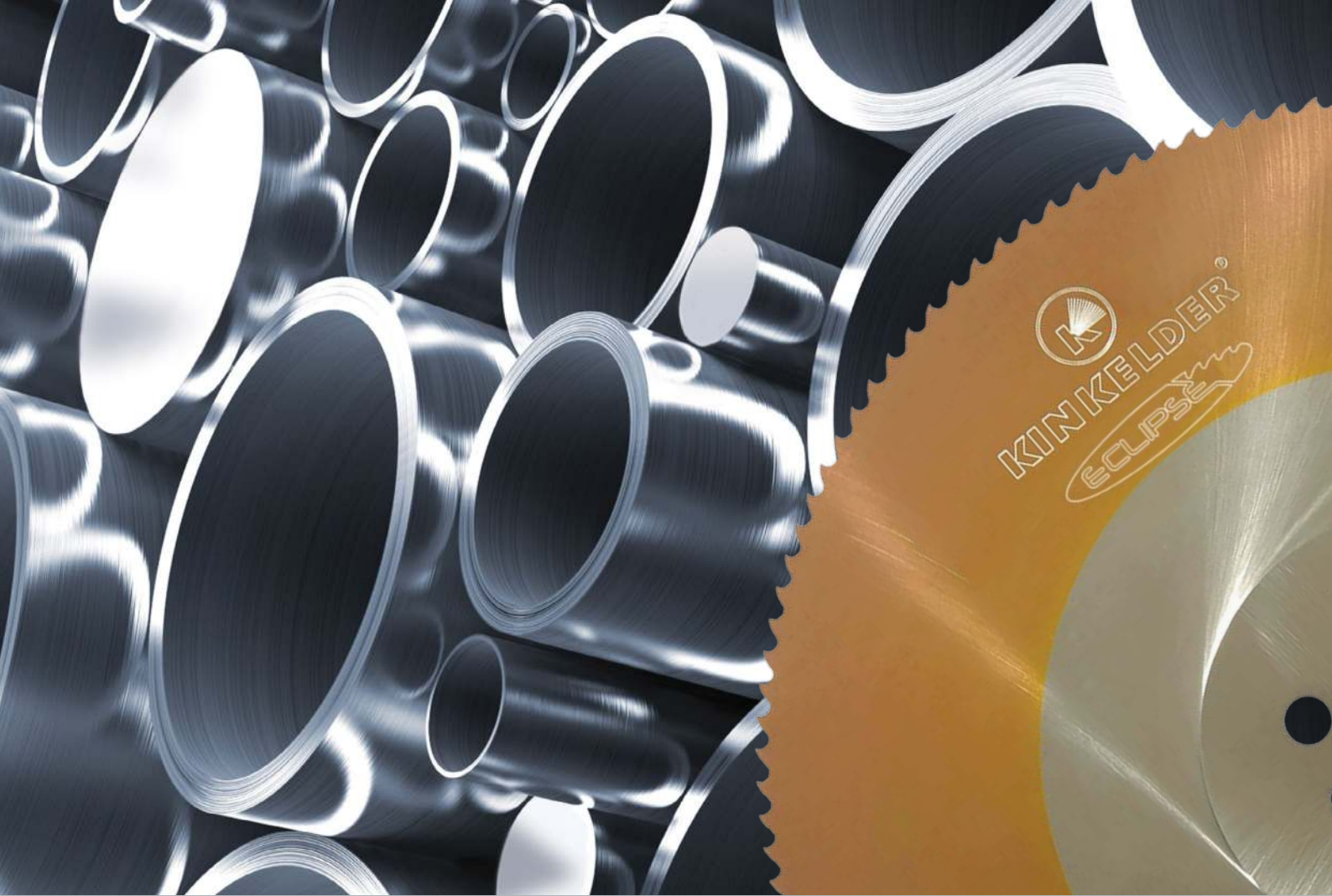




KINKELDER[®]
the cutting experts

HSS SERIES



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

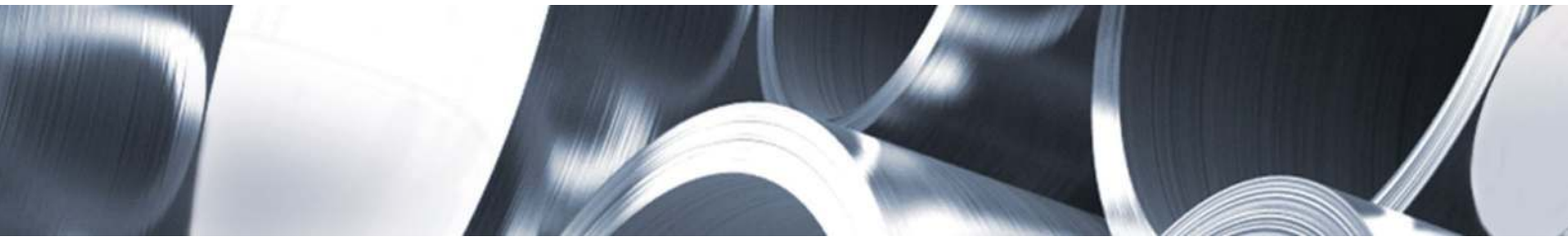
TYPICAL AVAILABE HSS ALPHA SAW BLADES

| 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 Eclipse 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, Eclipse allows a higher cutting speed than a steam treated saw blade. It can even be used for cutting thin walled tubes on automatic machines.

Eclipse 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

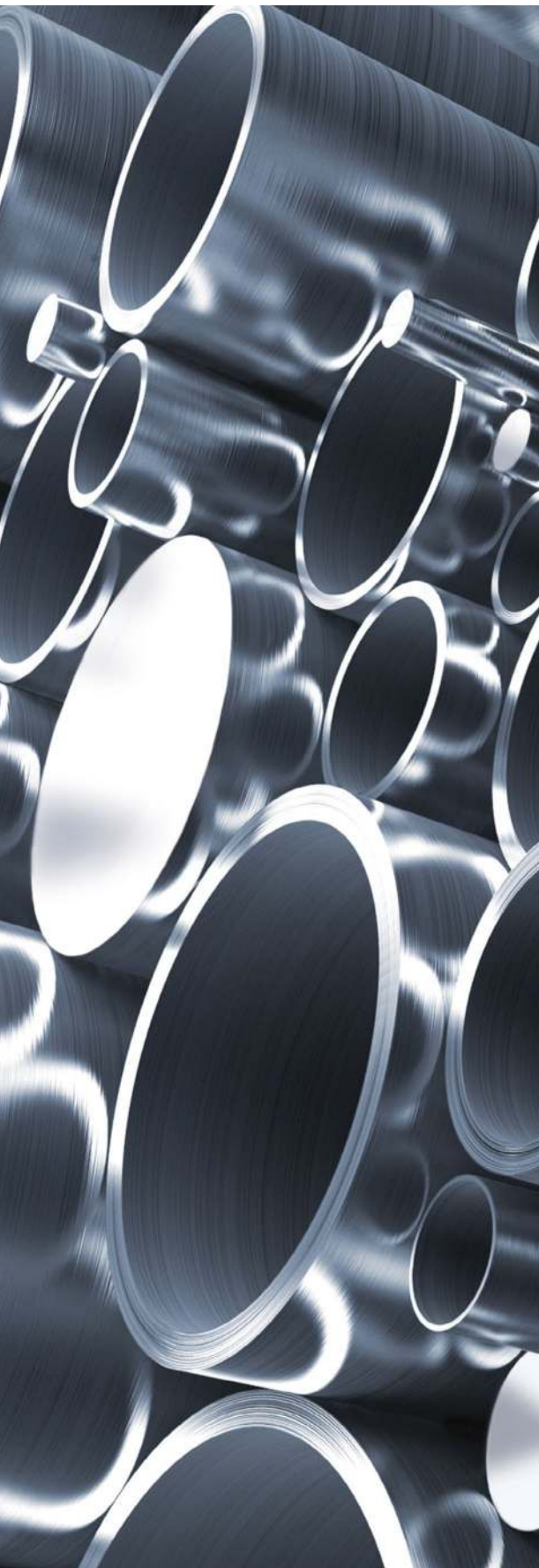
| | | |
|---------------------|--|--------------------------------|
| APPLICATIONS | All structural steel , non-alloy tool steel and stainless steel thin walled tubes. Tensile strength up to 600 N /mm ² | |
| PARAMETERS | | Suggested cutting speed |
| | Steel | 60 - 120 m/min |
| | Austenitic stainless 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 & ECLIPSE 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 |



KINKELDER[®]
the cutting experts



Kinkelder BV
Corporate Headquarters

Nijverheidsstraat 2
(Industrial Area Zuidspoor)
NL-6905 DL Zevenaar
The Netherlands

T: +31 (0)316 58 22 00
F: +31 (0)316 58 22 17
info@kinkelder.nl
www.kinkelder.com

KR Saws

Coventry, United Kingdom
T: +44 (0)24 7661 0907
sales@krsaws.co.uk
www.krsaws.co.uk

Kinkelder France SA

Orchies, France
T: +33 (320) 71 02 12
sales@kinkelder.fr
www.kinkelder.fr

AMV Service

Le Chambon Feugerolles
France
T: +33 (477) 405229
info@amvservice.com
www.amvservice.com

Sepio spol s.r.o.

Zborovice, Czech Republic
T: +420 (0)57 366 91 35
sepio@sepio.cz
www.sepio.cz

Werner Thelen Sägetechnik GmbH

Zülpich, Deutschland
T: +49 (2252) - 83875-0
info@wethe.de
www.wethe.de

Saws International Inc.

USA Headquarters
Machesney Park (IL), USA
T: +1 (815) 965 6900
info@kinkelderusa.com
www.kinkelderusa.com

Kinkelder Saw Inc.

Canton (MI), USA
T: +1 (734) 453 1199
info@kinkelderusa.com
www.kinkelderusa.com

Kinkelder Cutting Solutions Inc.

Louisville (KY), USA
T: +1 (502) 329 8244
cridge@kinkelderusa.com
www.kinkelderusa.com

Kinkelder USA South

Pell City (AL), USA
T: +1 (205) 884 49 71
info@kinkelderusa.com
www.kinkelderusa.com

Haas Saw & Supply

Summerville (SC), USA
T: +1 (843) 875 80 05
sales@haassaw.com
www.haassaw.com

Kinkelder Cutting Technology Co., Ltd.

Suzhou City, China
T: +86 (0)512 693 68 780
info@kinkelderchina.cn
www.kinkelder.com.cn

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