

Bolts-Inserts-Tools- Nuts-Screws-Washers- Hex Wrenches

Every Style
and Type



T-BOLT SETS Pg F22



L-WRENCH
HEX DRIVERS
Pg F18



SIDE GRIP CLAMPS
Pg F12



MODULAR T-SLOT BARS Pg F34



PNEUMATIC INSTALLATION TOOL Pg F11



SOCKET HEAD CAP SCREWS Pg F15



SOCKET SHOULDER SCREWS Pg F13



SOCKET HEAD LOCATING
SCREWS Pg F15



CLAMPING STUDS Pg F26



SQUARE HOLE SLEEVES Pg F17



HEX HEAD CAP SCREWS Pg F16



T-SLOT BOLTS Pg F23



ROTARY T-SLOT BOLTS Pg F24



PULL-OUT
DOWELS Pg F17



SPHERICAL FLANGE NUTS
& WASHERS Pg F33



HEX NUTS Pg F33



CHECK NUTS
Pg F33



C-WASHERS
Pg F21



WING NUT FASTENERS Pg F11



ADJ. PIVOT CLAMP ASSY
Pg F25



STEP BLOCKS
Pg F30



CARBON UNI-
INSERTS Pg F7



SS THREADED
INSERTS Pg F4



CROSS SLIDE
T-NUTS Pg F36

Threaded Inserts

Carbon Steel Inserts

E-Z LOK Threaded Inserts



LOCTITE®
BONDING
ASSURES
FIRM
LASTING
THREADS.



EZ-LOK for Strong Threads in Metal
UNITED's metal threads re-work and repair stripped or worn threads. **Available in bulk quantities or in kits.**

Use in steel, magnesium, aluminum, cast iron, copper, brass, masonite and plastic.

| | UNITED PART NO. | INTERNAL THREAD | EXTERNAL THREAD | LEN | TAP SIZE DRILL | TAP SIZE | MIN. THRD DEPTH | DRIVE TOOL NO. | CONVERSION NO. |
|---|-------------------|-----------------|-----------------|--------|-------------------------|----------|-----------------|----------------|----------------|
| #10 to 1" | | | | | | | | | |
| COARSE THREADS | | | | | | | | | |
| <p>COARSE THREAD SIZES</p> | UDB-329004 | 4-40 | 10-32 | .250 | 5/32 | 10-32 | 9/32 | -- | 329-004 |
| | UDB-329006 | 6-32 | 1/4-20 | .280 | 7 | 1/4-20 | 11/32 | -- | 329-006 |
| | UDB-329008 | 8-32 | 5/16-18 | .290 | F | 5/16-18 | 7/16 | UDB-500001 | 329-008 |
| | UDB-329300 | 10-24 | 3/8-16 | .406 | 5/16 | 3/8-16 | 15/32 | UDB-500002 | 329-3 |
| | UDB-329400 | 1/4-20 | 7/16-14 | .437 | 23/64 | 7/16-14 | 1/2 | UDB-500003 | 329-4 |
| | UDB-329500 | 5/16-18 | 1/2-13 | .484 | 27/64 | 1/2-13 | 9/16 | UDB-500004 | 329-5 |
| | UDB-329600 | 3/8-16 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-500005 | 329-6 |
| | UDB-329700 | 7/16-14 | 5/8-11 | .656 | 17/32 | 5/8-11 | 23/32 | UDB-500006 | 329-7 |
| | UDB-329800 | 1/2-13 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-500007 | 329-8 |
| | UDB-329900 | 9/16-12 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-500007 | 329-9 |
| | UDB-329100 | 5/8-11 | 7/8-9 | .687 | 49/64 | 7/8-9 | 13/16 | UDB-500008 | 329-10 |
| | UDB-3291018 | 5/8-11 | 7/8-9 | 1.125 | 49/64 | 7/8-9 | 1-1/4 | UDB-500008 | 329-1018 |
| UDB-329120 | 3/4-10 | 1-8 | .781 | 7/8 | 1-8 | 7/8 | UDB-500009 | 329-12 | |
| UDB-329140 | 7/8-9 | 1-1/4-7 | 1.125 | 1-7/64 | 1-1/4-7 | 1-1/4 | -- | 329-14 | |
| UDB-329160 | 1-8 | 1-3/8-12 | 1.250 | 1-9/32 | 1-3/8-12 | 1-3/8 | -- | 329-16 | |
| #10 to 1" | | | | | | | | | |
| FINE THREADS | | | | | | | | | |
| <p>FINE THREAD SIZES</p> | UDB-329332 | 10-32 | 3/8-16 | .406 | 5/16 | 3/8-16 | 15/32 | UDB-500002 | 329-332 |
| | UDB-329428 | 1/4-28 | 7/16-14 | .437 | 23/64 | 7/16-14 | 1/2 | UDB-500003 | 329-428 |
| | UDB-329524 | 5/16-24 | 1/2-13 | .484 | 27/64 | 1/2-13 | 9/16 | UDB-500004 | 329-524 |
| | UDB-329624 | 3/8-24 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-500005 | 329-624 |
| | UDB-329720 | 7/16-20 | 5/8-11 | .656 | 17/32 | 5/8-11 | 23/32 | UDB-500006 | 329-720 |
| | UDB-329820 | 1/2-20 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-500007 | 329-820 |
| | UDB-329918 | 9/16-18 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-500007 | 329-918 |
| | UDB-32910F | 5/8-18 | 7/8-9 | .687 | 49/64 | 7/8-9 | 13/16 | UDB-500008 | 329-10F |
| | UDB-3291216 | 3/4-16 | 1-8 | .781 | 7/8 | 1-8 | 7/8 | UDB-500009 | 329-1216 |
| | UDB-3291414 | 7/8-14 | 1-1/4-7 | 1.125 | 1-7/64 | 1-1/4-7 | 1-1/4 | -- | 329-1414 |
| | UDB-3291614 | 1-14 | 1-3/8-12 | 1.250 | 1-9/32 | 1-3/8-12 | 1-3/8 | -- | 329-1614 |
| | 1/4 to 5/8 | | | | | | | | |
| EXTRA HEAVY WALL | | | | | | | | | |
| <p>COARSE THREAD SIZES</p> | UDB-335400 | 1/4-20 | 1/2-13 | .484 | 27/64 | 1/2-13 | 9/16 | UDB-500003 | 335-4 |
| | UDB-335500 | 5/16-18 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-500004 | 335-5 |
| | UDB-335600 | 3/8-16 | 5/8-11 | .656 | 17/32 | 5/8-11 | 23/32 | UDB-500005 | 335-6 |
| | UDB-335800 | 1/2-13 | 7/8-9 | .687 | 49/64 | 7/8-9 | 13/16 | UDB-500007 | 335-8 |
| UDB-335100 | 5/8-11 | 1-8 | .781 | 7/8 | 1-8 | 7/8 | -- | 335-10 | |
| M6 to M16 | | | | | | | | | |
| IDs are METRIC THREADS | | | | | O.D.s are U.S. | | | | |
| <p>METRIC THREAD & U.S. EXTERNAL</p> | UDB-650600 | M6-1.0 | 3/8-16 | .406 | 5/16 | 3/8-16 | 15/32 | UDB-500003 | 650-6 |
| | UDB-650800 | M8-1.25 | 1/2-13 | .484 | 27/64 | 1/2-13 | 9/16 | UDB-500004 | 650-8 |
| | UDB-650100 | M10-1.50 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-500005 | 650-10 |
| | UDB-65010F | M10-1.25 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-500005 | 650-10F |
| | UDB-650120 | M12-1.75 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-500006 | 650-12 |
| | UDB-650140 | M14-2.0 | 7/8-9 | .687 | 49/64 | 7/8-9 | 13/16 | UDB-500007 | 650-14 |
| | UDB-650160 | M16-2.0 | 1-8 | .781 | 7/8 | 1-8 | 7/8 | UDB-500008 | 650-16 |
| M3 to M16 | | | | | | | | | |
| IDs are METRIC THREADS | | | | | O.D.s are METRIC | | | | |
| <p>METRIC THREAD & METRIC EXTERNAL</p> | UDB-450300 | M3-0.5 | M6-1.0 | 6.5 mm | 5.1 mm | M6-1.0 | 7.8 mm | -- | 450-3 |
| | UDB-450400 | M4-0.7 | M8-1.25 | 7.5 mm | 6.9 mm | M8-1.25 | 9.0 mm | UDB-500001 | 450-4 |
| | UDB-450500 | M5-0.8 | M8-1.25 | 7.5 mm | 6.9 mm | M8-1.25 | 9.0 mm | UDB-500001 | 450-5 |
| | UDB-450600 | M6-1.0 | M10-1.5 | 10.5 | 8.6 mm | M10-1.5 | 12.0 mm | UDB-500003 | 450-6 |
| | UDB-450800 | M8-1.25 | M12-1.75 | 12.5 | 10.4 mm | M12-1.75 | 14.5 mm | UDB-500004 | 450-8 |
| | UDB-450100 | M10-1.5 | M16-2.0 | 17.0 | 14.0 mm | M16-2.0 | 19.0 mm | UDB-500005 | 450-10 |
| | UDB-450120 | M12-1.75 | M16-2.0 | 17.0 | 14.0 mm | M16-2.0 | 19.0 mm | UDB-500006 | 450-12 |
| | UDB-450160 | M16-2.0 | M24-3.0 | 20.0 | 21.0 mm | M24-3.0 | 24.0 mm | UDB-500008 | 450-16 |

Carbon Steel Insert Kits

Carbon Steel Thread Inserts & Repair Kits

HEAVY DUTY WELDED HINGED LID



STEEL CASE



REPAIR KIT CONTAINS INSTRUCTIONS FOR THREE EASY STEPS.

Inserts & Repair Kits



POWER DRIVE TOOL FOR VOLUME INSTALLATION

UDB E-Z LOCK INSERTS can be used within minutes because the Loctite® bonding sets immediately and cures overnight to seal against gases and liquids and to prevent vibration.

REPAIR KITS will replace your worn threads. Use *UNITED* complete kits for all types of threads. Our quick Installation Tool offers easy installation and removal. Select the thread size range kits you require.

| UNITED KIT NUMBER | NO. OF INSERTS | INSERT PART NO. | INTERNAL THREAD | EXTERNAL THREAD |
|--------------------------------------|----------------|-----------------|-----------------|-----------------|
| COARSE THREAD #10 TO 1/2 INCH | | | | |
| UDB-325108C | 10 | UDB-329300 | 10-24 | 3/8-16 |
| | 10 | UDB-329400 | 1/4-20 | 7/16-14 |
| | 10 | UDB-329500 | 5/16-18 | 1/2-13 |
| | 10 | UDB-329600 | 3/8-16 | 9/16-12 |
| | 6 | UDB-329800 | 1/2-13 | 3/4-10 |
| COARSE THREAD 1/2 TO 1 INCH | | | | |
| UDB-325816C | 6 | UDB-329800 | 1/2-13 | 3/4-10 |
| | 7 | UDB-329100 | 5/8-11 | 7/8-9 |
| | 7 | UDB-329120 | 3/4-10 | 1-8 |
| | 2 | UDB-329160 | 1-8 | 1-3/8-12 |
| FINE THREAD #10 TO 1/2 INCH | | | | |
| UDB-325108F | 10 | UDB-329332 | 10-32 | 3/8-16 |
| | 10 | UDB-329428 | 1/4-28 | 7/16-14 |
| | 10 | UDB-329524 | 5/16-24 | 1/2-13 |
| | 10 | UDB-329624 | 3/8-24 | 9/16-12 |
| | 6 | UDB-329820 | 1/2-20 | 3/4-10 |
| FINE THREAD 1/2 TO 1 INCH | | | | |
| UDB-325816F | 6 | UDB-329820 | 1/2-20 | 3/4-10 |
| | 7 | UDB-32910F | 5/8-18 | 7/8-9 |
| | 7 | UDB-3291216 | 3/4-16 | 1-8 |
| | 2 | UDB-3291614 | 1-14 | 1-3/8-12 |
| METRIC THREAD M6 TO M12 | | | | |
| UDB-325612M | 10 | UDB-650600 | M6-1.0 | 3/8-16 |
| | 10 | UDB-650800 | M8-1.25 | 1/2-13 |
| | 10 | UDB-650100 | M10-1.50 | 9/16-12 |
| | 6 | UDB-650120 | M12-1.75 | 3/4-10 |
| M3-0.5 TO M8-1.25 | | | | |
| UDB-325100M | 10 | UDB-450300 | M3-0.5 | M6-1.0 |
| | 10 | UDB-450400 | M4-0.7 | M8-1.25 |
| | 10 | UDB-450500 | M5-0.8 | M8-1.25 |
| | 10 | UDB-450600 | M6-1.0 | M10-1.5 |
| | 10 | UDB-450800 | M8-1.25 | M12-1.75 |
| M8-1.25 TO M16-2.0 | | | | |
| UDB-325200M | 10 | UDB-450800 | M8-1.25 | M12-1.75 |
| | 10 | UDB-450100 | M10-1.5 | M16-2.0 |
| | 8 | UDB-450120 | M12-1.75 | M16-2.0 |
| | 5 | UDB-450160 | M16-2.0 | M24-3.0 |

1 Drill with standard drill.

E-Z LOK EXTERNAL THREADS are standard and pitched to permit use of standard installation tools.



2 Tap hole with standard tap.

EXTERNAL THREADS provide superior holding power in soft and hard metals. Micro encapsulated Loctite bonding assures firm lasting threads.



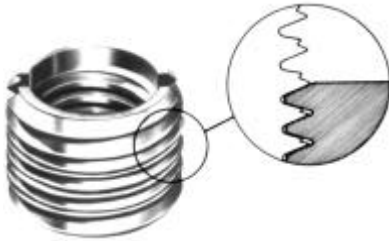
3 Turn and tighten E-Z LOK flush with bolt.

INSTALL-REMOVE INSERT by overcoming the Loctite bonding with a standard screw and bolt extractor and replace with a new insert with the same tools.



E-Z LOK 303

Stainless 303 Thread Inserts



- ★ NON-SEIZING
- ★ NON-GALLING
- ★ NON-MAGNETIC
- ★ WEAR RESISTANT
- ★ CORROSION RESISTANT
- ★ AIRCRAFT QUALITY
- ★ IDEAL FOR FASTENERS
- ★ SPECIFIED BY OEMS



WIDE VARIETY of STAINLESS STEEL LOCTITE® INSERTS

| | UNITED PART NO. | INTERNAL THREAD | EXTERNAL THREAD | LEN | TAP DRILL SIZE | TAP SIZE | MIN. THRD DEPTH | DRIVE TOOL PART NO. | CONVERSION NO. |
|---|---|-----------------|-----------------|---------|----------------|----------|-----------------|---------------------|----------------|
| #10 to 1" | COARSE THREADS | | | | | | | | |
| STAINLESS STEEL COARSE THREAD | UDB-303004 | 4-40 | 10-32 | .250 | 5/32 | 10-32 | 9/32 | -- | 303-004 |
| | UDB-303006 | 6-32 | 1/4-20 | .280 | 7 | 1/4-20 | 11/32 | -- | 303-006 |
| | UDB-303008 | 8-32 | 5/16-18 | .290 | F | 5/16-18 | 7/16 | UDB-325001 | 303-008 |
| | UDB-303300 | 10-24 | 3/8-16 | .406 | 5/16 | 3/8-16 | 15/32 | UDB-325002 | 303-3 |
| | UDB-303400 | 1/4-20 | 7/16-14 | .437 | 23/64 | 7/16-14 | 1/2 | UDB-325003 | 303-4 |
| | UDB-303500 | 5/16-18 | 1/2-13 | .484 | 27/64 | 1/2-13 | 9/16 | UDB-325004 | 303-5 |
| | UDB-303600 | 3/8-16 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-325005 | 303-6 |
| | UDB-303700 | 7/16-14 | 5/8-11 | .656 | 17/32 | 5/8-11 | 23/32 | UDB-325006 | 303-7 |
| | UDB-303800 | 1/2-13 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-325007 | 303-8 |
| | UDB-303100 | 5/8-11 | 7/8-9 | .687 | 49/64 | 7/8-9 | 13/16 | UDB-325008 | 303-10 |
| UDB-303120 | 3/4-10 | 1-8 | .781 | 7/8 | 1-8 | 7/8 | UDB-325009 | 303-12 | |
| #10 to 1/2" | FINE THREADS | | | | | | | | |
| STAINLESS STEEL FINE THREAD | UDB-303332 | 10-32 | 3/8-16 | .406 | 5/16 | 3/8-16 | 15/32 | UDB-325002 | 303-332 |
| | UDB-303428 | 1/4-28 | 7/16-14 | .437 | 23/64 | 7/16-14 | 1/2 | UDB-325003 | 303-428 |
| | UDB-303524 | 5/16-24 | 1/2-13 | .484 | 27/64 | 1/2-13 | 9/16 | UDB-325004 | 303-524 |
| | UDB-303624 | 3/8-24 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-325005 | 303-624 |
| | UDB-303720 | 7/16-20 | 5/8-11 | .656 | 17/32 | 5/8-11 | 23/32 | UDB-325006 | 303-720 |
| | UDB-303820 | 1/2-20 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-325007 | 303-820 |
| M6 to M16 | IDs are METRIC THREADS O.D.s are U.S. | | | | | | | | |
| SS METRIC INTERNAL & U.S. EXTERNAL | UDB-653600 | M6-1.0 | 3/8-16 | .406 | 5/16 | 3/8-16 | 15/32 | UDB-325003 | 653-6 |
| | UDB-653800 | M8-1.25 | 1/2-13 | .484 | 27/64 | 1/2-13 | 9/16 | UDB-325004 | 653-8 |
| | UDB-653100 | M10-1.50 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-325005 | 653-10 |
| | UDB-65310F | M10-1.25 | 9/16-12 | .515 | 31/64 | 9/16-12 | 19/32 | UDB-325006 | 653-10F |
| | UDB-653120 | M12-1.75 | 3/4-10 | .656 | 21/32 | 3/4-10 | 3/4 | UDB-325007 | 653-12 |
| | UDB-653140 | M14-2.0 | 7/8-9 | .687 | 49/64 | 7/8-9 | 13/16 | UDB-325008 | 653-14 |
| | UDB-653160 | M16-2.0 | 1-8 | .781 | 7/8 | 1-8 | 7/8 | | 653-16 |
| M3 to M16 | IDs are METRIC THREADS O.D.s are METRIC | | | | | | | | |
| SS METRIC INTERNAL & METRIC EXTERNAL | UDB-453300 | M3-0.5 | M6-1.0 | 6.5 mm | 5.1 mm | M6-1.0 | 7.8 mm | -- | 453-3 |
| | UDB-453400 | M4-0.7 | M8-1.25 | 7.5 mm | 6.9 mm | M8-1.25 | 9.0 mm | UDB-325001 | 453-4 |
| | UDB-453500 | M5-0.8 | M8-1.25 | 7.5 mm | 6.9 mm | M8-1.25 | 9.0 mm | UDB-325001 | 453-5 |
| | UDB-453600 | M6-1.0 | M10-1.5 | 10.5 mm | 8.6 mm | M10-1.5 | 12.0 mm | UDB-325003 | 453-6 |
| | UDB-453800 | M8-1.25 | M12-1.75 | 12.5 mm | 10.4 mm | M12-1.75 | 14.5 mm | UDB-325004 | 453-8 |
| | UDB-453100 | M10-1.5 | M16-2.0 | 17.0 mm | 14.0 mm | M16-2.0 | 19.0 mm | UDB-325005 | 453-10 |
| | UDB-453120 | M12-1.75 | M16-2.0 | 17.0 mm | 14.0 mm | M16-2.0 | 19.0 mm | UDB-325006 | 453-12 |
| | UDB-453160 | M16-2.0 | M24-3.0 | 20.0 mm | 21.0 mm | M24-3.0 | 24.0 mm | UDB-325008 | 453-16 |

Stainless 303 Thread Insert Kits

303 Stainless
Threads

UNITED STAINLESS 303 INSERTS are Non-Magnetic. They resist corrosion. **UNITED Stainless** meets the exacting requirements of the Aircraft Industry. The Non-Seizing and Non-Galling properties of **UNITED's Stainless** are ideal for use with Threaded Fasteners.

303 STAINLESS
THREADED INSERTS



REPAIR KITS WITH 303 STAINLESS INSERTS

| UNITED KIT NUMBER | NO. OF INSERTS | INSERT PART NO. | INTERNAL THREAD | EXTERNAL THREAD |
|---|----------------|-----------------|-----------------|-----------------|
| #10 to 1/2" | | | | |
| COARSE THREAD | | | | |
| UDB-303300K | 10 | UDB-303300 | 10-24 | 3/8-16 |
| | 10 | UDB-303400 | 1/4-20 | 7/16-14 |
| | 10 | UDB-303500 | 5/16-18 | 1/2-13 |
| | 10 | UDB-303600 | 3/8-16 | 9/16-12 |
| | 6 | UDB-303800 | 1/2-13 | 3/4-10 |
| #10 to 1/2" | | | | |
| FINE THREAD | | | | |
| UDB-30332K | 10 | UDB-303332 | 10-32 | 3/8-16 |
| | 10 | UDB-303428 | 1/4-28 | 7/16-14 |
| | 10 | UDB-303524 | 5/16-24 | 1/2-13 |
| | 10 | UDB-303624 | 3/8-24 | 9/16-12 |
| | 6 | UDB-303820 | 1/2-20 | 3/4-10 |
| M6 to M12 | | | | |
| METRIC THREAD M6 TO M12 | | | | |
| UDB-653600K | 10 | UDB-653600 | M6-1.0 | 3/8-16 |
| | 10 | UDB-653800 | M8-1.25 | 1/2-13 |
| | 10 | UDB-653100 | M10-1.50 | 9/16-12 |
| | 6 | UDB-653120 | M12-1.75 | 3/4-10 |
| M3 to M8 | | | | |
| METRIC THREAD M3-0.5 TO M8-1.25 | | | | |
| UDB-453300K | 10 | UDB-453300 | M3-0.5 | M6-1.0 |
| | 10 | UDB-453400 | M4-0.7 | M8-1.25 |
| | 10 | UDB-453500 | M5-0.8 | M8-1.25 |
| | 10 | UDB-453600 | M6-1.0 | M10-1.5 |
| | 10 | UDB-453800 | M8-1.25 | M12-1.75 |
| M8 to M16 | | | | |
| METRIC THREAD M8-1.25 TO M16-2.0 | | | | |
| UDB-453800K | 10 | UDB-453800 | M8-1.25 | M12-1.75 |
| | 10 | UDB-453110 | M10-1.5 | M16-2.0 |
| | 8 | UDB-453112 | M12-1.75 | M16-2.0 |
| | 5 | UDB-453116 | M16-2.0 | M24-3.0 |

**INSTRUCTIONS AND
INSERTING TOOL FOR
VOLUME PRODUCTION
INCLUDED IN EACH KIT**



INSERTING TOOL

STEEL CASE



**UniSerts—Fast
Thread Repair**

UNITED's Threaded Inserts

FOUR EASY STEPS TO SIMPLIFIED INSTALLATION



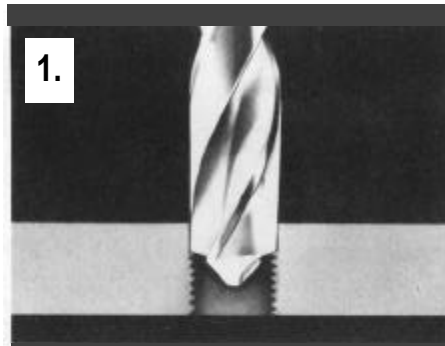
PERMANENT
STEEL THREADS

UniSerts FEATURE:

- A. Permanent stronger steel threads
- B. Fast repair
- C. Ideal for original equipment-OEM
- D. Positive lock against rotation
- E. No tang break off
- F. High strength and reliability
- G. Wear resistant
- H. Specified by auto and truck industry
- I. Stronger than original
- J. Can be used in most materials aluminum, steel, magnesium, cast iron, plastic

MINIATURE INSERTS

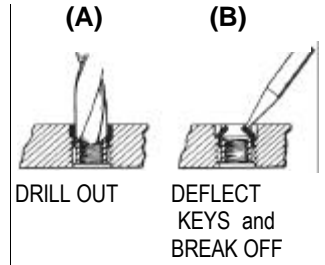
Screw miniature series into threaded mandrel and screw insert into tapped hole. A spring-loaded trip mechanism drives the keys into the parent material. See far right.



1.

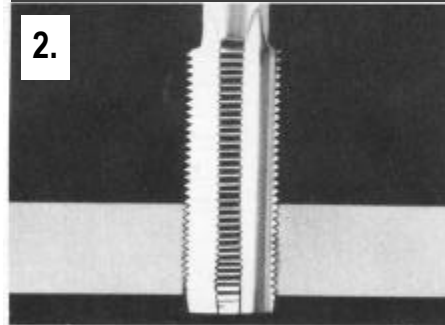
It's unlikely that our strong UniSerts threads will be removed.

Drill out old threads. Use standard drill.



DRILL OUT

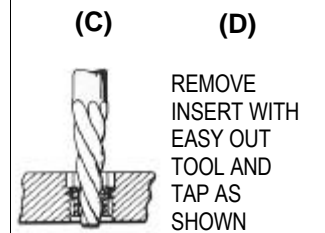
DEFLECT
KEYS and
BREAK OFF



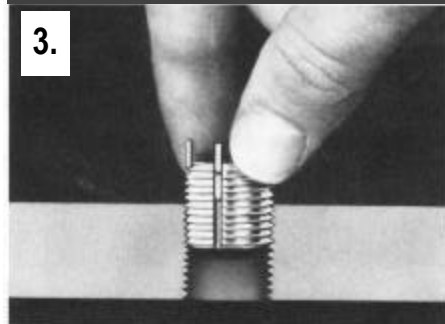
2.

Remove old insert.

Tap with standard tap.

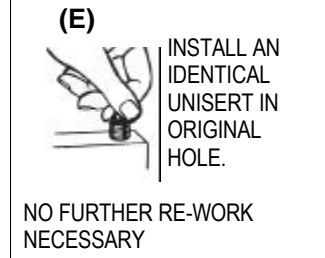


REMOVE
INSERT WITH
EASY OUT
TOOL AND
TAP AS
SHOWN



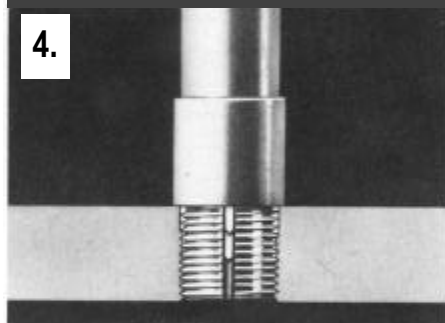
3.

Screw in new UniSert until slightly below surface. Keys act as depth stop.



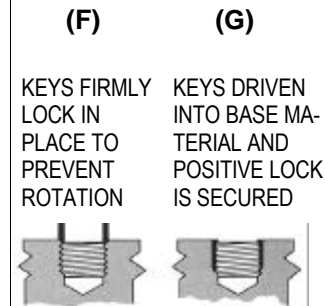
INSTALL AN
IDENTICAL
UNISERT IN
ORIGINAL
HOLE.

NO FURTHER RE-WORK
NECESSARY



4.

Drive Keys down with several light taps on installation tool.

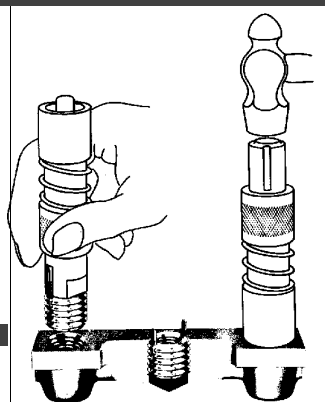


KEYS FIRMLY
LOCK IN
PLACE TO
PREVENT
ROTATION

KEYS DRIVEN
INTO BASE MA-
TERIAL AND
POSITIVE LOCK
IS SECURED



Screw insert on mandrel. Turn insert into tapped hole. Spring-loaded trip mechanism drives Keys into material.



THE "PERFECT" HOLE

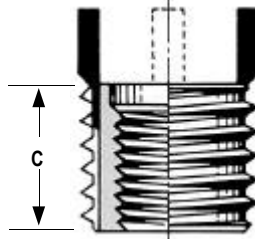
Carbon Steel UniSerts

PERMANENT STEEL THREADS FOR QUICK REPAIR
WITH POSITIVE MECHANICAL LOCK AGAINST REPAIRS

UniSerts-Tools-Kits



INSTALLATION TOOL



A - INTERNAL THREAD - I.D.
B - EXTERNAL THREAD - O.D.

HEAVY DUTY INSERTS
Are used for general
purpose applications.

30 USA sizes from
10 24 to 1-1/2 12.

12L15 Steel
Black Oxide Finish



HEAVY DUTY - USA

| INSERTS UNITED PART NO. | INSERT DIMENSIONS | | | | INSTALLATION DATA | | | | | | | REMOVAL DATA | |
|-------------------------------|-------------------|-------------|----------|---------------------------|--------------------|---------------|------------------|----------------------|----------------------------|------------------------|--------------------|---------------|----------------|
| | A INTERNAL | B EXTERN | C LEN | SHEAR ENGAG (SQ.IN) | REQ D TAP DRILL | C SINK DIA | MIN THRD DPTH | STANDRD TAP UN-2B | INSTALL N TOOL PART NO. | REPAIR KIT PART NO. | INSERTS PER KIT | DRILL SIZE | DRILL DEPTH |
| UDB-1024-US | #10-24 | 3/8-16 | .31 | .1901 | (Q) | .332 | 3/8 | 3/8 | 3/8-16 | UDB-10-UST | 15 | 9/32 | 1/8 |
| UDB-1032-US | #10-32 | | | | UDB-1032-USK | | | | | | | | |
| UDB-1420-US | 1/4-20 | 7/16-14 | .37 | .2842 | (X) | .397 | 7/16 | 7/16 | 7/16-14 | UDB-14-UST | 13 | 11/32 | 3/16 |
| UDB-1428-US | 1/4-28 | | | | UDB-1428-USK | | | | | | | | |
| UDB-51618-US | 5/16-18 | 1/2-13 | .43 | .3588 | (29/64) | .453 | 1/2 | 1/2 | 1/2-13 | UDB-516-UST | 8 | 13/32 | 3/16 |
| UDB-51624-US | 5/16-24 | | | | UDB-51624-USK | | | | | | | | |
| UDB-3816-US | 3/8-16 | 9/16-12 | .50 | .4975 | (33/64) | .516 | 9/16 | 9/16 | 9/16-12 | UDB-38-UST | 6 | 15/32 | 3/16 |
| UDB-3824-US | 3/8-24 | | | | UDB-3824-USK | | | | | | | | |
| UDB-71614-US | 7/16-14 | 5/8-11 | .62 | .7172 | (37/64) | .578 | 5/8 | 11/16 | 5/8-11 | UDB-716-UST | 6 | 17/32 | 3/16 |
| UDB-71620-US | 7/16-20 | | | | UDB-71620-USK | | | | | | | | |
| UDB-1213-US | 1/2-13 | 3/4-16 | .62 | 1.0573 | (45/64) | .703 | 3/4 | 11/16 | 3/4-16 | UDB-12-UST | 5 | 21/32 | 3/16 |
| UDB-1220-US | 1/2-20 | | | | UDB-1220-USK | | | | | | | | |
| UDB-91612-US | 9/16-12 | 3/4-16 | .81 | 1.0573 | (45/64) | .703 | 3/4 | 7/8 | 3/4-16 | UDB-916-UST | 3 | 21/32 | 3/16 |
| UDB-91618-US | 9/16-18 | | | | UDB-91618-USK | | | | | | | | |
| UDB-5811-US | 5/8-11 | 7/8-14 | .87 | 1.4866 | (53/64) | .828 | 7/8 | 1 | 7/8-14 | UDB-58-UST | 2 | 25/32 | 3/16 |
| UDB-5818-US | 5/8-18 | | | | UDB-5818-USK | | | | | | | | |
| UDB-3410-US | 3/4-10 | 1-1/8-12 | 1.12 | 2.4901 | (1-1/16) | 1.062 | 1-1/8 | 1-5/16 | 1-1/8-12 | UDB-34-UST | 2 | 31/32 | 5/16 |
| UDB-3416-US | 3/4-16 | | | | UDB-3416-USK | | | | | | | | |
| UDB-789-US | 7/8-9 | 1-1/4-12 | 1.25 | 3.1370 | (1-3/16) | 1.187 | 1-1/4 | 1-7/16 | 1-1/4-12 | UDB-78-UST | 2 | 1-3/32 | 5/16 |
| UDB-7814-US | 7/8-14 | | | | UDB-7814-USK | | | | | | | | |
| UDB-18-US | 1-8 | 1-3/8-12 | 1.37 | 3.8381 | (1-5/16) | 1.312 | 1-3/8 | 1-9/16 | 1-3/8-12 | UDB-1-UST | 2 | 1-7/32 | 5/16 |
| UDB-112-US | 1-12 | | | | UDB-112-USK | | | | | | | | |
| UDB-1187-US | 1-1/8-7 | 1-1/2-12 | 1.62 | 4.7519 | (1-7/16) | 1.437 | 1-1/2 | 1-11/16 | 1-1/2-12 | UDB-118-UST | 2 | 1-11/32 | 5/16 |
| UDB-11812-US | 1-1/8-12 | | | | UDB-11812-USK | | | | | | | | |
| UDB-1147-US | 1-1/4-7 | 1-5/8-12 | 1.81 | 5.4459 | (1-35/64) | 1.547 | 1-5/8 | 2 | 1-5/8-12 | UDB-114-UST | 2 | 1-15/32 | 5/16 |
| UDB-11412-US | 1-1/4-12 | | | | UDB-11412-USK | | | | | | | | |
| UDB-1386-US | 1-3/8-6 | 1-3/4-12 | 1.90 | 6.2140 | (1-11/16) | 1.688 | 1-3/4 | 2-1/16 | 1-3/4-12 | UDB-138-UST | 2 | 1-19/32 | 5/16 |
| UDB-13812-US | 1-3/8-12 | | | | UDB-13812-USK | | | | | | | | |
| UDB-1126-US | 1-1/2-6 | 1-7/8-12 | 2.00 | 7.1032 | (1-51/64) | 1.797 | 1-7/8 | 2-3/16 | 1-7/8-12 | UDB-112-UST | 2 | 1-23/32 | 5/16 |
| UDB-11212-US | 1-1/2-12 | | | | UDB-11212-USK | | | | | | | | |

HEAVY DUTY - METRIC

| | | | | | | | | | | | | | |
|----------------|----------|----------|-------|--------|--------|------|------|----------|-----------------|----------------|----|-------|------|
| UDBM-58-USM | M5 | M8 | .315 | .1626 | H | .32 | .36 | M8 | UDBM-58-USMT | UDBM-58-USK | 15 | 7/32 | 5/32 |
| UDBM-61-USM | M6 | M10x1.25 | .394 | .2754 | S | .40 | .45 | M10x1.25 | UDBM-61-USMT | UDBM-61-USK | 13 | 19/64 | 3/16 |
| UDBM-8125-USM | M8 | M12x1.25 | .472 | .4134 | 27/64 | .48 | .54 | M12x1.25 | UDBM-516-USMT | UDBM-8125-USK | 8 | 3/8 | 3/16 |
| UDBM-81-USM | M8x1.0 | | | | | | | | | UDBM-81-USK | | | |
| UDBM-1015-USM | M10 | M14x1.5 | .551 | .5295 | 1/2 | .56 | .62 | M14x1.5 | UDBM-38-USMT | UDBM-015-USK | 6 | 29/64 | 3/16 |
| UDBM-10125-USM | M10x1.25 | | | | | | | | | UDBM-10125-USK | | | |
| UDBM-12175-USM | M12 | M16x1.5 | .630 | .7288 | 37/64 | .63 | .69 | M16x1.5 | UDBM-12175-USMT | UDBM-12175-USK | 5 | 17/32 | 3/16 |
| UDBM-12125-USM | M12x1.25 | | | | | | | | | UDBM-12125-USK | | | |
| UDBM-162-USM | M16 | M22x1.5 | .866 | 1.3900 | 13/16 | .88 | .96 | M22x1.5 | UDBM-58-USMT | UDBM-162-USK | 2 | 11/16 | 1/4 |
| UDBM-1615-USM | M16x1.5 | | | | | | | | | UDBM-1615-USK | | | |
| UDBM-2025-USM | M20 | M30x2 | 1.181 | 2.7502 | 1-7/64 | 1.19 | 1.36 | M30x2 | UDBM-2015-USMT | UDBM-2025-USK | 2 | 1 | 1/4 |
| UDBM-2015-USM | M20x1.5 | | | | | | | | | UDBM-2015-USK | | | |