

Kinkelder Circular Sawblades



HSS Circular Sawblades

Kinkelder produces HSS metal circular sawblades in diameters varying from 150 to 570 mm in various designs. Our standard stocked range is set out below.

Standard specifications:

Material	M2 = DIN 1.3343
Manufacturing standards	DIN 1836, 1837, 1838 and 1840
Tooth forms	BW, HZ
Cutting clearance angle	18° / 8°
Design hardness	Steam-treated 63-65 HRc

Please indicate with order:

Diameter, thickness, borehole, pinhole pattern, tooth pitch, number of teeth and tooth form. In addition, indicate cutting and clearance angle where these differ from the standard cutting and clearance angle (18° / 8°).

Service life improvement

There are ways of improving the service life of a sawblade. This is among others possible by using a steam-treated sawblade.

Steam-treated

The steam-treatment of Kinkelder HSS sawblades is carried out in a special oven, in which steam at a constant temperature of 550°C is injected. This process provides a hard dark-blue layer of Fe₃O₄ on the sawblade with a thickness of 3 - 5µm. This hard, wear resistant oxide layer has a micro-porous structure as a result of which the coolant has a better cooling and lubricating effect on the sawblade. The result is a greatly reduced chance of cold-weld and an increase in service life.

Sharpening & Repair Service

We offer a prompt sharpening service with up-to-date CNC machinery, and can provide any tooth configuration from a large inventory of blank blades.

Standard HSS Circular Sawblade Stocked Range

Dia. x thickness mm	Bore-hole mm	Pinhole combinations	Weight kg	Number of teeth and toothpitches (mm)											
				2.5	3	4	5	6	7	8	9	10	11	12	14
225 x 2	40	2/8.5/55, 4/12/64	0.6	280	220	180	150	120	100	90	80	72			
250 x 2	32	2/8.5/45, 2/11/63	0.7	320	240	200/180	160	128	120/112	100	84	80	72		
	40	2/8.5/55, 4/12/64		320	240	200	160	128	112	100	84	80	72		
275 x 2	32	2/8.5/45, 2/11/63	0.8	336	280	220	180	144	120	110	96	84	80	72	
	40	2/8.5/55, 4/12/64		336	280	220	180	144	120	110	96	84	80	72	
315 x 2.5	32	2/8.5/45, 2/11/63	1.3	390	320	250	200	160	140	120	110	100	90	80	72
	40	2/8.5/55, 4/12/64		390	320	250	200	160	140	120	110	100	90	80	72
350 x 2.5	32	2/8.5/45, 2/9/50, 2/12/64	1.6		336	280	220	180	160	140	120	110	100	90	80
	40	2/8.5/45, 4/12/64			336	280	220	180	160	140	120	110	100	90	80
370 x 2.5	32	2/8.5/45, 2/9/50, 2/12/64	1.6		336	280	220	180	160	140	120	110	100	90	80
400 x 3	40	2/8.5/55, 4/12/64	2.5			310	250	200	180	160	140	128	114	100	90
520 x 4	40		10	300 Friction Sawblade (JIFFY)											

Segmental Circular Sawblades

AVAILABLE ON INDENT

The segmental circular sawblade consists of a CrV steel disc surrounded by a rim of hardened high speed steel. This rim consists of a number of segments which are rivetted to the disc.

