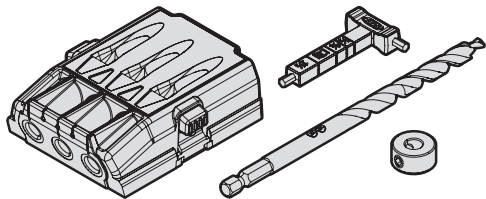


OWNER'S MANUAL



Kreg Micro-Pocket™ Drill Guide Kit KPHA530



WARNING Every user must read and follow instructions and safety precautions in this manual. Failure to do so could result in serious injury. Save manual for future reference.

We're here to help.

We want you to have an exceptional project building experience. If you have questions or need support, please get in touch.
1-800-447-8638 | technicalsupport@kregtool.com

Tell us about your experience.

Your opinion counts. And we're always looking for ways to improve. Share your feedback so we can keep growing and innovating for you. www.kregtool.com/feedback

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Safety Precautions

WARNING Before using a power tool with this product, read, and follow the tool manufacturer's instructions and safety precautions in addition to the safety precautions below to reduce risk of serious injury from hazards such as fire, electric shock, or rotating drill bit.

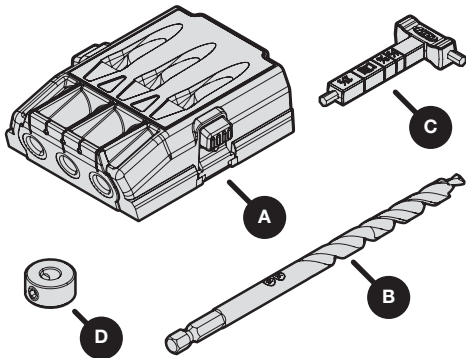
- Always wear personal protective equipment recommended by the manufacturer of the power tool you are using, such as eye, hearing, or respiratory protection.
- The drill bit is sharp. Handle with care.
- Do not allow familiarity gained from frequent use of your tools to replace safe work practices. A moment of carelessness is sufficient to cause severe injury.
- Avoid awkward hand positions where a sudden slip could cause contact with the rotating bit.
- When drilling, always ensure workpiece is clamped securely. It is dangerous to hold workpiece in place by hand.

WARNING Do not operate this tool or any machinery while under the influence of drugs, alcohol, or medications.

WARNING This product can expose you to chemicals including Acrylonitrile and other chemicals, which are known to the State of California to cause cancer and reproductive harm. For more information go to www.P65Warnings.ca.gov.

Pre-Installation/Pre-Assembly

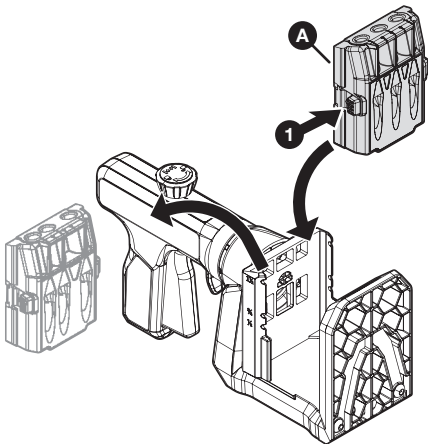
Review this section before you begin. Ensure you have all parts listed below. If any item appears missing or lost, do not use this product. Contact Technical Support or return product to place of purchase.



Part	Description
A	KPHA530 Kreg Micro-Pocket™ Drill Guide
B	Easy-Set Micro-Pocket Drill Bit
C	Material Thickness Gauge/Hex Wrench
D	Easy-Set Micro-Pocket Stop Collar

Assembly/Setup

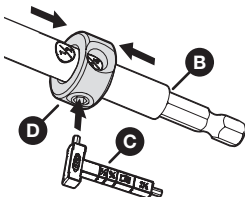
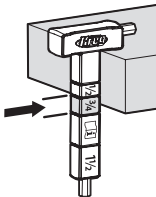
- Remove existing drill guide from the Kreg Jig 520 by squeezing the tabs (1) on both sides and sliding the drill guide out of the carriage.
- Insert the Micro-Pocket Drill Guide (A) into the carriage of the Kreg Jig 520 by squeezing the tabs (1) on both sides and sliding into the carriage.



Operation – Drilling Your First Pocket Hole

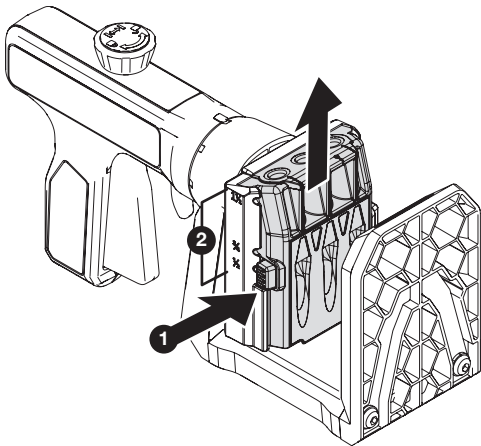
1 Determine the Material Thickness and Set the Stop Collar

- Use the material thickness gauge (C) to determine the material thickness range.
- Set the stop collar (D) by placing it on the drill bit (B) and aligning the window of the stop collar (D) with the material thickness range determined in step a.
- Use the hex wrench (C) to lock the stop collar (D) into place on the drill bit (B).



2 Adjust the Drill Guide

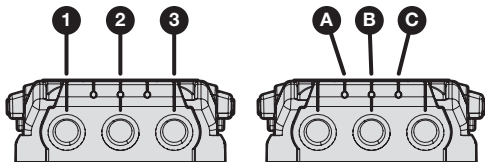
Adjust the drill guide by pressing both tabs (1) on the guide and sliding it to the measurement setting (2) that corresponds with your material thickness.



3 Position your Workpiece

There are two different methods for aligning your Kreg Jig with your workpiece:

- For a workpiece narrower than 1-1/4" wide it is recommended to place each pocket hole 3/8" from the edge, if possible. To do this, mark 3/8" from each edge as the center of the pocket hole and align one of the numbered pocket-hole drill guides (number 1, 2, or 3) and drill the first pocket hole. Then, re-position to the second mark and repeat the drilling process.
- For a workpiece between 1-1/4" to 2-1/4", use the board centering mark A and drilling pocket-holes 1 and 2.
- For a workpiece between 2-1/4" and 3-1/2", use board centering mark B and drilling pocket-holes 1, 2, and 3.
- For wider workpieces such as a drawer box side, it is recommended that the pocket-holes be spaced at 3/4" center-to-center spacing. For workpieces such as panels, it is recommended that the pocket-hole spacing be 1/2" to 1-1/4" from the edge and then every 4" to 6".



Board Width	Center Mark	Drill Guide
1-1/4" to 2-1/4"	A	1 and 2
1-1/4" to 2-1/4"	C	2 and 3
2-1/4" to 3-1/2"	B	1, 2, and 3

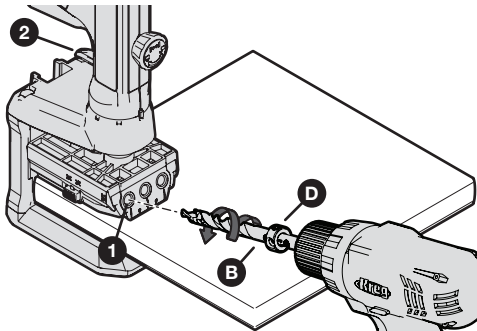
Place your workpiece in the jig and squeeze the handle repeatedly until your workpiece is held securely in the jig. Proceed to the **Operation - Drilling and Driving Pocket-Hole Screws** section to start drilling.

Operation – Drilling and Driving Pocket-Hole Screws

1 Drill Pocket Holes

WARNING When drilling, always ensure the workpiece is clamped securely.


- Place your prepared drill bit (B) with stop collar (D) into your drill.
- Insert your drill bit into the drill guide (1) and bring your drill up to speed before contacting the workpiece to ensure correct rotation of the drill bit.
- Drill until the stop collar (D) stops going any deeper due to contact between the stop collar (D) and drill guide (1). Remove the drill bit (B) from the drill guide while the drill bit is still rotating.
- When done drilling pocket hole(s), pull the trigger (2) to release the clamping pressure, and then remove your workpiece.



2


Drive Screws

- a. Your Micro-Pocket™ Drill Guide Kit is designed to work with SPS type screw heads. Ensure you are using the correct screw size according to this chart:

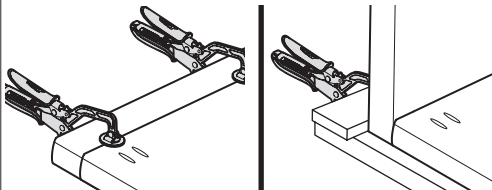
Gauged Material Thickness	Easy-Set Stop Collar	Material Thickness Stop	Screw Length
1/2 Range	1/2	1/2	1" (25 mm)
3/4 Range	3/4	3/4	1-1/4" (32 mm)
	3/4	3/4	1-1/2" (38 mm)
1-1/2 Range	1 1/2	1 1/2	2-1/2" (64 mm)

For more information on screw selections, go to www.Kregtool.com/Screws or simply scan the QR code on the side of your sample screw package.

Note For some material in the 1/2" range, it may be necessary to use the SPS-F075 screw to prevent the tip of the screw from exiting the workpiece.

Note If your material thickness falls in the  range, use the same setup techniques as the 3/4" range with a 1-1/2" screw.

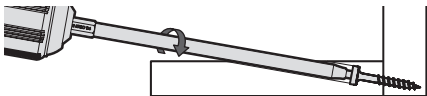
- b. Clamp joints in place to ensure a better finished joint. These examples show face joints and edge joints.



2 Drive Screws (continued)

WARNING When drilling, always ensure the workpiece is clamped securely.

- c. Place your screw on your driver tip, position the screw in the pocket hole, and drive the screw until it is fully seated without overdriving.



Accessories

KPHA750 Pocket-Hole Jig Docking Station

