

Thank you for purchasing the Mini Kreg Jig. This guide will provide you with the instructions and techniques for using the tool. Please review the following information to become familiarized with the tool before actual use.

**1. General**

If you are new to pocket hole joinery there are three simple elements that apply to every pocket hole joint. To get the most out of your Mini pocket hole tool you need to know how these elements work together:

- A. Positioning the jig
- B. Setting the drilling depth
- C. Choosing the right thread pitch and screw length

**A. Positioning the Jig**

There are three standard material thicknesses widely used in woodworking today. They are...

- 1. 3/4" (19mm) material found in furniture and cabinetry
- 2. 1/2" (13mm) material commonly used in drawer box construction
- 3. 1-1/2" (38mm) material used in light frame construction (i.e. decks, patio furniture, home improvements)

The primary design of this tool is to place a pocket hole so that when the screw is driven, it emerges at or near the midpoint of the material thickness being drilled. As the standard material thickness changes, so does the position of the jig to successfully center the screw and achieve maximum joint strength. As shown in Fig. 1, the jig is positioned for standard 3/4" (19mm) thick material. Simply align the edge of the jig flush with the end of the workpiece and clamp to position it correctly. To set the jig for working with 1/2" (13mm) material position the edge of the jig 1/4" (6mm) beyond the edge of the workpiece and clamp. To center a screw in 1-1/2" (38mm) material, set the end of the jig back from the edge of the workpiece 1-1/4" (32mm).

**B. Setting the Drilling Depth (Depth Collar Adjustment)**

Each jig position has its recommended drilling depth. To drill in 3/4" (19mm) material for example, set the Depth Collar 3-1/2" (89mm) from the Step of the drill bit (see figure 1A) using a folding rule or tape measure. This will place the tip of the bit approximately 1/8" (3mm) from the edge of the workpiece. Adjust the depth collar to 3-5/16" (84mm) from the step of the bit for 1/2" (13mm) material and 4-1/4" (108mm) from the step of the bit for 1-1/2" (38mm) material. To set the depth, simply slide the Depth Collar onto the loose drill bit shank (the bit should not be chucked into the drill). Measure and position the Depth Collar the desired distance from the Step of the drill. Tighten the setscrew with the Allen wrench provided. Now chuck the KJD bit/collar into your drill.

NOTE: For best results we recommend using a corded electric drill rated at 2,000 rpm or above.

**C. Thread Pitch and Screw Length**

You'll want to use a self-tapping screw when assembling pocket hole joints. The self-tapping feature of the screw eliminates the need to pre-drill the second workpiece when joining two pieces of material. For each material thickness you will want to select the correct thread pitch and screw length. Use a fine thread screw in hardwoods such as oak, maple, hickory, cherry, walnut and birch. Use a coarse thread screw in softer materials such as pine, plywood, particle board and MDF. Recommended screw lengths for each thickness are shown below.

- For 3/4" (19mm) material -- use a 1-1/4" (32mm) screw
- For 1/2" (13mm) material -- use a 1" (25mm) screw
- For 1-1/2" (38mm) material -- use a 2-1/2" (64mm) screw

**2. Drilling the First Holes**

To drill your first pocket holes, first clamp the jig to the workpiece with a Face Clamp or a similar woodworking clamp. Second, use a woodworkers clamp to secure the material with the jig attached to your workbench. Insert the tip of the drill bit half way into the Drill Guide. Start the drill to full speed, and plunge the drill into the guide until the Depth Collar contacts the rim of the Drill Guide. Back the drill out and let the bit stop turning. (Note: When drilling your first few holes you may notice some blue plastic chips. This is normal and is a result of the tight tolerances placed on the KJD bit and drill guide.)

**CAUTION: NEVER ATTEMPT TO HOLD THE JIG IN YOUR HAND WHEN DRILLING. THE TOOL MUST BE CLAMPED TO THE WOOD FOR THIS STEP. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN PERSONAL INJURY AND/OR DAMAGE TO THE TOOL(S).**

**3. Assembly / Driving Pocket Hole Screws (face frame example)**

If you are using a Face Clamp to assemble the joint place the large pad of the clamp on the face side of the joint. Be sure that both pads are equally balanced over each workpiece at the joint line. Adjust the closure pressure until the two parts are firmly secured. The Face Clamp will keep the face surface of the two pieces flush with each other during assembly. It is recommended to drive the screws with a cordless drill/driver that has an adjustable clutch. Start with a light clutch setting and adjust torque as necessary to seat the pocket hole screw. Because the hardness varies among wood species, plywood and composites, drive a few "test" screws to select the proper clutch setting on your drill for the material you are assembling.

**4. Plugging the Pocket Holes**

The pocket holes you drill have the ability to be plugged with 3/8" wooden dowel available in various species. The Mini Kreg Jig incorporates a plug setting feature into the bottom of the tool that helps you complete this process. To use, simply place a plug into the profile on the underside of the jig, swab some glue around the edges of the plug and the inside of the hole and press into position as shown at right. Sand the excess flush.



**Tips for getting the most out of your pocket hole tool:**

- For safety, clamp parts to a work surface before drilling pocket holes. **\*\*NEVER HOLD THE TOOL AND PARTS IN YOUR HAND WHILE DRILLING.\*\***
- Use a corded electric drill with a speed of 2000 rpm or higher for drilling pocket holes.
- Use a cordless (battery) drill/driver with an adjustable clutch feature to drive screws.

**\*\* FOR MORE DETAILED INSTRUCTIONS, TIPS AND TECHNIQUES VISIT WWW.KREGTOOL.COM \*\***

