

Circular saws



Important note

We only use saw blades which are steam-finished (HSS DM 05).

What are the effects of the steam treatment? By evaporating at 500°C a controlled oxidation is being achieved. An iron oxide layer (Fe_3O_2) is generated on the surface of the saw blade, which improves the gliding properties and will at the same time protect against corrosion. Furthermore, tensions inside the blade are removed by what the risk of fracture is being reduced and the durability will considerably increase. Therefore, order your saw blade always with METALLKRAFT.

HKS 230 - Manual circular metal saws for the factory and on the construction sites to cut aluminium, steel and stainless steel

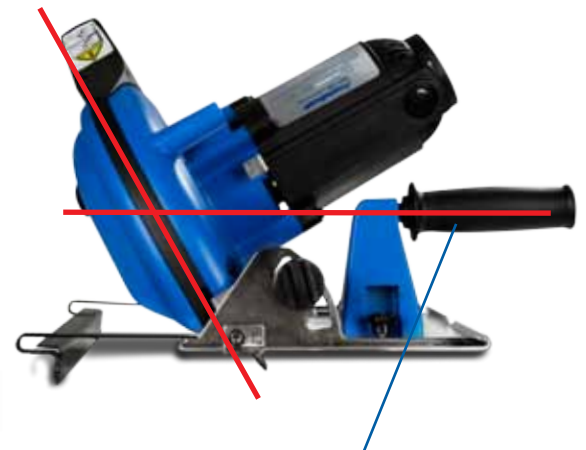
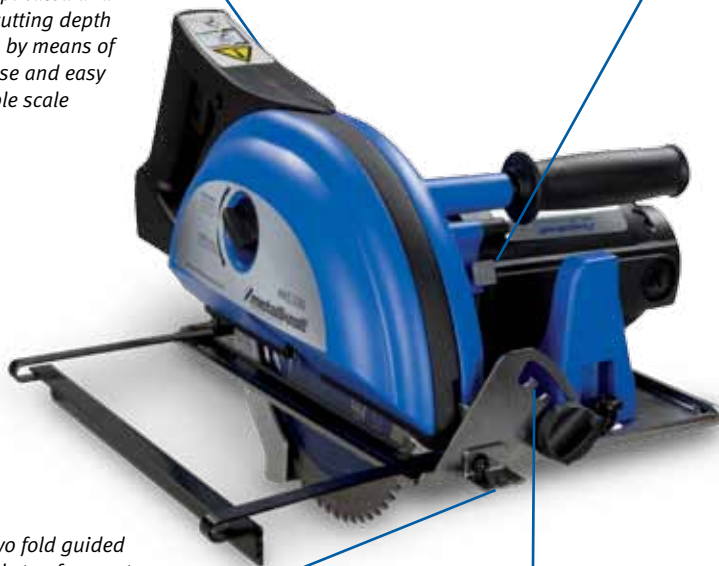
- The ideal machine for assembly companies, pointers, locksmith's shops, repair companies, stand builders, etc.
- Perfectly usable, where parting-off grinders are not powerful enough or are not working properly
- Cuts stainless steel with minimum burr
- chips carry off the heat, this way only little heat development when cutting
- High-wattage motor with smooth starting and overload protection
- It is possible to plunge into the material
- Uncomplicated and rapid cutting depth setting by means of a precise and easy readable scale
- Solid and robust structure
- Handle can be screwed in at two different positions for easy handling of the saw at any position
- Easy operation



• Rapid saw blade replacement by gear retention pin



• Uncomplicated and rapid cutting depth setting by means of a precise and easy readable scale



• Handle can be mounted at another position for mitre cuts, so that the saw can be safely guided parallel to the cutting layer

• With two fold guided parallel stop for exact cutting guidance



• Infinitely variable and easy setting of the mitre angle; grid at 0°, 15°, 30° and 45°



Type	HKS 230 *
Item No	384 0231
Technical data	
Motor power 230 V / 50 Hz	1.7 kW
Speeds	2600 min ⁻¹
Cutting range 90° <input type="checkbox"/> / Wall thickness	82 mm
Cutting range 45° <input type="checkbox"/> / Wall thickness	56 mm
Max. saw blade diameter	Ø 230 mm
Saw blade hole	Ø 25.4 mm
Saw blade thickness	2 mm
Dimensions (LxWxH)	620 x 320 x 270 mm
Weight	7.1 kg

* Machine is delivered in a solid plastic case without saw blade

Saw blades designed specially for the machines and the corresponding applications:



Steel



Aluminium



Stainless steel

Saw blades Ø 230 x 25.4 mm	Blade thickness	Number of teeth	Item No.
Steel	2.0 mm	48	385 0231
Aluminium	2.4 mm	80	385 0232
Stainless steel	1.8 mm	60	385 0233

MTS 356 - Metal dry cutter, saw metal without coolant

- Extremely solid and robust structure
- Easy to transport
- For sawing of profiles and tubes made of steel, iron, copper, brass, aluminium, plastic material, composite materials and stainless steel with little burrs without coolant
- Application e.g. in the metal construction, in carpenter's shops, for interior constructions, etc.
- Motor with smooth start-up due to easy handling when switching on the saw
- With a prism clamping jaw to clamp pipes as standard
- Vice with quick adjustment
- Safe stand due to aluminium die cast foot
- Angle for mitre cuts
Right-hand 45°, left-hand 39°
- With length stop for precise cuts
- With spindle locking mechanism for more rapid saw blade replacement



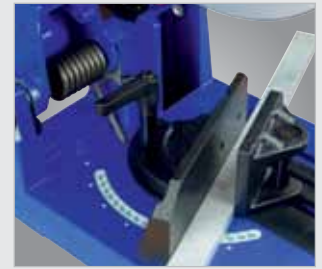
Substructure
collapsible
Item No 363 0000

Scope of delivery

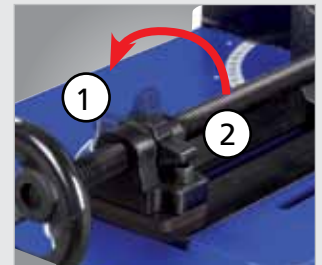
- 4, 6 and 8 mm hexagon socket spanner
- Safety goggles
- 1 prism clamping jaw
- Without saw blade



Prism clamping jaw
1 piece is included in
the scope of delivery



- Easily read the mitre angle from the scale
- Vice slewable infinitely variable from the right 45°, left 39°
- Vice with quick adjustment



- The saw is equipped with a quick-action vice. By moving the lever it is switched over between quick-clamping (Pos. 1) and clamping (Pos. 2)



- Prism vice for pipes (second prism jaws optional, Item No 385 0355)

Type	MTS 356	
Item No	384 0355	
Technical data		
Motor power 230 V / 50 Hz	2.2 kW	
Speeds	1300 min ⁻¹	
Cutting range 0°	<input type="checkbox"/>	100 x 180 mm (H x W)
Cutting range 0°	<input type="checkbox"/>	120 x 120 mm
Cutting range 0°	<input type="radio"/>	132 mm
Cutting range 45° on the right, 39° on the left	<input type="checkbox"/>	120 x 90 mm (H x B)
Cutting range 45° on the right, 39° on the left	<input type="checkbox"/>	90 x 90 mm
Cutting range 45° on the right, 39° on the left	<input type="radio"/>	105 mm
Saw blade diameter	Ø 355 mm	
Weight	23.5 kg	



Steel



Aluminium



Stainless steel

Accessories	Item No	
Substructure MTS 356	363 0000	
Prism clamping jaw	385 0355	
Saw blades		
	Number of	
Ø 355 x 2.4 x 25.4 mm teeth		
- Steel	80	385 3504
- Aluminium	80	385 3502
- Stainless steel	90	385 3503
Ø 305 x 2.4 x 25.4 mm		
- Steel	60	385 3051

Manual circular metal saws with one and two speeds as well as mitre slewable sawing head and vice

- For steel
- Two cutting speeds
- Reduction gear, running silently in an oil bath
- Automatic membrane coolant pump with coolant filter as standard
- Mobile safety device provides for an optimum safety when cutting
- Control handle with safety switch
- Electric installation at low-voltage 24 volts, with emergency-stop switch, main switch, speed selector switch and overload protection
- Machine head slewable by 45° to the left

Equipment from MKS 250 N on:

- Machine head can be turned 45° to the left and to the right from MKS 250 on
- Vice slewable by 45° to the left and by 45° to the right
- Quick action clamping vice with double clamping device guarantees precise cut with minimum burr



- Quick-clamping vice slewable by 45° to the left and by 45° to the right



MKS 250 N
Scope of delivery as standard



Type	MKS 250 N	MKS 255 N	MKS 275 N
Item No	362 0251	362 0253	362 0275
Technical data			
Motor power 50 Hz	0.9 kW / 230 V	0.95/1.32 kW / 400 V	1.1/1.5 kW / 400 V
Speeds	40 min ⁻¹	40/80 min ⁻¹	40/80 min ⁻¹
Span width vice	100 mm	100 mm	105 mm
Saw blade diameter	Ø 250 mm	Ø 250 mm	Ø 275 mm
Infeed height including base	970 mm	970 mm	970 mm
Footprint in mm	800 x 830 x 755	800 x 830 x 755	830 x 900 x 1025
Weight	83 kg	83 kg	98 kg



MKS 255 N

- Double vice, slewable from -45° to +45° with quick action clamping

Scope of delivery:

- Coolant equipment
- Length stop 500 mm
- Operating tool
- Without saw blade
- Without substructure

MKS 275 N

Scope of delivery:

- Coolant equipment
- Length stop 500 mm
- Operating tool
- Without saw blade
- Without substructure

Accessory



Chip lifting device "Chipmag"

- Magnetic Item No 385 0010



MD 11

Standard equipment micro dosing units

- Universally applicable for minimum lubrication of tool inserts and metal-forming tools
- Separate air and spray duct, therefore no dripping
- with extra-large lubricant tank, frequency-controlled pump and spray head

Peculiarities of the micro dosing unit MD 12

- Filter pressure regulator with water separator
- Robust steel sheet housing
- Coaxial hose with steel flex jacket



MD 12

Cutting capacity MKS 250 N / MKS 255 N

	●	○	□	▭
90°	40	70	70 x 70	55 x 95
45°	35	65	55 x 55	50 x 60
45° +	35	65	55 x 55	50 x 60

Cutting capacity MKS 275 N

	●	○	□	▭
90°	45	65	65 x 65	85 x 60
45°	40	60	40 x 40	40 x 60
45° +	40	60	40 x 40	40 x 60

Cutting capacity MKS 275 N optionally equipped with saw blade 315 N

	●	○	□	▭
90°	45	80	80 x 80	100 x 70
45°	40	80	70 x 70	80 x 70
45° +	40	80	70 x 70	80 x 70

Accessories

	Item No
Machine base MKS 250 N/255 N/275 N	364 2571
Coolant concentrate 5 litres	360 1751
Spray 5 litres Micro dosing unit	360 8020
Micro dosing unit MD 11 - 230 volts	360 8011
Micro dosing unit MD 12 - 230 volts	360 8012
Assembly micro-feeder	900 2000

Saw blades MKS 250/255 N

HSS saw blade DM05 Ø250x2x32 mm t ³⁾	365 2504
HSS saw blade DM05 Ø250x2x32 mm t ⁶⁾	365 2506

Saw blades MKS 275 N

HSS saw blade DM05 Ø275x2.5x32 mm t ³⁾	365 2754
HSS saw blade DM05 Ø275x2.5x32 mm t ⁶⁾	365 2756
HSS saw blade DM05 Ø275x2.5x32 mm t ⁸⁾	365 2758

³⁾ t = Tothing

Manual circular metal saws with 315 mm saw blade, two speeds as well as mitre slewable saw head and vice



- Two cutting speeds
- Machine head is turnable by 45° to the left and 45° to the right
- Reduction gear, running silently in an oil bath
- Automatic membrane coolant pump with coolant filter as standard
- Quick-action vice with anti-burr device, slewable by 45° to the left and 45° to the right
- Vice with longitudinal movement and this way appropriate for longitudinal cuts and for slotting

- Mobile safety device provides for an optimum safety when cutting
- Control handle with safety switch
- Electric installation at low-voltage 24 volts, with emergency-stop switch, main switch, speed selector switch and overload protection

Equipment MKS 315 R / MKS 316 R

- With adjustable sliding clutch by what a fracture of the saw blade can be excluded
- **MKS 316 R very well appropriate to machine stainless steel due to the slow speeds**



- Quick-clamping vice slewable by 45° to the left and by 45° to the right

Accessory



- **Chip lifting device "Chipmag"**
- Magnetic Item No 385 0010



MKS 315 N

Scope of delivery:

- Coolant equipment
- Length stop 500 mm
- Operating tool
- Without saw blade
- Without substructure

MKS 315 R / MKS 316 R

Scope of delivery

- Coolant equipment with filter
- Material support arm with roll
- Length stop 500 mm
- Operating tool
- Without saw blade
- Without substructure

Type	MKS 315 N	MKS 315 R	MKS 316 R
Item No	362 0303	362 1315	362 1316
Technical data			
Motor power 50 Hz	1.5/2.2 kW / 400 V	1.5/2.2 kW / 400 V	1.32/1.91 kW / 400 V
Speeds	40/80 min ⁻¹	40/80 min ⁻¹	20/40 min ⁻¹
Span width vice	120 mm	120 mm	120 mm
Saw blade diameter	Ø 315 mm	Ø 315 mm	Ø 315 mm
Infeed height incl. base	1015 mm	1015 mm	1015 mm
Footprint in mm	1000 x 1150 x 1475	1000 x 1150 x 1475	1000 x 1150 x 1475
Weight	165 kg	170 kg	170 kg

Accessories

Accessories	Item No
Machine base	364 3171
Coolant concentrate 5 litres	360 1751
Spray 5 litres Micro dosing unit	360 8020
Assembly micro-feeder	900 2000

Saw blades MKS 315 N/315 R/316 R

HSS saw blade DM05 Ø315x2.5x32 mm t4 ¹⁾	365 3154
HSS saw blade DM05 Ø315x2.5x32 mm t6 ¹⁾	365 3156
HSS saw blade DM05 Ø315x2.5x32 mm t8 ¹⁾	365 3158

Saw blades for stainless steel MKS 315 R

HSS-E saw blade Ø315x2.5x32 mm t4 ¹⁾	365 3254
HSS-E saw blade Ø315x2.5x32 mm t6 ¹⁾	365 3256

¹⁾ t = Toothing

Cutting capacity MKS 315 N

	●	○	□	▭
90°	55	90	80 x 80	115 x 70
45°	50	80	70 x 70	70 x 70
45° +	50	80	70 x 70	70 x 70

Cutting capacity MKS 315 R / 316 R

	●	○	□	▭
90°	65	90	85 x 85	120 x 70
45°	60	80	70 x 70	80 x 70
45° +	60	80	70 x 70	80 x 70

MKS 350 - Manual circular metal saw with saw blade 350 mm MKS 350 H - Semi-automatic type

- Solid and robust structure
- Two cutting speeds as standard
- Machine head is slewable by 45° to the left and by 90° to the right
- Reduction gear, running silently in an oil bath
- With membrane coolant pump with filter
- Double vice with counter vice and anti-burr clamping jaws guarantees for a precise cut free from burrs
- Vice with longitudinal movement and this way appropriate for longitudinal cuts and for slotting
- Quick-clamping vice slewable by 45° to the left and by 45° to the right

- Adjustable blade protection coupling
- Mobile safety device provides for an optimum safety when cutting
- Electric installation at low-voltage 24 volts, with emergency-stop switch, main switch, speed selector switch and overload protection
- Control handle with safety switch
- **MKS 351 very well appropriate to machine stainless steel due to the slow speeds**

Semi-automatic operation MKS 350 H

- Activating the motor and Closing the vice
- Lowering the saw head for cutting
- Return of the saw head in the initial position and stopping the motor
- Opening the vice



- Quick-clamping vice slewable by 45° to the left and by 45° to the right

Accessory



- Chip lifting device "Chipmag"
- Magnetic Item No 385 0010



MKS 350 / MKS 351

Scope of delivery:

- Coolant equipment
- Length stop 500 mm
- Operating tool
- Without saw blade
- Without substructure

MKS 350 H

Scope of delivery:

- Coolant equipment
- Length stop 500 mm
- Operating tool
- Without saw blade
- Incl. substructure

Type	MKS 350	MKS 351	MKS 350 H
Item No	362 1350	362 1351	362 0352
Technical data			
Motor power 400 V/50 Hz	1.8/2.4 kW	1.5/2.2 kW	1.8/2.4 kW
Speeds	40/80 min ⁻¹	20/40 min ⁻¹	40/80 min ⁻¹
Span width vice	120 mm	120 mm	120 mm
Saw blade diameter	Ø 350 mm	Ø 350 mm	Ø 350 mm
Infeed height including base	1025 mm	1025 mm	1040 mm
Footprint in mm	1000 x 1200 x 1475	1000 x 1200 x 1475	1000 x 1200 x 1475
Weight	210 kg	210 kg	280 kg

Accessories

Accessories	Item No
Machine base MKS 350/351	364 3171
Coolant concentrate 5 litres	360 1751
Spray 5 litres Micro dosing unit	360 8020
Micro dosing unit MD 11 - 230 volts	360 8011
Micro dosing unit MD 12 - 230 volts	360 8012
Assembly micro-feeder	900 2000

Saw blades MKS 350/351/350 H

HSS saw blade DM05Ø 350x2.5x32 mm t ₄ ¹⁾	365 3504
HSS saw blade DM05Ø 350x2.5x32 mm t ₆ ¹⁾	365 3506

Saw blades for stainless steel MKS 351

HSS-E saw blade Ø 350x2.5x32 mm t ₄ ¹⁾	365 3514
HSS-E saw blade Ø 350x2.5x32 mm t ₆ ¹⁾	365 3516

¹⁾t = Toothing

Cutting capacity MKS 350 / MKS 351 / MKS 350

	●	○	□	▭
90°	60	110	100 x 100	120 x 80
45°	55	80	80 x 80	80 x 80
45° +	55	80	80 x 80	80 x 80

MKS 315 V - Manual vertical circular metal saw with saw blade 315 mm
MKS 350 V - Manual vertical circular metal saw with saw blade 350 mm
MKS 316 V - Type with lower speed to saw stainless steel



- Solid and robust structure
- Easy and trouble-free operation
- Two cutting speeds
- Machine head vertically guided, with dovetail guide and adjustable V-ledge, slewable by 45° to the left and by 60° to the right with a locking mechanism at 45°, 0°, -45°, 60°
- Adjustable depth stop for the vertical stroke of the saw head
- Reduction gear, running silently in an oil bath
- Coolant pump with coolant filter
- Coolant jet distribution for a better lubrication of the saw blade
- Cross-sliding vice with anti-burr device
- Chip breaker to clean the blade
- Electric installation at low-voltage 24 volts, with emergency-stop switch, main switch, speed selector switch and overload protection
- Control handle with safety switch

Accessory



Chip lifting device "Chipmag"
 • Magnetic Item No 385 0010



Scope of delivery MKS 315V, 316V, 350V

- Coolant equipment with filter
- Material support arm with roll
- Length stop 500 mm
- Operating tool
- Without saw blade

Type	MKS 315 V	MKS 316 V	MKS 350 V	Accessories	Item No
Item No	362 2315	362 2316	362 2350		
Technical data				Coolant concentrate 5 litres	360 1751
Motor power 400V / 50 Hz	1.3/1.8 kW	1.3/1.9 kW	1.9/2.5 kW	Chipmag (chip lifting device)	385 0010
Speeds	33/66 min ⁻¹	17/34 min ⁻¹	36/72 min ⁻¹	Micro dosing unit MD 11 - 230 volts	360 8011
Span width vice	160 mm	160 mm	185 mm	Micro dosing unit MD 12 - 230 volts	360 8012
Saw blade diameter	Ø 315 mm	Ø 315 mm	Ø 350 mm	Assembly micro-feeder	900 2000
Infeed height including base	910 mm	910 mm	905 mm	Spray 5 litres Micro dosing unit	360 8020
Footprint in mm	1500x650x1700	1500x650x1700	1050x1000x1850	Saw blades MKS 315 V/316 V	
Weight	270 kg	270 kg	450 kg	HSS saw blade DM05 Ø 315x2.5x32 mm t4 ¹⁾	365 3154
				HSS saw blade DM05 Ø 315x2.5x32 mm t6 ¹⁾	365 3156
				HSS saw blade DM05 Ø 315x2.5x32 mm t8 ¹⁾	365 3158
				Saw blades for stainless steel MKS 316 V	
				HSS-E saw blade Ø315x2.5x32 mm t4 ¹⁾	365 3254
				HSS-E saw blade Ø315x2.5x32 mm t6 ¹⁾	365 3256
				Saw blades MKS 350 V	
				HSS saw blade DM05 Ø 350x2.5x32 mm t4 ¹⁾	365 3504
				HSS saw blade DM05 Ø 350x2.5x32 mm t6 ¹⁾	365 3506
				HSS saw blade DM05 Ø 350x2.5x32 mm t8 ¹⁾	365 3508
				HSS saw blade DM05 Ø 350x2.5x32 mm t10 ¹⁾	365 3510

Cutting capacity MKS 315 V, 316 V

	●	○	□	▭
90°	70	100	90 x 90	135 x 80
45°	70	100	90 x 90	100 x 80
45° +	70	100	90 x 90	100 x 80
60° +	70	80	70 x 70	70 x 80

Cutting capacity MKS 350 V

	●	○	□	▭
90°	100	100	90 x 90	170 x 90
45°	100	100	90 x 90	125 x 90
45° +	100	100	90 x 90	125 x 90
60° +	90	90	90 x 90	90 x 90

¹⁾ t = Toothing ²⁾ Price without assembly to the saw

MKS 315 VH - Semi-automatic vertical circular metal saw with saw blade 315 mm
MKS 350 VH - Semi-automatic vertical circular metal saw with saw blade 350 mm

- Solid and robust structure
- Easy and trouble-free operation
- Two cutting speeds
- Machine head vertically guided, with dovetail guide and adjustable V-ledge, slewable by 45° to the left and by 60° to the right with a locking mechanism at 45°, 0°, -45°, 60°
- Adjustable depth stop for the vertical stroke of the saw head
- Reduction gear, running silently in an oil bath
- Coolant pump with coolant filter

- Coolant jet distribution for a better lubrication of the saw blade
- Cross-sliding pneumatic quick-action vice with anti-burr device
- Chip breaker to clean the blade
- Electric installation at low-voltage 24 volts, with emergency-stop switch, main switch, speed selector switch, low-voltage release and overload protection

Functionality semi-automatic machine

- Closing the vice and activation of the motor
- Lowering the saw head for cutting
- Stopping the motor and return of the saw head in the initial position
- Opening the vice



MKS 315 VH



MKS 350 VH

Scope of delivery

- MKS 315: material support arm with roll
- MKS 350: material roller conveyor 1000 mm
- Length stop 500 mm
- Operating tool
- Without saw blade
- Coolant equipment with filter

Type	MKS 315 VH	MKS 350 VH
Item No	362 3315	362 3350
Technical data		
Motor power 400 V / 50 Hz	1.3/1.8 kW	1.9/2.5 kW
Speeds	33/66 min ⁻¹	36/72 min ⁻¹
Span width machine vice	160 mm	185 mm
Saw blade diameter	Ø 315 mm	Ø 350 mm
Infeed height including base		905 mm
Footprint mm	1500 x 650 x 2000	2640 x 1200 x 2000
Weight	300 kg	480 kg

Accessories	Item No
coolant concentrate 5 litres	360 1751
Chipmag (chip lifting device)	385 0010
Micro dosing unit MD 11 - 230 volts	360 8011
Micro dosing unit MD 12 - 230 volts	360 8012
Assembly micro-feeder	900 2000
Spray 5 litres Micro dosing unit	360 8020
Saw blades MKS 315 VH	
HSS Saw blade DM05 Ø 315 x 2.5 x 32 mm t4 ¹⁾	365 3154
HSS Saw blade DM05 Ø 315 x 2.5 x 32 mm t6 ¹⁾	365 3156
HSS Saw blade DM05 Ø 315 x 2.5 x 32 mm t8 ¹⁾	365 3158
Saw blades MKS 350 VH	
HSS Saw blade DM05 Ø 350 x 2.5 x 32 mm t4 ¹⁾	365 3504
HSS Saw blade DM05 Ø 350 x 2.5 x 32 mm t6 ¹⁾	365 3506
HSS Saw blade DM05 Ø 350 x 2.5 x 32 mm t8 ¹⁾	365 3508
HSS Saw blade DM05 Ø 350 x 2.5 x 32 mm t10 ¹⁾	365 3510

Cutting capacity MKS 315 VH

	●	○	□	▣
90°	70	100	90 x 90	135 x 80
45°	70	100	90 x 90	100 x 80
45° +	70	100	90 x 90	100 x 80
60° +	70	80	70 x 70	70 x 80

Cutting capacity MKS 350 VH

	●	○	□	▣
90°	100	100	90 x 90	170 x 90
45°	100	100	90 x 90	125 x 90
45° +	100	100	90 x 90	125 x 90
60° +	90	90	90 x 90	90 x 90

¹⁾t = Toothing

LMS 400 / LMS 400 H / LMS 400 P - Manual and semi-automatic circular saw for light metal with saw blade 400 mm



- Circular sawing machine to cut solid material and profiles made of aluminium and light metal alloys
- Solid and robust structure
- Easy and trouble-free operation
- Precise cutting
- Saw head is slewable by 45° to the left and by 45° to the right
- Easy turning of the saw head by 45° due to positioning bolts e.g. Schifter cut
- Rotary table is mounted on bearings
- Saw shaft is mounted on bearings

LMS 400 H

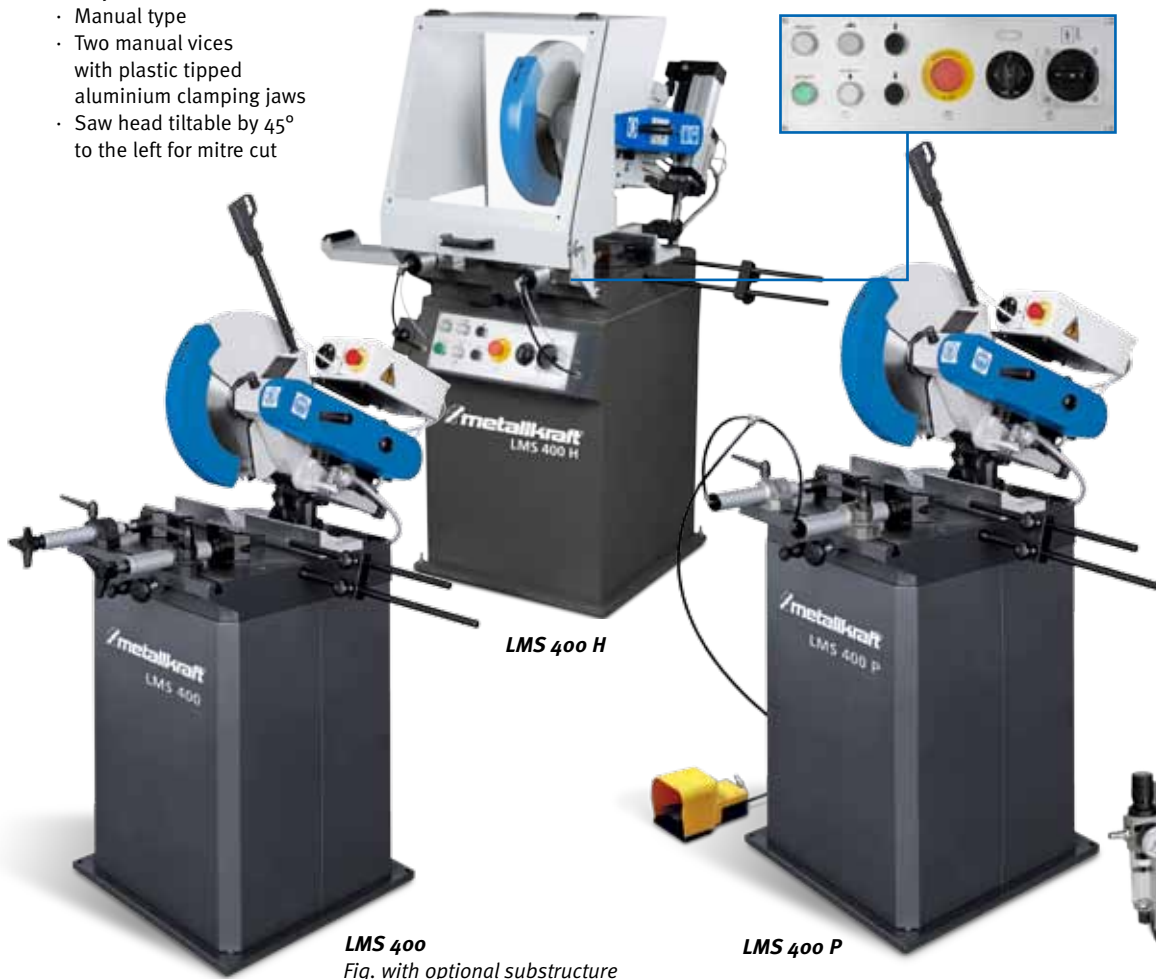
- Semi-automatic type
- Two pneumatic quick-action vices with plastic tipped aluminium clamping jaws

LMS 400 P

- Saw head tiltable by 45° to the left for mitre cut
- pneumatic vices with plastic tipped aluminium clamping jaws
- Control handle with safety switch

LMS 400

- Manual type
- Two manual vices with plastic tipped aluminium clamping jaws
- Saw head tiltable by 45° to the left for mitre cut



Accessory



Standard equipment micro dosing units

- Universally applicable for minimum lubrication of tool inserts and metal-forming tools
- Separate air and spray duct, therefore no dripping
- with extra large lubricant tank, frequency-controlled pump and spray head

Peculiarities

- of the micro dosing unit MD 12**
- Filter pressure regulator with water separator
- Robust steel sheet housing
- Coaxial hose with steel flex jacket



Type	LMS 400	LMS 400 H	LMS 400 P
Item No	362 5400	362 5401	362 5402
Technical data			
Motor power 400 V / 50 Hz	2.2 kW	2.2 kW	
Speeds	3000 min ⁻¹	3000 min ⁻¹	
Span width machine vice	220 mm	220 mm	
Saw blade diameter	Ø 400 mm	Ø 400 mm	
Infeed height including base	855 mm	855 mm	
Footprint in mm	1500x1000x900	1500x1000x1600	
Weight	160 kg	210 kg	

Scope of delivery LMS 400

- Length stop 500 mm
- Operating tool
- Without substructure
- Without saw blade

Scope of delivery LMS 400 H / LMS 400 P

- Material support arm with roll
- Length stop 500 mm
- Operating tool
- Without saw blade

Accessories

Accessories	Item No
Machine base LMS 400	364 4071
HM saw blade Ø 400 x 4.0 x 32 mm z96	365 4048
Micro dosing unit MD 11 - 230 volts	360 8011
Micro dosing unit MD 12 - 230 volts	360 8012
Assembly micro-feeder	900 2000
Spray 5 litres Micro dosing unit	360 8020

¹⁾ Price without assembly to the saw

Cutting capacity LMS 400 / LMS 400 H / LMS 400 P

	●	○	□	▣
90°	60	140	110 x 110	180 x 100
45°	60	120	100 x 100	150 x 100
45° +	60	120	100 x 100	150 x 100

LMS 400 A - Automatic circular saw for light metal with saw blade 400 mm



- Automatic circular sawing machine to cut solid material and profiles made of aluminium and light metal alloys
- Solid and robust structure
- Easy and intuitive operation
- Precise cutting
- Rotary table is mounted on bearings
- Three pneumatic quick action clamps with Teflon clamping jaws

Functionality automatic machine

- Material feed
- Closing the vice and activation of the motor
- Activation of the coolant pump
- Lowering of the saw head up to the finishing of the cut
- Return of the feed wagon up to the determined dimension
- Return of the saw head in the initial position
- Opening the vice
- Repeating of the cycle



Type	LMS 400 A
Item No	362 5404
Technical data	
Motor power 400 V / 50 Hz	2.2 kW
Speeds	3000 min ⁻¹
Span width machine vice	180 mm
Saw blade diameter	Ø 400 mm
Infeed height including base	910 mm
Footprint	3800 x 1600 x 1700 mm
Weight	510 kg

Cutting capacity LMS 400 A

	●	○	□	▭
90°	60	130	110 x 110	180 x 100
45°	-	-	-	-
45° +	-	-	-	-
60° +	-	-	-	-

Scope of delivery

- Material roller conveyor 1000 mm
- Length stop 500 mm
- Operating tool

Accessories

Accessories	Item No
HM saw blade Ø 400 x 4.0 x 32 mm z96	365 4048
HM saw blade Ø 400 x 3.0 x 32 mm z84	365 4049
Micro dosing unit MD 11 - 230 volts	360 8011
Micro dosing unit MD 12 - 230 volts	360 8012
Assembly micro-feeder	900 2000
Spray 5 litres Micro dosing unit	360 8020

Saw blades for all Metallkraft circular saws

HKS 230		Item No
Saw blade for steel	Ø 230x2.0x25.4 mm	385 0231
Saw blade for aluminium	Ø 230x2.4x25.4 mm	385 0232
Saw blade for stainless steel	Ø 230x1.8x25.4 mm	385 0233
MTS 356		
Saw blade for steel	Ø 355x2.4x25.4mm Z80	385 3504
Saw blade for aluminium	Ø 355x2.4x25.4mm Z80	385 3502
Saw blade for stainless steel	Ø 355x2.4x25.4mm Z90	385 3503
Saw blade for steel	Ø 305x2.4x25.4mm Z60	385 3051
MKS 250 N, MKS 255 N		
HSS saw blade DM05	Ø 250x2x32 mm t4	365 2504
HSS saw blade DM05	Ø 250x2x32 mm t6	365 2506
MKS 275 N		
HSS saw blade DM05	Ø 275x2.5x32mm t4	365 2754
HSS saw blade DM05	Ø 275x2.5x32mm t6	365 2756
HSS saw blade DM05	Ø 275x2.5x32mm t8	365 2758
MKS 315 N, MKS 315 R, MKS 316 R		
HSS saw blade DM05	Ø 315x2.5x32 mm t4	365 3154
HSS saw blade DM05	Ø 315x2.5x32 mm t6	365 3156
HSS saw blade DM05	Ø 315x2.5x32 mm t8	365 3158
Saw blades for stainless steel MKS 315 R		
HSS -E saw blade	Ø 315x2.5x32 mm t4	365 3254
HSS -E saw blade	Ø 315x2.5x32 mm t6	365 3256
MKS 350, MKS 351, MKS 350 H		
HSS saw blade DM05	Ø 350x2.5x32 mm t4	365 3504
HSS saw blade DM05	Ø 350x2.5x32 mm t6	365 3506

Saw blades for stainless steel MKS 351		
HSS-E saw blade	Ø 350x2.5x32 mm t4	365 3514
HSS-E saw blade	Ø 350x2.5x32 mm t6	365 3516
MKS 315 V, MKS 316 V		Item No
HSS saw blade DM05	Ø 315x2.5x32 mm t4	365 3154
HSS saw blade DM05	Ø 315x2.5x32 mm t6	365 3156
HSS saw blade DM05	Ø 315x2.5x32 mm t8	365 3158
Saw blades for stainless steel MKS 316 V		
HSS-E saw blade	Ø 315x2.5x32 mm t4	365 3254
HSS-E saw blade	Ø 315x2.5x32 mm t6	365 3256
MKS 350 V		
HSS saw blade DM05	Ø 350x2.5x32 mm t4	365 3504
HSS saw blade DM05	Ø 350x2.5x32 mm t6	365 3506
HSS saw blade DM05	Ø 350x2.5x32 mm t8	365 3508
HSS saw blade DM05	Ø 350x2.5x32 mm t10	365 3510
MKS 315 VH		
HSS saw blade DM05	Ø 315x2.5x32 mm t4	365 3154
HSS saw blade DM05	Ø 315x2.5x32 mm t6	365 3156
HSS saw blade DM05	Ø 315x2.5x32 mm t8	365 3158
MKS 350 VH		
HSS saw blade DM05	Ø 350x2.5x32 mm t4	365 3504
HSS saw blade DM05	Ø 350x2.5x32 mm t6	365 3506
HSS saw blade DM05	Ø 350x2.5x32 mm t8	365 3508
HSS saw blade DM05	Ø 350x2.5x32 mm t10	365 3510
LMS 400, LMS 400 H, LMS 400 A		
HM saw blade	Ø 400x4.0x32 mm Z96	365 4048

Tooth pitch (t)

Make sure to use the correct tooth pitch when choosing the appropriate saw blade to cut a material which is the condition for a good cutting result. An easy rule is that you have to choose the smallest tooth pitch which guarantees a good chip ejection from the cutting zone. This rule does not help to find the tooth pitch however it explains the logic for the right choice.

It is necessary to know the following parameters to make the right choice: 1. Material cross section of the material, 2. Material type, 3. Application resp. cutting method

Cutting speed and feed

The choice of the correct saw blade speed and feed speed is decisive to optimize the cutting process. There is a close relationship between both speeds. If for instance the saw blade speed is too high in relation to the feed of the saw unit the workpiece will be rather polished than machined. The saw blade will be overheated and worn without attaining machining performance.

The following table includes recommendations for the correct use of our metal circular saw blades which of course are only approximate values:

	Steels up to 1500 N/m ²	Steels up to 1800 N/m ²	Steels up to 1200 N/m ²	Rustless Steels	Cast	Aluminium	Bronze/ Copper	Brass
Pipes / Profiles	Tooth pitch t (mm)							
Wall thickness	Tooth pitch t (mm)							
up to 1 mm	3	3	3	3	-	4	4	4
1-1.5 mm	4	4	3	4	-	5	5	5
1.5-2 mm	5	4	4	5	-	6	6	6
2-3 mm	5	5	5	5	-	7	7	7
from 3 mm	6	6	5	6	-	8	8	8 on
Full material	Tooth pitch t (mm)							
Cross section	Tooth pitch t (mm)							
10-20 mm	5	5	5	5	5	6	6	8
20-40 mm	8	6	6	6	6	8	8	10
40-60 mm	10	10	8	8	8	12	10	12
60-90 mm	12	12	10	11	11	16	13	14
90-110 mm	14	14	12	14	14	18	15	17
110-130 mm	16	16	14	16	16	20	17	19
130-150 mm	18	16	14	16	16	20	19	20
Tooth pitch t (mm)	Feed A (mm/min) for solid material pipes/profiles							
3	350-450	250-350	90-160	70-150	350-550	-	-	-
4	300-400	200-300	80-140	60-130	280-440	-	-	-
5	250-350	150-250	70-130	55-110	210-350	-	-	-
6	200-300	100-180	60-120	50-90	180-300	-	1400-2000	2000-4000
8	150-250	80-130	35-90	40-75	140-250	4500-8500	1000-1600	1500-3200
10	100-200	70-100	40-80	35-65	120-180	3800-6000	700-1200	1000-2500
12	80-150	65-90	35-65	30-55	90-150	3000-5000	550-850	800-1800
14	70-130	60-80	25-50	20-50	75-125	2800-4600	500-700	700-1400
16	50-120	55-70	15-40	15-35	65-110	2500-3700	400-600	600-1000
Ø Saw blade	min⁻¹							
250 mm	40-65	25-50	20-30	15-25	40-65	750-1100	250-380	500-700
300 mm	30-55	20-45	15-25	10-20	30-55	650-950	210-320	430-640
315 mm	30-50	20-40	15-25	10-20	30-50	600-900	200-300	400-600
350 mm	25-45	20-35	15-25	10-20	25-45	550-820	180-270	350-550
400 mm	20-40	15-30	10-20	8-15	20-40	470-720	160-240	300-480