



MODEL H6548 ZERO-CLEARANCE/DADO TABLE SAW INSERT INSTRUCTIONS

WARNINGS

- Disconnect the saw from its power source before fitting or removing the insert.
- Always wear eye protection.
- Be sure the blade is NOT in contact with the insert before switching the saw ON.
- Do not attempt to tilt the arbor while the blade is in the insert! The blade will bind, causing severe damage and possible injury! For beveled cuts, a separate, dedicated insert must be prepared. To do this, preset the angle and then proceed as instructed below.
- The insert must be securely clamped down with a board before plunging the blade up to cut the kerf.
- If you are using blade stabilizers, check their clearance before raising the blade.

INSTALLING AND FITTING YOUR INSERT

- 1) Lower the blade completely.
- 2) Place the insert in the throat opening, back end first, with the starter pocket located over the blade. Initially, the insert should be too long and hit on the front "fitting bumps."
- 3) Using a medium grit sanding block, LIGHTLY sand all four fitting bumps. Also, lightly bevel the bottom edges of the FRONT bumps to ease entry. Sand, test, repeat—to gradually "sneak-up" on a snug, yet easily removable fit. Once you have achieved a tight wedge fit, work on only the front bumps from then on.
- 4) Using a 3/32" hex wrench, adjust the leveling screws until the insert is stable and flush with the tabletop.
- 5) SPLITTER: If the insert is to be used with a splitter, you will need to finish cutting out the pre-routed optional splitter slot, using a saw or router and then rounding the sharp edges with sandpaper.

CUTTING THE BLADE SLOT (KERF)

- 1) Check that the insert is fitted properly and that the blade is clear. Using a stick, reach under the table and rotate the blade manually to check for blade clearance.
- 2) Fully cover the insert with a board, and clamp it to the table saw top at each end.
- 3) Reconnect power to the saw. Switch the saw ON, slowly and cautiously raise blade up to cut through the insert. **WARNING—KEEP HANDS OFF OF TABLE TOP, STAY CLEAR AND WEAR EYE PROTECTION.** Make sure you raise the blade to the maximum height at this time.
- 4) Lower the blade, turn off the saw, and remove the board. Your insert is now ready for use!

IMPORTANT TIPS

- Only use this insert with carbide tipped blades.
- DADO BLADE: Use the same procedures outlined above, but use additional caution due to the excessive material being machined from the insert during the slotting procedure.
- Under certain conditions, an undesirable scraping noise may be generated by your saw blade. Planer type blades, excessive arbor run-out, or blade distortion may be causing intermittent contact with the insert slot. To remedy this, remove the insert and slightly widen the slot using a file or sanding paddle.
- Ideally, a separate insert should be used with each blade, dado stack, or angle setup. This will ensure a true "zero-clearance" effect and give you the maximum benefit from your inserts.

