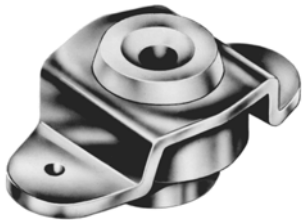


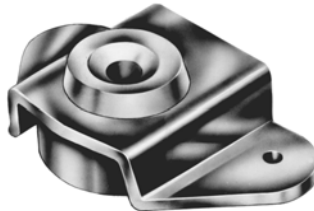
UNITED's Anchor® and Twisfit® Bushings

**Twisfit® Bushings
Anchor® Bushings**

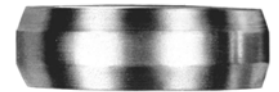
Our Long Time Classics!



REGULAR ANCHOR® BUSHINGS
Page B16



CORNER ANCHOR® BUSHINGS
Page B16



MULTI-GROOVE PIN RETAINERS



MULTI-GROOVE PIN BUSHINGS
Page B18



SERRATED PRESS
Page B20



SER-CAST
Page B13



TWISFIT® LOCK RINGS
Page B7



ANCHOR® PIN RETAINERS
Page B20



TWISFIT® LOCK RINGS
Page B7



SLOTTED ANCHOR® PIN BUSHINGS
Page B20



TWISFIT® SLOTTED HOLE LOCATORS
Page B8



STANDARD TWISFIT®
Page B6



TWISFIT® HANDLE BUSHINGS
Page B11

Bushing Problems?

Do You Have These Bushing Problems?

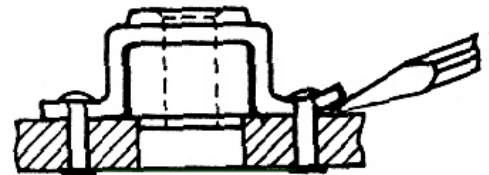
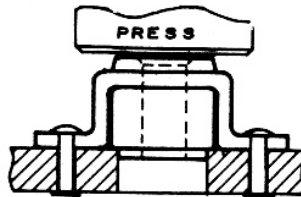
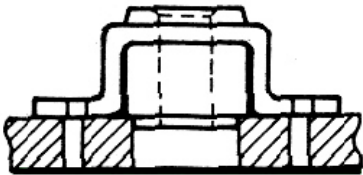
TYPE 'A' — RIVET IT?

Requires two or three drilled holes for mounting. Location must be accurate.

— WILL HOLD FOREVER!

Avoid Bushing cocking during pressing, riveting or welding operations.

If carefully removed, Bushing and Template are generally re-usable.

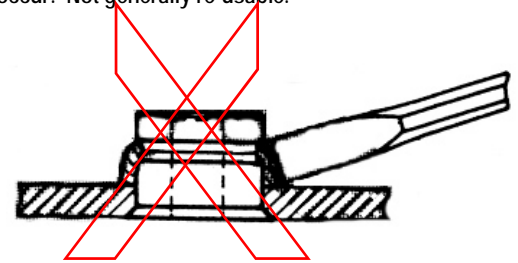


TYPE 'C' — CLINCH IT?

Expensive installation equipment may be required. Bushing may spin with inadequate clinching pressure.

Many Bushing configurations are required to accommodate varying plate thicknesses.

To remove Bushing, the cinching ring must be cut off. Damage to Bushing or Template may occur. Not generally re-usable.

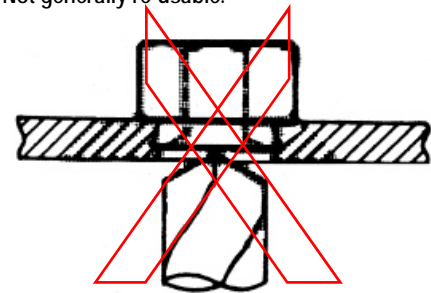
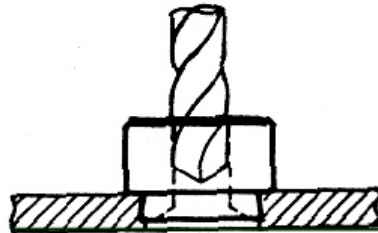
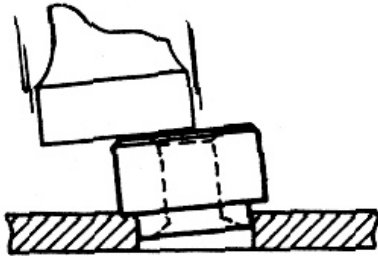


TYPE 'F' — FLARE IT?

Bushing can cock due to improper hammering.

Bushing may spin under the torque of the drill.

Bushing must be drilled out to be removed. Not generally re-usable.

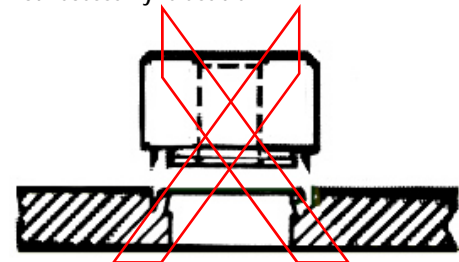
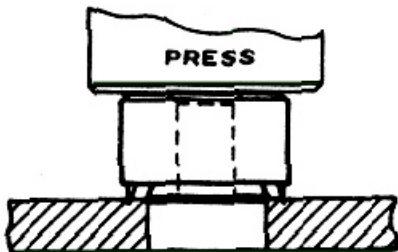


TYPE 'P' — PRESS IT?

Expensive installation equipment may be required.

Bushing may cock due to improper initial alignment. Bushing may be knocked out by drill deflection.

Template hole edge may distort. After Bushing and Template are separated, they are generally not necessarily re-usable.



Instant Solution



ALL ABOUT UNITED TWISFIT®

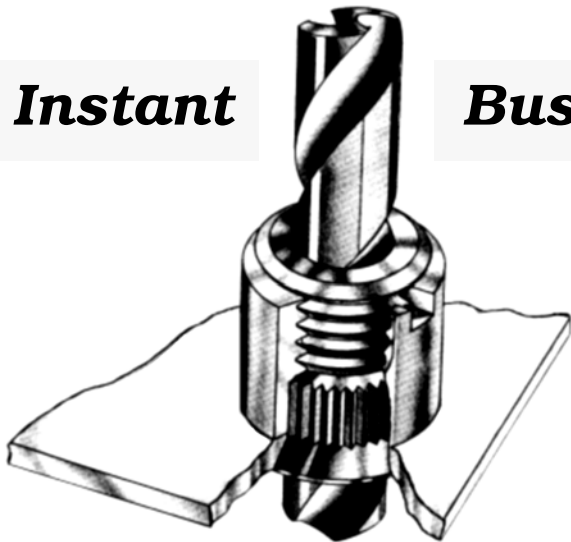
- ❶ **UNITED TWISFIT Bushings** are designed for simplified installation in drill plates made from thin gauge aluminum or cold rolled steel.
- ❷ **REUSABLE**—Fewer outside diameter configurations are required. Lock Rings are interchangeable. All Bushings and Rings can be removed and reused.
- ❸ **POSITIVE LOCKING**—Aluminum Lock Rings grip the Bushing and plate tightly. The left handed thread prevents the bushing from rotating while drilling. Guaranteed not to pull out. The lock rings will tighten when drilling. The 100° flange eliminates pull-out. Serrated O.D. prevents spin-out.
- ❹ **SELF ALIGNING**—The countersink in the plate aligns automatically with the bushing chamfer.
- ❺ **PRECISION**—UNITED's TWISFIT holds flush to the work piece. The drill is guided for the full length of the bushing. Chips won't accumulate between the work piece and the template. UNITED's TWISFIT Bushings are held within .002 T.I.R.
- ❻ **SIMPLIFIED INSTALLATION**—No tabs, straps, hammering, punching or spotwelding required. Cocked bushings are eliminated and there are no protrusions below the plate.
- ❼ **SPECIAL TOOLS NOT REQUIRED**—Pneumatic, hydraulic, clinching or hammering tools are not required. Simply insert the bushing and twist on the lock ring.
- ❽ **COST REDUCTION**—UNITED's EXCLUSIVE TWISFIT INSTANT BUSHING permits use of the thinnest fixture plate materials, reducing cost.
- ❾ **NO DISTORTION**—UNITED's TWISFIT Bushings will not buckle the plate or distort the hole. The fixture plates can be reused.
- ❿ **REDUCE INVENTORY**—UNITED's TWISFIT is available in all I.D. sizes from #55 thru 49/64 in only five O.D. configurations. Competitive O.D.s vary in number from 17 to 33 styles.

FREE!!!

If you have not enjoyed UNITED TWISFIT's simplicity and cost reduction, **try them at our expense!** Samples are always available upon your request. **Ask for UNITED's friendly engineering assistance.**

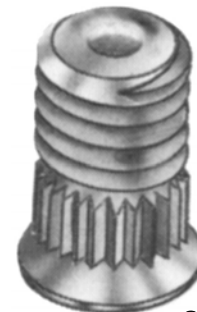
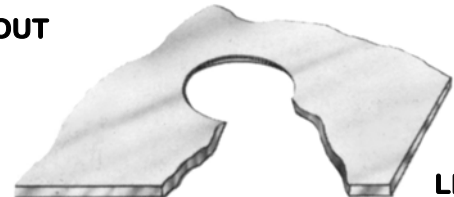
Instant

Bushings



- ACCURATE
- SECURE
- REUSABLE
- LOW COST
- REMOVABLE
- POSITIVE LOCKING
- REPLACEABLE
- PROMPT SERVICE
- NO CHIP BUILDUP
- NO DISTORTION
- PERPENDICULAR DRILLING
- SELF-ALIGNING
- MINIMUM O.D.
- NO HAMMERING
- NO COCKING
- NO SPIN OUT

- COMPACT
- LONG WEAR
- EASILY STORED
- MATERIAL SAVED
- CLOSER TOLERANCES
- SIMPLE INSTALLATION
- INCREASED EFFICIENCY
- LARGE INVENTORIES
- REDUCED WORKER FATIGUE
- UNIQUELY SUPERIOR



- LIGHTER FIXTURES
- REDUCED WEIGHT
- NO SPECIAL TOOLS
- FEWER CONFIGURATIONS

ADDED VALUE FROM **UNITED!**

Twisfit®

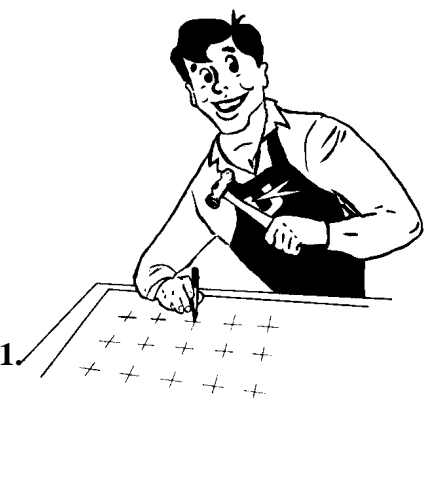
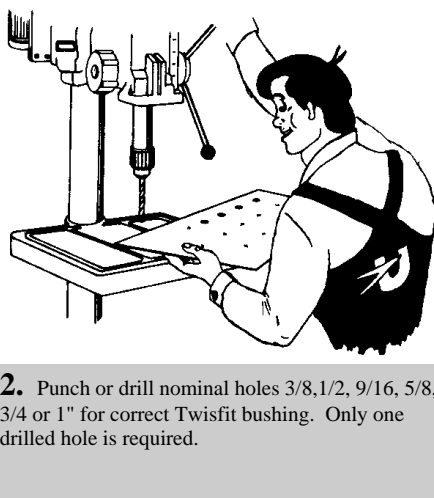
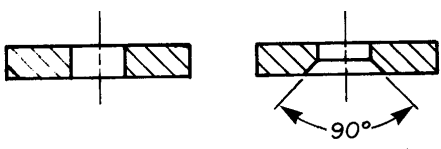
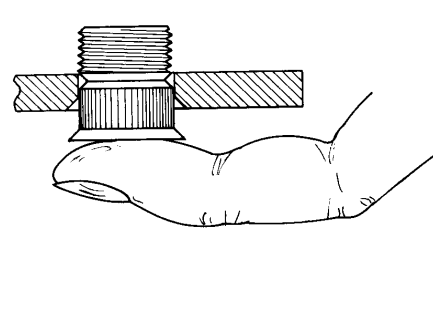
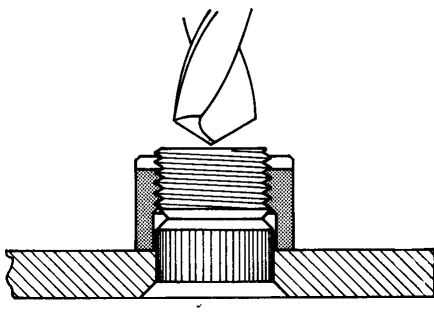
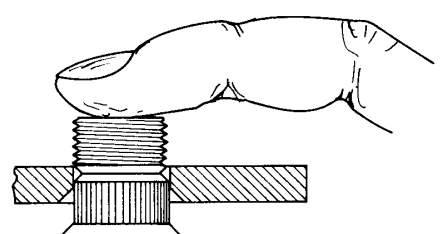
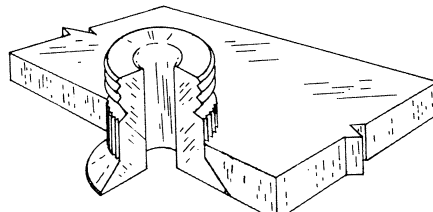
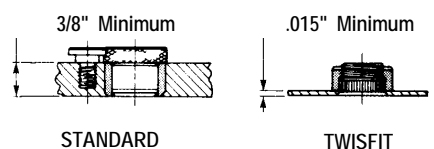
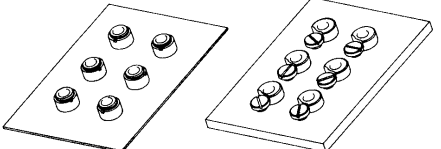
Twisfit® Installation

Instant Installations

IDEAL for METAL CABINETS, TRAILERS, TRUCKS, AUTOS, AIRCRAFT, BOATS, FURNITURE, APPLIANCES and MANUFACTURING

Twisfit® is designed for optimum drilling accuracy in steel, aluminum or magnesium plate tooling in thicknesses from .080 to 3/8 inch. Flush contact of the Twisfit ring against the plate assures perpendicular drill hole alignment. Expensive equipment or highly skilled labor is not required to produce low cost drill plates. UNITED's low cost Twisfits provide interchangeability for volume or short run production. Lightweight, easily stored Twisfit plates replace heavy, expensive drill fixtures.

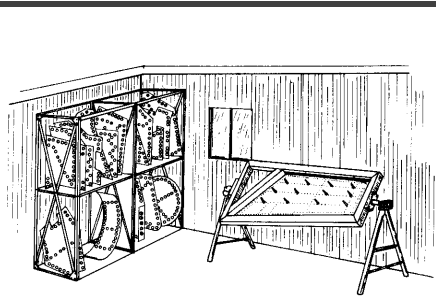
Easy Steps to Install Twisfits

 <p>1. Mark hole locations on the plate.</p>	 <p>2. Punch or drill nominal holes 3/8, 1/2, 9/16, 5/8, 3/4 or 1" for correct Twisfit bushing. Only one drilled hole is required.</p>	 <p>3. Dimple or countersink 90° to permit 100° flange to seat flush to .015 inside surface of plate.</p>
 <p>4. Slip Twisfit into drilled hole. No expensive installation equipment is required. Serrations prevent rotation.</p>		 <p>6. Easily removable, replaceable and reusable.</p>
 <p>7. The Twisfit's left handed thread is self tightening. It will not slip out.</p>	 <p>8. Twisfit is a low cost tooling technique — less plate thickness is required. Twisfits are supported amply from stock .015 of an inch thick.</p>	 <p>9. Weight reduced — material saved. A square Twisfit plate 3/16" thick is 2-1/2 lbs. A conventional 1/2" by 12" square fixture plate is 12 lbs. Plate drilling time is reduced 80%.</p>

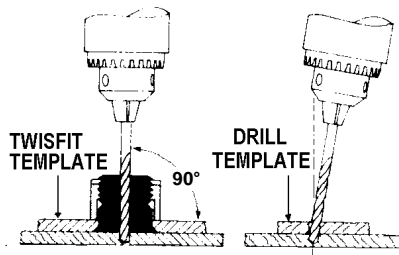
Instant Satisfaction

Twisfit® Application

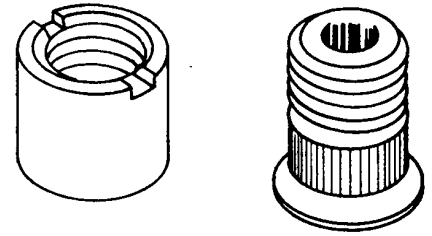
Reduce Fixture Weight and Material Costs Drastically



10. Lightweight Twisfit drill plates can be stored off the floor and overhead. Handling equipment is not required.

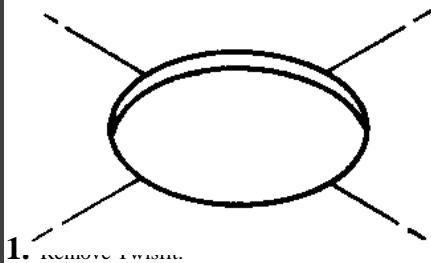


Angular or elongated holes result from unsupported drills. The Twisfit is a low cost insurance policy.

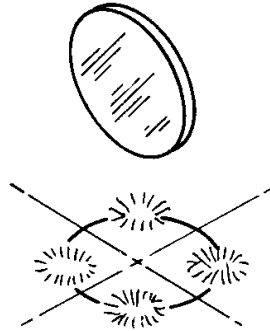


12. Remove the Twisfit and reuse both the Twisfit and the plate. Reduce cost and increase "smileage."

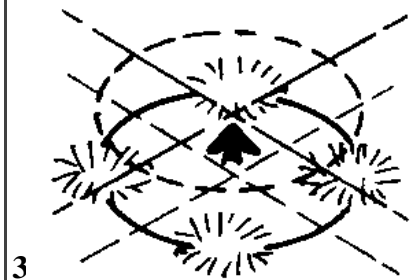
To rework Twisfit plate:



1. REMOVE TWISFIT.



2. Spotweld punch slug in old hole location.



3



Twisfit® Bushings

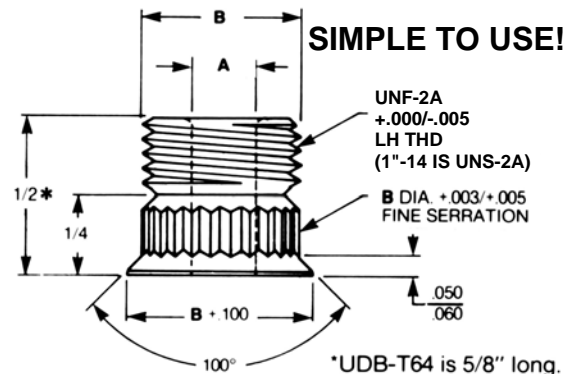
Instant Savings

Customers request over a million units annually!

**BEST BUSHING
BUY TODAY!**

STANDARD TWISFIT®

Exclusively UNITED!
PATENT 3,768,918



**TWISFIT®
TIGHTENS WHILE
DRILLING!**

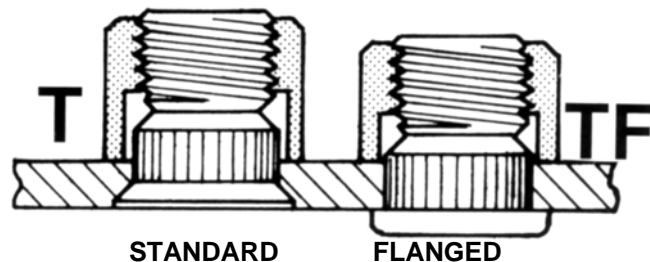
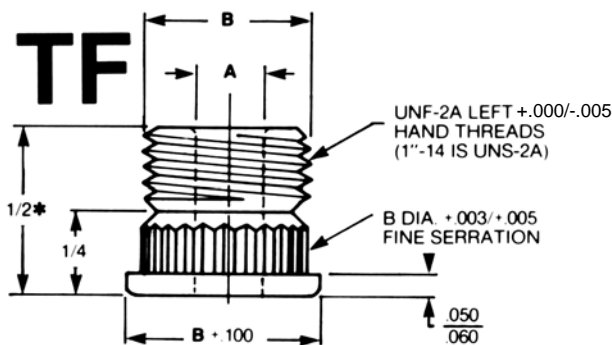
**TWISFIT® Used by
Leading AUTO,
AIRCRAFT, TRUCK,
TRAILER, CAMPER,
WINDOW, DOOR,
METAL FURNITURE
MANUFACTURERS!**

MATERIAL: STEEL
CASE HARDENED .015 DEEP
R/C 59 - 64
T.I.R. A to B = .002 MAX

TWISFIT BUSHING PART NO.	A I.D. RANGE +.0001 +.0015	B O.D. RANGE +.003 +.005	THD LH ALL TYPES	PLATE THICK-NESS	* USE LOCK RING	EACH ITEM PRICE	TWISFIT® QUANTITY PRICES					
							1 - 9	10 - 24	25 - 99	100 - 499	500 - 999	1000 UP
UDB-T-24	#55 - #43 .0520 - .0890	.375	3/8 - 24	1/64 - 1/8	T24-6	TWISFIT BUSHING	2.83	2.48	2.31	2.17	2.08	1.89
				9/64 - 3/16	T24-5	LOCK RING	1.04	1.00	0.94	0.90	0.87	0.85
				13/64 - 3/8	T24-3	TW LOCK RING	1.37	1.35	1.23	1.17	1.13	1.12
UDB-T-24	#42 - #10 .0935 - .1935	.375	3/8 - 24	1/64 - 1/8	T24-6	TWISFIT BUSHING	2.12	1.88	1.76	1.69	1.61	1.52
				9/64 - 3/16	T24-5	LOCK RING	1.04	1.00	0.94	0.90	0.87	0.85
				13/64 - 3/8	T24-3	TW LOCK RING	1.37	1.35	1.23	1.17	1.13	1.12
UDB-T-32	#9 - #0 .1960 - .3160	.500	1/2 - 20	1/64 - 1/8	T32-6	TWISFIT BUSHING	2.35	2.16	2.11	1.93	1.76	1.60
				9/64 - 3/16	T32-5	LOCK RING	1.14	1.07	0.94	0.93	0.87	0.85
				13/64 - 3/8	T32-3	TW LOCK RING	1.54	1.44	1.37	1.34	1.33	1.31
UDB-T-36	11/64 - 13/32 .1719 - .4062	.562	9/16 - 18	1/64 - 1/8	T36-6	TWISFIT BUSHING	3.05	2.93	2.50	2.42	2.31	2.18
				9/64 - 3/16	T36-5	LOCK RING	1.59	1.43	1.37	1.36	1.33	1.24
				13/64 - 3/8	T36-3	TW LOCK RING	1.89	1.82	1.77	1.73	1.72	1.64
UDB-T-40	5/16 - 7/16 .3125 - .4375	.625	5/8 - 18	1/64 - 1/8	T40-6	TWISFIT BUSHING	3.23	3.11	2.65	2.57	2.45	2.31
				9/64 - 3/16	T40-5	LOCK RING	1.59	1.43	1.37	1.36	1.33	1.24
				13/64 - 3/8	T40-3	TW LOCK RING	1.89	1.82	1.77	1.73	1.72	1.64
UDB-T-48	P - 1/2 .3230 - .5000	.750	3/4 - 16	1/64 - 1/8	T48-6	TWISFIT BUSHING	4.09	3.73	3.49	3.28	2.98	2.84
				9/64 - 3/16	T48-5	LOCK RING	1.70	1.60	1.55	1.48	1.44	1.43
				13/64 - 3/8	T48-3	TW LOCK RING	2.20	1.98	1.89	1.82	1.77	1.62
UDB-T-64	33/64 - 49/64 .5156 - .7656	1.000	1" - 14	1/64 - 1/8	T64-6	TWISFIT BUSHING	5.19	4.75	4.41	4.14	3.76	3.55
				9/64 - 3/16	T64-5	LOCK RING	1.91	1.82	1.74	1.64	1.55	1.47
				13/64 - 3/8	T64-3	TW LOCK RING	2.35	2.26	2.18	2.05	2.01	1.90

* For THINWALL LOCK RINGS, add suffix **TW** to Part No. Example: T24-6-TW. -6,-5,-3 LOCK RING STYLES ALL SAME PRICE.

FLANGED TWISFIT® — ALTERNATE STYLE FOR PLATE SUPPORT



The Flange Style is designed to support the Drill Plate above the work. Flange radius prevents scarring of work piece. Countersinking or dimpling is eliminated.

Flange Bushings are manufactured from semi-finished and are priced the same as Twisfits above.

Specify **T** for **Standard**.
EXAMPLE: UDB-T32 - 1/4"

Specify **TF** for **Flanged**.
EXAMPLE: UDB-TF40 - 3/8"

Instant Selections

For Lock Rings, Washers and Installation Tools

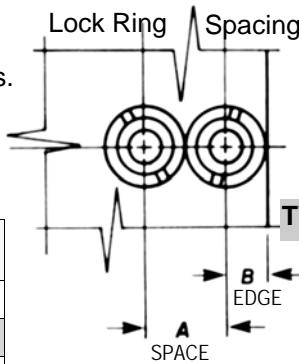
Lock Rings for
Twisfit® Bushings

SELECT LOCK RING DIAMETER

STANDARD: For Normal Accommodations. Use RTS type.
THINWALL: For Extremely Close Hole Spacing Only. Use RT type.

UNF-2B INTERNAL LH THD +.005/-000

STANDARD LOCK RING	A MINIMUM SPACING RT	A MINIMUM SPACING RTS	B MINIMUM EDGE SPACING
UDB-T-24 -(6,5 or 3)	33/64	9/16	1/4
UDB-T-32 -(6,5 or 3)	41/64	45/64	5/16
UDB-T-36 -(6,5 or 3)	45/64	3/4	11/32
UDB-T-40 -(6,5 or 3)	49/64	53/64	3/8
UDB-T-48 -(6,5 or 3)	1-1/64	1-3/32	1/2
UDB-T-64 -(6,5 or 3)	1-17/64	1-11/32	5/8
THINWALL LOCK RING	A MINIMUM SPACING RT	A MINIMUM SPACING RTS	B MINIMUM EDGE SPACING
UDB-T-24-(6,5 or 3)-TW	29/64	17/32	7/32
UDB-T-32-(6,5 or 3)-TW	37/64	43/64	9/32
UDB-T-36 -(6,5 or 3)-TW	41/64	23/32	5/16
UDB-T-40-(6,5 or 3)-TW	45/64	51/64	11/32
UDB-T-48 -(6,5 or 3)-TW	57/64	1-1/32	7/16
UDB-T-64-(6,5 or 3)-TW	1-9/64	1-9/32	9/16

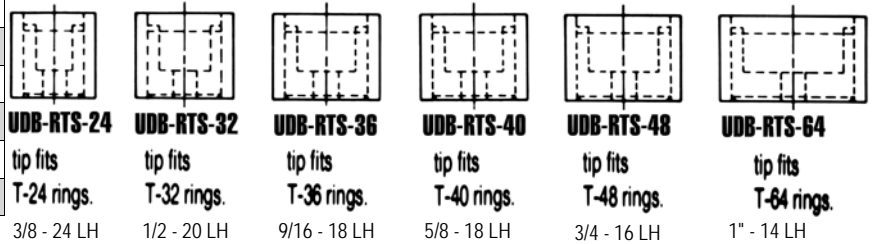


**REMOVAL and
INSTALLATION TOOL
UDB-RTS/RT-7 SET
contains
HANDLE and ALL SIX
SOCKETS.**



TWISFIT® REMOVAL / INSTALLATION TOOLS

SOCKET WITH SLEEVE	SOCKET ONLY	TIP FITS RING	PRICE
UDB-RTS-24	UDB-RT-24	T-24 (3/8 - 24 LH)	15.78
UDB-RTS-32	UDB-RT-32	T-32 (1/2 - 20 LH)	16.95
UDB-RTS-36	UDB-RT-36	T-36 (9/16 - 18)	18.49
UDB-RTS-40	UDB-RT-40	T-40 (5/8 - 18 LH)	18.49
UDB-RTS-48	UDB-RT-48	T-48 (3/4 - 16 LH)	20.14
UDB-RTS-64	UDB-RT-64	T-64 (1" - 14 LH)	20.14
UDB-RT-5 HANDLE ONLY			17.45
UDB-RTS-7 SET / UDB-RT-7 SET			120.90

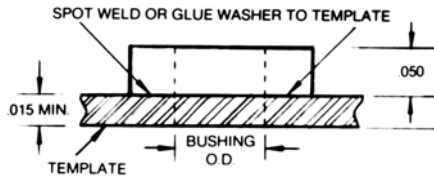


SEE BELOW FOR DETAILS.

.050 WASHERS
UDB-T24-W
UDB-T32-W
UDB-T36-W
UDB-T40-W
UDB-T48-W
UDB-T64-W

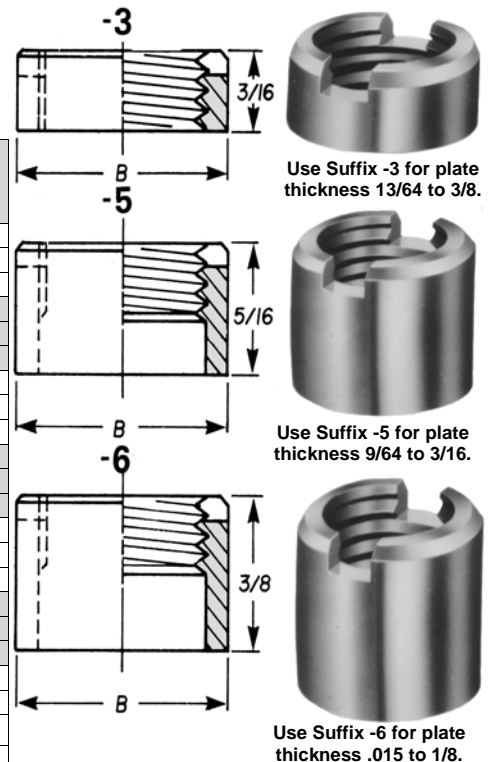
Twisfit® Bushings **Example:**

can be used on templates as thin as .015.
To add strength or support, use a .050 Washer.



TWISFIT® LOCK RINGS

THREE LENGTHS AVAILABLE
UNF-2B INTERNAL LH THD +.005/-000



LOCK RING PART NO.	PLATE THICKNESS	THD	B O.D. * THIN WALL	PRICE EACH ITEM	TWISFIT® QUANTITY PRICES					
					1 - 9	10 - 24	25 - 99	100 - 499	500 - 999	1000 UP
UDB-T-24-6	1/64 - 1/8	LH THD 3/8 - 24	1/2	TWISFIT BUSHING	2.83	2.48	2.31	2.17	2.08	1.89
UDB-T-24-5	9/64 - 3/16			LOCK RING	1.04	1.00	0.94	0.90	0.87	0.85
UDB-T-24-3	13/64 - 3/8	LH THD 3/8 - 24	* 7/16	TW LOCK RING	1.37	1.35	1.23	1.17	1.13	1.12
UDB-T-24-6	1/64 - 1/8			TWISFIT BUSHING	2.12	1.88	1.76	1.69	1.61	1.52
UDB-T-24-5	9/64 - 3/16	LH THD 3/8 - 24	1/2	LOCK RING	1.04	1.00	0.94	0.90	0.87	0.85
UDB-T-24-3	13/64 - 3/8			TW LOCK RING	1.37	1.35	1.23	1.17	1.13	1.12
UDB-T-32-6	1/64 - 1/8	LH THD 1/2 - 20	5/8	TWISFIT BUSHING	2.35	2.16	2.11	1.93	1.76	1.60
UDB-T-32-5	9/64 - 3/16			LOCK RING	1.14	1.07	0.94	0.93	0.87	0.85
UDB-T-32-3	13/64 - 3/8	LH THD 9/16 - 18	* 9/16	TW LOCK RING	1.54	1.44	1.37	1.34	1.33	1.31
UDB-T-36-6	1/64 - 1/8			TWISFIT BUSHING	3.05	2.93	2.50	2.42	2.31	2.18
UDB-T-36-5	9/64 - 3/16	LH THD 9/16 - 18	11/16	LOCK RING	1.59	1.43	1.37	1.36	1.33	1.24
UDB-T-36-3	13/64 - 3/8			TW LOCK RING	1.89	1.82	1.77	1.73	1.72	1.64
UDB-T-40-6	1/64 - 1/8	LH THD 5/8 - 18	3/4	TWISFIT BUSHING	3.05	2.93	2.50	2.42	2.31	2.18
UDB-T-40-5	9/64 - 3/16			LOCK RING	1.59	1.43	1.37	1.36	1.33	1.24
UDB-T-40-3	13/64 - 3/8	LH THD 3/4 - 16	* 11/16	TW LOCK RING	1.89	1.82	1.77	1.73	1.72	1.64
UDB-T-48-6	1/64 - 1/8			TWISFIT BUSHING	3.38	3.04	2.89	2.79	2.68	2.58
UDB-T-48-5	9/64 - 3/16	LH THD 1" - 14	1"	LOCK RING	1.70	1.60	1.55	1.48	1.44	1.43
UDB-T-48-3	13/64 - 3/8			TW LOCK RING	2.20	1.98	1.89	1.82	1.77	1.62
UDB-T-64-6	1/64 - 1/8	LH THD 1" - 14	1-1/4	TWISFIT BUSHING	5.19	4.75	4.41	4.14	3.76	3.55
UDB-T-64-5	9/64 - 3/16			LOCK RING	1.91	1.82	1.74	1.64	1.55	1.47
UDB-T-64-3	13/64 - 3/8		* 1-1/8	TW LOCK RING	2.35	2.26	2.18	2.05	2.01	1.90

* ADD SUFFIX -TW TO ORDER THINWALLS. REGULAR LOCK RINGS -6, -5, -3 ARE PRICED THE SAME.

Twisfit® Locators - Twistops - TC-TS Tabs

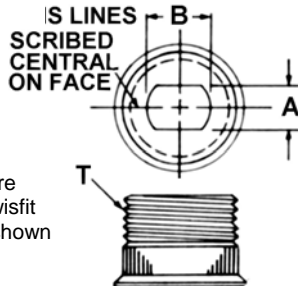
Instant Success

UNITED's Slot Locator Bushings provide precision part location while only having to maintain a ±.050 tooling tolerance.

Dowels, L Pins, T Pins or Locating Pins may be used as a master locating pin.



LOCK RING
AVAILABLE
IN 3 SIZES,
3/16, 5/16 AND
3/8.
SEE PAGE B7.



Dimensions are identical to Twisfit Bushings as shown on Page B6.

Install by scribing lines on the fixture plate and align with site lines on the Slot Locator Bushing.



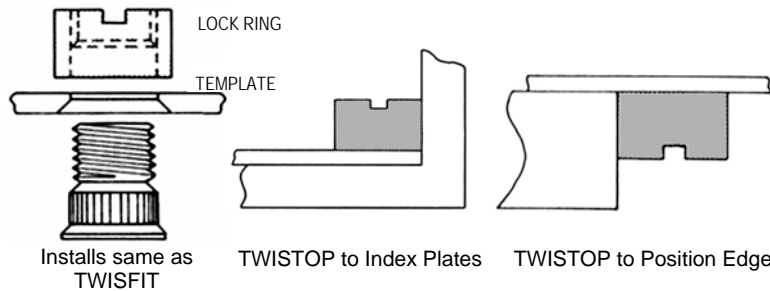
TWISFIT® SLOTTED HOLE LOCATORS

SLOTTED LOCATOR	A +.0010 -.0000	B	T LH THD	LOCK RING	PLATE THICKNESS	PRICE
5/8" UDB-TSL-40- 1/8	.1251	1/4	5/8 - 18	T-40-6	1/64 - 1/8	15.06
				T-40-5	9/64 - 3/16	
				T-40-3	13/64 - 3/8	
5/8" UDB-TSL-40- #30	.1286	1/4	5/8 - 18	T-40-6	1/64 - 1/8	15.06
				T-40-5	9/64 - 3/16	
				T-40-3	13/64 - 3/8	
5/8" UDB-TSL-40- #20	.1611	1/4	5/8 - 18	T-40-6	1/64 - 1/8	15.06
				T-40-5	9/64 - 3/16	
				T-40-3	13/64 - 3/8	
5/8" UDB-TSL-40- 3/16	.1876	3/8	5/8 - 18	T-40-6	1/64 - 1/8	15.06
				T-40-5	9/64 - 3/16	
				T-40-3	13/64 - 3/8	
5/8" UDB-TSL-40- #10	.1936	3/8	5/8 - 18	T-40-6	1/64 - 1/8	15.06
				T-40-5	9/64 - 3/16	
				T-40-3	13/64 - 3/8	
5/8" UDB-TSL-40- 1/4	.2501	3/8	5/8 - 18	T-40-6	1/64 - 1/8	15.06
				T-40-5	9/64 - 3/16	
				T-40-3	13/64 - 3/8	
3/4" UDB-TSL-48- 5/16	.3126	7/16	3/4 - 16	T-48-6	1/64 - 1/8	15.06
				T-48-5	9/64 - 3/16	
				T-48-3	13/64 - 3/8	
3/4" UDB-TSL-48- 3/8	.3751	1/2	3/4 - 16	T-48-6	1/64 - 1/8	15.06
				T-48-5	9/64 - 3/16	
				T-48-3	13/64 - 3/8	
3/4" UDB-TSL-48- 1/2	.5001	5/8	3/4 - 16	T-48-6	1/64 - 1/8	15.06
				T-48-5	9/64 - 3/16	
				T-48-3	13/64 - 3/8	
1" UDB-TSL-64- 5/8	.6251	3/4	1" - 14	T-64-6	1/64 - 1/8	47.91
				T-64-5	9/64 - 3/16	
				T-64-3	13/64 - 3/8	
UDB-TSL-64 is 5/8" LONG						
1" UDB-TSL-64- 3/4	.7501	13/16	1" - 14	T-64-6	1/64 - 1/8	57.88
				T-64-5	9/64 - 3/16	
				T-64-3	13/64 - 3/8	
UDB-TSL-64 is 5/8" LONG						



TWISTOPS are solid — without holes—for Custom Applications! Otherwise dimensions are identical to Twisfit Bushings as shown on Page B6.

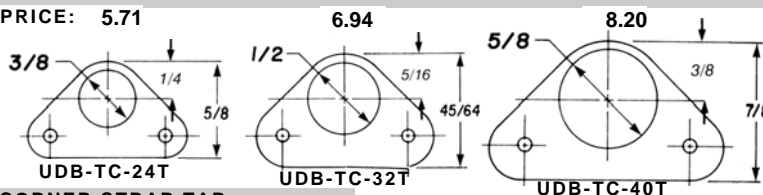
TWISTOPS



TWISTOP PART NO.	B -.003 -.005	T LH THD	LOCK RING	PLATE THICKNESS	PRICE
UDB-TS-24	3/8	3/8 - 24	T-24-6	1/64 - 1/8	1.59
			T-24-5	9/64 - 3/16	
			T-24-3	13/64 - 3/8	
UDB-TS-32	1/2	1/2 - 20	T-32-6	1/64 - 1/8	1.80
			T-32-5	9/64 - 3/16	
			T-32-3	13/64 - 3/8	
UDB-TS-36	9/16	9/16 - 18	T-36-6	1/64 - 1/8	2.05
			T-36-5	9/64 - 3/16	
			T-36-3	13/64 - 3/8	
UDB-TS-40	5/8	5/8 - 18	T-40-6	1/64 - 1/8	2.26
			T-40-5	9/64 - 3/16	
			T-40-3	13/64 - 3/8	
UDB-TS-48	3/4	3/4 - 16	T-48-6	1/64 - 1/8	2.53
			T-48-5	9/64 - 3/16	
			T-48-3	13/64 - 3/8	
UDB-TS-64	1"	1" - 14	T-64-6	1/64 - 1/8	3.70
			T-64-5	9/64 - 3/16	
			T-64-3	13/64 - 3/8	

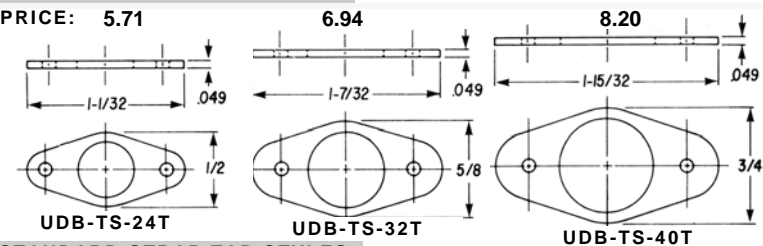
CORNER — TC and STANDARD STRAP TABS — TS

PRICE: 5.71



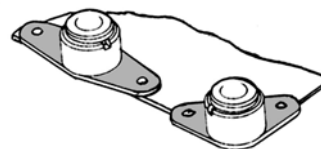
CORNER STRAP TAB

PRICE: 5.71



STANDARD STRAP TAB STYLES

Strengthens Corner and Template Edges



Use Template Twisfit Tabs when a TWISFIT Bushing is placed very close to an edge or corner.

Drill and/or countersink normally. Then locate a Tab over the hole and rivet or spot weld into place.

UNITED TABS sized to fit 3/8, 1/2 and 5/8 Twisfit® Bushings.

Instant Inventory In Twispik Cases

T-1 POPULAR FRACTIONAL Service Set

Instant Replacement!



24
DRAWERS

81 TWISFIT® Bushings and Lock Rings. The Popular Set contains 3 each of 15 I.D. sizes from 1/16" thru 1/2" in 1/32" increments. 45 Bushings and assorted Lock Rings. Selection is easy from the 24 drawers Twispik case containing 81 TWISFIT parts.

T-2 GENERAL FRACTIONAL Service Set

Instant Fixturing!



24
DRAWERS

176 TWISFIT® Bushings and Lock Rings. Ideal for the shop using most small fractional sizes. Four each in all ID sizes from 1/16" thru 1/2" in 64th increments. Has 60 assorted Lock Rings and a complete set of removal tools. The 24 Drawers Twispik Case offers fast and easy selection of the 176 TWISFIT pieces.

T-3 LETTER Service Set

Instant Access!



24
DRAWERS

144 TWISFITs and Lock Rings. Ideal for 'In-Between' Letter Sizes. Contains 4 each of all 26 Letter sizes from 'A' thru 'Z' along with 40 Lock Rings in the 24 Drawers Twispik Case. 144 TWISFIT pieces.

T-4 NUMBER Service Set

Instant Satisfaction!



36
DRAWERS

260 TWISFIT® Bushings and Lock Rings. For essential 'In-Between' number sizes. The Number Service Set contains 4 each of all wire gauge sizes from #1 thru #55 in addition to 40 assorted Lock Rings in the 36 Drawers Twispik Case. 260 TWISFIT pieces.

T-5 TOOL MAKERS Service Set

Instant Inventory!



36
DRAWERS

285 TWISFITs and Lock Rings. Tool Makers Larger Hole Service Set completes your sizes with all fractional IDs from 1/16" thru 49/64" in 64th increments. Has 96 assorted Lock Rings and a 6-piece set of removal tools. 285 TWISFIT pieces in the 36 Drawers Twispik Case.

T-345 SHOP MASTER Service Multi-Set

Instant Use!

108
DRAWERS



690 TWISFIT® Bushings, Lock Rings and all Installation and Removal Tools. The Shop Master TWISFIT Service Multi-Set is a complete template fixture building service inventory. The Multi-Set contains every letter, number, and fractional sizes from #55 (.0520) small thru 49/64" (.7656) large. Has 4 each of 127 sizes for a total of 508 TWISFIT Bushings, 176 Lock Rings, and a 6-piece set of Installation and Removal tools in a Multi-Set of three 36 Drawers Twispik Cases with 108 drawers.

Handle Bushing and Drill Stand Kit

Twisfit® Handle and Drill Stand SF Bushing Kit



UTK-649 Twisfit® Handle Bushing and Drill Stand Kit

UTK-649 KIT CONTENTS

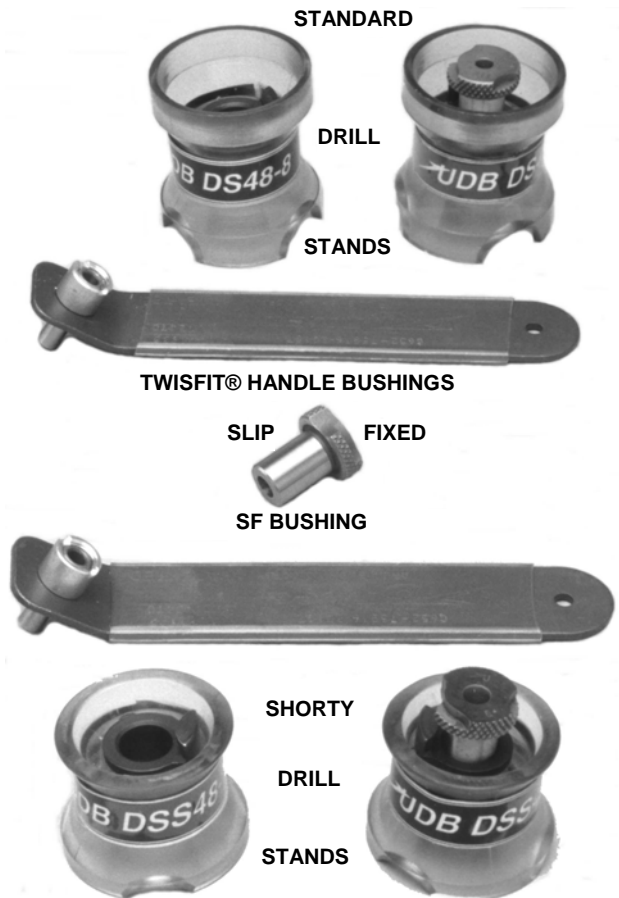
1 UTK-649 KIT ASSEMBLY				
QTY	PART NO.	I.D.	O.D.	LENGTH
HANDLE BUSHINGS				
2	UDB-752417	.1562 (5/32)	.266	1/2
2	UDB-752417	.1562 (5/32)	.261	1/2
2	UDB-752417	.1562 (5/32)	.257	1/2
2	UDB-752416	.1562 (5/32)	.250	1/2
2	UDB-752413	.1285 (#30)	.204	1/2
2	UDB-752413	.1285 (#30)	.199	1/2
2	UDB-752413	.1285 (#30)	.191	1/2
2	UDB-752412	.1285 (#30)	.166	1/2
2	UDB-752412	.1285 (#30)	.161	1/2
2	UDB-752410	.0980 (#40)	.156	1/2
SLIP-FIXED RENEWABLE BUSHINGS				
2	UDB-SF-32-12	.2660 (H)	1/2	3/4
2	UDB-SF-32-12	.2610 (G)	1/2	3/4
2	UDB-SF-32-12	.2570 (F)	1/2	3/4
2	UDB-SF-32-12	.2500 (E)	1/2	3/4
2	UDB-SF-32-12	.2040 (#6)	1/2	3/4
2	UDB-SF-32-12	.1990 (#8)	1/2	3/4
2	UDB-SF-32-12	.1910 (#11)	1/2	3/4
2	UDB-SF-32-12	.1660 (#19)	1/2	3/4
2	UDB-SF-32-12	.1610 (#20)	1/2	3/4
2	UDB-SF-32-12	.1562 (5/32)	1/2	3/4
2	UDB-SF-32-12	.1285 (#30)	1/2	3/4
2	UDB-SF-32-12	.0980 (#40)	1/2	3/4
2	UDB-DSS-48-12	DRILL STAND SHORTY 1/2" I.D.		
2	UDB-DS-48-8	STANDARD DRILL STAND 1/2" I.D.		

Ideal For Use in Hole Transfer!

This UTK-649 Kit is representative of **UNITED** Kits available for these tools when drilling or reaming cannot be reached with stationary or permanent tools. This Hole Transfer Kit was designed at **UNITED** and is specified for Lockheed's latest F-16 Aircraft. Send us your specifications.

Twisfit Bushings are reusable and replaceable. The handle has a comfortable plastic grip. A large variety of Slip Fixed Handle Bushings are available to satisfy your specific requirements.

Our light transparent and tough Drill Stand is designed to use with irregular or contoured surfaces. Does not crack and seats firmly to irregular surfaces. Assures 90° drill alignment.



Send us your requirements and we will design your Special Kit to get your job finished on time!

Instant Fixture

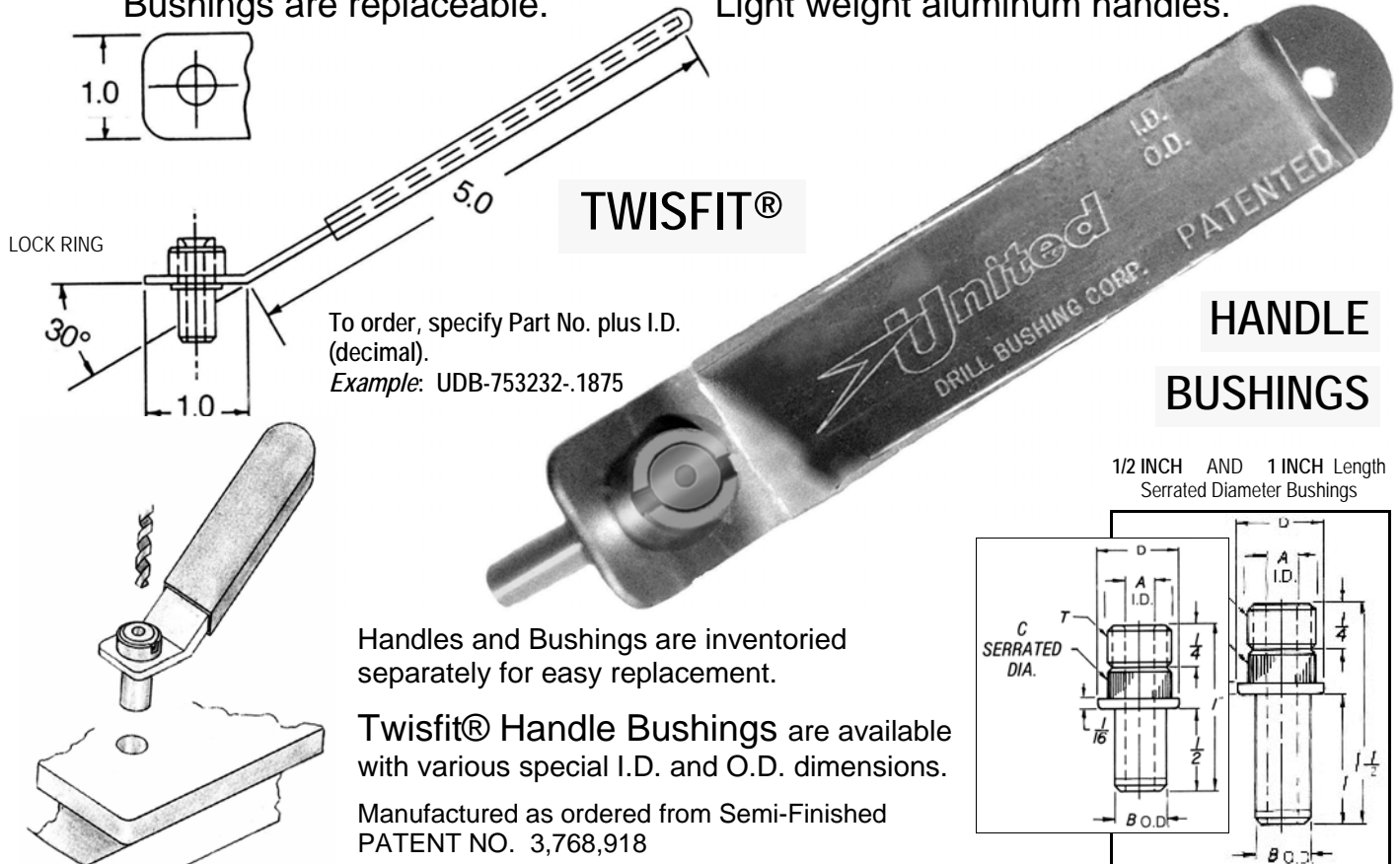
**Twisfit®
Handle Bushings**

WE WANT TO HANDLE YOUR BUSHINGS!

Twisfit® is ideal for drilling or reaming holes which cannot be reached with stationary or permanent tooling. Handle has comfortable grip with clear identification.

Bushings are replaceable.

Light weight aluminum handles.

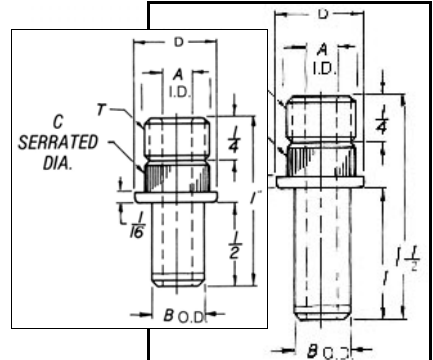


TWISFIT®

**HANDLE
BUSHINGS**

To order, specify Part No. plus I.D. (decimal).
Example: UDB-753232-.1875

1/2 INCH AND 1 INCH Length
Serrated Diameter Bushings



Handles and Bushings are inventoried separately for easy replacement.

Twisfit® Handle Bushings are available with various special I.D. and O.D. dimensions.

Manufactured as ordered from Semi-Finished
PATENT NO. 3,768,918

Specify 1/2" or 1" on Bushing length.
Add '-1L' to Bushing P/N for 1".

For Discount Quantity Pricing, see below.

Specify 1/2" or 1" on Bushing length.
Add '-1L' to Bushing P/N for 1".

UNITED PART NO.	A I.D. RANGE* STANDARD DRILL SIZES		B O.D. SIZE		C O.D.	D	T UNF-2A LH +.000 /- .005 BUSHING	UNF-2A LH +.005/- .000 LOCK RING	PRICE with Lock Rings	
	NOMINAL	DECIMAL	NOM.	ACTUAL					1/2 length	1" length
UDB-752410	#55-1/16	.0520-.0625	5/32	.1552-.1542	3/8	15/32	3/8-24	T-24-6	28.37	35.69
UDB-752412	#55-#39	.0520-.0995	3/16	.1865-.1855	3/8	15/32	3/8-24	T-24-6	22.02	27.53
UDB-752413	#55-#39	.0520-.0995	13/64	.2021-.2011	3/8	15/32	3/8-24	T-24-6	22.02	27.53
UDB-752416	#40-#28	.0980-.1405	1/4	.2490-.2480	3/8	15/32	3/8-24	T-24-6	22.33	27.93
UDB-752420	1/8-#10	.1250-.1935	5/16	.3115-.3105	3/8	15/32	3/8-24	T-24-6	18.18	22.85
UDB-752424	1/8-#10	.1250-.1935	3/8	.3740-.3730	3/8	15/32	3/8-24	T-24-6	18.18	22.85
UDB-753220	#10-#1	.1935-.2280	5/16	.3115-.3105	1/2	19/32	1/2-20	T-32-6	18.18	22.85
UDB-753224	#10-#1	.1935-.2280	3/8	.3740-.3730	1/2	19/32	1/2-20	T-32-6	17.33	21.83
UDB-753226	3/16-F	.1875-.2570	13/32	.4052-.4042	1/2	19/32	1/2-20	T-32-6	17.76	22.23
UDB-753228	A-L	.2340-.2900	7/16	.4365-.4355	1/2	19/32	1/2-20	T-32-6	17.76	22.23
UDB-753232	3/16-O	.1875-.3160	1/2	.4990-.4980	1/2	19/32	1/2-20	T-32-6	17.76	22.23
UDB-754036	M-11/32	.2950-.3437	9/16	.5615-.5605	5/8	23/32	5/8-18	T-40-6	16.64	20.99
UDB-754040	5/16-7/16	.3125-.4375	5/8	.6240-.6230	5/8	23/32	5/8-18	T-40-6	16.64	20.99
UDB-754848	5/16-17/32	.3125-.5312	3/4	.7490-.7480	3/4	27/32	3/4-16	T-48-6	16.64	20.99
UDB-756464	1/2-49/64	.5000-.7656	1	.9990-.9980	1	1-3/32	1-14	T-64-6	27.63	34.73

* Tolerances on 'A' dimension can be found on page A2.

QTY	1-2	3-5	6-11	12-23	24-49	50-99	100 & UP
DISCOUNT	LIST	-6%	-23%	-30%	-35%	-42%	-50%