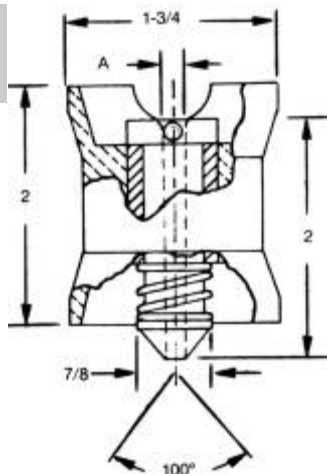


Drill Stands and Kits & Threaded Bushings

UNITED Drill Stands Spring Loaded & Threaded

SPRING LOADED DRILL STANDS



**NEW TRANSPARENT BLUE CODAR® MATERIAL
HIGH IMPACT STRENGTH
RESISTANT TO AIRCRAFT FUELS**

Spring Loaded Bushing in a Plastic Drill Stand can be used to transfer countersunk pilot holes into mating blank parts.

Manufactured from tough unbreakable plastic.

See page B10 for Drill Stands and Handle Bushing Kits.

UNITED PART NO.	A I. D. RANGE
DSP-40-32	#40 - 5/16

To order, specify Part Number and I. D.
Example: **DSP-40-32-1/4**



KITS with MATCHING BUSHINGS in a variety of sizes!

Align Drills and Reamers 90° to surface.

Transparent high impact strength plastic allows view of work and prevents skin damage.

Hardened bushings are interchangeable.



UDB-DSTAB-32-12-S DRILL STANDS and BUSHINGS SET

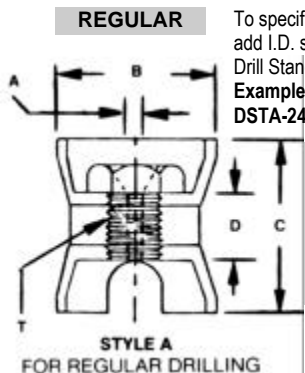
- Contents: 2 ea: DSTA-32-12 Drill Stands (Standard)
1 ea: DSTB-32-12 Drill Stand (Short)
1 ea: TB-32-12 Threaded Bushings (1/2-13)
I.D. Sizes: #40, 30, 5/32, 21, 20, 3/16, 10, 7/32, 1/4, F

UDB-DSTAB-48-16-S DRILL STANDS and BUSHINGS SET

- Contents: 2 ea: DSTA-48-16 Drill Stands (Standard)
1 ea: DSTB-48-16 Drill Stand (Short)
1 ea: TB-48-16 Threaded Bushings (3/4-16)
I.D. Sizes: 9/32, 5/16, 11/32, 3/8, 13/32, 7/16, 15/32, 1/2, 17/32, 9/16

THREADED DRILL STANDS FOR REPLACEABLE BUSHINGS

Specify BUSHINGS by adding I.D. size after Drill Stand Part No.



To specify bushings, add I.D. size after Drill Stand Part No.
Example: DSTA-24-12-1/4

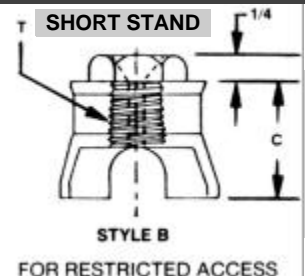
**STYLE A
DSTA
FOR
REGULAR
DRILLING**

THREADED DRILL STANDS							THREADED BUSHINGS	
STAND ONLY PART NO.	STYLE	T THREAD	A I.D. RANGE	B	C	D	BUSHING ONLY	ADD I.D.
DSTA-24-12	A	24 = 3/8-16	#80 - #40	1	1-5/8	1/2	TB-24-12	XXX
DSTA-32-12	A	32 = 1/2-13	#28 - 11/32	1-5/8	1-5/8	1/2	TB-32-12	XXX
DSTA-48-16	A	48 = 3/4-16	9/32 - 1/2	1-3/4	2	3/4	TB-48-12	XXX
DSTB-24-12	B	24 = 3/8-16	#80 - #40	1	1-1/4	1/2	TB-24-12	XXX
DSTB-32-12	B	32 = 1/2-13	#28 - 11/32	1-5/8	1-1/8	1/2	TB-32-12	XXX
DSTB-48-16	B	48 = 3/4-16	9/32 - 1/2	1-3/4	1-1/2	3/4	TB-48-12	XXX

FOR STANDS—WITH BUSHINGS—SIMPLY ADD I.D.

DSTA-24-12-#30 (For Style A Regular Stand)

DSTB-24-12-#30 (For Style B Short Stand) See Column A for I.D. sizes available.



**STYLE B
DSTB
RESTRICTED
ACCESS
DRILLING**

FOR BUSHINGS ONLY, 'TB' = THREADED BUSHINGS.

Available lengths under hex head are 1/2, 3/4 and 1".

Order example:
TB-O.D.-LENGTH-I.D.
TB-3/8-16 3/4 1/4
Or ANSI
TB-24-12-1/4
3/4 Lengths provided unless specified.

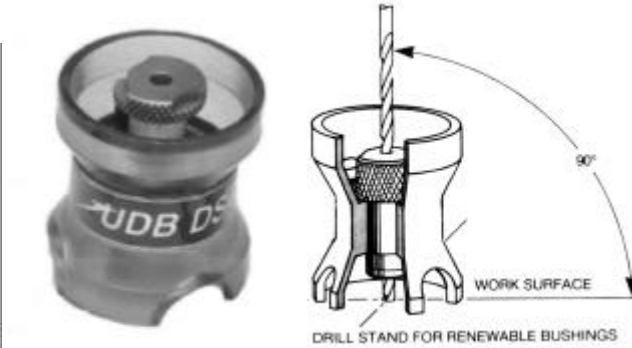
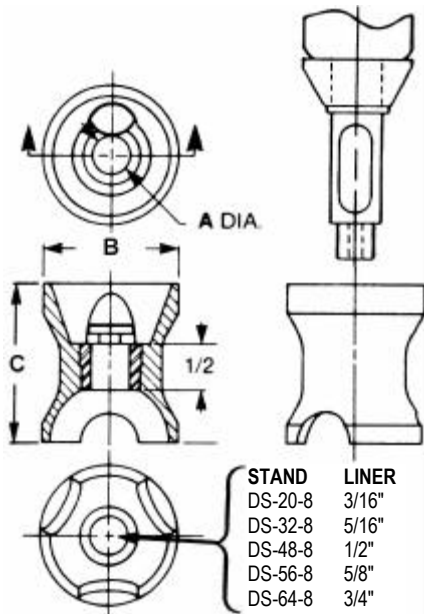


TB-24-12-I.D. 3/8 - 16 I.D. #80 - #40
TB-32-12-I.D. 1/2 - 13 I.D. #28 - 11/32
TB-48-16-I.D. 3/4 - 16 I.D. 9/32 - 1/2

Drill Stands Keep It Straight

UNITED's Portable Drill Stands keep your drills, reamers and taps 90° to your flat or curved working surface. Use the Drill Stand with UNITED's standard Slip Renewable or Slip Fixed Bushings. Manufactured from tough blue Codar® plastic with a precision hardened steel liner with locking lug for S or SF Bushings.

Drill Stands and Uni-Lock Bushings



**STANDARD
DRILL
STANDS**

STAND PART NO.	A LINER I.D.	B STAND O.D.	C STAND LENGTH	FOR USE WITH 'SF' BUSHING	UNI-LOCK LINER
DS-20-8	3/16	1"	1-5/8	SF-12-12- #80 - #40	UL-20-8 3/16
DS-32-8	5/16	1-5/8	1-5/8	SF-20-12- #80 - #10	UL-32-8 5/16
DS-48-8	1/2	1-3/4	2"	SF-32-12- #28 - 11/32	UL-48-8 1/2
DS-56-8	5/8	1-3/4	2"	SF-40-12- S - 7/16	UL-56-8 5/8
DS-64-8	3/4	1-3/4	2"	SF-48-12- 9/32 - 9/16	UL-64-8 3/4

DRILL STANDS WILL ACCOMMODATE BUSHINGS 1/2", 3/4" AND 1" LONG.
TOUGH - DURABLE - HIGH IMPACT PLASTIC - LASTS LONGER



SEE PAGE B10 DRILL STAND KITS.

UDB-DS-654325 DRILL STANDS-LINERS SET

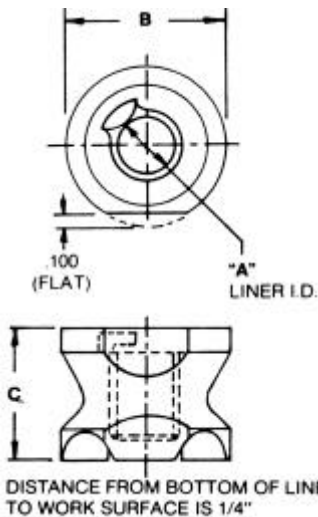
DS-64-8	DS-56-8	DS-48-8	DS-32-8	DS-20-8	
USE	USE	USE	USE	USE	
SF-48-12-I.D.	SF-40-12-I.D.	SF-32-12-I.D.	SF-20-12-I.D.	SF-12-12-I.D.	

GREAT FOR SITUATIONS WHERE YOU COME UP SHORT!

IDEAL FOR RESTRICTED AREAS. USE WITH SF BUSHINGS — SEE ABOVE.

Tough Durable blue PTMT with Alloy Steel Uni-Lock Liner.
Will accommodate bushings up to 1" long.

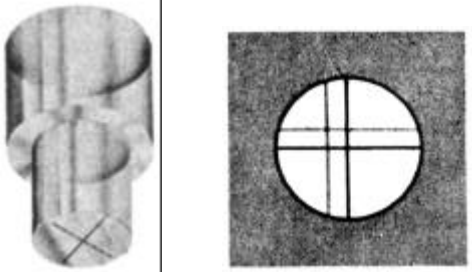
**SHORT
DRILL
STANDS**



STAND PART NO.	A LINER I.D.	B STAND O.D.	C STAND LEN	USE 'SF' BUSHING	DRILL SIZE RANGES
DSS-24-8	3/16	1	1-3/8	SF-12-12	#80 thru #40
DSS-32-8	5/16	1-5/8	1-3/8	SF-20-12	#80 thru #10
DSS-48-8	1/2	1-3/4	1-3/8	SF-32-12	28 thru 11/32
DSS-56-8	5/8	1-3/4	1-3/8	SF-40-12	S thru 7/16
DSS-64-8	3/4	1-3/4	1-7/8	SF-48-12	9/32 thru 9/16



Spotters and Adjustable Drill Bars



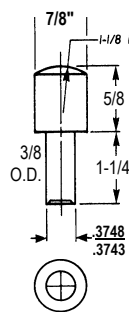
THE SPOTTER KNOWS!

When laying out drill fixtures, templates or dies, proceed in the normal fashion and scribe your location lines. To locate the holes accurately, use **UNITED's** "bombsite" locator the Spotter. This provides you with an accurate and magnified reference point.

Locate and Spot It

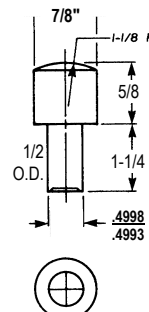
UNITED'S SPOTTER Bombsite Locator

SB-24-20



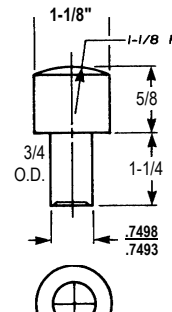
FITS DRILL BAR
DBL-40-12
NEW

SB-32-20



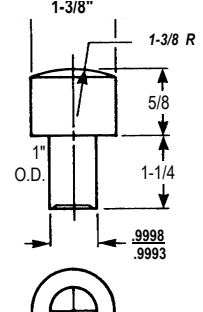
FITS DRILL BAR
DBL-48-12
Most Popular

SB-48-20



FITS DRILL BAR
DBL-64-12
Most Popular

SB-64-20



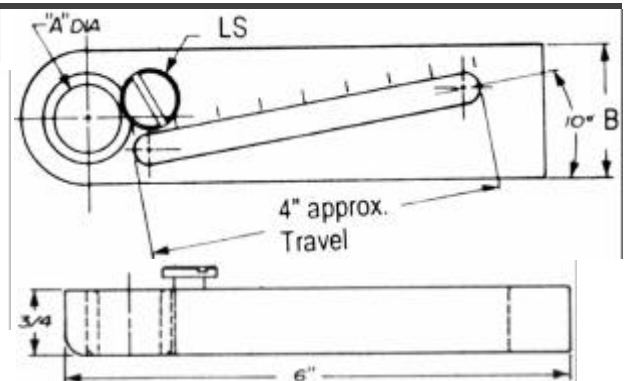
FITS DRILL BAR
DBL-88-12
NEW

Manufactured from tough, clear unbreakable plastic. Crosshairs are centrally located with ± 0.001 . See page C34.

ADJUSTABLE DRILL BARS



Provided with Lock Screw and Liner



UNITED PART NO.	I.D. LINER A +.0003	BAR WIDTH B	LOCKSCREW LS	USE WITH BUSHING #	I.D. RANGE	USE WITH SPOTTER #
DBL-40-12	3/8" .3751	1-1/4	TW-2	SF-24-12	#10 to #1	SB-24-20
DBL-48-12	1/2" .5002	1-1/2	LS-1	SF-32-12	#28 to 11/32	SB-32-20
DBL-64-12	3/4" .7503	1-1/2	LS-1	SF-48-12	9/32 to 9/16	SB-48-20
DBL-88-12	1" 1.0004	1-3/4	LS-2	SF-64-12	15/32 to 25/32	SB-64-20

UNITED's Adjustable Drill Bars provide accurate placement and alignment of drilled holes. We recommend use of our Spotter, enabling you to locate the Drill Bar centrally within ± 0.001 . Once centered, remove the Spotter and insert Drill Bushing. This provides an accurate and perpendicular hole.

IT'S AS SIMPLE AS 1 - 2 - 3!



1 Scribe your hole location. Loosely secure Drill Bar with a bolt in nearby drilled hole or drill and tap a 3/8 hole and secure with a 3/8 bolt.



2 Insert the Spotter. Locate the Drill Bar over scribed marks. Carefully align the cross hairs of the Spotter and scribed marks. Tighten the bolt.



3 Remove the Spotter. Insert Slip Fixed Bushing with required inside diameter. Drill or Ream.

Handy Adjustable Drill Bar Sets

Double End Adjustable Drill Bar Sets

UDB-DBS-1 TWO DRILL BARS and TWO SPOTTERS

UDB-DBS-1 ADJUSTABLE DRILL BAR SET includes Two Drill Bars and Two corresponding Spotters. The **Adjustable Drill Bars** have hardened steel liners to accommodate **1/2" and 3/4" Spotters**. In addition, appropriate Lock Screws are provided to secure **UNITED's** Slip Fit Renewable Bushings.

The **SET** includes the **Spotter SB-32-20**, the **Spotter SB-48-20**, the **Adjustable Drill Bar DBL-48-12** and the **Adjustable Drill Bar DBL-64-12** packaged with in an attractive compact **Molded Custom Case**.

UNITED OFFERS A LARGE VARIETY OF DRILL BARS AND BUSHING SETS. REFER TO PAGES A16 THRU A19 FOR OTHER STYLES.

UDB-DBS-1



UDB-DBS-2 ADJUSTABLE DRILL BAR and 12 BUSHINGS

UDB-DBS-2 ADJUSTABLE DRILL BAR SET includes a Drill Bar to accept the 1/2" Spotter and Bushings. With the Drill Bar is a Set of **Twelve Fixed Slip Renewable Bushings** in O.D. sizes: **5/32, #20, 3/16, #10, 7/32, 15/64, 1/4, F, 17/64, 9/32, 5/16 and 11/32**.

The **SET** includes the **Spotter SB-32-20** and the **Twelve SF-32-12 Bushings** packaged with the **Adjustable Drill Bar DBL-48-12** in a compact **Molded Custom Case**.

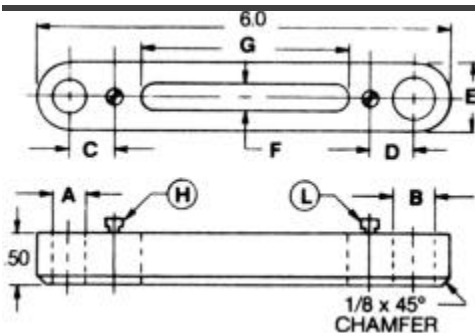


UDB-DBS-2

UDB-DBS-3 ADJUSTABLE DRILL BAR and 10 BUSHINGS

UDB-DBS-3 ADJUSTABLE DRILL BAR SET includes a Drill Bar to accept the 3/4" Spotter and Bushings. With the Drill Bar is a Set of **Ten Fixed Slip Renewable Bushings** in O.D. sizes: **9/32, 5/16, 11/32, 3/8, 13/32, 7/16, 15/32, 1/2, 17/32 and 9/16**.

The **SET** includes the **Spotter SB-48-20** and the **Ten SF-48-12 Bushings** packaged with the **Adjustable Drill Bar DBL-64-12** in a compact **Molded Custom Case**.



ADJUSTABLE DOUBLE END DRILL BARS

PROVIDE ACCURATE LOCATION and ALIGNMENT OF DRILLED HOLES



LOCK DRILL BAR DOWN WITH FASTENER IN "G" SLOT.

UNITED PART NO.	A +.0005 -.0000	B +.0005 -.0000	C	D	E	F	G Travel	Lockscrews included		Use with Bushings
								H	L	
DBL-16-20	.2501	.3126	.359	.500	3/4	3/8	3-1/8	TW-2	LS-1	SF-16-8/SF20-8
DBL-20-32	.3126	.5002	.500	.625	3/4	3/8	3-1/8	LS-1	LS-1	SF20-8/SF32-8
DBL-28-32	.4377	.5002	.453	.625	3/4	3/8	3-1/8	TW-2	LS-1	SF28-8/SF32-8
DBL-32-40	.5002	.6252	.625	.578	1	3/8	2-7/8	LS-1	TW-2	SF32-8/SF40-8
DBL-32-48	.5002	.7502	.625	.750	1-1/8	3/8	2-5/8	LS-1	LS-1	SF32-8/SF48-8
DBL-40-48	.6252	.7502	.578	.750	1-1/8	3/8	2-5/8	TW-2	LS-1	SF40-8/SF48-8