

Ball Lock® Mounting System Installation Instructions

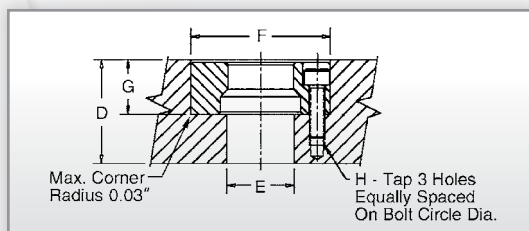
Installing the Face Mount Receiver Bushing:

1. Drill thru hole ('E' Diameter)
2. Counterbore, approximately 0.030 under 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 .012" below subplate surface



Face Mount Bushing Installation Dimensions

Part Number	Actual O.D. +.0000 -0.0004	Shank Diameter (mm)	Clearance Drill Diameter E	Bore +.0005, -.0000 F	Depth +.002, -.000 G	Min. Subplate Thickness D	Tap Size & Depth H	Bolt Circle Diameter 3 PL	Mounting Screw Torque
49506	1.375	13	11/16	1.375	0.469	3/4	8-32x5/16	0.984	36
49507	1.437	16	13/16	1.437	0.469	3/4	8-32x5/16	1.125	55
49501	1.687	20	13/16	1.687	0.637	1	10-32x3/8	1.362	55
49502	2.062	25	1	2.062	0.799	1-1/4	1/4-28x1/2	1.644	200
49503	2.265	30	1-3/16	2.265	0.871	1-3/8	1/4-28x3/4	1.876	200
49504	2.687	35	1-9/16	2.687	0.904	1-1/2	5/16-24x7/8	2.178	400
49505	3.500	50	2-5/32	3.500	1.239	2	3/8-24x1	2.916	700

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Installing the Back Mount Receiver Bushing:

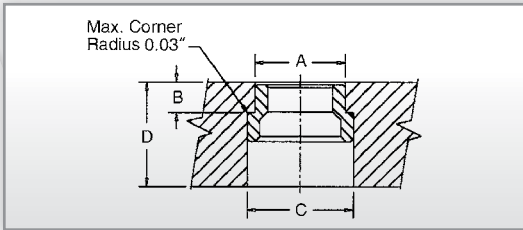
1. Drill thru hole approximately .030 under bore diameter
2. Counterbore 'C'; maintaining 'B' depth
3. Finish bore not to exceed .0005" smaller than actual O.D.
4. Press receiver bushing into counterbored hole



NOTE:

Installed bushings should be approximately .012" below subplate surface

When installing the Back Mount Bushing, the maximum interference fit between bore and bushing O.D. should not exceed .0005".



Back Mount Bushing Installation Dimensions

Part Number	Shank Dia. (mm)	Actual O.D. +0.0000 -0.0004 A	C-Bore ±.006 C	Depth +.000 -.002 B	Minimum Sub-Plate Thickness D
49516	13	0.7870	1.000	0.277	3/4
49517	16	0.8760	1.155	0.285	3/4
49511	20	1.0950	1.280	0.345	7/8
49512	25	1.3763	1.593	0.416	1
49513	30	1.6264	1.906	0.432	1-1/4
49514	35	1.8764	2.155	0.493	1-5/16
49515	50	2.6269	2.988	0.621	1-3/4