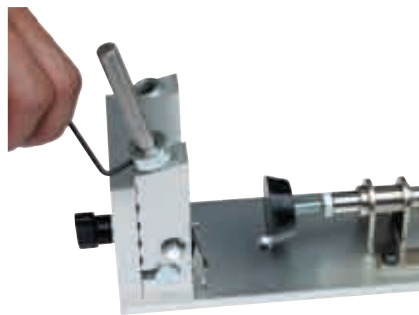


Step Two: Center Distance Setting Continued

The center markings on the jig begin at zero in the middle so you need to be able to divide your center distance in half and set each bushing to that number, to the left and to the right of the zero mark. Just loosen the locking knob slightly... enough to allow you to slide the guides... and slide them to the position you've decided. Lock them tight. If the guides are difficult to slide, a little paraffin wax or floor paste wax rubbed on the round guide rod and on the vertical steps in the back of the guides will make them move freely.

Step Three: Drill Stop Collar Setting



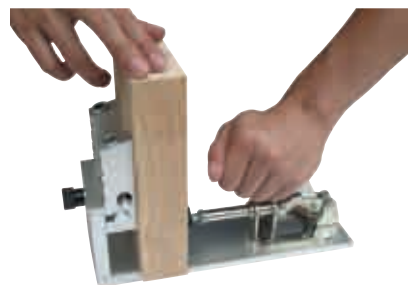
Setting the drill bit stop collar position is the easiest part of the entire process. Just drop the drill bit through the guide bushing allowing the point to rest on the base of the jig. Slide the stop collar over the shank of the drill bit & allow it to rest on the top of the guide bushing. Lock in place with the appropriate hex wrench supplied in the kit. Pull the bit out of the guide &

install it into your drill's chuck and you are ready to drill.

The only variation to this setting we've come across is when you have set the guides to the thickest setting of 1-1/2". The remaining shank of the drill bit that sticks out of the guide is short & after installing the stop collar, some drills cannot get a good grip on the remaining shank. If your drill is one of these, we recommend you to forget using the stop collar in this situation. Just position your drill chuck onto the drill bit shank while it's still in the guide & tighten it with the front of the drill chuck touching the top of the guide bushing the same as the stop collar would have. The drill chuck performs the same function as the stop collar in this case & it gives your drill enough drill shank to grip onto. I have an 18 volt 1/2" battery drill I like to use and I found I have to do this for it. With your guides set to the appropriate height and center distance and your drill bit stop collar set and chucked in your favorite drill, you're almost ready to drill pocket holes. Fasten your pocket jig down to a work bench top or flat solid surface so it's secure. You'll be using a power drill and you don't want the jig to slip around while you are drilling.

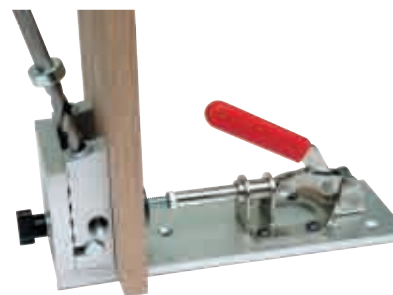
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Step Four: Clamp



Position your material in the jig and adjust the clamp pad so the pressure is good and strong enough to hold the material in place while you do your drilling.

Step Five: Drilling the Pocket Hole



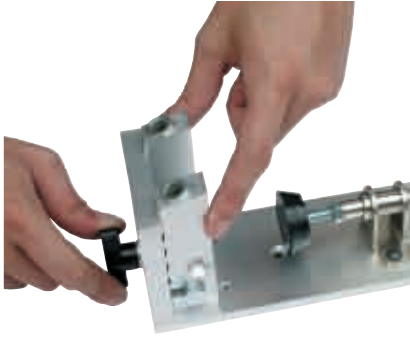
Start the drill bit into the guide bushing and just before you make contact with the wood, pull the trigger of the drill to bring the RPM of the drill bit up to full speed before touching the material.

If you neglect to do this you risk breaking the small diameter area of the drill bit rendering it useless. We do not warrantee the drill bit against breakage because of this. We have many happy customers using their original drill bit as supplied with the kit because they understood this principle.

By the way, the first several times that you use the pocket jig, you will see small black paint chips and metal cuttings in the drilled dust and in the drilled hole. This is normal as the drill bit makes it's own "seat" in the area of the guide beyond the hardened bushing that guides the bit. This is normal and not detrimental to the life of the bit or the jig. If you only use the jig for drilling soft wood and then later try it in hard wood, the same chips may be seen again. Hardwood causes higher stresses on the drill bit. Full RPM's and slow, even feeding of the bit into the wood will increase the life of the bit and reduce the stress on the jig in all drilling operations regardless of hard or soft wood being drilled.

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For Difficult Pockets



1. Remove the guide bushings and bar from the main jig.



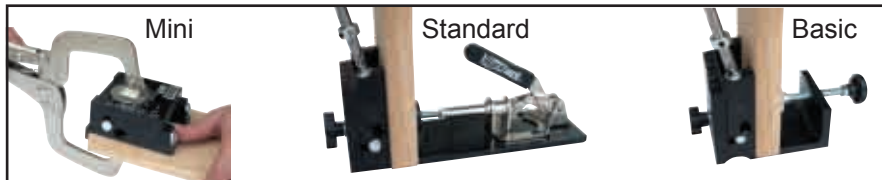
2. Place the guide bushings & bar onto portable base. Insert the provided cap screw into the back side of the jig.



3. Adjust for center distance and material thickness. Tighten with hex wrench.



4. Locate and retain in place with a face clamp. Drill pockets as required.



Both the Standard and the Mini are included in the Deluxe Kit



Ask your dealer:

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- BlackJack Face Clamps
- BlackJack Drill Bits
- BlackJack Clamps & Guides
- BlackJack Clamps & Racks
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BlackJack™

Deluxe Pocket Jig Instructions

Patent #2468382

The **BlackJack Pocket Jig** is unique in that the drill guides can be adjusted for varying material thickness and varying center distances between them. This is the feature that allowed us to obtain the patent on the jig's design and it's the feature that makes it a dream to use in comparison to other jigs on the market.

5 preset material thicknesses: 1/2", 3/4", 1", 1-1/4", 1-1/2"

Step One: Wood Thickness Setting



Standard shown

The first step is to adjust the guides vertically to match as closely as possible the thickness of material you are drilling. You will see five different settings laser etched onto the back of the drill guide support. If your material thickness is between any two of these settings, you have the choice to set the guides to the

next thinner or thicker setting. Usually it doesn't matter. It's never mattered to any project I've worked on but it remains your choice if you are in this situation.

Step Two: Center Distance Setting



Standard shown

Once you have the guide height determined and you've lifted the guides to that setting and tightened the locking knob, you may want to adjust the center distance between the guides to match your project. If you are making the face frame for a kitchen cabinet that's 1-1/2" wide,

you'll likely want the centers at 7/8" to leave a little material at either side of the drilled holes. If you are installing a partition wall and you're drilling the ends of 2x4's (1-1/2" setting), you might want the center distance set at 2-1/2".