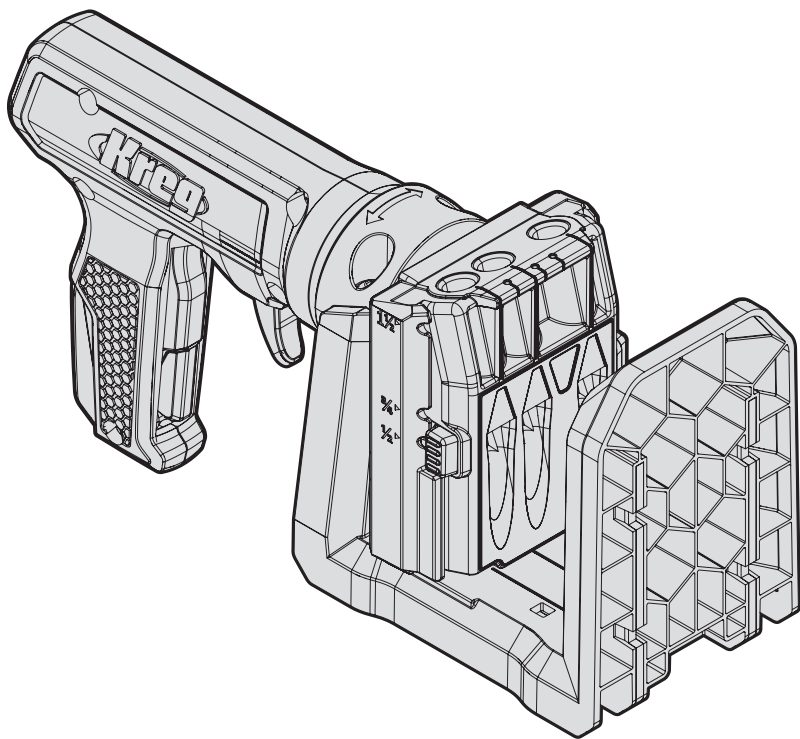


OWNER'S MANUAL



Kreg Pocket-Hole Jig 520PRO2



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 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.

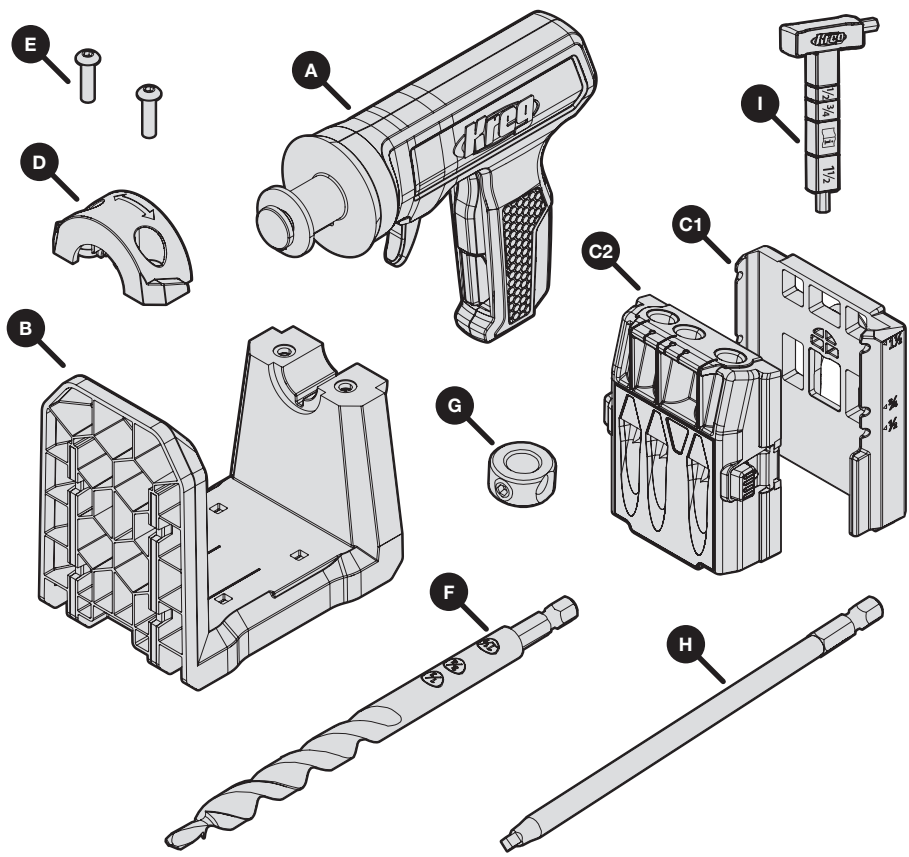
WARNING Do not operate this tool or any machinery while under the influence of drugs, alcohol, or medications.

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-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

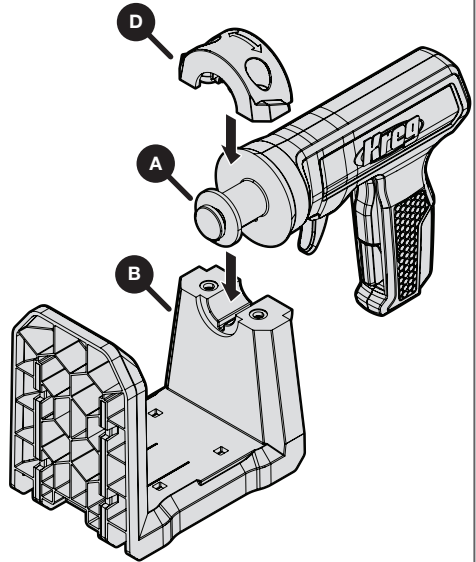


Part	Description
A	KPHJ520 Pocket-Hole Jig handle
B	KPHJ520 Pocket-Hole Jig base
C1	Drill Guide holder
C2	Drill Guide with GripMaxx™ anti-slip surface
D	Collar

Part	Description
E	Screw
F	Easy-set pocket-hole drill bit
G	Easy-set stop collar
H	6" Driver bit
I	Material thickness gauge/Hex wrench

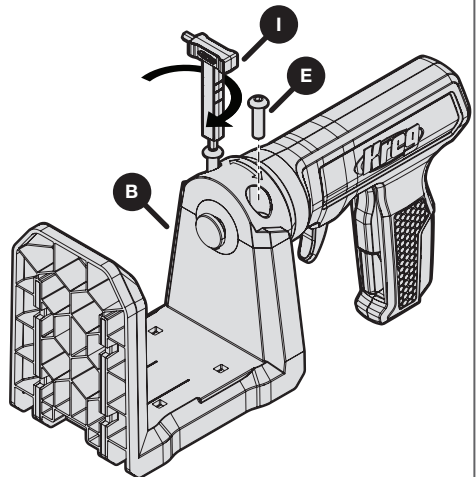
1 Assemble the Jig Handle and Jig Base

- a. Place the pocket-hole jig handle (A) in the pocket-hole jig base (B).
- b. Place the collar (D) over the pocket-hole jig handle (A), aligning the holes on the collar (D) with those on the pocket-hole jig base (B).



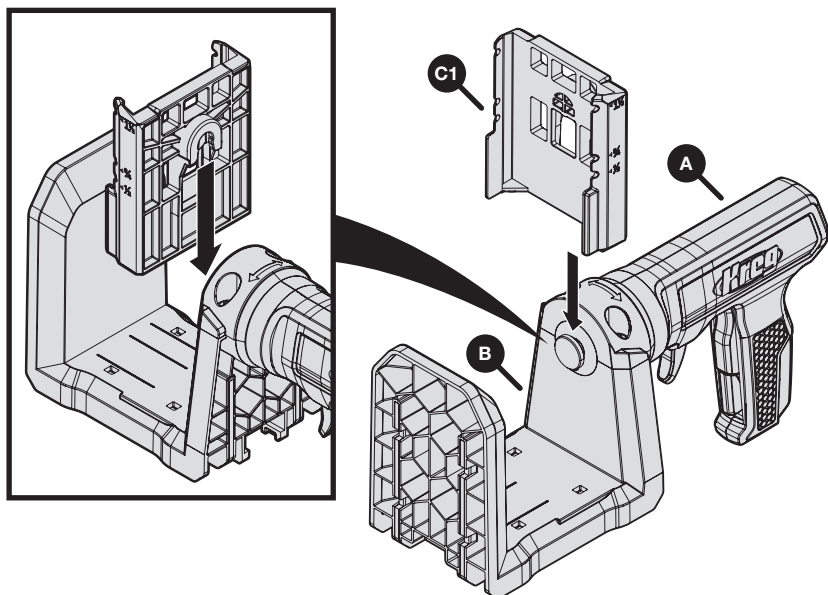
2 Secure the Collar to the Jig Base

- a. Insert screws (E) into the holes on the collar to attach to the Pocket-Hole Jig Base (B).
- b. Tighten the screws using the material thickness gauge/hex wrench (I).

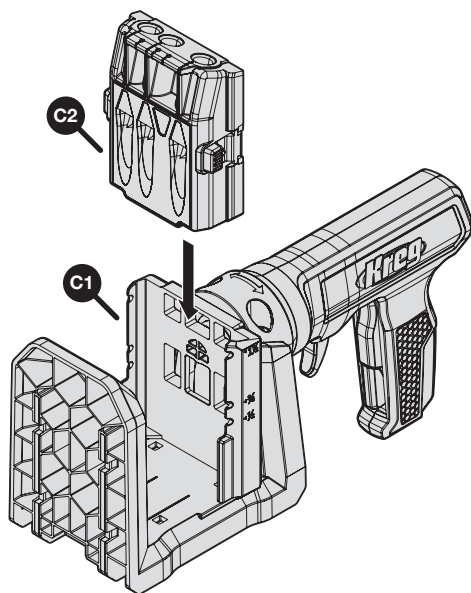


3 Attach the Drill Guide to the Jig Base

- a. Slide the drill guide holder (C1) onto the metal rod extending from base (B) until it snaps into place.



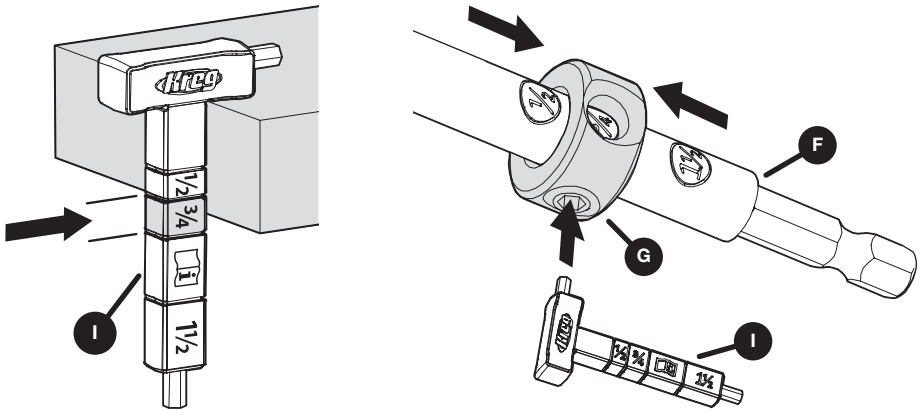
- b. Slide the drill guide (C2) into the drill guide holder (C1).



Operation - Drilling Your First Pocket Hole

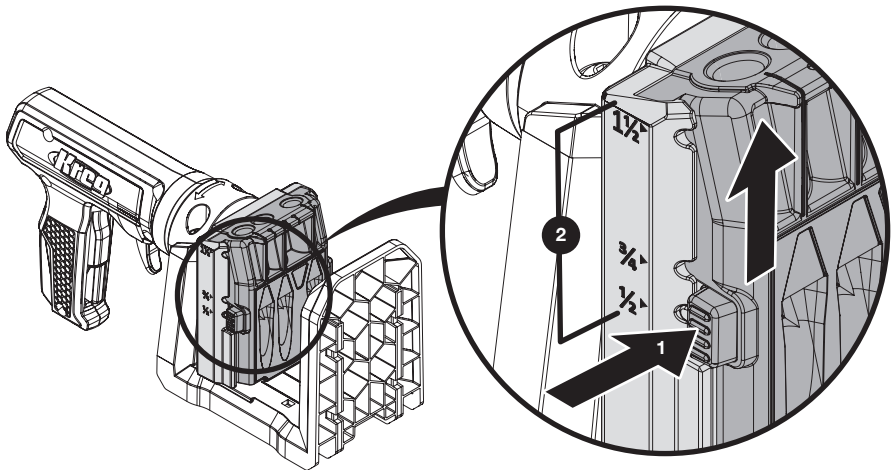
1 Determine the Material Thickness and Set the Stop Collar

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



2 Adjust the Drill Guide

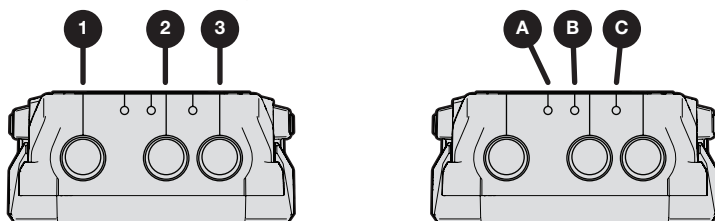
Adjust the drill guide by pressing both tabs (1) on the guide and sliding it to the measurement setting (2) that corresponds with your material measurement.



3 Position Your Workpiece

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

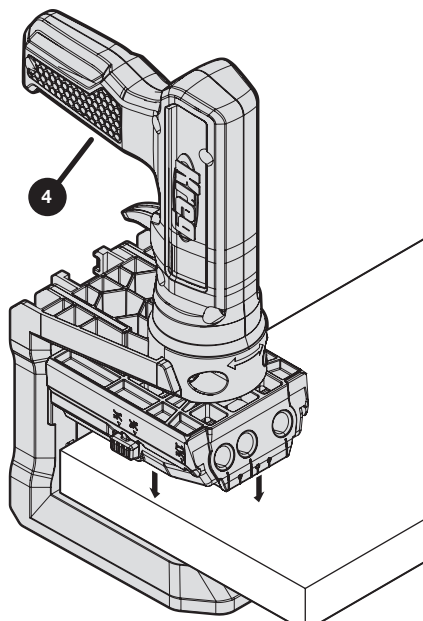
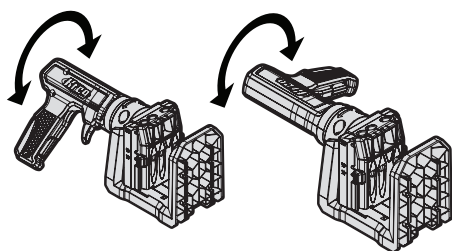
- a. Align the center line of any pocket-hole guide (numbers 1, 2, or 3) with the desired location on your workpiece. For wider panels (over 3-1/2" wide) pocket holes should be placed 5/8" to 1-1/2" from each edge of the workpiece and then every 6" to 8".
- b. Use the board centering marks (letters A, 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

- c. 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 The handle can be rotated to provide a comfortable hand position.

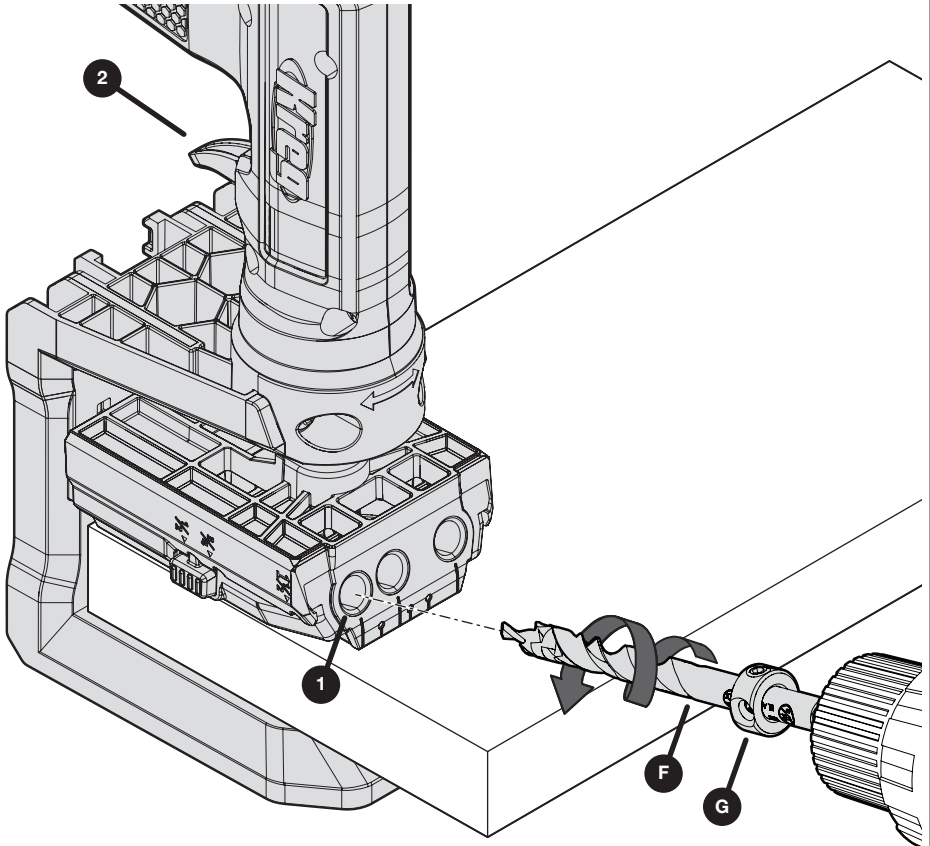


Operation - Drilling and Driving Pocket-Hole Screws

1 Drill Pocket Holes

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

- a. Place your prepared drill bit (F) with stop collar (G) into your drill.
- b. 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.
- c. Drill until the stop collar (G) stops going any deeper due to contact between the stop collar (G) and drill guide (1). Remove the drill bit (F) from the drill guide while the drill bit is still rotating.
- d. When done drilling pocket hole(s), pull the trigger (2) to release the clamping pressure and remove your workpiece.



2 Drive Screws

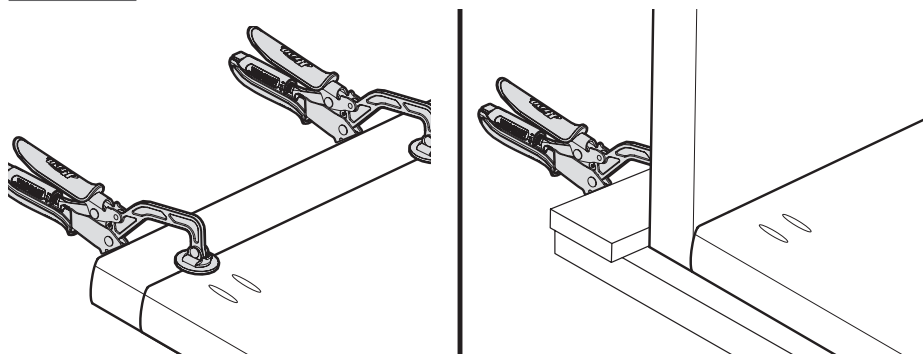
- a. Ensure you are using the correct screw size according to this chart:

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)

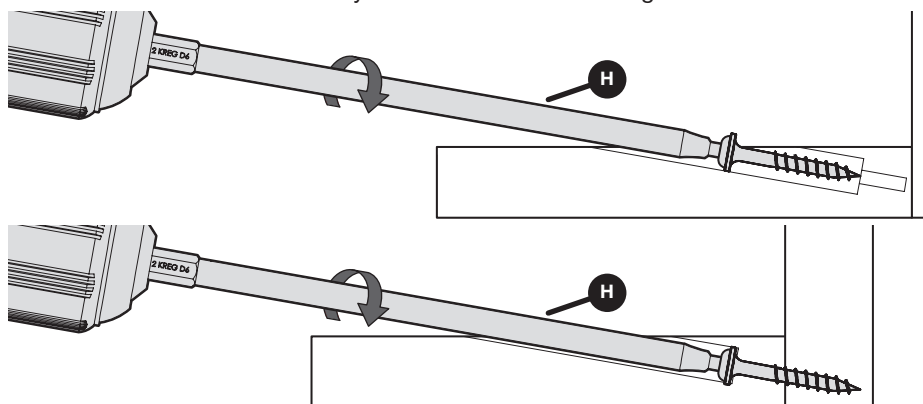
* A 1" screw is recommended for most applications, but if your workpiece is on the low end of the range, a 3/4" screw might be required to keep the screw tip from protruding.

- 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 (H), position the screw in the pocket hole, and drive the screw until it is fully seated without overdriving.





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