



NEW DORMER DRILLING & TAPPING RANGE

FROM HARRISON & CLOUGH



DORMER PRAMET®

METALMATE®

FASTENERS FOR METAL

The METALMATE® range presents
over 5,500 quality assured fastener
products, available with:



**FULL BATCH
TRACEABILITY
BACK TO THE
RAW MATERIAL**

**EN 10204
3.1
CERTIFICATION
AVAILABLE**



**MANUFACTURED
AND TESTED TO
INTERNATIONAL
STANDARDS**



**IN-HOUSE
QUALITY
DEPARTMENT**

**CE
APPROVED
PRODUCTS**



**TRIVALENT
CR3
PASSIVATION**



**ROHS
COMPLIANT**



A321

HSS DRILL WITH THREE-FLATS SHANK



A113

BRIGHT HSS DRILL



E55.(M)

POWER TOOL TAPS



E559

ECONOMICAL HAND AND SERIAL TAPS



M90.

SPIRAL FLUTED SCREW EXTRACTORS

INTRODUCTION



Introducing new intermediate length HSS drill with three-flat shanks designed for hand-held power tools, but also well performing option for machine drilling. Three flats on the shank prevents the drill from slipping in the chuck, while a self-centering 135° split point and bronze oxide finish makes the drilling action smooth. Intermediate length variant falls in between ANSI jobber and stub length, providing balanced ratio of flexibility and toughness. Metric range covers most usual sizes starting from 3 mm up to 13 mm.

DORMER PRAMET®**A321**

- Versatile HSS drill
- Three-flats shank
- DC Range:
3 – 13 mm

FEATURES & BENEFITS

Three-flats design on shank prevents slipping in power tools keyless chuck.

► **RELIABLE AND SAFE**
solution for any hand-held operation.

Precisely ground with 135° point and a sharp split point geometry.

► **EASY DRILLING, SELF-CENTERING**
capability and reduced thrust force.

Steam and bronze tempered surface finish for better lubrication.

► **IMPROVED DURABILITY**
throughout the whole life span.

Shorter intermediate length with strong web design.

► **SUPERIOR RIGIDITY**
even in unfavorable conditions.

APPLICATION EXAMPLE



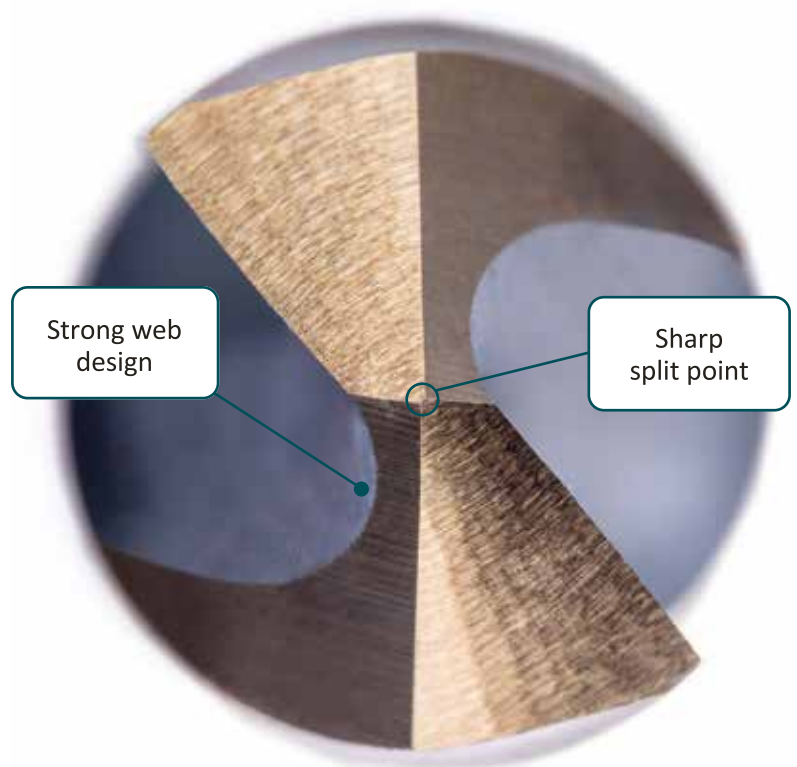
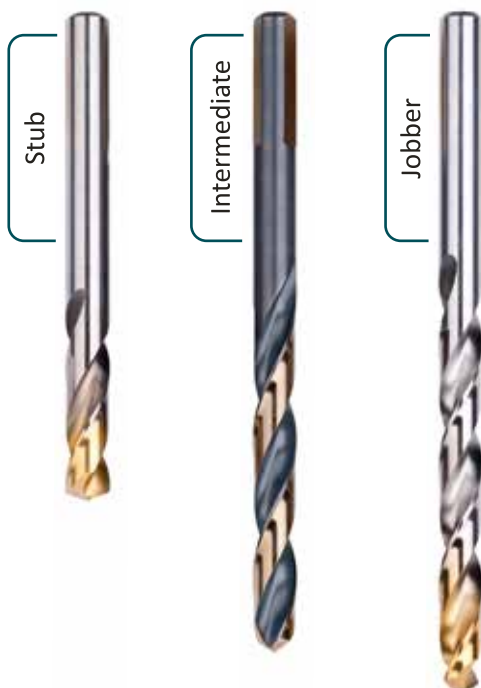
A321

HSS DRILL WITH THREE-FLATS SHANK

TECHNICAL DETAILS



LENGTHS OVERVIEW



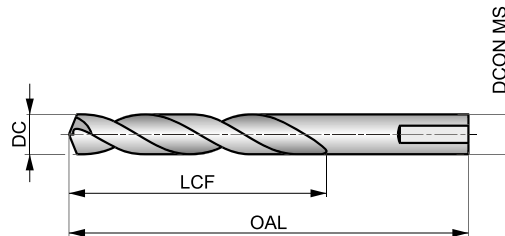
A321

DORMER PRAMET



HSS Intermediate Length Drill, Steam and Bronze Tempered Surface Finish

Heavy duty design drill with three-flat shanks for medium depth holes. Primarily suited for hand-held operations and pillar drill machines. Three flats on the shank allow for non-slip chucking. The self-centering 135° split point reduces thrust force and the steam and bronze tempered surface finish improves lubricity.



HSS	DORMER	3.5xD
135°	ST Bronze	
R	DC h8	

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page 12.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
33 H	37 H	38 H	28 H	25 F	22 E	19 F	15 F	13 E	11 F	10 E	8 D	21 E	17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
18 E	15 E	9 G	8 G	7 G	9 C	30 H	22 F	17 F	25 E	20 E	16 E	22 E	17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
13 E	20 E	15 E	11 E	10 E	8 E	23 E	17 E	13 E	33 J	25 J	17 I	42 H	37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
27 H	59 H	35 I	18 G	30 J	28 H	14 F	23 E	12 D	6 B	8 E	4 A	6 E	3 A
S4.1	S4.2												
5 E	2 A												

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
A3213.0	3.00	0.1180	37.0	64.0	3.00
A3213.3	3.30	0.1300	40.0	67.0	3.30
A3213.4	3.40	0.1340	40.0	67.0	3.40
A3213.5	3.50	0.1380	40.0	67.0	3.50
A3214.0	4.00	0.1580	47.0	74.0	4.00
A3214.1	4.10	0.1610	47.0	74.0	4.10
A3214.2	4.20	0.1650	47.0	74.0	4.20
A3214.3	4.30	0.1690	47.0	74.0	4.30
A3214.5	4.50	0.1770	49.0	77.0	4.50
A3214.9	4.90	0.1930	50.0	80.0	4.90
A3215.0	5.00	0.1970	50.0	80.0	5.00
A3215.1	5.10	0.2010	50.0	80.0	5.10
A3215.3	5.30	0.2090	52.0	84.0	5.30
A3215.5	5.50	0.2170	52.0	84.0	5.50
A3216.0	6.00	0.2360	52.0	90.0	6.00
A3216.3	6.30	0.2480	52.0	90.0	6.30
A3216.5	6.50	0.2560	55.0	93.0	6.50

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
A3216.8	6.80	0.2680	59.0	97.0	6.80
A3217.0	7.00	0.2760	59.0	97.0	7.00
A3217.3	7.30	0.2870	62.0	100.0	7.30
A3217.5	7.50	0.2950	62.0	100.0	7.50
A3218.0	8.00	0.3150	67.0	105.0	8.00
A3218.5	8.50	0.3350	68.0	107.0	8.50
A3219.0	9.00	0.3540	70.0	108.0	9.00
A3219.5	9.50	0.3740	70.0	110.0	9.50
A32110.0	10.00	0.3940	74.0	113.0	10.00
A32110.3	10.30	0.4060	74.0	113.0	10.30
A32110.5	10.50	0.4130	75.0	115.0	10.50
A32111.0	11.00	0.4330	77.0	117.0	11.00
A32111.5	11.50	0.4530	79.0	120.0	11.50
A32112.0	12.00	0.4720	85.0	126.0	12.00
A32112.5	12.50	0.4920	88.0	130.0	12.50
A32113.0	13.00	0.5120	88.0	130.0	13.00

A113

BRIGHT HSS DRILL

INTRODUCTION



Introducing cost effective general purpose HSS jobber drill with bright finish – Dormer A113. Conventional 118° point provides strength, while bright finish improves chip flow and its evacuation, especially in soft, sticky ferrous alloys and non-ferrous alloys. Easy multiple regrinding brings added value for maintenance mechanics, field service engineers, craftspeople, contract engineers, and educational institutions.

DORMER PRAMET®



A113



- HSS Jobber drill
- Bright finish
- Metric range: 0.8 – 14 mm
- Imperial range: 3/64 – 35/64"

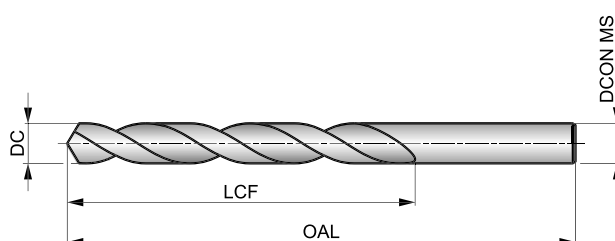
A113

DORMER PRAMET



HSS Jobber Drill, Bright Finish

A versatile all-around drill with a 118° conventional point, which provides strength and is easy to regrind, making it very cost-effective for general purpose applications. Usable for hand-held and machine drilling. Bright finish improves chip flow in soft ferrous or non-ferrous materials.



HSS	DIN 338	4xD
118°	Bright	
λ 20-35°	R	DC h8

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page XY.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	N1.1	N1.2
■ 29 H	■ 33 H	■ 33 H	■ 25 H	■ 22 F	■ 19 E	■ 26 H	■ 19 F	■ 15 F	■ 22 E	■ 18 E	■ 14 E	■ 29 J	■ 22 J
N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3							
■ 15 I	■ 37 H	■ 33 H	■ 24 H	■ 52 H	■ 31 I	■ 16 G							

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A113.8	—	0.80	0.0315	10.0	30.0	0.80
A113.9	—	0.90	0.0354	11.0	32.0	0.90
A1131.0	—	1.00	0.0394	12.0	34.0	1.00
A113N60	N60	1.02	0.0402	12.0	34.0	1.02
A1131.05	—	1.05	0.0413	12.0	34.0	1.05
A113N57	N57	1.09	0.0429	14.0	36.0	1.09
A1131.1	—	1.10	0.0433	14.0	36.0	1.10
A113N56	N56	1.18	0.0465	14.0	36.0	1.18
A1133/64	3/64	1.19	0.0469	16.0	38.0	1.19
A1131.2	—	1.20	0.0472	16.0	38.0	1.20
A1131.3	—	1.30	0.0512	16.0	38.0	1.30
A113N55	N55	1.32	0.0520	16.0	38.0	1.32
A1131.35	—	1.35	0.0531	18.0	40.0	1.35
A1131.4	—	1.40	0.0551	18.0	40.0	1.40
A1131.5	—	1.50	0.0591	18.0	40.0	1.50
A113N53	N53	1.51	0.0594	20.0	43.0	1.51
A1131.55	—	1.55	0.0610	20.0	43.0	1.55
A1131/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1131.6	—	1.60	0.0630	20.0	43.0	1.60
A113N52	N52	1.61	0.0634	20.0	43.0	1.61
A1131.65	—	1.65	0.0650	20.0	43.0	1.65
A1131.7	—	1.70	0.0669	20.0	43.0	1.70
A113N50	N50	1.78	0.0701	22.0	46.0	1.78
A1131.8	—	1.80	0.0709	22.0	46.0	1.80
A113N49	N49	1.85	0.0728	22.0	46.0	1.85
A1131.9	—	1.90	0.0748	22.0	46.0	1.90
A113N48	N48	1.93	0.0760	24.0	49.0	1.93
A1131.95	—	1.95	0.0768	24.0	49.0	1.95
A1135/64	5/64	1.98	0.0781	24.0	49.0	1.98
A1132.0	—	2.00	0.0787	24.0	49.0	2.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A113N46	N46	2.06	0.0811	24.0	49.0	2.06
A1132.1	—	2.10	0.0827	24.0	49.0	2.10
A113N44	N44	2.18	0.0858	27.0	53.0	2.18
A1132.2	—	2.20	0.0866	27.0	53.0	2.20
A113N43	N43	2.26	0.0890	27.0	53.0	2.26
A1132.3	—	2.30	0.0906	27.0	53.0	2.30
A113N42	N42	2.37	0.0933	30.0	57.0	2.37
A1133/32	3/32	2.38	0.0938	30.0	57.0	2.38
A1132.4	—	2.40	0.0945	30.0	57.0	2.40
A113N41	N41	2.44	0.0961	30.0	57.0	2.44
A1132.5	—	2.50	0.0984	30.0	57.0	2.50
A113N39	N39	2.53	0.0996	30.0	57.0	2.53
A1132.55	—	2.55	0.1004	30.0	57.0	2.55
A1132.6	—	2.60	0.1024	30.0	57.0	2.60
A113N37	N37	2.64	0.1039	30.0	57.0	2.64
A1132.7	—	2.70	0.1063	33.0	61.0	2.70
A113N36	N36	2.71	0.1067	33.0	61.0	2.71
A1132.75	—	2.75	0.1083	33.0	61.0	2.75
A1137/64	7/64	2.78	0.1094	33.0	61.0	2.78
A1132.8	—	2.80	0.1102	33.0	61.0	2.80
A113N34	N34	2.82	0.1110	33.0	61.0	2.82
A113N33	N33	2.87	0.1130	33.0	61.0	2.87
A1132.9	—	2.90	0.1142	33.0	61.0	2.90
A113N32	N32	2.95	0.1161	33.0	61.0	2.95
A1133.0	—	3.00	0.1181	33.0	61.0	3.00
A113N31	N31	3.05	0.1201	36.0	65.0	3.05
A1133.1	—	3.10	0.1220	36.0	65.0	3.10
A1131/8	1/8	3.17	0.1250	36.0	65.0	3.17
A1133.2	—	3.20	0.1260	36.0	65.0	3.20
A1133.25	—	3.25	0.1280	36.0	65.0	3.25

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A113N30	N30	3.26	0.1283	36.0	65.0	3.26
A1133.3	—	3.30	0.1299	36.0	65.0	3.30
A1133.4	—	3.40	0.1339	39.0	70.0	3.40
A113N29	N29	3.45	0.1358	39.0	70.0	3.45
A1133.5	—	3.50	0.1378	39.0	70.0	3.50
A1139/64	9/64	3.57	0.1406	39.0	70.0	3.57
A1133.6	—	3.60	0.1417	39.0	70.0	3.60
A1133.7	—	3.70	0.1457	39.0	70.0	3.70
A113N26	N26	3.73	0.1469	39.0	70.0	3.73
A113N25	N25	3.80	0.1496	43.0	75.0	3.80
A1133.8	—	3.80	0.1496	43.0	75.0	3.80
A113N24	N24	3.86	0.1520	43.0	75.0	3.86
A1133.9	—	3.90	0.1535	43.0	75.0	3.90
A113N23	N23	3.91	0.1539	43.0	75.0	3.91
A1133.95	—	3.95	0.1555	43.0	75.0	3.95
A1135/32	5/32	3.97	0.1563	43.0	75.0	3.97
A113N22	N22	3.99	0.1571	43.0	75.0	3.99
A1134.0	—	4.00	0.1575	43.0	75.0	4.00
A113N21	N21	4.04	0.1591	43.0	75.0	4.04
A1134.05	—	4.05	0.1594	43.0	75.0	4.05
A113N20	N20	4.09	0.1610	43.0	75.0	4.09
A1134.1	—	4.10	0.1614	43.0	75.0	4.10
A1134.15	—	4.15	0.1634	43.0	75.0	4.15
A1134.2	—	4.20	0.1654	43.0	75.0	4.20
A1134.25	—	4.25	0.1673	43.0	75.0	4.25
A1134.3	—	4.30	0.1693	47.0	80.0	4.30
A11311/64	11/64	4.37	0.1719	47.0	80.0	4.37
A1134.4	—	4.40	0.1732	47.0	80.0	4.40
A1134.5	—	4.50	0.1772	47.0	80.0	4.50
A1134.6	—	4.60	0.1811	47.0	80.0	4.60
A1134.7	—	4.70	0.1850	47.0	80.0	4.70
A1133/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1134.8	—	4.80	0.1890	52.0	86.0	4.80
A113N11	N11	4.85	0.1909	52.0	86.0	4.85
A1134.9	—	4.90	0.1929	52.0	86.0	4.90
A113N10	N10	4.92	0.1937	52.0	86.0	4.92
A1134.95	—	4.95	0.1949	52.0	86.0	4.95
A1135.0	—	5.00	0.1969	52.0	86.0	5.00
A113N8	N8	5.06	0.1992	52.0	86.0	5.06
A1135.1	—	5.10	0.2008	52.0	86.0	5.10
A11313/64	13/64	5.16	0.2031	52.0	86.0	5.16
A1135.2	—	5.20	0.2047	52.0	86.0	5.20
A1135.3	—	5.30	0.2087	52.0	86.0	5.30
A1135.4	—	5.40	0.2126	57.0	93.0	5.40
A1135.5	—	5.50	0.2165	57.0	93.0	5.50
A1137/32	7/32	5.56	0.2188	57.0	93.0	5.56
A1135.6	—	5.60	0.2205	57.0	93.0	5.60
A1135.7	—	5.70	0.2244	57.0	93.0	5.70
A1135.8	—	5.80	0.2283	57.0	93.0	5.80
A1135.9	—	5.90	0.2323	57.0	93.0	5.90
A11315/64	15/64	5.95	0.2344	57.0	93.0	5.95
A1136.0	—	6.00	0.2362	57.0	93.0	6.00
A113B	B	6.04	0.2378	63.0	101.0	6.04
A1136.1	—	6.10	0.2402	63.0	101.0	6.10
A1136.2	—	6.20	0.2441	63.0	101.0	6.20
A1136.3	—	6.30	0.2480	63.0	101.0	6.30
A1131/4	1/4	6.35	0.2500	63.0	101.0	6.35
A1136.4	—	6.40	0.2520	63.0	101.0	6.40
A1136.5	—	6.50	0.2559	63.0	101.0	6.50
A1136.6	—	6.60	0.2598	63.0	101.0	6.60
A113G	G	6.63	0.2610	63.0	101.0	6.63
A1136.7	—	6.70	0.2638	63.0	101.0	6.70

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A11317/64	17/64	6.75	0.2656	69.0	109.0	6.75
A1136.8	—	6.80	0.2677	69.0	109.0	6.80
A1136.9	—	6.90	0.2717	69.0	109.0	6.90
A1137.0	—	7.00	0.2756	69.0	109.0	7.00
A1137.1	—	7.10	0.2795	69.0	109.0	7.10
A1139/32	9/32	7.14	0.2813	69.0	109.0	7.14
A1137.2	—	7.20	0.2835	69.0	109.0	7.20
A1137.3	—	7.30	0.2874	69.0	109.0	7.30
A1137.4	—	7.40	0.2913	69.0	109.0	7.40
A1137.5	—	7.50	0.2953	69.0	109.0	7.50
A11319/64	19/64	7.54	0.2969	75.0	117.0	7.54
A1137.6	—	7.60	0.2992	75.0	117.0	7.60
A1137.7	—	7.70	0.3031	75.0	117.0	7.70
A1137.8	—	7.80	0.3071	75.0	117.0	7.80
A1137.9	—	7.90	0.3110	75.0	117.0	7.90
A1135/16	5/16	7.94	0.3125	75.0	117.0	7.94
A1138.0	—	8.00	0.3150	75.0	117.0	8.00
A1138.1	—	8.10	0.3189	75.0	117.0	8.10
A1138.2	—	8.20	0.3228	75.0	117.0	8.20
A1138.3	—	8.30	0.3268	75.0	117.0	8.30
A11321/64	21/64	8.33	0.3281	75.0	117.0	8.33
A1138.4	—	8.40	0.3307	75.0	117.0	8.40
A1138.5	—	8.50	0.3346	75.0	117.0	8.50
A1138.6	—	8.60	0.3386	81.0	125.0	8.60
A1138.7	—	8.70	0.3425	81.0	125.0	8.70
A11311/32	11/32	8.73	0.3438	81.0	125.0	8.73
A1138.8	—	8.80	0.3465	81.0	125.0	8.80
A113S	S	8.84	0.3480	81.0	125.0	8.84
A1138.9	—	8.90	0.3504	81.0	125.0	8.90
A1139.0	—	9.00	0.3543	81.0	125.0	9.00
A1139.1	—	9.10	0.3583	81.0	125.0	9.10
A11323/64	23/64	9.13	0.3594	81.0	125.0	9.13
A1139.2	—	9.20	0.3622	81.0	125.0	9.20
A1139.3	—	9.30	0.3661	81.0	125.0	9.30
A113U	U	9.34	0.3677	81.0	125.0	9.34
A1139.4	—	9.40	0.3701	81.0	125.0	9.40
A1139.5	—	9.50	0.3740	81.0	125.0	9.50
A1133/8	3/8	9.53	0.3750	87.0	133.0	9.53
A1139.6	—	9.60	0.3780	87.0	133.0	9.60
A1139.7	—	9.70	0.3819	87.0	133.0	9.70
A1139.8	—	9.80	0.3858	87.0	133.0	9.80
A1139.9	—	9.90	0.3898	87.0	133.0	9.90
A11325/64	25/64	9.92	0.3906	87.0	133.0	9.92
A11310.0	—	10.00	0.3937	87.0	133.0	10.00
A11310.1	—	10.10	0.3976	87.0	133.0	10.10
A11310.2	—	10.20	0.4016	87.0	133.0	10.20
A11310.3	—	10.30	0.4055	87.0	133.0	10.30
A11313/32	13/32	10.32	0.4063	87.0	133.0	10.32
A11310.4	—	10.40	0.4094	87.0	133.0	10.40
A11310.5	—	10.50	0.4134	87.0	133.0	10.50
A11310.6	—	10.60	0.4173	87.0	133.0	10.60
A11310.7	—	10.70	0.4213	94.0	142.0	10.70
A11327/64	27/64	10.72	0.4219	94.0	142.0	10.72
A11310.8	—	10.80	0.4252	94.0	142.0	10.80
A11310.9	—	10.90	0.4291	94.0	142.0	10.90
A11311.0	—	11.00	0.4331	94.0	142.0	11.00
A11311.1	—	11.10	0.4370	94.0	142.0	11.10
A1137/16	7/16	11.11	0.4375	94.0	142.0	11.11
A11311.2	—	11.20	0.4409	94.0	142.0	11.20
A11311.3	—	11.30	0.4449	94.0	142.0	11.30
A11311.4	—	11.40	0.4488	94.0	142.0	11.40
A11311.5	—	11.50	0.4528	94.0	142.0	11.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A11329/64	29/64	11.51	0.4531	94.0	142.0	11.51
A11311.6	—	11.60	0.4567	94.0	142.0	11.60
A11311.7	—	11.70	0.4606	94.0	142.0	11.70
A11311.8	—	11.80	0.4646	94.0	142.0	11.80
A11311.9	—	11.90	0.4685	101.0	151.0	11.90
A11315/32	15/32	11.91	0.4688	101.0	151.0	11.91
A11312.0	—	12.00	0.4724	101.0	151.0	12.00
A11312.1	—	12.10	0.4764	101.0	151.0	12.10
A11312.2	—	12.20	0.4803	101.0	151.0	12.20
A11312.3	—	12.30	0.4843	101.0	151.0	12.30
A11331/64	31/64	12.30	0.4844	101.0	151.0	12.30
A11312.4	—	12.40	0.4882	101.0	151.0	12.40
A11312.5	—	12.50	0.4921	101.0	151.0	12.50
A11312.6	—	12.60	0.4961	101.0	151.0	12.60
A1131/2	1/2	12.70	0.5000	101.0	151.0	12.70
A11312.7	—	12.70	0.5000	101.0	151.0	12.70

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A11312.8	—	12.80	0.5039	101.0	151.0	12.80
A11312.9	—	12.90	0.5079	101.0	151.0	12.90
A11313.0	—	13.00	0.5118	101.0	151.0	13.00
A11333/64	33/64	13.10	0.5156	101.0	151.0	13.10
A11313.1	—	13.10	0.5157	101.0	151.0	13.10
A11313.2	—	13.20	0.5197	101.0	151.0	13.20
A11313.3	—	13.30	0.5236	108.0	160.0	13.30
A11313.4	—	13.40	0.5276	108.0	160.0	13.40
A11317/32	17/32	13.49	0.5313	108.0	160.0	13.49
A11313.5	—	13.50	0.5315	108.0	160.0	13.50
A11313.6	—	13.60	0.5354	108.0	160.0	13.60
A11313.7	—	13.70	0.5394	108.0	160.0	13.70
A11313.8	—	13.80	0.5433	108.0	160.0	13.80
A11335/64	35/64	13.89	0.5469	108.0	160.0	13.89
A11313.9	—	13.90	0.5472	108.0	160.0	13.90
A11314.0	—	14.00	0.5512	108.0	160.0	14.00

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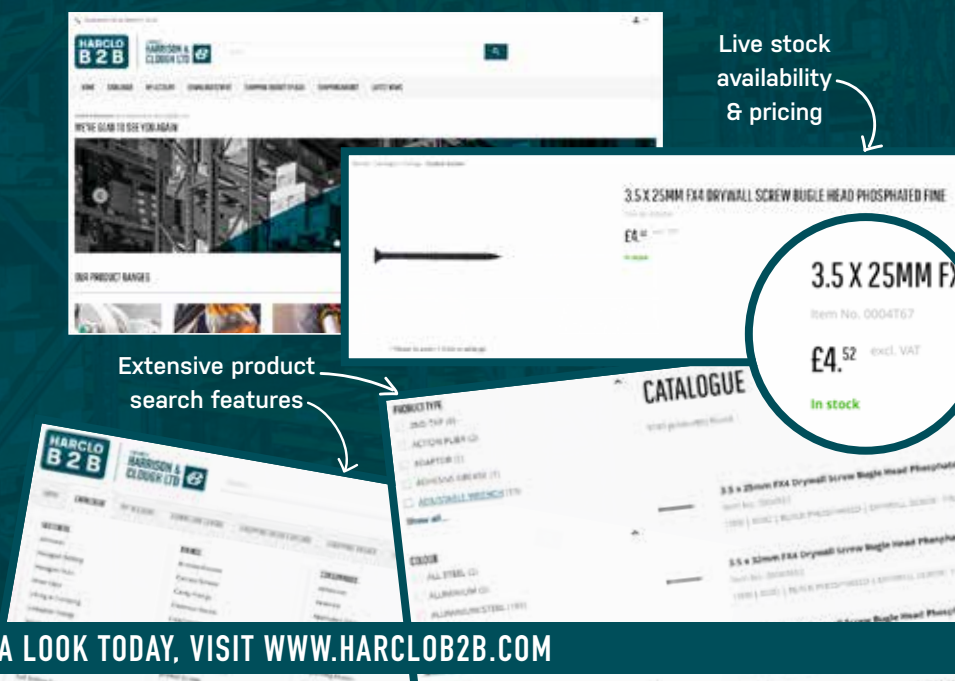
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INTRODUCTION



A new assortment of general purpose, economical taps with a specific focus for operations using handheld power tools has been introduced. The Dormer E556 and E557 metric range features strong design suitable for maintenance mechanics, field service engineers, crafts people, contract engineers and educational institutes.

DORMER PRAMET®**E556(M)**

- For through holes only
- For soft steels and carbon steels
- Range: M3 – M12

**E557(M)**

- For blind holes
- For soft steels and carbon steels
- Range: M3 – M12

FEATURES & BENEFITS

Simple, strong design
in high-quality HSS.



COST-EFFECTIVE
solution for general usage.

Bright surface finish easing swarf flow.



APPLICATION VERSATILITY
for handheld power tools operations.

Short and thick tap style increases
rigidity.

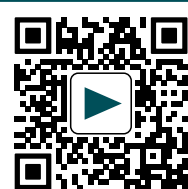


STABLE AND RELIABLE
performance up to 2xD holes depth.

APPLICATION EXAMPLES



VIDEO



E556(M)

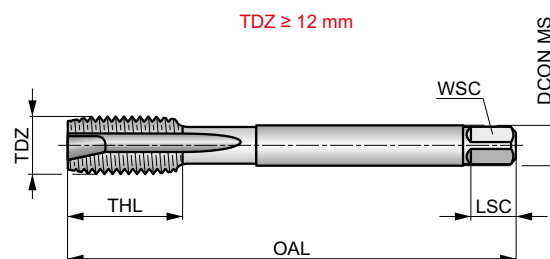
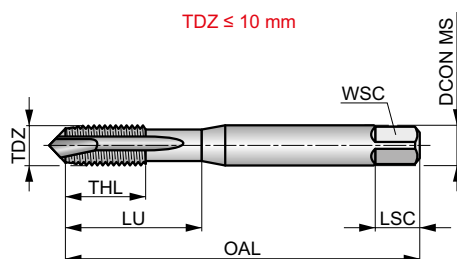
DORMER PRAMET



HSS Spiral Point Power Tool Tap, Metric, ISO Standard

Ideal for hand held tapping with the use of Power Tools. Suited for through holes only the spiral point propel the chips ahead of the cutting zone, thus reducing loading and clogging in the flutes. The bright finish improve the chip flow in soft and non-ferrous materials.

M	ISO 529	6H
	2×D	HSS
B 3.5-5		
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1 ■ 14	P1.2 ■ 15	P1.3 ■ 16	P2.1 ■ 11	P2.2 ■ 9	P3.1 ■ 8	P3.2 ■ 5
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Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
E556M3	3	0.50	48.0	11	3.15	2.50	5	3	2.50	18.00
E556M4	4	0.70	53.0	13	4.00	3.15	6	3	3.30	21.00
E556M5	5	0.80	58.0	16	5.00	4.00	7	3	4.20	25.00
E556M6	6	1.00	66.0	19	6.30	5.00	8	3	5.00	30.00
E556M8	8	1.25	72.0	22	8.00	6.30	9	3	6.80	35.00
E556M10	10	1.50	80.0	24	10.00	8.00	11	3	8.50	39.00
E556M12	12	1.75	89.0	29	9.00	7.10	10	3	10.30	—

E557(M)

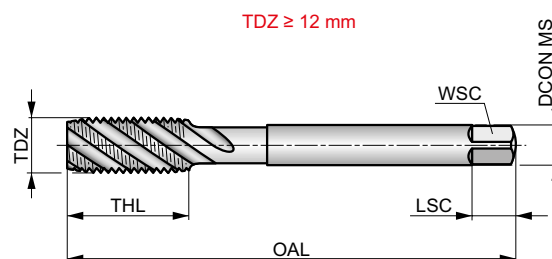
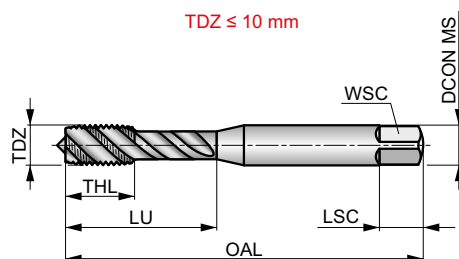
DORMER PRAMET



HSS Spiral Flute Power Tool Tap, Metric, ISO Standard

Ideal for hand held tapping with the use of Power Tools. Tapping typically produce long stringy chips which, when not evacuated properly, can cause serious problems especially when threading blind holes. The spiral flute design counters this problem as it draws chips from the hole being tapped.

M	ISO 529	6H
	2xD	HSS
C 2-3		I 35°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2
■ 14	■ 15	■ 16	■ 11	■ 9	■ 8	■ 5

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
E557M3	3	0.50	48.0	6	3.15	2.50	5	3	2.50	18.00
E557M4	4	0.70	53.0	8	4.00	3.15	6	3	3.30	21.00
E557M5	5	0.80	58.0	10	5.00	4.00	7	3	4.20	25.00
E557M6	6	1.00	66.0	12	6.30	5.00	8	3	5.00	30.00
E557M8	8	1.25	72.0	15	8.00	6.30	9	3	6.80	35.00
E557M10	10	1.50	80.0	18	10.00	8.00	11	3	8.50	39.00
E557M12	12	1.75	89.0	21	9.00	7.10	10	3	10.30	—

INTRODUCTION



Introducing the Dormer E559 series, a fresh line of cost-effective hand and serial taps. The reliable tapping design ensures a smooth cutting action and efficient chip evacuation. Our extensive selection includes the most popular M, MF, UNC and UNF thread forms, available in a wide range of sizes. The Dormer E559 is the right economical choice for maintenance mechanics, field service engineers, craftspeople, contract engineers, and educational institutions.

DORMER PRAMET®



EXPLANATION HAND TAPS

- + Hand taps cut always a full thread profile
- + Any tap lead can be used for tapping in through holes
- Limitations on usable thread lengths in blind holes



E559N01

- Taper lead



E599N02

- Plug lead



E559N03

- Bottoming lead (Finishing tap)

HAND TAPS OVERVIEW

Straight Flute Taper Lead Hand Tap, ISO Standard

Versatile tap design for hand use or machine tapping in medium strength, medium carbon and alloy steel. With a taper lead chamfer which produces the thinnest chips providing a very gradual and smooth cutting action. Considered to be the best choice for producing short through holes up to 1.5xD.

  E559NO1(M) • Metric range: M3 – M20	  E559NO1(MF) • Metric-fine range: M8×1 – M16×1.5	  E559NO1(UNC) • UNC range: No. 10-24 – 1/2"	  E559NO1(UNF) • UNF range: No. 10-32 – 1/2"-20
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Straight Flute Plug Lead Hand Tap, ISO Standard

Versatile tap design for hand use or machine tapping in medium strength, medium carbon and alloy steel. With a plug lead chamfer which gives the tap a gradual cutting action. Great for producing through holes, as they are almost as easy as taper lead taps to start, yet also offer a more complete set of threads.

  E559NO2(M) • Metric range: M3 – M20	  E559NO2(MF) • Metric-fine range: M8×1 – M16×1.5	  E559NO2(UNC) • UNC range: No. 10-24 – 1/2"	  E559NO2(UNF) • UNF range: No. 10-32 – 1/2"-20
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Straight Flute Bottoming Lead Hand Tap, ISO Standard

Versatile tap for medium strength carbon and alloy steel. With bottoming lead, which though it is hard to start threading with is capable of cutting thread almost all of the way to the bottom of a blind hole. Best used as machine tap or if by hand in sequence after taper and plug lead or starter and intermediate serial tap.

  E559NO3(M) • Metric range: M3 – M20	  E559-NO3(MF) • Metric-fine range: M8×1 – M16×1.5	  E559-NO3(UNC) • UNC range: No. 10-24 – 1/2"	  E559-NO3(UNF) • UNF range: No. 10-32 – 1/2"-20
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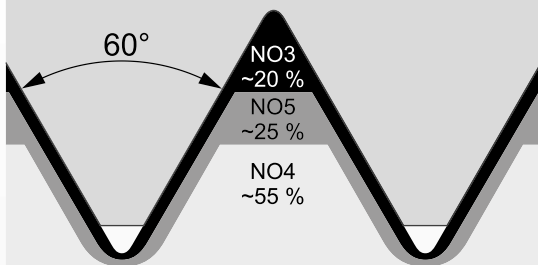
Set of 3 Straight Flute Hand Taps, ISO Standard

The most versatile taps for hand use or machine tapping through or blind holes in medium strength, medium carbon and alloy steel. Set including taps with 3 different chamfer lengths; taper lead which is ideally for short through holes, plug perfect for deeper through holes and bottoming best suited for blind holes.

  E559NO6(M) • Metric range: M3 – M20	  E559NO6(MF) • Metric-fine range: M8×1 – M16×1.5	  E559NO6(UNC) • UNC range: No. 10-24 – 1/2"	  E559NO6(UNF) • UNF range: No. 10-32 – 1/2"-20
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Note: Serial taps NO4 and NO5 do not cut a full thread profile!



EXPLANATION SERIAL TAPS

- + This set of serial taps requires lower cutting force, ideal to use with wrench.
- + This set of serial taps can be a problem solver for harder materials tapping.
- Serial taps always need to be used in sequence from NO4 to NO3.



E559NO4

- Starter tap



E559NO5

- Seconding tap



E559NO3

- Finishing tap (Bottoming lead)

SERIAL TAPS OVERVIEW

Set of 3 Straight Flute Serial Hand Taps, ISO Standard

Ideal for hand tapping tough materials. The straight flute design makes it suitable for both through and blind holes. Set of 3 taps to be used in sequence, first the starter tap to make a roughing cut, second the intermediate to cut the thread a little fuller and third the finisher for smoothing the thread and making it exact.



Set of 2 Straight Flute Serial Hand Taps, ISO Standard

Ideal for hand tapping tough materials. The straight flute design makes it suitable for both through and blind holes. Set of 2 taps to be used in sequence, first the starter tap to make a roughing cut and a finisher for smoothing the thread and making it exact.



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INTRODUCTION



The Dormer assortment for MRO & General Engineering applications has been expanded with a range of screw extractors, a problem solver for removing broken or seized screws. There are nine individual products, each one for different bolt size starting from M5 up to M50, or 3/16" up to 2 1/8" respectively. All are manufactured from specific high-quality steel to withstand the flex and high torque loads experienced during operation. We also introduce two variants of extractor sets and five variants of bolt removal kits, which contains Burrs P100, P101, HSS-E stub drill A117, and an extractor M900 of proper size.

DORMER PRAMET®


VIDEO



M900

- Spiral fluted screw extractor
- Application range:
M5 – M50 (3/16" – 2 1/8")



M901

- Two Set of extractors
- Variant A: Five pieces set
M5-M20 (3/16" – 3/4")
- Variant B: Six pieces set
M5-M30 (3/16" – 1")



M902

- Bolt removal kits
- Available in 5 variants
- Each contains:
Burrs P100, P101
HSS-E Stub Drill A117
Extractor M900

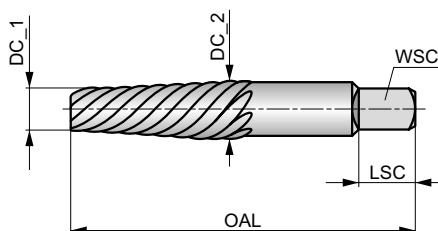
M900

DORMER PRAMET



Screw Extractor

Screw extractor is used counter-clockwise to remove broken right-handed bolts from threaded holes without damaging threads. It's necessary to drill guide hole of proper size before using the extractor.



Drill Size A: To be used on low or medium tensile strength screws. Drill Size B: To be used on high tensile strength screws.

Product							DC_1	DC_2	WSC	LSC	OAL
		(mm)	(mm)	(inch)	(inch)	(inch)	(mm)	(mm)	(mm)	(mm)	(mm)
M9001	M5 – M6	2	2	3/16" – 1/4"	5/64	5/64	1.37	3.20	2.60	5.10	51.1
M9002	M6 – M8	2.8	3	1/4" – 5/16"	7/64	1/8	2.18	4.80	3.90	6.70	61.1
M9003	M8 – M12	4	4.2	5/16" – 7/16"	5/32	11/64	3.18	6.40	4.80	7.50	68.7
M9004	M12 – M14	5.5	6	7/16" – 9/16"	7/32	15/64	4.37	8.00	6.00	8.00	76.7
M9005	M14 – M20	7.2	8	9/16" – 3/4"	9/32	5/16	6.35	11.10	8.30	11.50	86.1
M9006	M20 – M30	10.5	11	3/4" – 1"	13/32	7/16	9.53	15.90	11.90	13.10	94.4
M9007	M30 – M42	13.5	14.5	1" – 1.3/8"	17/32	9/16	12.30	19.10	14.30	17.90	107.4
M9008	M42 – M45	20.5	21.5	1.3/8" – 1.3/4"	13/16	27/32	18.65	25.10	19.80	19.40	114.3
M9009	M45 – M50	27	28	1.3/4" – 2.1/8"	1.1/16	1.3/32	24.61	32.30	24.60	22.60	121.3

M901

DORMER PRAMET



Screw Extractor Set

Set of Screw Extractor sizes M9001 – M9005 or M9001 – M9006.

A = Styles in Set, B = No. in Set, C = Diameters in Set.

Product	Nr.	A	B	C
M901A	A	M900	5	M9001 – M9005
M901B	B	M900	6	M9001 – M9006

M902

DORMER PRAMET



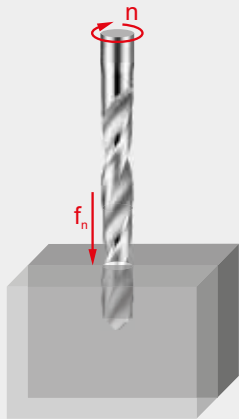
Bolt Removal Kit

Tools for removing broken right-handed bolts come in a set of four. First, use the P100 burr to flatten the bolt. Second, use the P101 burr to create a starting cone. Third, use the HSS-E stub drill A117 to drill a hole for the extractor. Finally, use the screw extractor in a counter-clockwise motion to remove the broken bolt without damaging the threads.

A = Styles in Set, B = No. in Set, C = Diameters in Set.

Product	Nr.	A	B	C
M902M6-M8	M6 – M8	M900, P100, P101, A117	4	P1004.9, P1014.9, A1173.0, M9002
M902M8-M10	M8 – M10	M900, P100, P101, A117	4	P1006.4, P1016.4, A1174.0, M9003
M902M10-M12	M10 – M12	M900, P100, P101, A117	4	P1007.8, P1017.8, A1174.2, M9003
M902M12-M14	M12 – M14	M900, P100, P101, A117	4	P1009.3, P1019.3, A1176.0, M9004
M902M14-M16	M14 – M16	M900, P100, P101, A117	4	P1010.7, P10110.7, A1178.0, M9005

DRILLING FEED RATE CHART



Feed per revolution (f_n in mm/rev)
Depending on the working conditions
it might be necessary to adjust these
values $\pm 25\%$.

How to use this table to find the feed per revolution (f_n):

1. Find your Alpha Code on the product page (example: 46J, "J" is the Alpha Code).
2. Find the closest diameter for your cutting application in the top row of the table.
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter and Alpha Code is the feed per revolution (f_n).

		ϕ DC (mm)																		
		0.15	0.50	1.00	2.00	3.00	4.00	5.00	6.00	8.00	10.00	12.00	15.00	16.00	20.00	25.00	30.00	40.00	50.00	100.00
Feed rates	A	0.003	0.006	0.012	0.023	0.029	0.032	0.036	0.042	0.054	0.062	0.069	0.082	0.086	0.110	0.125	0.135	0.155	0.175	0.263
	B	0.004	0.007	0.014	0.028	0.037	0.041	0.046	0.053	0.067	0.080	0.090	0.103	0.108	0.135	0.153	0.165	0.188	0.208	0.312
	C	0.004	0.008	0.015	0.032	0.044	0.050	0.056	0.064	0.080	0.098	0.110	0.125	0.130	0.160	0.180	0.195	0.220	0.240	0.360
	D	0.004	0.008	0.016	0.038	0.053	0.060	0.068	0.078	0.098	0.119	0.130	0.149	0.155	0.188	0.210	0.228	0.253	0.275	0.413
	E	0.004	0.009	0.017	0.043	0.062	0.071	0.080	0.092	0.115	0.140	0.150	0.173	0.180	0.215	0.240	0.260	0.285	0.310	0.465
	F	0.005	0.009	0.018	0.050	0.073	0.084	0.095	0.109	0.138	0.165	0.178	0.202	0.210	0.248	0.275	0.295	0.320	0.343	0.515
	G	0.005	0.010	0.019	0.056	0.084	0.096	0.109	0.126	0.160	0.190	0.205	0.231	0.240	0.280	0.310	0.330	0.355	0.375	0.563
	H	0.005	0.010	0.020	0.066	0.102	0.116	0.130	0.150	0.190	0.228	0.243	0.271	0.280	0.320	0.355	0.375	0.398	0.418	0.627
	I	0.005	0.011	0.021	0.076	0.119	0.134	0.150	0.173	0.220	0.265	0.280	0.310	0.320	0.360	0.400	0.420	0.440	0.460	0.690
	J	0.006	0.012	0.024	0.084	0.135	0.152	0.170	0.197	0.250	0.298	0.315	0.349	0.360	0.405	0.445	0.465	0.485	0.503	0.755
	K	0.007	0.013	0.026	0.092	0.150	0.170	0.190	0.220	0.280	0.330	0.350	0.388	0.400	0.450	0.490	0.510	0.530	0.545	0.818
	L	0.007	0.014	0.028	0.101	0.165	0.186	0.208	0.240	0.305	0.360	0.385	0.419	0.430	0.485	0.525	0.545	0.568	0.588	0.882
	M	0.008	0.015	0.030	0.110	0.180	0.202	0.225	0.260	0.330	0.390	0.420	0.450	0.460	0.520	0.560	0.580	0.605	0.630	0.945
	N	0.008	0.016	0.032	0.119	0.195	0.218	0.242	0.280	0.355	0.420	0.455	0.481	0.490	0.555	0.595	0.615	0.642	0.672	1.008
	S	0.002	0.004	0.008	0.014	0.020	0.025	0.030	0.037	0.050	0.080	0.100	0.123	0.130	0.150	0.170	0.190	0.220	0.240	–
	T	0.004	0.008	0.015	0.028	0.040	0.050	0.060	0.070	0.090	0.110	0.130	0.160	0.170	0.190	0.210	0.230	0.260	0.275	–
	U	0.007	0.013	0.026	0.048	0.070	0.080	0.090	0.107	0.140	0.170	0.200	0.223	0.230	0.240	0.270	0.300	0.360	0.375	–
	V	0.010	0.019	0.038	0.069	0.100	0.115	0.130	0.153	0.200	0.250	0.280	0.310	0.320	0.340	0.400	0.440	0.510	0.530	–
	W	0.012	0.025	0.049	0.089	0.130	0.150	0.170	0.200	0.260	0.330	0.380	0.418	0.430	0.450	0.470	0.490	0.520	0.540	–
	X	0.014	0.028	0.056	0.103	0.150	0.180	0.210	0.250	0.330	0.420	0.480	0.533	0.550	0.580	–	–	–	–	–
	Y	0.017	0.034	0.068	0.124	0.180	0.220	0.260	0.317	0.430	0.550	0.700	0.700	0.700	0.740	–	–	–	–	–
	Z	0.024	0.047	0.094	0.172	0.250	0.325	0.400	0.533	0.800	1.000	1.100	1.175	1.200	1.200	–	–	–	–	–

The background of the advertisement is a red brick wall. Various types of metal masonry fixings are scattered across the image, including large threaded rods with hexagonal heads, smaller wall plugs, and screws. A red plastic tool, possibly a drill bit or a screwdriver, is also visible on the right side.

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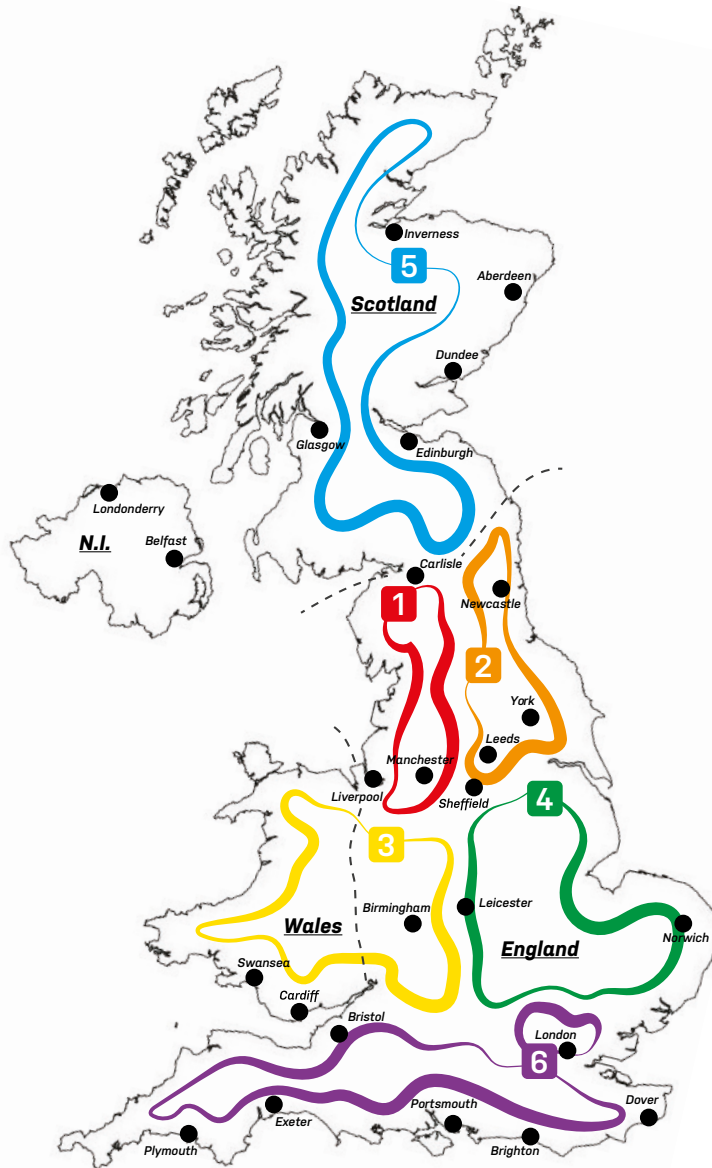
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