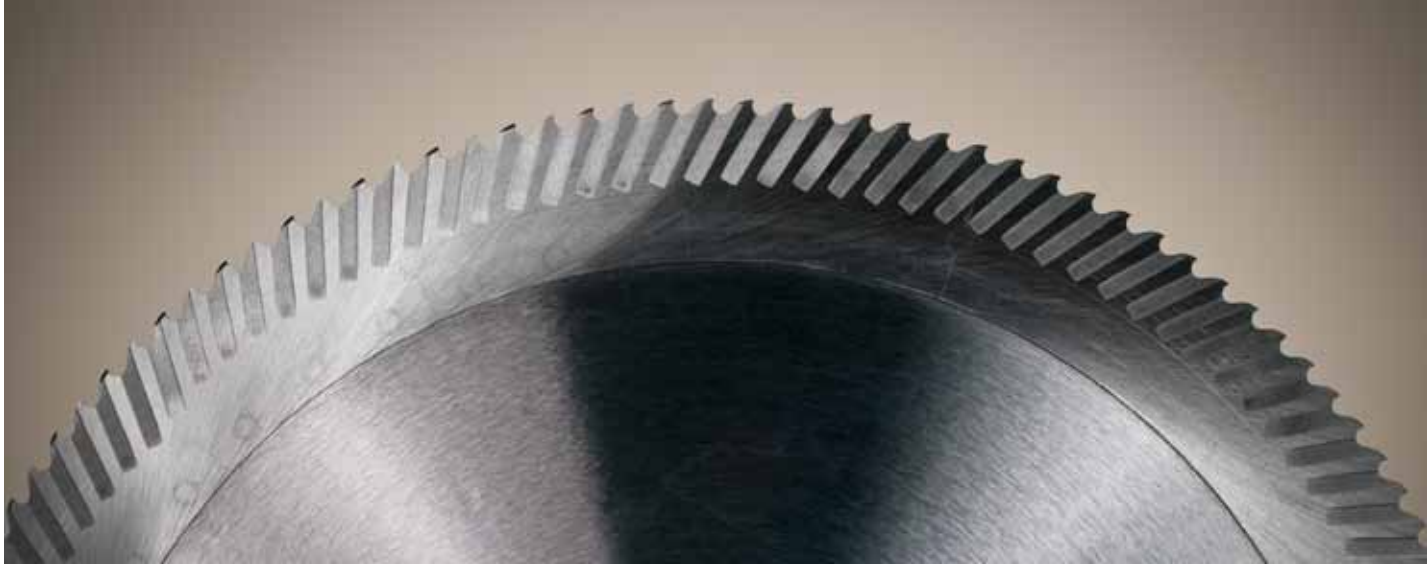




## **KS & KSC**

Segmental Saw Blades





## Kampmann Segmental Saw Blades

**KS**

MADE BY KAMP MANN

### Concept

The Kampmann GmbH is using a solid construction made of alloyed steel, and HSS high-speed-steel segments. The segmental saw blades are a guarantee for excellent cut surface and a long life time.

Available sizes: from Ø 250 mm up to Ø 1600 mm

The standard design of our segmental saw blades consists of roughing and finishing tooth geometry, HSS-Steel grade (1.3343) as well as all bores and pinholes according to customers requests.

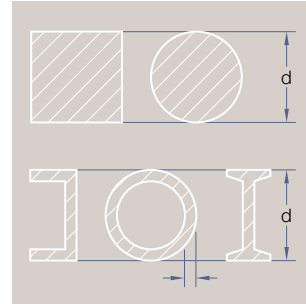
The segmental saw blades are also available in 1.3243 (cobalt alloyed).

segments	HSS (1.3343) / HSS-E (1.3243)
hardness	64 +/- 1 HRC / 65 +/- 1 HRC

## Applications

Cutting off solid bars, tubes and structural steel shapes as well as non-ferrous metals

- light metals
- structural steels
- heat treatable steels
- steel casting
- cast iron
- spring steels
- stainless steels
- unalloyed tool steels
- high-alloyed tool steels



## Cutting parameters

steel grades	strength N/mm <sup>2</sup>	cutting speed V <sub>c</sub> =m/min	rake angle	clearance angle	feed rates f <sub>z</sub> =mm/tp	cobalt- alloyed
light metals	100 - 300	500 - 1350	25 - 28	10 - 12	0,05 - 0,08	
structural steels	330 - 700	18 - 35	18	8	0,11 - 0,14	
unalloyed steel	600 - 700	10 - 15	14 - 16	6	0,06 - 0,07	
alloyed steel	800 - 900	10 - 12	13 - 16	6 - 8	0,05 - 0,07	
stainless steel	500 - 800	10 - 15	13 - 15	6 - 8	0,05 - 0,08	
steel casting	380 - 520	20 - 28	15 - 20	8 - 10	0,12 - 0,14	
cast iron	150 - 700	15 - 25	15 - 20	6 - 8	0,09 - 0,14	

All standard values



diameter	number of segments	diameter	number of segments
250	12	660	20
275	12	710	24
315	14	760	24
355	16	800	24
360	16	810	24
370	16	860	24
385	18	910	30
400	16	1010	30
410	18	1100	30
420	18	1110	36
425	18	1210	36
460	18	1250	36
470	18	1310	36
505	18	1400	36
510	18	1410	36
560	18	1430	36
610	20	1510	36
630	20	1600	40

Standard sizes in mm

Further dimensions and designs are available on request.



Coated segmental saw blades available  
up to Ø 710mm

## Advantages

- high cutting speed
- increased feed
- lower wear
- increasing productivity
- reduced production costs

## Imprint

### Concept & Realisation

Albert Hovine  
Kampmann GmbH

### Layout, Design & Photography

Jorge Rodrigues  
JorgeDesign - advertising agency

### Details

Changes in design and technical improvements  
may be made.

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