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Owner's Manual
Manuel du propriétaire
Manual del propietario

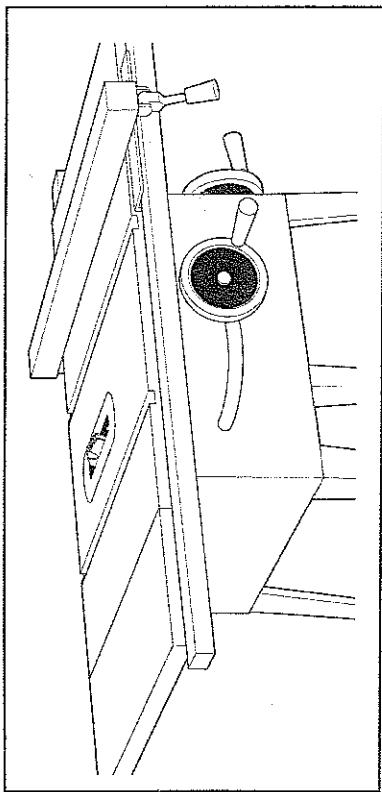
CRAFTSMAN[®]

Stacked Dado Set

Jeu de lames à rainures empilables

Juego de ranuradoras apiladas

Models/Modèles/Modelos: 932175, 932176



▲ WARNING:

Before operating product, read this manual and follow all its Safety and Operating Instructions.

- Safety Instructions
- Parts List
- Installation
- Operation
- Français, p. 9
- Español, p. 16

▲ AVERTISSEMENT:

Avant de vous servir de ce produit, lisez ce manuel et suivez toutes ses consignes de sécurité et les instructions de fonctionnement.

▲ ADVERTENCIA:

Antes de utilizar este producto, lea este manual y acate todas las instrucciones sobre seguridad y uso.

Sears, Roebuck and Co., Hoffman Estates IL 60179 U.S.A.

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08/06

Table of Contents

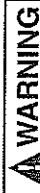
Important Safety Information	2, 3
Parts List	4
Installation	5
Operation	5-7
Common Joint Chart	8

Introduction

These dado sets are high-grade tools, carefully designed and made to fill exacting requirements. Like all other high-grade tools, they must be used properly to obtain optimum results. Reading and understanding these safety and operational instructions before using these dado sets will greatly reduce the

potential of accidents causing personal injury and/or damage to the cutting tool. REFER TO YOUR SAW OWNER'S MANUAL FOR CORRECT SAFETY AND OPERATING INSTRUCTIONS. DO NOT USE THESE DADO SETS ON HOME-MADE OR INDIVIDUALLY FABRICATED SAWS OF ANY KIND.

Safety Instructions for Dado Sets



WARNING To reduce the risk of injury, the user must read, understand, and obey the dado blade instructions and tool manual. Wear eye protection and a dust mask. Mount chippers between the outside blades with tips inside the gullet of the outside blades, and with the teeth pointing in the direction of the operator. Tighten the blade bolt as instructed. Do not through cut material with a dado blade. Not for cutting metal or masonry. Carbide (on some models) is a very hard but brittle material. Sharp blows or cutting through nails can cause tips to break off. Before each use, inspect tips for damage. Do not use if the blade has been dropped or damaged.

-- SAVE THESE INSTRUCTIONS --

Read and understand these instructions and the table saw manual for the use of this dado blade with your table or radial arm saw. Failure to follow all instructions and warnings may result in serious personal injury.

Be sure power cord is unplugged before installing the dado blade on your table saw. Accidental start up may cause serious personal injury.

Use safety equipment such as eye, ear, and dust protection. Particles may be thrown from the workpiece while cutting. Power tools are loud in operation.

Never cut through workpiece with a dado blade. Dado cuts are wide non-through cuts, and cutting through the workpiece may cause the kerf to collapse on the blade set and initiate a kickback of the work.

Use the proper table insert for the width and diameter of the dado blade. Dado blades that are larger than the slot of the table insert may strike and damage the insert.

Depending on your table saw design, use the inner blade washer or the shoulder of the arbor to support the dado set. Dado sets must be firmly mounted to the arbor shaft for maximum stability.

Chippers are always mounted between the two outside blades, and the direction of the chipper teeth must be the same as the direction of the blade teeth. Blade and chipper teeth must point toward the operator side of the table. Mixing the direction of the blade and chipper teeth may cause loss of control.

Do not cut with chippers alone. Chippers used alone may grab wood and cause a kickback.

Always mount chippers so the carbide tips (on some models) on the chipper are placed inside the gullet of the blade.

Chippers have carbide tips, which are wider than its body, therefore must be placed inside the gullet of the blade as this keeps them from rocking, and ensures an accurate setup. Carbide tips can be broken if not placed in the gullets from the pressure of the arbor nut.

Stagger the chippers such that their teeth are not in-line with the next chipper. Even distribution of the chippers contributes to better balance of the set.

Before operation and plugging in the tool, check to be sure that the dado blade is mounted properly, then rotate the dado blade by hand. It must rotate freely and not contact the table, insert, or any other part of the table saw.

We do not recommend cutting material that is warped, wobbly, or otherwise unstable. If this situation is unavoidable, always cut the material with the concave side against the table. Cutting the material with the concave side up or away from the table may cause the warped or wobbly material to roll, causing you to lose control; kickback and serious personal injury may result.

Use the miter gauge or rip fence to guide the workpiece through the dado set. You may use the miter gauge and rip fence together in dado applications, but the rip fence must be parallel to the dado blade. Using guides increases stability and reduces shifting of the workpiece during dadoing or grooving/ploughing.

Use push sticks and other jigs to hold down the workpiece and keep your hands away from the spinning blade. Dado cuts are blind cuts, but the blade still protrudes through the table, and you must be aware of the position of your hands to the spinning blade.

Use feather boards as necessary. In general, use vertically mounted feather boards for cross cut dados. Use vertical and horizontally mounted feather boards for rip cut (grooving or ploughing) dados.

Do not perform bevel dado cuts with a table saw. Dados are meant to cut square channels or rabbets. By tilting the dado, you may increase friction and the tendency of the workpiece to kickback.

Parts List

These dado sets consist of two 1/8" outside cutters, four 1/8" chippers (two 1/8" chippers on model 932175), and one 1/16" chipper. The supplied paper washers will aid in cutting grooves slightly larger than those specified (see Fig. 1).

Proper combinations of cutters will allow you to cut the following groove thicknesses: 1/8", 1/4", 5/16", 3/8", 7/16", 1/2", 9/16" on model 932175, and also 5/8", 11/16", 3/4", 13/16" on model 932176 (see charts, page 7).

Key No.	Description	Quantity
1	1/8" Outside Cutter	2
2	1/8" Chipper	4 (2 on model 932175)
3	1/16" Chipper	1
4	Paper/Cardboard Washers	8

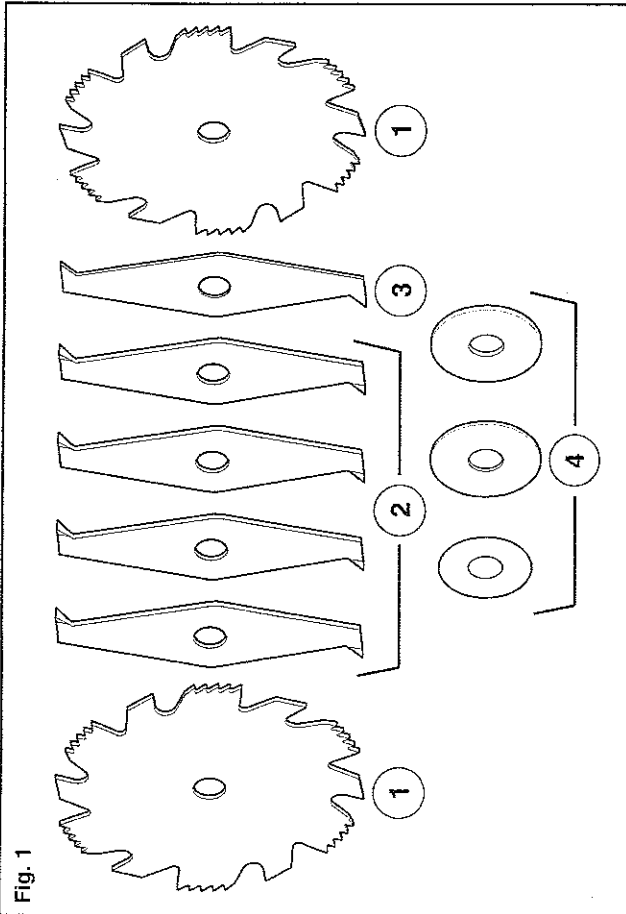


Fig. 1

RADIAL SAWS

1. After making sure that the machine is unplugged and turned "off", position the dado on the machine's arbor against the arbor flange as you would a circular saw blade.

2. Check arrows for correct direction of rotation.

3. Install the outside saw flange and arbor nut, but do not tighten at this time. If the arbor length is not sufficient to accept the outside flange, it may be omitted, placing the arbor nut directly against the dado head. However, do not omit the back flange.

4. To change width of cut, disconnect power and turn the machine "off". Loosen arbor nut, add or remove cutters and paper washers, and tighten arbor nut, repeating hand rotation test for clearance. Note that by slight adjustment of the width, either a tight or loose joint may be made.

5. Tighten the arbor nut.

TABLE SAWS

Install and properly adjust the dado insert, just as with a circular saw blade. Rotate the dado by hand one full turn before plugging into receptacle and turning saw "ON" to be sure it turns freely and does not strike any part of the table, insert, guard, or motor housing.

Installation

Operation

The most common operation is the cutting of grooves, or dados, across the grain of similar members, for example. Also, grooves may be cut lengthwise with the grain.

For 1/8" grooves, use one of the outside cutters, mounting it on the saw arbor in the same manner as a saw blade.

For 1/4" grooves, use both outside cutters.

The cross-cut teeth should be arranged as in Fig. 2. Make sure that the cutters do not move from this position when tightened on the arbor.

For 3/8" grooves, use a 1/8" chipper between the outside cutters (see Fig. 3). Place the chipper so that its cutting edges come in line with the bottom of one of the gullets (spaces between the groups of teeth on the outside cutters). This is necessary because the chippers are swaged thicker near their cutting edges. The swaged portion must enter the gullet before the dado can be tightened on the arbor. The proper arrangement of chippers is important. Failure to arrange them correctly will result in oversized grooves and damaged cutters.

Fig. 2

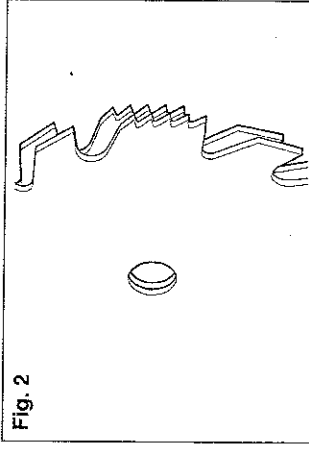
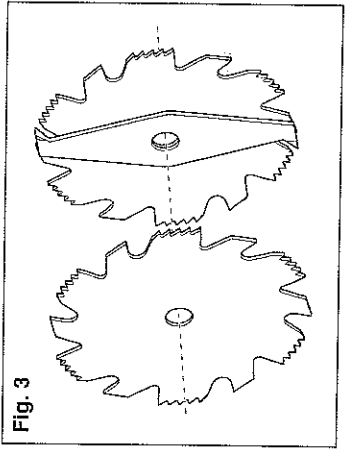


Fig. 3



For 1/2" grooves, arrange the necessary chippers between the outside cutters. Be careful to arrange the chippers so that their swaged portions are in line with the gullets of the outside cutters. When using multiple chippers, place them with the cutting edges evenly distributed around the circumference of the dado. Do not allow the swaged portions of two chippers to come in contact, as this will keep the cutters apart at the center, and prevent proper operation. Fig. 4 shows the proper arrangement of chippers.

Operate the dado in exactly the same manner as a circular saw blade, feeding the work slowly. The wider and deeper the groove, the slower the feed should be. **NOTE:** The non-swaged portions of the chippers of these dado sets are a few thousandths of an inch thinner than their nominal thickness. Thus, the 1/8" chipper is actually a few thousandths of an inch less than 1/8" thick. This allows for adjustment of the width of the groove. Many dado sets have cutters ground slightly oversized, to allow for a glue joint. While this is sometimes suitable, oversize cutters cannot cut a groove that is tight on its mating cutter.

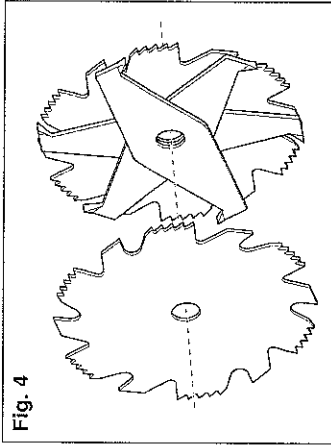


Fig. 4

USE OF PAPER WASHERS

To adjust the width of the groove to the exact size, use a few of the thin paper washers between the outside cutters and chippers, as shown in Fig. 5. In this illustration, "A" is the outside cutter, "B" is the chipper, and "C" is the paper washer. Cut these washers from tough paper, about 2 1/2" in diameter, with a 5/8" center hole. Fig. 5 shows the swaged portion of chipper "B" overlapping the inner face of outside cutter "A", enough to allow for a wide range of adjustment.

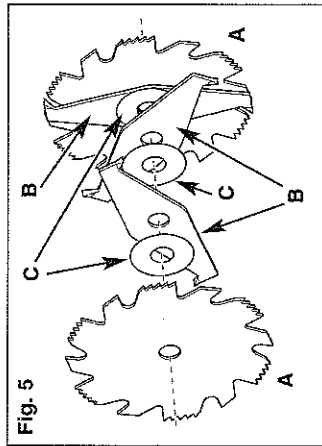


Fig. 5

SHARPENING INSTRUCTIONS

For best performance and safest operation, your dado should be kept sharp. A dull dado requires excessive cutting pressure. Handle dado with care -- avoid bumping against hard objects as teeth are easily damaged. Have dado repaired immediately after any damage. Sharpening a dado set requires considerable skill. For best results, have cutters sharpened by a skilled saw filer.

TENONS

These dado sets are useful for making tenons faster than cutting them with a saw blade. However, care should be taken to see that all stock is of uniform thickness.

The dado should project above the table the width of the tenon, with the rip gauge set to the left of the dado the same distance as the length of the tenon to be cut. For example, if a 3/8" tenon is to be cut on the end of a piece 1-1/8" thick, the dado should project 3/8" above the table, with the rip gauge set to the left of the dado.

Set the miter gauge square, and cut the first groove with the end of the stock against the rip gauge, thus gauging the length of the tenon. After the first cut, move the stock to the left and make as many cuts as necessary to remove the remainder of the stock. Turn the piece over and repeat this cut on the other side of the tenon. It is a good practice to cut a trial piece of the same thickness to see that it fits the mortise precisely before cutting the actual pieces.

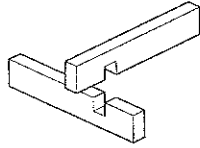
CUTTER BLADE COMBINATIONS TO PRODUCE GROOVES OF VARIOUS WIDTHS, MODEL 932175

DESIRED GROOVE WIDTH	NUMBER OF OUTSIDE BLADES	NUMBER OF 1/8" CHIPPERS	NUMBER OF 1/16" CHIPPERS
1/8"	1	—	—
1/4"	2	—	—
5/16"	2	—	1
3/8"	2	1	—
7/16"	2	1	1
1/2"	2	2	—
9/16"	2	2	1

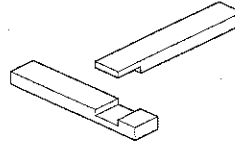
CUTTER BLADE COMBINATIONS TO PRODUCE GROOVES OF VARIOUS WIDTHS, MODEL 932176

DESIRED GROOVE WIDTH	NUMBER OF OUTSIDE BLADES	NUMBER OF 1/8" CHIPPERS	NUMBER OF 1/16" CHIPPERS
1/8"	1	—	—
1/4"	2	—	—
5/16"	2	—	1
3/8"	2	1	—
7/16"	2	1	1
1/2"	2	2	—
9/16"	2	2	1
5/8"	2	3	—
11/16"	2	3	1
3/4"	2	4	—
13/16"	2	4	1

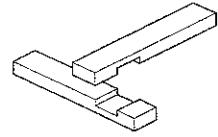
Common Joints



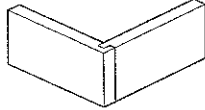
Notch Joint



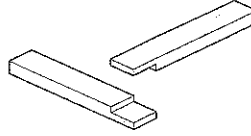
Tee Lap



Cross Lap



Box Corner Joint



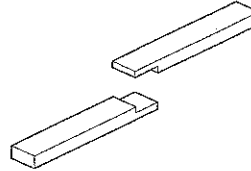
Corner Lap



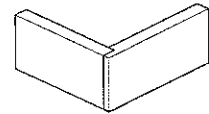
Half Gain Dado



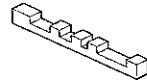
Half Gain Rabbet



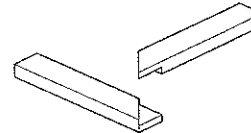
Straight Lap



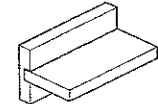
Mitered Box Corner



Dados



Half Lap Miter



Dado Joint