



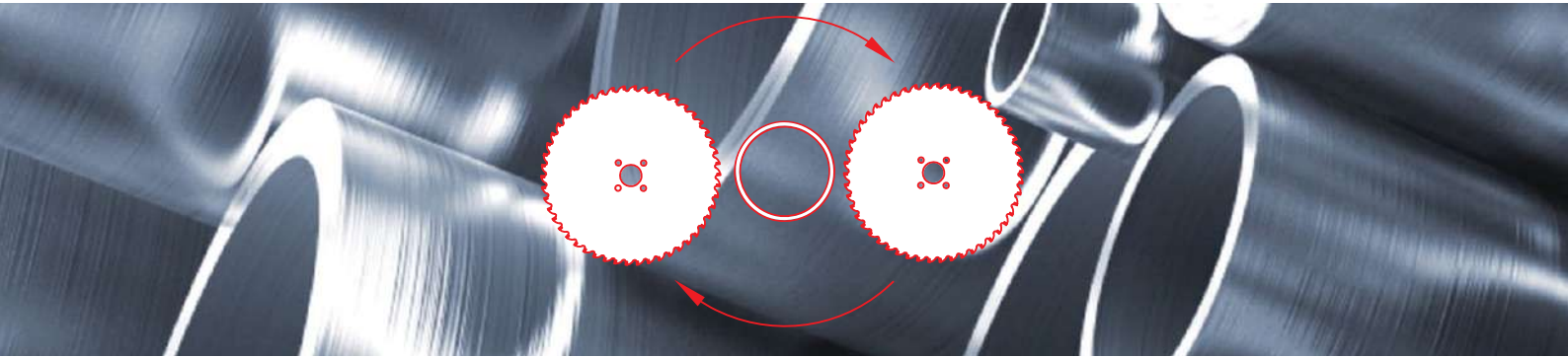
**KINKELDER**<sup>®</sup>  
the cutting experts



## **FLYING CUT-OFF** **TCT SERIES**

**3 proven sawing concepts  
for ERW tube and pipe industry**

# Orbital cut-off



TubeMaster saw blades have especially been designed for orbital flying cut-off applications on tube mills. Key features of this saw blade are fracture-resistant carbide tips, protected with a high-tech TiAlN-based PVD coating. Combined with a light cutting geometry for smooth chip evacuation, a milled like surface finish is achieved. This geometry also reduces vibration when cutting thin walled tubes (<4mm), thereby achieving excellent blade life.

The new generation of TubeMaster products has a new body design, new carbide grade, new tip geometry and a special coating. This results in a higher blade life and more regular blade performance.

## Advantages

- High line speed
- Cuts high tensile API Pipes (up to 110 KSI, X80, HT)
- High blade life
- Burr-free cut

**APPLICATIONS:** Orbital, flying cut-off applications

TubeMaster saw blades are available in diameters from Ø 300 up to Ø420 mm for all types of orbital cutting machines, such as MTM, OTO mills, Elmaksan, Kusakabe, Linsinger, Nakata and SMS Meer.

**PARAMETERS:** Suggested cutting speed: 350 - 400 m/min. Feed 1/2: 0,04 / 0,12 mm/tooth.

The TubeMaster Stainless saw blade has specifically been developed for cutting stainless steel tubes on orbital flying cut-off units. These saw blades can cope with cutting speeds between 60 - 120 m/min.

TubeMaster Stainless offers high uptime due to a blade life up to 3,5m<sup>2</sup>, combined with high cut quality and production output.

**APPLICATIONS:** Cutting austenitic stainless steel tubes on orbital flying cut-off machines

**PARAMETERS:** Suggested cutting speed: 60 - 120 m/min. Feed: 0.035 - 0.10 mm/tooth

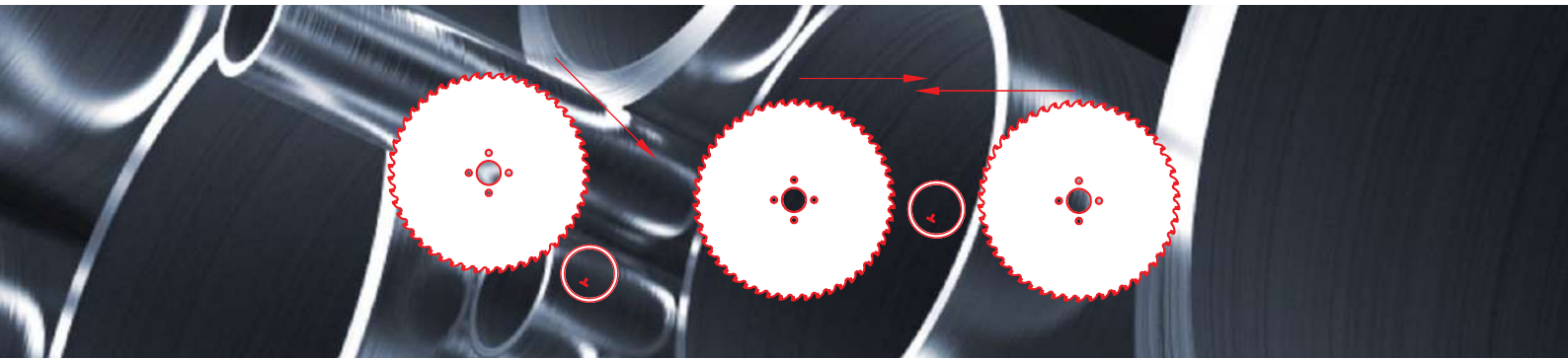
**MACHINES:** TubeMaster Stainless saw blades are available for all orbital cutting machines



For more information:

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

# Single and Twin cut-off with inside scarf



The PVD coated carbide tipped ScarfMaster has specifically been designed for flying cut-off applications dealing with heavy inside scarf. It features a very specific tooth geometry, combined with highly shock resistant carbide tips.

Due to strong saw body shoulders which give the teeth maximum support, the combination tooth/body obtains very high stability and fracture resistance. Extended blade life is therefore achieved.

#### Advantages

- High line speed
- Increased uptime
- High blade life
- Cuts heavy inside scarf
- Cuts high tensile API tubes (up to 110 KSI)
- Various tooth pitches available

**APPLICATIONS:** Flying cut-off applications dealing with heavy inside scarf

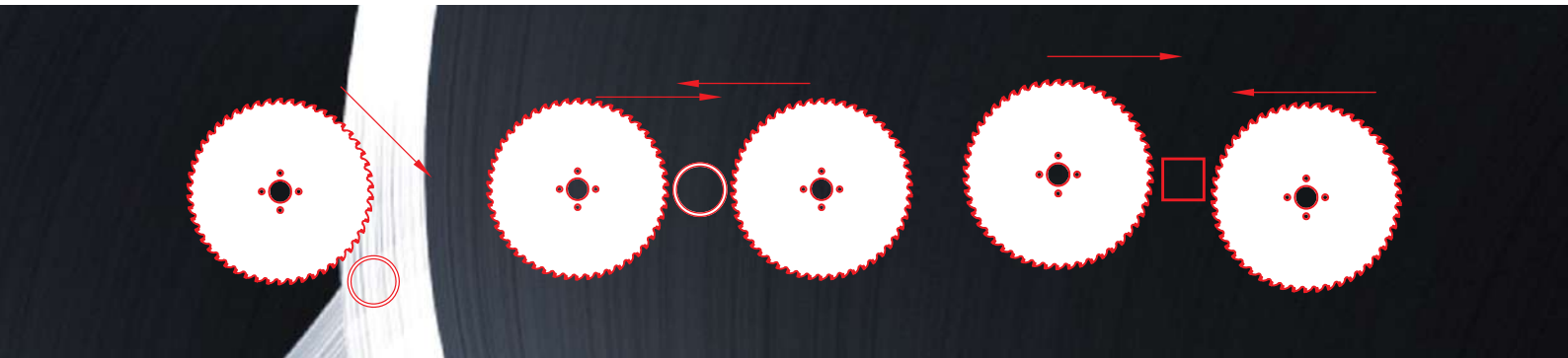
ScarfMaster saw blades are available in diameters from Ø 350 up to Ø600 mm for flying cut-off machines, such as MTM, OTO mills, Nakata and Olimpia.

**PARAMETERS:** Suggested cutting speed: 450 - 600 m/min. Feed: 0,04 mm/tooth.

#### TYPICAL APPLICATION EXAMPLES SCARFMASTER

Dimensions (mm)	Material specifications	Tensile strength (N/mm <sup>2</sup> )	Mill speed (m/min)	Cutting time (s)	Blade life (m <sup>2</sup> )	Machine
168 x 6	S355	520	40	4,8	3,5	OTO mills
100 x 8	1018	480	30	4,2	5,2	OTO mills
63 x 5	S355	520	60	2,6	3,5	MTM
48 x 3	S500 MC	500	75	2,0	2,4	Olimpia

# Single and Twin cut-off without inside scarf



SpeedMaster is a TCT saw blade for single- and twin cut-off units on steel tube mills. It provides an opportunity to greatly increase the tube manufacturing line speeds and cut the production costs.

Where cutting speed limits of coated HSS saw blades have been reached, SpeedMaster saw blades provide an effective solution.

## Advantages

- Extremely high line speed because of very short cutting times
- Very good surface finish, burr-free cut
- Increased uptime

**APPLICATIONS:** Single and Twin flying cut-off machines designed for TCT cutting with small or no ID scarf.

Tubes with a tensile strength up to 1800 N/mm<sup>2</sup>.

**PARAMETERS:** Suggested cutting speed: 200 - 600 m/min.

## TYPICAL APPLICATION EXAMPLES SPEEDMASTER

Dimensions (mm)	Material specifications	Tensile strength (N/mm <sup>2</sup> )	Mill speed (m/min)	Cutting speed (m/min)	Tooth load (mm/tooth)	Blade life (m <sup>2</sup> )
40 x 20 x 3	S355/1020	520	350	450	0,06/0,18	2,5
76 x 4,7	E235	420	90	400	0,06/0,14	7,9
60 x 5	S500MC	500	90	350	0,05/0,15	5,2

# Which concept fits you?



3 concepts, each designed  
to address a specific flying cut-off application



## Your benefits:

- Increase uptime
- Increase line speed
- Improve blade life
- Produce a burr-free cut

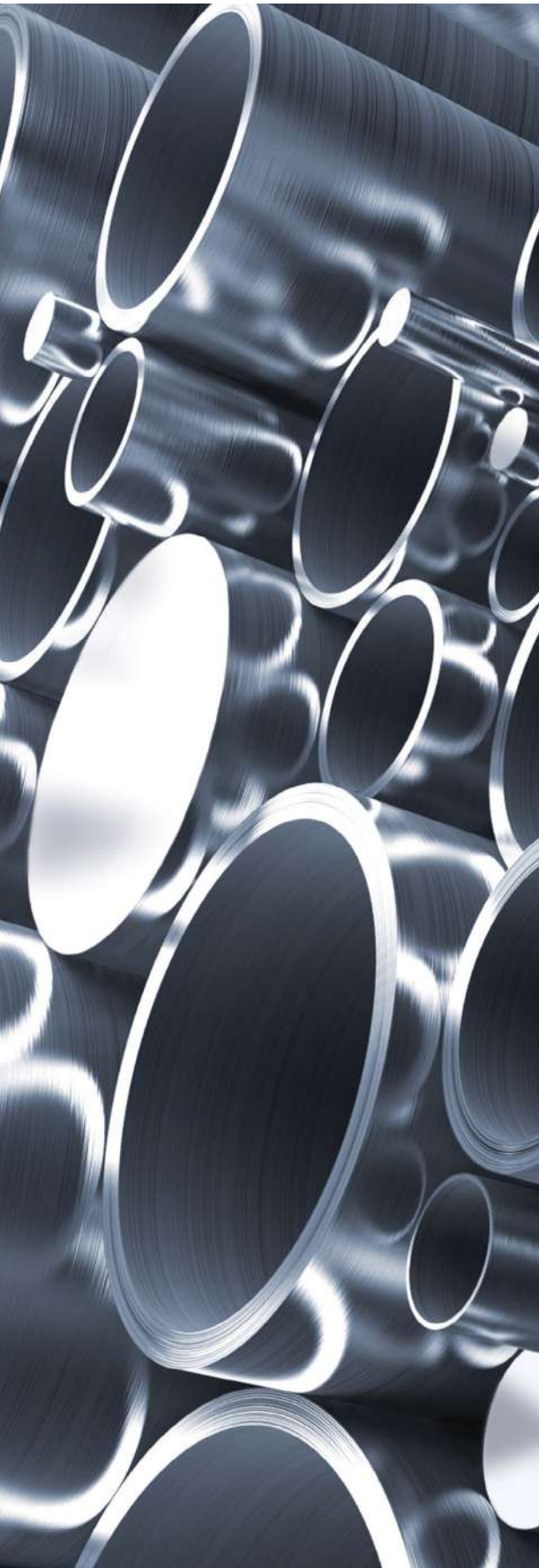
MACHINE	MATERIAL	SOLUTION
Orbital	All types	TubeMaster
Single linear or Twin	ID Scarf	ScarfMaster
	No ID Scarf	SpeedMaster

For more information:

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