FOREMAN INSTRUCTIONAL MANUAL
DB55 Pneumatic/DB110 Electric Models
(29341)

Electric Foreman
Item# DB110 (29341)

Pneumatic Foreman
Item# DB55

Patents pending.
The Blue Mark of Quality. Version 2005701 DB5305
RTD10000270AA

Note: Rockler may not carry all products and/or sizes listed in this vendor's publication.
Congratulations on choosing a Kreg Foreman Semi-Automatic Pocket Hole Machine!

Be sure to read the instructions and the safety warnings completely before using this machine.

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**Attention:**

As with all machinery, there are certain hazards involved with operation and use of the machine. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

This system was designed for certain applications only. Kreg strongly recommends that this system NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application, DO NOT use the Tools until you have written Kreg Tool and we have advised you.
Thank you for purchasing a KREG product. All products have been designed to ensure safe and efficient operation when installed and used properly.

Warning
Woodworking machines are dangerous and can cause personal injury if not used properly.
Read safety instructions and operating instruction for your machine completely before using products.
Using this system before understanding its safe and proper use could result in serious injury to the operator.
Failure to follow these rules may result in serious personal injury.
For your own safety, read instructions manual before operating the tool. Learn the tools application and limitations as well as the specific hazards peculiar to it.
Keep all guards and safety devices in proper place while using these products.
Always wear safety glasses.
Keep hands well away from the pneumatic or mechanical clamp and rotating bit when operating machine.
Avoid awkward hand positions, where a sudden slip could cause contact with rotating bit. Never reach under the clamp pad with either hand to hold down the workpiece.

Kickbacks
Beware of kickbacks; they can cause serious injury. A kickback occurs when the workpiece binds up while being drilled, causing it to twist, jump, or become airborne.

To Avoid kickbacks:
Always use sharp drill bits.
Keep machine in proper alignment and good working condition.
Never perform any “free hand” drilling. Work must always be held securely against the table and fence.
Always support longer boards when drilling.

To avoid injury, never make adjustments while the machine is running.
Make sure machine comes to a complete stop before removing or securing workpiece, or workpiece angle.
Ground all tools. If tool is equipped with three-prong plug, it should be plugged into a three hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter lug must be attached to a known ground. Never remove the third prong.
Remove adjusting keys and wrenches. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it “on”.
Don’t use in dangerous environment. Don’t use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.
Keep children and visitors away. All children and visitors should be kept a safe distance from work area.
Make workshop CHILD PROOF with padlocks, master switches, or by removing starter keys.
Don’t force tool. Don’t force tool attachment to do a job for which it was not designed.
Use right tool. Don’t use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.
Secure work. Use clamps or a vise to hold work when practical. It’s safer than using your hand and frees both hands to operate tool. Don’t over-reach. Keep proper footing and balance at all times.
Maintain tools in top condition. Keep tools sharp and clean for best and safest performance.
Follow instructions for lubricating and changing accessories.
Disconnect tools before servicing and when changing accessories such as bits, clamps, etc.
Use recommended accessories. The use of improper accessories may cause hazards.
Avoid accidental starting. Make sure switch is in “OFF” position before plugging in power cord.
Never stand on tool. Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
Check damaged parts. Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
Never leave tool running unattended. Turn power off. Don’t leave tool until it comes to a complete stop.
Drugs, alcohol, medication. Do not operate tool while under the influence of drugs, alcohol or any medication.
Make sure tool is disconnected from power supply while motor is being mounted, connected or reconnected.
### DB110 Electric Model

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DB55 Parts Diagram

DB55 Pneumatic Model

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Parts: DB5002, DB5003, DB5004, DB5006, DB5251, DB5009, DB5010, DB5215, DB5207, DB5216, DB5026
Semi-Automatic Electric Foreman DB110 Assembly
Entirely electric, no compressed air needed.
Motor rated at 3/4-HP and 8-amps

Assemble the Handle (Fig. 5A)
The Handle for the Foreman is disconnected for shipping purposes. The handle is shipped with two nut and bolt sets installed finger tight in the Handle and Operator Assembly.
1. Remove both nuts and washers from their respective bolts and align the first set of holes in the Handle and the Operator Assembly.
2. Push the first bolt through the Handle and Operator Assembly and attach the washer and nut.
3. Align the second set of holes in the Handle and the Operator Assembly and push the second bolt through the Handle and Operator Assembly and attach the remaining washer and nut.
4. Tighten both nut and bolt sets.

Attach the Mechanical Clamping Tower (Fig. 5B & 6B)
To attach the Mechanical Clamping Tower a bolt must be secured that is located on the underside of the machine. This operation may be performed with the machine placed on its side on a workbench to more easily reach the bolt. Refer to figure 5B and 6B for assembly. Location of the bolt is the same for electric and pneumatic models.
1. Remove all packing material from the Mechanical Clamping Tower prior to attaching the Tower to the Fence.
2. The anchoring bolt for the Clamping Tower passes through the EZ DB Fence and is held in position with a nut for shipping purposes. Remove the Nut from the 5/16-18 Bolt and use a ¼” Allen Wrench to thread the anchoring bolt into the bottom of the Clamping Tower.
3. Align the Clamping Tower so it sits squarely on the EZ DB Fence and tighten the anchoring bolt.

Connect the Clamping Linkage (Fig. 5C)
The Transfer Bars are disconnected from the Operator Assembly for shipping purposes. You will need to attach each Transfer Bar to the sides of the cam contained on the Operator Assembly.
1. Remove the 1/4” diameter X 3/4” long Clevis and Cotter Pin from the Operator Assembly.
2. Align each of the Transfer Bars outside the cam on the Operator Assembly.
3. Push the Clevis through the aligned holes and attach the Cotter Pin.
Assembly Instructions - DB55 Pneumatic

Semi-Automatic Pneumatic Foreman DB55 Assembly
90-120 psi recommended -
Minimum compressor capacity of 5.3 cfm @ 90 psi

Assemble the Handle (Fig. 6A)
The Handle for the Foreman is disconnected for shipping purposes.
The handle is shipped with two nut and bolt sets installed finger tight
in the Handle and Operator Assembly.
1. Remove both nuts and washers from their respective bolts and
   align the first set of holes in the Handle and the Operator
   Assembly.
2. Push the first bolt through the Handle and Operator Assembly
   and attach the washer and nut.
3. Align the second set of holes in the Handle and the Operator
   Assembly and push the second bolt through the Handle and
   Operator Assembly and attach the remaining washer and nut.
4. Tighten both nut and bolt sets.

Attach the Pneumatic Clamping Tower (Fig. 6B & 5B)
To attach the Pneumatic Clamping Tower a bolt must be secured that
is located on the underside of the machine. This operation may be
performed with the machine placed on its side on a workbench to
more easily reach the bolt. Refer to figure 5B and 6B for assembly.
Location of the bolt is the same for electric and pneumatic models.
1. Remove all packing material from the Pneumatic Clamping Tower
   prior to attaching the Tower to the Fence. The Air Cylinder is
   connected to the machine via the small diameter air supply line, be
   careful not to twist or disconnect the air supply line during
   assembly.
2. The anchoring bolt for the Clamping Tower passes through the
   EZ DB Fence and is held in position with a nut for shipping
   purposes. Remove the Nut from the 5/16-18 Bolt and use a ¼”
   Allen Wrench to thread the anchoring bolt into the bottom of the
   Clamping Tower.
3. Align the Clamping Tower so it sits squarely on the EZ DB Fence
   and tighten the anchoring bolt.

Fill the Automatic Oil Lubricator (Fig. 6C)
The Automatic Oil Lubricator is void of Air Tool Oil for shipping pur-
poses. A 2-ounce bottle of air tool oil is provided with the machine
and should be used to fill the Lubricator. Operation of the Automatic
Oil Lubricator is discussed in the “ADJUSTMENTS” – “Automatic Oil
Lubricator” section of this manual.
1. Remove the Fill Cap of the Lubricator and add air tool oil to the
   “MAX. OIL” line on the Lubricator.
2. Replace the Fill Cap in the Lubricator and tighten.
Semi-Automatic Electric Foreman DB110 Operation

Entirely electric, no compressed air needed.
Motor rated at 3/4-HP and 8-amps

GENERAL OPERATION (Fig. 7A)

To operate the Electric FOREMAN, first place a workpiece under the clamping pad. Make sure that the clamping pad extends no more than 1/8” above the workpiece in the unclamped state. If more than a 1/8” gap exists, adjust the Clamping Pad to the correct height. See the “ADJUSTMENTS” section – “Adjusting the Clamping Pad” for more information. Secondly making sure all body parts and clothing are safely away from the Clamping Pad, Drill Guide and Drill Bit, pull the handle towards the work surface. This action will start the Drill Motor and the mechanical action of moving the Handle will be transferred to the clamping mechanism to hold the workpiece in position prior to drilling. Continue to pull the Handle slowly toward the table surface to complete the drilling cycle. Finish the drilling process by carefully guiding the Handle back to the starting position. This will stop the Drill Motor and release the Clamping Pad.

MAINTENANCE (Fig. 7B & 7C)

1. Keep motor clean. Like any electric tool the Electric FOREMAN needs to be kept free of excessive wood chips and dust. Routinely remove waste material from inside the cabinet or mount the machine above an open stand that will not allow the waste material to accumulate.

2. Lubricate Guide Rods. Periodically service the Guide Rods with a dry film lubricant like Dri-Tool™ Lubricant from Empire Manufacturing. A dry film lubricant will not collect wood chips and dust and will extend the life of the Bearings and the Guide Rods. See the “ADJUSTMENTS” section – “Changing the Drill Bit” for more information on how to perform this maintenance. The mechanical linkage associated with the clamping mechanism should be lubricated periodically to ensure free movement of its parts.

3. Use a sharp Drill Bit. You can expect to drill between 4000 and 5000 holes in Oak with your #DKDB drill bit before the bit will need to be sharpened. This baseline was established using the factory settings described in the owner’s manual. Adjust your sharpening schedule for your settings and the material that you may be drilling. Keeping the Drill Bit clean and free of pitch, resin, and glue will significantly add to the life of the Drill Bit and increase the number of holes between sharpening. You can easily clean the Drill Bit with a proprietary cleaner like Blade Saver™ from Empire Manufacturing. WARNING! Even a dirty Drill Bit can be very sharp, exercise extreme caution when handling the cutting edges of the Drill Bit. After cleaning you can coat the Drill Bit with a proprietary lubricant designed for cutting wood such as OptiCut-XL™ from Empire Manufacturing. To change the Drill Bit see the “ADJUSTMENTS” section – “Changing the Drill Bit” for more information.
ADJUSTMENTS

Adjusting the EZ DB Fence (Fig. 8A, 8B & 8C)
The EZ DB Fence can be adjusted so that the screw exit point changes. This can be helpful when working with material thinner or thicker than 3/4”. The Pneumatic FOREMAN leaves the factory preset for 3/4” material. This setting can be changed by moving the Fence and Clamping Tower along the slots stamped in the Tool Plate. Be certain to re-adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – “Adjusting the Drill Bit Depth Stop” section of this manual. Before adjusting the EZ DB Fence make certain your machine is DISCONNECTED from the ELECTRICAL SUPPLY. Without an electrical supply you can be certain the machine will not accidentally engage while you are performing this adjustment.

1. Disconnect the machine from the electrical supply.
2. Loosen each Socket-head Cap Screw on the left and right side of the Fence using the 1/4” Allen Wrench.
3. Align the Fence perpendicular to the Top Plate for the setting that corresponds to the material thickness. These settings are outlined below.
4. Tighten the (2) Socket-head Cap Screws to lock the Fence into position.

3/4” Setting
This is the standard setting of the Fence to center a screw in 3/4” material. The Fence is located 5” from the front of the Tool Plate as shown in the figure below. If necessary adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – “Adjusting the Drill Bit Depth Stop” section of this manual.

1/2” Setting
Place a 3/8” x 3/8” shim made from scrap material along the length of the Fence as shown in the figure below. Use double-stick tape to hold the shim securely in position. Adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – “Adjusting the Drill Bit Depth Stop” section of this manual.

1-1/2” Setting
Loosen the (2) Socket-head Cap Screw on the left and right side of the Fence. Slide the Fence backwards until it stops at the back of the slots in the Top Plate. Re-tighten the (2) Socket-head Cap Screws. Adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – “Adjusting the Drill Bit Depth Stop” section of this manual.
9. **DB110 Electric - Adjustments**

**Adjusting the Drill Bit Depth Stop** *(Fig. 9A)*

A Drill Bit Depth Stop is provided to stop the Drill Bit forward motion. Before adjusting the Drill Bit Depth Stop make certain your machine is DISCONNECTED from the ELECTRICAL SUPPLY. Without an electrical supply you can be certain the machine will not accidentally engage while you are performing this adjustment. The Depth Stop Adjusting Screw should be adjusted so that the pilot point of the Drill Bit is just slightly away from the Fence when the Motor Mount contacts the head of the Depth Stop Adjusting Screw. Make sure the Depth Stop Adjusting Screw is locked into position with the Depth Stop Lock Nut.

1. Disconnect the machine from the electrical supply.
2. Remove the Black Acrylic Top to gain access to the inside of the machine.
3. Loosen the Depth Stop Lock Nut on the Depth Stop Adjusting Screw. Turn the Depth Stop Adjusting Screw to the approximate position.
4. Pull the Handle until the Drill Bit pilot point is slightly away from the Fence.
5. Adjust the Depth Stop Adjusting Screw till the Head contacts the Motor Mount.
6. Tighten the Lock Nut to lock the Depth Stop Adjusting Screw in position.
7. Place the Black Acrylic Top back on the machine.

**Adjusting the Clamping Pad Height** *(Fig. 9B)*

The Clamping Pad can be adjusted for material of different thicknesses. The factory setting will clamp materials of approximate thicknesses of 3/4". For materials thicker than 3/4", the Clamping Pad will need to be moved upward to allow the material to locate below the Clamp Pad. For materials less than 3/4" in thickness adjust the Clamping Pad downward to a gap of 1/8" above the material. Before adjusting the Clamping Pad make certain your machine is DISCONNECTED from the ELECTRICAL SUPPLY. Without an electrical supply you can be certain the Drill Bit will not accidentally rotate while you are performing this adjustment.

1. Rotate the Brass Lock Nut away from the Adjustment Shaft and up the Hold Down Bolt to free the rotation of the Adjustment Shaft.
2. Rotate the Adjustment Shaft up the Hold Down Bolt to allow a 1/8" gap above the material under the Clamping Pad.
3. Tighten the Brass Lock Nut against the Adjustment Shaft to prevent the accidental movement during normal drilling operations.

**Safety Switch** *(Fig. 9C)*

An automatic disconnect switch is provided to ensure that the Drill Motor will not run while servicing the Electric FOREMAN. When the Black Acrylic Top is removed the switch is open, disconnecting the Drill Motor from the electrical supply. When the Black Acrylic Top is placed back in position the Safety Switch is closed and the machine will operate as normal. Although this switch is designed to remove electrical power to the Drill Motor it is still highly recommended that the Electric FOREMAN be disconnected from the electrical supply when servicing the machine or making routine adjustments.
Semi-Automatic Electric Foreman DB110 Operation

ADJUSTMENTS (Cont’)

Swing Stops (Fig. 10A)
Two Swing Stops are provided to assist in drilling pocket holes in the same location on multiple workpieces of the same dimension. When the Swing Stop is not used, it will pivot out of the way to allow the workpiece to slide underneath and rest against the fence. To change the location of the Swing Stop simply loosen the knob, move to the new location and tighten the knob to lock the Swing Stop in position.

Changing the Drill Bit (Fig. 10B & 10C)

IMPORTANT! Before changing the Drill Bit, make certain your machine is DISCONNECTED from the ELECTRICAL SUPPLY. Without an electrical supply you can be certain the Drill Bit will not accidentally engage while you are performing this adjustment.

1. Disconnect the machine from the electrical supply.
2. Remove the Black Acrylic Top to gain access to the inside of the machine.
3. Lift the Tool Plate as it pivots on the hinges till the Safety Latch engages to hold the Tool Plate in position.
4. Remove the Clevis and Cotter Pin from the Connecting Rod to disconnect the Connecting Rod from the Motor Mount.
5. Remove the Hairpin Clips from the ends of the Guide Rods and remove the Drill Motor and Motor Mount assembly.
   NOTE: Now is a good time to clean and lubricate the Guide Rods according to the “MAINTENANCE” section of this manual.
6. Loosen both Set-screws with the hex key that hold the Drill Bit in place inside the Drill Adapter.
7. Insert a new or re-sharpened Drill Bit into the Drill Adapter, aligning the flats on the Drill Bit shank with the set-screws in the Drill Adapter.
8. Tighten the set-screws front and back to maintain equal pressure on the Drill Bit shaft.
10. Connect the Clevis and Cotter Pin through the Connecting Rod and Motor Mount.
11. Lift the Tool Plate to disengage the Safety Latch and lower the Tool Plate into position.
12. Check the Drill Bit Depth Stop settings for the material thickness being drilled.
13. Place the Black Acrylic Top back on the machine.
Semi-Automatic Pneumatic Foreman DB55 Operation
90-120 psi recommended -
Minimum compressor capacity of 5.3 cfm @ 90 psi

GENERAL OPERATION (Fig. 11A)

To operate the Pneumatic FOREMAN, first place a workpiece under the clamping pad. Make sure that the clamping pad extends no more than 1/4" above the workpiece in the unclamped state. If more than a 1/4" gap exists, adjust the clamping tower to the correct height. See the “ADJUSTMENTS” section – “Adjusting the Clamping Cylinder” for more information. Secondly make sure all body parts and clothing are safely away from the clamping pad, drill guide and drill bit, pull the handle towards the work surface. This action will activate the Clamping Cylinder and start the Drill Motor. Continue to pull the handle slowly toward the table surface to complete the drilling cycle. Finish the drilling process by carefully guiding the handle back to the starting position. This will stop the flow of pressurized air to the Drill Motor and the Clamping Cylinder.

MAINTENANCE (Fig. 11B & 11C)

1. Oil air motor daily. Like any air tool the Pneumatic FOREMAN needs to be oiled periodically to extend the life of the Drill Motor. An Automatic Oil Lubricator is installed on the Pneumatic FOREMAN and set to perform correctly at the factory. See the “ADJUSTMENTS” section – “Adjusting the Automatic Oil Lubricator” for more information.

2. Lubricate Guide Rods. Periodically service the Guide Rods with a dry film lubricant like Dri-Tool™ Lubricant from Empire Manufacturing. A dry film lubricant will not collect wood chips and dust and will extend the life of the Bearings and the Guide Rods. See the “ADJUSTMENTS” section – “Changing the Drill Bit” for more information on how to perform this maintenance.

3. Use a sharp Drill Bit. You can expect to drill between 4000 and 5000 holes in Oak with your #DKDB drill bit before the bit will need to be sharpened. This baseline was established using the factory settings described in the owner’s manual. Adjust your sharpening schedule for your settings and the material that you may be drilling. Keeping the Drill Bit clean and free of pitch, resin, and glue will significantly add to the life of the Drill Bit and increase the number of holes between sharpening. You can easily clean the Drill Bit with a proprietary cleaner like Blade Saver™ from Empire Manufacturing. WARNING! Even a dirty Drill Bit can be very sharp, exercise extreme caution when handling the cutting edges of the Drill Bit. After cleaning you can coat the Drill Bit with a proprietary lubricant designed for cutting wood such as OptiCut-XL™ from Empire Manufacturing. To change the Drill Bit see the “ADJUSTMENTS” section – “Changing the Drill Bit” for more information.

Always use a sharp Drill Bit for optimum drilling operation.
ADJUSTMENTS

Adjusting the EZ DB Fence (Fig. 12A, 12B & 12C)
The EZ DB Fence can be adjusted so that the screw exit point changes. This can be helpful when working with material thinner or thicker than 3/4”. The Pneumatic FOREMAN leaves the factory preset for 3/4” material. This setting can be changed by moving the Fence and Clamping Tower along the slots stamped in the Tool Plate. Be certain to re-adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – Adjusting the Drill Bit Depth Stop section of this manual. Before adjusting the EZ DB Fence make certain your machine is DISCONNECTED from the AIR SUPPLY. Cycle the machine via the Handle to remove air from the system. Without an air supply you can be certain the machine will not accidentally engage while you are performing this adjustment.

1. Disconnect the machine from the air supply.
2. Loosen each Socket-head Cap Screw on the left and right side of the Fence using the 1/4” Allen Wrench.
3. Align the Fence perpendicular to the Top Plate for the setting that corresponds to the material thickness. These settings are outlined below.
4. Tighten the (2) Socket-head Cap Screws to lock the Fence into position.

3/4” Setting
This is the standard setting of the Fence to center a screw in 3/4” material. The Fence is located 5” from the front of the Tool Plate as shown in the figure below. If necessary adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – Adjusting the Drill Bit Depth Stop section of this manual.

1/2” Setting
Place a 3/8” x 3/8” shim made from scrap material along the length of the Fence as shown in the figure below. Use double-stick tape to hold the shim securely in position. Adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – Adjusting the Drill Bit Depth Stop section of this manual.

1-1/2” Setting
Loosen the (2) Socket-head Cap Screw on the left and right side of the Fence. Slide the Fence backwards until it stops at the back of the slots in the Top Plate. Re-tighten the (2) Socket-head Cap Screws. Adjust the Drill Bit Depth Stop as outlined in the “ADJUSTMENTS” – Adjusting the Drill Bit Depth Stop section of this manual.
Adjusting the Drill Bit Depth Stop (Fig. 13A)
A Drill Bit Depth Stop is provided to stop the Drill Bit forward motion. Before adjusting the Drill Bit Depth Stop make certain your machine is DISCONNECTED from the AIR SUPPLY. Cycle the machine via the Handle to remove air from the system. Without an air supply you can be certain the machine will not accidentally engage while you are performing the adjustment. The Depth Stop Adjusting Screw should be adjusted so that the pilot point of the Drill Bit is just slightly away from the Fence when the Motor Mount contacts the head of the Depth Stop Adjusting Screw. Make sure the Depth Stop Adjusting Screw is locked into position with the Depth Stop Lock Nut.

1. Disconnect the machine from the air supply.
2. Remove the Black Acrylic Top to gain access to the inside of the machine.
3. Loosen the Depth Stop Lock Nut on the Depth Stop Adjusting Screw. Turn the Depth Stop Adjusting Screw to the approximate position.
4. Pull the Handle till Drill Bit pilot point is slightly away from the Fence.
5. Adjust the Depth Stop Adjusting Screw till the Head contacts the Drill Motor Mounting Block.
6. Tighten the Depth Stop Lock Nut to lock the Depth Stop Adjusting Screw in position.
7. Place the Black Acrylic Top back on the machine.

Adjusting the Clamping Cylinder Height (Fig. 13B)
The Clamping Cylinder can be adjusted for material of different thicknesses. The factory setting will clamp materials of approximate thicknesses between 1/2” and 3/4”. For materials thicker than 7/8”, the Clamping Cylinder will need to be moved upward to allow the material to locate below the Clamp Pad. Before adjusting the Clamping Cylinder make certain your machine is DISCONNECTED from the AIR SUPPLY. Cycle the machine via the Handle to remove air from the system. Without an air supply you can be certain the Clamping Cylinder will not accidentally engage or the Drill Bit will not rotate while you are performing the adjustment.

1. Loosen the (2) 1/2” nuts located on the rear of the Clamping Tower.
2. Adjust the Clamping Cylinder to allow a 1/4” gap above the material under the Clamp Pad.
3. Tighten the (2) 1/2” nuts to lock the Clamping Cylinder in position.

Automatic Oil Lubricator (Fig. 13C)
An Automatic Oil Lubricator is provided to maintain proper lubrication to the pneumatic motor. The Automatic Oil Lubricator is preset at 1/2 turn open. The oil level in the Air System Lubricator should be routinely checked and refilled with air motor oil comparable to the oil provided. Normal use of the machine will cause a light film of oil to accumulate on the back on the machine cabinet where the pneumatic motor exhausts. To increase the amount of oil added the system turn the Adjustment Screw counter-clockwise. Likewise to decrease the amount of oil added to the system turn the Adjustment Screw clockwise. Make certain your machine is DISCONNECTED from the AIR SUPPLY when filling the Automatic Oil Lubricator. Cycle the machine via the Handle to remove air from the system.
Semi-Automatic Pneumatic Foreman DB55 Operation
ADJUSTMENTS (Cont')

Swing Stops (Fig. 14A)
Two Swing Stops are provided to assist in drilling pocket holes in the same location on multiple work pieces of the same dimension. When the Swing Stop is not used, it will pivot out of the way to allow the work piece to slide underneath and rest against the fence. To change the location of the Swing Stop simply loosen the knob, move to the new location and tighten the Knob to lock the Swing Stop in position.

Changing the Drill Bit (Fig. 14B & 14C)

**IMPORTANT!** Before changing the Drill Bit, make certain your machine is DISCONNECTED from the AIR SUPPLY. Cycle the machine via the Handle to remove air from the system. Without an air supply you can be certain the Drill Bit will not accidentally engage while you are performing this adjustment.

1. Disconnect the machine from the air supply.
2. Remove the Black Acrylic Top to gain access to the inside of the machine.
3. Lift the Tool Plate as it pivots on the hinges till the Safety Latch engages to hold the Tool Plate in position.
4. Remove the Clevis and Cotter Pin from the Connecting Rod to disconnect the Connecting Rod from the Drill Motor Mounting Block.
5. Remove the Hairpin Clips from the ends of the Guide Rods and remove the Drill Motor and Motor Mount assembly.
   
   **NOTE:** Now is a good time to clean and lubricate the Guide Rods according to the “MAINTENANCE” section of this manual.
6. Use the Chuck Key to open the Drill Chuck jaws. Remove the dull Drill Bit from the Drill Chuck jaws.
7. Insert a new or re-sharpened Drill Bit into the Drill Chuck, aligning the flats on the Drill Bit shank with the jaws of the Drill Chuck.
8. Insert the Chuck Key into EACH hole of the Drill Chuck and tighten EACH jaw of the Drill Chuck to maintain equal pressure on the Drill Shaft.
10. Connect the Clevis and Cotter Pin through the Connecting Rod and Drill Motor Mounting Block.
11. Lift the Tool Plate to disengage the Safety Latch and lower the Tool Plate into position.
12. Check the Drill Bit Depth Stop settings for the material thickness being drilled.
13. Place the Black Acrylic Top back on the machine.

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Adjust the Swing Stop to locate the material for repetitive drilling.

Disconnect the Connecting Rod and Hairpin Clips to remove the Air Drill Motor from the Guide Rods.

The Drill Bit is held in position with the Drill Chuck.
Kreg Tool Company warrants to its authorized distributors of Kreg products and the original purchasers from such distributors, the #DB55 and DB110 Foreman Semi-Automatic Pocket Hole Machine to be free of defects in materials and workmanship for a period of one (1) year from the date of delivery to the original purchaser. During said warranty period Kreg will, at its option, repair or replace any product (or component part thereof) proving defective during said period. This warranty applies only to products which are used in accordance with all instructions as to operation, maintenance and safety set forth in catalogs, manuals, and/or instruction sets furnished by Kreg Tool Company.

This warranty becomes effective only if the accompanying card is fully and properly completed and returned to Kreg Tool Company within ten (10) days from date of delivery to the original purchaser.

The drill guide will carry a lifetime warranty.

This warranty does not apply to items that would normally be consumed or require replacement due to normal wear (drill bits, lubricants, etc.); for the cost of removal of components if such removal is authorized by Kreg Tool Company; for shipment to Kreg Tool Company’s repair facility; or for reinstallation.

This warranty is null and void if the product has been subjected to (1) misuse, abuse or improper service or storage; (2) accident, neglect, damage or other circumstances beyond Kreg Tool Company’s control; (3) modifications, disassembly, tampering, alterations or repairs outside of Kreg Tool Company’s factory not authorized by Kreg Tool Company; (4) to any product not bearing its original serial number plate; and (5) for non-original purchasers. This warranty does not apply to normal wear and tear, corrosion, abrasion, or repairs required due to natural causes or acts of God.

To obtain warranty service contact the distributor from which the FOREMAN Pocket Hole Boring Machine was purchased, or you may contact Kreg Tool Company directly. Proof of purchase will be required before remedy will be provided under the terms of this warranty. Kreg Tool Company assumes no responsibility for products which are returned without prior authorization. Kreg Tool Company’s obligations under this warranty shall be exclusively limited to repairing or replacing (at Kreg Tool Company’s option) products which are determined by Kreg Tool Company to be defective upon delivery at Kreg Tool Company’s factory, and on inspection by Kreg Tool Company. Under no circumstance shall Kreg Tool Company be liable for incidental or consequential damages resulting from defective products, nor shall Kreg Tool Company’s liability exceed the purchase price paid for the product by the original purchaser.

This is Kreg Tool Company’s sole warranty. Any and all other warranties which may be implied by law, including any warranties for merchantability or fitness for a particular purpose, are hereby limited to the duration of this warranty. Kreg Tool Company shall not be liable for any loss, damage or expense directly or indirectly related to the use of its products or from any other cause or for consequential damages (including without limitation, loss of time, inconvenience, and loss of production). The warranty contained herein may not be modified and no other warranty, expressed or implied, shall be made by or on behalf of Kreg Tool Company.

Please register your warranty by sending the separate warranty registration card.

Keep this form for your records.

For your records the following information will be useful in the event warranty service is required. For complete records attach copy of purchase invoice to this form.

Date of Purchase:     ___/___/___

Purchased From:     ____________________________________________

Serial Number:          ________________________________________

(serial number is located on the side of the machine)

Kreg Tool Company, 201 Campus Drive, Huxley, IA 50124