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

- Upper Anvil Assembly
- Drill Spindle Assembly
- Pressure Foot Bushing
- Lower Anvil Assembly (Offset C)
Anvil Assemblies

Part No. Components
For Ordering Anvil Assy.

SAMPLE PART NUMBER

First Position
Second Position
Third Position
Fourth Position

UCC - B - 390 - 04U

UNITED CALIFORNIA CORPORATION

Alphabetical Symbol Code that indicates component name. See below.


Note: Tooling for G200 BHX, G400, G666 BH and G900 BH Machines will be illustrated in our Drivmatic Catalog.

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

<table>
<thead>
<tr>
<th>CODE</th>
<th>NAME</th>
<th>FITS</th>
<th>CODE</th>
<th>NAME</th>
<th>FITS</th>
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<tbody>
<tr>
<td>AU</td>
<td>ASSEMBLY, UPPER ANVIL</td>
<td>LB</td>
<td>AL</td>
<td>RAIL GUIDE</td>
<td>AL</td>
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<tr>
<td>FH</td>
<td>FINGER HOLDER</td>
<td>CP</td>
<td>AL</td>
<td>DOWEL PIN</td>
<td>AL</td>
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<tr>
<td>RS</td>
<td>RETURN SPRING</td>
<td>P</td>
<td>AL</td>
<td>SOCKET HEAD CAP SCREW</td>
<td>AL</td>
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<tr>
<td>GS</td>
<td>GARTER SPRING</td>
<td>AS</td>
<td>AL</td>
<td>LOWER ANVIL SKIRT</td>
<td>AL</td>
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<tr>
<td>OR</td>
<td>'O' RING</td>
<td>CS</td>
<td>AL</td>
<td>BASE PIN</td>
<td>AL</td>
</tr>
<tr>
<td>F</td>
<td>FINGER</td>
<td>AL</td>
<td>AL</td>
<td>ANVIL PIN</td>
<td>AL</td>
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<tr>
<td>B</td>
<td>BUTTON</td>
<td>IA</td>
<td>AL</td>
<td>ANVIL BASE</td>
<td>AL</td>
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<tr>
<td>A</td>
<td>ANVIL</td>
<td>SR</td>
<td>AL</td>
<td>STRIPPER BOLT</td>
<td>AL</td>
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<td>AD</td>
<td>ADAPTER</td>
<td>SS</td>
<td>AU &amp; AL</td>
<td>LOCK SPRING</td>
<td>AL</td>
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<td>PB</td>
<td>PRESSURE FOOT BUSHING</td>
<td>RB</td>
<td>AL</td>
<td>TENSION SPRING</td>
<td>AL</td>
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<tr>
<td>PP</td>
<td>PRESSURE PLATE</td>
<td>CR</td>
<td>AL</td>
<td>GUIDE PROTECTOR</td>
<td>AL</td>
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<td>LC</td>
<td>LOWER OFFSET 'C' FRAME ASSY</td>
<td>BA</td>
<td>AL</td>
<td>FLUSH SCREW</td>
<td>AL</td>
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<table>
<thead>
<tr>
<th>CODE</th>
<th>Explanation</th>
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<tr>
<td>390</td>
<td>Indicates component applies to Upper Tooling and is interchangeable between short and long series.</td>
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<tr>
<td>390S</td>
<td>Indicates component applies to Lower Stake Type Anvil.</td>
</tr>
<tr>
<td>390C</td>
<td>Indicates component applies to Lower 'C' Type Anvil.</td>
</tr>
<tr>
<td>391</td>
<td>Indicates component applies to Upper Tooling—Short series Only.</td>
</tr>
<tr>
<td>392</td>
<td>Indicates component applies to Upper Tooling—Long series Only.</td>
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</table>
Drill Spindle and Pressure Foot Assy

PART RELATIONSHIP DRAWING

Full Scale Charts Available on Request.

Call UNITED For Information.

Drill Spindle and Pressure Foot Assy

Master Collet
UCC-562936

Master Collet Nut (Mates with G39A Drill Spindle)
UCC-551064

Drill Spindle Assembly
UCC-655014

Drill Spindle Extension Adapter
UCC-655103

Pressure Foot Bushing
UCC-PB-391-XX
UCC-PB-392-XX

Collet Nut
UCC-551080

Collet
UCC-655441

Replaceable Clamp Sleeve
UCC-CS-390S-X

Anvil Button
UCC-B-390S-X

Lock Spring
UCC-LS-390S-123

Inner Anvil
UCC-FS-390S-X

Flush Screw
UCC-FS-390S-123