

Automatic Drill Riveter Tools

Drill Riveting



MASTER
COLLETS
Pg U6



FINGER
HOLDERS
Pg U9



UPPER PRESSURE
FOOT BUSHINGS
Pg U6



FLUSH & UNIVERSAL
TYPE ANVILS
Pg U8



LOWER STAKE
ASSEMBLIES
Pg U12



UPPER
ANVIL
ASSEMBLIES
Pg U3



ANVIL ADAPTER
Pg U8



FINGERS Pg U9



RETURN
SPRINGS
Pg U9



UDB-85 PIN POSITION
GAUGES Pg U38



UDB-85-10 PIN
POSITION
GAUGES
Pg U39



ANVIL
BUTTONS
Pg U14



UDB-34D PIN POSITION
GAUGES Pg U36



UPPER
ANVIL
ASSEMBLIES
Pg U7



CLAMP
SLEEVES
Pg U5



UPPER ANVIL
ADAPTER
Pg U3



GUIDE
PROTECTORS
Pg U14



BUCKING BARS
Pg U24 - U26



PLATE NUT DRILL JIGS
Pg U27 - U35

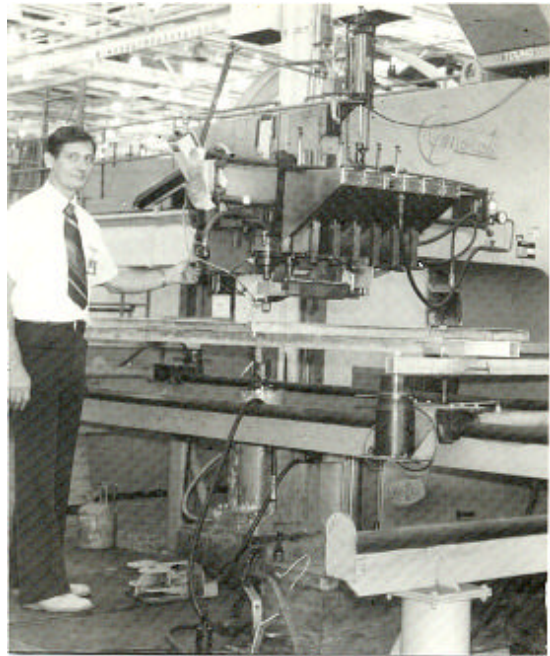
Anvil Assemblies

Drill / Riveter Tooling Technology

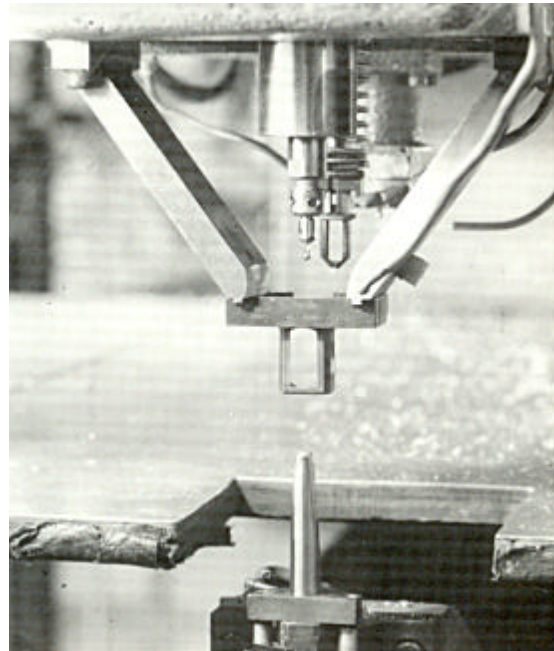
UPPER ANVIL ASSEMBLY



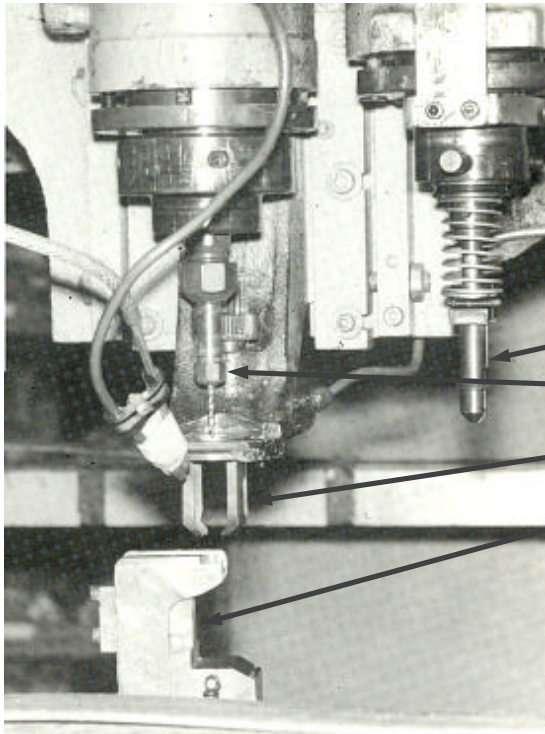
UNITED has worked closely with Mr. Roy Toomay in the development of our Automatic Drill/Riveter Tooling. He is shown with a G39A machine.



LOWER STAKE TYPE ANVIL



PRESSURE FOOT BUSHING



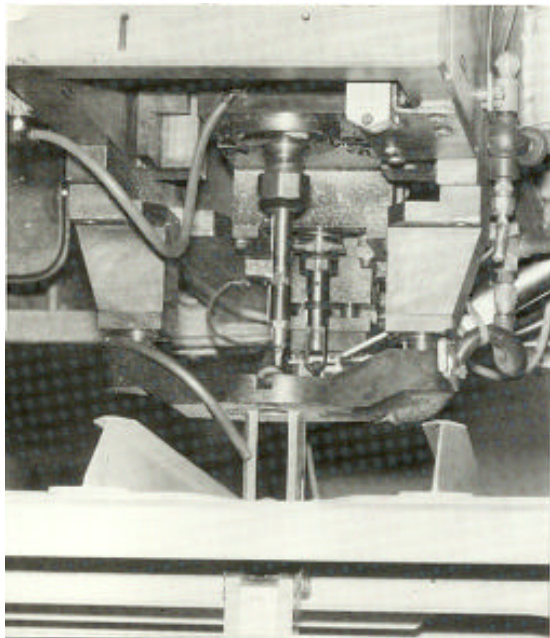
Shown on left:

Upper Anvil Assembly

Drill Spindle Assembly

Pressure Foot Bushing

Lower Anvil Assembly
(Offset C)

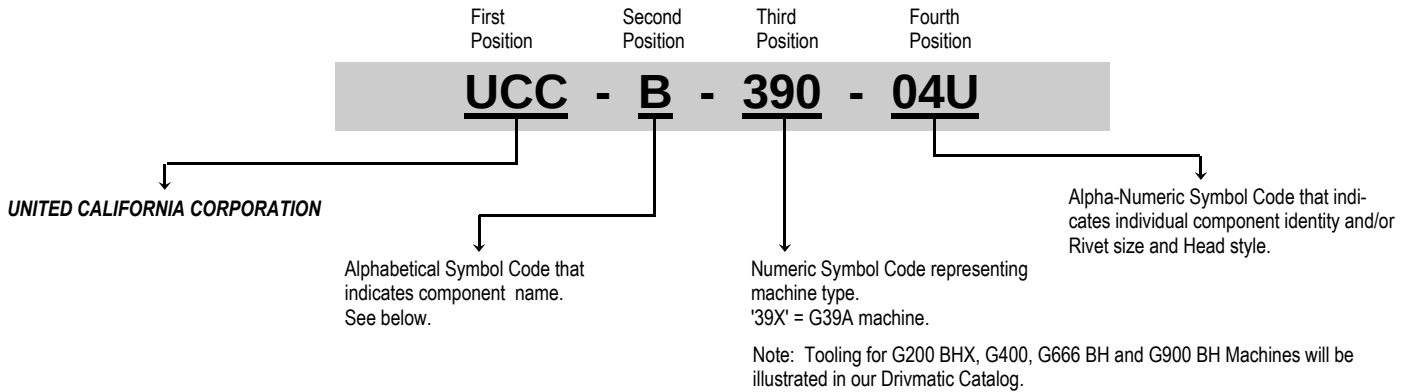


UPPER ANVIL ADAPTER



Part No. Components For Ordering Anvil Assy.

SAMPLE PART NUMBER



SECOND POSITION: Alphabetical Symbol Code indicating Component Name. AL=Lower Anvil; AU=Upper Anvil.

CODE	NAME	FITS	CODE	NAME	FITS	CODE	NAME	FITS
AU	ASSEMBLY, UPPER ANVIL		LB	BASE	AL	RG	RAIL GUIDE	AL
FH	FINGER HOLDER	AU	CP	CLAMP PIN	AL	DP	DOWEL PIN	AL
RS	RETURN SPRING	AU	P	PIN	AL	SH	SOCKET HEAD CAP SCREW	AL
GS	GARTER SPRING	AU	AS	LOWER ANVIL SKIRT	AL	LA	LOWER ANVIL	AL
OR	'O' RING	AU	CS	REPLACEABLE CLAMP SLEEVE	AL	BP	BASE PIN	AL
F	FINGER	AU	AL	ASSEMBLY, LOWER ANVIL	AL	AP	ANVIL PIN	AL
B	BUTTON	AU & AL	IA	INNER ANVIL	AL	AB	ANVIL BASE	AL
A	ANVIL	AU	SR	SNAP RING	AL	SB	STRIPPER BOLT	AL
AD	ADAPTER	AU	SS	STAKE SCREW	AU & AL	LS	LOCK SPRING	AL
PB	PRESSURE FOOT BUSHING	AU	RB	RUB STRIP	AL	TS	TENSION SPRING	AL
PP	PRESSURE PLATE	AU	CR	CLAMP RAIL	AL	GP	GUIDE PROTECTOR	AL
LC	LOWER OFFSET 'C' FRAME ASSY	AU	BA	BASE ADAPTER	AL	FS	FLUSH SCREW	AL

THIRD POSITION: Numeric Code indicating Machine type.

CODE	Explanation
390	Indicates component applies to Upper Tooling and is interchangeable between short and long series.
390S	Indicates component applies to Lower Stake Type Anvil.
390C	Indicates component applies to Lower 'C' Type Anvil.
391	Indicates component applies to Upper Tooling—Short series Only.
392	Indicates component applies to Upper Tooling—Long series Only.

Drill Spindle and Pressure Foot Assy

Assemblies

PART RELATIONSHIP DRAWING

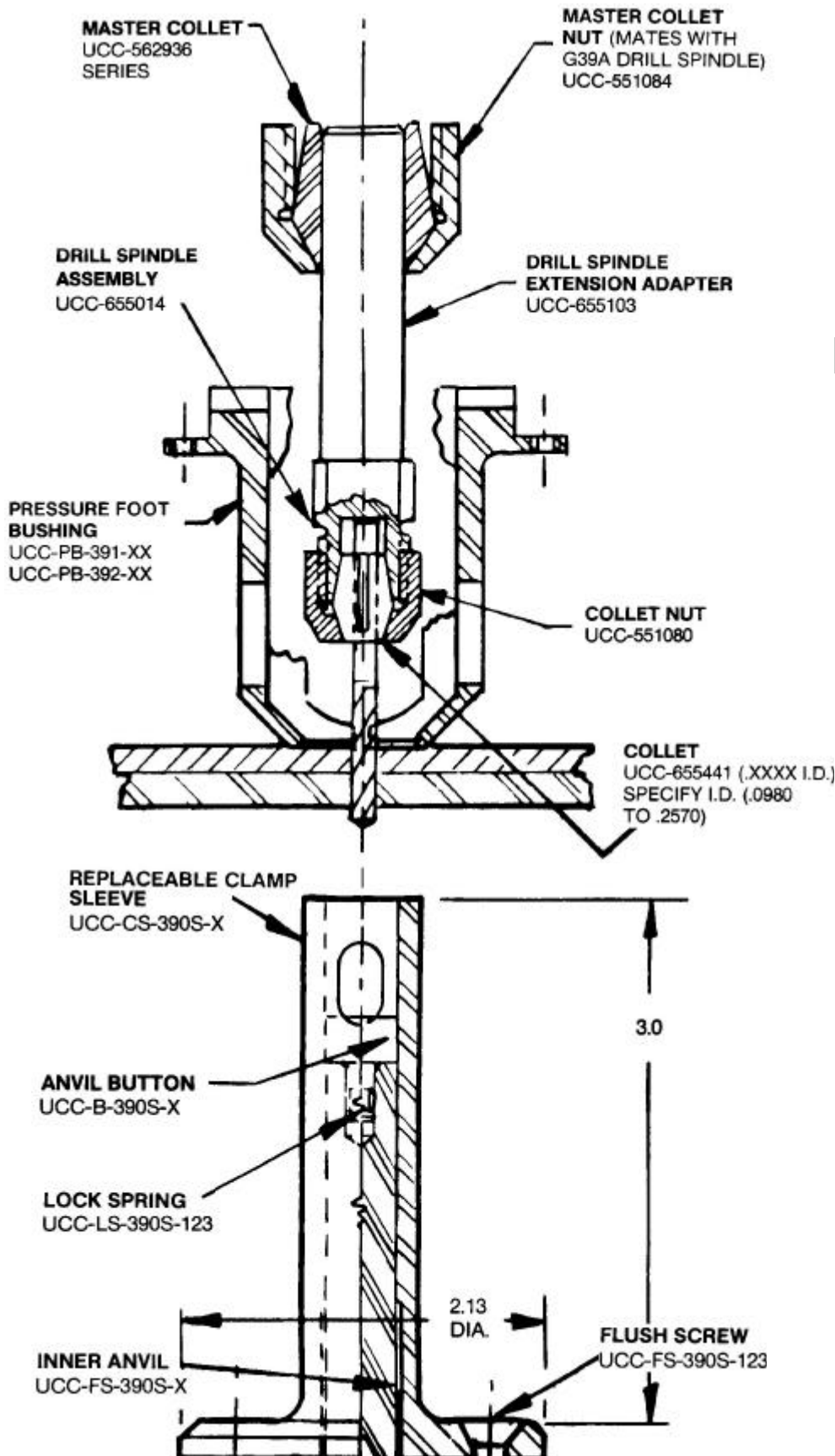
Full Scale Charts
Available on Request.

Call **UNITED**
For Information.

PRESSURE FOOT BUSHING



CLAMP SLEEVE

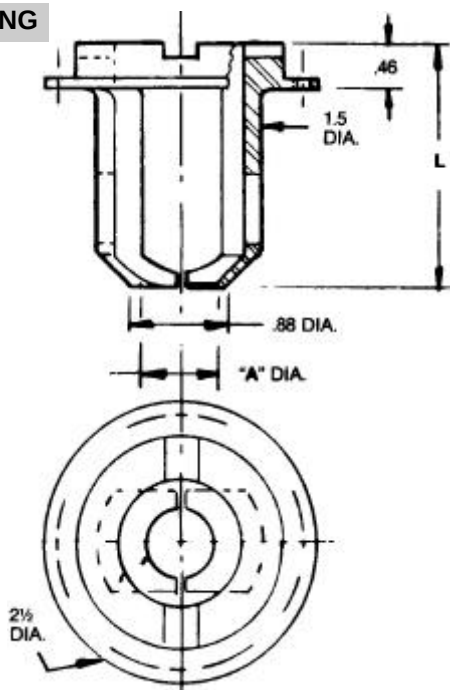


Accessories for Automatic Drill Riveters

Upper Pressure Foot Bushings & Drill Spindle Adapter Extensions

PRESSURE FOOT BUSHINGS

UPPER PRESSURE FOOT BUSHING



Factory modified variations are possible to suit customer part.

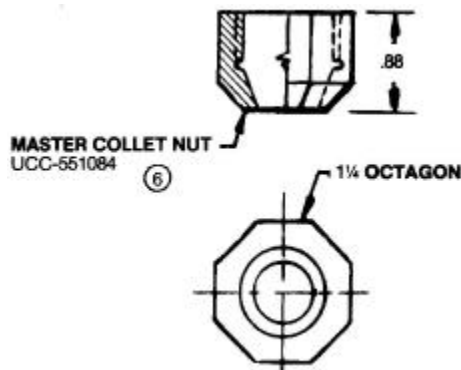
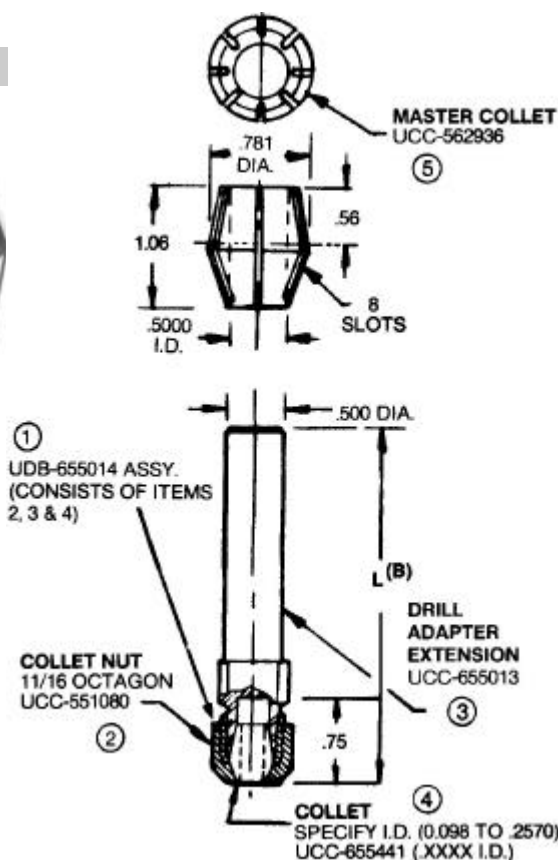
Submit part dimensional data for corresponding UCC part number.

Call **UNITED** today!

UPPER PRESSURE FOOT BUSHING PART NO.	RIVET DIA.	A DIA.	L
UCC-PB-391-01	1/8, 5/32	.62	1.775
UCC-PB-391-02	3/16, 1/4	.56	1.775
UCC-PB-392-01	1/8, 5/32	.62	2.275
UCC-PB-392-02	3/16, 1/4	.56	2.275

DRILL SPINDLE ADAPTER EXTENSIONS

MASTER COLLET



PART NO.	PART NAME	ITEM NO.
UCC-655014	Spindle Adapter Extension Assembly (A) (B) See drawing and below.	1 (2, 3, 4)
UCC-551080	Collet Nut, 11/16 Octagon	2
UCC-655013	Drill Adapter Extension (B)	3
UCC-655441 (.xxxx I.D.)	Collet (.0980 to .2570 I.D.) (A)	4
UCC-562936	Master 'Y' Collet (.5000 I.D.)	5
UCC-551084	Master Collet Nut (1-1/4 Octagon)	6

(A) Customer to specify within I.D. Range shown.
(B) Length of Extension is 3.13 to fit long tooling, 2.63 for short tooling.

Upper Anvil Assembly

Upper Anvil Assemblies

PART RELATIONSHIP DRAWING

ANVIL ADAPTOR
UCC-AD-391-01 (LONG)
UCC-AD-392-01 (SHORT)

COMPLETE ASSEMBLY

WITH BUTTON TYPE ANVIL

UCC-AU-392-XF = Long Flush Button
UCC-AU-392-XU = Long Univ. Button
UCC-AU-391-XF = Short Flush Button
UCC-AU-391-XU = Short Univ. Button

WITH ONE PIECE ANVIL

UCC-AU-392-1 XF = SHORT FLUSH ANVIL
UCC-AU-392-1 XU = SHORT UNIV. ANVIL
UCC-AU-392-2 XF = LONG FLUSH ANVIL
UCC-AU-392-2 XU = LONG UNIV. ANVIL

DOWEL PIN
UCC-DP-390-01

RETURN SPRING
UCC-RS-391-01
UCC-RS-392-01

STAKE SCREW
UCC-SS-390-01

FINGER HOLDER
UCC-FH-391-XX
UCC-FH-392-XX

ANVIL
UCC-A-391-01
UCC-A-392-01
UCC-A-391-XX
UCC-A-392-XX

GARTER SPRING
UCC-GS-390-01

STAKE SCREW
UCC-SS-390-01

FINGERS
UCC-F-391-XX
UCC-F-392-XX

ANVIL BUTTON
UCC-B-390-XX

LOCK SPRING
UCC-LS-390-01

"O" RING
UCC-OR-390-XX

UPPER ANVIL ASSEMBLY

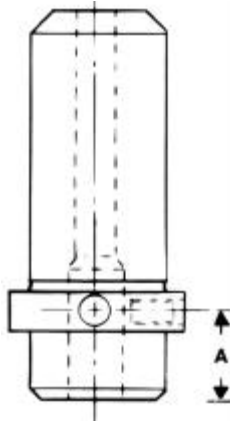


Anvil Assemblies

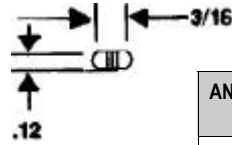
Upper Anvil Assembly Parts

UPPER ANVIL ASSEMBLIES

ANVIL ADAPTER

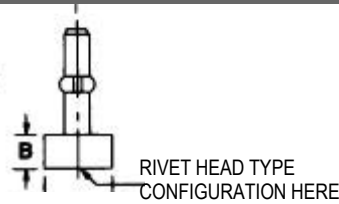


ANVIL ADAPTER PART NO.	A
UCC-AD-391-01	.563
UCC-AD-392-01	1.063

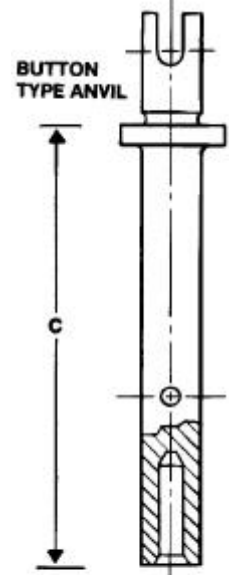


ANVIL LOCKSPRING PART NO.
UCC-LS-390-01

ANVIL BUTTON



ANVIL BUTTON PART NO.	NOM. RIVET SIZE	RIVET HEAD TYPE	A	B
UCC-B-390-5F	1/8, 5/32	FLUSH	.280	.250
UCC-B-390-6F	3/16	FLUSH	.360	.260
UCC-B-390-4U	1/8	UNIV.	.326	.240
UCC-B-390-5U	5/32	UNIV.	.360	.240
UCC-B-390-6U	3/16	UNIV.	.430	.247



BUTTON TYPE ANVIL PART NO.	C
UCC-A-391-01	2.937
UCC-A-392-01	3.437

FLUSH AND UNIVERSAL TYPE ANVILS



-8F

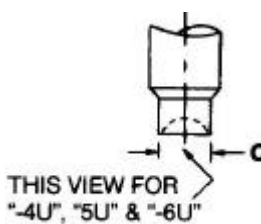


-5F & -6F

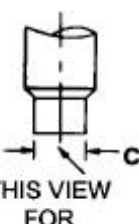


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FOR
8F
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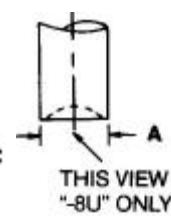
FLUSH & UNIV. ANVIL PART NO.	NOM. RIVET SIZE	RIVET HEAD TYPE	A	B	C
UCC-A-391-25F	1/8, 5/32	FLUSH	.474	3.187	.280
UCC-A-391-26F	3/16	FLUSH	.474	3.197	.360
UCC-A-391-28F	1/4	FLUSH	.604	3.202	.604
UCC-A-391-24U	1/8	UNIV.	.474	3.177	.326
UCC-A-391-25U	5/32	UNIV.	.474	3.183	.360
UCC-A-391-26U	3/16	UNIV.	.474	3.184	.430
UCC-A-391-28U	1/4	UNIV.	.604	3.170	.604
UCC-A-392-25F	1/8, 5/32	FLUSH	.474	3.687	.280
UCC-A-392-26F	3/16	FLUSH	.474	3.697	.360
UCC-A-392-28F	1/4	FLUSH	.604	3.702	.604
UCC-A-392-24U	1/8	UNIV.	.474	3.677	.326
UCC-A-392-25U	5/32	UNIV.	.474	3.677	.360
UCC-A-392-26U	3/16	UNIV.	.474	3.684	.430
UCC-A-392-28U	1/4	UNIV.	.604	3.670	.604



THIS VIEW FOR
"-4U", "-5U" & "-6U"



THIS VIEW FOR
"-5F" & "-6F"



THIS VIEW FOR
"-8U" ONLY

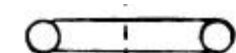
Drill/Riveter Tooling and Accessories for Automatic Drill Riveters

Finger Holding Assembly

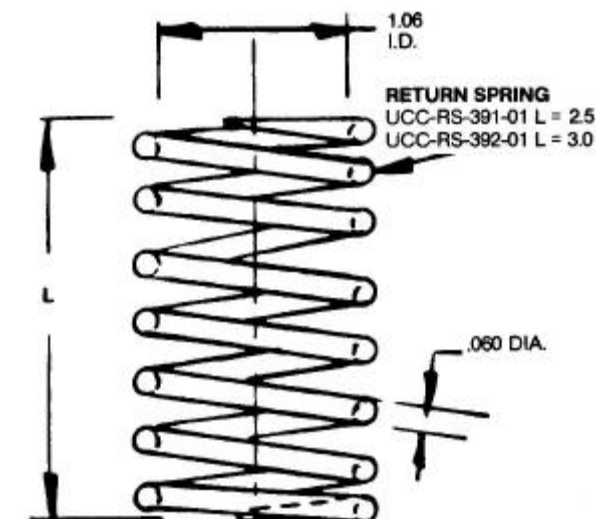
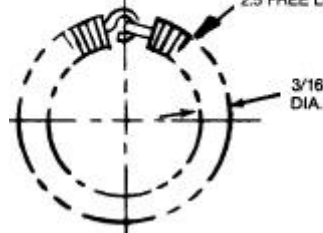
PART RELATIONSHIP DRAWING



GARTER SPRING



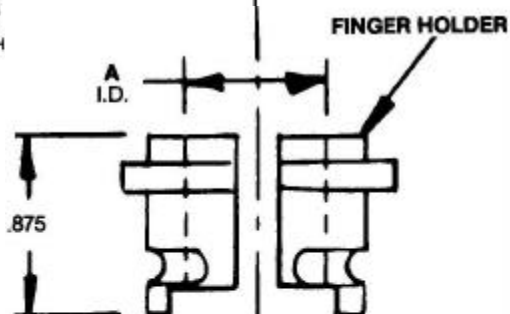
GARTER SPRING
UCC-GS-390-01
2.5 FREE LENGTH



RETURN SPRING
UCC-RS-391-01 L = 2.5
UCC-RS-392-01 L = 3.0



RETURN SPRING



FINGER HOLDER



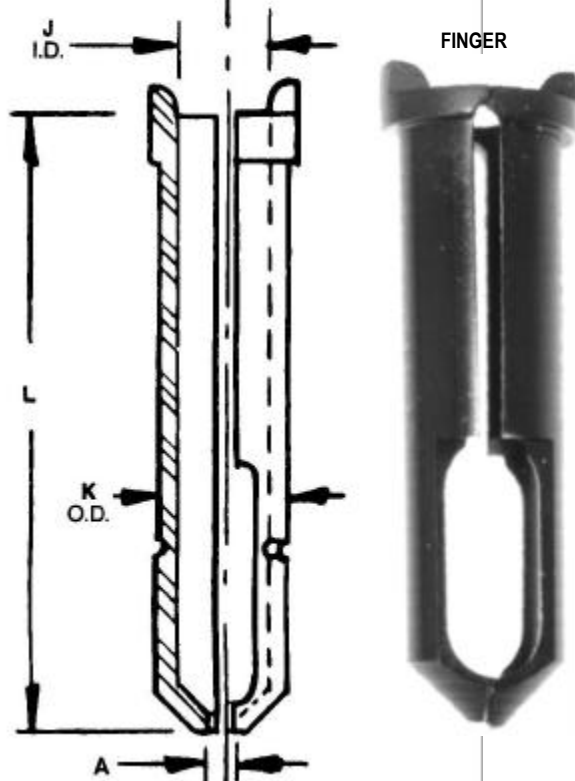
FINGER HOLDERS

FINGER HOLDER

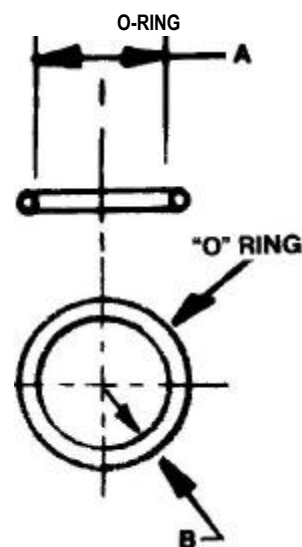
FINGER HOLDER PART NO.	NOM. RIVET SIZE	A
UCC-FH-390-01	1/8, 5/32, 3/16	.635
UCC-FH-390-02	1/4	.760

FINGERS

FINGER PART NO.	A RIVET SIZE	L	J	K
UCC-F-391-04	1/8	2.500	.479	.625
UCC-F-391-05	5/32	2.500	.479	.625
UCC-F-391-06	3/16	2.470	.479	.625
UCC-F-391-08	1/4	2.410	.609	.748
UCC-F-392-04	1/8	3.000	.479	.625
UCC-F-392-05	5/32	3.000	.479	.625
UCC-F-392-06	3/16	2.970	.479	.625
UCC-F-392-08	1/4	2.910	.609	.748



FINGER



O-RING

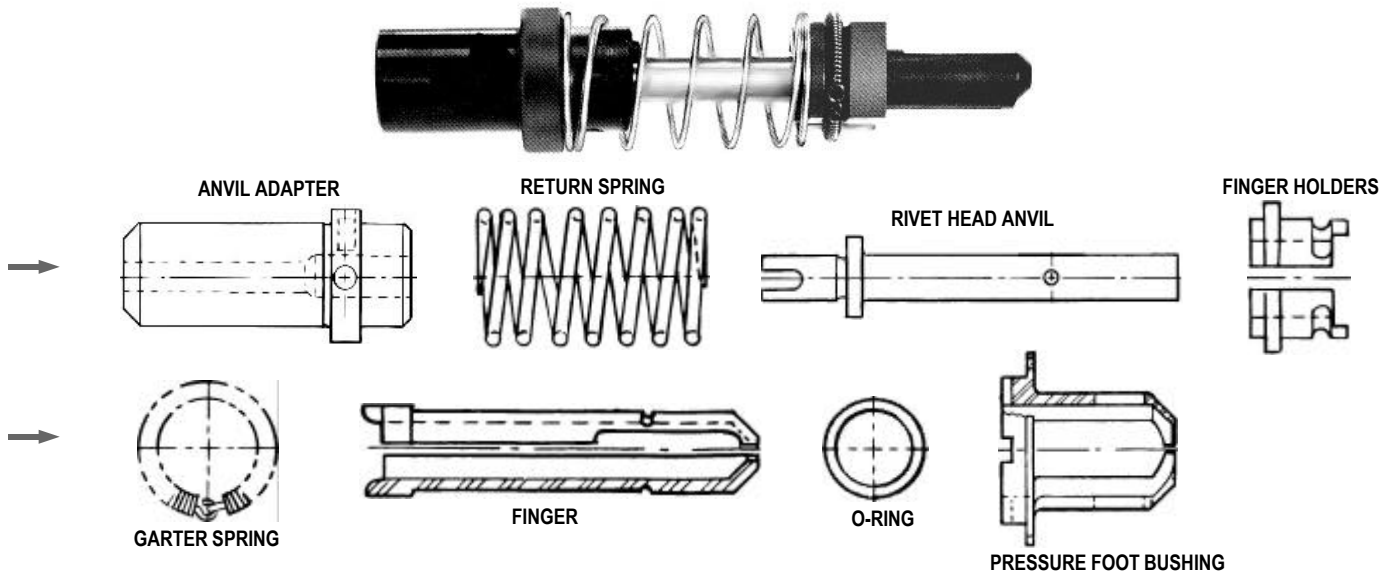
"O" RING

'O' RING PART NO.	A	B
UCC-OR-390-01	9/16	3/32
UCC-OR-390-02	11/16	3/32

Upper Anvil Assemblies

One-Piece Anvil UPPER ANVIL ASSEMBLIES

Standard Upper Anvil Assy for G39A Machines with One-Piece Anvils



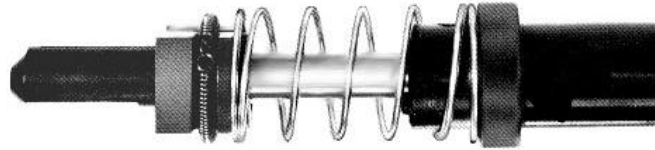
FOR SHORT TOOLING (4.250 DIMENSION)										
RIVET SIZE	RIVET HEAD TYPE	ASSEMBLY NO.	ANVIL ADAPTER	RETURN SPRING	ANVIL	FINGER HOLDER	GARTER SPRING	FINGER	'O' RING	PRESSURE FOOT BUSHING
1/8	FLUSH	UCC-AU-391-24AF	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-24AF	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-04	UCC-OR-390-01	UCC-PB-391-01
	UNIVERSAL	UCC-AU-391-24AU	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-24AU	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-04	UCC-OR-390-01	UCC-PB-391-01
5/32	FLUSH	UCC-AU-391-25AF	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-25AF	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-05	UCC-OR-390-01	UCC-PB-391-01
	UNIVERSAL	UCC-AU-391-25AU	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-25AU	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-05	UCC-OR-390-01	UCC-PB-391-01
3/16	FLUSH	UCC-AU-391-26AF	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-26AF	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-06	UCC-OR-390-01	UCC-PB-391-02
	UNIVERSAL	UCC-AU-391-26AU	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-26AU	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-06	UCC-OR-390-01	UCC-PB-391-02
1/4	FLUSH	UCC-AU-391-28AF	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-28AF	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-08	UCC-OR-390-01	UCC-PB-391-02
	UNIVERSAL	UCC-AU-391-28AU	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-28AU	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-08	UCC-OR-390-01	UCC-PB-391-02
FOR LONG TOOLING (4.750 DIMENSION)										
1/8	FLUSH	UCC-AU-392-24AF	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-24AF	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-04	UCC-OR-390-01	UCC-PB-392-01
	UNIVERSAL	UCC-AU-392-24AU	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-24AU	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-04	UCC-OR-390-01	UCC-PB-392-01
5/32	FLUSH	UCC-AU-392-25AF	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-25AF	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-05	UCC-OR-390-01	UCC-PB-392-01
	UNIVERSAL	UCC-AU-392-25AU	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-25AU	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-05	UCC-OR-390-01	UCC-PB-392-01
3/16	FLUSH	UCC-AU-392-26AF	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-26AF	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-06	UCC-OR-390-01	UCC-PB-392-02
	UNIVERSAL	UCC-AU-392-26AU	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-26AU	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-06	UCC-OR-390-01	UCC-PB-392-02
1/4	FLUSH	UCC-AU-392-28AF	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-28AF	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-08	UCC-OR-390-01	UCC-PB-392-02
	UNIVERSAL	UCC-AU-392-28AU	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-28AU	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-08	UCC-OR-390-01	UCC-PB-392-02

* GEMCOR NUMBERS

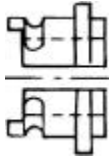
Standard Upper Anvil Assy for G39A Machines with Button Type Anvils

Upper Anvil
Assemblies

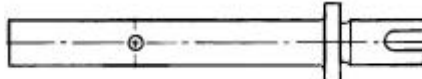
Button Type
UPPER ANVIL ASSEMBLIES



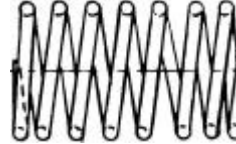
FINGER HOLDERS



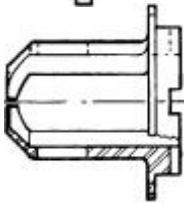
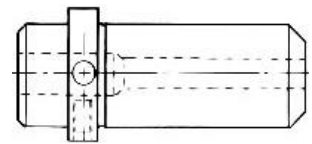
RIVET HEAD ANVIL



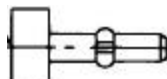
RETURN SPRING



ANVIL ADAPTER



PRESSURE FOOT BUSHING



ANVIL BUTTON



O-RING



FINGER



GARTER SPRING

FOR SHORT TOOLING (4.250 DIMENSION)

RIVET SIZE	RIVET HEAD TYPE	ASSEMBLY NO.	ANVIL ADAPTER	RETURN SPRING	ANVIL	FINGER HOLDER	GARTER SPRING	FINGER	'O' RING	ANVIL BUTTON	PRESSURE FOOT BUSHING
1/8	FLUSH	UCC-AU-391-14F	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-01	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-04	UCC-OR-390-01	UCC-B-390-5F	UCC-PB-391-01
	UNIVERSAL	UCC-AU-391-14U	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-01	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-04	UCC-OR-390-01	UCC-B-390-5U	UCC-PB-391-01
5/32	FLUSH	UCC-AU-391-15F	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-01	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-05	UCC-OR-390-01	UCC-B-390-5F	UCC-PB-391-01
	UNIVERSAL	UCC-AU-391-15U	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-01	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-05	UCC-OR-390-01	UCC-B-390-5U	UCC-PB-391-01
3/16	FLUSH	UCC-AU-391-16F	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-01	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-06	UCC-OR-390-01	UCC-B-390-6F	UCC-PB-391-02
	UNIVERSAL	UCC-AU-391-16U	UCC-AD-391-01	UCC-RS-391-01	UCC-A-391-01	UCC-FH-391-01	UCC-GS-390-01	UCC-F-391-06	UCC-OR-390-01	UCC-B-390-6U	UCC-PB-391-02

FOR LONG TOOLING (4.750 DIMENSION)

1/8	FLUSH	UCC-AU-392-14F	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-01	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-04	UCC-OR-390-01	UCC-B-390-5F	UCC-PB-392-01
	UNIVERSAL	UCC-AU-392-14U	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-01	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-04	UCC-OR-390-01	UCC-B-390-5U	UCC-PB-392-01
5/32	FLUSH	UCC-AU-392-15F	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-01	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-05	UCC-OR-390-01	UCC-B-390-5F	UCC-PB-392-01
	UNIVERSAL	UCC-AU-392-15U	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-01	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-05	UCC-OR-390-01	UCC-B-390-5U	UCC-PB-392-01
3/16	FLUSH	UCC-AU-392-16F	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-01	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-06	UCC-OR-390-01	UCC-B-390-6F	UCC-PB-392-02
	UNIVERSAL	UCC-AU-392-16U	UCC-AD-392-01 * (302-C-1006)	UCC-RS-392-01 * (206-P-80A)	UCC-A-392-01	UCC-FH-392-01	UCC-GS-390-01 * (302-A-2009)	UCC-F-392-06	UCC-OR-390-01	UCC-B-390-6U	UCC-PB-392-02

* GEMCOR NUMBERS

**Automatic Riveting
Anvil Stake Assembly**

ASSEMBLY PARTS VIEW

**UDB-390S-6 DRIVEMATIC
IN LINE LOWER ANVIL
ASSEMBLY**

FOR USE ON GENERAL
DRIVEMATIC MACHINE #G39A,
TWIN SPINDLE



ASSEMBLY

Lower Stake Assembly

GUIDE

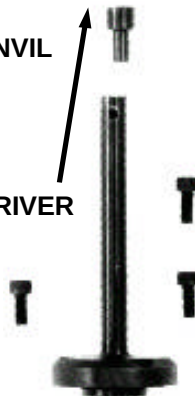


BUSHING



ANVIL

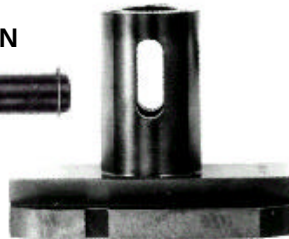
ANVIL DRIVER



LOCKING PIN



BASE



DRIVING PIN



UNITED
Automatic
Riveting
Assemblies
will
wear long
and
hold size
longer than
competitive
tools...

We guarantee it!

In Line Stake Type Lower Anvil Assembly

**Anvil Assembly
Specialists**

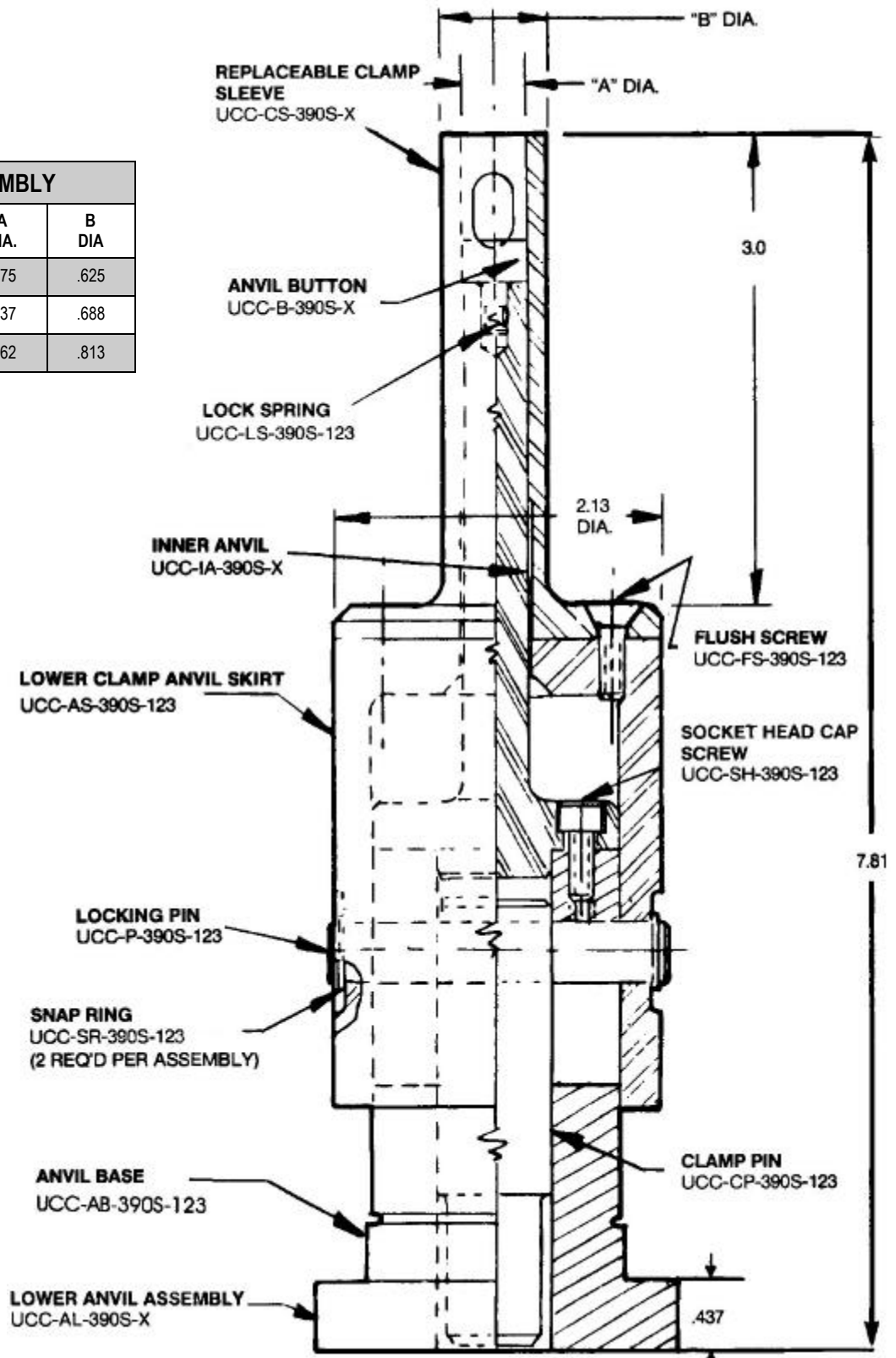
All Assemblies are serialized for traceability and exact parts replacement.

LOWER ANVIL ASSEMBLY Parts View

LOWER ANVIL ASSEMBLY			
PART NO.	RIVET DIA.	A DIA.	B DIA.
UCC-AL-390S-45	1/8, 5/32	.375	.625
UCC-AL-390S-6	3/16	.437	.688
UCC-AL-390S-8	1/4	.562	.813

Factory modified variations are possible to suit Customer part.

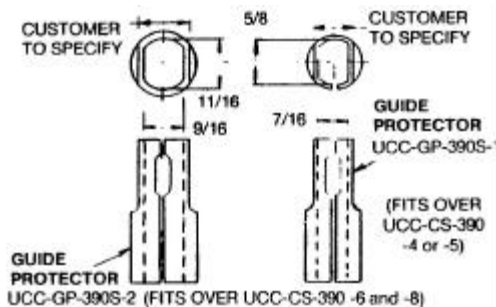
Submit part dimensional data for UCC Part No. and quotation.



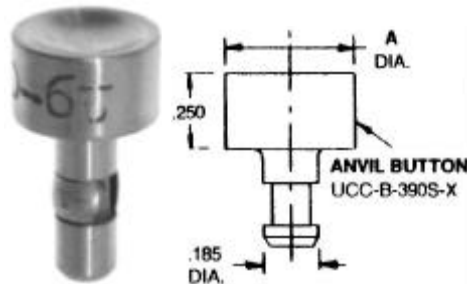
Drill/Riveter Tooling and Accessories

In Line Stake Type Lower Anvil Assembly Components

GUIDE PROTECTORS



ANVIL BUTTONS

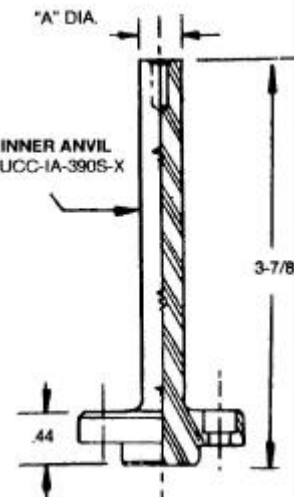


ANVIL BUTTON

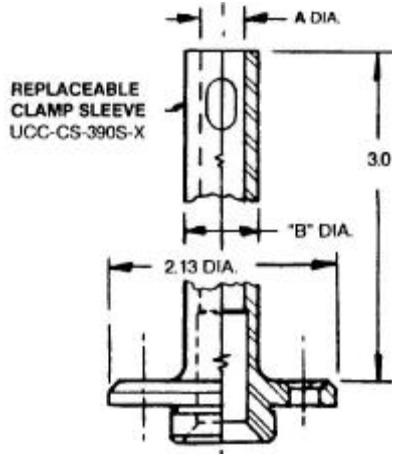
PART NO.	NOM. RIVET SIZE	A
UCC B- -4	1/8	.311
UCC-B-390S-5	5/32	.374
UCC-B-390S-6	3/16	.436
UCC-B-390S-8	1/4	.561

INNER ANVILS

INNER ANVIL		
PART NO.	NOM. RIVET SIZE	A DIA
UCC-IA-390S-4	1/8	.311
UCC-IA-390S-5	5/32	.374
UCC-IA-390S-6	3/16	.436
UCC-IA-390S-8	1/4	.561

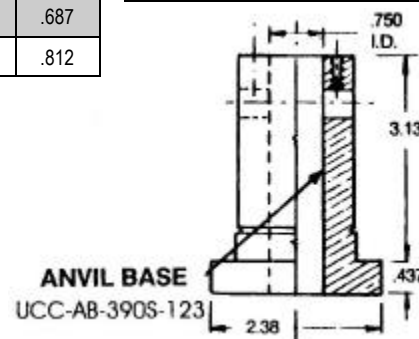


CLAMP SLEEVES

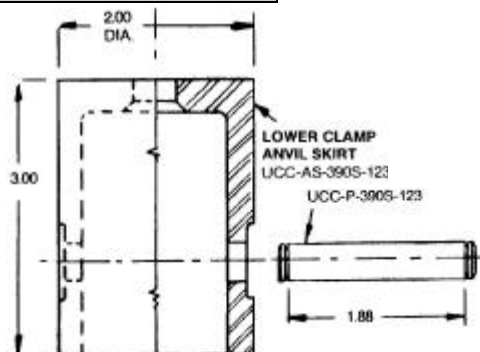


CLAMP SLEEVE			
PART NO.	NOM. RIVET SIZE	A DIA	B DIA
UCC-CS-390S-4	1/8	.312	.625
UCC-CS-390S-5	5/32	.375	.625
UCC-CS-390S-6	3/16	.437	.687
UCC-CS-390S-8	1/4	.562	.812

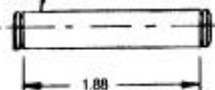
ANVIL BASES



LOWER ANVIL SKIRTS

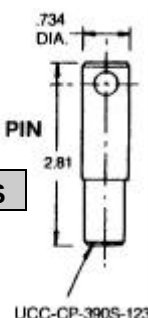


LOCKING PINS



CLAMP PIN

CLAMP PINS



Anvil Drill Riveter Pressure Tool Bushings

**Pressure Foot
Precision Bushings**

UNITED PRESSURE FOOT BUSHINGS



ADAPTER BUSHINGS

The
Quality
You Need
is
Manufactured
into the
Parts

You Need
at
UNITED!

Better
Faster
Lower Cost!



CUSTOM PRESSURE BUSHING



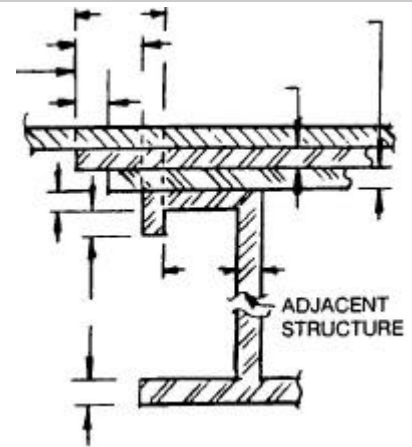
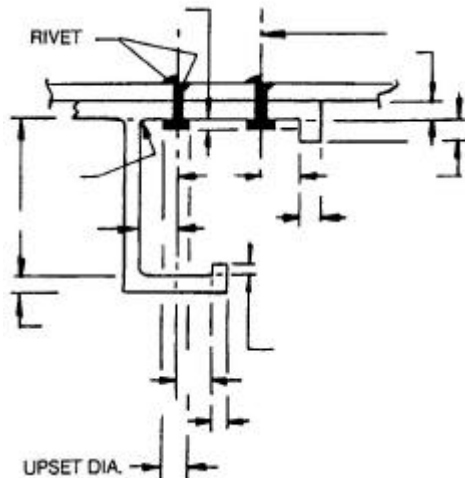
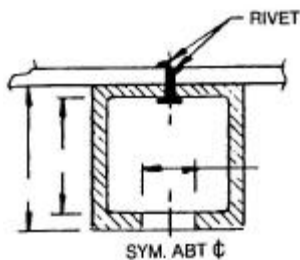
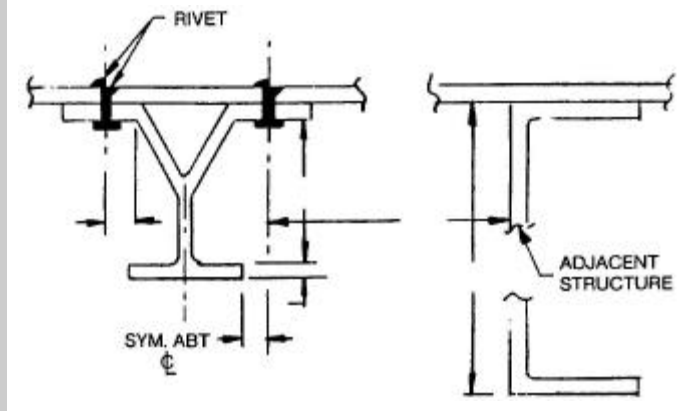
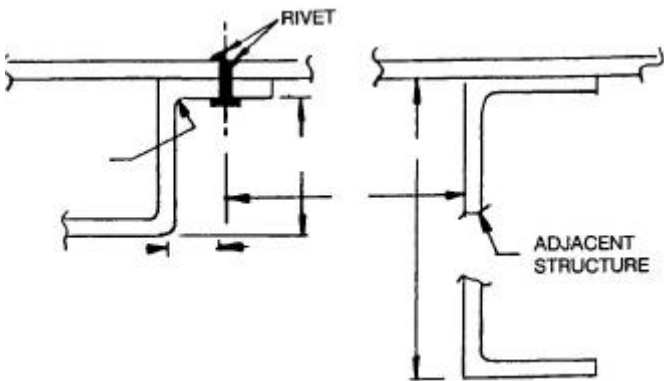
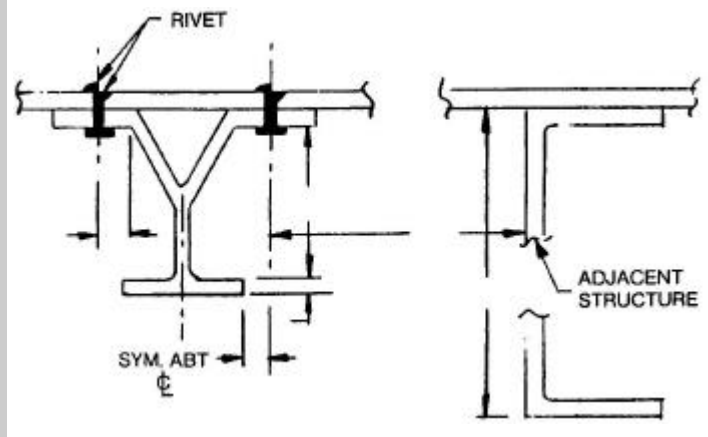
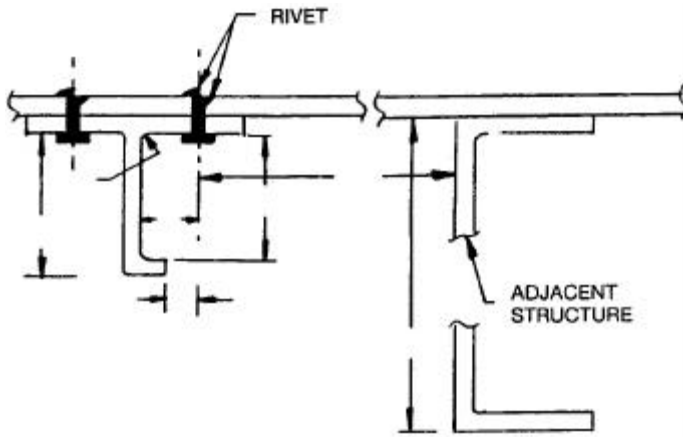
PRESSURE TOOL BUSHING

*Your Tooling
Specialists*

ASSEMBLY LAYOUTS VIEW

Typical Application Layouts for Lower Anvil Assemblies

DIMENSIONALIZE TO COMPLETE YOUR LAYOUT

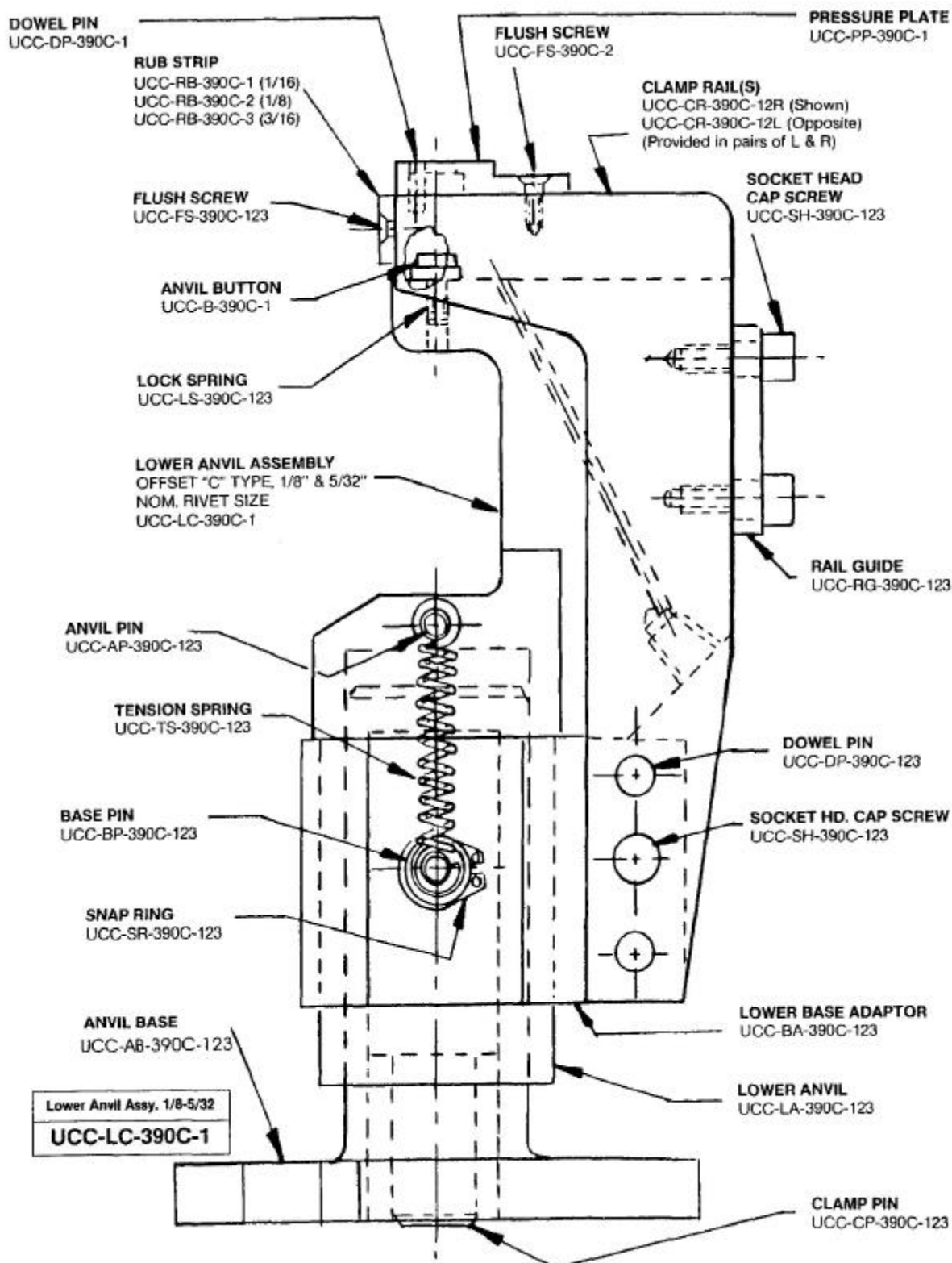


Lower Anvil Assembly Offset 'C' Type for 1/8 - 5/32 Rivets UCC-LC-390C-1

Anvil Assembly
Specialists

UCC-LC-390C-1

LOWER ANVIL ASSEMBLY
Parts View

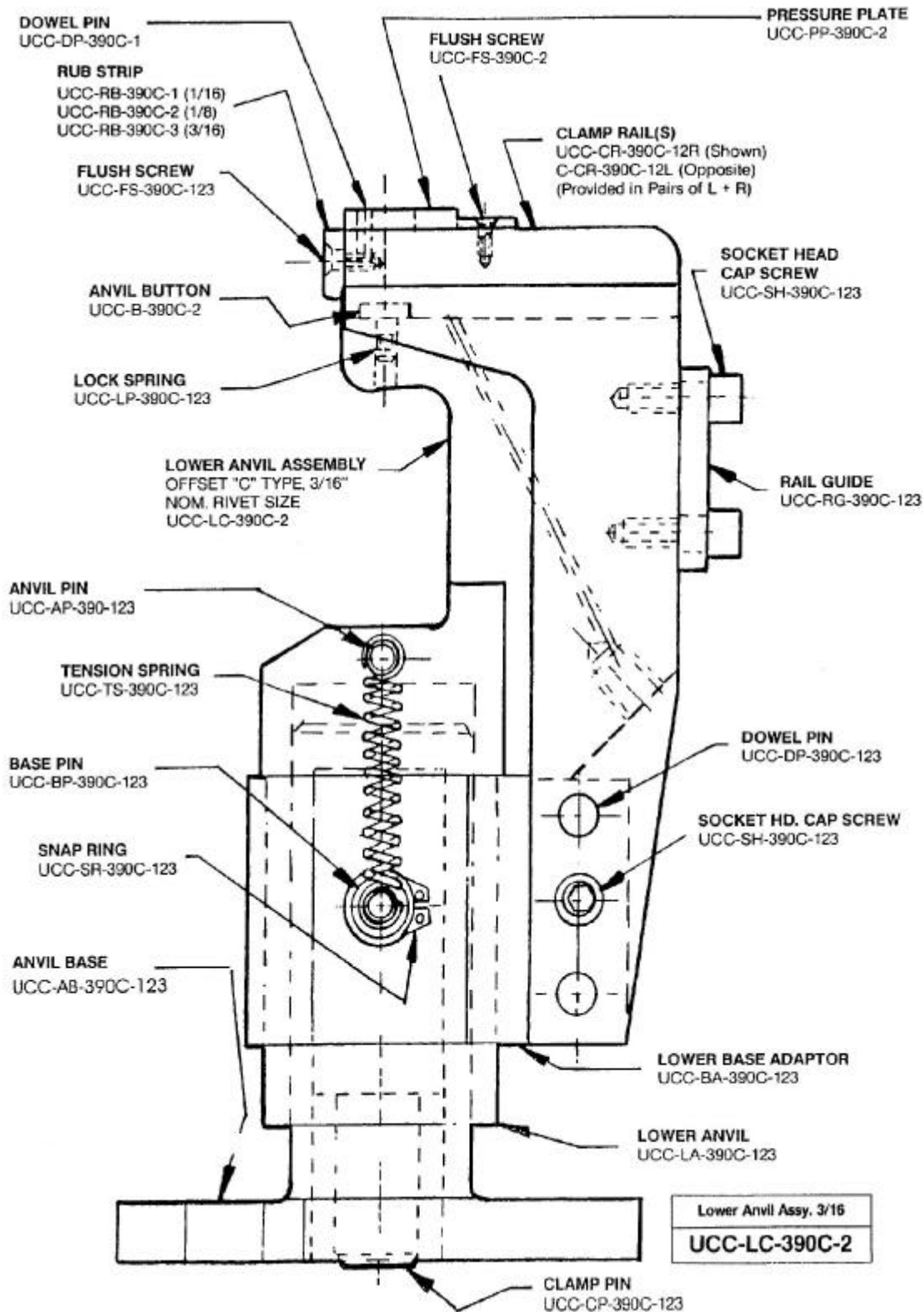


**Anvil Assembly
Specialists**

UCC-LC-390C-2

**LOWER ANVIL ASSEMBLY
Parts View**

Lower Anvil Assembly Offset 'C' Type for 3/16 Rivets UCC-LC-390C-2

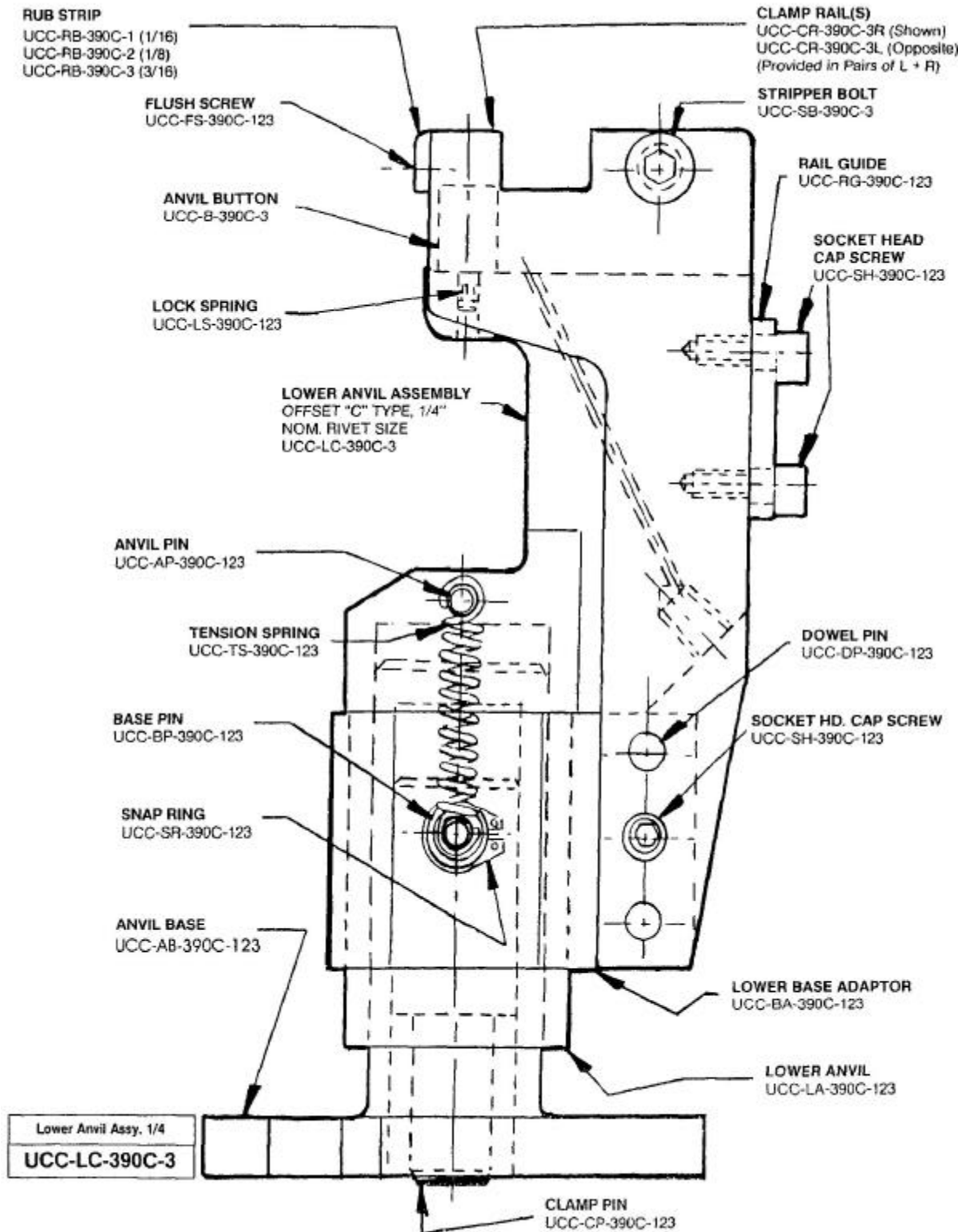


Lower Anvil Assembly Offset 'C' Type for 1/4 Nominal Rivets UCC-LC-390C-3

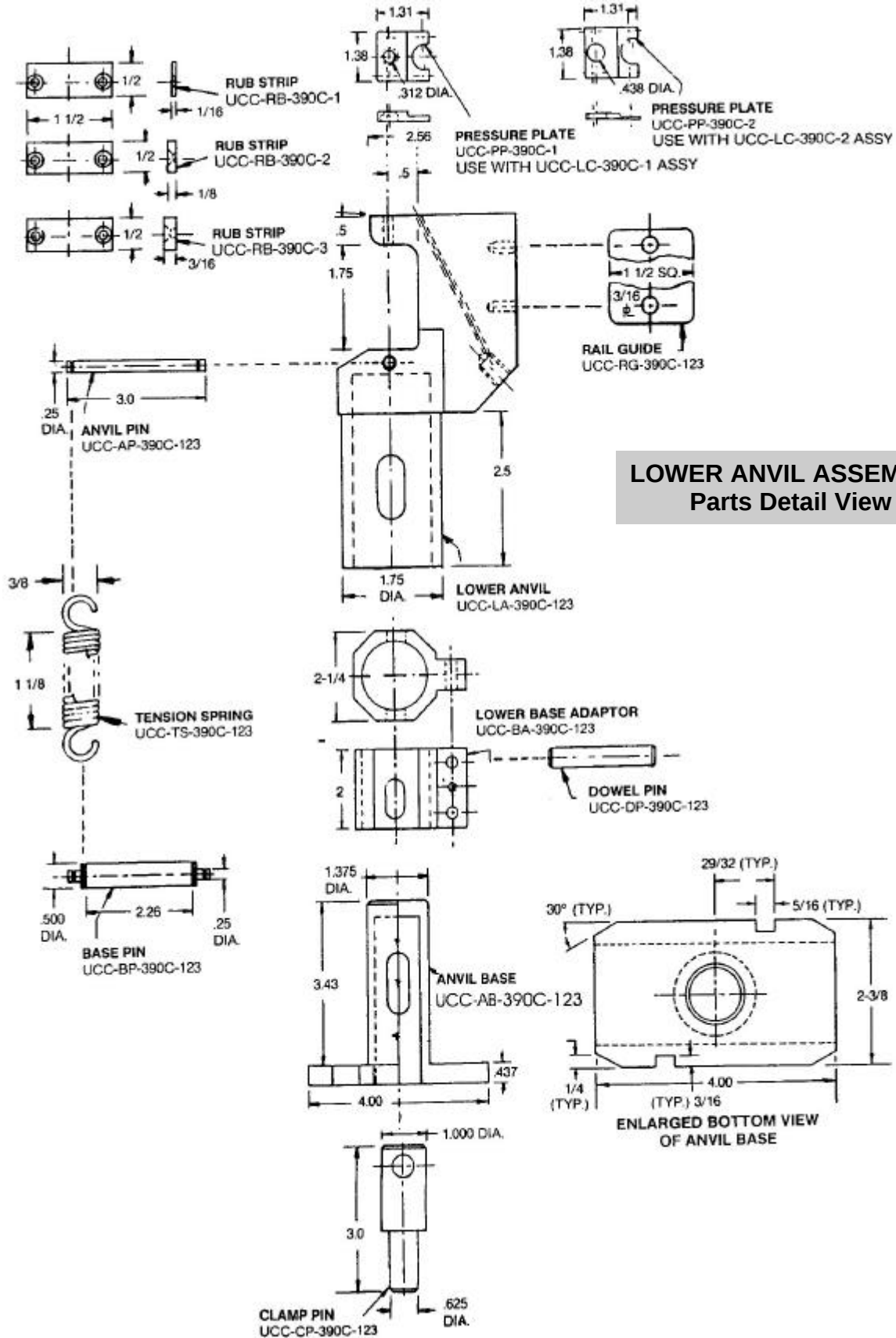
**Anvil Assembly
Specialists**

UCC-LC-390C-3

**LOWER ANVIL ASSEMBLY
Parts View**



Lower Anvil Assembly Accessory Parts Detail

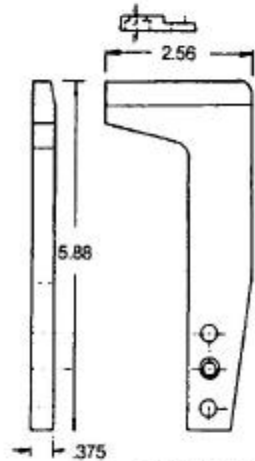
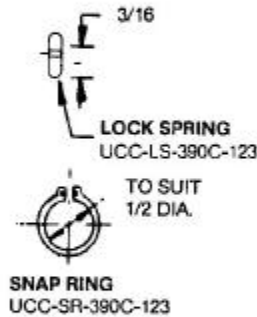
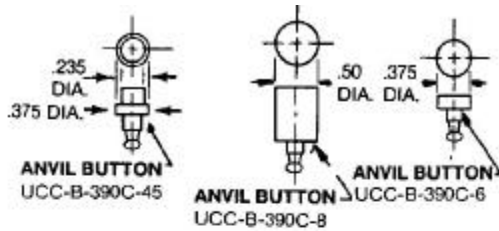


**LOWER ANVIL ASSEMBLY
Parts Detail View**

Lower Anvil Assembly Accessory Parts Detail

Anvil Assembly
Specialists

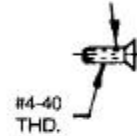
LOWER ANVIL ASSEMBLY Parts Detail View



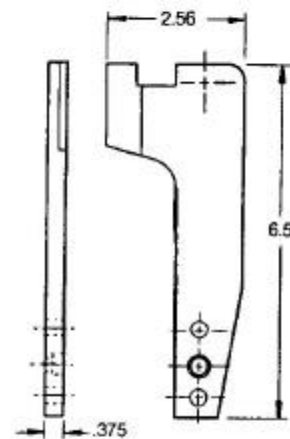
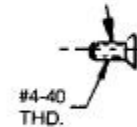
USE ON
UCC-LC-390C-1 & 2
ASSY. ONLY

CLAMP RAIL(S)
UCC-CR-390C-12 R (Shown)
UCC-CR-390C-12 L (Opposite)
(Provided in Pairs of L + R)

FLUSH SCREW
UCC-FS-390C-1

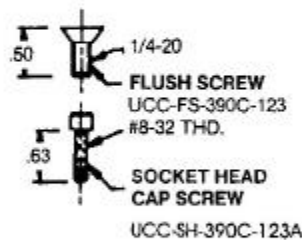


FLUSH SCREW
UCC-FS-390C-2

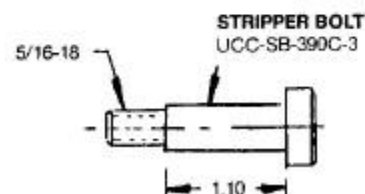
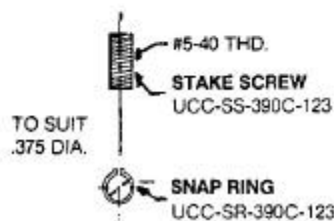
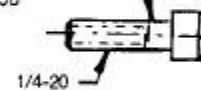


CLAMP RAIL(S)
UCC-CR-390C-3 R (Shown)
UCC-CR-390C-3 L (Opposite)
(Provided in Pairs of L + R)

USED ON
UCC-LC-390C-3
ASSY. ONLY



SOCKET HEAD CAP SCREW
UCC-SH-390C-123B



**View Other Items
In Our Catalog**

UNITED's Product Items Shown in L thru V Sections



Section R
Taper Lock Cutters for Free Hand Tools & Positive
Feed Equipment for Hole Retrofit Applications



Section O
Adapters, Air Flow
Control, Nose
Pieces & Reducers



Section Q
Taper Lock
Tooling
Helox-Shelox



Section N
Aircraft Burnishing,
Chip Chasing &
Seat Track Tools

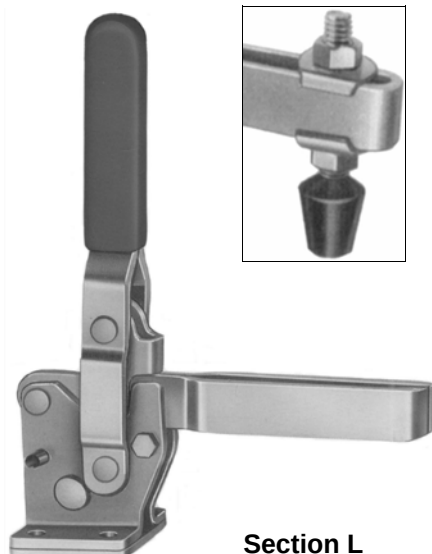


Section S
Complete Taper
Lock & Standard
Gauges



Section M
Automotive & Aircraft
Specific Tools

Section P
Nurlock Adapter & Extended Range Tips,
Helical Lock Liners, Kits & Accessories



Section L
Toggle Clamps, Fast
Clamps & Accessories



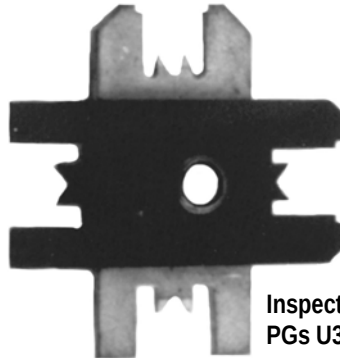
Section U
Automatic Drill Riveter
Tools & Accessories



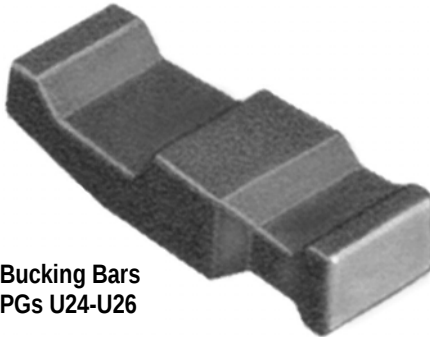
Section T
Custom Kits for Standard & Specialty Tools

Riveting, Bucking Bars, Inspection and Shear Test Tooling in This Section 'U'

Rivet Tooling



Inspection Gauges
PGs U36-U39



Bucking Bars
PGs U24-U26

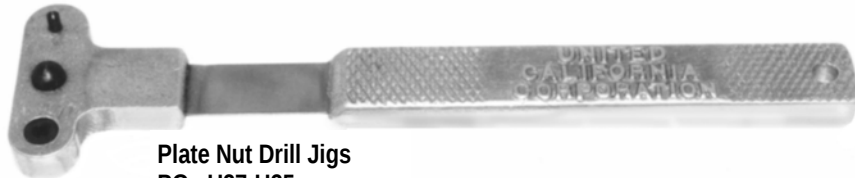
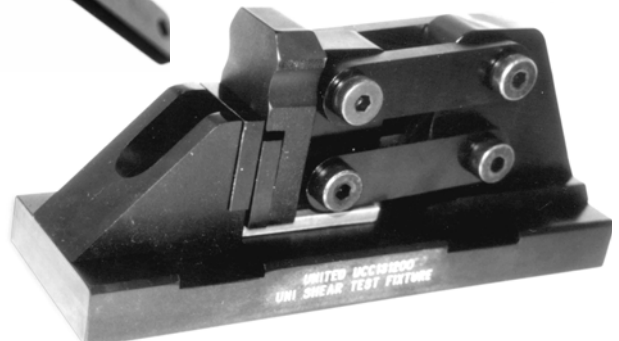


Plate Nut Drill Jigs
PGs U27-U35



New Products Coming



Bucking Bars

UNITED's New Bucking Bars

FEATURES:

UNITED carefully manufactures *Quality First Bucking Bars On Time.*

- Maximum strength Bars
- Superior design and wear under the most severe conditions

Cast Bars manufactured to top standards with high grade tool steel, heat treated to RC-38-42

- Bars can be reused repeatedly

Fabricated Custom Bars machined from superior bar stock

- Hardened to develop tough working surfaces
- Highly polished to MRS 32 finish, black oxide finish, identifiable by engraved numbers

Repairable, reusable, mag particles inspected to avoid cracks, fissures and assure long life

APPLICATIONS: For use under severe conditions where solid strength and performance are required.

UNITED BUCKING BAR STYLES

UCC-700601 6 LBS	UCC-700605 1-1/2 LBS	UCC-700610 3/4 LB	UCC-700614 2-3/4 LBS
UCC-700619 1-1/4 LBS	UCC-700633 1-1/4 LBS	UCC-700634 1 LB	UCC-700638 1-1/4 LBS
UCC-700639 2 LBS	UCC-700643 1-1/4 LBS	UCC-700646 2-1/4 LBS	UCC-700647 1-1/2 LBS
UCC-700649 2 LBS	UCC-700658 3 LBS	UCC-700662 1 LB	UCC-700667 4-1/4 LBS

Bucking Bar Styles and Dimensions

Bucking Bars

UNITED's TWO Bucking Bar Types:

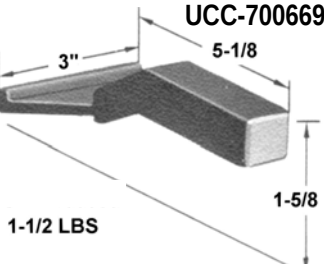
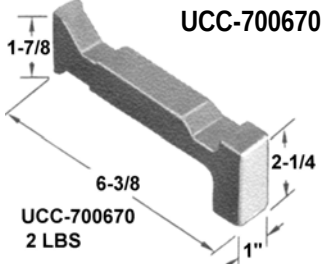
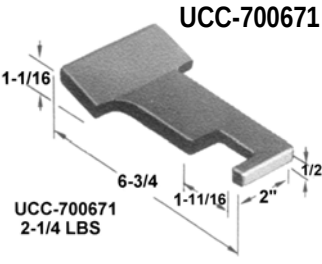
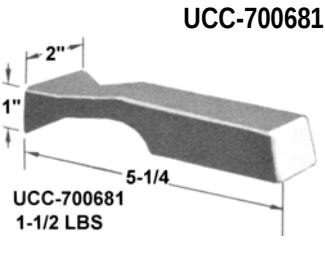
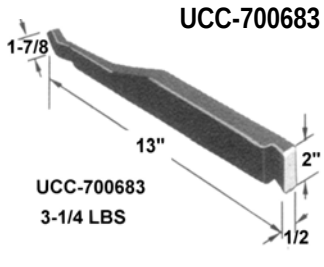
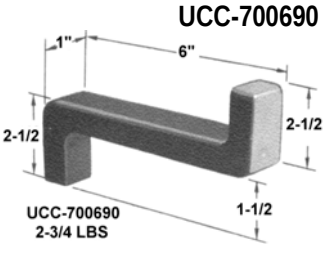
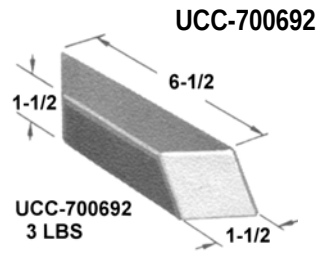
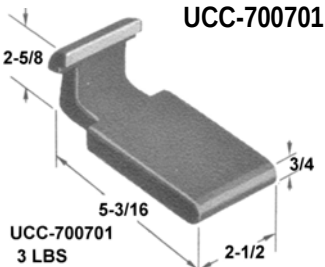
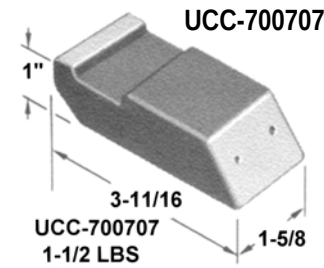
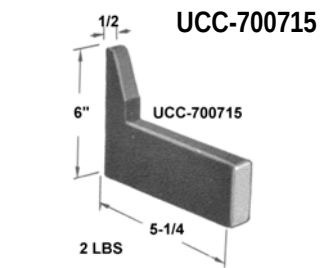
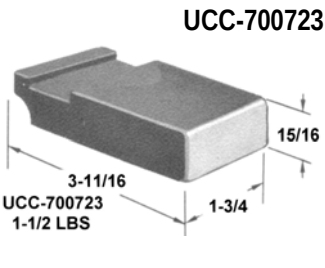
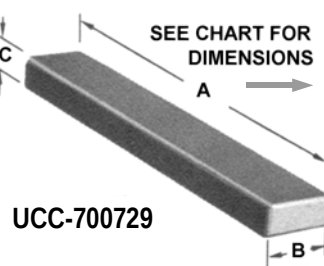
CAST — Clearly identified bars

- Nonporous
- High grade tool steel
- Heat treated to Rockwell 38-42
- Can be re-worked several times without more heat treating

FABRICATED — Part Numbers engraved, Dated, Black Oxide finish

- Machined from steel and can be refurbished
- Hardened for strong tough working surface - RC-40-44
- Satin-finished working area - Mag particle inspected
- Mirror-polished bucking surface on request to MRS 32-64

UNITED BUCKING BAR STYLES

 UCC-700669 3" 5-1/8" 1-5/8" 1-1/2 LBS	 UCC-700670 1-7/8" 6-3/8" 2-1/4" 1" 2 LBS	 UCC-700671 1-1/16" 6-3/4" 1-11/16" 2" 1/2" 2-1/4 LBS	 UCC-700681 2" 1" 5-1/4" 1-1/2 LBS																																																																									
 UCC-700683 1-7/8" 13" 2" 1/2" 3-1/4 LBS	 UCC-700690 1" 6" 2-1/2" 1-1/2" 2-1/2" 2-3/4 LBS	 UCC-700692 1-1/2" 6-1/2" 1-1/2" 3 LBS	 UCC-700701 2-5/8" 5-3/16" 3/4" 2-1/2" 3 LBS																																																																									
 UCC-700707 1" 3-11/16" 1-5/8" 1-1/2 LBS	 UCC-700715 1/2" 6" 5-1/4" 2 LBS	 UCC-700721 1" 2-7/16" 3-3/4" 1-3/4 LBS	 UCC-700723 3-11/16" 1-3/4" 15/16" 1-1/2 LBS																																																																									
 UCC-700729 SEE CHART FOR DIMENSIONS A B C	<table><thead><tr><th>PART NO.</th><th>A</th><th>B</th><th>C</th><th>WT-LBS</th></tr></thead><tbody><tr><td>UCC-700729-1</td><td>4"</td><td>1/2</td><td>1/2</td><td>1-1/4</td></tr><tr><td>UCC-700729-2</td><td>4"</td><td>3/4</td><td>3/4</td><td>1/2</td></tr><tr><td>UCC-700729-3</td><td>4"</td><td>1"</td><td>1"</td><td>1</td></tr><tr><td>UCC-700729-4</td><td>4"</td><td>1-1/2</td><td>1-1/2</td><td>2-1/2</td></tr><tr><td>UCC-700729-5</td><td>4"</td><td>2"</td><td>2"</td><td>4-1/2</td></tr><tr><td>UCC-700729-6</td><td>4"</td><td>1/2</td><td>1/4</td><td>1/8</td></tr></tbody></table>			PART NO.	A	B	C	WT-LBS	UCC-700729-1	4"	1/2	1/2	1-1/4	UCC-700729-2	4"	3/4	3/4	1/2	UCC-700729-3	4"	1"	1"	1	UCC-700729-4	4"	1-1/2	1-1/2	2-1/2	UCC-700729-5	4"	2"	2"	4-1/2	UCC-700729-6	4"	1/2	1/4	1/8	<table><thead><tr><th>PART NO.</th><th>A</th><th>B</th><th>C</th><th>WT-LBS</th></tr></thead><tbody><tr><td>UCC-700729-7</td><td>5"</td><td>5/8</td><td>5/16</td><td>1/4</td></tr><tr><td>UCC-700729-8</td><td>6"</td><td>1"</td><td>3/4</td><td>1-1/4</td></tr><tr><td>UCC-700729-9</td><td>6"</td><td>2"</td><td>1"</td><td>3-1/2</td></tr><tr><td>UCC-700729-10</td><td>6"</td><td>2"</td><td>1-1/2</td><td>4-1/4</td></tr><tr><td>UCC-700729-11</td><td>6"</td><td>2"</td><td>2-1/2</td><td>8-1/2</td></tr><tr><td>UCC-700729-12</td><td>12"</td><td>4"</td><td>3"</td><td>40</td></tr></tbody></table>			PART NO.	A	B	C	WT-LBS	UCC-700729-7	5"	5/8	5/16	1/4	UCC-700729-8	6"	1"	3/4	1-1/4	UCC-700729-9	6"	2"	1"	3-1/2	UCC-700729-10	6"	2"	1-1/2	4-1/4	UCC-700729-11	6"	2"	2-1/2	8-1/2	UCC-700729-12	12"	4"	3"	40
PART NO.	A	B	C	WT-LBS																																																																								
UCC-700729-1	4"	1/2	1/2	1-1/4																																																																								
UCC-700729-2	4"	3/4	3/4	1/2																																																																								
UCC-700729-3	4"	1"	1"	1																																																																								
UCC-700729-4	4"	1-1/2	1-1/2	2-1/2																																																																								
UCC-700729-5	4"	2"	2"	4-1/2																																																																								
UCC-700729-6	4"	1/2	1/4	1/8																																																																								
PART NO.	A	B	C	WT-LBS																																																																								
UCC-700729-7	5"	5/8	5/16	1/4																																																																								
UCC-700729-8	6"	1"	3/4	1-1/4																																																																								
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UCC-700729-10	6"	2"	1-1/2	4-1/4																																																																								
UCC-700729-11	6"	2"	2-1/2	8-1/2																																																																								
UCC-700729-12	12"	4"	3"	40																																																																								

Bucking Bar Attachments

UNITED's Bucking Bars & Attachments

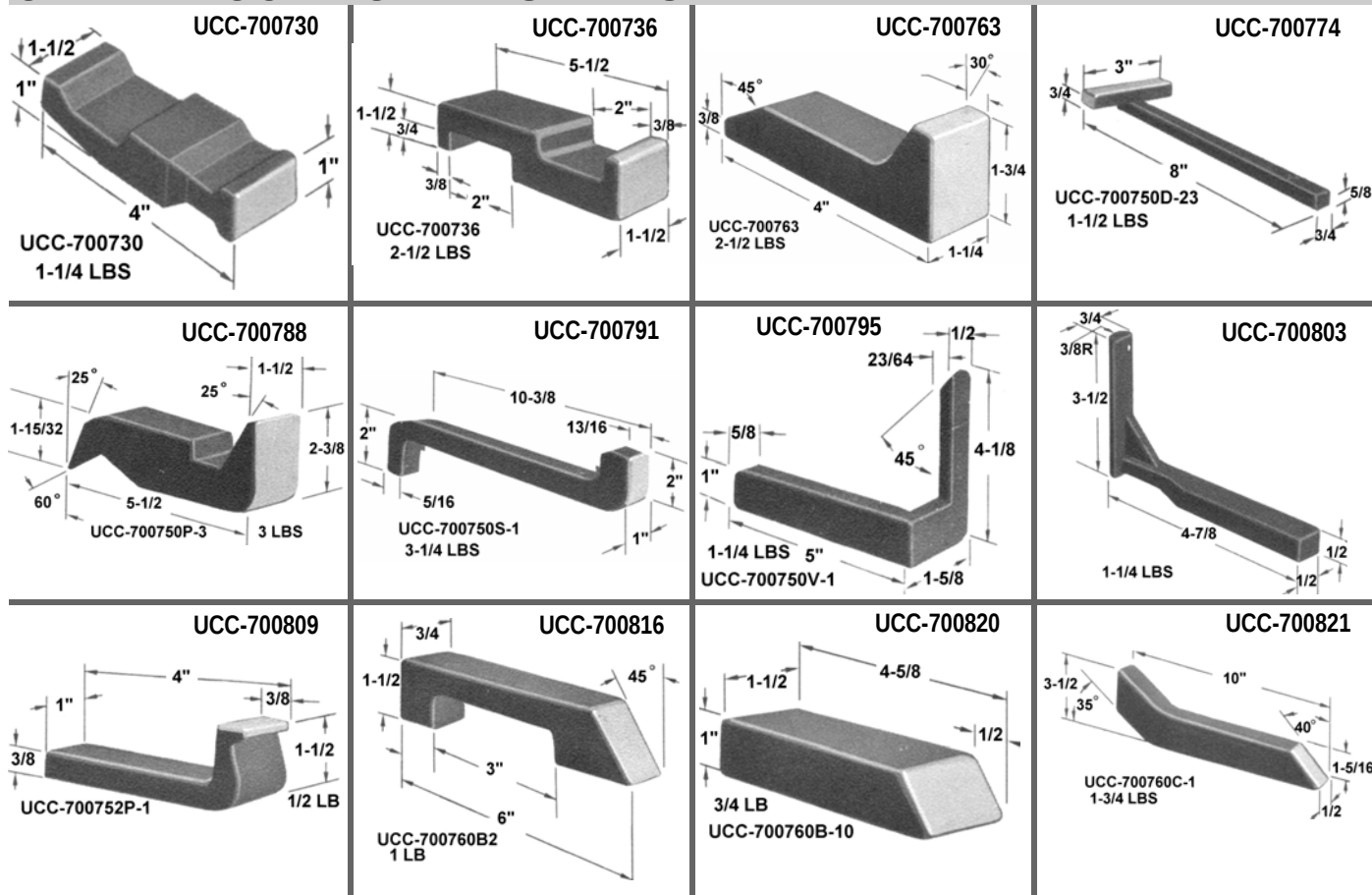
Our Bucking Bars Reduce Shock and Decrease Vibrations!

APPLICATIONS: For use in difficult areas or hard-to-get-to places and under severe conditions where steady strength and sure performance are required.

CAUTION: Eye Protection must be used when working with Bucking Bars.

Bucking Bars sold separately or in *UNITED* Kits - See Attachments below.

UNITED BUCKING BAR STYLES



BUCKING BAR ATTACHMENTS
Sold separately or as a set in UCC-7001001-BBK Kits. Special design has adjustable screw for increasing or decreasing spring tension according to rivet size. Comfortable cushioned handle reduces vibration.

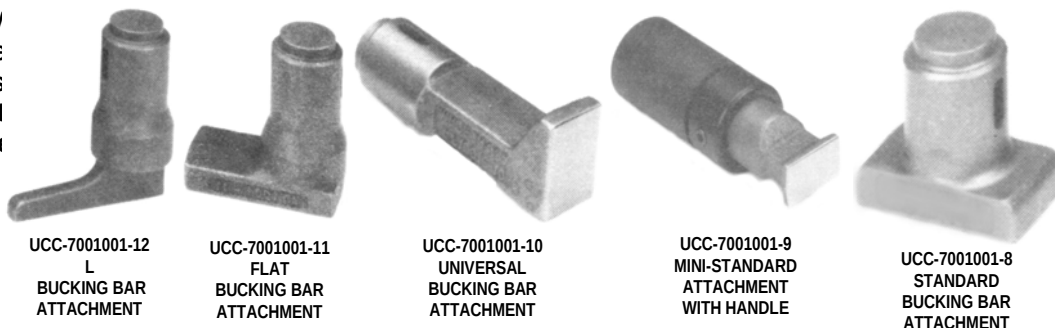


Plate Nut Drill Jig Types and Styles

Plate Nut Drill Jigs

UNITED's UCC 518xxx Series

FOR INSTRUCTIONS &
DETAILS, SEE PGS. U28-U35.

STYLE **A** TWO HOLES TWO LUGS
SELECT:

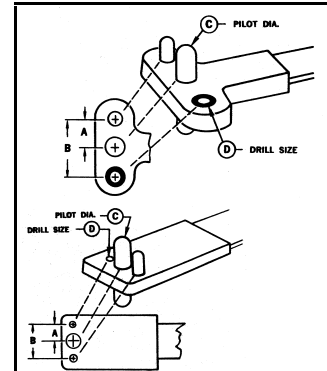


AS

STANDARD RIVET SPACING
DOUBLE-WING
TWO WING

AR

REDUCED RIVET SPACING
DOUBLE-WING, TWO WING
MINIATURE OR MICRO-MINIATURE



STYLE **B** ONE HOLE TWO LUGS
SELECT:

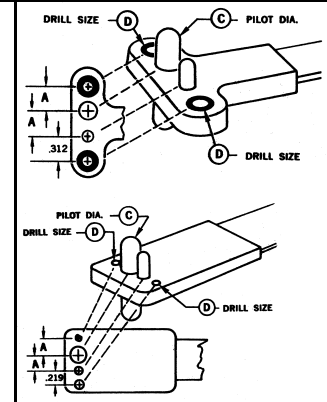


BS

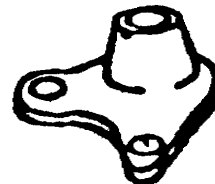
STANDARD RIVET SPACING
SINGLE-WING
ONE WING

BR

REDUCED RIVET SPACING
SINGLE-WING, ONE WING
MINIATURE OR MICRO-MINIATURE



STYLE **C** CORNER ONE HOLE TWO LUGS
SELECT:

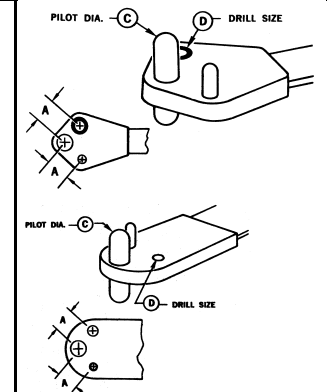


CS

STANDARD RIVET SPACING
'MICKEY MOUSE'

CR

REDUCED RIVET SPACING
'MICKEY MOUSE'
MINIATURE OR MICRO-MINIATURE



STYLE **D** SIDE-BY-SIDE ONE HOLE TWO LUGS
SELECT:

DS

STANDARD RIVET SPACING

DR

REDUCED RIVET SPACING
SHORT WING OR SHORT LUG
MINIATURE OR MICRO-MINIATURE

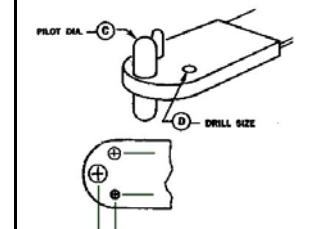
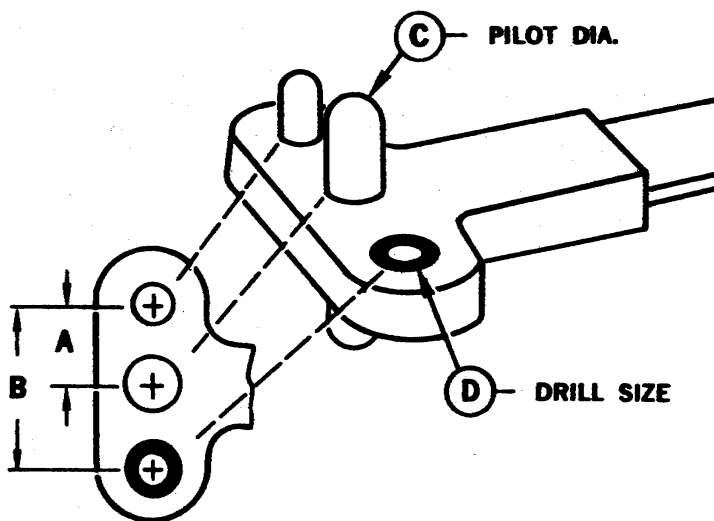


Plate Nut Drill Jigs

Two Lug Plate Nut Drill Jigs

UCC 518XXX SERIES TYPES	AS TWO LUGS TWO HOLES ANCHOR PLATE NUT
STANDARD RIVET SPACING	
DOUBLE- WING OR TWO-WING	



AS TWO LUGS TWO HOLES

STANDARD RIVET SPACING

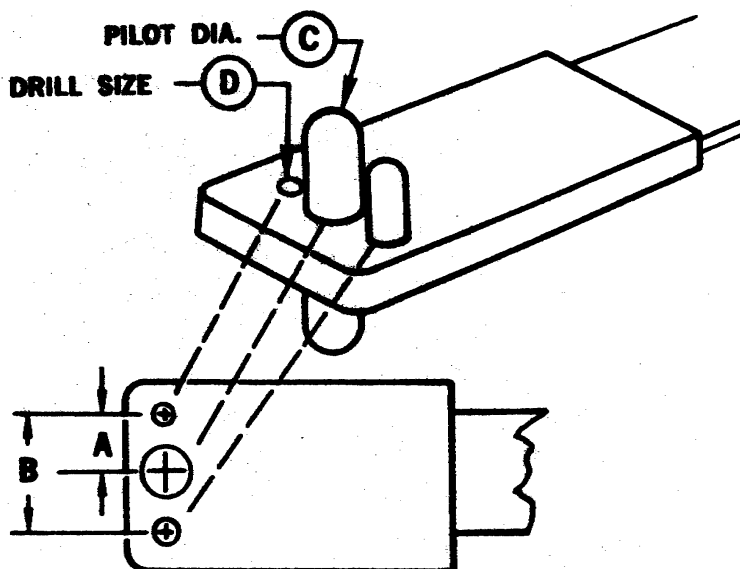
Select your **UNITED** Part Number by
Drill (rivet) size D and then by Pilot
Diameter size C. Lug Nut requires A and B.

HOLE PATTERN

UNITED PART NO.	Space A DIM	Space B DIM	Drill C	Jig D	PART NO.	A	B	C	D	PART NO.	A	B	C	D	PART NO.	A	B	C	D
UCC-518065	.312	.625	.187	.098	UCC-518050	.344	.68	.28	.09	UCC-518120	.500	1.00	.271	.098	UCC-518140	.500	1.00	.656	.098
UCC-518070	.312	.625	.218	.098	UCC-518055	.344	.68	.29	.09	UCC-518325	.500	1.00	.281	.098	UCC-518225	.500	1.00	.687	.128
UCC-518150	.344	.688	.118	.098	UCC-518060	.344	.688	.312	.098	UCC-518125	.500	1.00	.295	.098	UCC-518230	.500	1.00	.702	.128
UCC-518006	.344	.688	.128	.098	UCC-518335	.359	.718	.312	.128	UCC-518130	.500	1.00	.310	.098	UCC-518330	.562	1.12	.191	.098
UCC-518005	.344	.688	.139	.098	UCC-518075	.375	.750	.248	.098	UCC-518170	.500	1.00	.310	.128	UCC-518235	.562	1.12	.437	.128
UCC-518155	.344	.688	.142	.098	UCC-518080	.375	.750	.281	.098	UCC-518121	.500	1.00	.312	.098	UCC-518106	.562	1.12	.499	.161
UCC-518011	.344	.688	.159	.098	UCC-518085	.375	.750	.372	.098	UCC-518175	.500	1.00	.312	.128	UCC-518240	.592	1.18	.811	.128
UCC-518010	.344	.688	.164	.098	UCC-518320	.375	.750	.397	.098	UCC-518180	.500	1.00	.314	.128	UCC-518245	.595	1.19	.592	.128
UCC-518015	.344	.688	.164	.098	UCC-518315	.375	.750	.437	.098	UCC-518305	.500	1.00	.343	.128	UCC-518250	.625	1.25	.435	.128
UCC-518016	.344	.688	.166	.098	UCC-518090	.375	.750	.437	.098	UCC-518135	.500	1.00	.342	.098	UCC-518021	.625	1.25	.499	.151
UCC-518020	.344	.688	.167	.098	UCC-518095	.375	.750	.467	.098	UCC-518185	.500	1.00	.372	.128	UCC-518255	.687	1.37	.191	.128
UCC-518025	.344	.688	.187	.098	UCC-518340	.414	.828	.372	.128	UCC-518190	.500	1.00	.373	.128	UCC-518260	.687	1.37	.405	.128
UCC-518030	.344	.688	.191	.098	UCC-518004	.437	.875	.311	.098	UCC-518195	.500	1.00	.375	.128	UCC-518265	.687	1.37	.498	.128
UCC-518035	.344	.688	.192	.098	UCC-518100	.437	.875	.372	.098	UCC-518200	.500	1.00	.389	.128	UCC-518270	.687	1.37	.500	.128
UCC-518501	.344	.688	.218	.098	UCC-518105	.450	.900	.372	.098	UCC-518101	.500	1.00	.437	.128	UCC-518275	.687	1.37	.656	.128
UCC-518040	.344	.688	.226	.098	UCC-518160	.500	1.00	.191	.128	UCC-518310	.500	1.00	.467	.128	UCC-518280	.687	1.37	.718	.128
UCC-518061	.344	.688	.250	.098	UCC-518110	.500	1.00	.248	.098	UCC-518205	.500	1.00	.500	.128	UCC-518285	.687	1.37	.749	.128
UCC-518045	.344	.688	.255	.098	UCC-518165	.500	1.00	.248	.128	UCC-518210	.500	1.00	.561	.128	UCC-518290	.687	1.37	.811	.128
					UCC-518115	.500	1.00	.255	.098	UCC-518215	.500	1.00	.593	.128	UCC-518295	.687	1.37	.938	.128
					UCC-518502	.500	1.00	.266	.098	UCC-518220	.500	1.00	.624	.128	UCC-518300	.700	1.40	.850	.128

Two Lug Plate Nut Drill Jigs

Plate Nut Drill Jigs



AR TWO LUGS TWO HOLES ANCHOR PLATE NUT



UCC 518XXX SERIES TYPES

REDUCED
RIVET
SPACING
DOUBLE-
WING OR
TWO WING
MINIATURE
OR MICRO-
MINIATURE

AR TWO LUGS TWO HOLES

REDUCED RIVET SPACING

Select your **UNITED** Part Number by
Drill (rivet) size D and then by Pilot

Diameter size C. Lug Nut requires A and B.

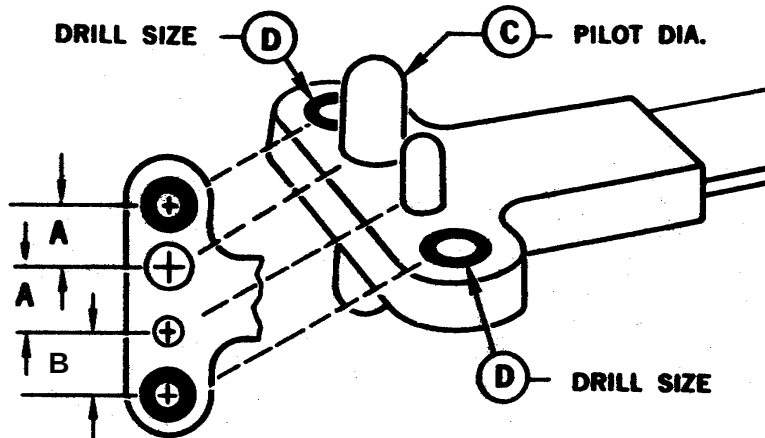
HOLE PATTERN

UNITED PART NO.	Space A DIM	Space B DIM	Drill C Pilot DIA	Jig D Rivet Hole	PART NO.	A	B	C	D	PART NO.	A	B	C	D
UCC-518345	.125	.250	.0860	.067	UCC-518385	.2185	.437	.1660	.098	UCC-518430	.250	.500	.2570	.098
UCC-518350	.1325	.265	.0990	.067	UCC-518041	.2185	.437	.1910	.098	UCC-518460	.2695	.539	.2480	.098
UCC-518355	.148	.296	.1120	.067	UCC-518390	.2185	.437	.2055	.098	UCC-518435	.281	.562	.2480	.098
UCC-518360	.1715	.343	.1390	.067	UCC-518481	.234	.468	.1560	.098	UCC-518440	.281	.562	.2810	.098
UCC-518365	.203	.406	.1120	.098	UCC-518395	.234	.468	.1640	.098	UCC-518056	.281	.562	.3120	.098
UCC-518478	.203	.406	.1140	.098	UCC-518400	.234	.468	.1925	.098	UCC-518445	.295	.562	.3230	.098
UCC-518071	.203	.406	.1280	.098	UCC-518405	.234	.468	.1930	.098	UCC-518476	.295	.590	.1760	.098
UCC-518370	.203	.406	.1400	.098	UCC-518046	.234	.468	.2180	.098	UCC-518475	.295	.590	.1910	.098
UCC-518036	.203	.406	.1660	.098	UCC-518410	.234	.468	.2270	.098	UCC-518477	.295	.590	.1940	.098
UCC-518375	.203	.406	.1800	.098	UCC-518415	.234	.468	.2340	.098	UCC-518450	.3125	.625	.3120	.1285
UCC-518380	.2185	.437	.1390	.098	UCC-518470	.250	.500	.1875	.098	UCC-518455	.3125	.625	.3430	.1285
UCC-518479	.2185	.437	.1400	.098	UCC-518420	.250	.500	.1910	.098	UCC-518081	.359	.718	.3120	.1285
UCC-518076	.2185	.437	.1590	.098	UCC-518482	.250	.500	.2170	.098	UCC-518465	.359	.718	.3730	.1285
					UCC-518425	.250	.500	.2180	.098	UCC-518086	.414	.828	.3730	.1285
					UCC-518051	.250	.500	.2500	.098	UCC-518066	.414	.828	.4360	.1285

Plate Nut Drill Jigs

Two Lug Plate Nut Drill Jigs

UCC 518XXX SERIES TYPES	BS TWO LUGS ONE HOLE ANCHOR PLATE NUT
STANDARD RIVET SPACING SINGLE- WING OR ONE-WING	



BS TWO LUGS ONE HOLE

STANDARD RIVET SPACING

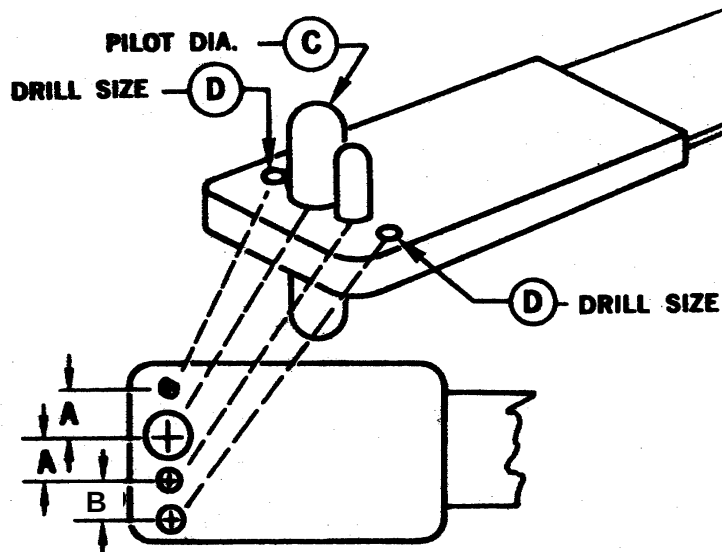
Select your **UNITED** Part Number by
Drill (rivet) size D and then by Pilot
Diameter size C. Lug Nut requires A and B.

HOLE PATTERN

UNITED PART NO.	Space A DIM	Space B DIM	Drill C Pilot DIA	Jig D Rivet Hole	PART NO.	A	B	C	D	PART NO.	A	B	C	D
UCC-518141	.344	.312	.1280	.098	UCC-518505	.344	.312	.1910	.1285	UCC-518545	.500	.312	.2480	.098
UCC-518480	.344	.312	.1390	.098	UCC-518510	.344	.312	.1920	.098	UCC-518550	.500	.312	.2555	.098
UCC-518590	.344	.312	.1425	.098	UCC-518515	.344	.312	.2130	.098	UCC-518503	.500	.312	.2660	.098
UCC-518091	.344	.312	.1590	.098	UCC-518126	.344	.312	.2180	.098	UCC-518555	.500	.312	.3105	.098
UCC-518485	.344	.312	.1640	.098	UCC-518520	.344	.312	.2265	.098	UCC-518565	.500	.312	.3105	.1285
UCC-518490	.344	.312	.1645	.098	UCC-518525	.344	.312	.2480	.098	UCC-518570	.500	.312	.3145	.1285
UCC-518495	.344	.312	.1675	.098	UCC-518530	.344	.312	.2555	.098	UCC-518560	.500	.312	.3430	.098
UCC-518500	.344	.312	.1875	.098	UCC-518535	.344	.312	.2810	.098	UCC-518575	.500	.312	.3720	.1285
					UCC-518540	.344	.312	.3105	.1285	UCC-518580	.500	.312	.3730	.1285
					UCC-518545	.500	.312	.2480	.098	UCC-518585	.562	.344	.4350	.1285

Two Lug Plate Nut Drill Jigs

Plate Nut Drill Jigs



BR
TWO LUGS ONE HOLE
ANCHOR PLATE NUT



**UCC
518XXX
SERIES
TYPES**

REDUCED
RIVET
SPACING
SINGLE-WING
OR
ONE WING.
MINIATURE
OR MICRO-
MINIATURE

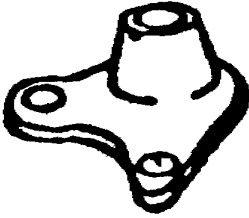
BR TWO LUGS ONE HOLE REDUCED RIVET SPACING

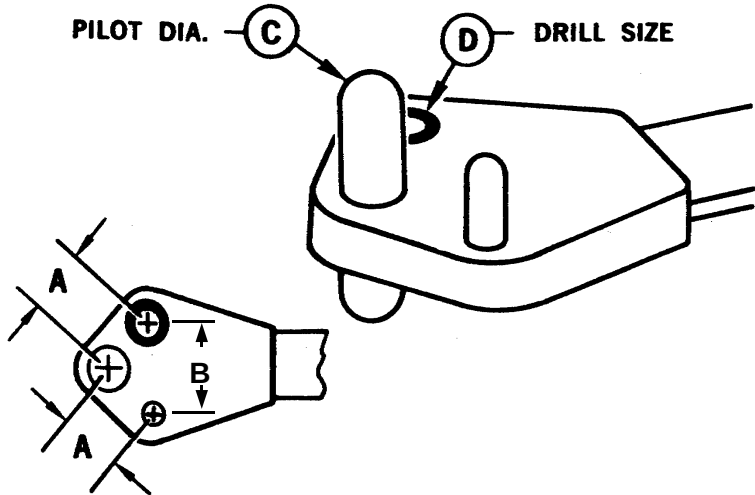
Select your **UNITED** Part Number by
Drill (rivet) size D and then by Pilot
Diameter size C. Lug Nut requires A and B.

HOLE PATTERN

UNITED PART NO.	Space A DIM	Space B DIM	Drill C Pilot DIA	Jig D Rivet Hole	PART NO.	A	B	C	D	PART NO.	A	B	C	D
UCC-518605	.125	.219	.0860	.067	UCC-518181	.203	.219	.1280	.098	UCC-518675	.250	.219	.1875	.098
UCC-518610	.133	.219	.0990	.067	UCC-518630	.203	.219	.1400	.098	UCC-518655	.250	.219	.1910	.098
UCC-518615	.148	.219	.1120	.067	UCC-518635	.218	.219	.1390	.098	UCC-518660	.250	.219	.2180	.1285
UCC-518620	.171	.219	.1390	.067	UCC-518186	.218	.219	.1640	.098	UCC-518665	.281	.219	.2480	.1285
UCC-518625	.203	.219	.1120	.067	UCC-518640	.218	.219	.1660	.1285	UCC-518670	.281	.219	.2810	.098
					UCC-518645	.234	.219	.1640	.098	UCC-518191	.359	.269	.3120	.1285
					UCC-518650	.234	.219	.1930	.098	UCC-518196	.414	.269	.3730	.1285

Corner 2-Lug Plate Nut Drill Jigs

UCC 518XXX SERIES TYPES	CS TWO LUGS ONE HOLE ANCHOR PLATE NUT
STANDARD RIVET SPACING 'MICKEY MOUSE'	



CS TWO LUGS ONE HOLE

STANDARD RIVET SPACING

Select your **UNITED** Part Number by
Drill (rivet) size D and then by Pilot
Diameter size C. Lug Nut requires A and B.

HOLE PATTERN

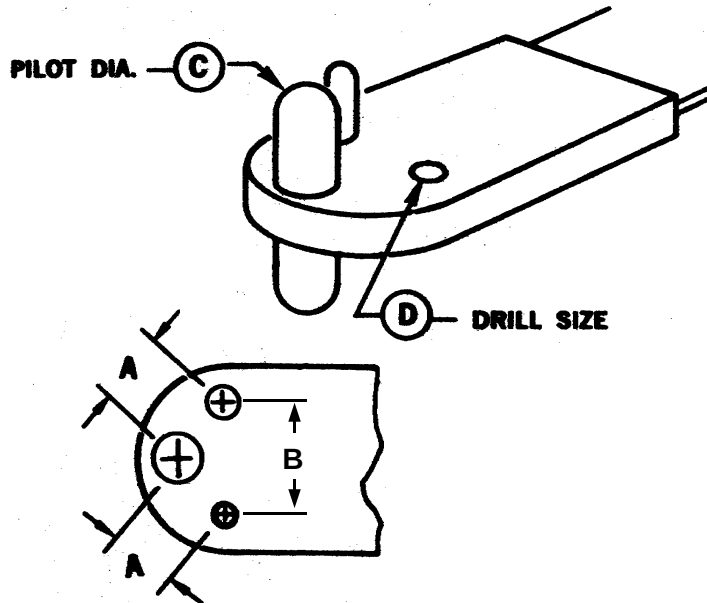
UNITED PART NO.	Space A DIM	Space B DIM	Drill C Pilot DIA	Jig D Rivet Hole
UCC-518680	.344	.486	.1390	.098
UCC-518775	.344	.486	.1425	.098
UCC-518241	.344	.486	.1590	.098
UCC-518685	.344	.486	.1640	.098
UCC-518690	.344	.486	.1645	.098
UCC-518695	.344	.486	.1675	.098

PART NO.	A	B	C	D
UCC-518700	.344	.486	.1875	.098
UCC-518705	.344	.486	.1910	.098
UCC-518710	.344	.486	.1980	.098
UCC-518201	.344	.486	.2180	.098
UCC-518715	.344	.486	.2865	.098
UCC-518780	.358	.506	.2120	.1285
UCC-518786	.414	.585	.3780	.1285
UCC-518725	.500	.707	.2480	.098
UCC-518720	.500	.707	.2555	.098
UCC-518735	.500	.707	.3105	.098

PART NO.	A	B	C	D
UCC-518740	.500	.707	.3110	.1285
UCC-518745	.500	.707	.3120	.1285
UCC-518750	.500	.707	.3145	.1285
UCC-518755	.500	.707	.3720	.1285
UCC-518760	.500	.707	.3730	.1285
UCC-518216	.500	.707	.4360	.1285
UCC-518765	.562	.795	.4350	.1285
UCC-518251	.562	.795	.4360	.1610
UCC-518770	.562	.795	.4375	.1285
UCC-518221	.562	.795	.4990	.1610

Corner 2-Lug Plate Nut Drill Jigs

Plate Nut Drill Jigs



CR TWO LUGS ONE HOLE ANCHOR PLATE NUT	UCC 518XXX SERIES TYPES
	REDUCED RIVET SPACING 'MICKEY MOUSE' MINIATURE OR MICRO- MINIATURE

CR TWO LUGS ONE HOLE

REDUCED RIVET SPACING

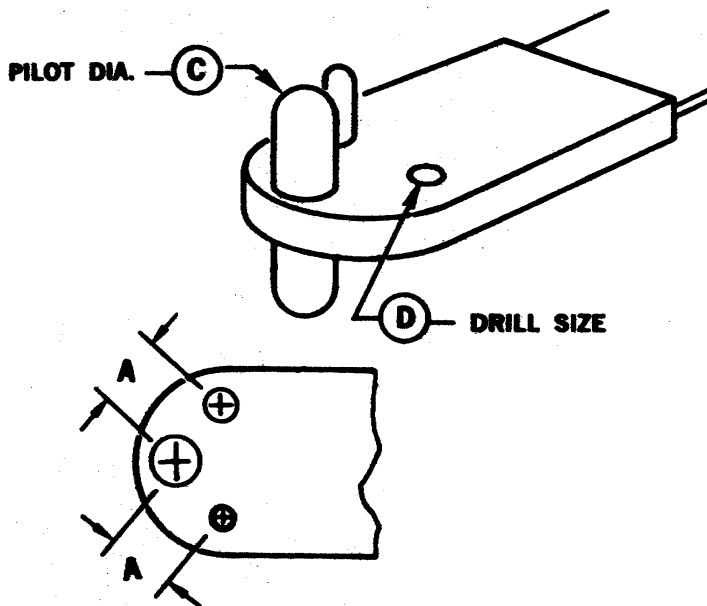
Select your **UNITED** Part Number by
Drill (rivet) size D and then by Pilot
Diameter size C. Lug Nut requires A and B.

HOLE PATTERN

UNITED PART NO.	Space A DIM	Space B DIM	Drill C Pilot DIA	Jig D Rivet Hole	PART NO.	A	B	C	D	PART NO.	A	B	C	D
UCC-518785	.125	.177	.0860	.067	UCC-518815	.218	.308	.1390	.098	UCC-518281	.250	.354	.2480	.098
UCC-518790	.138	.196	.0990	.067	UCC-518306	.218	.308	.1560	.098	UCC-518845	.281	.398	.2480	.098
UCC-518795	.148	.210	.1120	.067	UCC-518820	.218	.308	.1660	.098	UCC-518850	.281	.398	.2180	.098
UCC-518800	.178	.243	.1390	.067	UCC-518271	.218	.308	.1910	.098	UCC-518286	.281	.398	.3120	.098
UCC-518805	.203	.287	.1120	.098	UCC-518825	.234	.331	.1640	.098	UCC-518855	.312	.441	.3120	.1285
UCC-518301	.203	.287	.1275	.098	UCC-518830	.234	.331	.1930	.098	UCC-518860	.312	.441	.3430	.1285
UCC-518810	.203	.287	.1400	.098	UCC-518276	.234	.331	.2150	.098	UCC-518311	.359	.508	.3120	.1285
UCC-518266	.203	.287	.1660	.098	UCC-518865	.250	.354	.1875	.098	UCC-518291	.359	.508	.3730	.1285
					UCC-518835	.250	.354	.1910	.098	UCC-518316	.414	.585	.3730	.1285
					UCC-518840	.250	.354	.2180	.098	UCC-518296	.414	.585	.4360	.1285

Plate Nut Drill Jigs

Side-By-Side Plate Nut Drill Jigs



UCC 518XXX SERIES TYPES	DS TWO LUGS ONEHOLE ANCHOR PLATE NUT
STANDARD RIVET SPACING	

DS TWO LUGS ONE HOLE

STANDARD RIVET SPACING

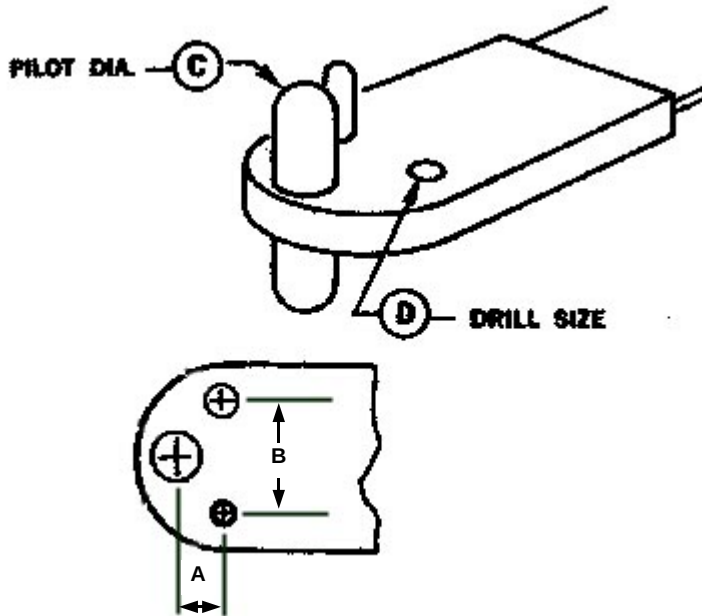
Select your **UNITED** Part Number by Drill (rivet) size D and then by Pilot Diameter size C. Lug Nut requires A and B.

HOLE PATTERN

[illegible]

Side-By-Side Plate Nut Drill Jigs

Plate Nut Drill Jigs



DR TWO LUGS ONE HOLE ANCHOR PLATE NUT	UCC 518XXX SERIES TYPES
	REDUCED RIVET SPACING SHORT-WING OR SHORT LUG MINIATURE OR MICRO- MINIATURE

DR TWO LUGS ONE HOLE

REDUCED RIVET SPACING

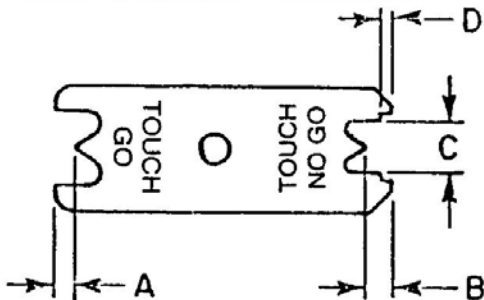
Select your **UNITED** Part Number by
Drill (rivet) size D and then by Pilot
Diameter size C. Lug Nut requires A and B.

HOLE PATTERN

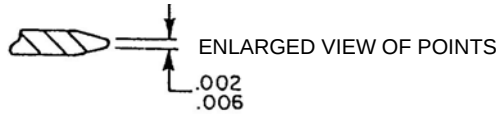
UNITED PART NO.	Space A DIM	Space B DIM	Drill C Pilot DIA	Jig D Rivet Hole	PART NO.	A	B	C	D	PART NO.	A	B	C	D
UCC-518870	.234	.219	.1640	.098	UCC-518326	.250	.219	.2480	.098	UCC-518890	.359	.269	.3120	.1285
UCC-518321	.234	.219	.2150	.098	UCC-518880	.281	.219	.2480	.098	UCC-518900	.359	.269	.3125	.1285
UCC-518905	.250	.219	.1875	.098	UCC-518336	.281	.219	.3120	.098	UCC-518346	.359	.269	.3730	.1285
UCC-518875	.250	.219	.1910	.098	UCC-518885	.312	.250	.3120	.1285	UCC-518895	.414	.269	.3720	.1285
					UCC-518351	.344	.300	.1910	.1285	UCC-518356	.438	.300	.2480	.1285
					UCC-518331	.344	.300	.2480	.1285	UCC-518341	.438	.300	.3120	.1285

UDB-34D Pin Position Gauge

Pin Position Gauge



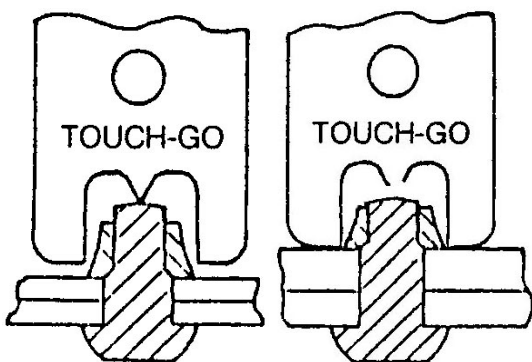
Locking Pin And Swage



UDB PART NO.	N.A.S. GAUGE NO.	NOMINAL SIZE	A +.001 -.000	B +.000 -.001	C ±.001	D ±.001
UDB-34D-9A	34D-9A	.164	.168	.260	.2530	.0875
UDB-34D-10A	34D-10A		.168	.254	.2400	.0795
UDB-34D-11	34D-11		.168	.254	.2530	.0605
UDB-34D-1	34D-1	.190 & .203	.238	.322	.2972	.0665
UDB-34D-2	34D-2		.218	.288	.2972	.0725
UDB-34D-3	34D-3	.250 & .266	.307	.399	.3942	.0725
UDB-34D-4	34D-4		.301	.379	.3942	.0995
UDB-34D-5	34D-5	.312 & .328	.399	.479	.4992	.0635
UDB-34D-6	34D-6		.384	.449	.4862	.1055
UDB-34D-7	34D-7	.375 & .391	.496	.582	.5892	.1185
UDB-34D-8	34D-8		.480	.545	.5892	.1555

PIN POSITION GAUGE	These gauges are designed to inspect the position of the installed swage locking pins in relation to the sheet line or work surface, verifying that the correct length of fastener was installed.
PIN POSITION and SWAGE GAUGE	These gauges, in addition to inspection of proper grip length, are also designed to inspect the swaged collar in relation to the sheet line or work surface to determine that the installed collar is completely and sufficiently swaged.

USAGE INSTRUCTIONS FOR UDB-34D and 75, EXCEPT 75-6 and 75-7 See next page.

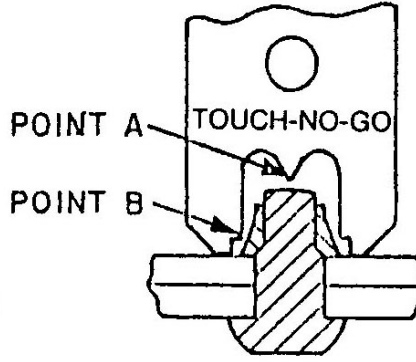


ACCEPT

1. Point Touches Pin
2. Legs of Gauge Clear Sheet Line
3. Pin is Acceptable
4. Gauge Pin with Touch-No Go End

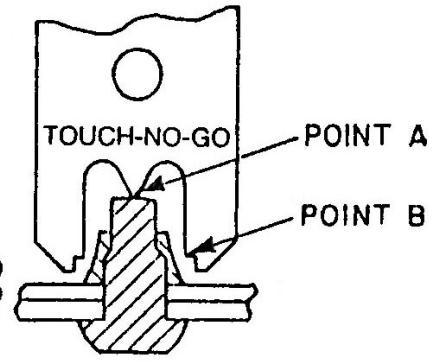
REJECT

1. Point Does Not Touch Sheet Line.
2. Legs of Gauge Touch Sheet Line
3. Pin Grip is Too Short.



ACCEPT

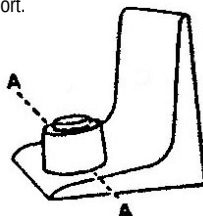
1. Point A Does Not Touch Pin
2. Legs of Gauge Touch Sheet Line
3. Points B Do Not Touch Collar
4. Pin Grip and Collar Swage is Acceptable
5. Gauge Pin with Touch-Go End



REJECT

1. Point A Touches Pin
2. Legs of Gauge Clear Sheet Line
3. Points B Touch Collar
4. Pin is Too Long
5. Collar is Not Swaged Enough

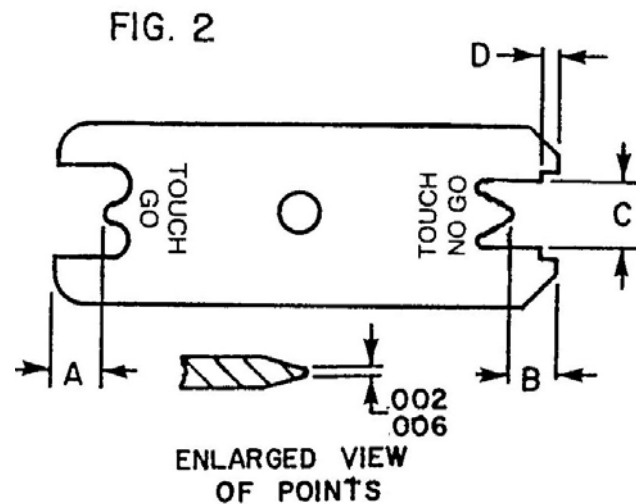
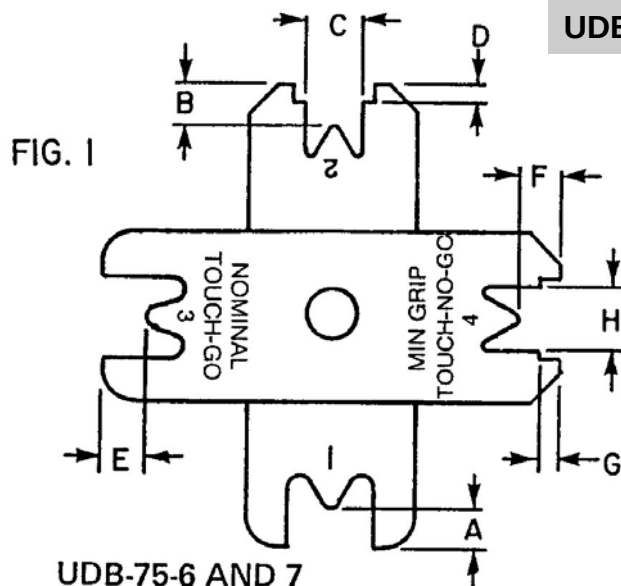
Against Slopes,
Use Gauge in
Plane A - A.



Inspection Gauges

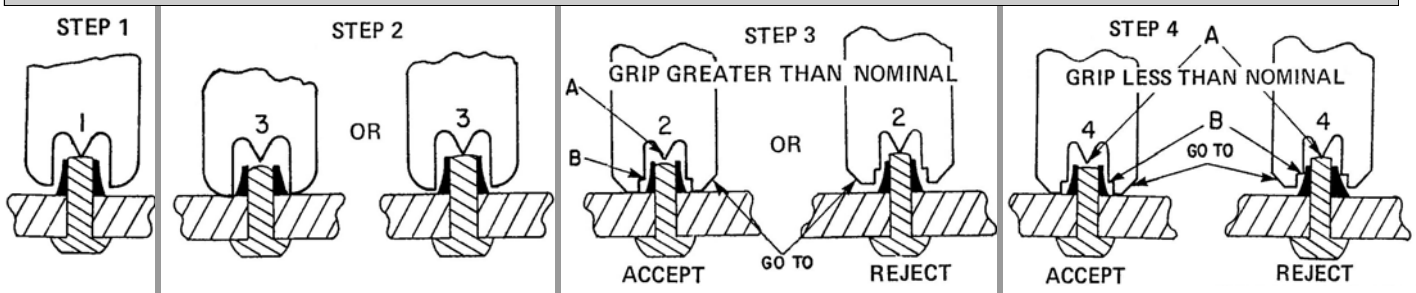
UDB-75

UDB-75-1 THRU 5 and 8 SHOWN on PREVIOUS PAGE



UDB PART NO.	N.A.S. GAUGE NO.	NOMINAL SIZE	A +.001 -.000	B +.000 -.001	C	D	E	F	G	H
UDB-75-5	75-5	.156 & .164	.169	.241	.2405	.081 .080				
UDB-75-8	75-11				.2400	.098 .097				
UDB-75-1	75-1	.190	.194	.266	.2795 .2775	.115 .113				
UDB-75-2	75-2	.250	.246	.318	.3704 .3684	.140 .138				
UDB-75-3	75-3	.312	.265	.337	.4720 .4700	.130 .128				
UDB-75-4	75-4	.375	.308	.380	.5657 .5637	.160 .158				
UDB-75-6	75-6	.125	.136	.1660	.1905	.072 .071	.1655	.209	.092	.1905
UDB-75-7	75-7			.1655	.1900	.062 .061	.1650	.208	.091	.1900

TO USE PIN POSITION AND SWAGE GAUGES UDB-75-6 and UDB-75-7,
BOTH STEP 1 AND STEP 3 or STEP 4 MUST ACCEPT.

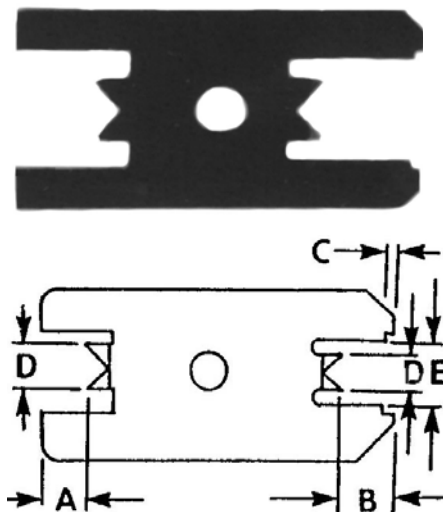


STEP 1	Point Touches Stump and Legs of Gauge Clear Sheet. Go to Step 2, if Point Clears Stump when Legs of Gauge Touch Sheet. REJECT
STEP 2	If Point Does Not Touch Pin, go to Step 3. If Point Touches Stump, go to Step 4.
STEP 3	Point A does Not Touch Stump. Grip is Not Under Minimum. Points B Do Not Touch Collar. Collar Swaged enough. ACCEPT Point A Touches Stump. Grip is Under Minimum and/or Points B Touch Collar. Collar Not Swaged enough. REJECT
STEP 4	Same procedure as Step 3 Except use Side 4 of Gauge.

UDB-85 Pin Position Gauge

Pin Position And Swage

UDB-85 PIN POSITION and SWAGE GAUGES

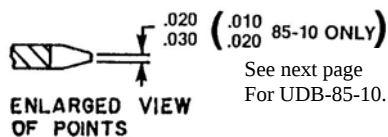
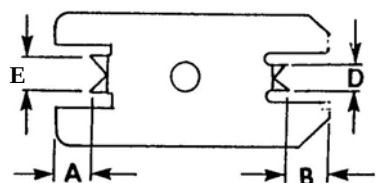


UDB PART NO.	N.A.S. GAUGE NO.	NOMINAL SIZE	A +.001 -.000	B	C	D ±.001	E ±.001
UDB-85-7	85-7	.164	.167	.230/.229	.030-.028	.136	.254-.252
UDB-85-12	85-12		.161	.234/.233	.037-.036	.136	.2535-.3530
UDB-85-17	85-17	.190 & .203	.200	.280/.279	.081-.079	.164	.286-.284
UDB-85-2	85-2	.250 & .266	.295	.374/.373	.038-.036	.224	.401-.399
UDB-85-18	85-18		.287	.364/.363	.058-.056	.224	.401-.399
UDB-85-21	85-21		.287	.364/.363	.140-.138	.224	.3704-.3684
UDB-85-3	85-3	.312 & .328	.339	.459/.458	.083-.081	.268	.487-.485
UDB-85-8	85-8		.404	.492/.491	.110-.109	.268	.4725-.4720
UDB-85-19	85-19		.404	.492/.491	.104-.102	.268	.487-.485
UDB-85-4	85-4	.375 & .391	.411	.549/.548	.062-.060	.339	.603-.601
UDB-85-9	85-9		.507	.604/.603	.120-.119	.339	.5755-.5750
UDB-85-22	85-22		.507	.604/.603	.150-.149	.339	.5755-.5750

USAGE INSTRUCTIONS FOR UDB-85, EXCEPT 85-10 See next page.

I TOUCH GO POINTS A POINTS B ACCEPT	II TOUCH GO POINTS A POINTS B REJECT	I - Points Touch Pin - Legs of Gauge Clear Sheet Line - Pin is Acceptable - Gauge Pin with Touch-No Go End	III TOUCH NO GO POINTS A POINTS B ACCEPT	IV TOUCH NO GO POINTS A POINTS B REJECT	III - Points A Do Not Touch Pin - Legs of Gauge Touch Sheet Line - Points B Do Not Touch Collar - Pin Grip and Collar Swage is Acceptable - Gauge Pin with Touch-Go End	IV - Points A Touch Pin - Legs of Gauge Clear Sheet Line - Points B Touch Collar - Pin is Too Long - Collar is Not Swaged Enough
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UDB-76 and UDB-90 PIN POSITION GAUGES



UDB PART NO.	N.A.S. GAUGE NO.	NOMINAL SIZE	A +.001 -.000	B +.001 -.000	D ±.001	E ±.001
UDB-76-#						
UDB-76-1A	76-1A	.190 & .203	.194	.264	.164	.150
UDB-76-2A	76-2A	.250 & .266	.248	.316	.224	.200
UDB-76-3	76-3	.312 & .328	.268	.341	.268	.268
UDB-76-4	76-4	.375 & .391	.319	.390	.339	.339
UDB-90-#						
UDB-90-4	90-4	.125	.160	.236	.100	.100
UDB-90-5	90-5	.156	.181	.261	.125	.125
UDB-90-6	90-6	.190	.186	.279	.164	.164
UDB-90-8	90-8	.250	.226	.318	.224	.224
UDB-90-10	90-10	.312	.265	.366	.268	.268
UDB-90-12	90-12	.375	.298	.403	.339	.339

USAGE INSTRUCTIONS FOR UDB-76 and UDB-90

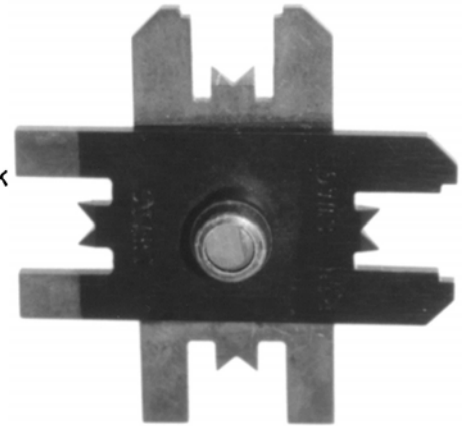
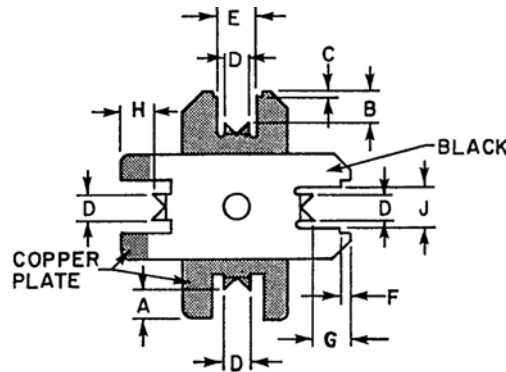
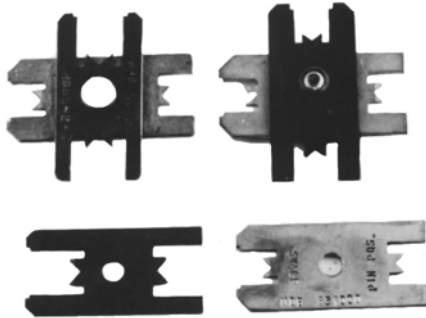
I TOUCH NO GO ACCEPT	II TOUCH NO GO REJECT	I - Points Do Not Touch Pin - Legs of Gauge Touch Sheet Line - Pin Grip is Too Short.	III TOUCH NO GO ACCEPT	IV TOUCH NO GO REJECT	I - Points Do Not Touch Pin - Legs of Gauge Touch Sheet Line - Pin is acceptable - Gauge Pin with Touch-Go End	II - Points Touch Pin - Legs of Gauge Clear Sheet Line - Pin is Too Long
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Pin Position And Swage

UDB-85-10 Pin Position Gauge

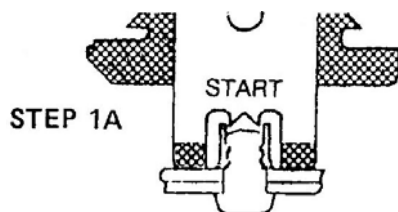
UDB-85-10 PIN POSITION and SWAGE GAUGES

SWAGE and PIN POSITION PROFILE GAUGE
FOR 3/16" STANDARD PULL TYPE BOLTS.



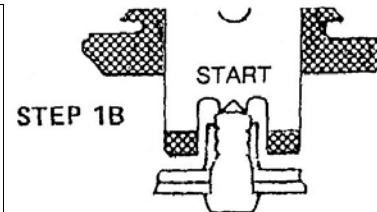
UDB PART NO.	N.A.S. GAUGE NO.	NOMINAL SIZE	A +.001 -.000	B	C	D ±.001	E	F	G	H	J
UDB-85-10	85-10	.190 & .203	.208	.2260 .2255	.039 .037	.164	.304 .302	.060 .058	.280 .279	.2255 .2250	.304 .302

HOW TO USE PIN POSITION AND SWAGE GAUGES UDB-85-10



STEP 1
USE START

- A. If Copper Plate Finish touches the Sheet, see Step 2 below.
- B. If Black Touches the Pin, see Step 3 below.

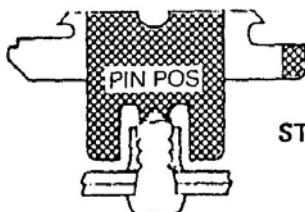


STEP 2
USE COPPER PLATE

- A. Check Pin Position: Legs Must Not Touch the Sheet.
- B. Check Swage: Legs Must Touch the Sheet.

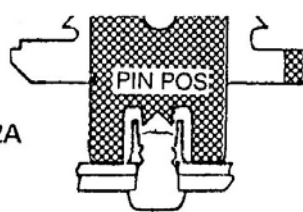
STEP 3
USE BLACK

- A. Check Pin Position: Legs Must Touch the Sheet.
- B. Check Swage: Legs Must Touch the Sheet.

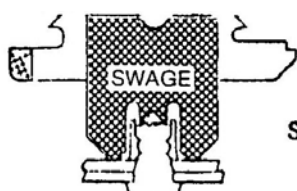


STEP 2A

ACCEPT

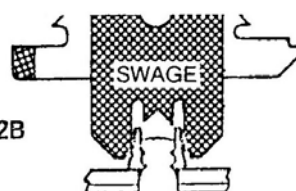


REJECT

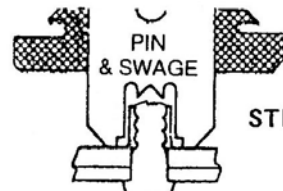


STEP 2B

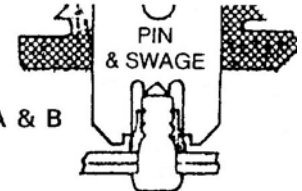
ACCEPT



REJECT



ACCEPT



REJECT

STEP 3A & B