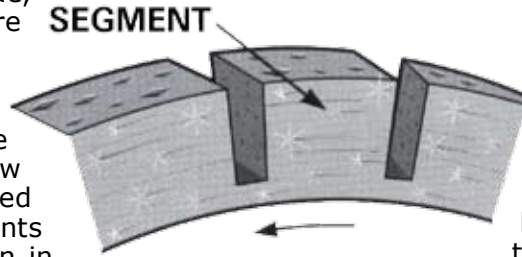


DIAMOND BLADE CUTTING TIPS

TIPS ON SAWING WITH DIAMOND BLADES

- Before mounting the blade, make sure saw flanges are clean, smooth and true.
- Mount blade in proper rotation direction. Always rotate the blade in the same direction. Be sure you follow the directional arrows marked on the blade. The segments will also indicate the direction in which the blade should turn. Trails will show following the diamonds. Mount blade with the diamonds leading.
- Be sure to tighten the blade firmly on the shaft.
- Make sure the blade is not touching the work surface.
- Start saw engine.
- Position saw and turn on water feed.
- Put saw at the maximum RPM's for the blade size being used.
- With the new blade, lower blade into the work surface approximately 1". This should take approximately 4 seconds. Cut about 15-18 feet at slow travel speed. Slow travel speed should be about 5-6 feet per minute for "break in" period. Return to the start of



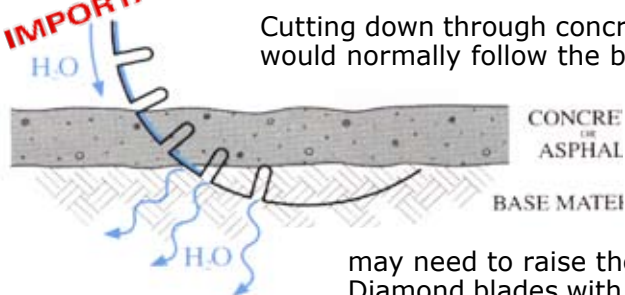
the cut. Lower the blade to the desired depth of cut and start cutting at slow travel. Ease into a slight faster travel speed until the blade begins to ease up out of the cut. Slightly reduce the travel speed cutting depth and stays there. This is the right speed for the blade cuts too slowly, the bonding of the segment may be too hard for the material being cut, or it may be simply

- be rotating too fast. Check your saw RPM's and blade specifications for proper usage. Aggregate hardness is hard to determine and may take some experimentation.
- Always pull blade out of the cut with the WATER ON.
- Do not idle the blade down in the cut. This will wear down the sides of the blade segments. This will cause the blade to stick or "bind" in the cut.
- Do not try to cut curves. Position the saw at a new angle and cut straight lines.
- Do not ever load the saw with the blade attached. These blades are not designed to cut truck ramps, truck beds, trailers or angle iron.

TIPS ON "DRY CUTTING" WITH DIAMOND BLADES

- Be sure to mount blade tightly in the proper rotation direction. Abide by directional arrow when mounting blade.
 - Take very shallow cuts, 2" or less to allow the heat to dissipate out of the cut. Cut for approximately 25-35 seconds, then pull the blade out of the cut for 5-10 seconds. This intermittent cutting will allow the blade to cool down to its original shape and form. NOTE: As a diamond blade heats up, the steel core is at greater risk of losing tension. The above mentioned method of cutting will keep your blade in good running condition. Also, if a blade overheats, it is likely to "Glaze" over and
- quit cutting. Should this happen, take very shallow cuts in a highly abrasive material such as asphalt, lightweight block, sand stone, etc. The abrasive nature of these materials will break down the metals covering the diamond, resume cutting in your normal manner. You should notice a more aggressive cut. If not, contact your local distributor or the factory.
- Remember to keep the filter clean on your saw. This will allow the saw to operate at its optimum RPM.
 - Once again, do not cut the curves. Realign your saw and make only straight cuts.

IMPORTANT! THE "REAL ENEMY" WHEN CUTTING



Cutting down through concrete or asphalt into gravel, sand or dirt causes water loss that would normally follow the blade into the cut. The water stays down in the base material instead of "in the cut" where the water belongs. The base material is highly abrasive. This abrasiveness combined with the loss of water causes a VERY RAPID UNDERCUTTING of the steel center. If you notice the reduction of water coming out of the cut or a change of color (muddy, gray, or just different) pay closer attention to your depth of cut. You

may need to raise the blade up to help prolong the useful life of your investment. Diamond blades with slanted core protection will help to offset this rapid wear, but simply paying attention here pays off in longer blade life!

THE BASE MATERIAL IS THE REAL ENEMY! STAY OUT OF IT TO HELP PROTECT YOUR INVESTMENT!