

# Automatic Drill Riveter Tools

**Drill Riveting**



**MASTER COLLETS**  
Pg U6



**FINGER HOLDERS**  
Pg U9



**UPPER PRESSURE FOOT BUSHINGS**  
Pg U6



**FLUSH & UNIVERSAL TYPE ANVILS**  
Pg U8



**LOWER STAKE ASSEMBLIES**  
Pg U12



**ANVIL ADAPTER**  
Pg U8



**FINGERS** Pg U9



**UPPER ANVIL ASSEMBLIES**  
Pg U3



**ANVIL BUTTONS**  
Pg U14



**RETURN SPRINGS**  
Pg U9



**GARTER SPRINGS**  
Pg U9



**UPPER ANVIL ASSEMBLIES**  
Pg U7



**UDB-85 PIN POSITION GAUGES** Pg U38



**UDB-85-10 PIN POSITION GAUGES**  
Pg U39



**UDB-34D PIN POSITION GAUGES** Pg U36



**BUCKING BARS**  
Pg U24 - U26



**CLAMP SLEEVES**  
Pg U5



**UPPER ANVIL ADAPTER**  
Pg U3



**GUIDE PROTECTORS**  
Pg U14



**PLATE NUT DRILL JIGS**  
Pg U27 - U35

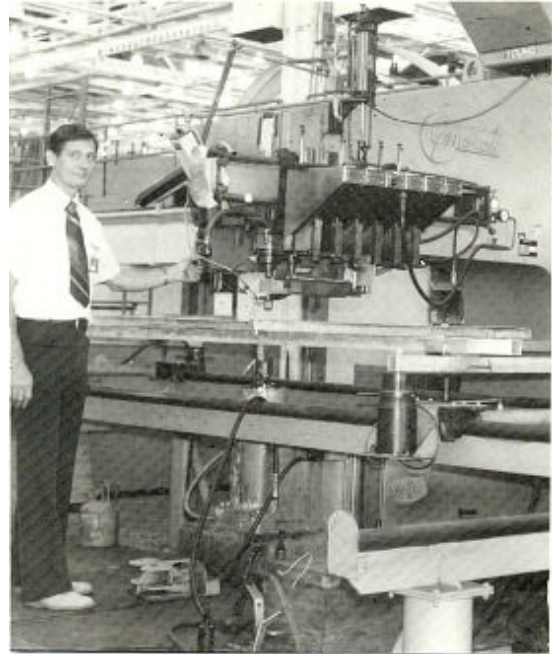
## Anvil Assemblies

# Drill / Riveter Tooling Technology

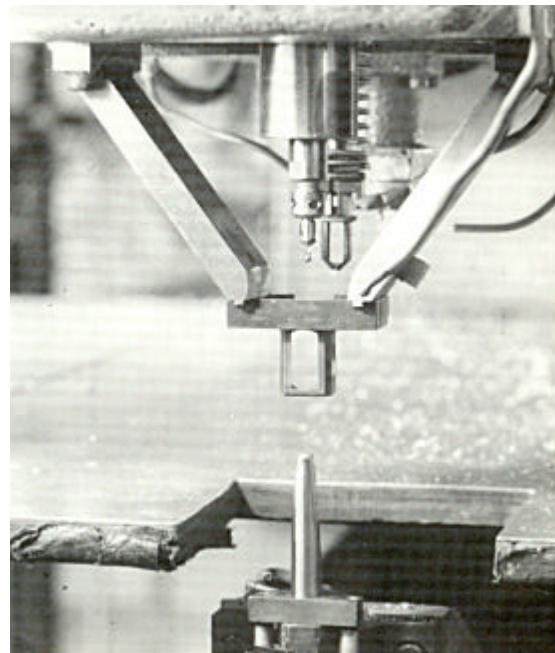
### UPPER ANVIL ASSEMBLY



*UNITED* has worked closely with Mr. Roy Toomay in the development of our Automatic Drill/Riveter Tooling. He is shown with a G39A machine.



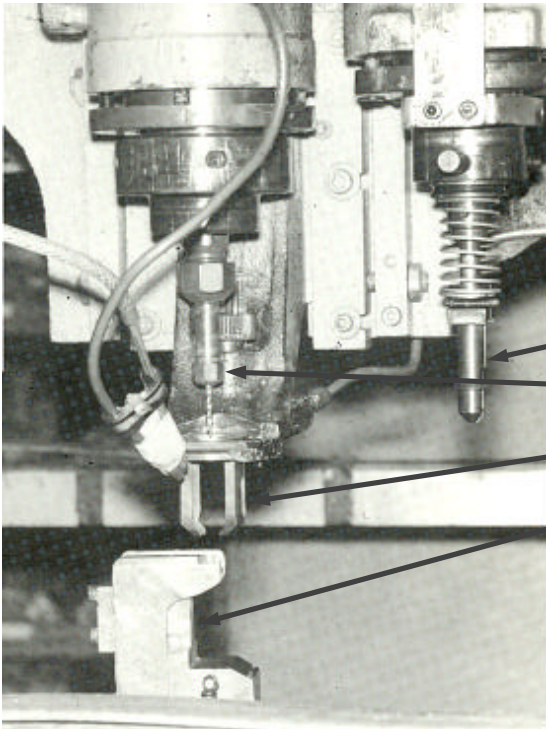
### LOWER STAKE TYPE ANVIL



# Anvil Technologies

## Anvil Assemblies

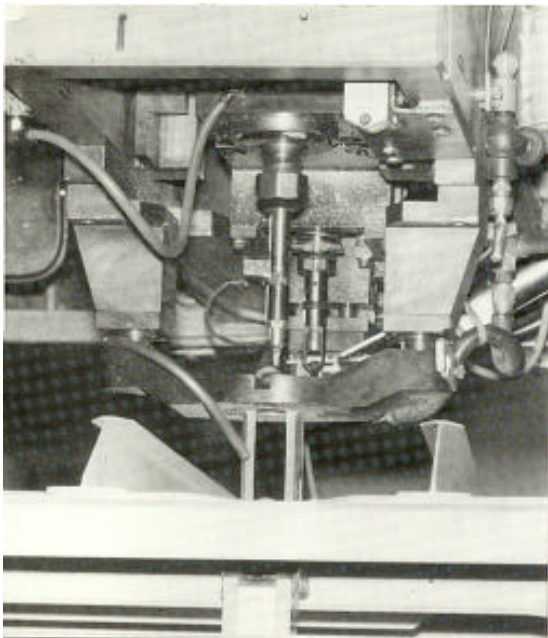
### PRESSURE FOOT BUSHING



- Shown on left:
- Upper Anvil Assembly
- Drill Spindle Assembly
- Pressure Foot Bushing
- Lower Anvil Assembly (Offset C)

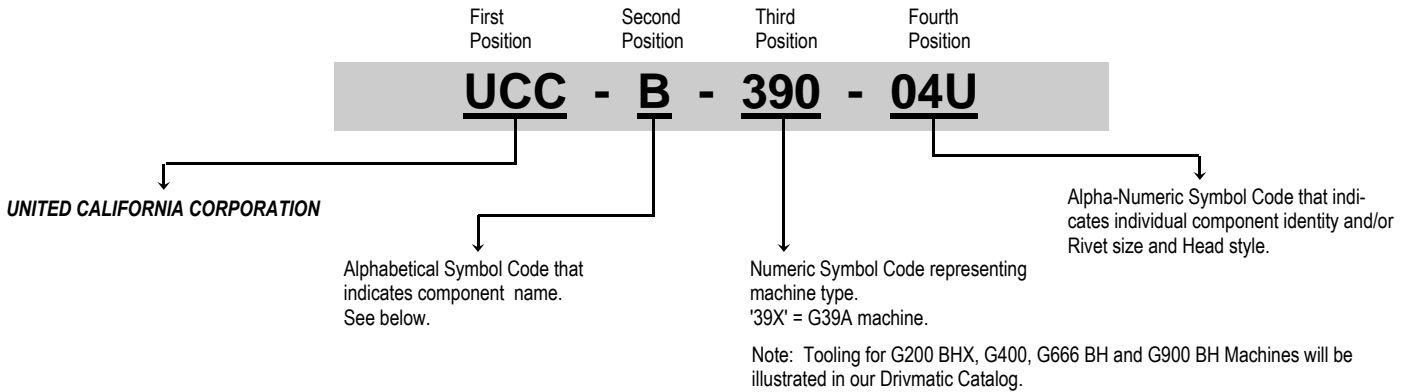


### UPPER ANVIL ADAPTER



# Part No. Components For Ordering Anvil Assy.

## SAMPLE PART NUMBER



### SECOND POSITION: Alphabetical Symbol Code indicating Component Name. AL=Lower Anvil; AU=Upper Anvil.

CODE	NAME	FITS	CODE	NAME	FITS	CODE	NAME	FITS
<b>AU</b>	ASSEMBLY, UPPER ANVIL		<b>LB</b>	BASE	AL	<b>RG</b>	RAIL GUIDE	AL
<b>FH</b>	FINGER HOLDER	AU	<b>CP</b>	CLAMP PIN	AL	<b>DP</b>	DOWEL PIN	AL
<b>RS</b>	RETURN SPRING	AU	<b>P</b>	PIN	AL	<b>SH</b>	SOCKET HEAD CAP SCREW	AL
<b>GS</b>	GARTER SPRING	AU	<b>AS</b>	LOWER ANVIL SKIRT	AL	<b>LA</b>	LOWER ANVIL	AL
<b>OR</b>	'O' RING	AU	<b>CS</b>	REPLACEABLE CLAMP SLEEVE	AL	<b>BP</b>	BASE PIN	AL
<b>F</b>	FINGER	AU	<b>AL</b>	ASSEMBLY, LOWER ANVIL	AL	<b>AP</b>	ANVIL PIN	AL
<b>B</b>	BUTTON	AU & AL	<b>IA</b>	INNER ANVIL	AL	<b>AB</b>	ANVIL BASE	AL
<b>A</b>	ANVIL	AU	<b>SR</b>	SNAP RING	AL	<b>SB</b>	STRIPPER BOLT	AL
<b>AD</b>	ADAPTER	AU	<b>SS</b>	STAKE SCREW	AU & AL	<b>LS</b>	LOCK SPRING	AL
<b>PB</b>	PRESSURE FOOT BUSHING	AU	<b>RB</b>	RUB STRIP	AL	<b>TS</b>	TENSION SPRING	AL
<b>PP</b>	PRESSURE PLATE	AU	<b>CR</b>	CLAMP RAIL	AL	<b>GP</b>	GUIDE PROTECTOR	AL
<b>LC</b>	LOWER OFFSET 'C' FRAME ASSY	AU	<b>BA</b>	BASE ADAPTER	AL	<b>FS</b>	FLUSH SCREW	AL

### THIRD POSITION: Numeric Code indicating Machine type.

CODE	Explanation
<b>390</b>	Indicates component applies to Upper Tooling and is interchangeable between short and long series.
<b>390S</b>	Indicates component applies to Lower Stake Type Anvil.
<b>390C</b>	Indicates component applies to Lower 'C' Type Anvil.
<b>391</b>	Indicates component applies to Upper Tooling—Short series Only.
<b>392</b>	Indicates component applies to Upper Tooling—Long series Only.



# Drill Spindle and Pressure Foot Assy

Assemblies

## PART RELATIONSHIP DRAWING

Full Scale Charts Available on Request.

Call **UNITED** For Information.

### PRESSURE FOOT BUSHING



### CLAMP SLEEVE

