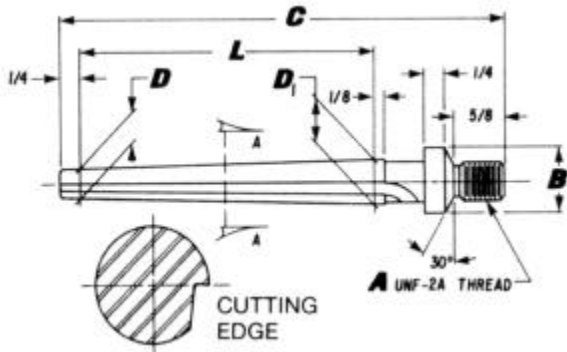


Single Flute Tapered Reamer The Taper Scraper

UDB-755750 Series
Groups 1-2-3-4-5

UDB-755750 SERIES



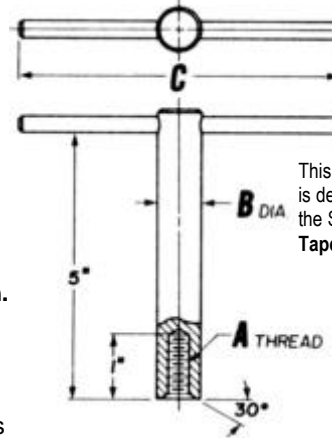
Single Flute Tapered Reamer — The 'Taper Scraper'



Taper Lock holes drilled in sandwiched materials and checked with UNITED Taper Hole Gauges may be slightly irregular in shape, size or finish. The Single Flute Taper Reamer is used to correct those conditions.

This Reamer removes irregularities and leaves a fine hole finish. Continue to check the hole with a UNITED Taper Hole Gauge and if found to be accurate, proceed with the installation of the fastener.

The Single Flute Taper Reamer is best used with a T-Handle. Designed to remove only a few thousandths of material. These tools should not be used where an actual hole enlargement is needed. UNITED provides a re-sharpening service for these critical reamers.



This T-Handle is designed for the Single Flute Taper Scraper.

FITS REAMER THREADS
Select by Thread Size

T-Handle

TAPER SCRAPER	TAPER LOCK SIZE	GROUP	A THD	B	C	D	D ₁	L	T-Handle used
UDB-755758	5/32	1-5	5/16-24	3/8	3.70	.162	.205	2.064	755750
UDB-755762	3/16	1-5			4.18	.189	.242	2.543	
UDB-755764	1/4	1-5			4.85	.248	.315	3.215	
UDB-755766	5/16	1-5	7/16-20	1/2	5.27	.310	.383	3.503	755760
UDB-755768	3/8	1-4			4.84	.372	.436	3.071	
UDB-755772	3/8	5			4.07	.404	.452	2.303	
UDB-755774	7/16	1-4			5.37	.434	.509	3.599	
UDB-755776	7/16	5		4.45	.471	.527	2.687		
UDB-755778	1/2	1-4		5/8	5.93	.496	.582	4.127	
UDB-755782	1/2	5		4.88	.538	.602	3.071		
UDB-755784	9/16	1-3		5/8-18	7/8	6.48	.559	.656	
UDB-755786	9/16	4	6.48			.590	.687	4.655	
UDB-755788	9/16	5	6.48			.621	.718	4.655	
UDB-755792	5/8	1-3	6.86			.621	.726	5.039	
UDB-755794	5/8	4	6.86			.655	.760	5.039	
UDB-755796	5/8	5	6.86			.688	.793	5.039	
UDB-755798	3/4	1-3	7.58		.746	.866	5.758		
UDB-755800	3/4	4	7.58		.786	.906	5.758		
UDB-755802	3/4	5	7.58		.825	.945	5.758		
UDB-755804	7/8	1-3	1"		8.58	.875	1.014	6.700	
UDB-755806	7/8	4			8.58	.921	1.061	6.700	
UDB-755808	7/8	5			8.58	.969	1.109	6.700	
UDB-755810	1"	1-3	1-1/4		9.38	1.001	1.157	7.500	
UDB-755812	1"	4			9.38	1.053	1.209	7.500	
UDB-755814	1"	5			9.38	1.105	1.261	7.500	

Do not remove cutting edge burr—it cuts!

TAPER SCRAPER IS THE TOOL TO FINISH THE JOB!

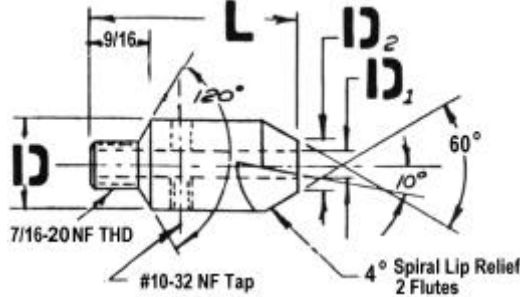
Return to UNITED for Sharpening

The Most Used Taper Lock Tool!

**UDB-975923 Series
Groups 1-2-3-4-5**

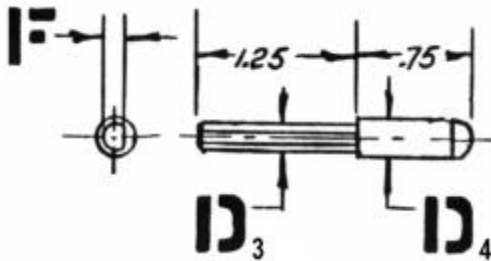
Countersinks- Threaded Shanks with Removable Pilots - 60° Cutter

UDB-975923 SERIES



Countersink Threaded Shank — 60° Cutter

Two Flutes 4° Spiral Lip Relief — Threaded Shank Countersinks with Removable Pilots.

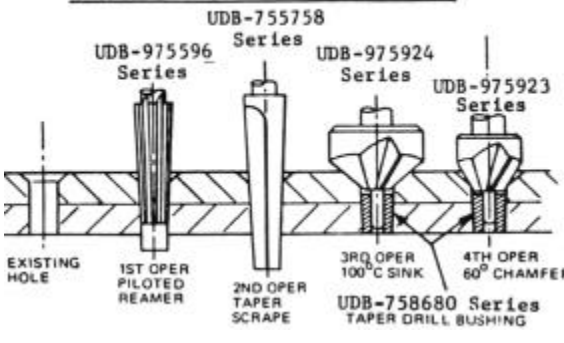


COUNTERSINK PILOTS Ground and Hardened

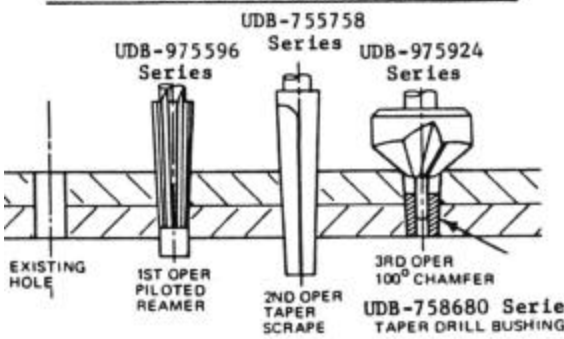
D ₃ SHANK	D ₄ PILOT	F DIA. FLAT
7/16 = .1085	1/8 = .1245	3/32 = .093
7/16 = .1085	3/16 = .1870	3/32 = .093
1/4 = .2495	1/4 = .2495	7/32 = .218
1/4 = .2495	5/16 = .3120	7/32 = .218
1/4 = .2495	3/8 = .3745	7/32 = .218

PART NO. and FASTENER SIZE	Group No.	D	D ₁ +.000 - .001	D ₂ +.002 - .002	D ₃ +.0000 - .0002 PILOT SHANK	D ₄ +.0002 - .0000 PILOT	F FLAT	L LEN
UDB-975923- 3/16-1	1	.62	.109	.169	.1085	.1245	.093	1.62
UDB-975923- 3/16-2	2	.62	.109	.181	.1085	.1245	.093	1.62
UDB-975923- 3/16-3	3	.62	.109	.190	.1085	.1245	.093	1.62
UDB-975923- 3/16-4	4	.62	.109	.206	.1085	.1245	.093	1.62
UDB-975923- 3/16-5	5	.62	.109	.215	.1085	.1245	.093	1.62
UDB-975923- 1/4-1	1	.62	.109	.234	.1085	.1870	.093	1.62
UDB-975923- 1/4-2	2	.62	.109	.240	.1085	.1870	.093	1.62
UDB-975923- 1/4-3	3	.62	.109	.256	.1085	.1870	.093	1.62
UDB-975923- 1/4-4	4	.62	.109	.268	.1085	.1870	.093	1.62
UDB-975923- 1/4-5	5	.62	.109	.281	.1085	.1870	.093	1.62
UDB-975923- 5/16-1	1	.62	.109	.300	.1085	.1870	.093	1.62
UDB-975923- 5/16-2	2	.62	.109	.312	.1085	.1870	.093	1.62
UDB-975923- 5/16-3	3	.62	.109	.325	.1085	.1870	.093	1.62
UDB-975923- 5/16-4	4	.62	.109	.343	.1085	.1870	.093	1.62
UDB-975923- 5/16-5	5	.62	.109	.356	.1085	.1870	.093	1.62
UDB-975923- 3/8-1	1	.87	.250	.362	.2495	.2495	.218	1.62
UDB-975923- 3/8-2	2	.87	.250	.381	.2495	.2495	.218	1.62
UDB-975923- 3/8-3	3	.87	.250	.393	.2495	.2495	.218	1.62
UDB-975923- 3/8-4	4	.87	.250	.415	.2495	.2495	.218	1.62
UDB-975923- 3/8-5	5	.87	.250	.425	.2495	.2495	.218	1.62
UDB-975923- 7/16-1	1	.87	.250	.430	.2495	.3120	.218	1.62
UDB-975923- 7/16-2	2	.87	.250	.440	.2495	.3120	.218	1.62
UDB-975923- 7/16-3	3	.87	.250	.460	.2495	.3120	.218	1.62
UDB-975923- 7/16-4	4	.87	.250	.481	.2495	.3120	.218	1.62
UDB-975923- 7/16-5	5	.87	.250	.497	.2495	.3120	.218	1.62
UDB-975923- 1/2-1	1	.87	.250	.487	.2495	.3120	.218	1.62
UDB-975923- 1/2-2	2	.87	.250	.512	.2495	.3120	.218	1.62
UDB-975923- 1/2-3	3	.87	.250	.525	.2495	.3120	.218	1.62
UDB-975923- 1/2-4	4	.87	.250	.550	.2495	.3120	.218	1.62
UDB-975923- 1/2-5	5	.87	.250	.575	.2495	.3120	.218	1.62
UDB-975923- 9/16-1	1	.87	.250	.543	.2495	.3745	.218	1.62
UDB-975923- 9/16-2	2	.87	.250	.581	.2495	.3745	.218	1.62
UDB-975923- 9/16-3	3	.87	.250	.612	.2495	.3745	.218	1.62
UDB-975923- 9/16-4	4	.87	.250	.643	.2495	.3745	.218	1.62
UDB-975923- 9/16-5	5	.87	.250	.675	.2495	.3745	.218	1.62
UDB-975923- 5/8-1	1	1.12	.250	.625	.2495	.3745	.218	1.62
UDB-975923- 5/8-2	2	1.12	.250	.656	.2495	.3745	.218	1.62
UDB-975923- 5/8-3	3	1.12	.250	.687	.2495	.3745	.218	1.62
UDB-975923- 5/8-4	4	1.12	.250	.725	.2495	.3745	.218	1.62
UDB-975923- 5/8-5	5	1.12	.250	.762	.2495	.3745	.218	1.62
UDB-975923- 3/4-1	1	1.12	.250	.737	.2495	.3745	.218	1.62
UDB-975923- 3/4-2	2	1.12	.250	.768	.2495	.3745	.218	1.62
UDB-975923- 3/4-3	3	1.12	.250	.806	.2495	.3745	.218	1.62
UDB-975923- 3/4-4	4	1.12	.250	.850	.2495	.3745	.218	1.62
UDB-975923- 3/4-5	5	1.12	.250	.887	.2495	.3745	.218	1.62

CUTTER SEQUENCE FOR FLUSH FASTENERS



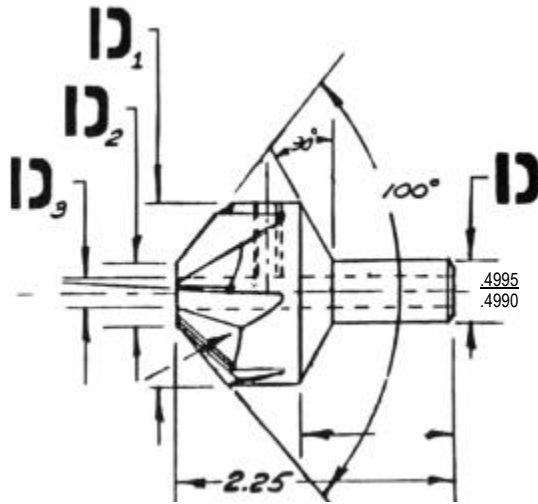
CUTTER SEQUENCE FOR PROTRUDING FASTENERS



Countersinks Six Flutes 100° Piloted Removable Pilots

**UDB-975924 Series
Groups 1-2-3-4-5**

UDB-975924 SERIES

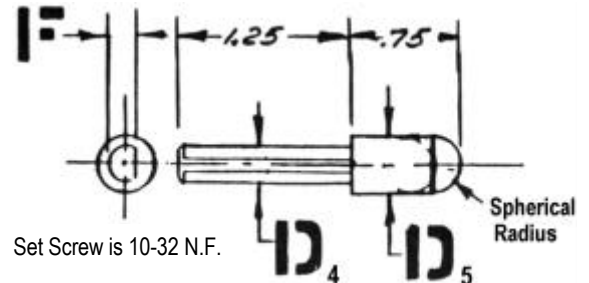


HIGH SPEED CUTTER
Spherical Radius

Shanks Flatted One Side
100° — 5° to 7° Primary Relief on 6 Flutes
H.S.S. — Hardened and Precision Ground
3° — +1° - 0° Axial Rake
Plain Concentric Shank



Countersink with Removable Pilots



Set Screw is 10-32 N.F.

COUNTERSINK PILOTS Ground and Hardened

PART NO. and FASTENER SIZE	Group	D		D ₂	D ₃	D ₄	D ₅	F FLAT
		+0.000 -0.005 SHANK	D ₁	+0.00 -0.01 NOSE	+0.001 -0.000 PILOT HOLE	+0.000 -0.002 PILOT SHANK	+0.002 -0.000 PILOT	
UDB-975924- 3/16-1	1 - 5	.4995	.875	.1979	.109	.1085	.1245	.093
UDB-975924- 1/4-1	1 - 5	.4995	.875	.2596	.109	.1085	.1870	.093
UDB-975924- 5/16-1	1 - 5	.4995	.875	.3227	.109	.1085	.1870	.093
UDB-975924- 3/8-1	1 - 5	.4995	1.000	.3858	.250	.2495	.2495	.218
UDB-975924- 7/16-1	1 - 5	.4995	1.250	.4500	.250	.2495	.3120	.218
UDB-975924- 1/2-1	1 - 5	.4995	1.250	.5141	.250	.2495	.3120	.218
UDB-975924- 9/16-1	1 - 5	.4995	1.375	.5864	.250	.2495	.3745	.218
UDB-975924- 5/8-1	1 - 5	.4995	1.625	.6512	.250	.2495	.3745	.218
UDB-975924- 3/4-1	1 - 5	.4995	1.750	.7809	.250	.2495	.3745	.218

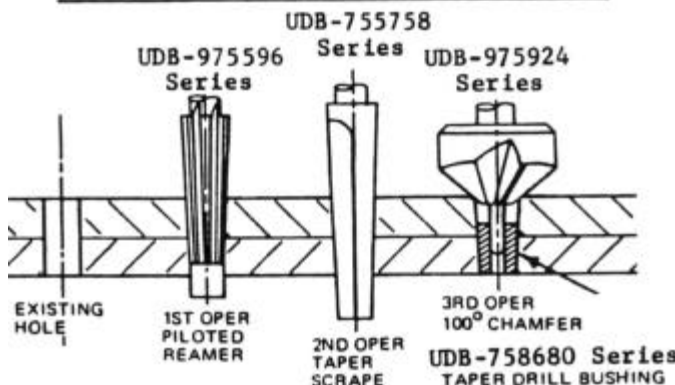
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1/4 = .2495	5/16 = .3120	7/32 = .218
1/4 = .2495	3/8 = .3745	7/32 = .218

D3 Internal Diameter is precision ground.

Locate on arbor or centers to re-grind.

Has minimum center on both ends of I.D. for re-grind.

CUTTER SEQUENCE FOR PROTRUDING FASTENERS



CUTTER SEQUENCE FOR FLUSH FASTENERS

