KAMPMANN
SAW - TECHNOLOGY

EASYCAT

High Performance Circular Saw Blade

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EASYCAT®
MADE BY KAMPMANN

Concept

The “Easycat” carbide saw blade is a special development for high cutting speed application, used for example on welding lines with a flying saw head or for mass production circular saws for highest demands on economic efficiency and cutting performance in continuous operation.

Important things for high speed cutting saw blades like our “Easycat”, are the tension, the tight tolerances in the side run out a special tooth geometry which is adapted to the steel grades as well as the adapted carbide grades and PVD coatings.

Easycat types

Depending on the sawing conditions and the material to be cut, several types are available; they differ mainly by the carbide grades, the cutting angles and by the PVD coating.

On the following table you will find the different types, divided into applications.

Easycat types & applications

types	application	cutting parameter	steel
Easycat S (Solid)	solid bars	Vc 70 - 140 m/min fz: 0,04 - 0,08 mm/Z	alloyed & unalloyed steel, (except stainless steel), carbon > 0,4%
Easycat T (Tube)	tubes & steel sections	Vc: 180 - 300 m/min fz: 0,05 - 0,10 mm/Z	alloyed, unalloyed and high alloyed steel, (except stainless steel), carbon > 0,4%
Easycat FS (Flying saw)	welded tubes & steel sections	Vc: 90 - 600 m/min fz: 0,05 - 0,12 mm/Z	alloyed, unalloyed and high alloyed steel, (except stainless steel), carbon > 0,4%
Easycat X (Stainless steel)	solid bars and tubes	Vc: 60 - 80 m/min fz: 0,04 - 0,06 mm/Z	stainless steel
Easycat C (Cermet)	solid bars	Vc: 70 - 130 m/min fz: 0,05 - 0,07 mm/Z	alloyed & unalloyed steel. carbon < 0,45%

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Standard sizes in mm

EC T	EC S	EC FS	EC X	EC C	Bore (H7)
250	250		250	250	32/40
	285		285	285	32/40
315	315	315	315	315	32/40/50
350	350	350	350		50
	360		360	360	40/50
		400			40/50
	425	425	425	425	50
		450			50
	460		460	460	50
		500			80/100/140
		650			80/100/140
		690			80/100/140

Characteristics

- adapted tooth shape
- improved grinding process
- less side run out
- thin cutting width
- smooth running, less vibrations
- adapted carbide grade
- adapted PVD coating

Advantages

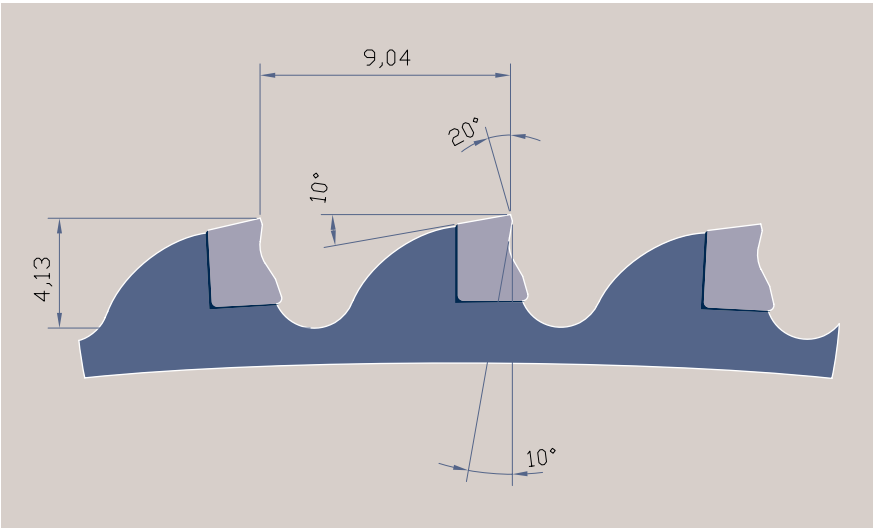
- smooth cutting surfaces
- less burrs
- long life time
- high cutting speeds & feed rates
- regrind enable teeth
- economical cutting tool
- standard sizes available ex stock

Cutting parameters
according to Easycat type

Vc	60 m/min - 600 m/min
fz	0,04 mm/Z - 0,12 mm/Z

All standard values

Tooth shapes



Selection of sawing machines for Easycat

- Adige
- Amada
- Dreistern
- KUSAKABE
- Oto Mills
- Rattunde
- RSA
- Sinico
- Vai Siemens

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EASYCAT® S

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Solid

Concept

PVD coated and carbide tipped saw blade; suitable for cutting solid bars. The Easycat S is a guarantee for high cutting performances and smooth surfaces on hard steels with a tensile strength higher than 1100N/mm².

Standard sizes in mm

sizes	teeth	bore (H7)	pinholes	pinholes	saw machine
250 x 2,0	60/72/80	32	4/9/50 4/11/63		Wagner, Kasto, Adige
285 x 2,0	60/72/80	32/40	4/9/50 4/11/63	2/12/80	Wagner, Kasto, ITEC
315 x 2,3	72/80	32/40	4/9/50 4/11/63	2/12/65 2/15/80	Kasto, Behringer Eisele
350 x 2,6	60/80/100	50	4/15/80		Rattunde, Kaltenbach
360 x 2,6	60/80/100	40/50	4/15/80 4/12/90	4/15/80 4/11/90	Amada, Kasto
425 x 2,7	60/80/100	50	4/14/80		Kasto, Tsune
460 x 2,7	60/80/100	50	4/12/90		Amada, Nishijima

EASYCAT® T

MADE BY KAMPMANN

Tube

Concept

The PVD coated and carbide tipped saw blade was developed to cut off steel tubes on full-automatic saw machines.
High cutting performances on hard steels up to 1400 N/mm² and excellent cutting surfaces consolidate the quality of the Easycat T saw blade.
The small pitch of 170 teeth on Ø of 350 mm saw blade, is a good solution for reaching high performances on tubes with high tensile strength and wall thicknesses less than 3,0 mm.

Standard sizes in mm

sizes	teeth	bore (H7)	pinholes	pinholes	saw machine
250 x 2,0	60/80	32/40	4/9/50 4/11/63	4/12/64	Kasto, Adige, Amada
315 x 2,3	80/100/120/**140**	32/40/50	4/9/50 4/11/63	4/12/64 4/15/80	Rattunde
350 x 2,6	80/100/120/**170**	50	4/15/80		Rattunde

EASYCAT® FS

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Flying Saw

Concept

The PVD coated and carbide tipped saw blade was developed to cut off steel tubes and structural steel shapes on welding lines with a flying cut off unit.
Very high cutting rates (up to 600m/min) make this saw blade becoming a very economical tool.
With a cutting performance which corresponds to such of a friction saw blade you can reach the production speeds of a tube mill.
The small pitch of 170 teeth on Ø of 350 mm saw blade, is a solution for reaching high performances on tubes with high tensile strength and wall thicknesses less than 3,0 mm.
A very good alternative to HSS circular saw blades.

Standard sizes in mm

sizes	teeth	bore (H7)
315 x 2,3	800/100/140	40
350 x 2,3	80/100/120/**144/170**	40/50
400 x 2,6	100/120/140/170	40/50
450 x 2,7	110/140/160/180/220	50/80
500 x 3,6	120/140/160/220/240	80/120/140
600 x 3,6	150	80/120/140
650 x 3,6	150	80/120/140
690 x 3,6	170	80/120/140

More sizes are available on request.

EASYCAT® X

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Stainless Steel

Concept

The ideal solution for cutting off stainless steel tubes and bars;
The PVD coated and carbide tipped saw blade was developed to cut off steel tube and bars on full automatic saw. An adapted carbide grade, a specific grinding and braze process allow a perfect cutting surface with high precision and avoid premature teeth losses.

Standard sizes in mm

sizes	teeth	bore (H7)	pinholes	pinholes
250 x 2,0	54/60/72/80	32	4/11/63 4/9/50	
285 x 2,0	60/72/80	32	4/11/63 4/9/50	
315 x 2,3	80	32	4/11/63 4/9/50	
350/360 x 2,5	60/80/100	40/50	4/11/63 4/9/50	4/14/80 4/16/80 4/11/90
425 x 2,7	60/80/100	50	4/14/80 4/16/80	
460 x 2,7	40/60/80	50	4/11/63 4/14/80	4/16/80

More sizes are available on request.

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EASYCAT® C

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Cermet

Cutting parameters

Vc	70 m/min - 130 m/min
fz	0,045 mm/Z - 0,07 mm/Z

Standard values

Concept

Cermet tipped saw blade, used for cut off solid bars.
Designed for cutting off unalloyed and alloyed steel with low carbon content (< 0.45%).
The adapted carbide grade, the specific grinding and braze process allow a perfect cutting surface with high precision and avoid premature teeth losses.

Standard sizes in mm

*d1: cutting width *d2: body thickness

sizes	d1*	d2*	bore (H7)	teeth	pinholes	saw machines
250	2,0	1,7 (1,75)	32 (40)	54	4/9/50 4/11/63 4/9/50 4/11/63 2/12/65 + 2/15/80	Tsune, Kasto, Everising, Behringer-Eisel, Nishijima
	2,0	1,7 (1,75)	32 (40)	60		
	2,0	1,7 (1,75)	32 (40)	72		
	2,0	1,7 (1,75)	32 (40)	80		
285	2,0	1,7 (1,75)	32 (40)	60	4/11/63 4/9/50 4/11/80 2/11/80	Tsune, Kasto, Everising, Behringer-Eisel, Amada, Nishijima, Kentai
	2,0	1,7 (1,75)	32 (40)	72	4/11/63 4/9/50 2/12/65 + 2/15/80	
	2,0	1,7 (1,75)	32 (40)	80		
315	2,3	1,7 (1,75)	32 (40)	72	4/11/63 4/9/50 2/12/65 + 2/15/80	Kasto (C9), Behringer-Eisele, Kentai
360	2,5 (2,6)	2,25 (2,3)	40 (50)	60	4/11/63 4/9/50 4/14/80 4/16/80 4/11/90 2/12/65 + 2/15/80 2/11/80	Nishijima, Tsune, Kasto(C14), Everising, Behringer-Eisele, Amada, Anderson
	2,5 (2,6)	2,25 (2,3)	40 (50)	80		
	2,5 (2,6)	2,25 (2,3)	40 (50)	100		
425	2,6 (2,7)	2,25	50	60	4/14/80	Kaso (C14), Tsune
	2,6 (2,7)	2,25	50	80		
	2,6 (2,7)	2,25	50	100		
460	2,7	2,25 (2,3)	40 (50)	40	4/11/63 4/14/8 4/16/80 2/12/65 + 2/15/80 4/11/90	Amada, Behringer-Eisele, Everising Nishijima
	2,7	2,25 (2,3)	40 (50)	60		
	2,7	2,25 (2,3)	40 (50)	80		

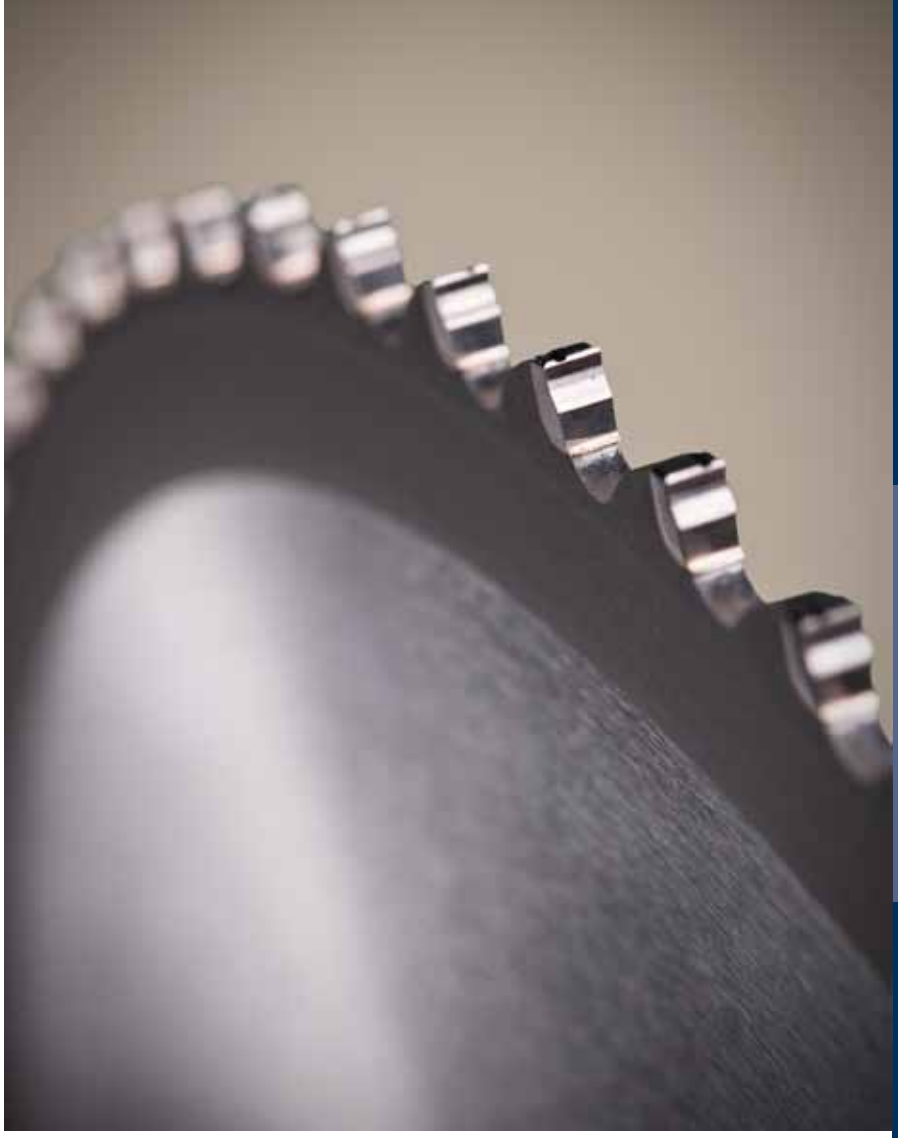
Advantages

- low temperature
- low noise
- excellent cutting surfaces
- less burrs
- long life time

Cutting parameters

Ø Saw blade (mm)	DIN-Nr.	name	tensile strength (N/mm²)	Vmax (m/min)	fz (mm/teeth)	
360	1.0301	C10	450 - 650	120	0,05	0,07
360	1.7030	28Cr4	700 - 900	100	0,05	0,07
360	1.6582	34CrNiMo6	1000 - 1200	80	0,05	0,07
360	1.7220	34CrMo4	900 - 1100	80	0,05	0,07
360	1.3505	100Cr6	700 - 750	80	0,05	0,07
360	1.4000	X6Cr13	400 - 600	70	0,05	0,07
360	1.7034	37Cr4	750 - 1000	80	0,05	0,07

Standard values



The right number of theeth (size of bars in mm)

diameter	number of theeth	size of bars																														
		10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100	105	110	115	120	125	130	135	140	145	150	155
250	54						■	■	■	■																					
	60					■	■	■	■																						
	72			■	■	■	■	■																						
285	60						■	■	■	■	■	■	■	■																
	72			■	■	■	■	■	■	■	■	■																		
	80		■	■	■	■	■	■	■																					
360	60							■	■	■	■	■	■	■	■	■	■	■	■	■										
	80					■	■	■	■	■	■	■	■	■	■															
	100				■	■	■	■	■	■																				
420	60								■	■	■	■	■	■	■	■	■	■	■	■	■	■								
	80						■	■	■	■	■	■	■	■	■	■														
	100			■	■	■	■	■	■	■	■	■	■	■																
460	40															■	■	■	■	■	■	■	■	■	■	■	■	■	■		
	60													■	■	■	■	■	■	■	■	■									
	80								■	■	■	■	■	■	■	■	■	■													

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JEASYCAT® C
MADE BY KANEMANN
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Details
Changes in design and technical improvements may be made.

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