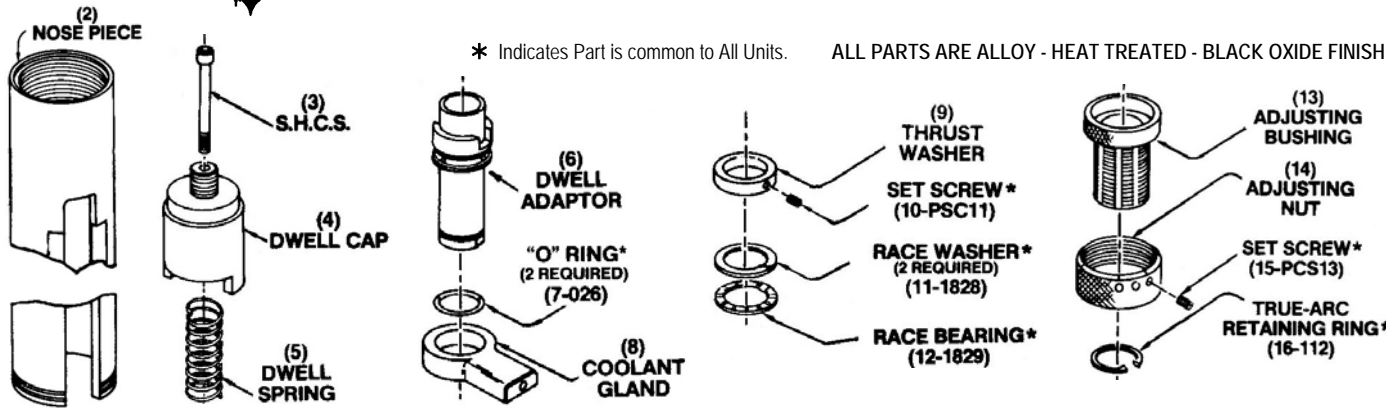


Depth Sensor Units Replacement Parts

Replacement Parts for

See Page Q20 for Parts Explosion View.

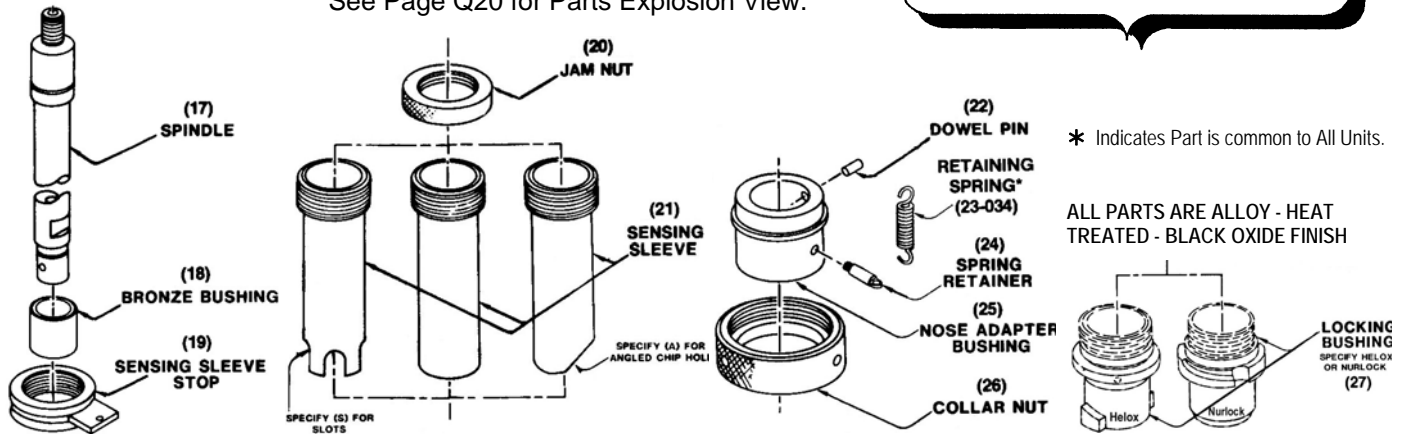


UNIT NO.	1 MOTOR ADAPTER (NOT SHOWN)	2 NOSE PIECE	3 CAP SCREW	4 DWELL CAP	5 DWELL SPRING	6 DWELL ADAPTER	8 COOLANT GLAND	9 THRUST WASHER	13 ADJUSTING BUSHING	14 ADJUSTING NUT
UDB-756161-5-24-1.250	—	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756161-9-24-1.3750	—	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756161-12-25-2.000	—	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756162-9-24-1.375	—	2-216	3-108	4-210	5-221	6-211	8-213	9-113	13-212	14-215
UDB-756162-14-25-2.000	—	2-216	3-108	4-210	5-221	6-211	8-213	9-113	13-212	14-215
UDB-756167-5-23-.875	—	2-225	3-109	4-214	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756167-5-23-1.125	—	2-225	3-109	4-214	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756167-5-24-1.000	—	2-225	3-109	4-214	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756167-5-24-1.250	—	2-225	3-109	4-214	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756167-8-24-1.375	—	2-225	3-109	4-214	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756171-5-24-1.250	—	2-16	3-109	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756171-8-24-1.375	—	2-16	3-109	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756171-9-24-1.375	—	2-16	3-109	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756171-9-25-2.000	—	2-16	3-109	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756171-12-25-2.000	—	2-16	3-109	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172-8-24-1.375	—	2-216	3-109	4-210	5-21	6-211	8-213	9-113	13-212	14-215
UDB-756172-9-24-1.375	—	2-216	3-109	4-210	5-21	6-211	8-213	9-113	13-212	14-215
UDB-756172-10-25-2.000	—	2-216	3-109	4-210	5-21	6-211	8-213	9-113	13-212	14-215
UDB-756172-14-25-2.000	—	2-216	3-109	4-210	5-21	6-211	8-213	9-113	13-212	14-215
UDB-756172A-3-22-.750	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-5-22-.750	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-3-23-.875	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-5-23-.875	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-5-23-1.125	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-8-24-1.250	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-8-24-1.375	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-8-25-2.000	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-10-25-2.000	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-8-26-2.375	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-10-26-2.375	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-14-26-2.375	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-6-24-1.250	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756172A-6-24-1.375	1-114	2-16	3-108	4-10	5-21	6-11	8-13	9-113	13-12	14-15
UDB-756173-10-25-2.000	—	2-145	3-109	4-103	5-31	6-107	8-111	9-113	13-115	14-117
UDB-756173-14-26-2.375	—	2-145	3-109	4-103	5-31	6-107	8-111	9-113	13-115	14-117
UDB-756173-18-26-2.375	—	2-145	3-109	4-103	5-31	6-107	8-111	9-113	13-115	14-117
UDB-756177-3-23-.875	—	2-225	3-441	4-214	5-449	6-215	8-221	9-325	13-217	14-219
UDB-756177-5-23-.875	—	2-225	3-441	4-214	5-449	6-215	8-221	9-325	13-217	14-219
UDB-756177-5-23-1.125	—	2-225	3-441	4-214	5-449	6-215	8-221	9-325	13-217	14-219
UDB-756177-5-24-1.000	—	2-225	3-441	4-214	5-449	6-215	8-221	9-325	13-217	14-219
UDB-756177-5-24-1.250	—	2-225	3-441	4-214	5-449	6-215	8-221	9-325	13-217	14-219
UDB-756177-5-24-1.375	—	2-225	3-441	4-214	5-449	6-215	8-221	9-325	13-217	14-219
UDB-756177-5-24-1.375A	—	2-225	3-441	4-214	5-449	6-215	8-221	9-325	13-217	14-219

Depth Sensor Units

Replacement Parts Depth Sensors

See Page Q20 for Parts Explosion View.



* Indicates Part is common to All Units.

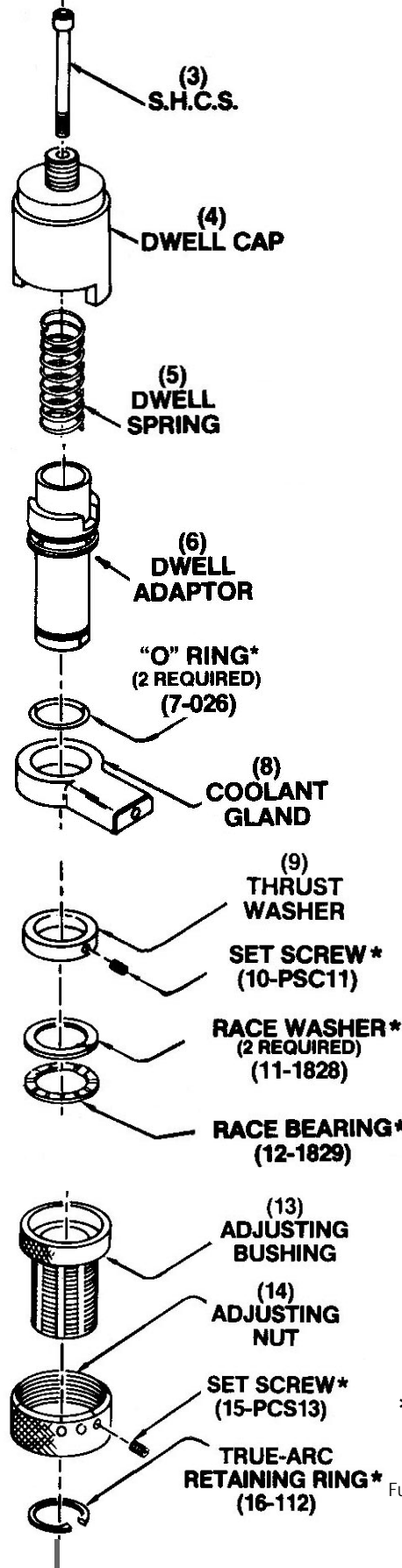
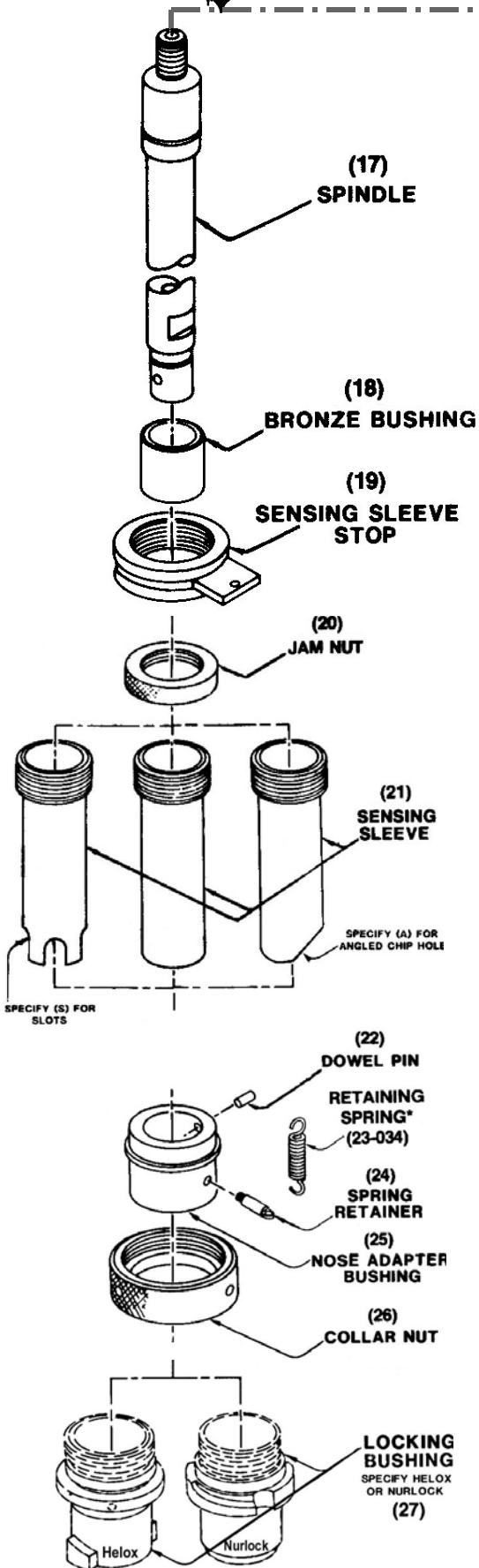
ALL PARTS ARE ALLOY - HEAT TREATED - BLACK OXIDE FINISH

17 SPINDLE	18 BRONZE BUSHING	19 SENSING SLEEVE STOP	20 JAM NUT	21 SENSING SLEEVE	22 DOWEL PIN	24 SPRING RETAINER	25 NOSE BUSHING ADAPTER	26 COLLAR NUT	27 LOCKING BUSHING	UNIT NO.
17-4B	18-74	19-419	20-421	21-74B	22-3/16 D.P.	24-6	25-53A	26-7	27-561	UDB-756161-5-24-1.250
17-4B	18-75	19-57JN	20-57	21-71T	22-3/16 D.P.	24-6	25-53A	26-7	27-56X	UDB-756161-9-24-1.3750
17-205B	18-75F	19-57AJN	20-57A	21-51B	22-3/16 D.P.	24-6	25-53A	26-7	27-606A	UDB-756161-12-25-2.000
17-204B	18-275	19-257JN	20-257	21-271T	22-3/16 D.P.	24-206	25-253A	26-207	27-256X	UDB-756162-9-24-1.375
17-205B	18-275F	19-257AJN	20-257A	21-251B	22-3/16 D.P.	24-206	25-253A	26-207	27-606A	UDB-756162-14-25-2.000
17-525B	18-526	19-419	20-421	21-429B	22-3/16 D.P.	24-6	25-445A	26-223	27-56C	UDB-756167-5-23-875
17-227B	18-528	19-419	20-421	21-426B	22-3/16 D.P.	24-6	25-445A	26-223	27-56D	UDB-756167-5-23-1.125
17-227B	18-73B	19-419	20-421	21-72B	22-3/16 D.P.	24-6	25-445A	26-223	27-56H	UDB-756167-5-24-1.000
17-227B	18-74B	19-419	20-421	21-74B	22-3/16 D.P.	24-6	25-445A	26-223	27-56I	UDB-756167-5-24-1.250
17-227B	18-443	19-419X	20-421X	21-425B	22-3/16 D.P.	24-6	25-445A	26-223	27-56E	UDB-756167-8-24-1.375
17-4B	18-74	19-419	20-421	21-74B	22-3/16 D.P.	24-6	25-53A	26-7	27-56I	UDB-756171-5-24-1.250
17-4B	18-75	19-57JN	20-57	21-71T	22-3/16 D.P.	24-6	25-53A	26-7	27-56X	UDB-756171-8-24-1.375
17-205B	18-75X	19-57JN	20-57	21-71T	22-3/16 D.P.	24-6	25-53A	26-7	27-56X	UDB-756171-9-24-1.375
17-205B	18-75F	19-57AJN	20-57A	21-51B	22-3/16 D.P.	24-6R	25-7	26-203X	27-203AB	UDB-756171-9-25-2.000
17-520B	18-525B	19-57AJN	20-57A	21-51B	22-3/16 D.P.	24-6R	25-7	26-203AX	27-203AB	UDB-756171-12-25-2.000
17-204B	18-275	19-257JN	20-257	21-271T	22-3/16 D.P.	24-206	25-253A	26-207	27-256X	UDB-756172-8-24-1.375
17-205B	18-275X	19-257JN	20-257	21-271T	22-3/16 D.P.	24-206	25-253A	26-207	27-256X	UDB-756172-9-24-1.375
17-205B	18-275F	19-257AJN	20-257A	21-251B	22-3/16 D.P.	24-206R	25-207	26-203AX	27-203AB	UDB-756172-10-25-2.000
17-520B	18-525B	19-257AJN	20-257A	21-251B	22-3/16 D.P.	24-206R	25-207	26-203AX	27-203AB	UDB-756172-14-25-2.000
17-525B	18-61	19-419	20-421	21-60B	22-3/16 D.P.	24-6	25-601	26-7	27-50J	UDB-756172A-3-22-750
17-227B	18-62	19-419	20-421	21-60B	22-3/16 D.P.	24-6	25-601	26-7	27-56J	UDB-756172A-5-22-750
17-525B	18-526	19-419	20-421	21-429B	22-3/16 D.P.	24-6	25-602	26-7	27-56C	UDB-756172A-3-23-875
17-227B	18-527	19-419	20-421	21-429B	22-3/16 D.P.	24-6	25-602	26-7	27-56C	UDB-756172A-5-23-875
17-227B	18-528	19-419	20-421	21-426B	22-3/16 D.P.	24-6	25-602	26-7	27-56D	UDB-756172A-5-23-1.125
17-4B	18-62	19-57JN	20-57	21-63B	22-3/16 D.P.	24-6	25-603	26-7	27-56N	UDB-756172A-8-24-1.250
17-4B	18-65	19-57JN	20-57	21-64B	22-3/16 D.P.	24-6	25-603	26-7	27-56L	UDB-756172A-8-24-1.375
17-4B	18-67	19-57AJN	20-57A	21-66B	22-3/16 D.P.	24-6		26-7	27-604	UDB-756172A-8-25-2.000
17-205B	18-67A	19-57AJN	20-57A	21-66B	22-3/16 D.P.	24-6		26-7	27-604	UDB-756172A-10-25-2.000
17-4B	18-65A	19-57AJN	20-57A	21-66B	22-3/16 D.P.	24-6		26-7	27-605	UDB-756172A-8-26-2.375
17-205B	18-67A	19-57AJN	20-57A	21-66B	22-3/16 D.P.	24-6		26-7	27-605	UDB-756172A-10-26-2.375
17-520B	18-69	19-57AJN	20-57A	21-66B	22-3/16 D.P.	24-6		26-7	27-605	UDB-756172A-14-26-2.375
17-4B	18-62	19-57JN	20-57	21-63B	22-3/16 D.P.	24-6	25-603	26-7	27-56N	UDB-756172A-6-24-1.250
17-4B	18-65	19-57A	20-57A	21-64B	22-3/16 D.P.	24-6	25-603	26-7	27-56L	UDB-756172A-6-24-1.375
17-123B	18-174	19-135	20-133	21-176B	22-1/4 D.P.	24-141	25-139	26-143	27-182	UDB-756173-10-25-2.000
17-123B	18-125B	19-135	20-133	21-131B	22-1/4 D.P.	24-141	25-139	26-143	27-159	UDB-756173-14-26-2.375
17-123B	18-190B	19-188	20-187	21-186B	22-1/4 D.P.	24-141	25-139	26-143	27-191A	UDB-756173-18-26-2.375
17-525B	18-526	19-419	20-421	21-429B	22-3/16 D.P.	24-405	25-445A	26-223	27-56	UDB-756177-3-23-875
17-227B	18-527	19-419	20-421	21-429B	22-3/16 D.P.	24-405	25-445B	26-223	27-56C	UDB-756177-5-23-875
17-527B	18-528	19-419	20-421	21-426B	22-3/16 D.P.	24-405	25-53A	26-223	27-56D	UDB-756177-5-23-1.125
17-227B	18-73	19-419	20-421	21-72B	22-3/16 D.P.	24-405	25-53A	26-223	27-56X	UDB-756177-5-24-1.000
17-227B	18-74	19-419	20-421	21-74B	22-3/16 D.P.	24-405	25-53A	26-223	27-56I	UDB-756177-5-24-1.250
17-227B	18-443	19-419X	20-421X	21-425B	22-3/16 D.P.	24-405	25-53A	26-223	27-56E	UDB-756177-5-24-1.375
17-227B	18-528	19-419X	20-421X	21-426B	22-3/16 D.P.	24-405	25-53A	26-223	27-56B	UDB-756177-5-24-1.375A

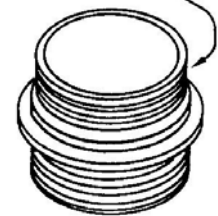
Depth Sensor Units Parts

Parts Explosion View

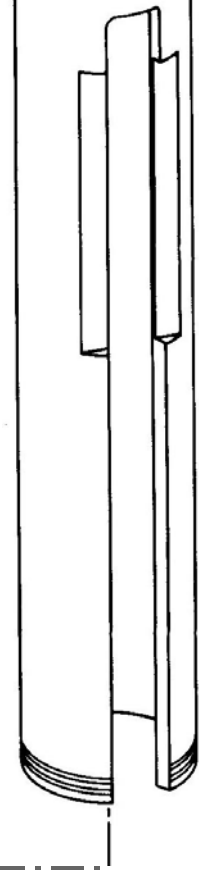
Parts Explosion View.



(1) MOTOR ADAPT.



NOSE PIECE (2)



* Indicates Part is common to All Units.

Full Scale Charts are available on request.

ALL PARTS ARE ALLOY - HEAT TREATED - BLACK OXIDE FINISH

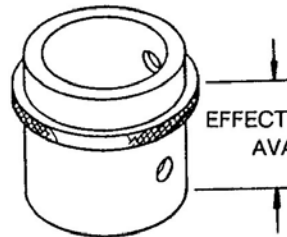
Optional Accessories for All QDA Drill Assemblies

Accessories for All QDA Drill Assy

See Page Q20 for Parts Explosion View.

PART NO.	SERIES	LENGTH	THREAD
UDB-756177-445	24000	1.25	1-1/2 - 12 LH
UDB-756177-445A	23000	1.25	1-1/4 - 12 LH
UDB-756171-53A	24000	1.56	1-1/2 - 12 LH
UDB-756171-53	24000	1.31	1-1/2 - 12 LH
UDB-756172-2003A	26000	2.31	2-1/4 - 16 LH
UDB-756172-203	25000	2.31	2 - 16 LH
UDB-756172-203 (FOR 1.875 SLEEVE)	25000	1.25	2 - 16 LH
UDB-756171-3	23000	2.84	1-1/4 - 12 LH
UDB-756171-73	24000	2.84	1-1/2 - 12 LH

Connects Sensor Housing to Adapter Tip and Sensing Sleeve.



EFFECTIVE LENGTH AVAILABLE

Additional lengths and locking series can be manufactured quickly to accommodate your special requirements.



These assemblies can be equipped with **UNITED's** Helox® Adapters that fit Shelox® Liners. Nurlock Adapters and Bushing Tips (or 'Kellers') are also adaptable to these units.

Angular Sensing Sleeve will contact irregular and contoured surfaces to control drill depth to within .0005 or even .0001. The Depth Sensing Assembly is self-compensating plus or minus 3/16 thru 1-1/4 Fastener sizes. Detailed information is available.

UNITED's Sensors are versatile. They can quickly be increased or decreased in standoff by changing the Adapter Nose Bushing.

ALLOY STEEL—HEAT TREATED—TOUGH—PRECISION GROUND—BLACK OXIDE FINISH

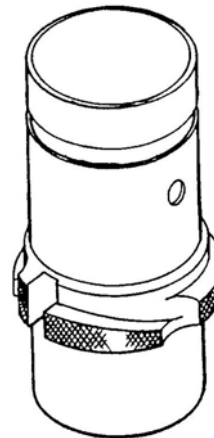
COMBINATION NOSE ADAPTER AND LOCKING BUSHINGS

UNITED's Super Sensors can also be adjusted in stroke by using the full range of the Adjusting Nuts. Please refer to UDB Set Up Charts.

ALLOY STEEL—HEAT TREATED—TOUGH—PRECISION GROUND—BLACK OXIDE FINISH

PART NO.	FITS MOTOR	LENGTH
UDB-756177-219	QDA-27	1.25
UDB-756171-15	QDA-11	1.80
UDB-756171-9573	QDA-11	3.00

Connects Sensor Housing to Sensing Sleeve



ADJUSTING NUT AND BUSHINGS

UNITED's Super Adjustable Nut changes an ordinary Air Tool into a Depth Gauge. Finer adjustment with fewer holes.

ALLOY STEEL—HEAT TREATED—TOUGH—PRECISION GROUND—BLACK OXIDE FINISH

Adjusts to within .0001

FITS MODEL NO.	STANDARD ADJUSTER ADJ. RANGE .0013 - .0050		FINE ADJUSTER ADJ. RANGE .0001 - .0007	
	BUSHING	NUT	BUSHING	NUT
QDA-11	UDB-756171-13-12	UDB-756171-14-15	UDB-756171-13-12N	UDB-756171-14-15N
QDA-12	UDB-756172-13-212	UDB-756172-14-215	UDB-756172-13-212N	UDB-756172-14-215N
QDA-13	UDB-756173-13-115	UDB-756173-14-117	UDB-756173-13-115N	UDB-756173-14-117N
QDA-27	UDB-756177-13-217	UDB-756177-14-219	UDB-756177-13-217N	UDB-756177-14-219N



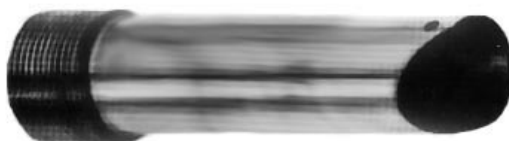
**Helox® Depth Sensor
Spacematic Motors**

Helox® Depth Sensor Assemblies

Fits OMARK-WINSLOW HS-2



LOCKING WING PLATE **LOCK RING**



**SENSING SLEEVE
UDB-755200**



NOSEPIECE **HELOX® TIP**
BUSHING BARREL PATENT NO. 3,762,827

★ Built-in Depth Sensor

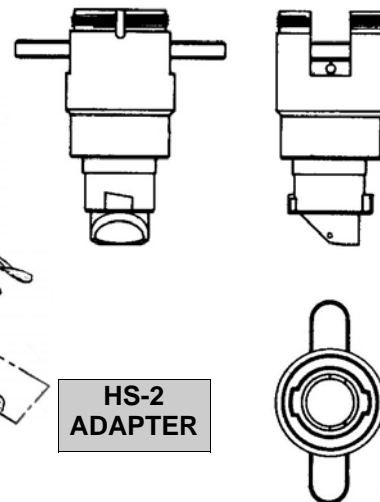
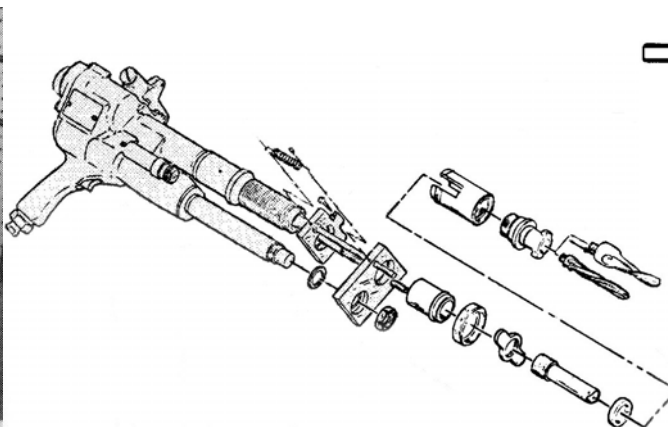
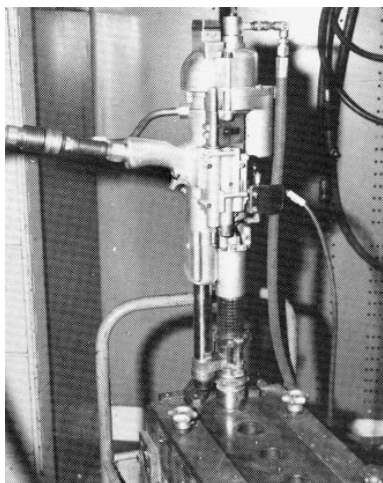
★ Helox® Adapter Nose fits

★ Drills for 3/16 Group 1 thru 3/8

POSITIVE LOCKING!

POSITIVE POSITIONING!

CONTROLLED FEED AND SPEED!



**HS-2
ADAPTER**

This accurate drilling assembly is ideal for tapered fastener hole preparation and depth sensing. This assembly is manufactured to adapt to **Omark-Winslow HS-2 automatic feed drills.** Its Helox® Nose is made in sizes to fit most of *UNITED's* Shelox® Liners. Nurlock adapter tips or 'Kellers' are available. Adapters are manufactured from the finest tool steels.

This adapter and the Omark-Winslow drilling unit were designed for drilling 3/16 diameter, Group 1 thru 3/8 diameter, Group 1 Taper Lock Fasteners. It will guide any Taper Cutter, Reamer or Drill made for the preparation of holes in this range.

Consult with *UNITED* or one of *UNITED's* authorized distributors for an adapter best suited for your needs. Detailed specifications are available.

For Spacematic Air Motors

**Helox® Depth Sensor
Spacematic Motors**

Fits OMARK-WINSLOW J-200

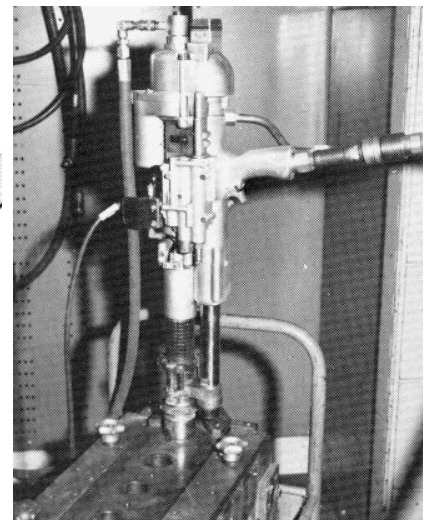
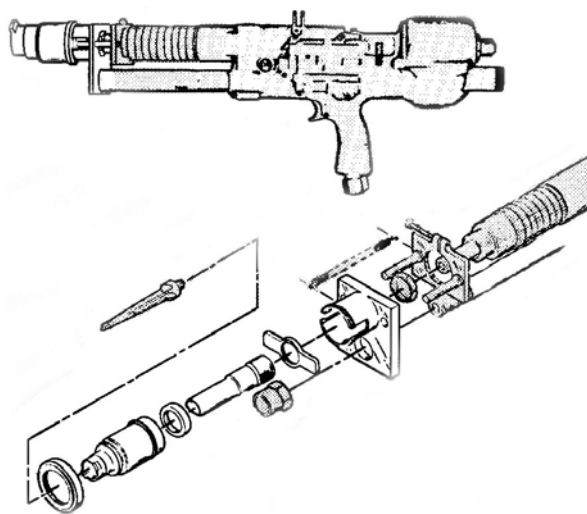
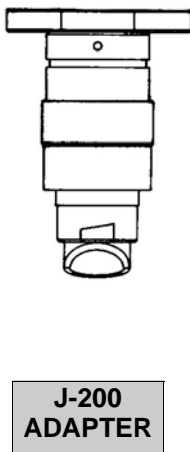
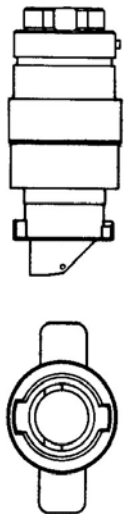


- ★ Drills for 3/16 Group 1 thru 3/8
- ★ Helox® Adapter Nose fits
- ★ Senses Depths accurately

POSITIVE LOCKING!

POSITIVE POSITIONING!

CONTROLLED FEED AND SPEED!



This precise drilling assembly for tapered fastener hole preparation and depth sensing has a larger capacity. Similar to the HS-2, this assembly is designed to fit the **Omark-Winslow J-200** automatic feed drills. Its Helox® Nose will adapt to corresponding **UNITED's** Shelox® Liners. Nurlock adapter tips or 'Kellers' are available. Adapters are manufactured from the finest tool steels.

This adapter and the Omark-Winslow drilling unit were designed for drilling larger capacity 3/8 diameter, Group 3 Taper Lock Fasteners for standard holes. It will guide any Taper Cutter, Reamer or Drill made for the preparation of holes in this range.

Consult with **UNITED** or one of **UNITED's** authorized distributors in your area for the adapter assembly to fill your needs. Detailed specifications are available.

Boeing Adapter Assemblies

Rockwell (Boeing) Adapter Assemblies

THE ROCKWELL ADAPTER (Now BOEING)

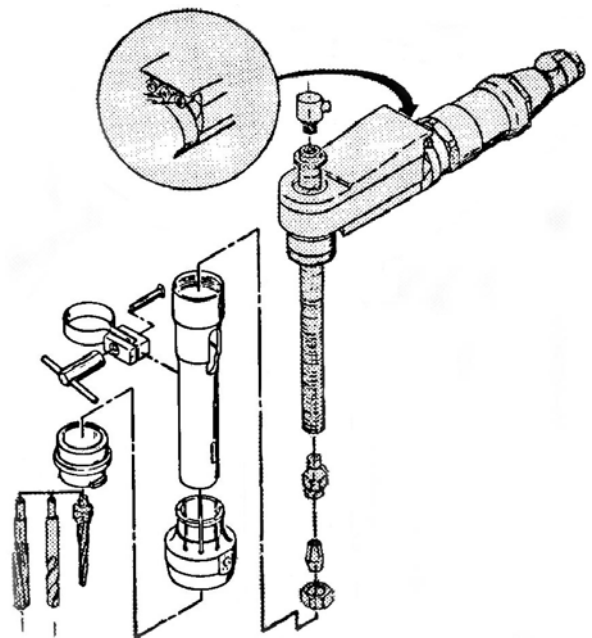
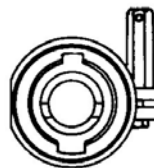
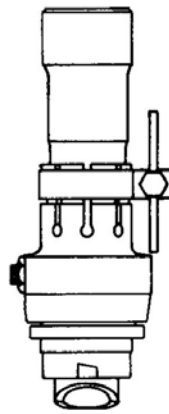
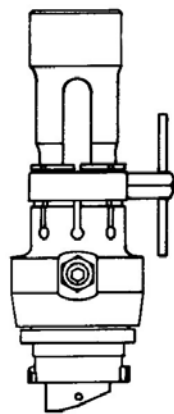
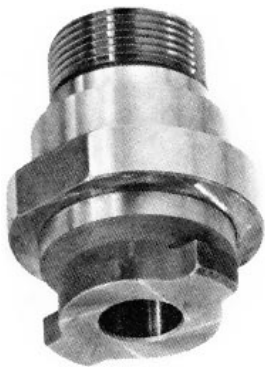


UDB-754820

PATENT NO. 3,762,827

- ★ Positive locking, positive positioning, controlled feed and speed.
- ★ Made to fit right into *UNITED's* Shelox Liners.
- ★ Adjusts to varying depths and surfaces.

NOSE PIECE



Call *UNITED*
FOR THE
BEST IN
DRILLING
ADAPTERS!

ROCKWELL
ADAPTER
UDB-754820

This accurate drilling Adapter is designed for the Rockwell #61PA Drill Motor and provides accurate location and depth control. This Nosepiece can be provided to fit any of *UNITED's* Shelox® Liners. The Nosepiece can be provided with conventional adapter tips to fit locking liners. They are manufactured from hardened and ground tool steel for a long and trouble-free life.

The combination of this Adapter and the Rockwell 61PA motor (160-265 rpm) will drill such tough jobs as the Taper Lock Fastener holes 7/16 Group 1 thru 5/8 Group 3. It can be used to guide taper cutters, reamers and standard drills.

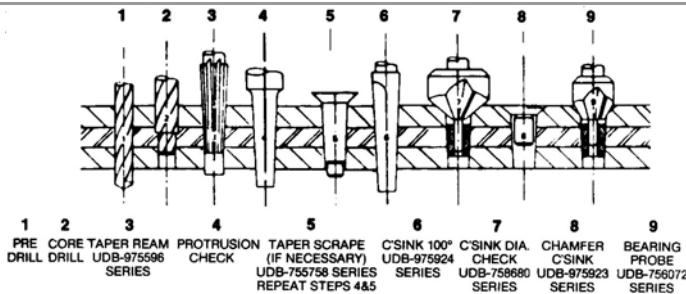
Call *UNITED* or one of *UNITED's* authorized distributors for the design best suited for your needs. You'll be glad you did!

UNITED Taper Lock Hole Preparation

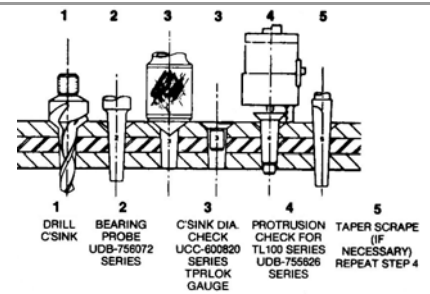
Flush and Protruding Holes

FLUSH FASTENER — ALUMINUM STRUCTURE

1. SEQUENCE FOR FREE HAND TOOLS

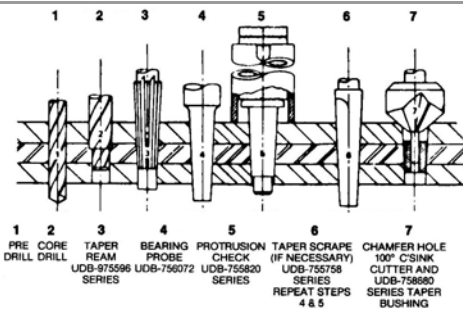


2. SEQUENCE FOR POSITIVE FEED EQUIPMENT

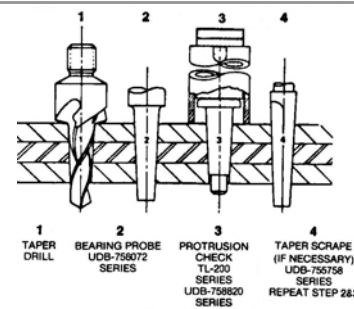


PROTRUDING FASTENER — ALUMINUM STRUCTURE

3. SEQUENCE FOR FREE HAND TOOLS



4. SEQUENCE FOR POSITIVE FEED EQUIPMENT



SEQUENCES FOR TAPER LOCK HOLE REWORK

Step 1. Predrill using UDB-758680 Series Taper Drill Bushing.	NOM. SIZE FASTENER	PREDRILL SIZE
	5/32	.0937 DIA.
	3/16	.1250 DIA.
	1/4, 5/16	.1875 DIA.
	3/8	.2500 DIA.
	7/16, 1/2	.3125 DIA.
	9/16, 5/8, 3/4	.3750 DIA.

Step 2. Pilot Core Drill to suit piloted Taper Pin Reamer.

Step 3. Ream using UDB-975596 Series with appropriate Pilot. Allow clean-up material for Step 4.

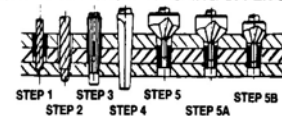
Step 4. Scrape the using UDB-755758 Series Single Flute Scraper. Remove minimum amount of material. Probe hole for bearing and check for proper protrusion.

Step 5. Protruding Head Fastener: Chamfer edge of hole using 100° Countersink Cutter and appropriate UDB-758680 Series Bushing to Pilot Cutter.

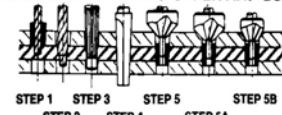
Step 5A. Flush Head Fastener: Countersink using 100° Cutter and suitable UDB-758680 Series Bushing to Pilot Cutter.

Step 5B. Chamfer juncture of countersink and tapered hole with 60° Cutter using same bushing as above for piloting. Check Countersink diameter.

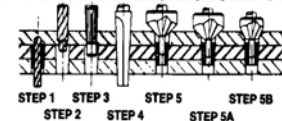
NEW LOWER STRUCTURE-EXISTING UPPER STRUCTURE



NEW CENTER STRUCTURE-EXISTING UPPER AND LOWER STRUCTURE



NEW UPPER STRUCTURE-EXISTING LOWER STRUCTURE



ADDITIONAL SEQUENCES — Charts available at your request.

- Flush Fastener — Aluminum structure — For two-step Drill-Ream using positive feed motors and drill bar using 6 Tools.
- Protruding Fastener Aluminum Structure — Sequence for tow step Drill-Ream using positive feed equipment and Drill Bar using 6 Tools.
- Flush Fastener — Aluminum/Titanium structure — Sequence for two-step Drill-Ream using positive feed motors and Drill Bar using 7 Tools.
- Protruding Fastener — Titanium or Aluminum/Titanium structure — Sequence for two-step Drill-Ream using positive feed motors and Drill Bar using 6 Tools.
- Flush Fastener — Aluminum structure — Rework to first and second oversize for Flush Head Fasteners using positive feed equipment and Drill Bar with 5 Tools.

- Flush Fastener — Aluminum or Titanium structure — Rework to first and second oversize for Flush Head Fasteners using positive feed equipment and Drill Bar with 5 Tools.
- Flush Fastener — Aluminum or Titanium structure — Rework to first and second oversize for Flush Head Fasteners using Free Hand Tools using 6 Tools.
- Protruding Fastener — Aluminum or Titanium structure — Rework to first and second oversize using Free Hand Tools using 4 Tools.
- Drill using UDB-758680 Series Taper Drill Bushing for either Flush or Protruding Fasteners using 5 or 6 Tools.
- Thru 23. Individual Data Sheets for cutter sequence for 5/32, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8 and 3/4 Flush and Protruding Fasteners.