

DG Drill Guides

Precision Guidance

The UNITED Pressure Foot Drilling System

DG *

DG Precision Drill Guide

UNITED's 'DG' Drill Guides are used with precision tooling.

DG Guides give the highest quality production through precision I.D. and O.D. tolerances without wear to the production tool.

I.D. and concentricity are to ANSI specifications.

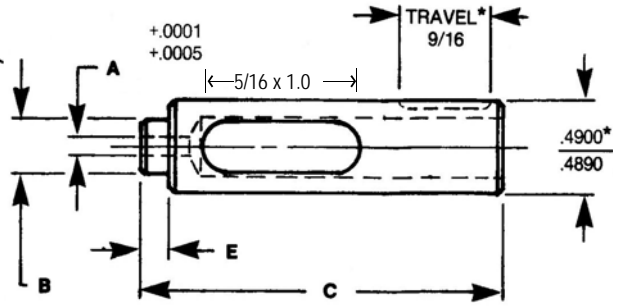
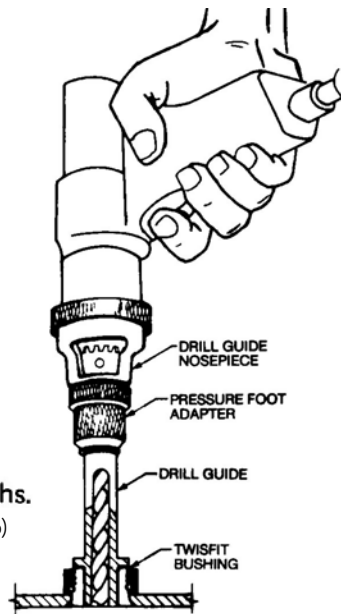
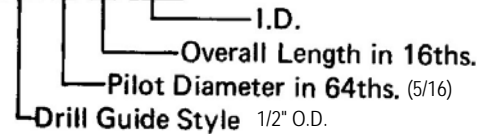
* For 5/8" body O.D. and 3/4" travel, specify 'DGL' (Fits PFA-40-12).



TYPE 2

Use with DGNP-32-xx NOSEPIECE

DG-20-24-5/32

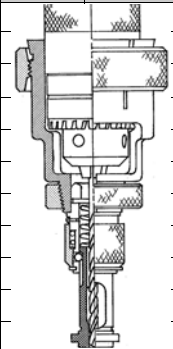
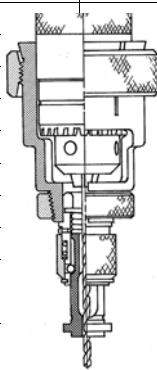


A and B diameters concentric within .0005 T.I.R.
 E = .43 for 5/16 Pilot Diameters.
 E = .70 for 1/2 Pilot Diameters.

ALLOY STEEL
 HEAT TREATED RC-60-65

REF SP-12D

A		B		DASH	C OVERALL LENGTH													
I.D. RANGE	PILOT DIAMETER	NOM.	ACTUAL		-24	-26	-28	-30	-32	-34	-36	-38	-40	-42	-46	-68		
NOMINAL	DECIMAL	NOM.	ACTUAL		1-1/2	1-5/8	1-3/4	1-7/8	2"	2-1/8	2-1/4	2-3/8	2-1/2	2-5/8	2-7/8	4-1/4		
5/32 thru 11/64	.1562 .1719	5/16 1/2	.3122 - .3117 .4995 - .4990	-20 -32	DG-20-24												DG-20-46 DG-32-46	DG-20-68 DG-32-68
#17 thru #14	.1730 .1820	5/16 1/2	.3122 - .3117 .4995 - .4990	-20 -32		DG-20-26 DG-32-26											DG-20-46 DG-32-46	DG-20-68 DG-32-68
#13 thru #11	.1850 .1910	5/16 1/2	.3122 - .3117 .4995 - .4990	-20 -32			DG-20-28 DG-32-28										DG-20-46 DG-32-46	DG-20-68 DG-32-68
#10 thru 13/64	.1935 .2031	5/16 1/2	.3122 - .3117 .4995 - .4990	-20 -32			DG-20-30 DG-32-30										DG-20-46 DG-32-46	DG-20-68 DG-32-68
#6 thru 7/32	.2040 .2187	5/16 1/2	.3122 - .3117 .4995 - .4990	-20 -32				DG-20-32 DG-32-32									DG-20-46 DG-32-46	DG-20-68 DG-32-68
#2 thru 15/64	.2210 .2344	5/16 1/2	.3122 - .3117 .4995 - .4990	-20 -32					DG-20-34 DG-32-34								DG-20-46 DG-32-46	DG-20-68 DG-32-68
'B' thru 1/4	.2380 .2500	5/16 1/2	.3122 - .3117 .4995 - .4990	-20 -32						DG-20-36 DG-32-36							DG-20-46 DG-32-46	DG-20-68 DG-32-68
'F' thru 'J'	.2570 .2770	1/2	.4995 - .4990	-32							DG-32-38						DG-32-46	DG-32-68
'K' thru 'L'	.2811 .2900	1/2	.4995 - .4990	-32								DG-32-40					DG-32-46	DG-32-68
'M' thru 'O'	.2950 .3160	1/2	.4995 - .4990	-32									DG-32-42	DG-32-46			DG-32-46	DG-32-68



NOTE: Drill Guides with 9/16 travel use jobber length drills and PFA-32-9 Pressure Foot Adapter (Lengths 1-1/2 thru 2-5/8 guide jobber length drills). Drill Guides with 1-1/4 travel use six inch extension drills and PFA-32-20 Pressure Foot Adapter. Drill Guides with 9/16 travel use six inch extension drills and PFA-32-9 Pressure Foot Adapter. Lengths 2-7/8 and 4-1/4 guide six inch extension drills.

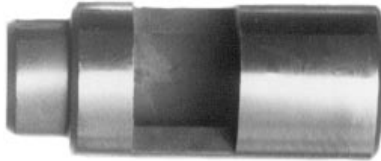
Angularity Controlled

The UNITED Pressure Foot Drilling System

DGB and DGA Drill Guides

DGB DRILL GUIDES

TYPE I REF SP 127-LC

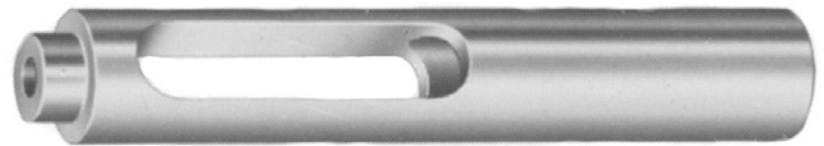


DGB—SHORT LENGTH

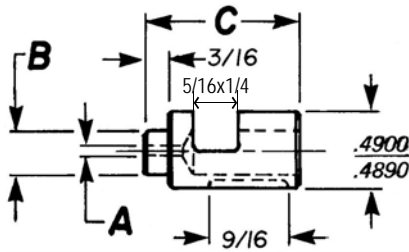
USE WITH DGNP-32-XX NOSEPIECE
USE WITH PFA-32-9

DGA DRILL GUIDES

TYPE II REF SP 127-JC



DGA—REGULAR LENGTH

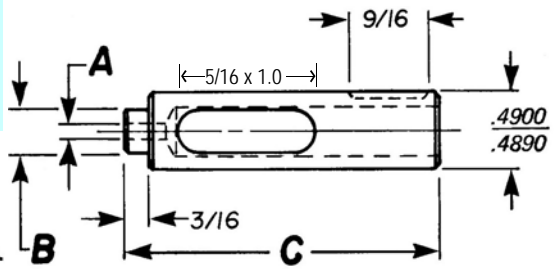


DGA and DGB Drill Guides are used with standard jobber length drills for conventional drilling. Both Guides have 9/16 travel.

ORDERING EXAMPLE

DGA-16-16-#58

I.D.
Overall Length in 16ths.
Pilot Diameter in 64ths.
Drill Guide Style



DG-16-68 THRU DG-24-68 REF SP127-XC

A		B		C OVERALL LENGTH															
I. D. RANGE		PILOT DIAMETER		-16	-18	-22	-26	-30	-34	-36	-38	-40	-42	-44	-68				
NOMINAL	DECIMAL	NOMINAL	DASH	1"	1-1/8	1-3/8	1-5/8	1-7/8	2-1/8	2-1/4	2-3/8	2-1/2	2-5/8	2-3/4	4-1/4				
#58 thru 3/32	.0420	1/4	-16	DGB-16-16												DGA-16-68			
	.0937	5/16	-20	DGB-20-16	Chip Slot: $\left\langle \leftarrow 5/16 \times 1/4 \rightarrow \right\rangle$														
		3/8	-24	DGB-24-16													DGA-24-68		
#41 thru 9/64	.0960	1/4	-16		DGB-16-18											DGA-16-68			
	.1406	5/16	-20		DGB-20-18	Chip Slot: $\left\langle \leftarrow 5/16 \times 1/4 \rightarrow \right\rangle$													
		3/8	-24		DGB-24-18												DGA-24-68		
#27 thru #22	.1440	1/4	-16			DGA-16-22										DGA-16-68			
	.1570	5/16	-20			DGA-20-22	Chip Slot: $\left\langle \leftarrow 5/16 \times 5/8 \rightarrow \right\rangle$												
		3/8	-24			DGA-24-22											DGA-24-68		
#21 thru #11	.1590	1/4	-16				DGA-16-26									DGA-16-68			
	.1910	5/16	-20				DGA-20-26	Chip Slot: $\left\langle \leftarrow 5/16 \times 3/4 \rightarrow \right\rangle$											
		3/8	-24			DGA-24-26											DGA-24-68		
#10 thru 13/64	.1935															DGA-16-68			
	.2031	5/16	-20					DGA-20-30	Chip Slot: $\left\langle \leftarrow 5/16 \times 1-3/16 \rightarrow \right\rangle$										
		3/8	-24						DGA-24-30								DGA-24-68		
#6 thru 7/32	.2040															DGA-16-68			
	.2187	5/16	-20						DGA-20-34	DGA-20-36	Chip Slot (& all below) $\left\langle \leftarrow 5/16 \times 1.0 \rightarrow \right\rangle$								
		3/8	-24							DGA-24-34	DGA-24-36					DGA-24-68			
#2 thru 1/4	.2210															DGA-16-68			
	.2500	5/16	-20								DGA-20-38					DGA-24-68			
		3/8	-24								DGA-24-38					DGA-24-68			
'F' thru 'J'	.2570															DGA-16-68			
	.2770	3/8	-24									DGA-24-40				DGA-24-68			
'K' thru 'L'	.2811															DGA-16-68			
	.2900	3/8	-24										DGA-24-42			DGA-24-68			
																DGA-16-68			
'M' thru 'O'	.2950															DGA-16-68			
	.3160	3/8	-24												DGA-24-44	DGA-24-68			

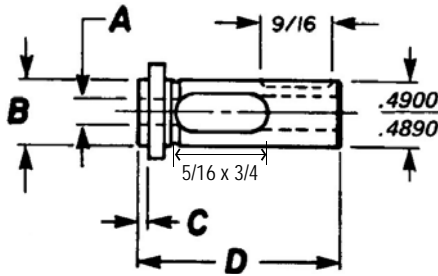
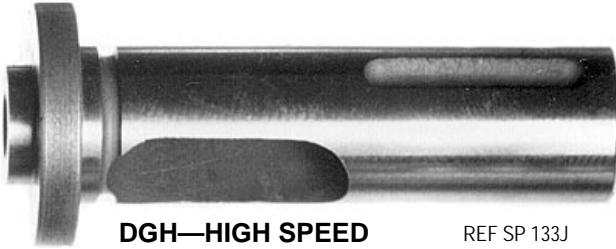
USE DGA AND DGB WITH PFA-32-9 PRESSURE FOOT ADAPTER.

DGH and DGT Drill Guides

Angularity Controlled

The UNITED Pressure Foot Drilling System

DGH DRILL GUIDES

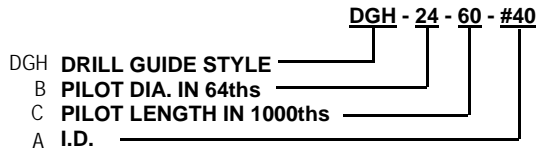


DGH Drill Guide lengths correspond to jobber drills. DGH is used for hi-speed drilling applications.

The pilot lengths provided correspond to conventional plate thickness for hi-speed drilling.

Coolant should be used for the best results with hi-speed drilling.

ORDERING EXAMPLE

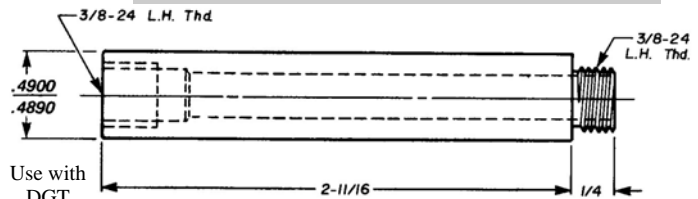


A		D LEN	LEN #
I.D. RANGE			
NOMINAL	DECIMAL		
#40 thru 9/64	.0980 .1406	1-1/8	18
#27 thru #22	.1440 .1570	1-3/8	24
#21 thru #11	.1590 .1910	1-5/8	26
#10 thru 13/64	.1935 .2031	1-7/8	28
#6 thru 7/32	.2040 .2187	2-1/8	34
#2 thru 1/4	.2210 .2500	2-3/8	38
'F' thru 'J'	.2570 .2770	2-1/2	40
'K' thru 'L'	.2810 .2900	2-5/8	42
'M' thru 'O'	.2950 .3160	2-3/4	44

A		B		C PILOT LENGTH		
I.D. RANGE		PILOT DIAMETER		DGH (OAL in 16THs)		
NOMINAL	DECIMAL	NOMINAL	DASH	.060 (1/16)	.080 (5/64)	.125 (1/8)
#40 thru #1	.0980 .2280	3/8	-24	DGH-24-60	DGH-24-80	DGH-24-125
#40 thru 'O'	.0980 .3160	1/2	-32	DGH-32-60	DGH-32-80	DGH-32-125
#40 thru 'O'	.0980 .3160	9/16	-36	DGH-36-60	DGH-36-80	DGH-36-125
#40 thru 'O'	.0980 .3160	5/8	-40	DGH-40-60	DGH-40-80	DGH-40-125

Use DGH with PFA-32-9 Pressure Foot Adapter and DGNP-32-XX Nosepiece.

DGE DRILL GUIDE EXTENSIONS



Use with DGT

DGE-32-43 EXTENSION PART NO.

REF SP 12528

DGT DRILL GUIDES



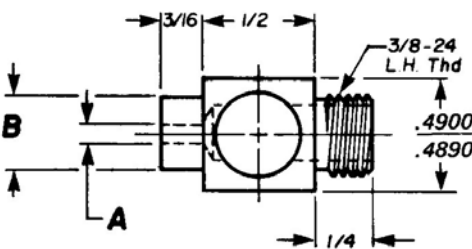
DGT—THREADED TIP
See additional sizes on Page C25.

REF SP 12523

Use DGS with PFA-32-9 Pressure Foot Adapter and DGNP-32-XX Nosepiece.

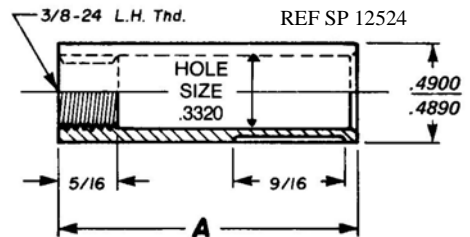
Use Threaded Drill Guide Tips and Threaded Sleeves with standard jobber length drills.

Add the Threaded Drill Guide Extension and use six inch Extension Drills.



A		B		PART NO.
I.D. RANGE		PILOT DIAMETER		
NOMINAL	DECIMAL	NOMINAL	DASH	
#58 thru #10	.0420 .1935	1/4	-16	DGT-16-3
#58 thru 1/4	.0420 .2500	5/16	-20	DGT-20-3
#58 thru 1/4	.0420 .2500	3/8	-24	DGT-24-3

DGS DRILL GUIDE SLEEVES



Use DGS with PFA-32-9 Pressure Foot Adapter and DGNP-32-XX Nosepiece.

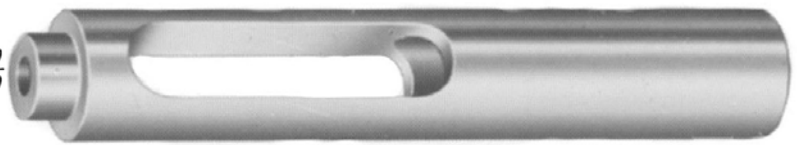
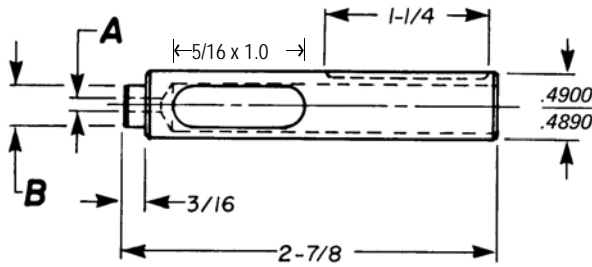
A LENGTH	PART NO.
27/32	DGS-32-27
1-3/32	DGS-32-35
1-17/32	DGS-32-49
3"	DGS-32-96
3-1/2"	DGS-32-112

Deep Controlled Holes

The UNITED Pressure Foot Drilling System

**DGC and DGF
Drill Guides**

DGC DRILL GUIDES



DGC—STANDARD EXTENDED

USE WITH DGNP-32-XX NOSEPIECE, Page C6.

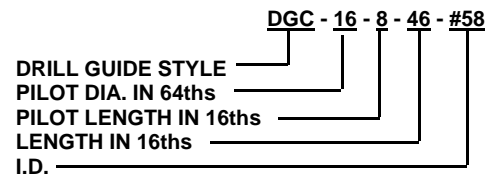
USE DGC WITH PFA-32-20 PRESSURE FOOT ADAPTER. See page C8.

REF: SP127LC

A		B		PART
I.D. RANGE		PILOT DIA.		NO.
NOMINAL	DECIMAL	NOM	DASH	ANSI
#58 - 5/64	.0420 - .0781	1/4	- 16	DGC-16-46
#47 - 7/64	.0785 - .1093	1/4	- 16	DGC-16-46
#35 - #10	.1100 - .1935	1/4	- 16	DGC-16-46
#58 - 5/64	.0420 - .0781	5/16	- 20	DGC-20-46
#47 - 7/64	.0785 - .1093	5/16	- 20	DGC-20-46
#35 - #10	.1100 - .1935	5/16	- 20	DGC-20-46
#9-1/4	.1960 - .2500	5/16	- 20	DGC-20-46
#58-5/64	.0420 - .0781	3/8	- 24	DGC-24-46
#47-7/64	.0785 - .1093	3/8	- 24	DGC-24-46
#35-#10	.1100 - .1935	3/8	- 24	DGC-24-46
#9-1/4	.1960 - .2500	3/8	- 24	DGC-24-46
F-O	.2570 - .3160	3/8	- 24	DGC-24-46

To Order,
ADD LENGTH of
PILOT. See Chart
below and Ordering
Example for format.

ORDERING EXAMPLE



LENGTH OF PILOT — ANSI LENGTH IN 1/16 Other Lengths are Special											
1/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1"
1	2	3	4	5	6	7	8	10	12	14	16

DGF Drill Guides are the same as DGC but with depth control grooves added to allow controlled depths of 7/8, 1-1/8 and 1-3/8.

USE DGF WITH PFA-32-20 PRESSURE FOOT ADAPTER (pg. C8) AND DGNP-32-xx NOSEPIECE.

REF: SP127LC with STOP GROOVES. See page C8.

DGF DRILL GUIDES



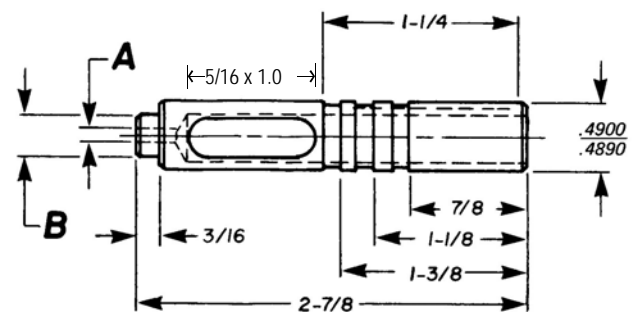
DGF— WITH DEPTH CONTROL GROOVES

A		B		PART
I.D. RANGE		PILOT DIA.		NO.
NOMINAL	DECIMAL	NOM	DASH	ANSI
#58 - 5/64	.0420 - .0781	1/4	- 16	DGF-16-46
#47 - 7/64	.0785 - .1093	1/4	- 16	DGF-16-46
#35 - #10	.1100 - .1935	1/4	- 16	DGF-16-46
#58 - 5/64	.0420 - .0781	5/16	- 20	DGF-20-46
#47 - 7/64	.0785 - .1093	5/16	- 20	DGF-20-46
#35 - #10	.1100 - .1935	5/16	- 20	DGF-20-46
#9-1/4	.1960 - .2500	5/16	- 20	DGF-20-46
#58-5/64	.0420 - .0781	3/8	- 24	DGF-24-46
#47-7/64	.0785 - .1093	3/8	- 24	DGF-24-46
#35-#10	.1100 - .1935	3/8	- 24	DGF-24-46
#9-1/4	.1960 - .2500	3/8	- 24	DGF-24-46
F-O	.2570 - .3160	3/8	- 24	DGF-24-46

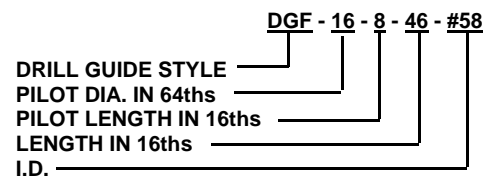


Stop Clip for Grooves. See page C8. DGSC-16 fits 1/2 O.D.s

To Order,
ADD LENGTH of
PILOT. See Chart
below and Ordering
Example for format.



ORDERING EXAMPLE



LENGTH OF PILOT — ANSI LENGTH IN 1/16 Other Lengths are Special											
1/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1"
1	2	3	4	5	6	7	8	10	12	14	16

DGJ and DGI Drill Guides

Drill Breakage Eliminated

The UNITED Pressure Foot Drilling System

DGJ DRILL GUIDES

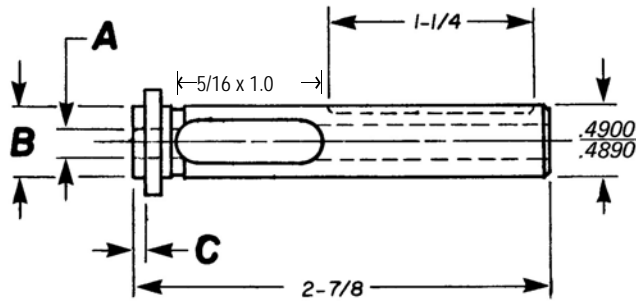


DGJ Drill Guides are used in the higher speed drill motors.

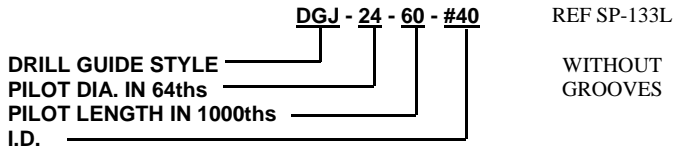
Use with six inch extension drills only.

DGJ—HIGH SPEED FOR EXTENSION DRILLS

Use DGJ with PFA-32-20 Pressure Foot Adapter and DGNP-32-XX Nosepiece.

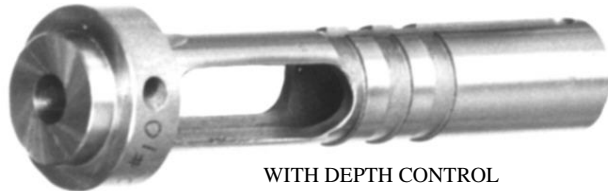


ORDERING EXAMPLE



A		B		C PILOT LENGTH		
I. D. RANGE		PILOT DIAMETER		DGJ (OAL LEN IN 16THS)		
NOMINAL	DECIMAL	NOMINAL	DASH	.060 (1/16)	.080 (5/64)	.125 (1/8)
#40 thru #1	.0980 .2280	3/8	-24	DGJ-24-60	DGJ-24-80	DGJ-24-125
#40 thru 'O'	.0980 .3160	1/2	-32	DGJ-32-60	DGJ-32-80	DGJ-32-125
#40 thru 'O'	.0980 .3160	9/16	-36	DGJ-36-60	DGJ-36-80	DGJ-36-125
#40 thru 'O'	.0980 .3160	5/8	-40	DGJ-40-60	DGJ-40-80	DGJ-40-125

DGI DRILL GUIDES

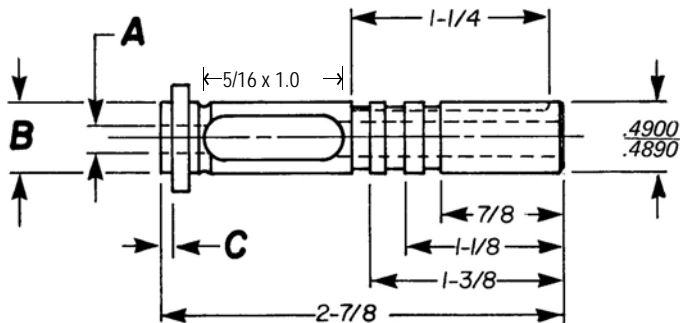


WITH DEPTH CONTROL

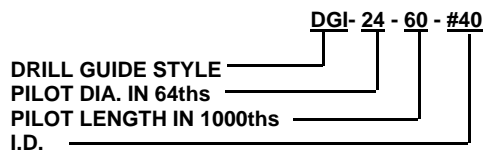
DGI—HIGH SPEED DEPTH CONTROL GUIDE

DGI Drill Guides are the same as the DGJ with the addition of Depth Control Grooves.

Use DGI with PFA-32-10 Pressure Foot Adapter and DGNP-32-XX Nosepiece.



ORDERING EXAMPLE



REF SP-138L (WITH GROOVES—DGI)
REF SP-133L (WITHOUT GROOVES—DGJ—SEE)

A		B		C PILOT LENGTH		
I. D. RANGE		PILOT DIAMETER		DGI (OAL LEN IN 16THS)		
NOMINAL	DECIMAL	NOMINAL	DASH	.060 (1/16)	.080 (5/64)	.125 (1/8)
#40 thru #1	.0980 .2280	3/8	-24	DGI-24-60	DGI-24-80	DGI-24-125
#40 thru 'O'	.0980 .3160	1/2	-32	DGI-32-60	DGI-32-80	DGI-32-125
#40 thru 'O'	.0980 .3160	9/16	-36	DGI-36-60	DGI-36-80	DGI-36-125
#40 thru 'O'	.0980 .3160	5/8	-40	DGI-40-60	DGI-40-80	DGI-40-125

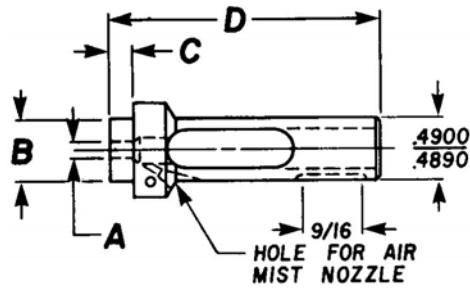
Cutting Hole Protection

The UNITED Pressure Foot Drilling System

DGMC and DGME Drill Guides

USE WITH DGNP-32-XX NOSEPIECE

USE DGMC WITH PFA-32-9 PRESSURE FOOT ADAPTER



DGMC DRILL GUIDES



DGMC—FLANGED AIR MIST STYLE C
ORDERING EXAMPLE

USE AMU-22-23-24 AIR MIST ASSEMBLY

See Chart below for Chip Slot Length.

USE DGMC WITH JOBBER DRILLS and AIR MIST.

DGMC - 20 - 8 - #28

DRILL GUIDE STYLE
PILOT DIA. IN 64ths
LENGTH IN 16ths
I.D.

A		D LENGTH
I.D. RANGE NOMINAL	DECIMAL	
#28 thru #22	.1405 .1570	1-3/8
#21 thru #16	.1590 .1770	1-5/8
#15 thru 3/16	.1800 .1875	1-3/4
#12 thru #10	.1890 .1935	1-7/8
#9 thru #4	.1960 .2090	2-1/8
#3 thru 1/4	.2130 .2500	2-1/4
'F' thru 'J'	.2570 .2770	2-3/8
'K' thru 'L'	.2810 .2900	2-1/2
'M' thru 'O'	.2950 .3160	2-3/4

A		B		C PILOT LENGTH							
I.D. RANGE NOMINAL	DECIMAL	PILOT DIAMETER NOMINAL	DASH	-1 1/16	-2 1/8	-3 3/16	-4 1/4	-5 5/16	-6 3/8	-7 7/16	-8 1/2
#28 thru #11	.1405 .1910	5/16	-20	DGMC-20-1	DGMC-20-2	DGMC-20-3	DGMC-20-4	DGMC-20-5	DGMC-20-6	DGMC-20-7	DGMC-20-8
#10 thru #1	.1935 .2280	3/8	-24	DGMC-24-1	DGMC-24-2	DGMC-24-3	DGMC-24-4	DGMC-24-5	DGMC-24-6	DGMC-24-7	DGMC-24-8
'A' thru 'L'	.2340 .2900	7/16	-28	DGMC-28-1	DGMC-28-2	DGMC-28-3	DGMC-28-4	DGMC-28-5	DGMC-28-6	DGMC-28-7	DGMC-28-8
7/32 thru 'O'	.2187 .3160	1/2	-32	DGMC-32-1	DGMC-32-2	DGMC-32-3	DGMC-32-4	DGMC-32-5	DGMC-32-6	DGMC-32-7	DGMC-32-8
7/32 thru 'O'	.2187 .3160	9/16	-36	DGMC-36-1	DGMC-36-2	DGMC-36-3	DGMC-36-4	DGMC-36-5	DGMC-36-6	DGMC-36-7	DGMC-36-8
7/32 thru 'O'	.2187 .3160	5/8	-40	DGMC-40-1	DGMC-40-2	DGMC-40-3	DGMC-40-4	DGMC-40-5	DGMC-40-6	DGMC-40-7	DGMC-40-8

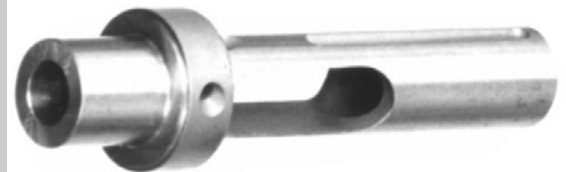
USE DGME WITH PFA-32-9 PRESSURE FOOT ADAPTER AND DGNP-32-xx NOSEPIECE.

DGME Flange Air Mist Drill Guides are used for high speed drilling. The pilot length corresponds with the height of the UNITED Twisfit Bushing.

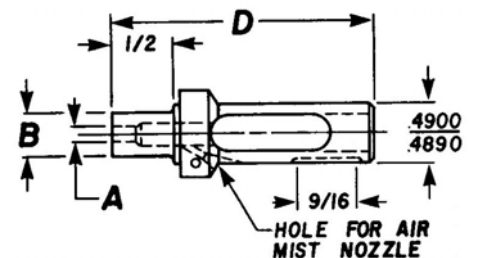
Maximum bearing between the pilot O.D. and the Twisfit I.D. assures accurate hole location and perpendicular drilling.

USE DGME WITH JOBBER DRILLS IN TWISFIT BUSHINGS.

DGME DRILL GUIDES



DGME— FLANGED AIR MIST STYLE E



USE AMU-22-23-24 AIR MIST ASSEMBLY

ORDERING EXAMPLE

DGME - 20 - 8 - #28

DRILL GUIDE STYLE
PILOT DIA. IN 64ths
LENGTH IN 16ths
I.D.

A		D LEN	Chip Slot Length (5/16 wide)
I.D. RANGE NOMINAL	DECIMAL		
#28 thru #22	.1405 .1570	1-3/8	5/8
#21 thru #16	.1590 .1770	1-5/8	5/8
#15 thru 3/16	.1800 .1875	1-3/4	5/8
#12 thru #10	.1890 .1935	1-7/8	3/4
#9 thru #4	.1960 .2090	2-1/8	3/4
#3 thru 1/4	.2130 .2500	2-1/4	7/8
'F' thru 'J'	.2570 .2770	2-3/8	7/8
'K' thru 'L'	.2810 .2900	2-1/2	1.0
'M' thru 'O'	.2950 .3160	2-3/4	1.0

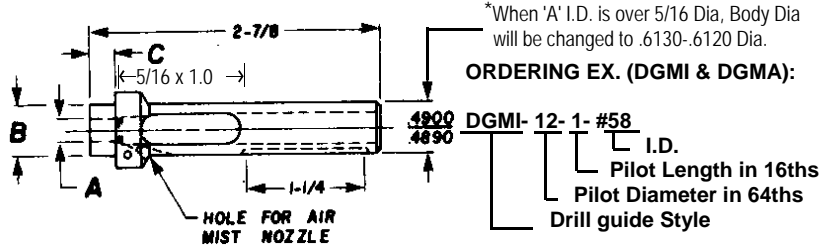
A		B		PART NO.
I.D. RANGE NOMINAL	DECIMAL	PILOT DIAMETER NOMINAL	DASH	
#28 thru #11	.1405 .1910	5/16	-20	DGME-20-8
#10 thru #1	.1935 .2280	3/8	-24	DGME-24-8
'A' thru 'L'	.2340 .2900	7/16	-28	DGME-28-8
7/32 thru 'O'	.2187 .3160	1/2	-32	DGME-32-8

DGMI and DGMA Drill Guides

Bushing Wear Eliminated

The UNITED Pressure Foot Drilling System

DGMI DRILL GUIDES

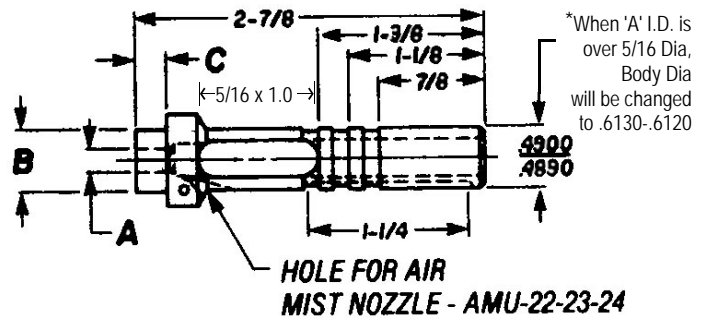


DGMI—FLANGE AIR MIST FOR EXTENSION

USE AMU-22-23-24 AIR MIST ASSEMBLY. FOR EXTENSION DRILLS USE PFA-32-20 AND DGNP-32-

A		B		C PILOT LENGTH								
I.D. RANGE		PILOT DIAMETER		-1	-2	-3	-4	-5	-6	-7	-8	
NOMINAL	DECIMAL	NOMINAL	DASH	1/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	
#58 thru #39	.0420 .0995	3/16	-12	DGMI-12-1	DGMI-12-2	DGMI-12-3	DGMI-12-4	DGMI-12-5	DGMI-12-6	DGMI-12-7	DGMI-12-8	
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMI-16-1	DGMI-16-2	DGMI-16-3	DGMI-16-4	DGMI-16-5	DGMI-16-6	DGMI-16-7	DGMI-16-8	
1/8 thru #7	.1250 .2010	5/16	-20	DGMI-20-1	DGMI-20-2	DGMI-20-3	DGMI-20-4	DGMI-20-5	DGMI-20-6	DGMI-20-7	DGMI-20-8	
3/16 thru 1/4	.1875 .2500	3/8	-24	DGMI-24-1	DGMI-24-2	DGMI-24-3	DGMI-24-4	DGMI-24-5	DGMI-24-6	DGMI-24-7	DGMI-24-8	
'F' thru 'L'	.2570 .2900	7/16	-28	DGMI-28-1	DGMI-28-2	DGMI-28-3	DGMI-28-4	DGMI-28-5	DGMI-28-6	DGMI-28-7	DGMI-28-8	
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMI-32-1	DGMI-32-2	DGMI-32-3	DGMI-32-4	DGMI-32-5	DGMI-32-6	DGMI-32-7	DGMI-32-8	
9/32 thru 'O'	.2812 .3160	9/16	-36	DGMI-36-1	DGMI-36-2	DGMI-36-3	DGMI-36-4	DGMI-36-5	DGMI-36-6	DGMI-36-7	DGMI-36-8	
9/32 thru 25/64	.2812 .3906*	5/8	-40	DGMI-40-1	DGMI-40-2	DGMI-40-3	DGMI-40-4	DGMI-40-5	DGMI-40-6	DGMI-40-7	DGMI-40-8	

DGMA DRILL GUIDES



DGMA—FLANGE AIR MIST WITH DEPTH CONTROL

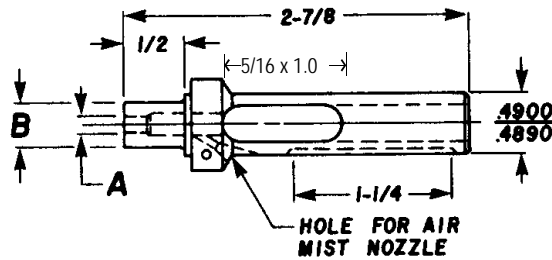
USE AMU-22-23-24 AIR MIST ASSEMBLY. FOR EXTENSION DRILLS USE WITH PFA-32-20 AND DGNP-32-XX NOSEPIECE.

A		B		C PILOT LENGTH								
I.D. RANGE		PILOT DIAMETER		-1	-2	-3	-4	-5	-6	-7	-8	
NOMINAL	DECIMAL	NOMINAL	DASH	1/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	
#58 thru #39	.0420 .0995	3/16	-12	DGMA-12-1	DGMA-12-2	DGMA-12-3	DGMA-12-4	DGMA-12-5	DGMA-12-6	DGMA-12-7	DGMA-12-8	
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMA-16-1	DGMA-16-2	DGMA-16-3	DGMA-16-4	DGMA-16-5	DGMA-16-6	DGMA-16-7	DGMA-16-8	
1/8 thru #7	.1250 .2010	5/16	-20	DGMA-20-1	DGMA-20-2	DGMA-20-3	DGMA-20-4	DGMA-20-5	DGMA-20-6	DGMA-20-7	DGMA-20-8	
3/16 thru 1/4	.1875 .2500	3/8	-24	DGMA-24-1	DGMA-24-2	DGMA-24-3	DGMA-24-4	DGMA-24-5	DGMA-24-6	DGMA-24-7	DGMA-24-8	
'F' thru 'L'	.2570 .2900	7/16	-28	DGMA-28-1	DGMA-28-2	DGMA-28-3	DGMA-28-4	DGMA-28-5	DGMA-28-6	DGMA-28-7	DGMA-28-8	
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMA-32-1	DGMA-32-2	DGMA-32-3	DGMA-32-4	DGMA-32-5	DGMA-32-6	DGMA-32-7	DGMA-32-8	
9/32 thru 'O'	.2812 .3160	9/16	-36	DGMA-36-1	DGMA-36-2	DGMA-36-3	DGMA-36-4	DGMA-36-5	DGMA-36-6	DGMA-36-7	DGMA-36-8	
9/32 thru 25/64	.2812 .3906*	5/8	-40	DGMA-40-1	DGMA-40-2	DGMA-40-3	DGMA-40-4	DGMA-40-5	DGMA-40-6	DGMA-40-7	DGMA-40-8	

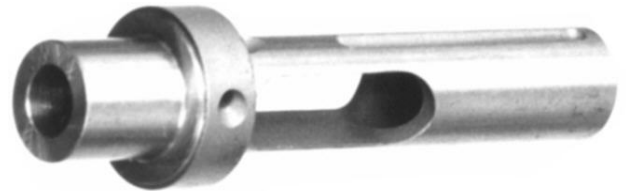
For Twisfit Applications

The UNITED Pressure Foot Drilling System

**DGMJ and DGMB
Drill Guides**



DGMJ DRILL GUIDES



**DGMJ—CRITICAL HOLE,
EXTENDED AIR MIST USED WITH TWISFIT BUSHINGS**

USE
AMU-22-23-24
AIR MIST

DGMJ Flange Air Mist Drill Guides for high speed drilling with extension drills without depth control grooves. The pilot length corresponds with the height of Twisfit Bushings.

Maximum bearing between the pilot O.D. and the Twisfit I.D. assures accurate hole location and perpendicular drilling.

USE WITH
DGNP-32-XX
NOSEPIECE

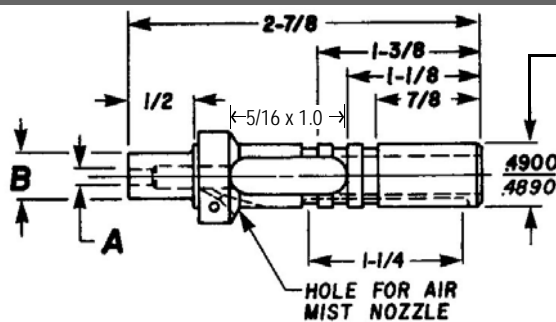
ORDERING EXAMPLE:

DGMJ - 12 - 8 - #58

DRILL GUIDE STYLE
PILOT DIA. IN 64ths
LENGTH IN 16ths
I.D.

A		B		PART NO.
I.D. RANGE		PILOT DIAMETER		
NOMINAL	DECIMAL	NOMINAL	DASH	
#58 thru #40	.0420 .0980	3/16	-12	DGMJ-12-8
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMJ-16-8
#27 thru #11	.1440 .1910	5/16	-20	DGMJ-20-8
#10 thru #1	.1935 .2280	3/8	-24	DGMJ-24-8
'A' thru 'L'	.2340 .2900	7/16	-28	DGMJ-28-8
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMJ-32-8

USE DGMJ WITH
PFA-32-20 PRESSURE
FOOT ADAPTER



*When 'A' I.D. is over 5/16 Dia, Body Dia will be changed to .6130-.6120 Dia.

DGMB DRILL GUIDES

REF SP 138



**DGMB—CRITICAL HOLE, EXTENDED AIR MIST
WITH DEPTH CONTROL USED WITH TWISFIT BUSHINGS**

DGMB Flange Air Mist Drill Guides for high speed drilling with extension drills with depth control grooves. The pilot length corresponds with the height of Twisfit Bushings.

Maximum bearing between the pilot O.D. and the Twisfit I.D. assures accurate hole location and perpendicular drilling.

USE WITH DGNP-32-XX
NOSEPIECE

ORDERING EXAMPLE:

DGMB - 12 - 8 - #58

USE DGMB WITH PFA-32-20
PRESSURE FOOT ADAPTER

DRILL GUIDE STYLE
PILOT DIA. IN 64ths
LENGTH IN 16ths
I.D.

A		B		PART NO.
I.D. RANGE		PILOT DIAMETER		
NOMINAL	DECIMAL	NOMINAL	DASH	
#58 thru #40	.0420 .0980	3/16	-12	DGMB-12-8
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMB-16-8
#27 thru #11	.1440 .1910	5/16	-20	DGMB-20-8
#10 thru 'F'	.1935 .2570	3/8	-24	DGMB-24-8
'A' thru 'L'	.2340 .2900	7/16	-28	DGMB-28-8
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMB-32-8
9/32 thru 25/64	.2812 .3906*	5/8	-40	DGMB-40-8

DGMG and DGMF Drill Guides

Pressure Foot Drilling With Travel

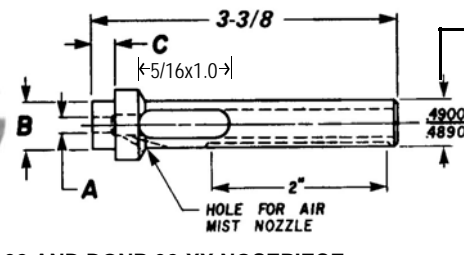
The UNITED Pressure Foot Drilling System

DGMG DRILL GUIDES



DGMG—FLANGE AIR MIST 2" TRAVEL

USE AMU-22-23-24 AIR MIST ASSEMBLY. USE PFA-32-32 AND DGNP-32-XX NOSEPIECE.



*When 'A' I.D. is over 5/16 Dia, Body Dia will be changed to .6130-.6120 Dia.

ORDERING EXAMPLE:

DGMG-12-1-#58
 I.D.
 Pilot Length in 16ths
 Pilot Diameter in 64ths
 Drill guide Style

DGMG Flange Air Mist Drill Guides have 2" travel and use eight inch extension drill.

They are used in PFA-32-32 Pressure Foot Adapters and make use of the AMU-22 Air Mist Unit.

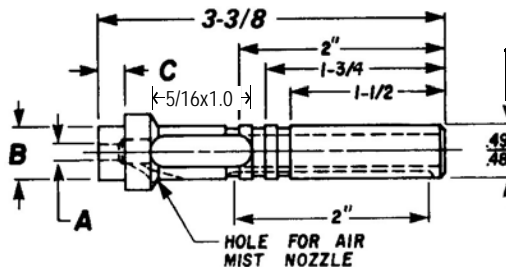
A		B		C PILOT LENGTH								
I.D. RANGE		PILOT DIAMETER		-1	-2	-3	-4	-5	-6	-7	-8	
NOMINAL	DECIMAL	NOMINAL	DASH	1/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	
#58 thru #40	.0420 .0980	3/16	-12	DGMG-12-1	DGMG-12-2	DGMG-12-3	DGMG-12-4	DGMG-12-5	DGMG-12-6	DGMG-12-7	DGMG-12-8	
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMG-16-1	DGMG-16-2	DGMG-16-3	DGMG-16-4	DGMG-16-5	DGMG-16-6	DGMG-16-7	DGMG-16-8	
#27 thru #11	.1440 .1910	5/16	-20	DGMG-20-1	DGMG-20-2	DGMG-20-3	DGMG-20-4	DGMG-20-5	DGMG-20-6	DGMG-20-7	DGMG-20-8	
#10 thru #1	.1935 .2280	3/8	-24	DGMG-24-1	DGMG-24-2	DGMG-24-3	DGMG-24-4	DGMG-24-5	DGMG-24-6	DGMG-24-7	DGMG-24-8	
'A' thru 'L'	.2340 .2900	7/16	-28	DGMG-28-1	DGMG-28-2	DGMG-28-3	DGMG-28-4	DGMG-28-5	DGMG-28-6	DGMG-28-7	DGMG-28-8	
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMG-32-1	DGMG-32-2	DGMG-32-3	DGMG-32-4	DGMG-32-5	DGMG-32-6	DGMG-32-7	DGMG-32-8	
9/32 thru 'O'	.2812 .3160	9/16	-36	DGMG-36-1	DGMG-36-2	DGMG-36-3	DGMG-36-4	DGMG-36-5	DGMG-36-6	DGMG-36-7	DGMG-36-8	
9/32 thru 25/64	.2812 .3906*	5/8	-40	DGMG-40-1	DGMG-40-2	DGMG-40-3	DGMG-40-4	DGMG-40-5	DGMG-40-6	DGMG-40-7	DGMG-40-8	

DGMF DRILL GUIDES



DGMF—FLANGE AIR MIST WITH DEPTH CONTROL GROOVES—2" TRAVEL

USE AMU-22-23-24 AIR MIST ASSEMBLY. FOR EXTENSION DRILLS USE WITH PFA-32-32 AND DGNP-32-XX NOSEPIECE.



*When 'A' I.D. is over 5/16 Dia, Body Dia will be changed to .6130-.6120 Dia.

ORDERING EXAMPLE:

DGMF-12-1-#58
 I.D.
 Pilot Length in 16ths
 Pilot Diameter in 64ths
 Drill guide Style

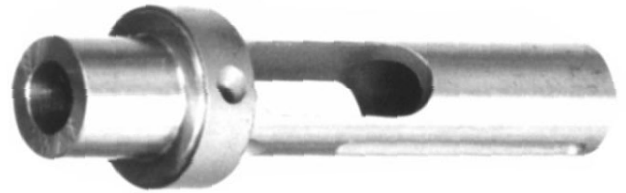
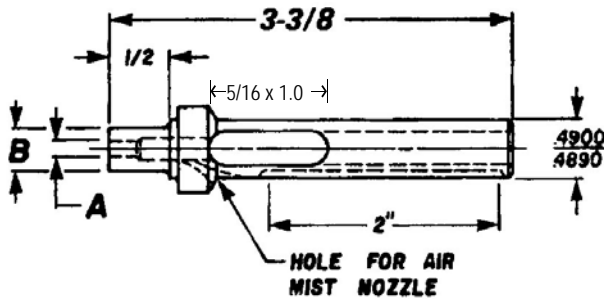
DGMF Flange Air Mist Drill Guides have all the features of the DGMG with the addition of the depth control grooves to give varying drill depths.

A		B		C PILOT LENGTH								
I.D. RANGE		PILOT DIAMETER		-1	-2	-3	-4	-5	-6	-7	-8	
NOMINAL	DECIMAL	NOMINAL	DASH	1/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	
#58 thru #40	.0420 .0980	3/16	-12	DGMF-12-1	DGMF-12-2	DGMF-12-3	DGMF-12-4	DGMF-12-5	DGMF-12-6	DGMF-12-7	DGMF-12-8	
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMF-16-1	DGMF-16-2	DGMF-16-3	DGMF-16-4	DGMF-16-5	DGMF-16-6	DGMF-16-7	DGMF-16-8	
#27 thru #11	.1440 .1910	5/16	-20	DGMF-20-1	DGMF-20-2	DGMF-20-3	DGMF-20-4	DGMF-20-5	DGMF-20-6	DGMF-20-7	DGMF-20-8	
#10 thru #1	.1935 .2280	3/8	-24	DGMF-24-1	DGMF-24-2	DGMF-24-3	DGMF-24-4	DGMF-24-5	DGMF-24-6	DGMF-24-7	DGMF-24-8	
'A' thru 'L'	.2340 .2900	7/16	-28	DGMF-28-1	DGMF-28-2	DGMF-28-3	DGMF-28-4	DGMF-28-5	DGMF-28-6	DGMF-28-7	DGMF-28-8	
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMF-32-1	DGMF-32-2	DGMF-32-3	DGMF-32-4	DGMF-32-5	DGMF-32-6	DGMF-32-7	DGMF-32-8	
9/32 thru 'O'	.2812 .3160	9/16	-36	DGMF-36-1	DGMF-36-2	DGMF-36-3	DGMF-36-4	DGMF-36-5	DGMF-36-6	DGMF-36-7	DGMF-36-8	
9/32 thru 25/64	.2812 .3906*	5/8	-40	DGMF-40-1	DGMF-40-2	DGMF-40-3	DGMF-40-4	DGMF-40-5	DGMF-40-6	DGMF-40-7	DGMF-40-8	

Increase Hole Production

The UNITED Pressure Foot Drilling System

DGMH and DGMD
Drill Guides



DGMH DRILL GUIDES

DGMH—FLANGE AIR MIST 2" TRAVEL FOR USE WITH 8" EXTENSION DRILLS

A		B		PART NO.
I.D. RANGE		PILOT DIAMETER		
NOMINAL	DECIMAL	NOMINAL	DASH	
#58 thru #40	.0420 .0980	3/16	-12	DGMH-12-8
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMH-16-8
#27 thru #11	.1440 .1910	5/16	-20	DGMH-20-8
#10 thru #1	.1935 .2280	3/8	-24	DGMH-24-8
'A' thru 'L'	.2340 .2900	7/16	-28	DGMH-28-8
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMH-32-8

USE AMU-22-23-24 AIR MIST ASSEMBLY.

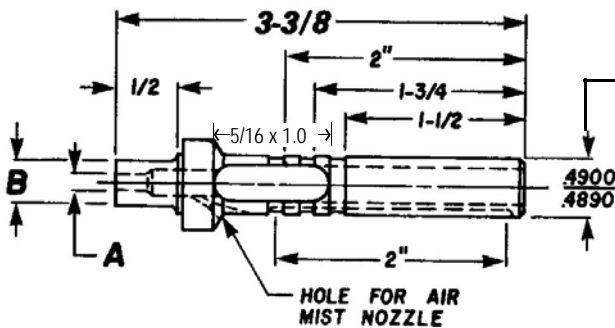
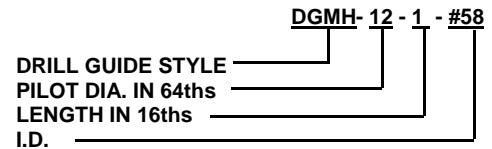
DGMH Drill Guides are used with 8" extension drills and have 2" of travel.

When used in conjunction with UNITED's Twisfit Bushing, the DGMH Drill Guide offers critical hole alignment. The 1/2" pilot hole length corresponds with the height of Twisfit Bushings for maximum bearing between the pilot O.D. and the Twisfit I.D. which assures accurate hole location and perpendicular drilling.

USE WITH
DGNP-32-XX
NOSEPIECE

ORDERING EXAMPLE:

USE DGMH WITH
PFA-32-32 PRESSURE



*When 'A' I.D. is over 5/16 Dia, Body Dia will be changed to .6130-.6120 Dia.



DGMD DRILL GUIDES

DGMD—FLANGE AIR MIST, 2" TRAVEL WITH DEPTH CONTROL USE WITH 8" EXTENSION DRILLS

A		B		PART NO.
I.D. RANGE		PILOT DIAMETER		
NOMINAL	DECIMAL	NOMINAL	DASH	
#58 thru #40	.0420 .0980	3/16	-12	DGMD-12-8
3/32 thru 9/64	.0937 .1406	1/4	-16	DGMD-16-8
#27 thru #11	.1440 .1910	5/16	-20	DGMD-20-8
#10 thru 'F'	.1935 .2570	3/8	-24	DGMD-24-8
'A' thru 'L'	.2340 .2900	7/16	-28	DGMD-28-8
9/32 thru 'O'	.2812 .3160	1/2	-32	DGMD-32-8
9/32 thru 25/64	.2812 .3906*	5/8	-40	DGMD-40-8

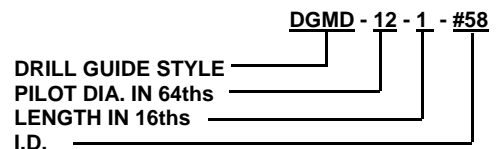
DGMD Drill Guides are used with 8" extension drills and have 2" of travel, with the addition of depth control grooves. Drilling depths are controlled to 1-1/2", 1-3/4" and 2".

When used in conjunction with UNITED's Twisfit Bushing, the DGMD Drill Guide offers critical hole alignment. The 1/2" pilot hole length corresponds with the height of Twisfit Bushings for maximum bearing. Maximum bearing between the pilot O.D. and the Twisfit I.D. assures accurate hole location and perpendicular drilling.

USE WITH DGNP-32-XX
NOSEPIECE

ORDERING EXAMPLE:

USE DGMD WITH PFA-32-32
PRESSURE FOOT ADAPTER



DGMK and DGML Drill Guides

Drill Deeper Larger Holes

The UNITED Pressure Foot Drilling System

DGMK DRILL GUIDES



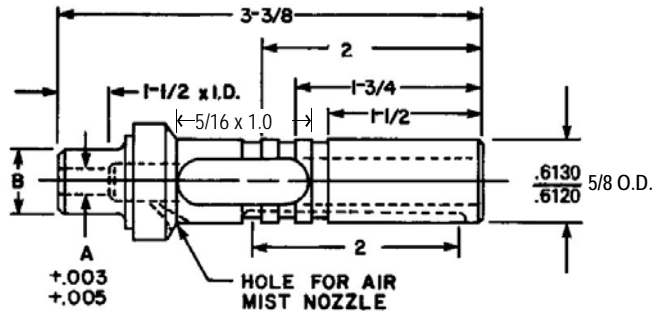
DGMK—FLANGE AIR MIST WITH DEPTH CONTROL
USE WITH 8" EXTENSION DRILLS—2" TRAVEL

USE AMU-22-23-24 AIR MIST ASSEMBLY.
USE PFA-40-32 AND DGNP-40-XX NOSEPIECE.

Flange Air Mist Drill Guides are used with 8" extension drills and have 2" of travel.

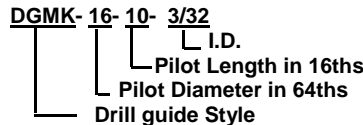
The 1/2" pilot hole length corresponds with the height of TWISFIT bushings for maximum bearing.

The DGMK will accept drills to 25/64 in diameter.



REFS:
SP-135D
SP-139F
SP-139K
SP-139L
SP-139N

ORDERING EXAMPLE:



I.D. RANGE	A		B		PART NO.
	NOMINAL	DECIMAL	NOMINAL	DASH	
3/32 thru 9/64	.0937	.1406	1/4	-16	DGMK-16-10
7/64 thru 11/64	.1094	.1719	9/32	-18	DGMK-18-10
#27 thru #11	.1440	.1910	5/16	-20	DGMK-20-10
#10 thru #1	.1935	.2280	3/8	-24	DGMK-24-10
'A' thru 'L'	.2340	.2900	7/16	-28	DGMK-28-10
9/32 thru 'O'	.2812	.3160	1/2	-32	DGMK-32-10
9/32 thru 3/8	.2812	.3750	9/16	-36	DGMK-36-10
9/32 thru 25/64	.2812	.3906	5/8	-40	DGMK-40-10

DGML DRILL GUIDES



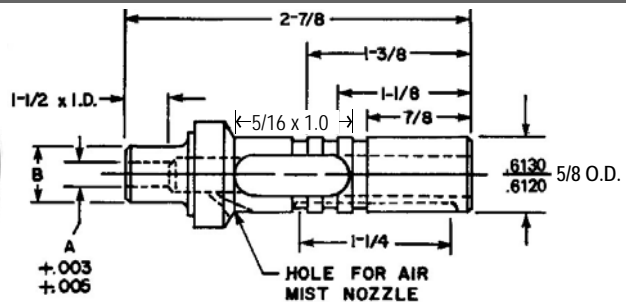
DGML—FLANGE AIR MIST WITH DEPTH CONTROL
USE WITH 6" EXTENSION DRILLS—1-1/4" TRAVEL

USE AMU-22-23-24 AIR MIST ASSEMBLY.
FOR EXTENSION DRILLS USE WITH PFA-40-20 AND DGNP-40-XX NOSEPIECE.

DGML Flange Air Mist Drill Guides are used with 6" extension drills and have 1-1/4 inch of travel.

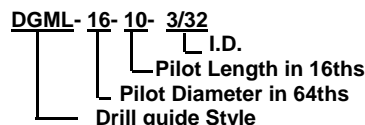
The pilot hole length corresponds with the height of the Twisfit Bushing for maximum bearing.

The DGML will accept drills to 25/64 in diameter.



REFS:
SP-135D
SP-139F
SP-139K
SP-139L
SP-139N

ORDERING EXAMPLE:



I.D. RANGE	A		B		PART NO.
	NOMINAL	DECIMAL	NOMINAL	DASH	
3/32 thru 9/64	.0937	.1406	1/4	-16	DGML-16-10
7/64 thru 11/64	.1094	.1719	9/32	-18	DGML-18-10
#27 thru #11	.1440	.1910	5/16	-20	DGML-20-10
#10 thru #1	.1935	.2280	3/8	-24	DGML-24-10
'A' thru 'L'	.2340	.2900	7/16	-28	DGML-28-10
9/32 thru 'O'	.2812	.3160	1/2	-32	DGML-32-10
9/32 thru 3/8	.2812	.3750	9/16	-36	DGML-36-10
9/32 thru 25/64	.2812	.3906	5/8	-40	DGML-40-10