

Slab Sawing with Optimum Efficiency and Safety



For successful sawing ensure the blade is matched to the saw, job at hand and the operating RPM matches the blade's requirements.

- Based on the depth of cut, select the correct blade diameter and install the blade following the manufacturer's recommendations.
- Always match the saw's rpm to the blade's diameter. Slower speeds will make the blade act softer so it will wear prematurely; running the blade too fast makes the blade act hard, which can result in glazing and inefficient cutting. It also could cause the blade to break or lose segments. A blade's maximum cutting efficiency is approximately 12,000 surface feet per minute.
- Always step cut. Make a 1-inch cut as your guide cut. You should cut 1 to 2 inches deep at a time no matter how deep the final cut will be. If you try to make 8-inch cuts in one pass you will ruin the blade quickly, it heats up the blade and causes it to warp. If your cut gets off course, it is better to get out of it and restart on the line.
- Water is key, pay attention to water flow. The nozzles should be positioned to spray water to cool the blade, control dust and help take slurry out of the cut. If water flow stops, stop cutting immediately or you will ruin the blade. If you have too much water, the saw could hydroplane.
- Listen to the engine, it can tell you if the blade is bouncing or wobbling. At the first indication of a

Recommended Blade RPM and Maximum Depth of Cut

| Blade Diameter (inches) | Operating RPM | Blade Collar (inches) | Maximum Depth of Cut (inches) |
|-------------------------|---------------|-----------------------|-------------------------------|
| 14 | 2,900 | 4-1/2 | 4-3/4 |
| 16 | 2,600 | 4-1/2 | 5-3/4 |
| 18 | 2,600 | 4-1/2 | 6-3/4 |
| 20 | 2,450 | 4-1/2 | 7-3/4 |
| 24 | 1,950 | 4-1/2 | 9-3/4 |
| 26 | 1,950 | 4-1/2 | 10-3/4 |
| 30 | 1,650 | 6 | 12 |
| 36 | 1,400 | 6 | 15 |
| 42 | 1,050 | 6 | 18 |
| 48 | 850 | 8 | 20 |
| 54 | 775 | 8 | 23 |

problem shut down the saw and find the cause. It's likely the blade is loose, damaged or installed incorrectly. Inspect the engine, check to see if the belts are loose or worn. If you neglect the belts and pulleys you'll start to see poor cutting performance.

Remember, concrete dust is a serious health hazard, make sure to follow OSHA standards for eye, nose and mouth protection.