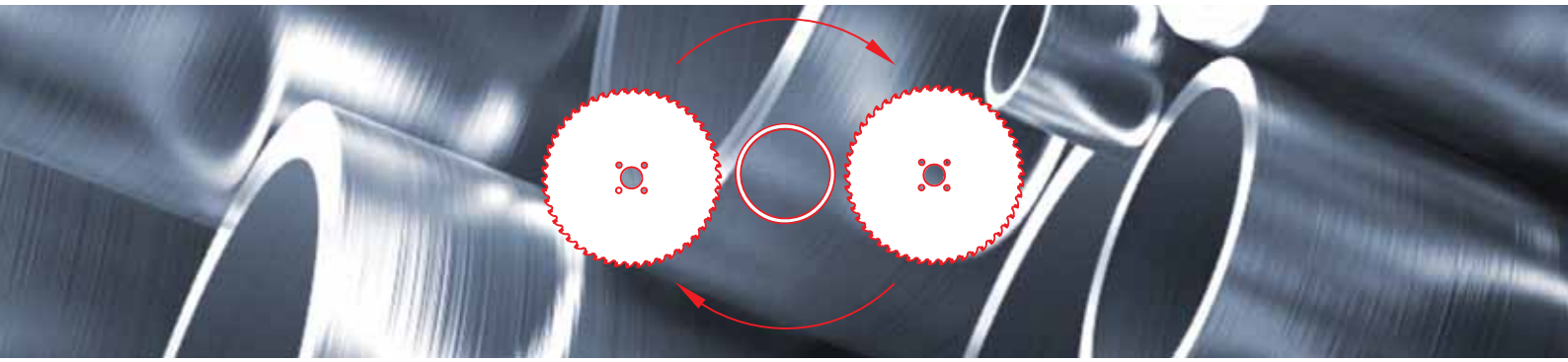
KINKELDER®
the cutting experts

FLYING CUT-OFF
TCT SERIES

**3 proven sawing concepts
for ERW tube and pipe industry**

Orbital cut-off



TUBEMASTER®

Key features of the TubeMaster saw blade are fracture-resistant carbide tips, protected with a high-tech TiAlN-based PVD coating. Combined with a light cutting geometry, which eases chip removal, a milled like surface finish is assured. This geometry also reduces vibration when cutting thin wall tubing (<4mm), thereby achieving excellent blade life.

Advantages

- High line speed
- High blade life
- Cuts high tensile API Pipes (up to 110 KSI, X80, HT)
- Burr-free cut

APPLICATIONS: Orbital, flying cut-off applications

TubeMaster saw blades are available in diameters from Ø 300 up to Ø420 mm for all types of orbital cutting machines, such as MTM, OTO mills, Elmaksan, Kusakabe, Linsinger and SMS Meer.

PARAMETERS: Suggested cutting speed: 350 - 400 m/min.
Feed: 0,04 - 0,12 mm/tooth.

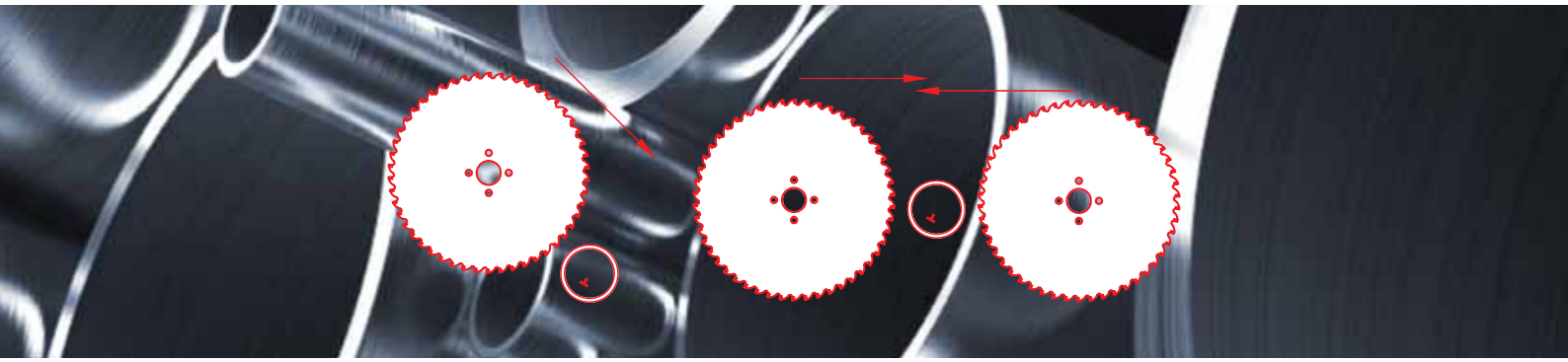
TYPICAL APPLICATION EXAMPLES

Dimensions (mm)	Material specifications	Tensile strength (N/mm²)	Cutting time (s)	Blade life (m²)	Machine
323 x 9	X80	560	9	3,2	Nakata
169 x 11	S355J2	580	7,6	3,8	OTO mills
510 x 15	S355	520	21	4,0	Linsinger
127 x 5	S355	520	14	4,5	SMS Meer

For more information:

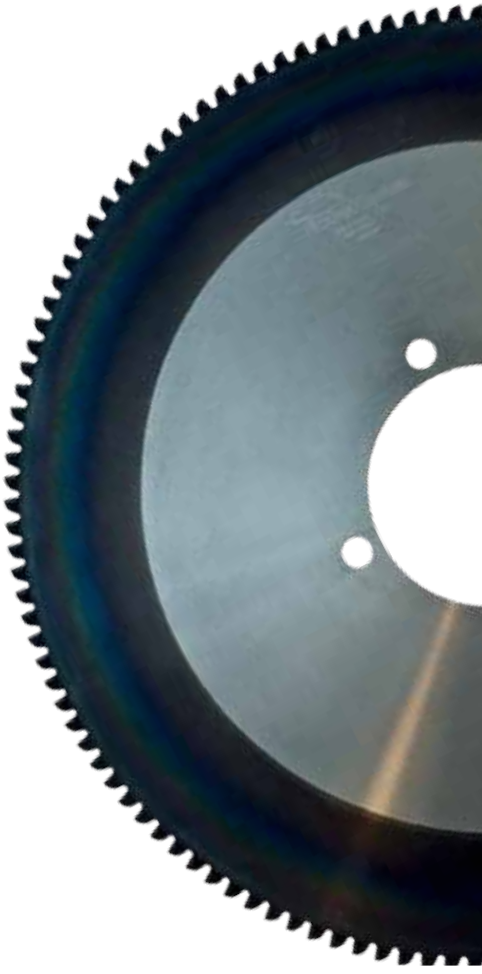
www.kinkelder.com

Single and Twin cut-off: ID-scarf



ScarfMaster®

ScarfMaster is a PVD coated carbide tipped saw blade featuring a very specific tooth-geometry while tips themselves are made of a highly shock resistant type of carbide. The teeth are supported by a saw body with extra strong shoulders, which give the combination tooth/body very high stability and fracture resistance and therefore extended blade life.



Advantages

- High line speed
- Increased uptime
- High blade life
- Cuts heavy ID scarf
- Cuts high tensile API tubes (up to 110 KSI)
- Various tooth geometries available

APPLICATIONS: Flying cut-off application dealing with heavy ID Scarf

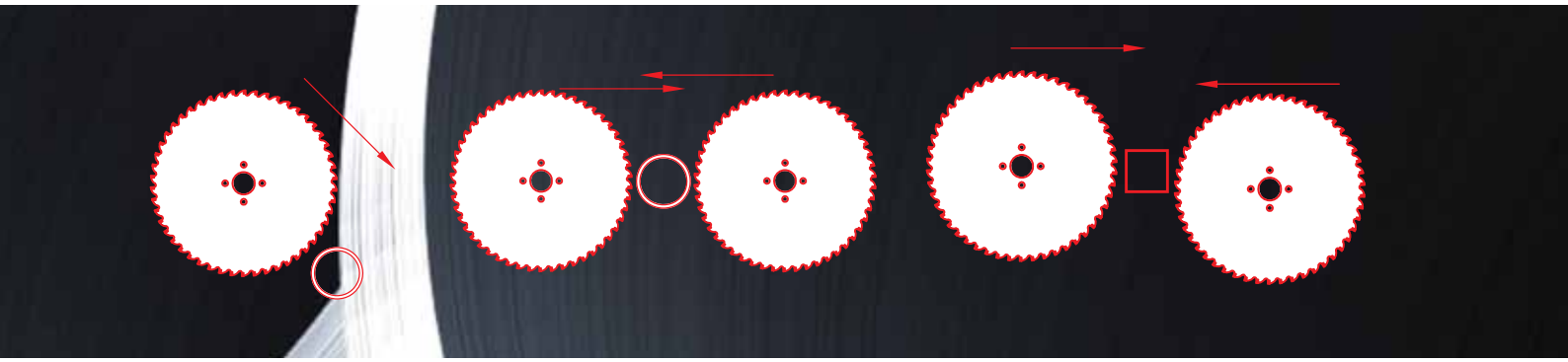
ScarfMaster saw blades are available in diameters from Ø 450 up to Ø600 mm for flying cut-off machines, such as MTM, OTO mills, Nakata and Olimpia.

PARAMETERS: Suggested cutting speed: 450 m/min.
Feed: 0,04 mm/tooth.

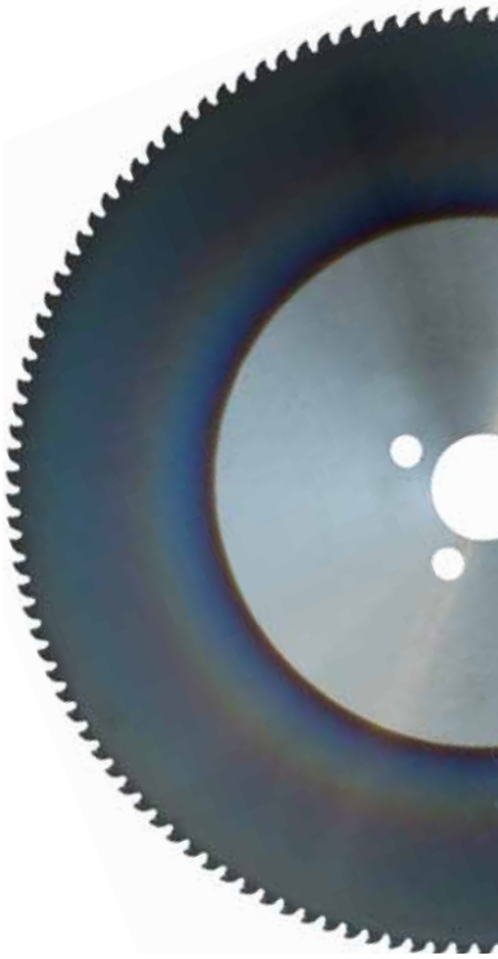
TYPICAL APPLICATION EXAMPLES

Dimensions (mm)	Material specifications	Tensile strength (N/mm²)	Mill speed (m/mm²)	Cutting time (s)	Blade life (cuts or m²)	Machine
168 x 6	S355	520	40	4,8	3,5 m²	OTO mills
100 x 8	1018	480	30	4,2	4,500 cuts	OTO mills
63 x 5	S355	520	60	2,6	1,5 m²	MTM
48 x 3	S500 MC	500	75	2,0	1,4 m²	Olimpia

Single and Twin cut-off: no ID-scarf



SPEEDMASTER®



SpeedMaster is a TCT saw blade for flying cut-off applications on tube mills. It provides an opportunity to greatly increase the tube manufacturing line speeds and cut the production costs.

Where cutting speed limits of coated HSS saw blades have been reached, SpeedMaster saw blades provide an effective solution.

Advantages

- Extremely high line speed because of very short cutting times
- Very good surface finish, burr-free cut
- Increased uptime

APPLICATIONS:	Single and Twin flying cut-off machines designed for TCT cutting with small or no ID scarf
PARAMETERS:	Tubes with a tensile strength up to 1800 N/mm^2. Suggested cutting speed: 200 - 600 m/min.

TYPICAL APPLICATION EXAMPLES

Dimensions (mm)	Material specifications	Tensile strength (N/mm^2)	Mill speed (m/min)	Cutting speed (m/min)	Tooth load (mm/tooth)	Blade life (cuts)
40 x 20 x 3	S355/1020	520	350	450	0,06/0,18	25,000
76 x 4,7	E235	420	90	400	0,06/0,14	7,500
60 x 5	S500MC	500	90	350	0,05/0,15	6,000

Which concept fits you?

3 concepts, each designed
to address a specific flying cut-off application

TUBEMASTER® SCARFMASTER® SPEEDMASTER®

These are your benefits:

- Reduce downtime
- Increase line speed
- Improve blade life
- Produce a burr-free cut

MACHINE	MATERIAL	SOLUTION
Orbital	All types	TubeMaster
Single linear or Twin	ID Scarf	ScarfMaster
	No ID Scarf	SpeedMaster

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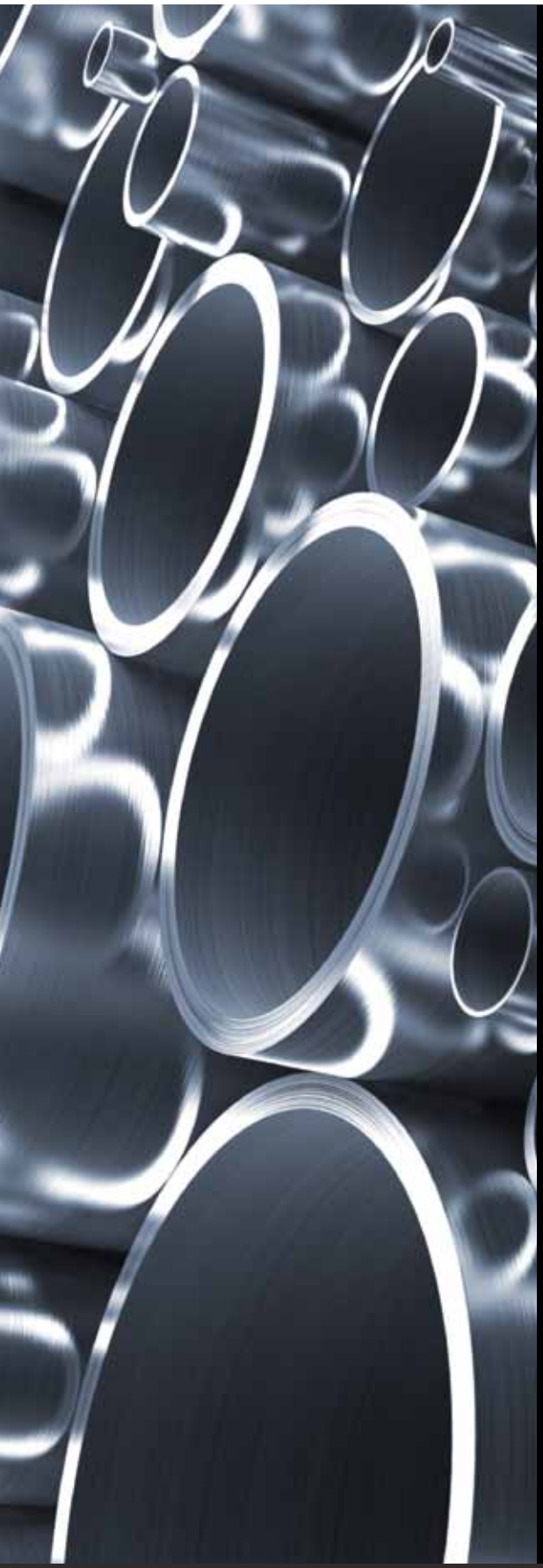

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