KINKELDER®
the cutting experts



TCT SERIES

CX SERIES

The new standard in TCT cutting

High performance (stainless) steel tube cutting





The CX 3 saw blade has been developed for cutting tubes on high performance automatic sawing machines, at a higher maximum cutting speed than possible with HSS saw blades. It is most effective on sawing machines with accurate control of chip load and variable feed rate. Bigger tips are applied at pitches > 9mm for added stability.

- For high performance cutting of carbon steel tubes
- Cutting alloyed steel up to 900 N/mm^2
- Versatile, fast, cost-effective, dependable performance

APPLICCATIONS	Steel tubes with a tensile strength between 600 to 1,500 N/mm^2
PARAMETERS	Suggested cutting speed: 180 - 280 m/min. Feed rate: 0,04 - 0,16 mm/tooth.
MACHINES	Soco, Rattunde, Sinico, Bewo, RSA, Plantool, Adige, OMP



The high nickel content of austenitic stainless steel tubes makes them difficult to cut with HSS saw blades. With the dedicated tooth geometry of the carbide tipped and PVD coated CX 4 saw blade, perfect surface finish and burr-free tube ends will be achieved.

- Setting new standards for fast cutting of stainless steel tubes
- Smooth cut surface, very little burr, long blade life
- Low cutting force allows cutting thin walled tube/profile

APPLICATIONS	Austenitic stainless steel tubes
PARAMETERS	Suggested cutting speed: 80 - 140 m/min. Feed rate: 0,06 - 0,12 mm/tooth.
MACHINES	Soco, Rattunde, Bewo, RSA, Sinico



The CX 5 saw blade has been specifically designed to cut thin walled tubes. Because of its light cutting properties, it is also very well suited for use on a wide range of automatic cut-off machines.

- For cutting thin wall, high hardness, unstable products
- Low vibration, low noise, smooth cut surface, low burr
- For thin walled tube/profile made of DP, CP, HSLA and TRIP type materials

APPLICATIONS	Thin wall high hardness tube cutting on lighter machines. High performance cutting of thin walled tubes and unstable profiles on high-end machines.
PARAMETERS	Suggested cutting speed: 160 - 280 m/min. Feed rate: 0,025 - 0,12 mm/tooth.
MACHINES	Soco, Kasto, Bewo, RSA, Adige, Sinico, Rattunde

Cutting low to high tensile carbon steel & stainless steel solids





The PVD coated, carbide tipped CX 1-M saw blade has been developed for cutting solid carbon steel (carbon content < 0.60%) with a medium tensile strength between 500 and 900 N/mm^2 at very high production rates.

- New saw body design
- Specifically designed for cutting solid carbon steel with medium tensile strengths
- High productivity
- Best blade life performances when a wider range of materials needs to be cut

APPLICATIONS	Solid carbon steel with a tensile strength between 500 and 900 N/mm^2 on high performance machines
PARAMETERS	Suggested cutting speed: 100 - 280 m/min. Feed rate: 0,06 - 0,10 mm/tooth.
MACHINES	All known brands of stationary automatic sawing machines such as: Soco, Nishijimax, Tsune, Mega, Everising, Rattunde, Behringer etc.



Applying a new saw body design, new tooth geometries and a new type of PVD coating, the CX 1-H saw blade has specifically been designed for cutting high tensile carbon steel (> 900 N/mm^2, carbon content ≥ 0.60%) at very high production rates. It is also very suitable for cutting ferritic, martensitic and duplex stainless steel bars with a diameter larger than 35 mm.

- New saw body design
- New dedicated tooth geometries
- New type of coating
- Best blade life performances when cutting high tensile carbon steel
- High productivity when cutting stainless steel

APPLICATIONS	Hard solid carbon steel with a tensile strength higher than 900 N/mm^2 and ferritic, martensitic and duplex stainless steel bars Ø >35 mm on high performance machines
PARAMETERS	Suggested cutting speed: 60 - 140 m/min. Feed rate: 0,05 - 0,09 mm/tooth.
MACHINES	All known brands of stationary automatic sawing machines such as: Soco, Nishijimax, Tsune, Mega, Everising, Rattunde, Behringer etc.

Cutting low to medium tensile carbon and austenitic stainless solid steel





CX 6-S saw blades are carbide tipped and PVD coated for cutting stainless steel solids with a diameter ≤ 35 mm. High production rates and optimal surface finish can be achieved with our dedicated geometry.

- New saw body design
- Best saw blade when cutting ferritic, martensitic and duplex stainless steel at smaller diameter ranges
- Specifically developed for stainless steel solids with a diameter ≤ 35 mm
- Dedicated tooth geometry

APPLICATIONS	Austenitic, ferritic, martensitic and duplex stainless steel bars with a diameter ≤ 35 mm
PARAMETERS	Suggested cutting speed: 80 - 140 m/min. Feed rate: 0,03 - 0,05 mm/tooth.
MACHINES	Soco, Tsune, Amada, Mega, Kasto, Kentai, Behringer, Exactcut, Everising



The PVD coated CX 6-L saw blade has specifically been designed for cutting austenitic stainless steel bars with a diameter larger than 35mm at very high production rates. With its dedicated geometry, very fast cutting and good surface finish can be achieved.

- New saw body design
- Specifically developed for stainless steel bars with a diameter > 35 mm
- Dedicated tooth geometry
- Very high production rates

APPLICATIONS	Austenitic stainless steel bars with a diameter > 35 mm
PARAMETERS	Suggested cutting speed: 80 - 120 m/min. Feed rate: 0,06 - 0,12 mm/tooth.
MACHINES	Soco, Tsune, Amada, Mega, Kasto, Kentai, Behringer, Exactcut, Everising



CX 7 is a Cermet tipped, PVD coated saw blade dedicated to cutting carbon steel (carbon content < 0.60%) with a low to medium tensile strength up to 750 N/mm^2. The best blade performance is being achieved when cutting lower tensile materials. On many applications, a blade life of 50 m^2 and more can be achieved.

- New saw body design
- Specifically designed for cutting low to medium tensile carbon steel
- Best blade performance when cutting lower tensile strength materials

APPLICATIONS	Solid carbon steel with a tensile strength up to 750 N/mm^2
PARAMETERS	Suggested cutting speed: 100 - 280 m/min. Feed rate: 0,06 - 0,10 mm/tooth.
MACHINES	Soco, Kasto, Nishijima, Tsune, Amada, Behringer, RSA, Rattunde, Sinico, Mega, Exactcut, Everising

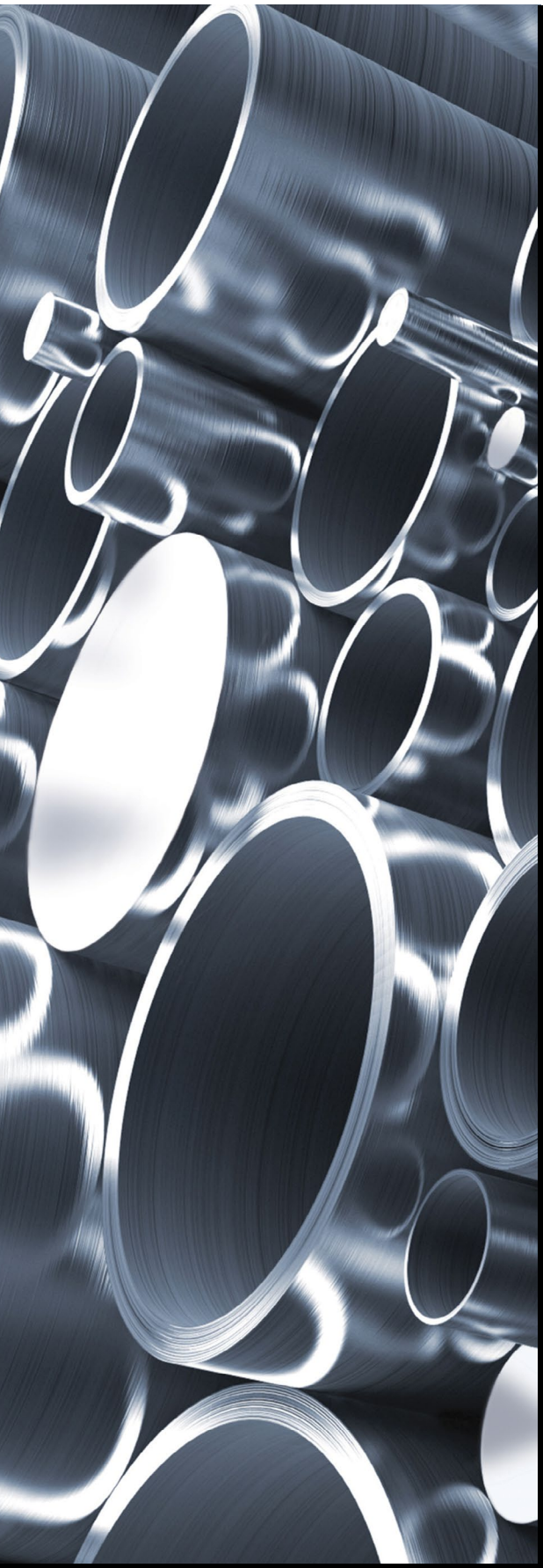
Product application matrix TCT CX Series for (stainless) steel tubes

Color ref.	Application	Suggested blade type
3	Medium to high tensile carbon steel (C < 0.60%) Tensile strength 600 - 1.500 N/mm²	CX SERIES 3
4	Austenitic stainless steel tubes	CX SERIES 4
5	High tensile, thin walled carbon steel (C ≥ 0.60%) tubes Instable high tensile hollow sections	CX SERIES 5

Product application matrix TCT CX Series for (stainless) steel solids

Color ref.	Application	Suggested blade type
7	Low to medium tensile carbon steel (C < 0.60%) Tensile strength < 750 N/mm²	CX SERIES 7
1M	Low to medium tensile carbon steel (C < 0.60%) Tensile strength 500 - 900 N/mm²	CX SERIES 1 M
1H	High tensile carbon steel (C ≥ 0.60%) Tensile strength > 900 N/mm²	CX SERIES 1 H
	Ferritic stainless steel Ø > 35 mm	
	Martensitic stainless steel Ø > 35 mm	
	Duplex stainless steel Ø > 35 mm	
6S	Ferritic stainless steel Ø ≤ 35 mm	CX SERIES 6 S
	Martensitic stainless steel Ø ≤ 35 mm	
	Duplex stainless steel Ø ≤ 35 mm	
	Austenitic stainless steel Ø ≤ 35 mm	
6L	Austenitic stainless steel Ø > 35 mm	CX SERIES 6 L

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