



**KINKELDER**<sup>®</sup>  
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 / mm<sup>2</sup>

#### 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 / mm<sup>2</sup>

#### 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](http://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

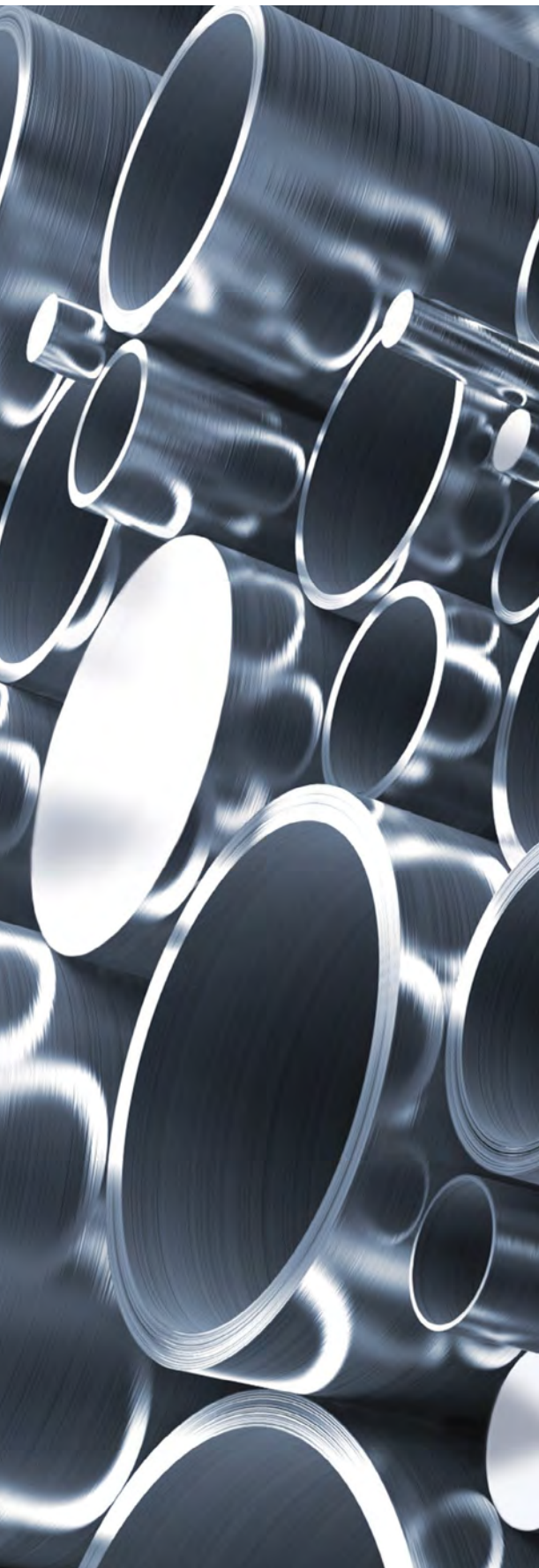
<b>APPLICATIONS</b>	All structural steel , non-alloy tool steel and stainless steel thin walled tubes. Tensile strength up to 600 N /mm <sup>2</sup>	
<b>PARAMETERS</b>		<b>Suggested cutting speed</b>
	Steel	60 - 120 m/min
	Austenitic stainless steel (300 series)	30 - 50 m/min
	Ferritic without Ti (409 & 412)	220 - 260 m/min
	Ferritic with Ti (441)	60 - 120 m/min
<b>MACHINES</b>	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



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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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