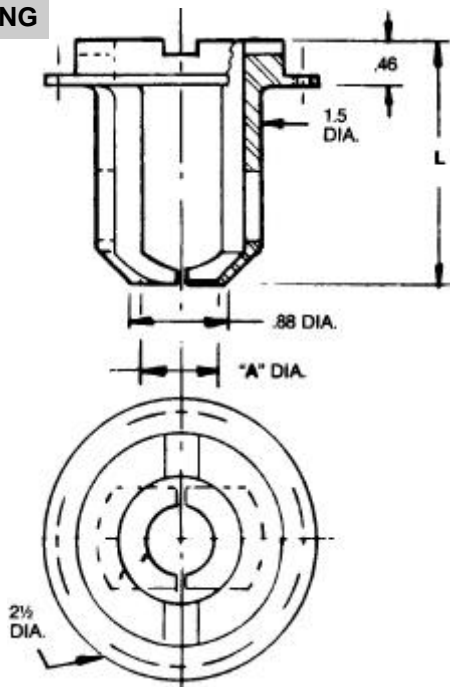


**Accessories for  
Automatic Drill Riveters**

# Upper Pressure Foot Bushings & Drill Spindle Adapter Extensions

**PRESSURE FOOT BUSHINGS**

**UPPER PRESSURE FOOT BUSHING**



Factory modified variations are possible to suit customer part.

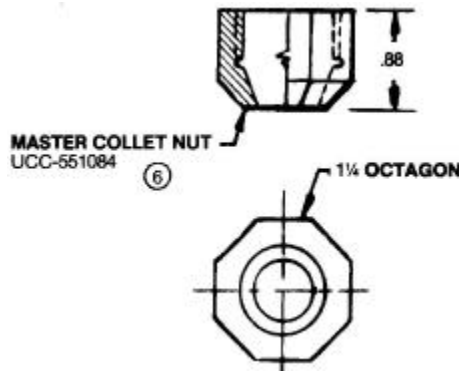
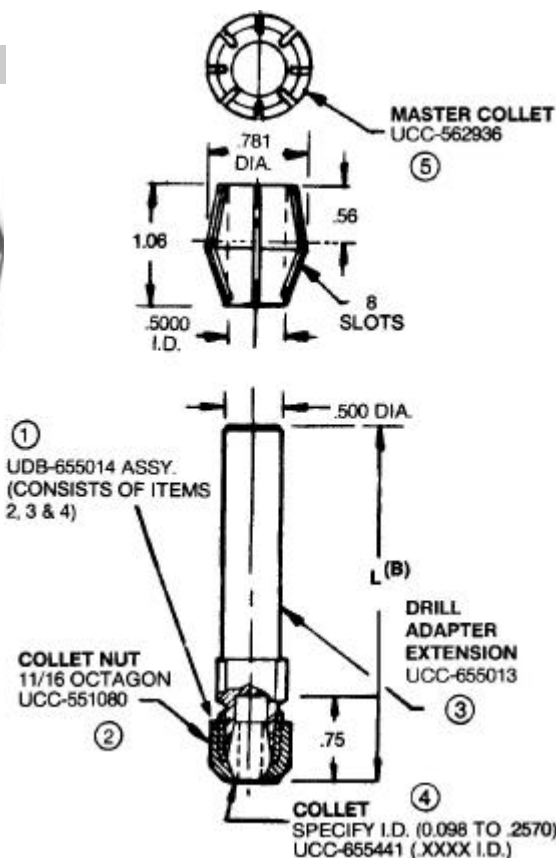
Submit part dimensional data for corresponding UCC part number.

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



**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**

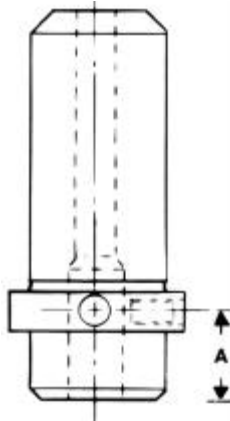


# Anvil Assemblies

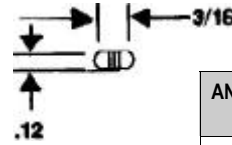
# Upper Anvil Assembly Parts

## UPPER ANVIL ASSEMBLIES

### ANVIL ADAPTER

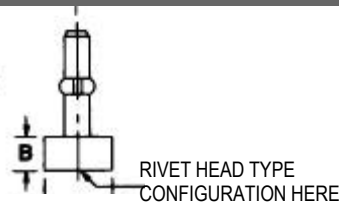


| ANVIL ADAPTER PART NO. | A     |
|------------------------|-------|
| UCC-AD-391-01          | .563  |
| UCC-AD-392-01          | 1.063 |

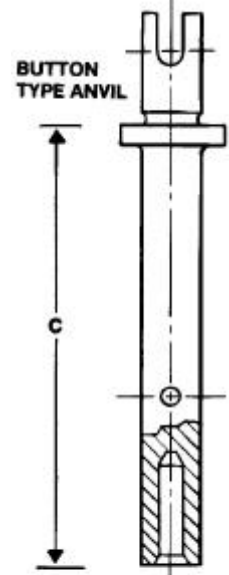


| ANVIL LOCKSPRING PART NO. |
|---------------------------|
| UCC-LS-390-01             |

### ANVIL BUTTON

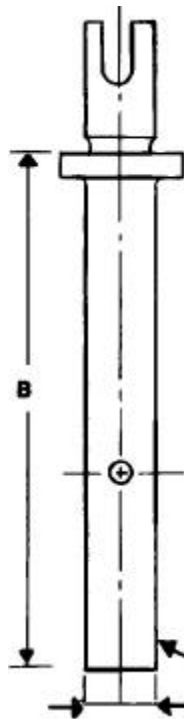


| ANVIL BUTTON PART NO. | NOM. RIVET SIZE | RIVET HEAD TYPE | A    | B    |
|-----------------------|-----------------|-----------------|------|------|
| UCC-B-390-5F          | 1/8, 5/32       | FLUSH           | .280 | .250 |
| UCC-B-390-6F          | 3/16            | FLUSH           | .360 | .260 |
| 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 |



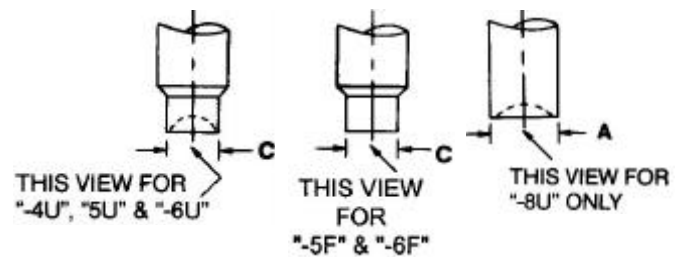
| BUTTON TYPE ANVIL PART NO. | C     |
|----------------------------|-------|
| UCC-A-391-01               | 2.937 |
| UCC-A-392-01               | 3.437 |

## FLUSH AND UNIVERSAL TYPE ANVILS



THIS VIEW FOR 8F ONLY

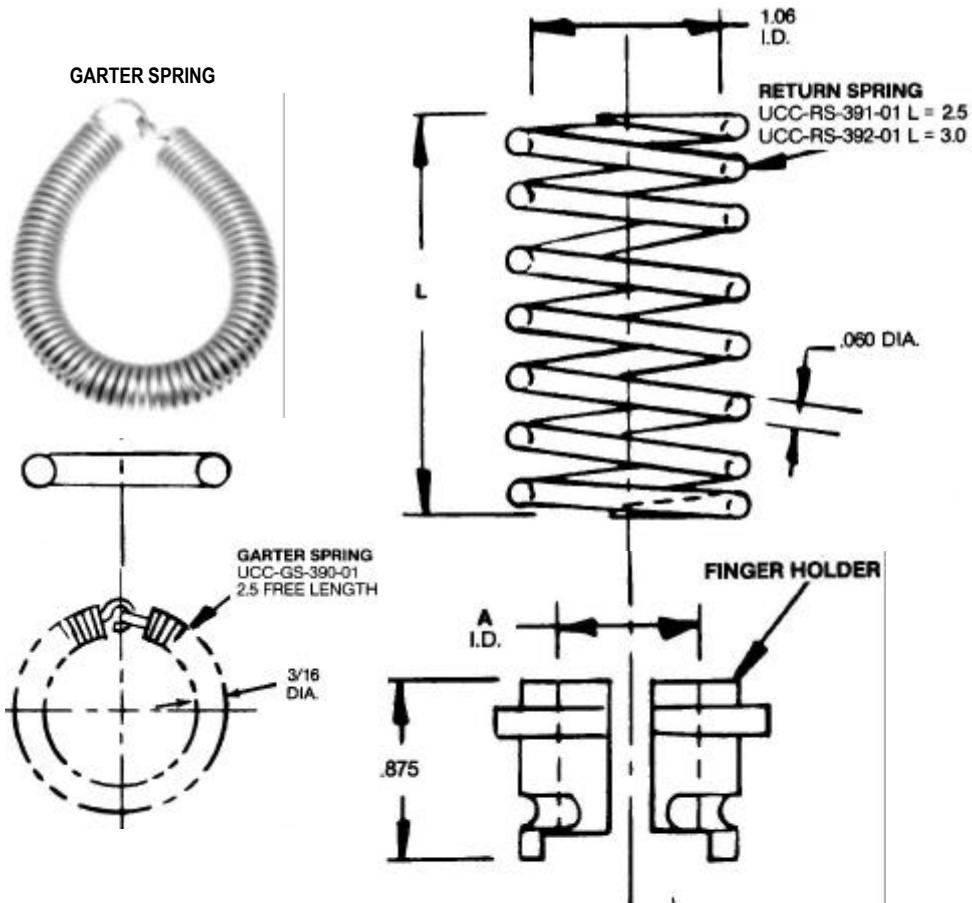
| FLUSH & UNIV. ANVIL PART NO. | NOM. RIVET SIZE | RIVET HEAD TYPE | A    | B     | C    |
|------------------------------|-----------------|-----------------|------|-------|------|
| UCC-A-391-25F                | 1/8, 5/32       | FLUSH           | .474 | 3.187 | .280 |
| UCC-A-391-26F                | 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 |



# Drill/Riveter Tooling and Accessories for Automatic Drill Riveters

## Finger Holding Assembly

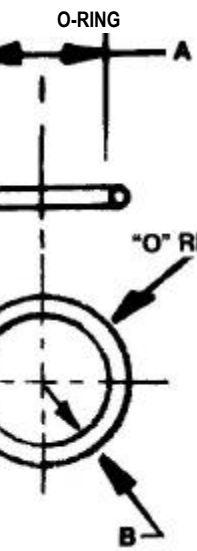
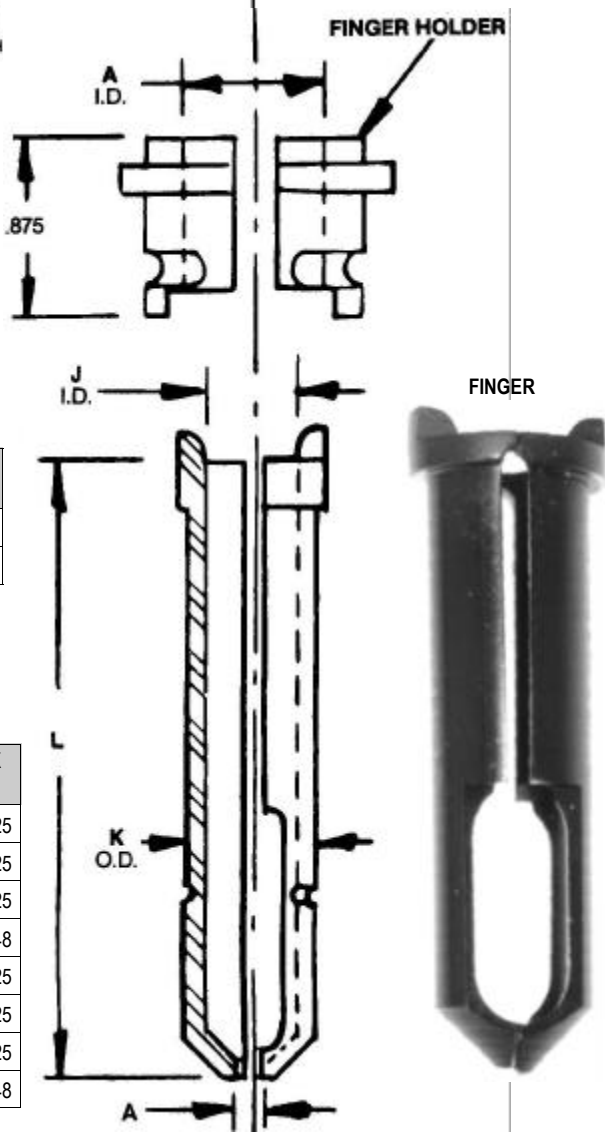
### PART RELATIONSHIP DRAWING



RETURN SPRING

**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 |



**'O' RING**

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

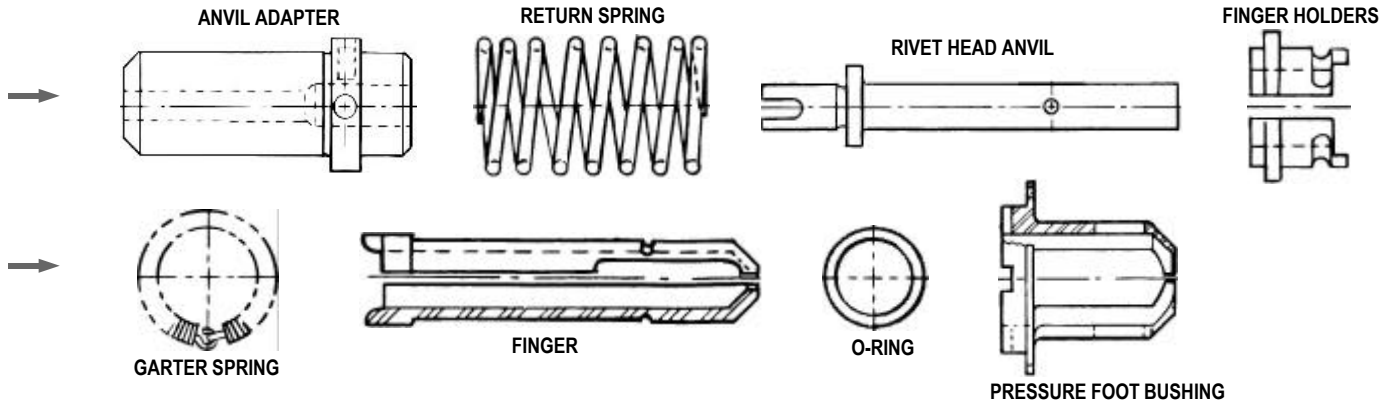
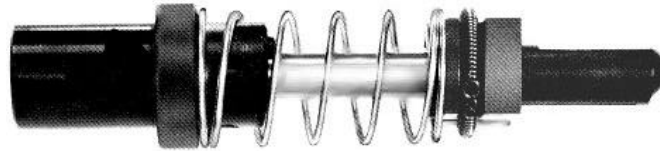
**FINGERS**

| 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 |

# Upper Anvil Assemblies

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

One-Piece Anvil  
UPPER ANVIL ASSEMBLIES



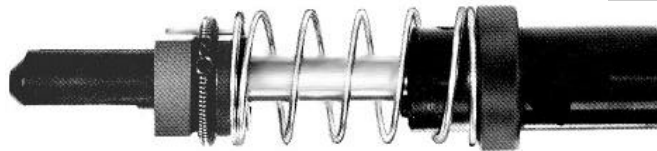
| FOR SHORT TOOLING (4.250 DIMENSION) |                 |                 |                                 |                                |                |               |                                 |              |               |                       |
|-------------------------------------|-----------------|-----------------|---------------------------------|--------------------------------|----------------|---------------|---------------------------------|--------------|---------------|-----------------------|
| 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<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-24AF | UCC-FH-392-01 | UCC-GS-390-01<br>* (302-A-2009) | UCC-F-392-04 | UCC-OR-390-01 | UCC-PB-392-01         |
|                                     | UNIVERSAL       | UCC-AU-392-24AU | UCC-AD-392-01<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-24AU | UCC-FH-392-01 | UCC-GS-390-01<br>* (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<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-25AF | UCC-FH-392-01 | UCC-GS-390-01<br>* (302-A-2009) | UCC-F-392-05 | UCC-OR-390-01 | UCC-PB-392-01         |
|                                     | UNIVERSAL       | UCC-AU-392-25AU | UCC-AD-392-01<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-25AU | UCC-FH-392-01 | UCC-GS-390-01<br>* (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<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-26AF | UCC-FH-392-01 | UCC-GS-390-01<br>* (302-A-2009) | UCC-F-392-06 | UCC-OR-390-01 | UCC-PB-392-02         |
|                                     | UNIVERSAL       | UCC-AU-392-26AU | UCC-AD-392-01<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-26AU | UCC-FH-392-01 | UCC-GS-390-01<br>* (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<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-28AF | UCC-FH-392-01 | UCC-GS-390-01<br>* (302-A-2009) | UCC-F-392-08 | UCC-OR-390-01 | UCC-PB-392-02         |
|                                     | UNIVERSAL       | UCC-AU-392-28AU | UCC-AD-392-01<br>* (302-C-1006) | UCC-RS-392-01<br>* (206-P-80A) | UCC-A-392-28AU | UCC-FH-392-01 | UCC-GS-390-01<br>* (302-A-2009) | UCC-F-392-08 | UCC-OR-390-01 | UCC-PB-392-02         |

\* GEMCOR NUMBERS

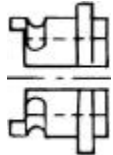
# Standard Upper Anvil Assy for G39A Machines with Button Type Anvils



Button Type  
UPPER ANVIL ASSEMBLIES



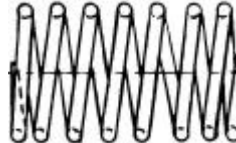
FINGER HOLDERS



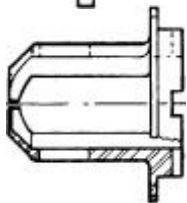
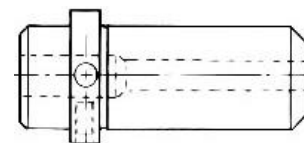
RIVET HEAD ANVIL



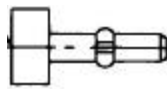
RETURN SPRING



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