

## MIRANDA GOLD DRILLS

### Precision & Long Life Drilling

#### SIZE RANGE : GOLD JOBBER DRILL

- Metric size : 1.0 mm to 20.0 mm
- Inch size : 3/64" to 25/32"

#### SIZE RANGE : GOLD STUB DRILL

- Metric size : 1.5 mm to 16.0 mm
- Inch size : 5/64" to 5/8"

#### APPLICATION

- Suitable for non ferrous metals.
- Suitable for aluminium alloy & Cast steel material.
- Suitable for material up to 25HRc.
- Suitable for general application

#### SPECIALLY DESIGNED

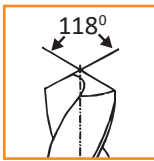
- Specially designed & treated for precision drilling in general purpose steel for longer life & heat resistance.
- Performs well in broad range of material in the iron & steel categories.

#### SIZE RANGE : GOLD LONG DRILL

- Metric size : 1.00 mm to 16.0 mm
- Inch size : 3/64" to 5/8"

#### ADVANTAGES

- Premium-grade industrial steel & super hard performance coating for longer life, heat resistance & precision drilling.
- Unique flute design for superior material removal.
- Special heat treatment provides additional strength.
- Improve hole finish due to better lubrication properties.
- Improve 30% productivity as compared to standard drill



**IS : 5101 - 1991**

**DIN : 338**

#### SPEED AND FEED FOR DRILLING

Work Material Cutting Condition Dia. (mm)	Steels		Cast iron		Alloy Steel		Aluminium		Copper		Stainless Steel		Plastic		Magnesium Alloy		Brass	
	rpm	mm/rev	rpm	mm/rev	rpm	mm/rev	rpm	mm/rev	rpm	mm/rev	rpm	mm/rev	rpm	mm/rev	rpm	mm/rev	rpm	mm/rev
2	3550	0.03	3550	0.03	1800	0.02	10000	0.03	2800	0.03	1800	0.03	8000	0.03	14000	0.03	5000	0.04
3	2240	0.06	2240	0.06	1120	0.03	6300	0.06	1800	0.06	1120	0.06	5000	0.06	9000	0.06	3150	0.08
5	1400	0.11	1400	0.11	710	0.05	4000	0.11	1120	0.11	710	0.11	3150	0.11	5600	0.11	2000	0.14
8	900	0.16	900	0.16	450	0.08	2500	0.16	710	0.16	450	0.16	2000	0.16	3550	0.16	1250	0.20
12	560	0.22	560	0.22	280	0.11	1600	0.22	450	0.22	280	0.22	1250	0.22	2240	0.22	800	0.28
16	450	0.25	450	0.25	224	0.13	1250	0.25	355	0.25	224	0.25	1000	0.25	1800	0.25	630	0.33
20	355	0.30	355	0.30	180	0.15	1000	0.30	280	0.30	180	0.30	800	0.30	1400	0.30	500	0.38

## MIRANDA SUPER DRILLS

### Precision drilling on hard material

#### APPLICATION

- Drilling alloy steel up to 28-35 HRC.
- Suitable for drilling all types of stainless steel materials.
- Suitable for forged steel components.
- All Titanium alloys, Hastelloy, Inconel and Heat Resistant steels

#### SIZE RANGE : SUPER JOBBER DRILL

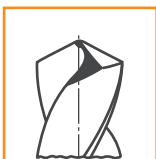
- Metric size : 1.00 mm to 16.0 mm
- Inch size : 3/64" to 5/8"

#### ADVANTAGES

- High helix flute and reinforced web gives maximum rigidity.
- Improved cutting action and faster chip evacuation.
- Self centering drill with special web thinning that reduces thrust.
- Trouble free drilling for high alloy steel material.
- Reduced contact area that results into less heat generation.
- Good for drilling on curved surface.
- Up to 100% higher productivity as compared to standard drill on hard metal drilling.

130° self-centering split point that requires less torque and thrust in machine drilling and thus reduce axial force and increases tool life. This point helps break up chips in deep hole drilling and is an excellent choice when used on CNC equipment.

130° Split Point



**IS : 5101 - 1991**

**DIN : 338**



Work Material	Steels containing a high proportion (>10%) of nickelchrome and nickle		Corrosion and heat resisting alloys containing a high proportion of carbon, chrome, and molybdenum		Titanium Alloy	
	Cutting speed 10 m / min.		Cutting speed 6.3 m / min.		Cutting speed 4 m / min.	
Cutting Condition	Rev. per min	Feed mm / rev.	Rev. per min	Feed mm / rev.	Rev. per min	Feed mm / rev.
Dia. (mm)						
2.0	1600	0.020	1000	0.020	630	0.020
2.5	1250	0.020	800	0.020	500	0.020
3.15	1000	0.030	630	0.030	400	0.030
4.0	800	0.040	500	0.040	315	0.040
5.0	630	0.050	400	0.040	250	0.040
6.3	500	0.060	315	0.040	200	0.040
8.0	400	0.080	250	0.060	160	0.060
10.0	315	0.100	200	0.080	125	0.080
12.50	250	0.100	160	0.080	100	0.080