

Diamond Product Tips

Blade Tips

- Make certain the blade is suitable for the material before cutting
- Guide the blade straight into the material. Do not tilt or subject it to lateral stress or pressure
- Do not use unnecessary pressure; the weight of the machine is sufficient
- Carry out a slight pendulum movement (forwards, backwards)

Dry Core Tips

- Ideally, use a dedicated dry diamond core machine with variable speed control and a slipping clutch
- Use on rotary only: no hammer action
- Pilot drill the wall first with a 13mm masonry drill and use a guide rod to follow the pilot hole
- For harder materials and larger diameter cores use a slower RPM: for softer materials and smaller diameter cores use a faster RPM
- Clear debris from the hole at regular intervals to prevent the core from binding in the hole
- Do not force the core; let it do the work

Wet Core Tips

- Use suitable wet drilling diamond drill motors & rig stands
- Ensure the rig stand is level and secure with zero movement
- Use sufficient supply of water to keep the segments cool
- When the core hits re-bar; relax the pressure and allow the core to drill at its own rate

Re-sharpening Tip

- If the cutting speed of a diamond product reduces you can re-sharpen it by making several passes into a highly abrasive material; such as a 3-Newton concrete block or soft sandstone

Variables that affect performance

Variables	Condition	Cutting speed	Tool life
Bond hardness	Harder	Slower	Longer
	Softer	Faster	Shorter
Diamond Quality	Lower	Slower	Shorter
	Higher	Faster	Longer
Diamond Grit Size	Coarser	Faster	Longer
	Finer	Slower	Shorter
Diamond Concentration	Lower	Faster	Shorter
	Higher	Slower	Longer
Horsepower	Lower	Slower	Longer
	Higher	Faster	Shorter
Blade RPM	Lower	Faster	Shorter
	Higher	Slower	Longer
Water Flow	Lower	Faster	Shorter
	Higher	Slower	Longer
Cutting Depth	Shallow	Faster	Longer
	Deep	Slower	Shorter
Material Hardness	Harder	Slower	Longer
	Softer	Faster	Shorter
Aggregate Size	Larger	Slower	Shorter
	Smaller	Faster	Longer
Steel Reinforcement	Less	Faster	Longer
	More	Slower	Shorter