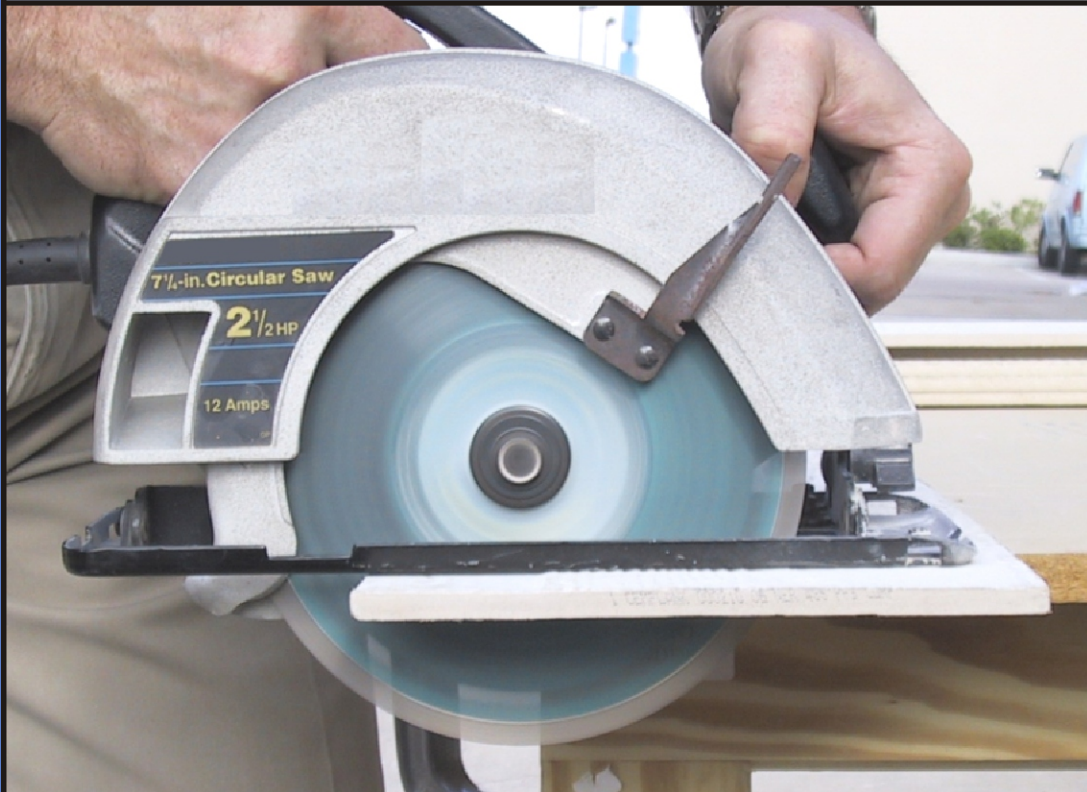




**POWER**  
DIAMOND TOOLS



*Choice of the skilled Professional!*



**100% Guaranteed !**





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Hand Saw



Right Angle Grinder



Tile Saw



Cut-Off Saw



Coring Machine



Masonry Saw



Walk Behind Saw



Concrete Saw

Dear Customers,

Please allow me to welcome you to our product line of some of the finest diamond cutting products available.

Power Diamond Tools prides itself on producing superior products for the best price possible. Our entire staff is dedicated to providing the best customer service in the industry.

If you have any questions or problems about any of our products please contact us. If any of our products fails to perform as advertised we will either replace it or return your money, that's a **100% Guarantee**

Good luck and enjoy cutting with diamonds.

Sincerely,

Tom Tamlyn  
President

### How Diamond Blades Work

Metal alloys and synthetic diamonds are combined to form the segments of a diamond blade. These metal alloys are commonly referred to as the blades "Matrix" or "Bond". The diamond blade cuts by grinding away the materials as the blade moves through the material. As the blade cuts the diamonds are dislodged or sheered off and the Matrix is worn away exposing fresh diamonds.

The speed at which the Matrix is worn away is dependent upon the hardness of the Matrix and the type of material being cut. If the Matrix is too soft for the material then the Matrix will be worn away very quickly not allowing the diamonds to cut. This will cause the blade to have a very short blade life. If the Matrix is too hard for the material then the Matrix will not be worn away fast enough. The diamonds exposed will be used and removed and new diamonds will not be exposed. This will cause the blade to cut very slowly or not at all. The blade may also chatter or bounce.

It is very important to match the right Matrix hardness to the right materials. For example if your cutting a very hard material like Granite then blade will need a soft Matrix. This means that the Matrix will wear away fast enough to expose new diamonds to cut the hard material. If your cutting something very abrasive like Block or Asphalt then you will need a hard Matrix. The Matrix will wear away much slower giving the diamonds time to cut and giving the blade a longer life.

### Blade Application

All Power Diamond Tool's blades are listed and described by their application. These terms are general please read the blades detail description before purchasing.

**General Purpose** - These blades are designed with a Matrix that is not too hard and not too soft, with just the right diamond with just the right Matrix hardness to allow the blade to cut almost anything. These type of blades are great for General Contractors and Do-it-Yourself users that need a low cost option that will cut almost anything. These blades are the best option for hardware stores and retail outlets that have a variety of customers with a wide range of materials. General purpose is a very broad term; there are materials and application that these blades will not perform well on. If there is any questions please ask your dealer or contact us for information on your specific material.

**Masonry** - These blades are designed specifically with the masonry contractor in mind. When we say Masonry we are referring to Cement Block and Cast Brick. Block is soft and abrasive and Brick is typically hard. These blades are made to run on walk behind saws, and high speed cut off saws. These blades are equipped with heavy duty cores, tall segments, and high quality diamonds to give these blades the best cutting performance and the longest blade life possible. Please purchase the Masonry Blade right for the materials your cutting in order to get the best performance possible.

**Concrete/Asphalt** - These blades are designed specifically for the cutting of Concrete or Asphalt with a wet cutting walk behind saw or chop saw, other types are available. Our concrete blades are rated with a bond hardness that refers to the type of material being cut. Please make sure you purchase the right blade for your material. Heavy cores, tall segments, and high quality diamonds make these blades the best choice for concrete cutting professionals.

**Stone** - These blades are designed for the cutting of stone like Granite or Marble. The terms Stone is very general our stone blades are made to cut hard stones like Granite. Not all Stones are hard, for example Sand Stone is very soft and abrasive. Our Stone Blades would not cut well in this type of material. A blade with a harder Matrix would be needed, a General Purpose or even a Block blade would be a good option. Please make sure you purchase the right blade for the materials your cutting if you ever have a questions please contact your dealer or us for information on your specific material.

Key Chart: **Wet** 

**Wet/Dry**  **Dry** 

### Recommend Cutting Depths

Blade Diameter	Cutting Depth	Blade Diameter	Cutting Depth
<b>Hand Saw Blades</b>			
4"	.....1"	7"	.....2-1/2"
4-1/2"	.....1-1/4"	8"	.....3"
5"	.....1-1/2"		
<b>Tile Saw Blades</b>			
6"	.....1-3/4"	9"	.....3-1/4"
7"	.....2-1/4"	10"	.....4-3/4"
8"	.....2-3/4"		
<b>Masonry Saw Blades</b>			
14"	.....5"	20"	.....5"
18"	.....7"		
<b>Wall Saw Blades</b>			
18"	.....6-1/2"	36"	.....14-1/2"
24"	.....9-1/2"	42"	.....17-3/4"
30"	.....11-1/2"	48"	.....20-3/4"
<b>High Speed Blades</b>			
12"	.....4"	14"	.....5"
<b>Concrete Saw Blades</b>			
12"	.....3-5/8"	26"	.....10-5/8"
14"	.....4-5/8"	30"	.....11-5/8"
16"	.....5-5/8"	36"	.....14-5/8"
18"	.....6-5/8"	42"	.....17-5/8"
20"	.....7-5/8"	48"	.....19-5/8"
24"	.....9-5/8"		

For hard, dense materials such as stone and tile, the optimum performance speed is 10-25% less than the speeds show.

Blade Shaft speeds (RPM's at no load) for most tools will be higher than the recommended operating speeds as shown. Under normal sawing conditions, the actual blade shaft speed of the tool will slow down under load, and should fall within the optimum speed range

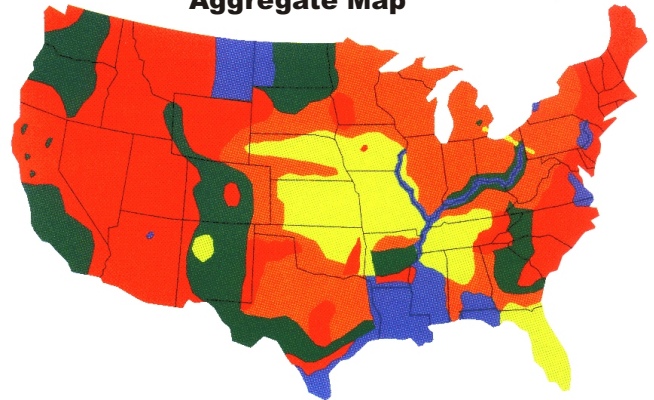
### Recommend Operating Speed

Diameter	Recommended Operating Speed (RPM)*	Maximum Safe Speed (RPM)**
4"	9072	15000
4-1/2"	8063	13300
5"	7257	12000
6"	6048	10185
7"	5184	8730
8"	4536	7640
9"	4032	6790
10"	3629	6115
12"	3024	5095
12" High Speed		6300
14"	2592	4365
14" High Speed		5500
16"	2268	3820
18"	2016	3395
20"	1814	3055
22"	1649	2780
24"	1512	2550
26"	1396	2350
28"	1296	2185
30"	1210	2040
32"	1134	1910
36"	1008	1700
42"	864	1455
48"	756	1275

\* Based on 11,000 SFPM (Surface Feet Per Minute) - The general optimum Performance range for cutting concrete and masonry products, ±10%.

\*\* This speed (RPM) represents the Maximum safe speed (in revolutions per minute (RPM) at which each blade can be used. Before using any blade, make sure the blade shaft (arbor) speed of the tool is within the maximum safe limit of that blade.


### Aggregate Map



Soft Medium Soft Medium Medium Hard Hard

**Aggregate** - Aggregate is hard rock usually found in river beds, this rock is an important component of concrete, since most of the concrete used in construction is made locally the Aggregate used in the concrete is usually from a local source. This allows us to use geology to map out the types of Aggregate across the country. The hardness of the Aggregate can drastically affect how a Diamond Blade will perform when cutting. Please take note of the Aggregate hardness in your region before choosing a concrete blade.

### Bond Hardness Chart

	SOFT  HARD					
Concrete Bond	C1	C2	C3	C4	C5	C6
Masonry Bond	Hard Brick	Brick	80%Brick 20%Block	50%Brick 50%Block		Block
Other Bonds	Granite	General Purpose Non Abrasive		General Purpose		General Purpose Abrasive

Please note this chart is a graphical display of bond hardness in a very general way to be used as a visual aid. The chart is not completely accurate for example a Granite Bond is not necessarily the same as a Hard Brick or a C1 Bond. There are other factors that effect a blades performance like diamond type, size, and quantity.



# Universal Diamond Blade

## General Purpose, Fiber-Cement



**Universal Diamond Blade** - Segmented Diamond Blade with Sintered Segments for dry or wet cutting. Low cost and great performance makes the Universal Diamond Blade a favorite among general contractors and do-it-yourself users. This blade will cut almost any material very well.

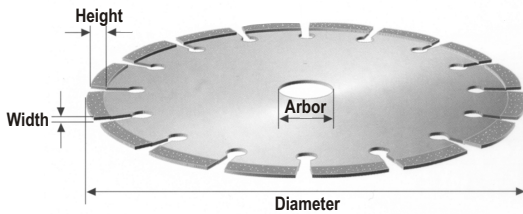
### When Carbide Won't Cut It!



### Universal Diamond Blades

Part #	Blade Diameter	Segment	
		Width	Height
00015	4.5"	.08"	.28"
00101	5"	.08"	.28"
00135	5.5"	.08"	.28"
00016	7"	.10"	.30"
00017	8"	.10"	.30"
00086	10"	.14"	.34"
00087	12"	.14"	.34"
00088	14"	.14"	.34"

DFB-Part#



**1st Choice for Fiber-Cement**



**Cuts Curves**



**Cuts Steel**



**Cuts Granite**



**Cuts Brick**

MATERIAL		Universal
Siding, Backer Board, & Decking	Fiber Cement	[X]
	Durock®	
	Webbed Poly Decking	
Masonry	Glazed Masonry Tile	[X]
	Pavers and Hard Brick	
	Roof Tile	
	Soft-Medium Brick	
	Block	
Concrete & Asphalt	Lathe & Plaster, Stucco	[X]
	Cured Concrete	
	Green Concrete	
Steel	Asphalt	[X]
	Tubing and Shapes	
	Wood with Nails	
Stone	Rebar and Remesh	[X]
	Granite	
	Marble	
	Sand Stone	[X]

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# Continuous Rim Blade

## General Purpose, Thin Hard Materials



**Continuous Rim Diamond Blade** - Continuous segment sintered to the entire circumference of the blade give this blade an incredible smooth cut. Great choice for ceramic tile, and thin hard materials where chipping needs to be avoided. For most application this blade is used wet but can be run dry.

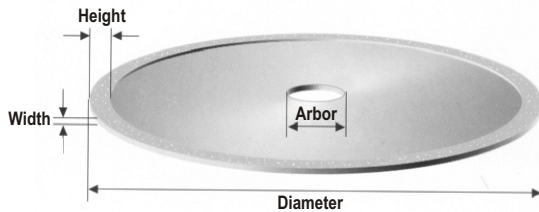
### 1st Choice for Ceramic Tiles!



### Continuous Rim Diamond Blades

Part #		Blade Diameter	Segment	
Standard Grade	Premium Grade		Width	Height
00079	00102	4"	.06"	.28"
00078	00060	4.5"	.06"	.28"
00097	00103	5"	.06"	.28"
00098	00104	6"	.07"	.28"
00080	00061	7"	.07"	.28"
00081	00062	8"	.07"	.28"
00082	00063	10"	.08"	.28"
00107	00105	12"	.09"	.28"
00108	00106	14"	.09"	.28"

DCB-Part#



MATERIAL		Continuous Rim
Ceramics and Glasses	Ceramic Tile	
	Glazed Masonry Tile	
	Glass	
	Porcelain	
Siding, Roofing, & Decking	Vinyl Siding	
	Pole Barn Siding	
	Standing Seam Roofs	
	Aluminum Gutters	
	Corrugated Steel	
	Hard/Abrasive Plastics	
Stone	Thin Marble and Granite	



Cuts Masonry



Cuts Granite



Cuts Tile



Cuts Steel

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# Turbo Blades

## General Purpose, Stone, Masonry



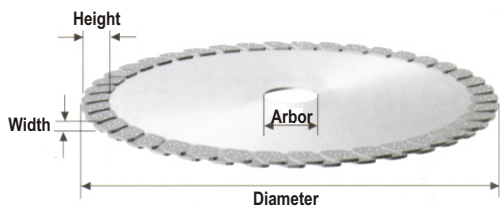
**Turbo Diamond Blade** - Turbo Diamond Blades have a blade design that is a blending of a Segmented Blade design and a Continuous Rim Blade design. This gives the Turbo blade the best of both worlds, fast cutting with a smooth, clean, edge. This blade is designed to cut fast with holes bored into the core to allow the blade to cool as it runs.



### Turbo Diamond Blades

Part # Granite	Part # GP-Abrasive	Part # GP-Non Abrasive	Blade Diameter	Segment	
				Width	Height
00064		00348	4"	.08"	.28"
00056		00349	4.5"	.08"	.28"
	Economy»	00134	7"	.09"	.28"
00065		00350	7"	.09"	.28"
00352		00351	8"	.09"	.28"
00084	00131	00008	10"	.10"	.28"
00057	00132	00009	12"	.12"	.31"
00083	00133	00010	14"	.14"	.31"

DTB-Part# GP-Non Abrasive  
 DTM-Part# GP-Abrasive  
 DTS-Part# Granite



- All styles can be run either wet or dry.
- Available in four styles: Granite, General Purpose Non-Abrasive, General Purpose Abrasive, and Economy.
- Granite is an excellent blade for many stones and very popular with stone fabricators and masons.
- Non-Abrasive is an excellent blade for pavers and other hard bricks. Note: Hard Brick style will wear quickly with block and concrete.
- The Abrasive blade is a great blade for use on 'Quickie' saws to cut block.
- The Economy Blade gives excellent performance at a great price. 7" Economy is preferred by some for fiber cement and Durock®

MATERIAL		Turbo Blades
Stone	Granite	Granite
	Marble	
	Sand Stone	
Masonry	Glazed Masonry Tile	GP-NA
	Hard Brick	
	Roof Tile	
	Soft-Medium Brick Block	
Concrete & Asphalt	Cured Concrete	GP-A
	Green Concrete	
	Asphalt	
Siding, Roofing, & Decking	Fiber Cement	GP-NA
	Vinyl	
	Steel	
	Aluminum	
	Hard/Abrasive Plastics	

GP-NA : General Purpose Non-Abrasive  
 GP-A : General Purpose Abrasive

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# Segmented Blade

## Masonry, Stone, Roof Tile



### Segmented Blades

- PDT Segmented Blades have the longest life and highest performance. They have more diamonds and a heavier core.
- These are premium blades designed for use by skilled craftsmen on dedicated jobs.
- These blades are optimized for specific materials and may perform poorly if used to cut other materials.
- They cost more initially but give **lower overall cost** through longer blade life and faster cutting speed.

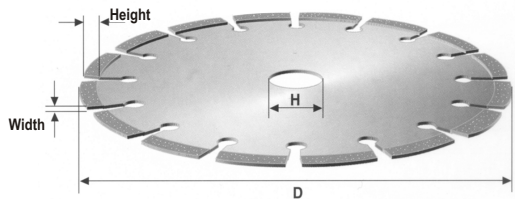


These blades come in several different styles optimized for the specific material being cut.

### STYLES

- 100% Block (BLK)
- 100% Brick (BRK)
- 50%-50% Brick-Block (5/5)
- 80%-20% Brick-Block (8/2)
- Roof Tile (RT)
- Hard Brick (H/B)
- Granite (GRT)

	Dry/Wet	Wet
• 100% Block (BLK)	X	X
• 100% Brick (BRK)	X	X
• 50%-50% Brick-Block (5/5)	X	X
• 80%-20% Brick-Block (8/2)	X	
• Roof Tile (RT)	X	
• Hard Brick (H/B)	X	
• Granite (GRT)	X	



### Premium Segmented Blades Dry

Part # 50% Brick 50% Block	Part # Block	Blade Diameter	Segment	
			Width	Height
00472	00471	14"	.11"	.47"
00475	00474	20"	.13"	.47"

### Performance Segmented Blades Dry

Part # 50% Brick 50% Block	Part # Block	Blade Diameter	Segment	
			Width	Height
00464		12"	.11"	.39"
00466	00465	14"	.11"	.39"
00469	00468	20"	.13"	.39"

### Standard Segmented Blades Wet Only

Part # Brick	Part # 50% Brick 50% Block	Part # Block	Blade Diameter	Segment	
				Width	Height
00027	00029	00024	14"	.138"	.42"
00028	00030	00025	20"	.18	.42"

### Standard Segmented Diamond Blades Dry

Part # Roof Tile	Part # Granite	Part # Hard Brick	Part # Brick	Part # 50% Brick 50% Block	Part # 80% Brick 20% Block	Part # Block	Blade Diameter	Segment	
								Width	Height
00054	0052			00031			7"	.0866"	.2755"
00055	00125		00036	00040		00032	12"	.135"	.378"
00056	00073	00071	00037	00042	00044	00034	14"	.138"	.42"
	00074	00072	00038	00067		00035	20"	.18	.42"

### DMB-Part #

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# Brick/Paver

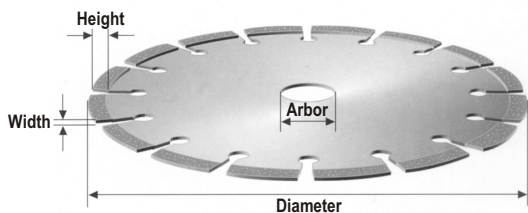
## Masonry, Brick, Pavers



**Brick/Paver** - General Purpose Masonry specifically designed for the Brick and Paver industry. A perfect choice for the contractor cutting a variety of Masonry Products, Brick, Pavers, Block, and most other materials. These blades can be run wet or dry.



MATERIAL		Turbo Blades
Stone	Granite	
	Marble	
	Sand Stone	
Masonry	Glazed Masonry Tile	
	Hard Brick	
	Roof Tile	
	Soft-Medium Brick Block	
Concrete & Asphalt	Cured Concrete	
	Green Concrete	
	Asphalt	
Siding, Roofing, & Decking	Fiber Cement	
	Vinyl	
	Steel	
	Aluminum	
	Hard/Abrasive Plastics	



### Brick/Paver Diamond Blade

Part #	Blade Diameter	Segment	
		Width	Height
00501	7"	.10"	.30"
00502	10"	.14"	.34"
00503	12"	.14"	.34"
00504	14"	.14"	.34"

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# Deep Tooth Blade

## General Purpose, Masonry, Concrete



**Deep Tooth** - Aggressive segment design and curved channels give this blade a faster cutting speed than blades with standard teeth.

- Much longer life in concrete, block, asphalt and other aggressive materials.
- Combination of a narrow slot and turbo design gives a smooth edge.
- The "T" segment eliminates segment loss due to undercutting of the steel core.



MATERIAL		Deep Tooth
Siding, Backer Board, & Decking	Fiber Cement	[Black]
	Durock®	
	Webbed Poly Decking	
Masonry	Glazed Masonry Tile	[Black]
	Pavers and Hard Brick	
	Roof Tile	
	Soft-Medium Brick	
	Block	
	Lathe & Plaster, Stucco	
Concrete & Asphalt	Cured Concrete	[Black]
	Green Concrete	
	Asphalt	
Steel	Tubing and Shapes	[Black]
	Wood with Nails	
	Rebar and Remesh	
Stone	Granite	[Black]
	Marble	
	Sand Stone	

**Outlasts Carbide 600:1**  
**100% Guaranteed**  
**Cuts Wet or Dry**

### Deep Tooth Diamond Blades

Part #	Blade Diameter	Segment	
		Width	Height
* 00501	7"	.08"	.28"
00495	7"	.08"	.28"
00497	10"	.08"	.28"
00498	12"	.08"	.28"
00499	14"	.10"	.30"

\*Diamond Mandrel  
**DDB-Part#**

- ◆ "T" Shaped Segment
- ◆ Faster Cutting
- ◆ 100% Longer Life

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# Segmented Diamond Blades

## Concrete, Asphalt



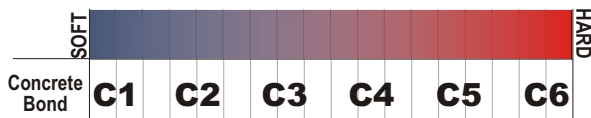
### Concrete & Asphalt Blades

- PDT concrete and asphalt blades have the longest life and highest performance with more diamonds and a heavier core.
- Concrete blades perform best when run wet but you may run dry for short durations. The weld of every segment on every blade is tested for strength.
- 12" & 14" blades have fully tensioned cores and can be run on most high-speed saws.



Bond Hardness	Application	Aggregate	Sand	Steel Reinforcing
C1	Cured Concrete	Critically Hard	Non-Abrasive	Heavy
C2	Fast Cutting of Cured Concrete	Critically Hard	Light Abrasive	Light to Medium
C3	General Purpose Cutting Cured Concrete	Medium to Hard	Medium Abrasive	Light to Medium
C4	Cured Concrete & Joint Widening	Soft to Medium	Medium Abrasive	Light
C5	Green Concrete & Asphalt Over Concrete	Soft to Medium	Abrasive	Very Light to None
C6	Extra Long-life in Asphalt Asphalt Over Concrete Green Concrete	Soft	Most Abrasive	Very Light to None

### Bond Hardness Chart



### Standard Concrete

C4	C6	Blade Diameter	Segment	
			Width	Height
00325	00326	12"	.135	.335
00004	00330	14"	.135	.335

### DSC-Part#

### Premium Concrete Diamond Blades

PART #						Blade Diameter	Segment	
C1	C2	C3	C4	C5	C6		Width	Height
00301	00302		00304		00306	12"	.11"	.32"
00307	00308	00310	00085	00311	00312	14"	.17"	.38"
00319	00320	00321	00322	00323	00324	20"	.17"	.38"

### DSC-Part#

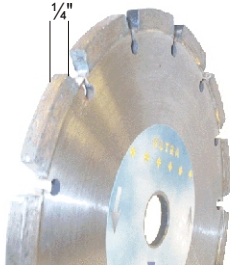
### Green Concrete

TYPE	PART #	Blade Diameter	Segment	
			Width	Height
Turbo Style	00047	7"	.10	.35
Segmented	00331	7"	.10	.45

### DSC-Part#

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**TUCK POINT BLADE**  
This blade has a very heavy core with .25" or .16" segments. Specifically designed to remove grout between brick and block or slot concrete.



Tuck Point Diamond Blade

PART #	Blade Diameter	Segment	
		Width	Height
00047	4"	.258	.343
00298	5"	.258	.343
00068	7"	.258	.343
00400	4"	.16	.343
00401	4 1/2"	.16	.343
00402	5"	.16	.343
00403	6"	.16	.343
00404	7"	.16	.343

Premium  
Standard

**DTP-Part #**



**JOINT WIDENER**  
Widen control joints in green concrete or old sealed joints in cured concrete.



Joint Widener Diamond Blade

PART #	Blade Diameter	Segment	
		Width	Height
00347	8"	.50	.275
00346	8"	.375	.275

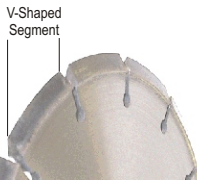
**DJW-Part #**



PART #

00183

**Backing Flange**  
For use with 4-1/2" Grinder when using 4" and 4-1/2" dry cut diamond blades.



**V - GROOVE  
CRACK CHASER**  
Cleans, routs and repairs cracks in concrete and other materials. Designed for use on a small angle grinder.



Crack Chaser Diamond Blade

PART #	Blade Diameter	Segment	
		Width	Height
00343	4"	.24	.24
00344	7"	.24	.32

**DCC-Part #**



# Grinding Cups, Coring Tools & Hole Saws




## Grinding Cup Wheels

- Turbo Row is used for fast, smooth polishing and finishing of stone, tile, porcelain, refractory and light-duty masonry and concrete. Turbo Row is available in fast and smooth cutting grades.
- Continuous Rim is used for the wet polishing of marble, granite and stone.
- Single Row is used for fast removal on concrete, masonry, stone, and similar materials.
- Double Row is used for long life and smooth finish on concrete, masonry, stone and similar materials. Both Single and Double Row are available in Fast and Smooth cutting grades.



### Turbo Row



### Turbo Row Grinding Cup

Turbo Coarse Cut	Turbo Fine Cut	Cup Diameter	Segment Height
00144	00099	4"	.196"
00100		6"	.196"
00148		7"	.196"

### DGC-Part #

### APPLICATION

- Ceramic Tile, Porcelain
- Refractory
- Stone, Marble, Granite
- Masonry, Concrete

### Double Row



### Double Row Grinding Cup

Double Row Coarse Cut	Cup Diameter	Segment Width
00169	4"	.196"
00170	4.5"	.196"
00172	6"	.196"
00173	7"	.196"

### DGC-Part #



### Masonry & Concrete Dry Coring Tools

Masonry & Concrete coring tool is used for block and soft brick as well as light duty concrete and softer stones.

•All diameters are 10" in length with 5/8"-11 thread.

Part #	SPECIFICATIONS		
	Diameter		Min/Max RPM
	Inches	mm	
00176	1"	25.4	1000/1500
00177	1 1/8"	29	1000/1500
00178	1 1/4"	32	1000/1500
00179	1 1/2"	38	1000/1500
00180	1 3/4"	44	1000/1500
00181	2"	51	1000/1500
00184	3"	76	500/1000
00186	3 1/2"	89	500/1000
00187	4"	102	500/1000
00189	4 1/2"	114	500/1000
00190	5"	127	500/1000
00193	6"	152	250/500

### DCT-Part #



### Diamond Hole Saws - Dry

First Choice for fiber-cement siding. Cuts concrete, steel, roof tile, masonry, stone, wood with nails, plastic decking, and more!



Hole Saw	SPECIFICATIONS		
	Diameter		Min/Max. RPM
	Inches	mm	
00355	1"	21	600/1500
00358	1.5"	31	600/1500
00360	2"	51	600/1500
00362	2 1/2"	63	600/1500
00363	3"	76	600/1500
00365	3 1/2"	89	600/1500
00366	4"	102	600/1500
00368	4 1/2"	114	600/1500
00369	5"	127	600/1500
00372	6"	152	500/800

### DHS-Part #

# Blade Comparisons Chart



MATERIAL		Universal	Turbo Blades	Segmented Blades	Continuous Rim	
Stone	Granite		3			
	Marble					
	Sand Stone					
Masonry	Glazed Masonry Tile		2			
	Hard Brick					Hard Brick
	Roof Tile					Roof Tile
	Soft-Medium Brick Block					Brick Block
Concrete & Asphalt	Cured Concrete		1			
	Green Concrete					Concrete
	Asphalt					Asphalt
Siding, Roofing, & Decking	Fiber Cement		2			
	Vinyl					
	Steel					General Purpose
	Aluminum					
	Hard/Abrasive Plastics					
Glassy Materials	Ceramic Tile					
	Glass					
	Porcelain					
	Quarry Tile					

## Diamond Blade Item Detail

U

Universal Blade

The 1st choice for cutting all fiber-cement siding. It cuts most other materials very well. The low cost, excellent performance, and wide applicability makes it a very attractive choice. Cuts wet or dry.

TB

Sintered Turbo Rim Blade

- 1 -For block, masonry and concrete.
- 2 -For brick, hard brick, stones.  
*\*Not for block and similar abrasive materials.*
- 3 -For granite and the hardest stones.  
These blades cut wet or dry.

LAB

Laser Welded Segmented Blade

These blades have the longest life and highest performance with more diamond and heavier core. These blades come wet/dry and wet-only. They come in several different styles optimized for the specific material being cut.

CR

Continuous Rim Blade

Preferred by the leading contractors. This blade cuts Tile and Thin Stones plus Vinyl & Metal Siding, Gutters, and Sheet Metal. Cuts with clean, square edges and little or no burr. Cuts wet (or dry if kept cool)

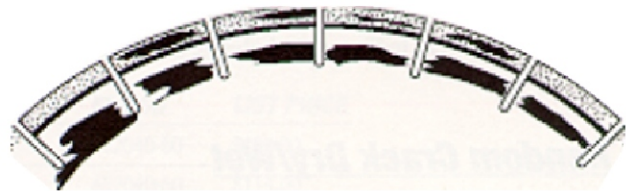
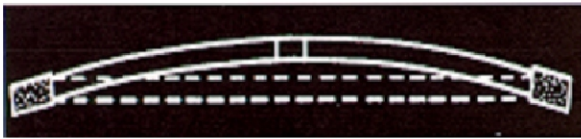


Virtually all diamond blade problems result from any of the following:

1. Using the wrong blade for the job (wrong hardness?)
2. Using the blade improperly (cutting with inadequate cooling, feeding to hard, etc.)
3. Equipment problems (damaged spindles, arbors, etc.)

Listed below are five common problems, their causes, and how to avoid such problems in the future. Power Diamond Tools can evaluate your problem blade.

## Loss of Tension



### Appearance:

Blade wobbles excessively in the cut.

Blue/black steaks on the segments and core.

Core is dish shaped.

### Cause:

Steel Core has overheated due to lack of cooling - critical specifically in dry cutting applications.

Rubbing on the side of the material being cut (flat saws).

Improper bond specification (too hard).

Operated at improper RPM.

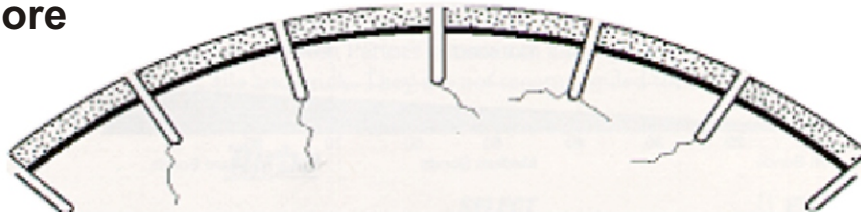
### Solution:

When dry cutting. Never cut for more than 30 to 45 seconds. After each cut allow for a cool down period of 20-30 seconds.

When wet cutting apply more water and check your water flow.

Is the correct bond used?

## Cracks in Core



### Appearance:

Hairline cracks starting in the gullets between the segments. Cracks can run in both vertical and horizontal directions.

Blue/Black streaks on the segments and core.

### Cause:

The fatigue cracks are a result of the blade (segments) moving sideways as it is cutting.

Blade has lost tension (see above) and has been operated for some time while wobbling.

The blade is working "too hard" (too hard of a bond) causing loss of tension and fluttering in the blade.

Equipment problems such as spindle bearings, arbor and alignment.

### Solution:

Operate dry cutting blades intermittently or use water.

Use a softer bond.

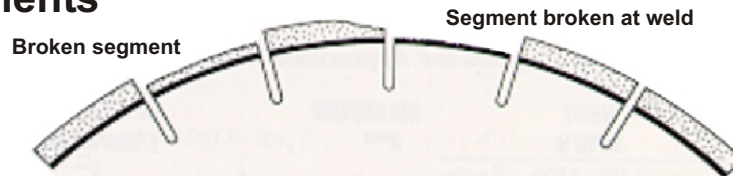
Use more water when wet cutting.

Do not feed the blade as hard.

If enough segment remains on a soldered wet cutting blade, the segments can be installed on a new core.



## Broken Segments



### Appearance:

1. One or more segments are broken off. Part of the segment is still left on the Blade.
2. One or more segments are broken off at the laser weld or solder joint.

### Cause:

The blade has been jammed or twisted in the cut.

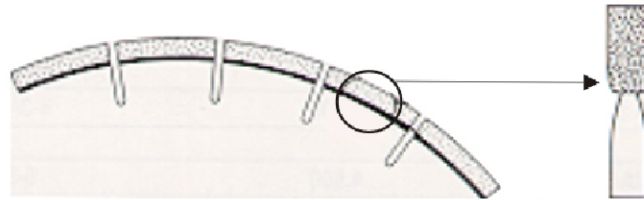
Dry cutting blades; the laser weld was weak. Wet cutting blades; inadequate cooling of the blade or a poor solder joint.

### Solution:

PDT will repair the blade at a nominal charge.

PDT will repair lost segments at **No Charge** if it is found to be from improper manufacturing.

## Under Cut



### Appearance:

The steel core is worn out immediately under the segments.

Some segments might be lost.

### Cause:

Material being cut is very abrasive, such as asphalt or green concrete.

Inadequate Amount of water has been applied.

Cutting into the fill (sub-base) such as sand.

### Solution:

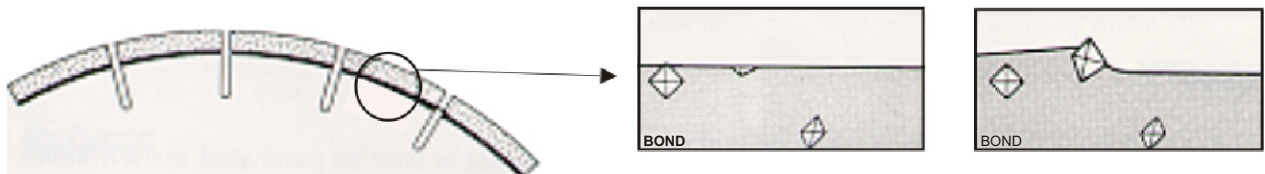
Use as much water as possible.

Do not cut into the sub-base.

Use a blade with Undercut Retardant Core -"URC's"

**Note:** Undercut retardant cores will not always prevent core wear. The best defense is to always ensure ample water supply to flush out the fine grit generated during the cutting

## Won't Cut "Glazed"



### Appearance:

The diamond on the segment are not protruding over the bonding material.

The segment might appear polished.

### Cause:

1. Blade is too hard for the materials- wrong bond.

2. Blade has been operate on inappropriate equipment or at wrong rpm.

3. Segments have been coated with steel from cutting into a reinforcement bar.

### Solution:

1. Make sure you do not use a bond intended for asphalt or green concrete in cured or extremely hard aggregates.

2. Make sure that the blade was intended for the equipment used. Also, refer to the RPM chart for "Best Operating Speeds."

3. Avoid cutting into a re-bar lengthwise. The steel in the bar can melt and coat the segment. All cutting through re-bar will slow down the cutting. Cross cutting or a re-bar embedded in concrete generally does not present a problem.

**Note:** "Glazed" blades can be opened up by cutting into abrasive materials such as cinder block, asphalt or a dressing stone.



*The choice of professionals!*



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