



KINKELDER[®]
the cutting experts

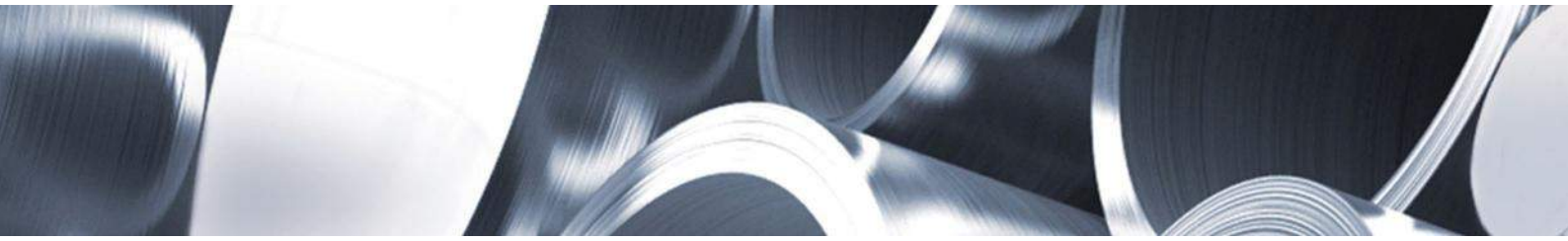
HSS SERIES



STANDARD

HSS SERIES

Cutting tubes and solids on manual
and (semi-)automatic 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.

- MATERIALS:** All materials 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 materials with high tensile strengths.

- MATERIALS:** All materials 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.

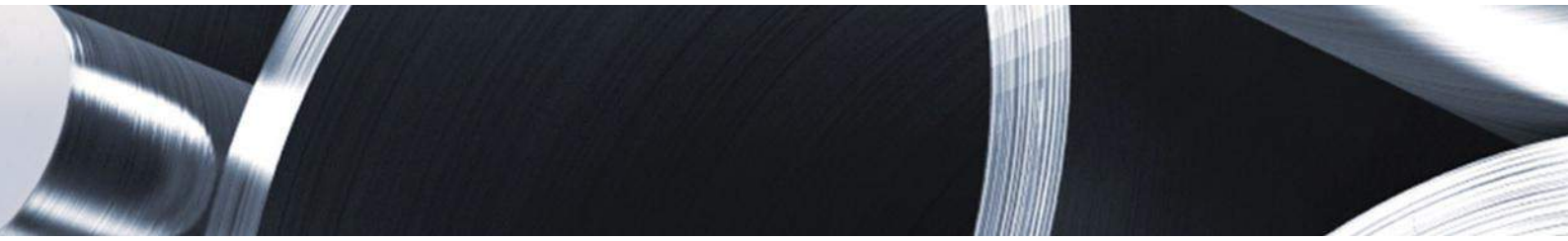
- MACHINES:** Manual, semi-automatic, automatic

TYPICAL APPLICATION EXAMPLES

Blade type	Material	Dimensions (mm)	Cutting speed (m/min)	Cutting time (s)	Blade life (cuts)	Blade life (m ²)
Alpha	Tube	25 x 1,5	38	4,0	18,000	2,0
Alpha	Tube	32 x 2,0	38	4,2	14,000	2,5
Solar	Tube, S275	33,9 x 2,0	150	1,5	11,000	2,2
Solar	Tube, S275	45 x 2,5	150	2,0	6,000	2,0

For more information:

www.kinkelder.com



EC 3000 - The allround HSS solution

Due to a sophisticated PVD coating for wear protection which achieves a very low friction coefficient, the EC 3000 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, EC 3000 allows a higher cutting speed than a steam treated saw blade. It can even be used for cutting thin walled tubes on automatic machines.

EC 3000 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- and stainless steel



MATERIALS: All structural steel , non-alloy tool steel and stainless steel thin walled tubes. Tensile strength up to 600 N / mm².

PARAMETERS:	Suggested cutting speed	Blade life
Steel	60 - 120 m/min	
Austenitic stainless steel (300 series)	30 - 50 m/min	≈ 1 m ²
Ferritic w/o Ti (409 & 412)	220 - 260 m/min	≈ /< 1 m ²
Ferritic with Ti (441)	60 - 120 m/min	

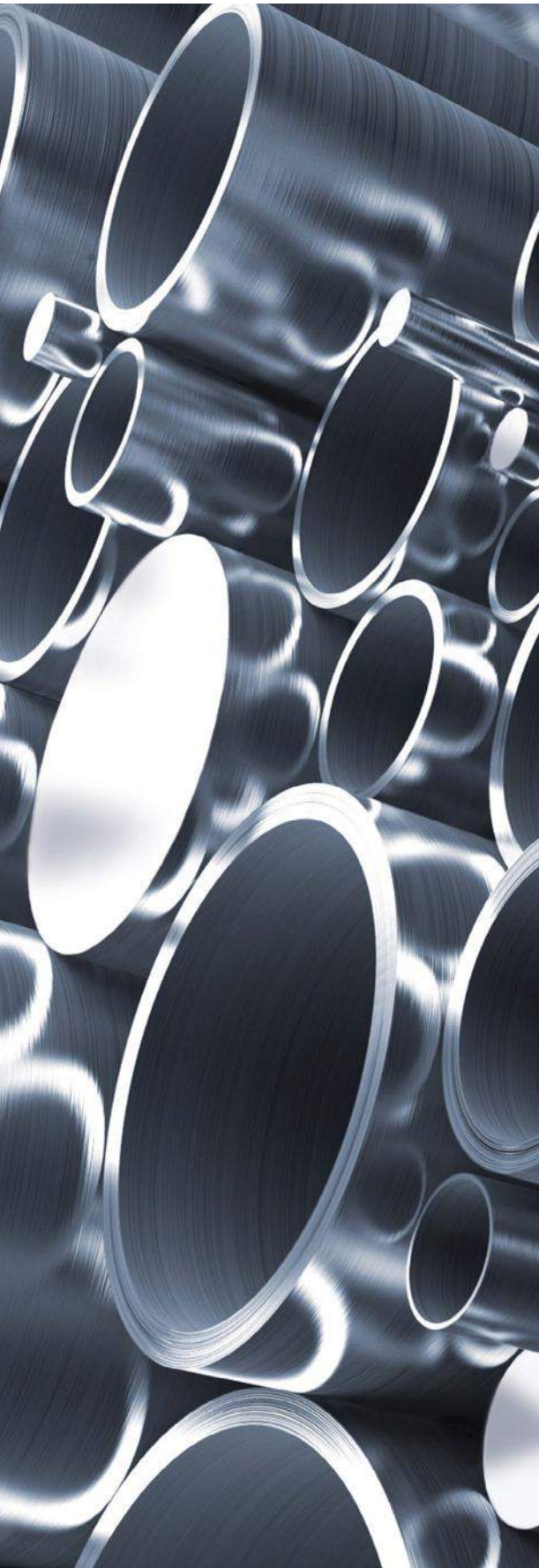
MACHINES: Automatic

TYPICAL APPLICATION EXAMPLES HSS EC 3000

Material	Dimensions (mm)	Cutting speed (m/min)	Cutting time (s)	Blade life (cuts)	Blade life (m ²)
Tube, S235	18 x 1,6	180	0,4	35.000	3,0
Tube, S235	25 x 2,0	140	0,9	25.000	3,6
Tube, S235	40 x 4,0	70	3,96	5.000	2,2
Tube, S275	60 x 2,6	120	2,7	5.000	2,6



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Kinkelder BV
Corporate Headquarters

Nijverheidsstraat 2
(Industrial Area Zuidspoor)
NL-6905 DL Zevenaar
P.O. Box 242
NL-6900 AE Zevenaar
The Netherlands

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

Kinkelder Belgium
N.V./S.A.

Sint-Pieters-Leeuw, Belgium
T: +32 (0)2 465 64 42
info@kinkelder.be
www.kinkelder.be

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.com/fr

Kinkelder France

Messein, France
T: +33 (383) 539713
info@kinkelder.fr
www.kinkelder.com/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

Kinkelder Cutting
Technology Co., Ltd.

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

Saws International
USA Headquarters

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

Kinkelder Saw Inc.

Canton (MI), USA
T: +1 (734) 453 1199
info@kinksaw.com
www.kinkelder.com/en

Kinkelder Cutting
Solutions Inc.

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

Alabama Cutting
Technologies

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

KTS Sägetechnik GmbH

Zülpich, Germany
T: +49 (2252) 835178-0
info@kts-saetechnik.de
www.kts-saetechnik.de

Grasche GmbH

Remscheid, Germany
T: +49 (0) 2191-5615-0
info@grasche.de
www.grasche.de