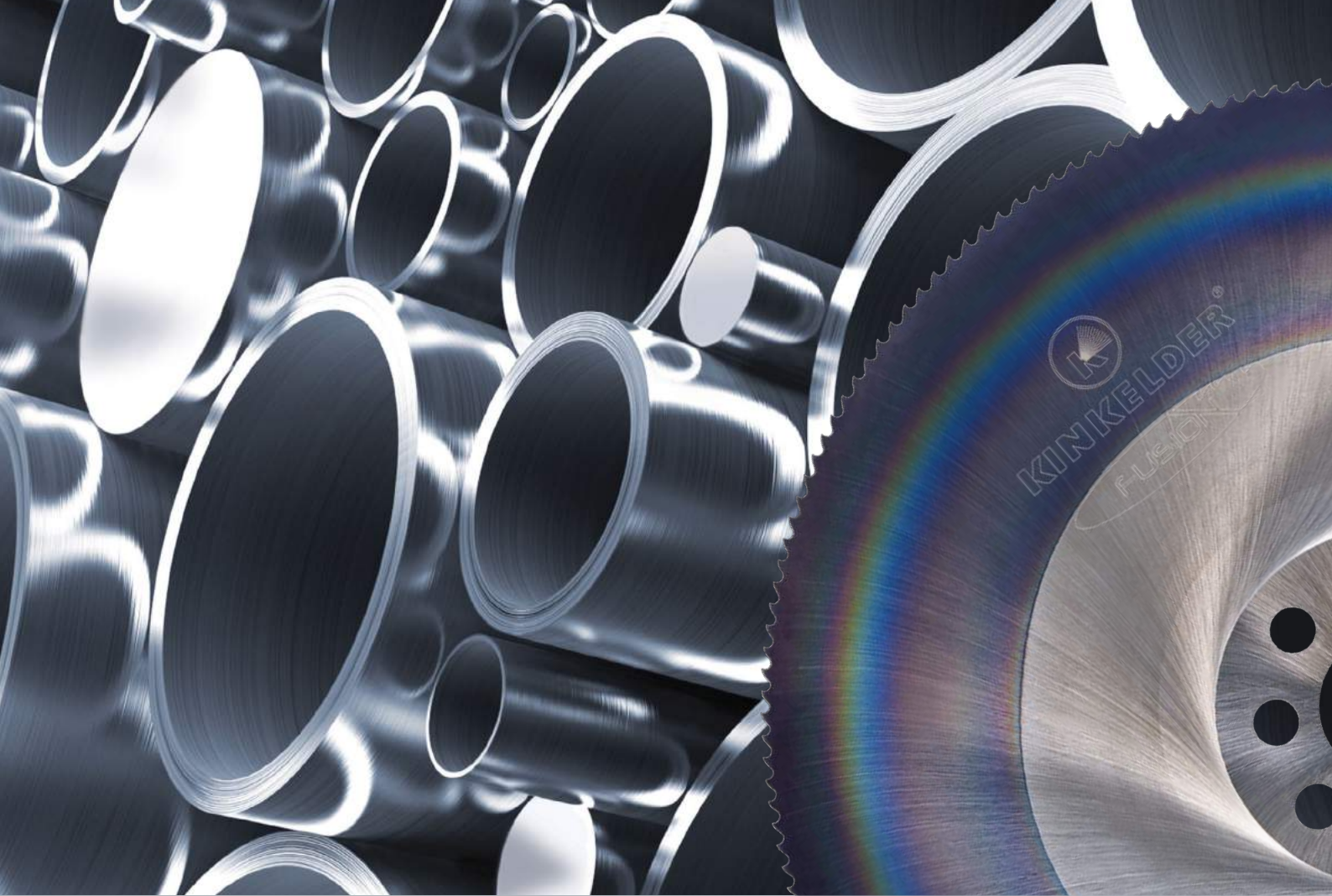




KINKELDER[®]
the cutting experts

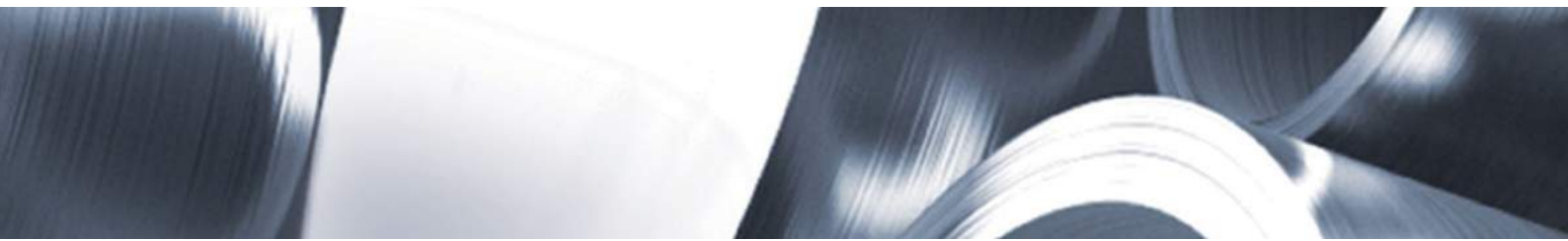
HSS SERIES



ADVANCED

HSS SERIES

Cutting harder materials
at higher cutting speeds



Pulsar saw blades distinguish themselves by a low friction coefficient, which makes them especially efficient at cutting harder materials at higher cutting speeds. Also very suitable for cutting stainless steel.

MATERIALS:	Ideal for cutting stainless steel and sticky, gummy materials		
PARAMETERS:		Suggested cutting speed	Blade life
	Steel	60 - 120 m/min	
	Austenitic stainless steel (300 series)	30 - 50 m/min	0,8 - 1,5m ²
	Ferritic w/o Ti (409 & 412)	220 - 260 m/min	< 1,5m ²
	Ferritic with Ti (441)	60 - 120 m/min	
MACHINES:	Automatic		



A special multilayer coating with high thermal insulation capacity enables the Fusion saw blade to cut harder materials at high cutting speeds with spray mist coolant.

MATERIALS:	Medium to high tensile (carbon) steel		
PARAMETERS:	Suggested cutting speed: 100 - 180 m/min. Feed: 0,04 - 0,15 mm/tooth.		
MACHINES:	Semi-automatic, automatic, flying cut-off applications		

TYPICAL APPLICATION EXAMPLES

Blade type	Material (mild steel)	Dimensions (mm)	Material specs.	Tensile strength (N/mm ²)	Cutting time (s)	Cutting speed (m/min)	Tooth load (mm/tooth)	Blade life (m ²)
Pulsar	Tube	25 x 2,0	S275		0,6	180	0,05	2,8
Pulsar	Tube	42 x 2,3	S235		0,5	200	0,06	3,2
Fusion	Tube	48 x 3,2	S235	520	1,2	180	0,04	3,6
Fusion	Tube	48 x 2,8	S275	520	1,0	220	0,06	4,3

For more information:

www.kinkelder.com



The Power 2000 saw blade has a thin kerf for cutting thin walled tubes and profiles. A superior surface finish and low friction PVD coating ensure low vibration, less burr and reduced risk of tube-end deformation.



MATERIALS:	Ideal for very thin walled tubes and profiles, both steel and stainless steel		
PARAMETERS:		Suggested cutting speed	Blade life
	Steel	60 - 120 m/min	
	Austenitic stainless steel (300 series)	30 - 50 m/min	0.8 - 2 m ²
	Ferritic w/o Ti (409 & 412)	220 - 260 m/min	< 3m ²
	Ferritic with Ti (441)	60 - 120 m/min	
MACHINES:	Automatic		

Performance 3000 is an allround saw blade for industrial applications on a very high performance level. The sophisticated multilayer coating combines high temperature resistance with a very low friction coefficient.



MATERIALS:	Harder materials at higher cutting speeds		
PARAMETERS:	Suggested cutting speed: 100 - 180 m/min. Feed: 0,04 - 0,15 mm/tooth.		
MACHINES:	Semi-automatic, automatic		

TYPICAL APPLICATION EXAMPLES

Blade type	Material (mild steel)	Dimensions (mm)	Tensile strength (N/mm ²)	Cutting speed (m/min)	Blade life (cuts)	Blade life (m ²)
Power	Tube	34 x 4,0	420	140	8,660	3,2
Power	Tube	45 x 9,0	460	120	3,540	3,7
Performance	Tube	55 x 3	520	180	9,500	4,6
Performance	Tube	55 x 3	620	140	6,000	3



The thick body and thinned cutting area of the Power Integral saw blade provide a low friction coefficient and reduced cutting resistance combined with higher strength. This enables these saw blades to be used for extremely demanding applications, like fast cutting of thin walled products.

MATERIALS: Thin walled (stainless) steel tubes, brass/ copper

PARAMETERS: Suggested cutting speed: 60 - 180 m/min. Feed: 0,02 - 0,16 mm/tooth.

MACHINES: Manual, semi-automatic and automatic



Due to a sophisticated multilayer coating, the Supreme saw blade series can cope with higher cutting speeds, feeds and tube hardnesses. The integral body provides an optimal compromise between rigidity of the saw blade and a vibration-reducing thin kerf.

MATERIALS: Steel tubes and profiles with a tensile strength up to 800 N/mm²

PARAMETERS: Suggested cutting speed: 100 - 250 m/min. Feed: 0,04 - 0,25 mm/tooth.

MACHINES: Automatic

TYPICAL APPLICATION EXAMPLES

Blade type	Material (mild steel)	Dimensions (mm)	Material specs.	Cutting speed (m/min)	Cutting time (s)	Blade life (cuts)	Blade life (m ²)
Power Integral	Tube	89 x 2,0	S275	120	3,5	4,000	1,8
Power Integral	Tube	50 x 1,5	1.4512	180	1,6	9,000	2,1
Supreme	Tube	40 x 5,0	S275 NBK	78	4,7	11,225	3,98
Supreme	Tube	70 x 5,0	ST 52	220	1,35	1,172	1,25

HSS SERIES

TYPICAL AVAILABLE HSS SAW BLADES

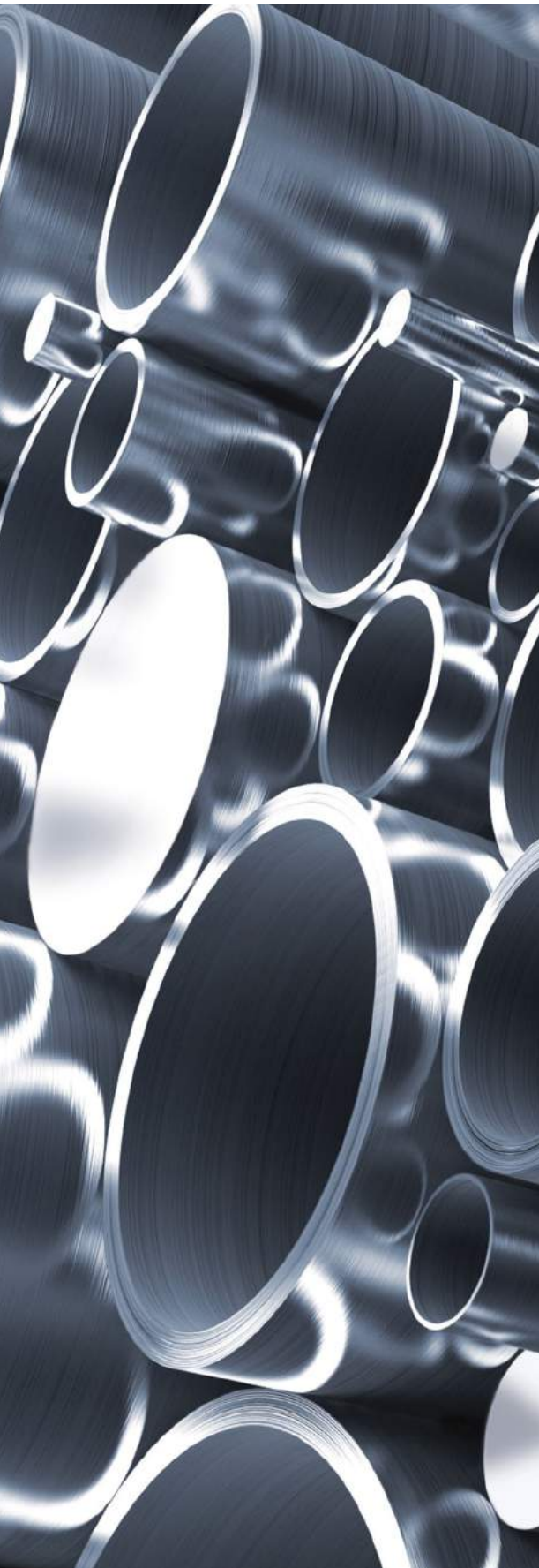
Diameter (mm)	Kerf (mm)	Borehole (mm)	Teeth
175	1,2/1,6/2,0	32	64/90/110/140/180
200	1,2/1,6/1,8/2,0	32	72/100/128/160/200
210	2,0	32	84/90/120/150/180/220
225	1,2/1,6/2,0	32/40	80/80/120/150/180/220
250	1,2/1,6/2,0/2,5/3,0	32/40	64/80/100/110/128/160/200/240
275	1,6/2,0/2,5/3,0	32/40	72/78/84/96/110/120/144/180/220/280
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	2,5/3,0/3,5	40/50	70/80/90/100/110/120/140/160/190/220/300
400	2,5/3,0/3,5/4,0	40/50	70/80/90/100/128/140/160/180/200/250/320
425	3,0/3,5/4,0	32/40/50	70/80/100/110/120/130/140/160/180/220/260/350
450	3,0/3,5/4,0	40/50	80/90/100/120/140/180/240/280
500	3,0/3,5/4,0/5,0	40/50	90/100/110/130/160/200/260/310
525	3,5/4,0	50	90/104/120/140/170/220/280/340
550	3,0/4,0/5,0	50/80	100/110/130/150/180/220/300/360
560	3,0/4,0/5,0	50/80	100/110/130/150/180/220/300/360
570	4,0/5,0	50/80	100/110/130/150/180/220/300/360
580	4,0/5,0	50/80	100/110/130/150/180/220/300/360
600	4,0/5,0	50/80	100/120/130/160/190/240/320/380
630	4,0/5,0	50/80	100/120/130/160/190/240/320/380

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