

High Speed Steels

Product Specifications

AISI/ ASTM	MATERIAL			CHEMISTRY								HEAT TREATMENT DETAILS					
	EN	DIN	JIS	C	Si	Mn	Cr	Mo	V	W	Co	Annealing (Slow Cooling)	Quenchant (Hot Bath)	Quenching	Tempering (Air Cooling)	Annealed (HB)-max	Quenched & (Hrc) Tempered
M2	6/5/2	1.3343	SKH51	0.9	0.3	0.3	4.1	5	1.8	6.4		800-880	OIL	1200-1240	550-570	255	63
M35	6/5/2+5%	1.3243	SKH55	0.92	0.35	0.3	4.1	5	1.9	6.4	4.8	800-840	OIL	1200-1240	550-570	277	64
M42	2/10/1/8	1.3247	SKH59	1.1	0.25	0.25	3.9	9.2	1.2	1.4	7.8	820-840	OIL	1170-1210	520-590	285	66
T1	18/4/1	1.3355	SKH2	0.75	0.2	0.2	4.1		1.1	18		820-880	OIL	1250-1290	560-580	248	62

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Size Range

HIGH SPEED	AISI	DIN	Supply condition	Rounds	Square	Flat	Application
	M2	1.3343	Annealed	2 ÷ 350	10 ÷ 130	20X10 ÷ 700X65	Twist drills, taps, die chasers, rotating files, cutters, broaches, woodworking tools, applies sectors for circular and straight blades, dies and tools for fine cutting.
	M35	1.3243	Annealed	30 ÷ 100			Tools for roughing work at very high cutting speeds on steels and cast iron, high performance twist drills, cutters and taps, highly stressed dies and tools in cold hearing and extrusion processes.
	M42	1.3247	Annealed	8 ÷ 120			Suitable for making tools which is used to process Ni, Ti alloy steel.
	T1	1.3355	Annealed	12 ÷ 65		20X10 ÷ 100X32	Tools for the machining of very hard metals, nickel, cobalt and titanium based alloys, broaches, cutters, twist drills, taps, cutting tools and cold wok punches.