

Circular saws



Important notice

We exclusively use steam-treated saw blades (HSS DM 05).

What does steam treatment achieve? Steaming at 500°C achieves controlled oxidation. A ferric oxide layer (Fe_3O_2) is created on the surface of the saw blades, thus improving the sliding quality while at the same time protecting against corrosion. Additionally, internal stresses in the blade are eliminated, thus reducing the risk of breakage and significantly improving the service life. This is why you should always order saw blades by METALLKRAFT.

Metal-cutting circular saw, manual/Metal dry cutter

HKS 230 – Metal hand-held circular saw for workshops and building sites when cutting aluminium, steel and stainless steel

- ▶ The ideal machine for assembly shops, facade builders, locksmiths, repair workshops, trade fair constructors etc.
- ▶ Ideal for applications where angle grinders are not strong enough or cannot work cleanly
- ▶ Cuts stainless steel without burrs
- ▶ Cuttings conduct the heat away, hence only low heat formation during cutting
- ▶ Highly resilient motor with soft start and overload protection
- ▶ Immersion in the material possible
- ▶ Uncomplicated and rapid cutting depth setting based on a precise and easy-to-read scale
- ▶ Stable and robust structure
- ▶ Handle can be screwed in at two different positions for convenient handling of the saw in any position
- ▶ Easy to use



- ▶ Uncomplicated and rapid cutting depth setting based on a precise and easy-to-read scale



- ▶ Rapid saw blade change by gear locking pin



- ▶ With twofold guided parallel limit stop for exact cut guidance



- ▶ Continuously adjustable and convenient setting of the mitre angle; grid division at 0°, 15°, 30° and 45°



- ▶ Handle can be converted so that the saw can be safely guided parallel to the cutting plane

Model	HKS 230 *
Art. no.	3840231

Technical specifications	
Motor output 230 V / 50 Hz	1.7 kW
Speeds	2 220 rpm
Cutting range 90° □ / Wall thickness	80 mm
Cutting range 45° □ / Wall thickness	56 mm
Max. saw blade diameter	Ø 230 mm
Saw blade bore	Ø 25.4 mm
Saw blade thickness	2 mm
Dimensions (LxWxH)	620 x 320 x 270 mm
Weight	7.1 kg

* Machine is supplied in sturdy plastic case without saw blade
196

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



Steel



Aluminium



Stainless steel

Saw blades Ø 230 x 25.4 mm	Blade thickness	Number of teeth	Art. no.
Steel	2.0 mm	48	3850231
Aluminium	2.4 mm	80	3850232
Stainless steel	1.8 mm	60	3850233

MTS 356 – Metal dry cutter, sawing metal without coolant

- ▶ Extremely stable and robust structure
- ▶ Easy to transport
- ▶ For virtually burr-free sawing of sections and pipes made of steel, iron, copper, brass, aluminium, plastics, composite materials and stainless steel, without needing a coolant
- ▶ For use in metalworking, carpentry, interior fitting, etc.
- ▶ Soft-start motor for easier handling on

- switching on the saw
- ▶ Includes prism clamping jaws for clamping pipes as standard equipment
- ▶ Easily adjustable clamps
- ▶ Stable thanks to die-cast aluminium feet
- ▶ Angle for mitre cuts
- ▶ right 45°, left 39°
- ▶ With length stop for precise cutting
- ▶ With spindle lock for easy saw blade replacement



Chassis
foldable
Art no. 3630000



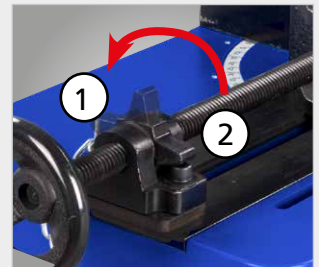
Prism clamping jaw
1 piece included in
scope of supply

Scope of delivery:

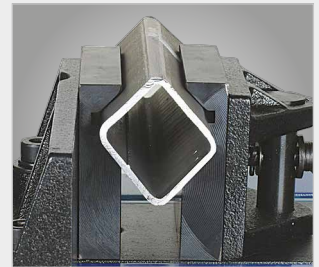
- › 4, 6 and 8 mm Allen key
- › Protective eyewear
- › 1 Prism clamping jaw
- › Without saw blade



- ▶ Mitre angle easy to read off the scale
- ▶ Vice continuously adjustable swivel from right 45°, left 39°
- ▶ Easily adjustable clamps



- ▶ Saw equipped with quick-release vice, by changing over the toggle lever between the quick-release (Pos. 1) and clamping (Pos. 2)



- ▶ Prism vice for pipes
- ▶ (second prism jaws optional, art. no. 3850355)



Steel

Aluminium

Model	MTS 356
Art. no.	3840355

Technical specifications	
Motor output 230 V / 50 Hz	2.2 kW
Speeds	1 300 rpm
Cutting range 0°	100 x 180 mm (H x W)
Cutting range 0°	120 x 120 mm
Cutting range 0°	132 mm
Cutting range right 45°, left 39°	120 x 90 mm (H x W)
Cutting range right 45°, left 39°	90 x 90 mm
Cutting range right 45°, left 39°	105 mm
Saw blade diameter	Ø 355 mm
Weight	23.5 kg

Accessories	Number of teeth	Art. no.
Chassis MTS 356		3630000
Prism clamping jaw		3850355
Saw blades Ø 355 x 2.4 x 25.4 mm		
- Steel	80	3853504
- Aluminium	80	3853502
Saw blades Ø 305 x 2.4 x 25.4 mm		
- Steel	60	3853051

Metal-cutting circular saws

Manual metal-cutting circular saws with one and two speeds, and swivelling saw head and vice for mitre cuts

- ▶ For steel
- ▶ Two cutting speeds
- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Automatic diaphragm coolant pump with coolant filter as standard
- ▶ moving guard ensures optimum safety while cutting
- ▶ Control handle with safety switch
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection
- ▶ Swivels from -45° to +45°
- ▶ Machine head swivels through 45° anti-clockwise and 45° clockwise
- ▶ Vice swivels through 45° anti-clockwise and 45° clockwise
- ▶ Quick release vice with double clamping device guarantees precise and virtually burr-free cutting



MKS 250 N
Standard scope of supply



MKS 255 N
▶ Double vice, swivelling from -45° to +45° with quick release

Scope of delivery:

- › Coolant system
- › Cross-cut fence 500 mm
- › Operating tool
- › Without saw blade
- › without chassis

Model	MKS 250 N	MKS 255 N	MKS 275 N
Art. no.	3620251	3620253	3620275
Technical specifications			
Motor output 50 Hz	1.1 kW / 230 V	0.95 - 1.32 kW / 400 V	1.1 - 1.5 kW / 400 V
Speeds	40 - 80 rpm	40 - 80 rpm	40 - 80 rpm
Vice jaw width	100 mm	100 mm	105 mm
Saw blade diameter	Ø 250 mm	Ø 250 mm	Ø 275 mm
Run-in height incl. chassis	970 mm	970 mm	970 mm
Dimensions (L x W x H)	800 x 830 x 755 mm	800 x 830 x 755 mm	830 x 900 x 1 025 mm
Weight	91 kg	94 kg	98 kg

Cutting capacity MKS 250 N

	●	○	□	▭
0°	40	70	70 x 70	55 x 95
45°/45°	35	65	60 x 60	50 x 65

Cutting capacity MKS 255 N

	●	○	□	▭
0°	40	70	70 x 70	55 x 95
45°/45°	35	65	55 x 55	55 x 60

Cutting capacity MKS 275 N

	●	○	□	▭
0°	45	65	65 x 65	85 x 60
45°/45°	40	60	40 x 40	40 x 60

Cutting capacity MKS 275 N optionally with saw blade 315 N

	●	○	□	▭
0°	45	80	80 x 80	100 x 70
45°/45°	40	80	70 x 70	80 x 70

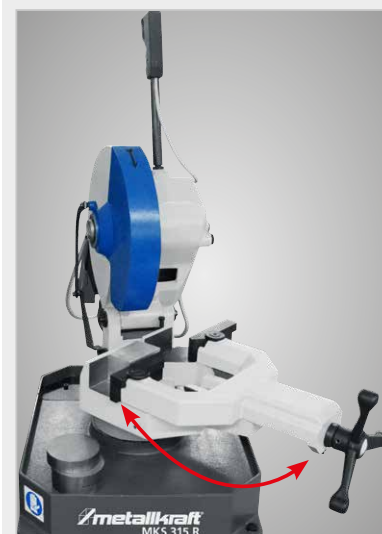


MKS 275 N

MKS 275 N

Scope of delivery:

- › Coolant system
- › Cross-cut fence 500 mm
- › Operating tool
- › Without saw blade
- › without chassis



- ▶ Quick release vice swivelling through 45° anti-clockwise and 45° clockwise

Micro-dosing unit standard equipment
Universally deployable for minimal lubrication of
tool blades and forming tools

- ▶ Separate air and spraying agent lines avoid dripping

- ▶ With extra large lubricant tank, frequency-controlled pump and spray head

Micro-dosing unit MD 11

- ▶ For circular saws and metal-cutting band saws

Micro-dosing unit MD 12, special features

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



MD 11



MD 12

Accessories

Machine chassis MKS 250 N/255 N/275 N

Coolant concentrate 5 l

Spraying agent 5 l, micro-dosing unit

Micro-dosing unit MD 11 - 24V AC

Micro-dosing unit MD 12 - 24V AC

Micro-dosing unit assembly

Saw blades MKS 250/255 N

HSS saw blade DM05 Ø250x2x32 mm t4 ¹⁾

HSS saw blade DM05 Ø250x2x32 mm t6 ¹⁾

Saw blades MKS 275 N

HSS saw blade DM05 Ø275x2.5x32 mm t4 ¹⁾

HSS saw blade DM05 Ø275x2.5x32 mm t6 ¹⁾

HSS saw blade DM05 Ø275x2.5x32 mm t8 ¹⁾

¹⁾t = tooth spacing ²⁾Price without installation on the saw



Chipmag swarf remover

- ▶ magnetic Art. no. 3850010

Metal-cutting circular saws

Manual metal-cutting circular saws with 315 mm saw blade, one and two speeds, and swivelling saw head and vice for mitre cuts



- ▶ two cutting speeds
- ▶ swivelling machine head by 45° anti-clockwise and 45° clockwise
- ▶ Reduction gear running in oil bath
- ▶ automatic diaphragm coolant pump with coolant filter as standard
- ▶ Quick release vice with burr-prevention unit, swivelling through 45° anti-clockwise and 45° clockwise

- ▶ Vice longitudinally displaceable, and thus suitable for longitudinal cutting and slotting
- ▶ moving guard ensures optimum safety while cutting
- ▶ Control handle with safety switch
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection

Equipment MKS 315 R / MKS 316 R

- ▶ with adjustable slip clutch, thus ruling out breaking of the saw blade
- ▶ **MKS 316 R low-speed, and thus perfect for working with stainless steel**



▶ Quick release vice swivelling through 45° anti-clockwise and 45° clockwise



MKS 315 N

Scope of delivery MKS 315 N:

- › Coolant system
- › Cross-cut fence 500 mm
- › Operating tool
- › **Without saw blade**
- › **Without chassis**



MKS 315 R / MKS 316 R

Scope of delivery MKS 315 R / MKS 316 R:

- › Coolant system with filter
- › Material support arm with roller
- › Cross-cut fence 500 mm
- › Operating tool
- › **Without saw blade**
- › **Without chassis**

Cutting capacity MKS 315 N

	●	○	□	▭
0°	55	90	80 x 80	70 x 115
45°/45°	50	80	70 x 70	70 x 70

Cutting capacity MKS 315 R / 316 R

	●	○	□	▭
0°	65	90	85 x 85	70 x 120
45°/45°	60	80	70 x 70	70 x 80

Model	MKS 315 N	MKS 315 R	MKS 316 R
Art. no.	3620303	3621315	3621316

Technical specifications	MKS 315 N	MKS 315 R	MKS 316 R
Motor output 50 Hz/400 V	1.5 - 2.2 kW	1.5 - 2.2 kW	1.32 - 1.91 kW
Speeds	40 - 80 rpm	40 - 80 rpm	20 - 40 rpm
Vice jaw width	120 mm	120 mm	120 mm
Saw blade diameter	Ø 315 mm	Ø 315 mm	Ø 315 mm
Run-in height incl. chassis	1 015 mm	1 015 mm	1 015 mm
Length	1 000 mm	1 000 mm	1 000 mm
Width	1 150 mm	1 150 mm	1 150 mm
height	1 475 mm	1 475 mm	1 475 mm
Weight	165 kg	193 kg	193 kg

Accessories

	Art. no.
Machine chassis	3643171
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020
Micro-dosing unit assembly	9002000

Saw blades MKS 315 N/315 R/316 R

HSS saw blade DM05 Ø315x2.5x32 mm t4 ¹⁾	3653154
HSS saw blade DM05 Ø315x2.5x32 mm t6 ¹⁾	3653156
HSS saw blade DM05 Ø315x2.5x32 mm t8 ¹⁾	3653158

Saw blades for stainless steel MKS 315 R

HSS-E saw blade Ø315x2.5x32 mm t4 ¹⁾	3653254
HSS-E saw blade Ø315x2.5x32 mm t6 ¹⁾	3653256

¹⁾t = tooth spacing



Chipmag swarf remover
magnetic Art. no. 3850010,

MKS 350 – manual metal-cutting circular saw with 350 mm saw blade

MKS 350 H – semi-automatic version



- ▶ Stable and robust structure
- ▶ two cutting speeds standard
- ▶ machine head swivels through 45° anti-clockwise and 90° clockwise
- ▶ Reduction gear running in oil bath
- ▶ includes diaphragm coolant pump with filter
- ▶ double vice with counter vice and burr-prevention jaws guarantees precise and burr-free cutting
- ▶ Vice longitudinally displaceable, and thus suitable for longitudinal cutting and slotting
- ▶ Quick release vice swivelling through 45° anti-clockwise and 45° clockwise

- ▶ moving guard ensures optimum safety while cutting
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection
- ▶ Control handle with safety switch
- ▶ **MKS 351 R low-speed, and thus perfect for working with stainless steel**

Semi-automatic mode MKS 350 H

- ▶ Motor is activated and
- ▶ Vice closed
- ▶ Saw head lowered for cutting
- ▶ Saw head returns to original position and motor stops
- ▶ Vice opens



- ▶ Quick release vice swivelling through 45° anti-clockwise and 45° clockwise



MKS 350 / MKS 351



MKS 350 H

Scope of delivery MKS 350 / MKS 351:

- › Coolant system
- › Cross-cut fence 500 mm
- › Operating tool
- › **Without saw blade**
- › **Without chassis**

Scope of delivery MKS 350 N:

- › Coolant system
- › Cross-cut fence 500 mm
- › Operating tool
- › **Without saw blade**
- › **incl. chassis**

Cutting capacity MKS 350 / MKS 351 / MKS 350 H

	●	○	□	▭
0°	60	110	100 x 100	80 x 120
45°/45°	55	80	80 x 80	80 x 80

Model	MKS 350	MKS 351	MKS 350 H
Art. no.	3621350	3621351	3620352

Technical specifications			
Motor output 400 V / 50 Hz	1.8 - 2.4 kW	1.5 - 2.2 kW	1.8 - 2.4 kW
Speeds	40 - 80 rpm	20 - 40 rpm	40 - 80 rpm
Vice jaw width	120 mm		
Saw blade diameter	Ø 350 mm		
Run-in height incl. chassis	1 025 mm		
Length	1 000 mm		
Width	1 200 mm		
height	1 475 mm		
Weight	231 kg		

Accessories

	Art. no.
Machine chassis MKS 350/351	3643171
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 350/351/350 H

HSS saw blade DM05Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05Ø 350x2.5x32 mm t6 ¹⁾	3653506

Saw blades for stainless steel MKS 351

HSS-E saw blade Ø 350x2.5x32 mm t4 ¹⁾	3653514
HSS-E saw blade Ø 350x2.5x32 mm t6 ¹⁾	3653516

¹⁾ t = tooth spacing ²⁾ Price without installation on the saw



Chipmag swarf remover magnetic Art. no. 3850010,

Vertical metal-cutting circular saws



MKS 315 V – manual vertical metal-cutting circular saw with 315 mm saw blade

MKS 350 V – manual vertical metal-cutting circular saw with 350 mm saw blade

MKS 316 V – low-speed version for cutting stainless steel

- ▶ Stable and robust structure
- ▶ easy and trouble-free operation
- ▶ two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 60° clockwise, with stops at -45°, 0°, -45°, 60°
- ▶ Adjustable depth stop for vertical stroke of saw head
- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter
- ▶ Coolant jet distribution for improved saw blade lubrication
- ▶ laterally displaceable vice with burr-prevention unit
- ▶ Chip breaker for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection
- ▶ Control handle with safety switch

Accessories



Chipmag swarf remover

- ▶ magnetic Art. no. 3850010,



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

- › Coolant system with filter
- › Material support arm with roller
- › Cross-cut fence 500 mm
- › Operating tool
- › Swarf remover T4
- › **Without saw blade**

Cutting capacity MKS 315 V, 316 V

	●	○	□	▭
0°	70	100	90 x 90	80 x 135
45°	70	100	90 x 90	80 x 100
45°	70	100	90 x 90	80 x 100
60°	70	80	70 x 70	70 x 70

Cutting capacity MKS 350 V

	●	○	□	▭
0°	100	120	100 x 100	90 x 170
45°	100	120	90 x 90	90 x 125
45°	100	120	90 x 90	90 x 125
60°	90	90	90 x 90	90 x 90

Model	MKS 315 V	MKS 316 V	MKS 350 V
Art. no.	3622315	3622316	3622350

Technical specifications			
Motor output 400 V/50 Hz	1.3 - 1.8 kW	1.3 - 1.8 kW	1.9 - 2.5 kW
Speeds	33 - 66 rpm	17 - 34 rpm	36 - 72 rpm
Vice jaw width	160 mm		185 mm
Saw blade diameter	Ø 315 mm		Ø 370 mm
Run-in height incl. chassis	910 mm		905 mm
Length	1 500 mm		1 050 mm
Width	650 mm		1 000 mm
height	1 700 mm		1 850 mm
Weight	270 kg		450 kg

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000
Spraying agent 5 l, micro-dosing unit	3608020
Saw blades MKS 315 V/316 V	
HSS saw blade DM05 Ø 315x2.5x32 mm t4 ¹⁾	3653154
HSS saw blade DM05 Ø 315x2.5x32 mm t6 ¹⁾	3653156
HSS saw blade DM05 Ø 315x2.5x32 mm t8 ¹⁾	3653158
Saw blades for stainless steel MKS 316 V	
HSS-E saw blade Ø 315x2.5x32 mm t4 ¹⁾	3653254
HSS-E saw blade Ø 315x2.5x32 mm t6 ¹⁾	3653256
Saw blades MKS 350 V	
HSS saw blade DM05 Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05 Ø 350x2.5x32 mm t6 ¹⁾	3653506
HSS saw blade DM05 Ø 350x2.5x32 mm t8 ¹⁾	3653508
HSS saw blade DM05 Ø 350x2.5x32 mm t10 ¹⁾	3653510
¹⁾ t = tooth spacing ²⁾ Price without installation on the saw	
Chip remover for MKS 315/350 V	
051/24 for Ø 315, 350 mm t4	03620512404
051/24 for Ø 315, 350 mm t6	03620512406
051/24 for Ø 315, 350 mm t8	03620512408
051/24 for Ø 315, 350 mm t10	03620512410

MKS 315 VH – semi-automatic vertical metal-cutting circular saw with 315 mm saw blade. MKS 350 VH – semi-automatic vertical metal-cutting circular saw with 350 mm saw blade

- ▶ Stable and robust structure
- ▶ easy and trouble-free operation
- ▶ two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 60° clockwise, with stops at -45°, 0°, -45°, 60°
- ▶ Adjustable depth stop for vertical stroke of saw head

- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter
- ▶ Coolant jet distribution for improved saw blade lubrication
- ▶ laterally displaceable pneumatic quick release vice with burr-prevention unit
- ▶ Chip breaker for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch, undervoltage trip and overload protection

Semi-automatic mode

- ▶ Vice closes and motor is activated
- ▶ Saw head lowered for cutting
- ▶ Motor stops and saw head returns to original position
- ▶ Vice opens



MKS 315 VH



MKS 350 VH

Scope of delivery:

- › MKS 315: Material support arm with roller
- › MKS 350: Material roller conveyor 1 000 mm
- › Cross-cut fence 500 mm

- › Operating tool
- › Swarf remover T4
- › **Without saw blade**
- › Coolant system with filter

Cutting capacity MKS 315 VH

	●	○	□	▭
0°	70	100	90 x 90	80 x 135
45°	70	100	90 x 90	80 x 100
45°	70	100	90 x 90	80 x 100
60°	70	80	70 x 70	70 x 70

Cutting capacity MKS 350 VH

	●	○	□	▭
0°	100	120	100 x 100	90 x 170
45°	100	120	90 x 90	90 x 125
45°	100	120	90 x 90	90 x 125
60°	90	90	90 x 90	90 x 90

Model	MKS 315 VH	MKS 350 VH
Art. no.	3623315	3623350
Technical specifications		
Motor output 3 x 400 V/50 Hz	1.3 - 1.8 kW	1.9 - 2.5 kW
Speeds	33 - 66 rpm	36 - 72 rpm
Clamping width machine vice	160 mm	185 mm
Saw blade diameter	Ø 315 mm	Ø 370 mm
Run-in height incl. chassis	910 mm	905 mm
Length	1 500 mm	2 640 mm
Width	650 mm	1 200 mm
height	2 000 mm	2 000 mm
Weight	300 kg	450 kg

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000
Spraying agent 5 l, micro-dosing unit	3608020
Saw blades MKS 315 V/316 V	
HSS saw blade DM05 Ø 315x2.5x32 mm t4 ¹⁾	3653154
HSS saw blade DM05 Ø 315x2.5x32 mm t6 ¹⁾	3653156
HSS saw blade DM05 Ø 315x2.5x32 mm t8 ¹⁾	3653158
Saw blades MKS 350 V	
HSS saw blade DM05 Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05 Ø 350x2.5x32 mm t6 ¹⁾	3653506
HSS saw blade DM05 Ø 350x2.5x32 mm t8 ¹⁾	3653508
HSS saw blade DM05 Ø 350x2.5x32 mm t10 ¹⁾	3653510

¹⁾ t = tooth spacing ²⁾ Price without installation on the saw

Chip remover for MKS 315 VH/350 VH

051/24 for Ø 315, 350 mm t4	03620512404
051/24 for Ø 315, 350 mm t6	03620512406
051/24 for Ø 315, 350 mm t8	03620512408
051/24 for Ø 315, 350 mm t10	03620512410

Vertical metal-cutting circular saws

MKS 315 VA – Automatic hydro-pneumatic vertical metal-cutting circular saw with CNC control

Arguments that impress in terms of quality, performance and price.

- ▶ Stable and robust structure
- ▶ Easy and intuitive use
- ▶ Two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 60° clockwise, with stops at 45°, 0°, -45°, -60°
- ▶ Adjustable depth stop for vertical stroke of saw head
- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter
- ▶ Coolant jet distribution for improved saw blade lubrication

- ▶ Laterally displaceable pneumatic quick release vice with burr-prevention unit
- ▶ Chip breaker T6 for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch, undervoltage trip and overload protection
- ▶ the control unit has 49 programs, each with up to 99 individual steps

Automatic mode

- ▶ Material feed
- ▶ Vice closes and motor is activated
- ▶ Coolant pump activated
- ▶ Saw head lowered for cutting
- ▶ Feed carriage returns to the defined dimension
- ▶ Saw head returns to original position
- ▶ Vice opens
- ▶ Cycle repeats



MKS 315 VA

Scope of delivery:

- › Machine chassis
- › Coolant system with filter
- › Material roller conveyor 1 000 mm
- › Operating tool
- › Instructions for use
- › Swarf remover T4
- › Without saw blade

Cutting capacity MKS 315 VA

	●	○	□	▭
0°	70	100	90 x 90	80 x 120
45°	70	90	80 x 80	80 x 80
45°	70	90	80 x 80	80 x 80
60°	70	80	70 x 70	80 x 70

Model	MKS 315 VA
Art. no.	3624315

Technical specifications	
Motor output 3 x 400 V/50 Hz	1.3 - 1.8 kW
Speeds	33 - 66 rpm
Feed	600 mm
Clamping width machine vice	120 mm
Saw blade diameter	Ø 315 mm
Dimensions (L x W x H)	2 500 x 1 000 x 2 000 mm
Weight	550 kg

Accessories

	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 315 VA

HSS saw blade DM05 Ø 315x2.5x32 mm t ₄ ¹⁾	3653154
HSS saw blade DM05 Ø 315x2.5x32 mm t ₆ ¹⁾	3653156
HSS saw blade DM05 Ø 315x2.5x32 mm t ₈ ¹⁾	3653158

¹⁾ t = tooth spacing

Chip remover for MKS 315 VA

051/24 for Ø 315, 350 mm t ₄	03620512404
051/24 for Ø 315, 350 mm t ₆	03620512406
051/24 for Ø 315, 350 mm t ₈	03620512408
051/24 for Ø 315, 350 mm t ₁₀	03620512410

MKS 350 VA – Automatic hydraulic vertical metal-cutting circular saw with CNC control

Arguments that impress in terms of quality, performance and price.

- ▶ Stable and robust structure
- ▶ easy and intuitive use
- ▶ the control unit has 49 programs, each with up to 99 individual steps
- ▶ two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 45° clockwise, with stops at 45°, 0°, -45°
- ▶ Adjustable depth stop for vertical stroke of saw head

- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter
- ▶ Coolant jet distribution for improved saw blade lubrication
- ▶ laterally displaceable hydraulic quick release vice with burr-prevention unit
- ▶ Chip breaker T6 for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch, undervoltage trip and overload protection

Automatic mode

- ▶ Material feed
- ▶ Vice closes and motor is activated
- ▶ Activation of coolant pump; saw head lowered for cutting
- ▶ Feed carriage returns to the defined dimension
- ▶ Saw head returns to original position
- ▶ Vice opens
- ▶ Cycle repeats



MKS 350 VA

Scope of delivery:

- › Machine chassis
- › Coolant system with filter
- › Material roller conveyor 1 000 mm
- › Instructions for use
- › Swarf remover T4
- › Without saw blade

Cutting capacity MKS 350 VA

	●	○	□	▬
	100	130	120 x 120	100 x 170
	100	130	110 x 110	100 x 140

Model	MKS 350 VA
Art. no.	3624350

Technical specifications	
Motor output 3 x 400 V/50 Hz	1.9 - 2.5 kW
Speeds	25/50 rpm
Feed	600 mm
Clamping width machine vice	185 mm
Saw blade diameter	Ø 370 mm
Dimensions (L x W x H)	3 500 x 1 200 x 1 900 mm
Weight	900 kg

Accessories

	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 315 VA

HSS saw blade DM05 Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05 Ø 350x2.5x32 mm t6 ¹⁾	3653506
HSS saw blade DM05 Ø 350x2.5x32 mm t8 ¹⁾	3653508
HSS saw blade DM05 Ø 350x2.5x32 mm t10 ¹⁾	3653510

¹⁾ t = tooth spacing

Chip remover for MKS 350 VA

051/24 for Ø 315, 350 mm t4	03620512404
051/24 for Ø 315, 350 mm t6	03620512406
051/24 for Ø 315, 350 mm t8	03620512408
051/24 for Ø 315, 350 mm t10	03620512410

Vertical metal-cutting circular saws/light alloy metal-cutting circular saws

LMS 400 / LMS 400 H / LMS 400 P – manual and semi-automatic light alloy metal-cutting circular saws with 400 mm saw blade



- ▶ Circular sawing machines for cutting full material and profiles made of aluminium and light alloys
- ▶ Stable and robust structure
- ▶ Easy and trouble-free operation
- ▶ Precise cutting
- ▶ Saw head swivels through 45° anti-clockwise and 45° clockwise
- ▶ Saw head tilts 45° anti-clockwise for compound cut
- ▶ Rotary plate with bearings
- ▶ Sawing shaft with bearings

LMS 400

- ▶ Manual version
- ▶ Two manual vices with plastic covered aluminium jaws
- ▶ Saw head swivels 45° anti-clockwise for compound cut

LMS 400 H

- ▶ Semi-automatic version
- ▶ Two pneumatic quick release vices with plastic covered aluminium jaws

LMS 400 P

- ▶ Saw head swivels 45° anti-clockwise for compound cut
- ▶ Two pneumatic vices with plastic covered aluminium jaws
- ▶ Control handle with safety switch



LMS 400

Scope of supply LMS 400:

- › Cross-cut fence 500 mm
- › Operating tool
- › **Without chassis**
- › **Without saw blade**



LMS 400 H

Scope of supply LMS 400 H:

- › Material support arm with roller
- › Cross-cut fence 500 mm
- › Operating tool
- › **With chassis**
- › **Without saw blade**



LMS 400 P

Scope of supply LMS 400 P:

- › Two pneumatic quick release vices
- › Cross-cut fence 500 mm
- › Operating tool
- › **Without chassis**
- › **Without saw blade**

Model	LMS 400	LMS 400 H	LMS 400 P
Art. no.	3625400	3625401	3625402

Technical specifications			
Motor output 3 x 400 V/50 Hz	2.2 kW	2.2 kW	2.2 kW
Speeds	3 000 rpm	3 000 rpm	3 000 rpm
Clamping width machine vice	180 mm	180 mm	180 mm
Saw blade diameter	Ø 400 mm	Ø 400 mm	Ø 400 mm
Run-in height incl. chassis	855 mm	855 mm	855 mm
Dimensions (L x W x H) in mm	1 500 x 1 000 x 900	1 500 x 1 000 x 1 600	1 500 x 1 000 x 1 600
Weight	160 kg	210 kg	210 kg

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

	●	○	□	▭
0°	60	140	110 x 110	100 x 180
45°/45°	60	130	100 x 100	100 x 150

Micro-dosing unit standard equipment

Universally deployable for minimal lubrication of tool blades and forming tools.

Separate air and spraying agent lines avoid dripping

- ▶ With extra large lubricant tank, frequency-controlled pump and spray head

Micro-dosing unit MD 11

- ▶ For circular saws and metal-cutting band saws



MD 11

Micro-dosing unit MD 12, special features

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



MD 12

Accessories

	Art. no.
Machine chassis LMS 400	3644071
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000
Saw blades MKS 315 VA	
HM saw blade Ø 400 x 4.0 x 32 mm T96	3654048

LMS 400 A – automatic light alloy metal-cutting saw with 400 mm saw blade

- ▶ automatic circular sawing machine for cutting full material and profiles made of aluminium and light alloys
- ▶ Stable and robust structure
- ▶ easy and intuitive use
- ▶ precise cutting
- ▶ rotary plate with bearings
- ▶ three pneumatic quick release vices with Teflon jaws
- ▶ Automatic mode
- ▶ Material feed
- ▶ Vice closes and motor is activated
- ▶ Coolant pump activated
- ▶ Saw head is lowered until the cut is complete
- ▶ Feed carriage returns to the defined dimension
- ▶ Saw head returns to original position
- ▶ Vice opens
- ▶ Cycle repeats



Scope of delivery:

- › Material roller conveyor 1 000 mm
- › Cross-cut fence 500 mm
- › Operating tool

Model	LMS 400 A
Art. no.	3625404

Technical specifications	
Motor output 3 x 400 V/50 Hz	2.2 kW
Speeds	3 000 rpm
Clamping width machine vice	180 mm
Saw blade diameter	Ø 400 mm
Feed length	900 mm
Run-in height incl. chassis	910 mm
Dimensions (L x W x H)	3 800 x 1 600 x 1 700 mm
Weight	510 kg

Cutting capacity LMS 400 A

	●	○	□	▭
	60	140	110 x 110	100 x 180

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000
Saw blades MKS 315 VA	
HM saw blade Ø 400 x 4.0 x 32 mm T96	3654048

¹⁾ Price without installation on the saw



Underground light metal cutting circular saw

New

ULMS – Automatic light alloy metal-cutting saw with upright blade Ø 420/500 mm

- ▶ For cutting aluminium and plastic profiles
- ▶ Safe cutting thanks to cover equipped with safety sensor
- ▶ Cutting at mitre angles between -45° and +45°
- ▶ Continuously adjustable saw blade feed
- ▶ Pneumatic vertical and horizontal clamping
- ▶ Integrated minimum quantity lubrication



Fig. shows **ULMS 420** with **accessories** roller conveyor with cross-cut fence and manual measuring system with mm scale

Scope of supply **ULMS 420**

2x saw blade 420 x 30 x 4 mm T96

Cooling system

Scope of supply **ULMS 500**

2x saw blade 500 x 30 x 4 mm T120

Cooling system

Model	ULMS 420	ULMS 500
Art. no.	3627420	3627500

Technical specifications

Saw band speed	3 580 rpm	3 580 rpm
Saw blade diameter	420 mm	500 mm
Cutting angle	-90°, -67,5°, -45°, -30°, -22,5°, -15°, 0°, 15°, 22,5°, 30°, 45°	-90°, -67,5°, -45°, -30°, -22,5°, -15°, 0°, 15°, 22,5°, 30°, 45°
Speeds	3 000 rpm	3 000 rpm
Motor output	3 kW / 400 V	3 kW / 400 V
Dimensions (L x W x H)	795 x 1 080 x 1 325 mm	855 x 1 135 x 1 360 mm
Weight	213 kg	229 kg

Cutting capacity **ULMS 420**

	135 x 135
	125 x 125

Cutting capacity **ULMS 500**

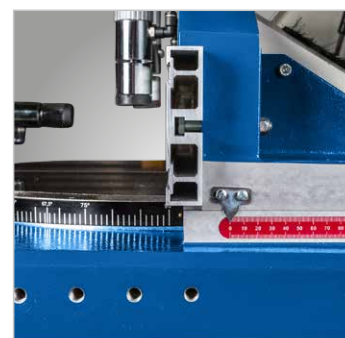
	170 x 170
	160 x 160

For the matching pure air deduster **RLA 1213 M** see our **HOLZKRAFT** catalogue 2019

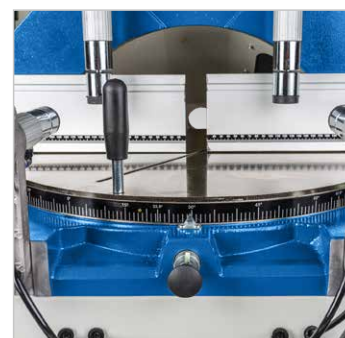




Simple and clear-cut operation



Stop continuously adjustable



Continuous adjustment of the mitre angle



Accessories	Art. no.
3 m roller conveyor with cross-cut fence and manual measuring system with mm scale.	3628003
Attachment side: right	
3 m roller conveyor with cross-cut fence and manual measuring system with mm scale.	3628004
Attachment side: left	
6 m roller conveyor with cross-cut fence and manual measuring system with mm scale.	3628006
Attachment side: right	
6 m roller conveyor with cross-cut fence and manual measuring system with mm scale.	3628007
Attachment side: left	
Saw blade 420 x 30 x 4 mm T96	3628042
Saw blade 500 x 30 x 4 mm T120	3628050

HOLZKRAFT minimax si 400es ALU 2 – professional, heavy-duty sliding table saws and format sliding sizing carriages made of anodised aluminium, specially designed for cutting aluminium and plastics

- ▶ Easy action, anodised aluminium sliding sizing carriage
- ▶ Table boom telescopic arm (longitudinally displaceable) with material roller and large surface area
- ▶ Extensible, telescopic cross-cut fence with two folding stops
- ▶ Precision rip fence, fold-away for large boards, with quick clamping and integrated granular adjustment
- ▶ With table width and length extension and eccentric clamp as standard
- ▶ **Robust, annular cast iron sawing unit – with double pivot segment guide (double cradle) and zero point pivoting for a smooth and perfect cut**
- ▶ Large torsion-free, grey cast work table
- ▶ On/off switch on sliding carriage
- ▶ Heavy deadweight ensures precision and smooth action
- ▶ Two cutting speeds switchable via inverter
- ▶ Stop below table can be swivelled away
- ▶ Cutting width 1270 mm

Scope of delivery minimax si400es 26 ALU 2:

Anodised aluminium sliding sizing carriage
Material roll on boom
Saw rip fence with rod guide
Table extension
Table width extension
Folding stops
Clamp sleigh
Eccentric clamp
Handle for sliding carriage
Saw blade swing protection
Micro-spraying device
2 saw blade speeds,
Electronically adjustable via inverter

Model	minimax si 400es 26 ALU 2
Art. no.	5504790

Technical specifications	
Table dimensions	940 x 560 mm
Table height	900 mm
Trimming length	3 200 mm
Dimensions sliding sizing carriage	360 x 142 x 3 200 mm
Max. cutting height 90°/45°	138 / 98 mm
Max. cross-cutting width left of saw blade	3 260 mm
Cutting width with rip fence	1270 mm
Saw blade angle	90° - 45°
Max. saw blade Ø	Ø 400 mm
Main saw blade speed	3 500/5 000 rpm
Motor output 400 V / 50 Hz / S6 - 40%	7.0 kW
Extraction port diameter	120 mm
Extraction duct Ø Saw blade protection	80 mm
Weight	715 kg
Transport width	990 mm



For the matching pure air deduster **RLA 1601 P & RLA 2001 P** see our HOLZKRAFT catalogue 2019

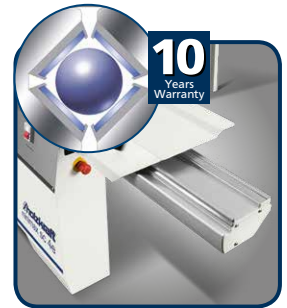
Info & video



Sliding
carriage
360 mm

Micro-dosing unit

- ▶ With extra large lubricant tank, frequency-controlled pump and spray head
- ▶ Separate air and spraying agent lines avoid dripping



Aluminium sliding carriage

- ▶ Sliding carriage is guided in highly-precise way and easily thanks to ball contact system proven in thousands of applications
- ▶ Ten years' HOLZKRAFT warranty on wear of the tempered guide rails

6 YEARS' HOLZKRAFT WARRANTY on wear of the swivelling segments



Tilt segment

- ▶ Permanent precision through 2x tilt segment guide



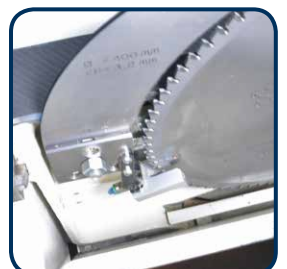
- ▶ With manual height adjustment and saw unit swivelling via hand-wheel
- ▶ Two cutting speeds switchable via inverter
- ▶ Switching-on of micro-spraying unit at side possible

For cutting
aluminium!



Accessories	Saw blade 400 mm
Art. no.	3650400
Saw blade Ø	400 mm
Saw blade hole	4.0 mm
Cutting width	30 mm
Saw blade teeth	72
Tooth shape	Triple-chip flat tooth
Quality	HM

**Cannot be retrofitted, only for new machine orders



- ▶ Micro-dosing unit directly on saw blade

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Metal-cutting band saws

Saw blades

Saw blades for all Metalkraft circular saws

HKS 230		Art. no.
Saw blade for steel	Ø 230 x 2.0 x 25.4 mm	3850231
Saw blade for aluminium	Ø 230 x 2.4 x 25.4 mm	3850232
Saw blade for stainless steel	Ø 230 x 1.8 x 25.4 mm	3850233
MTS 356		
Saw blade for steel	Ø 355 x 2.4 x 25.4 mm t80	3853504
Saw blade for aluminium	Ø 355 x 2.4 x 25.4 mm t80	3853502
Saw blade for stainless steel	Ø 355 x 2.4 x 25.4 mm t90	3853503
Saw blade for steel	Ø 305 x 2.4 x 25.4 mm t60	3853051
MKS 250 N, MKS 255 N		
HSS saw blade DM05	Ø 250 x 2 x 32 mm t4	3652504
HSS saw blade DM05	Ø 250 x 2 x 32 mm t6	3652506
MKS 275 N		
HSS saw blade DM05	Ø 275 x 2.5 x 32 mm t4	3652754
HSS saw blade DM05	Ø 275 x 2.5 x 32 mm t6	3652756
HSS saw blade DM05	Ø 275 x 2.5 x 32 mm t8	3652758
MKS 315 N, MKS 315 R, MKS 316 R		
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t4	3653154
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t6	3653156
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t8	3653158
Saw blades for stainless steel MKS 315 R		
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t4	3653254
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t6	3653256
MKS 350, MKS 351, MKS 350 H		
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t4	3653504
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t6	3653506

Saw blades for stainless steel MKS 351		Art. no.
HSS -E saw blade	Ø 350 x 2.5 x 32 mm t4	3653514
HSS -E saw blade	Ø 350 x 2.5 x 32 mm t6	3653516
MKS 315 V, MKS 316 V		
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t4	3653154
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t6	3653156
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t8	3653158

Saw blades for stainless steel MKS 316 V		
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t4	3653254
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t6	3653256
MKS 350 V		
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t4	3653504
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t6	3653506
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t8	3653508
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t10	3653510
MKS 315 VH		
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t4	3653154
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t6	3653156
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t8	3653158
MKS 350 VH		
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t4	3653504
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t6	3653506
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t8	3653508
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t10	3653510
LMS 400, LMS 400 H, LMS 400 A		
HM saw blade	Ø 400 x 4.0 x 32 mm t96	3654048

Teeth per inch (t)

When selecting a suitable saw blade for cutting a material, it is important to pay attention to the correct number of teeth per inch, which is a prerequisite for good cutting results. A rule of thumb states that the lowest teeth per inch figure should be selected that still allows for good swarf discharge from the cutting zone. This rule does not help you find the right tpi, but it does explain the logic of the right choice.

The following parameters must be known for the selection: 1. Cross section of the material, 2. Material type, 3. Application or cutting method

Cutting speed and feed

Choosing the right saw blade speed and feed rate is decisive to optimising the cutting process. There is a close relationship between the two speeds. For example, if the saw blade speed is too high compared to the saw's feed speed, the workpiece will be polished rather than cut. The saw blade will overheat and wear without providing cutting performance.

The following table contains recommendations for the correct use of our metal-cutting circular saw blades; of course, the values are only approximate guidelines:

	Steels up to 1 500 N/m²	Steels up to 1 800 N/m²	Steels up to 1 200 N/m²	Stainless steels	Cast iron	Aluminium	Bronze/copper	Brass
Pipes/sections wall thickness	Teeth per inch 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
Full materials cross cutting	Teeth per inch 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
Teeth per inch t (mm)	Feed A (mm/min) for full materials pipes/sections							
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	-	1 400-2 000	2 000-4 000
8	150-250	80-130	35-90	40-75	140-250	4 500-8 500	1 000-1 600	1 500-3 200
10	100-200	70-100	40-80	35-65	120-180	3 800-6000	700-1 200	1 000-2 500
12	80-150	65-90	35-65	30-55	90-150	3 000-5 000	550-850	800-1 800
14	70-130	60-80	25-50	20-50	75-125	2 800-4 600	500-700	700-1 400
16	50-120	55-70	15-40	15-35	65-110	2 500-3 700	400-600	600-1 000
Saw blade Ø	rpm							
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