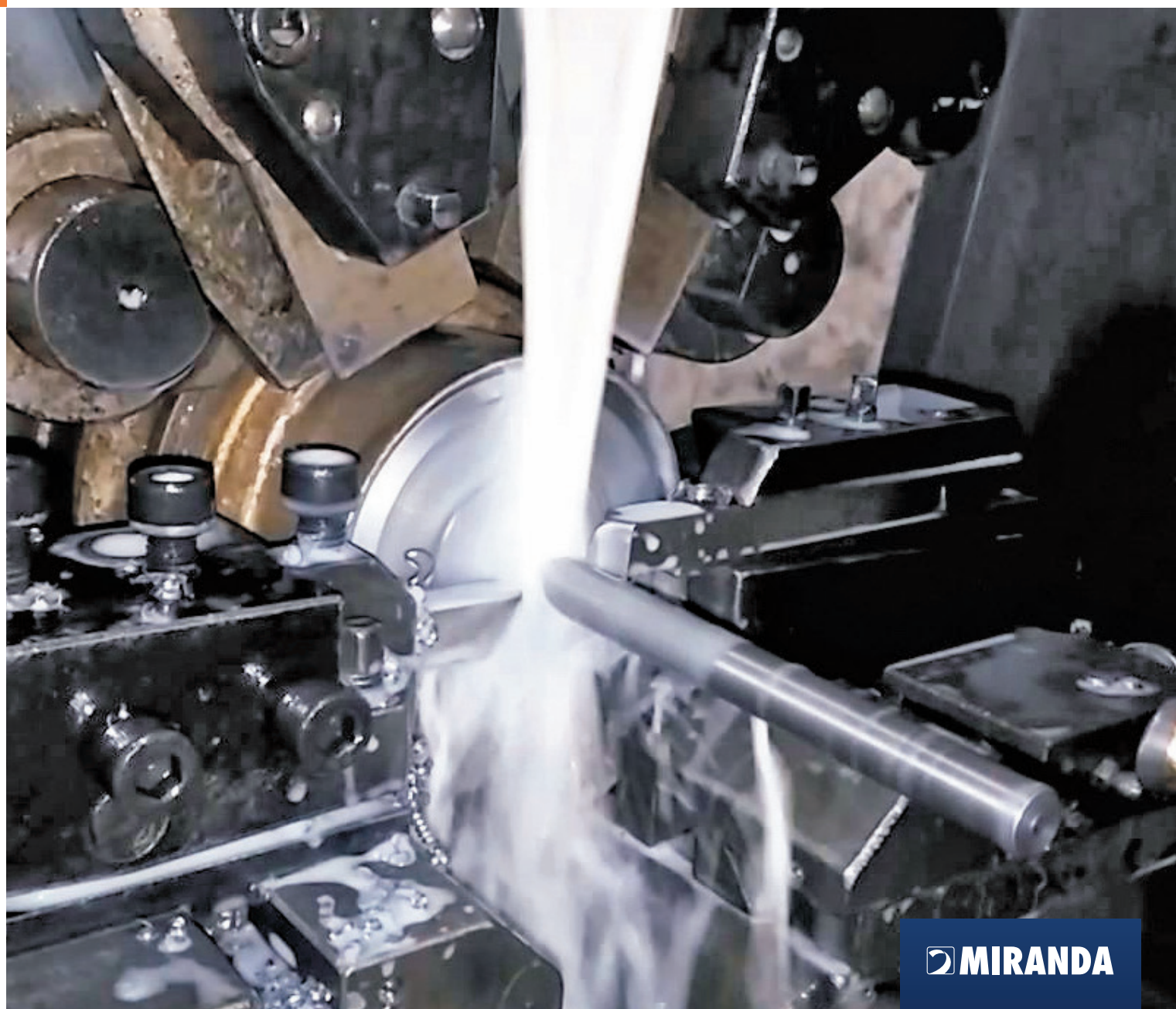
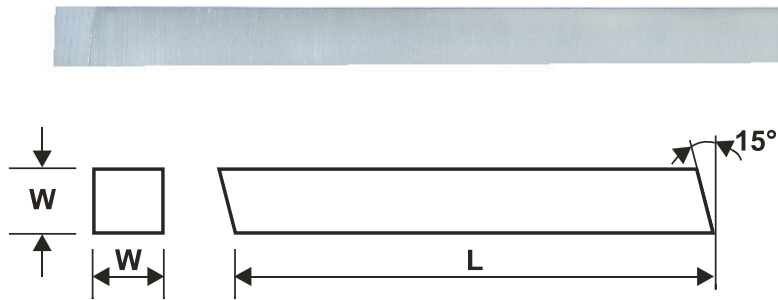


**DORMER  PRAMET**

**TURNING  
TECHNOLOGY**



## HSS TOOL BIT SQUARE



|                                 |                              |                |                  |    |                    |             |                    |
|---------------------------------|------------------------------|----------------|------------------|----|--------------------|-------------|--------------------|
| <b>HSS</b><br>M-35/M-42<br>T-42 | <b>Bevel end</b><br>15° / 0° | <b>h</b><br>13 | IS:11143<br>1991 | MS | <b>Alloy Steel</b> | <b>C.I.</b> | Pre-Hardened Steel |
|---------------------------------|------------------------------|----------------|------------------|----|--------------------|-------------|--------------------|

| Metric Sizes |      |                             |    |     |     |     |     |
|--------------|------|-----------------------------|----|-----|-----|-----|-----|
| Square W     |      | Length (Tolerance +/-1.5mm) |    |     |     |     |     |
| mm           | inch | L mm                        |    |     |     |     |     |
| -            | 3/32 | 65                          | 75 |     |     |     |     |
| 3            | 1/8  |                             | 75 | 100 |     |     |     |
| 4            | 5/32 |                             | 75 | 100 |     |     |     |
| 5            | 3/16 |                             | 75 | 100 | 150 |     |     |
| 6            | 1/4  |                             | 75 | 100 | 150 | 200 |     |
| 8            | 5/16 |                             | 75 | 100 | 150 | 200 |     |
| 10           | -    |                             | 75 | 100 | 150 | 200 | 250 |
| 12           | 1/2  |                             | 75 | 100 | 150 | 200 | 250 |
| 14           | 9/16 |                             |    | 100 | 150 | 200 | 250 |
| 16           | 5/8  |                             |    | 100 | 150 | 200 | 250 |
| 19           | 3/4  |                             |    | 100 | 150 | 200 | 250 |
| 20           | -    |                             |    | 100 | 150 | 200 | 250 |
| 25           | 1    |                             |    |     | 150 | 200 | 250 |

| Description          | Standard   |
|----------------------|--|
| End Bevel            | Standard 15°, 0° and as per customer requirement   |
| Tolerance (Diameter) | h13 / h12  |
| Applications         | 1) HSS Tool bits are used for general Lathe Work.<br>2) HSS Cobalt Tool bits are used for general Lathe Work with increased wear resistance.<br>a) Turning b) Grooving c) Facing d) Slotting |

| Manufacturing Standards |            |
|-------------------------|------------|
| I. S.                   | 11143-1991 |
| DIN                     | 4964       |
| ISO                     | 5421       |

**S100:** M35 (HSS with 5% Cobalt) (63-66 HRC)

**S200:** M42 (HSS with 8% Cobalt) (65-68 HRC)

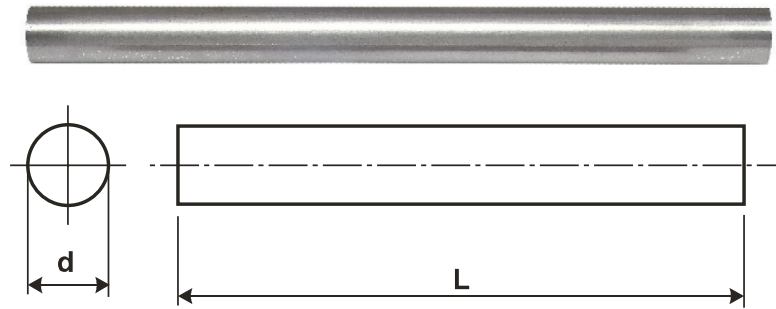
**S400:** T42 (HSS with 10% Cobalt) (64-67 HRC)

**S400E:** M35 with cryogenic (Ultra Low) Heat Treatment (64-67 HRC)

**S500:** T42 with cryogenic (Ultra Low) Heat Treatment (65-69 HRC)

Miranda Square Toolbits are made from M35, M42 & T42 Grades of HSS

## HSS ROUND TOOL BIT



|                                 |                        |                |                  |    |                    |             |                    |
|---------------------------------|------------------------|----------------|------------------|----|--------------------|-------------|--------------------|
| <b>HSS</b><br>M-35/M-42<br>T-42 | <b>Bevel end</b><br>0° | <b>h</b><br>13 | IS:11143<br>1991 | MS | <b>Alloy Steel</b> | <b>C.I.</b> | Pre-Hardened Steel |
|---------------------------------|------------------------|----------------|------------------|----|--------------------|-------------|--------------------|

| Metric Sizes |      |                             |    |     |     |     |     |
|--------------|------|-----------------------------|----|-----|-----|-----|-----|
| Diameter D   |      | Length (Tolerance +/-1.5mm) |    |     |     |     |     |
| mm           | inch | L mm                        |    |     |     |     |     |
| -            | 3/32 | 65                          | 75 | 100 |     |     |     |
| 3            | 1/8  |                             | 75 | 100 |     |     |     |
| 4            | 5/32 |                             | 75 | 100 |     |     |     |
| 5            | 3/16 |                             | 75 | 100 | 150 |     |     |
| 6            | 1/4  |                             | 75 | 100 | 150 | 200 |     |
| 8            | 5/16 |                             | 75 | 100 | 150 | 200 |     |
| 10           | -    |                             | 75 | 100 | 150 | 200 | 250 |
| 12           | 1/2  |                             | 75 | 100 | 150 | 200 | 250 |
| 14           | 9/16 |                             |    | 100 | 150 | 200 | 250 |
| 16           | 5/8  |                             |    | 100 | 150 | 200 | 250 |
| -            | 3/4  |                             |    | 100 | 150 | 200 | 250 |
| 20           | -    |                             |    | 100 | 150 | 200 | 250 |
| 25           | 1    |                             |    |     | 150 | 200 | 250 |

| Description          | Standard   |
|----------------------|--|
| End Bevel            | Standard 0° and as per customer requirement  |
| Tolerance (Diameter) | h9 / h8  |
| Applications         | 1) HSS Tool bits are used for general Lathe Work.<br>a) Die Punching b) Rolling c) Milling d) Boring Work.<br>2) HSS Cobalt Tool bits are used for general Lathe Work with increased wear resistance.<br>a) Die Punching b) Rolling c) Milling d) Boring Work. |

| Manufacturing Standards |            |
|-------------------------|------------|
| I. S.                   | 11143-1991 |
| DIN                     | 4964       |
| ISO                     | 5421       |

**S100:** M35 (HSS with 5% Cobalt) (63-66 HRC)

**S200:** M42 (HSS with 8% Cobalt) (65-68 HRC)

**S400:** T42 (HSS with 10% Cobalt) (64-67 HRC)

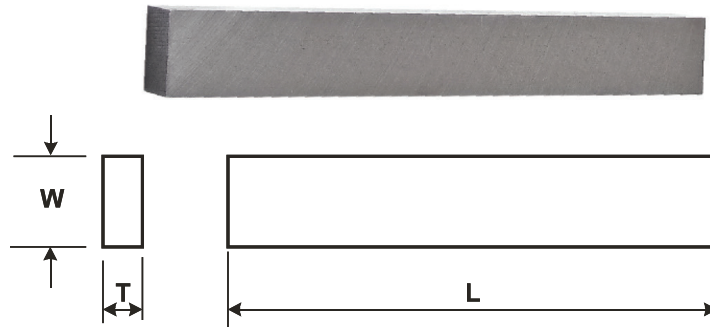
**S400E:** M35 with cryogenic (Ultra Low) Heat Treatment (64-67 HRC)

**S500:** T42 with cryogenic (Ultra Low) Heat Treatment (65-69 HRC)

Miranda Round Toolbits are made from M35, M42 & T42 Grades of HSS

Special sizes and tolerance can be supplied

## HSS RECTANGULAR (FLAT) TOOL BITS



|                            |                        |                |                  |    |                    |             |                    |
|----------------------------|------------------------|----------------|------------------|----|--------------------|-------------|--------------------|
| <b>HSS</b><br>M-35<br>T-42 | <b>Bevel end</b><br>0° | <b>h</b><br>13 | IS:11143<br>1991 | MS | <b>Alloy Steel</b> | <b>C.I.</b> | Pre-Hardened Steel |
|----------------------------|------------------------|----------------|------------------|----|--------------------|-------------|--------------------|

| Metric Sizes      |               |                                     |     |     |     |     |     |
|-------------------|---------------|-------------------------------------|-----|-----|-----|-----|-----|
| Thickness<br>T mm | Width<br>W mm | Length (Tolerance +/-1.5mm)<br>L mm |     |     |     |     |     |
| 10                | 12            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 16            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 20            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 25            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 12            | 75                                  | 100 | 125 | 150 | 200 | 250 |
| 12                | 16            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 20            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 25            | 75                                  | 100 | 125 | 150 | 200 | 250 |
| 13                | 14            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 16            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 26            | 75                                  | 100 | 125 | 150 | 200 | 250 |
| 15                | 25            | 75                                  | 100 | 125 | 150 | 200 | 250 |
| 16                | 20            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 30            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 32            | 75                                  | 100 | 125 | 150 | 200 | 250 |
| 20                | 25            | 75                                  | 100 | 125 | 150 | 200 | 250 |
|                   | 20            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 25            | 75                                  | 100 | 125 | 150 | 200 |     |
| 6                 | 8             | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 10            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 12            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 16            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 20            | 75                                  | 100 | 125 | 150 | 200 |     |
| 8                 | 25            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 12            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 13            | 75                                  | 100 | 125 | 150 | 200 |     |
|                   | 20            | 75                                  | 100 | 125 | 150 | 200 |     |

| Manufacturing Standards |            |
|-------------------------|------------|
| I. S.                   | 11143-1991 |
| DIN                     | 4964       |
| ISO                     | 5421       |

| Description                 | Standard   |
|-----------------------------|--|
| End Bevel                   | Standard 0°  |
| Tolerance Width / Thickness | h13 / h12  |
| Applications                | 1) HSS Tool bits are used for general Lathe Work.<br>2) HSS Cobalt Tool bits are used for general Lathe Work with increased wear resistance. |

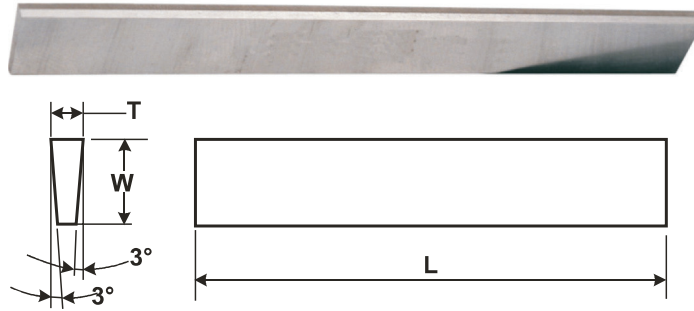
**S100:** M35 (HSS with 5% Cobalt) (63-66 HRC)

**S400:** T42 (HSS with 10% Cobalt) (64-67 HRC)

Miranda Flat Toolbits are made from M35, M42 & T42 Grades of HSS

Special sizes and tolerance can be supplied

## HSS PARTING TOOL BITS



|                           |                              |                |                  |           |                    |             |                           |
|---------------------------|------------------------------|----------------|------------------|-----------|--------------------|-------------|---------------------------|
| <b>HSS</b><br>M-2<br>T-42 | <b>Bevel end</b><br>15° / 0° | <b>h</b><br>13 | IS:11143<br>1991 | <b>MS</b> | <b>Alloy Steel</b> | <b>C.I.</b> | <b>Pre-Hardened Steel</b> |
|---------------------------|------------------------------|----------------|------------------|-----------|--------------------|-------------|---------------------------|

| Metric Sizes      |               |                             |     |     |     |     |
|-------------------|---------------|-----------------------------|-----|-----|-----|-----|
| Thickness<br>T mm | Width<br>W mm | Length (Tolerance +/-1.5mm) |     |     |     |     |
|                   |               | L mm                        |     |     |     |     |
| 2.5               | 10            | 75                          | 100 | 125 |     |     |
|                   | 12            | 75                          | 100 | 125 |     |     |
| 3                 | 12            | 75                          | 100 | 125 | 150 |     |
|                   | 20            | 75                          | 100 | 125 | 150 |     |
|                   | 22            | 75                          | 100 | 125 | 150 |     |
| 4                 | 16            | 75                          | 100 | 125 | 150 | 200 |
| 5                 | 20            | 75                          | 100 | 125 | 150 | 200 |
|                   | 25            | 75                          | 100 | 125 | 150 | 200 |
| 6                 | 25            | 75                          | 100 | 125 | 150 | 200 |

| Description                 | Standard  |
|-----------------------------|---|
| End Bevel                   | Standard 0° and as per customer requirement   |
| Tolerance Width / Thickness | h13 / h12   |
| Applications                | 1) HSS Tool bits are used for Parting off & Slotting applications.<br>2) HSS Cobalt Tool bits are used for Parting off & Slotting with increased wear resistance. |

| Manufacturing Standards |            |
|-------------------------|------------|
| I. S.                   | 11143-1991 |
| DIN                     | 4964       |
| ISO                     | 5421       |

Intermediate sizes are available on request

**S100:** M35 (HSS with 5% Cobalt) (63-66 HRC)

**S200:** M42 (HSS with 8% Cobalt) (65-68 HRC)

**S400:** T42 (HSS with 10% Cobalt) (64-67 HRC)

**S400E:** M35 with cryogenic (Ultra Low) Heat Treatment (64-67 HRC)

**S500:** T42 with cryogenic (Ultra Low) Heat Treatment (65-69 HRC)

Miranda Parting Toolbits are made from M2, T42 Grades of HSS

Special sizes and tolerance can be supplied

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As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable.**



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