



MODEL H7777 8" STACK DADO SET INSTRUCTION SHEET

!WARNING

Read and understand your table saw manual, set up your table saw according to the manual, then use your table saw enough to be familiar with it before attempting dado cuts. Making dado cuts is one of the more difficult operations that can be performed on a table saw. The size of the cut increases the chances of kickback. Kickback happens when the workpiece is thrown towards the operator at a high rate of speed. Until you have a clear understanding of kickback and how it occurs, **DO NOT** use this dado set! We strongly recommend that you read books, trade magazines, or get formal training before using this dado set. Failure to follow these warnings could result in serious personal injury. Regardless of the content in this instruction sheet, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Inventory (Figure 1)

	Qty
Right Outside Blade	1
Left Outside Blade.....	1
1/8" Chip Cutters	4
3/32" Chip Cutter.....	1
1/16" Chip Cutter.....	1
0.005" Shims	2
0.010" Shims	2
0.015" Shims	2
0.020" Shims	2

Introduction

The outside blades of this 30 tooth dado set feature five sets of teeth. Each of these sets consist of five angled teeth and a flat tooth. The angled teeth shown in **Figure 2** cut the wood fibers cleanly to prevent splintering and chipping at the edge of the dado and the flat teeth cut the flat bottom of the dado. Cutting a dado requires at least a 1½ HP table saw. Do not use this set in a portable table saw, a miter saw, or a circular saw.

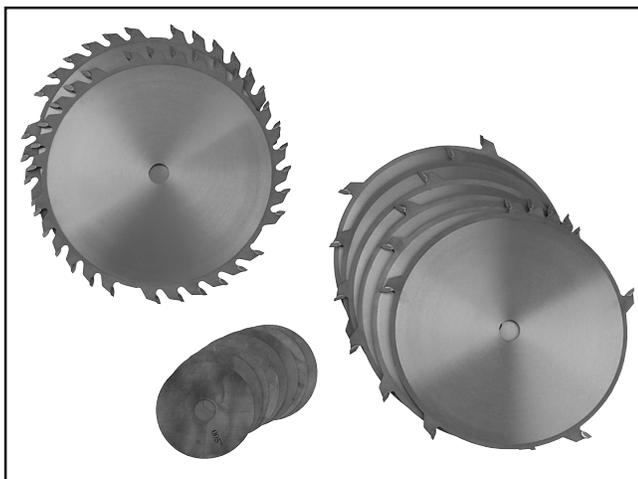


Figure 1. Inventory.

Set-Up

To install dado blades, do these steps:

1. UNPLUG THE TABLE SAW!
2. Remove the blade guard and anti-kickback devices, the table insert, the arbor nut and arbor flange, and the table saw blade.

- Slide the right outside blade over the arbor with the teeth facing toward the operator and the point of the angled teeth on the outside of the dado stack as shown in **Figure 2**.

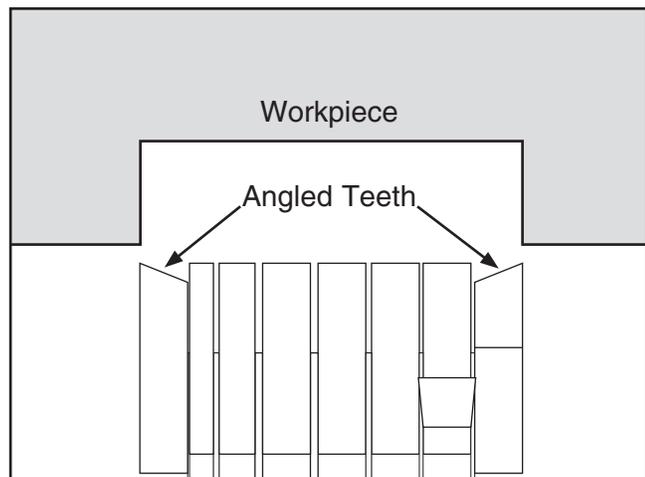


Figure 2. Correct position for outside blades.

- Install the chippers and the left outside blade to reach the desired width.
 - Make sure the teeth of the chippers align with the gullets of the outside blades and all of the teeth are offset (see **Figure 3**).
 - Use the shims and the $\frac{3}{32}$ " chipper to make odd sized dadoes; for example, a dado for plywood.
 - Measure the stack to check the width.

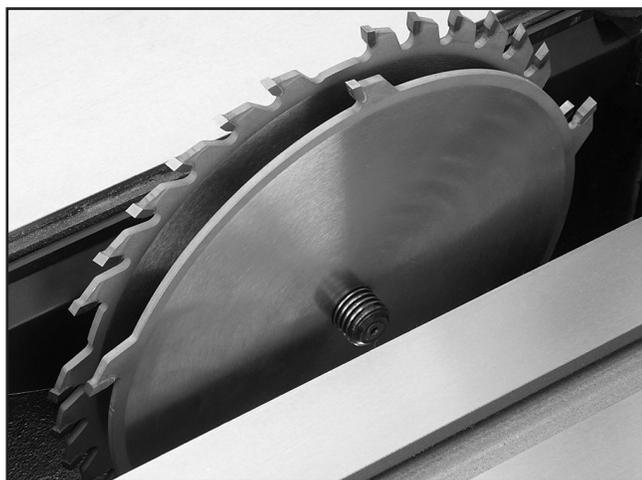


Figure 3. Chipper teeth offset from the outside blade teeth.

- Secure the dado blades with the arbor nut and flange, then install the dado insert as shown in **Figure 4**. Use a narrower dado stack and make multiple cuts if the arbor nut and flange will not fully thread onto the arbor.

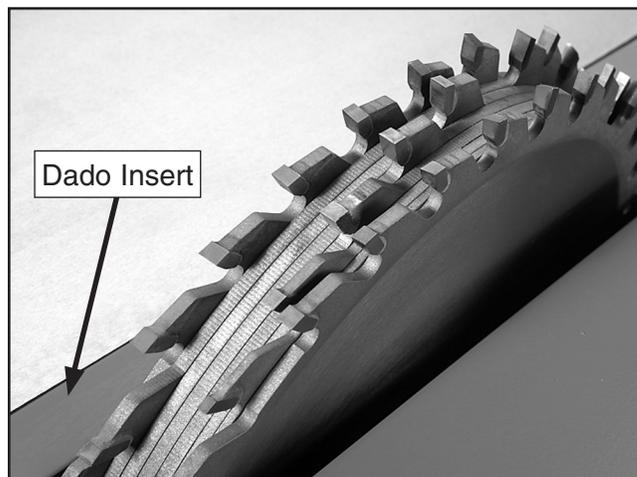


Figure 4. Dado blades installed in table saw.

!WARNING

DO NOT use the dado stack if the arbor nut and arbor flange will not fully thread onto the arbor. The arbor nut may come loose, allowing the dado blades to fly out of the table saw, causing serious injury or death.

- Set the dado blades to the desired height, make a test run in scrap wood, and then measure the finished dado to make sure it is the correct depth and width.
- If the width is incorrect, repeat **Steps 2–6**, adding or removing shims between the chipper blades to reach the desired width.

!WARNING

Never reach behind the dado or place hands in the path of the dado while the saw is running. If kickback occurs while reaching over the blade, hands or arms will be pulled into the spinning saw blade causing serious injury.

- When finished with dado operations, install the table saw blade, then re-install the blade guard, anti-kickback devices, and the standard table insert.

If you need additional help with this dado set, feel free to call our Technical Support at (570) 546-9663.