



## Modern Industries, Inc.

613 WEST 11<sup>th</sup> STREET • P.O. BOX 399  
ERIE, PENNSYLVANIA 16512-0399  
TEL. (814) 455-8061 Ext. 233 FAX (814) 453-4382  
Web Site: www.mpwer.com



# How to Machine the pockets for the SpeedLoc Receivers Reference Charts in Catalog for the dimensions of the pocket profile

## Threaded Receiver

1. Drill to the minor diameter of the thread.(D)
2. Circle or Helical mill Counter bore (A) to depth (B) leaving .010" to .015" on the (A) diameter.
3. Finish bore the counter bore to the (A) dimension (**This is the critical Dimension**) and depth (B). *Do not attempt to Circle or Helical mill to final (A) dimension.*
4. .025" x 45 degree Chamfer on the Diameters (D) & (A). (Ref. E)
5. Thread Mill or Tap thread required (D).
6. Position tolerance between the receivers is .0006" true position.

## Face Mount Receiver

### If you have Jergens Ball Lock already Mounted

1. Remove the Jergens Receiver.
2. Replace with Mpower SpeedLoc Receiver.

### If you have a blank Plate and Want the Face Mount Receiver

(We recommend the Threaded Receiver if you are starting from scratch)

1. Drill to the clearance diameter (A).
2. Circle or Helical mill Counter bore (B) to depth (C) leaving .010" to .015" on the (B) diameter.
3. Finish bore the counter bore to the (B) dimension (**This is the critical Dimension**) and depth (C). *Do not attempt to Circle or Helical mill to final (B) dimension.*
4. .025" x 45 degree Chamfer on the Diameters (B) & (A). (Ref. G)
5. Drill and tap three mounting holes (D).
6. Position tolerance between the receivers is .0006" true position.

## **How to Machine the Holes for the SpeedLoc Locators** **Reference Charts in Catalog for the dimensions of the pocket profile**

### **Standard Locator no Liner**

1. Remove material to Diameter (A)  $+0.015$ .
2.  $.025''$  x 45 degree Chamfer on the Diameters (A). (Ref. F)
3. Position tolerance between the Locators is  $.0006''$  true position.

### **Standard Location Liner**

1. Remove material to  $.010''$  to  $.015''$  Smaller than diameter (C).
2.  $.025''$  x 45 degree Chamfer on the Diameters (C) before Boring
3. Finish bore to the (C) dimension **Tolerance is  $-.0006/-0.001$  (This is the critical Dimension)**. *Do not attempt to Circle or Helical mill to final (C) dimension.*
4. Position tolerance between the Liners is  $.0006''$  true position.
5. You may have to lap out the Inside Diameter of Liner after installation if it may closes down some.

## **How to Machine the Holes for the SpeedLoc Compact Head** **Locators** **Reference Page Charts in Catalog for the dimensions of the pocket profile**

### **Compact Head Locator no Liner**

1. Remove material to the diameter (A)  $+0.015$ .
2. Circle or Helical mill Counter bore (F)  $+0.015$  to depth (E)  $+0.015$ .
3.  $.025''$  x 45 degree Chamfer on the Diameters (A) & (F). (Ref. G)
4. Position tolerance between the Locators is  $.0006''$  true position.

### **Stepped Location Liner**

1. Remove material  $.010''$  to  $.015''$  Smaller than diameter (C).
2. Circle or Helical mill Counter bore (D) to depth (E).
3. Finish bore the thru bore to the (C) dimension **Tolerance is  $-.0006/-0.001$  (This is the critical Dimension)**. *Do not attempt to Circle or Helical mill to final (C) dimension.*
4.  $.025''$  x 45 degree Chamfer on the Diameters (C) & (D). (Ref. G)
5. Position tolerance between the Liners is  $.0006''$  true position.
6. You may have to lap out the Inside Diameter of Liner after installation, it may close down some.