

## HIGH SPEED STEELS

POWMEX GRADE	CHEMICAL COMPOSITION (%)						STANDARDS				
							EU	DIN W. Nr.	BS	ASTM/ AISI	JIS
	C	Cr	Mo	V	W	Co					
IT 1	0.75	4.00	-	1.10	18.00	-	HS 18-0-1	1.3355	BT 1	T 1	SKH - 2
IT 4	0.80	4.00	0.60	1.50	18.00	4.60	HS 18-1-2-5	1.3255	BT 4	T 4	SKH - 3
IT 15	1.55	4.40	0.50	4.80	12.30	4.80	HS 12-1-4-5	1.3202	BT 15	T 15	SKH - 10
IT 42	1.28	4.00	3.30	3.10	9.20	9.60	HS 10-4-3-10	1.3207	BT 42	T 42	SKH - 57
IM 1	0.84	3.90	8.60	1.15	1.55	-	HS 2-9-1	1.3346	BM 1	M 1	-
IM 2	0.90	4.00	4.80	1.80	6.10	-	HS 6-5-2	1.3343	BM 2	M 2	SKH - 51
IM 3	1.22	4.00	4.80	2.80	6.10	-	HS 6-5-3	1.3344	BM 3	M 3 : 2	SKH - 53
IM 4	1.30	4.10	4.70	3.90	5.90	-	HS 6-5-4	-	BM 4	MH 4	SKH - 54
IM 6	0.80	4.10	5.00	1.50	4.25	12.00	HS 4-5-2-12	-	BM 6	M 6	-
IM 7	1.00	3.80	8.40	1.90	1.60	-	HS 2-9-2	1.3348	BM 7	M 7	SKH - 58
IM 9V	1.20	4.20	8.40	2.70	3.40	-	HS 4-8-3	-	BM 9V	M 9	-
IM 15	1.52	4.70	2.80	4.80	6.35	4.60	HS 6-3-5-6	-	BM 15	VM 15	-
IM 35	0.92	4.00	4.80	1.80	6.10	4.80	HS 6-5-2-5	1.3243	BM 35	M 35	SKH - 55
IM 42	1.10	3.85	9.20	1.10	1.50	7.80	HS 2-9-1-8	1.3247	BM 42	M 42	SKH - 59
IM 50	0.82	4.00	4.20	1.10	-	-	HS 0-4-1	1.3551	BM 50	M 50	-
IC 8	1.05	3.90	5.80	1.50	4.90	7.60	HS 5-6-2-8	-	-	C 8	-
IV 3	0.99	4.00	2.55	2.30	2.80	-	HS 3-3-2	1.3333	-	V 3	-
	0.88	3.85	2.85	1.85	6.10	-	HS 6-3-2	1.3390	-	-	-

**MANUFACTURING RANGE** (Applicable for all grades and all dimensions in mm)

<b>Rounds and Squares</b>	<b>Size</b>	<b>Flats</b>	<b>T</b>	<b>W</b>	<b>( W - T )</b>
Annealed and Centreless Ground	5 - 25	<b>Rolled</b>	6 - 15	25 - 40	> 8
Annealed	5.5 - 56		15.1 - 32	25 - 60	> 8
Annealed and Peeled	12 - 54	<b>Forged</b>	<b>High Speed Steels</b>		
<b>High Speed Steels</b>			40 - 100	80 - 120	
Forged, Annealed, Peeled and Turned	57 - 160	<b>Cold / Hot Work and Alloy Tool Steels</b>			
Rolled Squares	7.2 - 27		35 - 100	80 - 180	
Forged Squares	60 - 140	<b>LENGTH FOR ALL GRADES</b>			
<b>Cold / Hot Work and Alloy Tool Steels</b>		Upto 80 dia. 2 - 4 Mtrs. with 10% shorts down to 1 Mtr.			
Forged and Annealed	60 - 180	81 - 120 dia. 1.5 - 4 Mtrs. with 10% shorts down to 1 Mtr.			
Forged Squares	60 - 150	121 - 180 dia. 1.5 - 3 Mtrs. with 10% shorts down to 1 Mtr.			