

Ball Lock[®] Mounting System Installation Instructions

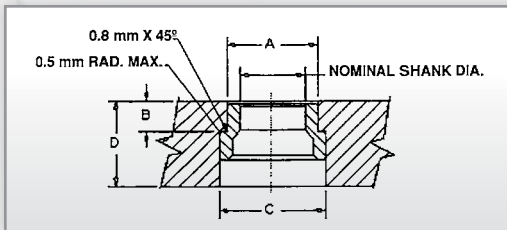
(Metric) Back Mount Style Receiver Bushing

1. Drill thru hole approximately 0.76 mm smaller than final bore diameter
2. Counterbore "C", maintaining "B" depth
3. Finish bore not to exceed 0/013 mm smaller than actual O.D. "A"
4. Press receiver bushing into counterbored hole

NOTES:

Installed bushings should be approximately 0.30 mm below subplate surface.

When installing the Back Mount Bushing the maximum interference fit between bore and bushing O.D. should not exceed 0.013 mm.



Metric Back Mount Bushing Installation Dimensions

Part Number	Shank Dia. (mm)	Actual O.D. +0.04 +0.03 A	Depth +/- .025 B	C-Bore C	Min. Sub-Plate Thickness D
49566	13	20	6.92	26	20
49567	16	22	7.24	29	20
49561	20	28	8.74	33	25
49562	25	35	10.54	41	25
49563	30	42	10.95	49	30
49564	35	48	12.50	55	35
49565	50	67	15.75	76	45

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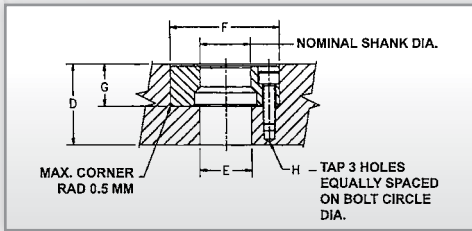
(Metric) Face Mount Receiver Bushing

1. Drill thru hole ('E' Diameter)
2. Counterbore, approximately 0.76 mm smaller than final bore diameter maintaining "G" depth
3. Finish bore hole to "F" and "G" dimensions
4. Drill and tap for mounting screws
5. Install receiver bushing; tap lightly into hole
6. Install mounting screws



NOTE:

Installed bushings should be approximately 0.30 mm below subplate surface.



Metric Face Mount Bushing Installation Dimensions

Part Number	Actual O.D. -0.01 -0.02	Shank Diameter (mm)	Minimum Sub-Plate Thickness D	Clearance Drill Diameter E	Bore +0.010 +0.003 F	Depth +0.025 -0.025 G	Tap X Depth 3 Pcs. Equally Spaced H	Bolt Circle Diameter	Mounting Screw Torque N-m
49566	35	13	20	13.5	35	11.91	M4x0.7x7	25	6.0
49557	37	16	20	21.0	37	11.91	M4x0.7x7	29	6.0
49551	45	20	25	21.0	45	16.21	M5x0.8x9	35	12.0
49552	55	25	30	25.5	55	20.32	M6x1.0x10	42	20.0
49553	60	30	35	30.5	60	22.15	M6x1.0x11	48	20.0
49554	70	35	40	40.0	70	22.99	M8x1.25x17	56	48.0
49555	92	50	50	55.0	92	31.50	M10x1.5x18	75	100.0