

High Speed Steel Tool Bits

High speed tool bits are supplied ready for service or can be easily adapted

Tool bit suppliers, delivering to the whole of the UK. West Yorkshire Steel are HSS tool bit stockholders and suppliers in grades M2 and M42, which are available in flat, squares and diameters. High speed steel tool bits are supplied in the heat treated condition and ground to close tolerances. In the supply condition high speed steel tool bits are ready for service or the tool bit can be shaped to suit your specific machining application. When grinding tool bits it is recommended to use plenty of coolant to avoid any substantial increase in heat. Standard sizes are available for quick delivery. Non standard sizes can be produced and supplied within a few weeks.

We welcome export enquiries for hss tool bits. Contact our sales office and consult our [shipping policy](#) for further details.

Contact our experienced sales team who will assist you with your enquiry.

Related Specifications

ASTM A681 DIN 17350 BS EN ISO 4957

Form of Supply

M2 and M42 tool bits are available in flat, squares and diameters. Tool bits are supplied in metric and imperial sizes. High speed steel tool bits are supplied in the heat treated condition and ground to close tolerances. High speed steel tool bits are supplied ready for service or can be adapted to suit your specific machining application. Standard sizes are available for quick delivery. Non standard sizes can be supplied within a few weeks.

As standard square tool bits are supplied with 15° angle cut ends and rectangular and rounds are supplied with square ends.

- Flat
 - Diameter
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M2 HSS Tool Bits

[M2 high speed steel](#) is a tungsten molybdenum, general purpose grade which offers high toughness combined with good cutting powers. M2 tool bits are suited for general machining of carbon, alloy and tool steel types. M2 tool bits offer good heat and abrasion characteristics. Standard machining operations can be carried out with M2 high speed steel tool bits. M2 tool bits are supplied hardened to approximately 62 to 64HRc. For a more demanding operation M42 tool bits may be required.

M2 Typical Analysis

Carbon	0.85%	Chromium	4.10%
Molybdenum	5.00%	Tungsten	6.40%
Vanadium	1.80%		

M42 HSS Tool Bits

[M42 high speed steel](#) is a cobalt molybdenum grade with a high hardness and superior hot hardness offering excellent cutting performance and excellent wear resistance. As an 8% cobalt high speed steel type M42 tool bits are suited for tougher materials such as work hardening types. They offer increased tool life with retention of the cutting edge. M42 tool bits are supplied hardened to approximately 65 to 68HRC.

M42 Typical Analysis

Carbon	1.05%	Silicon	0.35%
Tungsten	1.50%	Chromium	3.75%
Vanadium	1.15%	Molybdenum	9.50%
Cobalt	8.00%		

Standard Stock Sizes

Below is a list of our popular standard sizes. If the tool bit size you require is not listed please contact our sales team who may be able to assist you with your enquiry. Non standard high speed tool bit sizes, including metric rectangular sizes, can be produced in approximately 2 to 3 weeks (subject to size suitability and raw material availability).

Rectangular Imperial Sizes (inches)	Imperial Sizes (inches)	Round Imperial Sizes (inches)	Round Metric Sizes (mm)	Square Metric Sizes (mm)
Rectangular Imperial Sizes (inches)	Imperial Sizes (inches)	Round Imperial Sizes (inches)	Round Metric Sizes (mm)	Square Metric Sizes (mm)
1/2" x 3/16" x 4"	3/16" sq x 2 1/2"	3/16" dia x 2 1/2"	6 dia x 100	6 sq x 100
1/2" x 1/4" x 4"	3/16" sq x 3"	3/16" dia x 3"	8 dia x 100	8 sq x 100
1/2" x 3/8" x 4"	3/16" sq x 4"	3/16" dia x 4"	10 dia x 100	10 sq x 100
1/2" x 3/8" x 6"	1/4" sq x 2 1/2"	1/4" dia x 2 1/2"	12 dia x 100	12 sq x 100
5/8" x 1/4" x 4"	1/4" sq x 3"	1/4" dia x 3"	12 dia x 150	12 sq x 150
5/8" x 1/4" x 6"	1/4" sq x 4"	1/4" dia x 4"	16 dia x 150	16 sq x 150
5/8" x 3/8" x 4"	5/16" sq x 3"	5/16" dia x 3"	20 dia x 150	20 sq x 150
5/8" x 3/8" x 6"	5/16" sq x 4"	5/16" dia x 4"		
5/8" x 1/2" x 4"	3/8" sq x 3"	3/8" dia x 3"		
5/8" x 1/2" x 6"	3/8" sq x 4"	3/8" dia x 4"		
3/4" x 3/16" x 6"	3/8" sq x 6"	3/8" dia x 6"		
3/4" x 1/4" x 4"	1/2" sq x 3"	1/2" dia x 3"		
3/4" x 1/4" x 6"	1/2" sq x 4"	1/2" dia x 4"		
3/4" x 3/8" x 4"	1/2" sq x 6"	1/2" dia x 6"		
3/4" x 3/8" x 6"	5/8" sq x 4"	5/8" dia x 4"		
3/4" x 1/2" x 4"	5/8" sq x 6"	5/8" dia x 6"		
1" x 3/16" x 6"	3/4" sq x 4"	3/4" dia x 4"		
3/4" x 1/2" x 6"	3/4" sq x 6"	3/4" dia x 6"		
1" x 1/4" x 4"	1" sq x 6"	1" dia x 6"		
1" x 1/4" x 6"				
1" x 3/8" x 6"				
1" x 1/2" x 6"				
1" x 5/8" x 6"				

Rectangular Imperial Sizes (inches)	Imperial Sizes (inches)	Round Imperial Sizes (inches)	Round Metric Sizes (mm)	Square Metric Sizes (mm)
1" x 3/4" x 6"				
1 1/4" x 3/8" x 4"				
1 1/4" x 3/8" x 6"				
1 1/4" x 1/2" x 4"				
1 1/4" x 1/2" x 6"				
1 3/8" x 1/2" x 6"				
1 1/2" x 1/2" x 6"				

Quality Assured Supply

High speed steel tool bits are supplied in accordance with our ISO 9001:2015 registration.