



# POWERMATIC®

## Zero Clearance Table Saw Insert Instructions

### Warnings

- Disconnect saw from power source before fitting or removing insert.
- Always wear safety goggles.
- Be sure blade is not in contact with insert before switching 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! BEVELED CUTS ARE NOT ACCOMMODATED WITH THE USE OF A FACTORY ZERO CLEARANCE INSERT.
- Insert must be securely clamped down with a board before plunging blade up through it to cut kerf.
- If using blade stabilizers, check clearance before raising blade.

 **WARNING:** This product can expose you to chemicals including lead which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

 **WARNING:** Drilling, sawing, sanding or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards for personal protection. Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov/wood>.

### Installing and Fitting Your Insert

1. Lower the blade completely.
2. Place insert in table with starter pocket located over blade. (Adjustment screw may be in front or back depending on model of saw)
3. Run leveling screws down until insert is stable and flush with tabletop. (Use a 3mm hex wrench or Phillips screwdriver)
4. Adjust the length adjustment screw and side adjustment screw to achieve a fit that is snug, yet removable.
5. If the insert will not go down flush with table top because it is resting on top of blade, then raise up using leveling screws until insert is setting steady about 1/16" above tabletop. This should provide adequate clearance for blade.

### Cutting the Blade Slot (Kerf)

1. Check that insert is fitted properly, and that blade is clear. Using a stick, reach under the table and rotate the blade manually to check for blade clearance.
2. Fully cover the insert with a board, and clamp at each end to the table saw top.
3. Re-connect power to saw. Turn on Saw. Slowly and cautiously raise blade up to cut through the insert. **KEEP HANDS OFF TABLE TOP, STAY CLEAR & WEAR GOGGLES.** Raise blade to maximum height at this time.
4. Lower blade, turn off saw, and remove board. Your insert is now ready for use!

**IMPORTANT SPLITTER or RIVING KNIFE INFORMATION:** For all through cuts (i.e. cutting through the entire thickness in a single pass) you **MUST** cut a slot at the rear of the insert to accommodate the splitter or riving knife. Trace the outline of the slot from your original insert, and cut with bandsaw or hacksaw. Leave the bridge between the splitter/riving knife slot and the blade slot as thick as possible.

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## Important Tips

- Only recommended for use with carbide tipped cutters
- DADO BLADE – Use same procedures as outlined above, but use additional caution due to excessive material being machined from insert during the slotting procedure.
- Under certain conditions, an undesirable scraping noise may be generated by your saw blade. Planer type blades and/or 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.

## Reordering Inserts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. In the table below, locate your saw to determine the stock number for the inserts you wish to order. Having the proper reorder stock number available when you call will allow us to serve you quickly and accurately.

<b>Table Saw Type</b>	<b>Zero Clearance Insert Reorder Stock Number</b>
Powermatic PM2000B	1791786B

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