



# MODEL H7933 POCKET HOLE JIG KIT INSTRUCTION SHEET

## Introduction

The Model H7933 Pocket Hole Jig Kit is designed for pocket hole drilling in  $\frac{3}{4}$ " or thicker stock.

## Inventory (Figure 1)

- A. Hex Wrench 3mm ..... 1
- B. Step Drill Bit  $\frac{3}{8}$ " w/  $\frac{1}{8}$ " Pilot & Stop Collar.. 1
- C. Long Square Driver #2 ..... 1
- D. Short Square Driver #2 ..... 1
- E. Pocket Hole Jig ..... 1
- F. Flat-face Clamp ..... 1
- G. Jig Spacer ..... 1
- H. Wood Screws Square Drive #8 x  $1\frac{1}{4}$ " .... 100
- I. Carrying Case (not shown) ..... 1

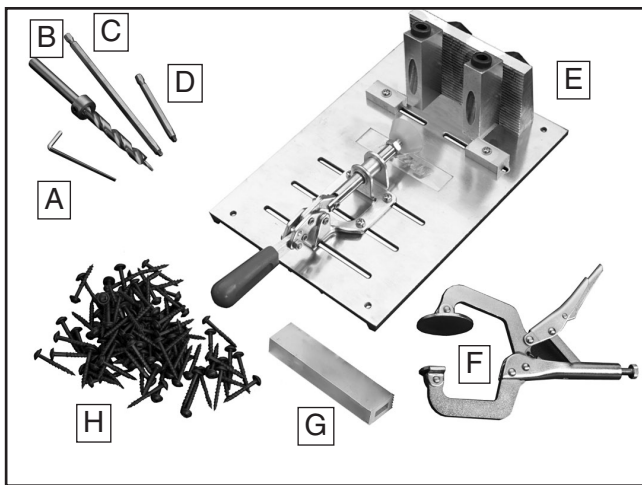


Figure 1. Model H7933 inventory.

## Drilling Instructions

The Model H7933 Pocket Hole Jig must be clamped or fastened to a workbench before use.

1. Orient the workpiece in the pocket hole jig based on the desired location of the pocket hole.
2. Adjust the stops and uprights, shown in **Figure 2**, to align the workpiece with a drilling hole. If necessary, place the jig spacer underneath the uprights, as shown in **Figure 3**, to prevent the workpiece from tilting when it is clamped.

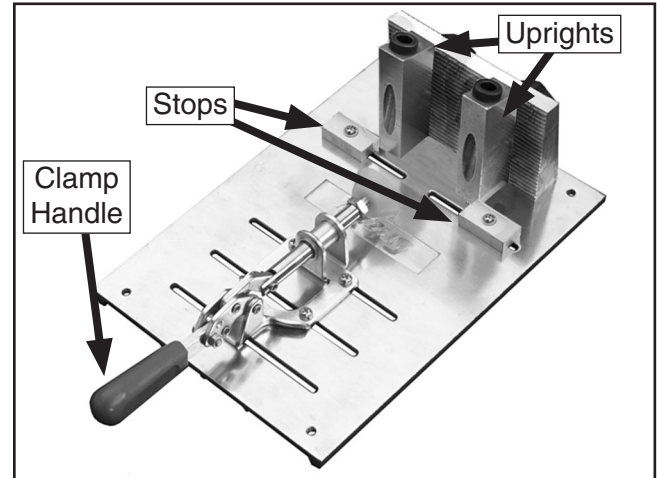


Figure 2. Jig components.

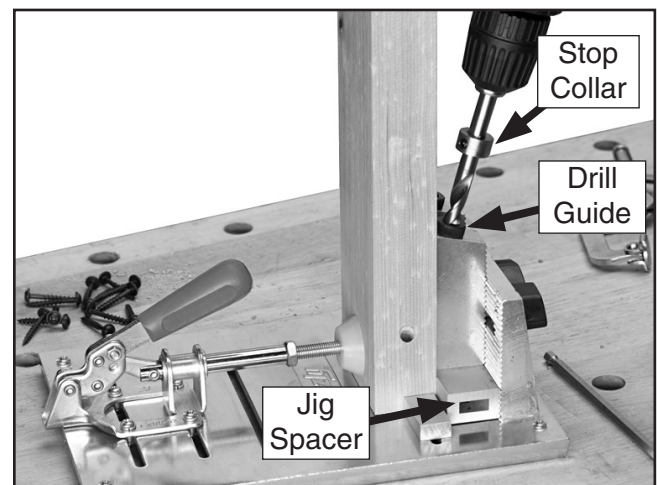


Figure 3. Drilling using the pocket hole jig.

**Note:** If more than one pocket hole needs to be drilled into the same workpiece, adjust the second upright accordingly.

3. Remove the workpiece.
4. Install the included step drill bit into your drill.
5. Loosen the stop collar indicated in **Figure 3**.
6. Feed the bit through the drill guide at the top of the upright, and tighten the stop collar at the desired drill depth. The drill pilot should never be closer than  $\frac{1}{8}$ " to the base plate.

7. Remove the drill bit from the drill guide.
8. Clamp the workpiece in the jig by pushing the clamp handle towards the workpiece.
9. Insert the drill bit into the drill guide until the bit pilot touches the workpiece.
10. Drill into the workpiece until the stop collar prevents the bit from going any deeper. Remove the drill bit.

## Clamping Instructions

The Model H7933 Pocket Hole Jig Kit includes a clamp use to hold two workpieces level while they are screwed together.

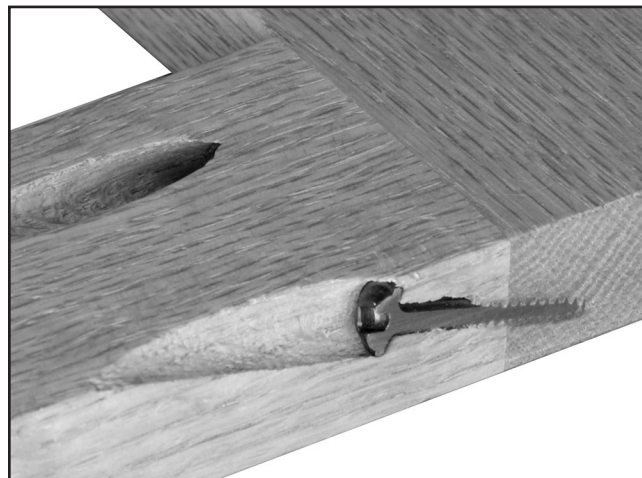
1. Clamp the two workpieces together using the included flat-face clamp.

**Note:** *We recommend using glue on the two joint faces unless the ability to disassemble the joint is desired.*

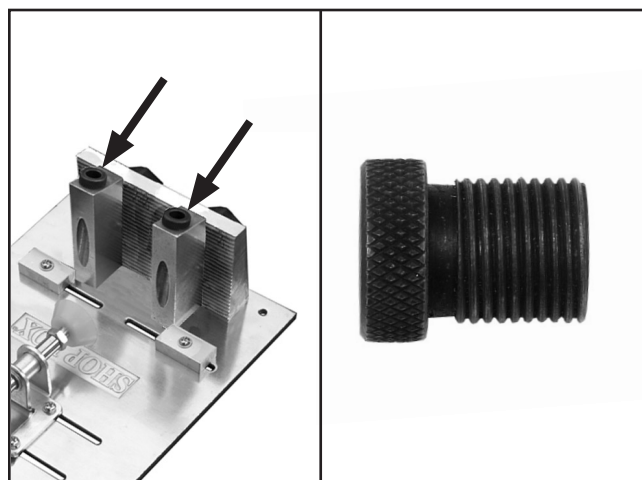
2. Install one of the included square drivers into your drill.
3. Screw the two workpieces together using the included square drive wood screws.

**Note:** *Some workpiece separation is normal at this stage. The wood screw will pull both workpieces together when completely installed.*

4. **Figure 4** shows a cross-section of a completed pocket hole joint.



**Figure 4.** Cross section of a pocket hole joint.



**Figure 5.** Model H7933 drill guide (Part # PH7933001).

## Replacement Drill Guides (Figure 5)

Replacement  $\frac{3}{8}$ " drill guides are available from Grizzly Industrial as **Part # PH7933001**.

*If you need help with your new pocket hole jig kit, call our Tech Support at: (570) 546-9663.*