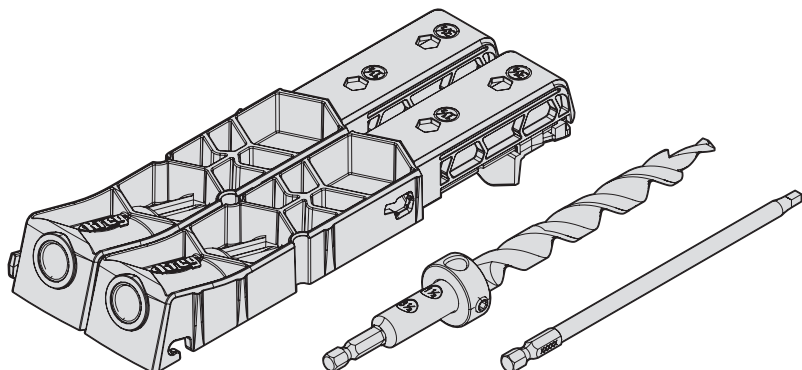


OWNER'S MANUAL



Pocket-Hole XL Jig

Manual applies to Item # KPHJ920



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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English 2

French 13

Spanish 25

Table of Contents

Safety Precautions	2	Tips	8
Pre-Assembly	3	Using the Clamp Pad Adapter	8
Product Description	3	Using the Jig for Repair Applications	9
Assembly	4	Using the Jig for Mitered Corners	9
Operation	5	Using the Jig for Railings.	10
Recommended Hole Spacing	6	Care and Cleaning	11
Set-Up and Screw Length Chart.	7	Troubleshooting.	11
		Accessories.	11

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 blade.

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

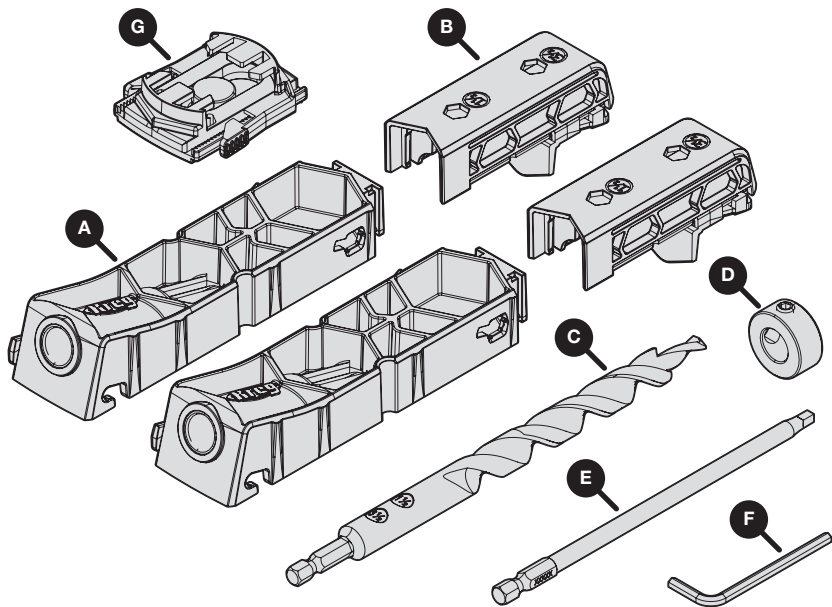
WARNING This product can expose you to chemicals including Acrylonitrile and other chemicals, which are known to the State of California to cause cancer and reproductive harm. For more information go to www.P65Warnings.ca.gov.

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.

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

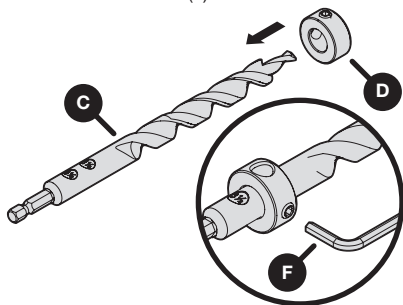


Part	Description
A	Drill guide
B	Material thickness stop
C	Easy-set drill bit
D	Easy-set stop collar

Part	Description
E	Driver bit
F	Hex wrench
G	Clamp pad adapter

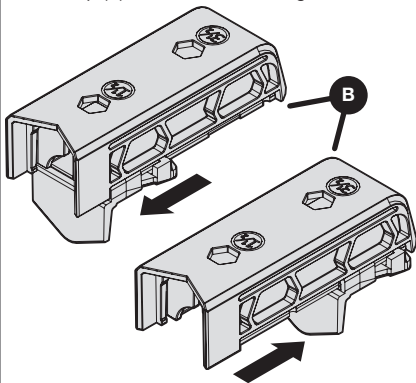
1 Set the Stop Collar

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



2 Position the Material Thickness Stop

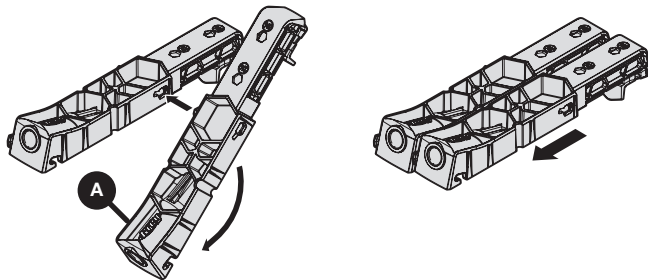
- Push and slide the material thickness stop (B) to the desired setting.



3 Configure the Jig

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

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

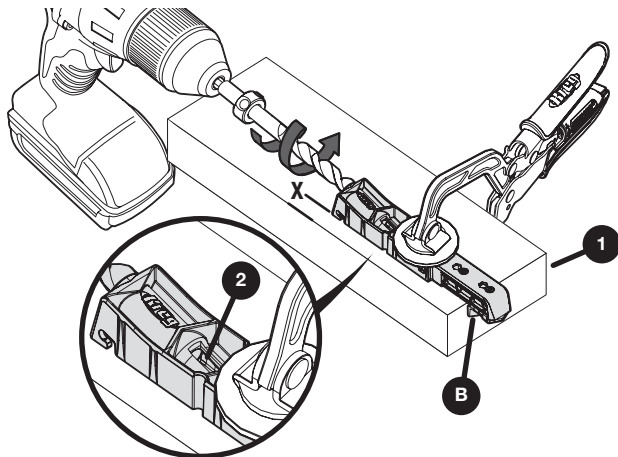


1 Clamp the Jig and Drill the Holes

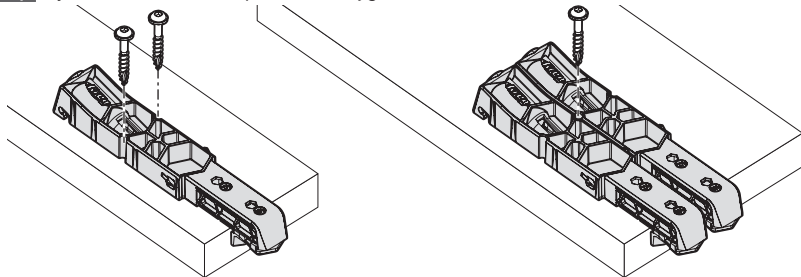
- a. Align the material thickness stop (B) to the edge of the workpiece (1).
- b. Clamp the jig to the piece.
- c. Drill the pocket hole.

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

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



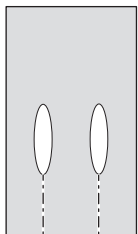
Tip If you cannot use a clamp, secure the jig with screws in the screw recesses.



Recommended Hole Spacing

2x4 or 4x4

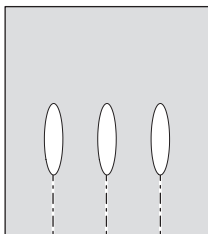
$3\frac{1}{2}"$
(89 mm)



$1"$ $1"$

2x6

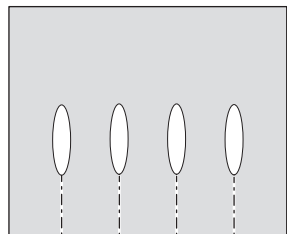
$5\frac{1}{2}"$
(140 mm)



$1\frac{1}{4}"$ $1\frac{1}{2}"$ $1\frac{1}{2}"$ $1\frac{1}{4}"$

2x8

$7\frac{1}{4}"$
(184 mm)

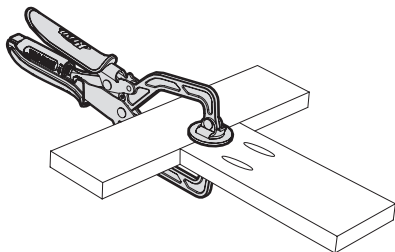


$1\frac{3}{8}"$ $1\frac{1}{2}"$ $1\frac{1}{2}"$ $1\frac{1}{2}"$ $1\frac{3}{8}"$

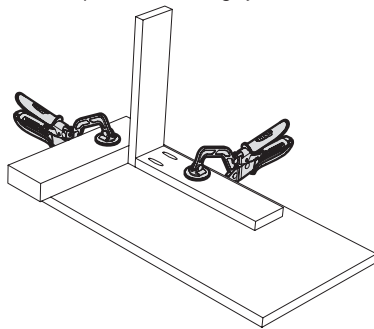
2 Clamp the Joint in Place

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

a. Clamp here for the face joint.

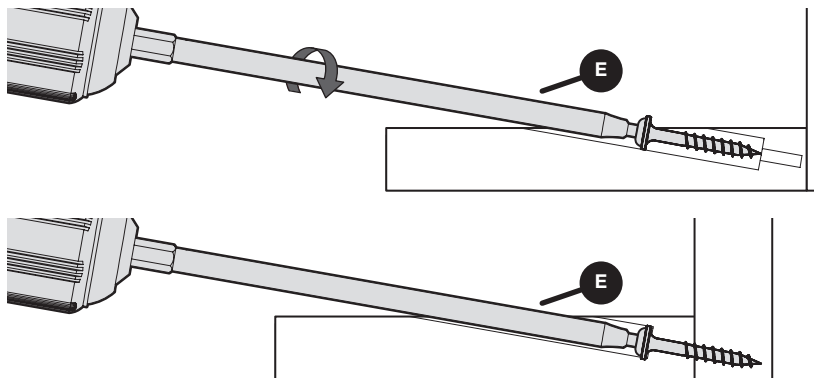


b. Clamp here for the edge joint.



3 Drive the Screws

- Place a screw on the driver bit (E).
- 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 XL Screws

Material Thickness	Easy-Set Stop Collar	Material Thickness Stop	Screw Length
1-1/2" (38 mm)	1-1/2" (38 mm)	1-1/2" (38 mm)	2-1/2" (64 mm)
3-1/2" (89 mm)	3-1/2" (89 mm)	3-1/2" (89 mm)	4" (102 mm)

Note Use of Standard size pocket hole screws will result in weaker joints.

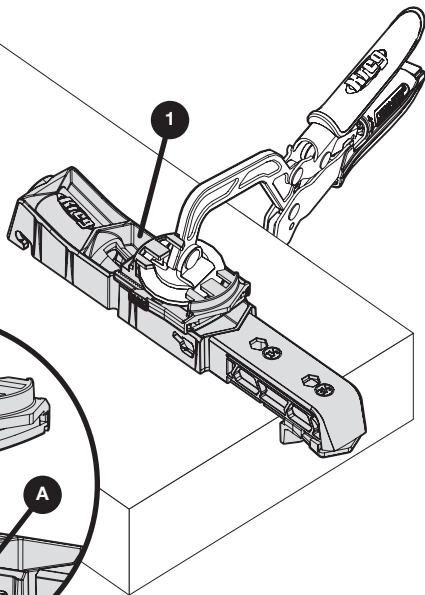
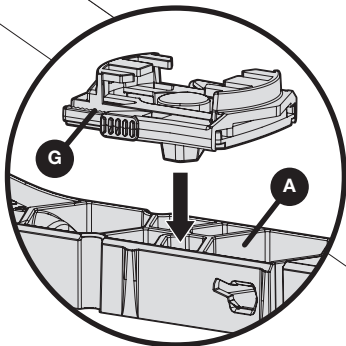
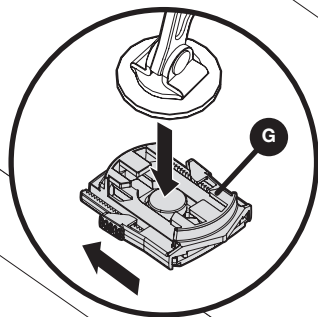
To learn more about selecting and purchasing Kreg Screws, visit: www.kregtool.com/screws.

Using the Clamp Pad Adapter

The clamp pad adapter connects the jig to the clamp.

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

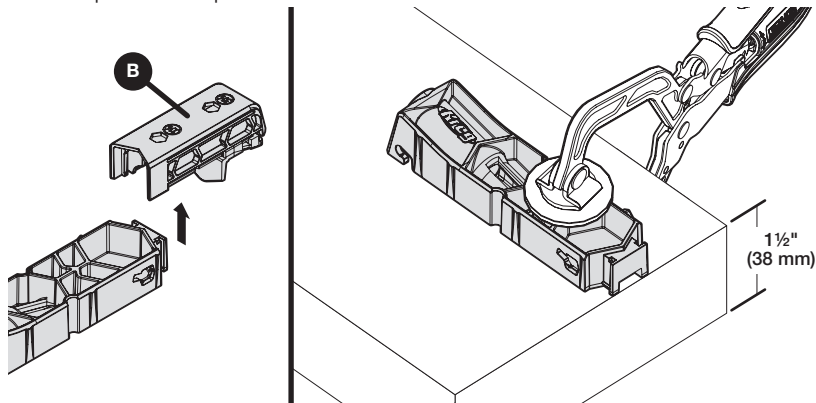
Note Do not block the chip ejection hole (1).



Using the Jig for Repair Applications

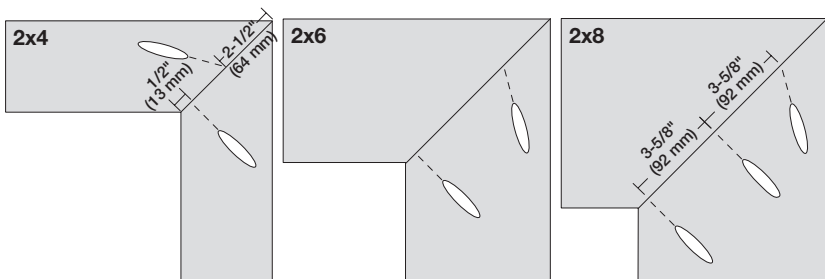
- Remove the material thickness stop (B).
- Position the jig on the workpiece.
- Clamp and drill the pocket-holes.

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



Using the Jig for Mitered Corners

- Remove the material thickness stop to get a screw close to the miter toe.
- Position the drill guide on the workpiece, angled away from the miter toe.
- Clamp the drill guide in place and drill the pocket hole.



Note For distances of 6" (152 mm) or more between pocket holes, drill a pocket hole midway between the two. In general, space pocket holes about 3" (76 mm) center-to-center along a joint. You can drill pocket holes in both parts or drill them all in one part.

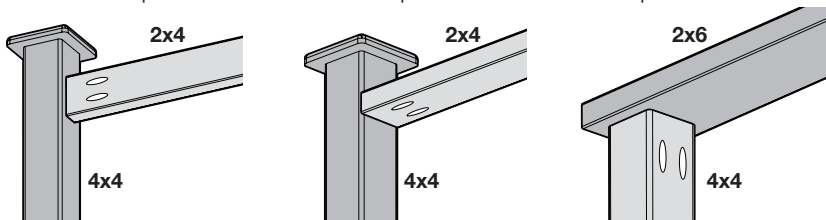
Using the Jig for Railings

International Residential Code Guardrail Requirements: Whether manufactured or site-built, guardrail systems must be constructed and installed to meet International Residential Code (IRC) live-load requirements. To be compliant, guardrails must withstand a 200-lb. (91-kg) load applied in any direction.

Compared to manufactured guardrail systems, site-built guardrails constructed of typical dimensional lumber are not as easy to build with certainty that the live-load requirement is met. The Code sets performance standards but does not provide prescriptive detailing for guardrail design. It is the responsibility of the designer, builder, and local code official to verify if a given guardrail design meets the requirements.

Guardrail connections of the three styles shown here, constructed using the Pocket-Hole XL Jig, meet the live load requirements specified in the IRC. (Testing covers only the connection of railing members to posts, not the connection of the posts to the deck structure.) To meet requirements, builders must execute these connections exactly as shown and use only structurally sound materials. Materials with splits or excessive knots must not be used.

Guardrail materials and fasteners are exposed to the weather and are subject to degradation over time. It is the homeowner's responsibility to periodically inspect the guardrail and perform any maintenance required to ensure continued compliance with IRC live-load requirements.



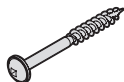
Care and Cleaning

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

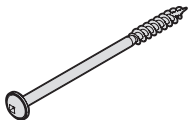
Troubleshooting

Contact Technical Support or see the website for FAQs.

Accessories



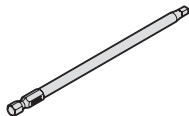
2-1/2" (64 mm)
Kreg XL Screws



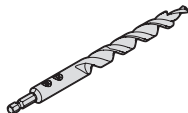
4" (102 mm)
Kreg XL Screws



Kreg Clamp



Kreg #3 Square Driver Bit



Kreg XL Drill Bit (KPHA908)



Kreg Easy-set Stop Collar



Hex Wrench



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