

Carbide Tipped Dado Sets General Purpose

Tool number	Description	Dia.	Teeth	Kerf	Bore
8-24 DADO	Complete Set	8"	24	13/16"	5/8"
8-1/16	Dado Chipper	8"	2	1/16"	5/8"
8-1/8	Dado Chipper	8"	2	1/8"	5/8"
8-24R	Saw Blade R	8"	24	1/8"	5/8"
8-24L	Saw Blade L	8"	24	1/8"	5/8"

Negative Hook Tooth Design Suitable for Wood & Melamine

Tool number	Description	Dia.	Teeth	Kerf	Bore
8-24 DADO-1	Complete Set	8"	24	13/16"	1"
8-1/16-1	Dado Chipper	8"	2	1/16"	1"
8-1/8-1	Dado Chipper	8"	2	1/8"	1"
8-24R-1	Saw Blade R	8"	24	1/8"	1"
8-24L-1	Saw Blade L	8"	24	1/8"	1"

Negative Hook Tooth Design Suitable for Wood & Melamine

Tool number	Description	Dia.	Teeth	Kerf	Bore
10-24 DADO	Complete Set	10"	24	13/16"	5/8"
10-1/16	Dado Chipper	10"	2	1/16"	5/8"
10-1/8	Dado Chipper	10"	2	1/8"	5/8"
10-24R	Saw Blade R	10"	24	1/8"	5/8"
10-24L	Saw Blade L	10"	24	1/8"	5/8"

Tool number	Description	Dia.	Teeth	Kerf	Bore
10-24 DADO-1	Complete Set	10"	24	13/16"	1"
10-1/16-1	Dado Chipper	10"	2	1/16"	1"
10-1/8-1	Dado Chipper	10"	2	1/8"	1"
10-24R-1	Saw Blade R	10"	24	1/8"	1"
10-24L-1	Saw Blade L	10"	24	1/8"	1"

Tool number	Description	Dia.	Teeth	Kerf	Bore
12-24 DADO	Complete Set	12"	24	13/16"	1"
12-1/16	Dado Chipper	12"	2	1/16"	1"
12-1/8	Dado Chipper	12"	2	1/8"	1"
12-24R	Saw Blade R	12"	24	1/8"	1"
12-24L	Saw Blade L	12"	24	1/8"	1"

Dado Shims *sold separately*

Tool number	Complete set includes:
S14	4 shims .002" Red
	2 shims .005" Blue
	4 shims .010" Black
	4 shims .020" Yellow

Set of 14 Dado Shims. Made from durable plastic, these shims are color coded for different thickness.

Outside diameter: 2 3/4"

Inside diameter: 5/8"

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Tool number	Description	Dia.	Teeth	Kerf	Bore
6-18 DADO CL	Complete Set	6"	18	13/16"	5/8"
6-1/16	Dado Chipper	6"	2	1/16"	5/8"
6-1/8	Dado Chipper	6"	2	1/8"	5/8"
6-18R	Saw Blade R	6"	18	1/8"	5/8"
6-18L	Saw Blade L	6"	18	1/8"	5/8"

Chip Limiter - will prevent kickback

Tool number	Description	Dia.	Teeth	Kerf	Bore
8-24 DADO-CL	Complete Set	8"	24	13/16"	5/8"
8-1/16	Dado Chipper	8"	2	1/16"	5/8"
8-1/8	Dado Chipper	8"	2	1/8"	5/8"
8-24RC	Saw Blade R	8"	24	1/8"	5/8"
8-24LC	Saw Blade L	8"	24	1/8"	5/8"

Chip Limiter - will prevent kickback

Carbide Tipped Dado Sets For Melamine

Tool number	Description	Dia.	Teeth	Kerf	Bore
8-46 DADO TN	Complete Set	8"	46	13/16"	5/8"
8-1/16	Dado Chipper	8"	2	1/16"	5/8"
8-1/8	Dado Chipper	8"	2	1/8"	5/8"
8-46R	Saw Blade R	8"	46	1/8"	5/8"
8-46L	Saw Blade L	8"	46	1/8"	5/8"

Tool number	Description	Dia.	Teeth	Kerf	Bore
8-46 DADO TN-1	Set	8"	46	13/16"	1"
8-1/16-1	Dado Chipper	8"	2	1/16"	1"
8-1/8-1	Dado Chipper	8"	2	1/8"	1"
8-46R-1	Saw Blade R	8"	46	1/8"	1"
8-46L-1	Saw Blade L	8"	46	1/8"	1"

Tool number	Description	Dia.	Teeth	Kerf	Bore
10-58 DADO TN	Set	10"	58	13/16"	5/8"
10-1/16	Dado Chipper	10"	2	1/16"	5/8"
10-1/8	Dado Chipper	10"	2	1/8"	5/8"
10-58R	Saw Blade R	10"	58	1/8"	5/8"
10-58L	Saw Blade L	10"	58	1/8"	5/8"

Tool number	Description	Dia.	Teeth	Kerf	Bore
10-58 DADO TN1	Set	10"	58	13/16"	1"
10-1/16-1	Dado Chipper	10"	2	1/16"	1"
10-1/8-1	Dado Chipper	10"	2	1/8"	1"
10-58R-1	Saw Blade R	10"	58	1/8"	1"
10-58L-1	Saw Blade L	10"	58	1/8"	1"



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DADO SET INSTRUCTIONS

Thank you for purchasing a DIMAR premium quality cutting tool. For your safety and to achieve good results, please read and fully understand these instructions before using this tool.

The DIMAR stacking dado set is an industrial quality carbide tipped tool that will give you years of trouble-free service, provided that it is properly maintained, re-sharpened and used in accordance with this booklet and other appropriate reference material.



Each Dado set consists of:

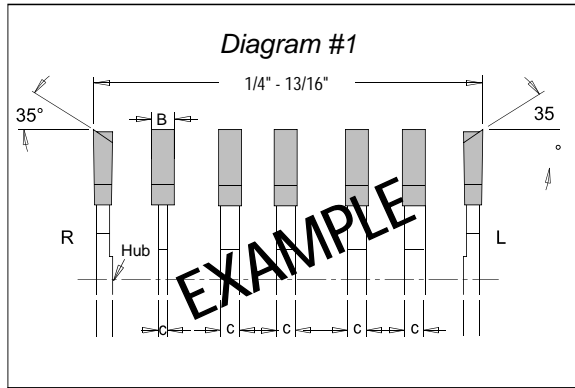
- 1 Saw Blade, Right Hand rotation
- 1 Saw Blade, Left Hand rotation
- 1 Dado Chipper 1/16"
- 4 Dado Chippers 1/8"
- Instruction Manual

Machine Selection:

Dado sets can be used on table saws or radial arm saws with 1-1/2 or more horsepower. Do not use this product in any under-powered table saw or other type of equipment such as a miter saw, portable circular saw, compound miter saw, portable table saw, etc. It is very important that your machine is stable, free of vibration and has minimal arbor run-out tolerances (.003" maximum). The run out can easily be checked using a dial indicator and magnetic base. In addition, the table insert (if using a table saw) must be of the appropriate type for dado sets, the arbor length must be adequately long, and the flanges/hardware must be in good condition.

Machine set up:

Unplug and lock out all power to the machine. Remove table insert, if using a table saw. Remove locknut, collar(s) and blade from arbor, flanges, dado components and all safety devices and guards. Determine the proper rotation of the outside saw blades by positioning the blades with the teeth facing you. The hubs of the saw blades should now be facing in, towards each other. (See diagram #1) Begin by placing the first collar on the arbor (if not already attached), then the first outside blade (the hub should face the end of the arbor). Next, add the appropriate chipper(s) and shim(s), being sure to stagger the chippers 90 degrees



Machine set up: (continued)

from each other. In addition, the teeth of the chippers should be placed within the gullet area of the outside blades. Finally, add the second outside blade, then the collar from the machine and properly tighten the locknut according to the machine manufacturers' specifications. Make sure to put safety devices and guards back in place. Double check that all components are tight. It is advisable to line up the teeth on both outside blades in order to take an accurate measurement. If using a table saw, replace the table insert with the proper dado insert.

Warning: Never attempt any cutting without the table insert in place. The work piece must be properly supported near the cutting area. Perform a test cut to check the set-up.

Warning: Both outside dado blades must be used. Never attempt to use the chippers without both outside blades in place.

MAXIMUM R.P.M. TABLE

Dado Set Diameter	Maximum R.P.M.
6"	9,500
8"	7,000
10"	5,700
12"	4,800

"Thank you for thinking DIMAR"

Safety checklist:

- Unplug machine before changing or adjusting blades or other components.
- Ensure machine safety guards are in place and functioning correctly.
- Wear proper eye, ear and face protection.
- Do not exceed maximum R.P.M. as listed (see table below).
- Use all necessary factory flanges, lock nut, etc.
- Use both outside dado blades.
- Wide or deep cuts should be performed in multiple passes.
- Keep hands and loose clothing away from cutting area.
- Use adequate ventilation.

Maintenance

To maintain a safe and high quality cut, regular sharpening is required. This should be performed by a qualified sharpening service only. Also, all of the components of the dado set should be re-ground at the same time to ensure that the outside diameter (O.D) matches. For better performance, clean the dado blades and chippers after each use. For safe keeping, place the dado set back in the dado case. Stack the dado blades with the hubs touching. Do not let the teeth come in contact.

Notice:

This guide is intended for general information only and should not be considered a substitute for your power tools' owner's manual, nor a guide for safe woodworking practices. Please consult other appropriate reference materials.