

## INSTALLATION GUIDE FOR THE “ULTIMATE THUMB”

**STEP #1:** SET PITCHES FOR BOWLER ON PRESS, THEN USING 1 ½” DRILL BIT, DRILL OUTER SLEEVE HOLE 2 7/8” DEEP.(FIGURE 2). **TO ELIMINATE ANY POTENTIAL SLIDING ONLY DRILL 2 7/8” DEEP.** MEASUREMENT STARTS WHEN OUTER WALL OF THE BIT DRILLS INTO THE BALL (FIGURE 1).



(FIGURE 1)



(FIGURE 2)

**STEP #2:** USING 80 – 100 GRIT SANDPAPER (FIGURE 3), SAND THE OUTSIDE OF THE OUTER SLEEVE (FIGURE 4) TO STRENGTHEN ADHESION TO THE BALL.



(FIGURE 3)



(FIGURE 4)

**STEP #3:** USING ULTIMATE ULTRA GEL GLU THICK FORMULA (FIGURE 5). APPLY GLU TO THE INSIDE HOLE OF THE BALL (5 MINUTE EPOXY ULTIMATES #BP9024 RECOMMENDED FOR STRONGEST ADHESION). THEN INSERT THE OUTER SLEEVE INTO THE BALL UNTIL THE AUTO DEPTH IS FLUSH WITH THE BALL (FIGURE 6). LINING UP THE SCRIBE LINE WITH THE MARKER ON THE AUTO DEPTH @ 6 o’Clock. **USING A PLUG CUTTER OR ROUTER, CUT OFF TOP OF AUTO DEPTH ON OUTER SLEEVE TO BE FLUSH WITH BALL.**



(FIGURE 5)



(FIGURE 6)

**\*NOTE:** TO PREVENT AGAINST ADHESION BETWEEN THE INNER SLEEVE AND THE OUTER SLEEVE, WE RECOMMEND CUTTING DOWN THE OUTER SLEEVE AUTO DEPTH, BEFORE INSTALLING AND DRILLING THE INNER SLEEVE AND SLUG.

**\*NOTE: MAKE SURE ALL DEBRIS IS VACCUUMED OUT OF THE OUTER SLEEVE HOLE. ONCE THE OUTER SLEEVE IS INSTALLED, VACUUM ANY EXCESS DEBRIS FROM THE INSTALLED SLEEVE. THE HOLE SHOULD BE COMPLETELY CLEAN OF ANY DEBRIS BEFORE INSTALLING, LOCKING, AND DRILLING THE INNNER SLEEVE.**

**STEP# 4:** YOU ARE NOW READY TO INSTALL YOUR INNER SLEEVE. PLACE A SMALL AMOUNT OF LUBRICANT (CHAPSTICK, VASOLINE, BAR SOAP, SOAP STONE) ON THE BOTTOM 2 TABS OF THE INNER SLEEVE. INSERT INNER SLEEVE (FIGURE 7 & 8) INTO OUTER SLEEVE (FIGURE 9). INSIDE SLEEVE HAS 2 LARGE TABS ON ONE SIDE AND 2 SMALL TABS ON THE OPPOSITE SIDE. INSIDE SLEEVE WILL ONLY FIT INTO OUTER SLEEVE ONE WAY. **DO NOT FORCE THE INSIDE SLEEVE INTO THE OUTER SLEEVE!!!** ONCE SLEEVE IS INSERTED, TURN INNER SLEEVE 90 DEGREES CLOCKWISE UNTIL LOCKING SOUND IS HEARD AND FELT. ONCE INNER SLEEVE IS LOCKED INTO PLACE, YOU CAN START DRILLING THE THUMB HOLE (FIGURE 9). WE RECOMMEND DRILLING THROUGH THE BOTTOM OF THE SLUG AND INNER SLEEVE.



(FIGURE 7)



(FIGURE 8)



(FIGURE 9)

**\*\*\*\*DO NOT CUT DOWN INNER SLEEVE AND OUTER SLEEVE FLANGE AT THE SAME TIME\*\*\*\***

**STEP #5:** AFTER HOLE IS DRILLED OUT TO PREFERRED SIZE (FIGURE 9), SET PITCHES ON DRILL PRESS BACK TO (X:0.00 & Y:0.00). ONCE PITCHES ARE SET AT ZERO, LINE PLUG CUTTER OR ROUTER UP WITH THE TOP OF THE INNER SLEEVE. ONCE LINED UP CUT EXCESS MATERIAL OFF UNTIL FLUSH WITH BALL (FIGURE 11). SAND AND FINISH HOLE TO COMPLETE (FIGURE 12)



(FIGURE 10)



(FIGURE 11)



(FIGURE 12)

