

Drill Test Fixture

Drilling Kit Test Fixture

UNITED PROVIDES COMPLETE DRILLING TEST FIXTURES WITH COUPONS TO DRILL, REAM, BORE TEST PRIOR TO ACTUAL REPAIR.

A COMMERCIAL SETUP AND TEST FIXTURE

UTK-268002-25 KIT

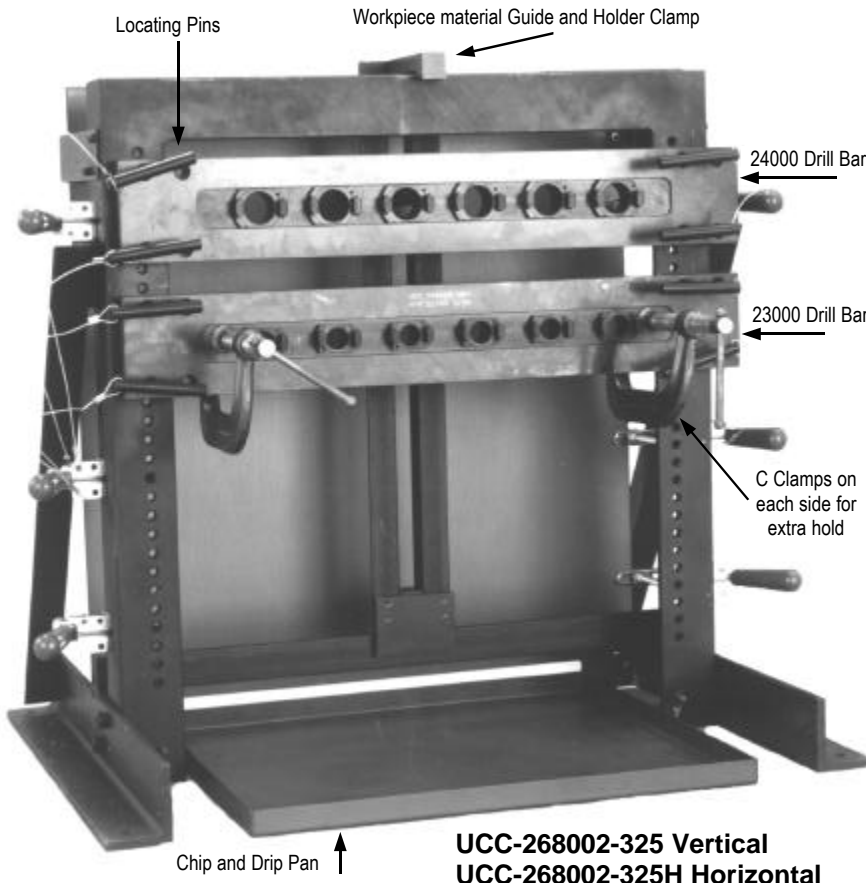
Complete Drilling Test Fixture with coupons to Drill, Ream, Bore, Countersink, Counterbore and Drill Preliminary Holes prior to the actual repair, modification or retrofit on the actual aircraft, assembly or work piece.

The Test Fixture includes two complete Drill Bars for alignment and clamping of Power Tools. It contains six Toggle Clamps to hold the Test Coupons and two C-Clamps to clamp the coupons firmly to the test bars. Added are Locators, the Chip and Coolant Collection Pan. This specific fixture has twenty Test Coupons to drill, ream, and countersink.

Rib-I Stacker Case



Rugged Rib-I Case UCC-268002-350 is 36" L x 36" W x 36" H. Fixture is 28" L x 28" W x 24" deep.



This fixture is provided with two complete Drill Bars of your choice containing Helical Nurlock Liner Bushings. UNITED Helical Nurlock Liners and Adapters Tips are available in all sizes in the 21000, 22000, 23000, 24000, 25000, 26000, 27000, 28000, 29000 and 30000 Series.

The Fixture will hold five drill bars. UNITED will provide on request 5 Bars 21000, 22000, 23000, 24000 and 25000 Series with slipfit sleeves to accommodate all Nurlock Adapter Tip Shank O.D. sizes.

The Fixture shown was mounted vertically and supplied with coupon sandwiches of steel aluminum, titanium and composite materials.

Call or Fax UNITED for further details.

Drilling Test Fixture is mounted vertically or horizontally. For horizontal, add 'H' to Part No.

Super Power Feed Kit

PIGGY BACK MOTOR, COOLANT NOSE PIECES
AND ACCESSORIES

UNITED Super
Power Feed Kit

UTK-268002-15 KIT

UNITED Coolant Nosepieces and Coolant Adapters provide the Piggyback Motor with the ability to Drill, Ream, Countersink and Counterbore. The Nurlock Coolant Adapter Series A11000, A12000, A13000, A14000 and A15000 will accommodate cutting tool diameters from 1/16" thru 1-3/16".

Case UCC 268002-145 is
24² L x 18² W x 16² H inside.



THE UNITED SUPER POWER FEED KIT UTK-268002-15



KIT CONTENTS

- | | | |
|--------------------------------------|---------------------------------------|--|
| 1. UCC-268002-132 Drill Motor | 6. UDB-849121 Chuck Key | 11. UDB-621238-NCS Nosepiece Assembly |
| 2. UDB-731302-1/4 1/2" Chuck Adapter | 7. UDB-615720 Stroke Stop | 12. UDB-612043-C Nosepiece Assembly |
| 3. UDB-619405 #2 Morse Taper Adapter | 8. UDB-621235-NCS Nosepiece Assembly | 13. UDB-619402-C Nosepiece Assembly |
| 4. UDB-619406 #3 Morse Taper Adapter | 9. UDB-621236-NCS Nosepiece Assembly | 14. UCC-268002-354 Male Air Fitting |
| 5. UDB-849415JC 1/2" Drill Chuck | 10. UDB-621237-NCS Nosepiece Assembly | 15. UCC-268002-145 Case Assembly with Foam |

**UNITED Spacematic
Kit with Depth Control**

United Spacematic Kit

UTK-268002-20 SPACEMATIC and UDB-755200 HS-2 SENSOR



Rib-I
Stacker
Case

**UNITED CASE UCC-268002-169 is
32" L x 22" W x 16" H inside
RUGGED RIB-I STACK STYLE CASE**

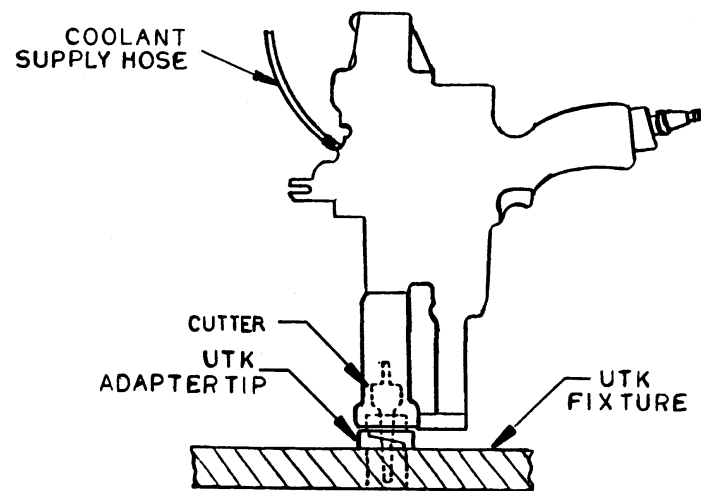


**UCC-268002-168 Spacematic
Motor with UDB-755200 HS-2
Depth Sensor**

UTK-268002-20 KIT

**With Spacematic Depth Control for Drilling
and Reaming, Taper Locks, Countersinking
and Counterboring**

Typical Set Up for Spacematic Drill Motor
with Spacematic Sensor and *UNITED'S*
Coolant Nurlock Adapter Tips and Depth
Sensor—Ideal for tapered holes and
countersinking. Lightweight and fast!



This proven HS-2E-280-2.0 Drill
Motor combined with *UNITED*
Drill Bars assures 90° holes to
surface relationships. Ideal for
close tolerance depth control
within .0005 for clean precise
holes. Excellent for Taper
Locks, Countersinks, Tapered
Fastener Holes and
Counterbores.

Included in the Kit are Spanner
Wrench and Male Air Fittings.

Call or Fax *UNITED* for further details.

Adjustable Drill Bars

WITH MULTIPLE TOOL DRILL GUIDES

Adjustable
Drill Bars Kit

UTK-268002-19-2 KIT

UNITED Drill Bars hold the Power Feed Air Tools securely. The Adjustable Drill Bar Guide Blocks hold and guide Nurlock Adapters from *UNITED*'s 21000 thru 24000 Series Helical Nurlock Liners and Nurlock Adapters.

Drill 90° to the work surface. You are assured perpendicularity and accurate locations.

Attractive aluminum hard blue anodized finish with alloy steel. Liners are black oxide heat treated.

UCC-268002-195

UCC-268002-196

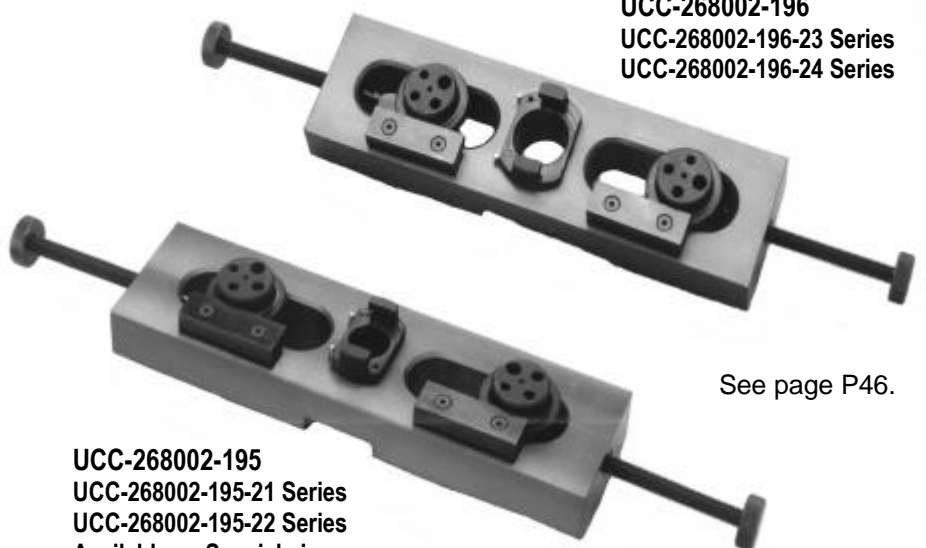


Case UCC-268002-197 is 15" L x 10" W x 8" H

UNITED's Adjustable Drill Bar Guide Blocks support Power Feed Pneumatic Tools.

UNITED's Drill Bar Guide Blocks assure 90° perpendicularity to the surface. Simultaneously the Fixture locates and secures positions for drilling five different small holes with Hand Held Portable Tools.

Specify Lock Liner Series required with each Bar.



UCC-268002-196
UCC-268002-196-23 Series
UCC-268002-196-24 Series

See page P46.

UCC-268002-195
UCC-268002-195-21 Series
UCC-268002-195-22 Series
Available as Specials in
25000 Series

Drill Bars 11" long x 3" wide x 1-1/4" high
with Chip Clearance between Liner and Workpiece

Call or Fax **UNITED** for further information.

**Positive Feed Motor
with Sensor Kit**

Power Feed Drill Motor

COMBINED WITH *UNITED* DEPTH SENSOR

UTK-268002-13 KIT

This Master Power Piggy Back Positive Feed Motor delivers the punch accurately when guided by *UNITED*'s Super Countersink, Tapered Hole or Counterbored Sensors Series UDB-756171 and UDB-756172.

Diameters and Depths are controlled within .0005.

Included with the Super Sensor and Motor are Jacobs Precision Chuck, Motor to Chuck Adapter, Chuck Key, Stroke Stop, Male Air Fitting, and Spanner Wrench for instant assembly.

This tool will drill 5/8² Taperlocks in addition to the 1² drills in steel, titanium and aluminum. The rugged *UNITED* precise Sensor will take all this Motor and Cutting Tools can dish out!



Rib-I
Stacker
Case

CASE UCC-268002-122 is 24" L x 18" W x 10" H inside



Motor

Adapter

Chuck

Key

KIT CONTENTS

UCC-268002-116	Drill Motor
UDB-756171-5-K23-1.25	Depth Sensor
UDB-731302-1/4	1/2 Chuck Adapter
UDB-849415JC	1/2 Drill Chuck
UDB-849121	Chuck Key
UDB-615720	Stroke Stop
UCC-268002-57F	Spanner Wrench
UCC-268002-354	Male Air Fitting
UCC-268002-122	Case Assy and Foam

The Piggy Back reduces overhang and develops 1.6 nominal horsepower. With its 4" stroke, it really cuts your material!



UNITED SUPER SENSOR
SERIES UDB-756171

This Drill Motor has the capacity to drill 1-1/4² in Aluminum and 1² in Titanium and Steel. *UNITED* Sensors UDB-756171 and UDB-756172 will also guide up to 7/8² Groups 1 and 2 Taperlocks. Call or Fax *UNITED* for further details.

Universal Swivel Fixture

PICKS UP AND ALIGNS HOLES 90 DEGREES TO SURFACE

**Single End Adjustable
Universal Swivel Kit**

UTK-268002-19-4 KIT

High Strength Swivels clamp in most locations. Adjustments can be made for alignment, location or clamping. Accuracy is assured when your power feed tools are held securely until precise holes are achieved. Rugged heat treated steel. Black oxide finish.

These rugged 23000 and 24000 Universal Nurlock Adapter Tip Fixtures swivel to control perpendicularity within 90° to your work surface.

Fixtures are 10" long closed and 11-1/2" open by 4" wide and 1-3/4" high. They will accept Swivel Liner Bushings from UNITED s 21000 to 24000 Series.



Rib-I
Stacker
Case

RIB-I STACK CASE UCC-268002-203 is 15" L x 10" W x 8" H inside.

Universal Single End Swivel Fixture locates and aligns holes 90° to surface.



**UCC-268002-202-24
24000 SERIES
UCC-268002-202-23
23000 SERIES
LOCK LINERS**

10" TO 11-1/2" LONG x 4" WIDE x 1-3/4" HIGH



**UCC-268002-201-21
21000 SERIES
UCC-268002-201-22
22000 SERIES
LOCK LINERS**

Call or Fax UNITED for further details.

1-1/2 ADJUSTMENT

SEE PAGE P43.

**UNIVERSAL ADJUSTABLE SWIVEL FIXTURE
PICK UP LOCATION — ADJUST — ALIGN — CONTROL PERPENDICULARITY — DRILL CONFIDENTLY**