



Diamond Saw Blade Operating Recommendations

Diameter D in mm	Flange diameter in mm	Drive Power in kW	Amount of coolant l/min	Lateral truth		Vertical truth		Parallelity table slide ways to saw in mm
				Flange in mm	Saw in mm	Arbour in mm	Saw in mm	
200	70	3.0 -7.5	6-10	0.02	0.12	0.02	0.15	0.02
250	80							
300	100							
350	120	5.0-7.5	10-15	0.04	0.15	0.02	0.15	0.03
400	140							
450	140							
500	170	11-15	15-20	0.06	0.2	0.3	0.2	0.5
550	170							
600	180							
650	180	15-20	20-30	0.08	0.25	0.3	0.2	0.06
700	200							
750	200							
800	120	25-35	30-40	0.1	0.3	0.04	0.25	0.07
900	250							
1000	250							
1100	250	30-40	40-50	0.12	0.5	0.04	0.25	0.09
1200	300							
1350	300							
1500	350	35-45	60-70	0.14	0.8	0.04	0.25	0.10
1600	350							
1700	400							
1800	400	40-50	70-80	0.16	1.1	0.04	0.25	0.15
2000	400							
2200	400							
2500	400	45-60	80-100	0.2	1.3	0.04	0.25	0.20
2700	400							
3000	500							
3500	500	55-75	100-120	0.2	1.3	0.04	0.25	0.25

Recommended Blade RPM for wet sawing of the following materials

Material	RPM
Asphalt	40-45m/s
Concrete	30-40m/s
Reinforced Concrete	25-35m/s
Refractory Brick	25-35m/s
Masonry	30-40m/s
Granite	25-30m/s
Marble	35-45m/s
Sandstone	35-45m/s

Saw blade diameter in mm	Rpm at a peripheral speed of						
	25 m/s	30 m/s	35 m/s	40 m/s	45 m/s	50 m/s	60 m/s
200	2390	2860	3340	3820	4300	4770	5730
250	1910	2290	2670	3060	3440	3820	4580
300	1590	1910	2230	2550	2860	3180	3820
350	1390	1640	1910	2180	2460	2730	3270
400	1190	1430	1670	1910	2150	2390	2860
450	1060	1270	1480	1700	1910	2120	2550
500	950	1150	1340	1530	1720	1910	2290
550	870	1040	1220	1390	1560	1740	2060
600	800	950	1110	1270	1430	1590	1910
650	730	880	1030	1180	1320	1470	1760
700	680	820	950	1090	1230	1360	1640
750	640	760	890	1020	1150	1270	1530
800	600	720	840	950	1070	1190	1430
900	530	640	740	850	950	1060	1270
1000	480	570	670	760	860	950	1150
1200	400	480	560	640	720	800	950
1350	350	420	500	570	640	710	850
1500	320	380	460	510	570	640	760
1600	300	360	420	480	540	600	720
1800	270	320	370	420	480	530	640