



Product Catalogue



A.Lindemann GmbH

We Make The Difference

www.alindemann.de

Welcome to Lindemann GmbH

A.Lindemann GmbH

For more than 40 years the Lindemann GmbH has been working as a sharpening service company in Germany's Ruhr area (Ruhrgebiet). As a partner for industry and handcraft we are standing side by side with our customers to solve their sawing job.

In the beginning of 2015 we took the step from a sharpening service to a manufacturer of saw blades. After taking over the complete circular saw blade business of the Arntz GmbH + Co. KG we became a manufacturer for all kinds of high precision circular saw blades for metal. The more than 200 years old tradition of the Arntz Company will live on in our products supplemented by innovations for the ongoing changing sawing challenges of our customers.

To support our customers we will deliver all established saw blades short-term from stock.

Due to the fact that circular saw blades need an excellent service, qualified personal is prepared at our production locations, in Dortmund and Schmöln, to service your saw blades according to your specification. Pick-up and delivery, with our own vehicles, are another service we offer to our customers, if possible.

Constantly changing demands to the sawing technology require always new solutions for the need of our clients. Lindemann leaves you not alone with this problem and supports you on site with our trained team of specialists. Our circular saw blades "Made in Germany", manufactured according to DIN/ISO 9001:2008 will solve this task to the satisfaction of our customers worldwide.

We are pleased to satisfy your sawing requirements.

Your Lindemann team

THIN KERF CIRCULAR COLD SAWS

The sawing-technology has made quantum leaps during the last 20 years. The selection of tool components, like substrates, coatings and the micro-geometry needs to be combined in the most optimal way, depending from the specific application.

The challenge for a sawblade manufacturer is to stabilize a high quality-level. Customers want to have tools which enables them to generate industrial processes on a stable level.

LINDEMANN is focusing its efforts on a high quality-level, in order to support customers to achieve a reliable and low cost-level.

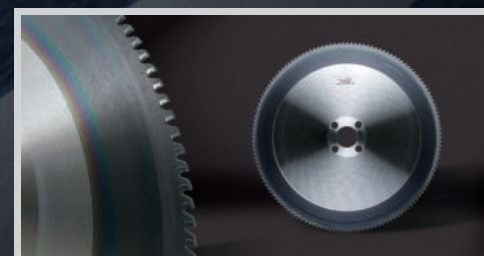
The MAXIMA Products are a statement of this company philosophy. Customers may have high expectations from every LINDEMANN sawblade. Applications-engineers are supporting customers, in order to achieve new performance levels in their production.

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Maxima Series for tube cutting

MAXIMA HT

Our Maxima HT is widely used in automotive industry for cutting at high speed different tubes on static machines, such as Rattunde, Nishijma, Soco, RSA and Adige.

Application: All tubes with a tensile strength up to 1600 N/mm²
Parameters: Cutting speed: 180 - 320 m/min
Tooth load: 0.04 - 0.14 mm/tooth

MAXIMA XS

This is newly developed to cut thin wall tubes on static machine, including light sawing machines like BEWO, RSA, OMP, Soco.

Application : All thin wall steel tubes with a tensile strength up to 800 N/mm² and stainless steel
Parameters : Cutting speed: 160 - 280 m/min
Tooth load: 0.025 - 0.12 mm/tooth



For Your Sawing Solution

Standard Specifications

Ø mm	Cutting width	Blade boby	Central bore	Pinholes	Standard dimensions									
					z60	z72	z80	z100	z120	z130	z140	z150	z160	z170
250	2.0	1.70	32	4/9/50+4/11/63			*	*						
		1.75	40	2/15/80+4/12/64			*	*						
285	2.0	1.70	32	4/9/50+4/11/63			*	*	*					
		1.75	40	2/12/80+2/15/80			*	*	*					
315	2.3	2.0	32	4/11/63				*	*					
			40	2/15/80+4/12/64				*	*					
	2.5	2.25	32	4/9/50				*	*					
350	2.7	2.50	50	4/16/80				*	*		*			
360	2.6	2.25	32	4/11/63				*	*		*			
			40	2/11/63+2/15/80+4/12/90				*	*		*			
			50	4/16/80				*	*		*			
400	2.8	2.50	50	4/16/80				*	*					
425	2.7	2.27	50	4/16/80				*	*		*			
450	2.8	2.50	50	4/16/80					*	*	*		*	
500	3.5	3.00	50	4/16/80					*		*			*

Maxima Series for flying cut-off machines

MAXIMA AF

Once the HSS saw blades reach maximum cutting limit, this is where MAXIMA AF come to place to provide you with the right solution on flying cut-off machines with single or twin heads.

Our PVD coated carbide blades will optimize your tube and pipes production.

Application : All tubes with a tensile strength up to 1600 N/mm²

Parameters : Cutting speed: 180 – 450 m/min
Tooth load: Fz1 0.03 to 0.07 mm & Fz2 0.06 to 0.15 mm



MAXIMA AFX

MAXIMA AFX is a newly developed product used in the same cutting application of MAXIMA AF but it provides an extended blade's life.

Faster line speed and shorter cutting time will decrease your production costs.

Application : All tubes with a tensile strength up to 1600 N/mm²

Parameters : Cutting speed: 180 – 500 m/min
Tooth load : Fz1 0.03 to 0.09 mm & Fz2 0.06 to 0.15 mm



For Your Sawing Solution

Standard Specifications

Ø mm	Cutting width	Blade boby	Central bore	Pinholes	Standard dimensions						
					z100	z120	z130	z140	z150	z160	z170
400	2.8	2.50	50	4/16/80	*	*	*	*			
425	2.7	2.27	50	4/16/80		*	*	*			
450	2.8	2.50	50	4/16/80		*	*	*		*	
500	3.5	3.00	50	4/16/80		*	*	*		*	*
550	3.60	3.20	80	4/23/120		*		*	*	*	*
			90	3/12.5/160		*		*	*	*	*
			140	4/17.5/170		*		*	*	*	*
560	3.60	3.20	80	4/23/120		*		*	*	*	*
			90	3/12.5/160		*		*	*	*	*
			140	4/17.5/170		*		*	*	*	*
600	3.60	3.20	80	4/23/120				*	*	*	*
			90	3/12.5/160				*	*	*	*
			140	4/17.5/170				*	*	*	*
630	3.60	3.20	80	4/23/120				*		*	
			90	3/12.5/160				*		*	
			140	4/17.5/170				*		*	
650	3.60	3.20	80	4/23/120					*		*
690	3.60	3.20	80	4/23/120					*		*

Maxima Series for flying cut-off machines

MAXIMA IF

TCT saw blade for cutting pipes with inner scarf on flying cut-off machines.

Maxima IF is designed to withstand heavy work. High shocks resistance will extend the blade's life.

Application : All tubes with a tensile strength up to 1600 N/mm²

Parameters : Cutting speed: 180 - 320 m/min

Tooth load: 0.04 - 0.14 mm/tooth



For Your Sawing Solution

Standard Specifications

Ø mm	Cutting width	Blade body	Central bore	Pinholes	Standard dimensions						
					z100	z120	z130	z140	z150	z160	z170
400	3.6	3.20	50	4/16/80	*	*	*	*			
425	3.6	3.20	50	4/16/80		*	*	*			
450	3.6	3.20	50	4/16/80		*	*	*		*	
500	3.6	3.20	50	4/16/80		*	*	*		*	*
550	3.6	3.20	80	4/23/120		*		*	*	*	*
			90	3/12.5/160		*		*	*	*	*
			140	4/17.5/170		*		*	*	*	*
560	3.6	3.20	80	4/23/120		*		*	*	*	*
			90	3/12.5/160		*		*	*	*	*
			140	4/17.5/170		*		*	*	*	*
600	3.6	3.20	80	4/23/120				*	*	*	*
			90	3/12.5/160				*	*	*	*
			140	4/17.5/170				*	*	*	*
630	3.6	3.20	80	4/23/120				*		*	
			90	3/12.5/160				*		*	
			140	4/17.5/170				*		*	
650	3.6	3.20	80	4/23/120					*		*
690	3.6	3.20	80	4/23/120					*		*

Maxima Series for orbital cutting

MAXIMA OF

Suitable for orbital flying cut-off machines.

Special PVD coating for high wear resistance and very strong teeth to withstand shock are the key features of this product.

Can be resharpen.

Application : All tube mills with orbital cutting for round and square pipes like Nakata, Fusakabe, Oto Mills, SMS Meer.

Parameters : Cutting speed: 200 - 600 m/min
Tooth load: 0.04 - 0.12 mm/tooth



For Your Sawing Solution

Standard Specifications

Ø mm	Cutting width	Blade boby	Central bore	Pinholes	Standard dimensions						
					z44	z52	z60	z70	z80	z90	z100
300	3.8	3.00	80	4/23/120	*	*					
315	3.5	2.70	50	4/16/80+4/13/90		*	*	*	*	*	
315	3.8	3.00	50	4/16/80+4/13/90		*	*	*	*	*	
350	2.9	2.25	45	4/17/120		*	*	*	*	*	*
350	3.5	2.90	50	4/16/80+4/13/90		*	*	*	*	*	*
350	3.8	3.00	50	4/16/80+4/13/90		*	*	*	*	*	*
355	2.9	2.25	45	4/17/120		*	*	*	*	*	*
355	3.5	2.90	50	4/16/80+4/13/90		*	*	*	*	*	*
380	3.8	3.00	115	2/21/200		*	*	*	*	*	*
400	3.8	3.00	115	2/21/200							*

Maxima Series for solid cutting

MAXIMA LS

Cermet saw blade for cutting solid carbon steel on sawing machines like Tsune, Bekamak, Noritake, Mega, Everising and Delta.

Application: Cutting solid steel bars up to 750 N/mm²

Parameters: Cutting speed: 100 - 130 m/min

Tooth load: 0.04 - 0.1 mm/tooth

MAXIMA LSC

Coated cermet blades for longer blade's life, low noise and smooth surface.

Application : Cutting solid steel bars up to 900 N/mm²

Parameters : Cutting speed: 100 - 200 m/min

Tooth load: 0.04 - 0.14 mm/tooth



For Your Sawing Solution

MAXIMA HS

Coated tungsten carbide tipped saw blades to achieve both high cutting speed and feeding rate.

Application : Cutting solid carbon steel and alloys solid bars on sawing machines like Ficep, Amada, Behringer, Simec, Bekamak and Kasto.

Parameters : Cutting speed: 100 - 280 m/min

Tooth load: 0.06 - 0.1 mm/tooth

MAXIMA HS PLUS

Coated tungsten carbide tipped saw blade specially designed for cutting stainless steel and titanium solid bars.

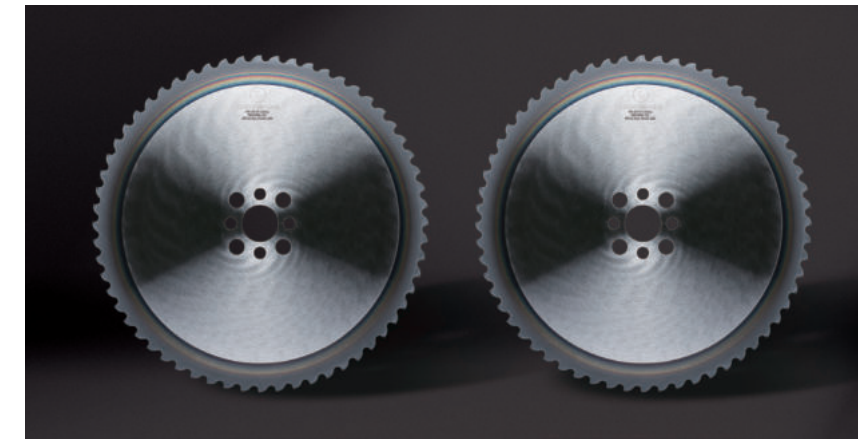
Application : Cutting solid stainless steel and titanium solid bars on sawing machines like Ficep, Amada, Behringer, Simec, Bekamak and Kasto.

Parameters : Cutting speed: Stainless steel 50 - 120 m/min

Titanium 50 - 100 m/min

Tooth load: stainless steel 0.05 - 0.1 mm/tooth

Titanium 0.03 - 0.06 mm/tooth



 Standard Specifications

Ø mm	Cutting width	Blade boby	Central bore	Pinholes	Standard dimensions							
					z40	z60	z72	z80	z100	z120	z130	z140
250	2.0	1.70	32	4/9/50+4/11/63		*	*	*	*			
		1.75	40	2/15/80+4/12/64		*	*	*	*			
285	2.0	1.70	32	2/9/50+4/11/63		*	*	*	*			
		1.75	40	2/12/80+2/15/80		*	*	*	*			
315	2.3	2.0	32	4/11/63		*	*	*	*			
			40	2/15/80+4/12/64		*	*	*	*			
	2.5	2.25	32	4/9/50		*	*	*	*			
360	2.6	2.25	32	4/11/63		*		*	*			
			40	2/11/63+2/15/80+4/12/90		*		*	*			
			50	4/16/80		*		*	*			
420	2.6	2.27	40/50	2/15/80		*		*	*			
425	2.7	2.25	50	4/16/80+4/12/90		*		*	*			
450	2.8	2.25	50	4/16/80		*		*	*			
460	2.7	2.25	50	4/16/80+4/12/90	*	*		*	*			

Other dimensions up to 830mm on request

 Machines table

STATIONARY SAWING MACHINE MODEL AND SAWBLADE SIZE					
Machine			Sawblade dimensions		
BRAND	MODEL	PINHOLES	D	B/b	d
Adige	CM502-CM512	4/11/63	350	2.6/2.25	32
	CM 601-EM80-BC 80	4/11/63	350	2.6/2.25	32
	CM 602	4/12/64	360	2.6/2.25	40
Amada	CM 65 AN	4/11/80	285	2.0/1.75	40
	CM 75 CNC	4/11/80	285	2.0/1.75	40
	CM 100 AN	4/11/90	360	2.6/2.25	40
	CM 100 CNC	4/11/90	360	2.6/2.25	40
	CM 150 AN	4/11/90	460	2.7/2.25	50
Anderson	NCB-65	4/11/63	280	2.0/1.75	32
	NCB-100	4/11/90	360	2.6/2.25	40
Behringer-Eisele	HCS 70	2/15/80	250	2.0/1.75	40
	HCS 70	2/15/80	285	2.0/1.75	40
	HCS 70	2/15/80	315	2.3/2.0	40
	HCS 90	2/15/80	285	2.0/1.75	40
	HCS 90	2/15/80	315	2.3/2.0	40
	HCS 90	2/15/80	360	2.6/2.25	40
	HCS 130	2/15/80	315	2.3/2.0	40
	HCS 130	2/15/80	360	2.6/2.25	40
	HCS 130	2/15/80	420	2.7/2.25	40
	HCS 150	2/15/80	360	2.6/2.25	40
	HCS 150	2/15/80	425	2.7/2.25	40
	HCS 150	2/15/80	460	2.7/2.25	40
Bekamak	75 XS	2/11/63	285	2.0/1.75	32
	100 XS	2/16/80	360	2.6/2.27	40
	130 XS	2/16/80	425	2.6/2.27	40
	150 XS	2/16/80	460	2.7/2.27	40
	300 XS	4/27/160	850	4.2/3.6	80
Bewo	ECH108	4/12/64	250	2.0/1.75	40
Bewo	DCH76	4/12/64	350	2.6/2.25	40

For Your Sawing Solution

Machine			Sawblade dimensions		
BRAND	MODEL	PINHOLES	D	B/b	d
Daito/Delta	P-65A	4/11/80	285	2.0/1.75	40
	P-100A	4/11/90	360	2.6/2.25	40
Endo	HS-36 (SS 36)	4/16/80	360	2.6/2.25	50
Everising	P-65A	4/11/63	250	2.0/1.7	32
	P-65A/P-70B	4/11/63	285	2.0/1.75	32
	P-100A/B	4/11/90	360	2.6/2.25	40
	P-150A/B	4/13/90	460	2.7/2.25	50
Exact - Cut	MAC 60	4/9/50	250	2.0/1.75	32
	MAC 60	4/9/50	285	2.0/1.75	32
Fong Ho	THC-70NC	4/11/63	250	2.0/1.75	32
	THC-70NC/ B90NC	4/11/63	285	2.0/1.75	32
	THC-B90NC	4/11/63	315	2.3/2.0	32
	TAC-1 30NC	4/15/80	360	2.6/2.25	50
	TAC-130NC	4/15/80	425	2.7/2.25	50
	TAC-165NC	4/21/90	460	2.7/2.25	50
I.T.E.C.	DC 65	4/9/50	285	2.0/1.75	32
	DC 85	4/11/63	360	2.6/2.25	40
Kaltenbach	KMR 100 AP	4/15/80	360	2.6/2.25	50
Kasto (Wagner)	WA C7	4/9/50	250	2.0/1.7	32
	WA C7	4/9/50	285	2.0/1.7	32
	Speed C9	4/9/50	250	2.0/1.7	32
	Speed C9	4/9/50	285	2.0/1.7	32
	Speed C9	4/9/50	315	2.5/2.25	32
	Gripspeed C10	4/11/90	360	2.6/2.25	40
	Vario/Speed C14/C15	4/15/80	360	2.6/2.25	50
	Vario/Speed C14/C15	4/15/80	425	2.7/2.25	50
	Vario/Speed C14/C15	4/15/80	460	2.7/2.25	50
	Vario/Speed C14/C15	4/15/80	460	2.7/2.25	50
Kentai	KTC-65	4/11/63	250	2.0/1.75	32
	KTC-85	4/11/63	315	2.3/2.0	32
Mega	CS65	4/11/63	285	2.0/1.75	32
	CS100	4/11/90	360	2.6/2.25	40
	CS150	4/11/90	460	2.7/2.25	50
Missler	CS4	4/11/90	360	2.6/2.25	40
Nishijima	NHC-050 NA	4/11/63	250	2.0/1.7	32
	NHC-070 NA	4/11/63	285	2.0/1.7	32
	NHC-100 NA	4/16/80	360	2.6/2.25	50
	NHC-150 NA	4/21/90	460	2.7/2.25	50
	NHC-180 NA	4/21/120	560	3.0/2.5	50
Noritake	NCS-2/50	2/11/63	240	2.0/1.75	32
	NCS-5/50	4/11/63	240	1.5/1.25	32
	NCS-2/65	2/11/80	280	2.0/1.75	40
	NCS-2A/ 70	4/11/80	285	2.0/1.75	40
	NCS-2A/ 100	4/11/90	360	2.6/2.25	40
	NCS-2/ 150	4/11/90	460	2.7/2.25	50
Plantool	QCS 15/210	4/12/64	250	2.0/1.75	40
	QCS 15/210	4/12/64	315	2.3/2.0	40
Rattunde	ACS 90/2	4/16/80	360	2.6/2.25	50
Rhobi	KTC-65CNC	4/11/63	250	2.0/1.75	32
	KTC-65CNC	4/11/63	285	2.0/1.75	32
	KTC-85CNC	4/11/63	315	2.3/2.0	32
RSA	SC / SK	4/12/64	315	2.3/2.0	40
	CC90	4/12/64	315	2.3/2.0	40
	CC150 / SH150	4/15/80	460	2.7/2.25	50
	S100	4/15/80	360	2.6/2.25	50
	XXL	4/15/80	500	2.7/2.25	50
Shyh Hong (Shoma)	KD-65	4/11/63	280	2.0/1.75	32
	KD-70	4/11/63	285	2.0/1.75	32
	KD-100	4/11/90	360	2.6/2.25	40
Simec	SIMAX 100	4/16/80	360	2.6/2.25	50
	SIMAX 150	4/21/90	460	2.7/2.25	50
Sinico	TOP 2000	4/16/80	350	2.6/2.25	32
Trennjager	SPA75	4/11/63	280	2.0/1.75	32
	SPA100	4/11/90	360	2.6/2.25	40
	SPA150	4/11/90	460	2.7/2.25	50
Tsune	TK5C-50GL	4/11/63	250	2.0/1.7	32
	TK5C-70GL	4/11/63	285	2.0/1.7	32
	TK5C-100GL	4/15/80	360	2.6/2.25	50
	TK5C-101GL	4/15/80	360	2.6/2.25	50
	TK5C-101GL	4/15/80	425	2.7/2.25	50
Webo	DB-70	4/11/63	250	2.0/1.7	40
	DB-70	4/11/63	315	2.3/2.0	40

HSS COLD SAW BLADES

HSS circular saw blades are mainly used in the fields of carbon steel, alloy steel, stainless steel, cast iron and non-ferrous pipes, bars, sections in normal cutting temperature.

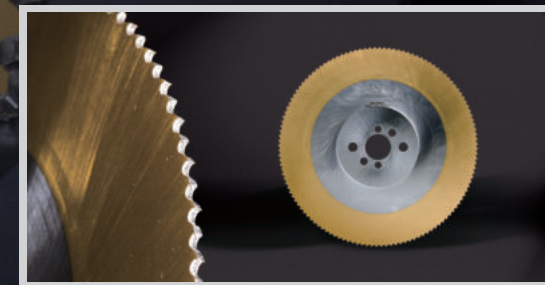
It is widely used in the fields of machinery, automobile metallurgy etc. and can be used both in the production online and offline cutting to size. It is a good substitute cutting tools for traditional band saw and shearing cutting etc.

Available high speed steel: HSS-DMo5 and HSS-Co5.

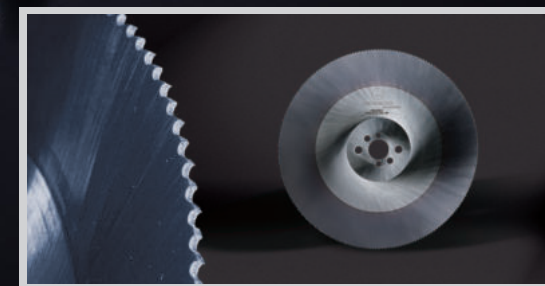
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• GoldTeK

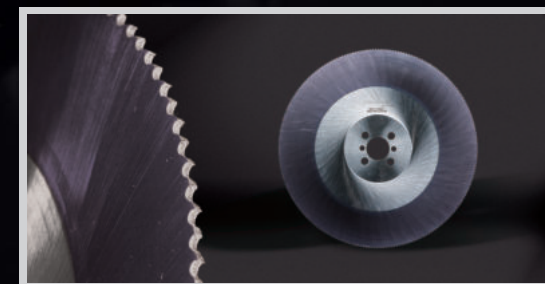
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• PowerTeK



• EdgeTeK

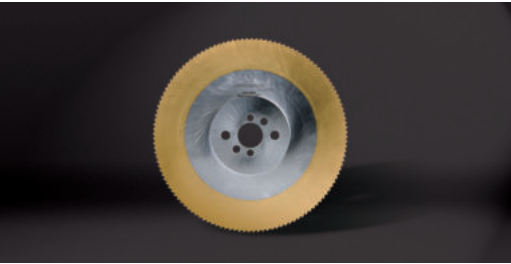


HSS cold saw blade

PVD Coatings

Applied for cutting pipes, bars and profiles of carbon steel, alloy steel, stainless steel and non-ferrous metal etc.

GoldTek

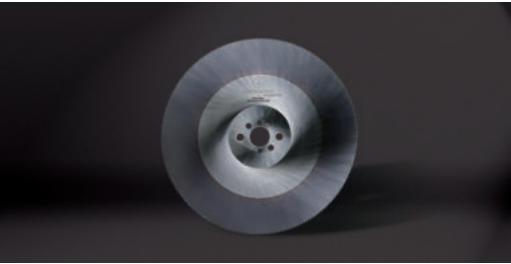


APPLICATIONS: tubes, profiles and solids with a tensile strength up to 650 N / mm²

CUTTING PARAMETERS: 60 - 150 m/min. Feed: 0.03 - 0.1 mm/tooth.

MACHINES: Manual, semi-automatic and auto-matic

PowerTek

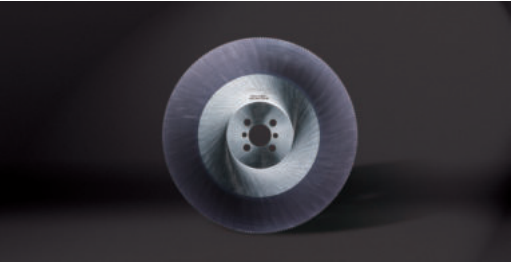


APPLICATIONS: All structural steel, non-alloy tool steel and stainless steel.

CUTTING PARAMETERS: 30 – 230 m/min. Feed: 0.02 – 0.18 mm/tooth

MACHINES: Semi-automatic, automatic and fly cut-off

EdgeTek



APPLICATIONS: Medium to high tensile (carbon) steel and stainless steel

CUTTING PARAMETERS: 40 – 240 m/min. Feed: 0.02 – 0.18 mm/tooth

MACHINES: Semi-automatic, automatic and fly cut off

For Your Sawing Solution

Coatings	Silvertek	Nitrotek	Goldtek	Powertek	Edgetek
Surface hardness (Hv)	900	900	2400	3300	3500
Oxidation temperature (°)	350	350	600	500	800
Friction coefficient	0.55	0.6	0.4	0.2	0.3

PVD coating choice

Materials	Silvertek	Nitrotek	Goldtek	Powertek	Edgetek
Steel 500 N/mm ²	③	③	②	②	①
Steel 800 N/mm ²		③		①	①
Steel 1200 N/mm ²				②	①
Stainless steel				①	①
Inconel				②	①
Titanium				②	①
Cast iron				②	①
Aluminium	③			①	②
Brass	③			①	②
Copper	③			①	②
Zink alloy				②	①

① Highest blade life ② Medium blade life ③ Working alternative

 Standard Execution

Ø	THICKNESS	CENTRAL BORE	HUB	STANDARD SIDE RUN- OUT	PRIME SIDE RUN- OUT	NUMBER OF TEETH AND TOOTH FORM													
						T3	T4	T4.5	T5	T5.5	T6	T7	T8	T9	T10	T12	T14	T16	T18
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	BW	BW	BW	BW	BW	HZ	HZ	HZ	HZ	HZ	HZ	HZ	HZ	HZ
200	1.0	32	100	0.15	0.10	200	160	140	130	120	100	90	80	70	60				
200	1.2	32	100	0.15	0.10	200	160	140	130	120	100	90	80	70	60				
200	1.5 / 1.6	32	90	0.15	0.10	200	160	140	130	120	100	90	80	70	60				
200	1.8	32	90	0.15	0.10	200	160	140	130	120	100	90	80	70	60				
200	2.0	25.4 / 32	90	0.15	0.10	200	160	140	130	120	100	90	80	70	60				
225	1.2	32	100	0.15	0.10	220	180	160	140	128	120	100	90	80	70	60			
225	1.5 / 1.6	32	100	0.15	0.10	220	180	160	140	128	120	100	90	80	70	60			
225	2.0	25.4 / 32 / 40	100	0.15	0.10	220	180	160	140	128	120	100	90	80	70	60			
250	1.2	25.4 / 32	100	0.15	0.10	250	200	180	160	140	128	110	100	90	80	66			
250	1.5 / 1.6	32	100	0.15	0.10	250	200	180	160	140	128	110	100	90	80	66			
250	2.0	25.4 / 32 / 40	100	0.15	0.10	250	200	180	160	140	128	110	100	90	80	66			
250	2.5	25.4 / 32 / 40	100	0.15	0.10	250	200	180	160	140	128	110	100	90	80	66			
250	3.0	32 / 40	100	0.15	0.10	250	200	180	160	140	128	100	100	90	80	66			
275	1.2	32	100	0.15	0.10	280	220	200	180	160	140	120	110	96	90	70	60		
275	1.6	32 / 40	100	0.15	0.10	280	220	200	180	160	140	120	110	96	90	70	60		
275	2.0	32 / 40	100	0.15	0.10	280	220	200	180	160	140	120	110	96	90	70	60		
275	2.5	25.4 / 32 / 40	100	0.15	0.10	280	220	200	180	160	140	120	110	96	90	70	60		
275	3.0	32 / 40 / 50	100	0.15	0.10	280	220	200	180	160	140	120	110	96	90	70	60		
300	1.6	32 / 40	100	0.15	0.10	300	220	210	180	170	160	140	120	104	90	80	68		
300	2.0	32 / 40	100	0.15	0.10	300	220	210	180	170	160	140	120	104	90	80	68		
300	2.5	32 / 38 / 40	100	0.15	0.10	300	220	210	180	170	160	140	120	104	90	80	68		
300	3.0	32 / 40	100	0.15	0.10	300	220	210	180	170	160	140	120	104	90	80	68		
315	1.6	32 / 40	120	0.2	0.12	300	240	220	200	180	160	140	120	110	100	80	70	60	
315	1.8	32 / 40	120	0.2	0.12	300	240	220	200	180	160	140	120	110	100	80	70	60	
315	2.0	32 / 40	100	0.2	0.12	300	240	220	200	180	160	140	120	110	100	80	70	60	
315	2.5	32 / 40	100	0.2	0.12	300	240	220	200	180	160	140	120	110	100	80	70	60	
315	3.0	32 / 40	100	0.2	0.12	300	240	220	200	180	160	140	120	110	100	80	70	60	
325	2.0	32	100	0.2	0.12	320	250	220	200	190	170	150	128	110	100	80	72	64	
325	2.5	32 / 40	100	0.2	0.12	320	250	220	200	190	170	150	128	110	100	80	72	64	
325	3.0	40	100	0.2	0.12	320	250	220	200	190	170	150	128	110	100	80	72	64	

For Your Sawing Solution

Ø	THICKNESS	CENTRAL BORE	HUB	STANDARD SIDE RUN- OUT	PRIME SIDE RUN- OUT	NUMBER OF TEETH AND TOOTH FORM													
						T3	T4	T4.5	T5	T5.5	T6	T7	T8	T9	T10	T12	T14	T16	T18
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	BW	BW	BW	BW	BW	HZ	HZ	HZ	HZ	HZ	HZ	HZ	HZ	HZ
350	1.8	32 / 40	120	0.2	0.12	350	280	240	220	200	180	160	140	120	110	90	80	70	60
350	2.0	32 / 40	120	0.2	0.12	350	280	240	220	200	180	160	140	120	110	90	80	70	60
350	2.5	32 / 40 / 50	120	0.2	0.12	350	280	240	220	200	180	160	140	120	110	90	80	70	60
350	3.0	32 / 40 / 50	120	0.2	0.12	380	280	260	220	210	190	160	140	120	110	96	80	70	64
370	2.0	32 / 40	120	0.25	0.15	380	280	260	220	210	190	160	140	120	110	96	80	70	64
370	2.5	32 / 40 / 50	120	0.25	0.15	380	280	260	220	210	190	160	140	120	110	96	80	70	64
370	3.0	32 / 40 / 50	120	0.25	0.15	380	280	260	220	210	190	160	140	120	110	96	80	70	64
370	3.5	32 / 40 / 50	120	0.25	0.15	380	280	260	220	210	190	160	140	120	110	96	80	70	64
400	2.2 / 2.5	32 / 40 / 50	130	0.25	0.15		310	280	250	230	200	180	160	140	120	100	90	80	70
400	2.5	32 / 40 / 50	120	0.25	0.15		310	280	250	230	200	180	160	140	120	100	90	80	70
400	3.0	32 / 40 / 50	120	0.25	0.15		310	280	250	230	200	180	160	140	120	100	90	80	70
400	3.5	40 / 50	120	0.25	0.15		310	280	250	230	200	180	160	140	120	100	90	80	70
400	4.0	40 / 50	120	0.25	0.15		310	280	250	230	200	180	160	140	120	100	90	80	70
425	2.5	32 / 40 / 50	120	0.25	0.15		320	300	260	240	220	190	160	150	130	110	90	84	70
425	3.0	32 / 40 / 50	120	0.25	0.15		320	300	260	240	220	190	160	150	130	110	90	84	70
425	3.5	32 / 40 / 50	120	0.25	0.15		320	300	260	240	220	190	160	150	130	110	90	84	70
425	4.0	32 / 40 / 50	120	0.25	0.15		320	300	260	240	220	190	160	150	130	110	90	84	70
450	2.5	40 / 50	130	0.25	0.15		350	320	280	260	230	200	180	160	140	120	100	90	80
450	3.0	40 / 50	130	0.25	0.15		350	320	280	260	230	200	180	160	140	120	100	90	80
450	3.5	40 / 50	130	0.25	0.15		350	320	280	260	230	200	180	160	140	120	100	90	80
450	4.0	40 / 50	130	0.25	0.15		350	320	280	260	230	200	180	160	140	120	100	90	80
500	3.0	40 / 50	130	0.3	0.20		390	350	310	280	260	230	200	170	160	130	110	100	90
500	3.5	40 / 50	130	0.3	0.20		390	350	310	280	260	230	200	170	160	130	110	100	90
500	4.0	40 / 50	130	0.3	0.20		390	350	310	280	260	230	200	170	160	130	110	100	90
525	3.5	50	140	0.3	0.20		410	360	330	300	270	230	200	180	164	130	110	104	90
525	4.0	50	140	0.3	0.20		410	360	330	300	270	230	200	180	164	130	110	104	90
550	3.0	50 / 90 / 140	225	0.3	0.20		440	380	340	310	280	250	220	190	170	140	120	110	90
550	3.5	50 / 90 / 140	225	0.3	0.20		440	380	340	310	280	250	220	190	170	140	120	110	90
550	4.0	50 / 90 / 140	225	0.3	0.20		440	380	340	310	280	250	220	190	170	140	120	110	90
560	3.5	50 / 80 / 140	225	0.3	0.20		450	390	360	320	300	250	220	190	180	140	120	110	90
560	4.0	50 / 80 / 140	225	0.3	0.20		450	390	360	320	300	250	220	190	180	140	120	110	90
600	3.5	50/80/90/140	225	0.3	0.20		460	420	380	340	320	270	240	210	190	160	130	120	100
600	4.0	50/80/90/140	225	0.3	0.20		460	420	380	340	320	270	240	210	190	160	130	120	100
600	4.0	50/80/90/140	225	0.3	0.20		460	420	380	340	320	270	240	210	190	160	130	120	110
630	4.0	80/90/140	225	0.3	0.20		480	430	390	350	320	280	240	220	190	160	140	120	110

Standard Specifications

Central bore	Pinholes
Ø 25.4	-----
Ø 32	2/8/55+2/9/50+2/11/63
Ø 40	2/8/55+4/12/64(Ø ≥425 4/12/64+2/15/80+2/15/100)
Ø 50	4/15/80+4/14/85
Ø 80	4/23/120
Ø 90	3/12.5/160
Ø 140	4/17.5/170

Correct tooth pitch - optimum performance

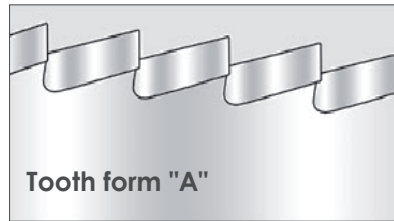
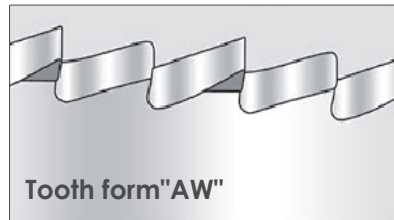
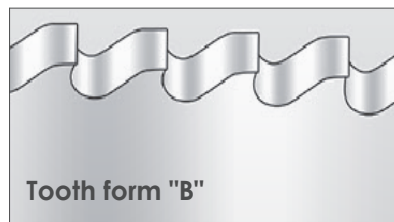
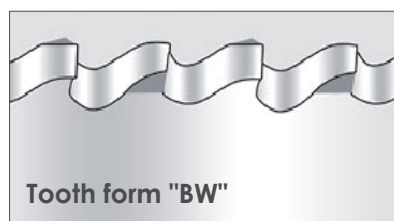
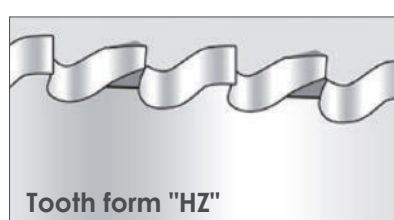
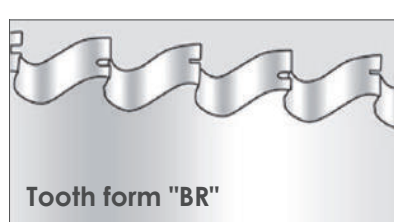
The choice of the right tooth pitch is vital to achieve the optimum performance for metal slitting saw blades in order to cut the relevant cross section combined with the quality of material.

Material	Steel up to 500 N/mm²	Steel up to 800 N/mm²	Steel up to 1200 N/mm²	Stainless steel	Cast iron	Light metal	Copper and Bronze	Brass
Cutting angles	18°/ 12°	15°/ 8°	12°/ 6°	12°/ 6°	10°/ 6°	25°/ 10°	20°/ 10°	15°/ 10°
Solid material diam. (mm)	Tooth pitch T (mm)							
10 - 20	8	6	5	6	6	8	6	8
20 - 40	10	8	6	6	6	10	8	10
40 - 60	12	10	8	8	8	12	10	12
60 - 90	15	13	10	11	11	16	13	14
90 - 110	18	16	12	14	14	18	16	18
110 - 130	22	18	14	16	16	22	18	20
130 - 150	25	20	16	18	18	25	20	22
Pipes and profiles wall thickness (mm)	Tooth pitch T (mm)							
< 1	3	3	3	3	-	4	4	4
1 - 1,5	4	4	3	4	-	5	5	5
1,5 - 2	5	4	4	5	-	6	6	6
2 - 3	6	5	5	5	-	7	7	7
> 3	7	6	5	6	-	8	8	8

The data recommended in this table are intended only as a guide.

For Your Sawing Solution

Tooth forms and tooth geometries

 <p>Tooth form "A"</p>	<p>For thin metal slitting saw blades with a tooth pitch up to approx. 3.0 mm.</p> <p>Advisable for brass, tooth form "A" is suitable for slotting materials.</p>
 <p>Tooth form "AW"</p>	<p>All teeth of tooth form "AW" are bevelled alternatively.</p>
 <p>Tooth form "B"</p>	<p>Suitable for cutting tubes and profiles made of steel or non-ferrous metals.</p> <p>Tooth form "B" is specialized for cutting very thinwalled pipes and profiles.</p>
 <p>Tooth form "BW"</p>	<p>All teeth of tooth form "BW" are bevelled alternatively.</p>
 <p>Tooth form "HZ"</p>	<p>This tooth is also known as form "C". Teeth are ground according to the roughing and finishing tooth system. Tooth form "HZ" is suitable for cutting solid materials or thick [>3mm] pipes.</p>
 <p>Tooth form "BR"</p>	<p>Tooth form "BR" is a "B" tooth with chip breaker. This tooth form is suitable for cutting pipes under high performance conditions on automatic machines .</p>

 Machines table

Type of machine	Sawblade Ø mm	Bore Ø mm	Pinholes mm
ADIGE SALA	200 – 250	32	4-9-50
	275 – 315	32	2-11-63 + 2-9-50
	315 – 350	40	4-12-64
	400 – 425	50	4-15-80
BAIER	175 – 250	32	4 Keyways
BEKAMAK	350	32	2-11-63
	370	32	2-11-63
	285	32	2-11-63
	350	40	2-16-80
	425	40	2-16-80
	450	40	2-16-80
BEWO	200 – 300	32	2-8-45 + 2-11-63
	315	40	2-8-55 + 4-12-63
	350	40	2-8-55 + 4-12-63
BIMAX	100 – 300	32	2-8-45
BONAK	250 – 350	40	2-8-55 + 4-12-64
BROBO WALDOWN	225 – 250	32	2-8-45 + 2-11-63
	300	38	2-9-55
	300 – 400	40	2-8-55 + 4-12-64
	500	40	2-8-55 + 4-12-64 + 2-12-80
CONNI	400 – 425	40	4-11-63
	400 – 500	50	4-15-80
DALLY	250 – 500	40	2-8-55 + 4-12-64 + 2-12-80
DEMURGER	160 – 300	25.4	without pinholes
	200 – 250	32	2-8-45 + 2-11-63
	225 – 350	40	2-8-55 + 4-12-64
DONG JIN	300 – 370	40	2-8-55 + 4-12-64
DORINGER	315 – 350	40	2-12-64
EISELE	110	22	without pinholes
	210 – 220	40	2-8-55
	250 – 350	40	2-8-55 + 4-12-64
	370 – 450	40	2-12-64 + 2-15-80
	500	40	2-12-80 + 2-15-100

Type of machine	Sawblade Ø mm	Bore Ø mm	Pinholes mm
EXACTCUT	250	32	4-9-50
FABRIS	225 – 350	32	2-8-45 + 2-11-63
FEMI	225 – 350	32	2-8-45 + 2-11-63
FONG-HO	250 – 275	32	2-8-45 + 2-9-50 + 2-11-6
	300 – 400	32	4-11-63
	360	40	2-11-63 + 3-11-65
GERNETTI	315	40	4-11-63
	350	50	4-15-80
	500	50	4-18-100
HÄBERLE	225	32	2-8-45
	225 – 275	40	2-8-55
	300 – 450	40	2-8-55 + 4-12-64
IBP	200 – 350	32	2-11-63
PEDRAZZOLI	425 – 500	50	4-15-80
IMET	250 – 350	32	2-8-45 + 2-11-63 + 2-8-55
	315 – 350	40	4-12-64
KALTENBACH	225 – 250	32	without pinholes
	350 – 450	50	4-15-80
KASTO	425	50	4-15-80
KOSOKU	250	32	2-9-50 + 2-8-45
	275	45	2-11-66
	360 – 380	45	4-11-66
MAC	300	32	2-9-50
	370 – 450	40	4-11-63
MACC	225 – 350	32	2-8-45 + 2-11-63
	350 – 450	40	2-8-55 + 4-12-64
MACO	350 – 425	50	4-15-80
MAIR	300 – 350	32	2-8-45 + 2-11-63
	300 – 350	40	2-8-55 + 4-12-64
MEP	225 – 350	32	2-8-45 + 2-11-63

For Your Sawing Solution

Type of machine	Sawblade Ømm	Bore Ømm	Pinholes mm
METORA	250 – 350	32	2-11-80
MBM MERCURY	300 – 350	32	without pinholes
MTM	300	32	2-8-45
	400	40	4-12-64
	400	50	4-15-80
	450	90	3-13-160
	550	80	3-13-160
	550	90	3-13-160
OMES	225 – 370	32	2-8-45 + 2-11-63
OMP	250 – 370	32	2-8-45 + 2-11-63
	400 – 525	50	4-15-80
OTO MILLS	500	50	4-15-80
	550	140	4-20-170
PEDRAZZOLI	250 – 315	32	4-11-63
	300 – 350		without pinholes
RATTUNDE	400	50	4-15-80
RAYGOR	225 – 350	32	2-8-45 + 2-11-63
	300	38	2-9-55
	250 – 370	40	2-8-55 + 4-12-64
RGA	225 – 275	25.4	without pinholes
	250 – 370	40	2-8-55 + 2-11-63
ROBEJO	250 – 350	32	2-8-45 + 2-12-64
ROHBI TSUNE	175 – 300	32	2-8-45 + 2-11-63
	285	32	4-9-50
	420	50	4-15-80
RSA	200	32	2-11-63
	315	40	4-12-64
	315	40	4-12-64
	370	32	2-11-63
	450	50	4-15-80
	350	50	4-15-80
RURACK	500	50	4-15-80
	225	32	2-8-45 + 2-11-63
	250 – 315	32	2-8-45 + 4-9-50 + 2-12-84
	370	40	4-12-64 + 2-15-80
	300 – 350	40	2-8-55-4-12-64

Type of machine	Sawblade Ømm	Bore Ømm	Pinholes mm
SCOTCHMAN	250– 300	32	2-8-45 + 2-11-63
	275– 350	40	2-8-55 + 4-12-64
SIMEC	250 – 350	32	2-8-45 + 2-11-63
SINICO	350	32	2-8-45 + 2-11-63
SOCO	250 – 350	32	2-8-45 + 2-11-63
STARTRITE	250	32	2-9-56 + 2-12-64
	300 – 315	32	2-11-80
STAYER	225	32	without pinholes
	300 – 350	32	without pinholes
THOMAS	225– 350	32	2-8-45 + 2-11-63
TOMET	225– 350	32	2-8-45 + 2-11-63
TRENNJAEGER	250	32	2-9-50
	250–315	40	4-11-63
	315– 450	50	4-14-85
ULMIA	160– 300	32	without pinholes
	250 – 400	40	4-11-63
VAI-SEUTHE	560	80	4-23-120
VIEMME	250– 350	32	2-8-45 + 2-11-63
	250– 400	40	2-8-55 + 4-12-64
VOUCHER	275	35	2-13.5-57.2
WAGNER	200–315	32	4-9-50
	350	50	4-15-80
WAHLEN	250– 400	40	2-8-55 + 2-11-63
WEIDMAN	210– 275	32	2-8-45 + 2-11-63
WINTER	250–315	40	2-8-55 + 4-12-64
WUNSCH	210– 250	32	2-8-45 + 2-11-63
	210– 300	40	2-8-55 + 4-12-64
	315– 400	40	2-8-55 + 4-12-64

SEGMENTAL SAW BLADES

Optimum tempered HSS segments as well as precise manufactured steel bodies are the basis for the LINDEMANN high speed segmental saw blades.

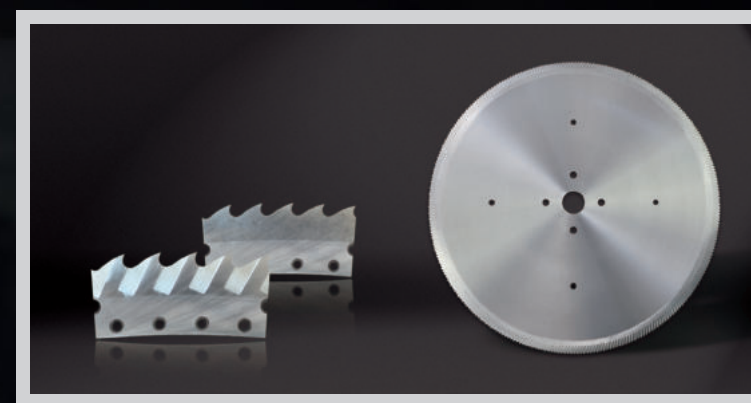
- Precise tensioning and straightening is LINDEMANN know-how.
- Side cutting clearance ensures best cutting.
- The tooth geometry is adapted according to the function of cutting.
- High precision of the segments guarantees competent repairing.

Available high speed steels: HSS-DMo5 and HSS-Co5

CONTENTS

• Standard segmental saw blades

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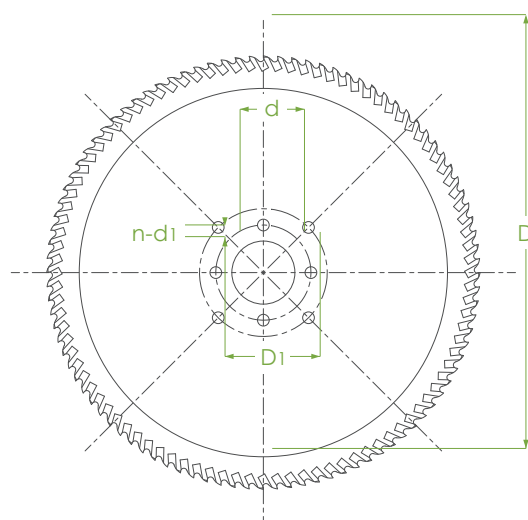
• R/T segments saw blades

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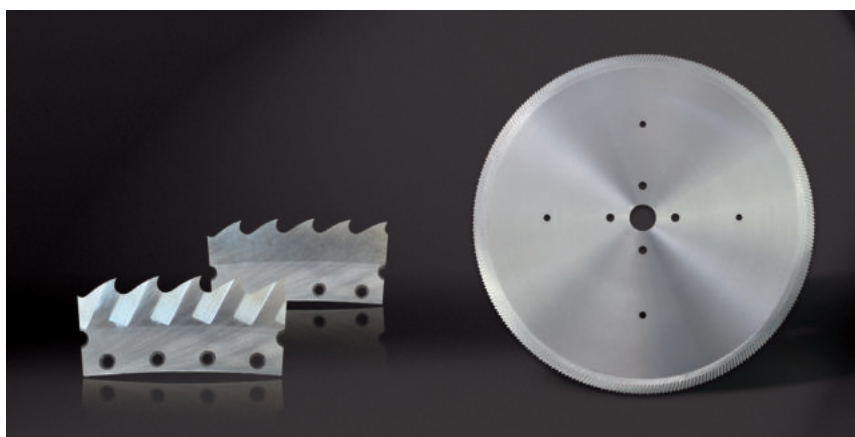


Standard segmental saw blades

VS = Roughing tooth
NS = Finishing tooth
S = Width of cut
S1 = Width of roughing tooth
E = Thickness of saw body
T = Tooth pitch
SW = Rake angle
FW = Clearance angle
α = Chamfer of rake angle
h = High-Low difference (table below)
t = Tooth depth
r = Gullet radius
R = Tooth back radius
X = Limit of resharpening



Tooth pitch in (mm)	4.5 – 8.5	8.6 – 16.5	16.6 – 28.5	28.6 – 48.5	48.6 – 88.8
High - Low difference in (mm)	0.20 – 0.30	0.25 – 0.35	0.40 – 0.50	0.50 – 0.60	0.60 – 0.70



For Your Sawing Solution

Complete delivery program

Diameter Ø mm	Kerf thickness mm	Body thickness mm	Number of segments	Weight kg	Teeth Number	Number of teeth per segment										HSS-segments available in	
					Pitch	2	3	4	5	6	8	10	12	DMo5	EMo5 Co5		
					T=mm												
315	3.6	3.0	14	1.7	Z T			56 17.7	70 14.1	84 11.8	112 8.8	140 7.1	168 5.9	D			
360	3.6	2.8	16	2.5	Z T			64 17.7	80 14.1	96 11.8	128 8.8	160 7.1	192 5.9	D			
370	3.6	2.8	16	2.6	Z T			64 18.2	80 14.5	96 12.1	128 9.1	160 7.3	192 6.1	D			
400	4.0	3.2	16	2.8	Z T			64 19.6	80 15.7	96 13.1	128 9.8	160 7.9	192 6.5	D	E		
425	4.0	3.2	18	3.4	Z T			72 18.5	90 14.8	108 12.4	144 9.3	180 7.4	216 6.2	D	E		
450	4.0	3.3	18	4.0	Z T			72 19.6	90 15.7	108 13.1	144 9.8	180 7.9	216 6.7	D	E		
460	4.7	3.3	18	5.0	Z T			72 20.1	90 16.1	108 13.4	144 10	180 8	216 7.3	D			
500	5.0	3.8	18	5.8	Z T		54 29.1	72 21.8	90 17.5	108 14.5	144 10.9	180 8.7	216 7.6	D			
520	5.7	4.0	18	6.7	Z T			72 22.7	90 18.2	108 15.1	144 11.3	180 9.1	216 8.1	D			
560	5.0	3.7	18	7.5	Z T			72 24.4	90 19.5	108 16.3	144 12.2	180 9.8	216 8.3	D			
570	5.7	4.0	18	8.8	Z T			72 24.9	90 19.9	108 16.6	144 12.4	180 9.9	240 8.6	D			
630	6.0	4.0	20	10.8	Z T		60 33	80 24.7	100 19.8	120 16.5	160 12.4	200 9.9		D	E		
660	6.0	4.0	20	11.5	Z T		60 34.6	80 25.9	100 20.7	120 17.3	160 13	200 10.4		D			
710	6.0	4.5	24	13.5	Z T		72 31	96 23.2	120 18.6	144 15.5	192 11.6			D	E		
760	6.0	4.5	24	16.5	Z T		72 33.2	96 24.9	120 19.9	144 16.6	192 12.4	240 9.9		D			
800	7.0	5.0	24	19.0	Z T		72 34.9	96 26.2	120 20.9	144 17.5	192 13.1	240 10.5		D			
910	7.0	5.0	30	27.5	Z T	60 47.6	90 31.8	120 23.8	150 19.1	180 15.9	240 11.9			D			
1020	8.3	6.2	30	35	Z T	60 53.4	90 35.6	120 26.7	150 21.4	180 17.8	240 13.4			D			
1120	8.5	6.5	36	50	Z T	72 48.9	108 32.6	144 24.4	180 19.5	216 16.3				D			
1250	9.0	7.0	36	65	Z T	72 54.5	108 36.4	144 27.3	180 21.8	216 18.2	288 13.6			D			
1320	9.0	7.0	36	75	Z T	72 57.6	108 38.4	144 38.4	180 23	216 19.2	288 14.4			D			
1430	9.5	7.0	36	93	Z T	72 62.4	108 41.6	144 31.2	180 25	216 20.8	288 15.6			D			
1510	10.5	8.5	36	112	Z T	72 65.9	108 43.9	144 32.9	180 26.4	216 22				D			
1610	10.5	8.5	40	126	Z T	80 63.2	120 42.1	160 31.6	200 25.3	240 21.1				D	E		
1870	15.0	11.0	42	235	Z T	84 69.9	126 46.6	168 35						D			

More Toothings on Request

Reference Values

for economical use of segmental circular saw blades

Material	Specification	Material	Tensile Strength	Cutting Speed Vc = m/min.	Feed per Tooth fz = mm/z	Cutting Angle	Clearance Angle	HSS Segments 1.3343DMo5=D 1.3243 EMo5Co5=E
Structural Steels	ST33 - 1	1.0033	300 - 500	24 - 40	0.18 - 0.28	18 - 20	7 - 10	D
	ST37 - 3	1.0116	350 - 450	24 - 40	0.18 - 0.28	18 - 20	7 - 10	D
	ST42 - 3	1.0136	400 - 500	18 - 40	0.18 - 0.28	18 - 20	7 - 10	D
	ST50 - 2	1.0050	500 - 600	18 - 40	0.18 - 0.28	18 - 20	7 - 10	D
	ST52 - 3	1 0570	500 - 600	18 - 40	0.15 - 0.25	16 - 20	6 - 9	D
	ST60 - 2	1.0060	600 - 700	18 - 40	0.15 - 0.25	16 - 20	6 - 9	D
Case hardening steels	C15	1.0401	400 - 500	18 - 24	0.15 - 0.25	18 - 20	7 - 9	D
	16MnCr5	1.7131	700 - 750	18 - 24	0.15 - 0.25	18 - 20	7 - 9	D
	20CrMo2	1.7311	700 - 750	18 - 24	0.15 - 0.25	18 - 20	7 - 9	D
Free machining steels	9SMn28	1.0715	400 - 600	18 - 24	0.15 - 0.25	18 - 20	7 - 9	D
	45S20	1.0727	600 - 750	18 - 24	0.15 - 0.25	18 - 20	7 - 9	D
Heat-treatable steels	C35	1.0501	550 - 750	15 - 20	0.12 - 0.25	18 - 20	7 - 9	D
	C60	1.0601	700 - 850	15 - 20	0.12 - 0.25	18 - 20	7 - 9	D
	30Mn5	1.1165	700 - 900	15 - 20	0.12 - 0.25	18 - 20	7 - 9	D
Steel-castings	GS 38	1.0416	380 - 520	20 - 28	0.18 - 0.28	15 - 20	6 - 8	D
	GS-52	1.0551	600 - 700	16 - 22	0.15 - 0.25	15 - 20	6 - 8	D
	GS-60	1.0553	600 - 700	16 - 22	0.15 - 0.25	15 - 20	6 - 8	D
	GS-70	1.0554	600 - 700	16 - 22	0.15 - 0.25	15 - 20	6 - 8	D
Cast iron	GG-15	0.6015	150 - 500	16 - 25	0.18 - 0.28	18 - 20	6 - 8	D
	GG 30	0.6030	600 - 700	15 - 18	0.18 - 0.28	18 - 20	6 - 8	D
	G GG -50	0.7050	600 - 700	15 - 18	0.15 - 0.25	15 - 18	6 - 8	D
	GTW-50	0.8040	600 - 700	15 - 18	0.15 - 0.25	15 - 18	6 - 8	D
	GTS-65	0.8165	600 - 700	15 - 18	0.15 - 0.25	15 - 18	6 - 8	D
Ball bearing steels	100Cr6	1.3505	900 - 1000	10 - 12	0.08 - 0.12	14 - 16	6 - 8	E
	100CrMn6	1.3520	900 - 1000	10 - 12	0.08 - 0.12	14 - 16	6 - 8	E
Spring steels	55Si7	1.0904	1200 - 1400	6 - 10	0.06 - 0.12	12	6	E
	55Cr3	1.7176	1200 - 1400	6 - 10	0.06 - 0.12	12	6	E
Unalloyed tool steels	C75W	1.1750	600 - 700	10 - 12	0.08 - 0.15	14 - 16	6	E
	C80W1	1.1525	600 - 700	10 - 12	0.08 - 0.15	14 - 16	6	E
Alloyed tool steels	125Cr1	1.2002	800 - 900	8 - 12	0.05 - 0.12	12 - 16	6 - 8	E
	X210Cr12	1.2080	800 - 900	8 - 12	0.05 - 0.12	12 - 16	6 - 8	E
	X42Cr13	1.2083	800 - 900	8 - 12	0.05 - 0.12	12 - 16	6 - 8	E
	X165CrV12	1.2201	800 - 900	8 - 12	0.05 - 0.12	12 - 16	6 - 8	E
	32CrMoV3 3	1.2365	800 - 900	8 - 12	0.05 - 0.12	12 - 16	6 - 8	E
	45WCrV7	1.2542	800 - 900	8 - 12	0.05 - 0.12	12 - 16	6 - 8	E
	56NiCrMoV7	1.2714	800 - 900	8 - 12	0.05 - 0.12	12 - 16	6 - 8	E
High speed steels	S-6-5-2-5	1.3243	800 - 900	8 - 12	0.08 - 0.15	13 - 16	6 - 8	E
Valvesteels	X45CrSi9 3	1.4718	900 - 1050	8 - 12	0.10 - 0.15	10 - 12	6	E
	45CrNiW18 9	1.4873	800 - 1000	8 - 12	0.10 - 0.15	10 - 12	6	E
Stainless steels	X10Cr13	1.4006	450 - 650	8 - 12	0.08 - 0.15	16 - 18	6 - 8	E
	X20Cr13	1.4021	700 - 800	8 - 12	0.08 - 0.15	16 - 18	6 - 8	D
Aluminum	Al99,5	3.0255	100 - 300	800 - 2000	0.05 - 0.10	25 - 28	10 - 12	D
	AlMgSiPb	3.0615	100 - 500	200 - 600	0.05 - 0.10	22 - 25	10 - 12	D
	MgAl6Zn	3.5612	100 - 500	200 - 600	0.05 - 0.10	22 - 25	10 - 12	D
Copper Bronze Brass Germansilver	Cu		150 - 200	100 - 300	0.07 - 0.15	20 - 25	10 - 12	D
	CuSn		50 - 150	40 - 120	0.10 - 0.16	18 - 20	8 - 10	D
	CuZn		200 - 400	150 - 300	0.10 - 0.16	10 - 15	8 - 10	D
	CuNi		200 - 400	100 - 200	0.07 - 0.15	20 - 22	10 - 12	D

For Your Sawing Solution

R/T segments saw blades

Segmental circular saw blades R/T

Special segments are ground radial and tangential.

The relief grinding ensures good cutting clearance and avoids side pick-up on the tooth rim.

Solving problems for:

Large cross-sections

Material with residual stress

Large H-beams



Diameter Ø mm	Kerf mm	Body mm	Number of segments	Bore holes and pinholes	Number of teeth Z Tooth pitch T=mm	Coarse II special	Coarse III special	Coarse IV special	Coarse V special
630	6	4	20	80/4/23/120	Z		60	80	100
					T		33	24.7	19.8
710	6	4.5	24	80/4/23/120	Z		72	96	120
					T		31	23.3	18.6
800	7	5	24	80/4/23/120 + 4/27/160	Z		72	96	120
					T		34.9	26.6	20.9
910	7	5	30	80/4/23/120 + 4/27/160	Z	60	90	120	150
					T	47.6	31.8	23.8	19.1
1020	8.3	6.2	30	100/4/32/200	Z	60	90	120	150
					T	53.4	35.6	26.7	21.4
1120	8.5	6.5	36	100/4/32/200	Z	72	108	144	180
					T	48.9	32.6	24.4	19.5
1250	9	7	36	100/4/32/220 + 4/32/250	Z	72	108	144	180
					T	54.5	32.4	27.3	21.8
1320	9	7	36	100/4/32/250 160/8/27/270 + 4/42/315	Z	72	108	144	180
					T	57.6	38.4	28.8	23
1430	9.5	7	36	100/4/32/250	Z	72	108	144	180
					T	62.4	41.6	31.2	25

Correct tooth pitch - optimum cutting process

Decisive for economical cutting, segmental circular saw blades are the right choice of tooth pitch in connection with the dimension of the material and the material quality.

Technical Recommendation: D = dimension of cutting material in mm T = tooth pitch in mm																					
D=		20	30	40	50	60	70			80	90	100	125	150	175	200	250	300	400	500	600
Aluminum Copper Structural Steels Heat-treatable steels Nitriding steels Case hardening steels Steel castings	 T=	8.0	10.5	12.5	14.5	16.5	18.0			19.5	21.0	22.5	26.0	29.5	32.5	35.5	40.5	45.5	55.5	58.0	64.0
Cast iron Spring steels Rolled steels Valve steels Tool steels High speed steels	 T=	6.5	8.0	9.5	11.0	12.0	13.0			14.0	15.0	16.0	18.5	20.5	22.5	24.0	27.0	30.0	36.0	39.0	43.0
Profile of all kinds wall thickness = 0.1 x D	 T=	5.5	6.5	7.5	8.5	9.5	10.5			11.0	11.5	12.0	13.5	15.0	16.5	17.5	19.5	21.5	23.5	25.0	27.0
Profile of all kinds wall thickness = 0.05 x D	 T=	5.0	6.0	7.0	7.5	8.0	8.5			9.5	9.5	10.0	11.0	12.0	12.5	13.0	14.0	15.0	17.0	19.0	21.0
Profile of all kinds wall thickness = 0.025 x D	 T=	4.0	4.5	5.0	5.5	6.0	6.3			6.5	6.8	7.0	7.5	8.0	8.5	9.0	9.5	10.0	11.0	12.0	13.0

The data recommended in this table are intended only as a guide.

RESHARPENABLE TCT CIRCULAR COLD SAWS

TCT circular saw blade is a special cutting tool applied with certain cutting machine. It consists of teeth made by TCT and body made by tool steel. The TCT teeth is brazed onto the saw blank and then grinded into different profiles by grinding machine. It features in high efficiency and long life-time. It is suitable for cutting pipes, sections and rails made of carbon steel, alloy steel, cast iron, copper, and aluminum.

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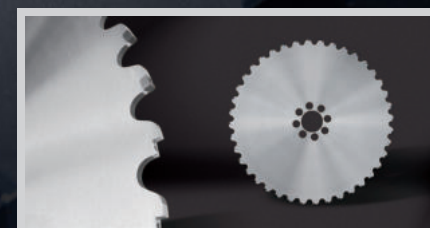
• HM for steel 37/41



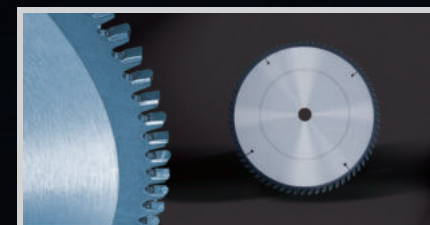
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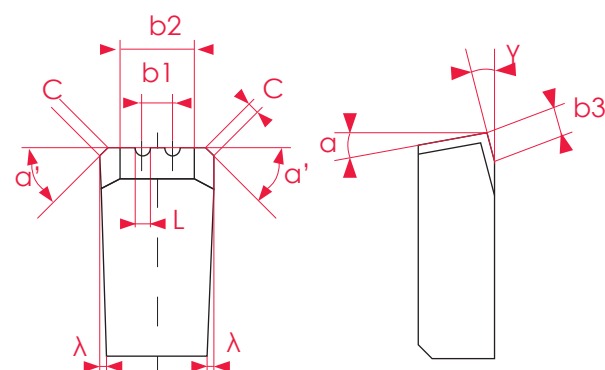


HM for steel

MAXIMA

Heavy-duty circular saw blade for high production

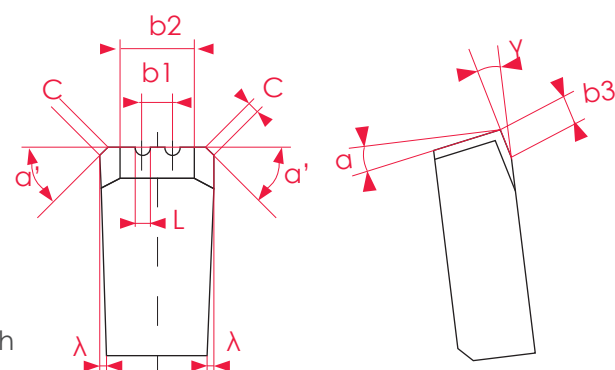
- Tip seat 0°
- Stable tooth back
- Tooth shapes: triple chip or notch-ground
- For materials of approx. 300 - 1400 N/mm² tensile strength
- Standard sawblade design, worldwide approved
- Cutting speed (Vc) 80 - 180 m/min
- Feed rates (fz) 0.06 - 0.16 mm/t



MAXIMA 3000

– For solid material and heavy-wall pipes – For fastest cutting rates

- The all-rounder for high performance sawing machines
- Negative tip seat angle
- Reinforced tooth back
- Tooth shape: notch-ground
- For materials of 300 - 1500 N/mm² tensile strength
- Excellent blade life
- Cutting speed (Vc) 80 - 250 m/min
- Feed rates (fz) 0.08 - 0.18 mm/t

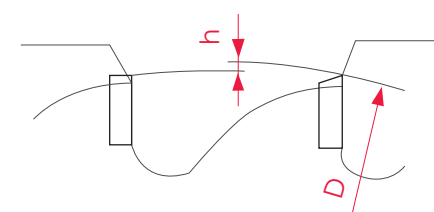
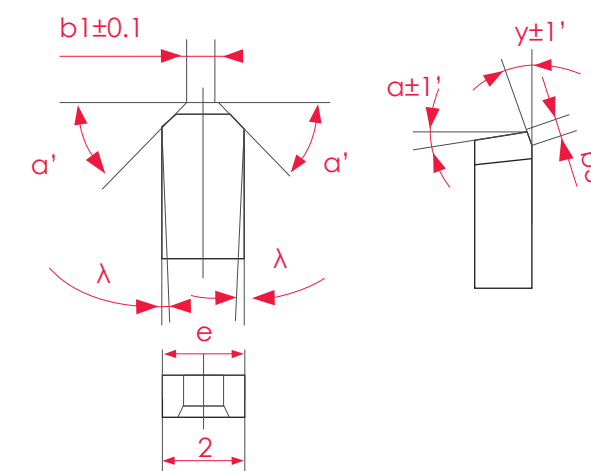
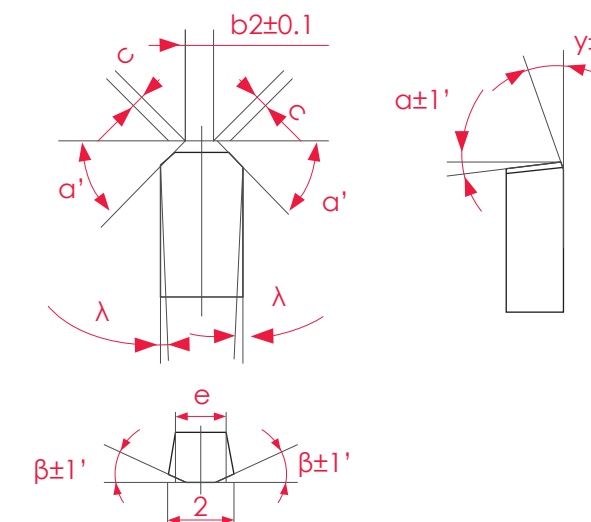
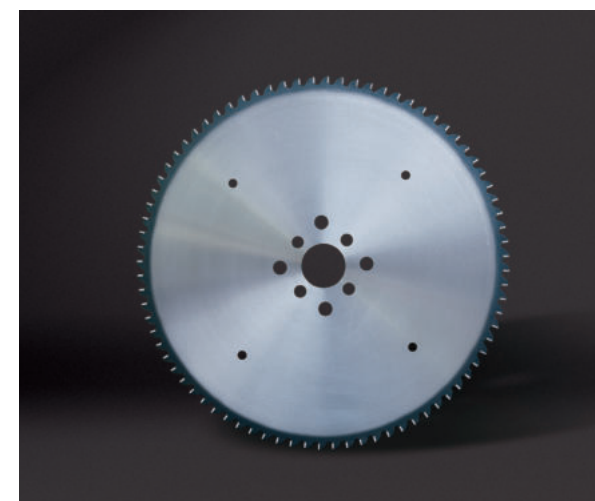
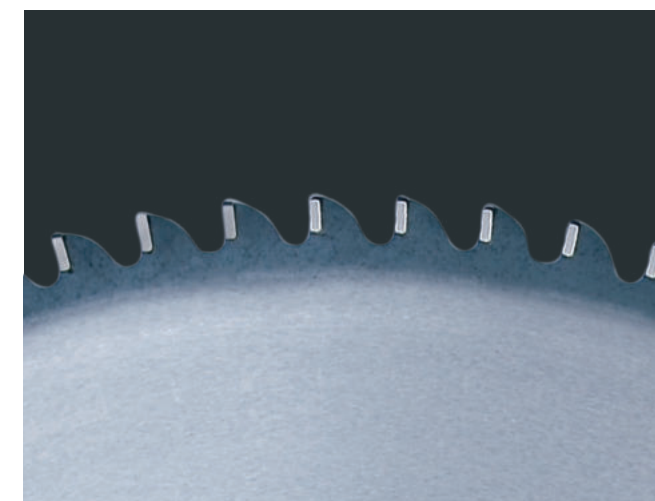


For Your Sawing Solution

MAXIMA RAIL

TCT circular sawblade for cutting hardest railway bars

- High performance circular saw blade for cutting hardest railway bars
- Tooth shape: triple chip geometry
 - Cutting speed (Vc) 80 - 120 m/min
 - Feed rates (fz) 0.08 - 0.12 mm/t



Standard Delivery Program

MAXIMA. MAXIMA RAIL. MAXIMA 3000. MAXIMA X-Plus. MAXIMA Plus

Diameter mm	Kerf Thickness mm	Body Thickness mm	Teeth Number
250	3.5	2.5	48 / 50 / 54 / 60 / 70 / 90
280	3.5	2.5	48 / 50 / 54 / 60 / 70 / 90
315	4.0	3.0	48 / 50 / 54 / 60 / 70 / 90 / 100
350	4.5	3.5	48 / 50 / 54 / 60 / 70 / 90 / 100
360	4.5	3.5	48 / 50 / 54 / 60 / 70 / 90 / 100
400	4.5	3.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120
420	4.5	3.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120
425	4.5	3.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120
450	5.0	4.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120
475	4.5	3.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140
500	5.0	4.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140
560	3.8	2.8	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160
570	5.5	4.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
630	6.5	5.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
660	6.5	5.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
710	6.5	5.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
760	6.5	5.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
800	6.5	5.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
830	6.5	5.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
860	8.0	6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
910	8.0	6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
940	8.0	6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
960	8.0	6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1000	6.0 / 8.0	5.0 / 6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1020	6.5 / 8.0	5.0 / 6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200

For Your Sawing Solution

Diameter mm	Kerf Thickness mm	Body Thickness mm	Teeth Number
1040	6.0 / 8.0	5.0 / 6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1050	8.5	6.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1060	6.0 / 8.0	5.0 / 6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1120	8.0	6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1125	8.0	6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1150	6.5 / 8.0	5.0 / 6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1160	6.5 / 8.5	5.5 / 6.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1250	8.0	6.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1320	9.0	7.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1350	9.0	7.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1370	8.2	6.8	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1430	9.0	7.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1470	9.0	7.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1600	11.0	9.0	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1700	12.5	10.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1720	12.5	10.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1800	12.5	10.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1860	12.5	10.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1900	12.5	10.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
1980	12.5	10.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200
2200	12.5	10.5	48 / 50 / 54 / 60 / 70 / 90 / 100 / 120 / 140 / 154 / 160 / 200

Other diameters and pitches on demand

MAXIMA-X-PLUS

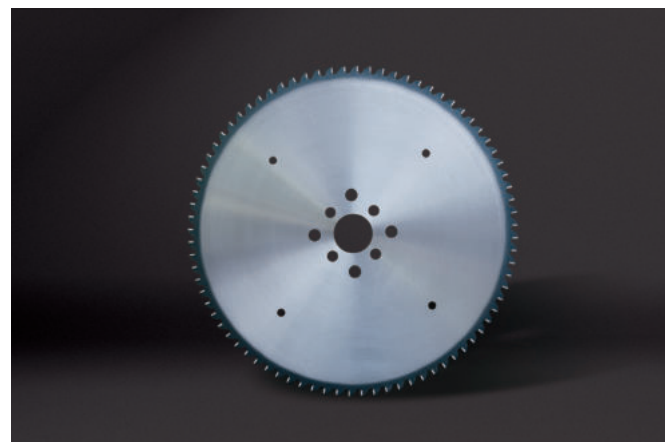
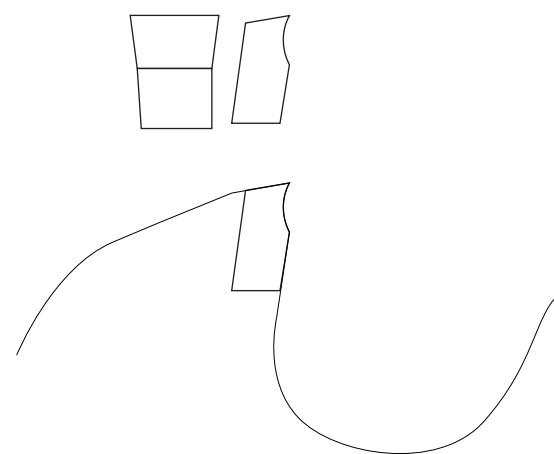
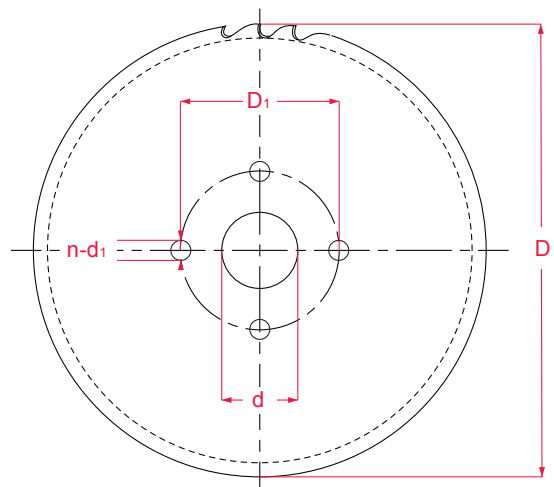
- For solid CrNi-alloys
- For small and medium cross sections

- Tip seat 0°
- Carbide tips with special chip-guide
- Tooth shape: notch-ground
- Minimizing the problematic wear (diffusion) of carbide tips
- Cutting speed (Vc) 60 - 140 m/min
- Feed rates (fz) 0.06 - 0.12 mm/t.

MAXIMA-PLUS

For light and medium wall pipes and profiles

- Positive tip seat angle with specially designed tooth geometry
- Suitable for all advanced and low vibration sawing machines, such as FRAMAG, LINSINGER, MFL, WAGNER
- For clean cutting edges and fast cutting rates
- Cutting speed (Vc) 100 - 160 m/min
- Feed rates (fz) 0.09 - 0.15 mm/t



For Your Sawing Solution

HM for non ferrous material

HM-NE-POSITIV

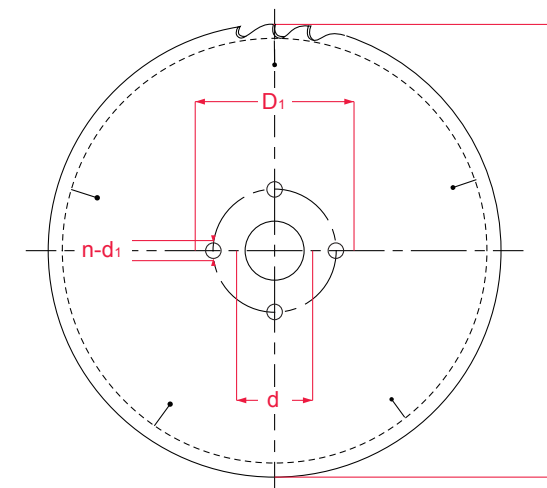
For solid material and profile

- Available saw blades $\varnothing$ 400 - 2250 mm
- Long service life

SUPER-CUT

For solid material

- Copper and copper alloys
- Aluminium and aluminium alloys
- Available saw blades $\varnothing$ 400 - 2200 mm
- Specially ground chip guides provide easier formation of curled chips
- Long service life
- Cutting speed (Vc)
 - for Copper 400 - 800 m/min
 - for Aluminium (soft) 50 - 90 m/sec
 - for Aluminium (hard) 15 - 70 m/sec
- Feed rates (fz)
 - for Copper 0.03 - 0.06 mm/t.
 - for Aluminium (soft) 0.06 - 0.12 mm/t.
 - for Aluminium (hard) 0.03 - 0.06 mm/t.



SUPER-CUT-DS

For solid material

- Copper and copper alloys
- Aluminium and aluminium alloys
- Available saw blades $\varnothing$ 400 - 2200 mm
- Specially ground chip guides provide easier formation of curled chips
- Long service life
- With detension slots
- For low noise cutting
- Application same as "SUPER-CUT"



Standard Delivery Program

Available as HM-NE · Positiv, Super Cut, Super Cut DS, Techno Cut

Diameter mm	Kerf Thickness mm	Body Thickness mm	Bore mm	Teeth Number
400	4.2	3.2	30/32/40/50/60	68/96
420	4.2	3.2	30	96
450	4.4	3.4	30/40	110
500	4.6	3.6	25/30/40/50/80	72/100/120
550	5	4	50/60/80	100
600	5.5	4	40/60/80	42/54/70/72/100/120/160
630	5.5	4	80	42/54/70/80/120
660	5.5	4	80	72
710	6	5	80	80/100/160
760	6.5	5	40/80	72/120
800	6.5	5	40	72/120/140
850	7	6	40	120
950	7.5	6	60	100/160/200/220
1000	7.5	6		100/120/180
1100	7.5	6		60/100/120
1250	8	6.5		60/100/120/140/200
1300	8	6.5		100
1410	10	7.5		60/120/160
1520	10	7.5		60/120/160
1610	12	9		60/120/160
1720	14	10		52/60/120/200
1810	17	11		60
1870	17.5	11		50/60/70
2050	20	12		68
2200	20	14		80
2250	20	15		60

Other diameters and pitches on demand

For Your Sawing Solution

MEGA-CUT

For solid material

MEGA-CUT - the carbide-tipped circular saw blade based on a segmental saw tooth form 2 STS.

This cutting tool combines the high cutting rates of tungsten-carbide with the "easy-repair" features of a segmental saw blade and its low-vibration / low-noise cuts.

The saw blades are available in three different geometric designs:

- A - for Aluminium
- B - for Brass
- c - for Copper

MEGA-CUT saw blades can be used for peripheral cutting speeds up to 2000 m/min

Standard Delivery Program

Dimensions mm	Bore mm	Tooth Number mm	Pitch mm
910 x 7.3	80 4/23/120 + 4/27/160	60	47.6
1020 x 8.6	100 4/32/200	60	53.4
1120 x 8.8	100 4/32/200	72	48.9
1250 x 9.3	100 4/32/250	72	54.5
1320 x 9.3	100 4/32/250	72	57.6
1430 x 9.8	100 4/32/250	72	62.4
1510 x 10.8	100 4/32/250	72	65.9
1610 x 10.8	100	80	63.2
1870 x 15.3	100	84	69.9

TECHNO-CUT

For solid material and profiles

Available for all carbide-tipped circular saw blades.Especially designed for dampening execution. "Spoke-like" laser slots filled with a special permanent-elastic dampening material lead to an enormous reduction of vibration and noise,particularly during cutting operations at high circumference speeds. The shock absorption and dampening of vibrations reduce the wear of the carbide-cutting-edges and therefore, increase the life of saw blade.

Screwed blades

Cutting Workpiece: rails, beams, wheel hubs and forging solids with different materials;

Cutting Temperature: room temperature;

Cutting Machine: sawing machine for rails, beams, wheel hubs and forgings;

Cutting Application: cutting to length;

Blade Material: low alloy tool steel;

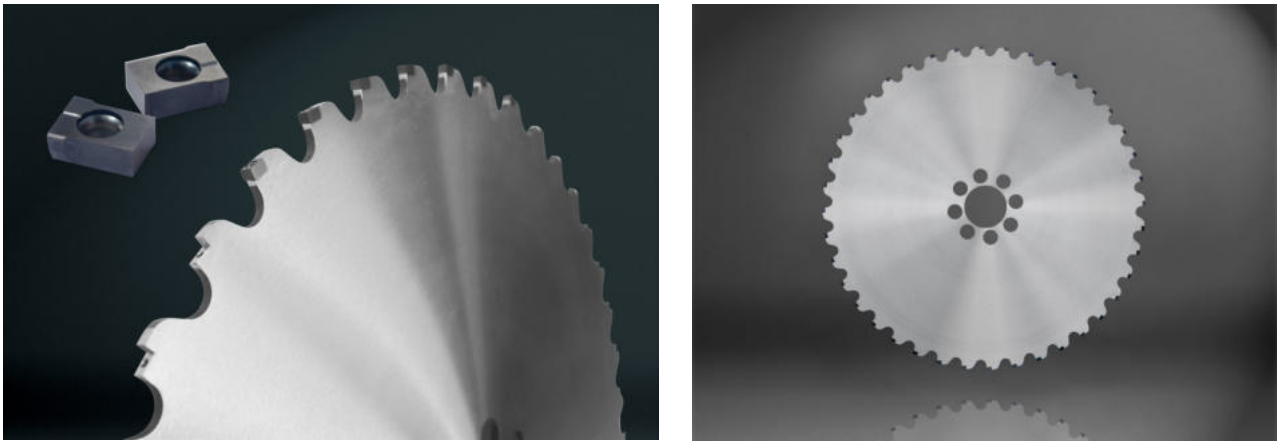
Carbide Material: P25-P40 tungsten carbides;

Main Process: heat-treatment, grinding, leveling, tip seat machining, assembling;

Technical Characteristics: it's equipped with the same sawing machine as brazed type TCT saw blades. Teeth coating improves the cutting lifetime, and is specially designed for cutting hard-processing materials. Compared with brazed type, screwed type avoids the heating on the body during brazing. This will in turn increase the body lifetime. Beside the advantage of fast cutting and high efficacy, screwed type also makes the repair more convenient and easy;

Main Specifications: Φ 660 mm - Φ 1500mm.

For Your Sawing Solution



Standard specifications

Diameter (mm)	Kerf Thickness (mm)	Body Thickness (mm)	Bore (mm)	Teeth Number
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Rails and Beams Screwed Type

660	8.0	7.0	80	60
710	8.0	7.0	80	60

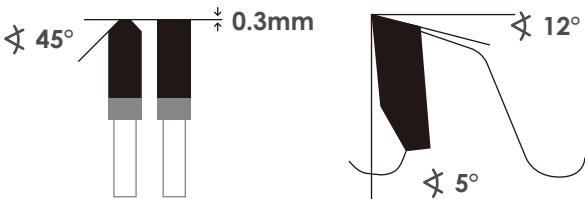
Wheel Hubs Screwed Type

1250	10.5	9.0	100	60
1270	10.5	9.0	100	54/60
1550	10.5	9.0	100	54/60

Alu-Tek

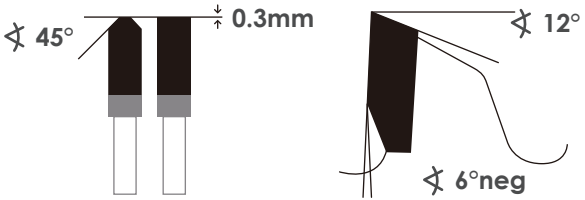
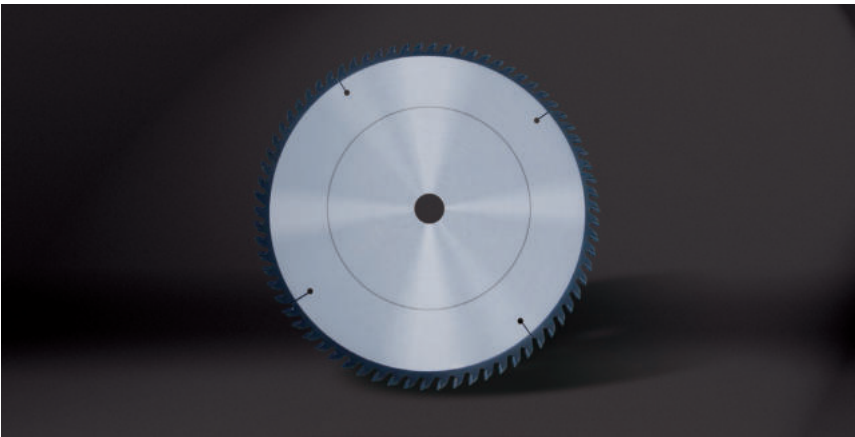
Positive angle

Suitable for cutting full sections in aluminium or non-ferrous solid materials on single or double miter saws with mechanical clamping of the piece.



Negative angle

Suitable for cutting aluminium and non-ferrous profiles on miter saws with manual or mechanical clamping of the piece. Use with the saw blade over the workpiece to be cut is recommended.



For Your Sawing Solution

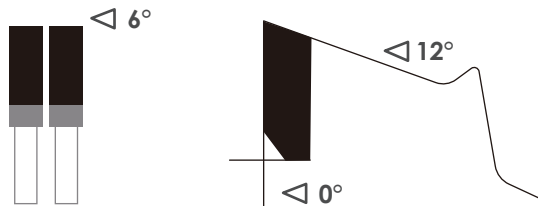
Standard specifications

D (mm)	B/b (mm)	d (mm)	Z	
200	3.0 - 2.0	30	60	
216	3.0 - 2.0	30	60	
250	3.2 - 2.2	30	60	✂
250	3.2 - 2.2	32	60	✂
250	3.2 - 2.2	30	80	✂
250	3.2 - 2.2	32	80	✂
300	3.2 - 2.4	30	72	✂
300	3.2 - 2.4	32	72	✂
300	3.2 - 2.4	30	84	✂
300	3.2 - 2.4	32	84	✂
300	3.2 - 2.4	30	96	✂
300	3.2 - 2.4	32	96	✂
350	3.4 - 2.8	30	84	✂
350	3.4 - 2.8	32	84	✂
350	3.4 - 2.8	30	96	✂
350	3.4 - 2.8	32	96	✂
350	3.4 - 2.8	30	108	✂
350	3.4 - 2.8	32	108	✂
400	3.6 - 2.8	30	96	✂
400	3.6 - 2.8	32	96	✂
400	3.6 - 2.8	30	120	✂

D (mm)	B/b (mm)	d (mm)	Z	
400	3.6 - 2.8	32	120	✂
420	3.8 - 3.0	30	108	✂
420	3.8 - 3.0	32	108	✂
450	3.8 - 3.0	30	96	✂
450	3.8 - 3.0	32	96	✂
450	3.8 - 3.0	30	108	✂
450	3.8 - 3.0	32	108	✂
450	3.8 - 3.0	30	128	✂
450	3.8 - 3.0	32	128	✂
500	4.0 - 3.2	30	120	✂
500	4.0 - 3.2	32	120	✂
500	4.0 - 3.2	30	140	✂
500	4.0 - 3.2	32	140	✂
550	4.2 - 3.5	30	132	✂
550	4.2 - 3.5	32	132	✂
550	4.2 - 3.5	30	148	✂
550	4.2 - 3.5	32	148	✂
600	4.2 - 3.5	30	144	✂
600	4.2 - 3.5	32	144	✂
600	4.2 - 3.5	30	156	✂
600	4.2 - 3.5	32	156	✂

Dry-Tek

Suitable for cutting steel and other ferrous materials on typical dry cut machines and portable saws.



RECOMMENDED SPEED

- Ø 160 - 200 mm = 3500 - 3000 min-1/rpm
- Ø 210 - 250 mm = 2800 - 1900 min-1/rpm
- Ø 260 - 305 mm = 1800 - 1500 min-1/rpm
- Ø 350 - 355 mm = 1500 - 1200 min-1/rpm



For Your Sawing Solution

Standard specifications

D (mm)	B/b (mm)	d	Z
150	2.2 - 1.6	20	26
150	2.2 - 1.6	30	26
160	2.2 - 1.6	20	28
160	2.2 - 1.6	30	28
170	2.2 - 1.6	20	30
170	2.2 - 1.6	30	30
180	2.2 - 1.6	20	32
180	2.2 - 1.6	30	32
190	2.2 - 1.6	30	32
200	2.2 - 1.6	30	34
216	2.2 - 1.6	30	36
220	2.2 - 1.6	30	38
230	2.2 - 1.6	30	40
235	2.2 - 1.6	30	40
240	2.2 - 1.6	30	42
250	2.4 - 1.8	30	48
270	2.4 - 1.8	30	60
300	2.4 - 1.8	30	60
300	2.4 - 1.8	30	80
305	2.2 - 1.8	25.4	60
305	2.2 - 1.8	25.4	80
355	2.4 - 2.0	25.4	72
355	2.4 - 2.0	25.4	90

Metal cold-cutting & hot-cutting circular saw blade

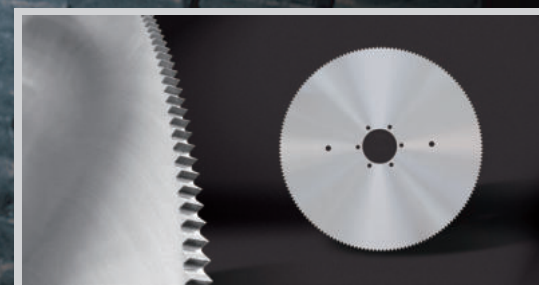
For metallurgical cutting applications, friction saws, metal cold-cutting and hot-cutting circular saw blades are the primary and traditional products utilized by A.LINDEMANN.

Through our heat treatment and machining processes, we are able to produce cold saws and hot saws made of high quality tool steel and low carbon alloy steel. A. LINDEMANN is able to produce saws with excellent mechanical properties. They are easy to use, have a wide range of applications and lower the cost of cutting. Our saws are widely used in cutting steel bars, pipes, as well as sections of different materials.

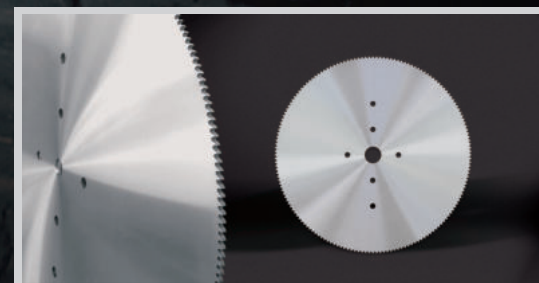
In recent years A. LINDEMANN has been engaged in continuous research and development, focusing on the body material, tooth profile as well as blade structure. This research has brought us remarkable achievements in the performance of our saw blades.

CONTENTS

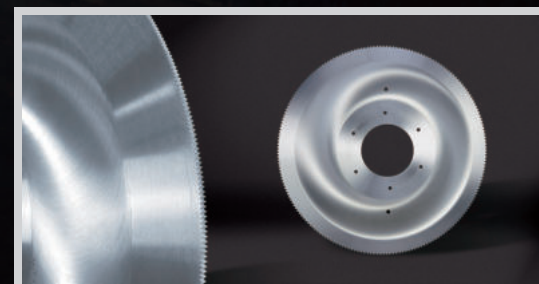
• Metal cold-cutting circular saw blades 53/54



• Metal hot-cutting circular saw blades 55/56

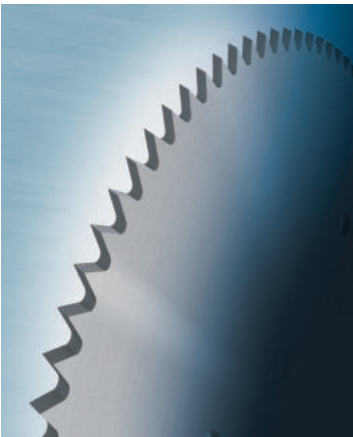
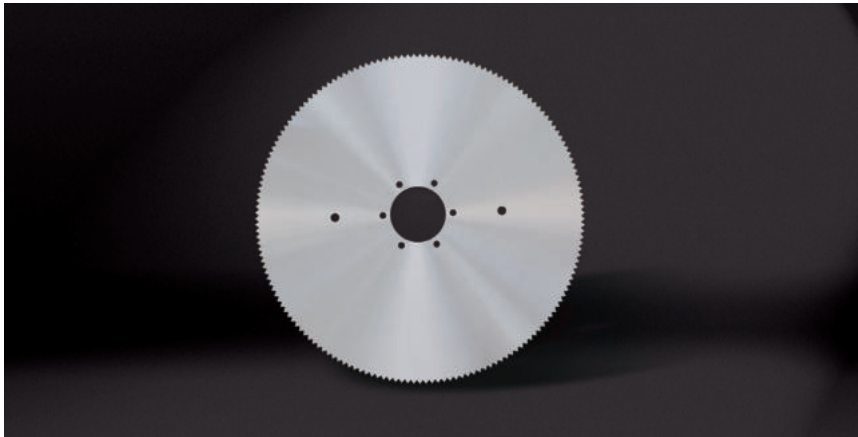


• Power-saved metal cold & hot cutting 57/58



Metal cold-cutting circular saw blades

- Cutting Workpiece:** ERW pipes, cold forming sections, small sections, etc;
- Cutting Temperature:** room temperature, but water pressure is required for teeth washing and blade cooling;
- Cutting Machine:** cold flying sawing machine, cold sawing machine;
- Cutting Application:** cutting ends, cutting to length;
- Blade Material:** high quality spring steel, low alloy tool steel;
- Main Process:** heat-treatment, grinding, leveling, tooth milling;
- Technical Characteristics:** good rigidity, high strength, easy to use;
- Main Specifications:** Φ350 mm - Φ1600 mm.



For Your Sawing Solution

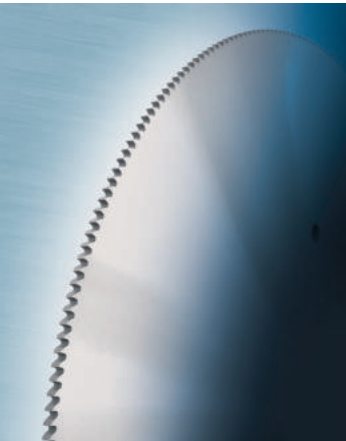
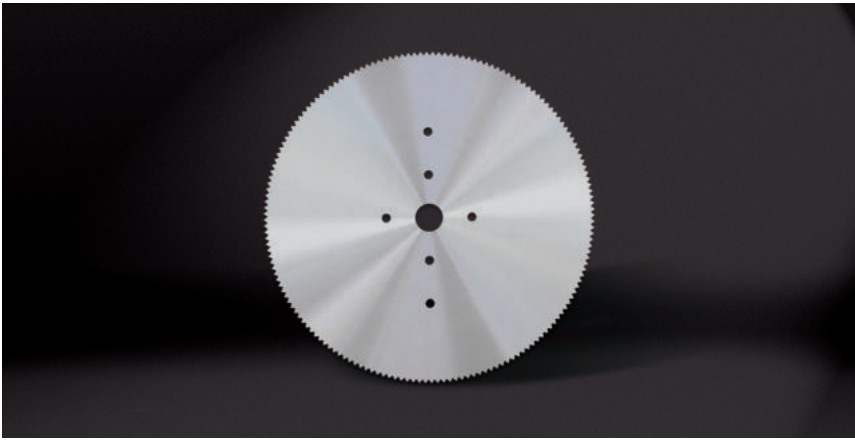
Standard specifications

Diameter (mm)	Bore (mm)	Thickness (mm)	Teeth Number
350	32	3.0	180/220
400	40/60	2.0/3.0/4.0/5.0	200/220/240/260
450	40/50/60/70	2.5/3.0/4.0/5.0	200/220/240/280
500	40/60/70/80	2.5/3.0/4.0/5.0	200/240/300/320
550	70/80	3.0/4.0/5.0	200/220/260/300
600	40/60/80/90	4.0/5.0/6.0	200/260/280/300
650	70/80/90	4.0/5.0/6.0	180/256/300/400
700	70/80/100	4.0/5.0/6.0	216/240/300/320
750	80/100/110	4.0/5.0/6.0/7.0/8.0	216/240/300//380
800	80/100/110/120	4.0/5.0/6.0/7.0/8.0	260/300//360/400/450/500
900	100/110/120/150	5.0/6.0/7.0/8.0	220/260/300/340/450
1000	120/125/180/300	5.0/6.0/7.0/8.0/9.0	280/300/340/450/480
1100	120/125/140/180	7.0/8.0/8.5/9.0	288/300/340/380/480
1200	120/125/180/300	7.0/8.0/9.0/9.5	308/360/400
1300	120/160	8.0	320/400
1400	185	8.0	480
1450	180	9.0	410
1500	180	9.0	410/440
1600	180	9.0/10.0	440/500

Note: products as per customer's design are available

Metal hot-cutting circular saw blades

- Cutting Workpiece:** steel sections, rounds of different materials;
- Cutting Temperature:** 750°C or above, 800°C above if high-alloy steel;
- Cutting Machine:** hot sawing machine;
- Cutting Application:** cutting ends, cutting to length;
- Blade Material:** high quality spring steel;
- Main Process:** heat-treatment, grinding, leveling, tooth milling, tooth beveling, tooth hardening;
- Technical Characteristics:** it is a special hot saw designed to reduce the burrs and improve the cutting quality, through the direction setting on teeth beveling and blade rotating;
- Main Specifications:** Φ750 mm - Φ3200 mm.

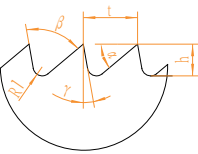


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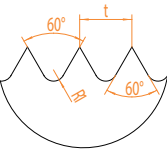
Standard specifications

Diameter mm	Thickness mm	Teeth Number
750	6.0	248
800	6.0	190 / 220 / 250
900	6.0	220 / 260 / 300
950	6.0	280 / 300
1000	6.0 / 7.0 / 8.0	230 / 260 / 300 / 320 / 350
1050	8.0 / 10.0	288
1100	5.0 / 6.0 / 7.0 / 8.0 / 9.0	188 / 288 / 300 / 360 / 400
1150	8.0 / 10.0	190 / 340
1200	7.0 / 8.0 / 9.0 / 10.0	276 / 348 / 360 / 380 / 400
1300	7.0 / 8.0 / 10.0	280 / 304 / 348 / 380 / 450
1400	8.0 / 9.0 / 10.0	320 / 360 / 380 / 400 / 440
1500	6.0 / 8.0 / 9.0 / 10.0 / 11.0	220 / 276 / 320 / 380 / 400 / 450 / 500
1600	8.0 / 10.0 / 12.0	288 / 380 / 410 / 450 / 500 / 550
1650	9.0 / 10.0	348 / 410
1700	9.0 / 10.0 / 12.0	500 / 588
1800	9.0 / 10.0 / 11.0 / 12.0	240 / 260 / 295 / 300 / 350 / 400 / 450 / 500 / 550 / 600 / 630
2000	10.0 / 12.0 / 13.0 / 14.0	275 / 295 / 300 / 320 / 330 / 380 / 600 / 630 / 660
2100	14.0 / 14.5	400 / 440 / 660 / 730
2200	14.0	320 / 580 / 700 / 760
2500	14.5	370 / 420

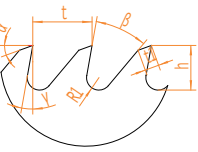
Note: products as per customers design are available



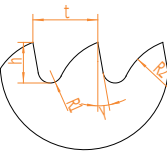
Rat tooth
It is sharp and easy to regrind, so it is one of the most common tooth profiles used for all kinds of workpiece.



Triangle tooth
It is strong, wearable and easy to regrind, so it is more suitable for workpiece with high strength and low cutting temperature.



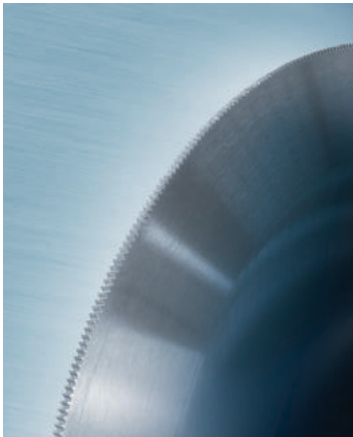
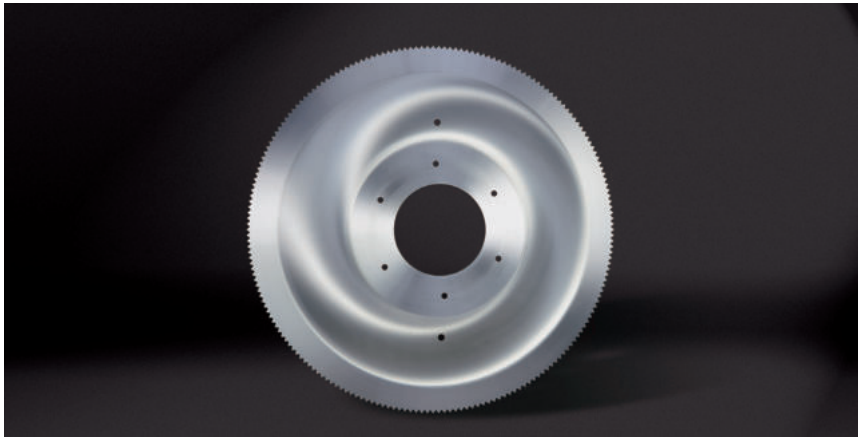
Wolf tooth
It is strong and wearable, but difficult to regrind, so it is not widely used.



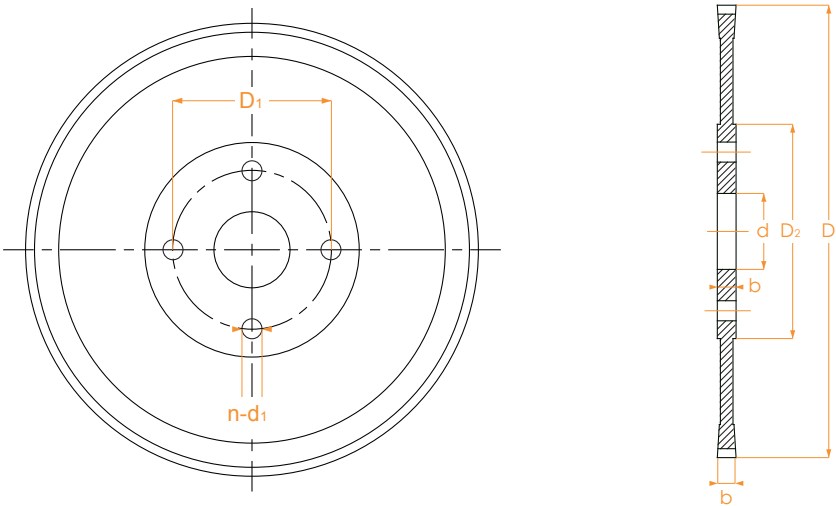
Curve tooth
It is strong and wearable, but difficult to regrind, so it is not widely used.

Power-saved metal cold & hot cutting

- Cutting Workpiece:** rounds, pipes, large & medium sections, etc. with different materials;
- Cutting Temperature:** no special requirements;
- Cutting Machine:** cold sawing machine, hot sawing machine;
- Cutting Application:** cutting ends, cutting to length;
- Blade Material:** low alloy tool steel;
- Main Process:** heat-treatment, grinding, leveling, tooth milling, hol-low/taper grinding;
- Technical Characteristics:** hollow or taper structure saves power by 25% above, improves stable cutting, nice cutting surface and longer service life;
- Main Specifications:** Φ 1500 mm - Φ 2200 mm.



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Standard specifications

Diameter (mm)	Thickness (mm)	Teeth Number
1500	10.0	300
1600	10.0	430
1700	10.0/10.5	520
1800	11.0 / 12.0 / 14.0	420 / 480 / 600
2000	12.0 / 13.0 / 14.0	260 / 330 / 630 / 660
2100	14.5 / 16.0	660 / 730
2200	14.0	580

Note: products as per customer's design are available

Contact Us

For Your Sawing Solution



A. Lindemann GmbH
www.alindemann.de

Hildebrandstr.17, 44319 Dortmund, Germany
Phone : +49(0) 231 977699 10
Fax : +49(0) 231 977699 11
Email : info@alindemann.de



A. Lindemann GmbH
www.alindemann.de

Industriering 12, 04626 Schmöln, Germany
Phone: +49(0) 344 915872 40
Fax: +49(0) 344 915872 50
Email: sln@alindemann.de



A. Lindemann USA
www.alindemann.us

1005 Eighth Ave, Glenshaw, PA 15116
Phone : +1 412 4877282
Fax : +1 412 4877298
Email : sales@alindemann-usa.com



A. Lindemann CN
www.alindemann.cn

No.6, Hexi road, Lubei District, Tangshan City
Phone : +86(0) 315 2053050
Fax : +86(0) 315 2053050
Email : wl@alindemann.com