



Model D3614

ZERO CLEARANCE

TABLE SAW INSERT

WARNINGS

- Disconnect the saw from the power source before fitting or removing the insert.
- Always wear eye protection.
- Ensure that the blade is NOT in contact with the insert before turning 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. Pre-set the angle and then proceed as instructed below.
- The insert must be covered by a board that is securely clamped down before plunging the blade up.
- If you are using blade stabilizers, check the clearance before raising the blade.

INSTALLING AND FITTING YOUR INSERT

1. Lower the blade completely.
2. Place the insert in the throat opening so the blade starter pocket is directly over the blade.
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, and repeat to achieve a TIGHT, WEDGE fit.
4. Adjust the four leveling screws until the insert is flush with the table top.
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, then smooth over the sharp edges with fine sandpaper.

CUTTING THE BLADE SLOT (KERF)

1. Check that the insert is fitted properly and that there is clearance between the blade and the insert. (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 the board at each end to the table saw top.
3. Re-connect power to the saw. Turn the saw ON, then slowly and cautiously raise the blade up to cut through the insert. KEEP HANDS OFF OF TABLE TOP, STAY CLEAR AND WEAR EYE PROTECTION. Raise the blade to the maximum height.
4. Lower the blade, turn the saw OFF, and remove the board. Your insert is now ready for use!

IMPORTANT TIPS FOR USE

- Only recommended for use with carbide tipped cutters.
- DADO BLADE: Use same procedures outlined above, but use additional caution due to 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, and/or blade distortion may intermittently cause blade/insert contact. 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 set-up. This will ensure a true "zero-clearance" effect and give you maximum benefit from your inserts.

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