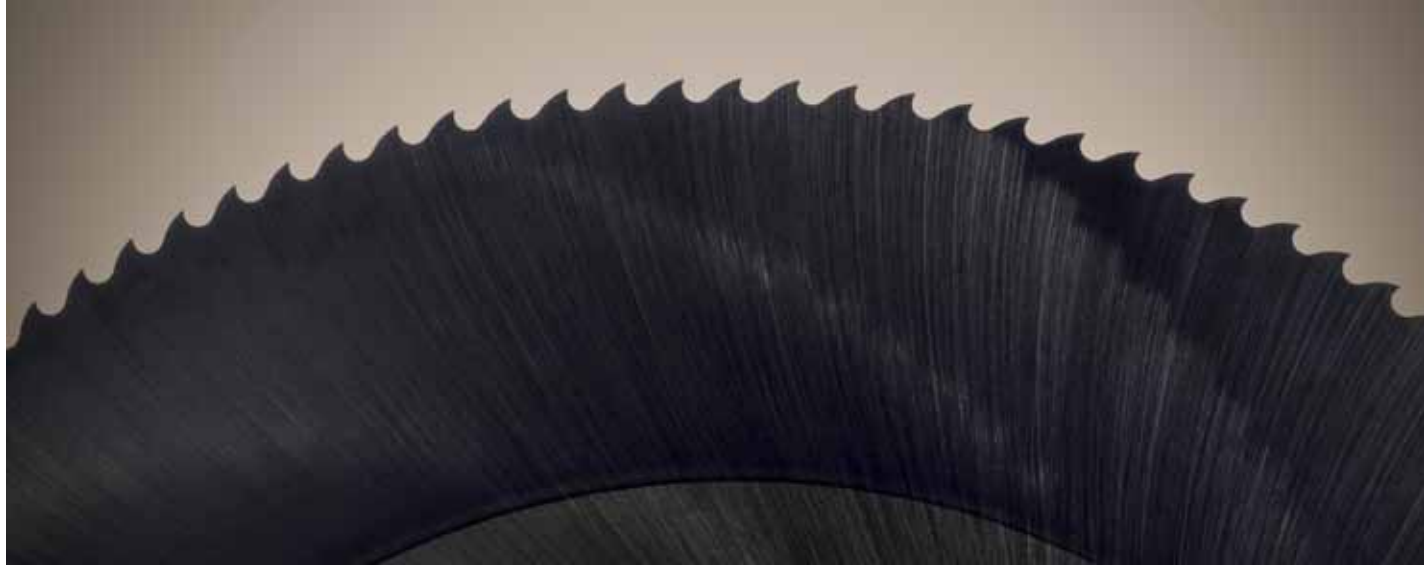




ROYAL

HSS-Circular Saw Blades





Concept

HSS-Dmo5 (1.3343)

Circular saw blades in high speed steel (5% molybdenum content), suitable for cutting-off steels and alloys with hardness between 500 N/mm² and 800 N/mm². The saw blades are used on manual, semi-automatic and fully automatic sawing machines to cut tubes and pipes, open and welded structural steel shapes up to 200 mm.

Our standard range goes from Ø 160 mm to Ø 620 mm, on demand we are able to produce up to Ø 700mm, with tooth forms A - AW - B - BW - C - BS (chip breaker).

The standard execution of the whole range is bright. We also supply PVD-coated or steam treated ones.

HSS-E Co5% (1.3243)

Circular saws in high speed steel (5% cobalt content), suitable for cutting off steels and alloys with hardness > 800 N/mm². The saw blades are used on semi-automatic fully-automatic and flying cut off sawing machines to cut tubes, pipes, open and welded structural steel shapes up to 200 mm.



Types

		ROYAL	ROYAL +	ROYAL <i>Performance</i>
HSS Dm05	1.3343			
HSSE Co5%	1.3243			
less side run out				
bright				
steam treated				
coated				



Coatings & Applications

HSS	ROYAL <i>blank</i>	tube, solid material and structural steel shapes. Steel, 500 up to 750 N/mm ²
HSS/HSS-E	ROYAL <i>TiCN</i>	tube, solid material and structural steel shapes. Steel, 750 up to 1000 N/mm ²
HSS-E	ROYAL <i>TiCN</i>	tube, solid material and structural steel shapes. Aluminium alloys and cast iron. Steel, > 1000 N/mm ²
HSS-E	ROYAL <i>TiALN /Performance</i>	tube, solid material and structural steel shapes. Stainless steel, and high alloyed steel as well as titanium alloys

Cutting parameters

steel grades	Vc (m/min) with coating	Vc (m/min) without coating	fz (mm/Z) feed rate
Steel < 500 N/mm ² (C10, C15, St37, St44)	180 - 200	40 - 30	0,04 - 0,08
Steel < 800 N/mm ² (C40, C60, 15Cr3, 16MnCr5)	160 - 180	25 - 35	0,03 - 0,07
Steel < 1200 N/mm ² (40CrMnMo7)	30	15 - 25	0,02 - 0,06
Stainless steel	30	20 - 30	0,02 - 0,06
Cast iron	30	20 - 30	0,03 - 0,05
Titanium	25	12 - 15	0,02 - 0,05
Brass		400 - 600	0,05 - 0,07
Copper		200 - 300	0,04 - 0,06
Bronze		200 - 400	0,05 - 0,07
Aluminium		500 - 700	0,06 - 0,08

All standard values

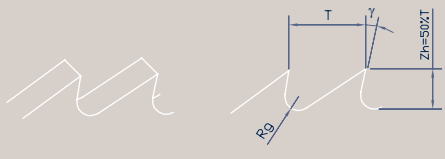




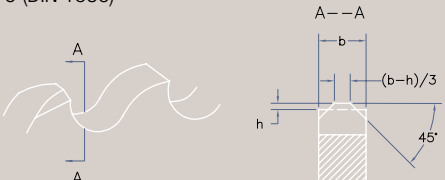
Standard sizes in mm

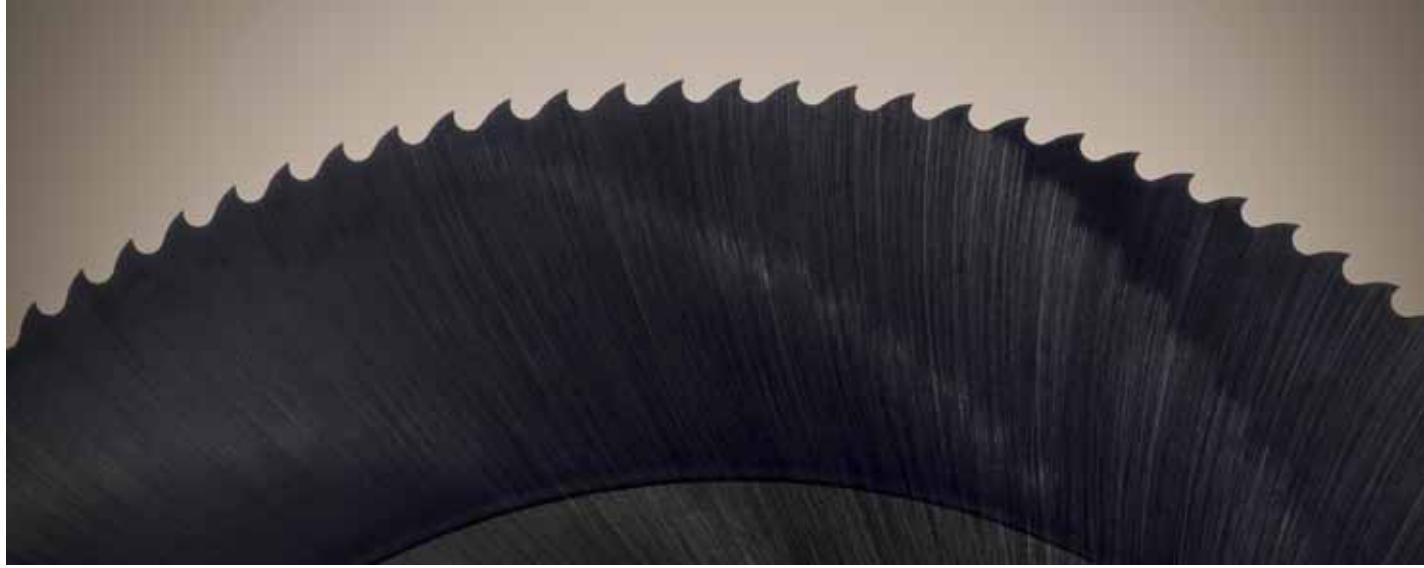
Ø	bore	hub	thickness	side run out		standard pinholes
				Royal	Royal +	
160	32	75	1,2/1,5/2,0	0,20	0,12	2/8/45 + 2/11/63
175	32	75	1,2/1,5/2,0	0,20	0,12	2/8/45 + 2/11/63 BAIER
200	32	90	1,0/1,2/1,5/1,6/1,8/2,0/2,5	0,20	0,12	2/8/45 + 2/11/63 UNI SLOTS
210	32	90	2,0	0,20	0,12	2/8/45 + 2/11/63
225	32	100	1,2/1,5/1,6/1,8/1,9/2,0/2,5	0,20	0,15	2/8/45 + 2/11/63 UNI SLOTS
	40	100	1,8/1,9/2,0/2,5			2/8/55 + 4/12/64
250	32	100	1,0/1,2/1,5/1,6/2,0/2,5	0,20	0,15	2/8/45 + 2/11/63 2/8/45 + 2/9/50 + 2/11/63 BAIER UNI SLOTS
	40	100	2,0/2,5/3,0			2/8/55 + 4/12/64
275	32	100	1,2/1,6/2,0/2,5/3,0	0,25	0,15	2/8/45 + 2/11/63 2/8/45 + 2/9/50 + 2/11/63 UNI SLOTS
	40	100	2,0/2,5/3,0			2/8/55 + 4/12/64
300	32	100	1,6/2,0/2,5/3,0	0,25	0,15	2/8/45 + 2/11/63 2/8/45 + 2/9/50 + 2/11/63 UNI SLOTS
	40	100	1,6/2,0/2,5/3,0			2/8/55 + 4/12/64
315	32	100	1,6/2,0/2,5/3,0/3,5	0,25	0,18	2/8/45 + 2/11/63 2/8/45 + 2/9/50 + 2/11/63 UNI SLOTS
	40	100	1,6/2,0/2,5/3,0/3,5			2/8/55 + 4/12/64
325	32	120	2,0/2,5/3,0	0,25	0,18	2/8/45 + 2/11/63
	40	120	2,0/2,5/3,0			2/8/55 + 4/12/64

Standard sizes in mm

Ø	bore	hub	thickness	side run out		standard pinholes
				Royal	Royal +	
350	32	120	1,8/2,0/2,5/3,0	0,25	0,18	2/8/45 + 2/11/63 2/8/45 + 2/9/50 + 2/11/63 UNI SLOTS
	40	120	1,8/2,0/2,5/3,0/3,5			2/8/55 + 4/12/64
	50	120	1,8/2,0/2,5/3,0/3,5			4/15/80 + 4/14/85
370	32	120	2,5/3,0	0,30	0,20	2/8/45 + 2/11/63
	40	120	2,5/3,0/3,5			2/8/55 + 4/12/64
	50	120	2,5/3,0			4/15/80 + 4/14/85
400	40	120	2,5/3,0/3,5	0,30	0,20	2/8/55 + 4/12/64
	50	120	2,5/3,0/3,5/4,0			4/15/80 + 4/14/85
425	40	120	2,5/3,0/3,5	0,30	0,20	2/8/55 + 4/12/64
	50	120	2,5/3,0/3,5/4,0			4/15/80 + 4/14/85
450	40	130	2,5/3,0/3,5/4,0	0,30	0,20	2/8/55 + 4/12/64
	50	130	2,5/3,0/3,5/4,0			4/15/80 4/15/80 + 4/14/85
500	40	130	3,0/3,5/4,0/5,0	0,30	0,22	2/8/55 + 4/12/64
	50	130	3,0/3,5/4,0/5,0			4/15/80 + 4/14/85
525	50	140	3,5/4,0	0,35	0,25	4/15/80 + 4/14/85
550	50	140	3,5/4,0/5,0	0,35	0,25	4/15/80 + 4/14/85
	90	200	4,0/5,0			3/12,5/160
	140	225	4,0/5,0			4/17,5/170
570	50	180	4,0/5,0	0,35	0,25	4/15/80 + 4/14/85
600	50	200	4,0/5,0	0,35	0,25	4/15/80 + 4/14/85
	90	200	4,0/5,0			3/12,5/160
	140	225	4,0/5,0			4/17,5/170
620	140	225	4,0/5,0	0,35	0,25	4/17,5/170

Tooth shapes

geometry		
<p>A (DIN 1837)</p> 	<ul style="list-style-type: none"> - angular tooth form, fine pitch mainly suitable for slitting and cutting off thin tubes and structural steel shapes as well as for shallow slots - especially for short-chipping materials 	
<p>AW (DIN 1837)</p> 	<ul style="list-style-type: none"> - angular tooth with alternately bevelled teeth, fine pitch. - for fine mechanics and thin-walled pipes 	
<p>B (DIN 1838)</p> 	<ul style="list-style-type: none"> - is mainly used for cutting off and slotting bigger cross-sectional areas - especially for long-chipping materials - universal applications possible 	
<p>BW (DIN 1838)</p> 	<ul style="list-style-type: none"> - curved tooth form with alternately bevelled teeth, coarse pitch - tubes and structural steel shapes $\varnothing > 2,5$ mm 	
<p>BS</p> 	<p>Chip breaker</p> <ul style="list-style-type: none"> - universal use for tube and structural steel shapes as well as solid bars with small sections, in general with high cutting speeds 	
<p>C (DIN 1838)</p> 	<ul style="list-style-type: none"> - due to the presence of a roughing and a finishing tooth this geometry is suitable for bigger cross-sectional areas as well as for solid materials 	



Concept

HSS-E Co5% (1.3243)

This circular saw blade designed with a multilayer special coating and an innovative surface technology is especially used for cutting off tubes and structural steel shapes on flying saw machines.

Characteristics

- innovative surface technique
- innovative PVD coating
- less side run out
- innovative surface technology



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