1051 Olsen Dr Ste 111 | Henderson, NV 89011
Phone: 702-294-1231 | Fax: 702-294-1232
Email: info@oshlun.com | Website: www.oshlun.com

Stack Dado Set Instructions

Item #SDS-0630 & SDS-0842

Safety Information

- Read and obey all instructions including your machine owner's manual. Failure to obey instructions could lead to serious bodily injury or even death.
- All rotating tools can be dangerous, use this product at your own risk.
- Always wear ANSI approved eye and hearing protection, as well as a dust mask or respirator. A full-face shield is also recommended.
- Do not use this product on any under-powered table saw or other type of machine such as a miter saw, portable circular saw, or any other saw that is not recommended to run a stack dado by the saw manufacturer. Consult your owners manual before use and obey all instructions. Contact the saw manufacturer if you do not have the manual.
- Always turn the power off and unplug the electrical cord when changing blades, accessories, or servicing the machine.
- Keep your hands, body, clothing, and hair clear of the cutting area. Do not wear jewelry or loose fitting clothing while using this product.
- Be sure to follow the rotational arrows on the blades and chippers when installing.
- Always do a final inspection and make sure the arbor nut is properly securing the dado. Also ensure that the blades and chippers are properly spaced so the carbide teeth are not touching.
- Never use this product at speeds in excess of the maximum RPM rating.
- It is recommended to use a dado insert if using on a table saw.
- Carbide is a very hard and brittle material that can chip or break if it strikes rocks, nails, or other foreign objects. Make sure that the material you are cutting is free of these foreign objects.
- Before each use, inspect the dado for dull, missing, broken, or cracked teeth, or any other damage. Do not use if the dado is dull or any damage is suspected.
- Use this product only for cutting wood.
- Always use both outside saw blades. Never use the chippers or just one outside saw blade alone.
- Only operate the machine when proper safety guards are in place.
- It is important that you have a stable machine free of vibration and minimal arbor run out tolerance (0.003" maximum run-out). This can be checked with a dial indicator and a magnetic base.

Caution

Sharpening these tools with a diamond file or grinding wheel will produce dust with potentially hazardous ingredients, specifically cobalt and tungsten. If the teeth become dull, it is highly recommended to have them professionally sharpened by a qualified local saw sharpening shop.

Fig. 1

Fig. 2

Produces small score marks on the outer edges to help reduce tear-out and splintering.

Fig. 3

General Information

This dado has been designed with beveled outside blade teeth. This means that the outside saws will cut the very outer edges slightly deeper than the chippers (see Fig. 2). This minimizes tear-out and gives an overall better cut. This dado has also been designed to cut undersized to accommodate "nominal thickness" plywood. Both of these features are common on many different dado sets on the market.

Dado Cut Chart

Width	Saws	1/8"	1/16"	3/32"
1/4"	2	0	0	0
5/16"	2	0	1	0
11/32"	2	0	0	1
3/8"	2	1	0	0
13/32"	2	0	1	1
7/16"	2	1	1	0
15/32"	2	1	0	1
1/2"	2	2	0	0
17/32"	2	1	1	1
9/16"	2	2	1	0

Note: Shims can be added for any adjustments

Width	Saws	1/8"	1/16"	3/32"
19/32"	2	2	0	1
5/8"	2	3	0	0
21/32"	2	2	1	1
11/16"	2	3	1	0
23/32"	2	3	0	1
3/4"	2	4	0	0
25/32"	2	3	1	1
13/16"	2	4	1	0
27/32"	2	4	0	1
29/32"	2	4	1	1

Note: 29/32" width will require use of shims

Notes: The above Dado Cut Chart is intended to be used as a guide only and does not account for any re-sharpening or normal manufacturing and run-out tolerances. This chart also does not account for the undersized cut design for "nominal thickness" plywood. We recommend doing a test cut in scrap wood to ensure the width is suitable for your needs. Use shims for any adjustments.

Dado Setup Instructions

Use the Dado Cut Chart (above) to select the components needed for the dado width that you want and proceed with the following.

- Unplug the saw and remove the nut, outer flange, and saw blade from the arbor shaft.
- Carefully clean and inspect the arbor shaft threads, nut, flanges, dado pieces, and all safety devices.
- Determine the proper rotation of the outside saws and chippers (the face of the teeth should be facing the front of the table saw if using a table saw).
- Place the inside flange on the arbor shaft (if not already attached) and install the left outside saw blade with the high point of the angled teeth on the outside of the cut and the blade markings facing out.
- As needed, add the desired number of chippers and shims (be sure to place the chipper teeth inside the gullet area of the outside blades and space the teeth so they do not touch, see Fig. 1). If using more than one chipper, space them evenly for optimum balance and cutting performance. If using multiple shims, spread them evenly throughout the stack.
- Add the right outside saw blade and make sure that the chipper teeth (or left outside blade teeth) are inside of the gullet area of the right outside saw blade. It is important that no carbide teeth are in contact with each other or another part of the blade body prior to tightening.
- Install the outer flange and tighten the nut. The nut should be secured by a minimum of 3 threads on the arbor shaft. If you are cutting a wide dado width, you may need to leave the outside flange off of the arbor shaft to ensure that the nut is securely fastened by at least 3 threads.
- Make sure all safety guards are in place and re-install table saw dado insert if using a table saw.
- Plug in the saw and perform a test cut in scrap wood to ensure you have the desired cut width. Adjust the cut width with shims as necessary.

Notes: Carbide teeth should never come in contact with other teeth or steel bodies. If you use shims to get your desired cut width, we recommend that you spread them out between different blades as opposed to stacking them together. For wide or deep dadoes, multiple passes are recommended to reach the desired width or depth.

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