

GROUPS OF MATERIALS for cutting tools



Group of material		Material no.	Etching
LWS	→ Alloyed tool steel	1.2235 1.2067 or similar	none
Characteristics of material	Chrome alloyed tool steel of very good toughness and medium capacity wear resistance		
Fields of application	Sufficient for many normal cutting operations with good price/performance ratio		
SBS	→ Specially treated steel	B 153 T or similar	SBS or B 153 T
Characteristics of material	Similar to chrome alloyed tool steel but improved by special treatment		
Fields of application	Demanding cutting operations, similar to high chrome (HWS) steel but with a better price/performance ratio		
HWS	→ High chrome steel with 12 % Cr	1.2201 1.2601 1.2379 1.2080 1.2436 or similar	12 % Cr
Characteristics of material	High alloy ledeburite chrome steel with good capacity of wear resistance and good toughness		
Fields of application	For very demanding cutting operations		
HSS	→ High speed steel	1.3333 1.3343 1.3355 1.3318 or similar	HSS
Characteristics of material	High speed steel with high capacity of wear resistance due to its content of wolfram and molybdenum and with sufficient toughness		
Fields of application	For extremely demanding cutting operations		
HSP	→ HSS powder metal	ASP CPM or similar	HSP
Characteristics of material	High speed steel made of powder metal with better toughness than High speed steel (HSS) by homogeneous structural constitution and, with a better capacity of wear resistance		
Fields of application	Like high-speed steel (HSS) but only with special cutting operations demanded by the materials to be cut		
RFS	→ Stainless steel	1.4528 1.4112 or similar	RFS
Characteristics of material	Stainless and acid-proof steel with at least 17% Cr with acceptable wear properties and good toughness		
Fields of application	Cutting operations demanding rust and acid-resisting properties		
HM	→ Tungsten carbide tipped or solid carbide	K 10 G 30	HM
Characteristics of material	e.g. material redensified by HIP method with excellent capacity for wear resistance		
Fields of application	Cutting operations requiring very long service life; here, the extremely sensitive cutting edges require especially trained operating staff and suitable machines		

GROUPS OF MATERIALS

for knife holders, spacers and similar



Group of material		Material no.	Etching
VGS	→ Tempering steel	1.1191 1.1750 1.0503 or similar	none
LWS	→ Alloyed tool steel	1.2003 1.2235 1.2067 1.2419 1.2241 or similar	none
RWS	→ Stainless steel	1.4571 or similar	none
RFS	→ Stainless steel (heat treatable)	1.4112 1.4034 1.4021 or similar	none
FBS	→ Spring steel (hardened)	1.1274 or similar	none
FRS	→ Spring steel (hardened, stainless)	- . - - - -	none

Subject to modification

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WILHELM BILSTEIN GmbH & Co. KG

Kölner Str. 27-29 Tel. +49 (0) 22 06/60 06-0 verkauf@bilstein.net
D-51491 Overath Fax +49 (0) 22 06/60 06-29/-49 www.bilstein.net

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