

To create wood plugs for pocket holes you must build a fixture to hold the workpiece at a 15 degree angle from vertical as shown in Figure 1.

FIGURE 1. FIXTURE TO HOLD WORKPIECE

3/4" stock works well for plug material. Secure fixture in vise and clamp workpiece to fixture as shown in Figure 2. It is important that vise is secured to table to prevent movement of workpiece while drilling plug. Position workpiece so that edge of workpiece and inside of cutter is like that shown in Figure 3. Placing cutter too far back will result in endgrain on the face of the plug. Moving cutter too far forward will result in a plug that is possibly too short.

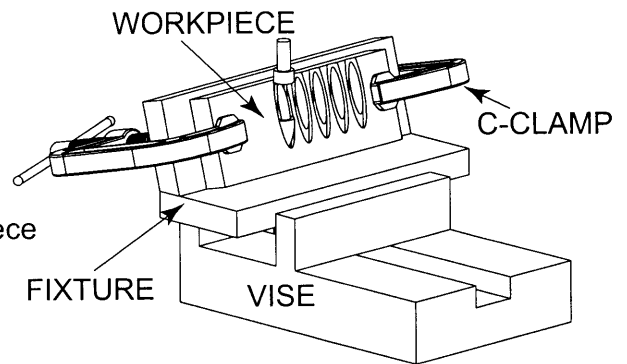


FIGURE 2. PLUG CUTTING SETUP

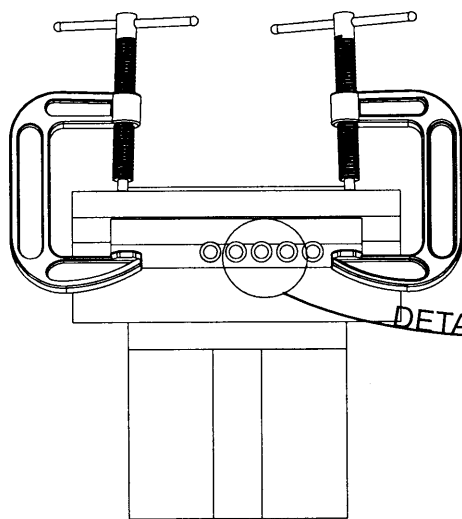


FIGURE 3. TOP VIEW OF SETUP

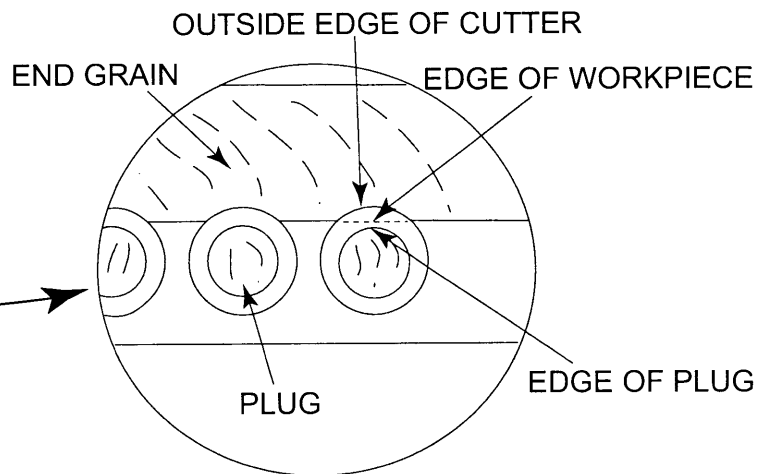


FIGURE 3A. DETAIL OF FIGURE 3

Start drill press and feed cutter into workpiece. Begin with an RPM of 1000 and test quality of cut. Some species of wood may require slower or faster spindle speed. Start with a slow feed rate to obtain a crisp edge on the top of the plug. Feed into workpiece until there is a small amount of clearance between top of plug and cutter. See Figure 3A. Once full depth is achieved, set drill press depth stop. To drill additional plugs, loosen vise, move workpiece over, tighten vise and drill plug.

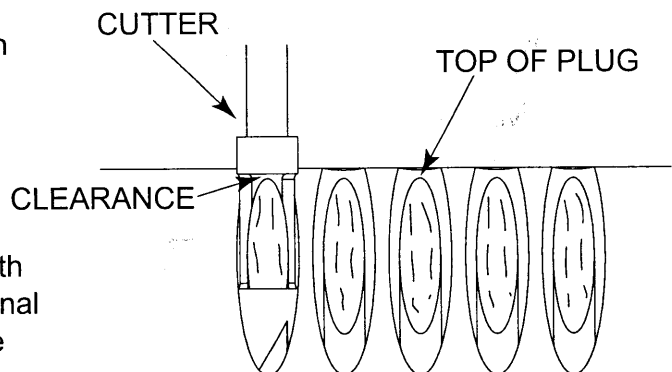


FIGURE 4. FINAL CUTTER DEPTH

Resaw plugs out of workpiece using a bandsaw. Set the table at 45 degrees and position blade so as to just cut plugs free. Be sure to cut the 45 degree angle in the correct direction. See Figure 5.



FIGURE 5. SIDE VIEW OF PLUG