

POCKET HOLE JIG KIT #854 INSTRUCTIONS

Please read these instructions carefully and thoroughly before using this product.

SAFETY INSTRUCTIONS

1. Always use eye protection when using power tools. Wear safety goggles that comply with ANSI Z87.1.
2. Always unplug your power drill before changing bits and attaching drill stops.

WHAT'S INCLUDED

(see figure above)

CALLOUT #	DESCRIPTION	QUANTITY
1	Wood thickness adjustment thumbwheel	1
2	Step drill bit, 3/8"	1
3	Stop collar	1
4	Hex wrench	1
5	#2 x 6" square drive bit	1
6	1" long coarse thread wood screws with #2 washer head	24
7	1" long fine thread wood screws with #2 washer head	24
8	Spare hex head screws	2
9	Work piece clamp with plastic thumbnut	1
10	Jig mounting holes	2
11	Hex head screws (hidden) securing jig base to vertical piece	2

SETUP INSTRUCTIONS

To familiarize yourself with the jig and avoid ruining good stock, practice making a few pocket holes on scrap pieces of wood before starting your project.

Secure the jig to your workbench or fixed work surface using the two mounting holes on the bottom of the jig (Callout 10).



OPERATING INSTRUCTIONS

1. Adjust the height of the drilling platform for the nominal work piece thickness by aligning the top of the platform with the correct line on the scale marked on the jig body. Secure the platform by hand-tightening the metal thumbwheel (Callout 1).



2. To set the drill bit to the correct drilling length, ensure that the stop collar (Callout 3) on the step drill bit (Callout 2) is positioned at the correct height to prevent drilling into the jig. The tip of the bit should be close to the platform—but not touch it. Use the included hex wrench to loosen/tighten the set screw on the stop collar.



3. Center the work piece to be drilled through in the jig and clamp it tightly using the black plastic thumbnut (Callout 9).

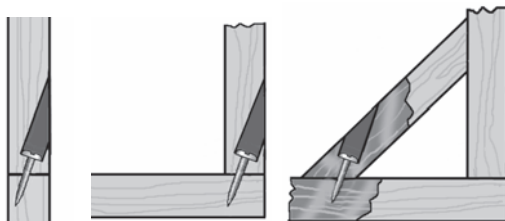


4. After making sure that your drill and bit are up to speed, drill the pocket hole(s) until the stop collar hits the metal ring on the top of the jig. For cleaner cut holes and easier drilling, do not attempt to drill the entire depth with one stroke. Instead, use short strokes until the drill has reached its final depth. When you're finished, unclamp the drilled-through work piece and remove it from the jig.



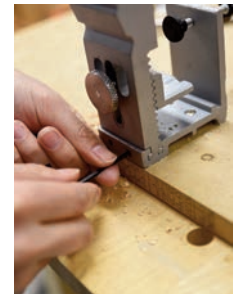
5. Clamp the drilled-through work piece and its mate together in the desired joint configuration (angled, edge-to-edge, or 90°).

To complete the joints, use the included square drive bit (Callout 5) to drive screws through the drilled-through work piece into its mate, adding glue if desired.

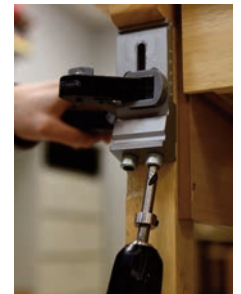


6. The vertical piece of the #854 jig can be separated from the base to create pocket holes on horizontal work pieces, or in hard-to-reach areas, such as corners.

To detach the base of the jig from its vertical piece, use the included hex wrench to loosen and remove the two hex head screws (Callout 11) that connect the two sections. Two spare hex head screws are included, should one or both screws go missing while the sections are separated.



7. To use the vertical piece (including the drilling platform) separately, follow the same instructions as above. Use a separate clamp (not included) to secure the work piece and vertical piece before drilling.



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