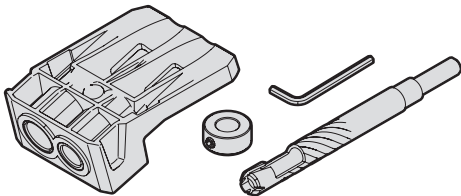


OWNER'S MANUAL



Kreg Plug Cutter Drill Guide Kit KPHA740



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 the risk of serious injury from hazards such as fire, electric shock, or rotating drill bit.

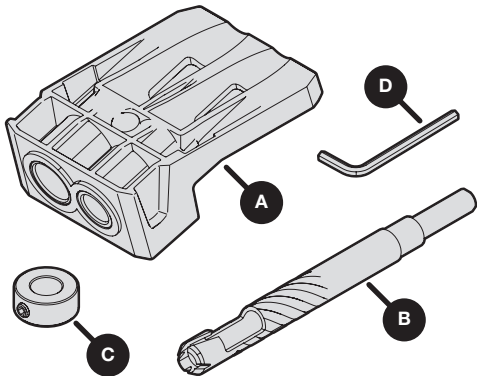
- Always wear personal protective equipment recommended by the manufacturer of the power tool you are using, such as eye, hearing, or respiratory protection.
- The drill bit is sharp. Handle with care.
- Do not allow familiarity gained from frequent use of your tools to replace safe work practices. A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

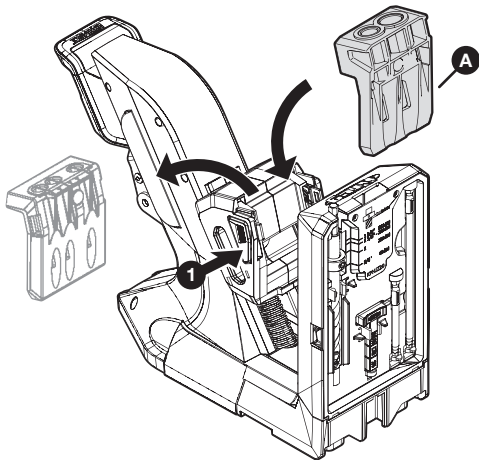
Review this section before you begin. Ensure you have all parts listed below. If any item appears missing or lost, do not use this product. Contact Technical Support or return product to place of purchase.



Part	Description
A	KPHA740 Plug Cutter Drill Guide
B	Plug Cutter Bit (for standard size pocket holes)
C	Plug Cutter Stop Collar
D	Hex Wrench

Assembly/Setup

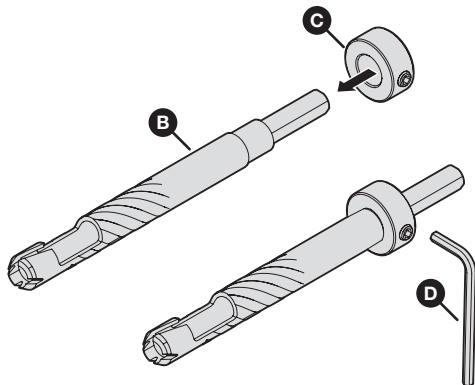
- a. Remove existing drill guide from the Kreg Jig 720 by squeezing the tabs (1) on both sides and lifting forward and up to remove the drill guide from the carriage of the Kreg Jig.
- b. Insert the Plug Cutter Drill Guide (A) into the carriage by squeezing the tabs (1) on both sides of the drill guide carriage, inserting the bottom tab of the Plug Cutter Drill Guide (A) into the slot on the Kreg Jig carriage and pressing the top of the Plug Cutter Drill Guide (A) into place.



Assembly/Setup (continued)

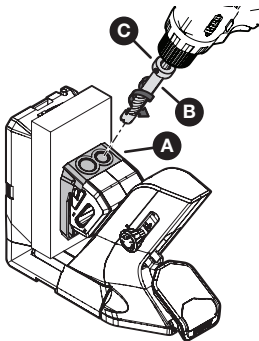
- c. Slide the Plug Cutter Stop Collar (C) onto the Plug Cutter Bit (B) until it rests on the bit shoulder. Tighten the Plug Cutter Stop Collar (C) set screw with the hex wrench (D).

Note Kreg recommends using a corded drill for drilling pocket hole plugs. Higher speeds will produce better quality pocket hole plugs, but also increase the heat produced, so it may be necessary to adjust your production rate to allow time for the bit to cool.



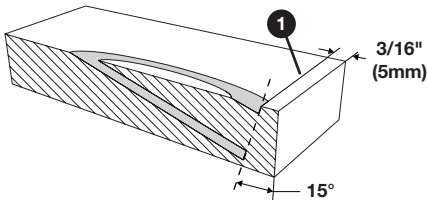
Operation – Drill the Plugs

- a. Cut the plug blanks 3-1/4" (83 mm) long in the intended direction of the plug. For best results, use leftover scraps from your project to match color and grain pattern.
- b. Set the drill on the highest speed.
- c. Clamp the blank securely in the Kreg Jig KPHJ720.
- d. Insert the Plug Cutter Bit (B) into the Plug Cutter Drill Guide (A) holding the Plug Cutter bit about 1/4" (6 mm) from the workpiece.
- e. Start the drill and let it come up to full speed. Then, using light pressure and a slow feed rate, slowly push the Plug Cutter Bit (B) until the stop collar (C) contacts the Plug Cutter Drill Guide (A).
- f. Withdraw the Plug Cutter Bit (B) from the Plug Cutter Drill Guide (A) taking care as the Plug Cutter Bit (B) may be hot.
- g. Release the clamp, reposition the blank, re-clamp securely, and repeat for each plug.



Operation – Cut the Plugs from the Blank

- Mark a line in location 1 that is $\frac{3}{16}$ " (5 mm) from the bottom edge of the plug blank.
- Apply a strip of masking tape across the plugs to keep them in position while cutting.
- Cut along the line at a 15° angle with a band saw, scroll saw, multi-purpose oscillation tool, or fine-tooth hand saw.

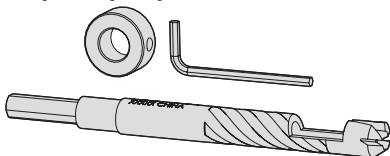


Operation – Plug the Pocket Holes

- Glue plugs in letting approximately $\frac{1}{16}$ " (2 mm) of the plug protrude.
- Once glue is dry, sand the plug flush.

Accessories

KPC1040 Kreg Micro Plug Cutting Bit



KPC1060 Kreg HD Plug Cutting Bit

