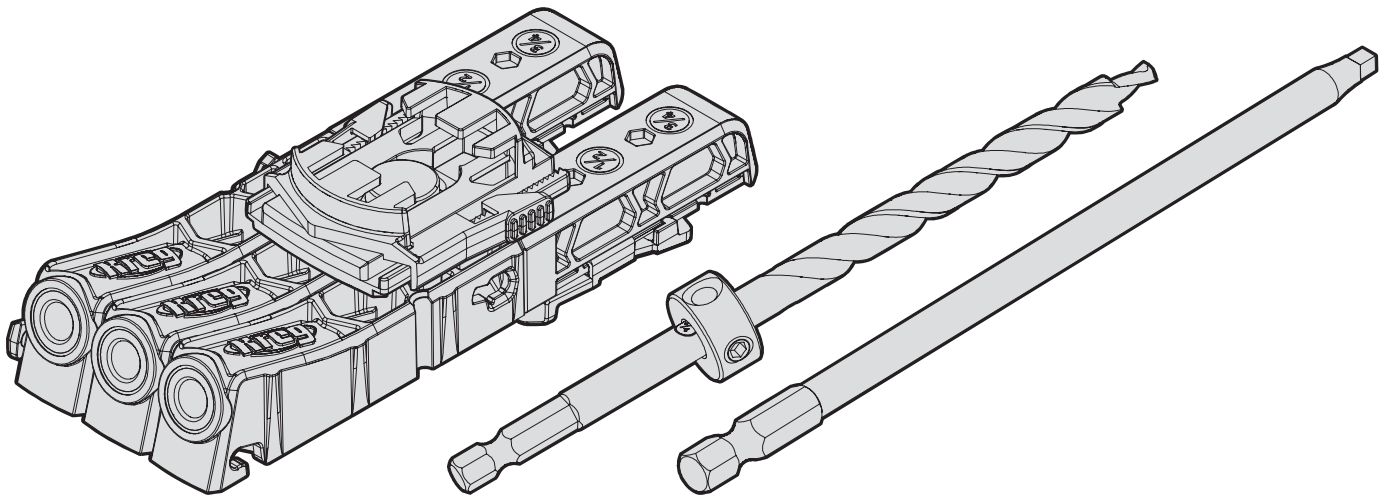


# OWNER'S MANUAL



## Micro Pocket-Hole Jig

Manual applies to Item # KPHJ230



**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.

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## Safety Precautions

**WARNING** Before using an electric 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 follow the written safety instructions for using your jig.
- Follow your drill manufacturer’s safety guidelines.
- Always wear personal protective equipment certified as such, including safety glasses, hearing and respiratory protection. When using a power tool, always follow the manufacturer’s personal protective equipment requirements.
- The drill bit is sharp. Handle with care.
- Do not attempt to hold the jig in place with your hand while drilling. Secure the jig in place with a clamp.
- 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.

**WARNING** Avoid awkward hand positions where a sudden slip could cause contact with the rotating bit.

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

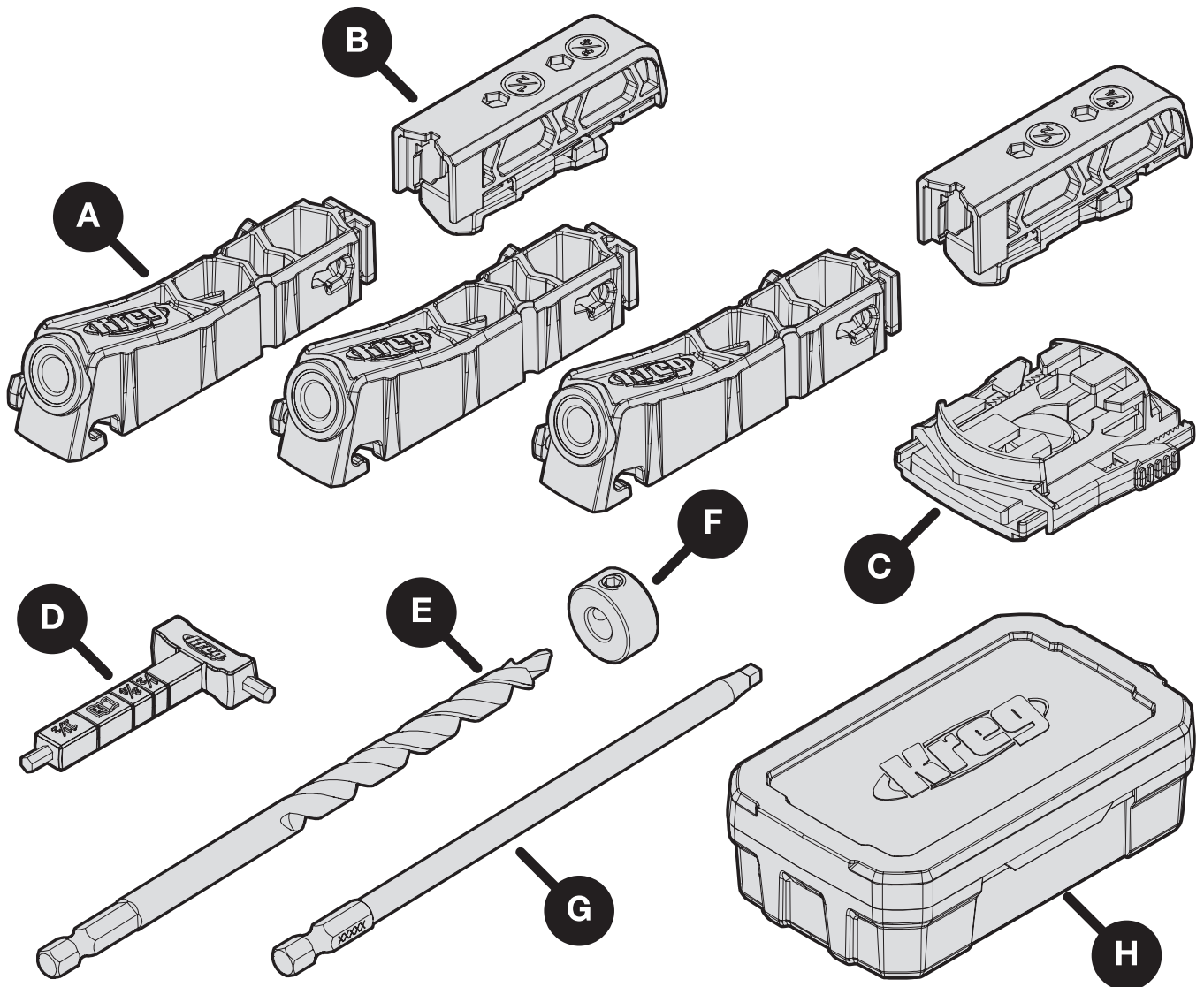
**WARNING** This product can expose you to chemicals including Acrylonitrile and other chemicals, which are known to the State of California to cause cancer and reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

**WARNING** Drilling, sawing, sanding, or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

## Pre-Assembly

Review this section before you begin. Ensure you have all tools on hand and compare the package with the items listed in the Product Description section. If any item appears missing or lost, do not use this product. Contact Technical Support or return product to place of purchase.

## Product Description



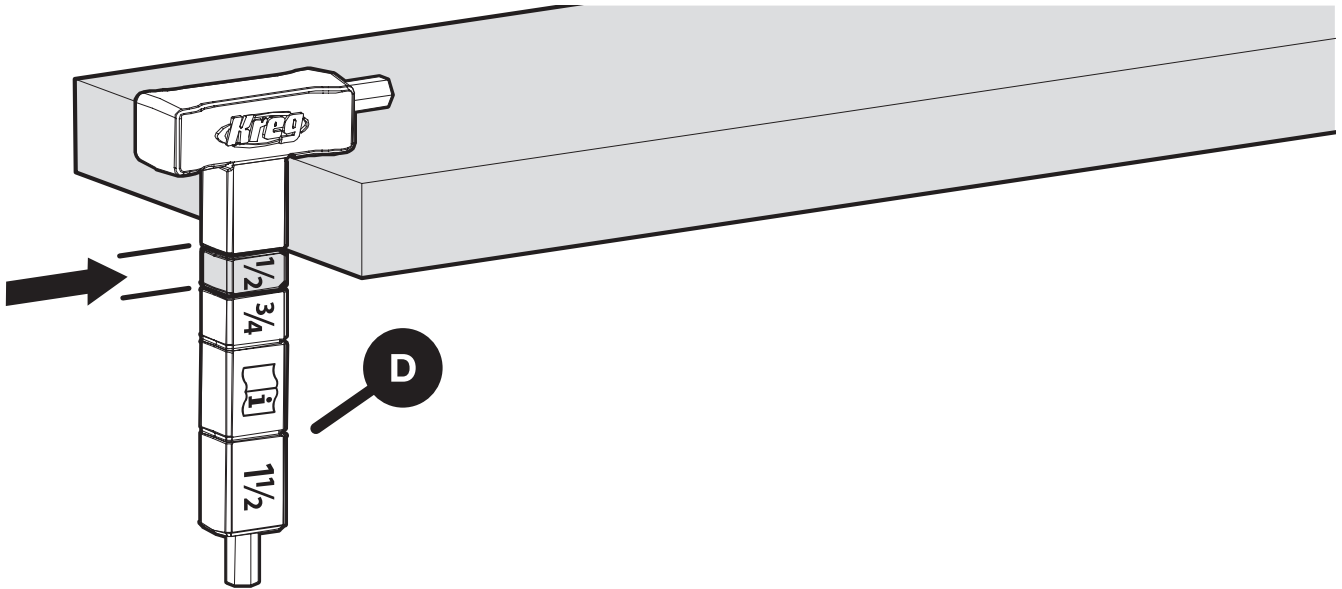
| Part | Description                              |
|------|--|
| A    | Drill guide                              |
| B    | Material thickness stop                  |
| C    | Clamp pad adapter                        |
| D    | Material thickness gauge with hex wrench |

| Part | Description          |
|------|----------------------|
| E    | Easy-set drill bit   |
| F    | East-set stop collar |
| G    | Driver bit           |
| H    | Case                 |

# Assembly

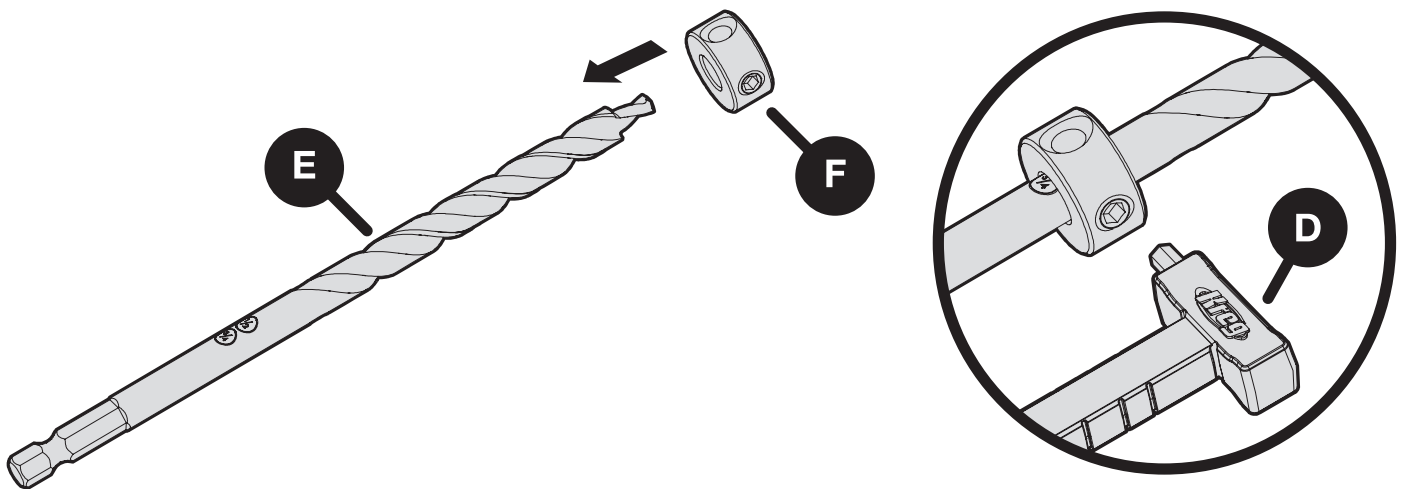
## 1 Determine the Material Thickness

- Use the material thickness gauge (D) to determine the material thickness range.



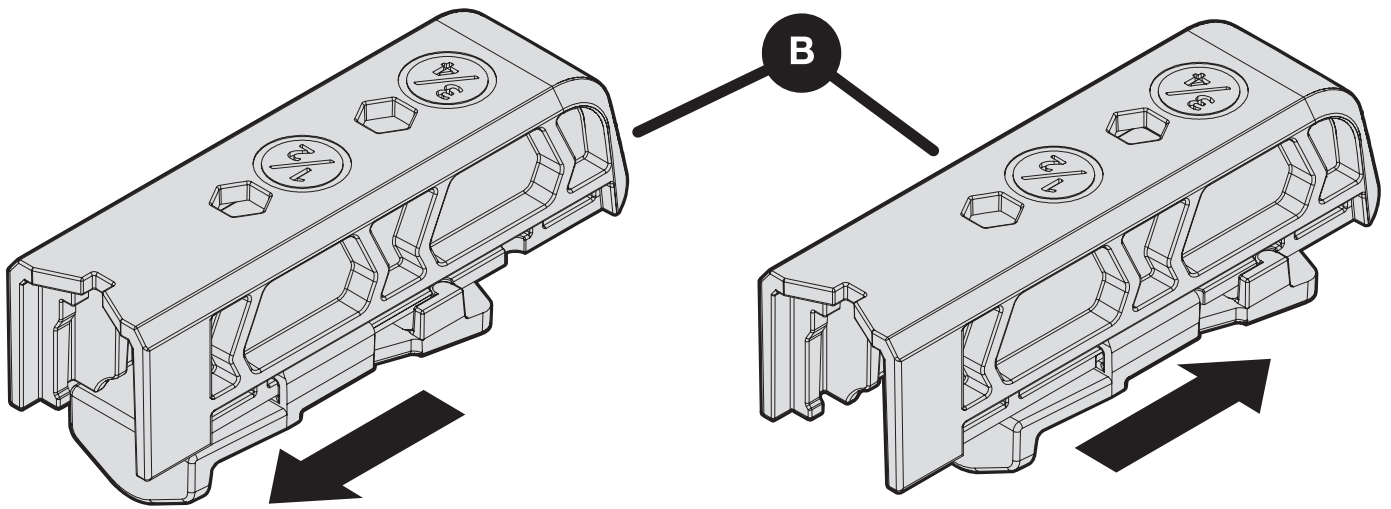
## 2 Set the Stop Collar

- Slide the easy-set stop collar (F) so the desired setting on the drill bit (E) is centered in the easy-set stop collar window.
- Tighten the easy-set stop collar (F) with the hex wrench (D).



### 3 Position the Material Thickness Stop

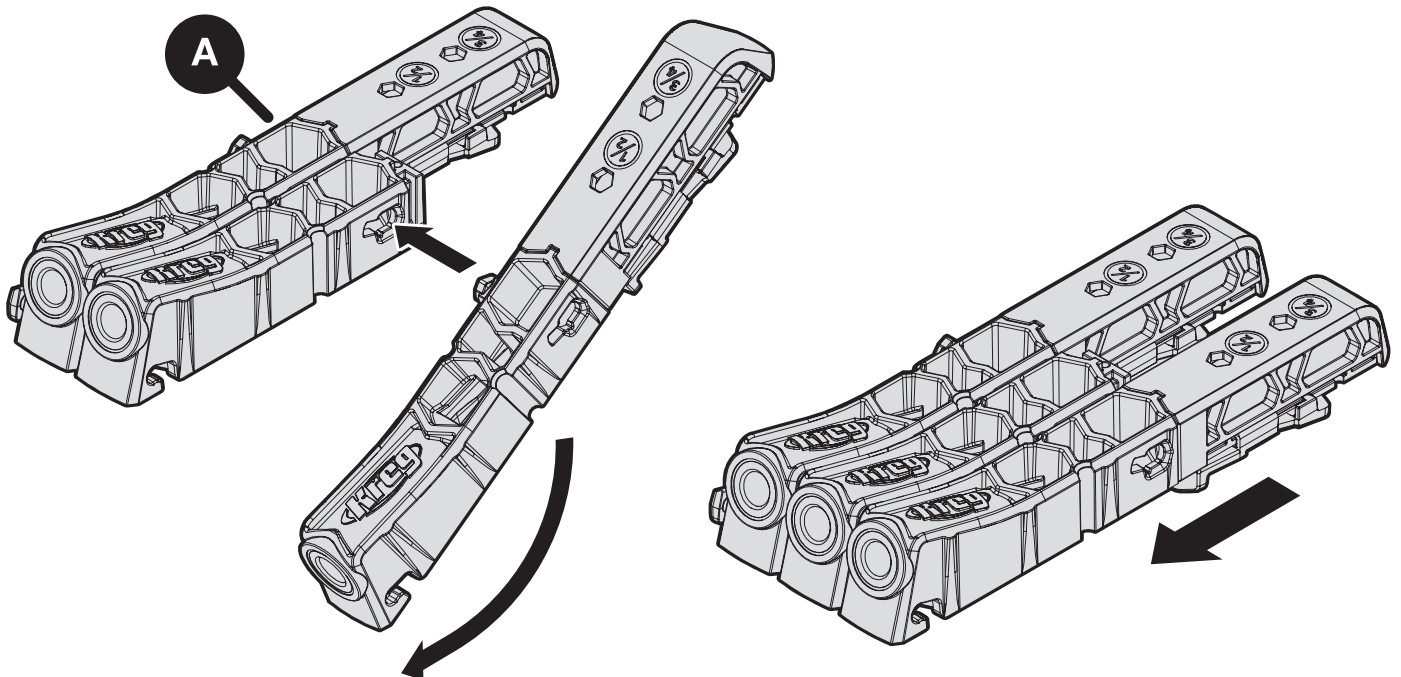
- a. Push and slide the material thickness stop (B) to the desired setting.



### 4 Configure the Jig

- a. Insert and rotate the drill guide (A) into the other drill guide.
- b. Slide the drill guide forward to join.

**Note** To remove, pull back and rotate the drill guide to separate.

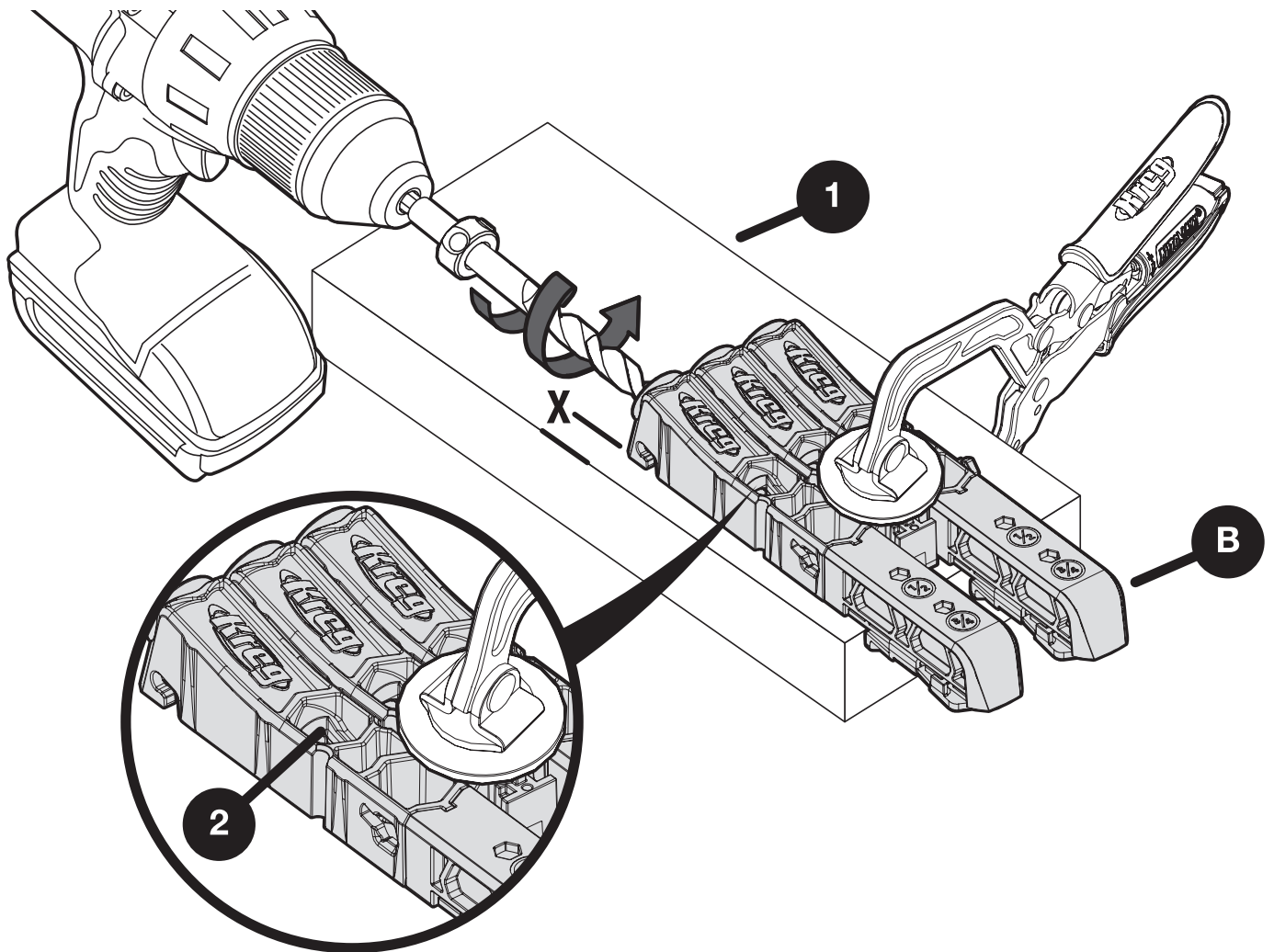


# Operation

## 5 Clamp the Jig and Drill the Holes

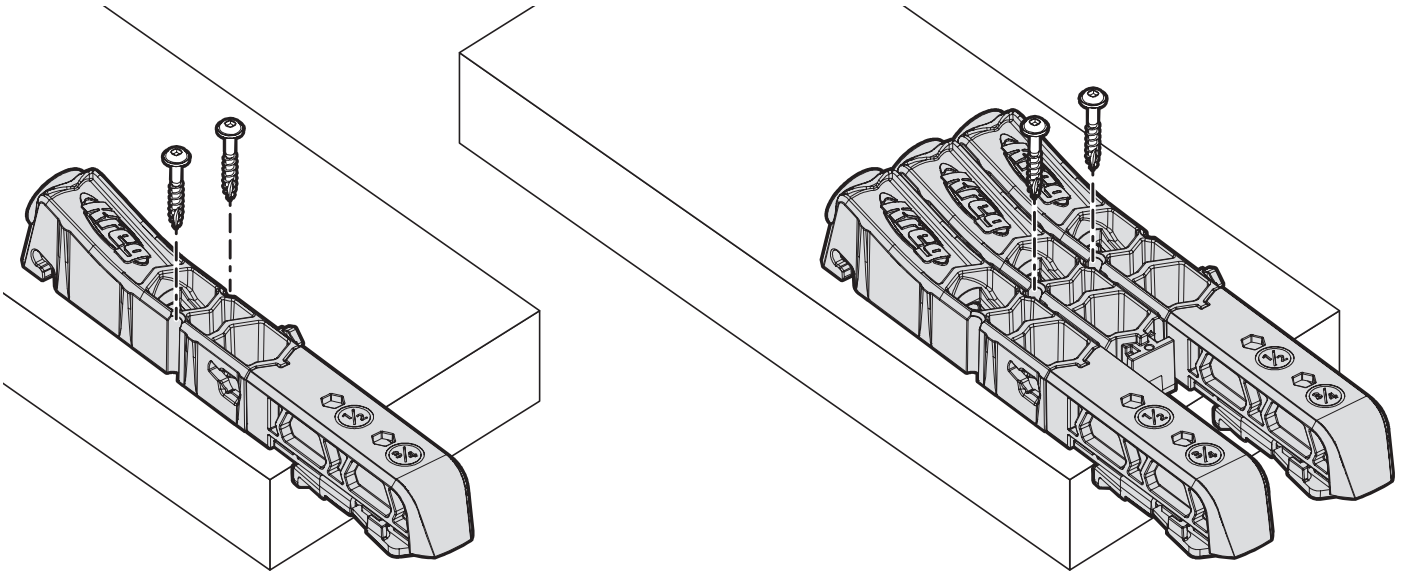
- a. Align the material thickness stop (B) to the edge of the workpiece (1).
- b. Clamp the jig to the piece.
  - Note** Do not block the chip ejection hole (2).
- c. Drill the pocket hole.

**Tip** Place pocket holes at the recommended distance from edge (X) of the workpiece. See next section for recommendations.



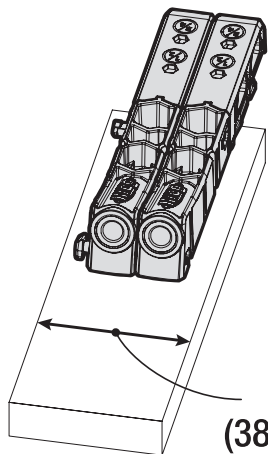


**Tip** If you cannot use a clamp, secure the jig with screws in the screw recesses.

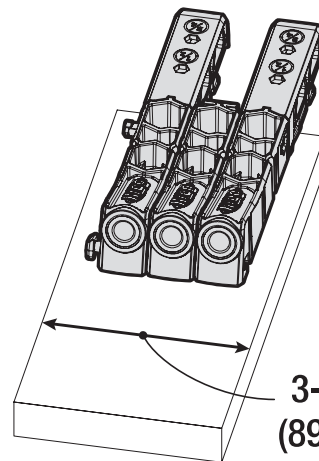


## Recommended Hole Spacing Configurations

### Narrow Pieces



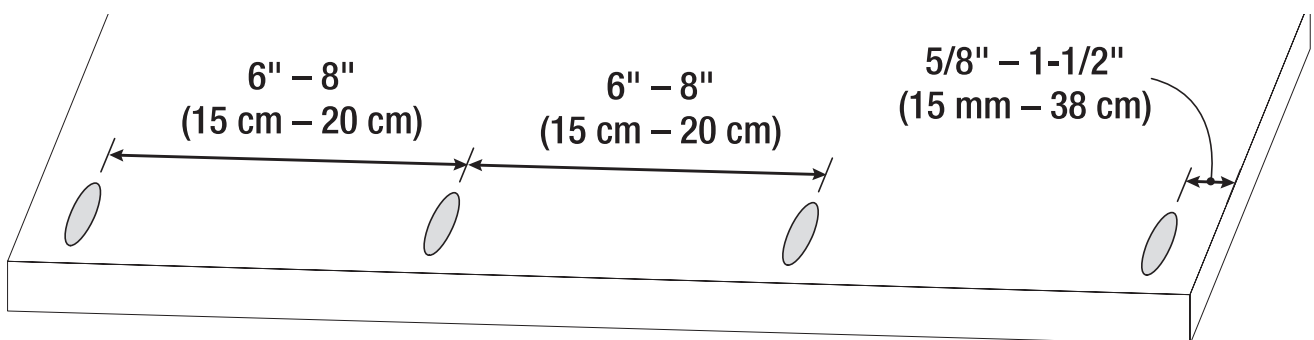
1-1/2" – 2"  
(38 mm – 51 mm)



3-1/2"  
(89 mm)

### Wide Pieces

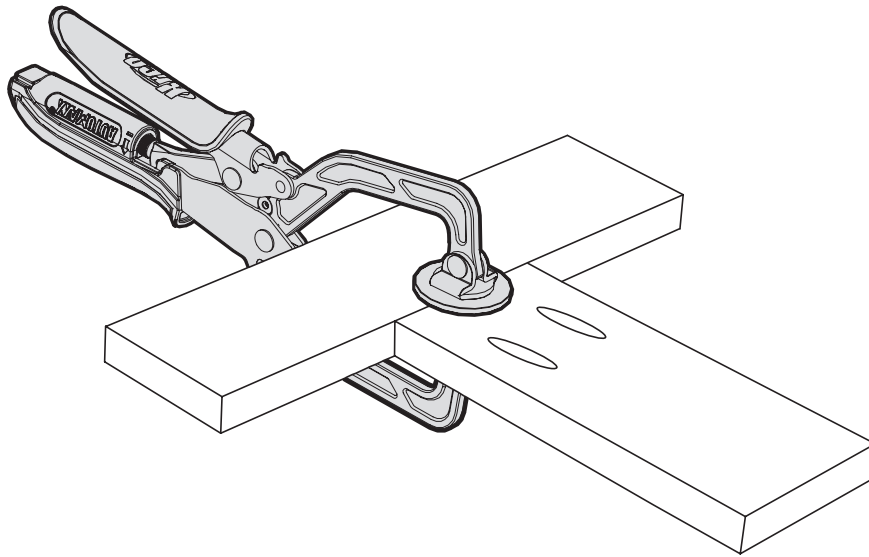
Place pocket holes 5/8" to 1-1/2 in. from edge, then every 6-8 in.



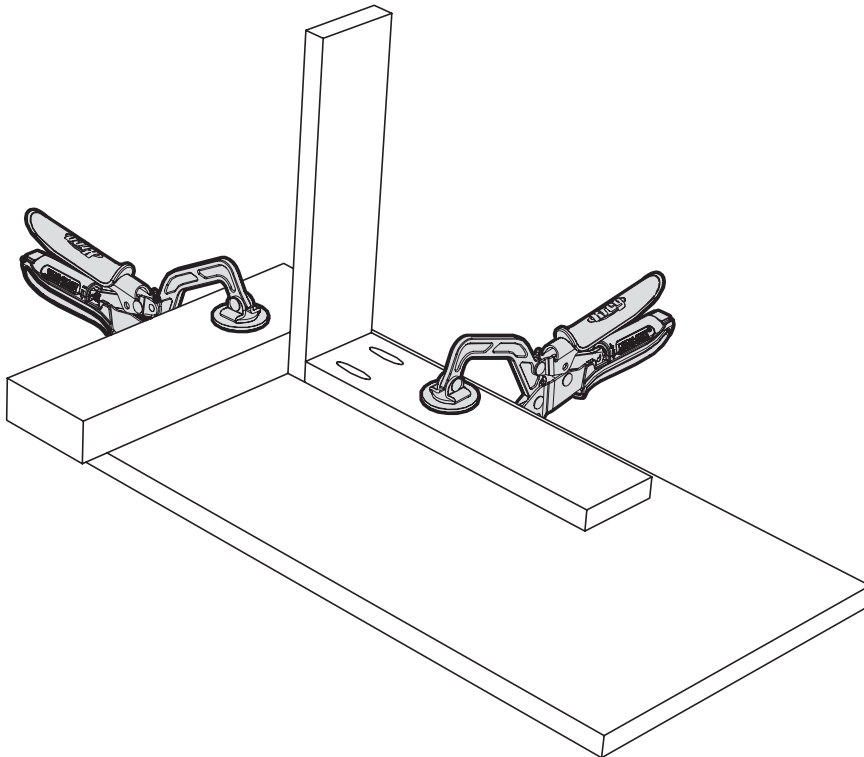
## 6 Clamp the Joint in Place

**Note** Clamping secures the workpieces and gives you a better finished joint.

a. Clamp here for the face joint.



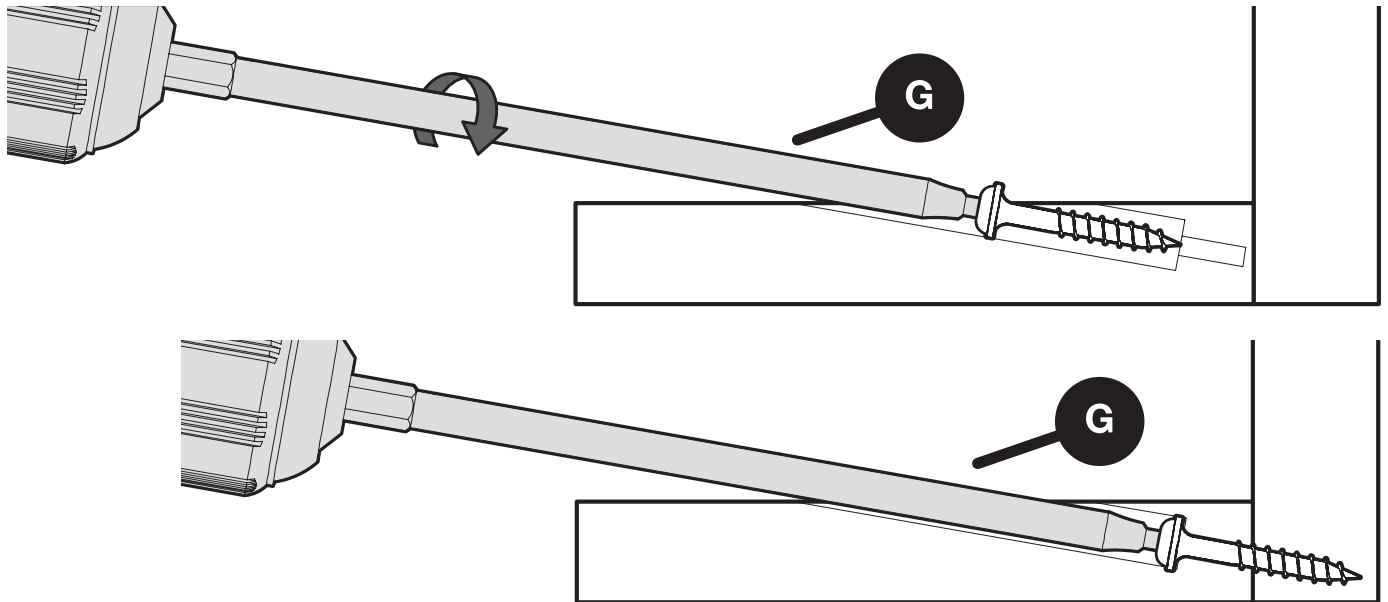
b. Clamp here for the edge joint.





## 7 Drive the Screws

- Place a screw on the driver bit (G).
- Position the screw in the pilot hole.
- Drive the screw until fully seated without over driving the screw.



## Set-Up and Screw Length Chart For Kreg Screws

| Material Thickness | Easy-Set Stop Collar | Material Thickness Stop | Screw Length   |
|--------------------|----------------------|-------------------------|----------------|
| 1/2"               | 1/2"                 | 1/2"                    | 3/4" (19 mm)   |
| 3/4"               | 3/4"                 | 3/4"                    | 1-1/4" (32 mm) |

**Note** Use only SPS style head screws.

**Note** The recommended screw length is 3/4" (19 mm), but in some slightly thicker materials a 1" (25 mm) screw could be used for increased holding power.

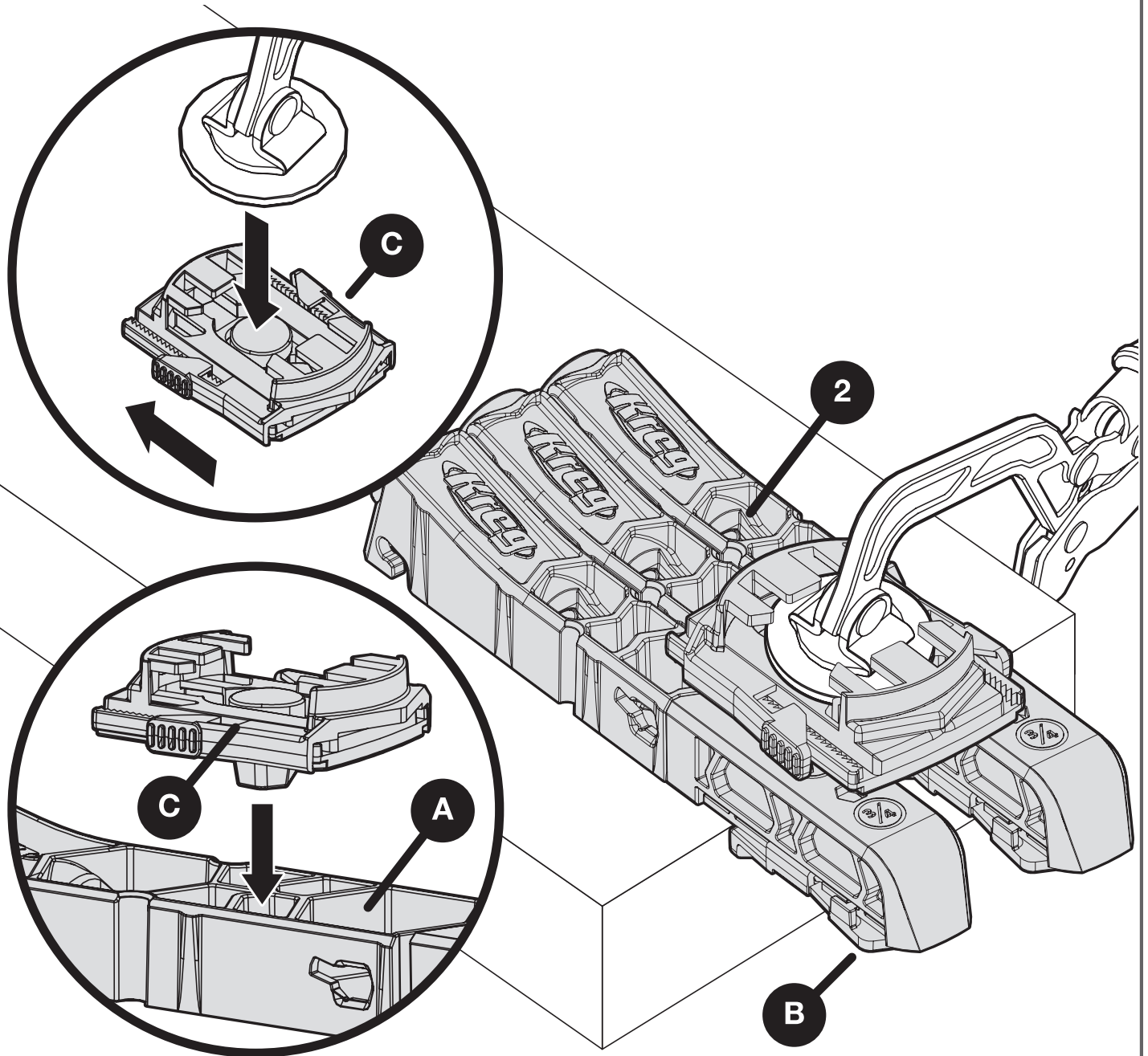
To learn more about selecting and purchasing Kreg Screws, visit: [www.kregtool.com/screws](http://www.kregtool.com/screws).

## Using the Clamp Pad Adapter

The clamp pad adapter connects the jig to the clamp.

- a. Position the clamp in the adapter (C) and slide closed.
- b. Seat the rubber anchor of the adapter (C) in the drill guide (A) as indicated in section view below.

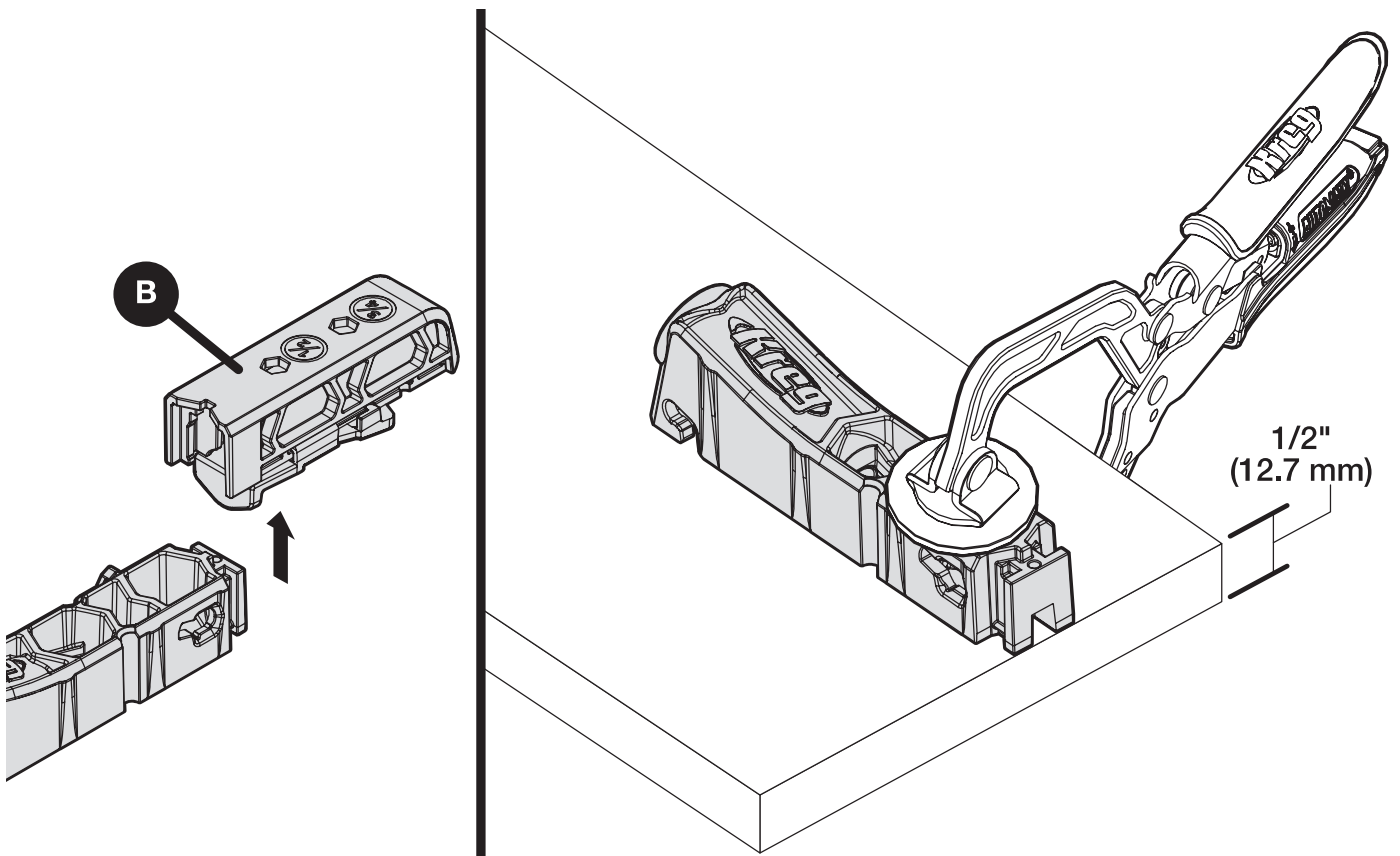
**Note** Do not block the chip ejection hole (2).



## Using the Jig for Repair Applications

- a. Remove the material thickness stop (B).
- b. Position the jig on the workpiece.
- c. Clamp and drill the pocket-holes.

**Note** The position of the stop collar on the drill bit does not change.



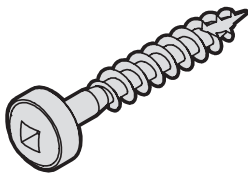
## Care and Cleaning

To clean, remove any wood chips and wipe clean with a soft, damp cloth.

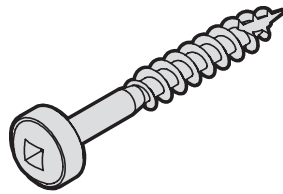
## Troubleshooting

Contact Technical Support or see the website for FAQs.

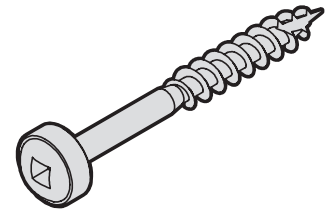
## Accessories



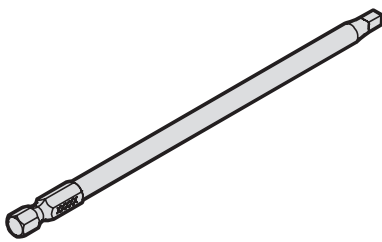
Kreg 3/4" Zinc Pocket-Hole screw  
#(SPS-F075-100)



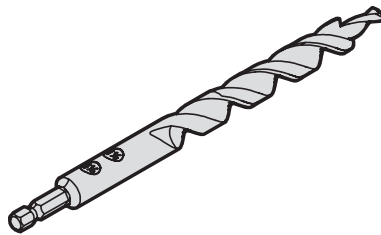
Kreg 1" Zinc Pocket-Hole  
Screws  
(#SPS-F1-100,  
#SPS-C1-100)



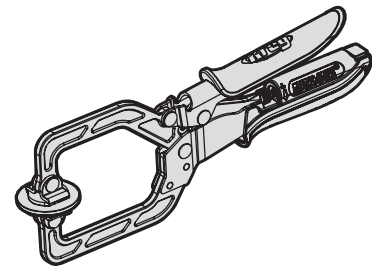
Kreg 1-1/4" Zinc Pocket-Hole  
Screws  
(#SPS-F125-100,  
#SPS-C125-100)



Kreg Square Driver Bit  
(#D6)



Kreg Micro Easy-set  
Drill Bit  
(#KPHA540)



Kreg Wood  
Project Clamp  
(#KHC3)



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