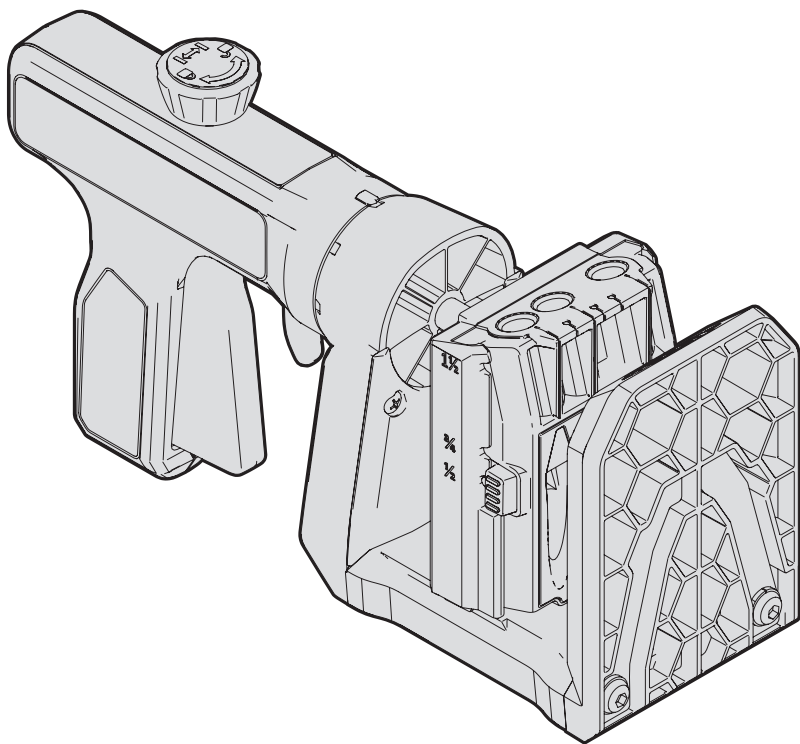


# OWNER'S MANUAL



## Kreg Pocket-Hole Jig 500-Series

Manual applies to all 500-Series Pocket-Hole Jigs



**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](mailto:technicalsupport@kregtool.com)

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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.

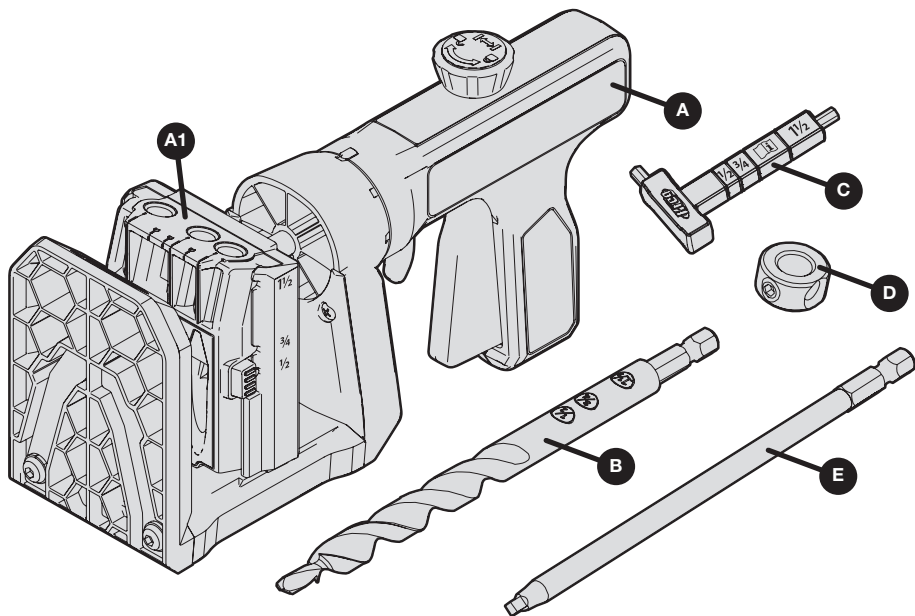
**WARNING** Do not operate this tool or any machinery while under the influence of drugs, alcohol, or medications.

**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](http://www.P65Warnings.ca.gov).

# Pre-Operation

Review this section before you begin. Ensure you have all tools/materials on hand and compare the package with the items listed in the Hardware Included and Product Description sections. 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	KPHJ520 Pocket-Hole Jig A1-Drill Guide with GripMaxx™ anti-slip surface
B	Easy-set pocket-hole drill bit
C	Material thickness gauge/Hex wrench

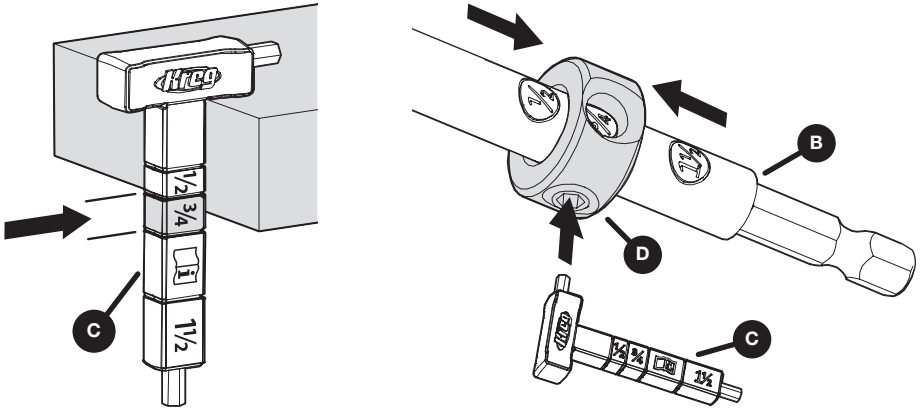
Part	Description
D	Easy-set stop collar
E	6" Driver bit

**Note** This product may include sample screws and a clamp, depending upon the model you have purchased.

# Operation - Drilling Your First Pocket Hole

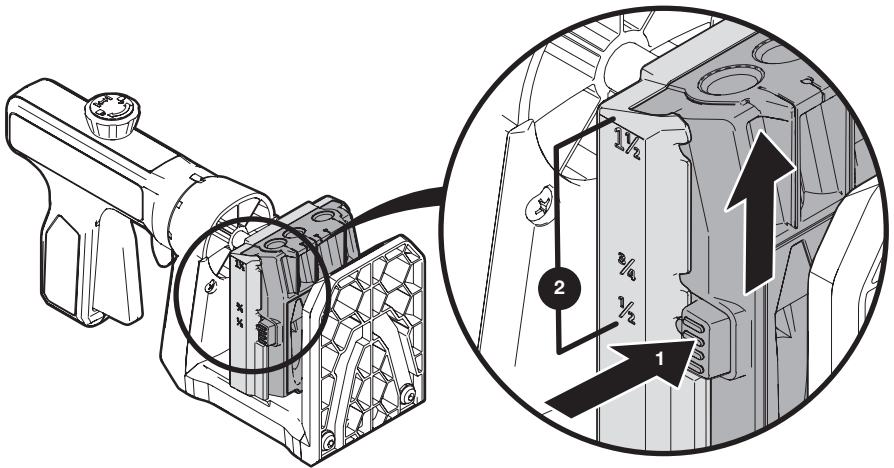
## 1 Determine the Material Thickness and Set the Stop Collar

- 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

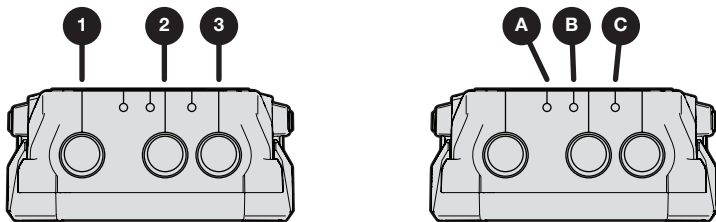
Adjust the drill guide by pressing both tabs (1) on the guide and sliding it to the measurement setting (2) that corresponds with your material measurement.



### 3 Position Your Workpiece

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

- Align the center line of any pocket-hole guide (numbers 1, 2, or 3) with the desired location on your workpiece. For wider panels (over 3-1/2" wide) pocket holes should be placed 5/8" to 1-1/2" from each edge of the workpiece and then every 6" to 8".
- Use the board centering marks (letters A, B, or C) to center two pocket holes on the workpiece ranging in width from 1-1/4" to 3-1/2" wide. See the table below for details on each size range.

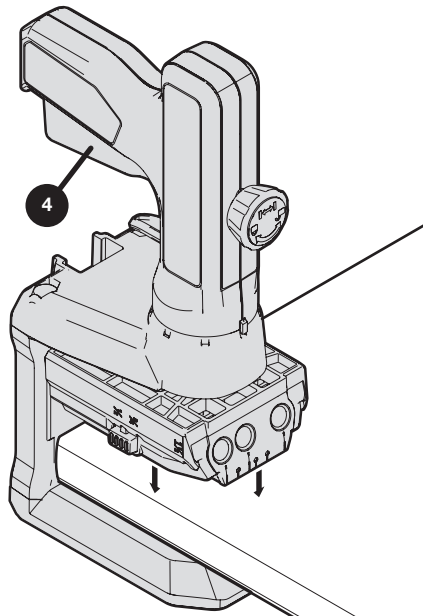
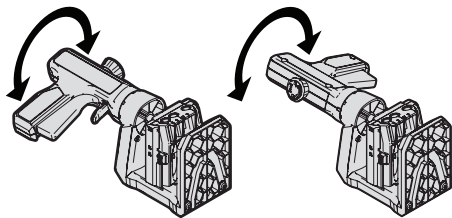


Board Width	Center Mark	Drill Guide
1-1/4" to 1-3/4"	C	2 and 3
1-3/4" to 2-3/8"	A	1 and 2
2-3/8" to 3-1/2"	B	1 and 3

- Place your workpiece in the jig and squeeze the handle (4) repeatedly to clamp your workpiece securely into the jig. Proceed to the **Operation - Drilling and Driving Pocket-Hole Screws** section to start drilling.

**Tip** To drill pocket holes on similar workpieces at a faster pace, see the **Using the Quick Reset Feature** section of the manual.

**Tip** The handle can be rotated to provide a comfortable hand position.

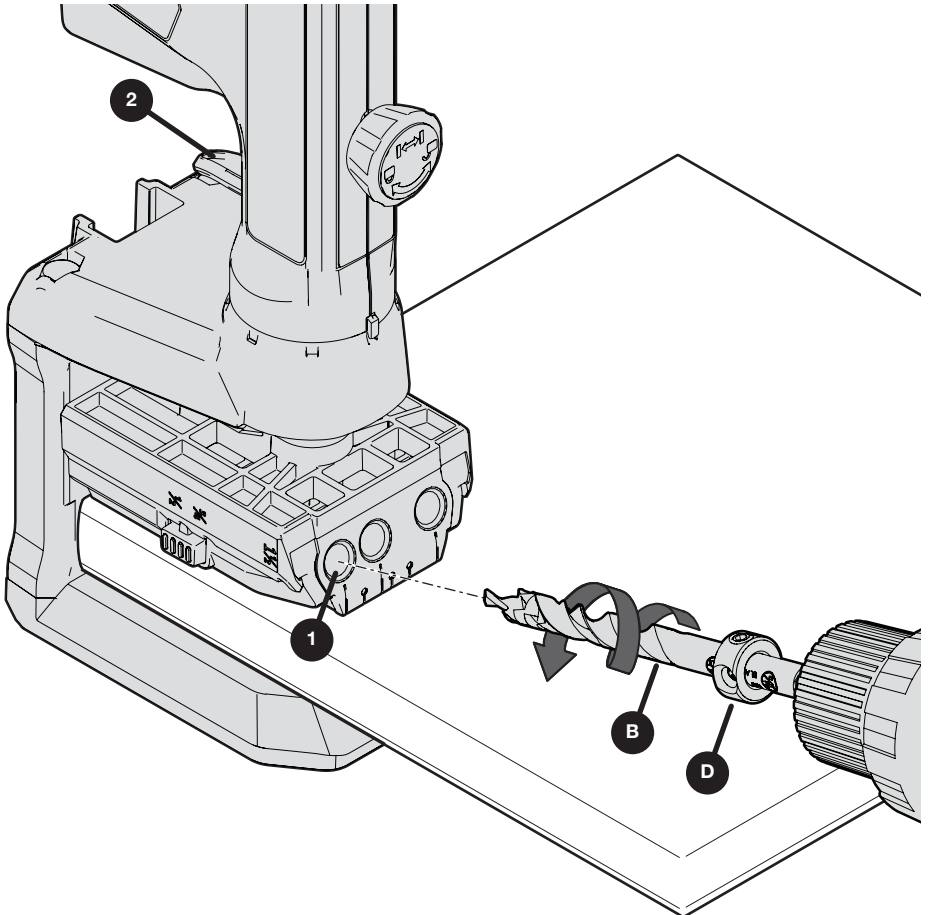


# Operation - Drilling and Driving Pocket-Hole Screws

## 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 remove your workpiece.




## 2 Drive Screws

- a. 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)

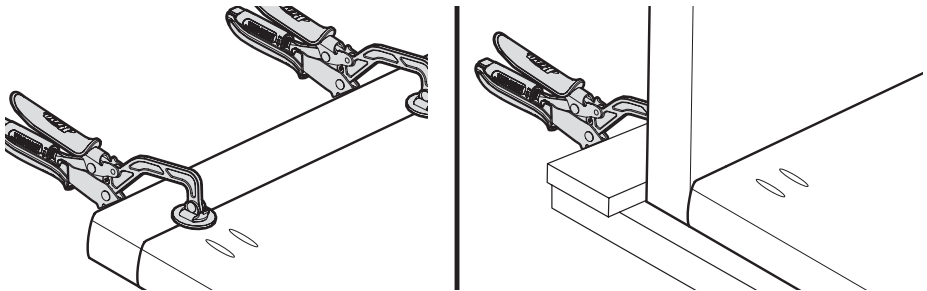
For more information on screw selections, go to [www.Kregtool.com/Screws](http://www.Kregtool.com/Screws) or simply scan the QR code on the side of your sample screw package.

**Tip** A 1" screw is recommended for most applications, but if your workpiece is on the low end of the range, a 3/4" screw might be required to keep the screw tip from protruding.

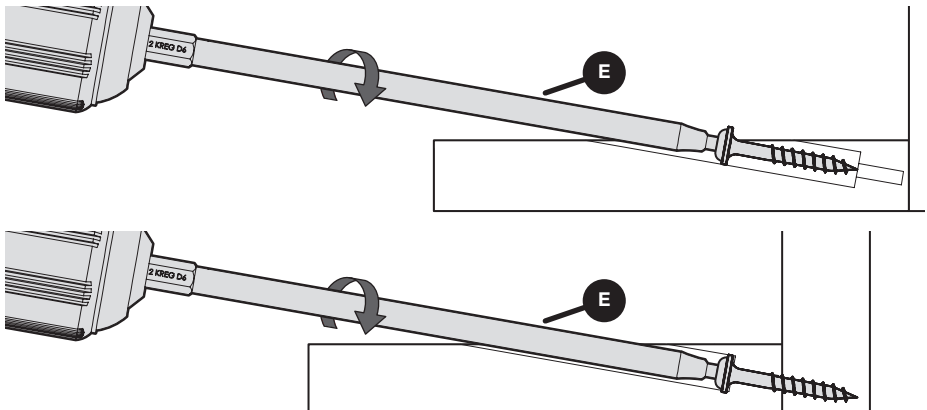
**Note** If your material thickness falls in the  range, use the same setup techniques as the 3/4" range with a 1-1/2" screw.

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

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



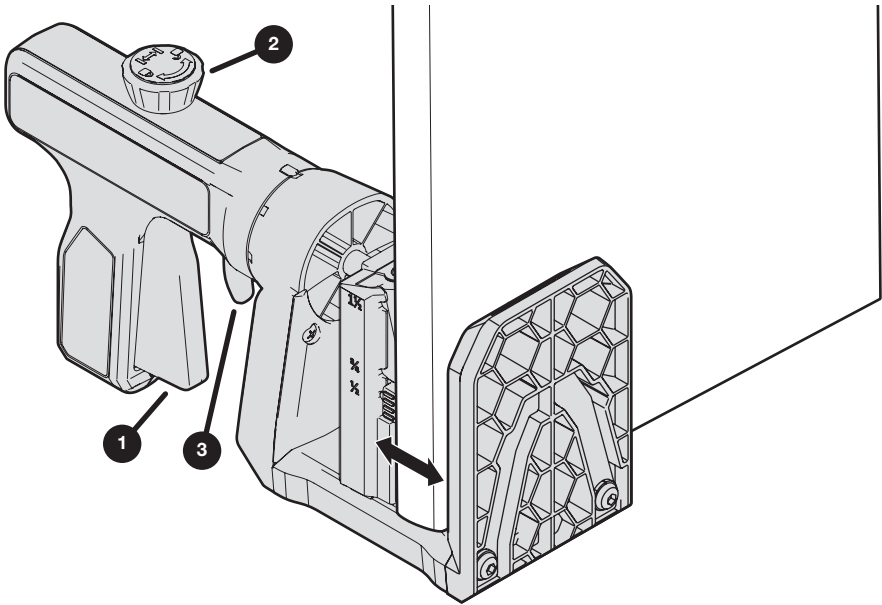
- c. Place your screw on the driver tip (E), position the screw in the pocket hole, and drive the screw until it is fully seated without overdriving.



## Using the Quick Reset Feature

The Quick Reset feature allows you to drill pocket holes on multiple similar workpieces by limiting the back and forth movement of the clamp for a faster clamp and release of your workpiece. To use the Quick Reset feature:

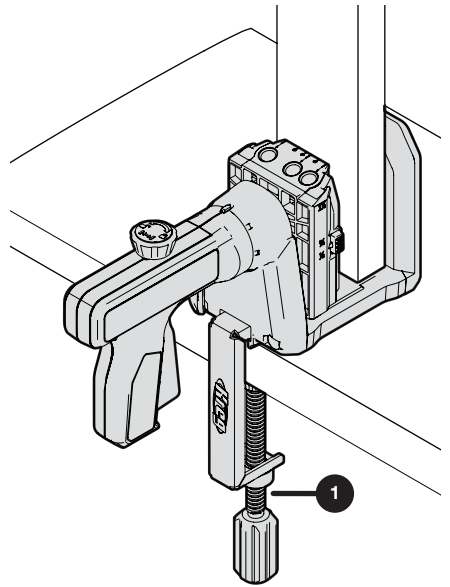
- a. Squeeze the handle (1) to clamp your workpiece securely in the jig.
- b. Tighten the knob (2) by hand until it is tight.
- c. Drill your pocket holes.
- d. Pull the drill guide release (3) to move the clamp back just enough to release the workpiece.
- e. Align to your next hole location and squeeze the handle (1) two or three times to quickly re-clamp.
- f. Once finished with your similarly-sized workpieces, loosen the knob (2) and pull the drill guide release (3) to return the clamp to its maximum opening.





## Using Your Kreg Jig

- a. Your Kreg Jig has been designed to work in different orientations. You may find it more comfortable to work with your Kreg Jig placed with the end of the work surface and the handle up in the air.
- b. You can secure the jig in place on your workbench using the Pocket-Hole Jig Clamp (1) at the bottom of the jig.



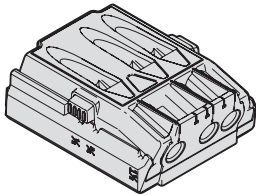
## Care and Cleaning

Periodically clean your tool by vacuuming any chips and wood dust.

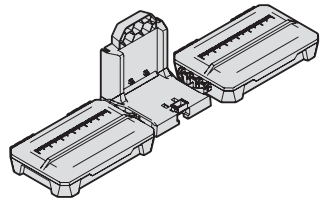
Keep GripMaxx™ anti-slip surface clean and free of dust by wiping with a damp cloth.

## Accessories

KPHA530 Kreg Micro Drill Guide



KPHA750 Pocket-Hole Jig Docking Station



KPHA760 Kreg Bench Clamp

