

INTERCHANGEABLE THUMB

INSTALLATION INSTRUCTIONS:



OUTER SLEEVE



INNER SLEEVE

STEP #1: Set pitches for bowler's thumbhole on press. Line up using the Ultimate 1-1/2" bit (figure 1). Remove the 1-1/2" bit and drill a pilot hole (it is recommended that you drill a pilot hole). Using the 1-1/2" bit, drill the outer sleeve hole to the preset collar depth (figure 2). Bevel the hole to remove any sharp edges and vacuum hole, cleaning it of all debris.

STEP #2: Rough up the outer sleeve to strengthen adhesion to the ball (figure 3).

STEP #3: Apply Ultimate 5 minute epoxy (figure 4) to the inside hole of the ball. Then insert the outer sleeve in the ball ensuring that the scribe line with the marker on the auto depth is at 6 o'clock (figure 5). Using a plug cutter or router, cut off the top of the auto depth on the outer sleeve to be flush with the ball.

NOTE – It is recommended that you cut down the outer sleeve auto depth before installing and drilling the inner sleeve and slug. Also, make sure all debris has been removed from the outer sleeve hole before installing, locking and drilling the inner.

STEP #4: Place a small amount of lubricant (Vaseline or bar soap) on the bottom two tabs of the inner sleeve. Insert the inner sleeve into the outer sleeve. The inside sleeve has two large tabs on the one side and two small tabs on the opposite side. Inside sleeve will only fit into the out sleeve one way. Do not force the inner sleeve into the outer sleeve. Once sleeve is inserted, turn inner sleeve 90 degrees clockwise until locking sound is heard and felt (figure 6). Once inner sleeve is locked into place, you can start drilling the thumb hole. We recommend drilling through the bottom of the slug and inner sleeve.

STEP #5: After the hole is drilled out to the preferred size, set pitches on drill press back to zero and line plug cutter or router up with the top of the inner sleeve (figure 7). Once lined up, cut excess material off until flush with the ball. Bevel the hole and remove any excess debris (Figure 8).



FIGURE 1



FIGURE 2



FIGURE 3



FIGURE 4



FIGURE 5



FIGURE 6



FIGURE 7



FIGURE 8