

High Speed Steel Tool Bits

Quality high speed steel tool bits, available in rounds, squares and flats

HSS 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.

Popular grades we supply as tool bits

[M2](#) | [M42](#)

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.



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

- Flat
- Square
- Diameter

M2 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 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.

Precision ground flat stock / gauge plate can be produced using D2 tool steel. Subject to size, suitability and availability pieces can be produced in approximately 2 to 3 weeks. Standard and non-standard sizes are available.

M42 Typical Analysis

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

Quality Assured Supply

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

Standard Stock Sizes

On page 3 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)

Standard Stock Sizes (other non standard sizes can be produced or may be on stock)

Rectangular Imperial Sizes (inches)	Square 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"				
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"				



West Yorkshire Steel Ltd
 Sandbeck Industrial Estate,
 Wetherby, Leeds,
 LS22 7DN UK

Call: 01937 584440
 Fax: 01937 580128
 Email: sales@westyorkssteel.com



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