



## MODEL H0627/H0628/H4231 ZERO-CLEARANCE TABLE INSERT INSTRUCTIONS

If you need help with your new insert, call our Tech Support at: (570) 546-9663.

### **WARNING**

- **Disconnect saw from power before fitting or removing table insert!**
- **Always wear eye protection.**
- **Do not tilt the blade while it is in the insert! For beveled cuts, a separate insert must be used with the blade slot (kerf) cut only at that angle.**
- **Insert must be securely clamped down with a board before plunging the blade up through it to cut the kerf.**
- **If using a blade stabilizer, check the clearance before raising the blade.**

### Important Considerations

**CARBIDE BLADES:** Only recommended for use with carbide tipped blades

**DEDICATED INSERTS:** 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 table inserts.

**SPLITTER/RIVING KNIFE:** If this insert is to be used with a splitter or riving knife, you will need to finish cutting out the pre-routed optional splitter slot, using a saw or router. Break any leftover sharp edges with sandpaper.

**FINGER HOLE:** Before fitting the insert, consider drilling a finger hole near the front of the insert to make it easier to remove after installation; otherwise, a snug fitting table insert may be difficult to pull out.

**DADO BLADE:** Use extreme caution when cutting the blade slot (kerf) by moving the blade much slower than otherwise due to the substantial cutting forces from the wide dado blade.

### Installing and Fitting Your Insert

1. Lower the blade completely.
2. Place the insert in the throat opening, back end first, so that the anti-lift lug engages under the rear edge of the table top. Initially, the insert should be too long and hit on the front "fitting bumps."
3. Using a medium grit sanding block, lightly sand all four bumps. While sanding, slightly bevel the bottom edges of the front bumps to ease entry. Once the table insert has a tight wedge fit, only sand the front bumps. Sand, test-fit, and repeat to gradually "sneak-up" on a snug, yet easily removable fit.
4. Adjust the four leveling screws until the insert is stable and is flush with the tabletop.

### Cutting the Blade Slot (Kerf)

1. Check that the insert is fitted properly and that the blade is NOT touching the insert. To check the blade clearance, you can rotate the blade from below using a stick or by moving the belt.
2. Place a scrap board over the top of the table insert and firmly clamp the board to the table at both ends, so the table insert will not lift when you raise the blade into it during the next step.
3. Re-connect the saw to power. **KEEP HANDS OFF OF TABLE TOP, DON'T STAND DIRECTLY BEHIND THE BLADE PATH, AND WEAR EYE PROTECTION.** Switch the saw **ON**, then slowly and cautiously raise the blade up to its maximum height to cut through the insert.
4. Lower the blade completely, turn the saw **OFF**, then remove the clamping board. The insert is now ready for use!

**Note:** Under certain conditions, an undesirable scraping noise may be generated by excessive arbor run-out or blade distortion causing the blade body to intermittently contact the insert slot. To remedy this, remove the insert and slightly widen the slot, using a file or sanding paddle.

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