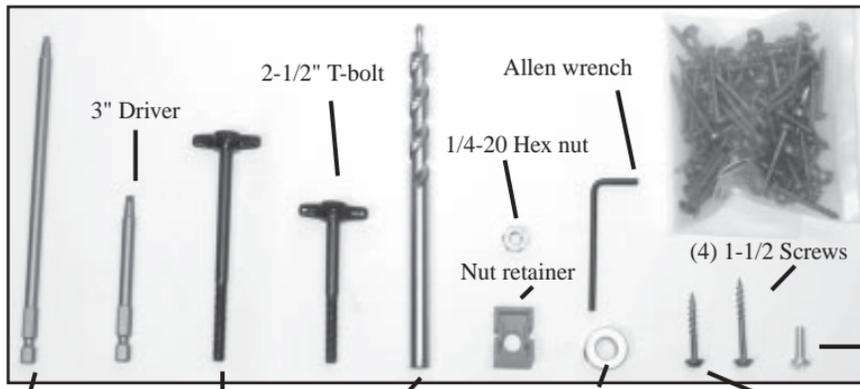
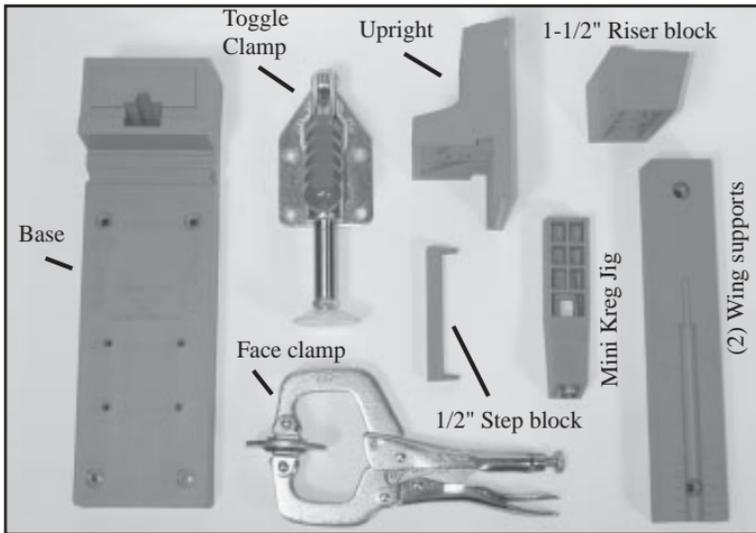


2



Sample pack of screws

6" Driver

3-3/4" T-bolt

6" Driver

3-3/4" T-bolt

3/8" KJD bit

1/4-20 Hex nut

Nut retainer

Depth collar

(4) 1-1/2" Screws

(4) 10-32 x 3/4" Machine Screws

(4) 1-1/4" Screws

Thank you!!!

Thank you for purchasing the Kreg Jig K2000 ProPack from Kreg Tool Company. For over a decade, Kreg Tool has worked to make woodworking faster, stronger, and simpler using pocket hole joinery. The K2000 Kreg Jig you have purchased is loaded with features that make it the most versatile pocket hole system available.

Kreg Tool welcomes your ideas and comments. To contact us please call 1-800-447-8638, or visit our web site at **www.kregtool.com**. The web site now includes a pocket hole joinery forum where employees of Kreg Tool and other woodworking enthusiasts can get together to solve problems and gather useful information.

Important Notice

Before drilling any parts with your Kreg Jig K2000, assemble the upright onto the base in Position 1, adjust your depth collar for 3/4" material on your drill bit, and drill out each of the holes. This process will remove blue plastic chips from the drill guide path. The chips are perfectly normal and occur because of the tight tolerances placed on the drill guides and the path of the drill bit. Blue chips will continue to be seen for approximately the first 20 holes.

Warranty

The Kreg Jig K2000 comes with a 30 day satisfaction guarantee. If you are unhappy with the performance of the jig in any way, simply return it within 30 days for a full refund. Both the K2000 and the Mini Kreg Jig included in this ProPack carry a lifetime warranty on their hardened steel drill guides.

Assembly Instructions

Please follow these simple steps in order to prepare your Kreg Jig for use. Refer to the photo on page 2 of this manual for part reference.

1. Step 1, press the hex nut into the hex recess on the bottom of the jig base. Step 2, then push the plastic nut firmly onto the ribs to capture the nut as shown in fig. 1.
2. If the toggle clamp is not already assembled, use the 4 machine screws to attach it to the base.
3. Next, you'll want to screw the base down to a piece of plywood using the four 1-1/2" screws provided. The plywood will serve as a mobile base that will allow you to easily transport the jig around your work area. Simply clamp the plywood to your workbench when ready to drill.
4. Locate the 2 support wings and place them perpendicular to the base so that they appear as shown at right. Notice that the support wings are positioned to the forward edge of the 1/2" Step Block groove. Positioning them as shown will assure that the groove does not become filled with wood chips while drilling. Finally, screw the wings tight to the plywood using the (4) 1-1/4" screws provided. The wing supports serve two purposes: 1. They help to support panels that are wider than the base of the jig. 2. They incorporate a groove that is used to help locate the correct depth collar setting.

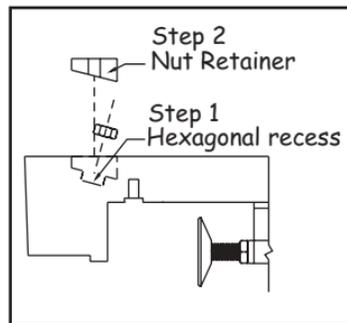
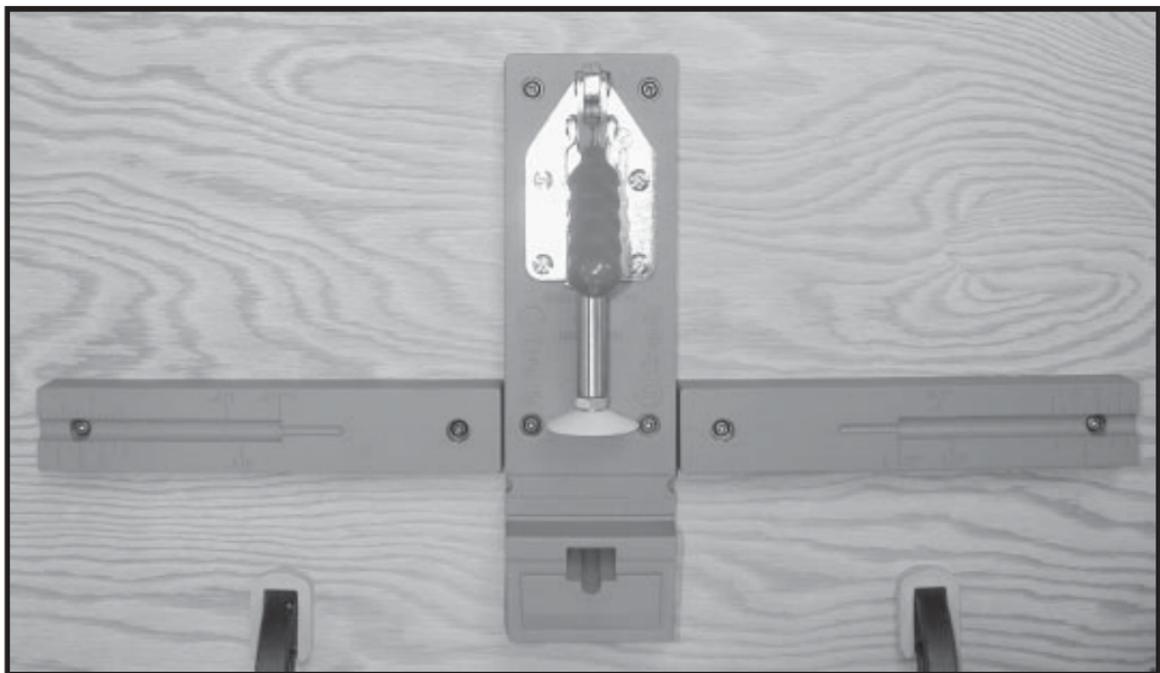


fig. 1



Kreg Jig K2000 Philosophy

Pocket hole joinery has come a long way in the last decade. An astounding number of woodworkers are realizing what we've known for many years—that the fast, strong, and simple technique that was primarily used in face frame assembly can be utilized in many different woodworking applications. To better serve the growing number of woodworkers that use pocket hole joinery as their main joinery method, Kreg worked to design a pocket hole tool that easily places pocket holes in their ideal location. The innovative design of the K2000 has produced a tool that provides three easy adjustments for working with different thicknesses of material as well as three horizontal hole spacings to properly place holes in material of varying widths. In addition, the Mini Kreg Jig that is included in this ProPack can be used virtually anywhere. Simply clamp the jig flush to the edge of your workpiece, adjust depth collar setting, and drill to achieve the Position 1 result. Adjust the distance from the edge of your workpiece accordingly for thicker or thinner materials and change your depth collar setting.

6

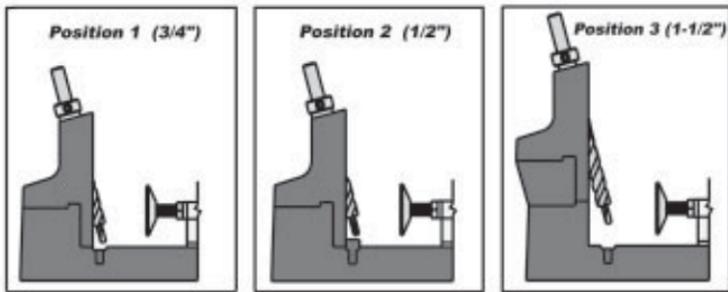


fig. 2

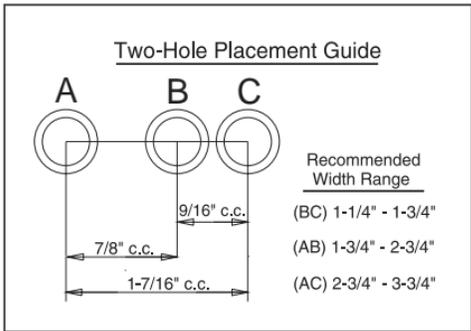


fig. 3

Set-up for Position 1

**Position 1 assumes standard 3/4" thick material using 1-1/4" screw. However, use this position for material ranging between 3/4" and 1-1/8" in thickness. (You may need to adjust screw length as material thickness varies.)

1. Set up base and support wings as shown on page 5.
2. Place the upright onto the base and finger tighten using the 2-1/2" T-Bolt provided until parts are snug.
3. When using 3/4" material, the depth collar can be set by aligning the step of the drill bit with the 3/4" marking on either wing support. Then use the allen wrench to tighten the depth collar flush with the end of the wing support as shown in fig. 5. This setting leaves approximately 1/8" between the tip of the bit and the base of the jig. (The depth collar setting on the wing supports is a standard setting only. Difference in screw length as well as material thickness may cause need for adjustment. Always check your setting before drilling final holes as shown on page 8, fig. 7.)
4. Depending on which width of material you will be drilling, either choose the AB, AC, or BC hole spacings shown in fig. 6. Center the appropriate two holes over the width of your material.

fig. 4

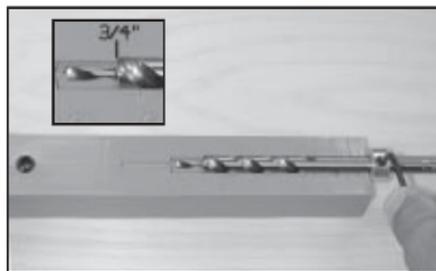
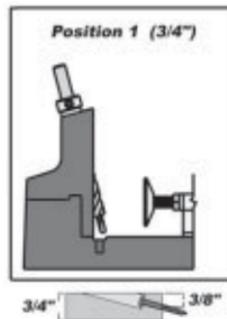


fig. 5

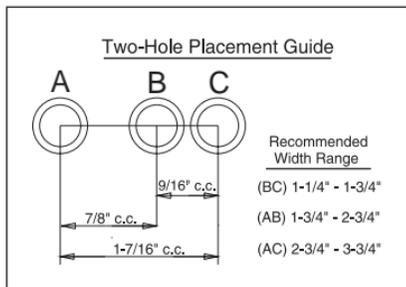


fig. 6

Drilling the Pocket Hole

Because variations in wood thickness and screw length can cause undesired results in the screw protruding through the final workpiece, always check depth collar setting by testing in scrap material and adjust depth collar accordingly (as shown in fig. 7). To set the correct clamping pressure, spin the bumper in or out of the clamp's barrel until the handle snaps closed with two fingers of pressure. Once adjusted correctly, tighten the hex nut. Drill the pocket hole by sliding the bit into the guide allowing the drill to achieve full speed before pushing into the material. Once the depth collar has made contact with the top of the drill guide, keep the drill turning at full speed and withdraw the drill bit from the guide. It is recommended to use a 2000+ RPM corded drill in order to maximize drill bit life.



fig. 7

8

Assembling the Joint

Self-tapping pocket hole screws eliminate the need to bore an aligning pilot hole in the mating workpiece, even in hardwoods like oak, hickory and maple. Although other types of screws may work, pocket hole screws greatly reduce splitting and are hardened to nearly eliminate breakage. We recommend using glue unless the ability to disassemble the joint is desired.

Using the 6" Face Clamp included to align the workpieces, as shown below, ensures that the joint stays flush as the screws are driven. Place the large washer on the face of the joint, increase tension, and clamp. The washer will help to keep the face flush if the workpieces are of slightly different thicknesses, and will also keep the clamp from denting the face of softer materials.

It is strongly recommended to drive the screws using a drill with a clutch. The clutch allows you to vary how much torque the drill puts on the screws so you don't have strip out. Most cordless drills include this feature. If you do not have a drill with a clutch, you can use a corded drill to drive the screws until they are almost seated, and then finish driving the screws using a hand driver.

When driving the screws, you may notice a slight separation of the work pieces before the screw begins to pull them back together. This is normal, but if the gap exceeds 1/4" increase the clamp pressure. The face clamp works well for aligning face frame and picture frame style joints. For other joints a bar clamp will be useful to keep the workpieces in position while driving the screws.

A good tip for joining workpieces is to build a grid similar to the one shown in fig. 8. The grid allows you to suspend the joint above the table top where you can reach it from both sides with the face clamp. The grid also keeps your tools, screws and glue easily accessible between the 2x4's, yet out of the way when sliding the frame around. Make the grid using a sheet of 3/4" plywood cut to any dimension, with 2x4's pocket-holed on edge to the sheet. Vary the spacing of the 2x4's.



fig. 8

Set-up for Position 2

**Position 2 was primarily designed for use with standard 1/2" thick material. This type of stock is widely used in drawer construction. To attach workpieces, plan on using 1" screws. You will also want to use this position for material ranging between 1/2" and 5/8" in thickness. (You may need to adjust screw length as material thickness varies.)

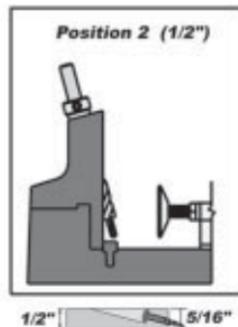


fig. 9

1. Set up base and support wings as shown on page 5.
2. Press the 1/2" Step Block into place.
3. When using 1/2" material, the depth collar can be set by aligning the step of the drill bit with the 1/2" marking on either wing support. Then use the allen wrench to tighten the depth collar flush with the end of the wing support as shown in fig. 10. This setting leaves approximately 1/8" between the tip of the bit and the base of the jig. (The depth collar setting on the wing supports is a standard setting only. Difference in screw length as well as material thickness may cause need for adjustment. Always check your setting before drilling final holes as shown on page 8.)
4. Depending on which width of material you will be drilling, either choose the AB, AC, or BC hole spacings shown in fig. 11. Center the appropriate two holes over the width of your material.

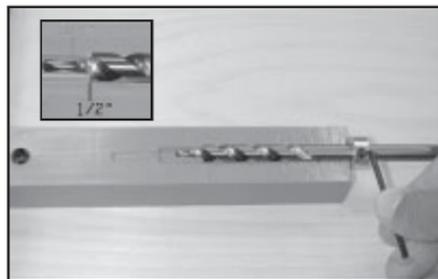


fig. 10

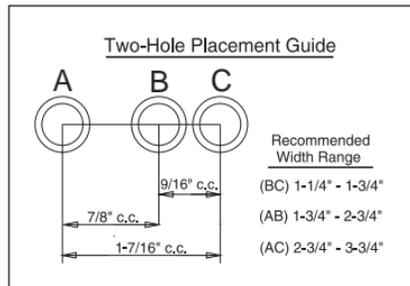


fig. 11

Set-up for Position 3

**Position 3 assumes standard 1-1/2" thick material using 2-1/2" screw. However, use this position for material ranging between 1-1/2" to 2" in thickness. (You may need to adjust screw length as material thickness varies.)

1. Set up base and support wings as shown on page 5.
2. Locate the 1-1/2" Riser Block from the ProPack case. Press the Riser Block into position on the base and then assemble the upright on top of the Riser Block using the 3-3/4" T-bolt. Finger tighten until all parts become snug.
3. When using 1-1/2" material, the depth collar can be set by aligning the step of the drill bit with the 1-1/2" marking on either wing support. Then use the allen wrench to tighten the depth collar flush with the end of the wing support as shown in fig. 13. This setting leaves approximately 3/4" between the tip of the bit and the base of the jig. (The depth collar setting on the wing supports is a standard setting only. Difference in screw length as well as material thickness may cause need for adjustment. Always check your setting before drilling final holes as shown on page 8.)
4. Depending on which width of material you will be drilling, either choose the AB, AC, or BC hole spacings shown in fig. 14. Center the appropriate two holes over the width of your material.

fig. 12

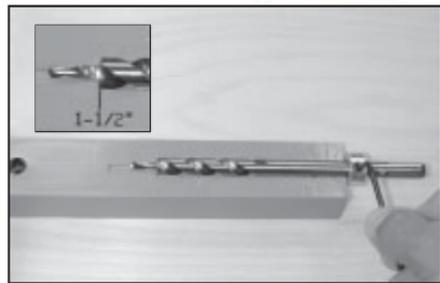


fig. 13

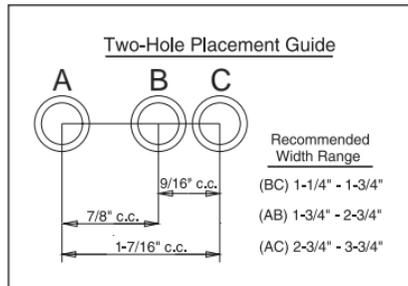


fig. 14

Choosing the Right Screw

Choosing the right screw is largely a matter of experimentation, however some guidelines do exist.

1. **Thread** - Our screws are designed so that a fine thread screw is to be used in hardwoods, and a coarse thread screw is used in softwoods and composite material (plywood, particle board, MDF).
2. **Length** - 1-1/4" is standard length for 3/4" materials. Use 1" screws when working with 1/2" thick material. A 2-1/2" screw is recommended when working with 1-1/2" thick material. All screws are available in a Sun Seal weather resistant finish. Call for details.
3. **Maxi-loc Screws** - The washer head keeps the screw head from crushing into the bottom of the pocket hole and seating the screws deeper than desired. Use a coarse thread washer head when joining any combination of soft materials like pine, plywood or particle board. Use a fine washer head screw when the pocket hole is bored in a soft material and passes into a hard material (i.e., edge-banding or partition to face frame).



fig. 15



fig. 16

Applications

With the almost limitless settings and adjustability of the K2000 ProPack, application data has grown tremendously. The following are some of the most common in use today.

Face Frames

Using pocket hole joinery for face frames is faster and stronger than conventional methods (dowel, biscuit and even mortise and tenon), and frees you from having to simultaneously manipulate several bar clamps as the frame is clamped for glue-up.

Angled Joinery

Using pocket hole joinery to make angles and curves eliminates difficult clamping set-ups and the expense of specialized clamps. To form any angle up to 45 degrees, rather than cutting half the desired angle on both workpieces, the entire angle is cut on the mating workpiece (right), which provides more distance for the screw. Before drilling the pocket hole make sure the depth collar is set correctly by checking a piece of scrap.

Cutting the entire miter on only one workpiece makes its edge longer than the edge of the first workpiece. This overhang is to be removed with a jointer, sander, or hand plane. Notice in fig. 18 that the point of the joint shifts away from the glue-line. When making face frames assemble your angled stiles first, remove the overhang, and then complete the face frame. A simple jig, as pictured at right, makes it easy to screw the workpieces together.

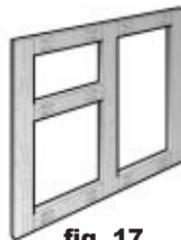
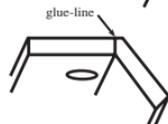
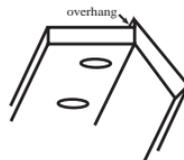


fig. 17



13

fig. 18

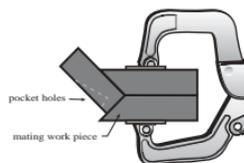
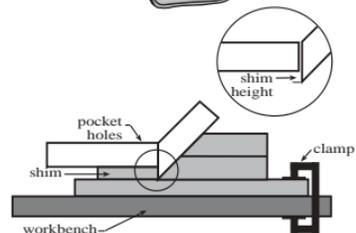


fig. 19



Curves

The same technique used to form angles is also used for curves, except a shallower angle between 5 and 15 degrees is typically used as shown at right. The smaller angle creates a smaller overhang, and a belt sander is used to smooth the face. This technique can be used for both solid wood and curved panel work as well.

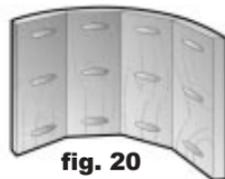


fig. 20

Beveled Ninety Degree Corners

Trying to join two workpieces, each with 45 degree miters, to form a 90 degree corner is not a good application for the pocket hole joint. However, a 90 degree change of direction can be accomplished using pocket hole joinery with the 90 degree bevel joint shown at right. The joint consists of a center workpiece with a 45 degree miter on both edges.



fig. 21

Table Tops and Aprons

When making table tops a bar clamp is helpful to hold the work in position as the screws are driven.



fig. 22

Edge-Banding Countertops or Shelving

Pocket holes are a great, sometimes overlooked solution for edge-banding countertops and shelving made from either plywood or particle board as shown at right.



fig. 23

Mitered Corners

Using pocket hole joinery for a mitered corner eliminates the need for frustrating and expensive clamps. For narrower frames a single pocket hole can be used. Cut the miter and rout the rabbet before boring the pocket holes. Use a face clamp to align the joint and drive the screws. Notice in the drawing at right that the holes are not necessarily drilled perpendicular to the joint line. This is accomplished by lifting one edge of the workpiece off the base of the jig as shown. This technique is especially helpful when working with stock less than 2" wide. One inch screws are useful when making mitered corners.



fig. 24



fig. 25

Window and Door Jam Extensions

A great time saver and something that can easily be accomplished in the field.

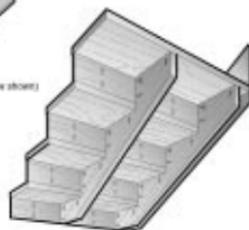
Stairs

Extremely solid stair construction. Pocket holes can be bored into existing stairs to eliminate squeaks.



(interior side of casement window shown)

fig. 26



(pocket holes on back side)

fig. 27

Post (Leg) and Rail Leg

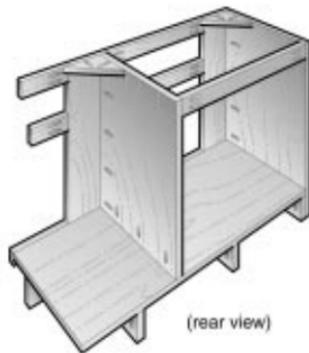
Table and chair legs are extremely strong and easy to construct with pocket hole joinery. Cut the miters for the brace after drilling the pocket holes.



fig. 28

Traditional Style (Framed Cabinets)

Pocket hole joinery can be used for almost every facet of framed cabinet construction, as shown at right. The traditional technique calls for making the face frame and case as separate components, and then fitting the two together, creating substantial opportunities for error. Because of the strength of pocket hole joinery, cabinet end-panels and partitions can be attached directly to the face frame one component at a time making construction much simpler. Also, the strength of pocket hole joinery eliminates the need for dados and rabbets that are usually cut into the face frame for the partitions and end-panels, making construction easier.



(rear view)

fig. 29

Euro-Style (Frameless) Cabinets

Pocket hole joinery works well for Euro-style (frameless) cabinetry, as shown at right. Use #SML-C125 (#7 coarse) screws for greater holding power.



(pocket holes on back or underside)

fig. 30

Shelving

Pocket holes work great for shelving with or without a dado.

Outdoor Applications

The K2000 makes working with dimension material easier than ever. Pocket holes help to hide the fastener from exposure to the elements. Because water can no longer pool around the head of the fastener and seep into the core of the wood, the fastener and the wood last much longer.

Project Plans / Videos

To get the most out of your Kreg Jig ProPack, consider purchasing one of our pocket hole plan sets or instructional videos. The plan sets include step-by-step instructions in a large, easy to read format that will have you building professional quality projects in no time. Be sure to check with your local dealer or www.kregtool.com for the most up to date listing of projects available.



Mini Kreg Jig

The Mini Kreg Jig is provided in the ProPack as a portable companion to the K2000. Simply clamp the jig flush to the edge of your 3/4" workpiece, adjust depth collar setting, and drill to achieve the Position 1 result as shown at right. Adjust accordingly for thicker or thinner materials and change your depth collar setting.



18

The Mini Kreg Jig also incorporates a plug setting feature into its design. Load the plug into the groove on the underside of the jig (1), position it in the center of the pocket hole and press into place (2). Pre-cut pocket hole plugs are available in a variety of species from Kreg.

1.



2.

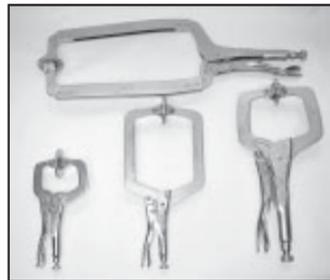
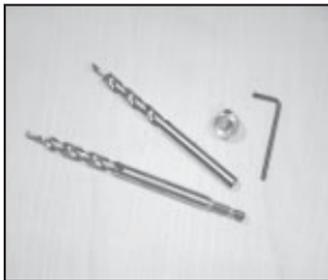


Other Products Available From Kreg Tool

For maximum performance from your Kreg Jig ask your dealer for genuine Kreg tools and accessories. If there is not a Kreg dealer near you, or your dealer can't supply you with genuine Kreg accessories, please call 1-800-447-8638 or visit www.kregtool.com.

Maintenance

- Place a drop of oil in hardened steel drill guides when dry, or every 250-500 holes.
- Keep your drill bits sharp. It is recommended that you sharpen your bits after approximately 750-1000 holes. Kreg Tool provides a bit sharpening service for a small fee.





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