

Dado Chipper Set-Up & Configuration Guide

These charts explain how to set up your dado cutters to achieve your desired width of cut. Complete set-up instructions, safety information and technical specifications are contained in the manual that comes in the dado set.

Symbol Key	
⊗	Outer Blades
◆	Chipper
◊	Chipper
○	Shim
●	Spacer

For ultimate precision and cut quality, this unique stacked dado system allows for quick and easy adjustments without the use of shims—giving flawless flat bottom cuts in hardwoods, softwoods, veneered plywoods and laminates. This chart is applicable for the SD606 and the SD608 Dial-A-Width dado sets.

Set-Up For SD600 Series Dial-A-Width Dado Sets - Cuts Dadoes From 7/32" to 29/32"

Cut Width	7/32"	1/4"	9/32"	5/16"	11/32"	3/8"	13/32"	7/16"	15/32"	1/2"	17/32"	9/16"	19/32"	5/8"	21/32"	11/16"	23/32"	3/4"	25/32"	13/16"	27/32"	7/8"	29/32"
Left Outside Blade	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
Right Outside Blade	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
3/32" Chipper	-	-	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	◆
1/8" Chipper	-	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆
1/8" Chipper	-	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆
1/8" Chipper	-	-	-	-	-	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆
1/8" Chipper	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆
*Number of Clicks	1	9	16	25	8	16	15	22	8	16	15	22	8	16	15	22	8	16	15	22	8	15	22

* The clicks are from zero on a "zeroed-out" dial. To learn how to zero-out the SD600 series dial refer to the manual that is included with the SD600 series dado sets. Always check the Table Saw manual or consult the manufacturer for the maximum allowable dado width.

The SD500 Super Dado series are available in 6"(SD506), 8"(SD508), 10"(SD510) and 12"(SD512). This series gives flawless flat bottom grooves with virtually splinter-free cuts in hardwoods, softwoods, veneered plywoods and laminates. This chart is applicable for the SD506, SD508, SD510 and SD512 dado sets.

Set-Up For SD500 Series Dado Sets - Cuts Dadoes From 1/4" to 29/32"

Cut Width	7/32"	1/4"	9/32"	5/16"	11/32"	3/8"	13/32"	7/16"	15/32"	1/2"	17/32"	9/16"	19/32"	5/8"	21/32"	11/16"	23/32"	3/4"	25/32"	13/16"	27/32"	7/8"	29/32"
Left Outside Blade	N/A	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
Right Outside Blade	N/A	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
1/16" Chipper	N/A	-	-	◆	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	-	-	◆
3/32" Chipper	N/A	-	-	-	◆	-	◆	-	◆	-	◆	-	◆	-	◆	-	◆	-	◆	-	◆	◆	◆
1/8" Chipper	N/A	-	-	-	-	◆	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	◆	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	◆	-	◆	◆	◆	◆
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	◆	-	◆	◆	◆
0.020" (0.5mm) Shim	N/A	-	○	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	○
0.012" (0.3mm) Shim	N/A	-	○	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	○
0.008" (0.2mm) Shim	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
0.004" (0.1mm) Shim	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

The SD300 series gives superb cuts in softwoods & hardwoods. Available in 6"(SD306) and 8"(SD308) sizes. Cuts; hardwoods, softwoods, chipboard, plywood, & laminates. This chart is applicable for the SD306 and SD308 dado sets.

Set-Up For SD300 Series Dado Sets - Cuts Dadoes From 1/4" to 7/8"

Cut Width	7/32"	1/4"	9/32"	5/16"	11/32"	3/8"	13/32"	7/16"	15/32"	1/2"	17/32"	9/16"	19/32"	5/8"	21/32"	11/16"	23/32"	3/4"	25/32"	13/16"	27/32"	7/8"	29/32"	
Left Outside Blade	N/A	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	N/A	
Right Outside Blade	N/A	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	N/A	
1/16" Chipper	N/A	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	-	-	◆	◆	◆	N/A	
1/8" Chipper	N/A	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	N/A
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	N/A
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	N/A
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆	N/A
0.020" (0.5mm) Shim	N/A	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	○	○	N/A
0.012" (0.3mm) Shim	N/A	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	○	○	N/A
0.008" (0.2mm) Shim	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	○	N/A
0.004" (0.1mm) Shim	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	○	N/A



(Continued) Dado Chipper Set-Up & Configuration Guide

The SD200 series gives great performance at a great price. Available in 6"(SD206) and 8"(SD208). Cuts; hardwoods, softwoods, chipboard, plywood, & laminates. This chart is applicable for both the SD206, & SD208 dado sets.

Set-Up For SD200 Series Dado Sets - Cuts Dadoes From 1/4" to 7/8"																								
Cut Width	7/32"	1/4"	9/32"	5/16"	11/32"	3/8"	13/32"	7/16"	15/32"	1/2"	17/32"	9/16"	19/32"	5/8"	21/32"	11/16"	23/32"	3/4"	25/32"	13/16"	27/32"	7/8"	29/32"	
Left Outside Blade	N/A	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	N/A	
Right Outside Blade	N/A	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	N/A	
1/8" Chipper	N/A	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	N/A	
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆	N/A	
1/8" Chipper	N/A	-	-	-	-	-	-	-	-	-	-	-	-	◆	◆	◆	◆	◆	◆	◆	◆	◆	N/A	
1/16" Spacer	N/A	-	-	⊙	⊙	-	-	⊙	⊙	-	-	⊙	⊙	-	-	⊙	⊙	⊙	⊙	⊙	⊙	⊙	N/A	
0.020" (0.5mm) Shim	N/A	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	N/A
0.012" (0.3mm) Shim	N/A	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	-	○	N/A
0.008" (0.2mm) Shim	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	○	N/A
0.004" (0.1mm) Shim	N/A	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	⊙	N/A

Dado Replacement Parts & Shim Sets

Use Dado Sets components only with the dado set for which they are designed. Never use chippers without both outside blades. SS100 will work with any stacked dado set on table saws or radial arm saws with a 5/8" arbor. SS200 will work with any stacked dado on table saws or radial arm saws with a 1" arbor.

Freud dado sets are built to last through many years of sharpening and use. However, accidents like dropping a chipper do happen and Freud offers a full range of replacement parts. All outside blades and chippers are made to the same exacting standards of quality as the original set. For wider cuts Freud's Precision Shim Set and additional chippers are available.

Precision Shim Sets Outside Number of Each Thickness						
Item	Arbor	Dia.	.004	.008	.012	.020
SS100	5/8"	3-5/32"	4	2	2	2
SS200	1"	3-5/32"	4	2	2	2

Chippers						
Item	For	Dia.	Teeth	Arbor	Thickness	
SD206C16	SD206	6"	2	5/8"	1/16"	
SD206C18	SD206	6"	2	5/8"	1/8"	
SD208C16	SD208	8"	2	5/8"	1/16"	
SD208C18	SD208	8"	2	5/8"	1/8"	
SDIC0616	SD306	6"	2	5/8"	1/16"	
SDIC0618	SD306	6"	2	5/8"	1/8"	
SDIC0816	SD308	8"	2	5/8"	1/16"	
SDIC0818	SD308	8"	2	5/8"	1/8"	
SDIC1016	SD310	10"	2	1"	1/16"	
SDIC1018	SD310	10"	2	1"	1/8"	
SDIC1216	SD312	12"	2	1"	1/16"	
SDIC1218	SD312	12"	2	1"	1/8"	
SD506C16	SD506	6"	4	5/8"	1/16"	
SD506C332	SD506	6"	4	5/8"	3/32"	
SD506C18	SD506	6"	4	5/8"	1/8"	
SD508C16	SD508	8"	4	5/8"	1/16"	
SD508C332	SD508	8"	4	5/8"	3/32"	
SD508C18	SD508	8"	4	5/8"	1/8"	
SD510C16	SD510	10"	4	1"	1/16"	
SD510C332	SD510	10"	4	1"	3/32"	
SD510C18	SD510	10"	4	1"	1/8"	
SD512C16	SD512	12"	4	1"	1/16"	
SD512C332	SD512	12"	4	1"	3/32"	
SD512C18	SD512	12"	4	1"	1/8"	
SD606C18	SD606	6"	4	5/8"	1/8"	
SD606C332	SD606	8"	4	5/8"	3/32"	
SD608C18	SD608	8"	4	5/8"	1/8"	
SD608C332	SD608	8"	4	5/8"	3/32"	

Replacement Parts For SD606 & SD608 Series	
SD600SP	Spring hub assembly bearing & screws
SD600BB	Ball bearing for hub assembly
SD600HUB	Dial hub
SD600FLG	Flange for blade assembly
SD600BTI	Threaded insert for flange
SD600ISC1	Screws for threaded insert
SD600FSC	Screws for flange

Outside Blades						
Item	For	Dia.	Teeth	Arbor	Orientation	
SD206OLH	SD206	6"	10	5/8"	Left Side	
SD206ORH	SD206	6"	10	5/8"	Right Side	
SD208OLH	SD208	8"	12	5/8"	Left Side	
SD208ORH	SD208	8"	12	5/8"	Right Side	
SDOS06LH	SD306	6"	24	5/8"	Left Side	
SDOS06RH	SD306	6"	24	5/8"	Right Side	
SDOS08LH	SD308	8"	24	5/8"	Left Side	
SDOS08RH	SD308	8"	24	5/8"	Right Side	
SDOS10LH	SD310	10"	36	1"	Left Side	
SDOS10RH	SD310	10"	36	1"	Right Side	
SDOS12LH	SD312	12"	36	1"	Left Side	
SDOS12RH	SD312	12"	36	1"	Right Side	
SD506OLH	SD506	6"	24	5/8"	Left Side	
SD506ORH	SD506	6"	24	5/8"	Right Side	
SD508OLH	SD508	8"	24	5/8"	Left Side	
SD508ORH	SD508	8"	24	5/8"	Right Side	
SD510OLH	SD510	10"	32	1"	Left Side	
SD510ORH	SD510	10"	32	1"	Right Side	
SD512OLH	SD512	12"	36	1"	Left Side	
SD512ORH	SD512	12"	36	1"	Right Side	
SD606OLH	SD606	6"	24	5/8"	Left Side	
SD606ORH	SD606	6"	24	5/8"	Right Side	
SD608OLH	SD608	8"	24	5/8"	Left Side	
SD608ORH	SD608	8"	24	5/8"	Right Side	

Dado Parts & Shims



DADO SETS