

# Dado Chipper Set-Up & Configuration Guide

These charts explain how to set up your dado cutters to achieve your desired width of cut. Complete set-up instructions, safety information and technical specifications are contained in the manual that comes in the dado set.

| Symbol Key |              |
|------------|--------------|
| ⊗          | Outer Blades |
| ◆          | Chipper      |
| ◊          | Chipper      |
| ○          | Shim         |
| ●          | Spacer       |

For ultimate precision and cut quality, this unique stacked dado system allows for quick and easy adjustments without the use of shims—giving flawless flat bottom cuts in hardwoods, softwoods, veneered plywoods and laminates. This chart is applicable for the SD606 and the SD608 Dial-A-Width dado sets.

## Set-Up For SD600 Series Dial-A-Width Dado Sets - Cuts Dadoes From 7/32" to 29/32"

| Cut Width           | 7/32" | 1/4" | 9/32" | 5/16" | 11/32" | 3/8" | 13/32" | 7/16" | 15/32" | 1/2" | 17/32" | 9/16" | 19/32" | 5/8" | 21/32" | 11/16" | 23/32" | 3/4" | 25/32" | 13/16" | 27/32" | 7/8" | 29/32" |
|---------------------|-------|------|-------|-------|--------|------|--------|-------|--------|------|--------|-------|--------|------|--------|--------|--------|------|--------|--------|--------|------|--------|
| Left Outside Blade  | ⊗     | ⊗    | ⊗     | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      |
| Right Outside Blade | ⊗     | ⊗    | ⊗     | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      |
| 3/32" Chipper       | —     | —    | —     | —     | ◆      | ◆    | —      | —     | ◆      | ◆    | —      | —     | ◆      | ◆    | —      | —      | ◆      | ◆    | —      | —      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | —     | —    | —     | —     | —      | —    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | —     | —    | —     | —     | —      | —    | —      | —     | —      | —    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | —     | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | —     | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | ◆      | ◆      | ◆      | ◆    | ◆      |
| *Number of Clicks   | 1     | 9    | 16    | 25    | 8      | 16   | 15     | 22    | 8      | 16   | 15     | 22    | 8      | 16   | 15     | 22     | 8      | 16   | 15     | 22     | 8      | 15   | 22     |

\* The clicks are from zero on a "zeroed-out" dial. To learn how to zero-out the SD600 series dial refer to the manual that is included with the SD600 series dado sets. Always check the Table Saw manual or consult the manufacturer for the maximum allowable dado width.

The SD500 Super Dado series are available in 6"(SD506), 8"(SD508), 10"(SD510) and 12"(SD512). This series gives flawless flat bottom grooves with virtually splinter-free cuts in hardwoods, softwoods, veneered plywoods and laminates. This chart is applicable for the SD506, SD508, SD510 and SD512 dado sets.

## Set-Up For SD500 Series Dado Sets - Cuts Dadoes From 1/4" to 29/32"

| Cut Width           | 7/32" | 1/4" | 9/32" | 5/16" | 11/32" | 3/8" | 13/32" | 7/16" | 15/32" | 1/2" | 17/32" | 9/16" | 19/32" | 5/8" | 21/32" | 11/16" | 23/32" | 3/4" | 25/32" | 13/16" | 27/32" | 7/8" | 29/32" |
|---------------------|-------|------|-------|-------|--------|------|--------|-------|--------|------|--------|-------|--------|------|--------|--------|--------|------|--------|--------|--------|------|--------|
| Left Outside Blade  | N/A   | ⊗    | ⊗     | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      |
| Right Outside Blade | N/A   | ⊗    | ⊗     | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      |
| 1/16" Chipper       | N/A   | —    | —     | ◆     | —      | —    | ◆      | ◆     | —      | —    | ◆      | ◆     | —      | —    | ◆      | ◆      | —      | —    | ◆      | ◆      | —      | —    | ◆      |
| 3/32" Chipper       | N/A   | —    | —     | —     | ◆      | —    | ◆      | —     | ◆      | —    | ◆      | —     | ◆      | —    | ◆      | —      | ◆      | —    | ◆      | —      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | ◆    | —      | ◆     | ◆      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | ◆    | —      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | ◆      | —      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | ◆      | —      | ◆      | ◆    | ◆      |
| 0.020" (0.5mm) Shim | N/A   | —    | ○     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | —      | —      | —      | ○    | —      |
| 0.012" (0.3mm) Shim | N/A   | —    | ○     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | —      | —      | —      | ○    | —      |
| 0.008" (0.2mm) Shim | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | —      | —      | —      | —    | —      |
| 0.004" (0.1mm) Shim | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | —      | —      | —      | —    | —      |

The SD300 series gives superb cuts in softwoods & hardwoods. Available in 6"(SD306) and 8"(SD308) sizes. Cuts; hardwoods, softwoods, chipboard, plywood, & laminates. This chart is applicable for the SD306 and SD308 dado sets.

## Set-Up For SD300 Series Dado Sets - Cuts Dadoes From 1/4" to 7/8"

| Cut Width           | 7/32" | 1/4" | 9/32" | 5/16" | 11/32" | 3/8" | 13/32" | 7/16" | 15/32" | 1/2" | 17/32" | 9/16" | 19/32" | 5/8" | 21/32" | 11/16" | 23/32" | 3/4" | 25/32" | 13/16" | 27/32" | 7/8" | 29/32" |
|---------------------|-------|------|-------|-------|--------|------|--------|-------|--------|------|--------|-------|--------|------|--------|--------|--------|------|--------|--------|--------|------|--------|
| Left Outside Blade  | N/A   | ⊗    | ⊗     | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | N/A    |
| Right Outside Blade | N/A   | ⊗    | ⊗     | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗     | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | ⊗      | ⊗      | ⊗      | ⊗    | N/A    |
| 1/16" Chipper       | N/A   | —    | —     | ◆     | ◆      | —    | —      | ◆     | ◆      | —    | —      | ◆     | ◆      | —    | —      | ◆      | ◆      | —    | —      | ◆      | ◆      | ◆    | N/A    |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | N/A    |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | N/A    |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | N/A    |
| 1/8" Chipper        | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | ◆      | ◆      | ◆      | ◆    | N/A    |
| 0.020" (0.5mm) Shim | N/A   | —    | ○     | —     | ○      | —    | ○      | —     | ○      | —    | ○      | —     | ○      | —    | ○      | —      | ○      | —    | ○      | —      | ○      | ○    | N/A    |
| 0.012" (0.3mm) Shim | N/A   | —    | ○     | —     | ○      | —    | ○      | —     | ○      | —    | ○      | —     | ○      | —    | ○      | —      | ○      | —    | ○      | —      | ○      | ○    | N/A    |
| 0.008" (0.2mm) Shim | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | —      | —      | —      | ○    | N/A    |
| 0.004" (0.1mm) Shim | N/A   | —    | —     | —     | —      | —    | —      | —     | —      | —    | —      | —     | —      | —    | —      | —      | —      | —    | —      | —      | —      | ○    | N/A    |

# (Continued) Dado Chipper Set-Up & Configuration Guide

The SD200 series gives great performance at a great price. Available in 6"(SD206) and 8"(SD208). Cuts; hardwoods, softwoods, chipboard, plywood, & laminates. This chart is applicable for both the SD206, & SD208 dado sets.

| Set-Up For SD200 Series Dado Sets - Cuts Dadoes From 1/4" to 7/8" |       |      |       |       |        |      |        |       |        |      |        |       |        |      |        |        |        |      |        |        |        |      |        |
|-------------------------------------------------------------------|-------|------|-------|-------|--------|------|--------|-------|--------|------|--------|-------|--------|------|--------|--------|--------|------|--------|--------|--------|------|--------|
| Cut Width                                                         | 7/32" | 1/4" | 9/32" | 5/16" | 11/32" | 3/8" | 13/32" | 7/16" | 15/32" | 1/2" | 17/32" | 9/16" | 19/32" | 5/8" | 21/32" | 11/16" | 23/32" | 3/4" | 25/32" | 13/16" | 27/32" | 7/8" | 29/32" |
| Left Outside Blade                                                | N/A   | ✱    | ✱     | ✱     | ✱      | ✱    | ✱      | ✱     | ✱      | ✱    | ✱      | ✱     | ✱      | ✱    | ✱      | ✱      | ✱      | ✱    | ✱      | ✱      | ✱      | ✱    | N/A    |
| Right Outside Blade                                               | N/A   | ✱    | ✱     | ✱     | ✱      | ✱    | ✱      | ✱     | ✱      | ✱    | ✱      | ✱     | ✱      | ✱    | ✱      | ✱      | ✱      | ✱    | ✱      | ✱      | ✱      | ✱    | N/A    |
| 1/8" Chipper                                                      | N/A   | –    | –     | –     | ◆      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | N/A    |
| 1/8" Chipper                                                      | N/A   | –    | –     | –     | –      | –    | –      | –     | –      | ◆    | ◆      | ◆     | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | N/A    |
| 1/8" Chipper                                                      | N/A   | –    | –     | –     | –      | –    | –      | –     | –      | –    | –      | –     | –      | ◆    | ◆      | ◆      | ◆      | ◆    | ◆      | ◆      | ◆      | ◆    | N/A    |
| 1/16" Spacer                                                      | N/A   | –    | –     | ⊙     | ⊙      | –    | –      | ⊙     | ⊙      | –    | –      | ⊙     | ⊙      | –    | –      | ⊙      | ⊙      | ⊙    | ⊙      | ⊙      | ⊙      | ⊙    | N/A    |
| 0.020" (0.5mm) Shim                                               | N/A   | –    | ○     | –     | ○      | –    | ○      | –     | ○      | –    | ○      | –     | ○      | –    | ○      | –      | ○      | –    | ○      | –      | ○      | ○    | N/A    |
| 0.012" (0.3mm) Shim                                               | N/A   | –    | ○     | –     | ○      | –    | ○      | –     | ○      | –    | ○      | –     | ○      | –    | ○      | –      | ○      | –    | ○      | –      | ○      | ○    | N/A    |
| 0.008" (0.2mm) Shim                                               | N/A   | –    | –     | –     | –      | –    | –      | –     | –      | –    | –      | –     | –      | –    | –      | –      | –      | –    | –      | –      | –      | ○    | N/A    |
| 0.004" (0.1mm) Shim                                               | N/A   | –    | –     | –     | –      | –    | –      | –     | –      | –    | –      | –     | –      | –    | –      | –      | –      | –    | –      | –      | –      | ⊙    | N/A    |

## Dado Replacement Parts & Shim Sets

Use Dado Sets components only with the dado set for which they are designed. Never use chippers without both outside blades. SS100 will work with any stacked dado set on table saws or radial arm saws with a 5/8" arbor. SS200 will work with any stacked dado on table saws or radial arm saws with a 1" arbor.

Freud dado sets are built to last through many years of sharpening and use. However, accidents like dropping a chipper do happen and Freud offers a full range of replacement parts. All outside blades and chippers are made to the same exacting standards of quality as the original set. For wider cuts Freud's Precision Shim Set and additional chippers are available.

| Precision Shim Sets<br>Outside Number of Each Thickness |       |         |      |      |      |      |
|---------------------------------------------------------|-------|---------|------|------|------|------|
| Item                                                    | Arbor | Dia.    | .004 | .008 | .012 | .020 |
| SS100                                                   | 5/8"  | 3-5/32" | 4    | 2    | 2    | 2    |
| SS200                                                   | 1"    | 3-5/32" | 4    | 2    | 2    | 2    |

| Chippers  |       |      |       |       |           |
|-----------|-------|------|-------|-------|-----------|
| Item      | For   | Dia. | Teeth | Arbor | Thickness |
| SD206C16  | SD206 | 6"   | 2     | 5/8"  | 1/16"     |
| SD206C18  | SD206 | 6"   | 2     | 5/8"  | 1/8"      |
| SD208C16  | SD208 | 8"   | 2     | 5/8"  | 1/16"     |
| SD208C18  | SD208 | 8"   | 2     | 5/8"  | 1/8"      |
| SDIC0616  | SD306 | 6"   | 2     | 5/8"  | 1/16"     |
| SDIC0618  | SD306 | 6"   | 2     | 5/8"  | 1/8"      |
| SDIC0816  | SD308 | 8"   | 2     | 5/8"  | 1/16"     |
| SDIC0818  | SD308 | 8"   | 2     | 5/8"  | 1/8"      |
| SDIC1016  | SD310 | 10"  | 2     | 1"    | 1/16"     |
| SDIC1018  | SD310 | 10"  | 2     | 1"    | 1/8"      |
| SDIC1216  | SD312 | 12"  | 2     | 1"    | 1/16"     |
| SDIC1218  | SD312 | 12"  | 2     | 1"    | 1/8"      |
| SD506C16  | SD506 | 6"   | 4     | 5/8"  | 1/16"     |
| SD506C332 | SD506 | 6"   | 4     | 5/8"  | 3/32"     |
| SD506C18  | SD506 | 6"   | 4     | 5/8"  | 1/8"      |
| SD508C16  | SD508 | 8"   | 4     | 5/8"  | 1/16"     |
| SD508C332 | SD508 | 8"   | 4     | 5/8"  | 3/32"     |
| SD508C18  | SD508 | 8"   | 4     | 5/8"  | 1/8"      |
| SD510C16  | SD510 | 10"  | 4     | 1"    | 1/16"     |
| SD510C332 | SD510 | 10"  | 4     | 1"    | 3/32"     |
| SD510C18  | SD510 | 10"  | 4     | 1"    | 1/8"      |
| SD512C16  | SD512 | 12"  | 4     | 1"    | 1/16"     |
| SD512C332 | SD512 | 12"  | 4     | 1"    | 3/32"     |
| SD512C18  | SD512 | 12"  | 4     | 1"    | 1/8"      |
| SD606C18  | SD606 | 6"   | 4     | 5/8"  | 1/8"      |
| SD606C332 | SD606 | 8"   | 4     | 5/8"  | 3/32"     |
| SD608C18  | SD608 | 8"   | 4     | 5/8"  | 1/8"      |
| SD608C332 | SD608 | 8"   | 4     | 5/8"  | 3/32"     |

| Replacement Parts For SD606 & SD608 Series |                                       |
|--------------------------------------------|---------------------------------------|
| SD600SP                                    | Spring hub assembly brearing & screws |
| SD600BB                                    | Ball bearing for hub assembly         |
| SD600HUB                                   | Dial hub                              |
| SD600FLG                                   | Flange for blade assembly             |
| SD600BTI                                   | Threaded insert for flange            |
| SD600ISC1                                  | Screws for threaded insert            |
| SD600FSC                                   | Screws for flange                     |

| Outside Blades |       |      |       |       |             |
|----------------|-------|------|-------|-------|-------------|
| Item           | For   | Dia. | Teeth | Arbor | Orientation |
| SD206OLH       | SD206 | 6"   | 10    | 5/8"  | Left Side   |
| SD206ORH       | SD206 | 6"   | 10    | 5/8"  | Right Side  |
| SD208OLH       | SD208 | 8"   | 12    | 5/8"  | Left Side   |
| SD208ORH       | SD208 | 8"   | 12    | 5/8"  | Right Side  |
| SDOS06LH       | SD306 | 6"   | 24    | 5/8"  | Left Side   |
| SDOS06RH       | SD306 | 6"   | 24    | 5/8"  | Right Side  |
| SDOS08LH       | SD308 | 8"   | 24    | 5/8"  | Left Side   |
| SDOS08RH       | SD308 | 8"   | 24    | 5/8"  | Right Side  |
| SDOS10LH       | SD310 | 10"  | 36    | 1"    | Left Side   |
| SDOS10RH       | SD310 | 10"  | 36    | 1"    | Right Side  |
| SDOS12LH       | SD312 | 12"  | 36    | 1"    | Left Side   |
| SDOS12RH       | SD312 | 12"  | 36    | 1"    | Right Side  |
| SD506OLH       | SD506 | 6"   | 24    | 5/8"  | Left Side   |
| SD506ORH       | SD506 | 6"   | 24    | 5/8"  | Right Side  |
| SD508OLH       | SD508 | 8"   | 24    | 5/8"  | Left Side   |
| SD508ORH       | SD508 | 8"   | 24    | 5/8"  | Right Side  |
| SD510OLH       | SD510 | 10"  | 32    | 1"    | Left Side   |
| SD510ORH       | SD510 | 10"  | 32    | 1"    | Right Side  |
| SD512OLH       | SD512 | 12"  | 36    | 1"    | Left Side   |
| SD512ORH       | SD512 | 12"  | 36    | 1"    | Right Side  |
| SD606OLH       | SD606 | 6"   | 24    | 5/8"  | Left Side   |
| SD606ORH       | SD606 | 6"   | 24    | 5/8"  | Right Side  |
| SD608OLH       | SD608 | 8"   | 24    | 5/8"  | Left Side   |
| SD608ORH       | SD608 | 8"   | 24    | 5/8"  | Righth Side |