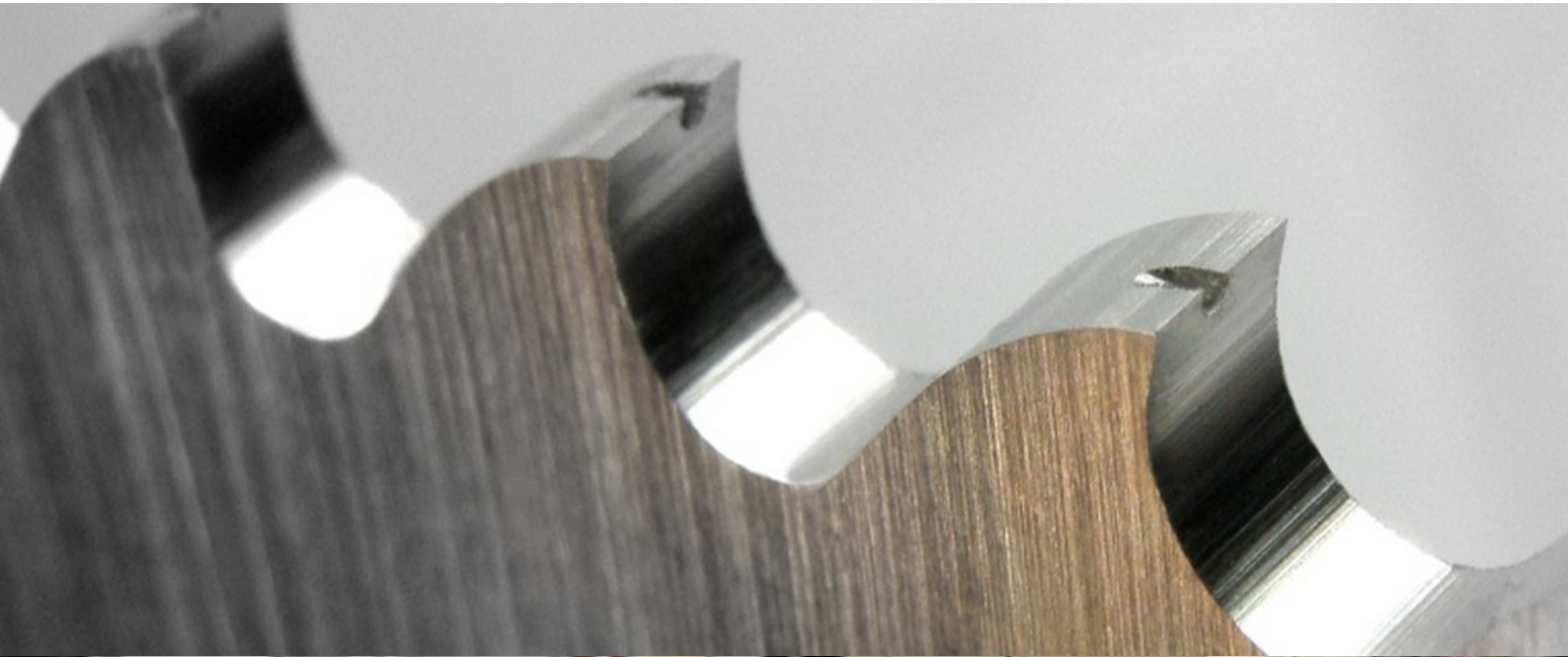




KINKELDER®

KINKELDER STANDARD PRODUCTS



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Contents

• HSS saw blades	4
• Standard range of HSS saw blades	5
• Geometry	7
• Segmental saw blades	8
• Standard range segmental circular saw blades	9
• Tungsten carbide tipped circular saw blades for wood and plastics	10
• Tungsten carbide tipped circular saw blades for ferrous	14
• Tungsten carbide tipped circular saw blades for non-ferrous	15
• Friction saw blades	16
• Circular knives	17
• Band saw blades	18
• Carbon band saw blades	19
• Bimetal band saw blades	20
• Tooth pitch determination for band saw blades	21
• Application matrix HSS saw blades	22
• Formulae for calculations	23

Customer values



Kinkelder Circular Saw product includes a vast range of tooth pitches, precision, thicknesses and setting styles in both regular and variable pitch form. Kinkelder allows customers to have it tailored to fit the needs and machine application.

Built to last



Since 1960, Kinkelder manufactures and pioneer of circular saw blade technology in Netherlands. Kinkelder provides cutting solution through R&D, consultancy and after sales for your long lasting productivity and profitability.



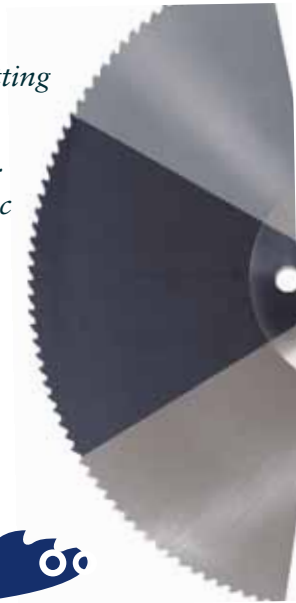
HSS

HSS saw blades

A bright saw blade does not have any surface treatment. It is ideal for cutting non-ferrous metals such as brass, aluminium and so on.

A steam treated saw blade has a Ferric Oxide surface coating for a longer blade life. It is mainly used for cutting steel on manual and semi-automatic sawing machines.

A flash chrome coated blade has a thin layer of chrome, produced in an electrolytic process. It protects the blade against corrosion and pick-up, and is generally used for cutting brass and copper.



Economy 3000



A high performance saw blade at an economic price

Product concept

Economy 3000 is a very cost effective saw blade with a sophisticated coating for wear protection. A special coating procedure has been developed in order to create a coating with a very low friction coefficient at an attractive price level.

Product advantages

Ideal for cutting tubes and profiles, Economy 3000 cuts much faster than a steam treated blade. Higher cutting speeds can be achieved as the coating protects the saw blade against side welding.

Application

Economy 3000 can be used on manual, semi automatic and automatic sawing machines. It's ideal for cutting thin wall tubes, in mild and stainless steel.

3000

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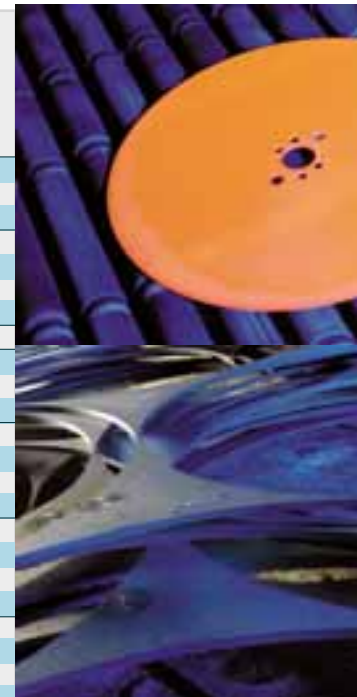


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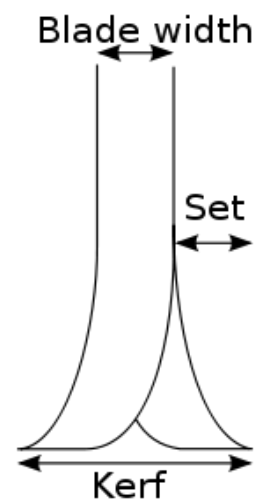
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Standard range of HSS saw blades

Diameter mm	Kerf mm	Borehole mm	Hub mm	Max. side run out (mm)		
				Steam treated, bright finished	TiN, TiAlN, TiCN, CrN, Econ. 3000 Flash Chrome	Weight kg
175	1,2					0,30
	1,6	32	70	0,20	0,15	0,30
	2,0					0,40
200	1,2					0,30
	1,6	32	90	0,20	0,15	0,40
	1,8					0,40
210	2,0	32	90	0,20	0,15	0,50
	2,0					0,50
	2,0					0,50
225	1,2					0,40
	1,6	32/40	90	0,20	0,15	0,50
	2,0					0,60
250	1,6					0,60
	2,0	32/40	90	0,25	0,20	0,70
	2,5					0,90
	3,0					1,10
275	1,6					0,70
	2,0	32/40	100	0,25	0,20	0,80
	2,5					1,10
	3,0					1,30
300	1,6					0,80
	2,0	32/38/40	100	0,25	0,20	1,00
	2,5					1,30
	3,0					1,60
315	2,0					1,10
	2,5	32/40	100	0,30	0,25	1,40
	3,0					1,70
325	2,0					1,20
	2,5	32/40	100	0,30	0,25	1,50
	3,0					1,80
350	2,0					1,50
	2,5	32/40/50	120	0,30	0,25	1,80
	3,0					2,00
	3,5					2,30
370	2,5					2,00
	3,0	40/50	120	0,30	0,25	2,50
	3,5					3,00
400	2,5					2,50
	3,0	40/50	120	0,30	0,25	3,00
	3,5					3,50
	4,0					4,00
425	3,0					3,00
	3,5	32/40/50	120	0,35	0,30	3,50
	4,0					4,00
450	3,0					3,50
	3,5	40/50	130	0,35	0,30	4,00
	4,0					4,50
500	3,0					4,00
	3,5	40/50	140	0,40	0,35	5,00
	4,0					5,50
525	5,0					6,90
	3,5	50	140	0,40	0,35	5,50
	4,0					5,70
550/560	3,0					5,00
	4,0	50/80	140/190	0,40	0,35	6,50
	5,0					7,90
570/580	4,0					6,80
	5,0	50/80	140/190	0,40	0,35	8,20
600	4,0					7,00
	5,0	50/80	190	0,40	0,35	8,40
630	4,0					7,50
	5,0	50/80	180/220	0,40	0,35	8,60



Our product range also includes saw blades with non-standard dimensions, such as diameter, thickness, bore, pinholes, tooth pitch and tooth form.



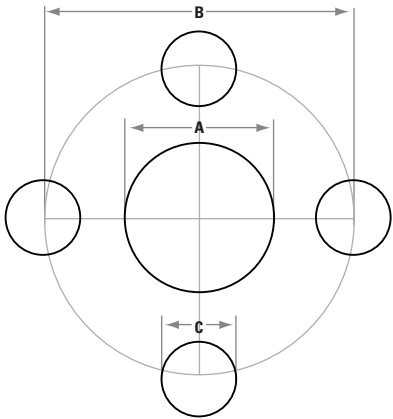


Standard range HSS sizes

Diameter mm	Number of teeth and tooth pitches (T in mm)													
	T 3	T 4	T 5	T 6	T 7	T 8	T 9	T 10	T 11	T 12	T 14	T 16	T 18	
175	180	140	110	90		64								
200	200	160	128	100		72								
210	210	160	130	110		84								
225	220	180	150	120		90	80							
250	240	200	160	128	110	100		80		64				
275	280	220	180	144	120	110	96	84	78	72				
300	320	240	200	160	140	120	110	100	90	80				
315	320	250	200	160	140	120	110	100	90	80	72			
325	320	250	200	170	150	130	110	100		90				
350	350	280	220	180	160	140	120	110		90	80			
370		300	220	190	160	140	120	110	100	90	80	70		
400		320	250	200	180	160	140	128		100	90	80	70	
425		350	260	220	180	160	140	130	120	110	100	80	70	
450			280	240			180		140		120	100	90	80
500			310	260		200		160		130	110	100	90	
525			330	270		210		164		140	120	104	90	
550			340	280		220		170		140	120	110	100	
570			360	300		220		180		150	130	110	100	
600			380	320		240		190		160	130	120	100	
630			380	320		240		190		160	130	120	100	

Bore and Pinhole combinations

Bore ϕ (mm)	Pinhole combinations (mm)
32	2/8,5/45 2/11/63
	2/8,5/45 2/9/50 2/12/64
	2/8,5/45 4/9/50 2/12/64
40	2/8,5/55 4/12/64
	2/15/80 4/12/64
	2/15/80 2/15/100 4/12/64
50	4/15/80
	4/18/100
	4/15/85
80	4/23/120



A Bore
B PCD
C Pinholes

Steel grades

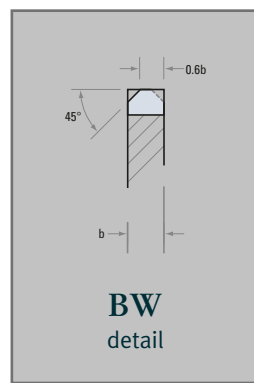
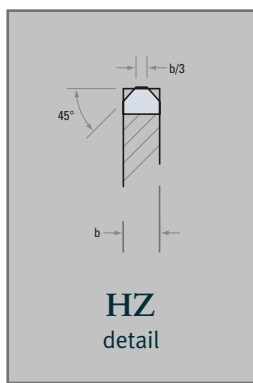
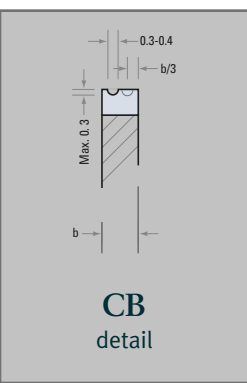
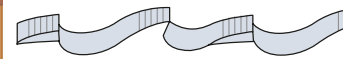
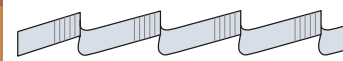
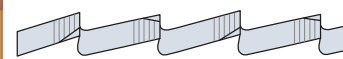
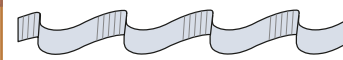
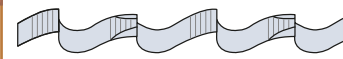
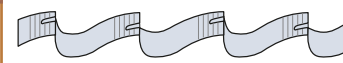
Steel specification	Hardness		Alloys					
	HRC ± 1	C	W	V	Mo	Cr	Co	
HS 6-5-2 M 2 DIN 1.3343	64	0,90%	6,3%	1,75%	5,0%	4,1%	-	
HS 6-5-2-5 M 35 DIN 1.3243	66	0,95%	6,3%	1,75%	5,0%	4,1%	5,0%	



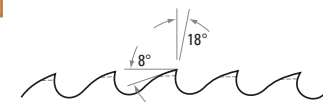
TOOTH SHAPE

Geometry Codes

CB	Chipbreaker tooth form is most effective for tube and profile cutting, particularly with PVD coated blades. It minimises burr formation even at high cutting rates.
HZ	The HZ tooth form is most suitable for solids and thick-wall tube cutting. The roughing tooth is bevelled on both sides, and is between 0.2 and 0.3 mm higher than the square finishing tooth.
BW	With BW geometry, the teeth are alternately bevelled. It is most suitable for cutting light gauge steel tube and sections on manual and semi automatic machines.
B	For very thin wall tubes, it is not necessary to break the chips, so the B geometry is suitable for such applications.
AW	AW geometry has been designed for machining work, such as slotting, with thin saw blades.
A	A geometry has been designed for machining work, such as milling, with thin saw blades.
VT	Variable pitch tooth forms can be used in combination with all geometries. It is particularly effective for reducing vibration on interrupted cutting.



Cutting/clearance angle: 18° / 8°



SEGMENTAL

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.

We produce segmental circular saw blades in diameters from 250 mm to 1610 mm. For our standard range see the table on the following page.

Standard specifications

Material	M2 = DIN 1.3343 M 35 = DIN 1.3243 (5% Cobalt)
Tooth forms	CB, HZ, BW
Cutting clearance angle	18° / 8°
Hardness	63 - 65 HRC

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

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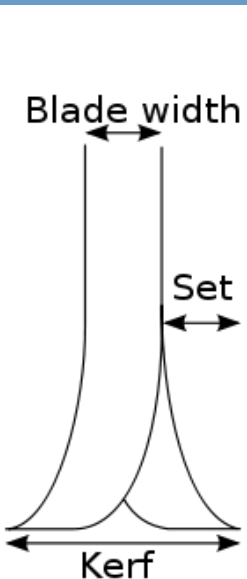




KINKELDER®

Standard range segmental circular saw blades

Diameter mm	No. of segm.	Thick- ness 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
250	12	3,0	32	2/8,5/45	4/9/50	2/12/64	1,0	21,8	16,4	13,1	10,9	8,2	6,5	5,5
275	12	3,0	32	2/8,5/45	4/9/50	2/12/64	1,0	24,0	18,0	14,4	12,0	9,0	7,2	6,0
				2/8,5/55	4/12/64	24,0		18,0	14,4	12,0	9,0	7,2	6,0	
300	14	3,6	40	2/8,5/55	4/12/64		1,5	22,3	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	11,7	8,8	7,1	5,9
				2/8,5/55	4/12/64	23,5		17,7	14,1	11,7	8,8	7,1	5,9	
360	16	3,6	40	2/8,5/55	4/12/64		2,0	23,6	17,7	14,1	11,8	8,8	7,1	5,9
				4/15/80	4/15/85	23,6		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	9,1	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
				4/15/80	4/15/85	26,2		19,6	15,7	13,1	9,8	7,9	6,5	
				4/16/90	4/23/96	26,2		19,6	15,7	13,1	9,8	7,9	6,5	
	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	12,4	9,3	7,4	6,2
				4/15/80	4/15/85	24,7		18,5	14,8	12,4	9,3	7,4	6,2	
450	18	4,0	50	4/15/80	4/18/100		4,0	26,2	19,6	15,7	13,0	9,8	7,9	6,5
460	18	5,0	40	4/12/64	2/15/80	2/15/100	4,5	26,7	20,0	16,0	13,4	10,0	8,0	6,7
				4/15/80	4/15/85	26,7		20,0	16,0	13,4	10,0	8,0	6,7	
				4/18/100		26,7		20,0	16,0	13,4	10,0	8,0	6,7	
				4/16/90	4/23/96	26,7		20,0	16,0	13,4	10,0	8,0	6,7	
510	18	5,7	50	4/18/100			6,5	29,7	22,2	17,8	14,8	11,1	8,9	7,4
				4/15/80	4/18/100	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	16,2	12,2	9,7	8,1
630	20	5,0	80	4/22/120	4/27/160		9,0	32,9	24,7	19,8	16,5	12,4	9,9	8,2
				4/22/120	4/27/160	32,9		24,7	19,8	16,5	12,4	9,9	8,2	
660	20	6,0	80	8/22/142			12,0	34,5	25,9	20,7	17,3	13,0	10,4	8,6
				4/22/120	4/27/160	34,5		25,9	20,7	17,3	13,0	10,4	8,6	
710	24	6,2	80	4/22/120	4/27/160		14,0	30,9	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	19,9	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	17,6	13,2	10,6	8,8
				4/30/200	4/30/250	20,0		35,3	26,5	21,2	17,6	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	31,7	23,8	19,0	15,9	11,9	9,5	7,9
				8/27/186		31,7		23,8	19,0	15,9	11,9	9,5	7,9	
				4/30/200	4/30/250	31,7		23,8	19,0	15,9	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	8,4
1010	30	8,0	100	4/30/200	4/30/250		38,0	35,2	26,4	21,1	17,6	13,2	10,6	8,8
1110	36	8,0	100	4/30/200	4/30/250		45,0	32,3	24,2	19,4	16,1	12,1	9,7	8,8
1120	36	8,2	100	4/30/200	4/30/250		48,0	32,6	24,4	19,5	16,3	12,2	9,8	8,1
1250	36	9,0	100	4/30/200	4/30/250		68,0	36,3	27,3	21,8	18,2	13,6	10,9	9,5
1310	36	9,0	100	4/30/200	4/30/250		75,0	38,1	28,6	22,9	19,0	14,3	11,4	9,5
1320	36	9,0	100	4/30/200	4/30/250		77,0	38,1	28,6	22,9	19,0	14,3	11,4	9,5
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	4/30/250			93,0	41,0	30,7	24,6	20,5	15,4	12,3	10,2
1510	36	9,0	100	4/30/250			116,0	43,9	32,9	26,3	22,0	16,5	13,2	11,0
1610	40	11,0	100	4/33/225	4/33/315		130,0	42,1	31,6	25,3	21,1	15,8	12,6	10,5





TCT

Tungsten carbide tipped circular saw blades for wood and plastics

TCT circular saw blades with chip limiters

No kick-back

Type LFZ1

Straight tooth form

Mainly for cutting hard and soft wood with the grain. Can be used for cutting off thick wood and rough timber such as scaffolding planks.

Type LFZ2

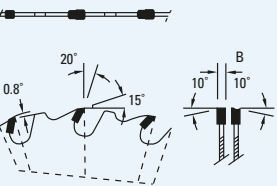
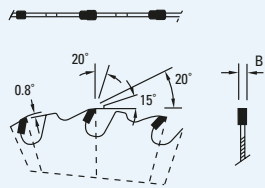
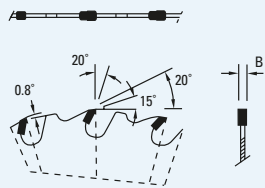
Straight tooth form

For cutting with the grain and cross cutting in hard and soft wood. Suitable for cutting off rough timber such as scaffolding planks.

Type LWZ3

Alternate bevel tooth form

For cutting with the grain and cross cutting in all natural woods. For panel sizing in blockboard, plywood, veneer or plastic faced materials. Does not make high demands on the surface of the cut.



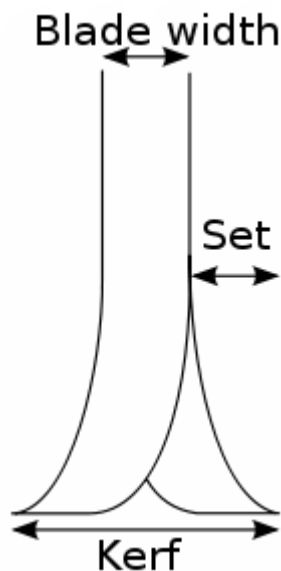
Tooth forms

- F** Straight tooth
- W** Alternate bevel tooth
- TF** Triple chip-flat tooth
- NEN** Negative triple chip-flat tooth
- NEP** Positive triple chip-flat tooth
- DH** Roof-straight-hollow tooth

Other tooth forms can be supplied on request

Explanation of abbreviations used

- D** Diameter saw blade
- B** Cutting width
- d** Diameter boreholes
- Z** Number of teeth



	D	B	d	Z
	250	3,2	30	12
	300	3,4	30	14
	350	3,7	30	16
	400	3,7	30	18
	450	4,0	30	20
	500	4,2	30	22

	D	B	d	Z
	200	3,0	30	14
	250	3,2	30	18
	300	3,4	30	20
	350	3,7	30	24
	400	3,7	30	28
	450	4,0	30	32
	500	4,2	30	32

	D	B	d	Z
	250	3,2	30	24
	300	3,4	30	28
	350	3,7	30	32
	400	3,7	30	36
	450	4,0	30	40
	500	4,2	30	44



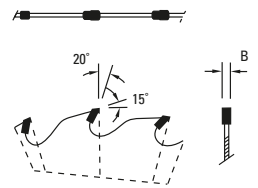
TCT circular saw blades without chip limiters

Type LF

Straight tooth form

For dry hard and soft wood. Deep gullets for large chip volumes. Most suitable for ripping thick timber. Also suitable for grooving.

D	B	d	Z
200	3,0	30	14
250	3,2	30	18
300	3,4	30	24
350	3,7	30	24
400	3,7	25	28
400	3,7	30	28
450	4,0	30	32
500	4,2	30	36
600	4,4	30	48
700	4,4	30	60



Type LW

Alternate bevel tooth form

The same application as LF. Also suitable for rough sawing. Not suitable for grooving.

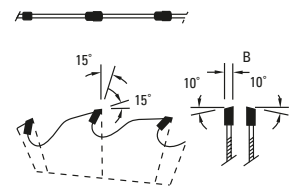
D	B	d	Z
400	3,7	30	32

Type QW

Alternate bevel tooth form

Mainly for cross cutting. Also suitable for veneered materials cutting with the grain as well as for soft-grained boards, gypsum sheets and linoleum.

D	B	d	Z
150	3,0	30	18
180	3,0	30	24
200	3,0	30	24
250	3,2	30	30
300	3,2	30	36
335	3,2	30	36
350	3,2	30	42
400	3,5	30	48
450	3,8	30	54
500	4,0	30	60

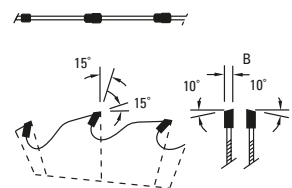


Type UW

Alternate bevel tooth form

For board materials veneered or plastic coated on one side. For coated or surface-treated boards, insulation boards, hard plastic, hard paper and ripping softwood packs.

D	B	d	Z
150	3,0	30	24
180	3,0	30	30
200	3,0	30	34
250	3,2	30	40
300	3,2	30	48
350	3,2	30	54
400	3,5	30	60
450	3,8	30	66
500	4,0	30	72





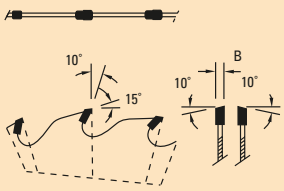
TCT

Tungsten carbide tipped circular saw blades for wood and plastics

Type GW

Alternate bevel tooth form

For the same materials as type UW, but with higher quality cut finish.

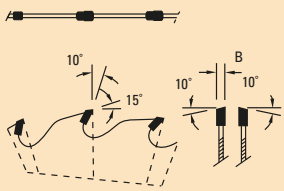


D	B	d	Z
180	3,0	30	36
200	3,0	30	42
250	3,2	30	48
300	3,2	30	60
350	3,2	30	72
400	3,5	30	84

Type KW

Alternate bevel tooth form

For good cut finish on veneered board materials coated with plastic on one side or surface-treated. Saw cut thickness up to 50 mm.

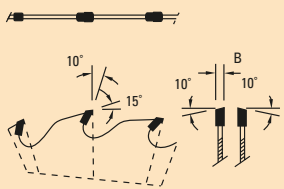


D	B	d	Z
150	3,0	30	36
180	3,0	30	42
200	3,0	30	48
250	3,2	30	60
300	3,2	30	72
350	3,2	30	84
400	3,5	30	96

Type VW

Alternate bevel tooth form

Same applications as type KW, but with even higher quality cut finish. Saw cut thickness up to 25 mm. For hard paper and plastics up to 10 mm thick.



D	B	d	Z
150	3,0	30	48
180	3,0	30	58
200	3,0	30	64
250	3,2	30	80
300	3,2	30	96
350	3,2	30	108
400	3,5	30	120
450	3,8	30	132



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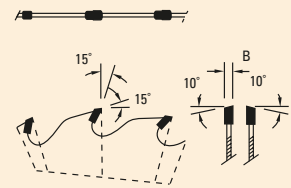
Type UWD

Alternate bevel tooth form

Thin saw blades, resulting in less material wastage. For high quality timber and expensive plastics. Also suitable for cutting off polypropylene. Saw cut thickness up to 30 mm.

The flange diameter should be at least 1/3 of the saw blade diameter.

D	B	d	Z
200	2,2	30	34
250	2,4	30	40
300	2,4	30	48
350	2,4	30	54



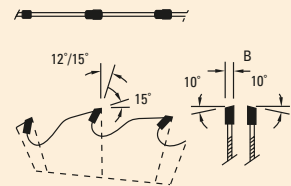
Type VWD

Alternate bevel tooth form

Thin saw blades, resulting in less material wastage. For plastic boards up to 8 mm cut height, acrylic plastics and Tufnol/Pertinax insulation.

The flange diameter should be at least 1/3 of the saw blade diameter.

D	B	d	Z
150	2,2	30	48
180	2,2	30	58
200	2,2	30	64
250	2,4	30	80
300	2,4	30	96

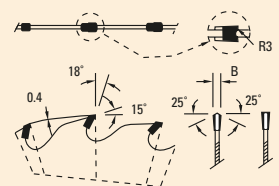


Type DH

Roof-straight-hollow ground tooth form

With hollow ground face angle. For veneered and plastic coated furniture boards.

D	B	d	Z
220	3,0	30	42
250	3,0	30	48
300	3,2	30	60



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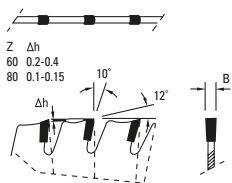
TCT Tungsten carbide tipped circular saw blades for ferrous

		Number of teeth										
		30	40	50	54	60	70	80	90	100	110	120
D	B	Tooth pitch										
400	4,0	41,9	31,4	25,1	23,3	20,9	18,0	15,7	14,0	12,5		
425	4,5	44,5	33,4	26,7	24,7	22,3	19,1	16,7	14,8	13,4	12,1	
500	5,0		39,3	31,4	29,1	26,2	22,4	19,6	17,5	15,7	14,3	13,1
610	6,5		47,9	38,3	35,5	31,9	27,4	24,0	21,3	19,2	17,4	16,0
630	6,5		49,5	39,6	36,7	33,0	28,3	24,7	22,0	19,8	18,0	16,5
660	6,5		51,8	41,5	38,4	34,6	29,6	25,9	23,0	20,7	18,8	17,3
710	6,5		55,8	44,6	41,3	37,2	31,9	27,9	24,8	22,3	20,3	18,6
760	7,0		59,7	47,8	44,2	39,8	34,1	29,8	26,5	23,9	21,7	19,9
810	7,0		63,6	50,9	47,1	42,4	36,4	31,8	28,3	25,4	23,1	21,2
860	7,0		67,5	54,0	50,0	45,1	38,6	33,8	30,0	27,0	24,6	22,5
910	8,0		71,5	57,2	52,9	47,6	40,8	35,7	31,8	28,6	26,0	23,8
960	8,0		75,4	60,3	55,9	50,3	43,1	37,7	33,5	30,2	27,4	25,1
1020	8,5		80,1	69,1	59,3	53,4	45,8	40,0	35,6	32,0	29,1	26,7
1120	8,5		88,0	70,4	65,2	58,6	50,3	44,0	39,1	35,2	32,0	29,3
1250	10,0			78,5	72,7	65,4	56,1	49,1	43,6	39,3	35,7	32,7

Larger sizes can also be supplied

Tungsten carbide tipped circular saw blades

Multipurpose



Type MF

Tungsten carbide tipped circular saw blades, multipurpose

For cutting steel, aluminium sections and pipes, thin-walled sections with insulation and steel/chipboard panels. Also suitable for repairing broken pallets.

D	B	d	Z
304	2,25	25,4	60
			80
304	2,25	30,0	80
355	2,50	25,4	80

Explanation of abbreviations used

- D** saw blade diameter
- B** cutting width
- d** bore diameter
- Z** number of teeth





TCT Tungsten carbide tipped circular saw blades for non-ferrous

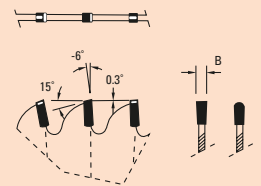
Type NEN negative rake

Negative triple chip-flat tooth form, noise reduced

Particularly suitable for thin walled sections of aluminium and plastic.

Larger sizes can also be supplied

D	B	d	Z
200	2,8	30	48
			64
220	3,0	30	64
250	3,2	30	48
			60
			80
275	3,2	30	68
			88
300	3,2	30	60
			72
			96
350	3,2	30	72
			84
			108
370	3,8	50	96
400	3,8	30	72
			96
			108
420	3,8	30	96
450	4,0	30	80
			108
500	4,4	30	80
			100/120



Tooth forms

- F** Straight tooth
- W** Alternate bevel tooth
- TF** Triple chip-flat tooth
- NEN** Negative triple chip-flat tooth
- NEP** Positive triple chip-flat tooth
- DH** Roof-straight-hollow tooth

Other tooth forms can be supplied on request

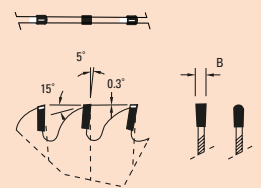
Type NEP positive rake

Positive triple chip-flat tooth form, noise reduced

Particularly suitable for cutting non-ferrous materials (such as aluminium and copper) in the form of thick walled sections and tubes as well as solid materials. Also suitable for cutting various types of plastics (including impact resistant plastics such as lexane, PVC, rod and sheet material). For metal cutting the use of a coolant improves the service life of the saw blade and gives an even better cut quality.

Larger sizes can also be supplied

D	B	d	Z
200	2,8	30	48
			64
220	3,0	30	64
250	3,2	30	48
			60
			80
300	3,2	30	60
			72
			96
350	3,2	30	72
			84
			108
400	3,8	30	72
			96
420	3,8	30	96
450	4,0	30	60
			80/108
500	4,4	30	60
			80
			100/120



Explanation of abbreviations used

- D** Diameter saw blade
- B** Cutting width
- d** Diameter boreholes
- Z** Number of teeth

Friction saw blades

Product

Kinkelder friction saw blades are available in Chrome Vanadium Steel to DIN 1.2235 or Tungsten Manganese steel DIN 1.2604.

The tooth styles and cutting angles are determined by the machine type and specification and hardness condition of the material to be sawn (blade life can be further increased by applying a chrome coating).

Our standard range covers diameters of 200 mm to 1200 mm. Larger diameters are available to special order.

Application

- The ideal peripheral speed range is 100 - 140 m/sec.
- Feed rates can vary from 80 - 2000 mm/min dependant on sawing conditions
- Friction saw blades are used for sawing steel tubes and profiles at temperatures below 250° C



CIRCULAR KNIVES

Circular knives

Product

Kinkelder supplies various types and sizes of circular knives to suit customers' applications.

Our circular knives are heat treated to a hardness of 58 - 60 or 63 - 65 HRC, with bright finish as standard. In addition to standard knife edge, various tooth forms are available for specific applications.

Circular knives are available within a diameter range of 100 mm - 600 mm.

Application

- Our circular knives are used for a wide range of applications including, cutting thin walled tubes, rubber, leather, paper, board, isolation and synthetic materials
- The peripheral speed (V) must be at a maximum 30 m/sec.
See page 23 of this brochure for the calculation of the peripheral speed



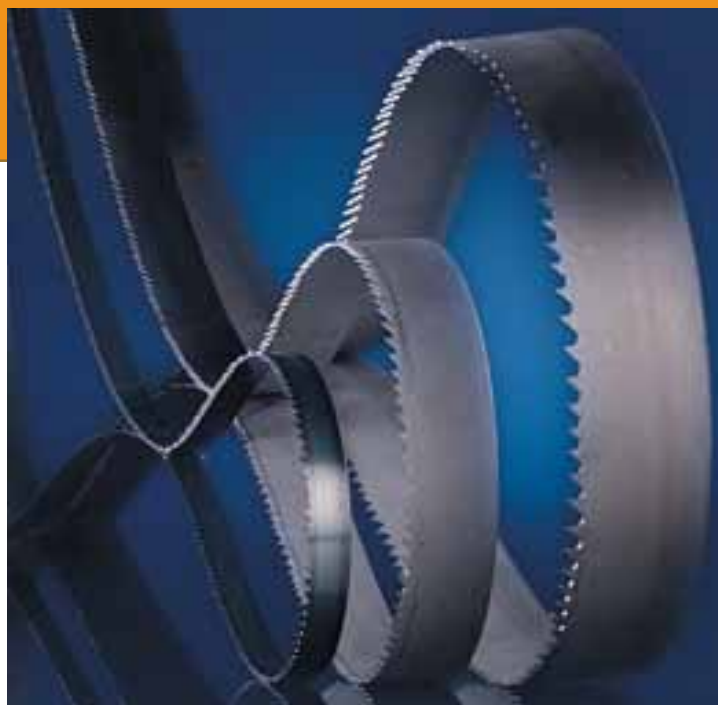
BAND SAW BLADES

Band saw blades

Introduction

Kinkelder offers bi-metal and carbon band saw blades in widths ranging from 3 mm to 80 mm and various thicknesses and tooth forms depending on the material to be cut. Band saw blades can be supplied as welded loops or in coil form.

On the following pages you will find details of the standard Kinkelder band saw blades.



Carbon band saw blades

The Kinkelder band saw blade is of the highest quality and ideal for use for many jobs arising in the workplace. This saw is specially suitable for the sawing of wood. The Kinkelder flexback carbon band saw blade is made of tool steel with hardened teeth and a flexible back, which is excellent for absorbing the shocks which occur during sawing.

Flexback carbon band saws

Width x thickness		Hook	Number of teeth per inch (25,4 mm)										
			Standard										
mm	inch												
6 x 0,65	1/4 x 0.025		4	6									32*
8 x 0,65	5/16 x 0.025		4	6									24*
10 x 0,65	3/8 x 0.025	3	4	6									24*
13 x 0,65	1/2 x 0.025	3	4	6									24*
16 x 0,80	5/8 x 0.032	3	4		4	6	8	10	14*	18	24*	32*	
20 x 0,80	3/4 x 0.032	3	4			6	8	10	14*	18*	24		
25 x 0,90	1 x 0.035	2	3	4		4	6	8	10	14*	24		

* with wavy set



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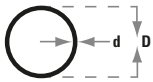


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TOOTH PITCH

Tooth pitch determination for band saw blades

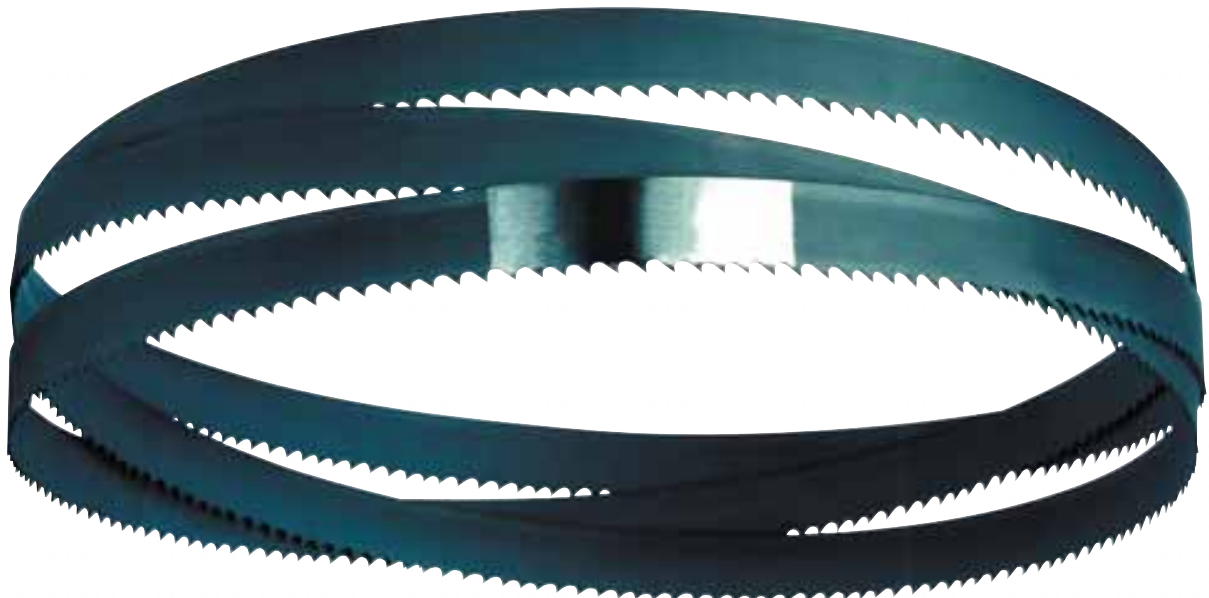


Recommendations for tooth pitch to be used for tubes

		Outside diameter D (mm)									
Wall thickness d		20	40	60	80	100	120	150	200	300	500
mm	inch	Number of teeth per inch (TPI)									
2	0.080	14	14	14	14	14	14	10/14	10/14	8/12	6/10
3	0.125	14	14	14	10/14	10/14	10/14	8/12	8/12	6/10	5/8
4	0.187	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	4/6
5	0.218	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
6	0.250	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	3/4
8	0.312	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6	3/4
10	0.375		6/10	5/8	5/8	5/8	4/6	4/6	4/6	3/4	3/4
12	0.500		5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	2/3
15	0.625		5/8	5/8	4/6	4/6	4/6	4/6	3/4	2/3	2/3
20	0.750			4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
30	1.000				3/4	3/4	3/4	3/4	2/3	2/3	2/3
50	2.000							2/3	2/3	2/3	2/3

Recommendations for tooth pitch to be used for solid material

Recommendation solid material			
Regular pitch		Combi pitch	
Material diameter mm	Number of teeth (TPI)	Material diameter mm	Number of teeth (TPI)
tot 10	14	tot 25	10/14
10-30	10	15-40	8/12
30-50	8	25-50	6/10
50-80	6	35-70	5/8
80-120	4	50-100	4/6
120-200	3	80-180	3/4
200-400	2	130-300	2/3
300-700	1,25	220-600	1/2
>600	0,75	>600	0,75/1,25




APPLICATIONS


Application matrix HSS saw blades


Tooth pitch recommendation

D (mm)	10	20	30	40	50	60	70	80	90	100	110	120	130	140	150
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Tooth pitch (mm)


 Round	5	7	9	10	11	12	13	14	15	16	17	17	18	19	20
---	---	---	---	----	----	----	----	----	----	----	----	----	----	----	----

 Square	5	7	9	10	11	12	13	14	15	16	17	17	18	19	20
--	---	---	---	----	----	----	----	----	----	----	----	----	----	----	----

 Thick wall tube	5	7	7	8	9	9	9	10	10	10	11	11	11	11	11
--	---	---	---	---	---	---	---	----	----	----	----	----	----	----	----

 Thin wall tube	4	5	6	6	7	7	7	8	8	8	9	9	9	9	9
--	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---


 RSJ									13	13	13	13	13	14	14	15
---	--	--	--	--	--	--	--	--	----	----	----	----	----	----	----	----


 Channel			13	13	13	14	14	14	14	14	14	14	15	16	16	16
---	--	--	----	----	----	----	----	----	----	----	----	----	----	----	----	----

Speed recommendation

Material type	Structural steels		Special steels	Stain- less	Cast steel	Cast iron	Non-ferrous			
						Copper	Brass	Bronze	Aluminium	


Peripheral speed (M/min)


 Round	30-60	20-40	5-30	15-30	10-40	200-400	350-600	25-125	80-1800
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 Square	30-60	20-40	5-30	15-30	10-40	200-400	350-600	25-125	80-1800
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 Thick wall tube	40-80	20-50	5-40	15-30	10-50	200-500	350-750	25-125	125-1800
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 Thin wall tube	50-120	25-80	10-50			350-650	400-900		250-1800
--	--------	-------	-------	--	--	---------	---------	--	----------

 RSJ	48-80	20-50	10-40						
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 Channel	30-60	20-50	10-40						80-1800
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