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› Vermont American 26741 6-Inch Stacked Steel Dado Set Instruction Manual

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Model: 26741

1. INTRODUCTION

The Vermont American 26741 6-Inch Stacked Steel Dado Set is designed for precision woodworking tasks, enabling the creation of various joints such as rabbets, splines, lap joints, and dadoes in all wood and wood products. This set allows for cutting widths ranging from 1/8-inch to 13/16-inch, adjustable in 1/16-inch increments, including 3/16-inch.

The complete set includes:

- Two (2) 1/8-inch outside saws
- Four (4) 1/8-inch chippers
- One (1) 1/16-inch chipper

This manual provides essential information for the safe and effective setup, operation, and maintenance of your dado set.



Image 1.1: The Vermont American 26741 6-Inch Stacked Steel Dado Set, showing the two outside blades and various chippers.

2. SAFETY INFORMATION

Always prioritize safety when operating power tools and accessories. Failure to follow these safety guidelines may result in serious injury.

- **Read and Understand:** Before installation or operation, read and understand this manual and the instruction manual for your specific saw.
- **Personal Protective Equipment (PPE):** Always wear appropriate eye protection (safety glasses or goggles), hearing protection, and a dust mask. Avoid loose clothing, jewelry, and long hair that could get caught in moving parts.

- **Disconnect Power:** Always disconnect the saw from the power source before installing, removing, or adjusting the dado set.
- **Inspect Blades:** Before each use, inspect the dado blades and chippers for any damage, cracks, or dullness. Do not use damaged blades.
- **Correct Arbor Size:** Ensure your saw's arbor size matches the dado set's 5/8-inch arbor. Improper fit can lead to vibration and unsafe operation.
- **Secure Installation:** Ensure the dado set is securely mounted and the arbor nut is tightened according to your saw manufacturer's instructions.
- **Material Suitability:** This dado set is designed for wood and wood products. Do not use it on metal, plastic, or other materials unless specifically approved.
- **Maintain Clear Work Area:** Keep your work area clean, well-lit, and free of obstructions.
- **Never Force:** Allow the dado set to cut at its own pace. Forcing the cut can lead to kickback or damage to the blades.
- **Use Fences and Guards:** Always use the saw's rip fence, miter gauge, and blade guards as appropriate for the operation.

3. SETUP AND INSTALLATION

Proper installation of the dado set is critical for safe and accurate cuts. Always refer to your saw's manual for specific instructions regarding dado blade installation.

3.1 Determining Cut Width

The Vermont American 26741 dado set can cut widths from 1/8-inch to 13/16-inch. To achieve the desired width, combine the two 1/8-inch outside saws with the appropriate chippers:

- Start with the two 1/8-inch outside saws.
- Add 1/8-inch chippers and the 1/16-inch chipper as needed between the outside saws to reach the desired dado width.
- For example, to cut a 1/2-inch dado, you would typically use the two 1/8-inch outside saws and two 1/8-inch chippers ($1/8 + 1/8 + 1/8 + 1/8 = 1/2$ inch).
- Small paper shims (not included in this set but often used with dado sets) can be used for fine adjustments to achieve a precise fit for your material.

3.2 Installation Steps

1. **Disconnect Power:** Ensure your saw is unplugged from the power source.
2. **Remove Existing Blade:** Carefully remove the standard saw blade and any existing washers or flanges from the arbor.
3. **Install Dado Set:**
 - Place one 1/8-inch outside saw onto the arbor, ensuring the teeth are oriented correctly for cutting (usually pointing towards the front of the saw table).
 - Add the selected chippers, alternating between chippers and the second outside saw, until the desired width is achieved. Ensure all chippers are properly seated and aligned.
 - Place the second 1/8-inch outside saw onto the arbor, again ensuring correct tooth orientation.
4. **Secure with Flange and Nut:** Reinstall the outer flange and arbor nut. Tighten the arbor nut firmly, but do not overtighten.
5. **Install Dado Insert:** Replace your standard throat plate with a dado-specific throat plate or a zero-clearance insert designed for dado blades. This provides proper support for the workpiece and reduces tear-out.

6. **Test Run:** Reconnect power and perform a brief test run to ensure the dado set spins smoothly without wobble or excessive vibration. Disconnect power again before making any adjustments.

4. OPERATING INSTRUCTIONS

This dado set is designed for cutting various joints in wood. Always ensure your saw is set up correctly and all safety precautions are followed.

4.1 General Operation

- **RPM Limit:** The maximum RPM for this dado set is 7000. Ensure your saw's operating speed does not exceed this limit.
- **Workpiece Support:** Always ensure the workpiece is fully supported before, during, and after the cut. Use push sticks or push blocks when cutting small pieces or when your hands are close to the blade.
- **Feed Rate:** Maintain a consistent and controlled feed rate. Do not force the material into the blades. A slower feed rate generally results in a cleaner cut.
- **Depth of Cut:** Adjust the blade height to achieve the desired dado depth. For deeper dados, consider making multiple shallow passes to reduce strain on the saw and improve cut quality.
- **Types of Cuts:** This dado set is suitable for creating:
 - **Dadoes:** Grooves cut across the grain of the wood.
 - **Rabbets:** Grooves cut along the edge or end of a board.
 - **Splines:** Grooves for inserting a separate piece of wood (spline) to join two boards.
 - **Lap Joints:** Joints where two pieces of wood overlap, often requiring a dado cut.

5. MAINTENANCE

Regular maintenance ensures the longevity and performance of your dado set.

- **Cleaning:** After each use, disconnect the saw from power and carefully remove any accumulated pitch or sawdust from the blades and chippers using a suitable blade cleaner and a stiff brush. Avoid abrasive cleaners.
- **Inspection:** Periodically inspect the dado set for dull teeth, bent blades, or any signs of damage. Dull blades can lead to burning, tear-out, and increased kickback risk.
- **Storage:** Store the dado set in its original packaging or a protective case to prevent damage to the teeth and to keep it clean. Store in a dry environment to prevent rust.
- **Sharpening:** When the blades become dull, have them professionally sharpened by a qualified service to maintain optimal performance and safety.

6. TROUBLESHOOTING

If you encounter issues while using your dado set, consider the following common problems and solutions:

Problem	Possible Cause	Solution
Uneven or rough dado cut	Dull blades; incorrect chipper combination; chippers slightly smaller than outside blades; too fast feed rate.	Inspect and sharpen blades; ensure correct chipper arrangement; use paper shims for fine width adjustment; reduce feed rate; make multiple shallow passes.

Problem	Possible Cause	Solution
Excessive tear-out	Dull blades; improper dado insert; too fast feed rate; cutting against grain without support.	Sharpen blades; use a zero-clearance dado insert; reduce feed rate; use a backing board or scoring cut.
Blade wobble or vibration	Improper installation; arbor nut not tightened; bent arbor; damaged blades/chippers.	Ensure dado set is correctly seated and arbor nut is tight; inspect arbor for damage; replace damaged blades/chippers.
Burning on workpiece	Dull blades; too slow feed rate; excessive pitch buildup.	Sharpen blades; increase feed rate slightly; clean blades thoroughly.

7. SPECIFICATIONS

- **Model:** 26741
- **Blade Diameter:** 6 inches
- **Arbor Size:** 5/8-inch round
- **Cut Widths:** 1/8-inch to 13/16-inch (in 1/16-inch increments)
- **Maximum RPM:** 7000
- **Plate Thickness:** 0.107-inch
- **Hook Angle:** 10 degrees
- **Material:** High Speed Steel
- **Compatible Material:** Wood, Wood Products, Alloy Steel
- **Number of Teeth:** 10 (on outside blades)
- **Item Weight:** 16 ounces
- **UPC:** 045325267417

8. WARRANTY AND SUPPORT

This Vermont American 26741 6-Inch Stacked Steel Dado Set is backed by a **Lifetime Limited Manufacturer's Warranty**. This warranty covers defects in material and workmanship under normal use. For specific details regarding warranty claims or product support, please refer to the official Vermont American website or contact their customer service directly.

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