

freud®

Super Dado



(21669)

(21697)

SD506 & SD508

RTD10000536AA

FREUD LIFETIME CUTTING TOOL GUARANTEE

All Freud tools are engineered and manufactured to the highest standards. Your satisfaction is a dominate consideration. Freud warrants to the original purchaser at retail that each new Freud cutting tool shall be free from defects in material and workmanship, subject to the Guidelines below. Upon verification of failure or malfunction, Freud shall, at its option, within sixty (60) days, repair or replace the tool, subject to the Guidelines below.

GUIDELINES

1. In the event of failure or malfunction, return the product, properly packaged and postage prepaid, to Freud at the address listed below or to an authorized Freud tool service station. See back of price list for authorized repair dealers. You may also contact Freud at (919) 434-3171 or in Canada (416)670-1025 for instructions on returns and technical advice.
2. All implied warranties for Freud's power tools (INCLUDING MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE) are limited to the period of one year from the purchase date. Some states do not allow limitations on how long an implied warranty lasts, so the above limitation may not apply to you.
3. A warranty claim shall be limited to repair or replacement as stated in Freud's Limited Tooling Warranty and Freud's Limited Power Tool Warranty, and in no event shall Freud be liable for any other direct, indirect, incidental or consequential damages, costs or expenses. INCIDENTAL AND CONSEQUENTIAL DAMAGES ARE EXCLUDED UNDER ALL WARRANTIES. Some States do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.
4. Freud warranties give you specific legal rights, and you may also have other rights which vary from State to State or Province to Province.
5. Freud warranties shall not be deemed to have failed their essential purpose while Freud is willing to repair or replace defective products.
6. Freud assumes no liability for defects or damage caused by abuse or misuse of any product or unauthorized service of any product. The product must have been used for its recommended purpose and not modified by sharpening or other changes. Normal wear and tear are not covered under Freud warranties.
7. Any action for breach of warranty must be commenced within one year after the accrual of the cause of action.

To obtain service under Freud warranties, contact an authorized repair station or:

IN UNITED STATES

Freud USA, Inc. (Attn: Customer Services)
218 Feld Avenue
High Point, North Carolina 27264
(919) 434-3171

IN CANADA

Freud Canada (Attn: Customer Services)
7450 Pacific Circle
Mississauga, Ontario L5T 2A3
(416)670-1025

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 and use caution in handling the dado during installation. Always dress appropriately.

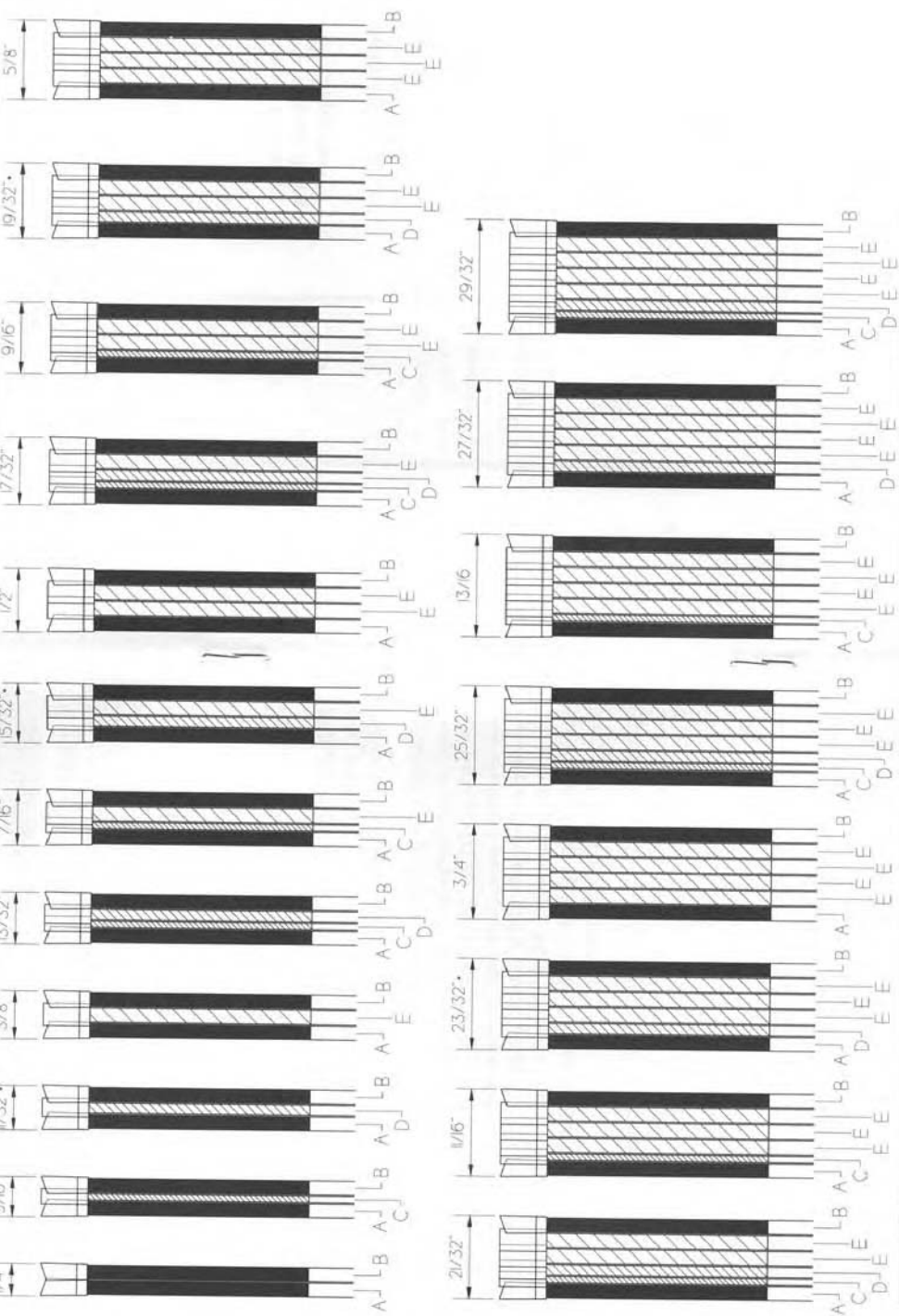
2. Use Both Outside Blades: Never use the chippers by themselves, or with only one outside blade. Not using both outside blades can cause personal injury, or damage to the tool.

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

4. 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. Install other outside blade being sure that the teeth of the last chipper are in the gullet of the outside blade.

5. 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, remove the outside blade, install the appropriate shims, reinstall the outside blade and guards, and make another test cut. If the fit is too loose; disconnect power, remove the outside blade, remove the chippers, install the chippers for the next smaller sized dado install the appropriate shims, reinstall the outside blade and guards, and make another test cut. Repeat this process until desired fit is attained.

6. Multiple Passes: Wide dado's 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.



A=LEFT OUTSIDE BLADE B=RIGHT OUTSIDE BLADE *FOR UNDERSIZED PLYWOOD
 C=1/16" FOUR WING CHIPPER D=3/32" FOUR WING CHIPPER E=1/8" FOUR WING CHIPPER

Technical Specifications

	SD506	SD508
Diameter:	6"	8"
Arbor Size:	5/8"	5/8"
Maximum Dado Width:	29/32"	29/32"
Number of Teeth:		
Outside Blades:	24	24
Chippers:	4	4
Geometry of Teeth:		
Outside Blade:		
Hook Angle:	Negative	Negative
Top Bevel Angle:	12 Flat 12 Beveled	12 Flat 12 Beveled
Chippers:		
Hook Angle:	Negative	Negative
Top Bevel Angle:	Flat	Flat
Shim Sizes:	.004, .008, .012, .020	.004, .008, .012, .020
Maximum RPM:	8,500 RPM	7,000 RPM