



Model D3697

ZERO-CLEARANCE INSERT

INSTRUCTIONS

Warnings

- DISCONNECT SAW FROM POWER BEFORE FITTING OR REMOVING INSERT!
- Always wear eye protection.
- Be sure blade is NOT in contact with insert before turning the saw **ON**.
- Do not attempt to tilt the arbor while the blade is in the insert! The blade will bind, causing severe damage and possible injury! For beveled cuts, a separate, dedicated insert must be prepared. Pre-set the angle and then proceed as instructed below.
- Insert must be securely clamped down with a board and secured with the front screw before plunging the blade up through it to cut the kerf.
- If using blade stabilizers, check clearance before raising blade.

Installing and Fitting Your Insert

1. Lower the blade completely, then place the insert into the throat opening.
2. Place a straightedge across the insert and table. If the top of the insert is flush with the table or slightly below it, go to **Step 3**. If the insert is raised above the table, the blade may be touching the bottom of the insert. In this case, install a smaller diameter blade that allows the insert to be flush with or below the table top.
3. Thread the four included M6-1 x 12 leveling set screws through the top mounting holes on the insert until each screw is flush with the bottom of the insert.
4. Thread the included M6-1 x 14 set screw halfway through the rear mounting hole, then thread the M6-1 x 10 set screw into the right side mounting hole so it is flush with the insert.
5. Place the insert into the throat opening, back end first, so the rear set screw fits into the indentation in the throat opening. Adjust the rear and side set screws as needed so the insert fits snugly.
6. Place a straightedge across the table and table insert, then turn the leveling set screws as needed to adjust the insert flush with the table top.
7. Thread the included M5-.8 x 20 flat head screw through the hole in the front of insert, but do not overtighten.
8. To remove the insert, remove the front screw, then bump the heel of the your hand on the back of the insert; the front of the insert should pop up slightly.
9. **SPLITTER:** If the insert is to be used with a splitter or riving knife, use a saw or router to cut out a slot. Break sharp edges with fine sandpaper.

Cutting the Blade Slot (Kerf)

1. Check that the insert is fitted properly and that the blade is clear. Open the motor access panel and rotate the flat belt to check for blade clearance. Install a smaller diameter blade if the current one touches the insert.
2. Fully cover the back end of the insert with a board and clamp it to the table saw top. Also, verify that the insert is secured to the table with the included flat head screw (See **Step 7** above.)
3. Re-connect power to saw, switch it **ON**, then slowly and cautiously raise the blade up to cut its way through the insert. **KEEP HANDS OFF OF TABLE TOP, STAY CLEAR AND WEAR EYE PROTECTION.** Raise blade to the maximum height at this time.
4. Lower the blade, turn the saw **OFF**, then remove the board. Your insert is now ready for use!

Important Tips for Use

- Only recommended for use with carbide tipped cutters.
- **DADO BLADE:** Use same procedures outlined above, but use additional caution due to excessive material being machined from the insert during the slotting procedure.
- Under certain conditions, an undesirable scraping noise may be generated by your saw blade. Excessive arbor run-out and/or blade distortion may be causing intermittent contact with the insert slot. To remedy this, remove the insert and slightly widen the slot using a file or sanding paddle.
- Ideally, a separate insert should be used with each blade, dado stack, or angle set-up. This will insure a true "zero-clearance" effect and give you maximum benefit from your inserts.