

## Dado Stack Set-up and Use Instructions

Outside saws are always used on the outside with chippers between them.

The high-point of each outside saw's carbide tips should be on the outside of the dado stack.

Do not use the chippers without both outside saws.

Verify the material thickness that will be placed in the dado groove prior to assembling the dado stack.

Use shims as required to fine-tune the dado groove width.

Clean all dust, chips and debris from saws and chippers before assembling.

Make sure both saws and all chippers are installed in the proper cutting direction.

Tighten the stack set firmly on the sawing machine's arbor shaft.

For deep dado cuts or when using a low-power machine, consider making at least two (2) passes over the dado set making each pass deeper.

Use a steady feedrate with material fully supported and guided in the direction of the dado groove.

Apply adequate downward pressure on material to keep it in contact with saw table at all times.

### CAUTION:

Rotating tools are dangerous - use at your own risk.

Follow OSHA guidelines and normal safety precautions.

Wear eye protection and keep hands away from rotating cutting tools.

Dado Width	Outside Saws	Number Chippers Used		
		1/8" Chipper	3/32" Chipper	1/16" Chipper
1/4"	2			
5/16"	2			1
11/32"	2		1	
3/8"	2	1		
13/32"	2		1	1
7/16"	2	1		1
15/32"	2	1	1	
1/2"	2	2		
17/32"	2	1	1	1
9/16"	2	2		1
19/32"	2	2	1	
5/8"	2	3		
21/32"	2	2	1	1
11/16"	2	3		1
23/32"	2	3	1	
3/4"	2	4		
25/32"	2	3	1	1
13/16"	2	4		1
27/32"	2	4	1	
29/32"	2	4	1	1



Dado sets typically consist of:

2 pc	Outside Saws
4 pc	1/8" Chipper
1 pc	3/32" Chipper
1 pc	1/16" Chipper
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8 pc	Total

Ridge Carbide Tool  
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