



English  
Version

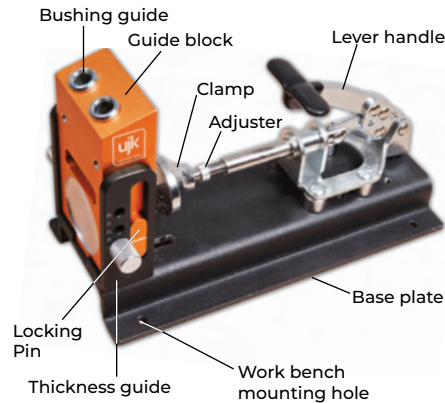
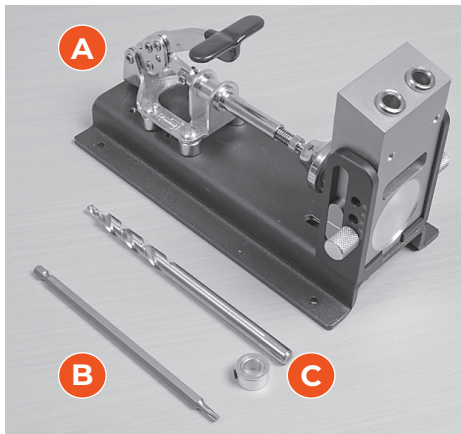


Code 503726  
Date: 10.07.2023

# Pocket Hole Jig

What's Included

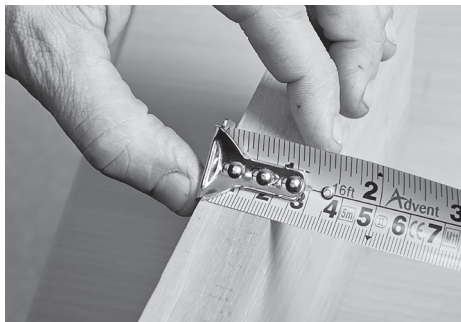
- A** x1 Pocket Hole Jig  
**B** x1 Long Torx T20 Pozidrive bit (Code 503457)  
**C** x1 M2 Hex shank step drill bit and ring collar clamp



Drill Guide Block Chart

Timber Thickness	USE
13 -17mm	12mm
18-23mm	18mm
24-29mm	24mm
30-35mm	30mm
36+mm	36mm

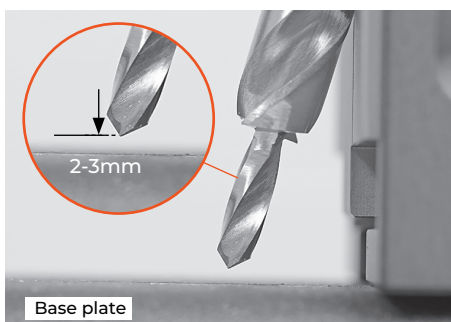
## Operating Instructions



**Step 1** Measure the width of the timber, see picture above.

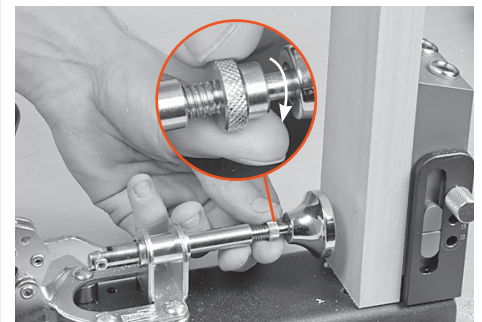
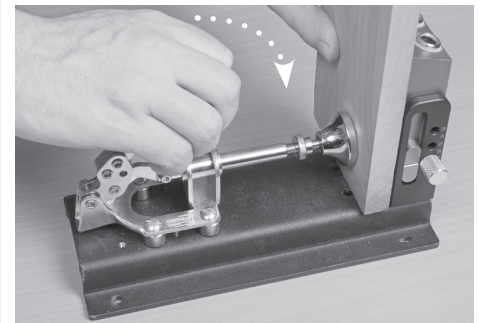


**Step 2** Line-up the machined groove (a) with the numbered scale (b) to match the timber thickness. See the "Drill Guide Block Chart" to set the correct height. Lock the block in position using the two threaded locking pins (c).



**Step 3** Place the ring collar clamp (C) over step drill bit shaft, inset the drill bit into the bushing guide hole, raise the drill bit so it's (2-3mm) above the base plate and tighten the ring collar flush against the bushing guide. **DO NOT OVERTIGHTEN!**

**Step 4** Clamp the timber against the guide block by pushing the lever handle forward, making sure the timber is clamped square and firm. If there is too much pressure or not enough, pull back the lever handle and rotate the threaded adjuster on the clamp shaft and try again. Repeat the procedure until correct. (See diagrams below)



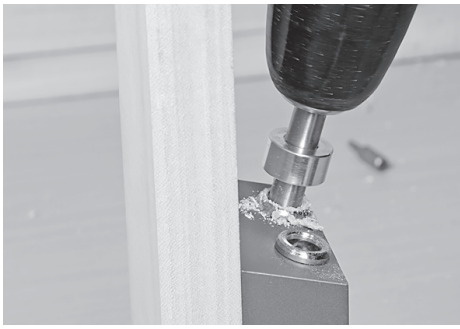
**NOTE: SET THE CORDLESS DRILL TO HIGH SPEED!**

**Step 5** Attach the drill bit to the drill, carefully insert the drill bit into one of the bushing guide holes, start the drill, using stage cutting for adequate chip clearance until the ring collar (C) is flush against the bushing guide. (See diagrams below) Repeat for the remaining hole.

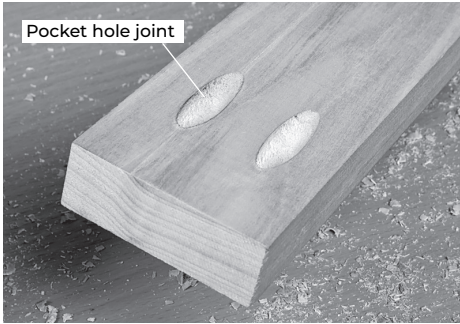


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**Step 6** Remove the drilled pocket hole joint from the jig, see diagram below.



### Screw Chart

Select the correct type of screw. Fine thread for hard wood, Course thread for soft wood.

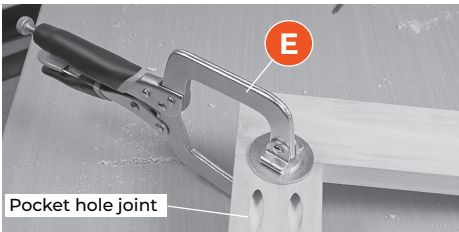
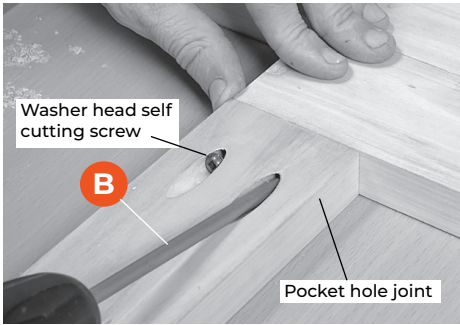
Timber Thickness	Screw
13-18mm	25mm
19-25mm	30mm
26-30mm	35mm
31-37mm	50mm
38+mm	60mm

### Assembly Suggestions

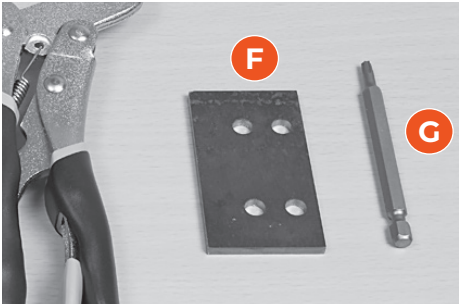
When assembling we recommend the following:

- A clear work bench
- A workstop (a length of straight timber clamped to either end will suffice)

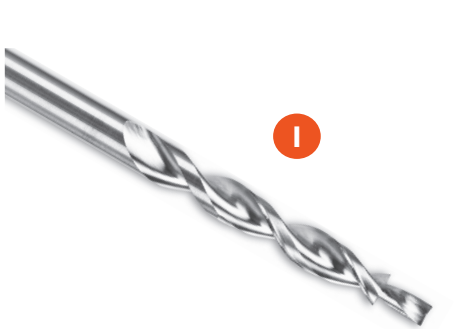
1. Line-up the joints, attach the long torx 20 drive bit (B) into your cordless drill.
2. Set the drill to a **LOW** torque setting, so as not to overdrive the screw.
3. Choose the correct screw length for your application.
4. Place washer head self cutting screws down into the pocket holes and screw the two joints together. (See diagram below)



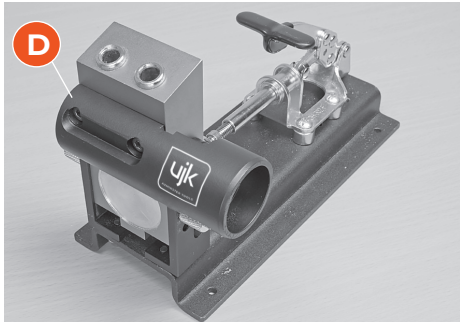
### Optional Accessories



			Code
D	x1	UJK Extractor Outlet for Pocket Hole Jig with two Hex screws	503801
E	x1	UJK Face Clamp	503727
F	x1	UJK Portable Base Plate	503802
G	x1	UJK Short Torx T20 Pozidrive bit	503456
H	x1	UJK Alignment Clamp with quick release	502710
I	x1	UJK Pocket Hole Drill Bit - Hex Shank	103397

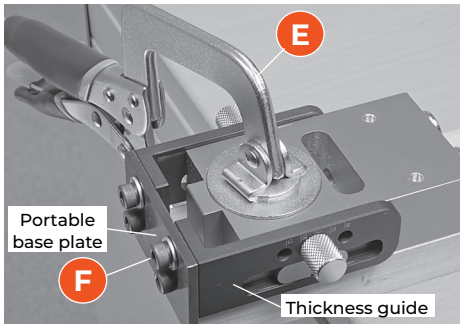


### Fitting the dust extractor



Locate the dust extractor assembly and the two Hex screws (D). Line up the pre-drilled holes with the threaded holes to the front of the guide block and secure with the two Hex screws.

### Portable Base Option



The pocket hole jig can be turned into a portable pocket hole guide by attaching the optional portable base plate (F), see instruction below.

1. Remove the guide block and thickness guides from the base plate by removing the four Hex screws.
2. Attach the portable base plate (F) to the thickness guides with the Hex screws. **DO NOT OVERTIGHTEN!** (See diagrams above)