

# Using Soft-Cut Early-Entry Blades

Soft cut blades are specially designed for early-entry concrete sawing. Specifically designed for trap-rock, chert, quartz, and limestone aggregate concrete.

The purpose of using a soft cut blade is to reduce the risk of random cracking in concrete when creating an expansion joint. The high production rate and the ability to cut the same day make soft cutting the best option for cutting green (early entry) concrete.

## Before making any cuts, you must break in your soft cut blade.

To ensure a long-lasting blade, you need to know how to properly prepare them. The reason for this is to expose the diamonds that are in the blade's segment. These are the diamonds that grind down the material you are cutting.

## Steps to Break in Your Soft cut early entry blade:

- 1) Put your soft cut blade on the saw.
- 2) In the material you are cutting, run your soft cut saw at 50% RPM for between 4.5 to 9 metres. This technique allows the blade to 'warm-up' and exposes the diamonds in the segments.
- 3) Raise the RPM's back up to 100% and continue cutting like normal.



See next page for best practices check list...

# Best practices for achieving quality soft cut joints

## Timing of cut!

Make sure you cut in the 'green zone' which is approximately 1 to 2 hours after finishing and before the final setting time. Use hand, foot and roll test.

## Make sure blade break in time is honoured

Operate saw at half of normal forward speed which will allow the blade to open up, remain cool, cut faster and ensure full blade life is achieved.

## Ensure alignment

Make sure that the blade is aligned with the skid slot and not cutting into the skid causing damage.

## Find optimum forward travel speed

If the saw is pulling left, speed up. If the saw is pulling right, slow down. Find the correct balance. Make sure the blade is cutting as freely as possible, not putting too much pressure on either side of the joint.

## Don't walk on saw joints while cutting

Watch your step while operating the floor saw.

## Transport and storage

When transporting and storing the floor saw always ensure that the blade has been removed with the skid plate attached.

## Change skid plate with every new blade

If starting out the job with a used blade and skid, inspect the bottom surface of the skid to make sure there is no damage. Also, inspect any used blade to ensure none of the diamond segments have overheated.

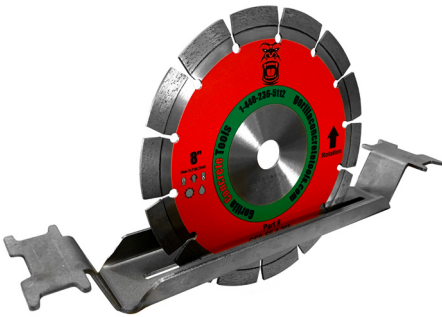
## Check blade block plungers

Check to ensure the block plungers are moving up and down freely allowing proper pressure of skid on the concrete surface. Clean the blade block daily.

## Use joint protectors at saw joint intersections

Don't sweep back and forth across the saw joints, keep the saw going in the same direction.

## Renewing the skid plate

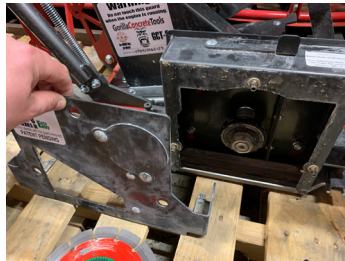


Checking the condition of the skid plate is critical. Ensure that this skid plate is checked regularly and is kept pristine. We suggest changing the skid plate with each new blade.

**Visit:** [www.speedcrete.co.uk](http://www.speedcrete.co.uk)  
to order these consumables.  
**Product code:** GS100-45



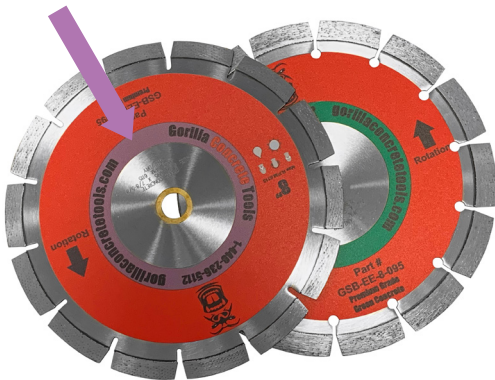
This premium early entry saw features a quick-change skid plate which is self-levelling. This quick change skid plate is intergrated into the the blade housing and can be easily swapped/cleaned in seconds.



## Identifying the correct blade for your floor type

This early entry saw can be used with various 7" and 8" blades. Each blade can be matched up to the required specifications of the floor you are working on. Each blade can be identified by looking at the colour chart below.

**Example:** The Purple band (see arrow below) shows that this blade is 1000-Purple and is for used aggregate.



### Specifications

Identification Colour	Aggregate
1000-Purple	Very Hard
2000-Green	Hard
3000-Red	Medium Hard
4000-Orange	Medium
5000-Yellow	Medium Soft
6000-Black	Soft