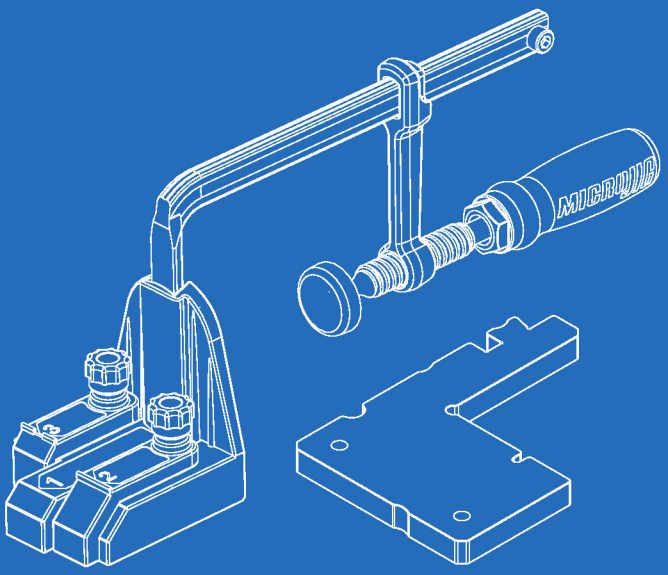
MATCHFIT™

MODEL # MF-1004

DADO STOP PRO

Instruction Manual v1.1

Read the Important Safety Disclaimers in this manual prior to use.
Keep manual for future reference.



MICROJIG
WORK SMARTER.

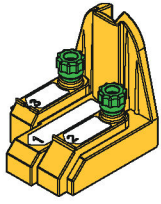
Get started with the fastest, most precise way to cut dados.

Watch the instructional video: MICROJIG.com/dadostoppro

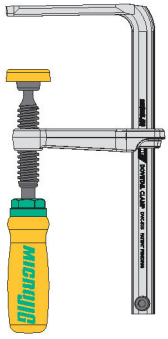
Your MATCHFIT Dado Stop Pro includes one of each:



Setup Gauge
SG-133



Dado Stop
DS-333



Dovetail Clamp
DVC-538

Our 3-Year Warranty protects you against any manufacturer defects.

Please mail the provided registration card or complete the registration online at:
MICROJIG.com/support/warranty-registration

Get more out of your table saw.

Get detailed information on how to tune up your table saw sent directly to your inbox when you become an MJ Insider. Go to **MICROJIG.com/newsletter** and enter your email address to subscribe today.

TABLE OF CONTENTS

Introduction 4

Operation Precautions & Safety 5-6

Align your Blade. 7

Preparing the Setup Gauge for Dados. 8-9

Making Dados with the Dado Stop

- Step 1: Setting the Blade Kerf 10
- Step 2: Setting Inlay Material Width. 10
- Step 3: Cutting the Dado. 11

Dado Stop as a Crosscut Stop 12

Using the Setup Gauge for your Dovetail Clamp Projects

- Step 1: Cutting the Clearance Slot 13
- Step 2: Routing the Dovetail Groove 13

MATCHFIT Dovetail Clamps 14-15



WORK SMARTER.

Congratulations on your purchase of the MATCHFIT Dado Stop Pro.

We know your projects are a labor of love just like our products are to us. That's why we put ourselves in your workshop, imagining every way you'll use and experience our family of products. Throughout your projects, you'll feel the difference our intelligent engineering and carefully selected materials make. We make the complex world of woodworking simpler, so you can work safer. We're always moving forward so you always *work smarter.*

SAFETY WARNING! Your MATCHFIT Dado Stop Pro is designed to be used in conjunction with a table saw. Make sure you are familiar with the operation of your saw before attempting any of the techniques presented within this manual. MICROJIG Inc. assumes no liability for any product not manufactured by it. The user must take all necessary precautions when operating a table saw or any other tools as recommended by their manufacturers and as required by any prudent tool user.

PROPER USE

- ☐ All components must be inspected for damage and securely fastened before every use. Stop using the tool if any damage occurs.
- ☐ In table saw operations, the rip fence must be securely locked parallel to the saw blade.
- ☐ When using the Dado Stop Pro in conjunction with any other tool, refer to that owner's manual first, read and follow all instructions and safety information.
- ☐ Always wear safety glasses and hearing protection. Follow all shop safety practices.
- ☐ It is the sole responsibility of the purchaser of this product to ensure that any third party reads and agrees to all safety precautions prior to use of this tool.
- ☐ Use saw blades that are designed for the intended cutting operation.
- ☐ Do not use this product while under the influence of drugs, alcohol or any medication.

MAINTENANCE

- ☐ Do not use this tool if any components are damaged. Contact your dealer or manufacturer for replacement parts.
- ☐ When not in use, store this product on a flat, clean surface.

TABLE SAW PREP

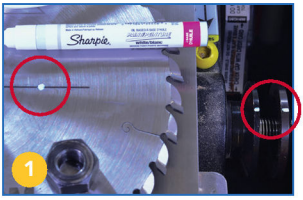
- ☐ The machine tabletop used in conjunction with this tool must be flat and free from obstructions other than the required fence and one cutting element. The tabletop must be reasonably level and below the waistline.
- ☐ You must have a sturdy, straight rip fence with a flat front surface preferably at least 2.5–3" in height and square to the tabletop. The rip fence must be long enough to cover the entire depth from the front to the rear of your tabletop. The rip fence must also be equipped with a locking mechanism to secure it on the tabletop so that it is parallel to the saw blade at all scale settings. WARNING! DO NOT SKEW THE RIP FENCE! The Dado Stop is designed to attach parallel to the saw blade.
- ☐ The rip fence should also be accurately calibrated to a fixed scale to secure a precise cutting width setting.
- ☐ A sharp, clean carbide-tipped saw blade should be used with this tool for crosscutting, unless otherwise specified.
- ☐ Ensure that your saw blade is set vertically at an absolute 90 degree angle.
- ☐ Ensure that your miter gauge fits properly and has no play within the miter slot.

WARNING! Never wear loose clothing, gloves, bracelets or other jewelry that may get caught in the moving parts or cutting elements.

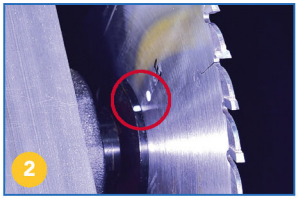
IMPORTANT: Run-out varies from table saw to table saw, saw blade to saw blade, or a combination of both. ***Each calibrated MATCHFIT Setup Gauge works with only one saw blade and table saw combination.***

FOR BEST RESULTS: ALIGN YOUR BLADE

To ensure precise fitting dados when changing saw blades, prepare the blade with a *reference point*. This allows you to quickly realign your blade to the original setting of your Setup Gauge.



Use an oil-based paint marker to draw reference dots on the arbor flanges, saw blade, and stiffener (if applicable).



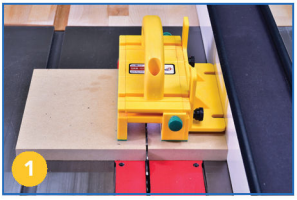
Align all reference dots each time this saw blade is installed on this table saw.

PREPARING THE SETUP GAUGE FOR DADOS

Instructional Video: MICROJIG.com/dadostoppro

TRIMMING THE BLADE KERF

NOTE: The Setup Gauge works as a template capturing the exact kerf of your saw blade for repeatable and consistent dado setups. *Proceed carefully, as you can only make one cut per Setup Gauge.*



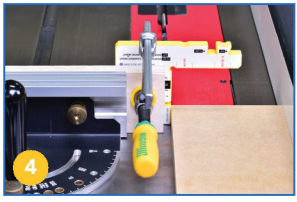
Rip a piece of 3/4" MDF to 4" wide. Do not move the fence until after trimming is complete, see 5. NOTE: Using MDF is preferred over solid wood or plywood.



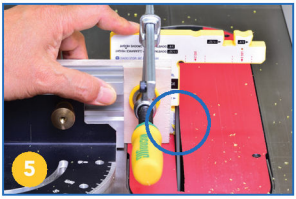
Place the Setup Gauge next to the blade. Raise the saw blade to the height of the center notch.



Using a Dovetail Clamp, attach the Setup Gauge to the miter gauge. It should gently touch the edge of the MDF without pinching or binding and sit square on the tabletop.



Push the miter gauge forward and backward slightly, making sure the Setup Gauge does not drag along the MDF.



Trim the lower portion of the Setup Gauge.

NOTE: *Proceed carefully, as you can only make one cut per Setup Gauge.*



1. Measure the width of the upper untrimmed section of the Setup Gauge.
2. Reset caliper to zero.
3. Measure the width of the trimmed section.

This number is the kerf that this saw blade and table saw are cutting including any run-out.

Write this number along with the table saw, and blade you are using in the space provided on the Setup Gauge for future reference.

Get more out of your table saw.

Get detailed information on how to tune up your table saw sent directly to your inbox when you become an MJ Insider. Go to **MICROJIG.com/newsletter** and enter your email address to subscribe today.

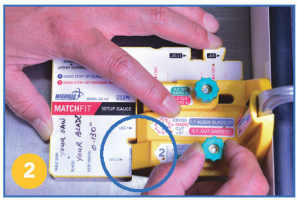
MAKING DADOS WITH THE DADO STOP

Instructional Video: MICROJIG.com/dadostoppro

STEP 1: SETTING THE BLADE KERF

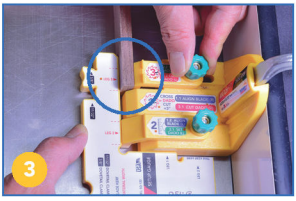


Assemble the Dado Stop by attaching the Dovetail Clamp. Slide the clamp into the dovetail groove on the backside of the Dado Stop.



1. Attach the Dado Stop to your rip fence.
2. Set the fence and Dado Stop clear of the blade.
3. Use the Setup Gauge to set Leg #2 of the Dado Stop as shown. This will ensure consistent results every time you use this blade. Reference: **1.2 ALIGN BLADE (L)**

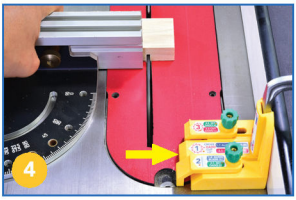
STEP 2: SETTING THE INLAY MATERIAL WIDTH



Use the Setup Gauge as a square across the Dado Stop aligned off the side of Leg #2. Reference: **2.1 SET DADO (L)**

Place the piece of stock to be fitted into the dado against the Setup Gauge, using it as a square. Adjust Leg #3 until it touches the piece. Reference: **2.2 SET DADO (R)**

STEP 3: CUTTING THE DADO

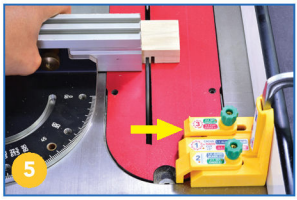


Cut the first shoulder:

1. Raise the blade to desired height.
1. Put stock against Leg #1. Leg #1 is exactly 3" long. Move and secure the fence to desired distance +3".
2. Make your cut.

Reference:

3.1 CUT DADO (R)

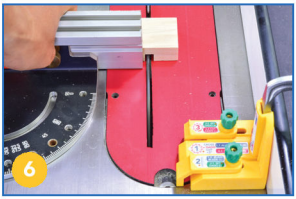


Cut the second shoulder:

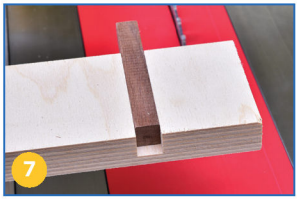
1. Put stock against Leg #3.
2. Make your cut.

Reference:

3.2 CUT DADO (L)



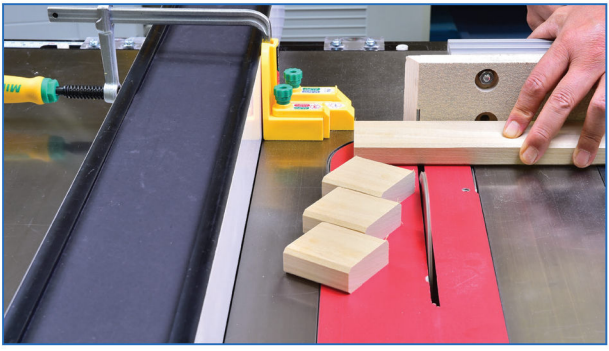
Repeat cuts to remove material between the shoulders.



Insert the inlay material.

DADO STOP AS A CROSSCUT STOP

How to use the Dado Stop as a safe and effective crosscut stop.

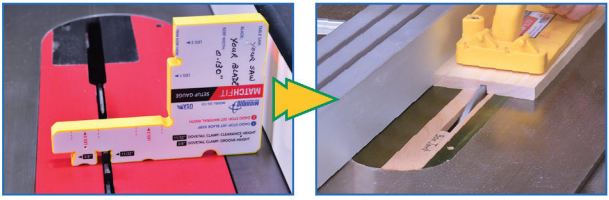


A rip fence/miter gauge combination should NEVER be used for crosscutting because the material trapped between the fence and blade will kick back. The MATCHFIT Dado Stop can be used as a safe and effective crosscut stop. The precise 3" length of the Dado Stop allows you to accurately set the rip fence scale.

1. Set Leg #1 gently against the blade.
   Reference: **1.1 ALIGN BLADE (R)**
2. Set the scale cursor on the rip fence to exactly 3". Now, move your fence to desired cut width (+3").
3. Move the stock so that it gently touches Leg #1. Make your cut. Repeat as necessary.

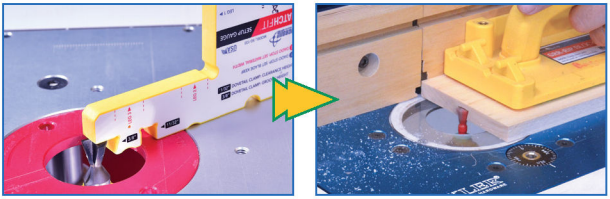
How to use the Setup Gauge as a height gauge when cutting dovetail grooves for your Dovetail Clamp projects.

STEP 1: CUTTING THE CLEARANCE SLOT



If clearance slot is desired, use the 11/32" height slot for clearance slot (for saw blades or 1/4" router bits).

STEP 2: ROUTING THE DOVETAIL GROOVE



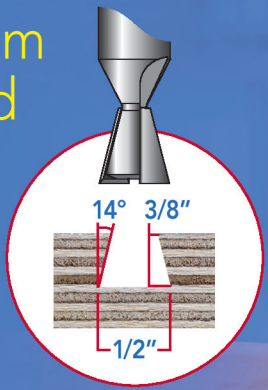
Use the 3/8" height slot to set the 1/2" 14° router bit height.

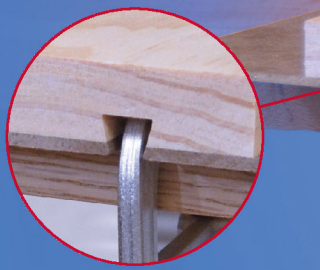
GET THE MOST OUT OF YOUR MATCHFIT SYSTEM:
For project plans, videos, manuals, and more information on the MATCHFIT system, visit **MICROJIG.com/matchfit**

MATCHFIT DOVETAIL CLAMPS

Clamping freedom that goes beyond the edge.

The MATCHFIT Dovetail Clamp profile fits a 3/8" deep groove made using a 1/2" diameter, 14° dovetail router bit. The breakthrough dovetail clamp arm design gives you the freedom to create your own track grooves, allowing you to clamp virtually anywhere. Work smarter.





Compatible with any 1/2" 14-Degree Dovetail Router Bit





Visit
bit.ly/dvcprojectplans
to download

FREE PROJECT PLANS

2-in-1 Straight Edge Guide Plans
Router Table Pressure Jig Plans
Table Saw Tall Fence Plans

MATCHFIT DOVETAIL CLAMPS



Get the most out of your
MATCHFIT system, visit
MICROJIG.com/dovetailclamp today.



Have questions? Need support? Contact MICROJIG directly.

Phone: **1-855-RIP-SAFE** International: **1-407-696-6695**
Email: **support@microjig.com**
Online: **MICROJIG.com/support**

Become an MJ Insider: MICROJIG.com/newsletter

MATCHFIT, Dovetail Clamp, and Dado Stop are trademarks of MICROJIG. Patent Pending.
A true MICROJIG innovation. MATCHFIT Dovetail Clamp designed in the USA, made in Taiwan. MATCHFIT Dado Stop and Setup Gauge made in the USA. © 2017 • **MICROJIG.com**