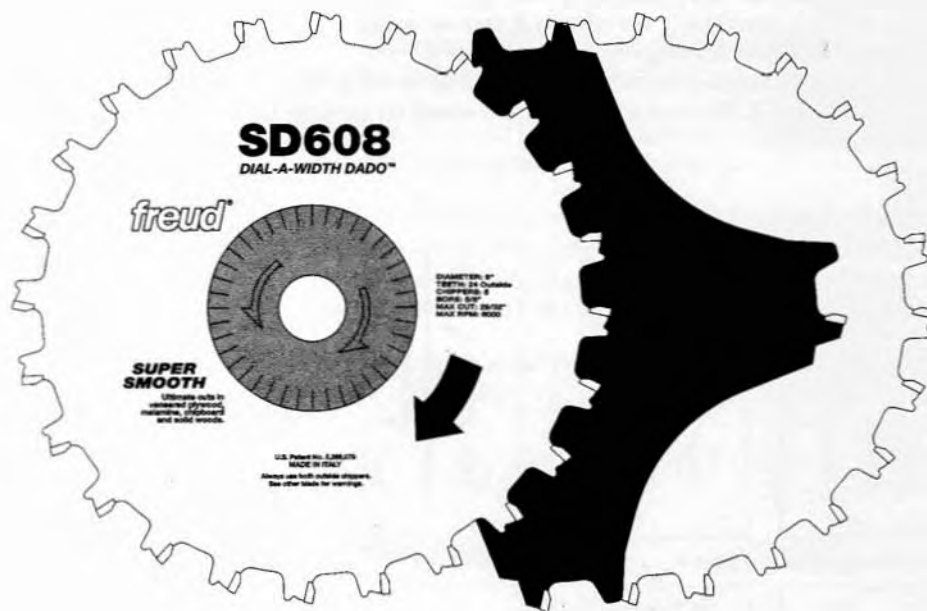


freud®

Dial-a-Width Dado



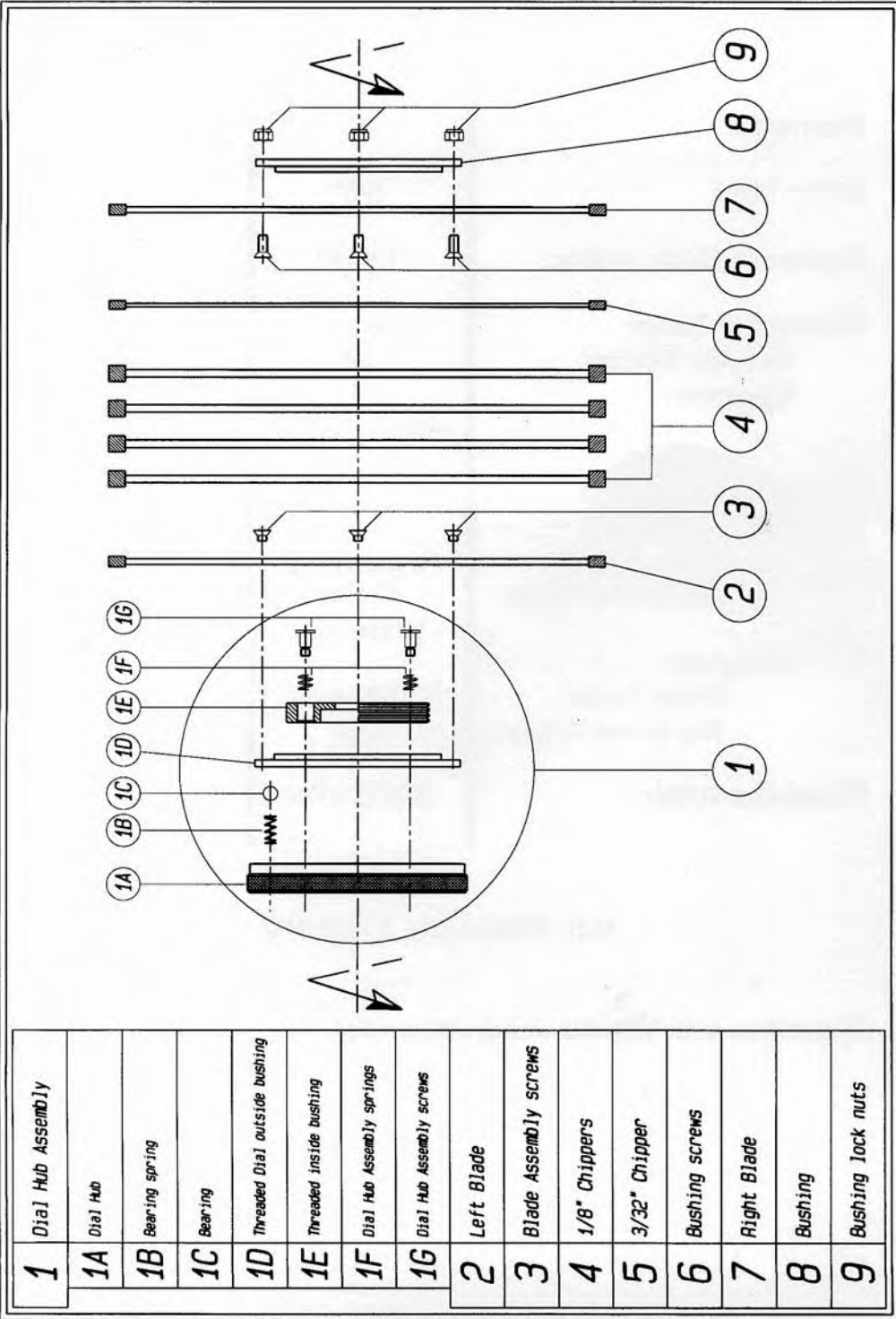
SD606 & SD608

Technical Specifications

	SD606	SD608
Diameter:	6"	8"
Arbor Size:	5/8"	5/8"
Maximum Dado Width:	13/16"	13/16"
Number of Teeth:		
Outside Blades:	24	24
Chippers:	4	4
Geometry of Teeth:		
Outside Blade:		
Hook Angle:	Negative 12°	Negative 12°
Top Bevel Angle:	12 Flat 12 Beveled	12 Flat 12 Beveled
Chippers:		
Hook Angle:	Negative 12°	Negative 12°
Top Bevel Angle:	Flat	Flat
Maximum RPM:	6,000 RPM	6,000 RPM

U.S. Patent No. 5 368 079

All specifications are subject to change without notice



1	Dial Hub Assembly
1A	Dial Hub
1B	Bearing spring
1C	Bearing
1D	Threaded Dial outside bushing
1E	Threaded inside bushing
1F	Dial Hub Assembly springs
1G	Dial Hub Assembly screws
2	Left Blade
3	Blade Assembly screws
4	1/8" Chippers
5	3/32" Chipper
6	Bushing screws
7	Right Blade
8	Bushing
9	Bushing lock nuts

SAVE THESE INSTRUCTIONS

1. Work Safely: Always use the guards and safety recommendations from the machine's manufacturer, wear safety glasses and appropriate hearing protection. Disconnect power before installing, or adjusting the dado. Keep hands a safe distance away from the dado while it is turning. Use caution in handling the dado during installation. Always dress appropriately.

2. Use Both Outside Blades: Never use the chippers by themselves, or with only one outside blade. Not using both outside blades can cause personal injury, or damage to the tool.

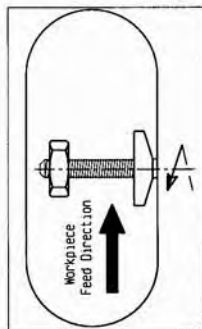
3. Clean Well: Be sure all components are clean and free from dust and chips. Chips between components may affect performance and damage tools.

4. Multiple Passes: Wide dados remove large amounts of material in a single pass at full depth. Multiple passes starting at a lower depth of cut may be required for proper control and safety.

5. Changing the Arbor Orientation: To change arbor from right to left, See **Figure 1**. Turn blade **2** with dial hub assembly **1** face down. Remove Blade assembly screws **3**. Remove dial hub assembly **1** from blade **2** and set aside.

Do not remove Dial Hub Assembly screws 1G !!

Refer to **Figure 2**. Remove bushing screws **6** and bushing lock nuts **9** from bushing **8** on outside right blade **7**. Remove bushing **8** and install on outside left blade **2** as shown in **Figure 4**.



Right-hand side arbor

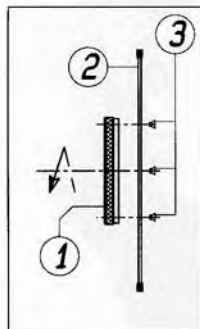


Figure 1

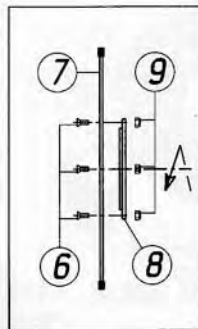
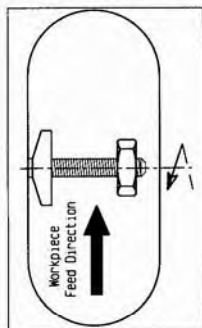


Figure 2



Left-hand side arbor

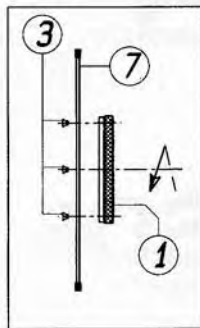


Figure 3

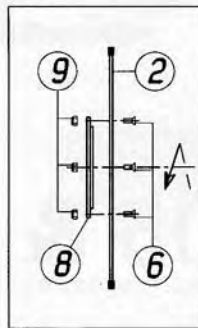


Figure 4

Install Dial Hub Assembly **1** on outside right blade **7** as shown in **Figure 3**. Using blade assembly screws **3**. Be sure that all screws and nuts are securely tightened before reinstalling the blades. Read and follow blade directions for proper blade rotation.

6. Setup: Use the chart on the next page to select the components needed for width of dado. After cleaning, place the first outside blade on the arbor, being sure rotation is correct. If chippers are being used, place them on next with the teeth of the chippers in the gullet of the outside blade. If more than one chipper is used, rotate every other chipper 45 degrees.

Before installing outside red dial plate, rotate dial, either clockwise or counter-clockwise (Figure 5), until screw mechanism is flush with blade body (Figure 6). (Caution: never unscrew hub past being flat with blade body.) Install red dial outside blade being sure that the teeth of the last chipper are in the gullet of the outside blade. Refer to the chart next page to determine the amount of "clicks" necessary to adjust cutting width to nominal size.

Figure 5

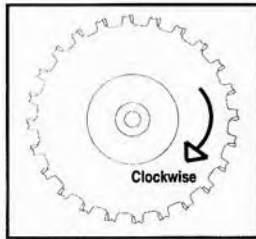
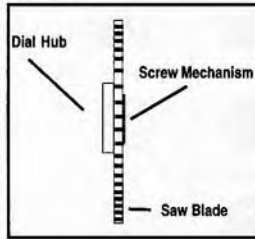


Figure 6



7. Adjusting Fit: After installing dado and replacing the appropriate safety guards, make a test cut in a scrap piece of wood. **If fit is too tight;** disconnect power, loosen the arbor nut and determine the amount of correction needed, turn dial counterclockwise the appropriate number of clicks to achieve desired cut width. Retighten arbor nut, connect power and make a test cut. Repeat process if necessary.

If fit is too loose; disconnect power, loosen the arbor nut, determine the amount of correction needed, turn dial clockwise the appropriate number of clicks or stop between clicks to achieve desired cut width. Retighten arbor nut, connect power and make a test cut. Repeat process if necessary.

8. Dial Hub Assembly Direction: Dial hub assembly **1A** should never be taken apart unless mechanism becomes hard to turn due to abnormal saw dust build up.

To open assembly proceed as follows: Place dial hub assembly **1A** mounted on saw blade face down (Figure 7). Remove dial assembly screws **1G** and dial assembly spring **1F**. **Caution: Screws 1G are spring loaded.** Lift blade with dial hub assembly **1** from dial hub **1A** and remove bearing spring **1B** and bearing **1C** (Figure 8). **Caution: Bearing 1C is spring loaded.**

To re-assemble: Carefully clean all surfaces and threads. Place dial hub **1A** face down on a flat surface (Figure 9). Insert bearing spring **1B** into appropriate hole in dial hub **1A**. Carefully place bearing **1C** on spring **1B**. Screw threaded inside bushing **1E** into threaded outside bushing **1D** until the outside surfaces are flush (Figure 9). Carefully place outside blade with threaded inside **1E** and outside **1D** bushings mounted, on dial hub and aligning the two holes in **1E** with the respective ones on dial hub **1A**. Insert dial hub assembly springs **1F** and screws **1G** into holes of threaded inside bushings **1E** and while applying uniform pressure on blade to compress bearing spring **1B**, tighten screws **1G**.

Figure 7

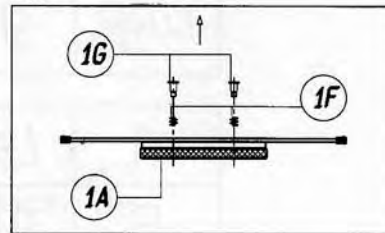


Figure 9

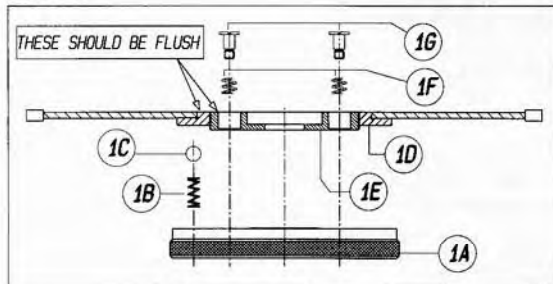
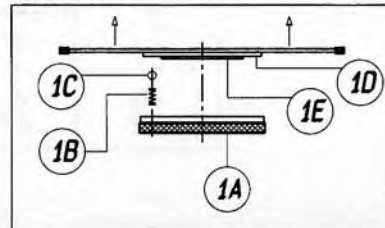


Figure 8



Obtainable fit	1/4"	5/16"	3/8"	7/16"	1/2"	9/16"	5/8"	11/16"	3/4"	13/16"
A	●	●	●	●	●	●	●	●	●	●
B	●	●	●	●	●	●	●	●	●	●
C			●		●		●		●	
D				●	●	●	●	●	●	●
D						●	●	●	●	●
D								●	●	●
D										●

Clicks	9	25	16	22	16	22	16	22	16	22
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A	<i>Left Outside Blade</i>
B	<i>Right Outside Blade</i>
C	<i>3/32" Chipper</i>
D	<i>1/8" Chippers</i>

With these setups, size can be increased or decreased 0.028" without adding or removing chippers.

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