
**Cutting tools — Designation of
high-speed steel groups**

Outils coupants — Désignation des groupes d'aciers rapides



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Foreword

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ISO 11054 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 11054:1993), which has been technically revised.

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Cutting tools — Designation of high-speed steel groups

1 Scope

This International Standard specifies the designation of groups of high-speed steels used for manufacturing high-speed steel (HSS) cutting tools such as taps, drills, end mills, etc. It is not intended to specify the composition of high-speed steels, which is the subject of ISO 4957.

2 Terms and definitions

For the purposes of this document the following terms and definitions apply.

2.1

conventional high-speed steel

high-speed steel produced by the traditional ingot metallurgy process

2.2

powder metallurgy high-speed steel

high-speed steel produced by the powder metallurgy process

3 Designation

Table 1 gives the code designation of high-speed steels used for cutting tools.

In addition to the standardized code, a supplementary symbol may be added by the manufacturer for a fuller description of his products.

Table 1 — High-speed steel groups

Production process	Designation code	Chemical composition class
Conventional high-speed steels	HSS	High-speed steel containing less than 4,5 % cobalt and less than 2,6 % vanadium
	HSS-E	High-speed steel containing at least 4,5 % cobalt or at least 2,6 % vanadium
Powder metallurgy high-speed steels	HSS-PM	High-speed steel containing less than 4,5 % cobalt and less than 2,6 % vanadium
	HSS-E-PM	High-speed steel containing at least 4,5 % cobalt or at least 2,6 % vanadium