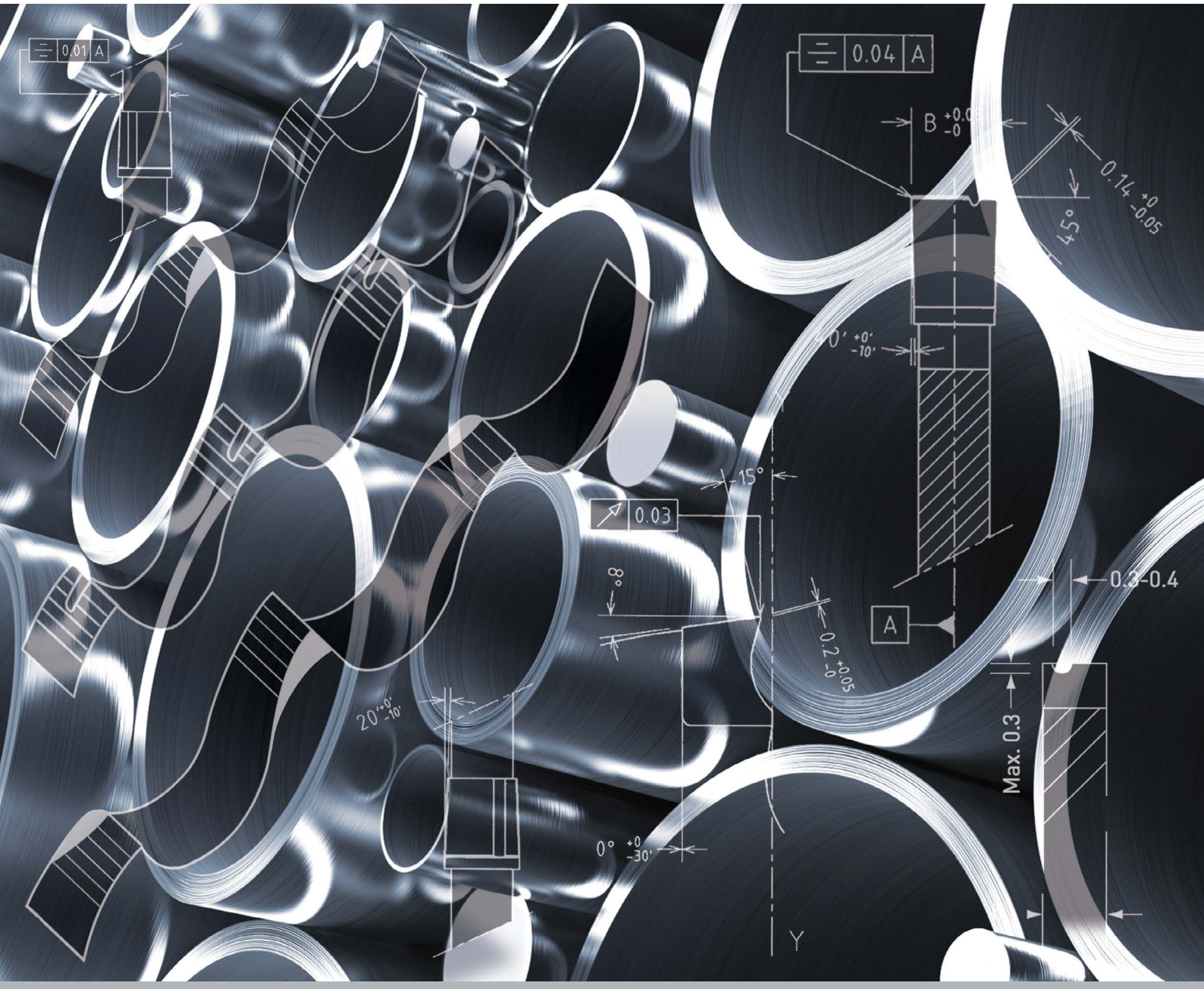
KINKELDER®
the cutting experts



SAW SUPPORT

Standard products and technical specifications

- Standard range HSS saw blades
- Tooth forms
- Cutting speed - RPM
- Segmental saw blades
- Solutions to cutting problems
- Product Application Matrixes



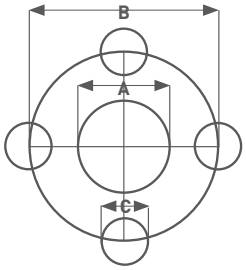
Standard range HSS saw blades

Diameter (mm)	Kerf (mm)				Weight (kg)				Number of teeth and tooth pitches													
									T3	T4	T5	T6	T7	T8	T9	T10	T11	T12	T14	T16	T18	
160	1.2	1.6	2.0		0.2	0.3	0.35		164	126	100	84		60								
175	1.2	1.6	2.0		0.25	0.35	0.4		180	140	110	90		64								
200	1.2	1.6	1.8	2.0	0.3	0.4	0.4	0.5	200	160	128	100		72								
210	2.0				0.5				210	160	130	110		84								
225	1.2	1.6	2.0		0.4	0.5	0.6		220	180	150	120	110	90	80							
250	1.6	2.0	2.5	3.0	0.6	0.7	0.9	1.1	240	200	160	128	120	100		80		64				
275	1.6	2.0	2.5	3.0	0.7	0.8	1.1	1.3	280	220	180	144	140	110	96	84	78	72				
300	1.6	2.0	2.5	3.0	0.8	1.0	1.3	1.6	320	240	200	160	140	120	110	100	90	80				
315	2.0	2.5	3.0		1.1	1.4	1.7		320	250	200	160	150	120	110	100	90	80	72			
325	2.0	2.5	3.0		1.2	1.5	1.8		320	250	200	170	160	130	110	100		90				
350	2.0	2.5	3.0	3.5	1.5	1.8	2.0	2.3	350	280	220	180	160	140	120	110		90	80			
370	2.5	3.0	3.5		2.0	2.5	3.0			300	220	190	180	140	128	110	100	90	80	70		
400	2.5	3.0	3.5	4.0	2.5	3.0	3.5	4.0		320	250	200	180	160	140	128		100	90	80	70	
425	3.0	3.5	4.0		3.0	3.5	4.0			350	260	220		160	140	130	120	110	100	80	70	
450	3.0	3.5	4.0		3.5	4.0	4.5				280	240		180		140		120	100	90	80	
500	3.0	3.5	4.0	5.0	4.0	5.0	5.5	6.9			310	260		200		160		130	110	100	90	
525	3.5	4.0			5.5	5.7					330	270		210		164		140	120	104	90	
550	3.5	4.0	5.0		5.0	6.5	7.9				340	280		220		170		140	120	110	100	
570	4.0	5.0			6.8	8.2					360	300		220		180		150	130	110	100	
600	4.0	5.0			7.0	8.4						320		240		190		160	130	120	100	
630	4.0	5.0			7.5	9.0						320		240		190		160	130	120	100	

Standard bore & pinhole combinations

Bore Ø (mm)	Pinhole combinations (mm)		
32	2/8,5/45	2/12/64	4/9/50
32 (Power / X-treme)	2/8,5/45	2/11/63	
40	2/8,5/55	4/12/64	
	2/15/80	2/15/100	4/12/64*
50	4/15/80	4/15/85	
50 (Power / X-treme)	4/15/80		
80	4/23/120		

Other bore/pinhole combinations available on request. * Diameter Ø 450 mm only.



A Borehole
B PCD
C Pinholes



Kerf/bore/hub HSS Standard

HSS BRIGHT & ALPHA



Ø	Kerf									Bore hole / hub combinations			
160	1.2	1.6		2.0						32/100			
175		1.6		2.0						32/100			
200	1.2	1.6	1.8	2.0						32/100			
225	1.2	1.6		2.0	2.5					32/100	40/110		
250	1.2	1.6		2.0	2.5					32/100	40/110		
275	1.2	1.6		2.0	2.5	3.0				32/100	40/110		
300		1.6		2.0	2.5	3.0				32/100	40/110		
315				2.0	2.5	3.0				32/100	40/110	50/140	
325				2.0	2.5	3.0				32/120	40/120		
350				2.0	2.5	3.0	3.5			32/120	40/140	50/140	
370				2.0	2.5	3.0	3.5			32/120	40/140	45/140	50/140
400					2.5	3.0	3.5	4.0	4.5	32/120	40/140	50/140	
425					2.5	3.0	3.5	4.0		32/120	40/140	50/140	
450					2.5	3.0	3.5	4.0		32/130	40/140	50/150	

HSS SOLAR

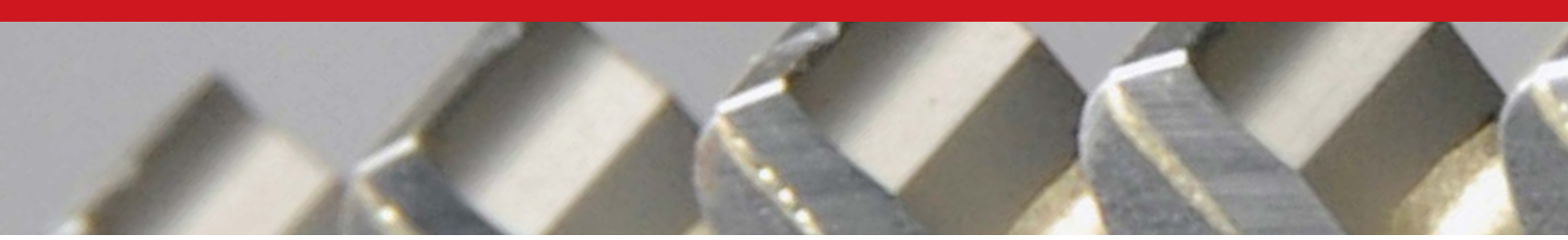


Ø	Kerf									Bore hole / hub combinations			
160	1.2	1.6		2.0						32/100			
175		1.6		2.0						32/100			
200	1.2	1.6	1.8							32/100			
225	1.2	1.6		2.0	2.5					32/100	40/110		
250	1.2	1.6		2.0	2.5					32/100	40/110		
275	1.2	1.6		2.0	2.5	3.0				32/100	40/110		
300		1.6		2.0	2.5	3.0				32/100	40/110		
315				2.0	2.5	3.0				32/100	40/110	50/140	
325				2.0	2.5	3.0				32/120	40/120		
350				2.0	2.5	3.0	3.5			32/120	40/140	50/140	
370				2.0	2.5	3.0	3.5			32/120	40/140	45/140	50/140
400					2.5	3.0	3.5	4.0	4.5	32/120	40/140	50/140	
425					2.5	3.0	3.5	4.0		32/120	40/140	50/140	
450					2.5	3.0	3.5	4.0		32/130	40/140	50/150	

HSS FERNOX



Ø	Kerf									Bore hole / hub combinations			
160	1.2	1.6		2.0						32/100			
175		1.6		2.0						32/100			
200	1.2	1.6	1.8							32/100			
225	1.2	1.6		2.0	2.5					32/100	40/110		
250	1.2	1.6		2.0	2.5					32/100	40/110		
275	1.2	1.6		2.0	2.5	3.0				32/100	40/110		
300		1.6		2.0	2.5	3.0				32/100	40/110		
315				2.0	2.5	3.0				32/100	40/110	50/140	
325				2.0	2.5	3.0				32/120	40/120		
350				2.0	2.5	3.0	3.5			32/120	40/140	50/140	
370				2.0	2.5	3.0	3.5			32/120	40/140	45/140	50/140
400					2.5	3.0	3.5	4.0	4.5	32/120	40/140	50/140	
425					2.5	3.0	3.5	4.0		32/120	40/140	50/140	
450					2.5	3.0	3.5	4.0		32/130	40/140	50/150	
500						3.0	3.5			50/150	80/200		
525						3.0	3.5			50/150	80/200		
550							3.5	4.0		90/200	140/225	50/150	
560							3.5	4.0		50/150	80/200	140/225	
600							3.5	4.0		50/150	80/240	140/225	50/190
630						3.0	3.5			80/200			



Kerf / bore / hub HSS Advanced

HSS FUSION 2.0 & FUSION NX



Ø	Kerf									Bore hole / hub combinations			
160	1.2	1.6		2.0						32/100			
175		1.6		2.0						32/100			
200	1.2	1.6	1.8							32/100			
225	1.2	1.6		2.0	2.5					32/100	40/110		
250	1.2	1.6		2.0	2.5					32/100	40/110		
275	1.2	1.6		2.0	2.5	3.0				32/100	40/110		
300		1.6		2.0	2.5	3.0				32/100	40/110		
315				2.0	2.5	3.0				32/100	40/110	50/140	
325				2.0	2.5	3.0				32/120	40/120		
350				2.0	2.5	3.0	3.5			32/120	40/140	50/140	
370				2.0	2.5	3.0	3.5			32/120	40/140	45/140	50/140
400					2.5	3.0	3.5	4.0	4.5	32/120	40/140	50/140	
425					2.5	3.0	3.5	4.0		32/120	40/140	50/140	
450					2.5	3.0	3.5	4.0		32/130	40/140	50/150	
500						3.0	3.5			50/150	80/200		
525						3.0	3.5			50/150	80/200		
550							3.5	4.0		90/200	140/225	50/150	
560							3.5	4.0		50/150	80/200	140/225	
600							3.5	4.0		50/150	80/240	140/225	50/190
630						3.0	3.5			80/200			

HSS POWER 2.0 & POWER NX

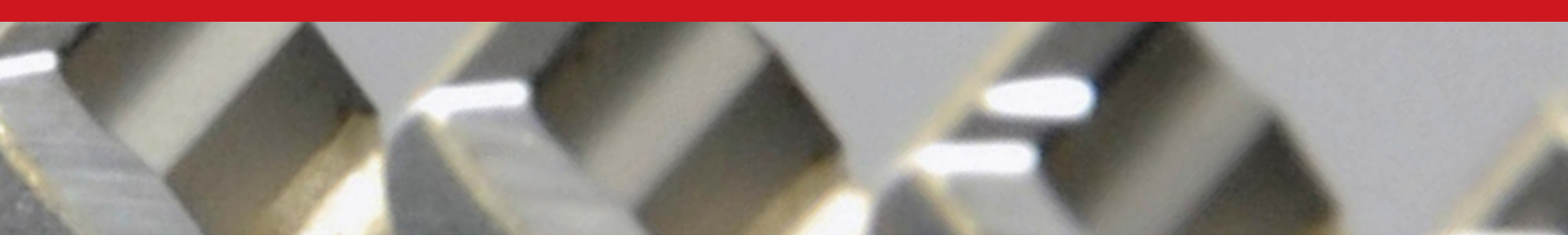


Ø	Kerf							Bore hole / hub combinations		
160	1.2							32/100		
200	1.2							32/100		
225	1.2							32/100		
250	1.2	1.6	1.8	2.0				32/100	40/120	
275	1.2		1.8	2.0		2.5		32/100	40/120	
315			1.8	2.0		2.5		32/100	40/120	50/140
350			1.8	2.0	2.2	2.5	3.0	32/120	40/140	50/140
370			1.8	2.0		2.5	3.0	32/120	40/140	50/140
400				2.0	2.2	2.5	3.0	40/140	50/140	
425						2.5	3.0	40/140	50/140	
450						2.5	3.0	32/130	40/140	50/150
600							3.0	50/200	80/200	

HSS X-TREME 2.0 & X-TREME NX

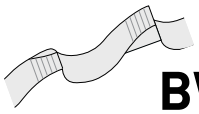


Ø	Kerf			Bore hole / hub combinations		
225		2.5		32/100	40/120	
315	2.0	2.5		32/120	40/140	50/140
350	2.0	2.5		32/120	40/140	50/140
370		2.5		32/120	40/140	50/140
400		2.5	3.0	32/120	40/140	50/140
425		2.5	3.0	32/120	40/140	50/140



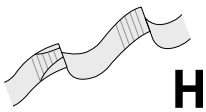
GEOMETRY

Tooth forms



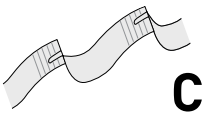
BW

All teeth of tooth form 'BW' are beveled alternatively. It is most suitable for cutting light gauge tubes and sections made of steel or non-ferrous metals. Tooth pitch 4mm or smaller.



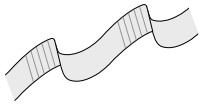
HZ

The 'HZ' tooth form is most suitable for cutting solids and thick walled tubes. The roughening tooth is bevelled on both sides and is between 0,2 and 0,3 mm higher than the square finishing tooth. Tooth pitch higher than 4mm.



CB

The Chipbreaker tooth form is most effective for tube and profile cutting, particularly with PVD coated blades (kerf 1,6mm and higher). It minimizes burr formation even at high cutting rates. It requires a stronger motor and allows the highest speeds. At high speeds the tube walls should not be too thin.



B

Tooth form 'B' is used for cutting very thin walled pipes and profiles. It is best applied for thin kerf saw blades.

STANDARD

Standard range HSS saw blades

TOOTH PITCH RECOMMENDATION (MM)

Diameter material (mm)	10	20	30	40	50	60	70	80	90	100	110	120	130	140	150
Round	5	7	8	9	10	11	12	13	14	14	15	16	16	17	17
Square	5	7	8	9	10	11	12	13	14	14	15	16	16	17	17
Thick walled (≥ 2,5mm) tube	4	5	6	6	7	7	7	7	8	8	8	8	8	8	9
Thin walled (≤ 2 mm) tube	3	4	5	5	6	6	6	7	7	7	7	7	7	7	8
RSJ								13	13	13	13	13	14	14	15
Channel			13	13	14	14	14	14	14	14	14	15	16	16	16

SPEED RECOMMENDATION (M/MIN)

Material type	Structural steels	Special steels	Stainless	Cast steel	Cast iron	Copper	Non-ferrous		
							Brass	Bronze	Aluminum
Round	30-60	20-40	5-30	15-30	10-40	200-400	350-600	25-125	80-1800
Square	30-60	20-40	5-30	15-30	10-40	200-400	350-600	25-125	80-1800
Thick walled (≥ 2,5mm) tube	40-80	20-50	5-40	15-30	10-50	200-500	350-750	25-125	125-1800
Thin walled (≤ 2 mm) tube	50-120	25-80	10-50			350-650	400-900		250-1800
RSJ	48-80	20-50	10-40						
Channel	30-60	20-50	10-40						80-1800



Segmental saw blades

Segmental circular saw blades consist of a chrome vanadium steel body, with hardened toothed segments riveted to the periphery. This construction makes it possible to repair a segmental saw blade after heavy tooth or segment damage, by simply replacing one or more segments. Kinkelder produces segmental circular saw blades in diameters from 250 mm to 1610 mm.



Standard specifications			
Material	**Tooth forms**	**Cutting/ clearance angle**	**Hardness**
M 2 = DIN 1.3343	HZ, BW	18 ° / 8 °	63 - 65 HRC
M 35 = DIN 1.3243 (5% Cobalt)			

The Kinkelder production range also includes saw blades with non-standard dimensions, such as different bores, pinholes, tooth pitches and tooth forms.

Diameter (mm)	No. of segments	Thickness (mm)	Bore hole (mm)	Pinhole combinations			Weight (kg)	Approx. tooth pitch dependent on the number of teeth per segment						
								3	4	5	6	8	10	12
275	12	3,0	32	2/8,5/45	4/9/50	2/12/64	1,0	24,0	17,9	14,4	12,0	9,0	7,2	6,0
275	12	3,0	40	2/8,5/55	4/12/64		1,0	24,0	17,9	14,4	12,0	9,0	7,2	6,0
300	14	3,6	32	2/8,5/45	4/9/50	2/12/64	1,5	22,4	16,8	13,5	11,2	8,4	6,7	5,6
300	14	3,6	40	2/8,5/55	4/12/64		1,5	22,4	16,8	13,5	11,2	8,4	6,7	5,6
315	14	3,6	32	2/8,5/45	4/9/50	2/12/64	1,5	23,5	17,7	14,1	11,8	8,8	7,1	5,9
315	14	3,6	40	2/8,5/55	4/12/64		1,5	23,5	17,7	14,1	11,8	8,8	7,1	5,9
315	14	3,6	50	4/15/80	4/15/85		1,5	23,5	17,7	14,1	11,8	8,8	7,1	5,9
360	16	3,6	40	2/8,5/55	4/12/64		2,0	23,5	17,7	14,1	11,8	8,8	7,1	5,9
360	16	3,6	50	4/15/80	4/15/85		2,0	23,5	17,7	14,1	11,8	8,8	7,1	5,9
370	16	3,6	50	4/15/80	4/15/85		2,5	24,2	18,2	14,5	12,1	9,0	7,3	6,1
400	16	4,0	40	2/15/80	4/12/64		3,0	26,2	19,6	15,7	13,1	9,8	7,9	6,5
400	16	4,0	50	4/15/80	4/15/85		3,0	26,2	19,6	15,7	13,1	9,8	7,9	6,5
400	16	4,0	60	4/16/90	4/23/96		3,0	26,2	19,6	15,7	13,1	9,8	7,9	6,5
400	16	5,0	50	4/15/80	4/15/85		3,5	26,2	19,6	15,7	13,1	9,8	7,9	6,5
425	18	4,0	40	2/15/80	4/12/64		3,5	24,7	18,5	14,8	12,5	9,3	7,4	6,2
425	18	4,0	50	4/15/80	4/15/85		3,5	24,7	18,5	14,8	12,5	9,3	7,4	6,2
450	18	4,0	50	4/15/80	4/18/100		4,0	26,1	19,6	15,7	13,1	9,8	7,9	6,5
460	18	5,0	40	4/12/64	2/15/80	2/15/100	4,5	26,7	20,1	16,0	13,4	10,0	8,0	6,7
460	18	5,0	50	4/15/80	4/15/85		4,5	26,7	20,1	16,0	13,4	10,0	8,0	6,7
460	18	5,0	60	4/18/100	4/16/90	4/23/96	4,5	26,7	20,1	16,0	13,4	10,0	8,0	6,7
510	18	5,7	50	4/15/80	4/18/100		6,5	29,7	22,2	17,8	14,8	11,1	8,9	7,4
560	18	5,0	50	4/18/100			7,0	32,6	24,4	19,5	16,3	12,2	9,8	8,1
560	18	5,0	80	8/22/142			7,0	32,6	24,4	19,5	16,3	12,2	9,8	8,1
630	20	5,0	80	4/22/120	4/27/160		9,0	33,0	25,0	19,8	16,5	12,4	9,9	8,2
630	20	6,0	80	4/22/120	4/27/160		9,0	33,0	25,0	19,8	16,5	12,4	9,9	8,2
660	20	6,0	80	8/22/142	4/22/120	4/27/160	12,0	34,5	26,0	20,7	17,3	13,0	10,4	8,6
710	24	6,2	80	4/22/120	4/27/160		14,0	31,0	23,2	18,6	15,5	11,6	9,3	7,7
760	24	6,3	80	4/22/120	4/27/160		16,0	33,1	24,9	19,8	16,6	12,4	9,9	8,3
810	24	6,8	80	4/22/120	4/27/160		20,0	35,3	26,5	21,2	17,7	13,2	10,6	8,8
860	24	6,5	80	4/22/120	4/27/160		21,0	37,5	28,1	22,5	18,8	14,1	11,3	9,4
910	30	7,0	80	4/22/120	4/27/160		26,0	31,8	23,8	19,0	15,8	11,9	9,5	7,9
910	30	7,0	100	8/27/186			26,0	31,8	23,8	19,0	15,8	11,9	9,5	7,9
960	30	7,0	80	4/22/120	4/27/160		29,0	33,5	25,1	20,1	16,7	12,6	10,0	8,4
1010	30	8,0	100	4/30/200	4/30/250		38,0	29,4	22,0	17,6	14,7	11,0	8,8	7,3
1110	30	8,0	100	4/30/200	4/30/250		48,0	32,2	24,2	19,4	16,1	12,1	9,7	8,1
1250	36	9,0	100	4/30/200	4/30/250		68,0	36,3	27,2	21,8	18,1	13,6	10,9	9,1
1310	36	9,0	100	4/30/200	4/30/250		75,0	38,0	28,6	22,8	19,0	14,3	11,4	9,5
1320	36	9,0	100	4/30/200	4/30/250		77,0	38,4	28,8	23,0	19,2	14,4	11,5	9,6
1410	36	9,0	100	4/30/200	4/30/250		87,0	41,0	30,7	24,6	20,5	15,4	12,3	10,2
1430	36	9,5	100	4/30/200	4/30/250		93,0	41,6	31,2	24,9	20,8	15,6	12,5	10,4
1510	36	36	100	4/30/200	4/30/250		116,0	43,9	32,9	26,3	22,0	16,5	31,2	10,9
1610	40	40	100	4/33/250	4/33/315		130,0	42,1	31,6	28,1	23,4	17,6	14,4	11,7

Other borehole/pinhole combinations available on request



Solutions to cutting problems

Blade breakage

Sudden failure of saw blades, due to breakage of teeth (carbide) or breakage of the saw blade itself (HSS) is generally caused by:

- Too many teeth on the saw blade for the application
- Excessive feed rate
- Material movement caused by clamping problems
- Incorrect choice of cutting parameters for the application
- Incorrect saw blade rotation (reversed)
- Material advancement when the saw blade is in the down position

Increase blade life

A common line of thought is that using higher cutting parameters is synonymous with a reduction in blade life. This is not always the case. Depending on the machine capabilities, we often experience that carbide tipped saw blades are not pushed hard enough to become fully effective. Our vast experience with many different sawing machines and applications allows us to get the maximum out of Kinkelder saw blades on different machines.

Simplify stock management

- One blade cuts all

By carefully analyzing your cut-off requirements, Kinkelder can reduce the number of different saw blades used. At the same time we can often improve blade life and reduce cut time by fine tuning cutting parameters. The reduction in variation of saw blades will make stock management easier and will reduce the amount of money tied up in blade inventory. Supply us your list of cut-off applications along with available machinery and required output/line speed and we will make a preliminary assessment of what we can do for your operation.

Tooth breakage

When small particles break away from the cutting edge (mostly occurring on carbide tipped saw blades), this is usually caused by:

- Chips sticking to the tooth face
- Excess pressure on the cutting edge will cause chipping. Use or add a wire brush, cold air gun or a better cutting fluid, for example KinkOil Ecotec.
- Increase tooth pitch. More room between the teeth will reduce chances of chips getting stuck between the teeth.
- Unstable, thin walled product. Vibration of the product during the cutting operation can cause tooth breakage. Improve the clamping system or change cutting parameters to reduce this vibration. Alternatively, change to another tooth geometry.

Improve cut quality

Inside (ID) burr

1. Dull saw blade
2. Wrong geometry or poor regrind
3. Wrong Tooth pitch
4. Saw blade vibration problem – machine condition, instable saw blade

Outside (OD) burr

1. Feed rate too low (pigtail). Before increasing it, check the fill ratio
2. Dull saw blade
3. Wrong geometry or poor regrind
4. Cutting speed too high

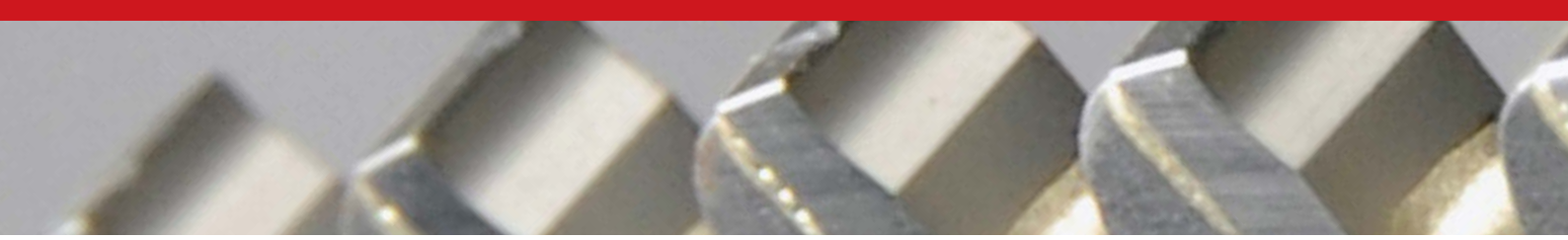
Improve surface quality

1. Scratched surface – Some tooth damaged – replace saw blade
2. Rough surface (HM)
   2a. Vibration – wrong parameters (change cutting speed and / or feed rate), wrong blade choice – change blade type or geometry
   2b. Wave – increase feed rate
   Rough wave – increase cutting speed

Increase line speed at flying cut-off applications

When the cut off time is limiting the speed of your tube line, Kinkelder has several types of saw blades and services available.

- SpeedMaster carbide tipped saw blades for extremely high cutting speeds and feed rates (for single blade and Twin blade machinery)
- Tubemaster carbide tipped saw blades for orbital cutting
- Scarfmaster carbide tipped saw blades for cutting ID-scarfed tubes
- HSS saw blades with a coating dedicated for high speed cutting
- HSS saw blades with an optimized tooth geometry to allow very high feed rates
- HSS saw blades with fully coated teeth + recoating services for up to 40% reduction of cut time

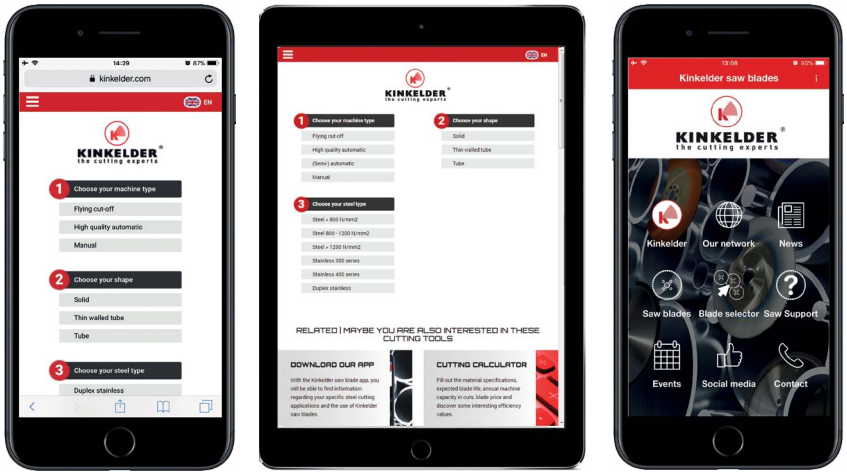


Product Application Matrixes

The following matrixes will offer you a helpful tool in finding the most suitable saw blade for your specific cutting application. In addition to these matrixes, you can consult the available tools on our website and saw blades app.

Blade selector www.kinkelder.com
Simply follow three easy steps and see which Kinkelder saw blade is recommended for your specific (stainless) steel cutting application.

Kinkelder saw blades app
With the Kinkelder saw blades app, you will be able to find all (technical) information regarding your specific steel cutting applications and the use of Kinkelder saw blades.

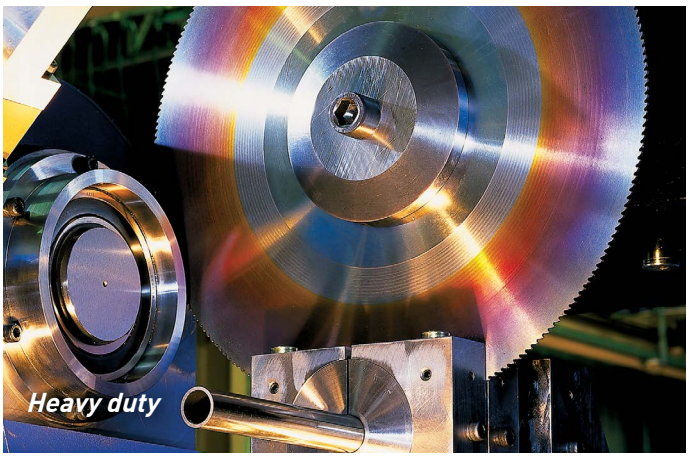


Manual/ semi-automatic

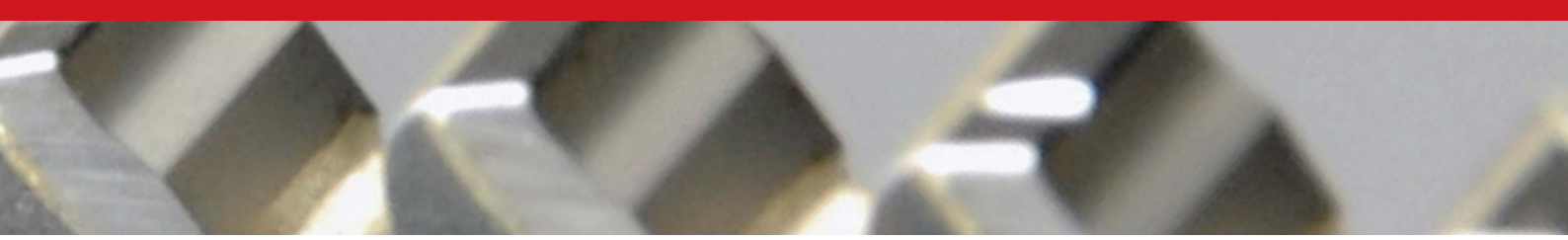


Automatic









TUBE

1 Highest blade life
2 High blade life
3 Medium blade life
4 Working alternative

	Manual								High quality automatic								Flying cut-off							
	Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 650 - 800 N/mm²	Steel 800 - 1200 N/mm²	Steel > 1200 N/mm²	Stainless steel 300 series	Stainless steel 400 series	Duplex stainless steel	Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 650 - 800 N/mm²	Steel 800 - 1200 N/mm²	Steel > 1200 N/mm²	Stainless steel 300 series	Stainless steel 400 series	Duplex stainless steel	Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 800 - 1200 N/mm²	Stainless 300 series	Stainless steel 400 series	ID Scarf Steel 800 - 1200 N/mm²	Orbital Steel	Orbital Stainless 300 series
HSS SAW BLADES																								
Alpha	3	4				4	3																	
Solar	2	3				3	2		4	4				4	4		4	4		4	4			
Fernox	1	2				2	1		4	4				3	4		3	3		3	3			
Fusion 2.0		1							2	2					2		1	1			1			
Fusion NX						1			3	3				2	3		2	2		1	2			
Power 2.0																								
Power NX																								
X-treme 2.0									1	1					1									
X-treme NX									3	3				1	3									
TCT SAW BLADES																								
Champion TL											1	2												
Champion TL Multi												1												
Champion SL																								
Champion TH												1	1											
CX 1-M																								
CX 1-H																								
CX 3											2	2												
CX 4														1	1	1								
CX 5												2	2											
CX 6-S																								
CX 6-L																								
CX 7																								
SpeedMaster																		2	1					
ScarfMaster																						1		
TubeMaster																							1	
TubeMaster stainless																								1



THIN WALLED TUBE

1 Highest blade life
2 High blade life
3 Medium blade life
4 Working alternative

		Manual								High quality automatic								Flying cut-off							
		Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 650 - 800 N/mm²	Steel 800 - 1200 N/mm²	Steel > 1200 N/mm²	Stainless steel 300 series	Stainless steel 400 series	Duplex stainless steel	Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 650 - 800 N/mm²	Steel 800 - 1200 N/mm²	Steel > 1200 N/mm²	Stainless steel 300 series	Stainless steel 400 series	Duplex stainless steel	Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 800 - 1200 N/mm²	ID Scarf Steel 800 - 1200 N/mm²	Orbital Steel 800 - 1200 N/mm²	Stainless 300 series	Orbital Stainless 300 series	Stainless steel 400 series
HSS SAW BLADES																									
ALPHA	Alpha	4																							
SOLAR	Solar	3	4				4	4		4	4				4	4		4	4				4		4
FERNOX	Fernox	2	3				3	3		4	4				3	4		3	3				3		4
FUSION 2.0	Fusion 2.0		2							3	2					2		1	1				2		3
FUSION NX	Fusion NX						2	2		4	3				3	3		2	2				1		4
POWER 2.0	Power 2.0	1	1					2		1	1					1		1	1						1
POWER NX	Power NX						1	1		2	2				1	2		2	2				1		2
X-TREME 2.0	X-treme 2.0									1	1					1									
X-TREME NX	X-treme NX									2	3				1	3									
TCT SAW BLADES																									
Champion TL	Champion TL											2	2												
Champion TL Multi	Champion TL Multi																								
Champion SL	Champion SL																								
Champion TH	Champion TH												2	2											
CX SERIES 1 M	CX 1-M																								
CX SERIES 1 H	CX 1-H																								
CX SERIES 3	CX 3											2													
CX SERIES 4	CX 4														1	1	1								
CX SERIES 5	CX 5											1	1	1			2			2*					
CX SERIES 6 S	CX 6-S																								
CX SERIES 6 L	CX 6-L																								
CX SERIES 7	CX 7																								
SPEEDMASTER	SpeedMaster																								
SCARFMASTER	ScarfMaster																								
TUBEMASTER	TubeMaster																								
STAINLESS TUBEMASTER	TubeMaster stainless																								

* Specifically suitable for cutting DP, CP, HSLA and TRIP material at flying cut-off applications

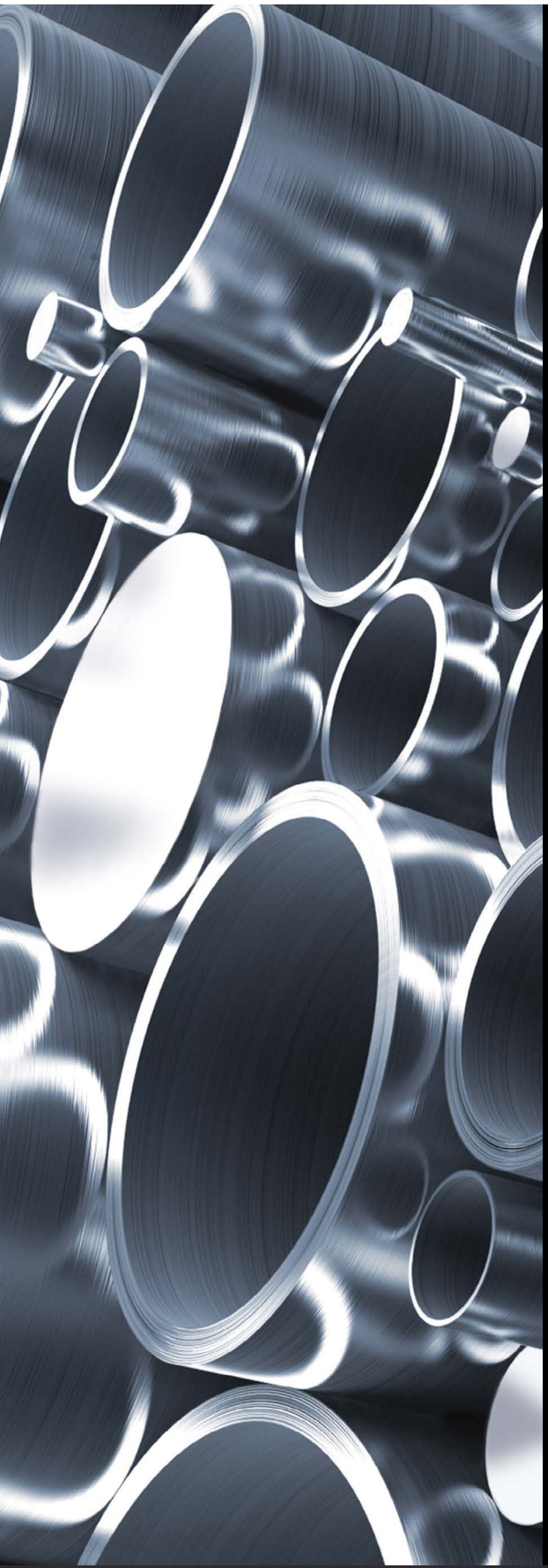


SOLIDS

1 Highest blade life
2 High blade life
3 Medium blade life
4 Working alternative

		Manual								High quality automatic							
		Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 650 - 800 N/mm²	Steel 800 - 1200 N/mm²	Steel > 1200 N/mm²	Stainless steel 300 series	Stainless steel 400 series	Duplex stainless steel	Steel < 400 N/mm²	Steel 400 - 650 N/mm²	Steel 650 - 800 N/mm²	Steel 800 - 1200 N/mm²	Steel > 1200 N/mm²	Stainless steel 300 series	Stainless steel 400 series	Duplex stainless steel
HSS SAW BLADES																	
ALPHA	Alpha	4	4				4	4									
SOLAR	Solar	3	3				3	3									
FERNOX	Fernox	2	2				2	2									
FUSION 2.0	Fusion 2.0	1	1				1	1									
FUSION NX	Fusion NX																
POWER 2.0	Power 2.0																
POWER NX	Power NX																
X-TREME 2.0	X-treme 2.0																
X-TREME NX	X-treme NX																
TCT SAW BLADES																	
Champion TL	Champion TL																
Champion TL MULTI	Champion TL Multi																
Champion SL	Champion SL										1	1					
Champion TH	Champion TH																
CX SERIES 1 M	CX 1-M										1	1			3		
CX SERIES 1 H	CX 1-H										4	4	1	1	4		
CX SERIES 3	CX 3																
CX SERIES 4	CX 4																
CX SERIES 5	CX 5																
CX SERIES 6 S	CX 6-S														2	1	1
CX SERIES 6 L	CX 6-L														1	1	1
CX SERIES 7	CX 7										2	2					
SPEEDMASTER	SpeedMaster																
SCARFMASTER	ScarfMaster																
TUBEMASTER	TubeMaster																
STAINLESS TUBEMASTER	TubeMaster stainless																

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