



Aluminum Pocket Hole Jig



SAFETY RULES

WARNING

For your own safety, read all of the rules and precautions before operating tool.

WARNING

Always follow proper operating procedures as defined in this manual even if you are familiar with use of this Aluminum Pocket Hole Jig or any tool used with this Aluminum Pocket Hole Jig. Remember that being careless for even a fraction of a second can result in severe personal injury.

Before using another tool with this product, always read, understand and follow the instructions and safety warnings in the owner's manual for that tool. If you do not have the owner's manual, obtain one from the tool's manufacturer before using it with this product.

You must be familiar with the use of any tool or accessory used with this Aluminum Pocket Hole Jig. The supplier cannot be held responsible for any accident, injury or damage incurred while using this Aluminum Pocket Hole Jig with any tool.

It is the responsibility of the purchaser of this product to ensure that any person using this product reads and complies with all instructions and safety precautions outlined in this manual and the operating manual of the tool being used prior to use.

WARNING

Some dust created by operation of power tool contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. To reduce your exposure to these chemicals, work in a well ventilated area and work with approved safety equipment. Always wear OSHA/NIOSH approved, properly fitting face mask or respirator when using such tools.

CAUTION

Do not modify or use this Aluminum Pocket Hole Jig for any application other than that for which it was designed.

FOLLOW ALL STANDARD SHOP SAFETY PRECAUTIONS, INCLUDING:

- Keep children and visitors at a safe distance from work area.
- Keep work area clean. Cluttered work areas invite accidents. Work area should be properly lit.
- Do not use power tools in dangerous environments. Do not use power tools in damp or wet locations. Do not expose power tools to rain.
- TURN OFF AND UNPLUG all power tools BEFORE making any adjustments or changing accessories.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.
- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of the tool.
- Wear protective hair covering to contain long hair.
- Wear safety shoes with non-slip soles.
- Wear safety glasses complying with United States ANSI Z87.1. Everyday glasses have only impact resistant lenses. They are NOT safety glasses.
- Wear face mask or dust mask if operation is dusty.
- A guard or any other part that is damaged should be properly repaired or replaced. Do not perform makeshift repairs.
- Use safety equipment such as featherboards, push sticks and push blocks, etc., when appropriate.
- Maintain proper footing at all times and do not overreach.
- Do not force woodworking tools.

CAUTION

Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.

CAUTION

Do not use the Aluminum Pocket Hole Jig until completely assembled and you have read and understood this entire operating manual and the operating manual of the tool being used with this Aluminum Pocket Hole Jig.

SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

SPECIFIC SAFETY WARNINGS

- Before using the Aluminum Pocket Hole Jig, be sure everyone using the product reads and understands all safety instructions and other information contained in the drill manufacturer's manual.
- The drill bit is sharp. Handle with care.
- Avoid awkward hand positions where a sudden slip could cause contact with the rotating bit.
- Properly secure your workpiece before drilling. Do not attempt to hold the Aluminum Pocket Hole Jig in place with your hand while drilling. Secure it to the workpiece with a clamp.
- Do not allow familiarity gained from frequent use of tools replace safe work practices. A moment of carelessness is sufficient to cause severe injury.

UNPACKING Refer to Figure 1

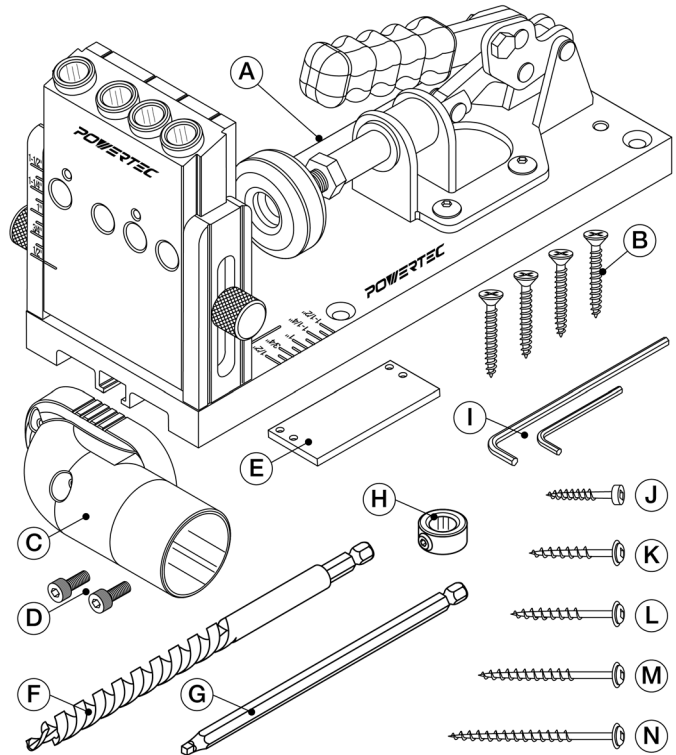
Check for shipping damage. Check immediately whether all parts and accessories are included.

ITEM	DESCRIPTION	QTY
A	Aluminum Pocket Hole Jig Base	1
B	Countersunk Phillips Screws	4
C	Dust Port	1
D	Socket-Head Screws (Dust Port)	2
E	Portable Steel Base Plate	1
F	3/8" Step Drill Bit	1
G	R2 Square Driver Bit	1
H	3/8" Stop Collar	1
I	Hex Keys	2
J	#7-1" L Coarse Square Drive Pan-Head Screws	10
K	#8-1-1/4" L Coarse Square Drive Washer-Head Screws	10
L	#8-1-1/2" L Coarse Square Drive Washer-Head Screws	10
M	#8-2" L Coarse Square Drive Washer-Head Screws	10
N	#8-2-1/2" L Coarse Square Drive Washer-Head Screws	10

WARNING

Before using the Aluminum Pocket Hole Jig, make sure to read and understand this entire operating manual and the operating manual of the drill being used.

Figure 1

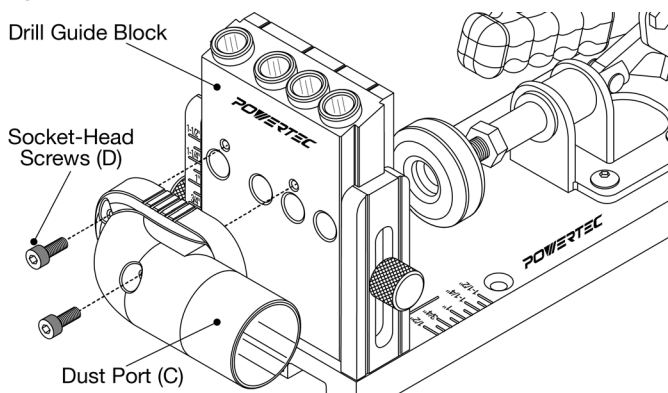


SET UP THE JIG

Attach the Dust Port:

See Figure 2. Using two Socket-Head Screws (D) secure Dust Port (C) to the body of the Drill Guide. Do not over tighten the screws. Doing so may cause damage to the Dust Port.

Figure 2

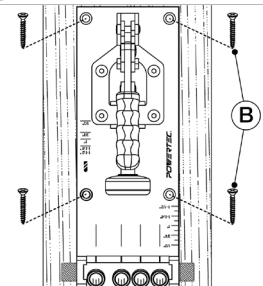


Secure the Jig:

Table Top Fitting

Fasten the Pocket Hole Jig to a table top using the Countersunk Phillips Screws (B) provided. Locate the four predrilled holes in the top of the Base and secure to the table top.

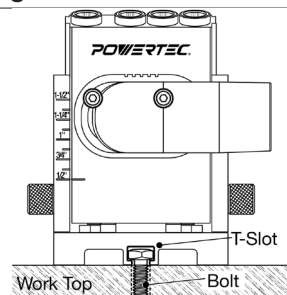
Figure 3



T-Slot Bolt Fitting

As an alternative method, a 5/16" bolt-head or nut can be used in the T-slot located on the bottom of the base to secure the Pocket Hole Jig.

Figure 4



Optional Portable Base (Included):

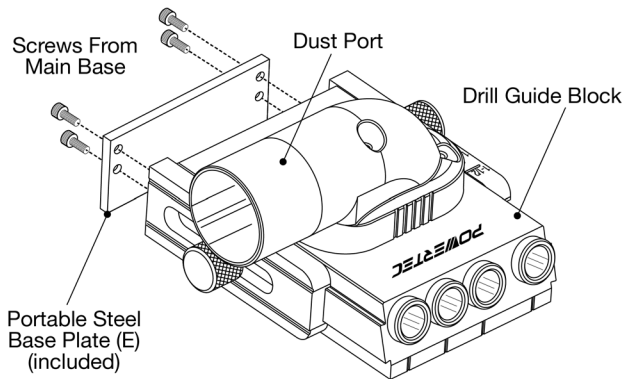
See Figure 5. The **POWERTEC** Aluminum Pocket Hole Jig includes an additional Portable Steel Base Plate (E) allowing the user the option of using this Jig as a portable unit.

1. Remove the four screws securing the Drill Guide Block from the bottom of the Main Jig Base.
2. Attach Steel Base Plate (E) to the base of the Drill Guide Block using the same four screws removed from the Main Jig Base. This assembly now functions as a Portable Jig.

NOTE: Make sure the plate extends past the base on the side opposite of the dust port.

3. Adjust the Jig for the workpiece thickness.
4. Place the Steel Base Plate over the edge of the workpiece and secure into place with a clamp before drilling the pocket holes.

Figure 5

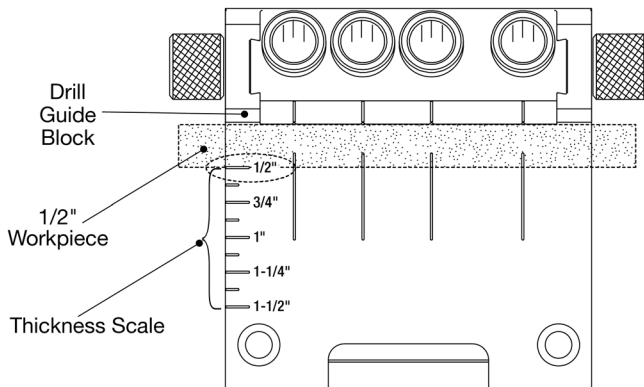


Measure Material Thickness:

See Figure 6. On the side of the Aluminum Pocket Hole Jig are material thickness alignment marks and measurements.

1. Place the workpiece against the Drill Guide Block. Workpiece thickness can be quickly gauged from the scale markings on the Jigs Base.
2. Example shows mark is aligned to 1/2" material thickness.

Figure 6

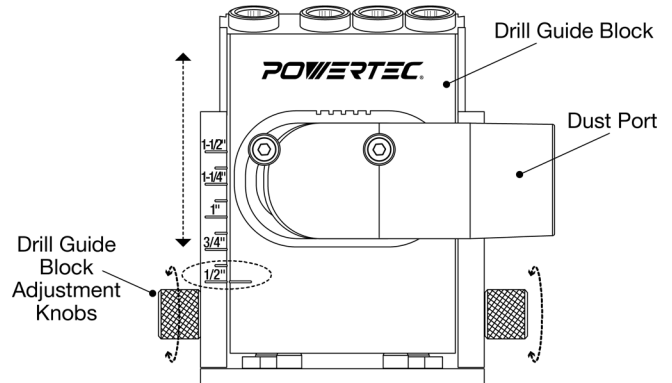


Adjust the Drill Guide Block:

See Figure 7. After the workpiece thickness has been determined—adjust the Drill Guide Block with the same measurement. In this example it is 1/2".

1. From the sides of the Drill Block Guide turn the two brass knobs counterclockwise to loosen the guide block.
2. Choose the measurement from the scale to the left of the dust port.
3. Tighten the two brass knobs to secure.

Figure 7



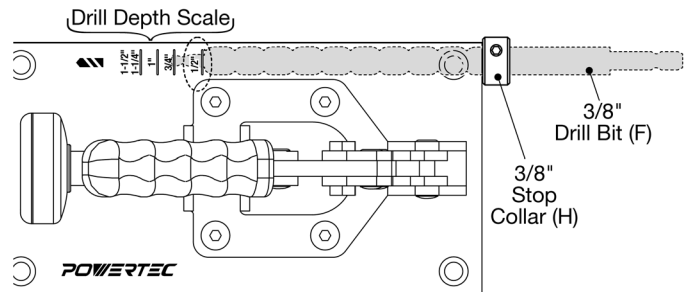
Set the Drill Depth Position:

1. See Figure 8. Slide the 3/8" Stop Collar (H) onto the 3/8" Drill Bit (F). Do not tighten at this time.
2. A Drill Depth Scale is engraved on the base of the Jig. Place the drill bit on the Drill Depth Scale as shown in Figure 8. In this example using the 1/2" measurement. Slide the 3/8" Stop Collar to the edge of Aluminum Pocket Hole Jig.
3. Once the drill bit is set—place the bit into the jig verifying the setting. Make adjustments as needed.

CAUTION

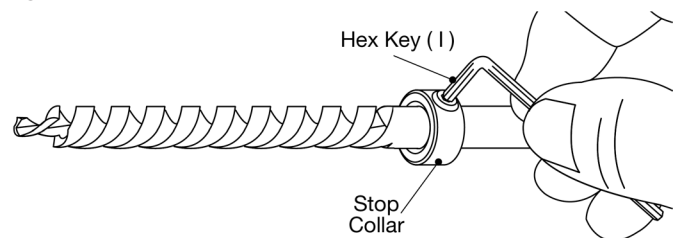
If set too long the bit will drill into the base of the Jig.

Figure 8



4. Tighten the Stop Collar with the provided Hex Key (I).

Figure 9



Set Up the Adjustable Clamp:

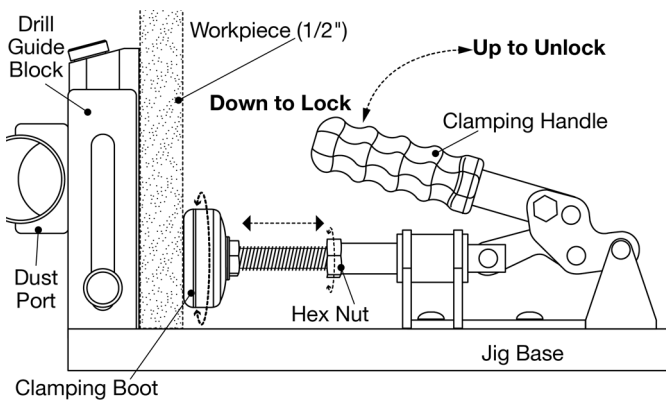
See Figure 10

1. With workpiece against the Drill Guide Block, loosen the Hex Nut behind the Clamping Boot.
2. Ensure the Clamping Handle is **Unlocked** yet in the downward position.
3. Adjust the Clamping Boot by rotating it clockwise until just making contact with the workpiece.
4. Lift the Clamping Handle—make one clockwise turn of the Clamping Boot.
5. Press down on the Clamping Handle to secure workpiece.
6. Adjust if needed. When set, tighten the Hex Nut.
7. The workpiece is now ready to be drilled.

CAUTION

Excessive pressure caused by improper settings may damage the workpiece or the Jig.

Figure 10



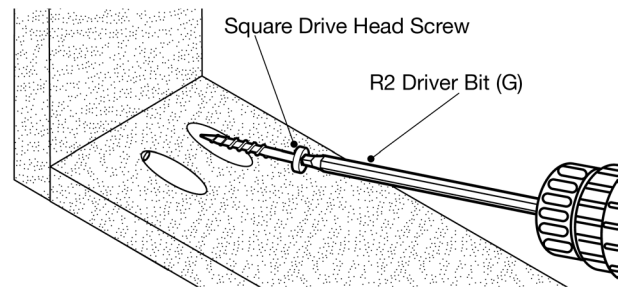
NOTE: Always ensure the Pocket Hole Jig is properly adjusted with enough pressure to secure the workpiece without putting undo strain on the Jig or Clamp.

GENERAL MAINTENANCE

WARNING

When servicing, use only identical replacement parts. Use of any other parts may create a hazard or cause product damage. To ensure safety and reliability, all repairs should be performed by a qualified service technician.

Figure 11



- Use the R2 Driver Bit (G) (supplied) to drive Square Drive Head wood screws into the material.

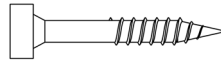
DRIVE POCKET HOLE SCREWS

1. Reference the **Recommended Screw Length** chart for the correct screw length for material thickness used.

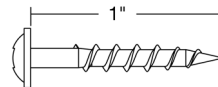
Recommended Screw Length:

Material Thickness	Screw Length
1/2" (13 mm)	1" * (25 mm)
3/4" (19 mm)	1-1/4" (32 mm)
1" (25 mm)	1-1/2" (38 mm)
1-1/4" (32 mm)	2" (51 mm)
1-1/2" (38 mm)	2-1/2" (64 mm)

* Pan-Head Pocket Screws recommended.



NOTE: Screw length is measured from the bottom of the head to the tip of the screw.



WARNING

Keep the Aluminum Pocket Hole Jig dry, clean, and free from oil and grease. Always use a clean cloth when cleaning. Never use brake fluids, gasoline, petroleum-based products or any strong solvent to clean the Aluminum Pocket Hole Jig. Chemicals can damage, weaken or destroy plastic which may result in serious personal injury.

Visit us on the web at www.powertecproducts.com



Put these instructions and the original sales invoice in a safe, dry place for future reference.

Southern Technologies, LLC • Chicago, IL 60606