



**KINKELDER**<sup>®</sup>  
the cutting experts

# CHAMPION



## **CHAMPION** **TCT SERIES**

The best choice for high volume  
steel tube and solid cutting

# Unbeatable in solid cutting



The Champion SL saw blade achieves extended blade life at solid cutting by combining the performance advantages of Cermet with the latest PVD coating technology.

## Advantages

The Champion SL saw blade offers the following benefits:

- High blade life
- Smooth surface
- Low noise
- Low cost per cut

**APPLICATIONS:** High performance cutting of low and medium strength solid steel bars with a tensile strength of 400 - 800 N/mm<sup>2</sup> with high requirements on surface quality and straightness

**PARAMETERS:** Suggested cutting speed: 100 - 280 m/min.  
Feed: 0,04 - 0,11 mm/tooth.

**MACHINES:** Rattunde, Kasto, Nishijima, Tsune, Behringer, Mega, Exactcut, Everising and other automatic sawing machines

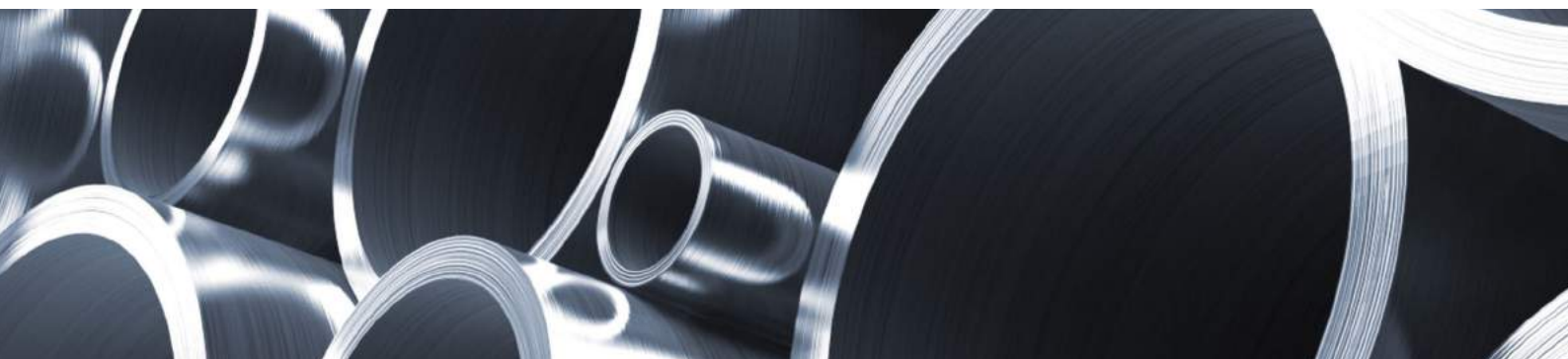
## TYPICAL APPLICATION EXAMPLES CHAMPION SL

Machines	Material	Dimensions (mm)	Tensile strength (N/mm <sup>2</sup> )	Cutting speed (m/min)	Tooth load (mm/tooth)	Blade life (m <sup>2</sup> )
Rattunde	Solid	Ø 45	600	240	0,04 / 0,07	86
Behringer	Solid	Ø 65	650	160	0,1	52
Everising	Solid	Ø 120	700	140	0,07	52

For more information:

[www.kinkelder.com](http://www.kinkelder.com)

# The top performers on hard tubes



Champion TL is our latest saw blade, designed for cutting tubes with tensile strength of 600 – 1,100 N/mm<sup>2</sup> on high output/high quality saw machines.

**APPLICATIONS:** Cutting steel tubes with a tensile strength up of 600 – 1,100 N/mm<sup>2</sup>

**PARAMETERS:** Suggested cutting speed: 180 – 280 m/min. Feed: 0.04 – 0.12 mm/tooth

**MACHINES:** Rattunde, Sinico, Bewo, RSA, Adige, Tsune



Champion TH has been developed to cut thin walled tubes with tensile strengths up to 1,800 N/mm<sup>2</sup>. The Champion TH saw blade can cope with the following 3 extreme cutting conditions:

- Cutting tubes with tensile strengths up to 1,800 N/mm<sup>2</sup>
- Cutting speeds up to 350 m/min
- Very high feed rates

**APPLICATIONS:** Thin walled steel tubes with a tensile strength up to 1,800 N/mm<sup>2</sup>

**PARAMETERS:** Suggested cutting speed: 200 - 350 m/min. Feed: 0,04 - 0,2 mm/tooth.

**MACHINES:** Rattunde, Sinico, Bewo, RSA, Adige

## TYPICAL APPLICATION EXAMPLES CHAMPION TL & TH

Type of saw blade	Material	Dimensions (mm)	Tensile strength (N/mm <sup>2</sup> )	Cutting speed (m/min)	Tooth load (mm/tooth)	Blade life (m <sup>2</sup> )
Champion TL	Tube, 26MnB5+N	32,5 x 5	600 - 700	260	0,02 / 0,085	13,4
Champion TL	Tube, 34mnB5+C	46 x 4,05	600 - 700	260	0,03 / 0,13	9,1
Champion TH	Seamless tube	25 x 3,25	750	275	0,04 / 0,095	15
Champion TH	Welded tube	42 x 3,0	700	260	0,06 / 0,2	10
Champion TH	Seamless tube	44 x 3,0	1,400	240	0,06 / 0,18	12



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