



Haas Saw



TCT SERIES

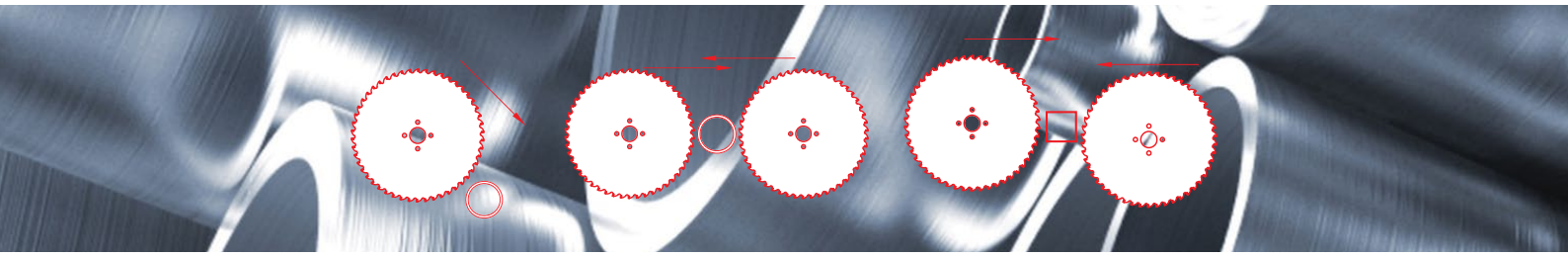
FLYING CUT-OFF

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

For more information:

www.haassaw.com

Single and Twin cut-off



SpeedMaster is a TCT saw blade for single- and twin cut-off units on steel 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. Tubes with a tensile strength up to 1.000 N/mm²

PARAMETERS

Cutting speed: 350 m/min (starting value).
Tooth load 1/2/3: relation 1/2/0.8. 0.05/0.10/0.04 mm/tooth.

Note: To accommodate higher requirements of line speed or reduce vibration level when cutting thin wall section, higher cutting speeds (up to 500m/min) can be applied. Tooth load can be doubled if required, while respecting max fill ratio of 10%.

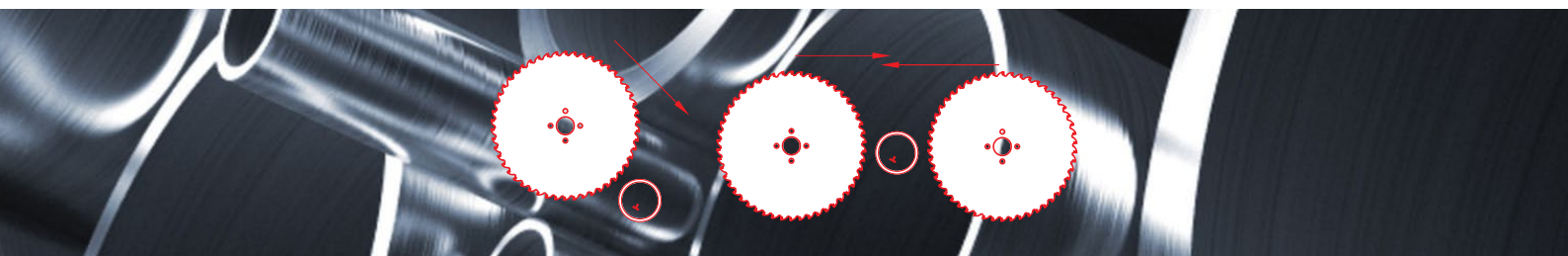
TYPICAL APPLICATION EXAMPLES SPEEDMASTER

| Dimensions (mm) | Material specifications | Tensile strength (N/mm ²) | Mill speed (m/min) | Cutting speed (m/min) | Tooth load (mm/tooth) | Blade life (m ²) |
|-----------------|-------------------------|---------------------------------------|--------------------|-----------------------|-----------------------|------------------------------|
| 40 x 20 x 3 | S355/1020 | 520 | 350 | 450 | 0,06/0,18 | 2,5 |
| 76 x 4,7 | E235 | 420 | 90 | 400 | 0,06/0,14 | 7,9 |
| 60 x 5 | S500MC | 500 | 90 | 350 | 0,05/0,15 | 5,2 |

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Single and Twin cut-off with inside scarf



The PVD coated carbide tipped ScarfMaster has specifically been designed for flying cut-off applications dealing with heavy inside scarf. It features a very specific tooth geometry, combined with highly shock resistant carbide tips.

Due to strong saw body shoulders which give the teeth maximum support, the combination tooth/body obtains very high stability and fracture resistance. Extended blade life is therefore achieved.

Advantages

- High line speed
- Increased uptime
- High blade life
- Cuts heavy ID scarf
- Cuts high tensile API Pipes (up to 1.800 N/mm²)
- Various tooth geometries available

APPLICATIONS

Flying cut-off applications dealing with heavy inside scarf

PARAMETERS

Cutting speed: 400 – 500 m/min (choose max available).
Tooth load 1/2/3: relation 1/1/1. Starting value 0.04 mm/tooth.

MACHINES

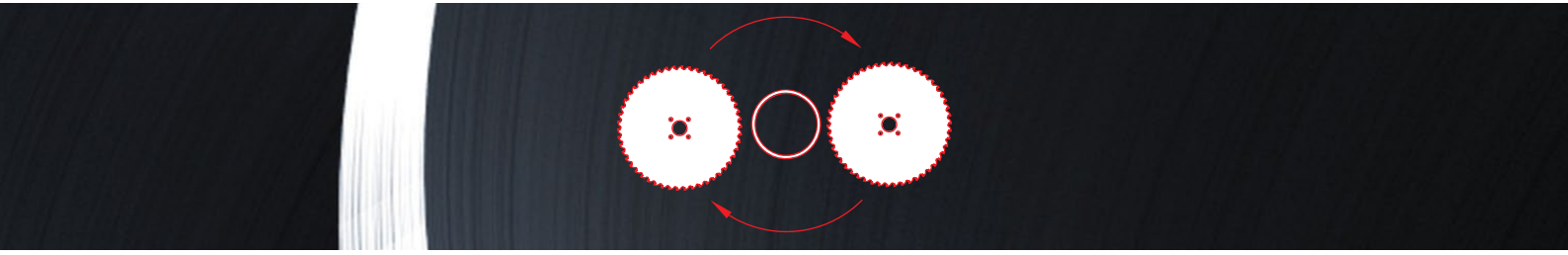
ScarfMaster saw blades are available for flying cut-off machines, such as MTM, OTO mills, Nakata and Olimpia.

Note: Primary failure mode for this application is tooth and shoulder damage. Raising cutting speed and reducing tooth load typically improves blade life. Blade life is highly depending on size, orientation and material grade of loose inside scarf. No guarantees can therefore be given for blade life. Blade life typically varies considerably, depending on operator/crew who influence scarf condition.

TYPICAL APPLICATION EXAMPLES SCARFMASTER

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

Orbital cut-off



TubeMaster saw blades have especially been designed for orbital flying cut-off applications on tube mills. Key features of this saw blade are fracture-resistant carbide tips, protected with a high-tech TiAlN-based PVD coating. Combined with a light cutting geometry for smooth chip evacuation, a milled like surface finish is achieved. This geometry also reduces vibration when cutting thin walled tubes (<4mm), thereby achieving excellent blade life.

The new generation of TubeMaster products has a new body design, new carbide grade, new tip geometry and a special coating. This results in a higher blade life and more regular blade performance.

Advantages

- High line speed
- High blade life
- Cuts high tensile API Pipes (up to 1.000 N/mm², X80, HT)
- Burr-free cut

APPLICATIONS

Orbital, flying cut-off applications

PARAMETERS

Suggested cutting speed: 350 – 400 m/min.
Feed 1/2: 0,04 / 0,12 mm/tooth.

MACHINES

TubeMaster saw blades are available for all types of orbital cutting machines, such as MTM, OTO mills, Elmaksan, Kusakabe, Linsinger, Nakata and SMS Meer.

Note: To accommodate higher requirements of line speed or reduce vibration level, much higher cutting speeds (up to 600 m/min) can be applied. Tooth load can be raised, while respecting max fill ratio of 10% during entry. Respect max cut depth of 3mm.



The TubeMaster Stainless saw blade has specifically been developed for cutting stainless steel tubes on orbital flying cut-off units. These saw blades can cope with cutting speeds between 60 – 120 m/min. TubeMaster Stainless offers high uptime due to a blade life up to 3,5m², combined with high cut quality and production output.

APPLICATIONS

Orbital, stainless steel flying cut-off applications

PARAMETERS

Suggested cutting speed: 60 – 120 m/min
Feed: 0.035 – 0.10 mm/tooth

MACHINES

TubeMaster Stainless saw blades are available for all orbital cutting machines.

For more information:

www.haassaw.com

Which concept fits you?

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



Your benefits:

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

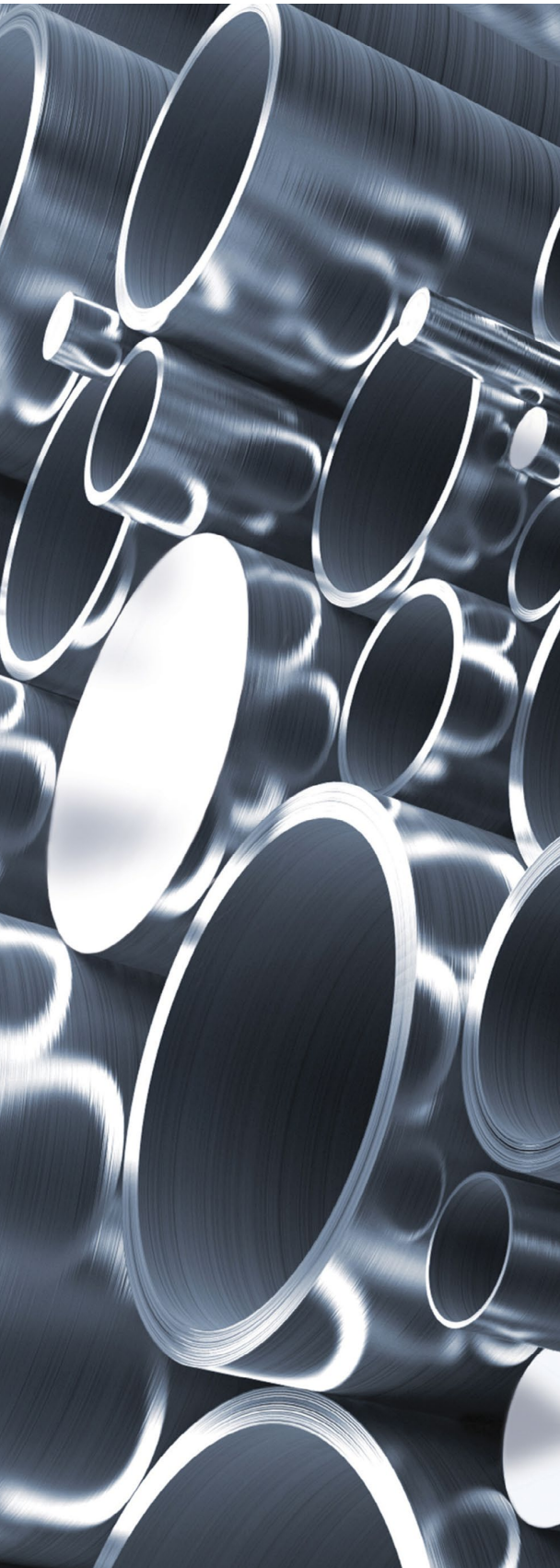
| APPLICATIONS | | |
|-----------------------|---------------------------------------|----------------------|
| MACHINE | MATERIAL | SOLUTION |
| Orbital | Steel tubes | TubeMaster |
| | Stainless steel tubes | TubeMaster Stainless |
| Single linear or Twin | Steel tubes with heavy ID scarf | ScarfMaster |
| | Steel tube with little or no ID scarf | SpeedMaster |

For more information:

www.haassaw.com



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HAAS SAW

1136 Drop Off Drive
Summerville SC 29486 USA
T: 843.875.8005
sales@haassaw.com
www.haassaw.com

Saws International Inc. USA Headquarters

Machesney Park IL
T: 815.965.6900
info@kinkelderusa.com
www.kinkelderusa.com

Kinkelder Saw Inc.

Canton MI
T: 734.453.1199
info@kinkelderusa.com
www.kinkelderusa.com

Kinkelder Cutting Solutions Inc.

Louisville KY
T: 502.329.8244
cridge@kinkelderusa.com
www.kinkelderusa.com

Kinkelder USA South

Pell City AL
T: 205.884.4971
info@kinkelderusa.com
www.kinkelderusa.com

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