

Used properly, the CMT dado will be a workhorse in your shop. Please save the instructions and carefully follow these guidelines before using:

- 1) **Set Up** - Your CMT dado is ready for use. Please handle carefully - it is sharp!! Use the chart on the next page to select the components needed for the desired dado width. Examine the components that are to be used and clean any foreign substance from the surface. After cleaning, place the outside blade on the arbor. If using a chipper, place it in the gullet on the inside of the outside blade. If more than one chipper is being used, rotate every other chipper 45°. Install other outside blade and make sure that the teeth of the last chipper are against the gullet of the outside blade.
- 2) **Set Up Tip** - Both outside blades are to be used at all times. There are no exceptions.
- 3) **Adjusting Fit and Multiple Passes** - Replace all safety guards after installing the dado. Then, make a cut in scrap material. If the fit is too loose, follow these instructions:
 - a) disconnect power
 - b) remove the outside blade
 - c) remove the chippers
 - d) install chippers for next smaller size dado
 - e) install appropriate shims
 - f) reinstall outside blades and guards
 - g) make another test cut
 - h) repeat this process until you obtain desired fit.

If the fit is too tight, follow these instructions:

- a) disconnect power
- b) remove the outside blade
- c) install the appropriate shims
- d) reinstall outside blades and guards
- e) make another test cut
- f) add more shims if necessary

For control and safety, it is advisable to use multiple passes on deeper dado cuts.

Safety Reminders

- a) Disconnect power before installing or adjusting the dado.
- b) Always dress appropriately.
- c) Wear safety glasses and hearing protection.
- d) Follow safety recommendations from machinery manufacturer.

03.60.0262



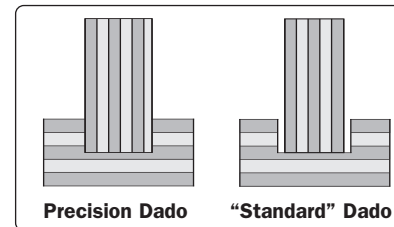
Precision Dado

230.524.08M

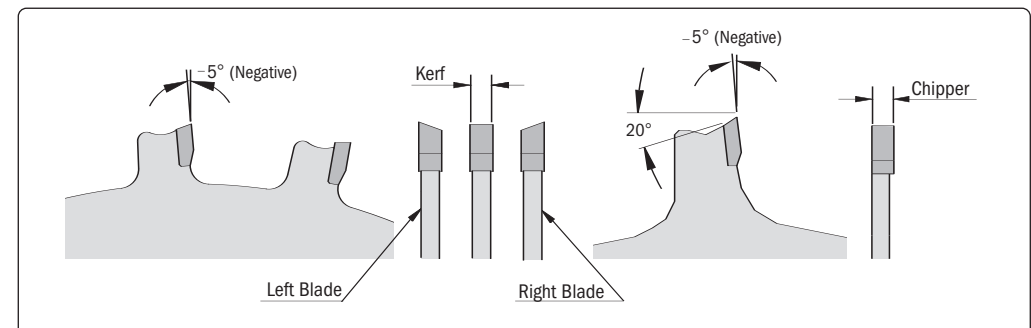


The CMT dado was designed by studying the shortcomings in "standard" dado design and by employing features that cabinet shops requested in their ideal dado set. Check out the following features:

- the anti-kickback design greatly reduces the chance for overfeeding. This is most important with a dado because of the amount of material being cut and it is crucial on a radial arm saw.
- Splinter free cuts will be obtained in veneer plywood, melamine, hardwood and softwood - this includes under size plywood because CMT has added a 2,4mm chipper with this material in mind!
- CMT chippers have four teeth which helps keep the cut flat and free from tear out. This is the cabinetmaker's dream dado at an affordable price!
- Shim set included. Set up any cut between 6,35mm and 23mm.



CMX-4 micrograin carbide teeth
 CMT's specially-formulated silver-copper-silver braze
 Laser cut, high grade German steel with Rockwell hardness of 42 to 44 blade body
 Tension ring by CNC equipment



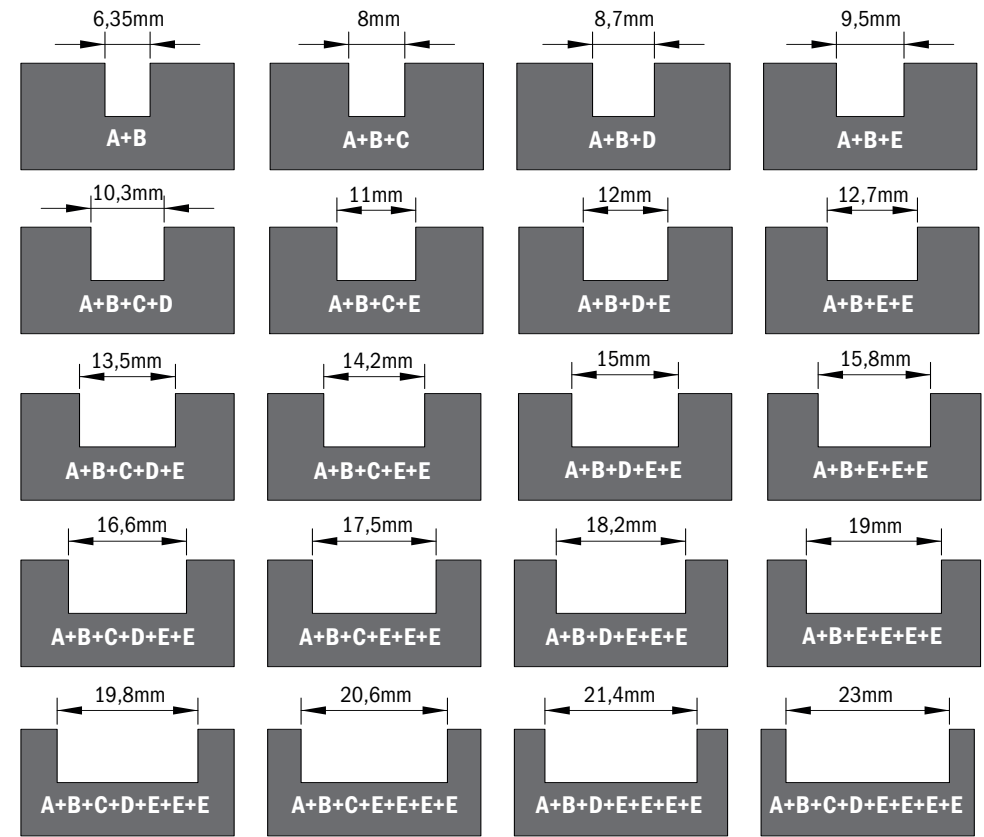
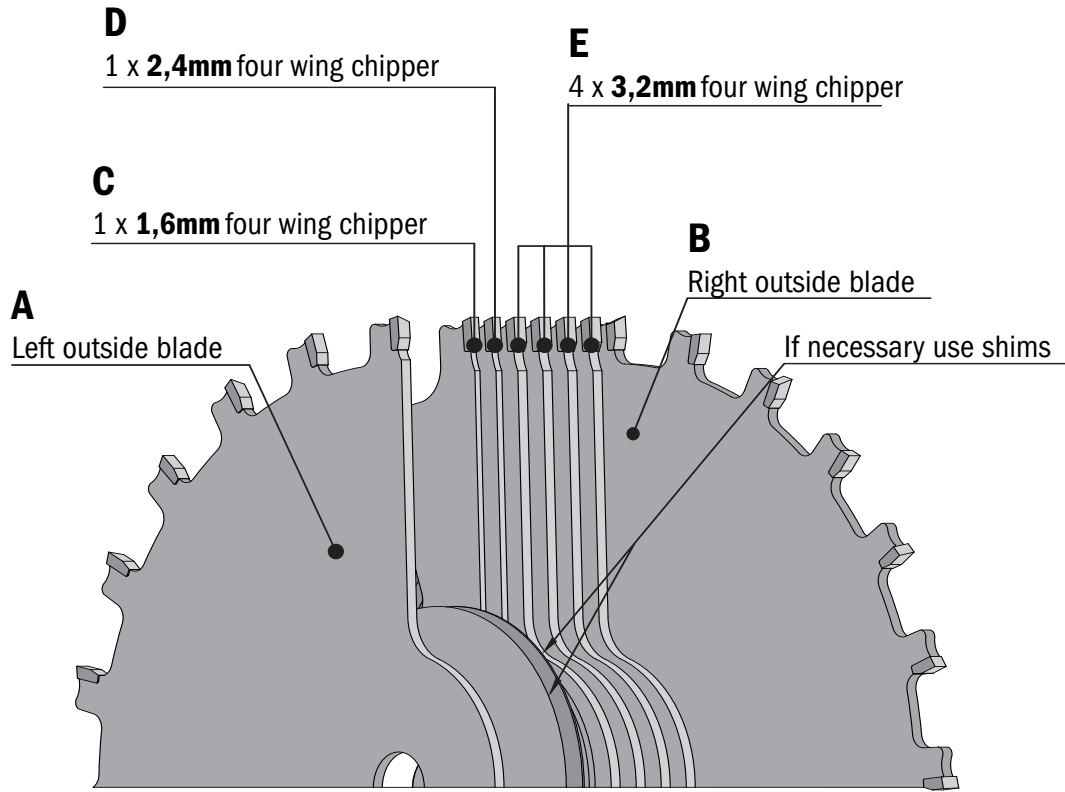
Blade Diameter mm	No. of Teeth	Hook Angle	Bore Diameter mm	Kerf Thickness mm	Chippers	Order No.
200	24	-5°	30	3,2	4x3,2mm - 1x2,4mm - 1x1,6mm	230.524.08M
spare parts:						
	230.999.21M	200mm Dado Chipper - 3,2mm		230.999.23M	200mm Dado Chipper - 1,6mm	
	230.999.22M	200mm Dado Chipper - 2,4mm		299.000.03M	Precision Dado Steel Shim Set	

CMT USA, inc.

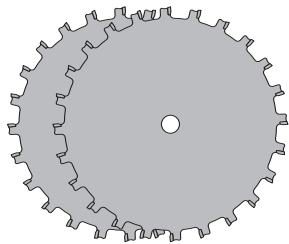
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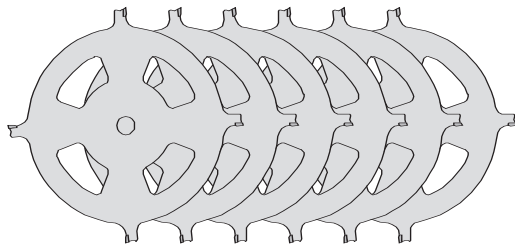
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Set includes:



2 BLADES



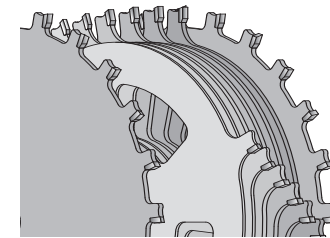
6 CARBIDE TIPPED FOUR TOOTH CHIPPERS.



SHIM SET

Shims set contains

No.	Shim Width
4	0.1 mm
2	0.2 mm
2	0.3 mm
2	0.5 mm



Slot width mm	No. Chippers Required			Slot width mm	No. Chippers Required		
	1,6mm	2,4mm	3,2mm		1,6mm	2,4mm	3,2mm
6,35	0	0	0	15	0	1	2
8	1	0	0	15,8	0	0	3
8,7	0	1	0	16,6	1	1	2
9,5	0	0	1	17,5	1	0	3
10,3	1	1	0	18,2	0	1	3
11	1	0	1	19	0	0	4
12	0	1	1	19,8	1	1	3
12,7	0	0	2	20,6	1	0	4
13,5	1	1	1	21,4	0	1	4
14,2	1	0	2	23	1	1	4