



MIRANDA FEW TOOLS
An Ashok Piramal Group company

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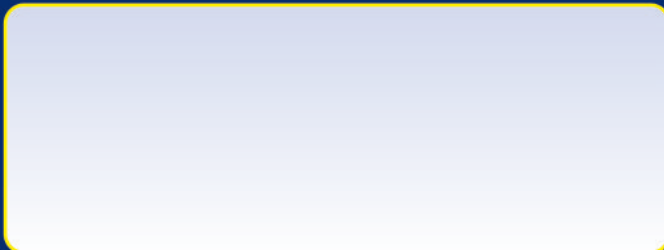
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Authorised Dealer



MIRANDA FEW TOOLS

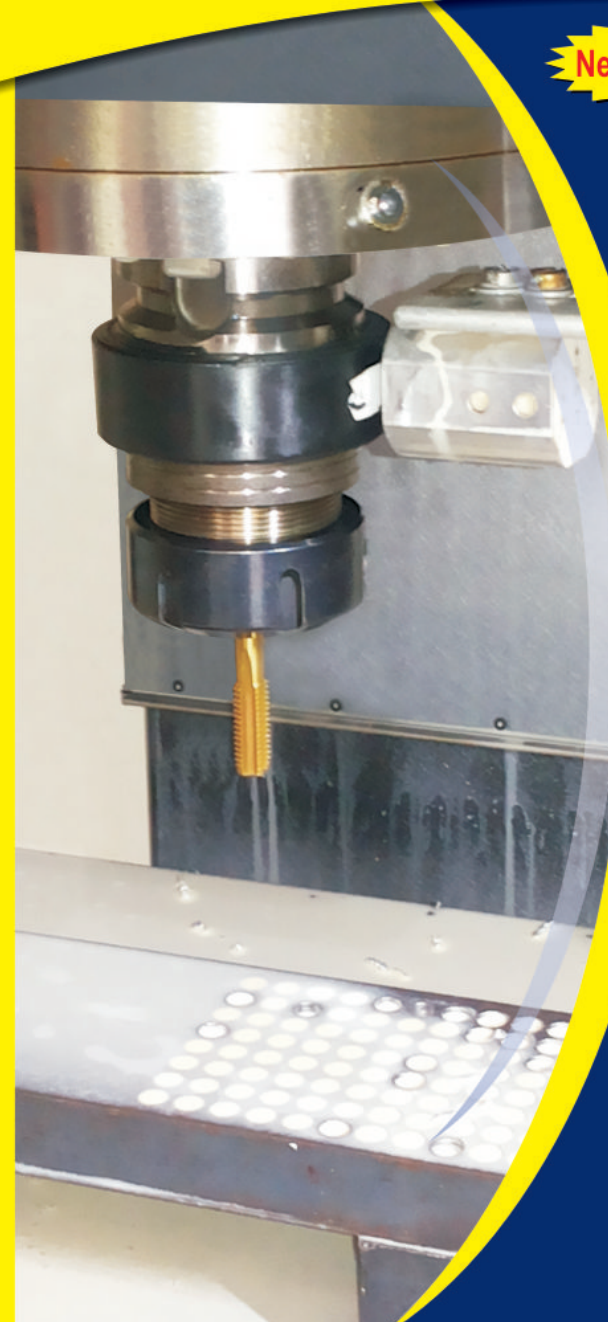


ASHOK
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New Launch

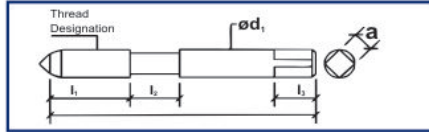
**MIRANDA
EDGE**

**HIGH PERFORMANCE
PLATINUM CUT TAPS**



HIGH PERFORMANCE PLATINUM CUT TAPS

ISO Metric HSS Ground Threads
Coarse and fine Pitch



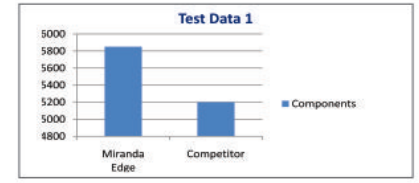
| Type | picture | Range | Series | Thread form | Blank Standard | Treatment | Material | Tapping type | Application |
|------------------------------|---------|--------|---------|-------------|------------------|-----------|----------|----------------|---|
| Straight Flute | | M3-M12 | MC 1 | M | IS -6175/ISO 529 | Bright | HSS-E | Blind/ Through | Medium to high tensile steel , Alloy steel , MS , general application |
| | | | MC2 | M | IS -6175/ISO 529 | TiN | | | |
| | | | MC3 | M | IS -6175/ISO 529 | TiAlN | | | |
| Straight Flute for cast iron | | M3-M12 | CI MC 1 | M | IS -6175/ISO 529 | Bright | HSS-E | Blind/ Through | cast iron , SG iron , abrasive type steel |
| | | | CI MC 2 | M | IS -6175/ISO 529 | TiN | | | |
| | | | CI MC 3 | M | IS -6175/ISO 529 | TiAlN | | | |
| Spiral Point | | M3-M12 | MA 1 | M | IS -6175/ISO 529 | Bright | HSS-E | Through holes | Medium to high tensile steel , Alloy steel , MS , general application |
| | | | MA 2 | M | IS -6175/ISO 529 | TiN | | | |
| | | | MA3 | M | IS -6175/ISO 529 | TiAlN | | | |
| Spiral Flute | | M3-M12 | MB 1 | M | IS -6175/ISO 529 | Bright | HSS-E | Blind Holes | Medium to high tensile steel , Alloy steel , MS , general application |
| | | | MB2 | M | IS -6175/ISO 529 | TiN | | | |
| | | | MB3 | M | IS -6175/ISO 529 | TiAlN | | | |

| Thread Designation | Pitch | Shank Diameter (d ₁) | Thread Length (l ₁) | Recess Length (l ₂) | Overall Length (L) | Square | | Tapping Drill dia |
|--------------------|-------|----------------------------------|---------------------------------|---------------------------------|--------------------|----------|--------------------------|-------------------|
| | | | | | | Size (a) | Length (l ₁) | |
| M3 | 0.50 | 3.15 | 11.00 | 7.00 | 48.00 | 2.50 | 5.00 | 2.50 |
| (M 3.5) | 0.60 | 3.55 | 13.00 | 7.00 | 50.00 | 2.80 | 5.00 | 2.90 |
| M4 | 0.70 | 4.00 | 13.00 | 8.00 | 53.00 | 3.15 | 6.00 | 3.30 |
| M5 | 0.80 | 5.00 | 16.00 | 9.00 | 58.00 | 4.00 | 7.00 | 4.20 |
| M6 | 1.00 | 6.30 | 19.00 | 11.00 | 66.00 | 5.00 | 8.00 | 5.00 |
| (M8) | 1.00 | 8.00 | 22.00 | 13.00 | 72.00 | 6.30 | 9.00 | 7.00 |
| M8 | 1.25 | 8.00 | 22.00 | 13.00 | 72.00 | 6.30 | 9.00 | 6.80 |
| (M10) | 1.25 | 10.00 | 24.00 | 15.00 | 80.00 | 8.00 | 11.00 | 8.80 |
| M10 | 1.50 | 10.00 | 24.00 | 15.00 | 80.00 | 8.00 | 11.00 | 8.50 |
| M12 | 1.75 | 9.00 | 29.00 | N.A. | 89.00 | 7.10 | 10.00 | 10.30 |
| M12 | 1.50 | 9.00 | 29.00 | N.A. | 89.00 | 7.10 | 10.00 | 10.50 |
| M12 | 1.25 | 9.00 | 29.00 | N.A. | 89.00 | 7.10 | 10.00 | 10.80 |

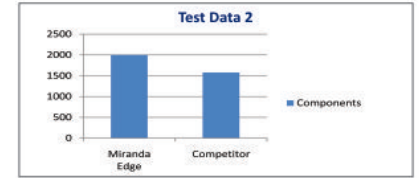
- Features :**
- General purpose high performance
 - High performance new innovative design for excellent chip evacuation
 - Increased static and dynamic strength of thread
 - Excellent thread surface quality
 - Premium grade steel - HSS-E for longer life
 - Newly developed Surface treatment to withstand the high stress and high heat associated

Test Data

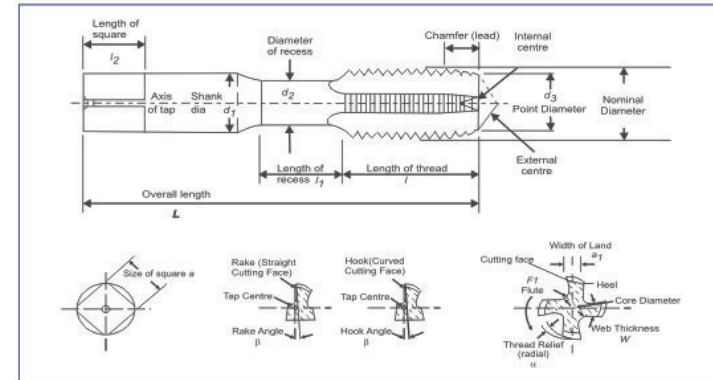
| Tool Type | Platinum Cut Tap | Competitor |
|---------------|------------------|------------|
| Components | 5850 | 5200 |
| Taps Size | MBx1.25 BTM | CIMC 3 |
| Work Material | Cast Iron | |
| Components | Flywheel | |
| Operation | Tapping | |
| RPM | 600 | |
| Feed | 750 | |
| Machine | SPM | |



| Tool Type | Platinum Cut Tap | Competitor |
|---------------|--------------------|------------|
| Components | 2000 | 1580 |
| Taps Size | MBx1.25 SPIREX MB1 | |
| Work Material | EN1A | |
| Components | SHAFT TRAVERS PIN | |
| Operation | TAPPING | |
| RPM | 700 | |
| Feed | 875 | |
| Machine | SPM | |



TAP TERMINOLOGY



Recommended Parameter

| Material | RC Value | HB value | Recommended Mtr / min | |
|--|----------|----------|-----------------------|--------|
| | | | Uncoated | Coated |
| Structural steels, free-cutting steels Case hardened steels, heat-treatable steels | <20 | <236 | 9-15 | 12-20 |
| | <25 | <256 | 9-13 | 11-18 |
| | <30 | <286 | 6-9 | 9-16 |
| | <35 | <326 | 5-8 | 6-10 |
| | <38 | <386 | 4-8 | 6-12 |
| Stainless- and acid-resistant steels, sulphured austenitic martensitic | <25 | <256 | 6-9 | 9-12 |
| | <36 | <286 | 6-9 | 7-12 |
| | <35 | <326 | 3-6 | 6-9 |
| Alloyed case hardened steels Alloyed heat-treatable steels Alloyed tool steels High speed tool steels | <25 | <256 | 3-6 | 9-12 |
| | <36 | <286 | 8-10 | 9-15 |
| | <35 | <326 | 5-8 | 6-9 |
| | <38 | <386 | 3-5 | 4-9 |
| Cast iron Spheroidal graphite iron Malleable cast iron | <186 | <186 | 15-20 | 18-25 |
| | <25 | <256 | 9-12 | 14-18 |
| Brass | <35 | <326 | 5-10 | 6-12 |
| | | | 9-13 | - |
| | | | 9-15 | - |