



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

# CX SERIES



**TCT SERIES**

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The new standard in TCT cutting

# High performance (stainless) steel tube cutting



The CX 3 saw blade has been developed for cutting tubes on high performance automatic sawing machines, at a higher maximum cutting speed than with HSS saw blades. It is most effective on sawing machines with accurate control of chip load and variable feed rate. Bigger tips are applied at pitches > 9mm for added stability.

## Advantages

- The workhorse for high performance cutting of carbon steel tubes.
- Cutting alloyed steel up to 900 N/mm<sup>2</sup>
- Versatile, fast, cost-effective, dependable performance

<b>MATERIALS</b>	Steel tubes with a tensile strength between 600 to 1,500 N/mm <sup>2</sup>
<b>PARAMETERS</b>	Suggested cutting speed: 180 - 280 m/min. Feed: 0,04 - 0,16 mm/tooth.
<b>MACHINES</b>	Soco, Rattunde, Sinico, Bewo, RSA, Plantool, Adige, OMP



The high nickel content of austenitic stainless steel tubes makes them difficult to cut with HSS saw blades. With the dedicated tooth geometry of the carbide tipped and PVD coated CX 4 saw blade, perfect surface finish and burr-free tube ends will be achieved.

## Advantages

- Setting new standards for fast cutting of stainless steel tubes
- Smooth cut surface, very little burr, long blade life
- Low cutting force allows cutting thin walled tube/profile

<b>MATERIALS</b>	Austenitic stainless steel tubes
<b>PARAMETERS</b>	Suggested cutting speed: 80 - 140 m/min. Feed: 0,06 - 0,12 mm/tooth.
<b>MACHINES</b>	Soco, Rattunde, Bewo, RSA, Sinico



The CX 5 saw blade has been specifically designed to cut thin walled tubes. Because of its light cutting properties it is also very well suited for use on a wide range of automatic cut-off machines.

## Advantages

- For cutting thin wall, high hardness, unstable products
- Low vibration, low noise, smooth cut surface, low burr
- For thin wall tube/profile made of DP, CP, HSLA and TRIP type materials

<b>MATERIALS</b>	Thin wall high hardness tube cutting on lighter machines. High performance cutting of thin walled tubes and unstable profiles on high-end machines.
<b>PARAMETERS</b>	Suggested cutting speed: 160 - 280 m/min. Feed: 0,025 - 0,12 mm/tooth.
<b>MACHINES</b>	Soco, Kasto, Bewo, RSA, Adige, Sinico, Rattunde

# Cutting low to high tensile carbon steel & stainless steel solids



The PVD coated, carbide tipped CX 1-M saw blade has been developed for cutting solid carbon steel (carbon content < 0.60%) with a medium tensile strength between 500 and 900 N/mm<sup>2</sup> at very high production rates.

## Advantages

- New saw body design
- Specifically designed for cutting solid carbon steel with medium tensile strengths
- High productivity
- Best blade life performances when a wider range of materials needs to be cut

<b>MATERIALS</b>	Solid carbon steel with a tensile strength between 500 and 900 N/mm <sup>2</sup> on high performance machines
<b>PARAMETERS</b>	Suggested cutting speed: 100 - 280 m/min. Feed: 0,06 - 0,10 mm/tooth.
<b>MACHINES</b>	All known brands of stationary automatic sawing machines such as: Soco, Nishijimax, Tsune, Mega, Everising, Rattunde, Behringer etc.



Applying a new saw body design, new tooth geometries and a new type of PVD coating, the CX 1-H saw blade has specifically been designed for cutting high tensile carbon steel (> 900 N/mm<sup>2</sup>, carbon content ≥ 0.60%) at very high production rates. It is also very suitable for cutting ferritic, martensitic and duplex stainless steel bars with a diameter larger than 35 mm.

## Advantages

- New saw body design
- New dedicated tooth geometries
- New type of coating
- Best blade life performances when cutting high tensile carbon steel
- High productivity when cutting stainless steel

<b>MATERIALS</b>	Hard solid carbon steel with a tensile strength higher than 900 N/mm <sup>2</sup> and ferritic, martensitic and duplex stainless steel bars Ø >35 mm on high performance machines
<b>PARAMETERS</b>	Suggested cutting speed: 60 - 140 m/min. Feed: 0,05 - 0,09 mm/tooth.
<b>MACHINES</b>	All known brands of stationary automatic sawing machines such as: Soco, Nishijimax, Tsune, Mega, Everising, Rattunde, Behringer etc.

For more information:

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

# Cutting low to medium tensile carbon and austenitic stainless solid steel



CX 6-S saw blades are carbide tipped and PVD coated for cutting stainless steel solids with a diameter  $\leq 35$  mm. High production rates and optimal surface finish can be achieved with our dedicated geometry.

## Advantages

- New saw body design
- Best saw blade when cutting ferritic, martensitic and duplex stainless steel at smaller diameter ranges
- Specifically developed for stainless steel solids with a diameter  $\leq 35$  mm
- Dedicated tooth geometry

<b>MATERIALS</b>	Austenitic, ferritic, martensitic and duplex stainless steel bars with a diameter $\leq 35$ mm
<b>PARAMETERS</b>	Suggested cutting speed: 80 - 140 m/min. Feed: 0,03 - 0,05 mm/tooth.
<b>MACHINES</b>	Soco, Tsune, Amada, Mega, Kasto, Kentai, Behringer, Exactcut, Everising



The PVD coated CX 6-L saw blade has specifically been designed for cutting austenitic stainless steel bars with a diameter larger than 35mm at very high production rates. With its dedicated geometry, very fast cutting and good surface finish can be achieved.

## Advantages

- New saw body design
- Specifically developed for stainless steel solids with a diameter  $> 35$  mm
- Dedicated tooth geometry
- Very high production rates

<b>MATERIALS</b>	Austenitic stainless steel bars with a diameter $> 35$ mm
<b>PARAMETERS</b>	Suggested cutting speed: 80 - 120 m/min. Feed: 0,06 - 0,12 mm/tooth.
<b>MACHINES</b>	Soco, Tsune, Amada, Mega, Kasto, Kentai, Behringer, Exactcut, Everising






CX 7 is a Cermet tipped, PVD coated saw blade dedicated to cutting carbon steel (carbon content  $< 0.60\%$ ) with a low to medium tensile strength up to 750 N/mm<sup>2</sup>. The best blade performance is being achieved when cutting lower tensile strength materials. On many applications, a blade life of 50 m<sup>2</sup> and more can be achieved.

## Advantages






- New saw body design
- Specifically designed for cutting low to medium tensile carbon steel
- Best blade performance when cutting lower tensile strength materials

<b>MATERIALS</b>	Solid carbon steel with a tensile strength up to 750 N/mm <sup>2</sup>
<b>PARAMETERS</b>	Suggested cutting speed: 100 - 280 m/min. Feed: 0,06 - 0,10 mm/tooth.
<b>MACHINES</b>	Soco, Kasto, Nishijima, Tsune, Amada, Behringer, RSA, Rattunde, Sinico, Mega, Exactcut, Everising

## Product application matrix TCT CX Series for (stainless) steel tubes

Color ref.	Application	Suggested blade type
<b>3</b>	Medium to high tensile carbon steel (C < 0.60%) Tensile strength 600 - 1.500 N/mm <sup>2</sup>	
<b>4</b>	Austenitic stainless steel tubes	
<b>5</b>	High tensile, thin walled carbon steel (C ≥ 0.60%) tubes Instable high tensile hollow sections	

## Product application matrix TCT CX Series for (stainless) steel solids

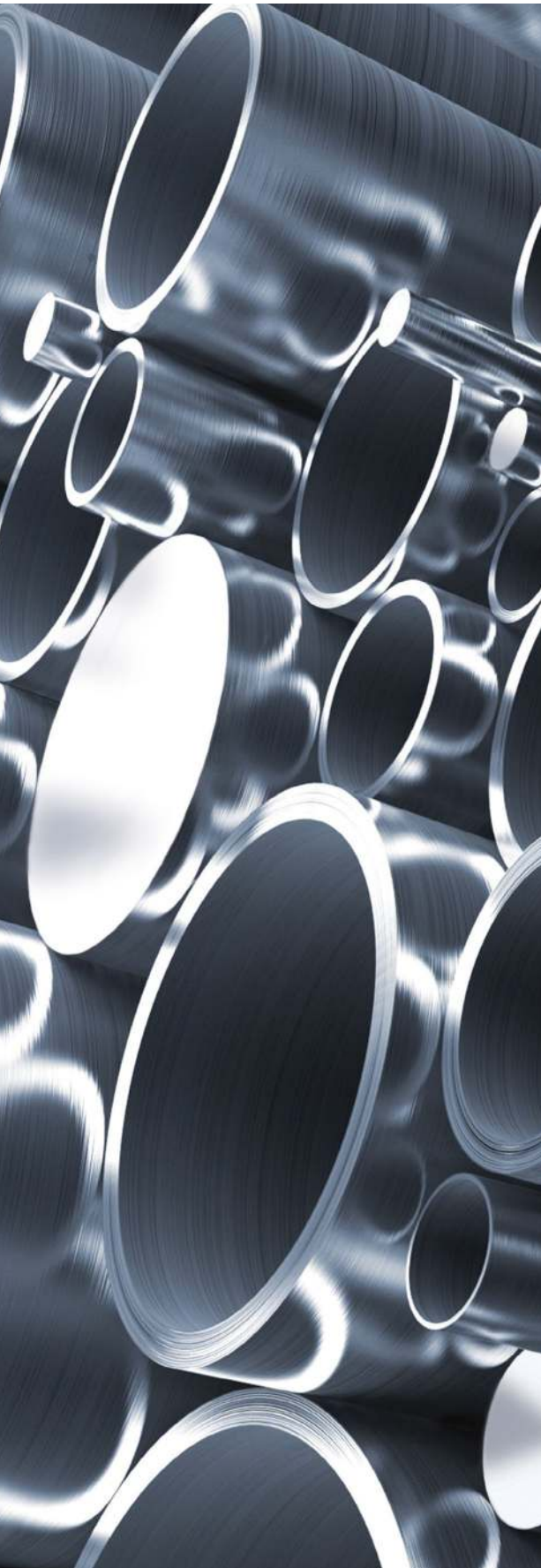
Color ref.	Application	Suggested blade type
<b>7</b>	Low to medium tensile carbon steel (C < 0.60%) Tensile strength < 750 N/mm <sup>2</sup>	
<b>1M</b>	Low to medium tensile carbon steel (C < 0.60%) Tensile strength 500 - 900 N/mm <sup>2</sup>	
<b>1H</b>	High tensile carbon steel (C ≥ 0.60%) Tensile strength > 900 N/mm <sup>2</sup>	
	Ferritic stainless steel Ø > 35 mm	
	Martensitic stainless steel Ø > 35 mm	
	Duplex stainless steel Ø > 35 mm	
<b>6S</b>	Ferritic stainless steel Ø ≤ 35 mm	
	Martensitic stainless steel Ø ≤ 35 mm	
	Duplex stainless steel Ø ≤ 35 mm	
	Austenitic stainless steel Ø ≤ 35 mm	
<b>6L</b>	Austenitic stainless steel Ø > 35 mm	

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