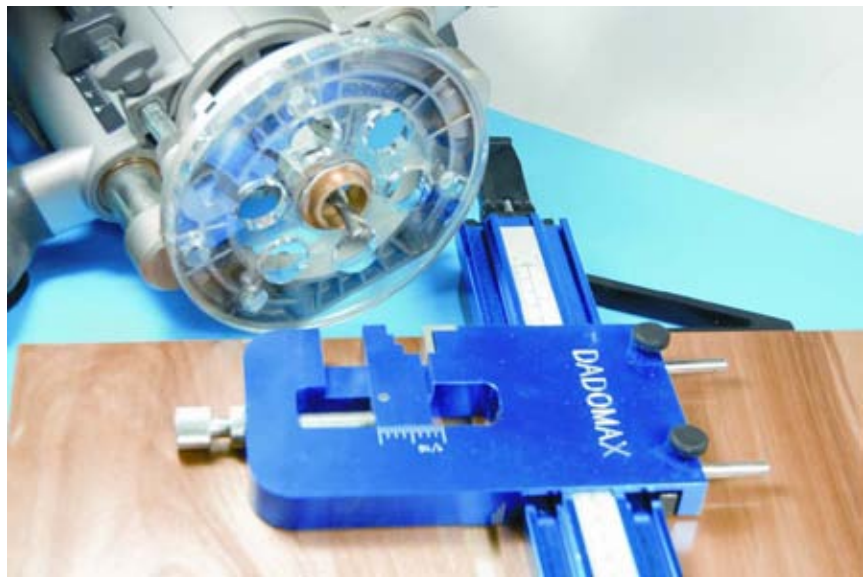




DadoMax™

Instructions for DadoMax™ Precision Dado Accessory

This manual will assist you in the general operation of the **DadoMax™** to achieve the maximum benefit from it. This manual assumes that you are a woodworker experienced in the use of a hand held router.



IMPORTANT

Carefully Read and understand all instructions and manufacturers warnings and instructions before assembly or operation of this product!

Do NOT insert or remove the router bushing from the jig until the router is shut off and has stopped rotating. Failure to do so may result in injury and or substantial damage to the router bit and the tool, such damage is NOT covered by warranty.

The **DadoMax™** is a precision jig for making dado cuts with a router. It eliminates the tedious steps involved in making precision dados without measuring the matching material or adjusting the cutters through the use of shims or other techniques.

The **DadoMax™** is designed to work with any hand held router equipped with a 1" outside diameter bushing guide. A Porter-Cable compatible bushing is supplied with the unit. The bushing has a 1 3/16 diameter threaded portion and a 1 3/8" lip. Many routers accept the bushing supplied, some models require an adaptor to allow the use of bushings. If required contact the router manufacturer to obtain any required adaptor.

Each DadoMax™ contains:

- 1 **DadoMax™** body,
 - 2 1" Brass bushing with locking nut
 - 3 Threaded knobs
 - 1 Hex key wrench
 - 2 Set screws.
 - 1 Instructions
- 1) The **DadoMax™** requires a user-supplied cam operated guide clamp available from Woodline or equivalent.
- 2) It is highly recommended that 1/2" diameter shank router bits with an overall length of 2 1/4" are used.

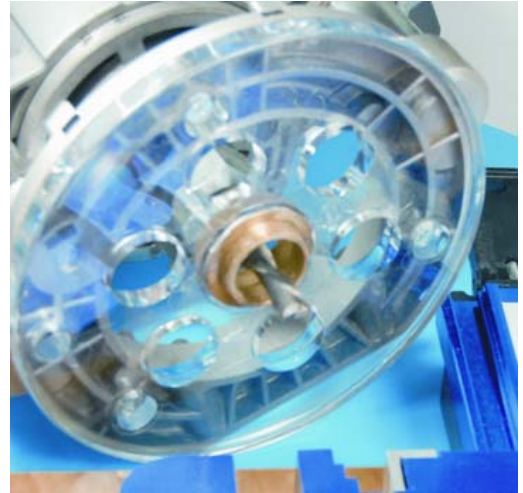
The **DadoMax™** is calibrated for use with 1/4", 3/8", or 1/2" diameter router bits. With the use of these sizes, the **DadoMax™** will be self-calibrating for any dado width between 1/4" and 1 1/8" wide.

WARNING -

WHILE SETTING UP THE DADOMAX JIG OR CHANGING SETTINGS, THE ROUTER SHOULD BE TURNED OFF AND UNPLUGGED IN KEEPING WITH COMMON WORKPLACE SAFETY PROCEDURES.

SETTING UP

- 1) Remove router base and install the 1" outside diameter router bushing and the locking nut. Nut must be securely tightened to prevent vibration from loosening the bushing. Nut should be checked periodically during use. The use of a rubber o-ring between the locking nut and the router base will serve to prevent the nut from vibrating loose.
- 2) Select a router bit from the three sizes referred to (1/4", 3/8", or 1/2") that will allow you to make your dado slot. The cutter must be smaller in diameter than the width of the slot being made. For a 3/4" wide dado slot, use a 1/2" or 3/8" diameter router bit.



Install the selected router bit in your router using normal procedures. Make sure the bit and bushing are properly tightened.

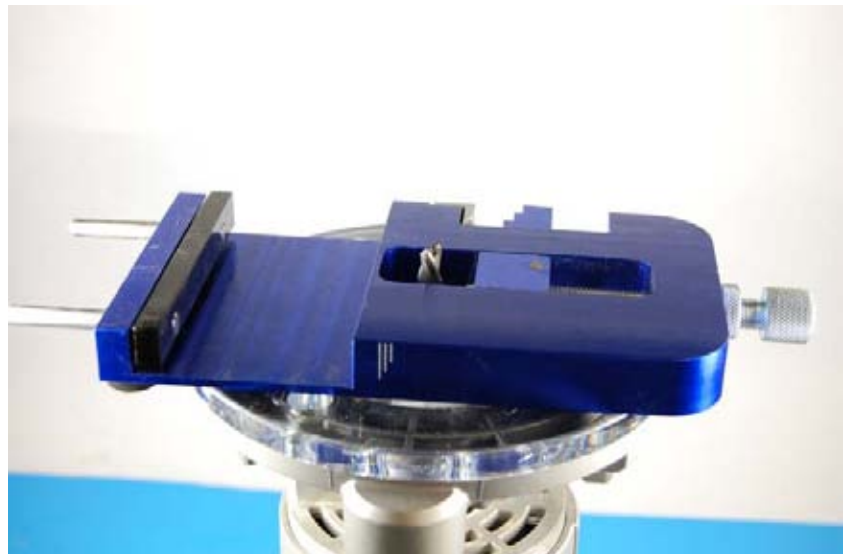
- 3) *Placing the DadoMax™ on Guide Clamp*, loosen the two thumb screws and open the movable fence. Place the **DadoMax™** onto the Guide. Tighten the thumb screws while holding the movable fence closed to achieve a snug fit. The **DadoMax™** should slide freely without excessive play along the length of the guide rail.



- 4) When the router base is too large to clear the thumb screws used to secure the movable fence, replace with the set screws supplied.

SETTING THE DADOMAX™ DEPTH OF CUT

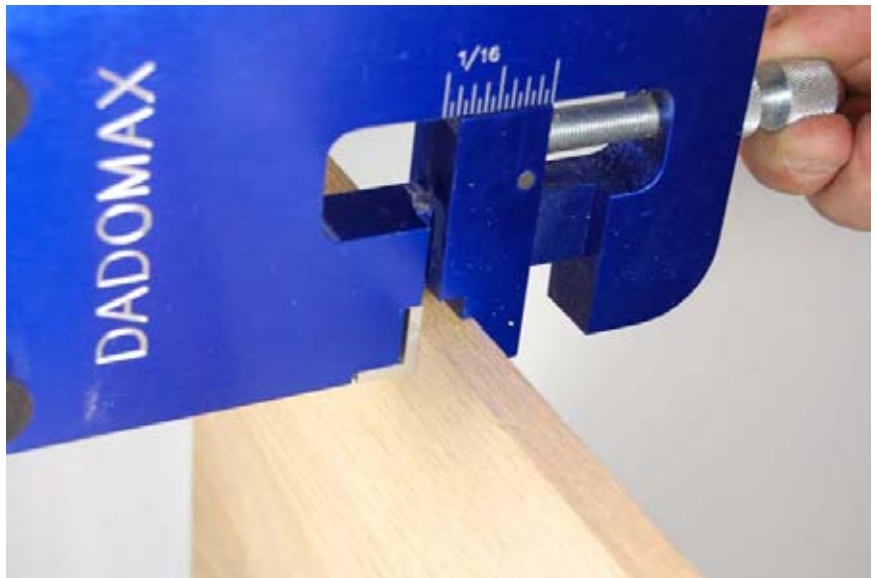
- 1) With the router held upside down, lower the **DadoMax™** face down onto the router to adjust the depth of cut. The amount of the bit protruding through the base of the **DadoMax™** will correspond to the depth of cut. If using a plunge router assure the measurement is made with the router fully against the



plunge stop.

SETTING THE DADOMAX™ FOR THICKNESS OF WOOD and adjusting the Run Out Compensator™.

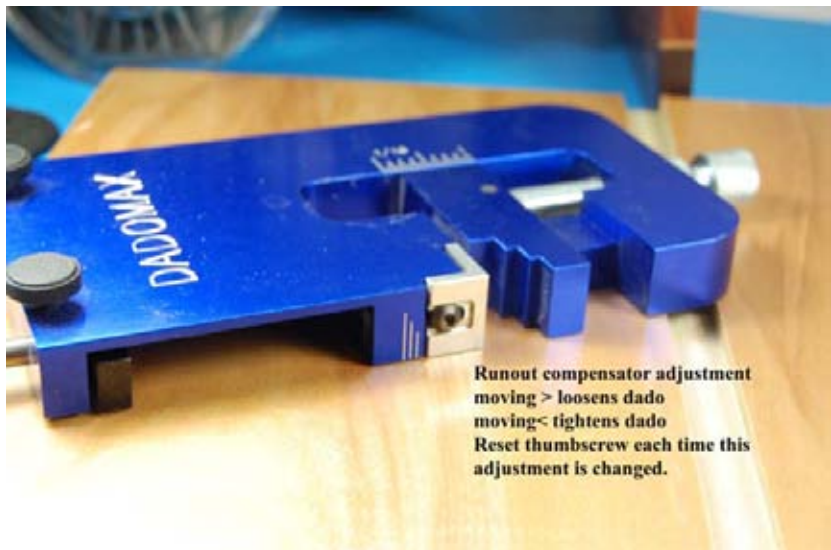
- 1) There are three steps in the moveable jaw of the **DadoMax™**. Each step corresponds to a different size bit. Either 1/4", 3/8" or 1/2" bits can be used. For 1/4" bits the step closest to the center of the jig is used. For 3/8" the center step and for 1/2" bits the outermost step is used. Figure shows 3/8 step being used (middle step)



- 2) Hold the **DadoMax™** over the edge of the board to be inserted in the dado and adjust the moveable jaw until the material is lightly clamped between the step and the fixed portion of the jig. Tighten the lock nut on the threaded rod to lock the jaw in place.

The first time the **DadoMax™** is used with a specific router or bit, the run out compensator may require adjustment. The *Run Out Compensator™* is adjusted by loosening the set screw and sliding the jaw to the left or right. Moving the jaw to the right makes the resulting dado fit loose. Moving the compensator jaw to the left tightens the final dado. Each time the compensator is adjusted, you must reset the thumbscrew for the dado thickness as in step 2.

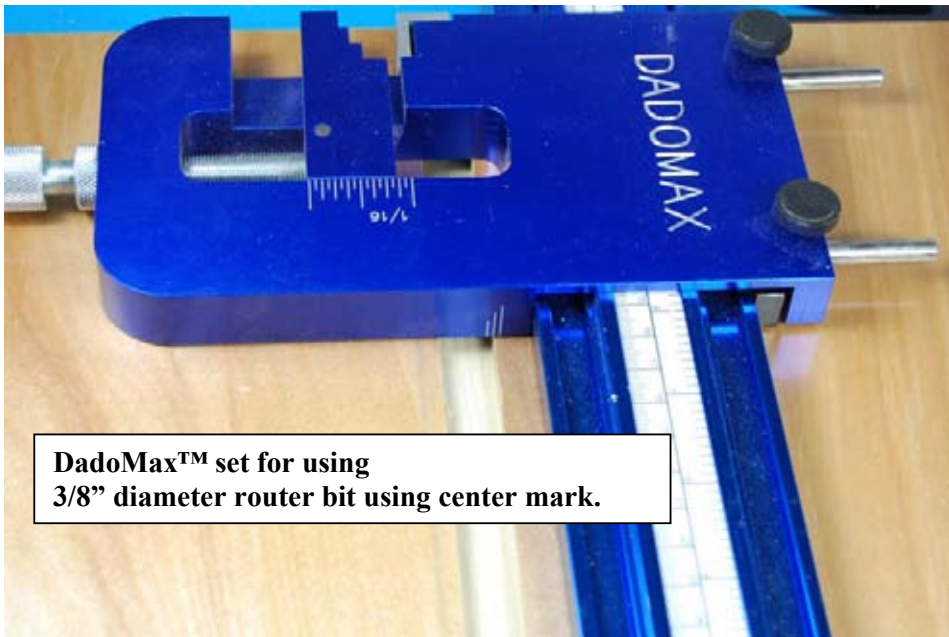
- 3) Fine dado width adjustments to fine tune the fit are made by tightening or loosening the threaded rod slightly after a test cut is made.



Runout compensator adjustment
moving > loosens dado
moving < tightens dado
Reset thumbscrew each time this
adjustment is changed.

POSITIONING THE DADOMAX™ AND ROUTER IN PREPARATION TO MAKE THE CUT

- 1) The three markings on the sides and end of the **DadoMax™** are used for aligning your dado cut. The longest mark represents the location using a 1/2" router bit. The medium mark represents the location using a 3/8" bit, and the shortest mark represents the location using a 1/4" bit. (Refer to Illustration 5)
- 2) The lines marked on the left and right sides of the **DadoMax™** identify the edges of the router bit and are most commonly used for *Stopped Dado Cuts*.
- 3) The markings on the sides of the **DadoMax™** identify the edge of the dado cut closest to the guide rail. Each marking represents where the edge of the dado will be cut for the corresponding size router bit.
- 4) With your wood on a firm work surface, mark the edges of your intended dado slot. Position the Clamp / **DadoMax™** assembly so the marks on the **DadoMax™** are aligned with the markings on the material. Remember to use the markings representing the specific router bit you are using.
- 5) Check the Clamp Guide for square alignment and lock it in place.



CUTTING THE DADO

- 1) Plug in the router and make the cut by sliding the router forward along the clamp guide, holding the router bushing firmly to the left side against the **DadoMax™** so that the cutter cuts clockwise into the wood. At the end of the dado cut, slide the router bushing firmly to the right side against the **DadoMax™**. Bring the router back along the clamp to complete the right side of the dado cut in normal router procedure

- 2) Turn off the router. After it stops completely, remove it from the **DadoMax™**. Remove any sawdust and check to make sure your material properly fits in the slot.
- 3) If it is too tight, or too loose refer to (FINE TUNING THE CUT)

FINE TUNING THE CUT

- 1) The width of the dado cut can be influenced by several factors. Simply adjusting the positioning knob slightly will fine tune the width of cut to make the perfect dado. Once set the jig will make the exact same width dado each time.
- 2) The scale on the top of the body is calibrated in 1/16" increments. It can be used to estimate the amount of adjustment. This is an approximation only because it does not take into consideration the setting of the *Run Out Compensator™*
- 3) If the dado adjustment fails to yield a perfect sized cut, the *Run Out Compensator™* may need adjustment. Refer to setup section for proper procedure.

Other Types of Cuts

DOVETAILS

Female dovetail cuts for sliding dovetail joints are also possible with the **DadoMax™**. To perform these specialty cuts the adjustment for the thumbscrew is screwed in completely so the bushing can not move from side to side. This is called the "trapped bushing" position. A dovetail bit is installed in the machine and the clamp is placed on the board. Alignment of the cutting position must be done manually by aligning the bit center with the desired cut location. Make the cut from the edge of the board. The matching male portion of a joint can be made on a router table or table saw.

STOPPED DADOS

Stopped dados are dados that either start or stop without going all the way to the edge of a board. A stop clamped onto the guide clamp will limit the travel of the **DadoMax™**. A simple stop can be fabricated from a T bolt and knob inserted into the edge of the clamp guide or by using a small c clamp over the guide. Any method is permissible as long as it limits the travel of the **DadoMax™** body.

Revised Adjustment Instructions for The Dadomax



Loosen the set screw on the side of the Dadomax with the hex key wrench (included). Adjust the bar to the approximate width of your clamp guide. Place on to your clamp guide and snug the sliding bar up against it. Secure the set screw. Make sure the Dadomax slides smoothly before proceeding.

Note: This new design does not interfere with the Base of your Router as what may have happened with the old Dadomax design.



