



# **Model X-390 Operating Guide**

**IMPORTANT:  
Read ALL Directions Before Using**

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Manufacturer      Husqvarna CP Soff-Cut  
265 Radio Road  
Corona, CA 92879

Model              USA  
X-390

Serial number      \_\_\_\_\_

Year manufactured      \_\_\_\_\_

# **WARNING: Failure to comply with the following warnings could result in serious bodily injury or death!**

## **SAFETY WARNINGS**

### **PERSONAL SAFETY**

- Read and understand instructions before operating saw.
- Always wear safety approved hearing, eye, head and respiratory protection.
- Wear boots with non-slip soles to provide proper footing. Steel-toed safety boots are recommended.
- Wear rubber work gloves to avoid contact with wet concrete which can cause serious skin irritation.
- Know how to stop the saw quickly in case of emergency.
- Keep all parts of your body away from blade and other moving parts. Do not wear loose clothing or jewelry which can be caught in moving parts. Wear protective hair covering to contain long hair.
- Use caution when loading and unloading saw.
- Stay alert. Maintain awareness of saw operation. Use common sense. Do not operate saw when tired or after consumption of any substance that would impair physical function or rational judgment.
- Do not over reach. Keep proper footing and balance.
- Guard against electric shock. Prevent body contact with grounded surfaces such pipes, conduit, radiators, etc.

### **WORK AREA SAFETY**

- Never operate the saw in any application or job where you are not trained or supervised.
- Keep visitors, children and animals out of the work area.
- Do not operate the saw in areas of combustible material or fumes. Sparks may occur from the saw that could cause a fire or explosion.
- The motor and saw can become hot during operation. Keep all body parts and foreign material away from the saw while running.
- Avoid dangerous environments. Do not use the saw in damp or wet locations. Do not expose saw to rain. Keep work area well lit and clean.
- Use only extension cords suitable for outdoor use and marked with a suffix W-A or W.
- Before connecting the saw to a power source (receptacle, outlet, etc.) insure the voltage supplied is the same as that specified on the saw nameplate. A power source with voltage greater than specified on the saw can result in serious injury as well as damage to the saw. If in doubt, do not use the saw. Using a power source with voltage less than the saw nameplate is harmful to the motor.
- The saw must be plugged into an outlet properly installed and grounded in accordance with all codes. Never modify the plug in any way. Do not use adaptor plugs. Check with a qualified electrician if you are in doubt.

### **SAW SAFETY**

- Do not leave saw unattended while the motor is running.
- Do not alter the saw. Any alteration or modification is misuse and may result in a dangerous condition.
- All safety guards must be in place before starting saw.
- Only operate the saw from behind the machine with both hands on the handle.
- Do not use damaged equipment, blades, guards or personal protection equipment. Do not disable safety equipment or kill switches.
- Use only Soff-Cut International, Inc. replacement parts. Use of unauthorized parts may create a danger.
- Remove all wrenches from the saw before starting.
- Never stand on the saw.
- When the saw is not in use or transporting, remove the blade and properly secure the saw to prevent accidental movement.
- Disconnect the electric cord to the saw and put the safety switch in off (red) position when not in use, before servicing, and when changing or installing blades.
- Do not abuse the electric cord. Never carry the saw by the cord or yank it to disconnect from the receptacle. Keep cord from heat, oil, or sharp edges. Inspect cord periodically and do not use saw if damaged.

### **BLADE SAFETY**

- Examine cutting blades before each use. Do not use any blade that has cracks, nicks, or flaws. Tri-arbor hole should be undamaged. Use only dry cut, steel centered, tri-arbor diamond blades made for cutting green concrete.
- Soff-Cut International, Inc. diamond blades are designed to only cut green concrete. Cutting any other material may result in blade failure or a dangerous condition.
- Inspect blade flanges for damage, excessive wear and cleanliness before mounting the blade. The blade should fit snugly on clean, undamaged, tri-arbor shaft.
- Use only Soff-Cut blades or blades marked with a maximum operating speed greater than 7000 rpm.
- Never operate the saw without the blade guard assembly securely in place including blade cover, front diverter and skid plate installed in working order. A damaged blade guard assembly must be replaced to protect the operator.
- Make sure the blade does not make contact with the ground or any other surface when maneuvering the saw.
- Avoid contacting the blade while it is rotating.
- Do not force, jam or twist the blade while cutting.

## GROUNDING INSTRUCTIONS

Grounding of the **X-390** electric saw is necessary while in use to protect the operator from electric shock or electrocution. The saw is equipped with an approved three-conductor cord and a three-prong grounding type plug to fit the proper grounding type receptacle. Do not remove the grounding prong from the three-prong plug. The green or green and yellow conductor in the cord is the grounding wire. The green wire in the cord must be the only wire connected to the saw's grounding system and must never be attached to an electrically "live" terminal. The saw must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all codes and ordinances. **WARNING: Do not remove or modify the plug installed on the saw. Check with a qualified electrician if you are in doubt if the outlet is properly grounded. Do not use the saw if the cord or plug is damaged.**

## EXTENSION CORDS

The **X-390** electric saw requires three wire extension cords only. The cord should have the required three wire receptacle to accept the saw plug and have a three-prong grounding type plug. As the distance from the supply outlet increases, a heavier gauge extension cord must be used. Using extension cords with too small a gauge of wire causes a serious drop in voltage resulting in loss of power and possible saw damage. Refer to the table shown to determine the required wire gauge. The smaller the gauge number of the wire, the greater the capacity of the cord. For example, a 14 gauge cord can carry a higher amp load than a 16 gauge cord.

### RECOMMENDED MINIMUM WIRE GAUGE FOR EXTENSION CORDS

<u>Volts</u>	<u>Amps</u>	<u>Cord length in feet</u>			
120 V	15 A	25'	50'	100'	150'
Minimum Wire Gauge		16 AWG	12 AWG	10 AWG	8 AWG

## GENERATORS

The minimum generator required to power the X-390 electric saw is 2800 watts continuous with a 120 volt 20 amp outlet producing 60 hertz single phase power. Generators vary widely so contact your generator distributor or manufacturer for their recommendation.

## MACHINE DESCRIPTION

The Soff-Cut International, Inc. **Model X-390** electric saw is designed as a residential and light commercial Ultra Early Entry concrete saw and is one of the smallest and lightest saws in the SoffCut line. The patented Soff-Cut Ultra Early Entry dry cutting system controls random cracking of concrete through the early timing of the saw cutting usually within one to two hours after the finishing process is completed. The patented saw and skid plate technology in conjunction with Soff-Cut blades allows for Ultra Early Entry sawing the same day while minimizing chipping and spalling. The saw is a manual push style with manual controls for all functions.

**Model number and part number** – X-390

**Materials cut** – Green concrete only.

**Blade type** – 5.0” (127mm) and 5.5” (140mm) dry cut diamond blade with tri-arbor

**Blade rotation** – Counter clockwise, upcutting

**Blade shaft speed** – 6850 rpm

**Cutting depth** – 7/8 to 1 1/8” (22 to 28.5mm) using a 5.5” (140mm) depending on amount of blade wear

**Cutting distance from wall** – 2” (51mm)

**Weight** – 30 lbs. (14 kg)

**Dimensions** – Handle not installed 30”L x 15”W x 11”H (762mmL x 381mmW x 279H)

**Blade raise/lower system** – Manual by rotating handle

**Guide system** – Manual front guide with spring return

**Handle** – Fiberglass with locking pins

**Average cutting rate** - Estimate only. Speed will vary with job conditions and concrete mixes.

Soft aggregates                    10 ft/min (3.0 m/min)

Medium aggregates                6 ft/min (1.8 m/min)

Hard aggregates                    3 ft/min (.9 m/min)

### Blade applications

Red Excel Series 3000                XL55-3000                Hard aggregate, medium abrasive sand

Yellow Excel Series 5000            XL55-5000                Medium hard to soft aggregate, abrasive sand

Blue Excel Series 7000                XL55-7000                Soft aggregate, highly abrasive sand

Blades are available in 5.5” (140mm) and 5” (127mm) diameters and in .095” (2.4 mm) and .225” (5.7 mm) widths. ProEdge bevel blades for decorative and hand tooled looks are also available.

### Motor specifications

Type                                    Air cooled, universal electric motor with gear reduction

Power                                    2.4 hp (1800 W)

Voltage                                   120 volts

Amperage                                15 amps

Cycles                                    60 hertz single phase

## BLADE AND SKID PLATE INSTALLATION

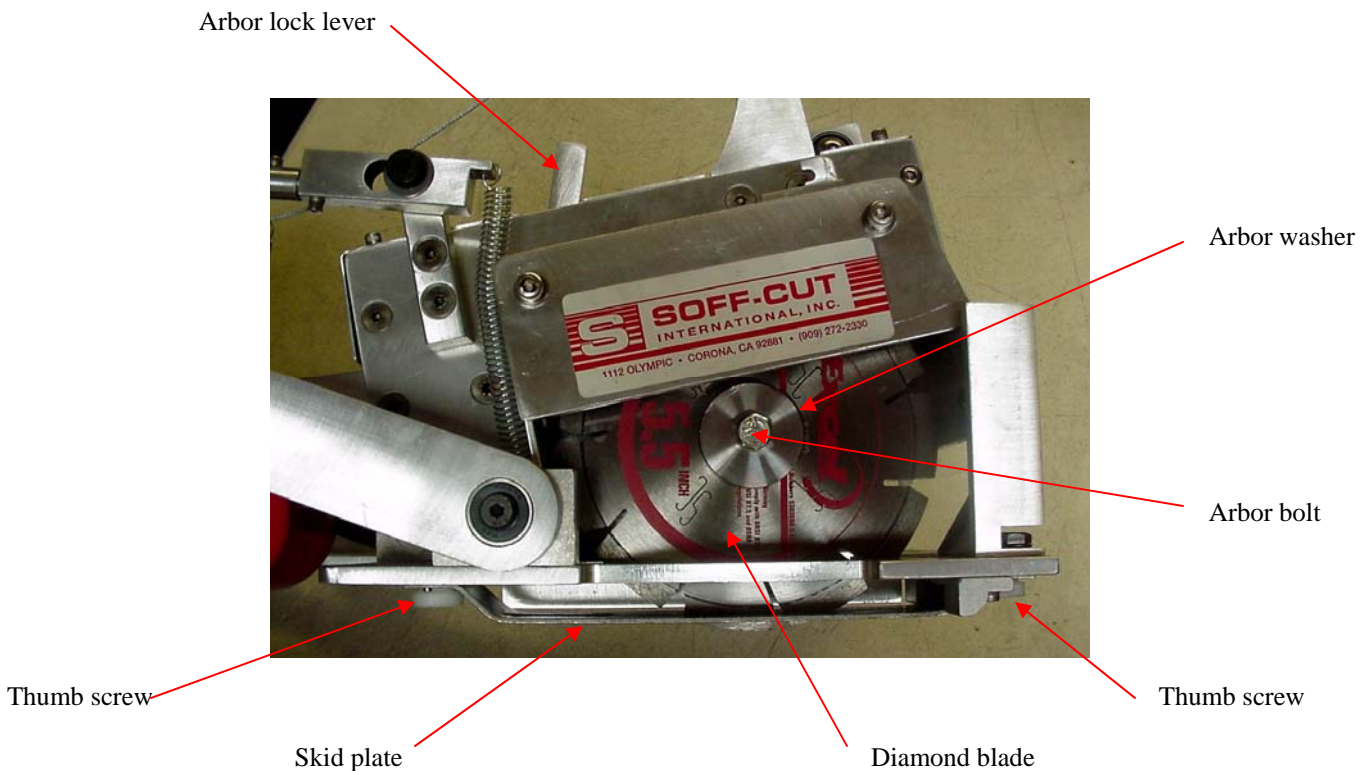
The Excel Series of diamond blades have been designed specifically for the Soff-Cut Ultra Early Entry dry cutting system of green concrete. These specialty blades are designed to increase speed and life while cutting a wide range of aggregates. Choose the correct specification of diamond blade for your area as follows:

Red Excel Series 3000	part no. XL55-3000	Hard aggregate, medium abrasive sand
Yellow Excel Series 5000	part no. XL55-5000	Medium hard to soft aggregate, abrasive sand
Blue Excel Series 7000	part no. XL55-7000	Soft aggregate, highly abrasive sand

With the saw turned off, unplugged from the power source and the safety switch on the handle in the OFF (red) position, push the box release lever on the left side of the saw forward and raise the front of the box. With the box fully tilted rearward, rotate the blade by hand while pushing rearward on the arbor lock lever on the right side of the saw. With the blade wrench provided with the saw, loosen the blade bolt on the arbor by turning counter clockwise. Remove the outer arbor washer or flange.

**WARNING: Inspect the blade for any damage. Do not use any blade that has cracks, nicks, flaws or a damaged arbor. Make sure the blade is marked with a maximum operating speed greater than 7000 rpm.** Match the blade tri-arbor to the blade shaft arbor and install the blade firmly against the rear flange. Insure the blade is installed on the tri-arbor correctly. Match the female tri-arbor of the outer washer or flange with the blade shaft and install the blade shaft bolt turning clockwise while holding the arbor lock lever. Be sure the outer flange is fully seated and firmly holding the diamond blade in position. Install a new skid plate by removing the white thumb nuts on the bottom of the saw. Install the skid plate on the studs by applying pressure on the ends of the skid plate. An alignment pin insures that the plate installs in one direction only. Do not force the skid plate or apply force in the center of the skid plate as this can bend or warp the skid plate and may cause chipping and raveling of the cut. Install the white thumb nuts to hold the skid plate. Check that the blade aligns with the skid plate slot. When replacing a worn blade, thoroughly clean the concrete from the blade block guard assembly and front diverter before installing the new blade. Discard the old skid plate and replace it with a new skid plate.

**Note: The patented skid plate is the most important part of the Soff-Cut Ultra Early Entry system. If it is bent, twisted or damaged, spalling and raveling of a cut may result. Store skid plates carefully and install them properly. Install a new skid plate with each new blade. Never reuse skid plates.**



## OPERATING INSTRUCTIONS

Experience is very important when running the **X-390** electric saw. A skilled worker is highly recommended. Read all instructions before using the saw. Always do an inspection of the saw before starting the motor. Check that all controls are in good working order. Check for loose bolts or nuts. Check the cord for damage. Insure all guards are secure, undamaged and properly installed. **WARNING: Do not operate the saw unless all guards, safety equipment and the motor on/off switch are in place and operational!** Repair or replace any damaged components. Check for proper specification of blade and that the skid plate is installed properly. Check that the blade and skid plate are in good condition. Make sure the work site is clean, well lit and hazard free.

Install the handles depending on the length needed. For best results, use both handles or 6 feet of length. Attach the extension cord to the handle with the cord clamps. This will keep the cord away from the saw. Make sure the safety switch on the handle is in the OFF (red) position. Extend the front guide mechanism with the white wheel and latch into place by sliding it forward on the hooked latch on top of the blade guard. Plug in the extension cord to the proper electrical source. Check that the cord is not tangled or caught on anything. Use a minimum generator size of 2800 watts with a 20 amp circuit breaker for 110 volts.

To begin sawing, line up the saw with the cut line using the white wheel on the front guide and the small notch on the back of the base plate. Turn the safety switch to the ON (green) position. To turn the motor on, rotate the handle clockwise while keeping the saw aligned with the cut. Rotating the handle fully to the right will turn the motor on. Hold tightly as the saw will move back toward you slightly when starting to cut. Hold pressure to the right to keep the motor running. Push the saw forward with even pressure to cut keeping the front guide wheel on the cut line. Push the saw at about half speed for the first 20 feet to allow the blade to develop good diamond exposure or open up and promote full blade life. Increase the forward speed of the saw until the depth gauge starts to show red. All red is too fast. **Do not force the saw or stall the motor.** At the left rear corner of the saw is an aggregate adjustment knob. This adjustment knob will change the down pressure on the cutting blade in relationship to the hardness of the aggregate in your area. Simply turn the knob accordingly to the soft, medium or hard setting. By using the proper aggregate setting in conjunction with the depth gauge, you will obtain optimum cutting speeds. If in doubt, contact your ready mix supplier to help determine the aggregate hardness. **Do not add additional weights to the saw.** When approaching a wall or obstruction, touch the guide wheel against the wall and then back up to release the guide. The guide will rise out of the way to finish the cut. When the cut is complete, turn the handle quickly counter-clockwise until it stops. The motor will stop, the blade will raise and pressure will be applied to the rear back up wheel. Push down on the handle until about knee high and roll the saw off the concrete on the 2 rear wheels. Flip the safety switch to the OFF (red) position to avoid false starting. **Always secure the saw from movement while unattended.** Periodically, clean any excess concrete from inside the blade guard and front diverter. Always clean the blade guard assembly thoroughly before storing the saw. The saw will leave two trails of concrete cuttings. Lightly sweep the cuttings parallel to the cut with a soft bristle broom. **Do not walk on the joints or transport equipment across the joints until the concrete fully hardens.**



## **MAINTENANCE**

The following maintenance should be performed by the saw owner or operator.

- **Guards** – Check all guards for damage and proper function daily especially the blade guard. The blade guard should be secure to the saw and not damaged.
- **Diamond blade** – Inspect diamond blades daily for damage, cracks, secure fit to the arbor, loss of segments, warping or overheating. **If any blade shows any of these problems, discard the blade and never use.**
- **Skid plate** – Inspect the skid plate daily for damage, excessive wear in the blade slot, burrs on the concrete surface side, twisting and any movement when installed on the saw. Replace the skid plate with each new diamond blade. Never reuse skid plates or spalling and raveling may result. Periodically, check the skid plate for alignment with the blade. Insure that the blade does not contact the skid plate and adjust if necessary.
- **Saw controls** – Inspect all controls for proper function daily. **Check the motor on/off switch for proper operation.**
- **Cleaning** – Clean the blade guard and bottom plate of any excess concrete build up after each use. Keep the handle clean and dry. Keep all openings and slots on the saw clean and open so air flows freely through the motor compartment to insure proper cooling. Use compressed air and blow out the back side of the motor where the air intake slots are located. Rotate the arbor shaft by hand while cleaning the motor.
- **Saw pivot** – The saw box should be free to pivot without binding on concrete deposits. Clean and/or replace bearings as necessary.
- **Wheels** – Wheels should be wiped clean of sealers and concrete deposits. Inspect wheels for damage. Insure wheels roll freely.
- **Plastic case** – Keep plastic case clean as loose material can lodge in motor during transportation.

Any other maintenance or repairs should be done by a competent mechanic or by Soff-Cut personnel only.

**CAUTION:** Certain cleaning agents and solvents damage parts. Some of these are gasoline, carbon tetrachloride, chlorinated cleaning solvents, ammonia and household detergents that contain ammonia. Avoiding use of these and similar types of cleaning agents minimizes the probability of damage.

**WARNING:** Do not modify the saw! Use only Soff-Cut International replacement parts. Use of unauthorized parts may create a danger or damage the engine.



## **SAWING CONTRACTION JOINTS**

As concrete hydrates or cures and begins to set, it develops internal stresses which may cause random cracks casting doubt on the quality and workmanship of the concrete. Joints are saw cut in concrete to relieve these stresses before they seek their own relief in the form of a random crack. The Soff-Cut Ultra Early Entry system controls random cracking through the early timing of a saw cut at predetermined locations to create weakened planes in the concrete that subsequently crack at the bottom of the cut to relieve the stress. Soff-Cut sawed contraction joints should be a minimum of 1/8<sup>th</sup> the concrete depth and a minimum of 1” (25mm) deep. Contraction joints should be sawn as soon as the concrete will support the weight of the saw and the operator without marking or damaging the concrete. There are many possibilities for joint layout. Joint layout should be provided by the project designer, engineer or architect. If the joint layout is not provided, the saw contractor should submit a detailed joint layout for approval prior to cutting. Several factors affect joint spacing including:

- Concrete thickness
- Type, amount and location of reinforcement
- Shrinkage potential of concrete – cement (type, quantity), aggregate (size, quantity, quality), water to cement ratio, admixtures, concrete temperature
- Base friction
- Slab restraints
- Layout of foundations, racks, pits, equipment pads, trenches, etc.
- Environmental factors – temperature, wind, humidity
- Methods and quality of concrete curing.

Generally, contraction joint patterns should divide slabs into approximate square panels per the recommended spacing shown.

<b>RECOMMENDED CONTRACTION JOINT SPACING</b>	
<b><u>Concrete thickness, in. (mm)</u></b>	<b><u>Maximum spacing, ft (m)</u></b>
3.5 (90)	8 (2.4)
4, 4.5 (100, 114)	10 (3.0)
5, 5.5 (125, 140)	12 (3.6)
6 (150) or greater	15 (4.5)

At all intersecting cross cuts, install Soff-Cut joint protectors at each joint to prevent joint damage.

## **TROUBLESHOOTING**

### **MOTOR WILL NOT START**

- Check that the saw is plugged in correctly and you have the proper voltage.
- Check that the circuit breaker on the electrical outlet is not tripped.
- Check that the safety switch on the handle is in the ON (green) position.
- Insure that you have rotated the handle clockwise to the farthest position.
- Check that the blade shaft rotates freely and no concrete has built up in the blade block or motor.
- Check that the generator is on and at full throttle.
- Check that the ground fault interrupter on the electrical outlet is not tripped.
- Check that the extension cord is not faulty.

### **MOTOR RUNS BUT BOGGS DOWN WHEN CUTTING**

- Check that the extension cord is the proper wire gauge size for the length used.
- Check that the generator is at least 2800 watts and is at full throttle.
- Check that the diamond blade is the correct specification for the aggregate being cut.
- Check that the diamond blade is not worn out, glazed, warped or damaged.
- Insure that the diamond blade is not being twisted in the cut.
- Check that the diamond blade is not contacting the skid plate when cutting.
- Check that the aggregate adjustment knob is set for the proper aggregate for your area.
- Insure the diamond blade is properly mounted and secured with clean flanges.

### **SAW IS SPALLING AND RAVELING CUT**

- Check to see if diamond blade is worn out, glazed, warped or damaged.
- Insure that the diamond blade moves freely through the skid plate without contact.
- Check skid plate for excessive wear or gap around the diamond blade.
- Check bottom of skid plate for metal burrs or irregularities.
- Insure skid plate is not twisted or bent.
- Do not twist or move the saw sideways while cutting.
- Check that the motor is running properly.
- Insure the diamond blade is properly mounted and secured with clean flanges.
- Insure that the diamond blade is the correct specification for your area.
- Insure the slab is clean with no debris that could raise the skid plate or saw while cutting.
- Use Soff-Cut joint protectors at all cut intersections.
- Clean excess concrete debris from the blade guard assembly, front diverter, skid plate and bottom plate.

### **SAW PULLS TO ONE SIDE WHILE SAWING**

- Check front guide is properly aligned with the center of the diamond blade.
- Check to see if diamond blade is worn out, glazed, warped or damaged.
- Do not twist or move the saw sideways while cutting. Make gradual changes in pressure on the handlebar to control the saw in the cut.
- Insure that all wheels roll freely and smoothly.
- Do not force the saw. Allow the diamond blade to cut at its own rate of speed.
- Check the skid plate for damage or burrs.

## **WARRANTY**

The SoffCut International electric saw is thoroughly inspected and tested before leaving the factory. It is warranted to be free of defects from workmanship and materials for a period of 90 days from the date of original purchase or 10 hours, whichever comes first.

Before work is performed on any related warranty item, you must submit date of purchase and warranty repair estimate to SoffCut International. This can be done by letter, fax or telephone. SoffCut International will approve the cost or have you ship the unit back to SoffCut International prepaid for repair. Concerning parts that have failed, you can obtain a Returned Merchandise Authorization (RMA) number from SoffCut International. Send the parts back to SoffCut International prepaid with proof of purchase and the RMA number, and one of the following will happen:

1. Your account will be credited
2. The part will be repaired and returned to you
3. The part will be replaced and sent to you.

Note: SoffCut International is not responsible for shipping costs.

The above SoffCut International warranty does not apply under the following circumstances:

- Repairs made or attempted by others.
- Repairs required because of normal wear and tear.
- The saw has been abused, misused or improperly maintained
- Alterations have been made to the saw.

THE USE OF ANY OTHER BLADE EXCEPT THE ORIGINAL SOFFCUT BLADE PACKAGE MAY VOID THE WARRANTY AND COULD CAUSE INTERNAL DAMAGE TO THE MOTOR.

IN NO EVENT SHALL SOFFCUT INTERNATIONAL BE LIABLE FOR ANY INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES FROM THE SALE OR USE OF THE PRODUCT. THIS DISCLAIMER APPLIES BOTH DURING AND AFTER THE TERM OF THIS WARRANTY.

SOFFCUT INTERNATIONAL DISCLAIMS LIABILITY FOR ANY WARRANTIES INCLUDING IMPLIED WARRANTIES OF "MERCHANTABILITY" AND "FITNESS FOR A SPECIFIC PURPOSE" AFTER THE TERM OF THIS WARRANTY.

This warranty gives you specific legal rights and other possible rights, which may vary from state to state. Some states do not allow the exclusion or limitation of incidental or consequential damages so the above limitation or exclusion may not apply to you. Some states do not allow limitations on how long an implied warranty lasts so the above limitation may not apply to you.

If you are unable to obtain warranty service or are dissatisfied with the warranty service you received, contact the owner of the dealership involved. Normally, this should resolve your problem. For further assistance, call our parts and service department at 1-800-776-3328 or 1-951-272-2330.

### **Copyright 2008 Soff-Cut International, Inc.**

Covered by one or more of the following U.S. Patents

4769201, 4889675, 4928662, 4938201, 5056499, 5086750, 5184597, 5303688, 5305729, 5373834, 5441033, 5505189, 5507273, 5570677, 5575271, 5579754, 5582899, 5603310, 5660161, 5664553, 5666939, 5689072, 58030371, 6892719.

Other U.S. and foreign patents pending.

## Maximizing the Soff-Cut® System

**“The timing of concrete operations – especially finishing and jointing – is critical”**, states a quote from the foreword of the American Concrete Institute (ACI) 302.1R-96. It goes on to say that “Failure to address this issue can contribute to undesirable characteristics in the wearing surface such as cracking...” (It mentions other problems).

The patented Soff-Cut Ultra Early Entry system has revolutionized the method used to control random cracking. While Soff-Cut is being specified more today than ever, sometimes the ultra early-entry spec is not always followed on the job site. When that happens, building owners are not getting what they are paying for or the finished product they expect.

In order for the Soff-Cut system and an experienced Soff-Cut contractor to do a satisfactory job, four components must exist to meet the “specification”:

1. A Soff-Cut Ultra Early Entry dry up-cut saw
2. A Soff-Cut dry-cutting diamond blade
3. A Soff-Cut anti-ravel skid plate installed with every new diamond blade
4. An operator skilled in using the Soff-Cut Ultra Early Entry cutting system.

Without this, joints can not be cut early enough to control random cracking before it starts, which is what the building owner is paying for.

The ACI Spec 302.1R-96 says it best:

“Early-entry dry-cut saws use diamond-impregnated blades and a skid plate that helps prevent spalling. Timely changing of skid plates is necessary to effectively control spalling. It is best to change skid plates in accordance with manufacturer’s recommendations...The goal of saw-cutting is to create a weakened plane as soon as the joint can be cut...The timing of the early-entry process allows joints to be in place prior to development of significant tensile stresses in the concrete...”

The Portland Cement Association (PCA) engineering bulletin, Concrete Floors on Ground, also states:

“Proper jointing can eliminate unsightly random cracks. Aspects of jointing that lead to a good job are choosing the correct type of joint for each location, establishing a good joint pattern and layout, and installing the joint at the correct time...**Timing of joint sawing is critical**...Lightweight, high-speed, early-cut saws have been developed to permit joint sawing very soon after floor finishing, sometimes within 0 to 2 hours...if the cut is sawn within a few hours after final finishing, random cracking can be controlled...”

Soff-Cut has the only Ultra Early Entry dry-cutting system which controls random cracking through the early timing of the cut. With the patented Soff-Cut method, control joints are usually cut within 0 to 2 hours after the finishing process. Joint cutting should begin as soon as the concrete will support the weight of the saw and the operator at each joint location and before final set. If the joints are not being cut within this time frame then the Soff-Cut Ultra Early Entry method is not being followed and building owners are not getting what they are paying for or the finished product that they expect.

We hope this information is beneficial to building owners, general contractors, concrete finishers, saw operators and the entire industry. For additional information, contact Soff-Cut International, Inc. at (951) 272-2330 or (800) 776-3328, or see our website [www.soffcut.com](http://www.soffcut.com).

Revised 9/2008