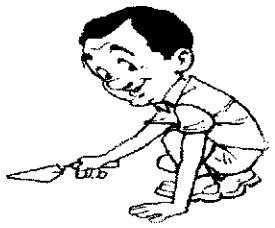
B.T. ENGINEERING PTY LTD



BRICKSAWS WORKPLACE OPERATING INSTRUCTIONS

Note: Occupational Health and Safety regulations must be followed at all times

TO OPERATE THE BRICKSAW YOU MUST:-

1. BE RECOGNISED BY THE EMPLOYER AS A COMPETENT OPERATOR.
2. CHECK TO ENSURE THE MACHINE IS OPERATIONAL AND NO "OUT OF SERVICE" TAGS ARE ATTACHED.
3. CHECK THAT ALL GUARDS ARE IN PLACE.
4. CHECK THAT THE BLADE IS IN GOOD CONDITIONS AND ATTACHED SAFELY TO THE MACHINE.
5. MAKE SURE THE WORK AREA IS CLEAR OF OBSTRUCTIONS.
6. WEAR APPROPRIATE PERSONAL SAFETY EQUIPMENT EG. EAR MUFFS, SAFETY GLASSES AND STEEL CAPPED WORK BOOTS.
7. CHECK POWER SUPPLY IS OPERATIONAL, ENSURE ELELCTRIC SWITCH IS IN OFF POSITION BEFORE CONNECTING EXTENSION CORD, USE APPROPRIATE AMPERAGE AND MAXIMUM 20M EXTENSION LEAD ONLY.
8. PETROL POWERED UNITS, FOLLOW REGULAR MAINTANENCE GUIDELINES IN OWNERS MANUAL. USE UNLEADED FUEL ONLY, USE IN WELL-VENTILATED AREA, DO NOT REFUEL WHILE MOTOR IN OPERATION, STORE PETROL IN APPROVED CONTAINERS.
9. ENSURE THAT WATER IS RUNNING FREELY ONTO THE BLADE AT ALL TIMES WHEN CUTTING.
10. NEVER FORCE THE BLADE THROUGH THE MATERIAL BEING CUT.
11. TURN OFF THE POWER AND WATER SUPPLY AT THE COMPLETION OF CUTTING OR WHEN LEAVING THE MACHINE.

HOLDING MATERIAL TO BE CUT

1. WHEN HOLDING BRICKS KEEP HANDS AND FINGERS AT LEAST 50MM FROM BLADE.
2. HOLD BRICKS FIRMLY WHEN CUTTING. YOU CAN USUALLY HOLD THE BRICK WITH YOUR THUMBS AGAINST THE FRONT RAISED EDGE OF TABLE OR CART.
3. NEVER HOLD A BRICK THAT YOU ARE CUTTING WITH YOUR HAND ACROSS THE FRONT OF THE BLADE.
4. DO NOT TRY TO CUT MORE THAN ONE BRICK AT A TIME.
5. DO NOT START SAW UNLESS THE MATERIAL TO BE CUT IS CLEAR OF THE BLADE.
6. MAKE SURE MATERIAL TO BE CUT IS SITTING FLAT, SQUARE AND AGAINST THE FRONT EDGE OF THE CART IF POSSIBLE. USE A BRUSH REGULARY TO SWEEP GRIT ETC OFF THE TOP OF THE CART.
7. BE VERY CAREFULL IF TRYING TO ALIGN MATERIAL ON THE CART WHILST BLADE IS RUNNING.
8. IF THE SAW BLADE BINDS IN A CUT, DO NOT ATTEMPT TO HOLD OR GRAB IT. LET IT GO AND IMMEDIATELY TURN OFF THE POWER.
9. DO NOT CUT MATERIAL THAT HAVE CRACKS IN THEM.
10. WHEN MAKING DEEP CUTS EG 110MM SPLITS, DO NOT PUSH THE CUT PORTIONS AGAINST THE SIDES OF THE BLADE. KEEP THE HAND PRESSURE DOWNWARDS.
11. ALWAYS ENSURE THAT YOUR FINGERS ARE NEVER PLACED IN FRONT OR BEHIND WHERE THE BLADE WILL CUT.
12. NEVER PUT YOUR FINGERS INSIDE THE HOLES OR SLOTS OF EXTRUDED BRICKS WHILE CUTTING THEM.

CUTTING TECHNIQUES

1. **BACK CUTTING** IS THE SAFEST WAY TO CUT BECAUSE THERE IS NO CHANCE OF THE BRICK BEING CAUGHT BY THE BLADE AND THROWN OUT THE BACK OF THE SAW. ON THE DOWNS SIDE THOUGH, THIS METHOD IS MARGINALLY SLOWER AND CAN CAUSE MORE WEAR TO THE BLADE.
   METHOD ONCE THE BRICK IS SET IN POSITION AND READY TO CUT, THE CART IS BROUGHT FORWARD (TOWARDS THE OPERATOR). THE BLADE LOWERED AND LOCKED IN POSITION TO THE LEVEL OF THE CART. TURN SAW AND WATER ON. THE BRICK IS THEN SLOWLY PUSHED THROUGH THE BLADE.

2. **STEP CUTTING** USUALLY QUICKER BUT OPERATOR MUST ENSURE THAT THE BRICK IS BEING CUT MORE ON THE BACK THAN THE FRONT AT ALL TIMES SO THAT THE CHANCE OF THE BRICK BEING CAUGHT BY THE BLADE IS REDUCED.
   METHOD ONCE THE BRICK IS SET IN POSITION AND READY TO CUT THE CART IS BROUGHT FORWARD (TOWARDS THE OPERATOR). THE SAW AND WATER SWITCHED ON. THE BRICK IS THEN PUSHED UNDER THE BLADE WHILST IT IS STILL IN THE RAISED POSITION. THE BLADE IS THEN LOWERED AS THE CART AND BRICK ARE PUSHED BACK AND FORTH. KEEP AN EVEN PRESSURE ON BLADE AT ALL TIMES. THIS MEANS THAT THE BRICK IS BEING CUT ON BOTH THE FORWARD AND BACKWARD MOVEMENT OF THE CART AND NOT BEING "BUMPED" INTO THE CUT.

B.T. BRICKSAW

Congratulations on your purchase of a B.T. Bricksaw.
B.T. Bricksaws have been carefully designed & engineered to provide ease of operations and many years of excellent service.

Please follow these guide lines:

1. WATER - use as much water as possible to keep blade cool, to little water causes heat build up which weakens the welding between diamond segment and blade blank.
HINT - attach 1" PVC clear tube to drain at rear of saw, to drain water to an unused area of worksite.

2. ELECTRIC MOTORS - (WARNING) Recommended maximum extension lead length 15M OF 15AMP
To long lead or poor power supply could cause motor damage
(No Warranty on burnt out start windings in electric motors)
If your electric motor overheats and cuts out:
- check lead is not to long
- Your blade selection is OK? Wrong blade selection could mean you have to push to hard putting load on the motor.

WARNING - Do Not hose motor to cool it down as water can enter and damage may occur.

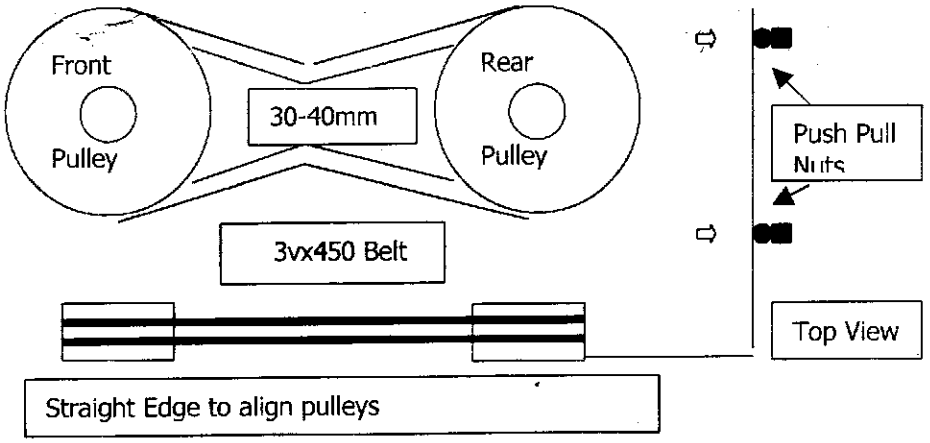
3. WORKHEAD - the bearings are sealed so greasing is not necessary, however if you remove the seals you can apply some grease yourself. Use water resistant grease. If any work has been carried out on the workhead it is essential to loctite bearings and pulleys to shalf.

4. Keep your saw clean. Buildup of muck in bed of saw can cause rust.

5. BLADE TENSION - Correct Blade tension and alignment is important to the performance of your saw.

TO ADJUST BELT TENSION

Loosen 4 Motor mount bolts.Use Push/Pull Nuts a rear of saw to achieve correct alignment.



6. BLADE SPEED - is set on electric motors at 2900 RPM.
Petrol engined saws are also set at 2900 RPM before leaving our workshop.

7. NOTE PETROL ENGINES - check oil before starting. We recommend you purchase a spare air cleaner and change it regularly.

BLADES - Much has to be learn't to get the most out of blades.

A. Firstly to Cut HARD material you need a soft matrix blade.
A SOFT blade leaves the diamond chips standing pround you need this to cut into the hard materials such as most extruded clay bricks and pavers.

B. To cut SOFT materials such as dry pressed clay bricks and pavers to cement blocks the blade has to be able to withstand this. If you use a soft matrix blade on soft brick you will shorten the life of your blade. It is our recommendation you buy two types of blades, this will ensure maximum life and fast cutting of each particular type of material (please correctly mark each blade for its particular use). Remember if you use hard blade on hard material it will take longer and put more load on your saw. Time is money spend a little extra on Top Quality Blades and spend more time laying bricks or pavers.