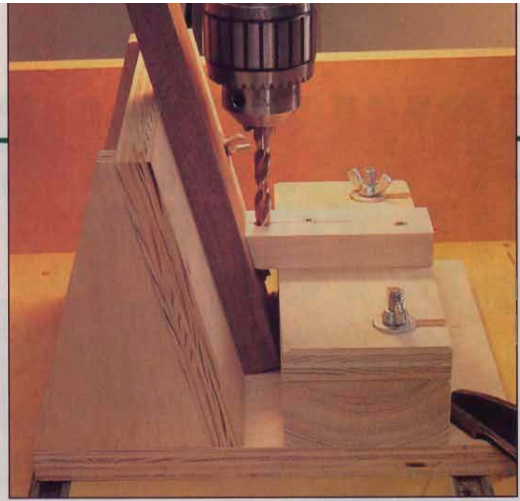


# on-the-money drill-press pocket hole jig



No need for a store-bought jig with this shop aid. We built ours out of  $\frac{3}{4}$ " plywood and a few pieces of solid stock cut to the dimensions shown on the Exploded View drawing.

Build and assemble the jig as shown. Mark the hole-location centerline on the face of the workpiece, and place the workpiece against the angled fence.

Slide the guide assembly firmly against the workpiece, as shown in the Front Section View drawing below, aligning the centerline on the guide with the one marked on the workpiece. The slots in the guide block allow you to adjust the guide for different thicknesses of wood. Slide the stopblock up to the edge of the workpiece, and tighten it in place. (Because most stiles and rails require a pair of pocket holes, we drill the first set of holes at one setting, loosen the wing nut, move the stopblock, and drill the second set of holes at the next setting.)

Chuck a  $\frac{3}{8}$ " brad-point bit into your drill press (longer bits allow more clearance). Align the  $\frac{3}{8}$ " hole in the guide with the  $\frac{3}{8}$ " bit. Clamp the base of the jig firmly to your drill-press table. Drill the hole into, but not through the stock, as shown on the Front Section View drawing. Once the right depth has been determined, set the stop on your drill press to drill to the exact depth each time. Later, use a portable drill and a  $\frac{1}{8}$ " bit to drill a

pilot hole through the center of the angled  $\frac{3}{8}$ " counterbore to finish creating the pocket hole for the screw. **Note:** We used our jig on a heavy-duty benchtop drill press with a spindle travel of  $\frac{3}{4}$ ". But, we found it wouldn't work on a small benchtop model with a 2" spindle travel or models with limited clearance on the side where the drill-press stop juts out.

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