



KINKELDER[®]
the cutting experts

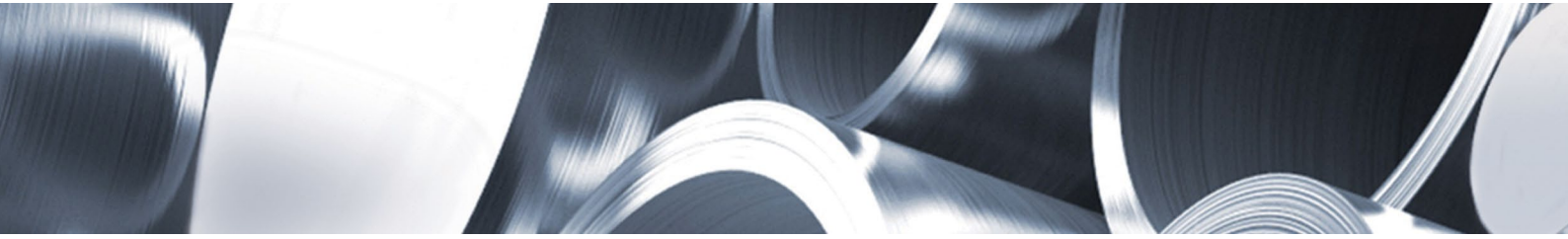


HSS SERIES

STANDARD

Cutting tubes and solids on manual
and (semi-)automatic sawing machines

Cutting tubes and solids on manual sawing machines



The steam treated Alpha saw blade has a blue Oxide surface layer for a longer blade life compared to the uncoated saw blade. It is mainly being used for cutting steel on manual and semi-automatic sawing machines.

APPLICATIONS

All applications like tubes, profiles and solids. All structural steels and non-alloy tool steel with a tensile strength up to 700 N / mm²

PARAMETERS

Suggested cutting speed: 30 - 60 m/min.

MACHINES

Manual, semi-automatic



Due to the higher oxidation temperature, this TiN coated Solar saw blade is able to cut applications with high tensile strengths.

APPLICATIONS

All applications like tubes, profiles and solids with a tensile strength up to 750 N / mm²

PARAMETERS

Suggested cutting speed: 80 - 140 m/min.
Feed: 0,04 - 0,09 mm/tooth.

MACHINES

Manual, semi-automatic, automatic

TYPICAL AVAILABE HSS ALPHA SAW BLADES

Diameter (mm)	Kerf (mm)	Bore hole (mm)	Teeth
160	1,2 / 1,6 / 2,0	32	80 / 100 / 120 / 160
175	1,6 / 2,0	32	64 / 90 / 110 / 140 / 180
200	1,2 / 1,6 / 1,8 / 2,0	32	72 / 100 / 128 / 160 / 200
225	1,2 / 1,6 / 2,0 / 2,5	32 / 40	64 / 80 / 90 / 120 / 150 / 180 / 220
250	1,2 / 1,6 / 2,0 / 2,5	32 / 40	64 / 80 / 100 / 110 / 128 / 160 / 200 / 240
275	1,2 / 1,6 / 2,0 / 2,5 / 3,0	32 / 40	72 / 78 / 84 / 96 / 110 / 120 / 144 / 180 / 220 / 280
300	1,6 / 2,0 / 2,5 / 3,0	32 / 38 / 40	80 / 90 / 100 / 110 / 120 / 140 / 160 / 200 / 240 / 320
315	2,0 / 2,5 / 3,0	32 / 40	72 / 80 / 90 / 100 / 110 / 120 / 140 / 160 / 200 / 250 / 320
325	2,0 / 2,5 / 3,0	32 / 40	90 / 100 / 110 / 130 / 150 / 170 / 200 / 250 / 320
350	2,0 / 2,5 / 3,0 / 3,5	32 / 40 / 50	80 / 90 / 110 / 120 / 140 / 160 / 180 / 220 / 280 / 350
370	2,0 / 2,5 / 3,0 / 3,5	40 / 50	70 / 80 / 90 / 100 / 110 / 120 / 140 / 160 / 190 / 220 / 300
400	2,5 / 3,0 / 3,5 / 4,0 / 4,5	40 / 50	70 / 80 / 90 / 100 / 128 / 140 / 160 / 180 / 200 / 250 / 320
425	2,5 / 3,0 / 3,5 / 4,0	32 / 40 / 50	70 / 80 / 100 / 110 / 120 / 130 / 140 / 160 / 180 / 220 / 260 / 350
450	2,5 / 3,0 / 3,5 / 4,0	40 / 50	80 / 90 / 100 / 120 / 140 / 180 / 240 / 280

For more information:

www.kinkelder.com

The allround HSS solution



Due to a sophisticated PVD coating for wear protection which achieves a very low friction coefficient, the Fernox saw blade is a cost efficient solution for cutting structural and non-alloy tool steel thin walled tubes.

When cutting tubes and profiles on manual and semi-automatic sawing machines, Fernox allows a higher cutting speed than a steam treated saw blade. It can even be used for cutting thin walled tubes on automatic machines.

Fernox is also very suitable for cutting stainless steel tubes and profiles.

Advantages compared with steam treated

- Higher blade life
- Increased uptime
- Lower cost per cut
- Little or no side pick-up
- Higher production output
- Ideal for cutting both structural steel and stainless

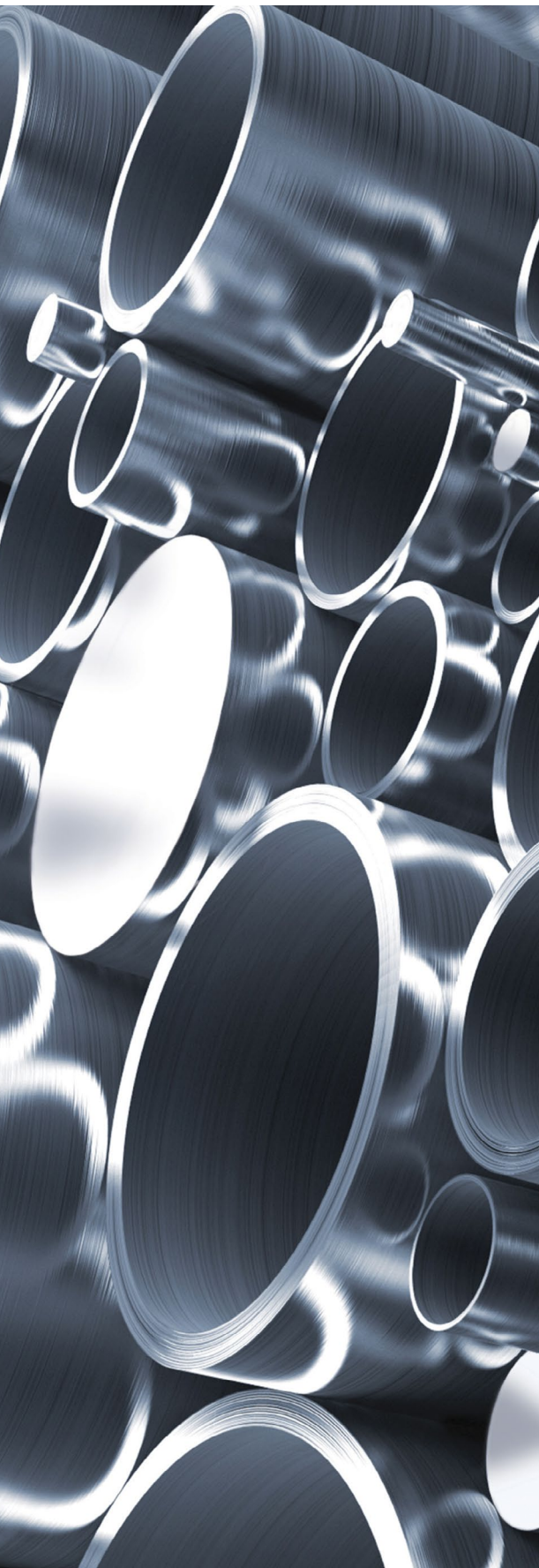
APPLICATIONS	All structural steel , non-alloy tool steel and stainless steel thin walled tubes. Tensile strength up to 600 N /mm ²	
PARAMETERS	Suggested cutting speed	
	Steel	60 - 120 m/min
	Austenitic stainless steel (300 series)	30 - 50 m/min
	Ferritic without Ti (409 & 412)	220 - 260 m/min
	Ferritic with Ti (441)	60 - 120 m/min
MACHINES	Manual, automatic, flying cut-off applications	

TYPICAL AVAILABE HSS SOLAR & FERNOX SAW BLADES

Diameter (mm)	Kerf (mm)	Bore hole (mm)	Teeth
160	1,2 / 1,6 / 2,0	32	80 / 100 / 120 / 160
175	1,6 / 2,0	32	64 / 90 / 110 / 140 / 180
200	1,2 / 1,6 / 1,8 / 2,0	32	72 / 100 / 128 / 160 / 200
225	1,2 / 1,6 / 2,0 / 2,5	32 / 40	64 / 80 / 90 / 120 / 150 / 180 / 220
250	1,2 / 1,6 / 2,0 / 2,5	32 / 40	64 / 80 / 100 / 110 / 128 / 160 / 200 / 240
275	1,2 / 1,6 / 2,0 / 2,5 / 3,0	32 / 40	72 / 78 / 84 / 96 / 110 / 120 / 144 / 180 / 220 / 280
300	1,6 / 2,0 / 2,5 / 3,0	32 / 38 / 40	80 / 90 / 100 / 110 / 120 / 140 / 160 / 200 / 240 / 320
315	2,0 / 2,5 / 3,0	32 / 40	72 / 80 / 90 / 100 / 110 / 120 / 140 / 160 / 200 / 250 / 320
325	2,0 / 2,5 / 3,0	32 / 40	90 / 100 / 110 / 130 / 150 / 170 / 200 / 250 / 320
350	2,0 / 2,5 / 3,0 / 3,5	32 / 40 / 50	80 / 90 / 110 / 120 / 140 / 160 / 180 / 220 / 280 / 350
370	2,0 / 2,5 / 3,0 / 3,5	40 / 50	70 / 80 / 90 / 100 / 110 / 120 / 140 / 160 / 190 / 220 / 300
400	2,5 / 3,0 / 3,5 / 4,0 / 4,5	40 / 50	70 / 80 / 90 / 100 / 128 / 140 / 160 / 180 / 200 / 250 / 320
425	2,5 / 3,0 / 3,5 / 4,0	32 / 40 / 50	70 / 80 / 100 / 110 / 120 / 130 / 140 / 160 / 180 / 220 / 260 / 350
450	2,5 / 3,0 / 3,5 / 4,0	40 / 50	80 / 90 / 100 / 120 / 140 / 180 / 240 / 280



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