germany
 - Greece
 - Poland
 - Spain
 - France
 - Sweden
 - Austria
 - Denmark
 - Finland
 - Benelux
 - Norway
 - Switzerland
 - England

- H** | Harditalia Headquarter
- P** | Production site
- S** | Sales Office



Brasil
HARDY METALÚRGICA
 metal duro de alta qualidade

Bulgaria
dimotek
 mechanical working reliability

Italy
DIAMIL tube & bar tools specialists | **HARDITALIA** your partner in hard metal

The **OMCD Group** headed by the Tedeschi family for two generations, is a multinational company made up of **10 brands active in the field of Hard Metal, sintered copper/tungsten and precious metals.**

Its centralized structure and **synergy between each brand** guarantees **control of the entire production process**, from the refining of minerals to the micro-finishing operations.

Technical **competence**, continuous **innovation** and focus on **customer satisfaction** are just some of the reasons why every day more and more companies rely on OMCD Group as their commercial business partner.



DOWNLOAD
the digital version



DIAMIL
tube & bar tools specialists
OMCD GROUP

Diamil by Harditalia srl
Via Genova 9
Oggiona con S.Stefano - 21040 (Va) Italia
Tel. +39 0331 215007 - Fax +39 0331 215024
harditalia@harditalia.com
diamil.it / harditalia.com